TO: ALL HOLDERS OF FLAP DRIVE COMPONENTS OVERHAUL MANUAL, 27-55-41

REVISION NO. 19, DATED JUL 1/09

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
In step 4.B.(3)(c)3) changed "69-40405-8, -10" to "69-40205-8, -10"					X								

FLAP DRIVE COMPONENTS

27-55-41

BOEING P/N SEE PAGE 1

AIRLINE P/N

THE FOLLOWING DIRECTIVES APPLY TO THIS SUBJECT:

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVES	DATE DIRECTIVE INCORPORATED INTO TEXT
		PRR 30627	Feb 15/68
		PRR 31081	Feb 15/69
27-1028		PRR 31960-3	Sep 10/71
57-1073		PRR 32070-6	Jun 25/74
		PRR 32121-10	Dec 25/74
		PRR 32503	Dec 25/75
		PRR 33310-1	Dec 5/83
57-1227			Mar 1/95
27-1200		PRR 35005-162	Nov 1/03

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
	27-55-41		19	Nov 1/03		
	T-1	Nov 1/03	20	Nov 1/03		
	T-2	BLANK	21	Nov 1/03		
*	LEP-1	Jul 1/09	22	Nov 1/03		
	LEP-2	BLANK	23	Nov 1/03		
	T/C-1	Nov 1/03	24	BLANK		
	T/C-2	BLANK				
	1	Nov 1/03				
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*	2C	Jul 1/09				
	2D	Nov 1/03				
	2E	Nov 1/03				
	2F	Nov 1/03				
	2G	Nov 1/03				
	2H	Nov 1/03				
	2I	Nov 1/03				
	2J	Nov 1/03				
	2K	Nov 1/03				
	2L	BLANK				
	3	Nov 1/03				
	4	Nov 1/03				
	5	Nov 1/03				
	6	Nov 1/03				
	6A	Nov 1/03				
	6B	Nov 1/03				
	6C	Nov 1/03				
	6D	BLANK				
	7	Nov 1/03				
	8	Jun 1/95				
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	8B	BLANK				
	9	Nov 1/03				
	10	Nov 1/03				
	11	Jun 1/95				
	12	Nov 1/03				
	13	Nov 1/03				
	14	Nov 1/03				
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	16	Nov 1/03				
	16A	Nov 1/03				
	16B	BLANK				
	17	Nov 1/03				
	18	Nov 1/03				

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*[1] Special instructions are not necessary. Use standard industry practices.
*[2] Also use the instructions in SOPM 20-30-01 and 20-30-03.
*[3] Also use the instructions in SOPM 20-44-02 and 20-70-01.

FLAP DRIVE COMPONENTS

Part Number	Nomenclature	Fig.
65-49529	Bellcrank Assy	12
65-50587	Outboard Flap Drive Gimbal *[1]	1A
65-51280	Support Assy	9
65-52925	Drive Shaft Assy	3
65-55509	Cam Track *[1]	1B
65-55552	Bellcrank Assy	13
65-68271	Cam Track *[1]	1B
65-73271	Drive Shaft Assy	10
65C30843	Cam Track *[1]	1C
65C30844	Cam Track *[1]	1C
65C30846	Bellcrank Assy	12
65C33679	Cam Track *[1]	1C
65C33680	Cam Track *[1]	1C
65C37893	Drive Shaft Assy	3,10
69-38943	Torque Tube Assy	4
69-39236	Pushrod Assy	11
69-40205	Drive Shaft Assy	5
69-44671	Support Assy	6
69-45163	Torque Tube Assy	7
69-46648	Torque Tube Assy	8
69-46649	Torque Tube Assy	8
69-54904	Cam Track *[1]	1B

*[1] Inspection and Refinish data only.

1. DESCRIPTION AND OPERATION

A. The flap drive components include metal tubes, couplings, sleeves, bearing supports, bellcranks, cam tracks, and pushrods.

B. These flap drive components, with the flap drive gearbox assemblies, transmit torque from the flap drive power unit assembly to the flap drive transmission assemblies.

2. DISASSEMBLY

A. Disassemble these components only as necessary for fault isolation, to find the serviceability of parts, and to do repairs and restore the unit to serviceable condition.

B. Before you disassemble drive shaft assemblies (Fig. 3, 5, 10) or torque tube assemblies (Fig. 4, 7, 8), refer to Fits and Clearances for limits of the spline backlash between couplings and sleeves. Be sure to measure backlash within worn area of internal spline of sleeve.

3. INSPECTION/CHECK

A. Examine all parts for defects by standard industry practices. Refer to Fits and Clearances for design dimensions and wear limits.

B. Penetrant check (SOPM 20-20-02) -- cam tracks (Fig. 1B), tubes (4, Fig. 3, 5, 8, 10; 6, Fig. 11), shafts (7, Fig. 4, 7), supports (2, Fig.6, 9) and bellcranks (12, Fig. 12; 5, Fig. 13). Be sure to include the ID and OD of the formed ends.

C. Magnetic particle check (SOPM 20-20-01) -- sleeves (1, Fig. 3, 4, 5, 7, 8, 10), couplings (3, Fig. 3, 4, 5, 7, 8, 10), shaft ends (5, Fig. 4; 6, Fig. 7).

D. Magnetic particle check (SOPM 20-20-01) -- gimbal (Fig. 1A; 65-50587-1 and -3) before and after plating (see Repair par. B.28), gimbal (Fig. 1; 65-50587-4) before shot peening and after plating (see Repair par. B.29).

4. REPAIR

A. Repair

(1) Repair small defects by standard industry practices. Material removal on torque tubes and shafts is limited by minimum wall thickness requirements given in Fits and Clearances.

(2) Repair drive shaft assemblies (65-52925-3, -20, 65-73271-15, -17) as follows:

(a) For torque tube (4, Fig. 3 and 10) wear less than 0.008 inch: blend the wear smoothly into the adjacent area. Refinish the tube per Refinish.

(b) For torque tube wear more than 0.008 inch:

1) Separate the tube at the worn area.

2) Make a solid round plug per Fig. 1. Chemical treat or chromic acid anodize (SOPM 20-43-03) the plug.

3) Install the plug 3.00 inches into one end of the torque tube.

4) Drill five 0.191-0.197 inch holes through the torque tube and plug. Space holes as shown (Fig. 1); alternate holes at 90 degrees with respect to each other.

5) Remove the plug and remove burrs. Then install the plug with wet BMS 10-11, Type 1 primer.

6) Install five BACR15BB6D rivets.

7) Put the other end of the separated torque tube on the plug. Adjust length as shown (Fig. 1). Straightness should be 0.010 inch TIR per foot of length.

8) Drill five holes per step 4).

9) Remove unfastened end of torque tube from plug and remove burrs. Install the plug with wet BMS 10-11, Type 1 primer.

10) Install five BACR15BB6D rivets.

11) Apply Type 60 adhesive (SOPM 20-50-12) between torque tube sections.

12) Refinish the torque tube per Refinish.

13) Make a tag or note to make sure that rivets do not catch on adjacent cables, tubes, or structure.

B. Refinish

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

(1) Fig. 3 parts

(a) Sleeve (1)

1) 69-33513-1, -4: Cadmium plate (F-15.02). Material: 4140 steel, 150-170 ksi.

2) 271N4276-1, -2: Cadmium plate (F-15.02). Apply BMS 10-11, Type 1 primer (F-20.02) but not on spline teeth or in ID. Material: 4330M or 4140 steel, 150-170 ksi.

(b) Coupling (3) -- Cadmium plate (F-1.20). Material: 4140 steel, 150-170 ksi.

(c) Tubes (4)

1) 65-52925-9 thru -12, -16, -26 thru -29, -33: Chemical treat and apply BMS 10-11, Type 1 primer (SRF-2.901). Apply BMS 10-10, Type 2 enamel (SRF-12.63). Material: Al alloy.

2) 65-52925-14, -25, -38 thru -41: Chemical treat and apply BMS 10-11, Type 1 primer (SRF-2.901). Material: Al alloy.

3) 65-52925-44, -45, -48, -49: Chemical treat and apply BMS 10-11, Type 1 primer (F-18.07). Material: Al alloy.

4) 65-52925-55, -56: Chemical treat and apply BMS 10-11, Type 1 primer (F-18.07). Material: Al alloy.

(d) Drive shaft assembly topcoat

1) 65-52925-54, -55, 65C37893-3, -4: Fig. 1D.

(2) Fig. 4 parts

(a) Sleeve (1) -- Cadmium plate (F-15.02). Material: 4140 steel, 150-170 ksi.

(b) Coupling (3) -- Cadmium plate (F-1.20). Material: 4140 steel, 150-170 ksi.

(c) Shaft end (5) -- Cadmium plate (F-15.02) all external surfaces and 1.257-inch ID, 0.0002-0.0003 inch thick. Apply BMS 10-11, Type 1 primer (F-20.02) to ID. Material: 4340 steel, 180-200 ksi.

(d) Plug (6) -- No finish. Material: Phenolic plastic.

(e) Shaft (7)

1) 69-38943-5, -7: Chemical treat and apply BMS 10-11, Type 1 primer (SRF-2.901). Material: Al alloy.

2) 69-38943-10: Chemical treat and apply BMS 10-11, Type 1 primer (SRF-2.901). Apply BMS 10-60 enamel (F-14.9813, which replaces SRF-14.9813). Material: Al alloy.

(3) Fig. 5 parts

(a) Sleeve (1)

1) 69-33513-1, -4: Cadmium plate (F-15.02). Material: 4140 steel, 150-170 ksi.

2) 271N4276-1, -2: Cadmium plate (F-15.02). Apply BMS 10-11, Type 1 primer (F-20.02) but not on spline teeth or in ID. Material: 4330M or 4140 steel, 150-170 ksi.

(b) Coupling (3) -- Cadmium plate (F-1.20). Material: 4140 steel, 150-170 ksi.

(c) Tube (4)

1) 69-40205-2, -4: Chemical treat and apply BMS 10-11, Type 1 primer (SRF-2.901). Material: Al alloy.

2) 69-40205-6: Chemical treat and apply BMS 10-11, Type 1 primer (SRF-2.901). Apply BMS 10-60 enamel (F-14.9813, which replaces SRF-14.9813). Material: Al alloy.

3) 69-40205-8, -10: Chemical treat and apply BMS 10-11, Type 1 primer (F-18.07). Apply BMS 10-86 Teflon coating (F-14.9624, which replaces SRF-14.9624) in a 1.90-2.10-inch wide band 3.03-3.23 inches from each end. Material: Al alloy.

(4) Fig. 6 parts

(a) Support (2) -- Chemical treat or chromic acid and apply BMS 10-11, Type 1 primer (SRF-2.30) and BMS 10-11, Type 2 enamel (SRF-12.63) but no primer or enamel in the bore for the bearing. Material: Al alloy.

(5) Fig. 7 parts

(a) Sleeve (1) -- Cadmium plate (F-15.02). Material: 4140 steel, 150-170 ksi.

(b) Coupling (3) -- Cadmium plate (F-1.20). Material: 4140 steel, 150-170 ksi.

(c) Shaft end (6) -- Cadmium plate (F-15.02) the OD, 0.0002-0.0003 inch thick. In the bore, phosphate treat (F-16.12, which replaces F-14.14) and apply BMS 10-11, Type 1 primer (F-20.03). Material: 4340 steel, 150-170 ksi.

(d) Shaft (7) -- Chemical treat and apply BMS 10-11, Type 1 primer (SRF-2.30) and BMS 10-60, Type 2 enamel (SRF-12.63) but no primer or enamel on spline teeth. Material: Al alloy.

(6) Fig. 8 parts

(a) Sleeve (1)

1) 69-33513-1: Cadmium plate (F-15.02). Material: 4140 steel, 150-170 ksi.

