TO: ALL HOLDERS OF ELEVATOR ASSY AND TAB ASSY OVERHAUL MANUAL, 55-20-10

REVISION NO. 12, DATED JUL 1/04

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 SB 55A1070 thru Rev. 1, which installs different nuts and cotter pins if the original parts are removed during free-play checks												X	
Added clarifications and updated callouts			X									X	

ELEVATOR ASSEMBLY AND TAB ASSEMBLY

55-20-10

BOEING P/N 65-73784-1, -2, -5 thru -24, -27 thru -44
65-73799-3, -4, -13, -14, -45, -46, -501, -502, -509, -510

AIRLINE P/N

THE FOLLOWING DIRECTIVES APPLY TO THIS SUBJECT:

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVES	DATE DIRECTIVE INCORPORATED INTO TEXT
		PRR 30459	Feb 15/69
		PRR 30494	Feb 15/69
		PRR 30680	Feb 15/69
		PRR 30913	Feb 15/69
55-1009, Rev 1		PRR 30485-1	Mar 10/71
		PRR 31624	Mar 10/71
55-1009		PRR 31967	Mar 10/71
27-1045			Sep 10/71
55-1009, Rev 2			Sep 10/71
27-1052, Rev 2		PRR 32043	Jun 10/72
		PRR 32113	Jun 10/72
55-1017		PRR 31558	Dec 25/72
		PRR 32121-27	Dec 25/72
27-1056, Rev 1		PRR 32099	Mar 25/73
23-1009		PRR 32121-3	Mar 25/73
27-1057			Sep 25/73
		MC 3430	Dec 25/75
		PRR 33191	Dec 5/83
55A1020, Rev 4			Dec 5/90
55A1070, Rev 1			Jul 1/04

LIST OF EFFECTIVE PAGES

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

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	55-20-10			1105	BLANK			
*	T-1	Jul 1/04		1106	Jul 5/81			
	T-2	BLANK		1107	Jul 5/81			
*	LEP-1	Jul 1/04		1108	Jul 5/81			
	LEP-2	BLANK		1108A	Jul 5/81			
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	T/C-2	BLANK		1108C	Jul 5/81			
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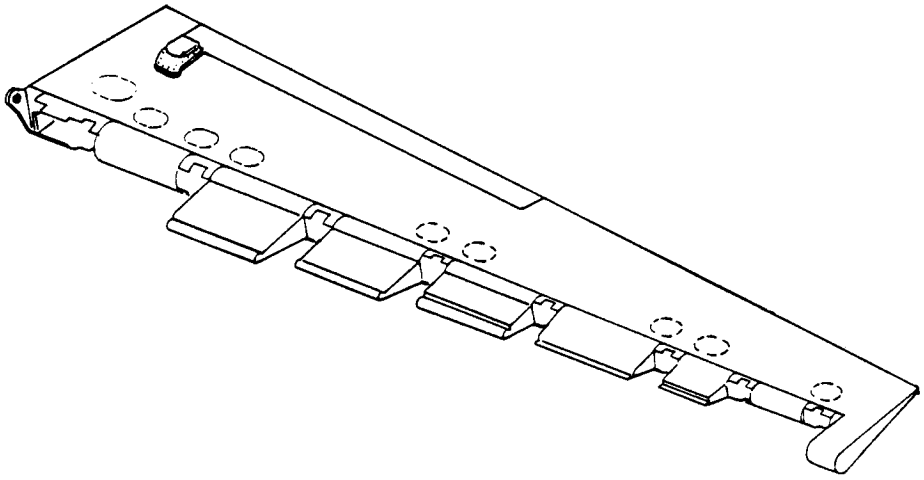
ELEVATOR ASSEMBLY



Elevator Assembly
Figure 1

DESCRIPTION AND OPERATION

1. Description

   A. The elevator is basically an aluminum frame structure, made up of front and rear spars, joined by chordwise ribs. This framework is covered with fiberglass reinforced plastic honeycomb skin panels. Internal areas of the structure are accessible through access doors, placed on the lower side of the assembly. The elevator is attached to the rear spar of the horizontal stabilizer with five hinge fitting assemblies made up of cast aluminum alloy fittings and steel roller bearings.

   B. The assembled elevator, without the tab in place, is balanced about the hinge centerline. Balance weights are installed on panels which extend forward from the front spar.

2. Operation

   A. The elevator is operated hydraulically to control pitch of the airplane.

DISASSEMBLY

1. Place elevator assembly in a suitable holding fixture, and disassemble as follows:

   A. Removal of Tip (See figure 1102.)

      (1) Remove bolts (2). Remove balance weight fairing (1).

      (2) Remove bolts (4, 5, and 6). Remove fairing assembly (3).

      (3) Remove bolts (8 and 10) and washers (9). Remove fairing assembly (7).

      (4) Remove static dischargers (13 and 14), if installed, by releasing setscrew securing discharger to retainer.

      NOTE: Do not remove discharger retainers (7C, 7D, 7F and 7K) and balance weight (11) unless repair or replacement is necessary.

   B. Removal of Access Doors, Fairings, and Seals (See figure 1103.)

      (1) Remove bolts (5). Remove door assembly (1).

      (2) Remove bolts (10). Remove door assemblies (6).

      (3) Remove bolts (19). Remove covers (11 through 18).

      (4) Remove bolts (21 and 22). Remove fairing (20). If fairing, P/N 65-53716-3 is used, remove bolts (29) and fairing (28) also.

      (5) Remove bolts (24 and 25). Remove fairing (23). If fairing, P/N 65-53716-4 is used, remove bolts (27) and fairing (26) also.

      (6) Remove bolts (37 thru 42). Remove angles (30, 31, 33, and 34) and seals (32 and 35). Remove radius fillers (36) if used.

   C. Removal and Disassembly of Tab (See figure 1104.)

      (1) Remove nuts (1), bolts (2), and washers (3 and 4) to detach bonding jumpers (5) from tab.

      (2) Remove cotter pins (6), nuts (7), bolts (8), and washers (8A and 9). Remove elevator control tab assembly (10) from elevator.

      (3) Remove bolts (15) and washers (15A). Remove hinge fitting assemblies (11), shims (16), and doublers (17). Measure and record thickness of shims for fabrication of new shims if replacement is necessary.

(4) Remove nuts (22), washers (23 and 25A), bolts (24, 25, and 26), and inserts (23A). Remove mast fitting assembly (18) and shims (27). Measure and record thickness of shims for fabrication of new shims if replacement is necessary.

(5) Remove bolts (33) and washers (34). Remove hinge bracket assemblies (30) and bonding jumpers (5) from rear spar of elevator.

NOTE: Do not remove fairing (28) unless replacement is necessary.

D. Removal of Attach Fittings (See figure 1105.)

(1) Remove bolts (5) and washers (6). Remove hinge fitting assemblies (1) and shims (7). Measure and record thickness of shims for fabrication of new shims if replacement is necessary.

(2) Remove bolts (15) and washers (16). Remove thrust hinge fitting assembly (8).

(3) Disassemble thrust hinge fitting assembly (8) made up of cap (9), base (10), bearing (11), nut (12), bolt (13), and washer (14).

NOTE: Cap (9) and base (10) form a matched set. Tag parts and keep together.

(4) Remove bolts (22 and 23) and washers (24). Remove control rod attachment bracket assembly (17) and shim (25). Measure and record thickness of shim for fabrication of new shim if replacement is necessary.

(5) Remove bolts (39) and washers (40). Remove hinge fitting assembly (35) and shim (41). Measure and record thickness of shim for fabrication of new shim if replacement is necessary.

NOTE: Control rod attachment bracket assembly (26) and control rod mast fitting assembly (42) are permanently fastened. They are shown for reference only and should not be removed except for replacement. Do not remove decals (46A) from fitting unless repair or replacement makes it necessary.

CLEANING

1. Clean all parts but bearings and exterior skin panels by standard industry practices and the instructions in SOPM 20-30-03.

2. Clean all bearings by the instructions in SOPM 20-30-01.

3. Clean exterior skin panels as follows:

   NOTE: Exterior skin panels are fiberglass reinforced plastic.

   A. Remove greases and other contaminants with clean cheesecloth soaked with a Series 87 solvent (SOPM 20-30-87). Wipe the surface dry with a clean cheesecloth.

   CAUTION: DO NOT SAND INTO THE GLASS FIBER REINFORCEMENT.

   B. Hand sand away remaining coatings and surface roughness with 240 grit or finer abrasive paper. Remove sanding dust per step 3.A.

INSPECTION/CHECK

1. Visual Checks

A. Examine all metal parts for pits, scratches, cracks, corrosion, and damage, using strong light and minimum of 10-power magnification.

B. Examine entire basic assembly for loose fasteners, and all painted and plated surfaces for blisters and flaking.

C. Examine all bearing, bushing and bolt holes for corrosion and excessive or eccentric wear.

D. Examine all bearings for excessive radial or axial play.

E. Check honeycomb parts for evidence of delamination, internal moisture, scratches, and contour defects.

(1) Tap surface of honeycomb panel or bonded structure lightly with a coin or plastic rod. Go over entire surface. Normal structure will produce a solid, metallic sound; delaminated areas will produce a dull, hollow sound; and areas containing moisture will produce a dull, solid sound.

(2) Examine areas suspected of containing moisture radiographically to determine extent of damage.

(3) Determine contour defects by laying a straightedge across surface of panel. Raised areas indicate delamination. Warp of panel can also be determined with the straightedge.

(4) Examine edges of panels carefully for cuts and abrasions. Delamination starts very easily from damage to an edge member of a honeycomb panel.

F. Examine bonding jumpers for frayed cables and cracked or broken terminals.

G. Check decoupled static dischargers (18, figure 1101, and 13 and 14, figure 1102).

NOTE: The parts identified in this procedure are installation items and may not be with the assembly during overhaul.

(1) Check that dischargers are intact and secure on retainers.

(2) Check dischargers for lightning damage as evidenced by burning and roughening of black conductive coating on blade, and pitting of retainers (14, 19, 24, 29 or 33).

(3) Check for broken, bent or blunted tungsten pins.

(4) Check for excessive erosion of discharger coating or peeling of tip cap. Leading edge erosion should not extend back more than one-third the width of discharger.

(5) Check that electrical resistance between discharger pin and airplane structure is between 5 and 100 megohms.

2. Special Checks

A. If visual examination discloses evidence of defects in any of the parts listed, perform the following checks:

(1) Penetrant check -- fittings (12 and 19, figure 1104), bracket (31), fittings (1, 35, and 43, figure 1105), and doubler (44) per 20-20-02, Penetrant Methods of Inspection.

(2) Magnetic particle check -- cap (9) and base (10) per 20-20-01, Magnetic Particle Inspection.

REPAIR

1. Repair

   A. Remove minor nicks, pits, scratches, and corrosion from structural components by polishing lightly with abrasive cloth, No. 200 grit or finer.

   B. For structural repairs, refer to the Boeing 737 Structural Repair Manual, D6-15565, 51-10, 51-20, 51-30, 51-40, 55-20-4, and 55-20-5.

   C. For repairs to fiberglass reinforced plastic honeycomb panels, refer to the Boeing 737 Structural Repair Manual, 51-40-09.

2. Refinish

   NOTE: Refer to 20-30-02 for stripping of protective finishes. Refer to 20-41-01 for decoding of F and SRF finish codes and their BAC equivalents.

   A. If plated or painted surfaces are worn or chipped, refinish the following parts as indicated:

      (1) Balance weight fairing (1, figure 1102)

         (a) P/N 65-53722-1 -- Apply SRF-2.30 all over plus SRF-12.63 on exterior surface.

         (b) P/N 65-53722-501 -- Apply SRF-2.30 all over plus F-14.9863-707 on exterior surface.

            NOTE: Fairings P/N 65-53722-1 and -501 are identical except for exterior finish. Fairing P/N 65-53722-501 may be made from fairing P/N 65-53722-1 by adding F-14.9863-707 over existing exterior finish.

      (2) Fairing assemblies (3 and 7, figure 1102) -- As follows:

         (a) Fairing assemblies (3, P/N 65-53723-1) and (7, P/N 65-53723-13, -14, -15, -16) -- Apply SRF-14.672, SRF-14.68, SRF-12.205, and SRF-12.63 on exterior surface of glass reinforced plastic parts. Apply SRF-2.30 followed by SRF-12.63 on exterior surface of aluminum straps.

(b) Fairing assembly (3, P/N 65-53723-519) -- Apply SRF-14.672, SRF-14.68, SRF-12.205, and F-14.9863-707 on exterior surface of glass reinforced plastic parts. Apply SRF-2.30 followed by F-14.9863-707 on exterior surface of aluminum straps.

(c) Fairing assemblies (7, P/N 65-53723-503, -504) -- Apply SRF-14.672, SRF-14.68 and SRF-12.205 on exterior surface of glass reinforced plastic parts, followed by SRF-14.9813 on exterior surface of plastic parts and exterior surface of aluminum straps.

(3) Balance weight (11, Fig. 1102) -- Apply SRF-12.206 all over followed by SRF-12.63. Material: Mild steel, annealed.

(4) Door assembly (1 or 6, Fig. 1103) -- Apply F-2.30 all over on inside surface only. Apply SRF-14.9625 on areas that fay with elevator structure. Material: Al Alloy.

(5) Fairing (20, 23, 26 or 28, Fig. 1103) -- Apply SRF-2.30 all over. On exterior surface only, follow SRF-2.30 with SRF-12.9625. Material: Al Alloy.

(6) Angles (30, 31, 33 or 34, Fig. 1103) -- Apply SRF-2.30 all over. Material: Al Alloy.

(7) Hinge fitting (12, Fig. 1104) -- Apply SRF-2.30 all over. Material: Al Alloy.

(8) Mast fitting (19, Fig. 1104) -- Apply SRF-2.30 all over followed by SRF-12.63 all over except in bushing holes. Material: Al Alloy.

(9) Hinge bracket (31, Fig. 1104) -- Apply SRF-2.30 all over except in slot in base. Material: Al Alloy.

(10) Hinge fitting (2 or 36, Fig. 1105) -- Apply SRF-2.30 all over except in holes for lubrication fitting and bushing. Material: Al Alloy.

(11) Cap and base (9 and 10, Fig. 1105) -- Apply F-1.1923 on mating surfaces and surfaces that fay with bearing. Apply SRF-1.285 on all other surfaces. Material: Steel AMS 4340, 180-200 ksi.

NOTE: Cap and base make up a matched set. Finish together, and keep parts together after refinishing.

(12) Mast fitting (43, Fig. 1105) -- Apply SRF-2.150 all over except in bushing holes. Material: Al Alloy.

(13) Apply SRF-14.9625 on all surfaces of door openings in elevator assembly that fay with access doors and covers.

B. Touch up interior surfaces of elevator structure with primer, BMS 10-11, type 1, as necessary.

C. Touch up exterior surfaces of elevator skin panels as follows:

(1) Elevator assemblies P/N 65-73784-1 and -2 -- Repair flame sprayed aluminum coatings per 737 Structural Repair Manual, Document D6-15565, 51-40-09.

(2) Elevator assemblies P/N 65-73784-5 thru -18 -- Apply F-14.672 plus SRF-14.68, followed by exterior decorative paint to suit individual operator.

D. Use primer BMS 10-79, type 2 (F-19.46) under decorative surfaces. BMS 10-79, type 2 is the preferred option to primer BMS 10-11, type 1.

3. Replacement

A. Replace all parts worn or damaged beyond simple repair.

B. Replace all rubber or fabric aerodynamic seals at each overhaul.

C. Replace all cotter pins at each overhaul.

D. Replace clogged or damaged lubrication fittings.

E. Replace defective antifriction bearings (14, Fig. 1104; 3 or 37, Fig. 1105) as follows:

(1) Press old bearing out of housing. Coat faying surfaces of new bearing and housing with grease, MIL-G-23827 or MIL-G-21164, and install bearing. Ball stake bearings (14, Fig. 1104 and 37, figure 1105) in five places; ball stake bearing (3, Fig. 1105) in four places as directed in 20-50-03, Bearing Installation and Retention.

F. Replace defective bearing (46, Fig. 1105) and sleeve (45) as follows:

(1) Press old bearing and sleeve out of fitting. Use dry primer, BMS 10-11, type 1, on sleeve (45), no primer on bearing (46). Install sleeve and bearing in fitting and roller swage per 20-50-03.

G. Replace defective bushings (20, 21 and 32, figure 1104) as follows:

(1) Press old bushing out of housing.

(2) Coat new bushing with primer, BMS 10-11, type 1, and press into housing while primer is wet.

(3) Machine bushings separately to nominal ID as follows:

(a) Bushings (20) used on mast fitting assemblies (18, P/N 69-40240-1, -2, -5, -6, -501 and -502) -- 0.2505 to 0.2515 inch.

(b) Bushings (20) used on mast fitting assemblies (18, P/N 69-40240-503 and -504) -- 0.2497 to 0.2502 inch.

(c) Bushings (21) used on mast fitting assemblies (18, P/N 69-40240-1, -2, -5, -6, -501 and -502) -- 0.3771 to 0.3781 inch.

(d) Bushings (21) used on mast fitting assemblies (18, P/N 69-40240-503 and -504) -- 0.3761 to 0.3766 inch.

H. Replace defective bushings (32 and 32A, figure 1104) by pressing out old bushing and installing new bushing with wet primer, BMS 10-11, type 1. Machine bushings as follows:

(1) Bushings (32 and 33A) used on hinge bracket assemblies (30 and 30A, P/N 69-41641-1, -501, -506 and -507) -- 0.2500 to 0.2515 inch.

(2) Bushings (32 and 32A) used on hinge bracket assembly (30, P/N 69-41641-508) -- 0.2495 to 0.2500 inch.

I. Replace defective bushings (20, 21, 29, 30, figure 1105) by removing old bushing and installing new bushing as follows. Replace bushings in pairs only.

(1) Bushings (20, 21, 29 and 30, P/N 69-44494-1, -2, -3, -501 and -502) -- Bond bushing to bracket with 20-50-12, type 38 adhesive as directed in 20-50-03, Bearing Installation and Retention. Machine bushings to ID of 0.3120 to 0.3123 and break sharp edges after installation.

(2) Bushings (20, P/N 66-25183-2 and -3) are not self-retaining; attach to bracket by suitable means for installation during mechanism installation in airplane.

(3) Bushings (29 and 30, P/N 69-50565-1, -2, -3, -4) -- Coat new bushings with primer, BMS 10-11, type 1 and press bushing into bracket while primer is wet. Machine to ID of 0.3120 to 0.3123 and break sharp edges after installation.

J. Replace all inserts (13, figure 1104) at each overhaul as follows:

(1) Remove old insert by pulling out of housing.

(2) Coat new insert with primer, BMS 10-11, type 1. Install insert in housing while primer is wet with first coil 1/4 turn below edge of hole.

(3) Remove tang and deburr.

K. Replace all bonding jumpers that show signs of deterioration, or have frayed cables and cracked terminals.

L. Replace damaged shims as follows:

(1) Adjust thickness of new basic shim to dimension recorded when shim was removed, by removing 0.003-inch laminations.

(2) Drill or punch holes through shim to match holes in adjacent parts.

(3) Deburr shim and coat with primer, BMS 10-11, type 1.

M. If decoupled static dischargers (18, figure 1101; and 13 and 14, figure 1102) require replacement, remove defective unit by removing setscrew securing discharger to retainer and install replacement in retainer. Take care to avoid damaging setscrew.

