TO: ALL HOLDERS OF OUTBOARD FLAP CARRIAGE ASSEMBLY OVERHAUL MANUAL, 57-53-35

REVISION NO. 56, DATED MAR 1/07

HIGHLIGHTS

DESCRIPTION OF CHANGE	TOPICS AFFECTED												
	D&O	D/Assy	Cleaning	Insp/Chk	Repair	Assy	F/C	Test	T/Shooting	S/Tools	Storage	IPL	L/Overhaul
Updated Repair procedure to incorporate improved repair procedures					X								

OUTBOARD FLAP CARRIAGE ASSEMBLY

57-53-35

BOEING P/N 65-46481-1, -8, -11 thru -28, -31 thru -34, -37 thru -42,-45 thru -70, -72 thru -76, -81 thru -86, -95, -96
65-79949-1 thru -10

AIRLINE P/N

THE FOLLOWING DIRECTIVES APPLY TO THIS SUBJECT:

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVES	DATE DIRECTIVE INCORPORATED INTO TEXT
57-1007, Rev 1		RC 10054	Aug 15/69
		RC 10251	Aug 15/69
		PRR 31718-3	Jun 10/71
		PRR 31779	Jun 10/71
57-1055		PRR 31982	Jun 10/71
57-1060		PRR 31994	Jun 10/71
		RC 10952	Jun 10/71
57-1066		PRR 32085	Mar 10/72
		RR 97025-8	Mar 10/72
		PRR 32185	Dec 25/72
57-1055, Rev 1			Mar 25/73
		PRR 32168	Dec 25/73
57-1060, Rev 2			Sep 25/74
57-1055, STATUS CHANGE			Dec 25/74
57-1085		PRR 32382	Mar 25/75
		PRR 32427	Jun 25/75
		PRR 32447-R	Jun 25/75
57-1091			Jun 25/75
		PRR 32523	Dec 25/75
57-1091, Rev 1			Dec 25/75
57-1092			Dec 25/75

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVES	DATE DIRECTIVE INCORPORATED INTO TEXT
57-1096			Dec 25/75
		PRR 32496-19	Jan 5/77
		PRR 32689	Jul 5/79
		PRR 32872	Jul 5/79
		PRR 32876	Jul 5/79
		PRR 32914	Jul 5/79
57-1092, Rev 1			Jan 5/80
		PRR 33043	Jan 5/81
		PRR 33125	Jul 5/81
57-1127			Jul 5/81
57-1127, Rev 1			Jul 5/82
		PRR 33498	Sep 5/84
57-1092, Rev 2			Jun 5/86
57-1127, Rev 2			Jun 5/86
57-1112, Rev 5			Dec 5/86
57-1218		PRR 35014	Jun 1/94
	57-28		Mar 1/97
	57-29		Mar 1/00
57-1066, Rev 3			Nov 1/03
57-1085, Rev 2			Nov 1/03
57-1092, Rev 3			Nov 1/03
57-1112, Rev 6			Nov 1/03
57A1218, Rev 3			Nov 1/03

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
	57-53-35		*	417	Mar 1/07		1122	Nov 1/03
	T-1	Nov 1/03		418	BLANK		1122A	Nov 1/03
	T-2	Nov 1/03		501	Nov 1/03		1122B	BLANK
*	LEP-1	Mar 1/07		502	Sep 5/89		1123	Nov 1/03
	LEP-2	BLANK		502A	Nov 1/03		1124	Jun 5/86
	T/C-1	Sep 25/74		502B	Mar 1/96		1125	Jun 5/86
	T/C-2	BLANK		502C	Sep 5/89		1126	Dec 1/94
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	2	Aug 15/69		503	Jun 5/86		1128	Mar 1/05
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*	405	Mar 1/07		1102	Jul 5/79		1141	Nov 1/03
	406	Dec 1/95		1103	Jul 5/79		1142	Nov 1/03
	406A	Jul 1/98		1104	Mar 5/90		1143	Nov 1/03
	406B	Dec 1/95		1105	Mar 1/05		1144	Nov 1/03
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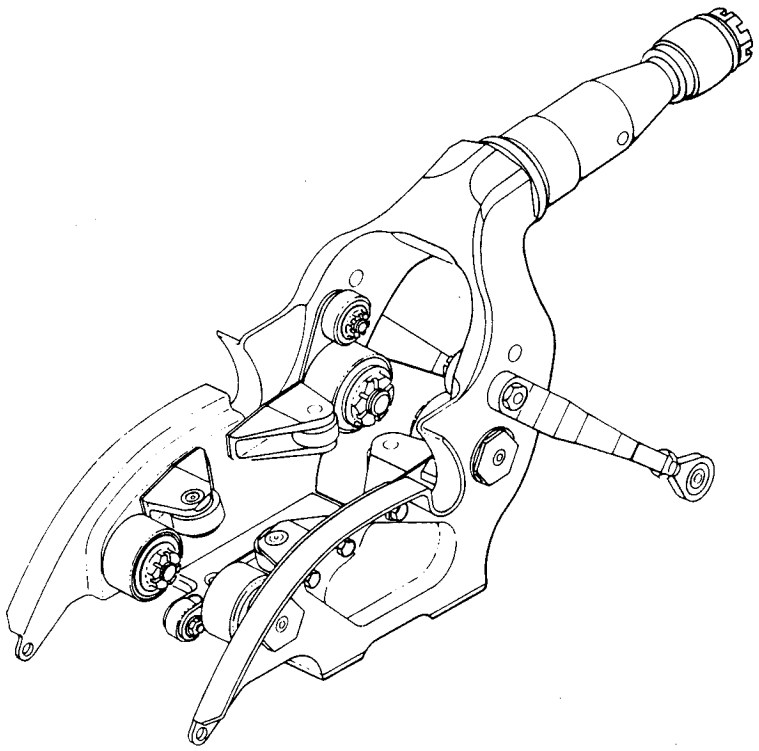
OUTBOARD FLAP CARRIAGE ASSEMBLY



Outboard Flap Carriage Assembly
Figure 1

DESCRIPTION AND OPERATION

1. Description

   A. The outboard flap carriage assembly consists of four bolt assemblies, two strut assemblies, two forward track roller bearings, two aft track roller bearings, two forward side roller assemblies, and two aft side roller assemblies mounted on a carriage assembly.

2. Operation

A. Four rollers on the carriage assembly support the flap on the flap track. Two side rollers provide lateral carriage alignment on the flap track. A detent on each side of the carriage retains a toggle switch which aids in flap extension.

3. Leading Particulars

Width -- 6.75 inches (approximately)
Length -- 21.00 inches (approximately)
Height -- 8.50 inches (approximately)
Weight -- 27.00 pounds (approximately)

DISASSEMBLY

Note: Item numbers apply to Fig. 1101, 1102 and 1103 except as noted.

1. Remove cotter pins (1), nuts (2), washers (3 and 5), bearings (4, 4A), washers (8A and 8B), if applicable, bolt assemblies (6), and applicable strut assemblies (9, 16, or 28) from carriage assembly (109).

   NOTE: Do not remove lubrication fitting (7) from bolts (8) unless repair or replacement is necessary.

2. Remove parts from applicable strut assemblies (9, 16, 28 or 113) as follows:

   A. Remove lockwire (10), rod ends (11), nuts (12) and rod end assemblies (13) from strut assemblies (9).

      NOTE: Do not remove bushings (14) from rod ends (15) unless repair or replacement is necessary.

   B. Remove lockwire (17 and 29), rod end assemblies (18 and 30), nuts (21 and 33), locks (22 and 34), couplings (23 and 35), sleeves (24A), if applicable, and nuts (24 and 36) from strut assemblies (16 and 28).

      NOTE: Do not remove bushings (19 and 31) from rod ends (20 and 32), bushings (26 and 38) from rod ends (27 and 39), or bushings (40) from carriage (112) unless repair or replacement is necessary.

   C. Loosen nuts (115 and 116). Unscrew rod end assemblies (118 and 121) from coupling (117). Remove nuts and lock (114).

      NOTE: Do not remove bushings (119 and 122) unless repair or replacement is necessary.

3. Remove cotter pins (41), bearing nuts (42), bearings (43, 43A), rub strips (44), shim washers (45), and bolt assemblies (46).

   NOTE: Note thickness and location of shim washers (45) to facilitate reassembly.

   Do not remove lubrication fittings (47) from bolts (48) unless repair or replacement is necessary.

4. Remove bolts (49), washers (50), radius fillers (51), aft side roller assemblies (52 and 60), and shims (68).

   NOTE: Note thickness and location of shims (68) to facilitate reassembly.

5. Remove lockwire (53 and 61), spring pins (54 and 62), bolt assemblies (55 and 63), and bearings (58 and 66) from brackets (59 and 67).

   NOTE: Do not remove lubrication fittings (56 and 64) from bolts (57 and 65) unless repair or replacement is necessary.

6. Remove bolts (69), washers (70), forward side roller assemblies (71 and 79), and shims (87).

   NOTE: Record thickness and location of shims (87) to facilitate reassembly.

7. Remove lockwire (72 and 80), spring pins (73 and 81), bolt assemblies (74 and 82), and bearings (77 and 85) from brackets (78 and 86).

   NOTE: Do not remove lubrication fittings (75 and 83) from bolts (76 and 84) unless repair or replacement is necessary.

8. Remove cotter pins (88), bearing nuts (89), bearings (90), washers (91), and bolt assemblies (92).

   NOTE: Do not remove lubrication fitting (93) from bolt (94) unless repair or replacement is necessary.

9. Remove cotter pins (95), nuts (96), washers (97), bolt assemblies (98), laminated washers (101), and needle bearings (102).

   NOTE: Record thickness and location of laminated washers (101) to facilitate reassembly.

   Do not remove lubrication fitting (99) from bolt (100) unless repair or replacement is necessary.

10. Remove pin (103), washers (103A) if applicable, nut (104), washer (106), or thrust nut (106A, Fig. 1102), and roller (107) from carriage assembly (109).

    NOTE: Do not remove bonded bushing (108), sleeve (110), or bushings (111) from carriage (112) unless repair or replacement is necessary.

    Sleeves 65-47821-4,-18 (110, IPL Fig. 1101) and 65-47821-18 (110, IPL Fig. 1103) are not allowed on 65-47821 carriage assemblies (112, Fig. 1101, 1103) that have incorporated Service Bulletin 737-57-1218.

11. If assembled to carriage assembly (109), remove items (108A thru 108C, 108E Fig. 1101, 1103) and bearing (108D, Fig. 1101, 1103).

CLEANING

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

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

INSPECTION/CHECK

1. Visual Check

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

   B. Examine all threaded parts for cross-threading and stripping.

   C. Examine painted and plated surfaces for blisters or flaking.

   D. Check parts for wear beyond limits given in Fig. 601.

   E. Check all bearings for corrosion, roughness, binding, excessive radial or axial play, and for freedom of rotation.

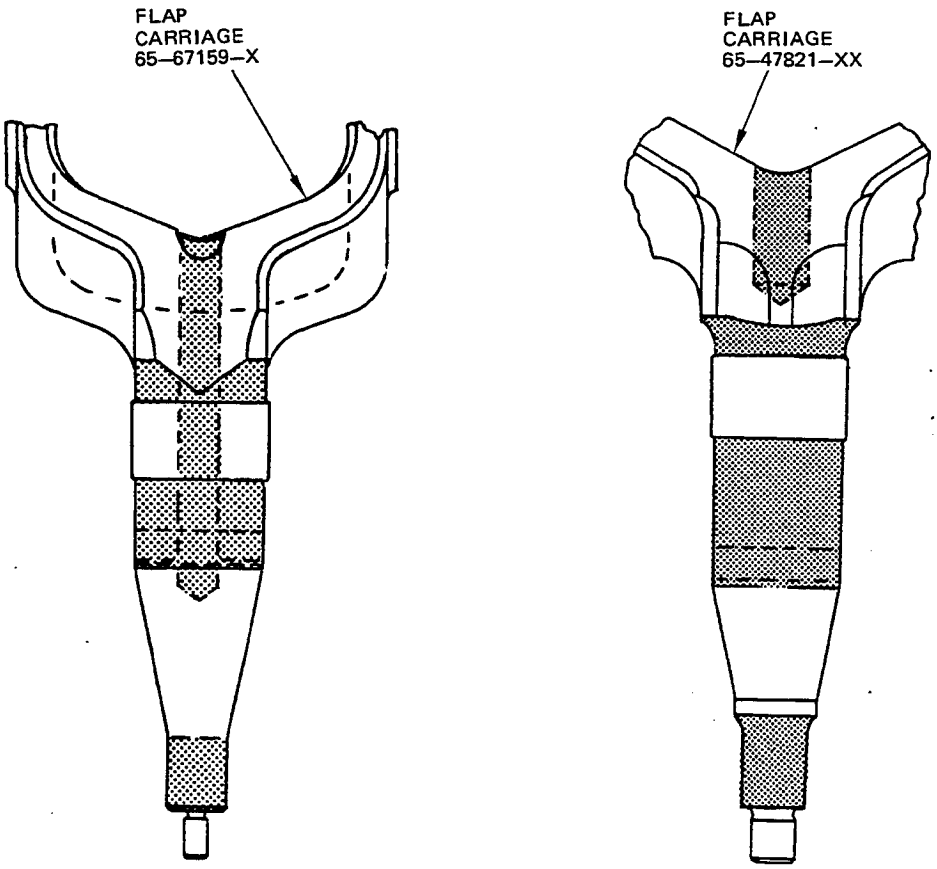
   F. Examine all bearing, bushing, and bolt holes for corrosion and excessive or eccentric wear.

   G. Examine carriage (112) spindle for corrosion per Fig. 301. If corrosion is found, refer to Repair. If no corrosion is found, refer to Assembly for corrosion prevention modification.

2. Special Checks (Fig. 1101, 1102, 1103)

   A. Perform magnetic particle examination per 20-20-01 on bolts (8, 48, 57, 65, 76, 84, 94, and 100), rod ends (15, 20, 27, 32, 39, 120 and 123), couplings (23, 35 and 117), bearing nuts (42 and 89), brackets (59, 67, 78 and 86), roller (107), bushing (108, Fig. 1101, 1102, 1103, P/N 69-61976-1, 69-61976-2, 69-61977-1, -2 and 69-64197-1, -2, 69-67219-6, -7, -8, -12, -13, -14), and carriage (112).

   B. Perform penetrant examination per 20-20-02 on bushing (108, Fig. 1102, P/N 69-46448-1).



CORROSION CHECK AREAS

Flap Carriage Spindle Corrosion Check
Figure 301

REPAIR

1. Repair (Fig. 401, 402, 403)

A. Remove corrosion and minor defects per SOPM 20-10-02. Refer to Fits and Clearances for design dimensions and wear limits.

B. Refer to SOPM 20-10-01 and SOPM 20-10-02 for machining of high strength steel parts.

C. Carriage (Fig. 1102; 112) 65-67159-2, -4, -6, -8 spindle tip repair with a threaded stud (Fig. 402).

(1) Remove bushing (108) from carriage (112).

(2) Cut off the damaged threaded end of the spindle. Machine the end smooth with the end of the narrower OD of the spindle per SOPM 20-10-02.

(3) Machine a hole in the end of the spindle, concentric with spindle centerline, as shown.

(4) Make a stud as shown.

(5) Install the stud in the spindle by the shrink-fit method, with wet BMS 5-95 sealant.

(6) Drill the two holes through the spindle and the stud, and the smaller hole through the end of the stud, as shown. Make these holes in the horizontal plane when the carriage is in the upright position.

(7) Install a NASM16562-231 roll pin in each of the holes through the spindle and the stud with wet BMS 5-95 sealant.

(8) Get a 69-61976-1 bushing and machine the 0.39-0.41 hole to 0.62-0.63 inch. Or use a 69-61976-2 bushing, which already has the larger hole.

(9) Machine the thread of the nut (Fig. 1102; 106A) 1/2-20 UNF-2B.

(10) Install the modified bushing on the spindle of carriage (112) with wet BMS 5-95 sealant.

(11) Install bearing (107) on carriage assembly (109) with the modified thrust nut. Tighten the thrust nut to 100-150 pound-inches.

(12) Install a nut BACN10JD8CD with washers AN960C816 and AN960C816L, in combination as required to align the nut slots with the 0.141-inch hole in the stud. Tighten the nut to 100-150 pound-inches. Install a clevis pin NASM20392-1P27, washer (103A) and lockwire. Install lockwire through pin, make one twist and wrap each end around nut, BACN10JD8; bring one end around pin between head and washer (105). Twist lockwire ends per 20-50-02.

NOTE: These steps (11) (12) replace ASSEMBLY step 1.B. for carriage assemblies 65-46481-8, -13, -14, -19, -20, -25, -26 repaired by installation of 1/2 inch stud.

D. Carriage spindles (112) with defects can be repaired by machining and plating and as described in the following instructions. Diameter 1 and 2 can be repaired by sulfamate nickel plating, or sulfamate nickel plating plus a repair sleeve. Diameter 3 can be repaired by sulfamate nickel buildup, or cadmium-titanium plate and installing an undersize bearing (107) or undersize bushing (108).

(1) If installed, remove any bearing, bushings or sleeve, discard sleeve, remove all finishes, coatings and platings from the spindle.

(2) Mount the carriage between the centers in a suitable fixture. Use the special mounting bore shown in Fig. 401 to help hold the carriage spindle.

(3) Concentrically machine the outer diameters of the carriage spindle, as necessary to remove defects, to the dimensions and finish shown in Fig. 403 per SOPM 20-10-02. Maintain a 63 Ra finish.

(4) After the area is machined, stress relieve per SOPM 20-10-02.

(5) Shot peen per SOPM 20-10-03.

(6) Repair the machined area for Diameter 1 as shown in Fig. 403 and as follows:

(a) Sulfamate nickel plate the machined area, per SOPM 20-42-09, to 0.003-0.030 inch thickness. After initial application of the plating current and during the plating process, the rate of plating deposit must not exceed a maximum of 0.002 inches per hour.

(b) After plating, finish the repair area to 63Ra and record the outer diameter for use in creating the interference with the repair sleeve in the following step.

(c) Make a repair sleeve for Diameter 1 area as shown in Fig. 407 or 408 and as follows:

1) Repair sleeve material AISI 304 annealed cres bar per AMS 5639.

2) Min sleeve wall thickness 0.032 inch.

3) Machine inner diameter to create interference fit of 0.0020-0.0040 inch upon installation.

4) Finish all machine surfaces 63 Ra.

5) Passivate (F-17.25) all over, plus apply cadmium plate (F-15.02) to the inner diameter.

(d) Install the repair sleeve per Replacement Step 3.B.

(e) Machine the repair sleeve outer diameter to the dimensions and finish shown in Fig. 403.

(7) Repair the machined area for Diameter 2 as shown in Fig. 403 and as follows:

NOTE: If the design after plate outer diameter of Diameter 2 can be restored by sulfamate nickel plate, (0.030 in. maximum thickness) then a repair sleeve can not be used.

(a) Sulfamate nickel plate the machined area, per SOPM 20-42-09, to 0.003-0.030 inch thickness. After initial application of the plating current and during the plating process, the rate of plating deposit must not exceed a maximum of 0.002 inches per hour.

(b) If necessary, make a repair sleeve for Diameter 2 area as shown in Fig. 409 or 410 and as follows:

1) Repair sleeve material AISI 304 annealed cres bar per AMS 5639.

2) Min sleeve wall thickness 0.032 inch.

3) Machine inner diameter to create an interference fit of 0.0020-0.0040 inch upon installation.

4) Finish all machine surfaces 63 Ra.

5) Apply passivate (F-17.25) all over, plus apply cadmium plate (F-15.02) to the inner diameter.

(c) Install the repair sleeve using Replacement Step 3.B.

(d) Machine the repair sleeve outer diameter to the dimensions and finish shown in Fig. 403.

(8) Repair the machined area for Diameter 3 as shown in Fig. 403 and as follows:

NOTE: If the design after plate outer diameter of Diameter 3 can be restored by sulfamate nickel plate (0.030 inch maximum thickness), then an under size bearing (107) or undersize bushing (108) does not have to be used.

(a) Sulfamate nickel plate the machined area, per SOPM 20-42-09, to 0.003-0.030 inch thickness. After initial application of the plating current and during the plating process, the rate of plating deposit must not exceed a maximum of 0.002 inches per hour.

(b) If the design after plate outer diameter of Diameter 3 can not be restored using the previous sulfamate nickel plating process, then machine Diameter 3 up to the repair limit shown in Fig. 403 to accommodate an undersize bearing (107) or undersize bushing (108).

1) Apply cadmium-titanium plate (F-15.01), then apply BMS 10-11, Type 1 primer (F-20.02) to the machined area.

2) Install an undersize bearing (107) using Assembly Step 1.

3) Install an undersize bushing (108) using Replacement Step 3.E.

E. Carriages (65-47821-series) Diameter 4 hole in spindle for crossbolt (108C) (Fig. 403)

(1) Remove bushing (111) from the carriage assembly.

(2) Machine the hole as required per SOPM 20-10-02, within repair limits, to remove defects. Chamfer outside edge of hole 45 degrees by 0.01-0.03 inch.

(3) Stylus cadmium plate the machined surface per SOPM 20-42-10.

(4) Make a repair bushing per Fig. 404.

(5) Install the repair bushing using Repair Step 3.F. Make sure the bushing ends are at or 0.02 inch maximum below the surfaces. Remove unwanted sealant.

(6) Fillet seal the end of the repair bushing with BMS 5-95 sealant.

(7) Ream the bushing ID to 0.312-0.313 inch design diameter.

F. Carriage (112) holes Diameter 6 (Fig. 401)

(1) Remove bushing (40) from carriage assembly.

(2) Machine the hole oversize, within repair limits, to remove defects. Chamfer the outside edge of the holes 0.01-0.03 at 45 degrees.

(3) Stylus cadmium plate machined surface per 20-42-10 to a thickness of 0.0005-0.0007 inch.

(4) Apply one coat BMS 10-11, Type 1 primer to the reworked hole and allow to dry.

(5) Make an oversize bushing per Fig. 405.

(6) Install the repair bushing using Repair Step 3.F.

(7) Machine the installed bushing to the ID of the standard bushing (40): 0.3750-0.3765 inch.

(8) Restore the bushing bore chamfer as necessary.

G. Carriage (112) holes Diameters 1, 3, 5, 7, 8, 10 (Fig. 401)

(1) Machine holes oversize, within repair limits, to remove defects. Chamfer the outside edge of the holes 0.01-0.03 inch at 45 degrees.

(2) Make a repair bushing or sleeve, as applicable (Fig. 404, 406).

(3) Stylus cadmium plate the holes per SOPM 20-42-10, then install the bushing using Repair Step 3.F.

(4) Machine the installed bushings to the indicated hole design diameters.

(5) Restore the bushing bore chamfer as necessary.

(6) If you installed a repair bushing with a flange in hole Diameter 8, include a note with the carriage to install a 0.032-inch thick NAS1149F0432P (or equivalent) washer between the carriage and the fairing support arm.

H. Rod end 69-42367-4, -6 (15, Fig. 1101, 1102)

(1) Remove bushing (14). Machine hole in rod end within 0.5629 maximum repair diameter, to remove defects. Chamfer ends 0.01-0.02 inch at 45 degrees.

(2) Make an oversize bushing per Fig. 404.

(3) Stylus cadmium plate the hole per SOPM 20-42-10.

(4) Install the bushing using Repair Step 3.F.

(5) Machine the ID of the installed bushing to 0.3750-0.3765 inch diameter.

2. Refinish (Fig. 1101, 1102, 1103)

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

A. Bolts (57, 65, 76, 84) -- Cadmium plate (F-15.02). Material: 4340 steel, 125-145 ksi.

B. Rod ends (15, 20, 27, 32, 39), couplings (23, 35), sleeve (24A) -- Passivate (F-8.07). Material: 17-4PH CRES, 180-200 ksi.

C. Nut (42) -- Cadmium plate (F-15.02) all over. Material: 4340 steel, 180-200 ksi.

D. Bolt (48)

(1) (69-38825-2) -- Cadmium plate (F-15.02). Material: 4340 steel, 180-200 ksi.

(2) (69-38825-6) -- Cadmium-Titanium plate (15.01). Material: 4340 Steel, 180-200 ksi.

(3) (69-38825-4, -8) -- Cadmium-titanium plate (F-15.01). Material: 4340 steel, 270-300 ksi.

E. Fillers (51, 134) -- Chemical treat or chromic acid anodize and apply primer BMS 10-11, Type 1 (SRF-2.30). Material: Al Alloy

F. Brackets (59, 67, 78, 86)

(1) 69-35323-series, 69-35324-series -- Cadmium plate and apply primer BMS 10-11, Type 1 (SRF-1.285), and enamel BMS 10-11, Type 2 (SRF-12.63) color BAC707, but no primer in holes and no enamel on inside surfaces. Material: 4140 steel, 180-200 ksi.

(2) 65C16951-series, 65C16950-series -- Passivate (F-17.09). Apply primer BMS 10-11, Type 1 (F-20.02) all over but not in holes. Material: 17-4PH CRES.

G. Nut (89) -- Cadmium plate (F-15.02). Material: 4340 steel, 180-200 ksi.

H. Bolt (94)

(1) (69-35347-2, -6) -- Cadmium-titanium plate (15.01). Material: 4340 steel, 180-200 ksi.

(2) (69-35347-4, -8) -- Cadmium-titanium plate (F-15.01). Material: 4340 M steel, 270-300 ksi.

I. Bolt (8, 100) -- Cadmium plate (F-15.02) all over. Material: 4340 steel, 180-200 ksi.

J. Washer (106)

(1) (66-23245-1, -2) -- Cadmium plate (F-1.191) all over. Material: 4130 steel, 160-180 ksi.

(2) (69-61978-1, -2) -- Chrome plate (F-1.842) all over, except in hole. Material: 17-4PH CRES, 180-200 ksi.

(3) (69-61978-3) -- Cadmium plate (F-15.02). Material: 4330 steel, 180-200 ksi.

K. Nut (Fig. 1102; 106A) -- Chrome plate (F-1.90, which replaces F-1.842) bearing surface only. Passivate (F-8.07) other surfaces. Material: 17-4PH CRES, 180-200 ksi.

L. Roller (107), Fig. 1101, (66-23216-1) -- Chromium plate (F-15.04) all over, minimum thickness 0.002 inch. Material: 4340 steel, 270-300 ksi.

M. Bearing (107), (65C10596-1, -2, -3, -4, -5, -7, -8, -9) -- Passivate (F-8.07) all over. Apply cadmium plate (F-15.05) to bore and radius only. Plating thickness 0.0002-0.0003 inch. Material: BMS 7-213, grade 2, steel.

N. Bushing (108)

(1) (66-23215-1) -- Cadmium plate (F-4.201) on inside diameter only. Material: Copper beryllium, 175-205 ksi.

(2) (69-61976-1, -2, 69-61977-1, -2) -- Cadmium plate (F-1.1926) inside diameter only. Material: 440C CRES.

(3) (69-64197-1) -- Passivate (F-8.07) all over. Cadmium plate bore and radius (F-15.05), 0.0002-0.0003 inch thick. Material: BMS 7-213, grade 2, steel, 220-235 ksi.

O. Sleeve (110)

(1) (65-47821-4, -18) -- Cadmium plate (F-1.1926) on inside diameter only. Material: 304 CRES.

(2) (65-67159-3) -- Cadmium plate (F-1.1926) on inside diameter (optional on outside diameter). Material: 304 CRES.

(3) (69-67219-4, -5) -- Passivate (F-8.07) all over. Cadmium plate (F-1.1926) on inside diameter only. Material: 304 CRES.

P. Carriage (112) -- See Fig. 401.

Q. Angle (135) -- Cadmium plate and apply primer BMS 10-11, Type 1 (SRF-1.285) and enamel BMS 10-11, Type 2 (SRF-12.63) color BAC707. Material: 4340 steel, 160-180 ksi.

R. Coupling (117) -- Passivate (F17.09). Material: 17-4PH Cres, 180-200 ksi.

3. Replacement (Fig. 1101, 1102, 1103)

A. Bushings (14, 19, 26, 31, 38, 40, 111, 119, 122) -- Install replacement bushings by the shrink fit method of SOPM 20-50-03.

B. Sleeve (110) and repair sleeves

(1) Heat a replacement sleeve (110), or repair sleeve, to 325°F maximum and assemble with wet BMS 5-95 sealant.

(2) Machine the OD of the sleeve per SOPM 20-10-02 to the diameter shown in Fig. 403. Keep a 63-microinch finish and concentricity with the spindle within 0.001 inch total indicator reading.

(3) Fillet seal each end of sleeve (110), or repair sleeve with wet BMS 5-95 sealant.

C. Replace any damaged parts that cannot be easily repaired.

D. Replace all cotter pins, spring pins, and lockwire at each overhaul.

E. Bushing (108)

(1) (66-23215-1, 69-46448-1 or 69-61977-1) -- Remove chromate treatment from mating surfaces by lightly polishing with crocus cloth. Then bond a replacement bushing to the spindle of carriage (112) with Loctite retaining compound No. 75.

(2) (69-64197-1 or 69-61976-1) -- Apply wet BMS 5-95 sealant to mating surfaces of bushing and shaft before installation.

F. Bushings (111)

(1) Install replacement bushings using the shrink fit method as shown in SOPM 20-50-03.

(a) Install with wet BMS 5-95 sealant.

(b) The ends of the bushing must be below the spindle surface within 0.000-0.002 inch.

(c) Remove any excess sealant.

G. Decal (124) -- Remove the old decal. Apply a replacement decal here on the conical section of spindle.

4. Materials

NOTE: Equivalent substitutes can be used.