2) 271N4276-1: Cadmium plate (F-15.02). Apply BMS 10-11, Type 1 primer (F 20.02) but not on spline teeth or in ID. Material: 4330M or 4140 steel, 150-170 ksi.

(b) Coupling (3) -- Cadmium plate (F-1.20). Material: 4140 steel, 150-170 ksi.

(c) Tube (4)

1) 69-46648-2, -4: Chemical treat and apply BMS 10-11, Type 1 primer (SRF-2.901) and BMS 10-60, Type 2 enamel (SRF-12.63) but no primer or enamel on spline teeth. Material: Al alloy.

2) 69-46648-6: Chemical treat and apply BMS 10-11, Type 1 primer (F-18.07). Apply BMS 10-86 Teflon coating (F-14.9624, which replaces SRF-14.9624) in a 1.90-2.10-inch wide band 7.38-7.58 inches from each end. Material: Al alloy.

3) 69-46649-2: Material: Chemical treat and apply BMS 10-11, Type 1 primer (SRF-2.901) and BMS 10-60, Type 2 enamel (SRF-12.63) but no primer or enamel on spline teeth. Material: Al alloy.

4) 69-46649-4: Chemical treat and apply BMS 10-11, Type 1 primer (F-18.07). Material: Al alloy.

(d) Fitting (5) -- Chemical treat or chromic acid and apply BMS 10-11, Type 1 primer (F-18.05). Material: Al alloy.

(7) Fig. 9 parts

(a) Support (2) -- Sulfuric acid anodize (F-2.201). Apply BMS 10-11, Type 1 primer (SRF-12.201) but not in hole for bearing. Material: Al alloy.

(8) Fig. 10 parts

(a) Sleeve (1) -- Cadmium plate (F-15.02). Apply BMS 10-11, Type 1 primer (F-20.02) but not on spline teeth. Material: 4140 steel, 110-170 ksi.

(b) Coupling (3) -- Cadmium plate (F-1.20). Material: 4140 steel, 150-170 ksi.

(c) Tube (4)

1) 65-73271-7, -8, -9, -12, -16: Chemical treat and apply BMS 10-11, Type 1 primer (SRF-2.901). Material: Al alloy.

2) 65-73271-10, -11, -14, -18, -19, -20, -24: Chemical treat and apply BMS 10-11, Type 1 primer (F-18.07). Material: Al alloy.

(d) Drive shaft assembly topcoat

1) 65-73271-1, -2, -3, -6: Apply BMS 10-11, Type 1 primer (SRF-12.205) and BMS 10-10, Type 2 enamel (SRF-12.63), to the coupling, but not on the spline teeth.

2) 65-73271-4, -5, -13, -17: Apply BMS 10-11, Type 1 primer and BMS 10-60 enamel (F-14.9813, which replaces SRF-14.9813) to the coupling, but not on the spline teeth.

3) 65-73271-21, -22, -23, 65C37893-5, -6, -7: Apply BMS 10-11, Type 1 primer (SRF-12.205) and BMS 10-10, Type 2 enamel (SRF-12.63), to the coupling, but not on the spline teeth. Apply enamel per Fig. 1D.

(9) Fig. 11 parts

(a) Tube (6)

1) 69-39236-3, -4: Chemical treat and apply BMS 10-11, Type 1 primer (SRF-2.901) but no primer on threads. Apply BMS 10-11, Type 2 enamel (SRF-12.63) on exterior. Material: Al alloy.

2) 69-39236-7, -8: Chemical treat and apply BMS 10-11, Type 1 primer (F-18.07) but no primer on threads. Apply BMS 10-11, Type 2 enamel (F-21.02) on exterior. Material: Al alloy.

3) 69-39236-16: Chemical treat and apply BMS 10-11, Type 1 primer (F-18.07) but no primer on threads. Apply BMS 10-11, Type 2 enamel (F-21.02) on exterior. Material: Al alloy.

(10) Fig. 12 parts

(a) Clevis (8)

1) 69-37836-1: Cadmium plate (F-15.02). Material: 4140 steel, 160-180 ksi.

2) 69-37836-2: Passivate (F-17.25, which replaces F-17.09). Material: 15-5PH CRES, 180-200 ksi.

(b) Bellcrank (12)

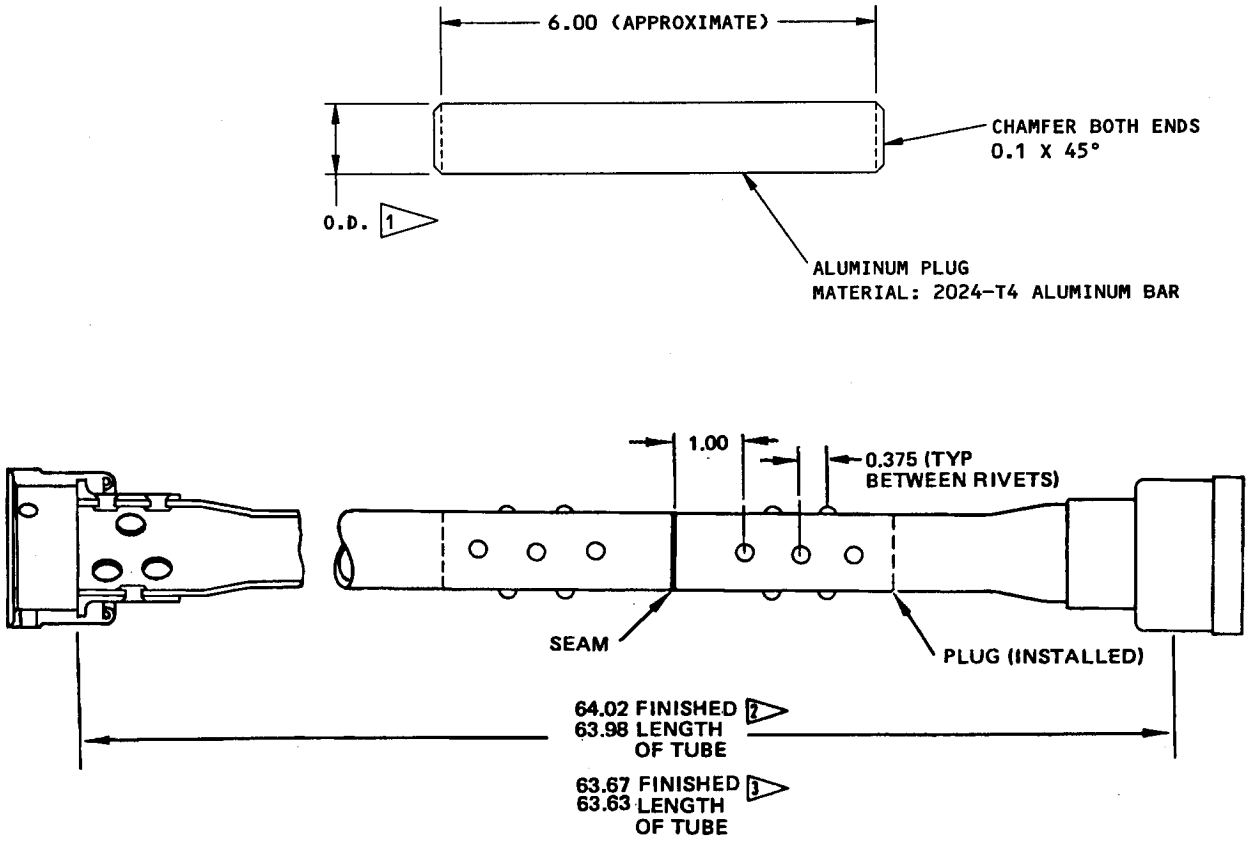
1) 65-55508-series: Chemical treat or chromic acid anodize and apply BMS 10-11, Type 1 primer (F-18.05) and BMS 10-11, Type 2 enamel (F-21.02) but no primer or enamel on machined internal surfaces. Material: Al alloy.

2) 65C30900-1 thru -4, -7 thru -10: Chromic acid anodize (F-17.04). Apply BMS 10-11, Type 1 primer (F-20.02) and BMS 10-11, Type 2 enamel (F-21.02) but not in holes. Material: Al alloy.

3) 65C30900-11 thru -18: Chromic acid anodize (F-17.19). Apply BMS 10-11, Type 1 primer (F-20.02) and BMS 10-11, Type 2 enamel (F-21.02) but not in holes. Material: Al alloy.

(11) Gimbals 65-50587-series -- See Fig. 1A.

(12) Cam tracks -- See Fig. 1B, 1C.



125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

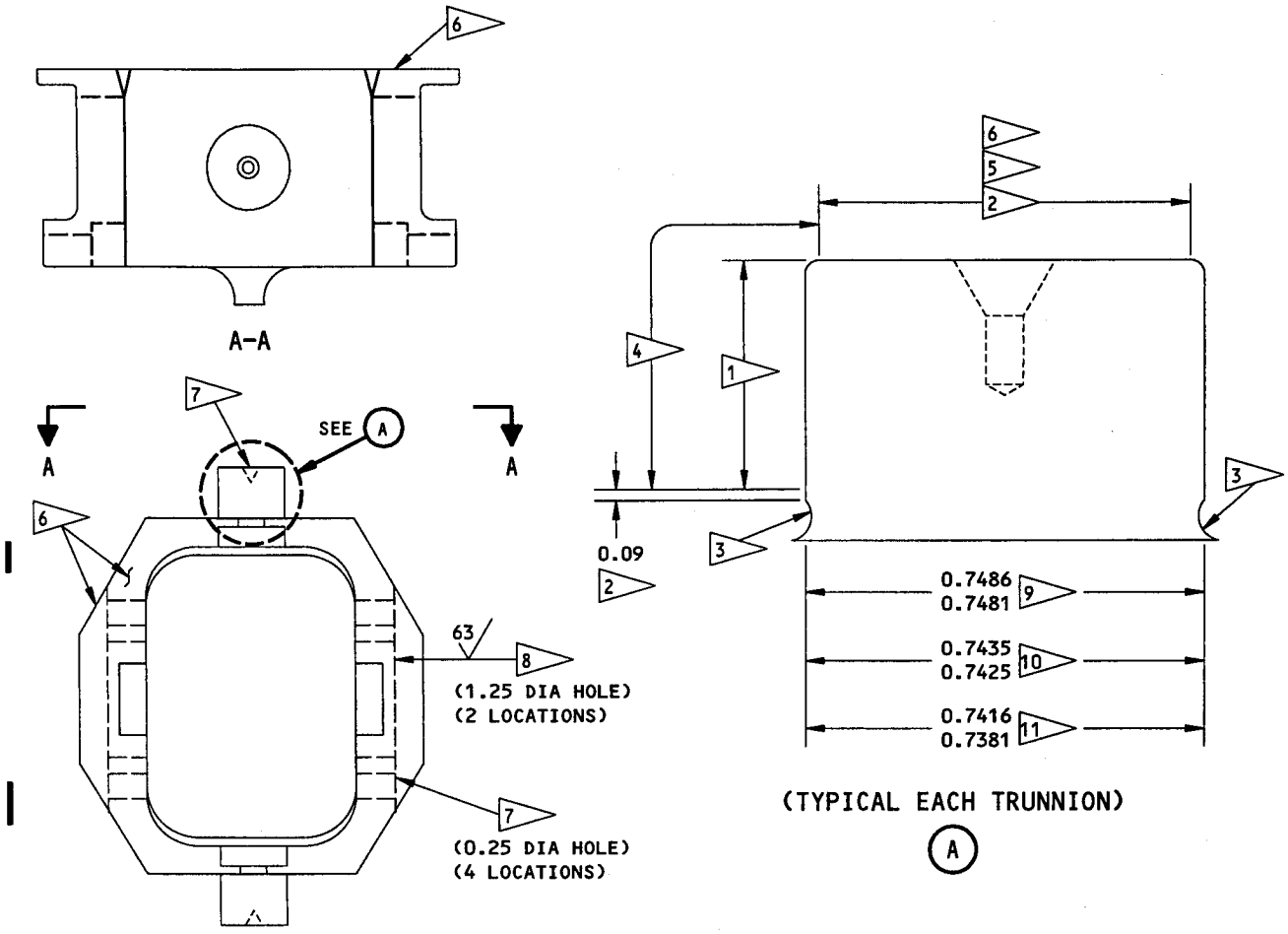
ALL DIMENSIONS ARE IN INCHES

1. ADJUST THE OD FOR 0.000-0.005 CLEARANCE WITH CLEARANCE WITH ID OF SHAFT.
2. 65-52925-3, -20; 65-73271-15
3. 65-73271-17

65-52925-3,-20
65-73271-15,-17

Shaft Assembly Repair
Figure 1

W52807



REFINISH

CHROME PLATE SURFACES SHOWN BY 1.

