TO: ALL HOLDERS OF INBOARD FLAP TRACK ASSEMBLY OVERHAUL MANUAL, 57-53-16

REVISION NO. 31, DATED JUL 1/08

HIGHLIGHTS

DESCRIPTION OF CHANGE	TOPICS AFFECTED												
	D & O	D / Assy	Cleaning	Insp/Chk	Repair	Assy	F/C	Test	T/Shooting	S/Tools	Storage	IPL	L/Overhaul
Changed the bushing ID dimension					X								

INBOARD FLAP TRACK ASSEMBLY

57-53-16

BOEING P/N 65-46438-1, -2, -4 thru -15
65-46439-1 thru -8, -10, -11, -12, -14 thru -28
65C35276-1, -2
65C35617-3, -4
65C36867-1 thru -4

AIRLINE P/N

THE FOLLOWING DIRECTIVES APPLY TO THIS SUBJECT:

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVES	DATE DIRECTIVE INCORPORATED INTO TEXT
		PRR 33084	Jul 5/81
		PRR 33180-50	Sep 5/84
		PRR 33310-2	Sep 5/84
	57-18		Mar 5/90
737-57-1203		PRR 34707-R	Sep 5/91
737-57-1203		PRR 34707-R	Jun 5/93
737-57-1203R4			Nov 1/00
737-57-1239		PRR 35347-R	Mar 1/05

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
	57-53-16			27	Mar 5/90			
	T-1	Mar 1/05		28	Mar 5/90			
	T-2	BLANK		29	BLANK			
*	LEP-1	Jul 1/08		30	Jun 1/96			
	LEP-2	BLANK		30A	Jun 1/96			
	T/C-1	Mar 5/90		30B	Mar 1/05			
	T/C-2	BLANK		31	Mar 1/05			
	1	Jul 1/03		32	Nov 1/00			
*	2	Jul 1/08		33	Nov 1/00			
	2A	Jul 1/03		34	Nov 1/00			
	2B	Jul 1/03		35	Nov 1/00			
	2C	Sep 1/95		36	Jul 1/98			
	2D	BLANK		36A	Nov 1/00			
	3	Sep 1/95		36B	Nov 1/00			
	4	Jun 1/97		37	Nov 1/00			
	5	Jun 1/97		38	Nov 1/00			
	6	Mar 1/01		39	Nov 1/00			
	7	BLANK		40	Mar 1/05			
	8	Jun 1/97		41	Mar 1/05			
	9	Jun 1/97		42	Mar 1/05			
	10	Mar 1/01						
	11	BLANK						
	12	Jun 1/97						
	13	Dec 1/97						
	14	Jun 1/97						
	15	BLANK						
	16	Jul 1/98						
	16A	Jul 1/98						
	16B	Jul 1/98						
	17	Jul 1/98						
	18	Jun 1/97						
	19	Jun 1/97						
	20	Jun 1/97						
	21	Jun 1/97						
	22	Jun 1/97						
	23	Dec 1/97						
	24	Jul 1/02						
	24A	Dec 1/95						
	24B	Dec 1/95						
	24C	Dec 1/95						
*	24D	Jul 1/08						
	25	Jul 1/03						
	26	Jul 1/03						

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

INBOARD FLAP TRACK ASSEMBLY

1. DESCRIPTION AND OPERATION

A. The flap track assembly has inboard and outboard tracks, spacer block, terminal bushings and attaching parts. The track is a forged steel beam, with a slot along the full length. The aluminum spacer block is machined to fit the slot, which makes the track and spacer a matched set. The parts are bolted together through the track web. Inboard and outboard flap track assemblies are almost the same except for overall length.

B. Leading Particulars (Approximate)

Length	--	Outboard	-- 61 inches
		Inboard	-- 43 inches
Width	--	4 inches	
Height	--	7 inches	
Weight	--	Outboard	-- 55 pounds
		Inboard	-- 35 pounds

2. DISASSEMBLY

A. Use standard industry practices and these special steps.

CAUTION: BECAUSE SPACER (10, FIG. 9, 10, 11, 12, 13) IS MACHINED TO AGREE WITH THE SLOT IN TRACK (5, FIG. 9, 10, 11, 12, 13), THESE PARTS MUST BE KEPT TOGETHER AS A MATCHED SET.

B. Tag or identify track (5, Fig. 9, 10, 11, 12, 13) and spacer (10, Fig. 9, 10, 11, 12, 13) as a matched set.

C. If tracks 65-46439-17, -18 come in for overhaul with filler 69-50772-11, be sure to keep the filler with these tracks as a set.

3. INSPECTION/CHECK

A. Examine all parts for defects with standard industry practices. Do the checks shown below if you think there are defects on the parts.

B. Do the magnetic particle check per SOPM 20-20-01 on track (5, Fig. 9, 10, 11, 12, 13).

C. Do the penetrant check per SOPM 20-20-02 on spacer block or spacer assembly (10, Fig. 9, 10, 11, 12, 13).

4. REPAIR

A. Repair small defects by standard industry practices.

B. Track Wear Surfaces (Fig. 2 thru 7)

(1) Machine the surface, within repair limits, to remove defects and minimize variations in flange thickness.

(2) Shot peen the repaired surface per SOPM 20-10-03, intensity 0.012A2.

(3) Surface finish must as smooth as, or smoother than, the adjacent base metal.

(4) Refinish as indicated.

C. Holes for bushings (20, 21, 25, 35, 40, 45, Fig. 9) on tracks 65-46438-series (Fig. 7A).

(1) Machine as required, within repair limits to remove defects.

(2) Shot peen. Stylus cadmium plate.

(3) Make oversize bushings (Fig. 7B) as required to adjust for the defects removed in step (1).

(4) Install the bushings per par. 4.C.

D. Flap track aft engine mount bore hole on tracks 65-46409-1, -2, -5, -6, -9, -10, -17 thru -20, -23, -24 (Fig. 5).

(1) Machine the flap track aft engine mount bore holes, as necessary, to remove defects.

(2) Etch examine per SOPM 20-10-02.

(3) Magnetic particle examine per SOPM 20-20-01.

(4) If material must be removed from the fail safe bar, get instructions from Boeing.

(5) If you must remove material to make the hole larger than design dimensions, make a repair sleeve (Fig. 5A) to adjust for the material removed in step (1).

(6) Install the sleeve by the shrink fit method per SOPM 20-50-03.

E. Flap track mount holes (Fig. 7A, View C-C).

(1) Machine the mount hole as necessary to remove defects.

(2) Etch examine per SOPM 20-10-02.

(3) Magnetic particle examine per SOPM 20-20-01.

(4) If you must remove material to make the hole larger than design dimensions, make oversize or repair bushings (Fig. 7B) to adjust for the material removed in step (1).

(5) Install the bushings per par. 4.G.

F. Refinish

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

(1) Spacer block or spacer assembly (10, Fig. 9, 10, 11, 12) -- Chromic acid anodize (F-17.04). Apply BMS 10-11, Type 1 primer (F-20.03) all over, but not in threaded holes. Material: Al alloy.

(2) Track (5, Fig. 9, 10, 11, 12), 65-46409, 65-67136, 65-46407-1, -6, -9, -15, 65C35165, 65C35617 -- Cadmium-titanium plate (F-15.01). Apply BMS 10-11, Type 1 primer (F-20.03) all over but not in threaded holes. Material 4330M steel, 220-240 ksi.

(3) Track (5, Fig. 9), 65-46407-3, -8, -10, -11, -12, -13, -15, -16 -- Cadmium-titanium plate (F-15.01). Apply BMS 10-11, Type 1 primer (F-20.03) all over, but not in threaded holes. Material: 4340M steel, 270-300 ksi.

(4) Track assembly (65-46438-series, 65-46439-1 thru -8, -10 thru -18, -21, -22) -- Clean and apply BMS 10-11, Type 1 primer to the fastener heads and scratched and bare surfaces (SRF-14.9961). Apply BMS 10-60 gray gloss primer (SRF-14.9813) all over but not in open holes or on bushings.

(5) Track assemblies (65-46439 -19, -20, -23 thru -26) -- Clean and apply BMS 10-11, Type 1 yellow primer to bared surfaces (F-14.996). Apply BMS 10-60 gray gloss enamel (SRF-14.9813) all over except in open holes.

(6) Track assembly (65-46439-27,-28) -- Clean and apply BMS 10-11, Type 1 yellow primer to the fastener heads and scratched and bare surfaces (F-14.9961). Apply BMS 10-60 gray gloss enamel (SRF-14.9813) all over but not in open holes. Apply corrosion inhibiting compound BMS 3-23, Type 2 (F-19.26) on all interior surfaces.

(7) Track assembly (65C35617-series) -- Apply BMS 10-60 Boeing color 707 gray gloss enamel (SRF-14.9813) all over but not in open holes. Apply BMS 3-23, Type 2 corrosion inhibiting compound (F-19.26) on all interior surfaces.

(8) Track assembly (65C35276-series) -- Clean and apply BMS 10-11, Type 1 primer to scratched or bare surfaces (SRF-14.996). Apply BMS 10-60 gray gloss enamel (SRF-14.9813) all over but not on bushings.

(9) Track assemblies (65C36867-1 thru -4) -- Apply one coat of BMS 10-11, Type 1 primer (F-14.996) plus BMS 10-60, Type 1 gray gloss enamel (F-14.9813), except in bushing bores and bushing flanges. Coat all interior surfaces with BMS 3-23, Type 2 corrosion inhibiting compound (F-19.26).

G. Replacement

(1) Bushings (20, 21, 25, 35, 40, 45, Fig. 9)

(a) Track assemblies 65-46438-1, -2, -4 thru -14: Install replacement bushings with a press fit per SOPM 20-50-03.

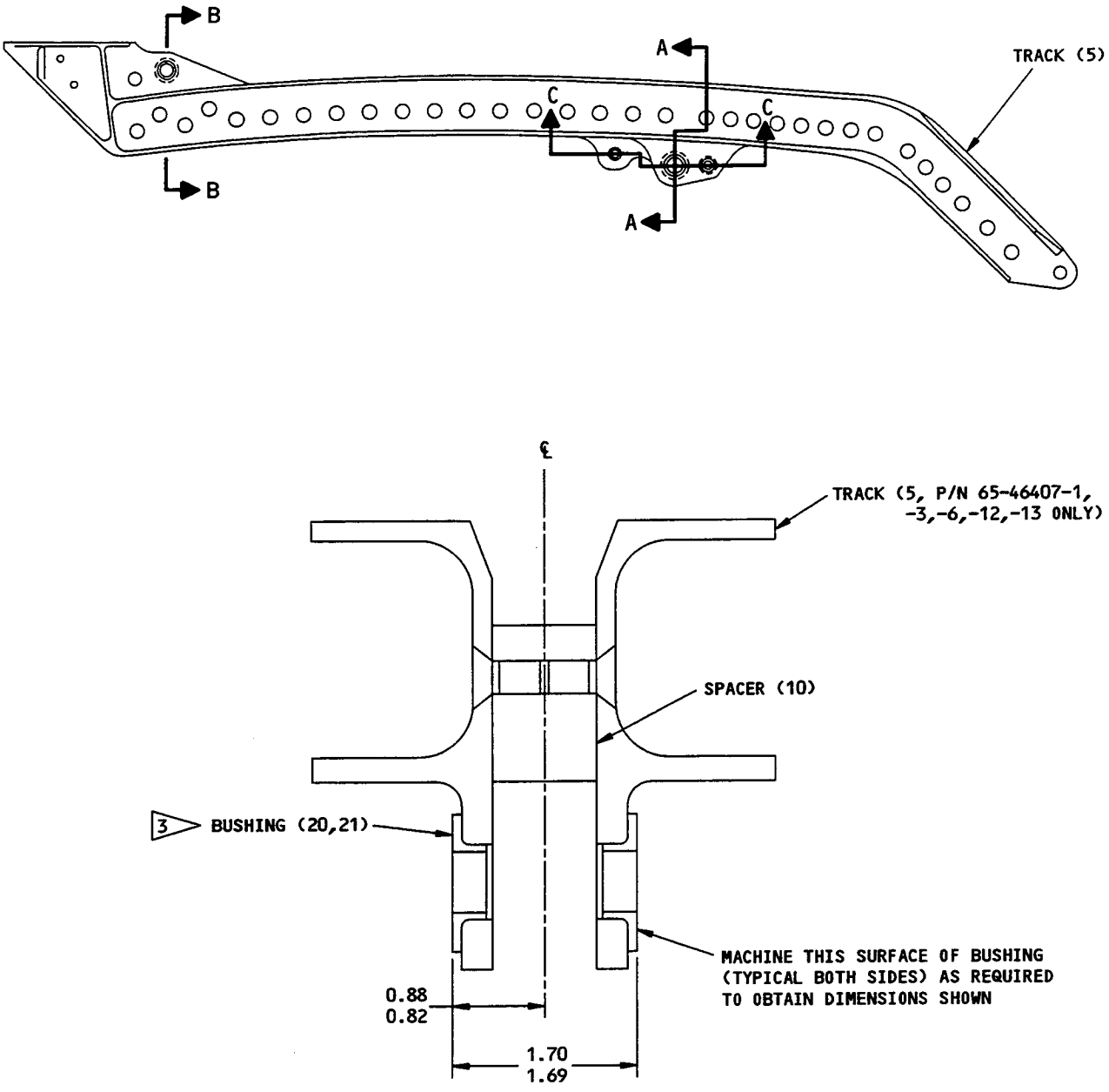
(b) Track assemblies 65-46438-15: Install the bushings by the shrink fit or press fit method per SOPM 20-50-03.

(c) As necessary, machine the flange and the inside diameter of the bushings to design dimensions (Fig. 1).

(2) Bushings (20, Fig. 11, 12, 13)

(a) For bushing (20, Fig. 11), install replacement bushings by the shrink fit or press fit method per SOPM 20-50-03.

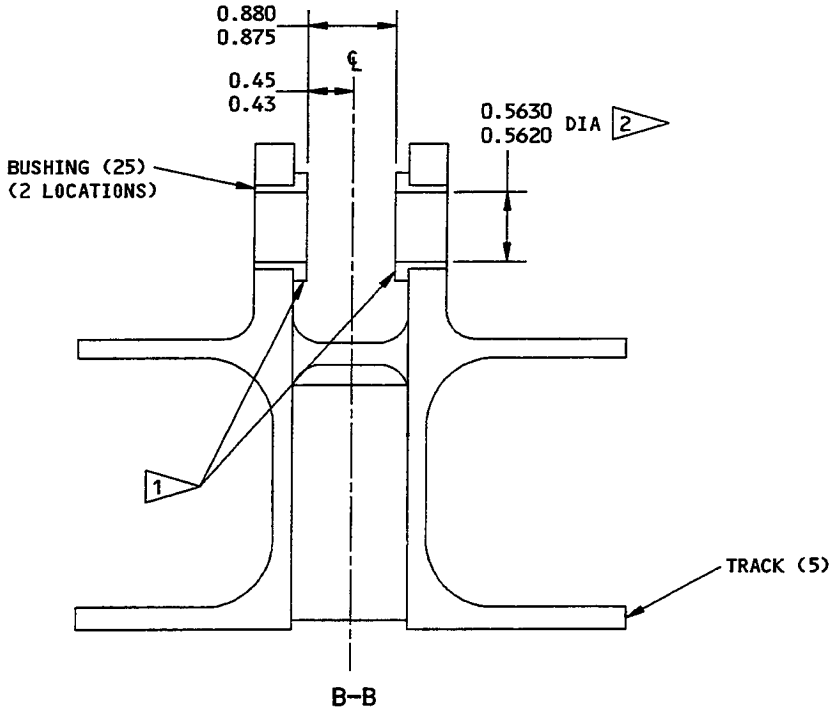
(b) For bushing (20, Fig. 12, 13), install replacement bushings with BMS 5-95 per SOPM 20-50-03.

