

CHAPTER

54

NACELLES



757
ILLUSTRATED TOOL AND EQUIPMENT MANUAL

CHAPTER 54
NACELLES

Subject/Page	Date	Subject/Page	Date	Subject/Page	Date
EFFECTIVE PAGES		54-50-05 (cont)		54-50-12 (cont)	
1	Sep 20/2008	2	Sep 20/2006	10	BLANK
2	BLANK	3	Sep 20/2006	54-50-13	
54-CONTENTS		4	BLANK	1	Sep 20/2006
O 1	Sep 20/2008	54-50-06		2	Sep 20/2006
2	BLANK	1	Sep 20/2006	3	Sep 20/2006
54-00-01		2	Sep 20/2006	4	Sep 20/2006
1	Sep 20/2006	3	Sep 20/2006	54-50-14	
2	BLANK	4	BLANK	1	Sep 20/2006
54-00-02		54-50-07		2	Sep 20/2006
1	Sep 20/2006	1	Sep 20/2006	54-50-15	
2	Sep 20/2006	2	Sep 20/2006	O 1	Sep 20/2008
3	Sep 20/2006	3	Sep 20/2006	2	Sep 20/2007
4	Sep 20/2006	4	BLANK	3	Sep 20/2007
54-00-03		54-50-08		4	BLANK
1	Sep 20/2006	1	Sep 20/2006		
2	BLANK	2	Sep 20/2006		
54-10-01		3	Sep 20/2006		
1	Sep 20/2006	4	BLANK		
2	Sep 20/2006	54-50-09			
54-50-01		1	Sep 20/2006		
1	Sep 20/2006	2	BLANK		
2	Sep 20/2006	54-50-10			
3	Sep 20/2006	1	Sep 20/2006		
4	BLANK	2	BLANK		
54-50-02		54-50-11			
1	Sep 20/2006	1	Sep 20/2006		
2	Sep 20/2006	2	Sep 20/2006		
54-50-03		3	Sep 20/2006		
1	Sep 20/2006	4	BLANK		
2	Sep 20/2006	54-50-12			
3	Sep 20/2006	1	Sep 20/2006		
4	Sep 20/2006	2	Sep 20/2006		
5	Sep 20/2006	3	Sep 20/2006		
6	BLANK	4	Sep 20/2006		
54-50-04		5	Sep 20/2006		
1	Sep 20/2006	6	Sep 20/2006		
2	Sep 20/2006	7	Sep 20/2006		
54-50-05		8	Sep 20/2006		
1	Sep 20/2006	9	Sep 20/2006		

A = Added, R = Revised, O = Overflow, D = Deleted

54-EFFECTIVE PAGES



757

ILLUSTRATED TOOL AND EQUIPMENT MANUAL

TABLE OF CONTENTS

<u>Subject</u>	<u>Title</u>	<u>Part No.</u>
54-	NACELLES	
54-00-02	SLING EQUIPMENT - STRUT, RB211-535 ENGINE	B54002-41, -52
54-00-03	PRELOAD FIXTURE - STRUT, RB211-535 ENGINE STRUT	B54003-8
54-10-01	PULLER EQUIPMENT - FUSE PIN	A54008-1, -13
54-50-01	PRELOAD FIXTURE EQUIPMENT - STRUT, PW2000 SERIES ENGINES	B54004-13
54-50-02	SLING - STRUT, PW2000 ENGINES	B54005-35
54-50-03	ALIGN FIXTURE - NACELLE SIDE LINK	B54006-1, -12
54-50-04	ALIGN FIXTURE - NACELLE DIAGONAL BRACE	B54008-1, -2
54-50-05	DRILL JIG - NACELLE DIAGONAL BRACE, RB211-535	B54010-30
54-50-06	DRILL JIG - NACELLE DIAGONAL BRACE, PW2000	B54011-1
54-50-07	DRILL JIG - NACELLE SIDE LINK	B54007-1
54-50-08	JIG EQUIPMENT - SIDE LINK, STRUT	B54012-1
54-50-09	GREASE REMOVER - MIDSPAR FUSE PIN	B54014-1
54-50-10	TORQUE WRENCH - MIDSPAR FUSE PIN IMMOBILIZER	B54015-1
54-50-11	SLING EQUIPMENT - FUSE PIN, REMOVAL/INSTALLATION - RB211-535 ENGINE	B54017-22
54-50-12	REMOVAL/INSTALLATION KIT - FUSE PIN	B54018-29, -42, -44, -45
54-50-13	ADAPTER EQUIPMENT - STRUT UNLOAD, FORWARD ENGINE MOUNT	B54019-23, -24, -40, -41
54-50-14	SLING - RB211-535 ENGINE	B54009-19
54-50-15	SLING EQUIPMENT - DIAGONAL BRACE UNLOAD, PW2000 SERIES ENGINE	B54013-38, -48