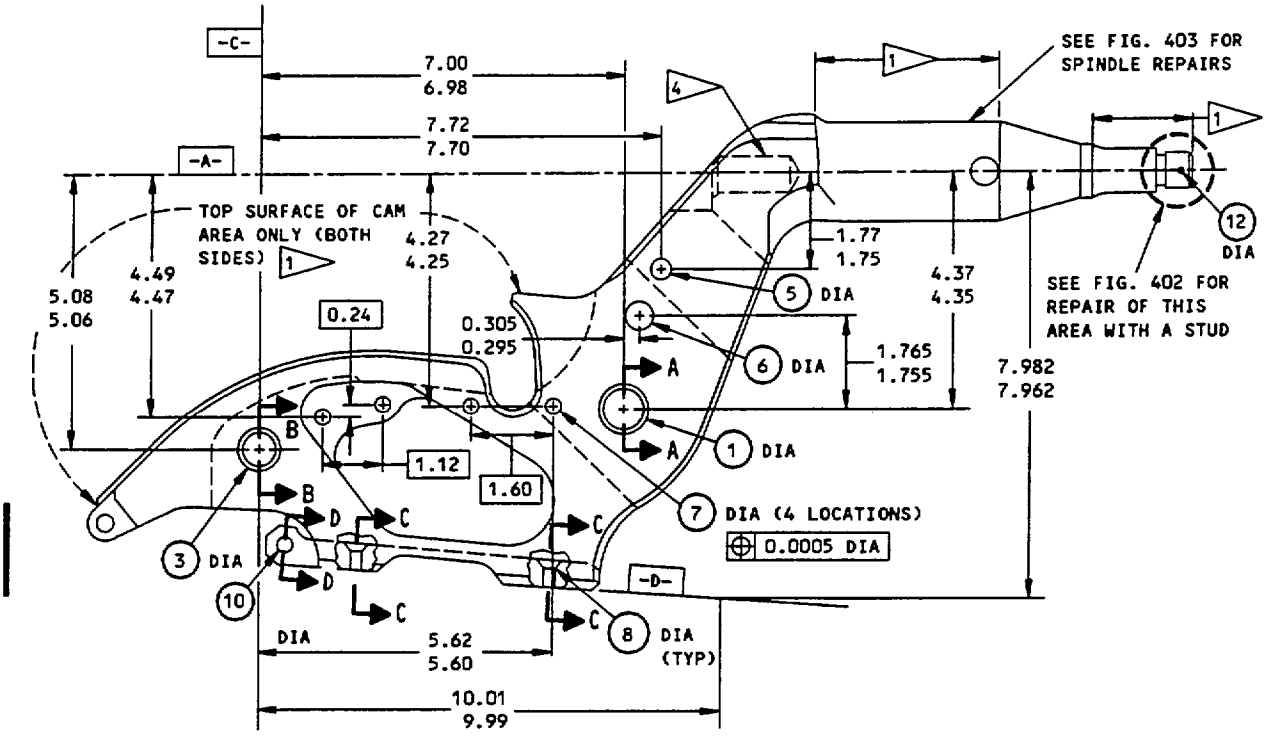
A. Primer -- BMS 10-11, Type 1 (Ref 20-60-02)

B. Enamel -- BMS 10-60 (Ref 20-60-02)

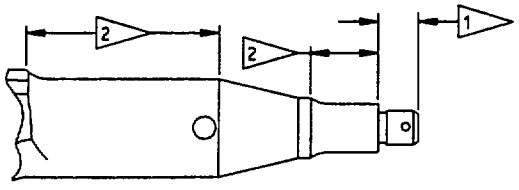
C. Retaining compound -- Loctite 75 (Ref 20-60-04)

D. Grease -- MIL-G-21164 (Ref 20-60-03)

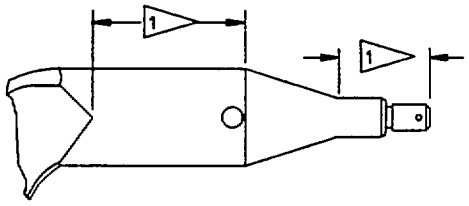
E. Sealant -- BMS 5-95 (Ref 20-60-04)



NOTE: THIS SPINDLE REFINISH APPLIES TO CARRIAGE 65-47821-5,-9,-11,13 ONLY



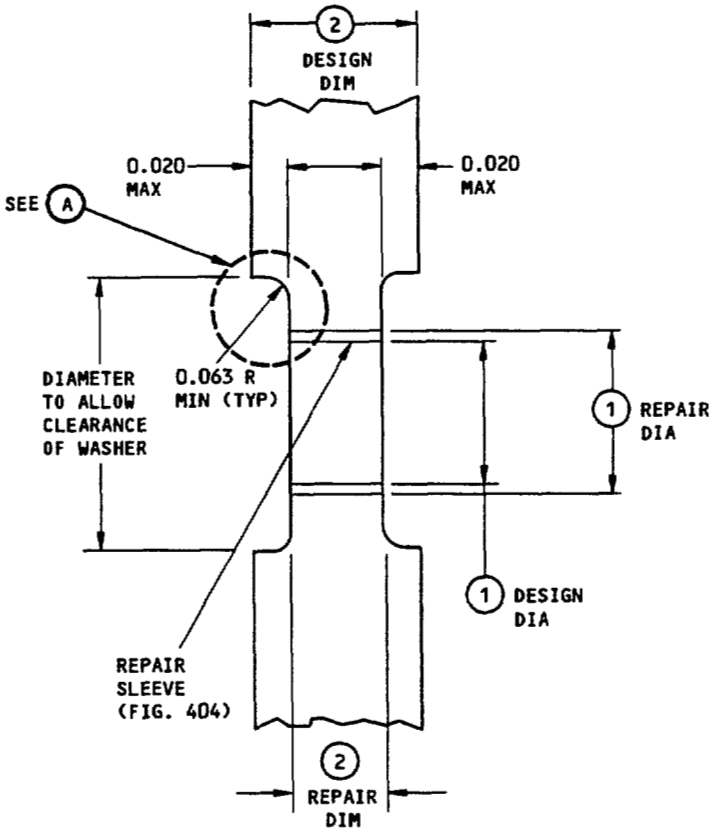
65-47821-17,-21,-23,-25,-27,-29



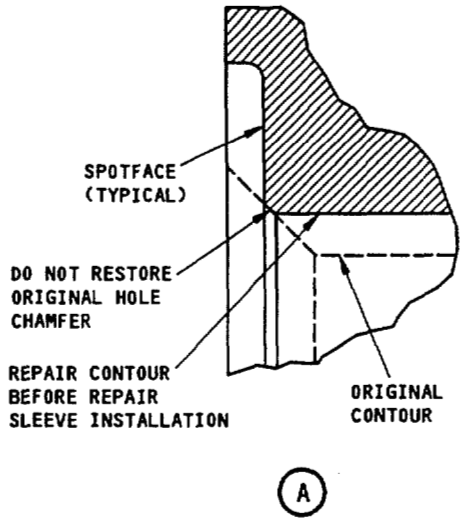
65-67159-2,-4,-6,-8,-10

CARRIAGE (112)
65-47821-SERIES
65-67159-SERIES

Carriage Repair and Refinish
Figure 401 (Sheet 1)



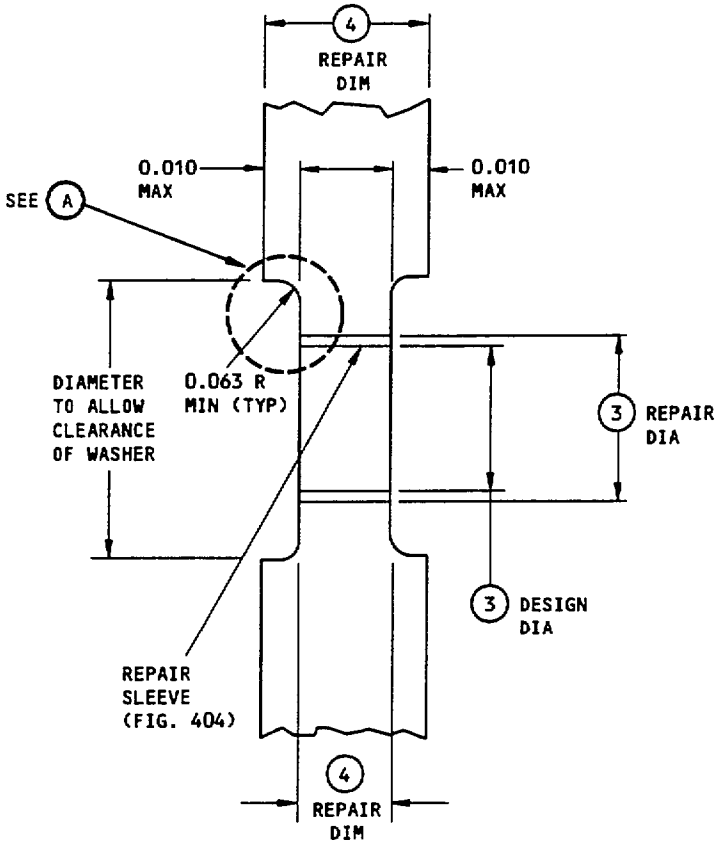
AFT ROLLER HOLE
A-A



CARRIAGE (112)
65-47821-SERIES ONLY

Carriage Repair and Refinish
Figure 401 (Sheet 2)

E57877

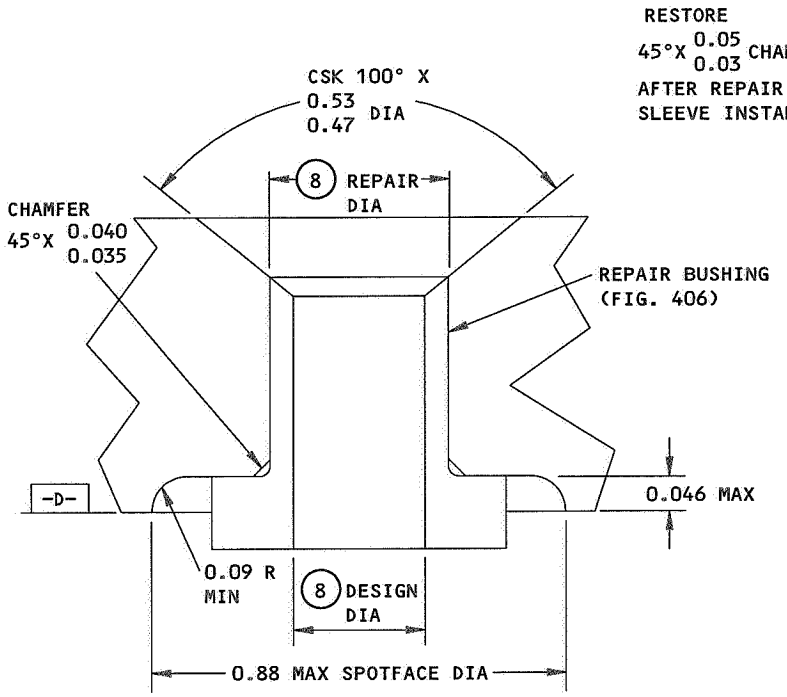


FORWARD ROLLER HOLE
B-B

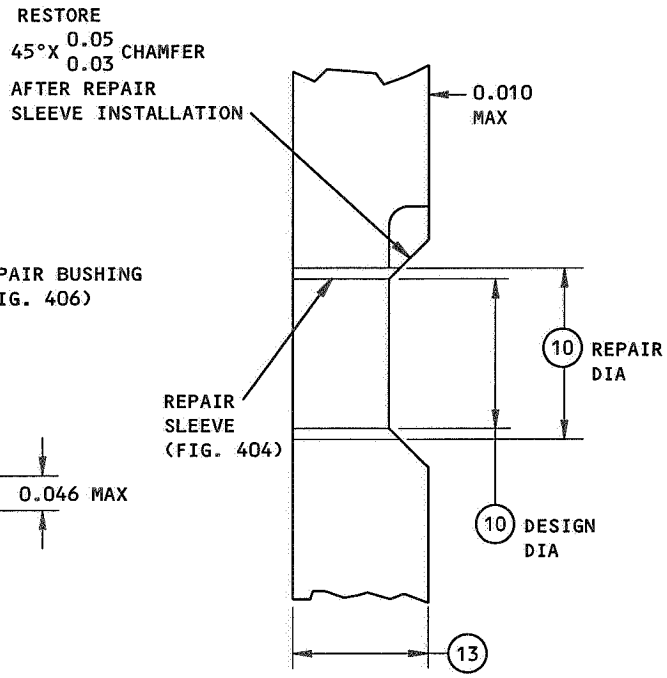
CARRIAGE (112)
65-47821-SERIES ONLY

Carriage Repair and Refinish
Figure 401 (Sheet 3)

E57885



SUPPORT ARM ATTACH BORE
C-C



FORWARD DEADWEIGHT ROLLER HOLE
D-D

	1	2	3	4	5	6	7	8	10	12	13
DESIGN DIMENSION	0.8781 0.8745	0.57 0.55	0.7531 0.7495	0.57 0.55	0.4420 0.4370	0.5004 0.4998	0.2610 0.2550	0.254 0.250	0.2540 0.2500	0.151 0.141	0.135 0.115
REPAIR LIMIT 3	1.000 0.940	0.52	0.830 0.812	0.54	0.5045	0.5629	0.3235	0.320	0.3350 0.3165	---	0.110

REFINISH

CADMIUM-TITANIUM PLATE (F-15.01). APPLY BMS 10-11, TYPE 1 PRIMER (F-20.02) AND BMS 10-11, TYPE 2 ENAMEL (F-21.02) UNLESS SHOWN BY 1 2 .

REPAIR

REF 3 4

63 MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: 4340M STEEL, 270-300 KSI

ALL DIMENSIONS ARE IN INCHES

1 NO PRIMER OR ENAMEL IN HOLES OR ON THESE SURFACES

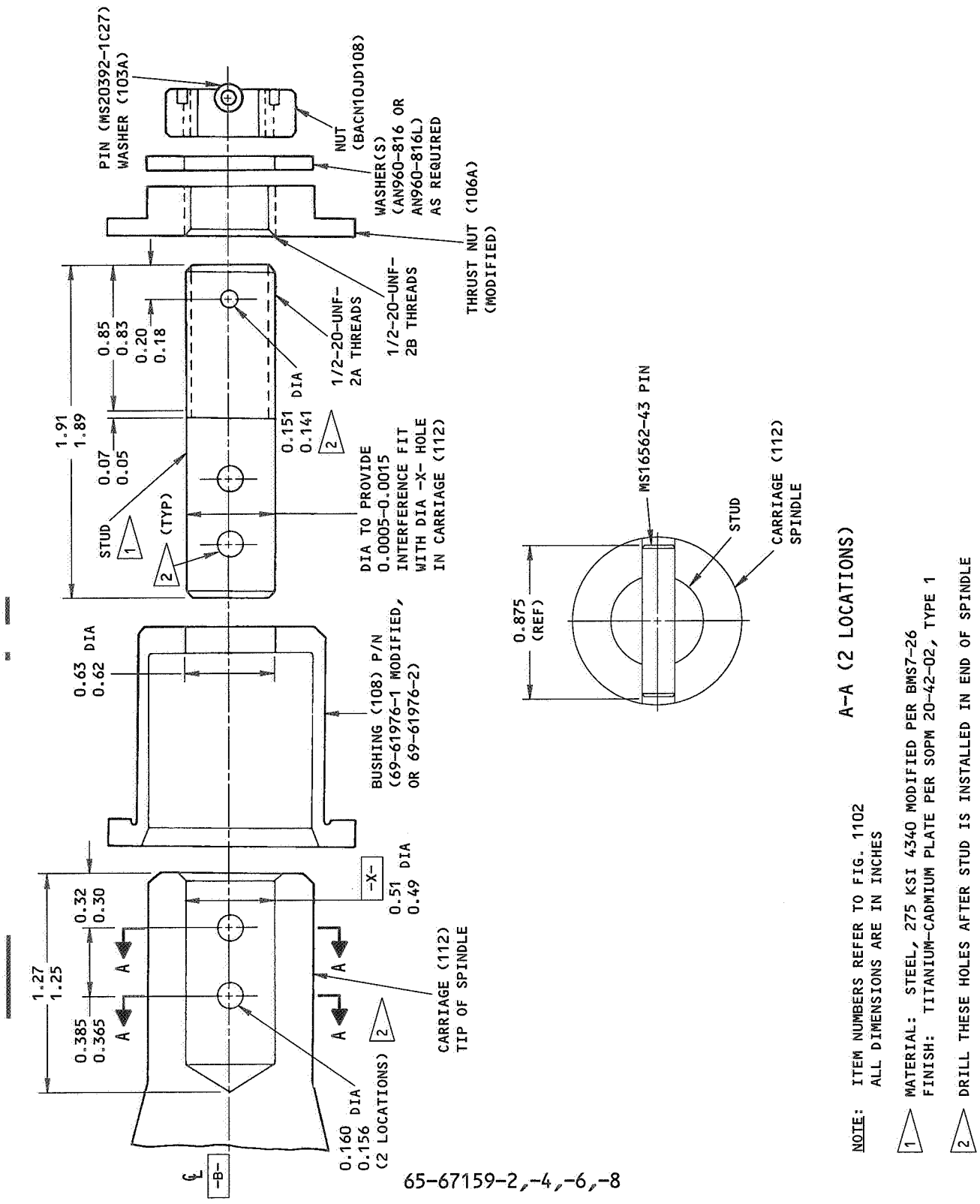
2 APPLY PRIMER BUT NO ENAMEL

3 RANGE OR LIMIT FOR INSTALLATION OF REPAIR BUSHING OR SLEEVE (FIG. 404, 405, 406)

4 TO HELP YOU MACHINE THE SPINDLE, USE THIS SPECIAL MOUNTING BORE. IF THE SPINDLE DOES NOT HAVE THIS BORE, MAKE ONE 0.375-0.500 DIA, 0.375 DEEP, ALIGNED WITH THE SPINDLE AS SHOWN, WITH 0.06 MIN RADIUS ALL AROUND AT THE BOTTOM. MACHINE PER SOPM 20-10-02.

CARRIAGE (112)
65-47821-SERIES
65-67159-SERIES
Carriage Repair and Refinish
Figure 401 (Sheet 4)

F38884

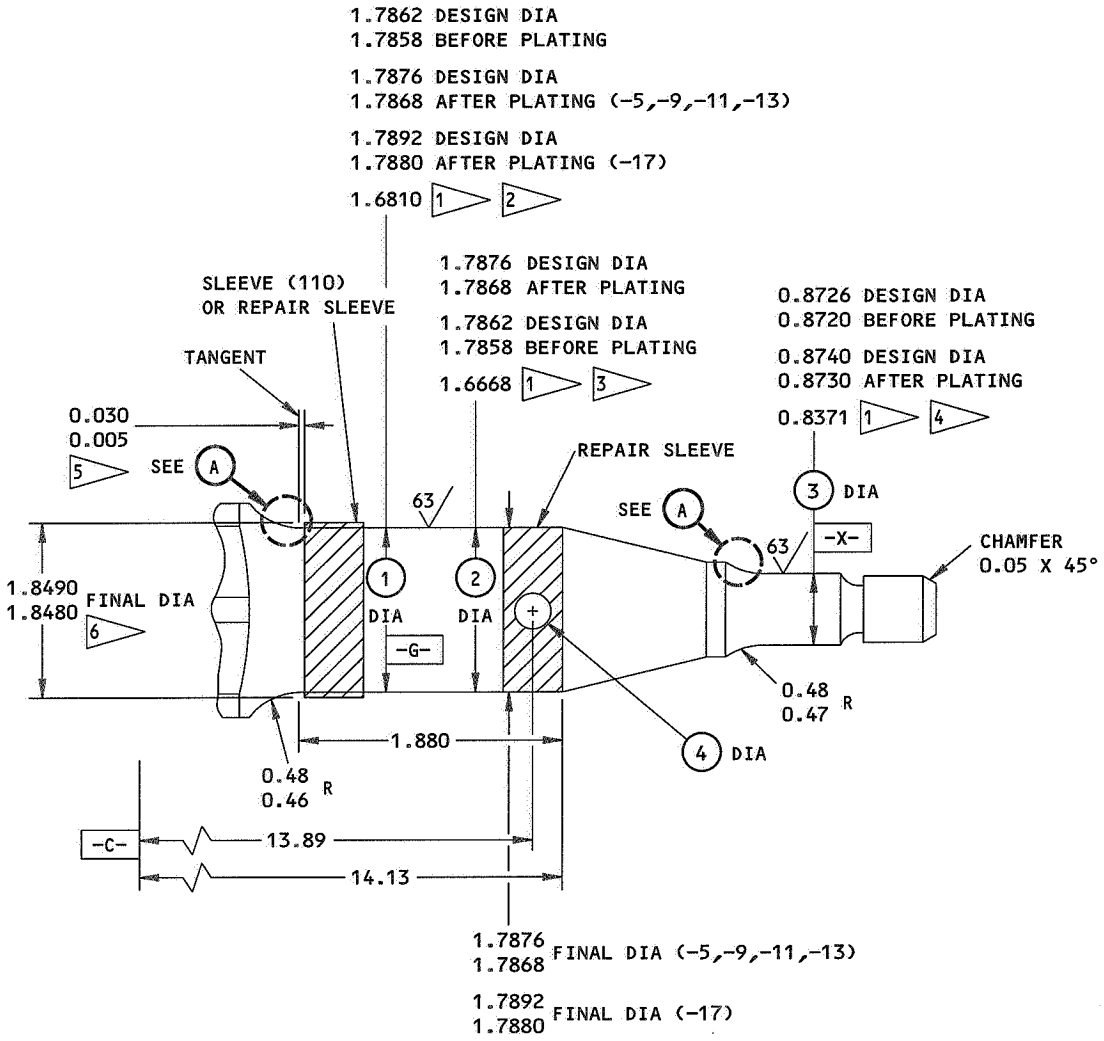


NOTE: ITEM NUMBERS REFER TO FIG. 1102
ALL DIMENSIONS ARE IN INCHES

1. MATERIAL: STEEL, 275 KSI 4340 MODIFIED PER BMS7-26
   FINISH: TITANIUM-CADMIUM PLATE PER SOPM 20-42-02, TYPE 1
2. DRILL THESE HOLES AFTER STUD IS INSTALLED IN END OF SPINDLE

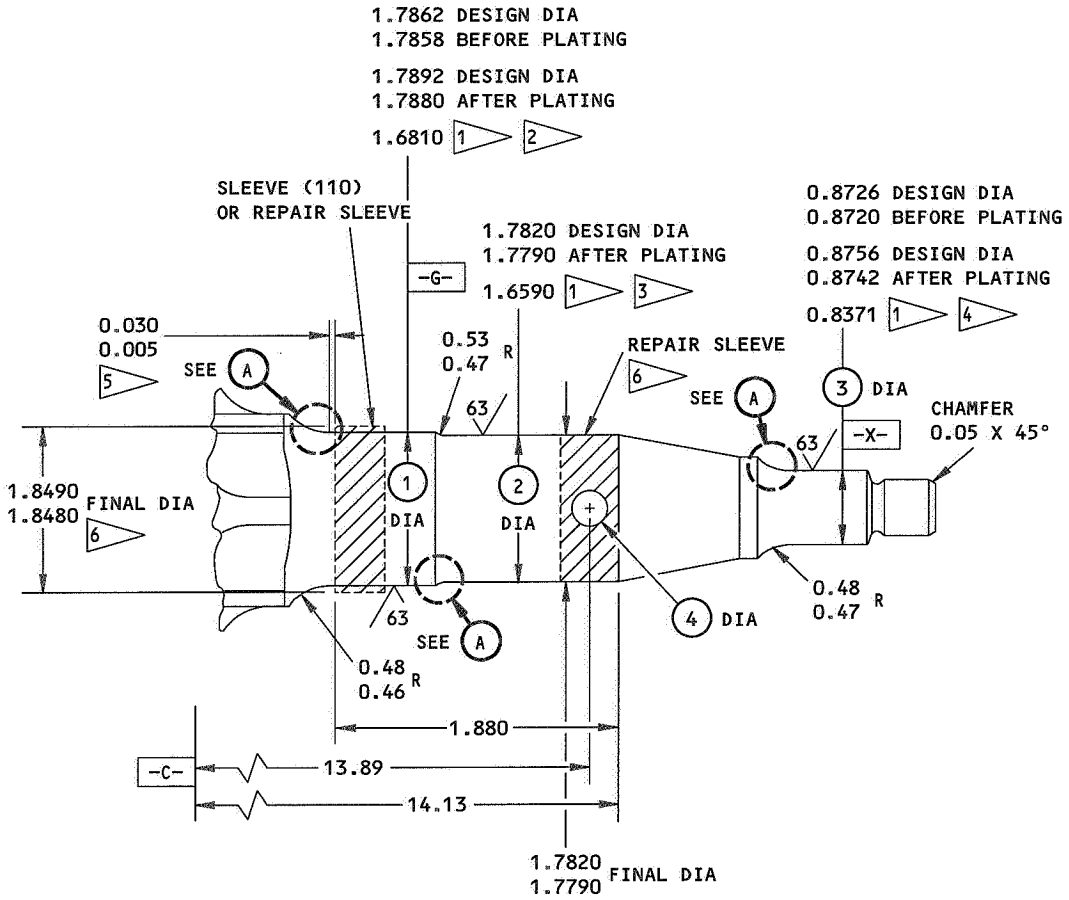
65-67159-2,-4,-6,-8

Carriage Spindle Tip Repair
Figure 402



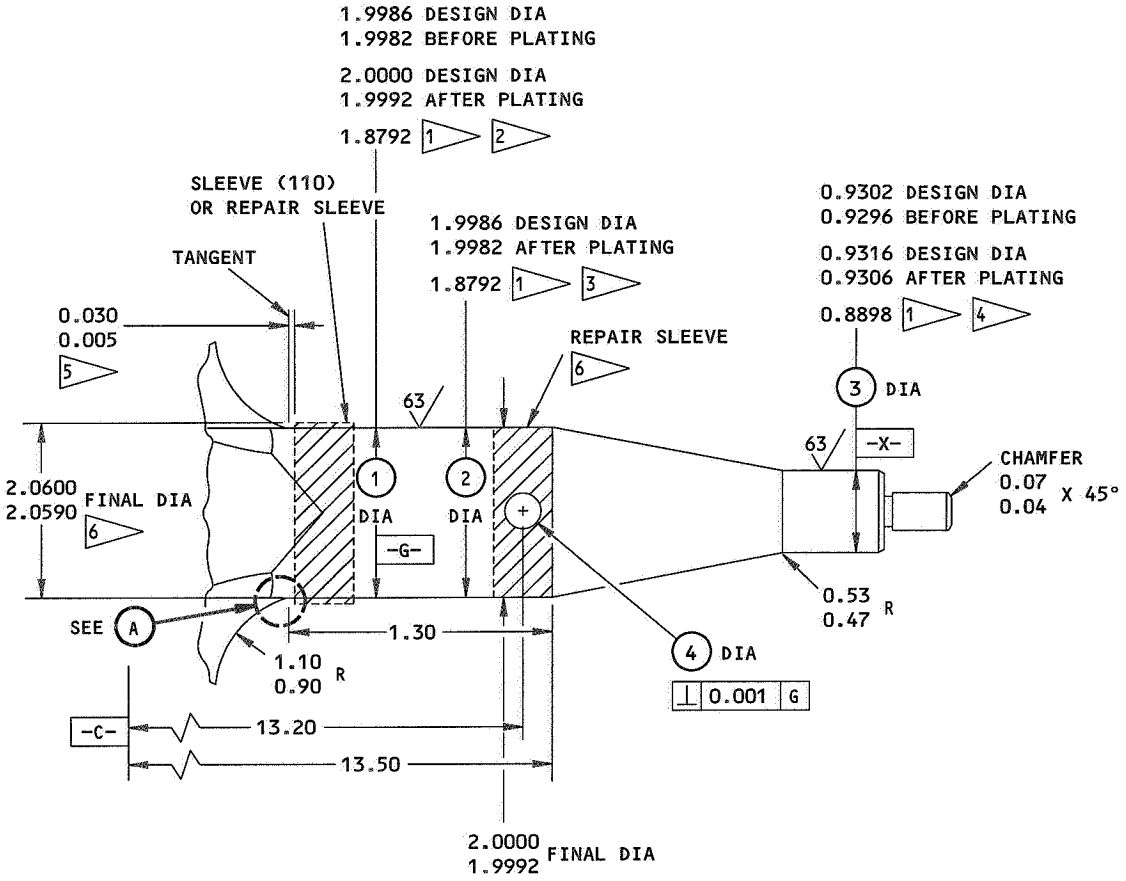
CARRIAGE (112)
65-47821-5,-9,-11,-13,-17

Carriage Spindle Repair
Figure 403 (Sheet 1)



CARRIAGE (112)
65-47821-21,-23,-25,-27,-29

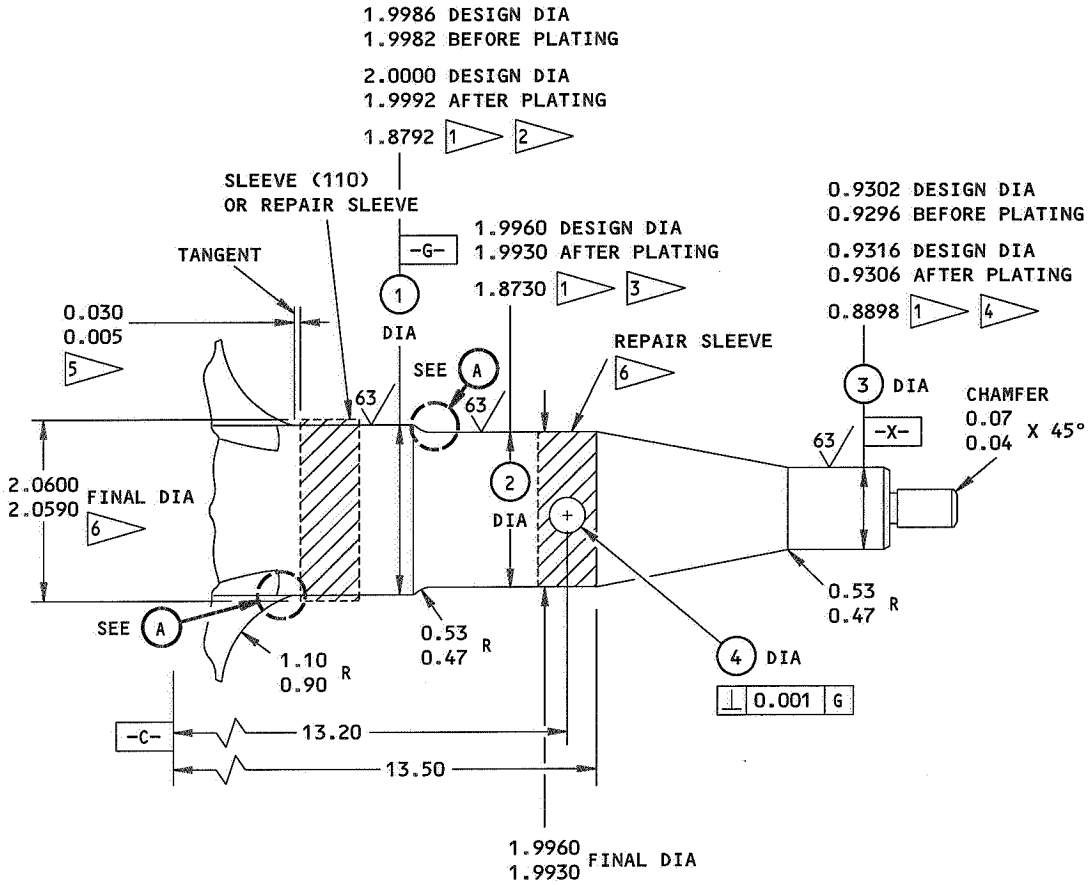
Carriage Spindle Repair
Figure 403 (Sheet 2)



CARRIAGE (112)
65-67159-2,-6,-8

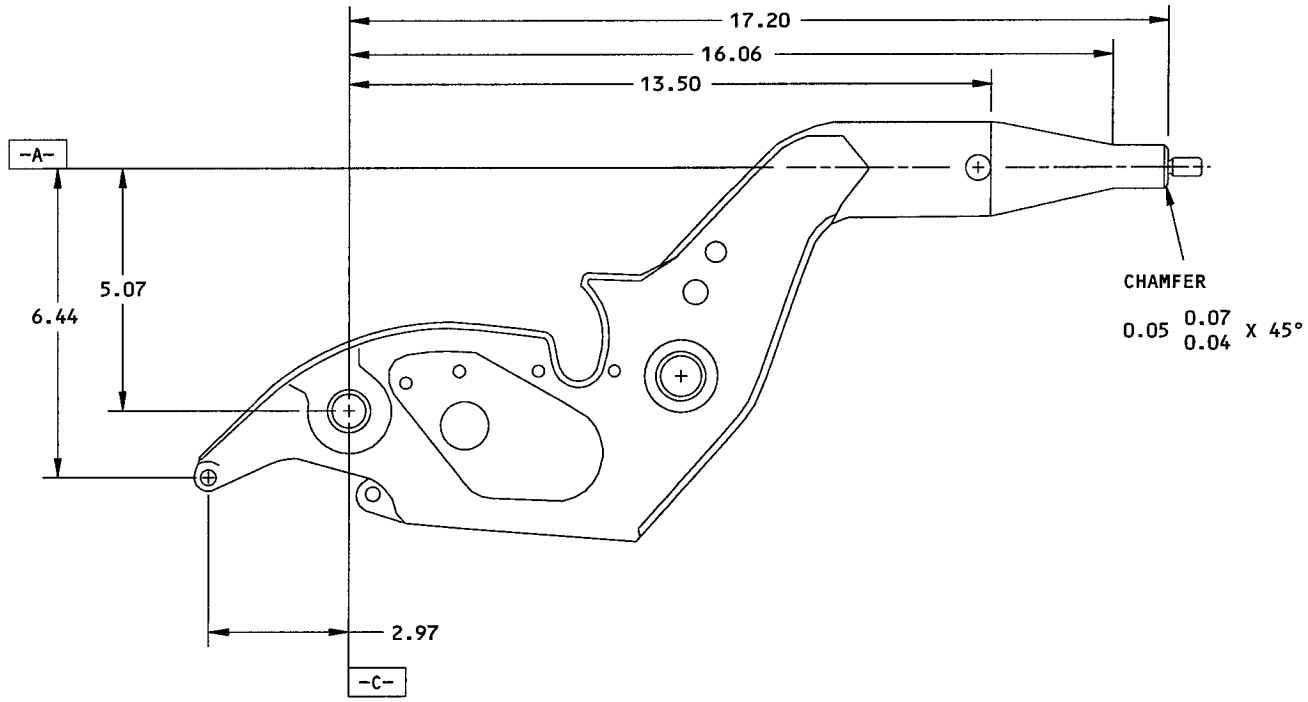
Carriage Spindle Repair
Figure 403 (Sheet 3)

K76960

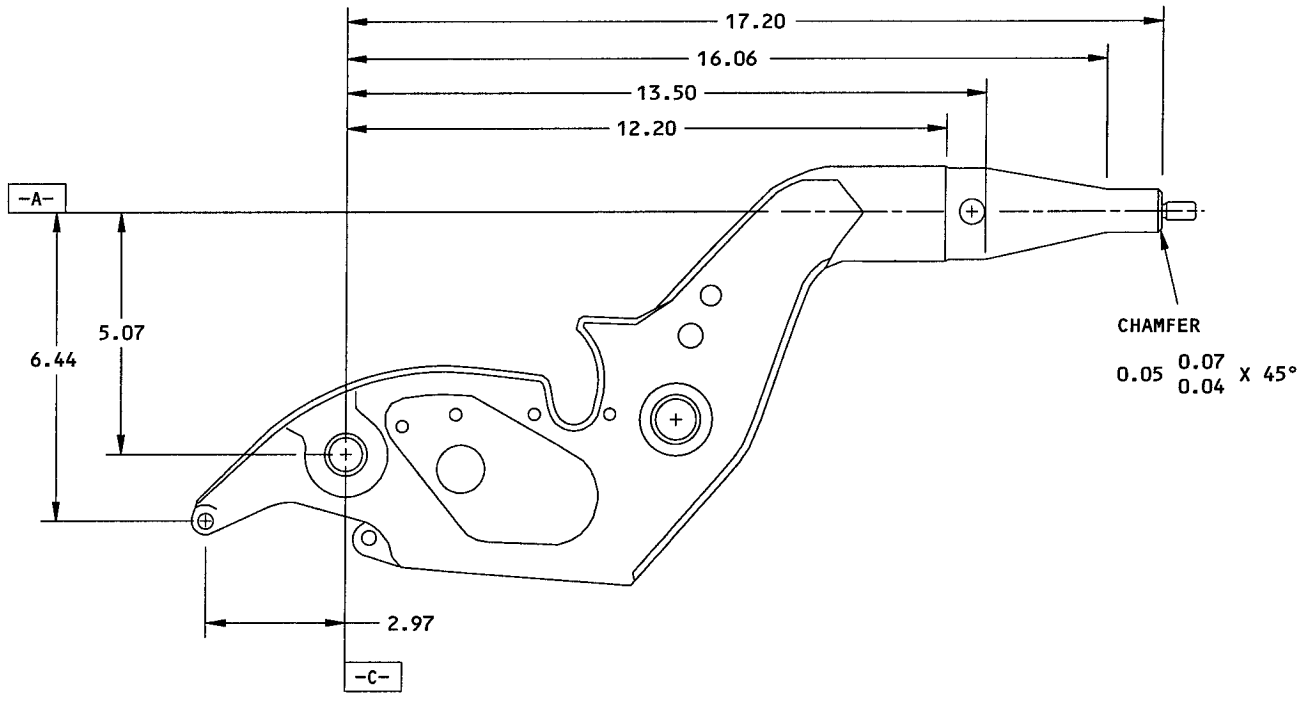


CARRIAGE (112)
65-67159-10

Carriage Spindle Repair
Figure 403 (Sheet 4)

