TO: ALL HOLDERS OF ELEVATOR CONTROL TORQUE TUBE ASSEMBLY OVERHAUL MANUAL, 27-37-07

REVISION NO. 17, 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
Incorporated TR 27-48 which added coverage of Service Bulletin 737-27A1274		X			X	X	X					X	

ELEVATOR CONTROL TORQUE TUBE ASSEMBLY

27-37-07

BOEING P/N 65-45187-2, -3, -4, -501, -7 thru -14, -17, -20, -21, -22, -23

AIRLINE P/N

THE FOLLOWING DIRECTIVES APPLY TO THIS SUBJECT:

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVES	DATE DIRECTIVE INCORPORATED INTO TEXT
		PRR 31452	May 15/69
		PRR 31481	Dec 10/70
		PRR 32039	Dec 25/72
		PRR 32912-1	Jul 5/79
		PRR 32900-1	Jul 5/79
		PRR 33034	Jul 5/81
27-1163			Sep 5/90
27A1274			Mar 1/08

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
27-37-07						
*	T-1	Mar 1/08				
	T-2	BLANK				
*	LEP-1	Mar 1/08				
	LEP-2	BLANK				
	T/C-1	Jul 5/81				
	T/C-2	BLANK				
	1	Jul 5/79				
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*	101	Mar 1/08				
*	102	Mar 1/08				
	201	Jul 5/81				
	202	BLANK				
	301	Mar 5/93				
	302	BLANK				
*	401	Mar 1/08				
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*	403	Mar 1/08				
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*	1101	Mar 1/08				
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*	1102B	BLANK				
*	1103	Mar 1/08				
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*[1] Special instructions not required. Use standard industry practices and the information contained in 20-44-02 and 20-70-01.

ELEVATOR CONTROL TORQUE TUBE ASSEMBLY

Fig. 1 Deleted

DESCRIPTION AND OPERATION

1. The torque tube assembly consists of a retainer bushing, torque tube, two support links, three input cranks, and four sideplates. Four aft control quadrants are mounted on the torque tube. The assembly transmits motion in the elevator control system to provide input power to the elevators. (See Fig. 1101 for view.)

2. Leading Particulars (Approximate)

   Length -- 39 inches
   Width -- 11 inches
   Height -- 17.5 inches
   Weight -- 19 pounds

DISASSEMBLY

1. Remove nuts, washers, and bolts (1 thru 3, Fig. 1101) and input crank assembly (4) from torque tube (100).

   NOTE: Do not remove bearing (5), sleeve (6), rivets (7), or input cranks (9) from bonded crank assembly (8) unless repair or replacement is necessary.

2. Remove screws (10), washers (11), and bearing retainer (12).

3. Remove screws (13, 13A, 14, 14A), washers (15, 15A, 15B, 15C, 16, 16A) and ground bolt shroud (16S) from sideplates (26, 31, 64, 69).

4. Remove nuts (17), washers (18 thru 20), and bolts (21).

5. Remove nut (22), washer (23), bolt (24), spacer (25), and sideplates (26, 31).

   NOTE: Do not remove collars (27, 32), lockbolts (28, 33), or doublers (29, 34) from sideplates (30, 35) unless repair or replacement is necessary.

6. Remove support links (36, 41), spacers (46, 47), bearings (48), and bushing (49).

   NOTE: Do not remove bushings (37, 42), rivets (38, 43), or nutplates (39, 44) from links (40, 45) unless repair or replacement is necessary.

7. Remove pin (50), bushing (51), pin (52), and bushing (53).

   NOTE: Do not remove inserts (54) from bushing (55) unless repair or replacement is necessary.

   Bushing (51) and (53) are matched sets with torque tube assembly and should be marked prior to removal to ensure they are reinstalled correctly. If 65-45187 assembly has been previously overhauled, verify correct orientation of bushings (51) and (53) to ensure best alignment of drilled holes in bushings (51) and (53) and corresponding holes through torque tube assembly (100). This procedure will prevent excess stress on pins (50) and (52).

8. Remove nuts (56), washers (57, 58), bolts (59, 59A), aft quadrants (60, 61), and sideplates (64, 69).

   NOTE: Do not remove collars (65, 70), lockbolts (66, 71), or doublers (67, 72) from sideplates (68, 73) unless repair or replacement is necessary.

   Do not remove rivets (62) or spacers (63) from aft quadrants (60, 61, 86) unless repair or replacement is necessary.

9. Remove nuts (74, 106), washers (75, 107), bolts (76, 110), bracket (108), washers (109) and input crank (77). Bracket (108) and washers (109) are used on elevator control torque tube assemblies 65-45187-7, thru -10, -12, -13, -14, -17, -20 thru -23.

   NOTE: Do not remove bearing (78), sleeve (79), rivets (80), or input cranks (82) from bonded crank assembly (81) unless repair or replacement is necessary.

10. Remove nuts (83), washers (84), bolts (85), and aft quadrants (86).

    NOTE: Identify left and right aft quadrants (86) to facilitate reassembly.

11. For elevator control torque tube assemblies 65-45187-4, -7 thru -10, -12, -13, -14, -17, -20 thru -23, remove nuts (105), washers (103, 104), bolts (102), and lever (101).

12. Remove retainer (87) from input crank (93).

    NOTE: Do not remove bearing (88) from retainer (89) unless repair or replacement is necessary.

13. Remove nuts (90), washers (91), bolts (92), and input crank (93).

    NOTE: Do not remove bearing (94), sleeve (95), rivets (96), or input cranks (98 and 99) from bonded crank assembly (97) unless repair or replacement is necessary.

CLEANING

1. Clean all parts except bearings (5, 48, 78, 88, 94) in accordance with standard industry practices and the information contained in 20-30-03. Clean bearings (5, 48, 78, 88, 94) only by special procedure for teflon lined bearings in 20-30-01.

INSPECTION/CHECK

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

2. Penetrant check per 20-20-02 -- items (4, 37, 40, 42, 45 thru 47, 49, 51, 55, 60, 61, 77, 86, 89, 93, 100, 101, 106).

3. Magnetic particle check per 20-20-01 -- bolts (21).

4. Check bearing (88) as installed in retainer (87). Make sure that bearing (88) moves smoothly and without binding.

REPAIR

1. Repair minor defects in accordance with standard industry practices. Refer to Fits and Clearances for design dimensions and wear limits.

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. Input crank assemblies (8, 81, 97) 65-45192-3, 65-45192-4 -- Manually apply chemical coating and apply one coat BMS 10-11, Type 1 primer (SRF-2.31) except no primer on face of 2.3110 to 2.3120-inch diameter. Input crank assemblies (8, 81, 97) 65-45192-7, 65-45192-8 -- Manually apply chemical coating and apply one coat of BMS 10-11, Type 1 primer (F-18.06) except no primer on face of 2.3110 to 2.3120-inch diameter. Material: Al alloy.

