COMPONENT MAINTENANCE MANUAL WITH ILLUSTRATED PARTS LIST

OUTBOARD SPOILER PANEL ASSEMBLY

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COMPONENT MAINTENANCE MANUAL

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To: All holders of OUTBOARD SPOILER PANEL ASSEMBLY 57-56-52.

Attached is the current revision to this COMPONENT MAINTENANCE MANUAL

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57-56-52 TRANSMITTAL LETTER		501	Mar 01/2006		
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1	Mar 01/2006	1002	Jul 01/2006		
2	BLANK	1003	Mar 01/2006		
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101	Mar 01/2006	1005	Mar 01/2006		
102	BLANK	1006	Mar 01/2006		
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A = Added, R = Revised, D = Deleted, O = Overflow

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TEMPORARY REVISION AND SERVICE BULLETIN RECORD

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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.

Revision		Filed	
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INTRODUCTION

1. General

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

B. This manual is divided into different parts:

(1) Title Page

(2) Transmittal Letter

(3) Highlights

(4) List of Effective Pages

(5) Table of Contents

(6) Temporary Revision & Service Bulletin Record

(7) Record of Revisions

(8) Record of Temporary Revisions

(9) Introduction

(10) Procedures & IPL Sections

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

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

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

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

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

OUTBOARD SPOILER PANELS ASSEMBLY - DESCRIPTION AND OPERATION

1. Description and Operation

A. Description

(1) The flight and ground spoilers are composed of a graphite/epoxy prepreg fabric bonded assembly. The four spoilers are attached to the rear spar of each wing with three aluminum alloy fittings. One of these fittings is a combination actuator and hinge fitting, and two are eccentric hinges. The assemblies are recessed into the upper surface of the wing, outboard of the nacelle.

B. Operation

(1) The flight spoiler is used, along with the ground spoiler, when the airplane is being operated on the ground, and without the ground spoiler during flight. They are operated hydraulically in conjunction with the speed brake to assist in stabilizing the airplane and braking speed.

2. Leading Particulars (approximate)

A. Length – 52 inches

B. Width – 20 inches

C. Thickness – 2 inches

D. Weight – 16 pounds

COMPONENT MAINTENANCE MANUAL

TESTING AND FAULT ISOLATION

(NOT APPLICABLE)

DISASSEMBLY

1. **General**

   A. This section contains the data necessary to disassemble the outboard spoiler panels assembly.

   B. Use standard industry practices for disassembly of this component, and additional procedures in the following steps.

   C. Disassemble this component only as necessary to complete fault isolation, determine serviceability of parts, perform required repairs, and restore the unit to serviceable condition.

2. **Disassembly**

   A. Note and record thickness of laminated shims (60, 65, IPL Figure 1) for reference during assembly.

   B. Hinge fitting (114) is both mechanically fastened and structurally bonded as an integral part of the panel assembly (240). If necessary maintenance cannot be accomplished in place, use care to prevent delamination or other damage to the graphite/epoxy structure or honeycomb.

   C. Remove rub strip (245) by scraping off with a sharp-edged wooden or plastic tool.

   D. Hinge fitting (43) and shims (60, 65) are separated from the panel assembly by removing bolts (10, 30) common to the panel assembly (240) and three rivets (40) common to the clips (50, 55).

      NOTE: Clips (50, 55) need not be removed unless replacement is necessary. If removal is necessary, use care to prevent delamination or other damage to the graphite/epoxy structure or honeycomb.

CLEANING

1. General

A. This section contains the data necessary to clean the outboard spoiler panel assembly.

B. Use standard industry practices for cleaning of this component.

2. Cleaning

A. References

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

B. Cleaning procedures

CAUTION: DO NOT VAPOR DEGREASE EPOXY BONDED STRUCTURES WITH CHLORINATED CLEANING AGENTS SUCH AS METHYLENE CHLORIDE, TRICHLOROETHYLENE, AND TRICHLOROETHANE. CHLORINATED CLEANING AGENTS WILL CAUSE DAMAGE TO EPOXY BONDED STRUCTURES. 1,1,1-TRICHLOROETHANE IS ONE OF THE SOLVENTS ALLOWED FOR CLEANING COMPOSITE COMPONENTS. DO NOT SUBMERGE PARTS IN THE SOLVENT OR ALLOW STANDING SOLVENT ON THE PARTS OR DAMAGE MAY OCCUR. USE 1,1, 1-TRICHLOROETHANE ONLY AS A WIPE SOLVENT.

