TO: ALL HOLDERS OF AILERON CENTERING MECHANISM ASSEMBLY OVERHAUL MANUAL, 27-14-21

REVISION NO. 21, DATED MAR 1/08

HIGHLIGHTS

DESCRIPTION OF CHANGE	TOPICS AFFECTED												
	D & O	D / Assy	Cleaning	Insp/Chk	Repair	Assy	F/C	Test	T/Shooting	S/Tools	Storage	IPL	L/Overhaul
Added 65-50555-11 as an option for use on top assemblies 65-75960-5 thru -20												X	

AILERON CENTERING MECHANISM ASSEMBLY

27-14-21

BOEING P/N 65-52283-6
65-75960-2, -4, -5, -6, -8, -12, -14, -17 thru -20, -22, -23, -25

AIRLINE P/N

THE FOLLOWING DIRECTIVES APPLY TO THIS SUBJECT:

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVES	DATE DIRECTIVE INCORPORATED INTO TEXT
		PRR 30652	Mar 10/70
		PRR 30732	Mar 10/70
27-1021		PRR 31393	Mar 10/70
		PRR 32039	Mar 25/74
		PRR 32121-10	Jun 10/72
		PRR 32609	Jul 5/79
		PRR 32900-1	Jul 5/79
		PRR 32912-1	Jul 5/79
		PRR 33625	Sep 5/84
27-1134			Mar 5/87
		PRR 33410-59	Mar 5/87
		PRR 34475-2	Mar 5/89
		PRR 34533	Mar 5/89
27-1155			Mar 5/90
		PRR 35037	Jun 5/92

LIST OF EFFECTIVE PAGES

* Indicates pages revised, added or deleted in latest revision
F Indicates foldout pages - print one side only

	PAGE	DATE	PAGE	DATE	PAGE	DATE
27-14-21						
	T-1	Jun 5/92				
	T-2	BLANK				
*	LEP-1	Mar 1/08				
	LEP-2	BLANK				
	T/C-1	Jul 5/79				
	T/C-2	BLANK				
	1	Jul 1/99				
	2	BLANK				
	101	Mar 5/89				
	102	Mar 1/00				
	201	Jul 5/79				
	202	BLANK				
	301	Mar 1/00				
	302	BLANK				
	401	Mar 1/00				
	402	Mar 1/00				
	402A	Mar 1/00				
	402B	BLANK				
	403	Jul 5/79				
	404	Jul 1/99				
	405	Nov 1/07				
	406	BLANK				
	501	Nov 1/03				
	502	Jul 1/99				
	601	Mar 1/00				
	602	Jan 5/81				
	603	Mar 1/00				
	604	BLANK				
	1101	Dec 5/93				
	1102	Jul 1/99				
	1103	Mar 5/89				
	1104	Mar 1/00				
*	1105	Mar 1/08				
	1106	Jun 5/92				
	1107	Dec 1/94				
	1108	Mar 1/02				
	1109	Mar 1/00				
	1110	BLANK				

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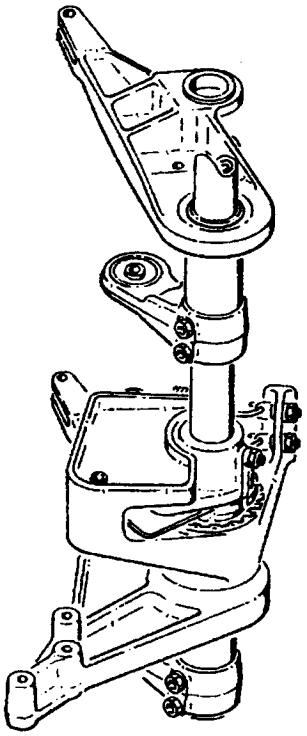
*[1] Use applicable procedures contained in 20-44-02, and standard industry practices.

AILERON CENTERING MECHANISM ASSEMBLY



Aileron Centering Mechanism Assembly
Figure 1

DESCRIPTION AND OPERATION

1. The mechanism assembly provides aileron control system centering and artificial feel. It consists of cam, roller arm, support, and two springs. The cam is fastened to the control quadrant shaft by the use of bolts. The roller arm and attached roller pivot on the support. The springs hold the roller in the cam detent, providing control system centering and artificial feel.

2. Leading particulars

   Length -- 12 inches
   Width -- 10 inches
   Height -- 28 inches
   Weight -- 10.40 pounds

DISASSEMBLY

1. Procedure (Fig. 1101)

   A. Remove sleeve (1), reaction support assembly (2), and bearing (3).

      NOTE: Do not remove bushings (4) from reaction support (5) unless replacement is necessary.

   B. Remove spacer (6), nuts (7), washers (8), bolts (9), and lever assembly (10).

      NOTE: Do not remove bearing (11), sleeve (12), collar (12A), lockbolt (12B), or separate levers (13 and 14) unless replacement is necessary.

   C. Remove nuts (15), washers (17), and eyebolts (18).

   D. Remove nuts (16) from eyebolts (18).

   E. Remove cotter pins (19), washers (20), and straight pins (21) to disconnect springs (22) from roller arm assembly (34).

   F. Remove nuts (23), washers (24), and bolts (25).

   G. Remove nuts (26), washers (27), and screws (28).

   H. Remove cotter pin (29), nut (30), washer (31), and bolt (32) to disconnect roller arm assembly (34).

   I. Remove cotter pin (32A), nut (32B), washer (32C), bolt (32D), and bearing (33) from roller arm assembly (34).

      NOTE: Do not remove bearing (35) from arm (36) unless replacement is necessary.

   J. Remove hub (37), cam (38), nut (39), washer (40), bearings (41), spacer (42) and support assembly (43).

      NOTE: Do not remove bushing (44) from support (45) or plug (38C) from cam (38B) unless replacement is necessary.

   K. Remove nuts (46), washers (47), bolts (48), and lever assembly (49).

      NOTE: Do not remove bearing (50), sleeve (51), collar (51A), lockbolt (51B), or separate levers (52 and 53) unless replacement is necessary.

L. Remove spacer (55).

M. Remove retainer (55A), sleeve (55B) and support (60) from outer tubing (62).

N. Remove screws (56A), fillers (56B), bearing (57), and sleeve (58) from support (60).

NOTE: Do not remove bushings (59), or inserts (59A) from support (60) unless replacement is necessary.

O. Separate inner tubing (61) and outer tubing (62).

CLEANING

1. Clean all parts except bearings (3, 11, 35, 41, 50, 57) in accordance with standard industry practices and the information contained in 20-30-03. Clean bearings (3, 11, 35, 41, 50, 57) by special method for teflon lined bearing per 20-30-01.

INSPECTION/CHECK

1. Check all parts for obvious defects in accordance with standard industry practices. Refer to Fits and Clearances for design dimensions and wear limits.

2. Penetrant check sleeves (1, 55B, 58), supports (5, 45, 60), levers (13, 14, 52, 53), arm (36), hub (37), plug (38C), nut (39), retainer (55A), and tubing (61, 62) per SOPM 20-20-02.

3. Magnetic particle check spring (22) and cam (38) per SOPM 20-20-01.

4. Spring Check (22; 69-39429-2 only)

   NOTE: Free length inside hooks is approximately 3.68 inches.

   A. Extend spring to 3.91-inch length. Load shall be 7.35 - 8.35 lb.

   B. Extend spring to 5.63-inch length. Load shall be 61.35 - 69.35 lb.

5. Spring Check (22; 69-39429-3 only)

   NOTE: Free length inside hooks is approximately 3.635 inches.