CADMIUM PLATE (F-15.02) AND APPLY BMS 10-11 TYPE 1 PRIMER (F-20.02) UNLESS SHOWN BY 4. APPLY ENAMEL AS SHOWN BY 6

1. CHROME PLATE (F-15.03), 0.003-0.005 THICK.
2. CHROME PLATE RUNOUT AREA
3. NO CHROME PLATE
4. NO PRIMER IN THIS AREA
5. PRIMER MUST COVER UNPLATED SURFACE (65-50587-1 ONLY)
6. APPLY BMS 10-60 ENAMEL (F-14.9813, WHICH REPLACES SRF-14.9813) OR BMS 10-11, TYPE 2 ENAMEL (F-21.02) (65-50587-3,-4)
7. DO NOT SHOT PEEN
8. CADMIUM PLATE (F-15.02) 0.0002-0.0003 THICK

REPAIR

(SAME AS REFINISH)

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MAGNETIC PARTICLE EXAMINE (SOPM 20-20-01) IMMEDIATELY BEFORE SHOT PEENING AND IMMEDIATELY AFTER PLATING

SHOT PEEN (SOPM 20-10-03)
0.017-0.046 SHOT SIZE
0.016 A2 INTENSITY

MATERIAL:
65-50587-1, -3: 4340 STEEL, 180-200 KSI
65-50587-4: 4330M STEEL, 180-200 KSI

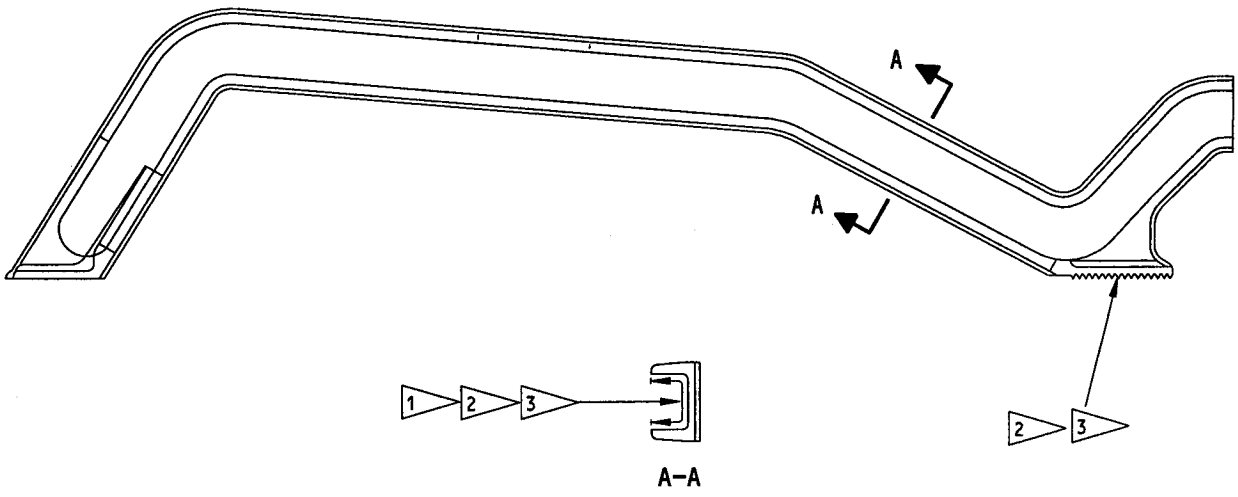
ALL DIMENSIONS ARE IN INCHES

9. DIAMETER AFTER PLATING (65-50587-1,-3,-4)
10. DIAMETER BEFORE PLATING (65-50587-1,-3)
11. DIAMETER BEFORE PLATING (65-50587-4)

65-50587-1,-3,-4

Outboard Flap Drive Gimbal Refinish
Figure 1A

695486



A-A

REFINISH

HARD ANODIZE (F-17.06) AREA SHOWN BY 2.
CHROMIC ACID ANODIZE (F-17.04) OTHER AREAS.
APPLY BMS 10-11, TYPE 1 PRIMER (F-20.02) AND
BMS 10-11 TYPE 2 ENAMEL (SRF-12.63 OR F-21.02)
UNLESS SHOWN BY 2 3.

REPAIR

(SAME AS REFINISH)

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

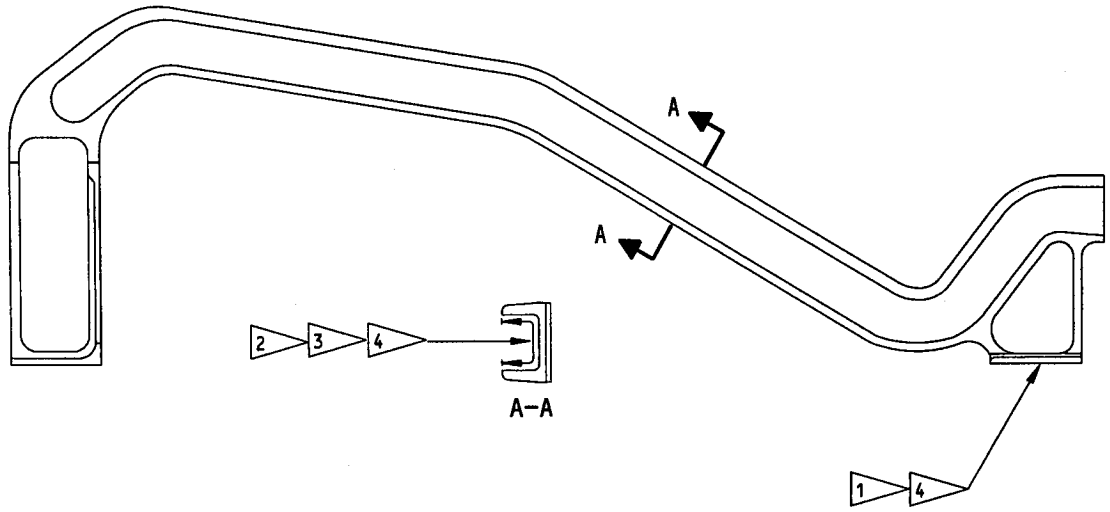
1 HARD ANODIZE THIS AREA, ON THE FULL LENGTH OF TRACK
NO CHROMIC ACID ANODIZE, PRIMER, OR ENAMEL IN THIS AREA

2 NO PRIMER IN THIS AREA (65-68271)

3 NO ENAMEL IN THIS AREA

65-55509-1 SHOWN
65-55509-2,-5,-6,-9,-10 SIMILAR
69-54904-5,-6 SIMILAR
65-68271-1,-2,-7,-8,-11,-12 SIMILAR

Cam Track Refinish
Figure 1B



REFINISH

HARD ANODIZE (F-17.06) AREA SHOWN BY 2.
FLASH HARD ANODIZE (F-17.30) OTHER SURFACES AND APPLY BMS 10-11 TYPE 1 PRIMER (F-20.02) AND BMS 10-11 TYPE 2 ENAMEL (F-21.02) UNLESS SHOWN BY 3 4.

1. DO NOT SHOT PEEN THIS AREA
2. HARD ANODIZE (F-17.06), FULL LENGTH OF TRACK
3. NO PRIMER ON THIS SURFACE
4. NO ENAMEL ON THIS SURFACE

REPAIR

(SAME AS REFINISH)

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

SHOT PEEN (SOPM 20-10-03)(UNLESS SHOWN BY 1)
0.017-0.028 SHOT SIZE
0.006 A2 INTENSITY

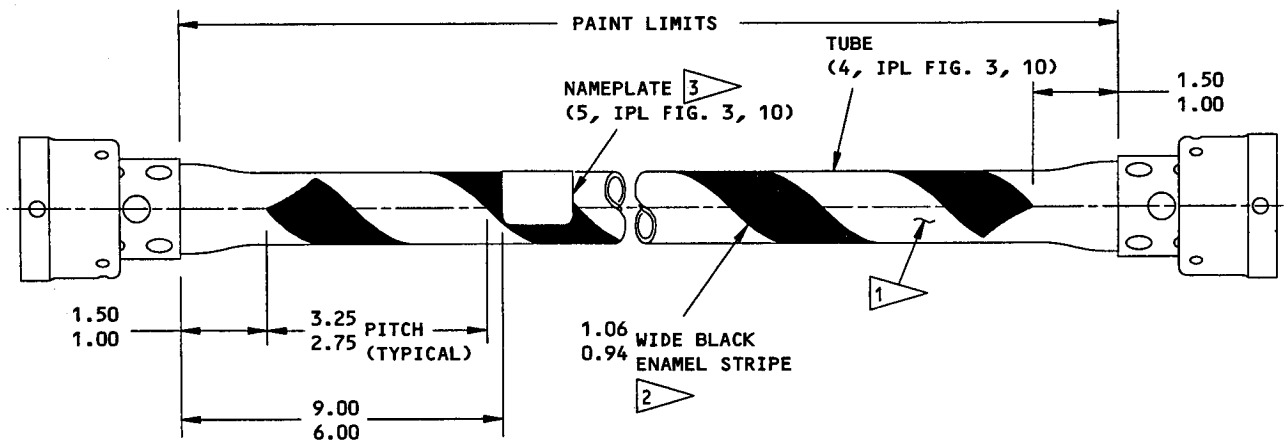
MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

65C30843-1 SHOWN
65C30843-2,-5,-6 SIMILAR
65C30844-1,-2,-5,-6,-7,-8,-9,-10 SIMILAR
65C33679-1,-2 SIMILAR
65C33680-1,-2 SIMILAR

Cam Track Refinish
Figure 1C

730082



ITEM NUMBERS REFER TO IPL
FIGURES 3 AND 10

ALL DIMENSIONS ARE IN INCHES

1> APPLY ORANGE BMS 10-11, TYPE 2 ENAMEL (F-21.28-2226) WITHIN THE PAINT LIMITS

2> APPLY BMS 10-11, TYPE 2 ENAMEL (F-21.28-701 OR -706) IN A CONTINUOUS SPIRAL PATTERN AS SHOWN

3> BOND WITH TYPE 70 OR TYPE 89 ADHESIVE (SOPM 20-50-12)

65-52925-54,-55
65-73271-21,-22,-23
65C37893-3 THRU -7

Drive Shaft Assembly
Figure 1D

W53101

C. Replacement (Fig. 1E)

(1) Tubes, shafts, couplings -- Locate rivets to match holes in couplings. For 65-52925 (except -50 thru -55), 69-40205-1, -3, -5, -7, -9, and 69-46649-1, 65-73271-1, -2, -3, -15, install rivets with wet BMS 10-11, Type 1 primer. For 65-52925-50 thru -55; 69-40205-11, -12; 69-46648-5, -7 and 69-46649-3, -5, 65-73271-4, -5, -13, -17, -21, -22, -23, 65C37893-series, install rivets with BMS 5-95 sealant (SOPM 20-50-19).

