TO: ALL HOLDERS OF MAIN LANDING GEAR BEAM INSTALLATION COMPONENTS OVERHAUL MANUAL, 57-41-01

REVISION NO. 15, DATED NOV 1/07

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
Updated oversize repair value					X								

MAIN LANDING GEAR BEAM INSTALLATION COMPONENTS

57-41-01

BOEING P/N 65-46401-1, -2, -7, -8, -15, -16, -19, -20, -23, -24, -27, -28, -33, -34, -37 thru -44, -69 thru -74
65-49442-1, -2, -7, -8
65-52235-1, -2, -7 thru -10, -15, -16, -27 thru -32, -35, -36, -38
65-67172-1, -2, -5, -6, -13, -14, -17, -18, -23 thru -26, -29, -30, -33, -34
65-82764-1, -2, -15, -16, -19, -20, -21, -22, -27, -28, -31, -32, -35, -36, -39, -40
65C32102-7, -8
65C32697-5, -7
65C32699-1, -2
65C32918-1, -2, -7, -8, -17 thru -20

AIRLINE P/N

THE FOLLOWING DIRECTIVES APPLY TO THIS SUBJECT

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVES	DATE DIRECTIVE INCORPORATED INTO TEXT
57-1071		PRR 32134	Jul 5/77
		PRR 32206	Jul 5/77
57-1073		PRR 32070-6	Dec 1/94
		PRR 32070-6R	Dec 1/94
		PRR 34103-1	Mar 5/87
	57-22		Sep 1/94
		PRR 35005-80	Dec 1/94
57-1073R4			Dec 1/94
		PRR 35155	Mar 1/96

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
57-41-01			12	Jul 1/02		
	T-1	Jul 1/02	13	Nov 1/99		
	T-2	BLANK	14	Nov 1/99		
*	LEP-1	Nov 1/07	15	Nov 1/99		
	LEP-2	BLANK	16	Nov 1/99		
	T/C-1	Nov 1/99	16A	Nov 1/99		
	T/C-2	BLANK	16B	BLANK		
	1	Mar 1/05	17	Nov 1/99		
	2	Mar 1/05	18	Nov 1/99		
	2A	Mar 1/05	19	Nov 1/99		
	2B	Mar 1/05	20	Nov 1/99		
	2C	Mar 1/05	21	Jul 1/00		
	2D	Mar 1/05	22	BLANK		
	2E	Mar 1/05	23	Nov 1/99		
	2F	BLANK	24	Nov 1/99		
	3	Nov 1/99	25	Nov 1/99		
	4	Mar 1/02	26	Nov 1/99		
	4A	Jul 1/02	27	Nov 1/99		
	4B	Mar 1/02	28	Nov 1/99		
	4C	Nov 1/99	29	Nov 1/99		
	4D	Mar 1/02	30	Nov 1/99		
	4E	Mar 1/02	31	Nov 1/99		
	4F	Mar 1/02	32	Nov 1/99		
	4G	Mar 1/00	33	Mar 1/00		
*	4H	Nov 1/07	34	Mar 1/00		
	4I	Mar 1/02	35	Mar 1/00		
	4J	Jul 1/02	36	Mar 1/00		
	4K	Jul 1/02	37	Mar 1/00		
	4L	Jul 1/02	38	Jul 1/02		
	4M	Jul 1/02	39	Jul 1/02		
	4N	Jul 1/02	40	Jul 1/02		
	4O	Mar 1/05	41	Jul 1/02		
	4P	Jul 1/02	42	Jul 1/02		
	5	Nov 1/99	43	Jul 1/02		
	6	Nov 1/99	44	Jul 1/02		
	7	Nov 1/99	45	Jul 1/02		
	8	Nov 1/99	46	BLANK		
	9	Nov 1/99				
	10	Jul 1/02				
	10A	Nov 1/99				
	10B	Nov 1/99				
	10C	Jul 1/02				
	10D	BLANK				
	11	Nov 1/99				

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*[1] Special instructions are not required. Use standard industry practices.

*[2] Also refer to the instructions in SOPM 20-30-03.

*[3] Also refer to the instructions in SOPM 20-44-02 and 20-10-01.

MAIN LANDING GEAR BEAM INSTALLATION COMPONENTS

1. DESCRIPTION AND OPERATION

A. This manual includes some parts of the main landing gear beam installation, such as beam assemblies, stabilizer assemblies, and stabilizing fitting assemblies. Overhaul functions which cannot be done by standard industry practices are included in the repair instructions for each component.

2. INSPECTION/CHECK

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

B. Magnetic particle examine (SOPM 20-20-01)

(1) IPL Fig. 6: lock plate (10) (69-63566-1), nuts (45, 110), retainer (135)

(2) IPL Fig. 8: lock plates (10, 10L), nut (30, 95), retainer (120)

C. Penetrant examine (SOPM 20-20-02)

(1) IPL Fig. 6: block (40), beam (145)

(2) IPL Fig. 7: beam (80)

(3) IPL Fig. 8: bond assembly (130), bushings (170, 175), sleeve (180)

(4) IPL Fig. 9: fitting (5)

(5) IPL Fig. 10: stabilizer (5)

(6) IPL Fig. 11: fitting (5)

(7) IPL Fig. 12: link (5)

(8) IPL Fig. 13: fitting (5)

(9) IPL Fig. 14: fitting (5)

D. Ultrasonic examine or eddy current examine in and around the bores of the inner and outer attach lugs and the trunnion mounting bore of beam (145, Fig. 6) and (80, Fig. 7).

3. REPAIR

A. Materials

NOTE: Equivalent substitutes can be used.

(1) Sealant -- BMS 5-95 (SOPM 20-60-04)

(2) Primer -- BMS 10-11, Type 1 (SOPM 20-60-02)

(3) Teflon Coating -- BMS 10-86 (SOPM 20-60-02)

B. Lug Holes

(1) 65-46401 beams Pre SB 57-1071 (Fig. 3)

(a) Machine lug holes oversize as required to remove defects.

(b) Install oversize bushings (71, 72) or (73, 74) (Refer to SB 57-1071).

(c) Machine (hone) to design dimensions and finish.

(2) Fittings (65-49442, 65-67172, 65C37918), stabilizer (65-52235), link (65C32697) (Fig. 1A, 1B, 1D, 1F, 1H)

(a) Machine lug holes as required, within repair limits, to remove defects.

(b) Make repair sleeves (Fig. 1J) or oversize bushings (Fig. 1K, 1L) to adjust for the material removed.

(c) Install the sleeves or bushings by the shrink fit method of SOPM 20-50-03 with wet BMS 5-95 sealant.

C. Lug faces (Fig. 1A, 1B, 1D, 1F)

(1) Spotface, machine or blend out defects within repair limits. If spotfaced, make the corner radius 0.06-0.09 inch.

(2) Penetrant examine per SOPM 20-20-02.

(3) Shot peen (if applicable) as indicated.

(4) Refinish as indicated.

(5) If you removed more than 0.005 inch from the lug face, make a repair shim per Fig. 1I and install it with BMS 5-95 sealant.

D. 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. 6 Parts

(a) Lock plate (10)

1) (69-63566-1) -- Cadmium-titanium plate (F-15.01). Apply BMS 10-11, Type 1 primer (F-20.02). Material: 4340 steel, 180-200 ksi.

2) (69-65315-1, -2) -- Cadmium plate and apply BMS 10-11, Type 1 primer (F-16.01). Material: 301 CRES.

(b) Radius block (40) -- Chemical treat or chromic acid anodize and apply primer BMS 10-11, Type 1 (F-18.05). Material: Al alloy.

(c) Nut (45) -- Cadmium-titanium plate (F-15.01), 0.0003-0.0005 thick. Material: 4340M steel, 220-240 steel.

(d) Washer (50) -- Cadmium plate and apply BMS 10-11, Type 1 primer (F-16.01, which replaces F-16.02). Material: 17-7PH CRES, 150-170 ksi.

(e) Reservoir (70) -- Passivate (F-8.07). Material: 17-4PH CRES.

(f) Bolt (95) -- Passivate (F-8.07). Material: A286 CRES.

(g) Lock (105) -- Passivate (F-8.07). Material: 15-5PH or 17-4PH CRES.

(h) Nut (110) -- Passivate (F-17.25, which replaces F-17.09). Material: 15-5PH CRES, 180-200 ksi.

(i) Retainer (135) -- Cadmium plate (F-15.02). Apply BMS 10-11, Type 1 primer (F-20.03), but not in splines or in tapped holes. Material: 17-4PH CRES, 150-170 ksi.

(j) Beam assembly (145) -- Fig. 1

(2) Fig. 7 Parts

(a) Beam (80) -- Chemical treat or chromic acid anodize and apply BMS 10-11, Type 1 primer (SRF-2.30). Material: Al Alloy.

(b) Retaining ring assembly (130, 145) -- Apply BMS 10-11, Type 1 primer (SRF-12.206) on the surface opposite studs. Material: 321 or 347 CRES.

(3) Fig. 8 Parts

(a) Lock Plate (10, 10L) -- Cadmium plate (F-15.06). Apply BMS 10-11, Type 1 primer (F-20.02). Material 15-5PH CRES, 180-200 ksi.

(b) Nut (30) -- Apply BMS 3-8 solid film lubricant (F-19.10). Material: 15-5PH CRES, 180-200 ksi.

(c) Washer (35) -- Cadmium plate and apply BMS 10-11, Type 1 primer (F-16.01). Material: 17-7PH CRES, 150-170 ksi.

(d) Reservoir (55) -- Passivate (F-8.07). Material: 17-4PH CRES.

(e) Bolt (80) -- Passivate (F-8.07). Material: A286 CRES.

(f) Lock (90) -- Passivate (F-8.07). Material: 15-5PH or 17-4PH CRES.

(g) Nut (95) -- Passivate (F-17.25, which replaces F-17.09). Material: 15-5PH CRES.

(h) Shim (100) -- Chemical treat and apply BMS 10-11, Type 1 primer (F-18.06). Material: Al alloy.

(i) Retainer (120) -- Cadmium plate (F-15.02), 0.0002-0.0004 inch thick. Apply BMS 10-11, Type 1 primer (F-20.03) but not on splines or in tapped holes. Material: 15-5PH or 17-7PH CRES, 150-170 ksi.

(j) Bond Assembly (130) -- Fig. 3A

(k) Bushing (170) -- Cadmium plate (F-15.06). Material: Al-Ni-Bronze.

(l) Bushing (175) -- Anodize and apply BMS 10-11, Type 1 primer (F-18.04). Material: Al Alloy.

(m) Sleeve (180) -- Chromic acid anodize and apply BMS 10-11, Type 1 primer (F-18.13). Material: Al Alloy

(4) Fig. 9 Parts

(a) Fitting (5) -- See Fig. 1A.

(5) Fig. 10 Parts

(a) Stabilizer (5, 65-52235-3, -4, -11 thru -14, -17, -18, -21 thru -26, -33. -34) -- See Fig. 1B.

(b) Stabilizer (5, 65-52235-37) -- See Fig. 1C.

(6) Fig. 11 Parts

(a) Fitting (5, 65-67172-3, -4, -7, -8, -15, -16, -19, -20) -- See Fig. 1D.

(b) Fitting (5, 65-67172-21, -22, -27, -28, -31, -32, -35, -36) -- See Fig. 1E.

(7) Fig. 12 Parts

(a) Link (5) -- See Fig. 1F.

(8) Fig. 13 Parts

(a) Fitting (5) -- See Fig. 1G.

(9) Fig. 14 Parts

(a) Fitting (5) -- See Fig. 1H.

E. Replacement

NOTE: On the 65-46401 beam assemblies (Fig. 7), we recommend that bushings (65, 70) be replaced with bushings (66, 71) or (72, 73, 74) (Ref SB 57-1071).

(1) Bushings and sleeves in beams 65-46401-series (Fig. 7)

(a) Remove the old bushings or sleeves.

(b) Install replacement bushings or sleeves by the shrink fit method of SOPM 20-50-03.

(c) Machine (hone) the bushings and sleeves to design dimensions and finish.

(2) Bushings and sleeves in beams 65-82764-series (Fig. 6)

(a) Remove the old bushings or sleeves.

(b) Install replacement bushings or sleeves by the shrink fit method of SOPM 20-50-03 with wet BMS 5-95 sealant on mating surfaces.

(c) Seal the area and gaps between the bushing flange and the bond assembly with BMS 5-95 sealant.

(d) Machine the bushings or sleeves to design dimensions and finish shown in Fig. 1.

(e) Seal the bushings and sleeves as shown.

(3) Bushings or sleeves in beam 65C32102-series (Fig. 8)

(a) Remove the old bushings or sleeves.

(b) Install replacement bushings or sleeves by the shrink fit method of SOPM 20-50-03 with wet BMS 5-95 sealant on mating surfaces.

(c) Seal the area and gaps between the bushing flange and the bond assembly with BMS 5-95 sealant.

(d) Machine the bushings or sleeves to design dimensions and finish as shown in Fig. 3A.

(e) Seal the bushings and sleeves as shown.

(4) Bushings (10) in stabilizing fittings 65-49442-series (Fig. 9) and 65-67172-series (Fig. 11)

(a) Remove the old bushings.

(b) If the fitting was repaired per step 3.C. and a repair shim was used, be sure to machine the replacement bushings to a length equal to the thickness of the repaired lug.

(c) Install replacement bushings by the shrink fit method of SOPM 20-50-03. Mismatch of 0.01 inch with the outer surface of the fitting is permitted.

(5) Bushings (12) in stabilizing fittings 65-67172-series (Fig. 11)

(a) Remove the old bushings.

(b) Install replacement bushings by the shrink fit method of SOPM 20-50-03 with BMS 5-95 sealant.

(c) Machine the bushings to design dimensions and finish as shown in Fig. 1E.

(6) Bushings (10, 15) in stabilizer assemblies 65-52235-1, -2, -8, -9, -10, -29 thru -32, -35, -36 (Fig. 10)

(a) Remove the old bushings.

(b) If the stabilizer was repaired per step 3.C. and a repair shim was used, be sure to machine the replacement bushings to a length equal to the thickness of the repaired lug.

(c) Install replacement bushings by the shrink fit method of SOPM 20-50-03. Mismatch of 0.01 inch with the outer surface of the stabilizer is permitted.

(7) Bushings (10, 15) in stabilizer assemblies 65-52235-15, -16 (Fig. 10)

(a) Remove the old bushings.

(b) If the stabilizer was repaired per step 3.C. and a repair shim was used, be sure to machine the replacement bushings to a length equal to the thickness of the repaired lug.

(c) Solvent clean the hole and the bushing. Do not chemical treat the hole.

(d) Apply a thin layer of Loctite to the mating surfaces and install the replacement bushing. Mismatch of 0.01 inch with the outer surface of the stabilizer is permitted.

(e) Clean unwanted Loctite from the surface of the stabilizer with degreasing solvent.

(f) Let the Loctite cure a minimum of 2 hours.

(8) Bushings (12, 17) in stabilizer assembly 65-52235-38 (Fig. 10)

(a) Remove the old bushings.

(b) Install replacement bushings by the shrink fit method of SOPM 20-50-03 with BMS 5-95 sealant.

(c) Machine the bushings to dimensions shown in Fig. 1C.

(9) Bearing in beams 65-82764-series (Fig. 6)

(a) Remove the old bearing from the beam assembly.

(b) Install a replacement bearing per Assembly par. 4.B.(7), (8), (9). On the 65-82764-series beams, adjust the nut and install items (30, 35, 40) as shown in Fig. 2.

(c) If you replace screw (30) with a new one, be sure to cut it shorter as indicated.

(10) Bearings in beams 65C32102-series (Fig. 8)

(a) Remove the old bearings.

(b) Install a replacement bearing (40) per Assembly par. 4.D.(2).

(c) Install a replacement bearing (125) per Assembly par. 4.D.(1).

(11) Bushings (10, 15) in stabilizer links 65C32697-series (Fig. 12)

(a) Remove the old bushings.

(b) Install replacement bushings by the shrink fit method of SOPM 20-50-03 with BMS 5-95 sealant.

(c) Machine the bushings to dimensions shown in Fig. 1F.

(12) Bushings (10) in stabilizing fittings 65C32699-series (Fig. 13)

(a) Remove the old bushings.

(b) Install replacement bushings by the shrink fit method of SOPM 20-50-03 with BMS 5-95 sealant.

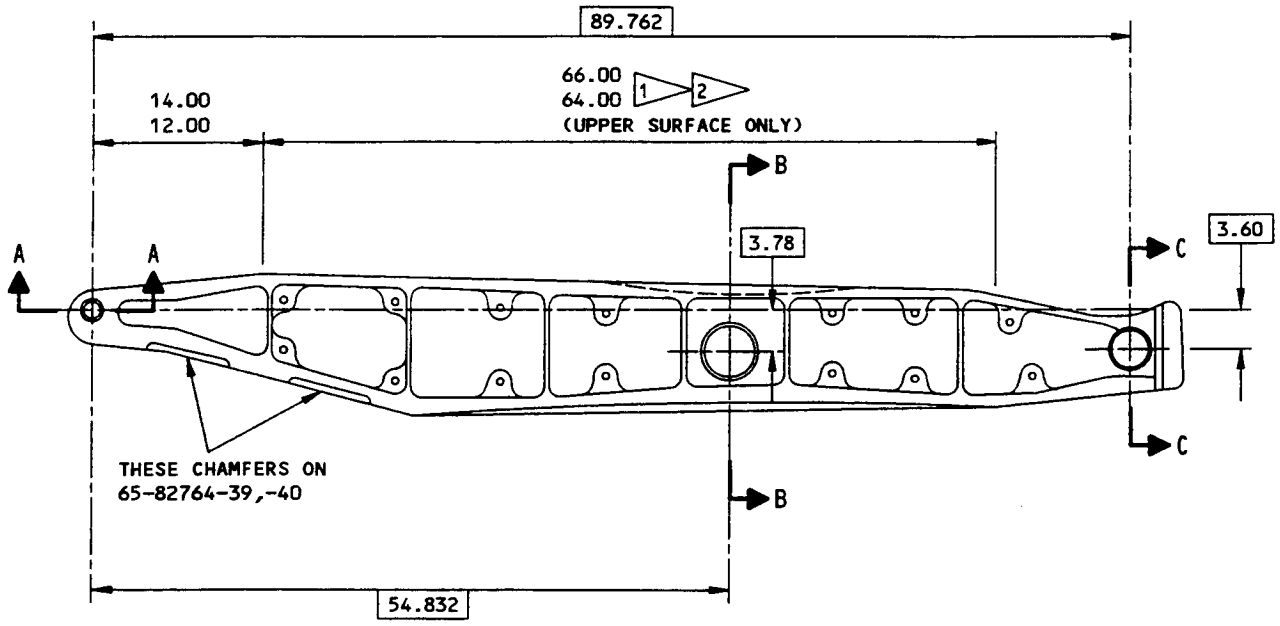
(c) Machine the bushings to design dimensions and finish as shown in Fig. 1G.

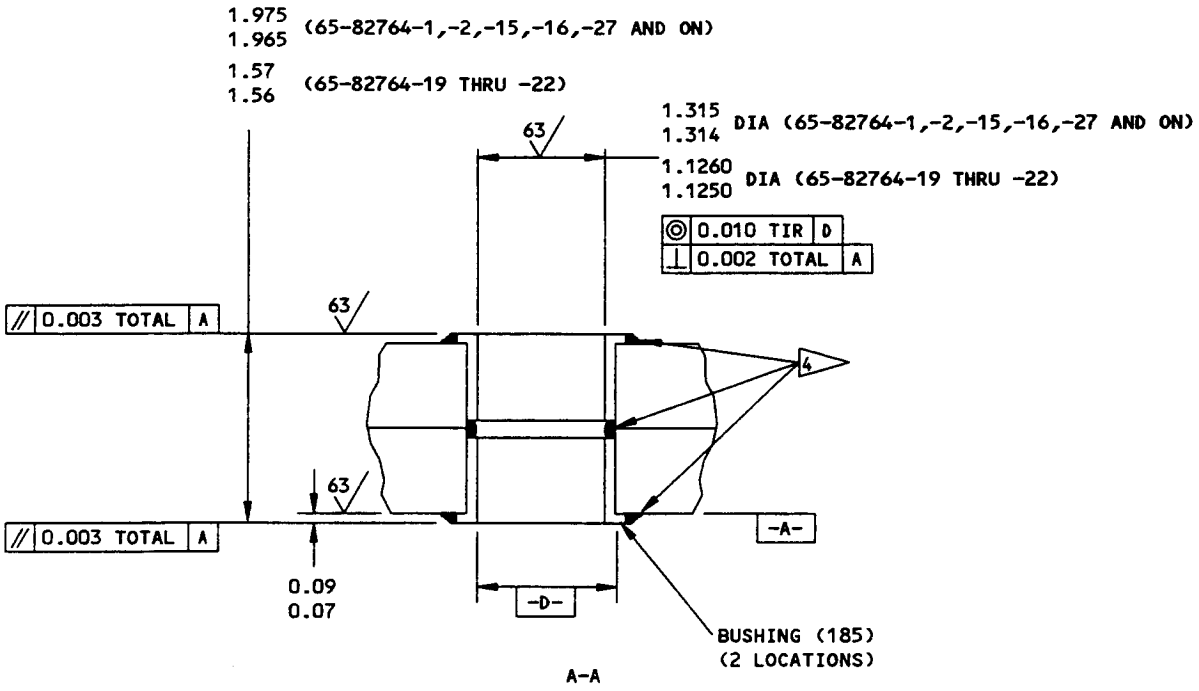
(13) Bushings (10) in stabilizing fittings 65C32918-series (Fig. 14)

(a) Remove the old bushings.

(b) Install replacement bushings by the shrink fit method of SOPM 20-50-03 with BMS 5-95 sealant.

(c) Machine the bushings to design dimensions and finish as shown in Fig. 1H.

