



COMPONENT MAINTENANCE MANUAL WITH ILLUSTRATED PARTS LIST

INBOARD SPOILER PANEL ASSEMBLY

**PART NUMBER
65C25242-16SP**

BOEING PROPRIETARY, CONFIDENTIAL, AND/OR TRADE SECRET

Copyright © 1995 The Boeing Company
Unpublished Work - All Rights Reserved

Boeing claims copyright in each page of this document only to the extent that the page contains copyrightable subject matter. Boeing also claims copyright in this document as a compilation and/or collective work.

This document includes proprietary information owned by The Boeing Company and/or one or more third parties. Treatment of the document and the information it contains is governed by contract with Boeing. For more information, contact The Boeing Company, P.O. Box 3707, Seattle, Washington 98124.

Boeing, the Boeing signature, the Boeing symbol, 707, 717, 727, 737, 747, 757, 767, 777, 787, Dreamliner, BBJ, DC-8, DC-9, DC-10, KC-10, KDC-10, MD-10, MD-11, MD-80, MD-88, MD-90, P-8A, Poseidon and the Boeing livery are all trademarks owned by The Boeing Company; and no trademark license is granted in connection with this document unless provided in writing by Boeing.

PUBLISHED BY BOEING COMMERCIAL AIRPLANES GROUP, SEATTLE, WASHINGTON, USA
A DIVISION OF THE BOEING COMPANY
PAGE DATE: Jul 01/2009

57-56-62

Page 1
Jul 01/2009



COMPONENT MAINTENANCE MANUAL

Revision No. 14
Jul 01/2009

To: All holders of INBOARD SPOILER PANEL ASSEMBLY 57-56-62.

Attached is the current revision to this COMPONENT MAINTENANCE MANUAL

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

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

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

ATTENTION

IF YOU RECEIVE PRINTED REVISIONS, PLEASE VERIFY THAT YOU HAVE RECEIVED AND FILED THE PREVIOUS REVISION. BOEING MUST BE NOTIFIED WITHIN 30 DAYS IF YOU HAVE NOT RECEIVED THE PREVIOUS REVISION. REQUESTS FOR REVISIONS OTHER THAN THE PREVIOUS REVISION WILL REQUIRE A COMPLETE MANUAL REPRINT SUBJECT TO REPRINT CHARGES SHOWN IN THE DATA AND SERVICES CATALOG.

57-56-62

TRANSMITTAL LETTER

Page 1

Jul 01/2009



COMPONENT MAINTENANCE MANUAL

Location of Change

Description of Change

NO HIGHLIGHTS

57-56-62

HIGHLIGHTS

Page 1

Jul 01/2009



COMPONENT MAINTENANCE MANUAL

Subject/Page	Date	Subject/Page	Date	Subject/Page	Date
TITLE PAGE		57-56-62 CLEANING (cont)		57-56-62 ILLUSTRATED PARTS LIST (cont)	
O 1	Jul 01/2009	402	BLANK	1009	Mar 01/2006
2	BLANK	57-56-62 CHECK		1010	Mar 01/2006
57-56-62 TRANSMITTAL LETTER		501	Mar 01/2006	1011	Mar 01/2006
O 1	Jul 01/2009	502	BLANK	1012	Mar 01/2006
2	BLANK	57-56-62 REPAIR - GENERAL		1013	Mar 01/2006
57-56-62 HIGHLIGHTS		601	Mar 01/2006	1014	BLANK
O 1	Jul 01/2009	602	Jul 01/2008		
2	BLANK	57-56-62 REPAIR 1-1			
57-56-62 EFFECTIVE PAGES		601	Mar 01/2006		
1	Jul 01/2009	602	BLANK		
2	BLANK	57-56-62 REPAIR 2-1			
57-56-62 CONTENTS		601	Mar 01/2006		
1	Mar 01/2006	602	Mar 01/2006		
2	BLANK	57-56-62 REPAIR 3-1			
57-56-62 TR AND SB RECORD		601	Mar 01/2006		
1	Mar 01/2006	602	BLANK		
2	BLANK	57-56-62 ASSEMBLY			
57-56-62 REVISION RECORD		701	Jul 01/2008		
1	Mar 01/2006	702	Mar 01/2006		
2	Mar 01/2006	703	Nov 01/2006		
57-56-62 RECORD OF TEMPORARY REVISIONS		704	BLANK		
1	Mar 01/2006	57-56-62 FITS AND CLEARANCES			
2	Mar 01/2006	801	Mar 01/2006		
57-56-62 INTRODUCTION		802	Mar 01/2006		
1	Mar 01/2009	803	Mar 01/2006		
2	BLANK	804	BLANK		
57-56-62 DESCRIPTION AND OPERATION		57-56-62 SPECIAL TOOLS, FIXTURES, AND EQUIPMENT			
1	Mar 01/2006	901	Mar 01/2006		
2	BLANK	902	BLANK		
57-56-62 TESTING AND FAULT ISOLATION		57-56-62 ILLUSTRATED PARTS LIST			
101	Mar 01/2006	1001	Nov 01/2008		
102	BLANK	1002	Jul 01/2006		
57-56-62 DISASSEMBLY		1003	Mar 01/2006		
301	Jul 01/2008	1004	Mar 01/2006		
302	BLANK	1005	Mar 01/2006		
57-56-62 CLEANING		1006	Mar 01/2006		
401	Mar 01/2006	1007	Mar 01/2006		
		1008	Mar 01/2006		

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

57-56-62

EFFECTIVE PAGES

Page 1

Jul 01/2009

**COMPONENT MAINTENANCE MANUAL****TABLE OF CONTENTS**

<u>Paragraph Title</u>		<u>Page</u>
INBOARD SPOILER PANEL ASSEMBLY - DESCRIPTION AND OPERATION		1
TESTING AND FAULT ISOLATION	(Not Applicable)	
DISASSEMBLY		301
CLEANING		401
CHECK		501
REPAIR		601
ASSEMBLY		701
FITS AND CLEARANCES		801
SPECIAL TOOLS, FIXTURES, AND EQUIPMENT	(Not Applicable)	
ILLUSTRATED PARTS LIST		1001

57-56-62

CONTENTS

Page 1

Mar 01/2006



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.

57-56-62

INTRODUCTION

Page 1

Mar 01/2009



COMPONENT MAINTENANCE MANUAL

INBOARD SPOILER PANEL ASSEMBLY - DESCRIPTION AND OPERATION

1. Description and Operation

A. Description

- (1) The inboard spoiler panel assembly is composed of a graphite epoxy prepreg fabric bonded assembly. It is attached to the rear spar of each wing with four forged aluminum alloy fittings. Two of these fittings are combination actuator and hinge fittings and two are eccentric hinges. The assembly is recessed into the upper surface of the wing between the engine nacelle and the fuselage.

B. Operation

- (1) The ground spoiler is used only when the airplane is being operated on the ground. It is operated hydraulically in conjunction with the speed brake to assist in stabilizing the airplane and reducing speed. During flight, the spoiler is locked in closed position by a lockout valve which is operated by extension or compression of the main landing gear shock strut. When the airplane becomes airborne, the shock strut is extended, and, through a push-pull cable attached to the upper torsion link, actuates the lockout valve to close the spoiler. When the airplane touches down, the shock strut is compressed, actuating the lockout valve to open the spoiler.

