



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

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

### **PART NUMBER**

**114A1220-10, -201, -202, -203, -204, -5, -6, -7, -8, -9**

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**57-56-44**

**COMPONENT MAINTENANCE MANUAL**

Revision No. 14  
Jul 01/2009

To: All holders of NO. 2 AND 3 KRUEGER FLAP AND BULLNOSE ASSEMBLY 57-56-44.

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.

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### Description of Change

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

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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 BULLNOSE ASSEMBLY - DESCRIPTION AND OPERATION**

#### **1. Description**

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

#### **2. Operation**

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

#### **3. Leading Particulars (Approximate)**

- A. Length – 69 inches
- B. Width
  - (1) 23 inches with the bullnose assemblies extended
  - (2) 19 inches with the bullnose assemblies retracted
- C. Height – 9 inches
- D. Weight – 53 pounds

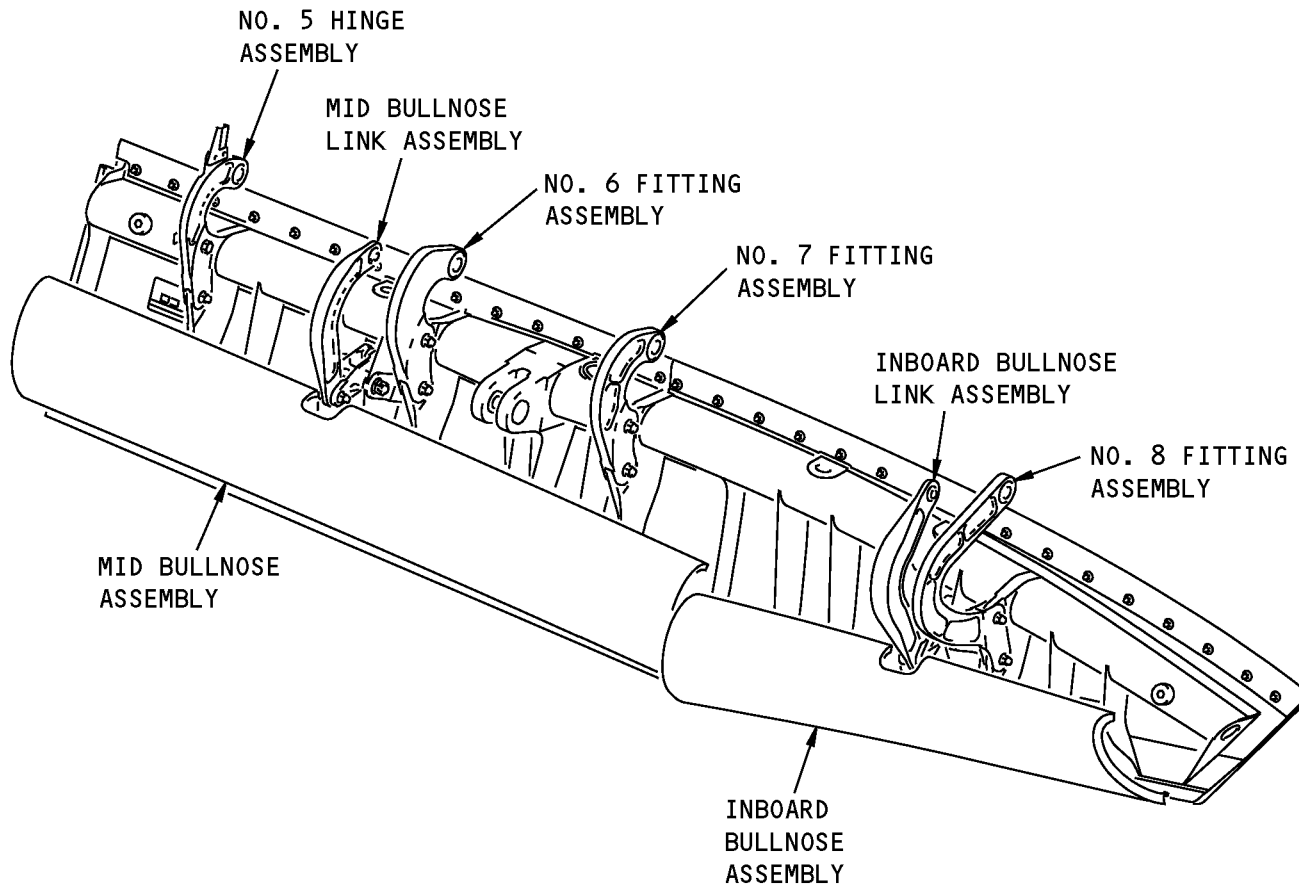
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DESCRIPTION AND OPERATION

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## COMPONENT MAINTENANCE MANUAL



114A1220-5 SHOWN

Krueger Flap and Bullnose Assemblies No. 2 and 3  
Figure 1

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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 bullnose assembly.
- B. Disassemble this component sufficiently to isolate the defects, do the necessary repairs, and put the component back to a serviceable condition.
- C. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- D. Refer to IPL Figure 1 for item numbers.

#### 2. Disassembly

- A. Procedure
  - (1) Use standard industry procedures and the steps shown below to disassemble this component.
  - (2) If you remove a hinge fitting assembly (25, 105, 150, 155) for repair or replacement, remove one hinge fitting assembly at a time.

**NOTE:** The centerline through the bearings (95, 110, 160) of the hinge fitting assemblies No. 5 thru No. 8 (25, 105, 150, 155) is the hinge line of the Krueger flap assembly (1B, 5A). This centerline must not be changed during disassembly and assembly. The centerline of the remaining hinge fitting assemblies are used to re-install the hinge fitting you removed.

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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 No. 2 and 3 Krueger flap and bullnose assembly.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 1 for item numbers.

#### 2. Cleaning

##### A. References

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

##### B. Procedure

- (1) Clean the bearings (95, 110, 160, 380, 385, 390, 585) SOPM 20-30-01.
- (2) Use standard industry procedures and refer to SOPM 20-30-03 to clean all other parts.

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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 for item numbers.

#### 2. Check

##### A. References

Reference	Title
SOPM 20-20-01	MAGNETIC PARTICLE INSPECTION
SOPM 20-20-02	PENETRANT METHODS OF INSPECTION

##### B. Procedure

- (1) Use standard industry procedures to do a visual check of all the parts for defects. Do the penetrant or magnetic particle check if the visual check shows possible damage or if you suspect possible damage on the parts listed below.
- (2) Do a magnetic particle check (SOPM 20-20-01) of these parts:
  - (a) Rod (330A, 335A).
- (3) Do a penetrant check (SOPM 20-20-02) of these parts:
  - (a) Fittings (100, 115, 165, 170)
  - (b) Bellcrank (360)
  - (c) Link (395, 400, 405).
  - (d) Clevis (470).
  - (e) Casting (590, 595, 600, 605).
  - (f) Flap (640, 645).

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CHECK

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## COMPONENT MAINTENANCE MANUAL

### REPAIR

#### 1. General

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

**Table 601:**

<b>PART NUMBER</b>	<b>NAME</b>	<b>REPAIR</b>
—	REFINISH OF OTHER PARTS	1-1
114A1201	CLEVIS ASSEMBLY	2-1, 2-2
114A1221	INBOARD KRUEGER FLAP ASSEMBLY	3-1, 3-2
114A1320	MID BULLNOSE ASSEMBLY	4-1, 4-2
114A1321	INBOARD BULLNOSE ASSEMBLY	5-1, 5-2
114A1401	ROD ASSEMBLY	6-1
114A1411	LINK ASSEMBLY	7-1, 7-2
114A1424	LINK ASSEMBLY	8-1, 8-2
114A1413	BELLCRANK ASSEMBLY	9-1, 9-2
114A1420	MID BULLNOSE LINK ASSEMBLY	10-1
114A1430	INBOARD BULLNOSE LINK ASSEMBLY	11-1
114A1725	FITTING ASSEMBLY	12-1, 12-2
114A1726	NO. 6 FITTING ASSEMBLY	13-1, 13-2
114A1727	NO. 7 FITTING ASSEMBLY	14-1, 14-2
114A1728	NO. 8 FITTING ASSEMBLY	15-1, 15-2

#### 2. Dimensioning Symbols

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

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REPAIR - GENERAL

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

### EXAMPLES

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

True Position Dimensioning Symbols  
Figure 601

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REPAIR - GENERAL

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## COMPONENT MAINTENANCE MANUAL

### REFINISH OF OTHER PARTS - REPAIR 1-1

#### 1. General

- A. This procedure has the data necessary to refinish the parts which are not given in the specified repairs.
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.

#### 2. Refinish of Other Parts

- A. Consumable Materials

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

Reference	Description	Specification
C00033	Coating - Exterior Protective Enamel, Flexibility Use	BMS10-60, Type II
C00175	Primer - Urethane Compatible, Corrosion Resistant (Less Than 1% Aromatic Amines)	BMS10-79, Type III
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23

- B. References

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

- C. General

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

- D. Procedure

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

- (1) Refer to REPAIR 1-1, Table 601 for refinish details.

**Table 601:** Refinish Details

IPL FIG. & ITEM	MATERIAL	FINISH
IPL Fig. 1		
Flap assembly (1B, 5A)		Do this after all finishing and sealing are done: Mask the seals, bearings, ID plate. Apply water displacing and corrosion inhibiting compound, G00009 to all surfaces of the flap and bullnose but not on the OML surface, inside torque tube, hinge arms, and on the surface at the inboard end.

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REPAIR 1-1

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

<b>IPL FIG. &amp; ITEM</b>	<b>MATERIAL</b>	<b>FINISH</b>
Target (40)	HYMU80	Cadmium plate (F-15.06). Apply primer, C00175 primer (F-19.47). Apply enamel coating, C00033 (F-19.39-707).
Bracket (55, 60)	Aluminum alloy	Chemical treat (F-17.07). Apply primer, C00175 (F-19.47). Apply enamel coating, C00033 (F-19.39-707).
Seal retainer (490)	Aluminum alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00175 (F-19.47). Apply enamel coating, C00033(F-19.39-707).
Seal retainer (495)		Chemical treat (F-17.10) and apply primer, C00259 (F-20.02) to all trimmed aluminum edges.

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REPAIR 1-1

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## COMPONENT MAINTENANCE MANUAL

### CLEVIS ASSEMBLY - REPAIR 2-1

114A1201-1

#### 1. General

- A. This procedure has the data necessary to repair and refinish the clevis assembly (455).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for item numbers.

#### 2. Bushing Replacement

- A. Consumable Materials

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

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

- B. References

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

- C. Procedure

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

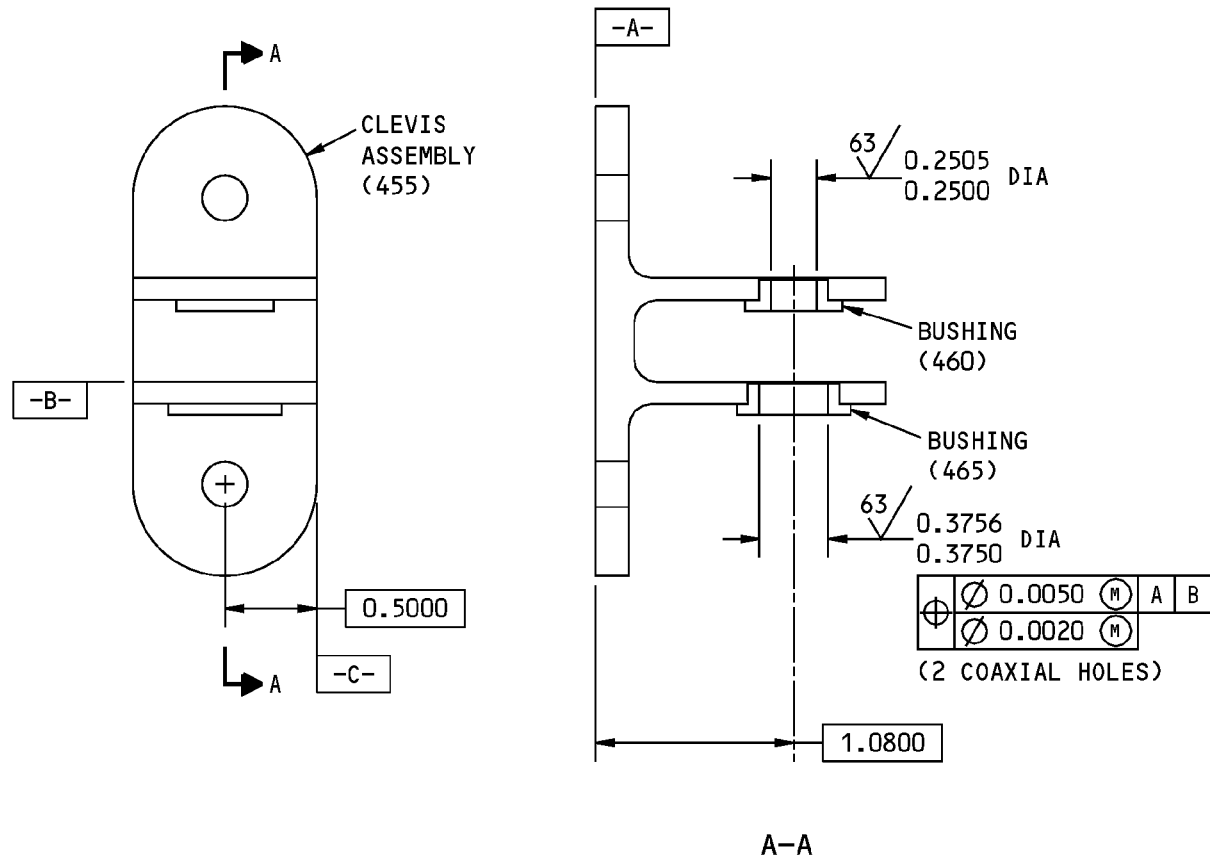
- (1) Remove the bushings (460, 465) from the clevis (470).
- (2) Install the new bushings (460, 465) on the clevis (470) with sealant, A00247. Use the shrink-fit method (SOPM 20-50-03).
- (3) Ream the inside diameter of the bushings (460, 465) to the dimensions shown in REPAIR 2-1, Figure 601.
- (4) Break all sharp edges.

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REPAIR 2-1  
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# COMPONENT MAINTENANCE MANUAL



63/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

114A1201-1 Clevis Assembly Repair  
Figure 601

## 57-56-44

REPAIR 2-1

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## COMPONENT MAINTENANCE MANUAL

### CLEVIS - REPAIR 2-2

114A1201-3

#### 1. General

- A. This procedure has the data necessary to repair and refinish the clevis (470).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for item numbers.
- E. General repair details:
  - (1) Material: 7050-T7451 Aluminum alloy

#### 2. Clevis Refinish

- A. Consumable Materials

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

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

- B. References

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

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

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

- (1) Boric acid - sulfuric acid anodize or chromic acid anodize (F-17.31).
- (2) Apply primer, C00175 (F-19.47) all over the clevis (470) but not in the bore.
- (3) Apply enamel coating, C00033 (F-19.39-707) all over but not in the bore.

# 57-56-44

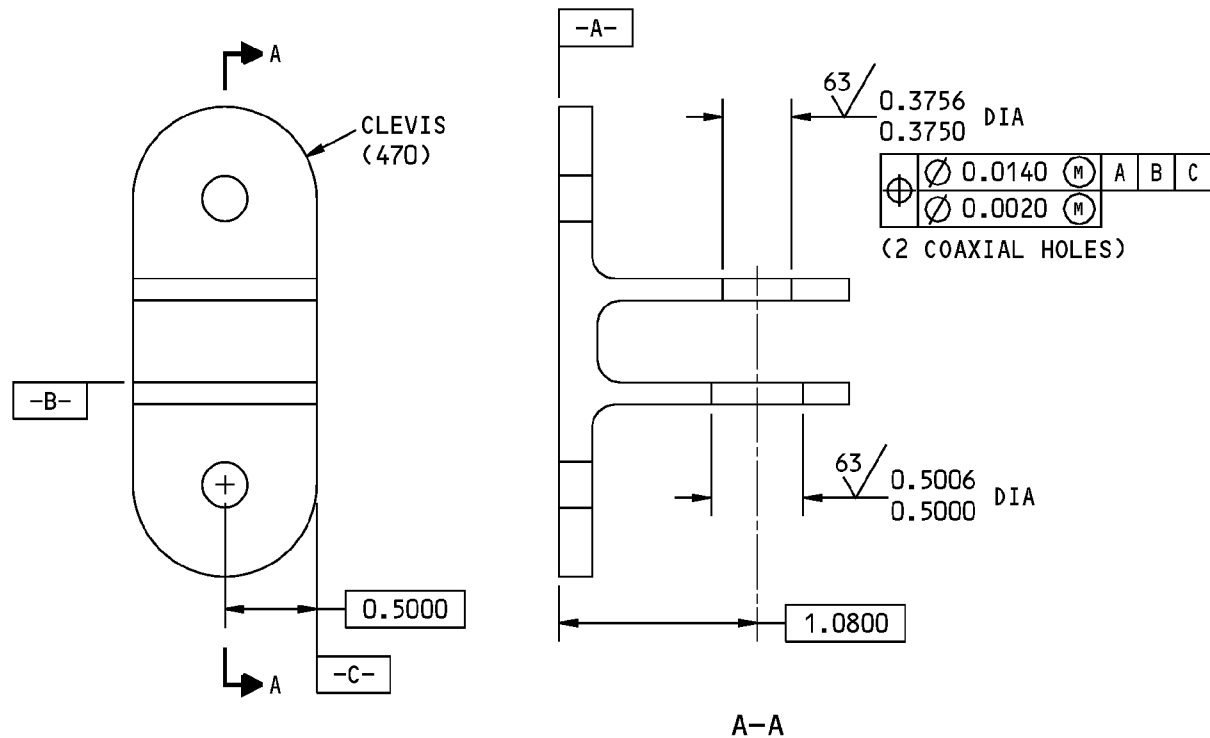
REPAIR 2-2

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## COMPONENT MAINTENANCE MANUAL



63/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

114A1201-3 Clevis Repair  
Figure 601

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REPAIR 2-2

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## COMPONENT MAINTENANCE MANUAL

### INBOARD KRUEGER FLAP ASSEMBLY - REPAIR 3-1

114A1221-1, -2, -201, -202

#### 1. General

- A. This procedure has the data necessary to repair and refinish the inboard Krueger flap assembly (610, 615).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for item numbers.

#### 2. Bushing Replacement

- A. Consumable Materials

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

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

- B. References

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

- C. Procedure

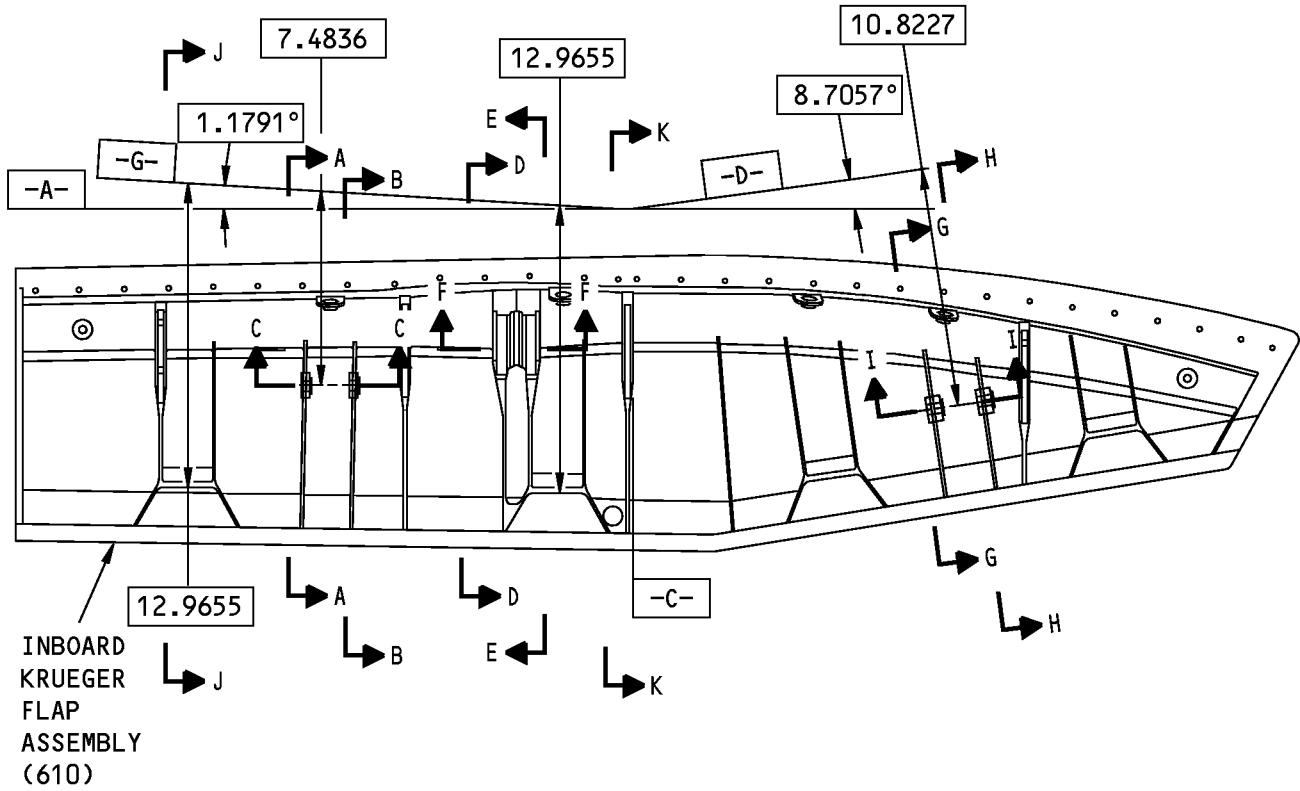
**NOTE:** For stripping of protective finishes, refer to SOPM 20-30-02. For decoding table for Boeing finishes codes, refer to SOPM 20-41-01. For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Remove the bushings (620, 625, 630, 635) from the flap (640, 645).
- (2) Install the new bushings (620, 625, 630, 635) on the flap (640, 645) with sealant, A00247. Use the shrink fit method (SOPM 20-50-03).
- (3) Ream the inside diameter of the bushings (620, 625, 630, 635) to the dimensions shown in REPAIR 3-1, Figure 601.
- (4) Break all sharp edges.

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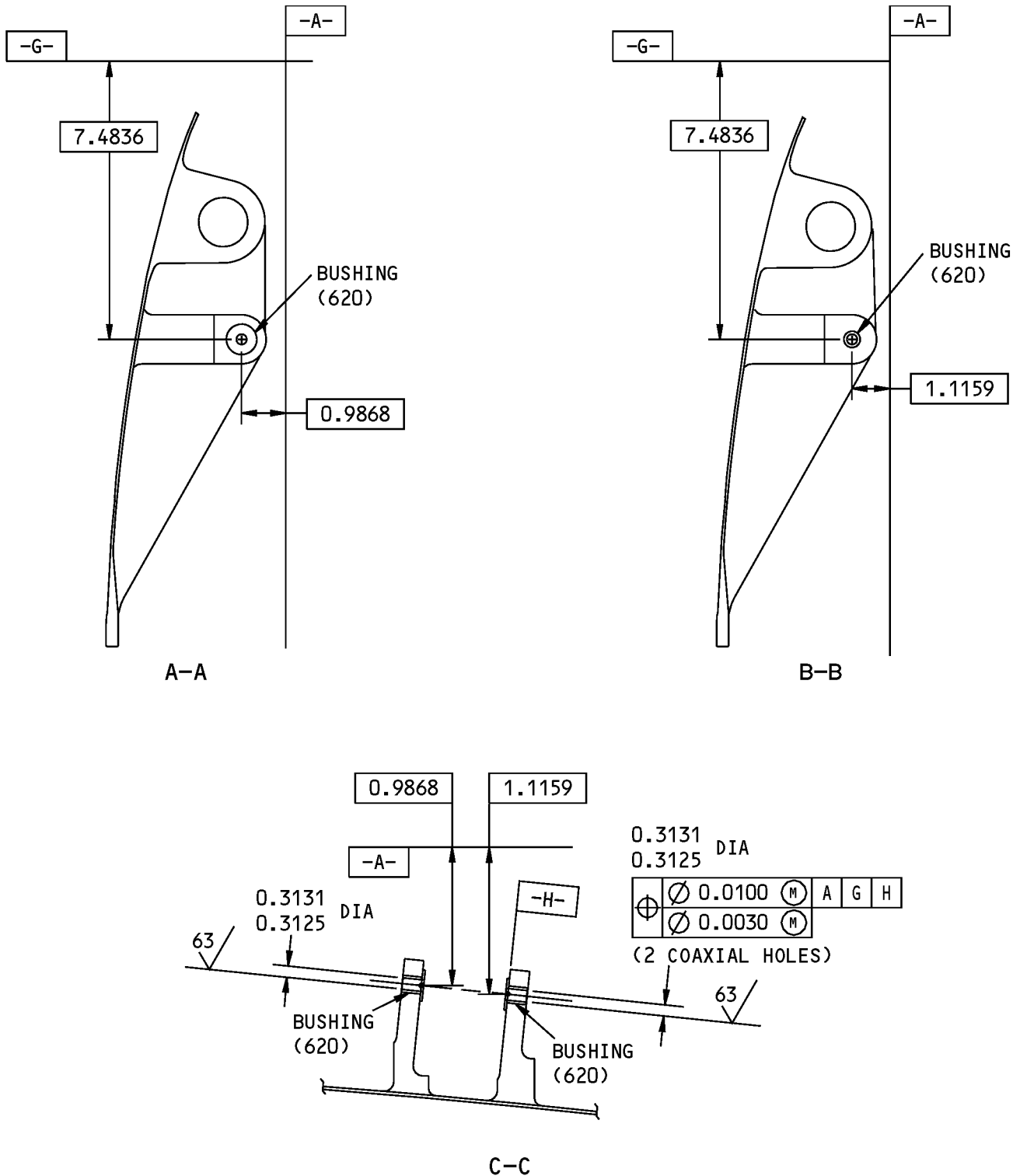
114A1221-1,-2,-201,-202 Inboard Krueger Flap Assembly Repair  
Figure 601 (Sheet 1 of 5)

## 57-56-44

REPAIR 3-1

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**COMPONENT MAINTENANCE MANUAL**

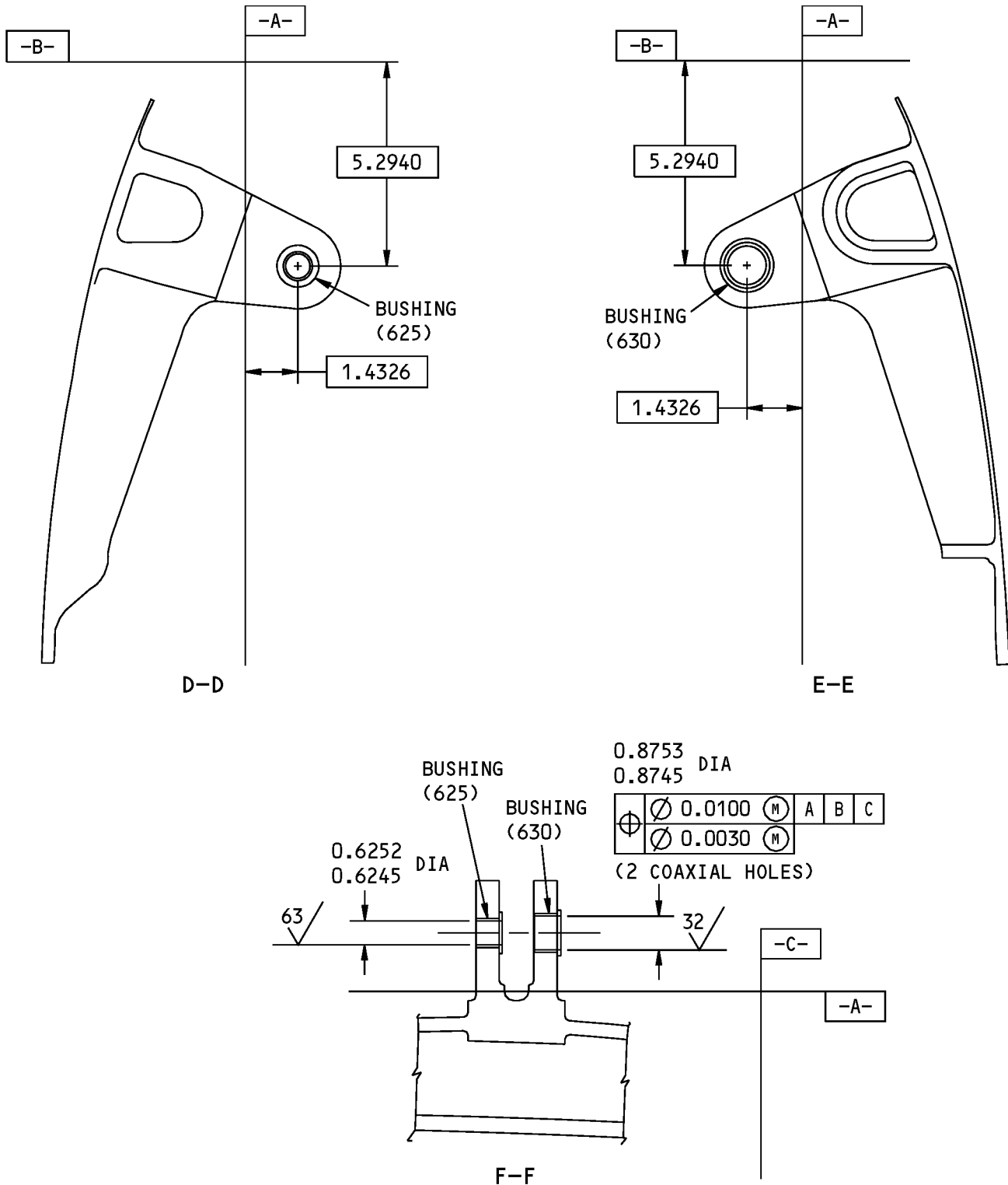
114A1221-1,-2,-201,-202 Inboard Krueger Flap Assembly Repair  
Figure 601 (Sheet 2 of 5)

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REPAIR 3-1

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**COMPONENT MAINTENANCE MANUAL**

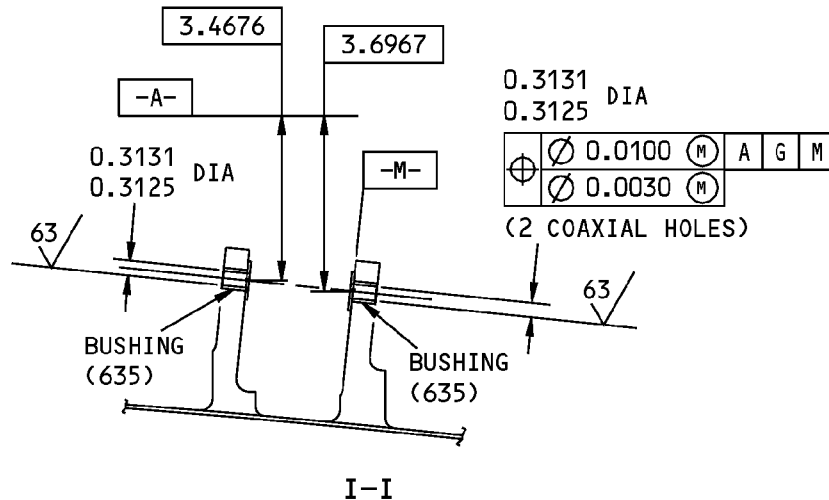
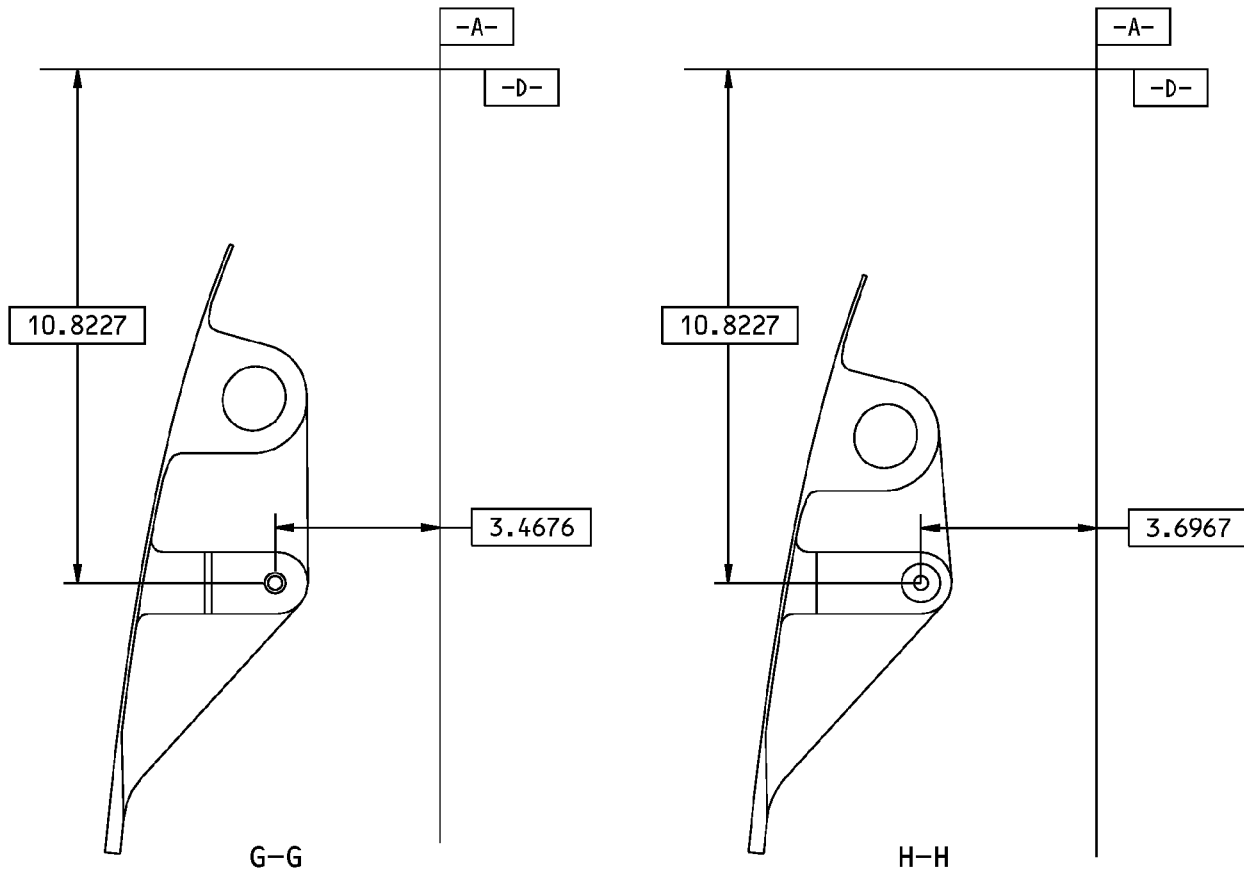
114A1221-1,-2,-201,-202 Inboard Krueger Flap Assembly Repair  
Figure 601 (Sheet 3 of 5)

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REPAIR 3-1

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**COMPONENT MAINTENANCE MANUAL**

114A1221-1,-2,-201,-202 Inboard Krueger Flap Assembly Repair  
Figure 601 (Sheet 4 of 5)

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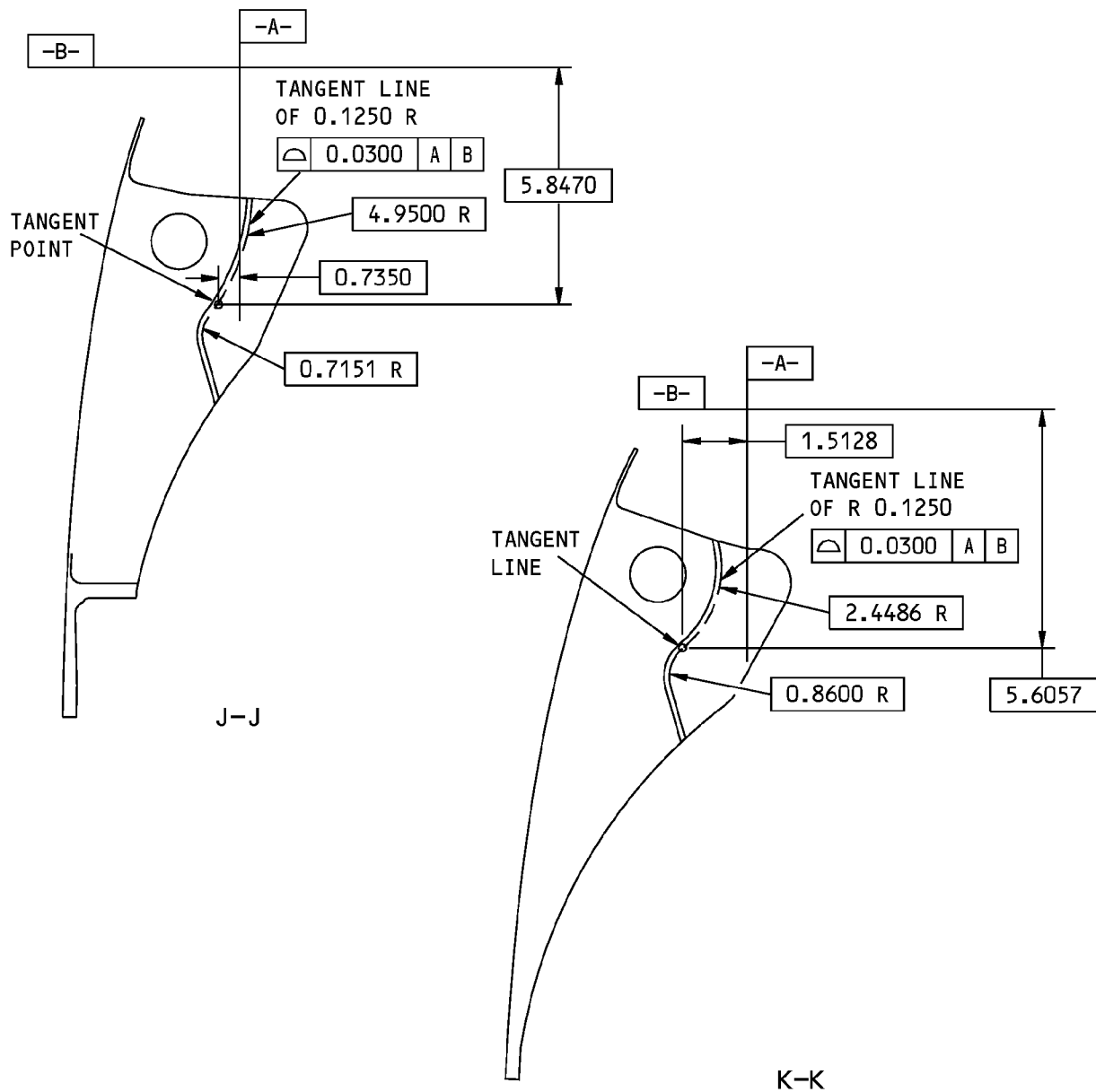
REPAIR 3-1

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# COMPONENT MAINTENANCE MANUAL



125/ ALL MACHINED SURFACES UNLESS  
SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

114A1221-1,-2,-201,-202 Inboard Krueger Flap Assembly Repair  
Figure 601 (Sheet 5 of 5)

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REPAIR 3-1

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## COMPONENT MAINTENANCE MANUAL

### FLAP - REPAIR 3-2

114A1221-3, -4, -203, -204

#### 1. General

- A. This procedure has the data necessary to repair and refinish the flap (640, 645).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for item numbers.
- E. General repair details:
  - (1) Material: A357-T61 Aluminum alloy

#### 2. Flap Refinish

- A. Consumable Materials

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

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

- B. References

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

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

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

- (1) Apply Boric Acid - sulfuric acid anodize or chromic acid as follows:
  - (a) For 114A1221-3, -4: Boric acid - sulfuric acid anodize or chromic acid anodize (F-17.35). Anodize is not required on the inside diameter of the torque tube. Throw-in allowed.
  - (b) For 114A1221-203, -204: Boric acid - sulfuric acid anodize or chromic acid anodize (F-17.35). Anodize is not required on the inside diameter of the torque tube. Throw-in allowed.
- (2) Apply primer, C00175 (F-19.47) all over the flap (640, 645) but not in the bores.
- (3) Apply enamel coating, C00033 (F-19.39-707) all over but not in the bores.