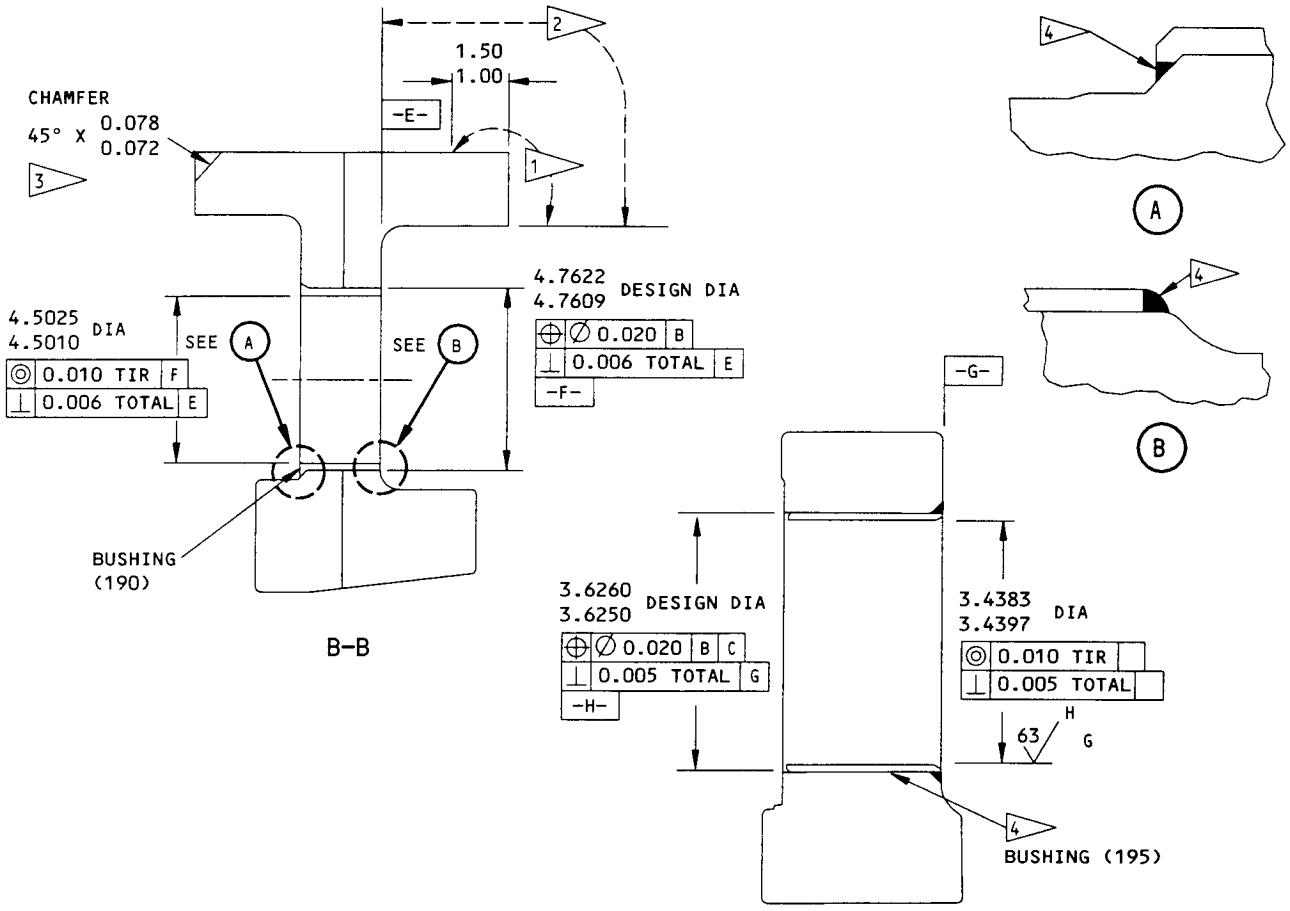




ITEM NUMBERS REFER TO FIG. 6
ALL DIMENSIONS ARE IN INCHES

65-82764-SERIES

Beam Repair and Refinish
Figure 1 (Sheet 1)



REFINISH

APPLY PRIMER (F-14.995, WHICH REPLACES SRF-14.995) ALL OVER FOLLOWED BY ENAMEL, BMS 10-60 (F-14.9812, WHICH REPLACES SRF-14.9812). NO PRIMER AND ENAMEL ON BUSHINGS, SLEEVE, IN BOLT HOLES OR AS SHOWN BY 1

REPAIR

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: AL ALLOY

SHOT PEEN: (SOPM 20-10-03)
0.023-0.055 SHOT SIZE
0.008-0.016 A2 INTENSITY

ITEM NUMBERS REFER TO FIG. 6

ALL DIMENSIONS ARE IN INCHES

1 FOR 65-82764-1,-2,-15,-16,-19 THRU -22,-27, -28: AFTER PRIMER, APPLY BMS 10-86 ENAMEL (F-14.9624, WHICH REPLACES SRF-14.9624) ALONG EDGE OVER LENGTH SHOWN. OPTIONAL F-14.9812, WHICH REPLACES SRF-14.9812 FOR ALL OVER APPLICATION.

2 FOR 65-82764-31 AND ON: AFTER PRIMER, APPLY BMS 10-86 ENAMEL (F-14.9625, WHICH REPLACES SRF-14.9625) ALONG EDGE OVER LENGTH SHOWN

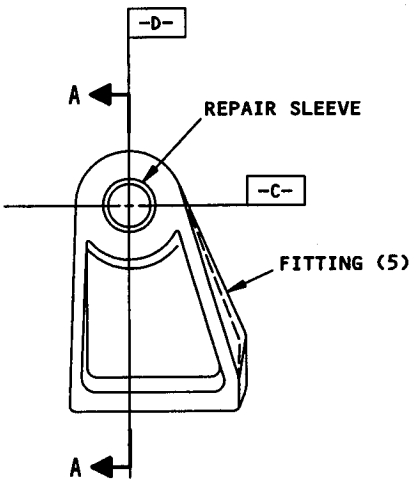
3 FOR 65-82764-19,-20: APPLY BMS 10-11, TYPE 1 PRIMER (F-20.03) AND BMS 10-60 ENAMEL (F-14.9812), WHICH REPLACES SRF-149812) TO CHAMFER SURFACE AND 0.50 INCH OUT FROM THE CHAMFER SURFACE.

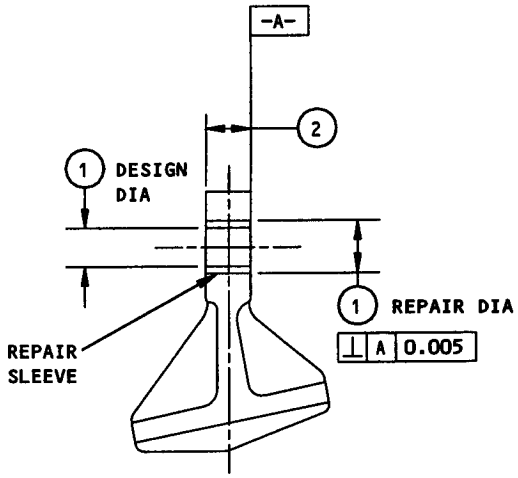
4 APPLY BMS 5-95 SEALANT ALL AROUND

65-82764-SERIES

Beam Repair and Refinish
Figure 1 (Sheet 2)

F55868





	1	2
DESIGN DIM	0.9379 0.9370	0.845 0.840
REPAIR LIMIT	1.030 1	0.760 2

REFINISH

CHEMICAL TREAT OR CHROMIC ACID ANODIZE AND APPLY BMS 10-11 TYPE 1 PRIMER (SRF-2.30)

1 LIMIT FOR INSTALLATION OF REPAIR SLEEVE

2 RESTORATION TO DESIGN DIMENSION NOT REQUIRED

REPAIR

REF 1 2

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

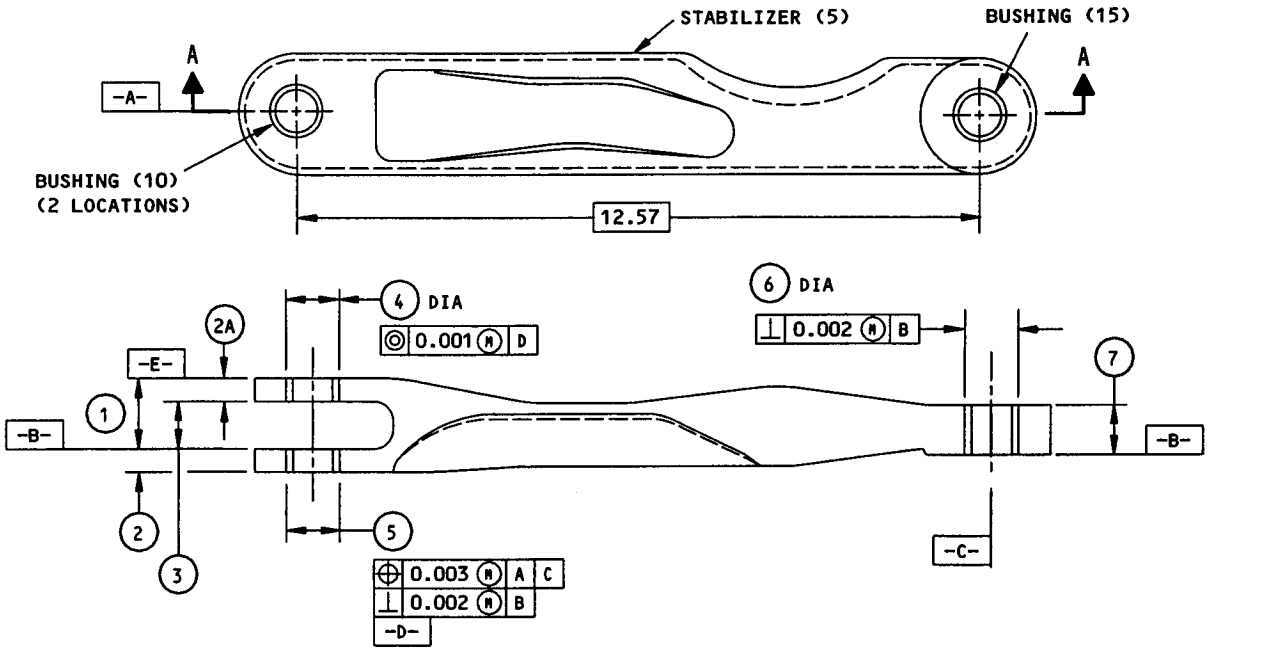
BREAK SHARP EDGES

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

FITTING (5, FIG. 9)
65-49442-3,-4,-9,-10

Fitting Repair and Refinish
Figure 1A



	1	2	2A 1	2A 2	3 1	3 2	4 3	4 4	5 3	5 4	6 3	6 4	7
DESIGN DIM	1.35 1.33	0.47 0.45	0.485 0.460	0.480 0.455	0.870 0.865	0.875 0.870	0.9379 0.9370	0.9420 0.9416	0.9379 0.9370	0.9420 0.9416	0.9379 0.9370	0.9420 0.9416	0.830 0.825
REPAIR LIMIT	----	0.40 5	0.40 5	0.40 5	----	----	1.0300 6	1.0300 6	1.0300 6	1.0300 6	1.0300 6	1.0300 6	0.765 5

REFINISH

STABILIZERS (5) 1 :
CHEMICAL TREAT OR CHROMIC ACID ANODIZE AND APPLY BMS 10-11, TYPE 1 PRIMER (SRF-2.30)

STABILIZERS (5) 2 :
CHEMICAL TREAT OR CHROMIC ACID ANODIZE AND APPLY BMS 10-11, TYPE 1 PRIMER (F-18.05)

REPAIR

REF 5 6

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK SHARP EDGES

SHOT PEEN: (SOPM 20-10-03)
0.023-0.028 SHOT SIZE
0.006-0.010 A2 INTENSITY

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

1 65-52235-3,-4,-11 THRU -14,-17,-18, -21 THRU -26

2 65-52235-33,-34

3 65-52235-3,-4,-11 THRU -14,-21 THRU -26

4 65-52235-17,-18

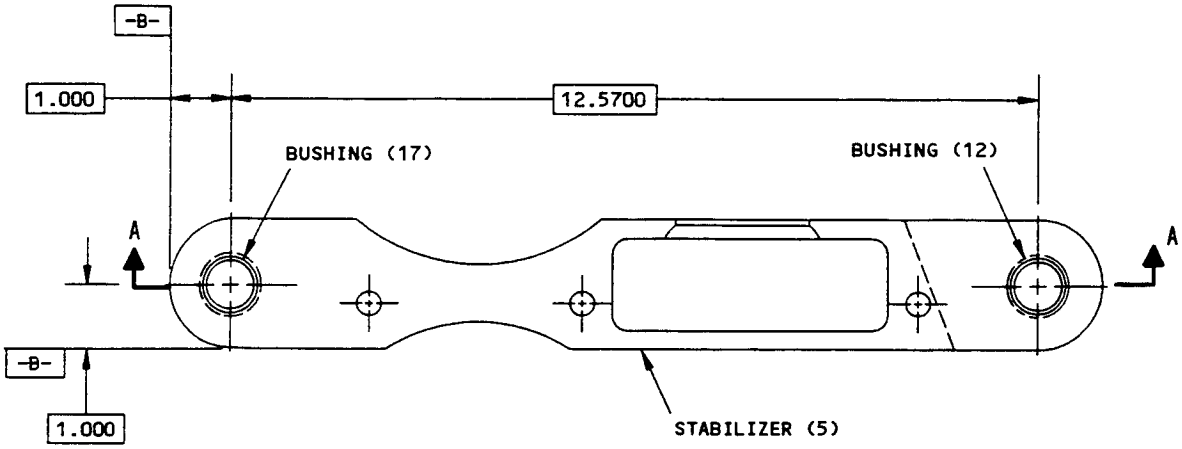
5 RESTORATION TO DESIGN DIMENSIONS NOT REQUIRED

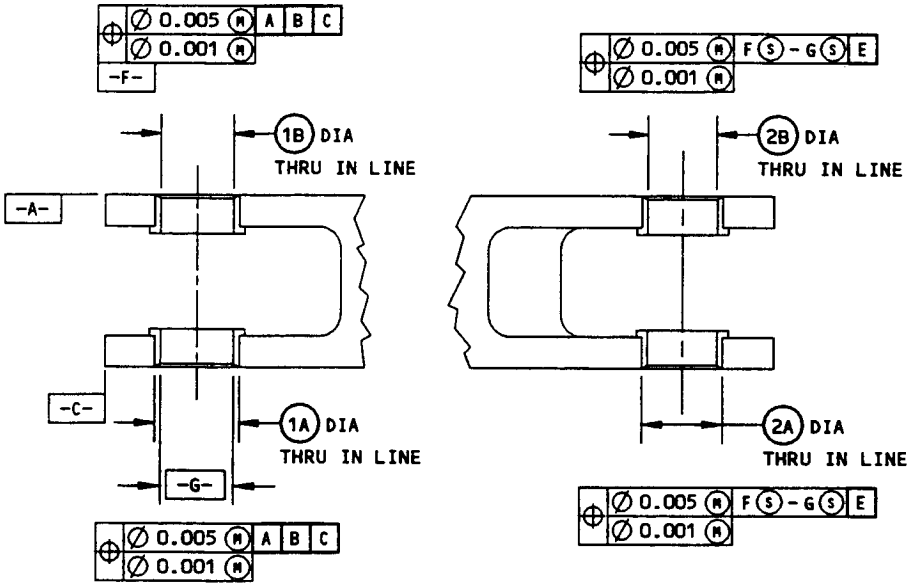
6 LIMIT FOR INSTALLATION OF REPAIR SLEEVE

STABILIZER ASSY (1, FIG. 10)
65-52235-1,-2,-7 THRU -10,-15,-16,-27 THRU -32,-35,-36

Stabilizer Repair and Refinish
Figure 1B

E40733





	1A	1B	2A	2B
DESIGN DIM	0.8757 0.8750	0.7472 0.7462	0.8757 0.8750	0.7472 0.7462
REPAIR LIMIT	—	—	—	—

STABILIZER ASSY (1, FIG. 10)
65-52235-38

Stabilizer Repair and Refinish
Figure 1C (Sheet 1)

REFINISH

BORIC ACID-SULFURIC ACID ANODIZE OR CHROMIC ACID ANODIZE (F-17.31). APPLY BMS 10-11, TYPE 1 PRIMER (F-20.02) BUT NOT IN HOLES FOR BUSHINGS.

REPAIR

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

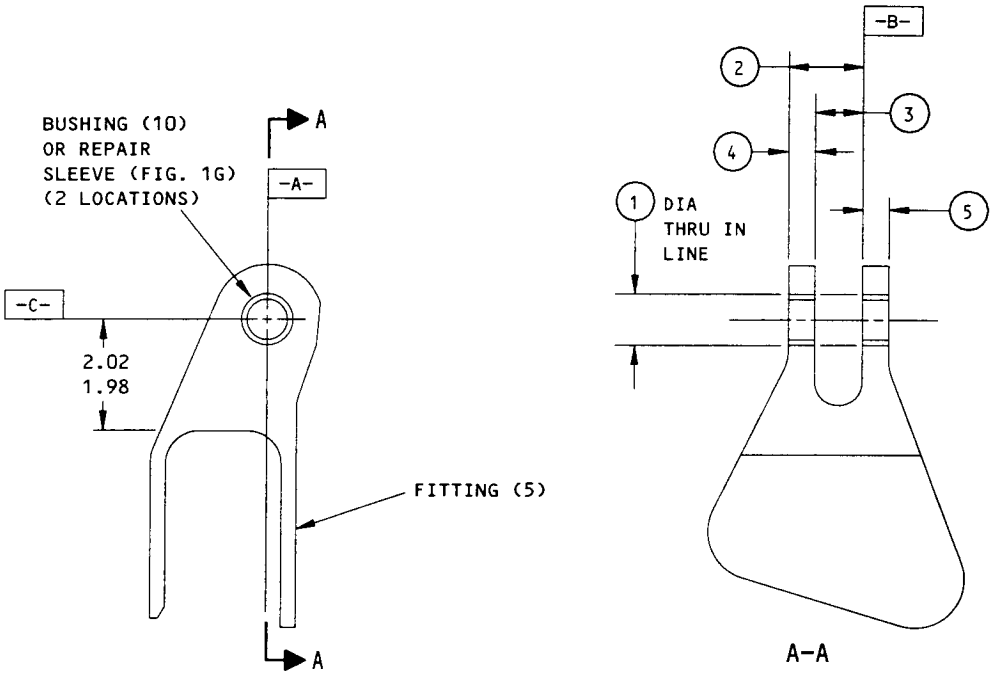
SHOT PEEN: (SOPM 20-10-03)
0.023-0.028 SHOT SIZE
0.004-0.007 A2 INTENSITY

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

STABILIZER (1, FIG.10)
65-52235-38

Stabilizer Repair and Refinish
Figure 1C (Sheet 2)



	1	2	3 ▷1	3 ▷2	4 ▷1	4 ▷2	5
DESIGN DIM	0.9379 0.9370	1.34 1.32	0.860 0.850	0.860 0.855	0.490 0.460	0.485 0.460	0.470 0.450
REPAIR LIMIT	1.0300 ▷3	---	---	---	0.420 ▷4	0.420 ▷4	0.420 ▷4

REFINISH

FITTINGS (5):
65-67172-3,-4: CHEMICAL TREAT OR CHROMIC ACID ANODIZE AND APPLY BMS 10-11 TYPE 1 PRIMER (SRF-2.30)
65-67172-7,-8,-15,-16,-19,-20: CHEMICAL TREAT OR CHROMIC ACID ANODIZE AND APPLY BMS 10-11 TYPE 1 PRIMER (F-18.05)

▷1 65-67172-1,-2,-5,-6

▷2 65-67172-13,-14,-17,-18

▷3 LIMIT FOR INSTALLATION OF REPAIR SLEEVE

▷4 RESTORATION TO DESIGN DIMENSION NOT REQUIRED

REPAIR

REF ▷3 ▷4

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK SHARP EDGES

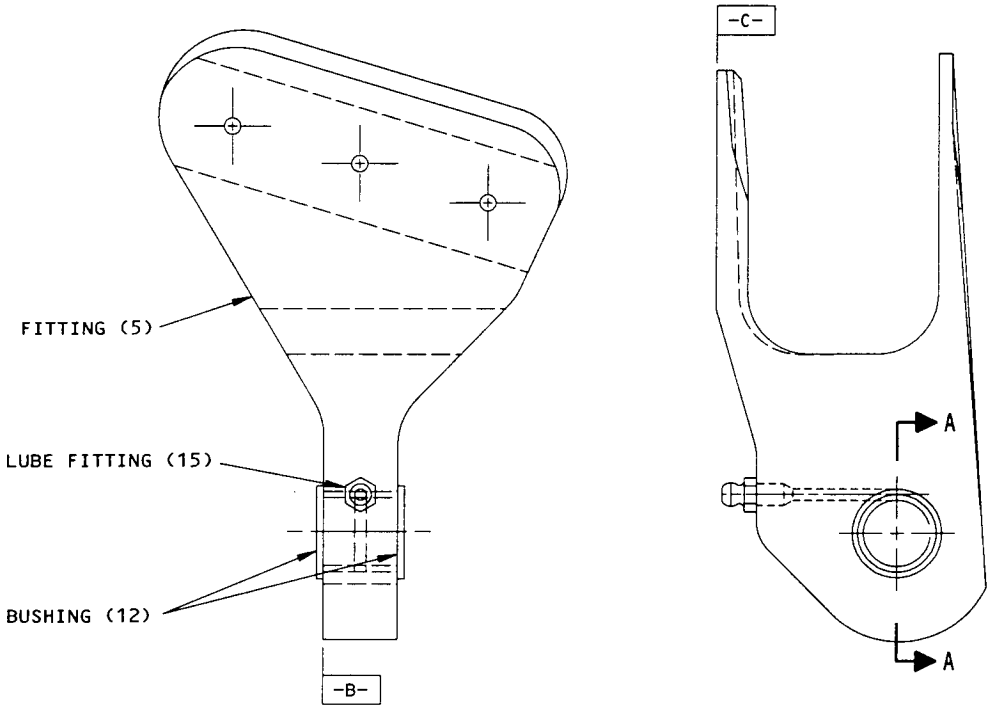
SHOT PEEN: (SOPM 20-10-03)
0.023-0.046 SHOT SIZE
0.014 A2 INTENSITY

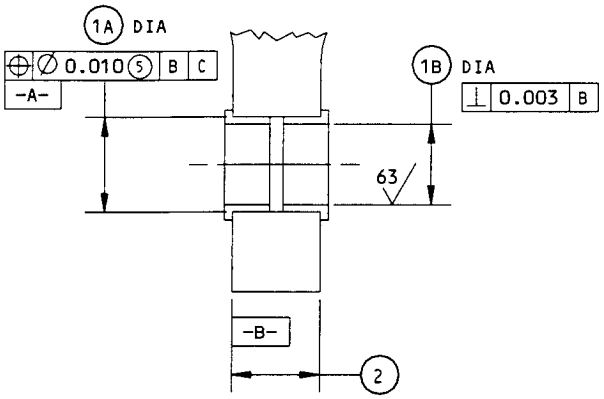
MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

FITTING (1, FIG. 11)
65-67172-1,-2,-5,-6,-13,-14,-17,-18

Fitting Repair and Refinish
Figure 1D





A-A

	1A	1B	2
DESIGN DIM	0.8757 0.8750	0.7503 0.7495	0.825 0.820
REPAIR LIMIT	---	---	---

REFINISH

BORIC ACID-SULFURIC ACID ANODIZE OR CHROMIC ACID ANODIZE (F-17.31). APPLY BMS 10-11, TYPE 1 PRIMER (F-20.02) BUT NOT IN HOLES FOR BUSHINGS.