   A. Extend spring to 3.86-inch length. Load shall be 6.92-7.92 lb.

   B. Extend spring to 5.31-inch length. Load shall be 51.5-59.4 lb.

6. Check cam (38) for roughness or uneven wear. Maximum allowable depth of any dents is 0.005 inch.

7. Check bearing (33) for roughness. OD shall not be less than 0.896 inch at any point. Maximum radial play: 0.002 inch.

REPAIR

1. Repair (Fig. 1101)

   A. Remove minor defects in accordance with standard industry practices. Refer to Fig. 601 for design dimensions and wear limits.

   B. Bearing bores of support assembly (43).

      (1) Machine bores as required to remove defects. Do not exceed diameter of 2.370 inches.

      (2) Manufacture and install cadmium plated steel bushing in one or both holes, as applicable. Bushing OD to have interference fit of 0.0013 - 0.0032 inch.

      (3) Machine bushing bore to design diameter of 2.2500 - 2.2515 inch.

2. Refinish

   NOTE: Refer to SOPM 20-30-02 for stripping of protective finishes and to SOPM 20-41-01 for explanation of F and SRF finish codes.

   A. Sleeve (1, 55B, 58), Spacer (6, 55), Tubing (61, 62) -- Alodize followed by primer, BMS 10-11, Type 1 (SRF-2.901), all over except no primer on bearing surface. Material: Al alloy.

   B. Reaction Support (5; 65-50555-2, -6 only), Levers (13, 14, 52, 53), Filler (56B) -- Alodize or chromic acid anodize and apply primer, BMS 10-11, Type 1 (F-18.05), all over except no primer on bushing and bearing surfaces and inside diameter of mounting hole. Material: Al alloy.

   C. Bolts (18), Washers (40) -- Cadmium plate (SRF-1.1926) all over.

   D. Spring (22; 69-39429-2 only) -- Apply primer, BMS 10-11, Type 1 (SRF-12.206), all over.

   E. Arm (36) -- Sulfuric acid anodize (F-2.201) followed by primer, BMS 10-11, Type 1 (SRF-12.205), all over except in 0.7488-inch diameter hole. Material: Al alloy.

   F. Hub (37) -- Sulfuric acid anodize (F-2.201) followed by primer, BMS 10-11, Type 1 (SRF-12.205), all over except 1.421-inch diameter hole. Apply primer, BMS 10-11, Type 1 (SRF-12.206) on cam surface. Material: Al alloy.

   G. Cam (38; 69-39428-2, -3, -4 and 69-68793-1 only) -- Passivate (F-8.07) followed by primer, BMS 10-11, Type 1 (SRF-12.206), all over except no primer on surface shown in Fig. 401. Material: 17-7PH CRES (180-200 ksi).

H. Nut (39) -- Alodize or chromic acid anodize followed by primer, BMS 10-11, Type 1 (SRF-2.30), all over except omit primer on threads. Material: Al alloy.

I. Spacer (42) -- Alodize followed by primer, BMS 10-11, type 1 (SRF-2.901), all over. Material: Al alloy.

J. Support (45) -- Sulfuric acid anodize (F-2.201) followed by primer, BMS 10-11, Type 1 (SRF-12.205), all over except no primer on bushing and bearing surfaces. Material: Al alloy.

K. Retainer (55A) -- Alodize or chromic acid anodize followed by primer, BMS 10-11, Type 1 (SRF-2.30), all over except omit primer on surfaces indicated in Fig. 401. Material: Al alloy.

L. Reaction support (60) -- Alodize or chromic acid anodize and apply primer, BMS 10-11, Type 1 (SRF-2.30), all over except no primer on bushing, bearing and sleeve surfaces, threaded areas and inside diameter of the four 0.250-inch holes. On 65-75928-4 assy, apply enamel BMS 10-60 white gloss (SRF-14.9812), to primed surfaces. Material: Al alloy.

M. Reaction support (5; 65-50555-10 only) -- Chemical treat and apply one coat of BMS 10-11, Type 1 primer (F-18.06). Apply one coat of BMS 10-11, type II enamel, color BAC702 white gloss (SRF-21.03). No primer or enamel on bushing and bearing surfaces and inside diameter of mounting hole. Material: Al alloy.

N. Cam (38; 69-39428-5 only) -- Passivate (F-17.09). Apply two coats BMS 10-11, Type 1 primer (F-20.03) and apply BMS 10-60 Boeing color 702 white gloss enamel (SRF-14.9812) all over except no primer or enamel on surface shown in Fig. 401. Material: 15-5 PH CRES (180-200 ksi).

O. Spring (22; 69-39429-3 only) -- Passivate (F-17.09). Material: 17-7 PH CRES.

3. Replacement

A. Discard all cotter pins.

B. Bearing (35), bushing (4, 59) -- Assemble with wet BMS 10-11, type 1 primer. Install bearings and bushings per SOPM 20-50-03. After installation of bushings (4, 59), in-line machine through both bushings to an inside diameter of 1.0000-1.0005 inches with a surface texture of 125 microinches.

C. Bushing (44) -- Install with MIL-C-11796, class 3 corrosion preventive compound on both surfaces of press fit.

D. Bearings (11, 50) -- Install and roller swage both sides, Type 1, per SOPM 20-50-03.

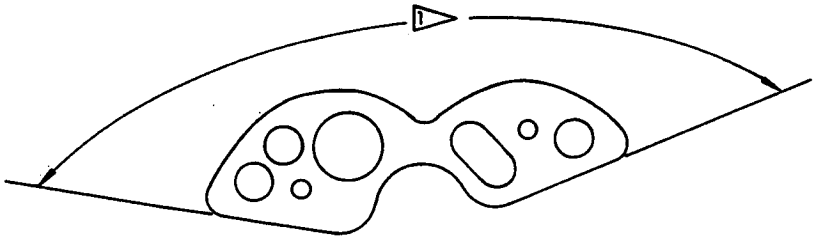
E. If levers (13, 14, 52, 53) were separated in repair, bond in pairs (13, 14) and (52, 53) per SOPM 20-50-12, using type 38 adhesive, special method II, after primer has cured.

F. Deleted

G. Deleted

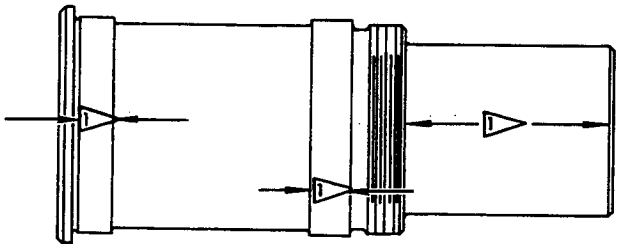
H. Replace bearings (41) if worn.

I. When replacing sleeves (1, 55B, 58), levers (10, 49), hub (37), retainer (55A), tubing (61, 62), locate and drill holes for bolts (9, 25, or 48) as applicable per Fig. 402.



