

**BOEING**   
**COMMERCIAL JET**  
**OVERHAUL MANUAL**

TO: ALL HOLDERS OF ENGINE MOUNT SUPPORT BRACKET ASSEMBLY OVERHAUL MANUAL,  
 57-40-13

REVISION NO. 0, DATED JUL 5/81

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
Released new manual covering 65-50706 Support Bracket Assemblies, incorporating PRR 32649													

# ENGINE MOUNT SUPPORT BRACKET ASSEMBLY

## 57-40-13

BOEING P/N 65-50706-1,-2,-5 thru -8, -23 thru -26, -29 thru -32

AIRLINE P/N

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THE FOLLOWING DIRECTIVES APPLY TO THIS SUBJECT:

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVES	DATE DIRECTIVE INCORPORATED INTO TEXT
		PRR 32649	Jul 5/81

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* Indicates pages revised, added or deleted in latest revision					
F Indicates foldout pages - print one side only					
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ENGINE MOUNT SUPPORT BRACKET ASSEMBLY

1. DESCRIPTION AND OPERATION

- A. The engine mount support bracket assembly is bolted to the wing front spar. It transfers engine forces to the wing structure.
- B. Leading particulars (approximate)
  - Width -- 3 inches
  - Length -- 6 inches
  - Height -- 11 inches
  - Weight -- 10 pounds

2. INSPECTION/CHECK (Fig. 1)

- A. Perform penetrant examination of bracket (20) and bronze bushings (69-37867-30, -33, -35) per 20-20-02
- B. Perform magnetic particle examination of CRES bushings (69-37867-46, -47, -48, -71) per 20-20-01.

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3. REPAIR (Fig. 1)

A. Materials

- (1) primer -- BMS 10-11, type 1 (Ref 20-60-02)

B. Refinish

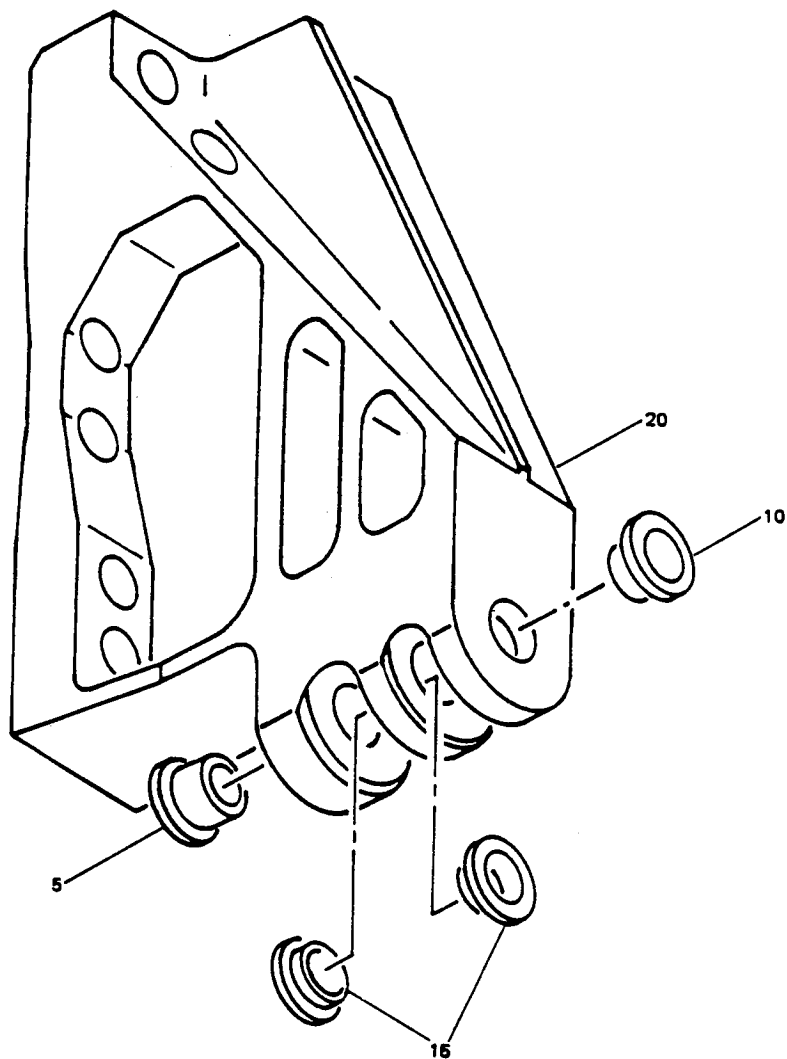
NOTE: Refer to 20-30-02 for stripping of protective finishes and to 20-41-01 for explanation of F finish codes.

- (1) Bushings (5,10,15; 69-38767-30, -33, -35) -- cadmium plate per 20-42-05 Type 2, class 2 (F-4.201) Material: Al-Ni-Bronze.
- (2) Bushings (5,10,15; 69-38767-46, -47, -48, -71) -- Cadmium plate per 20-42-05 Type 2, class 2 (F-1.1929). Material: CRES 17-4PH, 180-200 ksi.
- (3) Bracket (20) -- Chromic acid anodize per 20-43-01 (F-17.02) and apply one coat primer all over except in holes (F-20.02).  
Material: Al alloy.

C. Replacement

- (1) Bushings (5, 10, 15)
- (a) If necessary to replace bushings in bracket (20), install new bushings with wet primer, using shrink-fit method per 20-50-03.
- (b) Line machine bushings to 0.8175-0.8190 diameter, in line within 0.0005 inch. Maintain 63-microinch finish.

4. ILLUSTRATED PARTS LIST



Engine Mount Support Bracket Assembly  
Figure 1

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FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	N O M E N C L A T U R E							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
1-	65-50706-1									A	RF
	65-50706-2									B	RF
	65-50706-5									C	RF
	65-50706-6									D	RF
	65-50706-7									E	RF
	65-50706-8									F	RF
	65-50706-23									G	RF
	65-50706-24									H	RF
	65-50706-25									I	RF
	65-50706-26									J	RF
	65-50706-29									K	RF
	65-50706-30									L	RF
	65-50706-31									M	RF
	65-50706-32									N	RF
5	69-37867-30									. A-H	1
5	69-37867-46									. IJ	1
5	69-37867-71									. K-N	1
10	69-37867-33									. A-H	1
10	69-37867-47									. I-N	1
15	69-37867-35									. A-H	2
15	69-37867-48									. I-N	2
20	65-50706-3									. A	1
20	65-50706-4									. B	1
20	65-50706-9									. C	1
20	65-50706-10									. D	1
20	65-50706-11									. E	1
20	65-50706-12									. F	1
20	65-50706-17									. GI	1
20	65-50706-18									. HJ	1
20	65-50706-27									. K	1
20	65-50706-28									. L	1
20	65-50706-33									. M	1
20	65-50706-34									. N	1