REPAIR

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

SHOT PEEN: (SOPM 20-10-03)
0.023-0.055 SHOT SIZE
0.010-0.015 A2 INTENSITY

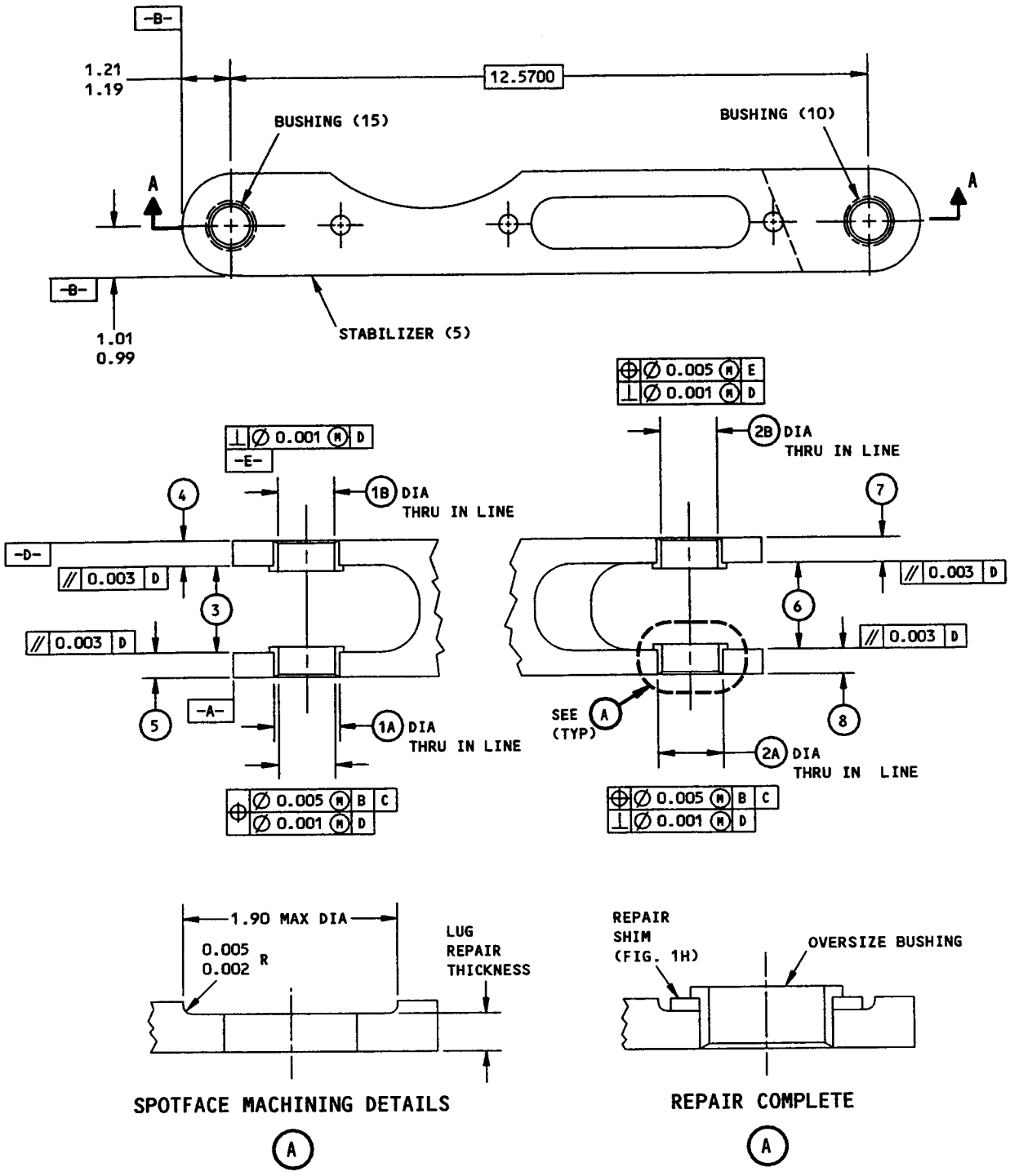
MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

FITTING (1, FIG. 11)
65-67172-23 THRU -26,-29,-30,-33,-34

Fitting Repair and Refinish
Figure 1E

E56358



SPOTFACE MACHINING DETAILS

A

REPAIR COMPLETE

A

STABILIZER ASSY (1, FIG. 12)
65C32697-5,-7

Link Repair and Refinish
Figure 1F (Sheet 1)

	(1A)	(1B)	(2A)	(2B)	(3)	(4)	(5)	(6)	(7)	(8)
DESIGN DIM	1.0007 1.0000	0.8753 0.8745	0.8757 0.8750	0.7472 0.7462	0.895 0.885	0.415 0.395	0.420 0.400	0.955 0.945	0.385 0.365	0.390 0.370
REPAIR LIMIT	1.1000 ▷1	—	0.9700 ▷1	—	—	0.360 ▷2	0.360 ▷2	—	0.340 ▷2	0.340 ▷2

REFINISH

CHROMIC ACID ANODIZE (F-18.13). APPLY BMS 10-11, TYPE 1 PRIMER (F-20.02) BUT NOT IN HOLES FOR BUSHINGS.

REPAIR

REF ▷1 ▷2

125 √ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

SHOT PEEN (SOPM 20-10-03):
0.023-0.055 SHOT SIZE
0.012-0.014 A2 INTENSITY

MATERIAL: AL ALLOY

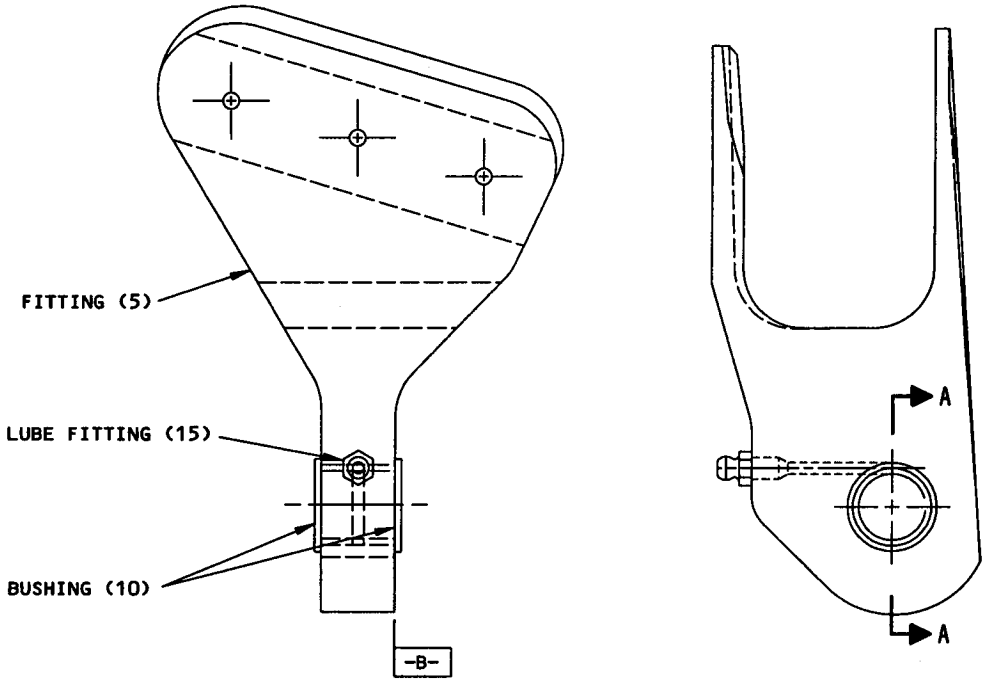
ALL DIMENSIONS ARE IN INCHES

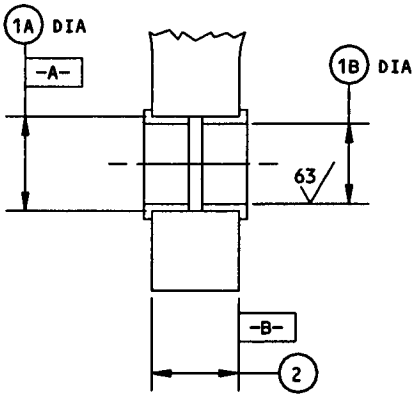
▷1 LIMIT FOR INSTALLATION OF OVERSIZE BUSHINGS
▷2 LIMIT FOR SPOTFACE REPAIR (SEE (A))

LINK ASSY (1, FIG.12)
65C32697-5,-7

Link Repair and Refinish
Figure 1F (Sheet 2)

LD4793





A-A

	1A	1B	2
DESIGN DIM	1.0007 1.0000	0.8753 0.8745	0.690 0.680
REPAIR LIMIT	---	---	---

REFINISH

APPLY BMS 10-11, TYPE 1 PRIMER (F-20.03) BUT NOT IN HOLE FOR LUBE FITTING.

REPAIR

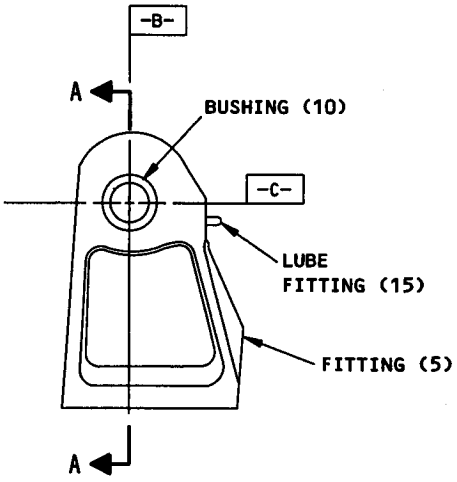
125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

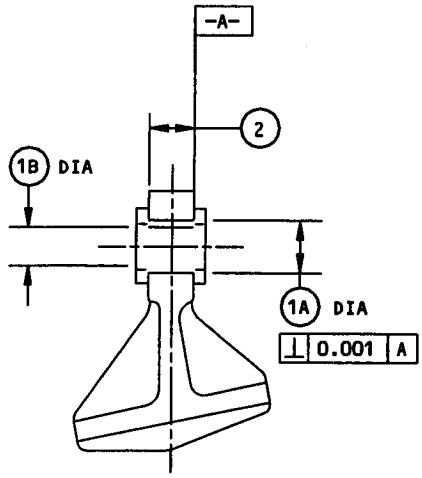
SHOT PEEN: (SOPM 20-10-03)
0.023-0.046 SHOT SIZE
0.012 A2 INTENSITY

MATERIAL: TI ALLOY

ALL DIMENSIONS ARE IN INCHES

FITTING (1, FIG. 13)
65C32699-1,-2
Fitting Repair and Refinish
Figure 1G





	(1)	(2)
DESIGN DIM	0.8757 0.8750	0.755 0.750
REPAIR LIMIT	0.9257 1	—

REFINISH

CHEMICAL TREAT OR CHROMIC ACID ANODIZE AND APPLY BMS 10-11 TYPE 1 PRIMER (F-18.13), BUT NO PRIMER IN HOLES FOR BUSHINGS OR LUBE FITTING

1 LIMIT FOR INSTALLATION OF REPAIR BUSHING.

REPAIR

REF 1

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK SHARP EDGES

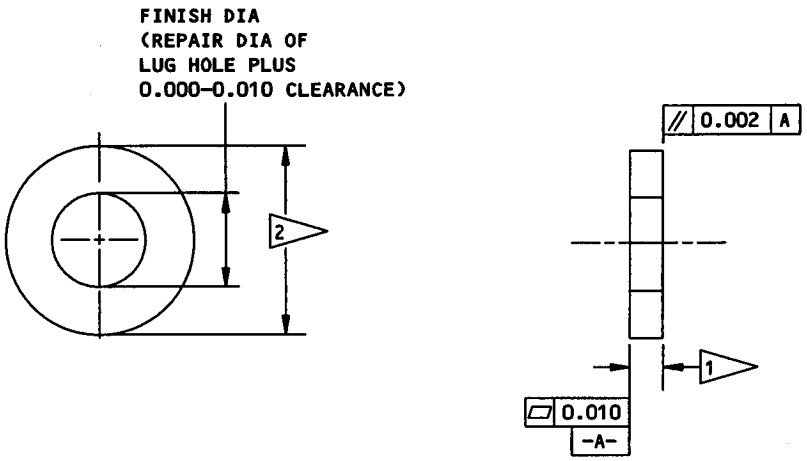
MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

FITTING (5, FIG. 14)
65C32918-3,-4,-9,-10,-19,-20

Fitting Repair and Refinish
Figure 1H

M89296



1 THICKNESS EQUAL TO REPAIR DEPTH.

2 OUTSIDE DIAMETER TO BE LESS THAN SPOTFACE DIAMETER. ALSO, ADJUST FOR CORNER RADIUS OF SPOTFACE. IF ALL OF THE LUG SURFACE WAS MACHINED, MAKE THE WASHER OUTSIDE DIAMETER EQUAL TO THE DIAMETER OF THE LUG.

REPAIR

125 MACHINED SURFACES

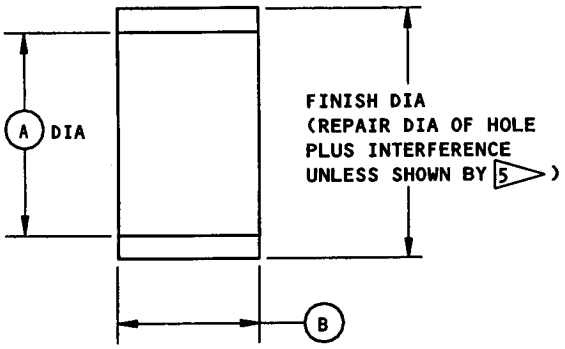
BREAK SHARP EDGES

NO FINISH

MATERIAL: 2024-0 OR 7075-T6 AL ALLOY

ALL DIMENSIONS ARE IN INCHES

Repair Shim Details
Figure 1I



HOLE LOCATION	REPAIR FIGURE	REPLACES BUSHING	A	B	INTERFERENCE (UNLESS SHOWN BY 5)	MATERIAL	FINISH
1	1A	10, FIG. 9 10-60516-206	0.7526 0.7516	0.845 0.840 1	0.0020 0.0010	6	7
1	1A	2	0.9379 0.9370	0.845 0.840 1	0.0020 0.0010	6	7
4 3	1B	10, FIG. 10 10-60516-205	0.7526 0.7516	0.47 0.45 1	0.0020 0.0010	6	7
4 4	1B	10, FIG. 10 10-60516-205	0.7526 0.7516	0.47 0.45 1	0.0040 0.0020 5	6	7
4 3	1B	2	0.930 0.920	0.47 0.45 1	0.0020 0.0010	6	7
4 4	1B	2	0.9420 0.9416	0.47 0.45 1	0.0040 0.0020 5	6	7
6 3	1B	15, FIG. 10 10-60516-206	0.7526 0.7516	0.830 0.825 1	0.0020 0.0010	6	7
6 4	1B	15, FIG. 10 10-60516-206	0.7526 0.7516	0.830 0.825 1	0.0040 0.0020 5	6	7
6 3	1B	2	0.930 0.920	0.830 0.825 1	0.0020 0.0010	6	7
6 4	1B	2	0.9420 0.9416	0.830 0.825 1	0.0040 0.0020 5	6	7
1	1D	10, FIG. 11 10-60516-205	0.7526 0.7516	0.49 0.46 1	0.0020 0.0010	6	7
1	1D	2	0.9379 0.9370	0.49 0.46 1	0.0020 0.0010	6	7

Repair Sleeve Details
Figure 1J (Sheet 1)

1. OR AS NECESSARY FOR A FIT FLUSH TO 0.010 MAXIMUM BELOW THE LUG SURFACE
2. REPAIR SLEEVE FOR INSTALLATION OF STANDARD BUSHING PER PARTS LIST
3. STABILIZERS 65-52235-3,-4,-11 THRU -14, -21 THRU -26
4. STABILIZERS 65-52235-17,-18
5. CLEARANCE FIT
6. 7075-T6 AL ALLOY
7. NO FINISH

REPAIR

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

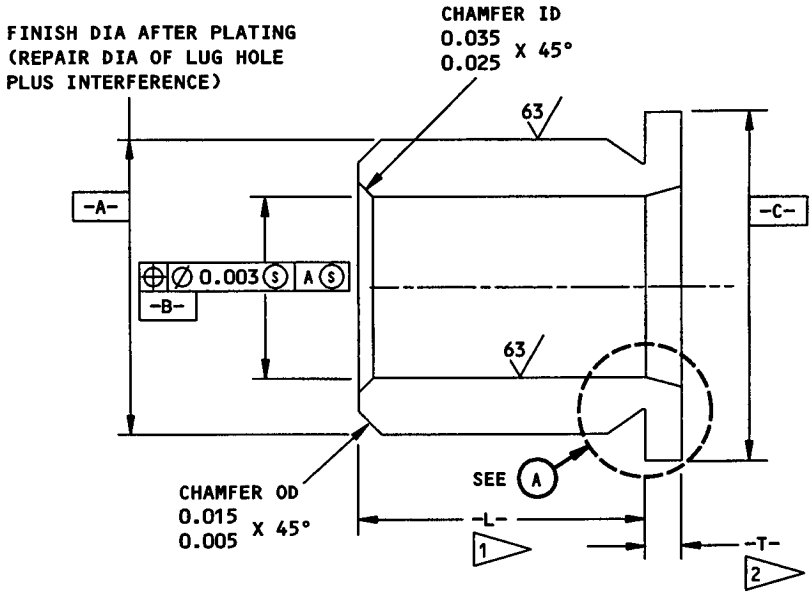
BREAK SHARP EDGES

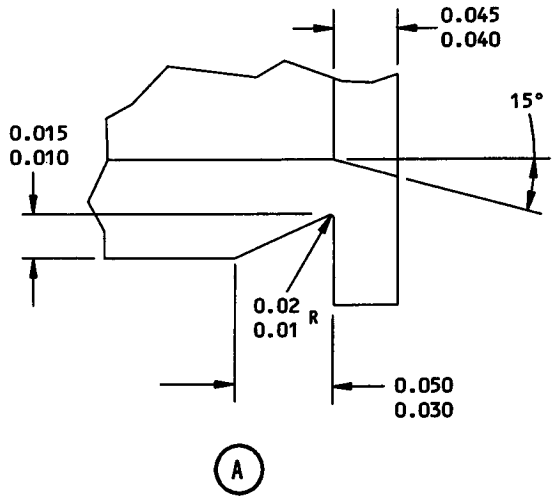
MATERIAL: AS NOTED

FINISH: AS NOTED

ALL DIMENSIONS ARE IN INCHES

Repair Sleeve Details
Figure 1J (Sheet 2)





Oversize Bushing Details
Figure 1K (Sheet 1)

REPLACES BUSHING			-B-	-C-	-L-	-T-	INTER-FERENCE	MATERIAL	FINISH
IPL		PART NO.							
FIG.	ITEM								
12	10	69-77058-4	0.739 0.734	1.040 1.030	0.365 0.360	0.045 0.040	0.0020 0.0010	▷3	F-15.06
12	15	69-77058-5	0.864 0.844	1.190 1.180	0.395 0.390	0.045 0.040	0.0020 0.0010	▷3	F-15.06

▷1 OR LUG REPAIR THICKNESS +0.000/-0.005

▷2 PLUS AMOUNT REMOVED FROM LUG HOLE

▷3 AL-NI-BRONZE (AMS 4640)

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

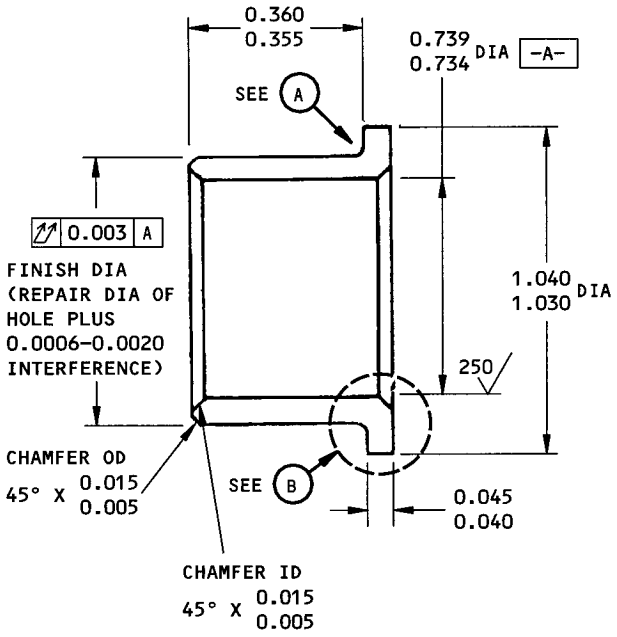
MATERIAL: AS NOTED

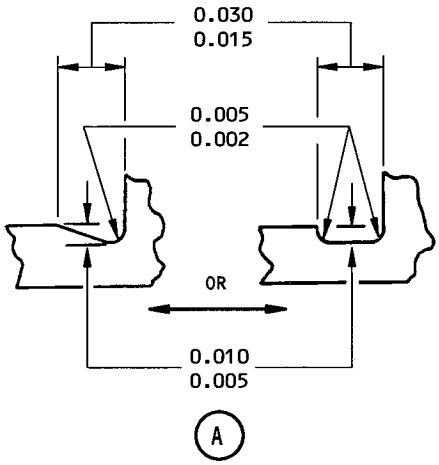
FINISH: AS NOTED

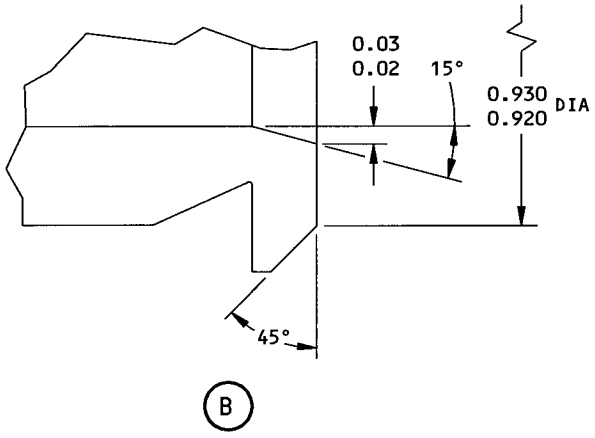
DIMENSIONS ARE AFTER PLATING UNLESS SHOWN DIFFERENTLY

ALL DIMENSIONS ARE IN INCHES

Oversize Bushing Details
Figure 1K (Sheet 2)







