

TO: ALL HOLDERS OF INBOARD TRAILING EDGE FLAP ASSEMBLY OVERHAUL MANUAL, 57-53-22

REVISION NO. 49, DATED MAR 1/09

HIGHLIGHTS

DESCRIPTION OF CHANGE	TOPICS AFFECTED												
	D & O	D / A s s y	C l e a n i n g	I n s p / C h k	R e p a i r	A s s y	F / C	T e s t	T / S h o o t i n g	S / T o o l s	S t o r a g e	I P L	L / O v e r h a u l
Updated IPL to show the correct toggle assembly part number												X	

Mar 1/09

57-53-22
HIGHLIGHTS
Page 1 of 1

INBOARD TRAILING EDGE FLAP ASSEMBLY

57-53-22

BOEING P/N 65-46436-5 thru -8, -11 thru -24, -31, -32, -33SP thru -36SP,
-39SP thru -44SP, -59, -60
65-71940-15 thru -18, -27, -28, -35, -36
65-71969-1 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
57-1029, Rev 1 78-1005, Rev 1		RC 12052	Jun 10/71
		PRR 30440	Jun 10/71
		PRR 31030	Jun 10/71
		PRR 31030K	Jun 10/71
		PRR 31030-10	Jun 10/71
		PRR 31030-54	Jun 10/71
		PRR 31030-7	Jun 10/71
		PRR 31040	Jun 10/71
		PRR 31243	Jun 10/71
		PRR 31243-1	Jun 10/71
		PRR 31243-2	Jun 10/71
		PRR 31243-3	Jun 10/71
		PRR 31563-1	Jun 10/71
		PRR 3158, 31718, 31718-1, 31718-2	Jun 10/71
27-1030		PRR 31701	Jun 10/71
57-1060		PRR 31975	Jun 10/71
		PRR 31994	Jun 10/71
		MR 38117	Jun 10/71

Jul 1/03

57-53-22
Page T-1

BOEING
OVERHAUL MANUAL

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVES	DATE DIRECTIVE INCORPORATED INTO TEXT
57-1044		PRR 31904	Jun 10/71
		PRR 31904-1	Jun 10/71
57-1057		PRR 31243-4	Sep 10/71
57-1048		PRR 31923	Sep 10/71
		PRR 32070-11	Mar 10/72
		PRR 32109	Mar 10/72
		PRR 32109-1	Mar 10/72
		MC 3400-20K	Mar 10/72
		PRR 32121-21	Sep 10/72
		PRR 32194	Sep 10/72
		PRR 32198	Dec 25/72
		PRR 32224	Jun 25/73
		PRR 31995	Jun 25/73
57-1076			Sep 25/73
		PRR 31595	Jun 25/74
		PRR 32039	Jun 25/74
		PRR 32290-2	Jun 25/74
		PRR 32309	Jun 25/74
		PRR 32335	Jun 25/74
		PRR 32374	Jun 25/74
57-1060 Rev 2			Sep 25/74
		PRR 32426	Mar 25/75
57-1076 Rev 1			Jun 25/75
		PRR 32505	Jun 25/75
		PRR 32505-1	Jun 25/75
57-1090			Dec 25/75
		PRR 32519-3	Dec 25/75
57-1044 Rev 1			Dec 25/75
57-1097			Jan 5/77
		PRR 32765	Jan 5/79
		PRR 32781	Jan 5/79
		PRR 32680	Jan 5/79
		PRR 32430	Jan 5/79
		PRR 32848	Jan 5/80
		PRR 32950-3	Jan 5/80
		PRR 32992	Jul 5/80
		PRR 32848-1	Jan 5/81
		PRR 33084	Jan 5/82
57-1124			Jan 5/82
		PRR 33191	Jul 5/83
27-1110			Mar 5/84
		PRR 33180-30	Jun 5/84
57-1223			Dec 1/94
		PRR 35129	Dec 1/94
57-1222			Jul 1/03
57-1242			Jul 1/03
57-1297			Jul 1/07
57-1303			Nov 1/08
57-1290			Nov 1/08

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
57-53-22		404E	Mar 1/06	508B	BLANK
T-1	Jul 1/03	404F	BLANK	509	Jun 1/97
T-2	Nov 1/08	405	Jul 1/03	510	Jun 1/97
* LEP-1	Mar 1/09	406	Jul 1/03	511	Jul 1/03
* LEP-2	Mar 1/09	407	Mar 1/98	512	Jun 10/71
* LEP-3	Mar 1/09	408	Mar 1/99	513	Jun 10/72
LEP-4	BLANK	408A	Mar 1/98	514	Jun 1/97
T/C-1	Sep 25/74	408B	Mar 1/99	514A	Jun 1/97
T/C-2	BLANK	409	DELETED	514B	Dec 5/87
1	Sep 25/74	410	Mar 1/02	515	Jul 5/83
2	Jun 10/71	411	Nov 1/01	516	Mar 1/98
3	Jun 10/71	412	Jul 1/03	516A	Jan 5/82
4	BLANK	413	Nov 1/99	516B	BLANK
101	Jul 1/03	414	Jul 1/03	517	Mar 25/75
102	Jul 1/03	415	Jun 1/94	518	Jan 5/82
103	Jan 5/77	416	Jun 1/94	518A	Jul 1/03
104	Jul 1/03	417	Mar 1/96	518B	BLANK
105	Sep 25/73	418	Jun 1/94	519	Jul 1/03
106	Jun 10/71	419	Jun 1/94	520	Jun 10/71
107	Jun 10/71	420	Jun 1/94	520A	Jul 1/03
108	Jun 10/71	421	Jun 1/94	520B	BLANK
109	Jul 5/77	422	Mar 1/99	521	Dec 25/75
110	Jun 10/71	423	Jun 1/94	522	Jul 1/03
111	Jun 10/71	424	Mar 1/04	522A	Mar 1/05
112	Jun 10/71	424A	Mar 1/04	522B	BLANK
113	Dec 5/87	424B	BLANK	523	Mar 1/05
114	Dec 5/87	425	Mar 1/98	524	Sep 5/92
201	Dec 25/72	426	Nov 1/99	525	Dec 5/87
202	BLANK	427	Nov 1/99	526	Jul 1/03
301	Jun 10/71	428	Jul 1/03	527	Nov 1/05
302	Mar 1/02	429	Jul 1/03	528	Jul 1/03
401	Jul 1/03	430	Jul 1/03	601	Jun 10/71
402	Mar 1/04	431	Mar 1/04	602	Jun 5/85
402A	Mar 1/04	432	Mar 1/04	603	Jun 10/71
402B	Mar 1/04	433	Mar 1/04	604	Jun 10/71
402C	Mar 1/04	434	Mar 1/04	605	Jun 10/71
402D	Mar 1/04	501	Sep 1/95	606	Jun 10/71
402E	Jul 1/07	502	Jun 1/95	607	Sep 10/71
402F	Jul 1/07	503	Jun 1/95	608	Jun 10/71
403	Mar 1/04	504	Mar 1/05	609	Mar 5/87
404	Mar 1/04	505	Jun 1/95	610	Jun 10/71
404A	Mar 1/04	506	Jun 1/95	611	Jun 10/71
404B	Mar 1/04	507	Dec 25/75	612	BLANK
404C	Mar 1/04	508	Mar 5/85	901	Jun 10/71
404D	Mar 1/04	508A	Jun 1/97	902	BLANK

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
57-53-22 (Cont)		1128	Mar 25/75	1158	Jun 10/71
1001	Jun 10/71	1129	Jun 10/71	1159	Sep 10/72
1002	BLANK	1130	Jun 10/71	1160	Jun 10/71
1101	Jul 1/03	1130A	Jan 5/79	1161	Sep 5/93
1102	Mar 1/99	1130B	Jun 25/75	1162	Jan 5/82
1103	Nov 1/08	1131	Nov 1/08	1163	Dec 5/87
1104	Nov 1/08	1132	Nov 1/08	1164	Mar 5/84
1105	Nov 1/08	1133	Jul 1/07	1165	Jan 5/82
1106	Nov 1/08	1134	Jul 1/07	1166	Mar 5/84
1106A	Nov 1/08	1135	Jul 1/07	1166A	Jan 5/82
1106B	Nov 1/08	1136	Jul 1/07	1166B	BLANK
1107	Nov 1/08	1136A	Jan 5/79	1167	Jan 5/82
1108	Nov 1/08	1136B	Jan 5/79	1168	Jan 5/82
1108A	Nov 1/08	1136C	Jan 5/79	1169	Mar 1/99
1108B	Nov 1/08	1136D	Jan 5/79	1170	Jan 5/79
1109	Jul 1/03	1136E	Jul 1/07	1170A	Nov 1/08
1110	Mar 1/99	1136F	Jul 1/07	1170B	Jun 5/90
1111	Jun 10/71	1136G	Jul 1/07	1171	Jan 5/82
1112	Jun 10/71	1136H	Jul 1/07	1172	Jun 10/71
1112A	Jul 1/03	1136I	Jul 1/07	1173	Mar 1/95
1112B	BLANK	1136J	Jul 1/07	1174	Mar 1/95
1113	Nov 1/08	1137	Jun 10/71	1175	Mar 1/95
* 1114	Mar 1/09	1138	Jun 10/71	1176	Dec 5/92
1115	Jul 1/03	1139	Jul 1/03	1177	Jul 1/07
1116	Jul 1/03	1140	Jul 1/03	1178	BLANK
1116A	Jul 1/03	1141	Mar 1/97	1179	Jul 1/07
1116B	Jul 1/03	1142	Mar 1/97	1180	Jul 1/07
1116C	Jul 1/03	1143	Mar 1/97	1181	Jul 1/07
1116D	Jul 1/03	1144	Jul 1/03	1182	Jul 1/07
1117	Jul 1/03	1145	Jul 1/03	1183	Jul 1/07
1118	Jan 5/78	1146	Jul 1/03	1184	Jul 1/07
1119	Jan 5/79	1147	Mar 1/96	1185	Jul 1/07
1120	BLANK	1148	Jul 1/03	1186	Jul 1/07
1121	Jan 5/81	1149	Mar 1/96	1187	Jul 1/07
1122	Dec 25/75	1150	Mar 1/96	1188	Jul 1/07
1123	Nov 1/08	1151	Jul 1/03	1189	Jul 1/07
1124	Nov 1/08	1152	Jul 1/03	1190	Jul 1/07
1124A	Jul 1/03	1153	Jul 1/03	1191	Jul 1/07
1124B	Jul 1/03	1154	Jul 1/03	1192	Jul 1/07
1124C	Jul 1/03	1155	Jul 1/03	1193	Jul 1/07
1124D	Jul 1/03	1156	Jul 1/03	1194	Jul 1/07
1125	Jan 5/79	1156A	Jul 1/03	1195	Jul 1/07
1126	Sep 10/71	1156B	BLANK	1196	Jul 1/07
1127	Jan 5/79	1157	Jan 5/79	* 1197	Mar 1/09

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
57-53-22 (Cont)					
1198	Jul 1/07				
1198A	Jul 1/07				
1198B	Jul 1/07				
1198C	Jul 1/07				
1198D	BLANK				

BOEING
COMMERCIAL JET
OVERHAUL MANUAL

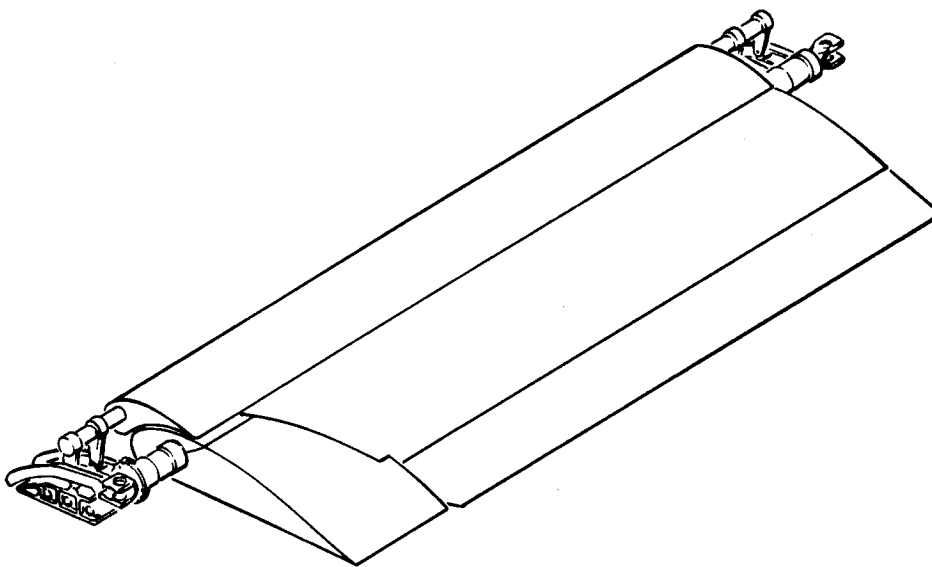
TABLE OF CONTENTS

<u>Paragraph Title</u>	<u>Page</u>
Description and Operation	1
Disassembly	101
Cleaning.	201
Inspection/Check.	301
Repair.	401
Assembly.	501
Fits and Clearances	601
Testing (not applicable)	
Trouble Shooting (not applicable)	
Storage Instructions.	901
Special Tools, Fixtures, and Equipment.	1001
Illustrated Parts List.	1101

65-16436
65-71940
65-71969

BOEING
COMMERCIAL JET
OVERHAUL MANUAL

INBOARD TRAILING EDGE FLAP ASSEMBLY



Inboard Trailing Edge Flap Assembly
Figure 1

DESCRIPTION AND OPERATION

1. Description

- A. The inboard trailing edge flap assembly (figure 1) is one of a set of two flap assemblies, which form auxiliary wing surface, and provide added lift during takeoff and landing. The flap is constructed of four segments: a fore flap, a mid flap, an aft flap, and a flipper flap. Actuating mechanisms are built into each of these components to separate them during extension. When the flap is extended, it moves along underwing steel tracks, on rollers in two carriage assemblies which are part of the mid flap.

BOEING
COMMERCIAL JET
OVERHAUL MANUAL

65-46436
65-71940
65-71969

- B. The fore flap consists of sheet metal covered nose ribs, a spar, and a curved, machine tapered honeycomb trailing edge. Both upper and lower surfaces of the flap are covered with clad aluminum skin panels. Three supports extend through the lower surface to connect the fore flap to tracks carried in the mid flap. A toggle assembly is installed in each end of the fore flap. These toggles move along cams mounted on the mid flap carriages.
- C. The mid flap is of conventional sheet metal construction, consisting of a front spar, rear spar, trailing edge upper and lower chord angles, nose ribs, interspar ribs, and trailing edge assembly. An internal mechanism is installed in the flap to actuate the aft flap. Also contained in the mid flap are three fore flap tracks. These tracks travel on roller bearings installed between three interspar rib assemblies. Four track ribs are installed in the trailing edge section to support the aft flap. The entire mid flap is covered with clad aluminum skin. The panels on the lower surface are removable, and provide access to the flap actuating mechanisms. Two carriage assemblies are installed on torque tubes, one at each end of the mid flap. These carriages carry forged cams on which the fore flap toggle assemblies ride. The carriages travel along the underwing flap tracks on roller bearings.
- D. The aft flap is a monospar structure, and consists of the spar, sheet metal covered nose ribs, and a machine tapered honeycomb trailing edge assembly. Both upper and lower surfaces are covered with clad aluminum skin. Four flap carriages are installed on the leading edge of the flap. Each carriage consists of a support fitting, two carriage sideplates, and track rollers. The carriages roll along cam tracks in the trailing edge of the mid flap. The forward track rollers are supported by eccentric bushings which provide a means of adjusting the aft flap contour to match the contour of the mid flap. Rotation of the eccentrics raises or lowers the forward end of the carriages, thus rotating the aft flap around the aft carriage rollers. Two pushrods connect the aft flap to the mid flap actuating mechanism.
- E. The flipper flap is a machine-tapered honeycomb assembly, with a bearing support housing bolted to the front spar. The bearing support housing is a removable two-piece assembly that is bolted together to secure the flipper flap to the mid flap outboard carriage torque tube assembly. The flipper flap is primarily an extension of the mid and aft flaps. It is located adjacent to the tailpipe of the engine, and its movement, relative to the rest of the flap, is adjusted to prevent contact with the engine tailpipe.

65-46436
65-71940
65-71969

BOEING
COMMERCIAL JET
OVERHAUL MANUAL

2. Operation

- A. The trailing edge flap is operated hydraulically through a power transmission system attached to a torque tube at each end of the mid flap. As the flap is extended, cables attached to a fixed boom located at the inboard end of the flap actuate the mechanism in the mid flap. This mechanism causes the mid and aft flaps to separate at a measured rate.

DISASSEMBLY

1. Mount inboard trailing edge flap assembly on a suitable workstand.
2. Remove installation items from inboard trailing edge flap assembly.

NOTE: Parts being removed in this paragraph are part of the installation and may, or may not, be installed on the assembly when it is received for overhaul.

A. Remove outboard gimbal assembly. (See Fig. 1101.)

- (1) Remove nuts (5), washers (6), bolts (7).
- (2) Mark and record position of gimbal assembly (9) in relation to indexing plate assembly (14).
- (3) Slide gimbal assembly (9) out of flap. Remove shim (8).

NOTE: Measure and record thickness of shim (8) for fabrication of new shim if replacement is necessary.

(4) Disassemble gimbal shaft assembly as follows:

- (a) Remove spanner nut (19) and keywasher (18).
- (b) Pull bearing (20) off end of gimbal shaft (11).
- (c) Remove sleeve (21) and spacer (20J) if installed.
- (d) Open keywasher (26) and loosen spanner nut (27) to relieve tension on pin or bolt (24).
- (e) Remove either pin (24), or nut (22), washer (23), and bolt (24).
- (f) Remove spanner nut (27), keywasher (26), and threaded bushing (25) from gimbal shaft.
- (g) Remove bushing retainer (28) and spacer (29). Slide gimbal shaft (11) out of indexing plate assembly (14).

NOTE : Do not disassemble indexing plate assembly (14) unless replacement of bearing is necessary.

B. Remove inboard gimbal assembly. (See Fig. 1101.)

- (1) Remove capscrews (30) and washers (31). Slide gimbal assembly (32) out of inboard torque tube. Remove shims (54).

NOTE: Measure and record number and thickness of shim/shims for fabrication of new shims if replacement is necessary.

- (2) Disassemble gimbal assembly as follows:

- (a) Remove keywasher (38) and spanner nut (39).
- (b) Pull bearing (40) off end of gimbal shaft (34).
- (c) Remove sleeve (41) and spacer (40J) if installed.
- (d) Open keywasher (45) and loosen spanner nut (46) to relieve tension on bolt or pin (44). Remove either pin (44), or nut (42), washer (43), and bolt (44).
- (e) Remove spanner nut (46), keywasher (45), threaded bushing (47), retainer (48), and spacer (49).
- (f) Remove retainer (50), bearing (51), retainer (52), and spacer (53), if applicable.

C. Remove flipper flap assembly. (See Fig. 1103.)

- (1) Remove nut (2), washer (3) and bolt (4).
- (2) Remove upper housing (5).

CAUTION: EXERCISE CARE WHEN REMOVING UPPER HOUSING (5) TO PREVENT WIPER SEALS (7) AND BUSHINGS (8) FROM FALLING OUT AND GETTING DAMAGED.

- (3) Remove flipper flap assembly and reassemble bearing support housing (5, 6) with wipers (8) and bearings (9) in housing.
- (4) Refer to Subject 57-53-23 for disassembly of flipper flap assembly.

3. Remove and disassemble fore flap assembly. (See Fig. 1102.)**A. Remove fore flap assembly and disassemble.**

- (1) Remove nuts (1, 2), washers (3, 4), and bolts (5, 6).
- (2) Remove fore flap from flap assembly and place on a suitable workstand or bench.

NOTE: Tracks (7, 8) remain inside mid flap, and will be removed when mid flap is disassembled.

- (3) Remove shims (9 and 10). Record thickness and location of each shim for reassembly, and fabrication of new shims if necessary.
- (4) Remove cotter pins (11), nuts (12), washers (13 and 14), bearings (15), bushings (16 and 17), and toggle assembly (18).
- (5) Disassemble toggle assembly (18) by removing spring pin (19), bolt assembly (20), bearing (23), cotter pin (24), nut (25), washer (26), and bearing (27).

NOTE: Do not remove lubrication fitting (22) from bolt (21), or bushings (29) from toggle (30) unless repair or replacement is necessary.

- (6) Remove cotter pin (31), nut (32), washers (33 and 34), bolt (35), retainer (36), and guide (37).
- (7) Cut lockwire and remove bolts (39, 40, and 41), washers (42, 43, and 44), retainers (45, 46, and 47), nuts (48, 49 and 50), and brackets (51 and 52). Identify brackets (51, 52) prior to removal to ensure correct assembly.
- (8) Remove shims (53 and 54). Record thickness and location of each shim for reassembly, and fabrication of new shims if necessary.
- (9) Remove support assemblies (59 and 62) by removing cotter pins (55), nuts (56), washers (57), and bolts (58).

NOTE: Do not disassemble support assemblies (59 and 62), unless repair or replacement is required.

- (10) Remove torque tube assembly (70) from each end of fore flap by removing bolts (65), cotter pins (66), nuts (67), washers (68), and bolts (69).

NOTE: Do not remove rivets (71), nutplate (72), and filler (73) from tube (74) unless nutplate (72) needs to be replaced.

- (11) Remove screws (75), retainers (76), and seals (77 and 78).
- (12) Remove nuts (80), washers (81), bolts (82), and end block assembly (83) from fore flap.

NOTE: Do not disassemble end block assembly (83).

- (13) Remove nuts (87), washers (88), bolts (89), and end block assembly (90) from fore flap.

NOTE: Do not disassemble end block assembly (90).

- (14) Repair fore flap structure (94) per 737 Structural Repair Manual, 57-50-4.

4. Remove and disassemble aft flap. (See Fig. 1104.)

A. Remove aft flap from flap assembly.

- (1) Extend aft flap to limit.
- (2) Remove trailing edge assembly (3, 3A, Fig. 1105) as applicable, from mid flap by removing screws (12, 12B, 12D thru 12F, as applicable) washers (12A, 12C), bolts (14, 14A, as applicable), nut (14C), radius blocks (4, 4A, 13, as applicable), and shims (5 through 11).

NOTE: Do not remove bolts (16), nuts (17), and plate (19) unless bumper (18) needs to be replaced.

- (3) Disconnect aft flap actuating pushrods in mid flap from aft flap by removing cotter pins (58, Fig. 1104), nuts (59), washers (60), and bolts (61).
- (4) Remove bearings (9) from aft flap bearing supports by removing cotter pins (3), nuts (4), washers (5), and bolt assemblies (6).
- (5) Remove aft flap and place on a suitable workstand or bench.

B. Disassemble aft flap.

- (1) Remove nose skin assemblies (1) by removing bolts (2).
- (2) Remove bolts (10, 11). Remove roller support assemblies (12, 20) from flap with ribs (29, 30) attached. Remove shims (28).

NOTE: Do not detach ribs from support fittings. Do not disassemble components of support assemblies (12, 20) unless repair or replacement is required.

- (3) Remove cotter pins (34), nuts (35), and cam followers (36) from support assemblies (12, 20).
- (4) Remove cotter pins (37), nuts (38), washers (39), eccentric bushings (40), bolts (41), rollers (42), and bushings (43) from support assemblies (12, 20).

NOTE: Do not remove rivets (45) unless eccentric lock (44) needs to be replaced.

- (5) Remove slave attach fitting assemblies (46) by removing bolts (49) and washers (50).
- (6) Remove screws (57), retainers (54, 55, 56), and seals (51, 52, 53) from structure assembly.

BOEING
COMMERCIAL JET
OVERHAUL MANUAL

5. Disassemble mid flap (Fig. 1105).

NOTE: Items (3 thru 19) were removed when aft flap was removed, per par. 4 above.

A. Remove aerodynamic seals and lower skins.

- (1) Remove bolt (20), filler (21), shim (22), and clip-on nut (23).
Remove bolts (24) and retainer (25).

NOTE: Do not remove rivets (26) unless nutplates (27) need to be replaced.

- (2) Remove bolts (28) and retainers (29 and 32).

NOTE: Do not remove rivets (30, 33, and 35) unless nutplates (31, 34, and 36) need to be replaced.

- (3) Remove seal (37).

- (4) Remove bolts (38), retainer (39), plates (42), and shim (63).

NOTE: Do not remove rivets (40) unless nutplates (41) need to be replaced.

- (5) Remove nuts (43), washers (44), bolts (45, 45A and 47), shim (46), nutplate assembly (44A), fitting (3C), serrated plate (52), and angle assembly (48), as applicable.

NOTE: Do not remove rivets (51) unless serrated plate (50) needs to be replaced; or rivets (44D and 53) unless nutplates (44C and 54) need to be replaced.

- (6) Remove nut (55), washer (56), bolt (57), and plate (62).

- (7) Remove bolt (58), washer (59), nut (60), if applicable, and plate (62).

NOTE: Do not remove rivets (61) from applicable assemblies unless nutplate (60) needs to be replaced.

- (8) Remove seal plate assembly (64).

NOTE: Do not remove items (65 thru 74 or 120 thru 124) unless repair or replacement is required.

BOEING
COMMERCIAL JET
OVERHAUL MANUAL

65-46436
65-71940
65-71969

- (9) Remove bolts (75), seal (76), and retainer (77).

NOTE: Do not remove rivets (78) unless a nutplate (79) needs to be replaced.

- (10) Remove bolts (80), retainer (81), and seal (82).

NOTE: Do not remove rivets (83) unless a nutplate (84) needs to be replaced.

- (11) Remove bolt (85), retainer (86), seal (87), and fillers (88 and 89).

NOTE: Do not remove rivets (90) unless a nutplate (91) needs to be replaced.

- (12) Remove seal (92), bolts (93), and retainers (94 through 98).

- (13) Remove bolts (100 and 101) and lower aft inboard skin assembly (99).

- (14) Remove bolts (103 and 104) and lower forward inboard skin assembly (102).

- (15) Remove bolts (107 and 108) and lower forward center skin assembly (105).

- (16) Remove bolts (110, 111, and 112) and lower outboard skin assembly (109).

- (17) Remove nuts (115), spacers (116), washers (117), and bolts (118).

- (18) Remove tracks by sliding forward and out of support and bracket assemblies (26, 50, 53, 60, and 63, figure 1109).

B. Remove outboard carriage assemblies. (See figure 1106.)

- (1) Remove cotter pins (14), nuts (15), washers (16), and bolts (17, 18, and 19). Remove cams (20 and 21).

- (2) Cut lockwire and remove bolts (24), nuts (23), and retainers (22). Remove crossbeam (25).

- (3) Cut lockwire and remove bolts (26) and washers (27). Remove roller assemblies (28) and shims (35).

NOTE: Measure and record location and thickness of shims (35) for fabrication of new shims during assembly if replacement is necessary.

65-46436
65-71940
65-71969

BOEING
COMMERCIAL JET
OVERHAUL MANUAL

- (4) Remove bracket (29), bearing (30), spring pin (31), and bolt assembly (32) from roller assemblies.

NOTE: Do not remove lubrication fitting (34) from bolt assembly (32) unless it needs to be replaced.

- (5) Remove cotter pins (36), nuts (37), and bolt assemblies (38).
Remove bearings (41) and washers (42 and 43).

NOTE: Do not remove lubrication fittings (40) from bolt assemblies (38) unless they need to be replaced.

- (6) Cut lockwire and remove bolts (44) and washers (45). Remove roller assemblies (46 and 58).
- (7) Disassemble items (47 through 57) from roller assembly (46).
- (8) Disassemble items (59 through 69) from roller assembly (58).
- (9) Detach plate (73) from carriages by removing nuts (70), washers (71), and bolts (72).
- (10) Remove bumper plate (75) by removing bolts (76).
- (11) Remove nuts (79), washers (80), and bolts (81, 82, and 83). Pull gimbal bearing support (84) out of torque tube.
- (12) Remove nuts (85), washers (86 and 87), bolts (88, 89, and 90), and washers (91 and 92).
- (13) Remove nuts (93), washers (94 and 95), and bolts (96, 97, and 98).
- (14) Slide support assembly (99) out of torque tube. Remove bumper support (74).

NOTE: Do not remove rivets (77) unless nutplates (78) need to be replaced.

- (15) Remove nuts (102), washers (103 and 104), and bolts (105 and 106).
- (16) Remove carriage assemblies (2 and 8).

NOTE: Do not remove items (3 through 7) from carriage assembly (2); or items (9 through 13) from carriage assembly (8) unless repair or replacement is required.

- (17) Remove cotter pin (107), nut (108), washer (109), and bolt (110).

BOEING
COMMERCIAL JET
OVERHAUL MANUAL

65-46436
65-71940
65-71969

- (18) Slide fail-safe tube assembly (111) out of torque tube.
 - (19) Remove collars (112) and bolts (113).
 - (20) Slide fail-safe support (114) out of torque tube.
 - (21) Remove nuts (117), washers (118), and bolts (119). Remove washers (115 and 116).
 - (22) Remove torque tube (120) from flap.
 - (23) Remove supports (125) by removing collars (123) and bolts (124).
- C. Remove inboard carriage assemblies. (See figure 1107.)
- (1) Remove nuts (1, figure 1108), washers (2), bolts (3), cotter pin (4), nut (5), washer (6), and bolt (7). Remove support fitting assembly (8) and serrated plates (11 and 12).

NOTE: Do not remove bushings (10) from fitting (9) unless replacement is required.
 - (2) Remove cotter pins (13), nuts (14), washers (15), bolts (16 and 17), and washer (18) to detach pulley support (19) and shim (20) from carriage.
 - (3) Remove cotter pins (13, figure 1107), nuts (14), washers (15), and bolts (16, 17, and 18). Remove cams (19 and 20).
 - (4) Remove bolts (21 and 22) and washers (23). Remove roller assemblies (24) and shims (31).

NOTE: Bolt (21) also detaches pulley support (19, figure 1108) and shim (20). Measure and record location and thickness of shims for fabrication of new shims if replacement is necessary.
 - (5) Disassemble roller assemblies (24, figure 1107) by removing bearing (26), spring pin (27), and bolt assembly (28) from bracket (25).

NOTE: Do not remove lubrication fitting (30) from bolt assembly (28) unless it needs to be replaced.
 - (6) Remove cotter pins (32), nuts (33), and bolt assemblies (34). Remove bearings (37) and washers (38 and 39).

NOTE: Do not remove lubrication fittings (36) from bolt assemblies (34) unless they need to be replaced.

65-46436
65-71940
65-71969

BOEING
COMMERCIAL JET
OVERHAUL MANUAL

(7) Remove bolts (40) and washers (41). Remove roller assemblies (42 and 54).

(8) Disassemble roller assembly (42) by removing items (43 thru 53).

NOTE: Do not remove lubrication fitting (51) from bolt assembly (49) unless it needs to be replaced.

(9) Disassemble roller assembly (54) by removing items (55 thru 65).

NOTE: Do not remove lubrication fitting (63) from bolt assembly (61) unless it needs to be replaced.

(10) Deleted

(11) Remove nuts (71), washers (72), and bolts (73, 74, and 75).

(12) Pull gimbal shaft bearing support assembly (76) out of torque tube.

(13) Remove nuts (79), washers (80), and bolts (81, 82, and 83). Remove washers (84 and 85).

(14) Remove nuts (86), washers (87), and bolts (88 and 89).

(15) Slide gimbal shaft bearing support assembly (90) out of torque tube.

(16) Remove nuts (93), washers (94), and bolts (95 and 96).

(17) Remove cotter pin (97), nut (98), washer (99), and bolt (100).

(18) Remove carriage assemblies (2 and 8). Remove fail-safe fitting (101) and plate (102).

(19) Remove cotter pin (103), nut (104), washer (105), and bolt (106).

NOTE: Deleted.

(20) Pull fail-safe tube assembly (107) out of flap.

(21) Remove nuts (108), washers (109), and bolts (110).

(22) Slide fail-safe tube support (111) out of torque tube.

BOEING
COMMERCIAL JET
OVERHAUL MANUAL

65-46436
65-71940
65-71969

- (23) Remove nuts (112), washers (113), bolts (114), and washers (115 and 116).
- (24) Remove nuts (117), washers (118), bolts (119), and washers (120 and 121).
- (25) Pull torque tube (122) out of flap.
- (26) Remove nuts (123), washers (124), and bolts (125). Remove tube support (126).

D. Remove and disassemble aft flap drive mechanism. (See figure 1108.)

NOTE: Fitting assembly (8) and pulley support (19) and attaching hardware were detached when inboard carriages were removed per paragraph 5.C. above.

- (1) Remove cable guard (21) from fitting assembly (8) by removing nut (22) and bolt (23).
- (2) Remove pulleys (24 and 25) by removing cotter pin (26), nut (27), washer (28), and bolt (29).
- (3) Remove pulley (33) by removing cotter pin (30), nut (31), washer (32), and bolt (34).
- (4) Remove nut (35), washer (36), spacer (37), and bolt (38).
- (5) Remove nuts (39 and 43), washers (40 and 44), spacers (41 and 45), bolt (42), and screw (46).
- (6) Remove cotter pins (48 and 50) and turn cam follower (49) out of housing in pulley support (19). Remove pulley (47).
- (7) Detach end fitting (53) and fitting assembly (54) from boom (52) by removing nuts (58), washers (59, 60, and 61), and bolts (62 and 63). Remove nut (64) and washer (65) from end fitting (53).

NOTE: Do not remove bushings (56 and 57) from fitting (55) unless replacement is required.

- (8) Remove nut (67) and washer (68). Remove rod end bearing (66).
- (9) Detach fitting (70) and screw (69) from boom (52) by removing nuts (71), washers (72), and bolts (73). Remove nut (74) and washer (75) from screw (69).

65-46436
65-71940
65-71969

BOEING
COMMERCIAL JET
OVERHAUL MANUAL

- (10) Remove pulley bracket assembly (77) by removing nuts (86), washers (87), and bolts (88). Remove items (79 through 85) from bracket (78).

NOTE: Do not remove bushings (82) from bracket (78) unless replacement is required.

- (11) Remove cotter pins (89), washers (90), and pins (91).

CAUTION: RELIEVE TENSION ON CABLE ASSEMBLIES (112 AND 113) BEFORE PERFORMING FOLLOWING STEP.

- (12) Remove bolts (92 and 93) and washers (94). Remove cable drum assembly (136), spindle assembly (139), bellcrank assembly (158), and bracket assembly (148) from flap as a unit.
- (13) Remove nuts (95), washers (96), spacers (97), and bolts (98).
- (14) Remove guard bracket (101) by removing bolts (99) and washers (100).
- (15) Remove nuts (102), washers (103), spacers (104), and bolts (105).
- (16) Detach cable assemblies (109 and 110) from drum (137) by removing nut (106), washer (107), and screw (108).
- (17) Remove two cotter pins (111) from bellcrank assembly (158) and detach cable assemblies (112) from bellcrank.
- (18) Remove pushrod assembly (116) by removing cotter pin (122), nut (123), washer (124), and bolt (125).
- (19) Partially disassemble pushrod assembly (116) by loosening nut (120), removing key (121), and turning bearing (119) out of tube (117).

NOTE: Do not remove bearing (118) from tube unless repair or replacement is required.

- (20) Remove drum assembly (136) and spindle assembly (139) from bracket assembly (148) by removing cotter pin (127), nut (128), washers (129, 130, and 131), and bolt (132).
- (21) Separate spindle assembly (139) from drum assembly (136) by removing nuts (133), washers (130 and 134), and bolts (135).

NOTE: Do not remove bushings (138) from drum (137), or bushing (141) from spindle (140) unless repair or replacement is required.

BOEING
COMMERCIAL JET
OVERHAUL MANUAL

65-46436
65-71940
65-71969

- (22) Remove cotter pin (142), nut (143), washers (144, 145, and 146), and bolt (147).

NOTE: Do not remove bearings (151), bushings (152), rivets (153), or nutplates (154) from bracket (149) unless repair or replacement is required.

- (23) Remove bellcrank assembly (158) and cam arm assembly (162) as a unit.

- (24) Remove bolt (155), washer (156), and stop (157).

- (25) Cut lockwire and remove nut (170), lock (171), spacer (172), washer (173), if applicable, clutch disks (174 and 175), shaft (176), and washers (177, 178, and 179). Separate bellcrank assembly (158) and cam arm assembly (162).

NOTE: Do not remove bushings (160 and 161) from bellcrank (159) unless repair or replacement is required.

- (26) Remove cotter pin (165), nut (166), washer (167), and bearing (169) from arm (163).

NOTE: Do not remove bushings (164 and 168) unless repair or replacement is required.

- (27) Remove bolts (180 and 181), washers (182), and bolts (183) to detach bracket assembly (184) from flap.

NOTE: Do not remove bushings (186), rivets (187), or nutplates (188) from bracket (185) unless repair or replacement is required.

- (28) Remove cotter pin (189), nut (190), washer (191), and bolt (192); detach bellcrank assembly (194) from bracket assembly (184).

- (29) Remove two cotter pins (193) from bellcrank (195) to detach cable assemblies (113).

- (30) Detach clips (115) and turnbuckles (114) from cable assemblies (112 and 113).

- (31) Remove pushrod assembly (199) by removing cotter pin (205), nut (206), washer (207), and bolt (208).

NOTE: Do not remove sleeve (196), bearing (198), or bushings (197) from bellcrank (195) unless repair or replacement is required.

65-46436
65-71940
65-71969

BOEING
COMMERCIAL JET
OVERHAUL MANUAL

- (32) Loosen nut (203) and remove key (204), bearing (202), and nut (203) from pushrod assembly (199).

NOTE: Do not remove bearing (201) from tube (200) unless repair or replacement is required.

E. Remove tracks and track guides (Ref Fig. 1109).

CAUTION: DO NOT REMOVE AFTFLAP CARRIAGE TRACKS (5) FROM MIDFLAP ASSEMBLY UNLESS REPAIR OR REPLACEMENT IS NECESSARY. TRACKS ARE PRESET AND SHIMMED AT THE FACTORY, REMOVAL MAY DESTROY FAIR RELATIONSHIP OF AFTFLAP TO MIDFLAP.

- (1) Record the position of the track in respect to the midflap assembly using locally fabricated index tooling.
- (2) Remove aft flap carriage tracks (5) by removing bolts (6 and 10), washers (7), retainers (8), and cylindrical nuts (9).
- (3) Record thickness and location of shims (11) for reference during assembly or later fabrication if replacement is required.
- (4) Remove nuts (1), spacers (2), washers (3), and bolts (4) from each track. Slide tracks out of cutouts in leading edge of flap.
- (5) Remove roller assembly (12) by removing nut (19), washer (20), and bolt (21).
- (6) Disassemble cotter pin (13), nut (14), washer (15), bearing (16), boss (17), and plate (18).
- (7) Remove bearing (25) by removing cotter pin (22), nut (23), and washer (24).
- (8) Remove support assembly (26) by removing cotter pins (27), nuts (28), washers (29), and bolts (30).
- (9) Remove support assembly (31) by removing nuts (32), washers (33), and bolts (34 and 35).
- (10) Remove bearing (36) by removing cotter pin (37), nut (38), washers (39 and 40), and bolt assembly (41).

NOTE: Do not disassemble bolt assembly (41).

- (11) Remove rub strips (42 and 43) by scraping off with a sharp-edged wooden or plastic tool.

NOTE: Do not remove rub strip (44) unless it needs to be replaced.

- (12) Remove bearings (46) from between outboard foreflap track ribs by removing cotter pins (47), nuts (48), and washers (49).

BOEING
COMMERCIAL JET
OVERHAUL MANUAL

65-46436
65-71940
65-71969

- (13) Remove bracket assemblies (50 and 53) by removing bolts (56 and 57), washers (58), and screws (59).
- (14) Scrape off rub strips (52 and 55) with a sharp-edged wooden or plastic tool.
- (15) Remove bearings (46) from between inboard foreflap track ribs by removing cotter pins (47), nuts (48), and washers (49).
- (16) Remove bracket assemblies (60 and 63) and deflector (70) by removing bolts (66 and 67), washers (68), and screws (69).
- (17) Scrape off rub strips (62 and 65) with a sharp-edged wooden or plastic tool.

65-46436
65-71940
65-71969

BOEING
COMMERCIAL JET
OVERHAUL MANUAL

CLEANING

1. General

- A. Wash and rinse all metal parts except bearings in dry cleaning solvent, Specification P-D-680, or equivalent.
- B. Remove stubborn accumulations of dirt with a stiff-bristle brush. Do not use a metallic brush.
- C. Thoroughly clean interior of midflap structure to enhance action of corrosion preventive compound, IPS-3, to be applied later.
- D. Dry parts with clean, lint-free cloth, or dry, compressed air.
- E. For further information, refer to 20-30-03, General Cleaning Procedures.

2. Bearings

- A. Clean all bearings per 20-30-01, Cleaning and Relubricating Antifriction Bearings.

INSPECTION/CHECK

1. Visual Check

- A. Examine all metal parts for pits, scratches, cracks, corrosion, and damage using a strong light and a minimum of 10-power magnification.
- B. Examine entire basic assembly for loose fasteners, corrosion, damage, and general condition of paint and finish.
- C. Examine all bearings for excessive radial or axial play.
- D. Examine all bearing, bushing, and bolt holes for excessive or eccentric wear.
- E. Examine all pulleys for guttering in cable grooves.
- F. Examine all rollers for excessive wear, pitting, or fretting.
- G. Examine all cable assemblies for frayed cables and corroded or damaged terminals.

2. Honeycomb and Bonded Parts Check

- A. Tap surface of honeycomb or bonded panel lightly with a coin or plastic rod. Go over entire surface. Normal structure will produce a solid metallic sound; delaminated areas will produce a dull hollow sound; and areas containing moisture will produce a dull solid sound.
- B. Examine areas suspected of containing moisture radiographically to determine extent of damage.
- C. Determine contour defects by laying a straightedge across the surface of the panel. Raised areas indicate delamination. Warp of panels also can be determined with the straightedge.
- D. Examine edges of panel carefully for cuts and abrasions. Delamination starts very easily from damage to an edge member of a honeycomb panel.

3. Special Check

CAUTION: TO PREVENT DAMAGE TO ANTIFRICTION BEARINGS, IT IS NECESSARY TO PROTECT THEM FROM INSPECTION FLUID WHEN PERFORMING MAGNETIC PARTICLE OR DYE PENETRANT EXAMINATION OF COMPONENTS CONTAINING BEARINGS. AN ADEQUATE EXAMINATION CAN BE MADE BY CAREFULLY MASKING OFF THE BEARING AND APPLYING THE FLUID BY BRUSH INSTEAD OF BY DIPPING.

NOTE: It is not necessary to press out a bearing to check inside of component bore unless crack indications are detected during visual examination.

- A. Do a visual check of all parts for any damage in accordance with standard industry practices. If any damage is found or if you think there are cracks or damage, perform examinations of the damaged part according to paragraphs B, C and D below.
- B. If visual check shows evidence of defects, then do a magnetic particle examination per SOPM 20-20-01 on collars (12, 35, Fig. 1101), spacer (17), sleeves (21, 41), pins (24, 44), bushings (25, 47), retainers (28, 48, 50, 52); bolt (21, Fig. 1102), toggle (30), brackets (51, 52), supports (60, 63), torque tube (74); bolts (7, Fig. 1104); fitting (3C, Fig. 1105), tracks (113, 114); carriages (4, 10, Fig. 1106), cams (20, 21), crossbeam (25), bracket (29), bolt (39), bushing (60), bolt (66), plate (73) torque tube (121); carriages (3, 9, Fig. 1107), cams (19, 20), bracket (25), bolts (29, 35, 50, 62), bushings (44, 56), plate (102); pulley support (19, Fig. 1108), end fitting (53), clutch disk (175), shaft (176), washer (177); and support assembly (26, Fig. 1109).
- C. If visual check shows evidence of defects, then do a magnetic particle examination -- Shafts (11, 34, Fig. 1101). Sleeves (13, 37) must be removed to perform this check, refer to REPAIR section.
- D. If visual check shows evidence of defects, then do a penetrant examination per SOPM 20-20-02 on indexing plate (15, Fig. 1101); supports (13, 21, Fig. 1104), bracket (47); hook (123, 152, Fig. 1105); supports (84, 100, Fig. 1106), fail-safe tube assembly (111), fail-safe support (114), sleeve (122); supports (77, 91, Fig. 1107), fail-safe fitting (101), fail-safe tube assembly (107), fail-safe support (111), torque tube (122), tube support (126); fittings (9, 55, 70, Fig. 1108), boom (52), brackets (78, 149, 185), tubes (117, 200), drum (137), bushings (152), bellcranks (159, 195), cam arm (163), clutch disk (174); and boss (17, Fig. 1109), plate (18, 161), support assembly (31), brackets (51, 54, 61, 64).
- E. Check the spring (178, Fig. 1108).
 - (1) The spring (69-42385-1 only) shall deflect 0.035 inch under a load of 2570 to 3170 pounds.
 - (2) The spring (69-42385-2 only) shall deflect 0.015 inch under a load of 1070 to 1470 pounds.

REPAIR

1. Repair

A. For repairs to the structure of the flap, refer to the Boeing 737-200 Structural Repair Manual, such as these sections: 51-40-9, 57-50-1, 57-50-2, and 57-50-4.

B. Refer to these standard practices, as applicable.

- (1) SOPM 20-10-01 for repair and refinish of high strength steel parts
- (2) SOPM 20-10-03 for shot peening
- (3) SOPM 20-10-05 for thermal spray coatings
- (4) SOPM 20-20-01 for magnetic particle inspections
- (5) SOPM 20-20-02 for penetrant examinations

C. Tracks (Fig. 403, 404, 404A)

(1) Method 1 -- Buildup with thermal spray coating.

(a) Machine the surface as necessary, within repair limits, to remove defects.

(b) Break all sharp edges.

(c) Shot peen machined surface with shot size 0.016-0.033, 0.006-0.011 A2 intensity for 65-47894-1; .010A2 intensity for 65-47901-1; 0.015 A2 intensity for 65-50746-1.

(d) Apply BMS 10-67, Type 1 thermal spray coating.

(e) Make sure the surface is as smooth or smoother than the adjacent bare metal.

(f) Refinish as indicated.

(2) Method 2 -- Small defect removal

(a) Machine the repair surface as necessary, within repair limits.

(b) Break all sharp edges.

(c) Shot peen the machined repaired surface with shot size 0.016-0.033, of 0.006-0.011 A2 intensity for 65-47894-1; .010A2 intensity for 65-47901-1; 0.015 A2 intensity for 65-50746-1.

(d) Make sure the surface is as smooth or smoother than the adjacent base metal.

(e) Refinish as indicated.

D. Drum assembly (136, Fig. 1108) Scroll Cam (Fig. 406, 407)

- (1) For repair with insert -1 (Fig. 406), machine the worn area of scroll cam surface of drum (137) with the 0.375 inch and 0.750 inch diameter cutters. Let the 0.375 inch cutter run out at each end to blend into the profile cut of the 0.750 inch cutter.
- (2) For repair with insert -2 (Fig. 407), machine the worn area of scroll cam surface of drum (137) with the 0.375 inch cutter, as shown.
- (3) Make a -1 or -2 insert as necessary per Fig. 408.
- (4) Put the insert in the repaired area of the drum.
- (5) Drill and ream 0.1895-0.1905 inch diameter holes through the insert and the drum. Put 3 holes in insert -1. Put 2 holes in insert -2.
- (6) Remove the insert. Remove burrs from all holes.
- (7) Chemical treat and apply BMS 10-11, Type 1 primer (F-18.06) in holes and on machined surfaces of the drum.
- (8) Install the insert on the repaired area of drum with wet sealant BMS 5-95. Let the sealant come out at the corners.
- (9) Attach the insert to the drum with the Hi-lok fasteners BACB30FN6A3 and collars BACC30M6 with wet BMS 10-11, Type 1 primer.
- (10) Machine the scroll cam and the insert to the design contour and width per Fig. 405 and SOPM 20-10-05.
- (11) Penetrant examine per SOPM 20-20-02.
- (12) Chemical treat and apply BMS 10-11, Type 1 primer (F-18.06) on the drum on the scroll cam surfaces.

E. Torque tube (74, Fig. 1102)

- (1) Repair the outside diameter as follows:
 - (a) Machine as required, within repair limits, to remove defects as shown in Fig. 409.
 - (b) Shot peen as shown in Fig. 409.
 - (c) Build up machined surfaces with nickel plate and machine to design dimensions and finish as shown in Fig. 409.

(2) Repair of attach holes.

(a) Method 1 -- Nickel plate buildup

- 1) Machine as necessary to remove defects within repair limits as shown in Fig. 409.
- 2) Do a class A magnetic particle check of machined areas as shown in the SOPM 20-20-01.
- 3) Shot peen as shown in Fig. 409.
- 4) Build up the surfaces with nickel plate. Machine the nickel plate to design dimensions and finish as shown in Fig. 409.

(b) Method 2 -- Installation of repair bushing

CAUTION: MAKE SURE TO MACHINE THE ATTACH HOLES LARGE ENOUGH TO MEET THE MINIMUM WALL THICKNESS REQUIREMENTS SHOWN IN FIG. 419.

- 1) Machine as necessary to remove defects within repair limits as shown in Fig. 409.
- 2) Do a class A magnetic particle check of machined areas as shown in the SOPM 20-20-01.
- 3) Refinish as shown in Fig. 409.
- 4) Make a repair bushing (Fig. 416) as required to adjust for the material removed.
- 5) Install the repair bushing by the shrink-fit method (SOPM 20-50-03) with BMS 5-95 sealant on mating surfaces.
- 6) Machine the bushing bore to design dimensions and finish as shown in Fig. 409.

(c) Method 3 -- Installation of oversize bolts

- 1) Machine the attach holes to a diameter of 0.3125-0.3165 as shown in Fig. 409.
- 2) Do a class A magnetic particle check of machined areas as shown in the SOPM 20-20-01.
- 3) Refinish as shown in Fig. 409.
- 4) Machine the mating holes in the support 60, 63, Fig. 414.
- 5) Make a note to be sure to use the oversize bolt and related washer and nut in the oversized holes.

- F. Cam Arm (163, Fig. 1108) (65-55588-6) Lug faces (Fig. 410).
- (1) Machine as required, within repair limits, to remove defects.
 - (2) Refinish as indicated.
 - (3) Get an AN960KD616 or AN960KD616L washer for each face that you repaired. Adjust the thickness of each washer to be the same as the material removed from the mating face. Include a note to use these washers along with the standard washers when you put the cam arm assembly back together.
- G. Bushing (29, Fig. 1102) Replacement, Toggle Assembly (18, Fig. 1102).
- (1) Remove the old bushings.
 - (2) If you find defects on the toggle surfaces, refer to par. 1.I. repair instructions.
 - (3) Install replacement bushings by the shrink-fit or press method of SOPM 20-50-03.
- H. Bearing (23, Fig. 1102) Replacement, Toggle Assembly (18, Fig. 1102).
- (1) For 65-3336-1, -2, do the following:
 - (a) Remove lockwire from spring pin (19).
 - (b) Remove spring pin (19), bolt assembly (20) and the bearing.
 - (c) Apply a thin layer of MIL-G-23827 grease to all surfaces of bolt assembly (20) and the bearing.
 - (d) Install the bearing and bolt assembly (20).
 - (e) Install spring pin (19).
 - (f) Lockwire spring pin (19) per SOPM 20-50-02 with MS20995NC32 lockwire.
 - (2) For 65-3336-3, to the following:
 - (a) Remove the bolt (20) and the bearing (23).
 - (b) Install the new bolt (20) in the bearing (23) and toggle (30) using the press fit method per SOPM 20-50-03.
 - (c) Upset the hollow end of the pin to the minimum diameter shown in Fig. 412A. Make sure the bearing (23) turns freely under light finger pressure.

I. Bearing (27, Fig. 1102) Replacement, Toggle Assembly (18, Fig. 1102).

- (1) Remove bearing (27), bushing (28), washer (26), nut (25), and cotter pin (24).
- (2) Apply a thin layer of BMS 3-24 grease to the shank and threads of bearing (27).
- (3) Install bearing (27), bushing (28), washer (26), and nut (25). Tighten nut (25) to 50-100 pound-inches.

NOTE: For 69-35336-1, -2, it may be necessary to add AN960-616L washer and for 69-35336-3, it may be necessary to add NAS1149C0632R washer, if and as required to provide cotter pin engagement while meeting nut torque requirements.

- (4) Install cotter pin (24) per SOPM 20-50-02.

J. Toggle (30, Fig. 1102) Lug Holes.

- (1) For 69-35329-1 only: machine as required, within repair limits, to remove defects.
- (2) Refinish as indicated in Fig. 412.
- (3) If applicable, make repair bushings (Fig. 413) to adjust for the material removed in step (1).
- (4) Install the bushings by the shrink-fit method of SOPM 20-50-03.
- (5) Machine the bores of the bushings to design dimensions and finish. Be sure to restore the countersink, if necessary.

K. Bushing (61A, Fig. 1102) replacement, support assembly (55, 60)

- (1) Remove the old bushings.
- (2) Install and fillet seal the replacement bushing (61A) with BMS 5-95 sealant per SOPM 20-50-03.

L. Support (60, 63, Fig. 1102) holes, (Fig. 414).

- (1) Method 1 -- Installation of repair bushing

CAUTION: MAKE SURE TO MACHINE THE ATTACH HOLES LARGE ENOUGH TO MEET THE MINIMUM WALL THICKNESS REQUIREMENTS SHOWN IN FIG. 415.

- (a) Machine as necessary to remove defects within repair limits as shown in Fig. 414.

- (b) Do a class A magnetic particle check of machined areas as shown in the SOPM 20-20-01.
 - (c) Refinish as shown in Fig. 414.
 - (d) Make a repair bushing (Fig. 415) as required to adjust for the material removed.
 - (e) Install the repair bushing by the shrink-fit method (SOPM 20-50-03) with BMS 5-95 sealant on mating surfaces.
 - (f) Machine the bushing bore to design dimensions and finish as shown in Fig. 414.
- (2) Method 2 -- Installation of oversize bolts
- (a) Machine the support holes to a diameter of 0.3125-0.3165 as shown in Fig. 414.
 - (b) Do a class A magnetic particle check of machined areas as shown in the SOPM 20-20-01.
 - (c) Refinish as shown in Fig. 414.
 - (d) Machine the mating holes in the torque tube oversize.
 - (e) Make a note to be sure to use the oversize bolt and related washer and nut in the oversized holes.

2. 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.

A. Fig. 1101 Parts

- (1) Fore flap assembly (1)
- (a) 65-46430-75, -76, -79, -80, 65-71978-1, -2, -23, -24 -- Apply gray gloss enamel BMS 10-60, color BAC 707 (SRF-14.9813) after installation of support assemblies (59, 60, Fig. 1102), and torque tube assembly (70, Fig. 1102), but before installation of toggle assembly (18). Omit finish from rub strips, seals, and identification plates.
 - (b) 65-46430-83, -84 -- Chemical treat and apply primer BMS 10-11, Type 1 (SRF-2.30) and abrasion-resistant finish (SRF- 14.9624) on top surface of flap in a strip 13.00 inches wide from trailing edge forward for full length of flap, and on bottom surface in a strip 1.20 inches wide running from a line 0.25 inch aft of lower skin splice to 0.95 inch forward of splice. Apply primer BMS 10-11, Type 1 (SRF-12.205) and enamel BMS 10-60, color BAC707 (SRF-14.9813) to all other exterior surfaces before installation of toggle assemblies and cam follower bearings. Omit finish from rub strips, seals and identification plates.

- I
- (c) 65-71940-23, -24, -33, -34 -- Apply gray gloss enamel BMS 10-60, color BAC707 (SRF-14.9813) after installation of support assemblies and torque tube assembly, but before installation of toggle assembly. Prepare the surface (SRF-14.672), then apply conductive coating BMS 10-21, Type 3 (SRF-14.685, which replaces SRF-14.68) and enamel BMS 10-60, color BAC707 (SRF-14.9813) over fiberglass areas only. Omit finish from rub strips, seals, and identification plates.
 - (d) 65-46430-87 and -88 -- Chemical treat or chromic acid anodize and apply primer BMS 10-11, Type 1 (SRF-2.30) and abrasion-resistant finish (SRF-14.9624) on top surface of flap in a strip 13.00 inches wide from trailing edge forward for full length of flaps, and on bottom surface in a strip 1.20 inches wide running from a line 0.25 inch aft of lower skin splice to 0.95 inch forward of splice. Apply primer BMS 10-79 and gloss enamel BMS 10-60 Type 2 (SRF-14.9863-707) to all other exterior surfaces after installation of tube and support assemblies. Omit finish from rub strips, seals and identification plates.

(2) Mid flap assembly (2)

- (a) Interior surfaces, midflap structure -- Apply BMS 3-23, Type 2, corrosion preventive compound (F-19.26) to all interior surfaces between front and rear spars, including ribs, front surface of rear spar, aft surface of forward spar, and forward and aft surfaces of midspar.

NOTE: This is the recommended procedure for protection of all midflap assemblies from corrosion. Parts delivered with early airplanes could be without this finish.

Do not apply corrosion preventive compound to areas that will subsequently be painted or sealed. Before you apply the compound, mask control cables, pulleys, bearings, and wire bundles. Or apply the compound before you install these components.

- (b) Exterior surface of 65-71902-1 thru -4, -9 thru -26, -31 thru -36, -41 thru -46 and 65-71971-1 thru -4, -133 thru -136 -- Apply finish as shown in Fig. 401, except apply no finish to carriage assembly (1, Fig. 1106). Omit finish on rub strips, seals and identification plates.

- I
- (c) Exterior surface of 65-71940-21, -22, -25, -26, -31, -32, -35, -36, -41, -42 -- Apply finish as shown in Fig. 401, except apply no finish to carriage assembly. Prepare the surface (SRF-14.672), then apply conductive coating BMS 10-21, Type 3 (SRF-14.685, which replaces SRF-14.68) and enamel BMS 10-60, color BAC707 (SRF-14.9813) to fiberglass areas only. Omit finish on rub strips, seals, and identification plates.

(3) Aft flap assembly (3)

- (a) 65-46434-117, -118, -135, -136, 65-71970-1, -2 -- Apply abrasion-resistant finish (SRF-14.9624) to top surface in a spanwise strip 3.70 inches wide, starting 9.00 inches forward of trailing edge. Apply gray gloss enamel BMS 10-60 (SRF-14.9813) to all other areas. Omit finish on seals and seal retainers.

- (b) 65-71940-19, -20, -29, -30 -- Apply abrasion-resistant finish (SRF-14.9624) to top surface in a spanwise strip 3.70 inches wide, starting 9.00 inches forward of trailing edge. Apply gray gloss enamel BMS 10-60 (SRF-14.9813) to all other areas, but prepare the surface (SRF-14.672) and apply BMS 10-21 conductive coating (SRF-14.685, which replaces SRF-14.68) and enamel BMS 10-60 (SRF-14.9813) on fiberglass areas only. Omit finish on rub strips, seals and identification plates.
- (c) 65-46434-139, -140 -- Apply abrasion-resistant finish (SRF-14.9624) to top surface in a spanwise strip 3.70 inches wide, starting 9.00 inches forward of trailing edge. Apply primer BMS 10-79 areas. Omit finish on seals and retainers. Mask all bearings and bushings and gloss enamel BMS 10-60, Type 2 (F-14.9863-707) to all other

NOTE: This primer and enamel (F-14.9863-707) can be applied to any painted fitting attached to or which comes out through the flap exterior.

- (4) Shaft assemblies (10, 33) -- Apply primer BMS 10-11, Type 1 (SRF-12.205) all over, but not on bearing surface. Material: 4340M steel, 270-300 ksi.
- I (5) Shafts (11, 34) -- Cadmium-titanium plate (F-15.01) all over, but not on end bearing surface and in holes. Chrome plate (F-15.04) on end bearing surface. Dimension limits of end bearing surface OD are 0.4942-0.4945 inch before plating, and 0.4988-0.4995 inch after plating. Dimension limits of main shaft area OD are 0.9979-0.9983 inch before plating and 0.9989-0.9995 inch after plating. Magnetic particle examine after plating. Material: 4340M steel, 270-300 ksi.
- (6) Indexing plate (15) 65-50585-7, -9, -11, -13, -14 -- Sulfuric acid anodize (F-2.201). Apply primer BMS 10-11, Type 1 (SRF - 12.205) all over, but not on 2.699-inch bore or 1.750-inch bearing seat. (65-50585-19, -20) chromic acid anodize and apply primer BMS 10-11, Type 1 (F-18.13) all over, but not on 2.675 OD or 1.75 diameter. Material: Al alloy.
- (7) Retainers (28, 48) -- Cadmium plate (F-1.1926). Apply primer BMS 10-11, Type 1 (SRF -12.205) all over. Diameters must be concentric within 0.002 TIR after plating. Material: 4340 steel, 180-200 ksi.
- (8) Retainer (50) -- See Fig. 401.
- (9) Retainer (52) -- No finish (F-25.01). Material: 17-4PH CRES, 180-200 ksi.

B. Fig. 1102 Parts

- (1) Track (7) -- Cadmium-titanium plate (F-15.01). Apply BMS 10-11, Type 1 primer (F-20.02). Apply BMS 10-11, Type 2 enamel, color 707 gray (SRF-12.63). Material: 4340M steel, 270-300 ksi.
- (2) Track (8) -- Cadmium-titanium plate (F-15.01). Apply BMS 10-11, Type 1 primer (F-20.02). Apply BMS 10-11, Type 2 enamel, color 707 gray gloss (F-21.02). Material: 4330M steel, 220-240 ksi.

- (3) Bolt (21) -- Cadmium plate (F-1.1926) all over, but not in holes. Magnetic particle examine after plating. Dimension limits of OD are 0.2493-0.2504 inch before plating, and 0.2502-0.2513 inch after plating. Material: 4340 steel, 160-180 ksi.
- (4) Deleted.
- (5) Retainer (36) -- Passivate (F-8.07) all over. Material: 17-4PH CRES, 180-200 ksi.
- (6) Guide (37) -- Apply primer BMS 10-11, Type 1 (SRF-12.205), but not on surfaces shown in Fig. 401. Material: Al alloy.
- (7) Brackets (51, 52) -- Cadmium-titanium plate (F-1.308, which replaces F-1.181). Apply primer BMS 10-11, Type 1 (SRF-12.205), and enamel BMS 10-11, Type 2, color BAC707 (SRF-12.63) all over, but not in holes. Material: 4330M steel, 220-240 ksi.
- (8) Supports (60, 63) -- See Fig. 414.
- (9) Rub strips (61, 64) (69-38802-7) -- Cadmium plate (F-15.06) all over. (65C37022-1) -- No finish (F-25.01). Material: Beryllium copper.
- (10) Torque tube (74) -- See Fig. 409.
- (11) Retainers (85, 92) -- Cadmium plate and apply primer BMS 10-11, Type 1 (SRF-1.285). Apply gray gloss enamel BMS 10-60 (SRF-14.9813). Material: 4130 steel.

C. Fig. 1103 Parts

- (1) Housings (5, 6) -- Apply mixed-primer-system finish (SRF-14.08) all over. Material: Al alloy.

D. Fig. 1104 Parts

- (1) Bolt (7) -- Cadmium plate (F-1.1926) all over, but not in holes. Magnetic particle examine after plating. Dimension limits of OD are 0.2481-0.2487 inch before plating, and 0.2485-0.2495 inch after plating. Material: Steel.
- (2) Supports (13, 21) -- Chemical treat or chromic acid anodize and apply primer BMS 10-11, Type 1 (SRF-2.30) and enamel BMS 10-11, Type 2 (SRF-12.63) but not primer or enamel in holes. Material: Al alloy.
- (3) Bracket (47) -- Chemical treat or chromic acid anodize and apply primer BMS 10-11, Type 1 (SRF-2.30) and enamel BMS 10-11, Type 2 (SRF-12.63) but no primer or enamel in holes. Material: Al alloy.
- (4) Shield assembly (63) -- Chemical treat or chromic acid anodize and apply primer BMS 10-11, Type 1 (SRF-2.30) all over. Apply gray gloss enamel BMS 10-60 (SRF-14.9813) to all exterior surfaces.

E. Fig. 1105 Parts

- (1) Trailing Edge Assembly (3) -- Prepare surface and apply BMS 10-79, Type 2 primer and gray BMS 10-60, Type 2 enamel (F-14.9863-707) to exterior and fittings attached to or which come out to the flap exterior, but not on bearings or bushings.
- (2) Fitting (3C) -- Passivate (F-8.07) all over. Material: 17-4PH CRES, 180-200 ksi.
- (3) Tracks (113, 114) -- Cadmium-titanium plate (F-1.308, which replaces F-1.181). Apply primer BMS 10-11, Type 1 (SRF-12.205) and enamel BMS 10-11, Type 2, color BAC707 (SRF-12.63) all over, but no primer or enamel in holes. Material: 4330M steel, 220-240 ksi for 65-47901-1; 4340M steel, 270-300 ksi for 65-50746-1.
- (4) Hook (123) -- Chemical treat or chromic acid anodize and apply primer BMS 10-11, Type 1 (SRF-2.30). Apply abrasion-resistant finish (SRF-14.9625) all over, but not on mounting surface. Material: Al alloy.
- (5) Hook (152, 65C33274-series) -- Chromic acid anodize and apply BMS 10-11, Type 1 primer (F-18.13). Apply abrasion-resistant finish (SRF-14.9625) but not mating surface. Material: Al alloy.
- (6) Hook (152, 69-54946-series) -- Chemical treat or chromic anodize and apply BMS 10-11, Type 1 primer (F-18.05). Apply abrasion-resistant finish (SRF-14.9625) all over but not on mating surface. Apply BMS 10-11, Type 2 enamel, color BAC707 (F-20.02) on mating surface. Material: Al alloy.
- (7) Retainers (131, 140) -- Chemical treat or chromic acid anodize and apply primer BMS 10-11, Type 1 (SRF-2.30). Material: Al alloy.
- (8) Spacers (144 thru 147) -- Chemical treat or chromic acid anodize and apply primer BMS 10-11, Type 1 (SRF-2.30) all over. Material: Al alloy.
- (9) Plate (161) -- Chemical treat or chromic acid anodize and apply one coat primer BMS 10-11, Type 1 (SRF-2.30) all over. Material: Al alloy.

F. Fig. 1106 Parts

- (1) Carriages (4, 10) -- Cadmium-titanium plate (F-1.308, which replaces F-1.181) all over, followed by primer BMS 10-11, Type 1 (SRF-12.205). Material: 4330M steel, 220-240 ksi.
- (2) Cams (20, 21) -- Cadmium-titanium plate (F-1.308, which replaces F-1.181) all over, followed by primer BMS 10-11, Type 1 (SRF-12.206), followed by gray gloss enamel BMS 10-60 (SRF-14.9813) all over. Magnetic particle examine after plating. Material: 4330M steel, 220-240 ksi.

- (3) Crossbeam (25) -- Cadmium plate and apply primer BMS 10-11, Type 1 (SRF-1.285) all over, followed by enamel BMS 10-11, Type 2, color BAC707 (SRF-12.63) all over, but no primer or enamel in holes. Material: 4340 steel, 180-200 ksi.
- (4) Brackets (29) -- Cadmium plate and apply primer BMS 10-11, Type 1 (SRF-1.285) all over, followed by enamel BMS 10-11, Type 2, color BAC707 (SRF-12.63) all over, but not in holes. Magnetic particle check after plating. Material: 4140 steel, 125-145 ksi.
- (5) Bolts (33) -- Cadmium plate (SRF-1.1926) all over, but not in holes. Magnetic particle examine after plating. Design dimensions of OD are 0.3743-0.3744 inch before plating, and 0.3747-0.3752 inch after plating. Material: 4340 steel, 125-145 ksi.
- (6) Bolts (39, 54, 66) -- Cadmium-titanium plate (F-15.01). Magnetic particle examine after plating. Design dimensions of OD are 0.8736-0.8739 inch before plating, and 0.8740-0.8745 inch after plating. Material: 4340 steel, 180-200 ksi.
- (7) Plate (73) (69-39233-2) -- Cadmium-titanium plate (F-1.308, which replaces F-1.181) followed by primer BMS 10-11, Type 1 (SRF-12.206) and gray enamel BMS 10-11, Type 2 (SRF-12.63). Material: 4130 steel, 180-200 ksi.
- (8) Plate (73) (69-39233-3,-4) -- Apply phosphate fluoride coating (F-14.881) and primer BMS 10-11, Type 1 (F-20.02). Material 6AL-4V Titanium alloy.
- (9) Supports (84, 100) -- Chemical treat or chromic acid anodize and apply primer BMS 10-11, Type 1 (SRF-2.30 or F-18.13) all over, but not in holes. Material: Al alloy.
- (10) Fail-safe tube assemblies (111) -- Chemical treat or chromic acid anodize and apply one coat primer BMS 10-11, Type 1 (SRF-2.30) all over. Apply 1.00-inch wide band of BMS 5-26 Class A sealant, 0.03 inch thick, on external area between 8.50 and 9.50 inches from inboard end of tube. Material: Al alloy.
- (11) Fail-safe supports (114, Fig. 1106) -- Chemical treat or chromic acid anodize and apply primer BMS 10-11, Type 1 (SRF-2.30). Material: Al alloy.
- (12) Torque tubes (121, Fig. 1106) -- See Fig. 401.
- (13) Sleeve (122, Fig. 1106) -- Cadmium plate to 0.0002-0.0004 inch thickness (F-15.02). Material: 304 CRES per QQ-S-763, Class 304.

G. Fig.1107 Parts

- (1) Carriage (1, 65-52246-17, -18) -- After assembly apply gray gloss enamel BMS 10-60, color BAC707 (SRF-14.9813) all over but not in holes. Small amounts of enamel can be around edges of rub strip (6). Material: 4330M steel, 220-240 ksi.

- (2) Carriages (3, 9) -- Cadmium-titanium plate (F-1.308, which replaces F-1.181) all over, followed by primer BMS 10-11, Type 1 (SRF-12.205). Material: 4330M steel, 220-240 ksi.
- (3) Cams (19, 20) -- Cadmium-titanium plate (F-1.308, which replaces F-1.181) all over, followed by primer BMS 10-11, Type 1 (SRF-12.206), followed by gray gloss enamel BMS 10-60 (SRF-14.9813) all over. Magnetic particle examine after plating. Material: 4330M steel, 220-240 ksi.
- (4) Brackets (25) -- Cadmium plate and apply primer BMS 10-11, Type 1 (SRF-1.285) all over, followed by enamel BMS 10-11, Type 2, color BAC707 (SRF-12.63) all over, but not in holes. Magnetic particle check after plating. Material: 4140 steel, 125-145 ksi.
- (5) Bolts (29) -- Cadmium plate (SRF-1.1926) all over, but not in holes. Magnetic particle examine after plating. Design dimensions of OD are 0.3743-0.3744 inch before plating, and 0.3747-0.3752 inch after plating. Material: 4340 steel, 125-145 ksi.
- (6) Bolts (35, 50, 62) -- Cadmium-titanium plate (F-15.01). Magnetic particle examine after plating. Design dimensions of OD are 0.8736-0.8739 inch before plating, and 0.8740-0.8745 inch after plating. Material: 4340 steel, 180-200 ksi.
- (7) Plate (102) (69-39233-1) -- Cadmium-titanium plate (F-1.308, which replaces F-1.181) followed by primer BMS 10-11, Type 1 (SRF-12.206) and gray enamel BMS 10-11, Type 2 (SRF-12.63). Material: 4130 steel, 180-200 ksi.
- (8) Plate (102) (69-39233-3) -- Apply phosphate fluoride coating (F-14.881) and primer BMS 10-11, Type 1 (F-20.02). Material: 6AL-4V Titanium alloy.
- (9) Supports (77, 91) -- Chemical treat or chromic acid anodize and apply primer BMS 10-11, Type 1 (SRF-2.30 or F-18.13) all over, but not in holes. Material: Al alloy.
- (10) Fail-safe tube assemblies (107) -- Chemical treat or chromic acid anodize and apply one coat primer BMS 10-11, Type 1 (SRF-2.30) all over. Apply 1.00-inch wide band of BMS 5-26 Class A sealant, 0.03 inch thick, on external area between 8.50 and 9.50 inches from inboard end of tube. Material: Al alloy.
- (11) Fail-safe supports (111) -- Chemical treat or chromic acid anodize and apply primer BMS 10-11, Type 1 (SRF-2.30). Material: Al alloy.
- (12) Torque tubes (122) -- See Fig. 401.

H. Fig. 1108 Parts

- (1) Fitting (9) -- Sulfuric acid anodize (F-2.201). Apply primer BMS 10-11, Type 1 (SRF-12.205). Material: Al alloy.
- (2) Serrated plates (11, 12) -- Chemical treat or chromic acid anodize and apply primer BMS 10-11, Type 1 (SRF-2.30). Material: Al alloy.

- (3) Pulley support (19) -- Cadmium plate (F-1.1929). Magnetic particle examine after plating. Internal dimension limits after plating are 0.6250-0.6255 inch. Material: 17-4PH CRES, 150-190 ksi.
- (4) Boom (52) -- Chromic acid anodize (F-17.02) and apply BMS 10-11, Type 1 primer (F-20.02) and BMS 10-11, Type 2 enamel, 707 gray gloss (F-21.02) all over but not (F-2.204 or F-17.06) except inside of track. Optional: Flash hard anodize (0.0001-0.0003 inch thick). Apply of BMS 10-11, Type 1 primer (F-20.02) all over but not in the area shown in Fig. 401. Apply hard anodize (F-17.06) to full length of track as shown in Fig. 401. Material: Al alloy.
- (5) Fitting assemblies (54, 69-42346-1, -2, -5, -6; 70, 69-42343-1, -2, -5, -6) -- Chemical treat or chromic acid anodize and apply one coat primer BMS 10-11, Type 1 (SRF-2.30) all over. Material: Al alloy.
- (6) Drum (137) -- Chemical treat or chromic acid anodize and apply primer BMS 10-11, Type 1 (SRF-2.30) all over, but not to internal machined areas. Apply one more layer of primer (F-20.02) in all cable grooves. Material: Al alloy.

NOTE: Cam track areas are hard anodized.

- (7) Brackets (78, 149) -- Sulfuric acid anodize (F-2.201) and apply primer BMS 10-11, Type 1 (SRF-12.205), but not in holes. Material: Al alloy.
- (8) Bellcrank (159) -- Chemical treat or chromic acid anodize and apply primer BMS 10-11, Type 1 (SRF-2.30) all over, but not inside housing, because the housing inside is hard anodize. Material: Al alloy.
- (9) Cam arm (163) -- Chemical treat or chromic acid anodize and apply primer BMS 10-11, Type 1 (SRF-2.30) all over. Then apply primer BMS 10-11, Type 1 (SRF-12.206) to the rim of the part as shown in Fig. 401. Material: Al alloy.
- (10) Fitting (53)
 - (a) 69-43572-1: Passivate (F-8.07) all over. Material: 15-5PH or 17-7PH CRES, 180-200 ksi.
 - (b) 69-43572-3: Passivate (F-8.07) or cadmium plate and apply primer BMS 10-11, Type 1 (F-16.01). Material: 15-5PH CRES, 180-200 ksi.
- (11) Fitting assembly (54)(69-42346-9, -10) -- Chemical treat or chromic acid anodize, and apply BMS 10-11, Type 1 primer (F-18.05) all over. Material: Al alloy.
- (12) Screw (69) -- Passivate (F-17.09) all over. Material: 17-4PH CRES, 180-200 ksi.
- (13) Fitting (70A)(69-42343-11, -12) -- Chemical treat or chromic acid anodize and apply BMS 10-11, Type 1 primer (F-18.05 all over. Material: Al alloy.

- (14) Spring (178) -- Passivate (F-17.09) all over. Material: 17-7PH CRES, 210-230 ksi (69-42385-1). 15-5PH CRES, 180-200 ksi (69-42385-2).
- (15) Bracket (185) -- Chromic acid anodize (F-17.19). Apply primer BMS 10-11, Type 1 (F-20.02) but not in holes. Material: Al alloy.
- (16) Bellcrank (195) -- Chemical treat or chromic acid anodize and apply BMS 10-11, Type 1 (SRF-2.30) all over. Material: Al alloy.

I. Fig. 1109 Parts

- (1) Track (5) -- Cadmium plate and apply MIL-P-85582 primer (F-1.131). Apply BMS 10-11, Type 1 primer (SRF-12.206) all over but not in holes. Apply BMS 10-11, Type 2 enamel, color 707 gray (SRF-12.63) all over but not in holes. Material: 4340M steel, 270-300 ksi.
- (2) Support (26A) -- Cadmium-titanium plate (F-1.308, which replaces F-1.181) all over. Apply primer BMS 10-11, Type 1 (SRF-12.205) all over. Material: 4340M steel, 270-300 ksi.
- (3) Support assembly (31) -- Chromic acid anodize (F-17.19). Apply primer BMS 10-11, Type 1 (F-20.02). Material: Al alloy.
- (4) Brackets (51, 54, 61, 64)
 - (a) 69-39223-3, -4, -7, -8 -- Chemical treat or chromic acid anodize and apply primer BMS 10-11, Type 1 (SRF-2.30) all over, but not in holes. Material: Al alloy.
 - (b) 69-39223-13 thru -15 -- Chromic acid anodize (F-17.19). Apply primer BMS 10-11, Type 1 (F-20.02) but not in holes. Material: Al alloy.

J. Aluminum seal retainers, fillers, and miscellaneous sheet metal parts, but not external skins and doors -- Chemical treat or chromic acid anodize and apply BMS 10-11, Type 1 primer (SRF-2.30).

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

3. Replacement

- A. Replace all unserviceable parts that cannot be repaired.
- B. Replace all cotter pins at each overhaul.
- C. Replace all fabric aerodynamic seals at each overhaul.
- D. Replace all phenolic rub strips.

- (1) To remove the old rub strip, scrape it off with a sharp-edged wooden or plastic tool.

- (2) Install a replacement rub strip and bond it in position as follows:
- (a) Bond rub strip (61, 64, Fig. 1102; 7, 13, Fig. 1106; 12, Fig. 1107) per SOPM 20-50-12, Type 38, special method 2.
 - (b) Bond rub strip (86, 93, Fig. 1102) per SOPM 20-50-12, Type 60.
 - (c) Bond rub strip (16, 24, Fig. 1102; 42, 43, 44, Fig. 1109) per SOPM 20-50-12, Type 38.
 - (d) Bond rub strip (52, 55, 62, 65, Fig. 1109) per SOPM 20-50-12, Type 38, special method 1.
 - (e) Bond rub strip per SOPM 20-50-12, Type 38, special method 2.
 - (f) Bond rub strip (79, Fig. 1102) per Boeing D6-6232 document.
 - (g) Bond rub strips P/N 65-47856-25 (4H, Fig. 1107) per SOPM 20-50-12, Type 68.
 - (h) Bond rub strips, P/N 65-47856-29, -30, 69-78357-1, -2 (4H, Fig. 1107) per SOPM 20-50-12, Type 44 or Type 70.
- E. Replace all metal rub strips.
- (1) To remove the old rub strip, pry it off. If it is attached with rivets, remove the rivets first, then pry off the strip.
 - (2) Install a replacement rub strip and bond it in position with Type 44 per SOPM 20-50-12. Solvent clean off unwanted sealant. Install new rivets.
- F. Replace all clogged or damaged lubrication fittings, NAS516-1.
- G. Riveted parts -- Drill out the rivets. Be careful not to enlarge rivet holes. Remove the defective part. Install a replacement part with new rivets.
- H. Helical coil inserts -- Remove the old insert. Install a replacement with wet primer, BMS 10-11, Type 1, 1/4 to 1/2 turn below surface of part. Remove tang.
- I. Press-fit bushings -- Press out the old bushing. Install a replacement bushing by the press fit method of SOPM 20-50-03.
- J. Bushings (101, Fig. 1106 and 92, Fig. 1107).
- (1) Remove the bad bushings.
 - (2) Install replacement bushings and point stake them in position per SOPM 20-50-03 with 4 points equally spaced between the old stake marks within ± 0.03 inch.

- (3) Machine the bores to 1.0005-1.0010-inch diameter.
- K. Bearing (151, Fig. 1108) or bushing (152)
 - (1) Carefully press out the bad part.
 - (2) Solvent clean the hole and the mating surfaces of the bearing or bushing.
 - (3) Apply Loctite primer T to the mating surfaces of bushing, bearing, and bracket (149).
 - (4) Apply Loctite 609 retaining compound to the mating surfaces, and then install the part. Let the adhesive cure for 2 hours at room temperature.
 - (5) Solvent clean the unwanted Loctite 609 compound from the surfaces.
- L. Bearing (198, Fig. 1108) -- Machine the swaged flange from sleeve (196). Press out the bearing and the sleeve from bellcrank (195). Install a replacement bearing (198) and sleeve (196) and swage the sleeve per SOPM 20-50-03.
- M. Sleeve (122, Fig. 1106) (Fig. 402)
 - (1) Remove the old sleeve, which is a shrink-fit on shaft (120).
 - (2) Heat the replacement sleeve to 375°F maximum.
 - (3) Apply primer BMS 10-11, Type 1 to the mating surfaces of the tube (121) and the sleeves (122).
 - (4) Install the sleeves (122) on the tube (121) as shown in Fig. 402. If required, machine the sleeve diameter to the dimension and finish as shown in Fig. 402.
 - (5) If a machine replacement sleeve (122) is not available, get a sleeve, part number 69-5488-1. Install it onto the tube (121) and machine it to the dimensions and finish as shown per steps 3.M.(2) thru 3.M.(4) and Fig. 402.
- N. Reinforcing plate (65B) -- Remove the old plate. Bond a replacement in position with Type 44 adhesive per SOPM 20-50-12.
- O. Sleeves (13, 37, Fig. 1101)
 - (1) Remove the old sleeve, which is a shrink-fit on its mating shaft.
 - (2) Cool shafts (11, 34) in coolant.
 - (3) Heat the replacement sleeve to 225°F maximum.
 - (4) Put collars (12, 35) against shaft shoulder, spacer (36) against collar (35). Install sleeves (13, 37) with wet primer BMS 10-11, Type 1.