2. Leading Particulars (approximate)

- A. Length – 93 inches
- B. Width – 21 inches
- C. Thickness – 2 inches
- D. Weight – 27 pounds

57-56-62

DESCRIPTION AND OPERATION

Page 1

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

TESTING AND FAULT ISOLATION

(NOT APPLICABLE)

57-56-62

TESTING AND FAULT ISOLATION

Page 101

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

DISASSEMBLY

1. General

- A. This procedure has the data necessary to disassemble the inboard spoiler panel assembly.
- B. Disassemble this component only as necessary to complete fault isolation, determine the serviceability of parts, perform required repairs, and restore the unit to serviceable condition.
- C. Refer to IPL Figure 1 for item numbers.

2. Disassembly

A. Tools/Equipment

NOTE: Equivalent substitutes may be used.

Reference	Description
STD-764	Scraper - Non-metallic

B. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

C. References

Reference	Title
SOPM 20-60-04	MISCELLANEOUS MATERIALS

D. Procedure

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

- (1) Use standard industry practices for disassembly of this component, and additional procedures in the following steps.
- (2) Note thickness of laminated shims (40, 180, 185, 190, IPL Figure 1) for reference during assembly.
- (3) Do not remove hinge fittings (75, 80) unless replacement is necessary or repair cannot be accomplished in place. Hinge fittings (75, 80) have all faying surfaces sealed with sealant, A00247 and fasteners (85) attach through the graphite/epoxy spar.
- (4) Remove hinge fitting (37) and shims (180) from the panel without removing clips (45, 50) from the structure. If clips (45, 50) are removed, use care to prevent delamination or other damage to the graphite/epoxy panel or honeycomb.
- (5) Remove rub strip (195) by scraping off with a sharp edged non-metallic scraper, STD-764.

57-56-62

DISASSEMBLY

Page 301

Jul 01/2008



COMPONENT MAINTENANCE MANUAL

CLEANING

1. General

- A. This procedure has the data necessary to clean the inboard spoiler panel assemblies.
- 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. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
B00090	Solvent - Inhibited Trichloroethane 1,1,1	MIL-T-81533
G01043	Cloth - Lint-free	

- B. References

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

- C. Procedure

CAUTION: DO NOT CLEAN GRAPHITE/ARAMID EPOXY STRUCTURES WITH CHLORINATED CLEANING AGENTS SUCH AS METHYLENE CHLORIDE, TRICHLOROETHYLENE AND TRICHLOROETHANE. CHLORINATED CLEANING AGENTS WILL CAUSE DAMAGE TO GRAPHITE/ARAMID EPOXY STRUCTURES.

- (1) Refer to SOPM 20-30-03 for cleaning all parts, other than bearings, using standard shop practices.
- (2) Refer to SOPM 20-30-01 for cleaning/refurbishing instructions for anti-friction bearings.
- (3) Clean teflon lined bearing (170) by wiping with a clean lint-free cloth, G01043 containing solvent, B00090. Do not immerse in any solvent.

NOTE: Teflon lined bearings are self-lubricated. Do not apply lubricants of any kind to teflon bearings.

57-56-62

CLEANING

Page 401

Mar 01/2006



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 the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 1 for item numbers.

2. Check

A. References

Reference	Title
SOPM 20-20-02	PENETRANT METHODS OF INSPECTION
737 SRM 57-70-00	Structural Repair Manual
737 SRM 57-70-02	Structural Repair Manual
737 SRM 57-70-90	Attach Fittings

B. Procedure

- (1) Check all parts for obvious defects in accordance with standard industry practices.
- (2) Penetrant check fittings (37, 75, 80, IPL Figure 1) per SOPM 20-20-02 if visual examinations shows evidence of defects.
- (3) Check honeycomb and bonded parts for evidence of delamination, internal water, scratches, and contour defects.
 - (a) Examine for delamination ultrasonically.
 - (b) Examine areas suspected of containing water radiographically to determine extent of damage.
 - (c) Examine edges of panel carefully for cuts and abrasions. Delamination starts very easily from damage to an exposed edge of honeycomb panel.
- (4) Refer to 737 SRM 57-70-00 for allowable honeycomb and laminate damage data.
- (5) Check assembly components for nicks, scratches and corrosion. Refer to 737 SRM 57-70-02, Structure, and 737 SRM 57-70-90, Attach Fittings for allowable repair limits and data.
- (6) Refer to FITS AND CLEARANCES section for allowable wear limits.

57-56-62

CHECK

Page 501

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

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
65C25246	FITTING ASSEMBLY, ACTUATOR ATTACHMENT	1-1
65C25243	PANEL ASSEMBLY-INBOARD SPOILER	2-1
- - -	MISCELLANEOUS PARTS FINISH	3-1

2. Standard Practices

- A. Refer to the following standard practices, as applicable, for details of procedures in the individual repairs.
- SOPM 20-30-01 Cleaning and Lubrication of Antifriction Bearings
 - SOPM 20-30-02 Stripping of Protective Finishes
 - SOPM 20-30-03 General Cleaning Procedures
 - SOPM 20-30-87 Solvents for Final Cleaning of Composites Before Painting (Series 87)
 - 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 20-43-03 Chemical Conversion Coatings for Aluminum
 - SOPM 20-50-03 Bearing Removal, Installation and Retention
 - SOPM 20-50-07 Lubrication
 - SOPM 20-50-12 Application of Adhesives
 - SOPM 20-60-02 Finishing Materials
 - SOPM 20-60-03 Lubricants
 - SOPM 20-60-04 Miscellaneous Materials

3. Materials

NOTE: Equivalent substitutes can be used.

- A. Enamel – coating, C00032 BMS 10-60, Type 1
- B. Primer –
- (1) BMS 10-11, Type 1 primer, C00259
 - (2) BMS 10-79, Type 2 primer, C00319
- C. Sealant –
- (1) BMS 5-95 sealant, A00247
 - (2) BMS 5-95, Type B adhesive, A01076
 - (3) clean dry air, G50321
 - (4) Cleaning wiper, G50262

57-56-62

REPAIR - GENERAL

Page 601

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

- D. Static Conditioner – Magna 28C1 conditioner filler, C00058 Dexter 28-C-1
- E. Surfacer –
 - (1) Epocast 156 surfacer, A50098
 - (2) Dexter 8-W-5 surfacer, A50099
- F. Potting Compound – adhesive, A50038 BMS 5-123, Type 1, Class 2
- G. Solvent – Series 87 solvent, B01007 Series 87
- H. Grease – grease, D00013 MIL-G-23827

57-56-62

REPAIR - GENERAL

Page 602

Jul 01/2008



COMPONENT MAINTENANCE MANUAL

FITTING ASSEMBLY-ACTUATOR ATTACHMENT - REPAIR 1-1

65C25246-5, -6, 65C35610-1, -2

1. General

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

2. Bushing Replacement (IPL Figure 1)

- A. Remove bushings (160) and bearings (165, 170).
- B. Refinish as shown in REPAIR 1-1, Paragraph 3..
- C. Install bushings (160) by the press fit procedure of SOPM 20-50-03, with wet sealant, A00247.
- D. Install bearings (165, 170) and roller swage them per SOPM 20-50-03, with wet sealant, A00247.
 - (1) Apply grease, D00013 (F-19.08) to bearing (165,170,170A) (PRE SB 737-57-1227) prior to installation.