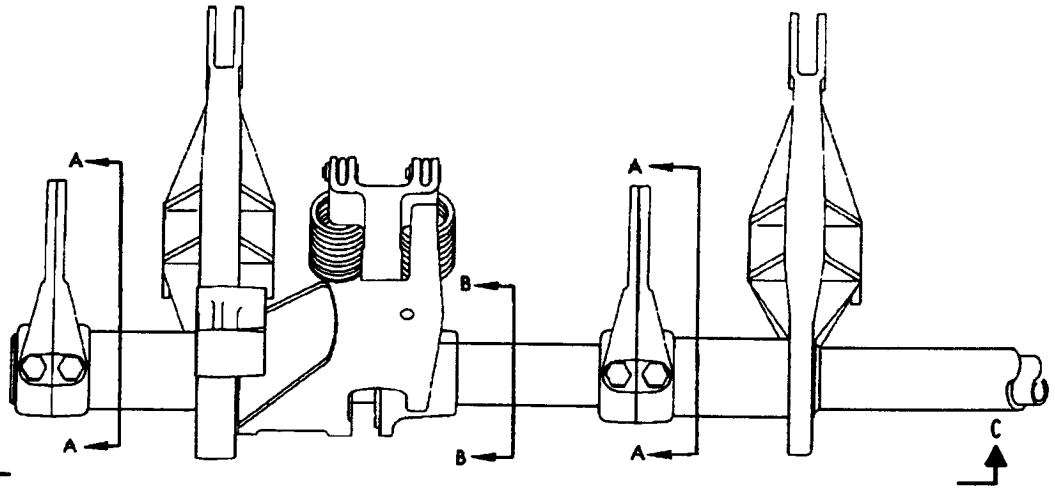
CAM (38)

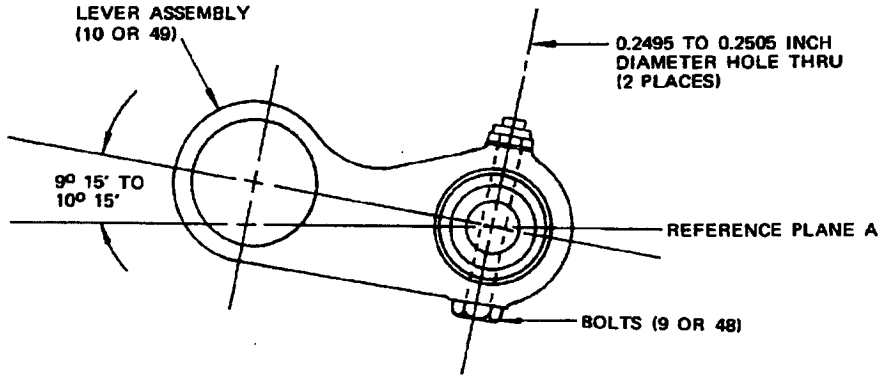
(69-39428-SERIES SHOWN)



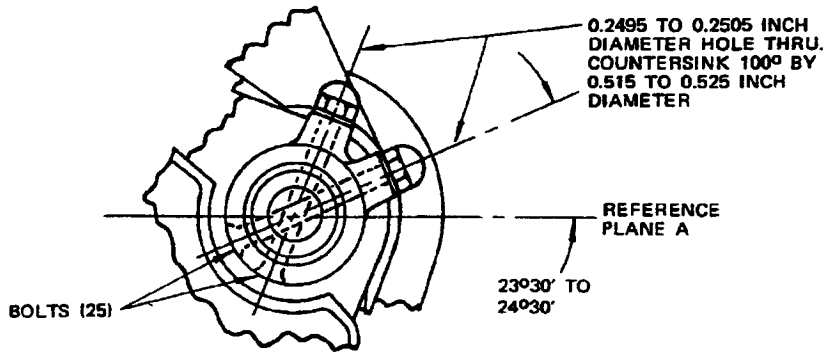
RETAINER (55A)

NO PRIMER ON THESE SURFACES



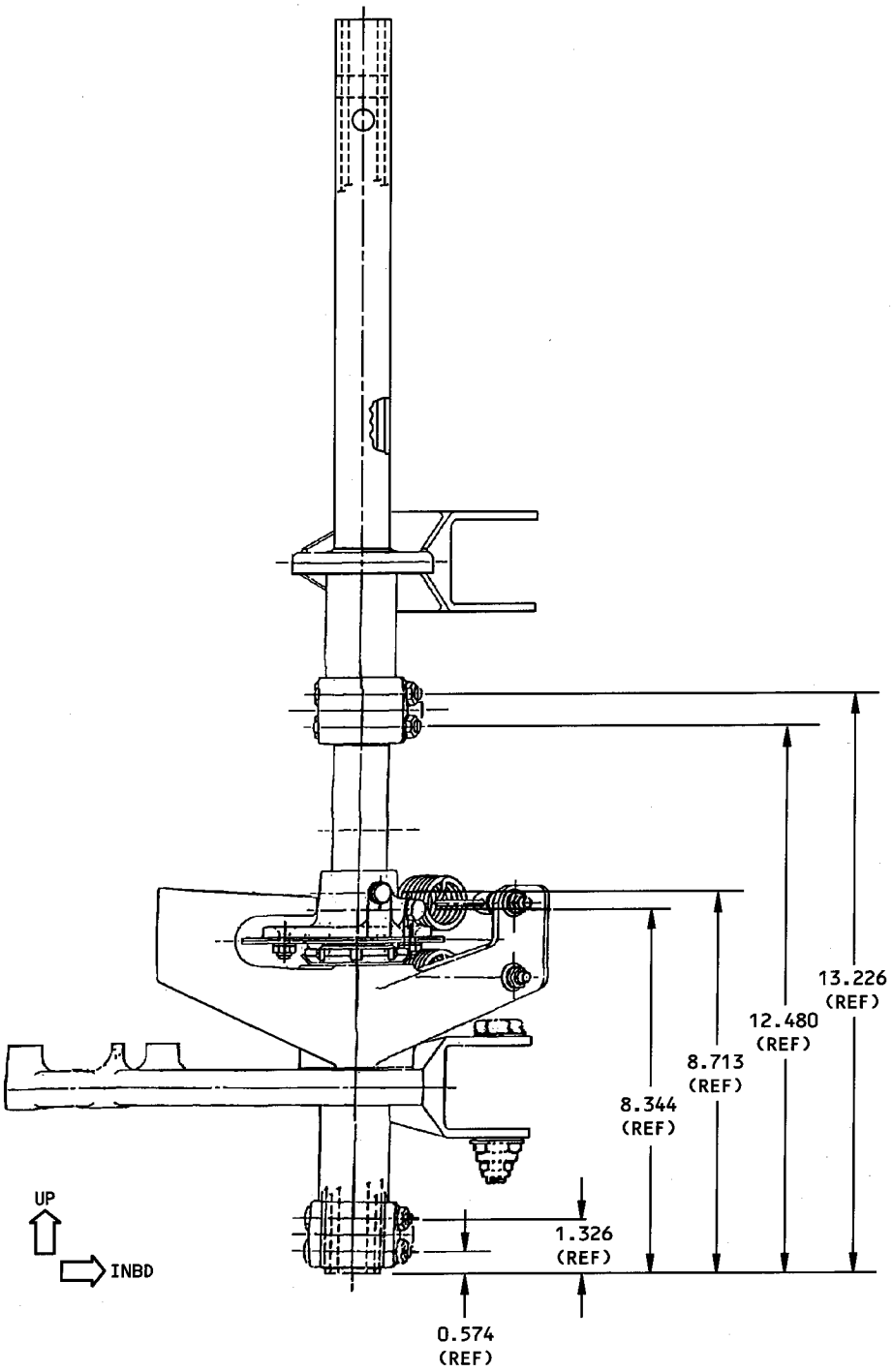


SECTION A-A



SECTION B-B

Replacement Data
Figure 402 (Sheet 1)



SECTION C-C
(ROTATED 90°)

Replacement Data
Figure 402 (Sheet 2)

K25973

ASSEMBLY

1. Procedure (Fig. 1101)

   A. Assemble inner tubing (61) and outer tubing (62).

   B. Install sleeve (58), bearing (57), fillers (56B), and screws (56A) in support (60). Install bearing (57) with wet primer BMS 10-11, Type 1, on external surface. Lockwire screws (56A), only if screws with drilled heads are installed. Lockwire screws (56A) installed with self-locking inserts (59A) is not required.