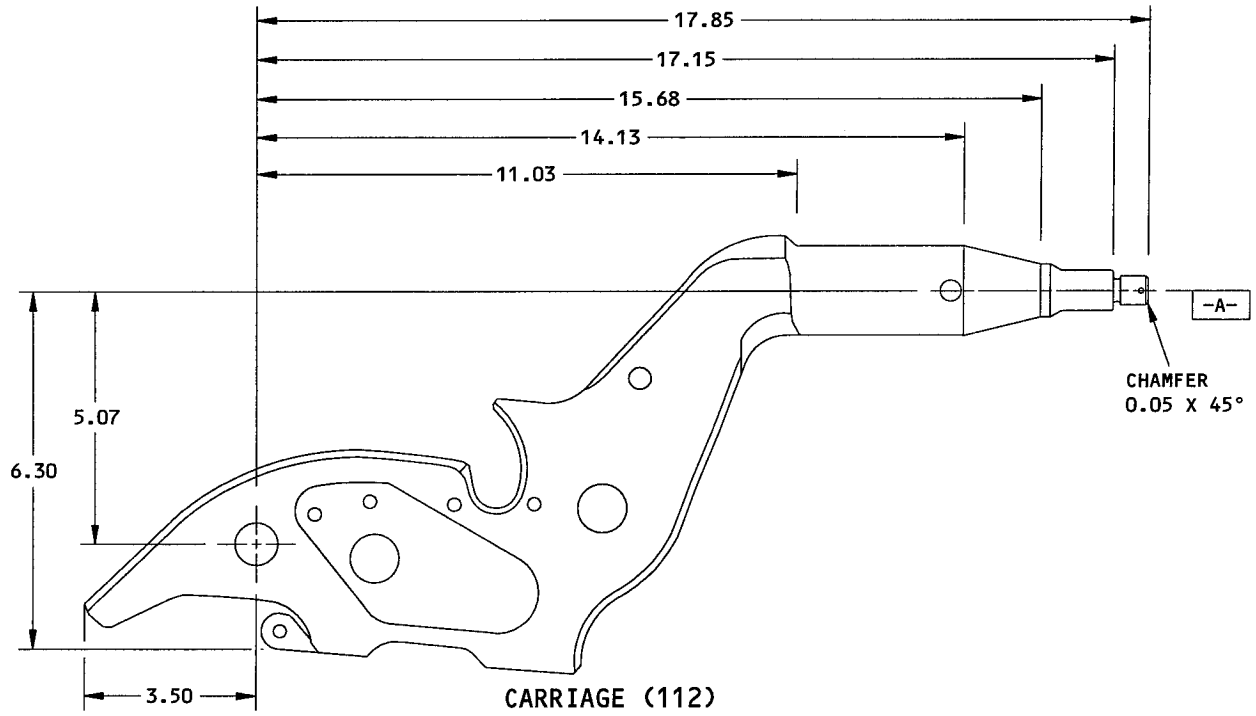


65-67159-2,-4,-6,-8

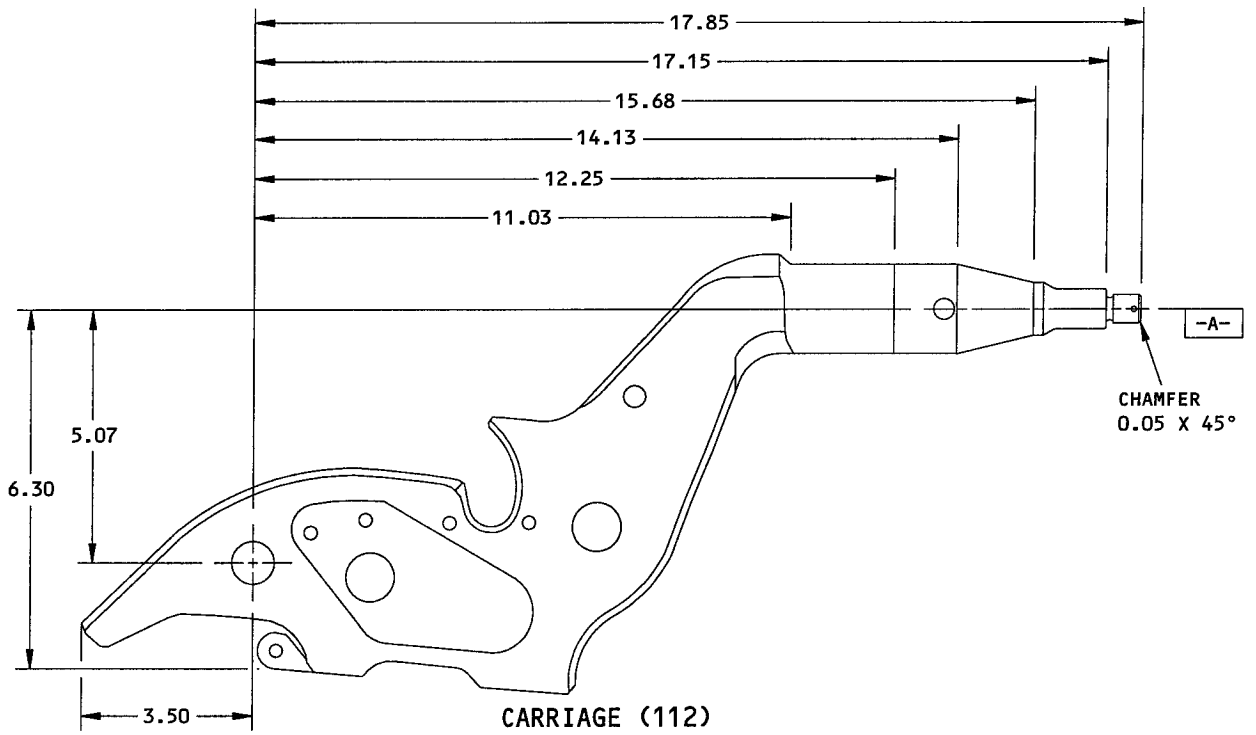


65-67159-10

Carriage Spindle Repair
Figure 403 (Sheet 5)

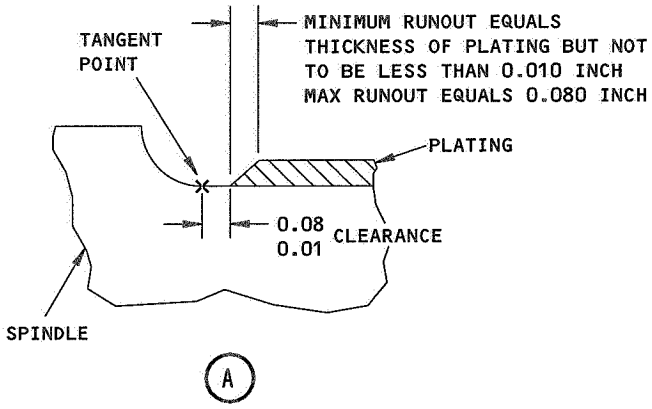


CARRIAGE (112)
65-47821-5,-9,-11,-13,-17



CARRIAGE (112)
65-47821-21,-23,-25,-27,-29

Carriage Spindle Repair
Figure 403 (Sheet 6)



	HOLE (4)		
	65-47821-5, -9, -11	65-47821-13, -17, -21, -23, -25, -27, -29	65-67159- SERIES
DESIGN DIMENSION	0.4160 0.4040	0.4379 0.4373	0.5004 0.4998
REPAIR LIMIT	0.6000 7	0.6000 7	8

Carriage Spindle Repair
Figure 403 (Sheet 7)

REFINISH

SEE FIG. 401

REPAIR

SHOT PEEN (SOPM 20-10-03):
0.016-0.039 SHOT SIZE
0.014A-0.019A INTENSITY
COVERAGE 2.0

MATERIAL: 4340M STEEL, 270-300 KSI

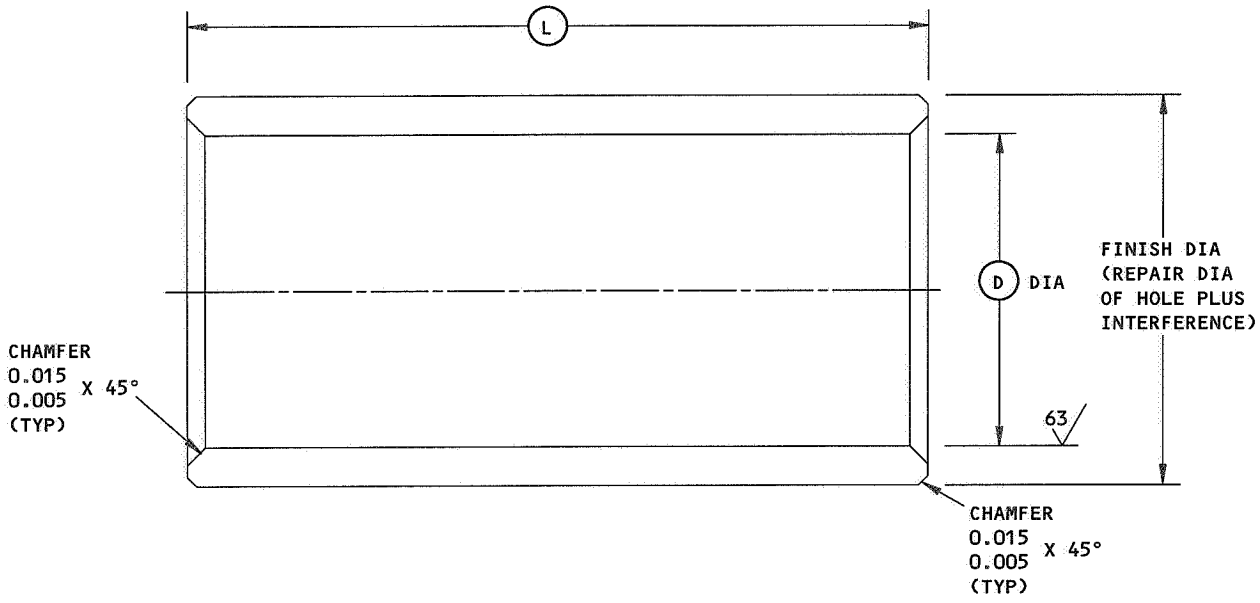
ALL DIMENSIONS ARE IN INCHES

ANGLE TOLERANCE ±2°

1. ULTIMATE REPAIR LIMIT: IF THE DIAMETERS #1,#2 OR #3 ARE LESS THAN THE REPAIR LIMIT, THEN NO REPAIRS ARE ALLOWED TO THE DIAMETERS AND THE CARRIAGE SHOULD BE REMOVED FROM SERVICE.
2. REPAIR DIAMETER 1 WITH SULFAMATE NICKEL PLATE (0.003-0.030) INCH, THEN INSTALL A AISI 304 ANNEALED CRES REPAIR SLEEVE AND MACHINE OUTER DIAMETER OF REPAIR SLEEVE PER 6. REFER TO REPAIR PROCEDURE
3. REPAIR DIAMETER 2 WITH SULFAMATE NICKEL PLATE (0.003-0.030) INCH, OR SULFAMATE NICKEL PLATE (0.003-0.030) INCH PLUS A AISI 304 ANNEALED CRES REPAIR SLEEVE AND MACHINE OUTER DIAMETER OF REPAIR SLEEVE PER 7. REFER TO REPAIR PROCEDURE. SLEEVE TO HAVE 0.032 INCH MIN THICKNESS
4. REPAIR DIAMETER 3 WITH SULFAMATE NICKEL PLATE (0.003-0.030) INCH. IF AFTER PLATE DESIGN DIMENSIONS CAN NOT BE RESTORED, THEN APPLY CADMIUM-TITANIUM PLATE (F-15.01) PLUS APPLY BMS 10-11 TYPE 1 PRIMER (F-20.02) AND INSTALL AN UNDERSIZE BEARING (107). REFER TO REPAIR PROCEDURE
5. SET BACK DISTANCE BETWEEN RADIUS TANGENT POINT AND SLEEVE MUST BE 0.005-0.030 INCH
6. AFTER SLEEVE IS INSTALLED, MAKE SURE TO MACHINE THE OUTER DIAMETER OF SLEEVE TO DIMENSION SHOWN AND 63Ra
7. LIMIT FOR INSTALLATION OF REPAIR BUSHING (FIG. 404).
8. GET REPAIR INSTRUCTIONS FROM BOEING.

Carriage Spindle Repair
Figure 403 (Sheet 8)

E78985



HOLE LOCATION	REPAIR FIGURE	(D)	(L)	INTERFERENCE FIT	MATERIAL
(1)	401	0.8781 0.8745	0.53 0.51 ▷3	0.0017 0.0010	▷1 OR ▷2
(3)	401	0.7531 0.7495	0.55 0.53 ▷3	0.0017 0.0010	▷1 OR ▷2
(5)	401	0.442 0.437	▷4	0.0017 0.0010	▷1 OR ▷2
(7)	401	0.261 0.255	▷4	0.0017 0.0010	▷1 OR ▷2
(10)	401	0.254 0.250	▷4	0.0015 0.0005	▷1 OR ▷2
(4)	403	0.3130 0.3120	▷5	0.0017 0.0010	▷1 OR ▷2
▷6	--	0.3765 0.3750	▷4	0.0017 0.0010	▷1 OR ▷2

REFINISH

CADMIUM PLATE (F-15.06)

▷1 15-5PH CRES, 180-200 KSI
▷2 17-4PH CRES, 180-200 KSI
▷3 EQUAL TO OR 0.002 LESS THAN BORE LENGTH
▷4 BORE LENGTH ±0.002
▷5 SAME AS ORIGINAL BUSHING (111)
▷6 BORE FOR BUSHING (14) IN ROD END (15)

REPAIR

63 FINISH EXCEPT AS NOTED

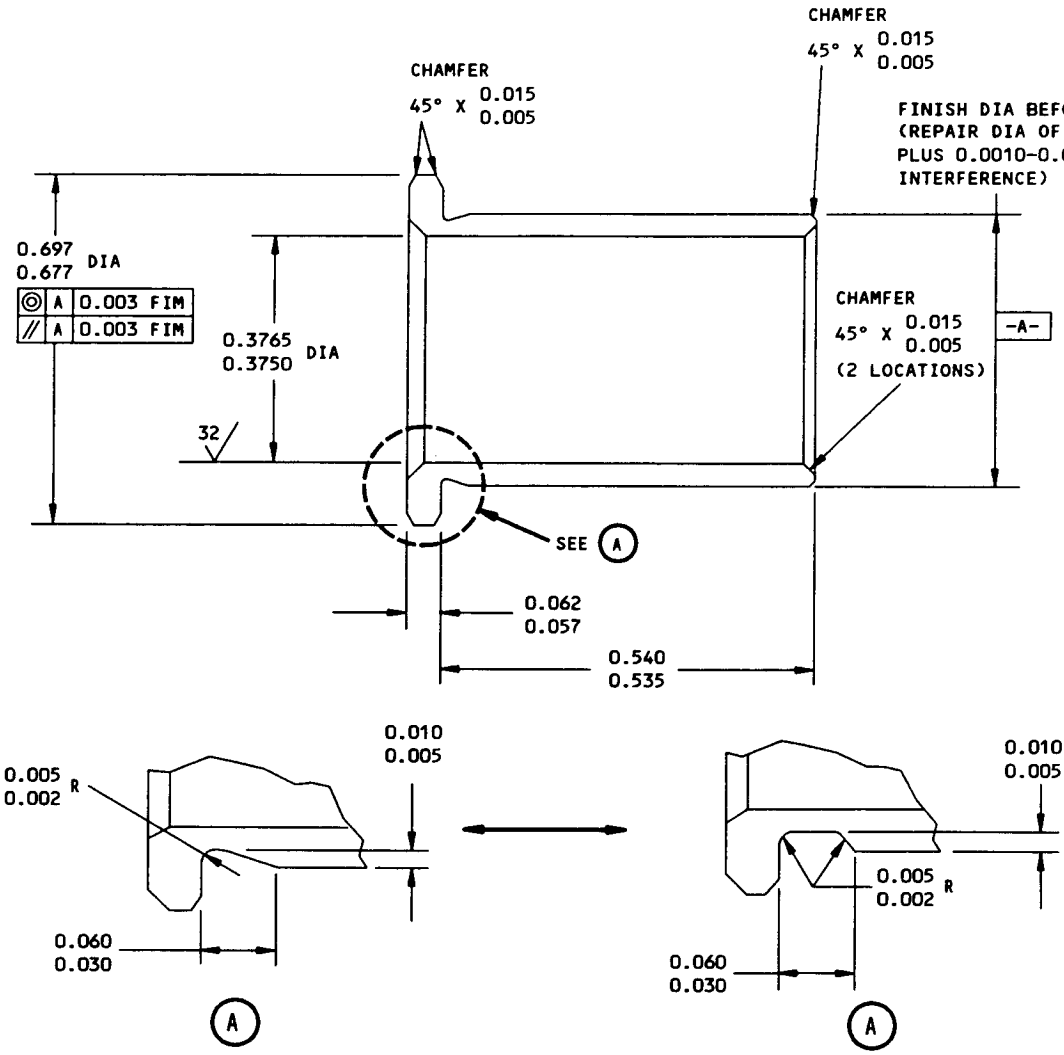
MATERIAL: AS NOTED

ALL DIMENSIONS ARE IN INCHES

DIMENSIONS APPLY AFTER PLATING

Repair Sleeve Details
Figure 404

E78968



REPAIR

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

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

MATERIAL: 17-4PH (AMS 5643) OR 15-5PH (AMS 5659), 180-200 KSI

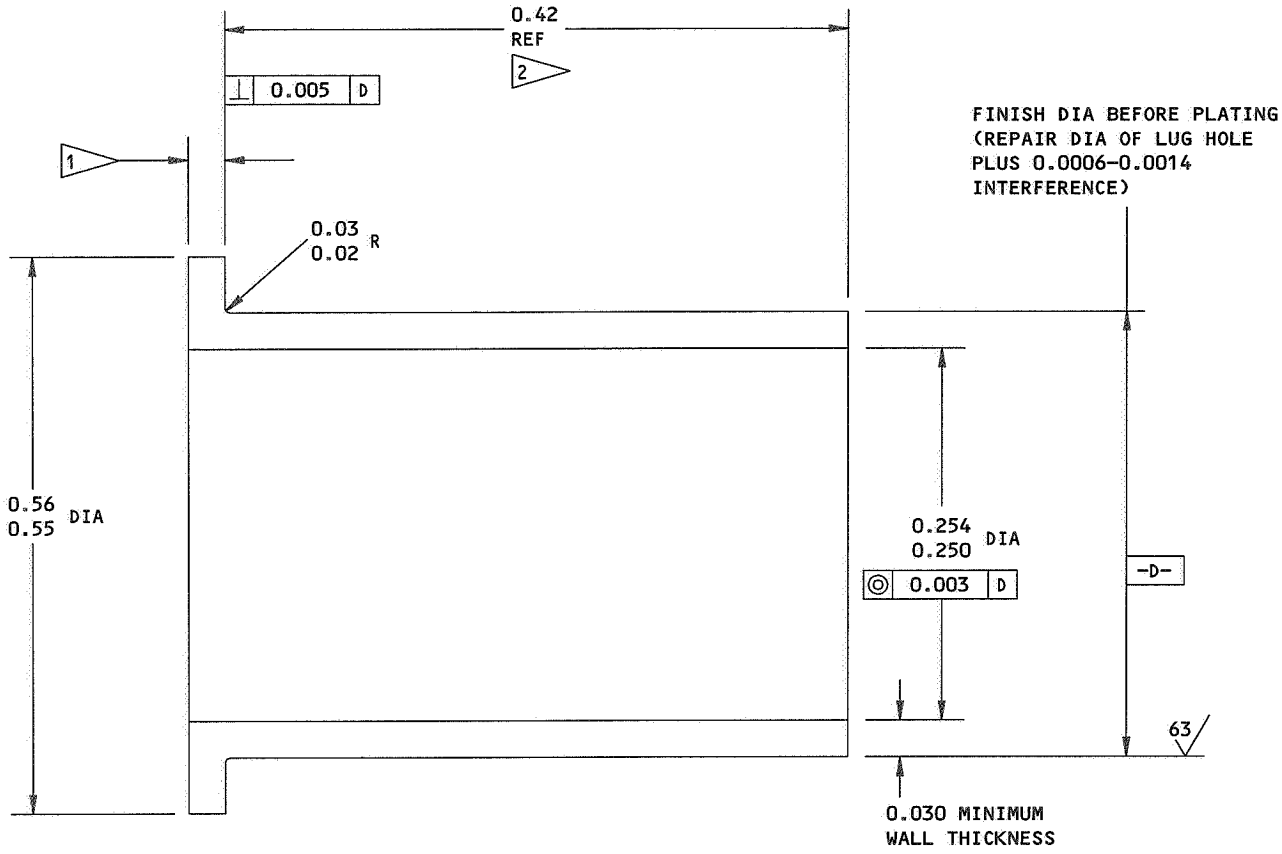
ALL DIMENSIONS APPLY BEFORE PLATING

ALL DIMENSIONS ARE IN INCHES

HOLE LOCATION (6) FIG. 401 - REPLACES BUSHING (40) BACB28X6B054

Oversize Bushing Details
Figure 405

F39240



REPAIR

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK SHARP EDGES 0.01-0.02 R

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

MATERIAL: 17-4PH (AMS 5643) OR 15-5PH CRES (AMS 5659), 180-200 KSI

ALL DIMENSIONS APPLY BEFORE PLATING

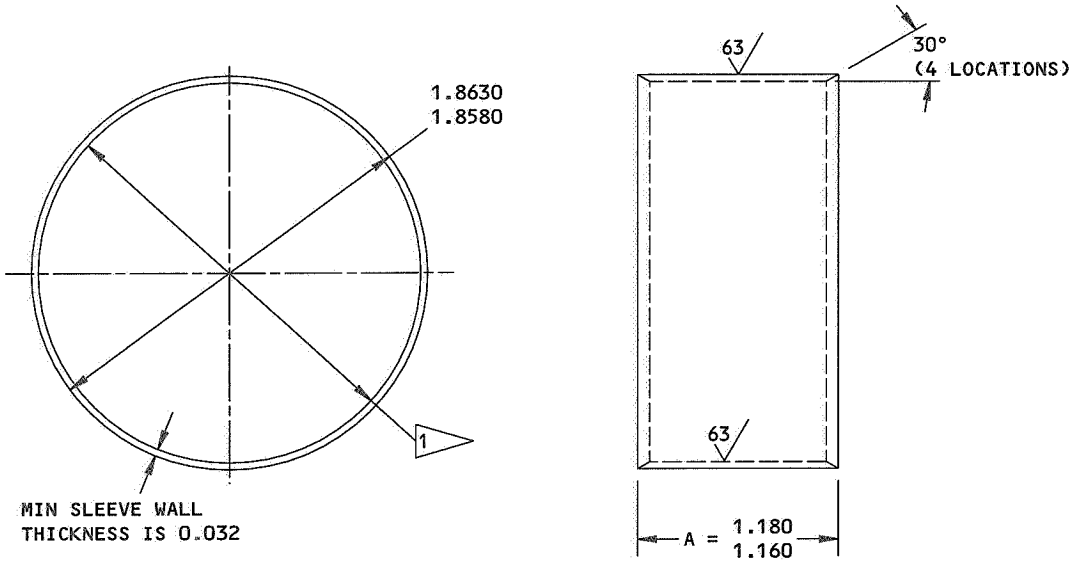
ALL DIMENSIONS ARE IN INCHES

1 SPOTFACE DEPTH PLUS 0.040

2 LENGTH TO PERMIT THE COUNTERSINK OF FIG. 401

HOLE LOCATION (8) FIG. 401

Repair Bushing Details
Figure 406



1 THE INNER DIAMETER OF THE REPAIR SLEEVE IS EQUAL TO THE OUTER DIAMETER (DIAMETER 1) OF THE SPINDLE MINUS THE INTERFERENCE OF 0.0020-0.0040

REPAIR

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

PASSIVATE (F-17.25) ALL SURFACES, CADMIUM PLATE (F-15.02)

MATERIAL: AISI 304 ANNEALED CRES BAR
AMS 5639

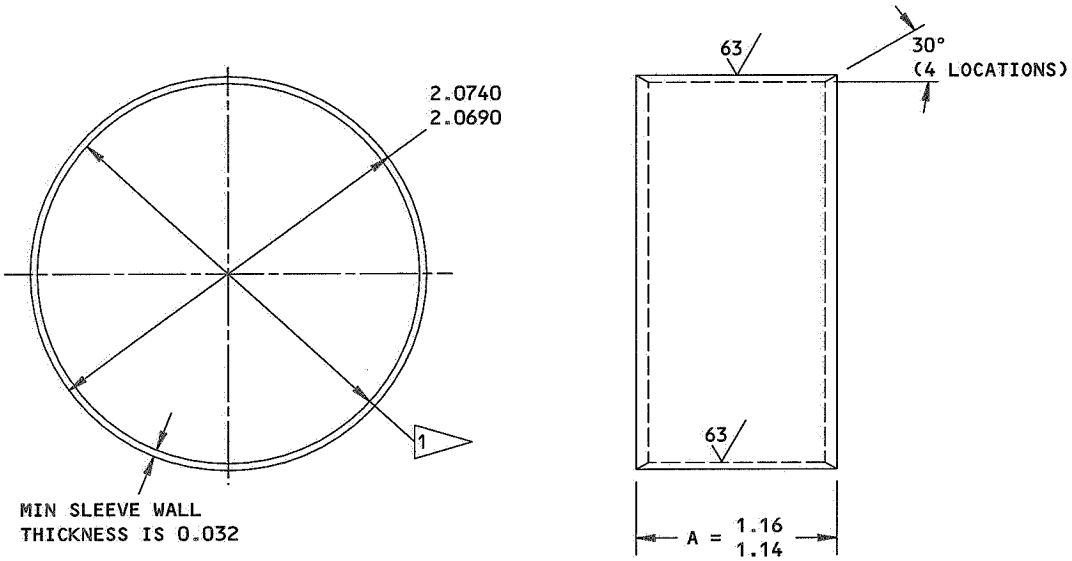
ALL DIMENSIONS ARE IN INCHES

ANGLE ±2°

REPAIR SLEEVE FOR FIG. 403 DIAMETER 1
65-47821 SPINDLES

Repair Sleeve Details
Figure 407

J83418



1 THE INNER DIAMETER OF THE REPAIR SLEEVE IS EQUAL TO THE OUTER DIAMETER (DIAMETER 1) OF THE SPINDLE MINUS THE INTERFERENCE OF 0.0020-0.0040

REPAIR

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

PASSIVATE (F-17.25) ALL SURFACES, CADMIUM PLATE (F-15.02)

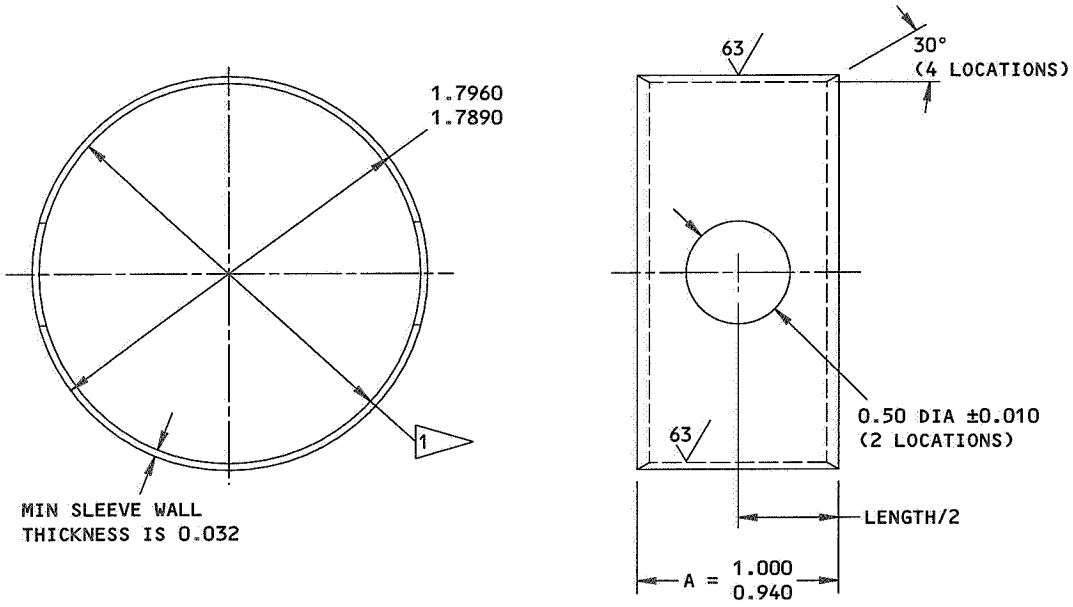
MATERIAL: AISI 304 ANNEALED CRES BAR
AMS 5639

ALL DIMENSIONS ARE IN INCHES

ANGLE ±2°

REPAIR SLEEVE FOR FIG. 403 DIAMETER 1
65-67159 SPINDLES

Repair Sleeve Details
Figure 408



1 THE INNER DIAMETER OF THE REPAIR SLEEVE IS EQUAL TO THE OUTER DIAMETER (DIAMETER 2) OF THE SPINDLE MINUS THE INTERFERENCE OF 0.0020-0.0040

REPAIR

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

PASSIVATE (F-17.25) ALL SURFACES, CADMIUM PLATE (F-15.02)

MATERIAL: AISI 304 ANNEALED CRES BAR
AMS 5639

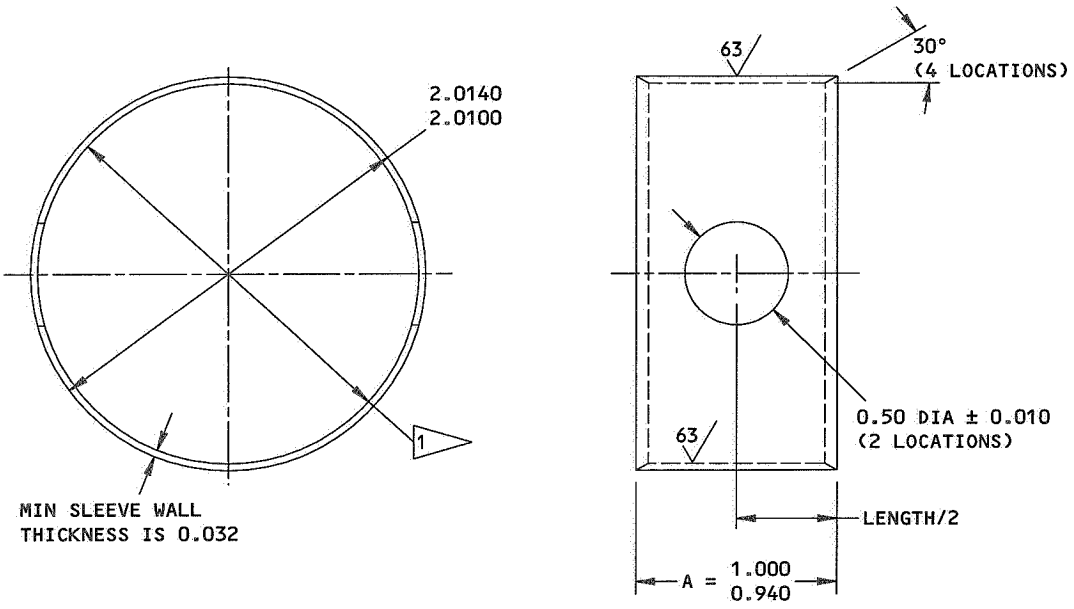
ALL DIMENSIONS ARE IN INCHES

ANGLE ±2°

REPAIR SLEEVE FOR FIG. 403 DIAMETER 2
65-47821 SPINDLES

Repair Sleeve Details
Figure 409

J83549



1 THE INNER DIAMETER OF THE REPAIR SLEEVE IS EQUAL TO THE OUTER DIAMETER (DIAMETER 2) OF THE SPINDLE MINUS THE INTERFERENCE OF 0.0020-0.0040

REPAIR

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

PASSIVATE (F-17.25) ALL SURFACES, CADMIUM PLATE (F-15.02)

MATERIAL: AISI 304 ANNEALED CRES BAR
AMS 5639

ALL DIMENSIONS ARE IN INCHES

ANGLE ±2°

REPAIR SLEEVE FOR FIG. 403 DIAMETER 2
65-67159 SPINDLES

Repair Sleeve Details
Figure 410

ASSEMBLY

NOTE: Item numbers apply to Fig. 1101, 1102 and 1103 except as noted.

1. Install bearing (107) on carriage assembly (109).

   A. 65-46481-39 thru -42, -45, -46, -49 thru -62, -69, -70

      (1) 65-46481-57 thru -60 only. Install key (Fig. 1103; 106A) with corrosion prevention compound MIL-C-11796, class 3.

      (2) Install bearing (107) on carriage assembly (109) with wet sealant, BMS 5-95.

      (3) Fillet seal per Fig. 502.

      (4) Install washer (106) and nut (104).

      (5) Tighten nut to 150-300 pound-inches (Ref SB 57-1127, Rev 2).

      (6) Use washers (105) as required to align castellations with clevis pin hole.

      (7) Install clevis pin and install lockwire through pin, make one twist and wrap each end around nut (104); bring one end around pin between head and washer (105). Twist lockwire ends per 20-50-02.

   B. 65-46481-8, -13, -14, -19, -20, -23 thru -28, -63, -64

      NOTE: For carriage assemblies 65-46481-8, -13, -14, -25 and -26 repaired by installation of 1/2-inch stud, refer to REPAIR for part numbers and assembly instructions in lieu of ASSEMBLY, step 1.

      65C10596-6, -7, -8 bearings, which have no key way, may be installed on 65-47821-23 thru -25 carriages (with Keyway) provided washer 69-61978-1 (106) is replaced per IPL and nut (104) is torqued to 1000-1200 pound-inches. Bearing 65C10596-1 (with Keyway) is preferred for such carriages. 65C10596-5 bearing has three keyways which allow the bearing to be installed in different positions to expose new contact surfaces to wear.

      Use the "KARON" lined bearings, KJB197014V-5 and KJB208015V-5 with the "KARON" bushings only. Do not intermix.

(1) 65-46481-63, -69 bond bushing (108) to carriage (109) spindle using loctite retaining compound No. 75 per 20-60-04.

(2) 65-46481-23 thru -28, -63, -64. Install bearing (107) on carriage assembly (109) with a light film of MIL-G-21164 grease.

(3) 65-46481-8, -13, -14, -19, -20. Install bearing (107) on carriage assembly (109) with a light film of MIL-G-7116 grease in I.D. of bearing (107).

(4) Install washer (106) and nut (104).

(5) Tighten nut (104) to 150-300 pound-inches.

(6) Use washers (105) as required to align castellations with clevis pin hole.

(7) Install clevis pin.

(8) Install lockwire through clevis pin (103) make one twist and wrap each end around nut (104); bring one end around clevis pin between head and washer (105). Twist lockwire ends per 20-50-02.

C. 65-46481-31 thru -34, -37, -38, -47, -48

NOTE: Use the "KARON" lined bearings, KJB197014V-5 and KJB208015V-5 with the "KARON" bushings only. Do not intermix.

(1) Install bearing (107) on carriage assembly (109).

(2) Install washer (106) and nut (104).

(3) Tighten nut (104) to 100-150 pound-inches.

(4) Use washers (105) as required to align castellations with clevis pin hole.

(5) Install clevis pin (103).

(6) Install lockwire through clevis pin (103) make one twist and wrap each end around nut (104); bring one end around clevis pin between head and washer (105). Twist lockwire ends per 20-50-02.

D. 65-79949-1 thru -10, 65-46481-1, -11, -12, -15, -16, -17, -18, -21, -22

NOTE: Use the "KARON" lined bearings, KJB197014V-5 and KJB208015V-5 with the "KARON" bushings only. Do not intermix.

65C10596-6, -7, -8 bearings, which have no keyway, may be installed on 65-47821-21 thru -22 carriages (with Keyway) provided washer 69-61978-1 (106) is replaced per IPL and nut (104) is torqued to 1000-1200 pound-inches. Bearing 65C10596-1 (with Keyway) is preferred for such carriages. 65C10596-5 bearing has three keyways which allow the bearing to be installed in different positions to expose new contact surfaces to wear.

(1) Bond bushing (108) to carriage (109) spindle using loctite retaining compound No. 75 as shown in (SOPM 20-50-12).

(a) Remove chromate treatment on cad plated shafts and bushings by lightly polishing with crocus cloth.

(2) Install bearing (107) on carriage assembly (109) with a light film of MIL-G-21164 grease on I.D. of bearing.

(3) Install washer (106) and nut (104).