N. Replace decoupled static discharger retainers (8, figure 1101; and 7C and 7D, figure 1102) on assemblies not incorporating Service Bulletin 23-1009.

(1) Remove retainer as follows:

(a) Mark position of retainer. Place marks outside cleaning area.

(b) Remove adhesive fillet at any point and start a crack in adhesive with a sharp tool.

CAUTION: DO NOT SCRATCH SKIN WITH SHARP TOOL.

NOTE: Chemical stripper, Turco 5351, may be used to soften adhesive.

(c) After crack is started in adhesive, lift and pry retainer off surface.

CAUTION: TAKE CARE TO AVOID DAMAGE TO SURFACE.

(2) Prepare surface area for bonding.

(a) Build a dam around adhesive residue on surface with modeling clay or putty and fill dam with stripper, Turco 5351, to cover adhesive.

(b) Allow adhesive to soften and remove residue with plastic or wooden scraper. Reapply stripper if necessary.

WARNING: SOLVENT IS FLAMMABLE. DO NOT USE NEAR FLAME OR SPARKS. USE ONLY IN WELL VENTILATED AREA.

(c) Clean area to be bonded with solvent, Series 91 (SOPM 20-30-91). Wipe off solvent before it evaporates.

(d) Lightly abrade surface with 600-grit paper or cloth. Remove sanding dust with clean, dry gauze or cheesecloth. Do not use solvent.

(3) Prepare adhesive, 610-1016 or Electro-Bond 2016, as follows:

(a) Mix part B hardener with part A resin in a clean glass or metal container. Mix thoroughly with wood tongue depressor or similar paddle until mixture is smooth.

WARNING: ADHESIVE CONTAINS EPOXY RESIN. AVOID BREATHING VAPORS AND CONTACT WITH EYES, SKIN OR CLOTHING. WASH HANDS FREQUENTLY.

(b) Allow adhesive to stand for 10 minutes prior to application.

(4) Clean mounting surface of retainer (33) with solvent, Series 88 (SOPM 20-30-88) and lightly abrade with 600-grit paper or cloth. Remove sanding dust with clean, dry gauze or cheesecloth.

NOTE: Plated retainers (identified by a green dot) should not be abraded.

(5) Apply a thin coating of adhesive, about 0.02 inch thick, to mounting surface of retainer and to airplane surface within 5 minutes of cleaning mounting area. Ensure concave surfaces are filled with adhesive and no voids are apparent.

(6) Apply retainer firmly to airplane surface. Twist slightly with moderate pressure to assure thorough wetting and to squeeze out excess adhesive.

NOTE: Retainer should be in line with slipstream and location mark. Do not re-press or allow base to twist once it has been set in place.

(7) Remove excess adhesive with wooden scraper but be sure there is a fillet of adhesive around the entire edge of retainer.

(8) Fill any existing voids with adhesive. No cracks should be visible, even if mounting surface does not exactly conform to retainer.

CAUTION: BE SURE NOT TO WASH AWAY ADHESIVE FILLET.

(9) Clean off excess adhesive with cloth dampened with solvent, Series 91 (SOPM 20-30-91), leaving a fillet no more than 0.125 inch around base of the retainer and no higher than face of retainer.

(10) Cure adhesive as follows:

(a) Tape retainer firmly to surface with masking tape, or if heat clamp is to be used, place polyvinyl alcohol film over retainer.

(b) Set an infrared lamp, heat clamp or blower directly over the retainer. Position lamp about 4 to 6 inches from retainer.

CAUTION: ON HONEYCOMB TRAILING EDGE PANELS, TEMPERATURE MUST NOT EXCEED 200°F OR HONEYCOMB SANDWICH WILL BE DAMAGED.

(c) Adjust blower, heat clamp or infrared lamp to give a bond line temperature of 200°F.

NOTE: A thermocouple should be taped adjacent to the bond area to aid in indicating bond line temperature.

(d) Cure for 10 to 20 minutes at 200°F. Cure is complete when adhesive cannot be indented with knife.

CAUTION: CLEANING AND BONDING OF RETAINERS MUST BE DONE CORRECTLY OR CONDUCTIVITY OF ADHESIVE MAY NOT BE ASSURED.

(11) Fill any visible gaps or cracks in fillet or between retainer base and airplane surface with fresh adhesive.

(12) Cure the new adhesive per step (10) or cure for approximately 24 hours at ambient temperature of 75°F or higher.

(13) Check decoupled static discharger retainers.

(a) When adhesive is fully cured and cooled to between 70 and 80°F, check for cracks in adhesive fillet between retainer and mounting surface. Any crack is cause for rejection.

CAUTION: TORQUE SHOULD BE APPLIED IN A PLANE PARALLEL TO THE PLANE OF CONTACT BETWEEN AIRPLANE STRUCTURE AND RETAINER. STRUCTURAL DAMAGE MAY OCCUR IF TENSION OR COMPRESSION LOADS ARE APPLIED.

(b) Using torque tool, Granger Associates P/N 610-1014 or equivalent, check retainer adhesion to 246 pound-inches.

(c) Measure dc resistance between discharger retainers and structure with a low resistance testing set. Replace retainers measuring more than 0.1-ohm resistance.

(14) Seal decoupled static discharger retainers.

WARNING: SOLVENT USED IN THIS PROCESS IS FLAMMABLE AND SHOULD NOT BE USED NEAR FLAME OR SPARKS.

(a) Clean area to be sealed around the retainer base fillet and rivet heads with BMS 11-7, FCC-55, MEK: Sec-Butyl Alcohol (42:52), or MPK. Apply solvent from squeeze bottle or safety can with clean oil-free gauze or cheesecloth. Repeat as necessary.

(b) Wipe off solvent each time before it evaporates, using more gauze or cheesecloth. Make certain that area to which sealant is to be applied is not contaminated.

(c) Prepare sealant, Pro-Seal 890, as follows:

1) Mix base compound with matched curing compound in clean glass or metal container per vendor's instructions.

2) Mix thoroughly with wood tongue depressor or similar paddle until mixture is homogeneous.

NOTE: Pot life of sealant Class B-2 is approximately 2 hours at ambient temperature range of 60 to 80°F. Sealant should not be applied if temperature is below 50°F.

(d) Apply a continuous sealant fillet around edge of retainer base with sealant gun or aluminum tube. Cover exposed adhesive completely and lap sealant 1/8 to 3/16 inch onto skin and retainer surface.

(e) Smooth sealant surface and feather edges of fillet with sealant gun nozzle or fairing tool. Cover all exposed adhesive with a minimum of 0.03 inch of sealant.

(f) Cure sealant application as follows:

1) Circulate warm air over sealant with blower. Adjust blower to provide sealant temperature not to exceed 120°F.

NOTE: A thermocouple should be taped adjacent to sealant area to aid in indicating sealant temperature.

2) Cure for approximately 18 hours at 120°F, or 72 hours at 75 to 80°F.

O. Replace decoupled static discharger retainers (14, figure 1101; and 7F and 7K, figure 1102) on assemblies incorporating Service Bulletin 23-1009.

(1) Remove retainers as follows:

(a) Remove rivets (16, figure 1101) or bolts (8, figure 1102) attaching strap (13 figure 1101; and 7G or 7L, figure 1102) to elevator structure.

CAUTION: TAKE CARE TO AVOID DAMAGE TO SURFACE.

(b) Carefully peel strap and attached retainer from surface.

(c) Remove rivets (15, figure 1101; and 7H or 7M, figure 1102) and pry or peel retainer from strap.

(2) Remove adhesive residue from strap and surface with plastic or wooden scraper and clean cloth dampened with solvent, Series 91 (SOPM 20-30-91).

(3) Check skin surface and strap (13, figure 1101; or 7G and 7L, figure 1102) for corrosion. Remove corrosion, if present, by polishing with abrasive cloth, 200-grit or finer.

(4) Apply chemical film treatment, Alodine or Iridite, to skin or strap surface followed by one coat of primer, BMS 10-11, type 1, in faying surface area.

(5) Clean faying surfaces of retainer and strap with solvent, Series 92 (SOPM 20-30-92) applied with clean cloth. Wipe off solvent before it evaporates.

(6) Apply a corrosion-protection faying-surface seal of sealant, BMS 5-95, about 0.01 inch thick, to faying surface of retainer and install retainer on strap using rivets (15, Fig. 1101; or 7H and 7M, Fig. 1102).

(7) Bond strap (13, Fig. 1101, or 7G and 7L, Fig. 1102) to elevator trailing edge skin with adhesive per 20-50-12, using type 44 adhesive. Align holes in strap with mating holes in structure.

(8) Install rivets (16, Fig. 1101) or bolts (8, Fig. 1102) and washers (9).

(9) Install dischargers (18 , Fig. 1101; or 13 and 14, Fig. 1102) in retainer.

(10) Check that electrical resistance between discharger pin and airplane structure is between 5 and 100 megohms.

4. Materials

NOTE: Use listed materials or equivalent substitutes.

A. Adhesives

(1) 610-1016 -- Granger Associates, Palo Alto, California

(2) Electro-Bond 2016 A/B -- Adhesive Engineering Co., San Carlos, California

(3) Type 44, per 20-50-12

B. Solvents

(1) Series 87 (Ref 20-30-87)

(2) Series 88 (Ref 20-30-88)

(3) Series 91 (Ref 20-30-91)

(4) Series 92 (Ref 20-30-92)

(5) MEK, MPK, BMS 11-7, FCC-55, or MEK: Sec-Butyl Alcohol (42:58) (Ref 20-60-01)

C. Stripper, Turco 5351 -- Turco Products Inc. Division of Purex Corp., 24600 South Main Street, Wilmington, California 90746

D. Sealant, Pro-Seal 890, B2 -- Teledyne Coast Pro-Seal, 19451 Susana Road, Compton, California 90221

E. Sealant -- BMS 5-95

F. Primer -- BMS 10-79, type 2

ASSEMBLY

1. Place basic elevator assembly in a suitable holding fixture, and build up as follows:

   A. Installation of Attach Fittings (Fig. 1105)

      (1) Locate shims (41) and hinge fitting assembly (35). Install bolts (39) and washers (40).

      (2) Locate control bracket assembly (17) and shim (25). Install bolts (22 and 23) and washers (24).

      (3) Assemble cap (9), base (10), bearing (11), bolts (13), washers (14), and nuts (12), to make up thrust hinge fitting assembly (8).

      (4) Install thrust hinge fitting assembly (8) with bolts (15) and washers (16).

      (5) Locate hinge fitting assemblies (1) and shims (7). Install bolts (5) and washers (6).

      (6) Coat all bushing surfaces with grease.

      (7) Inject grease through lubrication fitting (4, 11A, 38 and 45A).

   B. Installation of Aerodynamic Seals, Fairings, and Access Doors (Fig. 1103)

      NOTE: Balance cavity seals (45) are not installed until elevator assembly has been balanced per par. D.(2).

      (1) Install fairing (43) with bolts (44). Leave bolts loose.

      (2) Locate angles (33 and 34) and seal (35). Install bolts (37, 38, 39, and 40) as applicable.

      (3) Locate angles (30 and 31) and seal (32). Install radius fillers (36) and bolts (37, 41, and 42) as applicable.

      (4) Install fairing (23) with bolts (24 and 25). If fairing, P/N 65-53716-4, is used, install fairing (26) also with bolts (27).

      (5) Install fairing (20) with bolts (21 and 22). If fairing, P/N 65-53716-3, is used, install fairing (28) also with bolts (29).

      (6) Install covers (11 thru 18) with bolts (19).

(7) Install door assemblies (6) with bolts (10).

(8) Install door assembly (1) with bolts (5).

C. Tip Buildup (Fig. 1102)

(1) Install fairing assembly (7) with bolts (8 and 10) and washers (9).

(2) Install fairing assembly (3) with bolts (4, 5, and 6).

(3) Install balance weight fairing (1) with bolts (2).

D. Buildup and Installation of Tab (Fig. 1104)

(1) Locate hinge bracket assemblies (30 and 30A) on rear spar of elevator. Locate bonding jumpers (5) with extreme inboard and outboard brackets. Install bolts (33) and washers (34). Leave bolts loose.

(2) Check balance of elevator assembly. Rebalance as necessary as directed in the Boeing 737-100 or -200 Structural Repair Manual, 51-80-04 or the Boeing 737-300, -400, or -500 Structural Repair Manual 51-60-04.

(3) Install balance cavity seals (46 thru 56) with bolts (57, 58) and washers (59).

(4) Install shims (27) and mast fitting assembly (18) on front spar of tab with bolts (24, 25, and 26), inserts (23A), washers (23 and 25A), and nuts (22).

(5) Install hinge fitting assemblies (11), shims (16), and doublers (17) with bolts (15) and washers (15A).

(6) Coat all bushings in hinge assemblies and hinge bracket assemblies with grease.

(7) Install tab assembly (10).

(a) Install tab assemblies 65-73799-3, -4, -13 and -14 as follows:

1) Locate tab assembly (10), and attach to rear spar of elevator with bolts (8), washers (9), and nuts (7). Adjust position of each hinge bracket to eliminate binding between hinge and bracket. Tighten nuts (7) finger-tight (torque of 0 to 5 pound-inches) and install cotter pins (6).

(b) Install tab assemblies 65-73799-501, -502, -509 and -510 as follows:

1) Locate tab assembly (10), and attach to rear spar of elevator with items (6 through 8A and 9) per figure 501. Adjust position of each hinge bracket to eliminate binding between hinge and bracket.

(8) Tighten bolts (33).

(9) Attach bonding jumpers (5) to tab with bolts (2), washers (3 and 4), and nuts (1).

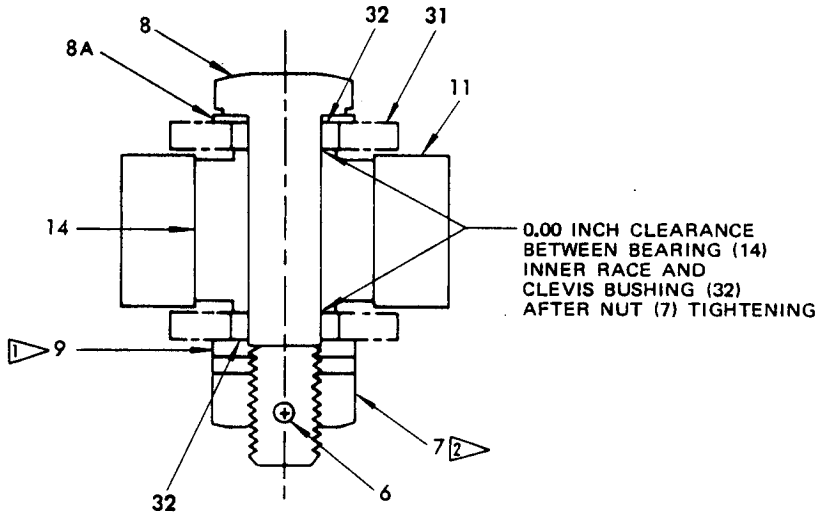
E. Touch up finish on entire assembly as necessary after completion of buildup.

2. Materials

NOTE: Use listed materials or equivalent substitutes.

A. Grease -- Specification MIL-G-23827 or MIL-G-21164

B. Primer -- Specification BMS 10-11, type 1



1 USE TWO AN960PD416 WASHERS. ONE AN960PD416L WASHER MAY BE USED IN ADDITION TO TWO AN960PD416 WASHERS IF NECESSARY FOR COTTER PIN (6) INSTALLATION.

2 TIGHTEN TO TORQUE OF 15 POUND-INCHES. APPLY MINIMUM ADDITIONAL TORQUE (60 POUND-INCHES MAXIMUM) TO ROTATE NUT (7) FOR COTTER PIN (6) INSTALLATION.

Tab Hinge Installation
Figure 501

STORAGE INSTRUCTIONS

1. Wrap entire assembly in greaseproof material, and store in a cool, dry area, preferably humidity controlled. Place package where it will not be moved frequently or handled roughly.

2. For further information, refer to Subjects 20-44-02, Temporary Protective Coatings, and 20-70-01, Protection, Storage, and Handling of Airplane Components.

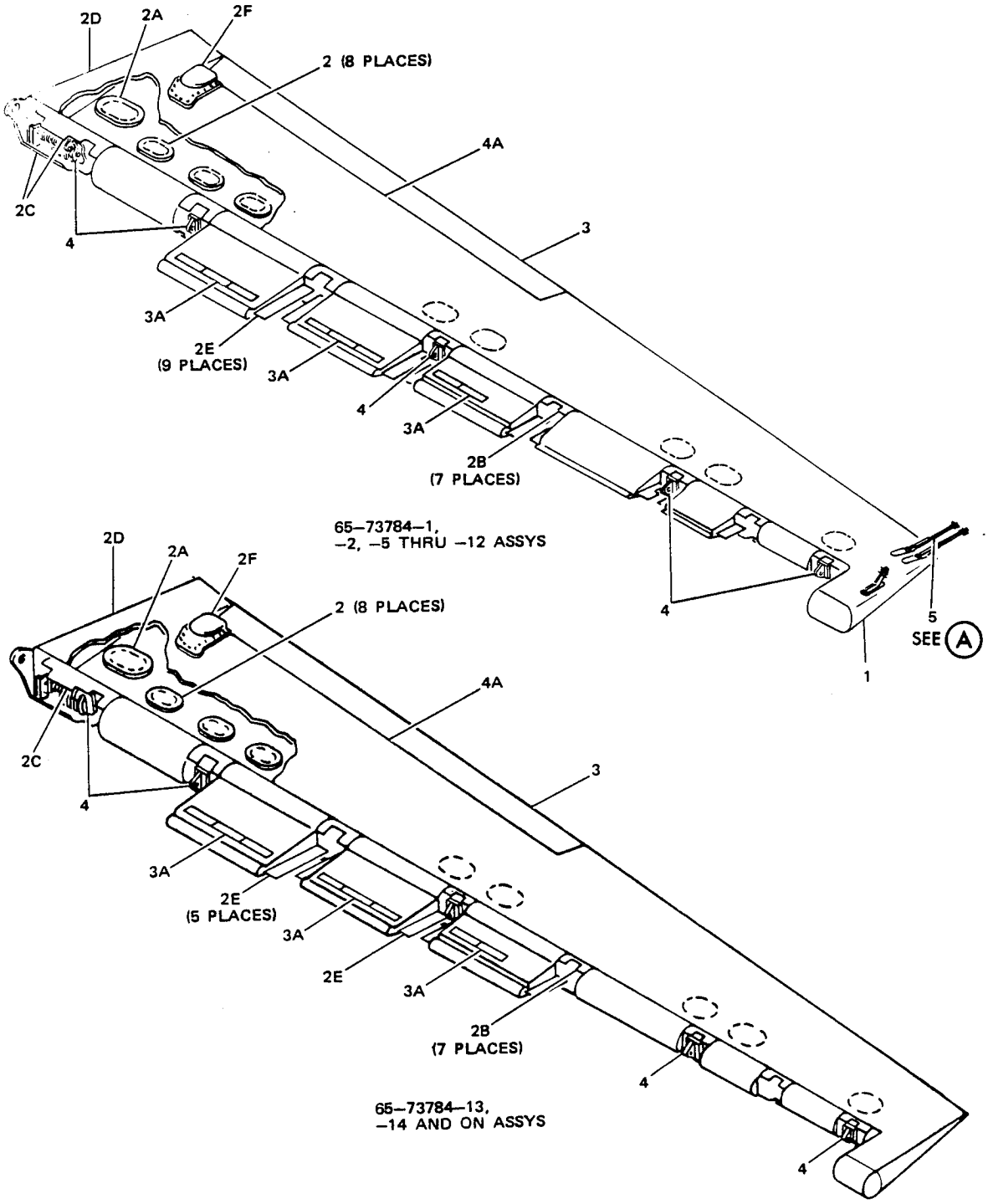
3. Tag assembly with identity of unit and cure date for seals.