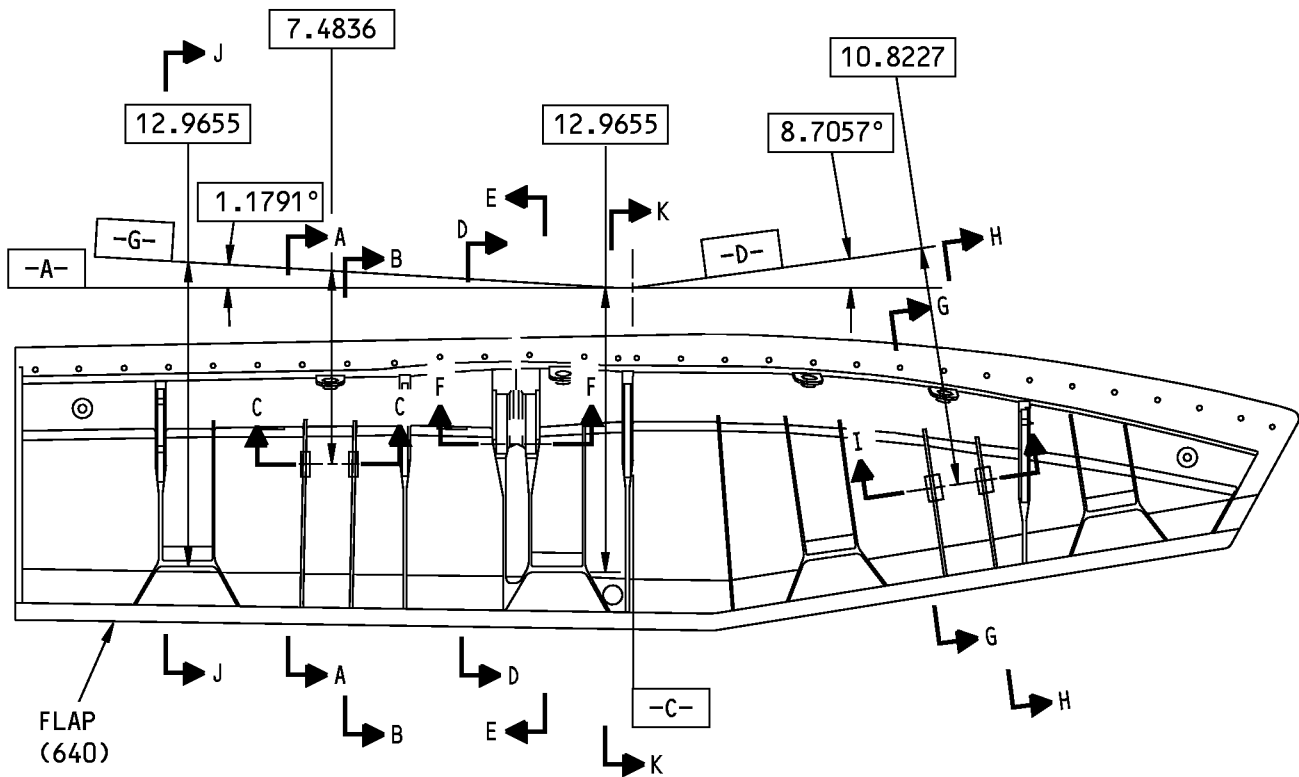
# 57-56-44

REPAIR 3-2

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114A1221-3,-4,-203,-204 Inboard Krueger Flap Assembly Repair  
Figure 601 (Sheet 1 of 5)

## 57-56-44

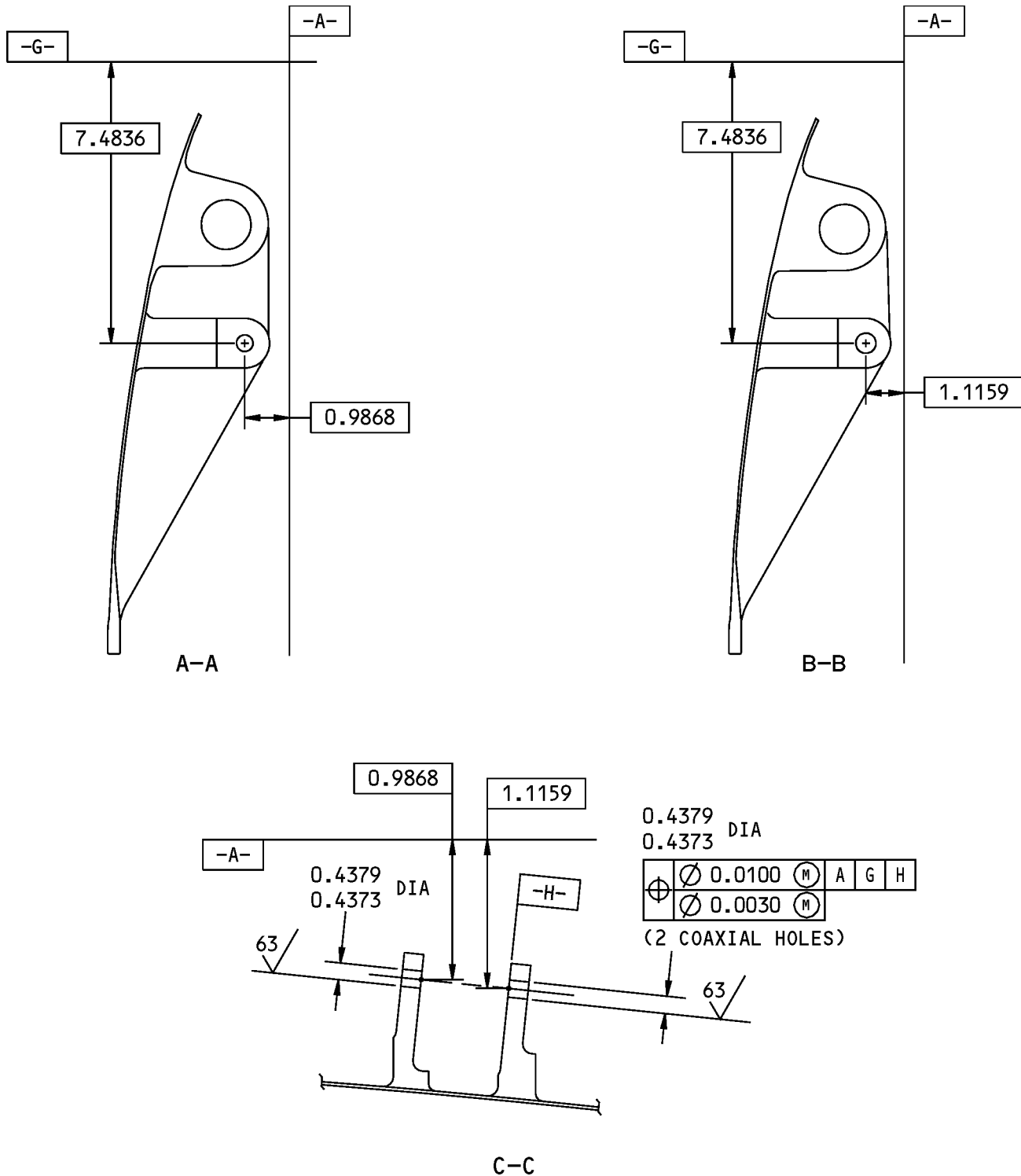
REPAIR 3-2

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# COMPONENT MAINTENANCE MANUAL



114A1221-3,-4,-203,-204 Inboard Krueger Flap Assembly Repair  
Figure 601 (Sheet 2 of 5)

## 57-56-44

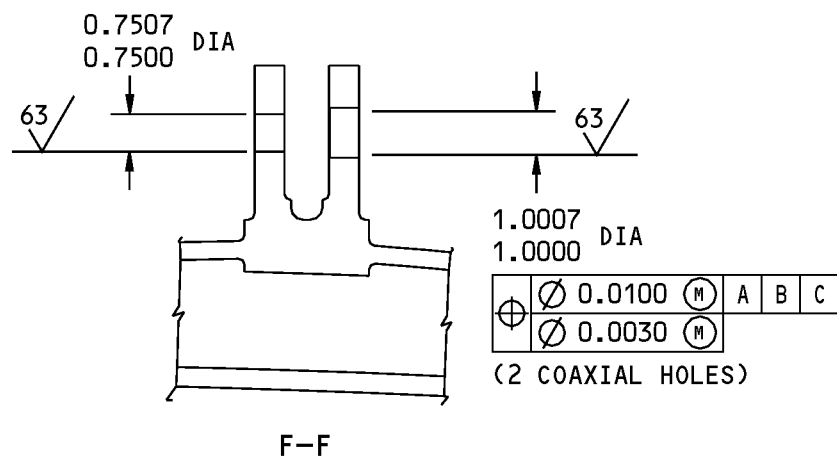
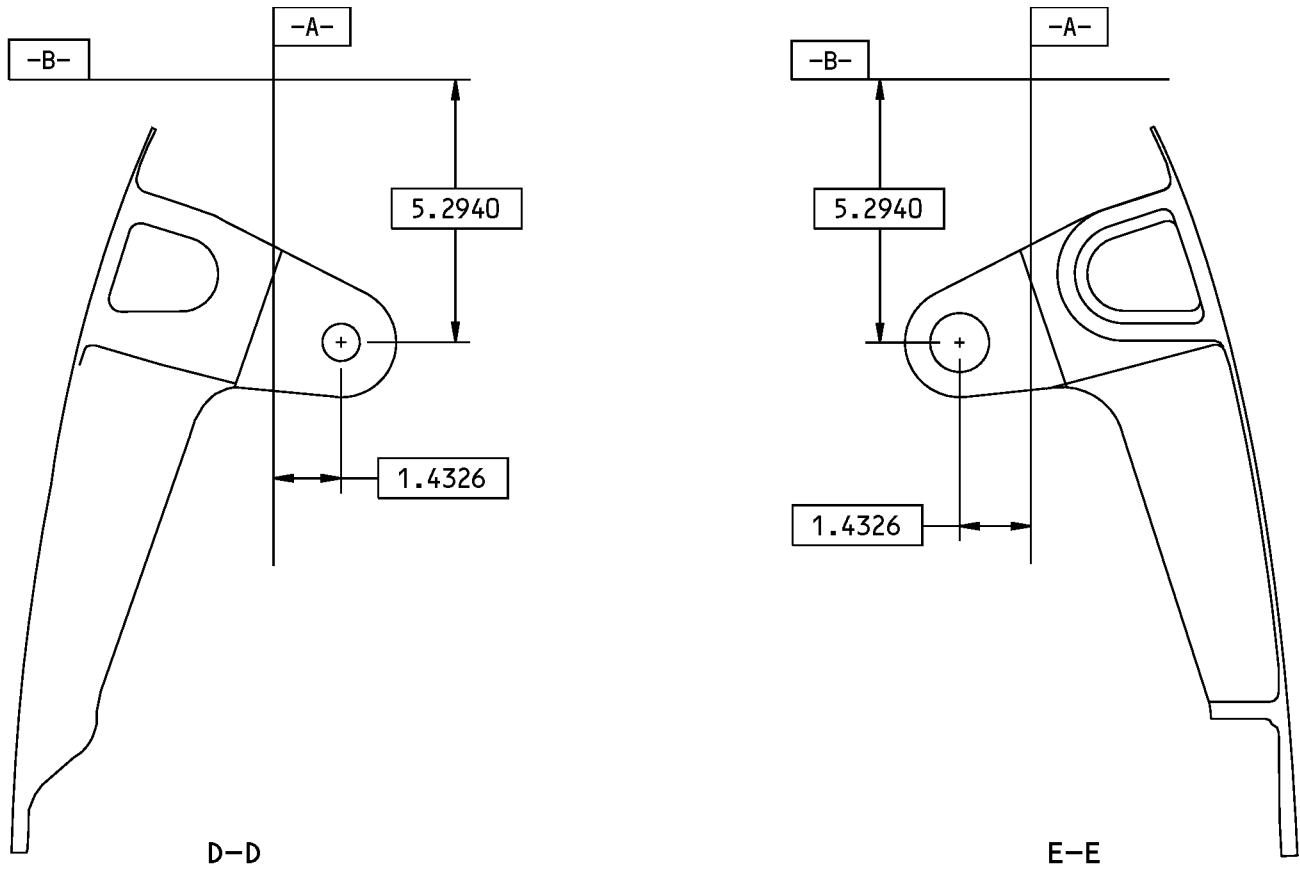
REPAIR 3-2

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114A1221-3,-4,-203,-204 Inboard Krueger Flap Assembly Repair  
Figure 601 (Sheet 3 of 5)

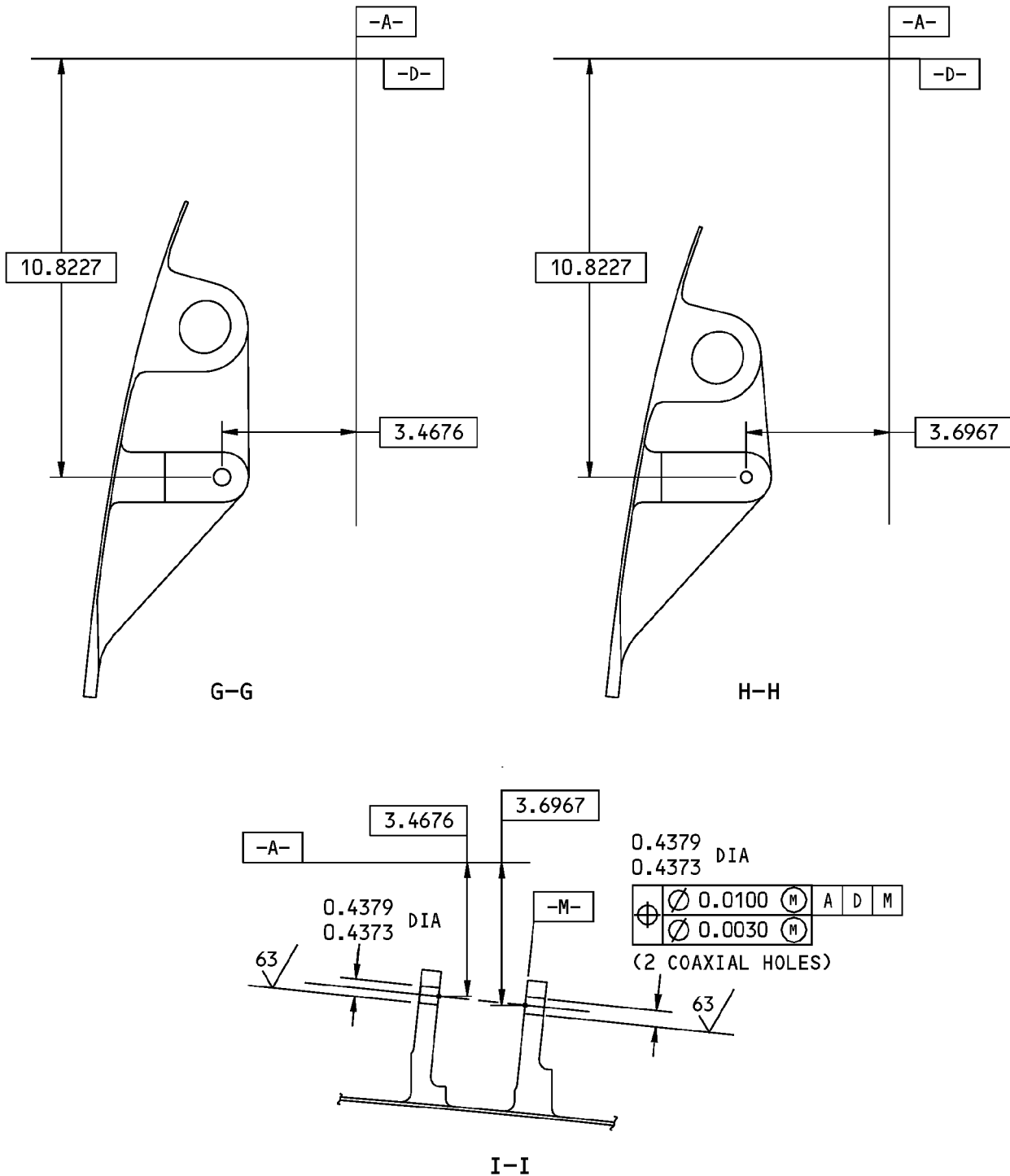
## 57-56-44

REPAIR 3-2

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## COMPONENT MAINTENANCE MANUAL



114A1221-3,-4,-203,-204 Inboard Krueger Flap Assembly Repair  
Figure 601 (Sheet 4 of 5)

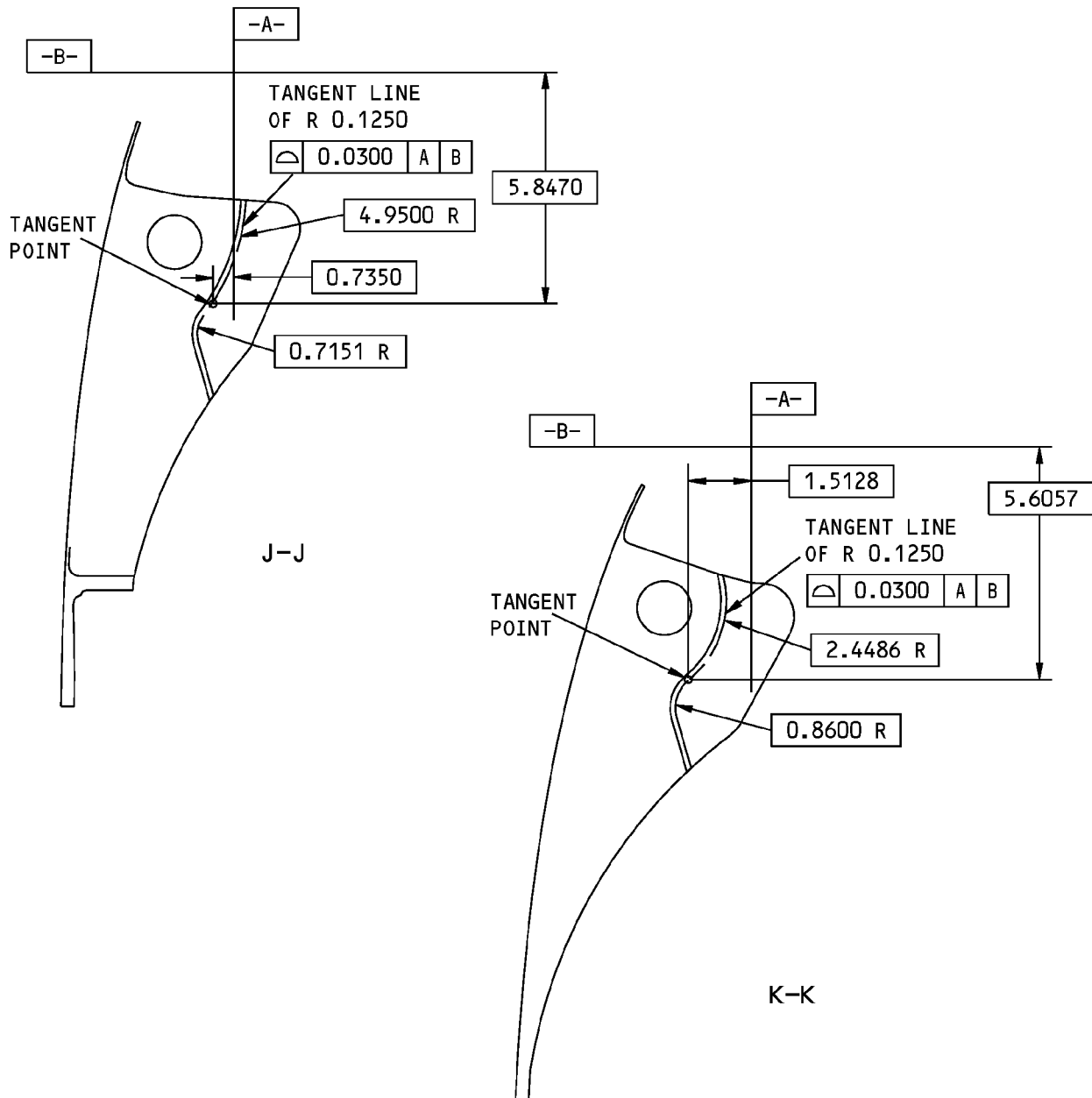
# 57-56-44

REPAIR 3-2

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# COMPONENT MAINTENANCE MANUAL



125/ ALL MACHINED SURFACES UNLESS  
SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

114A1221-3,-4,-203,-204 Inboard Krueger Flap Assembly Repair  
Figure 601 (Sheet 5 of 5)

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REPAIR 3-2

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## COMPONENT MAINTENANCE MANUAL

### MID BULLNOSE ASSEMBLY - REPAIR 4-1

114A1320-1, -2

#### 1. General

- A. This procedure has the data necessary to repair and refinish the mid bullnose assembly (555, 560).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for item numbers.

#### 2. Bearing Replacement

- A. Consumable Materials

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

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

- B. References

Reference	Title
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT

- C. Procedure

- (1) Remove the bearings (585) from the casting (590, 595).
- (2) Install the new bearings (585) on the casting (590, 595) with sealant, A00247 and roller swage (SOPM 20-50-03).

#### 3. Bushing Replacement

- A. Consumable Materials

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

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

- B. References

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

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## COMPONENT MAINTENANCE MANUAL

### C. Procedure

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

- (1) Remove the bushing (575, 580) from the casting (590, 595).
- (2) Install the new bushing (575, 580) on the casting (590, 595) with sealant, A00247. Use the shrink fit method (SOPM 20-50-03).
- (3) Ream the inside diameter of the bushing (575, 580) to the dimensions shown on REPAIR 4-1, Figure 601.
- (4) Break all sharp edges.

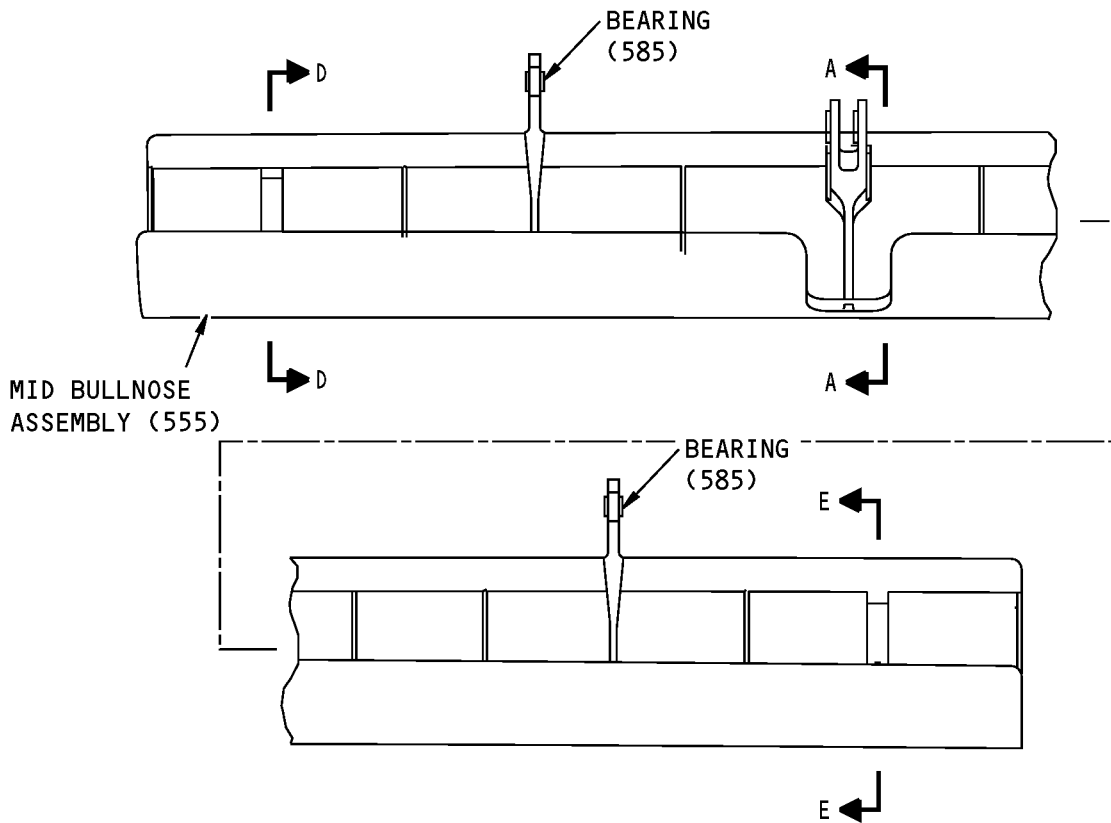
# 57-56-44

REPAIR 4-1  
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## COMPONENT MAINTENANCE MANUAL



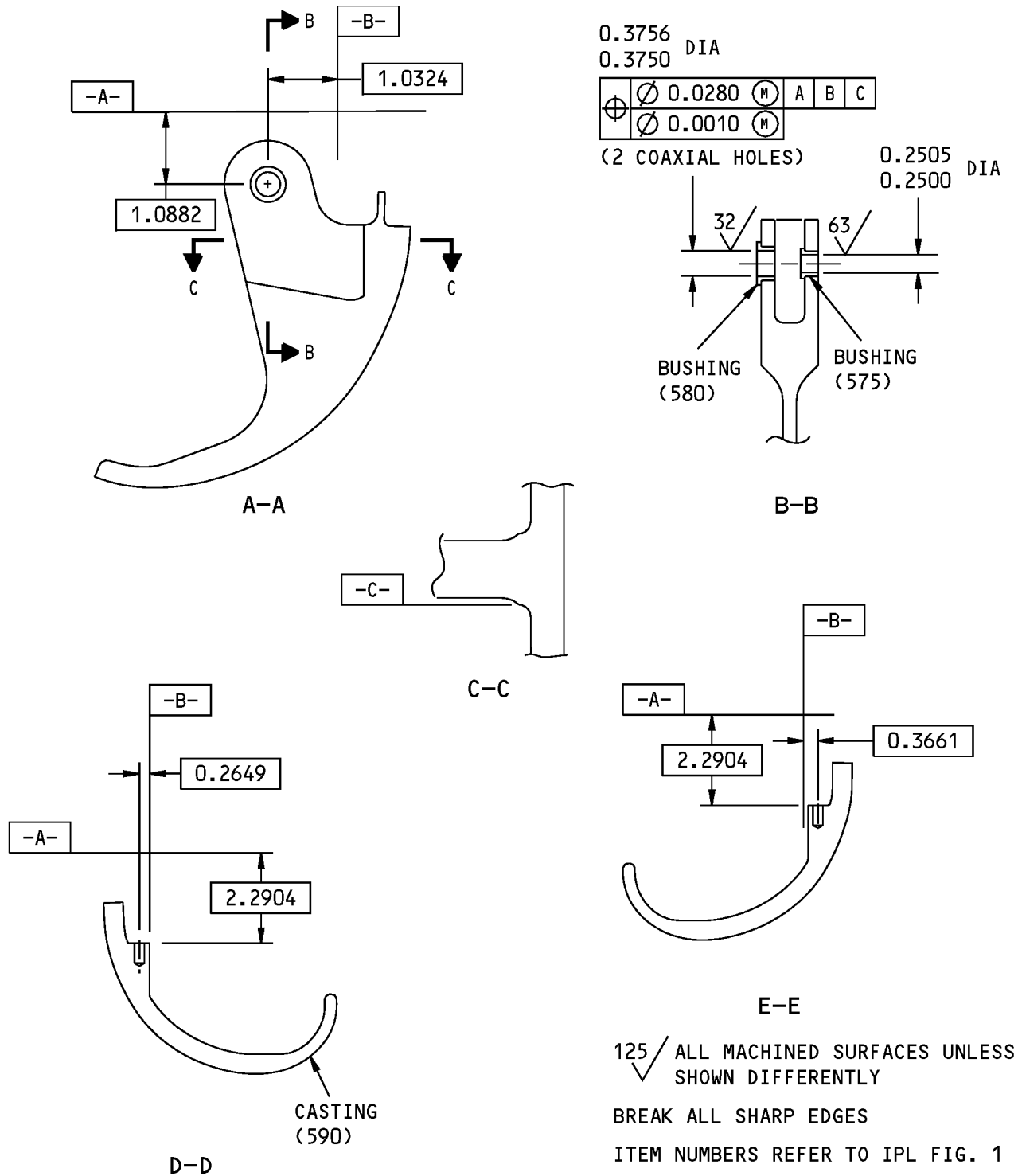
114A1320-1 SHOWN  
114A1320-2 OPPOSITE

114A1320-1,-2 Mid Bullnose Assembly Repair  
Figure 601 (Sheet 1 of 2)

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REPAIR 4-1  
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# COMPONENT MAINTENANCE MANUAL



114A1320-1,-2 Mid Bullnose Assembly Repair  
Figure 601 (Sheet 2 of 2)

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## COMPONENT MAINTENANCE MANUAL

### CASTING - REPAIR 4-2

114A1320-3, -4

#### 1. General

- A. This procedure has the data necessary to repair and refinish the casting (590, 595).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for item numbers.
- E. General repair details:
  - (1) Material: A357-T61 Aluminum alloy

#### 2. Casting Refinish

- A. Consumable Materials

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

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

- B. References

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

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

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

- (1) Boric acid - sulfuric acid anodize or chromic acid anodize (F-17.31).
- (2) Apply one coat primer, C00175 (F-19.47) all over the casting (590, 595) but not in the bushing and bearing bores.
- (3) Apply enamel coating, C00033 (F-19.39-707) all over but not in the bushing and bearing bores.

# 57-56-44

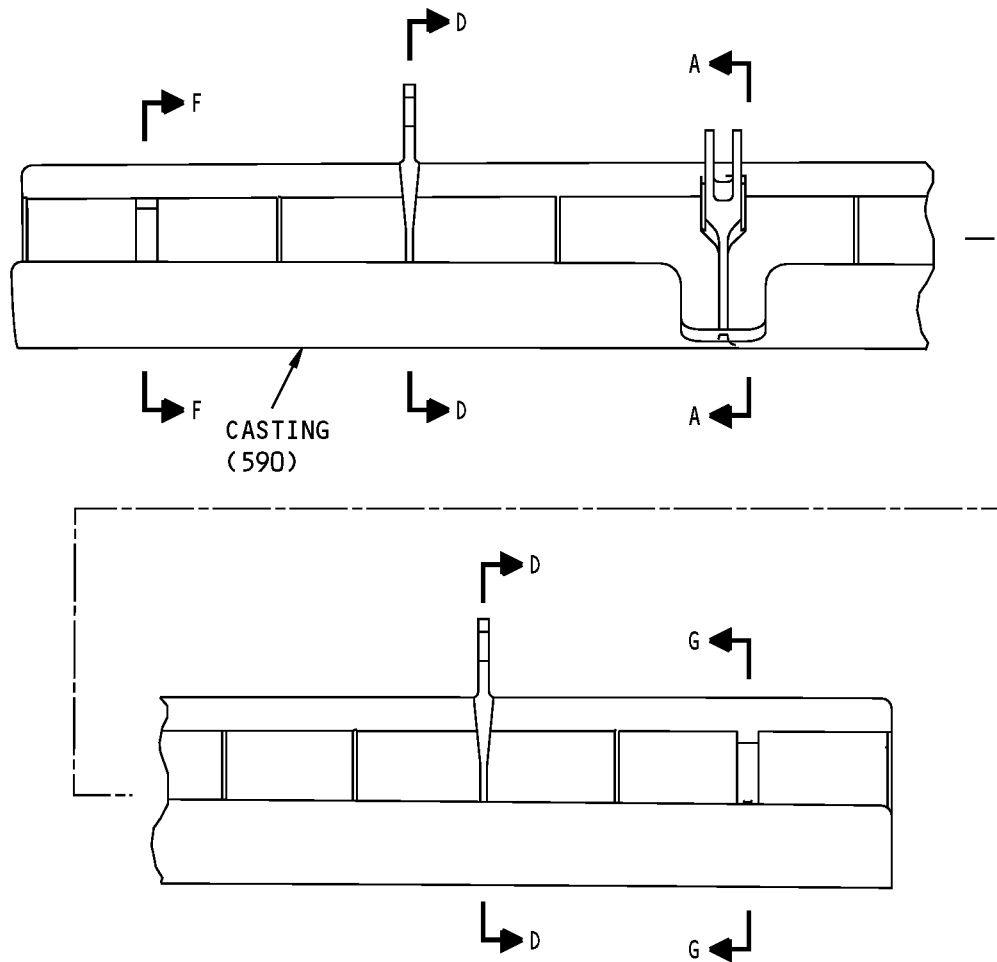
REPAIR 4-2

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114A1320-3 SHOWN  
114A1320-4 OPPOSITE

114A1320-3,-4 Casting Repair  
Figure 601 (Sheet 1 of 3)

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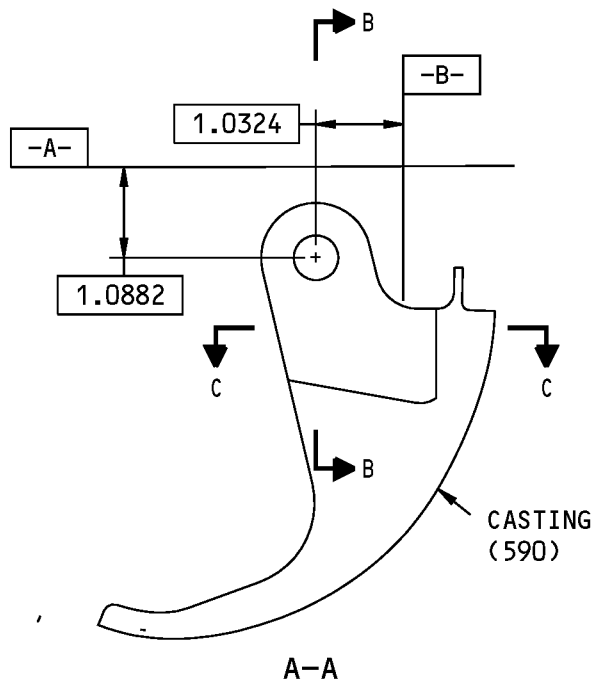
REPAIR 4-2

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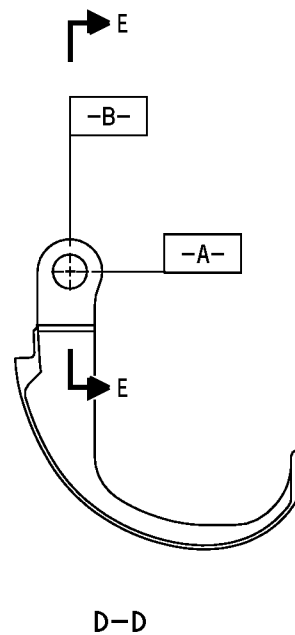
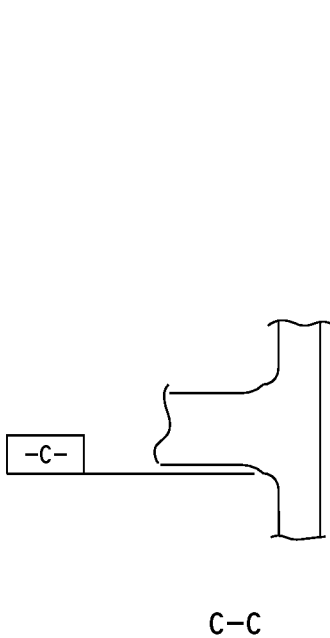
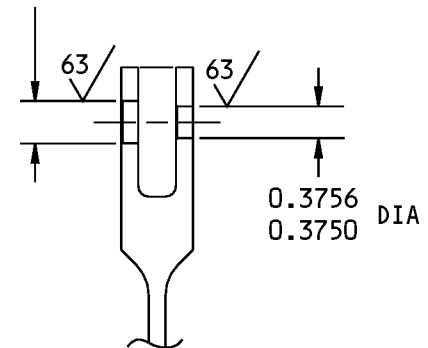
# COMPONENT MAINTENANCE MANUAL



0.5006 DIA  
0.5000

⊕	⌀ 0.0280 (M)	A	B	C
	⌀ 0.0020 (M)			

(2 COAXIAL HOLES)



114A1320-3,-4 Casting Repair  
Figure 601 (Sheet 2 of 3)

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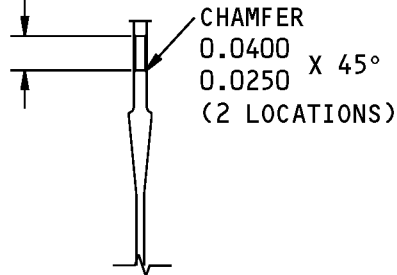


# COMPONENT MAINTENANCE MANUAL

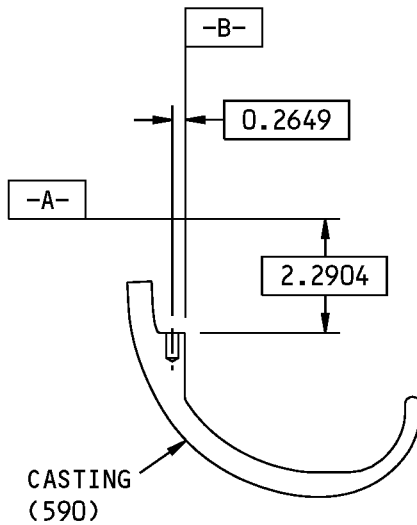
0.6885  
0.6875 DIA

$\oplus$   $\ominus$  0.0050  $\textcircled{M}$  A B

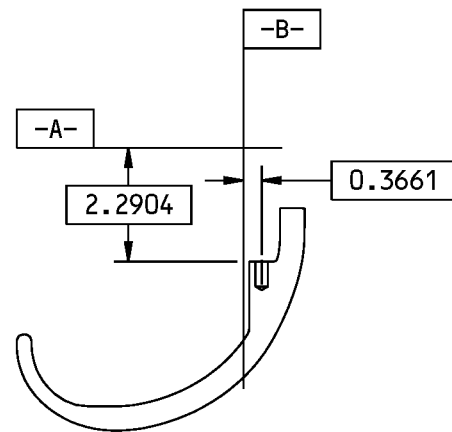
(2 COAXIAL HOLES)



E-E



F-F



G-G

125/ ALL MACHINED SURFACES UNLESS  
SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

114A1320-3,-4 Casting Repair  
Figure 601 (Sheet 3 of 3)

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REPAIR 4-2

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## COMPONENT MAINTENANCE MANUAL

### INBOARD BULLNOSE ASSEMBLY - REPAIR 5-1

114A1321-1, -2

#### 1. General

- A. This procedure has the data necessary to repair and refinish the inboard bullnose assembly (565, 570).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for item numbers.

#### 2. Bearing Replacement

- A. Consumable Materials

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

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

- B. References

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

- C. Procedure

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

- (1) Remove the bearings (585) from the casting (600, 605).
- (2) Install the new bearings (585) on the casting (600, 605) with sealant, A00247 and roller swage (SOPM 20-50-03).

#### 3. Bushing Replacement

- A. Consumable Materials

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

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

- B. References

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

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Reference	Title
SOPM 20-60-04	MISCELLANEOUS MATERIALS

**C. Procedure**

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

- (1) Remove the bushing (575, 580) from the casting (600, 605).
- (2) Install the new bushing (575, 580) on the casting (600, 605) with sealant, A00247. Use the shrink fit method (SOPM 20-50-03).
- (3) Ream the inside diameter of the bushing (575, 580) to the dimensions shown on REPAIR 5-1, Figure 601.
- (4) Break all sharp edges.