3. Refinish

- A. Fitting (75, 80) – Chromic acid anodize and apply primer, C00259 (F-18.13) and enamel coating, C00700 (SRF-14.9813), but no primer or enamel in the holes.
- B. Fitting (75A, 80A) – Chromic acid anodize (F-17.19) all over and in holes. Apply primer, C00259 (F-20.02) and enamel coating, C00700 (SRF-14.9813), but no primer or enamel in the holes.

57-56-62

REPAIR 1-1

Page 601

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

PANEL ASSEMBLY-INBOARD SPOILER - REPAIR 2-1

65C25243-1

1. General

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

2. Repair

- A. Refer to 737 SRM 57-70-00 for structural repair to damaged plies or honeycomb of the graphite/epoxy panel (315).

3. Refinish

- A. Top surface – Prepare the surface (SRF-14.672). Apply primer, C00319 (F-19.46).
- B. Bottom surface – Prepare the surface (F-14.67). Apply primer, C00319 (F-19.46).

4. Replacement

- A. Rub strip (195)
 - (1) Remove the old rub strip with an approved scraper (SOPM 20-50-19).
 - (2) Bond a replacement rub strip in position with adhesive, A01076 per SOPM 20-50-12.
- B. Fabric seals (235-265, 295, 300, 355) – Replace by standard industry practices.
- C. Inserts (220)
 - (1) Remove the bad or loose inserts.
 - (2) Enlarge the hole diameter to 1.7-1.9 times the maximum diameter of the insert. For repairs larger than this, refer to 737 SRM 57-70-00.
 - (3) Remove loose particles, and the dust, from the hole by vacuum or blow them out with clean dry air, G50321 below 30 psi.
 - (4) Fill the hole to 60-90 percent of its capacity with adhesive, A50038 potting compound.
 - (5) Install the replacement insert into the prepared hole as shown in REPAIR 2-1, Figure 601.
 - (6) Remove unwanted potting material with a wiper, G50262 wet with a Series 87 solvent, B01007.
 - (7) Let this cure 20-40 minutes at 65°F-100° F.
 - (8) Remove the installation tab, protective tape, etc.

57-56-62

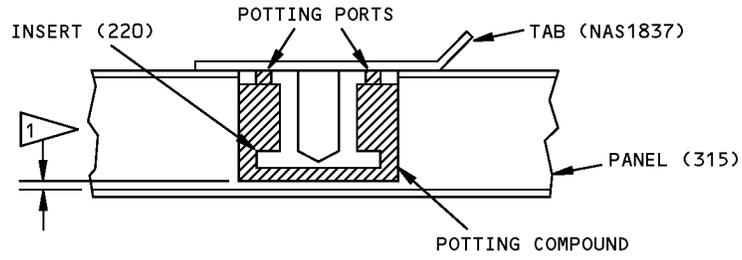
REPAIR 2-1

Page 601

Mar 01/2006



COMPONENT MAINTENANCE MANUAL



1 CORE MAY BE CRUSHED ON INSTALLATION TO ENSURE FLUSHNESS

Blind Insert Installation
Figure 601

57-56-62

REPAIR 2-1

Page 602

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

MISCELLANEOUS PARTS REFINISH - REPAIR 3-1

1. General

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

2. Refinish details

- A. Repair of these parts is only replacement of the original finish. Refer to REPAIR 3-1, Table 601 for refinish details.

Table 601: Refinish Details

IPL FIG. & ITEM	MATERIAL	FINISH
Fig. 1		
Fitting (37)	Al Alloy	Chromic acid anodize and apply primer, C00259 (F-18.13) and Apply enamel coating, C00700 (SRF-14.9813), but no primer and enamel in holes.
Clips (45, 50)	Al Alloy	Chromic acid anodize and apply primer, C00259 (F-18.13). Apply enamel coating, C00700 (SRF-14.9813).
Angle (285)	Graphite/epoxy	Prepare the surface (F-14.67). Apply primer, C00319 (F-19.46).
Angles (325, 330)	Al Alloy	Chemical treat and apply primer, C00259 (F-18.06). Apply enamel coating, C00700 (SRF-14.9813).

57-56-62

REPAIR 3-1

Page 601

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

ASSEMBLY

1. General

- A. This procedure has the data necessary to assemble the inboard spoiler panel 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 the 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

- B. References

Reference	Title
SOPM 20-50-01	BOLT AND NUT INSTALLATION
SOPM 20-60-04	MISCELLANEOUS MATERIALS

- C. 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 practices for assembly of this component and the following additional procedures.
- (2) Delaminate shims (40, 180, 185, 190) by removing 0.003 inch thick laminations as required for assembly.

NOTE: Fitting (37, 75, 80) centerlines must be straight within 0.010 inches.

Maximum gaps between faying parts at all locations, except at rubber seal locations, is 0.005 inches.

- (3) Apply sealant, A00247 in accordance with ASSEMBLY, Figure 702.
- (4) Install fasteners, other than those attaching rubber seals, wet and fillet seal with sealant, A00247.
- (5) Install fasteners on air passage skin surfaces flush to within plus 0.005 inch and minus 0.010 inch.