(2) Shaft ends -- Install rivets per dimensions shown.

(3) Filler plug (6, Fig. 4) -- Remove the old plug. Clean the mating faying surface of shaft (7, Fig. 4). Install a replacement plug with Type 38 adhesive (SOPM 20-50-12) on mating surfaces with the filler plug flush with end of shaft, let the adhesive cure, and drill to match shaft (7, Fig. 4).

(4) Bearings (1, Fig. 6; 1, Fig. 9) -- Apply a layer film of MIL-G-21164 grease to faying surfaces and press into place. Roller swage (SOPM 20-50-03).

(5) Rod end (2, Fig. 11) -- Locate rivets (1) to match holes in tube (6). Install rivets (1) and rod end (2) with BMS 5-95 sealant.

(6) Bushing (3, Fig. 12) -- Install by the shrink fit or press fit method (SOPM 20-50-03) with wet BMS 10-11, Type 1 primer (assemblies 65-49529 only).

(7) Bearing (6, Fig. 12) -- Install with sleeve (7) with wet BMS 10-11, Type 1 primer. Roller swage (SOPM 20-50-03) (assemblies 65-49529 only).

(8) Insert (11, Fig. 12) -- Apply BMS 10-11, Type 1 primer to insert and threaded hole. Install insert with top coil 3/4 to 1 1/2 turns below the top surface of hole. Remove tang.

(9) Bearing (6, Fig. 12) -- Install with sleeve (7) (SOPM 20-50-03) with BMS 5-95 sealant. Fillet seal shoulder with BMS 5-95 sealant (assemblies 65C30846 only).

(10) Cam follower (1, Fig. 12) -- Apply BMS 10-11, Type 1 primer (F-20.201) to all areas of hole and let dry (assemblies 65C30846 only).

(11) Bushing (3, Fig. 12) -- Install by the shrink fit or press fit method (SOPM 20-50-03) with BMS 5-95 sealant. Fillet seal shoulder with BMS 5-95 sealant (assemblies 65C30846 only).

(12) Bushing (20, Fig. 13) -- Install by the shrink fit or press fit method (SOPM 20-50-03) with wet BMS 10-11, Type 1 primer.

(13) Bushing (25, Fig. 13) -- Install by the shrink fit or press fit method (SOPM 20-50-03) (assembly 65-55552-6 only).

(14) Bearing (15) - Install with sleeve (10) with wet BMS 10-11, Type 1, primer. Roller swage (SOPM 20-50-03).

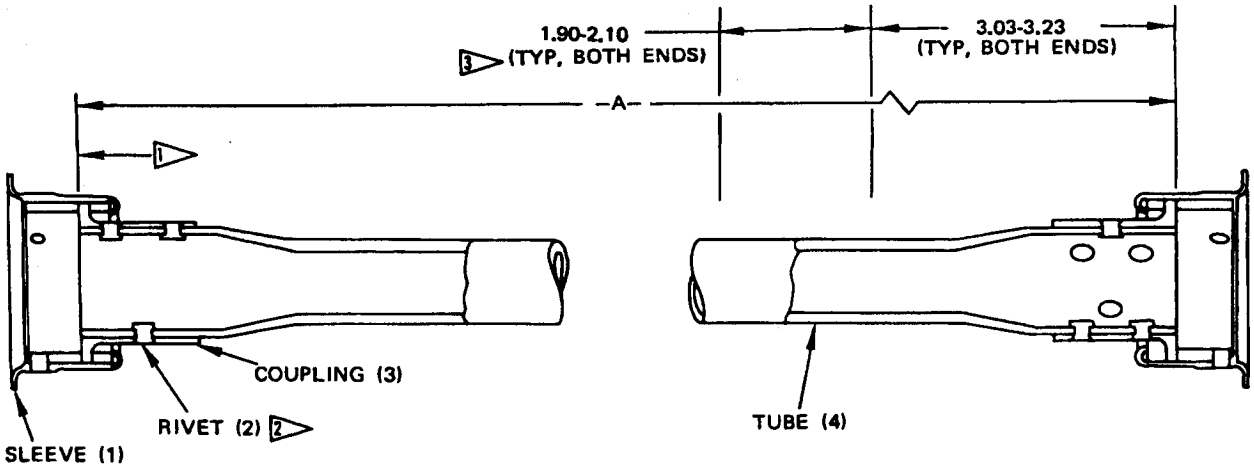
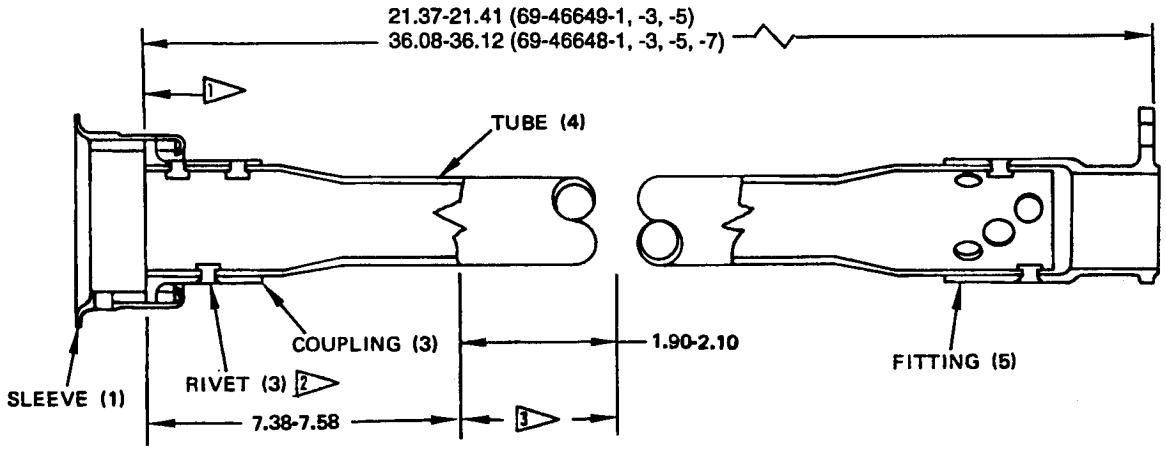


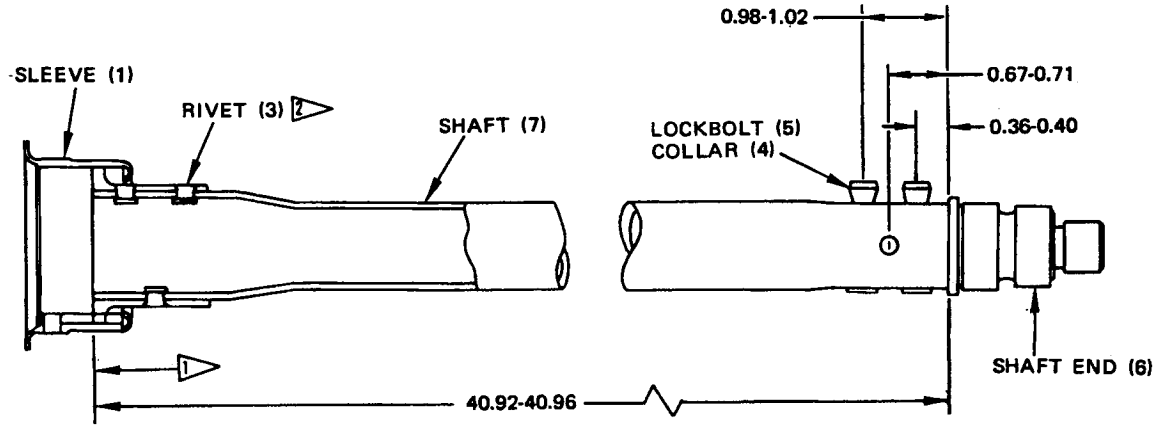
FIG.	PART NO	PART DASH NO	DIM -A-
3	65-52925	-3,-20	63.98-64.02
		-4,-21	14.62-14.66
		-5,-22,-54	52.70-52.74
		-6,-23,-55	45.55-45.59
		-13,-19	52.44-52.48
		-15	14.48-14.52
		-32	14.40-14.44
		-34	34.45-34.49
		-35,-42,-50	42.41-42.45
		-36	59.80-59-84
		-37,-43,-51	51.87-51.91
		-46,-52	42.41-42.45
		-47,-53	51.87-51.91
	65C37893	-3	52.70-52.74
		-4	45.55-45.59
5	69-40205	-1,-3,-5,-7, -9,-11,-12	53.60-53.64
10	65-73271	-1,-4,-21	52.88-52.92
		-2,-5,-22	44.48-44.52
		-3,-6,-23	45.79-45.83
		-13	14.08-14.12
		-15	63.98-64.02
		-17	63.63-63.67
	65-37893	-5	52.88-52.92
		-6	44.48-44.52
		-7	45.79-45.83

Replacement Diagram
Figure 1E (Sheet 1)

E99178

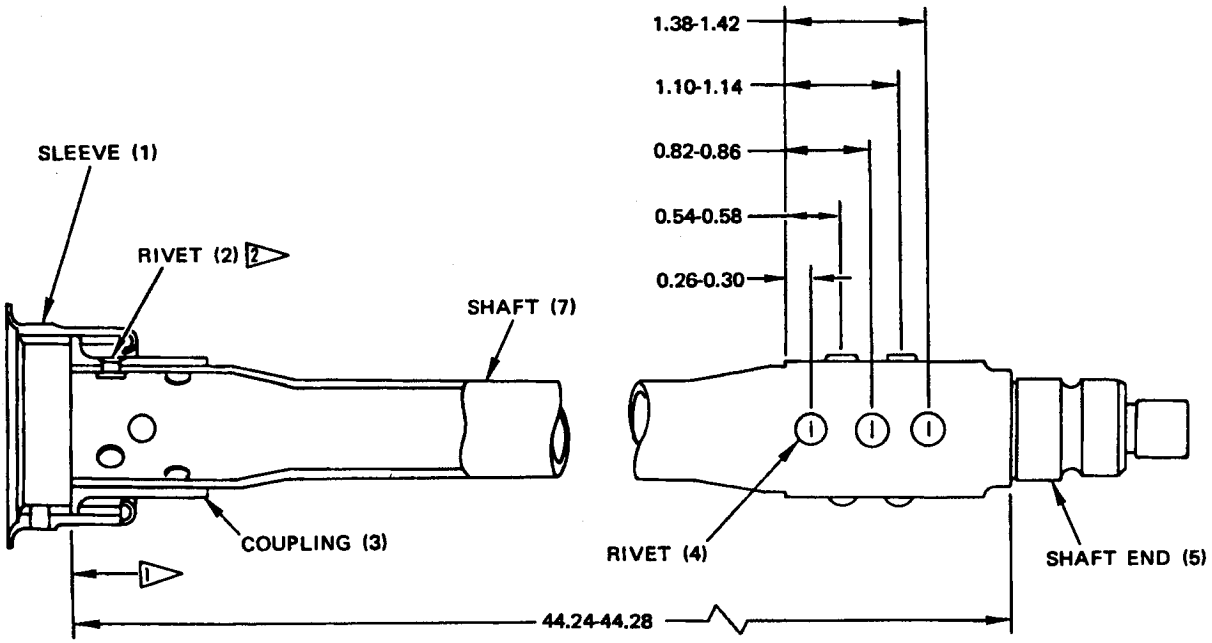


69-46648, 69-46649 (FIG. 8)



69-45163 (FIG. 7)

Replacement Diagram
Figure 1E (Sheet 2)



1 END OF TUBE MUST BE FLUSH WITH END OF COUPLING (TYPICAL ALL PARTS)

2 ALL RIVETS MUST BE FLUSH WITH SURFACE OF COUPLING WITHIN 0.015 (TYPICAL)

3 APPLY ABRASION RESISTANT FINISH (F-14.9624, WHICH REPLACES SRF-14.9624) (69-46648-6, 69-40205-8, -10)

ALL DIMENSIONS ARE IN INCHES

69-38943 (FIG. 4)

Replacement Diagram
Figure 1E (Sheet 3)

W53252

5. ASSEMBLY

A. Pushrod assembly (Fig. 11) -- Install rod end (3) by coating threads with BMS 3-24 or BMS 3-33 grease. Adjust the pushrod assembly to the length shown in Fig. 1F.