(4) Tighten nut (104) to 100-150 pound-inches.

(5) Use washers (105) as required to align castellations with clevis pin hole.

(6) Install clevis pin (103).

(7) Install lockwire through clevis pin (103) make one twist and wrap each end around nut (104); bring one end around clevis pin between head and washer (105). Twist lockwire ends SOPM 20-50-02.

E. 65-46481-65, -66, -67, -72, -73, -74, -75, -76, -81, -82, -83, -84, -85, -86, -95, -96

NOTE: Use the "KARON" lined bearings, KJB197014V-5 and KJB208015V-5 with the "KARON" bushings only. Do not intermix.

(1) 65-46481-65, -66, -67, -72. Install bearing (107) on carriage assembly (109).

(2) 65-46481-73 thru -76, -81 thru -86, -95, -96. Install bearing (107) on carriage (109) with wet sealant BMS 5-95.

(3) Install washer (106) and nut (104).

(4) Tighten nut (104) to 150-300 pound-inches (Ref SB 57-1127, Rev 2).

(5) Use washers (105) as required to align castellations with clevis pin hole.

(6) Install clevis pin (103).

(7) Install lockwire through clevis pin (103), make one twist, and wrap each end around nut (104); bring one end around clevis pin between head and washer (105). Twist lockwire ends per 20-50-02.

F. 65-46481-68, -68

(1) Install bearing (107) on carriage assembly (109) with wet sealant BMS 5-95.

(2) Install washer (106) and nut (104).

(3) Tighten nut (104) to 400-600 pound-inches.

(4) Use washer (105) or a combination of washers (105) as required to align castellations with clevis pin hole.

(5) Install clevis pin (103)

(6) Install lockwire through clevis pin (103), make twist, and wrap each end around nut (104); bring one end around clevis pin between head and washer (105). Twist lockwire end per 20-50-02.

2. Coat bolt assemblies (98) and washers (101) with light film of grease, MIL-G-23827. Install bearings (102) with washers (97 and 101), bolt assemblies (98), nuts (96), and cotter pins (95). Remove 0.002-inch laminations from washers (101) as required to maintain a gap of 0.002 inch maximum between needle bearings (102) and carriage (112).

3. Install bearings (90) with bolt assemblies (92), washers (91), and bearing nuts (89). Coat all surfaces of bolt assemblies (92) with light film of grease, MIL-G-23827 prior to installation.

4. Tighten bolt assemblies (92) to within a torque range of 175 to 425 pound-inches and install cotter pins (88).

5. Preassemble forward side roller assemblies (71 and 79) as follows:

A. Install bearings (77 and 85) on brackets (78 and 86) with bolt assemblies (74 and 82) and spring pins (73 and 81).

B. Secure spring pins (73 and 81) to brackets (78 and 86) with lockwire (72 and 80) per 20-50-02. Apply wet BMS 10-11, Type 1 primer to faying surfaces of bolt assemblies (74 and 82), spring pins (73 and 81), and brackets (78 and 86) immediately prior to installation.

6. Install preassembled forward side roller assemblies (71 and 79) using shims (87), washers (70), and bolts (69). Lockwire heads of bolts (69) together using double twist method per 20-50-02. Remove 0.002-inch laminations from shims (87) as required to maintain a dimension of 0.670 to 0.675 inch from roller surface of bearings (77 and 85) to centerline of carriage (112) as shown in Fig. 501. Apply BMS 10-11, Type 1 primer to delaminated surface of shims (87). Coat all surfaces of bolts (69) with light film of grease, MIL-G-23827, prior to installation.

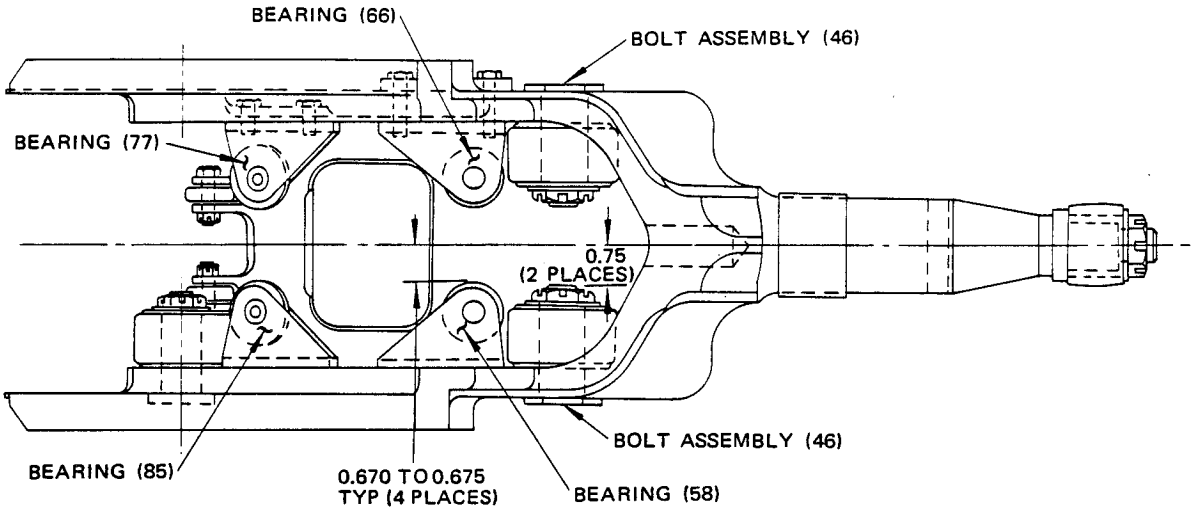
7. Preassemble aft side roller assemblies (52 and 60) as follows:

   A. Install bearings (58 and 66) on brackets (59 and 67) with bolt assemblies (55 and 63) and spring pins (54 and 62).

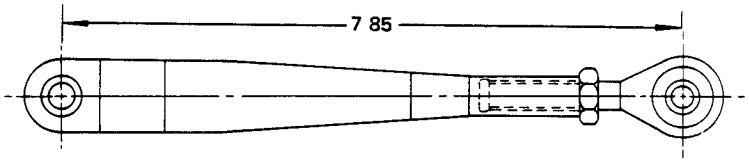
   B. Secure spring pins (54 and 62) to brackets (59 and 67) with lockwire (53 and 61). Apply wet BMS 10-11, Type 1 primer to faying surfaces of bolt assemblies (55 and 63), spring pins (54 and 62), and brackets (59 and 67) immediately prior to installation.

8. Install preassembled aft side roller assemblies (52 and 60) using shims (68), washers (50), radius fillers (51), and bolts (49). Lockwire heads of bolts (49) together using double twist method per 20-50-02. Remove 0.002-inch laminations from shims (68) as required for a dimension of 0.670 to 0.675 inch from roller surface of bearings (58 and 66) to centerline of carriage (112) as shown in Fig. 501. Apply BMS 10-11, Type 1 primer to delaminated surface of shims (68). Coat all surfaces of bolts (49) with light film of grease, MIL-G-23827, prior to installation. To improve access to roller lubrication fittings, roller assemblies 52 and 60 may be interchanged to place lube fittings on upper side.

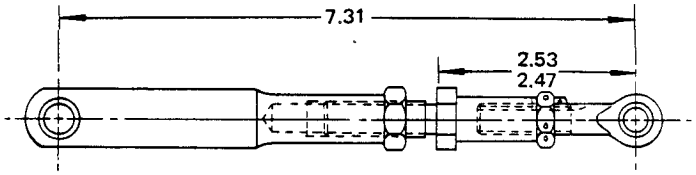
9. Install bearings (43) using bolt assemblies (46), shim washers (45), rub strips (44), bearing nuts (42), and cotter pins (41). Loose fit bolt assemblies (6) through sides of carriage (112) to align upper holes in rub strips (44) and tighten bolt assemblies (46) to within a torque range of 200 to 500 pound-inches. Coat all surfaces of bolt assemblies (46) with light coat of grease, MIL-G-23827, prior to installation. Remove 0.002-inch laminations from shim washers (45) as required to maintain a dimension of 0.75 inch minimum from threaded end of bolt assemblies (46) to centerline of carriage (112) as shown in Fig. 501. Apply one coat of BMS 10-11, Type 1.



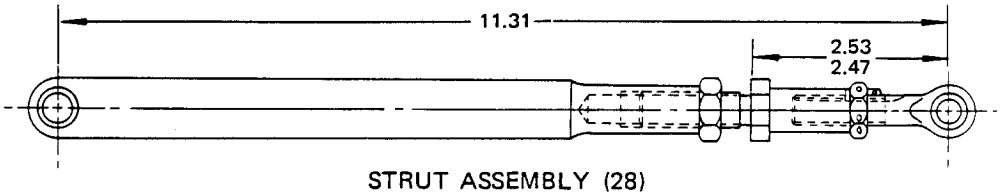
NOTE: ALL DIMENSIONS IN INCHES



STRUT ASSEMBLY (9)

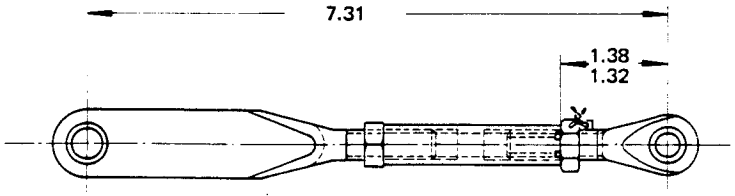


STRUT ASSEMBLY (16)



STRUT ASSEMBLY (28)

NOTE: ALL DIMENSIONS IN INCHES



STRUT ASSEMBLY (113)

primer followed by one coat of BMS 10-11, type 2 enamel, color BAC707 to delaminated surface of shim washers (45) per 20-41-02, Application of Chemical and Solvent Resistant Finishes. Install cotter pins (41) per 20-50-02, Installation of Safetying Devices, so that pin ends do not extend beyond end of bolt assemblies (46).

10. Preassemble parts of applicable strut assemblies (9, 16, 28 and 113) as follows:

A. Strut Assemblies (16 and 28)

(1) Install nuts (21 and 33) and locks (22 and 34) on rod end assemblies (18 and 30).

(2) Screw rod end assemblies (18 and 30) with attached parts into couplings (23 and 35) and adjust length to dimensions shown in figure 501.

NOTE: Assemble rod end assemblies (18 and 30) and couplings (23 and 35) with thin coat of corrosion preventive compound, Specification MIL-C-16173, grade 2 on both internal and external surfaces of mating threads.

(3) Tighten nuts (21 and 33) to within a torque range of 20 to 40 pound-inches and secure nuts to locks (22 and 34) with lockwire (17 and 29) per double twist method.

(4) Screw nuts (24 and 36) on couplings (23 and 35); install sleeves (24A), if applicable, and couplings (23 and 35) on rod end assemblies (25 and 37); adjust length to dimensions shown in figure 501.

NOTE: Assemble rod end assemblies (25 and 37) and couplings (23 and 35) with thin coat of corrosion preventive compound, Specification MIL-C-16173, grade 2 on both internal and external surfaces of mating threads.

(5) Tighten nuts (24 and 36) to within a torque range of 30 to 50 pound-inches.

B. Strut Assemblies (9)

(1) Install nuts (12) on rod ends (11), screw rod ends into rod end assemblies (13), and adjust length to dimension shown in Fig. 501.

NOTE: Assemble rod ends (11) and rod end assemblies (13) with thin coat of corrosion preventive compound, Specification MIL-C-11796, class 3 on mating surfaces of threads.

(2) Tighten nuts (12) to within a torque range of 20 to 40 pound-inches and secure nut with lockwire (10) per double twist method.

C. Strut Assembly (113)

(1) Prior to assembly, apply to all threads of parts of strut assembly thin coat of MIL-C-16173, grade 2, corrosion preventive compound.

(2) Insert lock (114) in slot of rod end (123). Screw nut (115) on rod end.

(3) Screw nut (116) on rod end (120). Screw both rod ends into coupling (117). Adjust to dimensions shown in Fig. 501.

(4) Tighten nuts (115 and 116) within torque range of 20 to 40 pound-inches. Lockwire nut (115) to lock (114).

11. Install applicable strut assemblies (9 or 16 and 28) using bolt assemblies (6), washers (8A, 8B, Fig. 1101, 1102), if applicable, washers (3, 5), bearings (4), nuts (2), and cotter pins (1).

12. Bearing Installation (Fig. 1101 and 1103; 108D)

A. Line ream the spindle bushing (111) and the bearing bushings to 0.3120-0.3130 inch diameter.

NOTE: If the bushings in the bearing (108D) are to be replaced, replace only with identical bushings. Install bushings as shown in (SOPM 20-50-03).

B. Temporary install the bearing (108D) onto the carriage spindle with the bolt (108C), washers (108B, 108E) and nut (108A).

NOTE: The bearing will be removed at final installation. The application of applicable sealant will be accomplished at final installation.

13. After assembly of carriage assembly apply sealant as shown on Fig. 502.

NOTE: Flagnote 2 to be accomplished after final installation.

14. Materials

NOTE: Use listed materials or equivalent substitutes.

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

B. Enamel -- BMS 10-11, Type 2, color BAC707 (SOPM 20-60-02)

C. Grease -- Specification MIL-G-23827 (SOPM 20-60-03)

D. Grease -- Specification MIL-G-21164 (SOPM 20-60-03)

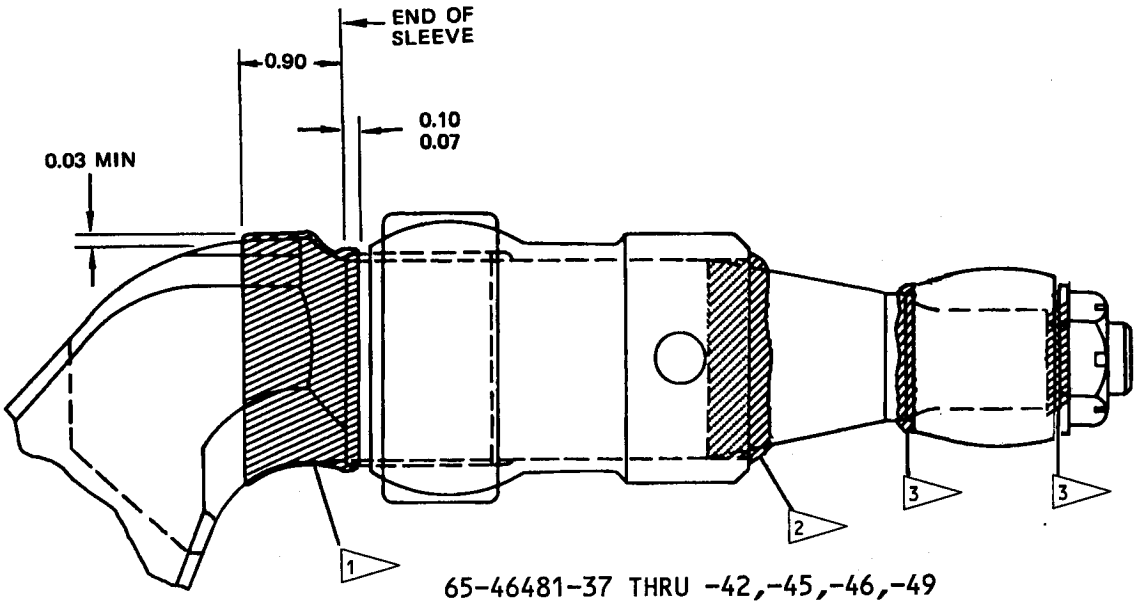
E. Corrosion Preventive Compound -- MIL-C-16173, grade 2 (SOPM 20-60-03)

F. Corrosion Preventive Compound -- MIL-C-11796, class 3 (SOPM 20-60-03)

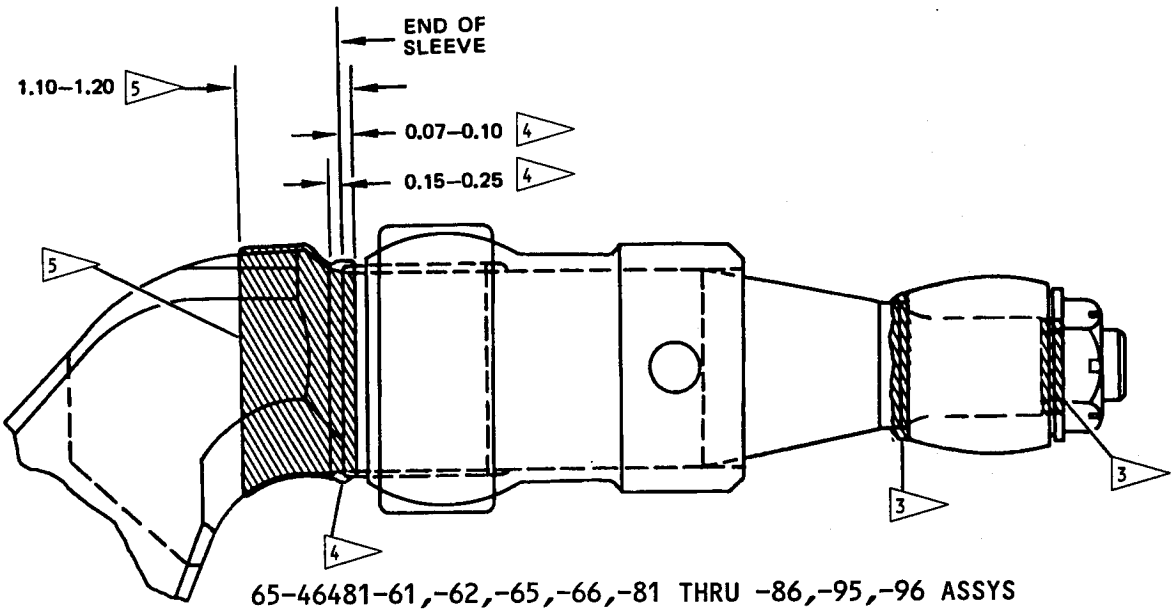
G. Sealant -- BMS 5-95 (SOPM 20-60-04)

H. Abrasion resistant teflon coating -- BMS 10-86, gray (SOPM 20-60-02)

I. Compound -- Loctite 75 (SOPM 20-60-04)



65-46481-37 THRU -42,-45,-46,-49 THRU -60,-69,-70 ASSYS



65-46481-61,-62,-65,-66,-81 THRU -86,-95,-96 ASSYS

1. BRUSH COAT SEAL WITH BMS 5–95 TO DIMENSIONS SHOWN. APPLY GRAY GLOSS ENAMEL BMS 10–60 (SRF–14.9813) OVER SEALANT.
2. FILLET SEAL WITH BMS 5–95, APPLY AFTER INSTALLATION INTO MIDFLAP.
3. FILLET SEAL WITH BMS 5–95. DO NOT ALLOW SEALANT TO FLOW ONTO BEARING, OUTER DIAMETER
4. FILLET SEAL WITH BMS 5–95 TO DIMENSIONS SHOWN
5. APPLY ONE COAT BMS 10–11, TYPE 1 PRIMER PLUS ABRASION RESISTANT TEFLON COATING (SRF 14.9625)

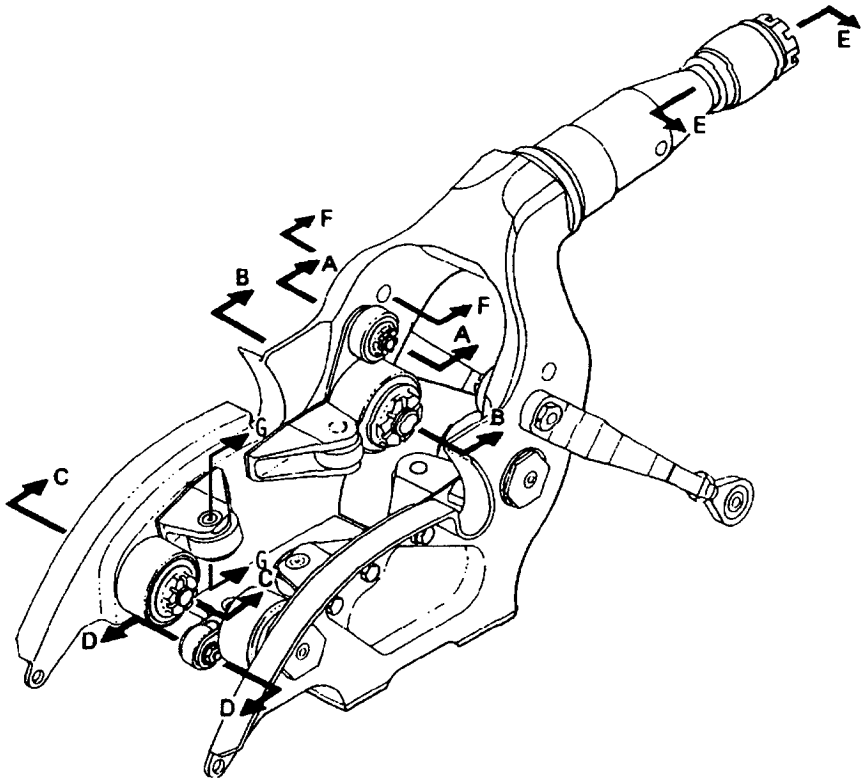
NOTE: ALL DIMENSIONS IN INCHES

Spindle Sealing Details
Figure 502

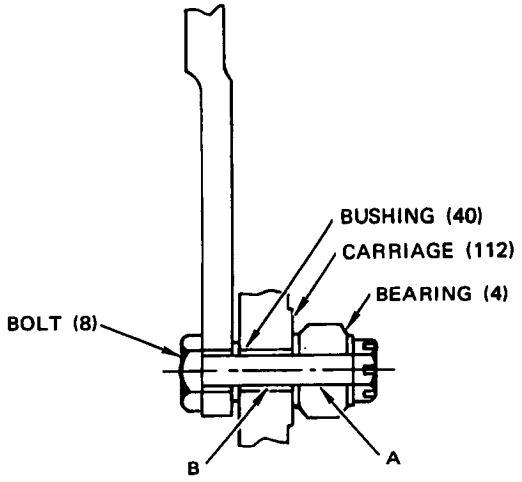
W51558

FITS AND CLEARANCES

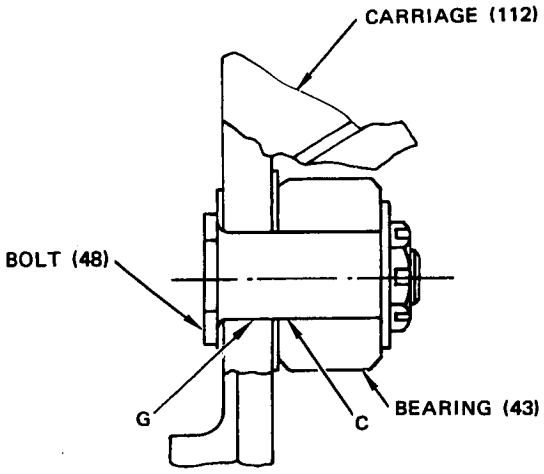
1. The fits and clearances table lists design dimensions and service wear limits for close tolerance parts of the assembly that are subject to wear or corrosion. Unless otherwise specified, parts should be returned to the design dimensions whenever rework is accomplished.
2. Clearances are given to aid 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.



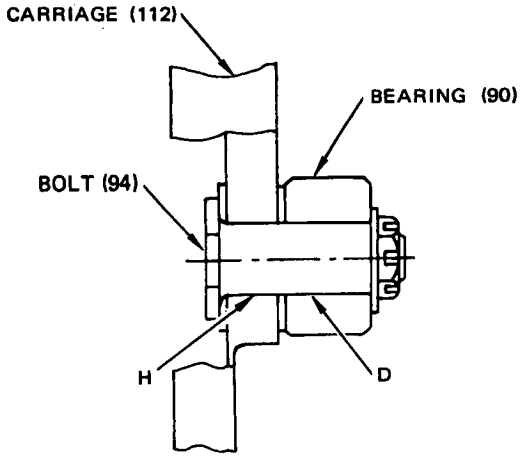
Fits and Clearances
Figure 601 (Sheet 1)



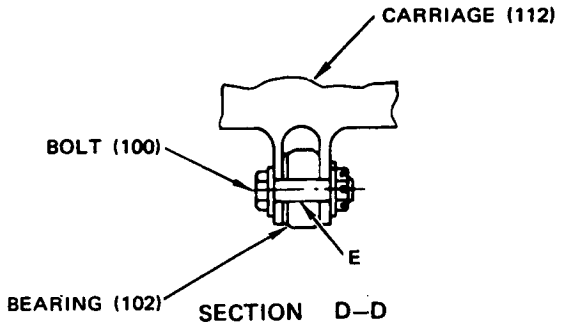
SECTION A–A



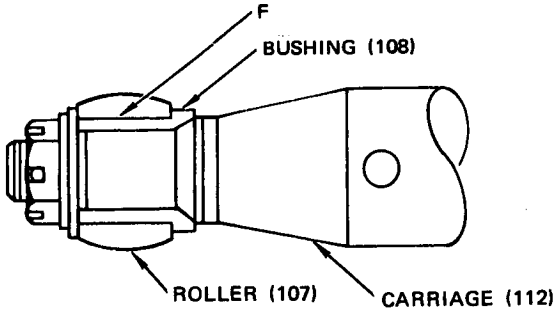
SECTION B–B

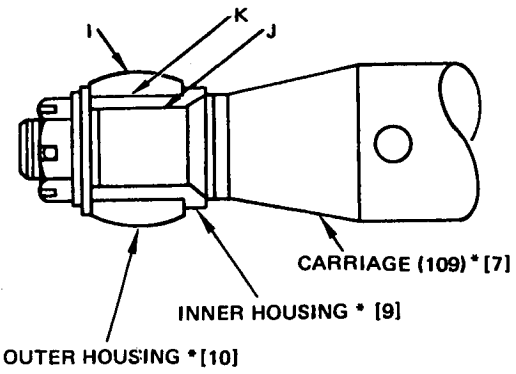


SECTION C–C

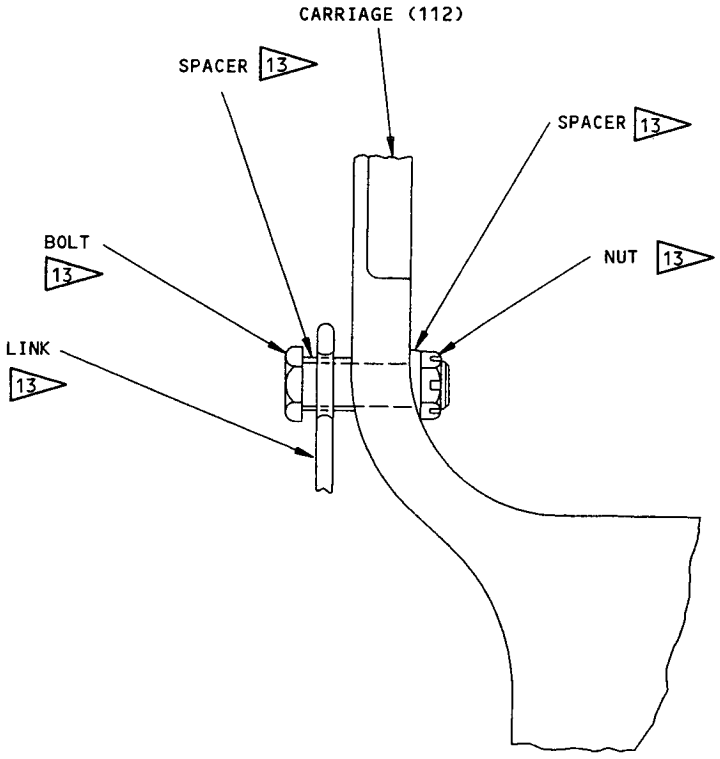


SECTION D–D

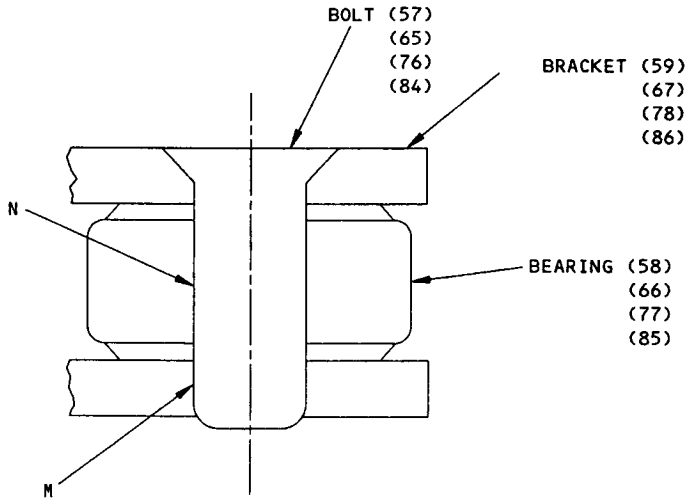




SECTION E–E



SECTION F-F



SECTION G-G

Fits and Clearances
Figure 601 (Sheet 3)

Ref Letter Fig. 5	Mating Item No. Fig. 7	Design Dimensions				Service Wear Limits		
		Dimensions (inches)		Assembly Clearance (inch) *[8]		Dimension Limits (inches)		Maximum Allowable Clearance (inch)
		Min	Max	Min	Max	Min	Max	
A	ID 4	0.3743	0.3750	-0.0002	0.0015		0.3775	0.0030
	ID 8	0.3735	0.3745			0.3713		
B	ID 40	0.3750	0.3765	0.0005	0.0030		0.3905	0.0060
	OD 8	0.3745				0.3690		
C	ID 43	0.8743	0.8750	0.0000	0.0013			0.0026
	OD 48	0.8737	0.8743			0.8717		
D	ID 90	0.7493	0.7500	0.0000	0.0013		0.7519	0.0026
	OD 94	0.7487	0.7493			0.7467		
E	ID 102	0.2493	0.2500	-0.0002	0.0015		0.2525	0.0030
	OD 100	0.2485	0.2495			0.2463		
F	ID 107*[1]	1.1265	1.1315	0.0010	0.0065		1.1385 *[11]	0.0130
	OD 108*[2]	1.1250	1.1255			1.1135		
F	ID 107*[4]	1.0520	1.0525	0.0025	0.0035		1.0625	0.0130
	OD 108*[5]	1.0490	1.0495			1.0390		
G	ID 112	0.8745	0.8781	0.0002	0.0044			0.0088
	OD 48	0.8737	0.8743			0.8717		
H	ID 112	0.7495	0.7531	0.0002	0.0044			0.0088
	OD 94	0.7487	0.7493			0.7421		
I	OD 107*[6]	1.4990	1.5000			1.4645		
J	ID 107*[6]	0.8740	0.8745	-0.0016	0.0003		0.8770	0.003
	OD 109*[7]	0.8742	0.8756			0.8726		
K	ID *[10]	1.0510	1.0520	0.001	0.003		1.0530	0.0050
	OD *[9]	1.0490	1.0490			1.0480		
L	ID 112	0.437	0.442	0.000	0.006		1.0530	0.008
	OD *[12]	0.436	0.437			0.429		
M	ID *[14]	0.3755	0.3765	0.0003	0.0016			
	ID *[15]	0.3749	0.3752					
N	ID *[16]	0.3743	0.3750	-0.0009	0.0001			
	OD *[15]	0.3749	0.3752					

Fits and Clearances
Figure 601 (Sheet 4)

*[1] Part Number 66-23216-1
*[2] Part Number 69-46448-1
*[3] Part Number 66-23215-1
*[4] Part Number LA5941A
*[5] Part Number 69-49147-1
*[6] Part Number KJB197014V1
*[7] Part Numbers 65-46481-95, -96 only
*[8] Minus sign denotes interference fit
*[9] KJB197014V3
*[10] KJB197014V5
*[11] Different service wear limits for 66-23216-1 are a result of different mating parts.
*[12] Link Support Bolt Ref OHM 57-53-32
*[13] Ref OHM 57-53-32
*[14] Part Number 69-35323-3, -4, 65C16951-3, -4, 69-35324-3, -4, 65C16950-3, -4
*[15] Part Number 66-23220-3
*[16] Part Number BACB10B132, BACB10ET06

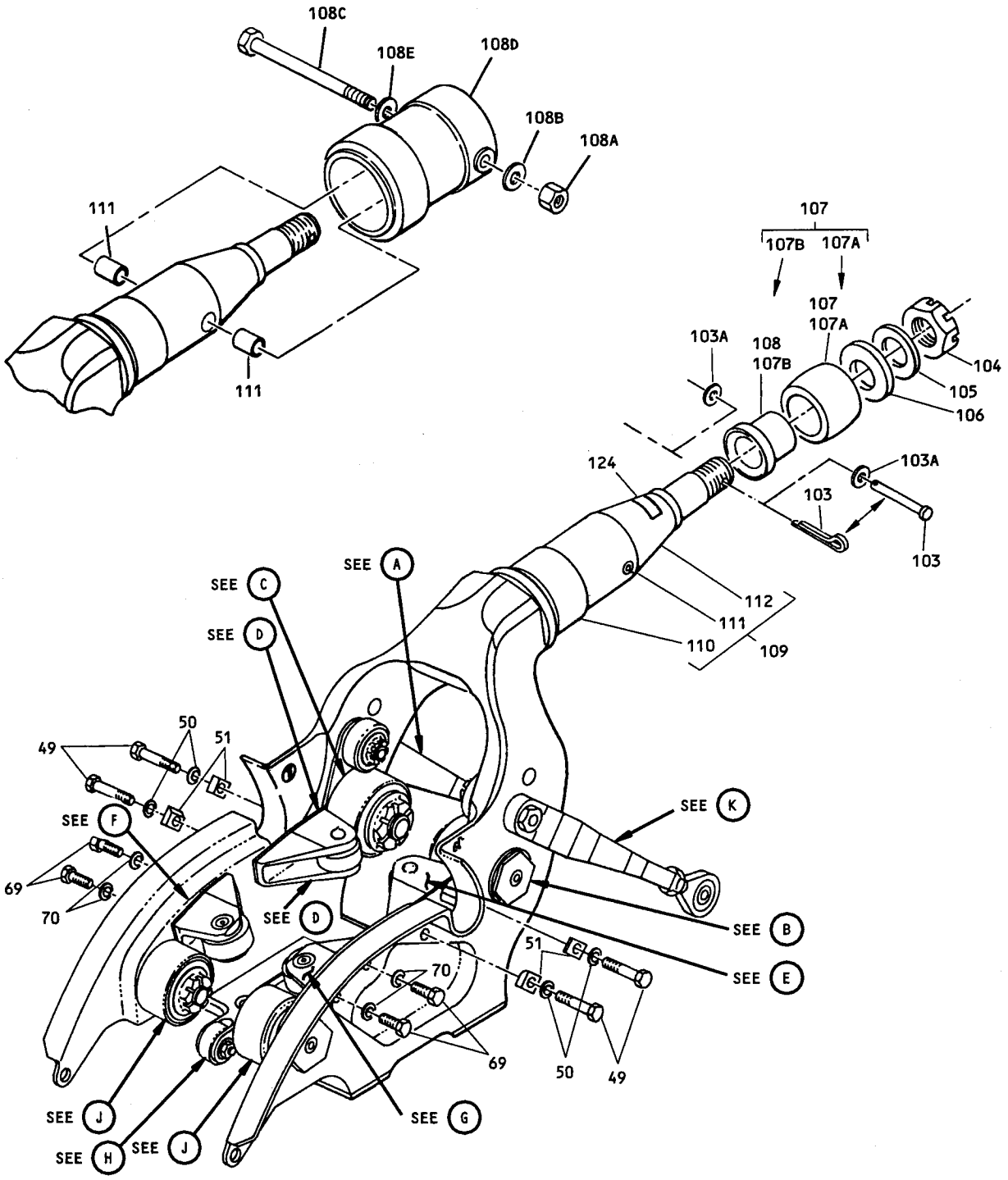
Fits and Clearances
Figure 601 (Sheet 5)

STORAGE INSTRUCTIONS

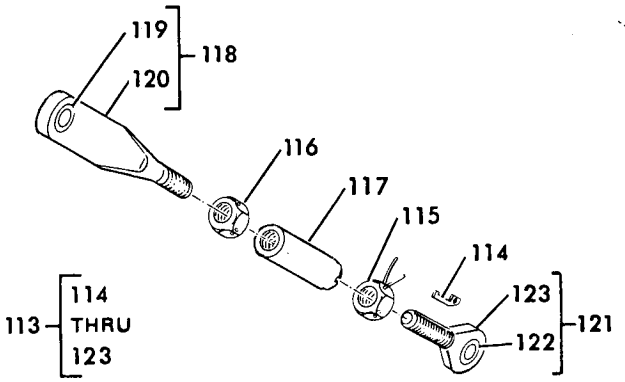
1. Wrap entire assembly in vapor barrier paper. Tag with overhaul date.

