



COMPONENT MAINTENANCE MANUAL WITH ILLUSTRATED PARTS LIST

OUTBOARD GROUND SPOILER ASSEMBLY NO. 1 AND 12

**PART NUMBER
113A4100-1, -2, -3, -4**

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57-56-63

Page 1
Jul 01/2009



COMPONENT MAINTENANCE MANUAL

Revision No. 7
Jul 01/2009

To: All holders of OUTBOARD GROUND SPOILER ASSEMBLY NO. 1 AND 12 57-56-63.

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.

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57-56-63

TRANSMITTAL LETTER

Page 1

Jul 01/2009

113A4100



COMPONENT MAINTENANCE MANUAL

Location of Change

Description of Change

NO HIGHLIGHTS

57-56-63

HIGHLIGHTS

Page 1

Jul 01/2009



COMPONENT MAINTENANCE MANUAL

Subject/Page	Date	Subject/Page	Date	Subject/Page	Date
TITLE PAGE		57-56-63 CLEANING (cont)		57-56-63 SPECIAL TOOLS, FIXTURES, AND EQUIPMENT	
O 1	Jul 01/2009	402	BLANK	901	Mar 01/2006
2	BLANK	57-56-63 CHECK		902	BLANK
57-56-63 TRANSMITTAL LETTER		501	Jul 01/2008	57-56-63 ILLUSTRATED PARTS LIST	
O 1	Jul 01/2009	502	BLANK	1001	Nov 01/2008
2	BLANK	57-56-63 REPAIR - GENERAL		1002	Jul 01/2008
57-56-63 HIGHLIGHTS		601	Jul 01/2008	1003	Jul 01/2008
O 1	Jul 01/2009	602	Mar 01/2006	1004	Jul 01/2008
2	BLANK	57-56-63 REPAIR 1-1		1005	Jul 01/2008
57-56-63 EFFECTIVE PAGES		601	Jul 01/2008	1006	Mar 01/2006
1	Jul 01/2009	602	BLANK	1007	Jul 01/2008
2	BLANK	57-56-63 REPAIR 2-1		1008	Mar 01/2006
57-56-63 CONTENTS		601	Jul 01/2008	1009	Mar 01/2006
1	Mar 01/2006	602	Jul 01/2008	1010	Mar 01/2006
2	BLANK	603	Mar 01/2006	1011	Nov 01/2008
57-56-63 TR AND SB RECORD		604	Jul 01/2008	1012	Nov 01/2008
1	Jul 01/2008	605	Jul 01/2008	1013	Nov 01/2008
2	BLANK	606	Jul 01/2008	1014	BLANK
57-56-63 REVISION RECORD		607	Mar 01/2006		
1	Mar 01/2006	608	BLANK		
2	Mar 01/2006	57-56-63 REPAIR 2-2			
57-56-63 RECORD OF TEMPORARY REVISIONS		601	Jul 01/2008		
1	Mar 01/2006	602	Mar 01/2006		
2	Mar 01/2006	603	Mar 01/2006		
57-56-63 INTRODUCTION		604	Mar 01/2006		
1	Mar 01/2009	605	Mar 01/2006		
2	BLANK	606	Mar 01/2006		
57-56-63 DESCRIPTION AND OPERATION		607	Mar 01/2006		
1	Mar 01/2006	608	Mar 01/2006		
2	Mar 01/2006	609	Mar 01/2006		
57-56-63 TESTING AND FAULT ISOLATION		610	BLANK		
101	Mar 01/2006	57-56-63 ASSEMBLY			
102	BLANK	701	Mar 01/2009		
57-56-63 DISASSEMBLY		702	Nov 01/2008		
301	Mar 01/2006	57-56-63 FITS AND CLEARANCES			
302	BLANK	801	Mar 01/2006		
57-56-63 CLEANING		802	Mar 01/2006		
401	Mar 01/2006	803	Mar 01/2006		
		804	BLANK		

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

57-56-63

EFFECTIVE PAGES

Page 1

Jul 01/2009

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

<u>Paragraph Title</u>		<u>Page</u>
NO. 1 AND 12 OUTBOARD GROUND SPOILER 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

57-56-63

CONTENTS

Page 1

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

TEMPORARY REVISION AND SERVICE BULLETIN RECORD

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVE	DATE OF INCORPORATION INTO MANUAL

57-56-63

TR AND SB RECORD

Page 1

Jul 01/2008



COMPONENT MAINTENANCE MANUAL

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



COMPONENT MAINTENANCE MANUAL

All temporary revisions to this manual will be accompanied by a cover sheet bearing the temporary revision number. Enter the temporary revision number in numerical order, together with the temporary revision date, the date the temporary revision is inserted and the initials of the person filing. When the temporary revision is incorporated or cancelled, and the pages are removed, enter the date the pages are removed and the initials of the person who removed the temporary revision.

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



COMPONENT MAINTENANCE MANUAL

Temporary Revision		Inserted		Removed	
Number	Date	Date	Initials	Date	Initials

Temporary Revision		Inserted		Removed	
Date	Initials	Number	Date	Date	Initials



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.

57-56-63

INTRODUCTION

Page 1

Mar 01/2009



COMPONENT MAINTENANCE MANUAL

NO. 1 AND 12 OUTBOARD GROUND SPOILER ASSEMBLY - DESCRIPTION AND OPERATION

1. Description

- A. There are four flight spoiler assemblies, one outboard ground spoiler assembly, and one inboard ground spoiler assembly on each wing. The outboard ground spoiler assemblies are installed on the left and right wings in pair as No. 1 and 12. The spoiler assemblies are in pairs as No. 2 and 11, No. 3 and 10, No. 4 and 9, No. 5 and 8. The inboard ground spoiler assemblies are in pair as No. 6 and 7.
- The outboard ground spoiler assembly has a bonded assembly, two jumper assemblies, a center fitting, and two end ribs. The bonded assembly is made from aluminum honeycomb core reinforced between two aluminum alloy panels. The center fitting and the two end ribs are made from aluminum alloy. The outboard ground spoiler assemblies are attached to the hinges on the rear spar of the wings.

2. Operation

- A. The flight spoiler assemblies are used together with the aileron assemblies for lateral control and speed brakes. The flight spoiler assemblies on the left and right wings can be raised alternately for lateral control during flight, or can be raised together as speed brakes during landing. The flight spoiler assemblies are controlled by actuators.

3. Leading Particulars (Approximate)

- A. Length – 59 inches
- B. Width – 23 inches
- C. Height – 3 inches
- D. Weight – 14 pounds

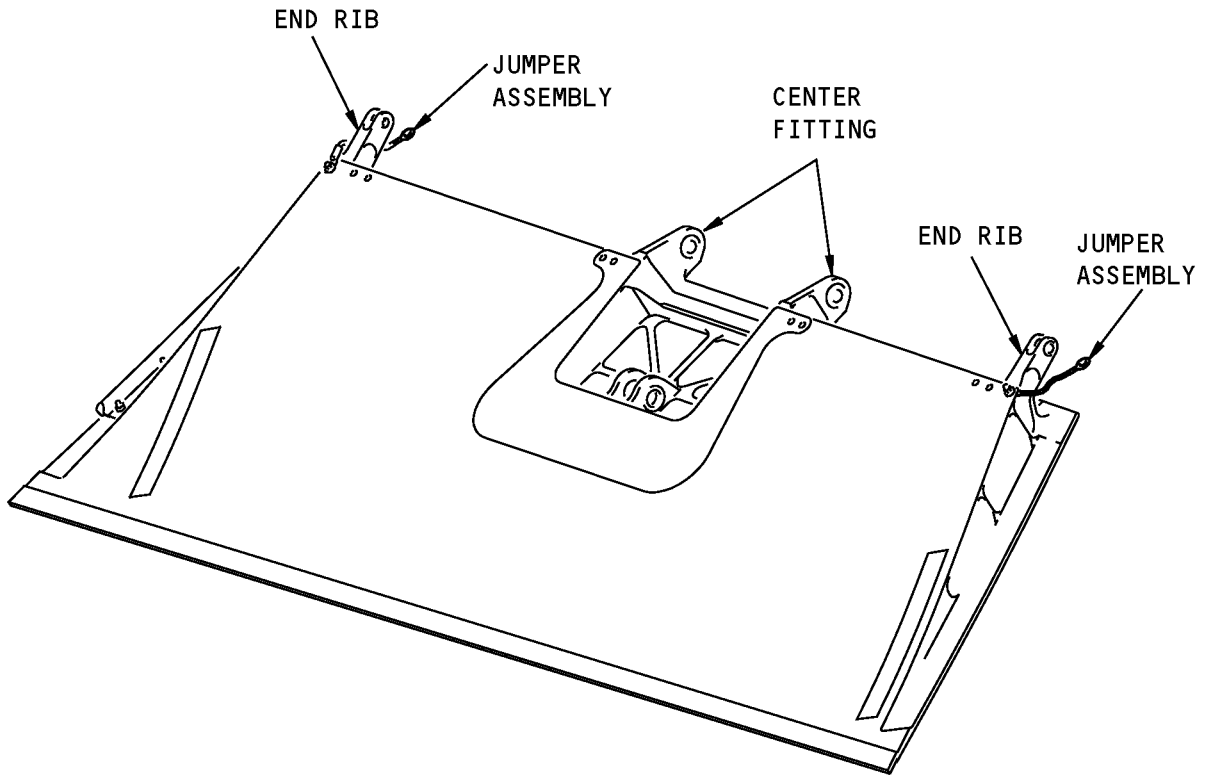
57-56-63

DESCRIPTION AND OPERATION

Page 1

Mar 01/2006

COMPONENT MAINTENANCE MANUAL



No. 1 and 12 Outboard Ground Spoiler Assemblies
Figure 1

57-56-63

DESCRIPTION AND OPERATION

Page 2

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

TESTING AND FAULT ISOLATION

(NOT APPLICABLE)

57-56-63

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 No. 1 and 12 outboard ground spoiler assembly (IPL Figure 1; 1A, 5).
- 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.

2. Disassembly

A. References

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

B. Procedure

NOTE: For bearing removal, installation and retention, refer to SOPM 20-50-03.

- (1) Use standard industry procedures to disassemble this component.

References

57-56-63

DISASSEMBLY

Page 301

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

CLEANING

1. General

- A. This procedure has the data necessary to clean the No. 1 and 12 outboard ground spoiler assembly (IPL Figure 1; 1A, 5).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.

2. Cleaning

A. References

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

B. Procedure

- (1) Clean the bearings (IPL Figure 1; 20) as specified in SOPM 20-30-01.
- (2) Use standard industry procedures and refer to SOPM 20-30-03 to clean all parts.

57-56-63

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 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 20-20-02	PENETRANT METHODS OF INSPECTION
737 NDT Part 1, 51-05-01	Tap Test Inspection of Honeycomb Sandwich Structure
737 NDT Part 4, 51-00-02	Full Depth Honeycomb and Laminate Structure Inspection
737 NDT Part 9, 51-00-01	Non-Destructive Testing

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:
 - (a) Do a penetrant check (SOPM 20-20-02) of these parts:
 - 1) End rib (145, 150, 155, 160)
 - 2) Center fitting (165, 170)
- (2) Do a check for cracks, corrosion, or missing potting and sealant at the ends of the panel bond assemblies.
- (3) Do a check of the honeycomb structure and bonded parts for evidence of delamination, internal water, scratches, and contour defects.
 - (a) If you see delamination or impact damage when you do a visual check, do an ultrasonic inspection or a tap test to find all damage. Refer to the 737 NDT Part 4, 51-00-02.

NOTE: For the tap test, use a small solid metal disk and tap the surface area lightly but firmly. You will hear a sharp sound when you tap on solid bonded areas, and dull sound on void areas. Refer to the 737 NDT Part 1, 51-05-01.
 - (b) Do a check on areas you suspect of containing water with the radiographic or thermographic method. Refer to the 737 NDT Part 9, 51-00-01.
 - (c) Do a check on the edges of the panel carefully for cuts and abrasions. Delamination starts very easily from damage to an edgemember of honeycomb panel.
- (4) Refer to the applicable 737 Structural Repair Manuals section for allowable damage and repair data.