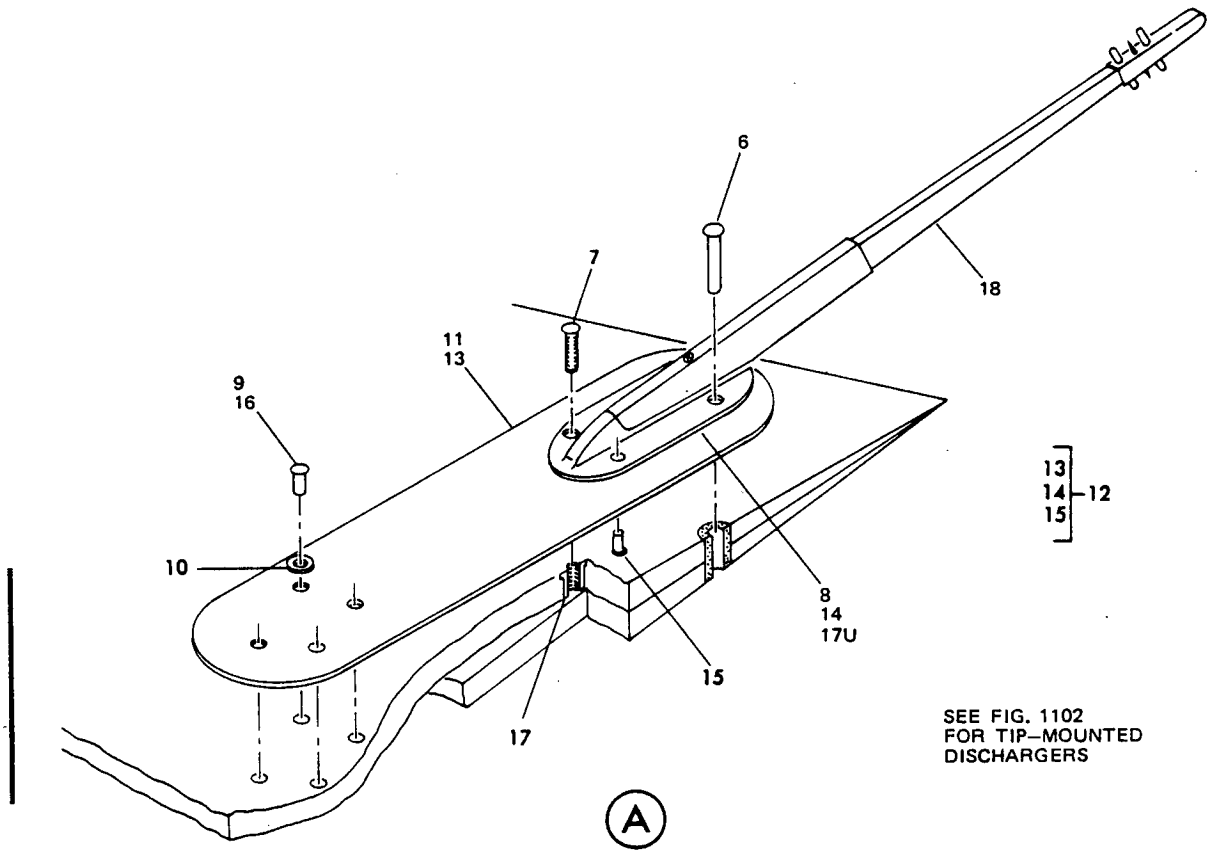
SPECIAL TOOLS, FIXTURES, AND EQUIPMENT

1. Torque Tool, P/N 610-1014 -- Used to check bonding of static discharger retainer on assemblies not incorporating Service Bulletin 23-1009. Granger Associates, 1360 Willow Road, Menlo Park, California 94025

   NOTE: Tool or equipment equivalent to listed item may be used.

ILLUSTRATED PARTS LIST





Elevator Assembly
Figure 1101 (Sheet 2)

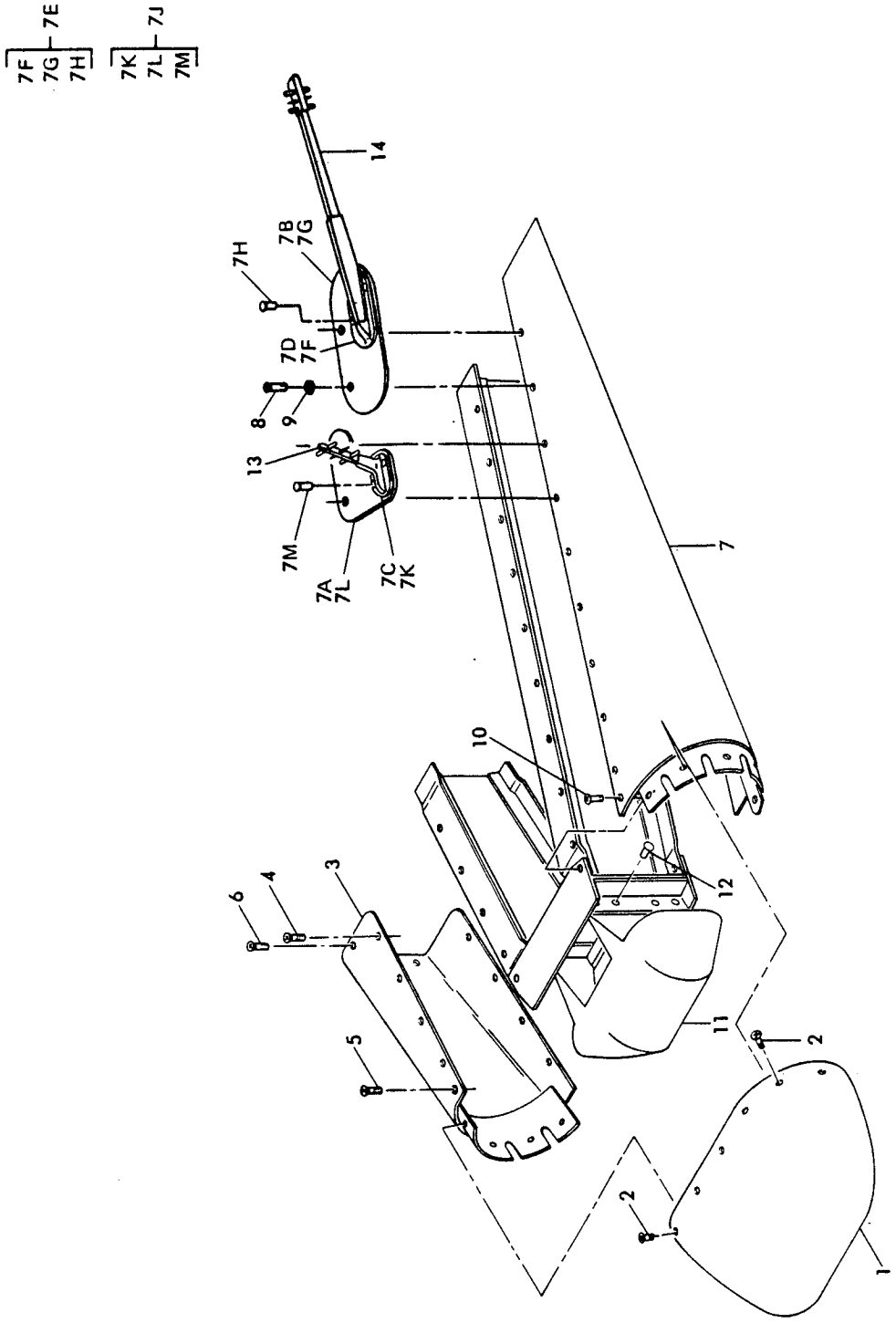
FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
	65-73784-1		ELEVATOR ASSY, LH (PRE SB 55A1020R4) *[10]	A	RF
	65-73784-9		ELEVATOR ASSY, LH	B	RF
	65-73784-5		ELEVATOR ASSY, LH (PRE SB 55A1020R4) *[10]	C	RF
	65-73784-7		ELEVATOR ASSY, LH	D	RF
	65-73784-11		ELEVATOR ASSY, LH	E	RF
	65-73784-13		ELEVATOR ASSY, LH (PRE SB 55A1020R4) *[10]	F	RF
	65-73784-15		ELEVATOR ASSY, LH *[5]	F	RF
	65-73784-21		ELEVATOR ASSY, LH	F	RF
	65-73784-19		ELEVATOR ASSY, LH	G	RF
	65-73784-17		ELEVATOR ASSY, LH	H	RF
	65-73784-31		ELEVATOR ASSY, LH	H	RF
	65-73784-23		ELEVATOR ASSY, LH (PRE SB 55A1020R4) *[10]	I	RF
	65-73784-27		ELEVATOR ASSY, LH *[6]	I	RF
	65-73784-41		ELEVATOR ASSY, LH	I	RF
	65-73784-29		ELEVATOR ASSY, LH	J	RF
	65-73784-33		ELEVATOR ASSY, LH	K	RF
	65-73784-35		ELEVATOR ASSY, LH	L	RF
	65-73784-37		ELEVATOR ASSY, LH *[7]	L	RF
	65-73784-39		ELEVATOR ASSY, LH	M	RF
	65-73784-43		ELEVATOR ASSY, LH	N	RF
	65-73784-2		ELEVATOR ASSY, RH (PRE SB 55A1020R4) *[10]	AA	RF
	65-73784-10		ELEVATOR ASSY, RH	BA	RF
	65-73784-6		ELEVATOR ASSY, RH (PRE SB 55A1020R4) *[10]	CA	RF
	65-73784-8		ELEVATOR ASSY, RH	DA	RF
	65-73784-12		ELEVATOR ASSY, RH	EA	RF
	65-73784-14		ELEVATOR ASSY, RH (PRE SB 55A1020R4) *[10]	FA	RF
	65-73784-16		ELEVATOR ASSY, RH *[5]	FA	RF
	65-73784-22		ELEVATOR ASSY, RH	FA	RF
	65-73784-20		ELEVATOR ASSY, RH	GA	RF
	65-73784-18		ELEVATOR ASSY, RH	HA	RF
	65-73784-32		ELEVATOR ASSY, RH	HA	RF
	65-73784-24		ELEVATOR ASSY, RH (PRE SB 55A1020R4) *[10]	IA	RF
	65-73784-28		ELEVATOR ASSY, RH *[6]	IA	RF
	65-73784-42		ELEVATOR ASSY, RH	IA	RF
	65-73784-30		ELEVATOR ASSY, RH	JA	RF
	65-73784-34		ELEVATOR ASSY, RH	KA	RF
	65-73784-36		ELEVATOR ASSY, RH	LA	RF
	65-73784-38		ELEVATOR ASSY, RH *[7]	LA	RF
	65-73784-40		ELEVATOR ASSY, RH	MA	RF

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
	65-73784-44		ELEVATOR ASSY, RH	NA	RF
1	65-53729-1		. TIP INSTL (FIG. 1102)	A-DFG	1
1	65-53729-2		. TIP INSTL (OPP)	AA-DA FA-GA	1
1	65-53729-21		. TIP INSTL (FIG. 1102)	EH	1
1	65-53729-22		. TIP INSTL (OPP)	EA HA	1
1	65-53729-23		. TIP INSTL (FIG. 1102)	IKLN	1
1	65-53729-24		. TIP INSTL (OPP)	IA KA LA NA	1
1	65-53729-27		. TIP INSTL (FIG. 1102)	JM	1
1	65-53729-28		. TIP INSTL (OPP)	JA MA	1
2	69-40241-1		. DOOR INSTL, ACCESS *[8] *[9]	ABC AA-CA	8
2	69-55994-1		. DOOR INSTL, ACCESS *[9]	C-N CA-NA	8
2A	69-45461-1		. DOOR INSTL, ACCESS *[8] *[9]	ABC AA-CA	1
2A	69-55994-2		. DOOR INSTL, ACCESS *[9]	C-N CA-NA	1
2B	65-53721-1		. COVER INSTL*[9]	A-N	1
2B	65-53721-2		. COVER INSTL *[9]	AA-NA	1
2C	65-53716-1		. FAIRING INSTL *[9]	AB	1
2C	65-53716-7		. FAIRING INSTL *[9]	C-N	1
2C	65-53716-2		. FAIRING INSTL *[9]	AA BA	1
2C	65-53716-8		. FAIRING INSTL *[9]	CA-NA	1
2D	65-65548-1		. SEAL INSTL *[8] *[9]	AB	1
2D	65-65548-13		. SEAL INSTL *[8] *[9]	ABC	1
2D	65-65548-2		. SEAL INSTL *[8] *[9]	AA BA	1
2D	65-65548-14		. SEAL INSTL *[8] *[9]	AA-CA	1
2D	65-69623-1		. SEAL INSTL *[9]	C-N	1
2D	65-69623-2		. SEAL INSTL *[9]	CA-NA	1
2E	65-53728-1		. SEAL INSTL, BALANCE CAVITY *[9]	A-N	1
2E	65-53728-2		. SEAL INSTL, BALANCE CAVITY *[9]	AA-NA	1
2F	65-53720		. FAIRING (FIG. 1103)		1
3	65-73799-1		TAB INSTL (FIG. 1104, REF 65-73795)	A-N	1
3	65-73799-2		TAB INSTL (FIG. 1104)	AA-NA	1
3A	65-60535-1		. WEIGHT INSTL (FIG. 1106)	A	1
3A	65-60535-2		. WEIGHT INSTL (FIG. 1106)	AA	1
3A	65-60535-5		. WEIGHT INSTL (FIG. 1106)	C	1
3A	65-60535-6		. WEIGHT INSTL (FIG. 1106)	CA	1
3A	65-60535-7		. WEIGHT INSTL (FIG. 1106)	BD	1
3A	65-60535-8		. WEIGHT INSTL (FIG. 1106)	BA DA	1
3A	65-60535-9		. WEIGHT INSTL (FIG. 1106)	F-N	1
3A	65-60535-10		. WEIGHT INSTL (FIG. 1106)	FA-NA	1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
4	65-47588-1		. FRONT SPAR INSTL (FIG. 1105)	A-H	1
4	65-47588-2		. FRONT SPAR INSTL (FIG. 1105)	AA-HA	1
4	65-47588-83		. FRONT SPAR INSTL (FIG. 1105)	I-N	1
4	65-47588-84		. FRONT SPAR INSTL (FIG. 1105)	IA-NA	1
4A	65-47589-1		. REAR SPAR INSTL *[8] (FIG. 1104)	AB	1
4A	65-47589-2		. REAR SPAR INSTL *[8] (FIG. 1104)	AA BA	1
4A	65-47589-19		. REAR SPAR INSTL (FIG. 1104)	A-K	1
4A	65-47589-20		. REAR SPAR INSTL (FIG. 1104)	AA-KA	1
4A	65-47589-31		. REAR SPAR INSTL (FIG. 1104)	L-N	1
4A	65-47589-32		. REAR SPAR INSTL (FIG. 1104)	LA-NA	1
5	65-53713-1		. SKIN PANEL INSTL, LH *[1]	A-DF IKLN	1
5	65-53713-2		. SKIN PANEL INSTL, RH *[1]	AA-DA FAIA KALANA	1
5	65-53713-75		. SKIN PANEL INSTL, LH *[1]	EHJM	1
5	65-53713-76		. SKIN PANEL INSTL, RH *[1]	EA HA JA MA	1
5	65-53713-93		. SKIN PANEL INSTL, LH *[1]	G	1
5	65-53713-94		. SKIN PANEL INSTL, RH *[1]	GA	1
6	MS20426A4		. . RIVET		1
7	NAS514P632-5		. . SCREW		1
8	610-1009		. . RETAINER, STATIC DISCHARGER, V08935 *[2] *[8]		1
9	CR2238-5-3		. . RIVET *[2] *[8]		4
10	BACW10UC8		. . WASHER *[2] *[8]		4
11	65-53713-71		. . STRAP *[3]		1
12	65-53713-503		. . RETAINER-STRAP ASSY (SB 23-1009)		1
12	65-53713-504		. . RETAINER-STRAP ASSY (OPP 65-53713-503)(SB 23-1009)		1
13	65-53713-505		. . . STRAP		1
14	65-53713-506		. . . RETAINER		1
15	MS20426A4-2		. . . RIVET		2
16	NAS1399MW5-3		. . RIVET (USED WITH 65-53713-505)		4
17	BACI12M06-2		. . INSERT		1
			INSTALLATION ITEMS		
17T	65-58128-2		DISCHARGER PROVISIONS INSTL *[8]	ABC AA-CA	1
17T	65-58128-15		DISCHARGER INSTL *[8]	D-N DA-NA	1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-17T	65-58128-16		DISCHARGER INSTL *[8]	F-N FA-NA	1
17U	610-1009		. RETAINER, DISCH, V08935 (USED ON 65-58128-2)	ABC AA-CA	1
18	610D1B		. DISCHARGER, TRAILING, V08935 (USED ON 65-58128-16)		1
18	610-1011		. DISCHARGER, TRAILING, V08935 (OPT TO 610D1B)		1
18	2-13S		. DISCHARGER, TRAILING, *[4] (USED ON 65-58128-15)		1
18	2-13		. DISCHARGER, TRAILING, *[4] (OPT TO 2-13S)(USED ON 65-58128-15)		1

*[1] SKIN PANELS ARE PART OF ELEVATOR PERMANENT STRUCTURE, SO ONLY THOSE PARTS THAT CAN BE EXPECTED TO REQUIRE REPLACEMENT ARE LISTED
*[2] USED WITH 65-53713-71
*[3] USED ON ASSEMBLIES NOT INCORPORATING SB 23-1009
*[4] CHELTON ELECTROSTATICS LTD, MARLOW, BUCKINGHAMSHIRE, ENGLAND
*[5] 65-73784-15, -16 OPP IDENTICAL TO 65-73784-13, -14 OPP EXCEPT FOR FWD C.G. BALANCE
*[6] 65-73784-27, -28 OPP IDENTICAL TO 65-73784-23, -24 OPP EXCEPT FOR FWD C.G. BALANCE
*[7] 65-73784-37, -38 OPP IDENTICAL TO 65-73784-35, -36 OPP EXCEPT FOR FWD C.G. BALANCE
*[8] LIMITED USE
*[9] SEE FIG. 1103
*[10] USE THE EXISTING PART NUMBER TO PLACE AN ORDER FOR THE NEW REPLACEMENT PART. THE NEW PART WILL HAVE THE MODIFICATIONS DESCRIBED IN THE SERVICE BULLETIN INCORPORATION.