2. Provide a suitable surrounding structure to prevent handling damage.

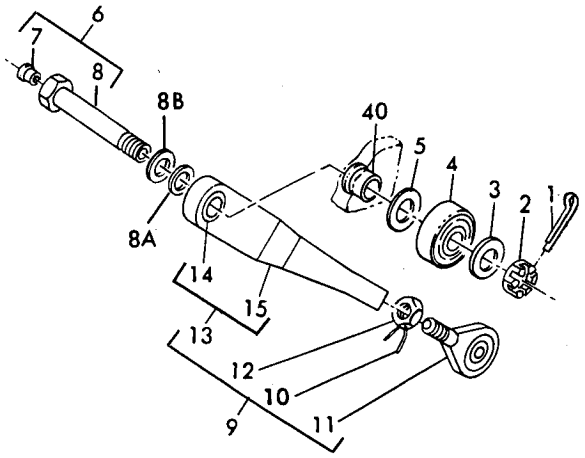
3. For further information, refer to "Temporary Protective Coatings," Subject 20-44-02.



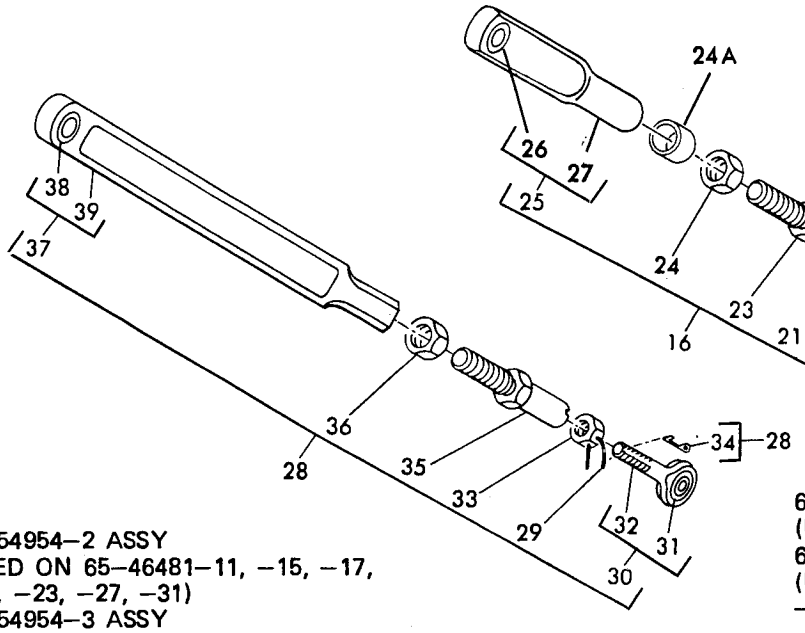
Outboard Flap Carriage Assembly
Figure 1101 (Sheet 1)



69–59869–1 ASSY
(USED ON 65–46481–1, –12, –16, –18, –22, –24, –28, –32, –34, –38)



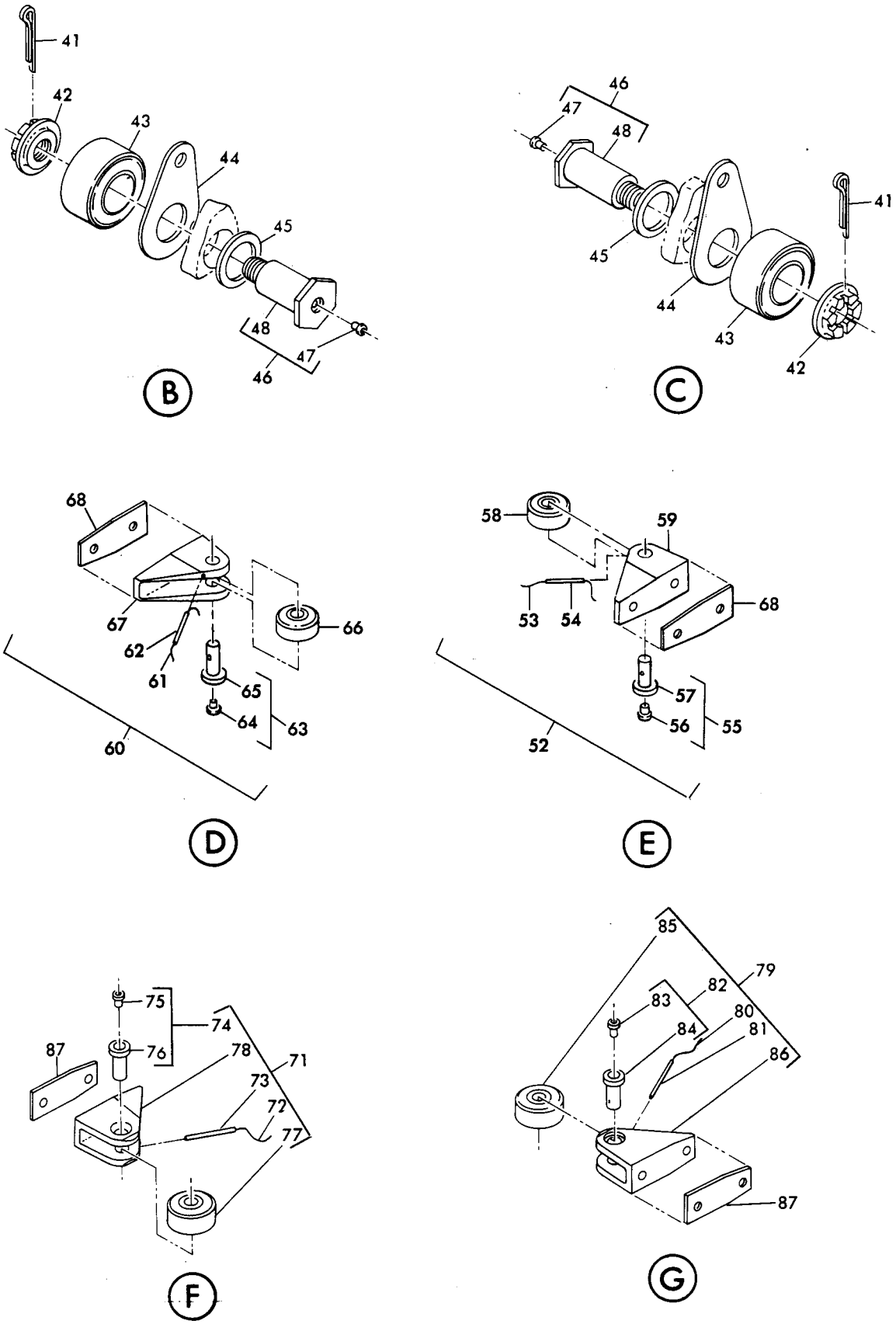
69–39245–1 ASSY
(USED ON 65–46481–1)



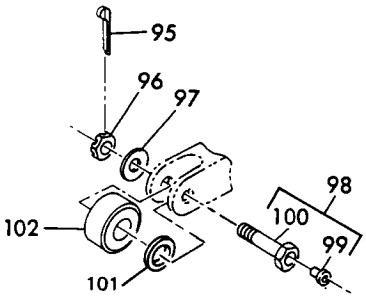
69–54954–2 ASSY
(USED ON 65–46481–11, –15, –17, –21, –23, –27, –31)
69–54954–3 ASSY
(USED ON 65–46481–33, –37)

69–54954–1 ASSY
(USED ON 65–46481–12,)
65–76161–3 ASSY
(USED ON 65–46481–1, –12, –16, –18, –22, –24, –28)

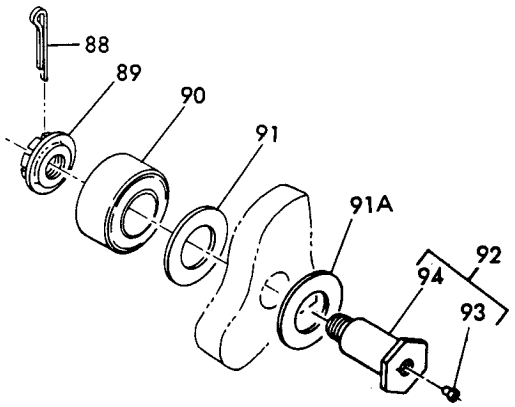
(A)



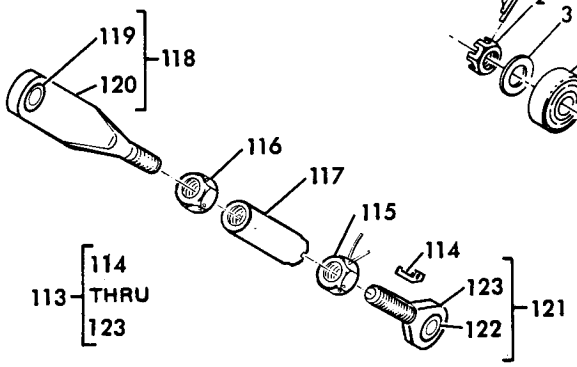
Outboard Flap Carriage Assembly
Figure 1101 (Sheet 3)



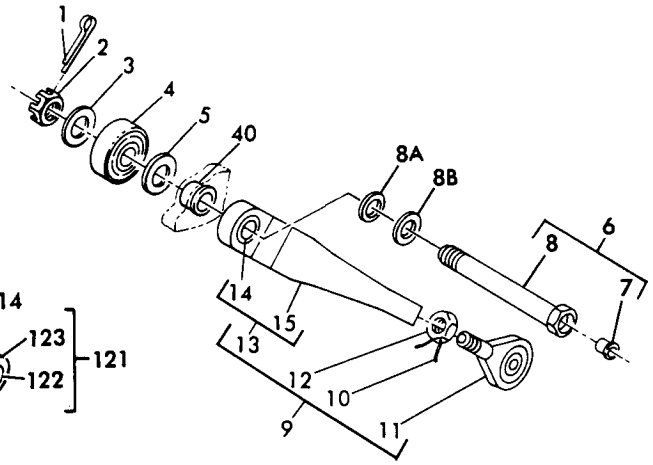
(H) (TYPICAL 2 LOCATIONS)



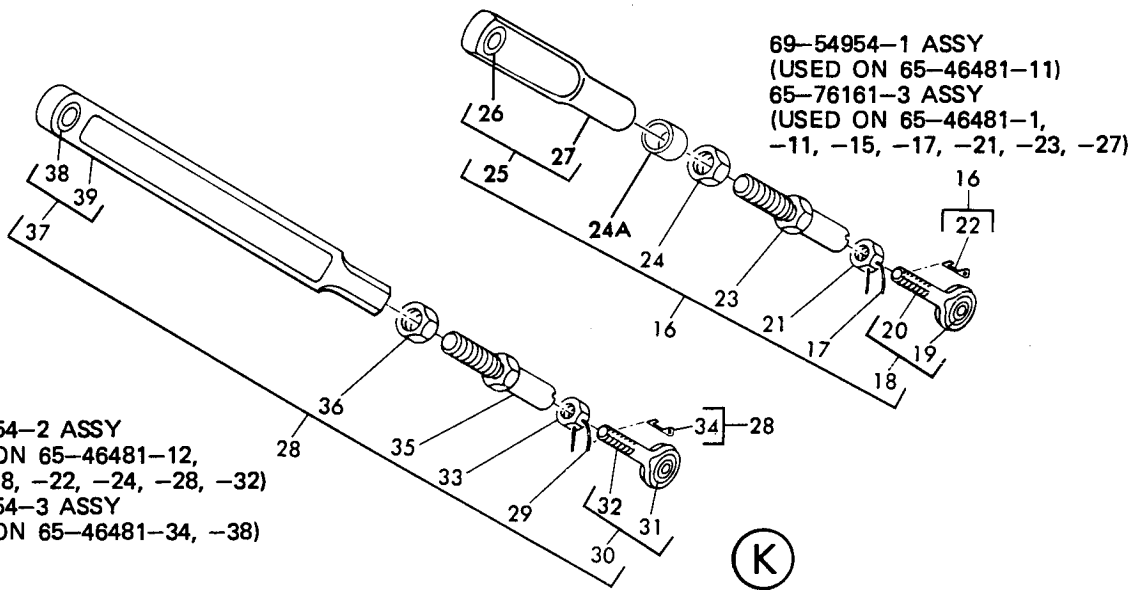
(J) (TYPICAL)



69–59869–1 ASSY
(USED ON 65–46481–1, –11, –15, –17, –21, –23, –27, –31, –33, –37,)



69–39245–1 ASSY
(USED ON 65–46481–1)



69–54954–1 ASSY
(USED ON 65–46481–11)
65–76161–3 ASSY
(USED ON 65–46481–1, –11, –15, –17, –21, –23, –27)

69–54954–2 ASSY
(USED ON 65–46481–12, –16, –18, –22, –24, –28, –32)
69–54954–3 ASSY
(USED ON 65–46481–34, –38)

(K)

Outboard Flap Carriage Assembly
Figure 1101 (Sheet 4)

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
	65-46481-1		CARRIAGE ASSY *[6] *[8] *[10] *[15]	A	RF
	65-46481-11		CARRIAGE ASSY *[6] *[8] *[10] *[11] *[15]	B	RF
	65-46481-12		CARRIAGE ASSY *[7] *[8] *[10] *[12] *[15]	C	RF
	65-46481-15		CARRIAGE ASSY *[6] *[8] *[10] *[11] *[15]	D	RF
	65-46481-16		CARRIAGE ASSY *[7] *[8] *[10] *[12] *[15]	E	RF
	65-46481-17		CARRIAGE ASSY *[6] *[8] *[10] *[11] *[15]	F	RF
	65-46481-18		CARRIAGE ASSY *[7] *[8] *[10] *[12] *[15]	G	RF
	65-46481-21		CARRIAGE ASSY *[6] *[8] *[10] *[11] *[15]	H	RF
	65-46481-22		CARRIAGE ASSY *[7] *[8] *[10] *[12] *[15]	I	RF
	65-79949-1		CARRIAGE ASSY (65-46481-11,-15 REWKD) *[10] *[15]	J	RF
	65-79949-2		CARRIAGE ASSY (65-46481-12,-16 REWKD) *[10] *[15]	K	RF
	65-79949-3		CARRIAGE ASSY (65-46481-17 REWKD) *[10] *[15]	L	RF
	65-79949-4		CARRIAGE ASSY (65-46481-18 REWKD) *[10] *[15]	M	RF
	65-79949-5		CARRIAGE ASSY (65-46481-21 REWKD) *[10] *[15]	N	RF
	65-79949-6		CARRIAGE ASSY (65-46481-22 REWKD) *[10] *[15]	O	RF
	65-46481-23		CARRIAGE ASSY *[6] *[8] *[10] *[11] *[15]	P	RF
	65-46481-24		CARRIAGE ASSY *[7] *[8] *[10] *[12] *[15]	Q	RF
	65-46481-27		CARRIAGE ASSY *[6] *[8] *[11] *[15]	R	RF
	65-46481-28		CARRIAGE ASSY *[7] *[8] *[12] *[15]	S	RF
	65-46481-31		CARRIAGE ASSY *[6] *[8] *[11] *[15]	T	RF
	65-46481-32		CARRIAGE ASSY *[7] *[8] *[12] *[15]	U	RF
	65-46481-33		CARRIAGE ASSY *[6] *[8] *[11] *[15]	V	RF
	65-46481-34		CARRIAGE ASSY *[7] *[8] *[12] *[15]	W	RF
	65-46481-37		CARRIAGE ASSY *[11] *[15]	X	RF
	65-46481-38		CARRIAGE ASSY *[12] *[15]	Y	RF
1	MS24665-304		. PIN, COTTER		2
2	BACN10JD106		. NUT (REPLS AN320-6)		2
3	AN960-616L		. WASHER		2
4	BACB10B132		. BEARING		2
5	AN960C616		. WASHER		2
5	AN960C616L		. WASHER (OPT TO AN960C616)		2
6	69-39243-3		. BOLT ASSY		2
7	NAS516-1		. . FITTING, LUBRICATION		1
8	69-39243-4		. . BOLT		1
8A	AN960PD616		. WASHER (USED WITH 65-6161-3)	A	2
8A	AN960PD616		. WASHER (USED WITH 65-76161-3)	B-Q	1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
8B	BACW10BN6AC		. WASHER (USED WITH 65-76161-3)	A	2
8B	BACW10BN6ANC		. WASHER (USED WITH 65-76161-3)(OPT TO BACW10BN6AC)	A	2
8B	BACW10BN6AC		. WASHER (USED WITH 65-76161-3)	B-Q	1
8B	BACW10BN6ANC		. WASHER (USED WITH 65-76161-3)(OPT TO BACW10BN6AC)	B-Q	1
9	69-39245-1		. STRUT ASSY *[2]	A	2
10	MS20995C32		. . LOCKWIRE (SB 57-1007)		AR
11	77261		. . ROD END, V09455 (BOEING 10-60799-158)		1
11	REMS10ATC12		. . ROD END, V21335 (BOEING 10-60779-158)		1
11	TFM-105-S		. . ROD END, V77896 (BOEING 10-60779-158)		1
11	DREM-5-076		. . ROD END, V81376 (BOEING 10-60779-158)		1
12	NAS509-6		. . NUT (SB 57-1007)		1
13	69-42367-3		. . ROD END ASSY (SB 57-1007)		1
13	69-42367-5		. . ROD END ASSY (SB 57-1007)		1
14	BACB28Y6B33		. . . BUSHING		1
15	69-42367-4		. . . ROD END (USED ON 69-42367-3)		1
15	69-42367-6		. . . ROD END (USED ON 69-42367-5)		1
16	65-76161-3		. STRUT ASSY (OPT TO 69-59869-1) *[2]	A-Q	1
16	69-54954-1		. STRUT ASSY *[2]	BC	1
16	65-76161-3		. STRUT ASSY	RS	2
17	MS20995C32		. . LOCKWIRE		AR
18	69-54956-1		. . ROD END ASSY (USED ON 69-54954-1)		1
18	65-76161-9		. . ROD END ASSY (USED ON 65-76161-3)		1
19	BACB28Y5B31		. . . BUSHING (USED ON 69-54956-1)		1
19	BACB28Y5B19		. . . BUSHING (USED ON 65-76161-9)		1
20	69-54956-2		. . . ROD END (USED ON 69-54956-1)		1
20	65-76161-8		. . . ROD END (USED ON 65-76161-9)		1
21	NAS509-6		. . NUT (USED ON 69-54954-1)		1
22	NAS559-2		. . LOCK (USED ON 69-54954-1)		1
23	69-54958-1		. . COUPLING		1
24	AN316-7L		. . NUT (USED ON 69-54954-1)		1
24	NAS509L7		. . NUT (USED ON 65-76161-3)		1
24A	65-76161-5		. . SLEEVE (USED ON 65-76161-3)		1
24A	NAS43HT7-21		. . BUSHING (OPT TO 65-76161-5 ON 65-76161-3)		1
24A	NAS43DD7-21		. . BUSHING (OPT TO 65-76161-5 ON 65-76161-3)		1
25	69-54955-1		. . ROD END ASSY (USED ON 69-54954-1)		1
25	65-76161-7		. . ROD END ASSY (USED ON 65-76161-3)		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
26	BACB28Y6B33		. . . BUSHING (USED ON 69-54955-1)		1
26	BACB28Y6B21		. . . BUSHING (USED ON 65-76161-7)		1
27	69-54955-2		. . . ROD END (USED ON 69-54955-1)		1
27	65-76161-6		. . . ROD END (USED ON 65-76161-7)		1
28	69-54954-3		. STRUT ASSY (REPLS 69-54954-2)	V-Y	1
28	69-54954-2		. STRUT ASSY	B-U	1
29	MS20995C32		. . LOCKWIRE		AR
30	69-54956-1		. . ROD END ASSY		1
31	BACB28Y5B31		. . . BUSHING		1
32	69-54956-2		. . . ROD END		1
33	NAS509-6		. . NUT		1
34	NAS559-2		. . LOCK		1
35	69-54958-1		. . COUPLING (USED ON 69-54954-2)		1
35	69-54958-2		. . COUPLING (USED ON 69-54954-3)		1
36	AN3167L		. . NUT		1
37	69-54957-1		. . ROD END ASSY		1
38	BACB28U6B33		. . . BUSHING		1
39	69-54957-2		. . . ROD END		1
40	BACB28X6B54		. BUSHING		2
41	MS24665-287		. PIN, COTTER		2
42	66-19144-2		. NUT, BEARING	R-Y	2
42	66-19144-2		. NUT, BEARING (POST SB 57-1060) (OPT TO 66-19144-1 ON SPARES ONLY)	A-Q	2
42	66-19144-1		. NUT, BEARING	A-Q	2
43	BACB10BN14		. BEARING	A-Q	2
43	BACB10B136		. BEARING	A-Q	2
43	YR743-3		. BEARING, V92563 (POST SB 57-1060R2)		2
43	14AFC1832		. BEARING, V92563 (POST SB 57-1060R2)		2
43	AC49007		. BEARING, V80657 (POST SB 57-1060R2)		2
43	AC47485		. BEARING, V80657 (POST SB 57-1060R2)		2
44	66-19116-1		. STRIP, RUB (REPLD BY 66-19116-7)		2
44	66-19116-7		. STRIP, RUB (REPLS 66-19116-1)		2
45	65-46481-5		. WASHER, SHIM		2
46	69-38825-5		. BOLT ASSY (POST SB 57-1096)		2
46	69-38825-1		. BOLT ASSY		2
47	NAS516-1		. . FITTING, LUBRICATION		1
48	69-38825-2		. . BOLT (USED ON 69-38825-1)		1
48	69-38825-6		. . BOLT (USED ON 69-38825-5)		1
49	BACB30GN4-13		. BOLT		4
50	AN960-416		. WASHER		4
51	65-46481-6		. FILLER, RADIUS		4
52	69-35323-1		. ROLLER ASSY, AFT SIDE		1
53	MS20995NC20		. . LOCKWIRE		AR
54	MS16562-217		. . PIN, SPRING		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
55	66-23220-1		. . BOLT ASSY		1
56	NAS516-1		. . . FITTING, LUBRICATION		1
57	66-23220-3		. . . BOLT		1
58	BACB10B132		. . BEARING		1
59	69-35323-3		. . BRACKET		1
60	69-35323-2		. ROLLER ASSY, AFT SIDE		1
61	MS20995NC20		. . LOCKWIRE		AR
62	MS16562-217		. . PIN, SPRING		1
63	66-23220-1		. . BOLT ASSY		1
64	NAS516-1		. . . FITTING, LUBRICATION		1
65	66-23220-3		. . . BOLT		1
66	BACB10B132		. . BEARING		1
67	69-35323-4		. . BRACKET		1
68	65-46481-4		. SHIM		2
69	BACB30GN4-4		. BOLT		4
70	NAS620-416		. WASHER		4
71	69-35324-2		. ROLLER ASSY, FORWARD SIDE		1
72	MS20995NC20		. . LOCKWIRE		AR
73	MS16562-217		. . PIN, SPRING		1
74	66-23220-1		. . BOLT ASSY		1
75	NAS516-1		. . . FITTING, LUBRICATION		1
76	66-23220-3		. . . BOLT		1
77	BACB10B132		. . BEARING		1
78	69-35324-4		. . BRACKET		1
79	69-35324-1		. ROLLER ASSY, FORWARD SIDE		1
80	MS20995NC20		. . LOCKWIRE		AR
81	MS16562-217		. . PIN, SPRING		1
82	66-23220-1		. . BOLT ASSY		1
83	NAS516-1		. . . FITTING, LUBRICATION		1
84	66-23220-3		. . . BOLT		1
85	BACB10B132		. . BEARING		1
86	69-35324-3		. . BRACKET		1
87	65-46481-3		. SHIM		1
88	MS24665-285		. PIN, COTTER		2
89	66-23217-2		. NUT, BEARING	R-Y	2
89	66-23217-2		. NUT, BEARING (POST SB 57-1060) (OPT TO 66-23217-1 FOR SPARES ONLY)	A-Q	2
89	66-23217-1		. NUT, BEARING	A-Q	2
90	BACB10BN12		. BEARING (PRE SB 57-1060R2)	A-I	2
90	BACB10B135		. BEARING (PRE SB 57-1060R2)	A-I	2
90	YR746-3		. BEARING, V92563 (POST SB 57-1060R2)		2
90	12AFC1628		. BEARING, V92563 (POST SB 57-1060R2)		2
90	AC49006		. BEARING, V80657 (POST SB 57-1060R2)		2
90	AC47957		. BEARING, V80657 (POST SB 57-1060R2)		2
91	AN960C1216L		. WASHER		2
91A	AN960-1416L		. WASHER		2

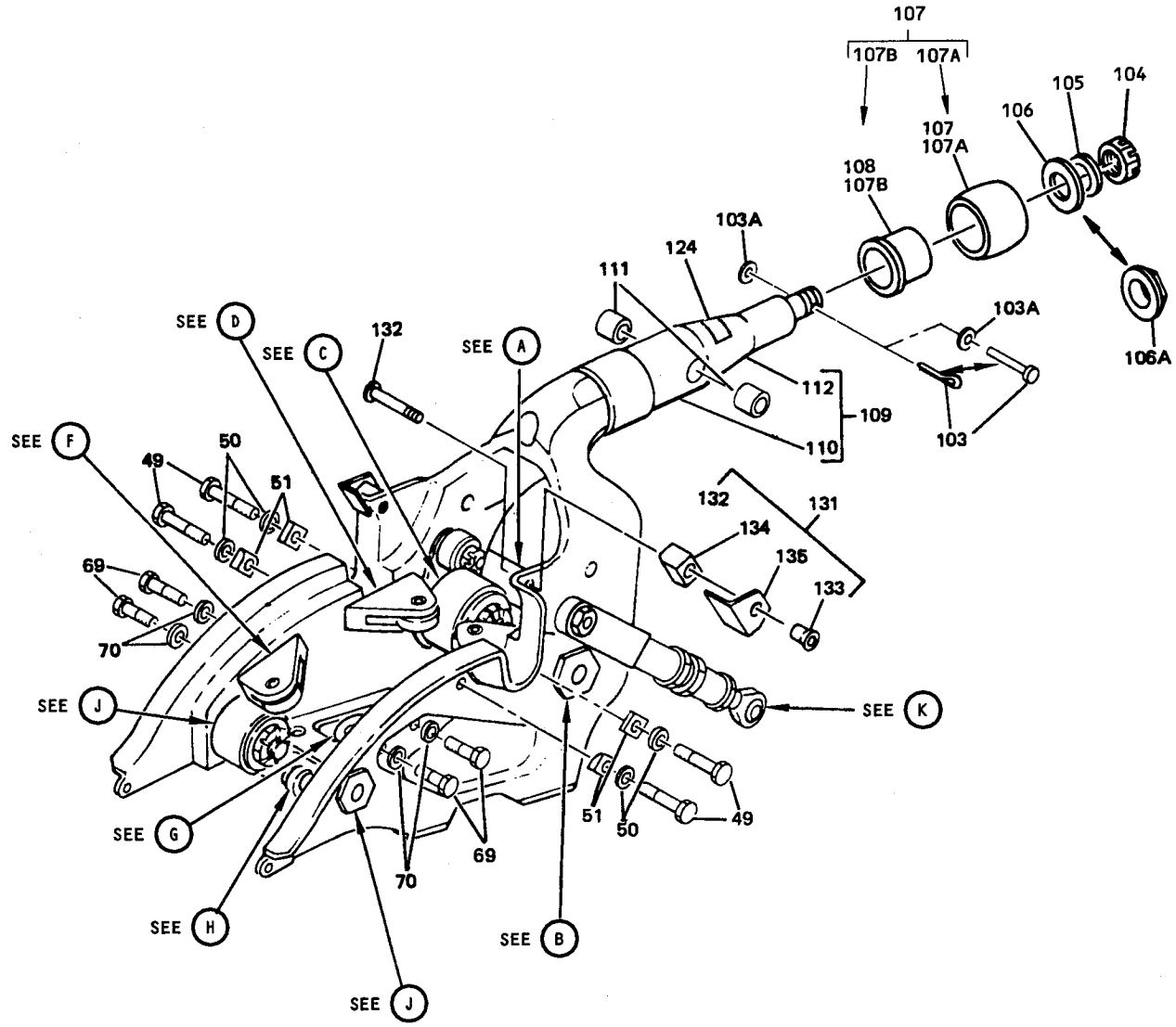
FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
92	69-35347-5		. BOLT ASSY (POST SB 57-1096)		2
92	69-35347-1		. BOLT ASSY		2
92	69-35347-9		DELETED		
93	NAS516-1		. . FITTING, LUBRICATION		1
94	69-35347-2		. . BOLT (USED ON 69-35347-1)		1
94	69-35347-6		. . BOLT (USED ON 69-35347-5)		1
94	69-35347-10		DELETED		
95	MS24665-132		. PIN, COTTER		2
96	BACN10JD104		DELETED		
96	AN320-4		. NUT		2
97	AN960-416L		. WASHER		2
98	69-20787-1		. BOLT ASSY		2
99	NAS516-1		. . FITTING, LUBRICATION		1
100	69-20787-4		. . BOLT		1
101	66-13369-1		. WASHER, LAMINATED		2
102	BACB10B131		. BEARING, NEEDLE		2
103	MS24665-355		. PIN, COTTER	A-I	1
103	MS20392-1C35		. PIN, CLEVIS (POST SB 57-1055R1)	BC	1
103	MS20392-1C35		. PIN, CLEVIS	P-Y	1
103	MS20392-1C33		. PIN, CLEVIS	J-O	1
103A	AN960-4		. WASHER	P-Y	2
104	AN320-10		. NUT (PRE SB 57-1055)	A-O	1
104	F12NE4717-108		. NUT (POST SB 57-1055, 57-1055R1)	BC	1
104	F12NE4717-108		. NUT (PRE SB 57-1055)	P-Y	1
104	BACN10JD110		DELETED		
104	F12NE4717-108		. NUT (REPLACES AN320-10) (POST SB 57-1092R2)	A-Y	1
105	AN960-1016L		. WASHER	A-O	AR
106	66-23245-1		. WASHER, THRUST	A-O	1
106	69-61978-1		. WASHER, THRUST (POST SB 57-1055 AND SB 57-1055R1)	BC	1
106	69-61978-2		. WASHER, THRUST (POST SB 57-1092R1)	A-O	1
106	69-61978-1		. WASHER, THRUST	P-Y	1
106	69-61978-2		. WASHER, THURST (POST SB 57-1092)	P-Y	1
107	66-23216-1		. BEARING	A-O	1
107	LA-4187-A		. BEARING (POST SB 57-1055) (SOURCE: V80894)	A-O	1
107	10-61865-1		. BEARING (POST SB 57-1055R1) (VENDER NO LA-5941-A) (SOURCE: V80894)	A-O	1
107	65C10596-2		DELETED		

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
107	65C10596-6		. BEARING (POST SB 57-1092R1)	A-O	1
107	LA-4187-A		. BEARING, V80894	P-S	1
107	65C10596-6		. BEARING (POST SB 57-1092R1)	P-S	1
107	10-61865-1		. BEARING	T-Y	1
107	65C10596-6		. BEARING (POST SB 57-109R1)	T-Y	1
107	KJB197014V-1		. BEARING ASSY (REPLS 65C10596-6 AND 66-23216-1) (POST SB 57-1092R2) *[4]	A-O	1
107	KJB197014V-1		. BEARING ASSY (POST SB 57-1092R2) *[2] *[4]	P-S	1
107	KJB197014V-1		. BEARING ASSY (REPLS 10-61865-1) *]2] *[4]	T-Y	1
107	KJB228114V-1		. BEARING ASSY, 0.014 UNDERSIZE (POST SB 57-1092R2 *[4]	A-W	1
107	KJB228214V-1		. BEARING ASSY, 0.030 UNDERSIZE (POST SB 57-1092R2) *[4]	A-W	1
107	KJB228314V-1		. BEARING ASSY, 0.060 UNDERSIZE	A-W	1
107A	KJB197014V-5		. . BEARING (USED ON KJB197014V-1, KJB228114V-1, KJB228214V-1, KJB228314V-1)		1
107B	KJB197014V-3		. . BUSHING (USED ON KJB197014V-1)		1
107B	KJB228114V-3		. . BUSHING (USED ON KJB228114V-1)		1
107B	KJB228214V-3		. . BUSHING (USED ON KJB228214V-1)		1
107B	KJB228314V-3		. . BUSHING (USED ON KJB228314V-1)		1
108	66-23215-1		. BUSHING	A-O	1
108	69-64197-1		. BUSHING (POST 57-1055R1)	ABC P-S	1
108	69-67219-12		DELETED		
108	69-67219-13		DELETED		
108	69-67219-14		DELETED		
108	69-67219-6		. BUSHING, STANDARD (POST SB 57-1085)	A-W	1
108	69-67219-7		. BUSHING, 0.014 UNDERSIZED (POST SB 57-1085) *[2]	A-W	1
108	69-67219-8		. BUSHING 0.030 UNDERSIZED (POST SB 57-1085) *[2]	A-W	1
108	69-64197-2		. BUSHING	XY	1