57-56-63

CHECK
Page 501
Jul 01/2008



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:

PART NUMBER	NAME	REPAIR
—	REFINISH OF OTHER PARTS	1-1
113A4100	NO. 1 AND 12 OUTBOARD	2-1
113A4110	GROUND SPOILER ASSEMBLY	2-2

2. Dimensioning Symbols

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

57-56-63

REPAIR - GENERAL

Page 601

Jul 01/2008



COMPONENT MAINTENANCE MANUAL

—	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
◎	CONCENTRICITY	DIM	VARIATIONS ARE ESTABLISHED BY TOLERANCES ON OTHER DIMENSIONS OR
≡	SYMMETRY		NOTES.
∠	ANGULARITY	-A-	DATUM
↗	RUNOUT	Ⓜ	MAXIMUM MATERIAL CONDITION (MMC)
↗	TOTAL RUNOUT	Ⓛ	LEAST MATERIAL CONDITION (LMC)
⊔	COUNTERBORE OR SPOTFACE	Ⓢ	REGARDLESS OF FEATURE SIZE (RFS)
∇	COUNTERSINK	Ⓟ	PROJECTED TOLERANCE ZONE
⊕	THEORETICAL EXACT POSITION OF A FEATURE (TRUE POSITION)	FIM	FULL INDICATOR MOVEMENT

EXAMPLES

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

True Position Dimensioning Symbols
Figure 601

57-56-63

REPAIR - GENERAL

Page 602

Mar 01/2006



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

2. Refinish of Other Parts

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

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 the 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
Seal retainer (70)	Aluminum alloy	Chemical treat (F-17.07). Apply primer, C00175 (F-19.47). Apply enamel coating, C00033 (F-19.39-707).

57-56-63

REPAIR 1-1
Page 601
Jul 01/2008



COMPONENT MAINTENANCE MANUAL

NO. 1 AND 12 OUTBOARD GROUND SPOILER ASSEMBLY - REPAIR 2-1

113A4100-1, -2, -3, -4

1. General

- A. This procedure has the data necessary to repair and refinish the No. 1 and 12 outboard ground spoiler assembly (1A, 5).
- B. Refer to the Standard Overhaul Practices 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 (10, 15) Replacement

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

- B. References

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

- C. Procedure

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

- (1) Remove the bushing (10, 15) from the end rib (145, 150, 155, 160).
- (2) Install the new bushing (10, 15) on the end rib (145, 150, 155, 160) with sealant, A00247. Use the shrink fit method (SOPM 20-50-03).
- (3) Ream the inside diameter of the bushing (10, 15) to the dimensions shown in REPAIR 2-1, Figure 601.
- (4) Break all sharp edges.

3. Bearing (20) Replacement

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

57-56-63

REPAIR 2-1
Page 601
Jul 01/2008



COMPONENT MAINTENANCE MANUAL

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 (20) from the center fitting (165, 170).
- (2) Install the new bearing (20) on the center fitting (165, 170) with sealant, A00247 and roller swage (SOPM 20-50-03).

4. Bushing (25) Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

C. Procedure

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

- (1) Remove the bushing (25) from the center fitting (165, 170).
- (2) Install the new bushing (25) on the center fitting (165, 170) with sealant, A00247. Use the shrink fit method (SOPM 20-50-03).

5. Aluminum Foil Marker Replacement

A. References

Reference	Title
SOPM 20-50-05	APPLICATION OF ALUMINUM FOIL AND OTHER MARKERS

B. Procedure

- (1) Remove the damaged aluminum foil marker (185) from the panel bond assembly (95, 100).
- (2) Clean the surface.
- (3) Install the new aluminum foil marker (185) on the panel bond assembly (95, 100). See REPAIR 2-1, Figure 602 and SOPM 20-50-05.

57-56-63

REPAIR 2-1
Page 602
Jul 01/2008



COMPONENT MAINTENANCE MANUAL

6. No. 1 and 12 Outboard Ground Spoiler Assembly Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
C00033	Coating - Exterior Protective Enamel, Flexibility Use	BMS10-60, Type II

B. References

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

C. Procedure

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

- (1) Apply enamel coating, C00033 (F-19.39-707). No finish on bearings (20), bushings (10, 15, 25), seals (75), seal retainers (70), and rub strip (105, 110).

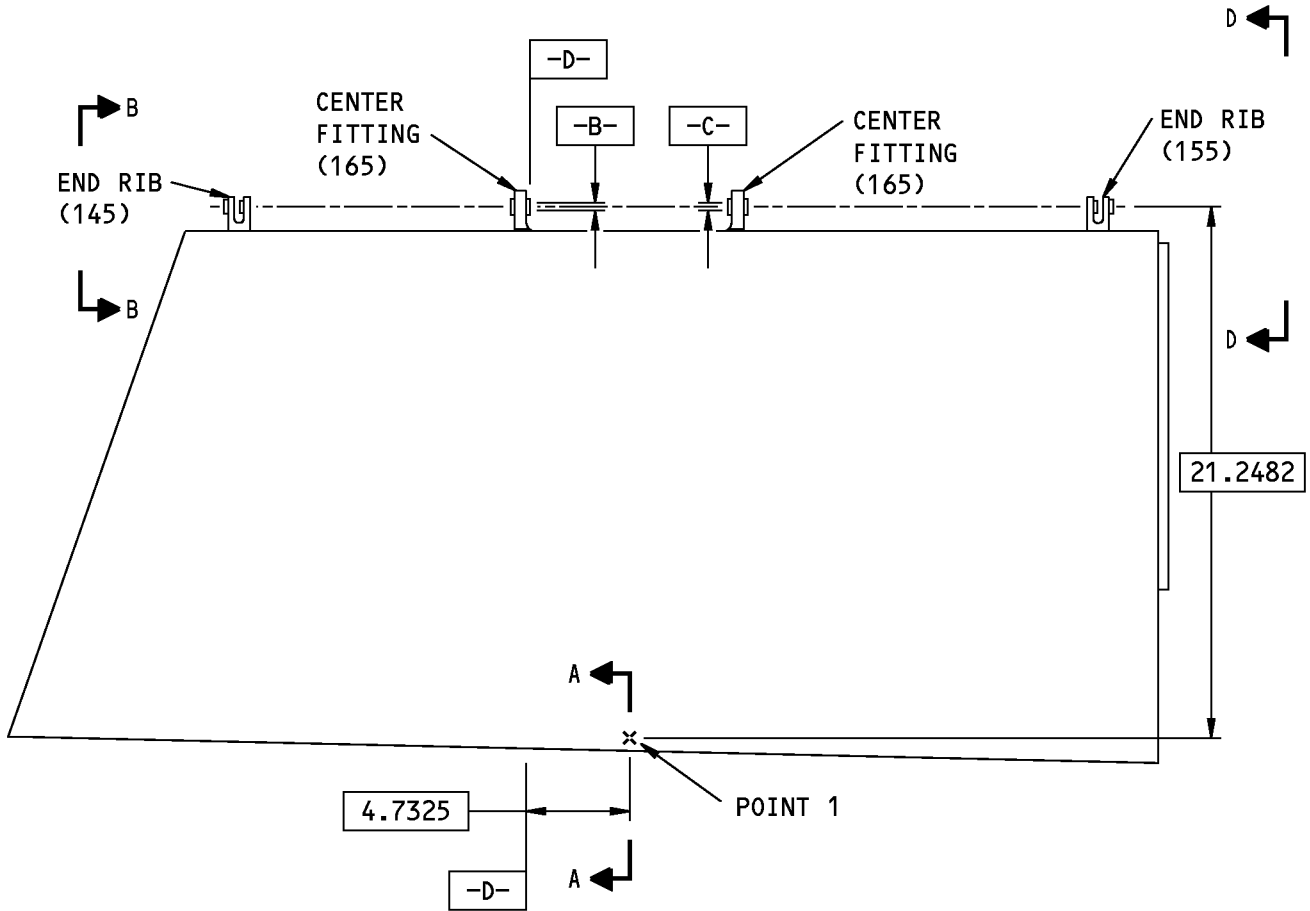
57-56-63

REPAIR 2-1

Page 603

Mar 01/2006

COMPONENT MAINTENANCE MANUAL



113A4100-1,-3 SHOWN
 113A4100-2,-4 OPPOSITE
 (THIS VIEW IS PERPENDICULAR TO DATUM -A-)

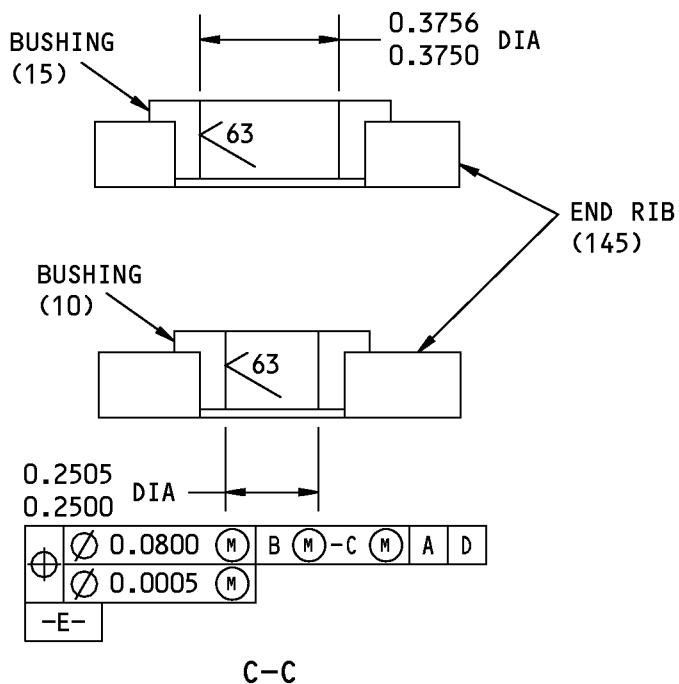
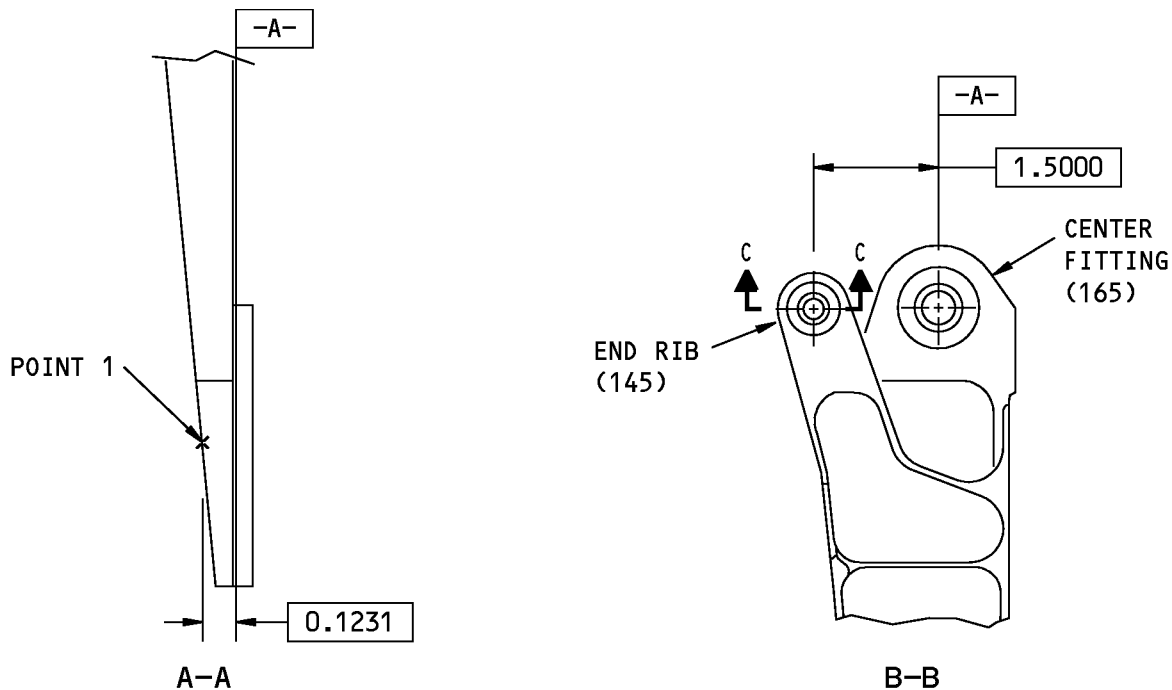
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113A4100-1,-2,-3,-4 No. 1 and 12 Flight Spoiler Assembly Repair
 Figure 601 (Sheet 1 of 3)