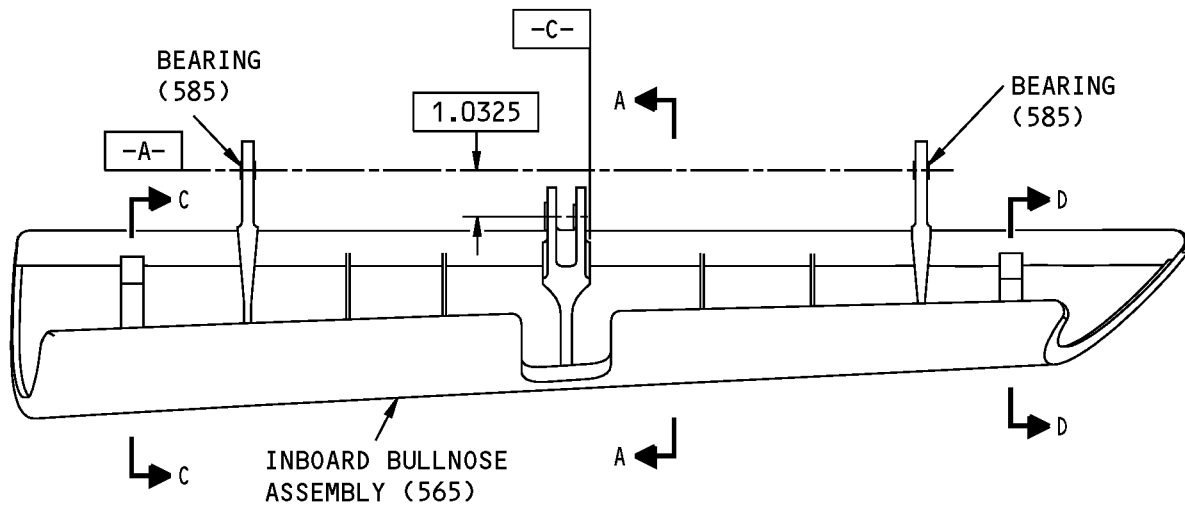
**57-56-44**

REPAIR 5-1

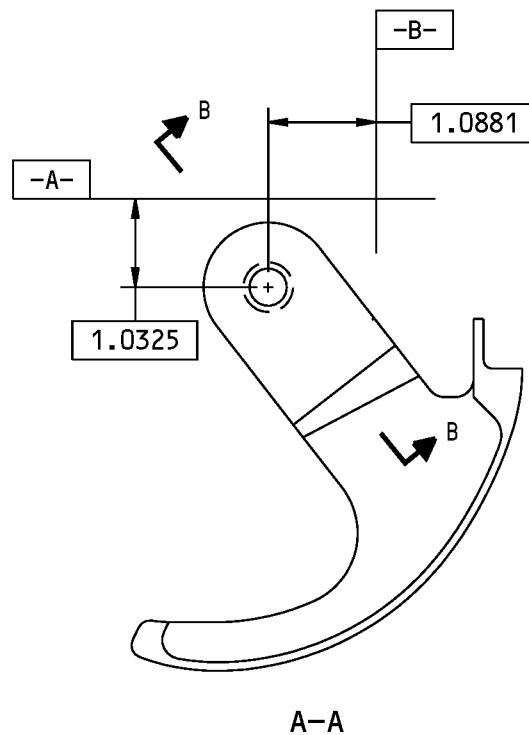
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114A1321-1 SHOWN  
114A1321-2 OPPOSITE



114A1321-1,-2 Inboard Bullnose Assembly Repair  
Figure 601 (Sheet 1 of 2)

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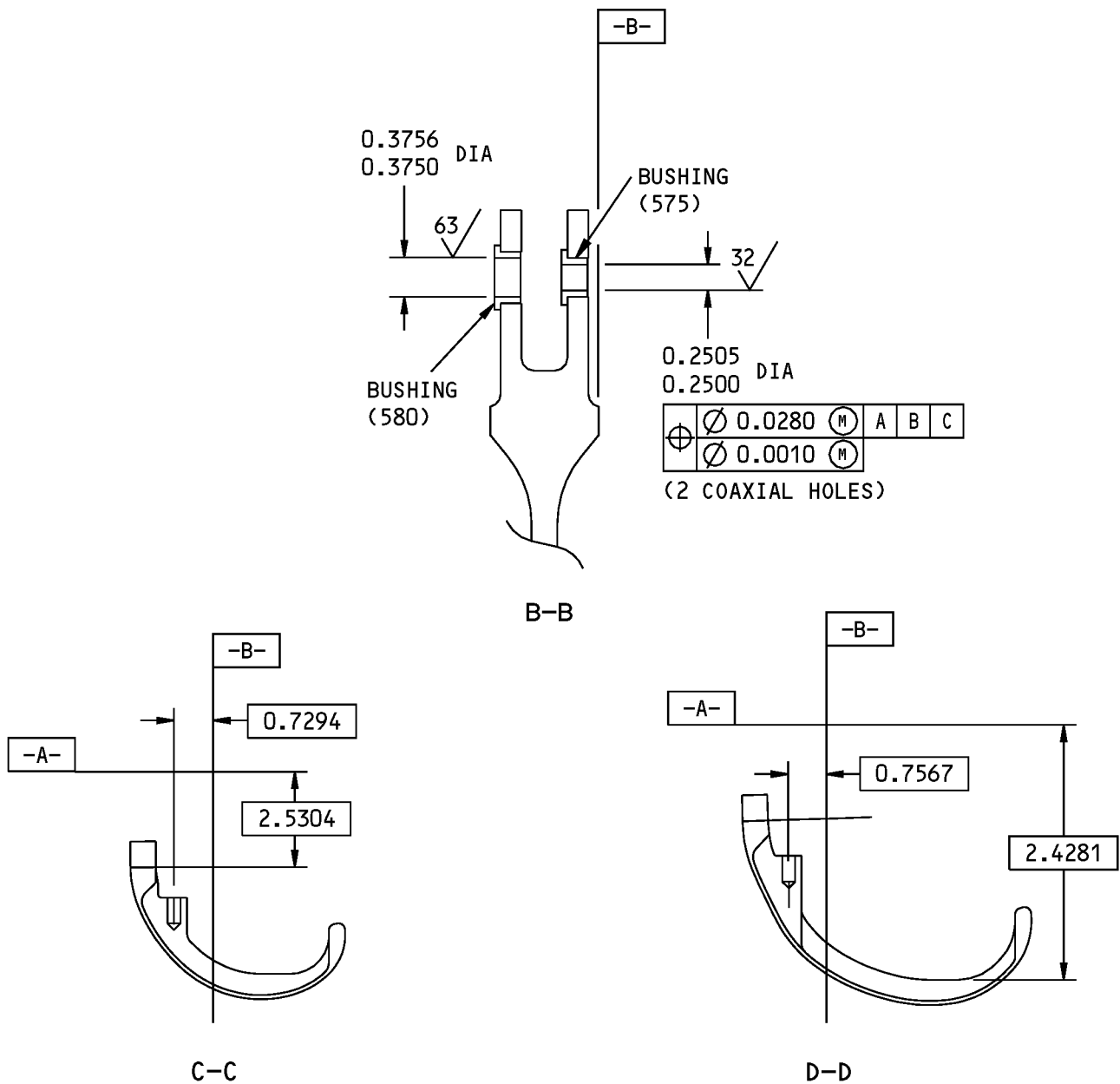
REPAIR 5-1

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# COMPONENT MAINTENANCE MANUAL



125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

114A1321-1,-2 Inboard Bullnose Assembly Repair  
Figure 601 (Sheet 2 of 2)

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REPAIR 5-1

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## COMPONENT MAINTENANCE MANUAL

### CASTING - REPAIR 5-2

114A1321-3, -4

#### 1. General

- A. This procedure has the data necessary to repair and refinish the casting (600, 605).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for item numbers.
- E. General repair details:
  - (1) Material: A357-T61 Aluminum alloy

#### 2. Casting Refinish

- A. Consumable Materials

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

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

- B. References

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

- C. Procedure (REPAIR 5-2, Figure 601)

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

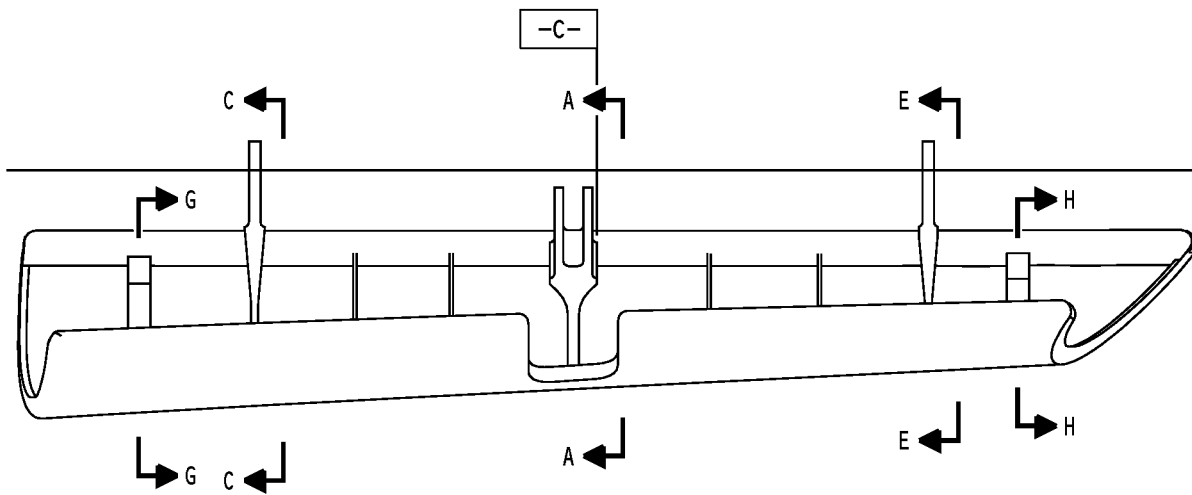
- (1) Boric acid - sulfuric acid anodize or chromic acid anodize (F-17.31).
- (2) Apply one coat primer, C00175 (F-19.47) all over the casting (600, 605) but not in the bushing and bearing bores.
- (3) Apply enamel coating, C00033 (F-19.39-707) all over but not in the bushing and bearing bores.

# 57-56-44

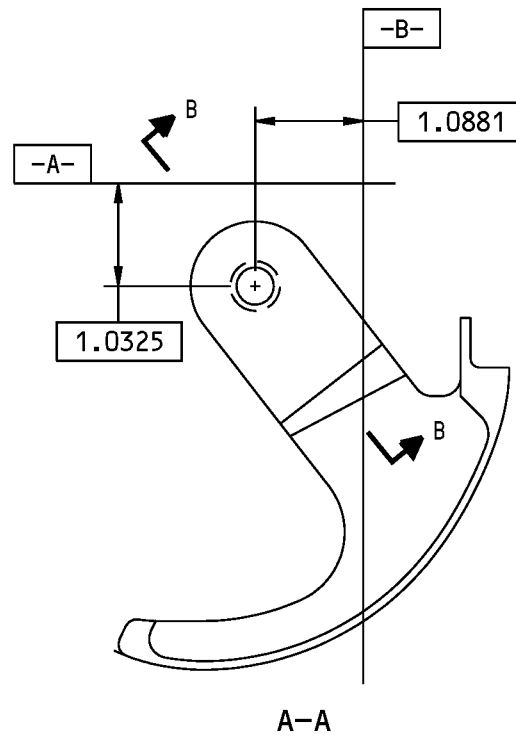
REPAIR 5-2

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**COMPONENT MAINTENANCE MANUAL**

114A1321-3 SHOWN  
114A1321-4 OPPOSITE



114A1321-3,-4 Casting Repair  
Figure 601 (Sheet 1 of 3)

# 57-56-44

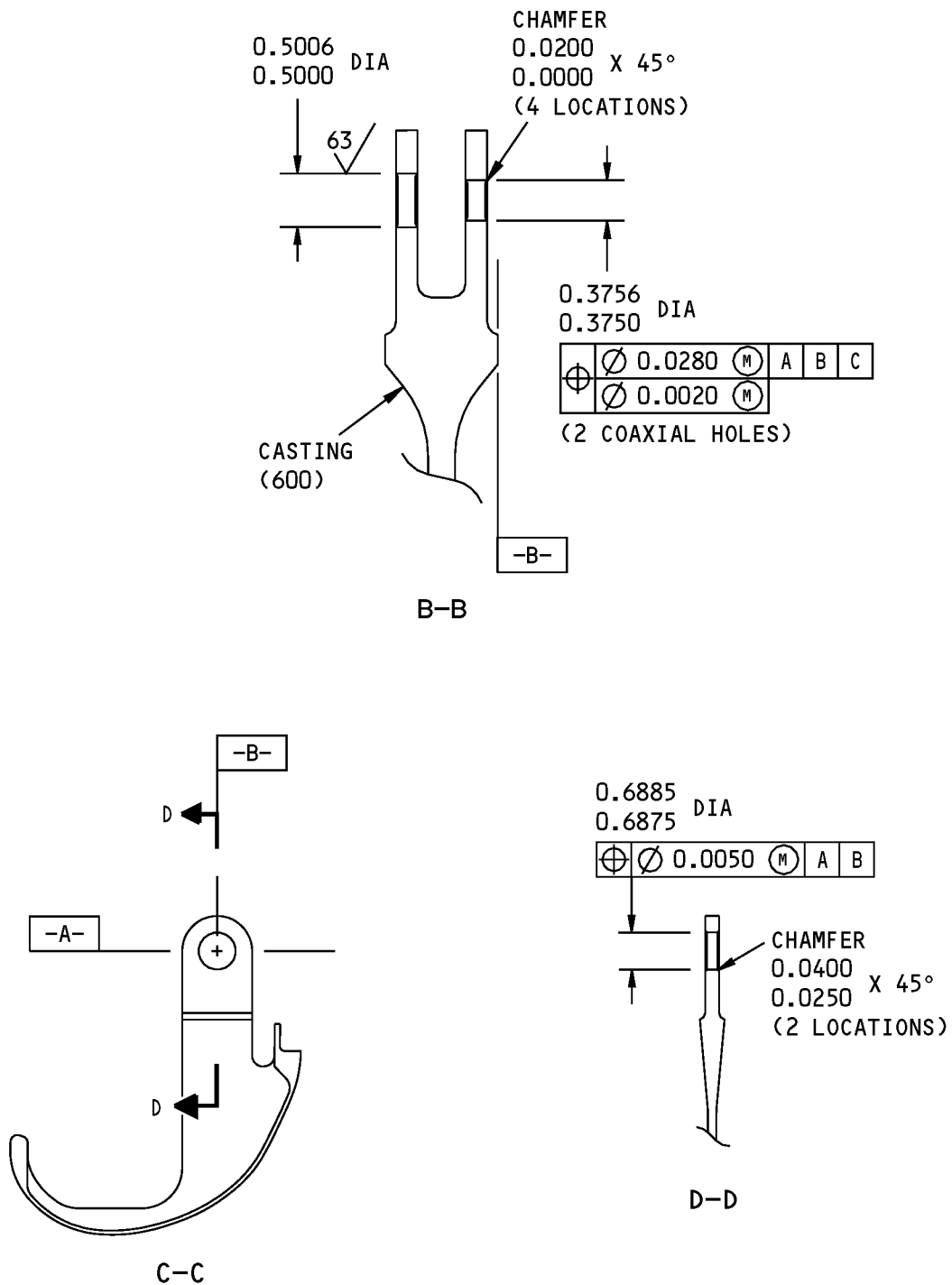
REPAIR 5-2

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# COMPONENT MAINTENANCE MANUAL



114A1321-3,-4 Casting Repair  
Figure 601 (Sheet 2 of 3)

## 57-56-44

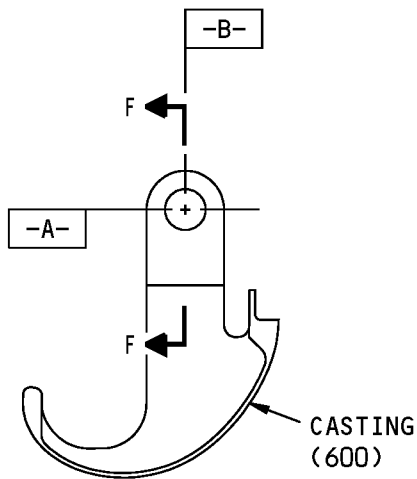
REPAIR 5-2

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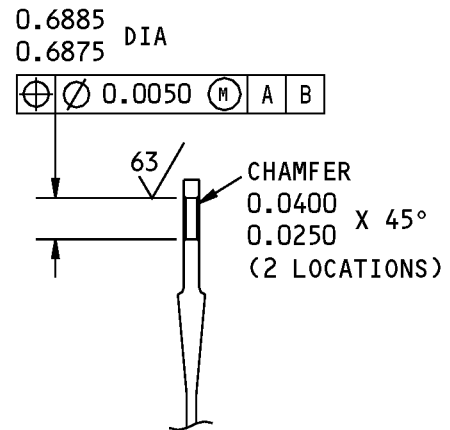
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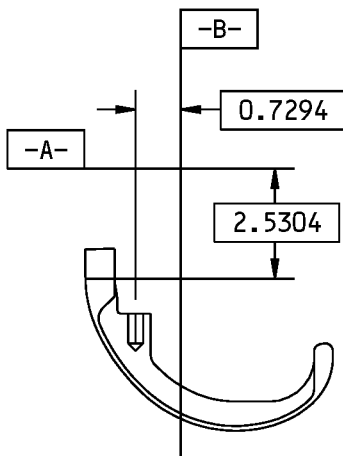
# COMPONENT MAINTENANCE MANUAL



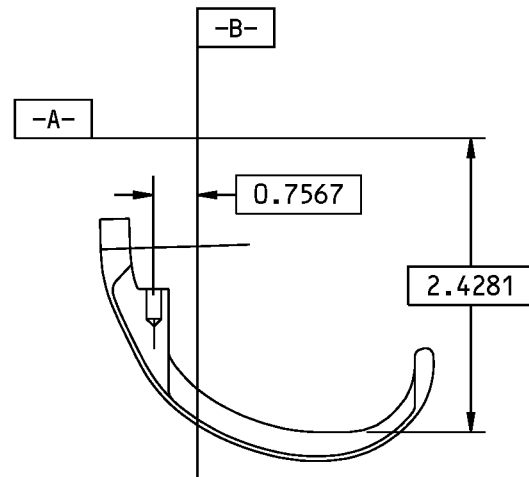
E-E



F-F



G-G



H-H

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

114A1321-3,-4 Casting Repair  
Figure 601 (Sheet 3 of 3)

## 57-56-44

REPAIR 5-2

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## COMPONENT MAINTENANCE MANUAL

### ROD ASSEMBLY - REPAIR 6-1

114A1401-9, -11

#### 1. General

- A. This procedure has the data necessary to repair and refinish the rod assembly (295A, 300A).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for item numbers.

#### 2. Rod End Bearing Replacement

- A. Procedure

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

- (1) Loosen the nut (305, 310) and remove the rod end bearing (320B, 325B) and washer (315) from the rod (330A, 335A).
- (2) Install the new rod end bearing (320B, 325B) on the rod (330A, 335A) with washer (315) (SOPM 20-50-03). See REPAIR 6-1, Figure 601 for the correct dimensions.
- (3) Tighten the nuts (305).

#### 3. Rod Refinish

- A. References

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

- B. Procedure

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

- (1) Passivate (F-17.25) the rod (330A, 335A).

# 57-56-44

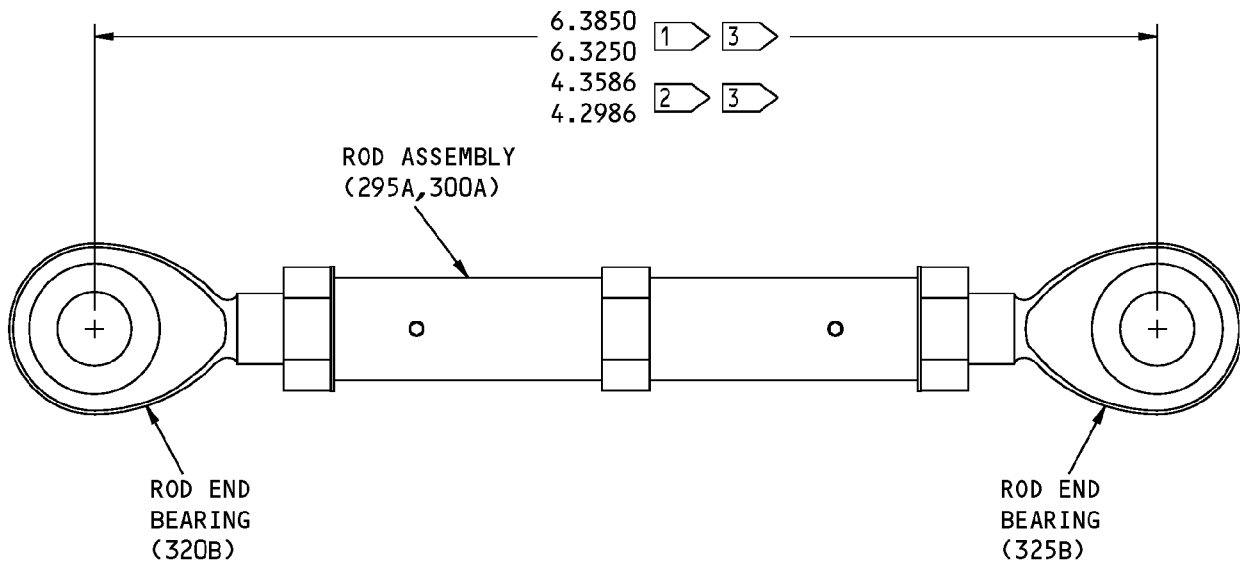
REPAIR 6-1

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# COMPONENT MAINTENANCE MANUAL



114A1401-9 SHOWN

1 FOR 114A1401-9

2 FOR 114A1401-11

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

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

114A1401-9,-11 Rod Assembly Repair  
Figure 601

## 57-56-44

REPAIR 6-1

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## COMPONENT MAINTENANCE MANUAL

### LINK ASSEMBLY - REPAIR 7-1

114A1411-1

#### 1. General

- A. This procedure has the data necessary to repair and refinish the link assembly (365).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601) for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for item numbers.

#### 2. Bearing Replacement

- A. Consumable Materials

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

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

- B. References

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

- C. Procedure

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

- (1) Remove the bearing (380, 390) from the link (395).
- (2) Install the new bearing (380, 390) on the link (395) with sealant, A00247 and roller swage (SOPM 20-50-03).

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REPAIR 7-1

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## COMPONENT MAINTENANCE MANUAL

### LINK - REPAIR 7-2

114A1411-2

#### 1. General

- A. This procedure has the data necessary to repair and refinish the link (395).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for item numbers.
- E. General repair details:
  - (1) Material: 7050-T7451 Aluminum alloy
  - (2) Shot peen: All surfaces, except in holes (SOPM 20-10-03)
    - (a) Intensity 0.005A-0.010A
    - (b) Coverage 1.0 (automated), 2.0 (manual)

#### 2. Link Refinish

- A. Consumable Materials

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

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

- B. References

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

- C. Procedure (REPAIR 7-2, Figure 601)

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

- (1) Boric acid - sulfuric acid anodize or chromic acid anodize (F-17.31).
- (2) Apply primer, C00175 (F-19.47) all over the link (395) but not in the bores.
- (3) Apply enamel coating, C00033 (F-19.39-707) all over but not in the bores.

# 57-56-44

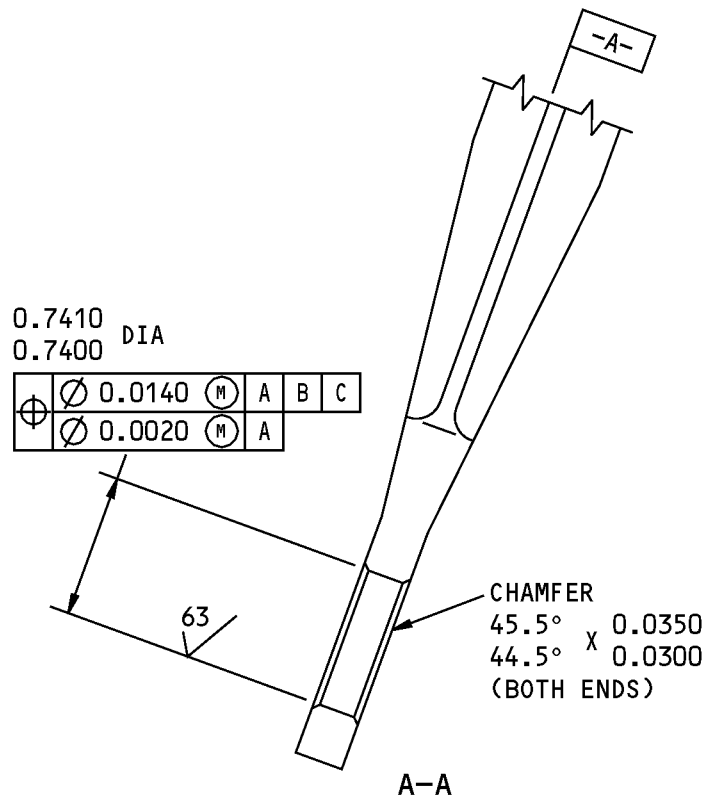
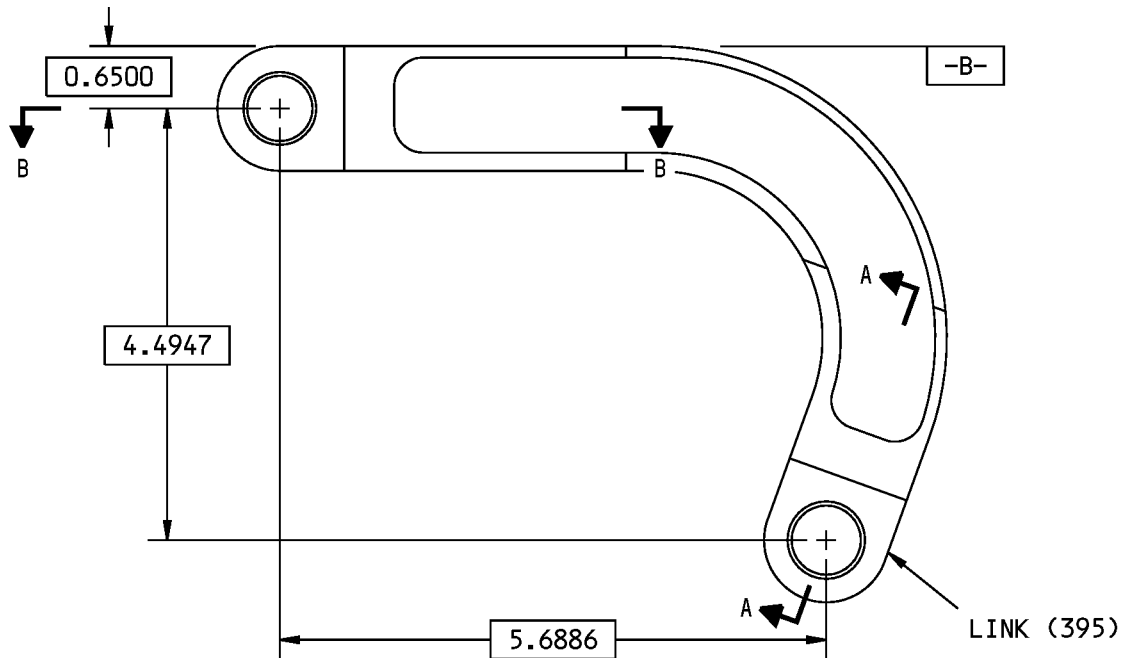
REPAIR 7-2

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# COMPONENT MAINTENANCE MANUAL



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

## 57-56-44

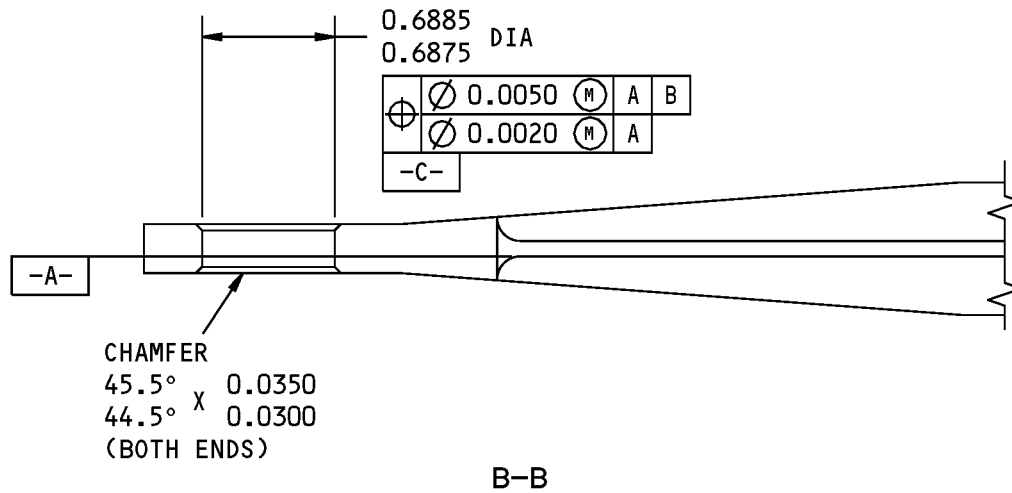
REPAIR 7-2

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## COMPONENT MAINTENANCE MANUAL



63/ ALL MACHINED SURFACES UNLESS  
SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

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

**57-56-44**

REPAIR 7-2

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## COMPONENT MAINTENANCE MANUAL

### LINK ASSEMBLY - REPAIR 8-1

114A1424-1, -2, -5, -6

#### 1. General

- A. This procedure has the data necessary to repair and refinish the link assembly (370, 375).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for item numbers.

#### 2. Bearing Replacement

- A. Consumable Materials

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

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

- B. References

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

- C. Procedure

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

- (1) Remove the bearing (385, 390) from the link (400, 405).
- (2) Install the new bearing (385, 390) on the link (400, 405) with sealant, A00247 and roller swage (SOPM 20-50-03).

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REPAIR 8-1  
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## COMPONENT MAINTENANCE MANUAL

### LINK - REPAIR 8-2

114A1424-3, -4, -7, -8

#### 1. General

- A. This procedure has the data necessary to repair and refinish the link (400, 405).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for item numbers.
- E. General repair details:
  - (1) Material: 7050-T7451 Aluminum alloy
  - (2) Shot peen: All surfaces, except in holes (SOPM 20-10-03)
    - (a) Intensity 0.005A-0.010A
    - (b) Coverage 1.0 (automated), 2.0 (manual)

#### 2. Link Refinish

- A. Consumable Materials

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

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

- B. References

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

- C. Procedure (REPAIR 8-2, Figure 601, REPAIR 8-2, Figure 602)

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

- (1) Boric acid - sulfuric acid anodize or chromic acid anodize (F-17.31).
- (2) Apply one coat primer, C00175 (F-19.47) all over the link (400, 405) but not in the bores.
- (3) Apply enamel coating, C00033 (F-19.39-707) all over but not in the bores.

# 57-56-44

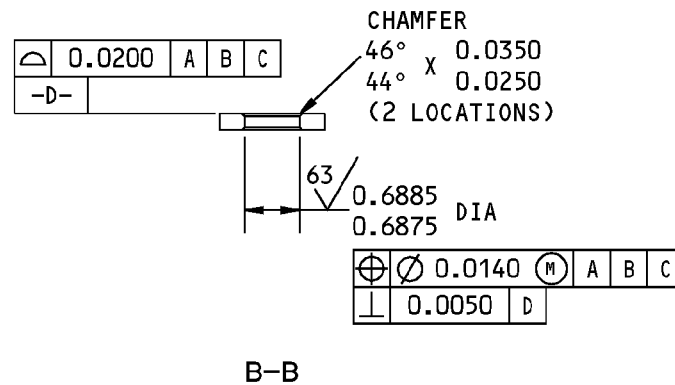
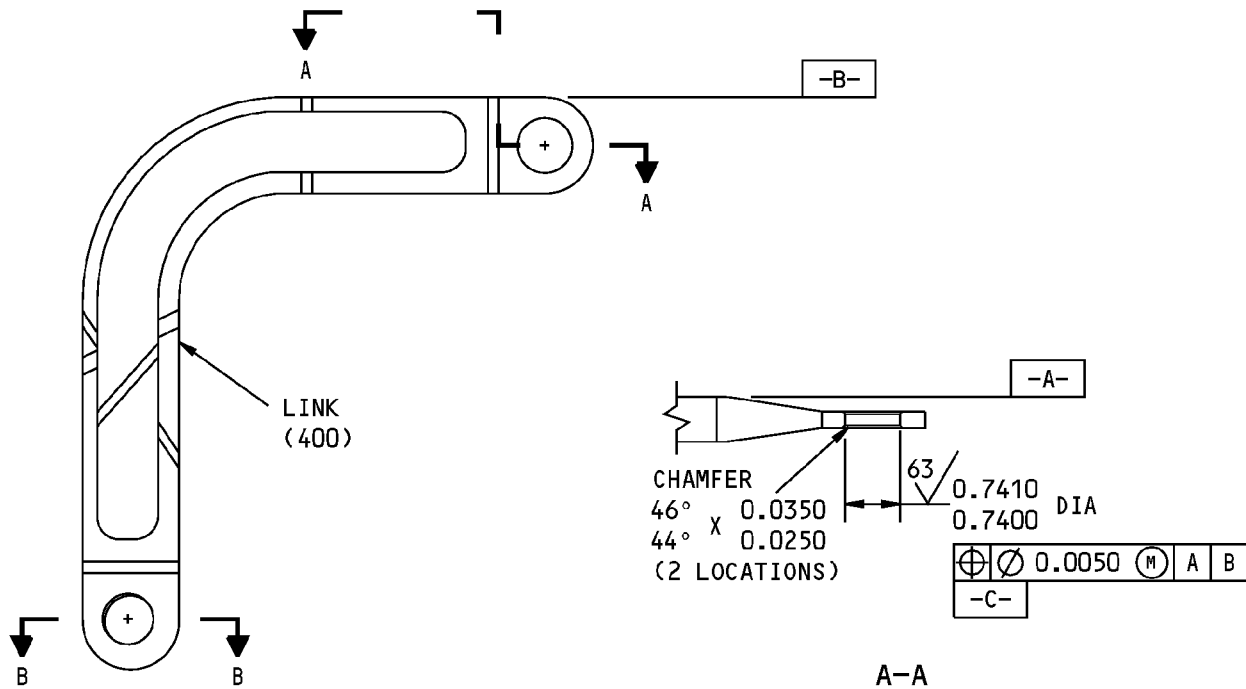
REPAIR 8-2

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## COMPONENT MAINTENANCE MANUAL



125/ ALL MACHINED SURFACES UNLESS  
SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

114A1424-3,-4 Link Repair  
Figure 601

**57-56-44**

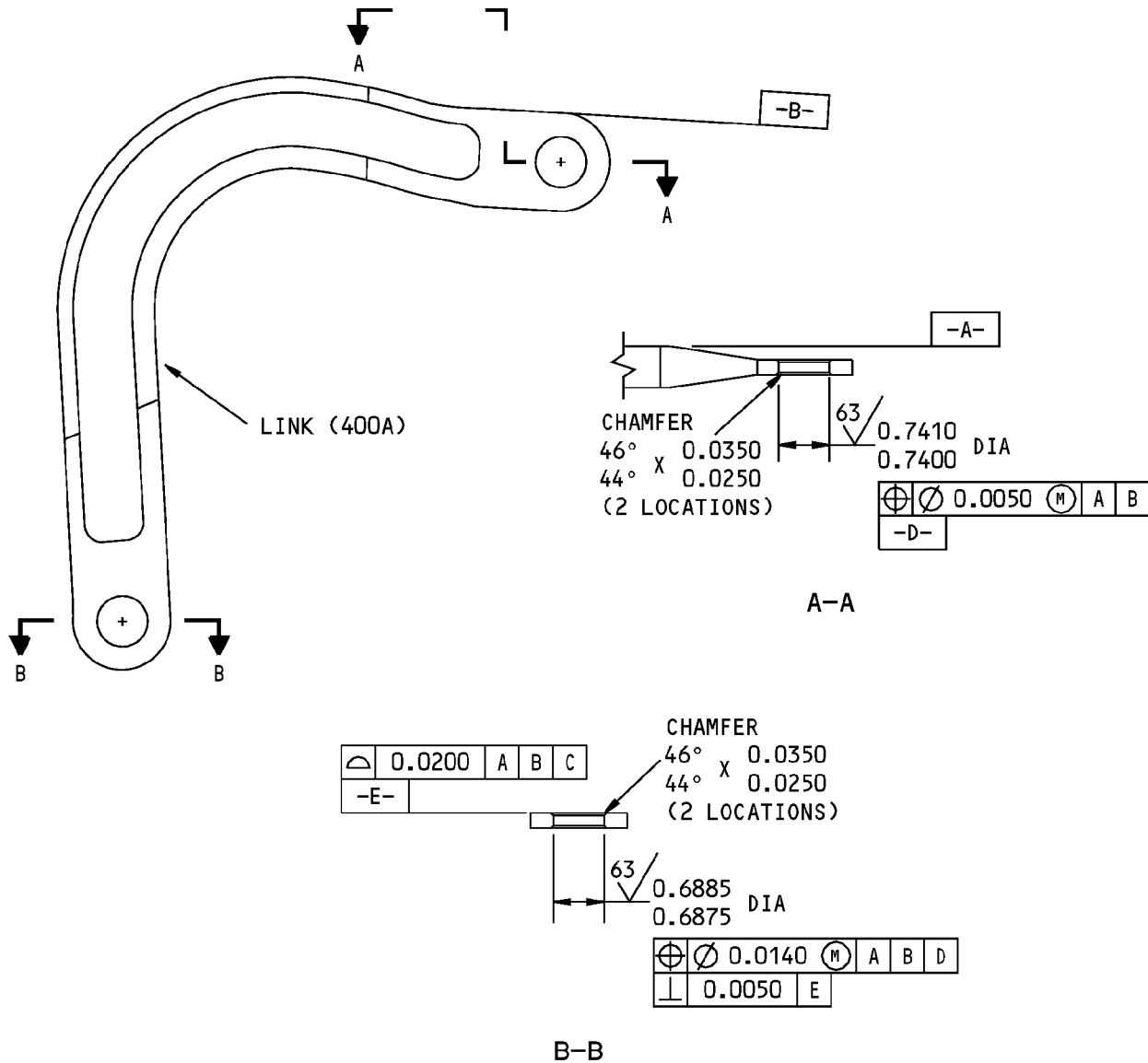
REPAIR 8-2

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## COMPONENT MAINTENANCE MANUAL



125/ ALL MACHINED SURFACES UNLESS  
SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

114A1424-7,-8 Link Repair  
Figure 602

**57-56-44**

REPAIR 8-2

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## COMPONENT MAINTENANCE MANUAL

### BELLCRANK ASSEMBLY - REPAIR 9-1

114A1413-1

#### 1. General

- A. This procedure has the data necessary to repair and refinish the bellcrank assembly (340).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for item numbers.