54-CONTENTS



757

ILLUSTRATED TOOL AND EQUIPMENT MANUAL

PART NUMBER: B54001-30 WAS MOVED TO 78-30-33



757

ILLUSTRATED TOOL AND EQUIPMENT MANUAL

PART NUMBER: B54002-41, -52

NAME: SLING EQUIPMENT - STRUT, RB211-535 ENGINE

AIRPLANE MAINTENANCE: YES

COMPONENT MAINTENANCE: NO

USAGE & DESCRIPTION: The B54002-52 sling equipment is used on 757 airplanes equipped with RB211-535C or E4 engines. The B54002-41 sling equipment must be reworked into the B54002-52 configuration before it is used on 757 airplanes equipped with RB211-535C or E4 engines. B54002-52 is used to remove or install the RB211-535C or E4 strut. Refer to the current B54002 drawing and AMM 54-51-01 for complete usage instructions. B54002-52 consists of:

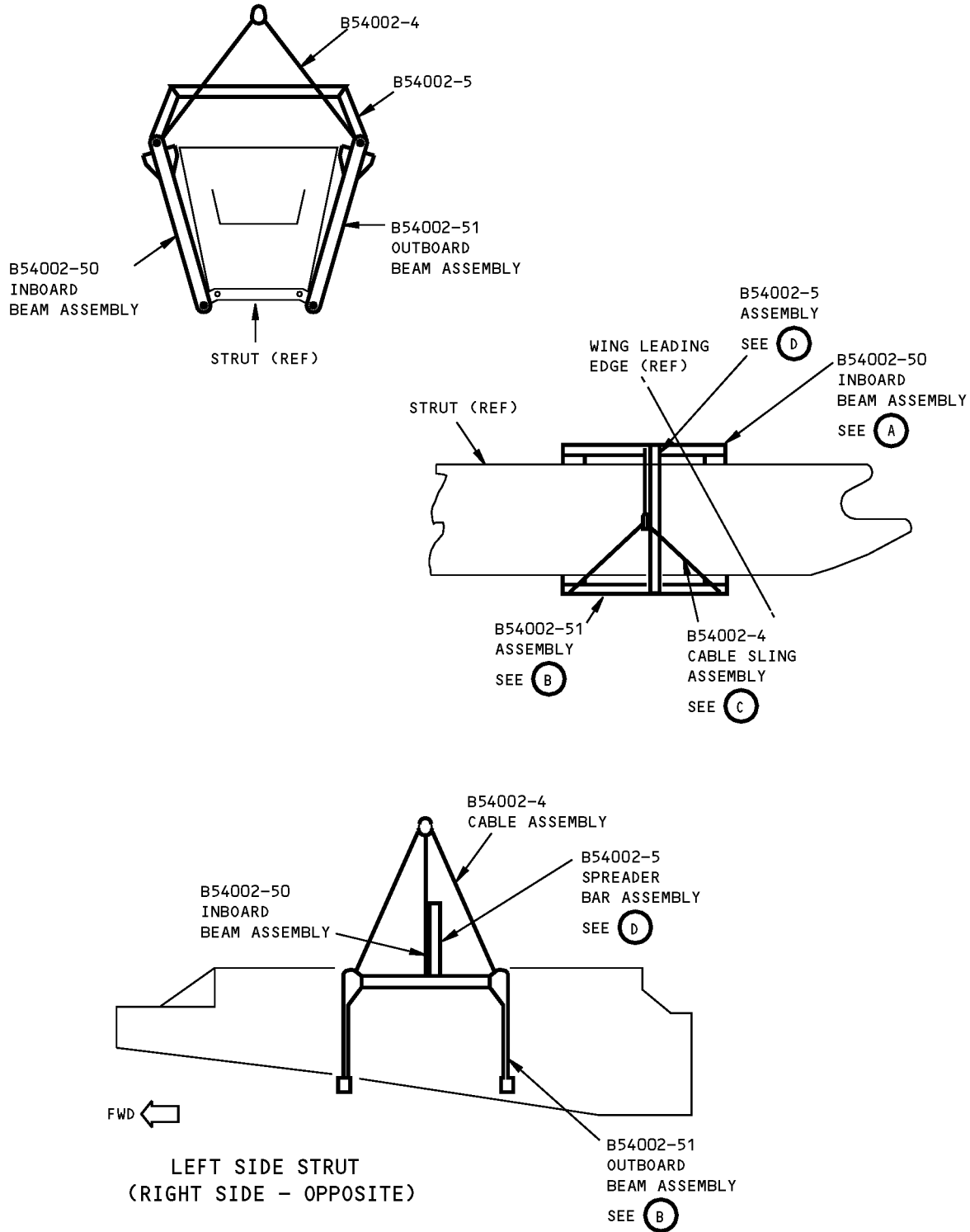
B54002-52		
QUANTITY	NOMENCLATURE	PART NUMBER
1	INBOARD BEAM ASSEMBLY	B54002-50
1	OUTBOARD BEAM ASSEMBLY	B54002-51
1	CABLE SLING ASSEMBLY	B54002-4
1	SPREADER ASSEMBLY	B54002-5
1	STORAGE BOX	