P. Bushings (56, 57, Fig. 1108)

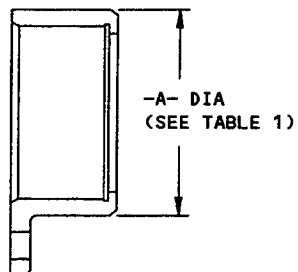
- (1) Remove the old bushings.
- (2) Install replacement bushings by the shrink fit method of SOPM 20-50-03.
- (3) Machine bushings as follows, with a 125 microinch or smoother finish.

BUSHING (FIG. 1108)	USED ON	DESIGN DIAMETER (INCH)
(56) BACB28U3B15	69-42346-1, -2, -5, -6	0.218 0.215
(56) BACB28W4B015	69-42346-9, -10, -13, -14	0.252 0.250
(57) BACB28U58B15	69-42346-1, -2, -5, -6	0.366 0.364
(57) BACB28W6B015	69-42346-9, -10, -13, -14	0.37B 0.375

4. Materials

NOTE: Equivalent substitutes can be used.

- A. Primer - Locquic primer, Grade T (SOPM 20-60-04)
- B. Retaining Compound -- Loctite 609 (SOPM 20-60-04)
- C. Adhesive -- Types 38, 44 (SOPM 20-50-12)
- D. Sealant -- BMS 5-26 (SOPM 20-60-04)
- E. Primer -- BMS 10-11, Type 1 (SOPM 20-60-02)
- F. Coolant -- Dry ice in methanol, O-M-232 (SOPM 20-60-01)
- G. Primer -- BMS 10-79, Type 2 (SOPM 20-60-02)

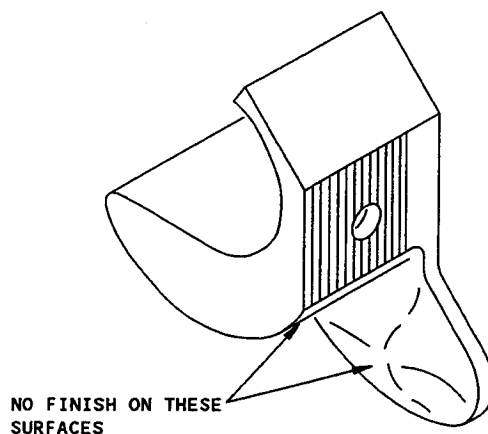


PART NO.	DIA -A- (AFTER PLATING)
69-43120-1,-2	2.0799 2.0792
69-43120-3 THRU -6	2.0783 2.0774

TABLE 1

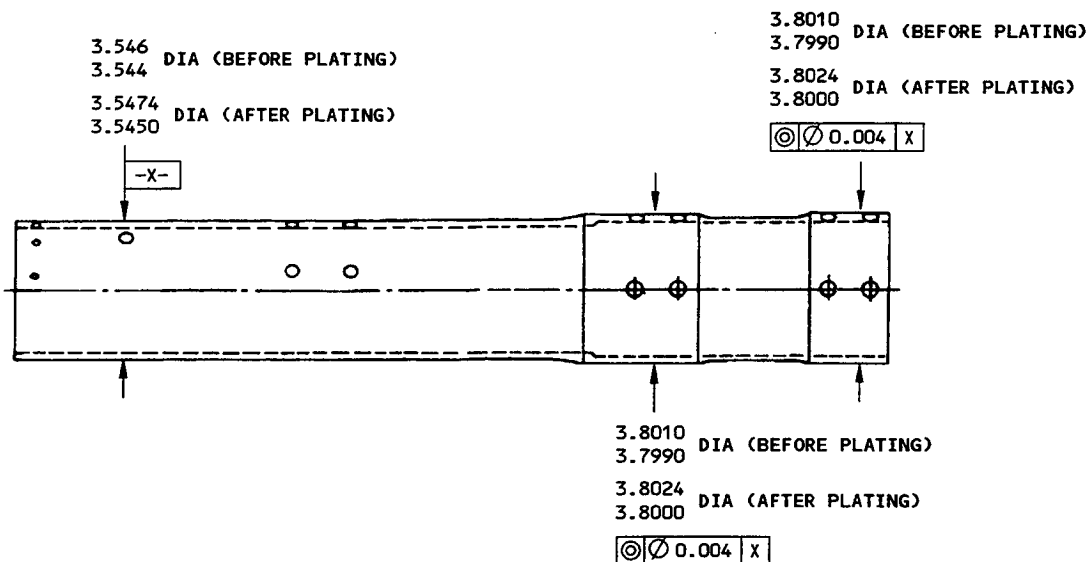
REFINISH
CADMIUM PLATE (F-15.02)

RETAINER (50, FIG. 1101)



GUIDE (37, FIG. 1102)

Miscellaneous Parts Refinish
Figure 401 (Sheet 1)



TORQUE TUBE (121, FIG. 1106)

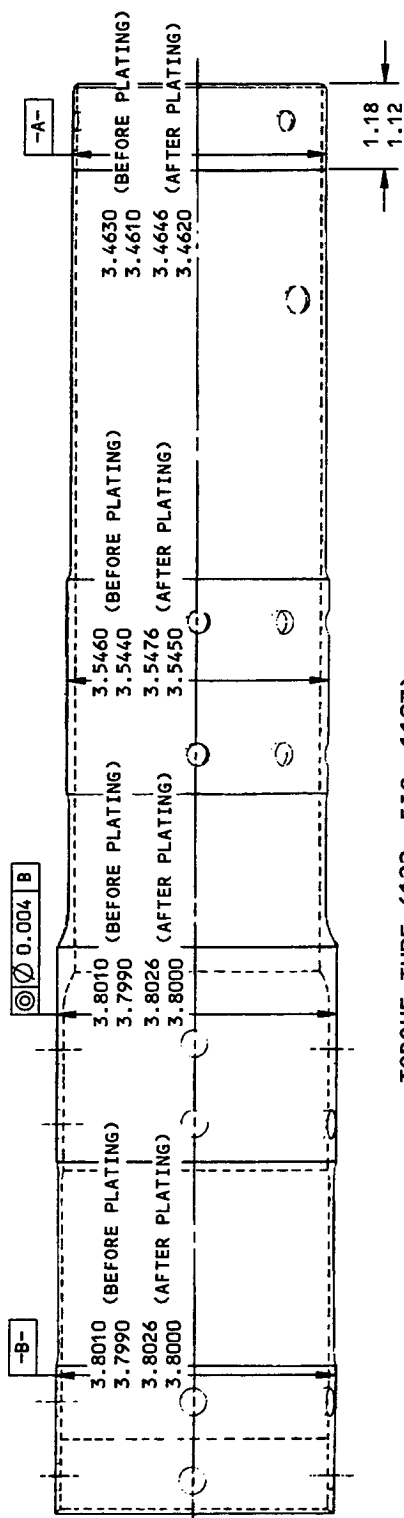
REFINISH

CADMIUM-TITANIUM PLATE (F-1.308) AND APPLY ONE COAT OF BMS 10-11, TYPE 1 PRIMER (F-20.02) TO ALL SURFACES. APPLY ONE ADDITIONAL COAT OF BMS 10-11 TYPE 1 PRIMER (F-20.02) TO THE TORQUE TUBE ID.

MATERIAL: 4330M STEEL, 180-200 KSI

ALL DIMENSIONS ARE IN INCHES

Miscellaneous Parts Refinish
Figure 401 (Sheet 2)



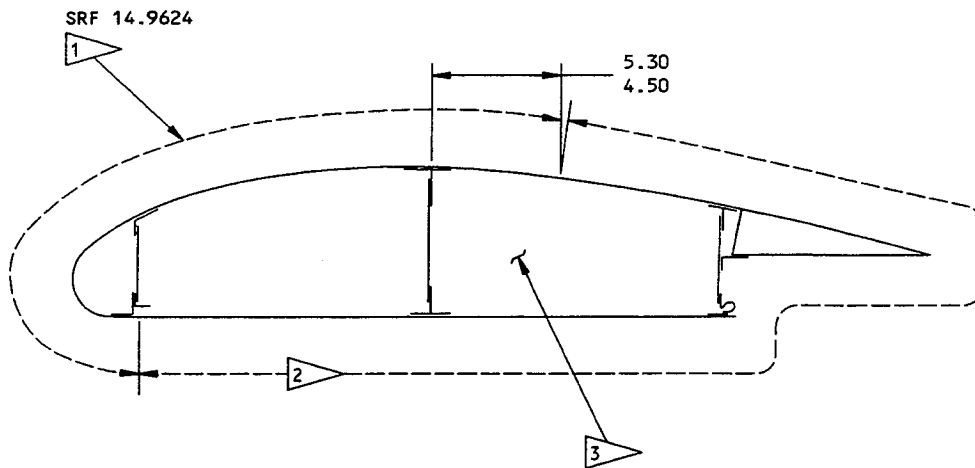
TORQUE TUBE (122, FIG. 1107)

MATERIAL: 4330M STEEL, 220-240 KSI
ALL DIMENSIONS ARE IN INCHES

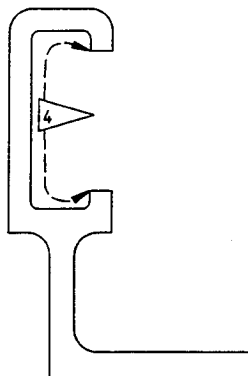
REFINISH

CADMIUM-TITANIUM PLATE (F-15.01) THE OD
AND APPLY BMS 10-11 PRIMER (F-20.02) TO IT.
APPLY BMS 10-11 PRIMER (F-20.03) TO THE ID.

Miscellaneous Parts Refinish
Figure 401 (Sheet 3)



MIDFLAP ASSEMBLY (2, FIG. 1101)



BOOM (52, FIG. 1108)

REFINISH

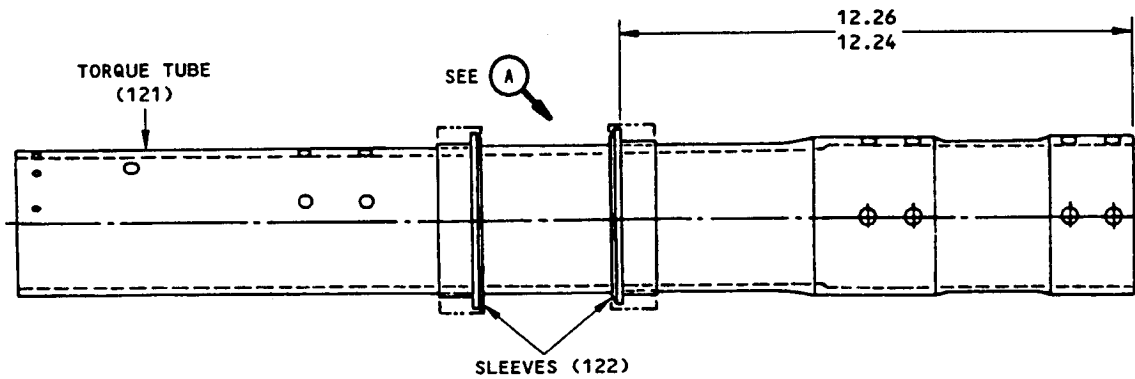
HARD ANODIZE AREA SHOWN BY 2
ON OTHER AREAS, CHROMIC ACID
ANODIZE (F-17.02), APPLY PRIMER
BMS 10-11, TYPE 1 (F-20.02) AND
ENAMEL BMS 10-11, TYPE 2 (F-21.02)

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

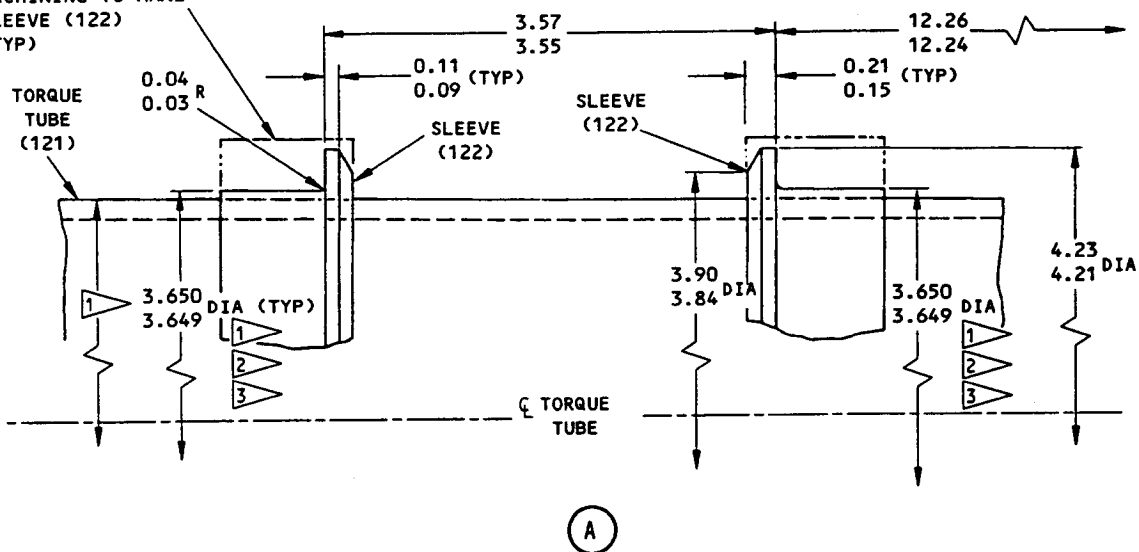
- 1 APPLY BMS 10-86 TEFLON COATING (SRF-14.9624).
- 2 APPLY BMS 10-79, TYPE 2 PRIMER AND BMS 10-60 ENAMEL (F-14.9863). USE THE COLOR OF THE AIRPLANE, IF APPLICABLE, AS FOR 65-71902-13,-14,-33, THRU -46.
- 3 ON EACH END, APPLY PRIMER BMS 10-11 TYPE 1 (SRF-14.996) AND BMS 10-60 ENAMEL (SRF-14.9813).
- 4 HARD ANODIZE (F-17.06) THIS INSIDE AREA, THE FULL LENGTH OF THE BOOM.

Miscellaneous Parts Refinish
Figure 401 (Sheet 4)



TORQUE TUBE ASSEMBLY (120, FIGURE 1106) 4

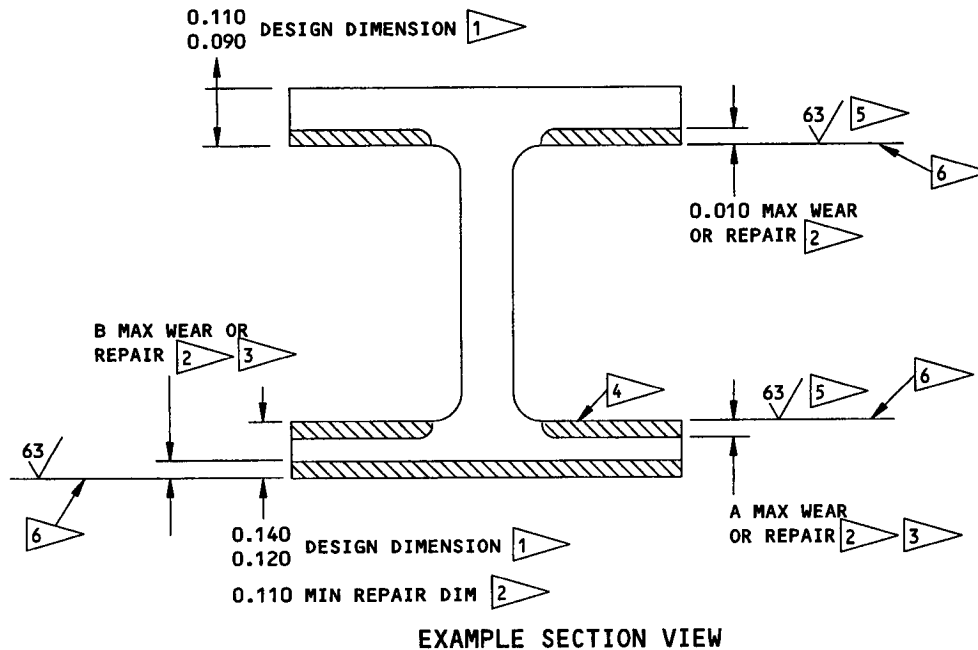
SLEEVE 69-54988-1
CONTOUR BEFORE
MACHINING TO MAKE
SLEEVE (122)
(TYP)



NOTES:

- 1 DIAMETERS TO BE CONCENTRIC WITH EACH OTHER WITHIN 0.001 TIR.
- 2 MACHINE SURFACE FINISH 63 MICROINCHES (MAX)
- 3 APPLY NO FINISH TO MACHINED SURFACE.
- 4 ASSEMBLE WET WITH BMS 5-95 SEALANT ON ALL FASTENERS AND FAYING SURFACES, AND APPLY BMS 3-29 TO ALL NON-FAYING SURFACES.

Replacement Data
Figure 402



REFINISH

CADMIUM-TITANIUM PLATE (F-15.01). APPLY PRIMER BMS 10-11, TYPE 1 (F-20.03) AND ENAMEL BMS 10-60 (SRF-14.9813) BUT NO PRIMER OR ENAMEL IN HOLES, OR AS SHOWN BY 6

WEAR SURFACE AGAINST THE CARRIAGE ROLLERS (NOT TO SCALE)

1 BEFORE PLATING

2 RESTORATION TO DESIGN DIMENSIONS NOT REQUIRED.

3 MAXIMUM WEAR OR REPAIR ON THESE TWO SURFACES (SUM OF A AND B) IS 0.010 INCH.

4 15 TO 1 BLEND OUT RATIO FOR REPAIR OF LOCAL DAMAGE ON TRACK SURFACE

5 63/ AFTER MACHINING, BEFORE SHOT PEEN;
75/ AFTER SHOT PEEN.

6 NO ENAMEL ON THESE SURFACES

REPAIR

REF 2 3 4 5

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

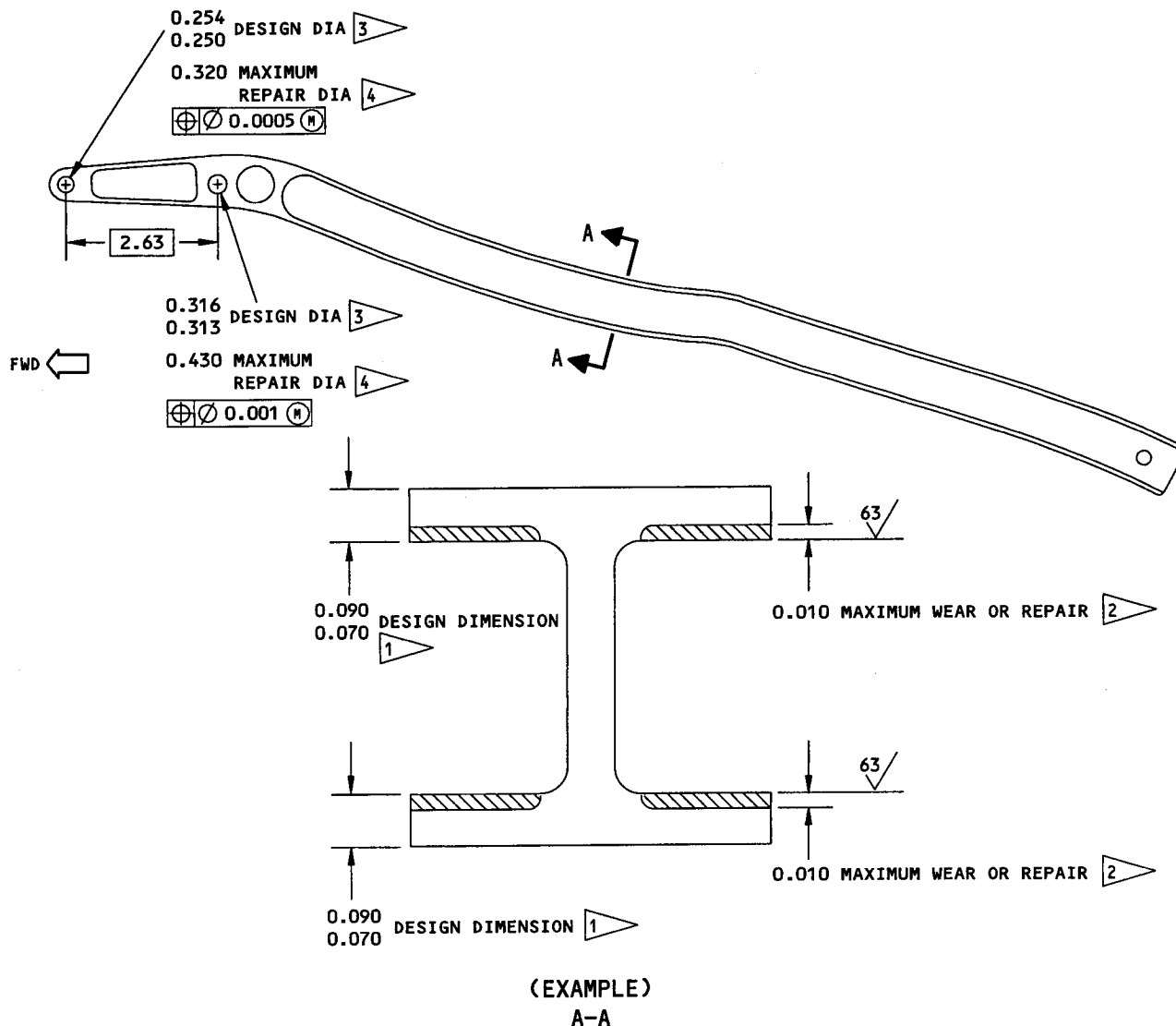
BREAK SHARP EDGES 0.02-0.04 R

SHOT PEEN: 0.016-0.033 SHOT SIZE
0.006-0.011 A2 INTENSITY

MATERIAL: 4340M STEEL, 270-300 KSI

ALL DIMENSIONS ARE IN INCHES

65-47894-1
Aft Flap Track Repair and Refinish
Figure 403



WEAR SURFACE AGAINST THE CARRIAGE ROLLERS. (NOT TO SCALE)

REFINISH

CADMIUM-TITANIUM PLATE (F-15.01). APPLY PRIMER BMS 10-11, TYPE 1 (F-20.02) AND ENAMEL 10-11 TYPE 2 (F-21.02) BUT NO PRIMER OR ENAMEL IN HOLES SHOWN BY

- AFTER PLATING
- RESTORATION TO DESIGN DIMENSIONS NOT REQUIRED.
- DO NOT PAINT THESE HOLES
- LIMIT FOR INSTALLATION OF REPAIR BUSHING (FIG. 411)

REPAIR

REF

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

MATERIAL: 4330M STEEL, 220-240 KSI

SHOT PEEN: 0.016-0.033 SHOT SIZE
0.010 A2 INTENSITY

ALL DIMENSIONS ARE IN INCHES

65-47901-1
Foreflap Track Repair and Refinish
Figure 404

65-46436
65-71940
65-71969
DASH NUMBERS LIMITED

BOEING
OVERHAUL MANUAL

0.254 DESIGN DIA 4
0.250

0.320 MAX REPAIR DIA 5

0.0005 (M)

2.63

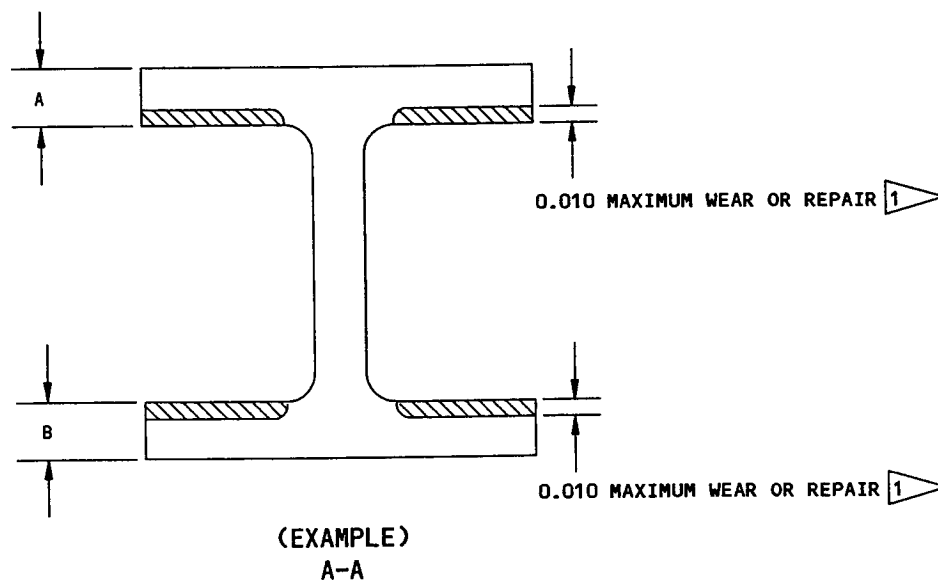
0.316 DESIGN DIA 4
0.313

0.430 MAX REPAIR DIA 5

0.001 (M)

FWD

LEFT SIDE VIEW



WEAR SURFACE AGAINST THE CARRIAGE ROLLERS (NOT TO SCALE)

65-50746-1
Foreflap Track Repair and Refinish
Figure 404A

DIM	DESIGN DIMENSIONS BEFORE PLATING		MINIMUM WEAR OR REPAIR THICKNESS	
			2	
X	A	B	A	B
1.70	0.085 0.075	0.090 0.070	0.075 3	0.070 3
2.40	0.091 0.081	0.101 0.081	0.071	0.071
3.00	0.096 0.086	0.110 0.090	0.076	0.080
4.00	0.104 0.094	0.125 0.105	0.084	0.095
5.00	0.112 0.102	0.140 0.120	0.092	0.110
6.00	0.121 0.111	0.155 0.135	0.101	0.125
7.00	0.129 0.119	0.170 0.150	0.109	0.140
7.70	0.135 0.125	0.180 0.160	0.115	0.150
8.36	0.140 0.130	0.190 0.170	0.120	0.160
9.06	0.145 0.135	0.200 0.180	0.125	0.170
14.10	0.185 0.175	0.260 0.240	0.165	0.230
19.00	0.115 0.105	0.130 0.110	0.095	0.100
20.20	0.065 0.055	0.110 0.090	0.045	0.080

TABLE A

REFINISH

CADMIUM-TITANIUM PLATE (F-15.01). APPLY PRIMER BMS 10-11, TYPE 1 (F-20.02) AND ENAMEL BMS 10-11, TYPE 2 (SRF-12.63) BUT NO PRIMER OR ENAMEL IN HOLES SHOWN BY 4.

- 1 THIS WEAR LIMIT IS NOT APPLICABLE AT X = 1.70 INCHES. SEE TABLE A.
- 2 RESTORATION TO DESIGN DIMENSION NOT REQUIRED.
- 3 WEAR OR MATERIAL REMOVAL PERMITTED ONLY WITHIN DESIGN DIMENSIONS
- 4 DO NOT PAINT THESE HOLES
- 5 LIMIT FOR INSTL OF REPAIR BUSHING (FIG. 411)

REPAIR

REF 1 2 3 5

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK SHARP EDGES 0.03-0.06 R

SHOT PEEN: 0.016-0.033 SHOT SIZE
0.015 A2 INTENSITY

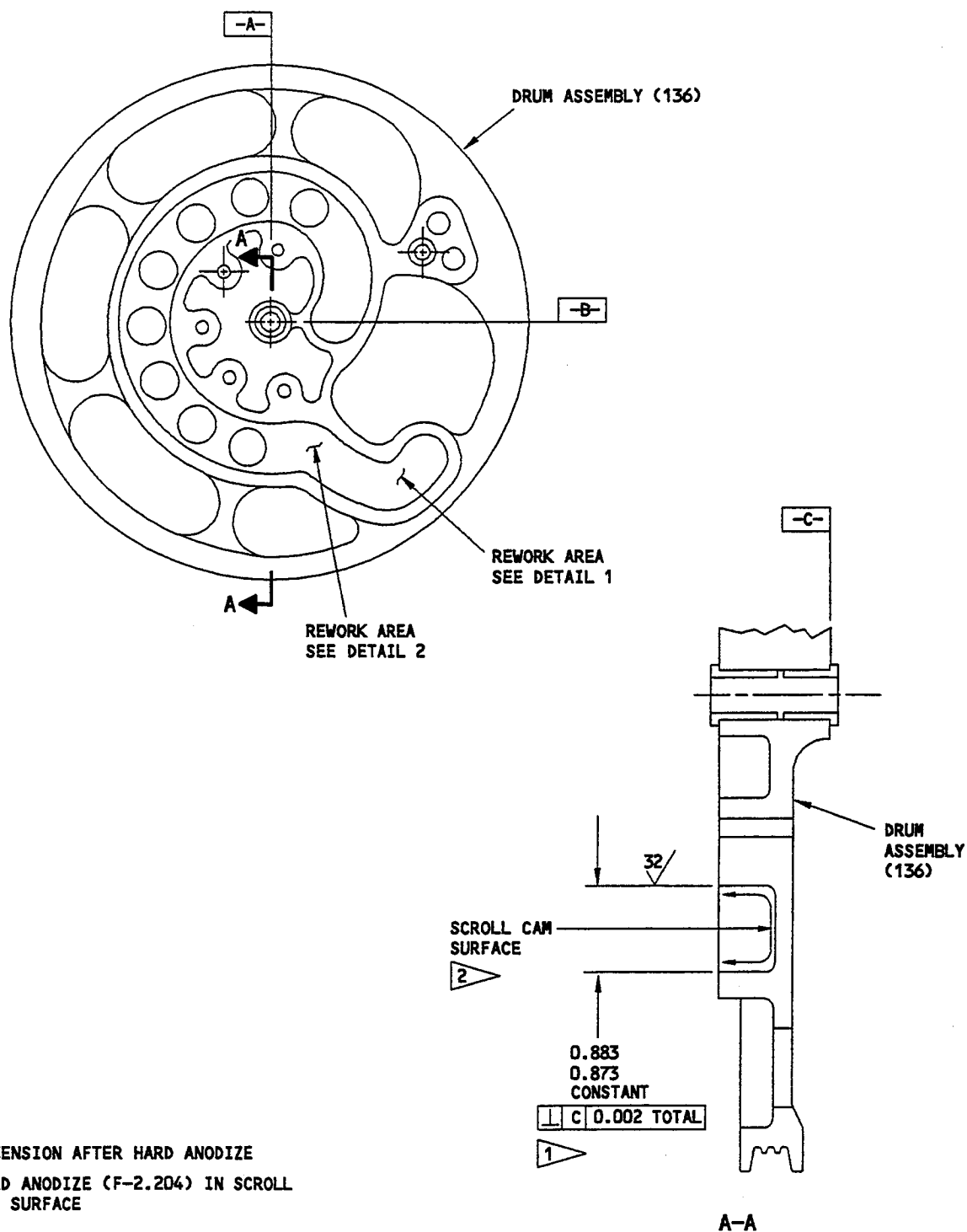
MATERIAL: 4340M STEEL, 270-300 KSI

ALL DIMENSIONS ARE IN INCHES

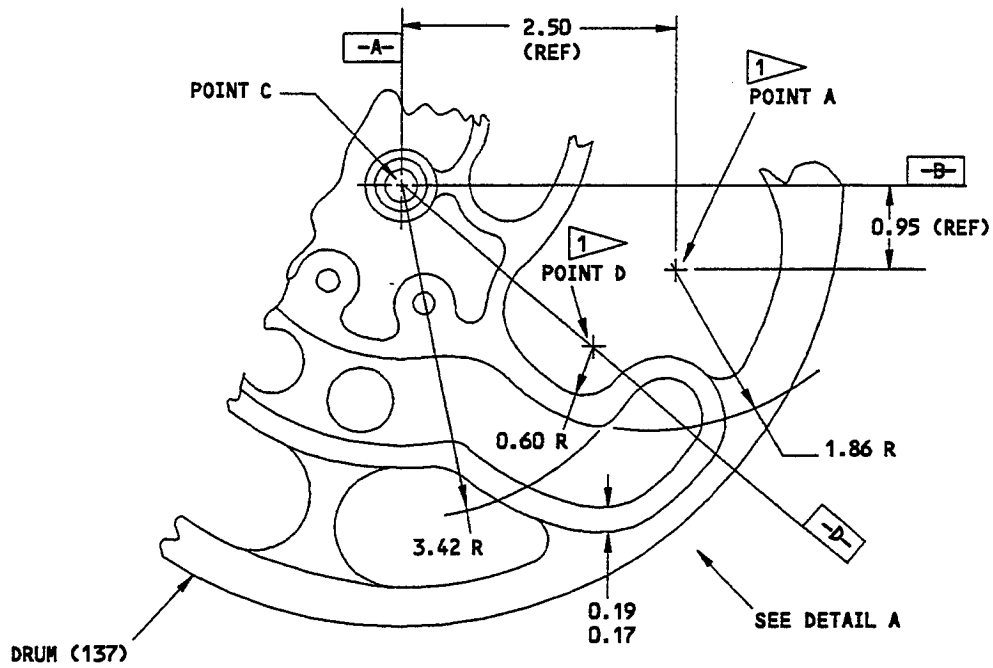
65-50746-1
Foreflap Track Repair and Refinish
Figure 404A (Sheet 2)

65-46436
65-71940
65-71969

BOEING
COMMERCIAL JET
OVERHAUL MANUAL



Drum Repair
Figure 405



DETAIL 1

1 DEFINE POINT "A" WITHIN THE LIMITS OF 1.86 RADIUS. MOUNT DRUM ON REVOLVING BASE PLATE ABOUT THE SECONDARY CENTER DEFINED AS POINT "D"

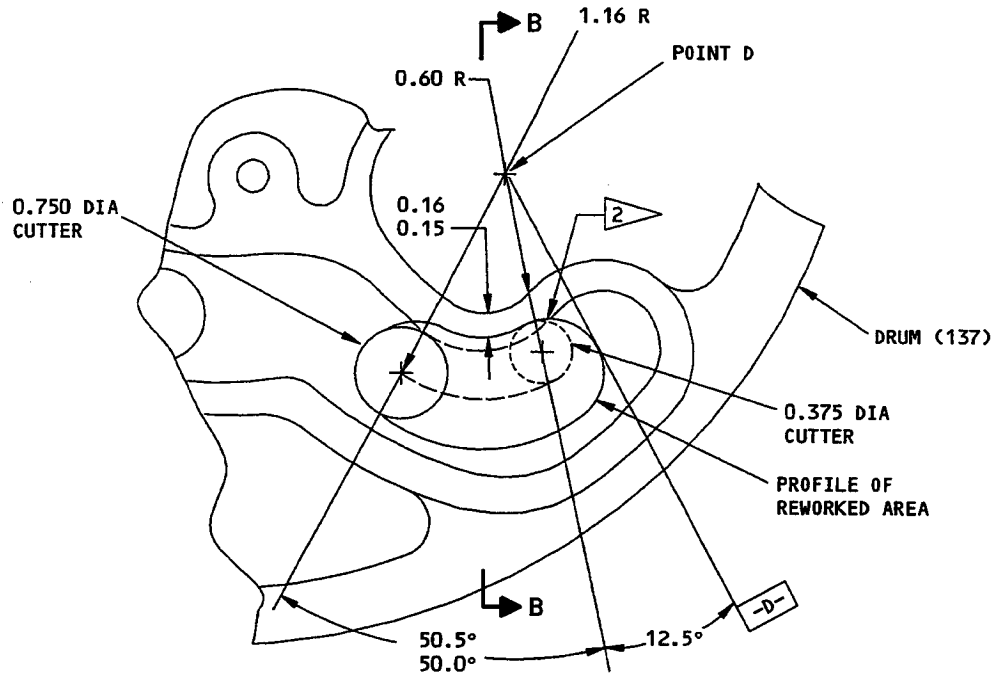
ALL DIMENSIONS ARE IN INCHES

Repair with Insert -1
Figure 406 (Sheet 1)

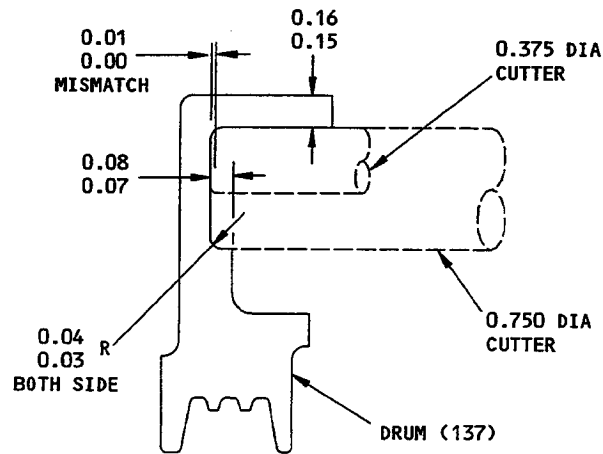
65-46436
65-71940
65-71969



OVERHAUL MANUAL



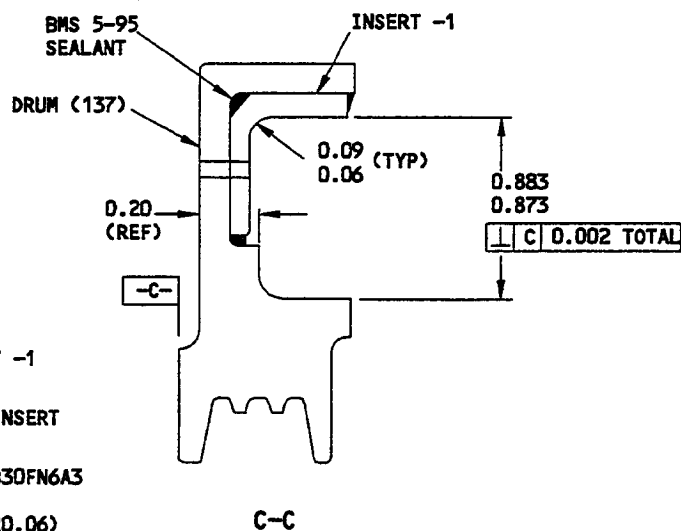
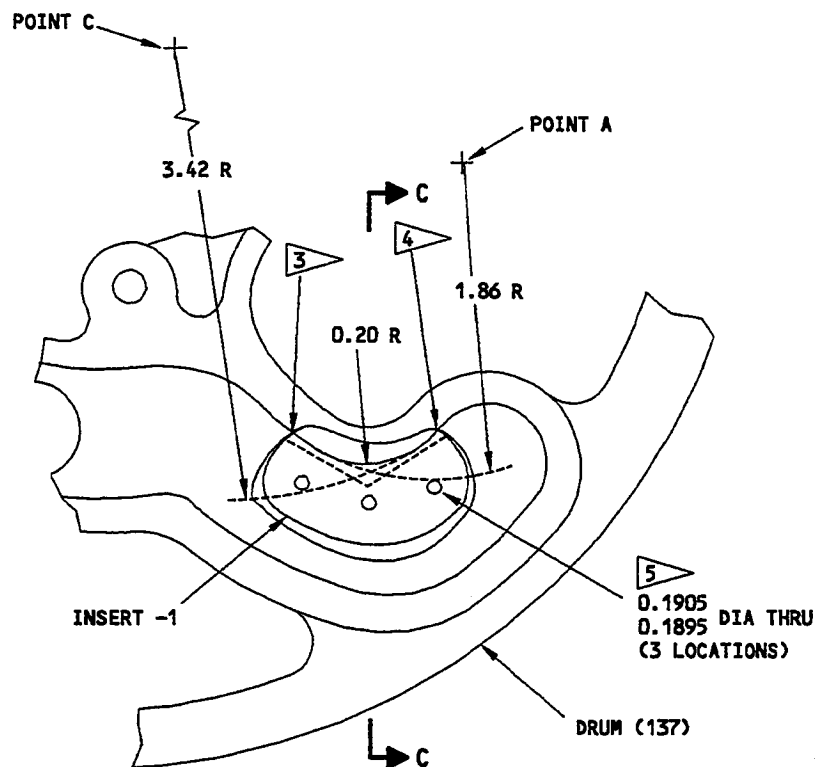
DETAIL A



B-B

- 2 LET THE 0.375 DIA CUTTER RUN OUT AT EACH END OF BLEND INTO THE PROFILE CUT OF THE 0.750 CUTTER.

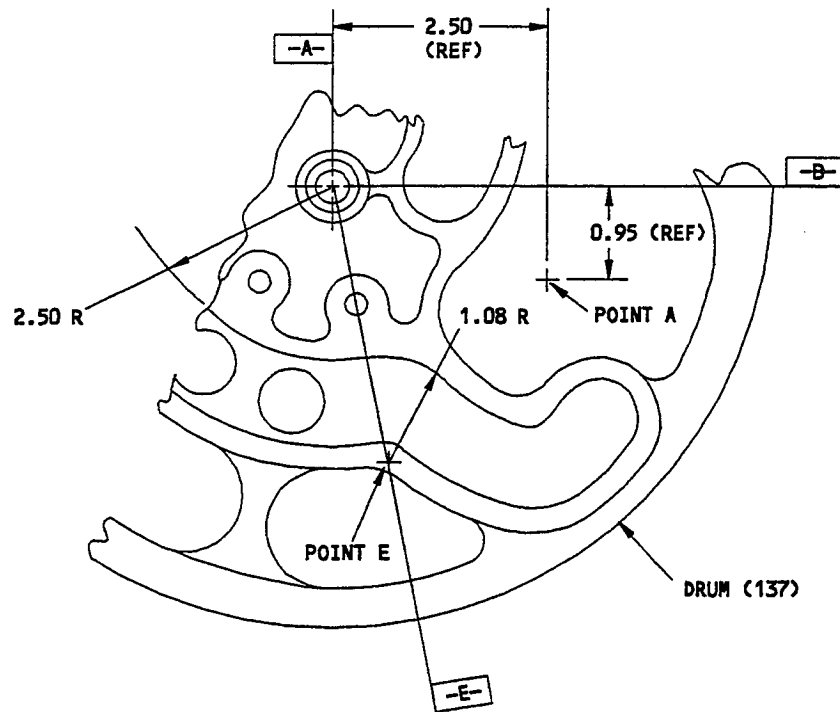
Repair with Insert -1
Figure 406 (Sheet 2)



- 3** NO GAP ALLOWED BETWEEN INSERT -1 AND THE DRUM AT THIS POINT
- 4** 0.03 GAP ALLOWED BETWEEN -1 INSERT AND THE DRUM AT THIS POINT
- 5** INSTALL HI-LOK FASTENERS BACB30FN6A3 AND COLLAR BACC30M6 WITH WET BMS 10-11, TYPE 1 PRIMER (F-20.06)

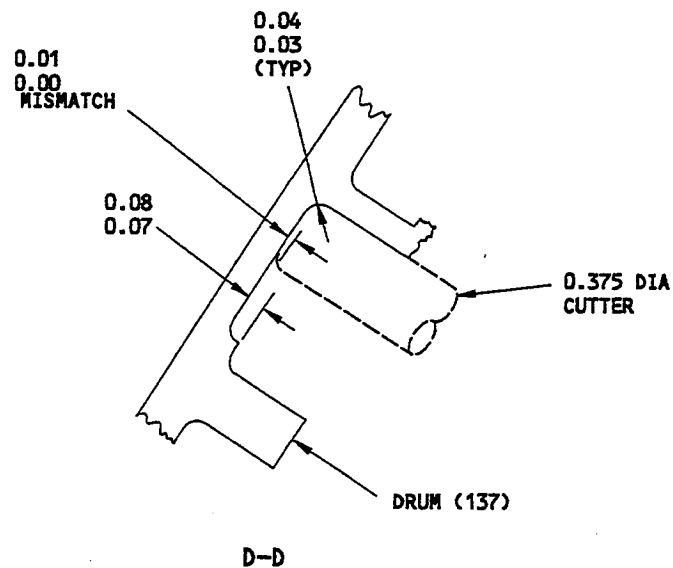
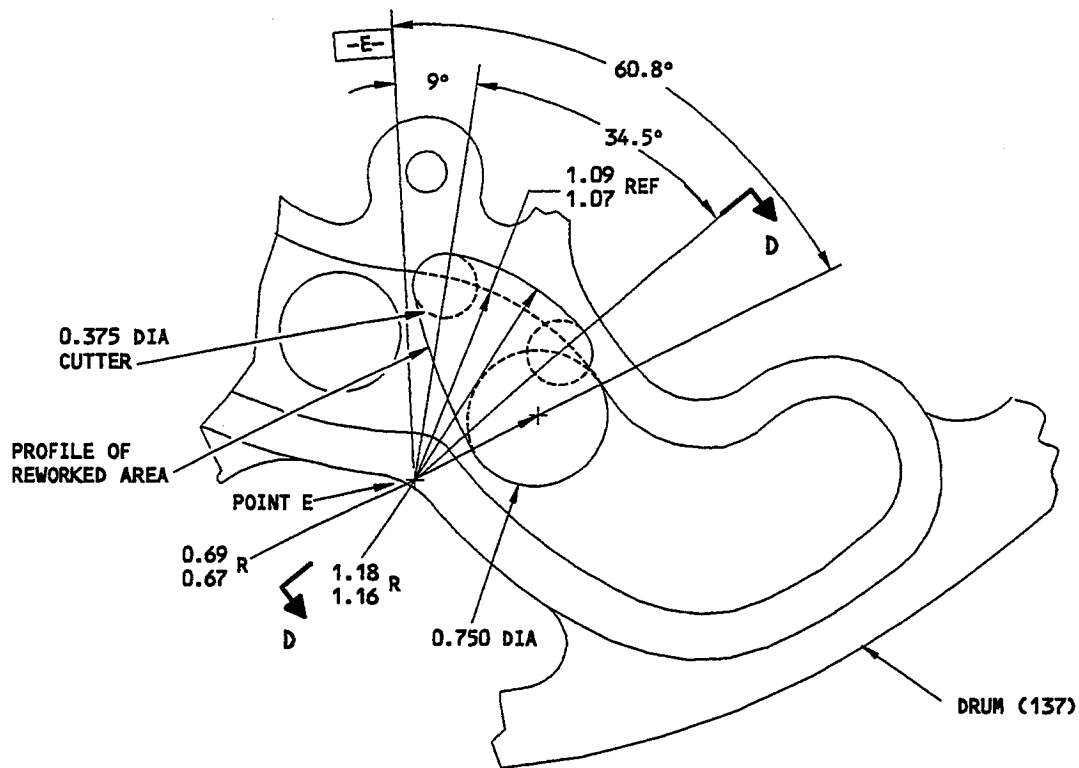
INSTALLATION OF INSERT -1

Repair with Insert -1
Figure 406 (Sheet 3)



DETAIL 2

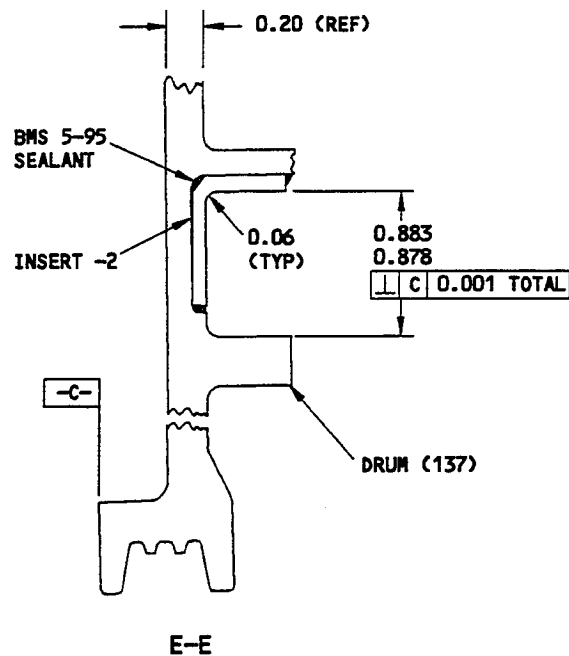
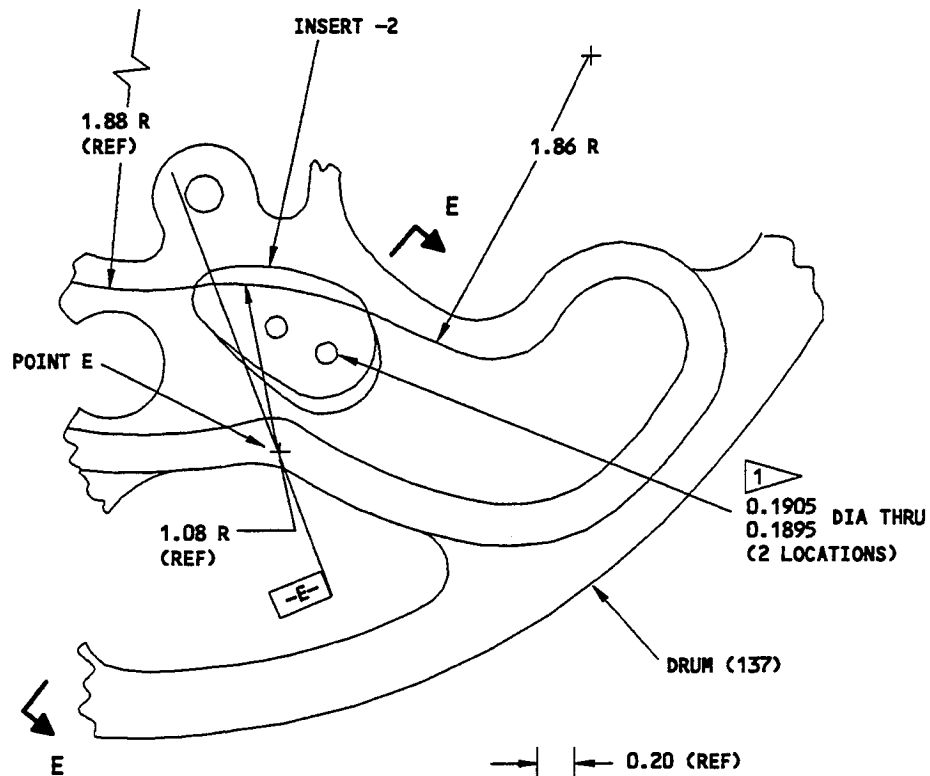
Repair with Insert -2
Figure 407 (Sheet 1)



Repair with Insert -2
Figure 407 (Sheet 2)

65-46436
65-71940
65-71969

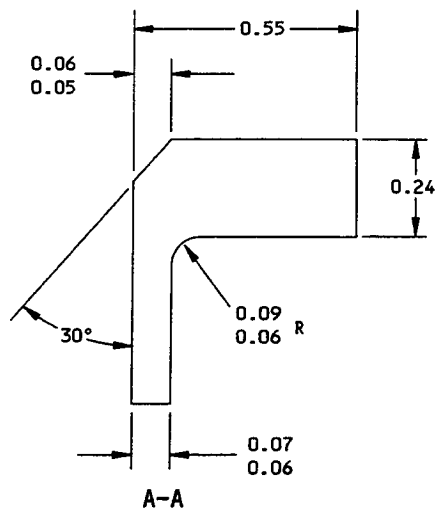
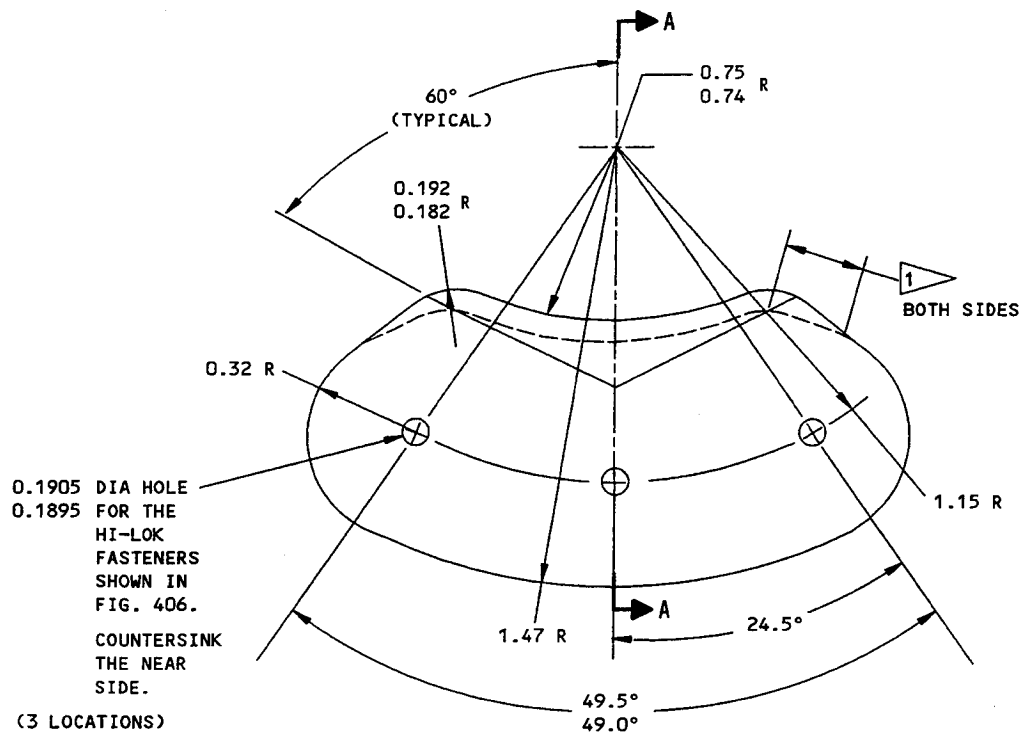
BOEING
COMMERCIAL JET
OVERHAUL MANUAL



1 INSTALL HI-LOK FASTENERS BACB30FN6A3 WITH COLLARS BACC30M6 WITH BMS 5-89 CORROSION INHIBITING ADHESIVE PRIMER (F-20.26)

INSTALLATION OF INSERT -2

Repair with Insert -2
Figure 407 (Sheet 3)



FINISH

CADMIUM PLATE AND APPLY ONE COAT OF
BMS 10-11 TYPE 1 PRIMER (F-16.01)

- 1 TAPER CHAMFER INTO 0.32 R OVER
THE LENGTH SHOWN
- 2 HOLE TO BE DRILLED AND REAMED WHEN
INSTALLED ON DRUM

BREAK CORNERS WITH 0.01-0.03 R
AROUND RERIPHERY

MATERIAL: 17-4PH CRES PER AMS 5643H
(180-200)

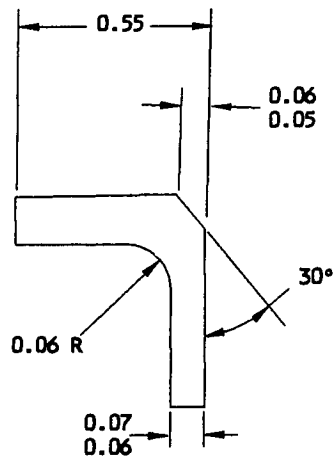
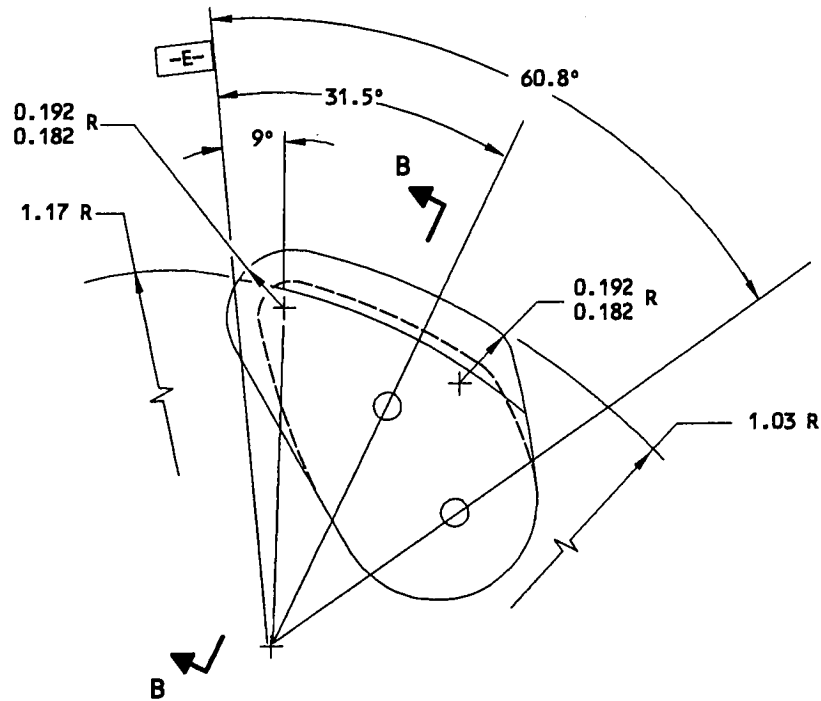
ALL DIMENSIONS ARE IN INCHES

INSERT -1

Insert Details
Figure 408 (Sheet 1)

65-46436
65-71940
65-71969

BOEING
COMMERCIAL JET
OVERHAUL MANUAL



B-B

FINISH

CADMIUM PLATE AND APPLY ONE COAT OF
BMS 10-11, TYPE 1 PRIMER (F-16.01)

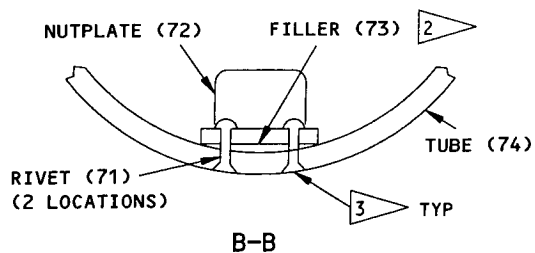
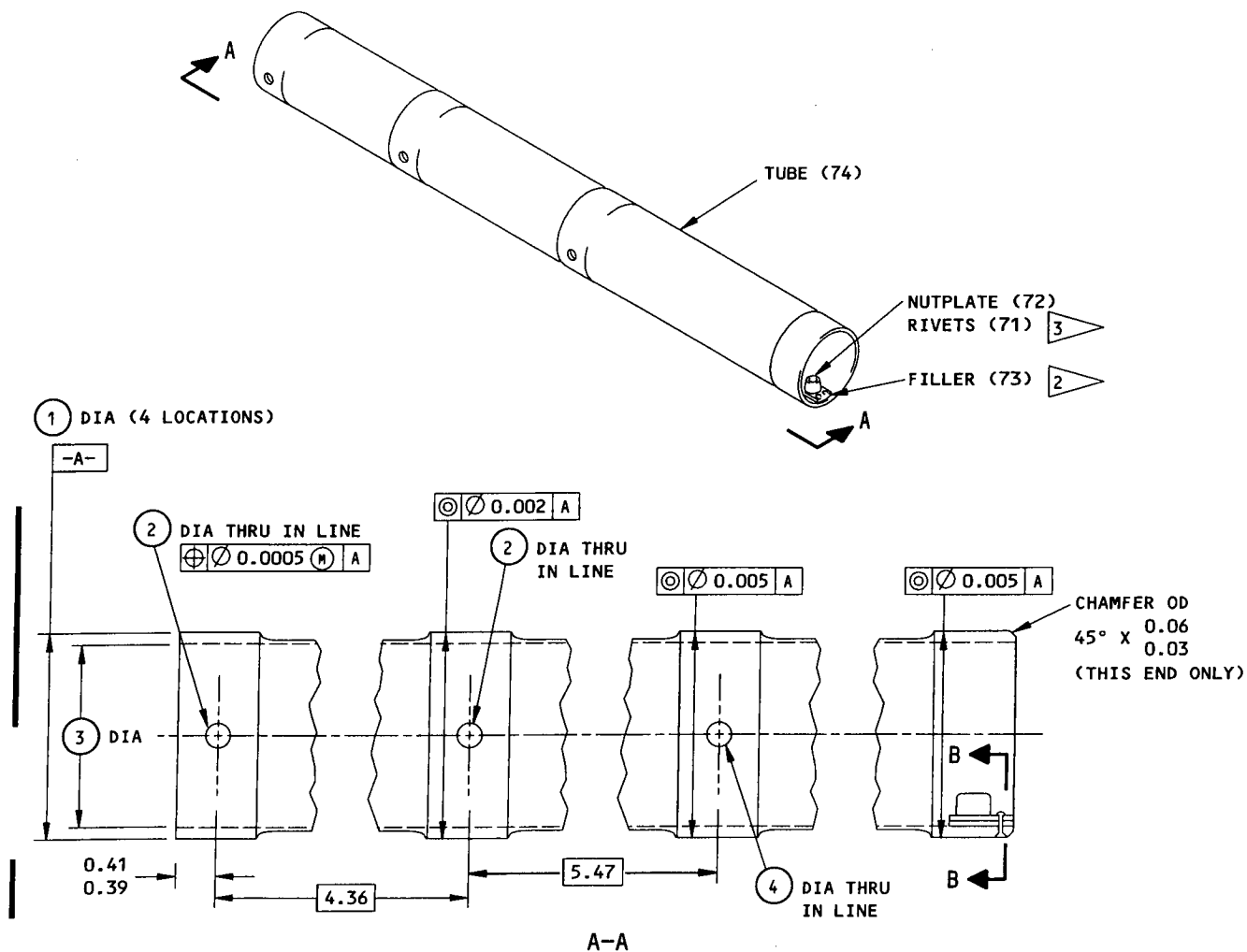
MATERIAL: 17-4PH CRES PER AMS 5643H
(180-200 KSI)

BREAK CORNERS WITH 0.01-0.03 R AROUND
PERIPHERY

ALL DIMENSIONS ARE IN INCHES

INSERT -2

Insert Details
Figure 408 (Sheet 2)



	1	2	3	4
DESIGN DIM	1.972 1.970	0.254 0.250	1.820 1.800	0.254 0.250
REPAIR LIMIT	1.950 1	0.313 1 0.3165 0.3125 4 0.3500 5	--	--

69-37815-1,-7,-8
Torque Tube Repair and Refinish
Figure 409 (Sheet 1)

REFINISH

FILLER (73) - CHROMIC ACID ANODIZE AND APPLY PRIMER, BMS 10-11, TYPE 1 (F-18.13)

TUBE (74) - CADMIUM PLATE AND APPLY PRIMER (F-16.01) ON OD. APPLY BMS 10-11, TYPE 1 PRIMER (F-20.03) ON ID.

- 1 LIMIT FOR SULFAMATE NICKEL PLATE BUILDUP (REF 20-42-09) AND MACHINE TO DESIGN DIMENSIONS AND FINISH.
- 2 INSTALL WITH BMS 5-95 SEALANT.
- 3 HEAD OF RIVET MUST NOT BE ABOVE TUBE OD SURFACE.
- 4 RANGE FOR INSTALLATION OF 1/16" OVERSIZE DIAMETER BOLT (NAS1105-360), WASHER (AN960-516), AND NUT (BACN10JD105).
- 5 LIMIT FOR INSTALLATION OF OVERSIZE REPAIR BUSHING.
- 6 IF REPAIR BUSHINGS AS SHOWN IN FIG. 416 ARE TO BE INSTALLED, THEN THIS CONTROL ALSO APPLIES TO THE BUSHING INNER DIAMETERS AFTER BUSHING ARE INSTALLED.

REPAIR

REF 1 THRU 5

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

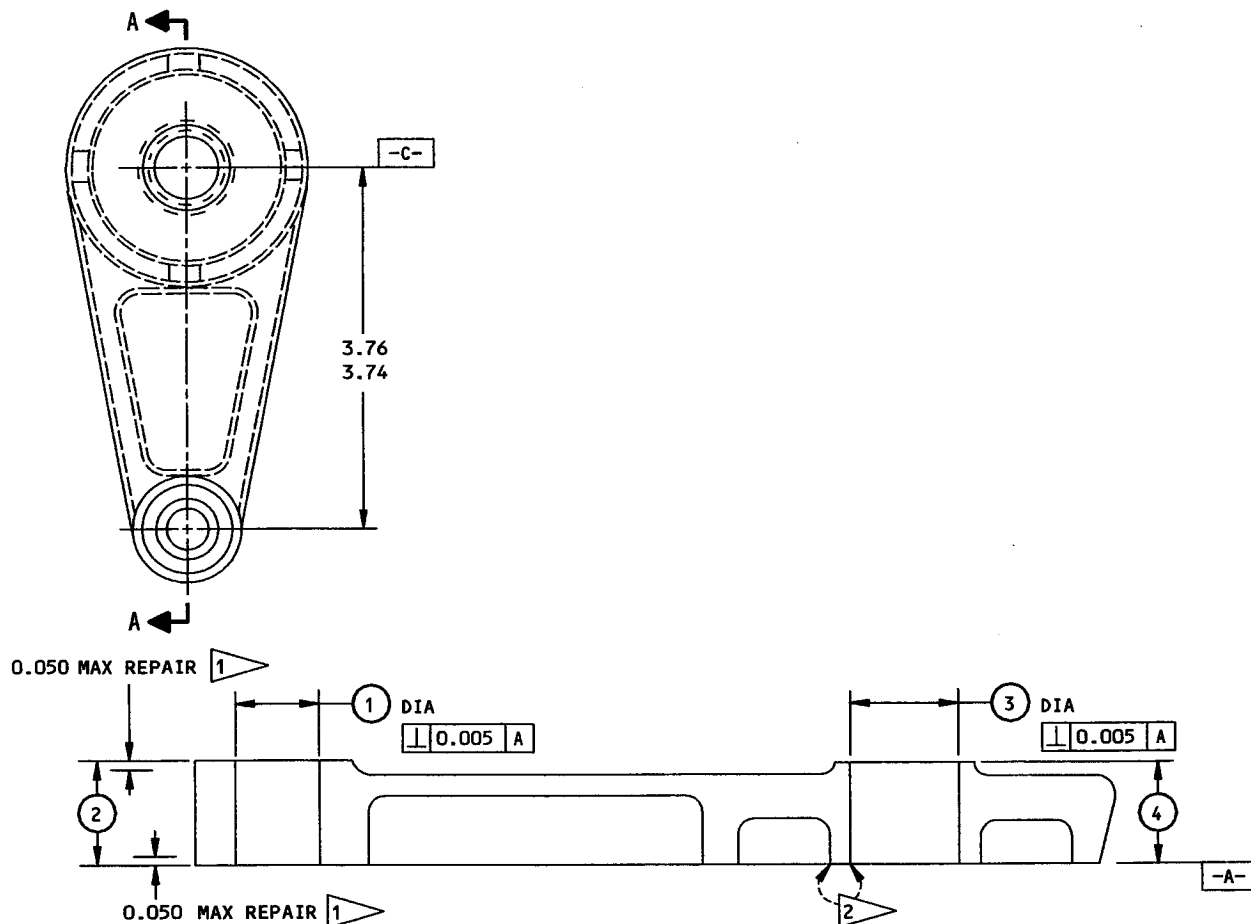
SHOT PEEN (REF 20-10-03): 0.016-0.033 SHOT SIZE
0.008 A2 INTENSITY

MATERIAL: FILLER (73) - AL ALLOY
TUBE (74) - 4330M STEEL, 180-200 KSI

ITEM NUMBERS REFER TO FIG. 1102

ALL DIMENSIONS ARE IN INCHES

69-37815-1,-7,-8
Torque Tube Repair and Refinish
Figure 409 (Sheet 2)



	1	2	3	4
DESIGN DIM	0.5003 0.4997	0.52 0.50	0.6254 0.6247	0.64 0.62
REPAIR LIMIT	—	0.46 1	—	—

REFINISH

CHROMIC ACID ANODIZE (F-17.19). APPLY PRIMER BMS 10-11, TYPE 1 (F-20.02) ALL OVER, BUT NOT IN BORES OR ON SPOTFACES. APPLY MORE PRIMER AS SHOWN BY 2

- 1 LIMIT FOR INSTALLATION OF REPAIR WASHER(S) (65-5558-6 ONLY)
- 2 APPLY ONE MORE LAYER OF PRIMER BMS 10-11, TYPE 1 TO THIS SURFACE

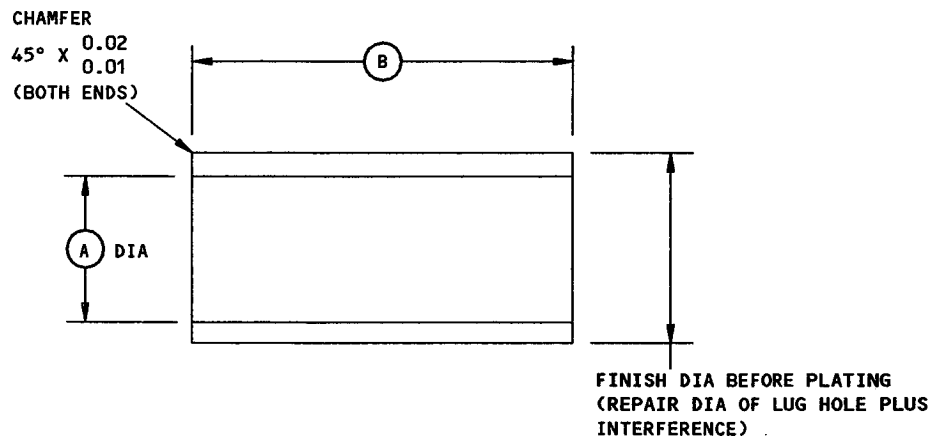
REPAIR

REF 1
125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: AL ALLOY
ALL DIMENSIONS ARE IN INCHES

CAM ARM (163, FIG. 1108)
65-55588-4,-6

Cam Arm Repair and Refinish
Figure 410



HOLE LOCATION	REPAIR FIG.	(A)	(B)	INTERFERENCE
FWD ATTACH	404	0.254 0.250	0.23 0.21 1	0.0015 0.0005
AFT ATTACH	404, 404A	0.316 0.313	1.01 1.00 1	0.0015 0.0005

1 ADJUST LENGTH OF SLEEVE TO FIT
FLUSH WITH OR 0.005 MAX BELOW
SURFACE OF LUG.

REPAIR

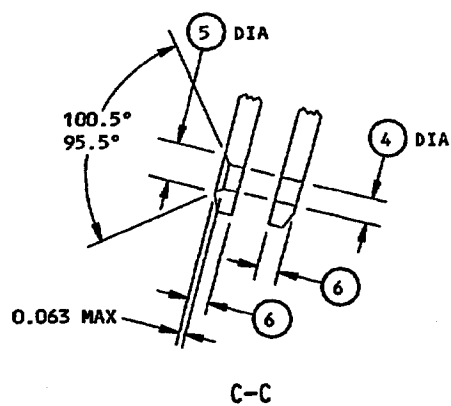
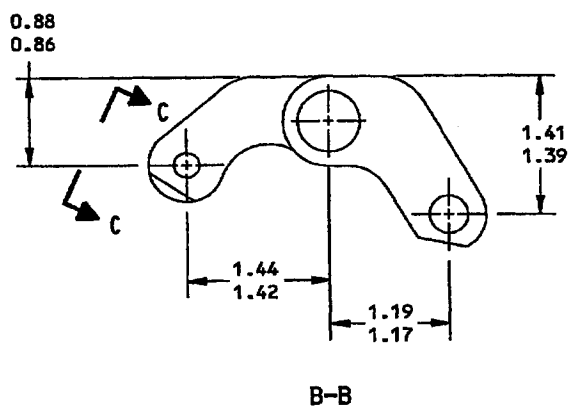
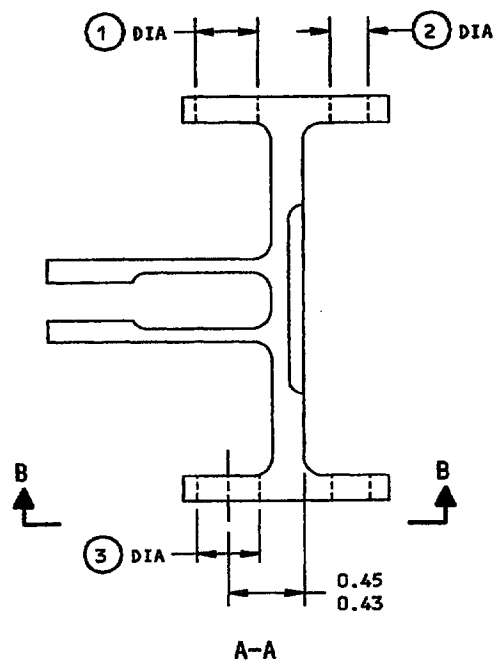
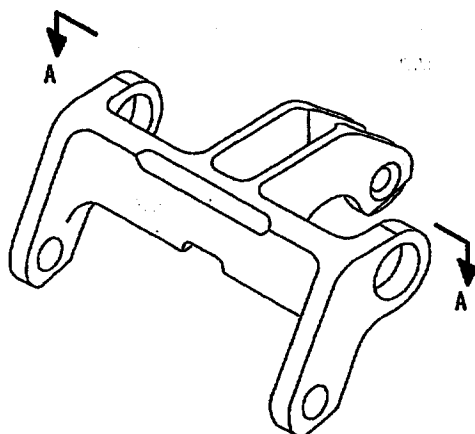
125/ ALL MACHINED SURFACES UNLESS SHOWN
DIFFERENTLY

CADMIUM PLATE (0.0003-0.0005 THICK, F-15.06)
(OPTIONAL ON INTERNAL SURFACES)

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

ALL DIMENSIONS ARE IN INCHES

Repair Bushing Details
Figure 411



69-35329-1
Toggle Repair and Refinish
Figure 412 (Sheet 1)

		①	②	③	④	⑤	⑥
69-35329-1	DESIGN DIM	0.6255 0.6248	0.378 0.375	0.6255 0.6248	0.2553 0.2513	0.420 0.390	0.21 0.19
	REPAIR LIMIT	---	---	---	0.2600 1 0.3160 2	---	---

REFINISH

69-35329-1 - CADMIUM PLATE AND APPLY PRIMER
BMS 10-11, TYPE 1 (F-16.01) BUT
NOT IN HOLES. APPLY ENAMEL
BMS 10-11, TYPE 2 (SRF-12.63)
BUT NOT IN HOLES.

65C33100-1 - CADMIUM PLATE AND APPLY PRIMER
BMS 10-11, TYPE 1 (F-16.01) BUT
NOT IN HOLES. APPLY ENAMEL
BMS 10-11, TYPE 2 (F-21.02) BUT
NOT IN HOLES.

65C33100-3,-4 - PASSIVATE (F-17.25) ALL OVER.

REPAIR

REF 1 2

125/ ALL MACHINED SURFACES UNLESS SHOWN
DIFFERENTLY

MATERIAL: 69-35329-1, 65C33100-1:
4340 STEEL, 160-180 KSI

MATERIAL: 65C33100-3,-4:
15-5 PH, 180-200 KSI

ALL DIMENSIONS ARE IN INCHES

1 RESTORATION TO DESIGN DIMENSION NOT
REQUIRED

2 LIMIT FOR INSTALLATION OF REPAIR BUSHINGS
(FIG. 413)

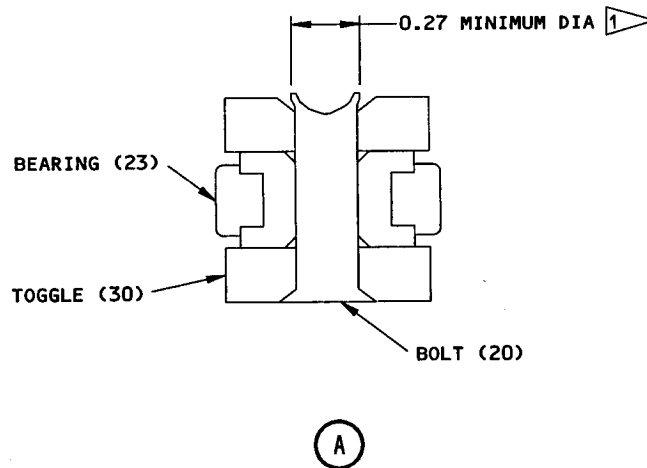
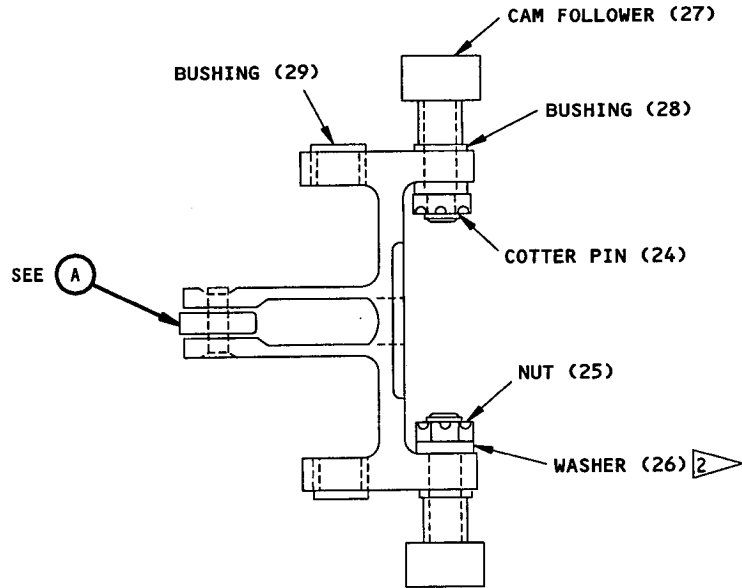
65C33100-1
69-35329-1

Toggle Repair and Refinish
Figure 412 (Sheet 2)

65-46436
65-71940
65-71969

DASH NUMBERS LIMITED

BOEING
OVERHAUL MANUAL

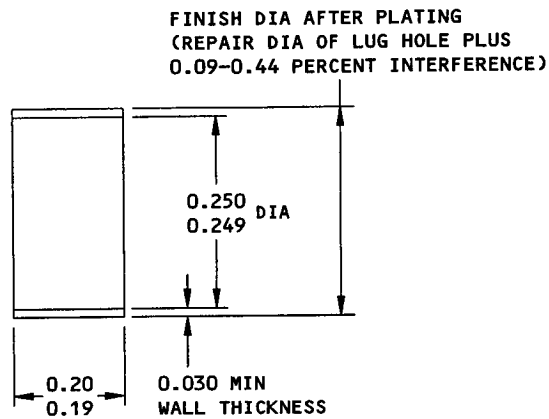


1 STAKE THE HOLLOW END OF THE PIN TO THE MINIMUM DIAMETER AS SHOWN.

2 IN ADDITION TO WASHER (26), USE NAS1149C0632R, IF AND AS REQUIRED TO PROVIDE COTTER PIN ENGAGEMENT.

69-35336-3

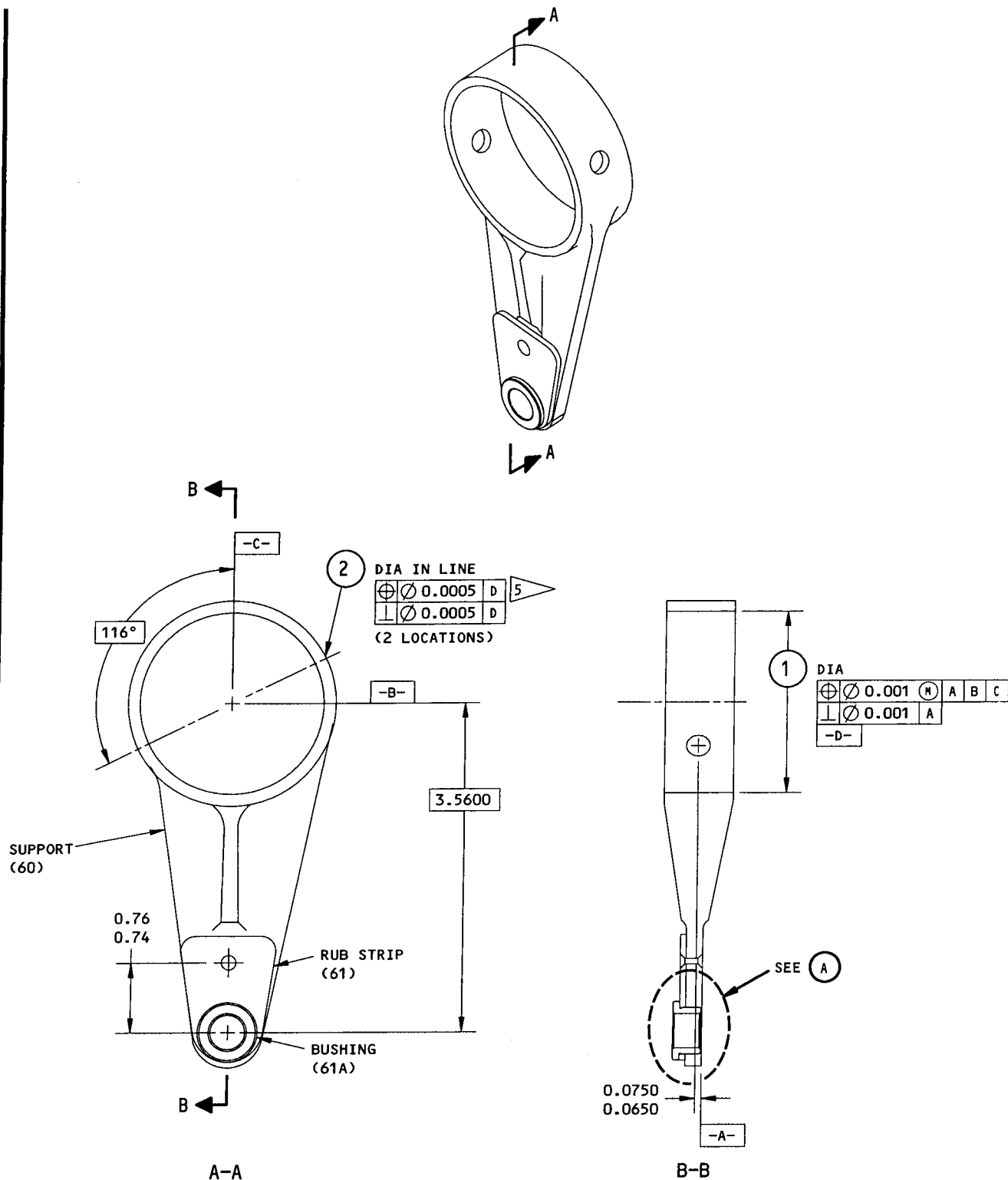
Toggle Assembly Bearing and Bushing Replacement
Figure 412A



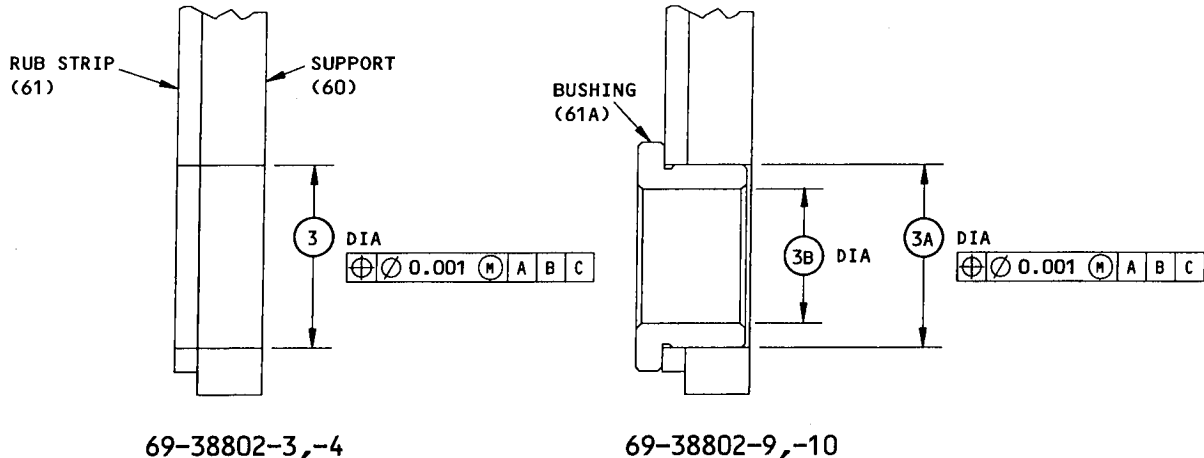
125/ ALL MACHINED SURFACES
BREAK SHARP EDGES 0.01-0.02R
FINISH: CADMIUM PLATE (F-15.06)
MATERIAL: 15-5PH OR 17-4PH CRES
(180-200 KSI)
ALL DIMENSIONS ARE IN INCHES

HOLE LOCATION (4) FIG. 412

Repair Bushing Details
Figure 413



69-38802-3,-4,-9,-10
Support Repair and Refinish
Figure 414 (Sheet 1)



(A)

	(1)	(2)	(3) 1	(3A) 2	(3B) 2
DESIGN DIM	1.978 1.976	0.254 0.250	0.379 0.375	0.5003 0.4993	0.379 0.375
REPAIR LIMIT	---	0.3165 3 0.3125 3 0.3500 4	---	---	---

REFINISH

CADMIUM-TITANIUM PLATE (F-15.01) (0.0003-0.0005 THICK ON DIAMETER (1)). APPLY BMS 10-11, TYPE 1 PRIMER (F-20.02). BUT NO PRIMER IN HOLES

- 1 FOR 69-38802-3,-4
- 2 FOR 69-38802-9,-10
- 3 LIMIT FOR INSTALLATION OF 1/16 OVERSIZE DIAMETER BOLT (NAS1105-36D), WASHER (AN960-516), AND NUT (BACH10JD105)
- 4 LIMIT FOR INSTALLATION OF REPAIR BUSHING AND STANDARD BOLT
- 5 IF REPAIR BUSHINGS AS SHOWN IN FIG. 415 ARE TO BE INSTALLED, THEN THIS CONTROL ALSO APPLIES TO THE BUSHING INNER DIAMETERS AFTER BUSHINGS ARE INSTALLED

REPAIR

REF 3 4

125/ MACHINE FINISH

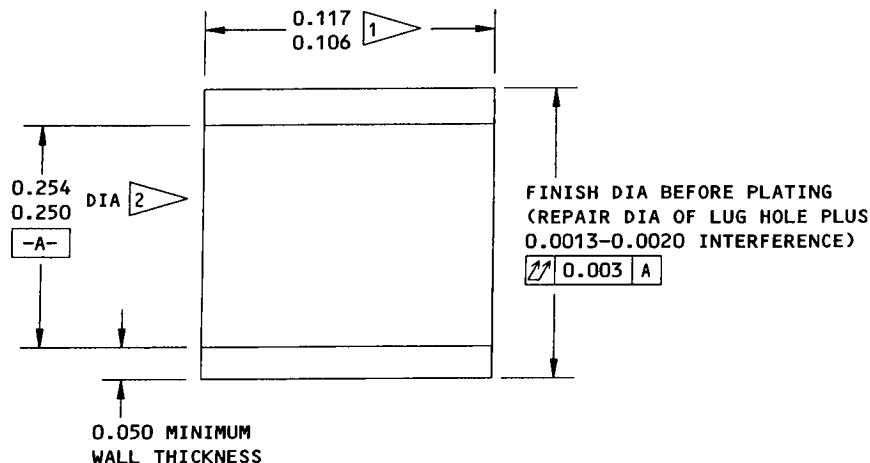
SHOT PEEN (SOPM 20-10-03) BUT NOT IN HOLES:
RC 55-65 SHOT HEAT TREAT
0.017-0.046 SHOT SIZE
0.008-0.013 A2 INTENSITY

MATERIAL: 4330M STEEL, 220-240 KSI

DIMENSIONS APPLY AFTER PLATING

ALL DIMENSIONS ARE IN INCHES

69-38802-3,-4,-9,-10
Support Repair and Refinish
Figure 414 (Sheet 2)



- 1 ADJUST THE LENGTH TO FIT FLUSH WITH THE SURFACE OR 0.010 MAXIMUM BELOW THE SURFACE
- 2 IF NECESSARY, YOU CAN LEAVE THIS DIAMETER UNDERSIZE IN ORDER TO MEET THE POSITIONAL TOLERANCE AFTER INSTALLATION, AS SHOWN IN FIG. 414.