B. Bellcrank assembly (Fig. 12) --

(1) Install cam follower (1; 65-49529 assemblies without KRP123300VT5K7 cam follower) with MIL-C-11796, class 3 corrosion preventive compound on threads and shanks. Tighten nut (5) to 60-85 pound-inches.

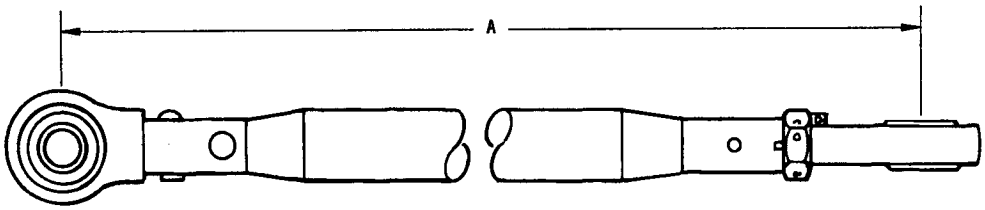
(2) Install cam follower (1; 65C30846-1 thru -4, -7 thru -18 assemblies without KRP123300VT5K7 cam follower) with BMS 3-24 or BMS 3-33 grease on all surfaces. Install washer (4) per 20-50-02; tighten nut (5) to 60-85 pound-inches.

(3) Install KRP123300VT5K7, cam follower with MIL-C-11796, class 3 corrosion preventive compound on threads and shanks. Tighten nut (5) to 60-85 pound-inches.

(4) Install clevis (8) so that centerlines of clevis attach points and bushing (6) are located as shown in Fig. 1G.

C. Bellcrank assembly (Fig. 13) --

(1) Install bushing (25) with both sides out from bellcrank (5).



PART NUMBER	DIMENSION A (INCHES)
69-39236-1,-9,-17	15.24-15.26
69-39236-2	19.24-19.26
69-39236-5,-11,-19	14.94-14.96
69-39236-6,-12,-20	18.94-18.96
69-39236-14,-18	19.59-19.61

Pushrod Assembly Length
Figure 1F

PART NUMBER	LENGTH BETWEEN CENTERLINES (INCHES)
65-49529-21,-22	4.97-6.08
65-49529-23,-24	3.87-4.80
65C30846-1,-7	6.10
65C30846-4,-10	4.20

Bellcrank Length Adjustment
Figure 1G

6. FITS AND CLEARANCES

ASSEMBLY PART NUMBER	DESIGN LIMITS (INCH)		SERVICE WEAR LIMIT (INCH)
	MIN	MAX	MAX
65-73271-1 thru -6, -21, -22, -23 65C37893-3 thru -7 69-38943-4, -6, -9 69-40205-1, -3, -5, -7, -9 69-45163-1 69-46648-1, -3, -5, -7 69-46649-1, -3, -5 69-52925-3, -5, -6, -13, -15, -19, -20, -22, -23, -54, -55	0.0000	0.0058	0.010
65-73271-13, -15, -17 65-52925-4, -21, -32, -34 thru -37, -42, -43, -46, -47, -50 thru -53	0.0000	0.0058	0.013
NOTE: Measure backlash at 1.6875-inch pitch diameter of internal spline of sleeve.			

Assembly Spline Backlashes
Figure 2

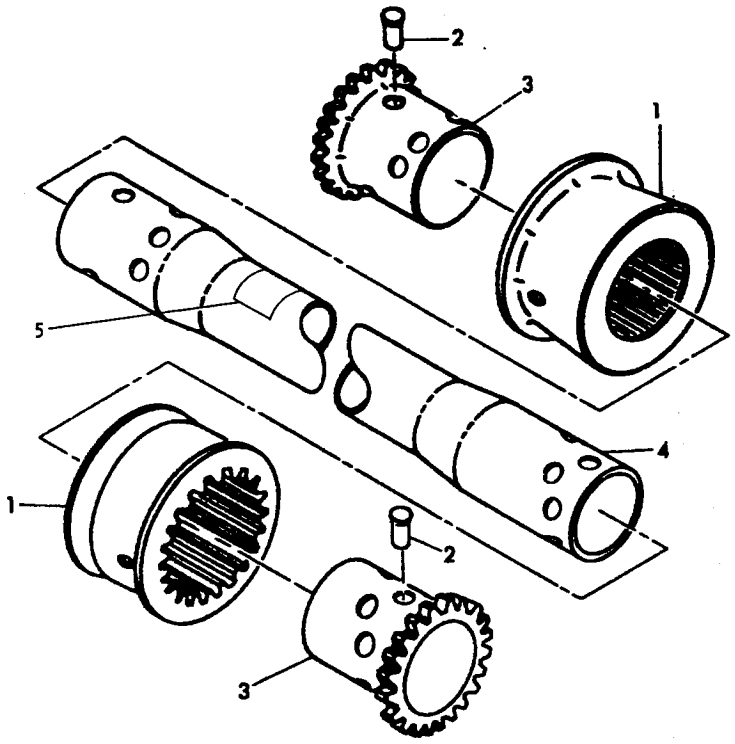
ASSEMBLY PART NUMBER	WALL THICKNESS (INCH)	
	DESIGN	MINIMUM REWORK
65-52925-3 thru -6, -15, -19, -20 thru -23, -32, -34 thru -37, -42, -43, -50, -51, -54, -55 65C37893-3 thru -7 69-45163-1 69-46648-1, -3, -5, -7 69-46649-1, -3, -5 65-73271-1 thru -6, -13, -15, -17, -21, -22, -23 69-38943-6, -9	0.083	0.075
69-40205-3, -5, -7, -11 69-38943-4 65-52925-13, -46, -47, -52, -53	0.100	0.090
69-40205-1, -9, -12	0.120	0.108

Torque Tube and Shaft Wall Thickness
Figure 2A

FOR TORQUE VALUES OF STANDARD FASTENERS, REFER TO SOPM 20-50-01			
Item No. Fig. 12	Name	Torque	
		Pound-Inches	Pound-Feet
5	Nut	60-85	

Torque Table
Figure 2B

7. ILLUSTRATED PARTS LIST



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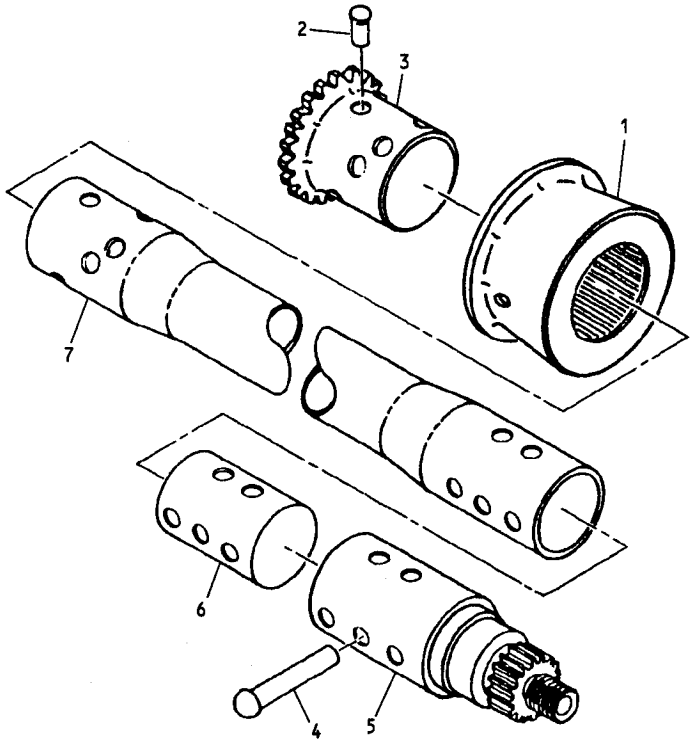
Flap Control Drive Shaft Assembly
Figure 3

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
3-					
	65-52925-3		DRIVE SHAFT ASSY, FLAP CONTROL	A	RF
	65-52925-4		DRIVE SHAFT ASSY, FLAP CONTROL	B	RF
	65-52925-5		DRIVE SHAFT ASSY, FLAP CONTROL (PRE SB 27-1200)	C	RF
	65-52925-6		DRIVE SHAFT ASSY, FLAP CONTROL (PRE SB 27-1200)	D	RF
	65-52925-13		DRIVE SHAFT ASSY, FLAP CONTROL	E	RF
	65-52925-15		DRIVE SHAFT ASSY, FLAP CONTROL	F	RF
	65-52925-19		DRIVE SHAFT ASSY, FLAP CONTROL	G	RF
	65-52925-20		DRIVE SHAFT ASSY, FLAP CONTROL	H	RF
	65-52925-21		DRIVE SHAFT ASSY, FLAP CONTROL	I	RF
	65-52925-22		DRIVE SHAFT ASSY, FLAP CONTROL (PRE SB 27-1200)	J	RF
	65-52925-23		DRIVE SHAFT ASSY, FLAP CONTROL (PRE SB 27-1200)	K	RF
	65-52925-32		DRIVE SHAFT ASSY, FLAP CONTROL	L	RF
	65-52925-34		DRIVE SHAFT ASSY, FLAP CONTROL	M	RF
	65-52925-35		DRIVE SHAFT ASSY, FLAP CONTROL	N	RF
	65-52925-36		DRIVE SHAFT ASSY, FLAP CONTROL	O	RF
	65-52925-37		DRIVE SHAFT ASSY, FLAP CONTROL	P	RF
	65-52925-42		DRIVE SHAFT ASSY, FLAP CONTROL	Q	RF
	65-52925-43		DRIVE SHAFT ASSY, FLAP CONTROL	R	RF
	65-52925-46		DRIVE SHAFT ASSY, FLAP CONTROL	S	RF
	65-52925-47		DRIVE SHAFT ASSY, FLAP CONTROL	T	RF
	65-52925-50		DRIVE SHAFT ASSY, FLAP CONTROL	U	RF
	65-52925-51		DRIVE SHAFT ASSY, FLAP CONTROL	V	RF
	65-52925-52		DRIVE SHAFT ASSY, FLAP CONTROL	W	RF
	65-52925-53		DRIVE SHAFT ASSY, FLAP CONTROL	X	RF
	65C37893-3		DRIVE SHAFT ASSY, FLAP CONTROL (POST SB 27-1200)	Y	RF
	65C37893-4		DRIVE SHAFT ASSY, FLAP CONTROL (POST SB 27-1200)	Z	RF
	65-52925-54		DRIVE SHAFT ASSY, FLAP CONTROL (POST SB 27-1200)	BA	RF
	65-52925-55		DRIVE SHAFT ASSY, FLAP CONTROL (POST SB 27-1200)	CA	RF
1	69-33513-1		. SLEEVE	A-R Y-CA	2
1	69-33513-1		. SLEEVE	ST	1
1	251N4276-1		. SLEEVE	UV	2
1	251N4276-1		. SLEEVE	WX	1
1A	69-33513-4		. SLEEVE	ST	1
1A	251N4276-2		. SLEEVE	WX	1
2	BACR15CE6D		. RIVET		18
3	6-61583		. COUPLING, SPLINED		2