WEIGHT: 100 lbs (45 kg)

DIMENSIONS: 12 x 20 x 40 inches (305 x 508 x 1016 mm)

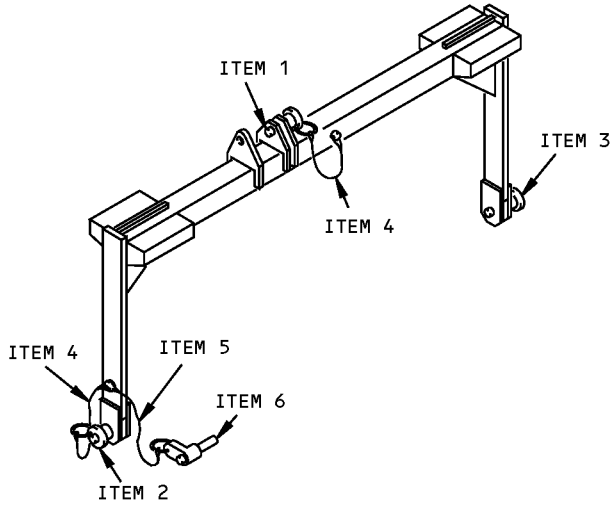
NOTE: B54002-52 replaces B54002-41 for future procurement.
B54002-41 supersedes B54002-1.

ILLUSTRATED TOOL AND EQUIPMENT MANUAL



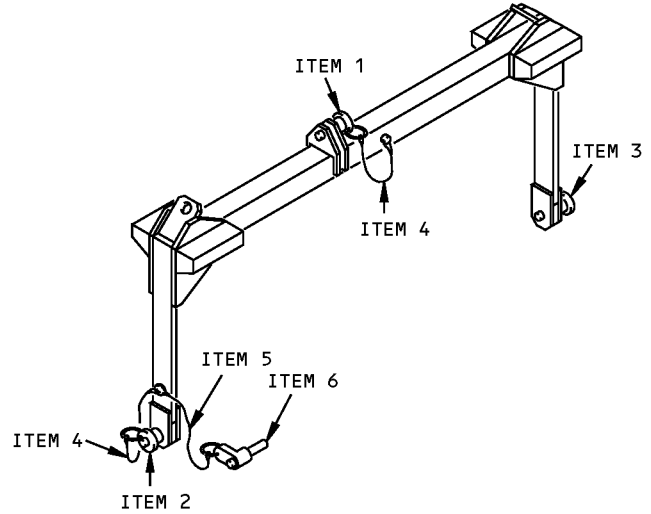
**RB211-535 Engine Strut Sling Equipment
Figure 1 (Sheet 1 of 2)**

ILLUSTRATED TOOL AND EQUIPMENT MANUAL



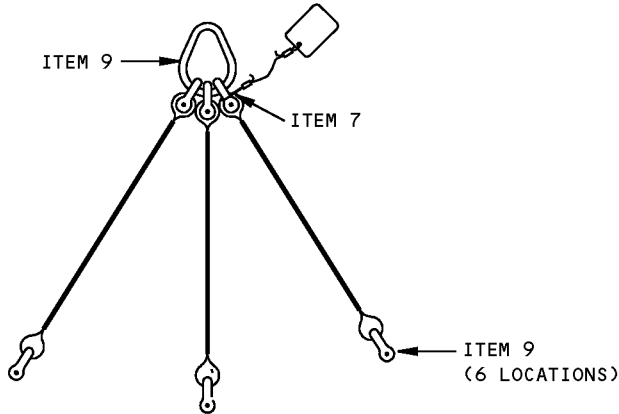
**B54002-50
INBOARD BEAM ASSEMBLY**

(A)