REPAIR

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK SHARP EDGES 0.01-0.02 R

MAGNETIC PARTICLE CHECK (SOPM 20-20-01)

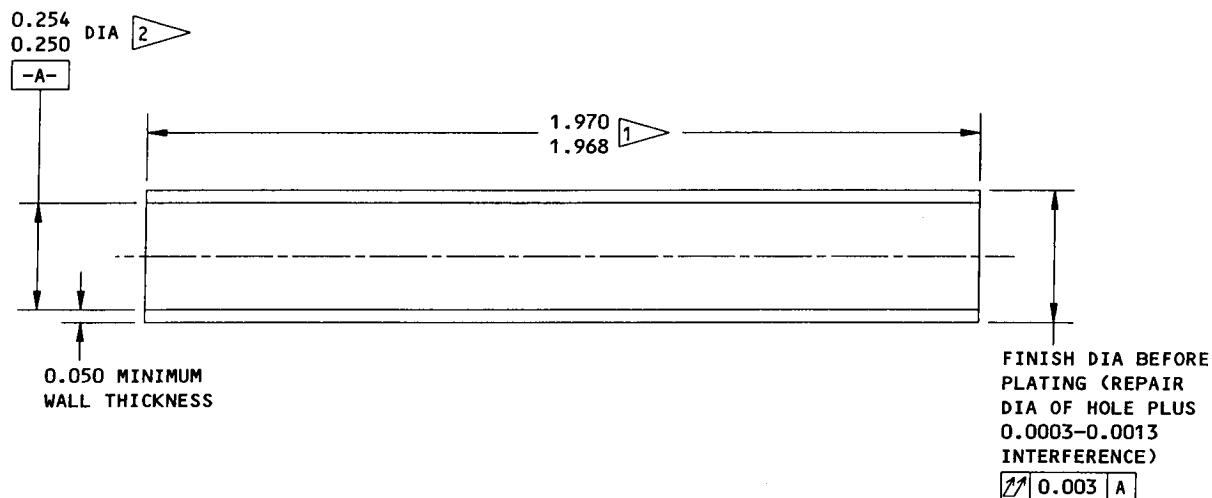
CADMIUM PLATE (0.0003-0.0005 THICK, F-15.06)(OPTIONAL ON INTERNAL SURFACES)

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

DIMENSIONS APPLY BEFORE PLATING

ALL DIMENSIONS ARE IN INCHES

Repair Bushing Details
Figure 415



- 1 ADJUST THE LENGTH TO FIT FLUSH WITH THE SURFACE OR 0.010 MAXIMUM BELOW THE SURFACE
- 2 IF NECESSARY, YOU CAN LEAVE THIS DIAMETER UNDERSIZE IN ORDER TO MEET THE POSITIONAL TOLERANCE AFTER INSTALLATION, AS SHOWN IN FIG. 601

125/ MACHINE FINISH
BREAK SHARP EDGES 0.01-0.02R
PENETRANT CHECK (SOPM 20-20-02)
CADMIUM PLATE (0.0003-0.0005 THICK, F-15.06)
BUT NOT ON INSIDE DIAMETER
MATERIAL: 15-5PH OR 17-4PH CRES, 180-200 KSI
DIMENSIONS APPLY BEFORE PLATING
ALL DIMENSIONS ARE IN INCHES

HOLE LOCATION 2 FIG. 409 - REPAIR BUSHING

Repair Bushing Details
Figure 416

ASSEMBLY

1. Build up mid flap.

A. Install outboard carriage (Fig. 1106).

NOTE: In steps (1) thru (13) install all bolts wet with BMS 5-95 sealant.

- (1) Locate fail-safe support (125). Attach with bolts (124) and collars (123).
- (2) Locate torque tube (120), and seat in support (125).
- (3) Locate washers (115 and 116) inside torque tube and attach torque tube to flap structure with bolts (119), washers (118), and nuts (117).
- (4) Locate fail-safe support (114) inside torque tube. Install bolts (113) and collars (112).
- (5) Locate fail-safe tube assembly (111) and align holes for bolt (110).
- (6) Coat bolt (110) with wet sealant, and install with head facing aft. Install washer (109) and nut (108). Tighten nut to torque range of 5 to 10 pound-inches and install cotter pin (107).
- (7) Locate carriage assemblies (2 and 8) on end of torque tube.
- (8) Attach plate (73) to carriages with bolts (72), washers (71), and nuts (70).
- (9) Locate bumper support (74). Align holes in bumper support, torque tube, and carriage (8). Install bolts (105 and 106), washers (103 and 104), and nuts (102).
- (10) Locate support assembly (99) inside torque tube and install bolts (96, 97 and 98), washers (94 and 95), and nuts (93).
- (11) Locate washers (91 and 92) inside torque tube and install bolts (88, 89 and 90), washers (86 and 87), and nuts (85).
- (12) Install gimbal support assembly (84) inside torque tube, and install bolts (81, 82 and 83), washers (80), and nuts (79). If you use a new support, increase the bore diameter to 2.2700-2.2705 inches. Chemical treat (F-2.940 per SOPM 20-41-01) and apply primer, BMS 10-11, Type 1 to the bare surfaces.
- (13) Attach bumper plate (75) to bumper support (74) with bolts (76).

- (14) Assemble roller assembly (58).
- (a) Coat eccentric bushing (60) with grease, Specification MIL-G-23827. Install bushing in retainer (59).
 - (b) Insert bolt assembly (65) in eccentric bushing and install washers (68 and 69).
 - (c) Install bearing (61) and nut (64). Tighten nut within torque range of 5 to 15 pound-inches and loosely install cotter pin (63).
- NOTE: Do not tighten nut (64) to full torque (200 to 500 pound-inches). Eccentric bushing must be adjusted when flap is installed in aircraft.
- (d) Install spring pin (62) with wet primer, Specification BMS 10-11, Type 1.
- (15) Assemble roller assembly (46).
- (a) Coat eccentric bushing (48) with grease, Specification MIL-G-23827. Install bushing in retainer (47).
 - (b) Insert bolt assembly (53) in eccentric bushing and install washers (56 and 57).
 - (c) Install bearing (49) and nut (52). Tighten nut within torque range of 0 to 10 pound-inches and loosely install cotter pin (51).
- NOTE: Do not tighten nut (52) to full torque (200 to 500 pound-inches). Eccentric bushing must be adjusted when flap is installed in aircraft.
- (d) Install spring pin (50) with wet primer, Specification BMS 10-11, Type 1.
- (16) Apply a brush coat of wet BMS 5-95 sealant in the bore of the carriage assembly (2). Install roller assembly (46) in carriage assembly (2) with two washers (45) and bolts (44).
- (17) Tighten bolts (44) within torque range of 30 to 40 pound-inches. Install lockwire between bolts using double-twist method.
- (18) Apply a brush coat of wet BMS 5-95 sealant in the bore of the carriage assembly (8). Install roller assembly (58) in carriage assembly (8) with two washers (45) and bolts (44).
- (19) Tighten bolts (44) within torque range of 30 to 40 pound-inches. Install lockwire between bolts using double-twist method.

- (20) Install bearings (41) with washers (42 and 43), bolt assemblies (38), and nuts (37).

NOTE: Use washers (43) only as necessary to align holes in bolt for cotter pin. Adjust thickness of washer by removing laminations. Coat washer with wet sealant, Specification BMS 5-95, after delamination.

- (21) Tighten nuts (37) within torque range of 200 to 500 pound-inches and install cotter pins (36).

- (22) Install barrel nut (23) and retainer (22). Locate crossbeam (25) and attach with bolts (24).

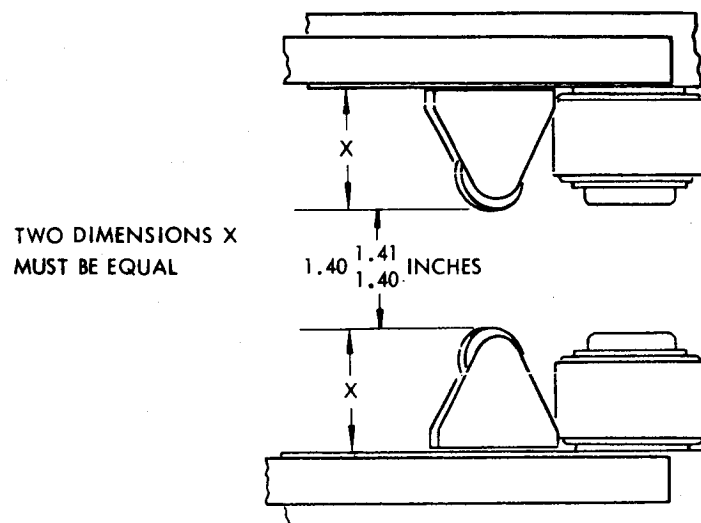
NOTE: Install bolts (24) with wet sealant, Specification BMS 5-95.

- (23) Install lockwire between each bolt and adjacent lug on crossbeam. Use double-twist method.

- (24) Locate roller assemblies (28) and shims (35). Locate with lubrication fitting (34) down. Adjust position of roller assemblies to dimensions given in Fig. 501.

NOTE: Adjust position of roller assemblies by removing laminations from shims (35). Coat shims with wet sealant, Specification BMS 5-95, after delamination.

- (25) Lubricate bearing (30), after installation, with grease, Specification MIL-G-23827.



Rigging-Carriage Rollers
Figure 501

- (26) Locate cams (20 and 21). Coat bolts (17, 18, and 19) with wet sealant, Specification BMS 5-95, and install with washers (16), and nuts (15).
- (27) Tighten nuts within torque range of 10 to 30 pound-inches and install cotter pins (14).

B. Install inboard carriage (Fig. 1107).

NOTE: In steps (1) thru (11), install all bolts with wet sealant, Specification BMS 5-95.

- (1) Locate tube support (126) in flap and attach with bolts (125), washers (124), and nuts (123).
- (2) Locate torque tube (122), and seat in tube support.
- (3) Locate washers (120 and 121) inside torque tube. Install bolts (119), washers (118), and nuts (117) through washers, torque tube, and support.
- (4) Locate washers (115 and 116) inside torque tube and install bolts (114), washers (113), and nuts (112).
- (5) Locate fail-safe support (111) inside torque tube and attach with bolts (110), washers (109), and nuts (108).
- (6) Locate fail-safe tube assembly (107) and align holes for bolt (106). Install bolt (106), washer (105), and nut (104). Tighten nut within torque range of 5 to 15 pound-inches and install cotter pin (103).
- (7) Locate carriage assembly (1) and plate (102). Install bolts (95 and 96), washers (94), and nuts (93).
- (8) Locate support assembly (90). Install bolts (88 and 89), washers (87), and nuts (86).
- (9) Locate carriage assembly (7). Locate strap washers (84 and 85) inside torque tube. Install bolts (81, 82, and 83), washers (80), and nuts (79).
- (9A) Apply gray gloss enamel BMS 10-60 (SRF-14.9813) to exposed OD surface of torque tube (122).
- (10) Locate gimbal bearing support assembly (76). Install bolts (73, 74, and 75), washers (72), and nuts (71).
- (11) Install bolt (100), washer (99), and nut (98). Tighten nut within torque range of 5 to 30 pound-inches and install cotter pin (97).
- (12) Deleted.

(13) Assemble roller assembly (54).

- (a) Coat eccentric bushing (56) with grease, Specification MIL-G-23827. Install bushing in retainer (55).
- (b) Insert bolt assembly (61) in eccentric bushing and install washers (64 and 65).
- (c) Install bearing (57) and nut (60). Tighten nut within torque range of 5 to 15 pound-inches, and loosely install cotter pin (59).

NOTE: Do not tighten nut (60) to full torque (200 to 500 pound-inches). Eccentric bushing must be adjusted when flap is installed in aircraft.

- (d) Install spring pin (58) with wet sealant, Specification BMS 5-95.

(14) Assemble roller assembly (42).

- (a) Coat eccentric bushing (44) with grease, Specification MIL-G-23827. Install bushing in retainer (43).
- (b) Insert bolt assembly (49) in eccentric bushing and install washers (52 and 53).
- (c) Install bearing (45) and nut (48). Tighten nut within torque range of 5 to 15 pound-inches, and loosely install cotter pin (47).

NOTE: Do not tighten nut (48) to full torque (200 to 500 pound-inches). Eccentric bushing must be adjusted when flap is installed in aircraft.

- (d) Install spring pin (46) with wet sealant, Specification BMS 5-95.

(15) Apply a brush coat of wet BMS 5-95 sealant in bore of the carriage (9). Locate roller assembly (54) and attach with two washers (41) and bolts (40).

(16) Tighten bolts (40) within torque range of 30 to 40 pound-inches and install lockwire between bolts using double-twist method.

(17) Apply a brush coat of wet BMS 5-95 sealant in bore of the carriage (3). Locate roller assembly (42) and attach with two washers (41) and bolts (40).

- (18) Tighten bolts (40) within torque range of 30 to 40 pound-inches and install lockwire between bolts using double-twist method.
- (19) Install bearings (37) with washers (38 and 39), bolt assemblies (34), and nuts (33).

NOTE: Use washers (39) as necessary to align hole in bolt for cotter pin. Adjust thickness of washers by removing lamination. Coat washers with wet sealant, Specification BMS 5-95, after delamination.

CAUTION: INSTALL COTTER PINS SO THEY WILL NOT PROTRUDE BEYOND ENDS OF BOLTS.

- (20) Tighten nuts (33) within torque range of 200 to 500 pound-inches and install cotter pins (32).
- (21) Assemble bearing (26) in bracket (25) with bolt assembly (28) and spring pin (27).
- (22) Locate roller assemblies (24) and shims (31). Adjust position of roller assemblies to dimensions given in Fig. 501 by removing laminations from shims (31). Coat shims with wet sealant, Specification BMS 5-95, after delamination. Lubricate bearing (26) with grease, Specification MIL-G-23827, after installation.
- (23) Attach roller assemblies and shims with washers (23) and bolts (21 and 22). Install bolts with wet sealant, Specification BMS 5-95.

NOTE: Tighten inboard bolts (21) and the rear outboard bolt (21) within torque range of 30 to 40 pound-inches. Do not tighten forward outboard bolt (22). This bolt also attaches pulley support which is installed later. Install lockwire in a continuous, double-twist loop between inside bolts.

- (24) Coat bolts (16, 17, and 18) with wet sealant, Specification BMS 5-95. Locate cams (19 and 20) and attach with bolts (16, 17, and 18), washers (15), and nuts (14).
- (25) Tighten nuts within torque range of 10 to 30 pound-inches and install cotter pins (13).

C. Install track guides and tracks (Fig. 1109)

NOTE: In the following procedure, coat all bolts with corrosion preventive compound, Specification MIL-C-11796, class 3, before installation.

BOEING
COMMERCIAL JET
OVERHAUL MANUAL

- (1) Locate bracket assemblies (60 and 63) and deflector (70) between inboard fore flap track ribs. Attach with washers (68), screws (69), and bolts (66 and 67). Remove 0.003-inch laminations from shims (71, 72) if and as required. Maximum permissible gap 0.005 inch prior to bolt (66) installation. Apply primer BMS 10-11, type 1, to delaminated shim and install wet or dry.

NOTE: No deviation in grip length of lower panel bolts (66) is permitted.

- (2) Install bearing (46) in each bracket assembly (60 and 63) with washers (49), nut (48), and cotter pin (47).
- (3) Locate bracket assemblies (50 and 53) between outboard fore flap track ribs. Attach with washers (58), screws (59), and bolts (56 and 57). Remove 0.003-inch laminations from shims (71, 72) if and as required. Maximum permissible gap 0.005 inch prior to bolt (56) installation. Apply primer BMS 10-11, type 1, to delaminated shim and install wet or dry.

NOTE: No deviation in grip length of lower panel bolts (56) is permitted.

- (4) Install bearing (46) in each bracket assembly (50 and 53) with washers (49), nut (48), and cotter pin (47).
- (5) Install bearing (36) between center fore flap track ribs. Attach with bolt assembly (41), washers (39 and 40), and nut (38).
- (6) Tighten nut (38) within torque range of 95 to 110 pound-inches. Install cotter pin (37).
- (7) Locate support assembly (31), and attach with bolts (34 and 35), washers (33), and nuts (32).
- (8) Locate support assembly (26), and attach with bolts (30), washers (29), and nuts (28).
- (9) Tighten nuts (28) within torque range of 100 to 140 pound-inches. Install cotter pins (27).
- (10) Coat shaft of bearing (25) with corrosion preventive compound, Specification MIL-C-11796, class 3. Install bearing with washer (24) and nut (23).
- (11) Tighten nut (23) within torque range of 60 to 85 pound-inches. Install cotter pin (22).
- (12) Assemble plate (18), boss (17), bearing (16), washer (15), nut (14), and cotter pin (13) to make up roller assembly (12).

OVERHAUL MANUAL

- (13) Locate roller assembly (12) in flap, and attach with bolt (21), washer (20), and nut (19).
- (14) Slide tracks (113 and 114, figure 1105) through openings in leading edge of mid flap. Position bearings in tracks (Fig. 503).
- (15) Install bolt (4, Fig. 1109), washer (3), two spacers (2), and nut (1) on each track (Fig. 503).

CAUTION: PLACE WASHER (3) BENEATH HEAD OF BOLT OR NUT AS NECESSARY TO KEEP BOTH ENDS OF BOLT (4) BETWEEN 0.00 AND 0.08 INCH INSIDE EDGES OF TRACK.

- (16) Install cylindrical nut (9) and retainer (8) at each aft flap carriage track location.
- (17) Locate track (5) and shim (11) at each aft flap carriage track location. Attach with bolts (6 and 10) and washers (7). Install bolts, with wet primer, Specification BMS 10-11, type 1, finger-tight. Measure gap between track and shim. Tighten bolts.
- (18) Use same shims removed during disassembly. Remove laminations from new shims to reduce thickness to dimension recorded during disassembly, if replacement is necessary. Coat shims with primer, Specification BMS 10-11, type 1, after delamination.

NOTE: Maximum allowable gap after shimming is 0.000 to 0.005 inch. Maximum allowable shim thickness is 0.06 inch.

D. Install aft flap actuating mechanism (Fig. 1108).

NOTE: Coat all bolts with corrosion preventive compound, Specification MIL-C-11796, class 3, before installation, unless otherwise instructed.

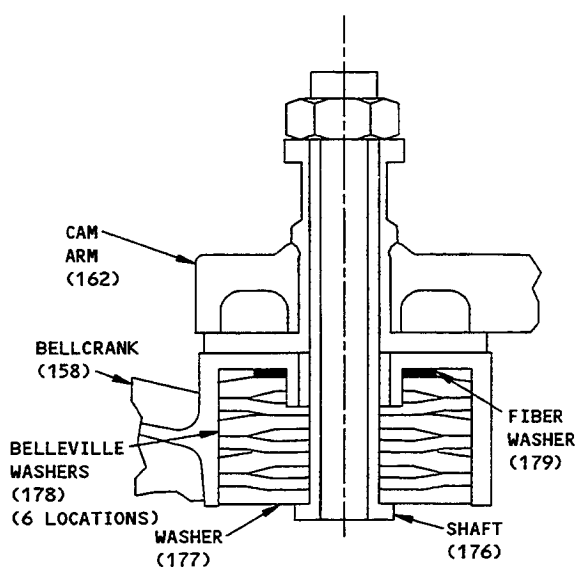
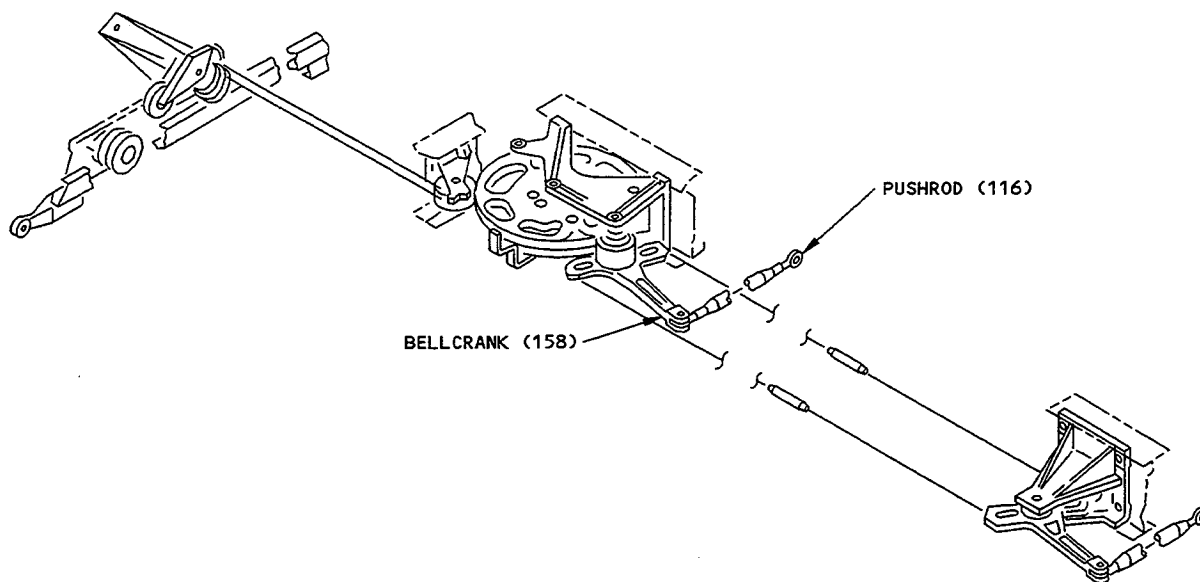
- (1) Locate bracket assembly (184) in flap. Attach with bolts (180, 181, and 183), and washers (182).
- (2) Install bellcrank assembly (194). Attach with bolt (192), washer (191), and nut (190). Tighten nut within torque range of 5 to 10 pound-inches and install cotter pin (189).
- (3) Assemble rod end bearing (202), key (204), and nut (203) on pushrod assembly (199). Adjust dimension between bearing centerlines to 19.56 inches.

NOTE: This is an initial adjustment. Final adjustment will be made when aft flap assembly is installed on mid flap assembly.

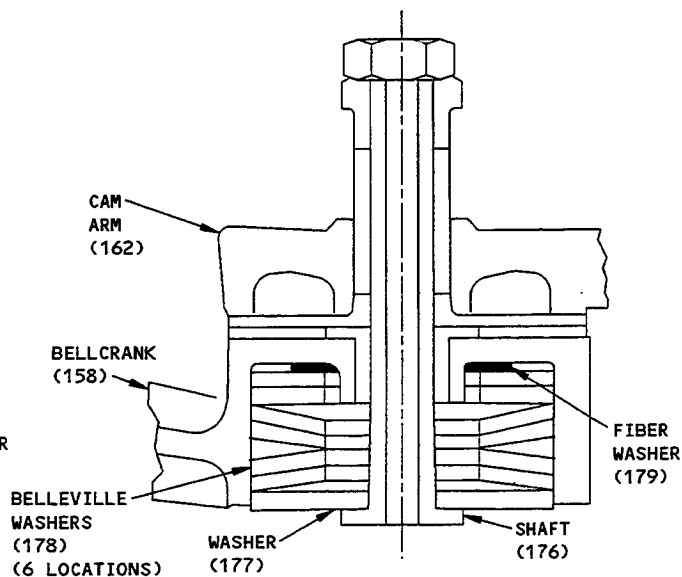
- (4) Install pushrod assembly (199) with bolt (208), washer (207), and nut (206).
 - (5) Tighten nut (206) to 5-10 pound-inches. Install cotter pin (205). Install lockwire by the double-twist method between head of bolt (208) and the hole in the arm of the clevis on the bellcrank assembly.
 - (6) Connect drum assembly (136) and spindle assembly (139) with bolts (135), washers (130, 134), and nuts (133). Put washers (130) under nuts. Put washers (134) under heads of bolts.
 - (7) Apply a layer of corrosion preventive compound, MIL-C-11796, class 3 to bearing (169) and install it on cam arm assembly (162). Attach with washer (167), nut (166), and cotter pin (165). On cam arm assembly (162, 65-55588-8), attach bearing (169) with key washer (167) and nut (166, AN316-6R) and tighten the nut to 95-110 lb-in.
 - (8) Assemble bellcrank assembly (158) and cam arm assembly (162) with clutch components as follows:
 - (a) Put fiber washer (179) inside the housing of the bellcrank assembly.
 - (b) Lightly lubricate Belleville washers (178) with MIL-G-23827 grease and install in housing. If the Belleville washers are 69-42385-1, put them together in three groups of two washers, with the concave faces of each group together as shown. If the Belleville washers are 69-42385-2, put them together in three groups of two washers, with the concave face of one washer against the convex surface of the other in each group, as shown. (Fig. 501A).
 - (c) Put washer (177) on top of Belleville washers and put shaft (176) through washers and housing. On assemblies Post SB 27-1030, be sure to install shaft (176, 69-42386-2) with the keyslot in the direction of the arm of bellcrank (159).
 - (d) Put clutch disks (174 and 175) on shaft.
 - (e) Install cam arm assembly (162).
- CAUTION:** AS YOU TURN NUT (170) ONTO SHAFT (176), MAKE SURE THE LOWER END OF LOCK (171) ENGAGES THE SLOT IN SPACER (172) OR THE PARTS COULD COME APART.
- (f) Install washer (173), if applicable, spacer (172), nut (170), and lock (171) on shaft (176). Install washer (173) with its teflon face toward spacer (172).
 - (9) Install stop (157) in bracket assembly (148) with washer (156) and bolt (155).

65-46436
65-71940
65-71969
DASH NUMBERS LIMITED

BOEING
COMMERCIAL JET
OVERHAUL MANUAL



CONFIGURATION WITH 69-42385-1
BELLEVILLE WASHERS (178)
A-A



CONFIGURATION WITH 69-42385-2
BELLEVILLE WASHERS (178)
A-A

ITEM NUMBERS REFER TO FIG. 1108

Belleville Washer Installations
Figure 501A

- (10) Install drum assembly (136), spindle assembly (139), and bellcrank assembly (158) with clutch and cam arm assembly (162) in bracket assembly (148). Use washers (130, 145) as necessary to get the gap shown in Fig. 501B. Within these limits, adjust the washers to align the upper cable groove of drum (137) and the cable groove of pulley (83) in the same plane.
- (11) Tighten bolts (132, 147), washers (129, 130, 144, 145), washers (131, 146), nuts (128, 143), and cotter pins (127, 142). Put washers (131, 146) under the heads of the bolts. Install washers (129, 130) as necessary under nut (128). Install washers (144, 145) as necessary under nut (143).
- (12) Adjust braking point of clutch plates as follows (Fig. 502):
 - (a) Clamp bracket assembly (148) tightly to the bench.
 - (b) Move the bellcrank to align the long arm with the center of the drum assembly.
 - (c) Tighten nut (170) until a load of 340-360 pounds, applied perpendicular to the long arm as shown, causes the clutch teeth to disengage.
 - (d) Apply this load to disengage the teeth five times in a clockwise direction and five times in a counterclockwise direction.
 - (e) Adjust nut (170) to make sure the clutch continues to disengage in each direction with this load applied to the bellcrank.
 - (f) Install lockwire between lock (171) and nut (170) by the double twist method.
- (13) Turn drum assembly (136) to find the upper and lower and inboard and outboard sides when installed in flap. Put the drum assembly in the approximate position in the flap and install cables as follows:
 - (a) Start cable assembly (109) in lower groove of drum assembly (136), and wrap approximately 1-1/8 turns around drum to center groove terminal point.
 - (b) Put the end fitting of the cable assembly in the terminal socket on the drum.
 - (c) Start cable assembly (110) in the upper groove of drum assembly (136), and wrap approximately 1/2 turn around the drum to the center groove terminal point.

- (d) Place end fitting of cable assembly in terminal socket on drum.
- (e) Install screw (108), washer (107), and nut (106), to lock ends of cable assemblies (109, 110) in place.
- (14) Make up pushrod assembly (116) by installing rod end bearing (119) on tube (117) with nut (120) and key (121). Adjust dimension between bearing centerlines to 19.56 inches.
- (15) Install pushrod assembly (116) on bellcrank assembly (158) with bolt (125), washer (124), nut (123), and cotter pin (122).
- (16) Assemble cable assemblies (112, 113), turnbuckle (114), and clip (115).
- (17) Place end fittings of cable assemblies (113) in sockets in bellcrank assembly (194) and install cotter pins (193) to retain ends of cables.
- (18) Place end fittings of cable assemblies (112) in sockets in bellcrank assembly (158) and install cotter pins (111) to retain ends of cables.
- (19) Install bolts (98), spacers (97), washers (96), and nuts (95).
- (20) Install guard bracket (101) with bolts (99) and washers (100).
- (21) Install bolts (105), spacers (104), washers (103), and nuts (102).
- (22) Locate bracket assembly (148) and attach with bolts (92 and 93) and washers (94).
- (23) Make up pulley bracket assembly (77) by assembling bracket (78), pulley (83), bolt (85), washer (84), bushings (82), washer (81), nut (80), and cotter pin (79).
- (24) Install pulley bracket assembly (77) with bolts (88), washers (87), and nuts (86).
- (25) Place cable assembly (110) in groove of pulley (83). Install pins (91), washers (90), and cotter pins (89). Pull end of cable assembly through cutout in flap rib.

- (26) Locate pulley support (19) and shim (20).

NOTE: Use same shim (20) removed during disassembly. If replacement is necessary, remove laminations from new shim to reduce thickness to dimension recorded during disassembly. Coat shim with primer, Specification BMS 10-11, type 1, after delamination.

- (27) Attach pulley support and shim with bolts (16 and 17), washers (15), and nuts (14). Attach roller support bracket with previously installed bolt and washers (22 and 23, figure 1107).
- (28) Tighten nuts (14) within torque range of 30 to 40 pound-inches and install cotter pins (13).
- (29) Tighten bolt (22, figure 1107) within torque range of 30 to 40 pound-inches, and install lockwire, using double-twist method, between bolts (21 and 22, figure 1107).
- (30) Install cam follower (49, figure 1108) and two pulleys (47) on pulley support (19). Install cotter pin (48).
- (31) Locate serrated plates (11 and 12) and fitting assembly (8) on carriages. Attach with bolts (3 and 7), washers (2 and 6), and nuts (1 and 5).

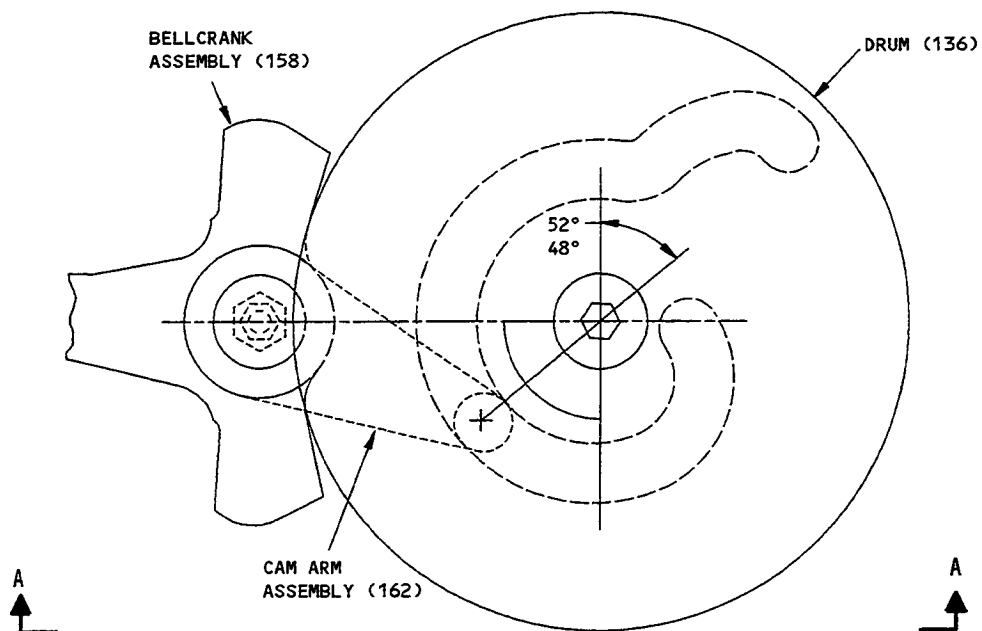
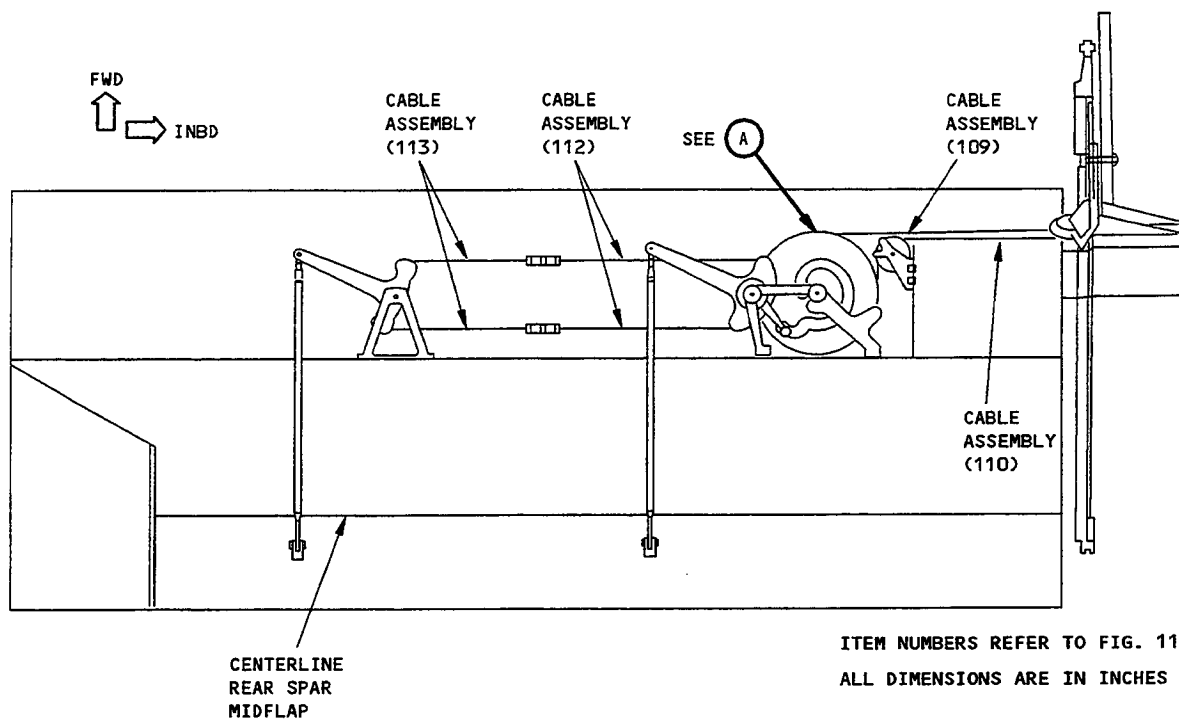
NOTE: Do not tighten bolts to full torque. Position of fitting must be adjusted later.

- (32) Install pulley (33) with bolt (34), washer (32), nut (31), and cotter pin (30).
- (33) Install pulleys (24 and 25) with bolt (29), washer (28), nut (27), and cotter pin (26).
- (34) Build up boom assembly (51) as follows:
- (a) Install fitting assembly (54) on boom (52). Attach with bolts (62 and 63), washers (59, 60, and 61), and nuts (58).
 - (b) Install nut (64) and washer (65) on end fitting (53), and install end fitting (53) inside end fitting assembly (54).
 - (c) Install fitting (70) on boom. Attach with bolts (73), washers (72), and nuts (71).

65-46436
65-71940
65-71969

- (d) Install washer (75) and nut (74) on screw (69). Install screw in fitting (70).
- (e) Install nut (67) on rod end bearing (66). Install rod end bearing and washer (68) in fitting (70).
- (35) Locate cam follower (49) in track of boom assembly (51).
- (36) Thread cable assembly (109) over pulleys (24 and 47). Thread cable assembly (110) over pulleys (25, 33 and 47).
- (37) Place end fitting on cable assembly (109) in socket of screw (69).
- (38) Place end fitting on cable assembly (110) in socket of end fitting (53).
- (39) Tighten nut (64) on end fitting (53), and nut (67) on screw (69). Tighten only enough to take up slack in cables. Install cotter pin (50).
- (40) Install bolt (38), spacer (37), washer (36), and nut (35).
- (41) Install cable guard (21) with bolt (23) and nut (22).
- (42) Install screw (46), spacer (45), washer (44), and nut (43).
- (43) Install bolt (42), spacer (41), washer (40), and nut (39).
- (44) Adjust position of pulley support fitting assembly (8) so that cables coming off pulleys are centered in cutout in rib of flap. Tighten bolts (3 and 7) and install cotter pin (4) through bolt (7).
- (45) Rig cables as follows: (See figure 502.)
 - (a) Install two 1/4-inch diameter rigging pins through boom (52), trapping follower (49).
 - (b) Adjust cable assemblies (109 and 110) to position bearing (169) as shown.

NOTE: Rigging may be simplified by constructing a rigging block out of 0.25-inch thick plastic (or equivalent) material, shaped to fit the contour of the end of the cam slot. The block is cut to provide the 0.42-inch dimension between cam follower bearing (169) and the end of the cam slot. The block is taped in position while cam follower is held against block and cables are adjusted accordingly.



POSITION OF DRUM ASSEMBLY FOR CABLE GROOVE ALIGNMENT

(A)

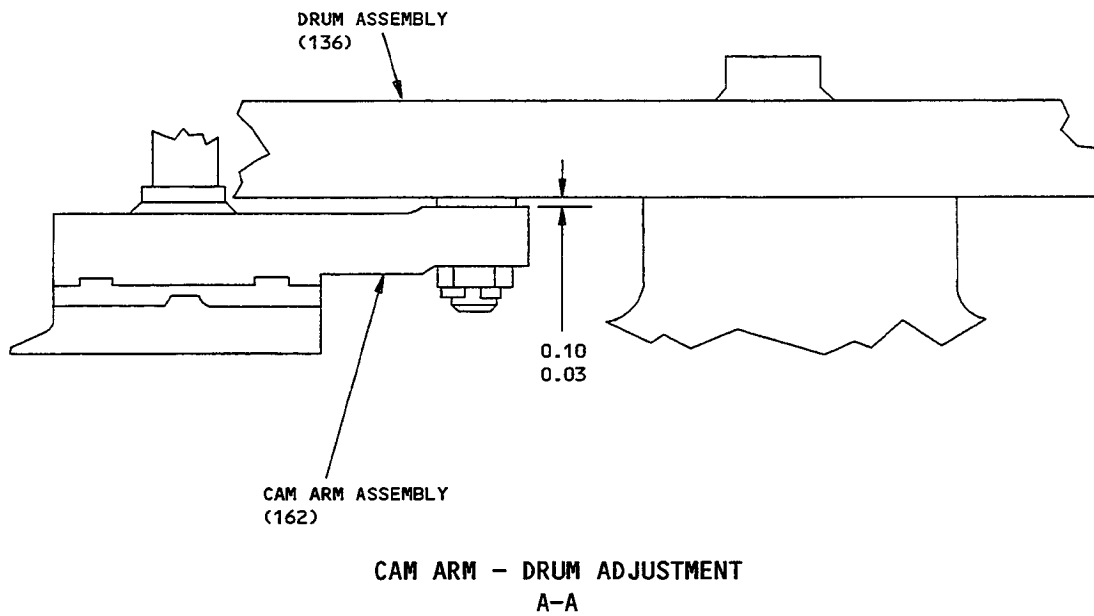
Actuating Mechanism Assembly Adjustment
Figure 501B (Sheet 1)

65-46436
65-71940
65-71969

DASH NUMBERS LIMITED

BOEING 
COMMERCIAL JET

OVERHAUL MANUAL



NOTE: MAXIMUM AXIAL FLOAT IS 0.016 INCH

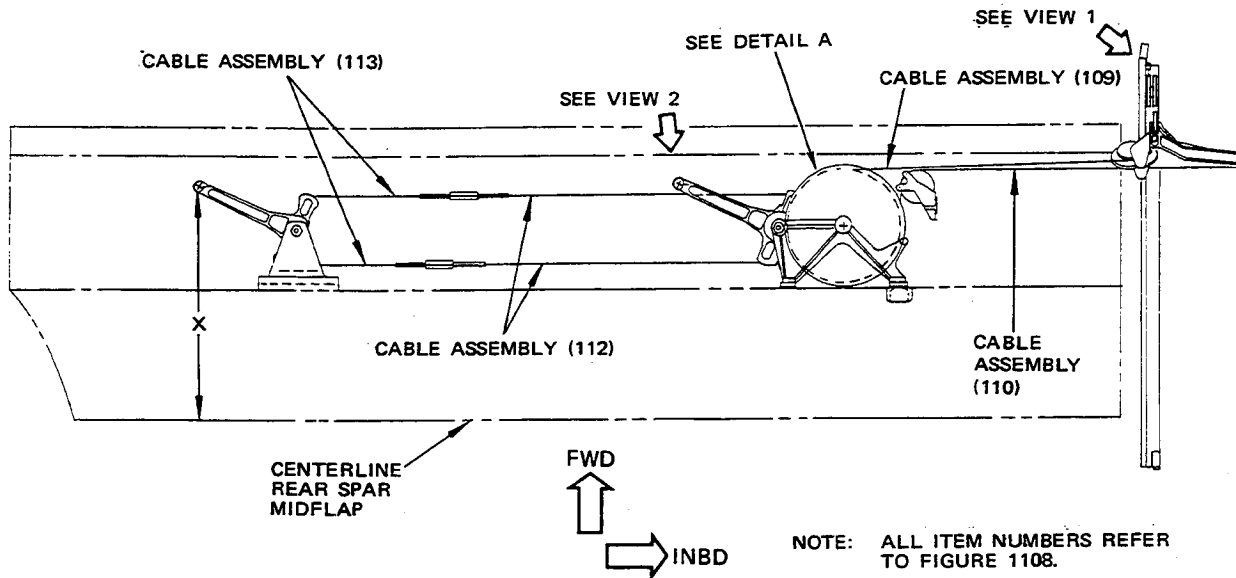
ITEM NUMBERS REFER TO FIG. 1108

ALL DIMENSIONS ARE IN INCHES

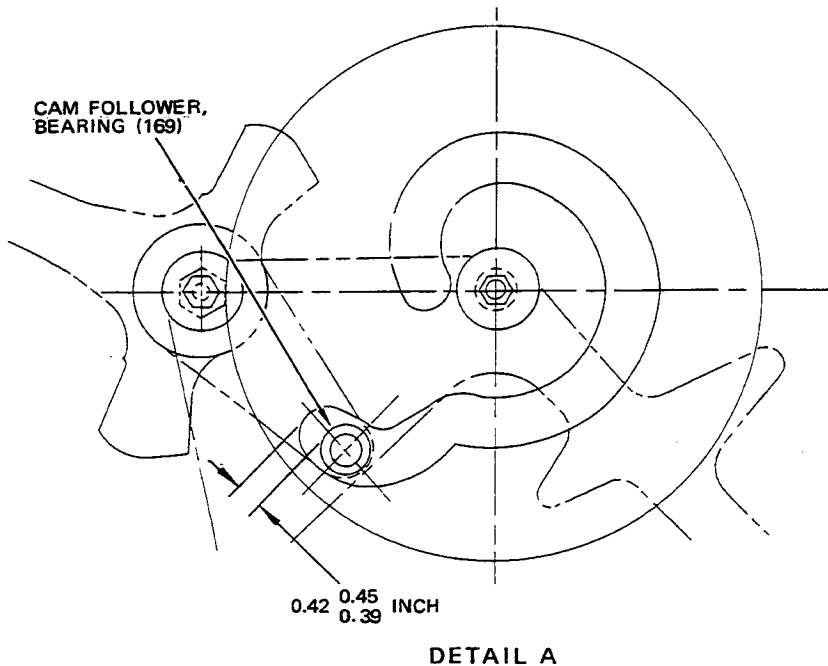
Actuating Mechanism Assembly Adjustment
Figure 501B (Sheet 2)

BOEING
COMMERCIAL JET
OVERHAUL MANUAL

65-46436
65-71940
65-71969



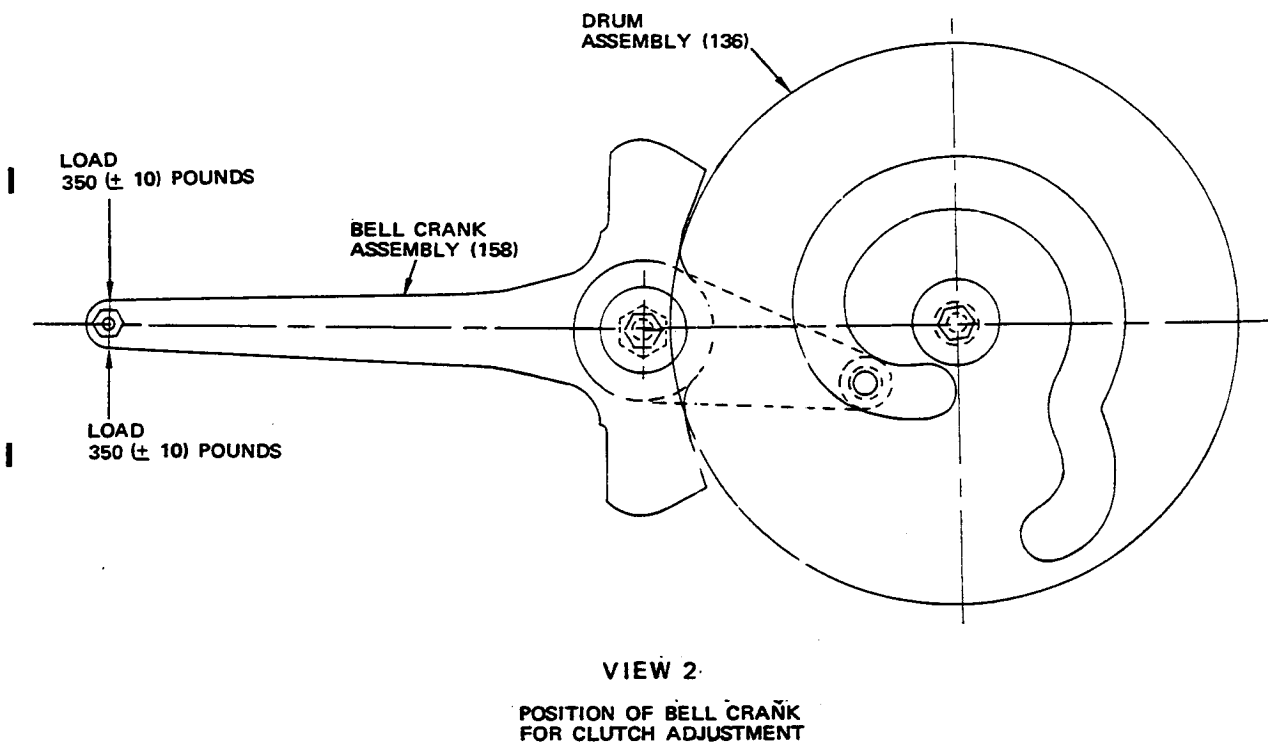
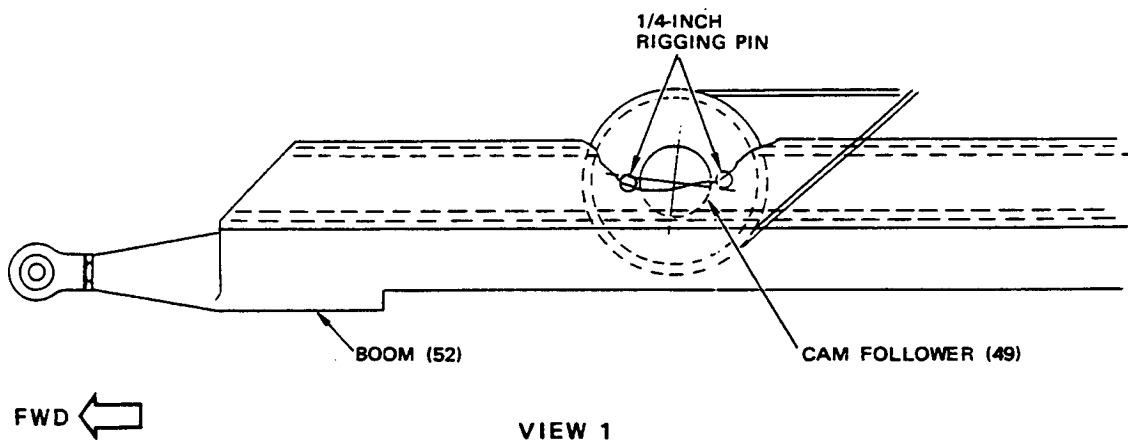
NOTE: MINIMUM CLEARANCE BETWEEN CABLES AND STRUCTURE SHALL BE 0.05 INCH AFTER RIGGING COMPLETE TRAVEL OF THE FLAP. CONTROL CABLES SHALL NOT BE DEFLECTED BY FAIRLEADS, GROMMETS, ETC. FROM RIGGED OR NORMAL OPERATING POSITION.



Actuating Mechanism Rigging Data
Figure 502 (Sheet 1)

65-46436
65-71940
65-71969

BOEING
OVERHAUL MANUAL





OVERHAUL MANUAL

65-46436

65-71940

65-71969

DASH NUMBERS LIMITED

- (c) Tighten nuts (64 and 67) to increase tension on cables to 90-110 pounds. Measure the tension with a tensiometer such as a Pacific Scientific Co., Model T5-2002-104-00.
 - 1) When you adjust the tension of the cables, put the tensiometer on the cable between the rig pins and the aft cable adjusting point.
 - 2) Deflect the cable away from the boom to install the tensiometer, then release as you make tension adjustments. Be sure that the cam follower bearing (169) is against the rig block after tension adjustment.
 - 3) After you are done, deflect the cable away from the boom and remove the tensiometer.
 - (d) Remove clips (115). Adjust the length of cable assemblies (112, 113) to move bellcrank assembly (194) to make the dimension from centerline of pushrod attach hole to centerline of mid flap rear spar be equal to the related dimension for bellcrank assembly (158) within 0.06 inch.
 - (e) Tighten turnbuckles (114) to increase the tension on cables to 180-220 pounds. Measure the tension with the tensiometer. Adjust as necessary, then remove the tensionmeter. Install clips (115).
- (46) After all rigging is complete, install lockwire on all cable adjusting nuts (64, 74, Fig. 1108). Do not remove the rig pin. Length of pushrods will be adjusted when aft flap is installed.
- (47) On mid flap assemblies 65-71902-31, -32, -43, -44, -45, -46, apply sealant as shown in Fig. 502A.

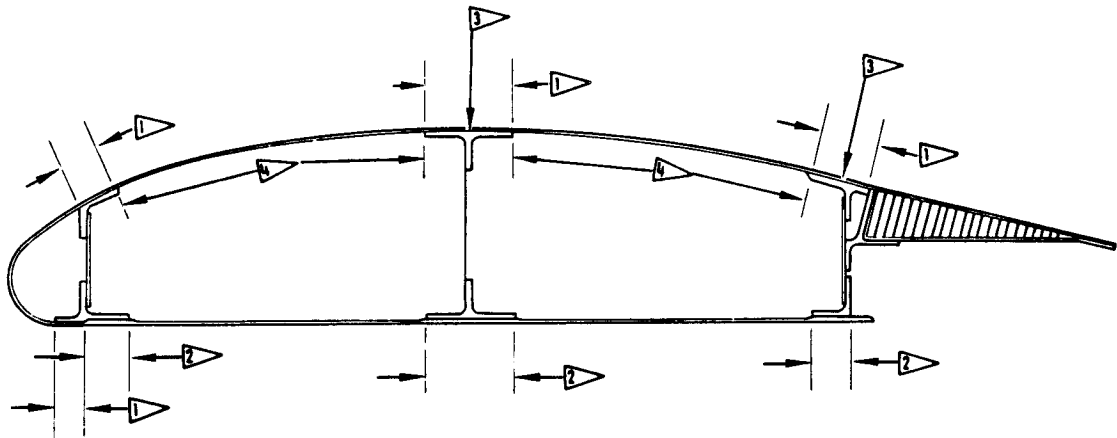
BOEING
COMMERCIAL JET
OVERHAUL MANUAL

E. Install aerodynamic seals and lower skins (Fig. 1105).

NOTE: Coat all bolts with corrosion preventive compound, Specification MIL-C-11796, class 3, before installation.

CAUTION: NO DEVIATION IS ALLOWED IN GRIP LENGTH FROM DESIGNATED GRIP LENGTH OF BOLTS ATTACHING LOWER SKINS.

- (1) Locate outboard skin assembly (109). Attach with bolts (110, 111, and 112).
- (2) Locate forward center skin assembly (105) and splice plate (106). Attach with bolts (107 and 108).
- (3) Locate forward inboard skin assembly (102). Attach with bolts (103 and 104).



- 1 APPLY BMS 5-95 SEALANT TO SPAR-UPPER SKIN FAYING SURFACES
- 2 APPLY PARTING AGENT TO PANEL ON FAYING SURFACE WITH SPAR. APPLY BMS 5-95, CLASS F SEALANT TO SPAR
- 3 SEAL GAP BETWEEN PANELS WITH BMS 5-95, CLASS B SEALANT. HEIGHT OF SEALANT TO BE 0.02 ABOVE TO 0.01 INCH BELOW SURFACE OF PANELS
- 4 ASSEMBLE RIBS AND STIFFENERS TO UPPER SKINS WITH BMS 5-95 FAYING SURFACE SEALANT.

65-46436
65-71940
65-71969

BOEING
COMMERCIAL JET
OVERHAUL MANUAL

- (4) Locate aft skin assembly (99). Attach with bolts (100 and 101).
- (5) Locate retainers (94, 95, 96, 97, and 98). Attach with bolts (93).
- (6) Install aerodynamic seal (92) in retainers.

NOTE: Do not lockwire seals to retainers. Aft flap must be installed before lockwire is installed.

- (7) Install aerodynamic seal (82) and retainer (81) on outboard end of flap with bolts (80).
- (8) Install aerodynamic seal (87), fillers (88 and 89) and retainer (86). Attach with bolts (85).
- (9) Install aerodynamic seal (76) and retainer (77). Attach with bolts (75).
- (10) Install seal plate assembly (64) as follows:
 - (a) Locate seal plate assembly (64) and install plates (62). Attach with bolts (58), washers (56 and 59), and nuts (55 and 60), as applicable.
 - (b) Install angle assembly (48), serrated plate (52), and shim (46). Attach with bolts (45 and 47), washers (44), and nuts (43).
 - (c) Install shim (63), plates (42), and retainer (39). Attach with bolts (38).
 - (d) Install seal (37) and retainers (29 and 32). Attach with bolts (28).
 - (e) Install retainer (25) with bolts (24).
 - (f) Install nut (23), shim (22) and filler (21) with bolt (20).
- (11) Install seal plate assembly (141 and 143) as follows:

NOTE: Coat all bolts with light film of grease MIL-G-23827 and install bolts until snug. Final bolt tightening will be accomplished after mid flap installation on wing and adjustment of seal plate assembly to required position.

- (a) Install adapter plate assembly (158). Attach with bolts (155).
- (b) Install seal plate assembly (143) and spacers (144, 145, 146, 147). Attach with bolts (142).

BOEING
COMMERCIAL JET
OVERHAUL MANUAL

65-46436
65-71940
65-71969

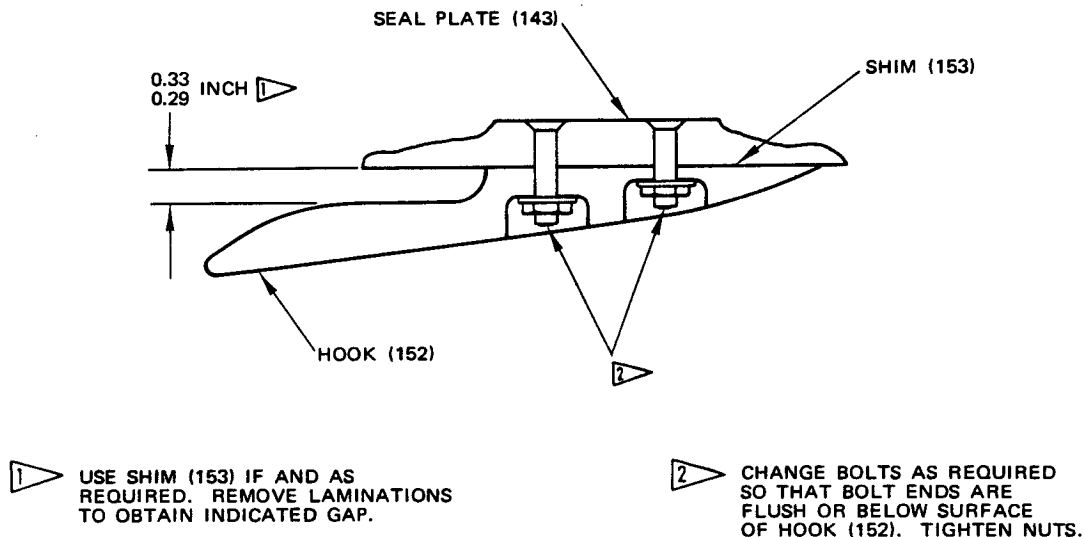
- (c) Install retainer (140), seal plate assembly (141), shims (139, 134) and filler (135). Attach with bolts (136, 132).
- (d) Install seal (130) and retainer (131). Attach with bolts (127).
- (e) Install hook (152) and shim (153). Attach with bolts (148, 149), washers (150) and nuts (151). See Fig. 502B for hook adjustment.

NOTE: Trailing edge assembly (3 and 3A), as applicable, will be installed after aft flap has been joined with mid flap.

2. Build up and install fore flap (Fig. 1102).

A. Mount fore flap structure (94) on a suitable workstand or holding fixture and build up as follows:

- (1) Throughout following procedure, coat all screws and bolts with grease, Specification MIL-G-23827, before installation.
- (2) Install end block assemblies (83 and 90) with bolts (82 and 89), washers (81 and 88), and nuts (80 and 87).



Hook Adjustment
Figure 502B

- (3) Install seals (77, 78) with retainers (76) and screws (75).
- (4) Install torque tube assemblies (70) with bolts (69, 65), washers (68), and nuts (67). Tighten bolts (65) within a torque range of 65 to 90 pound-inches, and nuts (67) within a torque range of 5 to 10 pound-inches. Install cotter pins (66).
- (5) Install support assemblies (59, 62) with bolts (58), washers (57), and nuts (56). Tighten nuts within a torque range of 5 to 10 pound-inches. Install cotter pins (55).
- (6) Install guide (37), retainer (36), bolt (35), washers (34, 33), and nut (32). Tighten nut within a torque range of 30 to 40 pound-inches. Install cotter pin (31).
- (7) Install track brackets (51, 52) at positions noted prior to removal, with shims (53, 54), bolts (39, 40, 41), washers (42, 43, 44), nuts (48, 49, 50), and retainers (45, 46, 47). Tighten bolts (39) within a torque range of 65 to 90 pound-inches; bolts (40) within a torque range of 130 to 180 pound-inches and bolts (41) within a torque range of 220 to 360 pound-inches.

NOTE: If new shims (53, 54) are used, remove laminations to achieve proper clearance with mid flap per par. 2.B. below. Coat delaminated area with primer, Specification BMS 10-11, Type 1.

- (8) Assemble toggle assemblies (18) as follows:

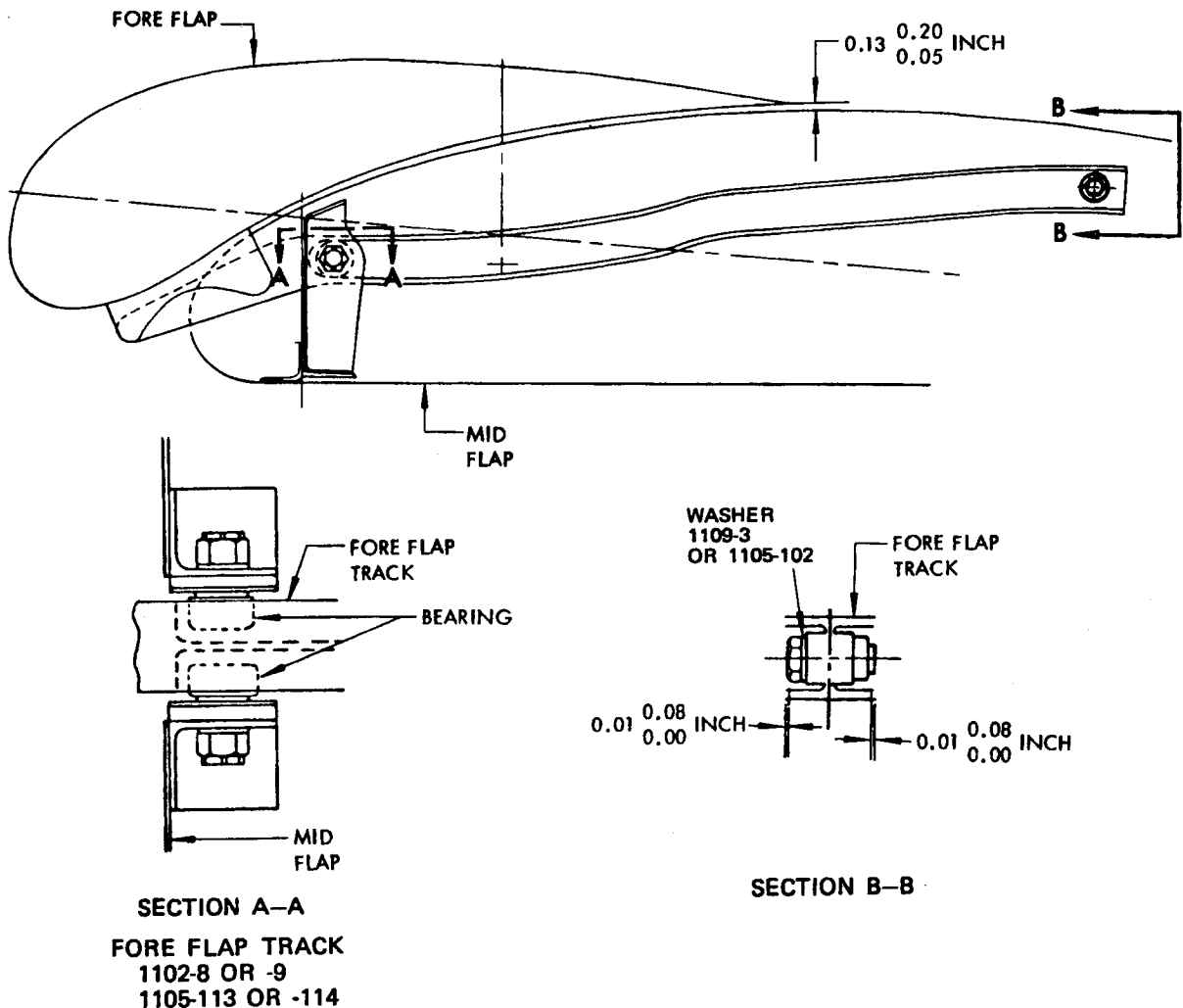
- (a) Coat bearings (27) and bushings (28) with a light film of grease, MIL-G-23827, and attach to toggle (30) with nuts (25) and washers (26). Tighten nuts (25) within a torque range of 95 to 110 pound-inches and install cotter pins (24).
- (b) Apply a light coat of grease to bearing (23) and bolt assembly (20); install bearing (23) with bolt assembly (20) and spring pin (19). Install lockwire through spring pin and hole in toggle (30).

- (9) Install bearings (15) with MIL-G-23827 grease, toggle assemblies (18), and bushings (16, 17) to support assemblies (59, 62) with washers (13, 14) and nuts (12). Tighten nuts (12) within torque range of 50 to 100 pound-inches, and install cotter pins (11).

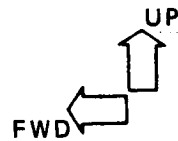
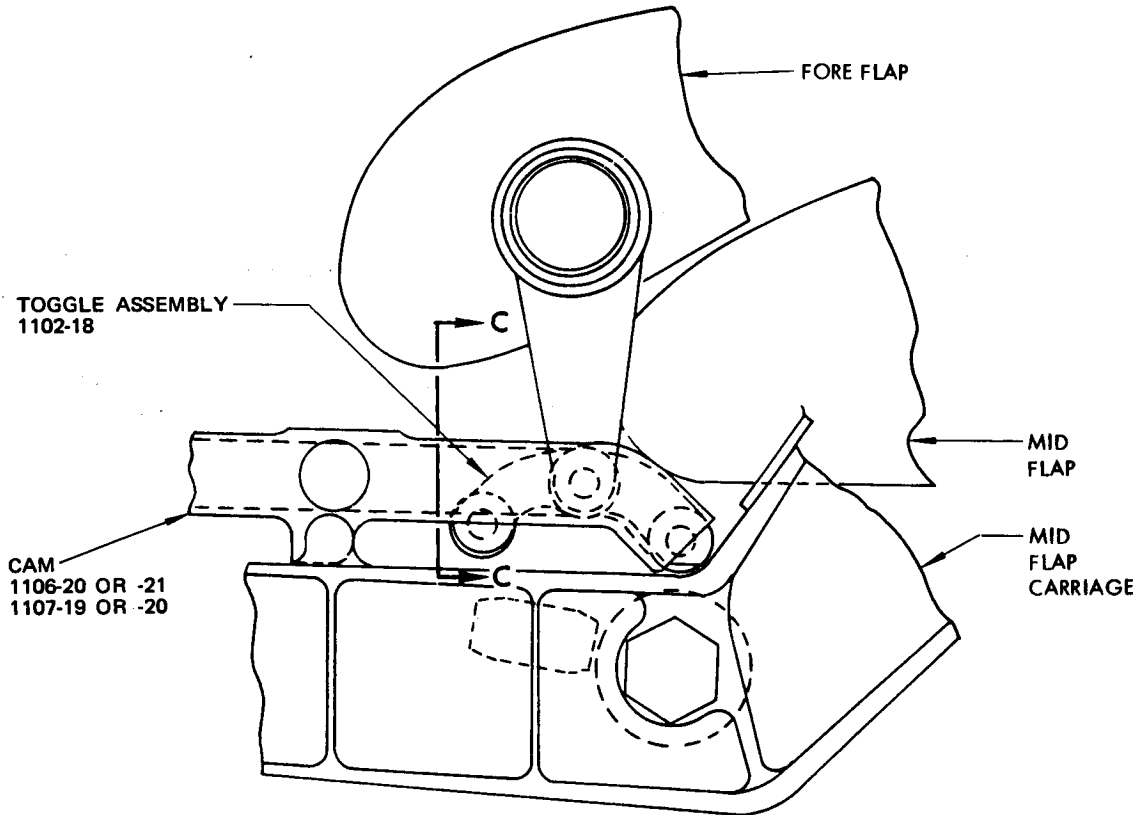
B. Join fore flap to mid flap (Fig. 503).

- (1) Extend tracks through openings in leading edge of mid flap.

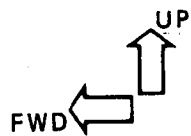
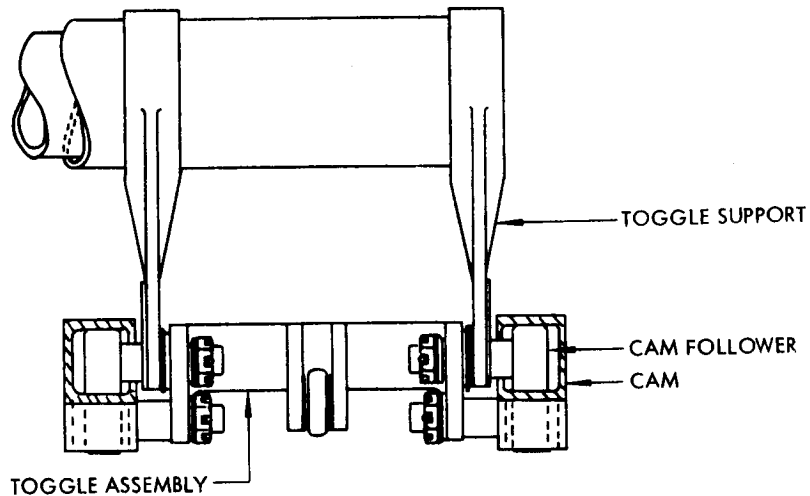
- (2) Locate toggles on fore flap in cams on mid flap, and move fore flap aft into position to attach tracks (7, 8, Fig. 1102) to track brackets (51, 52).
- (3) Locate shims (9, 10) in track brackets (51, 52) at each attaching point. If new shims are used, remove laminations to achieve thickness recorded during disassembly. Coat shims with primer, Specification BMS 10-11, Type 1, after delamination.
- (4) Coat bolts (5, 6) with a light film of grease, MIL-G-23827; install bolts (5, 6), washers (3, 4), and nuts (1, 2). Tighten nuts (2) with a torque range of 50 to 100 pound-inches, and nuts (1) within a torque range of 30 to 40 pound-inches.
- (5) Retract fore flap fully and check gap between lower surface of trailing edge of fore flap and upper surface of mid flap. If gap is less than 0.05 inch or more than 0.20 in any area, adjust thickness of shims (53, 54) to bring gap within tolerance.



Rigging Data - Fore Flap and Mid Flap Joining
Figure 503 (Sheet 1)



VIEW 2
FORE FLAP IN FULLY RETRACTED
POSITION SHOWING POSITION
OF FORE FLAP TOGGLES AND
MID FLAP CARRIAGE
(TYPICAL BOTH ENDS OF FLAP)



SECTION C-C

3. Build up and install aft flap (Fig. 1104).

A. Place basic flap structure assembly in a suitable holding fixture or workstand and build up as follows:

(1) Coat bolts (49) with primer Specification BMS 10-11, Type 1; locate slave attach fitting assemblies (46) and attach with washers (50) and bolts (49). Install lockwire between bolts using double-twist method.

(2) Install rollers in roller support assemblies (12, 20) as follows:

(a) Install rollers (42), bushings (43), and eccentric bushings (40) in supports (13, 21). Attach with bolts (41), washers (39), and nuts (38). Loosely install cotter pins (37).

NOTE: Do not tighten nuts (38). Eccentric bushings (40) must be adjusted when flap is installed in airplane.

- (b) Install cam follower (36) in supports (13 and 21). Attach with nuts (35). Tighten nut within 95 to 110 pound-inches, 240 pound-inches max torque allowed for pin (34) installation. Install cotter pin (34).
- (3) Coat bolts (10 and 11) with corrosion preventive compound, MIL-C-11796, class 3; locate roller support assemblies (12 and 20) and shims (28) in flap. Attach with bolts (10 and 11).

NOTE: Adjust thickness of shims (28) to close gap between support assemblies and flap ribs. Remove laminations from shims as necessary. Coat shims with primer, Specification BMS 10-11, type 1, after delamination.
- (4) Coat screws (57) with corrosion preventive compound, Specification MIL-C-11796, class 3.
- (5) Locate seal (53) and retainer (56). Attach seal and retainer with three screws (57).
- (6) Locate seal (51) and retainer (54). Attach seal and retainer with five screws (57).
- (7) Locate seal (52) and retainer (55). Attach seal and retainer with five screws (57).
- (8) Install nose skin assemblies (1) with bolts (2).
- (9) Install shield assembly (63) as follows:
 - (a) Apply abrasion-resistant finish (SRF-14.9625) to top surface of flap in a spanwise strip 1.50-1.70 inches wide, starting at trailing edge, for length of shield assembly and allow to dry.
 - (b) Apply 0.5 to 1.0 inch wide BMS 5-95 faying surface seal around entire periphery of shield and full length of shield along line of bolts (68).
 - (c) Position shield on flap and install bolts (64, 68) with wet sealant BMS 5-95.
- (10) Touch up all primed and painted areas.

- B. Join and rig aftflap to midflap using standard industry practices and the following steps (Fig. 504).

NOTE: Midflap trailing edge installation (3, IPL Fig. 1105) must be removed to install (or remove) the aftflap.

- (1) Ensure each pair of top and bottom deadweight rollers (42, IPL Fig. 1104) is adjusted identically between opposite sides of carriage support (4 locations). This may be done by viewing the rollers or by determining the location of the lock plate (44), relative to the bore, upon partial withdrawal of the eccentric bushing (40).
- (2) Remove (if necessary) aft flight roller (9) from aftflap assembly by removing attaching parts; cotter pin (3), nut (4) bolt (6), washers (5), and bushings (14, 22).
- (3) Install aftflap assembly (3, IPL Fig. 1101) into midflap assembly (2) by placing forward flight rollers (36, IPL Fig. 1104) and both top and bottom deadweight rollers (42) into aftflap tracks in midflap. Slide aftflap assembly forward into midflap.
- (4) Install aft flight roller (9) and washers (5) onto bolt (6) and secure with nut (4) and cotter pin (3).
- (5) Fully extend aftflap and with both pairs of bottom deadweight rollers (42) contacting track flanges, check both pairs of top deadweight rollers (42) to ensure contact with flange. As an option the forward flight rollers may be checked to ensure clearance with the upper flange. If contact cannot be achieved adjust top deadweight rollers using same procedure as outlined in steps 6.a thru d.

CAUTION: LOAD SHOULD BE APPLIED TO AN AREA OF 20 SQUARE INCHES OR MORE TO AVOID DAMAGING THE SKIN.

- (6) Ensure aftflap is fully extended and apply a 15 to 30 pound downward load in the area of the tracks to ensure contact between both pairs of deadweight rollers and the track flanges. Measure gap between aft flight roller (9) and flange. If gap exceeds 0.015 inch adjust bottom deadweight roller as follows:
 - (a) Remove cotter pin (37), nut (38) and washer (39) from bottom deadweight roller bolt (41).
 - (b) Disengage lock (44) by partially extracting eccentric bushing (40).

- (c) Rotate eccentric bushing to obtain proper adjustment and engage lock. If necessary, back off bushing to next detent to lock. When the gap cannot be reduced by using adjacent notches, rotate the eccentric bushing ± 90 degrees to obtain the use of additional settings.

NOTE: Do not rotate eccentric bushings independently. Adjustments must be made equally to both sides.

- (d) Secure bottom deadweight rollers with washer (39) and nut (38). Tighten nut 0-5 pound-inches.

CAUTION: PUSHRODS SHOULD BE HELD CLEAR OF AFTFLAP WHILE FLAP INSTALLATION IS CHECKED FOR BINDING OR OTHER DEFECTS.

- (e) Roll aftflap slowly forward to retracted position and aft to extended position. Operation should be accomplished using one person exerting approximately 50 pounds of force. If binding occurs, readjust deadweight rollers as required within the 0.015 inch limits specified for aft flight roller to track clearance.

- (f) Install cotter pin (37) into nut (38) per 20-50-02.

C. Obtain fair requirements between midflap and aftflap by using the following steps:

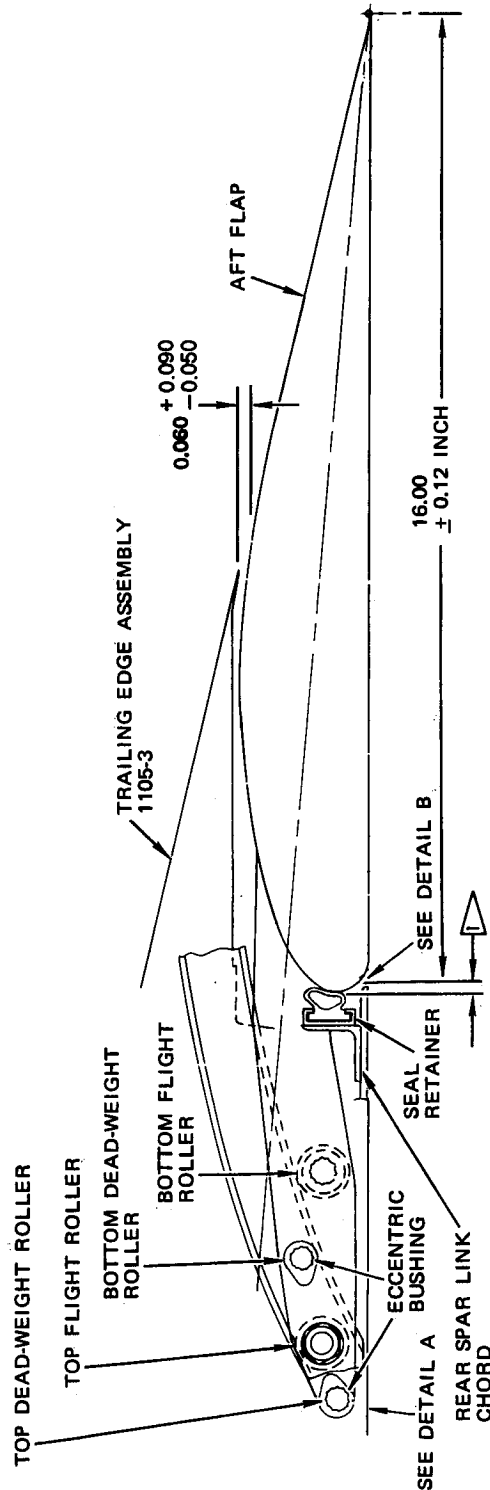
- (1) Connect pushrods to leading edge of aftflap by installing bolt (61), washer (60), and nut (59). Do not tighten nuts.