   C. Install support (60) with attaching parts, retainer (55A) and sleeve (55B) on outer tubing (62).

   D. Install spacer (55) on sleeve (58).

   E. Install lever assembly (49) on sleeve (58) with bolts (48), washers (47), and nuts (46). Tighten nuts (46) to a torque range of 30 to 40 pound-inches.

      NOTE: If lever assembly (49), sleeve (58), inner tubing (61), or outer tubing (62) has been replaced, locate and drill holes for bolts (48) per REPLACEMENT.

   F. Assemble support assembly (43), spacer (42), and bearings (41) and slide over retainer (55A) or support (60). On assembly 65-75960-25, install bearings (41) with BMS 5-95 sealant.

   G. Assemble washer (40) and nut (39). Tighten nut (39) to a torque of 150 pound-inches maximum. Apply thin coat of MIL-C-16173, grade 2, corrosion preventive compound to threads of nut and mating part before installing nut.

      NOTE: If item (40) washer is new and has two inner tongs, machine off one of the inner tongs and then replate reworked area before installation.

   H. Ball stake plug (38C) to cam (38B) per SOPM 20-50-03.

   I. Fasten hub (37) to cam (38) using screws (28), washers (27), and nuts (26). Install assembly of hub (37) and cam (38) and fasten with bolts (25), washers (24), and nuts (23).

      NOTE: If hub (37), retainer (55A), inner tubing (61), or outer tubing (62) has been replaced, locate and drill holes for bolts (25) per REPLACEMENT.

   J. Install bearing (33) in arm (36) with bolt (32D), washers (32C), nut (32B), and cotter pin (32A). Install bearing (33) per SOPM 20-50-03 and cotter pin (32A) per SOPM 20-50-02.

   K. Install arm assembly (34) in support assembly (43) with bolt (32), washer (31), nut (30), and cotter pin (29). Install cotter pin (29) per SOPM 20-50-02.

L. Install springs (22) with pins (21), washers (20), cotter pins (19), eyebolts (18), washers (17), and nuts (16, 15). Install cotter pins (19) per SOPM 20-50-02. Adjust springs (22) as follows:

(1) Adjust nuts (15) until play is eliminated from springs (22). Do not stretch springs (22) from free length. Bearing (33) must be in centered position on cam (38). Hold eyebolts (18) from rotating while adjusting nuts (15).

(2) Adjust nuts (15) equally, until breakout torque measured at outer tubing (62) is 25.0 to 33.0 pound-inches in both directions.

NOTE: Optional method of checking breakout torque is to check that breakout torque at bearing (11) is 8.6 to 11.2 pound-inches in both directions.

(3) Tighten nuts (16).

(4) Rotate outer tubing (62) relative to support assembly (43). Full travel in both directions is limited by stops on hub (37) contacting support assembly (43). Motion shall be smooth with no binding or interference.

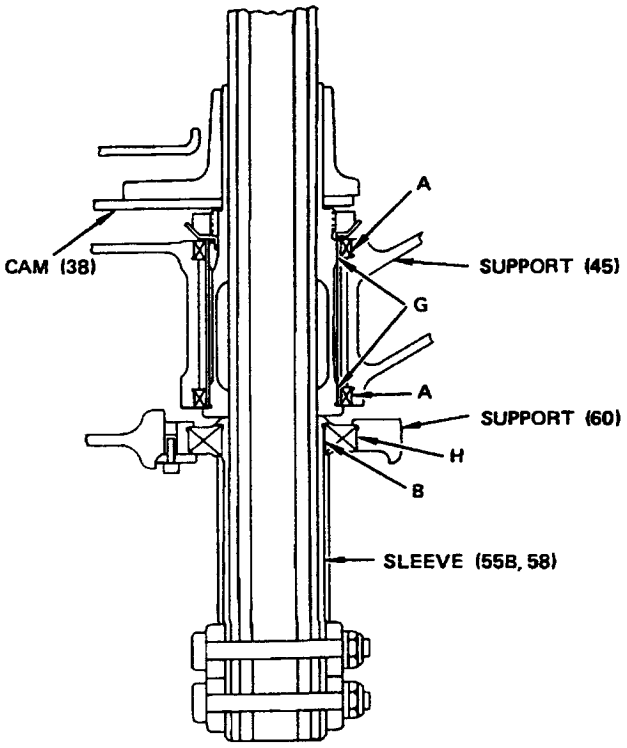
M. Slide lever assembly (10) over outer tubing (62).

N. Install bearing (3) in reaction support (5). Assemble bearing (3) with wet BMS 5-95 sealant on outside surfaces of bearing prior to installation.

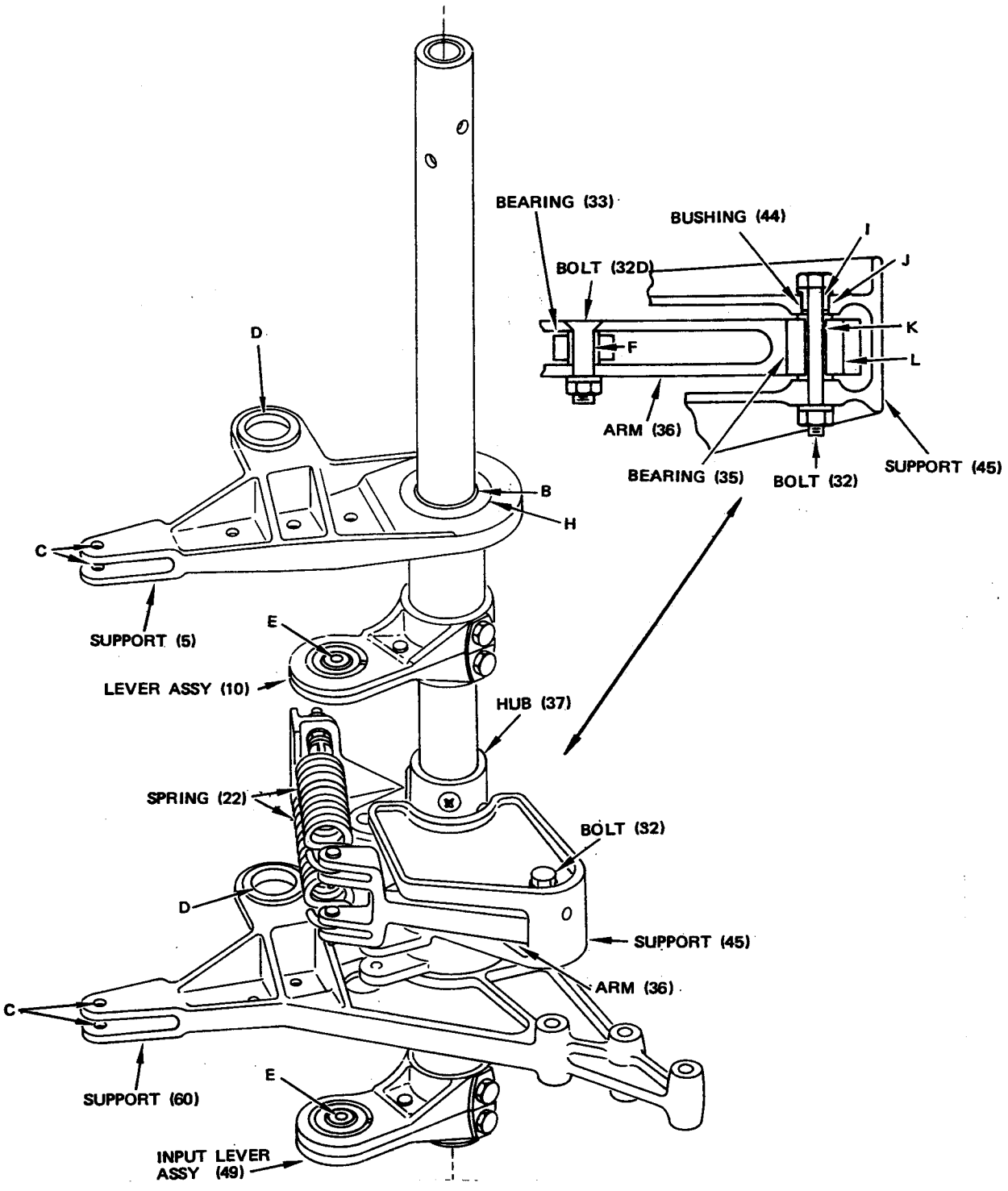
O. Assemble spacer (6), sleeve (1), and reaction support assembly (2) on outer tubing (62) and secure lever assembly (10) with bolts (9), washers (8), and nuts (7). Tighten nuts (7) to a torque range of 30 to 40 pound-inches.