   B. Bearing retainer (12), doublers (29, 34, 67, 72), sideplates (30, 35, 68, 73), spacers (46, 47), bushings (49, 51, 55), links (40, 45), retainer (89) 69-40348-2, -4 -- Alodize or chromic acid anodize all over followed by one coat of BMS 10-11, Type 1 primer (SRF-2.30). Retainer (89) 69-40348-5 -- Boric-acid-sulfuric acid anodize or chromic acid anodize (F-17.31) and apply one coat of BMS 10-11, Type 1 primer (F-20.02). Omit primer in base of retainer (89). Omit primer in the 0.7495-0.7500 inch bore and in the 3.00 inch bore of links (40, 45). Material: Al alloy.

   C. Bolts (21) -- Cadmium plate followed by one coat of MIL-P-8585 color Y primer (SRF-12.205) Material: 4340 Steel (180-200 ksi).

   D. Bushings (37, 42) -- Cadmium plate all over (F-1.1926), except on inside diameter. Material: Al-Ni-Bronze.

   E. Aft quadrants (60, 61, 86) -- Chromic acid anodize and apply one layer of BMS 10-11, Type 1 primer (F-18.05).

   F. Torque tube assembly (100) -- Alodize by brush, swab, or spray (F-2.940) all over followed by one coat of BMS 10-11, Type 1 primer (SRF-12.205). Material: Al alloy.

   G. Lever (101) -- Chromic acid anodize all over followed by one coat of BMS 10-11, Type 1 primer (F-18.05). Material: Al alloy.

   H. Assemblies 65-45187-10 thru -14, -17, -20 -- Apply one coat BMS 10-11, Type 1 primer (F-20.02) to all unprimed areas.

   I. Assemblies 65-45187-2, -3, -4, -501, -7, -8, -9 -- Apply one coat BMS 10-11, Type 1 primer (SRF-12.205) to all unprimed areas.

   J. Assemblies 65-45187-21, -22, -23 -- Apply one coat of BMS 10-11, Type 1 primer (SRF-14.996) to all unprimed areas.

   K. Bracket (108) -- Chromic acid anodize all over followed by one coat of BMS 10-11, Type 1 primer (F-18.13). Material: Al alloy.

   L. Shroud, ground bolt (16S) – Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31) and apply BMS 10-11, Type 1 primer (F-20.02).

3. Replacement

A. Replace all unserviceable and irreparable parts.

B. Bearings (5, 78, 94), Sleeves (6, 79, 95) -- Apply primer, BMS 10-11, Type 1 to faying surfaces of bearing, sleeve, and mating part. Install parts and roller swage sleeve per 20-50-03. Maximum breakout torque after bearing installation shall not exceed 0.075 lb-lb.

C. Bearing (88) -- Apply primer, BMS 10-11, Type 1 to mating surfaces of bearing and retainer (89). Install bearing in retainer and roller swage per 20-50-03.

D. Bushings (37, 37A 42 42A)

(1) Apply primer, BMS 10-11, Type 1 to mating surfaces of bushing and link (40, 45) and install bushings.

(2) Machine bushing ID to 0.6245-0.6250 inch.

E. Insert (54) -- Apply primer, BMS 10-11, Type 1 and install insert 1/4-1/2 inch below surface of bushing (55).

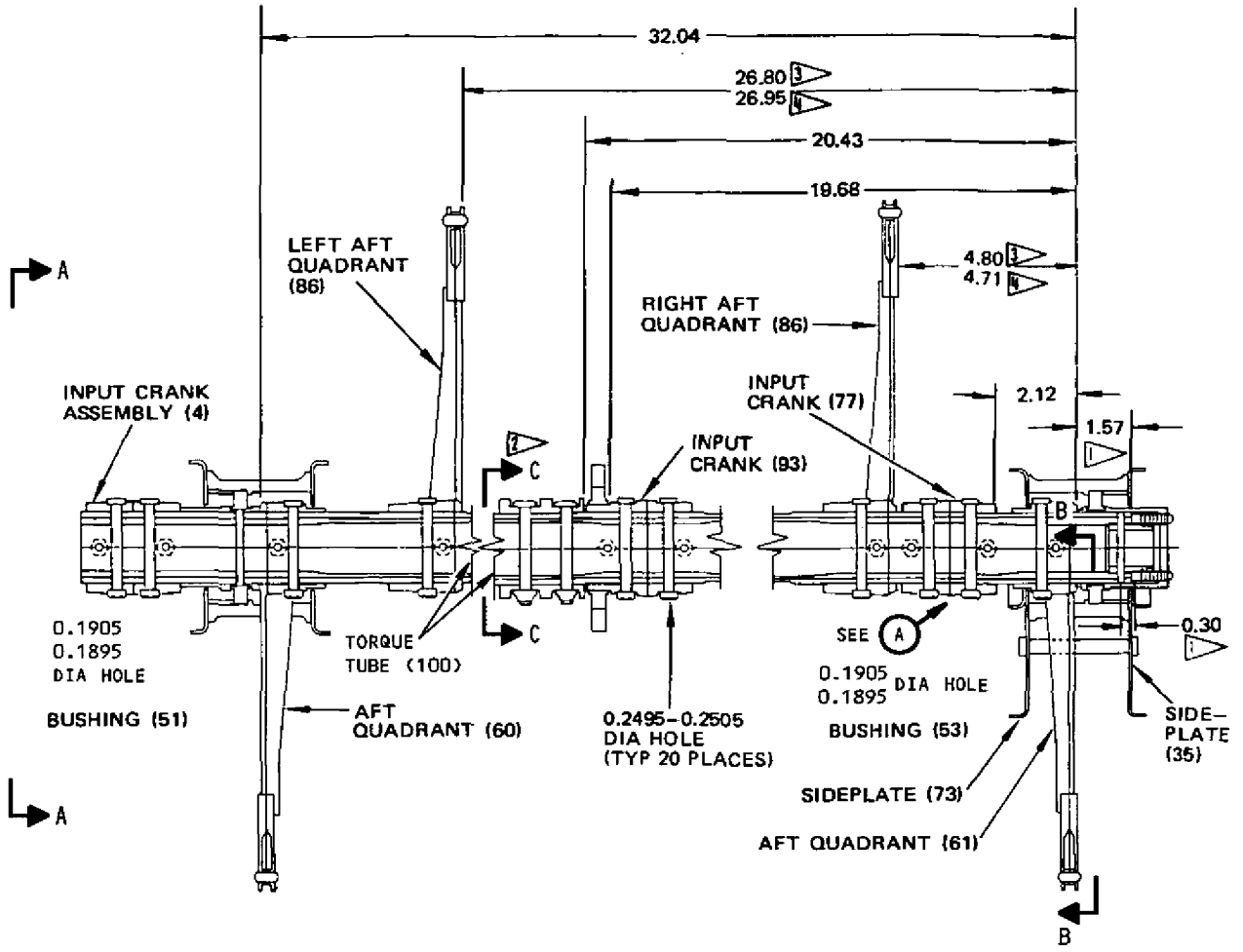
F. Torque Tube assy (100) -- Install and position parts as shown in Fig. 401. Drill holes as required for installation of parts (Refer to Assembly).