#### 2. Bushing Replacement

- A. Consumable Materials

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

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

- B. References

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

- C. Procedure

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

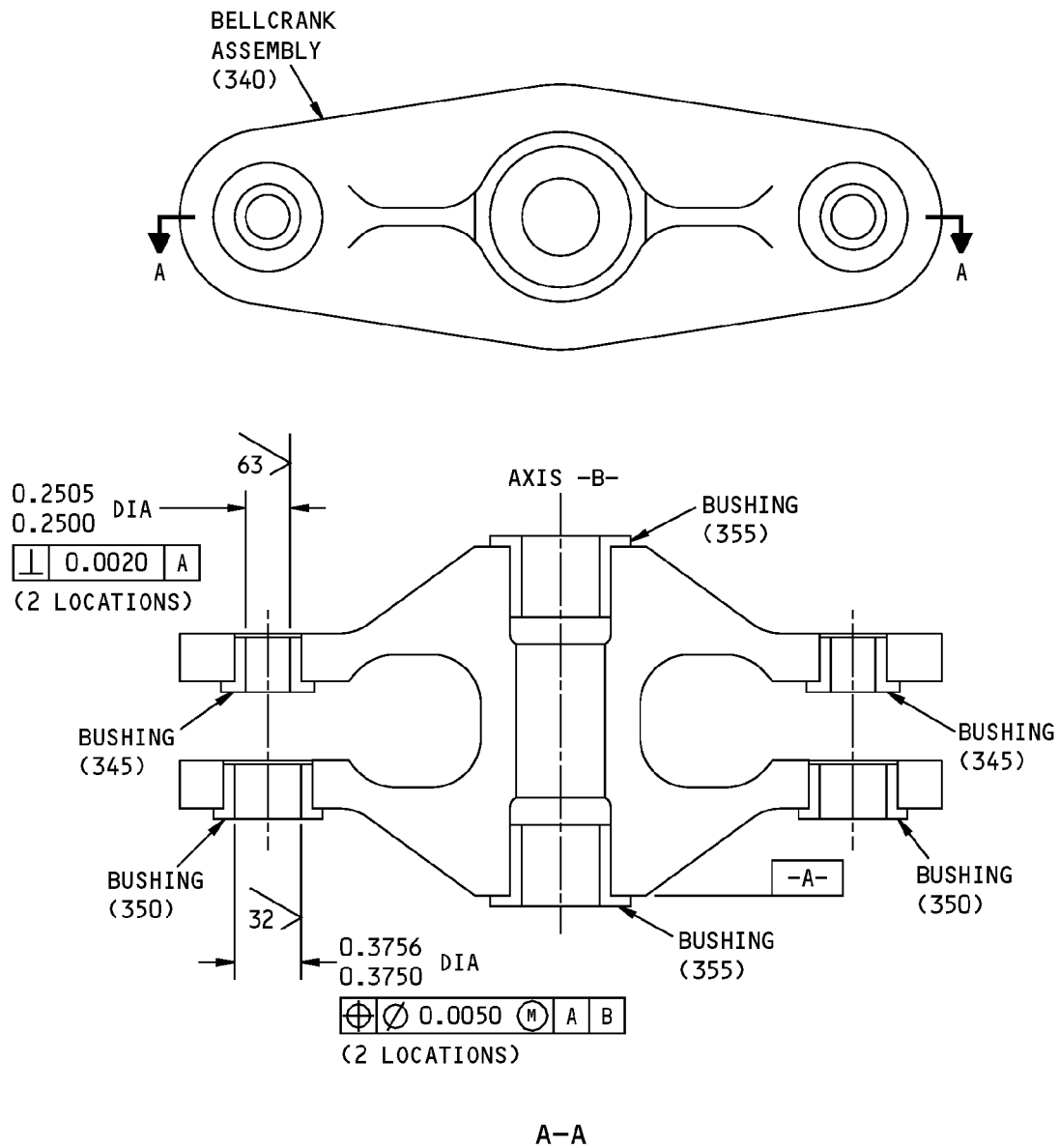
- (1) Remove the bushing (345, 350, 355) from the bellcrank (360).
- (2) Install the new bushing (355) on the bellcrank (360) with primer, C00259. Use the shrink fit method (SOPM 20-50-03).
- (3) Install the new bushing (345, 350) on the bellcrank (360) with sealant, A00247. Use the shrink fit method (SOPM 20-50-03).
- (4) Ream the inside diameter of the bushing (345, 350) to the dimensions shown in REPAIR 9-1, Figure 601).
- (5) Break all sharp edges.

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REPAIR 9-1  
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# COMPONENT MAINTENANCE MANUAL



63/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

114A1413-1 Bellcrank Assembly Repair  
Figure 601

## 57-56-44

REPAIR 9-1

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## COMPONENT MAINTENANCE MANUAL

### BELLCRANK - REPAIR 9-2

114A1413-2

#### 1. General

- A. This procedure has the data necessary to repair and refinish the bellcrank (360).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for item numbers.
- E. General repair details:
  - (1) Material: 7050-T7451 Aluminum alloy

#### 2. Bellcrank Refinish

- A. Consumable Materials

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

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

- B. References

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

- C. Procedure

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

- (1) Boric acid - sulfuric acid anodize or chromic acid anodize (F-17.31).
- (2) Apply primer, C00175 (F-19.47) all over the bellcrank (360) but not in the bushing bores. Hand touch-up is allowed to have 100% coverage in bores.
- (3) Apply enamel coating, C00033 (F-19.39-707) all over but not in the bushing bores.

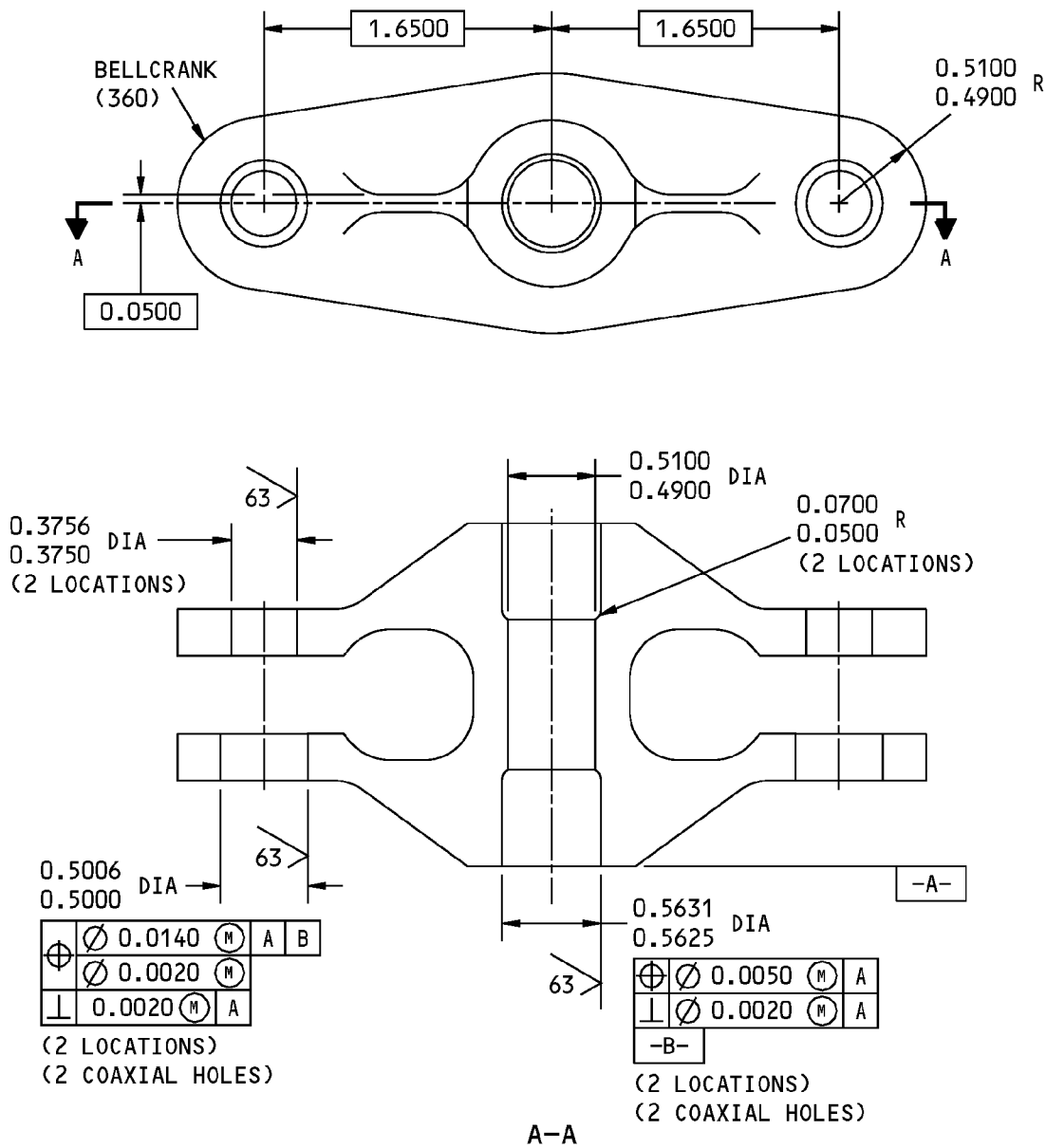
# 57-56-44

REPAIR 9-2

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## COMPONENT MAINTENANCE MANUAL



63/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

114A1413-2 Bellcrank Repair  
Figure 601

# 57-56-44

REPAIR 9-2

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## COMPONENT MAINTENANCE MANUAL

### MID BULLNOSE LINK ASSEMBLY - REPAIR 10-1

114A1420-3

#### 1. General

- A. This procedure has the data necessary to repair and refinish the mid bullnose link assembly (250A).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for item numbers.

#### 2. Bearing Replacement

- A. Procedure
  - (1) For repair of the rod assembly (295A), see the REPAIR 6-1.
  - (2) For repair of the link assembly (365), see the REPAIR 7-1 and REPAIR 7-2.

#### 3. Bushing Replacement

- A. Procedure
  - (1) For repair of the bellcrank assembly (340), see the REPAIR 9-1 and REPAIR 9-2.

#### 4. Assemble the Mid Bullnose Link Assembly

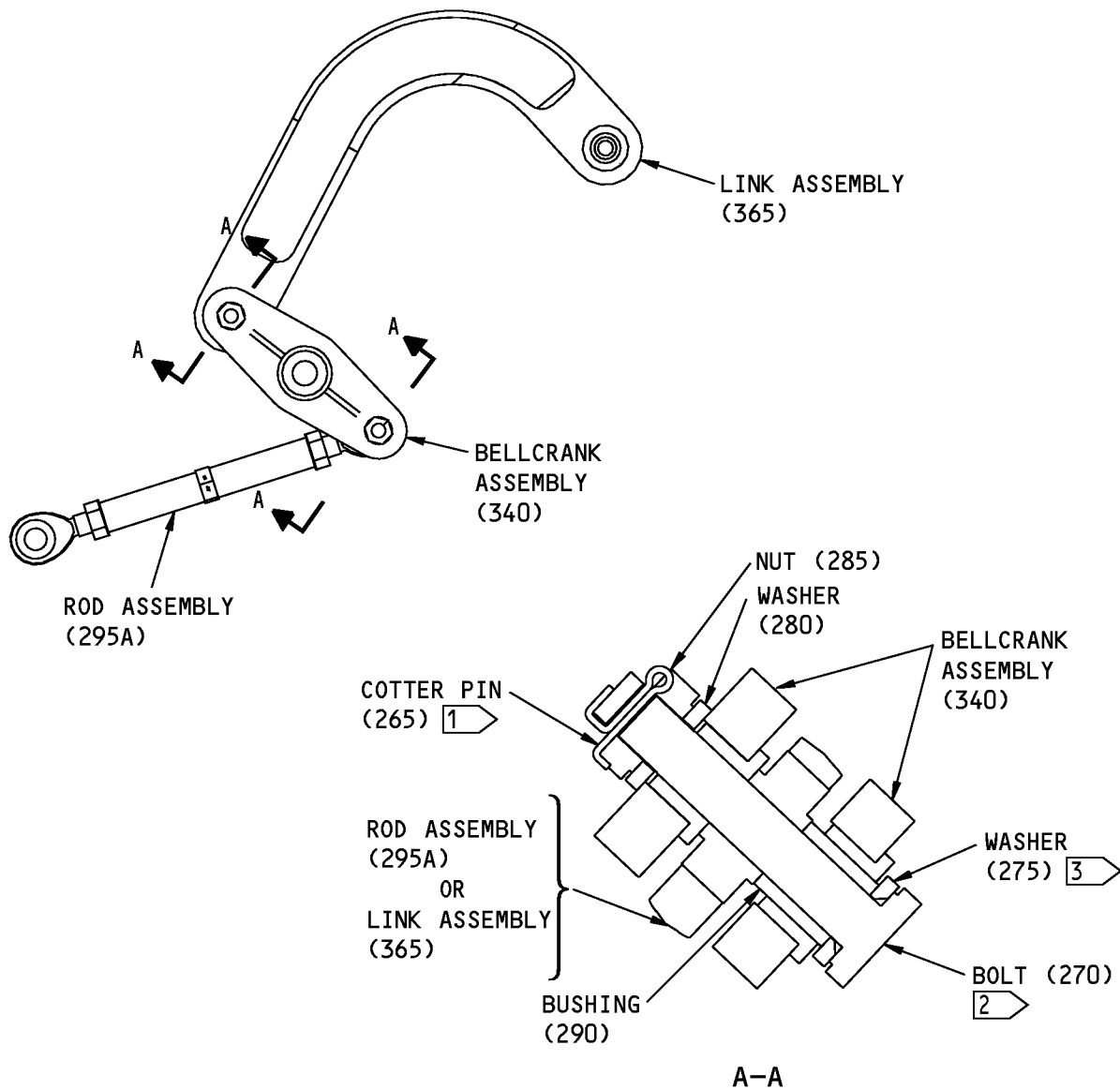
- A. Procedure
  - (1) Assemble the mid bullnose link assembly (250A).
    - (a) Assemble the rod assembly (295A), the bellcrank assembly (340) and the link assembly (365) together as shown in REPAIR 10-1, Figure 601.

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REPAIR 10-1  
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# COMPONENT MAINTENANCE MANUAL



- 1 INSTALL COTTER PIN PER (SOPM 20-50-02)
- 2 INSTALL BOLT WITH BMS 3-24 GREASE (F-19.16)
- 3 INSTALL CHAMFERED SIDE OF WASHER TOWARD HEAD OF BOLT

ITEM NUMBERS REFER TO IPL FIG. 1

114A1420-3 Mid Bullnose Link Assembly  
Figure 601

## 57-56-44

REPAIR 10-1  
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## COMPONENT MAINTENANCE MANUAL

### INBOARD BULLNOSE LINK ASSEMBLY - REPAIR 11-1

114A1430-3, -4, -5, -6

#### 1. General

- A. This procedure has the data necessary to repair and refinish the seal inboard bullnose link assembly (255A, 260A).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for item numbers.

#### 2. Bearing Replacement

- A. Procedure
  - (1) To repair the rod assembly (300A), See REPAIR 1-1.
  - (2) To repair the link assembly (370), See REPAIR 8-1 and REPAIR 8-2.

#### 3. Bushing Replacement

- A. Procedure
  - (1) To repair the bellcrank assembly (340), see REPAIR 9-1 and REPAIR 9-2.

#### 4. Assemble the Inboard Bullnose Link Assembly (255A, 260A).

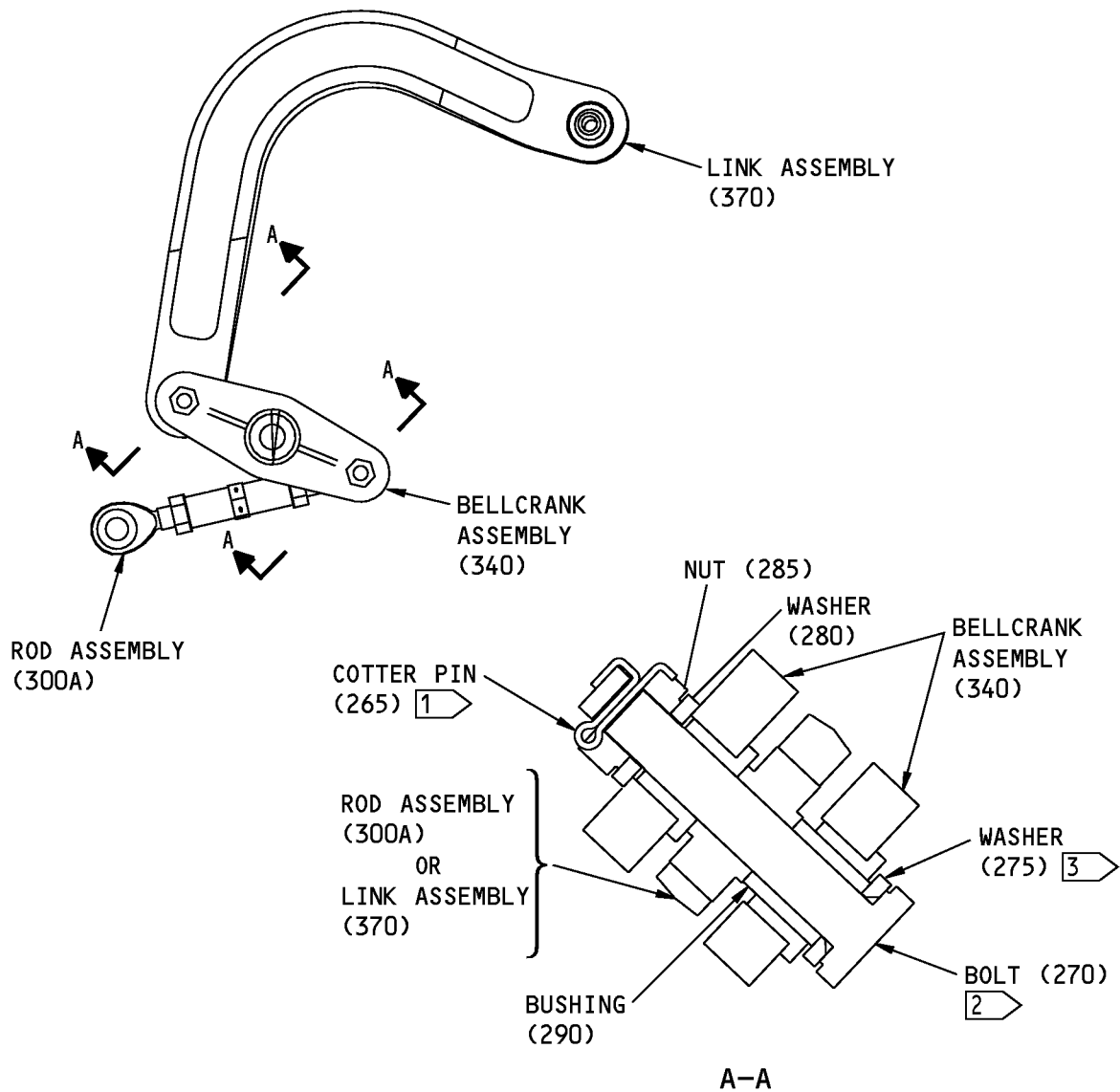
- A. Procedure
  - (1) Assemble the rod assembly (300A), the bellcrank assembly (340) and the link assembly (370) as shown in REPAIR 11-1, Figure 601.

**57-56-44**

REPAIR 11-1  
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# COMPONENT MAINTENANCE MANUAL



- 1 INSTALL COTTER PIN PER (SOPM 20-50-02)
- 2 INSTALL BOLT WITH BMS 3-24 GREASE (F-19.16)
- 3 INSTALL CHAMFERED SIDE OF WASHER TOWARD HEAD OF BOLT

ITEM NUMBERS REFER TO IPL FIG. 1

114A1430-3, -4, -5, -6 Inboard Bullnose Link Assembly  
Figure 601

## 57-56-44

REPAIR 11-1  
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## COMPONENT MAINTENANCE MANUAL

### NO. 5 FITTING ASSEMBLY - REPAIR 12-1

114A1725-1

#### 1. General

- A. This procedure has the data necessary to repair and refinish the No. 5 fitting assembly (90).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for item numbers.

#### 2. Bearing Replacement

- A. Consumable Materials

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

Reference	Description	Specification
D00015	Grease - Aircraft Bearing (Use BMS 3-24 until existing stocks are depleted, BMS 3-33 supersedes BMS 3-24)	BMS3-24 (Superseded by BMS 3-33)

- B. References

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

- C. Procedure

**NOTE:** For decoding table for Boeing finishes codes, refer to SOPM 20-41-01. For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Remove the bearing (95) from the fitting (100).
- (2) Install the new bearing (95) on the fitting (100) dry or with grease, D00015 and roller swage (SOPM 20-50-03).

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## COMPONENT MAINTENANCE MANUAL

### FITTING - REPAIR 12-2

114A1725-3

#### 1. General

- A. This procedure has the data necessary to repair and refinish the fitting (100).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for item numbers.
- E. General repair details:
  - (1) Material: TI-6AL-4V Titanium alloy

#### 2. Fitting Refinish

- A. Consumable Materials

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

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

- B. References

Reference	Title
SOPM 20-10-07	MACHINING OF TITANIUM
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

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

**NOTE:** For machining of titanium, refer to SOPM 20-10-07. For stripping of protective finishes, refer to SOPM 20-30-02. For decoding table for Boeing finishes codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) On the inside surfaces of the clevis area of the fitting (100): abrasive clean (F-14.882) and do the next step within 4 hours.
- (2) On the inside surfaces of the clevis area: apply primer, C00259 (F-20.02).

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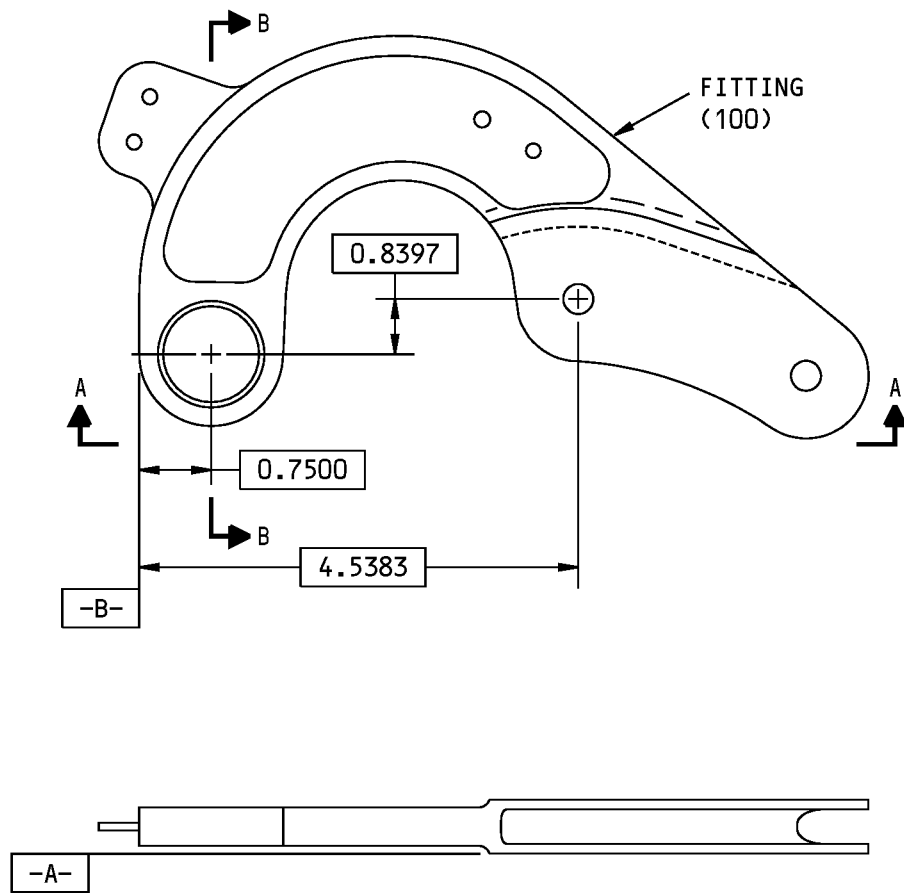
REPAIR 12-2

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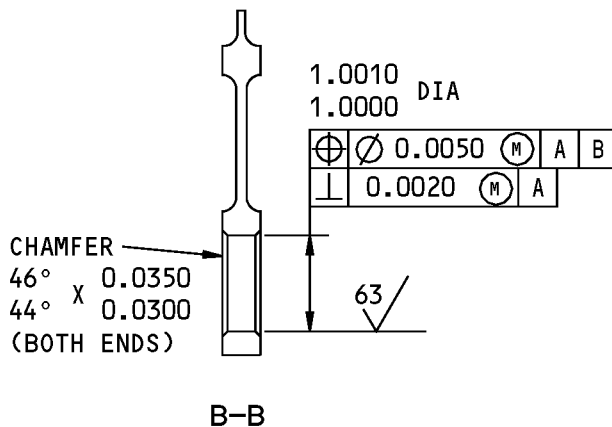
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# COMPONENT MAINTENANCE MANUAL



A-A



125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

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

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

114A1725-3 Fitting Repair  
Figure 601

## 57-56-44

REPAIR 12-2

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## COMPONENT MAINTENANCE MANUAL

### NO. 6 FITTING ASSEMBLY - REPAIR 13-1

114A1726-1, -5

#### 1. General

- A. This procedure has the data necessary to repair and refinish the No. 6 fitting assembly (150).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for item numbers.

#### 2. Bearing Replacement

- A. Consumable Materials

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

Reference	Description	Specification
D00015	Grease - Aircraft Bearing (Use BMS 3-24 until existing stocks are depleted, BMS 3-33 supersedes BMS 3-24)	BMS3-24 (Superseded by BMS 3-33)

- B. References

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

- C. Procedure

**NOTE:** For decoding table for Boeing finishes codes, refer to SOPM 20-41-01. For lubricants, refer to SOPM 20-60-03. For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Remove the bearing (160) from the fitting (165).
- (2) Install the new bearing (160) on the fitting (165) dry or with grease, D00015 and roller swage (SOPM 20-50-03).

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## COMPONENT MAINTENANCE MANUAL

### FITTING - REPAIR 13-2

114A1726-3, -7

#### 1. General

- A. This procedure has the data necessary to repair and refinish the fitting (165).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for item numbers.
- E. General repair details:
  - (1) Material: TI-6AL-4V Titanium alloy

#### 2. Fitting Refinish

- A. Consumable Materials

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

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

- B. References

Reference	Title
SOPM 20-10-07	MACHINING OF TITANIUM
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

- C. Procedure (REPAIR 13-2, Figure 601)

**NOTE:** For machining of titanium, refer to SOPM 20-10-07. For stripping of protective finishes, refer to SOPM 20-30-02. For decoding table for Boeing finishes codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Abrasive clean (F-14.882) the inside surfaces of the clevis/forks areas of the fitting (165). Do the next step within 4 hours.
- (2) Apply one coat of primer, C00259 (F-20.02) on the inside surfaces of the clevis/forks areas of the fitting (165).

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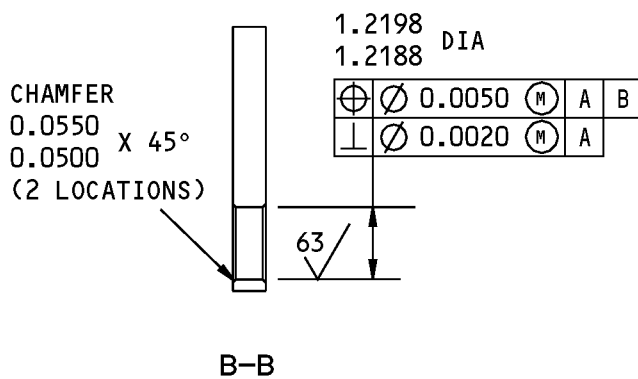
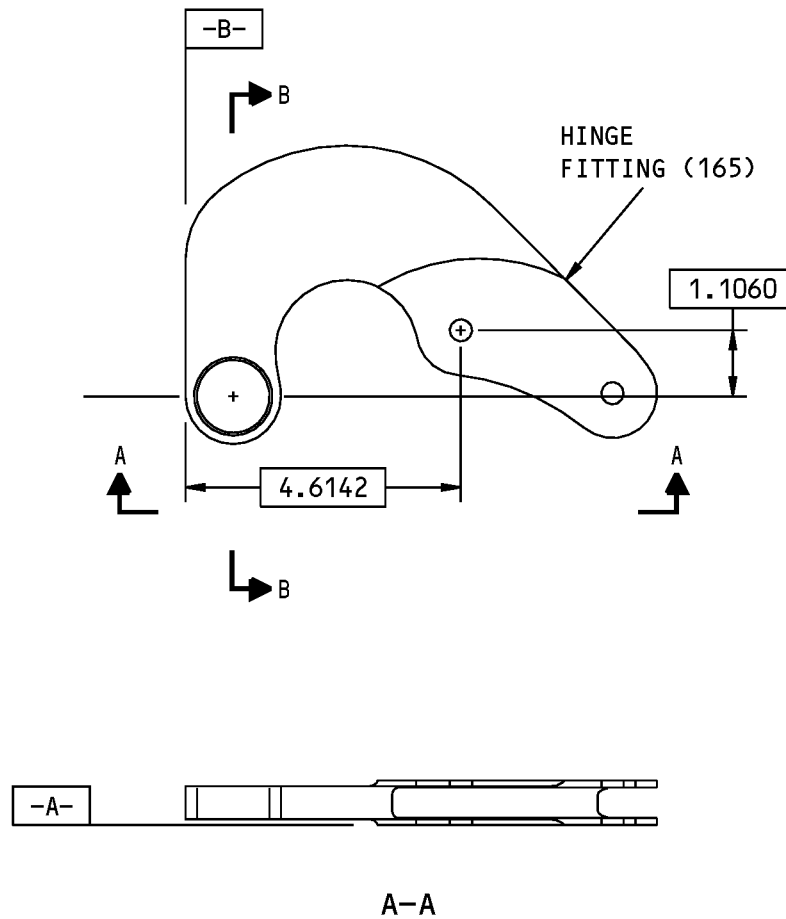
REPAIR 13-2

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# COMPONENT MAINTENANCE MANUAL



125 ✓ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

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

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

114A1726-3,-7 Hinge Fitting Repair  
Figure 601

## 57-56-44

REPAIR 13-2

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## COMPONENT MAINTENANCE MANUAL

### NO. 7 FITTING ASSEMBLY - REPAIR 14-1

114A1727-1

#### 1. General

- A. This procedure has the data necessary to repair and refinish the No. 7 fitting assemblies (155).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for item numbers.

#### 2. Bearing Replacement

- A. Consumable Materials

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

Reference	Description	Specification
D00015	Grease - Aircraft Bearing (Use BMS 3-24 until existing stocks are depleted, BMS 3-33 supersedes BMS 3-24)	BMS3-24 (Superseded by BMS 3-33)

- B. References

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

- C. Procedure

**NOTE:** For decoding table for Boeing finishes codes, refer to SOPM 20-41-01. For lubricants, refer to SOPM 20-60-03. For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Remove the bearing (160) from the fitting (170).
- (2) Install the new bearings (160) on the fitting (170) dry or with grease, D00015 and roller swage (SOPM 20-50-03).

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## COMPONENT MAINTENANCE MANUAL

### FITTING - REPAIR 14-2

114A1727-3

#### 1. General

- A. This procedure has the data necessary to repair and refinish the fitting (170).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for item numbers.
- E. General repair details:
  - (1) Material: TI-6AL-4V Titanium alloy

#### 2. Rod Refinish

- A. Consumable Materials

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

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

- B. References

Reference	Title
SOPM 20-10-07	MACHINING OF TITANIUM
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

- C. Procedure

**NOTE:** For machining of titanium, refer to SOPM 20-10-07. For stripping of protective finishes, refer to SOPM 20-30-02. For decoding table for Boeing finishes codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Abrasive clean (F-14.882) the inside surfaces of the clevis/forks areas of the fitting (170). Do the next step withing 4 hours.
- (2) Apply primer, C00259 (F-20.02) on the inside surfaces of the clevis/forks areas of the fitting (170).

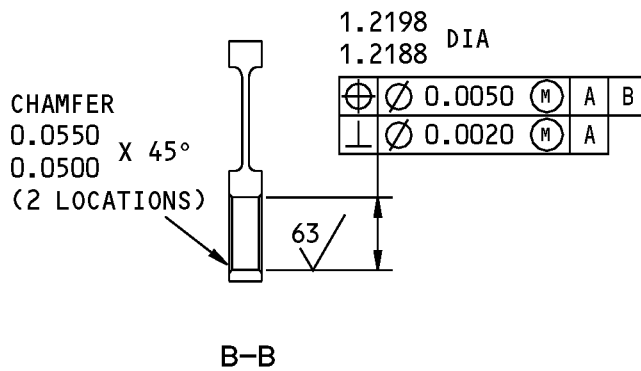
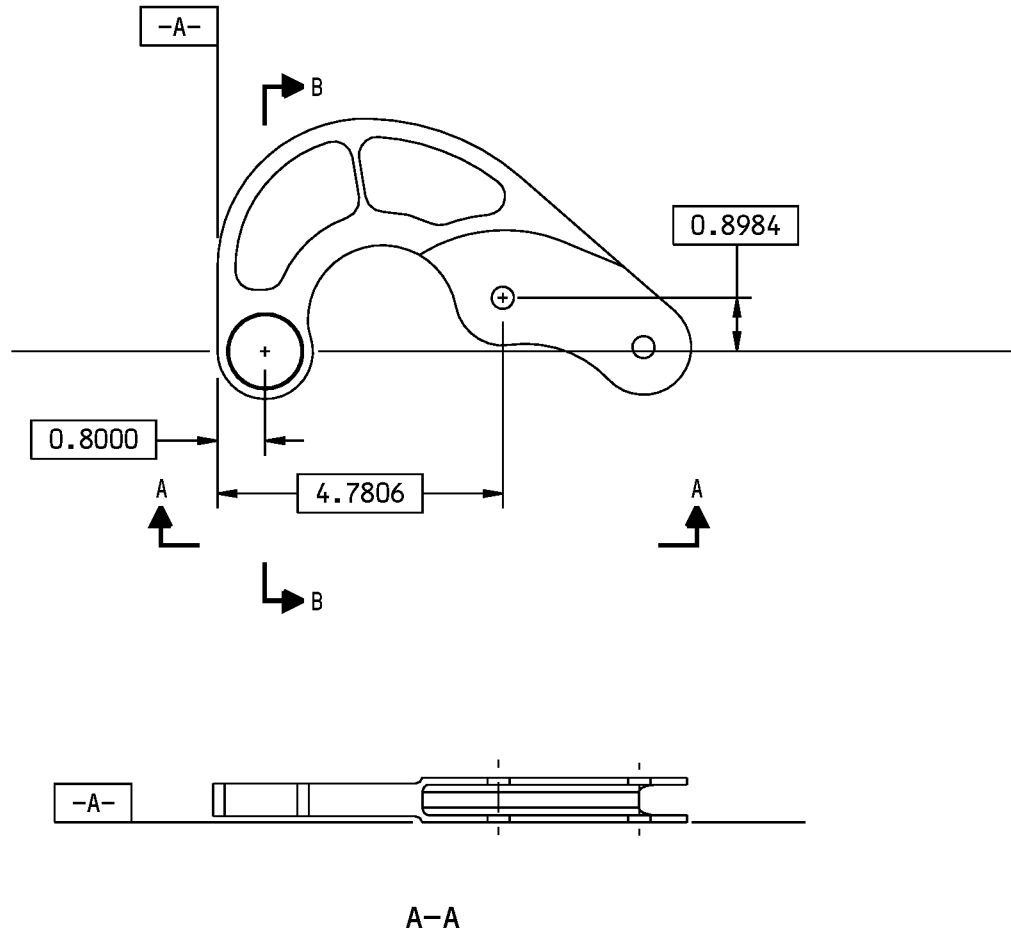
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# COMPONENT MAINTENANCE MANUAL



125 ✓ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

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

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

114A1727-3 Hinge Fitting Repair  
Figure 601

## 57-56-44

REPAIR 14-2

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## COMPONENT MAINTENANCE MANUAL

### NO. 8 FITTING ASSEMBLY - REPAIR 15-1

114A1728-1

#### 1. General

- A. This procedure has the data necessary to repair and refinish the No. 8 fitting assembly (105).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for item numbers.

#### 2. Bearing Replacement

- A. Consumable Materials

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

Reference	Description	Specification
D00015	Grease - Aircraft Bearing (Use BMS 3-24 until existing stocks are depleted, BMS 3-33 supersedes BMS 3-24)	BMS3-24 (Superseded by BMS 3-33)

- B. References

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

- C. Procedure

**NOTE:** For decoding table for Boeing finishes codes, refer to SOPM 20-41-01. For lubricants, refer to SOPM 20-60-03. For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Remove the bearing (110) from the fitting (115).
- (2) Install the new bearing (110) on the fitting (115) dry or with grease, D00015 and roller swage (SOPM 20-50-03).

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## COMPONENT MAINTENANCE MANUAL

### FITTING - REPAIR 15-2

114A1728-3

#### 1. General

- A. This procedure has the data necessary to repair and refinish the hinge fitting (115).
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for item numbers.
- E. General repair details:
  - (1) Material: TI-6AL-4V Titanium alloy

#### 2. Fitting Refinish

- A. Consumable Materials

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

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

- B. References

Reference	Title
SOPM 20-10-07	MACHINING OF TITANIUM
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

- C. Procedure (REPAIR 15-2, Figure 601)

**NOTE:** For machining of titanium, refer to SOPM 20-10-07. For stripping of protective finishes, refer to SOPM 20-30-02. For decoding table for Boeing finishes codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Abrasive clean (F-14.882) the inside surfaces of the clevis/forks areas of the fitting (115). Do the next step withing 4 hours.
- (2) Apply primer, C00259 (F-20.02) on the inside surfaces of the clevis/forks areas of the fitting (115).

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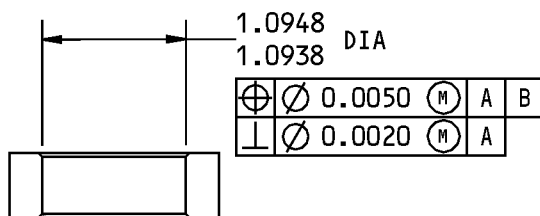
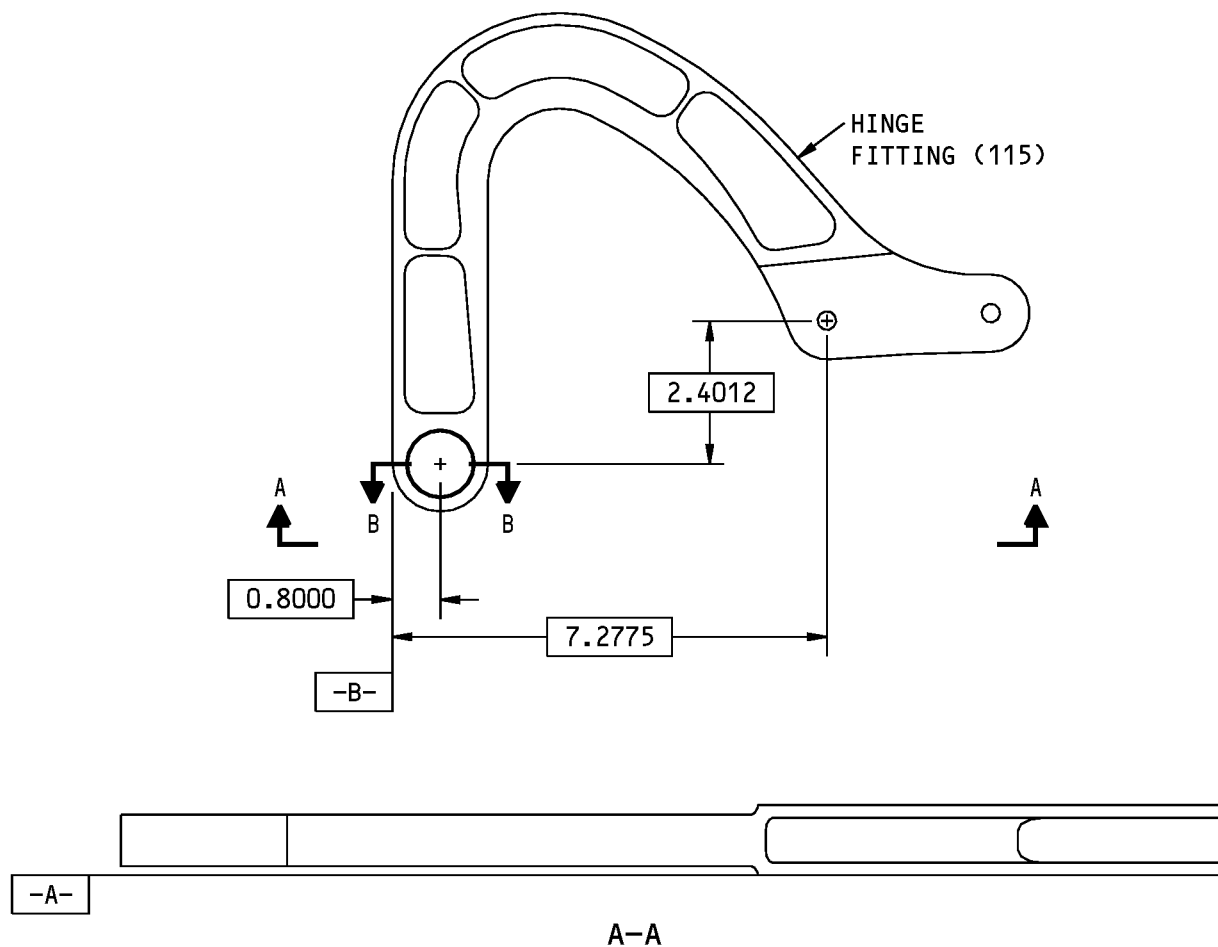
REPAIR 15-2

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# COMPONENT MAINTENANCE MANUAL



CHAMFER  
0.0350  
0.0300 X 45°  
(2 LOCATIONS)

B-B

125 ✓ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

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

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

114A1728-3 Hinge Fitting Repair  
Figure 601

## 57-56-44

REPAIR 15-2

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## COMPONENT MAINTENANCE MANUAL

### ASSEMBLY

#### 1. General

- A. This procedure has the data necessary to assemble the No. 2 and 3 Krueger flap and bullnose assembly.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Item numbers refer to IPL Figure 1 unless noted differently.