NOTE: Rod ends are connected temporarily for flap retraction so stowed position of the aftflap may be checked.

NOTE: After installing pushrods, prior to adjustment of the flaps, remove the rigging pins.

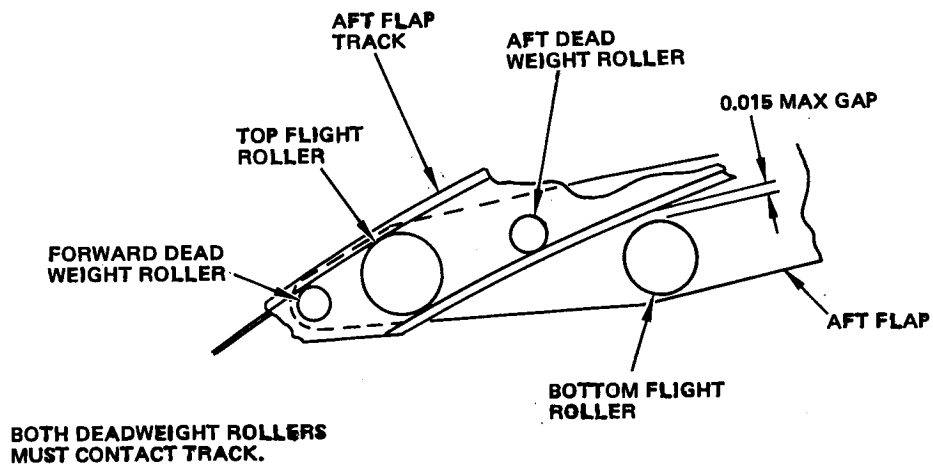
- (2) Confirm that dimension from bottom trailing edge of midflap to trailing edge of aftflap is 16.00 ± 0.120 inches as shown per Fig. 504. If adjustment is necessary, adjust pushrods (116, 199, IPL Fig. 1108) to obtain required dimension.
- (3) Tighten checknut (120, 203) to engage key (121, 204) extend and retract flaps as necessary to make adjustments and check dimensions. Once final adjustment is made install lockwire through checknut per 20-50-02.
- (4) Check gap between upper trailing edge of midflap (3, IPL Fig. 1105) and aftflap by positioning aftflap segment into stowed position and trial assembling midflap trailing edge installation. Clearance should be $0.060 +0.090, -0.050$ inch. Vary trailing edge position by adding or removing shims (5, 6, 7, 8, 9, 10, 11) if required. Install with BMS 10-11, Type 1 primer wet or dry. Maximum shim thickness allowed is 0.066 inch.

- (5) Install midflap trailing edge installation (Fig. 504).
- D. Check the seal at the leading edge of the aftflap (Fig. 504). When fully retracted, the aftflap leading edge must compress the seal between 10 and 30 percent. Adjust the seal as follows:
- (1) Add or remove shims as necessary under the seal retainer at each fastener to get seal compression.
 - (2) When the retainer is correctly shimmed, seal along the length of the retainer with GE RTV 174 as specified in 20-50-12 Type 60.
- E. With pushrods and seal retainer properly adjusted, install bolts (61, IPL Fig. 1104), washers (60), and nuts (59) to connect pushrods to leading edge of aftflap. Tighten nuts and install cotter pins (58).
- F. Operate flaps through one complete cycle, checking aftflap for binding or other evidence of faulty installation.
- I 4. Install installation items on inboard trailing edge flaps.
- NOTE:** If desired, these installation items need not be installed on the inboard trailing edge flap assembly until the assembly is installed on the airplane.
- A. Install flipper flap (Fig. 1103)
- (1) Remove nuts (2), washers (3), and bolts (4) from housing assembly (1).
 - (2) Install seals (8) and bearings (9) in upper housing (5) and lower housing (6).
 - (3) Install lower housing and upper housing on torque tube (120, Fig. 1106) and install bolts (4, Fig. 1103), washers (3), and nuts (2) with wet BMS 10-11, Type 1, primer. Tighten bolts only finger-tight because flap must be adjusted when the trailing edge flaps are installed on the airplane.

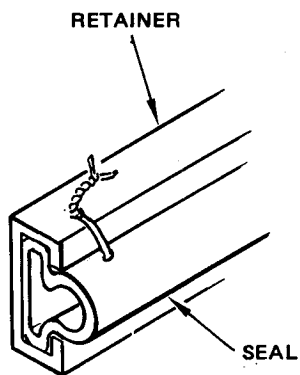


△ THE NOSE OF THE AFT FLAP MUST COMPRESS THE SEAL BETWEEN 10 AND 30 PERCENT. SHIM AS NECESSARY BETWEEN THE REAR SPAR AND THE SEAL RETAINER TO GET THE CORRECT SEAL COMPRESSION.

Rigging Data - Aft Flap to Mid Flap Joining
Figure 504 (Sheet 1)



DETAIL A



DETAIL B

B. Build up and install outboard gimbal assembly (Fig. 1101).

(1) Build up gimbal assembly (9).

- (a) Insert shaft assembly (10) through bearing of indexing plate assembly (14). Press bearing against shoulder.
- (b) Place spacer (29) on shaft assembly against bearing in indexing plate assembly.
- (c) Place bushing retainer (28) on shaft assembly against spacer (29).
- (d) Install keywasher (26) and spanner nut (27) on threaded bushing (25). Slide threaded bushing up on shaft assembly. Align holes for bolt or pin (24).
- (e) Install pin or bolt (24). If bolt is used, install washer (23) and nut (22).
- (f) Tighten spanner nut (27) against washer (26) and bushing retainer (28) within torque range of 20 0 to 250 pound-inches. Bend keys of washer to lock bolt in place.
- (g) Place sleeve (21) against shoulder on end of shaft (11).
- (h) Coat ID surface of bearing (20) with corrosion preventive compound, Specification MIL-C-11796, class 3, and press on end of shaft.
- (i) Place key washer (18) on shaft against bearing (20). Install spanner nut (19).
- (j) Tighten spanner nut (19) within torque range of 70 to 150 pound-inches. Bend keys of washer (18) to lock nut in place.
- (k) A spacer (20J) may be placed between bearing (20) and sleeve (21) for clamp up if required.

(2) Install gimbal assembly (9) in midflap assembly (2).

- (a) Coat OD surfaces of bearing (20) and indexing plate assembly (14) with corrosion preventive compound, Specification MIL-C-11796, class 3.
- (b) Slide gimbal assembly into torque tube, and seat in bearing supports.

- (c) Locate gimbal assembly with indexing plate in same position noted when assembly was removed. Install shim/shims (8).

NOTE: If new shims (8) are used, install same number and same thickness recorded during disassembly. Remove laminations from basic shim as necessary to fabricate shim to required thickness. Coat shim with primer, Specification BMS 10-11, Type 1, after delamination.

- (d) Install bolts (7), washers (6), and nuts (5).

NOTE: Do not tighten nuts (5) to full torque. Nuts will be tightened after adjustment of gimbal when flap is installed in aircraft.

C. Build up and install inboard gimbal assembly (Fig. 1101).

- (1) Build up gimbal assembly (32).

NOTE: Perform step (a) on gimbal assembly P/N 65-51622-5, -6, -13, -14 only.

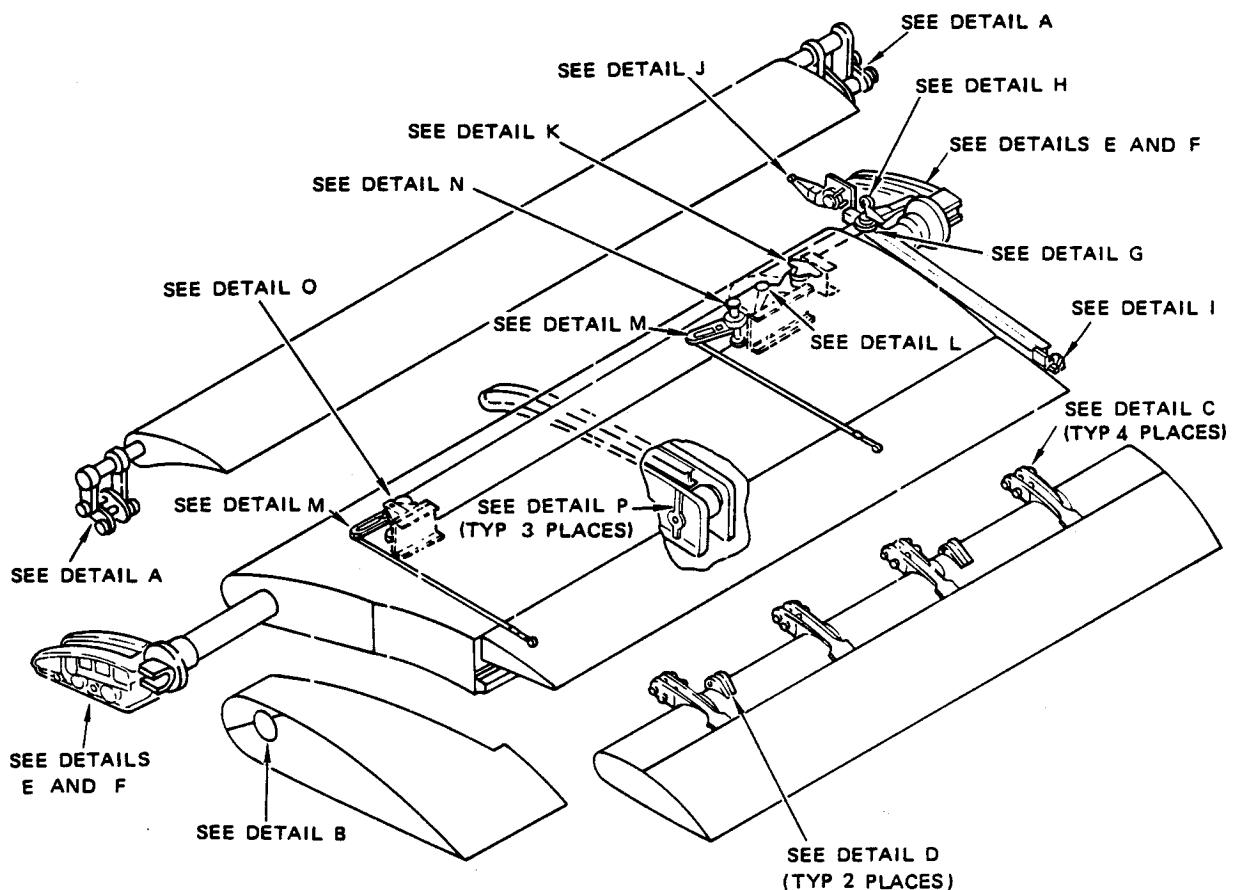
- (a) Place spacer (53) against shoulder on shaft assembly (33).
- (b) Insert shaft assembly through retainer (52).
- (c) Place bearing (51) on shaft assembly and press tightly against spacer or shoulder of shaft.
- (d) Coat OD surface of bearing (51) and ID surface of retainer (50) with corrosion preventive compound, Specification MIL-C-11796, class 3. Install retainer (50) over bearing.
- (e) Place spacer (49) on shaft assembly against bearing.
- (f) Place retainer (48) against spacer (49) on shaft assembly.
- (g) Install keywasher (45) and spanner nut (46) on threaded bushing (47).
- (h) Place threaded bushing (47) on shaft assembly (33), and align holes for pin or bolt (44).
- (i) Install pin or bolt (44). If bolt is used, install washer (43) and nut (42).

- (j) Tighten spanner nut (46) against keywasher (45) and retainer (48) within a torque range of 200 to 250 pound-inches. Bend keys of washer (45) to lock spanner nut in place.
 - (k) Locate sleeve (41) against shoulder on end of shaft (34).
 - (l) Coat ID surface of bearing (40) with corrosion preventive compound, Specification MIL-C-11796, class 3, and press on end of shaft (34).
 - (m) Install keywasher (38) and spanner nut (39).
 - (n) Tighten spanner nut (39) within a torque range of 75 to 150 pound-inches. Bend keys of washer (38) to lock spanner nut in place.
 - (o) A spacer (40J) may be placed between bearing (40) and sleeve (41) for clampup if required.
- (2) Install gimbal assembly (32) in mid flap assembly (2).
- (a) Locate shim/shims (54).
- NOTE:** If new shims (54) are used, install same number and same thickness recorded during disassembly. Remove laminations from shim as necessary to fabricate to correct dimension. Coat shim with primer, Specification BMS 10-11, Type 1, after delamination.
- (b) Coat OD surfaces of bearing (51) and retainer (50) with corrosion preventive compound, Specifications MIL-C-11796, class 3.
 - (c) Slide gimbal assembly (9) into torque tube and seat firmly in bearing supports.
 - (d) Install washers (31) and capscrews (30).

OVERHAUL MANUAL

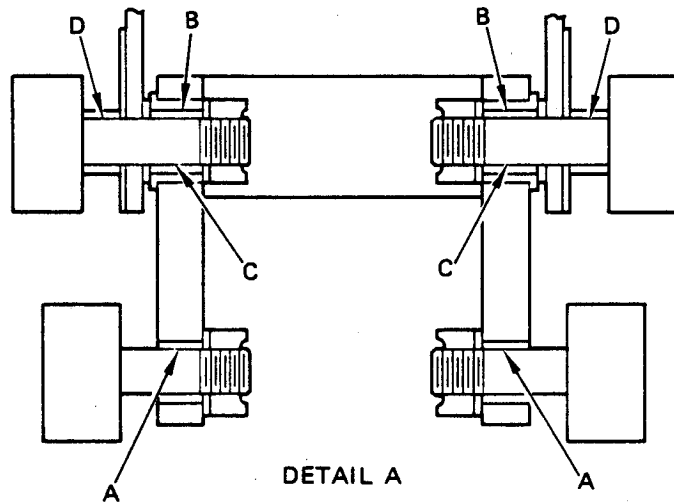
FITS AND CLEARANCES

1. The fits and clearances table lists design dimensions and service wear limits for close tolerance parts of the assembly that are subject to wear or corrosion. Unless otherwise specified, parts should be returned to the design dimensions whenever rework is accomplished.
2. Clearances are given to aid assembly of the components. The values given in the Maximum Allowable Clearance column are the maximum permitted to ensure proper functioning of the unit. If assembled parts fail to meet this requirement, one or more of the parts must be rejected. Parts that are rejected should be reworked if within the rework limits given in the Repair procedure; if not within rework limits, the parts should be scrapped. It is recommended that the design clearances be used as the guiding assembly criteria when newly reworked parts are assembled.

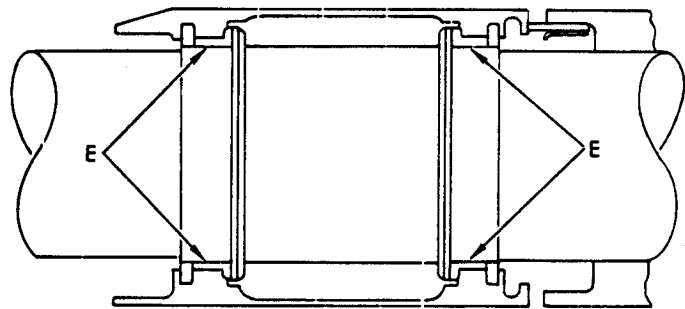


BOEING
COMMERCIAL JET
OVERHAUL MANUAL

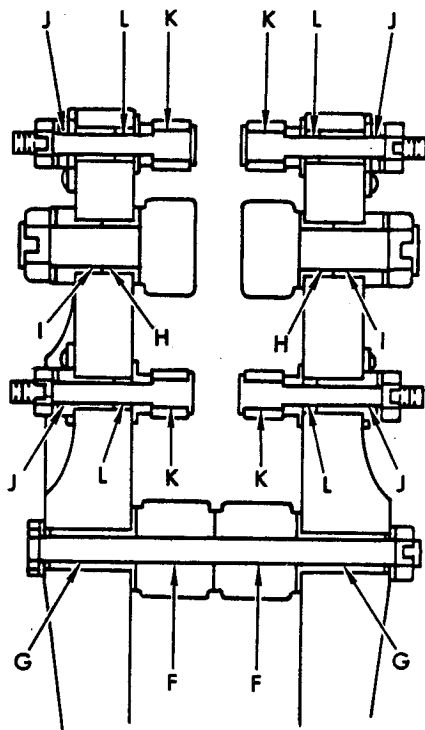
65-46436
65-71940
65-71969



DETAIL A

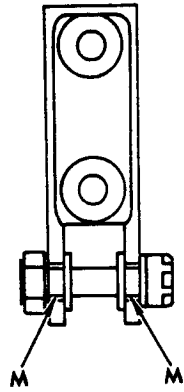


DETAIL B

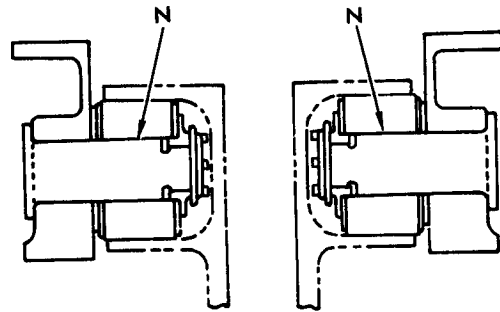


DETAIL C

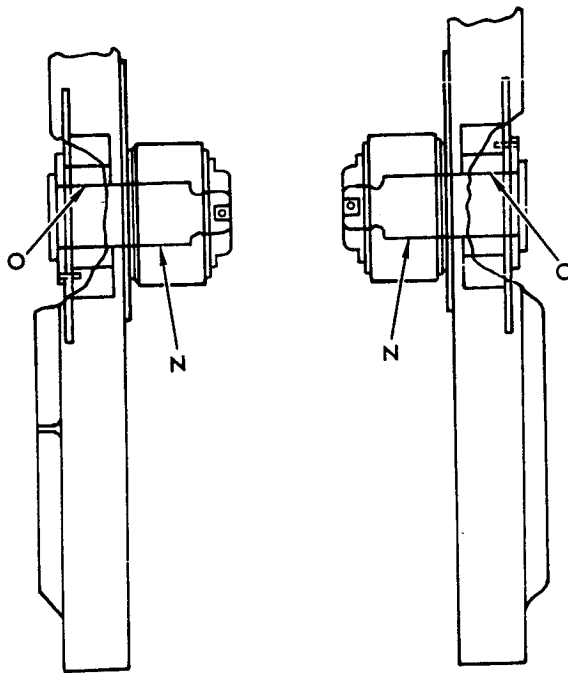
Fits and Clearances
Figure 601 (Sheet 2)



DETAIL D



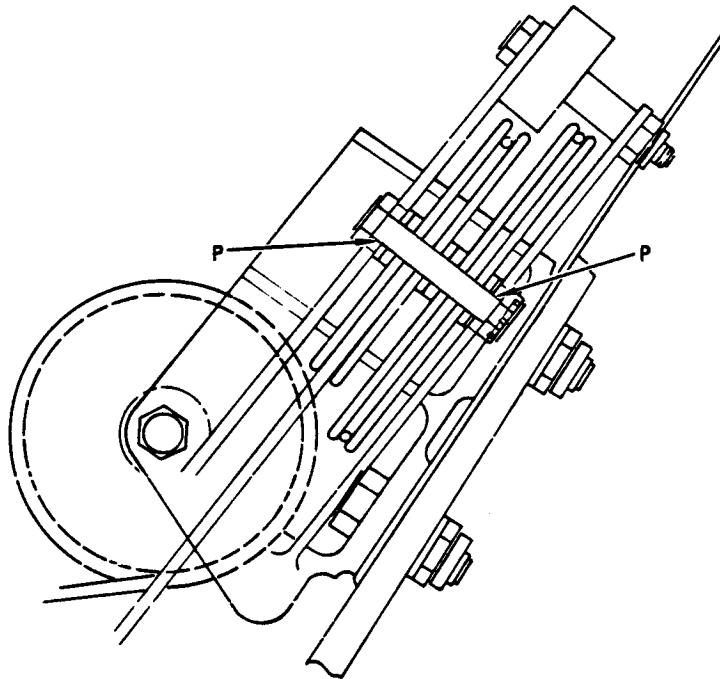
DETAIL E



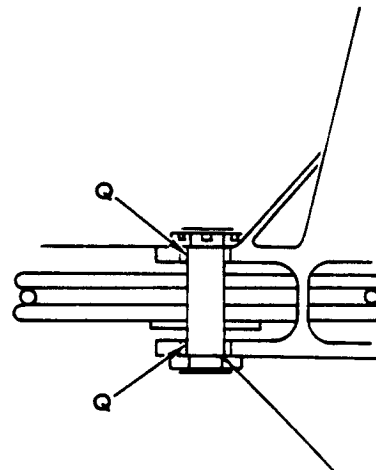
DETAIL F

BOEING
COMMERCIAL JET
OVERHAUL MANUAL

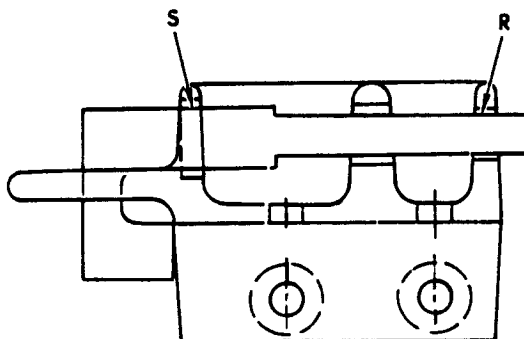
65-46436
65-71940
65-71969



DETAIL G



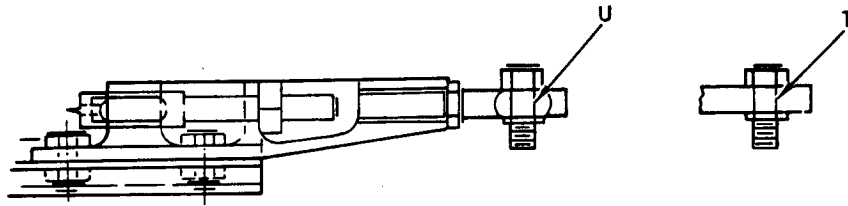
DETAIL H



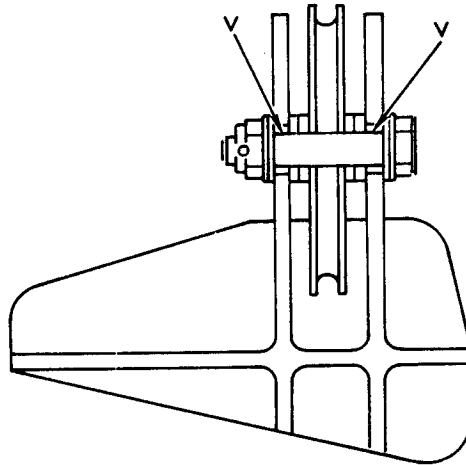
DETAIL I

65-46436
65-71940
65-71969

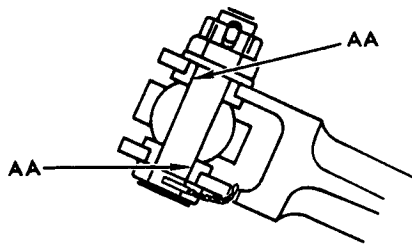
BOEING
COMMERCIAL JET
OVERHAUL MANUAL



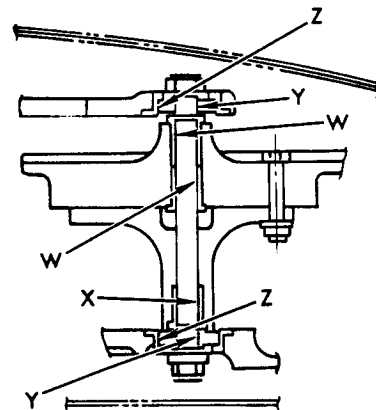
DETAIL J



DETAIL K



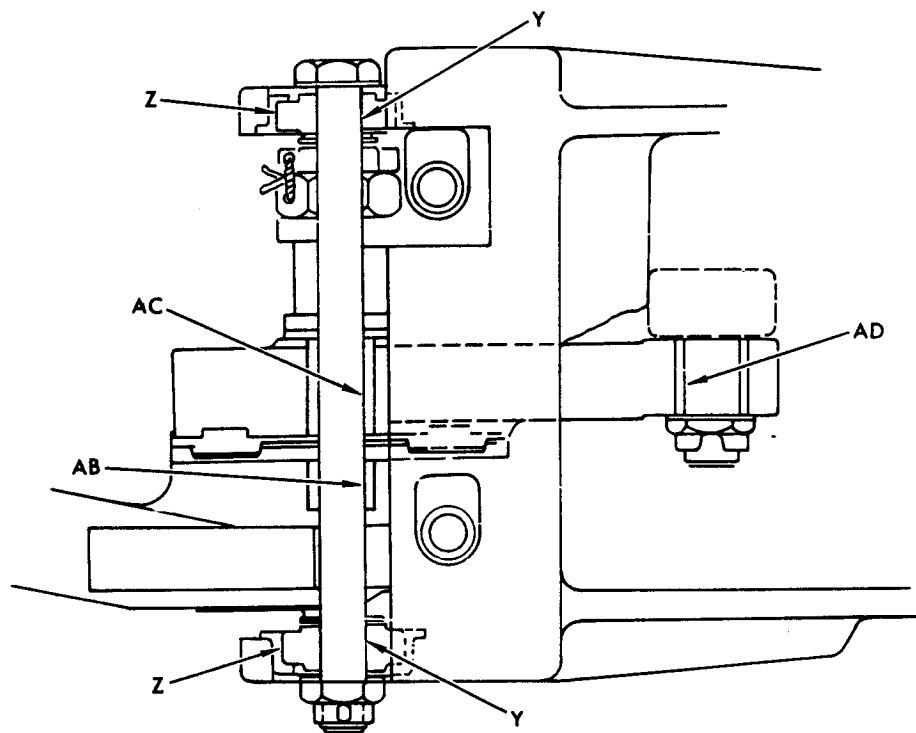
DETAIL M



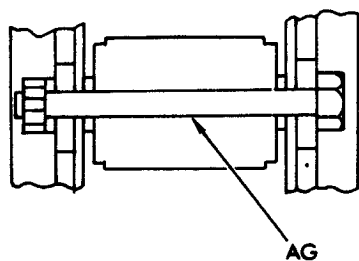
DETAIL L

BOEING
COMMERCIAL JET
OVERHAUL MANUAL

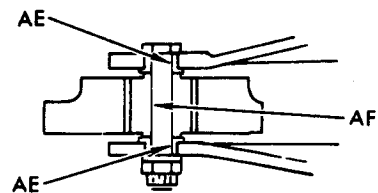
65-46436
65-71940
65-71969



DETAIL N



DETAIL P



DETAIL O

65-46436
65-71940
65-71969

BOEING
COMMERCIAL JET
OVERHAUL MANUAL

		Design Dimensions				Service Wear Limits		
Ref Letter Fig.601	Mating Item No. Fig.	Dimensions (inches)		Assembly Clearance (inch)		Dimension Limits (inches)		Maximum Allowable Clearance (inch)
		Min	Max	Min	Max	Min	Max	
A	1102-28	0.3750	0.3765	0.0000	0.0025	0.3700	0.3800	0.0050
	1102-27	0.3740	0.3750					
B	1102-29	0.5030	0.5040	0.0017	0.0036	0.4958	0.5085	0.0072
	1102-16	0.5006	0.5013					
C	1102-16	0.3750	0.3765	0.0000	0.0025	0.3700	0.3800	0.0050
	1102-15	0.3740	0.3750					
D	1102-17	0.3750	0.3765	0.0000	0.0025	0.3700	0.3800	0.0050
	1102-15	0.3740	0.3750					
E	1103-8	3.653	3.655	0.003	0.006	3.647	3.658	0.011
	1106-122	3.649	3.650					
F	1104-9	0.2493	0.2500	0.0001	0.0017	0.2459	0.2626	0.0034
	1104-6	0.2483	0.2592					
G	1104-14	0.2490	0.2510	0.0000	0.0027	0.2436	0.2546	0.0054
	1104-22							
H	1104-15	0.3750	0.3770	0.0000	0.0030	0.3690	0.3810	0.0060
	1104-23							
I	1104-36	0.3740	0.3750					
	1104-17	0.3750	0.3770	0.0000	0.0030	0.3690	0.3810	0.0060
	1104-25							
	1104-36	0.3740	0.3750					

BOEING
COMMERCIAL JET
OVERHAUL MANUAL

65-46436
65-71940
65-71969

		Design Dimensions				Service Wear Limits		
Ref Letter Fig.601	Mating Item No. Fig.	Dimensions (inches)		Assembly Clearance (inch)		Dimension Limits (inches)		Maximum Allowable Clearance (inch)
		Min	Max	Min	Max	Min	Max	
J	1104-40	0.1891	0.1897	0.0004	0.0016	0.1859	0.1919	0.0032
	1104-41	0.1881	0.1887					
K	1104-42	0.2525	0.2535	0.0001	0.0016	0.2475	0.2574	0.0050
	1104-41	0.2519	0.2524					
L	1104-43	0.1895	0.1905	0.0008	0.0024	0.1847	0.1935	0.0048
	1104-41	0.1881	0.1887					
M	1104-48	0.2500	0.2540	0.0005	0.0050	0.2400	0.2595	0.0100
	1104-61	0.2490	0.2495					
N	1106-41	0.8743	0.8750	0.0000	0.0010	0.8723	0.8765	0.0020
	1106-38	0.8740	0.8745					
N	1106-49	0.8743	0.8750	0.0000	0.0010	0.8723	0.8765	0.0020
	1106-53	0.8740	0.8745					
N	1106-61	0.8743	0.8750	0.0000	0.0010	0.8723	0.8765	0.0020
	1106-65	0.8740	0.8745					
N	1107-37	0.8743	0.8750	0.0000	0.0010	0.8723	0.8765	0.0020
	1107-34	0.8740	0.8745					
N	1107-45	0.8743	0.8750	0.0000	0.0010	0.8723	0.8765	0.0020
	1107-49	0.8740	0.8745					
N	1107-57	0.8743	0.8750	0.0000	0.0010	0.8723	0.8765	0.0020
	1107-61	0.8740	0.8745					

65-46436
65-71940
65-71969

BOEING
COMMERCIAL JET
OVERHAUL MANUAL

		Design Dimensions				Service Wear Limits		
Ref Letter Fig. 601	Mating Item No. Fig.	Dimensions (inches)		Assembly Clearance (inch)		Dimension Limits (inches)		Maximum Allowable Clearance (inch)
		Min	Max	Min	Max	Min	Max	
O	1106-48	0.8745	0.8781	0.0000	0.0041	0.8665	0.8825	0.0080
	1106-53	0.8740	0.8745					
O	1106-60	0.8745	0.8781	0.0000	0.0041	0.8665	0.8825	0.0080
	1106-65	0.8740	0.8745					
O	1107-44	0.8745	0.8781	0.0000	0.0041	0.8663	0.8827	0.0082
	1107-49	0.8740	0.8745					
O	1107-56	0.8745	0.8781	0.0000	0.0041	0.8663	0.8827	0.0082
	1107-61	0.8740	0.8745					
P	1108-10	0.2500	0.2540	0.0005	0.0055	0.2390	0.2605	0.0110
	1108-29	0.2485	0.2495					
Q	1108-10	0.2500	0.2540	0.0005	0.0055	0.2390	0.2605	0.0110
	1108-34	0.2485	0.2495					
R	1108-56	0.2150	0.2180	0.0020	0.0080	0.1990	0.2290	0.0160
	1108-53	0.2100	0.2130					
S	1108-57	0.3640	0.3660	0.0020	0.0080	0.3480	0.3780	0.0160
	1108-53	0.3580	0.3620					
T	1108-66*[1]	0.2495	0.2500	0.0000	0.0015	0.2465	0.2525	0.0030
	*[2]	0.2485	0.2495					
U	1108-76*[1]	0.2500	0.2515	0.0005	0.0030	0.2440	0.2555	0.0060
	*[2]	0.2485	0.2495					

Fits and Clearances
Figure 601 (Sheet 9)

BOEING
COMMERCIAL JET
OVERHAUL MANUAL

65-46436
65-71940
65-71969

		Design Dimensions				Service Wear Limits		
Ref Letter Fig. 601	Mating Item No. Fig.	Dimensions (inches)		Assembly Clearance (inch)		Dimension Limits (inches)		Maximum Allowable Clearance (inch)
		Min	Max	Min	Max	Min	Max	
V	1108-82	0.2500	0.2540	0.0005	0.0055	0.2390	0.2605	0.0110
	1108-85	0.2485	0.2495					
W	1108-138	0.3120	0.3160	0.0000	0.0045	0.3030	0.3210	0.0090
	1108-132	0.3115	0.3120					
X	1108-141	0.3120	0.3160	0.0000	0.0045	0.3030	0.3210	0.0090
	1108-132	0.3115	0.3120					
Y	1108-151	0.3120	0.3125	0.0000	0.0010	0.3100	0.3140	0.0020
	1108-132	0.3115	0.3120					
Y	1108-151	0.3120	0.3125	0.0000	0.0010	0.3100	0.3140	0.0020
	1108-147	0.3115	0.3120					
Z	1108-152	0.8135	0.8140	0.0010	0.0020	0.8095	0.8165	0.0040
	1108-151	0.8120	0.8125					
AA	1108-160	0.2500	0.2540	0.0005	0.0055	0.2390	0.2605	0.0110
	1108-125	0.2485	0.2495					
AA	1108-197	0.2500	0.2540	0.0005	0.0050	0.2400	0.2595	0.0100
	1108-208	0.2490	0.2495					
AB	1108-161	0.5000	0.5020	0.0005	0.0035	0.4930	0.5065	0.0070
	1108-176	0.4985	0.4995					
AC	1108-164	0.5000	0.5020	0.0005	0.0035	0.4930	0.5065	0.0070
	1108-176	0.4985	0.4995					

65-46436
65-71940
65-71969

BOEING
COMMERCIAL JET
OVERHAUL MANUAL

		Design Dimensions				Service Wear Limits		
Ref Letter Fig.601	Mating Item No. Fig.	Dimensions (inches)		Assembly Clearance (inch)		Dimension Limits (inches)		Maximum Allowable Clearance (inch)
		Min	Max	Min	Max	Min	Max	
AD	1108-168	0.3750	0.3790	0.0000	0.0050	0.3650	0.3850	0.0100
	1108-169	0.3740	0.3750					
AE	1108-186	0.3120	0.3160	0.0000	0.0045	0.3030	0.3210	0.0090
	1108-192	0.3115	0.3120					
AF	1108-198	0.3120	0.3125	0.0000	0.0010	0.3100	0.3140	0.0020
	1108-192	0.3115	0.3120					
AG	1109-36	0.3743	0.3750	0.0000	0.0015	0.3713	0.3775	0.0030
	1109-41	0.3735	0.3745					

*[1] Alternate configurations

*[2] Bolt NAS1104-4

65-46436
65-71940
65-71969

BOEING
COMMERCIAL JET
OVERHAUL MANUAL

STORAGE INSTRUCTIONS

1. Coat all bushings and bearings with a light coat of grease, Specification MIL-G-23827. Enclose bushings and bearings in nonabsorbent material.
2. Store assembly in a dry, cool area, preferably humidity controlled. Protect by covering or wrapping in heavy Kraft paper or similar material.
3. For general storage information, refer to Subject 20-44-02, Temporary Protective Coatings, and to Subject 20-70-01, Protection, Handling, and Storage of Airplane Components.

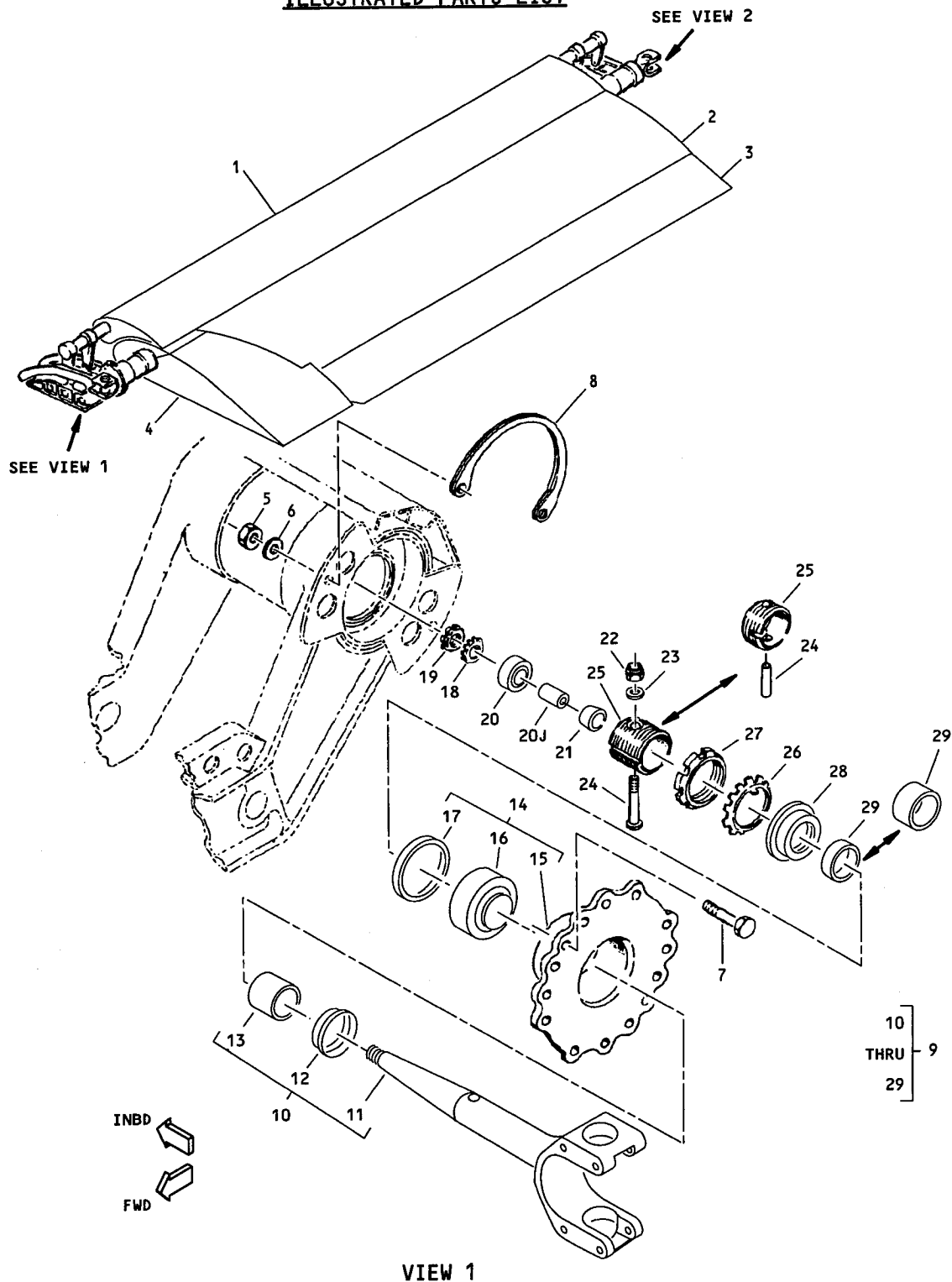
65-46436
65-71940
65-71969

BOEING
COMMERCIAL JET
OVERHAUL MANUAL

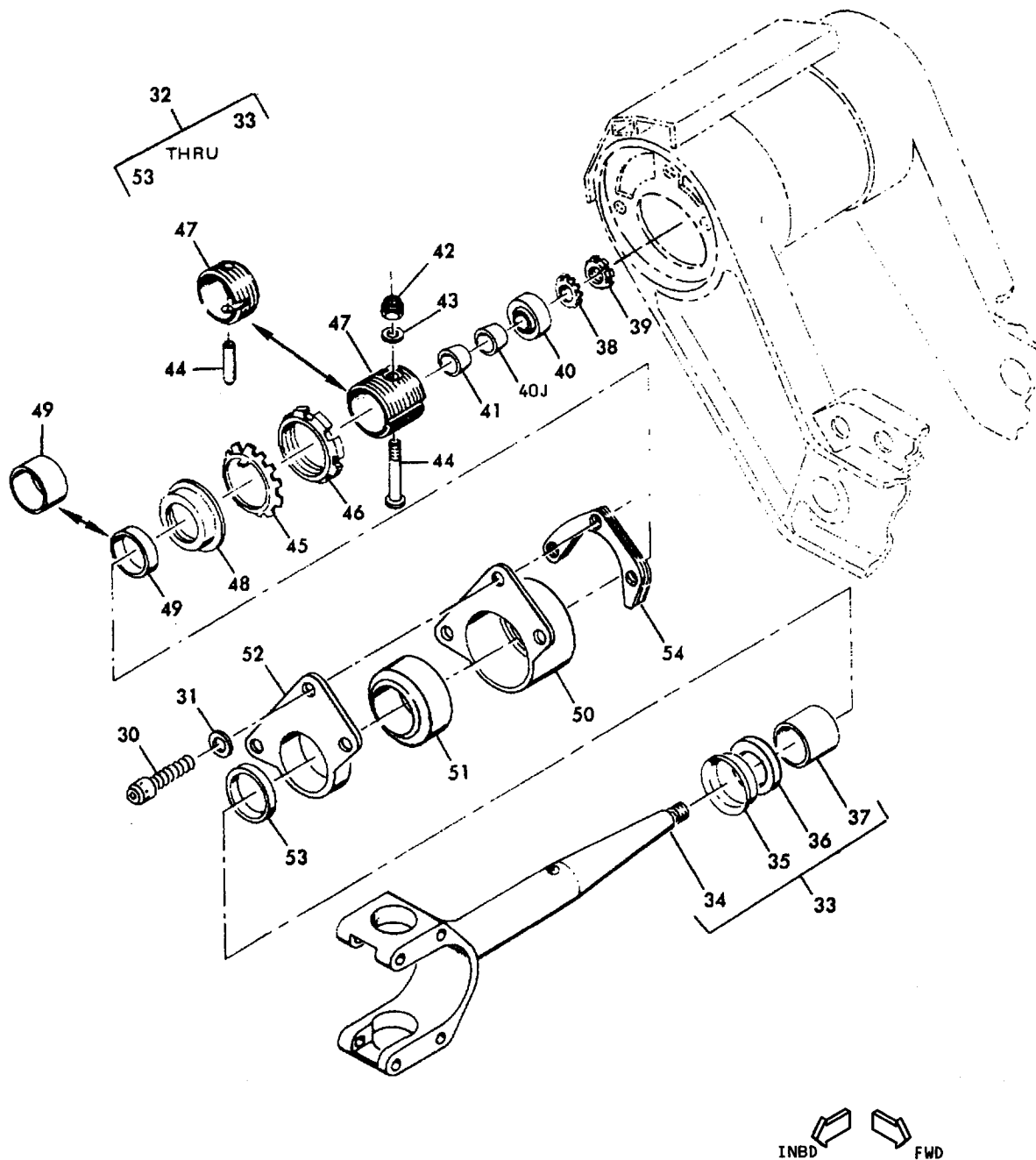
SPECIAL TOOLS, FIXTURES, AND EQUIPMENT

1. Tensiometer, Pacific Scientific Co., Model T5-2002-104-00, or equivalent
2. Rigging blocks, locally fabricated from 0.25-inch thick plastic or equivalent stock

ILLUSTRATED PARTS LIST



VIEW 1
Inboard Trailing Edge Flap Assembly
Figure 1101 (Sheet 1)



VIEW 2

Inboard Trailing Edge Flap Assembly
Figure 1101 (Sheet 2)

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
1101-	65-46436-5		INBD TE FLAP ASSY, LH							A	RF
	65-46436-6		INBD TE FLAP ASSY, RH							B	RF
	65-46436-7		INBD TE FLAP ASSY, LH							C	RF
	65-46436-8		INBD TE FLAP ASSY, RH							D	RF
	65-46436-11		INBD TE FLAP ASSY, LH							E	RF
	65-46436-12		INBD TE FLAP ASSY, RH							F	RF
	65-71969-1		INBD TE FLAP ASSY, LH (SB 57-1029)							G	RF
	65-71969-2		INBD TE FLAP ASSY, RH (SB 57-1029)							H	RF
	65-71969-3		INBD TE FLAP ASSY, LH (SB 57-1029)							I	RF
	65-71969-4		INBD TE FLAP ASSY, RH (SB 57-1029)							J	RF
	65-71940-15		INBD TE FLAP ASSY, LH							K	RF
	65-71940-16		INBD TE FLAP ASSY, RH							L	RF
	65-71940-17		INBD TE FLAP ASSY, LH							M	RF
	65-71940-18		INBD TE FLAP ASSY, RH							N	RF
	65-71940-27		INBD TE FLAP ASSY, LH							O	RF
	65-71940-28		INBD TE FLAP ASSY, RH							P	RF
	65-46436-13		INBD TE FLAP ASSY, LH							Q	RF
	65-46436-14		INBD TE FLAP ASSY, RH							R	RF
	65-71940-35		INBD TE FLAP ASSY, LH							S	RF
	65-71940-36		INBD TE FLAP ASSY, RH							T	RF
	65-46436-15		INBD TE FLAP ASSY, LH							U	RF
	65-46436-17		INBD TE FLAP ASSY, LH							V	RF
	65-46436-19		INBD TE FLAP ASSY, LH							W	RF
	65-46436-21		INBD TE FLAP ASSY, LH							X	RF
	65-46436-23		INBD TE FLAP ASSY, LH							Y	RF
	65-46436-16		INBD TE FLAP ASSY, RH							Z	RF
	65-46436-18		INBD TE FLAP ASSY, RH							BA	RF
	65-46436-20		INBD TE FLAP ASSY, RH							CA	RF
	65-46436-22		INBD TE FLAP ASSY, RH							DA	RF
	65-46436-24		INBD TE FLAP ASSY, RH							EA	RF
	65-46436-32		INBD TE FLAP ASSY, RH							FA	RF
	65-46436-34SP		INBD TE FLAP ASSY, RH *[3]							GA	RF
	65-46436-36SP		INBD TE FLAP ASSY, RH *[3]							HA	RF
	65-46436-40SP		INBD TE FLAP ASSY, RH *[3] (SB 27-1110) (PRE SB 57-1303) (PRE SB 57-1290)							IA	RF
	65-46436-42SP		INBD TE FLAP ASSY, RH *[3] (SB 27-1110)							JA	RF
	65-46436-44SP		INBD TE FLAP ASSY, RH *[3] SB 27-1110							KA	RF
	65-46436-31		INBD TE FLAP ASSY, LH							CB	RF
	65-46436-33SP		INBD TE FLAP ASSY, LH *[3]							DB	RF
	65-46436-35SP		INBD TE FLAP ASSY, LH *[3]							EB	RF
	65-46436-39SP		INBD TE FLAP ASSY, LH *[3] (SB 27-1110) (PRE SB 57-1303) (PRE SB 57-1290)							FB	RF
	65-46436-41SP		INBD TE FLAP ASSY, LH *[3] (SB 27-1110)							GB	RF
	65-46436-43SP		INBD TE FLAP ASSY, LH *[3] (SB 27-1110)							HB	RF

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-	65-46436-59		INBD TE FLAP ASSY, LH (REWORKED FROM 65-46436-39 PER SERVICE LETTER 737-SL-57-26)	IB	RF
	65-46436-60		INBD TE FLAP ASSY, RH (REWORKED FROM 65-46436-40 PER SERVICE LETTER 737-SL-57-26)	JB	RF
	65-46436-61SP		DELETED		
	65-46436-62SP		DELETED		
	65-46436-69SP		DELETED		
	65-46436-70SP		DELETED		
	65-46436-71SP		DELETED		
	65-46436-72SP		DELETED		
1	65-46430-75		. FOREFLAP ASSY, LH (SB 78-1005) (FIG. 1102) * [1]	ACQ	1
1	65-46430-76		. FOREFLAP ASSY, RH (SB 78-1005) (FIG. 1102) * [1]	BDR	1
1	65-46430-79		. FOREFLAP ASSY, LH (FIG. 1102) * [1]	ACEQ	1
1	65-46430-80		. FOREFLAP ASSY, RH (FIG. 1102) * [1]	BDFR	1
1	65-46430-83		. FOREFLAP ASSY, LH (FIG. 1102) * [1]	A	1
1	65-46430-84		. FOREFLAP ASSY, RH (FIG. 1102) * [1]	B	1
1	65-46430-87		. FOREFLAP ASSY, LH (FIG. 1102) * [1] (SB 27-1110) (PRE SB 57-1297) (PRE SB 57-1303) (PRE SB 57-1290)	AVX CB DB FB HB	1
1	65-46430-88		. FOREFLAP ASSY, RH (FIG. 1102) * [1] (SB 27-1110) (PRE SB 57-1297) (PRE SB 57-1303) (PRE SB 57-1290)	B BA DA FA GA IA KA	1
1	65-46430-97		. FOREFLAP ASSY, LH (FIG. 1102) (SB 27-1110)	UWY EB GB	1
1	65-46430-98		. FOREFLAP ASSY, RH (FIG. 1102) (SB 27-1110)	Z CA EA HA JA	1
1	65-46430-99		DELETED		
1	65-46430-100		DELETED		
1	65-46430-121		DELETED		
1	65-46430-122		DELETED		
1	65-46430-129		DELETED		
1	65-46430-130		DELETED		
1	65-71978-1		. FOREFLAP ASSY, LH (SB 78-1005) (FIG. 1102)	GI	1
1	65-71978-2		. FOREFLAP ASSY, RH (SB 78-1005) (FIG. 1102)	HJ	1
1	65-71940-23		. FOREFLAP ASSY, LH (FIG. 1102)	KM	1
1	65-71940-24		. FOREFLAP ASSY, RH (FIG. 1102)	LN	1
1	65-71940-33		. FOREFLAP ASSY, LH (FIG. 1102) * [1] (POST SB 57-1297) (POST SB 57-1303) (POST SB 57-1290)	AOS DB FB	1

65-46436
65-71940
65-71969



DASH NUMBERS LIMITED

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
1101-1	65-71940-34		.	FOREFLAP ASSY, RH (FIG. 1102))	[1]					BPT GA IA	1
				(POST SB 57-1297) (POST SB 57-1303)							
				(POST SB 57-1290)							
2	65-71902-1		.	MIDFLAP ASSY, LH (SB 57-1029)						AE	1
				(FIG. 1105)*	[1]						
2	65-71902-2		.	MIDFLAP ASSY, RH (SB 57-1029)						BF	1
				(FIG. 1105)*	[1]						
2	65-71902-3		.	MIDFLAP ASSY, LH (SB 57-1029)						C	1
				(FIG. 1105)*	[1]						
2	65-71902-4		.	MIDFLAP ASSY, RH (SB 57-1029)						D	1
				(FIG. 1105)*	[1]						
2	65-71902-9		.	MIDFLAP ASSY, LH (SB 57-1057)						AE	1
				(FIG. 1105)*	[1]						
2	65-71902-10		.	MIDFLAP ASSY, RH (SB 57-1057)						BF	1
				(FIG. 1105)*	[1]						
2	65-71902-11		.	MIDFLAP ASSY, LH (FIG. 1105)*	[1]					Q	1
2	65-71902-12		.	MIDFLAP ASSY, RH (FIG. 1105)*	[1]					R	1
2	65-71902-13		.	MIDFLAP ASSY, LH (FIG. 1105)*	[1]					A	1
2	65-71902-14		.	MIDFLAP ASSY, RH (FIG. 1105)*	[1]					B	1
2	65-71902-15		.	MIDFLAP ASSY, LH (REPLS						A	1
				65-71902-13)(FIG. 1105)							
2	65-71902-16		.	MIDFLAP ASSY, RH (REPLS						B	1
				65-71902-14)(Fig. 1105)							
2	65-71902-17		.	MIDFLAP ASSY, LH (FIG. 1105)						U	1
2	65-71902-18		.	MIDFLAP ASSY, RH (FIG. 1105)						Z	1
2	65-71902-19		.	MIDFLAP ASSY, LH (FIG. 1105)						V	1
2	65-71902-20		.	MIDFLAP ASSY, RH (FIG. 1105)						BA	1
2	65-71902-21		.	MIDFLAP ASSY, LH (FIG. 1105)						W	1
2	65-71902-22		.	MIDFLAP ASSY, RH (FIG. 1105)						CA	1
2	65-71902-23		.	MIDFLAP ASSY, LH (FIG. 1105)						X	1
2	65-71902-24		.	MIDFLAP ASSY, RH (FIG. 1105)						DA	1
2	65-71902-25		.	MIDFLAP ASSY, LH (FIG. 1105)						Y	1
2	65-71902-26		.	MIDFLAP ASSY, RH (FIG. 1105)						EA	1
2	65-71902-31		.	MIDFLAP ASSY, LH (FIG. 1105)						CB	1
2	65-71902-32		.	MIDFLAP ASSY, RH (FIG. 1105)						FA	1
2	65-71902-33		.	MIDFLAP ASSY, LH (FIG. 1105)						DB	1
2	65-71902-34		.	MIDFLAP ASSY, RH (FIG. 1105)						GA	1
2	65-71902-35		.	MIDFLAP ASSY, LH (FIG. 1105)						EB	1
2	65-71902-36		.	MIDFLAP ASSY, RH (FIG. 1105)						HA	1
2	65-71902-41		.	MIDFLAP ASSY, LH (FIG. 1105)*	[1]					FB	1
				(SB 27-1110) (PRE SB 57-1297)							
				(PRE SB 57-1303) (PRE SB 57-1290)							
2	65-71902-42		.	MIDFLAP ASSY, RH (FIG. 1105)*	[1]					IA	1
				(SB 27-1110) (PRE SB 57-1297)							
				(PRE SB 57-1303) (PRE SB 57-1290)							

Nov 1/08

57-53-22
Page 1105

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
1101-2	65-71902-43		.	MIDFLAP	ASSY,	LH	(FIG. 1105)*[1]			GB	1
				(SB 27-1110)							
2	65-71902-44		.	MIDFLAP	ASSY,	RH	(FIG. 1105)*[1]			JA	1
				(SB 27-1110)							
2	65-71902-45		.	MIDFLAP	ASSY,	LH	(FIG. 1105)*[1]			HB	1
				(SB 27-1110)							
2	65-71902-46		.	MIDFLAP	ASSY,	RH	(FIG. 1105)*[1]			KA	1
				(SB 27-1110)							
2	65-71902-49SP		.	MIDFLAP	ASSY,	LH	(FIG. 1105)			IB	1
2	65-71902-50SP		.	MIDFLAP	ASSY,	RH	(FIG. 1105)			JB	1
2	65-71971-1		.	MIDFLAP	ASSY,	LH	(SB 57-1029)			AGIQ	1
				(FIG. 1105)*[1]							
2	65-71971-2		.	MIDFLAP	ASSY,	RH	(SB 57-1029)			BHJR	1
				(FIG. 1105)*[1]							
2	65-71971-3		.	MIDFLAP	ASSY,	LH	(SB 57-1029)			CGI	1
				(FIG. 1105)*[1]							
2	65-71971-4		.	MIDFLAP	ASSY,	RH	(SB 57-1029)			DHJ	1
				(FIG. 1105)*[1]							
2	65-71940-21		.	MIDFLAP	ASSY,	LH	(FIG. 1105)			K	1
2	65-71940-22		.	MIDFLAP	ASSY,	RH	(FIG. 1105)			L	1
2	65-71940-25		.	MIDFLAP	ASSY,	LH	(FIG. 1105)			M	1
2	65-71940-26		.	MIDFLAP	ASSY,	RH	(FIG. 1105)			N	1
2	65-71940-31		.	MIDFLAP	ASSY,	LH	(FIG. 1105)			O	1
2	65-71940-32		.	MIDFLAP	ASSY,	RH	(FIG. 1105)			P	1
2	65-71940-37		.	MIDFLAP	ASSY,	LH	(FIG. 1105)			S	1
2	65-71940-38		.	MIDFLAP	ASSY,	RH	(FIG. 1105)			T	1
2	65-71971-133		.	MIDFLAP	ASSY,	LH	(FIG. 1105)*[1]			AQ	1
2	65-71971-134		.	MIDFLAP	ASSY,	RH	(FIG. 1105)*[1]			BR	1
2	65-71971-135		.	MIDFLAP	ASSY,	LH	(FIG. 1105)(OPT TO			Q	1
				65-71902-11)*[1]							
2	65C26310-7		DELETED								
2	65C26310-8		DELETED								
2	65C26310-11		DELETED								
2	65C26310-12		DELETED								
2	65C26310-13		DELETED								
2	65C26310-14		DELETED								
2	65-71971-136		.	MIDFLAP	ASSY,	RH	(FIG. 1105)(OPT TO			R	1
				65-71902-12)*[1]							
2	65-71940-41		.	MIDFLAP	ASSY,	LH	(POST SB 57-1297)			A DB FB	1
				(POST SB 57-1303) (POST SB 57-1290)							
				(FIG. 1105) *[1]							
2	65-71940-42		.	MIDFLAP	ASSY,	RH	(POST SB 57-1297)			B GA IA	1
				(POST SB 57-1303) (POST SB 57-1290)							
				(FIG. 1105) *[1]							

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
3	65-46434-89		DELETED		
3	65-46434-90		DELETED		
3	65-46434-117		. AFTFLAP ASSY, LH (FIG. 1104) *[1]	ACQ	1
3	65-46434-118		. AFTFLAP ASSY, RH (FIG. 1104) *[1]	BDR	1
3	65-46434-135		. AFTFLAP ASSY, LH (FIG. 1104)	EQ	1
3	65-46434-136		. AFTFLAP ASSY, RH (FIG. 1104)	FR	1
3	65-46434-139		. AFTFLAP ASSY, LH (FIG. 1104) (PRE SB 57-1303) (PRE SB 57-1290) (SB 27-1110) (PRE SB 57-1297)	AVX CB DB FB HB	1
3	65-46434-140		. AFTFLAP ASSY, RH (FIG. 1104) (PRE SB 57-1303) (PRE SB 57-1290) (SB 27-1110) (PRE SB 57-1297)	B BA DA FA GA IA KA	1
3	65-46434-179		. AFTFLAP ASSY, LH (FIG. 1104) (SB 27-1110)	UWY EB GB	1
3	65-46434-180		. AFTFLAP ASSY, RH (FIG. 1104)	Z CA EA HA JA	1
3	65-46434-181		DELETED		
3	65-46434-183		DELETED		
3	65-46434-182		DELETED		
3	65-46434-184		DELETED		
3	65-46434-301		DELETED		
3	65-46434-302		DELETED		
3	65-46434-335		DELETED		
3	65-46434-336		DELETED		
3	65-46434-351		DELETED		
3	65-46434-352		DELETED		
3	65-46434-367		DELETED		
3	65-46434-368		DELETED		
3	65-71970-1		. AFTFLAP ASSY, LH (SB 57-1029) (FIG. 1104)*[1]	ACGI	1
3	65-71970-2		. AFTFLAP ASSY, RH (SB 57-1029) (FIG. 1104)*[1]	BDHJ	1
3	65-71940-19		. AFTFLAP ASSY, LH (FIG. 1104)	KM	1
3	65-71940-20		. AFTFLAP ASSY, RH (FIG. 1104)	LN	1
3	65-71940-29		. AFTFLAP ASSY, LH (FIG. 1104) *[1] (POST SB 57-1297) (POST SB 57-1303) (POST SB 57-1290)	AOS DB FB	1
3	65-71940-30		. AFTFLAP ASSY, RH (FIG. 1104) *[1] (POST SB 57-1297) (POST SB 57-1303) (POST SB 57-1290)	BPT GA IA	1
			INSTALLATION PARTS		
4	65-71926-1		FLIPPER FLAP ASSY, LH (SB 78-1005) (FIG. 1103) (REF 65-73731)	ACEQ	1
4	65-71926-2		FLIPPER FLAP ASSY, RH (SB 78-1005) (FIG. 1103)	BDFR	1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
4	65-71926-59		FLIPPER FLAP ASSY, LH (FIG. 1103)	AE	1
4	65-71926-60		FLIPPER FLAP ASSY, RH (FIG. 1103)	BF	1
4	65-71926-65		FLIPPER FLAP ASSY, LH (FIG. 1103)	AEVX CB	1
4	65-71926-66		FLIPPER FLAP ASSY, RH (FIG. 1103)	BF BA DA FA	1
4	65-71926-77		FLIPPER FLAP ASSY, LH (FIG. 1103)	AE	1
4	65-71926-67		FLIPPER FLAP ASSY, LH (OPT)	AE	1
4	65-71926-78		FLIPPER FLAP ASSY, RH (FIG. 1103)	BF	1
4	65-71926-68		FLIPPER FLAP ASSY, RH (OPT)	BF	1
5	BACN10JC4		NUT (REPLS NAS679A4W)		2
6	AN960PD416		WASHER		2
7	NAS1104-10		BOLT (REPLS NAS1104-10W)		2
8	69-42965-1		SHIM, LAMINATED (OPT NAS1149D0463J AND NAS1149D0416J)		1
8A	NAS1149D0463J		WASHER (OPT 69-42965-1)		1
8B	NAS1149D0416J		WASHER (OPT 69-42965-1)		1
9	65-50588-5		GIMBAL ASSY, OUTBD *[1] REF 65-45108		1
9	65-50588-6		GIMBAL ASSY, OUTBD *[1] REF 65-61765		1
9	65-50588-7		GIMBAL ASSY, OUTBD *[1] REF 65-61765		1
9	65-50588-9		GIMBAL ASSY, OUTBD *[1] REF 65-45108		1
9	65-50588-10		GIMBAL ASSY, OUTBD *[1] REF 65-45108		1
9	65-50588-19		GIMBAL ASSY, OUTBD *[1] REF 65-45108		1
9	65-50588-20		GIMBAL ASSY, OUTBD *[1] REF 65-45108		1
10	65-50539-1		. SHAFT ASSY (USED ON 65-50588-5)		1
10	65-50539-6		. SHAFT ASSY (USED ON 65-50588-6,-7, -9,-10,-19,-20)		1
11	65-50539-2		. . SHAFT		1
12	69-37962-2		. . COLLAR		1
13	65-50539-4		. . SLEEVE (USED ON 65-50539-1)		1
13	65-50539-7		. . SLEEVE (USED ON 65-50539-6)		1
14	65-50585-6		. PLATE ASSY, INDEXING (USED ON 65-50588-5)		1
14	65-50585-8		. PLATE ASSY, INDEXING (USED ON 65-50588-6)		1
14	65-50585-10		. PLATE ASSY, INDEXING (USED ON 65-50588-7)		1
14	65-50585-15		. PLATE ASSY, INDEXING (USED ON 65-50588-9)		1
14	65-50585-16		. PLATE ASSY, INDEXING (USED ON 65-50588-10)		1
14	65-50585-17		. PLATE ASSY, INDEXING (USED ON 65-50588-19)		1
14	65-50585-18		. PLATE ASSY, INDEXING (USED ON 65-50588-20)		1

65-46436
65-71940
65-71969



DASH NUMBERS LIMITED

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	N O M E N C L A T U R E							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
1101-15	65-50585-7		.	.							1
15	65-50585-9		.	.							1
15	65-50585-11		.	.							1
15	65-50585-13		.	.							1
15	65-50585-14		.	.							1
15	65-50585-19		.	.							1
15	65-50585-20		.	.							1
16	BLFN17-003		.	.							1
16	BS34ATC56-2		.	.							1
16	KSBY17N1		.	.							1
16	YTA228		.	.							1
16	117182		.	.							1
17	66-24115-1		.	.							1
18	MS172202		.								1
19	MS172237		.								1
20	BLFN8-017		.								1
20	BS16ATC32		.								1
20	KSBN8		.								1
20	03-713-0500		.								1
20J	NAS1057T8-007		.								1
21	69-37962-1		.								1
22	BACN10JC4		.								1
23	AN960-416		.								1
24	NAS1104-20		.								1
24	69-52260-2		.								1

Nov 1/08

57-53-22
Page 1107

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-25	69-37961-1		. BUSHING, THREADED (USED ON 65-50588-5)		1
25	69-37961-2		. BUSHING, THREADED (USED ON 65-50588-6, -7, -9, -10, -19, -20)		1
26	MS172208		. WASHER, KEY		1
27	MS172243		. NUT, SPANNER		1
28	66-24116-1		. RETAINER, BUSHING		1
29	69-43122-2		. SPACER (USED ON 65-50588-5)		1
29	69-43122-5		. SPACER (USED ON 65-50588-6, -7, -9, -10, -19, -20)		1
30	MS24678-25		CAPSCREW		3
31	AN960-416		WASHER		3
32	65-51622-3		GIMBAL ASSY, INBD, LH *[1]		1
32	65-51622-5		GIMBAL ASSY, INBD, LH (REPLS 65-51622-3) *[1] (REF 65-45108)		1
32	65-51622-13		GIMBAL ASSY, INBD, LH		1
32	65-51622-4		GIMBAL ASSY, INBD, RH *[1]		1
32	65-51622-6		GIMBAL ASSY, INBD, RH (REPLS 65-51622-4) *[1]		1
32	65-51622-14		GIMBAL ASSY, INBD, RH		1
33	65-50539-5		. SHAFT ASSY (USED ON 65-51622-3 AND -4)		1
33	65-50539-6		. SHAFT ASSY (USED ON 65-51622-5, -6, -13, -14)		1
34	65-50539-2		. . SHAFT		1
35	69-37962-2		. . COLLAR		1
36	69-43122-1		. . SPACER (USED ON 65-50539-5 ONLY)		1
37	65-50539-4		. . SLEEVE (USED ON 65-50539-5 ONLY)		1
37	65-50539-7		. . SLEEVE (USED ON 65-50539-6 ONLY)		1
38	MS172202		. WASHER, KEY		1
39	MS172237		. NUT, SPANNER		1
40	BLFN8-017		. BEARING, V81376 (BOEING 10-60545-104)		1
40	BS16ATC32		. BEARING, V21335 (BOEING 10-60545-104)		1
40	KSBN8		. BEARING, V97613 (BOEING 10-60545-104)		1
40	TFA8		. BEARING, V77896 (BOEING 10-60545-104)		1
40	03-713-0500		. BEARING, V09455 (BOEING 10-60545-104)		1
40J	NAS1057T8-007		. SPACER *[4]		1
41	69-37962-1		. SLEEVE		1
42	BACN10JC4		. NUT (USED ON 65-51622-3, -4) (REPLS NAS679A4W)		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-43	AN960-416		. WASHER (USED ON 65-51622-3, -4)		1
44	NAS1104-20		. BOLT (USED ON 65-51622-3,-4) (REPLS NAS1104-20W)		1
44	69-52260-2		. PIN (USED ON 65-51622-5,-6,-13,-14)		1
45	69-42964-1		. WASHER, KEY		1
46	MS172243		. NUT, SPANNER		1
47	69-37961-1		. BUSHING, THREADED (USED ON 65-51622-3,-4)		1
47	69-37961-2		. BUSHING, THREADED (USED ON 65-51622-5,-6,-13,-14)		1
48	66-24116-1		. RETAINER		1
49	69-43122-1		. SPACER (USED ON 65-51622-3, -4)		1
49	69-43122-6		. SPACER (USED ON 65-51622-5,-6,-13,-14)		1
50	69-43120-1		. RETAINER, LH (USED ON 65-51622-3 ONLY)		1
50	69-43120-3		. RETAINER, LH (USED ON 65-51622-5 ONLY)		1
50	69-43120-5		. RETAINER, LH (USED ON 65-51622-13)		1
50	69-43120-2		. RETAINER, RH (USED ON 65-51622-4 ONLY)		1
50	69-43120-4		. RETAINER, RH (USED ON 65-51622-6 ONLY)		1
50	69-43120-6		. RETAINER, RH (USED ON 65-51622-14)		1
51	BLFN17-003		. BEARING, V81376 (BOEING 10-60545-42)		1
51	BS34ATC56-2		. BEARING, V21335 (BOEING 10-60545-42)		1
51	KSBY17N1		. BEARING, V97613 (BOEING 10-60545-42)		1
51	YTA228		. BEARING, V77896 (BOEING 10-60545-42)		1
51	117182		. BEARING, V09455 (BOEING 10-60545-42)		1
52	69-43121-1		. RETAINER (USED ON 65-51622-3,-5)		1
52	69-43121-3		. RETAINER (USED ON 65-51622-13)		1
52	69-43121-2		. RETAINER (USED ON 65-51622-4,-6)		1
52	69-43121-4		. RETAINER (USED ON 65-51622-14)		1
53	69-43122-3		. SPACER (USED ON 65-51622-5,-6,-13,-14)		3
54	69-42970-1		SHIM		3
-60	65-46430-73		. SHIM		6
-65	65-46430-74		. SHIM		6
-70	65C26311-29		DELETED		1
-70	65C26311-30		DELETED		1
-70	65C26311-73		DELETED		1
-70	65C26311-74		DELETED		1
-70	65C26311-81		DELETED		1
-70	65C26311-82		DELETED		1
-70	65C26311-511		DELETED		1
-70	65C26311-512		DELETED		1

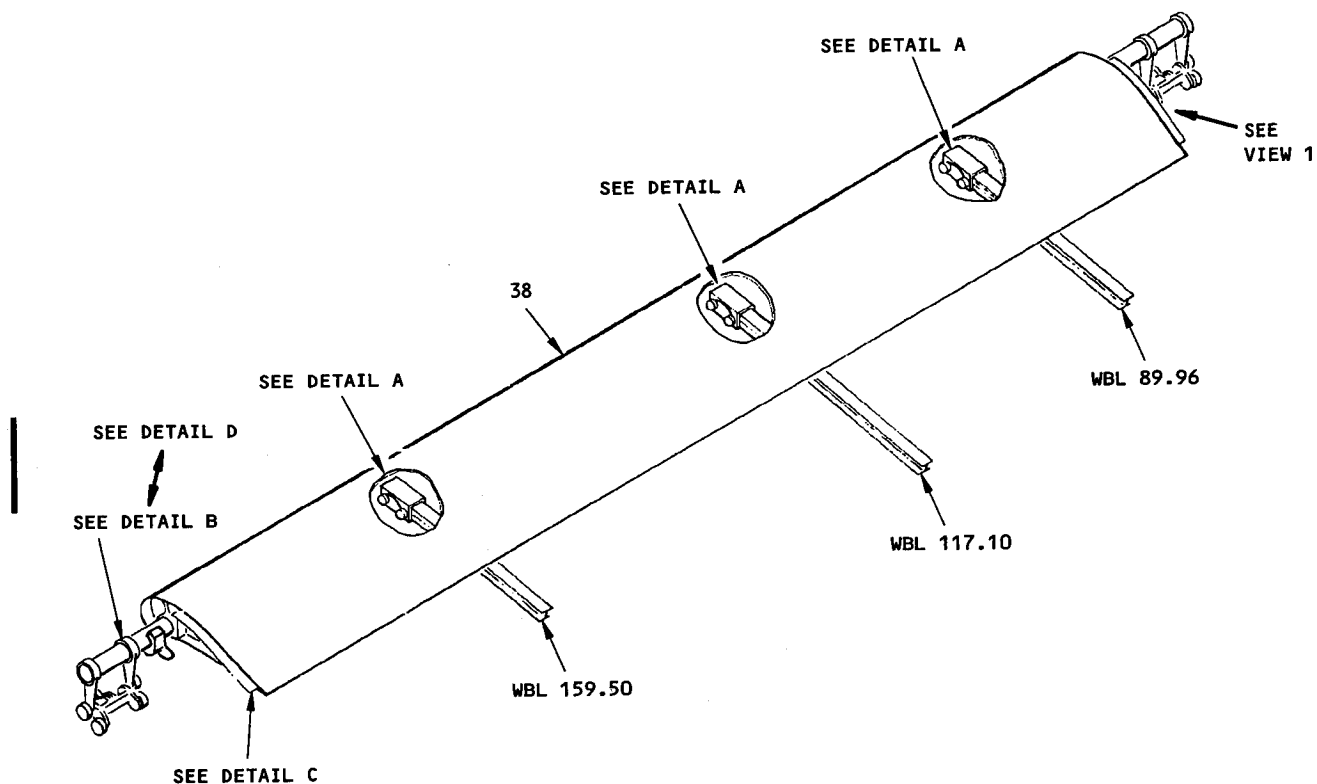
FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
1101-											
-75	65C27575-11										1
-75	65C27575-12										1
-80	BACB30LT4-22										3
-85	BACB30LT5-22										3
-90	BACB30LE4-22										3
-95	BACB30LE5-22										3
-100	BACB30NR4K7										3
-100	BACN10HR4CD										3
-105	BACN10HR5CD										3
-110	BACN10YR4CD										3
-115	BACN10YR5CD										3
-120	BACS18K25-14W										3
-125	BACW10BP4APU										3
-130	BACW10BP5APU										3
-135	BACW10BP4ACU										3
-140	BACW10BP5ACU										3

*[1] LIMITED USAGE

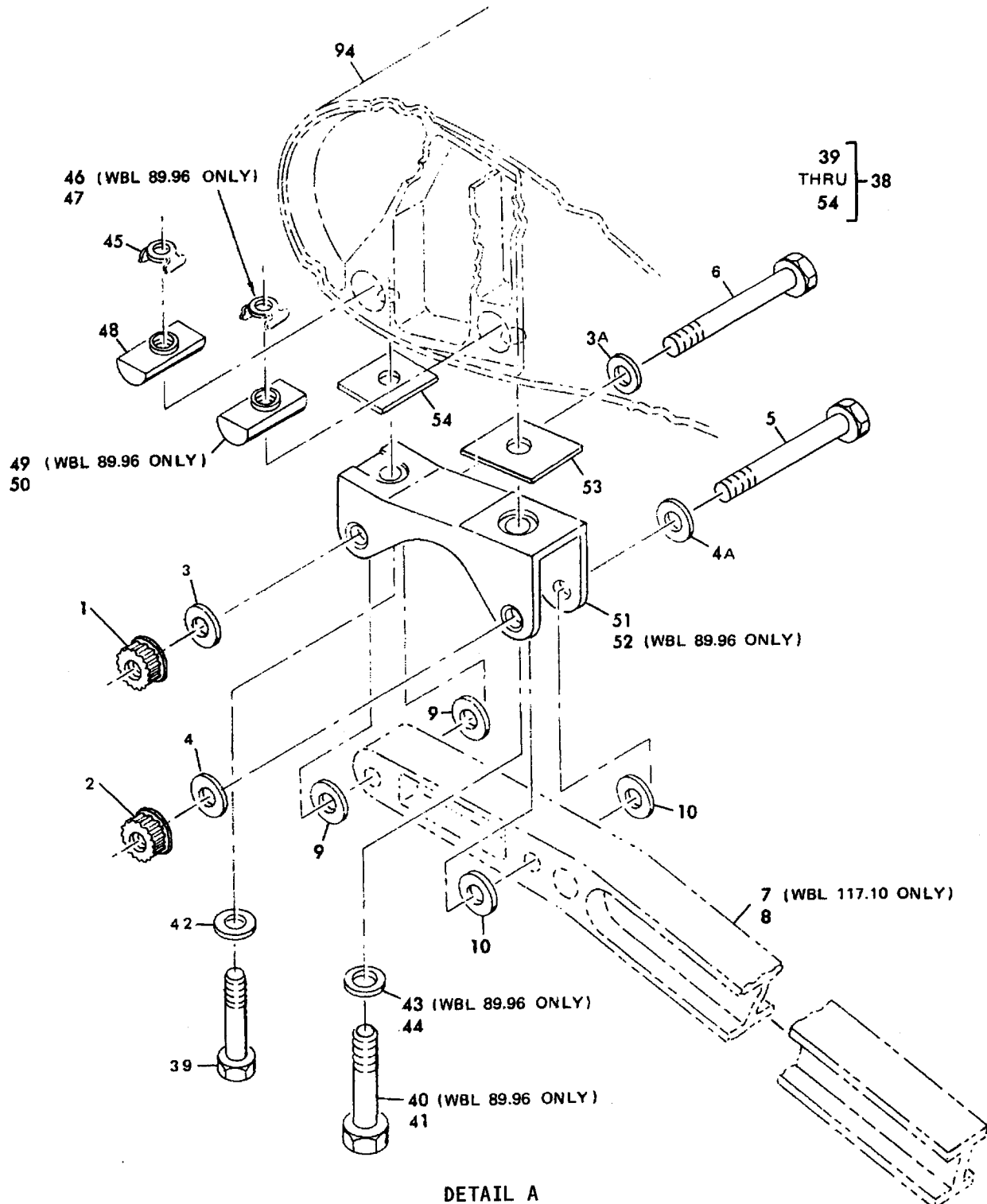
*[2] NO BOEING PART NUMBER ASSIGNED

*[3] COLOR CODED PARTS ARE IDENTIFIED WITH AN ALPHA "SP" SUFFIX. THIS ENTRY REPRESENTS CONSOLIDATION OF ALL COLOR CODES APPLICABLE FOR A GIVEN USAGE. ORDERS FOR COLOR CODED PARTS SHOULD INCLUDE THE REGISTRY NUMBER OF THE AIRPLANE FOR WHICH THE PARTS ARE ORDERED.

*[4] TO ACHIEVE CLAMP UP, ONE SPACER (20J, 40J) MAY BE INSERTED BETWEEN SLEEVE (21, 41) AND BEARING (20, 40), IF AND AS REQUIRED.