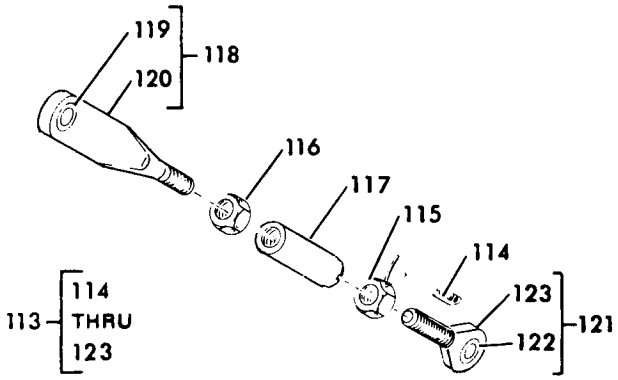
FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
108	69-61977-1		. BUSHING	P-S	1
108	69-64197-1		. BUSHING	T-W	1
108A	BACN10HR5CS		. NUT *[3] (POST SB 57-1112, 57-1066)	A-Y	1
108A	FNF26-524		. NUT, V56878 (PRE SB 57-1112)	R-Y	1
108A	BACN10HR5		. NUT (OPT TO BACN10HR5CS)	A-Y	1
108B	BACW10BP5APU		. WASHER *[3] (POST SB 57-1112, 57-1066)	A-Y	1
108B	AN960PD516		. WASHER (UNDER NUT) (PRE SB 57-1112)	R-Y	1
108C	70315-5-38		. BOLT *[3] (V56878) (POST SB 57-1112, 57-1066)	A-Y	1
108C	EWB26-5-38		. BOLT, V56878 (PRE SB 57-1112)	R-Y	1
108D	10-61850-1A		. BEARING (POST SB 57-1066)	A-Q	1
108D	10-61850-1		. BEARING	R-Y	1
108D	KMDB29-3		DELETED		
108D	79955		DELETED		
108D	KSC146729B		DELETED		
108D	176412		DELETED		
108D	HSP30-106		DELETED		
108D	KMDB29-2		DELETED		
108D	KSC236429V		. BEARING (V50632) (OPT)	A-Y	1
108E	BACW10BP5ACU		. WASHER *[3] (POST SB 57-1112, 57-1066)	A-Y	1
108E	BACW10BP5AC		DELETED		
109	65-47821-6		. CARRIAGE ASSY	ABCJK	1
109	65-47821-8		. CARRIAGE ASSY	DEJK	1
109	65-47821-10		. CARRIAGE ASSY	F-I L-Q	1
109	65-47821-12		. CARRIAGE ASSY	R-W	1
109	65-47821-16		. CARRIAGE ASSY	XY	1
110	65-47821-4		. . SLEEVE (USED ON 65-47821-6, -8, -10, -12) *[1] *[5]		1
110	65-47821-18		. . SLEEVE (USED ON 65-47821-16) *[5] *[9]		1
110	69-67219-16		. . SLEEVE, STD (POST SB 57-1085)		1
110	69-67219-4		. . SLEEVE, 0.014 UNDERSIZE (POST SB 57-1085)		1
110	69-67219-5		. . SLEEVE, 0.030 UNDERSIZE (POST SB 57-1085)		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
111	BACB28U5E075		. . BUSHING (USED ON 65-47821-12, -16) (OPT TO BACB28U5E170)		2
111	BACB28U5E170		. . BUSHING (USED ON 65-47821-12, -16) (OPT TO BACB28U5E075)		1
111	NAS537-5P075		. . BUSHING (USED ON 65-47821-6, -8, -10) (POST SB 57-1066)		2
112	65-47821-5		. . CARRIAGE (USED ON 65-47821-6)		1
112	65-47821-7		DELETED		
112	65-47821-17		. . CARRIAGE (USED ON 65-47821-16)		1
112	65-47821-9		. . CARRIAGE (USED ON 65-47821-8)		1
112	65-47821-11		. . CARRIAGE (USED ON 65-47821-10)		1
112	65-47821-13		. . CARRIAGE (USED ON 65-47821-12)		1
113	69-59869-1		. STRUT ASSY (REPLS 65-76161-3)*[2]	A	2
113	69-59869-1		. STRUT ASSY *[2]	B-Y	1
114	NAS559-2		. . LOCK		1
115	NAS509-6		. . NUT		1
116	NAS509L6		. . NUT		1
117	69-59872-1		. . COUPLING		1
118	69-59870-1		. . ROD END ASSY		1
119	BACB28Y6B29		. . . BUSHING		1
120	69-59870-3		. . . ROD END		1
121	69-59871-1		. . ROD END ASSY		1
122	BACB28Y5B29		. . . BUSHING		1
123	69-59871-3		. . . ROD END		1
124	BAC27DWG21		. MARKER, PLASTIC FILM (ADDED BY SB 57-1055, DELETED BY SB 57-1092R2)		1
125	69-66681		DELETED		
126	BACB30LJ4-8		DELETED		
127	AN960-416		DELETED		
128	BACN10JC4		DELETED		
129	65-46481-6		DELETED		
130	69-66681-3		DELETED		
130	69-66681-4		DELETED		
131	69-66681-2		DELETED		
132	BACB30LP4P6		DELETED		
133	66-10985		DELETED		
134	69-66681-7		DELETED		
135	69-66681-5		DELETED		
135	69-66681-6		DELETED		

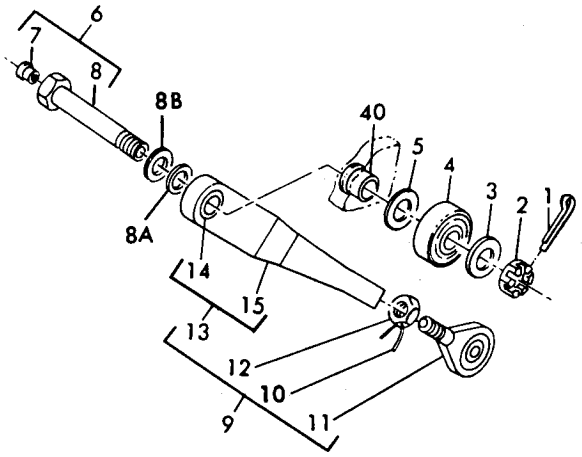
*[1] MAKE FROM 69-46453-1
*[2] LIMITED USE
*[3] PREFERRED ON ALL ASSYS FOR INCREASED CORROSION RESISTANCE
*[4] BEARING ASSEMBLIES HAVE "KARON" LININGS. DO NOT INTERMIX WITH OTHER BUSHINGS.
*[5] DO NOT USE SLEEVE ON CARRIAGE ASSY 65-47821-6,-8,-10,-12 OR -16 IF AN UNDERSIZE SLEEVE HAS BEEN INSTALLED.
*[6] PRE SB 737-57-1085R1, OPT TO 65-46481-39.
*[7] PRE SB 737-57-1085R1, OPT TO 65-46481-40.
*[8] NO EQUIVALENT BOEING PART NUMER FOR REWORKED PART.
*[9] MAKE FROM 69-46453-2.
*[10] PRE SB 737-57-1066R3.
*[11] PRE SB 737-57-1092R3, OPT 65-46481-81.
*[12] PRE SB 737-57-1092R3, OPT 65-46481-82.
*[13] PRE SB 737-57-1092R3, OPT 65-46481-83.
*[14] PRE SB 737-57-1092R3, OPT 65-46481-84.
*[15] PRE SB 737-57A1218R3.



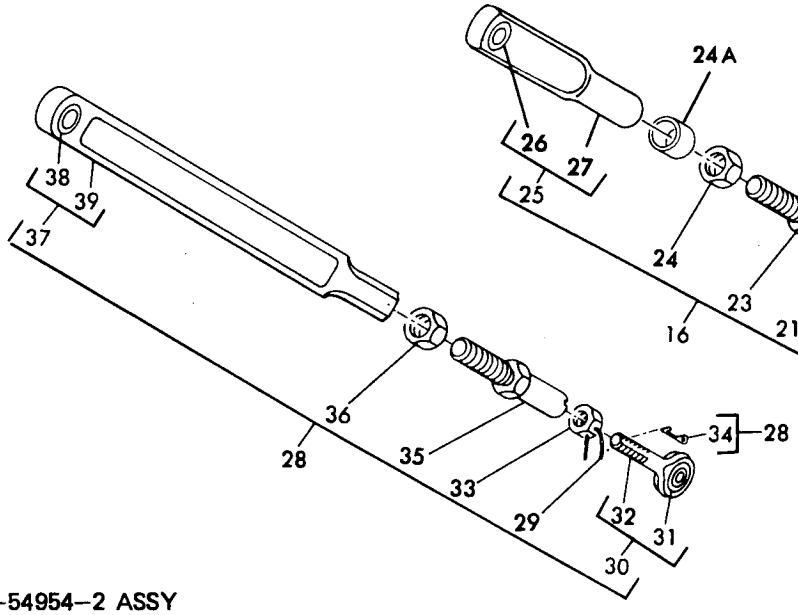
Outboard Flap Carriage Assembly
Figure 1102 (Sheet 1)



69–59869–1 ASSY
(USED ON 65–46481–8, –14, –20, –26)



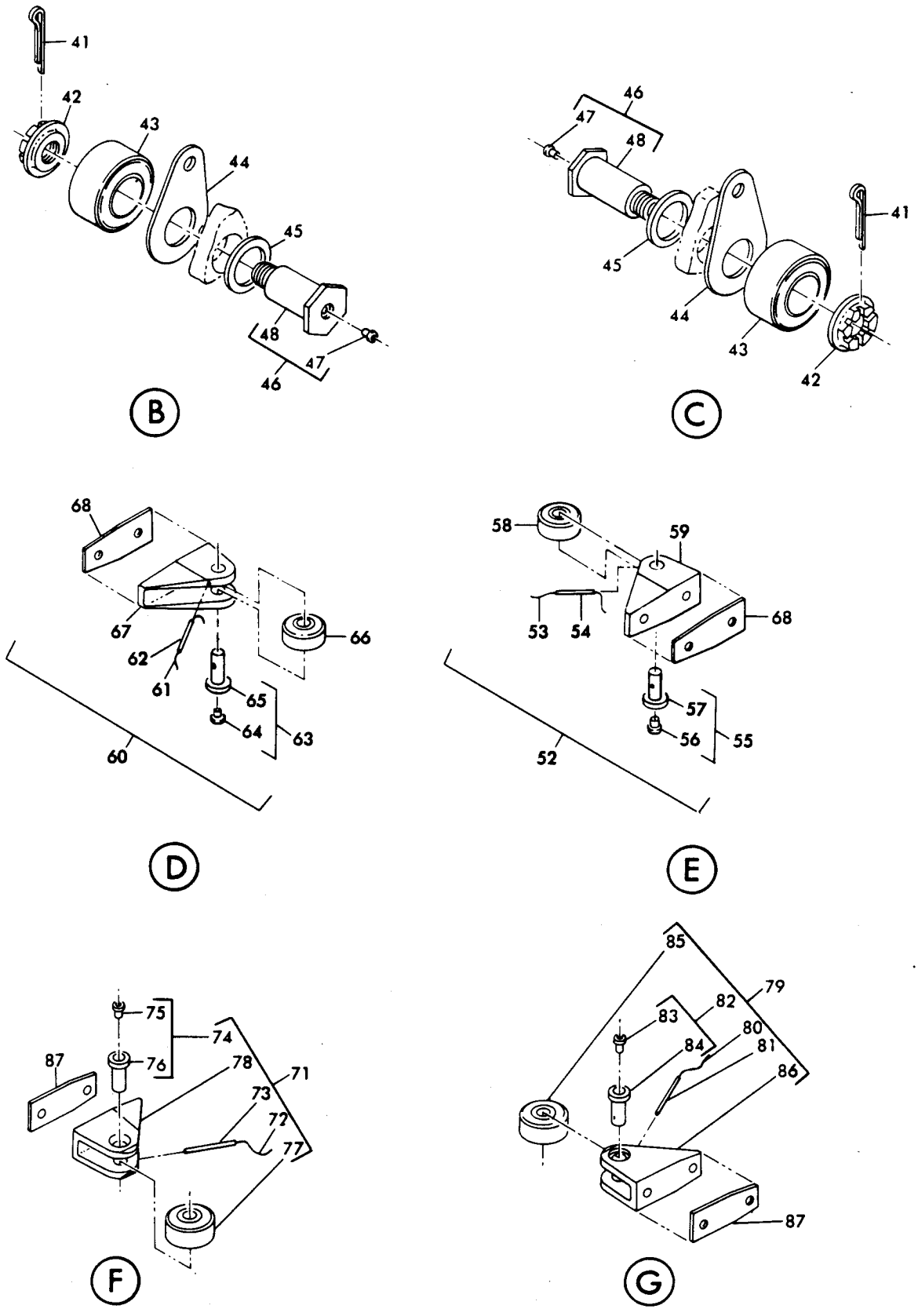
69–39245–1 ASSY
(USED ON 65–46481–8)



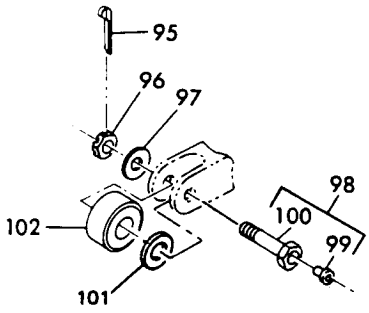
69–54954–2 ASSY
(USED ON 65–46481–13, –19, –25,)

69–54954–1 ASSY
(USED ON 65–46481–14)
65–76161–3 ASSY
(USED ON 65–46481–8,
–14, –20, –26)

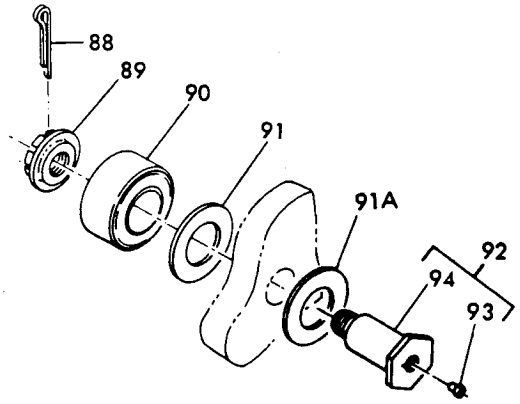
Ⓐ



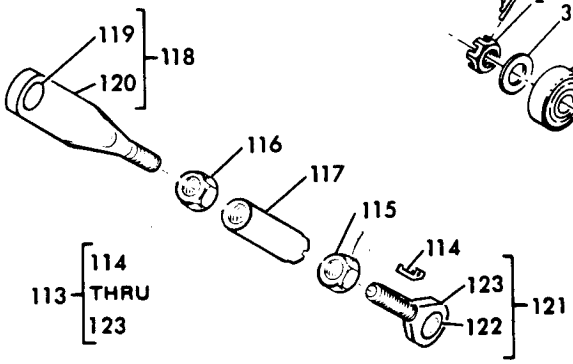
Outboard Flap Carriage Assembly
Figure 1102 (Sheet 3)



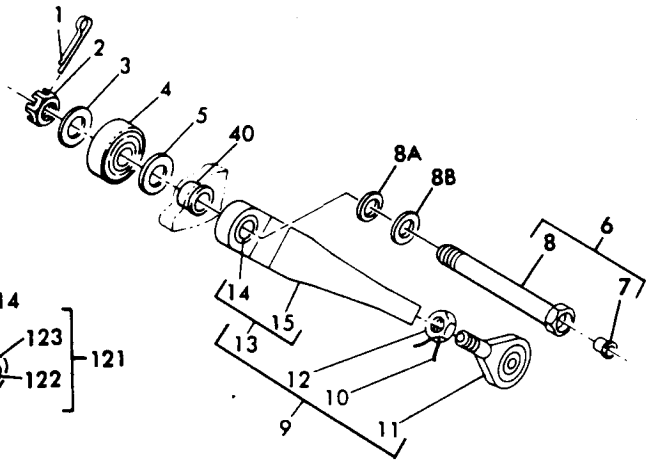
(H) (TYPICAL 2 LOCATIONS)



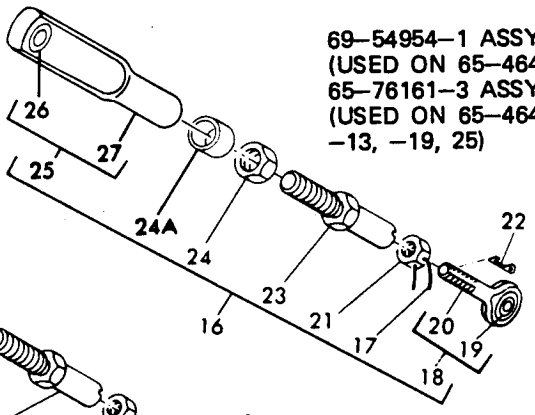
(J) (TYPICAL)



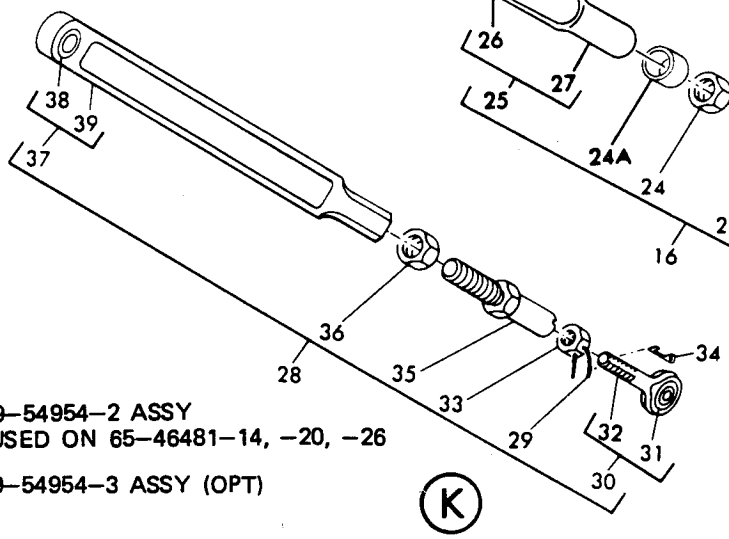
69–59869–1 ASSY
(USED ON 65–46481–8, –13, –19, –25,



69–39245–1 ASSY
(USED ON 65–46481–8)



69–54954–1 ASSY
(USED ON 65–46481–13)
65–76161–3 ASSY
(USED ON 65–46481–8
–13, –19, 25)



69–54954–2 ASSY
(USED ON 65–46481–14, –20, –26

69–54954–3 ASSY (OPT)

(K)

Outboard Flap Carriage Assembly
Figure 1102 (Sheet 4)

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1102-					
	65-46481-8		CARRIAGE ASSY *[6] *[7] *[8]	A	RF
	65-46481-13		CARRIAGE ASSY *[6] *[7] *[8] *[9] *[10] *[12]	B	RF
	65-46481-14		CARRIAGE ASSY *[6] *[7] *[8] *[9] *[11] *[12]	C	RF
	65-46481-19		CARRIAGE ASSY *[6] *[7] *[8] *[10] *[12]	D	RF
	65-46481-20		CARRIAGE ASSY *[6] *[7] *[8] *[11] *[12]	E	RF
	65-79949-7		CARRIAGE ASSY (65-46481-13 REWKD) *[7] *[12]	F	RF
	65-79949-8		CARRIAGE ASSY (65-46481-14 REWKD) *[7] *[12]	G	RF
	65-79949-9		CARRIAGE ASSY (65-46481-19 REWKD) *[7] *[12]	H	RF
	65-79949-10		CARRIAGE ASSY (65-46481-20 REWKD) *[7] *[12]	I	RF
	65-46481-25		CARRIAGE ASSY *[6] *[7] *[12]	J	RF
	65-46481-26		CARRIAGE ASSY *[6] *[7] *[12]	K	RF
1	MS24665-304		. PIN, COTTER		2
2	BACN10JD106		. NUT (REPLS AN320-6)		2
3	AN960-616L		. WASHER		2
4	BACB10B132		. BEARING		2
5	AN960C616		. WASHER		2
5	AN960C616L		. WASHER (OPT TO AN960C616)		2
6	69-39243-3		. BOLT, ASSY		2
7	NAS516-1		. . FITTING, LUBRICATION		1
8	69-39243-4		. . BOLT		1
8A	AN960PD616		. WASHER (USED WITH 65-76161-3)	A	2
8A	AN960PD616		. WASHER (USED WITH 65-76161-3)	B-K	1
8B	BACW10BN6AC		. WASHER (USED WITH 65-76161-3)	A	2
8B	BACW10BN6ANC		. WASHER (USED WITH 65-76161-3) (OPT TO BACW10BN6AC)	A	2
8B	BACW10BN6AC		. WASHER (USED WITH 65-76161-3)	B-K	1
8B	BACW10BN6ANC		. WASHER (USED WITH 65-76161-3) (OPT TO BACW10BN6AC)	B-K	1
9	69-39245-1		. STRUT ASSY *[4]	A	3
10	MS20995C32		. . LOCKWIRE (SB 57-1007)		AR
11	77261		. . ROD END, V09455 (BOEING 10-60799-158)		1
11	REMS10ATC12		. . ROD END, V21335 (BOEING 10-60779-158)		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1102-					
11	TFM-105-S		. . ROD END, V77896 (BOEING 10-60779-158)		1
11	DREM-5-076		. . ROD END, V81376 (BOEING 10-60779-158)		1
12	NAS509-6		. . NUT (SB 57-1007)		1
13	69-42367-3		. . ROD END ASSY (SB 57-1007)		1
13	69-42367-5		. . ROD END ASSY (SB 57-1007)		1
14	BACB28Y6B33		. . . BUSHING		1
15	69-42367-4		. . . ROD END (USED ON 69-42367-3)		1
15	69-42367-6		. . . ROD END (USED ON 69-42367-5)		1
16	65-76161-3		. ROD ASSY (OPT TO 69-59869-1, REPLS 69-54954-1)	B-K	1
16	65-76161-3		. ROD ASSY (OPT TO 69-59869-1, REPLS 69-39245-1) *[4]	A	2
16	69-54954-1		. STRUT ASSY (REPLD BY 69-76161-3, 69-54954-1) *[4]	BCFG	1
17	MS20995C32		. . LOCKWIRE		AR
18	69-54956-1		. . ROD END ASSY (USED ON 69-54954-1)		1
18	65-76161-9		. . ROD END ASSY (USED ON 65-76161-3)		1
19	BACB28Y5B31		. . . BUSHING (USED ON 69-54956-1)		1
19	BACB28Y5B19		. . . BUSHING (USED ON 65-76161-9)		1
20	69-54956-2		. . . ROD END (USED ON 69-54956-1)		1
20	65-76161-8		. . . ROD END (USED ON 65-76161-9)		1
21	NAS509-6		. . NUT (USED ON 69-54954-1)		1
22	NAS559-2		. . LOCK (USED ON 69-54954-1)		1
23	69-54958-1		. . COUPLING		1
24	AN316-7L		. . NUT (USED ON 69-54954-1)		1
24	NAS509L7		. . NUT (USED ON 65-76161-3)		1
24A	65-76161-5		. . SLEEVE (USED ON 65-76161-3)		1
24A	NAS43HT7-21		. . BUSHING (OPT TO 65-76161-5 ON 65-76161-3)		1
24A	NAS43DD7-21		. . BUSHING (OPT TO 65-76161-5 ON 65-76161-3)		1
25	69-54955-1		. . ROD END ASSY (USED ON 69-54954-1)		1
25	65-76161-7		. . ROD END ASSY (USED ON 65-76161-3)		1
26	BACB28Y6B33		. . . BUSHING (USED ON 69-54955-1)		1
26	BACB28Y6B21		. . . BUSHING (USED ON 65-76161-7)		1
27	69-54955-2		. . . ROD END (USED ON 69-54955-1)		1
27	65-76161-6		. . . ROD END (USED ON 65-76161-7)		1
28	69-54954-2		. STRUT ASSY	B-K	1
28	69-54954-3		DELETED		
29	MS20995C32		. . LOCKWIRE		AR
30	69-54956-1		. . ROD END ASSY (USED ON 69-54954-2)		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1102-					
31	BACB28Y5B31		. . . BUSHING		1
32	69-54956-2		. . . ROD END		1
33	NAS509-6		. . NUT		1
34	NAS559-2		. . LOCK		1
35	69-54958-1		. . COUPLING (USED ON 69-54954-2)		1
35	69-54958-2		DELETED		1
36	AN3167L		. . NUT		1
37	69-54957-1		. . ROD END ASSY		1
38	BACB28U6B33		. . . BUSHING		1
39	69-54957-2		. . . ROD END		1
40	BACB28X6B54		. BUSHING		2
41	MS24665-287		. PIN, COTTER		2
42	66-19144-2		. NUT, BEARING (PRE SB 57-1060)(OPT TO 66-19144-1 FOR SPARES ONLY)		2
42	66-19144-1		. NUT, BEARING (PRE SB 57-1060)		2
43	BACB10BN14		. BEARING (PRE SB 57-1060R2)		2
43	BACB10B136		. BEARING (PRE SB 57-1060R2)		2
43	YR743-3		. BEARING, V92563 (POST SB 57-1060R2)		2
43	14AFC1832		. BEARING, V92563 (POST SB 57-1060R2)		2
43	AC49007		. BEARING, V80657 (POST SB 57-1060R2)		2
43	AC47485		. BEARING, V80657 (POST SB 57-1060R2)		2
44	66-19116-1		. STRIP, RUB (REPLD BY 66-19116-7)		2
44	66-19116-7		. STRIP, RUB (REPLS 66-19116-1)		2
45	65-46481-5		. WASHER, SHIM		2
46	69-38825-7		. BOLT ASSY (POST SB 57-1096)		2
46	69-38825-3		. BOLT ASSY (PRE SB 57-1096)		2
47	NAS516-1		. . FITTING, LUBRICATION		1
48	69-38825-4		. . BOLT (USED ON 69-38825-3)		1
48	69-38825-8		. . BOLT (USED ON 69-38825-7)		1
49	BACB30GN4-13		. BOLT		4
50	AN960-416		. WASHER		4
51	65-46481-6		. FILLER, RADIUS		4
52	69-35323-1		. ROLLER ASSY, AFT SIDE		1
53	MS20995NC20		. . LOCKWIRE		AR
54	MS16562-217		. . PIN, SPRING		1
55	66-23220-1		. . BOLT ASSY		1
56	NAS516-1		. . . FITTING, LUBRICATION		1
57	66-23220-3		. . . BOLT		1
58	BACB10B132		. . BEARING		1
59	69-35323-3		. . BRACKET		1
60	69-35323-2		. ROLLER ASSY, AFT SIDE		1
61	MS20995NC20		. . LOCKWIRE		AR
62	MS16562-217		. . PIN, SPRING		1
63	66-23220-1		. . BOLT ASSY		1
64	NAS516-1		. . . FITTING, LUBRICATION		1

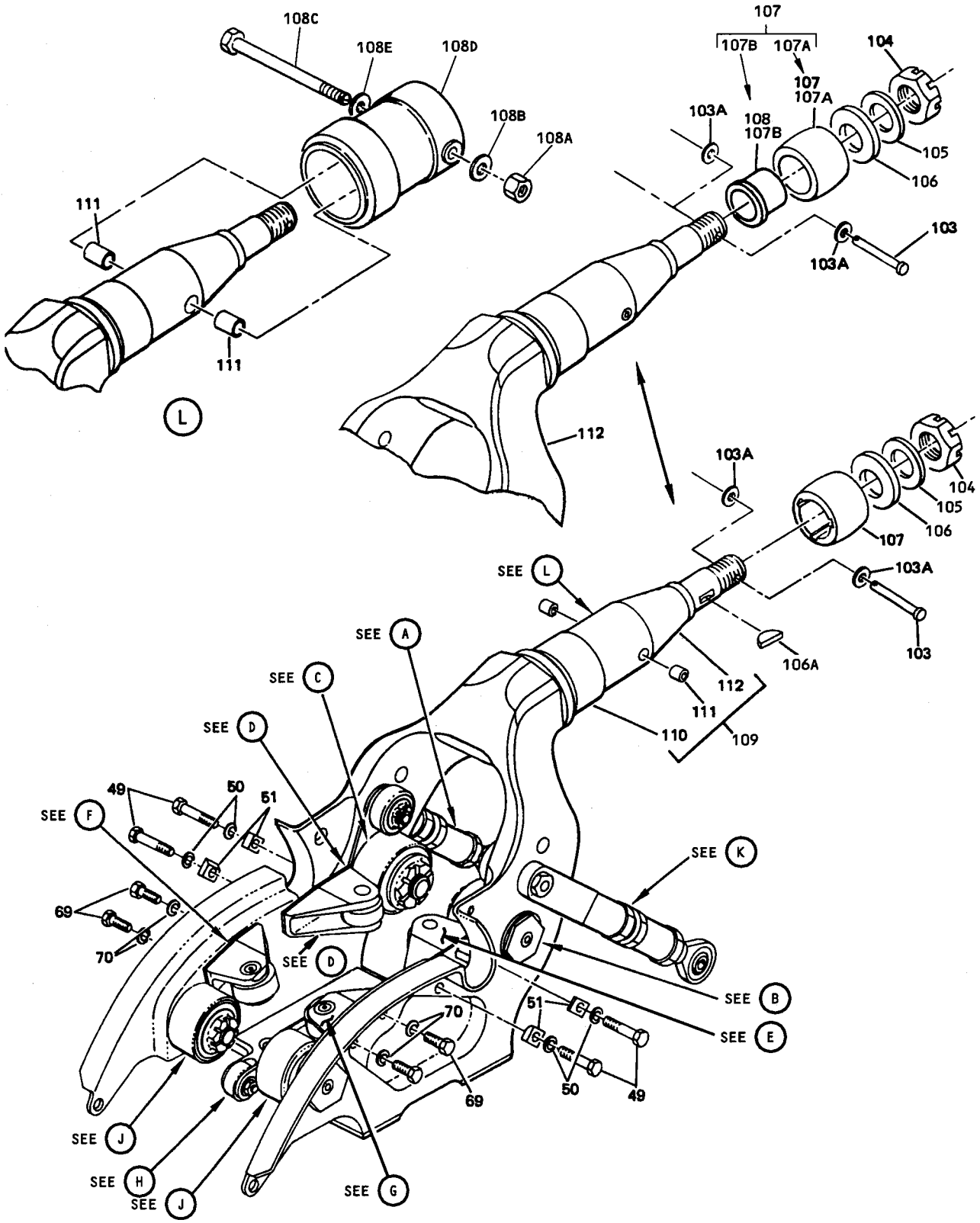
FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1102-					
65	66-23220-3		. . . BOLT		1
66	BACB10B132		. . BEARING		1
67	69-35323-4		. . BRACKET		1
68	65-46481-4		. SHIM		2
69	BACB30GN4-4		. BOLT		4
70	NAS620-416		. WASHER		4
71	69-35324-2		. ROLLER ASSY, FORWARD SIDE	A-K	1
72	MS20995NC20		. . LOCKWIRE		AR
73	MS16562-217		. . PIN, SPRING		1
74	66-23220-1		. . BOLT ASSY		1
75	NAS516-1		. . . FITTING, LUBRICTION		1
76	66-23220-3		. . . BOLT		1
77	BACB10B1132		. . BEARING		1
78	69-35324-4		. . BRACKET		1
79	69-35324-1		. ROLLER ASSY, FORWARD SIDE		1
80	MS20995NC20		. . LOCKWIRE		AR
81	MS16562-217		. . PIN, SPRING		1
82	66-23220-1		. . BOLT ASSY		1
83	NAS516-1		. . . FITTING, LUBRICATION		1
84	66-23220-3		. . . BOLT		1
85	BACB10B132		. . BEARING		1
86	69-35324-3		. . BRACKET		1
87	65-46481-3		. SHIM		2
88	MS24665-285		. PIN, COTTER		2
89	66-23217-2		. NUT, BEARING (POST SB 57-1060) (OPT TO 66-23217-1 ON SPARES ONLY)		2
89	66-23217-1		. NUT, BEARING (PRE SB 57-1060)		2
90	BACB10BN12		. BEARING (PRE SB 57-1060R2)		2
90	BACB10B135		. BEARING (PRE SB 57-1060R2)		2
90	YR746-3		. BEARING, V92563 (POST SB 57-1060R2)		2
90	12AFC1628		. BEARING, V92563 (POST SB 57-1060R2)		2
90	AC49006		. BEARING, V80657 (POST SB 57-1060R2)		2
90	AC47957		. BEARING, V80657 (POST SB 57-1060R2)		2
91	AN960C1216L		. WASHER		2
91A	AN960-1416L		. WASHER		2
92	69-35347-7		. BOLT ASSY (POST SB 57-1096)		2
92	69-35347-3		. BOLT ASSY (PRE SB 57-1096)		2
93	NAS516-1		. . FITTING, LUBRICATION		1
94	69-35347-4		. . BOLT (USED ON 69-35347-3)		1
94	69-35347-8		. . BOLT (USED ON 69-35347-7)		1
95	MS24665-132		. PIN, COTTER		2

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1102-					
96	BACN10JD104		DELETED		
96	AN320-4		. NUT		2
97	AN960-416L		. WASHER		2
98	69-20787-1		. BOLT ASSY		2
99	NAS516-1		. . FITTING, LUBRICATION		1
100	69-20787-4		. . BOLT		1
101	66-13369-1		. WASHER, LAMINATED		2
102	BACB10B131		. BEARING, NEEDLE		2
103	MS24665-287		. PIN, COTTER	A-E	1
103	MS20392-1C21		. PIN, CLEVIS (POST SB 57-1055)	ABCJK	1
103	MS20392-1C19		. PIN, CLEVIS	F-I	1
103A	AN960-4		. WASHER	JK	2
104	F12NE4717-064		. NUT, V72962 (POST SB 57-1055)	ABC	1
104	AN320-6		. NUT (PRE SB 57-1055)	A-E	1
104	F12NE4717-064		. NUT (V72962)	JK	1
104	BACN10JD6		. NUT (REPLD BY F12NE4717-064)	F-I	1
105	AN60-616L		. WASHER	A-E	AR
105	AN960PD616L		. WASHER	J-K	AR
105	AN960C616		. WASHER	F-I	AR
106	66-23245-2		. WASHER (PRE SB 57-1055)	A-I	1
106A	69-61979-1		. NUT, THRUST (POST SB 57-1055)	ABC	1
106A	69-61979-1		. NUT, THRUST	JK	1
107	LA-5941-A		. BEARING, V80894 (BOEING 10-61865-1) (POST SB 57-1055)	ABC	1
107	LA-4187-A		. BEARING, V80894	JK	1
107	66-23216-1		. BEARING (PRE SB 57-1055, 57-1092R2)	A-I	1
107	KJB208015V-1		. BEARING ASSY (POST SB 57-1092R2 *[4] *[5]	JK	1
107A	KJB208015V-5		. . BEARING (USED ON KJB208015V-1)		1
107B	KJB208015V-3		. . BUSHING (USED ON KJB208015V-1)		1
108	69-61976-1		. BUSHING	JK	1
108	69-61976-1		. BUSHING (POST SB 57-1055)	ABC	1
108	69-46448-1		. BUSHING (PRE SB 57-1055)	A-I	1
108	69-67219-12		. BUSHING, STD (POST SB 57-1085)	A-E	1
108	69-67219-13		. BUSHING, 0.014 UNDERSIZED (POST SB 57-1085)		1
108	69-67219-14		. BUSHING, 0.030 UNDERSIZED (POST SB 57-1085)		1