(1) Clean all parts except bearings using standard industry practices and the instructions in SOPM 20-30-03.

(2) Clean bearings per SOPM 20-30-01.

CHECK

1. General

A. This section contains the data necessary to check the outboard spoiler panel assembly.

B. Use standard industry practices to check this component.

2. Check

A. References

Reference	Title
SOPM 20-20-02	PENETRANT METHODS OF INSPECTION
737 NDT Chapter 57	Non-Destructive Testing
737 NDT Part 1, 51-01-01	Inspection of Repairs to Composite Structure
737 NDT Part 9, 51-00-01	Non-Destructive Testing

B. Procedures

(1) Check all parts for obvious defects using standard industry practices. If you find visible defects or suspect possible defects, do a magnetic particle or penetrant check as specified below.

(2) Penetrant check the following parts per SOPM 20-20-02 (IPL Figure 1).

(a) Fittings (43, 114)

(3) Do a check of the honeycomb structure:

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

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

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

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

(5) Check assembly components for nicks, scratches, and corrosion. Refer to the applicable 737 NDT Chapter 57 for allowable repair limits and data.

(6) Refer to FITS AND CLEARANCES for allowable wear data and assembly clearances.

REPAIR

1. Content

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

Table 601:

P/N	NAME	REPAIR
65C25256	HINGE FITTINGS - CENTER, FLIGHT SPOILER	1-1
65C25252	PANEL BOND ASSEMBLY, OUTBOARD SPOILER	2-1
- - -	MISCELLANEOUS PARTS REFINISH	3-1

2. Standard Practices

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

- SOPM 20-20-02 Penetrant Methods of Inspection
- SOPM 20-30-01 Cleaning and Relubricating Antifriction Bearings
- SOPM 20-30-02 Stripping of Protective Finishes
- SOPM 20-30-03 General Cleaning Procedures
- SOPM 20-30-83 Solvents for General Cleaning of Composites (Series 83)
- SOPM 20-41-01 Decoding Table for Boeing Finish Codes
- SOPM 20-41-02 Application of Chemical and Solvent Resistant Finishes
- SOPM 20-43-01 Chromic Acid Anodizing
- SOPM 20-50-03 Bearing and Bushing Replacement
- SOPM 20-50-07 Lubrication
- SOPM 20-60-02 Finishing Materials
- SOPM 20-60-04 Miscellaneous Materials

3. Materials

NOTE: Equivalent substitutes can be used.

A. Enamel - coating, C00700 BMS 10-60, BAC707 gray gloss

B. Primers

(1) BMS 5-89, Corrosion Inhibiting Adhesive Primer adhesive, A00195

(2) BMS 10-11, Type 1 primer, C00259

(3) BMS 10-79, Type 2 primer, C00319

C. Sealants

(1) BMS 5-95 sealant, A00247

(2) BMS 5-95, Type B adhesive, A01076

D. Static Conditioner - Magna 28C1 conditioner filler, C00058

E. Surfacers

(1) Epocast 156 surfacer, A50098

(2) Dexter 8-W-5 surfacer, A50099

F. Potting Compound -

(1) Adhesive Type 71 adhesive, A00279

(2) BMS 5-123, Type 1, Class 2 adhesive, A50038

G. Solvent - Series 83 solvent, B01003

HINGE FITTING - CENTER, FLIGHT SPOILER - REPAIR 1-1

65C25256–2

1. General

A. This section contains the data necessary to repair the hinge fitting.

B. Refer to REPAIR-GENERAL, Paragraph 2. for list of applicable standard practices.

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

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

2. Repair Procedure

A. Bushing (125) Replacement (IPL Figure 1)

(1) Remove bushing from the fitting (114).

(2) Install bushings by press fit per SOPM 20-50-03, except use wet sealant, A00247

(3) Fillet seal bushing flanges using sealant, A00247.

B. Bearing (115) Replacement (IPL Figure 1)

(1) Remove snap ring (120) and bearing from fitting (114).

(2) Install bearing by press fit.

NOTE: No adhesive primer or sealant is to be used.

(3) Apply light coating of grease per SOPM 20-30-01 and SOPM 20-50-07 after installation.

(4) Install snap ring (120).

(5) Verify breakaway torque does not exceed 20 pound-inch as measured per SOPM 20-50-03. Outer race must not rotate in fitting.

C. Refinishing

(1) Fitting (114) – Phosphoric acid anodize (F-20.31). Apply adhesive, A00195 prior to bonding (F-20.26).