63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK SHARP EDGES 0.010-0.020 R

CADMIUM PLATE (F-15.06) (OPT IN BORE)

MATERIAL: AL-NI-BRZ PER AMS 4640

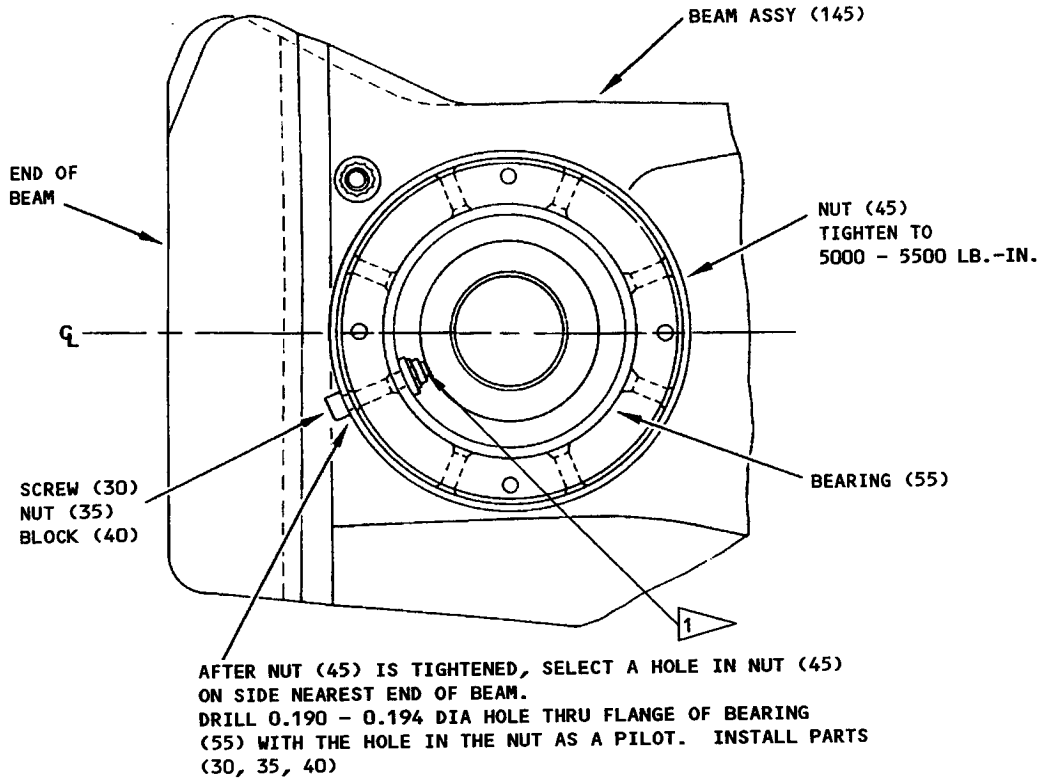
DIMENSIONS ARE BEFORE PLATING

ALL DIMENSIONS ARE IN INCHES

HOLE LOCATION (1A) FIG. 1H - REPLACES BUSHING (10, FIG. 14) 69-77049-2

Oversize Bushing Details
Figure 1L

M88975

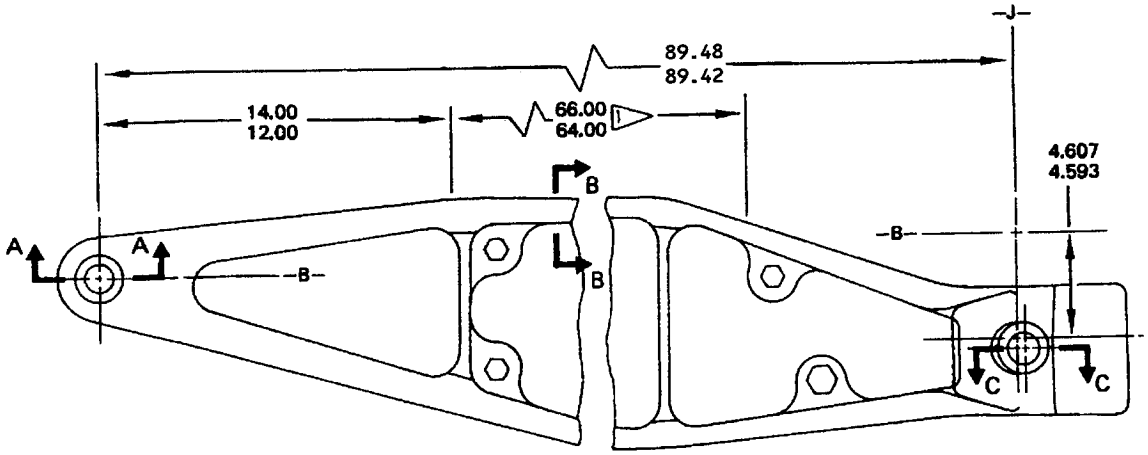


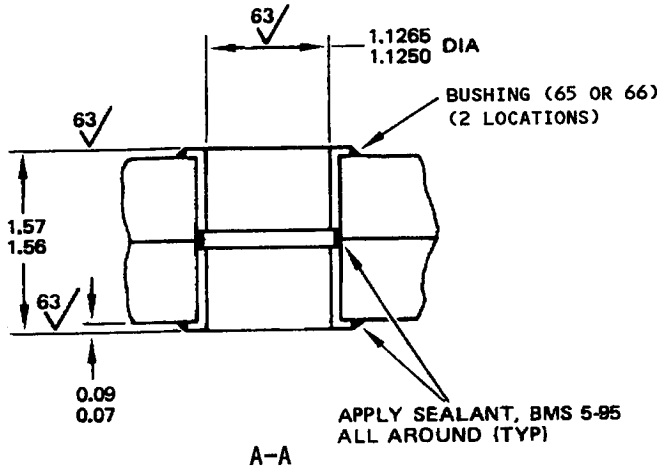
65-82764 BEAM ASSY (FIG. 6)
BEARING (55)

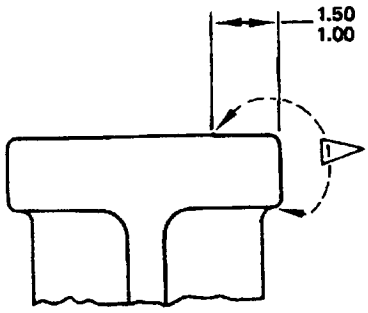
1 IF SCREW IS REPLACED, BE SURE TO CUT THE NEW ONE SHORTER AS FOLLOWS:

1. TO LET ONLY 1 OR 2 THREADS BE ABOVE THE NUT WHEN INSTALLED, OR TO BE 1.07-1.09 INCH LONG.
2. CHAMFER THE CUT ENDS TO THE ROOT DIAMETER OF THE THREADS.
3. STYLUS CADMIUM PLATE (F-15.29) THE CUT END SURFACES.

Bearing Replacement
Figure 2



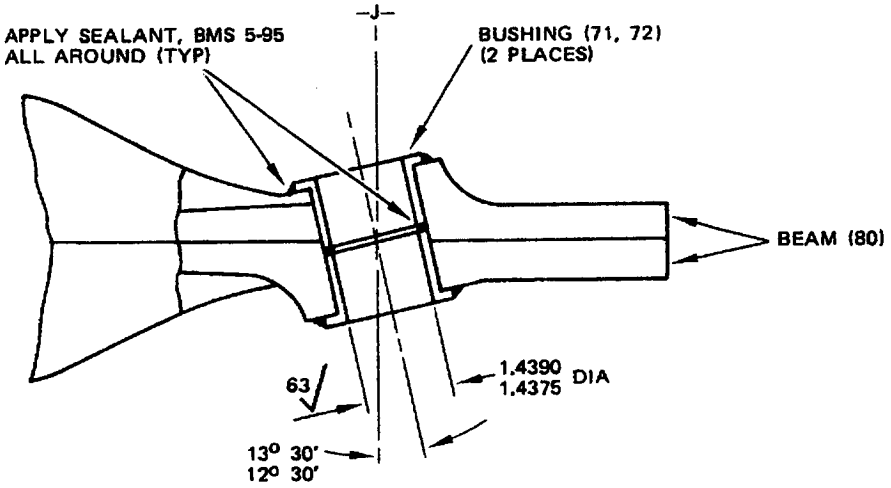




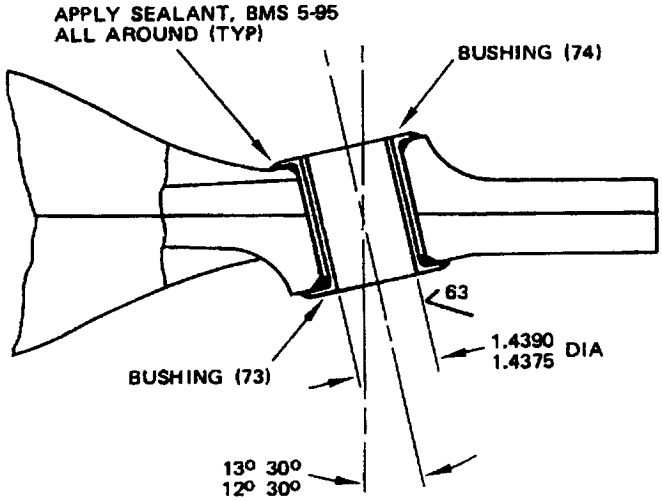
ITEM NUMBERS REFER TO FIG. 7

65-46401-SERIES

Beam Repair and Refinish
Figure 3 (Sheet 1)



CONFIGURATION FOR HOLE PER SB 57-1071
BUSHING (71) FOR HOLE DIA TO 1.630
BUSHING (72) FOR HOLE DIA TO 1.690



CONFIGURATION FOR HOLE PER SB 57-1071
BUSHINGS (73) (74) FOR HOLE DIA TO 1.750

C-C

REFINISH

BEAM (80): CHEMICAL TREAT OR CHROMIC ACID ANODIZE AND APPLY BMS 10-11 TYPE 1 PRIMER (SRF-2.30) ALL OVER. APPLY TEFLON ENAMEL ALONG EDGE OVER LENGTH SHOWN BY 1

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

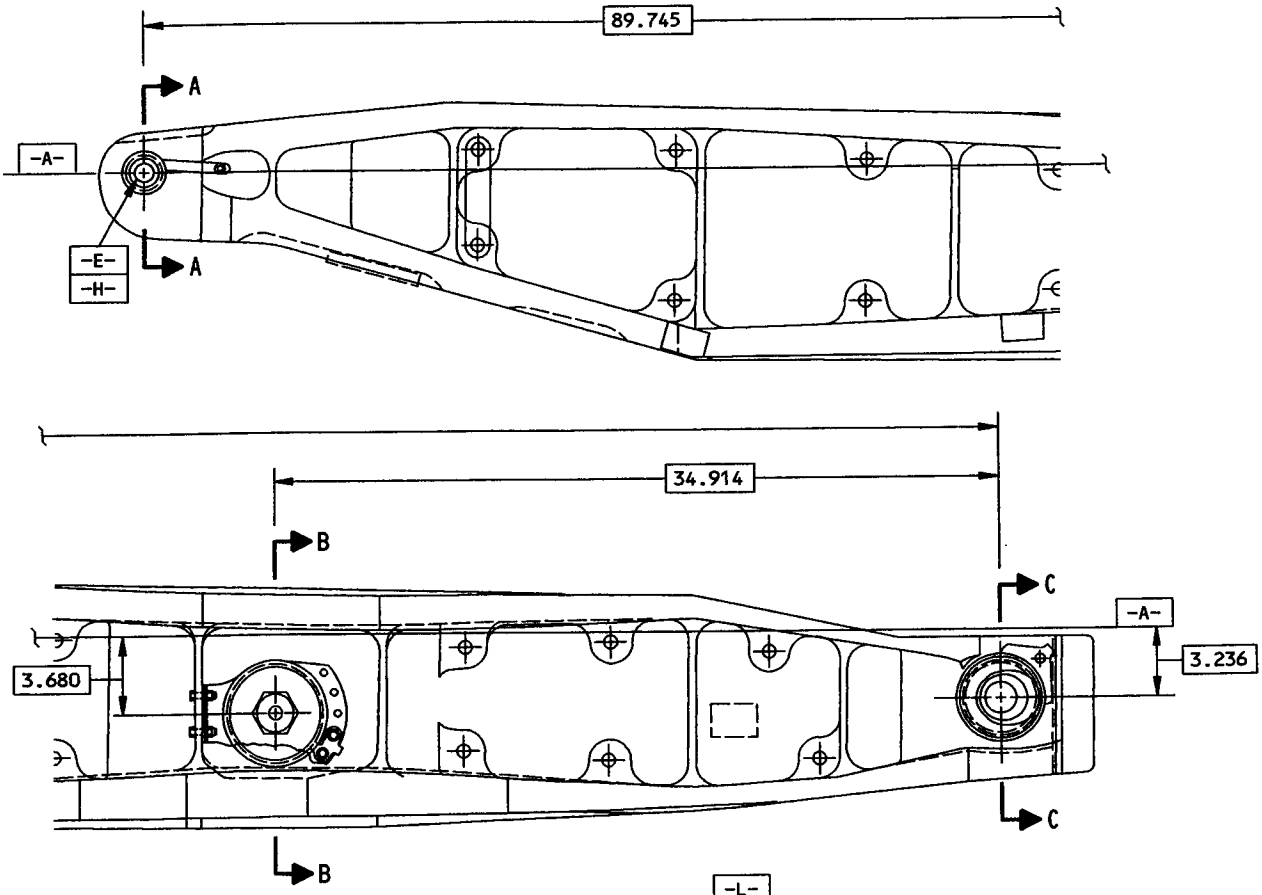
MATERIAL: AL ALLOY

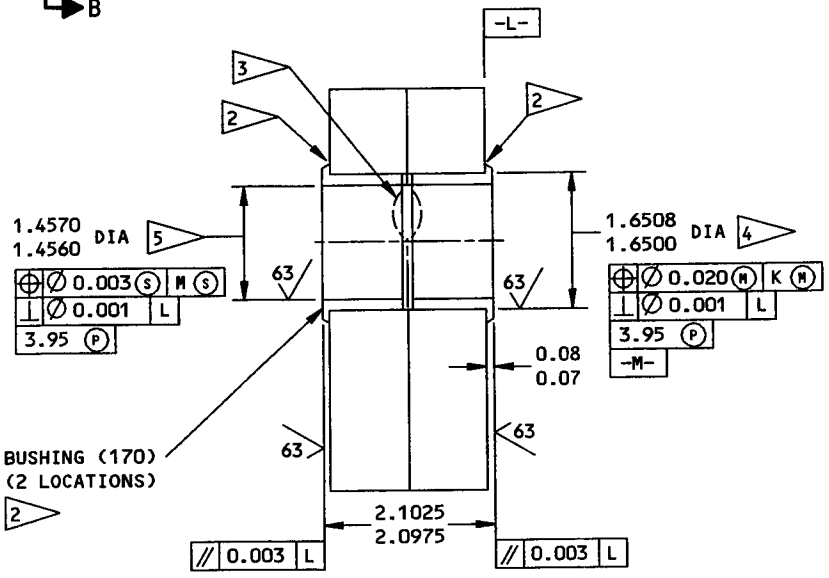
ITEM NUMBERS REFER TO FIG. 7

ALL DIMENSIONS ARE IN INCHES

65-46401-SERIES

Beam Repair and Refinish
Figure 3 (Sheet 2)

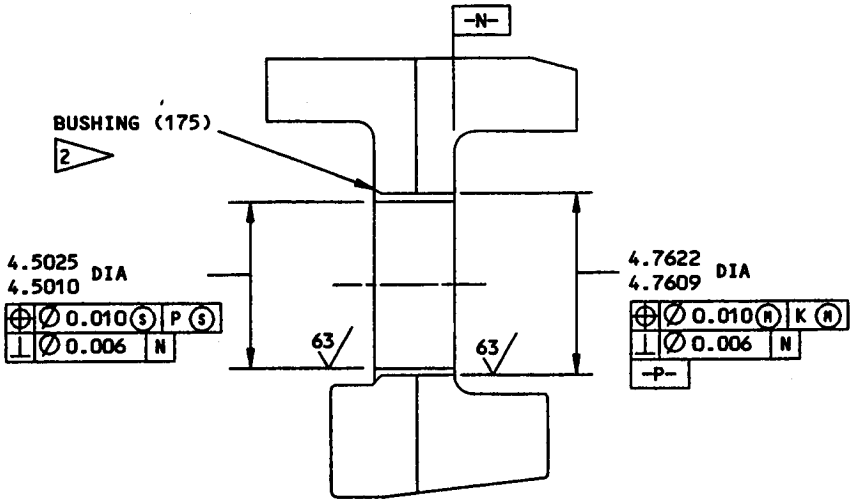




ITEM NUMBERS REFER TO FIG. 8
ALL DIMENSIONS ARE IN INCHES

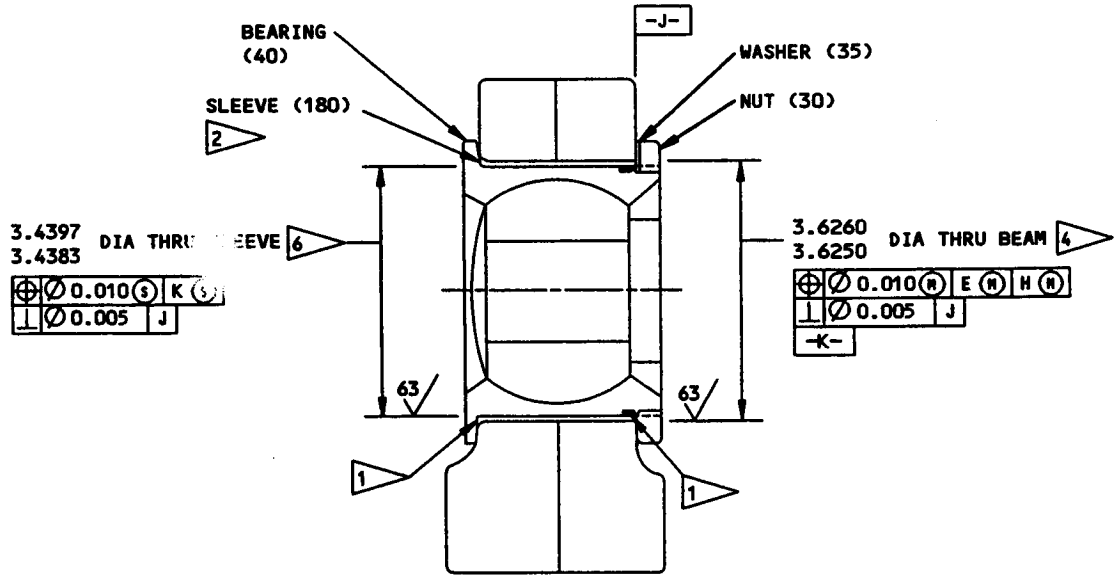
A-A
65C32102-SERIES

Beam Repair and Refinish
Figure 3A (Sheet 1)



(BEARING (125) NOT SHOWN)

B-B



C-C

1. APPLY BMS 5-95 SEALANT BETWEEN BOND ASSY AND BUSHINGS AND/OR BEARINGS TO FILL VOIDS
2. INSTALL BUSHINGS AND SLEEVES WITH BMS 5-95 SEALANT PER 20-50-03
3. PURGE GREASE HOLE AND GREASE GROOVE OF BMS-95 SEALANT AFTER INSTALLATION OF BUSHINGS
4. MANUALLY APPLY COLORED CHEMICAL COATING (F-18.01)
5. MACHINE BUSHINGS TO GIVEN DIMENSIONS AFTER INSTALLATION
6. MANUALLY APPLY COLORED CHEMICAL COATING (F-17.10) AND WIPE PRIMER ON INSIDE DIAMETER (F-19.50)

REFINISH

APPLY YELLOW EPOXY PRIMER (F-14.995) AND APPLY BMS 10-60 BOEING COLOR 702 WHITE GLOSS ENAMEL (F-14.9812) EXCEPT IN BUSHING, SLEEVE, AND BEARING HOLES.

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

65C32102-SERIES

Beam Repair and Refinish
Figure 3A (Sheet 2)

4. ASSEMBLY

A. Materials

NOTE: Equivalent substitutes can be used.

(1) Sealant -- BMS 5-95 (SOPM 20-60-04)

(2) Primer -- BMS 10-11, Type 1 (SOPM 20-60-02)

(3) Grease -- MIL-G-21164 (SOPM 20-60-03)

B. Beams 65-82764 (Fig. 6)

(1) Apply wet primer to the mating surfaces of bearing (140) and bushing (190), then install the bearing in bushing (190) in beam assembly (145).

(2) Apply sealant to the mating surfaces of the retainer (135) and beam assembly (145). Install the retainer on bearing (140). Attach the retainer to the beam assembly with items (120, 125, 130). Use shims (115) as required to remove the gap between the beam and the retainer. Apply primer to the shims after delaminating.

(3) Lubricate the threads of nut (110) with MIL-G-21164 grease and install the nut on bearing (140). Tighten the nut to 4500-7000 lb-in. Install lock (105) with items (95, 100).

(4) Install seal (80) on bearing (140) with clamp (75).

(5) Install reservoir (65) in nut (110). Tighten the reservoir to hold it in position, but do not tighten it to the final torque of 1200-1800 lb-in, because the reservoir will be removed when the beam is installed in the airplane.

(6) Lockwire bolts (95) to each other by the double twist method of SOPM 20-50-02.