#### 2. Assembly

##### A. References

Reference	Title
SOPM 20-50-01	BOLT AND NUT INSTALLATION
SOPM 20-50-02	INSTALLATION OF SAFETYING DEVICES
SOPM 20-60-04	MISCELLANEOUS MATERIALS

##### B. Procedure

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

- (1) Use standard industry procedures and the steps shown below to assemble this component.
- (2) Install the clevis assemblies (455) onto the inboard Krueger flap assembly (610) with the bolts (440), the washers (445), the shims (475) and the nuts (450), as shown in ASSEMBLY, Figure 701 and as follows.
  - (a) Install the bolts (440), the washers (445) and the nuts (450) with BMS 5-95 sealant (F-19.48).
  - (b) Refer to ASSEMBLY, Figure 701 for shim (475) instructions.
  - (c) Tighten the nuts (450) to 50-70 pound-inches.
- (3) Install the No. 5 hinge fitting assembly (25) onto the inboard Krueger flap assembly (610) with the bolts (10), the washers (15), the shims (120) and the nuts (20), as shown in ASSEMBLY, Figure 701 and as follows.
  - (a) Install the bolts (10), the washers (15) and the nuts (20) with BMS 5-95 sealant (F-19.48).
  - (b) Refer to ASSEMBLY, Figure 701 for shim (120) instructions.
  - (c) Tighten the nuts (20) to 90-125 pound-inches.
- (4) Install the No. 6 hinge fitting assembly (150) onto the inboard Krueger flap assembly (610) with the bolts (125), the washers (135), the shims (175) and the nuts (140) as shown in ASSEMBLY, Figure 701 and as follows.
  - (a) Install the bolts (125), the washers (135) and the nuts (140) with BMS 5-95 sealant.
  - (b) Refer to ASSEMBLY, Figure 701 for shim (175) instructions.
  - (c) Tighten the nut (140) to 150-200 pound-inches.
- (5) Install the No. 7 hinge fitting assembly (155) onto the inboard Krueger flap assembly (610) with the bolts (125, 130), the washers (135), the jumper (145), the shims (180) and the nuts (140) as shown in ASSEMBLY, Figure 701 and as follows.
  - (a) Install the bolts (125, 130), the washers (135) and the nuts (140) with BMS 5-95 sealant.

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ASSEMBLY

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## COMPONENT MAINTENANCE MANUAL

- 1) The jumper (145) is installed with the above parts: See the grounding instructions related to the jumper (145), shown by flagnote in ASSEMBLY, Figure 701.
- (b) Refer to ASSEMBLY, Figure 701 for shim (180) instructions.
- (c) Tighten the nut (140) to 150-200 pound-inches.
- (6) Install the No. 8 Hinge Fitting Assembly (105) onto the Inboard Krueger Flap Assembly (610) with the bolts (10), the washers (15), the shims (120) and the nuts (20) as shown in ASSEMBLY, Figure 701 and as follows.
  - (a) Install the bolts (10), the washers (15), and the nuts (20) with BMS 5-95 sealant.
  - (b) Refer to ASSEMBLY, Figure 701 for shim (120) instructions.
  - (c) Tighten the nuts (20) to 90-125 pound-inches.
- (7) Install the mid bullnose link assembly (250A) and Inboard Bullnose Link Assembly (255A, 260A) onto the Inboard Krueger Flap Assembly (610) as shown in ASSEMBLY, Figure 701 and as follows.
  - (a) Install the bellcrank assembly (340), part of the bullnose link assembly, onto the Krueger Flap Assembly.
    - 1) Install the bushing (240) as shown in ASSEMBLY, Figure 701.
    - 2) Install the bolt (195A, 200A), the washers (210, 220A) and the nut (230) with BMS 3-24 grease (F-19.16).
      - a) The jumper assembly (247, 248) is installed with the above parts: See the grounding instructions, related to the jumper assembly (247, 248), shown by flagnote in ASSEMBLY, Figure 701.
    - 3) Tighten the nut (230) to 90-125 pound-inches.
    - 4) Install the cotter pin (185) as shown in the (SOPM 20-50-02).
  - (b) Install the rod assembly (295A, 300A), part of the bullnose link assembly, onto the Krueger Flap Assembly.
    - 1) Install the bushing (245) as shown in ASSEMBLY, Figure 701.
    - 2) Install the bolt (205A), the washers (215, 225A), and the nut (235) with BMS 3-24 grease (F-19.16).
      - a) The jumper assembly (247, 248) is installed with the above parts: See the grounding instructions, related to the jumper assembly (247, 248), shown by flagnote in ASSEMBLY, Figure 701.
    - 3) Tighten the nut (235) to 30-50 pound-inches.
    - 4) Install the cotter pin (190) as shown in the (SOPM 20-50-02).
- (8) Install the mid Bullnose Assembly (555) and the Inboard Bullnose Assembly (565) onto the Krueger flap assembly (610) as shown in ASSEMBLY, Figure 701 and as follows.
  - (a) Install the bushing (435) as shown in ASSEMBLY, Figure 701.
  - (b) Install the mid bullnose assembly (555) onto the Krueger flap assembly (610) with the bolt (415), the washers (420, 425), and the nut (435) with BMS 3-24 grease (F-19.16).
  - (c) Tighten the nut (435) to 30-50 pound-inches.
  - (d) Install the cotter pin (410) as shown in the (SOPM 20-50-02).

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ASSEMBLY

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- (e) Make sure that the mid bullnose assembly (555) fits to the inboard Krueger flap assembly (610) as shown in ASSEMBLY, Figure 701.
- (9) Seal Installation
  - (a) Install the bulb seal (495) into the seal retainer (490).

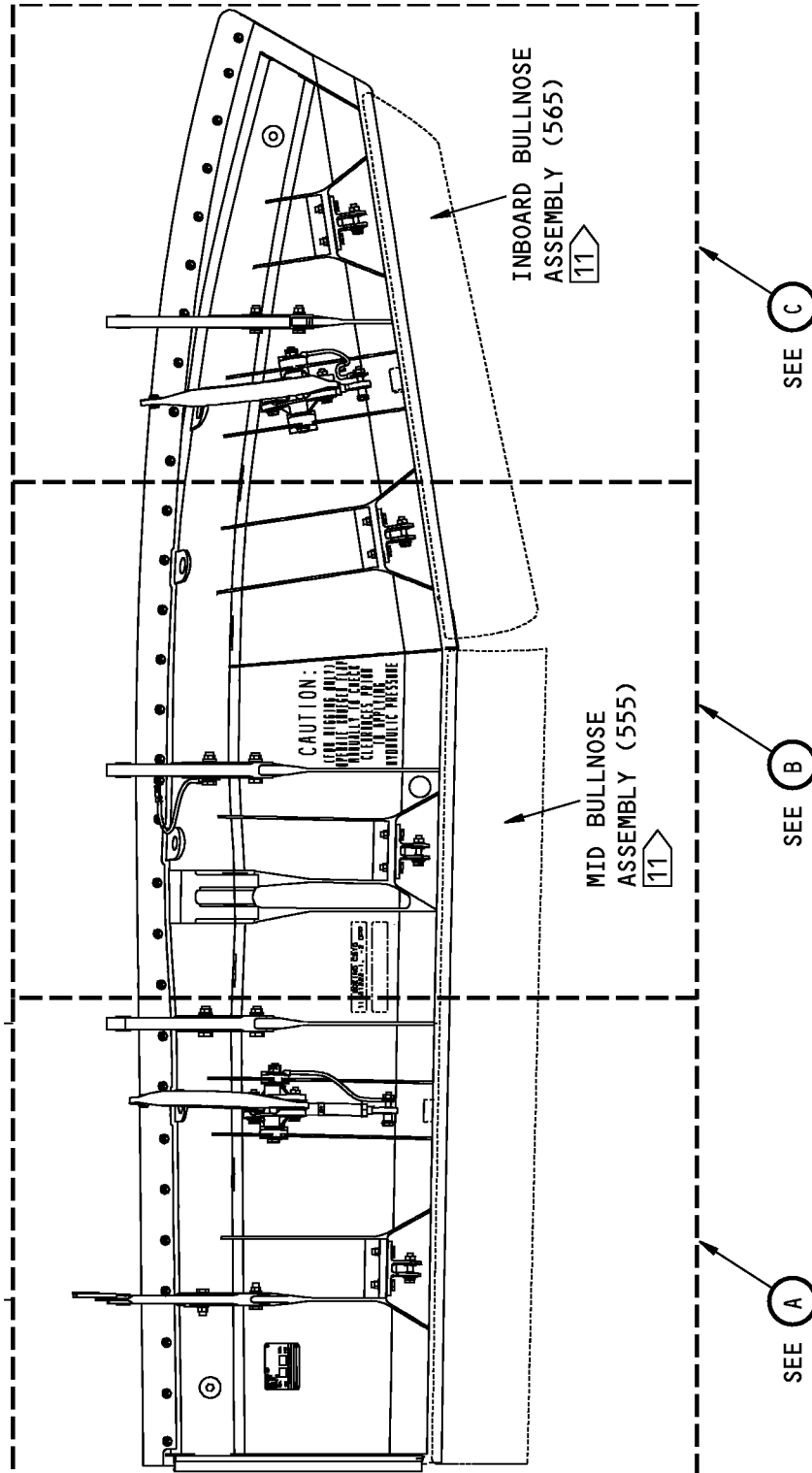
**NOTE:** The seal retainer is riveted onto the inboard Krueger flap assembly.

    - 1) Install a safety wire per (SOPM 20-50-02) to the seal (495) as shown in ASSEMBLY, Figure 701.
  - (b) Install the span wise seals (515, 525A) onto the inboard Krueger flap assembly (610) with the bolts (500), the washers (505) and the nuts (510).
    - 1) Install the bolts (500) with corrosion preventive compound MIL-C-11796 (F-19.11).
    - 2) Tighten the nuts (510) to 15-20 pound-inches.
- (10) Fit and Fair Instructions For No. 2 and No. 3 Krueger Flap and Bullnose Assembly.
  - (a) Install the bullnose (555) to the flap (610) by clamping, so that 80% firm contact exists between the bullnose and the flap and as shown in ASSEMBLY, Figure 701, view N-N. Make sure that the following conditions are met.
    - 1) For 114A1220-5, -7 max gap allowed is 0.015 inch, over a 4 inch max length.
    - 2) For 114A1220-9, -11 max gap allowed is 0.020 inch, over a 4 inch max length.
    - 3) Match OML contour surfaces MDS 276, 277 and 278 to +0.0200/-0.0100 for 114A1220-5, -7.
    - 4) Match OML contour surfaces MDS 276, 277 and 278 to +0.0300/-0.0100 for 114A1220-9, -11.
    - 5) While the bullnose (555) is in the clamped/firm contact condition, locate the bullnose clevis assembly (455) per the bullnose (555) lug and shim the gaps to within 0.005 inches; refer to shimming instructions in previous steps (max shim thickness allowed in 0.062 inches.).
    - 6) After the above instructions have been completed, rotate the bullnose (555) to ensure that no binding condition exists.
    - 7) After the above instructions have been completed, check the gap and misfair at the bullnose/flap interface, as provided for above, with a max force of 50 pounds on the center of the bullnose clevis (455). Force must be acting parallel to datum -A- within +/- 5 degrees.

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114A1220-5 thru -10, -201 thru -204 Krueger Flap and Bullnose Assembly  
Figure 701 (Sheet 1 of 15)

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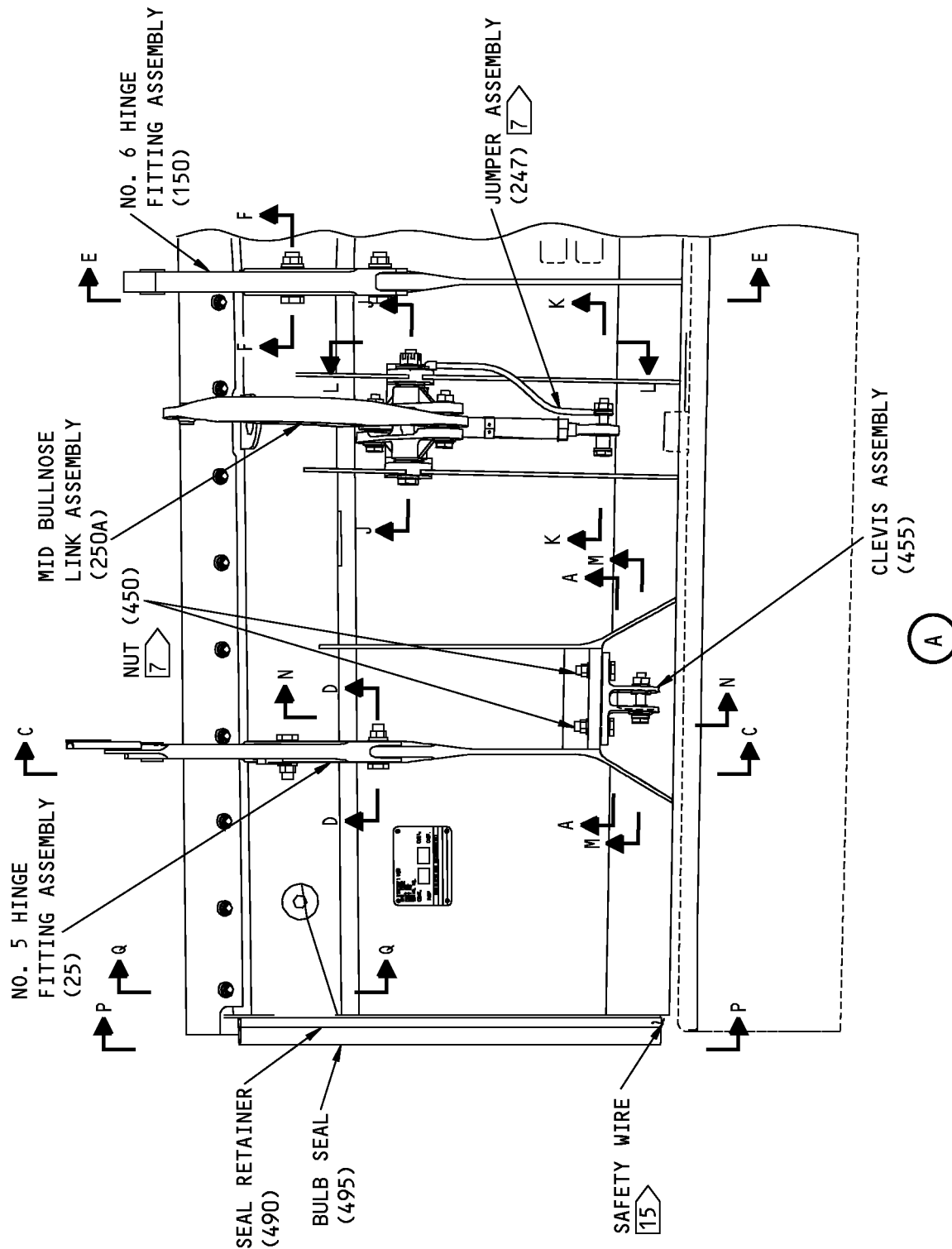
ASSEMBLY

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114A1220-5 thru -10, -201 thru -204 Krueger Flap and Bullnose Assembly  
Figure 701 (Sheet 2 of 15)

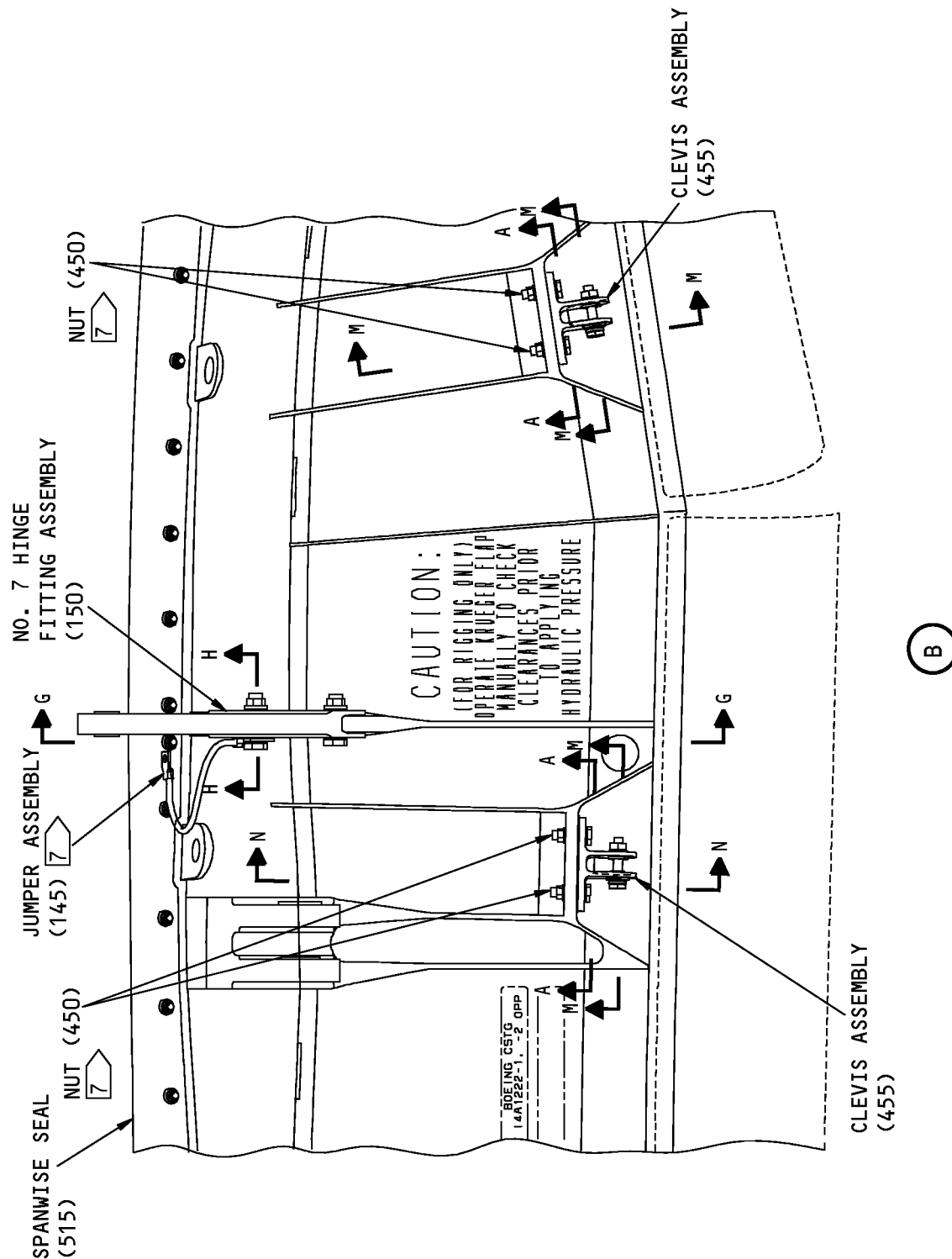
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ASSEMBLY

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114A1220-5 thru -10, -201 thru -204 Krueger Flap and Bullnose Assembly  
Figure 701 (Sheet 3 of 15)

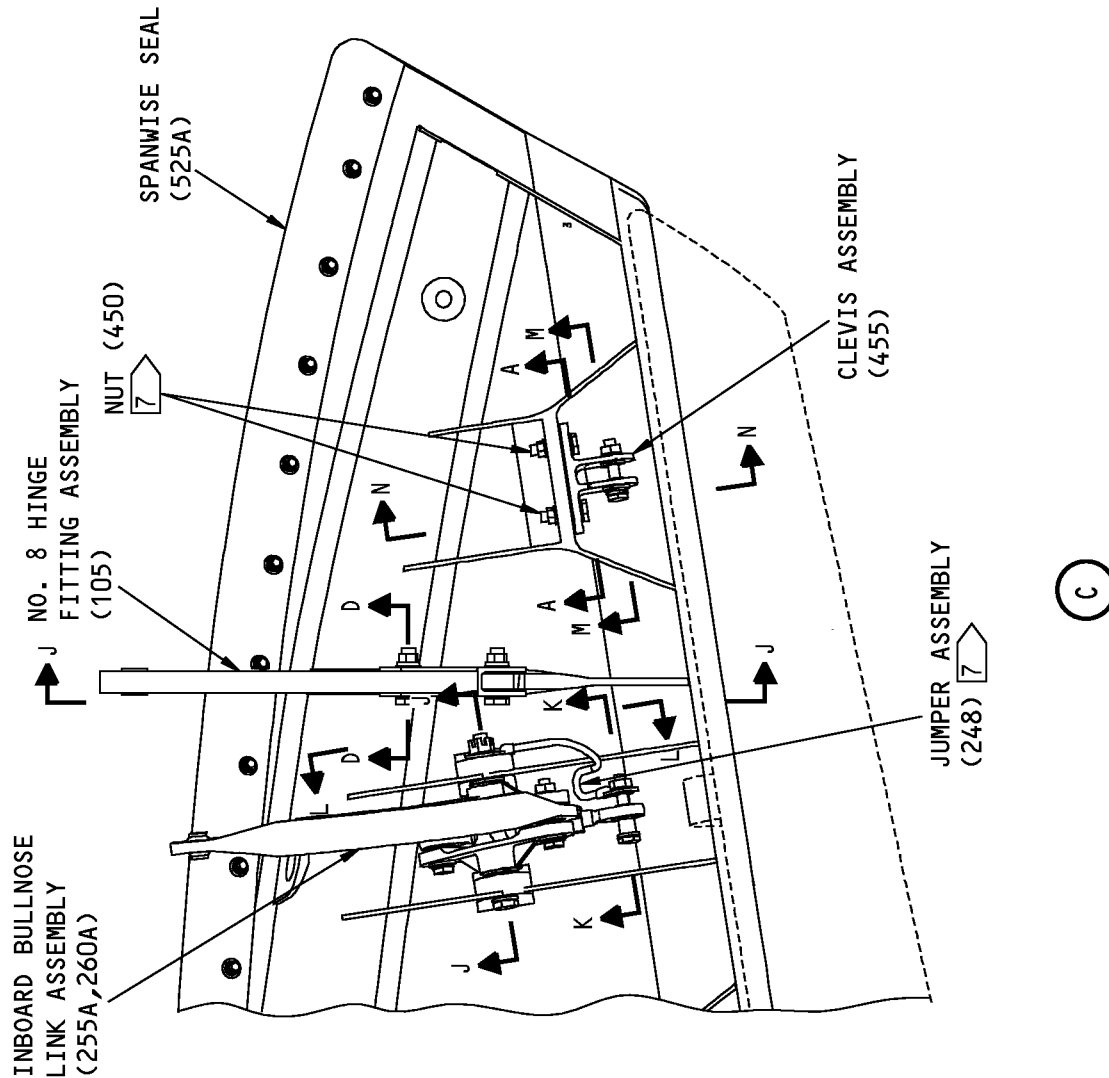
## 57-56-44

ASSEMBLY

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114A1220-5 thru -10, -201 thru -204 Krueger Flap and Bullnose Assembly  
Figure 701 (Sheet 4 of 15)

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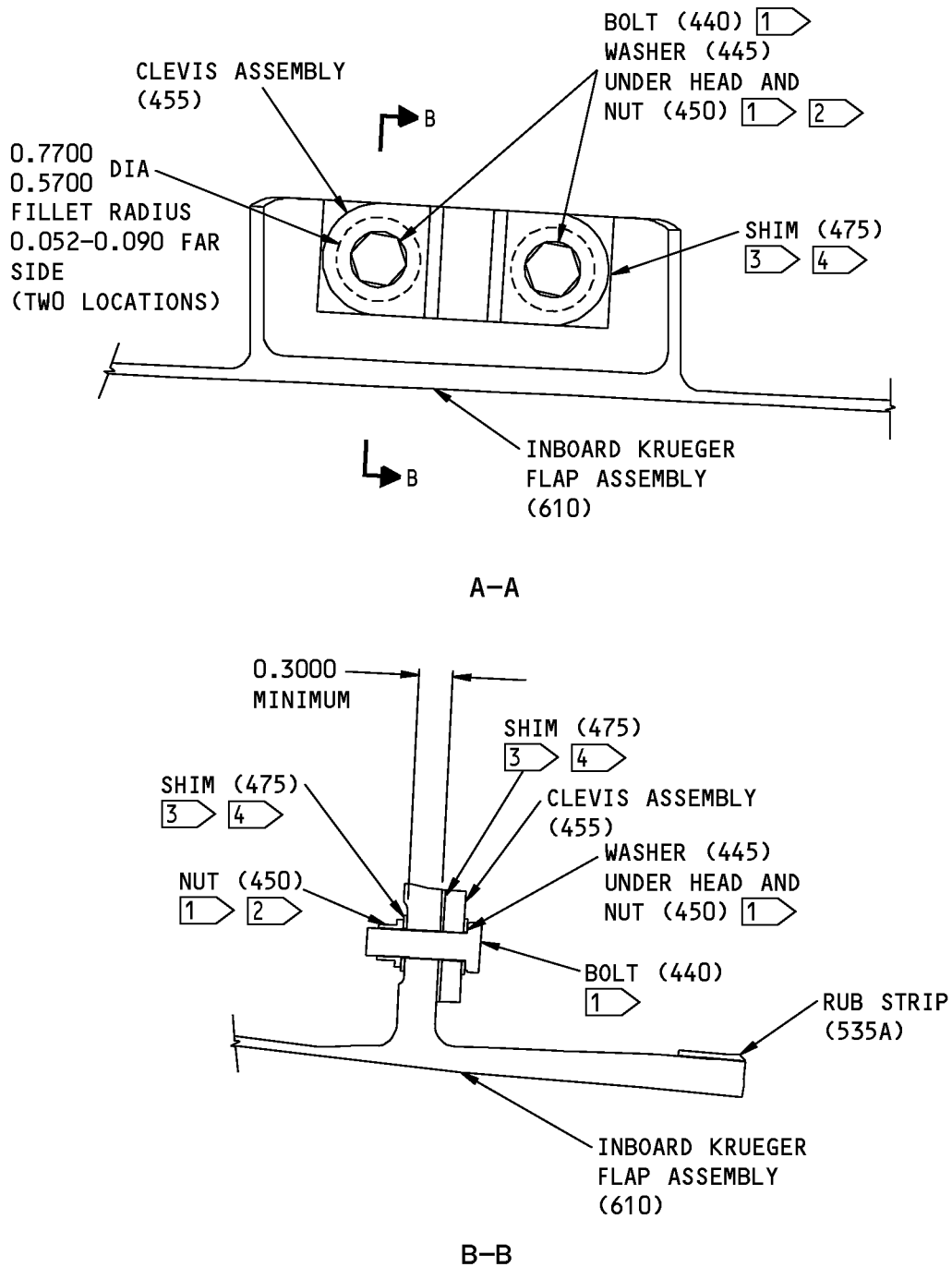
ASSEMBLY

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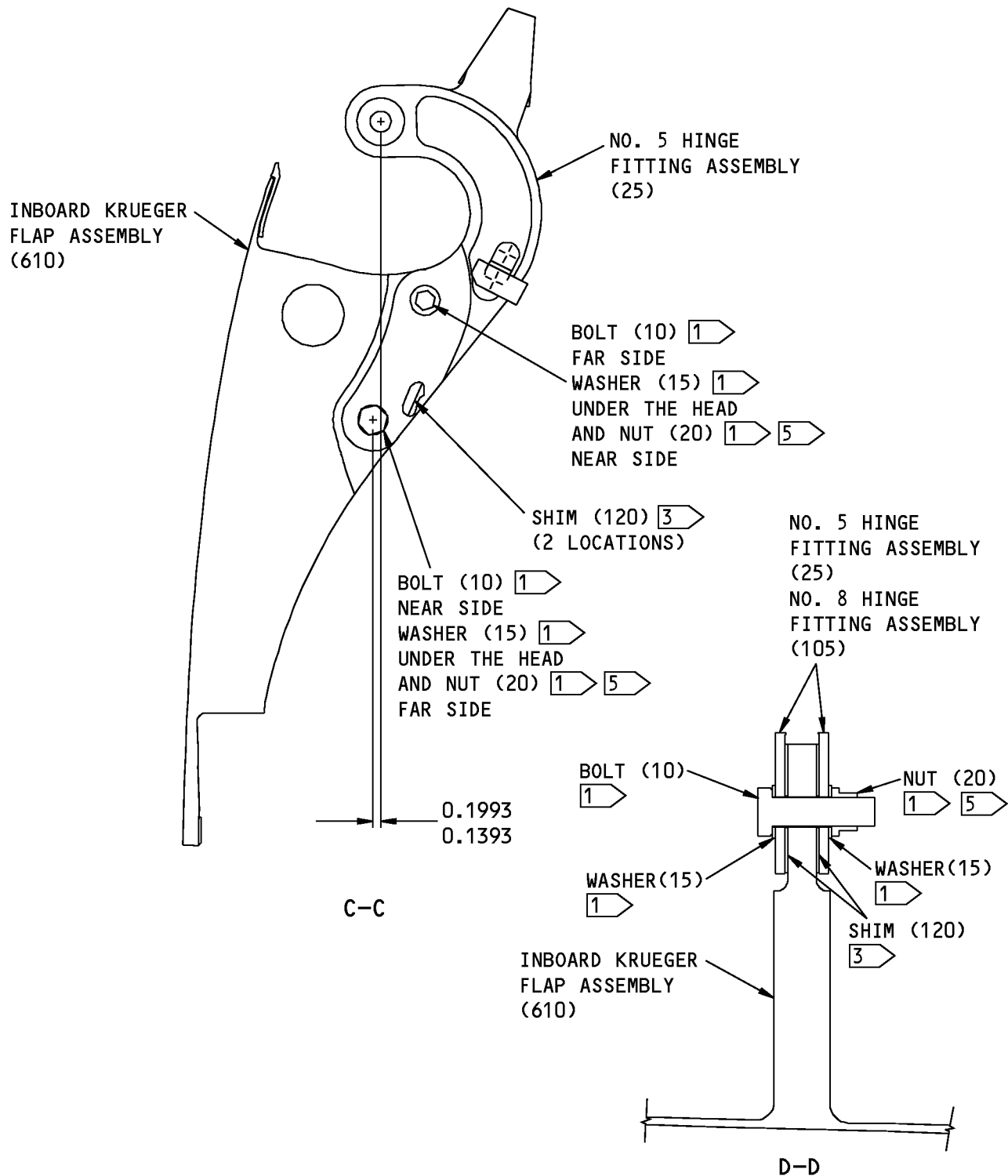
# COMPONENT MAINTENANCE MANUAL



114A1220-5 thru -10, -201 thru -204 Krueger Flap and Bullnose Assembly  
Figure 701 (Sheet 5 of 15)

## 57-56-44

ASSEMBLY  
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**COMPONENT MAINTENANCE MANUAL**

114A1220-5 thru -10, -201 thru -204 Krueger Flap and Bullnose Assembly  
Figure 701 (Sheet 6 of 15)

# 57-56-44

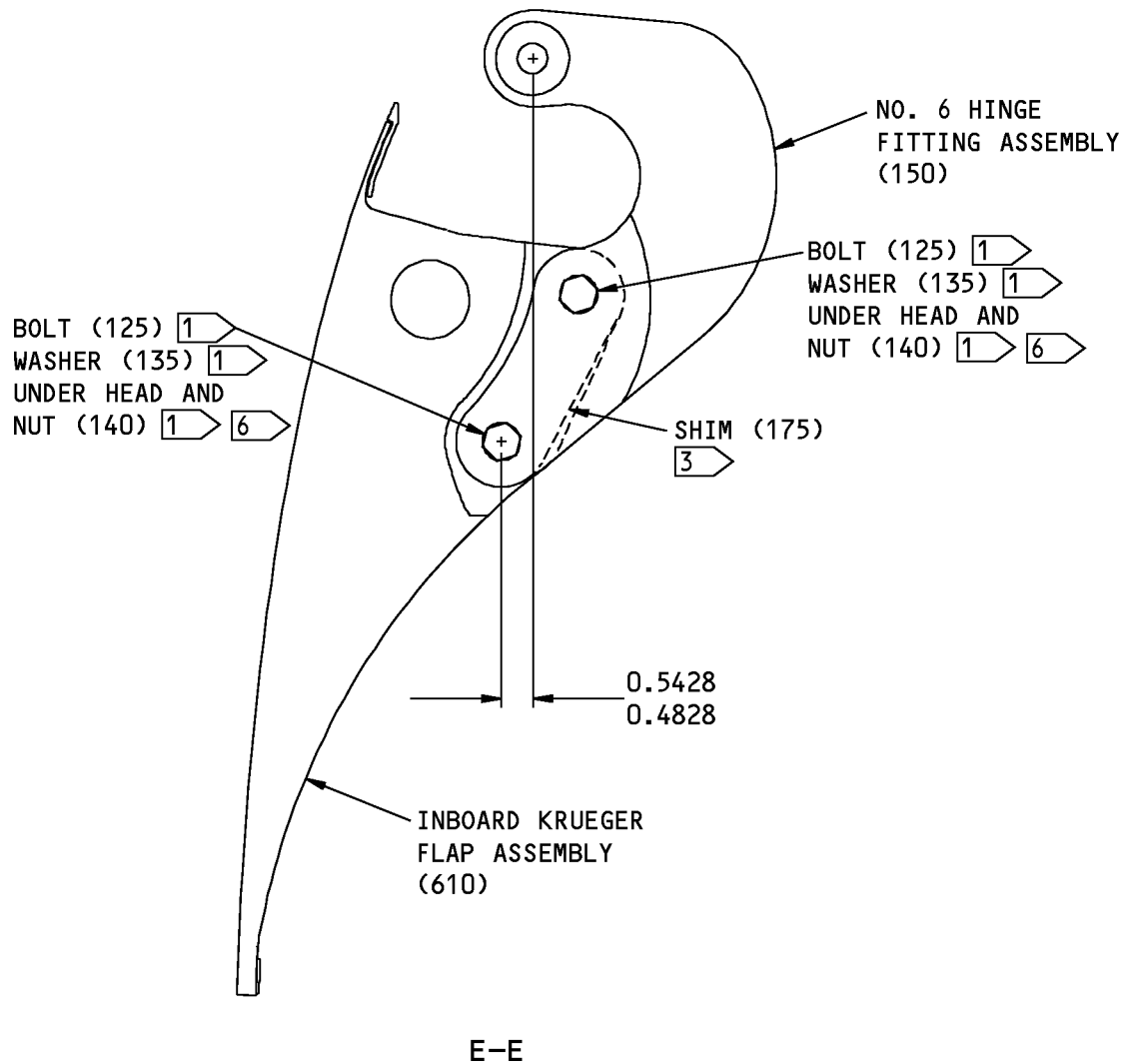
ASSEMBLY

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## COMPONENT MAINTENANCE MANUAL



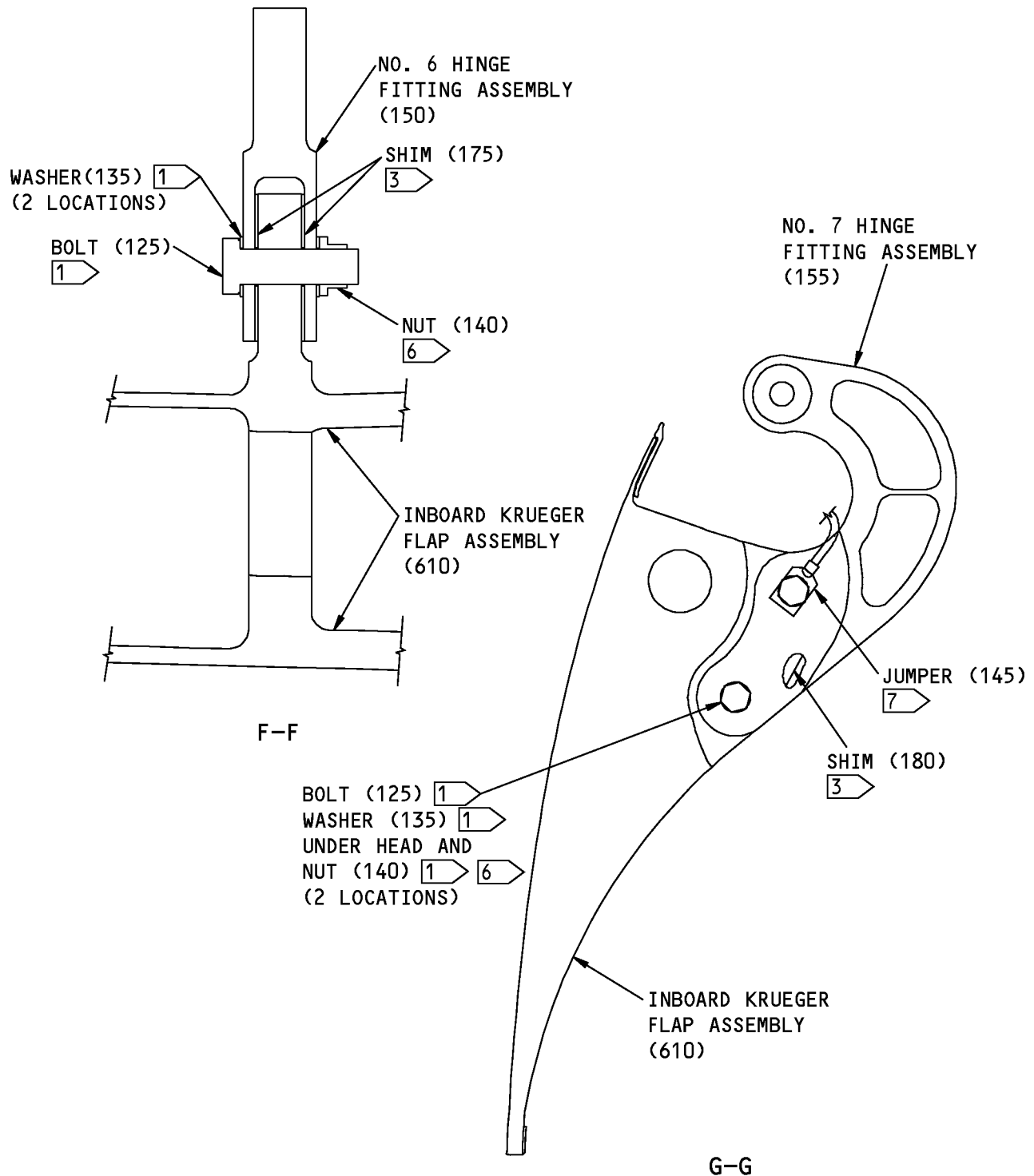
114A1220-5 thru -10, -201 thru -204 Krueger Flap and Bullnose Assembly  
Figure 701 (Sheet 7 of 15)

**57-56-44**

ASSEMBLY

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**COMPONENT MAINTENANCE MANUAL**