PANEL BOND ASSEMBLY, OUTBOARD SPOILER - REPAIR 2-1

65C25252–10

1. General

A. This section contains the data necessary to repair the panel bond assembly.

B. Refer to REPAIR-GENERAL, Paragraph 2. for list of applicable standard practices.

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

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

2. Procedures

A. Repair

(1) For structural repair to damaged plies or honeycomb of the graphite/epoxy panel, refer to 737 SRM 57-70-00.

B. Refinish

(1) Top Surface (Air Passage) – Prepare the surface (SRF-14.672). Apply primer, C00319 (F-19.46).

(2) Lower Surface – Prepare the surface (F-14.67). Apply primer, C00319 (F-19.46).

C. Replacement (IPL Figure 1)

(1) Rub Strip (245)

(a) Remove the old rub strip with a sharp edged wooden or plastic tool.

(b) Bond a replacement strip to the panel bond assembly with Type 93 adhesive, A01076 per SOPM 20-50-12.

NOTE: The rub strip has no finish. Bond it on before you refinish the panel.

(2) Fabric seals (150, 155, 193, 205, 210, 215, 220, 230, 235) – Replace by standard industry practices.

(3) Inserts (190)

(a) Remove the bad or loose insert(s).

(b) Enlarge the hole diameter to 1.7-1.9 times the maximum diameter of the insert. For repairs larger then this, refer to 737 SRM 57-70-00.

(c) Remove loose particles, and the dust, from the hole by vacuum or blow them out with clean, dry air below 30 psi.

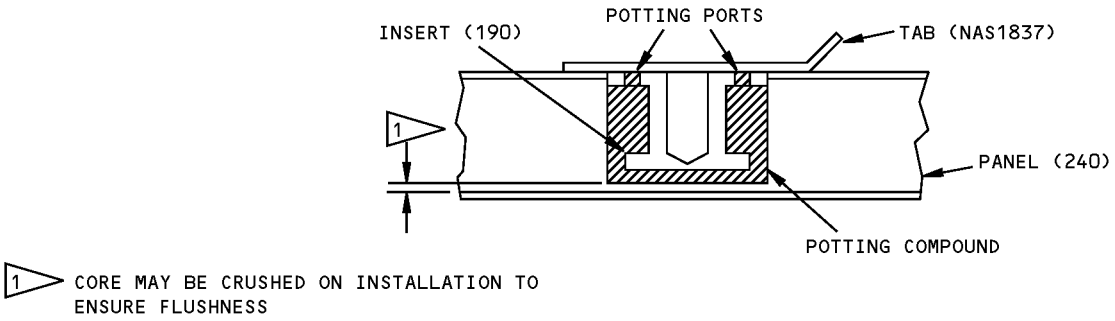
(d) Fill the hole to 60-90 percent of its capacity with adhesive, A50038 .

(e) Install the replacement insert into the prepared hole as shown in REPAIR 2-1, Figure 601.

(f) Remove unwanted potting material with a wiper with a Series 83 solvent, B01003.

(g) Let this cure for 20-40 minutes at 65-100°F.

(h) Remove alignment tabs, protective tapes, etc.



Blind Insert Installation
Figure 601

MISCELLANEOUS PARTS REFINISH - REPAIR 3-1

1. General

A. This section contains the data necessary to refinish the miscellaneous parts.

B. Refer to REPAIR-GENERAL, Paragraph 2. for list of applicable standard practices.

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

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

2. Repair Procedures

A. Repair of these parts is only replacement of the original finish.

Table 601: Refinish Details

IPL FIG. & ITEM	MATERIAL	FINISH
Panel Assy, Inboard Spoiler (1,2,3)	Graphite/Epoxy	Apply enamel primer, C00319 (F-14.9863-xxxx) on all surfaces in the customer color, but not to bushings, bearings or fabric seals.
Fitting (43)	Al Alloy	Chromic acid anodize (F-17.04). Apply coating, C00921 (F-19.46). Apply enamel coating, C00700 (SRF-14.9813), but not in the slot.
Clips (50,55)	Al Alloy	Chromic acid anodize and apply primer, C00259 (F-18.13). Apply enamel coating, C00700 (SRF-14.9813).

ASSEMBLY

1. General

A. This section contains the data necessary to assemble the outboard spoiler panels assembly.

B. Refer to REPAIR-GENERAL, Paragraph 2. for list of applicable standard practices.

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

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

2. Assembly

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95
A01076	Adhesive - Synthetic Rubber	BAC5010, Type 93 (BMS5-95, Class B)

B. References

Reference	Title
SOPM 20-50-12	APPLICATION OF ADHESIVES

C. Assembly Procedures

(1) Use standard industry practices for the assembly of this component and the following additional procedures.