NOTE: Replace entire tube assembly if inner or outer tubes are defective.

G. Bushings (51, 53) -- Install bushings in the torque tube and drill a new hole for pins (50) and/or (52), rotated 45 degrees relative to previous hole in torque tube (previously existing holes should be treated per F-18.01 and coated with BMS 5-95 sealant).

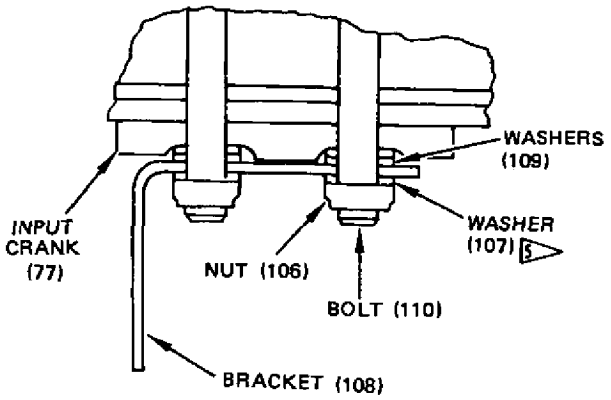
4. Materials

A. Primer -- BMS 10-11, Type 1 (Ref 20-60-02).



TOLERANCE ON DIM ± 0.01 EXCEPT OTHERWISE SPECIFIED

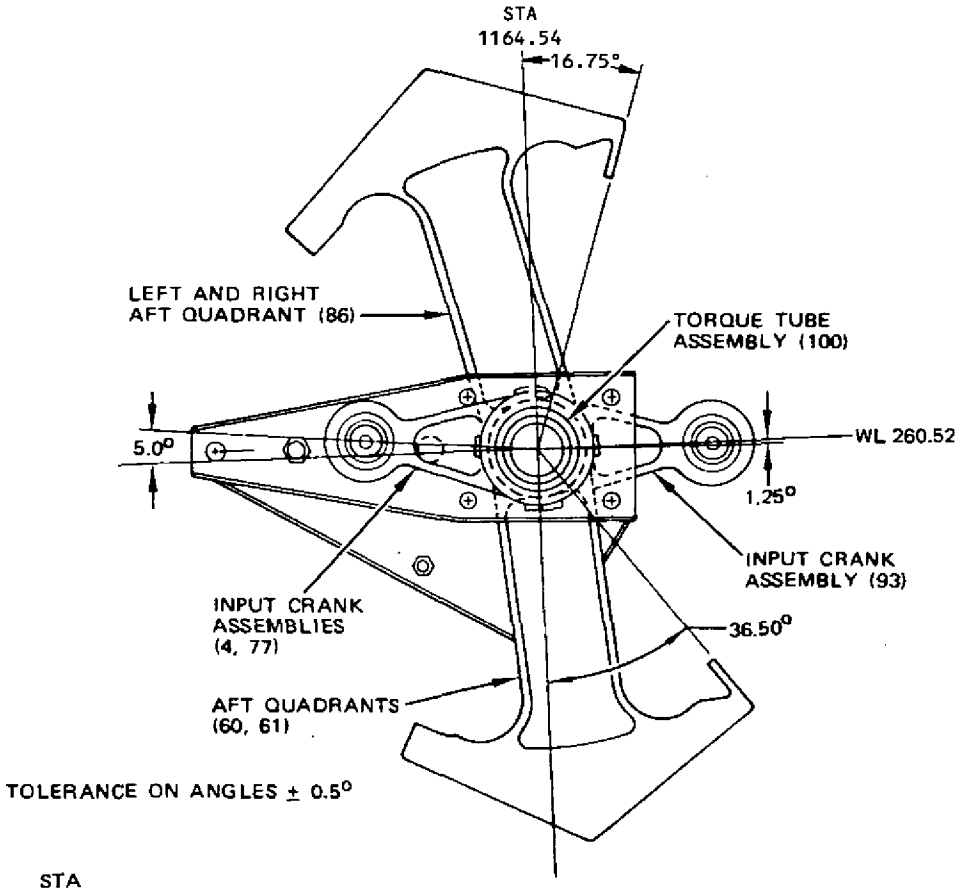
1. 0.30 AND 1.57 INCH DIMENSIONS SHOWN FROM END OF TORQUE TUBE ASSEMBLY (100)
2. 65-45187-4, -7 THRU-10,-12,-13,-14,-17, -20 THRU -23
3. 65-45187-2,-3,-4, -7 THRU -10,-501
4. 65-45187-11 THRU -14,-17, -20 THRU -23
5. 65-45187-7 REQUIRES TWO WASHERS (107)

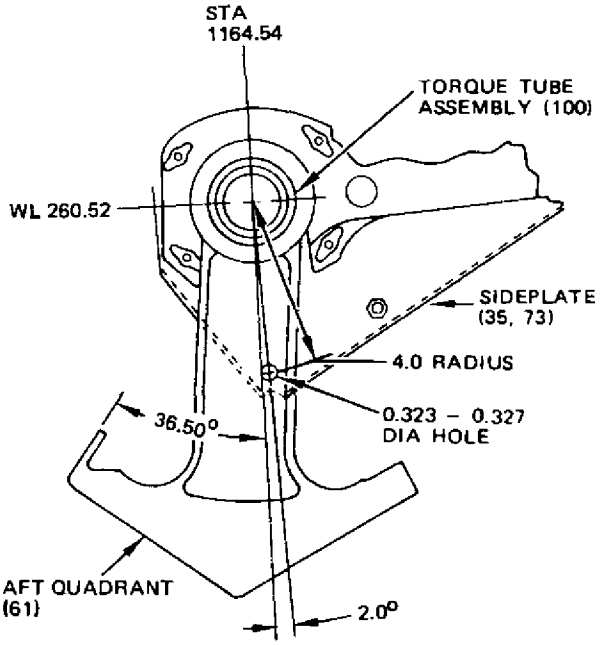


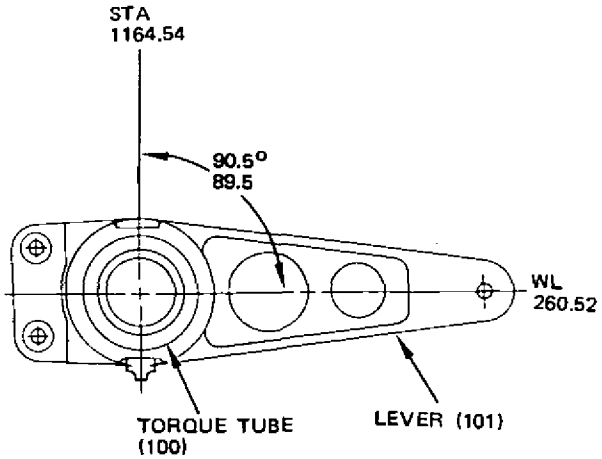
(65-45187-7 THRU -10,-12,-13, -14,-17, -20 THRU -23)

Torque Tube Replacement
Figure 401 (Sheet 1)

1473453







(65-45187-4, -7 THRU -10,-12,-13, -14,-17, -20 THRU -23)

Torque Tube Replacement
Figure 401 (Sheet 2)

1473474

ASSEMBLY

1. Materials

   A. Corrosion Preventive Compound -- MIL-C-11796, Class 3 (Ref 20-60-03)

   B. Primer -- BMS 10-11, Type 1 (Ref 20-60-02)

   C. Sealant -- BMS 5-95 (Ref 20-60-01)

2. Assembly (Fig. 1101)

   NOTE: Apply corrosion preventive compound to mating surfaces of all parts as they are assembled and installed on torque tube (100).