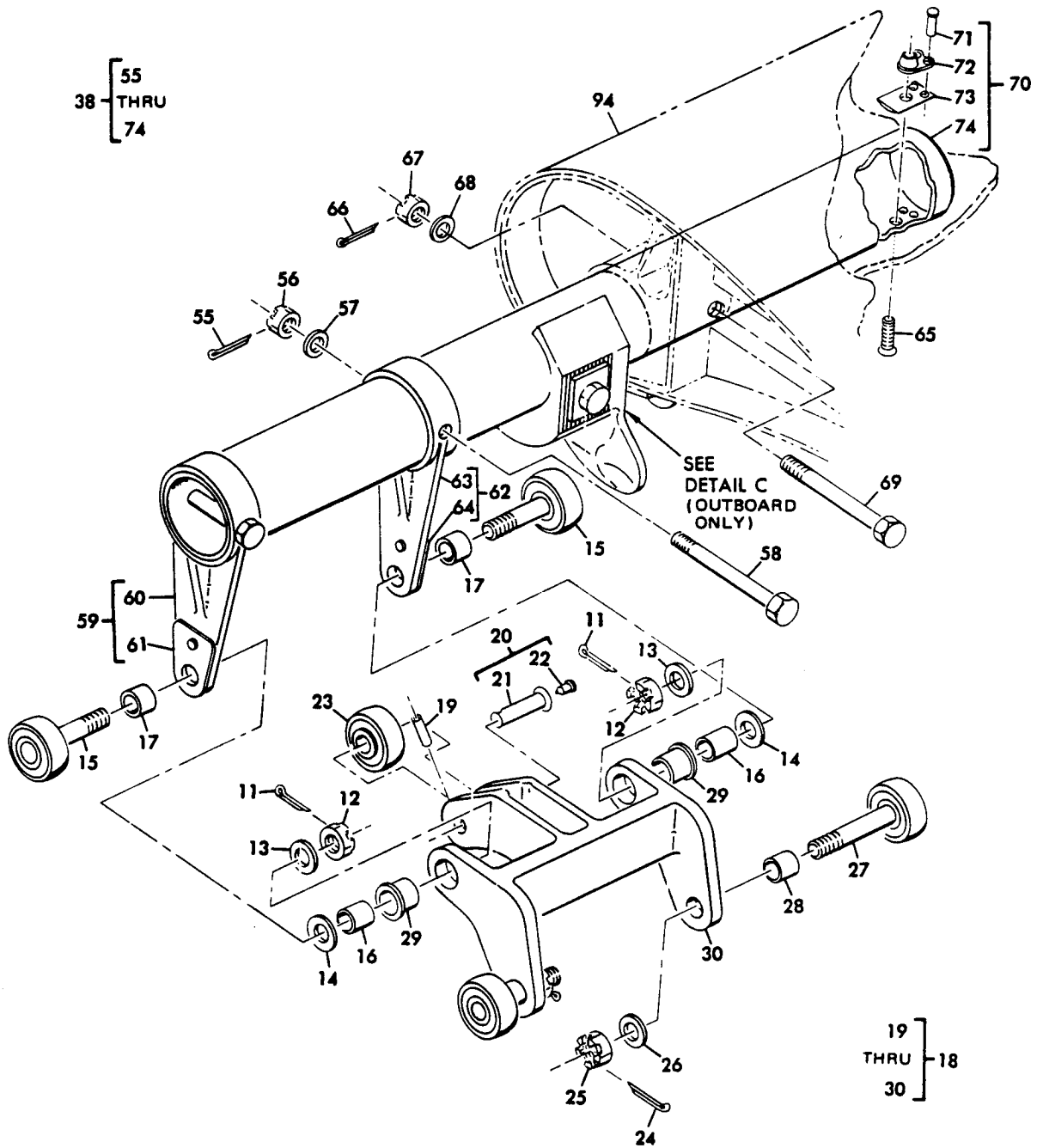
Fore Flap Assembly
Figure 1102 (Sheet 1)



Fore Flap Assembly
Figure 1102 (Sheet 2)

65-46436
65-71940
65-71969

BOEING
COMMERCIAL JET
OVERHAUL MANUAL



DETAIL B
(OUTBOARD SHOWN, INBOARD OPPOSITE)

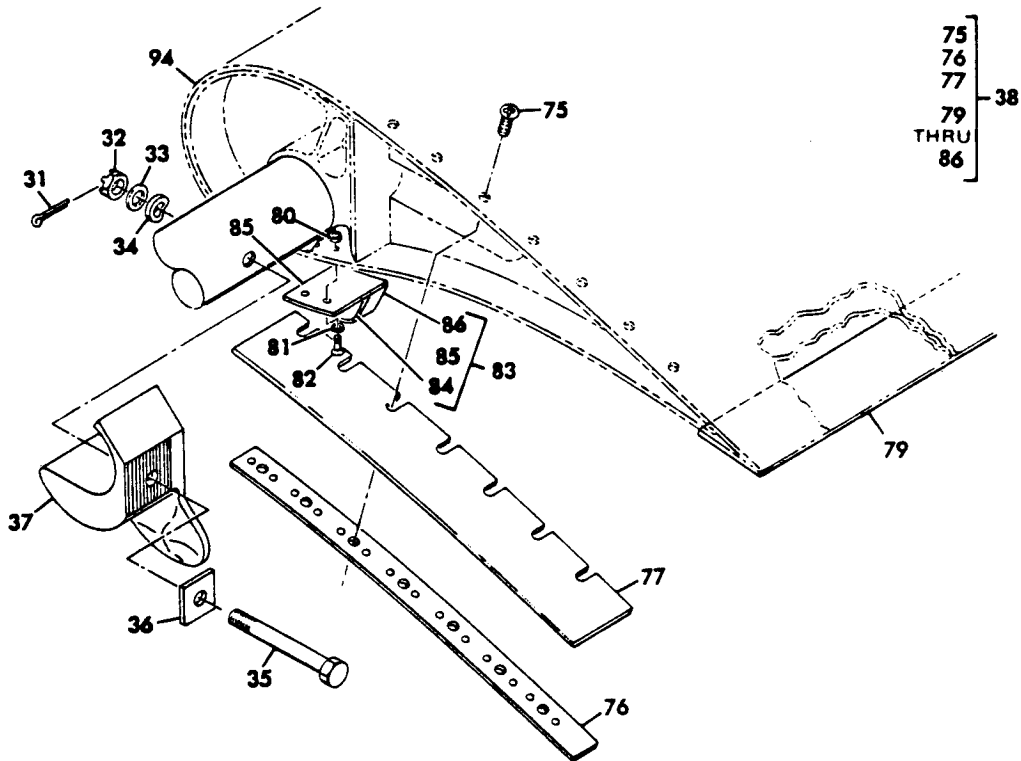
Jun 10/71

Fore Flap Assembly
Figure 1102 (Sheet 3)

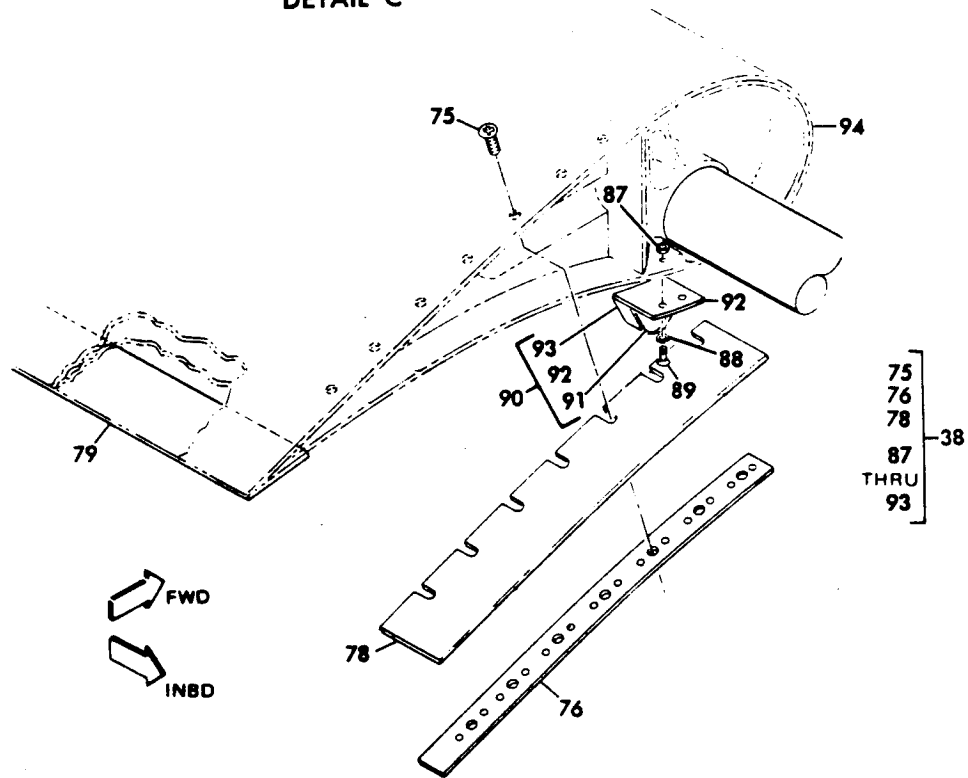
57-53-22
Page 1111

BOEING
COMMERCIAL JET
OVERHAUL MANUAL

65-46436
 65-71940
 65-71969

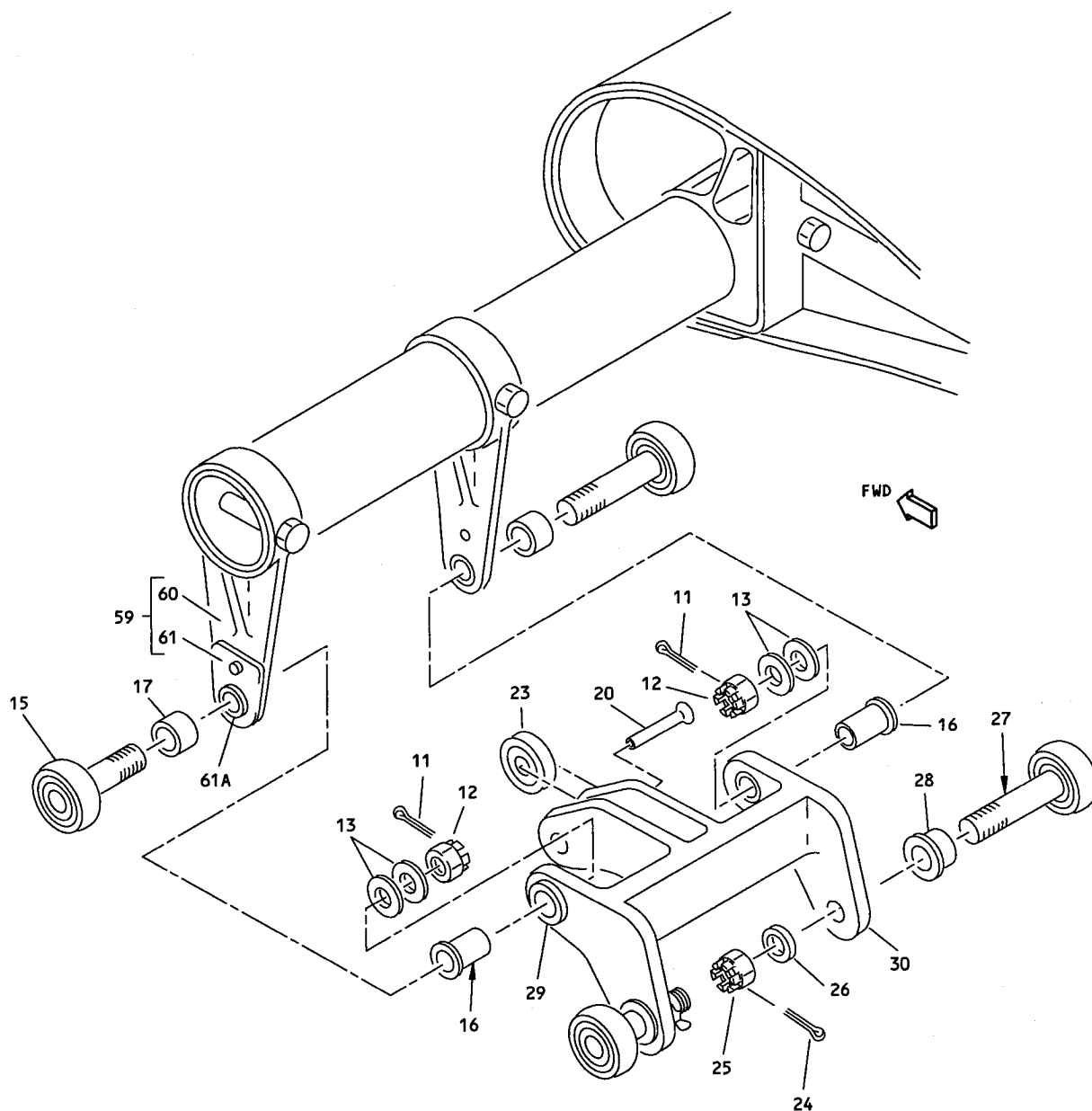


DETAIL C



VIEW 1

Fore Flap Assembly
 Figure 1102 (Sheet 4)



69-35336-3 AND CONFIGS POST SB 57-1222

DETAIL D

Fore Flap Assembly
Figure 1102 (Sheet 5)

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
1102-	65-46430-75		FOREFLAP ASSY (LH)(SB'S 78-1005, 57-1032)(PRE SB 57-1222) *[2]							A	RF
	65-46430-76		FOREFLAP ASSY (RH)(SB'S 78-1005, 57-1032)(PRE SB 57-1222) *[2]							B	RF
	65-46430-79		FOREFLAP ASSY (LH)(SB 57-1032)(PRE SB 57-1222) *[2]							C	RF
	65-46430-80		FOREFLAP ASSY (RH)(SB 57-1032)(PRE SB 57-1222) *[2]							D	RF
	65-46430-99		DELETED								
	65-46430-100		DELETED								
	65-46430-121		DELETED								
	65-46430-122		DELETED								
	65-46430-129		DELETED								
	65-46430-130		DELETED								
	65-71978-1		FOREFLAP ASSY (LH)(SB 78-1005)							E	RF
	65-71978-2		FOREFLAP ASSY (RH)(SB 78-1005)							F	RF
	65-71940-23		FOREFLAP ASSY (LH)							G	RF
	65-71940-24		FOREFLAP ASSY (RH)							H	RF
	65-46430-83		FOREFLAP ASSY, LH *[1] (PRE SB 57-1222) *[2]							I	RF
	65-46430-84		FOREFLAP ASSY, RH *[1] (PRE SB 57-1222) *[2]							J	RF
	65-46430-87		FOREFLAP ASSY, LH (PRE SB 57-1222) *[2] (PRE SB 57-1297) (PRE SB 57-1303) (PRE SB 57-1290)							K	RF
	65-46430-88		FOREFLAP ASSY, RH (PRE SB 57-1222) *[2] (PRE SB 57-1297) (PRE SB 57-1303) (PRE SB 57-1290)							L	RF
	65-71940-33		FOREFLAP ASSY (LH) *[1] (POST SB 57-1297) (POST SB 57-1303) (POST SB 57-1290)							M	RF
	65-71940-34		FOREFLAP ASSY (RH) *[1] (POST SB 57-1297) (POST SB 57-1303) (POST SB 57-1290)							N	RF
	65-46430-97		FOREFLAP ASSY, LH, FIBERGLASS REINFORCED (PRE SB 57-1222) *[2]							O	RF
	65-46430-98		FOREFLAP ASSY, RH, FIBERGLASS REINFORCED (PRE SB 57-1222) *[2]							P	RF
1	BACN10GW4		. NUT							A-P	3
2	BACN10GW5		. NUT							A-P	3
3	AN960-416L		. WASHER							A-P	3
3A	BACW10BN4C		. WASHER							A-P	2
4	AN960-516L		. WASHER							A-P	3
4A	BACW10BN5C		. WASHER							A-P	2
5	BACB30LE5-22		. BOLT							AP	3
5	BACB30FD5-21		. BOLT (OPT TO BACB30LE5-22)							AB	3

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE							USE CODE	QTY PER ASSY	
			1	2	3	4	5	6	7			
1102-												
6	BACB30LE4-22		.	B	O	L	T			AP	3	
6	BACB30FD4-21		.	B	O	L	T (OPT TO BACB30LE4-22)			AB	3	
6	MS20004-22		DELETED									
7	65-50746-1		.	T	R	A	C	K (FIG. 1105)		A-P	1	
8	65-47901-1		.	T	R	A	C	K (FIG. 1105)		A-P	2	
9	65-46436-9		.	S	H	I	M, LAMIN. WASHER			A-P	6	
9	65-46430-73		.	S	H	I	M OPT TO 65-46436-9			A-P	AR	
10	65-46436-10		.	S	H	I	M, LAMIN. WASHER			A-P	6	
10	65-46430-74		.	S	H	I	M OPT TO 65-46436-10			A-P	AR	
11	MS24665-283		.	P	I	N, COTTER (REPLS AN380-3-3)				A-P	4	
12	BACN10JD106		.	N	U	T (USED WITH BACB10AF6F16H OR BACB10BH60F11)(REPLS AN320-6)					4	
12	BACN10JD6		.	N	U	T (USED WITH BACB10BH60F12) (REPLS AN310-6)				A-P	4	
13	AN960-616		.	W	A	S	H	E	R	E-H M N	4	
13	AN960-616		.	W	A	S	H	E	R (PRE SB 57-1222)	A-DI-LOP	4	
13	AN960-616L		.	W	A	S	H	E	R (OPT)	E-H M N	AR	
13	AN960-616L		.	W	A	S	H	E	R (OPT)(PRE SB 57-1222)	A-DI-LOP	AR	
13	NAS1149C0663R		.	W	A	S	H	E	R (POST SB-1222) *[3]	A-DI-LOP	4	
15	AN960C816L		.	W	A	S	H	E	R		4	
15	BACB10AF6F16H		.	B	E	A	R	I	N (PREFERRED)	E-H M N	4	
15	BACB10AF6F16H		.	B	E	A	R	I	N (PREFERRED) (PRE SB 57-1222)	A-DI-LOP	4	
15	BACB10BH60F11		.	B	E	A	R	I	N (OPT)	E-H M N	4	
15	BACB10BH60F11		.	B	E	A	R	I	N (OPT)(PRE SB 57-1222)	A-DI-LOP	4	
15	BACB10BH60F11		.	B	E	A	R	I	N (OPT) (REPLS BACB10BH60CF11)		4	
15	BACB10BH60F12		.	B	E	A	R	I	N (OPT)	E-H M N	4	
15	BACB10BH60F12		.	B	E	A	R	I	N (OPT)(PRE SB 57-1222)	A-DI-LOP	4	
15	KRP141500VT6- 17		.	C	A	M	F	O	L	L	A	4
						(POST SB 57-1222)						
16	BACB28Y6C43		.	B	U	S	H	I	N	E-H M N	4	
16	BACB28Y6C43		.	B	U	S	H	I	N (PRE SB 57-1222)	A-DI-LOP	4	
16	BACB28X6C51		.	B	U	S	H	I	N (POST SB 57-1222)	A-DI-LOP	4	
17	NAS75-6-008		.	B	U	S	H	I	N	E-H M N	4	
17	NAS75-6-008		.	B	U	S	H	I	N (PRE SB 57-1222)	A-DI-LOP	4	
17	BACB28Y6C18		.	B	U	S	H	I	N (POST SB 57-1222)	A-DI-LOP	4	
18	69-35336-1		.	T	O	G	G	L	E	A	E-H M N	2
18	69-35336-1		.	T	O	G	G	L	E	A	E-H M N	2
						(PRE SB 57-1222)				A-DI-LOP	2	

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
1102-											
18	69-35336-2		.							E-H M N	2
18	69-35336-2		.							A-D I-L O P	2
18	69-35336-3		.							A-D I-L O P	4
19	MS16562-10		.	.							1
20	66-23212-1		.	.							1
20	69-77698-1		.	.							1
21	66-23212-2		.	.	.						1
22	NAS516-1		.	.	.						1
23	BACB10BN04										
23	BACB10ET04										
23	KRP502-4VT		.	.							1
24	MS24665-283		.	.							2
25	BACN10JD106		.	.							2
26	AN960-616		.	.							2
26	NAS1149C0663R		.	.							2
27	BACB10BH60F11		.	.							2
27	BACB10B196-11		.	.							2
27	BACB10AF6F14H		.	.							2
27	KRP141500VT6-16		.	.							2
28	NAS75-6-020		.	.							2
28	BACB28X6C55		.	.							2
29	BACB28X8B25		.	.							2
29	KJB331308V		.	.							2
30	69-35329-1		.	.							1
30	65C33100-1		.	.							1
30	65C33100-3		.	.							1
30	65C33100-4		.	.							1
31	MS24665-134		.	.						A-P	1
32	BACN10JD4		.	.						A-P	1
33	AN960PD416		.	.						A-P	1
34	69-59830-1		.	.						A-P	1
35	BACB30NE4D38		.	.						A-P	1
36	69-57855-1		.	.						A-P	1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1102					
37	65-76102-1		. GUIDE (SB 78-1005)	ACE	1
37	65-76102-1		. GUIDE	GIKMO	1
37	65-76102-2		. GUIDE (SB 78-1005)	BDF	1
37	65-76102-2		. GUIDE	HJLNP	1
37	65-76102-3		. GUIDE *[1]	KO	1
37	65-76102-4		. GUIDE *[1]	LP	1
38	65-46430-77		. FLAP ASSY (OPT)	ACEG	1
-38	65-46430-77		. FLAP ASSY (OPT)	ACEG	1
38	65-46430-78		. FLAP ASSY (OPT)	BDFH	1
-38	65-46430-78		. FLAP ASSY (OPT)	BDFH	1
38	65-46430-85		. FLAP ASSY (PREFERRED)	ACEGI	1
-38	65-46430-85		. FLAP ASSY (PREFERRED)	ACEGI	1
38	65-46430-86		. FLAP ASSY (PREFERRED)	BDFHJ	1
-38	65-46430-86		. FLAP ASSY (PREFERRED)	BDFHJ	1
38	65-46430-89		. FLAP ASSY	KMO	1
-38	65-46430-89		. FLAP ASSY	KMO	1
38	65-46430-90		. FLAP ASSY	LNP	1
-38	65-46430-90		. FLAP ASSY	LNP	1
-38	65-46430-101		DELETED		1
-38	65-46430-102		DELETED		1
-38	65-46430-119		DELETED		1
-38	65-46430-120		DELETED		1
-38	65-46430-131		DELETED		1
-38	65-46430-132		DELETED		1
-38	65-46430-149		DELETED		1
-38	65-46430-150		DELETED		1
-39	BACB30DM4-8H		. . BOLT	A-P	3
-40	66-26119-2		. . BOLT (OPT TO BACB30DM5-9H)	A-P	1
-40	BACB30DM5-9H		. . BOLT	A-P	1
-41	66-26119-3		. . BOLT (OPT TO BACB30DM6-10H)	A-P	2
-41	BACB30DM6-10H		. . BOLT	A-P	2
-42	BACW10P46S		. . WASHER	A-P	3
-43	BACW10P219S		. . WASHER	A-P	1
-44	BACW10P221S		. . WASHER	A-P	3
-45	BACR10V4		. . RETAINER	A-P	3
-46	BACR10V5		. . RETAINER	A-P	1
-47	BACR10V6		. . RETAINER		2
-48	BACN10HC4		. . NUT, CYLINDRICAL (REPLS BACN10CP4H)	A-P	3
-49	BACN10HC5		. . NUT, CYLINDRICAL (REPLS BACN10CP5H)	A-P	1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	N O M E N C L A T U R E							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
1102- -50	BACN10HC6		.	.	NUT, CYLINDRICAL (REPLS BACN10CP6H)					A-P	1
-51	65-90854-1		.	.	BRACKET, TRACK (ADDED BY SB 57- 1097)					A-P	2
-51	69-35349-1		.	.	BRACKET, TRACK						2
-52	69-35349-3		.	.	BRACKET, TRACK					A-P	1
-52	65-90854-3		.	.	BRACKET, TRACK (ADDED BY SB 57- 1097)					A-P	1
-53	BACS40R14B14F		.	.	SHIM					A-P	3
-54	BACS40R07B14F		.	.	SHIM						AR
-55	MS24665-134		.	.	PIN, COTTER (REPLS AN380-2-3)					A-P	4
-56	BACN10JD104		.	.	NUT (REPLS AN320-4)					A-P	4
-57	AN960-416		.	.	WASHER					A-P	4
-58	NAS1104-36D		.	.	BOLT (REPLS NAS1104-36DW)					A-P	4
-59	69-38802-3		.	.	SUPPORT ASSY					E-H M N	2
-59	69-38802-3		.	.	SUPPORT ASSY (PRE SB 57-1222)					A-D I-L O P	2
-59	69-38802-9		.	.	SUPPORT ASSY (POST SB 57-1222)					A-D I-L O P	2
-60	69-38802-5		.	.	SUPPORT (USED ON 69-38802-3)					A-D I-L O P	2
-60	69-38802-11		.	.	SUPPORT (USED ON 69-38802-9)						1
-61	69-38802-7		.	.	STRIP, RUB (USED ON 69-38802-3)						1
-61	65C37022-1		.	.	STRIP, RUB (USED ON 69-38802-9)						1
-61A	BACB28X6C23		.	.	BUSHING (USED ON 69-38802-9)						1
-62	69-38802-4		.	.	SUPPORT ASSY					E-H M N	2
-62	69-38802-4		.	.	SUPPORT ASSY (PRE SB 57-1222)					A-D I-L O P	2
-62	69-38802-10		.	.	SUPPORT ASSY (POST SB 57-1222)					A-D I-L O P	2
-63	69-38802-6		.	.	SUPPORT (USED ON 69-38802-4)					A-P	1
-63	69-38802-12		.	.	SUPPORT (USED ON 69-38802-10)						1
-64	69-38802-7		.	.	STRIP, RUB (USED ON 69-38802-4)					A-P	1
-64	65C37022-1		.	.	STRIP, RUB (USED ON 69-38802-10)						1
-64A	BACB28X6C23		.	.	BUSHING (USED ON 69-38802-10)						1
-65	BACB30LU4-6		.	.	BOLT (REPLS NAS517-4-6)					A-P	2
-66	MS24665-134		.	.	PIN, COTTER (REPLS AN380-2-3)					A-P	2
-67	BACN10JD104		.	.	NUT (REPLS AN320-4)					A-P	2
-68	AN960-416		.	.	WASHER					A-P	2
-69	NAS1104-38D		.	.	BOLT (REPLS NAS1104-38DW)					A-P	2
-70	69-37815-7		.	.	TUBE ASSY, TORQUE, LH					A-P	1
-70	69-37815-8		.	.	TUBE ASSY, TORQUE, RH					A-P	1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
1102-											
-71	BACR15BA3D		.	.	.	R	I	V	E	T (REPLS MS20426D3)	4
-72	BACN10JP4D		.	.	.	N	U	T	P	L	1
-73	69-37815-5		.	.	.	F	I	L	L	E	1
-74	69-37815-9		.	.	.	T	U	B	E	(USED ON 69-37815-7)	1
-74	69-37815-10		.	.	.	T	U	B	E	(USED ON 69-37815-8)	1
-75	BACS12N10-9		.	.	S	C	R	E	W		12
-76	65-46430-38		.	.	R	E	T	A	I	N	2
-77	65-46430-27		.	.	S	E	A	L			1
-78	65-46430-26		.	.	S	E	A	L			1
-79	65-46430-15		.	.	S	T	R	I	P	, RUB	1
-80	BACN10JC3		.	.	N	U	T (REPLS NAS679A3W)				2
-81	AN960PD10L		.	.	W	A	S	H	E	R	2
-82	BACB30LU3-3		.	.	B	O	L	T (REPLS BACB30FL3-3)			2
-83	65-68278-57		.	.	E	N	D	B	L	O	1
										65-68278-65) (SB 78-1005) *[1]	
-83	65-68278-58		.	.	E	N	D	B	L	O	1
										65-68278-57) (OPP 65-68278-57)	
										(OPT TO 65-68278-66) *[1]	
-83	65-68278-65		.	.	E	N	D	B	L	O	1
										65-68278-65) *[1]	
-83	65-68278-66		.	.	E	N	D	B	L	O	1
										65-68278-65) (OPP 65-68278-65) *	
-84	65-68278-25		.	.	.	B	L	O	C	K (USED ON 65-68278-57, 58)	1
-84	65-68278-62		.	.	.	B	L	O	C	K (USED ON 65-68278-65, -66)	1
-85	65-68278-61		.	.	.	R	E	T	A	I	1
-86	65-68278-44		.	.	.	R	U	B	S	T	1
-87	BACN10JC3		.	.	N	U	T (REPLS NAS679A3W)				2
-88	AN960PD10L		.	.	W	A	S	H	E	R	2
-89	BACB30LU3-2		.	.	B	O	L	T (REPLS BACB30FL3-3)			1
-90	65-68278-23		.	.	E	N	D	B	L	O	1
										65-68278-24) (OPP 65-68278-24) *	
-90	65-68278-24		.	.	E	N	D	B	L	O	1
										65-68278-68) *[1]	
-90	65-68278-67		.	.	E	N	D	B	L	O	1
										65-68278-68) (OPP 65-68278-68) *	
-90	65-68278-68		.	.	E	N	D	B	L	O	1
										65-68278-68) *[1]	
-91	65-68278-25		.	.	.	B	L	O	C	K (USED ON 65-68278-23, -24)	1
-91	65-68278-62		.	.	.	B	L	O	C	K (USED ON 65-68278-67, -68)	1
-92	65-68278-34		.	.	.	R	E	T	A	I	1
-93	65-68278-44		.	.	.	R	U	B	S	T	1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
1102-											
-94	*[2]										1
-100	65-46430-123										
-100	65-46430-124										
-100	65-46430-133										
-100	65-46430-134										
-100	65-46430-503										
-100	65-46430-504										
-100	65-46430-522										
-100	65-46430-523										
-105	65-46430-147										
-105	65-46430-153										
-110	65-46430-25										
-110	65-46430-72										
-115	65-68278-59										
-115	65-68278-60										
-120	65C32620-1										
-120	65C32620-11										
-120	65C32620-12										
-120	65C32620-2										
-120	65-46430-505										
-120	65-46430-506										
-125	66-26119-4										
-125	66-26119-5										
-130	69-35349-5										
-130	69-35349-7										
-135	69-37233-1										
-135	69-37813-1										
-135	69-39211-1										
-135	69-39211-2										
-135	69-39211-3										
-135	69-39211-4										
-135	69-46457-1										
-135	69-46457-2										
-140	69-37815-1										
-145	69-73105-1										
-145	69-73105-2										
-145	69-73105-7										
-145	69-73105-8										
-150	69-76975-1										
-150	69-76975-2										
-150	69-76976-1										
-150	69-76976-2										

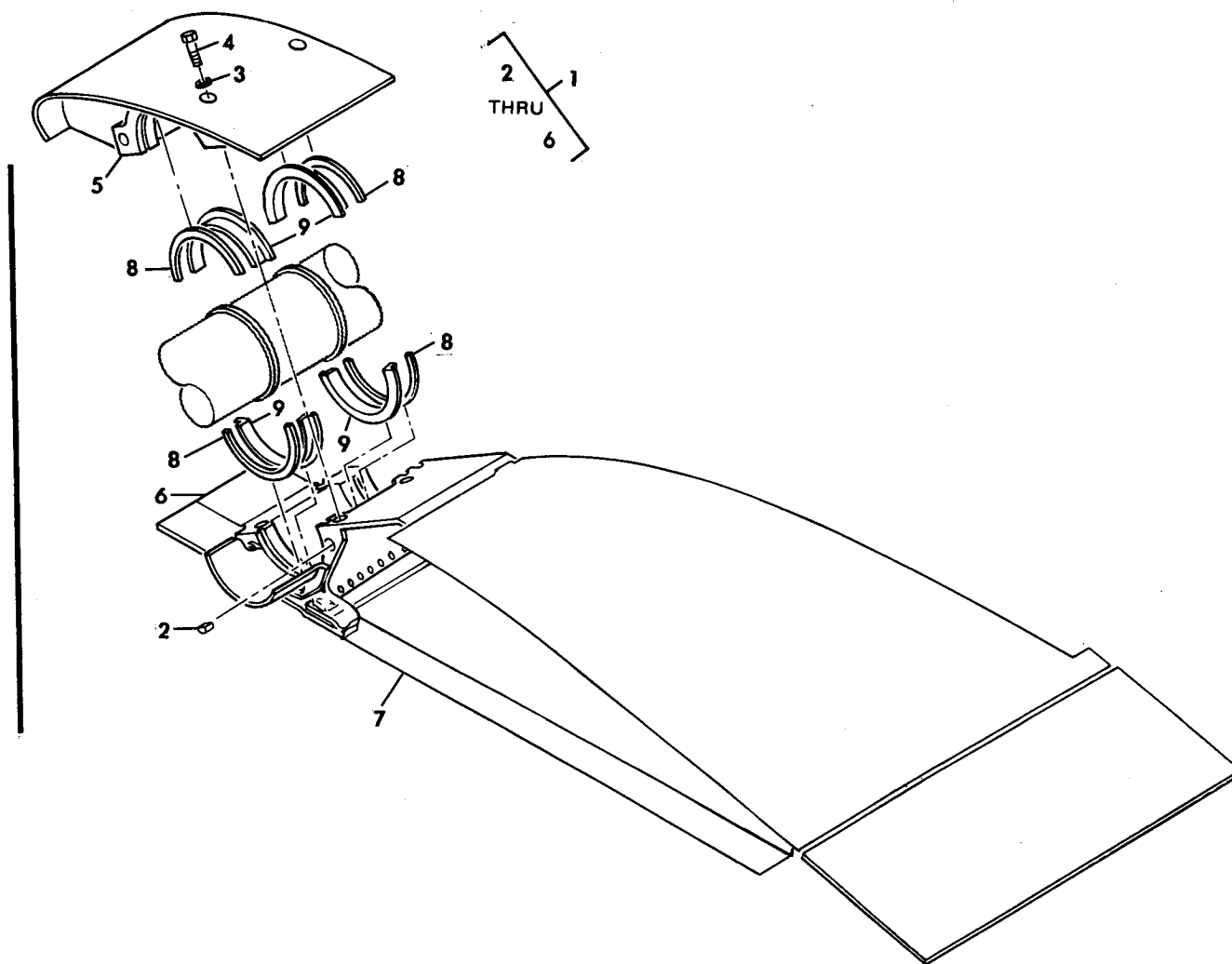
FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
1102-											
-150	69-76976-3										
-150	69-76976-4										
-150	69-76976-5										
-150	69-76976-6										
-150	69-76977-1										
-150	69-76977-2										
-155	69-78026-1										
-155	69-78026-2										
-155	69-78026-3										
-155	69-78026-4										
-155	69-78112-1										
-155	69-78112-2										
-155	69-78112-3										
-155	69-78112-4										
-160	69-78776-1										
-165	AN960KD10L										
-165	AN960KD416										
-170	BACB30DM5-9H										
-175	BACB30LE4H10										
-180	BACB30LE4H13										
-185	BACB30NN3K4										
-190	BACB30NN4K6										
-195	BACB30NR4DK36										
-200	BACB30NR4DK38										
-205	BACB30UU4K8H										
-210	BACB30UU5K11H										
-215	BACB30UU6K11H										
-220	BACB30VF4K6										
-225	BACN10CP4H										
-230	BACN10CP5H										
-235	BACN10CP6H										
-240	BACN10HC4										
-240	BACN10HC4										
-245	BACN10HC5										
-250	BACN10HC6										
-255	BACN10JD104CD										
-260	BACN10JD4CD										
-265	BACN10JN3CM										
-270	BACN10YR3CD										
-275	BACR10V4										
-280	BACR10V5										
-285	BACS40R010F0										
	10F										

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1102-					
-290	BACS40R014D0 14F		DELETED		
-295	BACS40R07B14F		DELETED		
-300	BACS40R08B14F		DELETED		
-305	BACS40R09B12F		DELETED		
-310	BACS40R09B13F		DELETED		
-315	BACS40R09B24F		DELETED		
-320	BACS40R100F100 F		DELETED		
-325	BACS40R10C21F		DELETED		
-330	BACS40R14D14F		DELETED		
-335	BACW10BN4C		DELETED		
-340	BACW10BN5C		DELETED		
-350	BACW10BN6C		DELETED		
-355	BACW10BP41CD		DELETED		
-360	BACW10DS4S		DELETED		
-365	BACW10DS5S		DELETED		
-370	BACW10DS6S		DELETED		
-375	MS24665-153		DELETED		
-380	NAS1068A3		DELETED		
-385	NAS1104-36D		DELETED		
-390	NAS1104-38D		DELETED		
-395	NAS6704H8		DELETED		
-400	NAS6705H11		DELETED		
-405	NAS6706H11		DELETED		
-410	BACW10BP4CD		DELETED		
-415	BACW10BP5CD		DELETED		
-420	BACW10BP6CD		DELETED		
-425	BACW10DS4S		DELETED		
-430	BACW10DS5S		DELETED		
-435	NAS1104-38D		DELETED		
-440	BACR15DR3PAC2		DELETED		
-445	MS24665-283		DELETED		
-450	BACB10FK6F16H S		DELETED		

*[1] LIMITED USAGE

*[2] NO BOEING PART NUMBER ASSIGNED

*[3] A MAXIMUM OF 2 AT EACH LOCATION AS IT IS NECESSARY TO GET THE CORRECT TORQUE
VALVE AND INSTALLATION OF THE COTTER PINS



Flipper Flap Assembly
Figure 1103

65-46436
65-71940
65-71969

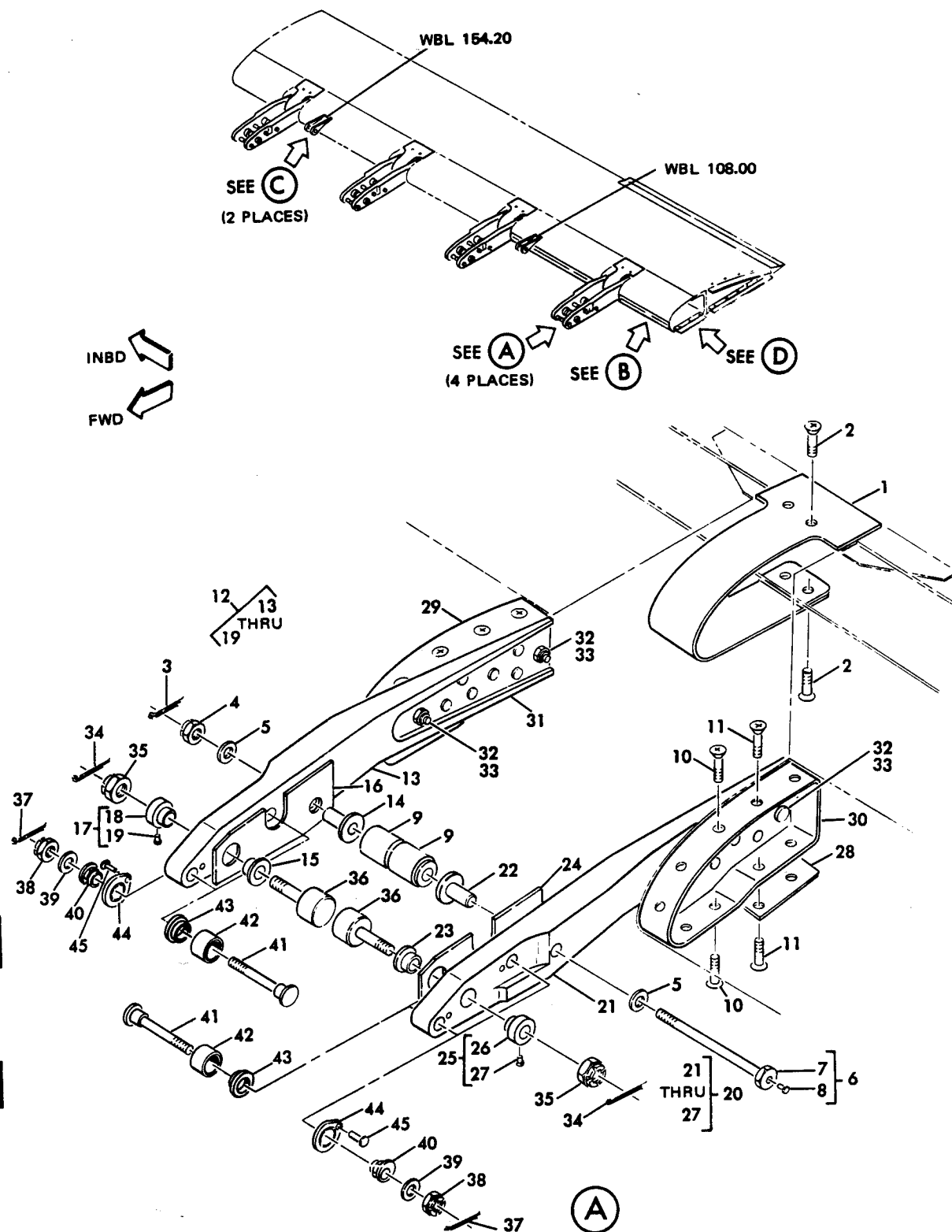
BOEING
COMMERCIAL JET
OVERHAUL MANUAL

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	N O M E N C L A T U R E 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1103	65-71926-1		FLIPPER FLAP ASSY (LH)(SB 78-1005)		RF
	65-71926-2		FLIPPER FLAP ASSY (RH)(SB 78-1005)		RF
	65-71926-59		FLIPPER FLAP ASSY, LH		RF
	65-71926-60		FLIPPER FLAP ASSY, RH		RF
	65-71926-65		FLIPPER FLAP ASSY, LH		RF
	65-71926-66		FLIPPER FLAP ASSY, RH		RF
	65-71926-67		FLIPPER FLAP ASSY, LH		RF
	65-71926-68		FLIPPER FLAP ASSY, RH		RF
	65-71926-77		FLIPPER FLAP ASSY, LH		RF
	65-71926-78		FLIPPER FLAP ASSY, RH		RF
1	65-71908-1		. HOUSING ASSY, BEARING SUPPORT, LH		1
1	65-71908-2		. HOUSING ASSY, BEARING SUPPORT, RH		1
2	BACN10HC4		. . NUT		4
3	BACW10BN4C		. . WASHER		4
4	BACB30FD4-12		. . BOLT		4
5	65-71908-7		. . HOUSING, UPPER (USED ON 65-71908-1)		1
5	65-71908-3		. . HOUSING, UPPER (OPT TO 65- 71908-7)		1
5	65-71908-8		. . HOUSING, UPPER (USED ON 65- 71908-2)		1
5	65-71908-4		. . HOUSING, UPPER (OPT TO 65- 71908-8)		1
6	65-71908-13		. . HOUSING, LOWER (USED ON 65- 71908-1)		1
6	65-71908-11		. . HOUSING, LOWER (OPT TO 65- 71908-13)		1
6	65-71908-14		. . HOUSING, LOWER (USED ON 65- 71908-2)		1
6	65-71908-12		. . HOUSING, LOWER (OPT TO 65- 71908-14)		1
7	*[1]		. COMPONENT ASSY (REF 57-53-23)		1
			INSTALLATION ITEMS		
8	69-57819-2		SEAL, WIPER		4
9	DBAF58-002		BUSHING, V81376 (BOEING 10-60516- 271)		4
9	KMS400		BUSHING, V97613 (BOEING 10-60516- 271)		4
9	YTD152		BUSHING, V77896 (BOEING 10-60516- 271)		4
9	90853		BUSHING, V09455 (BOEING 10-60516- 271)		4

*[1] NO BOEING PART NUMBER ASSIGNED

65-46436
65-71940
65-71969

BOEING
COMMERCIAL JET
OVERHAUL MANUAL



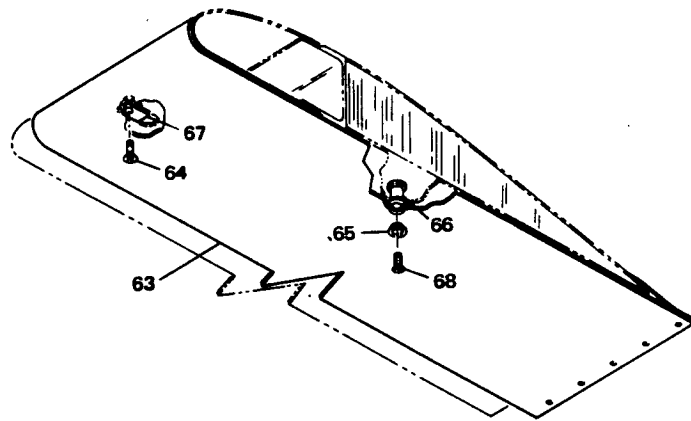
Aft Flap Assembly
Figure 1104 (Sheet 1)

Jan 5/81

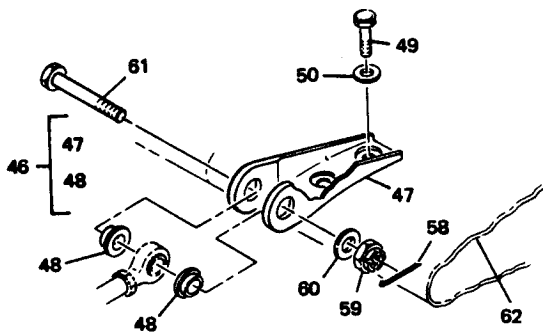
57-53-22
Page 1121

BOEING
COMMERCIAL JET
OVERHAUL MANUAL

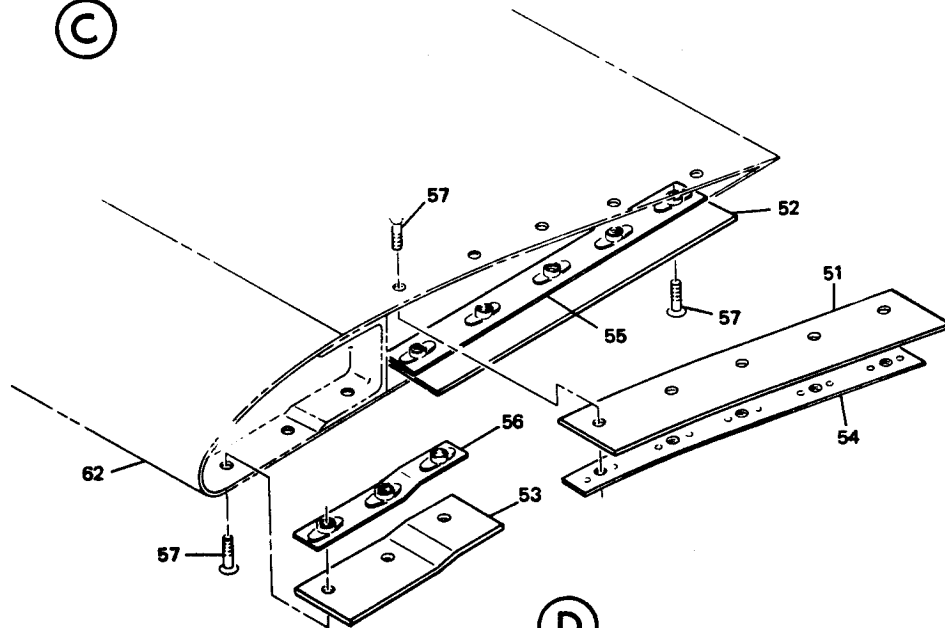
65-46436
 65-71940
 65-71969



(B)



(C)



(D)

Aft Flap Assembly
 Figure 1104 (Sheet 2)

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1104-	65-46434-89		DELETED		
	65-46434-90		DELETED		
	65-46434-117		AFTFLAP ASSY (LH)*[1]	A	RF
	65-46434-118		AFTFLAP ASSY (RH)*[1]	B	RF
	65-46434-135		AFTFLAP ASSY (LH)*[1]	C	RF
	65-46434-136		AFTFLAP ASSY (RH)*[1]	D	RF
	65-46434-139		AFTFLAP ASSY (LH)*[1] (PRE SB 57-1297) (PRE SB 57-1303) (PRE SB 57-1290)	E	RF
	65-46434-140		AFTFLAP ASSY (RH)*[1] (PRE SB 57-1297) (PRE SB 57-1303) (PRE SB 57-1290)	F	RF
	65-46434-301		DELETED		
	65-46434-302		DELETED		
	65-46434-335		DELETED		
	65-46434-336		DELETED		
	65-46434-351		DELETED		
	65-46434-352		DELETED		
	65-46434-367		DELETED		
	65-46434-368		DELETED		
	65-71940-19		AFTFLAP ASSY (LH)	G	RF
	65-71940-20		AFTFLAP ASSY (RH)	H	RF
	65-71970-1		AFTFLAP ASSY (LH)(SB 57-1029)	I	RF
	65-71970-2		AFTFLAP ASSY (RH)(SB 57-1029)	J	RF
	65-71940-29		AFTFLAP ASSY (LH) * [1] (POST SB 57-1290) (POST SB 57-1297) (POST SB 57-1303)	K	RF
	65-71940-30		AFTFLAP ASSY (RH) * [1] (POST SB 57-1290) (POST SB 57-1297) (POST SB 57-1303)	L	RF
	65-46434-179		AFTFLAP ASSY (LH)	M	RF
	65-46434-180		AFTFLAP ASSY (RH)	N	RF
1	69-42328-1		. SKIN ASSY, NOSE	A-D G-N	4
1	69-42328-1		DELETED		
1	69-42328-1		DELETED		
1	69-42328-1		DELETED		
1	69-42328-2		DELETED		
1	69-42328-13		DELETED		
1	69-42328-15		DELETED		
1	69-42328-15		DELETED		
1	69-42328-15		DELETED		
1	69-42328-18		. SKIN ASSY, NOSE	EF	4
2	BACB30LU3-2		. BOLT (REPLS NAS517-3-2)		16
3	MS24665-134		. PIN, COTTER (REPLS AN380-2-3)		4
4	BACN10JD104		. NUT (REPLS AN320-4)		4
5	AN960PD416L		. WASHER		8
6	69-38849-3		. BOLT ASSY		4
7	69-38849-4		. . BOLT		1
8	NAS516-1		. . FITTING, LUBRICATION		1
9	BACB10B97		. BEARING		8
10	BACB30LU3-2		. BOLT (REPLS NAS517-3-2)		40
10	BACB30LU3-2		DELETED		

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1104-					
11	BACB30LU4-4		. BOLT (REPLS NAS517-4-4)		32
11	BACB30LU4-4		DELETED		
11	BACB30VF4K4		DELETED		
12	65-47861-5		. SUPPORT ASSY, ROLLER		4
13	65-47861-7		. . SUPPORT		1
14	69-37234-14		. . BUSHING		1
15	69-37234-12		. . BUSHING		1
16	65-47861-9		. . RUB STRIP		1
17	69-39219-1		. . BUSHING ASSY		1
18	69-39219-3		. . . BUSHING		1
19	NAS516-1		. . . FITTING, LUBRICATION		1
20	65-47861-6		. SUPPORT ASSY, ROLLER		4
21	65-47861-8		. . SUPPORT		1
22	69-37234-14		. . BUSHING		1
23	69-37234-12		. . BUSHING		1
24	65-47861-9		. . RUB STRIP		1
25	69-39219-1		. . BUSHING ASSY		1
26	69-39219-3		. . . BUSHING		1
27	NAS516-1		. . . FITTING, LUBRICATION		1
28	BACS40R10B20F		. SHIM		8
29	65-47870-111		DELETED		
29	65-47870-112		DELETED		
29	65-47870-115		. RIB		4
29	65-47870-145		DELETED		
29	65-47870-146		DELETED		
29	65-47870-151		DELETED		
29	65-47870-152		DELETED		
29	65-47870-153		DELETED		
29	65-47870-154		DELETED		
30	65-47870-112		DELETED		
30	65-47870-116		. RIB		4
30	65-47870-146		DELETED		
30	65-47870-152		DELETED		
30	65-47870-154		DELETED		
31	BACR15BB6D		. RIVET (REPLS MS20470D6 AND AN470D6)		48
32	BACB30FM6-3		. LOCKBOLT		16
33	BACC30M6		. COLLAR, LOCKBOLT		16
34	MS24665-285		. PIN, COTTER (REPLS AN380-3-4)		8
35	BACN10JD106		. NUT (REPLS AN320-6)		8
36	CF2051		. FOLLOWER, CAM, V92563 (PREFERRED)		8
36	CC38364		. FOLLOWER, CAM, V60380 (OPT TO CF2051)		8
37	MS24665-134		. PIN, COTTER (REPLS AN380-2-3)		16
38	BACN10JD103		. NUT (REPLS AN320-3)		16
39	AN960PD10		. WASHER		16

65-46436
65-71940
65-71969
DASH NUMBERS LIMITED



FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1104-40	69-38829-2		. BUSHING, ECCENTRIC		16
41	69-38830-2		. BOLT (REPLS 69-38830-1)*[1]	A-D G-J	16
41	69-38830-5		. BOLT *[1]		16
42	KJB155104V		DELETED		
42	LA4186A		. ROLLER, V80894 (REPLS BOEING 10-60516-210)		16
42	LA4186A		DELETED		
43	69-37234-23		. BUSHING (REPLS 69-37234-21)*[1]		16
43	69-37234-21		. BUSHING (REPLS 69-37234-10)*[1]		16
44	69-39293-1		. LOCK, ECCENTRIC		16
45	BACR15BA3D		. RIVET (REPLS MS20426D3 AND AN426D3)		16
46	69-38871-1		. FITTING ASSY, SLAVE ATTACH (OPT TO 69-38871-3 AT WBL 154.20 ONLY)	A-D G-J	1
46	69-38871-3		. FITTING ASSY, SLAVE ATTACH (PREFERRED)	EFK-N	2
46	69-38871-3		DELETED		
47	69-38871-2		. . BRACKET (USED ON 69-38871-1)		1
47	69-38871-4		. . BRACKET (USED ON 69-38871-3)		1
48	NAS538B4P15		. . BUSHING		2
49	BACB30NE4H4		. BOLT (REPLS NAS1304-4H)		4
50	AN960PD416L		. WASHER		4
51	65-46434-58		. SEAL, UPPER	A-N	1
51	65-46434-58		DELETED		
51	65-46434-190		DELETED		
51	65-46434-227		DELETED		
51	69-78710-4		DELETED		
52	65-46434-59		. SEAL, LWR AFT	A-N	1
52	65-46434-59		DELETED		
52	65-46434-191		DELETED		
52	65-46434-228		DELETED		
52	69-78710-1		DELETED		
52	69-78710-3		DELETED		
53	65-46434-60		. SEAL, LWR FWD		1
53	65-46434-60		DELETED		
53	65-46434-229		DELETED		
53	69-78710-2		DELETED		
54	65-46434-63		. RETAINER, UPR	A-N	1
54	65-46434-63		DELETED		
54	65-46434-188		DELETED		
55	65-46434-64		. RETAINER, LWR	A-N	1
55	65-46434-64		DELETED		
55	65-46434-189		DELETED		
56	65-46434-65		. RETAINER, LWR FWD		1
57	BACS12N10-9		. SCREW		13

Jul 1/03

57-53-22
Page 1124A

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
1104-											
58	MS24665-153		.	PIN, COTTER (REPLS AN381-2-10,-12)							2
59	BACN10JD104AU		.	NUT (REPLS AN320C4)							2
60	AN960PD416L		.	WASHER							2
61	BACB30LJ4DU14		.	BOLT							2
62	*[2]			DELETED							
62	65-46434-77			DELETED							
62	65-46434-78			DELETED							
62	65-46434-79			DELETED							
62	65-46434-80			DELETED							
62	65-46434-81			DELETED							
62	65-46434-82			DELETED							
62	65-46434-83			DELETED							
62	65-46434-84			DELETED							
62	65-46434-85			DELETED							
62	65-46434-86			DELETED							
62	65-46434-147			DELETED							
62	65-46434-148			DELETED							
62	65-46434-149			DELETED							
62	65-46434-150			DELETED							
62	65-46434-151			DELETED							
62	65-46434-152			DELETED							
62	65-46434-153			DELETED							
62	65-46434-154			DELETED							
62	65-46434-155			DELETED							
62	65-46434-156			DELETED							
62	65-46434-217			DELETED							
62	65-46434-218			DELETED							
62	65-46434-219			DELETED							
62	65-46434-220			DELETED							
62	65-46434-221			DELETED							
62	65-46434-222			DELETED							
62	65-46434-223			DELETED							
62	65-46434-224			DELETED							
62	65-46434-225			DELETED							
62	65-46434-226			DELETED							
63	65-71939-1		.	SHIELD ASSY						GKM	1
63	65-71939-2		.	SHIELD ASSY (OPP)						HLN	1
64	BACB30LU3-2		.	BOLT						GHK-N	9
65	BACW10UB101		.	WASHER						GHK-N	10
66	SL2-3-500-1SP		.	INSERT, V97393						GHK-N	10
66	SL2869S35		.	INSERT, V97393 (OPT TO						GHK-N	10
67	BACN10FX1		.	NUT, CLIP-ON						GHK-N	9
68	NAS514P1032-5		.	BOLT						GHK-N	10
-70	65-46434-14			DELETED							
-70	65-46434-106			DELETED							
-70	65-46434-108			DELETED							
-75	65-46434-111			DELETED							

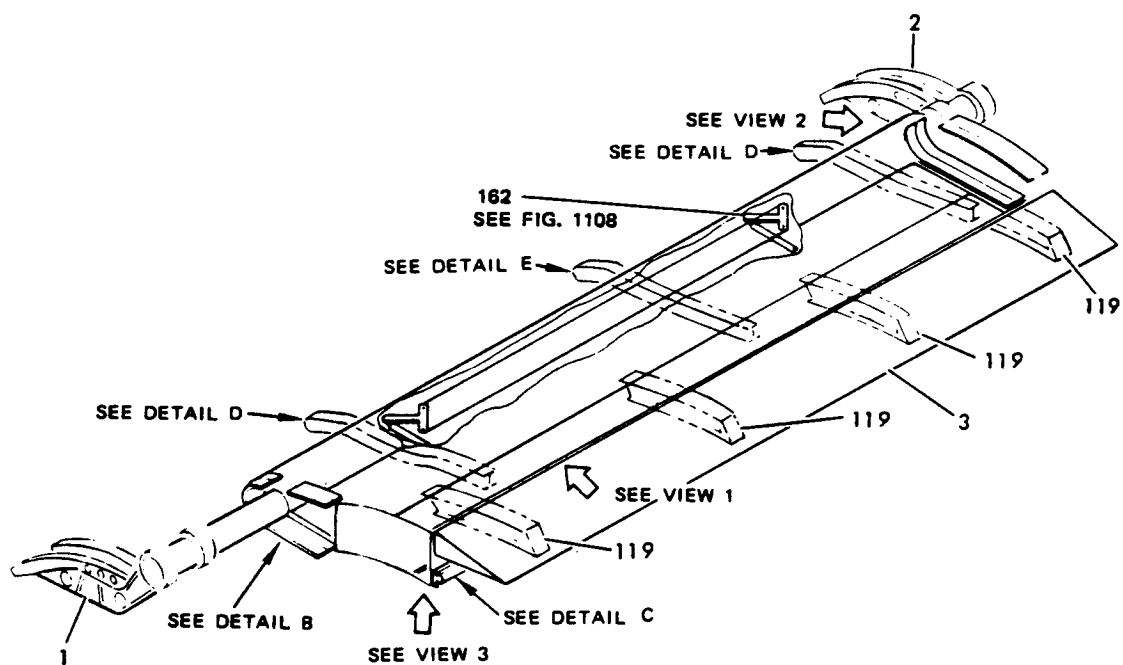
FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1104-					
-80	65-46434-303		DELETED		
-80	65-46434-304		DELETED		
-85	65-46434-33		DELETED		
-85	65-46434-34		DELETED		
-90	65-47861-501		DELETED		
-95	65-47861-5		DELETED		
-100	65-47861-7		DELETED		
-105	65-47861-9		DELETED		
-110	69-37234-12		DELETED		
-115	69-37234-14		DELETED		
-120	69-39219-1		DELETED		
-125	69-39219-3		DELETED		
-130	NAS516-1		DELETED		
-135	69-39219-501		DELETED		
-140	69-39219-502		DELETED		
-145	NAS516-1		DELETED		
-150	65-47861-6		DELETED		
-155	65-47861-8		DELETED		
-160	65-47861-9		DELETED		
-165	69-37234-12		DELETED		
-170	69-37234-14		DELETED		
-175	69-39219-1		DELETED		
-180	69-39219-3		DELETED		
-185	NAS516-1		DELETED		
-190	69-39219-501		DELETED		
-195	69-39219-502		DELETED		
-200	NAS516-1		DELETED		
-205	65-46434-75		DELETED		
-205	65-46434-76		DELETED		
-210	69-42324-1		DELETED		
-210	69-42324-1		DELETED		
-210	69-42324-3		DELETED		
-210	69-42324-3		DELETED		
-210	69-42324-3		DELETED		
-210	69-42324-3		DELETED		
-210	69-42324-3		DELETED		
-210	69-42324-3		DELETED		
-210	69-42324-3		DELETED		
-210	69-42324-3		DELETED		
-215	65-47870-113		DELETED		
-220	AN7510-1		DELETED		
-225	BACN10FX21		DELETED		
-230	BACN10FX21		DELETED		
-230	BACN10JT3CD		DELETED		
-235	BACN10JT3CD		DELETED		
-240	BACR15DR3PAC2		DELETED		

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1104-					
-245	BACS40R10C12F		DELETED		
-250	NAS1068A4		DELETED		
-255	NAS1195DD4FH		DELETED		
-260	NAS1195DD4FM		DELETED		
-265	NAS1304-4H		DELETED		
-270	NAS698A4		DELETED		

*[1] LIMITED USAGE

65-46436
65-71940
65-71969

BOEING
COMMERCIAL JET
OVERHAUL MANUAL



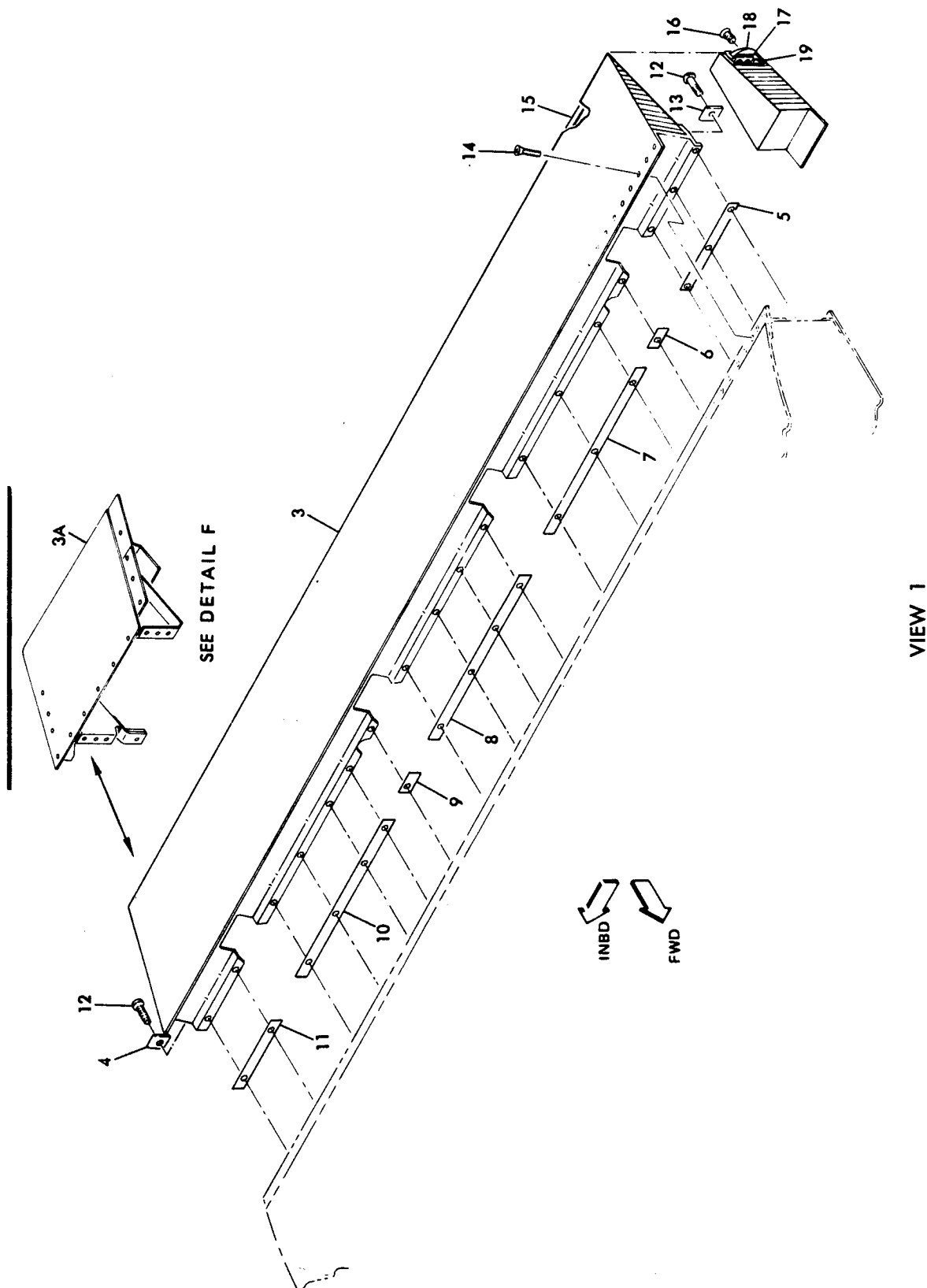
Jan 5/79

Mid Flap Assembly
Figure 1105 (Sheet 1)

57-53-22
Page 1125

BOEING
COMMERCIAL JET
OVERHAUL MANUAL

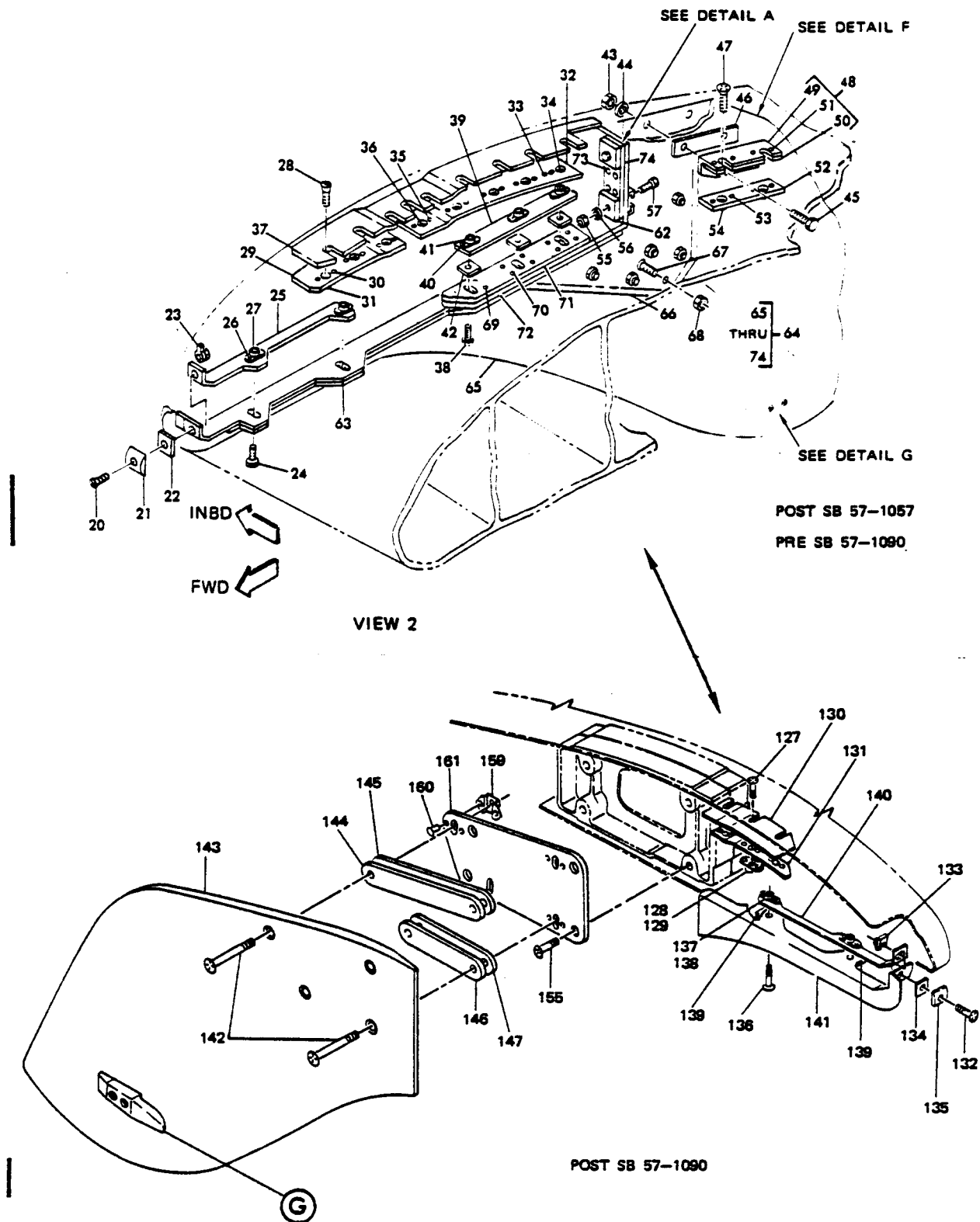
65-46436
 65-71940
 65-71969



Mid Flap Assembly
 Figure 1105 (Sheet 2)

65-46436
65-71940
65-71969

BOEING
COMMERCIAL JET
OVERHAUL MANUAL



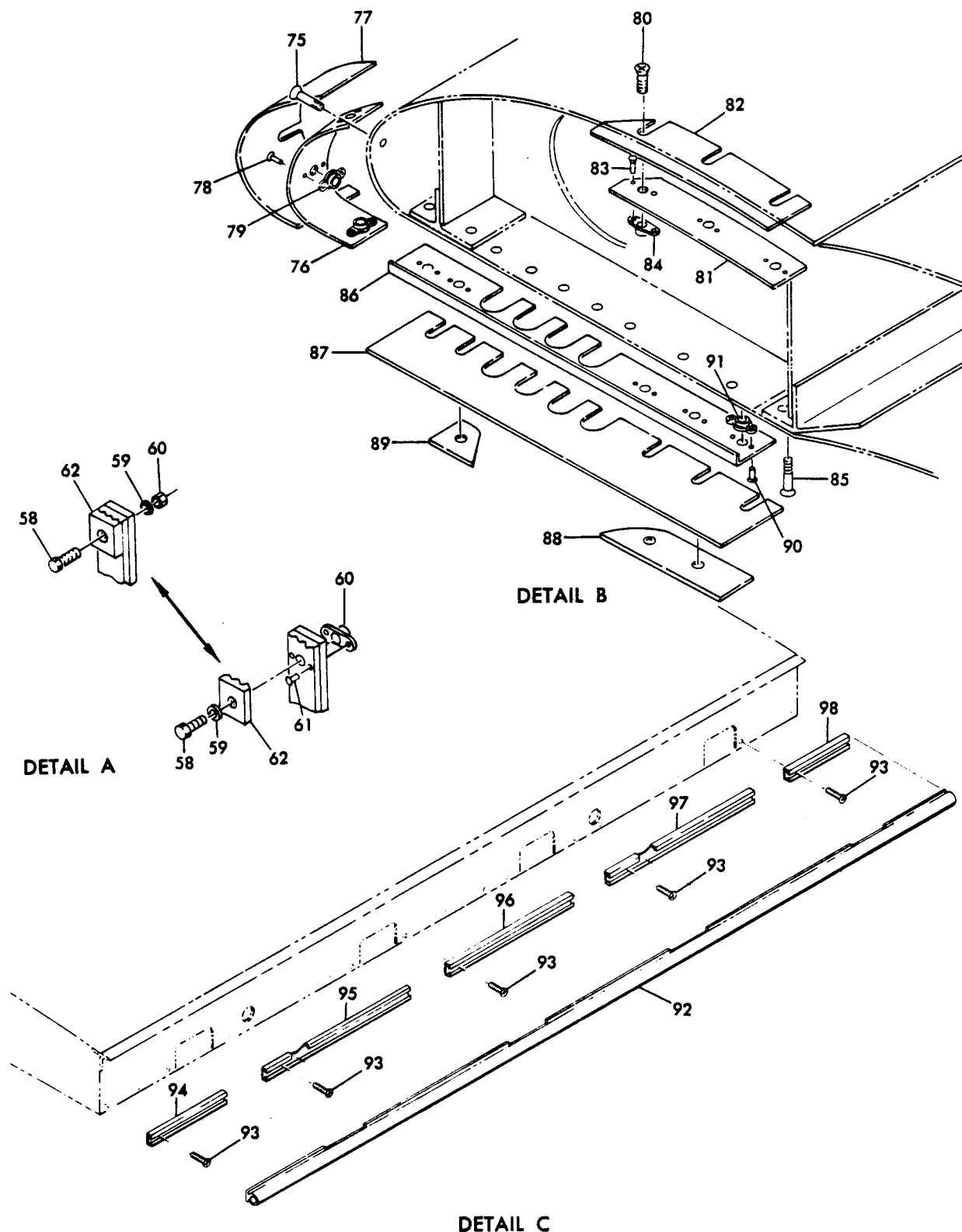
Jan 5/79

Mid Flap Assembly
Figure 1105 (Sheet 3)

57-53-22
Page 1127

BOEING
COMMERCIAL JET
OVERHAUL MANUAL

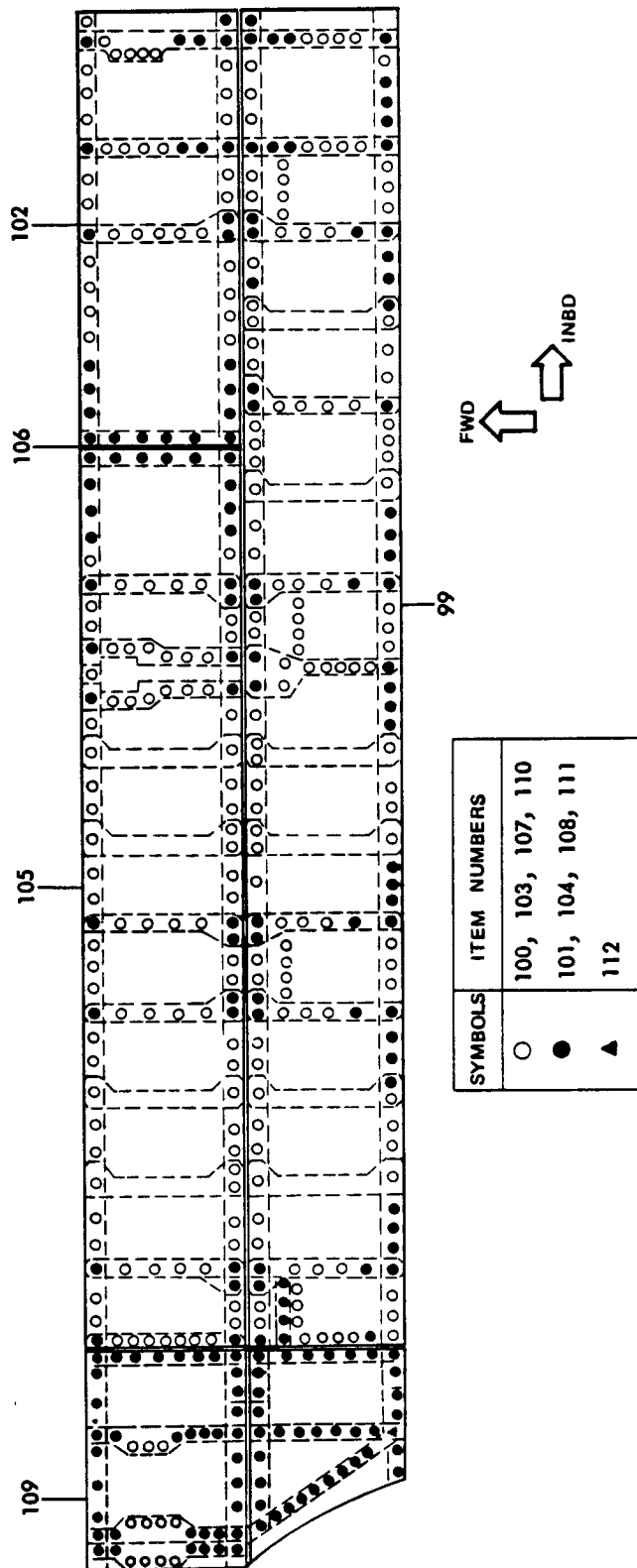
65-46436
65-71940
65-71969



Mid Flap Assembly
Figure 1105 (Sheet 4)

65-46436
65-71940
65-71969

BOEING
COMMERCIAL JET
OVERHAUL MANUAL

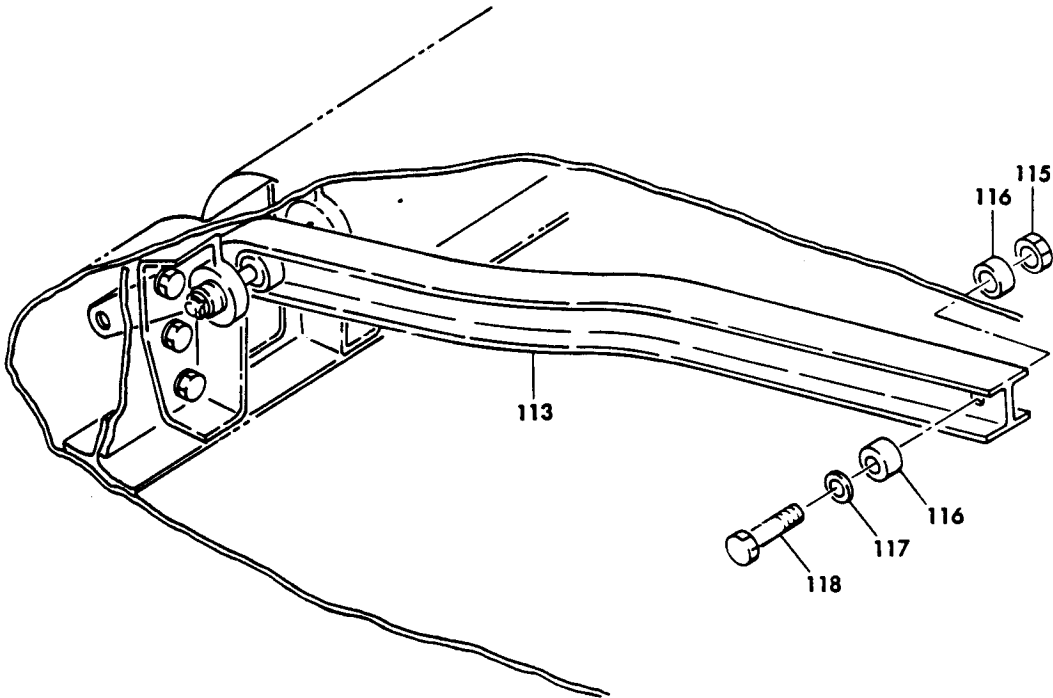


VIEW 3

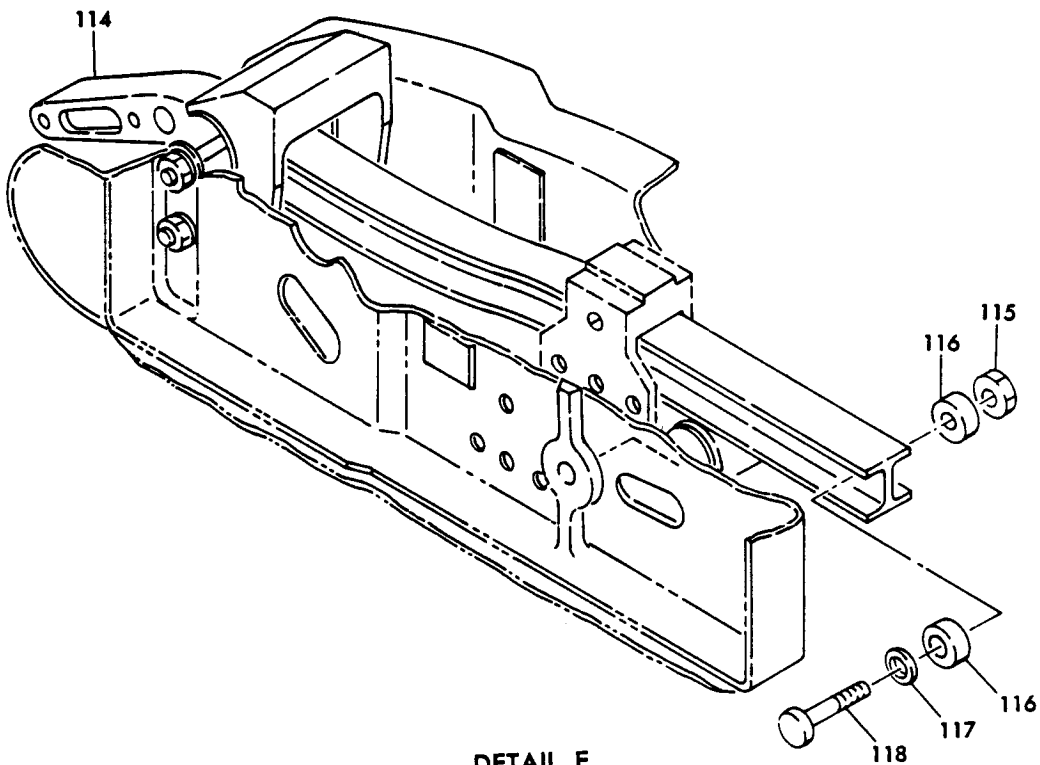
Jun 10/71

Mid Flap Assembly
Figure 1105 (Sheet 5)

57-53-22
Page 1129



DETAIL D

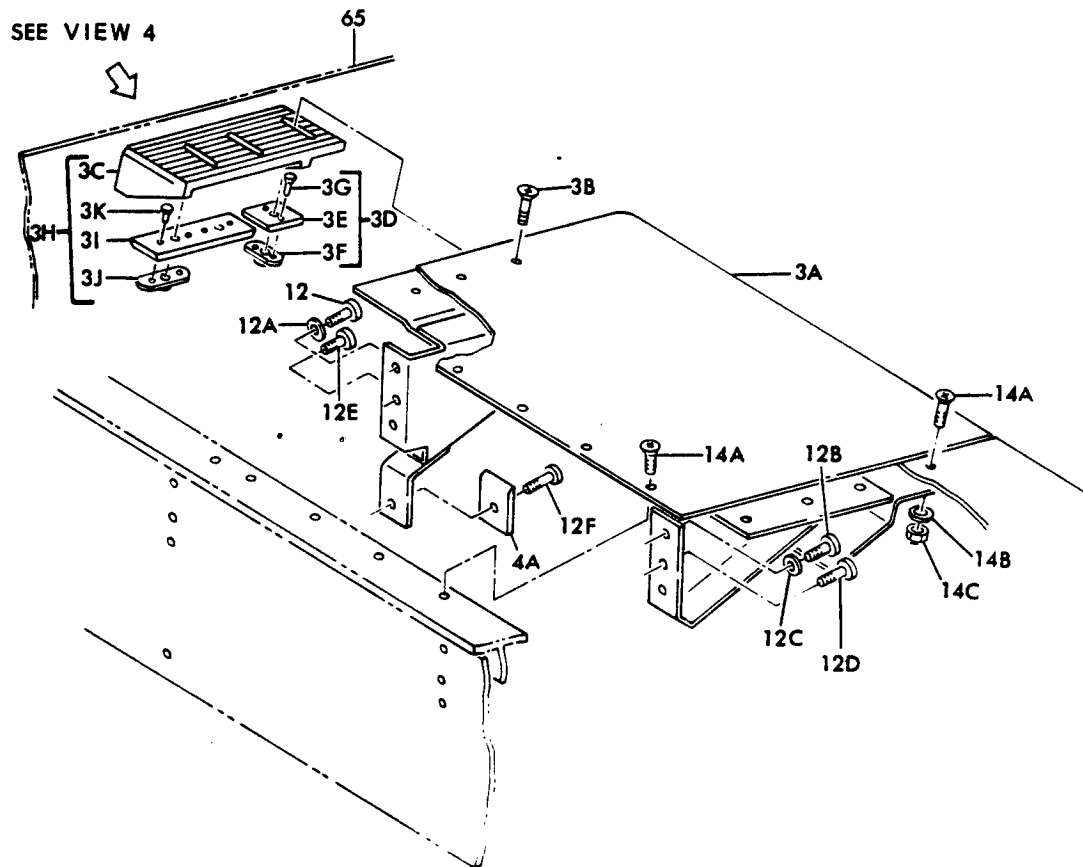


DETAIL E

Mid Flap Assembly
Figure 1105 (Sheet 6)