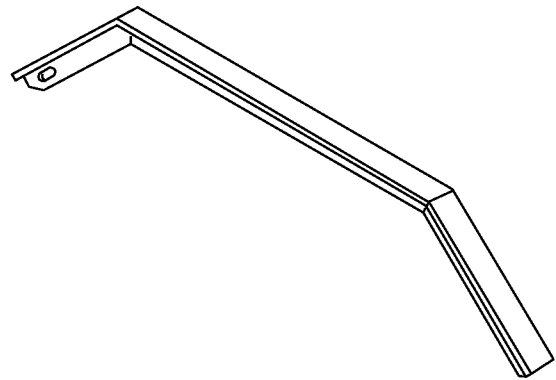
**B54002-51
OUTBOARD BEAM ASSEMBLY**

(B)



**B54002-4
CABLE SLING ASSEMBLY**

(C)



**B54002-5
SPREADER BAR ASSEMBLY**

(D)

**RB211-535 Engine Strut Sling Equipment
Figure 1 (Sheet 2 of 2)**



757

ILLUSTRATED TOOL AND EQUIPMENT MANUAL

REPAIRABLE/REPLACEABLE PARTS			
ITEM NO.	PART NO.	NOMENCLATURE	VENDOR CODE
1	NAS1355C3C10D	BALL LOCK PIN	
2	NAS1357C3C20D	BALL LOCK PIN	
3	NAS1360C3C20D	BALL LOCK PIN	
4	CL-63-KA-6.0	LANYARD	V99862
5	CL-63-KA-12.0	LANYARD	V99862
6	NAS1339C5C21D	BALL LOCK PIN	
7	CL-23-KA-10.0LR	LANYARD	V99862
8	G-209-7/16	SHACKLE	V75535
9	G-341-3/4	SLING LINK	V75535

ILLUSTRATED TOOL AND EQUIPMENT MANUAL

PART NUMBER: B54003-8

NAME: PRELOAD FIXTURE - STRUT, RB211-535 ENGINE STRUT

AIRPLANE MAINTENANCE: YES

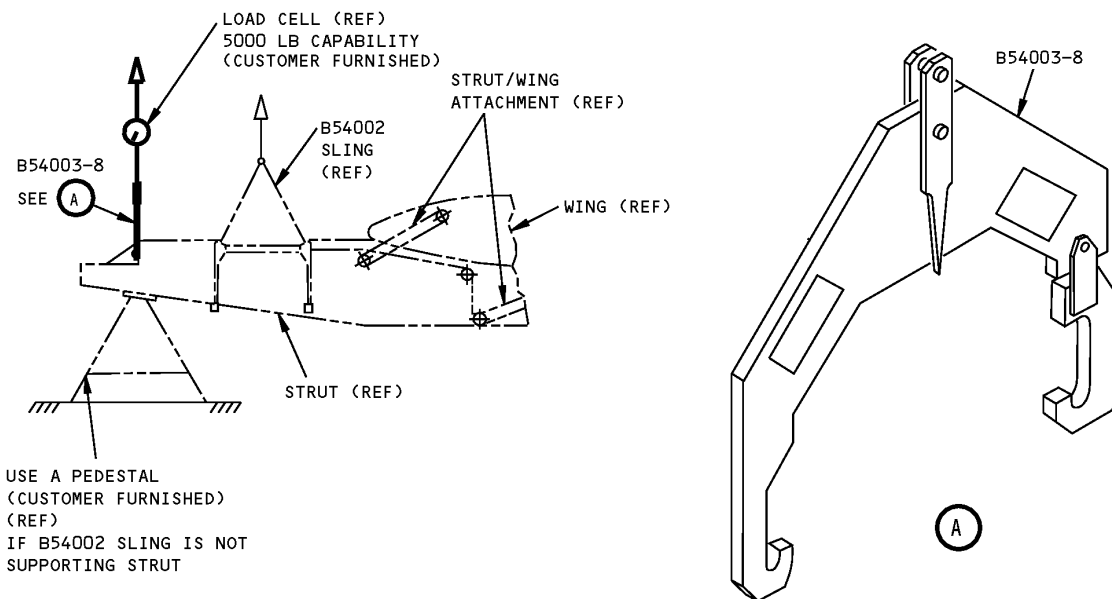
COMPONENT MAINTENANCE: NO

USAGE & DESCRIPTION: The B54003-8 preload fixture is used on 757 airplanes equipped with RB211-535 engines. B54003 is used for hole alignment and preload balancing of the strut/wing attaching bolts. B54003 is used in conjunction with a customer-furnished load cell, overhead lifting equipment and either a customer-furnished tripod jack or a B54002 strut sling. Refer to AMM 54-51-01 and AMM 54-51-02 for complete usage instructions. The B54003-8 preload fixture is a welded lift fixture.