57-56-63

REPAIR 2-1
 Page 604
 Jul 01/2008

COMPONENT MAINTENANCE MANUAL



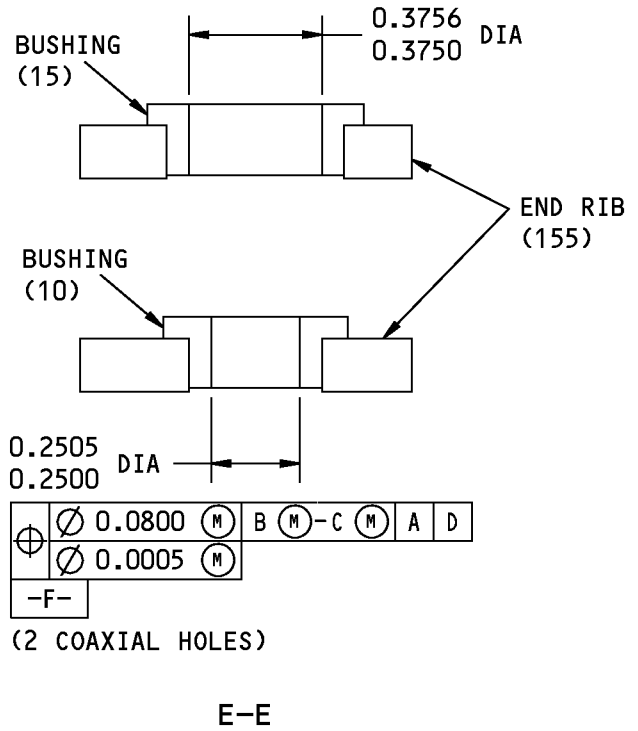
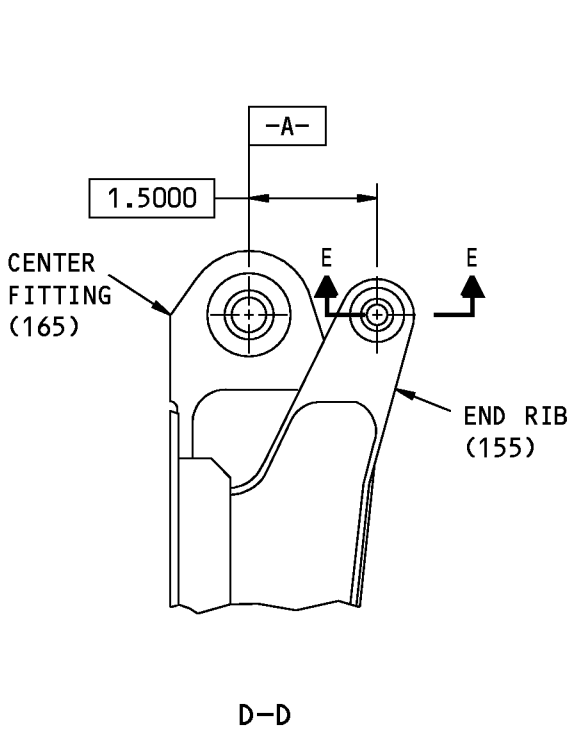
G29950 S00041007904_V2

113A4100-1,-2,-3,-4 No. 1 and 12 Flight Spoiler Assembly Repair
Figure 601 (Sheet 2 of 3)

57-56-63

REPAIR 2-1
Page 605
Jul 01/2008

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

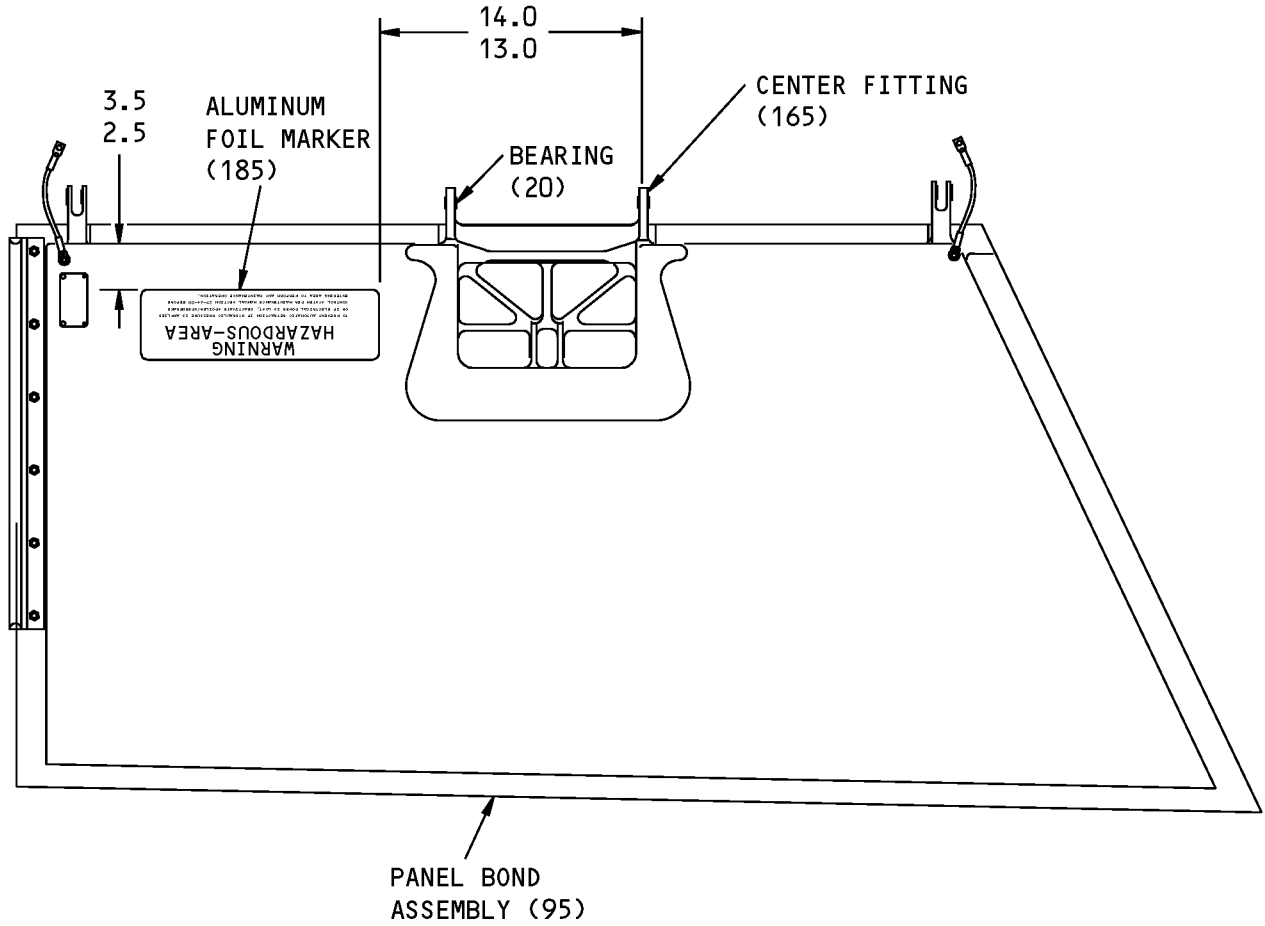
G29956 S00041007905_V2

113A4100-1,-2,-3,-4 No. 1 and 12 Flight Spoiler Assembly Repair
Figure 601 (Sheet 3 of 3)

57-56-63

REPAIR 2-1
Page 606
Jul 01/2008

COMPONENT MAINTENANCE MANUAL



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

Miscellaneous Parts Replacement
Figure 602

57-56-63

REPAIR 2-1
Page 607
Mar 01/2006



COMPONENT MAINTENANCE MANUAL

PANEL BOND ASSEMBLY - REPAIR 2-2

113A4110-1, -2

1. General

- A. This procedure has the data necessary to repair and refinish the panel bond assembly (95, 100).
- B. Refer to the Standard Overhaul Practices 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:
 - (a) End rib (145, 150, 155, 160): Aluminum alloy
 - (b) Center fitting (165, 170): Aluminum alloy
 - (2) Shot peen:
 - (a) Center fitting (165, 170):
 - 1) All repaired surfaces and bushing holes
 - 2) Intensity 0.012A - 0.017A
 - 3) Coverage 1.0 automated, 2.0 manual
 - 4) Overspray is permitted

2. End Rib Repair

A. References

Reference	Title
SOPM 20-20-02	PENETRANT METHODS OF INSPECTION
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

B. Procedure

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

- (1) Ream the holes for the bushings (10, 15) to remove defects, cracks and/or corrosion up to the limit shown in REPAIR 2-2, Figure 601.
- (2) Break all sharp edges.
- (3) Do a penetrant check (SOPM 20-20-02) on the areas you reamed.
- (4) Make the oversize bushing as shown in REPAIR 2-2, Figure 603 and the steps shown below.
 - (a) Bushing (10) material: 15-PH or 17-4PH CRES.

57-56-63

REPAIR 2-2

Page 601

Jul 01/2008



COMPONENT MAINTENANCE MANUAL

- (b) Bushing (15) material: Aluminum-nickel-bronze.
 - (c) Break all sharp edges.
 - (d) Bushing (10) finish: Zinc-nickel plate.
 - (e) Bushing (15) finish: Cadmium plate.
- (5) Install the oversize bushing (SOPM 20-50-03) as shown in REPAIR 2-1, Paragraph 2.C.(2).

3. Center Fitting Repair

A. References

Reference	Title
SOPM 20-20-02	PENETRANT METHODS OF INSPECTION
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

B. Procedure

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

- (1) Ream the hole for the bushing (25) to remove defects, cracks and/or corrosion up to the limit shown in REPAIR 2-2, Figure 602.
- (2) Break all sharp edges.
- (3) Do a penetrant check (SOPM 20-20-02) on the areas you reamed.
- (4) Make the oversize bushing as shown in REPAIR 2-2, Figure 603 and the steps shown below.
 - (a) Bushing (25) material: Aluminum-nickel-bronze.
 - (b) Break all sharp edges.
 - (c) Bushing (25) finish: Cadmium plate all over but not in holes.
- (5) Install the oversize bushing (SOPM 20-50-03) as shown in REPAIR 2-1, Paragraph 4.C.(2).

4. Panel Bond Assembly Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
C00175	Primer - Urethane Compatible, Corrosion Resistant (Less Than 1% Aromatic Amines)	BMS10-79, Type III

B. References

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

57-56-63

REPAIR 2-2
Page 602
Mar 01/2006

**COMPONENT MAINTENANCE MANUAL**

Reference	Title
SOPM 20-60-02	FINISHING MATERIALS

C. Procedure

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

- (1) Apply primer, C00175 (F-19.47).