65-46436
65-71940
65-71969

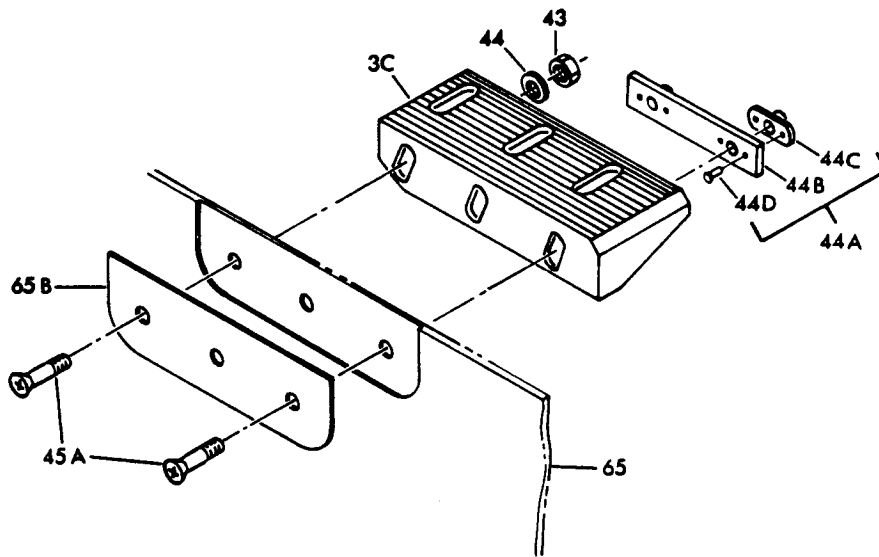
BOEING
COMMERCIAL JET
OVERHAUL MANUAL



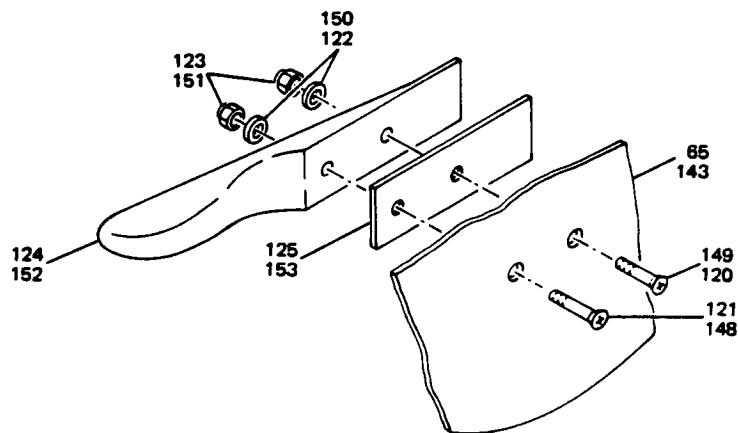
(PRE SB 57-1090)
DETAIL F

BOEING
COMMERCIAL JET
OVERHAUL MANUAL

65-46436
65-71940
65-71969



VIEW 4



DETAIL G

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
1105-	65-71902-1		MIDFLAP	ASSY,	LH	(SB	57-1029)			A	RF
	65-71902-2		MIDFLAP	ASSY,	RH	(SB	57-1029)			B	RF
	65-71902-3		MIDFLAP	ASSY,	LH	(SB	57-1029)			C	RF
	65-71902-4		MIDFLAP	ASSY,	RH	(SB	57-1029)			D	RF
	65-71902-9		MIDFLAP	ASSY,	LH	(SB	57-1057)			E	RF
	65-71902-10		MIDFLAP	ASSY,	RH	(SB	57-1057)			F	RF
	65-71902-11		MIDFLAP	ASSY,	LH					G	RF
	65-71902-12		MIDFLAP	ASSY,	RH					H	RF
	65-71902-13		MIDFLAP	ASSY,	LH					I	RF
	65-71902-14		MIDFLAP	ASSY,	RH					J	RF
	65-71971-1		MIDFLAP	ASSY,	LH	(SB	57-1029)			K	RF
	65-71971-2		MIDFLAP	ASSY,	RH	(SB	57-1029)			L	RF
	65-71971-3		MIDFLAP	ASSY,	LH	(SB	57-1029)			M	RF
	65-71971-4		MIDFLAP	ASSY,	RH	(SB	57-1029)			N	RF
	65-71940-21		MIDFLAP	ASSY,	LH					O	RF
	65-71940-22		MIDFLAP	ASSY,	RH					P	RF
	65-71940-25		MIDFLAP	ASSY,	LH					Q	RF
	65-71940-26		MIDFLAP	ASSY,	RH					R	RF
	65-71940-31		MIDFLAP	ASSY,	LH	*	[11]			S	RF
	65-71940-32		MIDFLAP	ASSY,	RH	*	[11]			T	RF
	65-71940-37		MIDFLAP	ASSY,	LH	*	[11]			TA	RF
	65-71940-38		MIDFLAP	ASSY,	RH	*	[11]			UA	RF
	65-71940-41		MIDFLAP	ASSY,	LH	*	[1] (POST SB 57-1297)			VA	RF
			(POST SB 57-1303) (POST SB 57-1290)								
	65-71940-42		MIDFLAP	ASSY,	RH	*	[1] (POST SB 57-1297)			WA	RF
			(POST SB 57-1303) (POST SB 57-1290)								
	65-71971-133		MIDFLAP	ASSY,	LH					U	RF
	65-71971-134		MIDFLAP	ASSY,	RH					V	RF
	65-71971-135		MIDFLAP	ASSY,	LH					W	RF
	65-71971-136		MIDFLAP	ASSY,	RH					X	RF
	65-71902-15		MIDFLAP	ASSY,	LH	(SB	57-1090)*[4]			Y	RF
	65-71902-16		MIDFLAP	ASSY,	RH	(SB	57-1090)*[4]			Z	RF
	65-71902-17		MIDFLAP	ASSY,	LH	*	[8]			Y	RF
	65-71902-19		MIDFLAP	ASSY,	LH					BA	RF
	65-71902-21		MIDFLAP	ASSY,	LH	*	[8]			BA	RF
	65-71902-23		MIDFLAP	ASSY,	LH					CA	RF
	65-71902-31		MIDFLAP	ASSY,	LH	*	[7]			CA	RF
	65-71902-25		MIDFLAP	ASSY,	LH	*	[8]			CA	RF
	65-71902-33		MIDFLAP	ASSY,	LH					DA	RF
	65-71902-35		MIDFLAP	ASSY,	LH	*	[8]			DA	RF
	65-71902-41		MIDFLAP	ASSY,	LH	(PRE SB 57-1297)				EA	RF
			(PRE SB 57-1303) (PRE SB 57-1290)								
	65-71902-43		MIDFLAP	ASSY,	LH	*	[9]			EA	RF
	65-71902-45		MIDFLAP	ASSY,	LH	*	[9]			EA	RF
	65-71902-49SP		MIDFLAP	ASSY,	LH	*	[10]			RA	RF

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
1105-	65-71902-18		MIDFLAP ASSY, RH *[8]							Z	RF
	65-71902-20		MIDFLAP ASSY, RH							NA	RF
	65-71902-22		MIDFLAP ASSY, RH *[8]							NA	RF
	65-71902-24		MIDFLAP ASSY, RH							OA	RF
	65-71902-32		MIDFLAP ASSY, RH *[7]							OA	RF
	65-71902-26		MIDFLAP ASSY, RH *[8]							OA	RF
	65-71902-34		MIDFLAP ASSY, RH							PA	RF
	65-71902-36		MIDFLAP ASSY, RH *[8]							PA	RF
	65-71902-42		MIDFLAP ASSY, RH (PRE SB 57-1297) (PRE SB 57-1303) (PRE SB 57-1290)							QA	RF
	65-71902-50SP		MIDFLAP ASSY, RH *[10]							SA	RF
1	65-71902-44		MIDFLAP ASSY, RH *[9]							QA	RF
	65-71902-46		MIDFLAP ASSY, RH *[9]							QA	RF
	65-68297-1		. MIDFLAP OUTBD CARRIAGE INSTL, LH (SB 57-1029)(FIG. 1106)							AEGIOS Y BA-EA TA VA	1
	65-68297-2		. MIDFLAP OUTBD CARRIAGE INSTL, RH (SB 57-1029)(FIG. 1106)							BFHJPT Z NA-QA UA WA	1
	65-68297-3		. MIDFLAP OUTBD CARRIAGE INSTL, LH (SB 57-1029)(FIG. 1106)							CQ	1
	65-68297-4		. MIDFLAP OUTBD CARRIAGE INSTL, RH (SB 57-1029)(FIG. 1106)							DR	1
	65-68297-13		. OUTBD CARRIAGE INSTL (FIG. 1106)							G	1
	65-68297-14		. OUTBD CARRIAGE INSTL (FIG. 1106)							H	1
	65-46492-1		. MIDFLAP OUTBD CARRIAGE INSTL, LH (SB 57-1029)(FIG. 1106)							KU	1
	65-46492-2		. MIDFLAP OUTBD CARRIAGE INSTL, RH (SB 57-1029)(FIG. 1106)							LV	1
1	65-46492-5		. MIDFLAP OUTBD CARRIAGE INSTL, LH (SB 57-1029)(FIG. 1106)							MW	1
	65-46492-6		. MIDFLAP OUTBD CARRIAGE INSTL, RH (SB 57-1029)(FIG. 1106)							NX	1
	65-52246-1		. MIDFLAP INBD CARRIAGE INSTL, LH (SB 57-1029)(FIG. 1107)							AEKIOSY BA-EA TA VA	1
	65-52246-2		. MIDFLAP INBD CARRIAGE INSTL, RH (SB 57-1029)(FIG. 1107)							BFLJPT Z NA-QA UA WA	1
	65-52246-7		. MIDFLAP INBD CARRIAGE INSTL, LH (SB 57-1029)(FIG. 1107)							CGMQ	1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	N O M E N C L A T U R E							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
1105- 2	65-52246-8		.	MIDFLAP	INBD	CARRIAGE	INSTL,	RH		DHNR	1
				(SB 57-1029)	(FIG. 1107)						
2	65-52246-7		.	MIDFLAP	INBD	CARRIAGE	INSTL,	LH		ACEY TA	1
				(OPT TO 65-52246-1)	(FIG. 1107)						
2	65-52246-8		.	MIDFLAP	INBD	CARRIAGE	INSTL,	RH		BDFZ UA	1
				(OPT TO 65-52246-2)	(FIG. 1107)						
3	65-46486-31		.	TE ASSY,	LH *[1]	(REPLD BY				ACEGK	1
				65-46486-505)						MOQUW	
3	65-46486-505		.	TE ASSY,	LH *[1]	(REPLS 65-46486-31)				ACEGOQ	1
3	65-46486-32		.	TE ASSY,	RH *[1]	(REPLD BY				BDFHL	1
				65-46486-506)						NPRVX	
3	65-46486-506		.	TE ASSY,	RH *[1]	(REPLS 65-46486-32)				BDFHPR	1
3	65-46486-73		.	TE ASSY,	LH *[1]	(SB 57-1057)				EIOSY	1
				(REPLD BY 65-46486-507)						TA	
3	65-46486-507		.	TE ASSY,	LH *[1]	(REPLS 65-46486-73)				EIOSY	1
										TA	
3	65-46486-74		.	TE ASSY,	RH *[1]	(SB 57-1057)				FJPTZ	1
				(REPLD BY 65-46486-508)							
3	65-46486-508		.	TE ASSY,	RH *[1]	(REPLS 65-46486-74)				FJPTZ	1
										UA	
3	65-46486-87		.	TE ASSY,	LH *[1]	(REPLD BY				ISY TA	1
				65-46486-511)							
3	65-46486-88		.	TE ASSY,	RH *[1]	(REPLD BY				JTZ UA	1
				65-46486-512)							
3	65-46486-113		DELETED								
3	65-46486-114		DELETED								
3	65-46486-111		.	TE ASSY,	LH *[1]					Y TA	1
3	65-46486-112		.	TE ASSY,	RH *[1]					Z UA	1
3	65-46486-111		.	TE ASSY,	LH					BA-EA	1
										VA	
3	65-46486-112		.	TE ASSY,	RH					NA-QA	1
										WA	
3	65-46486-139		.	TE ASSY,	LH					RA	1
3	65-46486-140		.	TE ASSY,	RH					SA	1
3	65-46486-509		.	TE ASSY,	LH *[1]					BA-EA	1
3	65-46486-510		.	TE ASSY,	RH *[1]					NA-QA	1
3	65-46486-511		.	TE ASSY,	LH *[1]	(REPLS 65-46486-87)				EIOSY	1
										TA	
3	65-46486-512		.	TE ASSY,	RH *[1]	(REPLS 65-46486-88)				FJPTZ	1
										UA	
3A	65-79953-1		.	TE ASSY,	LH (SB 57-1057)*[1]					EISY TA	1
3A	65-79953-9		.	TE ASSY,	LH *[1] (PRE SB 57-1090)					EIY TA	1
3A	65-79953-2		.	TE ASSY,	RH (SB 57-1057)*[1]					FJTZ UA	1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	N O M E N C L A T U R E							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
1105-											
3A	65-79953-10									FJZ UA 1	
3B	BACB30LU3-6										3
3C	65-79954-1										1
3C	65-79954-2										1
3D	69-61980-1										1
3E	69-61980-4										1
3F	BACN10JQ32										1
3G	MS20470M										2
3H	69-61980-2										1
31	69-61980-5										1
3J	BACN10JQ32										2
3K	MS20470M										4
4	65-46486-8										17
4	65-46486-8										15
4	65-46486-8										16
4A	65-46486-80										1
5	BACS40RO7B130										AR
6	BACS40RO7B19										AR
7	BACS40RO7B142										AR
8	BACS40RO7B178										AR
9	BACS40RO7B25										AR
10	BACS40RO7B198										AR
11	BACS40RO7B95										AR
12	NAS623-3-5										18
12A	AN960PD10										1
12B	NAS623-3-4										2
12C	AN960PD10L										2
12D	NAS623-3-6										1
12E	NAS623-3-7										2
12F	NAS623-3-8										1
13	65-46486-56										1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	N O M E N C L A T U R E							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
1105-14	BACB30LH2-3		. BOLT (USED WITH 65-46486-31,-32,-113,-114,-505,-506,-509,-510)								18
14	BACB30LH2-3		. BOLT (USED WITH 65-46486-73,-74,-87,-88,-507,-508,-511,-512)								16
14A	BACB30LH2-3		. BOLT (USED WITH 65-79953-1,-2,-9,-10)								7
14B	AN960PD8		. WASHER (USED WITH 65-79953-1,-2,-9,-10)								4
14C	BACN10JC08		. NUT (USED WITH 65-79953-1,-2,-9,-10)								4
14	BACB30LH2-3		. BOLT (USED WITH 65-46486-31,-32,-113,-114,-505,-506,-509,-510)								18
14	BACB30LH2-3		. BOLT (USED WITH 65-46486-73,-74,-87,-88,-507,-508,-511,-512)								16
14A	BACB30LH2-3		. BOLT (USED WITH 65-79953-1,-2,-9,-10)								7
14B	AN960PD8		. WASHER (USED WITH 65-79953-1,-2,-9,-10)								4
14C	BACN10JC08		. NUT (USED WITH 65-79953-1,-2,-9,-10)								4
15	65-46486-61		. STRIP, RUB (USED WITH 65-46486-31,-32,-113,-114,-505,-506,-509,-510)								1
15	65-46486-77		. STRIP, RUB (USED WITH 65-46486-73,-74,-87,-88,-507,-508,-511,-512)								1
16	BACB30LH3-6		. BOLT								2
17	BACN10JC3		. NUT (REPLS NAS679A3W)								2
18	69-57840-1		. BUMPER								1
19	65-46486-60		. PLATE								1
	ITEMS 20 THRU 74		PRE SB 57-1090								
20	BACB30LU3-7		. BOLT (REPLS BACB30FL3-7)							A-JO-T	1
21	65-50708-15		. FILLER							A-JO-T	1
22	BACS40R8E9		. SHIM							A-JO-T	1
23	BACN10FX1		. NUT, CLIP-ON							A-JO-T	1
24	BACB30LU3-5		. BOLT (REPLS BACB30FL3-5)							A-JO-T	2
25	65-50708-29		. RETAINER, LH							ACEGIO QS	1
25	65-50708-30		. RETAINER, RH							BDFHJP RT	1
26	BACR15BA3D		. RIVET (REPLS MS20426D3)							A-JO-T	4
27	BACN10JQ32		. NUTPLATE (REPLS BACN10LK5A32)							A-JO-T	2
28	BACB30LU3-4		. BOLT (REPLS BACB30FL3-4)							A-JO-T	8
29	65-50708-7		. RETAINER, LH							ACEGIO QS	1
29	65-50708-8		. RETAINER, RH							BDFHJP RT	1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
1105-											
30	BACR15BA3D		.	RIVET (REPLS MS20426D3)						A-JO-T	6
31	BACN10JN3		.	NUTPLATE (REPLS NAS1068A3)						A-JO-T	3
32	65-50708-41		.	RETAINER (USED WITH 65-50708-40)						A-JO-T	1
32	65-50708-49		.	RETAINER (USED WITH 65-50708-50)						A-JO-T	1
33	BACR15BA3D		.	RIVET (REPLS MS20426D3)						A-JO-T	2
34	BACN10KB3		.	NUTPLATE						A-JO-T	1
35	BACR15BA3D		.	RIVET (REPLS MS20426D3)						A-JO-T	8
36	BACN10JN3		.	NUTPLATE (REPLS NAS1068A3)						A-JO-T	4
37	65-50708-40		.	SEAL *[1]						A-JO-T	1
37	65-50708-50		.	SEAL *[1]						A-JO-T	1
38	BACB30LU4-10		.	BOLT (REPLS BACB30FL4-10)(USED WITH 65-71965-15,-16)						A-JO-T	3
38	BACB30LU4-12		.	BOLT (REPLS BACB30FL4-12)(USED WITH 65-76115-7 THRU -10)						A-JO-T	3
39	65-50708-47		.	RETAINER						A-JO-T	1
40	BACR15BA3D		.	RIVET (REPLS MS20426D3)						A-JO-T	6
41	BACN10JQ42		.	NUTPLATE (REPLS BACN101K5A32)						A-JO-T	3
42	69-57891-1		.	PLATE, SERRATED						A-JO-T	1
43	BACN10JC3		.	NUT (REPLS NAS679A3W)(USED WITH 65-71965-15,-16; 65-76115-7,-8)						A-JO-T	2
43	BACN10JC3		.	NUT (SB 57-1057)(USED WITH 65-76115-9,-10,-11,-12)						A-JO-T	1
43	BACN10JC4		.	NUT (USED WITH 65-76115-21,-22) (SB 57-1076R1)							6
44	AN960PD10		.	WASHER (USED WITH 65-71965-15,-16; 65-76115-7,-8)						A-JO-T	2
44	AN960PD10		.	WASHER (SB 57-1057)(USED WITH 65-76115-9,-10,-11,-12)						A-JO-T	1
44	AN960-416		.	WASHER (USED WITH 65-76115-21,-22) (SB 57-1076R1)							6
44A	69-61980-3		.	NUTPLATE STRIP (SB 57-1057)(USED WITH 65-76115-9,-10,-11,-12,-17,-18)						A-JO-T	1
44B	69-61980-6		.	STRIP							1
44C	BACN10JQ32		.	NUTPLATE							2
44D	MS20470M		.	RIVET							4
45	NAS603-7P		.	BOLT (REPLS NAS603-7)(USED WITH 65-71965-15,-16)						A-JO-T	2
45	NAS603-6P		.	BOLT (REPLS NAS603-6)(USED WITH 65-76115-7,-8)						A-JO-T	2
45A	BACB30NE3-6		.	BOLT (SB 57-1057,-1076)(USED WITH 65-76115-9,-10)						A-JO-T	3
45A	BACB30LU3-6		.	BOLT (USED WITH 65-76115-7,-8)(SB 57-1076)						A-JO-T	2

65-46436
65-71940
65-71969

BOEING
COMMERCIAL JET
OVERHAUL MANUAL

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	N O M E N C L A T U R E 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1105 45A	BACB30LU3-6		. BOLT (USED WITH 65B76115-11,-12)	A-J O-T	3
45A	NAS1504-6		. BOLT (USED WITH 65-76115-21,-22) (SB 57-1076R1)		6
46	BACS40R17D38		. SHIM	A-J O-T	AR
47	BACB30LU4-6		. BOLT (REPLS BACB30FL4-6)	A-J O-T	2
48	65-71965-19		. ANGLE ASSY, LH (USED WITH 65-71965-15; 65-76115-7)	A-J O-T	1
48	65-71965-20		. ANGLE ASSY, RH (USED WITH 65-71965-16; 65-76115-8)	A-J O-T	1
49	65-71965-5		. . ANGLE (USED ON 65-71965-19)		1
49	65-71965-6		. . ANGLE (USED ON 65-71965-20)		1
50	69-57889-4		. . PLATE, SERRATED		1
51	BACR15CE6M4		. . RIVET		4
52	69-57889-3		. PLATE, SERRATED	A-J O-T	1
53	BACR15BA3D		. RIVET (REPLS MS20426D3)	A-J O-T	4
54	BACN10JN4		. NUTPLATE (REPLS NAS1068A4)	A-J O-T	2
55	BACN10JC4		. NUT (REPLS NAS679A4W)	A-J O-T	1
56	AN96OPD416		. WASHER	A-J O-T	1
57	BACB30NF4-9		. BOLT (USED WITH 65-71965-15,-16)	A-J O-T	1
57	BACB30NF4-10		. BOLT (USED WITH 65-76115-7 THRU -10)	A-J O-T	1
58	BACB30NE4-8		. BOLT (REPLS NAS1304-8)(USED WITH 65-71965-15,-16)	A-J O-T	1
58	BACB30NE4-10		. BOLT (REPLS NAS1304-10)(USED WITH 65-76115-7 THRU -10)	A-J O-T	1
59	AN96OPD10		. WASHER	A-J O-T	1
60	BACN10GW4		. NUT (USED WITH 65-76115-7 THRU -10)	A-J O-T	1
60	BACN10JP4A		. NUTPLATE (USED WITH 65-71965-15,-16)	A-J O-T	1
61	BACR15BA3D		. RIVET (REPLS MS20426D3)(USED WITH 65-71965-15,-16)	A-J O-T	2

BOEING
COMMERCIAL JET
OVERHAUL MANUAL

65-46436
65-71940
65-71969

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	N O M E N C L A T U R E 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1105 62	69-57855-1		. PLATE, SERRATED	A-J O-T	2
63	65-50708-33		. SHIM, LH (MADE FROM BACS40R13E209)	ACEGI OQS	1
63	65-50708-34		. SHIM, RH (MADE FROM BACS40R13E209)	BDFHJ PRT	1
64	65-76115-7		. PLATE ASSY, SEAL, LH *[1]	ACEGI OQS	1
64	65-76115-8		. PLATE ASSY, SEAL, RH *[1]	BDFHJ PRT	1
64	65-76115-9		. PLATE ASSY, SEAL, LH (SB 57-1057)	A-J O-T	1
64	65-76115-10		. PLATE ASSY, SEAL, RH (SB 57-1057)	A-J O-T	1
64	65-76115-11		. PLATE ASSY, SEAL, LH *[1](OPT TO 65-76115-17)	ACEGI OQS	1
64	65-76115-12		. PLATE ASSY, SEAL, RH *[1](OPT TO 65-76115-18)	BDFHJ PRT	1
64	*[2]		. PLATE ASSY, SEAL, LH (SB 57-1076) *[5]		1
64	*[2]		. PLATE ASSY, SEAL, RH (SB 57-1076) *[5]		1
64	65-71965-15		. PLATE ASSY, SEAL, LH *[1]	ACEGI OQS	1
64	65-71965-16		. PLATE ASSY, SEAL, RH *[1]	BDFHJ PRT	1
64	*[2]		. PLATE ASSY, SEAL, LH (REWCD FROM 65-71965-15 BY SB 57-1057)		1
64	*[2]		. PLATE ASSY, SEAL, RH (REKD FROM 65-71965-16 BY SB 57-1057)		1
64	65-76115-17		. PLATE ASSY, SEAL, LH (OPT TO 65-76115-11)	ACEGI OQS	1
64	65-76115-18		. PLATE ASSY, SEAL, RH (OPT TO 65-76115-12)	BDFHJ PRT	1
64	65-76115-21		. PLATE ASSY, SEAL LH (SB 57-1076R1)		1
64	65-76115-22		. PLATE ASSY, SEAL RH (SB 57-1076R1)		1
65	65-71965-11		. . PLATE, SEAL, LH (USED ON 65-71965-15)*[1]		1
65	65-71965-12		. . PLATE, SEAL, RH (USED ON 65-71965-16)*[1]		1
65	65-71965-17		. . PLATE, SEAL, LH (USED ON 65-71965-15)*[1]		1
65	65-71965-18		. . PLATE, SEAL, RH (USED ON 65-71965-16)*[1]		1
65	65-76115-3		. . FAIRING ASSY, LH (USED ON 65-76115-7 AND -9)		1

65-46436
65-71940
65-71969

BOEING
COMMERCIAL JET
OVERHAUL MANUAL

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	N O M E N C L A T U R E							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
1105											
65	65-76115-4										1
65	65-76115-15										1
65	65-76115-16										1
65	65-76115-19										1
65	65-76115-20										1
65	*[2]										1
65	*[2]										1
65B	65-76115-13										1
65B	65-76115-14										1
65B	*[2]										1
65B	*[2]										1
65B	*[2]										1
66	65-71965-3										1
66	65-71965-4										1
67	BACB30UJ3-2										12
68	BACN10RB3										12
69	BACR15CE5B5										3
69	BACR15BA6DD										3
70	BACR15CE6M5										8
70	BACR15BA6DD										8
71	69-57889-1										1
71	69-57889-2										1
71	69-57889-11										1

BOEING
COMMERCIAL JET
OVERHAUL MANUAL

65-46436
65-71940
65-71969

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	N O M E N C L A T U R E 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1105					
71	69-57889-12		. . PLATE, SERRATED, RH (USED ON 65-76115-7, -9, -11, -17)		1
72	65-71965-14		. . FILLER (USED ON 65-71965-15, -16)		1
73	BACR15CE6M5		. . RIVET (USED ON 65-71965-15, -16)		4
73	BACR15BA6DD		. . RIVET (USED ON 65-76115-7 THRU -10)		4
74	69-57889-5		. . PLATE, SERRATED, LH (USED ON 65-71965-15)		1
74	69-57889-6		. . PLATE, SERRATED, RH (USED ON 65-71965-16)		1
74	69-57889-9		. . PLATE, SERRATED, LH (USED ON 65-76115-7, -9, -11, -17)		1
74	69-57889-10		. . PLATE, SERRATED, RH (USED ON 65-76115-8, -10, -12, -18)		1
75	BACB30LU3-4		. BOLT (REPLS BACB30FL3-4)		3
76	65-71904-14		. SEAL		1
77	65-71904-15		. RETAINER		1
78	BACR15BA3D		. RIVET (REPLS MS20426D3)		6
79	BACN10JN3		. NUTPLATE (REPLS NAS1068A3)		3
80	BACB30LU3-4		. BOLT (REPLS BACB30FL3-4)		3
81	65-71904-12		. RETAINER		1
82	65-71904-13		. SEAL		1
83	BACR15BA3D		. RIVET (REPLS MS20426D3)		6
84	BACN10JN3		. NUTPLATE (REPLS NAS1068A3)		3
85	BACB30LU3-6		. BOLT (REPLS BACB30FL3-6)		5
86	65-71904-9		. RETAINER, LH		1
86	65-71904-10		. RETAINER, RH		1
87	65-71904-11		. SEAL		1
88	65-71904-7		. FILLER		1
89	65-71904-8		. FILLER		1
90	BACR15BA3D		. RIVET (REPLS MS20426D3)		10
91	BACN10JN3		. NUTPLATE (REPLS NAS1068A3)		5
92	65-47841-73		. SEAL (USED WITH 65-46486-31)*[1]	ACEG	1
92	65-47841-74		. SEAL (USED WITH 65-46486-32)*[1]	BDFH	1
92	65-47841-95		. SEAL, LH (SB 57-1057)(USED WITH 65-79953-1, -9, AND 65C10544-1)		1
92	65-47841-96		. SEAL, RH (SB 57-1057)(USED WITH 65-79953-2, -10, AND 65C10544-2)		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
1105-93	BACB30LU2-3		.	BOLT (REPLS BACB30FL2-3)							25
94	65-47841-75		.	RETAINER, LH							1
94	65-47841-76		.	RETAINER, RH							1
95	65-47841-25		.	RETAINER, LH							1
95	65-47841-26		.	RETAINER, RH							1
96	65-47841-33		.	RETAINER, LH							1
96	65-47841-34		.	RETAINER, RH							1
97	65-47841-27		.	RETAINER, LH							1
97	65-47841-28		.	RETAINER, RH							1
98	65-47841-63		.	RETAINER (USED WITH 65-46486-31)						ACEG	1
				*[1]							
98	65-47841-64		.	RETAINER (USED WITH 65-46486-32)						BDFH	1
				*[1]							
98	65-47841-93		.	RETAINER, LH (SB 57-1057)(USED WITH 65-79953-1,-9 AND 65C10544-1)							1
98	65-47841-94		.	RETAINER, RH (SB 57-1057)(USED WITH 65-79953-2,-10 AND 65C10544-2)							1
99	65-47840-1			DELETED							
99	65-47840-2			DELETED							
99	65-71971-103		.	SKIN ASSY, LWR AFT INBD, LH						KMQUW	1
99	65-71971-104		.	SKIN ASSY, LWR AFT INBD, RH						LNRVX	1
99	65-47840-13		.	SKIN ASSY, LWR AFT INBD, LH						ACEGI	1
										OSY	
										BA-EA	
										TA VA	
99	65-47840-14		.	SKIN ASSY, LWR AFT INBD, RH						BDFHJ	1
										PTZ	
										NA-QA	
										UA WA	
99	65-47840-23		.	SKIN ASSY, LWR AFT INBD, LH						RA	1
99	65-47840-24		.	SKIN ASSY, LWR AFT INBD, RH						SA	1
100	BACB30LU3-4		.	BOLT (REPLS BACB30FL3-4)							116
101	BACB30LU4-7		.	BOLT (REPLS BACB30FL4-7)							58
102	65-47839-11		.	SKIN ASSY, LWR FWD INBD, LH						ACEGI	1
										OSY	
										BA-EA	
										TA VA	
102	65-47839-12		.	SKIN ASSY, LWR FWD INBD, RH						BDFHJ	1
										PTZ	
										NA-QA	
										UA WA	
103	BACB30LU3-4		.	BOLT (REPLS BACB30FL3-4)							33
104	BACB30LU4-7		.	BOLT (REPLS BACB30FL4-7)							24
105	65-47839-1		.	SKIN ASSY, LWR FWD CTR, LH						ACEGI	1
										OSY	
										BA-EA	
										TA VA	

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
1105-105	65-47839-2		. SKIN ASSY, LWR FWD CTR, RH							BDFHJ PTZ NA-QA UA WA	1
106	65-67105-14		. PLATE, SPLICE								1
107	BACB30LU3-4		. BOLT (REPLS BACB30FL3-4)								83
108	BACB30LU4-7		. BOLT (REPLS BACB30FL4-7)								30
109	65-71903-5		. SKIN ASSY, LWR OUTBD, LH *[1] (PRE SB 57-1048)							ACOQU W	1
109	65-71903-6		. SKIN ASSY, LWR OUTBD, RH *[1] (PRE SB 57-1048)							BDPRVX	1
109	65-71903-9		. SKIN ASSY, LWR OUTBD, LH (SB 57-1048)							ACKMO Q	1
109	65-71903-10		. SKIN ASSY, LWR OUTBD, RH (SB 57-1048)							BDLNPR	1
109	65-71903-9		. SKIN ASSY, LWR OUTBD, LH							EG	1
109	65-71903-10		. SKIN ASSY, LWR OUTBD, RH							FH	1
109	65-71903-11		. SKIN ASSY, LWR OUTBD, LH							ISY	1
109	65-71903-12		. SKIN ASSY, LWR OUTBD, RH							BA-EA TA VA JTZ NA-QA UA WA	1
110	BACB30LU3-4		. BOLT (REPLS BACB30FL3-4)								11
111	BACB30LU4-7		. BOLT (REPLS BACB30FL4-7)								72
112	BACB30LU3-6		. BOLT (REPLS BACB30FL3-6)								1
113	65-47901-1		. TRACK								2
114	65-50746-1		. TRACK								1
115	BACN10JC4		. NUT (REPLS NAS679A4W)								3
116	BACS18K25-14W		. SPACER								6
117	AN960PD416		. WASHER								AR
118	NAS1104-7		. BOLT (REPLS NAS1104-7W)								3
119			. TRACK AND GUIDE INSTL (FIG. 1109)								1
120	BACB30LU3-6		. BOLT *[3]								1
121	BACB30LU3-9		. BOLT *[3]								1
122	AN960PD10L		. WASHER								2
123	BACN10JC3		. NUT (REPLS NAS679A3W)							A-JO-T	1
124	69-54946-2		. HOOK							A-JO-T	1
125	BACS40R10C27		. SHIM							A-JO-T AR	
126	65C10544-1		. SEAL INSTL (SB 57-1090)(LIMITED) (PRE SB 57-1223) *[1]							Y TA	1
126	65C10544-2		. SEAL INSTL (SB 57-1090)(LIMITED) (PRE SB 57-1223) *[1]							Z UA	1
126	65C10544-11		. SEAL INSTL (LIMITED) (PRE SB 57-1223)							Y BA-EA TA VA	1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
1105-126	65C10544-12		.	SEAL	INSTL	(LIMITED)	(PRE	SB	57-1223)	Z NA-QA UA WA	1
126	65C10544-13		.	SEAL	INSTL	(PRE	SB	57-1223)		RA	1
126	65C10544-14		.	SEAL	INSTL	(PRE	SB	57-1223)		SA	1
126	65C10544-23		.	SEAL	INSTL	(POST	SB	57-1223)	*[1]	Y BA-EA RA TA VA	1
126	65C10544-24		.	SEAL	INSTL	(POST	SB	57-1223)	*[1]	Z NA-QA SA UA WA	1
127	BACB30NN3K4		.	.	BOLT	(REPLS	BACB30LU3-4)	(USED	ON 65C10544-11,-12)		3
127	BACB30NN3K4		.	.	BOLT	(USED	ON 65C10544-13,-14)			RA SA	3
127	BACB30LU3-4		.	.	BOLT	(REPLD	BY BACB30NN3K4)				3
128	NAS1068A3		.	.	NUTPLATE						3
129	BACR15BA3D		.	.	RIVET						6
130	65C10544-3		.	.	SEAL						1
131	65C10544-5		.	.	RETAINER					Y BA-EA RA TA VA	1
131	65-50708-7		.	.	RETAINER	(OPT	TO 65C10544-5)			Y BA-EA RA TA VA	1
131A	65C10544-6		.	.	RETAINER					Z NA-QA SA UA WA	1
131A	65-50708-8		.	.	RETAINER	(OPT	TO 65C10544-6)			Z NA-QA SA UA WA	1
132	BACB30NN3K7		.	.	BOLT	(REPLS	BACB30LU3-7)	(USED	ON 65C10544-11,-12)		1
132	BACB30LU3-7		.	.	BOLT	(REPLD	BY BACB30NN3K7)			Y BA-EA TA VA RA SA	1
132	BACB30NN3K7		.	.	BOLT	(USED	ON 65C10544-13,-14)				1
133	BACN10FX21		.	.	NUT, CLIP-ON						1
134	BACS40R8E9F		.	.	SHIM, LAMINATED						AR
135	65-50708-15		.	.	FILLER						1
136	BACB30NN3K		.	.	BOLT	*[6]	(REPLS	BACB30LU3)			2
136	BACB30LU3		.	.	BOLT	*[6]	(REPLD	BY BACB30NN3K)			2
137	BACN10JQ32		.	.	NUTPLATE						2
138	BACR15BA3D		.	.	RIVET						4
139	BACS40R10E10F		.	.	SHIM						AR
140	65-50708-29		DELETED								
140	65-50708-30		DELETED								

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	N O M E N C L A T U R E							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
1105-140	65C10544-501		.	.							1
140	65C10544-502		.	.							1
141	65C10543-5		.	.						Y BA-EA RA TA VA	1
141	65C10543-6		.	.						Z NA-QA SA UA WA	1
142	BACB30LP5-		.	.							4
143	65C10543-1		.	.						Y TA	1
143	65C10543-2		.	.						Z UA	1
143	65C10543-17		.	.						Y BA- EA TA VA	1
143	65C10543-18		.	.						Z NA- QA UA WA	1
143	65C10543-27		.	.						RA	1
143	65C10543-28		.	.						SA	1
143	65C10543-43		.	.						Y NA-QA SA UA WA	1
143	65C10543-44		.	.						Z NA-QA SA UA WA	1
144	65C10544-8		.	.							1
145	65C10544-9		.	.							1
146	65C10544-4		.	.							1
147	65C10544-7		.	.							1
148	BACB30NN3K9		.	.							1
148	BACB30LU3-9		.	.							1
149	BACB30NN3K6		.	.							1
149	BACB30LU3-6		.	.							1
150	AN960PD10L		.	.							2
151	BACN10JC3		.	.							2
152	65C33274-1		.	.							1
152	65C33274-1		.	.							1

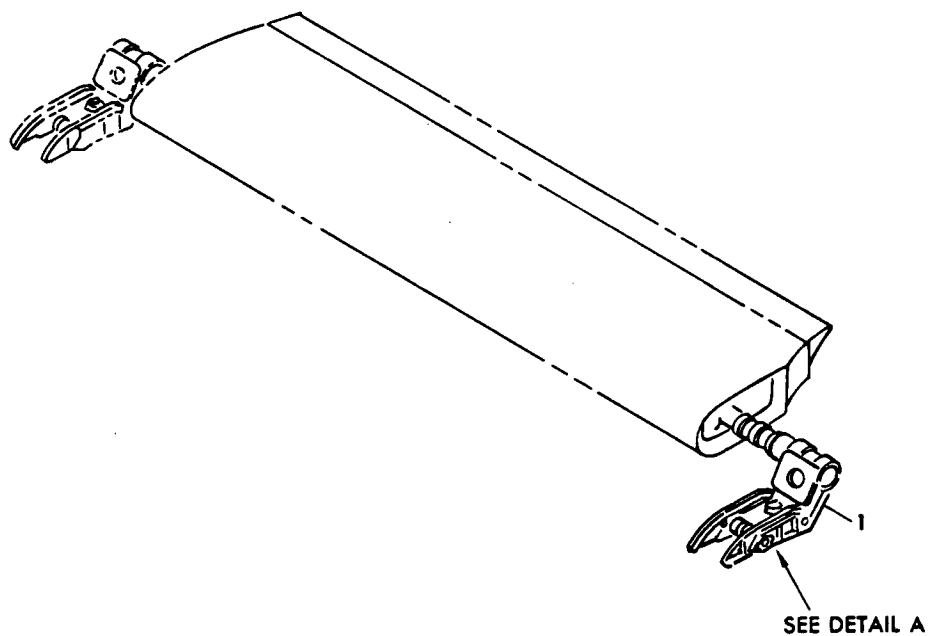
FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	N O M E N C L A T U R E							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
1105-152	65C33274-3		.	.							1
152	69-54946-2		.	.							1
152	69-54946-3		.	.							1
152	69-54946-4		.	.							1
152	69-54946-4		.	.							1
152	65C36873-1 (-2 OPP)		.	.							1
153	BACS40R10C27F		.	.							AR
154	65-52233-13		.	.							1
154	65-52233-14		.	.						Y BA-EA TA VA Z NA-QA UA WA	1
155	BACB30NN5K23		.	.							4
155	BACB30LU5-23		.	.							4
156	BACN10JR5F		.	.							4
157	BACR15BA4D		.	.							8
158	69-67279-1		.	.							1
158	69-67279-2		.	.							1
159	BACN10MX5		.	.	.						4
160	BACR15BA4D		.	.	.						8
161	69-67279-3		.	.	.						1
161	69-67279-4		.	.	.						1
162	65-55540-1		.	.						ACEGI Y TA	1
162	65-55540-2		.	.						BDFHJ Z UA	1
162	65-55540-19		.	.						BA	1
162	65-55540-20		.	.						NA	1
162	65-55540-25		.	.						CA DA	1
162	65-55540-26		.	.						OA PA	1
162	65-55540-27		.	.						EA RA VA	1
162	65-55540-28		.	.						QA WA	1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	N O M E N C L A T U R E							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
1105-											
-163	65-71993-19		.	P	R	O	T	E	C	T	1
-163	65-71993-20		.	P	R	O	T	E	C	T	1
			.	A	T	T	A	C	H	I	
-164	BACR15CE4B4		.	R	I	V	E	T		V	12
										W	
-165	65-71993-21		.	P	R	O	T	E	C	T	1
			.	A	T	T	A	C	H	I	
-166	BACR15CE4B4		.	R	I	V	E	T		V	7
										W	

- *[1] LIMITED USAGE
- *[2] NO BOEING PART NUMBER ASSIGNED
- *[3] ADJUST GRIP LENGTH OF BOLTS TO ENSURE THEY ARE FLUSH OR BELOW THE SURFACE OF HOOK. THREADS IN BEARING ARE PERMISSIBLE.
- *[4] 65-71902-1,-3,-9,-11,-13; 65-71940,-21,-25,-31; 65-71971-1,-3,-133,-135 WHEN REWORKED PER SB 57-1090 ARE RENUMBERED 65-71902-15. 65-71902-2,-4,-10,-12,-14; 65-71940-22,-26,-32; 65-71971-2,-4,-134,-136 WHEN REWORKED PER SB 57-1090 ARE RENUMBERED 65-71902-16. PARTS INSTALLED BY SB'S 57-1012, 57-1057, AND 57-1076 ARE DELETED BY SB 57-1090.
- *[5] REWORKED FROM SEAL PLATE ASSYS 65-76115-7 OR -9 (LH) OR 65-76115-8,-10 (RH). PHYSICALLY AND FUNCTIONALLY INTERCHANGEABLE WITH 65-76115-11 (LH) OR 65-76115-12 (RH) RESPECTIVELY.
- *[6] BOLT LENGTH AS REQUIRED.
- *[7] 65-71902-31,-32 OPP IDENTICAL TO 65-71902-23,-24 OPP. EXCEPT FOR FAYING SURFACE AND GAP SEALING AND FINISH.
- *[8] 65-71902-17,-18 OPP, -21,-22 OPP, -25,-26 OPP IDENTICAL TO 65-71902-15,-16 OPP, -19,-20 OPP, -23,-24 OPP, RESPECTIVELY, EXCEPT FOR FIBERGLASS/PLASTIC SKIN REINFORCEMENT.
- *[9] 65-71902-43, -44 OPP, -45, -46 OPP IDENTICAL TO 65-71902-41, -42 OPP EXCEPT FOR FAYING SURFACE AND GAP SEALING AND FINISH.
- *[10] SEE *[3] IN FIG. 1101
- *[11] 65-71940-31, -32 OPP, -37, -38 OPP IDENTICAL TO 65-71902-13, -14 OPP, -15, -16 OPP, RESPECTIVELY, EXCEPT FOR FIBERGLASS REINFORCEMENT AND FINISH.

65-46436
65-71940
65-71969

BOEING
COMMERCIAL JET
OVERHAUL MANUAL



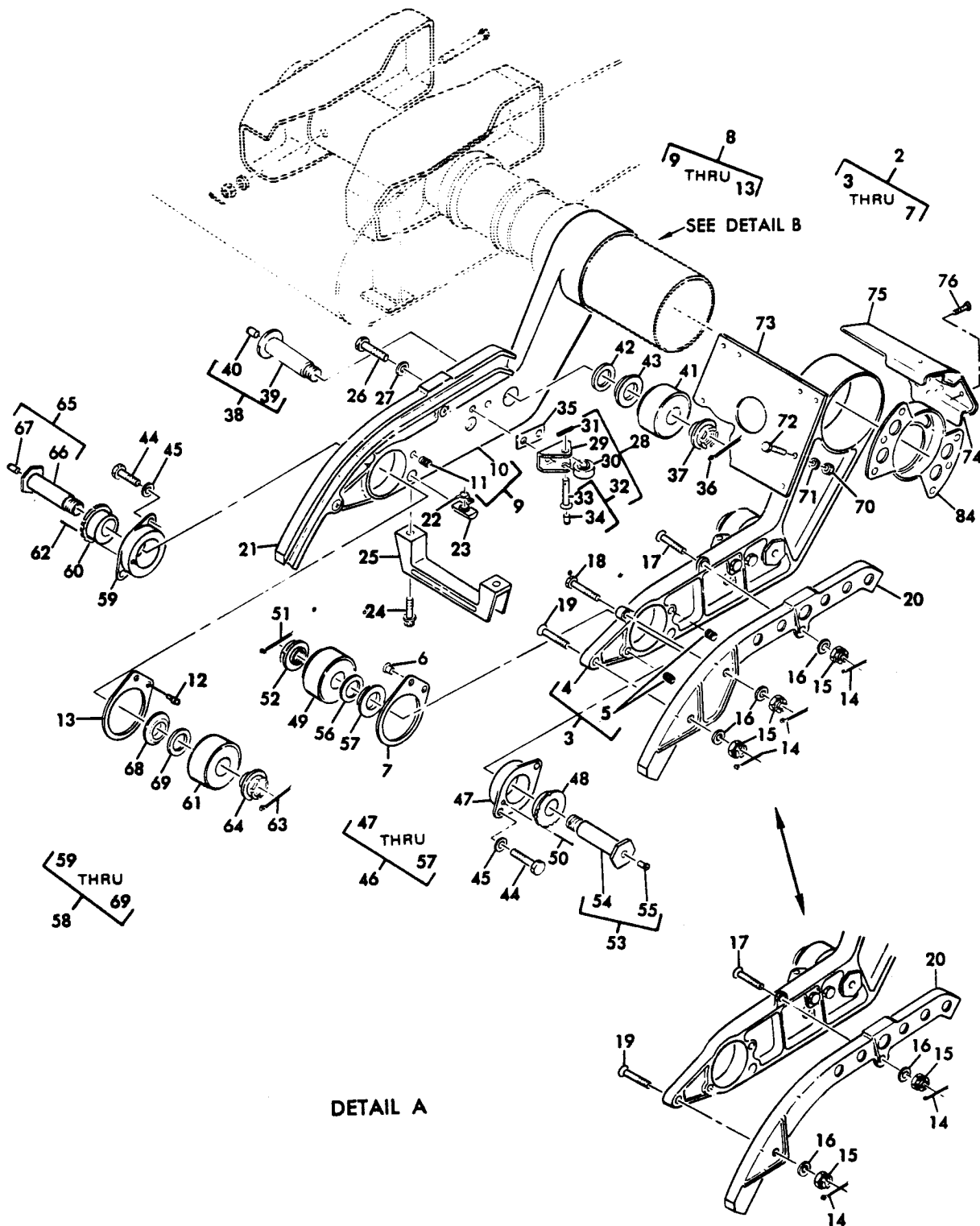
Jun 10/71

Mid Flap Outboard Carriage Installation
Figure 1106 (Sheet 1)

57-53-22
Page 1137

BOEING
COMMERCIAL JET
OVERHAUL MANUAL

65-46436
65-71940
65-71969

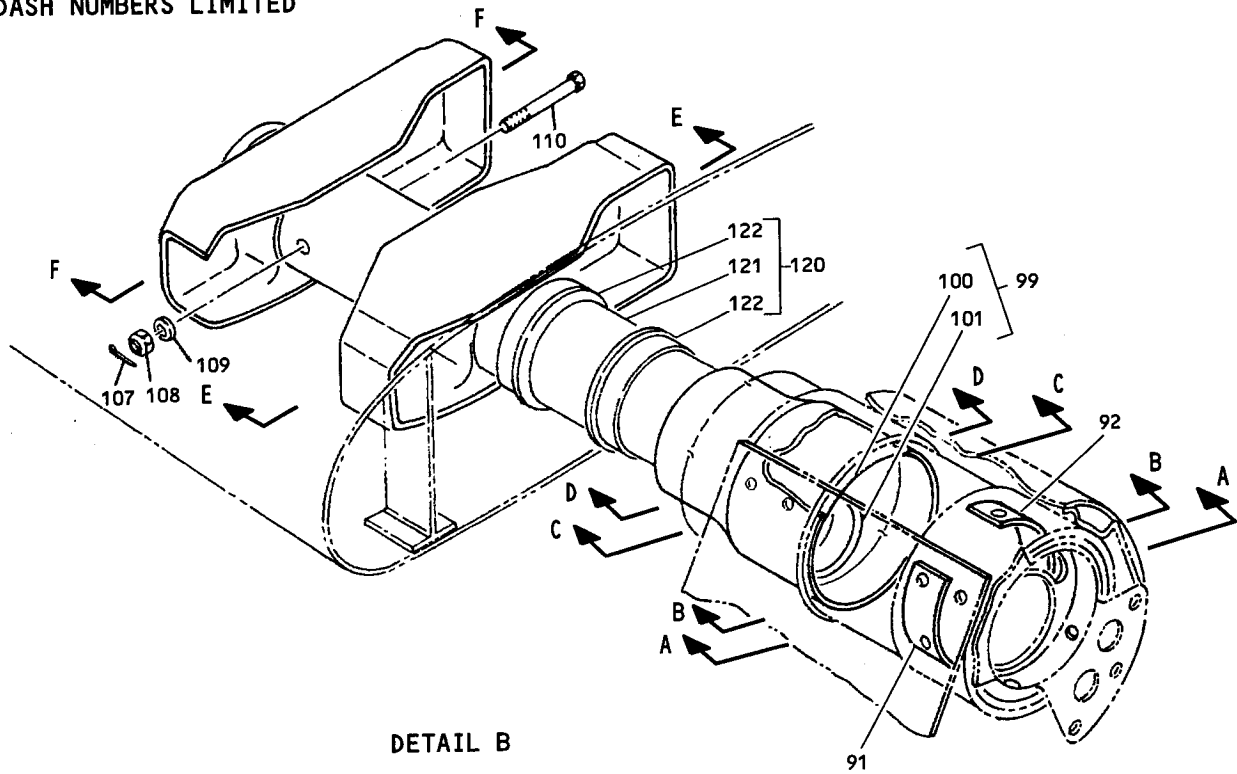


DETAIL A

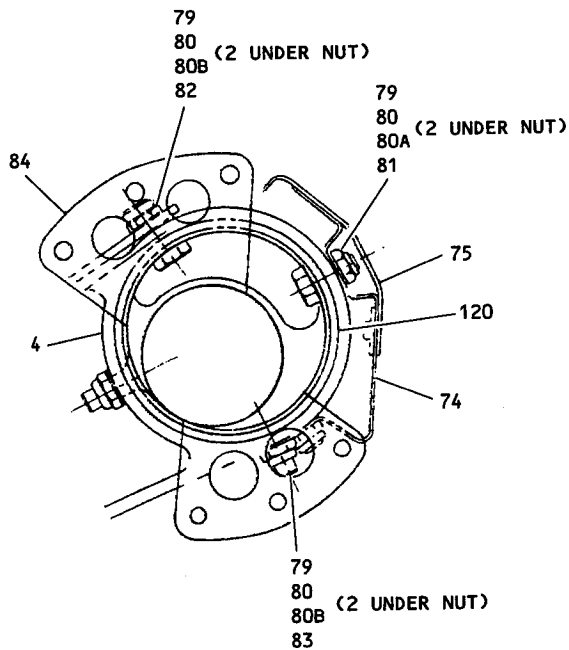
Mid Flap Outboard Carriage Installation
Figure 1106 (Sheet 2)

65-46436
65-71940
65-71969
DASH NUMBERS LIMITED

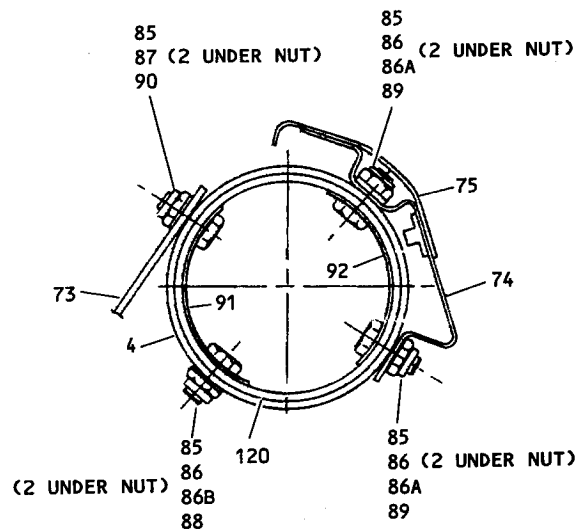
BOEING
OVERHAUL MANUAL



DETAIL B

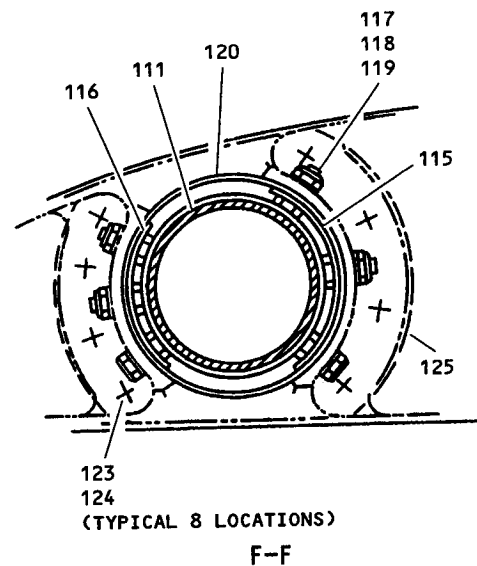
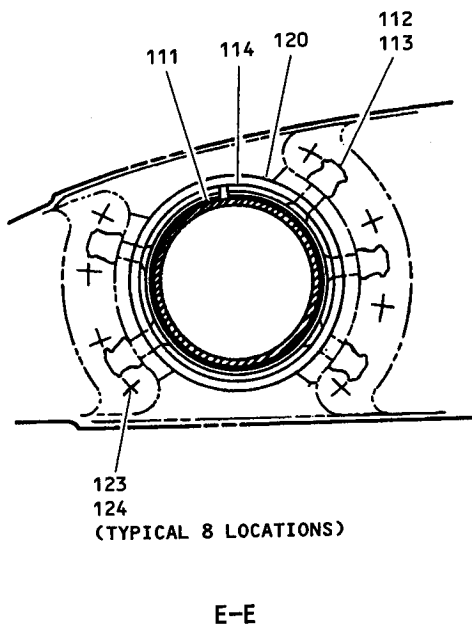
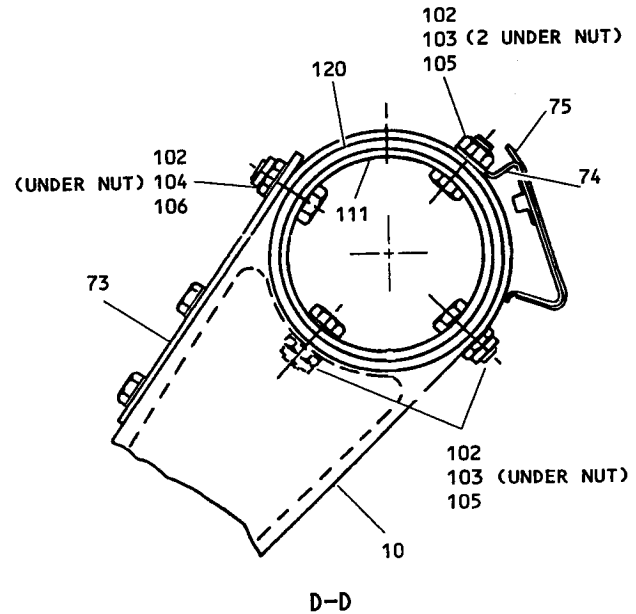
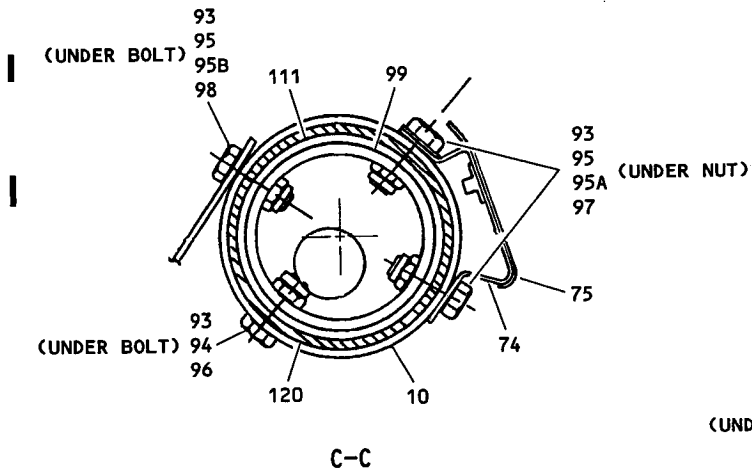


SECTION A-A



SECTION B-B

Mid Flap Outboard Carriage Installation
Figure 1106 (Sheet 3)



Mid Flap Outboard Carriage Installation
Figure 1106 (Sheet 4)

65-46436
65-71940
65-71969



OVERHAUL MANUAL

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1106-	65-68297-1		OUTBD CARRIAGE INSTL (LH) (SB 57-1029)	A	RF
	65-68297-2		OUTBD CARRIAGE INSTL (RH) (SB 57-1029)	B	RF
	65-68297-3		OUTBD CARRIAGE INSTL (LH) (SB 57-1029)	C	RF
	65-68297-4		OUTBD CARRIAGE INSTL (RH) (SB 57-1029)	D	RF
	65-46492-1		OUTBD CARRIAGE INSTL (LH) (SB 57-1029)	E	RF
	65-46492-2		OUTBD CARRIAGE INSTL (RH) (SB 57-1029)	F	RF
	65-46492-5		OUTBD CARRIAGE INSTL (LH) (SB 57-1029)	G	RF
	65-46492-6		OUTBD CARRIAGE INSTL (RH) (SB 57-1029)	H	RF
	65-68297-13		OUTBD CARRIAGE INSTL (LH)	I	RF
	65-68297-14		OUTBD CARRIAGE INSTL (RH)	J	RF
1	65-68297-5		. CARRIAGE ASSY, LH (REF 57-53-40)	A	1
1	65-68297-6		. CARRIAGE ASSY, RH (REF 57-53-40)	B	1
1	65-68297-7		. CARRIAGE ASSY, LH (REF 57-53-40)	CI	1
1	65-68297-7		. CARRIAGE ASSY (OPT TO 65-68297-5) (REF 57-53-40)	A	1
1	65-68297-8		. CARRIAGE ASSY (OPT TO 65-68297-6) (REF 57-53-40)	B	1
1	65-68297-8		. CARRIAGE ASSY, RH (REF 57-53-40)	DJ	1
2	65-46492-3		. CARRIAGE ASSY, LH (LIMITED)	EF	1
2	65-46492-7		. CARRIAGE ASSY, LH	GH	1
2	65-46492-9		. CARRIAGE ASSY, LH (LIMITED)	EF	1
3	65-47856-1		. . CARRIAGE ASSY (USED ON 65-46492-3)		1
3	65-47856-13		. . CARRIAGE ASSY (USED ON 65-46492-9)		1
3	65-67138-1		. . CARRIAGE ASSY (USED ON 65-46492-7)		1
4	65-47856-3		. . . CARRIAGE (USED ON 65-47856-1)		1
4	65-47856-15		. . . CARRIAGE (USED ON 65-47856-13)		1
4	65-67138-3		. . . CARRIAGE (USED ON 65-67138-1)		1
5	MS21209F4-15		. . . INSERT, HELICAL COIL		2
6	BACR15BA5B		. . RIVET (REPLS MS20246B5)		2
7	69-46447-1		. . STRIP, RUB		1
8	65-46492-4		. CARRIAGE ASSY, RH (LIMITED)	EF	1
8	65-46492-8		. CARRIAGE ASSY, RH	GH	1
8	65-46492-10		. CARRIAGE ASSY, RH (LIMITED)	EF	1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
1106-9	65-47856-2		.	.							1
9	65-47856-14		.	.							1
9	65-67138-2		.	.							1
10	65-47856-4		.	.	.						1
10	65-47856-16		.	.	.						1
10	65-67138-4		.	.	.						1
11	MS21209F4-15		.	.	.						2
12	BACR15BA5D		.	.							2
13	69-46447-1		.	.							1
14	MS24665-153		.							EF	6
14	MS24665-153		.							GH	4
15	BACN10JD104		.							EF	6
15	BACN10JD104		.							GH	4
16	AN960-416		.							EF	6
16	AN960-416		.							GH	4
17	BACB30LU4D13		.								2
18	NAS1104-10D		.								2
19	BACB30LU4D15		.								2
20	69-38848-1		.							EF	1
20	69-38848-5		.							EF	1
20	69-38848-5		.							GH	1
21	69-38848-2		.							EF	1
21	69-38848-6		.							EF	1
21	69-38848-6		.							GH	1
22	NAS578-5A		.								2
23	NAS577-5A		.								2
24	BACB30CW5H6		.								2
25	69-39230-1		.								1
26	BACB30NE4H6		.								4
27	BACW10BN4C		.								4
28	66-23233-1		.								2
29	69-37860-1		.	.							1
30	BACB10BN06		.	.							1
31	MS16562-216		.	.							1
32	66-23220-1		.	.							1
33	66-23220-3		.	.	.						1
34	NAS516-1		.	.	.						1

65-46436
65-71940
65-71969



OVERHAUL MANUAL

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
1106-											
35	BACS40SD14-26		.	SHIM							2
36	MS24665-287		.	PIN, COTTER (REPLS AN380-3-5)							2
37	66-19144-1		.	NUT (LIMITED)							2
37	66-19144-2		.	NUT (POST SB 57-1060)							2
38	66-23236-1		.	BOLT ASSY							2
39	66-23236-3		.	BOLT							1
40	NAS516-1		.	FITTING, LUBRICATION							1
41	BACB10BN14		.	BEARING (PRE SB 57-1060)							1
41	BACB10B136		.	BEARING (PRE SB 57-1060)							2
41	YR743-3		.	BEARING, V92563 (PRE SB 57-1060)							2
41	14AFC1832		.	BEARING, V92563 (POST SB 57-1060)							2
41	AC47485		.	BEARING, V80657 (POST SB 57-1060)							2
41	AC49007		.	BEARING, V80657 (POST SB 57-1060)							2
42	NAS1252-1416H		.	WASHER							2
43	69-46493-1		.	WASHER							2
44	BACB30NE4H2		.	BOLT (REPLS NAS1104-2H)							4
45	AN960-416L		.	WASHER							4
46	69-40659-3		.	ROLLER ASSY (REPLS 69-40659-1)							1
				(POST SB 57-1124)							
46	69-40659-1		.	ROLLER ASSY (PRE SB 57-1124)							1
47	66-24505-7		.	RETAINER (USED ON 69-40659-3)							1
47	66-24505-5		.	RETAINER (USED ON 69-40659-1)							1
48	69-37869-2		.	BUSHING, ECCENTRIC							1
49	BACB10BN14		.	BEARING (PRE SB 57-1060)							1
49	BACB10B136		.	BEARING (PRE SB 57-1060)							1
49	YR743-3		.	BEARING, V92563 (PRE SB 57-1060)							1
49	14AFC1832		.	BEARING, V92563 (POST SB 57-1060)							1
49	AC47485		.	BEARING, V80657 (POST SB 57-1060)							1
49	AC49007		.	BEARING, V80657 (POST SB 57-1060)							1
50	MS16562-35		.	PIN, SPRING							1
51	MS24665-289		.	PIN, COTTER (REPLS AN380-3-6)							1
52	66-19144-1		.	NUT (LIMITED)							1
52	66-19144-2		.	NUT (POST SB 57-1060)							1
53	66-23236-1		.	BOLT ASSY							1
54	66-23236-3		.	BOLT							1
55	NAS516-1		.	FITTING, LUBRICATION							1
56	69-46493-1		.	WASHER							1
57	69-46493-2		.	WASHER							1
58	69-40659-4		.	ROLLER ASSY (REPLS 69-40659-2)							1
				(POST SB 57-1124)							
58	69-40659-2		.	ROLLER ASSY (PRE SB 57-1124)							1
59	66-24505-8		.	RETAINER (USED ON 69-40659-4)							1
59	66-24505-6		.	RETAINER (USED ON 69-40659-2)							1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1106-60	69-37869-2		. . BUSHING, ECCENTRIC		1
61	BACB10BN14		. . BEARING (PRE SB 57-1060)		1
61	BACB10B136		. . BEARING (PRE SB 57-1060)		1
61	YR743-3		. . BEARING, V92563 (PRE SB 57-1060)		1
61	14AFC1832		. . BEARING, V92563 (POST SB 57-1060)		1
61	AC47485		. . BEARING, V80657 (POST SB 57-1060)		1
61	AC49007		. . BEARING, V80657 (POST SB 57-1060)		1
62	MS16562-35		. . PIN, SPRING		1
63	MS24665-289		. . PIN, COTTER (REPLS AN380-3-6)		1
64	66-19144-1		. . NUT (LIMITED)		1
64	66-19144-2		. . NUT (POST SB 57-1060)		1
65	66-23236-1		. . BOLT ASSY		1
66	66-23236-3		. . . BOLT		1
67	NAS516-1		. . . FITTING, LUBRICATION		1
68	69-46493-1		. . WASHER		1
69	69-46493-2		. . WASHER		1
70	BACN10JC5		. NUT (REPLS NAS679A5)		4
71	AN960PD516		. WASHER		4
72	NAS1105-5		. BOLT (REPLS NAS1105-5W)		4
73	69-39233-2		. PLATE (LIMITED)	EF	1
73	69-39233-4		. PLATE (OPT TO 69-39233-2) (LIMITED)	EF	1
73	69-39233-3		. PLATE	GH	1
74	69-44969-5		. SUPPORT, BUMPER, RH (PRE SB 57-1242)		1
74	69-44969-15		. SUPPORT BUMPER, RH (POST SB 57-1242)		1
74	69-44969-16		. SUPPORT BUMPER, LH (POST SB 57-1242)		1
74	69-44969-6		. SUPPORT, BUMPER, LH (PRE SB 57-1242)		1
75	69-44969-7		. PLATE, BUMPER, RH (LIMITED) (PRE SB 57-1242)	F	1
75	69-44969-8		. PLATE, BUMPER, LH (LIMITED) (PRE SB 57-1242)	E	1
75	69-44969-11		. PLATE, BUMPER, RH (LIMITED) (POST SB 57-1242)	F	1
75	69-44969-12		. PLATE, BUMPER, LH (LIMITED) (POST SB 57-1242)	E	1
75	69-44969-11		. PLATE, BUMPER, RH	H	1
75	69-44969-12		. PLATE, BUMPER, LH	G	1
76	BACB30LU3-2		. BOLT (REPLS BACB30FL3-2) (PRE SB 57-1242)		4

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1106-					
76	BACB30NN3K2		. BOLT (POST SB 57-1242)		4
77	BACR15BA3D		. RIVET (REPLS MS20426D3)		8
78	BACN10JR3F		. NUTPLATE (REPLS NAS686A3)		4
79	BACN10JC6CD		. NUT (REPLS BACN10JC6)		4
80	AN960PD616L		. WASHER (PRE SB 57-1242)		8
80A	NAS1149F0616P		. WASHER (POST SB 57-1242)		2
80B	AN960PD616L		. WASHER (POST SB 57-1242)		6
81	BACB30NR6K7		. BOLT (REPLS NAS1106-7)		1
82	NAS1106-8		. BOLT (REPLS NAS1106-8W)		1
83	BACB30LU6-8		. BOLT (REPLS BACB30FL6-8)		2
84	69-37209-3		. SUPPORT, GIMBAL	EG	1
84	69-37209-4		. SUPPORT, GIMBAL	FH	1
84	69-37209-5		. SUPPORT, GIMBAL *[2]		1
84	69-37209-6		. SUPPORT, GIMBAL *[2]		1
84	69-37209-7		. SUPPORT, GIMBAL (OPT TO 69-37209-5) *[2]		1
84	69-37209-8		. SUPPORT, GIMBAL (OPT TO 69-37209- 6) *[2]		1
84	69-37209-9		. SUPPORT, GIMBAL (OPT)	EG	1
84	69-37209-10		. SUPPORT, GIMBAL (OPT)	FH	1
85	BACN10JC6CD		. NUT (REPLS BACN10JC6)		4
86	AN960PD616L		. WASHER (PRE SB 57-1242)		6
86A	NAS1149F0616P		. WASHER (POST SB 57-1242)		4
86B	AN960PD616L		. WASHER (POST SB 57-1242)		2
87	AN960PD616		. WASHER		2
88	NAS1106-5		. BOLT (REPLS NAS1106-5W)		1
89	BACB30NR6K7		. BOLT (REPLS NAS1106-6)		2
90	NAS1106-7		. BOLT (REPLS NAS1106-7W)		1
91	69-40642-5		. WASHER		1
92	69-40642-6		. WASHER		1
93	BACN10JC6CD		. NUT (REPLS BACN10JC6)		4
94	AN960PD616		. WASHER		1
95	AN960PD616L		. WASHER (PRE SB 57-1242)		3
95A	NAS1149F0616P		. WASHER (POST SB 57-1242)		2
95B	AN960PD616L		. WASHER (POST SB 57-1242)		1
96	NAS1106-9		. BOLT (REPLS NAS1106-9W)		1
97	BACB30NR6K10		. BOLT (REPLS NAS1106-10)		2
98	NAS1106-11		. BOLT (REPLS NAS1106-11W)		1
99	69-37208-7		. SUPPORT ASSY, LH		1
99	69-37208-8		. SUPPORT ASSY, RH		1
100	69-37208-9		. . SUPPORT (USED ON 69-37208-7)		1
100	69-37208-10		. . SUPPORT (USED ON 69-37208-8)		1

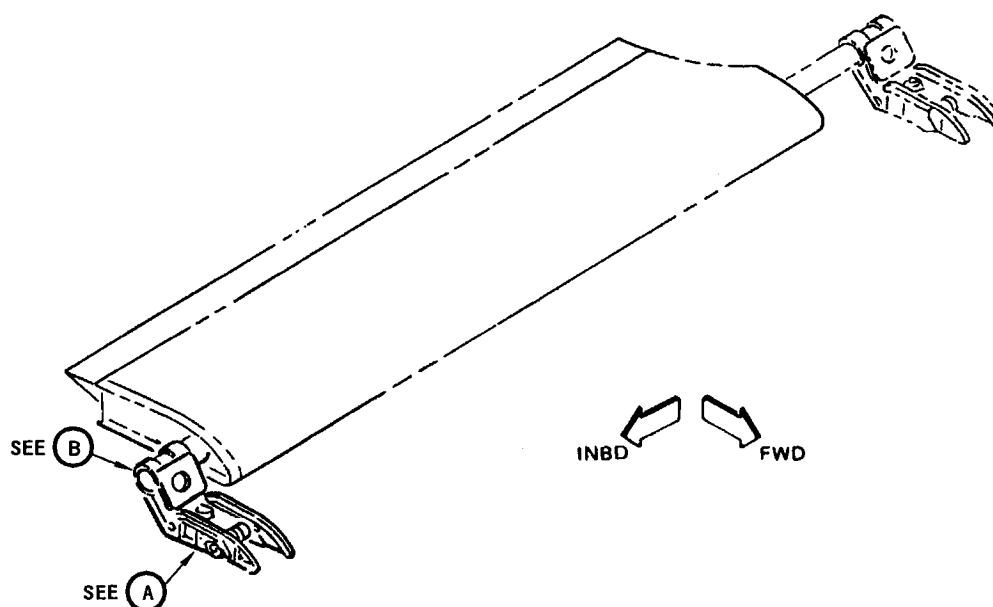
FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1106-					
101	66-23226-1		. . BUSHING		1
102	BACN10JC6		. NUT (REPLS NAS679A6)		4
103	AN960PD616L		. WASHER		3
104	AN960PD616		. WASHER		1
105	NAS1106-6		. BOLT (REPLS NAS1106-6W)		3
106	NAS1106-8		. BOLT (REPLS NAS1106-8W)		1
107	MS24665-136		. PIN, COTTER (REPLS AN380-2-4)		1
108	BACN10JD5		. NUT (REPLS AN310-5)		1
109	AN960PD516		. WASHER		1
110	NAS1105-58D		. BOLT (REPLS NAS1105-58DW)		1
111	69-54984-1		. TUBE ASSY, FAILSAFE, LH		1
111	69-54984-2		. TUBE ASSY, FAILSAFE, RH		1
112	BACC30M10		. COLLAR		5
113	BACB30FN10-9		. BOLT (REPLS NAS1105-8)		5
114	69-54987-1		. SUPPORT, FAILSAFE, LH		1
114	69-54987-2		. SUPPORT, FAILSAFE, RH		1
115	69-40642-7		. WASHER, TORQUE TUBE STRAP		1
116	69-40642-8		. WASHER, TORQUE TUBE STRAP		1
117	BACN10JC4		. NUT (REPLS NAS679A4W)		6
118	AN960PD416		. WASHER		6
119	NAS1104-6		. BOLT (REPLS NAS1104-6W)		6
120	65-68296-1		. TORQUE TUBE ASSY, LH		1
120	65-68296-2		. TORQUE TUBE ASSY, RH		1
121	65-68296-3		. . TUBE (USED ON 65-68296-1)		1
121	65-68296-4		. . TUBE (USED ON 65-68296-2)		1
122	65-68296-5		. . SLEEVE (MADE FROM 69-54988-1)		2
123	BACC30K8		. COLLAR		16
124	BACB30GW8-7		. BOLT		16
125	69-54986-1		. SUPPORT, FAILSAFE, LH		1
125	69-54986-2		. SUPPORT, FAILSAFE, RH		1

*[1] USED ON CARRIAGE ASSEMBLIES WITH FAILSAFE BOLT LUG

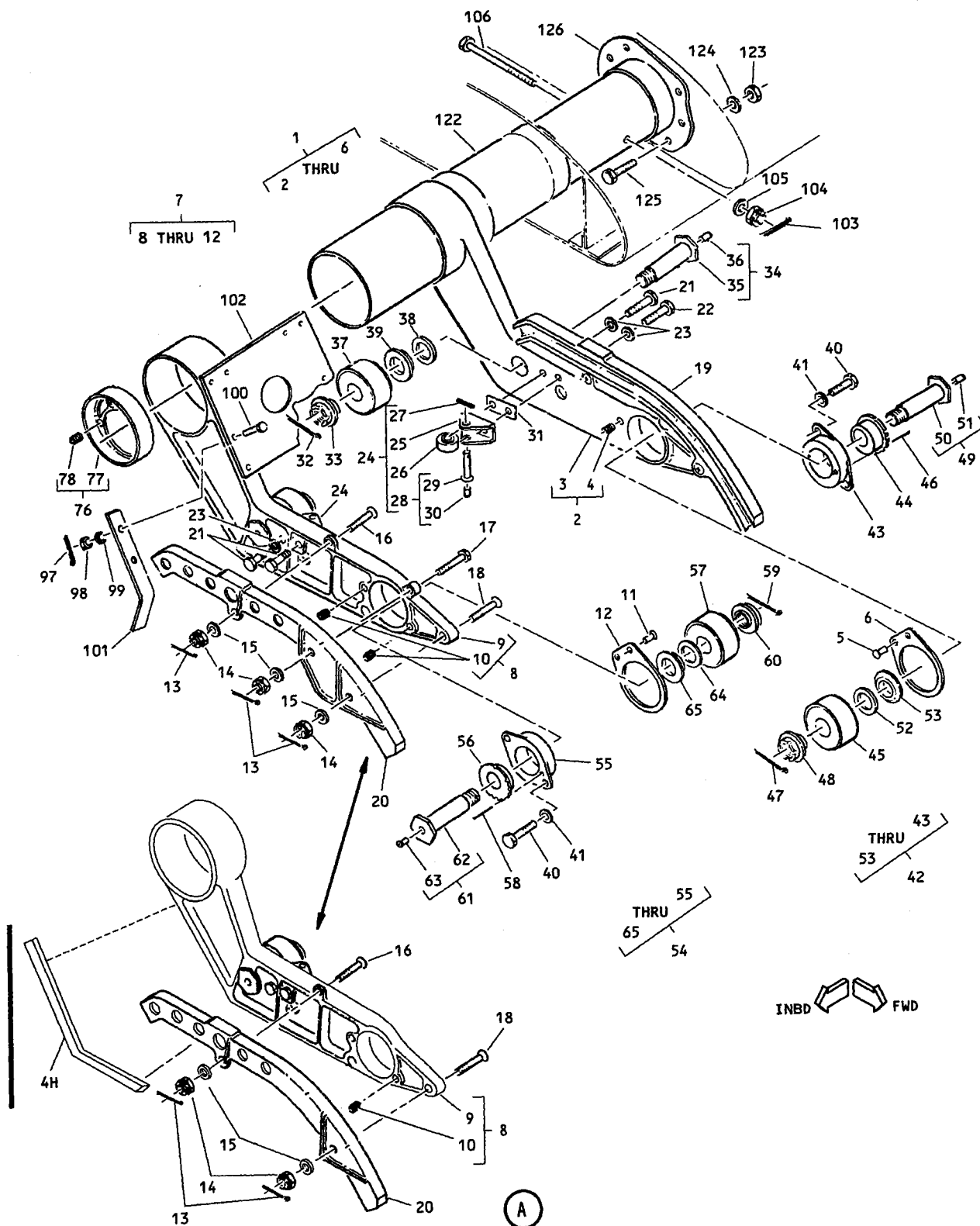
*[2] THIS PART COMES WITH UNDERSIZE BORE WHICH MUST BE INCREASED AT INSTALLATION. REFER TO ASSEMBLY FOR DETAILS.