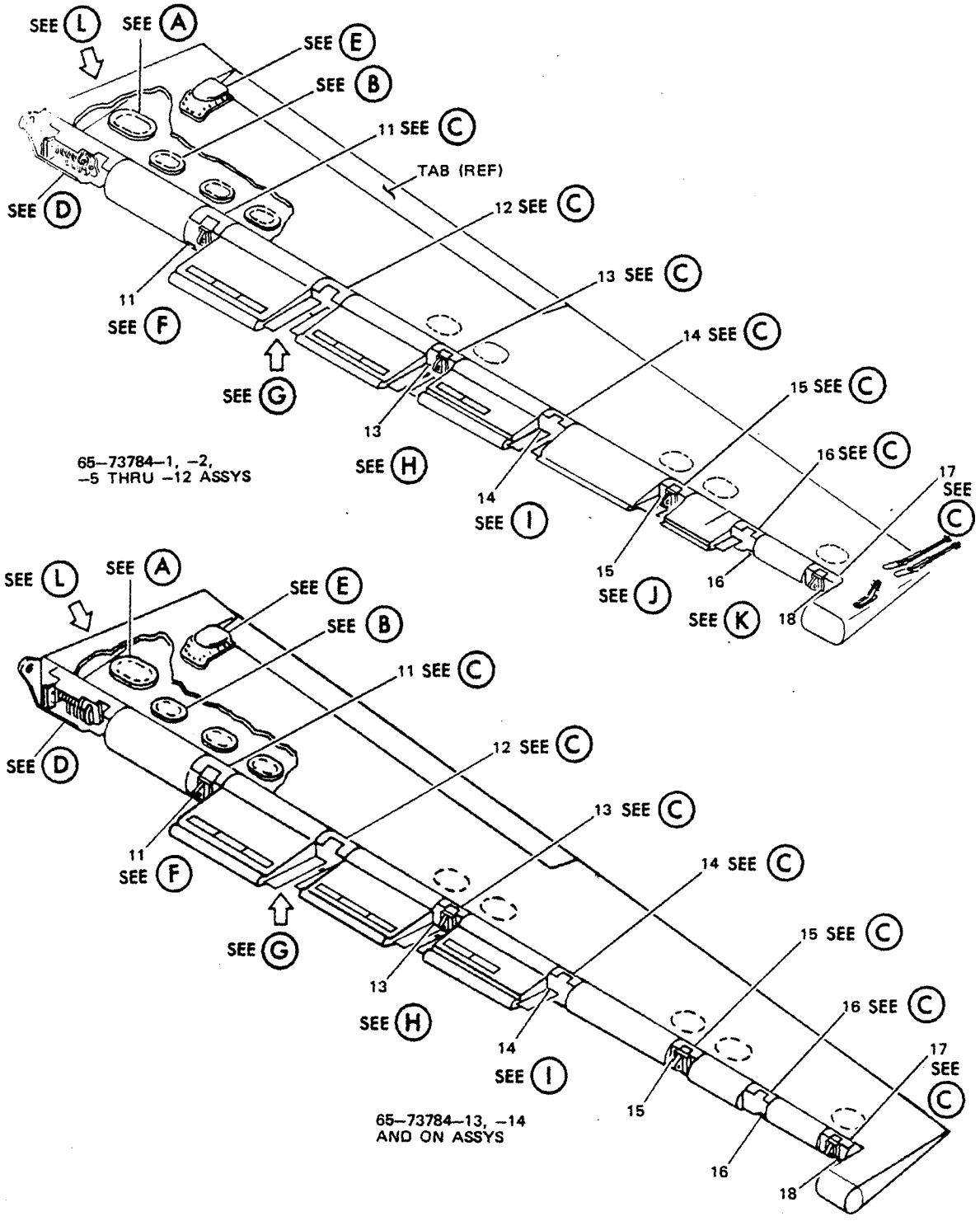
Tip Buildup
Figure 1102

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1102-					
	65-53729-1		TIP INSTL LH	A	RF
	65-53729-2		TIP INSTL RH	B	RF
	65-53729-21		TIP INSTL LH	C	RF
	65-53729-22		TIP INSTL RH	D	RF
	65-53729-23		TIP INSTL LH	E	RF
	65-53729-24		TIP INSTL RH	F	RF
	65-53729-27		TIP INSTL LH	G	RF
	65-53729-28		TIP INSTL RH	H	RF
1	65-53722-501		. FAIRING *[1] (REPLS 65-53722-1)		1
1	65-53722-1		. FAIRING *[1] (REPLD BY 65-53722-501)		1
2	BACB30LU3-3		. BOLT		13
3	65-53723-519		. FAIRING ASSY (REPLS 65-53723-1)		1
3	65-53723-1		. FAIRING ASSY *[3] (REPLD BY 65-53723-519)	AB	1
4	BACB30LU3-3		. BOLT		12
5	BACB30LU3-4		. BOLT		1
6	BACB30LU4-4		. BOLT		2
7	65-53723-15		. FAIRING ASSY, LH (SB 23-1009)	CG	1
7	65-53723-503		. FAIRING ASSY, LH (REPLS 65-53723-13)	AE	1
7	65-53723-13		. FAIRING ASSY, LH *[3]	A	1
7	65-53723-16		. FAIRING ASSY, RH (SB 23-1009)	DH	1
7	65-53723-504		. FAIRING ASSY, RH (REPLS 65-53723-14)	BF	1
7	65-53723-14		. FAIRING ASSY, RH *[3]	B	1
7A	65-53723-11		. . STRAP (USED ON 65-53723-13)		1
7A	65-53723-12		. . STRAP (USED ON 65-53723-14)		1
7B	65-53723-9		. . STRAP (USED ON 65-53723-13)		1
7B	65-53723-10		. . STRAP (USED ON 65-53723-14)		1
7C	611-1006		. . RETAINER, TIP, V08935		1
7D	610-1009		. . RETAINER, TRAILING, V08935		1
7E	65-53723-505		. . RETAINER-STRAP ASSY, TRAILING DISCHARGER (USED ON 65-53723-15,-503)(SB 23-1009)		1
7E	65-53723-506		. . RETAINER-STRAP ASSY, TRAILING DISCHARGER (USED ON 65-53723-16,-504)(SB 23-1009)		1
7F	65-53723-502		. . . RETAINER (MADE FROM 610-1009)		1
7G	65-53723-509		. . . STRAP (USED ON 65-53723-505)		1
7G	65-53723-510		. . . STRAP (USED ON 65-53723-506)		1

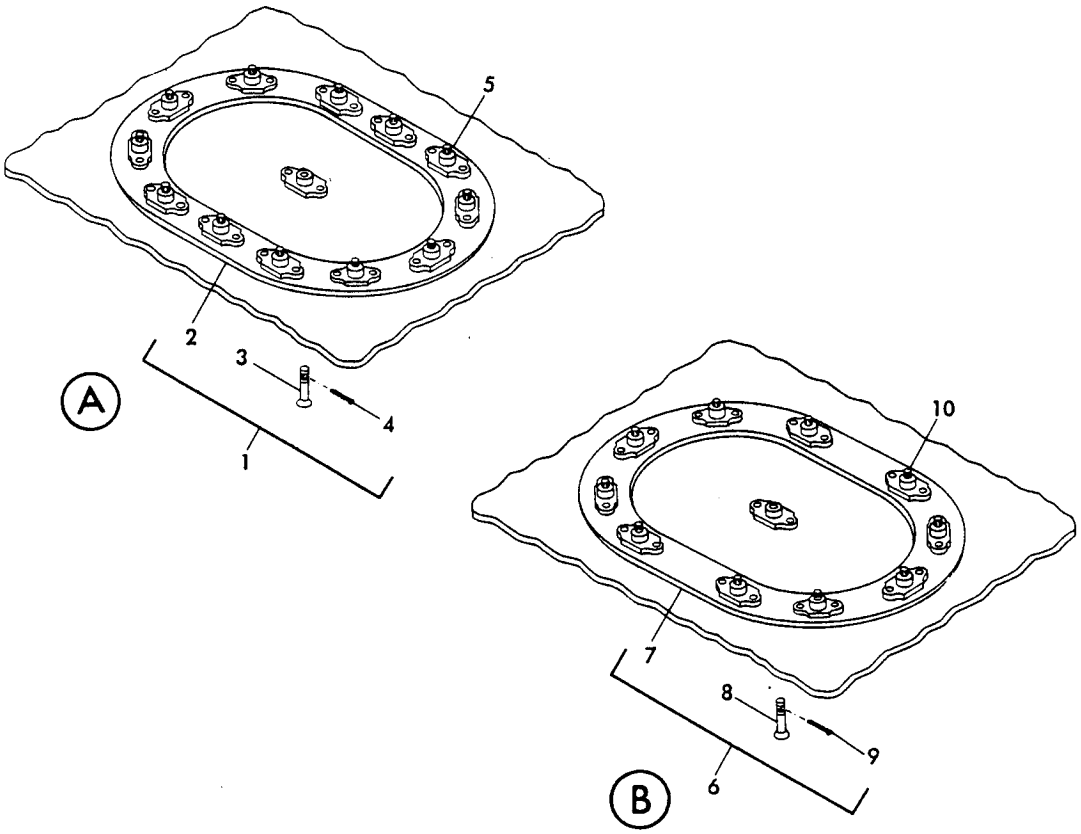
FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1102-					
7H	MS20426B4-2		. . . RIVET		2
7J	65-53723-507		. . RETAINER-STRAP ASSY, TIP DISCHARGER (USED ON 65-53723-15, -503)		1 1
7J	65-53723-508		. . RETAINER-STRAP ASSY, TIP DISCHARGER (USED ON 65-53723-16, -504)		1
7K	65-53723-513		. . . RETAINER (MADE FROM 611-1006)		1
7L	65-53723-511		. . . STRAP (USED ON 65-53723-507)		1
7L	65-53723-512		. . . STRAP (USED ON 65-53723-508)		1
7M	MS20426B4-2		. . . RIVET		2
8	BACB30LU3-3		. BOLT		18
9	BACW10UC10		. WASHER		8
10	BACB30LU3-4		. BOLT		1
11	65-53725-3		. WEIGHT, BALANCE		1
12	MS20470D6		. RIVET		AR
			INSTALLATION ITEMS		
-12T	65-58128-15		DISCHARGER INSTL *[3]		1
-12T	65-58128-16		DISCHARGER INSTL *[3]		1
13	611D1B		. DISCHARGER, TIP, V08935 (USED ON 65-58128-16)		1
13	611-1008		. DISCHARGER, TIP, V08935 (OPT TO 611D1B)		1
13	2-14		. DISCHARGER, TIP *[2] (USED ON 65-58128-15)		1
14	610D1B		. DISCHARGER, TRAILING, V08935 (USED ON 65-58128-16)		1
14	610-1011		. DISCHARGER, TRAILING, V08935 (OPT TO 610D1B)		1
14	2-13S		. DISCHARGER, TRAILING *[2] (USED ON 65-58128-15)		1 1
14	2-13		. DISCHARGER, TRAILING *[2] (OPT TO 2-13S)		1 1

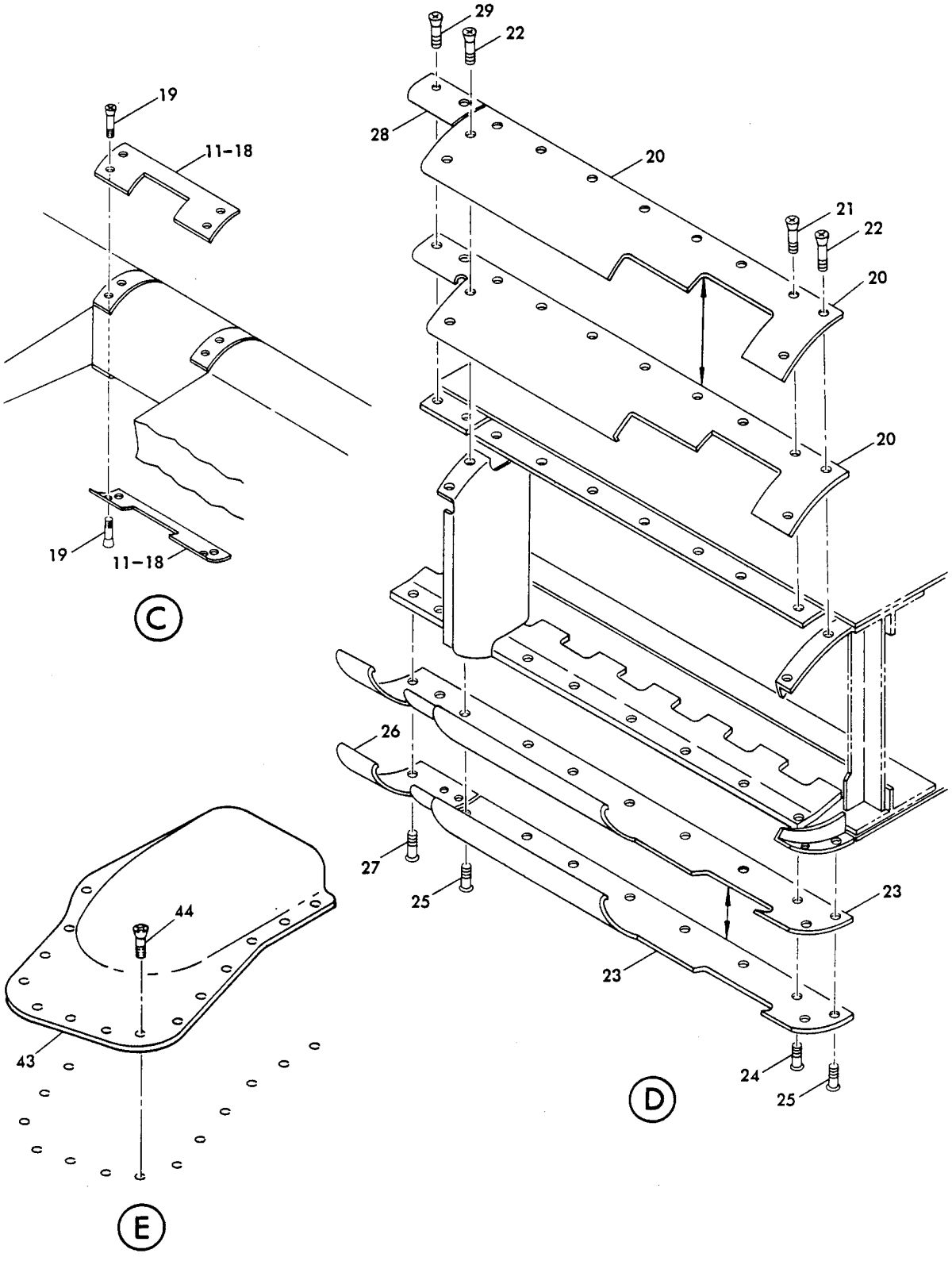
- NOT ILLUSTRATED

*[1] Balance weight fairings P/N 65-53722-1 and -501 are identical except for exterior finish.
*[2] Chelton Electrostatics Ltd., Marlow, Buckinghamshire, England
*[3] LIMITED USE

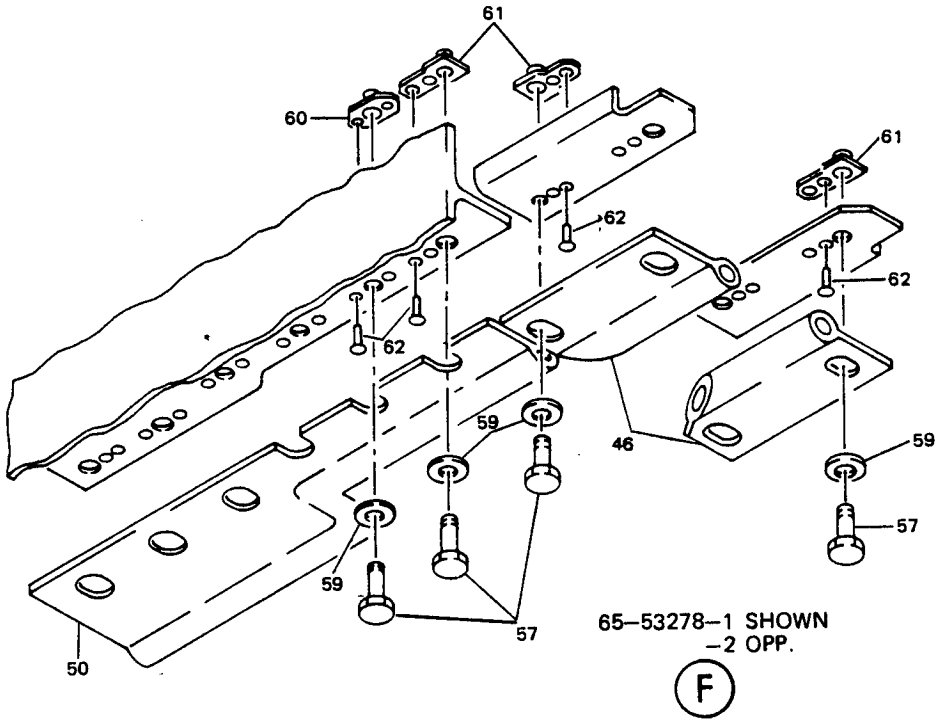


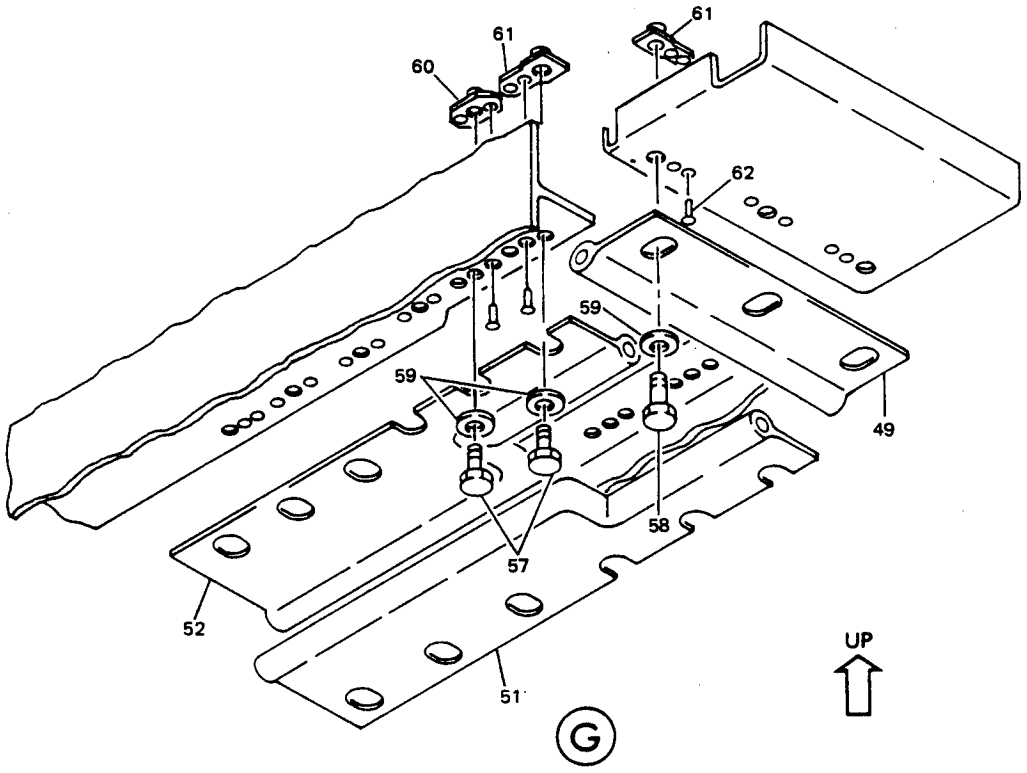
Elevator Assembly
Figure 1103 (Sheet 1)