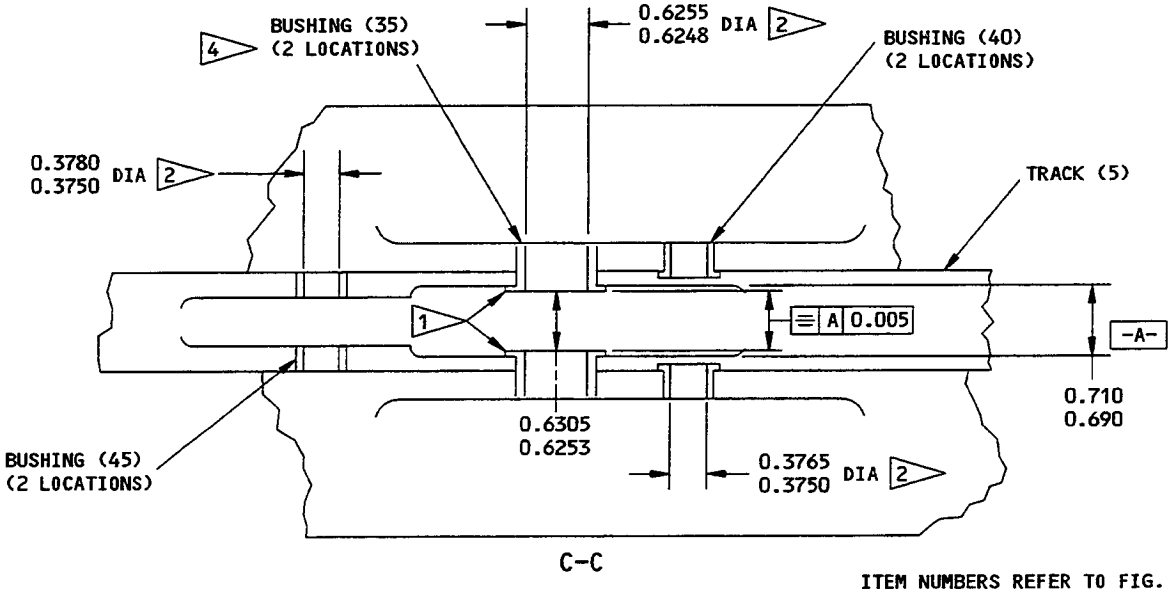


A-A

Bushing Replacement
Figure 1 (Sheet 1)

B58093





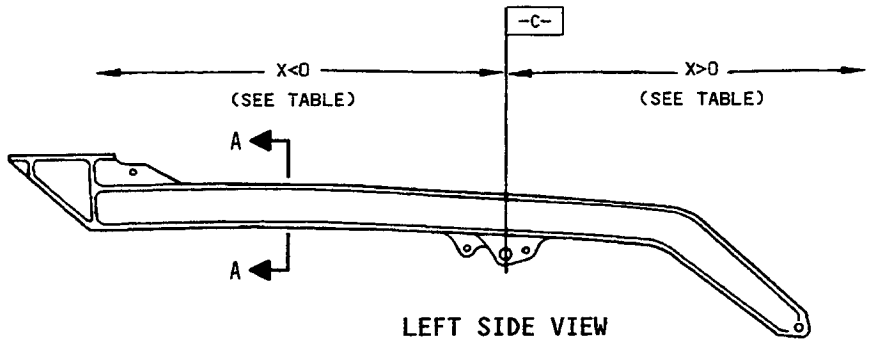
ITEM NUMBERS REFER TO FIG. 9

ALL DIMENSIONS ARE IN INCHES

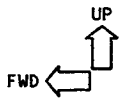
1. MACHINE THE FLANGE
2. MACHINE INSIDE DIAMETER AFTER INSTALLATION IF REQUIRED
3. 65-46438-1,-2,-4,-10,-11 ONLY
4. 65-46438-5,-6,-7,-8,-9,-12,-13,-14,-15 ONLY

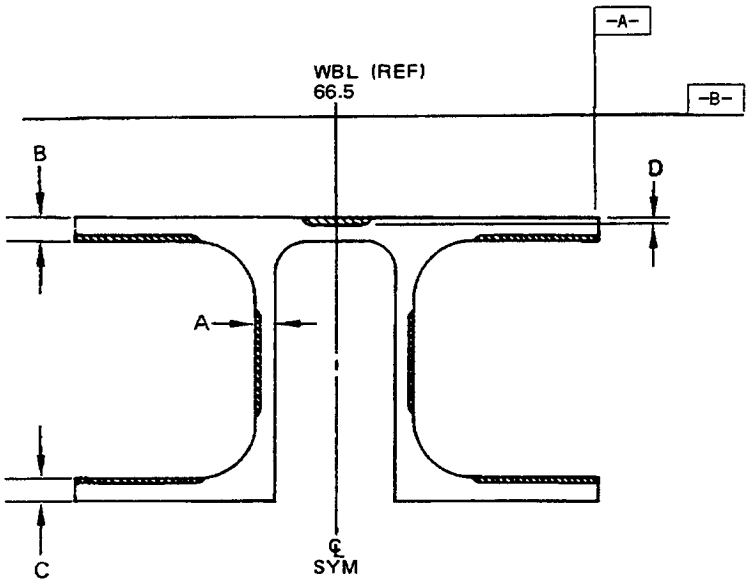
Bushing Replacement
Figure 1 (Sheet 2)

B58141



LEFT SIDE VIEW





A-A

CARRIAGE CONTACT
WEAR SURFACE

65-46407-8,-11,-15,-16

Inboard Flap Track Repair
Figure 2 (Sheet 1)

G49341

DIM	DESIGN DIMENSIONS BEFORE PLATING			MIN REPAIR THICKNESS			WEAR TOL
X	A	B	C	A	B	C	D
-22.00	--	0.140 0.120	--	--	0.100	--	--
-21.00	--	0.140 0.120	0.141 0.121	--	0.100	0.101	--
-20.00	--	0.140 0.120	0.142 0.122	--	0.100	0.102	--
-19.00	--	0.140 0.120	0.143 0.123	--	0.100	0.103	0.010
-18.00	--	0.145 0.125	0.144 0.124	--	0.105	0.104	0.010
-17.50	0.182 0.160	--	--	0.155	--	--	--
-17.00	0.182 0.160	0.150 0.130	0.145 0.125	0.155	0.110	0.105	0.010
-16.00	0.182 0.160	0.155 0.135	0.146 0.126	0.155	0.115	0.106	0.010
-15.00	0.182 0.160	0.156 0.136	0.147 0.127	0.155	0.116	0.107	0.010
-14.00	0.182 0.160	0.158 0.138	0.148 0.128	0.155	0.118	0.108	0.010
-13.00	0.182 0.160	0.159 0.139	0.149 0.129	0.155	0.119	0.109	0.010
-12.00	0.182 0.160	0.161 0.141	0.151 0.131	0.155	0.121	0.111	0.010
-11.00	0.182 0.160	0.162 0.142	0.152 0.132	0.155	0.122	0.112	0.010
-10.00	0.182 0.160	0.164 0.144	0.153 0.133	0.155	0.124	0.113	0.010
-9.00	0.182 0.160	0.165 0.145	0.154 0.134	0.155	0.125	0.114	0.010
-8.00	0.182 0.160	0.166 0.146	0.155 0.135	0.155	0.126	0.115	0.010
-7.00	0.182 0.160	0.168 0.148	0.156 0.136	0.155	0.128	0.116	0.010
-6.00	0.182 0.160	0.169 0.149	0.157 0.137	0.155	0.129	0.117	0.010
-5.00	0.182 0.160	0.171 0.151	0.158 0.138	0.155	0.131	0.118	0.010
-4.00	0.182 0.160	0.172 0.152	0.159 0.139	0.155	0.132	0.119	0.010
-3.00	0.182 0.160	0.174 0.154	0.160 0.140	0.155	0.134	0.120	0.010
-2.00	0.182 0.160	0.175 0.155	0.165 0.145	0.155	0.135	0.125	0.010
-1.00	0.182 0.160	0.175 0.155	0.165 0.145	0.155	0.135	0.125	0.010

65-46407-8, -11, 15, -16

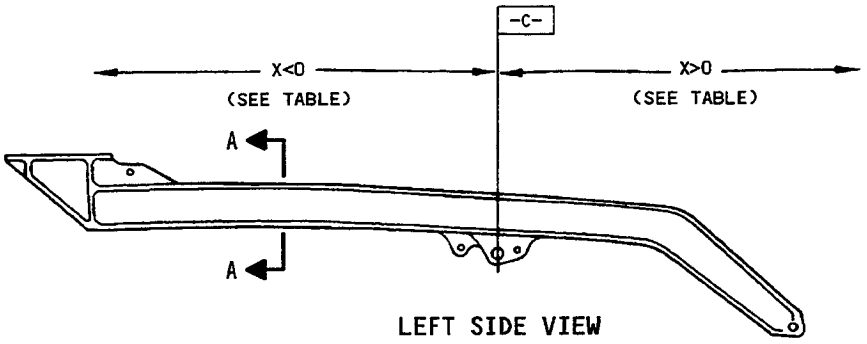
Inboard Flap Track Repair
Figure 2 (Sheet 2)

DIM	DESIGN DIMENSIONS BEFORE PLATING			MIN REPAIR THICKNESS			WEAR TOL
X	A	B	C	A	B	C	D
0.00	0.182 0.160	0.175 0.155	0.170 0.150	0.155	0.135	0.130	0.010
+ 1.00	0.182 0.160	0.180 0.160	0.175 0.155	0.155	0.140	0.135	0.010
2.00	0.182 0.160	0.180 0.160	0.175 0.155	0.155	0.140	0.135	0.010
3.00	0.182 0.160	0.180 0.160	0.190 0.170	0.155	0.140	0.150	--
4.00	0.182 0.160	0.190 0.170	0.200 0.180	0.155	0.150	0.160	--
5.00	0.182 0.160	0.200 0.180	0.220 0.200	0.155	0.160	0.180	--
6.00	0.182 0.160	0.220 0.200	0.230 0.210	0.155	0.180	0.190	--
7.00	0.182 0.160	0.230 0.210	--	0.155	0.190	--	--
11.00	0.182 0.160	0.320 0.300	0.120 0.100	0.155	0.280	0.080	--
12.00	0.182 0.160	0.320 0.300	0.120 0.100	0.155	0.280	0.080	--
13.00	--	0.320 0.300	0.120 0.100	--	0.280	0.080	--
14.00	--	0.320 0.300	--	--	0.280	--	--
15.00	--	0.320 0.300	--	--	0.280	--	--
15.59	--	0.320 0.300	--	--	0.280	--	--

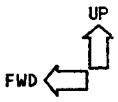
ALL DIMENSIONS ARE IN INCHES

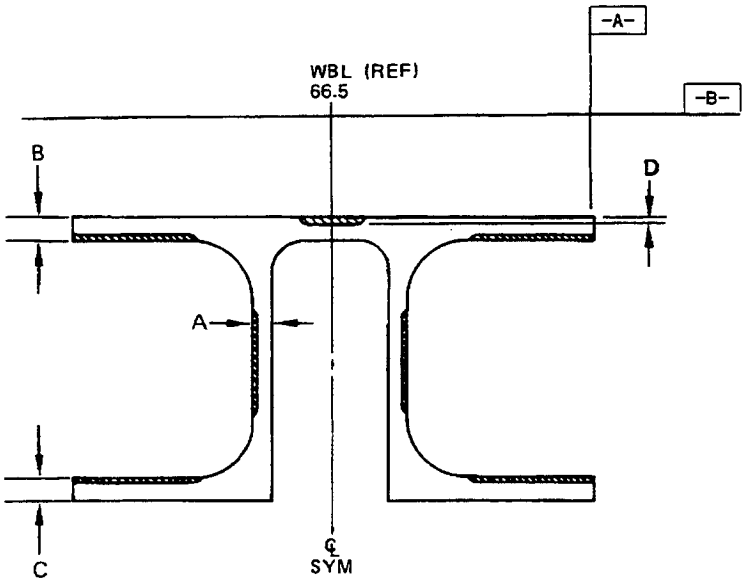
65-46407-8, -11, -15, -16

Inboard Flap Track Repair
Figure 2 (Sheet 3)



LEFT SIDE VIEW





A-A

CARRIAGE CONTACT
WEAR SURFACE

65-46407-3,-6,-9,-10,-12,-13

Inboard Flap Track Repair
Figure 3 (Sheet 1)

G49347

DIM	DESIGN DIMENSIONS BEFORE PLATING			MIN REPAIR THICKNESS			WEAR TOL
X	A	B	C	A	B	C	D
-22.00	--	0.150 0.130	--	--	0.110	--	--
-21.00	--	0.150 0.130	0.152 0.132	--	0.110	0.112	--
-20.00	--	0.150 0.130	0.153 0.133	--	0.110	0.113	--
-19.00	--	0.150 0.130	0.155 0.135	--	0.110	0.135	0.010
-18.00	--	0.155 0.136	0.156 0.136	--	0.115	0.116	0.010
-17.50	0.182 0.160	--	--	0.155	--	--	--
-17.00	0.182	0.160 0.140	0.158 0.138	0.155	0.120	0.118	0.010
-16.00	0.182	0.165 0.145	0.159 0.139	0.155	0.125	0.119	0.010
-15.00	0.182	0.166 0.146	0.161 0.141	0.155	0.126	0.121	0.010
-14.00	0.182	0.168 0.148	0.163 0.143	0.155	0.128	0.123	0.010
-13.00	0.182	0.169 0.149	0.164 0.144	0.155	0.129	0.124	0.010
-12.00	0.182	0.171 0.151	0.166 0.146	0.155	0.131	0.126	0.010
-11.00	0.182	0.172 0.152	0.167 0.147	0.155	0.132	0.127	0.010
-10.00	0.182 0.160	0.174 0.154	0.169 0.149	0.155	0.134	0.129	0.010
-9.00	0.182 0.160	0.175 0.155	0.171 0.151	0.155	0.135	0.131	0.010
-8.00	0.182 0.160	0.176 0.156	0.172 0.152	0.155	0.136	0.132	0.010
-7.00	0.182 0.160	0.178 0.158	0.174 0.154	0.155	0.138	0.134	0.010
-6.00	0.182 0.160	0.179 0.159	0.175 0.155	0.155	0.139	0.135	0.010
-5.00	0.182 0.160	0.181 0.161	0.177 0.157	0.155	0.141	0.137	0.010
-4.00	0.182 0.160	0.182 0.162	0.178 0.158	0.155	0.142	0.138	0.010
-3.00	0.182 0.160	0.184 0.164	0.180 0.160	0.155	0.144	0.140	0.010
-2.00	0.182 0.160	0.185 0.165	0.185 0.165	0.155	0.145	0.145	0.010
-1.00	0.182 0.160	0.185 0.165	0.185 0.165	0.155	0.145	0.145	0.010

65-46407-3, -6, -9, -10, 12, -13

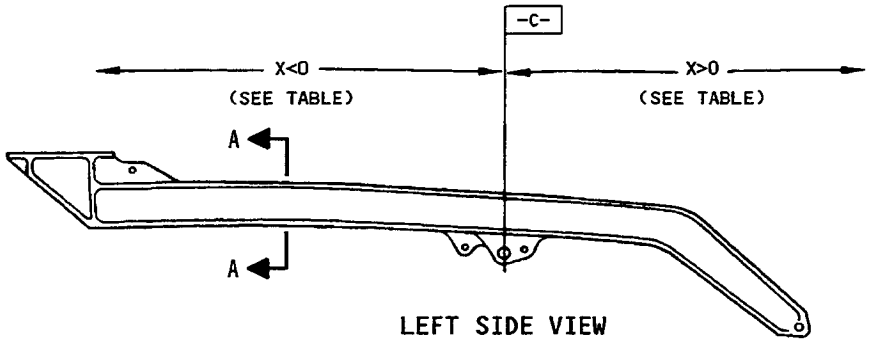
Inboard Flap Track Repair
Figure 3 (Sheet 2)