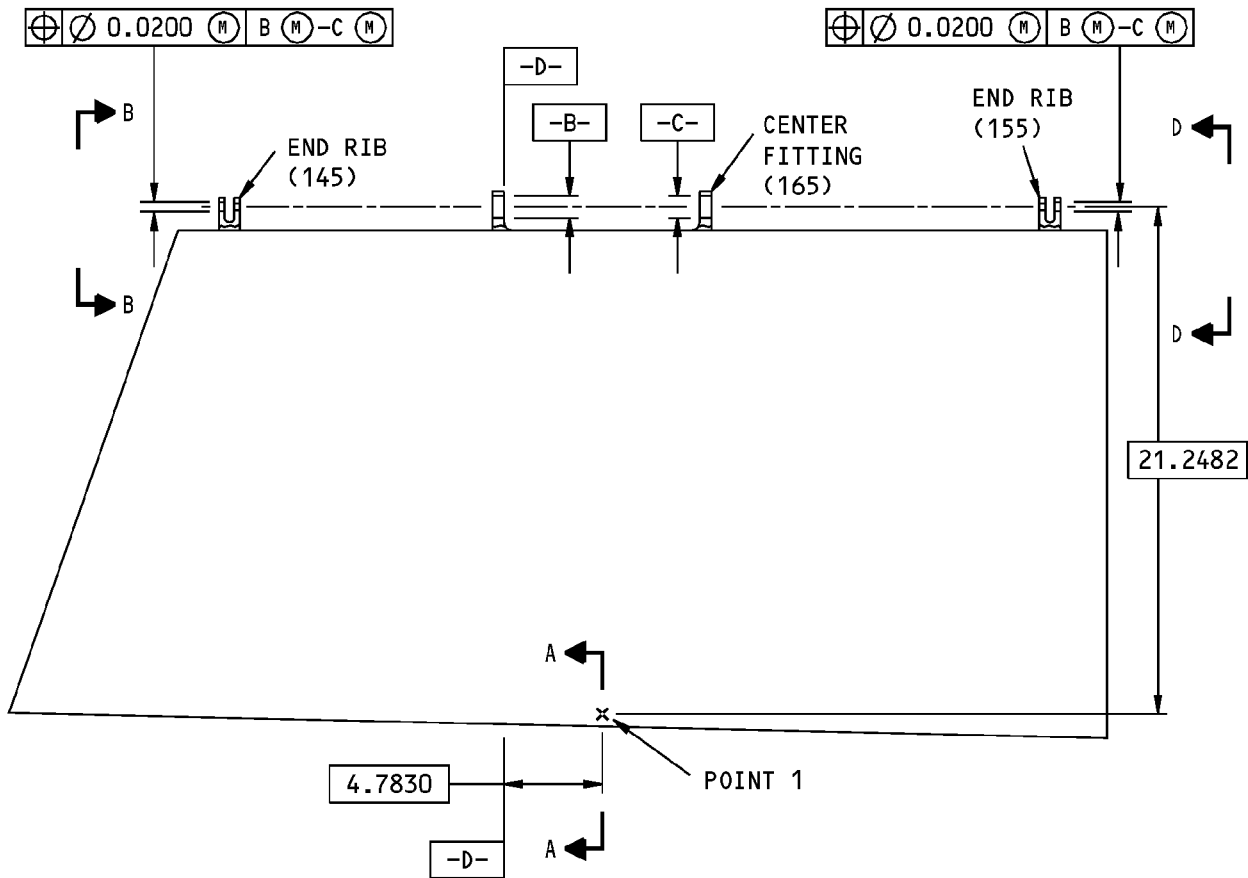
57-56-63

REPAIR 2-2

Page 603

Mar 01/2006

COMPONENT MAINTENANCE MANUAL



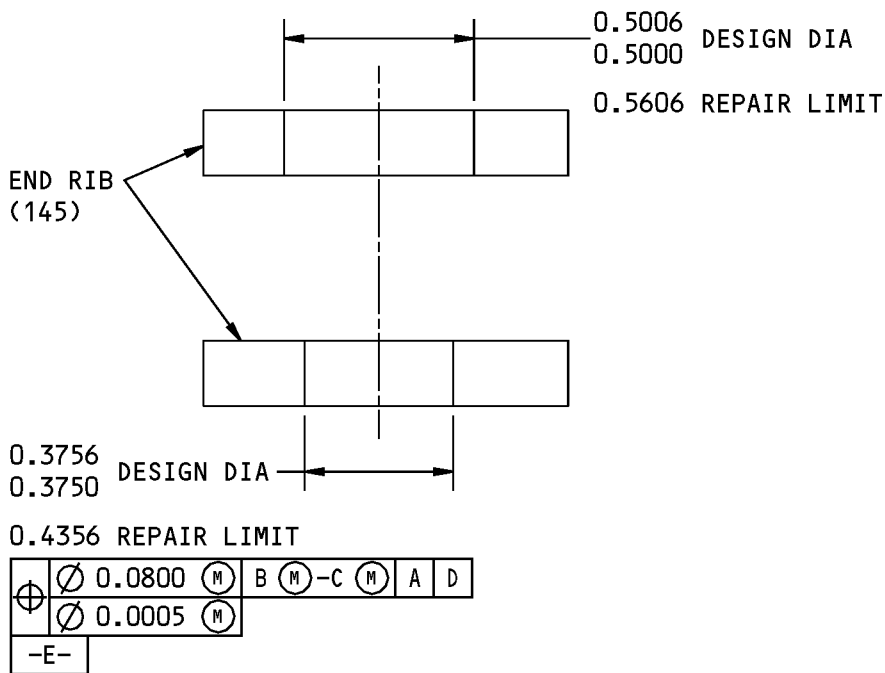
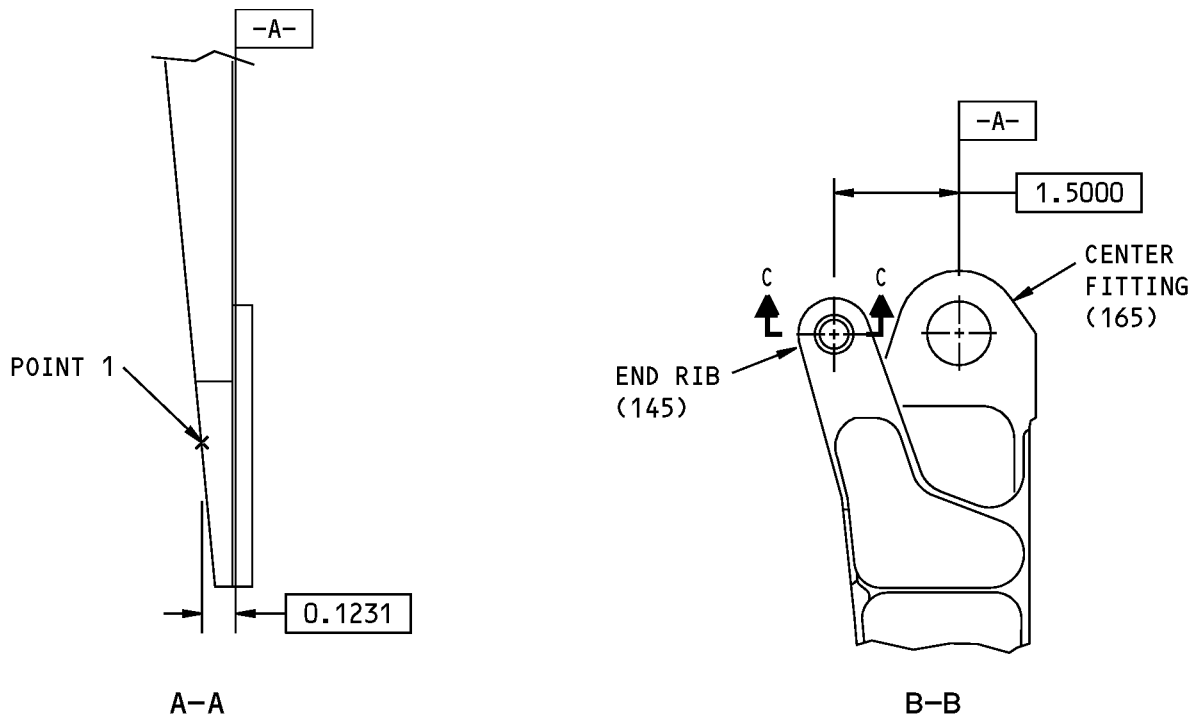
113A4110-1 SHOWN
 113A4110-2 OPPOSITE
 (THIS VIEW IS PERPENDICULAR TO DATUM -A-)

113A4110-1,2 Bond Panel Assembly Repair
 Figure 601 (Sheet 1 of 3)

57-56-63

REPAIR 2-2
 Page 604
 Mar 01/2006

COMPONENT MAINTENANCE MANUAL



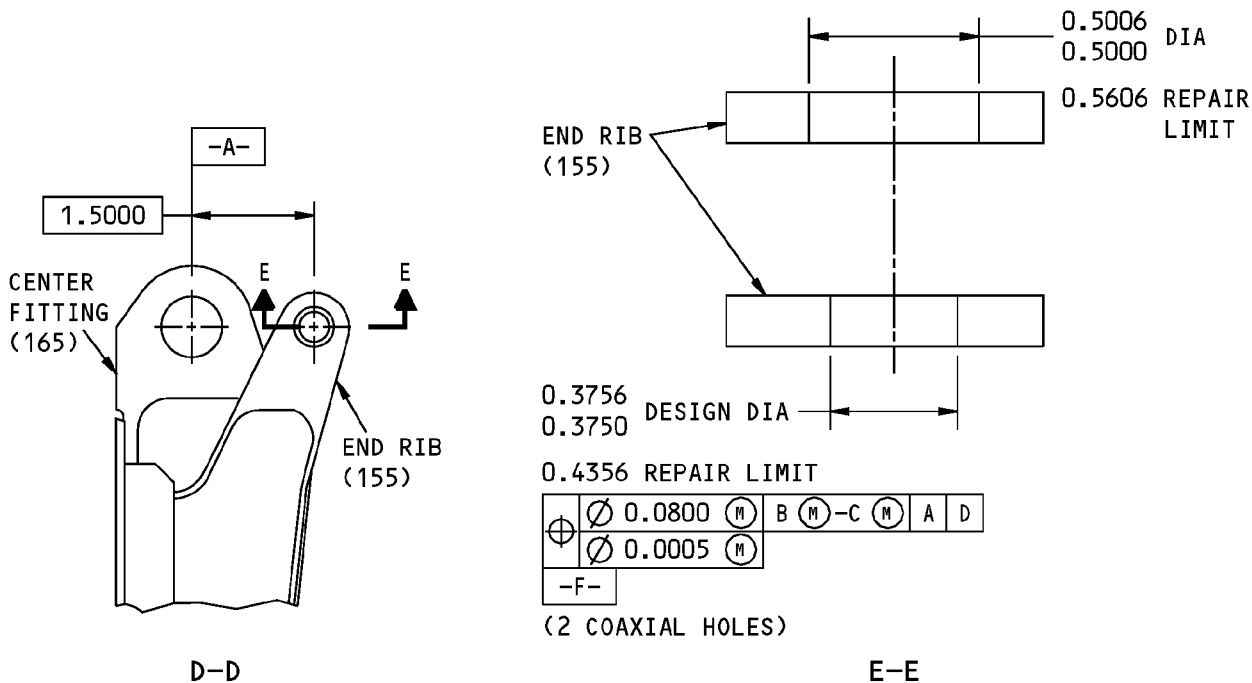
C-C

113A4110-1,-2 Bond Panel Assembly Repair
Figure 601 (Sheet 2 of 3)

57-56-63

REPAIR 2-2
Page 605
Mar 01/2006

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

113A4110-1,-2 Bond Panel Assembly Repair
Figure 601 (Sheet 3 of 3)