(2) Delaminate shims (60, 65, IPL Figure 1) by removing 0.003 inch thick laminations as required for assembly. Shim all gaps greater than 0.005 inch.

(3) Align centerlines of both slotted fittings (43) with center fitting hinge (114) centerline within 0.020 inch.

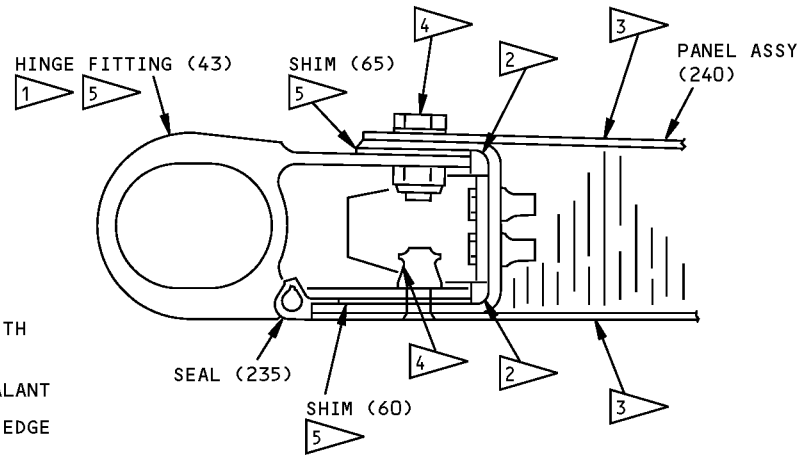
(4) Apply sealant, A00247 to fitting (43) faying surfaces in accordance with ASSEMBLY, Figure 701.

(5) Install all fasteners wet and fillet seal collars with sealant, A00247, except this requirement does not apply to fasteners attaching rubber seals.

(6) Fasteners on air passage skin surface to be installed flush to within plus 0.003 inch, minus 0.010 inch.

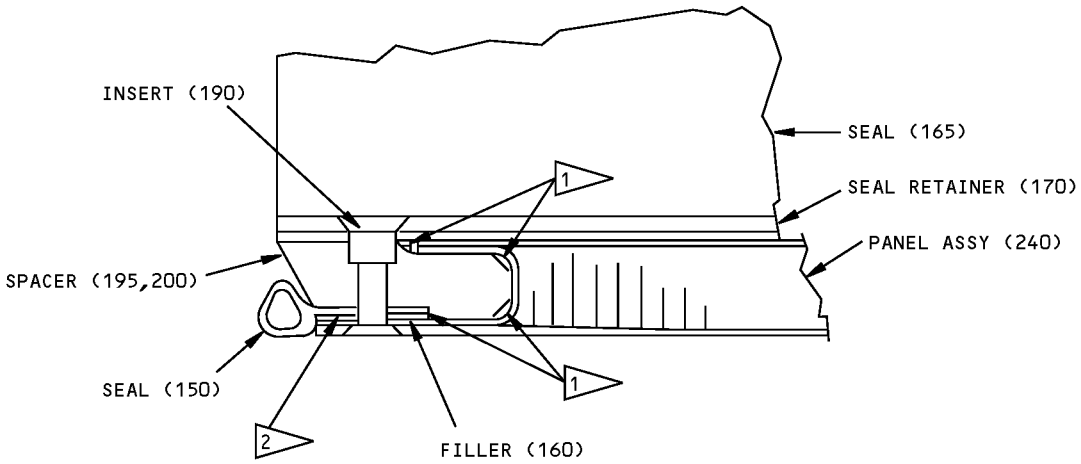
(7) Bond filler (160) to panel assembly (240) using sealant, A00247 per SOPM 20-50-12 (adhesive, A01076), as shown in ASSEMBLY, Figure 701. Allow bond to cure before installing spacer (195, 200).

(8) Prepack cavity with sealant, A00247 and install spacer (195, 200) while wet as shown in ASSEMBLY, Figure 701.