WEIGHT: 25 lbs (11 kg)

DIMENSIONS: 2 x 22 x 24 inches (51 x 559 x 610 mm)

NOTE: B54003-8 supersedes B54003-6.



**RB211-535 Engine Strut Preload Fixture
Figure 1**



757

ILLUSTRATED TOOL AND EQUIPMENT MANUAL

PART NUMBER: A54008-1, -13

NAME: PULLER EQUIPMENT - FUSE PIN

AIRPLANE MAINTENANCE: YES

COMPONENT MAINTENANCE: NO

USAGE & DESCRIPTION: The A54008-1 or -13 puller equipment is used on all 757 airplanes. A54008 is used to remove strut attachment fuse pins at the midspar fittings. Refer to AMM 54-51-01 and AMM 54-51-02 for complete usage instructions for RB211-535 engines. Refer to AMM 54-51-02 for complete usage instructions for PW2000 engines. A54008-1 and -13 consists of:

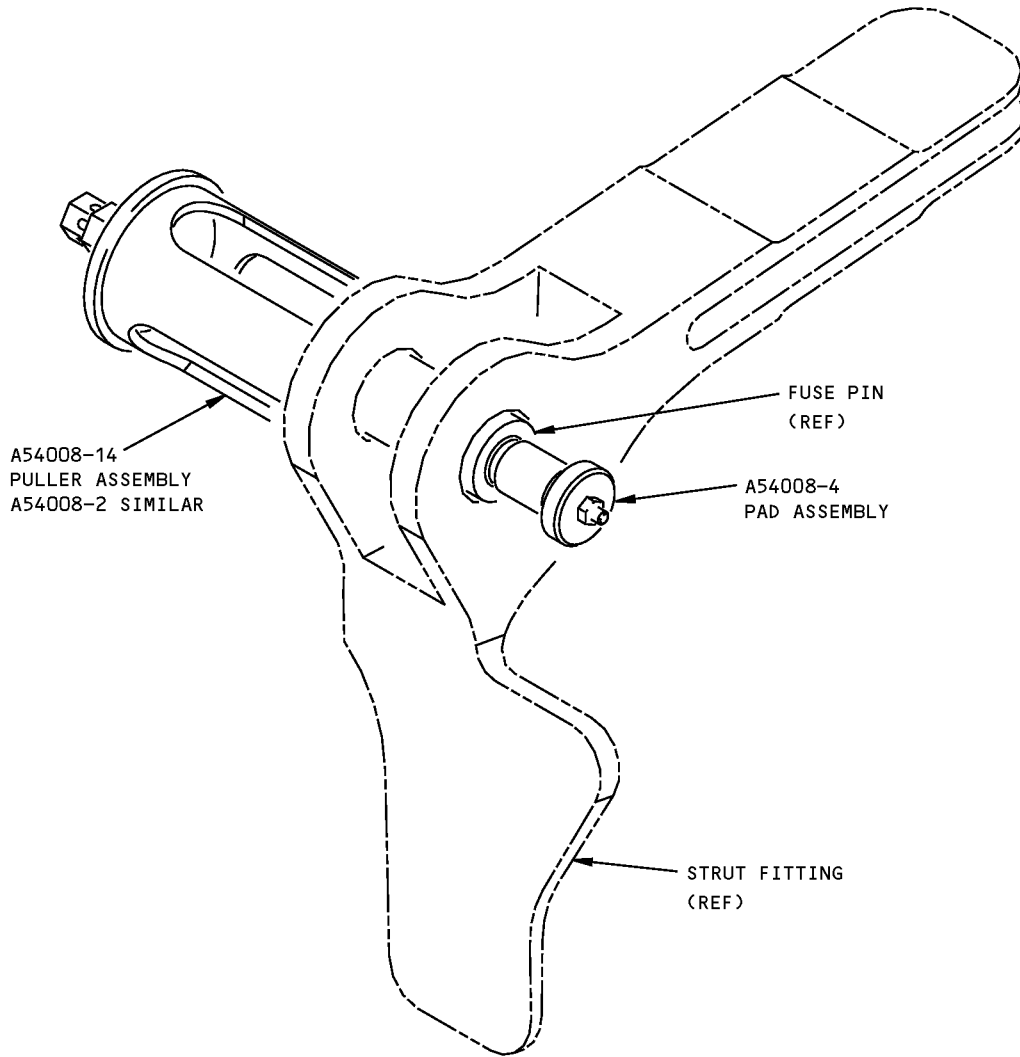
A54008-1		
QUANTITY	NOMENCLATURE	PART NUMBER
1	PULLER ASSEMBLY	A54008-2
1	PAD ASSEMBLY	A54008-4
1	STORAGE BOX	

A54008-13		
QUANTITY	NOMENCLATURE	PART NUMBER
1	PULLER ASSEMBLY	A54008-14
1	PAD ASSEMBLY	A54008-4
1	STORAGE BOX	

WEIGHT: 3 lbs (1.4 kg)

DIMENSIONS: 4 x 4 x 14 inches (102 x 102 x 356 mm)

NOTE: B54018 replaces A54008 for future procurement.
A54008-13 replaces A54008-1 for future procurement.