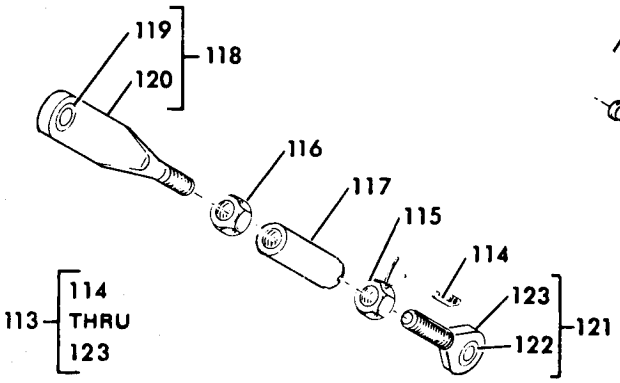
FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1102-					
109	65-67159-7		. CARRIGE ASSY (REPLS 65-67159-1, -5)		1
109	65-67159-1		. CARRIGE ASSY *[2] *[7]	A-G	1
109	65-67159-5		. CARRIGE ASSY *[3]	JK	1
110	65-67159-3		. . SLEEVE (USED ON 65-67159-1, -5, -7) *[1]		1
110	69-67219-9		. . SLEEVE, STD (SB 57-1085)		1
110	69-67219-10		. . SLEEVE, 0.014 UNDERSIZED (SB 57-1085)		1
110	69-67219-11		. . SLEEVE, 0.030 UNDERSIZED (SB 57-1085)		1
111	BACB28U6B75		. . BUSHING		2
112	65-67159-8		. . CARRIAGE (USED ON 65-67159-7)		1
112	65-67159-2		. . CARRIAGE (USED ON 65-67159-1)		1
112	65-67159-4		. . CARRIAGE (USED ON 65-67159-1)		1
112	65-67159-6		. . CARRIAGE (USED ON 65-67159-5)		1
113	69-59869-1		. STRUT ASSY (REPLS 65-76161-3) *[4]	ABC	2
113	69-59869-1		. STRUT ASSY (PREF)	A-K	1
114	NAS559-2		. . LOCK		1
115	NAS509-6		. . NUT		1
116	NAS509L6		. . NUT		1
117	69-59872-1		. . COUPLING		1
118	69-59870-1		. . ROD END ASSY		1
119	BAC28Y6B29		. . . BUSHING		1
120	69-59870-3		. . . ROD END		1
121	69-59871-1		. . ROD END ASSY		1
122	BACB28Y5B29		. . . BUSHING		1
123	69-59871-3		. . . ROD END		1
124	BAC27DWG21		. MARKER, PLASTIC FILM (ADDED BY SB 57-1055, DELETED BY SB 57-1092)		1
125-130	NOT USED				
131	69-66681-2		. KIT INSTL (SB 57-1091R1)	A-I	1
132	BACB30LP4P6		. . BOLT		2
133	66-10985		. . NUT, CSK		2
134	69-66681-7		. . FILLER, RADIUS		2
135	69-66681-5		. . ANGLE		1
135	69-66681-6		. . ANGLE (OPP)		1

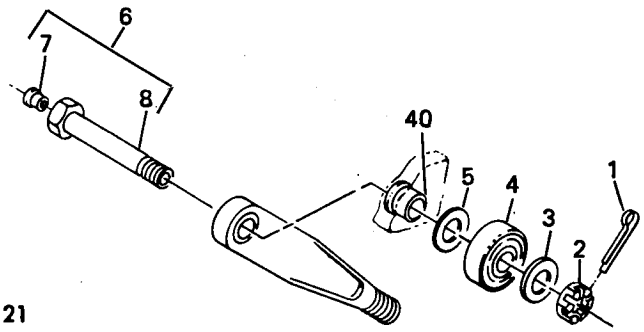
*[1] MAKE FROM 69-46449-1
*[2] 65-67159-1, AFTER REWK PER SB 57-1091R1, OPT TO 65-67159-7
*[3] 65-67159-5, AFTER REWK PER 69-66681, OPT TO 65-67159-7
*[4] LIMITED USE
*[5] BEARING ASSEMBLIES HAVE A "KARON" LINING. DO NOT INTERMIX WITH OTHER BUSHINGS

*[6] PRE SB 737-57-1085R1
*[7] NO EQUIVALENT BOEING PART NUMBER FOR REWORKED PART
*[8] PRE SB 737-57-1091R1
*[9] PRE SB 737-57-1066R3
*[10] PRE SB 737-57-1092R3, OPT 65-46481-83
*[11] PRE SB 737-57-1092R3, OPT 65-46481-84
*[12] PRE SB 737-57A1218R3



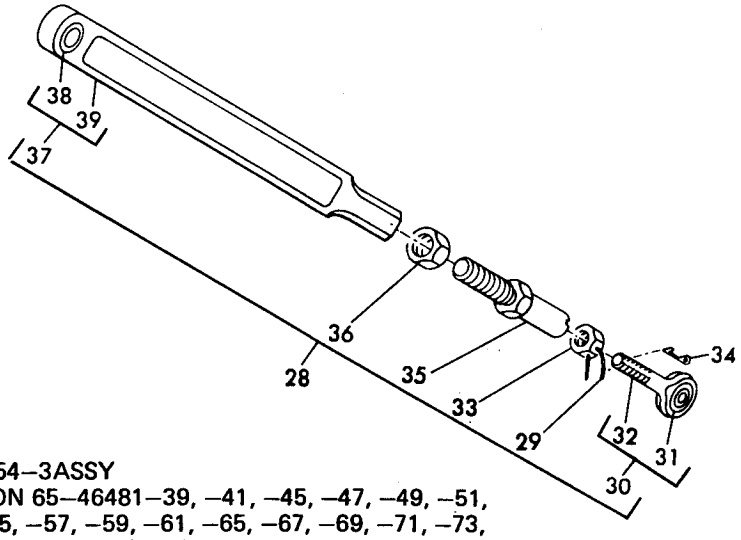
Outboard Flap Carriage Assembly
Figure 1103 (Sheet 1)





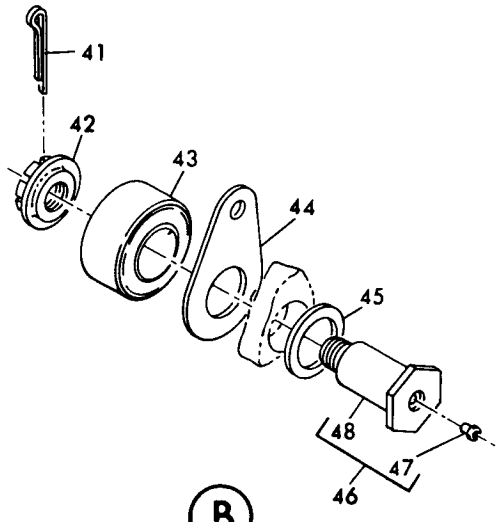
(TYPICAL)

69–59869–1 ASSY
(USED ON 65–46481–40, –42, –46, –48
–50, –52, –54, –56, –58, –60, –62, –66
–68, –70, –72, –74, –76, –82, –84, –86, OPTIONAL ON –64)
69–54954–2 ASSY (USED ON 65–46481–64)

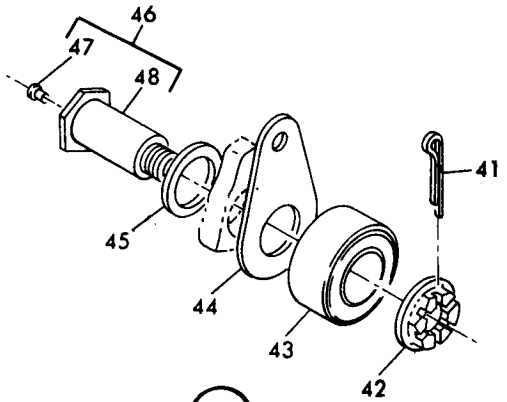


69–54954–3ASSY
(USED ON 65–46481–39, –41, –45, –47, –49, –51,
–53, –55, –57, –59, –61, –65, –67, –69, –71, –73,
–75, –81, –83, –85) –OPTIONAL ON –63)
69–54954–2 ASSY (USED ON 65–46481–63)

A

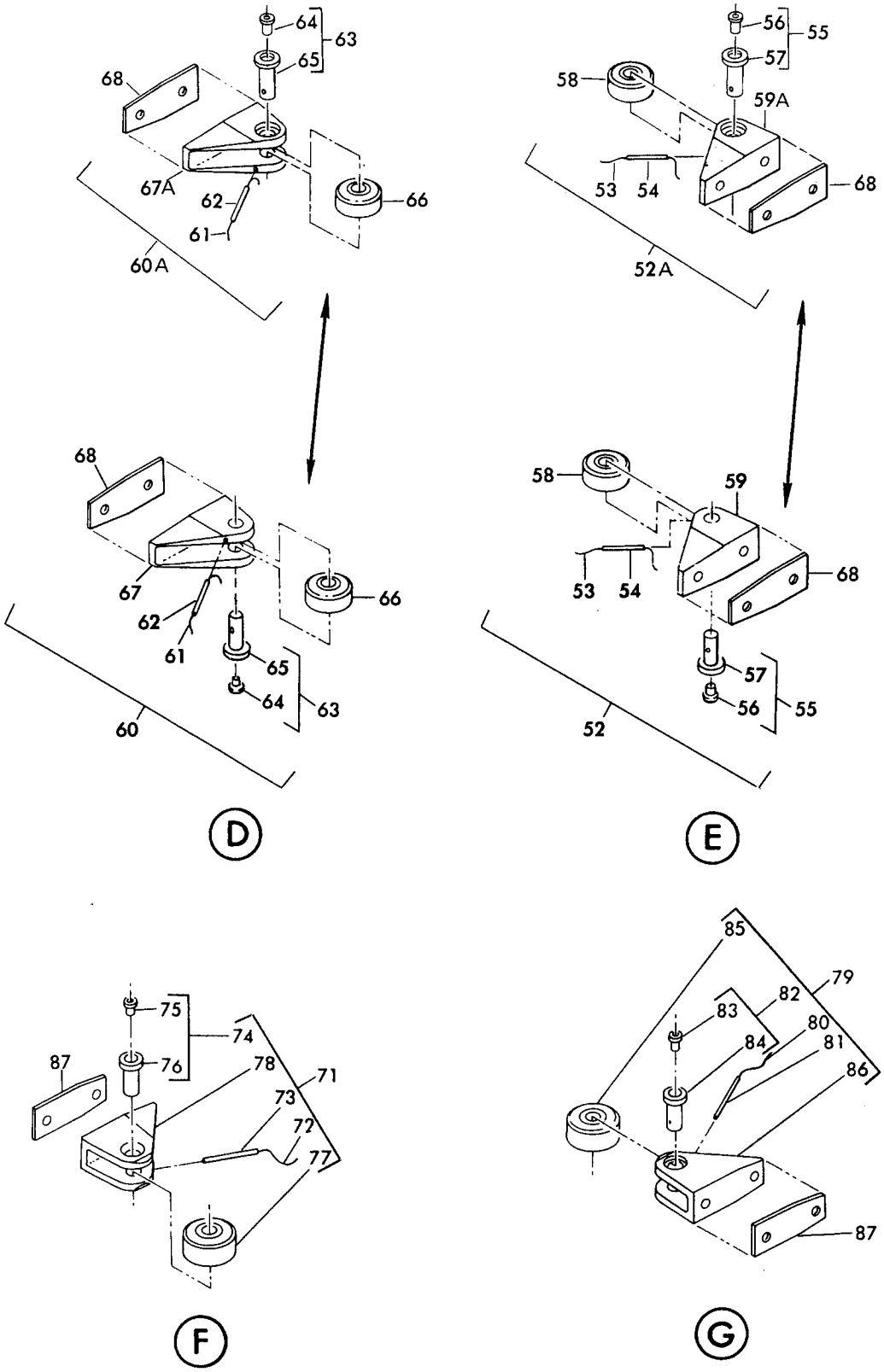


B



C

Outboard Flap Carriage Assembly
Figure 1103 (Sheet 2)


64
63
65
68
67A
62
66
61
60A
56
55
57
58
59A
53
54
68
52A
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67
62
66
61
65
64
63
60
58
59
53
54
68
57
56
55
52
D
E
75
74
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76
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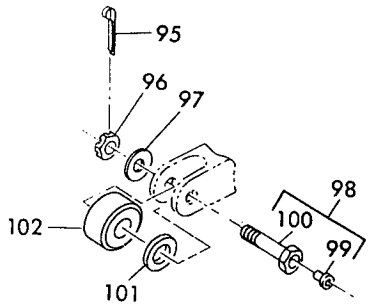
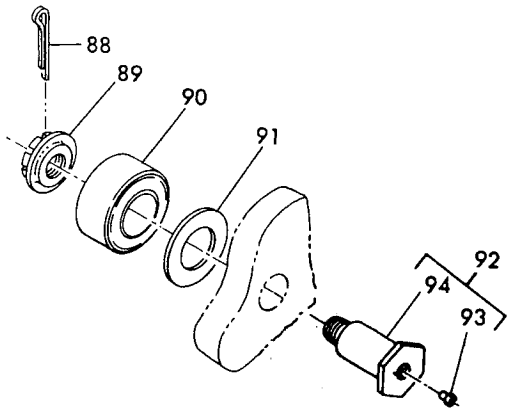
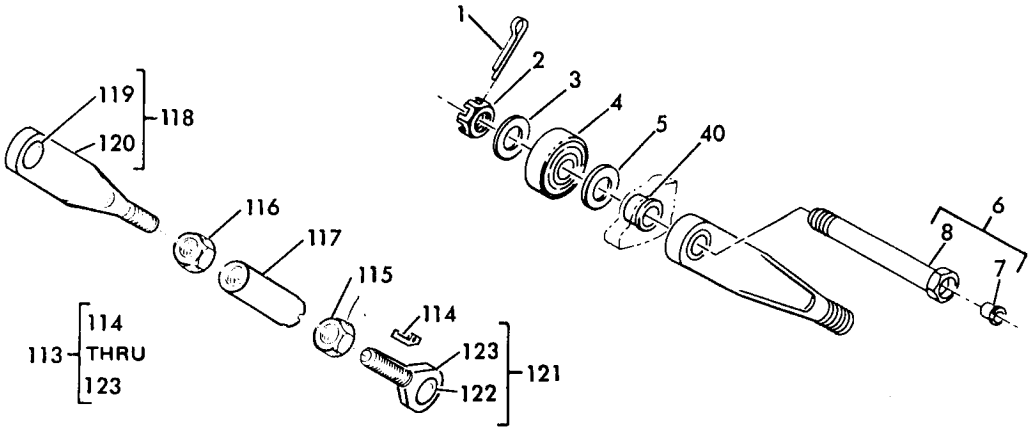
F
G



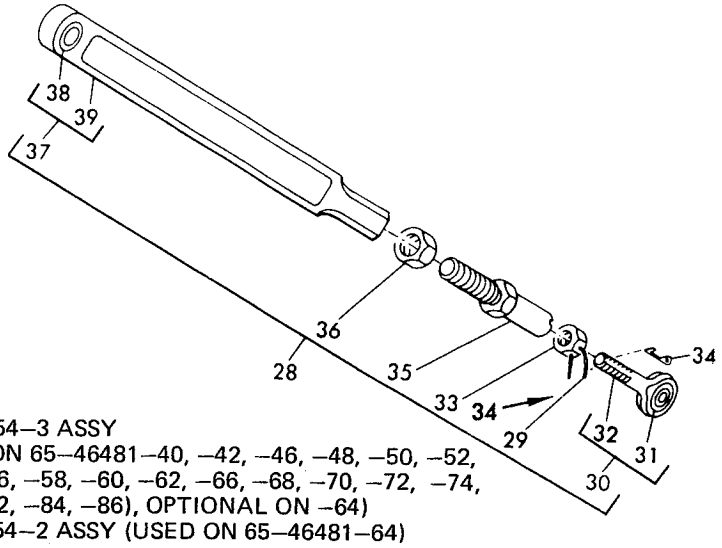
(H) (TYPICAL)



(J) (TYPICAL)



69–59869–1 ASSY
(USED ON 65–46481–39, –41, –45, –47, –49, –51, –53, –55, –57, –59, –61, –65, –67, –69, –71, –73, –75, –81, –83, –85), – OPTIONAL ON –63)
69–54954–2 ASSY (USED ON 65–46481–63)



69–54954–3 ASSY
(USED ON 65–46481–40, –42, –46, –48, –50, –52, –54, –56, –58, –60, –62, –66, –68, –70, –72, –74, –76, –82, –84, –86), OPTIONAL ON –64)
69–54954–2 ASSY (USED ON 65–46481–64)

(K)

Outboard Flap Carriage Assembly
Figure 1103 (Sheet 4)

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1103-					
	65-46481-39		CARRIAGE ASSY *[5] *[7] *[8]	A	RF
	65-46481-40		CARRIAGE ASSY *[6] *[7] *[8]	B	RF
	65-46481-41		CARRIAGE ASSY *[7] *[8]	C	RF
	65-46481-42		CARRIAGE ASSY *[7] *[8]	D	RF
	65-46481-45		CARRIAGE ASSY *[7] *[8]	E	RF
	65-46481-46		CARRIAGE ASSY *[7] *[8]	F	RF
	65-46481-47		CARRIAGE ASSY (RWK 65-46481-37)	G	RF
	65-46481-48		CARRIAGE ASSY (RWK 65-46481-38)	H	RF
	65-46481-49		CARRIAGE ASSY *[7] *[8]	I	RF
	65-46481-50		CARRIAGE ASSY *[7] *[8]	J	RF
	65-46481-51		CARRIAGE ASSY *[7] *[8]	K	RF
	65-46481-52		CARRIAGE ASSY *[7] *[8]	L	RF
	65-46481-53		CARRIAGE ASSY *[7] *[8]	M	RF
	65-46481-54		CARRIAGE ASSY *[7] *[8]	N	RF
	65-46481-55		CARRIAGE ASSY *[7] *[8]	O	RF
	65-46481-56		CARRIAGE ASSY *[7] *[8]	P	RF
	65-46481-57		CARRIAGE ASSY *[7] *[8]	Q	RF
	65-46481-58		CARRIAGE ASSY *[7] *[8]	R	RF
	65-46481-59		CARRIAGE ASSY *[7] *[8]	S	RF
	65-46481-60		CARRIAGE ASSY *[7] *[8]	T	RF
	65-46481-61		CARRIAGE ASSY *[7] *[8]	U	RF
	65-46481-62		CARRIAGE ASSY *[7] *[8]	V	RF
	65-46481-63		CARRIAGE ASSY *[7] *[8]	W	RF
	65-46481-64		CARRIAGE ASSY *[7] *[8]	X	RF
	65-46481-65		CARRIAGE ASSY *[7] *[8]	Y	RF
	65-46481-66		CARRIAGE ASSY *[7] *[8]	Z	RF
	65-46481-67		CARRIAGE ASSY *[7] *[8]	AA	RF
	65-46481-68		CARRIAGE ASSY *[7] *[8]	BA	RF
	65-46481-69		CARRIAGE ASSY *[7] *[8]	CA	RF
	65-46481-70		CARRIAGE ASSY *[7] *[8]	DA	RF
	65-46481-72		CARRIAGE ASSY *[7] *[8]	EA	RF
	65-46481-73		CARRIAGE ASSY *[7] *[8]	FA	RF
	65-46481-74		CARRIAGE ASSY *[7] *[8]	GA	RF
	65-46481-75		CARRIAGE ASSY *[7] *[8]	HA	RF
	65-46481-76		CARRIAGE ASSY *[7] *[8]	IA	RF
	65-46481-81		CARRIAGE ASSY *[7] *[8]	JA	RF
	65-46481-82		CARRIAGE ASSY *[7] *[8]	KA	RF
	65-46481-83		CARRIAGE ASSY *[7] *[8]	LA	RF
	65-46481-84		CARRIAGE ASSY *[7] *[8]	MA	RF
	65-46481-85		CARRIAGE ASSY *[7] *[8]	NA	RF
	65-46481-86		CARRIAGE ASSY *[7] *[8]	PA	RF

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1103-					
	65-46481-95		CARRIAGE ASSY *[7] *[8]	QA	RF
	65-46481-96		CARRIAGE ASSY *[7] *[8]	RA	RF
1	MS24665-304		. PIN, COTTER		2
2	BACN10JD106		. NUT (REPLS AN320-6)		2
3	AN960-616L		. WASHER		2
4	BACB10B132		. BEARING	A-Z AA-IA LA MA	2
4A	BACB10ET06		. BEARING	JA KA NA RA	2
5	AN960C616		. WASHER		2
5	AN960C616L		. WASHER (OPT TO AN960C616)		2
6	69-39243-3		. BOLT ASSY		2
7	NAS516-1		. . FITTING, LUBRICATION		1
8	69-39243-4		. . BOLT		1
8A	THRU 27		NOT USED		
28	69-54954-2		. STRUT ASSY (69-54954-3 OPT)	WX	1
28	69-54954-3		. STRUT ASSY	A-V Y-AA CA-RA	1
29	MS20995NC51		DELETED		
29	MS20995C32		. . LOCKWIRE		AR
30	69-54956-1		. . ROD END ASSY		1
31	BACB28Y5B31		. . . BUSHING		1
32	69-54956-2		. . . ROD END		1
33	NAS509-6		. . NUT		1
34	NAS559-2		. . LOCK		1
35	69-54958-2		. . COUPLING (USED ON 69-54954-3)		1
35	69-54958-1		. . COUPLING (USED ON 69-54954-2)		1
36	AN3167L		. . NUT		1
37	69-54957-1		. . ROD END ASSY		1
38	BACB28U6B33		. . . BUSHING		139
39	69-54957-2		. . . ROD END		1
40	BACB28X6B54		. BUSHING		2
41	MS24665-287		. PIN, COTTER		2
42	66-19144-2		. NUT, BEARING		2
43	14AFC1832		. BEARING (V92563)	A-Z AA-IA LA MA	2
43	AC47485		. BEARING (V80657)(OPT TO 14AFC1832)	ABGH	2
43	YR743-3		. BEARING (V92563)(OPT TO 14AFC1832)	ABGH	2

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1103-43	AC49007		. BEARING (V80657) (OPT TO 14AFC1832)	A-Z AA-IA LA MA	2
43A	BACB10ET14		. BEARING	JA KA NA-RA	2
44	66-19116-1		. STRIP, RUB (REPLD BY 66-19116-7)		2
44	66-19116-7		. STRIP, RUB (REPLS 66-19116-1)		2
45	65-46481-5		. WASHER, SHIM		2
46	69-38825-5		. BOLT ASSY *[2] (POST SB 57-1096)	A-V YZ AA-KA NA-RA	2
46	69-38825-1		. BOLT ASSY (PRE SB 57-1096)	A B G H BA	2
46	69-38825-7		. BOLT ASSY *[2] (POST SB 57-1096)	W X LA MA	2
47	NAS516-1		. . FITTING LUBRICATION		1
48	69-38825-2		. . BOLT (USED ON 69-38825-1)		1
48	69-38825-6		. . BOLT (USED ON 69-38825-5)		1
48	69-38825-8		. . BOLT (USED ON 69-38825-7)		1
49	BACB30GN4-13		. BOLT		4
50	AN960-416		. WASHER		4
51	65-46481-6		. FILLER, RADIUS		4
52	69-35323-2		. ROLLER ASSY, AFT, OUTBOARD SIDE	OP	1
52	69-35323-1		. ROLLER ASSY, AFT, OUTBOARD SIDE	A-H WX BA LA MA	1
52	65C16951-1		. ROLLER ASSY, AFT, OUTBOARD SIDE (OPT TO 69-35323-1)	WX LA MA	1
52	65C16951-1		. ROLLER ASSY, AFT, OUTBOARD SIDE	I-N Q-V Y-AA CA-KA NA-RA	1
52A	65C16951-2		. ROLLER ASSY, AFT, OUTBOARD SIDE (POST PRR 32876)	I-N Q-V Y-AA CA-KA NA-RA	1
53	MS20995NC20		. . LOCKWIRE		AR
54	MS16562-217		. . PIN, SPRING		1
55	66-23220-1		. . BOLT		1
56	NAS516-1		. . . FITTING, LUBRICATION		1
57	66-23220-3		. . . BOLT		1
58	BACB10B132		. . BEARING (USED ON 69-35323-1, -2)		1
58	BACB10ET06		. . BEARING (USED ON 65C16951-1, -2)		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1103-					
59	69-35323-3		. . BRACKET (USED ON 69-35323-1)		1
59	69-35323-4		. . BRACKET (USED ON 69-35323-2)		1
59	65C16951-3		. . BRACKET (USED ON 65C16951-1)		1
59A	65C16951-4		. . BRACKET (USED ON ITEM 52A)		1
60	69-35323-2		. ROLLER ASSY, AFT, INBOARD SIDE	A-H OPWX BALAM A	1
60	65C16951-2		. ROLLER ASSY, AFT, INBOARD SIDE (OPT TO 69-35323-2)	OPWXL AMA	1
60	65C16952-2		. ROLLER ASSY, AFT, INBOARD SIDE	I-N Q-V YZ AA CA-KA NA-RA	1
60	69-35323-1		. ROLLER ASSY, AFT, INBOARD SIDE	A-H BA	1
60	69-35323-1		. ROLLER ASSY, AFT, INBOARD SIDE	OP WX LAMA	1
60	65C16951-1		. ROLLER ASSY, AFT, INBOARD SIDE (OPT TO 69-35323-1)	OP-WX LA MA	1
60A	65C16951-1		. ROLLER ASSY, AFT, INBOARD SIDE (POST PRR 32876)	I-N Q-V YZ CA-KA NA-RA	1
61	MS20995NC20		. . LOCKWIRE		AR
62	MS16562-217		. . PIN, SPRING		1
63	66-23220-1		. . BOLT ASSY		1
64	NAS516-1		. . . FITTING, LUBRICATION		1
65	66-23220-3		. . . BOLT		1
66	BACB10B132		. . BEARING (USED ON 69-35323-1, -2)		1
66	BACB10ET06		. . BEARING (USED ON 65C16951-1,-2		1
67	69-35323-3		. . BRACKET (USED ON 69-35323-1)		1
67	69-35323-4		. . BRACKET (USED ON 69-35323-2)		1
67	65C16951-3		. . BRACKET (USED ON ITEM 60A)		1
67	65C16951-4		. . BRACKET (USED ON 65C16951-2)		2
68	65-46481-4		. SHIM		2
69	BACB30GN4-4		. BOLT		4
70	NAS620-416		. WASHER		4
71	69-35324-2		. ROLLER ASSY, FORWARD INBOARD SIDE	A-HOP WXBA LA MA	1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1103-					
71	65C16950-2		. ROLLER ASSY, FORWARD SIDE (OPT TO 69-35324-2)	I-AA CA-RA	1
72	MSS20995NC20		. . LOCKWIRE		AR
73	MS16562-217		. . PIN, SPRING		1
74	66-23220-1		. . BOLT ASSY		1
75	NAS516-1		. . . FITTING, LUBRICATION		1
76	66-23220-3		. . . BOLT		1
77	BACB10B132		. . BEARING (USED ON 69-35324-2)		1
77	BACB10ET06		. . BEARING (USED ON 65C16950-2)		1
78	69-35324-4		. . BRACKET (USED ON 69-35324-2)		1
78	65C16950-4		. . BRACKET (USED ON 65C16950-2)		1
79	69-35324-1		. ROLLER ASSY, FORWARD SIDE	A-H OPWX BALA MA	1
79	65C16950-1		. ROLLER ASSY, FORWARD SIDE (OPT TO 69-35324-1)	I-AA CA-RA	1
80	MS20995NC20		. . LOCKWIRE		AR
81	MS16562-217		. . PIN, SPRING		1
82	66-23220-1		. . BOLT ASSY		1
83	NAS516-1		. . . FITTING, LUBRICATION		1
84	66-23220-3		. . . BOLT		1
85	BACB10B132		. . BEARING (USED ON 69-35324-1)		1
85	BACB10ETT06		. . BEARING (USED ON 65C16950-1)		1
86	69-35324-3		. . BRACKET (USED ON 69-353324-1)		1
86	65C16950-3		. . BRACKET (USED ON 65C16950-1)		1
87	65-46481-3		. SHIM		2
88	MS24665-285		. PIN, COTTER		2
89	66-23217-2		. NUT, BEARING		2
90	12AFC1628		. BEARING (V92563)	A-IA LA MA	2
90	AC47957		. BEARING (V80657) (OPT TO 12AFC1628)	ABGH	2
90	YR746-3		. BEARING (V92563) (OPT TO 12AFC1628)	ABGH BA	2
90	AC49006		. BEARING (V80657) (OPT TO 12AFC1628)	A-IA LA MA	2
90	BACB10ET12		. BEARING	JA KA NA-RA	2
90	AN960C1216L		. WASHER		2

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1103-					
92	69-35347-1		. BOLT ASSY (PRE SB 57-1096)	ABGH BA	2
92	69-35347-5		. BOLT ASSY #[2] (POST SB 57-1069)	AB	2
92	69-35347-7		. BOLT ASSY #[2] (POST SB 57-1069)	AB	2
92	69-35347-5		. BOLT ASSY	C-F I-V Y-AA CA-KA NA-RA	2
92	69-35347-7		. BOLT ASSY	WX LA MA	2
93	NAS516-1		. . FITTING, LUBRICATION		1
94	69-35347-2		. . BOLT (USED ON 69-35347-1)		1
94	69-35347-6		. . BOLT (USED ON 69-35347-5)		1
94	69-35347-8		. . BOLT (USED ON 69-35347-7)		1
95	MS24665-132		. PIN, COTTER		2
96	BACN10JD104		DELETED		
96	AN320-4		. NUT		2
97	AN960-416L		. WASHER		2
98	69-20787-1		. BOLT ASSY		2
99	NAS516-1		. . FITTING, LUBRICATION		1
100	69-20787-4		. . BOLT		1
101	66-13369-1		. WASHER, LAMINATED		2
102	BACB10B131		. BEARING, NEEDLE	A-IA LA MA	2
102	BACB10ET04		. BEARING	JA KA NA-RA	2
103	MS20392-1C35		. PIN, CLEVIS		1
103A	AN960-4		. WASHER		2
104	BACN10JD110		. NUT	GH	1
104	F12NE4717-108		. NUT, V72962	A-F I-RA	1
105	AN960-1016L		. WASHER	A-V Y-AA CA-IA	AR
105	AN960PD1016L		. WASHER	JA-RA	AR
105	AN960XC1016L		. WASHER	WX BA LA MA	AR
106	69-61978-1		. WASHER, THRUST	A-F I-V CADA FAGA JA-RA	1
106	69-61978-2		. WASHER, THRUST	GHWX BA	1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1103-106	69-61978-3		. WASHER, THRUST	YZ AAEA HAIA	1
106A	65-46481-43		. KEY	A-F I-V Y-AA	1
106A	65-46481-71		. KEY	CA-IA	1
107	65C10596-7		DELETED		
107	65C10596-3		DELETED		
107	65C10596-8		DELETED		
107	65C10596-4		DELETED		
107	65C10596-5		. BEARING, W/KEYWAY	Q-V CA DA FA GA	1
107	65C10596-1		. BEARING, W/KEYWAY	A-F I-P	1
107	65C10596-9		. BEARING, W/KEYWAY	Y-AA EA HA IA	1
107	LA-4187-A		. BEARING	WX BA	1
107	65C10596-6		. BEARING, W/O KEYWAY	GH	1
107	KJB197014V-1		. BEARING ASSY *[3]	JA KA NA-RA	1
107	KJB228114V-1		. BEARING ASSY, 0.014 UNDERSIZE *[3]	JA KA NA-RA	1
107	KJB228214V-1		. BEARING ASSY, 0.030 UNDERSIZE *[3]	JA KA NA-RA	1
107	KJB228314V-1		. BEARING ASSY, 0.060 UNDERSIZE	JA KA NA-RA	1
107	KJB208015V-1		. BEARING ASSY *[3]	LA MA	1
107A	KJB197014V-5		. . BEARING (USED ON KJB197014V-1, KJB228114V-1, KJB228214V-1, KJB228314V-1)		1
107A	KJB208015V-5		. . BEARING (USED ON KJB208015V-1)		1
107B	65C10596-2		DELETED		
107B	KJB197014V-3		. . BUSHING (USED ON KJB197014V-1)		1
107B	KJB208015V-3		. . BUSHING (USED ON KJB208015V-1)		1
107B	KJB228114V-3		. . BUSHING (USED ON KJB228114V-1)		1
107B	KJB228214V-3		. . BUSHING (USED ON KJB228214V-1)		1
107B	KJB228314V-3		. . BUSHING (USED ON KJB228314V-1)		1
108	69-61976-2		. BUSHING	WX BA	1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1103-108A	BACN10HR5CS		. NUT *[1]	UV Y-AA EA-KA NA-RA	1
108A	BACN10HR5		. NUT	UV Y-AA EA-KA NA-RA	1
108A	FNF26-524		. NUT, V56878	A-T CA DA	1
108A	BACN10HR5		. NUT (OPT TO FNF26-524)	A-T CA DA	1
108B	BACW10BP5APU		. WASHER *[1]	UV Y-AA EA-KA PA-RA	1
108B	AN960PD516		. WASHER	A-T CA DA NA	1
108C	70315-5-38		. BOLT, MULTIPHASE, V56878 *[1]	UV Y-AA EA-KA NA PA-RA	1
108C	EWB26-5-38		. BOLT, V56878	A-T CA DA NA	1
108D	10-61850-1		. BEARING	A-L OP	1
108D	176412		DELETED		
108D	HSP30-106		DELETED		
108D	KMDB29-2		DELETED		
108D	10-61850-1A		. BEARING	MNQ-V Y-AA CA-KA NA-RA	1
108D	KMDB29-3		DELETED		
108D	79955		DELETED		
108D	KSC146729B		DELETED		
108D	HSPRR30-106		DELETED		

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1103-108D	HTY29-101		DELETED		
108D	KSC236429V		. BEARING, (V50632)(OPT)	A-V Y-AA CA-KA NA-RA	1
108E	BACW10BP5ACU		. WASHER *[1]	UV Y-AA EA-KA NA-RA	1
108E	BACW10BP5AC		. WASHER	I-N CA DA Q-T	1
109	65-47821-16		. CARRIAGE ASSY	GH	1
109	65-47821-20		. CARRIAGE ASSY	A-D	1
109	65-47821-22		. CARRIAGE ASSY	EFI-R	1
109	65-47821-24		. CARRIAGE ASSY	S-V Y-AA CA-KA	1
109	65-47821-26		. CARRIAGE ASSY	NA PA	1
109	65-67159-9		. CARRIAGE ASSY	WX BA LA MA	1
109	65-47821-28		. CARRIAGE ASSY	QA RA	1
110	65-47821-18		. . SLEEVE (USED ON 65-47821-16, -20, -22, -24, -26, -28) *[4] *[9]		1
110	69-67219-4		. . SLEEVE, .014 U/S (SB 57-1085)		1
110	69-67219-5		. . SLEEVE, .030 U/S (SB 57-1085)		1
110	65-67159-3		. . SLEEVE, (USED ON 65-67159-9) *[10]		1
111	BACB28U5E075		. . BUSHING (USED ON 65-47821-16) (OPT TO BACB28U5E170)		2
111	BACB28U5E170		. . BUSHING (USED ON 65-47821-16) (OPT TO BACB28U5E075)		1
111	BACB28U5C075		. . BUSHING (USED ON 65-47821-20, -22, -24, -26, -28) (OPT TO BACB28U5C170)		2
111	BACB28U5C170		. . BUSHING (USED ON 65-47821-20, -22, -24, -26, -28) (OPT TO BACB28U5C075)		1
111	BACB28U6B75		. . BUSHING (USED ON 65-67159-9)		1
112	65-47821-17		. . CARRIAGE (USED ON 65-47821-16)		1
112	65-47821-21		. . CARRIAGE (USED ON 65-47821-20)		1
112	65-47821-23		. . CARRIAGE (USED ON 65-47821-22)		1
112	65-47821-25		. . CARRIAGE (USED ON 65-47821-24)		1
112	65-47821-27		. . CARRIAGE (USED ON 65-47821-26)		1
112	65-47821-29		. . CARRIAGE (USED ON 65-47821-28)		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1103-					
112	65-67159-10		. . CARRIAGE (USED ON 65-67159-9)		1
113	69-54954-2		. STRUT ASSY	WX	1
113	69-59869-1		. STRUT ASSY		1
114	NAS559-2		. . LOCK		1
115	NAS509-6		. . NUT		1
116	NAS509L6		. . NUT (USED ON 69-54954-1)		1
116	AN316-7L		. . NUT (USED ON 69-54954-2)	WX	1
117	69-54958-1		. . COUPLING (USED ON 69-54954-2)	WX	1
117	69-59872-1		. . COUPLING (USED ON 69-59869-1)		1
118	69-54957-1		. . ROD END ASSY (USED ON 69-54954-2)	WX	1
118	69-59870-1		. . ROD END ASSY (USED ON 69-59869-1)		1
119	BACB28Y6B29		. . . BUSHING (USED ON 69-59870-1)		1
119	BACN28Y B33		. . . BUSHING (USED ON 69-45957-1)	WX	1
120	69-54954-2		. . . ROD END (USED ON 69-54957-1)	WX	1
120	69-59870-3		. . . ROD END (USED ON 69-59870-1)		1
121	69-54956-1		. . ROD END ASSY (USED ON 69-54954-2)	WX	1
121	69-59871-1		. . ROD END ASSY (USED ON 69-59869-1)		1
122	BACB28Y5B29		. . . BUSHING (USED ON 69-59871-1)		1
122	BACB28Y5B31		. . . BUSHING (USED ON 69-54956-1)	WX	1
123	69-54956-2		. . . ROD END (USED ON 69-54956-1)	WX	1
123	69-59871-3		. . . ROD END (USED ON 69-59871-1)		1

*[1] USE BOLT 70315-5-38 WITH BACW10BP5ACU WASHER UNDER HEAD, BACN10HR5CS NUT AND BACW10BP5APU WASHER UNDER NUT. PREFERRED ON ALL ASSYS FOR CORROSION RESISTANCE.
*[2] LIMITED USAGE.
*[3] BEARING ASSEMBLIES HAVE A "KARON" LINING. DO NOT INTERMIX WITH OTHER BUSHINGS.
*[4] DO NOT USE SLEEVE 65-47821-18 ON CARRIAGE ASSY 65-47821-16, -20, -22, -24, -26, OR -28 IF AN UNDERSIZE SLEEVE HAS BEEN INSTALLED.
*[5] PRE SB 737-57-1092R3, OPT 65-46481-81.
*[6] PRE SB 737-57-1092R3, OPT 65-46481-82.
*[7] PRE SB 737-57-57A1218R3.
*[8] NO EQUIVALENT BOEING PART NUMBER FOR REWORKED PART.
*[9] MAKE FROM 69-46453-2.
*[10] MAKE FROM 69-46449-1.