DIM	DESIGN DIMENSIONS BEFORE PLATING			MIN REPAIR THICKNESS			WEAR TOL
X	A	B	C	A	B	C	D
0.00	0.182 0.160	0.185 0.165	0.190 0.170	0.155	0.145	0.150	0.010
+ 1.00	0.182 0.160	0.190 0.170	0.190 0.170	0.155	0.150	0.150	0.010
2.00	0.182 0.160	0.190 0.170	0.200 0.180	0.155	0.150	0.160	0.010
3.00	0.182 0.160	0.200 0.180	0.210 0.190	0.155	0.160	0.170	--
4.00	0.182 0.160	0.210 0.190	0.220 0.200	0.155	0.170	0.180	--
5.00	0.182 0.160	0.225 0.205	0.240 0.220	0.155	0.185	0.200	--
6.00	0.182 0.160	0.240 0.220	0.240 0.220	0.155	0.200	0.200	--
7.00	0.182 0.160	0.250 0.230	--	0.155	0.210	--	--
11.00	0.182 0.160	0.250 0.230	0.113 0.110	0.155	0.310	0.090	--
12.00	0.182 0.160	0.350 0.330	0.113 0.110	0.155	0.310	0.090	--
13.00	--	0.350 0.330	0.113 0.110	--	0.310	0.090	--
14.00	--	0.350 0.330	--	--	0.310	--	--
15.00	--	0.350 0.330	--	--	0.310	--	--
15.59	--	0.350 0.330	--	--	0.310	--	--

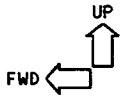
ALL DIMENSIONS ARE IN INCHES

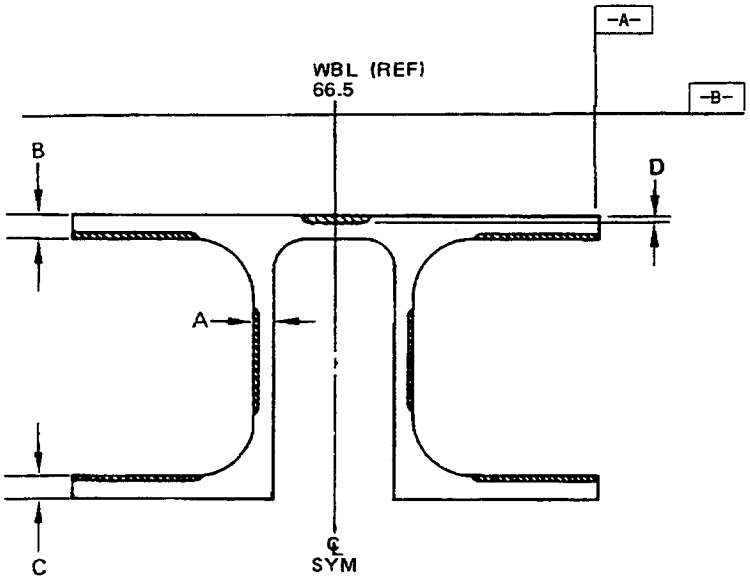
65-46407-3, -6, -9, -10, -12, -13

Inboard Flap Track Repair
Figure 3 (Sheet 3)



LEFT SIDE VIEW





A-A

CARRIAGE CONTACT
WEAR SURFACE

65-46407-1

Inboard Flap Track Repair
Figure 4 (Sheet 1)

G49351

DIM	DESIGN DIMENSIONS BEFORE PLATING			MIN REPAIR THICKNESS			WEAR TOL
X	A	B	C	A	B	C	D
-22.00	--	0.150 0.130	--	--	0.110	--	--
-21.00	--	0.160 0.140	0.190 0.170	--	0.120	0.150	--
-20.00	--	0.170 0.150	0.190 0.170	--	0.130	0.150	--
-19.00	--	0.175 0.155	0.190 0.170	--	0.135	0.150	0.010
-18.00	--	0.180 0.160	0.190 0.170	--	0.140	0.150	0.010
-17.50	0.182 0.160	--	--	0.155	--	--	--
-17.00	0.182	0.185 0.165	0.190 0.170	0.155	0.145	0.150	0.010
-16.00	0.182	0.190 0.170	0.190 0.170	0.155	0.150	0.150	0.010
-15.00	0.182	0.190 0.170	0.190 0.170	0.155	0.150	0.150	0.010
-14.00	0.182	0.190 0.170	0.190 0.170	0.155	0.150	0.150	0.010
-13.00	0.182	0.190 0.170	0.190 0.170	0.155	0.150	0.150	0.010
-12.00	0.182	0.190 0.170	0.190 0.170	0.155	0.150	0.150	0.010
-11.00	0.182	0.190 0.170	0.190 0.170	0.155	0.150	0.150	0.010
-10.00	0.182 0.160	0.190 0.170	0.190 0.170	0.155	0.150	0.150	0.010
-9.00	0.182 0.160	0.190 0.170	0.190 0.170	0.155	0.150	0.150	0.010
-8.00	0.182 0.160	0.190 0.170	0.190 0.170	0.155	0.150	0.150	0.010
-7.00	0.182 0.160	0.190 0.170	0.190 0.170	0.155	0.150	0.150	0.010
-6.00	0.182 0.160	0.190 0.170	0.190 0.170	0.155	0.150	0.150	0.010
-5.00	0.182 0.160	0.190 0.170	0.190 0.170	0.155	0.150	0.150	0.010
-4.00	0.182 0.160	0.190 0.170	0.190 0.170	0.155	0.150	0.150	0.010
-3.00	0.182 0.160	0.190 0.170	0.190 0.170	0.155	0.150	0.150	0.010
-2.00	0.182 0.160	0.190 0.170	0.190 0.170	0.155	0.150	0.150	0.010
-1.00	0.182 0.160	0.190 0.170	0.190 0.170	0.155	0.150	0.150	0.010

65-46407-1

Inboard Flap Track Repair
Figure 4 (Sheet 2)

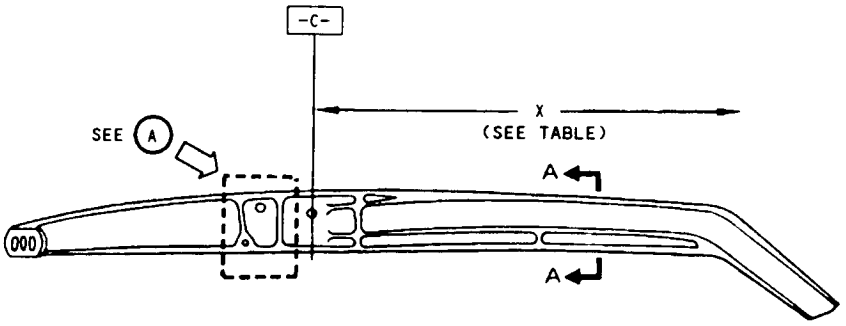
DIM	DESIGN DIMENSIONS BEFORE PLATING			MIN REPAIR THICKNESS			WEAR TOL
X	A	B	C	A	B	C	D
0.00	0.182 0.160	0.190 0.170	0.190 0.170	0.155	0.150	0.150	0.010
+ 1.00	0.182 0.160	0.190 0.170	0.190 0.170	0.155	0.150	0.150	0.010
2.00	0.182 0.160	0.190 0.170	0.190 0.170	0.155	0.150	0.150	0.010
3.00	0.182 0.160	0.200 0.180	0.190 0.170	0.155	0.160	0.150	--
4.00	0.182 0.160	0.210 0.190	0.195 0.175	0.155	0.170	0.155	--
5.00	0.182 0.160	0.225 0.205	0.210 0.190	0.155	0.185	0.170	--
6.00	0.182 0.160	0.240 0.220	0.240 0.220	0.155	0.200	0.200	--
7.00	0.182 0.160	0.250 0.230	--	0.155	0.210	--	--
11.00	0.182 0.160	0.360 0.340	0.160 0.140	0.155	0.320	0.120	--
12.00	0.182 0.160	0.360 0.340	0.160 0.140	0.155	0.320	0.120	--
13.00	--	0.360 0.340	0.160 0.140	--	0.320	0.120	--
14.00	--	0.360 0.340	--	--	0.320	--	--
15.00	--	0.360 0.340	--	--	0.320	--	--
15.59	--	0.360 0.340	--	--	0.320	--	--

ALL DIMENSIONS ARE IN INCHES

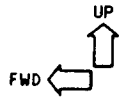
65-46407-1

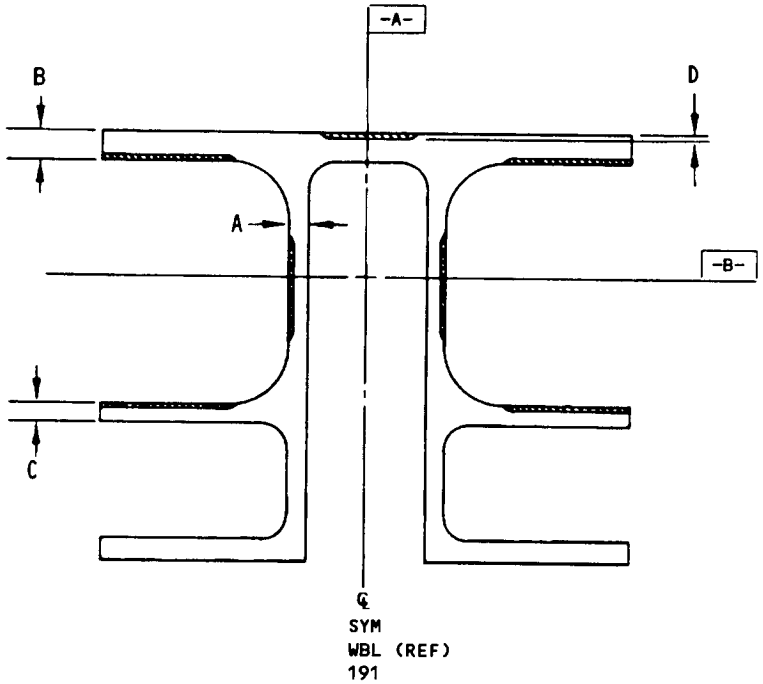
Inboard Flap Track Repair
Figure 4 (Sheet 3)

I



LEFT SIDE VIEW





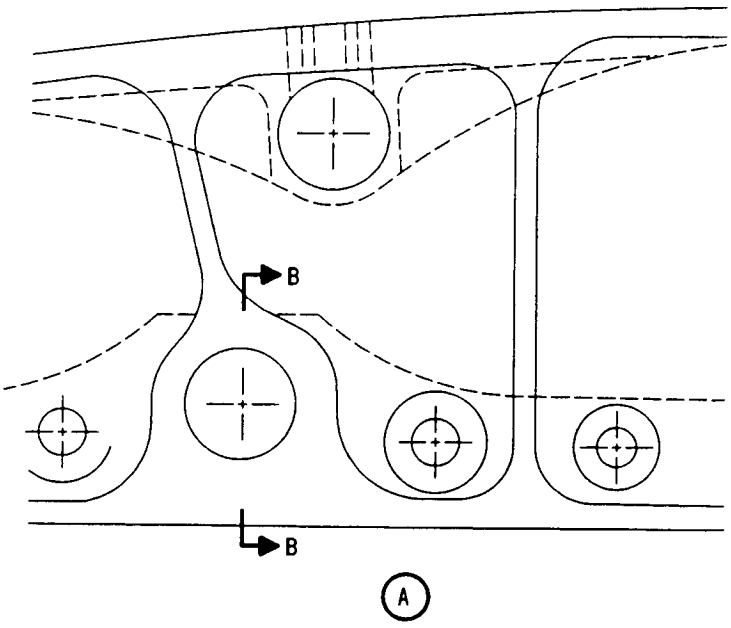
A-A

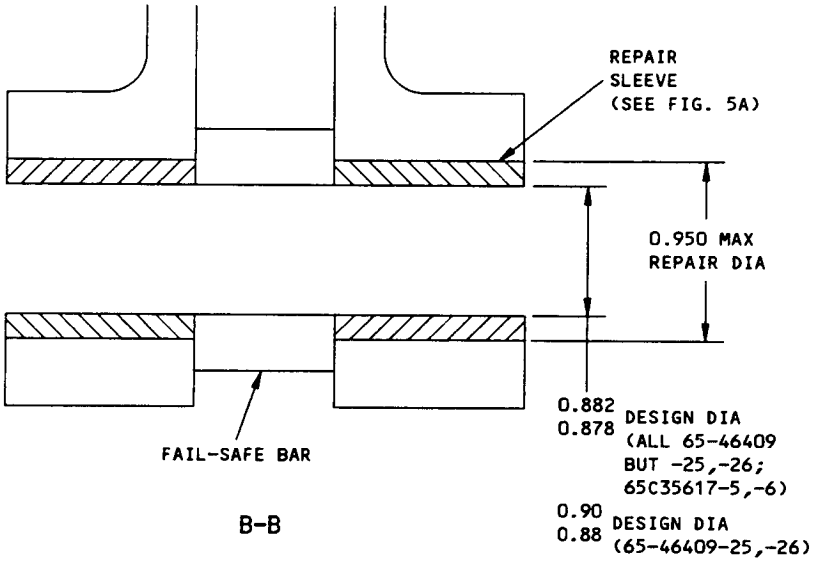
CARRIAGE CONTACT
WEAR SURFACE

65-46409-1,-2,-5,-6,-9,-10,-12,-15 THRU -20,-23 THRU -26, 65C35617-5,-6

Outboard Flap Track Repair
Figure 5 (Sheet 1)

F17651





65-46409-1,-2,-5,-6,-9,-10,-12,-15 THRU -20,-23 THRU -26, 65C35617-5,-6

Outboard Flap Track Repair
Figure 5 (Sheet 2)

DIM	DESIGN DIMENSIONS BEFORE PLATING			MIN REPAIR THICKNESS			WEAR TOL
X	A	B	C	A	B	C	D
5.12	--	0.795 0.752	0.190 0.170	--	0.732	0.150	--
7.12	--	0.504 0.462	0.190 0.170	--	0.442	0.150	--
8.00	0.182 0.160	0.397 0.354	--	0.155	0.335	--	0.010
11.12	0.182 0.160	0.210 0.190	0.190 0.170	0.155	0.170	0.150	0.010
14.12	0.182 0.160	0.210 0.190	0.190 0.170	0.155	0.170	0.150	0.010
17.12	0.182 0.160	0.210 0.190	0.190 0.170	0.155	0.170	0.150	0.010
20.12	0.182 0.160	0.210 0.190	0.190 0.170	0.155	0.170	0.150	0.010
23.12	0.182 0.160	0.210 0.190	0.190 0.170	0.155	0.170	0.150	0.010
26.12	0.182 0.160	0.210 0.190	0.190 0.170	0.155	0.170	0.150	0.010
27.12	0.182 0.160	0.210 0.190	0.190 0.170	0.155	0.170	0.150	0.010
28.12	0.182 0.160	0.210 0.190	0.190 0.170	0.155	0.170	0.150	--
29.12	0.182 0.160	0.210 0.190	0.201 0.181	0.155	0.170	0.161	--
30.12	0.182 0.160	0.210 0.190	0.213 0.193	0.155	0.170	0.173	--
31.12	0.182 0.160	0.210 0.190	0.234 0.214	0.155	0.170	0.194	--
32.12	0.182 0.160	0.207 0.187	0.242 0.222	0.155	0.167	0.202	--
32.52	0.182 0.160	0.205 0.185	0.257 0.237	0.155	0.165	0.217	--
33.12	0.182 0.160	0.204 0.184	0.309 0.289	0.155	0.164	0.269	--
37.00 *[1]	0.182 0.160	0.360 0.340	0.160 0.140	0.155	0.320	0.120	--
37.00 *[2]	0.182 0.160	0.340 0.320	0.130 0.110	0.155	0.300	0.090	--
37.75 *[1]	0.182 0.160	0.360 0.340	0.160 0.140	0.155	0.320	0.120	--
37.75 *[2]	0.182 0.160	0.340 0.320	0.130 0.110	0.155	0.300	0.090	--

65-46409-1, -2, -5, -6, -9, -10, -12, -15 thru -20, -23 thru -26,
65C35617-5, -6

Outboard Flap Track Repair
Figure 5 (Sheet 3)

DIM	DESIGN DIMENSIONS BEFORE PLATING			MIN REPAIR THICKNESS			WEAR TOL
X	A	B	C	A	B	C	D
38.50 *[1]	0.182 0.160	0.360 0.340	0.160 0.140	0.155	0.320	0.120	--
38.50 *[2]	0.182 0.160	0.340 0.320	0.130 0.110	0.155	0.300	0.090	--
39.75 *[1]	0.182 0.160	0.360 0.340	0.160 0.140	0.155	0.320	0.120	--
39.75 *[2]	0.182 0.160	0.340 0.320	0.130 0.110	0.155	0.300	0.090	--
40.00 *[1]	--	0.360 0.340	--	--	0.320	--	--
40.00 *[2]	--	0.340 0.320	--	--	0.300	--	--
40.75 *[1]	--	0.360 0.340	--	--	0.320	--	--
40.75 *[2]	--	0.340 0.320	--	--	0.300	--	--