   A. Install input crank (93) with bolts (92), washers (91), nuts (90).

   B. Install retainer (87) against input crank. For elevator control torque tube assemblies 65-45187-4, -7 thru -10, -12, -13, -14, -17, -20 thru -23, install lever (101) with bolts (102), washers (103, 104), nuts (105).

   C. Install both quadrants (86) with bolts (85), washers (84), nuts (83).

   D. Install input crank (77) with bolts (76, 110), washers (75, 107), nuts (74, 106), bracket (108), and washers (109). Bracket (108) and washers (109) are installed on elevator control torque tube assemblies 65-45187-7 thru -10, -12, -13, -14, -17, -20 thru -23.

   E. Install sideplate assemblies (69, 64) and aft quadrants (61, 60) with bolts (59), washers (58, 57), and nuts (56).

   F. Install bushings (53, 51, 49) and pins (52, 50).

      NOTE: Verify that bushings (51) and (53) are reinstalled with the proper orientation.

   G. Apply BMS 5-95 to internal and external diameter of bearings (48). Apply BMS 5-95 to external diameter of spacers (47, 46).

   H. Install bearings (48), spacers (47, 46), and support links (41, 36). After BMS 5-95 sealant has cured make sure that bearings (48) allow smooth movement of support links (41, 36) without binding.

   I. Install sideplates (31, 26) and spacer (25) with bolts (24), washers (23), and nuts (22).

J. Install bolts (21), washers (18, 19, 20), and nuts (17).

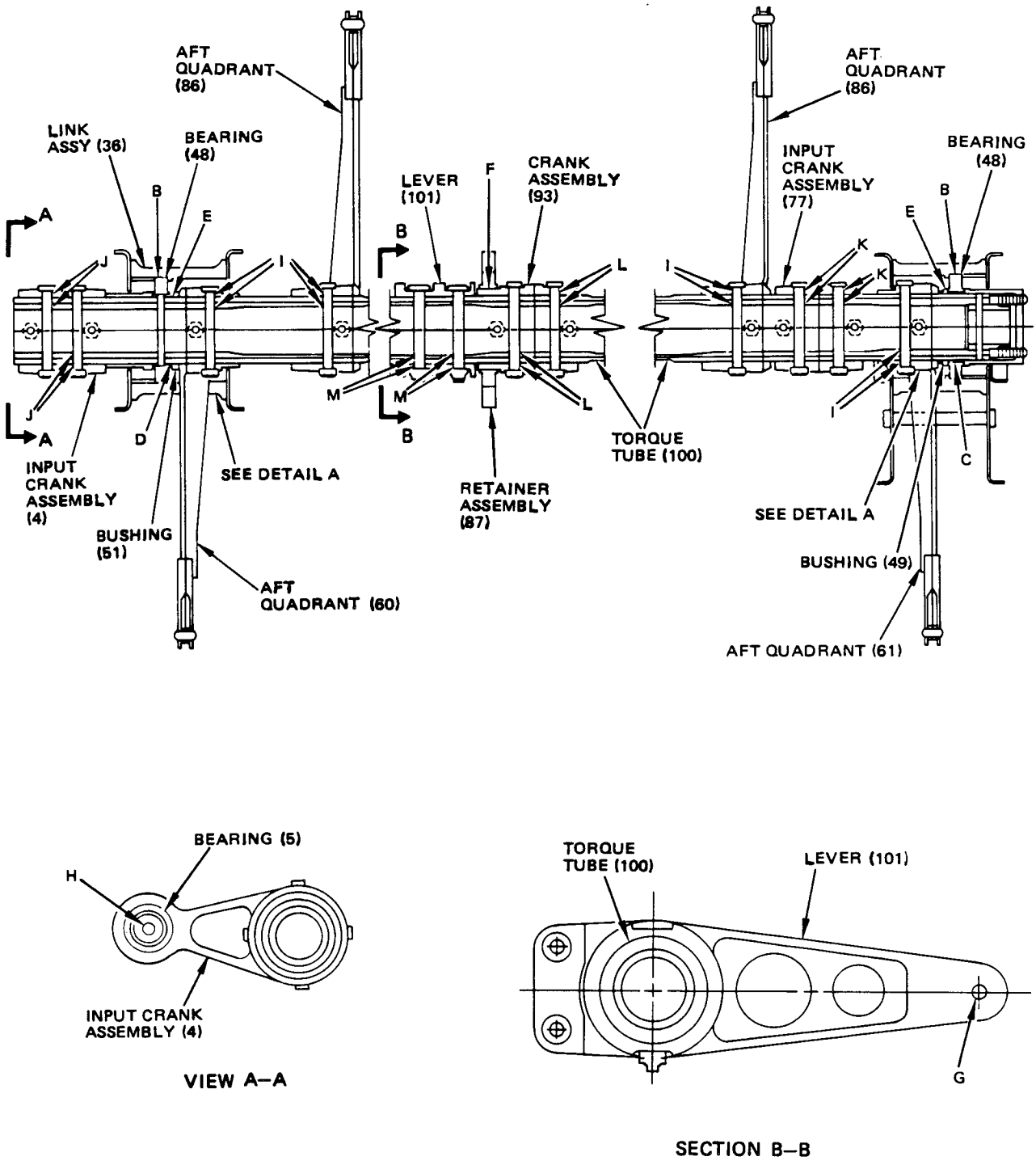
K. Attach sideplates (26, 31, 64, 69) and shroud (16S) to support links (36, 41), with washers (15, 15A, 15B, 15C, 16, 16A) and screws/bolts (13, 13A, 14, 14A). Tighten screws (13, 14) to 18-23 lb-in. Tighten bolts (13A, 14A) to 31.5 - 38.5 lb-in.

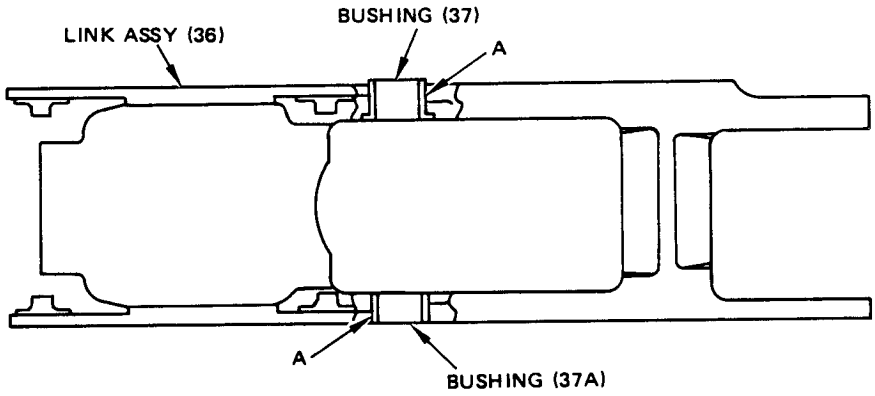
L. Install bearing retainer (12) with washer (11) and screw (10).