VENDORS

V09455	LEAR SIEGLER INCORPORATED, TRANSPORT DYNAMICS DIVISION, 3131 SEGERSTROM AVENUE, SANTA ANA, CALIFORNIA 92702
V21335	THE FAFNIR BEARING COMPANY, DIVISION OF TEXTRON INCORPORATED, 37 BOOTH STREET, NEW BRITAIN, CONNECTICUT 06050
V50632	KAMATICS CORPORATION, 1335 BLUE HILLS AVENUE, BLOOMFIELD, CONNECTICUT 06002
V56878	STANDARD PRESSED STEEL COMPANY, BENSON EAST, JENKINTOWN, PENNSYLVANIA 19046
V72962	ESNA, DIVISION OF AMERACE CORPORATION, 2330 VAUXHALL ROAD, UNION, NEW JERSEY 07083
V73134	HEIM UNIVERSAL, DIVISION OF ROCKWELL INTERNAT'L CORPORATION, 60 ROUND HILL ROAD, FAIRFIELD, CONNECTICUT 06430
V77896	REXNORD INCORPORATED, BEARING DIVISION, 2400 CURTIS STREET, DOWNER'S GROVE, ILLINOIS 60515
V80657	THE TORRINGTON COMPANY, BEARING DIVISION, 3702 W. SAMPLE STREET, SOUTH BEND, INDIANA 46634
V80894	TRIBON BEARING COMPANY, 439-441 HALL AVENUE, ST. MARY'S, PENNSYLVANIA 15857
V81376	SOUTHEAST PRODUCTS COMPANY, 1705 SOUTH MOUNTAIN AVENUE, MONROVIA, CALIFORNIA 91016
V92563	McGILL MANUFACTURING COMPANY INC., BEARINGS DIVISION, 907 LAFAYETTE, VALPARAISO, INDIANA 46383
V97613	SARGENT INDUSTRIES, KAHR BEARING DIVISION, 3010 NORTH SAN FERNANDO BLVD., BURBANK, CALIFORNIA 91503

Part No.	Fig. and Index No.	Qty. per Assy.
AC47485	1101-43	2
AC47485	1102-43	2
AC47485	1103-43	2
AC47957	1101-90	2
AC47957	1102-90	2
AC47957	1103-90	2
AC49006	1101-90	2
AC49006	1102-90	2
AC49006	1103-90	2
AC49007	1101-43	2
AC49007	1102-43	2
AC49007	1103-43	2
AN3167L	1101-36	1
AN3167L	1102-36	1
AN3167L	1103-36	1
AN316-7L	1101-24	1
AN316-7L	1102-24	1
AN316-7L	1103-116	1
AN320-10	1101-104	1
AN320-4	1101-96	2
AN320-4	1102-96	2
AN320-4	1103-96	2
AN320-6	1102-104	1
AN60-616L	1102-105	AR
AN960-1016L	1101-105	AR
AN960-1016L	1103-105	AR
AN960-1416L	1101-91A	2
AN960-1416L	1102-91A	2
AN960-4	1101-103A	2
AN960-4	1102-103A	2
AN960-4	1103-103A	2
AN960-416	1101-127	
AN960-416	1101-50	4
AN960-416	1102-50	4
AN960-416	1103-50	4
AN960-416L	1101-97	2
AN960-416L	1102-97	2
AN960-416L	1103-97	2
AN960-616L	1101-3	2
AN960-616L	1102-3	2
AN960-616L	1103-3	2
AN960C1216L	1101-91	2
AN960C1216L	1102-91	2
AN960C1216L	1103-90	2
AN960C616	1101-5	2
AN960C616	1102-105	AR

Part No.	Fig. and Index No.	Qty. per Assy.
AN960C616	1102-5	2
AN960C616	1103-5	2
AN960C616L	1101-5	2
AN960C616L	1102-5	2
AN960C616L	1103-5	2
AN960PD1016L	1103-105	AR
AN960PD516	1101-108B	1
AN960PD516	1103-108B	1
AN960PD616	1101-8A	1
AN960PD616	1101-8A	2
AN960PD616	1102-8A	1
AN960PD616	1102-8A	2
AN960PD616L	1102-105	AR
AN960XC1016L	1103-105	AR
BAC27DWG21	1101-124	1
BAC27DWG21	1102-124	1
BAC28Y6B29	1102-119	1
BACB10B1132	1102-77	1
BACB10B131	1101-102	2
BACB10B131	1102-102	2
BACB10B131	1103-102	2
BACB10B132	1101-4	2
BACB10B132	1101-58	1
BACB10B132	1101-66	1
BACB10B132	1101-77	1
BACB10B132	1101-85	1
BACB10B132	1102-4	2
BACB10B132	1102-58	1
BACB10B132	1102-66	1
BACB10B132	1102-85	1
BACB10B132	1103-4	2
BACB10B132	1103-58	1
BACB10B132	1103-66	1
BACB10B132	1103-77	1
BACB10B132	1103-85	1
BACB10B135	1101-90	2
BACB10B135	1102-90	2
BACB10B136	1101-43	2
BACB10B136	1102-43	2
BACB10BN12	1101-90	2
BACB10BN12	1102-90	2
BACB10BN14	1101-43	2
BACB10BN14	1102-43	2
BACB10ET04	1103-102	2
BACB10ET06	1103-4A	2
BACB10ET06	1103-58	1

Part No.	Fig. and Index No.	Qty. per Assy.
BACB10ET06	1103-66	1
BACB10ET06	1103-77	1
BACB10ET12	1103-90	2
BACB10ET14	1103-43A	2
BACB10ETT06	1103-85	1
BACB28U5C075	1103-111	2
BACB28U5C170	1103-111	1
BACB28U5E075	1101-111	2
BACB28U5E075	1103-111	2
BACB28U5E170	1101-111	1
BACB28U5E170	1103-111	1
BACB28U6B33	1101-38	1
BACB28U6B33	1102-38	1
BACB28U6B33	1103-38	1
BACB28U6B75	1102-111	2
BACB28U6B75	1103-111	1
BACB28X6B54	1101-40	2
BACB28X6B54	1102-40	2
BACB28X6B54	1103-40	2
BACB28Y5B19	1101-19	1
BACB28Y5B19	1102-19	1
BACB28Y5B29	1101-122	1
BACB28Y5B29	1102-122	1
BACB28Y5B29	1103-122	1
BACB28Y5B31	1101-19	1
BACB28Y5B31	1101-31	1
BACB28Y5B31	1102-19	1
BACB28Y5B31	1102-31	1
BACB28Y5B31	1103-122	1
BACB28Y5B31	1103-31	1
BACB28Y6B21	1101-26	1
BACB28Y6B21	1102-26	1
BACB28Y6B29	1101-119	1
BACB28Y6B29	1103-119	1
BACB28Y6B33	1101-14	1
BACB28Y6B33	1101-26	1
BACB28Y6B33	1102-14	1
BACB28Y6B33	1102-26	1
BACB30GN4-13	1101-49	4
BACB30GN4-13	1102-49	4
BACB30GN4-13	1103-49	4
BACB30GN4-4	1101-69	4
BACB30GN4-4	1102-69	4
BACB30GN4-4	1103-69	4
BACB30LJ4-8	1101-126	
BACB30LP4P6	1101-132	
BACB30LP4P6	1102-132	2

Part No.	Fig. and Index No.	Qty. per Assy.
BACN10HR5	1101-108A	1
BACN10HR5	1103-108A	1
BACN10HR5	1103-108A	1
BACN10HR5CS	1101-108A	1
BACN10HR5CS	1103-108A	1
BACN10JC4	1101-128	
BACN10JD104	1101-96	
BACN10JD104	1102-96	
BACN10JD104	1103-96	
BACN10JD106	1101-2	2
BACN10JD106	1102-2	2
BACN10JD106	1103-2	2
BACN10JD110	1101-104	
BACN10JD110	1103-104	1
BACN10JD6	1102-104	1
BACN28Y B33	1103-119	1
BACW10BN6AC	1101-8B	1
BACW10BN6AC	1101-8B	2
BACW10BN6AC	1102-8B	1
BACW10BN6AC	1102-8B	2
BACW10BN6ANC	1101-8B	1
BACW10BN6ANC	1101-8B	2
BACW10BN6ANC	1102-8B	1
BACW10BN6ANC	1102-8B	2
BACW10BP5AC	1101-108E	
BACW10BP5AC	1103-108E	1
BACW10BP5ACU	1101-108E	1
BACW10BP5ACU	1103-108E	1
BACW10BP5APU	1101-108B	1
BACW10BP5APU	1103-108B	1
DREM-5-076	1101-11	1
DREM-5-076	1102-11	1
EWB26-5-38	1101-108C	1
EWB26-5-38	1103-108C	1
F12NE4717-064	1102-104	1
F12NE4717-064	1102-104	1
F12NE4717-108	1101-104	1
F12NE4717-108	1101-104	1
F12NE4717-108	1101-104	1
F12NE4717-108	1103-104	1
FNF26-524	1101-108A	1
FNF26-524	1103-108A	1
HSP30-106	1101-108D	
HSP30-106	1103-108D	
HSPRR30-106	1103-108D	
HTY29-101	1103-108D	

Part No.	Fig. and Index No.	Qty. per Assy.
KJB197014V-1	1101-107	1
KJB197014V-1	1101-107	1
KJB197014V-1	1101-107	1
KJB197014V-1	1103-107	1
KJB197014V-3	1101-107B	1
KJB197014V-3	1103-107B	1
KJB197014V-5	1101-107A	1
KJB197014V-5	1103-107A	1
KJB208015V-1	1102-107	1
KJB208015V-1	1103-107	1
KJB208015V-3	1102-107B	1
KJB208015V-3	1103-107B	1
KJB208015V-5	1102-107A	1
KJB208015V-5	1103-107A	1
KJB228114V-1	1101-107	1
KJB228114V-1	1103-107	1
KJB228114V-3	1101-107B	1
KJB228114V-3	1103-107B	1
KJB228214V-1	1101-107	1
KJB228214V-1	1103-107	1
KJB228214V-3	1101-107B	1
KJB228214V-3	1103-107B	1
KJB228314V-1	1101-107	1
KJB228314V-1	1103-107	1
KJB228314V-1	1103-107B	1
KJB228314V-3	1101-107B	1
KMDB29-2	1101-108D	
KMDB29-2	1103-108D	
KMDB29-3	1101-108D	
KMDB29-3	1103-108D	
KSC146729B	1101-108D	
KSC146729B	1103-108D	
KSC236429V	1101-108D	1
KSC236429V	1103-108D	1
LA-4187-A	1101-107	1
LA-4187-A	1101-107	1
LA-4187-A	1102-107	1
LA-4187-A	1103-107	1
LA-5941-A	1102-107	1
MS16562-217	1101-54	1
MS16562-217	1101-62	1
MS16562-217	1101-73	1
MS16562-217	1101-81	1
MS16562-217	1102-54	1
MS16562-217	1102-62	1
MS16562-217	1102-73	1
MS16562-217	1102-81	1

Part No.	Fig. and Index No.	Qty. per Assy.
MS16562-217	1103-54	1
MS16562-217	1103-62	1
MS16562-217	1103-73	1
MS16562-217	1103-81	1
MS20392-1C19	1102-103	1
MS20392-1C21	1102-103	1
MS20392-1C33	1101-103	1
MS20392-1C35	1101-103	1
MS20392-1C35	1101-103	1
MS20392-1C35	1103-103	1
MS20995C32	1101-10	AR
MS20995C32	1101-17	AR
MS20995C32	1101-29	AR
MS20995C32	1102-10	AR
MS20995C32	1102-17	AR
MS20995C32	1102-29	AR
MS20995C32	1103-29	AR
MS20995NC20	1101-53	AR
MS20995NC20	1101-61	AR
MS20995NC20	1101-72	AR
MS20995NC20	1101-80	AR
MS20995NC20	1102-53	AR
MS20995NC20	1102-61	AR
MS20995NC20	1102-72	AR
MS20995NC20	1102-80	AR
MS20995NC20	1103-53	AR
MS20995NC20	1103-61	AR
MS20995NC20	1103-80	AR
MS20995NC51	1103-29	
MS24665-132	1101-95	2
MS24665-132	1102-95	2
MS24665-132	1103-95	2
MS24665-285	1101-88	2
MS24665-285	1102-88	2
MS24665-285	1103-88	2
MS24665-287	1101-41	2
MS24665-287	1102-103	1
MS24665-287	1102-41	2
MS24665-287	1103-41	2
MS24665-304	1101-1	2
MS24665-304	1102-1	2
MS24665-304	1103-1	2
MS24665-355	1101-103	1
MSS20995NC20	1103-72	AR
NAS43DD7-21	1101-24A	1
NAS43DD7-21	1102-24A	1
NAS43HT7-21	1101-24A	1

Part No.	Fig. and Index No.	Qty. per Assy.
NAS43HT7-21	1102-24A	1
NAS509-6	1101-115	1
NAS509-6	1101-12	1
NAS509-6	1101-21	1
NAS509-6	1101-33	1
NAS509-6	1102-115	1
NAS509-6	1102-12	1
NAS509-6	1102-21	1
NAS509-6	1102-33	1
NAS509-6	1103-115	1
NAS509-6	1103-33	1
NAS509L6	1101-116	1
NAS509L6	1102-116	1
NAS509L6	1103-116	1
NAS509L7	1101-24	1
NAS509L7	1102-24	1
NAS516-1	1101-47	1
NAS516-1	1101-56	1
NAS516-1	1101-64	1
NAS516-1	1101-7	1
NAS516-1	1101-75	1
NAS516-1	1101-83	1
NAS516-1	1101-93	1
NAS516-1	1101-99	1
NAS516-1	1102-47	1
NAS516-1	1102-56	1
NAS516-1	1102-64	1
NAS516-1	1102-7	1
NAS516-1	1102-75	1
NAS516-1	1102-83	1
NAS516-1	1102-93	1
NAS516-1	1102-99	1
NAS516-1	1103-47	1
NAS516-1	1103-56	1
NAS516-1	1103-64	1
NAS516-1	1103-7	1
NAS516-1	1103-75	1
NAS516-1	1103-83	1
NAS516-1	1103-93	1
NAS516-1	1103-99	1
NAS537-5P075	1101-111	2
NAS559-2	1101-114	1
NAS559-2	1101-22	1
NAS559-2	1101-34	1
NAS559-2	1102-114	1
NAS559-2	1102-22	1
NAS559-2	1102-34	1

Part No.	Fig. and Index No.	Qty. per Assy.
NAS559-2	1103-114	1
NAS559-2	1103-34	1
NAS620-416	1101-70	4
NAS620-416	1102-70	4
NAS620-416	1103-70	4
REMS10ATC12	1101-11	1
REMS10ATC12	1102-11	1
TFM-105-S	1101-11	1
TFM-105-S	1102-11	1
YR743-3	1101-43	2
YR743-3	1102-43	2
YR743-3	1103-43	2
YR746-3	1101-90	2
YR746-3	1102-90	2
YR746-3	1103-90	2
10-61850-1	1101-108D	1
10-61850-1	1103-108D	1
10-61850-1A	1101-108D	1
10-61850-1A	1103-108D	1
10-61865-1	1101-107	1
10-61865-1	1101-107	1
12AFC1628	1101-90	2
12AFC1628	1102-90	2
12AFC1628	1103-90	2
14AFC1832	1101-43	2
14AFC1832	1102-43	2
14AFC1832	1103-43	2
176412	1101-108D	
176412	1103-108D	
65-46481-1	1101	RF
65-46481-11	1101	RF
65-46481-12	1101	RF
65-46481-13	1102	RF
65-46481-14	1102	RF
65-46481-15	1101	RF
65-46481-16	1101	RF
65-46481-17	1101	RF
65-46481-18	1101	RF
65-46481-19	1102	RF
65-46481-20	1102	RF
65-46481-21	1101	RF
65-46481-22	1101	RF
65-46481-23	1101	RF
65-46481-24	1101	RF
65-46481-25	1102	RF
65-46481-26	1102	RF

Part No.	Fig. and Index No.	Qty. per Assy.
65-46481-27	1101	RF
65-46481-28	1101	RF
65-46481-3	1101-87	1
65-46481-3	1102-87	2
65-46481-3	1103-87	2
65-46481-31	1101	RF
65-46481-32	1101	RF
65-46481-33	1101	RF
65-46481-34	1101	RF
65-46481-37	1101	RF
65-46481-38	1101	RF
65-46481-39	1103	RF
65-46481-4	1101-68	2
65-46481-4	1102-68	2
65-46481-4	1103-68	2
65-46481-40	1103	RF
65-46481-41	1103	RF
65-46481-42	1103	RF
65-46481-43	1103-106A	1
65-46481-45	1103	RF
65-46481-46	1103	RF
65-46481-47	1103	RF
65-46481-48	1103	RF
65-46481-49	1103	RF
65-46481-5	1101-45	2
65-46481-5	1102-45	2
65-46481-5	1103-45	2
65-46481-50	1103	RF
65-46481-51	1103	RF
65-46481-52	1103	RF
65-46481-53	1103	RF
65-46481-54	1103	RF
65-46481-55	1103	RF
65-46481-56	1103	RF
65-46481-57	1103	RF
65-46481-58	1103	RF
65-46481-59	1103	RF
65-46481-6	1101-129	
65-46481-6	1101-51	4
65-46481-6	1102-51	4
65-46481-6	1103-51	4
65-46481-60	1103	RF
65-46481-61	1103	RF
65-46481-62	1103	RF
65-46481-63	1103	RF
65-46481-64	1103	RF

Part No.	Fig. and Index No.	Qty. per Assy.
65-46481-65	1103	RF
65-46481-66	1103	RF
65-46481-67	1103	RF
65-46481-68	1103	RF
65-46481-69	1103	RF
65-46481-70	1103	RF
65-46481-71	1103-106A	1
65-46481-72	1103	RF
65-46481-73	1103	RF
65-46481-74	1103	RF
65-46481-75	1103	RF
65-46481-76	1103	RF
65-46481-8	1102	RF
65-46481-81	1103	RF
65-46481-82	1103	RF
65-46481-83	1103	RF
65-46481-84	1103	RF
65-46481-85	1103	RF
65-46481-86	1103	RF
65-46481-95	1103	RF
65-46481-96	1103	RF
65-47821-10	1101-109	1
65-47821-11	1101-112	1
65-47821-12	1101-109	1
65-47821-13	1101-112	1
65-47821-16	1101-109	1
65-47821-16	1103-109	1
65-47821-17	1101-112	1
65-47821-17	1103-112	1
65-47821-18	1101-110	1
65-47821-18	1103-110	1
65-47821-20	1103-109	1
65-47821-21	1103-112	1
65-47821-22	1103-109	1
65-47821-23	1103-112	1
65-47821-24	1103-109	1
65-47821-25	1103-112	1
65-47821-26	1103-109	1
65-47821-27	1103-112	1
65-47821-28	1103-109	1
65-47821-29	1103-112	1
65-47821-4	1101-110	1
65-47821-5	1101-112	1
65-47821-6	1101-109	1
65-47821-7	1101-112	
65-47821-8	1101-109	1

Part No.	Fig. and Index No.	Qty. per Assy.
65-47821-9	1101-112	1
65-67159-1	1102-109	1
65-67159-10	1103-112	1
65-67159-2	1102-112	1
65-67159-3	1102-110	1
65-67159-3	1103-110	1
65-67159-4	1102-112	1
65-67159-5	1102-109	1
65-67159-6	1102-112	1
65-67159-7	1102-109	1
65-67159-8	1102-112	1
65-67159-9	1103-109	1
65-76161-3	1101-16	1
65-76161-3	1101-16	2
65-76161-3	1102-16	1
65-76161-3	1102-16	2
65-76161-5	1101-24A	1
65-76161-5	1102-24A	1
65-76161-6	1101-27	1
65-76161-6	1102-27	1
65-76161-7	1101-25	1
65-76161-7	1102-25	1
65-76161-8	1101-20	1
65-76161-8	1102-20	1
65-76161-9	1101-18	1
65-76161-9	1102-18	1
65-79949-1	1101	RF
65-79949-10	1102	RF
65-79949-2	1101	RF
65-79949-3	1101	RF
65-79949-4	1101	RF
65-79949-5	1101	RF
65-79949-6	1101	RF
65-79949-7	1102	RF
65-79949-8	1102	RF
65-79949-9	1102	RF
65C10596-1	1103-107	1
65C10596-2	1101-107	
65C10596-2	1103-107B	
65C10596-3	1103-107	
65C10596-4	1103-107	
65C10596-5	1103-107	1
65C10596-6	1101-107	1
65C10596-6	1101-107	1
65C10596-6	1101-107	1

Part No.	Fig. and Index No.	Qty. per Assy.
65C10596-6	1103-107	1
65C10596-7	1103-107	
65C10596-8	1103-107	
65C10596-9	1103-107	1
65C16950-1	1103-79	1
65C16950-2	1103-71	1
65C16950-3	1103-86	1
65C16950-4	1103-78	1
65C16951-1	1103-52	1
65C16951-1	1103-52	1
65C16951-1	1103-60	1
65C16951-1	1103-60A	1
65C16951-2	1103-52A	1
65C16951-2	1103-60	1
65C16951-3	1103-59	1
65C16951-3	1103-67	1
65C16951-4	1103-59A	1
65C16951-4	1103-67	2
65C16952-2	1103-60	1
66-10985	1101-133	
66-10985	1102-133	2
66-13369-1	1101-101	2
66-13369-1	1102-101	2
66-13369-1	1103-101	2
66-19116-1	1101-44	2
66-19116-1	1102-44	2
66-19116-1	1103-44	2
66-19116-7	1101-44	2
66-19116-7	1102-44	2
66-19116-7	1103-44	2
66-19144-1	1101-42	2
66-19144-1	1102-42	2
66-19144-2	1101-42	2
66-19144-2	1101-42	2
66-19144-2	1102-42	2
66-19144-2	1103-42	2
66-23215-1	1101-108	1
66-23216-1	1101-107	1
66-23216-1	1102-107	1
66-23217-1	1101-89	2
66-23217-1	1102-89	2
66-23217-2	1101-89	2
66-23217-2	1101-89	2
66-23217-2	1102-89	2
66-23217-2	1103-89	2
66-23220-1	1101-55	1

Part No.	Fig. and Index No.	Qty. per Assy.
66-23220-1	1101-63	1
66-23220-1	1101-74	1
66-23220-1	1101-82	1
66-23220-1	1102-55	1
66-23220-1	1102-63	1
66-23220-1	1102-74	1
66-23220-1	1102-82	1
66-23220-1	1103-55	1
66-23220-1	1103-63	1
66-23220-1	1103-74	1
66-23220-1	1103-82	1
66-23220-3	1101-57	1
66-23220-3	1101-65	1
66-23220-3	1101-76	1
66-23220-3	1101-84	1
66-23220-3	1102-57	1
66-23220-3	1102-65	1
66-23220-3	1102-76	1
66-23220-3	1102-84	1
66-23220-3	1103-57	1
66-23220-3	1103-65	1
66-23220-3	1103-76	1
66-23220-3	1103-84	1
66-23245-1	1101-106	1
66-23245-2	1102-106	1
69-20787-1	1101-98	2
69-20787-1	1102-98	2
69-20787-1	1103-98	2
69-20787-4	1101-100	1
69-20787-4	1102-100	1
69-20787-4	1103-100	1
69-35323-1	1101-52	1
69-35323-1	1102-52	1
69-35323-1	1103-52	1
69-35323-1	1103-60	1
69-35323-1	1103-60	1
69-35323-2	1101-60	1
69-35323-2	1102-60	1
69-35323-2	1103-52	1
69-35323-2	1103-60	1
69-35323-3	1101-59	1
69-35323-3	1102-59	1
69-35323-3	1103-59	1
69-35323-3	1103-67	1
69-35323-4	1101-67	1
69-35323-4	1102-67	1

Part No.	Fig. and Index No.	Qty. per Assy.
69-35323-4	1103-59	1
69-35323-4	1103-67	1
69-35324-1	1101-79	1
69-35324-1	1102-79	1
69-35324-1	1103-79	1
69-35324-2	1101-71	1
69-35324-2	1102-71	1
69-35324-2	1103-71	1
69-35324-3	1101-86	1
69-35324-3	1102-86	1
69-35324-3	1103-86	1
69-35324-4	1101-78	1
69-35324-4	1102-78	1
69-35324-4	1103-78	1
69-35347-1	1101-92	2
69-35347-1	1103-92	2
69-35347-10	1101-94	
69-35347-2	1101-94	1
69-35347-2	1103-94	1
69-35347-3	1102-92	2
69-35347-4	1102-94	1
69-35347-5	1101-92	2
69-35347-5	1103-92	2
69-35347-5	1103-92	2
69-35347-6	1101-94	1
69-35347-6	1103-94	1
69-35347-7	1102-92	2
69-35347-7	1103-92	2
69-35347-7	1103-92	2
69-35347-8	1102-94	1
69-35347-8	1103-94	1
69-35347-9	1101-92	
69-38825-1	1101-46	2
69-38825-1	1103-46	2
69-38825-2	1101-48	1
69-38825-2	1103-48	1
69-38825-3	1102-46	2
69-38825-4	1102-48	1
69-38825-5	1101-46	2
69-38825-5	1103-46	2
69-38825-6	1101-48	1
69-38825-6	1103-48	1
69-38825-7	1102-46	2
69-38825-7	1103-46	2
69-38825-8	1102-48	1
69-38825-8	1103-48	1
69-39243-3	1101-6	2

Part No.	Fig. and Index No.	Qty. per Assy.
69-39243-3	1102-6	2
69-39243-3	1103-6	2
69-39243-4	1101-8	1
69-39243-4	1102-8	1
69-39243-4	1103-8	1
69-39245-1	1101-9	2
69-39245-1	1102-9	3
69-42367-3	1101-13	1
69-42367-3	1102-13	1
69-42367-4	1101-15	1
69-42367-4	1102-15	1
69-42367-5	1101-13	1
69-42367-5	1102-13	1
69-42367-6	1101-15	1
69-42367-6	1102-15	1
69-46448-1	1102-108	1
69-54954-1	1101-16	1
69-54954-1	1102-16	1
69-54954-2	1101-28	1
69-54954-2	1102-28	1
69-54954-2	1103-113	1
69-54954-2	1103-120	1
69-54954-2	1103-28	1
69-54954-3	1101-28	1
69-54954-3	1102-28	
69-54954-3	1103-28	1
69-54955-1	1101-25	1
69-54955-1	1102-25	1
69-54955-2	1101-27	1
69-54955-2	1102-27	1
69-54956-1	1101-18	1
69-54956-1	1101-30	1
69-54956-1	1102-18	1
69-54956-1	1102-30	1
69-54956-1	1103-121	1
69-54956-1	1103-30	1
69-54956-2	1101-20	1
69-54956-2	1101-32	1
69-54956-2	1102-20	1
69-54956-2	1102-32	1
69-54956-2	1103-123	1
69-54956-2	1103-32	1
69-54957-1	1101-37	1
69-54957-1	1102-37	1
69-54957-1	1103-118	1
69-54957-1	1103-37	1
69-54957-2	1101-39	1

Part No.	Fig. and Index No.	Qty. per Assy.
69-54957-2	1102-39	1
69-54957-2	1103-39	1
69-54958-1	1101-23	1
69-54958-1	1101-35	1
69-54958-1	1102-23	1
69-54958-1	1102-35	1
69-54958-1	1103-117	1
69-54958-1	1103-35	1
69-54958-2	1101-35	1
69-54958-2	1102-35	1
69-54958-2	1103-35	1
69-59869-1	1101-113	1
69-59869-1	1101-113	2
69-59869-1	1102-113	1
69-59869-1	1102-113	2
69-59869-1	1103-113	1
69-59870-1	1101-118	1
69-59870-1	1102-118	1
69-59870-1	1103-118	1
69-59870-3	1101-120	1
69-59870-3	1102-120	1
69-59870-3	1103-120	1
69-59871-1	1101-121	1
69-59871-1	1102-121	1
69-59871-1	1103-121	1
69-59871-3	1101-123	1
69-59871-3	1102-123	1
69-59871-3	1103-123	1
69-59872-1	1101-117	1
69-59872-1	1102-117	1
69-59872-1	1103-117	1
69-61976-1	1102-108	1
69-61976-1	1102-108	1
69-61976-2	1103-108	1
69-61977-1	1101-108	1
69-61978-1	1101-106	1
69-61978-1	1101-106	1
69-61978-1	1103-106	1
69-61978-2	1101-106	1
69-61978-2	1101-106	1
69-61978-2	1103-106	1
69-61978-3	1103-106	1
69-61979-1	1102-106A	1
69-61979-1	1102-106A	1
69-64197-1	1101-108	1
69-64197-1	1101-108	1

Part No.	Fig. and Index No.	Qty. per Assy.
69-64197-2	1101-108	1
69-66681	1101-125	
69-66681-2	1101-131	
69-66681-2	1102-131	1
69-66681-3	1101-130	
69-66681-4	1101-130	
69-66681-5	1101-135	
69-66681-5	1102-135	1
69-66681-6	1101-135	
69-66681-6	1102-135	1
69-66681-7	1101-134	
69-66681-7	1102-134	2
69-67219-10	1102-110	1
69-67219-11	1102-110	1
69-67219-12	1101-108	
69-67219-12	1102-108	1
69-67219-13	1101-108	
69-67219-13	1102-108	1
69-67219-14	1101-108	
69-67219-14	1102-108	1
69-67219-16	1101-110	1
69-67219-4	1101-110	1
69-67219-4	1103-110	1
69-67219-5	1101-110	1
69-67219-5	1103-110	1
69-67219-6	1101-108	1
69-67219-7	1101-108	1
69-67219-8	1101-108	1
69-67219-9	1102-110	1
70315-5-38	1101-108C	1
70315-5-38	1103-108C	1
77261	1101-11	1
77261	1102-11	1
79955	1101-108D	
79955	1103-108D	

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