NOTE: If sleeve (1), lever assembly (10), inner tubing (61), or outer tubing (62) has been replaced, locate and drill holes for bolts (9) per REPLACEMENT.

FITS AND CLEARANCES



Fits and Clearances
Figure 601 (Sheet 1)

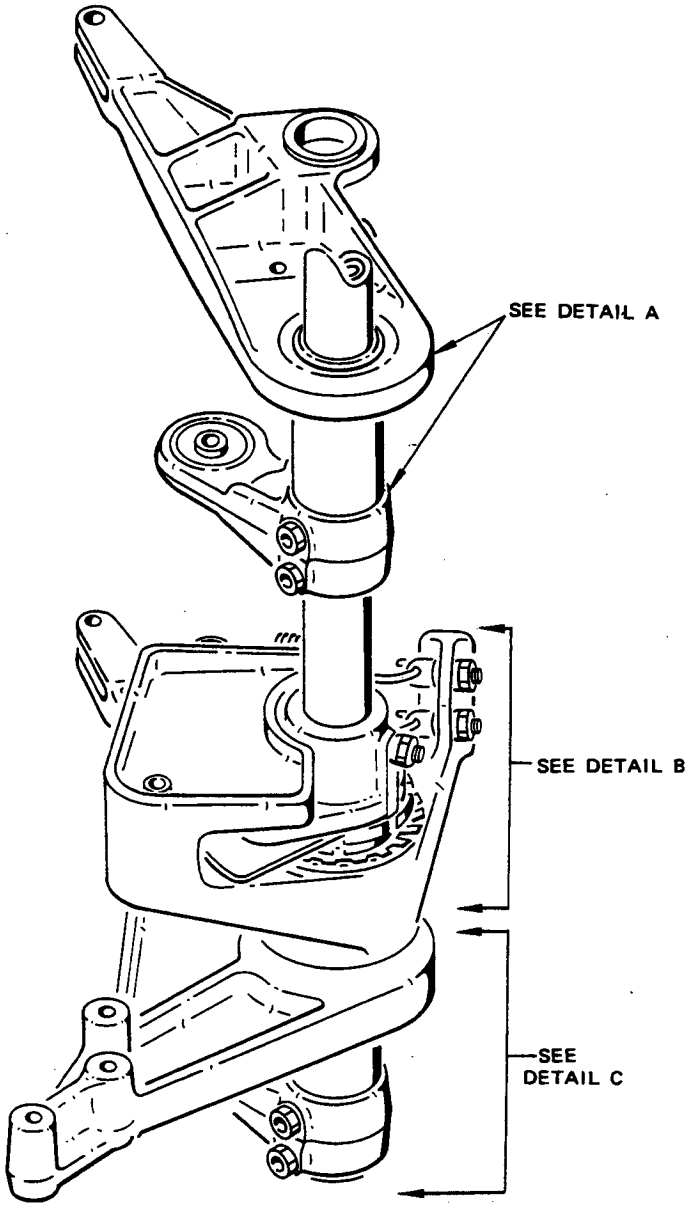


Fits and Clearances
Figure 601 (Sheet 2)

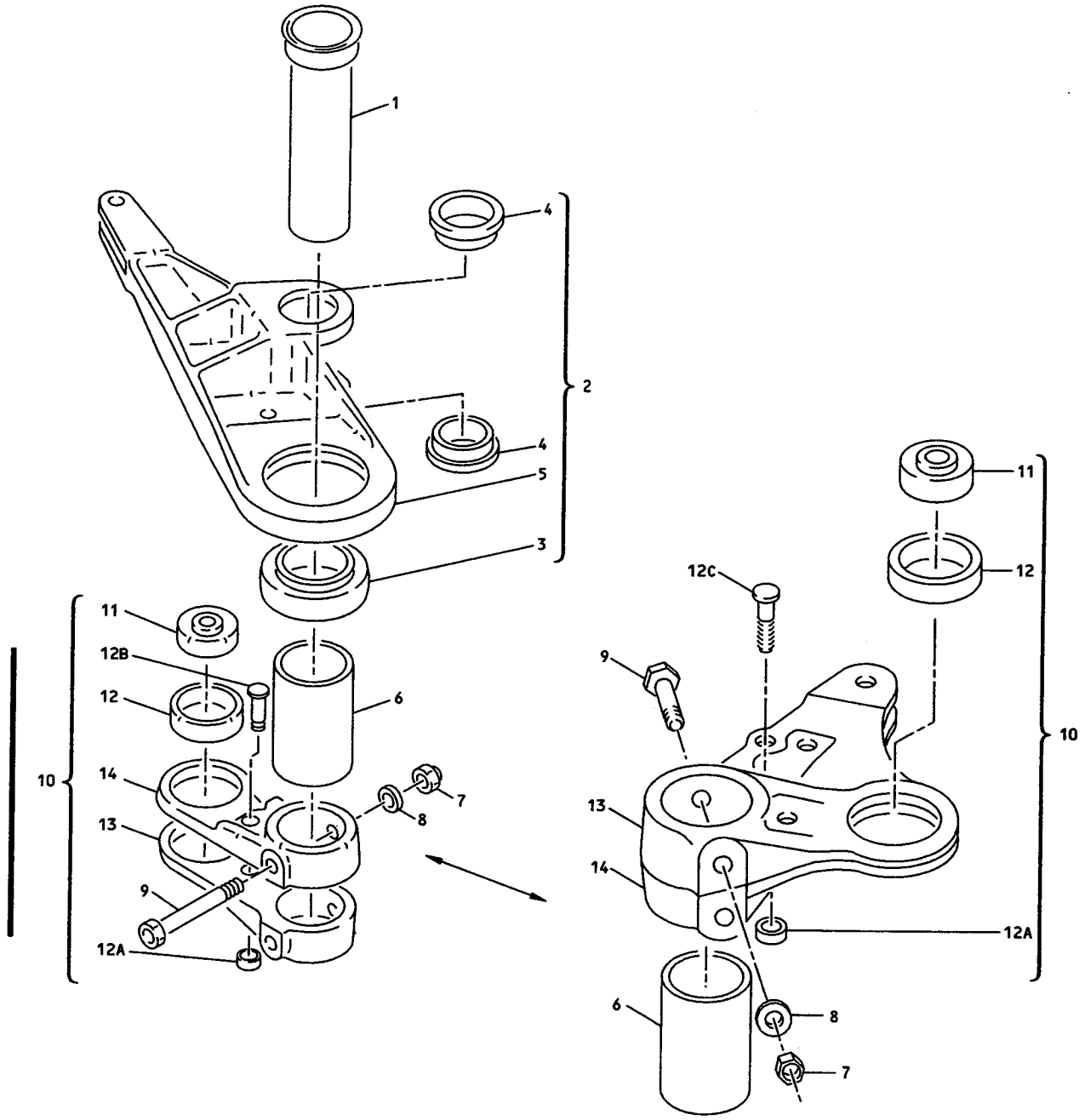
Ref Letter Fig. 601	Mating Item No. Fig. 1101	Design Dimensions				Service Wear Limits		
		Dimensions (inches)		Assembly Clearance (inch)		Dimension Limits (inches)		Maximum Allowable Clearance (inch)
		Min	Max	Min	Max	Min	Max	
A	ID 45	2.2500	2.2510	0.0000	0.0020		2.2510	0.0050
	OD 41	2.2485	2.2500			2.2485		
B	ID 3,57	1.4370	1.4380	0.0000	0.0020		1.4380	0.0020
	OD 1,55B,58	1.4360	1.4370			1.4360		
C	ID 5,60	0.2500	0.2570				0.2585	
D	ID 4,59	1.0000	1.0005				1.0015	
E	ID 11	0.3120	0.3125				0.3125	
F	ID 33	0.2495	0.2500	0.0000	0.0015		0.2500	0.0019
	OD 32D	0.2485	0.2495			0.2481		
G	ID 41	1.8115	1.8135	0.0000	0.0030		1.8140	0.0040
	OD 55A,60	1.8105	1.8115			1.8100		
H	ID 5,60	2.3750	2.3760	0.0000	0.0020		2.3760	0.0020
	OD 3,57	2.3740	2.3750			2.3740		
I	ID 44	0.2500	0.2515	0.0005	0.0030		0.2520	0.0035
	OD 32	0.2485	0.2495			0.2485		
J	ID 45	0.3748	0.3754	-0.0013 *[1]	-0.0002 *[1]		0.3760	0.0004
	OD 44	0.3756	0.3761			0.3756		
K	ID 35	0.2495	0.2500	0.0000	0.0015		0.2500	0.0015
	OD 32	0.2485	0.2495			0.2485		
L	ID 36	0.7488	0.7493	-0.0012 *[1]	-0.0002 *[1]		0.7500	0.0005
	OD 35	0.7495	0.7500			0.7495		