M. Install input crank (4) with bolts (3), washers (2), and nuts (1).

N. Touchup all unprimed areas with one coat of primer per 20-41-02.

FITS AND CLEARANCES





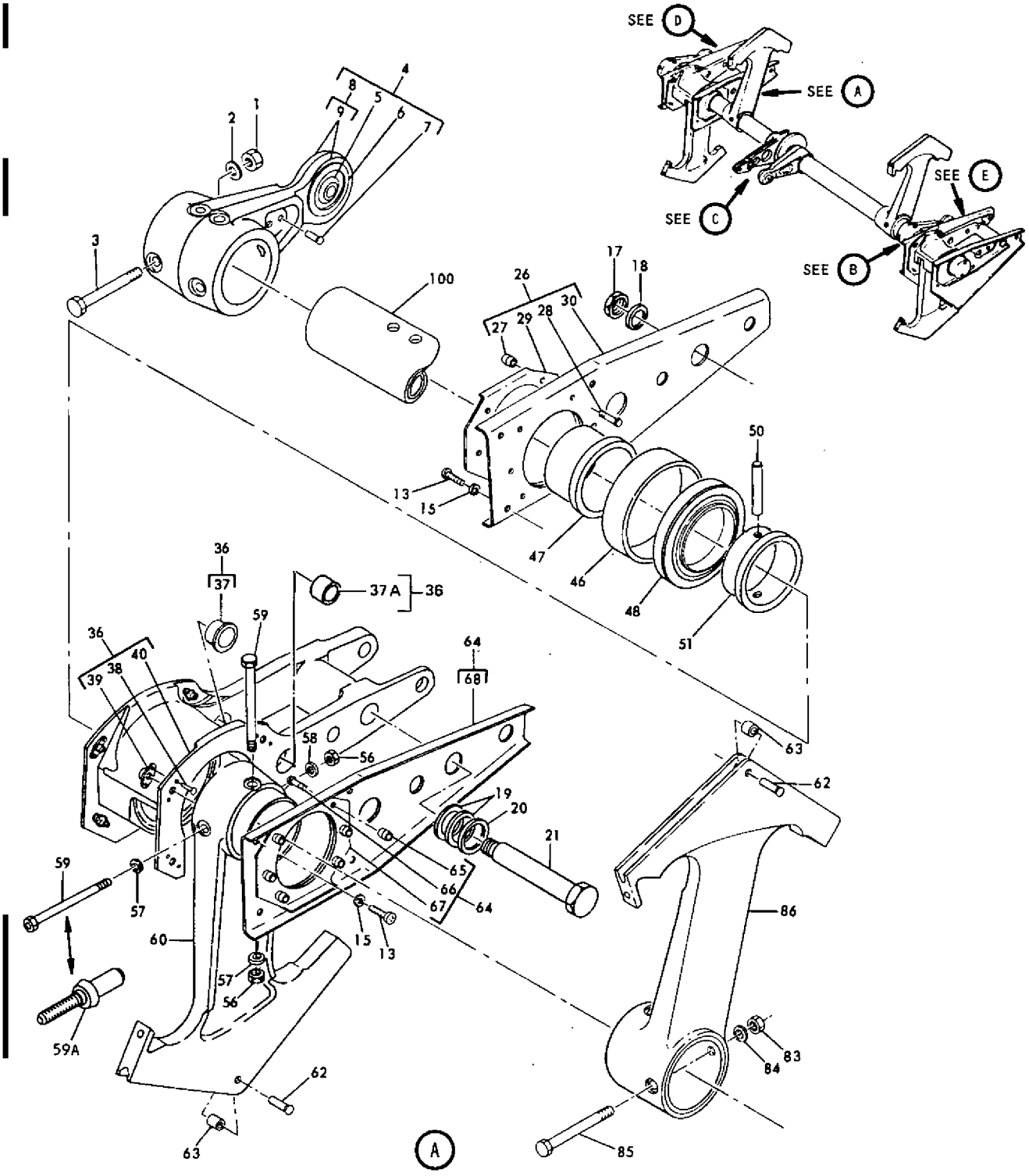
DETAIL A

Ref Letter Fig.	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 40, 45	.7500	.7507	0.0000	0.0012		0.7522	0.0022
	OD 37, 42	.7495	.7500			0.7491		
B	ID 40, 45	3.000	3.001	0.000	0.002		3.004	0.004
	OD 48	2.999	3.000			2.996		
C	ID 48	2.062	2.063	0.000	0.002		2.066	0.004
	OD 49	2.061	2.062			2.058		
D	ID 48	2.062	2.063	0.000	0.002		2.066	0.004
	OD 51	2.061	2.062			2.058		
E	ID 49, 51, 60, 61	1.921	1.923	0.001	0.005		1.930	0.010
	OD 100	1.918	1.920			1.911		
F	ID 88	2.312	2.313	0.000	0.002		2.316	0.004
	OD 97	2.311	2.312			2.308		

Ref Letter Fig.	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	
G	ID 101	0.2500	0.2510	0.0005	0.0025		0.2545	0.0050
	OD *[1]	0.2485	0.2495			0.2450		
H	ID 5,78,94	0.3120	0.3125	0.0000	0.0015		0.3150	0.0030
	OD *[2]	0.3110	0.3120			0.3090		
I	ID 60,61,86,100	0.2495	0.2505	0.0000	0.0020		0.2555	0.0060
	OD 59, 59A *[3]	0.2485	0.2495			0.2435		
I	ID 60,61,86,100	0.2600	0.2620	0.0000	0.0040			
	OD 59A *[4]	0.2580	0.2600					
I	ID 60,61,86,100	0.3120	0.3140	0.0000	0.0040			
	OD 59A *[5]	0.3100	0.3120					
J	ID 4,100	0.2495	0.2505	0.0000	0.0020		0.2535	0.0040
	OD 3	0.2485	0.2495			0.2455		
K	ID 77,100	0.2495	0.2505	0.0000	0.0020		0.2535	0.0040
	OD 110	0.2485	0.2495			0.2455		
L	ID 93,100	0.2495	0.2505	0.0000	0.0020		0.2535	0.0040
	OD 92	0.2485	0.2495			0.2455		
M	ID 100,101	0.2495	0.2505	0.0000	0.0020		0.2535	0.0040
	OD 102	0.2485	0.2495			0.2455		