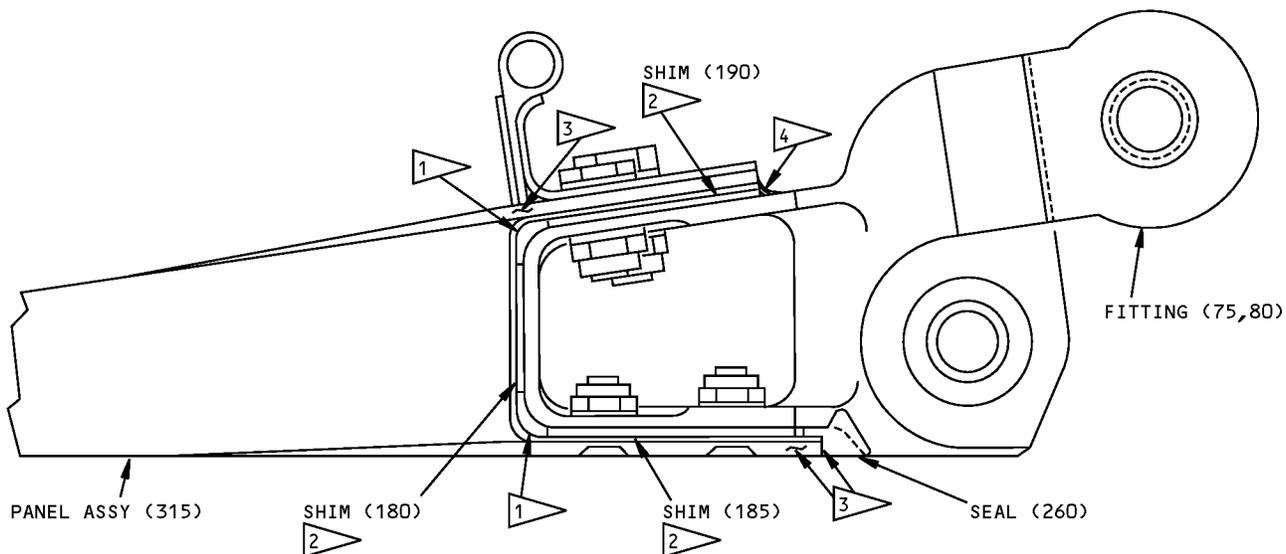
57-56-62

ASSEMBLY

Page 701

Jul 01/2008

COMPONENT MAINTENANCE MANUAL



- 1 PREPACK CAVITY WITH BMS 5-95 SEALANT
- 2 FAY SURFACE SEAL BETWEEN ALL SURFACES USING BMS 5-95 SEALANT

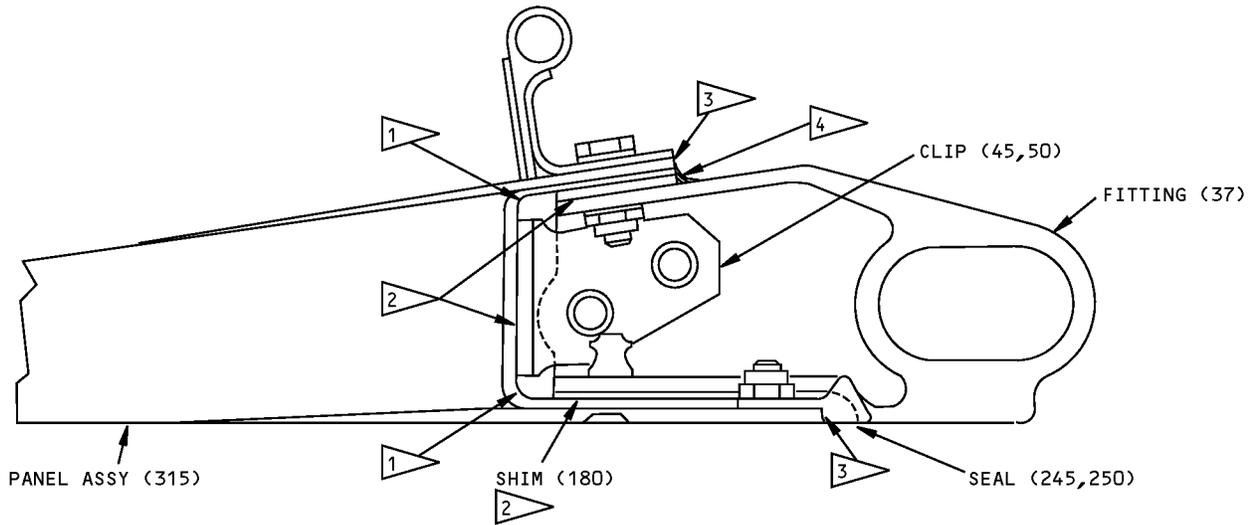
- 3 BRUSH APPLY BMS 5-95 SEALANT TO COMPOSITE EDGES
- 4 FILLET SEAL ALL FITTING EDGES ADJACENT TO COMPOSITE MATERIAL, USING BMS 5-95 SEALANT

Faying Seal Requirements
Figure 701

57-56-62

ASSEMBLY
Page 702
Mar 01/2006

COMPONENT MAINTENANCE MANUAL



- 1 PREPACK CAVITY WITH BMS 5-95 SEALANT
- 2 FAY SURFACE SEAL BETWEEN ALL SURFACES USING BMS 5-95 SEALANT

- 3 BRUSH APPLY BMS 5-95 SEALANT TO COMPOSITE EDGES
- 4 FILLET SEAL ALL FITTING EDGES ADJACENT TO COMPOSITE MATERIALS USING BMS 5-95 SEALANT