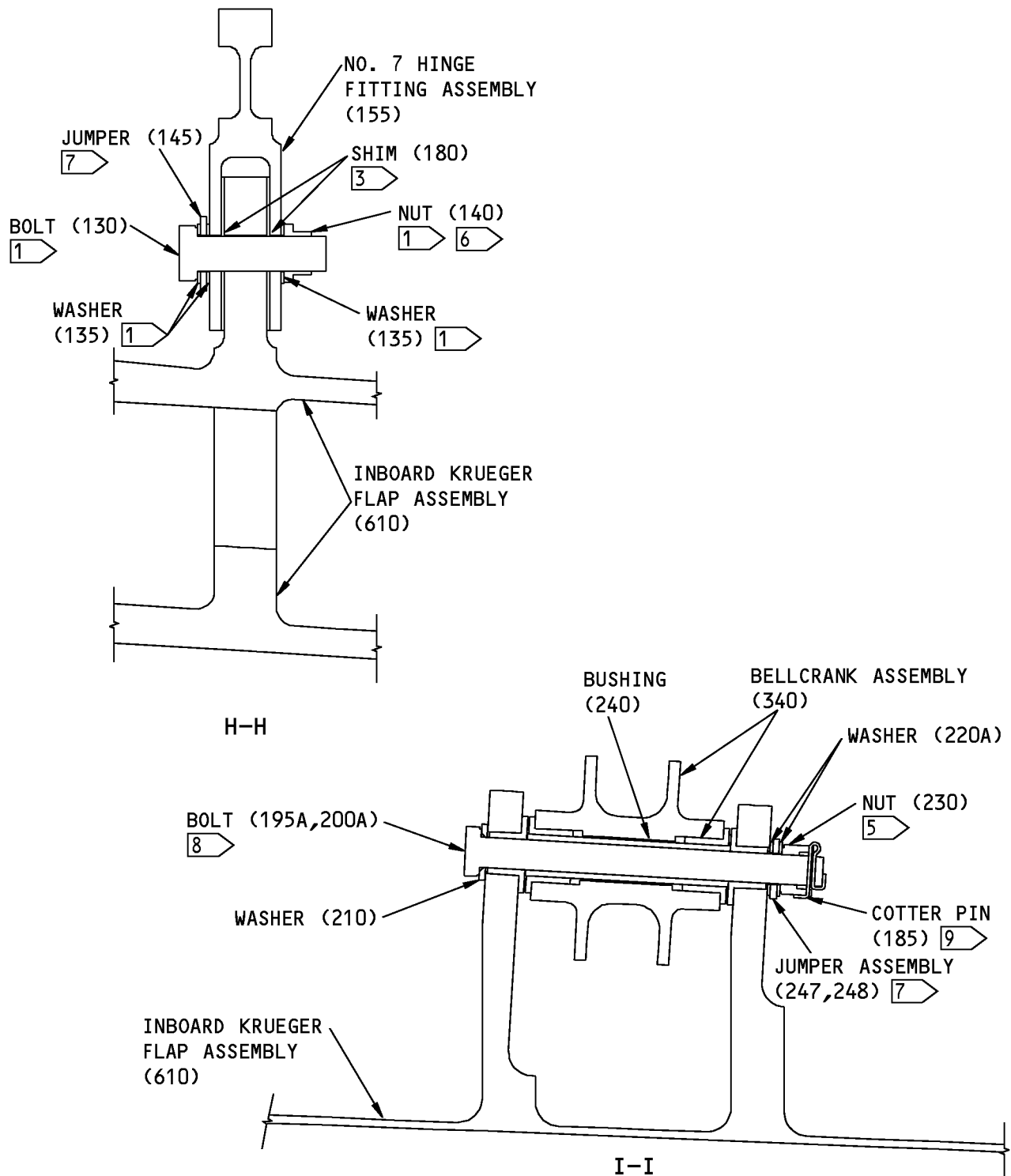
114A1220-5 thru -10, -201 thru -204 Krueger Flap and Bullnose Assembly  
Figure 701 (Sheet 8 of 15)

# 57-56-44

ASSEMBLY

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**COMPONENT MAINTENANCE MANUAL**

114A1220-5 thru -10, -201 thru -204 Krueger Flap and Bullnose Assembly  
Figure 701 (Sheet 9 of 15)

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ASSEMBLY

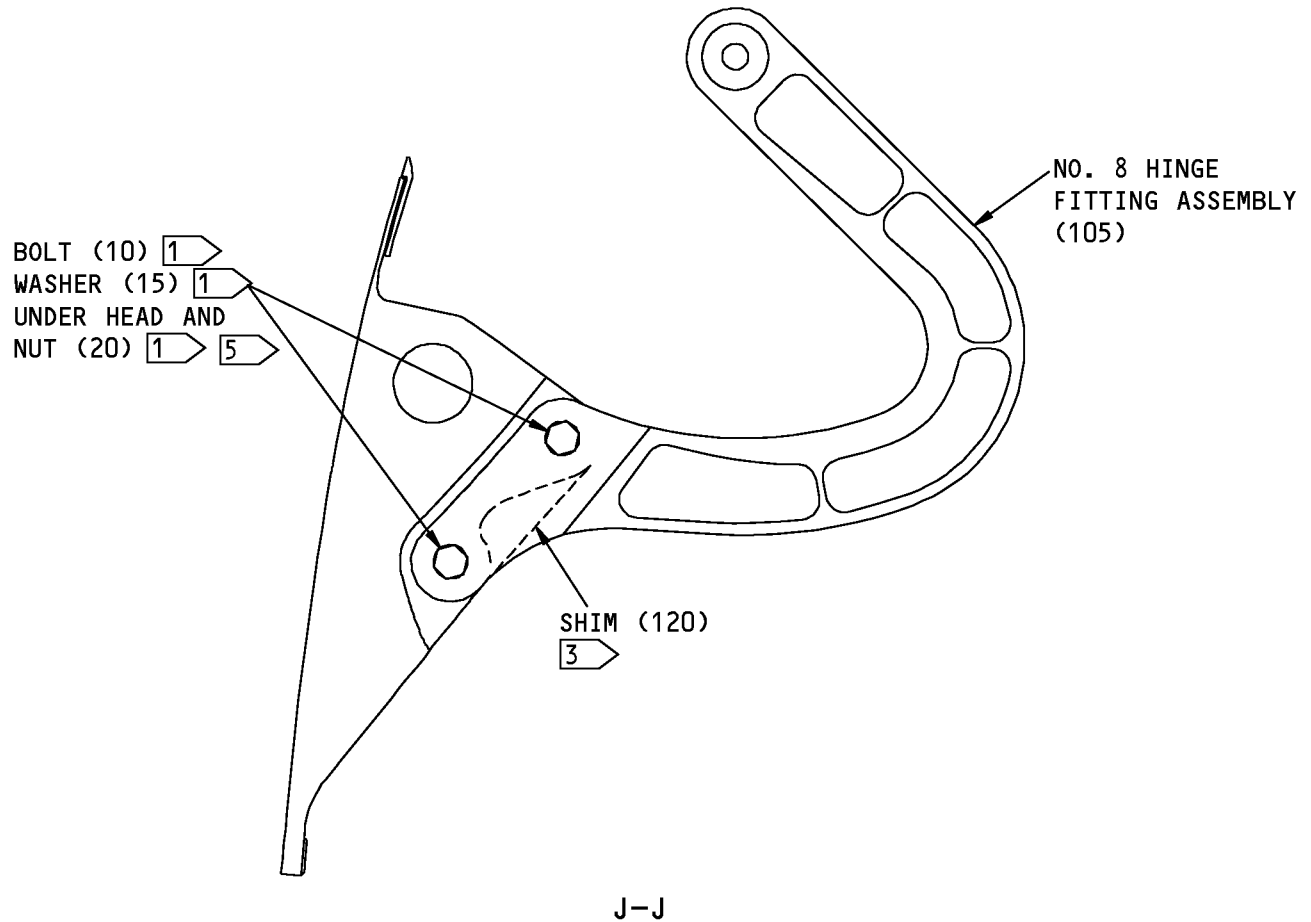
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## COMPONENT MAINTENANCE MANUAL



114A1220-5 thru -10, -201 thru -204 Krueger Flap and Bullnose Assembly  
Figure 701 (Sheet 10 of 15)

**57-56-44**

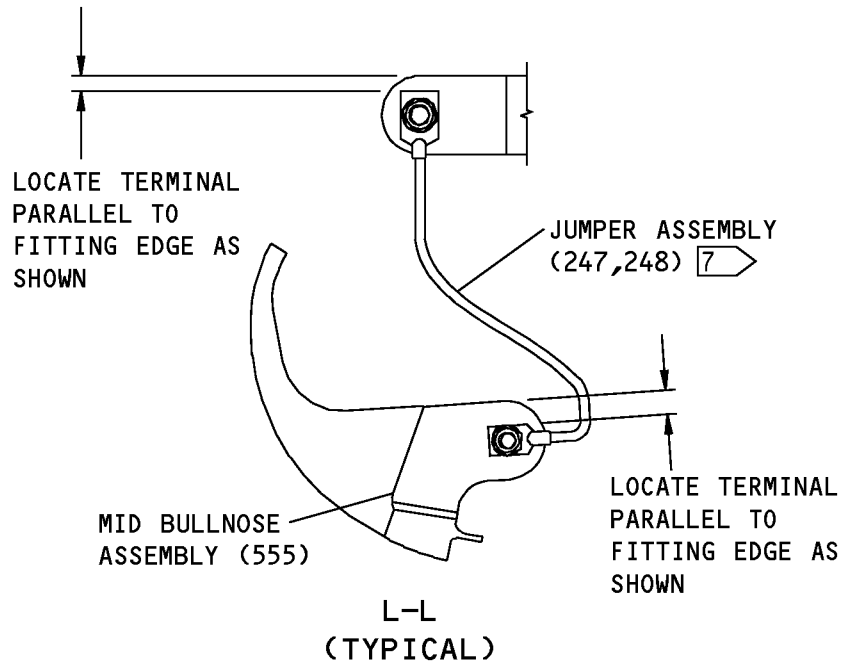
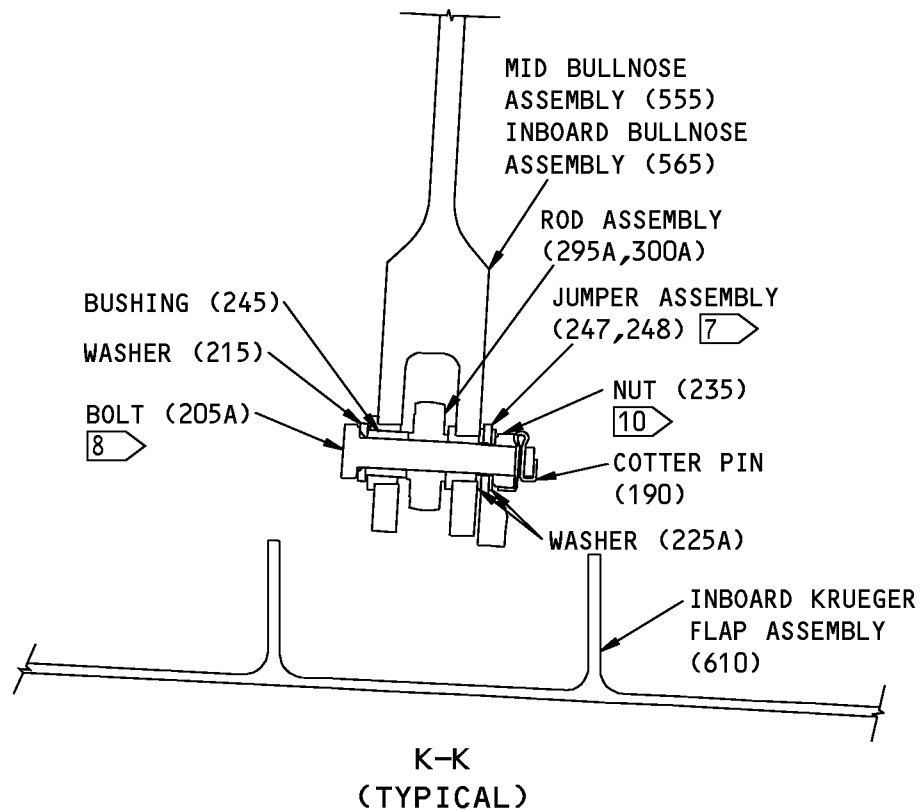
ASSEMBLY

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# COMPONENT MAINTENANCE MANUAL



114A1220-5 thru -10, -201 thru -204 Krueger Flap and Bullnose Assembly  
Figure 701 (Sheet 11 of 15)

## 57-56-44

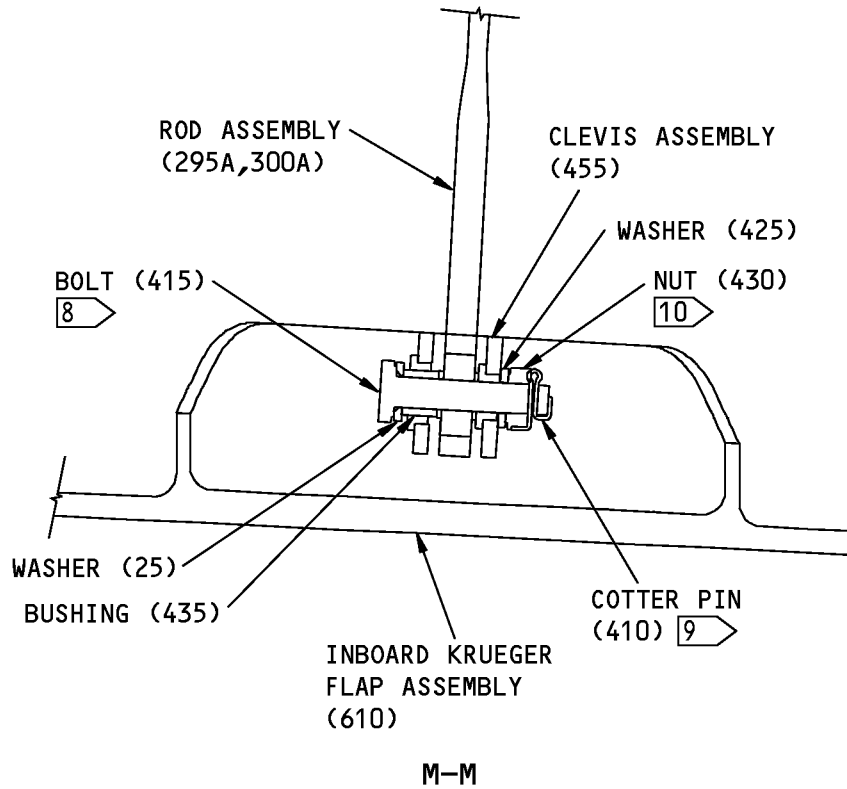
ASSEMBLY

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# COMPONENT MAINTENANCE MANUAL



114A1220-5 thru -10, -201 thru -204 Krueger Flap and Bullnose Assembly  
Figure 701 (Sheet 12 of 15)

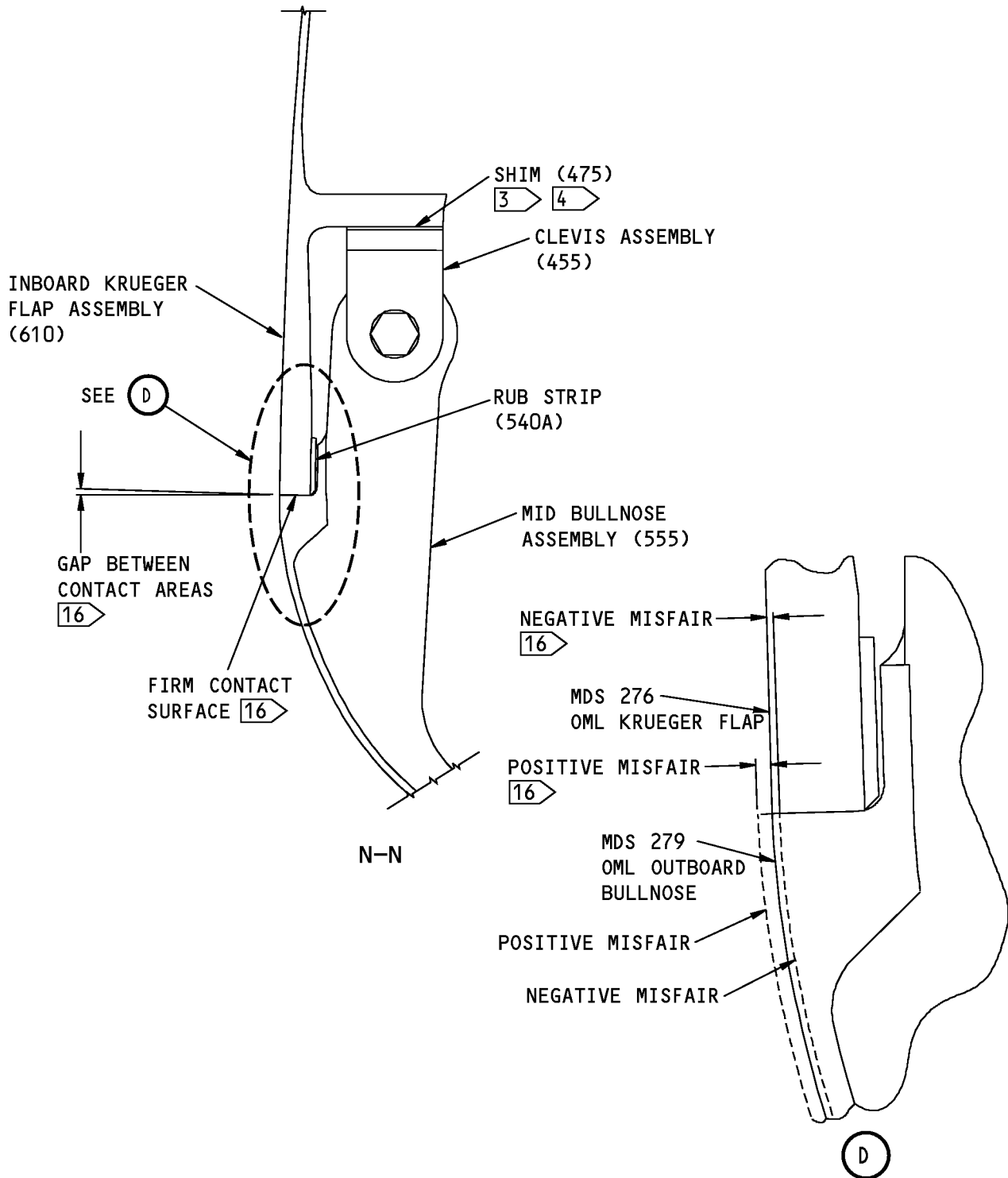
## 57-56-44

ASSEMBLY

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## COMPONENT MAINTENANCE MANUAL



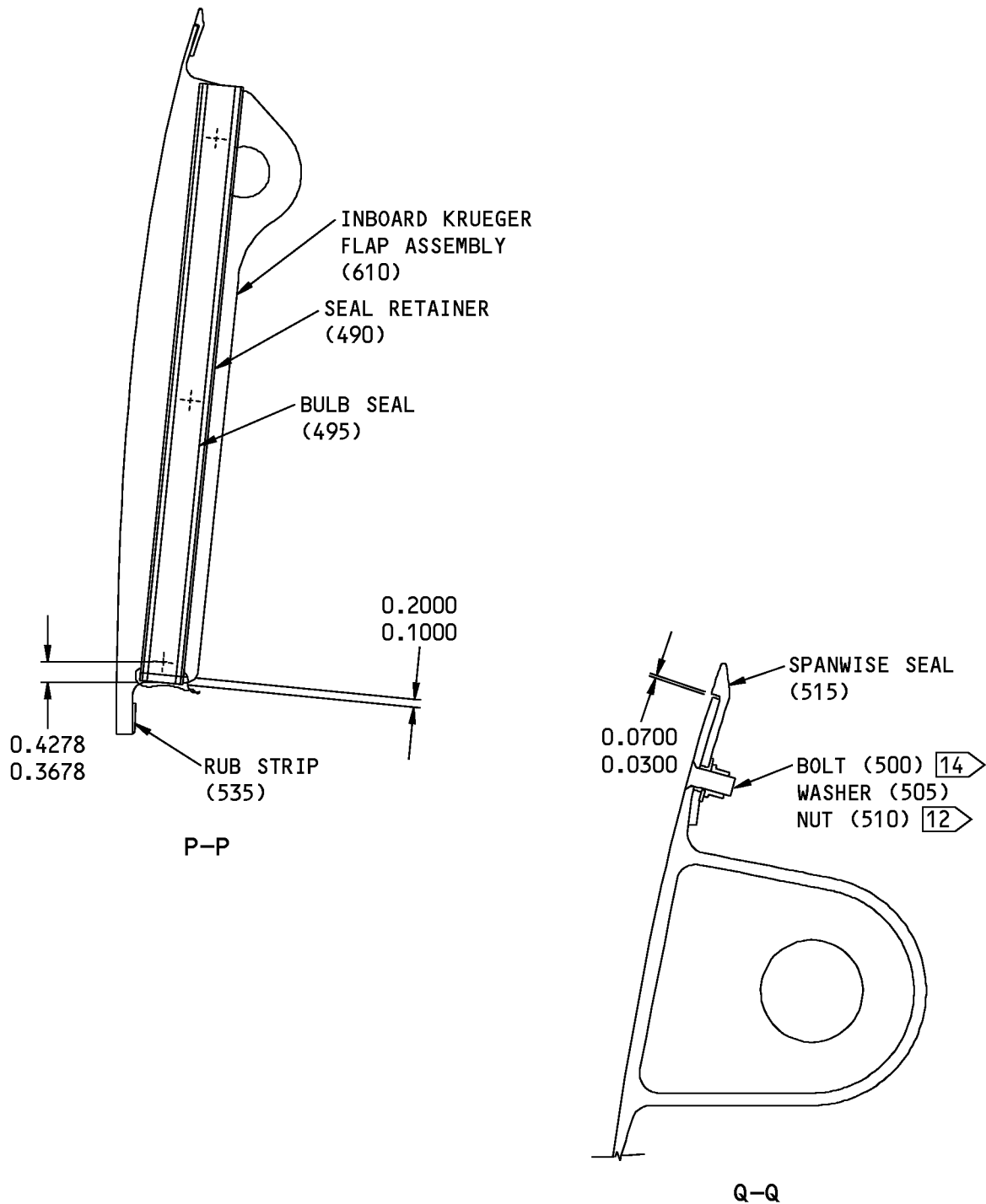
114A1220-5 thru -10, -201 thru -204 Krueger Flap and Bullnose Assembly  
Figure 701 (Sheet 13 of 15)

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ASSEMBLY

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**COMPONENT MAINTENANCE MANUAL**

114A1220-5 thru -10, -201 thru -204 Krueger Flap and Bullnose Assembly  
Figure 701 (Sheet 14 of 15)

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ASSEMBLY

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## COMPONENT MAINTENANCE MANUAL

- 1 INSTALL FASTENERS WITH BMS 5-95 SEALANT PER (F-19.48)
- 2 TIGHTEN THE NUT TO 50-70 POUND-INCHES
- 3 SHIM PER (SOPM 20-50-20), TYPE 1. MAXIMUM ALLOWED GAP 0.0050. MAXIMUM SHIM THICKNESS 0.0630. LAMINATED PORTION OF SHIM NOT TO EXCEED 0.0300. PEEL 0.0030 LAMINATIONS AND TAPER AS REQUIRED. FINISH SHIM BOTH SIDES AFTER DELAMINATION BEFORE INSTALLATION WITH BMS 5-95 SEALANT (F-20-05) ALSO SEE (SOPM 20-50-19)
- 4 OPTIONAL TO BOND SHIMS IN PLACE PER (SOPM 20-50-24) USING ONLY BMS 5-36 LOCTITE 430 OR 416
- 5 TIGHTEN THE NUT TO 90-125 POUND-INCHES
- 6 TIGHTEN THE NUT TO 150-200 POUND-INCHES
- 7 INSTALL THE GROUNDING STRAP PER (SOPM 20-11-03). CLEAN AREA TO BE ELECTRICALLY GROUNDED (AREA IN CONTACT WITH THE INNER WASHER) PER (SOPM 20-11-03) METHOD CM1. FILLET SEAL INSTALLATION WITH BMS 5-42 PER (SOPM 20-50-19) OPTIONAL SEALANT BMS 5-95
- 8 INSTALL FASTENERS WITH BMS 3-24 GREASE (F-19.16)
- 9 INSTALL COTTER PIN PER (SOPM 20-50-02)
- 10 TIGHTEN THE NUT TO 30-50 POUND-INCHES
- 11 THE MID BULLNOSE ASSEMBLY AND INBOARD BULLNOSE ASSEMBLY ARE SHOWN AS A PERIPHERY AND IN THE EXTENDED POSITION FOR CLARITY
- 12 TIGHTEN THE NUT (510) TO 15-20 POUND-INCHES
- 13 FASTENER FLUSHNESS REQUIREMENT: BOLT HEAD MUST BE INSTALLED WITHIN +0.0020 TO -0.010. DO NOT SHAVE HEAD OF BOLT
- 14 INSTALL WITH CORROSION PREVENTIVE COMPOUND MIL-C-11796 (F-19.11)
- 15 INSTALL A SAFETY WIRE AS SHOWN IN THE (SOPM 20-50-02)
- 16 SEE FIT AND FAIR INSTRUCTIONS IN THE ASSEMBLY PROCEDURE

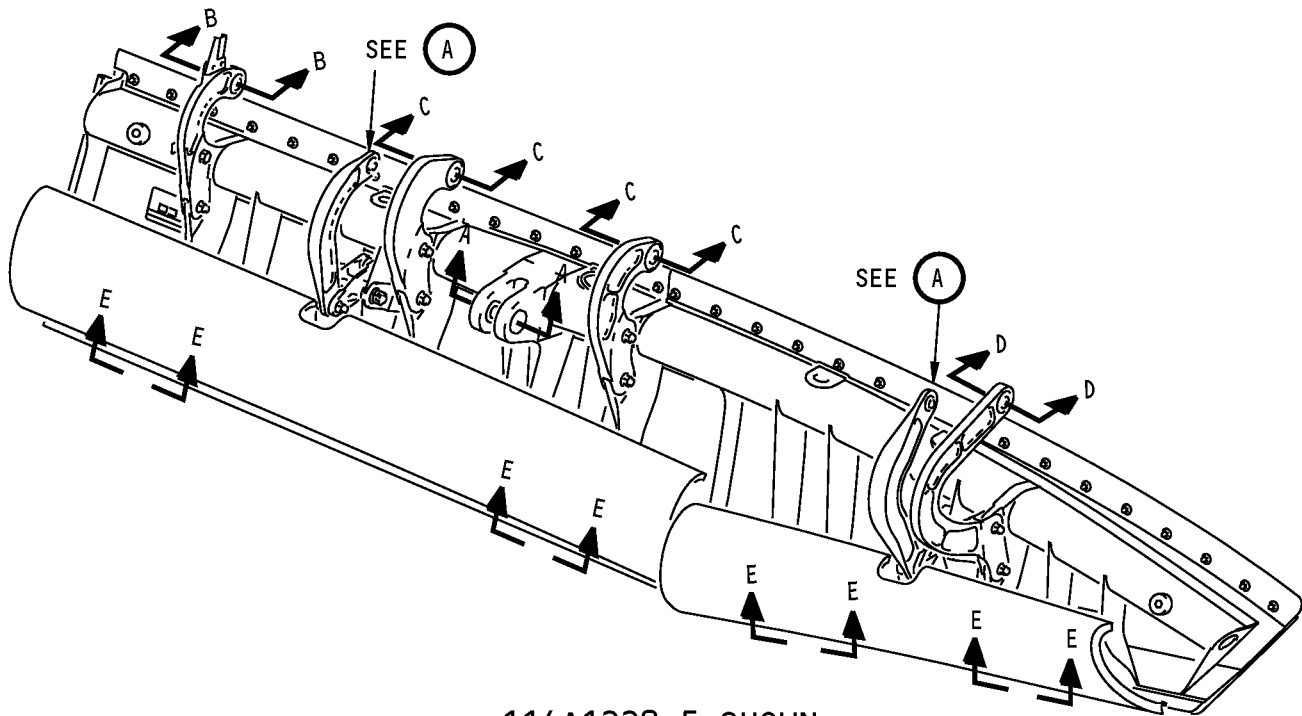
114A1220-5 thru -10, -201 thru -204 Krueger Flap and Bullnose Assembly  
Figure 701 (Sheet 15 of 15)

**57-56-44**

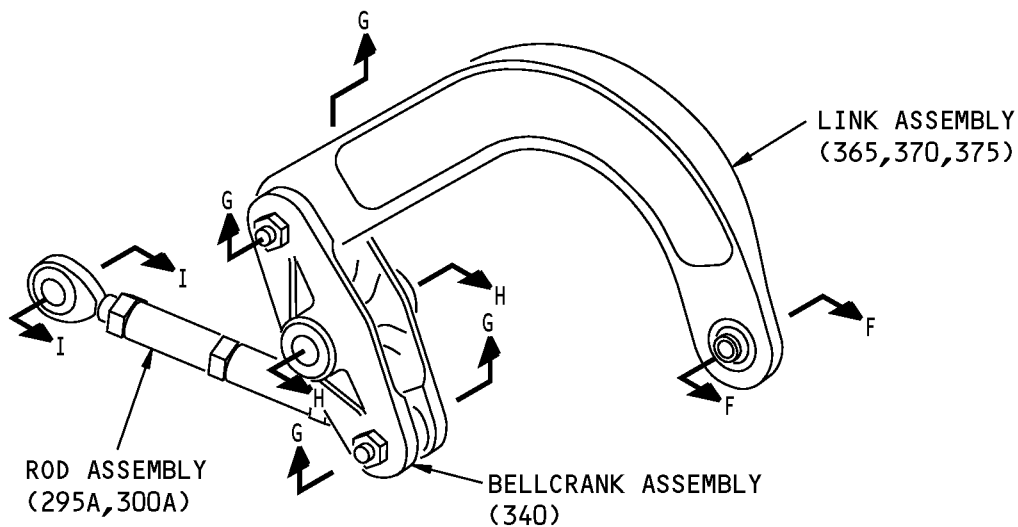
ASSEMBLY  
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# COMPONENT MAINTENANCE MANUAL

## FITS AND CLEARANCES



114A1220-5 SHOWN



MID BULLNOSE LINK ASSEMBLY (250A) SHOWN

(A)

Fits and Clearances  
Figure 801 (Sheet 1 of 8)

# 57-56-44

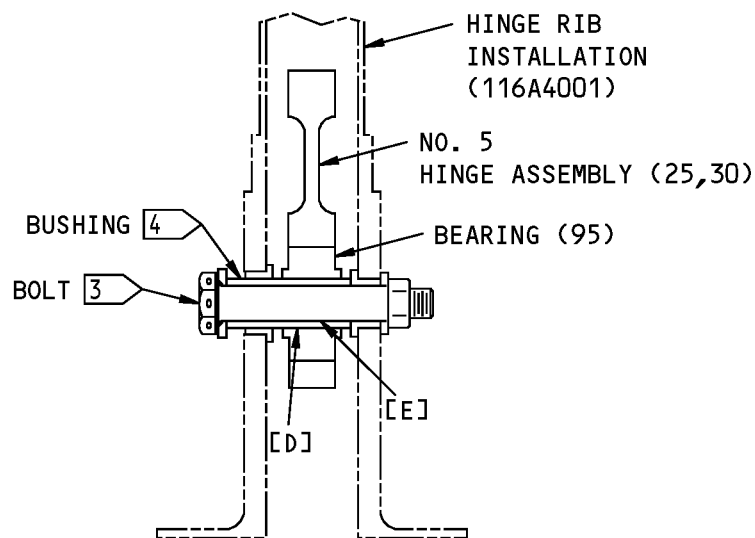
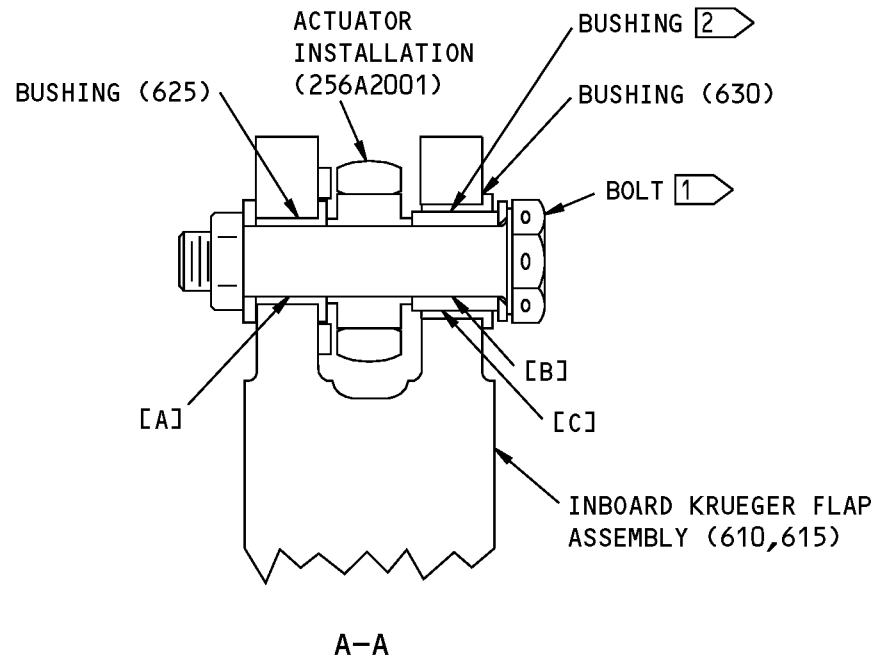
FITS AND CLEARANCES

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# COMPONENT MAINTENANCE MANUAL



114A1720-1 SHOWN

B-B

Fits and Clearances  
Figure 801 (Sheet 2 of 8)

**57-56-44**

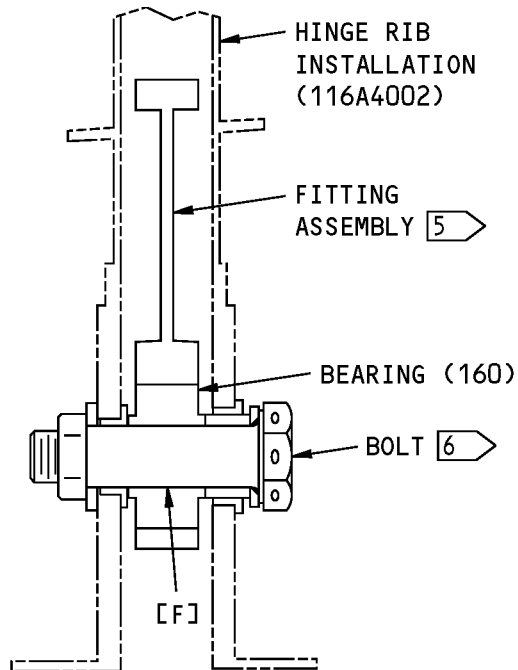
FITS AND CLEARANCES

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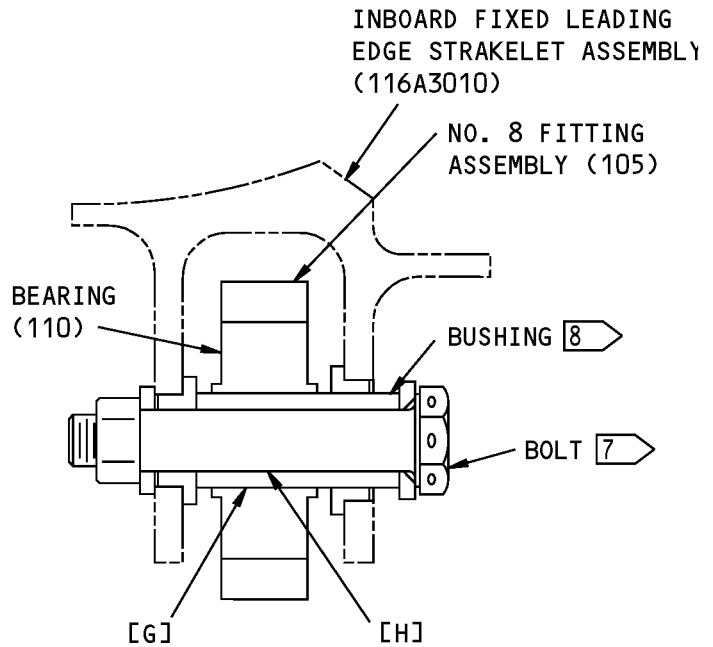


# COMPONENT MAINTENANCE MANUAL

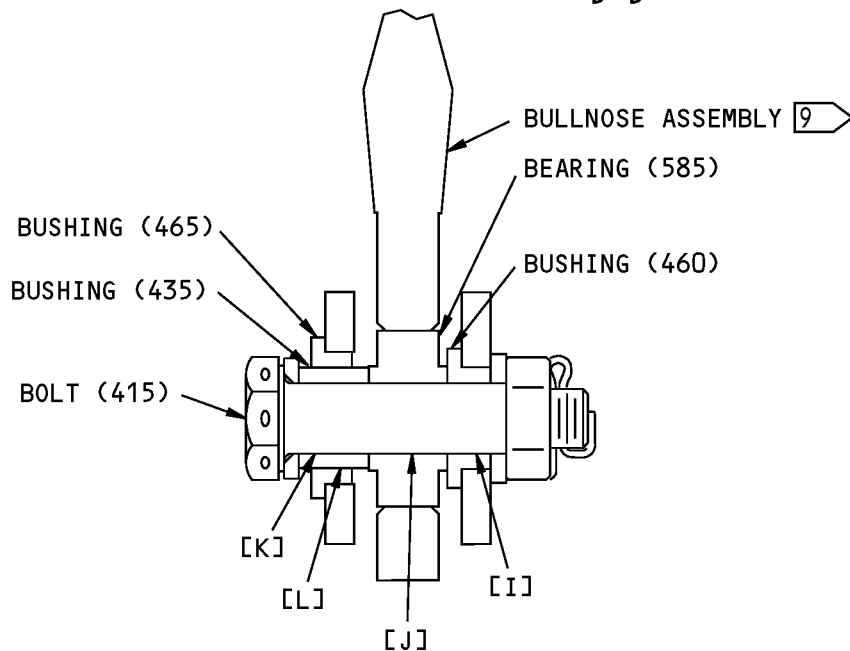


114A1726-1 SHOWN

C-C



D-D



SHOWN WITH MID BULLNOSE ASSEMBLY

E-E

Fits and Clearances  
Figure 801 (Sheet 3 of 8)

## 57-56-44

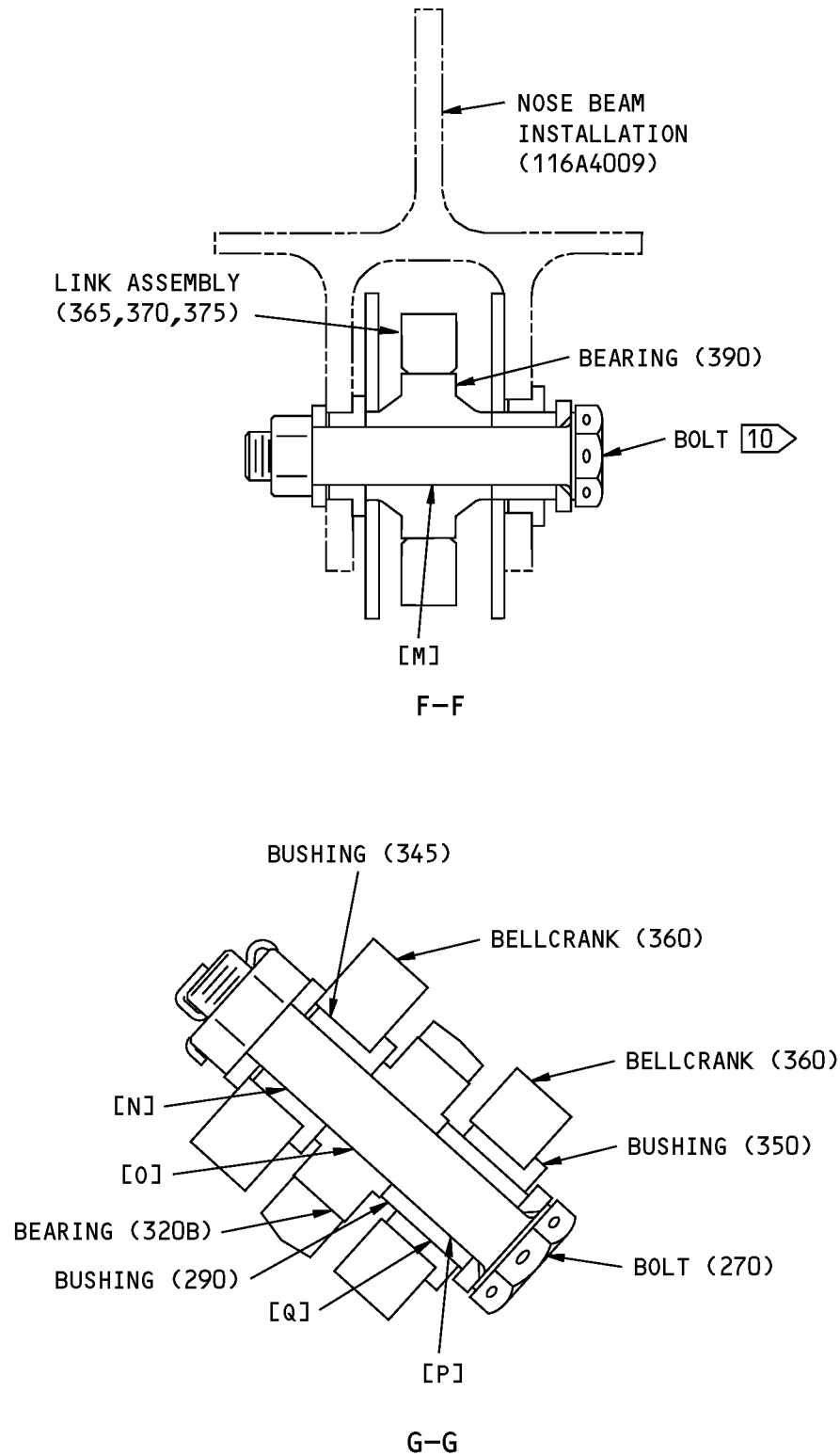
FITS AND CLEARANCES

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# COMPONENT MAINTENANCE MANUAL