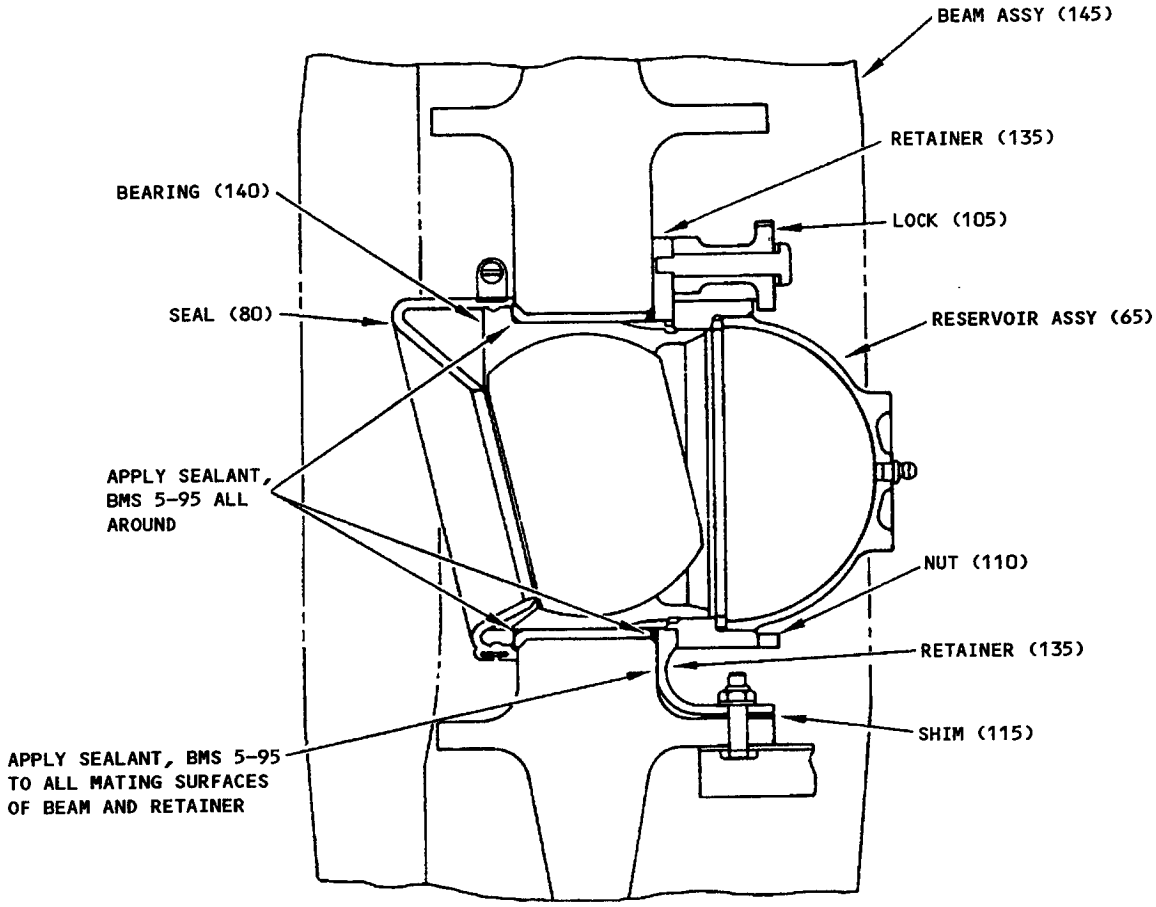
(7) Install bearing (55) in beam assembly (145) with washer (50) and nut (45). Do not tighten this nut.

CAUTION: DO NOT USE THE GOOD BOLTS (15) TO HOLD BEARING (55) WHEN YOU TIGHTEN NUT (45), OR THE BOLTS COULD BE DAMAGED. USE OTHER BOLTS OF EQUIVALENT SIZE WHEN YOU DO THIS TASK.

(8) Install lockplate (10) on bearing (55) with items (15, 20, 25). Tighten nut (25, BACN10JC4 only) to 60-80 lb-in.

(9) Hold bearing (55), and tighten nut (45) to 5000-5500 lb-in. with spanner wrench ST2580-422. Install nut on bearing (55) with items (30, 35, 40). If the hole in bearing does not align with a hole in the nut, drill a new hole as shown in Fig. 2. If you replace screw (30) with a new one, be sure to cut it shorter as indicated.

(10) Lockwire bolts (95) to each other. Lockwire reservoir (70) to lock (105). Use the double twist method of SOPM 20-50-02.



ITEM NUMBERS REFER TO FIG. 6

BEARING INSTL (60)
65-82764

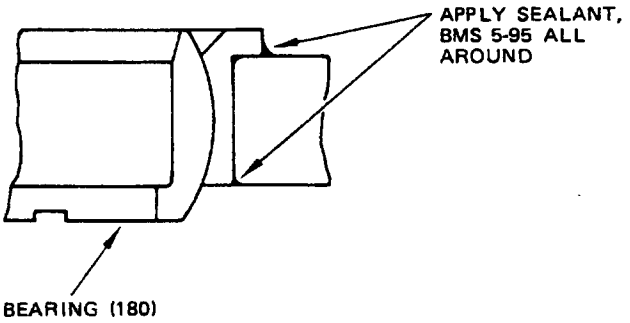
Bearing Sealant Application
Figure 4

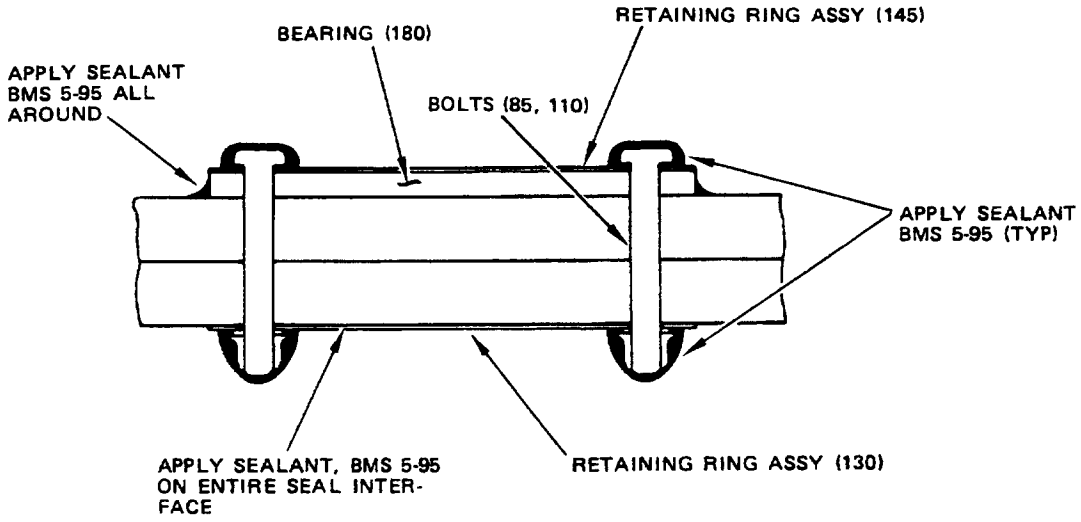
C. Beams 65-46401 beams (Fig. 7)

(1) Install bearing (180) with items (85 thru 130, 145, 160 thru 175).

(2) Tighten nuts (106) to 68-90 lb-in. Tighten nuts (126) to 220-360 lb-in.

(3) Seal bolts (85, 110), nuts (105, 125) and bearing (180) as shown in Fig. 4A.





ITEM NUMBERS REFER TO FIG. 7

65-46401

Bearing Sealant Application
Figure 4A

D. Beams 65C32102 (Fig. 8)

(1) Install bearing (125) (Fig. 4B)

(a) Apply wet primer to bearing (125) O.D. and bushing (175) I.D. Install the bearing in the bushing.

(b) Apply sealant to the mating surfaces of retainer (120) and bond assembly (130). Install the retainer on bearing (125) with items (105, 110, 115). Use shims (100) as required to remove the gap between the beam and the retainer. Apply primer to the shims after delaminating.

(c) Lubricate the threads of nut (95) with MIL-G-21164 grease and install the nut on bearing (125). Tighten the nut to 4500-7000 lb-in. Install lock (90) with items (80,85).

(d) Install seal (70) on bearing (125) with clamp (65).

(e) Install ring seal (75) and reservoir assembly (50) in nut (95). Tighten the reservoir to hold it in position, but do not tighten it to the final torque of 1200-1800 lb-in, because the reservoir will be removed when the beam is in the airplane.

(f) Lockwire bolts (80) to each other by the double twist method of SOPM 20-50-02.

(2) Install bearing (40)

(a) Apply BMS 5-95 sealant to the flange radius of bearing (40).

(b) Install bearing (40) in beam assembly (130).

(c) Apply BMS 5-95 sealant to fill the voids between bearing (40) and sleeve/bond assembly.

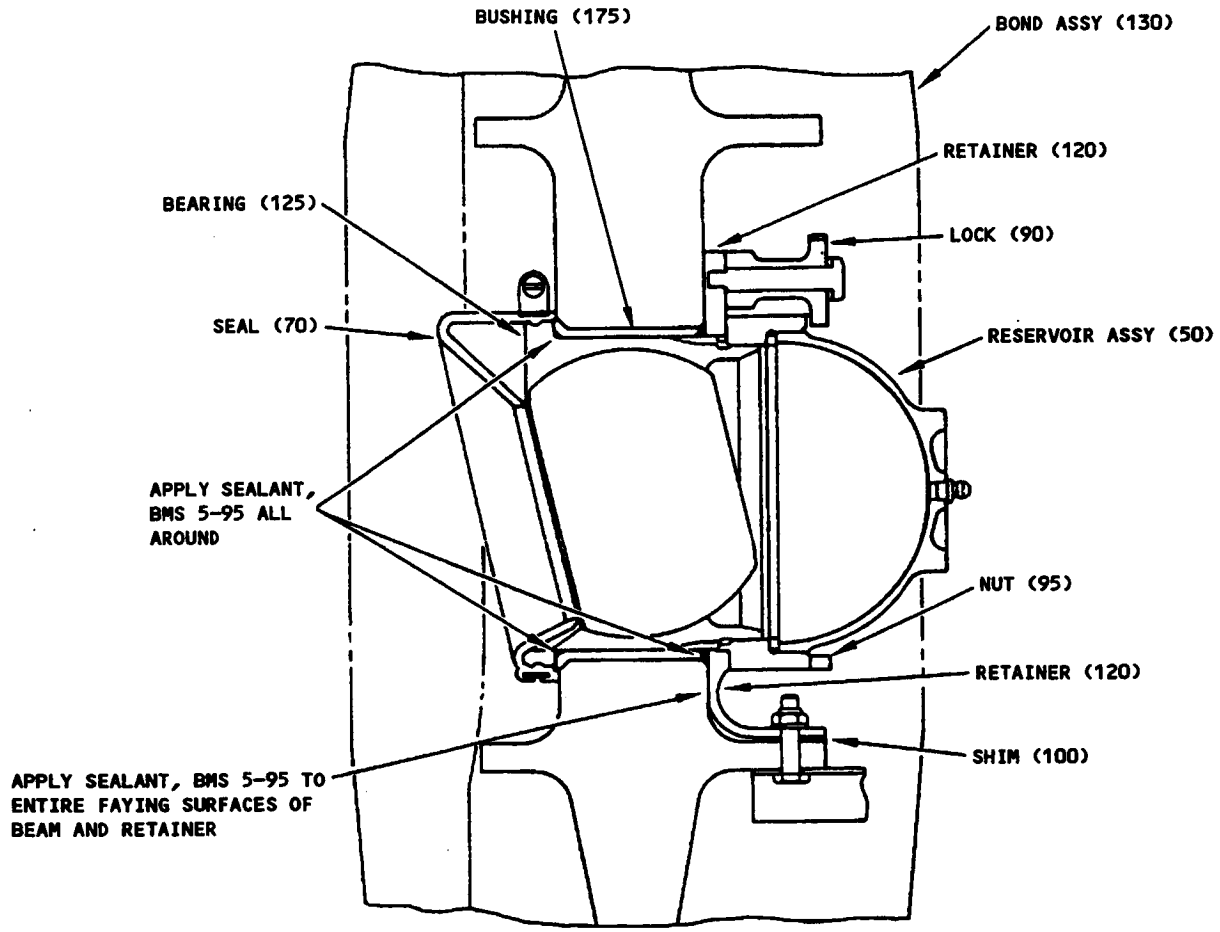
(d) Lubricate the bearing threads and install washer (35) and nut (30). Do not tighten this nut.

CAUTION: DO NOT USE THE GOOD BOLTS (15) AND LOCKPLATES (10) TO HOLD BEARING (40) WHEN YOU TIGHTEN NUT (30), OR THE BOLTS COULD BE DAMAGED. USE OTHER BOLTS OF EQUIVALENT SIZE WHEN YOU DO THIS TASK.

(e) Hold bearing (40), and tighten nut (30) to 2500-2750 lb-in. with tool ST2583-13.

(f) Install lockplates (10, 10L) on bearing (40) and nut (30). Install items (15, 20, 25) with wet BMS 5-95 sealant. Tighten nut (25) to 50-75 lb-in.

(g) Lockwire bolts (80) to each other, and lockwire reservoir (50) to lock (90). Use the double twist method of SOPM 20-50-02.



ITEM NUMBERS REFER TO FIG. 8

BEARING INSTL (45)
65C32102

Bearing Sealant Application
Figure 4B

Ref Letter Fig. 5	Mating Item No.	IPL Fig. No.	Design Dimensions				Service Wear Limits		
			Dimensions		Assembly Clearance		Dimension Limits		Maximum Allowable Clearance
			Min	Max	Min	Max	Min	Max	
A	*[1] 140	6			0.0020	0.0055			0.0150
A	*[1] 180	7							0.0150
A	*[1] 125	8			0.0020	0.0055			0.0150
B	ID 185	6	1.1250	1.1265				1.1320	
B	ID 65, 66	7	1.1250	1.1265				1.1320	
B	ID 170	8	1.4560	1.4570					
C	ID 70 thru 74	7	1.4375	1.4390				1.4445	
D	*[1] 40	8			0.0015	0.0040			

*[1] Clearance between inner ball and outer race

ALL DIMENSIONS ARE IN INCHES

Fits and Clearances
Figure 5

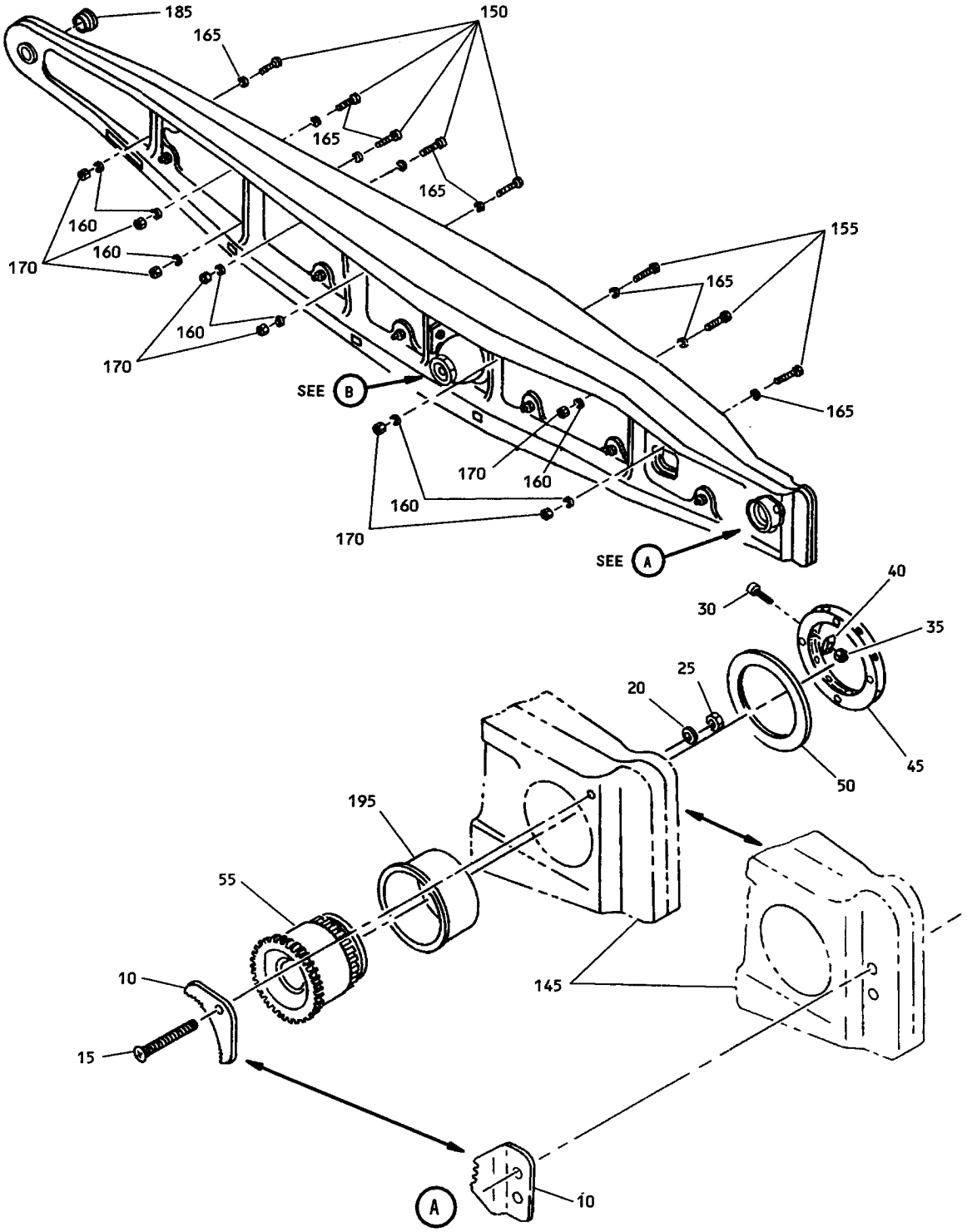
6. SPECIAL TOOLS, FIXTURES, AND EQUIPMENT

NOTE: Equivalent substitutes can be used.

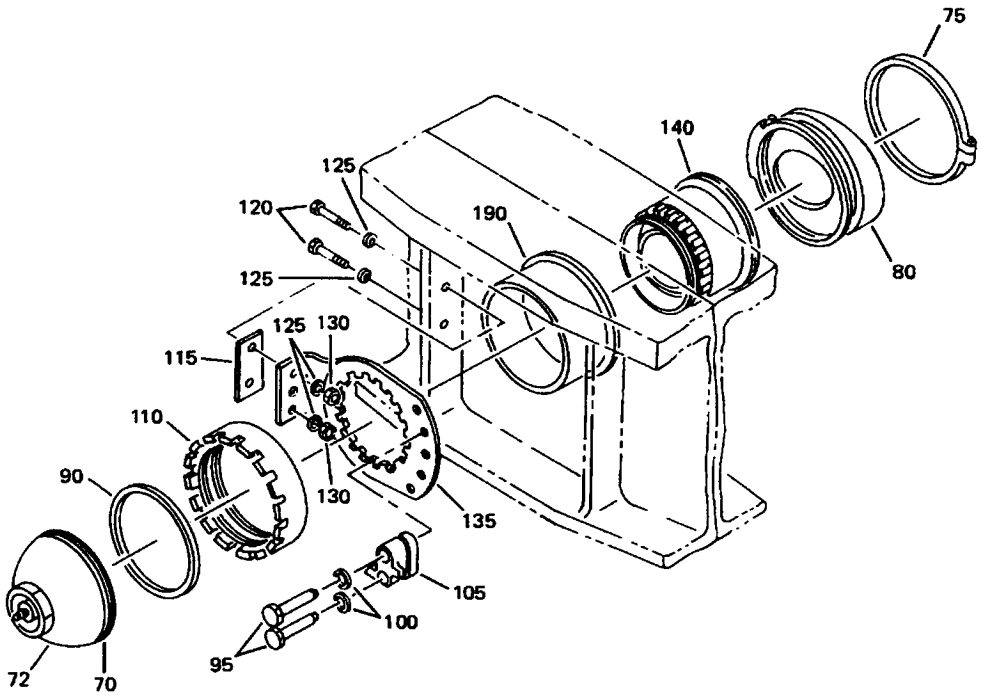
A. ST2580-422 -- Spanner Wrench

B. ST2583-13 -- Wrench Spline Drive Standard Tool

7. ILLUSTRATED PARTS LIST



65-82764
Wing Main Landing Gear Beam Assembly
Figure 6 (Sheet 1)



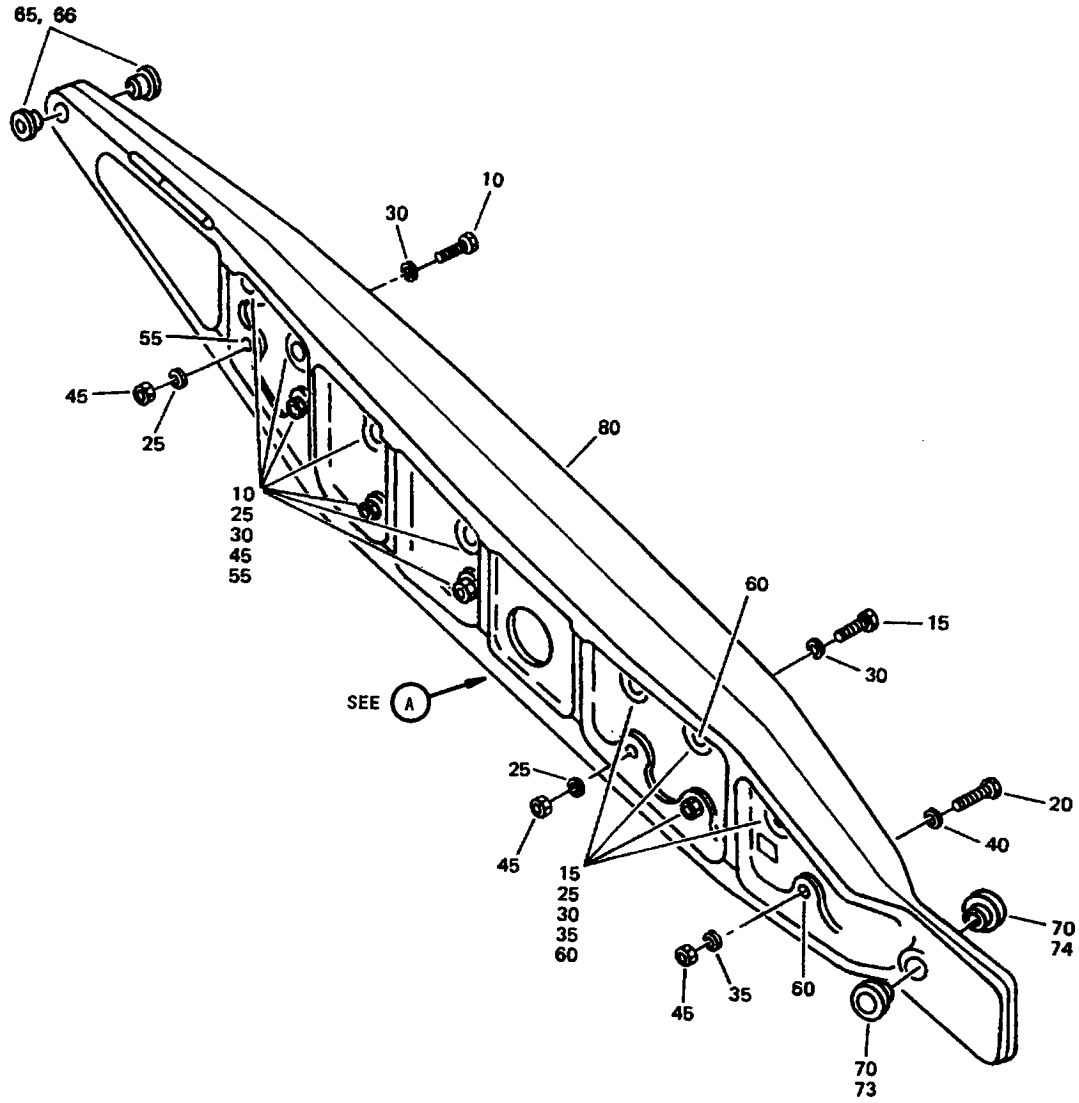
65-82764

Wing Main Landing Gear Beam Assembly
Figure 6 (Sheet 2)