*[1] INTERFERENCE FIT

ILLUSTRATED PARTS LIST

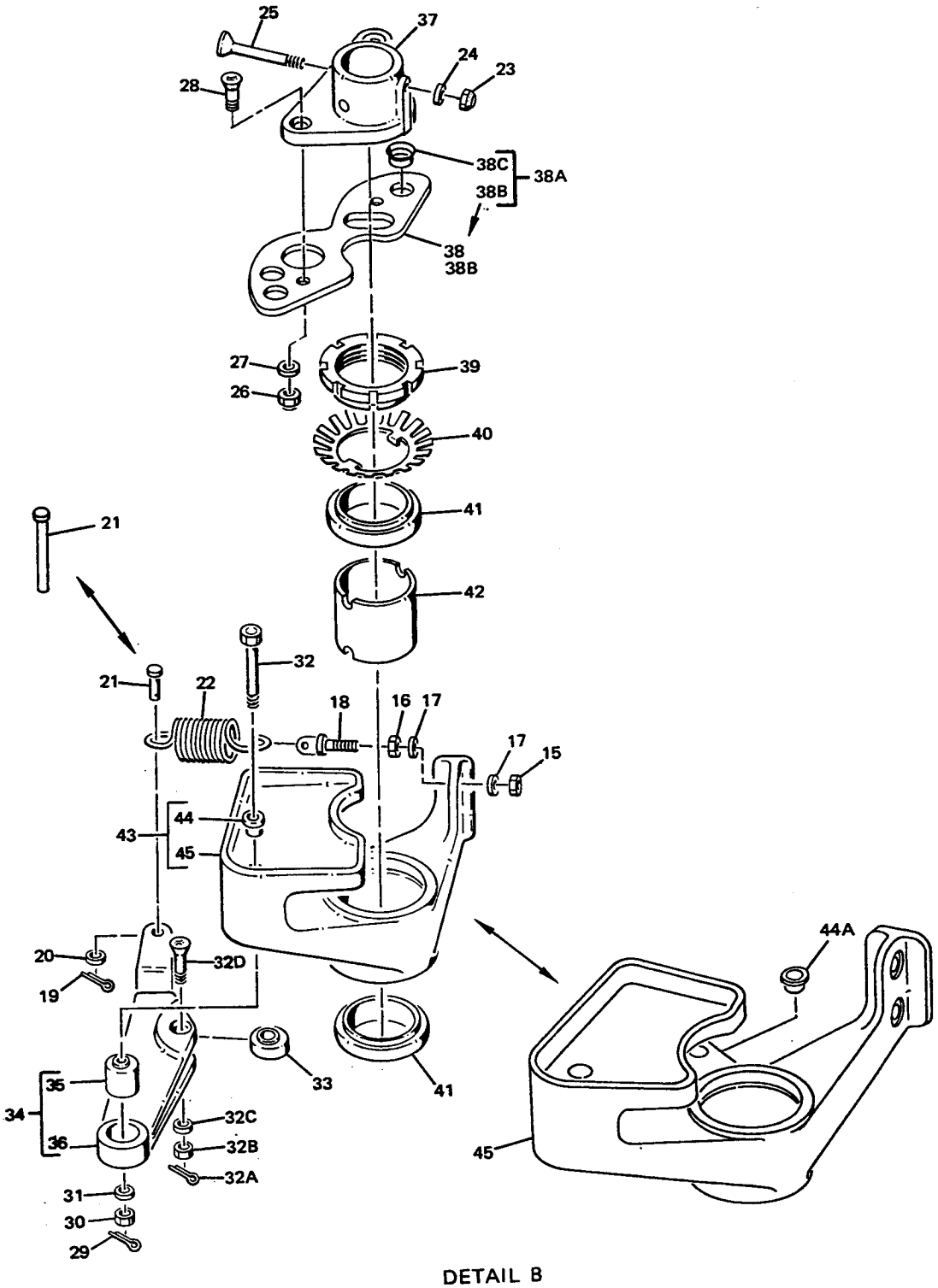


Aileron Centering Mechanism Assembly
Figure 1101 (Sheet 1)



DETAIL A

Aileron Centering Mechanism Assembly
Figure 1101 (Sheet 1A)