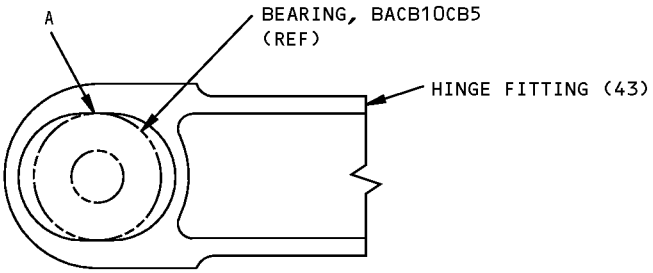
1. FILLET SEAL ALL FITTING EDGES WITH BMS 5-95 SEALANT
2. PREPACK CAVITY WITH BMS 5-95 SEALANT
3. BRUSH APPLY BMS 5-95 SEALANT TO EDGE OF COMPOSITE MATERIAL
4. WET INSTALL FASTENERS & FILLET SEAL COLLARS WITH BMS 5-95 SEALANT
5. FAY SURFACE SEAL BETWEEN ALL SURFACES USING BMS 5-95 SEALANT

Sealing Requirements
Figure 701



1. PREPACK CAVITIES WITH BMS 5-95 BEFORE INSTALLING SPACERS
2. COLD BOND SEAL WITH BMS 5-95 SEALANT

Sealing and Bonding Requirements
Figure 701



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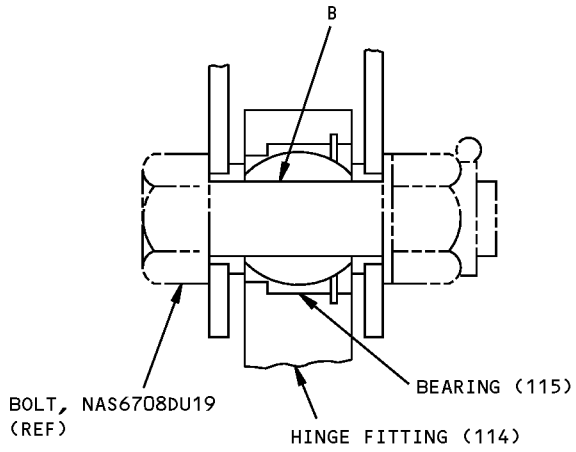

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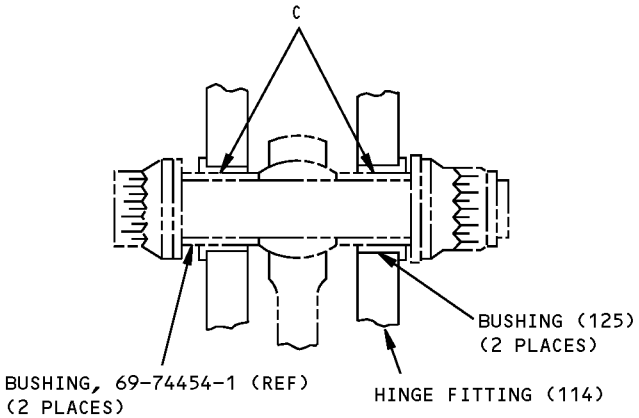


BC

Fits and Clearances
Figure 801 (Sheet 1 of 2)

Ref Letter Fig.801	Mating Item No. IPL Fig.1	Design Dimension				Service Wear Limit		
		Dimension		Assembly Clearance		Dimension		Maximum Clearance
		Min	Max	Min	Max	Min	Max	
A	ID 43	1.2505 [1]	1.2515 [1]	0.0005	0.0020		1.2550	0.0050
	OD [2]	1.2495	1.2500			1.2475		
B	ID 115	0.4995	0.5000	0.0000	0.0010		0.5020	0.0025
	OD [3]	0.4990	0.4995			0.4970		
C	ID 125	0.7500	0.7515	0.0010	0.0035		0.7540	0.0055
	OD [4]	0.7480	0.7490			0.7465		

[1] SLOT WIDTH
[2] BEARING, BACB10CB5 (REF)
[3] BOLT, NAS6708DU19 (REF)
[4] BUSHING, 69-74454-1 (REF)

Fits and Clearances
Figure 801 (Sheet 2 of 2)

COMPONENT MAINTENANCE MANUAL

SPECIAL TOOLS, FIXTURES, AND EQUIPMENT

(NOT APPLICABLE)