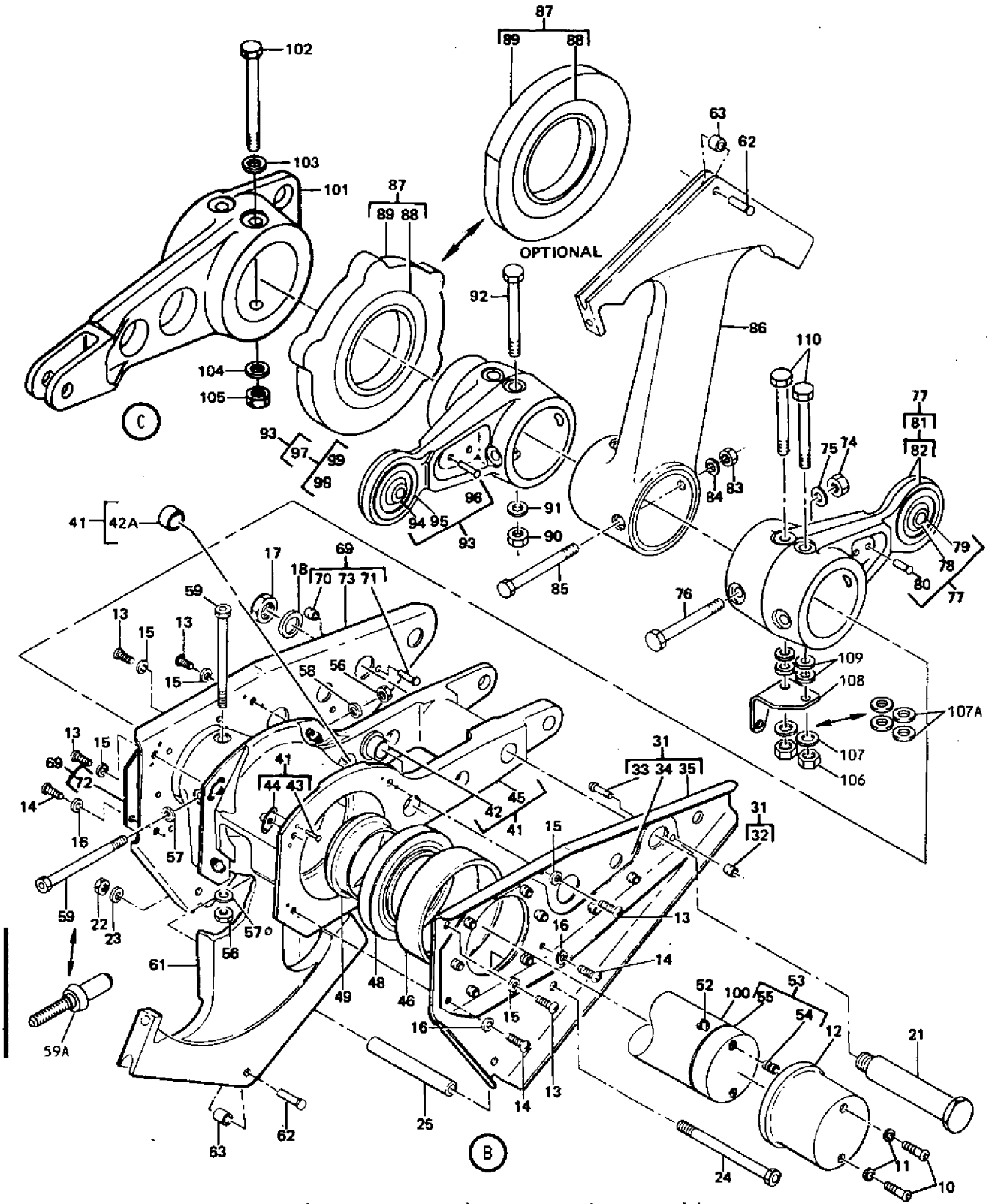
*[1] Installation Bolt BACB30NF4-15
*[2] Installation Bolt 69-27229-11
*[3] NAS1104-37
*[4] BACB30VW8P08U (POST SB 737-27A1274)
*[5] MS21141U1008P (POST SB 737-27A1274)

Fits and Clearances
Figure 601 (Sheet 3)



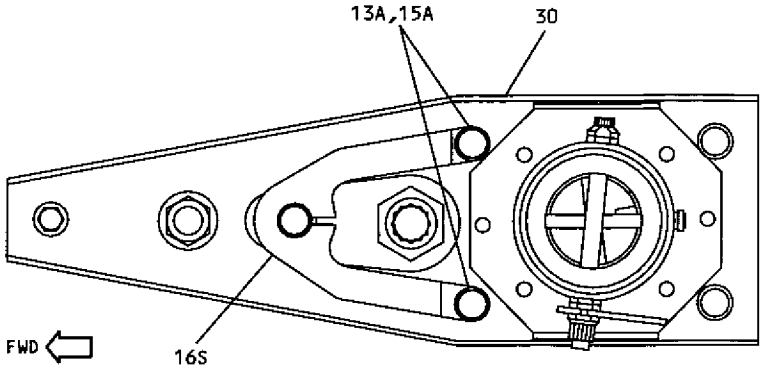
Elevator Control Torque Tube Assembly
Figure 1101 (Sheet 1)

1473587



Elevator Control Torque Tube Assembly
Figure 1101 (Sheet 2)

1418596



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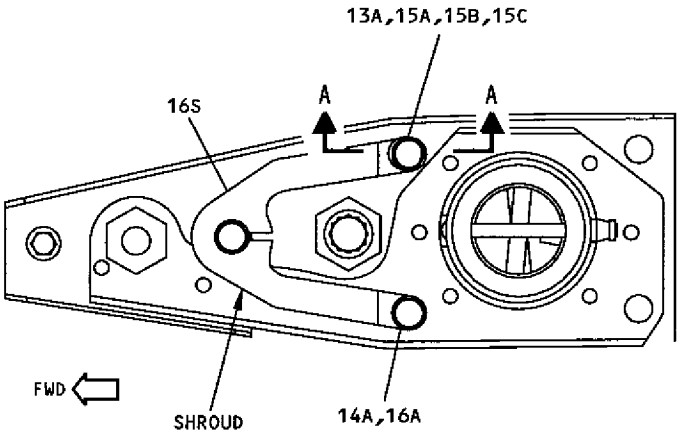

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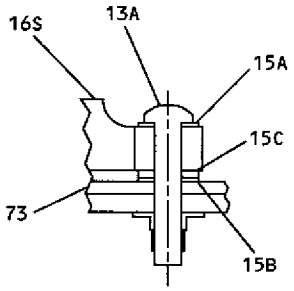

A-A

Elevator Control Torque Tube Assembly
Figure 1101 (Sheet 3)