**Fuse Pin Puller Equipment
Figure 1**



757

ILLUSTRATED TOOL AND EQUIPMENT MANUAL

PART NUMBER: B54004-13

NAME: PRELOAD FIXTURE EQUIPMENT - STRUT, PW2000 SERIES ENGINES

AIRPLANE MAINTENANCE: YES

COMPONENT MAINTENANCE: NO

USAGE & DESCRIPTION: The B54005-13 preload fixture equipment is used on 757 airplanes equipped with PW2000 series engines. B54005 is used in conjunction with the B54005 strut sling to align the upper link holes for fuse pin installation or removal of the engine strut to the wing. Refer to AMM 54-51-01 and AMM 54-51-02 for complete usage instructions. B54005-13 consists of:

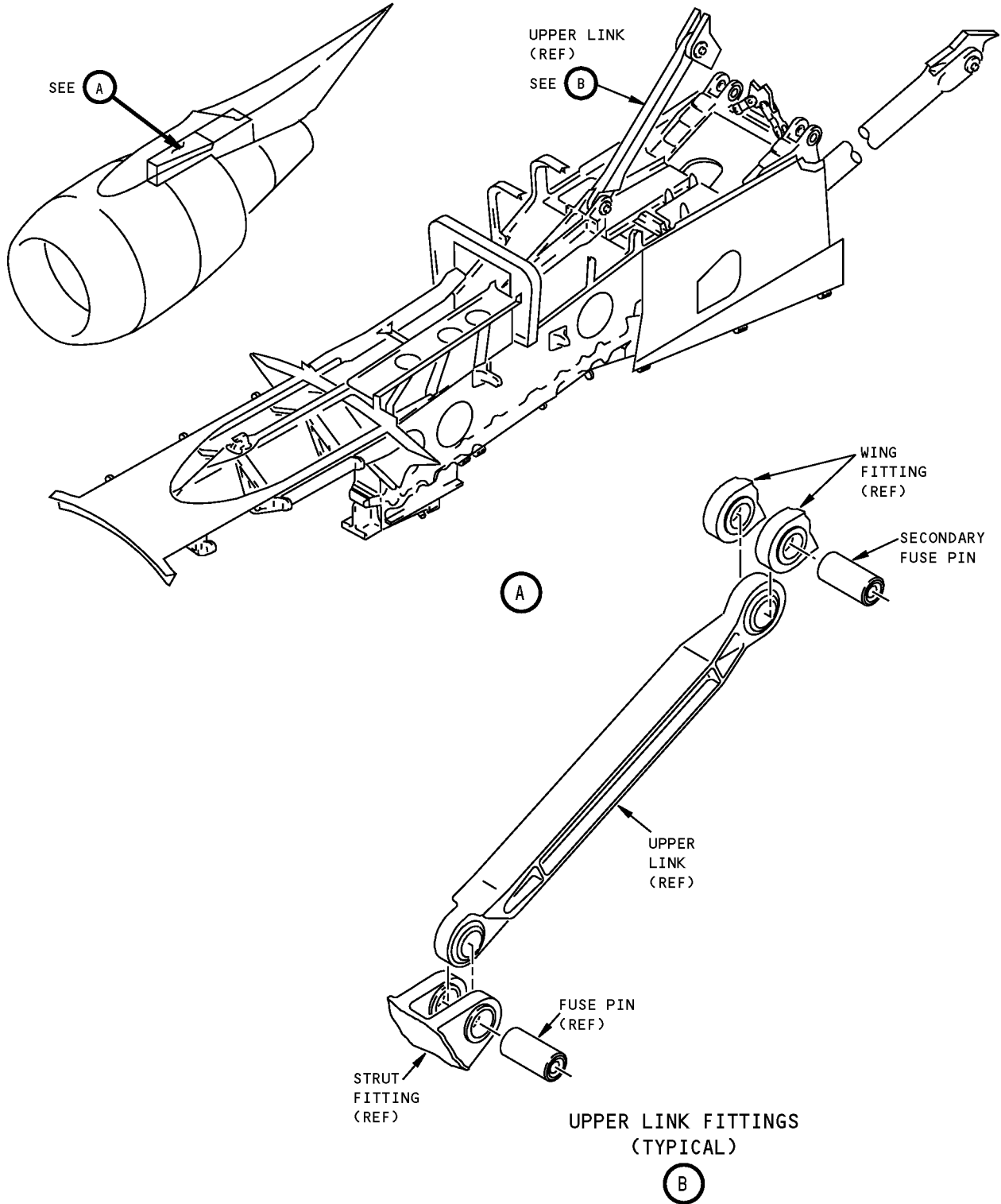
B54005-13		
QUANTITY	NOMENCLATURE	PART NUMBER
1	INDICATOR ASSEMBLY	B54005-4
1	PRELOAD FIXTURE ASSEMBLY	B54005-14
VARIOUS	CONNECTING HARDWARE	
1	STORAGE BOX	