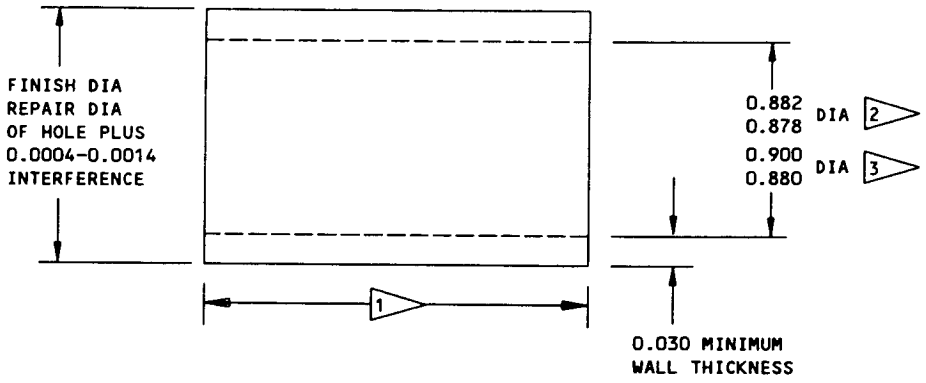
*[1] FOR 65-46409-1, -2, -5, -6

*[2] FOR 65-46409-9, -10, -12, -15, -16, -17, -18, -19, -20, -23, -24 THRU -26; 65C35617-5, -6

ALL DIMENSIONS ARE IN INCHES

65-46409-1, -2, -5, -6, -9, -10, -12, -15 thru -20, -23 thru -26,
65C35617-5, -6

Outboard Flap Track Repair
Figure 5 (Sheet 4)



REFINISH

CADMIUM PLATE AS SHOWN IN SOPM 20-42-05

1 EQUAL TO OR 0.0010 LESS THAN THE BORE LENGTH

2 ALL 65-46409 TRACKS BUT -25,-26; 65C35617-5,-6

3 TRACKS 65-46409-25,-26

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

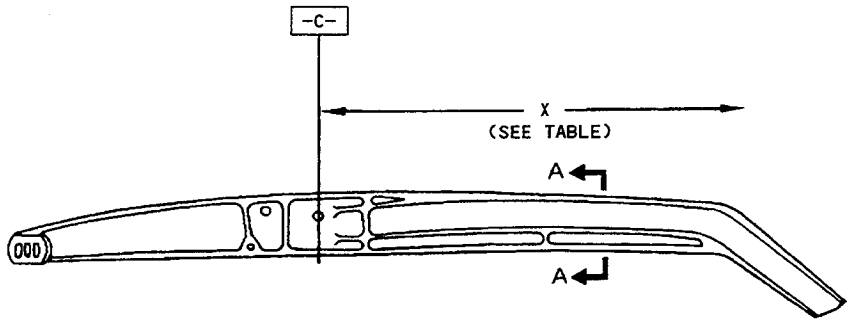
MATERIAL: 15-5PH OR 17-4PH CRES, 180-200 KSI

ALL DIMENSIONS ARE IN INCHES

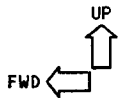
OUTBOARD FLAP TRACK HOLES (FIG. 5)

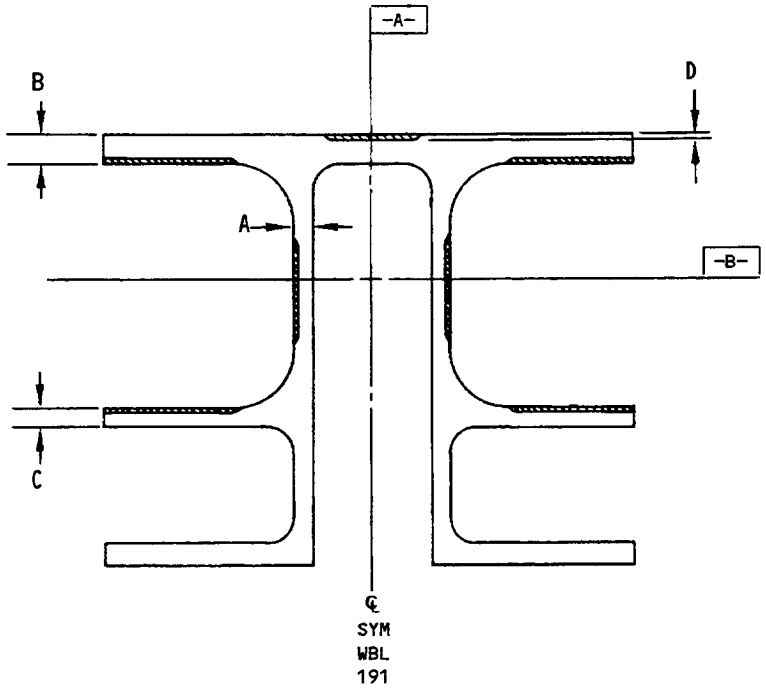
Repair Sleeve Details
Figure 5A

E40324



LEFT SIDE VIEW





A-A

CARRIAGE CONTACT
WEAR SURFACE

65-67136-1,-2

Outboard Flap Track Repair
Figure 6 (Sheet 1)

G49523

DIM	DESIGN DIMENSIONS BEFORE PLATING			MIN REPAIR THICKNESS			WEAR TOL
X	A	B	C	A	B	C	D
5.12	–	0.795 0.752	0.220 0.200	–	0.732	0.180	–
7.12	–	0.504 0.462	0.220 0.200	–	0.442	0.180	–
8.00	0.160 0.140	0.407 0.364	0.220 0.200	0.135	0.344	0.180	0.010
11.12	0.160 0.140	0.260 0.240	0.220 0.200	0.135	0.220	0.180	0.010
14.12	0.160 0.140	0.260 0.240	0.220 0.200	0.135	0.220	0.180	0.010
17.12	0.160 0.140	0.260 0.240	0.220 0.200	0.135	0.220	0.180	0.010
20.12	0.160 0.140	0.260 0.240	0.220 0.200	0.135	0.220	0.180	0.010
23.12	0.160 0.140	0.260 0.240	0.220 0.200	0.135	0.220	0.180	0.010
26.12	0.160 0.140	0.260 0.240	0.220 0.200	0.135	0.220	0.180	0.010
27.12	0.160 0.140	0.260 0.240	0.220 0.200	0.135	0.220	0.180	0.010
28.12	0.160 0.140	0.260 0.240	0.220 0.200	0.135	0.220	0.180	–
29.12	0.160 0.140	0.260 0.240	0.231 0.211	0.135	0.220	0.191	–
30.12	0.160 0.140	0.260 0.240	0.243 0.223	0.135	0.220	0.203	–
31.12	0.160 0.140	0.260 0.240	0.263 0.243	0.135	0.220	0.223	–
32.12	0.160 0.140	0.260 0.240	0.270 0.250	0.135	0.220	0.230	–
32.52	0.160 0.140	0.260 0.240	–	0.135	0.220	–	–
33.12	0.160 0.140	0.260 0.240	–	0.135	0.220	–	–
37.00	0.160 0.140	0.370 0.350	0.160 0.140	0.135	0.330	0.120	–
37.75	0.160 0.140	0.370 0.350	0.160 0.140	0.135	0.330	0.120	–
38.50	0.160 0.140	0.370 0.350	0.160 0.140	0.135	0.330	0.120	–
39.75	0.160 0.140	0.370 0.350	0.160 0.140	0.135	0.330	0.120	–

65-67136-1, -2

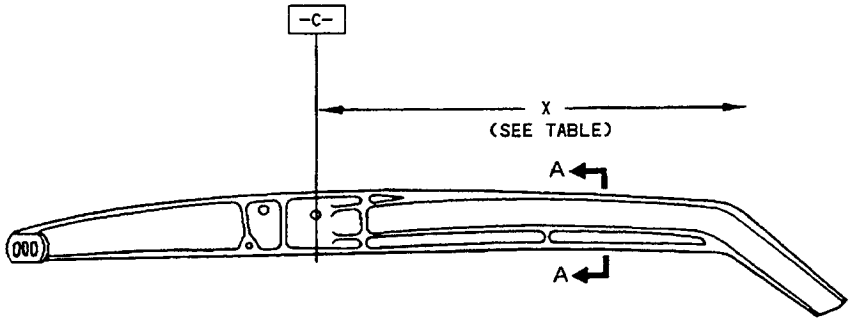
Outboard Flap Track Repair
Figure 6 (Sheet 2)

DIM	DESIGN DIMENSIONS BEFORE PLATING			MIN REPAIR THICKNESS			WEAR TOL
X	A	B	C	A	B	C	D
40.00	–	0.370 0.350	–	–	0.330	–	–
40.75	–	0.370 0.350	–	–	0.330	–	–

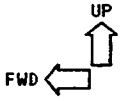
ALL DIMENSIONS ARE IN INCHES

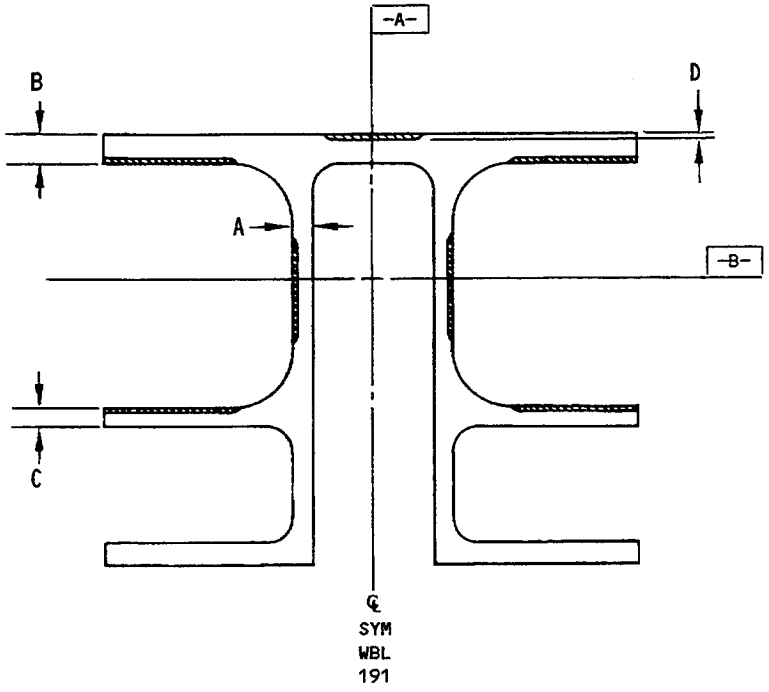
65-67136-1, -2

Outboard Flap Track Repair
Figure 6 (Sheet 3)



LEFT SIDE VIEW





A-A

CARRIAGE CONTACT WEAR SURFACE

65C35165-1,-2

Outboard Flap Track Repair
Figure 7 (Sheet 1)

G49553

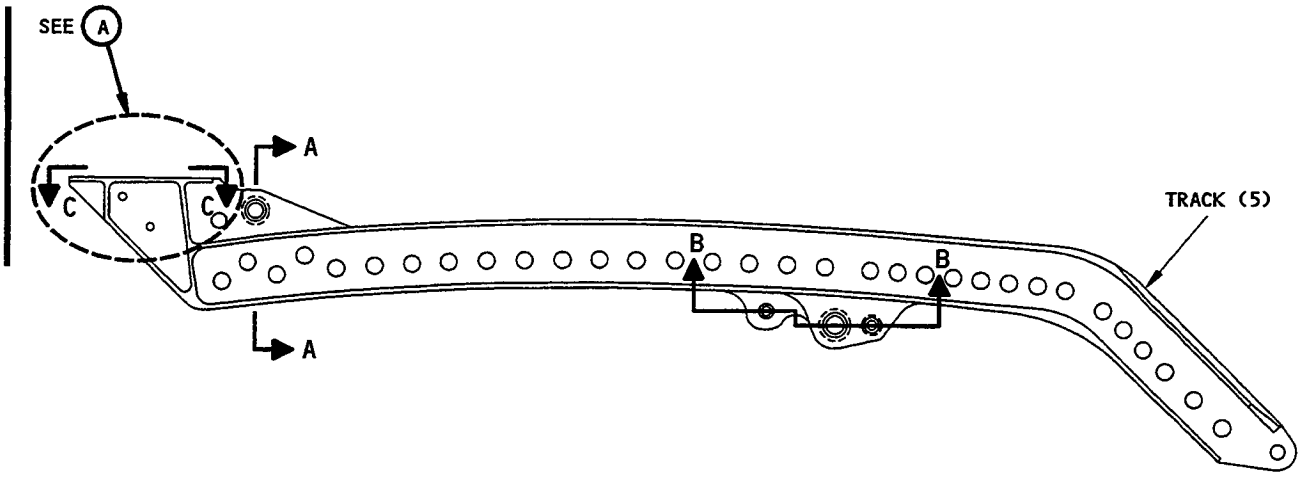
DIM	DESIGN DIMENSIONS BEFORE PLATING			MIN REPAIR THICKNESS			WEAR TOL
X	A	B	C	A	B	C	D
5.12	--	0.854 0.812	0.190 0.170	--	0.792	0.150	--
7.12	--	0.499 0.450	0.190 0.170	--	0.430	0.150	--
8.00	0.182 0.160	0.390 0.342	--	0.155	0.322	--	0.010
11.12	0.182 0.160	0.210 0.190	0.190 0.170	0.155	0.170	0.150	0.010
14.12	0.182 0.160	0.210 0.190	0.190 0.170	0.155	0.170	0.150	0.010
17.12	0.182 0.160	0.210 0.190	0.190 0.170	0.155	0.170	0.150	0.010
20.12	0.182 0.160	0.210 0.190	0.190 0.170	0.155	0.170	0.150	0.010
23.12	0.182 0.160	0.210 0.190	0.190 0.170	0.155	0.170	0.150	0.010
26.12	0.182 0.160	0.210 0.190	0.190 0.170	0.155	0.170	0.150	0.010
27.12	0.182 0.160	0.210 0.190	0.190 0.170	0.155	0.170	0.150	0.010
28.12	0.182 0.160	0.210 0.190	0.190 0.170	0.155	0.170	0.150	--
29.12	0.182 0.160	0.210 0.190	0.201 0.181	0.155	0.170	0.161	--
30.12	0.182 0.160	0.210 0.190	0.213 0.193	0.155	0.170	0.173	--
31.12	0.182 0.160	0.210 0.190	--	0.155	0.170	--	--
32.12	0.182 0.160	0.207 0.187	1.069 1.008	0.155	0.167	0.988	--
32.52	0.182 0.160	0.205 0.185	1.042 0.980	0.155	0.165	0.960	--
33.12	0.182 0.160	0.204 0.184	0.998 0.936	0.155	0.164	0.916	--
37.00	0.182 0.160	0.340 0.320	0.130 0.110	0.155	0.300	0.090	--
37.75	0.182 0.160	0.340 0.320	0.130 0.110	0.155	0.300	0.090	--
38.50	0.182 0.160	0.340 0.320	0.130 0.110	0.155	0.300	0.090	--
39.75	0.182 0.160	0.340 0.320	0.130 0.110	0.155	0.300	0.090	--