57-56-63

REPAIR 2-2
Page 606
Mar 01/2006

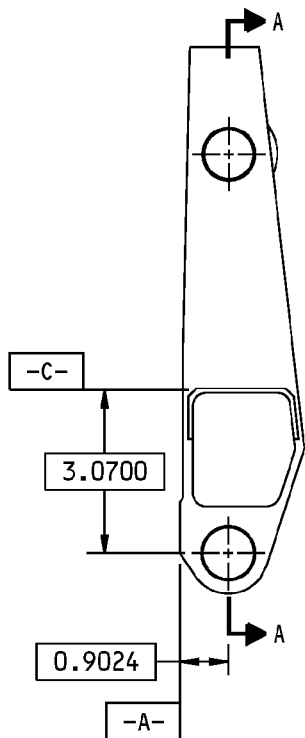
COMPONENT MAINTENANCE MANUAL

0.9379 DESIGN DIA
0.9370

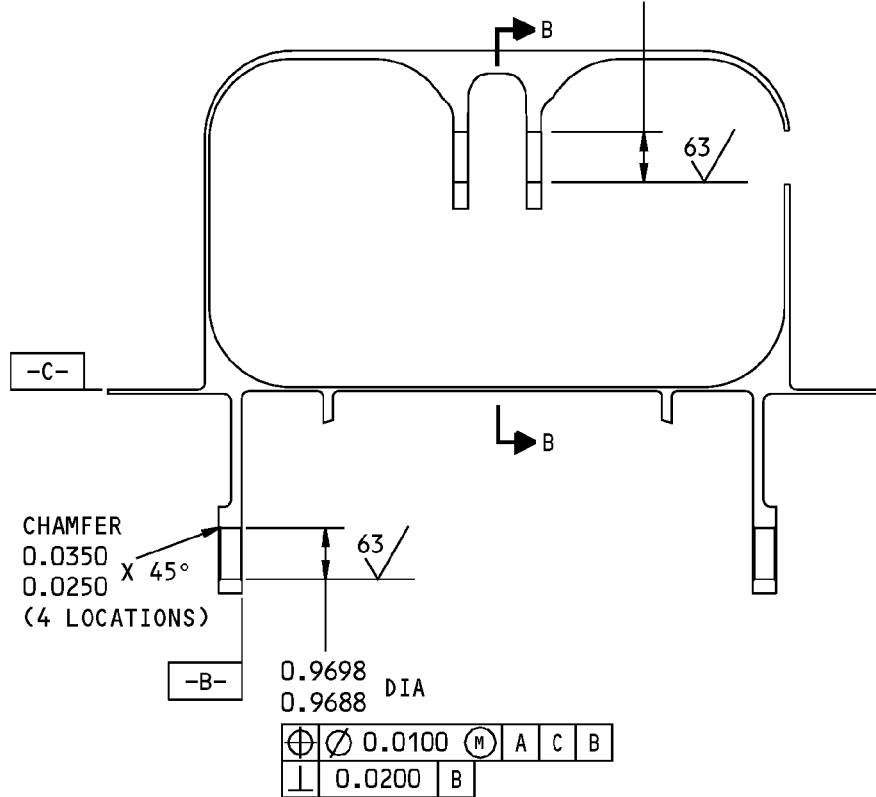
0.9979 REPAIR LIMIT

⊕	∅	0.0100	M	A	C
		0.0015			

(2 COAXIAL HOLES)



(SOME PARTS NOT SHOWN TO LET OTHER PARTS SHOW)



A-A

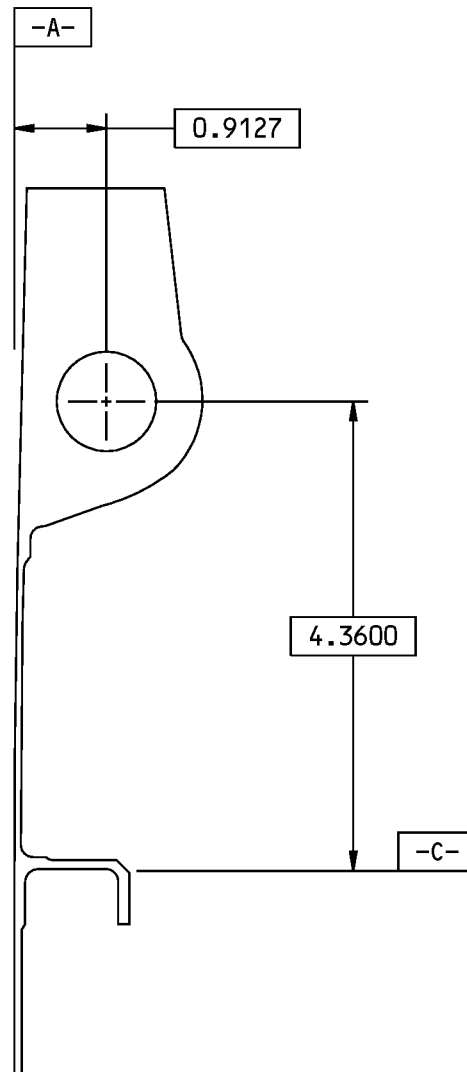
113A4120-1 Center Fitting Repair
Figure 602 (Sheet 1 of 2)

57-56-63

REPAIR 2-2
Page 607
Mar 01/2006



COMPONENT MAINTENANCE MANUAL



B-B

63/ ALL MACHINED SURFACES UNLESS
SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

113A4120-1 Center Fitting Repair
Figure 602 (Sheet 2 of 2)

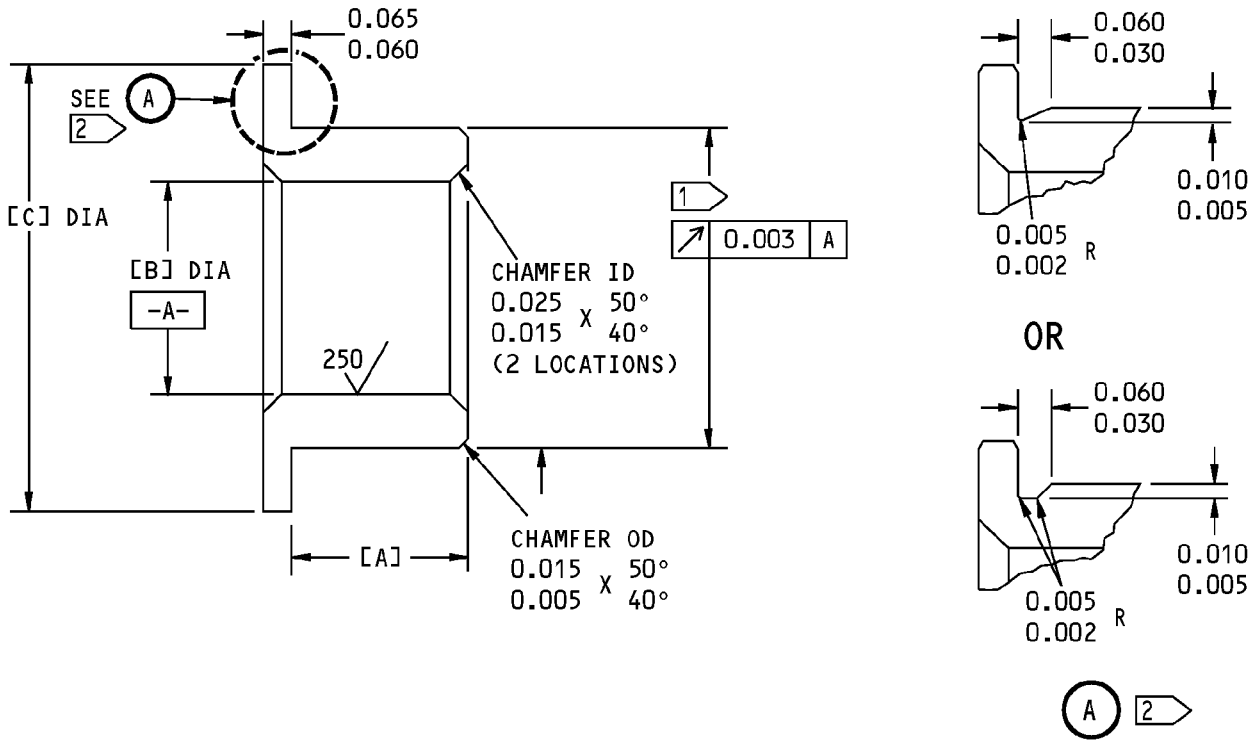
57-56-63

REPAIR 2-2

Page 608

Mar 01/2006

COMPONENT MAINTENANCE MANUAL



BUSHING TO BE REPLACED (IPL FIG. 1)	[A]	[B]	[C]	INTERFERENCE
10	0.140 0.135	0.2505 0.2500	0.540 0.530	0.0015 0.0003
15	0.140 0.135	0.3756 0.3750	0.630 0.620	0.0016 0.0004
25	0.270 0.265	0.7515 0.7500	1.260 1.240	0.0023 0.0004

1 THE OUTSIDE DIAMETER OF THE BUSHING AFTER PLATING IS EQUAL TO THE INSIDE DIAMETER OF THE LUG HOLE PLUS THE INTERFERENCE.

2 FOR BUSHING (25) ONLY.

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

Oversize Bushing Details
Figure 603

57-56-63

REPAIR 2-2

Page 609

Mar 01/2006



COMPONENT MAINTENANCE MANUAL

ASSEMBLY

1. General

- A. This procedure has the data necessary to assemble the No. 1 and 12 ground outboard spoiler assembly (1A, 5).
- 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. Assembly

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
C00528	Compound - Corrosion Preventive, Petroleum Hot Application (Soft Film)	MIL-C-11796, Class III
C00862	Coating - Chemical Conversion - Alodine 600	

B. References

Reference	Title
SOPM 20-11-03	REPAIR OF ELECTRICAL TERMINATIONS AND ELECTRICAL BONDING AREAS
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-41-02	APPLICATION OF CHEMICAL AND SOLVENT RESISTANT FINISHES
SOPM 20-43-03	CHEMICAL CONVERSION COATINGS FOR ALUMINUM
SOPM 20-50-01	BOLT AND NUT INSTALLATION
SOPM 20-60-02	FINISHING MATERIALS
SOPM 20-60-03	LUBRICANTS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

C. Procedure

NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For bolt and nut installation, refer to SOPM 20-50-01. For finishing materials, refer to SOPM 20-60-02. For lubricants, refer to SOPM 20-60-03. For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Use standard industry procedures and the steps shown below to assemble this component.
- (2) Install the jumper assemblies (45, 50) on the panel bond assembly (95, 100) (SOPM 20-11-03).

57-56-63

ASSEMBLY

Page 701

Mar 01/2009



COMPONENT MAINTENANCE MANUAL

- (a) Remove the finish, if necessary, in areas where you will install the jumper assemblies (45, 50).
 - (b) Apply Alodine 600 coating, C00862 (SOPM 20-43-03) by hand, brush, swab, or spray application (F-17.28) in areas you just removed the finish.
 - (c) Install the jumper assemblies (45, 50) on the panel bond assembly (95, 100) with bolts (30), washers (35), and nuts (40). Use three washers for installation, one washer (40) under the bolt head, and one washer (40) on each side of the jumper assembly (45, 50) (SOPM 20-11-03).
 - (d) Fillet seal the ends of the jumper assemblies (45, 50) with sealant, A00247.
- (3) Install the seal (75) on the panel bond assembly (95, 100).
- (a) In areas around the holes for bolts (55), apply primer, C00259 (SOPM 20-41-02) to all areas of the holes and countersink, counterbore, or other recess.
NOTE: Do the next step immediately after you complete this step.
 - (b) In areas around the holes for bolts (55), apply corrosion preventive compound, C00528 to all areas of the holes and countersink, counterbore, or other recess.
NOTE: Do the next step immediately after you complete this step.
 - (c) Install the seal (75) and seal retainer (70) on the panel bond assembly (95, 100) with bolts (55), washers (60), and nuts (65).