WEIGHT: 135 lbs (61 kg)

DIMENSIONS: 4 x 45 x 61 inches (102 x 1143 x 1549 mm)

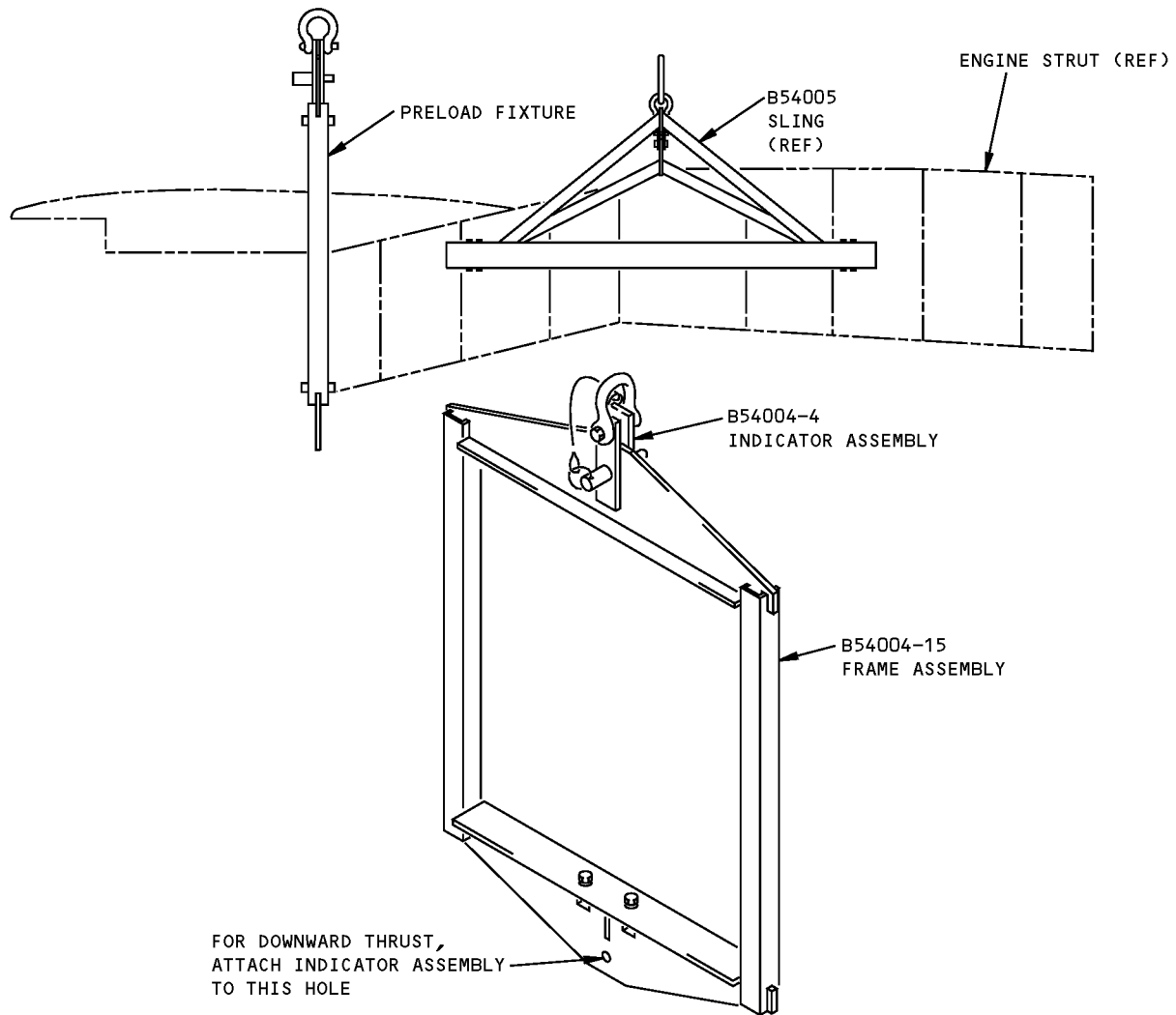
NOTE: B54004-13 supersedes B54004-1.