ILLUSTRATED PARTS LIST

1. Introduction

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

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

1 2 3 4 5 6 7

. Assembly

. Attaching parts for assembly

. . Detail parts for assembly

. . Subassembly

. . Attaching parts for subassembly

. . . Detail parts for subassembly

. . . Sub-subassembly

. . . Attaching parts for subassembly

. . . . . Details parts for sub-subassembly

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

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

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

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

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

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

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

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

H. Interchangeable Parts

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

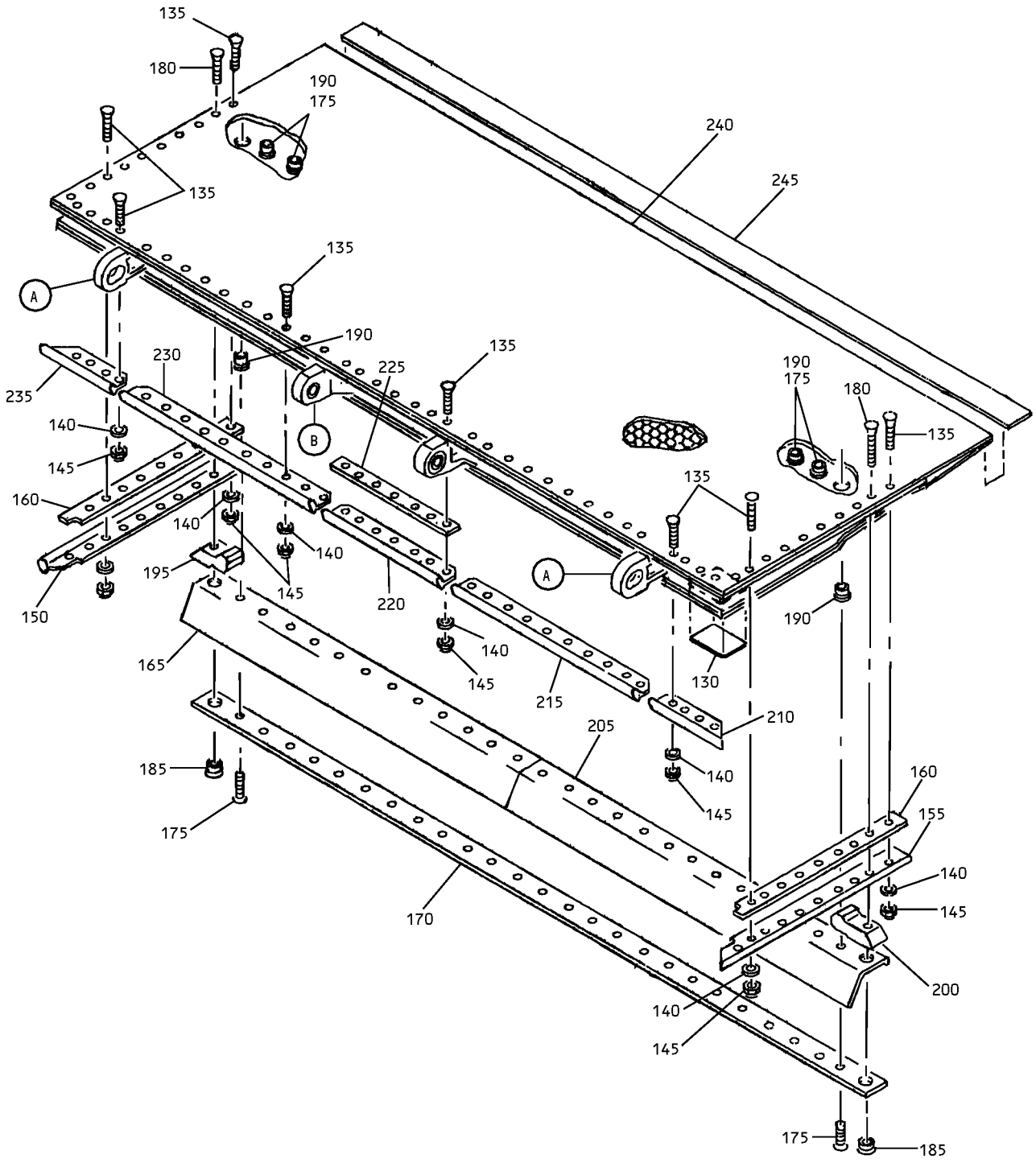
VENDOR CODES

Code	Name
97393	SHUR-LOK CORPORATION 2541 WHITE ROAD PO BOX 19584 IRVINE, CALIFORNIA 92623-9584 FORMERLY SHUR LOK CORP VB0060 FORMERLY IN SANTA ANA, CALIFORNIA 92714