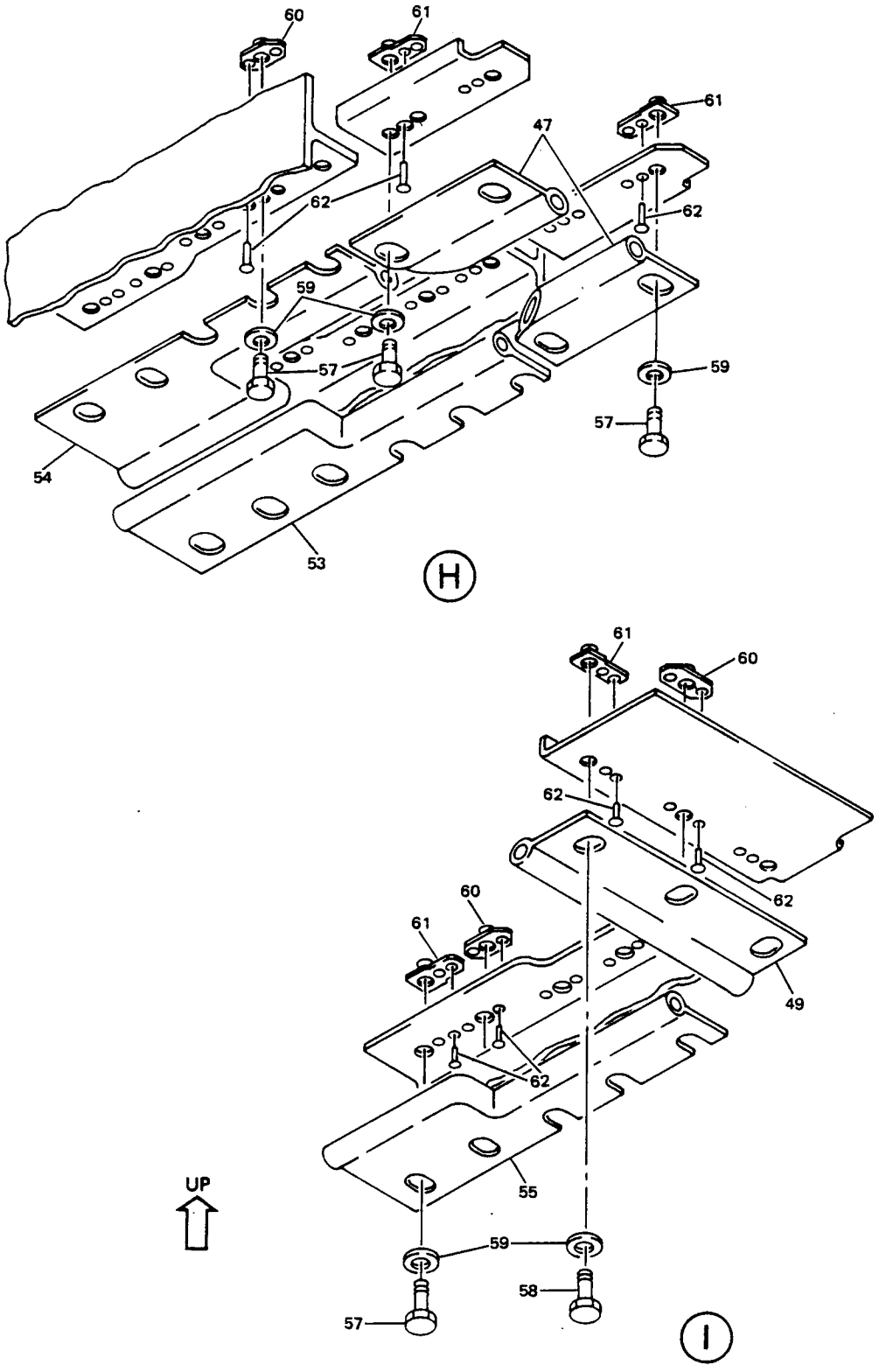

5
2
3
4
1
A
10
7
8
9
6
B



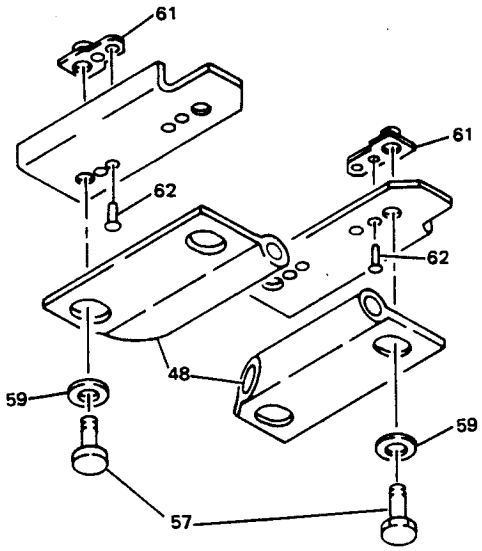
Elevator Assembly
Figure 1103 (Sheet 3)


61
60
61
62
62
62
59
46
59
57
59
57
50
65-53278-1 SHOWN
-2 OPP.
F


61
61
60
62
59
59
49
58
57
52
51
UP
G



Elevator Assembly
Figure 1103 (Sheet 5)



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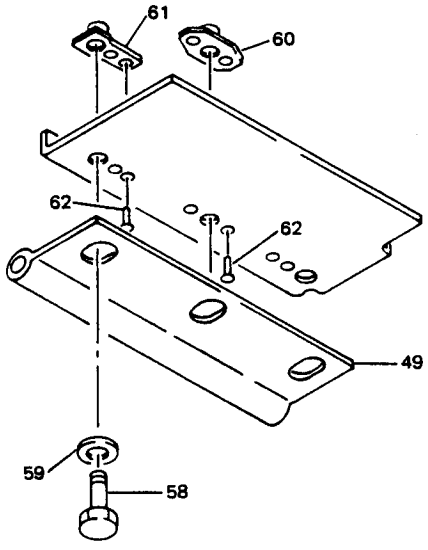

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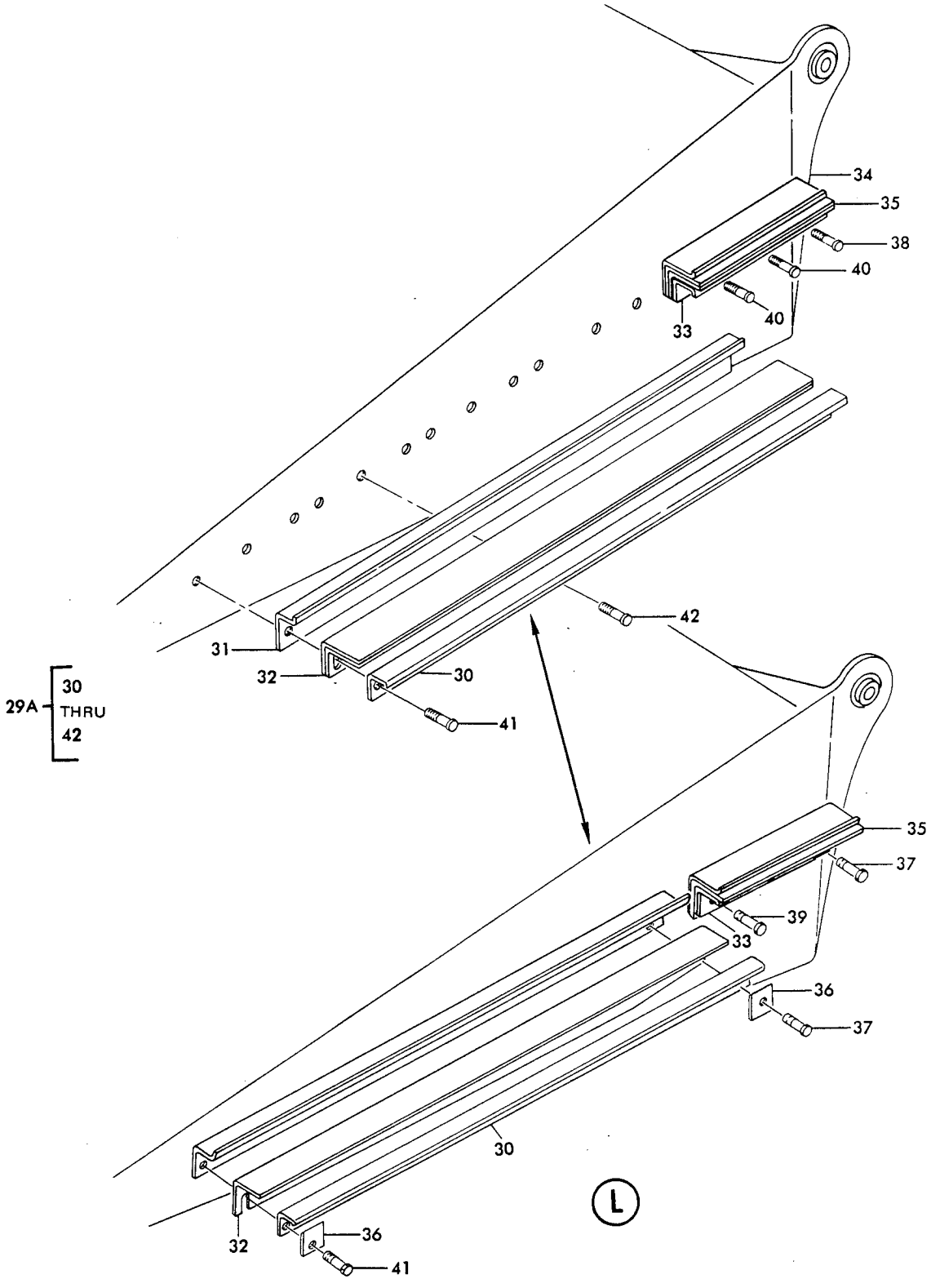


Elevator Assembly
Figure 1103 (Sheet 7)

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1103-					
	69-40241-1		DOOR INSTLN	A	RF
	69-55994-1		DOOR INSTLN	B	RF
	69-45461-1		DOOR INSTLN	C	RF
	69-55994-2		DOOR INSTLN	D	RF
1	69-55994-4		. DOOR ASSY	D	1
1	69-45461-2		. DOOR ASSY	C	1
2	69-55994-6		. . DOOR (USED ON 69-55994-4)		1
2	69-45461-4		. . DOOR (USED ON 69-45461-2)		1
3	69-40241-3		. . SCREW (USED ON 69-55994-4)		1
3	69-45461-3		. . SCREW (USED ON 69-45461-2)		1
4	MS24665-132		. . PIN, COTTER		1
5	BACB30LU3-2		. BOLT		12
6	69-55994-3		. DOOR ASSY	B	8
6	69-40241-2		. DOOR ASSY	A	8
7	69-55994-5		. . DOOR (USED ON 69-55994-3)		1
7	69-40241-5		. . DOOR (USED ON 69-40241-2)		1
8	69-40241-3		. . SCREW		1
9	MS24665-132		. . PIN, COTTER		1
10	BACB30LU3-2		. BOLT		80
	65-53721-1		COVER INSTL LH	E	RF
	65-53721-2		COVER INSTL RH	F	RF
11	65-53721-3		. COVER	EF	2
12	65-53721-4		. COVER	EF	2
13	65-53721-5		. COVER	EF	2
14	65-53721-6		. COVER	EF	2
15	65-53721-7		. COVER	EF	2
16	65-53721-8		. COVER	EF	2
17	65-53721-11		. COVER	EF	1
17	65-53721-9		DELETED		
18	65-53721-10		DELETED		
18	65-53721-12		. COVER	EF	1
19	BACB30LU3-1		. BOLT	EF	32
	65-53716-1		FAIRING INSTL, LH	G	RF
	65-53716-7		FAIRING INSTL, LH	H	RF
	65-53716-2		FAIRING INSTL, RH	I	RF
	65-53716-8		FAIRING INSTL, RH	J	RF
20	65-53716-9		. FAIRING	H	1
20	65-53716-10		. FAIRING	J	1
20	65-53716-3		. FAIRING	G	1
20	65-53716-4		. FAIRING	I	1
21	BACB30LU3-3		. BOLT	G-J	*[1]
22	BACB30LU3-1		. BOLT	G-J	4

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1103-					
23	65-53716-23		. FAIRING	H	1
23	65-53716-24		. FAIRING	J	1
23	65-53716-4		. FAIRING	G	1
23	65-53716-3		. FAIRING	I	1
24	BACB30LU3-3		. BOLT	G-J	*[2]
25	BACB30LU3-1		. BOLT	G-J	4
26	65-53716-19		. FAIRING *[3]	G	1
26	65-53716-20		. FAIRING *[3]	I	1
27	BACB30LU3-3		. BOLT	GI	3
28	65-53716-21		. FAIRING *[3]	GI	1
29	BACB30LU3-3		. BOLT	GI	2
29A	65-69623-1		SEAL INSTL	K	RF
29A	65-69623-2		SEAL INSTL	L	RF
29A	65-65548-13		SEAL INSTL (REPLS 65-65548-1)	M	RF
29A	65-65548-14		SEAL INSTL (REPLS 65-65548-2)	N	RF
29A	65-65548-1		SEAL INSTL, LH (REPLD BY 65-65548-13)	O	RF
29A	65-65548-2		SEAL INSTL, RH (REPLD BY 65-65548-14)	P	RF
30	69-55912-3		. ANGLE, LH	KM	1
30	65-65548-3		. ANGLE, LH	O	1
30	69-55912-4		. ANGLE, RH	LN	1
30	65-65548-4		. ANGLE, RH	P	1
31	65-65548-5		. ANGLE, LH	O	1
31	65-65548-6		. ANGLE, RH	P	1
32	10-60754-104		. SEAL	KL	1
32	65-65548-11		. SEAL ASSY	MN	1
32	65-65548-9		. SEAL	OP	2
33	69-55912-6		. ANGLE	K-N	1
33	65-65548-7		. ANGLE	OP	1
34	65-65548-8		. ANGLE	OP	1
35	10-60754-105		. SEAL	KL	1
35	65-65548-12		. SEAL ASSY	MN	1
35	65-65548-10		. SEAL	OP	2
36	BACF33C101-075D		. FILLER, RADIUS	K-N	7
37	BACB30NE3-9		. BOLT	K-P	2
38	BACB30NE3-8		. BOLT	OP	1
39	BACB30NE3-7		. BOLT	K-N	1
40	BACB30NE3-6		. BOLT	OP	2
41	BACB30NE3-5		. BOLT	K-P	*[4]
42	BACB30NE3-4		. BOLT	OP	4

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1103-					
43	65-53720-5		FAIRING, LH (REPLS 65-53720-1)		1
43	65-53720-1		FAIRING, LH (REPLD BY 65-53720-5) *[5]		1
43	65-53720-6		FAIRING, RH (REPLS 65-53720-2)		1
43	65-53720-2		FAIRING, RH (REPLD BY 65-53720-6) *[5]		1
44	BACB30LU3-4		BOLT (USED ON 65-53720-ALL)		17
45	65-53728-1		SEAL INSTL, BALANCE CAVITY	Q	RF
45	65-53728-2		SEAL INSTL, BALANCE CAVITY	R	RF
46	65-53728-3		. SEAL, STAS 65 AND 68	QR	2
47	65-53728-4		. SEAL, STAS 120 AND 123	QR	2
48	65-53728-5		. SEAL, STAS 175 AND 178	QR	2
49	65-53728-6		. SEAL, STAS 94, 149, 195	QR	3
50	65-53728-9		. SEAL, STA 68	QR	1
51	65-53728-10		. SEAL, STA 93	QR	1
52	65-53728-11		. SEAL, STA 95	QR	1
53	65-53728-12		. SEAL, STA 120	QR	1
54	65-53728-13		. SEAL, STA 123	QR	1
55	65-53728-14		. SEAL, STA 148	QR	1
56	69-22297-10		. SEAL, FWD	QR	3
			ATTACHING PARTS		
57	BACB30NE3-3		. BOLT (REPLS NAS1303-3)	QR	46
58	BACB30NE3-2		. BOLT (REPLS NAS1303-2)	QR	9
59	BACW10P44AL		. WASHER	QR	55
60	BACN10JR3F		. NUTPLATE, TWO LUG	QR	25
61	BACN10KB3F		. NUTPLATE, ONE LUG	QR	30
62	MS20426D3		. RIVET	QR	110

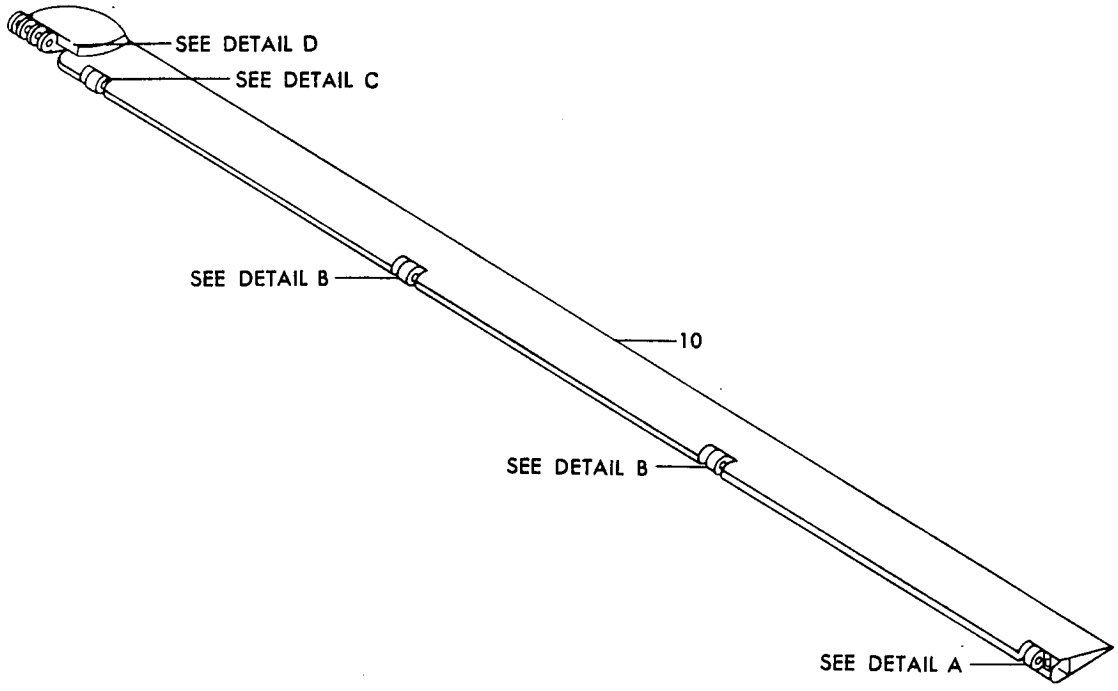
*[1] USE 8 WITH 65-53716-9 OR -10; USE 7 WITH 65-53716-3 OR -4