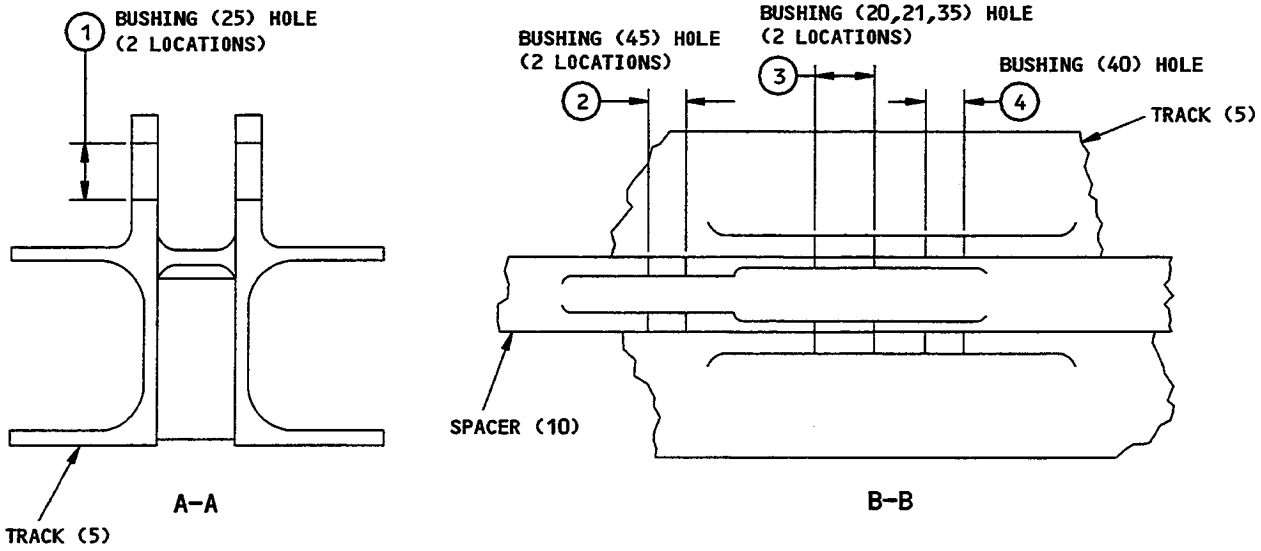
DIM	DESIGN DIMENSIONS BEFORE PLATING			MIN REPAIR THICKNESS			WEAR TOL
X	A	B	C	A	B	C	D
40.00	--	0.340 0.320	--	--	0.300	--	--
41.72	--	0.340 0.320	--	--	0.300	--	--

ALL DIMENSIONS ARE IN INCHES

65C35165-1, -2

Outboard Flap Track Repair
Figure 7 (Sheet 3)





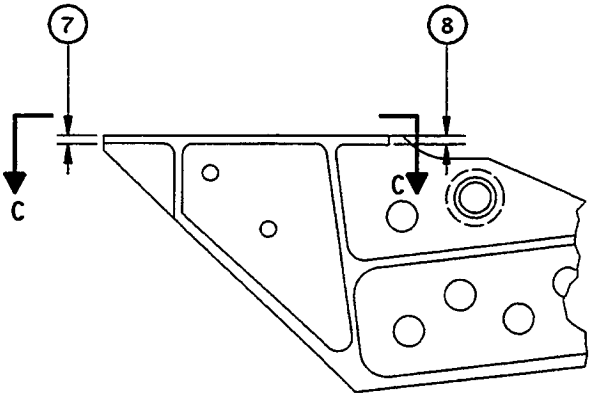
ITEM NUMBERS REFER TO FIG. 9

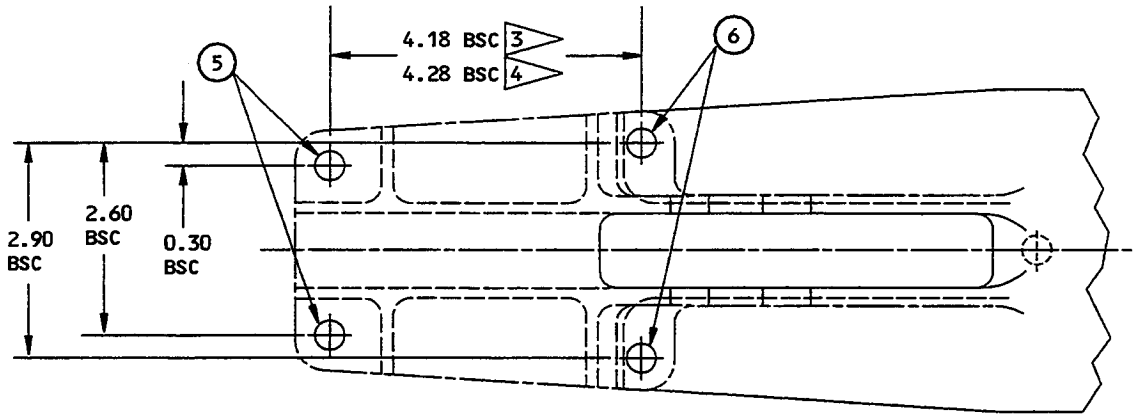
ALL DIMENSIONS ARE IN INCHES

65-46407-1, -3, -6, -8 THRU -13, -15, -16

Track Repair
Figure 7A (Sheet 1)

B58707





C-C

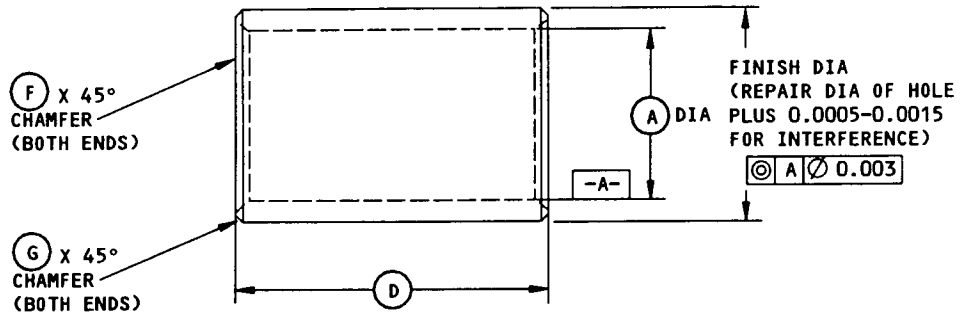
	1	2	3 1	3 2	4 1	4 2	5	6 3	6 4	7	8 5	8 6
DESIGN DIMENSION	0.6880 0.6873	0.5003 0.4997	0.6880 0.6872	0.8130 0.8122	0.5210 0.5000	0.5004 0.4998	0.379 0.376	0.379 0.376	0.442 0.438	0.15 0.13	0.15 0.13	0.26 0.24
REPAIR LIMIT 7	0.7505	0.5628	0.7505	0.8755	0.5835	0.5629	0.439 0.442	0.442 0.439	—	—	—	—

1 FOR TRACKS 65-46407-1, -6, -10, -13
2 FOR TRACKS 65-46407-3, -8, -9, -11, -12, -15, -16
3 FOR TRACKS 65-46407-1, -6, -8, -9, -10, -11, -13, -15, -16
4 FOR TRACKS 65-46407-3, -12
5 FOR TRACKS 65-46407-1, -3, -6, -8, -9, -10
6 FOR TRACKS 65-46407-11, -12, -13, -15, -16
7 LIMIT FOR INSTALLATION OF OVERSIZE OR REPAIR BUSHINGS (FIG. 7B)

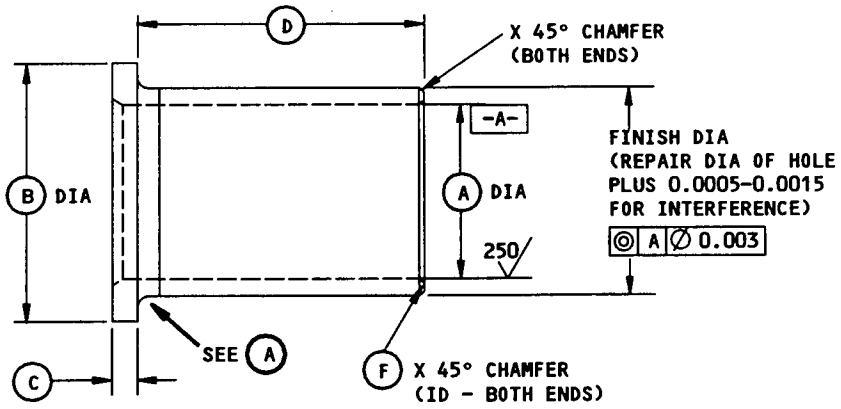
65-46407-1, -3, -6, -8 THRU -13, -15, -16

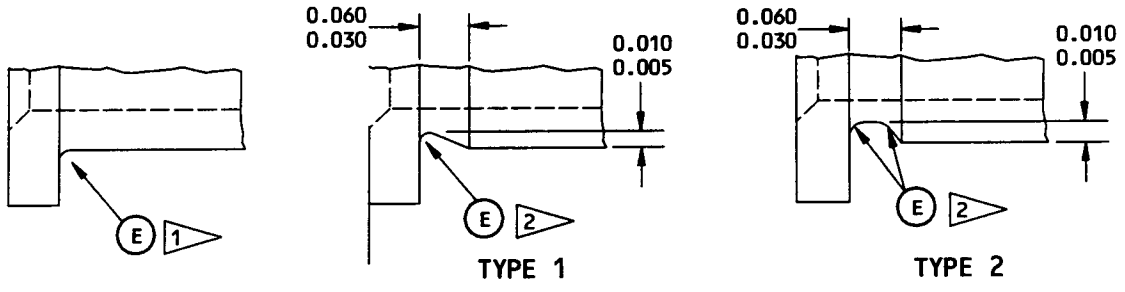
Track Repair
Figure 7A (Sheet 2)

B60560



REPLACES BUSHING (45) BACB28Y6C23





REPLACES BUSHINGS (20) 66-23224-1, (21) 66-23224-2,
(25) 69-37234-15, (35) BACB28W10C43,
(40) BACB28X6C27.

A

Oversize and Repair Bushing Details
Figure 7B (Sheet 1)

HOLE LOCATION (FIG. 7A)	REPLACES BUSHING (FIG. 9)	(A) I.D.	(B) FLANGE O.D.	(C) FLANGE	(D) LENGTH	(E) RADIUS	(F) CHAMFER	(G) CHAMFER	MATERIAL	FINISH (SOPM 20-41-01)
1	25	0.5630 0.5620	0.885 0.865	0.090 0.080	0.280 0.275	0.030 0.020	0.013 0.009	0.013 0.003	3	F-15.02
2	45	0.3765 0.3750	——	——	0.230 0.225	——	0.015 0.005	0.015 0.005	3	F-15.06
3	20	0.5630 0.5620	1.380 1.360	0.135 0.115	0.260 0.250	0.030 0.020	0.030 0.020	0.015 0.005	4	F-4.201
3	21	0.6255 0.6245	1.540 1.520	0.135 0.115	0.260 0.250	0.030 0.020	0.030 0.020	0.015 0.005	4	F-4.201
3	35	0.6255 0.6245	1.010 0.990	0.060 0.055	0.430 0.425	0.005 0.002	0.020 0.010	0.015 0.005	3	F-15.06
4	40	0.3765 0.3750	0.635 0.615	0.062 0.057	0.270 0.265	0.005 0.002	0.015 0.005	0.015 0.005	3	F-15.06
5, 6	---	0.379 0.376	0.635 0.615	0.062 0.057	0.140 0.130 (5) 0.250 0.240 (6)	0.005 0.002	0.015 0.005	0.015 0.005	3	F-15.06

1. NOT ON BUSHINGS 66-23224-1,-2; 69-37234-15
2. UNDERCUT TYPE 1 OR TYPE 2 OPTIONAL
3. MATERIAL: 17-4 PH CRES PER AMS 5643, (180-200 KSI). MAGNETIC PARTICLE EXAMINE PER SOPM 20-20-01, CLASS B
4. MATERIAL: ALUMINUM NICKEL BRONZE PER AMS 4640. PENETRANT EXAMINE PER SOPM 20-20-02
5. FOR THIN MOUNTING FLANGE
6. FOR THICK MOUNTING FLANGE

63 ALL MACHINED SURFACES, EXCEPT AS NOTED. BREAK ALL SHARP EDGES.

DIMENSIONS APPLY AFTER PLATING

ITEM NUMBERS REFER TO IPL FIG. 9

ALL DIMENSIONS ARE IN INCHES

Oversize and Repair Bushing Details
Figure 7B (Sheet 2)

B60715

5. ASSEMBLY (Fig. 9, 10, 11, 12, 13)

A. Assemble track (5) and spacer (10) as follows:

(1) Put spacer (10) in tracks (5). Apply a faying surface seal of BMS 5-95 sealant between the track and the spacer. Apply sealant to all mating surfaces between the parts. Apply a fillet seal of sealant on the lower surface between the track and spacer, each side and along the full length of the spacer.

CAUTION: THE 69-67217-3 BOLT LENGTH MUST BE 0.61-0.64 INCH TO BE SURE THERE IS A GAP BETWEEN ADJACENT ENDS OF OPPOSITE BOLTS (30, FIG. 9, 10, 11; 31, FIG. 3; 35, FIG. 12, 13) WHEN INSTALLED. BOLTS OF OTHER LENGTHS COULD TOUCH ENDS AND NOT CORRECTLY HOLD DOWN THE COMPONENTS.

(2) Get 69-67217-3 bolts (30, Fig. 9, 10, 11; 31, Fig. 9; 35, Fig. 12, 13) that have a length of 0.61-0.64 inch.

NOTE: If necessary, you can remove material from the end of the bolts to adjust their length to 0.61-0.64 inch. The smaller chamfer this makes on the bolt end is acceptable. No bolt finish touch-up is necessary.

(3) Apply BMS 5-95 sealant to holes and threads of these 69-67217-3 bolts (30, Fig. 9, 10, 11; 31, Fig. 9; 35, Fig. 12, 13) and install it while the sealant is wet. Tighten bolts to 100-140 pound-inches. Remove unwanted sealant.

(4) Machine the heads of the bolts, 69-67217-3 as follows:

(a) For the inboard, inboard flap track assemblies, 65-46438-xx, machine the heads of the aft six bolts (30, Fig. 9) flush with the track to within plus 0.005 inch and minus 0.005 inch on each side of the track.

(b) For the outboard, inboard flap track assemblies, 65-46439-xx, 65C35617-x, 65C35276-x, and 65C36867-x, machine the heads of the aft thirteen bolts (30, Fig. 10 and 11; 35, Fig. 12, 13) flush with the track to within plus 0.005 inch and minus 0.005 inch on each side of the tracks.

NOTE: Removal of cadmium plating from track (5) is not permitted.

(5) Apply BMS 5-95, class B sealant to threads and shank of bolt (70, Fig. 10, 11; 55, Fig. 12, 13) and install it while the sealant is wet with nut (76, Fig.10 ; 65, Fig. 11; 130, Fig. 12, 13) and washers (120, 125, Fig. 12, 13). Remove unwanted sealant.

(6) Apply BMS 5-95, class B sealant to threads and shank of bolt (35, Fig. 10, 11; 50, 52, Fig. 12, 13) and install it while the sealant is wet. Tighten nut (45, Fig. 10, 45, Fig. 11, NAS1804-6) to 220-360 pound-inches. Tighten nut (45, Fig. 11, BACN10HR6CD, 85, Fig. 12, 13) to 220-410 pound-inches. Remove unwanted sealant.

(7) Apply BMS 5-95, class B sealant to shank and locking groove of lockbolt (40, Fig. 10) and assemble it while the sealant is wet. Remove unwanted sealant.

(8) Install bolts (46, 47, 48, 49, Fig. 10), washers (46E, 46H, 47E, 47H, 48E, 48H, 49E, 49H, Fig. 10), nuts (46M, 47M, 48M, 49M) with BMS 5-95 sealant.

(9) Tighten nuts (46, 47, Fig. 10) to 220-410 pound-inches, nut (48, Fig. 10) to 65-100 pound-inches, and nut (49, Fig. 10) to 130-200 pound-inches.

(10) Apply BMS 5-95, class B sealant to threads and shank of bolt (40, Fig. 12, 13) and install it while the sealant is wet. Tighten nut (75. Fig. 12, 13) to 65-100 pound-inches. Remove unwanted sealant.

(11) Apply BMS 5-95, class B sealant to threads and shank of bolt (45, Fig. 12, 13) and install it while the sealant is wet. Tighten nut (80, Fig. 12, 13) to 130-200 pound-inches. Remove unwanted sealant.

(12) Apply BMS 10-11, Class B sealant to threads and shank of bolt (115, Fig. 11) and install it while the sealant is wet. Tighten nut (100, Fig. 11) to 65-100 pound-inches. Remove unwanted sealant.

(13) Apply BMS 10-11, Class B sealant to threads and shank of bolt (135, Fig. 11) and install it while the sealant is wet. Tighten nut (120, Fig. 11) to 130-200 pound-inches. Remove unwanted sealant.