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
3-					
4	65-52925-9		. TUBE	A	1
4	65-52925-10		. TUBE	B	1
4	65-52925-11		. TUBE	CY	1
4	65-52925-12		. TUBE	DZ	1
4	65-52925-14		. TUBE	E	1
4	65-52925-16		. TUBE	F	1
4	65-52925-25		. TUBE	G	1
4	65-52925-26		. TUBE	H	1
4	65-52925-27		. TUBE	I	1
4	65-52925-28		. TUBE	JY	1
4	65-52925-29		. TUBE	KZ	1
4	65-52925-33		. TUBE	L	1
4	65-52925-38		. TUBE	M	1
4	65-52925-39		. TUBE	N	1
4	65-52925-40		. TUBE	O	1
4	65-52925-41		. TUBE	P	1
4	65-52925-44		. TUBE	QU	1
4	65-52925-45		. TUBE	RV	1
4	65-52925-48		. TUBE	SW	1
4	65-52925-49		. TUBE	TX	1
4	65-52925-56		. TUBE	BA	1
4	65-52925-57		. TUBE	CA	1
5	BAC27DCT0436		. NAMEPLATE	U-X	1
5	BAC27DCT0440		. NAMEPLATE	BA CA	1



Flap Drive Torque Tube Assembly
Figure 4

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
4-					
	69-38943-4		TORQUE TUBE ASSY, FLAP DRIVE	A	RF
	69-38943-6		TORQUE TUBE ASSY, FLAP DRIVE	B	RF
	69-38943-9		TORQUE TUBE ASSY, FLAP DRIVE	C	RF
1	69-33513-1		. SLEEVE		1
2	BACR15CE6D		. RIVET		9
3	6-61583		. COUPLING		1
4	MS20470D6		. RIVET		5
5	69-38941-1		. SHAFT END		1
6	69-38943-3		. PLUG, FILLER	A	1
6	69-38943-3		. PLUG, FILLER (REPLD BY 69-38943-8)	B	1
6	69-38943-8		. PLUG, FILLER (REPLS 69-38943-3)	B	1
6	69-38943-8		. PLUG, FILLER	C	1
7	69-38943-5		. SHAFT	A	1
7	69-38943-7		. SHAFT	B	1
7	69-38943-10		. SHAFT	C	1

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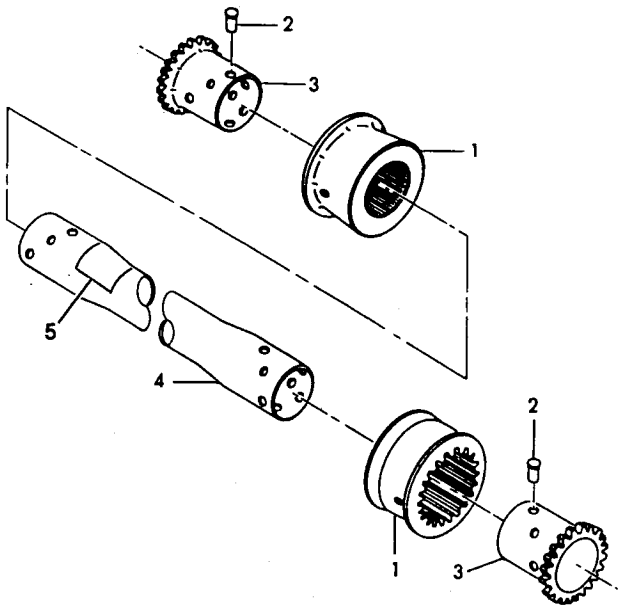
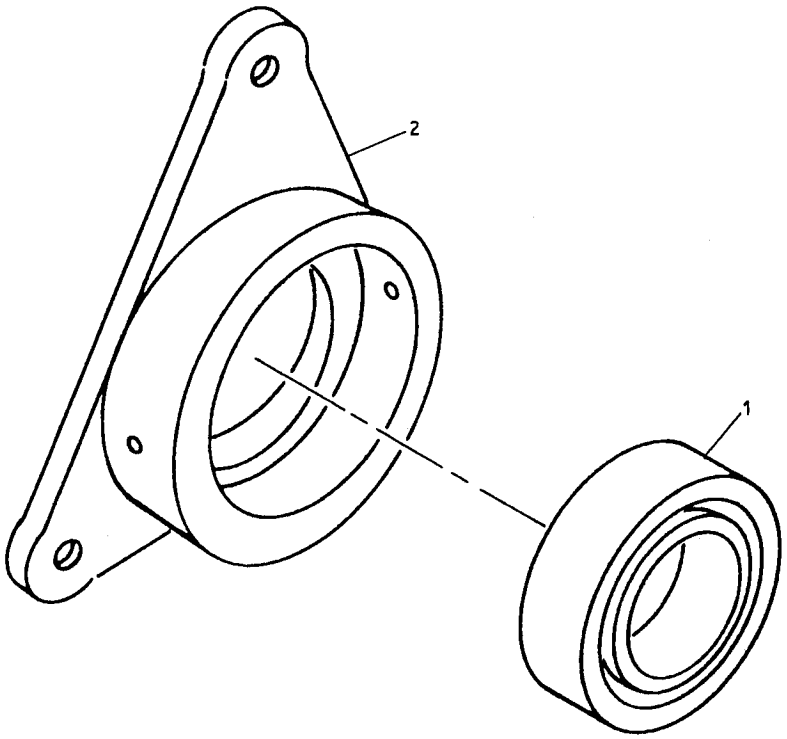


Flap Control Drive Shaft Assembly
Figure 5

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
5-					
	69-40205-1		DRIVE SHAFT ASSY, FLAP CONTROL	A	RF
	69-40205-3		DRIVE SHAFT ASSY, FLAP CONTROL	B	RF
	69-40205-5		DRIVE SHAFT ASSY, FLAP CONTROL	C	RF
	69-40205-7		DRIVE SHAFT ASSY, FLAP CONTROL	D	RF
	69-40205-9		DRIVE SHAFT ASSY, FLAP CONTROL	E	RF
	69-40205-11		DRIVE SHAFT ASSY, FLAP CONTROL	F	RF
	69-40205-12		DRIVE SHAFT ASSY, FLAP CONTROL	G	RF
1	69-33513-1		. SLEEVE	A-D	2
1	69-33513-4		. SLEEVE	E	2
1	251N4276-1		. SLEEVE	F	2
1	251N4276-2		. SLEEVE	G	2
2	BACR15BA6DD		DELETED		
2	BACR15CE6D		. RIVET		18
3	6-61583		. COUPLING		2
4	69-40205-2		. TUBE	A	1
4	69-40205-4		. TUBE	B	1
4	69-40205-6		. TUBE	C	1
4	69-40205-8		. TUBE	DF	1
4	69-40205-10		. TUBE	EG	1
5	BAC27DCT0437		. NAMEPLATE	FG	1



Flap Drive Torque Tube Bearing Support Assembly
Figure 6

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
6-					
	69-44671-1		SUPPORT ASSY, FLAP DRIVE TORQUE TUBE BEARING	A	RF
	69-44671-2		SUPPORT ASSY, FLAP DRIVE TORQUE TUBE BEARING	B	RF
1	BACB10C150H		. BEARING		1
2	69-44671-3		. SUPPORT	A	1
2	69-44671-4		. SUPPORT	B	1

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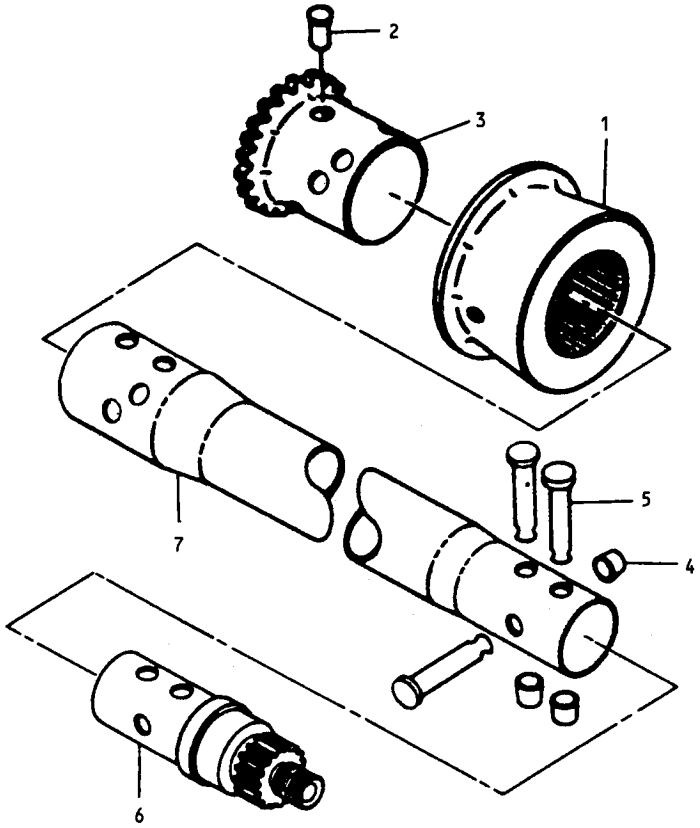
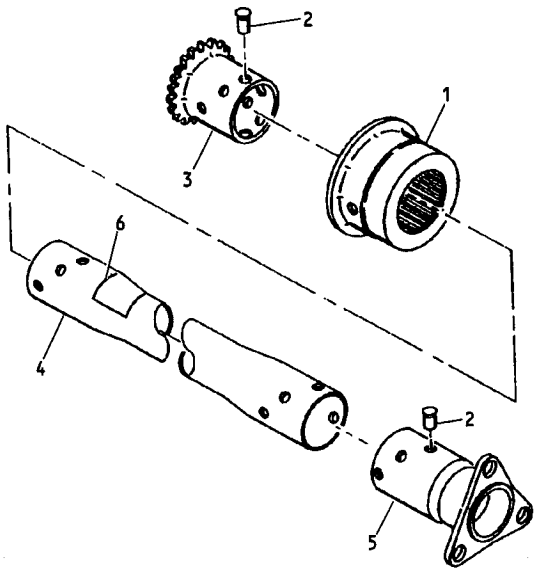


Flap Drive Torque Tube Assembly
Figure 7

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
7-	69-45163-1		TORQUE TUBE ASSY, FLAP DRIVE		RF
1	69-33513-1		. SLEEVE		1
2	BACR15CE6D		. RIVET		9
3	6-61583		. COUPLING		1
4	NAS1080-6		. COLLAR		3
5	BACB30DX6-16		. LOCKBOLT		3
6	69-44487-1		. SHAFT END		1
7	69-45163-2		. SHAFT		1

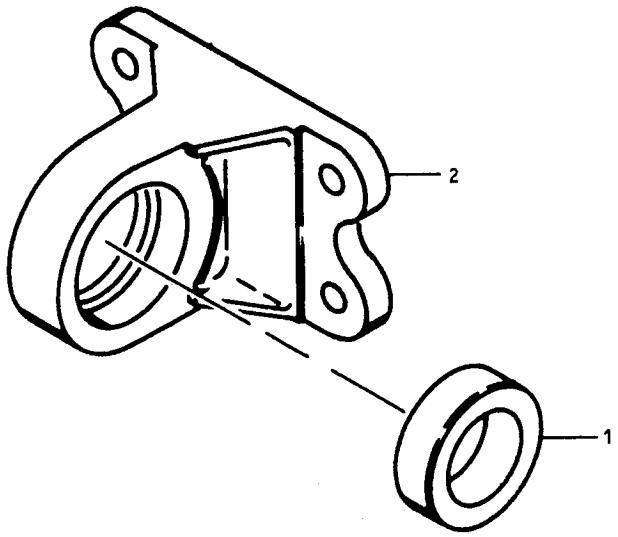
FLAP DRIVE
COMPONENTS
(SEE PAGE 1)