57-56-63

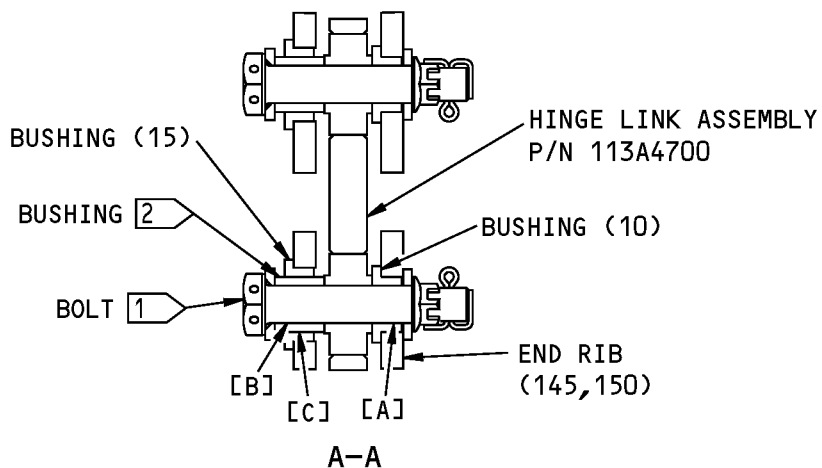
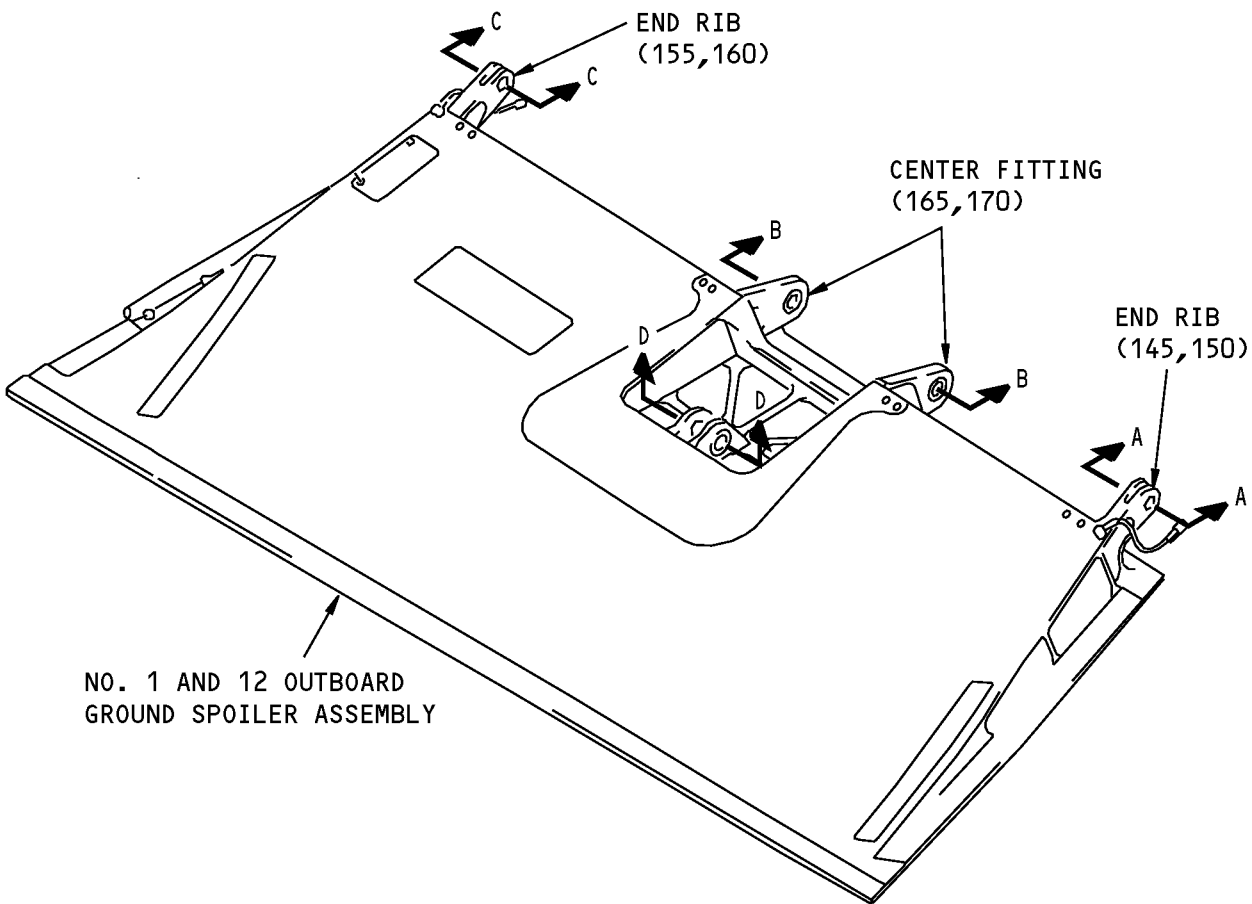
ASSEMBLY

Page 702

Nov 01/2008

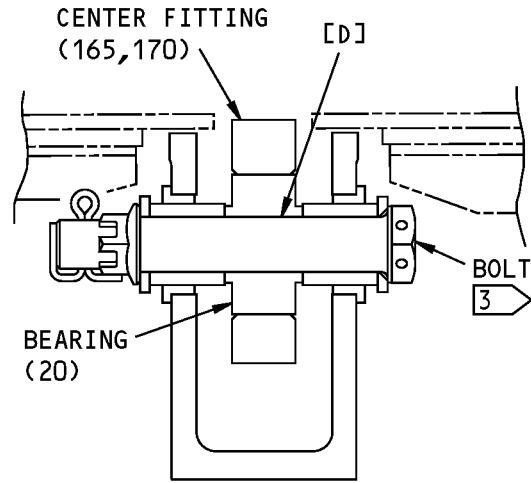
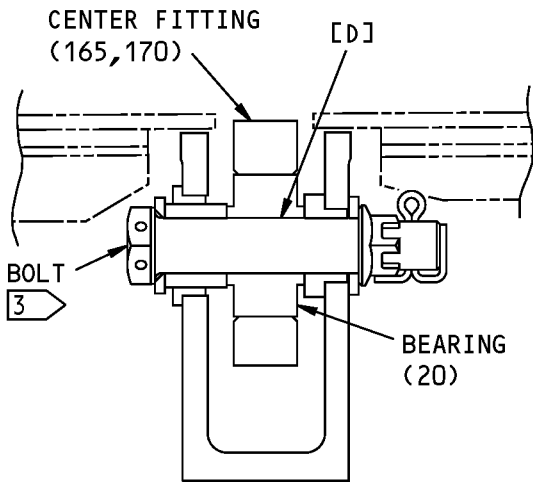
COMPONENT MAINTENANCE MANUAL

FITS AND CLEARANCES

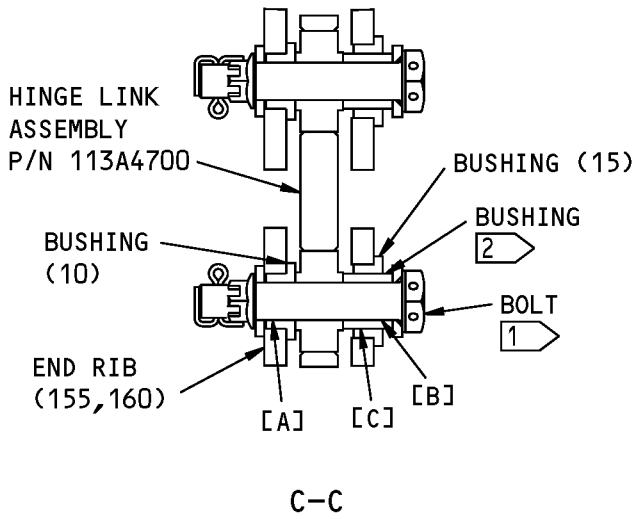


Fits and Clearances
Figure 801 (Sheet 1 of 3)

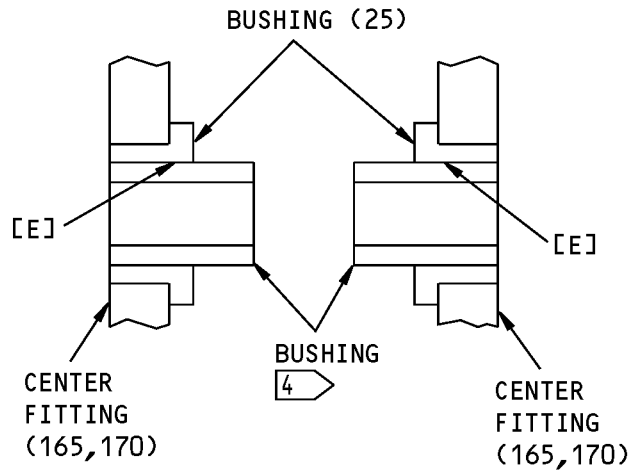
COMPONENT MAINTENANCE MANUAL



B-B



C-C



D-D

ITEM NUMBERS REFER TO IPL FIG. 1

Fits and Clearances
 Figure 801 (Sheet 2 of 3)







57-56-63

FITS AND CLEARANCES





Page 802

Mar 01/2006

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 (10)	0.2500	0.2505	0.0005	0.0020		0.2530	0.005
	OD BOLT 	0.2485	0.2495			0.2480		
[B]	ID BUSHING 	0.2500	0.2505	0.0005	0.0020		0.2530	0.005
	OD BOLT 	0.2485	0.2495			0.2480		
[C]	ID BUSHING (15)	0.3750	0.3756	0.0005	0.0016		0.3795	0.005
	OD BUSHING 	0.3740	0.3745			0.3700		
[D]	ID BEARING (20)	0.3750	0.3755	0.0005	0.0020		0.3780	0.005
	OD BOLT 	0.3735	0.3745			0.3730		
[E]	ID BUSHING (25)	0.7500	0.7515	0.0010	0.0030		0.7775	0.005
	OD BUSHING 	0.7485	0.7490			0.7465		

* ALL DIMENSIONS ARE IN INCHES

-  INSTALLATION BOLT, P/N
BACB30NM4DK16
-  INSTALLATION BUSHING, P/N
BACB28AK04-034
-  INSTALLATION BOLT, P/N
BACB30NM6DK22
-  INSTALLATION BUSHING, P/N
BACB28BA1012063

Fits and Clearances
Figure 801 (Sheet 3 of 3)

57-56-63
FITS AND CLEARANCES
Page 803
Mar 01/2006



COMPONENT MAINTENANCE MANUAL

SPECIAL TOOLS, FIXTURES, AND EQUIPMENT

(NOT APPLICABLE)

57-56-63

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

57-56-63

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
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
62554	SIMMONDS MECAERO FASTENERS INC 1734 SEQUOIA AVENUE ORANGE, CALIFORNIA 92668

57-56-63

ILLUSTRATED PARTS LIST

Page 1002

Jul 01/2008



COMPONENT MAINTENANCE MANUAL

Code	Name
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

57-56-63

ILLUSTRATED PARTS LIST

Page 1003

Jul 01/2008



COMPONENT MAINTENANCE MANUAL

NUMERICAL INDEX

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
100220-6		1	50	1
100220-7		1	45	1
113A4100-1		1	1A	RF
113A4100-2		1	5	RF
113A4100-3		1	1B	RF
113A4100-4		1	5A	RF
113A4110-1		1	95	1
113A4110-2		1	100	1
113A4110-3		1	115	1
113A4110-4		1	120	1
113A4111-1		1	130	1
113A4111-3		1	135	1
113A4112-1		1	145	1
113A4112-2		1	150	1
113A4112-3		1	155	1
113A4112-4		1	160	1
113A4114-1		1	110	1
113A4114-9		1	105	2
113A4120-1		1	165	1
113A4120-2		1	170	1
113A4150-9		1	75	1
113A4160-1		1	70	1
113A4160-9		1	70A	1
940CW20-6		1	50	1
940CW20-7		1	45	1
ADW06V301NC		1	20	2
BAC27NCT0217		1	185	1
BACB10FA06GC		1	20	2
BACB28AP04P014		1	10	2
BACB28AT06B014C		1	15	2
BACB28X12M027		1	25	2
BACB30VF08K4		1	55	6
BACJ40AB20-6		1	50	1
BACJ40AB20-7		1	45	1

57-56-63

ILLUSTRATED PARTS LIST

Page 1004

Jul 01/2008



COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACN10JC08CD		1	65	6
BACN10YR3CD		1	40	2
BACR15BB3D		1	175	2
BACR15CE5D		1	85A	1
BACR15CE6D		1	80	4
BACR15FT6D		1	90	8
		1	125	16
BACR15GF5D		1	85B	1
BACR15GF6D		1	80A	4
BACS12GU3K7		1	30	2
BACS40R008B018F		1	140	AR
H52732-3CD		1	40	2
KSC152200BZ06GC		1	20	2
KWDB06-35		1	20	2
MS27253-1		1	180	1
NAS1149D0316J		1	35	6
NAS1149DN832J		1	60	6
PLH53CD		1	40	2
RBEJ40AB20-6		1	50	1
RBEJ40AB20-7		1	45	1
SWKRS06-350SC		1	20	2
WES06FAGC		1	20	2
WHTFA06VC		1	20	2