Faying Seal Requirements
Figure 702

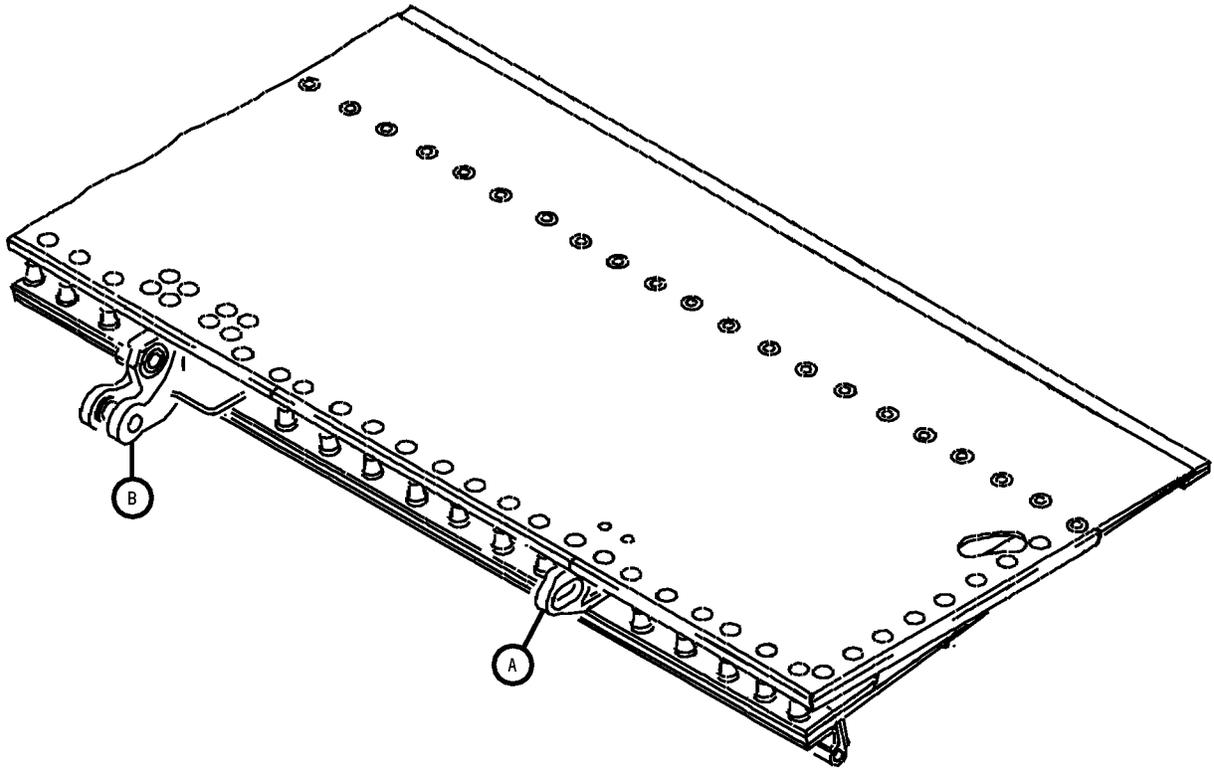
57-56-62

ASSEMBLY
Page 703
Nov 01/2006



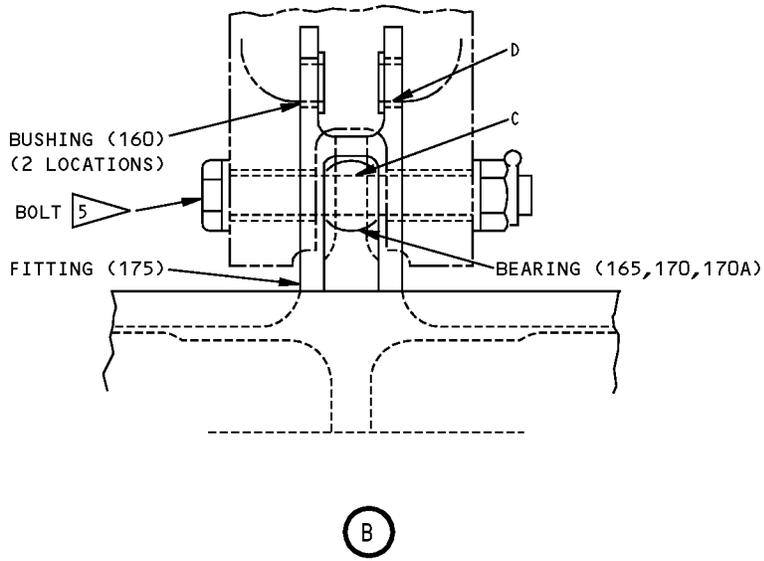
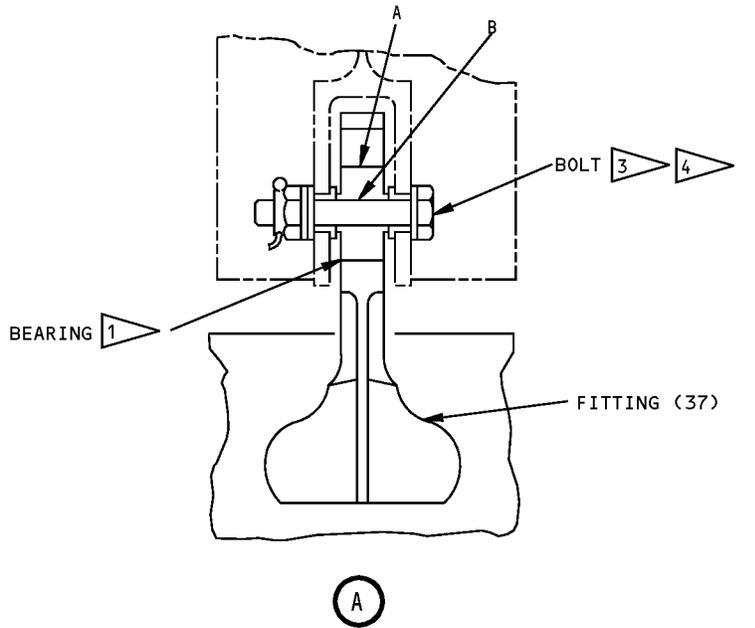
COMPONENT MAINTENANCE MANUAL

FITS AND CLEARANCES



Fits and Clearances
Figure 801 (Sheet 1 of 3)

COMPONENT MAINTENANCE MANUAL



Fits and Clearances
Figure 801 (Sheet 2 of 3)



COMPONENT MAINTENANCE MANUAL

Ref Letter Fig.801	Mating Item No. IPL Fig.1	Design Dimension				Service Wear Limit		
		Dimension		Assembly Clearance		Dimension		Maximum Clearance
		Min	Max	Min	Max	Min	Max	
A	ID 37 	 0.9019	 0.9029	0.0005	0.0020	0.8990	0.9050	0.0040
	OD 	0.9009	0.9014			0.8990	0.9050	
B	ID 	0.2495	0.2500	0.0000	0.0010	0.2475	0.2515	0.0025
	OD 	0.2490	0.2495			0.2475	0.2515	
B	ID 	0.2495	0.2500	0.0000	0.0010	0.2475	0.2515	0.0025
	OD 	0.2490	0.2495			0.2475	0.2515	
C	ID 165,170 170A	0.4995	0.5000	0.0000	0.0010	0.4970	0.5020	0.0025
	OD 	0.4990	0.4995			0.4970	0.5020	
D	ID 160	0.5000	0.5015	0.0005	0.0030	0.4970	0.5040	0.0045
	OD 	0.4985	0.4995			0.4970	0.5040	

 BACB10CB4 - BEARING

 WIDTH OF SLOT

 NAS6704DU17 - BOLT (INBD LOC, WBL 99.25)

 NAS6704DU15 - BOLT (OUTBD LOC, WBL 169.25)

 NAS6708DU53 - BOLT

 BACB30NF8-20 - BOLT (NOT SHOWN)

ALL DIMENSIONS ARE IN INCHES

Fits and Clearances
Figure 801 (Sheet 3 of 3)

57-56-62
FITS AND CLEARANCES
Page 803
Mar 01/2006



COMPONENT MAINTENANCE MANUAL

SPECIAL TOOLS, FIXTURES, AND EQUIPMENT

(NOT APPLICABLE)

57-56-62

SPECIAL TOOLS, FIXTURES, AND EQUIPMENT

Page 901

Mar 01/2006



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

57-56-62

ILLUSTRATED PARTS LIST

Page 1001

Nov 01/2008



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
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

57-56-62

ILLUSTRATED PARTS LIST

Page 1002

Jul 01/2006



COMPONENT MAINTENANCE MANUAL

NUMERICAL INDEX

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
10-60545-200S		1	165	1
10-60545-45		1	170	1
10-60545-45A		1	170A	1
65-68280-88		1	320	1
65-68280-89		1	355	1
65-68280-90		1	350	1
65-68280-91		1	355A	1
65-68280-92		1	355B	1
65-76165-11		1	305	1
65-76165-12		1	310	1
65C25242-10		1	250	1
65C25242-11		1	235	1
65C25242-12		1	240	1
65C25242-13		1	190	2
65C25242-14		1	185	2
65C25242-15		1	40	4
		1	180	4
65C25242-16SP		1	1	RF
65C25242-2		1	255	2
65C25242-3		1	295	1
65C25242-4		1	300	1
65C25242-5		1	265	1
65C25242-6		1	260	2
65C25242-7		1	290	2
65C25242-8		1	195	1
65C25242-9		1	245	1
65C25243-1		1	315	1
65C25245-4		1	37	2
65C25246-5		1	75	1
65C25246-6		1	80	1
65C25246-7		1	175	2
65C25247-1		1	285	1
65C25712-1		1	45	2
65C25712-2		1	50	2