Flap Drive Torque Tube Assembly
Figure 8

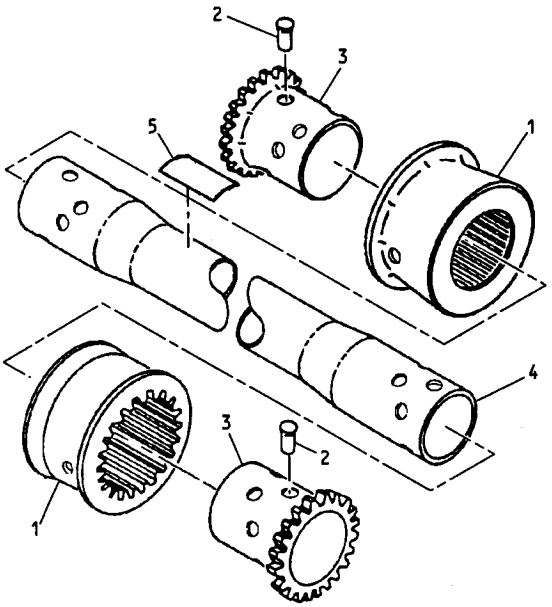
FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
8-					
	69-46648-1		TORQUE TUBE ASSY, FLAP DRIVE	A	RF
	69-46648-3		TORQUE TUBE ASSY, FLAP DRIVE	B	RF
	69-46648-5		TORQUE TUBE ASSY, FLAP DRIVE	C	RF
	69-46648-7		TORQUE TUBE ASSY, FLAP DRIVE	D	RF
	69-46649-1		TORQUE TUBE ASSY, FLAP DRIVE	E	RF
	69-46649-3		TORQUE TUBE ASSY, FLAP DRIVE	F	RF
	69-46649-5		TORQUE TUBE ASSY, FLAP DRIVE	G	RF
1	69-33513-1		. SLEEVE	ABE	1
1	69-33513-1		. SLEEVE (OPT)	CF	1
1	251N4276-1		. SLEEVE	C-G	1
2	BACR15CE6D		. RIVET		18
3	6-61583		. COUPLING		1
4	69-46648-2		. TUBE	A	1
4	69-46648-4		. TUBE	B	1
4	69-46648-6		. TUBE	CD	1
4	69-46649-2		. TUBE	E	1
4	69-46649-4		. TUBE	FG	1
5	65-59334-1		. FITTING	A-D	1
5	65-59334-2		. FITTING	EFG	1
6	BAC27DCT0434		. NAMEPLATE	CD	1
6	BAC27DCT0435		. NAMEPLATE	FG	1

W58211



Flap Drive Torque Tube Bearing Support Assembly
Figure 9

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
9-	65-51280-3		SUPPORT ASSY, FLAP DRIVE TORQUE TUBE BEARING		RF
1	DT16A		. BEARING, V77896		1
2	65-51280-4		. SUPPORT		1



Flap Control Drive Shaft Assembly
Figure 10

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
10-					
	65-73271-1		DRIVE SHAFT ASSY, FLAP CONTROL (PRE SB 27-1200)	A	RF
	65-73271-2		DRIVE SHAFT ASSY, FLAP CONTROL (PRE SB 27-1200)	B	RF
	65-73271-3		DRIVE SHAFT ASSY, FLAP CONTROL (PRE SB 27-1200)	C	RF
	65-73271-4		DRIVE SHAFT ASSY, FLAP CONTROL (PRE SB 27-1200)	D	RF
	65-73271-5		DRIVE SHAFT ASSY, FLAP CONTROL (PRE SB 27-1200)	E	RF
	65-73271-6		DRIVE SHAFT ASSY, FLAP CONTROL (PRE SB 27-1200)	F	RF
	65-73271-13		DRIVE SHAFT ASSY, FLAP CONTROL (SB 27-1028)	G	RF
	65-73271-15		DRIVE SHAFT ASSY, FLAP CONTROL (SB 57-1073)	H	RF
	65-73271-17		DRIVE SHAFT ASSY, FLAP CONTROL	I	RF

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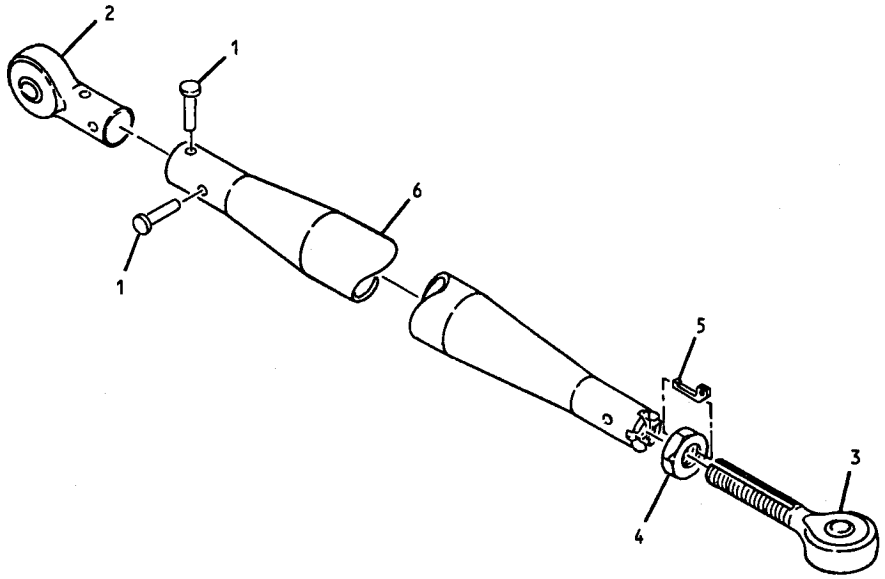
FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
10-					
	65C37893-5		DRIVE SHAFT ASSY, FLAP CONTROL (POST SB 27-1200)	J	RF
	65C37893-6		DRIVE SHAFT ASSY, FLAP CONTROL (POST SB 27-1200)	K	RF
	65C37893-7		DRIVE SHAFT ASSY, FLAP CONTROL (POST SB 27-1200)	L	RF
	65-73271-21		DRIVE SHAFT ASSY, FLAP CONTROL (POST SB 27-1200)	M	RF
	65-73271-22		DRIVE SHAFT ASSY, FLAP CONTROL (POST SB 27-1200)	N	RF
	65-73271-23		DRIVE SHAFT ASSY, FLAP CONTROL (POST SB 27-1200)	O	RF
1	69-57942-1		. SLEEVE		2
2	BACR15CE6D		. RIVET		18
3	6-61583		. COUPLING, SPLINED		2
4	65-73271-7		. TUBE	AJ	1
4	65-73271-8		. TUBE	BK	1
4	65-73271-9		. TUBE	CL	1
4	65-73271-10		. TUBE	D	1
4	65-73271-11		. TUBE	E	1
4	65-73271-12		. TUBE	FL	1
4	65-73271-14		. TUBE	G	1
4	65-73271-16		. TUBE	H	1
4	65-73271-18		. TUBE	I	1
4	65-73271-19		. TUBE	M	1
4	65-73271-20		. TUBE	N	1
4	65-73271-24		. TUBE	O	1
5	BAC27DCT0440		. NAMEPLATE	DEGI-O	1



Outboard Aft Flap Drive Mechanism Pushrod Assembly
Figure 11

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
11-					
	69-39236-1		PUSHROD ASSY, OUTBD AFT FLAP DRIVE MECH.	A	RF
	69-39236-2		PUSHROD ASSY, OUTBD AFT FLAP DRIVE MECH.	B	RF
	69-39236-5		PUSHROD ASSY, OUTBD AFT FLAP DRIVE MECH.	C	RF
	69-39236-6		PUSHROD ASSY, OUTBD AFT FLAP DRIVE MECH.	D	RF
	69-39236-9		PUSHROD ASSY, OUTBD AFT FLAP DRIVE MECH.	E	RF
	69-39236-11		PUSHROD ASSY, OUTBD AFT FLAP DRIVE MECH.	F	RF
	69-39236-12		PUSHROD ASSY, OUTBD AFT FLAP DRIVE MECH.	G	RF

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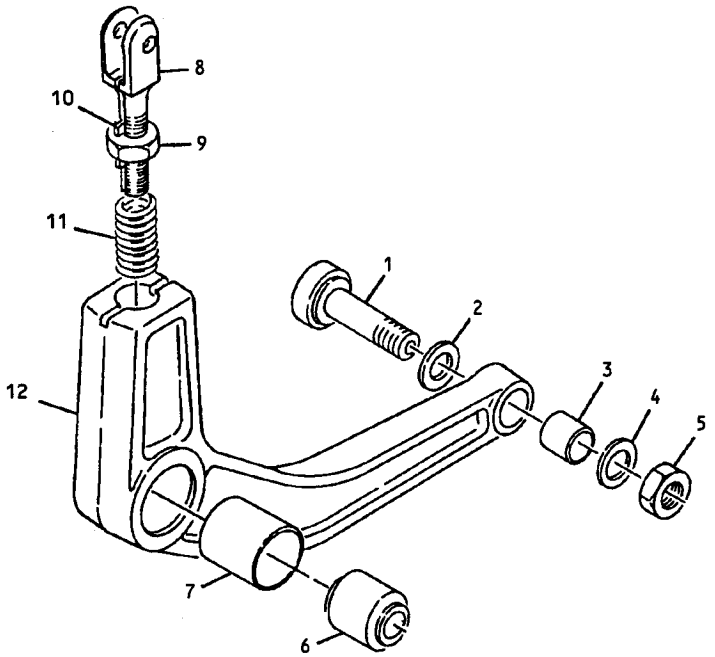
FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
11-					
	69-39236-14		PUSHROD ASSY, OUTBD AFT FLAP DRIVE MECH.	H	RF
	69-39236-17		PUSHROD ASSY, OUTBD AFT FLAP DRIVE MECH.	I	RF
	69-39236-18		PUSHROD ASSY, OUTBD AFT FLAP DRIVE MECH.	J	RF
	69-39236-19		PUSHROD ASSY, OUTBD AFT FLAP DRIVE MECH.	K	RF
	69-39236-20		PUSHROD ASSY, OUTBD AFT FLAP DRIVE MECH.	L	RF
1	MS20470D5		. RIVET		2
2	1201-2		. ROD END, V34742		1
2	10-60779-3		. ROD END (OPT)		1
3	10-60779-177		. ROD END		1
4	NAS1423-4		. NUT (SUPSDS NAS509-4)		1
4	NAS509-4		. NUT (SUPSD BY NAS1423-4)		1
5	NAS559-1		. KEY	A-H	1
5	NAS513-4		. KEY	I-L	1
6	69-39236-3		. TUBE	AEI	1
6	69-39236-4		. TUBE	B	1
6	69-39236-7		. TUBE	CFK	1
6	69-39236-8		. TUBE	DGL	1
6	69-39236-16		. TUBE	HJ	1