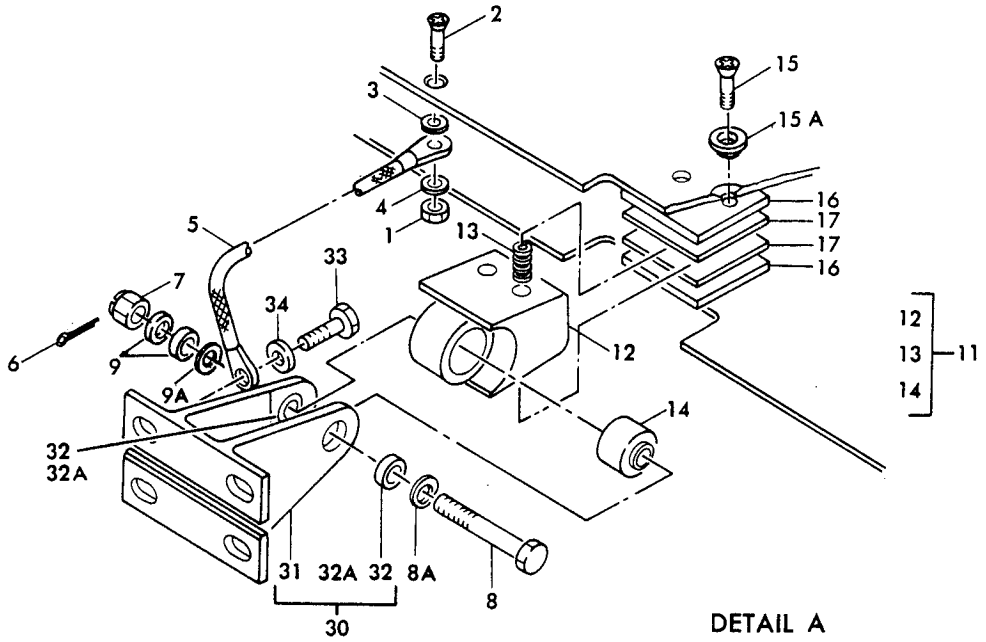
*[2] USE 9 WITH 65-53716-23 OR -24; USE 7 WITH 65-53716-3 OR -4

*[3] FAIRINGS 65-53716-19, -20, AND -21 ARE REWORK PARTS, USED WITH -3 AND -4 UNTIL -3 AND -4 ARE REPLACED

*[4] USE 7 WITH 65-65548-1 OR -2; USE 4 WITH 65-69623-1 OR -2 AND 65-65548-13 OR -14

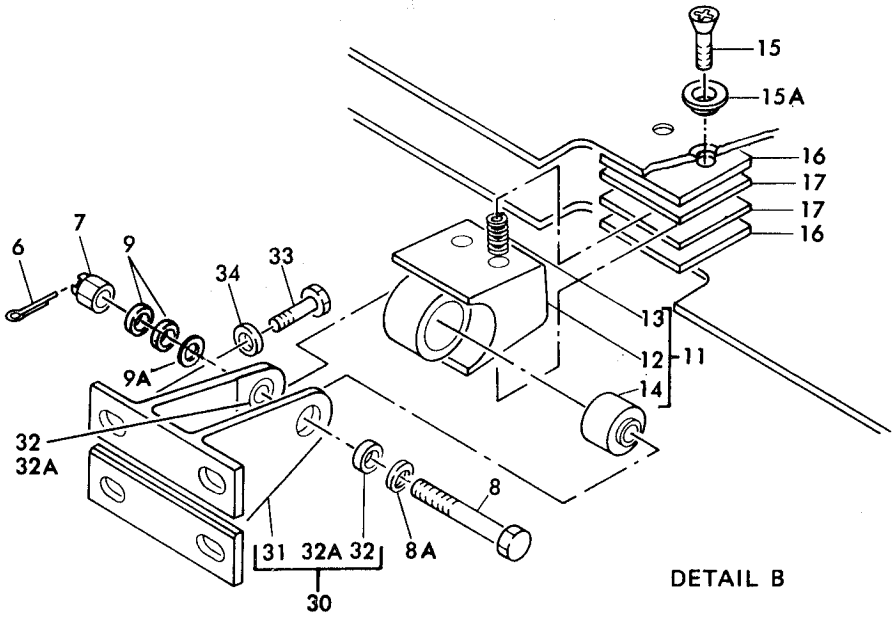
*[5] LIMITED USE



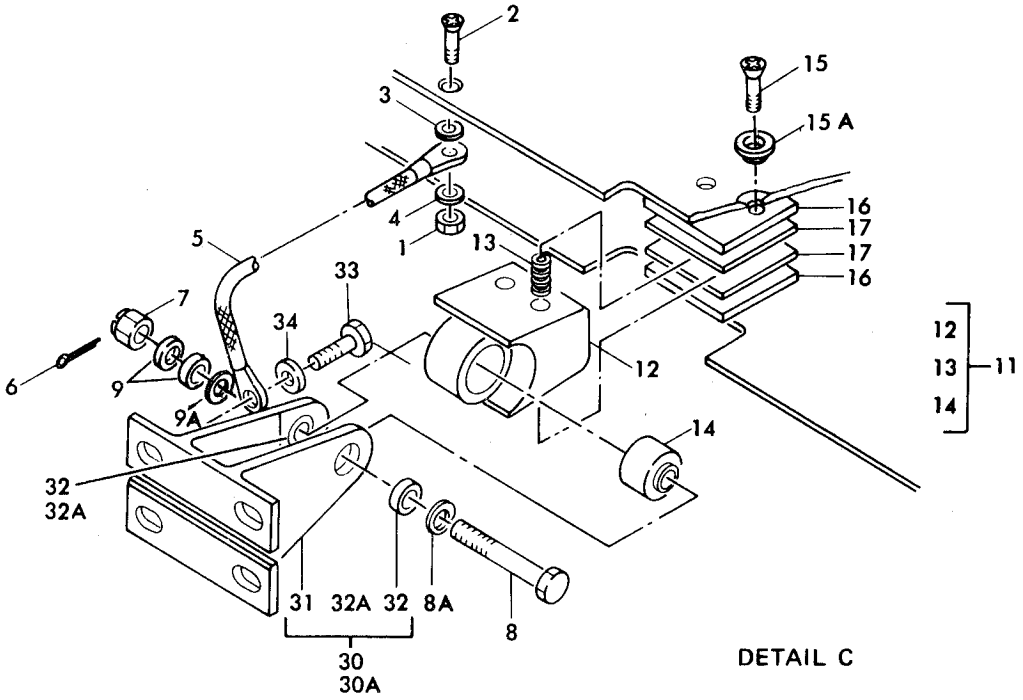


DETAIL A

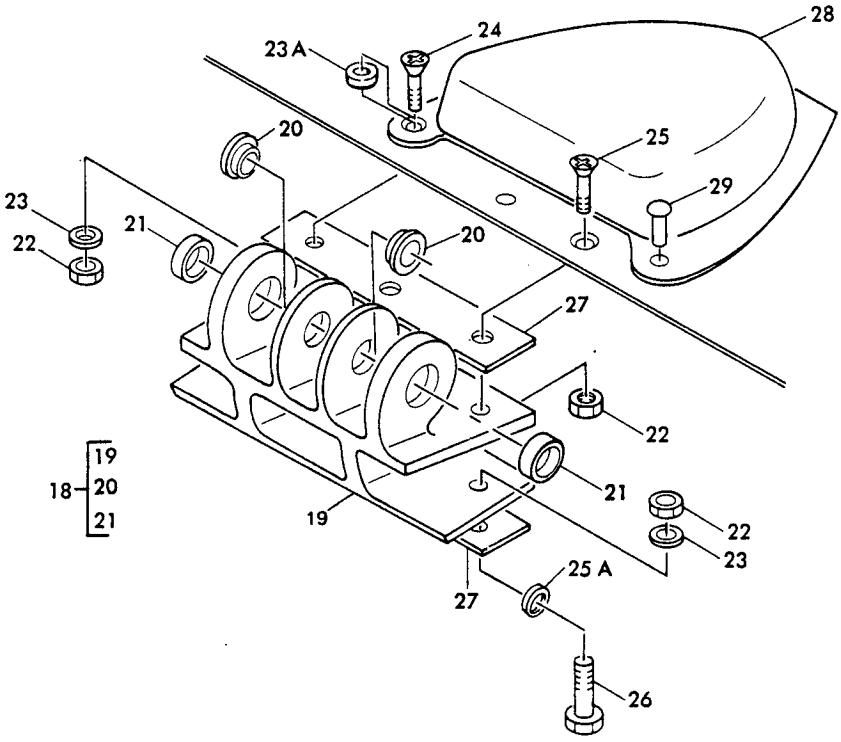
Tab Buildup and Installation
Figure 1104 (Sheet 1)



DETAIL B



DETAIL C



DETAIL D

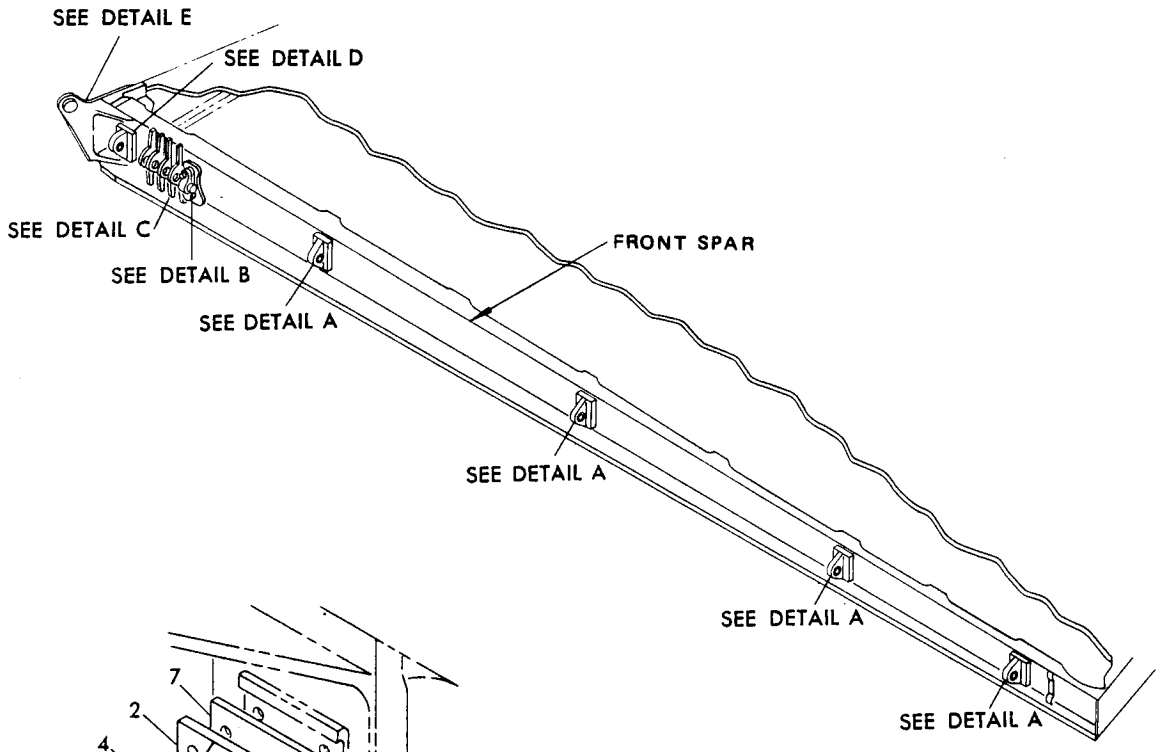
FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1104-					
	65-73799-1		TAB INSTL, ELEVATOR CONTROL, LH	A	RF
	65-73799-2		TAB INSTL, ELEVATOR CONTROL, RH	B	RF
1	BACN10JC3		. NUT		2
2	BACB30FL3-3		. BOLT *[2]		2
2	BACB30LU3-3		. BOLT *[3]		2
3	BACW10UD10		. WASHER		2
4	AN960D10		. WASHER		2
5	BACJ40A20-4		DELETED		
5	BACJ40A20-5		. JUMPER, BONDING		2
6	MS24665-132		. PIN, COTTER *[1]*[2]		4
6	MS24665-151		. PIN, COTTER *[1]*[4] (SB 55-1009)		4
6	MS24665-153		. PIN, COTTER *[1] (SB 55A1070R1)		AR
7	BACN10JC4		. NUT *[1] (POST SB 27-1056) *[5]		4
7	BACN10JD104AU		. NUT *[1] (POST SB 55-1009) *[4]		4
7	BACN10JD104		. NUT *[1] *[2]		4
7	BACN10JD4ASU		. NUT (PRE SB 55A1070R1)		AR
7	BACN11N4CS		. NUT (POST SB 55A1070R1)		AR
8	69-63391-4		. BOLT *[1] (POST SB 27-1056) *[5]*[6]		4
8	BACB30LM4CD13		. BOLT *[1] (POST SB 55-1009) *[4]		4
8	NAS1104-14D		. BOLT *[1] *[2]		4
8A	AN960PD416L		. WASHER *[4] *[5]		4
9	AN960PD416L		. WASHER *[5]		4
9	AN960PD416		. WASHER *[4]		8
9A	AN960PD416L		. WASHER *[4]		AR
10	65-73799-3		. TAB ASSY	A	1
10	65-73799-4		. TAB ASSY	B	1
10	65-73799-13		. TAB ASSY	A	1
10	65-73799-14		. TAB ASSY	B	1
10	65-73799-33		DELETED		
10	65-73799-34		DELETED		
10	65-73799-501		. TAB ASSY, (POST SB 55-1009, PRE SB 27-1056)	A	1
10	65-73799-502		. TAB ASSY, (POST SB 55-1009, PRE SB 27-1056)	B	1
10	65-73799-45		. TAB ASSY (POST SB 27-1056)	A	
10	65-73799-46		. TAB ASSY (POST SB 27-1056)	B	
10	65-73799-509		. TAB ASSY (POST SB 27-1056)	A	1
10	65-73799-510		. TAB ASSY (POST SB 27-1056)	B	1
11	69-40238-501		. . FITTING ASSY, HINGE *[1]*[5]		4
11	69-40238-3		. . FITTING ASSY *[1]*[5]		4
11	69-40238-1		. . FITTING ASSY, HINGE *[1]*[2]*[3]		4
12	69-40238-2		. . . FTG (USED ON 69-40238-1)		1
12	69-40238-4		. . . FTG (USED ON 65-40238-3)		1
12	69-40238-502		. . . FTG (USED ON 69-40238-501)		1
13	MS21209F1-15		. . . INSERT, HELICAL COIL		4

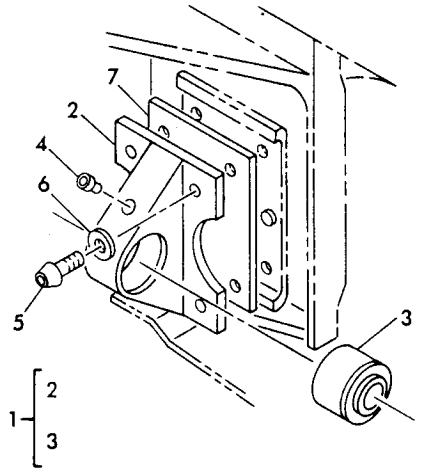
FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1104-					
14	BACB10CG4		. . . BEARING		1
14	BACB10A127		. . . BEARING (OPT TO BACB10CG4)		1
15	BACB30FL3-2		. . BOLT *[2]		16
15	BACB30LU3-2		. . BOLT *[4]*[5]		16
15A	BACW10UC10		. . WASHER (POST SB 55-1009) *[4]*[5]		16
16	BACS40A16-23		. . SHIM		AR
17	65-73799-24		. . DOUBLER *[5]		6
17	65-73799-29		. . DOUBLER (USED WITH EXTREME INBOARD HINGE FITTING ASSY) *[5]		2
18	69-40240-503		. . FITTING ASSY, MAST, LH (USED ON 65-73799-45,-509)(SB 27-1056)		1
18	69-40240-501		. . FITTING ASSY, MAST, LH (USED ON 65-73799-501,-509) *[1]		1 1
18	69-40240-5		. . FITTING ASSY, MAST, LH (USED ON 65-73799-13) *[1]		1
18	69-40240-1		. . FITTING ASSY, MAST, LH (USED ON 65-73799-3 ,-13) *[1]		1
18	69-40240-504		. . FITTING ASSY, MAST, RH (USED ON 65-73799-46,-510)(SB 27-1056)		1
18	69-40240-502		. . FITTING ASSY, MAST, RH (USED ON 65-73799-502,-510) *[1]		1
18	69-40240-6		. . FITTING ASSY, MAST, RH (USED ON 65-73799-14) *[1]		1
18	69-40240-2		. . FITTING ASSY, MAST, RH (USED ON 65-73799-4,-14) *[1]		1
19	69-40240-3		. . . FITTING, MAST (USED ON 69-40240-1,-5,-501,-503)		1
19	69-40240-4		. . . FITTING, MAST (USED ON 69-40240-2,-6,-502,-504)		1
20	BACB28W4B10		. . . BUSHING (USED ON 69-40240-1,-2)		2
20	69-56340-1		. . . BUSHING (USED ON 69-40240-5,-6)		2
20	69-56340-501		. . . BUSHING (USED ON 69-40250-501, -502,-503,-504)		2
21	NAS537B6P17		. . . BUSHING (USED ON 69-40240-1,-2, -5,-6)		2
21	69-59227-3		. . . BUSHING (USED ON 69-40250-501, -502,-503,-504)		2
22	NAS679A3W		. . NUT *[2]		6
22	BACN10JC3		. . NUT *[4]*[5]		6

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1104-					
23	AN960PD10L		. . WASHER (INSTALLED WITH 3 BOLTS LOWER SURFACE AND WITH INBOARD BOLT ON UPPER SURFACE) *[2]		4
23	AN960PD10L		. . WASHER (INSTALLED WITH 3 BOLTS LOWER SURFACE) *[4]		3
23	BACW10AW103AS		. . WASHER (INSTALLED WITH 3 BOLTS UPPER SURFACE) *[4]		3
23	AN960PD10L		. . WASHER (1 INSTALLED WITH 5 BOLTS, 2 INSTALLED WITH INBOARD BOLT ON UPPER SURFACE) *[5]		7
23A	69-59227-1		. . INSERT (INSTALLED WITH 3 BOLTS UPPER SURFACE) *[4]		3
24	BACB30FL3-6		. . BOLT (2 OUTBOARD BOLTS) *[2]		2
24	BACB30NE3-7Y		. . BOLT (3 PLACES UPPER SURFACE) *[4]		3
24	BACB30LM3-7		. . BOLT (2 OUTBOARD BOLTS) *[5]		2
25	BACB30FL3-8		. . BOLT *[2]		1
25	BACB30LM3-9		. . BOLT *[5]		1
25A	BACW10UC10		. . WASHER *[4]*[5]		3
26	BACB30FL3-4		. . BOLT *[2]		3
26	BACB30LU3-4		. . BOLT *[4]*[5]		3
27	BACS40A13-58		. . SHIM		AR
28	65-53720-3		. . FAIRING, LH (USED ON 65-73799-3)		1
28	65-53720-4		. . FAIRING, RH (USED ON 65-73799-4)		1
28	65-53720-7		. . FAIRING, LH (SB 55-1009, USED ON 65-73799-13,-501)		1
28	65-53720-8		. . FAIRING, RH (SB 55-1009, USED ON 65-73799-14,-502)		1 1
28	65-53720-501		. . FAIRING, LH (USED ON 65-73799-45,-509)		1
28	65-53720-502		. . FAIRING, RH (USED ON 65-73799-46,510)		1
29	MS20426D6		. . RIVET		1
29T	65-47589-1		REAR SPAR INSTL *[1]	C	RF
29T	65-47589-2		REAR SPAR INSTL *[1]	D	RF
29T	65-47589-19		REAR SPAR INSTL	E	RF
29T	65-47589-20		REAR SPAR INSTL	F	RF
29T	65-47589-31		REAR SPAR INSTL	G	RF
29T	65-47589-32		REAR SPAR INSTL	H	RF
30	69-41641-3		. BRACKET ASSY, HINGE (REPLS 69-41641-1,-501,-506,-507,-508)	GH	4
30	69-41641-508		. BRACKET ASSY, HINGE (SB 27-1056)	E-H	4