57-56-62

ILLUSTRATED PARTS LIST

Page 1003

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
65C35610-1		1	75A	1
65C35610-2		1	80A	1
65C35610-3		1	175A	1
69-73137-1		1	325	1
69-73137-2		1	330	1
AN960PD10		1	20	4
		1	340	4
AN960PD416		1	135	8
		1	150	8
AN960PD516		1	120	4
AN960PD616		1	100	4
BACB28X8C022		1	160A	2
BACB28X8C023		1	160	2
BACB30MY6K4		1	270	33
BACB30NM3K3		1	360	46
BACB30NM3K7		1	10	4
BACB30NM5K7		1	110	4
BACB30NM6K8		1	90	4
BACB30NN3K2		1	215	48
BACB30NN3K4		1	230	2
BACB30NN3K5		1	335	4
BACB30NN4K6		1	130	8
BACB30NN4K7		1	145	8
BACB30NT3K7		1	60	4
BACB30NZ6K6		1	30	4
BACB30VF08K3		1	200	67
BACB30VL6-250		1	85	8
BACB30VL6-300		1	55	8
BACC30AB6C		1	280	33
BACC30M6		1	35	4
BACN10JC08CD		1	210	67
BACN10JC3CD		1	70	4
		1	345	4
		1	370	46
		1	805	2

57-56-62

ILLUSTRATED PARTS LIST

Page 1004

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACS12CK3U12		1	800	2
BACW10BP2NAPU		1	205	67
BACW10BP3APU		1	810	6
BACW10BP3NAPU		1	15	4
		1	65	8
		1	275	33
		1	365	46
BACW10BP5APU		1	115	4
BACW10BP6APU		1	95	4
KSC111008V		1	165B	1
KSC234708V		1	170C	1
MS27253C2		1	375	1
NAS1805-3N		1	25	4
NAS1805-4N		1	140	8
		1	155	8
NAS1805-5N		1	125	4
NAS1805-6N		1	105	4
P28080		1	170B	1
P28090		1	165A	1
SL52C3		1	225	2
SL606-3CSP15		1	220	48