(14) Apply BMS 10-11, Class B sealant to threads and shank of bolt (155, Fig. 11) and install it while the sealant is wet. Tighten nut (140, Fig. 11) to 220-410 pound-inches. Remove unwanted sealant.

B. Install stop (15) with bolts (50, 55, Fig. 9; 75, 80, Fig. 10, 11; 60, 65, Fig. 12, 13) and these steps.

(1) Apply BMS 3-24 grease to the ID bore surfaces of stop (15) and track (5).

(2) Install MS20995NC-32 lockwire on the fasteners by the double twist method.

6. FITS AND CLEARANCES

Mating Item No.	IPL Fig. No.	Design Dimensions: Dimensions (inches) Min	Design Dimensions: Dimensions (inches) Max	Design Dimensions: Assembly Clearance (inch) Min	Design Dimensions: Assembly Clearance (inch) Max	Service Wear Limits ▷: Dimension Limits (inches) Min	Service Wear Limits ▷: Dimension Limits (inches) Max	Service Wear Limits ▷: Maximum Allowable Clearance (inch)
ID 20	9	0.5620	0.5630	0.0005	0.0020		0.5650	0.0040
OD *[1]		0.5610	0.5615			0.5590		
ID 21	9	0.6245	0.6255	0.0005	0.0020		0.6275	0.0040
OD *[2]		0.6235	0.6240			0.6215		
ID 25	9	0.5620	0.5630	0.0005	0.0020		0.5650	0.0040
OD *[3]		0.5610	0.5615			0.5590		
ID 35	9	0.6245	0.6255	0.0005	0.0020		0.6275	0.0040
OD *[2]		0.6235	0.6240			0.6215		
ID 40	9	0.3750	0.3765	0.0005	0.0025		0.3790	0.0050
OD *[4]		0.3740	0.3745			0.3715		
ID 40	9	0.3750	0.3765	0.0005	0.0030		0.3795	0.0060
OD *[5]		0.3735	0.3745			0.3705		
ID 45	9	0.3750	0.3780	0.0005	0.0040		0.3800	0.0060
OD *[6]		0.3740	0.3745			0.3720		
ID 20	10	0.4995	0.5005	0.0000	0.0015		0.5090	0.0100
OD *[7]		0.4990	0.4995			0.4905		
ID 20	10	0.4995	0.5005	0.0000	0.0020		0.5085	0.0100
OD *[8]		0.4985	0.4995			0.4905		
ID 25	10	0.4370	0.4380	0.0000	0.0015		0.4465	0.0100
OD *[9]		0.4365	0.4370			0.4280		
ID 20	11	0.4995	0.5005	0.0000	0.0020		0.5085	0.0100
OD *[8]		0.4985	0.5995			0.4905		

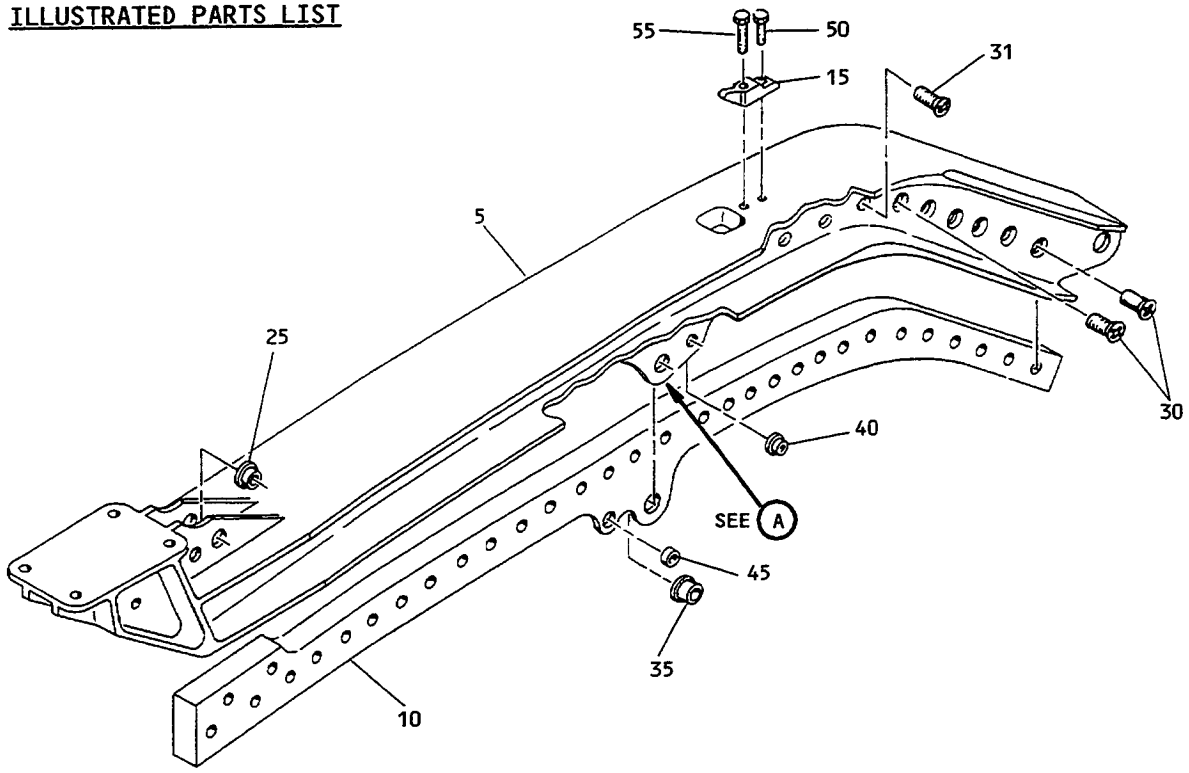
Fits and Clearances
Figure 8 (Sheet 1)

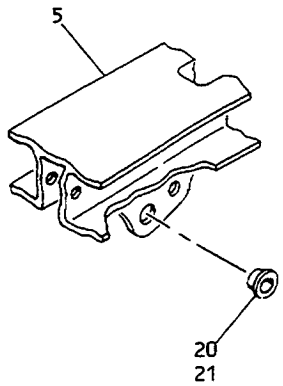
Mating Item No.	IPL Fig. No.	Design Dimensions: Dimensions (inches) Min	Design Dimensions: Dimensions (inches) Max	Design Dimensions: Assembly Clearance (inch) Min	Design Dimensions: Assembly Clearance (inch) Max	Service Wear Limits [1]: Dimension Limits (inches) Min	Service Wear Limits [1]: Dimension Limits (inches) Max	Service Wear Limits [1]: Maximum Allowable Clearance (inch)
ID 21	11	0.5620	0.5630	0.0005	0.0020		0.5710	0.0100
OD *[10]		0.5610	0.5615			0.5530		
ID 22	11	0.5620	0.5630	0.0020	0.0035		0.5695	0.0100
OD *[11]		0.5595	0.5600			0.5530		
ID 23	11	0.5620	0.5630	0.0005	0.0020		0.5710	0.0100
OD *[10]		0.5610	0.5615			0.5530		
ID 24	11	0.5620	0.5630	0.0020	0.0035		0.5695	0.0100
OD *[11]		0.5595	0.5600			0.5530		
ID 20	12	0.4995	0.5005	0.0000	0.0015		0.5090	0.0100
OD *[12]		0.4990	0.4995			0.4905		
ID 25	12	0.5620	0.5630	0.0020	0.0035		0.5695	0.0100
OD *[11]		0.5595	0.5600			0.5530		
ID 30	12	0.5620	0.5630	0.0020	0.0035		0.5695	0.0100
OD *[11]		0.5595	0.5600			0.5530		

*[1] BOLT BACB30LT9DU40
*[2] BOLT BACB30LE10U26 (DWG 65-63400)
*[3] BOLT BACB30LM9DU25
*[4] BOLT BACB30LJ6DU40
*[5] BOLT NAS1106-12 (DWG 65-63400)
*[6] BOLT BACB30LT6DU17 (DWG 65-63400)
*[7] BOLT BACB30LE8HU29, BACB30LE8HU31, OR BACB30LE8HU32
*[8] BOLT BACB30LE8H35
*[9] BOLT BACB30LE7HU28
*[10] PIN 69-73103-1 OR 69-73103-2 (DWG 65C26300)
*[11] PIN 69-73103-4 (DWG 65C26300)
*[12] BOLT BACB30LE8HU35

[1] REMOVE AND REPLACE IF SERVICE WEAR LIMITS ARE EXCEEDED.

7. ILLUSTRATED PARTS LIST





65-46438-1,-2,-4,-10 AND -11 ONLY

(A)

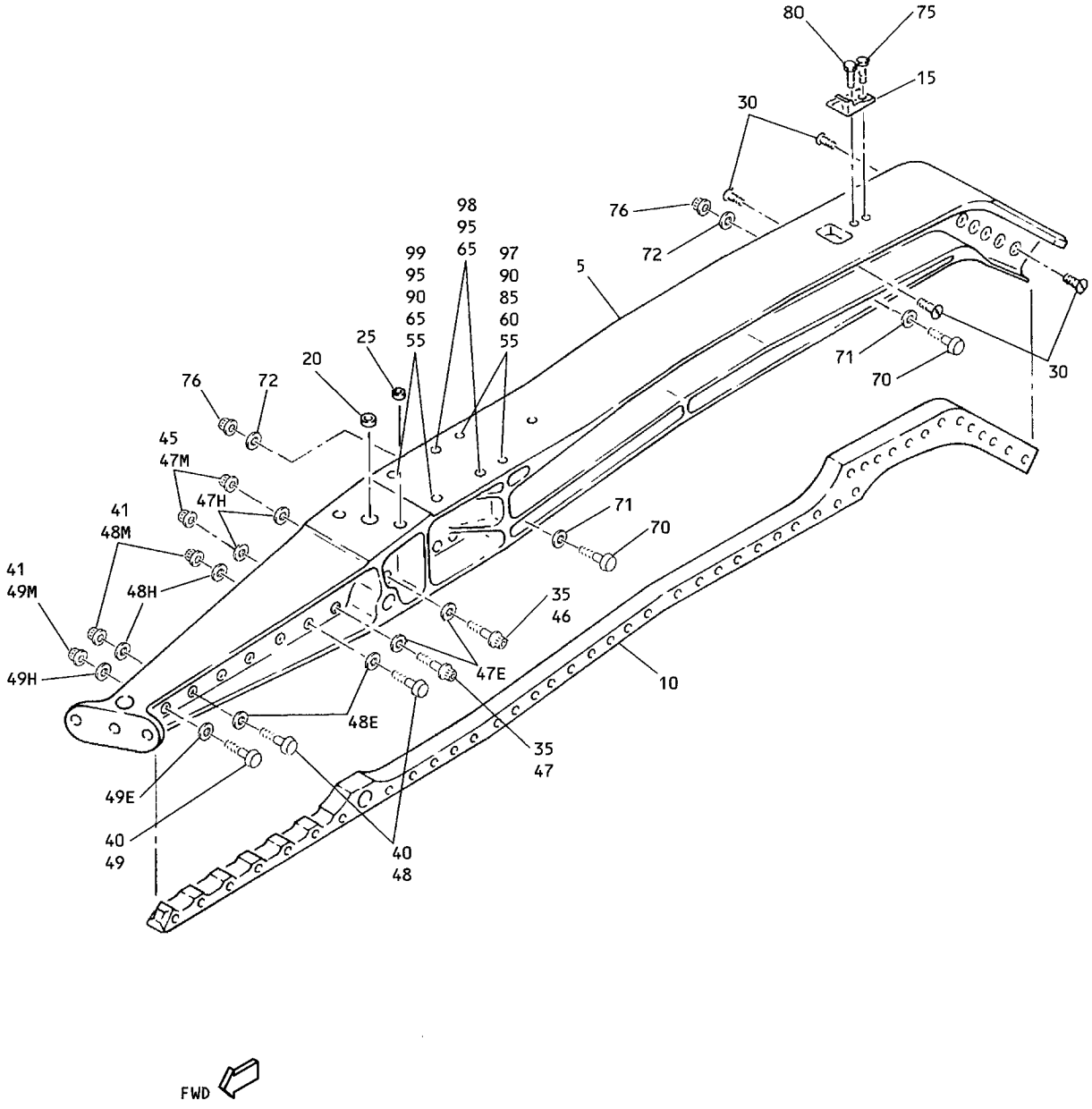
Inboard Flap, Inboard Track Assembly
Figure 9

F78875

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
9-					
	65-46438-1		TRACK ASSY, INBD FLAP, INBD	A	RF
	65-46438-2		TRACK ASSY, INBD FLAP, INBD	B	RF
	65-46438-4		TRACK ASSY, INBD FLAP, INBD	C	RF
	65-46438-5		TRACK ASSY, INBD FLAP, INBD	D	RF
	65-46438-6		TRACK ASSY, INBD FLAP, INBD	E	RF
	65-46438-7		TRACK ASSY, INBD FLAP, INBD	F	RF
	65-46438-8		TRACK ASSY, INBD FLAP, INBD	G	RF
	65-46438-9		TRACK ASSY, INBD FLAP, INBD	H	RF
	65-46438-10		TRACK ASSY, INBD FLAP, INBD	I	RF
	65-46438-11		TRACK ASSY, INBD FLAP, INBD	J	RF
	65-46438-12		TRACK ASSY, INBD FLAP, INBD	K	RF
	65-46438-13		TRACK ASSY, INBD FLAP, INBD	L	RF
	65-46438-14		TRACK ASSY, INBD FLAP, INBD	M	RF
	65-46438-15		TRACK ASSY, INBD FLAP, INBD	N	RF
	65-46439-1		TRACK ASSY, INBD FLAP, OUTBD (SEE FIG. 10 FOR DETAILS)		RF
	65-46439-2		TRACK ASSY, INBD FLAP, OUTBD (SEE FIG. 10 FOR DETAILS)		RF
	65-46439-3		TRACK ASSY, INBD FLAP, OUTBD (SEE FIG. 10 FOR DETAILS)		RF
	65-46439-4		TRACK ASSY, INBD FLAP, OUTBD (SEE FIG. 10 FOR DETAILS)		RF
	65-46439-5		TRACK ASSY, INBD FLAP, OUTBD (SEE FIG. 10 FOR DETAILS)		RF
	65-46439-6		TRACK ASSY, INBD FLAP, OUTBD (SEE FIG. 10 FOR DETAILS)		RF
	65-46439-7		TRACK ASSY, INBD FLAP, OUTBD (SEE FIG. 10 FOR DETAILS)		RF
	65-46439-8		TRACK ASSY, INBD FLAP, OUTBD (SEE FIG. 10 FOR DETAILS)		RF
	65-46439-10		TRACK ASSY, INBD FLAP, OUTBD (SEE FIG. 10 FOR DETAILS)		RF
	65-46439-11		TRACK ASSY, INBD FLAP, OUTBD (SEE FIG. 10 FOR DETAILS)		RF
	65-46439-12		TRACK ASSY, INBD FLAP, OUTBD (SEE FIG. 10 FOR DETAILS)		RF
	65-46439-14		TRACK ASSY, INBD FLAP, OUTBD (SEE FIG. 10 FOR DETAILS)		RF
	65-46439-15		TRACK ASSY, INBD FLAP, OUTBD (SEE FIG. 10 FOR DETAILS)		RF
	65-46439-16		TRACK ASSY, INBD FLAP, OUTBD (SEE FIG. 10 FOR DETAILS)		RF
	65-46439-17		TRACK ASSY, INBD FLAP, OUTBD (SEE FIG. 10, 11 FOR DETAILS)		RF