25
37
24
23
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38C
38A
38B
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38B
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18
16
17
17
15
43
44
45
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32B
32A
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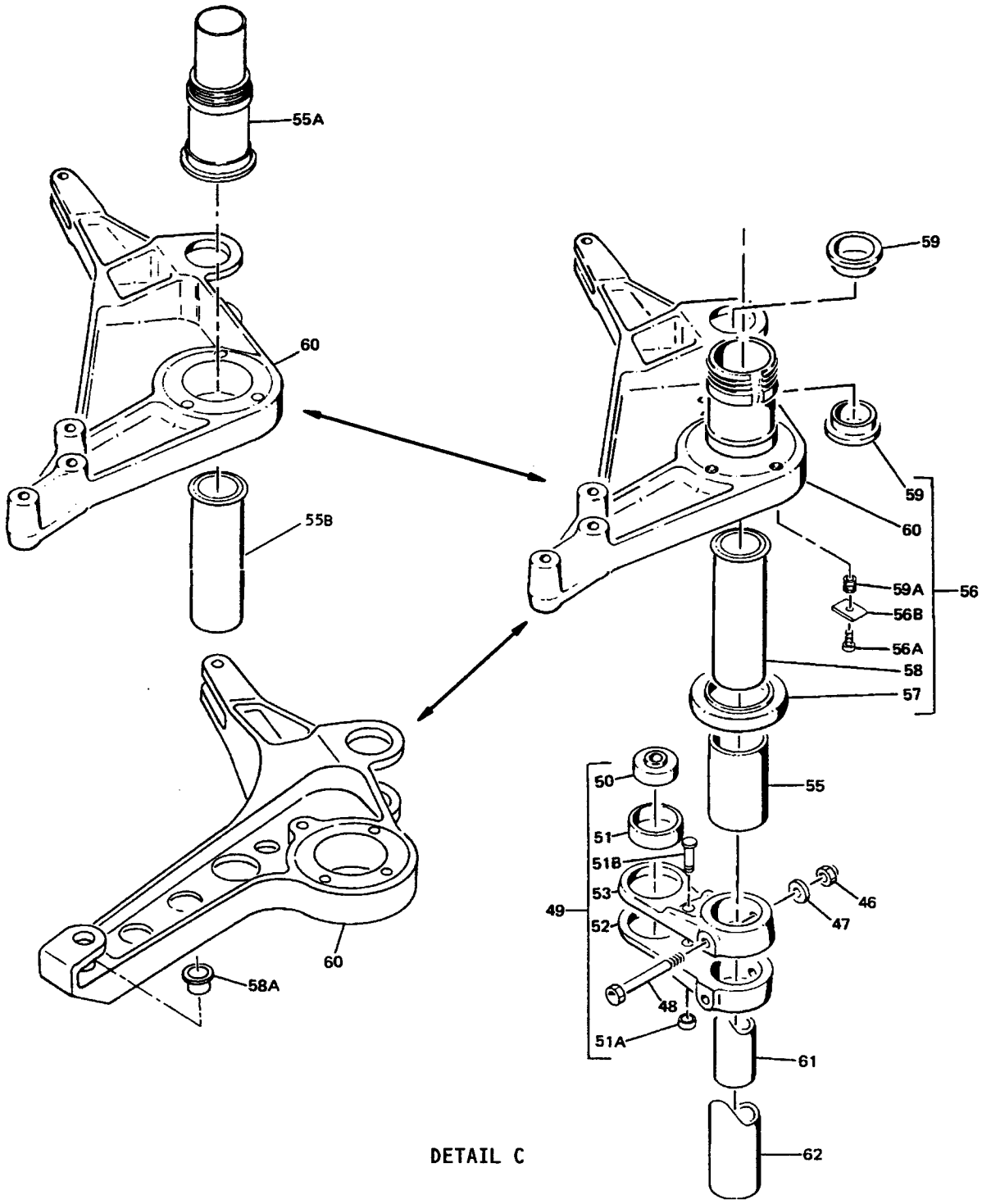
29
44A
45

DETAIL B



Aileron Centering Mechanism Assembly
Figure 1101 (Sheet 3)