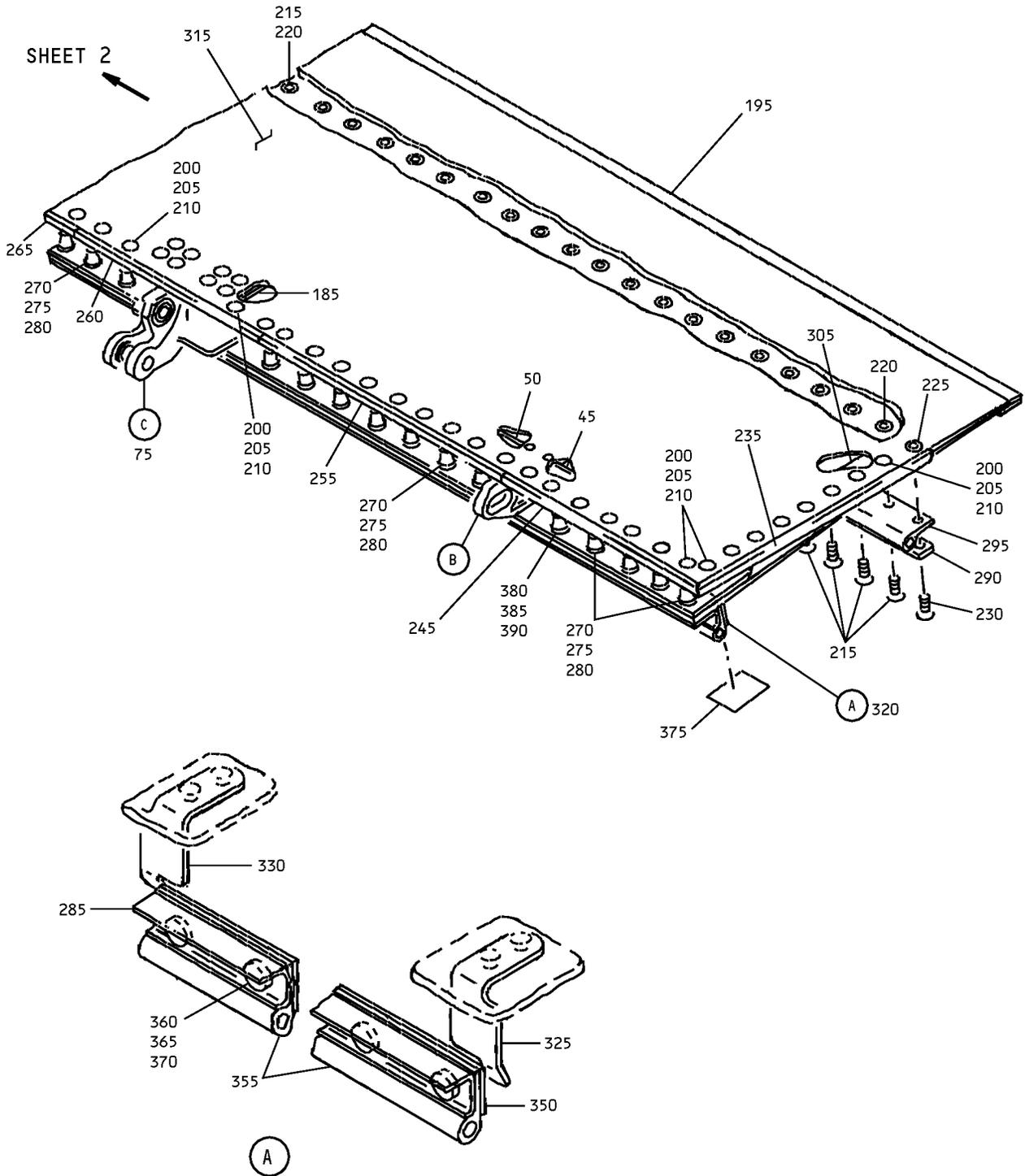
57-56-62

ILLUSTRATED PARTS LIST

Page 1005

Mar 01/2006

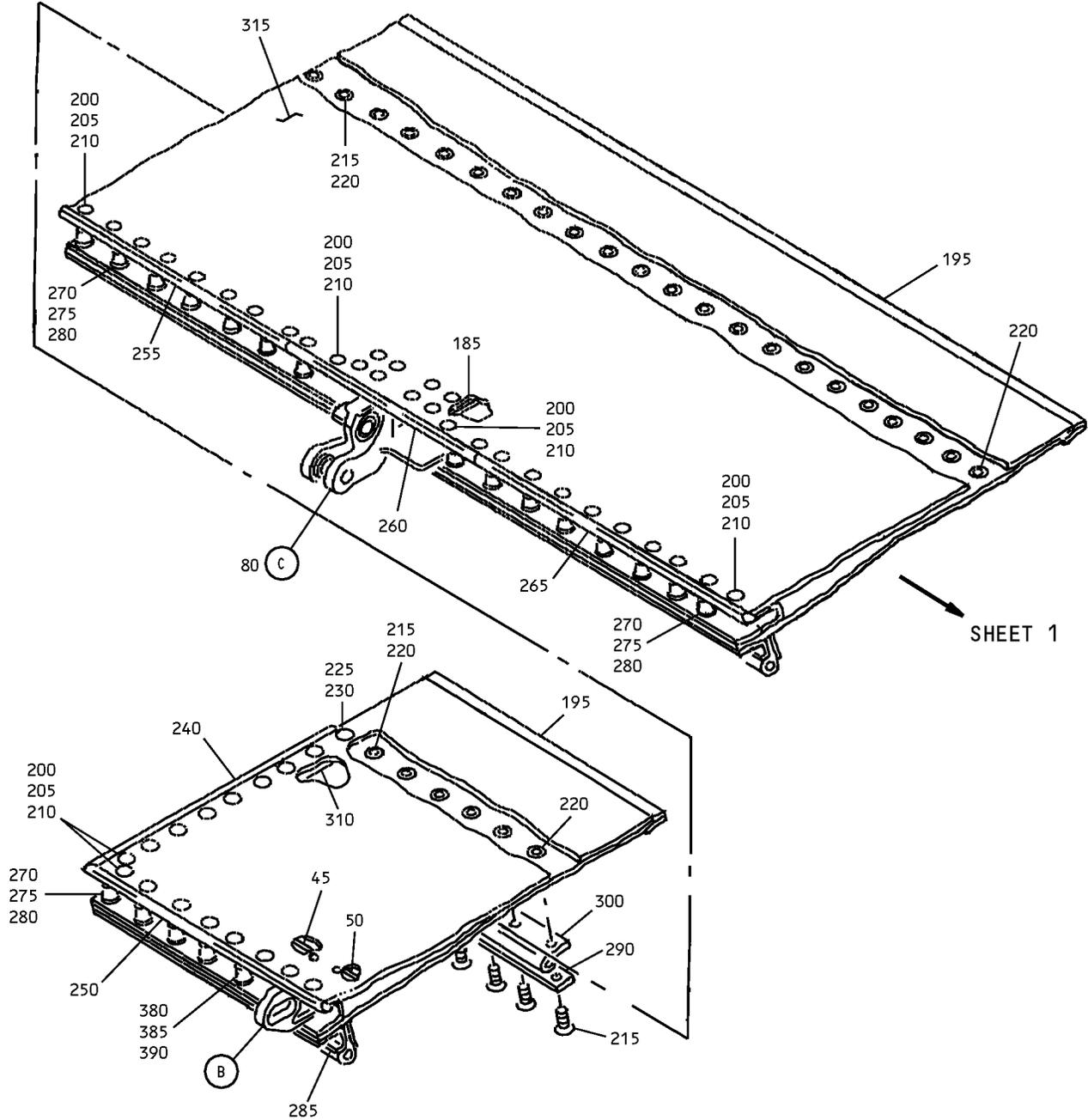
COMPONENT MAINTENANCE MANUAL



Inboard Spoiler Panel Assembly
IPL Figure 1 (Sheet 1 of 3)

57-56-62
ILLUSTRATED PARTS LIST
Page 1006
Mar 01/2006

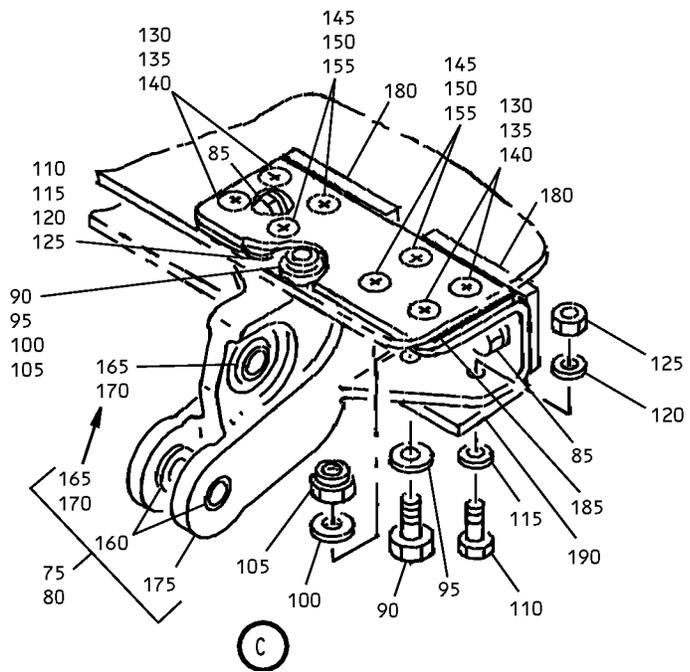
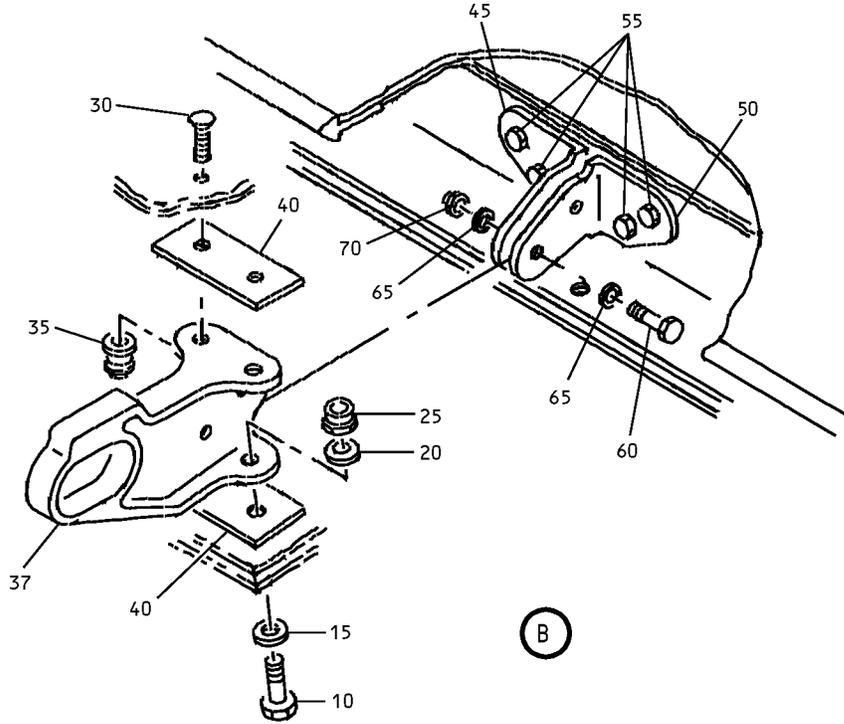
COMPONENT MAINTENANCE MANUAL



Inboard Spoiler Panel Assembly
IPL Figure 1 (Sheet 2 of 3)

57-56-62
ILLUSTRATED PARTS LIST
Page 1007
Mar 01/2006

COMPONENT MAINTENANCE MANUAL



Inboard Spoiler Panel Assembly
IPL Figure 1 (Sheet 3 of 3)