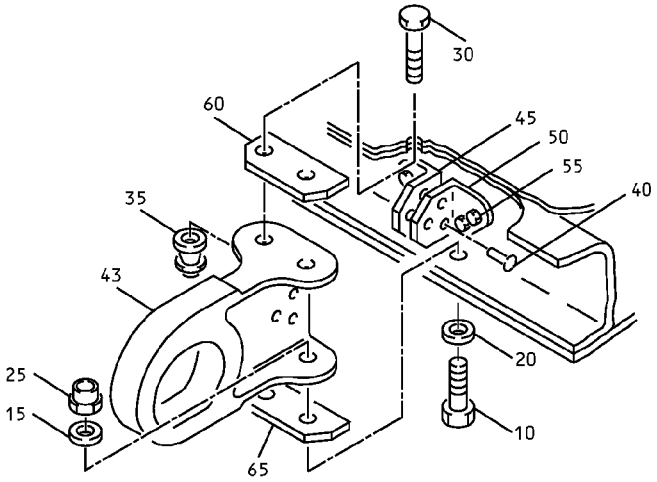
NUMERICAL INDEX

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
10-60545-144		1	115	2
10-60545-144A		1	115A	2
65-46451-69		1	205B	1
65-76174-10		1	200	1
65-76174-9		1	195	1
65C25251-10		1	215	1
65C25251-11		1	170	1
65C25251-13		1	193	1
65C25251-14		1	205	1
65C25251-15		1	60	2
65C25251-16		1	160	2
65C25251-19		1	1	RF
65C25251-2		1	245	1
65C25251-20		1	2	RF
65C25251-21		1	3	RF
65C25251-22		1	65	2
65C25251-3		1	150	1
65C25251-4		1	155	1
65C25251-5		1	225	1
65C25251-6		1	220	1
65C25251-7		1	235	1
65C25251-8		1	210	1
65C25251-9		1	230	1
65C25252-10		1	240	1
65C25255-1		1	43	2
65C25256-2		1	114	1
65C25262-1		1	50	2
65C25262-2		1	55	2
AN960PD10		1	75	4
AN960PD416		1	15	4
BACB30MY6K4		1	111	6
BACB30NM3K4		1	100	2
BACB30NM3K5		1	95	2
BACB30NN3K2		1	175	25

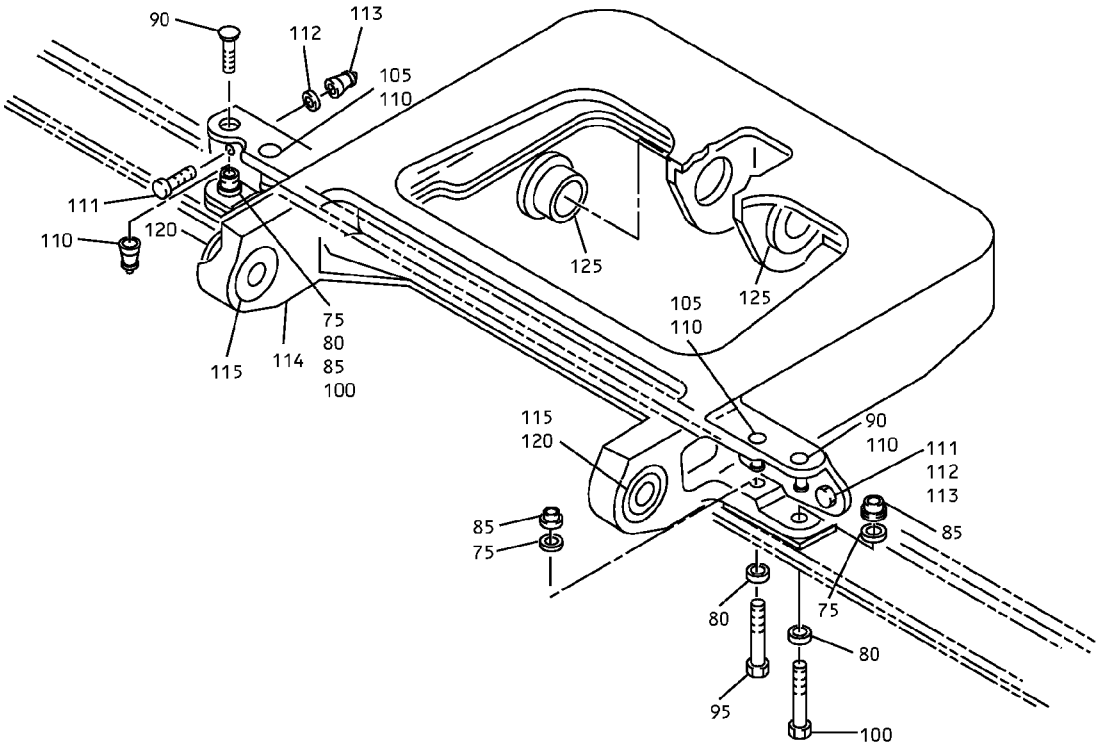
PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACB30NN3K5		1	180	2
BACB30NN4K5		1	10	4
BACB30NW8K5		1	30	4
BACB30NZ6K4		1	90	2
BACB30NZ6K5		1	105	2
BACB30VF08K3		1	135	53
BACB30VL6-250		1	45	8
BACC30AB6C		1	113	6
BACC30M		1	35	4
		1	110	4
BACN10JC08CD		1	145	53
BACR15B06D		1	40	6
BACW10BP2NAPU		1	140	53
BACW10BP3NAPU		1	80	4
		1	112	6
BACW10BP4NAPU		1	20	4
KSC157608V		1	115B	2
MS16625-1100		1	120	2
MS27253-1		1	130	1
NAS1805-3N		1	85	4
NAS1805-4N		1	25	4
NAS77A12-40P		1	125	2
SL52C3		1	185	2
SL606-3CSP14		1	190	25