Fits and Clearances  
Figure 801 (Sheet 4 of 8)

## 57-56-44

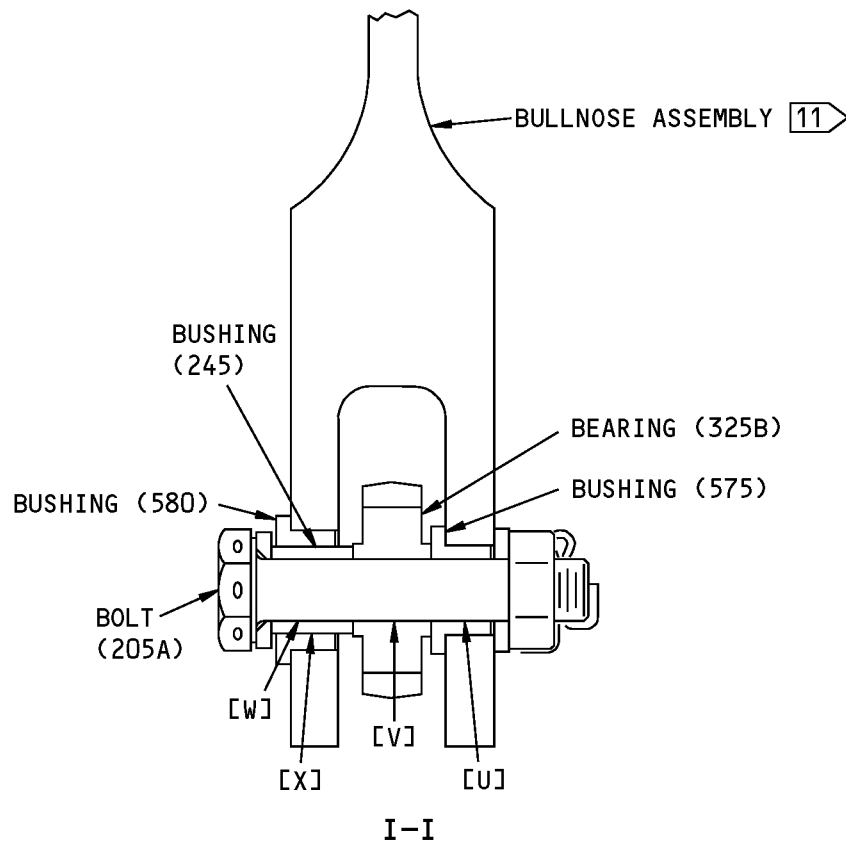
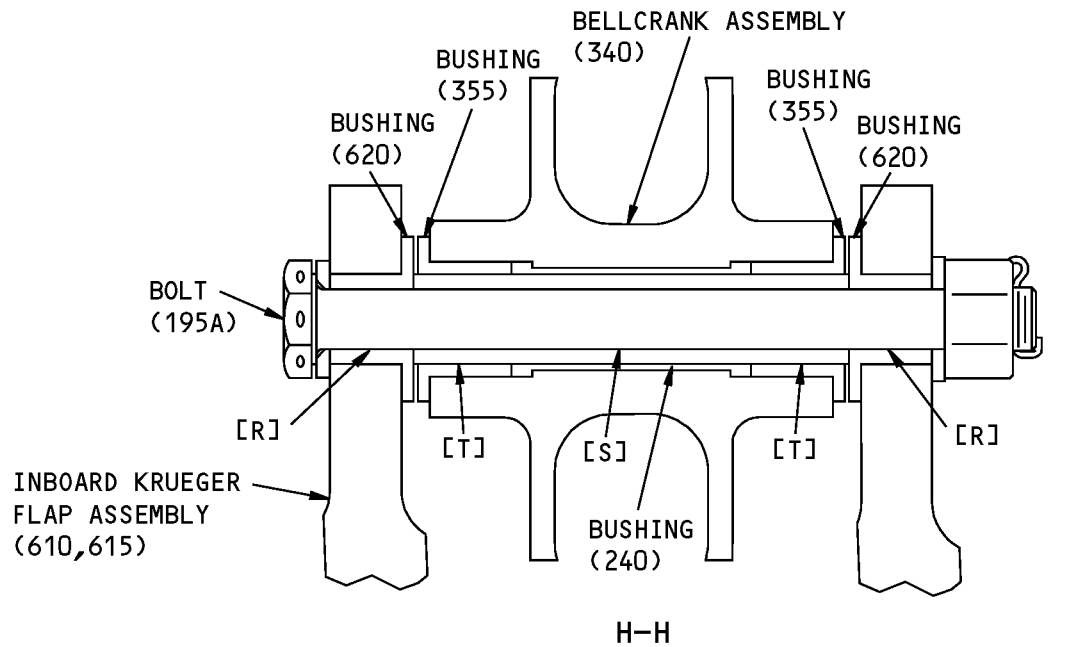
FITS AND CLEARANCES

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# COMPONENT MAINTENANCE MANUAL



Fits and Clearances  
Figure 801 (Sheet 5 of 8)

## 57-56-44












FITS AND CLEARANCES

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# COMPONENT MAINTENANCE MANUAL

REF LETTER	REF IPL	DESIGN DIMENSION*				SERVICE WEAR LIMIT*		
	FIG. 1, MATING ITEM NO.	DIMENSION		ASSEMBLY CLEARANCE		DIMENSION		MAXIMUM CLEARANCE
		MIN	MAX	MIN	MAX	MIN	MAX	
[A]	ID BUSHING (625)	0.6245	0.6252	0.0005	0.0022	0.6215	0.6267	0.0050
	OD BOLT 1 	0.6230	0.6240					
[B]	ID BUSHING 2 	0.6245	0.6250	0.0005	0.0020	0.6215	0.6265	0.0050
	OD BOLT 1 	0.6230	0.6240					
[C]	ID BUSHING (630)	0.8745	0.8753	0.0005	0.0018	0.8720	0.8763	0.0040
	OD BUSHING 2 	0.8735	0.8740					
[D]	ID BEARING (95)	0.4375	0.4385	0.0005	0.0020	0.4350	0.4395	0.0050
	OD BUSHING 4 	0.4365	0.4370					
[E]	ID BUSHING 4 	0.3125	0.3130	0.0005	0.0020	0.3095	0.3145	0.0050
	OD BOLT 3 	0.3110	0.3120					
[F]	ID BEARING (160)	0.5000	0.5005	0.0005	0.0020	0.4970	0.5020	0.0050
	OD BOLT 6 	0.4985	0.4995					
[G]	ID BEARING (110)	0.4375	0.4385	0.0005	0.0020	0.4350	0.4395	0.0050
	OD BUSHING 8 	0.4365	0.4370					
[H]	ID BUSHING 8 	0.3125	0.3130	0.0005	0.0020	0.3095	0.3145	0.0050
	OD BOLT 7 	0.3110	0.3120					
[I]	ID BUSHING (460)	0.2500	0.2505	0.0005	0.0020	0.2470	0.2520	0.0050
	OD BOLT (415)	0.2485	0.2495					
[J]	ID BEARING (585)	0.2500	0.2505	0.0005	0.0020	0.2470	0.2520	0.0050
	OD BOLT (415)	0.2485	0.2495					

\* ALL DIMENSIONS ARE IN INCHES

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Fits and Clearances  
Figure 801 (Sheet 6 of 8)

## 57-56-44


FITS AND CLEARANCES

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# COMPONENT MAINTENANCE MANUAL

REF LETTER	REF IPL	DESIGN DIMENSION*				SERVICE WEAR LIMIT*		
	FIG. 1, MATING ITEM NO.	DIMENSION		ASSEMBLY CLEARANCE		DIMENSION		MAXIMUM CLEARANCE
		MIN	MAX	MIN	MAX	MIN	MAX	
[K]	ID BUSHING (435)	0.2500	0.2505	0.0005	0.0020	0.2470	0.2520	0.0050
	OD BOLT (415)	0.2485	0.2495					
[L]	ID BUSHING (465)	0.3750	0.3756	0.0005	0.0016	0.3725	0.3766	0.0040
	OD BUSHING (435)	0.3740	0.3745					
[M]	ID BEARING (390)	0.2500	0.2505	0.0005	0.0020	0.2470	0.2520	0.0050
	OD BOLT 	0.2485	0.2495					
[N]	ID BUSHING (345)	0.2500	0.2505	0.0005	0.0020	0.2470	0.2520	0.0050
	OD BOLT (270)	0.2485	0.2495					
[O]	ID BEARING (320B)	0.2500	0.2505	0.0005	0.0020	0.2470	0.2520	0.0050
	OD BOLT (270)	0.2485	0.2495					
[P]	ID BUSHING (290)	0.2500	0.2505	0.0005	0.0020	0.2470	0.2520	0.0050
	OD BOLT (270)	0.2485	0.2495					
[Q]	ID BUSHING (350)	0.3750	0.3756	0.0005	0.0016	0.3725	0.3766	0.0040
	OD BUSHING (290)	0.3740	0.3745					
[R]	ID BUSHING (620)	0.3125	0.3131	0.0005	0.0021	0.3095	0.3146	0.0050
	OD BOLT (195A)	0.3110	0.3120					
[S]	ID BUSHING (240)	0.3125	0.3130	0.0005	0.0020	0.3095	0.3145	0.0050
	OD BOLT (195A)	0.3110	0.3120					
[T]	ID BUSHING (355)	0.4380	0.4390	0.0010	0.0025	0.4350	0.4405	0.0050
	OD BUSHING (240)	0.4365	0.4370					

\* ALL DIMENSIONS ARE IN INCHES

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Fits and Clearances  
Figure 801 (Sheet 7 of 8)

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FITS AND CLEARANCES

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# COMPONENT MAINTENANCE MANUAL

REF LETTER	REF IPL	DESIGN DIMENSION*				SERVICE WEAR LIMIT*		
	FIG. 1, MATING ITEM NO.	DIMENSION		ASSEMBLY CLEARANCE		DIMENSION		MAXIMUM CLEARANCE
		MIN	MAX	MIN	MAX	MIN	MAX	
[U]	ID BUSHING (575)	0.2500	0.2505	0.0005	0.0020	0.2470	0.2520	0.0050
	OD BOLT (205A)	0.2485	0.2495					
[V]	ID BEARING (325B)	0.2500	0.2505	0.0005	0.0020	0.2470	0.2520	0.0050
	OD BOLT (205A)	0.2485	0.2495					
[W]	ID BUSHING (245)	0.2500	0.2505	0.0005	0.0020	0.2470	0.2520	0.0050
	OD BOLT (205A)	0.2485	0.2495					
[X]	ID BUSHING (580)	0.3750	0.3756	0.0005	0.0016	0.3725	0.3766	0.0040
	OD BUSHING (245)	0.3740	0.3745					

\* ALL DIMENSIONS ARE IN INCHES

- 1 INSTALLATION BOLT P/N BACB30NM10DK38
- 2 INSTALLATION BUSHING P/N BACB28AK10-080
- 3 INSTALLATION BOLT P/N BACB30NR5DK23
- 4 INSTALLATION BUSHING P/N BACB28AK05-110
- 5 NO. 6 FITTING ASSEMBLY (150)  
NO. 7 FITTING ASSEMBLY (155)
- 6 INSTALLATION BOLT P/N BACB30NR8DK23
- 7 INSTALLATION BOLT P/N BACB30NR5DK23
- 8 INSTALLATION BUSHING P/N BACB28AK05-116
- 9 MID BULLNOSE ASSEMBLY (550,560)  
INBOARD BULLNOSE ASSEMBLY (565,570)
- 10 INSTALLATION BOLT P/N BACB30NR4DK19
- 11 MID BULLNOSE ASSEMBLY (555,560)  
INBOARD BULLNOSE ASSEMBLY (565,570)

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Fits and Clearances  
Figure 801 (Sheet 8 of 8)

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**COMPONENT MAINTENANCE MANUAL**

**SPECIAL TOOLS, FIXTURES, AND EQUIPMENT**

**(NOT APPLICABLE)**

**57-56-44**

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
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
15653	ALCOA GLOBAL FASTENERS INC DIV KAYNAR PRODUCTS 800 S STATE COLLEGE BLVD FULLERTON, CALIFORNIA 92831-3001 FORMERLY VK6405 MICRODOT AEROSP LTD; FORMERLY KAYNAR TECH FORMERLY FAIRCHILD FASTENERS KAYNAR DIV
15860	NEW HAMPSHIRE BALL BEARINGS, INC ASTRO DIVISION 155 LEXINGTON AVENUE LACONIA, NEW HAMPSHIRE 03246-2937 FORMERLY ASTRO BEARING CORP, LOS ANGELES, CALIF.
1FF12	CIRCUIT SYSTEMS CO 2621 COLORADO CIR PO BOX 171322 ARLINGTON, TEXAS 76017
1GK47	R AND B ELECTRONICS INC 2374 NW DALLAS STREET GRAND PRAIRIE, TEXAS 75050
50632	KAMATICS CORP SUB OF KAMAN CORP 1335 BLUE HILLS ROAD BLOOMFIELD, CONNECTICUT 06002-1304

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ILLUSTRATED PARTS LIST

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**COMPONENT MAINTENANCE MANUAL**

<b>Code</b>	<b>Name</b>
56644	AURORA BEARING CO 970 SOUTH LAKE STREET AURORA, ILLINOIS 60506-5929
62554	SIMMONDS MECAERO FASTENERS INC 1734 SEQUOIA AVENUE ORANGE, CALIFORNIA 92668
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
81376	SMITH ACQUISITION COMPANY 2240 BUENA VISTA BALDWIN PARK, CALIFORNIA 91706
91812	ESTERLINE MASON 13955 BALVOA ROAD SYLMAR, CALIFORNIA 91342 FORMERLY JANCO CORPORATION
97613	SARGENT CONTROLS & AEROSPACE/KAHR BEARING DIV 5675 W BURLINGAME RD TUCSON, ARIZONA 85743 FORMERLY AETNA STEEL PROD KAHR BEARING DIV V96579 FORMERLY SARGENT IND KAHR BEARING DIV, BURBANK, CALIFORNIA
S0352	NIPPON MINIATURE BEARING CO LTD TOKYO, JAPAN

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## NUMERICAL INDEX

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
03-835-07E001		1	95	1
03-836-07E001		1	110	1
100224-7		1	145	1
100227-6		1	248	1
100227-8		1	247	1
114A1201-1		1	455	4
114A1201-3		1	470	1
114A1220-10		1	5C	RF
114A1220-11		1	1F	RF
114A1220-12		1	5E	RF
114A1220-201		1	1E	RF
114A1220-202		1	5D	RF
114A1220-203		1	1G	RF
114A1220-204		1	5F	RF
114A1220-5		1	1B	RF
114A1220-6		1	5A	RF
114A1220-7		1	1C	RF
114A1220-8		1	5B	RF
114A1220-9		1	1D	RF
114A1221-1		1	610	1
114A1221-2		1	615	1
114A1221-201		1	610A	1
114A1221-202		1	615A	1
114A1221-203		1	640A	1
114A1221-204		1	645A	1
114A1221-3		1	640	1
114A1221-4		1	645	1
114A1320-1		1	555	1
114A1320-2		1	560	1
114A1320-3		1	590	1
114A1320-4		1	595	1
114A1321-1		1	565	1
114A1321-2		1	570	1
114A1321-3		1	600	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
114A1321-4		1	605	1
114A1401-11		1	300A	1
114A1401-9		1	295A	1
114A1402-11		1	335A	1
114A1402-9		1	330A	1
114A1411-1		1	365	1
114A1411-2		1	395	1
114A1413-1		1	340	1
114A1413-2		1	360	1
114A1420-3		1	250A	1
114A1424-1		1	370	1
114A1424-2		1	375	1
114A1424-3		1	400	1
114A1424-4		1	405	1
114A1424-5		1	370A	1
114A1424-6		1	375A	1
114A1424-7		1	400A	1
114A1424-8		1	405A	1
114A1430-3		1	255A	1
114A1430-4		1	260A	1
114A1430-5		1	255B	1
114A1430-6		1	260B	1
114A1701-11		1	180	2
114A1701-7		1	120	4
114A1701-9		1	175	2
114A1720-1		1	25	1
114A1720-2		1	30	1
114A1720-3		1	25A	1
114A1720-4		1	30A	1
114A1725-1		1	90	1
114A1725-3		1	100	1
114A1726-1		1	150	1
114A1726-3		1	165	1
114A1726-5		1	150A	1
114A1726-7		1	165A	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
114A1727-1		1	155	1
114A1727-3		1	170	1
114A1728-1		1	105	1
114A1728-3		1	115	1
114A1801-11		1	515B	1
114A1801-12		1	520B	1
114A1801-3		1	515	1
		1	515A	1
114A1801-4		1	520	1
		1	520A	1
114A1801-7		1	525A	1
114A1801-8		1	530A	1
114A1802-1		1	495	1
114A1803-1		1	490	1
114A1804-3		1	540A	1
114A1804-4		1	535A	1
114A1804-5		1	545	1
114A1804-6		1	550	1
114A1815-3		1	55	1
114A1815-4		1	60	1
114A1816-1		1	50	1
114A1816-3		1	85	1
114A1816-9		1	85A	1
114A1817-1		1	40	1
114A1817-5		1	80	1
940CW24-7		1	145	1
940CW27-6		1	248	1
940CW27-8		1	247	1
ADB04V301NC		1	380	1
		1	585	2
ADNE4-334N		1	325B	1
ADNE4-334N9		1	325B	1
ADNEL4-334N9		1	320B	1
ADW07V301NZ08G		1	160	1
AKBL07V04003		1	95	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
AKWL07V4003		1	110	1
ARNM4-101		1	325B	1
BACB10ES04C		1	385	1
BACB10FA08G		1	160	1
BACB10FB04GC		1	380	1
		1	585	2
BACB10GC07G		1	110	1
BACB10GD07G		1	95	1
BACB28AA5B033		1	620	2
BACB28AA5B048		1	635	2
BACB28AK04-029		1	435	4
BACB28AK04-034		1	245	2
BACB28AK04-041		1	290	2
BACB28AK05-212		1	240	2
BACB28AP04P011		1	460	1
BACB28AP04P019		1	575	1
BACB28AP04P025		1	345	2
BACB28AP10P058		1	625	1
BACB28AT06B011C		1	465	1
BACB28AT06B019C		1	580	1
BACB28AT06B025C		1	350	2
BACB28AT14B058C		1	630	1
BACB28AV07B040A		1	355	2
BACB30NR4DK14		1	415	4
BACB30NR4DK17		1	205A	2
BACB30NR4DK18		1	270	2
BACB30NR4K9		1	440	8
BACB30NR5DK50		1	195A	1
BACB30NR5DK55		1	200A	1
BACB30NR5K11		1	10	4
BACB30NR6K12		1	125	3
BACB30NR6K14		1	130	1
BACB30VF3K3		1	500	30
BACJ40AB24-7		1	145	1
BACJ40AB27-6		1	248	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACJ40AB27-8		1	247	1
BACN10JD104CD		1	235	2
		1	285	2
		1	430	4
BACN10JD5CD		1	230	2
BACN10YR3CD		1	510	30
BACN10YR4CD		1	450	8
BACN10YR5CD		1	20	4
BACN10YR6CD		1	140	4
BACP18BC02A04P		1	190	2
		1	265	2
		1	410	4
BACP18BC02A06P		1	185	2
BACR15FT5D		1	65	1
BACR15GF5D		1	45	2
		1	485	2
BACS40R010C026F		1	475	4
BACW10BP4ACU		1	215	2
		1	275	2
		1	420	4
BACW10BP4APU		1	280	2
		1	425	4
BACW10BP5ACU		1	210	2
BACW10BP6NAPU		1	315	2
BACW10P183AL		1	75	1
H52732-3CD		1	510	30
H52732-4CD		1	450	8
H52732-5CD		1	20	4
H52732-6CD		1	140	4
HTES04C		1	385	1
HTFB04GC		1	380	1
		1	585	2
HTLGD07V		1	95	1
KNDB04-70		1	380	1
		1	585	2

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
KRS173904B		1	325C	1
KSC145700BZ04GC		1	380	1
		1	585	2
KSC152200BZ08G		1	160	1
KSC272604V		1	390	1
KSR174004B		1	320C	1
KWDB08-33		1	160	1
MS27253-1		1	655	1
MSSE104FB		1	325B	1
MSSES04FBDF		1	325B	1
MSSESL04FBDF		1	320B	1
MSSRRS04FB		1	325B	1
NAS1149D0432H		1	225A	4
NAS1149D0432J		1	445	16
NAS1149D0532H		1	220A	4
NAS1149E0332P		1	505	30
NAS1149E0532R		1	15	8
NAS1149E0632R		1	135	9
NAS1399B4A2		1	650	4
NAS1399CW4A		1	35	2
NAS1399CW5A		1	70	1
NAS1399D5A		1	480	1
NAS509-6C		1	310	1
NAS509L6C		1	305	1
NC04T5C		1	385	1
NC07TG14		1	95	1
NEE07GDG		1	95	1
NES04FBGC		1	380	1
		1	585	2
PLH53CD		1	510	30
PLH54CD		1	450	8
PLH55CD		1	20	4
PLH56CD		1	140	4
RBEJ40AB24-7		1	145	1
RBEJ40AB27-6		1	248	1

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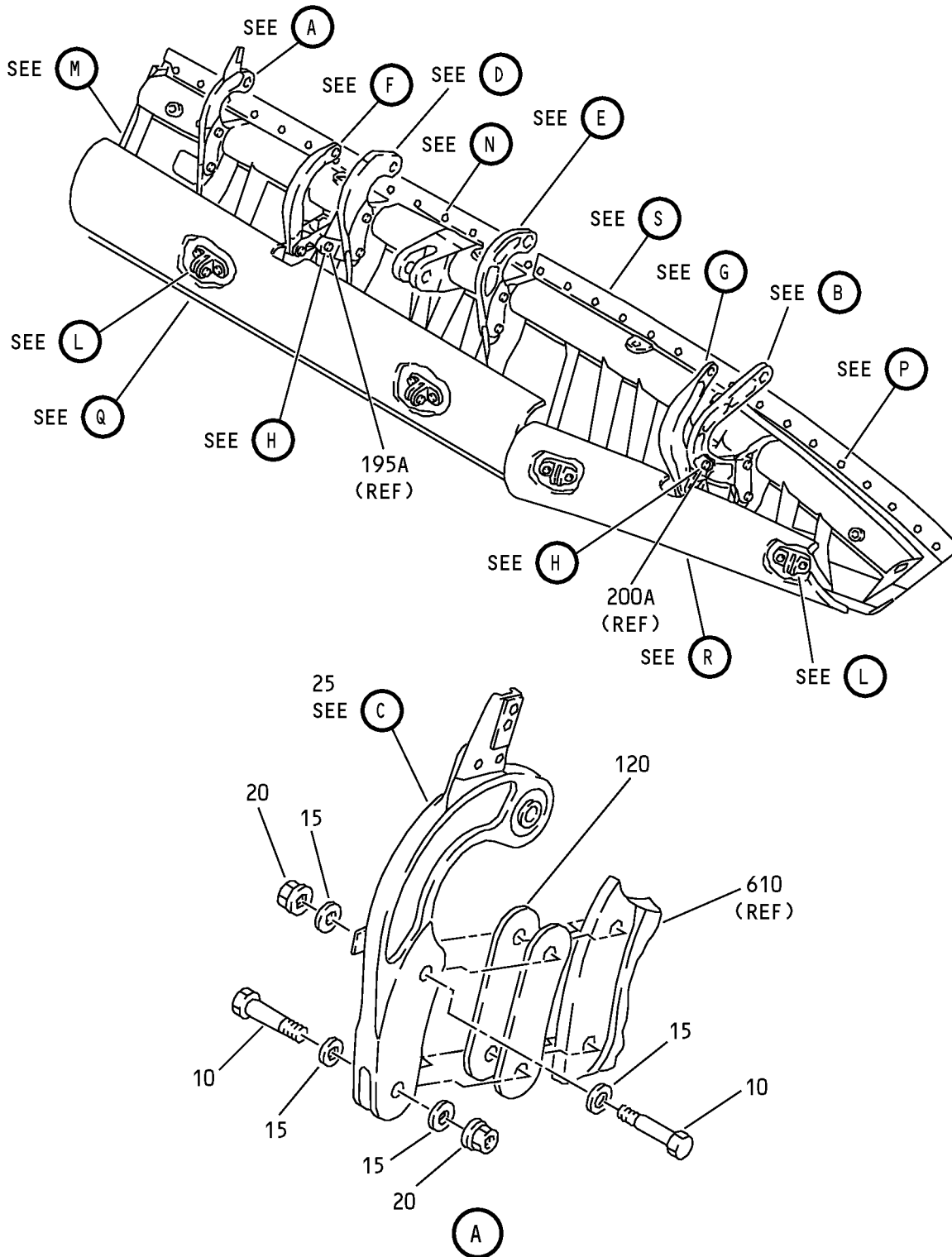
PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
RBEJ40AB27-8		1	247	1
S012T235-104-89		1	320B	1
S012T235-104-9		1	325B	1
S012T238-104-89		1	320C	1
S012T238-104-9		1	325C	1
SWKN04520C		1	385	1
SWKR07-419S		1	110	1
SWKRS08-350S		1	160	1
WC07TG14		1	110	1
WEE07GCG		1	110	1
WES08FAG		1	160	1
WHTFA08V		1	160	1
WHTLGC07V		1	110	1

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**COMPONENT MAINTENANCE MANUAL**

Krueger Flap and Bullnose Assemblies No. 2 and 3  
IPL Figure 1 (Sheet 1 of 12)

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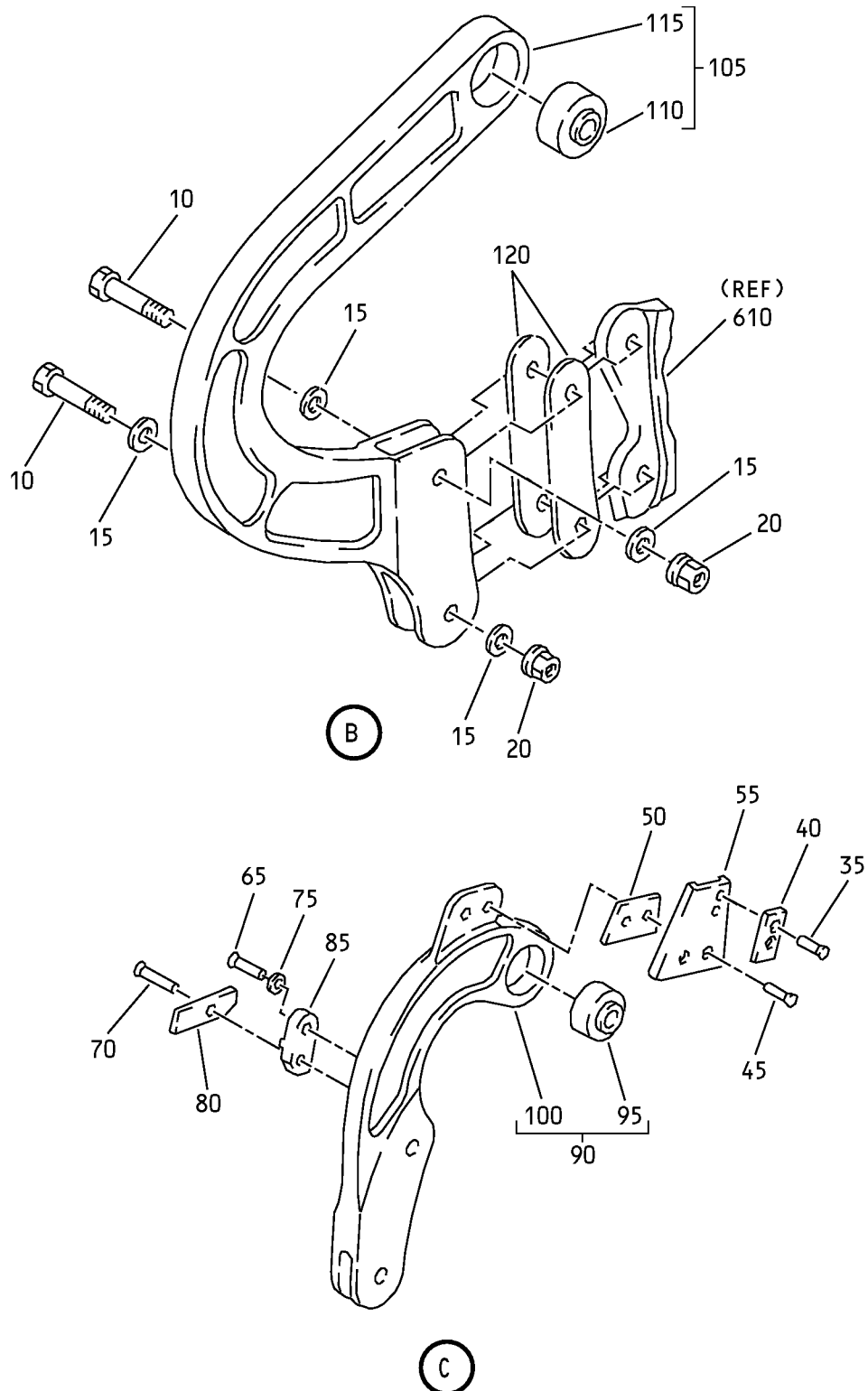
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Krueger Flap and Bullnose Assemblies No. 2 and 3  
IPL Figure 1 (Sheet 2 of 12)

## 57-56-44

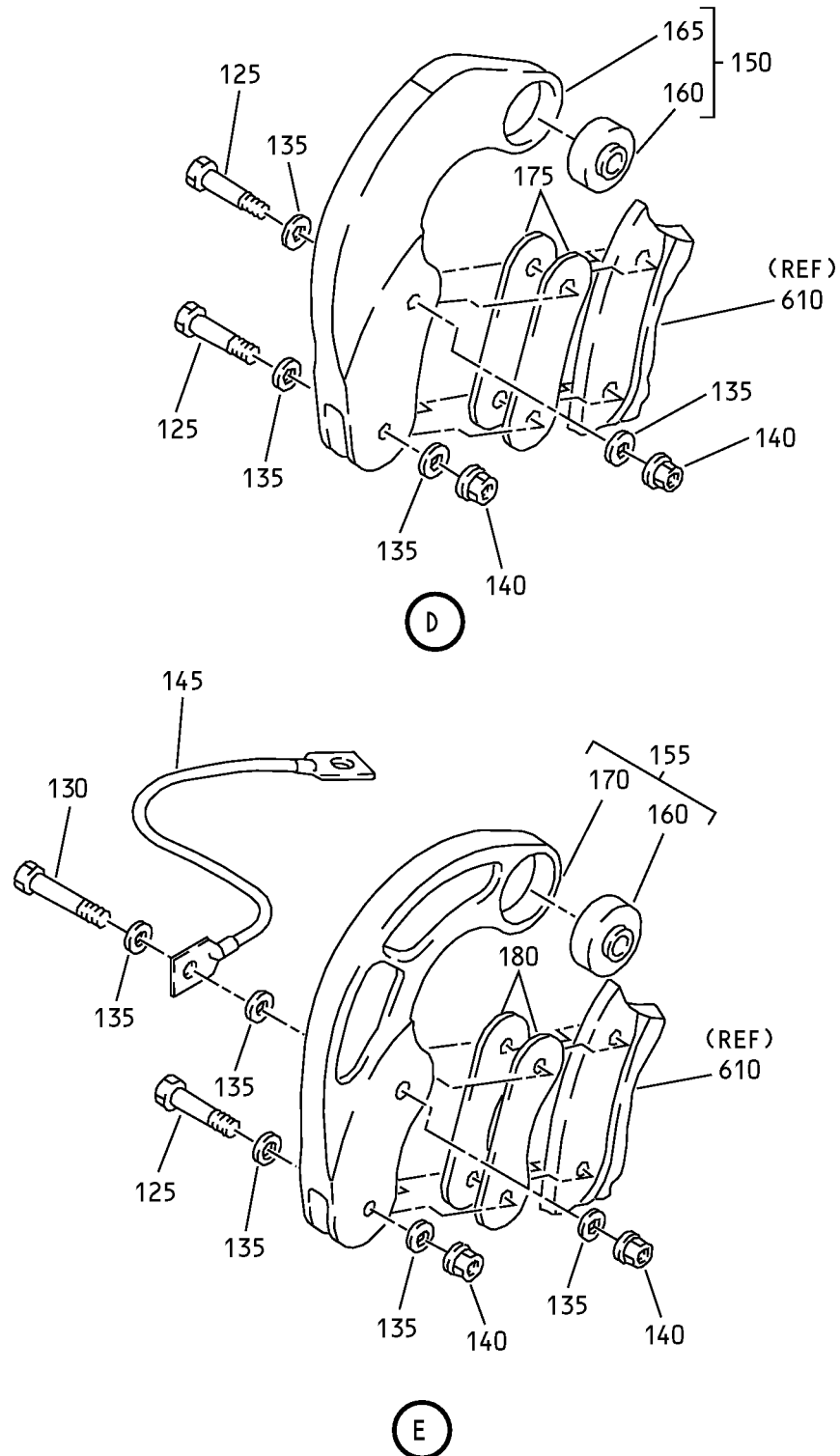
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Krueger Flap and Bullnose Assemblies No. 2 and 3  
IPL Figure 1 (Sheet 3 of 12)

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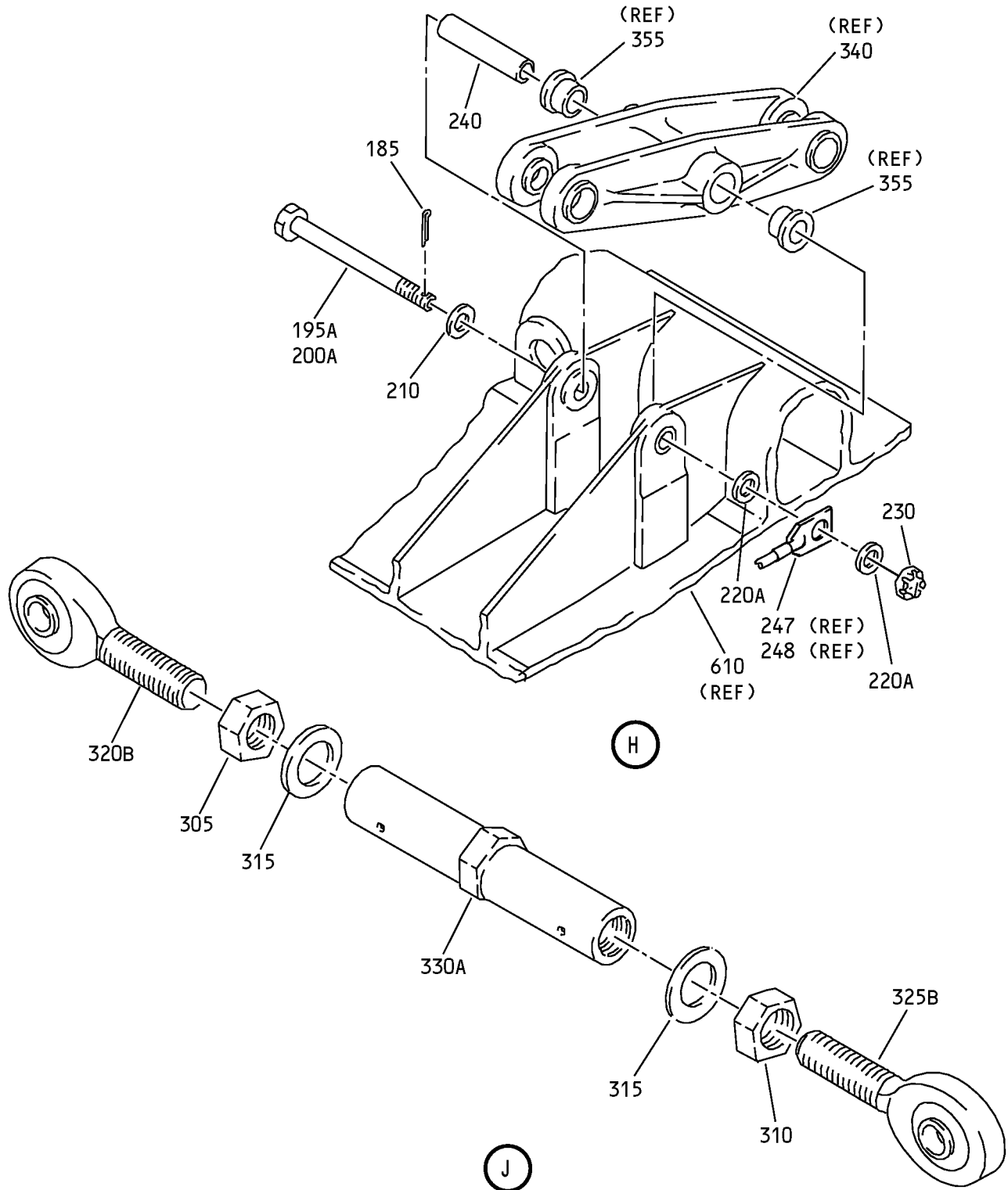
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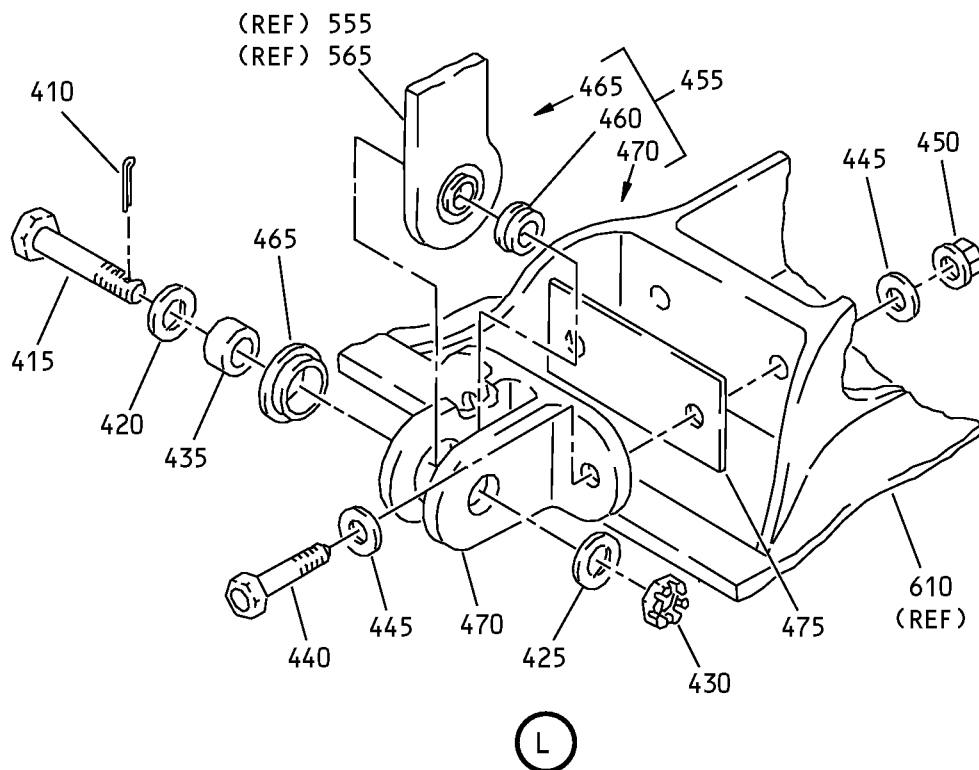
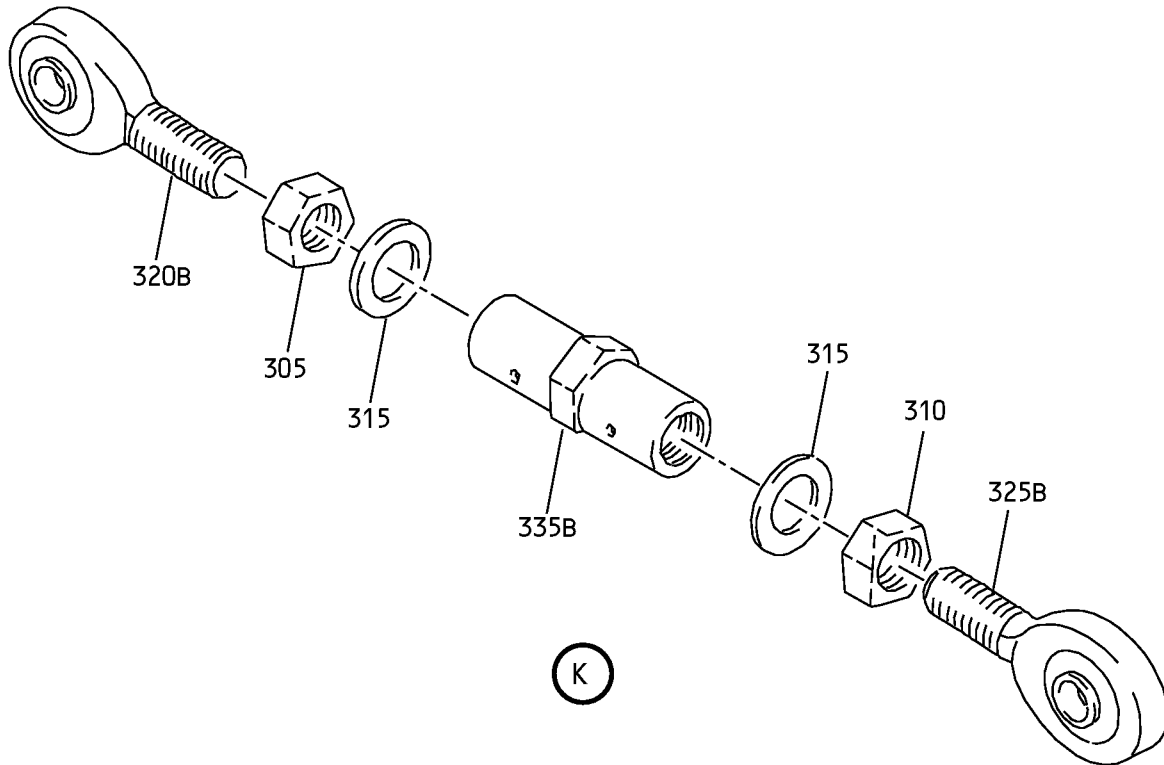
Krueger Flap and Bullnose Assemblies No. 2 and 3  
IPL Figure 1 (Sheet 6 of 12)