1473879

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
	65-45187-2		TORQUE TUBE ASSY, ELEVATOR CONTROL	A	RF
	65-45187-3		TORQUE TUBE ASSY, ELEVATOR CONTROL	B	RF
	65-45187-4		TORQUE TUBE ASSY, ELEVATOR CONTROL	C	RF
	65-45187-501		TORQUE TUBE ASSY, ELEVATOR CONTROL	D	RF
	65-45187-7		TORQUE TUBE ASSY, ELEVATOR CONTROL	E	RF
	65-45187-8		TORQUE TUBE ASSY, ELEVATOR CONTROL	F	RF
	65-45187-9		TORQUE TUBE ASSY, ELEVATOR CONTROL	G	RF
	65-45187-10		TORQUE TUBE ASSY, ELEVATOR CONTROL	H	RF
	65-45187-11		TORQUE TUBE ASSY, ELEVATOR CONTROL	I	RF
	65-45187-12		TORQUE TUBE ASSY, ELEVATOR CONTROL	J	RF
	65-45187-13		TORQUE TUBE ASSY, ELEVATOR CONTROL	K	RF
	65-45187-14		TORQUE TUBE ASSY, ELEVATOR CONTROL	L	RF
	65-45187-17		TORQUE TUBE ASSY, ELEVATOR CONTROL	M	RF
	65-45187-19		TORQUE TUBE ASSY, ELEVATOR CONTROL	N	RF
	65-45187-20		TORQUE TUBE ASSY, ELEVATOR CONTROL	O	RF
	65-45187-21		TORQUE TUBE ASSY, ELEVATOR CONTROL	P	RF
	65-45187-22		TORQUE TUBE ASSY, ELEVATOR CONTROL	Q	RF
	65-45187-23		TORQUE TUBE ASSY, ELEVATOR CONTROL	R	RF
1	BACN10JC4		. NUT (REPLD NAS679A4W)		4
2	AN960PD416		. WASHER		4
3	NAS1104-38		. BOLT		4
4	65-45192-1		. CRANK ASSY, INPUT	AD	1
4	65-45192-5		. CRANK ASSY, INPUT	BCE-M O-R	1
5	BACB10AC5		. . BEARING		1
6	69-38919-1		. . SLEEVE		1
7	BACR15BB6D		. . RIVET (REPLS MS20470D6)		2
8	65-45192-3		. . CRANK ASSY, BONDED (USED ON 65-45192-1)		1
8	65-45192-7		. . CRANK ASSY, BONDED (USED ON 65-45192-1)		1
9	69-37480-1		. . . CRANK (USED ON 65-45192-3)		2
9	69-37480-5		. . . CRANK (USED ON 65-45192-7)		2
10	NAS603-12P		. SCREW		2
11	AN960PD10		. WASHER		2
12	69-40393-1		. RETAINER, BEARING		1
13	NAS623-3-4		. SCREW		9
13A	NAS623-3-4		. SCREW (PRE SB 737-27A1274)		3
13A	BACB30NT3K10		. BOLT (POST SB 737-27A1274)		3
14	NAS623-3-5		. SCREW		3
14A	NAS623-3-5		. SCREW (PRE SB 737-27A1274)		1
14A	BACB30NT3K10		. BOLT (POST SB 737-27A1274)		1
15	AN960PD10		. WASHER		9
15A	AN960PD10		. WASHER (PRE SB 737-27A1274)		3

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
15A	NAS1146D0316J		. WASHER (POST SB 737-27A1274)		3
15B	NAS1146D0316J		. WASHER (POST SB 737-27A1274)		1
15C	NAS1149D0363J		. WASHER (POST SB 737-27A1274)		1
16	AN960PD10L		. WASHER		3
16A	AN960PD10L		. WASHER (PRE SB 737-27A1274)		1
16A	NAS1149D0316J		. WASHER (POST SB 737-27A1274)		1
16S	251A2346-2		. SHROUD, GROUND BOLT (POST SB 737-27A1274)		2
17	BACN10JC7		. NUT		2
18	AN960PD716		. WASHER		2
19	AN960PD1016		. WASHER		2
20	AN960PD1016L		. WASHER		1
21	69-43251-1		. BOLT	A-MO	2
21	69-43251-2		. BOLT (OPT)	A-MO	2
21	69-43251-2		. BOLT	PQR	2
22	BACN10JC4		. NUT (REPLS NAS679A4W)		1
23	AN960PD416		. WASHER		1
24	NAS1104-46		. BOLT		1
25	NAS43DD4-176		. SPACER		1
26	69-41217-1		. SIDEPLATE ASSY	A-MOP	1
26	69-41217-7		. SIDEPLATE ASSY	QR	1
27	NAS1080D5		. . COLLAR		6
28	BACB30GQ5		. . LOCKBOLT		6
29	69-41217-5		. . DOUBLER	A-MOP	1
29	69-41217-9		. . DOUBLER	QR	1
30	69-41217-3		. . SIDEPLATE		1
31	69-41216-1		. SIDEPLATE ASSY		1
32	NAS1080D5		. . COLLAR		9
33	BACB30GQ5		. . LOCKBOLT		9
34	69-41216-501		. . DOUBLER		1
35	69-41216-3		. . SIDEPLATE		1
36	65-51262-1		. LINK ASSY, SUPPORT	AD	1
36	65-51262-6		. LINK ASSY, SUPPORT (OPT)	BCE-H	1
36	65-51262-505		. LINK ASSY, SUPPORT (PREF)	BCE-K	1
36	65-51262-501		. LINK ASSY, SUPPORT (OPT)	BCE-K	1
36	65-51262-11		. LINK ASSY, SUPPORT	LM	1
36	65-51262-15		. LINK ASSY, SUPPORT	O-R	1
37	69-43294-2		. . BUSHING		1
37A	69-43294-501		. . BUSHING (USED ON 65-51262-501, -505)		1
38	BACR15CE3D		. . RIVET		16
39	BACN10JR3		. . NUTPLATE (REPLS NAS680A3)		8
40	65-51262-3		. . LINK (USED ON 65-51262-1)		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
40	65-51262-8		. . LINK (USED ON 65-51262-6)		1
40	65-51262-503		. . LINK (USED ON 65-51262-501,-505)		1
40	65-51262-13		. . LINK (USED ON 65-51262-11)		1
40	65-51262-17		. . LINK (USED ON 65-51262-15)		1
41	65-51262-2		. LINK ASSY, SUPPORT	AD	1
41	65-51262-7		. LINK ASSY, SUPPORT (OPT)	BCE-H	1
41	65-51262-506		. LINK ASSY, SUPPORT (PREF)	BCE-K	1
41	65-51262-502		. LINK ASSY, SUPPORT (OPT)	BCE-K	1
41	65-51262-12		. LINK ASSY, SUPPORT	LM	1
41	65-51262-16		. LINK ASSY, SUPPORT	O-R	1
42	69-43294-2		. . BUSHING		1
42A	69-43294-501		. . BUSHING (USED ON 65-51262-502, -506)		1
43	BACR15CE3D		. . RIVET		16
44	BACN10JR3		. . NUTPLATE (REPLS NAS680A3)		8
45	65-51262-4		. . LINK (USED ON 65-51262-2)		1
45	65-52162-9		. . LINK (USED ON 65-51262-7)		1
45	65-51262-504		. . LINK (USED ON 65-51262-502,-506)		1
45	65-51262-14		. . LINK (USED ON 65-51262-12)		1
45	65-51262-18		. . LINK (USED ON 65-51262-16)		1
46	69-41231-1		. SPACER		2
47	69-40714-1		. SPACER		1
48	BACB10EX33		. BEARING (REPLS BACB1OA832)		2
48	MS27648-33		. BEARING (OPT)		2
48	BACB10FV33J		. BEARING (OPT)		2
49	69-41229-1		. BUSHING		1
50	NAS607-3-16P		. PIN		1
51	69-40715-1		. BUSHING		1
52	NAS607-3-15P		. PIN		1
53	69-40380-1		. BUSHING ASSY		1
54	MS21209F1-15		. . INSERT		2
55	69-40380-2		. . BUSHING		1
56	BACN10JC4		. NUT (REPLS NAS679A4W)		4
57	AN960PD416		. WASHER		4
58	AN960PD416L		. WASHER		2
59	NAS1104-37		. BOLT		2
59A	NAS1107-37		. BOLT (PRE SB 737-27A1274)		2
59A	BACB30VW8P08U		. BOLT, BLIND (OPT) (POST SB 737-27A1274)		2
59A	MS21141U1008P		. BOLT, BLIND (OPT) (POST SB 737-27A1274)		2
60	65-50584-3		. QUADRANT, AFT (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-					
60	65-50584-10		. QUADRANT, AFT (OPT)	BCE-M O-R	1
60	65-50584-8		. QUADRANT, AFT	AD	1
60	65-50584-14		. QUADRANT, AFT (OPT)	QR	1
61	65-50584-4		. QUADRANT, AFT (OPT)	A	1
61	65-50584-11		. QUADRANT, AFT (OPT)	BCE-M O-R	1
61	65-50584-9		. QUADRANT, AFT	AD	1
61	65-50584-15		. QUADRANT, AFT (OPT)	QR	1
62	BACR15BB6D		. RIVET (REPLS MS2047OD6)		4
63	NAS42DD6-18		. SPACER		4
64	69-41217-2		. SIDEPLATE ASSY	A-MOP	1
64	69-41217-8		. SIDEPLATE ASSY	QR	1
65	NAS108OD5		. . COLLAR		6
66	BACB30GQ5		. . LOCKBOLT		6
67	69-41217-5		. . DOUBLER	A-MOP	1
67	69-41217-9		. . DOUBLER	QR	1
68	69-41217-3		. . SIDEPLATE		1
69	69-41216-2		. SIDEPLATE ASSY		1
70	NAS1080D5		. . COLLAR		9
71	BACB30GQ5		. . LOCKBOLT		9
72	69-41216-502		. . DOUBLER		1
73	69-41216-4		. . SIDEPLATE		1
74	BACN10JC4		. NUT (REPLS NAS679A4W)		2
75	AN960PD416		. WASHER		2
76	NAS1104-38		. BOLT		2
77	65-45192-1		. CRANK ASSY, INPUT	AD	1
77	65-45192-5		. CRANK ASSY, INPUT	BCE-M O-R	1
78	BACB10AC5		. . BEARING		1
79	69-38919-1		. . SLEEVE		1
80	BACR15BB6D		. . RIVET (REPLS MS2047OD6)		2
81	65-45192-3		. . CRANK ASSY, BONDED (USED ON 65-45192-1)		1
81	65-45192-7		. . CRANK ASSY, BONDED (USED ON 65-45192-5)		1
82	69-37480-1		. . . CRANK (USED ON 65-45192-3)		2
82	69-37480-5		. . . CRANK (USED ON 65-45192-7)		2
83	BACN10JC4		. NUT (REPLS NAS679A4W)		4
84	AN960PD416		. WASHER		4
85	NAS1104-37		. BOLT		4
86	65-50584-6		. QUADRANT, AFT (OPT)	A	2
86	65-50584-7		. QUADRANT, AFT	AD	2
86	65-50584-12		. QUADRANT, AFT	BCE-M O-R	2