65-46436
65-71940
65-71969

BOEING
COMMERCIAL JET
OVERHAUL MANUAL



Mid Flap Inboard Carriage Installation
Figure 1107 (Sheet 1)

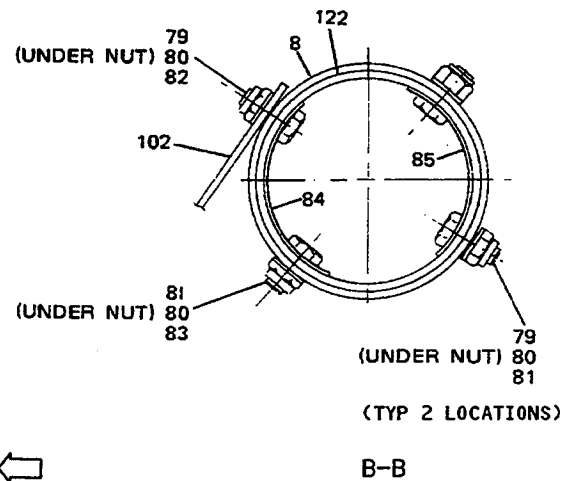
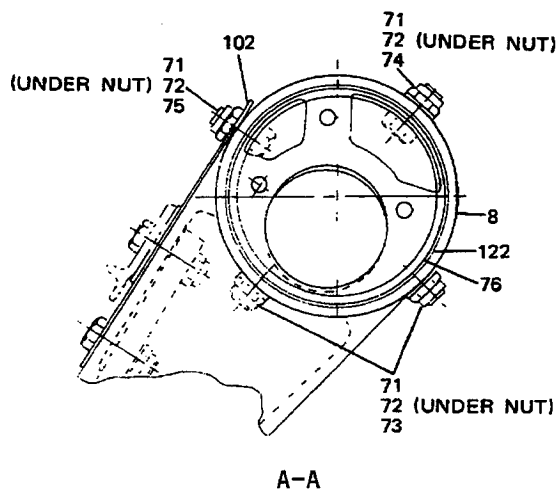
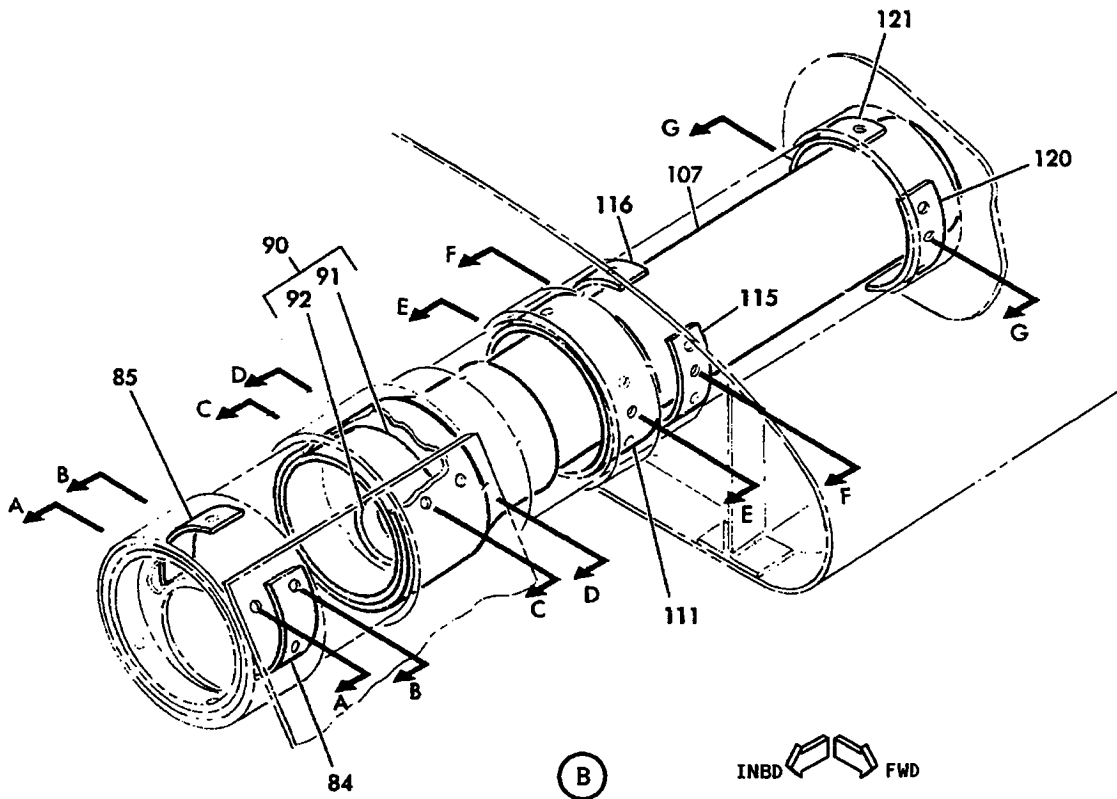


Mid Flap Inboard Carriage Installation
Figure 1107 (Sheet 2)

65-46436
65-71940
65-71969

BOEING
COMMERCIAL JET

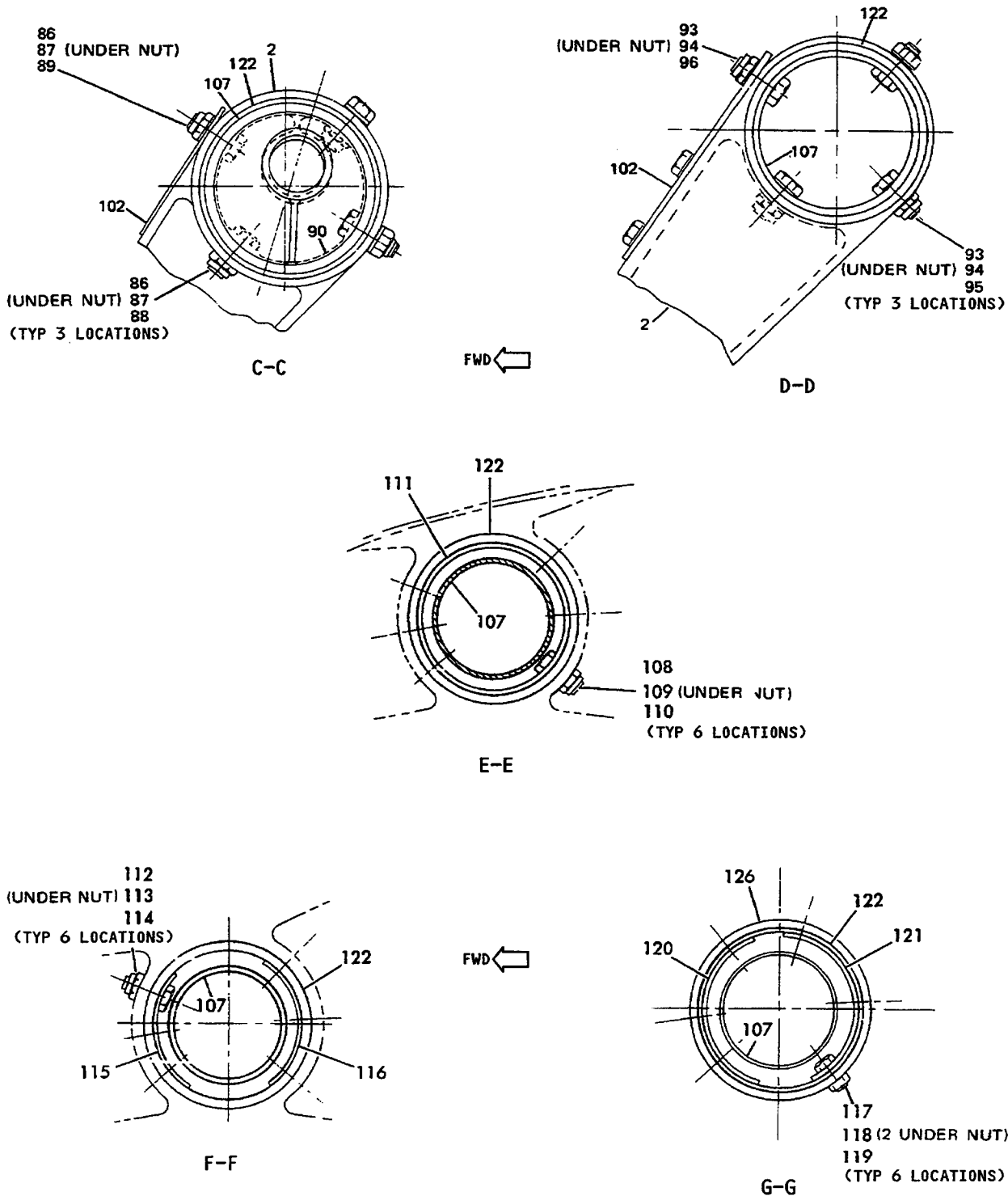
OVERHAUL MANUAL



Mid Flap Inboard Carriage Installation
Figure 1107 (Sheet 3)

BOEING
COMMERCIAL JET
OVERHAUL MANUAL

65-46436
65-71940
65-71969



Mid Flap Inboard Carriage Installation
Figure 1107 (Sheet 4)

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1107-	65-52246-1		MID FLAP INBOARD CARRIAGE INSTL (LH) (SB 57-1029)	A	RF
	65-52246-2		MID FLAP INBOARD CARRIAGE INSTL (RH) (SB 57-1029)	B	RF
	65-52246-7		MID FLAP INBOARD CARRIAGE INSTL (LH)	C	RF
	65-52246-8		MID FLAP INBOARD CARRIAGE INSTL (RH)	D	RF
1	65-52246-3		. CARRIAGE ASSY, LH *[1]	A	1
1	65-52246-9		. CARRIAGE ASSY, LH	C	1
1	65-52246-13		. CARRIAGE ASSY, LH *[1]	A	1
1	65-52246-4		. CARRIAGE ASSY, RH *[1]	B	1
1	65-52246-10		. CARRIAGE ASSY, RH	D	1
1	65-52246-14		. CARRIAGE ASSY, RH *[1]	B	1
1	65-52246-17		. CARRIAGE ASSY, LH *[1]	A	1
1	65-52246-18		. CARRIAGE ASSY, RH *[1]	B	1
2	65-47856-5		. . CARRIAGE ASSY (USED ON 65-52246-3)		1
2	65-47856-6		. . CARRIAGE ASSY (USED ON 65-52246-4)		1
2	65-47856-17		. . CARRIAGE ASSY (USED ON 65-52246-13)		1
2	65-47856-18		. . CARRIAGE ASSY (USED ON 65-52246-14)		1
2	65-67138-5		. . CARRIAGE ASSY (USED ON 65-52246-9)		1
2	65-67138-6		. . CARRIAGE ASSY (USED ON 65-52246-10)		1
2	65-47856-27		. . CARRIAGE ASSY (USED ON 65-52246-17)		1
2	65-47856-28		. . CARRIAGE ASSY (USED ON 65-52246-18)		1
3	65-47856-7		. . . CARRIAGE (USED ON 65-47856-5)		1
3	65-47856-8		. . . CARRIAGE (USED ON 65-47856-6)		1
3	65-47856-19		. . . CARRIAGE (USED ON 65-47856- 17, -27)		1
3	65-47856-20		. . . CARRIAGE (USED ON 65-47856- 18, -28)		1
3	65-67138-7		. . . CARRIAGE (USED ON 65-67138-5)		1
3	65-67138-8		. . . CARRIAGE (USED ON 65-67138-6)		1
4	MS21209F4-15		. . . INSERT, HELICAL COIL		2
4H	65-47856-25		. . . STRIP, RUB (USED ON 65-47856-17,-18,-5,-6)		1
4H	65-47856-29		. . . STRIP, RUB (OPT TO 69-78357-1) (USED ON 65-47856-27)		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1107-4H	65-47845-30		. . . STRIP, RUB (OPT TO 69-78357-2) (USED ON 65-47856-28)		1
4H	69-78357-1		. . . STRIP, RUB (OPT TO 65-47856-29) (USED ON 65-47856-27)		1
4H	69-78357-2		. . . STRIP, RUB (OPT TO 65-47856-30) (USED ON 65-47856-28)		1
6	69-46447-1		. . STRIP, RUB		1
7	65-52246-5		. CARRIAGE ASSY, LH *[1]	A	1
7	65-52246-11		. CARRIAGE ASSY, LH	C	1
7	65-52246-15		. CARRIAGE ASSY, LH *[1]	A	1
7	65-52246-6		. CARRIAGE ASSY, RH *[1]	B	1
7	65-52246-12		. CARRIAGE ASSY, RH	D	1
7	65-52246-16		. CARRIAGE ASSY, RH *[1]	B	1
8	65-47856-9		. . CARRIAGE ASSY (USED ON 65-52246-6)		1
8	65-47856-10		. . CARRIAGE ASSY (USED ON 65-52246-5)		1
8	65-47856-21		. . CARRIAGE ASSY (USED ON 65-52246-16)		1
8	65-47856-22		. . CARRIAGE ASSY (USED ON 65-5224615)		1
8	65-67138-9		. . CARRIAGE ASSY (USED ON 65-52246-12)		1
8	65-67138-10		. . CARRIAGE ASSY (USED ON 65-52246-11)		1
9	65-47856-11		. . . CARRIAGE (USED ON 65-47856-9)		1
9	65-47856-12		. . . CARRIAGE (USED ON 65-47856-10)		1
9	65-47856-23		. . . CARRIAGE (USED ON 65-47856-21)		1
9	65-47856-24		. . . CARRIAGE (USED ON 65-47856-22)		1
9	65-67138-11		. . . CARRIAGE (USED ON 65-67138-9)		1
9	65-67138-12		. . . CARRIAGE (USED ON 65-67138-10)		1
10	MS21209F4-15		. . . INSERT, HELICAL COIL		2
11	BACR15BA5B		. . RIVET (REPLS MS20246B5)		2
12	69-46447-1		. . STRIP, RUB		1
13	MS24665-153		. PIN, COTTER (REPLS AN381-2-10, AN381-2-12)		4
13	MS24665-153		. PIN, COTTER *[2]		6

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
1107-											
14	BACN10JD104		.	NUT	(REPLS	AN320-4)					4
14	BACN10JD104		.	NUT	(REPLS	AN320-4) *[2]					6
15	AN960-416		.	WASHER							4
15	AN960-416		.	WASHER	*[2]						6
16	BACB30LU4D13		.	BOLT	(REPLS	BACB30ABP4-13)					2
17	NAS1104-10D		.	BOLT	(REPLS	NAS1104-10DW) *[2]					2
18	BACB30LU4D15		.	BOLT	(REPLS	BACB30ABP4-15)					2
19	69-38848-1		.	CAM	*[1]*[2]					AB	1
19	69-38848-5		.	CAM	*[1]					AB	1
19	69-38848-5		.	CAM						CD	1
20	69-38848-2		.	CAM	*[1]*[2]					AB	1
20	69-38848-6		.	CAM	*[1]					AB	1
20	69-38848-6		.	CAM						CD	1
21	BACB30NE4H6		.	BOLT	(REPLS	NAS1304-6H)					3
22	BACB30NE4H10		.	BOLT	(REPLS	NAS1304-10H)					1
23	BACW10BN4C		.	WASHER	(REPLS	BACW10AKC4)					3
23	BACW10BN4C		.	WASHER	(REPLS	BACW10AKC4)					3
24	66-23233-1		.	ROLLER ASSY							2
25	69-37860-1		.	BRACKET							1
26	BACB10BN06		.	BEARING	(REPLS	BACB10B132)					1
27	MS16562-216		.	PIN, SPRING							1
28	66-23220-1		.	BOLT ASSY							1
29	66-23220-3		.	BOLT							1
30	NAS516-1		.	FITTING, LUBE							1
31	BACS40SD14-26		.	SHIM							2
32	MS24665-287		.	PIN, COTTER	(REPLS	AN380-3-5)					2
33	66-19144-1		.	NUT	(PRE SB	57-1060) *[1]					2
33	66-19144-2		.	NUT	(POST SB	57-1060)					2
34	66-23236-1		.	BOLT ASSY							2
35	66-23236-3		.	BOLT							1
36	NAS516-1		.	FITTING, LUBE							1
37	BACB10BN14		.	BEARING	(PRE SB	57-1060)					2
37	BACB10B136		.	BEARING	(PRE SB	57-1060)					2
37	YR743-3		.	BEARING	V92563	(PRE SB 57-1060)					2
37	14AFC1832		.	BEARING	V92563	(POST SB 57-1060)					2
37	AC47485		.	BEARING	V80657	(POST SB 57-1060)					2
37	AC49007		.	BEARING	V80657	(POST SB 57-1060)					2
38	NAS1252-1416H		.	WASHER							2
39	69-46493-1		.	WASHER							2
40	BACB30NE4H2		.	BOLT	(REPLS	NAS1304-2H)					4
41	AN960-416L4		.	WASHER							4

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1107-					
42	69-40659-1		. ROLLER ASSY		1
43	66-24505-5		. . RETAINER		1
44	69-37869-2		. . BUSHING, ECCENTRIC		1
45	BACB10BN14		. . BEARING (PRE SB 57-1060)		1
45	BACB10B136		. . BEARING (PRE SB 57-1060)		1
45	YR743-3		. . BEARING, V92563 (PRE SB 57-1060)		1
45	14AFC1832		. . BEARING, V92563 (POST SB 57-1060)		1
45	AC47485		. . BEARING, V80657 (POST SB 57-1060)		1
45	AC49007		. . BEARING, V80657 (POST SB 57-1060)		1
46	MS16562-35		. . PIN, SPRING		1
47	MS24665-289		. . PIN, COTTER (REPLS AN380-3-6)		1
48	66-19144-1		. . NUT (PRE SB 57-1060) *[1]		1
48	66-19144-2		. . NUT (POST SB 57-1060)		1
49	66-23236-1		. . BOLT ASSY		1
50	66-23236-3		. . . BOLT		1
51	NAS516-1		. . . FITTING, LUBE		1
52	69-46493-1		. . WASHER		1
53	69-46493-2		. . WASHER		1
54	69-40659-2		. ROLLER ASSY		1
55	66-24505-6		. . RETAINER		1
56	69-37869-2		. . BUSHING, ECCENTRIC		1
57	BACB10BN14		. . BEARING (PRE SB 57-1060)		1
57	BACB10B136		. . BEARING (PRE SB 57-1060)		1
57	YR743-3		. . BEARING, V92563 (PRE SB 57-1060)		1
57	14AFC1832		. . BEARING, V92563 (POST SB 57-1060)		1
57	AC47485		. . BEARING, V80657 (POST SB 57-1060)		1
57	AC49007		. . BEARING, V80657 (POST SB 57-1060)		1
58	MS16562-35		. . PIN, SPRING		1
59	MS24665-289		. . PIN, COTTER (REPLS AN380-3-6)		1
60	66-19144-1		. . NUT (PRE SB 57-1060)		1
60	66-19144-2		. . NUT (POST SB 57-1060)		1
61	66-23236-1		. . BOLT ASSY		1
62	66-23236-3		. . . BOLT		1
63	NAS516-1		. . . FITTING, LUBE		1
64	69-46493-1		. . WASHER		1
65	69-46493-2		. . WASHER		1
66	69-44969-5		DELETED		
66	69-44969-6		DELETED		
67	69-44969-9		DELETED		
67	69-44969-10		DELETED		
68	BACB30LU3-2		DELETED		
69	BACR15BA3D		DELETED		

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
1107-70	BACN10JR3F		DELETED								
71	BACN10JC6		. NUT (REPLS NAS679A6)								4
72	AN960PD616		. WASHER								4
73	BACB30DP6-7		. BOLT							CD	2
73	BACB30EL6-8		. BOLT							AB	2
74	BACB30DM6-6		. BOLT							CD	1
74	NAS1106-6		. BOLT (REPLS NAS1106-6W)							AB	1
75	BACB30DM6-8		. BOLT							CD	1
75	NAS1106-8		. BOLT (REPLS NAS1106-8W)							AB	1
76	69-40657-5		. SUPPORT ASSY, BEARING, GIMBAL SHAFT *[1]							A	1
76	69-40657-5		. SUPPORT ASSY, BEARING, GIMBAL SHAFT							C	1
76	69-40657-9		. SUPPORT ASSY, BEARING, GIMBAL SHAFT (OPT TO 69-40657-5) *[1]							AC	1
76	69-40657-6		. SUPPORT ASSY, BEARING, GIMBAL SHAFT *[1]							B	1
76	69-40657-6		. SUPPORT ASSY, BEARING, GIMBAL SHAFT							D	1
76	69-40657-10		. SUPPORT ASSY, BEARING, GIMBAL SHAFT (OPT TO 69-40657-6) *[1]							BD	1
77	69-40657-7		. . SUPPORT (USED ON 69-40657-5)								1
77	69-40657-8		. . SUPPORT (USED ON 69-40657-6)								1
77	69-40657-11		. . SUPPORT (USED ON 69-40657-9)								1
77	69-40657-12		. . SUPPORT (USED ON 69-40657-10)								1
78	MS21209F4-20		. . INSERT, HELICAL COIL								3
79	BACN10JC6		. NUT (REPLS NAS679A6)								4
80	AN960PD616		. WASHER								4
81	BACB30DM6-5		. BOLT							CD	2
81	NAS1106-5		. BOLT (REPLS NAS1106-5W)							AB	2
82	BACB30DM6-7		. BOLT							CD	1
82	NAS1106-7		. BOLT (REPLS NAS1106-7W)							AB	1
83	BACB30DM6-6		. BOLT							CD	1
83	NAS1106-5		. BOLT (REPLS NAS1106-5W)							AB	1
84	69-40642-5		. WASHER, TORQUE TUBE STRAP								1
85	69-40642-6		. WASHER, TORQUE TUBE STRAP								1
86	BACN10JC6		. NUT (REPLS NAS679A6)								4
87	AN960PD616L		. WASHER								4
88	NAS1106-9		. BOLT (REPLS NAS1106-9W)								3
89	NAS1106-10		. BOLT (REPLS NAS1106-10W)								1
90	69-40658-1		. SUPPORT ASSY, GIMBAL SHAFT BEARING, LH								1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1107-90	69-40658-2		. SUPPORT ASSY, GIMBAL SHAFT BEARING, RH		1
91	69-40658-3		. . SUPPORT (USED ON 69-40658-1)		1
91	69-40658-4		. . SUPPORT (USED ON 69-40658-2)		1
92	66-23226-1		. . BUSHING		1
93	BACN10JC6		. NUT (REPLS NAS679A6)		4
94	AN960PD616		. WASHER		4
95	NAS1106-7		. BOLT (REPLS NAS1106-7W)		3
96	NAS1106-8		. BOLT (REPLS NAS1106-8W)		1
97	MS24665-153		. PIN, COTTER (REPLS AN381-2-10)		1
98	BACN10JD105		. NUT (REPLS AN320-5)		1
99	AN960PD516		. WASHER		1
100	NAS1105-12D		. BOLT (REPLS NAS1105-12DW)		1
101	69-40665-1		. FITTING, FAILSAFE, LH		1
101	69-40665-2		. FITTING, FAILSAFE, RH		1
102	69-39233-1		. PLATE		1
102	69-39233-3		. PLATE (OPT TO 69-39233-1)		1
103	MS24665-134		. PIN, COTTER (REPLS AN380-2-3)		1
104	BACN10JD105		. NUT (REPLS AN320-5)		1
105	AN960PD516		. WASHER		1
106	NAS1105-54D		. BOLT (REPLS NAS1105-54DW)		1
107	69-37206-6		. TUBE ASSY, FAILSAFE *[1]	A	1
107	69-37206-1		. TUBE ASSY, FAILSAFE *[1]	B	1
107	69-37206-8		. TUBE ASSY, FAILSAFE *[1]	AC	1
107	69-37206-7		. TUBE ASSY, FAILSAFE *[1]	BD	1
107	69-54984-2		. TUBE ASSY, FAILSAFE *[1]	AC	1
107	69-54984-1		. TUBE ASSY, FAILSAFE *[1]	BD	1
108	BACN10JC5		. NUT (REPLS NAS679A5)		6
109	AN960PD516L		. WASHER		6
110	NAS1105-6		. BOLT (REPLS NAS1105-6W)	AB	6
110	NAS1105-7		. BOLT (REPLS NAS1105-7W)	CD	6
111	66-23218-1		. SUPPORT, FAILSAFE	BD	1
111	66-23218-2		. SUPPORT, FAILSAFE	AC	1
112	BACN10JC5		. NUT (REPLS NAS679A5)		6
113	AN960PD516L		. WASHER		6
114	NAS1105-7		. BOLT (REPLS NAS1105-7W)		6
115	69-40642-3		. WASHER, TORQUE TUBE STRAP		1
116	69-40642-4		. WASHER, TORQUE TUBE STRAP		1
117	BACN10JC4		. NUT (REPLS NAS679A4)		6
118	AN960PD416L		. WASHER		12
119	NAS1104-4		. BOLT (REPLS NAS1104-4W)		6

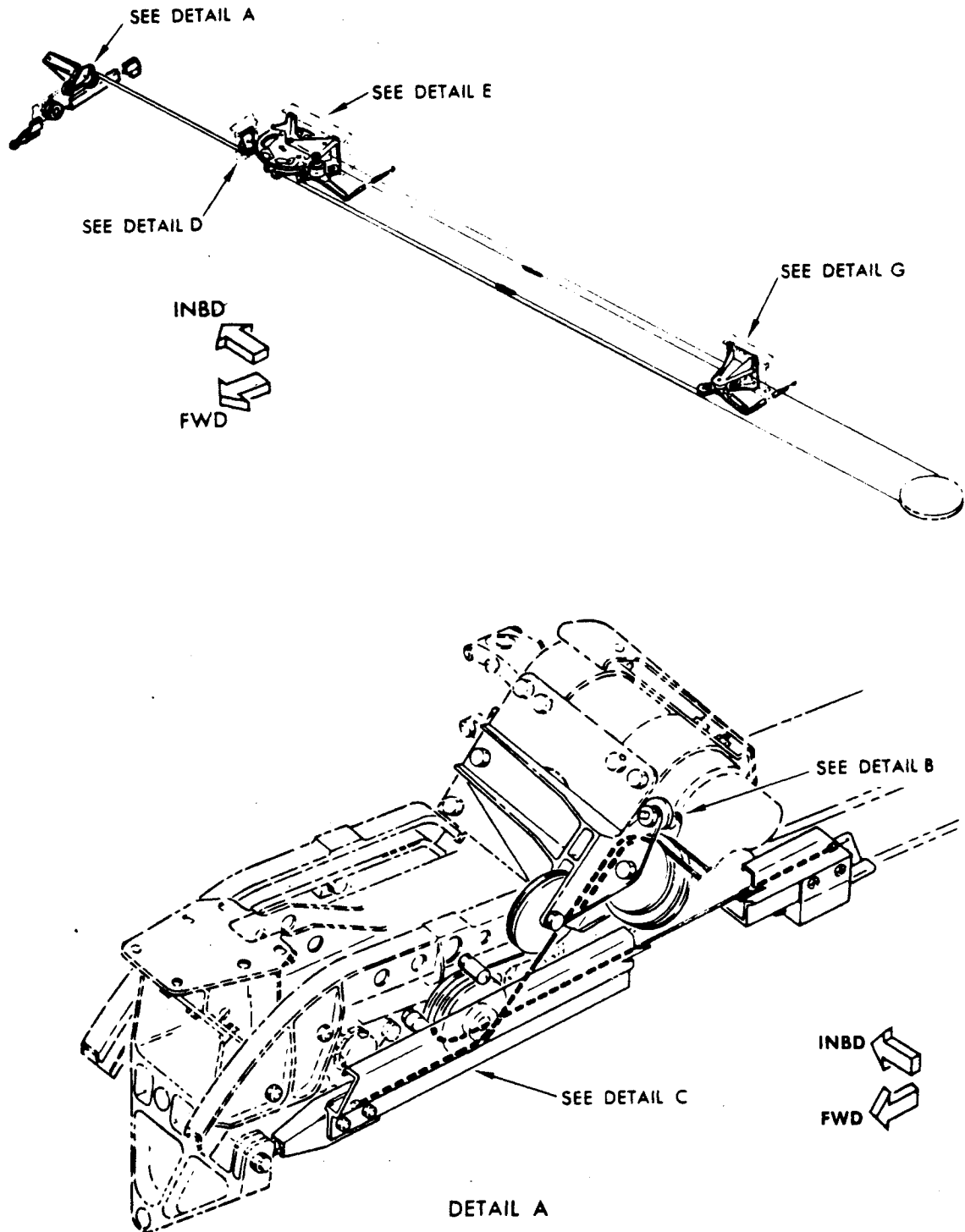
FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
1107-											
120	69-40642-1		.	WASHER,	TORQUE	TUBE	STRAP				1
121	69-40642-2		.	WASHER,	TORQUE	TUBE	STRAP				1
122	65-52211-2		.	TUBE,	TORQUE					AC	1
122	65-52211-1		.	TUBE,	TORQUE					BD	1
123	BACN10JC4		.	NUT (REPLS	NAS679A4)						6
124	AN960PD416		.	WASHER							6
125	NAS1104-4		.	BOLT (REPLS	NAS1104-4W)						6
126	66-23219-2		.	SUPPORT, TUBE	*[1]					A	1
126	66-23219-1		.	SUPPORT, TUBE	*[1]					B	1
126	66-23219-4		.	SUPPORT, TUBE	*[1]					AC	1
126	66-23219-3		.	SUPPORT, TUBE	*[1]					BD	1
126	66-23219-6		.	SUPPORT, TUBE						C	1
126	66-23219-5		.	SUPPORT, TUBE						D	1

*[1] LIMITED

*[2] USED ON CARRIAGE ASSEMBLIES WITH FAILSAFE BOLT LUG

65-46436
65-71940
65-71969

BOEING
COMMERCIAL JET
OVERHAUL MANUAL

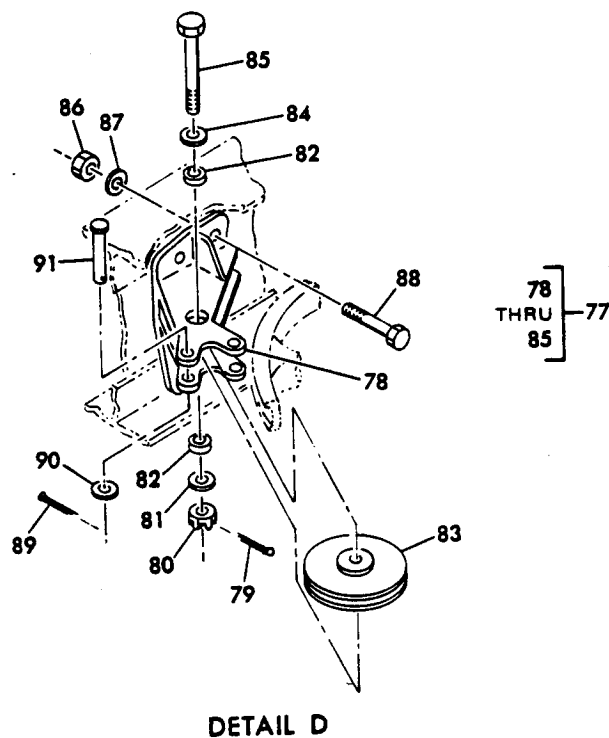


Jan 5/79

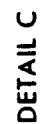
Aft Flap Actuating Mechanism
Figure 1108 (Sheet 1)

57-53-22
Page 1157

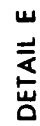
65-46436
65-71940
65-71969



Jun 10/71



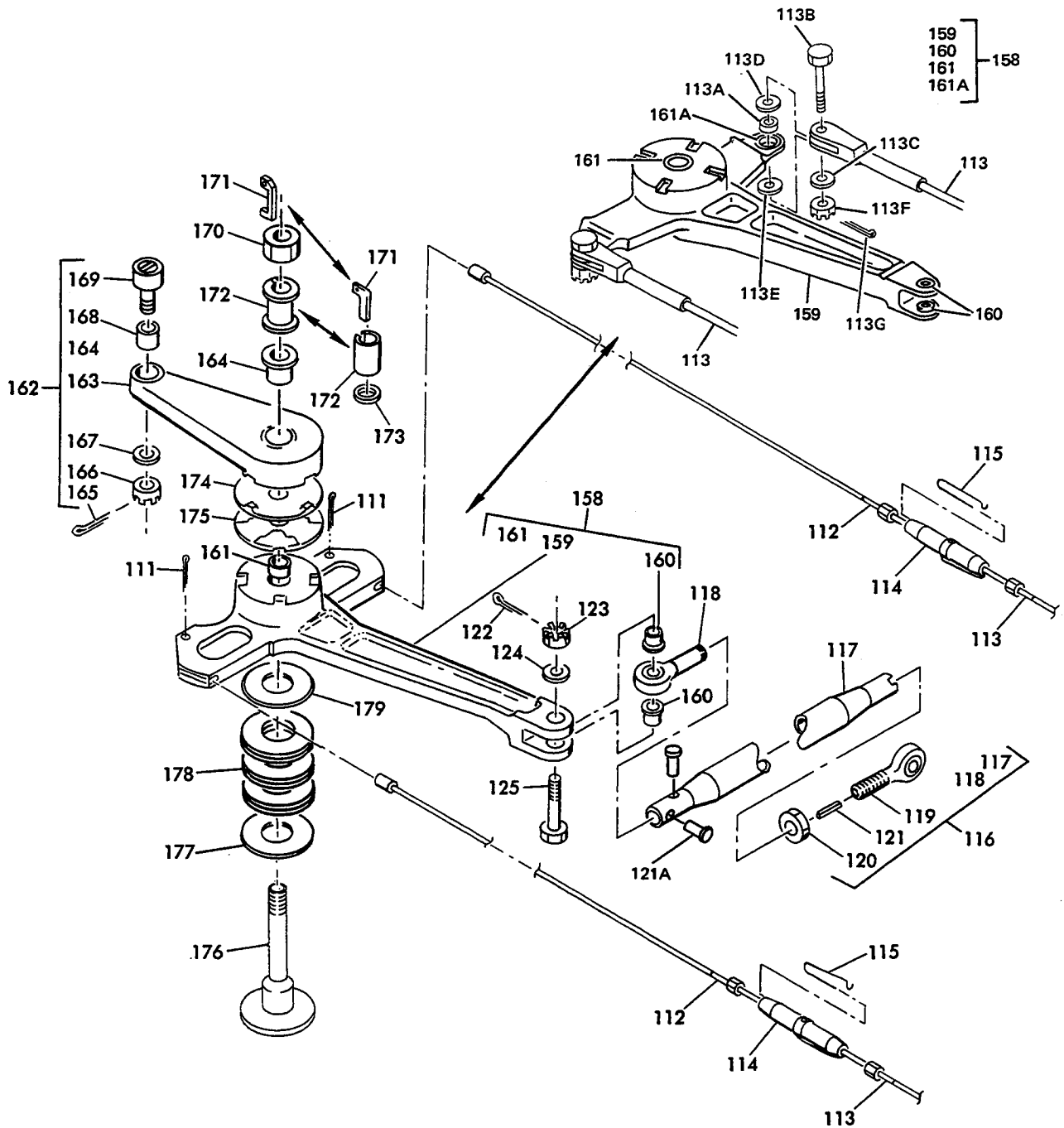
57-53-22
Page 1159



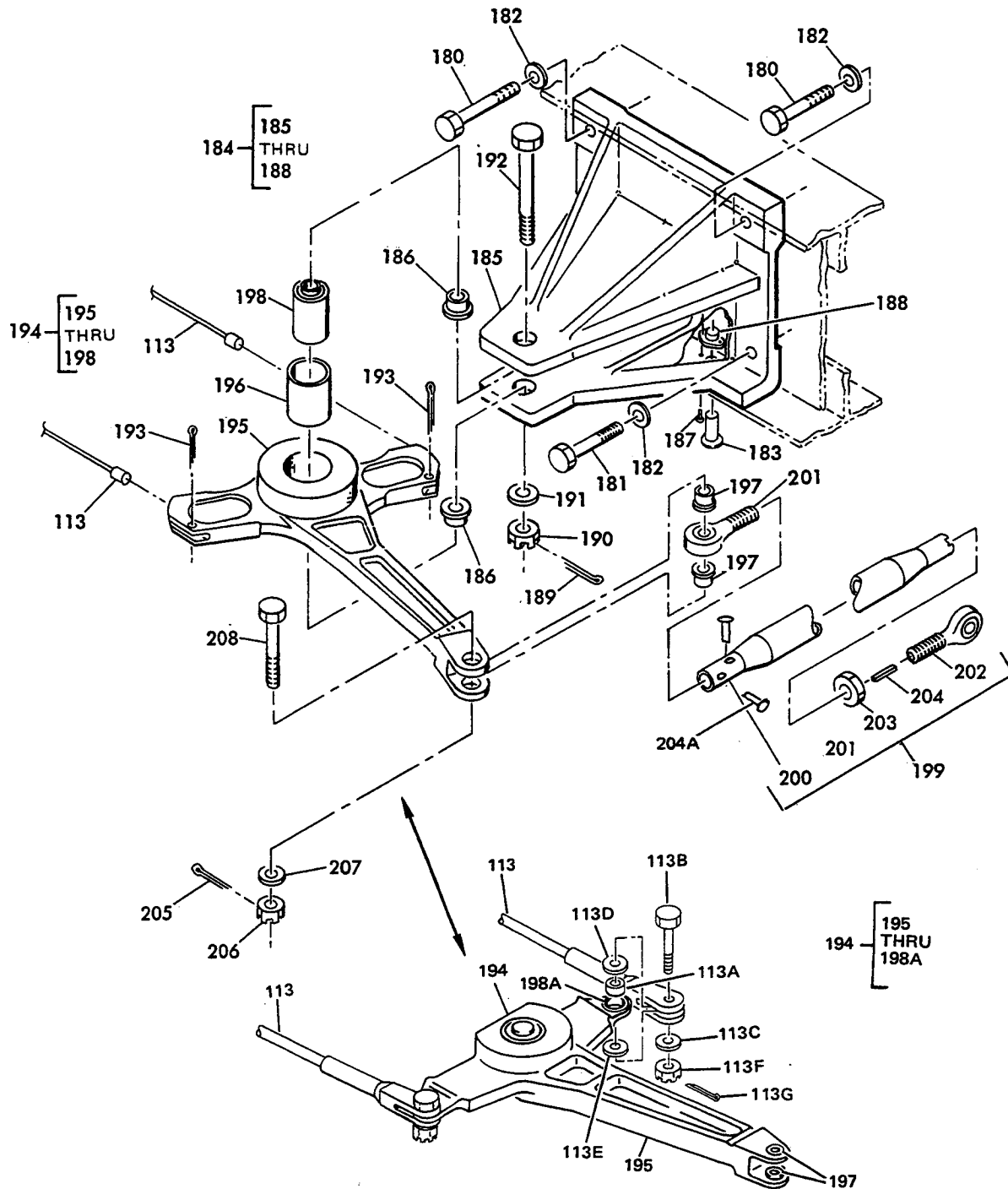
Jun 10/71

65-46436
65-71940
65-71969

BOEING
COMMERCIAL JET
OVERHAUL MANUAL



DETAIL F



DETAIL G

Inboard Aft Flap Drive Mechanism Installation
Figure 1108 (Sheet 6)

65-46436
65-71940
65-71969

BOEING
COMMERCIAL JET
OVERHAUL MANUAL

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	N O M E N C L A T U R E 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1108-	65-55540-1		DRIVE MECHANISM INSTL (LH)	A	RF
	65-55540-2		DRIVE MECHANISM INSTL (RH)	B	RF
	65-55540-20		DRIVE MECHANISM INSTL (RH)	C	RF
	65-55540-26		DRIVE MECHANISM INSTL (RH)	D	RF
	65-55540-28		DRIVE MECHANISM INSTL (RH)	E	RF
	65-55540-19		DRIVE MECHANISM INSTL (LH)	M	RF
	65-55540-25		DRIVE MECHANISM INSTL (LH)	N	RF
	65-55540-27		DRIVE MECHANISM INSTL (LH)	O	RF
1	BACN10JC5		. NUT (REPLS NAS679A5)		2
2	AN960PD516		. WASHER		2
3	NAS1105-8		. BOLT (REPLS NAS1105-8W)		2
4	MS24665-153		. PIN, COTTER (REPLS AN381-2-10 AND -12)		1
5	BACN10JD105		. NUT (REPLS AN320-5)		1
6	AN960PD516L		. WASHER		1
7	NAS1105-14D		. BOLT (REPLS NAS1105-14DW)		1
8	65-55549-1		. FITTING ASSY, LH	AM-O	1
8	65-55549-2		. FITTING ASSY, RH	BC-E	1
9	65-55549-3		. . FITTING (USED ON 65-55549-1)		1
9	65-55549-4		. . FITTING (USED ON 65-55549-2)		1
10	BACB28W4B12		. . BUSHING		4
11	69-43532-1		. PLATE, SERRATED		1
12	69-43532-2		. PLATE, SERRATED		1
13	MS24665-153		. PIN, COTTER (REPLS AN381-2-10 AND -12)		2
14	BACN10JD104		. NUT (REPLS AN320-4)		2
15	AN960PD416		. WASHER		2
16	BACB30LU4D7		. BOLT		2
17	BACB30NE4H10		. BOLT (REPLS NAS1304-10H)		1
18	BACW10BN4C		. WASHER (REPLS BACW10AKC4)		1
19	65-55513-7		. SUPPORT, PULLEY, LH (REPLS 65- 55513-1)	AM-O	1
19	65-55513-8		. SUPPORT, PULLEY, RH (REPLS 65- 55513-2)	BC-E	1
20	65-55540-7		. SHIM		1
21	69-42345-3		. GUARD, CABLE		1
22	BACN10JC3		. NUT (REPLS NAS679A3W)		1
23	NAS1103-19		. BOLT (REPLS NAS1103-19W)		1
24	MS20219-4		. PULLEY		1
25	10-61351-1		. PULLEY	ABCM	1
26	MS24665-153		. PIN, COTTER (REPLS AN381-2-10 AND -12)		1
27	BACN10JD104		. NUT (REPLS AN320-4)		1
28	AN960-416		. WASHER		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	N O M E N C L A T U R E 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1108-					
29	NAS1104-19D		. BOLT (REPLS NAS1104-19DW)		1
30	MS24665-153		. PIN, COTTER (REPLS AN381-2-10 AND -12)		1
31	BACN10JD104		. NUT (REPLS AN320-4)		1
32	AN960-416		. WASHER		1
33	MS20219-4		. PULLEY		1
34	NAS1104-12D		. BOLT (REPLS NAS1104-12DW)		1
35	BACN10JC3		. NUT (REPLS NAS679A3W)		1
36	AN960PD10		. WASHER		1
37	NAS43HT3-32		. SPACER (REPLS NAS43HT3-32A)		1
38	BACB30LU3-8		. BOLT (REPLS BACB30FL3-8)		1
39	BACN10JC3		. NUT (REPLS NAS679A3W)		1
40	AN960PD10		. WASHER		1
41	NAS43HT3-51		. SPACER (REPLS NAS43HT3-51A)		1
42	BACB30LU3-13		. BOLT (REPLS BACB30FL3-13)		1
43	BACN10JC3		. NUT (REPLS NAS679A3W)		1
44	AN960PD10		. WASHER		1
45	NAS43HT3-45		. SPACER (REPLS NAS43HT3-45A)		1
46	NAS623-3-17		. SCREW (REPLS NAS623-3-17W)		1
47	7219-12		. PULLEY, V12210	ABCM	2
48	MS24665-153		. PIN, COTTER (REPLS AN381-2-10 AND -12)		1
49	CF2057		. FOLLOWER, CAM, V92563 (PRFD)		1
49	CC39009		. FOLLOWER, CAM, V60380 (OPT TO CF2057)		1
50	MS24665-153		. PIN, COTTER (REPLS AN381-2-10 AND -12)		1
51	65-55541-3		. BOOM ASSY, LH *[1]	A	1
51	65-55541-4		. BOOM ASSY, RH *[1]	B	1
51	65-55541-5		. BOOM ASSY, LH (OPT TO 65-55591-3) *[1]	A	1
51	65-55541-7		. BOOM ASSY, LH (OPT TO 65-55541-5 OR -3)	A	1
51	65-55541-7		. BOOM ASSY, LH	MN	1
51	65-55541-9		. BOOM ASSY, LH (REPLS 65-55541-7)	N	1
51	65-55541-11		. BOOM ASSY, LH (SB 27-1110)	O	1
51	65-55541-6		. BOOM ASSY, RH (OPT TO 65-55541-4) *[1]	B	1
51	65-55541-8		. BOOM ASSY, RH (OPT TO 65-55541-6 OR -4)	B	1
51	65-55541-8		. BOOM ASSY, RH	CD	1
51	65-55541-10		. BOOM ASSY, RH (REPLS 65-55541-8)	D	1
51	65-55541-12		. BOOM ASSY, RH (SB 27-1110)	E	1

65-46436
65-71940
65-71969

BOEING
COMMERCIAL JET
OVERHAUL MANUAL

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	N O M E N C L A T U R E 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1108-52	69-42349-3		. . BOOM (USED ON 65-55541-3, -5, -7, -9, -11)		1
52	69-42349-4		. . BOOM (USED ON 65-55541-4, -6, -8, -10, -12)		1
53	69-43572-1		. . FITTING, END (USED ON 65-55541-3 THRU -8)		1
53	69-43572-3		. . FITTING, END (USED ON 65-55541-9 THRU -12)		1
54	69-42346-1		. . FITTING ASSY (USED ON 65-55541-3 AND -5)		1
54	69-42346-5		. . FITTING ASSY (USED ON 65-55541-7)		1
54	69-42346-9		. . FITTING ASSY (USED ON 65-55541-9, -11)		1
54	69-42346-2		. . FITTING ASSY (USED ON 65-55541-4 AND -6)		1
54	69-42346-6		. . FITTING, ASSY (USED ON 65-55541-8)		1
54	69-42346-10		. . FITTING ASSY (USED ON 65-55541-10, -12)		1
55	69-42346-3		. . . FITTING (USED ON 69-42346-1)		1
55	69-42346-4		. . . FITTING (USED ON 69-42346-2)		1
55	69-42346-7		. . . FITTING (USED ON 69-42346-5)		1
55	69-42346-8		. . . FITTING (USED ON 69-42346-6)		1
55	69-42346-11		. . . FITTING (USED ON 69-42346-9)		1
55	69-42346-12		. . . FITTING (USED ON 69-42346-10)		1
56	BACB28U3B15		. . . BUSHING (USED ON 69-42346-1, -2, -5, -6)		1
56	BACB28W4B015		. . . BUSHING (USED ON 69-42346-9, -10)		1
57	BACB28U5B15		. . . BUSHING (USED ON 69-42346-1, -2, -5, -6)		1
57	BACB28W6B015		. . . BUSHING (USED ON 69-42346-9, -10)		1
58	BACN10JC3		. . NUT (REPLS NAS679A3W) (USED ON 65-55541-3 THRU -8)		4
58	BACN10GW3		. . NUT (USED ON 65-55541-9 THRU -12)		4
59	AN960PD10L		. . WASHER		2
60	BACW10BH3		. . WASHER (USED ON 65-55541-3 THRU -8)		1
60	BACW10CT6C		. . WASHER (USED ON 65-55541-9 THRU -12)		2
61	AN960PD10		. . WASHER (USED ON 65-55541-3 THRU -8)		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	N O M E N C L A T U R E 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1108-62	NAS1503-5		. . BOLT		2
63	BACB30LU3-4		. . BOLT (REPLS BACB30FL3-4)		2
64	NAS509-5		. . NUT (USED ON 65-55541-3 THRU -8)		1
64	NAS509-6C		. . NUT (USED ON 65-55541-9 THRU -12)		1
65	AN960PD516		. . WASHER (USED ON 65-55541-3 THRU -8)		1
65	BACW10CT12C		. . WASHER (USED ON 65-55541-9 THRU -12)		1
65A	NAS43DD6-33		. . SPACER (USED ON 65-55541-9 THRU -12)		1
66	DREM4-344		. . BEARING, ROD END, V81376 (BOEING 10-60779-126) (PRFD)		1
66	REM8ATC8-3		. . BEARING, ROD END, V21335 (BOEING 10-60779-126) (PRFD)		1
66	77519		. . BEARING, ROD END, V09455 (BOEING 10-60779-126) (PRFD)		1
66	DREM4-181		. . BEARING, ROD END, V81376 (BOEING 10-60779-122) *[4]		1
66	REM8ATC8		. . BEARING, ROD END, V21335 (BOEING 10-60779-122) *[4]		1
66	YFM4E		. . BEARING, ROD END, V77896 (BOEING 10-60779-122) *[4]		1
66	177014		. . BEARING, ROD END, V09455 (BOEING 10-60779-122) *[4]		1
67	NAS509-4		. . NUT		1
68	AN960PD416L		. . WASHER		1
69	69-42347-1		. . SCREW		1
70	69-42343-1		. . FITTING ASSY (USED ON 65-55541-3)		1
70	69-42343-2		. . FITTING ASSY (USED ON 65-55541-4)		1
70	69-42343-5		. . FITTING ASSY (USED ON 65-55541-5, -7, -9)		1
70	69-42343-6		. . FITTING ASSY (USED ON 65-55541-6, -8, -10)		1
70	69-42343-9		. . FITTING ASSY (USED ON 65-55541-11) (SB 27-1110)		1
70	69-42343-10		. . FITTING ASSY (USED ON 65-55541-12) (SB 27-1110)		1
70A	69-42343-3		. . . FITTING (USED ON 69-42343-1)		1
70A	69-42343-4		. . . FITTING (USED ON 69-42343-2)		1
70A	69-42343-7		. . . FITTING (USED ON 69-42343-5)		1

65-46436
65-71940
65-71969

BOEING
COMMERCIAL JET
OVERHAUL MANUAL

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	N O M E N C L A T U R E 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1108-70A	69-42343-8		. . . FITTING (USED ON 69-42343-6)		1
70A	69-42343-11		. . . FITTING (USED ON 69-42343-9)		1
70A	69-42343-12		. . . FITTING (USED ON 69-42343-10)		1
70B	MS21209F4-15		. . . INSERT, HELICAL COIL		1
71	BACN10JC3		. . NUT (REPLS NAS679A3W)		2
72	AN960PD10		. . WASHER		2
73	NAS1103-4		. . BOLT (REPLS NAS1103-4W) (USED ON 65-55541-3 THRU -8)		2
73	BACB30NF3-4		. . BOLT (USED ON 65-55541-9 THRU -12)		2
74	NAS509-4		. . NUT		1
75	AN960PD416L		. . WASHER		1
76	BACB28Y4C22		. . BUSHING		1
77	65-55547-1		. BRACKET ASSY, PULLEY, LH	AM	1
77	65-55547-9		. BRKT ASSY, PULLEY, LH *[5]	A M-O	1
77	65-55547-2		. BRACKET ASSY, PULLEY, RH	BC	1
77	65-55547-10		. BRKT ASSY, PULLEY, RH *[6]	B-E	1
78	65-55547-3		. . BRACKET (USED ON 65-55547-1, -9)		1
78	65-55547-4		. . BRACKET (USED ON 65-55547-2, -10)		1
79	MS24665-134		. . PIN, COTTER (REPLS AN380-2-3)		1
80	BACN10JD4		. . NUT (REPLS AN310-4)		1
81	AN960PD416		. . WASHER		1
82	BACB28W4B20		. . BUSHING		2
83	BACP30J4		. . PULLEY	DN	1
83	BACP30F4A		. . PULLEY (OPT TO MS20219-4)	ABCM	1
83	MS20219-4		. . PULLEY	ABCM	1
84	MS20002C4		. . WASHER		1
85	BACB30NE4D16		. . BOLT (REPLS NAS1304-16DW)		1
86	BACN10JC3		. NUT (REPLS NAS679A3W)		3
87	AN960PD10L		. WASHER		3
88	NAS1103-5		. BOLT (REPLS NAS1103-5W)		3
89	MS24665-134		. PIN, COTTER (REPLS AN380-2-3)		2
90	AN960PD10L		. WASHER		2
91	MS20392-2C29		. PIN, STRAIGHT (REPLS MS20392-229)		2
92	MS20004-16		. BOLT		1
92	BACB30FD4-16		. BOLT (OPT TO MS20004-16)		1
93	MS20004-14		. BOLT		3
93	BACB30FD4-14		. BOLT (OPT TO MS20004-14)		3
94	BACW10BP4C		. WASHER (REPLS BACW10BJ4C)		4
95	BACN10JC3		. NUT (REPLS NAS679A3W)		2
96	AN960PD10L		. WASHER		4
97	NAS42DD6-50		. SPACER (REPLS NAS42DD6-50A)		2
98	NAS1103-17		. BOLT (REPLS NAS1103-17W)		2

65-46436
65-71940
65-71969

BOEING
COMMERCIAL JET
OVERHAUL MANUAL

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	N O M E N C L A T U R E							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
1108-											
99	NAS1103-7		.	BOLT	(REPLS	NAS1103-7W)					2
100	AN960PD10		.	WASHER							2
101	69-44940-1		.	BRACKET, GUARD							1
102	BACN10JC3		.	NUT (REPLS	NAS679A3W)						2
103	AN960PD10L		.	WASHER							4
104	NAS42DD6-89		.	SPACER (REPLS	NAS42DD6-89A)						2
105	NAS1103-27		.	BOLT (REPLS	NAS1103-27W)						2
106	BACN10JC3		.	NUT (REPLS	NAS679A3W)						1
107	BACW10CP3		.	WASHER (REPLS	AN970-3)						1
108	BACB30LU3-9		.	SCREW (REPLS	NAS517-3-9)						1
109	69-43531-15		.	CABLE ASSY *[1]						AB	2
109	69-43531-26		.	CABLE ASSY						CDEMN	1
										O	
109	69-43531-26		.	CABLE ASSY (OPT TO	69-43531-22)					AB	1
109	69-43531-22		.	CABLE ASSY *[1]						AB	1
109	69-43531-16		.	CABLE ASSY *[1]						AB	1
110	69-43531-25		.	CABLE ASSY						CDEMN	1
										O	
110	69-43531-25		.	CABLE ASSY (OPT TO	69-43531-21)					AB	1
110	69-43531-21		.	CABLE ASSY *[1]						AB	1
110	69-43531-17		.	CABLE ASSY *[1]						AB	1
111	MS24665-153		.	PIN, COTTER						AB	4
112	69-43531-33		.	CABLE ASSY						CDMN	2
112	69-43531-33		.	CABLE ASSY *[1]						EO	2
112	69-43531-37		.	CABLE ASSY *[1]						EO	2
112	69-43531-27		.	CABLE ASSY (OPT TO	69-43531-4)					AB	2
112	69-43531-4		.	CABLE ASSY						AB	2
113	69-43531-34		.	CABLE ASSY						CDMN	2
113	69-43531-34		.	CABLE ASSY *[1]						EO	2
113	69-43531-38		.	CABLE ASSY *[1]						EO	2
113	69-43531-28		.	CABLE ASSY (OPT TO	69-43531-5)					AB	2
113	69-43531-5		.	CABLE ASSY						AB	2
113A	65-55540-23		.	SPACER						C-E	4
										M-O	
113B	BACB30LM3DU7		.	BOLT						C-E	4
										M-O	
113C	AN960XC10		.	WASHER, CRES, .063						C-E	AR
										M-O	
113D	AN960XC10L		.	WASHER, CRES, .016						C-E	AR
										M-O	
113E	BACW10P3C		.	WASHER, CRES, .020						C-E	AR
										M-O	
113F	BACN10JD3		.	NUT						C-E	4
										M-O	

BOEING
COMMERCIAL JET
OVERHAUL MANUAL

65-46436
65-71940
65-71969

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	N O M E N C L A T U R E 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1108- 113G	MS24665-134		. COTTER PIN	C-E M-O	4
114	MS21251-5S		. TURNBUCKLE		2
115	BACC15AJ1		. CLIP (REPLS BACC15AJ16S)		4
116	69-43599-1		. PUSHROD ASSY		1
117	69-43599-3		. . TUBE		1
118	DREM4-296		. . BEARING, ROD END, V81376 (BOEING 10-60779-4)		1
118	YTP103		. . BEARING, ROD END, V77896 (BOEING 10-60779-4)		1
118	177147		. . BEARING, ROD END, V09455 (BOEING 10-60779-4)		1
119	DREM4-299		. . BEARING, ROD END, V81376 (BOEING 10-60779-178)		1
119	REMS8ATC10-7		. . BEARING, ROD END, V21335 (BOEING 10-60779-178)		1
119	YTM124R		. . BEARING, ROD END, V77896 (BOEING 10-60779-178)		1
119	177162		. . BEARING, ROD END, V09455 (BOEING 10-60779-178)		1
120	69-43564-1		. . NUT		1
121	69-43564-2		. . KEY		1
121A	MS20427M5		. . RIVET, MONEL		2
122	MS24665-153		. PIN, COTTER (REPLS AN381-2-10 AND -12)		1
123	BACN10JD104AU		. NUT (REPLS AN320C4)		1
124	AN960PD416		. WASHER		1
125	BACB30LJ4DHU 12		. BOLT		1
126	65-55540-3		. DRIVE MECHANISM ASSY, INBD AFT FLAP, LH *[1]	A	1
126	65-55540-11		. DRIVE MECHANISM ASSY, INBD AFT FLAP, LH *[1]	A	1
126	65-55540-13		. DRIVE MECHANISM ASSY, INBD AFT FLAP, LH (SB 27-1030)	A	1
126	65-55540-17		. DRIVE MECHANISM ASSY, INBD AFT FLAP, LH	A	1
126	65-55540-4		. DRIVE MECHANISM ASSY, INBD AFT FLAP, RH *[1]	B	1
126	65-55540-12		. DRIVE MECHANISM ASSY, INBD AFT FLAP, RH *[1]	B	1
126	65-55540-14		. DRIVE MECHANISM ASSY, INBD AFT FLAP, RH (SB 27-1030)	B	1

65-46436
65-71940
65-71969

 BOEING
OVERHAUL MANUAL

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
1108-126	65-55540-18		.	.	.	.	.	.	.	A	1
			.	.	.	.	.	.	.		
126	65-55540-21		.	.	.	.	.	.	.	MNO	1
126	65-55540-22		.	.	.	.	.	.	.	CDE	1
127	MS24665-153		.	.	.	.	.	.	.		1
			.	.	.	.	.	.	.		
128	BACN10JD105AU		.	.	.	.	.	.	.		1
129	AN960PD516		.	.	.	.	.	.	.		AR
130	AN960PD10L		.	.	.	.	.	.	.		AR
131	MS20002C5		.	.	.	.	.	.	.		1
132	BACB30LJ5DU59		.	.	.	.	.	.	.		1
133	BACN10JC3		.	.	.	.	.	.	.		5
134	BACW10AKWC3		.	.	.	.	.	.	.		5
135	NAS1103-15		.	.	.	.	.	.	.		5
136	65-55550-5		.	.	.	.	.	.	.	AMNO	1
136	65-55550-6		.	.	.	.	.	.	.	BCDE	1
137	65-55550-3		.	.	.	.	.	.	.		1
137	65-55550-4		.	.	.	.	.	.	.		1
138	BACB28W5B56		.	.	.	.	.	.	.		2
139	69-57808-1		.	.	.	.	.	.	.		1
140	69-57808-2		.	.	.	.	.	.	.		1
141	BACB28W5B50		.	.	.	.	.	.	.		1
142	MS24665-153		.	.	.	.	.	.	.		1
			.	.	.	.	.	.	.		
143	BACN10JD105		.	.	.	.	.	.	.		1
144	AN960PD516		.	.	.	.	.	.	.		AR
145	AN960PD516L		.	.	.	.	.	.	.		AR
146	MS20002C5		.	.	.	.	.	.	.		1
147	BACB30LJ5DU63		.	.	.	.	.	.	.		1
148	65-55554-23		.	.	.	.	.	.	.	AMNO	1
			.	.	.	.	.	.	.		
148	69-59832-5		.	.	.	.	.	.	.	AMNO	1
			.	.	.	.	.	.	.		
148	65-55554-24		.	.	.	.	.	.	.	BCDE	1
			.	.	.	.	.	.	.		
148	69-59832-6		.	.	.	.	.	.	.	BCDE	1
			.	.	.	.	.	.	.		
149	65-55554-27		.	.	.	.	.	.	.		1
			.	.	.	.	.	.	.		
149	69-59832-11		.	.	.	.	.	.	.		1
			.	.	.	.	.	.	.		
149	65-55554-28		.	.	.	.	.	.	.		1
			.	.	.	.	.	.	.		
149	69-59832-12		.	.	.	.	.	.	.		1
			.	.	.	.	.	.	.		
150	65-55554-29		.	.	.	.	.	.	.		4
			.	.	.	.	.	.	.		



OVERHAUL MANUAL

65-46436

65-71940

65-71969

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	N O M E N C L A T U R E							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
1108 150	69-59832-13		.	.	.	.	.	.	BEARING ASSY (USED ON 69-59832-11 AND -12)		4
151	BACB10A683		.	.	.	.	.	.	BEARING		1
152	69-59831-1		.	.	.	.	.	.	BUSHING		1
153	BACR15BA3B		.	.	.	.	.	.	RIVET (REPLS MS20426B3)		4
154	BACN10JN3		.	.	.	.	.	.	NUT/PLATE (REPLS NAS1068A3)		2
155	BACB30FD3H2		.	.	.	.	.	.	BOLT		2
156	BACW10BP3C		.	.	.	.	.	.	WASHER		2
157	69-54968-1		.	.	.	.	.	.	STOP, CAM ARM, LH		1
157	69-54968-2		.	.	.	.	.	.	STOP, CAM ARM, RH		1
158	65-55551-1		.	.	.	.	.	.	BELLCRANK ASSY, LH (USED ON 65-55540-11) *[1]		1
158	65-55551-9		.	.	.	.	.	.	BELLCRANK ASSY, LH (USED ON 65-55540-13) *[1]		1
158	65-55551-2		.	.	.	.	.	.	BELLCRANK ASSY, RH (USED ON 65-55540-12) *[1]		1
158	65-55551-10		.	.	.	.	.	.	BELLCRANK ASSY, RH (USED ON 65-55540-14) *[1]		1
158	65-55551-11		.	.	.	.	.	.	BELLCRANK ASSY, LH (USED ON 65-55540-13) (OPT TO 65-55551-9)		1
158	65-55551-12		.	.	.	.	.	.	BELLCRANK ASSY, RH (USED ON 65-55540-14) (OPT TO 65-55551-10)		1
158	65-55551-11		.	.	.	.	.	.	BELLCRANK ASSY, LH (USED ON 65-55540-17)		1
158	65-55551-12		.	.	.	.	.	.	BELLCRANK ASSY, RH (USED ON 65-55540-18)		1
158	65-55551-15		.	.	.	.	.	.	BELLCRANK ASSY (USED ON 65-55540-21)		1
158	65-55551-16		.	.	.	.	.	.	BELLCRANK ASSY (USED ON 65-55540-22)		1
159	65-55551-5		.	.	.	.	.	.	BELLCRANK (USED ON 65-55551-1)		1
159	65-55551-6		.	.	.	.	.	.	BELLCRANK (USED ON 65-55551-2)		1
159	65-55551-7		.	.	.	.	.	.	BELLCRANK (USED ON 65-55551-9)		1
159	65-55551-8		.	.	.	.	.	.	BELLCRANK (USED ON 65-55551-10)		1
159	65-55551-13		.	.	.	.	.	.	BELLCRANK (USED ON 65-55551-11)		1
159	65-55551-14		.	.	.	.	.	.	BELLCRANK (USED ON 65-55551-12)		1
159	65-55551-17		.	.	.	.	.	.	BELLCRANK (USED ON 65-55551-15)		1
159	65-55551-18		.	.	.	.	.	.	BELLCRANK (USED ON 65-55551-16)		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
1108-160	BACB28W4B9		.	.	.	BUSHING					2
161	BACB28U8B50		.	.	.	BUSHING					1
161A	BACB28U5B18		.	.	.	BUSHING (USED ON 65-55551-15, -16)					1
162	65-55588-1		.	.	.	ARM ASSY, CAM *[1]					1
162	65-55588-5		.	.	.	ARM ASSY, CAM (USED ON 65-55540-13 AND -14)(OPT)					1
162	65-55588-8		.	.	.	ARM ASSY, CAM (USED ON 65-55540-17,-18,-21,-22)					1
163	65-55588-4		.	.	.	ARM, CAM (USED ON 65-55588-1)					1
163	65-55588-6		.	.	.	ARM, CAM (USED ON 65-55588-5,-8)					1
164	BACB28W8B58		.	.	.	BUSHING					1
165	MS24665-285		.	.	.	PIN, COTTER (REPLS AN380-3-4)					1
166	BACN10JD106		.	.	.	NUT (REPLS AN320-6)					1
166	AN316-6R		.	.	.	NUT (USED ON 65-55588-8)					1
167	AN960PD616L		.	.	.	WASHER					1
167	MS27111-3		.	.	.	WASHER, KEY (USED ON 65-55588-8)					1
168	BACB28U6B52		.	.	.	BUSHING					1
169	BACB10AF6F8HS		.	.	.	BEARING					1
169	BACB10B196-7		.	.	.	BEARING (USED ON 65-55588-1) (OPT TO BACB10AF6F8HS)					1
169	BACB10AF6K8HS		.	.	.	BEARING (USED ON 65-55588-8)					1
170	69-43564-3		.	.	.	NUT					1
171	69-43564-5		.	.	.	LOCK (USED ON 65-55540-13,-14,-17, -18,-21,-22)(SB 27-1030)					1
171	69-43564-4		.	.	.	LOCK (USED ON 65-55540-11,-12)					1
172	69-42384-2		.	.	.	SPACER (USED ON 65-55540-13,-14, -17,-18,-21,-22)(SB 27-1030)					1
172	69-42384-1		.	.	.	SPACER (USED ON 65-55540-11,-12)					1
173	DU154		.	.	.	WASHER (PREF)(SB 27-1030) *[2]					1
173	DU06		.	.	.	WASHER (OPT TO DU154) *[2]					1
174	69-46451-1		.	.	.	DISK, CLUTCH					1
175	69-44994-2		.	.	.	DISK, CLUTCH					1
175	69-44994-1		.	.	.	DISK, CLUTCH (OPT)					1
176	69-42386-2		.	.	.	SHAFT (USED ON 65-55540-13,-14, -17,-18,-21,-22)(SB 27-1030)					1
176	69-42386-1		.	.	.	SHAFT (USED ON 65-55540-11,-12)					1

OVERHAUL MANUAL

65-46436
65-71940
65-71969

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	N O M E N C L A T U R E 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1108-					
177	69-44965-1		. . WASHER		1
178	69-42385-2		. . WASHER, BELLEVILLE (PREF)		6
178	69-42385-1		. . WASHER, BELLEVILLE		6
179	NAS549ML1416		. . WASHER, FIBER		1
180	NAS1104-10		. . BOLT (REPLS NAS1104-10W)		2
181	NAS1104-8		. . BOLT (REPLS NAS1104-8W)		2
182	AN960PD416		. . WASHER		4
183	BACB30LU3-5		. . BOLT (REPLS BACB30FL3-5)		3
184	65-49548-1		. . BRACKET ASSY		1
185	65-49548-2		. . . BRACKET		1
186	BACB28W5B20		. . . BUSHING		2
187	BACR15BA3D		. . . RIVET (REPLS MS20426B3)		6
188	BACN10JN3		. . . NUTPLATE (REPLS NAS1068A3)		3
189	MS24665-153		. PIN, COTTER (REPLS AN381-2-10 AND -12)		1
190	BACN10JD105		. NUT (REPLS AN320C5)		1
191	AN960PD416		. WASHER		1
192	BACB30LJ5DU24		. BOLT		1
193	MS24665-153		. PIN, COTTER (REPLS AN381-2-10 AND -12)	AB	2
194	65-55552-1		. BELLCRANK ASSY	AB	1
194	65-55552-4		. BELLCRANK ASSY (OPT)	AB	1
194	65-55552-6		. BELLCRANK ASSY	CDEMN O	1
195	65-55552-2		. . BELLCRANK (USED ON 65-55552-1)		1
195	65-55552-5		. . BELLCRANK (USED ON 65-55552-4)		1
195	65-55552-7		. . BELLCRANK (USED ON 65-55552-6)		1
196	65-55552-3		. . SLEEVE, SPLIT		1
197	BACB28W4B9		. . BUSHING		2
198	BACB10A660		. . BEARING		1
198A	BACB28U5B18		. . BUSHING (USED ON 65-55552-6)		2
199	69-43599-1		. PUSHROD ASSY		1
200	69-43599-3		. . TUBE		1
201	DREM4-296		. . BEARING, ROD END, V81376 (BOEING 10-60779-4)		1
201	YTP103		. . BEARING, ROD END, V77896 (BOEING 10-60779-4)		1
201	177147		. . BEARING, ROD END, V09455 (BOEING 10-60779-4)		1
202	DREM4-299		. . BEARING, ROD END, V81376 (BOEING 10-60779-178)		1
202	REMS8ATC10-7		. . BEARING, ROD END, V21335 (BOEING 10-60779-178)		1
202	YTM124R		. . BEARING, ROD END, V77896 (BOEING 10-60779-178)		1

65-46436
65-71940
65-71969

BOEING
COMMERCIAL JET
OVERHAUL MANUAL

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	N O M E N C L A T U R E 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1108- 202	177162		. . BEARING, ROD END, V09455 (BOEING 10-60779-178)		1
203	69-43564-1		. . NUT		1
204	69-43564-2		. . KEY		1
204A	MS20427M5		. . RIVET, MONEL		2
205	MS24665-153		. PIN, COTTER (REPLS AN381-2-10 AND -12)		1
206	BACN10JD104		. NUT (REPLS AN320C4)		1
207	AN960PD416		. WASHER		1
208	BACB30LJ4DHU 12		. BOLT		1

*[1] LIMITED USAGE

*[2] BEARING SALES & SERVICE DIVISION OF BEARING INC., 4021 - 16TH AVE. SO.,
SEATTLE, WASHINGTON 98108 (NO VENDOR CODE NUMBER ASSIGNED)

*[3] DELETED

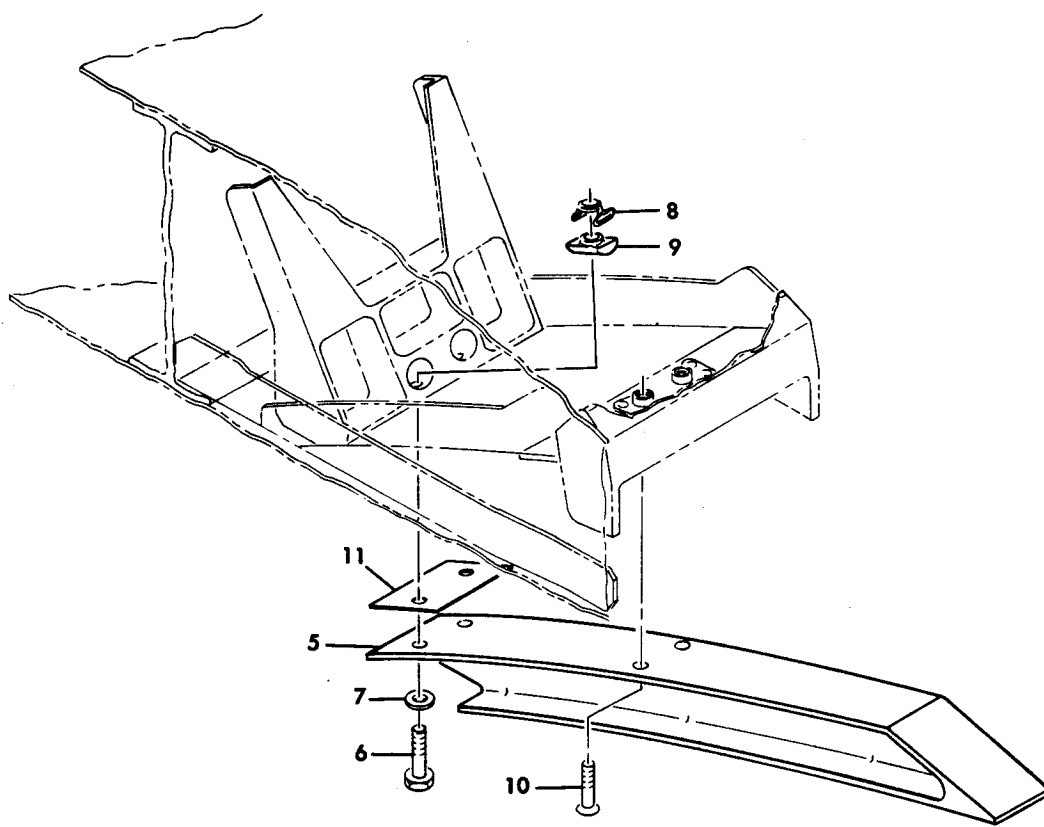
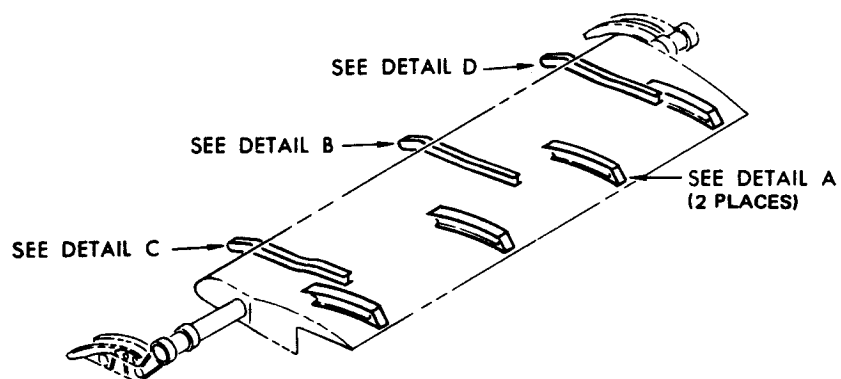
*[4] OPTIONAL ON 65-55541-3, -4

*[5] OPTIONAL TO 65-55547-1 ON 65-55540-1, -19

*[6] OPTIONAL TO 65-55547-2 ON 65-55540-2, -20

BOEING
COMMERCIAL JET
OVERHAUL MANUAL

65-46436
 65-71940
 65-71969

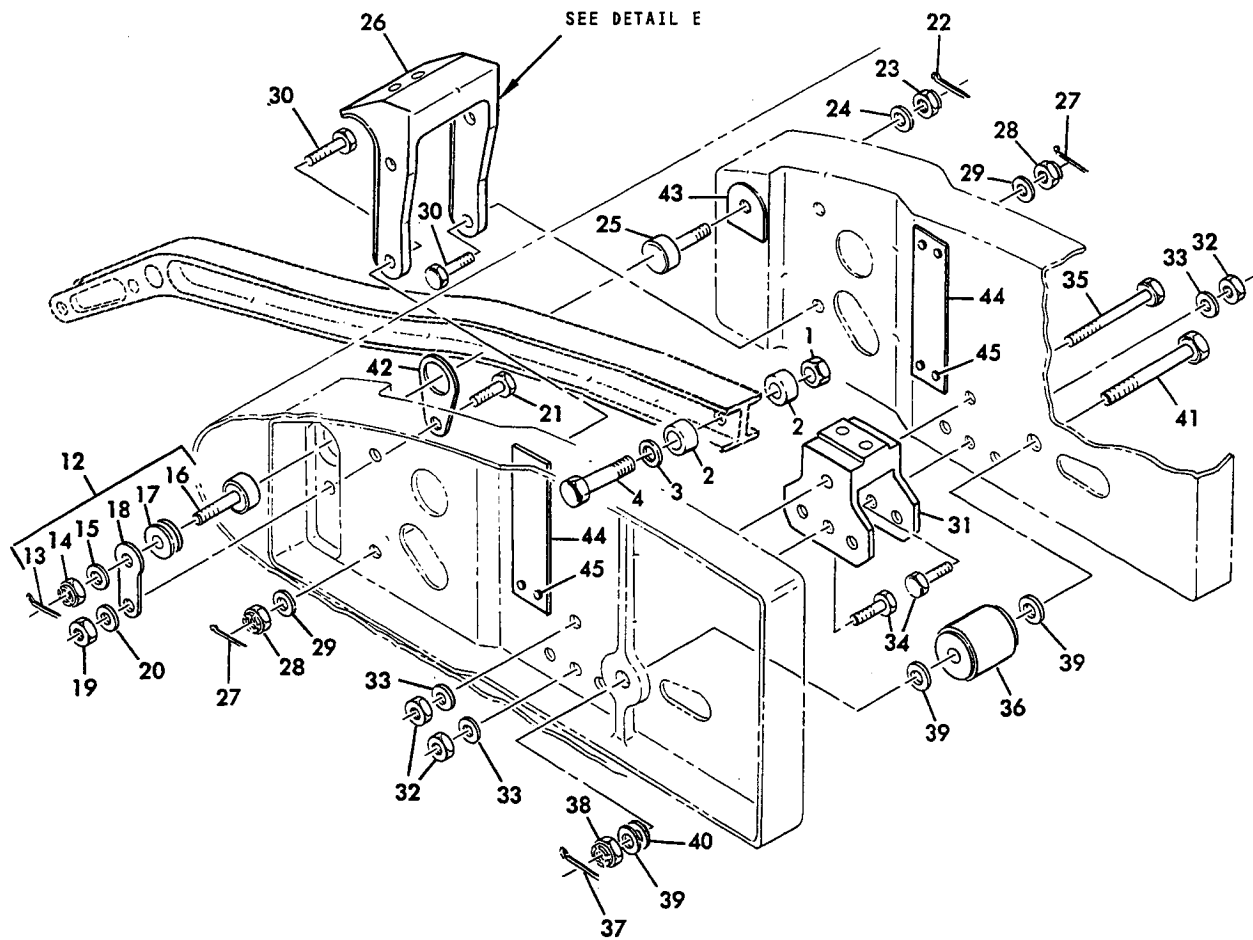


DETAIL A

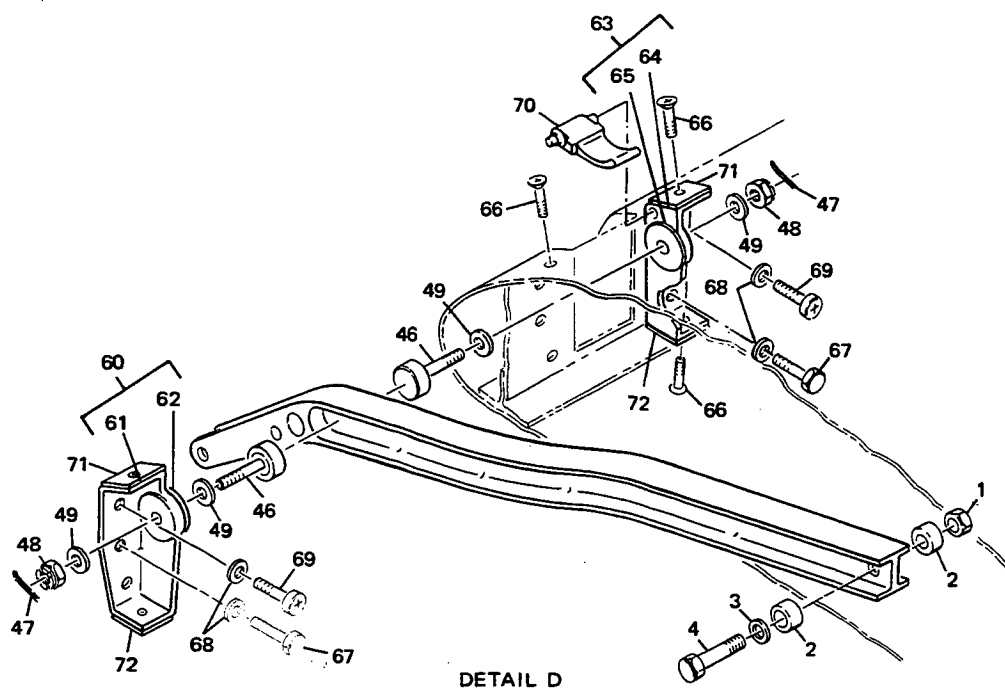
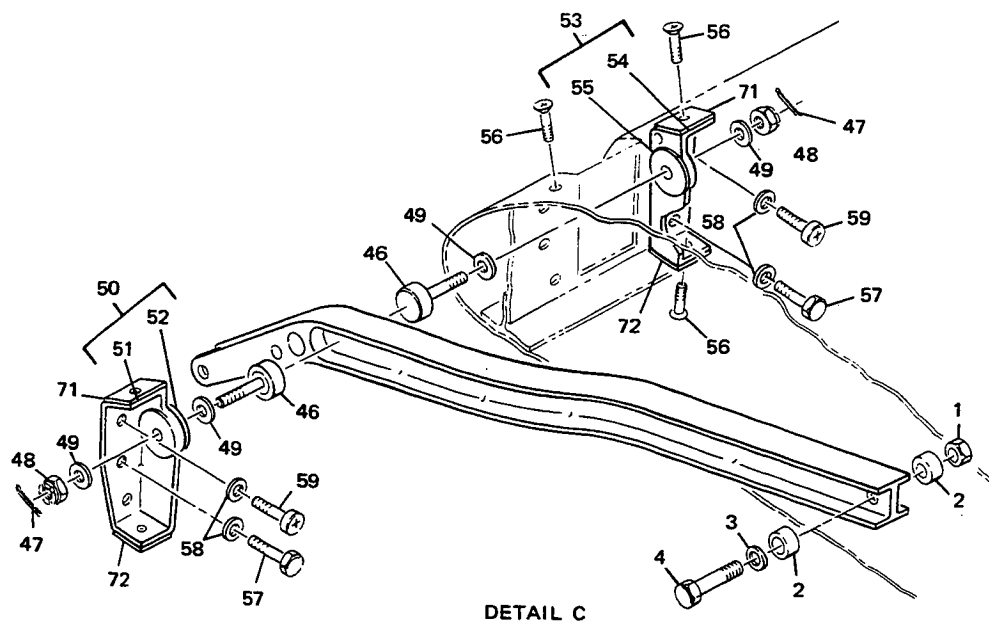
Tracks and Guides Installation
 Figure 1109 (Sheet 1)

65-46436
65-71940
65-71969

BOEING
COMMERCIAL JET
OVERHAUL MANUAL

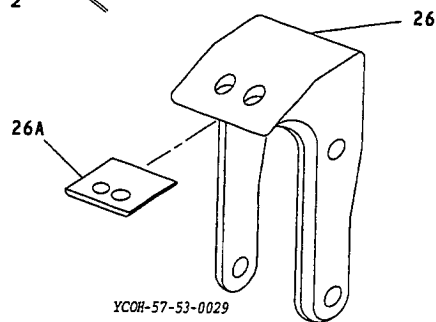


DETAIL B



WARNING

ITEM 26A CONTAINS BERYLLIUM. DUST, FUMES, OR MIST OF BERYLLIUM COMPOUNDS ARE HAZARDOUS IF INHALED. GET APPROVAL OF PROCEDURES FROM AUTHORIZED INDUSTRIAL HYGINE OR MEDICAL UNIT BEFORE YOU FILE, SAND, OR MACHINE BERYLLIUM ALLOY PARTS. REFER TO SOPM 20-10-09 FOR MORE DATA.



DETAIL E

65-46436
65-71940
65-71969

BOEING
COMMERCIAL JET
OVERHAUL MANUAL

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	N O M E N C L A T U R E 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1109-					
	*[1]		TRACKS AND GUIDES INSTL		
1	BACN10JC4		. NUT (REPLS NAS679A4W)		3
2	BACS18K25-14W		. SPACER		6
3	AN960PD416		. WASHER		AR
4	NAS1104-7		. BOLT (REPLS NAS1104-7W)		3
5	65-47894-1		. TRACK, INBOARD AFT FLAP		4
6	BACB30NE4H7		. BOLT (REPLS NAS1304-7H)		8
7	AN960PD416		. WASHER		8
8	NAS578-4A		. RETAINER		8
9	NAS577-4A		. NUT, CYLINDRICAL (REPLS NAS577-4)		8
10	BACB30LU3-6		. BOLT (REPLS BACB30FL3-6)		8
11	BACS40B12-22		. SHIM		AR
12	69-38868-1		. ROLLER ASSY		1
13	MS24665-155		. . PIN, COTTER (REPLS AN381-2-14 AND -16)		1
14	BACN10JD105		. . NUT (REPLS AN320-5)		1
15	AN960PD516L		. . WASHER		1
16	CB37976		. . BEARING, V60380		1
16	CF2041		. . BEARING, V92563 (OPT TO CB37976)		1
17	69-38868-2		. . BOSS		1
18	69-38868-3		. . PLATE		1
19	BACN10JC4		. NUT (REPLS NAS679A4W)		1
20	AN960PD416		. WASHER		1
21	NAS1104-7		. BOLT (REPLS NAS1104-7W)		1
22	MS24665-136		. PIN, COTTER (REPLS AN380-2-4)		1
23	BACN10JD105		. NUT (REPLS AN320-5)		1
24	AN960PD516		. WASHER		1
25	CB37976		. BEARING, V60380		1
25	CF2041		. BEARING, V92563 (OPT TO CB37976)		1
26	69-38869-1		. SUPPORT ASSY		1
26A	69-38869-3		. . BLOCK		1
27	MS24665-136		. PIN, COTTER (REPLS AN380-2-4)		4
28	BACN10JD5		. NUT (REPLS AN310-5)		4
29	AN960PD516		. WASHER		4
30	BACB30NE5D8		. BOLT (REPLS NAS1305-8D)		4
31	69-44992-1		. SUPPORT ASSY		1
32	BACN10JC4		. NUT (REPLS NAS679A4W)		7
33	AN960PD416		. WASHER		7

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	N O M E N C L A T U R E 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1109-					
34	NAS1104-4		. BOLT (REPLS NAS1104-4W)		6
35	NAS1104-23		. BOLT (REPLS NAS1104-23W)		1
36	BACB10B96		. BEARING		1
37	MS24665-285		. PIN, COTTER (REPLS AN380-3-4)		1
38	BACN10JD106		. NUT (REPLS AN320-6)		1
38	BACN10JD6		. NUT (OPT TO BACN10JD106) (REPLS AN310-6)		1
39	AN960PD616		. WASHER (USED WITH BACN10JD106)		3
40	AN960PD616		. WASHER (USED WITH BACN10JD6)		1
41	66-24503-1		. BOLT ASSY		1
42	65-50756-6		. STRIP, RUB		1
43	65-50756-7		. STRIP, RUB		1
44	65-50756-8		. STRIP, RUB		2
45	BACR15BB5A		. RIVET (REPLS MS20470A5)		8
46	CB37976		. BEARING, V60380		4
46	CF2041		. BEARING, V92563 (OPT TO CB37976)		4
47	MS24665-136		. PIN, COTTER (REPLS AN380-2-4)		4
48	BACN10JD105		. NUT (REPLS AN320-5)		4
48	BACN10JD5		. NUT (OPT TO BACN10JD105) (REPLS AN310-5)		4
49	AN960PD516		. WASHER		8
50	69-39223-1		. BRACKET ASSY		1
50	69-39223-9		. BRACKET ASSY (SB 57-1044)		1
51	69-39223-3		. . BRACKET (USED ON 69-39223-1)		1
51	69-39223-13		. . BRACKET (USED ON 69-39223-9)		1
52	66-24530-1		. . STRIP, RUB		1
53	69-39223-2		. BRACKET ASSY		1
53	69-39223-10		. BRACKET ASSY (SB 57-1044)		1
54	69-39223-4		. . BRACKET (USED ON 69-39223-2)		1
54	69-39223-14		. . BRACKET (USED ON 69-39223-10)		1
55	66-24530-1		. . STRIP, RUB		1
56	BACB30LU3-4		. BOLT (REPLS BACB30FL3-4)		4
57	NAS1103-4		. BOLT (REPLS NAS1103-4W)		4
58	AN960PD10L		. WASHER		6
59	NAS623-3-4		. SCREW (REPLS NAS623-3-4W)		2
60	69-39223-5		. BRACKET ASSY		1
60	69-39223-11		. BRACKET ASSY (SB 57-1044)		1
61	69-39223-7		. . BRACKET (USED ON 69-39223-5)		1
61	69-39223-15		. . BRACKET (USED ON 69-39223-11)		1
62	66-24530-1		. . STRIP, RUB		1
63	69-39223-6		. BRACKET ASSY		1
63	69-39223-12		. BRACKET ASSY (SB 57-1044)		1
64	69-39223-8		. . BRACKET (USED ON 69-39223-6)		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	N O M E N C L A T U R E							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
1109-64	69-39223-16		.	.					BRACKET (USED ON 69-39223-12)		1
65	66-24530-1		.	.					STRIP, RUB		1
66	BACB30LU3-4		.						BOLT (REPLS BACB30FL3-4)		4
67	NAS1103-4		.						BOLT (REPLS NAS1103-4W)		4
68	AN960PD10L		.						WASHER		6
69	NAS623-3-4		.						SCREW (REPLS NAS623-3-4W)		2
70	69-42351-1		.						DEFLECTOR		1
71	BACS40B13-16		.						SHIM		4
72	BACS40A14-14		.						SHIM		4

*[1] No Boeing P/N assigned. Items listed are components of Rib Installations P/N's 65-46489 and 65-50756, and Bracket Installation P/N 69-39224.