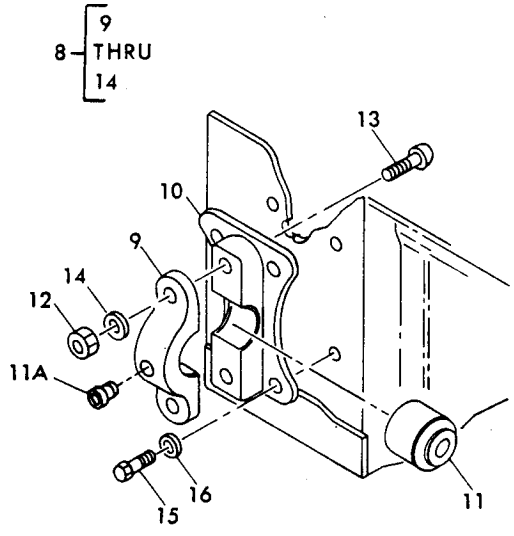
FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1104-					
30	69-41641-506		. BRACKET ASSY, HINGE *[1]	EF	4
30	69-41641-504		. BRACKET ASSY *[1]	EF	4
30	69-41641-502		. BRACKET ASSY *[1]	EF	4
30	69-41641-1		. BRACKET ASSY, HINGE (REPLD BY 69-41641-3)	CD	4
30A	69-41641-507		. BRACKET ASSY, HINGE (SB 55-1009)	EF	1
30A	69-41641-501		. BRACKET ASSY, HINGE	EF	1
31	69-41641-2		. . BRACKET, HINGE (USED ON 69-41641-1,-501,-507)		1
31	69-41641-503		. . BRACKET, HINGE (USED ON 69-41641-506,-508)		1
32	BACB28U4B012		. . BUSHING (USED ON 69-41641-1)		2
32	69-59227-2		. . BUSHING (USED ON 69-41641-501)		2
32	69-59227-2		. . BUSHING (USED ON 69-41641-506, -507,-508)		1
32A	69-59227-501		. . BUSHING (USED ON 69-41641-506, -507,-508)		1
33	BACB30NE3-7		. BOLT	C-F	16
33	BACB30NE3-10		. BOLT	GH	16
34	AN960PD10		. WASHER	C-H	16

*[1] LIMITED
*[2] USED WITH 65-73799-3, -4, -13, -14
*[3] USED WITH 65-73799-501, -502, -509, -510
*[4] USED ON 65-73799-501 and -502
*[5] USED ON 65-73799-45, -46, -509, -510
*[6] WITH BACN10JC4, ONE AN960PD416L, REPLACES BACB30LM4CD13, BACN10JD-104AU, TWO AN960PD416, AND MS24665-151

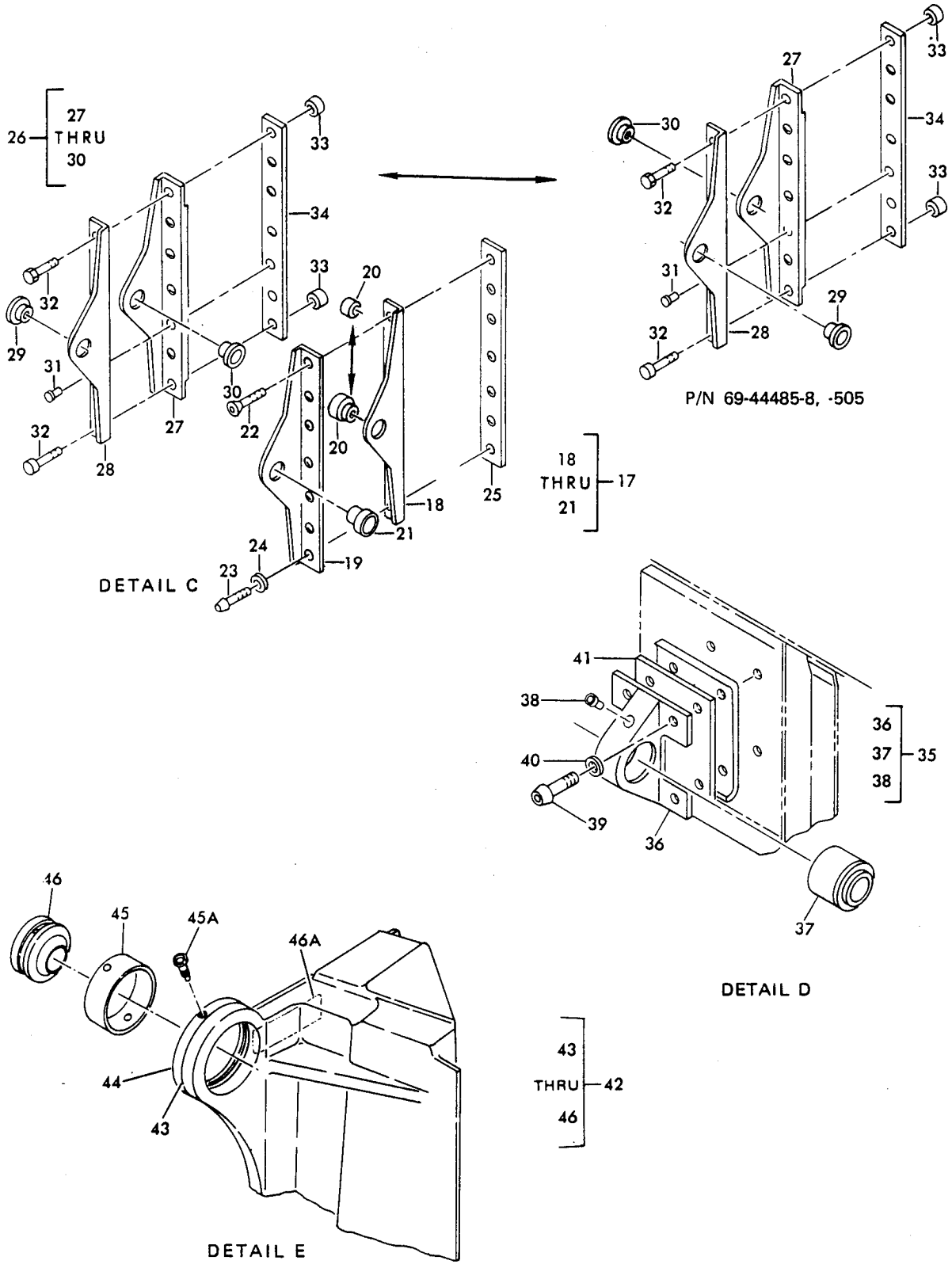




DETAIL A



DETAIL B


26 27 THRU 30
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DETAIL C
18 THRU 21 17
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P/N 69-44485-8, -505
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36 37 38 35
DETAIL D
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46A
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43 THRU 46 42
DETAIL E

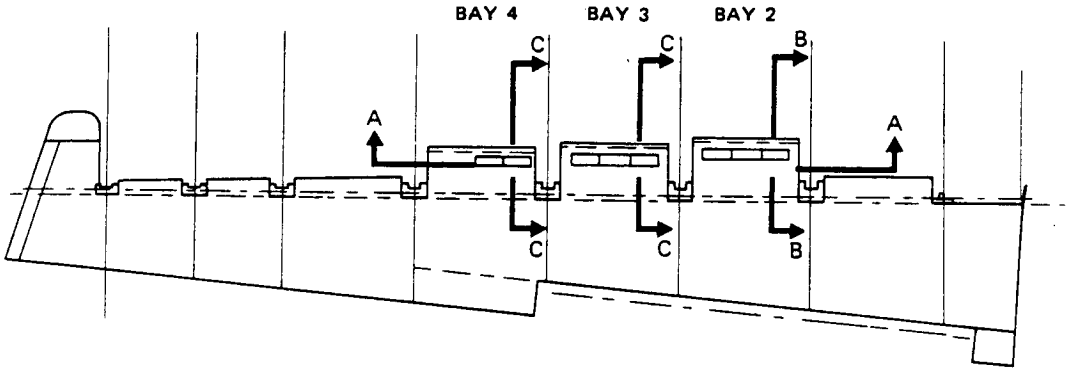
FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1105-					
	65-47588-1		FRONT SPAR INSTL, LH	A	RF
	65-47588-83		FRONT SPAR INSTL, LH	B	RF
	65-47588-2		FRONT SPAR INSTL, RH	N	RF
	65-47588-84		FRONT SPAR INSTL, RH	O	RF
1	69-40300-1		. FITTING ASSY, HINGE		4
2	69-40300-2		. . FITTING		1
3	BACB10c135H		. . BEARING (OPT TO BACB10C161GH)		1
3	BACB10C161GH		. . BEARING (OPT TO BACB10C135H)		1
4	NAS516-1		. . FITTING, LUB		1
5	MS20004-10		. BOLT		16
6	MS20002C4		. WASHER		16
7	65-47588-58		. SHIM (OPT TO 65-47588-77)		AR
7	65-47588-77		. SHIM (OPT TO 65-47588-58)		AR
8	65-53739-4		. FTG ASSY, HINGE (REPLS 65-53739-1) (POST SB 55-1017)		1
8	65-53739-1		. FTG ASSY, HINGE (REPLD BY (65-53793-4)(PRE SB 55-1017)	AN	1
9	65-53739-2		. . CAP (USED ON 65-53739-1)		1
9	65-53739-5		. . CAP (USED ON 65-53739-4)		1
10	65-53739-3		. . BASE		1
11	BACB10C85		. . BEARING		1
11A	NAS516-1		. . FITTING, LUB (USED ON 65-53739-4)		1
12	BACN10BL6L		. . NUT		2
13	MS20006-14		. . BOLT		2
14	MS20002-6		. . WASHER		2
15	BACB30CW4-10		. BOLT		4
16	MS20002C4		. WASHER		4
17	69-44485-503		. BRACKET ASSY LH *[1](SB 27-1052, 27-1056)	AB	1
17	69-44485-501		. BRACKET ASSY LH *[1]	A	1
17	69-44485-1		. BRACKET ASSY LH *[1]	A	1
17	69-44485-504		. BRACKET ASSY RH *[1](SB 27-1052, 27-1056)	NO	1
17	69-44485-502		. BRACKET ASSY RH *[1]	N	1
17	69-44485-2		. BRACKET ASSY *[1]	N	1

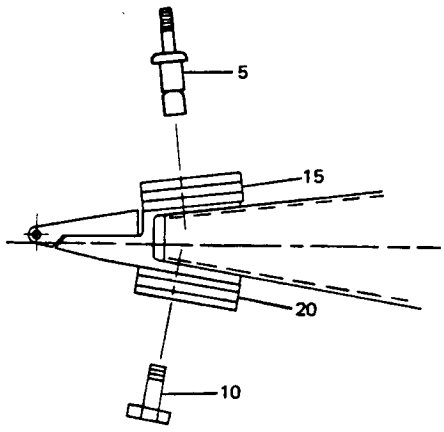
FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1105-					
18	69-44485-5		. . BRACKET		1
19	69-44485-6		. . BRACKET		1
20	69-44494-1		. . BUSHING (USED ON 69-44485-1,-2)		1
20	66-25183-2		. . BUSHING (USED ON 69-44485-501, -502)		1
20	66-25183-3		. . BUSHING (USED ON 69-44485-503, -504)		1
21	69-44494-2		. . BUSHING (USED ON 69-44485-1,-2)		1
21	69-44494-501		. . BUSHING (USED ON 69-44485-501, -502)		1
21	69-44494-502		. . BUSHING (USED ON 69-44485-503, -504)		1
22	BACB30EM4L6		. BOLT		1
23	MS20004-6		. BOLT		5
24	AN960PD416		. WASHER		5
25	BACS40R10B11		. SHIM		AR
26	69-44485-505		. BRACKET ASSY *[1](SB 27-1052, 27-1056)		1
26	69-44485-8		. BRACKET ASSY *[1]	AB	1
26	69-44485-7		. BRACKET ASSY *[1]	AB	1
27	69-44485-3		. . BRACKET		1
28	69-44485-4		. . BRACKET		1
29	69-50565-4		. . BUSHING (USED ON 69-44485-505)		1
29	69-44494-3		. . BUSHING (USED ON 65-44485-7)		1
29	69-50565-2		. . BUSHING (USED ON 65-44485-8)		1
30	69-50565-3		. . BUSHING (USED ON 69-44485-505)		1
30	69-44494-3		. . BUSHING (USED ON 65-44485-7)		1
30	69-50565-1		. . BUSHING (USED ON 65-44485-8)		1
31	MS20470D6		. RIVET		5
32	BACB30GP		. LOCKBOLT		2
33	NAS1080D		. COLLAR		2
34	BACS40R10B11		. SHIM		AR
35	69-41884-1		. FITTING ASSY, HINGE		1
36	69-41884-2		. . FITTING		1
37	BACB10C85Y		. . BEARING		1
38	NAS516-1		. . FITTING, LUB		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1105-					
39	BACB30CW4-12		. BOLT		4
40	MS20002C4		. WASHER		4
41	65-47588-62		. SHIM (OPT)		AR
41	65-47588-78		. SHIM (OPT)		AR
42	69-42978-503		. FITTING ASSY, MAST, LH *[1]	AB	1
42	69-42978-504		. FITTING ASSY, MAST, RH *[1]	NO	1
42	69-42978-501		. FITTING ASSY, MAST, LH *[1]	A	1
42	69-42978-502		. FITTING ASSY, MAST, RH *[1]	N	1
42	69-42978-505		. FITTING ASSY, MAST, LH *[1] (SB 27-1057)	A	1
42	69-42978-506		. FITTING ASSY, MAST, RH *[1] (SB 27-1057)	N	1
42	69-42978-1		. FITTING ASSY, MAST, LH *[1]	A	1
42	69-42978-2		. FITTING ASSY, MAST, RH *[1]	N	1
43	65-52930-1		. . FITTING	AB	1
43	65-52930-2		. . FITTING	NO	1
44	69-42962-3		. . DOUBLER (USED ON 69-42978-1,-501)		1
44	69-42962-4		. . DOUBLER (USED ON 69-42978-2,-502)		1
44	69-42962-501		. . DOUBLER (USED ON 69-42978-503, -505) (SB 27-1057)		1
44	69-42962-502		. . DOUBLER (USED ON 69-42978-505, -506) (SB 27-1057)		1
45	69-38919-14		. . SLEEVE (USED ON 69-42978-1,-2, -501,-502)		1
45	69-63523-1		. . SLEEVE (USED ON 69-42978-503, -504,-505,-506)(SB 27-1057)		1
45A	NAS516-1		. . FITTING, LUB (USED ON 69-42978-503,-504,-505,-506) (SB 27-1057)		1
46	DAS10-26A1-4		. . BEARING, V77896 (USED ON 69-42978-501,-502,-503,-504) (OPT TO DAS10-26A1-501)		1
46	DAS10-26A1-501		. . BEARING, V77896 (USED ON 69-42978-501, -502, -503, -504) (OPT TO DAS10-26A1-4)		1
46	YD134B		. . BEARING, V77896 (USED ON 69-42978-1,-2,-505,-506)		1
46A	BAC27DCT185		. MARKER (USED WITH 69-42978-1, -2,-505,-506)(SB 27-1045)		1
-47	MS20470D6		. RIVET		AR
-48	BACR15CE6D		. RIVET		4

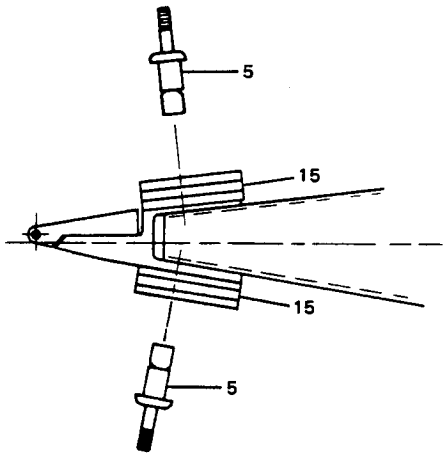
- NOT ILLUSTRATED

*[1] LIMITED USAGE

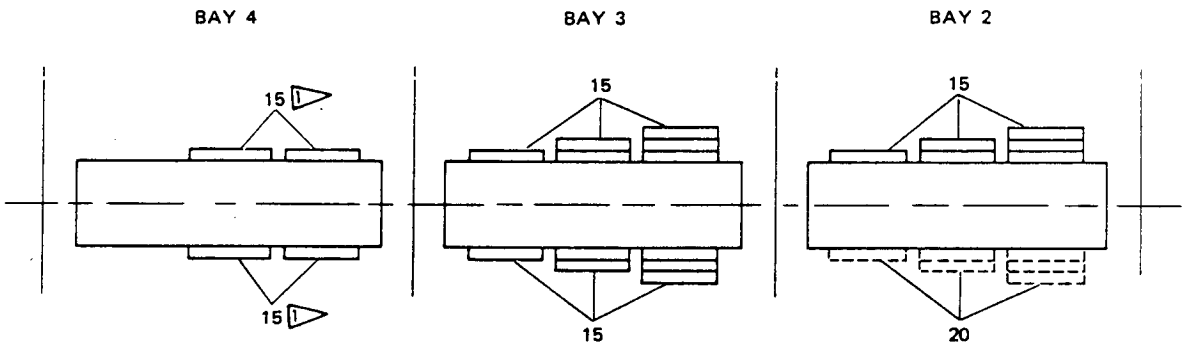




B–B



C–C



Elevator Balance Weight Installation
Figure 1106 (Sheet 2)

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1106-					
	65-60535-1		WEIGHT INSTL, ELEV BALANCE LH	A	RF
	65-60535-2		WEIGHT INSTL, ELEV BALANCE RH	B	RF
	65-60535-5		WEIGHT INSTL, ELEV BALANCE LH	C	RF
	65-60535-6		WEIGHT INSTL, ELEV BALANCE RH	D	RF
	65-60535-7		WEIGHT INSTL, ELEV BALANCE LH	E	RF
	65-60535-8		WEIGHT INSTL, ELEV BALANCE RH	F	RF
	65-60535-9		WEIGHT INSTL, ELEV BALANCE LH	G	RF
	65-60535-10		WEIGHT INSTL, ELEV BALANCE RH	H	RF
5	NAS1398B6*[1]		. RIVET, BLIND	A-D	27
5	NAS1738E6*[1]		. RIVET, BLIND (OPT)	A-D	27
5	NAS1398B6*[1]		. RIVET, BLIND	E-H	45
5	NAS1738E6*[1]		. RIVET, BLIND (OPT)	E-H	45
10	BACB30NF3*[1]		. BOLT		9
15	69-53211-1		. WEIGHT *[2]	AB	18
15	69-53211-1		. WEIGHT *[2]	CD	12
15	69-53211-1		. WEIGHT *[2]	E-H	22
20	69-53223-1		. WEIGHT *[2], BAY 2, LWR		6

*[1] Grip length of blind rivets and bolts depends upon number of balance weights used. Use this table as a guide:

NO. OF BALANCE WEIGHTS USED	RIVET TO USE	BOLT TO USE
NONE	NAS1398B5-3 OR NAS1398B6-3	BACB30NF3-2
1	NAS1398B6-5	BACB30NF3-4
2	NAS1398B6-8	BACB30NF3-7
3	NAS1398B6-10	BACB30NF3-10

NAS1738E6 OPT TO NAS1398B6

*[2] Quantity of weights listed is maximum number that may be installed. Actual quantity used will be determined by static balance of elevator.