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
6-					
	65-82764-1		BEAM ASSY, WING MLG	A	RF
	65-82764-2		BEAM ASSY, WING MLG	B	RF
	65-82764-15		BEAM ASSY, WING MLG	C	RF
	65-82764-16		BEAM ASSY, WING MLG	D	RF
	65-82764-19		BEAM ASSY, WING MLG (POST SB 57-1073)	E	RF
	65-82764-20		BEAM ASSY, WING MLG (POST SB 57-1073)	F	RF
	65-82764-21		BEAM ASSY, WING MLG (POST SB 57-1073)	G	RF
	65-82764-22		BEAM ASSY, WING MLG (POST SB 57-1073)	H	RF
	65-82764-27		BEAM ASSY, WING MLG	I	RF
	65-82764-28		BEAM ASSY, WING MLG	J	RF
	65-82764-31		BEAM ASSY, WING MLG	K	RF
	65-82764-32		BEAM ASSY, WING MLG	L	RF
	65-82764-35		BEAM ASSY, WING MLG	M	RF
	65-82764-36		BEAM ASSY, WING MLG	N	RF
	65-82764-39		BEAM ASSY, WING MLG	O	RF
	65-82764-40		BEAM ASSY, WING MLG	P	RF
5	MS27253-1		. PLATE, IDENTIFICATION		1
10	69-63566-1		. PLATE, LOCK	A-DI-P	1
10	69-65315-1		. PLATE, LOCK	EG	1
10	69-65315-2		. PLATE, LOCK	FH	1
			ATTACHING PARTS		
15	BACB30EL4-37		. BOLT (SUPSD BY BACB30EL4-38)	A-DIJ	1
15	BACB30LU3-21		. BOLT	E-H	2
15	BACB30EL4-38		. BOLT (SUPSDS BACB30EL4-37)	A-DIJ	1
15	BACB30LU3-38		. BOLT	K-P	1
20	AN960PD416		. WASHER	A-DIJ	1
20	AN960PD10		. WASHER	E-H	2
25	BACN10JC4		. NUT	A-DIJ	1
25	BACN10JC3		. NUT	E-H	2
			---------*---------		
30	MS21262-71		. SCREW		1
35	BACN10JC3		. NUT		1
40	69-63909-1		. BLOCK, RADIUS		1
45	69-63565-1		. NUT		1
50	69-63569-1		. WASHER		1
55	P20730-1		. BEARING, V57606 (BOEING 10-61857-4)		1
55	VTB01330-4		. BEARING, V06410 OR V06710 (BOEING 10-61857-4)		1
55	AMB22-4005		. BEARING, V15860 (BOEING 10-61857-1) (OPT)		1
55	HSFP22BD		. BEARING, V73134 (BOEING 10-61857-1) (OPT)		1
55	VTB01330		. BEARING, V06710 (BOEING 10-61857-1) (OPT)		1
55	P25320		. BEARING, V57606 (BOEING 10-61857-1) (OPT)		1
60	65-84104-1		. BEARING INSTL, REAR TRUNNION		1

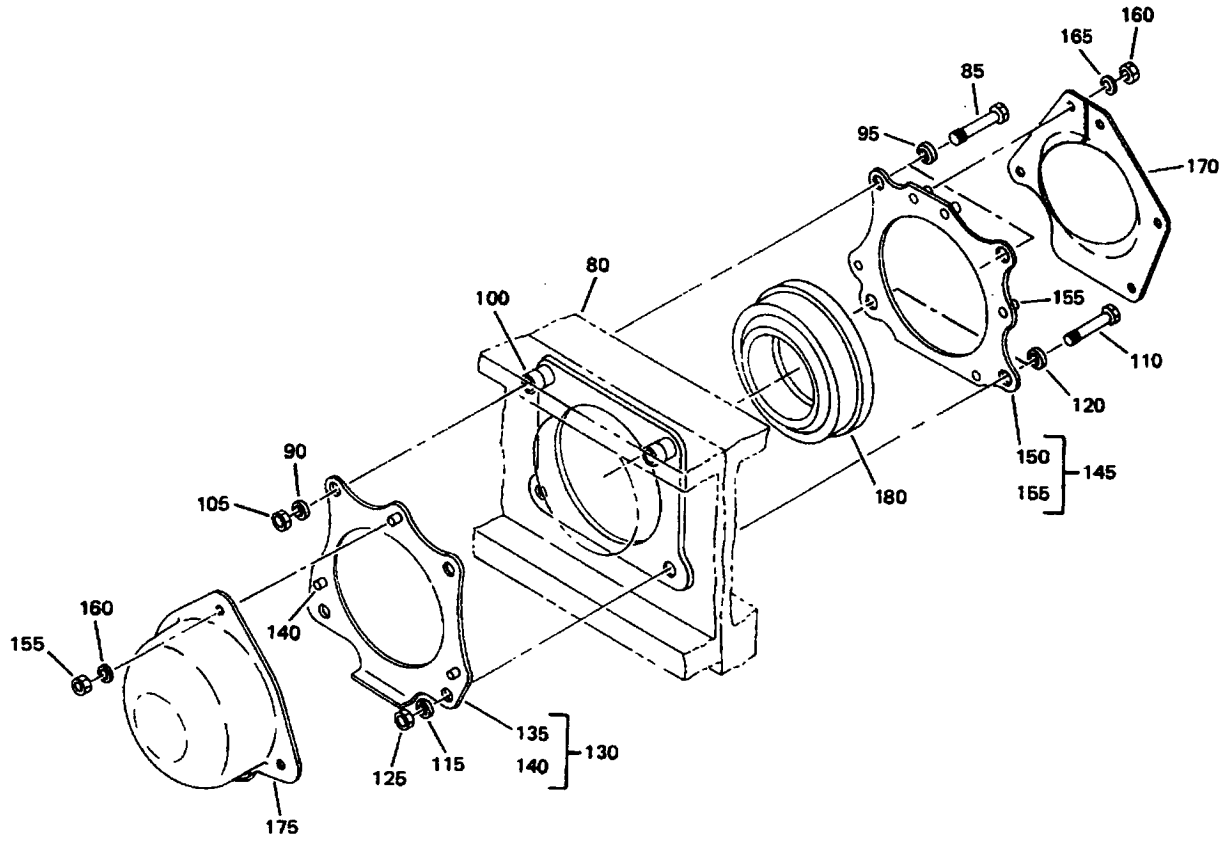
FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
6-					
65	65-84107-1		. . RESERVOIR ASSY, GREASE		1
70	65-84107-2		. . . RESERVOIR		1
72	MS15001-1		. . . FITTING, LUBE		1
75	802-512		. . CLAMP, V01268		1
75	C30E35-512		. . CLAMP, V14242 (OPT)		1
75	E70-512		. . CLAMP, V94581 (OPT)		1
75	E70S1-512		. . CLAMP, V94581 (OPT)		1
80	65-84110-2		. . SEAL		1
80	65-84110-1		. . SEAL (OPT)		1
90	69-63570-1		. . RING, SEAL		1
95	69-63571-1		. . BOLT		2
100	AN960C516		. . WASHER		2
105	65-84108-1		. . LOCK		1
110	65-84106-1		. . NUT		1
115	BACS40R10C 28F		. . SHIM		AR
120	BACB30NE4-11		. . BOLT		2
125	AN960PD416		. . WASHER		4
130	BACN10JC4		. . NUT		2
135	65-84105-1		. . RETAINER		1
140	ASBB48-2		. . BEARING, V15860 (BOEING10-61854-1) (LIMITED)		1
140	HSFP48ABA		. . BEARING, V73134 (BOEING10-61854-1) (LIMITED)		1
140	KSSB48-16		. . BEARING, V97613 (BOEING10-61854-1) (LIMITED)		1
140	55904		. . BEARING, V09455 (BOEING10-61854-1) (LIMITED)		1
140	VTB01340		. . BEARING, V06710 (BOEING10-61854-4) (LIMITED)		1
140	P25360		. . BEARING, V57606 (BOEING 10-61854-6) (LIMITED)		1
140	10-61854-8		. . BEARING (LIMITED)		1
140	P2A1260		. . BEARING, V57606 (BOEING 10-61854-10) (LIMITED)		1
140	VTB11990		. . BEARING, V06710 (BOEING 10-61854-10) (LIMITED)		1
145	65-82764-3		. BEAM ASSY - BONDED	A	1
145	65-82764-4		. BEAM ASSY - BONDED	B	1
145	65-82764-17		. BEAM ASSY - BONDED	C	1
145	65-82764-18		. BEAM ASSY - BONDED	D	1
145	65-82764-23		. BEAM ASSY - BONDED	EG	1
145	65-82764-24		. BEAM ASSY - BONDED	FH	1
145	65-82764-25		. BEAM ASSY - BONDED	I	1
145	65-82764-26		. BEAM ASSY - BONDED	J	1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
6-					
145	65-82764-29		. BEAM ASSY - BONDED	K	1
145	65-82764-30		. BEAM ASSY - BONDED	L	1
145	65-82764-33		. BEAM ASSY - BONDED	M	1
145	65-82764-34		. BEAM ASSY - BONDED	N	1
145	65-82764-37		. BEAM ASSY - BONDED	O	1
145	65-82764-38		. BEAM ASSY - BONDED	P	1
150	BACB30MT5T13		. BOLT		8
155	BACB30MT5T18		. BOLT		6
160	AN960PD516		. WASHER		14
165	BACW10BP5AC		. WASHER		14
170	BACN10HR5		. NUT		14
175	65-82764-5		. STRIP, RUB		1
180	66-25656-1		. STRIP, RUB	C-P	3
185	69-37867-60		. BUSHING	A-DI-P	2
185	69-37867-2		. BUSHING	E-H	2
190	65-84109-1		. BUSHING		1
195	69-63568-1		. SLEEVE		1
200	BACB30MT5T13		. BOLT (REPLD BY ITEM 200A)		8
200A	BACB30US5K13		. BOLT (REPLS ITEM 200)		8
205	BACB30MT5T18		. BOLT (REPLD BY ITEM 205A)		6
205A	BACB30US5K18		. BOLT (REPLS ITEM 205)		6
210	AN960PD516		. WASHER		14
215	BACW10BP5AC		. WASHER		14
220	BACN10HR5		. NUT		14



65-46401

Wing Main Landing Gear Beam Assembly
Figure 7 (Sheet 1)



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65-46401

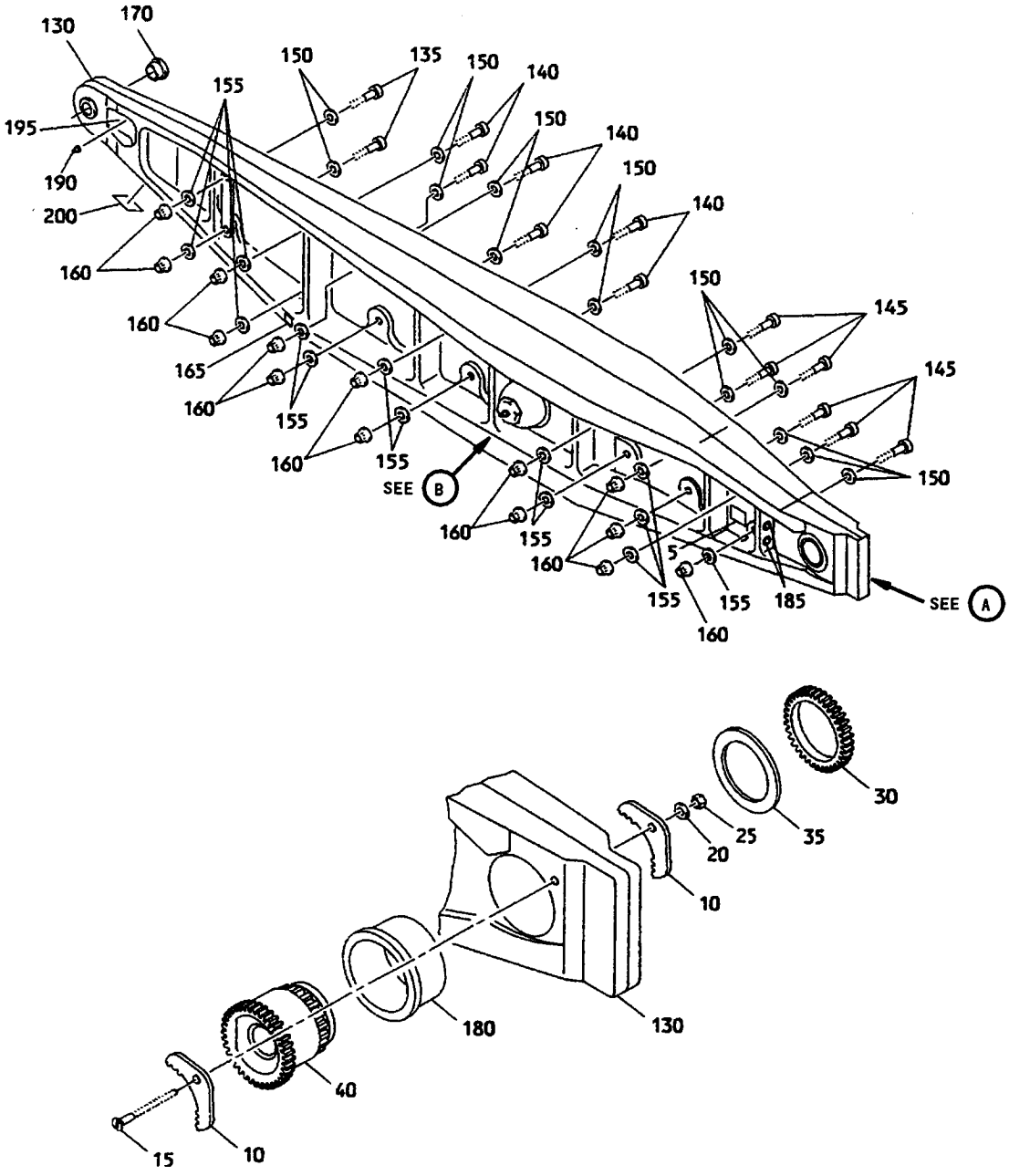
Wing Main Landing Gear Beam Assembly
Figure 7 (Sheet 2)

K58185

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
7-					
	65-46401-1		BEAM ASSY, WING MLG (PRE SB 57-1073)	A	RF
	65-46401-2		BEAM ASSY, WING MLG (PRE SB 57-1073)	B	RF
	65-46401-7		BEAM ASSY, WING MLG (PRE SB 57-1073)	C	RF
	65-46401-8		BEAM ASSY, WING MLG (PRE SB 57-1073)	D	RF
	65-46401-15		BEAM ASSY, WING MLG (PRE SB 57-1073)	E	RF
	65-46401-16		BEAM ASSY, WING MLG (PRE SB 57-1073)	F	RF
	65-46401-19		BEAM ASSY, WING MLG (PRE SB 57-1073)	G	RF
	65-46401-20		BEAM ASSY, WING MLG (PRE SB 57-1073)	H	RF
	65-46401-23		BEAM ASSY, WING MLG (PRE SB 57-1073)	I	RF
	65-46401-24		BEAM ASSY, WING MLG (PRE SB 57-1073)	J	RF
	65-46401-27		BEAM ASSY, WING MLG (PRE SB 57-1073)	K	RF
	65-46401-28		BEAM ASSY, WING MLG (PRE SB 57-1073)	L	RF
	65-46401-33		BEAM ASSY, WING MLG (PRE SB 57-1073)	M	RF
	65-46401-34		BEAM ASSY, WING MLG (PRE SB 57-1073)	N	RF
	65-46401-37		BEAM ASSY, WING MLG (PRE SB 57-1073)	O	RF
	65-46401-38		BEAM ASSY, WING MLG (PRE SB 57-1073)	P	RF
	65-46401-39		BEAM ASSY, WING MLG (PRE SB 57-1073)	Q	RF
	65-46401-40		BEAM ASSY, WING MLG (PRE SB 57-1073)	R	RF
	65-46401-41		BEAM ASSY, WING MLG (PRE SB 57-1073)	S	RF
	65-46401-42		BEAM ASSY, WING MLG (PRE SB 57-1073)	T	RF
	65-46401-43		BEAM ASSY, WING MLG (PRE SB 57-1073)	U	RF
	65-46401-44		BEAM ASSY, WING MLG (PRE SB 57-1073)	V	RF
	65-46401-69		BEAM ASSY, WING MLG	W	RF
	65-46401-70		BEAM ASSY, WING MLG	X	RF
	65-46401-71		BEAM ASSY, WING MLG (PRE SB 57-1073)	Y	RF
	65-46401-72		BEAM ASSY, WING MLG (PRE SB 57-1073)	Z	RF
	65-46401-73		BEAM ASSY, WING MLG (PRE SB 57-1073)	BA	RF
	65-46401-74		BEAM ASSY, WING MLG (PRE SB 57-1073)	CA	RF
5	MS27253-1		. PLATE, IDENTIFICATION		1
10	BACB30NM5C14		. BOLT (REPLS NAS1305-14)	A-V	8
10	NAS1305-14		. BOLT (REPLD BY BACB30NM5C14)	A-V	8
10	BACB30NM5C14		. BOLT	W-CA	8
15	BACB30NM5C18		. BOLT (REPLS NAS1305-18)	A-V	5
15	NAS1305-18		. BOLT (REPLD BY BACB30NM5C18)	A-V	5
15	BACB30NM5C18		. BOLT	W-CA	5
20	BACB30NM7C18		. BOLT (REPLS NAS1307-18)	A-V	1
20	NAS1307-18		. BOLT (REPLD BY BACB30NM7C18)	A-V	1
20	BACB30NM5C18		. BOLT	W-CA	1
25	AN960PD516		. WASHER	A-V	13
30	AN960PD516L		. WASHER	A-V	13
35	AN960PD716		. WASHER	A-V	1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
7-					
40	AN960PD716L		. WASHER	A-V	1
45	BACN10BL5L		. NUT	A-V	13
50	BACN10BL7L		. NUT		1
55	66-23234-2		. BUSHING		8
60	66-23234-3		. BUSHING		6
65	69-37867-2		. BUSHING (REPLD BY 69-37867-66, SB 57-1071)		2
66	69-37867-66		. BUSHING (REPLS 69-37867-2, SB 57-1071)		2
70	69-37867-1		. BUSHING (REPLD BY 65-85361-19, SB 57-1071)		2
71	65-85371-19		. BUSHING (REPLS 69-37867-1 SB 57-1071)		2
72	65-85371-20		. BUSHING (0.060 OVERSIZE) (SB 57-1071)		2
73	65-85371-21		. BUSHING (USED WITH ITEM 74) (0.12 OVERSIZE) (SB 57-1071)		1
74	65-85371-22		. BUSHING (USED WITH ITEM 73) (0.12 OVERSIZE) (SB 57-1071)		1
75	65-46401-31		. STRIP, RUB	GZ-CA	1
80	65-46401-3		. BEAM	A	1
80	65-46401-4		. BEAM	B	1
80	65-46401-9		. BEAM	C	1
80	65-46401-10		. BEAM	D	1
80	65-46401-17		. BEAM	E	1
80	65-46401-18		. BEAM	F	1
80	65-46401-21		. BEAM	G	1
80	65-46401-22		. BEAM	H	1
80	65-46401-25		. BEAM	I	1
80	65-46401-26		. BEAM	J	1
80	65-46401-29		. BEAM	K	1
80	65-46401-30		. BEAM	L	1
80	65-46401-45		. BEAM	M	1
80	65-46401-46		. BEAM	N	1
80	65-46401-49		. BEAM	O	1
80	65-46401-50		. BEAM	P	1
80	65-46401-51		. BEAM	Q	1
80	65-46401-52		. BEAM	R	1
80	65-46401-53		. BEAM	S	1
80	65-46401-54		. BEAM	T	1
80	65-46401-55		. BEAM	U	1
80	65-46401-56		. BEAM	V	1
80	65-46401-75		. BEAM	W	1
80	65-46401-76		. BEAM	X	1
80	65-46401-77		. BEAM	Y	1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
7-					
80	65-46401-78		. BEAM	Z	1
80	65-46401-79		. BEAM	BA	1
80	65-46401-80		. BEAM	CA	1
			INSTALLATION PARTS		
85	BACB30NM4C31		BOLT		2
85	NAS1304-31		BOLT (OPT)		2
90	AN960PD416		WASHER		2
95	AN960PD416L		WASHER		2
100	66-23234-1		BUSHING		2
105	BACN10BL4L		NUT		2
106	BACN10GW4		NUT		2
110	BACB30NM6C31		BOLT		2
110	NAS1306-31		BOLT (OPT)		2
115	AN960PD616		WASHER		2
120	AN960PD616L		WASHER		2
125	BACN10BL6L		NUT		2
126	BACN10GW6		NUT		2
130	69-44959-1		RING ASSY, RETAINING		1
130	69-44959-2		RING ASSY, RETAINING		1
135	69-44959-3		. RING, RETAINING (USED ON 69-44959-1)		1
135	69-44959-4		. RING, RETAINING (USED ON 69-44959-2)		1
140	BACS21AQ3C3K		. STUD		3
145	69-44957-1		RING ASSY, RETAINING		1
145	69-44957-2		RING ASSY, RETAINING		1
150	69-44957-3		. RING, RETAINING (USED ON 69-44957-1)		1
150	69-44957-4		. RING, RETAINING (USED ON 69-44957-2)		1
155	BACS21AQ3C3K		. STUD		4
160	BACN10JC3		NUT		8
165	AN960PD10L		WASHER		8
170	69-44958-1		COVER, DUST		1
175	69-44960-1		COVER, DUST		1
180	KSSN48-11		BEARING, V97613 (BOEING 10-60545-83)		1
180	NHSB48-203		BEARING, V15860 (BOEING 10-60545-83)		1
180	ASBT48-105		BEARING, V50294 (BOEING 10-60545-83)		1
180	NSPR41BAC		BEARING, V73134 (BOEING 10-60545-83)		1
180	176388		BEARING, V09455 (BOEING 10-60545-83)		1
180	KSSN48-3		BEARING, V97613 (BOEING 10-60545-41) (OPT)		1
180	76415		BEARING, V09455 (BOEING 10-60545-41) (OPT)		1
180	176193		BEARING, V09455 (BOEING 10-60545-41) (OPT)		1
180	69-60733-1		BEARING (OPT)		1