57-56-62

ILLUSTRATED PARTS LIST

Page 1008

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-1	65C25242-16SP		PANEL ASSY-INBD SPOILER (PRE SB 737-57-1227) (THERE IS NO EQUIVALENT BOEING PART NUMBER ASSIGNED FOR THE PART CHANGED BY SB 737-57- 1227R1.)								RF
-1A	65C25242-16		DELETED								
10	BACB30NM3K7		.	BOLT							4
15	BACW10BP3NAPU		.	WASHER							4
20	AN960PD10		.	WASHER							4
25	NAS1805-3N		.	NUT							4
30	BACB30NZ6K6		.	BOLT							4
35	BACC30M6		.	COLLAR							4
37	65C25245-4		.	FITTING-SLOTTED HINGE							2
40	65C25242-15		.	SHIM-LAMINATED							4
45	65C25712-1		.	CLIP							2
50	65C25712-2		.	CLIP							2
55	BACB30VL6-300		.	BOLT-BLIND							8
60	BACB30NT3K7		.	BOLT							4
65	BACW10BP3NAPU		.	WASHER							8
70	BACN10JC3CD		.	NUT							4
75	65C25246-5		.	FITTING ASSY-ACTUATOR ATTACHMENT (PRE SB 737-57-1207) (PRE SB 737-57-1227) (THERE IS NO EQUIVALENT BOEING PART NUMBER ASSIGNED FOR THE PART CHANGED BY SB 737-57- 1227R1.)							1
-75A	65C35610-1		.	FITTING ASSY-ACTUATOR ATTACHMENT (POST SB 737-52-1207)							1
80	65C25246-6		.	FITTING ASSY-ACTUATOR ATTACHMENT (PRE SB 737-57-1207)							1

-Item not Illustrated

57-56-62

ILLUSTRATED PARTS LIST

Page 1009

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1- -80A	65C35610-2		.	FITTING ASSY-ACTUATOR ATTACHMENT (POST SB 737-57-1207)							1
				ATTACHING PARTS							
85	BACB30VL6-250		.	BOLT-BLIND							8
90	BACB30NM6K8		.	BOLT							4
95	BACW10BP6APU		.	WASHER							4
100	AN960PD616		.	WASHER							4
105	NAS1805-6N		.	NUT							4
110	BACB30NM5K7		.	BOLT							4
115	BACW10BP5APU		.	WASHER							4
120	AN960PD516		.	WASHER							4
125	NAS1805-5N		.	NUT							4
130	BACB30NN4K6		.	BOLT							8
135	AN960PD416		.	WASHER							8
140	NAS1805-4N		.	NUT							8
145	BACB30NN4K7		.	BOLT							8
150	AN960PD416		.	WASHER							8
155	NAS1805-4N		.	NUT							8
				----- * -----							
160	BACB28X8C023		. .	BUSHING (USED ON ITEMS 75, 80)							2
-160A	BACB28X8C022		. .	BUSHING (USED ON ITEMS 75A, 80A)							2
165	10-60545-200S		. .	BEARING-SPHERICAL (USED ON ITEM 75) (PRE SB 737-57-1227)							1
-165A	P28090		. .	BEARING-SPHERICAL (USED ON ITEM 75A) (POST SB 737-57-1207)							1
-165B	KSC111008V		. .	BEARING-SPHERICAL (POST SB 737-57-1227)							1

-Item not Illustrated

57-56-62

ILLUSTRATED PARTS LIST

Page 1010

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
170	10-60545-45		.	.	BEARING-SPHERICAL (USED ON ITEM 80) (PRE SB 737-57-1227) (OPT ITEM 170A)						1
-170A	10-60545-45A		.	.	BEARING-SPHERICAL (USED ON ITEM 80) (PRE SB 737-57-1227) (OPT ITEM 170)						1
-170B	P28080		.	.	BEARING-SPHERICAL (USED ON ITEM 80A) (POST SB 737-57-1207)						1
-170C	KSC234708V		.	.	BEARING-SPHERICAL (POST SB 737-57-1227)						1
175	65C25246-7		.	.	FITTING (USED ON ITEMS 75, 80)						2
-175A	65C35610-3		.	.	FITTING (USED ON ITEMS 75A, 80A) (POST SB 737-57-1207)						1
180	65C25242-15		.		SHIM-LAMINATED						4
185	65C25242-14		.		SHIM-LAMINATED						2
190	65C25242-13		.		SHIM-LAMINATED						2
195	65C25242-8		.		STRIP-RUB						1
200	BACB30VF08K3		.		BOLT						67
205	BACW10BP2NAPU		.		WASHER						67
210	BACN10JC08CD		.		NUT						67
215	BACB30NN3K2		.		BOLT						48
220	SL606-3CSP15		.		INSERT (V97393)						48
225	SL52C3		.		NUT-FLUSH (V97393)						2
230	BACB30NN3K4		.		BOLT						2
235	65C25242-11		.		SEAL						1
240	65C25242-12		.		SEAL						1
245	65C25242-9		.		SEAL						1
250	65C25242-10		.		SEAL						1
255	65C25242-2		.		SEAL						2

-Item not Illustrated

57-56-62

ILLUSTRATED PARTS LIST

Page 1011

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
260	65C25242-6		.	SEAL							2
265	65C25242-5		.	SEAL							1
270	BACB30MY6K4		.	BOLT							33
275	BACW10BP3NAPU		.	WASHER							33
280	BACC30AB6C		.	COLLAR							33
285	65C25247-1		.	ANGLE							1
290	65C25242-7		.	RETAINER-SEAL							2
295	65C25242-3		.	SEAL							1
300	65C25242-4		.	SEAL							1
305	65-76165-11		.	SPACER							1
310	65-76165-12		.	SPACER							1
315	65C25243-1		.	PANEL ASSY-INBD SPOILER							1
320	65-68280-88		.	SEAL INSTL-SPOILER TO FOREFLAP							1
325	69-73137-1		..	ANGLE							1
330	69-73137-2		..	ANGLE							1
335	BACB30NN3K5		..	BOLT							4
340	AN960PD10		..	WASHER							4
345	BACN10JC3CD		..	NUT							4
350	65-68280-90		..	RETAINER							1
355	65-68280-89		..	SEAL (OPT ITEM : USE OF ITEM 355A TOGETHER WITH ITEM 355B)							1
355A	65-68280-91		..	SEAL (OPT ITEM : USE OF ITEM 355A TOGETHER WITH ITEM 355B IS EQUIVALENT TO ITEM 355)							1
355B	65-68280-92		..	SEAL (OPT ITEM : USE OF ITEM 355A TOGETHER WITH ITEM 355B IS EQUIVALENT TO ITEM 355)							1
360	BACB30NM3K3		..	BOLT							46
365	BACW10BP3NAPU		..	WASHER							46
370	BACN10JC3CD		..	NUT							46
375	MS27253C2		.	IDENT PLATE							1

-Item not Illustrated

57-56-62

ILLUSTRATED PARTS LIST

Page 1012

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-			INSTALLATION PARTS								
800	BACS12CK3U12		BOLT								2
805	BACN10JC3CD		NUT								2
810	BACW10BP3APU		WASHER								6

-Item not Illustrated