VENDORS

V09455	RBC TRANSPORT DYNAMICS CORPORATION, 3131 W. SEGERSTROM AVE., SANTA ANA, CALIFORNIA 92704-5811
V21335	TIMKEN US CORPORATION, 336 MECHANIC STREET, LEBANON, NEW HAMPSHIRE 03766-2614
V60380	TIMKEN US CORPORATION, 336 MECHANIC STREET, LEBANON, NEW HAMPSHIRE 03766-2614
V77896	REXNORD INDUSTRIES, INC., DIV. BEARING OPERATION 2400 CURTISS STREET, DOWNER'S GROVE, ILLINOIS 60515-4037
V80657	TIMKEN US CORPORATION, 336 MECHANIC STREET, LEBANON, NEW HAMPSHIRE 03766-2614
V80894	MORGAN ADVANCED MATERIALS & TECHNOLOGY, INC., 441 HALL AVE., ST. MARYS, PENNSYLVANIA 15857-1422
V81376	RBC SOUTHWEST PRODUCTS, INC., 2240 BUENA VISTA, DUARTE, CALIFORNIA 91010-3318
V92563	MCGILL MANUFACTURING COMPANY INCORPORATED, 909 NORTH LAFAYETTE STREET, VALPARAISO, INDIANA 46383-4299
V97393	SHUR-LOK CORP., 2541 WHITE ROAD, IRVINE, CALIFORNIA 92614-6235
V97613	SARGENT CONTROLS & AEROSPACE, 5675 WEST BURLINGAME ROAD, TUCSON, ARIZONA 85743-9453

Part No.	Fig. and Index No.	Qty. per Assy.
AC47485	1106-41	2
AC47485	1106-49	1
AC47485	1106-61	1
AC47485	1107-37	2
AC47485	1107-45	1
AC47485	1107-57	1
AC49007	1106-41	2
AC49007	1106-49	1
AC49007	1106-61	1
AC49007	1107-37	2
AC49007	1107-45	1
AC49007	1107-57	1
AN316-6	1108-166	1
AN7510-1	1104-220	
AN960-416	1101-23	1
AN960-416	1101-31	3
AN960-416	1101-43	1
AN960-416	1102-57	4
AN960-416	1102-68	2
AN960-416	1105-44	6
AN960-416	1106-16	4
AN960-416	1106-16	6
AN960-416	1107-15	4
AN960-416	1107-15	6
AN960-416	1108-28	1
AN960-416	1108-32	1
AN960-416L	1102-3	3
AN960-416L	1106-45	4
AN960-416L4	1107-41	4
AN960-516L	1102-4	3
AN960-616	1102-13	4
AN960-616	1102-13	4
AN960-616	1102-26	2
AN960-616L	1102-13	AR
AN960-616L	1102-13	AR
AN960C816L	1102-15	4
AN960KD10L	1102-165	
AN960KD416	1102-165	
AN960PD10	1104-39	16
AN960PD10	1105-12A	1
AN960PD10	1105-44	1
AN960PD10	1105-44	2
AN960PD10	1105-59	1
AN960PD10	1108-100	2
AN960PD10	1108-36	1
AN960PD10	1108-40	1
AN960PD10	1108-44	1
AN960PD10	1108-61	1

Part No.	Fig. and Index No.	Qty. per Assy.
AN960PD10	1108-72	2
AN960PD10L	1102-81	2
AN960PD10L	1102-88	2
AN960PD10L	1105-122	2
AN960PD10L	1105-12C	2
AN960PD10L	1105-150	2
AN960PD10L	1108-103	4
AN960PD10L	1108-130	AR
AN960PD10L	1108-59	2
AN960PD10L	1108-87	3
AN960PD10L	1108-90	2
AN960PD10L	1108-96	4
AN960PD10L	1109-58	6
AN960PD10L	1109-68	6
AN960PD416	1101-6	2
AN960PD416	1102-33	1
AN960PD416	1105-117	AR
AN960PD416	1105-56	1
AN960PD416	1106-118	6
AN960PD416	1107-124	6
AN960PD416	1108-124	1
AN960PD416	1108-15	2
AN960PD416	1108-182	4
AN960PD416	1108-191	1
AN960PD416	1108-207	1
AN960PD416	1108-81	1
AN960PD416	1109-20	1
AN960PD416	1109-3	AR
AN960PD416	1109-33	7
AN960PD416	1109-7	8
AN960PD416L	1104-5	8
AN960PD416L	1104-50	4
AN960PD416L	1104-60	2
AN960PD416L	1107-118	12
AN960PD416L	1108-68	1
AN960PD416L	1108-75	1
AN960PD516	1106-109	1
AN960PD516	1106-71	4
AN960PD516	1107-105	1
AN960PD516	1107-99	1
AN960PD516	1108-129	AR
AN960PD516	1108-144	AR
AN960PD516	1108-2	2
AN960PD516	1108-65	1
AN960PD516	1109-24	1
AN960PD516	1109-29	4
AN960PD516	1109-49	8
AN960PD516L	1107-109	6

Part No.	Fig. and Index No.	Qty. per Assy.
AN960PD516L	1107-113	6
AN960PD516L	1108-145	AR
AN960PD516L	1108-6	1
AN960PD516L	1109-15	1
AN960PD616	1106-104	1
AN960PD616	1106-87	2
AN960PD616	1106-94	1
AN960PD616	1107-72	4
AN960PD616	1107-80	4
AN960PD616	1107-94	4
AN960PD616	1109-39	3
AN960PD616	1109-40	1
AN960PD616L	1106-103	3
AN960PD616L	1106-80	8
AN960PD616L	1106-80B	6
AN960PD616L	1106-86	6
AN960PD616L	1106-86B	2
AN960PD616L	1106-95	3
AN960PD616L	1106-95B	1
AN960PD616L	1107-87	4
AN960PD616L	1108-167	1
AN960PD8	1105-14B	4
AN960PD8	1105-14B	4
AN960XC10	1108-113C	AR
AN960XC10L	1108-113D	AR
BACB10A660	1108-198	1
BACB10A683	1108-151	1
BACB10AF6F14H	1102-27	2
BACB10AF6F16H	1102-15	4
BACB10AF6F16H	1102-15	4
BACB10AF6F8HS	1108-169	1
BACB10AF6K8HS	1108-169	1
BACB10B136	1106-41	2
BACB10B136	1106-49	1
BACB10B136	1106-61	1
BACB10B136	1107-37	2
BACB10B136	1107-45	1
BACB10B136	1107-57	1
BACB10B196-11	1102-27	2
BACB10B196-7	1108-169	1
BACB10B96	1109-36	1
BACB10B97	1104-9	8
BACB10BH60F11	1102-15	4
BACB10BH60F11	1102-15	4
BACB10BH60F11	1102-15	4
BACB10BH60F11	1102-27	2
BACB10BH60F12	1102-15	4
BACB10BH60F12	1102-15	4

Part No.	Fig. and Index No.	Qty. per Assy.
BACB10BN04	1102-23	
BACB10BN06	1106-30	1
BACB10BN06	1107-26	1
BACB10BN14	1106-41	1
BACB10BN14	1106-49	1
BACB10BN14	1106-61	1
BACB10BN14	1107-37	2
BACB10BN14	1107-45	1
BACB10BN14	1107-57	1
BACB10ET04	1102-23	1
BACB10FK6F16HS	1102-450	
BACB28U3B15	1108-56	1
BACB28U5B15	1108-57	1
BACB28U5B18	1108-161A	1
BACB28U5B18	1108-198A	2
BACB28U6B52	1108-168	1
BACB28U8B50	1108-161	1
BACB28W4B015	1108-56	1
BACB28W4B12	1108-10	4
BACB28W4B20	1108-82	2
BACB28W4B9	1108-160	2
BACB28W4B9	1108-197	2
BACB28W5B20	1108-186	2
BACB28W5B50	1108-141	1
BACB28W5B56	1108-138	2
BACB28W6B015	1108-57	1
BACB28W8B58	1108-164	1
BACB28X6C23	1102-61A	1
BACB28X6C23	1102-64A	1
BACB28X6C51	1102-16	4
BACB28X6C55	1102-28	2
BACB28X8B25	1102-29	2
BACB28Y4C22	1108-76	1
BACB28Y6C18	1102-17	4
BACB28Y6C43	1102-16	4
BACB28Y6C43	1102-16	4
BACB30CW5H6	1106-24	2
BACB30DM4-8H	1102-39	3
BACB30DM5-9H	1102-170	
BACB30DM5-9H	1102-40	1
BACB30DM6-10H	1102-41	2
BACB30DM6-5	1107-81	2
BACB30DM6-6	1107-74	1
BACB30DM6-6	1107-83	1
BACB30DM6-7	1107-82	1
BACB30DM6-8	1107-75	1
BACB30DP6-7	1107-73	2
BACB30EL6-8	1107-73	2

Part No.	Fig. and Index No.	Qty. per Assy.
BACB30FD3H2	1108-155	2
BACB30FD4-12	1103-4	4
BACB30FD4-14	1108-93	3
BACB30FD4-16	1108-92	1
BACB30FD4-21	1102-6	3
BACB30FD5-21	1102-5	3
BACB30FM6-3	1104-32	16
BACB30FN10-9	1106-113	5
BACB30GW8-7	1106-124	16
BACB30LE4-22	1101-90	3
BACB30LE4-22	1102-6	3
BACB30LE4H10	1102-175	
BACB30LE4H13	1102-180	
BACB30LE5-22	1101-95	3
BACB30LE5-22	1102-5	3
BACB30LH2-3	1105-14	16
BACB30LH2-3	1105-14	16
BACB30LH2-3	1105-14	18
BACB30LH2-3	1105-14	18
BACB30LH2-3	1105-14A	7
BACB30LH2-3	1105-14A	7
BACB30LH3-6	1105-16	2
BACB30LJ4DHU	1108-208	1
BACB30LJ4DHU12	1108-125	1
BACB30LJ4DU14	1104-61	2
BACB30LJ5DU24	1108-192	1
BACB30LJ5DU59	1108-132	1
BACB30LJ5DU63	1108-147	1
BACB30LM3DU7	1108-113B	4
BACB30LP5-	1105-142	4
BACB30LT4-22	1101-80	3
BACB30LT5-22	1101-85	3
BACB30LU2-3	1105-93	25
BACB30LU3	1105-136	2
BACB30LU3-13	1108-42	1
BACB30LU3-2	1104-10	
BACB30LU3-2	1104-10	40
BACB30LU3-2	1104-2	16
BACB30LU3-2	1104-64	9
BACB30LU3-2	1105-67	12
BACB30LU3-2	1106-76	4
BACB30LU3-2	1107-68	
BACB30LU3-3	1102-82	2
BACB30LU3-3	1102-89	1
BACB30LU3-4	1105-100	116
BACB30LU3-4	1105-103	33
BACB30LU3-4	1105-107	83
BACB30LU3-4	1105-110	11

Part No.	Fig. and Index No.	Qty. per Assy.
BACB30LU3-4	1105-127	3
BACB30LU3-4	1105-28	8
BACB30LU3-4	1105-75	3
BACB30LU3-4	1105-80	3
BACB30LU3-4	1108-63	2
BACB30LU3-4	1109-56	4
BACB30LU3-4	1109-66	4
BACB30LU3-5	1105-24	2
BACB30LU3-5	1108-183	3
BACB30LU3-6	1105-112	1
BACB30LU3-6	1105-120	1
BACB30LU3-6	1105-149	1
BACB30LU3-6	1105-3B	3
BACB30LU3-6	1105-45A	2
BACB30LU3-6	1105-45A	3
BACB30LU3-6	1105-85	5
BACB30LU3-6	1109-10	8
BACB30LU3-7	1105-132	1
BACB30LU3-7	1105-20	1
BACB30LU3-8	1108-38	1
BACB30LU3-9	1105-121	1
BACB30LU3-9	1105-148	1
BACB30LU3-9	1108-108	1
BACB30LU4-10	1105-38	3
BACB30LU4-12	1105-38	3
BACB30LU4-4	1104-11	
BACB30LU4-4	1104-11	32
BACB30LU4-6	1102-65	2
BACB30LU4-6	1105-47	2
BACB30LU4-7	1105-101	58
BACB30LU4-7	1105-104	24
BACB30LU4-7	1105-108	30
BACB30LU4-7	1105-111	72
BACB30LU4D13	1106-17	2
BACB30LU4D13	1107-16	2
BACB30LU4D15	1106-19	2
BACB30LU4D15	1107-18	2
BACB30LU4D7	1108-16	2
BACB30LU5-23	1105-155	4
BACB30LU6-8	1106-83	2
BACB30NE3-6	1105-45A	3
BACB30NE4-10	1105-58	1
BACB30NE4-8	1105-58	1
BACB30NE4D16	1108-85	1
BACB30NE4D38	1102-35	1
BACB30NE4H10	1107-22	1
BACB30NE4H10	1108-17	1
BACB30NE4H2	1106-44	4

Part No.	Fig. and Index No.	Qty. per Assy.
BACB30NE4H2	1107-40	4
BACB30NE4H4	1104-49	4
BACB30NE4H6	1106-26	4
BACB30NE4H6	1107-21	3
BACB30NE4H7	1109-6	8
BACB30NE5D8	1109-30	4
BACB30NF3-4	1108-73	2
BACB30NF4-10	1105-57	1
BACB30NF4-9	1105-57	1
BACB30NN3K	1105-136	2
BACB30NN3K2	1106-76	4
BACB30NN3K4	1102-185	
BACB30NN3K4	1105-127	3
BACB30NN3K4	1105-127	3
BACB30NN3K6	1105-149	1
BACB30NN3K7	1105-132	1
BACB30NN3K7	1105-132	1
BACB30NN3K9	1105-148	1
BACB30NN4K6	1102-190	
BACB30NN5K23	1105-155	4
BACB30NR4DK36	1102-195	
BACB30NR4DK38	1102-200	
BACB30NR4K7	1101-100	3
BACB30NR6K10	1106-97	2
BACB30NR6K7	1106-81	1
BACB30NR6K7	1106-89	2
BACB30UU4K8H	1102-205	
BACB30UU5K11H	1102-210	
BACB30UU6K11H	1102-215	
BACB30VF4K4	1104-11	
BACB30VF4K6	1102-220	
BACC15AJ1	1108-115	4
BACC30K8	1106-123	16
BACC30M10	1106-112	5
BACC30M6	1104-33	16
BACN10CP4H	1102-225	
BACN10CP5H	1102-230	
BACN10CP6H	1102-235	
BACN10FX1	1104-67	9
BACN10FX1	1105-23	1
BACN10FX21	1104-225	
BACN10FX21	1104-230	
BACN10FX21	1105-133	1
BACN10GW3	1108-58	4
BACN10GW4	1102-1	3
BACN10GW4	1105-60	1
BACN10GW5	1102-2	3
BACN10HC4	1102-240	

Part No.	Fig. and Index No.	Qty. per Assy.
BACN10HC4	1102-240	
BACN10HC4	1102-48	3
BACN10HC4	1103-2	4
BACN10HC5	1102-245	
BACN10HC5	1102-49	1
BACN10HC6	1102-250	
BACN10HC6	1102-50	1
BACN10HR4CD	1101-100	3
BACN10HR5CD	1101-105	3
BACN10JC08	1105-14C	4
BACN10JC08	1105-14C	4
BACN10JC3	1102-80	2
BACN10JC3	1102-87	2
BACN10JC3	1105-123	1
BACN10JC3	1105-151	2
BACN10JC3	1105-17	2
BACN10JC3	1105-43	1
BACN10JC3	1105-43	2
BACN10JC3	1108-102	2
BACN10JC3	1108-106	1
BACN10JC3	1108-133	5
BACN10JC3	1108-22	1
BACN10JC3	1108-35	1
BACN10JC3	1108-39	1
BACN10JC3	1108-43	1
BACN10JC3	1108-58	4
BACN10JC3	1108-71	2
BACN10JC3	1108-86	3
BACN10JC3	1108-95	2
BACN10JC4	1101-22	1
BACN10JC4	1101-42	1
BACN10JC4	1101-5	2
BACN10JC4	1105-115	3
BACN10JC4	1105-43	6
BACN10JC4	1105-55	1
BACN10JC4	1106-117	6
BACN10JC4	1107-117	6
BACN10JC4	1107-123	6
BACN10JC4	1109-1	3
BACN10JC4	1109-19	1
BACN10JC4	1109-32	7
BACN10JC5	1106-70	4
BACN10JC5	1107-108	6
BACN10JC5	1107-112	6
BACN10JC5	1108-1	2
BACN10JC6	1106-102	4
BACN10JC6	1107-71	4
BACN10JC6	1107-79	4

Part No.	Fig. and Index No.	Qty. per Assy.
BACN10JC6	1107-86	4
BACN10JC6	1107-93	4
BACN10JC6CD	1106-79	4
BACN10JC6CD	1106-85	4
BACN10JC6CD	1106-93	4
BACN10JD103	1104-38	16
BACN10JD104	1102-56	4
BACN10JD104	1102-67	2
BACN10JD104	1104-4	4
BACN10JD104	1106-15	4
BACN10JD104	1106-15	6
BACN10JD104	1107-14	4
BACN10JD104	1107-14	6
BACN10JD104	1108-14	2
BACN10JD104	1108-206	1
BACN10JD104	1108-27	1
BACN10JD104	1108-31	1
BACN10JD104AU	1104-59	2
BACN10JD104AU	1108-123	1
BACN10JD104CD	1102-255	
BACN10JD105	1107-104	1
BACN10JD105	1107-98	1
BACN10JD105	1108-143	1
BACN10JD105	1108-190	1
BACN10JD105	1108-5	1
BACN10JD105	1109-14	1
BACN10JD105	1109-23	1
BACN10JD105	1109-48	4
BACN10JD105AU	1108-128	1
BACN10JD106	1102-12	4
BACN10JD106	1102-25	2
BACN10JD106	1104-35	8
BACN10JD106	1108-166	1
BACN10JD106	1109-38	1
BACN10JD3	1108-113F	4
BACN10JD4	1102-32	1
BACN10JD4	1108-80	1
BACN10JD4CD	1102-260	
BACN10JD5	1106-108	1
BACN10JD5	1109-28	4
BACN10JD5	1109-48	4
BACN10JD6	1102-12	4
BACN10JD6	1109-38	1
BACN10JN3	1105-31	3
BACN10JN3	1105-36	4
BACN10JN3	1105-79	3
BACN10JN3	1105-84	3
BACN10JN3	1105-91	5

Part No.	Fig. and Index No.	Qty. per Assy.
BACN10JN3	1108-154	2
BACN10JN3	1108-188	3
BACN10JN3CM	1102-265	
BACN10JN4	1105-54	2
BACN10JP4A	1105-60	1
BACN10JP4D	1102-72	1
BACN10JQ32	1105-137	2
BACN10JQ32	1105-27	2
BACN10JQ32	1105-3F	1
BACN10JQ32	1105-3J	2
BACN10JQ32	1105-44C	2
BACN10JQ42	1105-41	3
BACN10JR3F	1106-78	4
BACN10JR3F	1107-70	
BACN10JR5F	1105-156	4
BACN10JT3CD	1104-230	
BACN10JT3CD	1104-235	
BACN10KB3	1105-34	1
BACN10MX5	1105-159	4
BACN10RB3	1105-68	12
BACN10YR3CD	1102-270	
BACN10YR4CD	1101-110	3
BACN10YR5CD	1101-115	3
BACP30F4A	1108-83	1
BACP30J4	1108-83	1
BACR10V4	1102-275	
BACR10V4	1102-45	3
BACR10V5	1102-280	
BACR10V5	1102-46	1
BACR10V6	1102-47	2
BACR15BA3B	1108-153	4
BACR15BA3D	1102-71	4
BACR15BA3D	1104-45	16
BACR15BA3D	1105-129	6
BACR15BA3D	1105-138	4
BACR15BA3D	1105-26	4
BACR15BA3D	1105-30	6
BACR15BA3D	1105-33	2
BACR15BA3D	1105-35	8
BACR15BA3D	1105-40	6
BACR15BA3D	1105-53	4
BACR15BA3D	1105-61	2
BACR15BA3D	1105-78	6
BACR15BA3D	1105-83	6
BACR15BA3D	1105-90	10
BACR15BA3D	1106-77	8
BACR15BA3D	1107-69	
BACR15BA3D	1108-187	6

Part No.	Fig. and Index No.	Qty. per Assy.
BACR15BA4D	1105-157	8
BACR15BA4D	1105-160	8
BACR15BA5B	1106-6	2
BACR15BA5B	1107-11	2
BACR15BA5D	1106-12	2
BACR15BA6DD	1105-69	3
BACR15BA6DD	1105-70	8
BACR15BA6DD	1105-73	4
BACR15BB5A	1109-45	8
BACR15BB6D	1104-31	48
BACR15CE4B4	1105-164	12
BACR15CE4B4	1105-166	7
BACR15CE5B5	1105-69	3
BACR15CE6M4	1105-51	4
BACR15CE6M5	1105-70	8
BACR15CE6M5	1105-73	4
BACR15DR3PAC2	1102-440	
BACR15DR3PAC2	1104-240	
BACS12N10-9	1102-75	12
BACS12N10-9	1104-57	13
BACS18K25-14W	1101-120	3
BACS18K25-14W	1105-116	6
BACS18K25-14W	1109-2	6
BACS40A14-14	1109-72	4
BACS40B12-22	1109-11	AR
BACS40B13-16	1109-71	4
BACS40R010F010F	1102-285	
BACS40R014D014F	1102-290	
BACS40R07B14F	1102-295	
BACS40R07B14F	1102-54	AR
BACS40R08B14F	1102-300	
BACS40R09B12F	1102-305	
BACS40R09B13F	1102-310	
BACS40R09B24F	1102-315	
BACS40R100F100F	1102-320	
BACS40R10B20F	1104-28	8
BACS40R10C12F	1104-245	
BACS40R10C21F	1102-325	
BACS40R10C27	1105-125	
BACS40R10C27F	1105-153	AR
BACS40R10E10F	1105-139	AR
BACS40R14B14F	1102-53	3
BACS40R14D14F	1102-330	
BACS40R17D38	1105-46	AR
BACS40R8E9	1105-22	1
BACS40R8E9F	1105-134	AR
BACS40RO7B130	1105-5	AR
BACS40RO7B142	1105-7	AR

Part No.	Fig. and Index No.	Qty. per Assy.
BACS40RO7B178	1105-8	AR
BACS40RO7B19	1105-6	AR
BACS40RO7B198	1105-10	AR
BACS40RO7B25	1105-9	AR
BACS40RO7B95	1105-11	AR
BACS40SD14-26	1106-35	2
BACS40SD14-26	1107-31	2
BACW10AKWC3	1108-134	5
BACW10BH3	1108-60	1
BACW10BN4C	1102-335	
BACW10BN4C	1102-3A	2
BACW10BN4C	1103-3	4
BACW10BN4C	1106-27	4
BACW10BN4C	1107-23	3
BACW10BN4C	1107-23	3
BACW10BN4C	1108-18	1
BACW10BN5C	1102-340	
BACW10BN5C	1102-4A	2
BACW10BN6C	1102-350	
BACW10BP3C	1108-156	2
BACW10BP41CD	1102-355	
BACW10BP4ACU	1101-135	3
BACW10BP4APU	1101-125	3
BACW10BP4C	1108-94	4
BACW10BP4CD	1102-410	
BACW10BP5ACU	1101-140	3
BACW10BP5APU	1101-130	3
BACW10BP5CD	1102-415	
BACW10BP6CD	1102-420	
BACW10CP3	1108-107	1
BACW10CT12C	1108-65	1
BACW10CT6C	1108-60	2
BACW10DS4S	1102-360	
BACW10DS4S	1102-425	
BACW10DS5S	1102-365	
BACW10DS5S	1102-430	
BACW10DS6S	1102-370	
BACW10P219S	1102-43	1
BACW10P221S	1102-44	3
BACW10P3C	1108-113E	AR
BACW10P46S	1102-42	3
BACW10UB101	1104-65	10
BLFN17-003	1101-16	1
BLFN17-003	1101-51	1
BLFN8-017	1101-20	1
BLFN8-017	1101-40	1
BS16ATC32	1101-20	1
BS16ATC32	1101-40	1

Part No.	Fig. and Index No.	Qty. per Assy.
BS34ATC56-2	1101-16	1
BS34ATC56-2	1101-51	1
CB37976	1109-16	1
CB37976	1109-25	1
CB37976	1109-46	4
CC38364	1104-36	8
CC39009	1108-49	1
CF2041	1109-16	1
CF2041	1109-25	1
CF2041	1109-46	4
CF2051	1104-36	8
CF2057	1108-49	1
DBAF58-002	1103-9	4
DREM4-181	1108-66	1
DREM4-296	1108-118	1
DREM4-296	1108-201	1
DREM4-299	1108-119	1
DREM4-299	1108-202	1
DREM4-344	1108-66	1
DU06	1108-173	1
DU154	1108-173	
KJB155104V	1104-42	
KJB331308V	1102-29	2
KMS400	1103-9	4
KRP141500VT6-16	1102-27	2
KRP141500VT6-17	1102-15	4
KRP502-4VT	1102-23	1
KSBN8	1101-20	1
KSBN8	1101-40	1
KSBY17N1	1101-16	1
KSBY17N1	1101-51	1
LA4186A	1104-42	
LA4186A	1104-42	16
MS16562-10	1102-19	1
MS16562-216	1106-31	1
MS16562-216	1107-27	1
MS16562-35	1106-50	1
MS16562-35	1106-62	1
MS16562-35	1107-46	1
MS16562-35	1107-58	1
MS172202	1101-18	1
MS172202	1101-38	1
MS172208	1101-26	1
MS172237	1101-19	1
MS172237	1101-39	1
MS172243	1101-27	1
MS172243	1101-46	1
MS20002C4	1108-84	1

Part No.	Fig. and Index No.	Qty. per Assy.
MS20002C5	1108-131	1
MS20002C5	1108-146	1
MS20004-14	1108-93	3
MS20004-16	1108-92	1
MS20004-22	1102-6	
MS20219-4	1108-24	1
MS20219-4	1108-33	1
MS20219-4	1108-83	1
MS20392-2C29	1108-91	2
MS20427M5	1108-121A	2
MS20427M5	1108-204A	2
MS20470M	1105-3G	2
MS20470M	1105-3K	4
MS20470M	1105-44D	4
MS21209F4-15	1106-11	2
MS21209F4-15	1106-5	2
MS21209F4-15	1107-10	2
MS21209F4-15	1107-4	2
MS21209F4-15	1108-70B	1
MS21209F4-20	1107-78	3
MS21251-5S	1108-114	2
MS24665-134	1102-31	1
MS24665-134	1102-55	4
MS24665-134	1102-66	2
MS24665-134	1104-3	4
MS24665-134	1104-37	16
MS24665-134	1107-103	1
MS24665-134	1108-113G	4
MS24665-134	1108-79	1
MS24665-134	1108-89	2
MS24665-136	1106-107	1
MS24665-136	1109-22	1
MS24665-136	1109-27	4
MS24665-136	1109-47	4
MS24665-153	1102-375	
MS24665-153	1104-58	2
MS24665-153	1106-14	4
MS24665-153	1106-14	6
MS24665-153	1107-13	4
MS24665-153	1107-13	6
MS24665-153	1107-97	1
MS24665-153	1108-111	4
MS24665-153	1108-122	1
MS24665-153	1108-127	1
MS24665-153	1108-13	2
MS24665-153	1108-142	1
MS24665-153	1108-189	1
MS24665-153	1108-193	2

Part No.	Fig. and Index No.	Qty. per Assy.
MS24665-153	1108-205	1
MS24665-153	1108-26	1
MS24665-153	1108-30	1
MS24665-153	1108-4	1
MS24665-153	1108-48	1
MS24665-153	1108-50	1
MS24665-155	1109-13	1
MS24665-283	1102-11	4
MS24665-283	1102-24	2
MS24665-283	1102-445	
MS24665-285	1104-34	8
MS24665-285	1108-165	1
MS24665-285	1109-37	1
MS24665-287	1106-36	2
MS24665-287	1107-32	2
MS24665-289	1106-51	1
MS24665-289	1106-63	1
MS24665-289	1107-47	1
MS24665-289	1107-59	1
MS24678-25	1101-30	3
MS27111-	1108-167	
NAS1057T8-007	1101-20J	1
NAS1057T8-007	1101-40J	1
NAS1068A3	1102-380	
NAS1068A3	1105-128	3
NAS1068A4	1104-250	
NAS1103-15	1108-135	5
NAS1103-17	1108-98	2
NAS1103-19	1108-23	1
NAS1103-27	1108-105	2
NAS1103-4	1108-73	2
NAS1103-4	1109-57	4
NAS1103-4	1109-67	4
NAS1103-5	1108-88	3
NAS1103-7	1108-99	2
NAS1104-10	1101-7	2
NAS1104-10D	1106-18	2
NAS1104-10D	1107-17	2
NAS1104-12D	1108-34	1
NAS1104-19D	1108-29	1
NAS1104-20	1101-24	1
NAS1104-20	1101-44	1
NAS1104-23	1109-35	1
NAS1104-36D	1102-385	
NAS1104-36D	1102-58	4
NAS1104-38D	1102-390	
NAS1104-38D	1102-435	
NAS1104-38D	1102-69	2

Part No.	Fig. and Index No.	Qty. per Assy.
NAS1104-4	1107-119	6
NAS1104-4	1107-125	6
NAS1104-4	1109-34	6
NAS1104-6	1106-119	6
NAS1104-7	1105-118	3
NAS1104-7	1109-21	1
NAS1104-7	1109-4	3
NAS1104-8	1108-181	2
NAS1104-10	1108-180	2
NAS1105-12D	1107-100	1
NAS1105-14D	1108-7	1
NAS1105-5	1106-72	4
NAS1105-54D	1107-106	1
NAS1105-58D	1106-110	1
NAS1105-6	1107-110	6
NAS1105-7	1107-110	6
NAS1105-7	1107-114	6
NAS1105-8	1108-3	2
NAS1106-10	1107-89	1
NAS1106-11	1106-98	1
NAS1106-5	1106-88	1
NAS1106-5	1107-81	2
NAS1106-5	1107-83	1
NAS1106-6	1106-105	3
NAS1106-6	1107-74	1
NAS1106-7	1106-90	1
NAS1106-7	1107-82	1
NAS1106-7	1107-95	3
NAS1106-8	1106-106	1
NAS1106-8	1106-82	1
NAS1106-8	1107-75	1
NAS1106-8	1107-96	1
NAS1106-9	1106-96	1
NAS1106-9	1107-88	3
NAS1149C0663R	1102-13	4
NAS1149C0663R	1102-26	2
NAS1149D0416J	1101-8B	1
NAS1149D0463J	1101-8A	1
NAS1149F0616P	1106-80A	2
NAS1149F0616P	1106-86A	4
NAS1149F0616P	1106-95A	2
NAS1195DD4FH	1104-255	
NAS1195DD4FM	1104-260	
NAS1252-1416H	1106-42	2
NAS1252-1416H	1107-38	2
NAS1304-4H	1104-265	
NAS1503-5	1108-62	2
NAS1504-6	1105-45A	6

65-46436

65-71940

65-71969

DASH NUMBERS LIMITED



OVERHAUL MANUAL

Part No.	Fig. and Index No.	Qty. per Assy.
NAS42DD6-50	1108-97	2
NAS42DD6-89	1108-104	2
NAS43DD6-33	1108-65A	1
NAS43HT3-32	1108-37	1
NAS43HT3-45	1108-45	1
NAS43HT3-51	1108-41	1
NAS509-4	1108-67	1
NAS509-4	1108-74	1
NAS509-5	1108-64	1
NAS509-6C	1108-64	1
NAS514P1032-5	1104-68	10
NAS516-1	1102-22	1
NAS516-1	1104-130	
NAS516-1	1104-145	
NAS516-1	1104-185	
NAS516-1	1104-19	1
NAS516-1	1104-200	
NAS516-1	1104-27	1
NAS516-1	1104-8	1
NAS516-1	1106-34	1
NAS516-1	1106-40	1
NAS516-1	1106-55	1
NAS516-1	1106-67	1
NAS516-1	1107-30	1
NAS516-1	1107-36	1
NAS516-1	1107-51	1
NAS516-1	1107-63	1
NAS538B4P15	1104-48	2
NAS549ML1416	1108-179	1
NAS577-4A	1109-9	8
NAS577-5A	1106-23	2
NAS578-4A	1109-8	8
NAS578-5A	1106-22	2
NAS603-6P	1105-45	2
NAS603-7P	1105-45	2
NAS623-3-17	1108-46	1
NAS623-3-4	1105-12B	2
NAS623-3-4	1109-59	2
NAS623-3-4	1109-69	2
NAS623-3-5	1105-12	18
NAS623-3-6	1105-12D	1
NAS623-3-7	1105-12E	2
NAS623-3-8	1105-12F	1
NAS6704H8	1102-395	
NAS6705H11	1102-400	
NAS6706H11	1102-405	
NAS698A4	1104-270	
NAS75-6-008	1102-17	4

Part No.	Fig. and Index No.	Qty. per Assy.
NAS75-6-008	1102-17	4
NAS75-6-020	1102-28	2
REM8ATC8	1108-66	1
REM8ATC8-3	1108-66	1
REMS8ATC10-7	1108-119	1
REMS8ATC10-7	1108-202	1
SL2-3-500-1SP	1104-66	10
SL2869S35	1104-66	10
TFA8	1101-40	1
YFM4E	1108-66	1
YR743-3	1106-41	2
YR743-3	1106-49	1
YR743-3	1106-61	1
YR743-3	1107-37	2
YR743-3	1107-45	1
YR743-3	1107-57	1
YTA228	1101-16	1
YTA228	1101-51	1
YTD152	1103-9	4
YTM124R	1108-119	1
YTM124R	1108-202	1
YTP103	1108-118	1
YTP103	1108-201	1
03-713-0500	1101-20	1
03-713-0500	1101-40	1
10-61351-1	1108-25	1
117182	1101-16	1
117182	1101-51	1
14AFC1832	1106-41	2
14AFC1832	1106-49	1
14AFC1832	1106-61	1
14AFC1832	1107-37	2
14AFC1832	1107-45	1
14AFC1832	1107-57	1
177014	1108-66	1
177147	1108-118	1
177147	1108-201	1
177162	1108-119	1
177162	1108-202	1
65-46430-100	1101-1	
65-46430-100	1102-	
65-46430-101	1102-38	1
65-46430-102	1102-38	1
65-46430-119	1102-38	1
65-46430-120	1102-38	1
65-46430-121	1101-1	
65-46430-121	1102-	
65-46430-122	1101-1	

Jul 1/07

57-53-22
Page 1187

Part No.	Fig. and Index No.	Qty. per Assy.
65-46430-122	1102-	
65-46430-123	1102-100	
65-46430-124	1102-100	
65-46430-129	1101-1	
65-46430-129	1102-	
65-46430-130	1101-1	
65-46430-130	1102-	
65-46430-131	1102-38	1
65-46430-132	1102-38	1
65-46430-133	1102-100	
65-46430-134	1102-100	
65-46430-147	1102-105	
65-46430-149	1102-38	1
65-46430-15	1102-79	1
65-46430-150	1102-38	1
65-46430-153	1102-105	
65-46430-25	1102-110	
65-46430-26	1102-78	1
65-46430-27	1102-77	1
65-46430-38	1102-76	2
65-46430-503	1102-100	
65-46430-504	1102-100	
65-46430-505	1102-120	
65-46430-506	1102-120	
65-46430-522	1102-100	
65-46430-523	1102-100	
65-46430-72	1102-110	
65-46430-73	1101-60	6
65-46430-73	1102-9	AR
65-46430-74	1101-65	6
65-46430-74	1102-10	AR
65-46430-75	1101-1	1
65-46430-75	1102-	RF
65-46430-76	1101-1	1
65-46430-76	1102-	RF
65-46430-77	1102-38	1
65-46430-77	1102-38	1
65-46430-78	1102-38	1
65-46430-78	1102-38	1
65-46430-79	1101-1	1
65-46430-79	1102-	RF
65-46430-80	1101-1	1
65-46430-80	1102-	RF
65-46430-83	1101-1	1
65-46430-83	1102-	RF
65-46430-84	1101-1	1
65-46430-84	1102-	RF
65-46430-85	1102-38	1

Part No.	Fig. and Index No.	Qty. per Assy.
65-46430-85	1102-38	1
65-46430-86	1102-38	1
65-46430-86	1102-38	1
65-46430-87	1101-1	1
65-46430-87	1102-	RF
65-46430-88	1101-1	1
65-46430-88	1102-	RF
65-46430-89	1102-38	1
65-46430-89	1102-38	1
65-46430-90	1102-38	1
65-46430-90	1102-38	1
65-46430-97	1101-1	1
65-46430-97	1102-	RF
65-46430-98	1101-1	1
65-46430-98	1102-	RF
65-46430-99	1101-1	
65-46430-99	1102-	
65-46434-106	1104-70	
65-46434-108	1104-70	
65-46434-111	1104-75	
65-46434-117	1101-3	1
65-46434-117	1104-	RF
65-46434-118	1101-3	1
65-46434-118	1104-	RF
65-46434-135	1101-3	1
65-46434-135	1104-	RF
65-46434-136	1101-3	1
65-46434-136	1104-	RF
65-46434-139	1101-3	1
65-46434-139	1104-	RF
65-46434-14	1104-70	
65-46434-140	1101-3	1
65-46434-140	1104-	RF
65-46434-147	1104-62	
65-46434-148	1104-62	
65-46434-149	1104-62	
65-46434-150	1104-62	
65-46434-151	1104-62	
65-46434-152	1104-62	
65-46434-153	1104-62	
65-46434-154	1104-62	
65-46434-155	1104-62	
65-46434-156	1104-62	
65-46434-179	1101-3	1
65-46434-179	1104-	RF
65-46434-180	1101-3	1
65-46434-180	1104-	RF
65-46434-181	1101-3	

Part No.	Fig. and Index No.	Qty. per Assy.
65-46434-182	1101-3	
65-46434-183	1101-3	
65-46434-184	1101-3	
65-46434-188	1104-54	
65-46434-189	1104-55	
65-46434-190	1104-51	
65-46434-191	1104-52	
65-46434-217	1104-62	
65-46434-218	1104-62	
65-46434-219	1104-62	
65-46434-220	1104-62	
65-46434-221	1104-62	
65-46434-222	1104-62	
65-46434-223	1104-62	
65-46434-224	1104-62	
65-46434-225	1104-62	
65-46434-226	1104-62	
65-46434-227	1104-51	
65-46434-228	1104-52	
65-46434-229	1104-53	
65-46434-301	1101-3	
65-46434-301	1104-	
65-46434-302	1101-3	
65-46434-302	1104-	
65-46434-303	1104-80	
65-46434-304	1104-80	
65-46434-33	1104-85	
65-46434-335	1101-3	
65-46434-335	1104-	
65-46434-336	1101-3	
65-46434-336	1104-	
65-46434-34	1104-85	
65-46434-351	1101-3	
65-46434-351	1104-	
65-46434-352	1101-3	
65-46434-352	1104-	
65-46434-367	1101-3	
65-46434-367	1104-	
65-46434-368	1101-3	
65-46434-368	1104-	
65-46434-58	1104-51	
65-46434-58	1104-51	1
65-46434-59	1104-52	
65-46434-59	1104-52	1
65-46434-60	1104-53	
65-46434-60	1104-53	1
65-46434-63	1104-54	
65-46434-63	1104-54	1

Part No.	Fig. and Index No.	Qty. per Assy.
65-46434-64	1104-55	
65-46434-64	1104-55	1
65-46434-65	1104-56	1
65-46434-75	1104-205	
65-46434-76	1104-205	
65-46434-77	1104-62	
65-46434-78	1104-62	
65-46434-79	1104-62	
65-46434-80	1104-62	
65-46434-81	1104-62	
65-46434-82	1104-62	
65-46434-83	1104-62	
65-46434-84	1104-62	
65-46434-85	1104-62	
65-46434-86	1104-62	
65-46434-89	1101-3	
65-46434-89	1104-	
65-46434-90	1101-3	
65-46434-90	1104-	
65-46436-10	1102-10	6
65-46436-11	1101-	RF
65-46436-12	1101-	RF
65-46436-13	1101-	RF
65-46436-14	1101-	RF
65-46436-15	1101-	RF
65-46436-16	1101-	RF
65-46436-17	1101-	RF
65-46436-18	1101-	RF
65-46436-19	1101-	RF
65-46436-20	1101-	RF
65-46436-21	1101-	RF
65-46436-22	1101-	RF
65-46436-23	1101-	RF
65-46436-24	1101-	RF
65-46436-31	1101-	RF
65-46436-32	1101-	RF
65-46436-33SP	1101-	RF
65-46436-34SP	1101-	RF
65-46436-35SP	1101-	RF
65-46436-36SP	1101-	RF
65-46436-39SP	1101-	RF
65-46436-40SP	1101-	RF
65-46436-41SP	1101-	RF
65-46436-42SP	1101-	RF
65-46436-43SP	1101-	RF
65-46436-44SP	1101-	RF
65-46436-5	1101-	RF
65-46436-59	1101-	RF

Part No.	Fig. and Index No.	Qty. per Assy.
65-46436-6	1101-	RF
65-46436-60	1101-	RF
65-46436-61SP	1101-	
65-46436-62SP	1101-	
65-46436-69SP	1101-	
65-46436-7	1101-	RF
65-46436-70SP	1101-	
65-46436-71SP	1101-	
65-46436-72SP	1101-	
65-46436-8	1101-	RF
65-46436-9	1102-9	6
65-46486-111	1105-3	1
65-46486-111	1105-3	1
65-46486-112	1105-3	1
65-46486-112	1105-3	1
65-46486-113	1105-3	
65-46486-114	1105-3	
65-46486-139	1105-3	1
65-46486-140	1105-3	1
65-46486-31	1105-3	1
65-46486-32	1105-3	1
65-46486-505	1105-3	1
65-46486-506	1105-3	1
65-46486-507	1105-3	1
65-46486-508	1105-3	1
65-46486-509	1105-3	1
65-46486-510	1105-3	1
65-46486-511	1105-3	1
65-46486-512	1105-3	1
65-46486-56	1105-13	1
65-46486-60	1105-19	1
65-46486-61	1105-15	1
65-46486-73	1105-3	1
65-46486-74	1105-3	1
65-46486-77	1105-15	1
65-46486-8	1105-4	15
65-46486-8	1105-4	16
65-46486-8	1105-4	17
65-46486-80	1105-4A	1
65-46486-87	1105-3	1
65-46486-88	1105-3	1
65-46492-1	1105-1	1
65-46492-1	1106-	RF
65-46492-10	1106-8	1
65-46492-2	1105-1	1
65-46492-2	1106-	RF
65-46492-3	1106-2	1
65-46492-4	1106-8	1

Part No.	Fig. and Index No.	Qty. per Assy.
65-46492-5	1105-1	1
65-46492-5	1106-	RF
65-46492-6	1105-1	1
65-46492-6	1106-	RF
65-46492-7	1106-2	1
65-46492-8	1106-8	1
65-46492-9	1106-2	1
65-47839-1	1105-105	1
65-47839-11	1105-102	1
65-47839-12	1105-102	1
65-47839-2	1105-105	1
65-47840-1	1105-99	
65-47840-13	1105-99	1
65-47840-14	1105-99	1
65-47840-2	1105-99	
65-47840-23	1105-99	1
65-47840-24	1105-99	1
65-47841-25	1105-95	1
65-47841-26	1105-95	1
65-47841-27	1105-97	1
65-47841-28	1105-97	1
65-47841-33	1105-96	1
65-47841-34	1105-96	1
65-47841-63	1105-98	1
65-47841-64	1105-98	1
65-47841-73	1105-92	1
65-47841-74	1105-92	1
65-47841-75	1105-94	1
65-47841-76	1105-94	1
65-47841-93	1105-98	1
65-47841-94	1105-98	1
65-47841-95	1105-92	1
65-47841-96	1105-92	1
65-47845-30	1107-4H	1
65-47856-1	1106-3	1
65-47856-10	1107-8	1
65-47856-11	1107-9	1
65-47856-12	1107-9	1
65-47856-13	1106-3	1
65-47856-14	1106-9	1
65-47856-15	1106-4	1
65-47856-16	1106-10	1
65-47856-17	1107-2	1
65-47856-18	1107-2	1
65-47856-19	1107-3	1
65-47856-2	1106-9	1
65-47856-20	1107-3	1
65-47856-21	1107-8	1

Part No.	Fig. and Index No.	Qty. per Assy.
65-47856-22	1107-8	1
65-47856-23	1107-9	1
65-47856-24	1107-9	1
65-47856-25	1107-4H	1
65-47856-27	1107-2	1
65-47856-28	1107-2	1
65-47856-29	1107-4H	1
65-47856-3	1106-4	1
65-47856-4	1106-10	1
65-47856-5	1107-2	1
65-47856-6	1107-2	1
65-47856-7	1107-3	1
65-47856-8	1107-3	1
65-47856-9	1107-8	1
65-47861-5	1104-12	4
65-47861-5	1104-95	
65-47861-501	1104-90	
65-47861-6	1104-150	
65-47861-6	1104-20	4
65-47861-7	1104-100	
65-47861-7	1104-13	1
65-47861-8	1104-155	
65-47861-8	1104-21	1
65-47861-9	1104-105	
65-47861-9	1104-16	1
65-47861-9	1104-160	
65-47861-9	1104-24	1
65-47870-111	1104-29	
65-47870-112	1104-29	
65-47870-112	1104-30	
65-47870-113	1104-215	
65-47870-115	1104-29	4
65-47870-116	1104-30	4
65-47870-145	1104-29	
65-47870-146	1104-29	
65-47870-146	1104-30	
65-47870-151	1104-29	
65-47870-152	1104-29	
65-47870-152	1104-30	
65-47870-153	1104-29	
65-47870-154	1104-29	
65-47870-154	1104-30	
65-47894-1	1109-5	4
65-47901-1	1102-8	2
65-47901-1	1105-113	2
65-49548-1	1108-184	1
65-49548-2	1108-185	1
65-50539-1	1101-10	1

Part No.	Fig. and Index No.	Qty. per Assy.
65-50539-2	1101-11	1
65-50539-2	1101-34	1
65-50539-4	1101-13	1
65-50539-4	1101-37	1
65-50539-5	1101-33	1
65-50539-6	1101-10	1
65-50539-6	1101-33	1
65-50539-7	1101-13	1
65-50539-7	1101-37	1
65-50585-10	1101-14	1
65-50585-11	1101-15	1
65-50585-13	1101-15	1
65-50585-14	1101-15	1
65-50585-15	1101-14	1
65-50585-16	1101-14	1
65-50585-17	1101-14	1
65-50585-18	1101-14	1
65-50585-19	1101-15	1
65-50585-20	1101-15	1
65-50585-6	1101-14	1
65-50585-7	1101-15	1
65-50585-8	1101-14	1
65-50585-9	1101-15	1
65-50588-10	1101-9	1
65-50588-19	1101-9	1
65-50588-20	1101-9	1
65-50588-5	1101-9	1
65-50588-6	1101-9	1
65-50588-7	1101-9	1
65-50588-9	1101-9	1
65-50708-15	1105-135	1
65-50708-15	1105-21	1
65-50708-29	1105-140	
65-50708-29	1105-25	1
65-50708-30	1105-140	
65-50708-30	1105-25	1
65-50708-33	1105-63	1
65-50708-34	1105-63	1
65-50708-40	1105-37	1
65-50708-41	1105-32	1
65-50708-47	1105-39	1
65-50708-49	1105-32	1
65-50708-50	1105-37	1
65-50708-7	1105-131	1
65-50708-7	1105-29	1
65-50708-8	1105-131A	1
65-50708-8	1105-29	1
65-50746-1	1102-7	1

Part No.	Fig. and Index No.	Qty. per Assy.
65-50746-1	1105-114	1
65-50756-6	1109-42	1
65-50756-7	1109-43	1
65-50756-8	1109-44	2
65-51622-13	1101-32	1
65-51622-14	1101-32	1
65-51622-3	1101-32	1
65-51622-4	1101-32	1
65-51622-5	1101-32	1
65-51622-6	1101-32	1
65-52211-1	1107-122	1
65-52211-2	1107-122	1
65-52233-13	1105-154	1
65-52233-14	1105-154	1
65-52246-1	1105-2	1
65-52246-1	1107-	RF
65-52246-10	1107-1	1
65-52246-11	1107-7	1
65-52246-12	1107-7	1
65-52246-13	1107-1	1
65-52246-14	1107-1	1
65-52246-15	1107-7	1
65-52246-16	1107-7	1
65-52246-17	1107-1	1
65-52246-18	1107-1	1
65-52246-2	1105-2	1
65-52246-2	1107-	RF
65-52246-3	1107-1	1
65-52246-4	1107-1	1
65-52246-5	1107-7	1
65-52246-6	1107-7	1
65-52246-7	1105-2	1
65-52246-7	1105-2	1
65-52246-7	1107-	RF
65-52246-8	1105-2	1
65-52246-8	1105-2	1
65-52246-8	1107-	RF
65-52246-9	1107-1	1
65-55513-7	1108-19	1
65-55513-8	1108-19	1
65-55540-1	1105-162	1
65-55540-1	1108-	RF
65-55540-11	1108-126	1
65-55540-12	1108-126	1
65-55540-13	1108-126	1
65-55540-14	1108-126	1
65-55540-17	1108-126	1
65-55540-18	1108-126	1

Part No.	Fig. and Index No.	Qty. per Assy.
65-55540-19	1105-162	1
65-55540-19	1108-	RF
65-55540-2	1105-162	1
65-55540-2	1108-	RF
65-55540-20	1105-162	1
65-55540-20	1108-	RF
65-55540-21	1108-126	1
65-55540-22	1108-126	1
65-55540-23	1108-113A	4
65-55540-25	1105-162	1
65-55540-25	1108-	RF
65-55540-26	1105-162	1
65-55540-26	1108-	RF
65-55540-27	1105-162	1
65-55540-27	1108-	RF
65-55540-28	1105-162	1
65-55540-28	1108-	RF
65-55540-3	1108-126	1
65-55540-4	1108-126	1
65-55540-7	1108-20	1
65-55541-10	1108-51	1
65-55541-11	1108-51	1
65-55541-12	1108-51	1
65-55541-3	1108-51	1
65-55541-4	1108-51	1
65-55541-5	1108-51	1
65-55541-6	1108-51	1
65-55541-7	1108-51	1
65-55541-7	1108-51	1
65-55541-8	1108-51	1
65-55541-8	1108-51	1
65-55541-9	1108-51	1
65-55547-1	1108-77	1
65-55547-10	1108-77	1
65-55547-2	1108-77	1
65-55547-3	1108-78	1
65-55547-4	1108-78	1
65-55547-9	1108-77	1
65-55549-1	1108-8	1
65-55549-2	1108-8	1
65-55549-3	1108-9	1
65-55549-4	1108-9	1
65-55550-3	1108-137	1
65-55550-4	1108-137	1
65-55550-5	1108-136	1
65-55550-6	1108-136	1
65-55551-1	1108-158	1
65-55551-10	1108-158	1

Part No.	Fig. and Index No.	Qty. per Assy.
65-55551-11	1108-158	1
65-55551-11	1108-158	1
65-55551-12	1108-158	1
65-55551-12	1108-158	1
65-55551-13	1108-159	1
65-55551-14	1108-159	1
65-55551-15	1108-158	1
65-55551-16	1108-158	1
65-55551-17	1108-159	1
65-55551-18	1108-159	1
65-55551-2	1108-158	1
65-55551-5	1108-159	1
65-55551-6	1108-159	1
65-55551-7	1108-159	1
65-55551-8	1108-159	1
65-55551-9	1108-158	1
65-55552-1	1108-194	1
65-55552-2	1108-195	1
65-55552-3	1108-196	1
65-55552-4	1108-194	1
65-55552-5	1108-195	1
65-55552-6	1108-194	1
65-55552-7	1108-195	1
65-55554-23	1108-148	1
65-55554-24	1108-148	1
65-55554-27	1108-149	1
65-55554-28	1108-149	1
65-55554-29	1108-150	4
65-55588-1	1108-162	1
65-55588-4	1108-163	1
65-55588-5	1108-162	1
65-55588-6	1108-163	1
65-55588-8	1108-162	1
65-67105-14	1105-106	1
65-67138-1	1106-3	1
65-67138-10	1107-8	1
65-67138-11	1107-9	1
65-67138-12	1107-9	1
65-67138-2	1106-9	1
65-67138-3	1106-4	1
65-67138-4	1106-10	1
65-67138-5	1107-2	1
65-67138-6	1107-2	1
65-67138-7	1107-3	1
65-67138-8	1107-3	1
65-67138-9	1107-8	1
65-68278-23	1102-90	1
65-68278-24	1102-90	1

Part No.	Fig. and Index No.	Qty. per Assy.
65-68278-25	1102-84	1
65-68278-25	1102-91	1
65-68278-34	1102-92	1
65-68278-44	1102-86	1
65-68278-44	1102-93	1
65-68278-57	1102-83	1
65-68278-58	1102-83	1
65-68278-59	1102-115	
65-68278-60	1102-115	
65-68278-61	1102-85	1
65-68278-62	1102-84	1
65-68278-62	1102-91	1
65-68278-65	1102-83	1
65-68278-66	1102-83	1
65-68278-67	1102-90	1
65-68278-68	1102-90	1
65-68296-1	1106-120	1
65-68296-2	1106-120	1
65-68296-3	1106-121	1
65-68296-4	1106-121	1
65-68296-5	1106-122	2
65-68297-1	1105-1	1
65-68297-1	1106-	RF
65-68297-13	1105-1	1
65-68297-13	1106-	RF
65-68297-14	1105-1	1
65-68297-14	1106-	RF
65-68297-2	1105-1	1
65-68297-2	1106-	RF
65-68297-3	1105-1	1
65-68297-3	1106-	RF
65-68297-4	1105-1	1
65-68297-4	1106-	RF
65-68297-5	1106-1	1
65-68297-6	1106-1	1
65-68297-7	1106-1	1
65-68297-8	1106-1	1
65-68297-8	1106-1	1
65-71902-1	1101-2	1
65-71902-1	1105-	RF
65-71902-10	1101-2	1
65-71902-10	1105-	RF
65-71902-11	1101-2	1
65-71902-11	1105-	RF
65-71902-12	1101-2	1
65-71902-12	1105-	RF
65-71902-13	1101-2	1

Part No.	Fig. and Index No.	Qty. per Assy.
65-71902-13	1105-	RF
65-71902-14	1101-2	1
65-71902-14	1105-	RF
65-71902-15	1101-2	1
65-71902-15	1105-	RF
65-71902-16	1101-2	1
65-71902-16	1105-	RF
65-71902-17	1101-2	1
65-71902-17	1105-	RF
65-71902-18	1101-2	1
65-71902-18	1105-	RF
65-71902-18	1105-	RF
65-71902-19	1101-2	1
65-71902-19	1105-	RF
65-71902-2	1101-2	1
65-71902-2	1105-	RF
65-71902-20	1101-2	1
65-71902-20	1105-	RF
65-71902-21	1101-2	1
65-71902-21	1105-	RF
65-71902-22	1101-2	1
65-71902-22	1105-	RF
65-71902-23	1101-2	1
65-71902-23	1105-	RF
65-71902-24	1101-2	1
65-71902-24	1105-	RF
65-71902-25	1101-2	1
65-71902-25	1105-	RF
65-71902-26	1101-2	1
65-71902-26	1105-	RF
65-71902-3	1101-2	1
65-71902-3	1105-	RF
65-71902-31	1101-2	1
65-71902-31	1105-	RF
65-71902-32	1101-2	1
65-71902-32	1105-	RF
65-71902-33	1101-2	1
65-71902-33	1105-	RF
65-71902-34	1101-2	1
65-71902-34	1105-	RF
65-71902-35	1101-2	1
65-71902-35	1105-	RF
65-71902-36	1101-2	1
65-71902-36	1105-	RF
65-71902-4	1101-2	1
65-71902-4	1105-	RF
65-71902-41	1101-2	1
65-71902-41	1105-	RF

Part No.	Fig. and Index No.	Qty. per Assy.
65-71902-42	1101-2	1
65-71902-42	1105-	RF
65-71902-43	1101-2	1
65-71902-43	1105-	RF
65-71902-44	1101-2	1
65-71902-44	1105-	RF
65-71902-45	1101-2	1
65-71902-45	1105-	RF
65-71902-46	1101-2	1
65-71902-46	1105-	RF
65-71902-49SP	1101-2	1
65-71902-49SP	1105-	RF
65-71902-50SP	1101-2	1
65-71902-50SP	1105-	RF
65-71902-9	1101-2	1
65-71902-9	1105-	RF
65-71903-10	1105-109	1
65-71903-10	1105-109	1
65-71903-11	1105-109	1
65-71903-12	1105-109	1
65-71903-5	1105-109	1
65-71903-6	1105-109	1
65-71903-9	1105-109	1
65-71903-9	1105-109	1
65-71904-10	1105-86	1
65-71904-11	1105-87	1
65-71904-12	1105-81	1
65-71904-13	1105-82	1
65-71904-14	1105-76	1
65-71904-15	1105-77	1
65-71904-7	1105-88	1
65-71904-8	1105-89	1
65-71904-9	1105-86	1
65-71908-1	1103-1	1
65-71908-11	1103-6	1
65-71908-12	1103-6	.1
65-71908-13	1103-6	1
65-71908-14	1103-6	.1
65-71908-2	1103-1	1
65-71908-3	1103-5	1
65-71908-4	1103-5	1
65-71908-7	1103-5	1
65-71908-8	1103-5	1
65-71926-1	1101-4	1
65-71926-1	1103-	RF
65-71926-2	1101-4	1
65-71926-2	1103-	RF
65-71926-59	1101-4	1

Part No.	Fig. and Index No.	Qty. per Assy.
65-71926-59	1103-	RF
65-71926-60	1101-4	1
65-71926-60	1103-	RF
65-71926-65	1101-4	1
65-71926-65	1103-	RF
65-71926-66	1101-4	1
65-71926-66	1103-	RF
65-71926-67	1101-4	1
65-71926-67	1103-	RF
65-71926-68	1101-4	1
65-71926-68	1103-	RF
65-71926-77	1101-4	1
65-71926-77	1103-	RF
65-71926-78	1101-4	1
65-71926-78	1103-	RF
65-71939-1	1104-63	1
65-71939-2	1104-63	1
65-71940-15	1101-	RF
65-71940-16	1101-	RF
65-71940-17	1101-	RF
65-71940-18	1101-	RF
65-71940-19	1101-3	1
65-71940-19	1104-	RF
65-71940-20	1101-3	1
65-71940-20	1104-	RF
65-71940-21	1101-2	1
65-71940-21	1105-	RF
65-71940-22	1101-2	1
65-71940-22	1105-	RF
65-71940-23	1101-1	1
65-71940-23	1102-	RF
65-71940-24	1101-1	1
65-71940-24	1102-	RF
65-71940-25	1101-2	1
65-71940-25	1105-	RF
65-71940-26	1101-2	1
65-71940-26	1105-	RF
65-71940-27	1101-	RF
65-71940-28	1101-	RF
65-71940-29	1101-3	1
65-71940-29	1104-	RF
65-71940-30	1101-3	1
65-71940-30	1104-	RF
65-71940-31	1101-2	1
65-71940-31	1105-	RF
65-71940-32	1101-2	1
65-71940-32	1105-	RF
65-71940-33	1101-1	1

Part No.	Fig. and Index No.	Qty. per Assy.
65-71940-33	1102-	RF
65-71940-34	1101-1	1
65-71940-34	1102-	RF
65-71940-35	1101-	RF
65-71940-36	1101-	RF
65-71940-37	1101-2	1
65-71940-37	1105-	RF
65-71940-38	1101-2	1
65-71940-38	1105-	RF
65-71940-41	1101-2	1
65-71940-41	1105-	RF
65-71940-42	1101-2	1
65-71940-42	1105-	RF
65-71965-11	1105-65	1
65-71965-12	1105-65	1
65-71965-14	1105-72	1
65-71965-15	1105-64	1
65-71965-16	1105-64	1
65-71965-17	1105-65	1
65-71965-18	1105-65	1
65-71965-19	1105-48	1
65-71965-20	1105-48	1
65-71965-3	1105-66	1
65-71965-4	1105-66	1
65-71965-5	1105-49	1
65-71965-6	1105-49	1
65-71969-1	1101-	RF
65-71969-2	1101-	RF
65-71969-3	1101-	RF
65-71969-4	1101-	RF
65-71970-1	1101-3	1
65-71970-1	1104-	RF
65-71970-2	1101-3	1
65-71970-2	1104-	RF
65-71971-1	1101-2	1
65-71971-1	1105-	RF
65-71971-103	1105-99	1
65-71971-104	1105-99	1
65-71971-133	1101-2	1
65-71971-133	1105-	RF
65-71971-134	1101-2	1
65-71971-134	1105-	RF
65-71971-135	1101-2	1
65-71971-135	1105-	RF
65-71971-136	1101-2	1
65-71971-136	1105-	RF
65-71971-2	1101-2	1
65-71971-2	1105-	RF

Part No.	Fig. and Index No.	Qty. per Assy.
65-71971-3	1101-2	1
65-71971-3	1105-	RF
65-71971-4	1101-2	1
65-71971-4	1105-	RF
65-71978-1	1101-1	1
65-71978-1	1102-	RF
65-71978-2	1101-1	1
65-71978-2	1102-	RF
65-71993-19	1105-163	1
65-71993-20	1105-163	1
65-71993-21	1105-165	1
65-76102-1	1102-37	1
65-76102-1	1102-37	1
65-76102-2	1102-37	1
65-76102-2	1102-37	1
65-76102-3	1102-37	1
65-76102-4	1102-37	1
65-76115-10	1105-64	1
65-76115-11	1105-64	1
65-76115-12	1105-64	1
65-76115-13	1105-65B	1
65-76115-14	1105-65B	1
65-76115-15	1105-65	1
65-76115-16	1105-65	1
65-76115-17	1105-64	1
65-76115-18	1105-64	1
65-76115-19	1105-65	1
65-76115-20	1105-65	1
65-76115-21	1105-64	1
65-76115-22	1105-64	1
65-76115-3	1105-65	1
65-76115-4	1105-65	1
65-76115-7	1105-64	1
65-76115-8	1105-64	1
65-76115-9	1105-64	1
65-79953-1	1105-3A	1
65-79953-10	1105-3A	1
65-79953-2	1105-3A	1
65-79953-9	1105-3A	1
65-79954-1	1105-3C	1
65-79954-2	1105-3C	1
65-90854-1	1102-51	2
65-90854-3	1102-52	1
65C10543-1	1105-143	1
65C10543-17	1105-143	1
65C10543-18	1105-143	1
65C10543-2	1105-143	1
65C10543-27	1105-143	1

Part No.	Fig. and Index No.	Qty. per Assy.
65C10543-28	1105-143	1
65C10543-43	1105-143	1
65C10543-44	1105-143	1
65C10543-5	1105-141	1
65C10543-6	1105-141	1
65C10544-1	1105-126	1
65C10544-11	1105-126	1
65C10544-12	1105-126	1
65C10544-13	1105-126	1
65C10544-14	1105-126	1
65C10544-2	1105-126	1
65C10544-23	1105-126	1
65C10544-24	1105-126	1
65C10544-3	1105-130	1
65C10544-4	1105-146	1
65C10544-5	1105-131	1
65C10544-501	1105-140	1
65C10544-502	1105-140	1
65C10544-6	1105-131A	1
65C10544-7	1105-147	1
65C10544-8	1105-144	1
65C10544-9	1105-145	1
65C26310-11	1101-2	
65C26310-12	1101-2	
65C26310-13	1101-2	
65C26310-14	1101-2	
65C26310-7	1101-2	
65C26310-8	1101-2	
65C26311-29	1101-70	1
65C26311-30	1101-70	1
65C26311-511	1101-70	1
65C26311-512	1101-70	1
65C26311-73	1101-70	1
65C26311-74	1101-70	1
65C26311-81	1101-70	1
65C26311-82	1101-70	1
65C27575-11	1101-75	1
65C27575-12	1101-75	1
65C32620-1	1102-120	
65C32620-11	1102-120	
65C32620-12	1102-120	
65C32620-2	1102-120	
65C33100-1	1102-30	1
65C33100-3	1102-30	1
65C33100-4	1102-30	1
65C33274-1	1105-152	1
65C33274-1	1105-152	1
65C33274-3	1105-152	1

Part No.	Fig. and Index No.	Qty. per Assy.
65C36873-1	1105-152	1
65C37022-1	1102-61	1
65C37022-1	1102-64	1
66-19144-1	1106-37	2
66-19144-1	1106-52	1
66-19144-1	1106-64	1
66-19144-1	1107-33	2
66-19144-1	1107-48	1
66-19144-1	1107-60	1
66-19144-2	1106-37	2
66-19144-2	1106-52	1
66-19144-2	1106-64	1
66-19144-2	1107-33	2
66-19144-2	1107-48	1
66-19144-2	1107-60	1
66-23212-1	1102-20	1
66-23212-2	1102-21	1
66-23218-1	1107-111	1
66-23218-2	1107-111	1
66-23219-1	1107-126	1
66-23219-2	1107-126	1
66-23219-3	1107-126	1
66-23219-4	1107-126	1
66-23219-5	1107-126	1
66-23219-6	1107-126	1
66-23220-1	1106-32	1
66-23220-1	1107-28	1
66-23220-3	1106-33	1
66-23220-3	1107-29	1
66-23226-1	1106-101	1
66-23226-1	1107-92	1
66-23233-1	1106-28	2
66-23233-1	1107-24	2
66-23236-1	1106-38	2
66-23236-1	1106-53	1
66-23236-1	1106-65	1
66-23236-1	1107-34	2
66-23236-1	1107-49	1
66-23236-1	1107-61	1
66-23236-3	1106-39	1
66-23236-3	1106-54	1
66-23236-3	1106-66	1
66-23236-3	1107-35	1
66-23236-3	1107-50	1
66-23236-3	1107-62	1
66-24115-1	1101-17	1
66-24116-1	1101-28	1
66-24116-1	1101-48	1

Part No.	Fig. and Index No.	Qty. per Assy.
66-24503-1	1109-41	1
66-24505-5	1106-47	1
66-24505-5	1107-43	1
66-24505-6	1106-59	1
66-24505-6	1107-55	1
66-24505-7	1106-47	1
66-24505-8	1106-59	1
66-24530-1	1109-52	1
66-24530-1	1109-55	1
66-24530-1	1109-62	1
66-24530-1	1109-65	1
66-26119-2	1102-40	1
66-26119-3	1102-41	2
66-26119-4	1102-125	
66-26119-5	1102-125	
69-35329-1	1102-30	1
69-35336-1	1102-18	2
69-35336-1	1102-18	2
69-35336-2	1102-118	2
69-35336-2	1102-18	2
69-35336-3	1102-18	4
69-35349-1	1102-51	2
69-35349-3	1102-52	1
69-35349-5	1102-130	
69-35349-7	1102-130	
69-37206-1	1107-107	1
69-37206-6	1107-107	1
69-37206-7	1107-107	1
69-37206-8	1107-107	1
69-37208-10	1106-100	1
69-37208-7	1106-99	1
69-37208-8	1106-99	1
69-37208-9	1106-100	1
69-37209-10	1106-84	1
69-37209-3	1106-84	1
69-37209-4	1106-84	1
69-37209-5	1106-84	1
69-37209-6	1106-84	1
69-37209-7	1106-84	1
69-37209-8	1106-84	1
69-37209-9	1106-84	1
69-37233-1	1102-135	
69-37234-12	1104-110	
69-37234-12	1104-15	1
69-37234-12	1104-165	
69-37234-12	1104-23	1
69-37234-14	1104-115	
69-37234-14	1104-14	1

Part No.	Fig. and Index No.	Qty. per Assy.
69-37234-14	1104-170	
69-37234-14	1104-22	1
69-37234-21	1104-43	16
69-37234-23	1104-43	16
69-37813-1	1102-135	
69-37815-1	1102-140	
69-37815-10	1102-74	1
69-37815-5	1102-73	1
69-37815-7	1102-70	1
69-37815-8	1102-70	1
69-37815-9	1102-74	1
69-37860-1	1106-29	1
69-37860-1	1107-25	1
69-37869-2	1106-48	1
69-37869-2	1106-60	1
69-37869-2	1107-44	1
69-37869-2	1107-56	1
69-37961-1	1101-25	1
69-37961-1	1101-47	1
69-37961-2	1101-25	1
69-37961-2	1101-47	1
69-37962-1	1101-21	1
69-37962-1	1101-41	1
69-37962-2	1101-12	1
69-37962-2	1101-35	1
69-38802-10	1102-62	2
69-38802-11	1102-60	1
69-38802-12	1102-63	1
69-38802-3	1102-59	2
69-38802-3	1102-59	2
69-38802-4	1102-62	2
69-38802-4	1102-62	2
69-38802-5	1102-60	2
69-38802-6	1102-63	1
69-38802-7	1102-61	1
69-38802-7	1102-64	1
69-38802-9	1102-59	2
69-38829-2	1104-40	16
69-38830-2	1104-41	16
69-38830-5	1104-41	16
69-38848-1	1106-20	1
69-38848-1	1107-19	1
69-38848-2	1106-21	1
69-38848-2	1107-20	1
69-38848-5	1106-20	1
69-38848-5	1106-20	1
69-38848-5	1107-19	1
69-38848-5	1107-19	1

Part No.	Fig. and Index No.	Qty. per Assy.
69-38848-6	1106-21	1
69-38848-6	1106-21	1
69-38848-6	1107-20	1
69-38848-6	1107-20	1
69-38849-3	1104-6	4
69-38849-4	1104-7	1
69-38868-1	1109-12	1
69-38868-2	1109-17	1
69-38868-3	1109-18	1
69-38869-1	1109-26	1
69-38869-3	1109-26A	1
69-38871-1	1104-46	1
69-38871-2	1104-47	1
69-38871-3	1104-46	
69-38871-3	1104-46	2
69-38871-4	1104-47	1
69-39211-1	1102-135	
69-39211-2	1102-135	
69-39211-3	1102-135	
69-39211-4	1102-135	
69-39219-1	1104-120	
69-39219-1	1104-17	1
69-39219-1	1104-175	
69-39219-1	1104-25	1
69-39219-3	1104-125	
69-39219-3	1104-18	1
69-39219-3	1104-180	
69-39219-3	1104-26	1
69-39219-501	1104-135	
69-39219-501	1104-190	
69-39219-502	1104-140	
69-39219-502	1104-195	
69-39223-1	1109-50	1
69-39223-10	1109-53	1
69-39223-11	1109-60	1
69-39223-12	1109-63	1
69-39223-13	1109-51	1
69-39223-14	1109-54	1
69-39223-15	1109-61	1
69-39223-16	1109-64	1
69-39223-2	1109-53	1
69-39223-3	1109-51	1
69-39223-4	1109-54	1
69-39223-5	1109-60	1
69-39223-6	1109-63	1
69-39223-7	1109-61	1
69-39223-8	1109-64	1
69-39223-9	1109-50	1

Part No.	Fig. and Index No.	Qty. per Assy.
69-39230-1	1106-25	1
69-39233-1	1107-102	1
69-39233-2	1106-73	1
69-39233-3	1106-73	1
69-39233-3	1107-102	1
69-39233-4	1106-73	1
69-39293-1	1104-44	16
69-40642-1	1107-120	1
69-40642-2	1107-121	1
69-40642-3	1107-115	1
69-40642-4	1107-116	1
69-40642-5	1106-91	1
69-40642-5	1107-84	1
69-40642-6	1106-92	1
69-40642-6	1107-85	1
69-40642-7	1106-115	1
69-40642-8	1106-116	1
69-40657-10	1107-76	1
69-40657-11	1107-77	1
69-40657-12	1107-77	1
69-40657-5	1107-76	1
69-40657-5	1107-76	1
69-40657-6	1107-76	1
69-40657-6	1107-76	1
69-40657-7	1107-77	1
69-40657-8	1107-77	1
69-40657-9	1107-76	1
69-40658-1	1107-90	1
69-40658-2	1107-90	1
69-40658-3	1107-91	1
69-40658-4	1107-91	1
69-40659-1	1106-46	1
69-40659-1	1107-42	1
69-40659-2	1106-58	1
69-40659-2	1107-54	1
69-40659-3	1106-46	1
69-40659-4	1106-58	1
69-40665-1	1107-101	1
69-40665-2	1107-101	1
69-42324-1	1104-210	1
69-42324-1	1104-210	1
69-42324-3	1104-210	1
69-42324-3	1104-210	1
69-42324-3	1104-210	1
69-42324-3	1104-210	1
69-42324-3	1104-210	1
69-42324-3	1104-210	1

Part No.	Fig. and Index No.	Qty. per Assy.
69-42328-1	1104-1	4
69-42328-1	1104-1	
69-42328-1	1104-1	
69-42328-1	1104-1	
69-42328-13	1104-1	4
69-42328-15	1104-1	
69-42328-15	1104-1	
69-42328-15	1104-1	
69-42328-18	1104-1	4
69-42328-2	1104-1	
69-42343-1	1108-70	
69-42343-10	1108-70	
69-42343-11	1108-70A	1
69-42343-12	1108-70A	1
69-42343-2	1108-70	1
69-42343-3	1108-70A	1
69-42343-4	1108-70A	1
69-42343-5	1108-70	1
69-42343-6	1108-70	1
69-42343-7	1108-70A	1
69-42343-8	1108-70A	1
69-42343-9	1108-70	1
69-42345-3	1108-21	1
69-42346-1	1108-54	1
69-42346-10	1108-54	1
69-42346-11	1108-55	1
69-42346-12	1108-55	1
69-42346-2	1108-54	1
69-42346-3	1108-55	1
69-42346-4	1108-55	1
69-42346-5	1108-54	1
69-42346-6	1108-54	1
69-42346-7	1108-55	1
69-42346-8	1108-55	1
69-42346-9	1108-54	1
69-42347-1	1108-69	1
69-42349-3	1108-52	1
69-42349-4	1108-52	1
69-42351-1	1109-70	1
69-42384-1	1108-172	6
69-42384-2	1108-172	
69-42385-1	1108-178	
69-42385-2	1108-178	
69-42386-1	1108-176	1
69-42386-2	1108-176	1
69-42964-1	1101-45	1
69-42965-1	1101-8	1
69-42970-1	1101-54	3

Part No.	Fig. and Index No.	Qty. per Assy.
69-43120-1	1101-50	1
69-43120-2	1101-50	1
69-43120-3	1101-50	1
69-43120-4	1101-50	1
69-43120-5	1101-50	1
69-43120-6	1101-50	1
69-43121-1	1101-52	1
69-43121-2	1101-52	1
69-43121-3	1101-52	1
69-43121-4	1101-52	1
69-43122-1	1101-36	1
69-43122-1	1101-49	1
69-43122-2	1101-29	1
69-43122-3	1101-53	3
69-43122-5	1101-29	1
69-43122-6	1101-49	1
69-43531-15	1108-109	2
69-43531-16	1108-109	1
69-43531-17	1108-110	1
69-43531-21	1108-110	1
69-43531-22	1108-109	1
69-43531-25	1108-110	1
69-43531-25	1108-110	1
69-43531-26	1108-109	1
69-43531-26	1108-109	1
69-43531-27	1108-112	2
69-43531-28	1108-113	2
69-43531-33	1108-112	2
69-43531-33	1108-112	2
69-43531-34	1108-113	2
69-43531-34	1108-113	2
69-43531-37	1108-112	2
69-43531-38	1108-113	2
69-43531-4	1108-112	2
69-43531-5	1108-113	2
69-43532-1	1108-11	1
69-43532-2	1108-12	1
69-43564-1	1108-120	1
69-43564-1	1108-203	1
69-43564-2	1108-121	1
69-43564-2	1108-204	1
69-43564-3	1108-170	1
69-43564-4	1108-171	1
69-43564-5	1108-171	1
69-43572-1	1108-53	1
69-43572-3	1108-53	1
69-43599-1	1108-116	1
69-43599-1	1108-199	1

Part No.	Fig. and Index No.	Qty. per Assy.
69-43599-3	1108-117	1
69-43599-3	1108-200	1
69-44940-1	1108-101	1
69-44965-1	1108-177	1
69-44969-10	1107-67	
69-44969-11	1106-75	1
69-44969-11	1106-75	1
69-44969-12	1106-75	1
69-44969-12	1106-75	1
69-44969-15	1106-74	1
69-44969-16	1106-74	1
69-44969-5	1106-74	1
69-44969-5	1107-66	
69-44969-6	1106-74	1
69-44969-6	1107-66	
69-44969-7	1106-75	1
69-44969-8	1106-75	1
69-44969-9	1107-67	
69-44992-1	1109-31	1
69-44994-1	1108-175	1
69-44994-2	1108-175	1
69-46447-1	1106-13	1
69-46447-1	1106-7	1
69-46447-1	1107-12	1
69-46447-1	1107-6	1
69-46451-1	1108-174	1
69-46457-1	1102-135	
69-46457-2	1102-135	
69-46493-1	1106-43	2
69-46493-1	1106-56	1
69-46493-1	1106-68	1
69-46493-1	1107-39	2
69-46493-1	1107-52	1
69-46493-1	1107-64	1
69-46493-2	1106-57	1
69-46493-2	1106-69	1
69-46493-2	1107-53	1
69-46493-2	1107-65	1
69-52260-2	1101-24	1
69-52260-2	1101-44	1
69-54946-2	1105-124	1
69-54946-2	1105-152	1
69-54946-3	1105-152	1
69-54946-4	1105-152	1
69-54946-4	1105-152	1
69-54968-1	1108-157	1
69-54968-2	1108-157	1
69-54984-1	1106-111	1

Part No.	Fig. and Index No.	Qty. per Assy.
69-54984-1	1107-107	1
69-54984-2	1106-111	1
69-54984-2	1107-107	1
69-54986-1	1106-125	1
69-54986-2	1106-125	1
69-54987-1	1106-114	1
69-54987-2	1106-114	1
69-57808-1	1108-139	1
69-57808-2	1108-140	1
69-57819-2	1103-8	4
69-57840-1	1105-18	1
69-57855-1	1102-36	1
69-57855-1	1105-62	2
69-57889-1	1105-71	1
69-57889-10	1105-74	1
69-57889-11	1105-71	1
69-57889-12	1105-71	1
69-57889-2	1105-71	1
69-57889-3	1105-52	1
69-57889-4	1105-50	1
69-57889-5	1105-74	1
69-57889-6	1105-74	1
69-57889-9	1105-74	1
69-57891-1	1105-42	1
69-59830-1	1102-34	1
69-59831-1	1108-152	1
69-59832-11	1108-149	1
69-59832-12	1108-149	1
69-59832-13	1108-150	4
69-59832-5	1108-148	1
69-59832-6	1108-148	1
69-61980-1	1105-3D	1
69-61980-2	1105-3H	1
69-61980-3	1105-44A	1
69-61980-4	1105-3E	1
69-61980-5	1105-31	1
69-61980-6	1105-44B	1
69-67279-1	1105-158	1
69-67279-2	1105-158	1
69-67279-3	1105-161	1
69-67279-4	1105-161	1
69-73105-1	1102-145	
69-73105-2	1102-145	
69-73105-7	1102-145	
69-73105-8	1102-145	
69-76975-1	1102-150	
69-76975-2	1102-150	
69-76976-1	1102-150	

Part No.	Fig. and Index No.	Qty. per Assy.
69-76976-2	1102-150	
69-76976-3	1102-150	
69-76976-4	1102-150	
69-76976-5	1102-150	
69-76976-6	1102-150	
69-76977-1	1102-150	
69-76977-2	1102-150	
69-77698-1	1102-20	1
69-78026-1	1102-155	
69-78026-2	1102-155	
69-78026-3	1102-155	
69-78026-4	1102-155	
69-78112-1	1102-155	
69-78112-2	1102-155	
69-78112-3	1102-155	
69-78112-4	1102-155	
69-78357-1	1107-4H	1
69-78357-2	1107-4H	1
69-78710-1	1104-52	
69-78710-2	1104-53	
69-78710-3	1104-52	
69-78710-4	1104-51	
69-78776-1	1102-160	
7219-12	1108-47	2
77519	1108-66	1
90853	1103-9	4