Outboard Spoiler Panel Assembly
IPL Figure 1 (Sheet 1 of 2)



A



B

Outboard Spoiler Panel Assembly
IPL Figure 1 (Sheet 2 of 2)

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
–1	65C25251-19		PANEL ASSY-OUTBD SPOILER		RF
–2	65C25251-20		PANEL ASSY-OUTBD SPOILER		RF
–3	65C25251-21		PANEL ASSY-OUTBD SPOILER		RF
10	BACB30NN4K5		. BOLT		4
15	AN960PD416		. WASHER (ADJACENT TO FITTING)		4
20	BACW10BP4NAPU		. WASHER (ADJACENT TO SKIN)		4
25	NAS1805-4N		. NUT		4
30	BACB30NW8K5		. BOLT		4
35	BACC30M		. COLLAR		4
40	BACR15B06D		. RIVET		6
43	65C25255-1		. FITTING-HINGE		2
45	BACB30VL6-250		. BOLT		8
50	65C25262-1		. CLIP		2
55	65C25262-2		. CLIP		2
60	65C25251-15		. SHIM-LAMINATED		2
65	65C25251-22		. SHIM-LAMINATED		2
75	AN960PD10		. WASHER (ADJACENT TO FITTING)		4
80	BACW10BP3NAPU		. WASHER (ADJACENT TO SKIN)		4
85	NAS1805-3N		. NUT		4
90	BACB30NZ6K4		. BOLT		2
95	BACB30NM3K5		. BOLT		2
100	BACB30NM3K4		. BOLT		2
105	BACB30NZ6K5		. BOLT		2
110	BACC30M		. COLLAR		4
111	BACB30MY6K4		. BOLT		6
112	BACW10BP3NAPU		. WASHER (FAR SIDE)		6
113	BACC30AB6C		. COLLAR		6

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
114	65C25256-2		. HINGE FITTING		1
115	10-60545-144		. BEARING (REPLACED BY ITEM 115A) (PRE SB 737-57-1227)		2
115A	10-60545-144A		. BEARING (REPLACES ITEM 115) (PRE SB 737-57-1227)		2
115B	KSC157608V		. BEARING (POST SB 737-57-1227)		2
120	MS16625-1100		. RING		2
125	NAS77A12-40P		. BUSHING		2
130	MS27253-1		. PLATE-IDENT		1
135	BACB30VF08K3		. BOLT		53
140	BACW10BP2NAPU		. WASHER		53
145	BACN10JC08CD		. NUT		53
150	65C25251-3		. SEAL		1
155	65C25251-4		. SEAL		1
160	65C25251-16		. FILLER		2
170	65C25251-11		. RETAINER-SEAL		1
175	BACB30NN3K2		. BOLT		25
180	BACB30NN3K5		. BOLT		2
185	SL52C3		. NUT (V97393)		2
190	SL606-3CSP14		. INSERT (V97393)		25
193	65C25251-13		. SEAL (PRE SB 737-57-1192)		1
195	65-76174-9		. SPACER		1
200	65-76174-10		. SPACER		1
205	65C25251-14		. SEAL (PRE SB 737-57-1192)		1
–205B	65-46451-69		. SEAL, BLADE (POST SB 737-57-1192)		1
210	65C25251-8		. SEAL		1
215	65C25251-10		. SEAL		1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
220	65C25251-6		. SEAL		1
225	65C25251-5		. FILLER		1
230	65C25251-9		. SEAL		1
235	65C25251-7		. SEAL		1
240	65C25252-10		. PANEL ASSY		1
245	65C25251-2		. STRIP-RUB		1

–Item not Illustrated