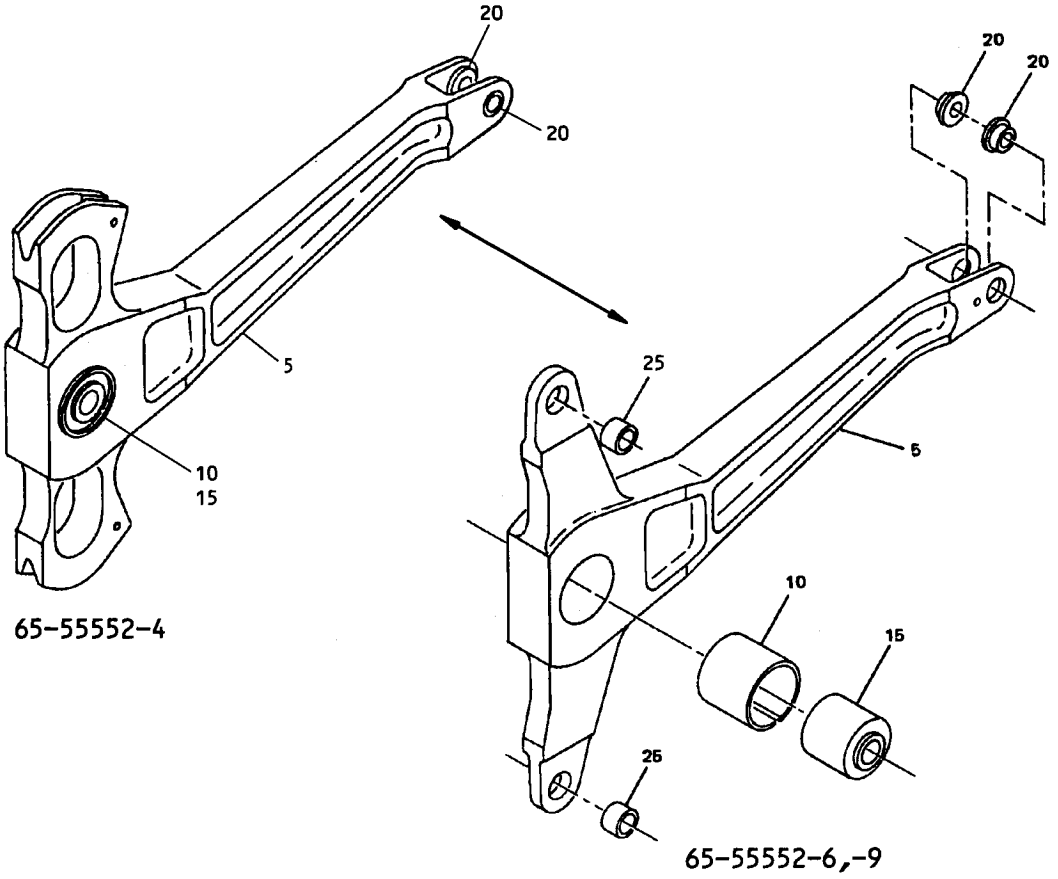


Flap Drive Mechanism Bellcrank Assembly
Figure 12

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
12-					
	65-49529-11		BELLCRANK ASSY, FLAP DRIVE MECH.	A	RF
	65-49529-12		BELLCRANK ASSY, FLAP DRIVE MECH.	B	RF
	65-49529-15		BELLCRANK ASSY, FLAP DRIVE MECH.	C	RF
	65-49529-16		BELLCRANK ASSY, FLAP DRIVE MECH.	D	RF
	65-49529-17		BELLCRANK ASSY, FLAP DRIVE MECH.	E	RF
	65-49529-18		BELLCRANK ASSY, FLAP DRIVE MECH.	F	RF
	65-49529-19		BELLCRANK ASSY, FLAP DRIVE MECH.	G	RF
	65-49529-20		BELLCRANK ASSY, FLAP DRIVE MECH.	H	RF
	65-49529-21		BELLCRANK ASSY, FLAP DRIVE MECH.	I	RF
	65-49529-22		BELLCRANK ASSY, FLAP DRIVE MECH.	J	RF
	65-49529-23		BELLCRANK ASSY, FLAP DRIVE MECH.	K	RF
	65-49529-24		BELLCRANK ASSY, FLAP DRIVE MECH.	L	RF
	65C30846-1		BELLCRANK ASSY, FLAP DRIVE MECH.	M	RF
	65C30846-2		BELLCRANK ASSY, FLAP DRIVE MECH.	N	RF
	65C30846-3		BELLCRANK ASSY, FLAP DRIVE MECH.	O	RF
	65C30846-4		BELLCRANK ASSY, FLAP DRIVE MECH.	P	RF
	65C30846-7		BELLCRANK ASSY, FLAP DRIVE MECH.	Q	RF
	65C30846-8		BELLCRANK ASSY, FLAP DRIVE MECH.	R	RF
	65C30846-9		BELLCRANK ASSY, FLAP DRIVE MECH.	S	RF

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
12-					
	65C30846-10		BELLCRANK ASSY, FLAP DRIVE MECH.	T	RF
	65C30846-11		BELLCRANK ASSY, FLAP DRIVE MECH.	U	RF
	65C30846-12		BELLCRANK ASSY, FLAP DRIVE MECH.	V	RF
	65C30846-13		BELLCRANK ASSY, FLAP DRIVE MECH.	W	RF
	65C30846-14		BELLCRANK ASSY, FLAP DRIVE MECH.	X	RF
	65C30846-15		BELLCRANK ASSY, FLAP DRIVE MECH. (PRE SB 57-1227)	Y	RF
	65C30846-16		BELLCRANK ASSY, FLAP DRIVE MECH. (PRE SB 57-1227)	Z	RF
	65C30846-17		BELLCRANK ASSY, FLAP DRIVE MECH. (PRE SB 57-1227)	BA	RF
	65C30846-18		BELLCRANK ASSY, FLAP DRIVE MECH. (PRE SB 57-1227)	CA	RF
	65C30846-21		BELLCRANK ASSY, FLAP DRIVE MECH. (POST SB 57-1227)	DA	RF
	65C30846-22		BELLCRANK ASSY, FLAP DRIVE MECH. (POST SB 57-1227)	EA	RF
	65C30846-23		BELLCRANK ASSY, FLAP DRIVE MECH. (POST SB 57-1227)	FA	RF
	65C30846-24		BELLCRANK ASSY, FLAP DRIVE MECH. (POST SB 57-1227)	GA	RF
1	BACB10AF5K7H		. CAM FOLLOWER (PREF) (PRE SB 57-1227)	A-L	1
1	BACB10BH59TK6		. CAM FOLLOWER (OPT)(PRE SB 57-1227)	A-L	1
1	BACB10BH59TK7		. CAM FOLLOWER (OPT)(PRE SB 57-1227)	A-L	1
1	BACB10BH59T7		. CAM FOLLOWER (OPT)(PRE SB 57-1227)	A-L	1
1	BACB10AF5K7H		. CAM FOLLOWER (PRE SB 57-1227)	M-Y	1
1	BACB10FK5K8H		DELETED		
1	KRP123300VT5K7		. CAM FOLLOWER, V50632 (POST SB 57-1227)	A-X	1
1	BACB10AF5K7H		. CAM FOLLOWER	Y-CA	1
1	KRP123300VT5K7		. CAM FOLLOWER, V50632 (OPT)	DA-GA	1
1	KRP123300NT5K 7MOD		. CAM FOLLOWER, V50632 (OPT)	DA-GA	1
1	KRP190505VTZ		. CAM FOLLOWER, V50632	DA-GA	1
2	AN960-516L		. WASHER	A-L	1
2	AN960C516L		. WASHER	M-GA	1
3	BACB28Y5B37		. BUSHING	A-L	1
3	BACB28X5M041		. BUSHING	M-GA	1
4	NAS460-516		. WASHER (USED WITH BACB10AF5K7H, BACB10BH59TK6, BACB10BH59TK7)	A-L	1
4	AN960-516L		. WASHER (USED WITH BACB10BH59T7)	A-L	1
4	MS27111-2		. WASHER	M-GA	1
5	AN316-5R		. WASHER (USED WITH BACB10AF5K7H, BACB10BH59TK6, BACB10BH59TK7)	A-L	1
5	MS35691-15		. NUT	M-GA	1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
12-					
5	NAS679A5		. NUT (USED WITH BACB10BH59T7)	A-L	1
6	BACB10A660		. BEARING (PRE SB 57-1227)	A-Y	1
6	MS27647-5L		DELETED		
6	KRP148505V		. BEARING, V50632 (POST SB 57-1227)	A-Y	1
6	BACB10A660		. BEARING	Y-CA	1
6	KRP148505V		. BEARING, V50632 (OPT)	DA-GA	1
6	KRP190305VTZ		. BEARING, V50632	DA-GA	1
7	65-49529-5		. SLEEVE	A-L	1
7	65C30846-5		. SLEEVE - SPLIT	M-X	1
7	65C30846-19		. SLEEVE - SPLIT	Y-GA	1
8	69-37836-1		. CLEVIS (REPLD BY 69-37836-2)	A-T	1
8	69-37836-2		. CLEVIS (REPLS 69-37836-1)	A-T	1
8	69-37836-2		. CLEVIS	U-GA	1
9	NAS509-7		. NUT		1
10	NAS559-3		. KEY-LOCK		1
11	MS21209F7-20		. INSERT		1
12	65-55508-5		. BELLCRANK	A	1
12	65-55508-4		. BELLCRANK	B	1
12	65-55508-9		. BELLCRANK	C	1
12	65-55508-8		. BELLCRANK	D	1
12	65-55508-11		. BELLCRANK	EK	1
12	65-55508-17		. BELLCRANK (OPT)	K	1
12	65-55508-12		. BELLCRANK	FL	1
12	65-55508-18		. BELLCRANK (OPT)	L	1
12	65-55508-13		. BELLCRANK	GI	1
12	65-55508-15		. BELLCRANK (OPT)	I	1
12	65-55508-14		. BELLCRANK	HJ	1
12	65-55508-16		. BELLCRANK (OPT)	J	1
12	65C30900-1		. BELLCRANK	M	1
12	65C30900-2		. BELLCRANK	N	1
12	65C30900-3		. BELLCRANK	O	1
12	65C30900-4		. BELLCRANK	P	1
12	65C30900-7		. BELLCRANK	Q	1
12	65C30900-8		. BELLCRANK	R	1
12	65C30900-9		. BELLCRANK	S	1
12	65C30900-10		. BELLCRANK	T	1
12	65C30900-11		. BELLCRANK	UY DA	1
12	65C30900-15		. BELLCRANK (OPT)	UY DA	1
12	65C30900-12		. BELLCRANK	VZ EA	1
12	65C30900-16		. BELLCRANK (OPT)	VZ EA	1
12	65C30900-13		. BELLCRANK	W BA FA	1
12	65C30900-17		. BELLCRANK (OPT)	W BA FA	1
12	65C30900-14		. BELLCRANK	Z CA GA	1
12	65C30900-18		. BELLCRANK (OPT)	Z CA GA	1



Flap Drive Mechanism Bellcrank Assembly
Figure 13

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
13-					
-1	65-55552-4		BELLCRANK ASSY, FLAP DRIVE MECH	A	RF
-1	65-55552-6		BELLCRANK ASSY, FLAP DRIVE MECH	B	RF
-1	65-55552-9		BELLCRANK ASSY, FLAP DRIVE MECH	C	RF
5	65-55552-5		. BELLCRANK	A	1
5	65-55552-7		. BELLCRANK	BC	1
10	65-55552-3		. SLEEVE - SPLIT		1
15	BACB10A660		. BEARING	AB	1
15	KRP148505V		. BEARING (OPT)	C	1
15	KRP190305VTZ		. BEARING	C	1
20	BACB28W4B009		. BUSHING		2
25	BACB28U5B018		. BUSHING	BC	2

W55743

VENDORS

V34742	WESTERN SKY INDUSTRIES DBA TYEE AIRCRAFT, 3008 100TH ST. S.W., EVERETT, WASHINGTON 98204-1907
V50632	KAMATICS CORP., 1330 BLUE HILLS DR., BLOOMFIELD, CONNECTICUT 06002-1303
V77896	REXNORD INDUSTRIES, INC., BEARING OPERATION DIV., 2400 CURTISS ST., DOWNERS GROVE, ILLINOIS 60515-0722