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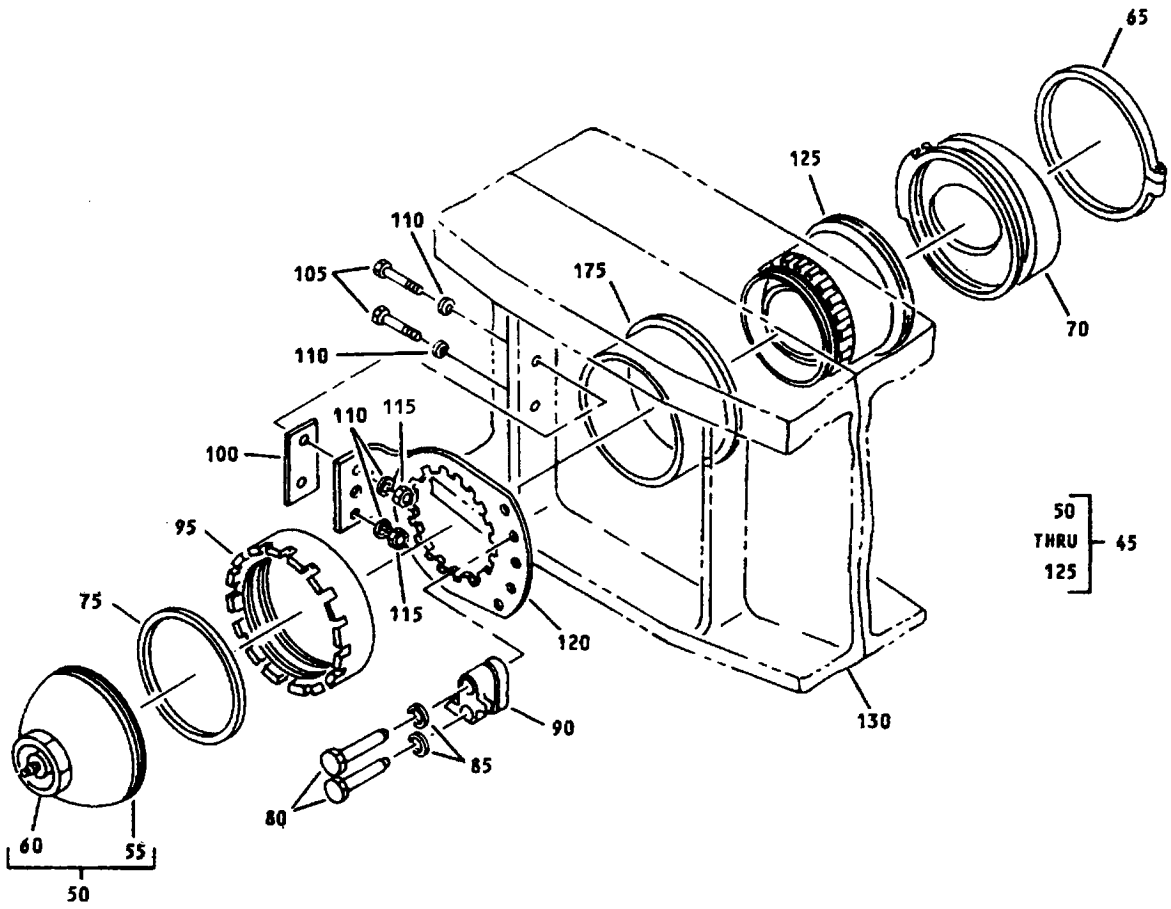
65C32102

Main Landing Gear Beam Assembly
Figure 8 (Sheet 1)



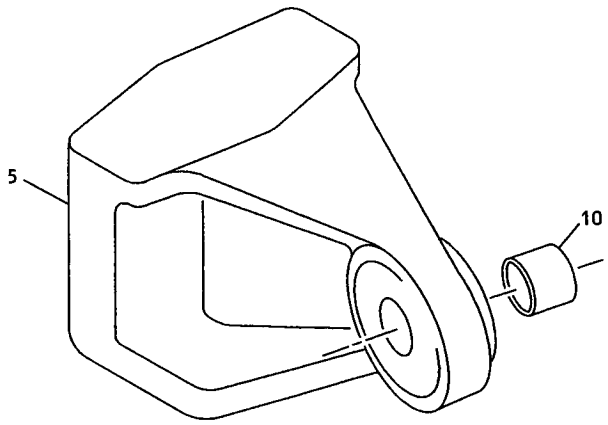
B

65C32102

Main Landing Gear Beam Assembly
Figure 8 (Sheet 2)

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
8-					
-1	65C32102-7		BEAM ASSY, MLG	A	RF
-1	65C32102-8		BEAM ASSY, MLG	B	RF
5	MS27253-1		. PLATE, IDENTIFICATION		1
10	65C33087-1		. PLATE, LOCK	A	1
10	65C33087-2		. PLATE, LOCK	B	1
10L	65C33087-3		. PLATE, LOCK	A	1
10L	65C33087-4		. PLATE, LOCK	B	1
15	BACB30NN4K43		. BOLT		1
20	AN960JD416		. WASHER		1
25	BACN10YR4CD		. NUT		1
30	69-77143-1		. NUT		1
35	69-77128-1		. WASHER		1
40	P26220		. BEARING, V57606 (BOEING 10-62098-5)		1
40	VTB10370		. BEARING, V06710 (BOEING 10-62098-5)		1
45	65-84104-1		. BEARING INSTL, REAR TRUNNION		1
50	65-84107-1		. . RESERVOIR ASSY, GREASE		1
55	65-84107-2		. . . RESERVOIR		1
60	MS15001-1		. . . FITTING, GREASE		1
65	802-512		. . CLAMP, V01268		1
65	C30E35-512		. . CLAMP, V14242		1
65	E70S1-512		. . CLAMP, V94581		1
70	65-84110-1		. . SEAL (LIMITED)		1
70	65-84110-2		. . SEAL (LIMITED)		1
70	65-84110-3		. . SEAL (LIMITED)		1
75	69-63570-1		. . RING, SEAL		1
80	69-63571-1		. . BOLT		2
85	AN960C516		. . WASHER		2
90	65-84108-1		. . LOCK		1
95	65-84106-1		. . NUT		1
100	69-76618-1		. . SHIM (PREF)		AR
100	BACS40R10C28F		. . SHIM (OPT)		AR
105	NAS6704-11		. . BOLT (LIMITED)		2
105	NAS6704-15		. . BOLT (LIMITED)		2
110	AN960JD416		. . WASHER		4
115	BACN10YR4CD		. . NUT		2
120	65-84105-1		. . RETAINER		1
125	ASBB48-2		. . BEARING, V15860 (BOEING 10-61854-1)(LIMITED)		1
125	HSFP48ABA		. . BEARING, V73134 (BOEING 10-61854-1)(LIMITED)		1
125	KSSB48-16		. . BEARING, V97613 (BOEING 10-61854-1)(LIMITED)		1
125	55904		. . BEARING, V09455 (BOEING 10-61854-1)(LIMITED)		1

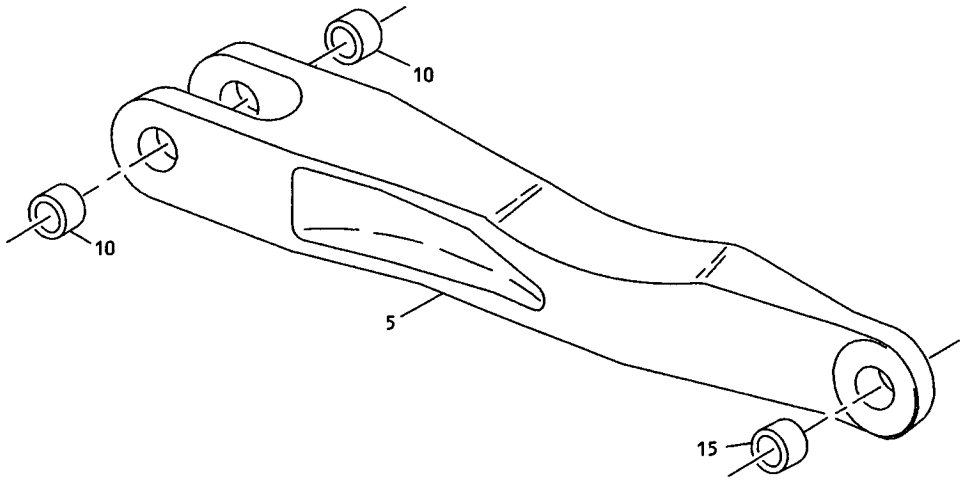
FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
8-					
125	VTB01340		. . BEARING, V06710 (BOEING 10-61854-4) (LIMITED)		1
125	P25360		. . BEARING, V57606 (BOEING 10-61854-6) (LIMITED)		1
125	10-61854-8		. . BEARING (LIMITED)		1
125	P2A1260		. . BEARING, V57606 (BOEING 10-61854-10) (LIMITED)		1
125	VTB11990		. . BEARING, V06710 (BOEING 10-61854-10) (LIMITED)		1
130	65C32102-9		. BOND ASSY	A	1
130	65C32102-10		. BOND ASSY	B	1
135	BACB30LE6-16		. BOLT		2
140	BACB30LE6-14		. BOLT		6
145	BACB30LE6-19		. BOLT		6
150	BACW10BP6AC		. WASHER		14
155	BACW10BP6AP		. WASHER		14
160	BACN10HR6CD		. NUT		14
165	66-25656-1		. RUB STRIP		1
170	69-77114-1		. BUSHING		2
175	65-84109-1		. BUSHING		1
180	69-77043-1		. SLEEVE		1
185	BACB28AP04P038		. BUSHING		2
190	MS15004-1		. FITTING, GREASE		1
195	65C32102-11		. TUBE		1
200	65C32102-5		. RUB STRIP		1



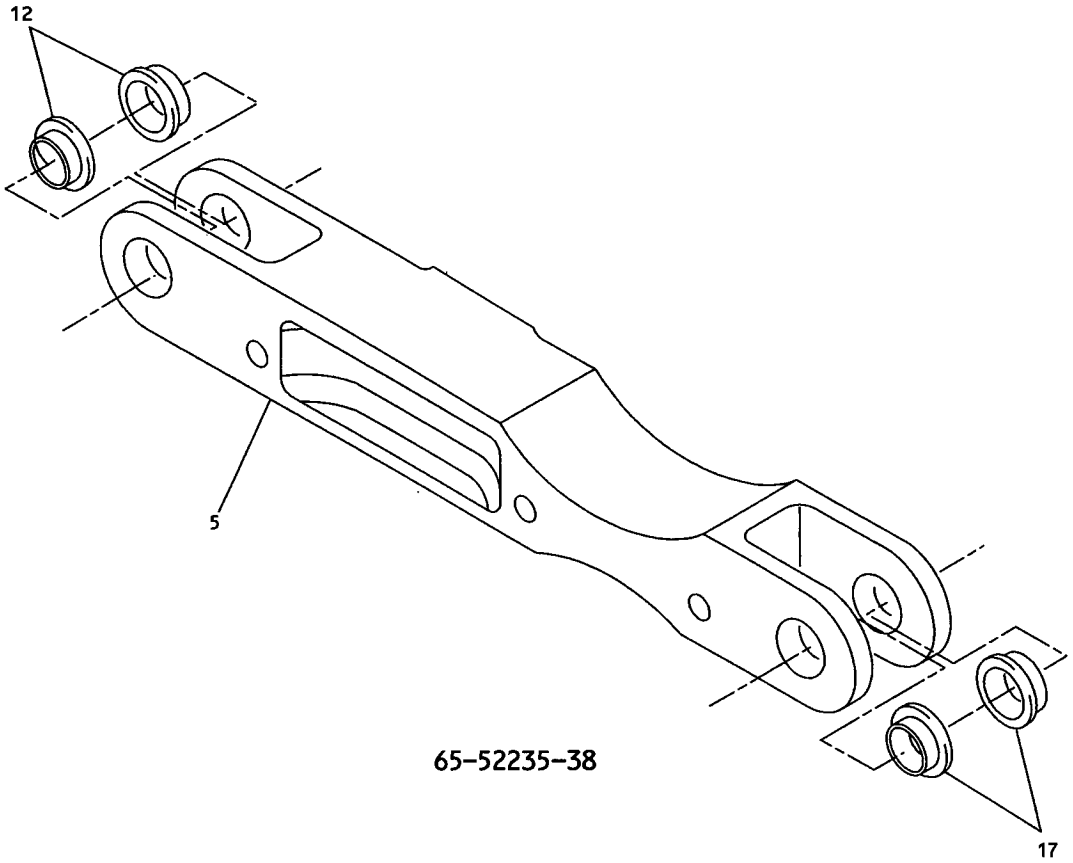
65-49442

Inboard Stabilizing Fitting 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-					
-1	65-49442-1		FITTING ASSY, REAR SPAR INBD STABILIZING	A	RF
-1	65-49442-2		FITTING ASSY, REAR SPAR INBD STABILIZING	B	RF
-1	65-49442-7		FITTING ASSY, REAR SPAR INBD STABILIZING	C	RF
-1	65-49442-8		FITTING ASSY, REAR SPAR INBD STABILIZING	D	RF
5	65-49442-3		. FITTING	A	1
5	65-49442-4		. FITTING	B	1
5	65-49442-9		. FITTING	C	1
5	65-49442-10		. FITTING	D	1
10	10-60516-206		. BUSHING		1



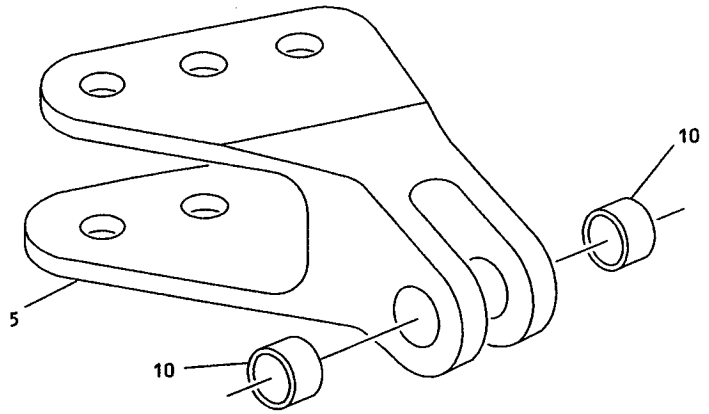
65-52235-1,-2,-7 THRU -10,-15,-16,-27 THRU -32,-35,-36



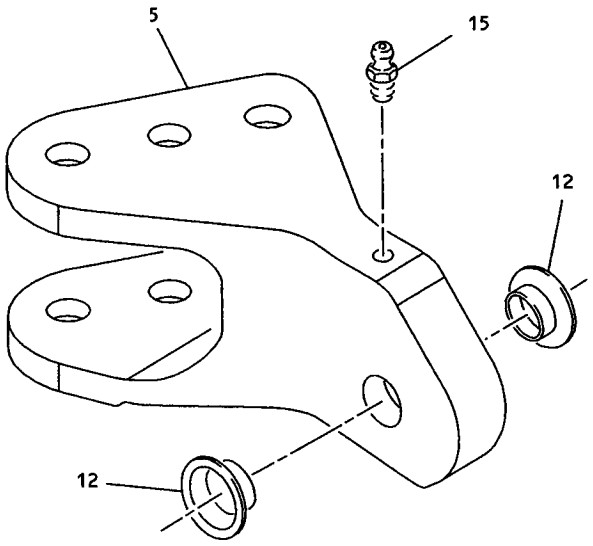
65-52235-38

Inboard Landing Gear Beam Stabilizer 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-					
-1	65-52235-1		STABILIZER ASSY,INBD LG BEAM	A	RF
-1	65-52235-2		STABILIZER ASSY,INBD LG BEAM	B	RF
-1	65-52235-7		STABILIZER ASSY,INBD LG BEAM	C	RF
-1	65-52235-8		STABILIZER ASSY,INBD LG BEAM	D	RF
-1	65-52235-9		STABILIZER ASSY,INBD LG BEAM	E	RF
-1	65-52235-10		STABILIZER ASSY,INBD LG BEAM	F	RF
-1	65-52235-15		STABILIZER ASSY,INBD LG BEAM	G	RF
-1	65-52235-16		STABILIZER ASSY,INBD LG BEAM	H	RF
-1	65-52235-27		STABILIZER ASSY,INBD LG BEAM	I	RF
-1	65-52235-28		STABILIZER ASSY,INBD LG BEAM	J	RF
-1	65-52235-29		STABILIZER ASSY,INBD LG BEAM	K	RF
-1	65-52235-30		STABILIZER ASSY,INBD LG BEAM	L	RF
-1	65-52235-31		STABILIZER ASSY,INBD LG BEAM	M	RF
-1	65-52235-32		STABILIZER ASSY,INBD LG BEAM	N	RF
-1	65-52235-35		STABILIZER ASSY,INBD LG BEAM	O	RF
-1	65-52235-36		STABILIZER ASSY,INBD LG BEAM	P	RF
-1	65-52235-38		STABILIZER ASSY,INBD LG BEAM	Q	RF
5	65-52235-3		. STABILIZER	A	1
5	65-52235-4		. STABILIZER	B	1
5	65-52235-11		. STABILIZER	C	1
5	65-52235-12		. STABILIZER	D	1
5	65-52235-13		. STABILIZER	E	1
5	65-52235-14		. STABILIZER	F	1
5	65-52235-17		. STABILIZER	G	1
5	65-52235-18		. STABILIZER	H	1
5	65-52235-21		. STABILIZER	I	1
5	65-52235-22		. STABILIZER	J	1
5	65-52235-23		. STABILIZER	K	1
5	65-52235-24		. STABILIZER	L	1
5	65-52235-25		. STABILIZER	M	1
5	65-52235-26		. STABILIZER	N	1
5	65-52235-33		. STABILIZER	O	1
5	65-52235-34		. STABILIZER	P	1
5	65-52235-37		. STABILIZER	Q	1
10	10-60516-205		. BUSHING	A-P	2
12	BACB28AT12B 036C		. BUSHING	Q	2
15	10-60516-206		. BUSHING	A-P	1
17	BACB28AT12B 029C		. BUSHING	Q	2



65-67172-1,-2,-5,-6,-13,-14,-17,-18

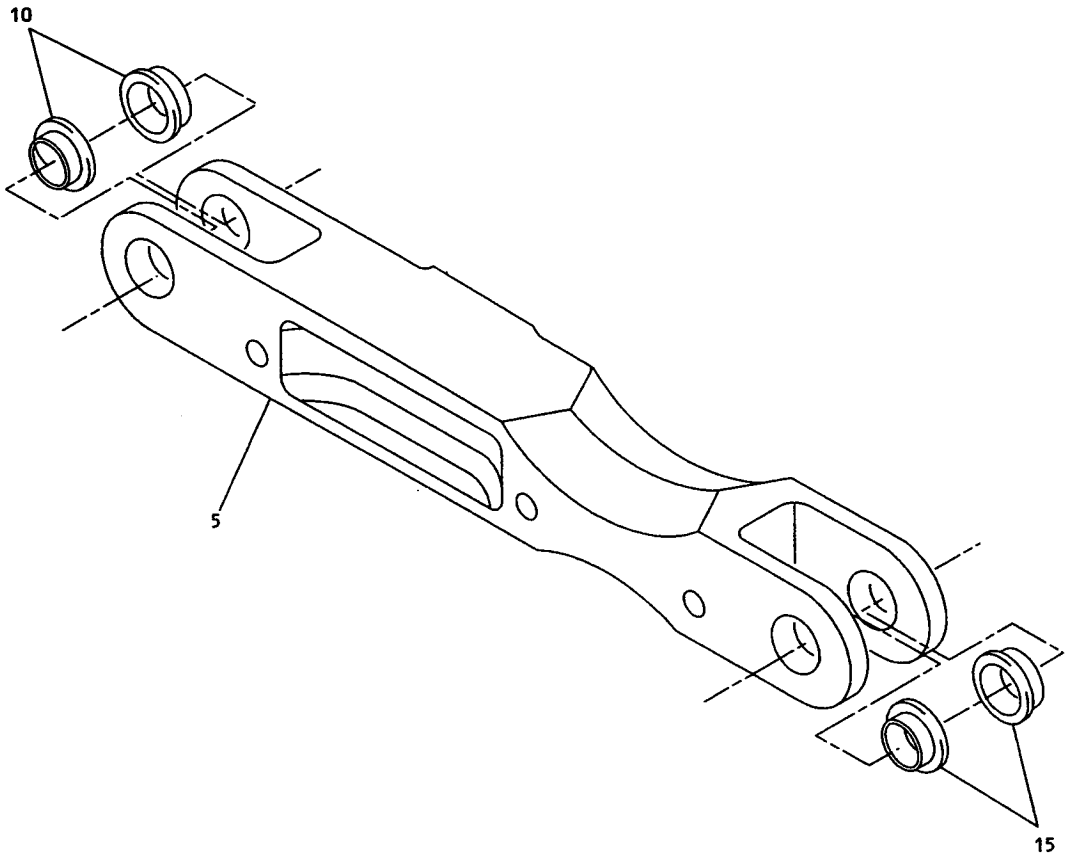


65-67172-23 THRU -26,-29,-30,-33,-34

Inboard Stabilizing Landing Gear Beam Fitting 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-					
-1	65-67172-1		FITTING ASSY, LG BEAM INBD STABILIZING	A	RF
-1	65-67172-2		FITTING ASSY, LG BEAM INBD STABILIZING	B	RF
-1	65-67172-5		FITTING ASSY, LG BEAM INBD STABILIZING	C	RF
-1	65-67172-6		FITTING ASSY, LG BEAM INBD STABILIZING	D	RF
-1	65-67172-13		FITTING ASSY, LG BEAM INBD STABILIZING	E	RF
-1	65-67172-14		FITTING ASSY, LG BEAM INBD STABILIZING	F	RF
-1	65-67172-17		FITTING ASSY, LG BEAM INBD STABILIZING	G	RF
-1	65-67172-18		FITTING ASSY, LG BEAM INBD STABILIZING	H	RF
-1	65-67172-23		FITTING ASSY, LG BEAM INBD STABILIZING	I	RF
-1	65-67172-24		FITTING ASSY, LG BEAM INBD STABILIZING	J	RF
-1	65-67172-25		FITTING ASSY, LG BEAM INBD STABILIZING	K	RF
-1	65-67172-26		FITTING ASSY, LG BEAM INBD STABILIZING	L	RF
-1	65-67172-29		FITTING ASSY, LG BEAM INBD STABILIZING	M	RF
-1	65-67172-30		FITTING ASSY, LG BEAM INBD STABILIZING	N	RF
-1	65-67172-33		FITTING ASSY, LG BEAM INBD STABILIZING	P	RF
-1	65-67172-34		FITTING ASSY, LG BEAM INBD STABILIZING	Q	RF
5	65-67172-3		. FITTING	A	1
5	65-67172-4		. FITTING	B	1
5	65-67172-7		. FITTING	C	1
5	65-67172-8		. FITTING	D	1
5	65-67172-15		. FITTING	E	1
5	65-67172-16		. FITTING	F	1
5	65-67172-19		. FITTING	G	1
5	65-67172-20		. FITTING	H	1
5	65-67172-21		. FITTING	I	1
5	65-67172-22		. FITTING	J	1
5	65-67172-27		. FITTING	K	1
5	65-67172-28		. FITTING	L	1
5	65-67172-31		. FITTING	M	1