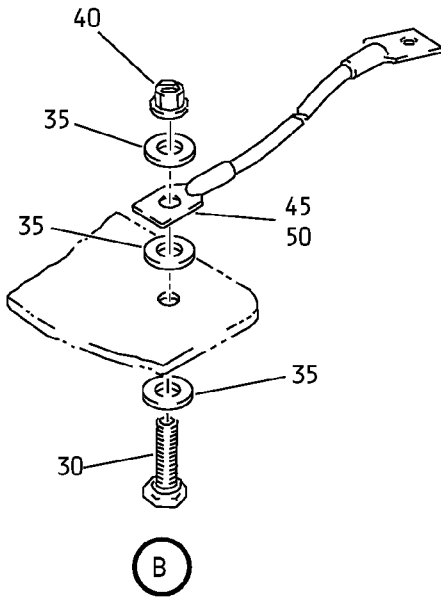
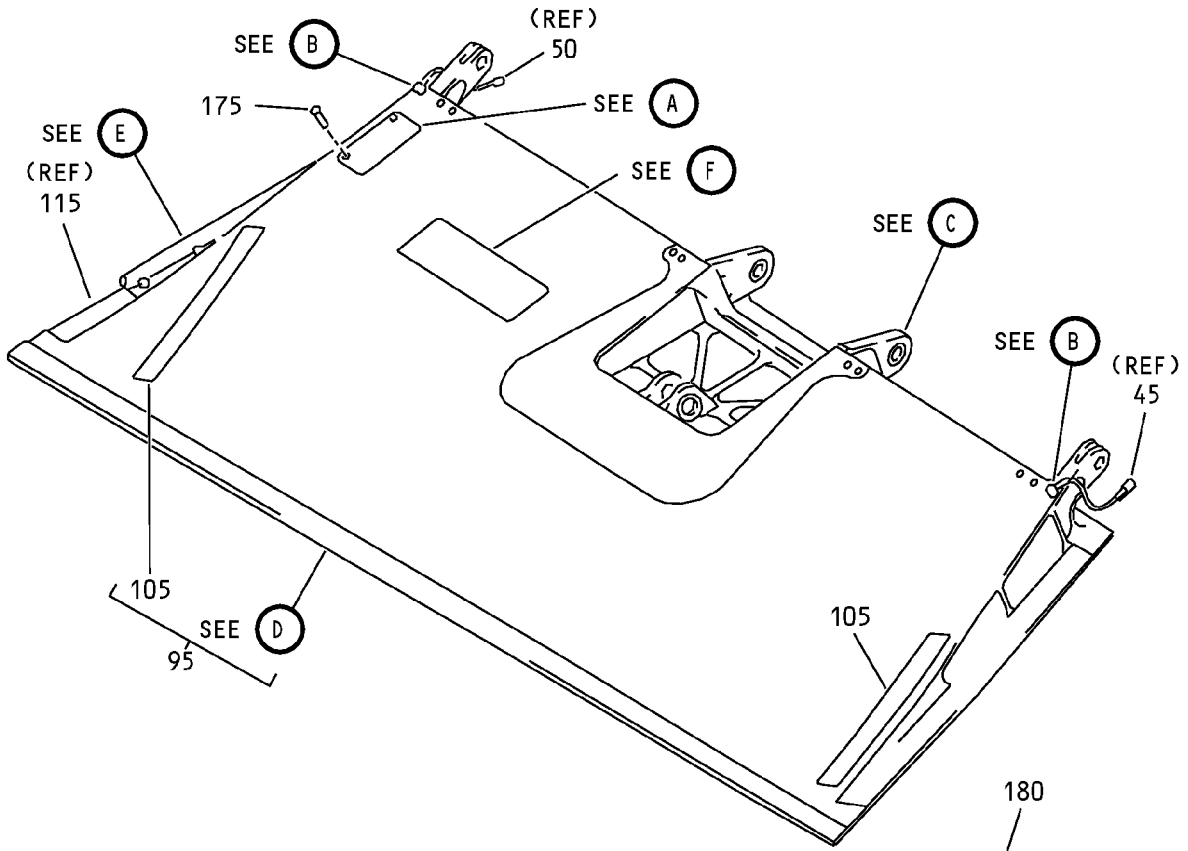
57-56-63

ILLUSTRATED PARTS LIST

Page 1005

Jul 01/2008

COMPONENT MAINTENANCE MANUAL



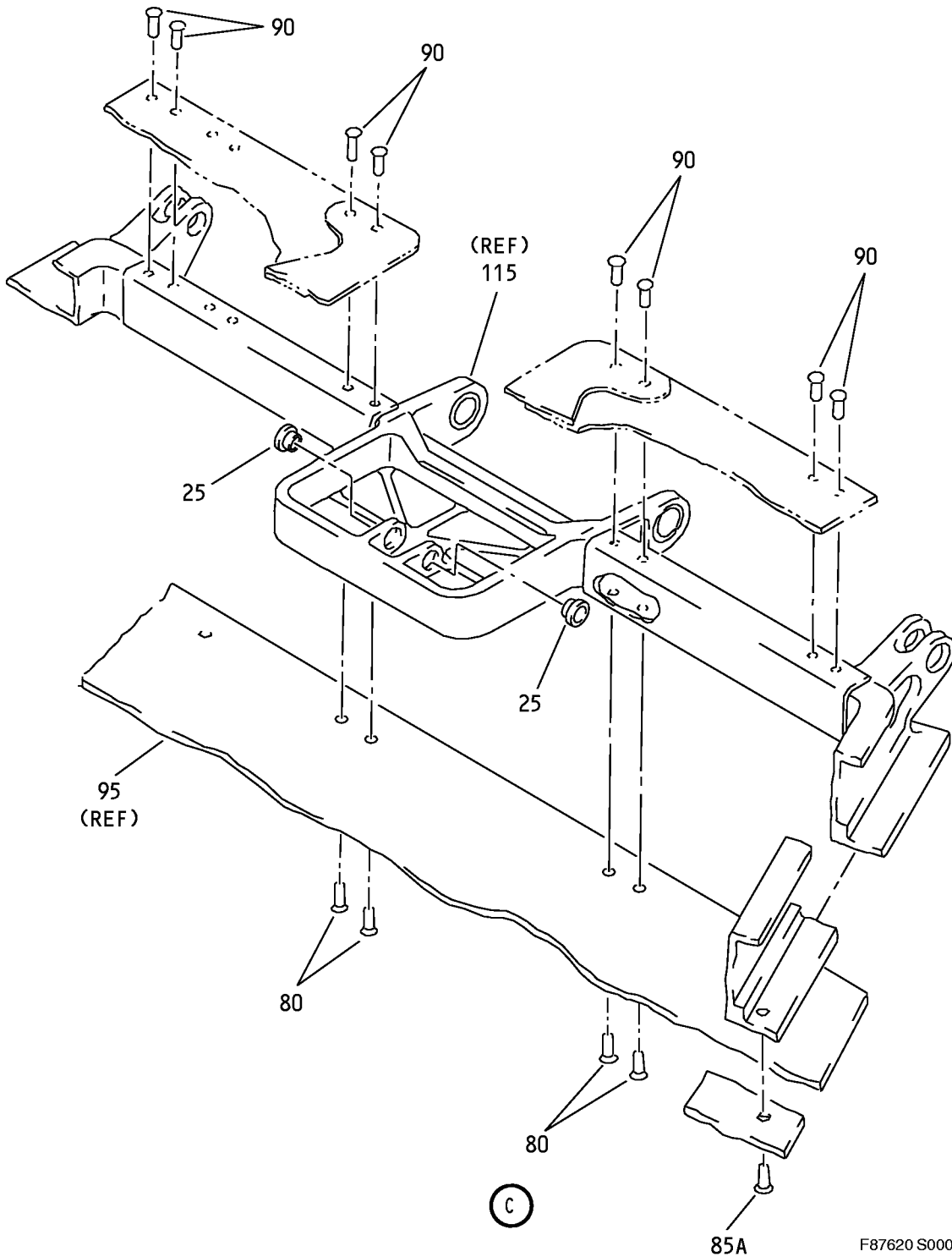
(B)

AIRCRAFT MOD.	
MFR. CODE	
PART NO.	
CONT NO.	
SERIAL NO.	
CONT.	CUST.
INSP.	INSP.
MODIFICATION INCORPORATED	

(A)

No. 1 and 12 Outboard Ground Spoiler Assemblies
IPL Figure 1 (Sheet 1 of 5)

COMPONENT MAINTENANCE MANUAL



F87620 S00041007923_V2

No. 1 and 12 Outboard Ground Spoiler Assemblies
IPL Figure 1 (Sheet 2 of 5)

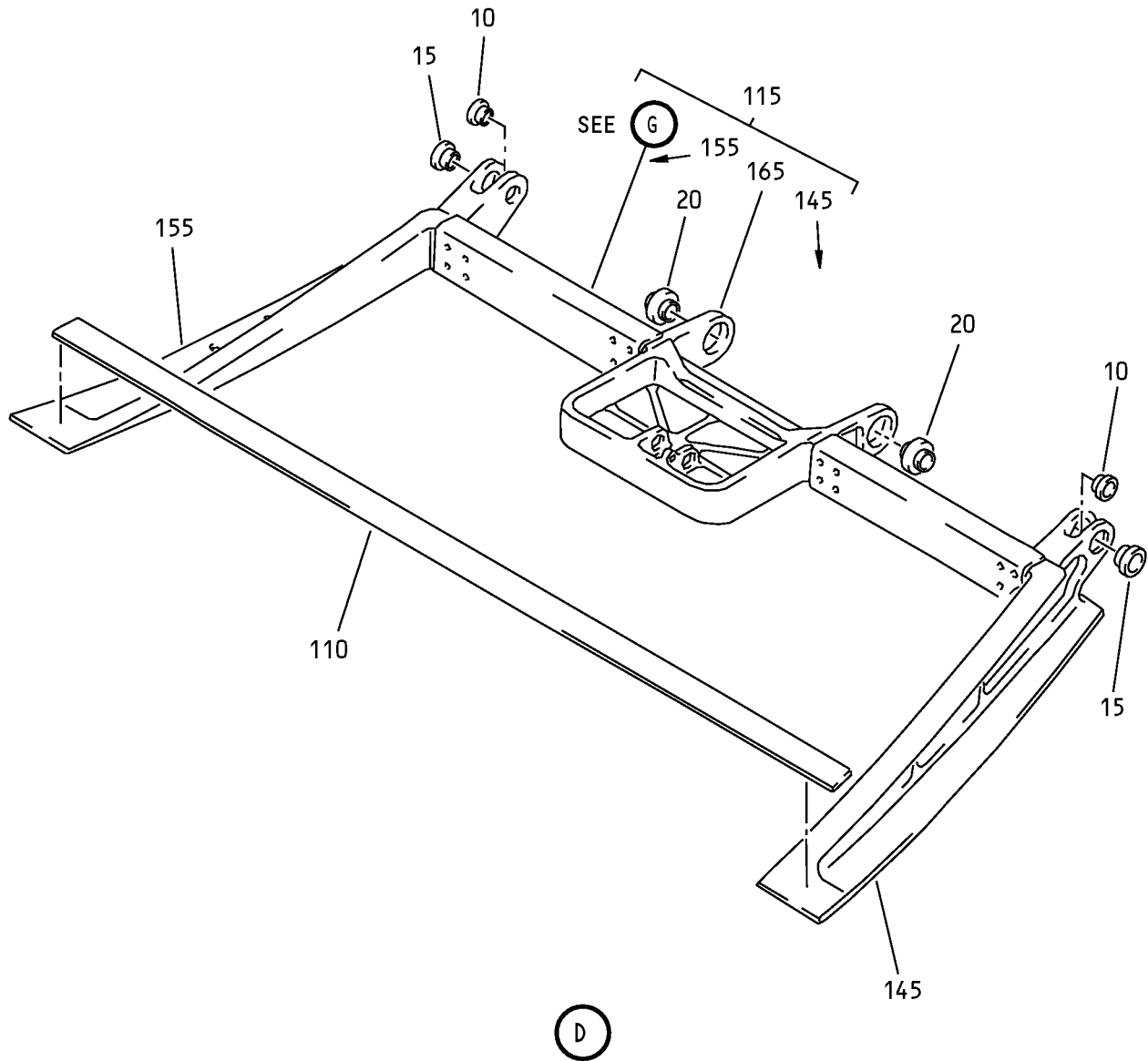
57-56-63

ILLUSTRATED PARTS LIST

Page 1007

Jul 01/2008

COMPONENT MAINTENANCE MANUAL



No. 1 and 12 Outboard Ground Spoiler Assemblies
IPL Figure 1 (Sheet 3 of 5)