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
	65-52283-6		MECHANISM ASSY, AIL CENTERING	A	RF
	65-75960-2		MECHANISM ASSY, AIL CENTERING (SB 27-1021)	B	RF
	65-75960-4		MECHANISM ASSY, AIL CENTERING	C	RF
	65-75960-5		MECHANISM ASSY, AIL CENTERING	D	RF
	65-75960-6		MECHANISM ASSY, AIL CENTERING	E	RF
	65-75960-8		MECHANISM ASSY, AIL CENTERING	F	RF
	65-75960-11		DELETED		
	65-75960-12		MECHANISM ASSY, AIL CENTERING	G	RF
	65-75960-16		DELETED		
	65-75960-14		MECHANISM ASSY, AIL CENTERING	H	RF
	65-75960-17		MECHANISM ASSY, AIL CENTERING	I	RF
	65-75960-18		MECHANISM ASSY, AIL CENTERING (SB 27-1134)	J	RF
	65-75960-19		MECHANISM ASSY, AIL CENTERING	K	RF
	65-75960-20		MECHANISM ASSY, AIL CENTERING	L	RF
	65-75960-22		MECHANISM ASSY, AIL CENTERING	M	RF
	65-75960-23		MECHANISM ASSY, AIL CENTERING	N	RF
	65-75960-25		MECHANISM ASSY, AIL CENTERING	O	RF
1	69-41679-1		. SLEEVE		1
2	65-50555-1		. SUPPORT ASSY, REACTION, UPPER	ABC	1
2	65-50555-5		. SUPPORT ASSY, REACTION, UPPER	D-L	1
2	65-50555-9		. SUPPORT ASSY, REACTION, UPPER	MN	1
2	65-50555-11		. SUPPORT ASSY, REACTION, UPPER	D-LO	1
3	BACB10A829		. . BEARING (OPT)(USED ON 65-50555-1,-5,-9)	A-N	1
3	BACB10FV23G		. . BEARING (PREF)(USED ON 65-50555-1,-5,-9)	A-N	1
3	BACB10FV23G		. . BEARING (USED ON 65-50555-11)	O	1
4	NAS538B16P019		. . BUSHING		2
5	65-50555-2		. . SUPPORT (USED ON 65-50555-1)		1
5	65-50555-6		. . SUPPORT (USED ON 65-50555-5)		1
5	65-50555-10		. . SUPPORT (USED ON 65-50555-9,-11)		1
6	69-41647-1		. SPACER	AB	1
6	69-41647-2		. SPACER	C-NO	1
7	BACN10JC4		. NUT (REPLS NAS679A4W)		2
8	AN960PD416		. WASHER		2
9	NAS1104-31		. BOLT	A-HKL	2
9	BACB30NF4-31		. BOLT	IJMNO	2
10	65-51548-1		. LEVER ASSY	AB	1
10	65-51548-8		. LEVER ASSY	CDEGK	1
10	65C19788-1		. LEVER ASSY	FHIJLMNO	1
11	BACB10AC5		. . BEARING		1
12	69-38919-1		. . SLEEVE		1
12A	NAS1080-6		. . COLLAR		1
12B	BACB30DX6-9		. . BOLT	ABCDEGK	1
12C	BACB30DX6-14		. . BOLT	FHIJLMNO	1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
13	65-51548-4		. . LEVER (USED ON 65-51548-1)		1
13	65-51548-10		. . LEVER (USED ON 65-51548-8)		1
13	65C19770-1		. . LEVER (USED ON 65C19788-1)		1
14	65-51548-3		. . LEVER (USED ON 65-51548-1, 65C19788-1)		1
14	65-51548-9		. . LEVER (USED ON 65-51548-8)		1
15	BACN10JC4		. NUT (REPLS NAS679A4W)		2
16	AN316-4R		. NUT		2
17	AN960PD416		. WASHER		4
18	69-39423-1		. EYEBOLT (PRE SB 27-1155)	A-HKL	2
18	69-74646-1		. EYEBOLT (POST SB 27-1155)	A-HKL	2
18	69-74646-1		. EYEBOLT	IJMNO	2
19	MS24665-134		. PIN, COTTER		2
20	AN960PD10L		. WASHER		2
21	MS20392-2C19		. PIN	A-GI	2
21	69-76564-1		. PIN	J-O	1
21	69-76564-2		. PIN (OPT TO 69-76564-1)	J-O	1
22	69-39429-2		. SPRING (PRE SB 27-1155)	A-M	2
22	69-39429-3		. SPRING (POST SB 27-1155)	A-M	2
22	69-39429-3		. SPRING	NO	2
23	BACN10JC4		DELETED		
23	BACN10R428		. NUT		2
24	AN960PD416		. WASHER		2
25	BACB30LU4-32		DELETED		
25	BACB30LU4-34		. BOLT (REPLS NAS517-4-34)	A	2
25	BACB30LU4-31		. BOLT (REPLS NAS517-4-31)	B-O	2
26	BACN10JC4		. NUT (REPLS NAS679A4W)		2
27	AN960PD416		. WASHER		2
28	BACB30LU4-6		. SCREW (REPLS NAS517-4-6)	A	2
28	BACB30LU4-5		. SCREW (REPLS NAS517-4-5)	B-O	2
29	MS24665-134		. PIN, COTTER		1
30	BACN10JD104		. NUT (REPLS AN320-4)		1
31	AN960PD416		. WASHER		1
32	NAS1104-26		DELETED		
32	NAS1104-26D		. BOLT	A-HKL	1
32	BACB30NF4D26		. BOLT	IJMNO	1
32A	MS24665-134		. PIN, COTTER		1
32B	BACN10JD104		. NUT (REPLS AN320-4)		1
32C	AN960PD416		. WASHER		1
32D	BACB30LU4D11		. BOLT		1
33	KP4R16FS428		. BEARING, V21335		1
33	KP4R16E6531		. BEARING, V21335, (OPT)		1
33	BACB10A339		. BEARING (OPT)		1
34	65-52286-4		. ARM ASSY, ROLLER	AB	1
34	65-52286-7		. ARM ASSY, ROLLER (OPT)	A	1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
34	65-52286-9		. ARM ASSY, ROLLER	C-F	1
34	65-52286-11		. ARM ASSY, ROLLER	G-O	1
35	BACB10CG4A		. . BEARING (REPLS BACB10A671)		1
36	65-52286-5		. . ARM (USED ON 65-52286-4)		1
36	65-52286-8		. . ARM (USED ON 65-52286-7)		1
36	65-52286-10		. . ARM (USED ON 65-52286-9)		1
36	65-52286-12		. . ARM (USED ON 65-52286-11)		1
37	65-53390-1		. HUB	A	1
37	65-53390-3		. HUB (SB 27-1021)	B	1
37	65-53390-4		. HUB	C-O	1
38	69-39428-2		. CAM	A	1
38	69-39428-3		. CAM (SB 27-1021)	B	1
38	69-39428-4		. CAM	CDIJM	1
38	69-68793-1		. CAM	E-HKL	1
38	69-39428-5		. CAM	NO	1
38A	65-75960-24		. CAM ASSY (OPT)	NO	1
38B	69-39428-4		. . CAM	NO	1
38C	69-77894-1		. . PLUG	NO	1
39	66-24467-1		. NUT		1
40	65-52283-3		. WASHER	A	1
40	65-75960-3		. WASHER (OPT)	A	
40	65-75960-3		. WASHER	B-O	1
40	65-52283-3		. WASHER (OPT)	B-O	
41	BACB10FU29G		. BEARING (PREF)	A-N	1
41	BACB10CF29PP		. BEARING (REPLS BACB10A31DDH)(OPT)	A-N	2
41	BACB10FU29G		. BEARING	O	2
42	69-39427-1		. SPACER		1
43	65-52285-4		. SUPPORT ASSY	AB	1
43	65-52285-7		. SUPPORT ASSY	C-HKL	1
43	65-52285-9		DELETED		
43	65-52285-14		DELETED		
43	65-52285-15		. SUPPORT ASSY	IJMNO	1
44	BACB28X4D38		. . BUSHING		1
44A	BACB28X4C25		. . BUSHING (USED ON 65-52285-15)		1
45	65-52285-5		. . SUPPORT (USED ON 65-52285-4)		1
45	65-52285-8		. . SUPPORT (USED ON 65-52285-7)		1
45	65-52285-12		DELETED		
45	65-52285-10		DELETED		
45	65-52285-16		. . SUPPORT (USED ON 65-52285-15)		1
46	BACN10JC4		. NUT (REPLS NAS679A4W)		2
47	AN960PD416		. WASHER		2
48	NAS1104-31		. BOLT	A-HKL	2
48	BACB30NF4-31		. BOLT	IJMNO	2
49	65-51548-1		. LEVER ASSY, INPUT	AB	1
49	65-51548-8		. LEVER ASSY, INPUT	C-O	1
50	BACB10AC5		. . BEARING		1
51	69-38919-1		. . SLEEVE		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
51A	BACC30X6X		. . COLLAR (REPLS NAS1080-6)		1
51B	BACB30DX6-9		. . BOLT, LOCK		1
52	65-51548-4		. . LEVER (USED ON 65-51548-1)		1
52	65-51548-10		. . LEVER (USED ON 65-51548-8)		1
53	65-51548-3		. . LEVER (USED ON 65-51548-1)		1
53	65-51548-9		. . LEVER (USED ON 65-51548-8)		1
54	69-41293-1		DELETED		
55	69-41647-1		. SPACER	AB	1
55	69-41647-2		. SPACER	C-O	1
55A	65-75384-1		. RETAINER (SB 27-1021)	B-O	1
55B	69-41679-1		. SLEEVE	B-O	1
56	65-50556-5		. SUPPORT ASSY, REACTION, LOWER	A	1
56	65-75928-1		. SUPPORT ASSY, REACTION, LOWER (SB 27-1021)	B	1
56	65-75928-5		. SUPPORT ASSY, REACTION, LOWER	C-HKL	1
56	65C25411-4		. SUPPORT ASSY, REACTION, LOWER	IJMN	1
56	65C25411-7		. SUPPORT ASSY, REACTION, LOWER	O	1
56A	BACS12CB08-8		. . SCREW (USED ON 65-50556-5, 65-75928-1, 65-75928-5)		3
56A	MS24674-8		DELETED		
56A	NAS1810-08-8		DELETED		
56A	NAS1801-08-8		. . SCREW (USED ON 65C25411-4,-7)		3
56B	69-54335-1		. . FILLER (USED ON 65-50556-5, 65-75928-1)		3
56B	69-54335-2		. . FILLER (USED ON 65-75928-5, 65C25411-4,-7)		3
57	BACB10A829		. . BEARING (OPT)	A-HKL	1
57	BACB10FV23G		. . BEARING (PREF)	A-HKL	1
57	BACB10EX23		. . BEARING (OPT)	IJMN	1
57	BACB10FV23G		. . BEARING (PREF)	IJMN	1
57	BACB10FV23G		. . BEARING	O	1
58	69-41679-1		. . SLEEVE (USED ON 65-50556-5)		1
58A	BACB28X6C018		. . BUSHING (USED ON 65C25411-4,-7)		1
59	NAS538B16P019		. . BUSHING		2
59A	MS21209C0820		. . INSERT		3
60	65-50556-2		. . SUPPORT (USED ON 65-50556-5)		1
60	65-75928-2		. . SUPPORT (SB 27-1021) (USED ON 65-75928-1)		1
60	65-75928-4		. . SUPPORT (USED ON 65-75928-5)		1
60	65C25411-5		. . SUPPORT (USED ON 65C25411-4,-7)		1
61	69-42177-1		. INNER TUBING, INPUT SHAFT		1
62	69-42176-1		. OUTER TUBING, INPUT SHAFT	AB	1
62	69-42176-2		. OUTER TUBING, INPUT SHAFT	C-O	1
63	BACB3DABP4-13		DELETED		

VENDORS

V21335 TORRINGTON CO., FAFNIR BEARING DIVISION, 59 FIELD ST., TORRINGTON, CONNECTICUT 06790-4942