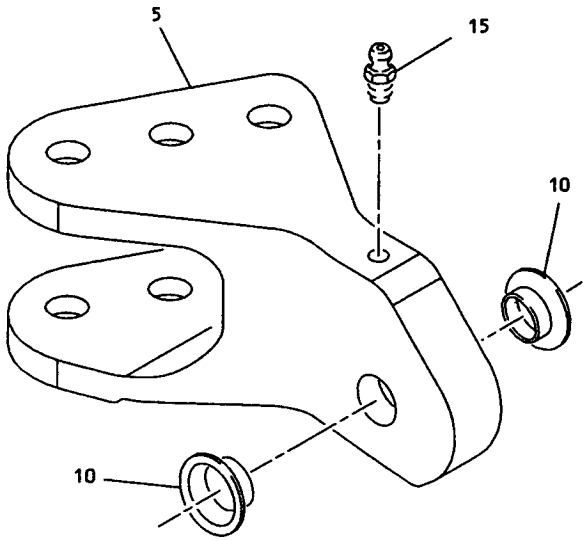
FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
11-					
5	65-67172-32		. FITTING	N	1
5	65-67172-35		. FITTING	O	1
5	65-67172-36		. FITTING	P	1
10	10-60516-205		. BUSHING	A-H	2
12	BACB28AT12B 034C		. BUSHING	J-P	2
15	MS15001-1		. FITTING, LUBE	J-P	1



65C32697

Inboard Landing Gear Beam Stabilizer Assembly
Figure 12

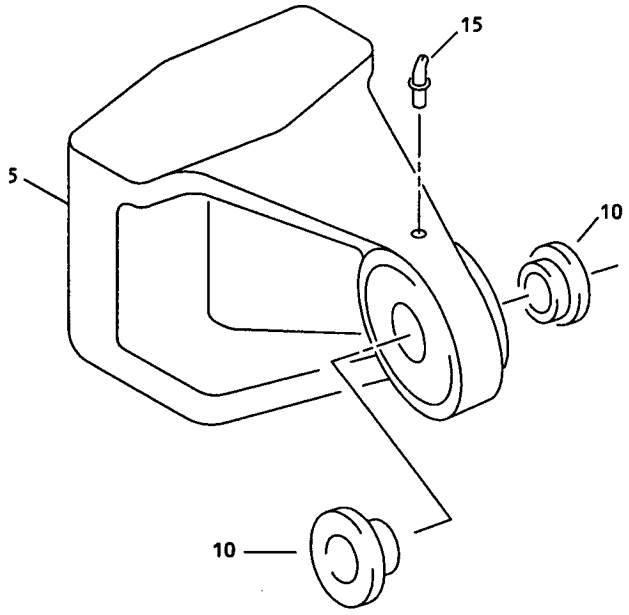
FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
12-					
1	65C32697-5		LINK ASSY - INBD STABILIZER	A	RF
1	65C32697-7		LINK ASSY - INBD STABILIZER	B	RF
5	65C32697-2		. LINK	A	1
5	65C32697-4		. LINK	B	1
10	69-77058-4		. BUSHING		2
15	69-77058-5		. BUSHING		2



65C32699-1,-2

Inboard Stabilizer Link Fitting 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	65C32699-1		FITTING ASSY - INBD STABILIZER LINK	A	RF
1	65C32699-2		FITTING ASSY - INBD STABILIZER LINK	B	RF
5	65C32699-3		. FITTING	A	1
5	65C32699-4		. FITTING	B	1
10	69-77058-13		. BUSHING		2
15	MS15001-1		. FITTING- LUBE		1



65C32918

Inboard Stabilizing Fitting Assembly
Figure 14

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
14-					
-1	65C32918-1		FITTING ASSY, REAR SPAR INBD STABILIZING	A	RF
-1	65C32918-2		FITTING ASSY, REAR SPAR INBD STABILIZING	B	RF
-1	65C32918-7		FITTING ASSY, REAR SPAR INBD STABILIZING	C	RF
-1	65C32918-8		FITTING ASSY, REAR SPAR INBD STABILIZING	D	RF
-1	65C32918-17		FITTING ASSY, REAR SPAR INBD STABILIZING	E	RF
-1	65C32918-18		FITTING ASSY, REAR SPAR INBD STABILIZING	F	RF
-1	65C32918-19		FITTING ASSY, REAR SPAR INBD STABILIZING	G	RF
-1	65C32918-20		FITTING ASSY, REAR SPAR INBD STABILIZING	H	RF
5	65C32918-3		. FITTING	AE	1
5	65C32918-4		. FITTING	BF	1
5	65C32918-9		. FITTING	C	1
5	65C32918-10		. FITTING	D	1
5	65C32918-21		. FITTING	G	1
5	65C32918-22		. FITTING	H	1
10	69-77049-1		. BUSHING		2
15	NAS516-1A		. FITTING - LUBE		1

VENDORS

VS0352	NMB MINEBEA CO. LTD., KARUIZAWA MFG. UNIT, ROD END DIV., 4106-73 MIYOTA-MACHI KITSAKU-GUN NAGANO-KEN 389-0293, JAPAN
V01268	AEROQUIP CORP., AEROQUIP AEROSPACE DIV., MARMAN PLANT, 11214 EXPOSITION BLVD., LOS ANGELES, CALIFORNIA 90064-3117
V06710	VALLEY-TODECO, 12975 BRADLEY AVE., SYLMAR, CALIFORNIA 91342-3830
V09455	RBC TRANSPORT DYNAMICS CORP., 3131 SEGERSTROM AVE., SANTA ANA, CALIFORNIA 92704-5872
V14242	VOSS INDUSTRIES INC., 2168 W. 25TH ST., CLEVELAND, OHIO 44113-4115
V15860	NEW HAMPSHIRE BALL BEARINGS, INC., ASTRO DIV., 155 LEXINGTON AVE., LACONIA, NEW HAMPSHIRE, 03246-2993
V50294	NEW HAMPSHIRE BALL BEARINGS, INC., 9700 INDEPENDENCE AVE., CHATSWORTH, CALIFORNIA 91311-4373
V57606	REXNORD CORP., PSI BEARINGS DIV., 2175 UNION PL., SIMI VALLEY, CALIFORNIA 93065-1661
V73134	ROLLER BEARING CO. OF AMERICA, HEIM BEARINGS DIV., 60 ROUND HILL RD., P.O. BOX 430, FAIRFIELD, CONNECTICUT 06430-0430
V94581	VIJ CORP., DBA NATIONAL UTILITIES CO., 1700 HICKORY DR., P.O. BOX 14639, FORT WORTH, TEXAS 76117-6020
V97613	SARGENT CONTROLS AND AEROSPACE, KAHR BEARING DIV., 5675 W. BURLINGAME RD., TUCSON, ARIZONA 85743, OR P.O. BOX 730, CORTARO, ARIZONA 85652-0730

Part No.	Fig. and Index No.	Qty. per Assy.
AMB22-4005	6-55	1
AN960C516	6-100	2
AN960C516	8-85	2
AN960JD416	8-110	4
AN960JD416	8-20	1
AN960PD10	6-20	2
AN960PD10L	7-165	8
AN960PD416	6-125	4
AN960PD416	6-20	1
AN960PD416	7-90	2
AN960PD416L	7-95	2
AN960PD516	6-160	14
AN960PD516	6-210	14
AN960PD516	7-25	13
AN960PD516L	7-30	13
AN960PD616	7-115	2
AN960PD616L	7-120	2
AN960PD716	7-35	1
AN960PD716L	7-40	1
ASBB48-2	6-140	1
ASBB48-2	8-125	1
ASBT48-105	7-180	1
BACB28AP04P038	8-185	2
BACB28AT12B029C	10-17	2
BACB28AT12B034C	11-12	2
BACB28AT12B036C	10-12	2
BACB30EL4-37	6-15	1
BACB30EL4-38	6-15	1
BACB30LE6-14	8-140	6
BACB30LE6-16	8-135	2
BACB30LE6-19	8-145	6
BACB30LU3-21	6-15	2
BACB30LU3-38	6-15	1
BACB30MT5T13	6-150	8
BACB30MT5T13	6-200	8
BACB30MT5T18	6-155	6
BACB30MT5T18	6-205	6
BACB30NE4-11	6-120	2
BACB30NM4C31	7-85	2
BACB30NM5C14	7-10	8
BACB30NM5C14	7-10	8
BACB30NM5C18	7-15	5
BACB30NM5C18	7-15	5
BACB30NM5C18	7-20	1
BACB30NM6C31	7-110	2
BACB30NM7C18	7-20	1
BACB30NN4K43	8-15	1

Part No.	Fig. and Index No.	Qty. per Assy.
BACB30US5K13	6-200A	8
BACB30US5K18	6-205A	6
BACN10BL4L	7-105	2
BACN10BL5L	7-45	13
BACN10BL6L	7-125	2
BACN10BL7L	7-50	1
BACN10GW4	7-106	2
BACN10GW6	7-126	2
BACN10HR5	6-170	14
BACN10HR5	6-220	14
BACN10HR6CD	8-160	14
BACN10JC3	6-25	2
BACN10JC3	6-35	1
BACN10JC3	7-160	8
BACN10JC4	6-130	2
BACN10JC4	6-25	1
BACN10YR4CD	8-115	2
BACN10YR4CD	8-25	1
BACS21AQ3C3K	7-140	3
BACS21AQ3C3K	7-155	4
BACS40R10C28F	6-115	AR
BACS40R10C28F	8-100	AR
BACW10BP5AC	6-165	14
BACW10BP5AC	6-215	14
BACW10BP6AC	8-150	14
BACW10BP6AP	8-155	14
C30E35-512	6-75	1
C30E35-512	8-65	1
E70-512	6-75	1
E70S1-512	6-75	1
E70S1-512	8-65	1
HSFP22BD	6-55	1
HSFP48ABA	6-140	1
HSFP48ABA	8-125	1
KSSB48-16	6-140	1
KSSB48-16	8-125	1
KSSN48-11	7-180	1
KSSN48-3	7-180	1
MS15001-1	11-15	1
MS15001-1	13-15	1
MS15001-1	6-72	1
MS15001-1	8-60	1
MS15004-1	8-190	1
MS21262-71	6-30	1
MS27253-1	6-5	1
MS27253-1	7-5	1
MS27253-1	8-5	1

Part No.	Fig. and Index No.	Qty. per Assy.
NAS1304-31	7-85	2
NAS1305-14	7-10	8
NAS1305-18	7-15	5
NAS1306-31	7-110	2
NAS1307-18	7-20	1
NAS516-1A	14-15	1
NAS6704-11	8-105	2
NAS6704-15	8-105	2
NHSB48-203	7-180	1
NSPR41BAC	7-180	1
P20730-1	6-55	1
P25320	6-55	1
P25360	6-140	1
P25360	8-125	1
P26220	8-40	1
P2A1260	6-140	1
P2A1260	8-125	1
VTB01330	6-55	1
VTB01330-4	6-55	1
VTB01340	6-140	1
VTB01340	8-125	1
VTB10370	8-40	1
VTB11990	6-140	1
VTB11990	8-125	1
10-60516-205	10-10	2
10-60516-205	11-10	2
10-60516-206	10-15	1
10-60516-206	9-10	1
10-61854-8	6-140	1
10-61854-8	8-125	1
176193	7-180	1
176388	7-180	1
55904	6-140	1
55904	8-125	1
65-46401-1	7-	RF
65-46401-10	7-80	1
65-46401-15	7-	RF
65-46401-16	7-	RF
65-46401-17	7-80	1
65-46401-18	7-80	1
65-46401-19	7-	RF
65-46401-2	7-	RF
65-46401-20	7-	RF
65-46401-21	7-80	1
65-46401-22	7-80	1
65-46401-23	7-	RF
65-46401-24	7-	RF

Part No.	Fig. and Index No.	Qty. per Assy.
65-46401-25	7-80	1
65-46401-26	7-80	1
65-46401-27	7-	RF
65-46401-28	7-	RF
65-46401-29	7-80	1
65-46401-3	7-80	1
65-46401-30	7-80	1
65-46401-31	7-75	1
65-46401-33	7-	RF
65-46401-34	7-	RF
65-46401-37	7-	RF
65-46401-38	7-	RF
65-46401-39	7-	RF
65-46401-4	7-80	1
65-46401-40	7-	RF
65-46401-41	7-	RF
65-46401-42	7-	RF
65-46401-43	7-	RF
65-46401-44	7-	RF
65-46401-45	7-80	1
65-46401-46	7-80	1
65-46401-49	7-80	1
65-46401-50	7-80	1
65-46401-51	7-80	1
65-46401-52	7-80	1
65-46401-53	7-80	1
65-46401-54	7-80	1
65-46401-55	7-80	1
65-46401-56	7-80	1
65-46401-69	7-	RF
65-46401-7	7-	RF
65-46401-70	7-	RF
65-46401-71	7-	RF
65-46401-72	7-	RF
65-46401-73	7-	RF
65-46401-74	7-	RF
65-46401-75	7-80	1
65-46401-76	7-80	1
65-46401-77	7-80	1
65-46401-78	7-80	1
65-46401-79	7-80	1
65-46401-8	7-	RF
65-46401-80	7-80	1
65-46401-9	7-80	1
65-49442-1	9-1	RF
65-49442-10	9-5	1
65-49442-2	9-1	RF

Part No.	Fig. and Index No.	Qty. per Assy.
65-49442-3	9-5	1
65-49442-4	9-5	1
65-49442-7	9-1	RF
65-49442-8	9-1	RF
65-49442-9	9-5	1
65-52235-1	10-1	RF
65-52235-10	10-1	RF
65-52235-11	10-5	1
65-52235-12	10-5	1
65-52235-13	10-5	1
65-52235-14	10-5	1
65-52235-15	10-1	RF
65-52235-16	10-1	RF
65-52235-17	10-5	1
65-52235-18	10-5	1
65-52235-2	10-1	RF
65-52235-21	10-5	1
65-52235-22	10-5	1
65-52235-23	10-5	1
65-52235-24	10-5	1
65-52235-25	10-5	1
65-52235-26	10-5	1
65-52235-27	10-1	RF
65-52235-28	10-1	RF
65-52235-29	10-1	RF
65-52235-3	10-5	1
65-52235-30	10-1	RF
65-52235-31	10-1	RF
65-52235-32	10-1	RF
65-52235-33	10-5	1
65-52235-34	10-5	1
65-52235-35	10-1	RF
65-52235-36	10-1	RF
65-52235-37	10-5	1
65-52235-38	10-1	RF
65-52235-4	10-5	1
65-52235-7	10-1	RF
65-52235-8	10-1	RF
65-52235-9	10-1	RF
65-67172-1	11-1	RF
65-67172-13	11-1	RF
65-67172-14	11-1	RF
65-67172-15	11-5	1
65-67172-16	11-5	1
65-67172-17	11-1	RF
65-67172-18	11-1	RF
65-67172-19	11-5	1

Part No.	Fig. and Index No.	Qty. per Assy.
65-67172-2	11-1	RF
65-67172-20	11-5	1
65-67172-21	11-5	1
65-67172-22	11-5	1
65-67172-23	11-1	RF
65-67172-24	11-1	RF
65-67172-25	11-1	RF
65-67172-26	11-1	RF
65-67172-27	11-5	1
65-67172-28	11-5	1
65-67172-29	11-1	RF
65-67172-3	11-5	1
65-67172-30	11-1	RF
65-67172-31	11-5	1
65-67172-32	11-5	1
65-67172-33	11-1	RF
65-67172-34	11-1	RF
65-67172-35	11-5	1
65-67172-36	11-5	1
65-67172-4	11-5	1
65-67172-5	11-1	RF
65-67172-6	11-1	RF
65-67172-7	11-5	1
65-67172-8	11-5	1
65-82764-1	6-	RF
65-82764-15	6-	RF
65-82764-16	6-	RF
65-82764-17	6-145	1
65-82764-18	6-145	1
65-82764-19	6-	RF
65-82764-2	6-	RF
65-82764-20	6-	RF
65-82764-21	6-	RF
65-82764-22	6-	RF
65-82764-23	6-145	1
65-82764-24	6-145	1
65-82764-25	6-145	1
65-82764-26	6-145	1
65-82764-27	6-	RF
65-82764-28	6-	RF
65-82764-29	6-145	1
65-82764-3	6-145	1
65-82764-30	6-145	1
65-82764-31	6-	RF
65-82764-32	6-	RF
65-82764-33	6-145	1
65-82764-34	6-145	1

Part No.	Fig. and Index No.	Qty. per Assy.
65-82764-35	6-	RF
65-82764-36	6-	RF
65-82764-37	6-145	1
65-82764-38	6-145	1
65-82764-39	6-	RF
65-82764-4	6-145	1
65-82764-40	6-	RF
65-82764-5	6-175	1
65-84104-1	6-60	1
65-84104-1	8-45	1
65-84105-1	6-135	1
65-84105-1	8-120	1
65-84106-1	6-110	1
65-84106-1	8-95	1
65-84107-1	6-65	1
65-84107-1	8-50	1
65-84107-2	6-70	1
65-84107-2	8-55	1
65-84108-1	6-105	1
65-84108-1	8-90	1
65-84109-1	6-190	1
65-84109-1	8-175	1
65-84110-1	6-80	1
65-84110-1	8-70	1
65-84110-2	6-80	1
65-84110-2	8-70	1
65-84110-3	8-70	1
65-85371-19	7-71	2
65-85371-20	7-72	2
65-85371-21	7-73	1
65-85371-22	7-74	1
65C32102-10	8-130	1
65C32102-11	8-195	1
65C32102-5	8-200	1
65C32102-7	8-1	RF
65C32102-8	8-1	RF
65C32102-9	8-130	1
65C32697-2	12-5	1
65C32697-4	12-5	1
65C32697-5	12-1	RF
65C32697-7	12-1	RF
65C32699-1	13-1	RF
65C32699-2	13-1	RF
65C32699-3	13-5	1
65C32699-4	13-5	1
65C32918-1	14-1	RF
65C32918-10	14-5	1

Part No.	Fig. and Index No.	Qty. per Assy.
65C32918-17	14-1	RF
65C32918-18	14-1	RF
65C32918-19	14-1	RF
65C32918-2	14-1	RF
65C32918-20	14-1	RF
65C32918-21	14-5	1
65C32918-22	14-5	1
65C32918-3	14-5	1
65C32918-4	14-5	1
65C32918-7	14-1	RF
65C32918-8	14-1	RF
65C32918-9	14-5	1
65C33087-1	8-10	1
65C33087-2	8-10	1
65C33087-3	8-10L	1
65C33087-4	8-10L	1
66-23234-1	7-100	2
66-23234-2	7-55	8
66-23234-3	7-60	6
66-25656-1	6-180	3
66-25656-1	8-165	1
69-37867-1	7-70	2
69-37867-2	6-185	2
69-37867-2	7-65	2
69-37867-60	6-185	2
69-37867-66	7-66	2
69-44957-1	7-145	1
69-44957-2	7-145	1
69-44957-3	7-150	1
69-44957-4	7-150	1
69-44958-1	7-170	1
69-44959-1	7-130	1
69-44959-2	7-130	1
69-44959-3	7-135	1
69-44959-4	7-135	1
69-44960-1	7-175	1
69-60733-1	7-180	1
69-63565-1	6-45	1
69-63566-1	6-10	1
69-63568-1	6-195	1
69-63569-1	6-50	1
69-63570-1	6-90	1
69-63570-1	8-75	1
69-63571-1	6-95	2
69-63571-1	8-80	2
69-63909-1	6-40	1
69-65315-1	6-10	1

Part No.	Fig. and Index No.	Qty. per Assy.
69-65315-2	6-10	1
69-76618-1	8-100	AR
69-77043-1	8-180	1
69-77049-1	14-10	2
69-77058-13	13-10	2
69-77058-4	12-10	2
69-77058-5	12-15	2
69-77114-1	8-170	2
69-77128-1	8-35	1
69-77143-1	8-30	1
76415	7-180	1
802-512	6-75	1
802-512	8-65	1

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