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
87	69-40348-3		. RETAINER ASSY	B-MOPQ	1
87	69-40348-3		. RETAINER ASSY (LIMITED USAGE)	A	1
87	69-40348-1		. RETAINER ASSY (OPT TO 69-40348-3) (LIMITED USAGE)	A	1
87	69-40348-6		. RETAINER ASSY	R	1
88	BACB10EX37		. . BEARING (REPLS BACB10A833)		1
88	MS27648-37		. . BEARING (OPT)		1
88	BACB10FV37J		. . BEARING (OPT)		1
89	69-40348-4		. . RETAINER (USED ON 69-40348-3)		1
89	69-40348-2		. . RETAINER (USED ON 69-40348-1)		1
89	69-40348-5		. . RETAINER (USED ON 69-40348-6)		1
90	BACN10JC4		. NUT (REPLS NAS679A4W)		4
91	AN960PD416		. WASHER		4
92	NAS1104-38		. BOLT		4
93	65-45192-2		. CRANK ASSY, INPUT	AD	1
93	65-45192-6		. CRANK ASSY, INPUT	BCE-M O-R	1
94	BACB10AC5		. . BEARING		1
95	69-38919-1		. . SLEEVE		1
96	BACR15BB6D		. . RIVET (REPLS MS2047OD6)		2
97	65-45192-4		. . CRANK ASSY, BONDED (USED ON 65-45192-2)		1
97	65-45192-8		. . CRANK ASSY, BONDED (USED ON 65-45192-6)		1
98	69-37480-1		. . . CRANK (USED ON 65-45192-4)		1
98	69-37480-5		. . . CRANK (USED ON 65-45192-8)		1
99	69-37480-4		. . . CRANK (USED ON 65-45192-4)		1
99	69-37480-6		. . . CRANK (USED ON 65-45192-8)		1
100	65-45193-1		. TORQUE TUBE ASSY	ABDI	1
100	65-45193-6		. TORQUE TUBE ASSY	CEFGJ	1
100	65-45193-10		. TORQUE TUBE ASSY	HKLM O-R	1
101	65C19775-1		. LEVER	CE-HJ-M O-R	1
102	BACB30NF4-37		. BOLT	CE-HJ-M O-R	2
103	AN960PD416		. LOCKWASHER	CE-HJ-M O-R	2
104	AN960PD416L		. LOCKWASHER	CE-HJ-M O-R	2
105	BACN10JC4		. NUT (REPLS NAS679A4W)	CE-HJ-M O-R	2
106	BACN10JC4		. NUT (REPLS NAS679A4W)		2

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
107	AN960PD416		. WASHER	A-DF-R	2
107A	AN960PD416		. WASHER	E	4
108	69-71796-7		. BRACKET (PRE SB 27-1163)	E	1
108	69-71796-9		. BRACKET (PRE SB 27-1163)	F	1
108	69-71796-10		. BRACKET (PRE SB 27-1163)	G-L	1
108	69-71796-13		. BRACKET (POST SB 27-1163)	E-L	1
108	69-71796-13		. BRACKET	MO-R	1
109	AN960PD416		. WASHER	E-R	4
110	NAS1104-38		. BOLT	A-DI	2
110	BACB30NF4-44		. BOLT	E	2
110	BACB30NF4-42		. BOLT	FGHJ-M O-R	2