VENDORS

V08935	GRANGER ASSOCIATES, 3101 SCOTT BLVD., SANTA CLARA, CALIFORNIA 95054-3394
V11815	TEXTRON, INC., 1224 E. WARNER AVE., SANTA ANA, CALIFORNIA 92707
V77896	REXNORD INDUSTRIES, INC., BEARING OPERATIONS, 2400 CURTISS ST., DOWNERS GROVE, ILLINOIS 60515-0722

Part No.	Fig. and Index No.	Qty. per Assy.
AN960D10	1104-4	2
AN960PD10	1104-34	16
AN960PD10L	1104-23	3
AN960PD10L	1104-23	4
AN960PD10L	1104-23	7
AN960PD416	1104-9	8
AN960PD416	1105-24	5
AN960PD416L	1104-8A	4
AN960PD416L	1104-9	4
AN960PD416L	1104-9A	AR
BAC27DCT185	1105-46A	1
BACB10A127	1104-14	1
BACB10c135H	1105-3	1
BACB10C161GH	1105-3	1
BACB10C85	1105-11	1
BACB10C85Y	1105-37	1
BACB10CG4	1104-14	1
BACB28U4B012	1104-32	2
BACB28W4B10	1104-20	2
BACB30CW4-10	1105-15	4
BACB30CW4-12	1105-39	4
BACB30EM4L6	1105-22	1
BACB30FL3-2	1104-15	16
BACB30FL3-3	1104-2	2
BACB30FL3-4	1104-26	3
BACB30FL3-6	1104-24	2
BACB30FL3-8	1104-25	1
BACB30GP	1105-32	2
BACB30LM3-7	1104-24	2
BACB30LM3-9	1104-25	1
BACB30LM4CD13	1104-8	4
BACB30LU3-1	1103-19	32
BACB30LU3-1	1103-22	4
BACB30LU3-1	1103-25	4
BACB30LU3-2	1103-10	80
BACB30LU3-2	1103-5	12
BACB30LU3-2	1104-15	16
BACB30LU3-3	1102-2	13
BACB30LU3-3	1102-4	12
BACB30LU3-3	1102-8	18
BACB30LU3-3	1103-21	*[1]
BACB30LU3-3	1103-24	*[2]
BACB30LU3-3	1103-27	3
BACB30LU3-3	1103-29	2
BACB30LU3-3	1104-2	2
BACB30LU3-4	1102-10	1
BACB30LU3-4	1102-5	1
BACB30LU3-4	1103-44	17

Part No.	Fig. and Index No.	Qty. per Assy.
BACB30LU3-4	1104-26	3
BACB30LU4-4	1102-6	2
BACB30NE3-10	1104-33	16
BACB30NE3-2	1103-58	9
BACB30NE3-3	1103-57	46
BACB30NE3-4	1103-42	4
BACB30NE3-5	1103-41	*[4]
BACB30NE3-6	1103-40	2
BACB30NE3-7	1103-39	1
BACB30NE3-7	1104-33	16
BACB30NE3-7Y	1104-24	3
BACB30NE3-8	1103-38	1
BACB30NE3-9	1103-37	2
BACB30NF3*[1]	1106-10	18
BACF33C101-075D	1103-36	7
BACI12M06-2	1101-17	1
BACJ40A20-4	1104-5	
BACJ40A20-5	1104-5	2
BACN10BL6L	1105-12	2
BACN10JC3	1104-1	2
BACN10JC3	1104-22	6
BACN10JC4	1104-7	4
BACN10JD104	1104-7	4
BACN10JD104AU	1104-7	4
BACN10JD4ASU	1104-7	AR
BACN10JR3F	1103-60	25
BACN10KB3F	1103-61	30
BACN11N4CS	1104-7	AR
BACR15CE6D	1105-48	4
BACS40A13-58	1104-27	AR
BACS40A16-23	1104-16	AR
BACS40R10B11	1105-25	AR
BACS40R10B11	1105-34	AR
BACW10AW103AS	1104-23	3
BACW10P44AL	1103-59	55
BACW10UC10	1102-9	8
BACW10UC10	1104-15A	16
BACW10UC10	1104-25A	3
BACW10UC8	1101-10	4
BACW10UD10	1104-3	2
CR2238-5-3	1101-9	4
DAS10-26A1-4	1105-46	1
DAS10-26A1-501	1105-46	1
MS20002-6	1105-14	2
MS20002C4	1105-16	4
MS20002C4	1105-40	4
MS20002C4	1105-6	16
MS20004-10	1105-5	16

Part No.	Fig. and Index No.	Qty. per Assy.
MS20004-6	1105-23	5
MS20006-14	1105-13	2
MS20426A4	1101-6	1
MS20426A4-2	1101-15	2
MS20426B4-2	1102-7H	2
MS20426B4-2	1102-7M	2
MS20426D3	1103-62	110
MS20426D6	1104-29	1
MS20470D6	1102-12	AR
MS20470D6	1105-31	5
MS20470D6	1105-47	AR
MS21209F1-15	1104-13	4
MS24665-132	1103-4	1
MS24665-132	1103-9	1
MS24665-132	1104-6	4
MS24665-151	1104-6	4
MS24665-153	1104-6	AR
NAS1080D	1105-33	2
NAS1104-14D	1104-8	4
NAS1398B6*[1]	1106-5	27
NAS1398B6*[1]	1106-5	45
NAS1399MW5-3	1101-16	4
NAS1738E6*[1]	1106-5	45
NAS1738E6*[1]	1106-5	9
NAS514P632-5	1101-7	1
NAS516-1	1105-11A	1
NAS516-1	1105-38	1
NAS516-1	1105-4	1
NAS516-1	1105-45A	1
NAS537B6P17	1104-21	2
NAS679A3W	1104-22	6
YD134B	1105-46	1
10-60754-104	1103-32	1
10-60754-105	1103-35	1
2-13	1101-18	1
2-13	1102-14	1
2-13S	1101-18	1
2-13S	1102-14	1
2-14	1102-13	1
610-1009	1101-17U	1
610-1009	1101-8	1
610-1009	1102-7D	1
610-1011	1101-18	1
610-1011	1102-14	1
610D1B	1101-18	1
610D1B	1102-14	1
611-1006	1102-7C	1
611-1008	1102-13	1

Part No.	Fig. and Index No.	Qty. per Assy.
611D1B	1102-13	1
65-47588-1	1101-4	1
65-47588-1	1105-	RF
65-47588-2	1101-4	1
65-47588-2	1105-	RF
65-47588-58	1105-7	AR
65-47588-62	1105-41	AR
65-47588-77	1105-7	AR
65-47588-78	1105-41	AR
65-47588-83	1101-4	1
65-47588-83	1105-	RF
65-47588-84	1101-4	1
65-47588-84	1105-	RF
65-47589-1	1101-4A	1
65-47589-1	1104-29T	RF
65-47589-19	1101-4A	1
65-47589-19	1104-29T	RF
65-47589-2	1101-4A	1
65-47589-2	1104-29T	RF
65-47589-20	1101-4A	1
65-47589-20	1104-29T	RF
65-47589-31	1101-4A	1
65-47589-31	1104-29T	RF
65-47589-32	1101-4A	1
65-47589-32	1104-29T	RF
65-52930-1	1105-43	1
65-52930-2	1105-43	1
65-53713-1	1101-5	1
65-53713-2	1101-5	1
65-53713-503	1101-12	1
65-53713-504	1101-12	1
65-53713-505	1101-13	1
65-53713-506	1101-14	1
65-53713-71	1101-11	1
65-53713-75	1101-5	1
65-53713-76	1101-5	1
65-53713-93	1101-5	1
65-53713-94	1101-5	1
65-53716-1	1101-2C	1
65-53716-1	1103-	RF
65-53716-10	1103-20	1
65-53716-19	1103-26	1
65-53716-2	1101-2C	1
65-53716-2	1103-	RF
65-53716-20	1103-26	1
65-53716-21	1103-28	1
65-53716-23	1103-23	1
65-53716-24	1103-23	1

Part No.	Fig. and Index No.	Qty. per Assy.
65-53716-3	1103-20	1
65-53716-3	1103-23	1
65-53716-4	1103-20	1
65-53716-4	1103-23	1
65-53716-7	1101-2C	1
65-53716-7	1103-	RF
65-53716-8	1101-2C	1
65-53716-8	1103-	RF
65-53716-9	1103-20	1
65-53720	1101-2F	1
65-53720-1	1103-43	1
65-53720-2	1103-43	1
65-53720-3	1104-28	1
65-53720-4	1104-28	1
65-53720-5	1103-43	1
65-53720-501	1104-28	1
65-53720-502	1104-28	1
65-53720-6	1103-43	1
65-53720-7	1104-28	1
65-53720-8	1104-28	1
65-53721-1	1101-2B	1
65-53721-1	1103-	RF
65-53721-10	1103-18	
65-53721-11	1103-17	1
65-53721-12	1103-18	1
65-53721-2	1101-2B	1
65-53721-2	1103-	RF
65-53721-3	1103-11	2
65-53721-4	1103-12	2
65-53721-5	1103-13	2
65-53721-6	1103-14	2
65-53721-7	1103-15	2
65-53721-8	1103-16	2
65-53721-9	1103-17	
65-53722-1	1102-1	1
65-53722-501	1102-1	1
65-53723-1	1102-3	1
65-53723-10	1102-7B	1
65-53723-11	1102-7A	1
65-53723-12	1102-7A	1
65-53723-13	1102-7	1
65-53723-14	1102-7	1
65-53723-15	1102-7	1
65-53723-16	1102-7	1
65-53723-502	1102-7F	1
65-53723-503	1102-7	1
65-53723-504	1102-7	1
65-53723-505	1102-7E	1

Part No.	Fig. and Index No.	Qty. per Assy.
65-53723-506	1102-7E	1
65-53723-507	1102-7J	1
65-53723-508	1102-7J	1
65-53723-509	1102-7G	1
65-53723-510	1102-7G	1
65-53723-511	1102-7L	1
65-53723-512	1102-7L	1
65-53723-513	1102-7K	1
65-53723-519	1102-3	1
65-53723-9	1102-7B	1
65-53725-3	1102-11	1
65-53728-1	1101-2E	1
65-53728-1	1103-45	RF
65-53728-10	1103-51	1
65-53728-11	1103-52	1
65-53728-12	1103-53	1
65-53728-13	1103-54	1
65-53728-14	1103-55	1
65-53728-2	1101-2E	1
65-53728-2	1103-45	RF
65-53728-3	1103-46	2
65-53728-4	1103-47	2
65-53728-5	1103-48	2
65-53728-6	1103-49	3
65-53728-9	1103-50	1
65-53729-1	1101-1	1
65-53729-1	1102-	RF
65-53729-2	1101-1	1
65-53729-2	1102-	RF
65-53729-21	1101-1	1
65-53729-21	1102-	RF
65-53729-22	1101-1	1
65-53729-22	1102-	RF
65-53729-23	1101-1	1
65-53729-23	1102-	RF
65-53729-24	1101-1	1
65-53729-24	1102-	RF
65-53729-27	1101-1	1
65-53729-27	1102-	RF
65-53729-28	1101-1	1
65-53729-28	1102-	RF
65-53739-1	1105-8	1
65-53739-2	1105-9	1
65-53739-3	1105-10	1
65-53739-4	1105-8	1
65-53739-5	1105-9	1
65-58128-15	1101-17T	1
65-58128-15	1102-12T	1

Part No.	Fig. and Index No.	Qty. per Assy.
65-58128-16	1101-17T	1
65-58128-16	1102-12T	1
65-58128-2	1101-17T	1
65-60535-1	1101-3A	1
65-60535-1	1106-	RF
65-60535-10	1101-3A	1
65-60535-10	1106-	27
65-60535-2	1101-3A	1
65-60535-2	1106-	RF
65-60535-5	1101-3A	1
65-60535-5	1106-	RF
65-60535-6	1101-3A	1
65-60535-6	1106-	RF
65-60535-7	1101-3A	1
65-60535-7	1106-	RF
65-60535-8	1101-3A	1
65-60535-8	1106-	RF
65-60535-9	1101-3A	1
65-60535-9	1106-	RF
65-65548-1	1101-2D	1
65-65548-1	1103-29A	RF
65-65548-10	1103-35	2
65-65548-11	1103-32	1
65-65548-12	1103-35	1
65-65548-13	1101-2D	1
65-65548-13	1103-29A	RF
65-65548-14	1101-2D	1
65-65548-14	1103-29A	RF
65-65548-2	1101-2D	1
65-65548-2	1103-29A	RF
65-65548-3	1103-30	1
65-65548-4	1103-30	1
65-65548-5	1103-31	1
65-65548-6	1103-31	1
65-65548-7	1103-33	1
65-65548-8	1103-34	1
65-65548-9	1103-32	2
65-69623-1	1101-2D	1
65-69623-1	1103-29A	RF
65-69623-2	1101-2D	1
65-69623-2	1103-29A	RF
65-73784-1	1101-	RF
65-73784-10	1101-	RF
65-73784-11	1101-	RF
65-73784-12	1101-	RF
65-73784-13	1101-	RF
65-73784-14	1101-	RF
65-73784-15	1101-	RF

Part No.	Fig. and Index No.	Qty. per Assy.
65-73784-16	1101-	RF
65-73784-17	1101-	RF
65-73784-18	1101-	RF
65-73784-19	1101-	RF
65-73784-2	1101-	RF
65-73784-20	1101-	RF
65-73784-21	1101-	RF
65-73784-22	1101-	RF
65-73784-23	1101-	RF
65-73784-24	1101-	RF
65-73784-27	1101-	RF
65-73784-28	1101-	RF
65-73784-29	1101-	RF
65-73784-30	1101-	RF
65-73784-31	1101-	RF
65-73784-32	1101-	RF
65-73784-33	1101-	RF
65-73784-34	1101-	RF
65-73784-35	1101-	RF
65-73784-36	1101-	RF
65-73784-37	1101-	RF
65-73784-38	1101-	RF
65-73784-39	1101-	RF
65-73784-40	1101-	RF
65-73784-41	1101-	RF
65-73784-42	1101-	RF
65-73784-43	1101-	RF
65-73784-44	1101-	RF
65-73784-5	1101-	RF
65-73784-6	1101-	RF
65-73784-7	1101-	RF
65-73784-8	1101-	RF
65-73784-9	1101-	RF
65-73799-1	1101-3	1
65-73799-1	1104-	RF
65-73799-13	1104-10	1
65-73799-14	1104-10	1
65-73799-2	1101-3	1
65-73799-2	1104-	RF
65-73799-24	1104-17	6
65-73799-29	1104-17	2
65-73799-3	1104-10	1
65-73799-33	1104-10	
65-73799-34	1104-10	
65-73799-4	1104-10	1
65-73799-45	1104-10	
65-73799-46	1104-10	
65-73799-501	1104-10	1

Part No.	Fig. and Index No.	Qty. per Assy.
65-73799-502	1104-10	1
65-73799-509	1104-10	1
65-73799-510	1104-10	1
66-25183-2	1105-20	1
66-25183-3	1105-20	1
69-22297-10	1103-56	3
69-38919-14	1105-45	1
69-40238-1	1104-11	4
69-40238-2	1104-12	1
69-40238-3	1104-11	4
69-40238-4	1104-12	1
69-40238-501	1104-11	4
69-40238-502	1104-12	1
69-40240-1	1104-18	1
69-40240-2	1104-18	1
69-40240-3	1104-19	1
69-40240-4	1104-19	1
69-40240-5	1104-18	1
69-40240-501	1104-18	1
69-40240-502	1104-18	1
69-40240-503	1104-18	1
69-40240-504	1104-18	1
69-40240-6	1104-18	1
69-40241-1	1101-2	8
69-40241-1	1103-	RF
69-40241-2	1103-6	8
69-40241-3	1103-3	1
69-40241-3	1103-8	1
69-40241-5	1103-7	1
69-40300-1	1105-1	4
69-40300-2	1105-2	1
69-41641-1	1104-30	4
69-41641-2	1104-31	1
69-41641-3	1104-30	4
69-41641-501	1104-30A	1
69-41641-502	1104-30	4
69-41641-503	1104-31	1
69-41641-504	1104-30	4
69-41641-506	1104-30	4
69-41641-507	1104-30A	1
69-41641-508	1104-30	4
69-41884-1	1105-35	1
69-41884-2	1105-36	1
69-42962-3	1105-44	1
69-42962-4	1105-44	1
69-42962-501	1105-44	1
69-42962-502	1105-44	1
69-42978-1	1105-42	1

Part No.	Fig. and Index No.	Qty. per Assy.
69-42978-2	1105-42	1
69-42978-501	1105-42	1
69-42978-502	1105-42	1
69-42978-503	1105-42	1
69-42978-504	1105-42	1
69-42978-505	1105-42	1
69-42978-506	1105-42	1
69-44485-1	1105-17	1
69-44485-2	1105-17	1
69-44485-3	1105-27	1
69-44485-4	1105-28	1
69-44485-5	1105-18	1
69-44485-501	1105-17	1
69-44485-502	1105-17	1
69-44485-503	1105-17	1
69-44485-504	1105-17	1
69-44485-505	1105-26	1
69-44485-6	1105-19	1
69-44485-7	1105-26	1
69-44485-8	1105-26	1
69-44494-1	1105-20	1
69-44494-2	1105-21	1
69-44494-3	1105-29	1
69-44494-3	1105-30	1
69-44494-501	1105-21	1
69-44494-502	1105-21	1
69-45461-1	1101-2A	1
69-45461-1	1103-	RF
69-45461-2	1103-1	1
69-45461-3	1103-3	1
69-45461-4	1103-2	1
69-50565-1	1105-30	1
69-50565-2	1105-29	1
69-50565-3	1105-30	1
69-50565-4	1105-29	1
69-53211-1	1106-15	12
69-53211-1	1106-15	22
69-53211-1	1106-15	6
69-53223-1	1106-20	6
69-55912-3	1103-30	1
69-55912-4	1103-30	1
69-55912-6	1103-33	1
69-55994-1	1101-2	8
69-55994-1	1103-	RF
69-55994-2	1101-2A	1
69-55994-2	1103-	RF
69-55994-3	1103-6	8
69-55994-4	1103-1	1

Part No.	Fig. and Index No.	Qty. per Assy.
69-55994-5	1103-7	1
69-55994-6	1103-2	1
69-56340-1	1104-20	2
69-56340-501	1104-20	2
69-59227-1	1104-23A	3
69-59227-2	1104-32	1
69-59227-2	1104-32	2
69-59227-3	1104-21	2
69-59227-501	1104-32A	1
69-63391-4	1104-8	4
69-63523-1	1105-45	1

Part No.	Fig. and Index No.	Qty. per Assy.