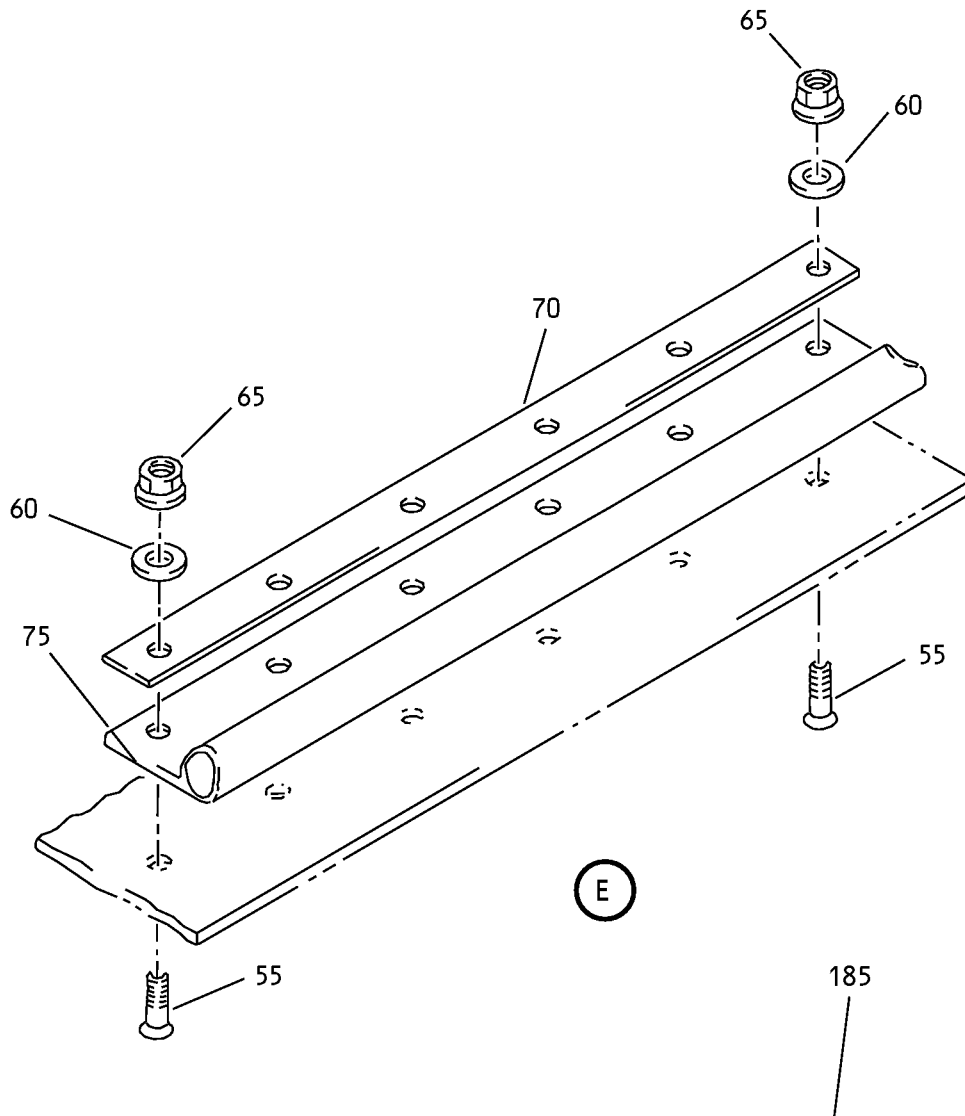
57-56-63

ILLUSTRATED PARTS LIST

Page 1008

Mar 01/2006

COMPONENT MAINTENANCE MANUAL



WARNING
HAZARDOUS-AREA

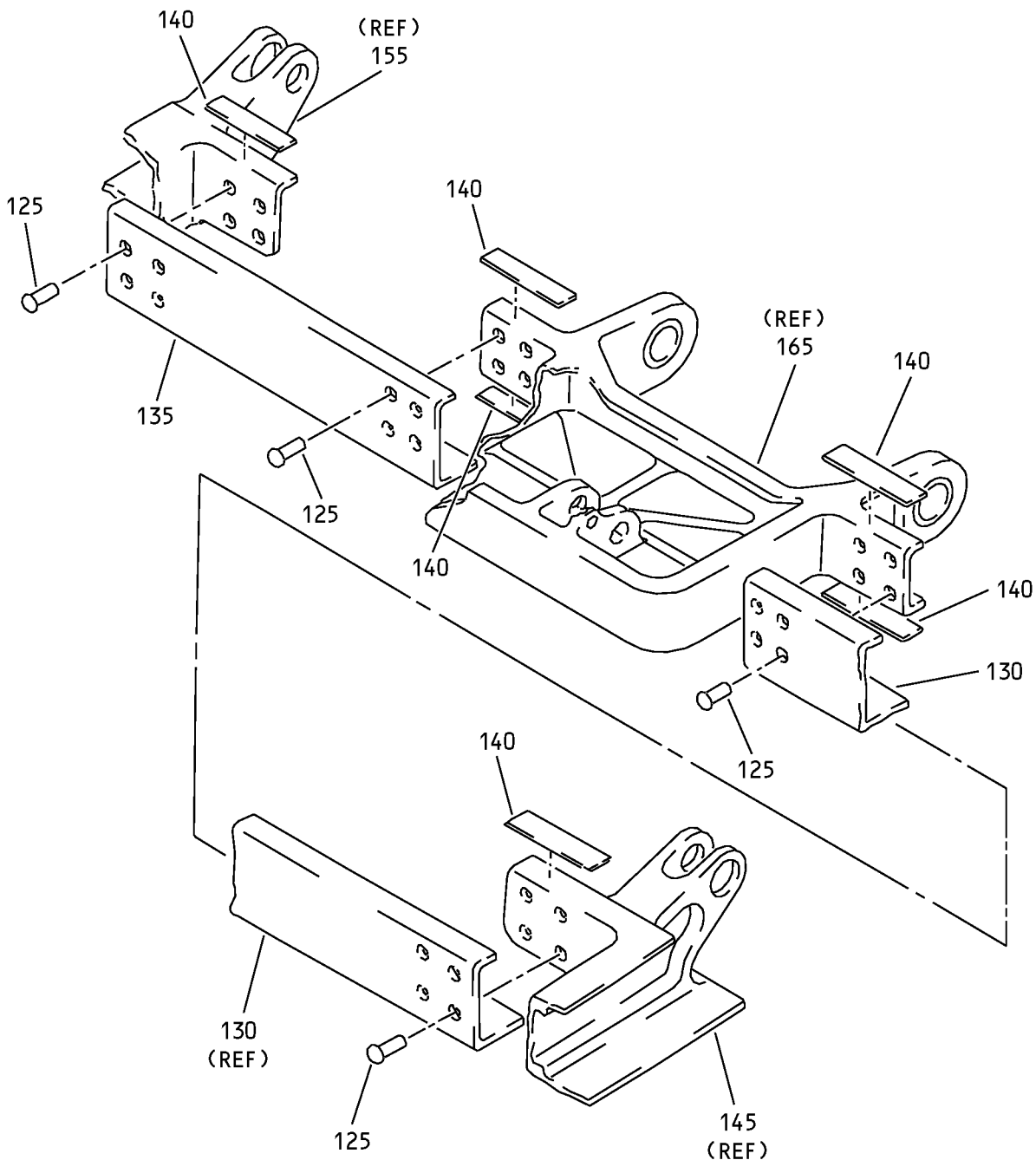
TO PREVENT AUTOMATIC RETRACTION IF HYDRAULIC PRESSURE IS APPLIED OR IF ELECTRICAL POWER IS LOST, DEACTIVATE SPOILER/SPEEDBRAKE CONTROL SYSTEM PER MAINTENANCE MANUAL SECTION 27-61-00 BEFORE ENTERING AREA TO PERFORM ANY MAINTENANCE OPERATION.

BAC27NCT0217

(F)

No. 1 and 12 Outboard Ground Spoiler Assemblies
 IPL Figure 1 (Sheet 4 of 5)

COMPONENT MAINTENANCE MANUAL



G

No. 1 and 12 Outboard Ground Spoiler Assemblies
IPL Figure 1 (Sheet 5 of 5)

57-56-63

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-											
-1A	113A4100-1		SPOILER ASSY-NO. 1 AND NO. 12, OUTBD GND							A	RF
-1B	113A4100-3		SPOILER ASSY-NO. 1 AND NO. 12, OUTBD GND							C	RF
-5	113A4100-2		SPOILER ASSY-NO. 1 AND NO. 12, OUTBD GND							B	RF
-5A	113A4100-4		SPOILER ASSY-NO. 1 AND NO. 12, OUTBD GND							D	RF
10	BACB28AP04P014		. BUSHING								2
15	BACB28AT06B014C		. BUSHING								2
20	ADW06V301NC		. BEARING (V15860) (SPEC BACB10FA06GC) (OPT SWKRS06-350SC (V81376)) (OPT KSC152200BZ06GC (V50632)) (OPT KWDB06-35 (V97613)) (OPT WES06FAGC (V73134)) (OPT WHTFA06VC (VS0352))								2
25	BACB28X12M027		. BUSHING								2
30	BACS12GU3K7		. SCREW								2
35	NAS1149D0316J		. WASHER								6
40	H52732-3CD		. NUT (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))								2
45	940CW20-7		. JUMPER ASSY (V91812) (SPEC BACJ40AB20-7) (OPT 100220-7 (V1FF12)) (OPT RBEJ40AB20-7 (V1GK47))								1
50	940CW20-6		. JUMPER ASSY (V91812) (SPEC BACJ40AB20-6) (OPT 100220-6 (V1FF12)) (OPT RBEJ40AB20-6 (V1GK47))								1
55	BACB30VF08K4		. BOLT								6
60	NAS1149DN832J		. WASHER								6
65	BACN10JC08CD		. NUT								6

-Item not Illustrated

57-56-63

ILLUSTRATED PARTS LIST

Page 1011

Nov 01/2008



COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
70	113A4160-1		.							A, B	1
-70A	113A4160-9		.							C, D	1
75	113A4150-9		.								1
80	BACR15CE6D		.								4
-80A	BACR15GF6D		.							C, D	4
-85	BACR15CE4D										
85A	BACR15CE5D		.							A, B	1
-85B	BACR15GF5D		.							C, D	1
90	BACR15FT6D		.								8
95	113A4110-1		.							A, C	1
-100	113A4110-2		.							B, D	1
105	113A4114-9		.	.							2
110	113A4114-1		.	.							1
115	113A4110-3		.	.						A, C	1
-120	113A4110-4		.	.						B, D	1
125	BACR15FT6D		.	.	.						16
130	113A4111-1		.	.	.						1
135	113A4111-3		.	.	.						1
140	BACS40R008B018F		.	.	.						AR
145	113A4112-1		.	.	.					A, C	1
-150	113A4112-2		.	.	.					B, D	1
155	113A4112-3		.	.	.					A, C	1
-160	113A4112-4		.	.	.					B, D	1
165	113A4120-1		.	.	.					A, C	1
-170	113A4120-2		.	.	.					B, D	1

-Item not Illustrated

57-56-63

ILLUSTRATED PARTS LIST

Page 1012

Nov 01/2008



COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
175	BACR15BB3D										2
180	MS27253-1										1
185	BAC27NCT0217										1

-Item not Illustrated