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**COMPONENT MAINTENANCE MANUAL**

Krueger Flap and Bullnose Assemblies No. 2 and 3  
IPL Figure 1 (Sheet 7 of 12)

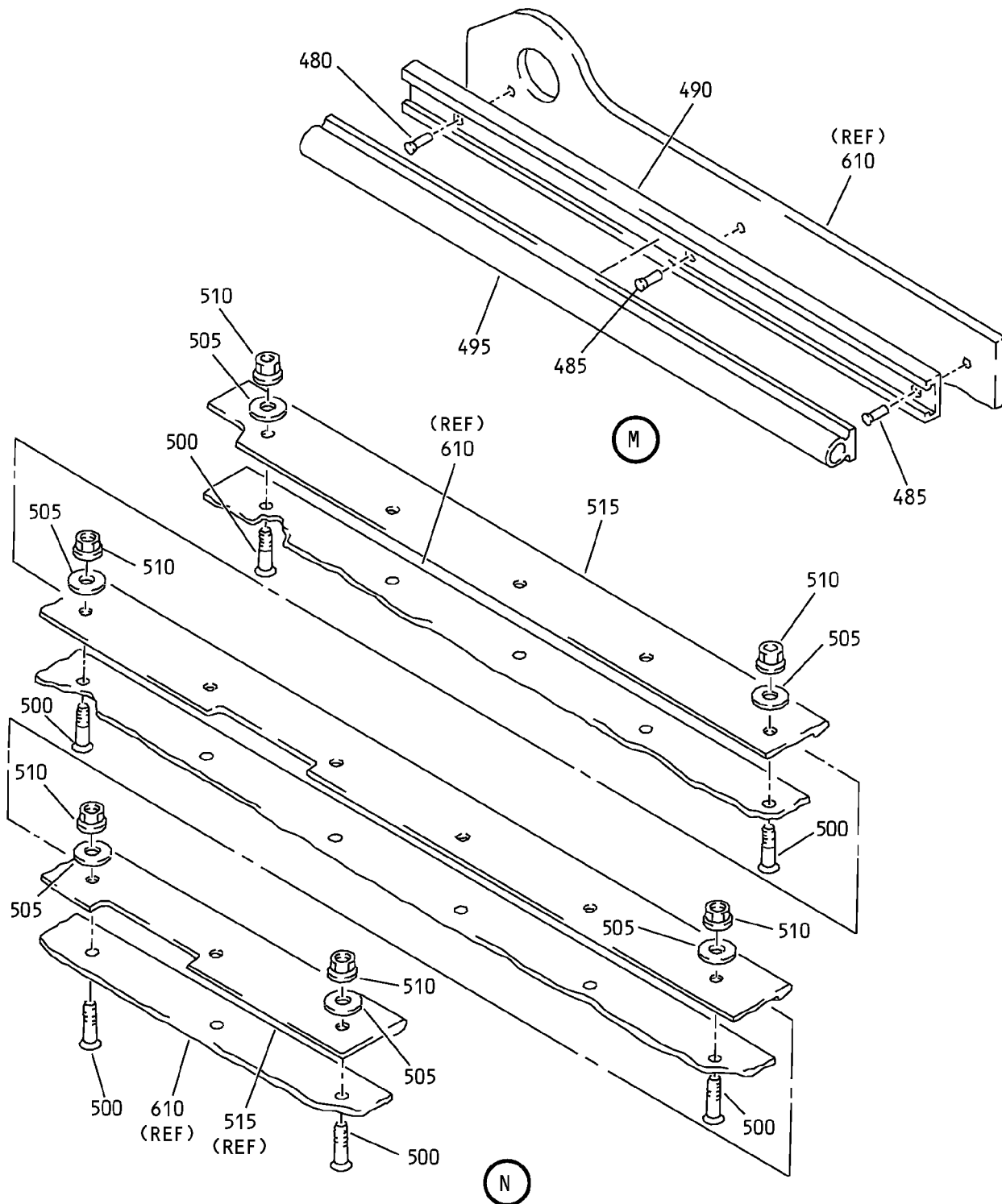
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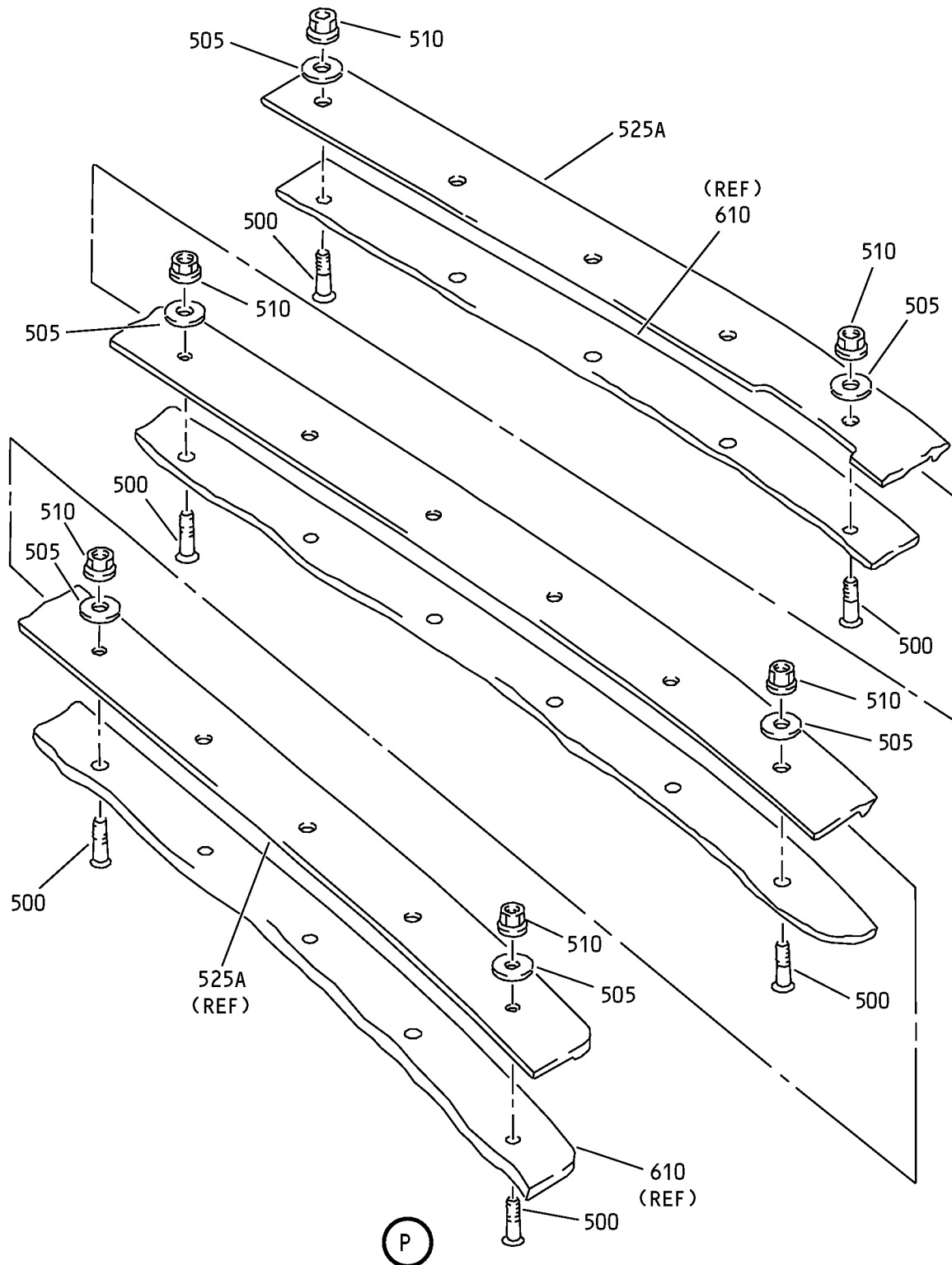
Krueger Flap and Bullnose Assemblies No. 2 and 3  
IPL Figure 1 (Sheet 8 of 12)

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**COMPONENT MAINTENANCE MANUAL**

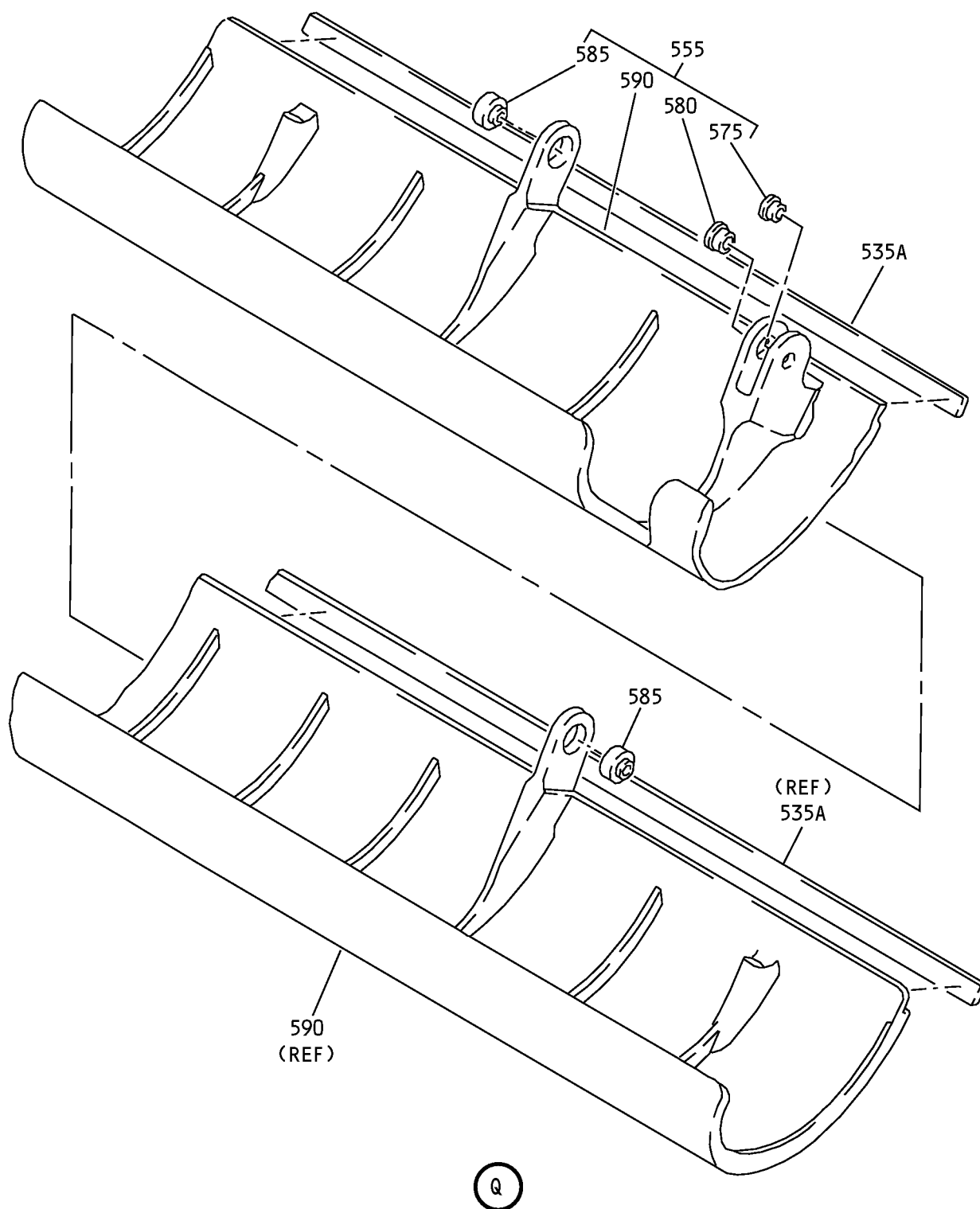
Krueger Flap and Bullnose Assemblies No. 2 and 3  
IPL Figure 1 (Sheet 9 of 12)

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**COMPONENT MAINTENANCE MANUAL**

Krueger Flap and Bullnose Assemblies No. 2 and 3  
IPL Figure 1 (Sheet 10 of 12)

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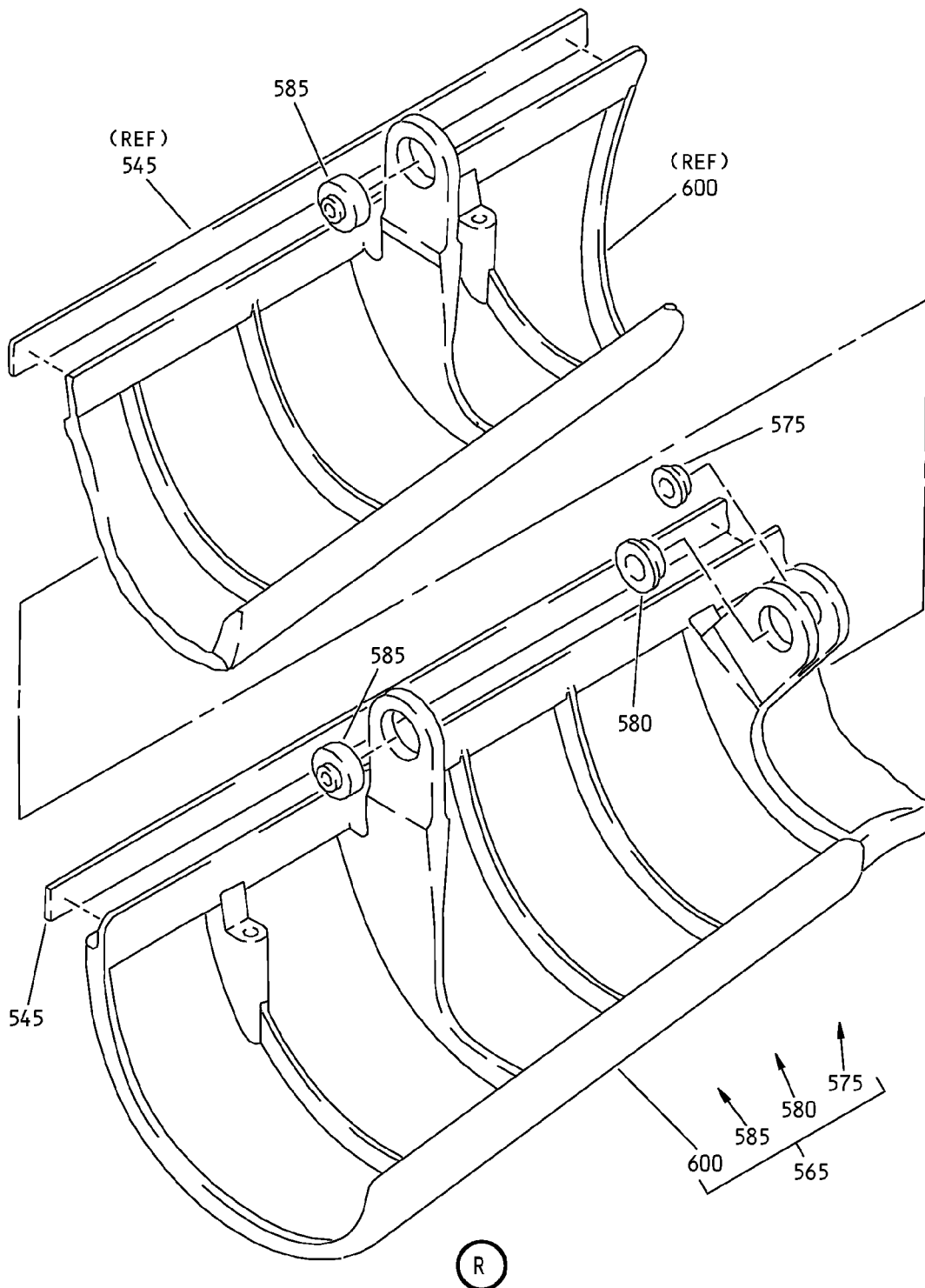
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Krueger Flap and Bullnose Assemblies No. 2 and 3  
IPL Figure 1 (Sheet 11 of 12)

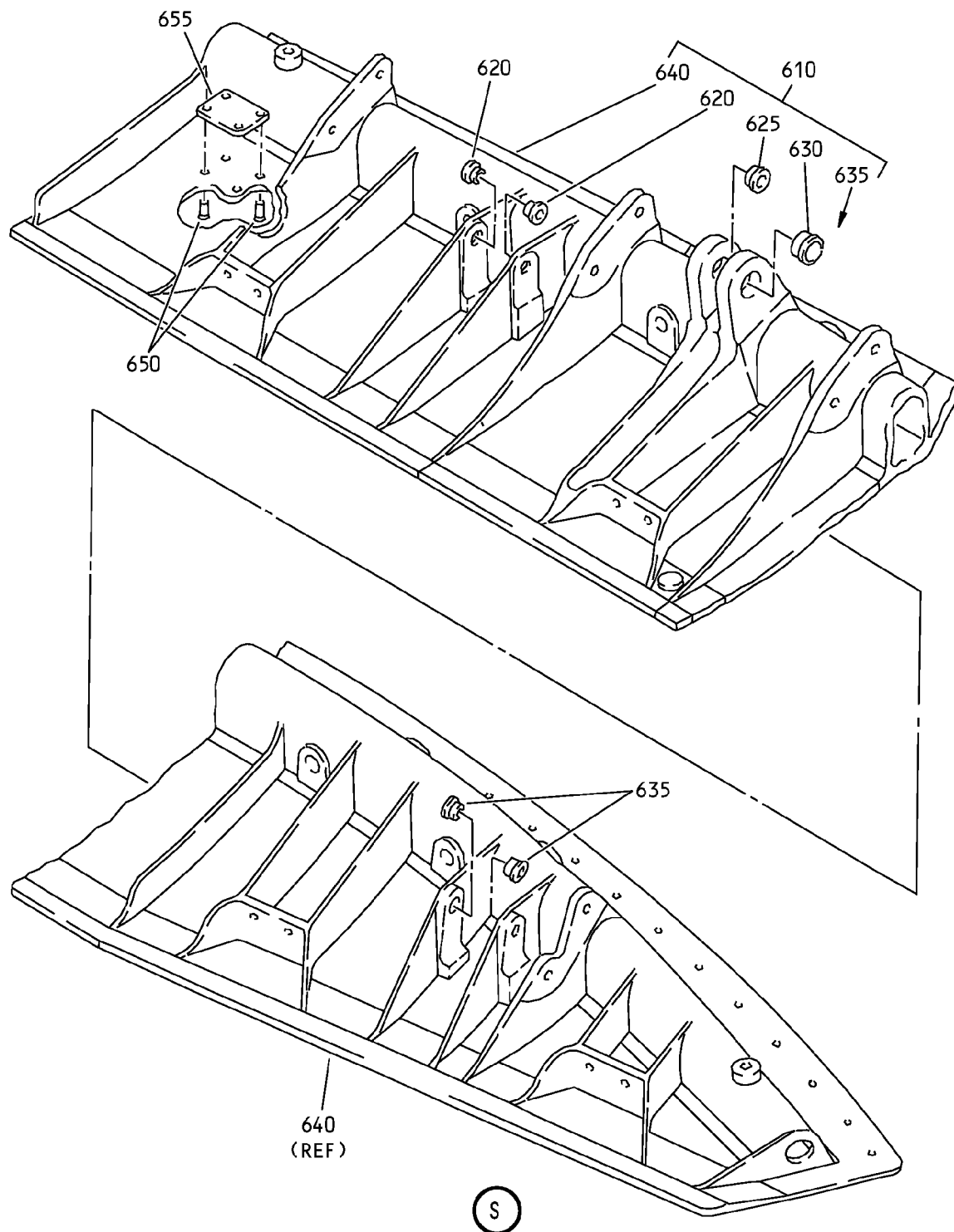
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Krueger Flap and Bullnose Assemblies No. 2 and 3  
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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1-					
-1A	114A1220-1		DELETED		
-1B	114A1220-5		FLAP AND BULLNOSE ASSY-NO. 2 AND NO. 3	A	RF
-1C	114A1220-7		FLAP AND BULLNOSE ASSY-NO. 2 AND NO. 3	C	RF
-1D	114A1220-9		FLAP AND BULLNOSE ASSY-NO. 2 AND NO. 3	E	RF
-1E	114A1220-201		FLAP AND BULLNOSE ASSY-NO. 2 AND NO. 3	G	RF
-1F	114A1220-11		FLAP AND BULLNOSE ASSY-NO. 2 AND NO. 3	J	RF
-1G	114A1220-203		FLAP AND BULLNOSE ASSY-NO. 2 AND NO. 3	L	RF
-5	114A1220-2		DELETED		
-5A	114A1220-6		FLAP AND BULLNOSE ASSY-NO. 2 AND NO. 3	B	RF
-5B	114A1220-8		FLAP AND BULLNOSE ASSY-NO. 2 AND NO. 3	D	RF
-5C	114A1220-10		FLAP AND BULLNOSE ASSY-NO. 2 AND NO. 3	F	RF
-5D	114A1220-202		FLAP AND BULLNOSE ASSY-NO. 2 AND NO. 3	H	RF
-5E	114A1220-12		FLAP AND BULLNOSE ASSY-NO. 2 AND NO. 3	K	RF
-5F	114A1220-204		FLAP AND BULLNOSE ASSY-NO. 2 AND NO. 3	M	RF
10	BACB30NR5K11		. BOLT		4
15	NAS1149E0532R		. WASHER		8
20	H52732-5CD		. NUT (V15653) (SPEC BACN10YR5CD) (OPT PLH55CD (V62554))		4
25	114A1720-1		. HINGE ASSY-NO. 5	A	1
-25A	114A1720-3		. HINGE ASSY-NO. 5	C, E, G, J, L	1
-30	114A1720-2		. HINGE ASSY-NO. 5	B	1

-Item not Illustrated

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## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
–30A	114A1720-4		. HINGE ASSY-NO. 5	D, F, H, K, M	1
35	NAS1399CW4A		. . RIVET (SIZE DETERMINED ON INST)		2
40	114A1817-1		. . TARGET		1
45	BACR15GF5D		. . RIVET (SIZE DETERMINED ON INST)		2
50	114A1816-1		. . BLOCK		1
55	114A1815-3		. . BRACKET	A, C	1
–60	114A1815-4		. . BRACKET	B, D	1
65	BACR15FT5D		. . RIVET (SIZE DETERMINED ON INST)		1
70	NAS1399CW5A		. . RIVET (SIZE DETERMINED ON INST)		1
75	BACW10P183AL		. . WASHER		1
80	114A1817-5		. . TARGET		1
85	114A1816-3		. . BLOCK	A, B	1
–85A	114A1816-9		. . BLOCK	C-M	1
90	114A1725-1		. . FITTING ASSY		1
95	03-835-07E001		. . . BEARING (V09455) (SPEC BACB10GD07G) (OPT NC07TG14 (V56644)) (OPT HTLGD07V (VS0352)) (OPT AKBL07V04003 (V15860)) (OPT NEE07GDG (V73134))		1
100	114A1725-3		. . . FITTING		1
105	114A1728-1		. FITTING ASSY-NO. 8		1
110	03-836-07E001		. . BEARING (V09455) (SPEC BACB10GC07G) (OPT WHTLGC07V (VS0352)) (OPT WC07TG14 (V56644)) (OPT AKWL07V4003 (V15860)) (OPT SWKR07-419S (V81376)) (OPT WEE07GCG (V73134))		1
115	114A1728-3		. . FITTING-HINGE		1
120	114A1701-7		. SHIM-LAMINATED		4

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## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
125	BACB30NR6K12		. BOLT		3
130	BACB30NR6K14		. BOLT		1
135	NAS1149E0632R		. WASHER		9
140	H52732-6CD		. NUT (V15653) (SPEC BACN10YR6CD) (OPT PLH56CD (V62554))		4
145	100224-7		. JUMPER (V1FF12) (SPEC BACJ40AB24-7) (OPT RBEJ40AB24-7 (V1GK47)) (OPT 940CW24-7 (V91812))		1
150	114A1726-1		. FITTING ASSY-NO. 6	A-D	1
–150A	114A1726-5		. FITTING ASSY-NO. 6	E-M	1
155	114A1727-1		. FITTING ASSY-NO. 7		1
160	WHTFA08V		. . BEARING (VS0352) (SPEC BACB10FA08G) (OPT WES08FAG (V73134)) (OPT KWDB08-33 (V97613)) (OPT KSC152200BZ08G (V50632)) (OPT ADW07V301NZ08G (V15860)) (OPT SWKRS08-350S (V81376))		1
165	114A1726-3		. . FITTING-HINGE (USED ON ITEM 150)	A-D	1
–165A	114A1726-7		. . FITTING-HINGE	E-M	1
170	114A1727-3		. . FITTING-HINGE (USED ON ITEM 155)		1
175	114A1701-9		. SHIM-LAMINATED		2
180	114A1701-11		. SHIM-LAMINATED		2
185	BACP18BC02A06P		. PIN-COTTER		2
190	BACP18BC02A04P		. PIN-COTTER		2
–195	BACB30NR5DK49		DELETED		
195A	BACB30NR5DK50		. BOLT		1
–200	BACB30NR5DK54		DELETED		
200A	BACB30NR5DK55		. BOLT		1
–205	BACB30NR4DK16		DELETED		

–Item not Illustrated

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## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
205A	BACB30NR4DK17		. BOLT		2
210	BACW10BP5ACU		. WASHER		2
215	BACW10BP4ACU		. WASHER		2
–220	BACW10BP5APU		DELETED		
220A	NAS1149D0532H		. WASHER		4
–225	BACW10BP4APU		DELETED		
225A	NAS1149D0432H		. WASHER		4
230	BACN10JD5CD		. NUT		2
235	BACN10JD104CD		. NUT		2
240	BACB28AK05-212		. BUSHING		2
245	BACB28AK04-034		. BUSHING		2
247	940CW27-8		. JUMPER ASSY (V91812) (SPEC BACJ40AB27-8) (OPT 100227-8 (V1FF12)) (OPT RBEJ40AB27-8 (V1GK47))		1
248	940CW27-6		. JUMPER ASSY (V91812) (SPEC BACJ40AB27-6) (OPT 100227-6 (V1FF12)) (OPT RBEJ40AB27-6 (V1GK47))		1
–250	114A1420-1		DELETED		
250A	114A1420-3		. LINK ASSY-MID BULLNOSE		1
–255	114A1430-1		DELETED		
255A	114A1430-3		. LINK ASSY-INBD BULLNOSE	A	1
–255B	114A1430-5		. LINK ASSY-INBD BULLNOSE	C, E, G, J, L	1
–260	114A1430-2		DELETED		
–260A	114A1430-4		. LINK ASSY-INBD BULLNOSE	B	1
–260B	114A1430-6		. LINK ASSY-INBD BULLNOSE	D, F, H, K, M	1
265	BACP18BC02A04P		. . PIN-COTTER		2
270	BACB30NR4DK18		. . BOLT		2
275	BACW10BP4ACU		. . WASHER		2
280	BACW10BP4APU		. . WASHER		2

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1–					
285	BACN10JD104CD		. . NUT		2
290	BACB28AK04-041		. . BUSHING		2
–295	114A1401-3		DELETED		
295A	114A1401-9		. . ROD ASSY (USED ON ITEM 250A)		1
–300	114A1401-5		DELETED		
300A	114A1401-11		. . ROD ASSY (USED ON ITEMS 255A, 255B, 260A, 260B)		1
305	NAS509L6C		. . . NUT		1
310	NAS509-6C		. . . NUT		1
315	BACW10BP6NAPU		. . . WASHER		2
–320	S012T235-104-89		DELETED		
–320A	S012T238-104-89		DELETED		
320B	ADNEL4-334N9		. . . BEARING-ROD END (V15860) (OPT ITEM 320C) (SPEC S012T235-104-89) (OPT MSSESL04FBDF (V73134))		1
–320C	KSR174004B		. . . BEARING-ROD END (V50632) (OPT ITEM 320B) (SPEC S012T238-104-89)		1
–325	ARNM4-101M		DELETED		
–325A	S012T238-104-9		DELETED		
325B	ADNE4-334N9		. . . BEARING-ROD END (V15860) (SPEC S012T235-104-9) (OPT ADNE4-334N (V15860)) (OPT ARNM4-101 (VS0352)) (OPT MSSE104FB (V73134)) (OPT MSSES04FBDF (V73134)) (OPT MSSRRS04FB (V73134)) (OPT ITEM 325C)		1
–325C	KRS173904B		. . . BEARING-ROD END (V50632) (SPEC S012T238-104-9) (OPT ITEM 325B)		1
330	114A1402-3		DELETED		

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1–					
330A	114A1402-9		. . . ROD (USED ON ITEM 295A)		1
335	114A1402-5		DELETED		
335A	114A1402-11		. . . ROD (USED ON ITEM 300A)		1
340	114A1413-1		. . BELLCRANK ASSY		1
345	BACB28AP04P025		. . . BUSHING		2
350	BACB28AT06B025C		. . . BUSHING		2
355	BACB28AV07B040A		. . . BUSHING		2
360	114A1413-2		. . . BELLCRANK		1
365	114A1411-1		. . LINK ASSY (USED ON ITEM 250A)		1
370	114A1424-1		. . LINK ASSY (USED ON ITEM 255A)	A	1
–370A	114A1424-5		. . LINK ASSY (USED ON ITEM 255B)	C, E, G, J, L	1
–375	114A1424-2		. . LINK ASSY (USED ON ITEM 260A)	B	1
–375A	114A1424-6		. . LINK ASSY (USED ON ITEM 260B)	D, F, H, K, M	1
380	ADB04V301NC		. . . BEARING (V15860) (SPEC BACB10FB04GC) (OPT KNDB04-70 (V97613)) (OPT KSC145700BZ04GC (V50632)) (OPT NES04FBGC (V73134)) (OPT HTFB04GC (VS0352)) (USED ON ITEM 365)		1
385	HTES04C		. . . BEARING (VS0352) (SPEC BACB10ES04C) (OPT NC04T5C (V56644)) (OPT SWKN04520C (V81376)) (USED ON ITEMS 370, 370A, 375, 375A)		1
390	KSC272604V		. . . BEARING (V50632)		1

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1–					
395	114A1411-2		. . . LINK (USED ON ITEM 365)		1
400	114A1424-3		. . . LINK (USED ON ITEM 370)	A	1
–400A	114A1424-7		. . . LINK (USED ON ITEM 370A)	C, E, G, J, L	1
–405	114A1424-4		. . . LINK (USED ON ITEM 375)	B	1
–405A	114A1424-8		. . . LINK (USED ON ITEM 375A)	D, F, H, K, M	1
410	BACP18BC02A04P		. PIN-COTTER		4
415	BACB30NR4DK14		. BOLT		4
420	BACW10BP4ACU		. WASHER		4
425	BACW10BP4APU		. WASHER		4
430	BACN10JD104CD		. NUT		4
435	BACB28AK04-029		. BUSHING		4
440	BACB30NR4K9		. BOLT		8
445	NAS1149D0432J		. WASHER		16
450	H52732-4CD		. NUT (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))		8
455	114A1201-1		. CLEVIS ASSY		4
460	BACB28AP04P011		. . BUSHING		1
465	BACB28AT06B011C		. . BUSHING		1
470	114A1201-3		. . CLEVIS		1
475	BACS40R010C026F		. SHIM		4
480	NAS1399D5A		. RIVET (SIZE DETERMINED ON INST)		1
485	BACR15GF5D		. RIVET (SIZE DETERMINED ON INST)		2
490	114A1803-1		. RETAINER-SEAL		1
495	114A1802-1		. SEAL-BULB (MAKE FROM EXTR RUBBER 10-60754-2 11.8)		1

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			1	2	3	4	5	6	7			
1–												
500	BACB30VF3K3		.	B	O	L	T				30	
505	NAS1149E0332P		.	W	A	S	H	E	R		30	
510	H52732-3CD		.	N	U	T					30	
				(V15653)								
				(SPEC BACN10YR3CD)								
				(OPT PLH53CD (V62554))								
515	114A1801-3		.	S	E	A	L	-	S	P	A	1
				(MAKE FROM SYNTHETIC RUBBER								
				10-60754-1175 X 33.0)								
–515A	114A1801-3		.	S	E	A	L	-	S	P	A	1
				(MAKE FROM SYNTHETIC RUBBER								
				10-60754-1175 X 33.0)								
				(OPT ITEM 515B)								
–515B	114A1801-11		.	S	E	A	L	-	S	P	A	1
				(MAKE FROM SYNTHETIC RUBBER								
				10-60754-1175 X AS REQUIRE)								
				(OPT ITEM 515A)								
–520	114A1801-4		.	S	E	A	L	-	S	P	A	1
				(MAKE FROM SYNTHETIC RUBBER								
				10-60754-1175 X 33.0)								
–520A	114A1801-4		.	S	E	A	L	-	S	P	A	1
				(MAKE FROM SYNTHETIC RUBBER								
				10-60754-1175 X 33.0)								
				(OPT ITEM 520B)								
–520B	114A1801-12		.	S	E	A	L	-	S	P	A	1
				(MAKE FROM SYNTHETIC RUBBER								
				10-60754-1175 X AS REQUIRE)								
				(OPT ITEM 520A)								
525	114A1801-5			D	E	L	E	T	E	D		
525A	114A1801-7		.	S	E	A	L	-	S	P	A	1
				(MAKE FROM SYNTHETIC RUBBER								
				10-60754-1175 X AS REQUIRE)								
–530	114A1801-6			D	E	L	E	T	E	D		
–530A	114A1801-8		.	S	E	A	L	-	S	P	A	1
				(MAKE FROM SYNTHETIC RUBBER								
				10-60754-1175 X AS REQUIRE)								
–535	114A1804-3			D	E	L	E	T	E	D		
535A	114A1804-4		.	S	T	R	I	P	-	R	U	1
–540	114A1804-4			D	E	L	E	T	E	D		

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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—											
—540A	114A1804-3		.	STRIP-RUB						B, D, F, H, K, M	1
545	114A1804-5		.	STRIP-RUB						A, C, E, G, J, L	1
—550	114A1804-6		.	STRIP-RUB						B, D, F, H, K, M	1
555	114A1320-1		.	BULLNOSE ASSY-MID						A, C, E, G, J, L	1
—560	114A1320-2		.	BULLNOSE ASSY-MID						B, D, F, H, K, M	1
565	114A1321-1		.	BULLNOSE ASSY-INBD						A, C, E, G, J, L	1
—570	114A1321-2		.	BULLNOSE ASSY-INBD						B, D, F, H, K, M	1
575	BACB28AP04P019		.	BUSHING							1
580	BACB28AT06B019C		.	BUSHING							1
585	ADB04V301NC		.	BEARING (V15860) (SPEC BACB10FB04GC) (OPT KNDB04-70 (V97613)) (OPT KSC145700BZ04GC (V50632)) (OPT NES04FBGC (V73134)) (OPT HTFB04GC (VS0352))							2
590	114A1320-3		.	CASTING (USED ON ITEM 555)						A, C, E, G, J, L	1
—595	114A1320-4		.	CASTING (USED ON ITEM 560)						B, D, F, H, K, M	1
600	114A1321-3		.	CASTING (USED ON ITEM 565)						A, C, E, G, J, L	1
—605	114A1321-4		.	CASTING (USED ON ITEM 570)						B, D, F, H, K, M	1
610	114A1221-1		.	FLAP ASSY-INBD KRUEGER FLAP						A, C, E, J	1
—610A	114A1221-201		.	FLAP ASSY-INBD KRUEGER FLAP						G, L	1
—615	114A1221-2		.	FLAP ASSY-INBD KRUEGER FLAP						B, D, F, K	1
—615A	114A1221-202		.	FLAP ASSY-INBD KRUEGER FLAP						H, M	1
620	BACB28AA5B033		.	BUSHING							2
625	BACB28AP10P058		.	BUSHING							1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1—					
630	BACB28AT14B058C		. . BUSHING		1
635	BACB28AA5B048		. . BUSHING		2
640	114A1221-3		. . FLAP	A, C, E, J	1
—640A	114A1221-203		. . FLAP	G, L	1
—645	114A1221-4		. . FLAP	B, D, F, K	1
—645A	114A1221-204		. . FLAP	H, M	1
650	NAS1399B4A2		. RIVET		4
655	MS27253-1		. PLATE-IDENT		1

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