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
9-					
	65-46439-18		TRACK ASSY, INBD FLAP, OUTBD (SEE FIG. 10, 11 FOR DETAILS)		RF
	65-46439-19		TRACK ASSY, INBD FLAP, OUTBD (SEE FIG. 11 FOR DETAILS)		RF
	65-46439-20		TRACK ASSY, INBD FLAP, OUTBD (SEE FIG. 11 FOR DETAILS)		RF
	65-46439-21		TRACK ASSY, INBD FLAP, OUTBD (SEE FIG. 11 FOR DETAILS)		RF
	65-46439-22		TRACK ASSY, INBD FLAP, OUTBD (SEE FIG. 11 FOR DETAILS)		RF
	65-46439-23		TRACK ASSY, INBD FLAP, OUTBD (SEE FIG. 11 FOR DETAILS)		RF
	65-46439-24		TRACK ASSY, INBD FLAP, OUTBD (SEE FIG. 11 FOR DETAILS)		RF
	65-46439-25		TRACK ASSY, INBD FLAP, OUTBD (SEE FIG. 11 FOR DETAILS)		RF
	65-46439-26		TRACK ASSY, INBD FLAP, OUTBD (SEE FIG. 11 FOR DETAILS)		RF
	65C35617-3		TRACK ASSY, INBD FLAP, OUTBD (SEE FIG. 11 FOR DETAILS)		RF
	65C35617-4		TRACK ASSY, INBD FLAP, OUTBD (SEE FIG. 11 FOR DETAILS)		RF
	65C35276-1		TRACK ASSY, INBD FLAP, OUTBD (SEE FIG. 12 FOR DETAILS)		RF
	65C35276-2		TRACK ASSY, INBD FLAP, OUTBD (SEE FIG. 12 FOR DETAILS)		RF
	65C36867-1		TRACK ASSY, INBD FLAP, OUTBD (SEE FIG. 13 FOR DETAILS) (PRE SB 737-57-1239)		RF
	65C36867-2		TRACK ASSY, INBD FLAP, OUTBD (SEE FIG. 13 FOR DETAILS) (PRE SB 737-57-1239)		RF
	65C36867-3		TRACK ASSY, INBD FLAP, OUTBD (SEE FIG. 13 FOR DETAILS) (POST SB 737-57-1239)		RF
	65C36867-4		TRACK ASSY, INBD FLAP, OUTBD (SEE FIG. 13 FOR DETAILS) (POST SB 737-57-1239)		RF
5	65-46407-1		. TRACK	A	1
5	65-46407-12		. TRACK	HI	1
5	65-46407-13		. TRACK	J	1
5	65-46407-15		. TRACK	K	1
5	65-46407-16		. TRACK	L-N	1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
9-					
5	65-46407-3		. TRACK	BE	1
5	65-46407-6		. TRACK	C	1
5	65-46407-10		. TRACK (OPT)	C	1
5	65-46407-8		. TRACK	D	1
5	65-46407-9		. TRACK	F	1
5	65-46407-11		. TRACK	G	1
10	65-46407-5		. SPACER	A-CIJ	1
10	65-46407-2		. SPACER (OPT)	ACJ	1
10	65-46407-7		. SPACER	D-HK-N	1
10	65-46407-14		. SPACER (OPT)	EGK-N	1
15	66-23211-1		. STOP		1
20	66-23224-1		. BUSHING	ACJ	2
21	66-23224-2		. BUSHING	BI	2
25	69-37234-15		. BUSHING		2
30	69-67217-3		. BOLT		12
31	69-67217-3		. BOLT		52
35	BACB28W10C43		. BUSHING	D-HK-N	2
40	BACB28X6C27		. BUSHING	D-HK-N	2
45	BACB28Y6C23		. BUSHING	D-HK-N	2
50	BACB30NR4HK3		. BOLT, HEX HEAD	MN	1
50	NAS1304-3HW		. BOLT, HEX HEAD	A-L	1
55	BACB30NR4HK6		. BOLT, HEX HEAD	MN	1
55	NAS1304-6HW		. BOLT, HEX HEAD	A-L	1



Inboard Flap, Outboard Track Assembly
Figure 10

F78895

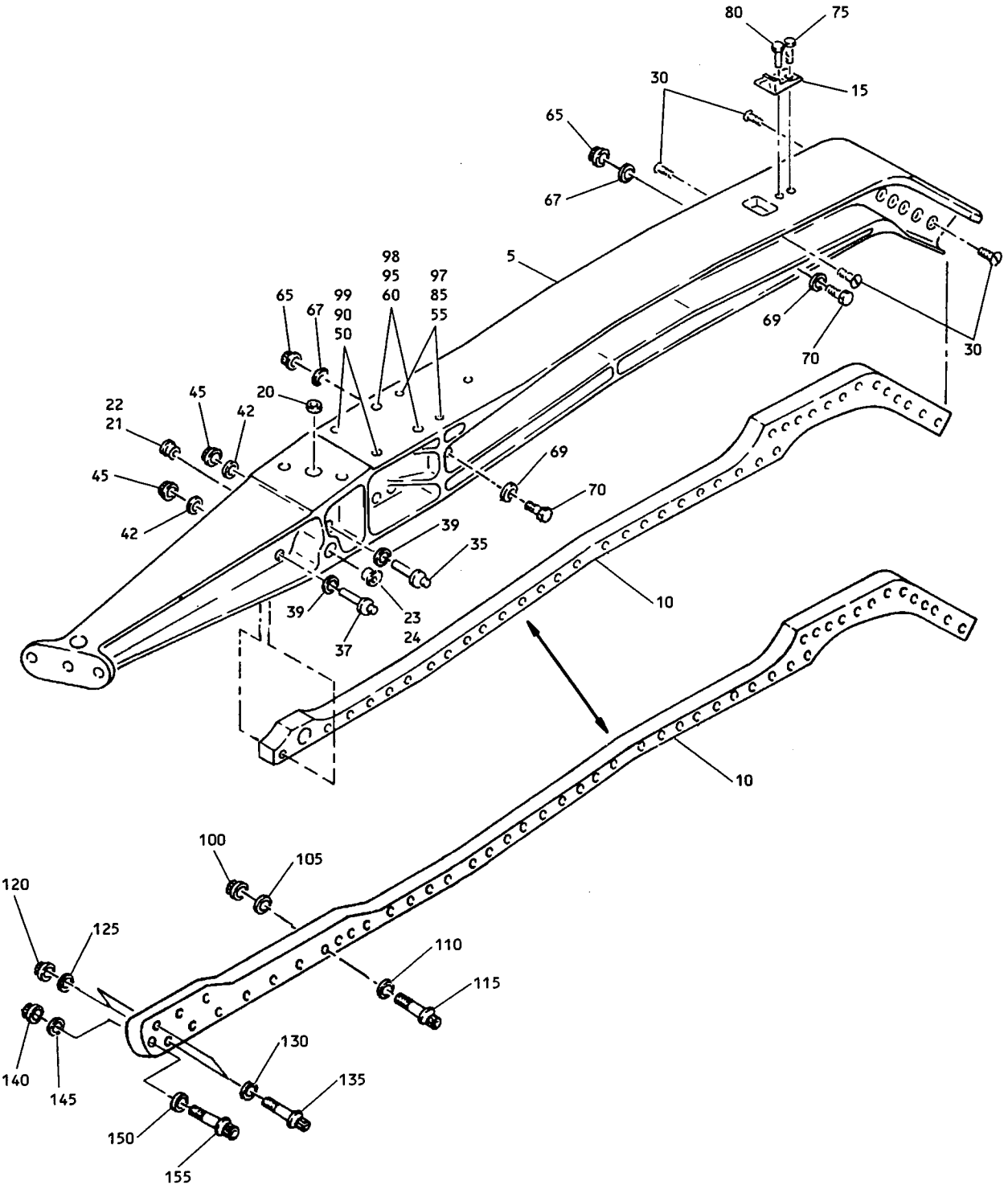
FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
10-					
	65-46439-1		TRACK ASSY, INBD FLAP, OUTBD	A	RF
	65-46439-2		TRACK ASSY, INBD FLAP, OUTBD	B	RF
	65-46439-3		TRACK ASSY, INBD FLAP, OUTBD	C	RF
	65-46439-4		TRACK ASSY, INBD FLAP, OUTBD	D	RF
	65-46439-5		TRACK ASSY, INBD FLAP, OUTBD	E	RF
	65-46439-6		TRACK ASSY, INBD FLAP, OUTBD	F	RF
	65-46439-7		TRACK ASSY, INBD FLAP, OUTBD	G	RF
	65-46439-8		TRACK ASSY, INBD FLAP, OUTBD	H	RF
	65-46439-10		TRACK ASSY, INBD FLAP, OUTBD	I	RF
	65-46439-11		TRACK ASSY, INBD FLAP, OUTBD	J	RF
	65-46439-12		TRACK ASSY, INBD FLAP, OUTBD	K	RF
	65-46439-14		TRACK ASSY, INBD FLAP, OUTBD	L	RF
	65-46439-15		TRACK ASSY, INBD FLAP, OUTBD	M	RF
	65-46439-16		TRACK ASSY, INBD FLAP, OUTBD	N	RF
	65-46439-17		TRACK ASSY, INBD FLAP, OUTBD *[1]	O	RF
	65-46439-18		TRACK ASSY, INBD FLAP, OUTBD *[1]	P	RF
	65-46439-27		TRACK ASSY, INBD FLAP, OUTBD (POST SB 737-57-1203) (SEE FIG. 11 FOR PRE SB 737-57-1203)	Q	RF
	65-46439-28		TRACK ASSY, INBD FLAP, OUTBD (POST SB 737-57-1203) (SEE FIG. 11 FOR PRE SB 737-57-1203)	R	RF
5	65-46409-1		. TRACK	A	1
5	65-46409-2		. TRACK	B	1
5	65-46409-5		. TRACK	C	1
5	65-46409-6		. TRACK	D	1
5	65-67136-1		. TRACK	E	1
5	65-67136-2		. TRACK	F	1
5	65-46409-9		. TRACK	G	1
5	65-46409-10		. TRACK	H	1
5	65-46409-12		. TRACK	IL	1
5	65-46409-15		. TRACK	J	1
5	65-46409-16		. TRACK	K	1
5	65-46409-17		. TRACK	MO	1
5	65-46409-18		. TRACK	NP	1
5	65-46409-25		. TRACK	Q	1
5	65-46409-26		. TRACK	R	1
10	65-46409-7		. SPACER	A-P	1
10	65-46409-3		. SPACER (OPT TO 65-46409-7)	A-D I L-P	1
10	65-46409-3		. SPACER (LIMITED) (OPT TO 65-46409-7)	GH	1
10	65-46409-13		. SPACER (OPT TO 65-46409-7)	GHJKM NOP	1
10	65-46409-27		. SPACER, FAIL-SAFE	QR	1
15	66-23211-1		. STOP		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
10-					
20	69-37234-4		. BUSHING	A-L	1
20	69-37234-25		. BUSHING	M-R	1
25	69-37234-24		. BUSHING	I	1
30	69-67217-3		. BOLT, 100 DEGREE		26
35	BACB30FD6-20		. BOLT	A-P	2
40	BACB30GW8-21		. LOCKBOLT	A-D	6
40	BACB30GW8-20		. LOCKBOLT	E-P	6
41	BACC30K8		. COLLAR		6
45	BACN10GW6		. NUT	A-P	2
46	BACB30LE6K22		. BOLT	QR	1
47	BACB30LE6K21		. BOLT	QR	1
47E	BACW10BP6CD		. WASHER	QR	2
47H	BACW10BP6DP		. WASHER	QR	2
47M	BACN10HR6CD		. NUT	QR	2
48	BACB30LE4K21		. BOLT	QR	5
48E	BACW10BP4CD		. WASHER	QR	5
48H	BACW10BP4DP		. WASHER	QR	5
48M	BACN10HR4CD		. NUT	QR	5
49	BACB30LE5K20		. BOLT	QR	1
49E	BACW10BP5CD		. WASHER	QR	1
49H	BACW10BP5DP		. WASHER	QR	1
49M	BACN10HR5CD		. NUT	QR	1
50	BACN10CT6		DELETED		
55	BACN10HR6		. NUT	EF	4
60	BACN10HR5		. NUT	A-D GH I-R	2
65	BACN10HR6		. NUT	A-H JK M-R	4
70	NAS1105-20		. BOLT	A-P	23
70	BACB30NM5K21		. BOLT	QR	23
71	BACW10CT10C		. WASHER	QR	23
72	AN906-516L		. WASHER	QR	23
75	NAS1304-3HW		. BOLT	A-P	1
75	BACB30NR4HK3		. BOLT	QR	1
76	NAS679-A5		. NUT	A-P	23
76	NAS1805-5N		. NUT	QR	23
80	NAS1304-6HW		. BOLT	A-P	1
80	BACB30NR4HK6		. BOLT	QR	1
85	NS02223-054		. RETAINER, V56878	A-D G-P	2
85	NS02223-064		DELETED		
90	NS02223-064		. RETAINER, V56878	EF	4
95	NS02223-064		. RETAINER, V56878	A-D G-P	4
97	BACR15BA4D		. RIVET	A-P	4
97	BACR15EB4P4		DELETED		
97	MS20427M4		. RIVET	QR	4

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
10-					
98	BACR15BA4D		. RIVET	A-D G-P	4
98	MS20427M4		. RIVET	QR	4
99	BACR15BA4D		. RIVET	A-P	4
99	MS20427M4		. RIVET	QR	4
			INSTALLATION PARTS		
-195	69-50772-11		FILLER	OP	1

- ITEM NOT ILLUSTRATED

*[1] 65-46439-17 IS THE SAME AS TRACK 65-46439-15 OR -21, AND TRACK 65-46439-18 IS THE SAME AS TRACK 65-46439-16 OR -22, EXCEPT THAT FILLER 69-50772-11 IS INCLUDED FOR POSSIBLE USE WHEN THE PARTS ARE INSTALLED ON THE AIRPLANE.



Inboard Flap, Outboard Track Assembly
Figure 11

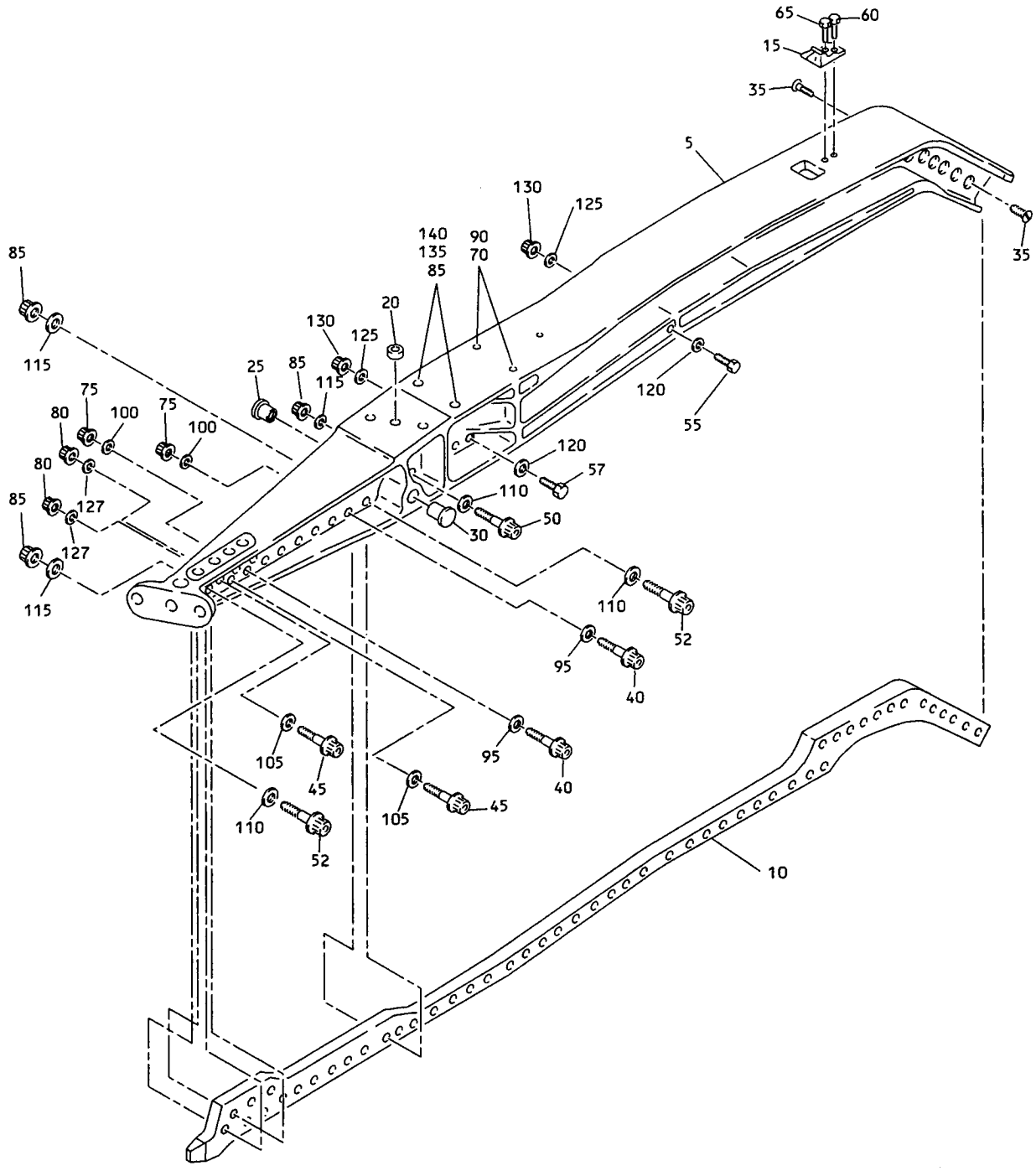
FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
11-					
	65-46439-19		TRACK ASSY, INBD FLAP, OUTBD (PRE SB 737-57-1203) (SEE ALSO FIG. 12 FOR POST SB 737-57-1203)	A	RF
	65-46439-20		TRACK ASSY, INBD FLAP, OUTBD (PRE SB 737-57-1203) (SEE ALSO FIG. 12 FOR POST SB 737-57-1203)	B	RF
	65-46439-21		TRACK ASSY, INBD FLAP, OUTBD(PRE SB 737-57-1203) (SEE FIG. 10 AND 13 FOR POST SB 737-57-1203)	C	RF
	65-46439-22		TRACK ASSY, INBD FLAP, OUTBD (PRE SB 737-57-1203) (SEE FIG. 10 AND 13 FOR POST SB 737-57-1203)	D	RF
	65-46439-23		TRACK ASSY, INBD FLAP, OUTBD (PRE SB 737-57-1203) (SEE ALSO FIG. 12 FOR POST SB 737-57-1203)	E	RF
	65-46439-24		TRACK ASSY, INBD FLAP, OUTBD (PRE SB 737-57-1203) (SEE ALSO FIG. 12 FOR POST SB 737-57-1203)	F	RF
	65-46439-25		TRACK ASSY, INBD FLAP, OUTBD (PRE SB 737-57-1203) (SEE ALSO FIG. 12 FOR POST SB 737-57-1203)	G	RF
	65-46439-26		TRACK ASSY, INBD FLAP, OUTBD (PRE SB 737-57-1203) (SEE ALSO FIG. 12 FOR POST SB 737-57-1203)	H	RF
	65-46439-17		TRACK ASSY, INBD FLAP, OUTBD *[1]	I	RF
	65-46439-18		TRACK ASSY, INBD FLAP, OUTBD *[1]	J	RF
	65C35617-3		TRACK ASSY, INBD FLAP, OUTBD (POST SB 737-57-1203)	K	RF
	65C35617-4		TRACK ASSY, INBD FLAP, OUTBD (POST SB 737-57-1203)	L	RF
5	65-46409-19		. TRACK (PRE SB 737-57-1203)	AEG	1
5	65C35388-3		. TRACK (POST SB 737-57-1203)	AEG	1
5	65-46409-20		. TRACK (PRE SB 737-57-1203)	BFH	1
5	65C35388-4		. TRACK (POST SB 737-57-1203)	BFH	1
5	65-46409-23		. TRACK (PRE SB 737-57-1203)	CI	1
5	65C35381-3		. TRACK (POST SB 737-57-1203)	CI	1
5	65-46409-24		. TRACK (PRE SB 737-57-1203)	DJ	1
5	65C35381-4		. TRACK (POST SB 737-57-1203)	DJ	1
5	65C35617-5		. TRACK	K	1
5	65C35617-6		. TRACK	L	1
10	65-46409-21		. SPACER (PRE SB 57-1203)	A-J	1
10	65C35388-5		. SPACER (POST SB 57-1203)	A-J	1
10	65C35617-7		. SPACER	KL	1
15	66-23211-1		. STOP		1
20	69-37234-25		. BUSHING	A-J	1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
11-					
21	69-39659-3		. BUSHING	EF	1
22	69-39659-4		. BUSHING	GH	1
23	69-39660-3		. BUSHING	EF	1
24	69-39660-4		. BUSHING	GH	1
30	69-67217-3		. BOLT, 100 DEGREE		26
35	BACB30FD6-20		. BOLT	A-J	1
35	BACB30LE6K21X		. BOLT	KL	1
37	BACB30FD6-20		. BOLT	A-J	1
37	BACB30LE6K20X		. BOLT	KL	1
39	BACW10BP61CD		. WASHER	KL	2
42	BACW10BP61DP		. WASHER	KL	2
45	NAS1804-6		. NUT	A-J	2
45	BACN10HR6CD		. NUT	KL	2
50	BACN10HR6		. NUT		2
55	BACN10HR6		. NUT	ABE HKL	2
55	BACN10HR5		. NUT	CDIJ	2
60	BACN10HR6		. NUT	CDIJ	2
65	BACN10JC5CD		. NUT	A-J	23
65	NAS1605-5L		. NUT	KL	23
67	BACW10P219S		. WASHER	KL	23
69	BACW10CT10C		. WASHER	KL	23
70	BACB30NR5K20		. BOLT	A-J	23
70	BACB30NM5K21		. BOLT	KL	23
75	BACB30NR4HK3		. BOLT		1
80	BACB30NR4HK6		. BOLT		1
85	NS02223-064		. RETAINER, V56878	ABE-HKL	2
85	NS02223-054		. RETAINER, V56878	CDIJ	2
90	NS02223-064		. RETAINER, V56878		2
95	NS02223-064		. RETAINER, V56878	CDIJ	2
97	BACR15BA4D		. RIVET		4
98	BACR15BA4D		. RIVET		4
99	BACR15BA4D		. RIVET		4
100	BACN10HR4CD		. NUT	KL	9
105	BACW10BP4DP		. WASHER	KL	9
110	BACW10BP4CD		. WASHER	KL	9
115	BACB30LE4K20		. BOLT	KL	9
120	BACN10HR5CD		. NUT	KL	2
125	BACW10BP5DP		. WASHER	KL	2
130	BACW10BP5CD		. WASHER	KL	2
135	BACB30LE5K20		. BOLT	KL	2
140	BACN10HR6CD		. NUT	KL	1
145	BACW10BP6DP		. WASHER	KL	1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
11-					
150	BACW10BP6CD		. WASHER	KL	1
155	BACB30LE6K20		. BOLT	KL	1
			INSTALLATION PARTS		
-195	69-50772-11		FILLER	IJ	1

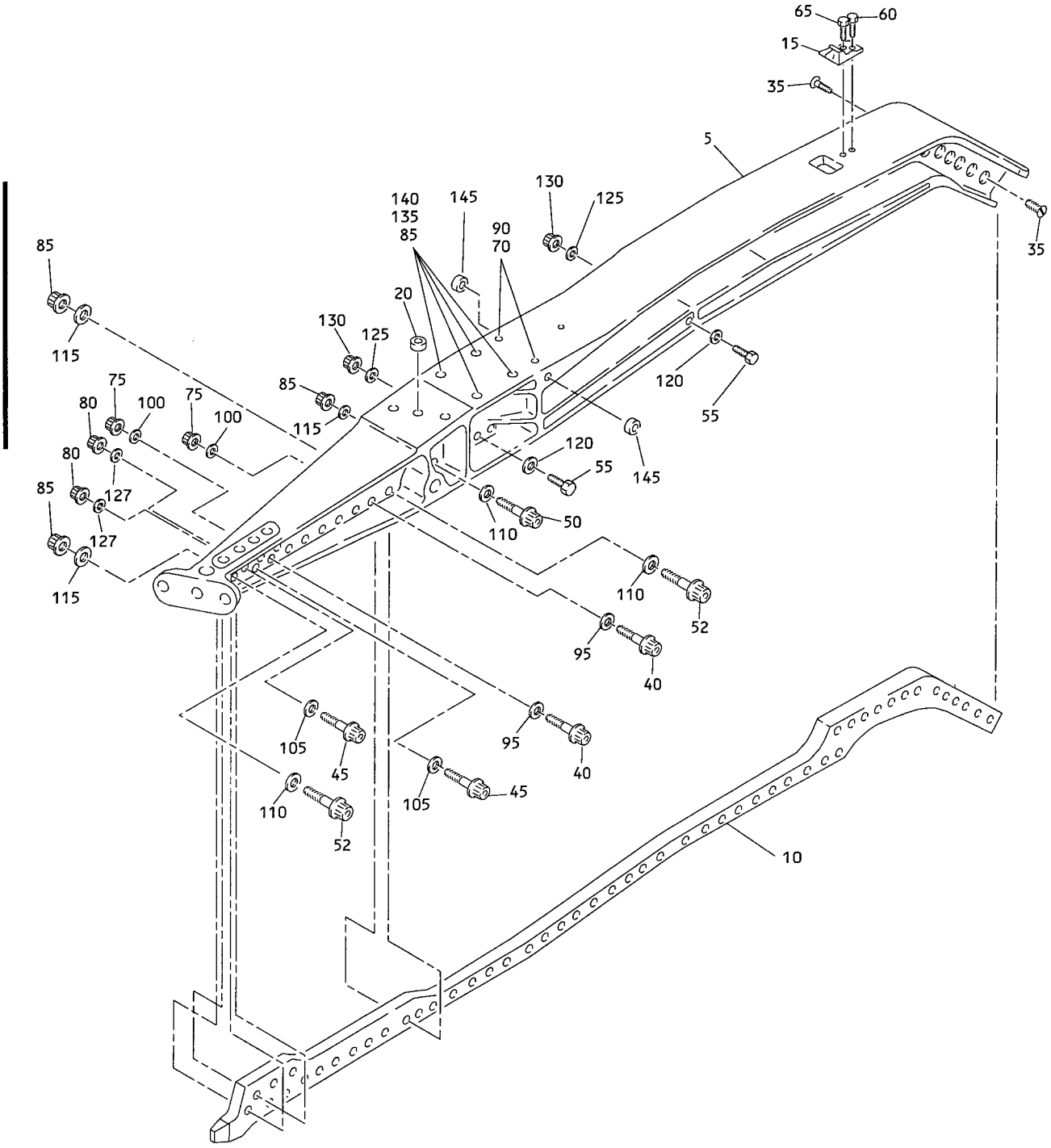
- ITEM NOT ILLUSTRATED

*[1] TRACK 65-46439-17 IS THE SAME AS TRACK 65-46439-15 OR -21 AND 65-46439-18 IS THE SAME AS TRACK 65-46439-16 OR -22, EXCEPT THAT FILLER 69-50772-11 IS INCLUDED FOR POSSIBLE USE WHEN THE PARTS ARE INSTALLED ON THE AIRPLANE.



Inboard Flap, Outboard Flap Track 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	65C35276-1		TRACK ASSY, INBD FLAP, OUTBD (POST SB 737-57-1203) (SEE FIG. 11 FOR PRE SB 737-57-1203)	A	RF
1	65C35276-2		TRACK ASSY, INBD FLAP, OUTBD (POST SB 737-57-1203) (SEE FIG. 11 FOR PRE SB 737-57-1203)	B	RF
5	65C35165-1		. TRACK	A	1
5	65C35165-2		. TRACK	B	1
10	65C35164-1		. SPACER		1
15	66-23211-1		. STOP		1
20	69-37234-25		. BUSHING		1
25	69-39659-4		. BUSHING		1
30	69-39660-4		. BUSHING		1
35	69-67217-3		. BOLT, 100 DEGREE		26
40	BACB30LE4K20		. BOLT		9
45	BACB30LE5K20		. BOLT		2
50	BACB30LE6K21		. BOLT		1
52	BACB30LE6K20		. BOLT		2
55	BACB30NM5K22		. BOLT		19
57	BACB30NM5K21		. BOLT		4
60	BACB30NR4HK3		. BOLT		1
65	BACB30NR4HK6		. BOLT		1
70	BACN10HC6		. NUT, BARREL		2
75	BACN10HR4CD		. NUT		9
80	BACN10HR5CD		. NUT		2
85	BACN10HR6CD		. NUT		5
90	BACR10V6		. RETAINER, NUT		2
95	BACW10BP4CD		. WASHER, CSK		9
100	BACW10BP4NDP		. WASHER, PLAIN		9
105	BACW10BP5CD		. WASHER, CSK		2
110	BACW10BP6CD		. WASHER, CSK		3
115	BACW10BP6NDP		. WASHER, PLAIN		3
120	BACW10CT10C		. WASHER, CSK		23
125	BACW10P219S		DELETED		
125	AN960-516L		. WASHER		23
127	BACW10BP5DP		. WASHER		2
130	NAS1805-5N		. NUT		23
135	NS02223-064		. RETAINER, V56878		2
140	MS20427M4		. RIVET		4



Inboard Flap, Outboard Flap Track 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	65C36867-3		TRACK ASSY, INBD FLAP, OUTBD (POST SB 737-57-1203) (SEE FIG. 11 FOR PRE SB 737-57-1203) (POST SB 737-57-1239)	A	RF
1	65C36867-4		TRACK ASSY, INBD FLAP, OUTBD (POST SB 737-57-1203) (SEE FIG. 11 FOR PRE SB 737-57-1203) (POST SB 737-57-1239)	B	RF
1	65C36867-1		TRACK ASSY, INBD FLAP, OUTBD (PRE SB 737-57-1239)	C	RF
1	65C36867-2		TRACK ASSY, INBD FLAP, OUTBD (PRE SB 737-57-1239)	D	RF
5	65C36868-1		. TRACK, OUTBD FLAP (65C36868-3 CAN REPLACE BUT NOT BE REPLACED BY 65C36868-1)	C	1
5	65C36868-2		. TRACK, OUTBD FLAP (65C36868-4 CAN REPLACE BUT NOT BE REPLACED BY 65C36868-2)	D	1
5	65C36868-3		. TRACK, OUTBD FLAP	A	1
5	65C36868-4		. TRACK, OUTBD FLAP	B	1
10	65C35164-1		. SPACER		1
15	66-23211-1		. STOP, TOGGLE		1
20	69-37234-25		. BUSHING		1
35	69-67217-3		. BOLT, 100 DEGREE		26
40	BACB30LE4-20		. BOLT (OPT TO BACB30LE4K20)		9
40	BACB30LE4K20		. BOLT (PREF)		9
45	BACB30LE5-20		. BOLT (OPT TO BACB30LE5K20)		2
45	BACB30LE5K20		. BOLT (PREF)		2
50	BACB30LE6K21		. BOLT		1
52	BACB30LE6K20		. BOLT		2
55	BACB30NM5K21		. BOLT		23
60	BACB30NR4HK3		. BOLT		1
65	BACB30NR4HK6		. BOLT		1
70	BACN10HC5		. NUT, BARREL (POST SB 737-57-1239)	AB	2
70	BACN10HC6		. NUT, BARREL (PRE SB 737-57-1239)	CD	2
75	BACN10HR4CD		. NUT		9
80	BACN10HR5CD		. NUT		2
85	BACN10HR6CD		. NUT		7
90	BACR10V5		. RETAINER, NUT (POST SB 737-57-1239)	AB	2
90	BACR10V6		. NUT, RETAINER (PRE SB 737-57-1239)	CD	2
95	BACW10BP4CD		. WASHER, CSK		9
100	BACW10BP4NDP		. WASHER, PLAIN		9
105	BACW10BP5CD		. WASHER, CSK		2
110	BACW10BP6CD		. WASHER, CSK		3
115	BACW10BP6NDP		. WASHER, PLAIN		3
120	BACW10CT10C		. WASHER, CSK		23

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
13-					
125	AN960-516L		. WASHER		23
127	BACW10BP5DP		. WASHER		2
130	NAS1805-5N		. NUT		23
135	NS02223-064		. RETAINER, V56878		4
140	MS20427M4		. RIVET		8
145	BACB28Y9C300		. BUSHING *[1] (POST SB 737-57-1239)	CD	1

*[1] BUSHING CUT INTO 2 PIECES, MACHINED AND PRESS OR SHRINK FIT INTO TRACK 65C36868-1, -3

VENDOR

V56878 SPS TECHNOLOGIES, INC., AEROSPACE AND INDUSTRIAL PRODUCTS DIV., 301 HIGHLAND AVE., JENKINTOWN, PENNSYLVANIA 19046