ILLUSTRATED TOOL AND EQUIPMENT MANUAL



**PW2000 Series Engines Strut Preload Fixture Equipment
Figure 1 (Sheet 1 of 2)**

ILLUSTRATED TOOL AND EQUIPMENT MANUAL



**PW2000 Series Engines Strut Preload Fixture Equipment
Figure 1 (Sheet 2 of 2)**



757

ILLUSTRATED TOOL AND EQUIPMENT MANUAL

PART NUMBER: B54005-35

NAME: SLING - STRUT, PW2000 ENGINES

AIRPLANE MAINTENANCE: YES

COMPONENT MAINTENANCE: NO

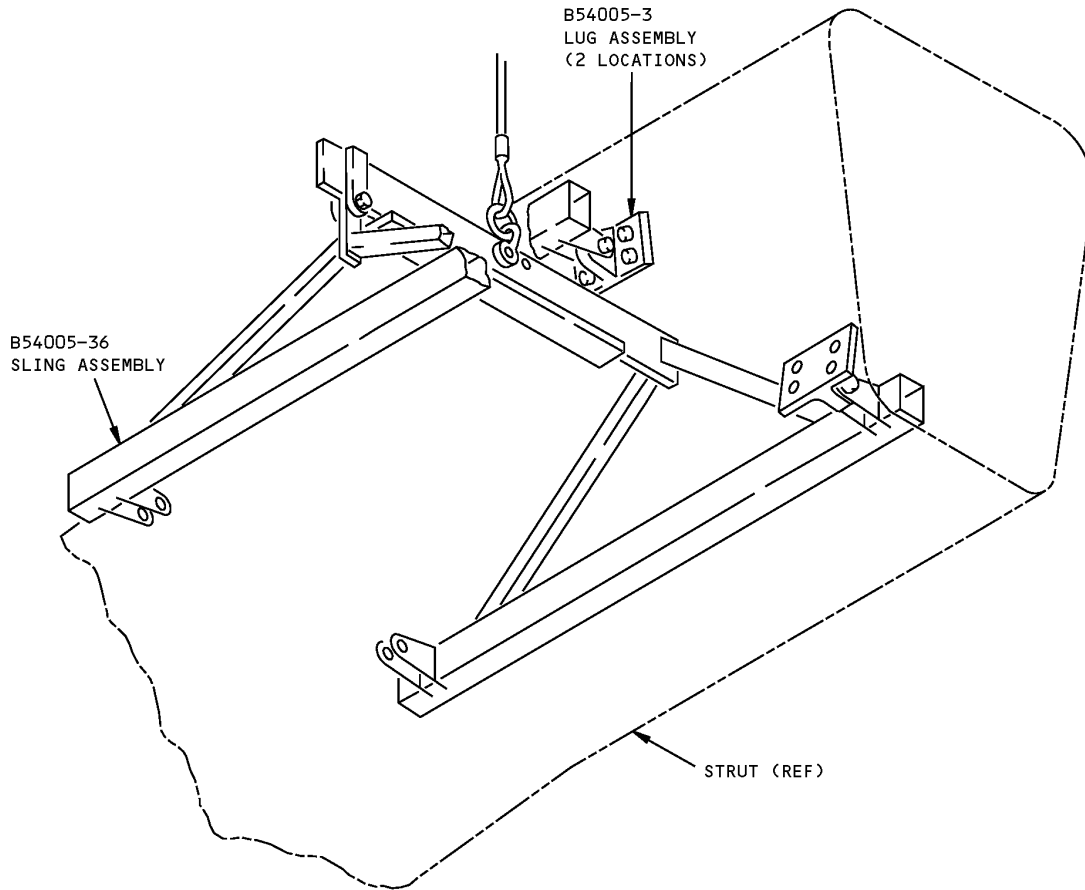
USAGE & DESCRIPTION: The B54005-35 sling is used on 757 airplanes equipped with PW2000 series engines. B54005 is used during strut installation in conjunction with a customer-furnished overhead lift, a B54004 strut preload fixture and a B54018 fuse pin removal and installation kit, to remove or install the PW2000 engine strut. Refer to AMM 54-51-01 for complete usage instructions. B54005-35 consists of a B54005-36 sling assembly, two B54005-3 lug assemblies, both contained in a storage box.

WEIGHT: 125 lbs (57 kg)

DIMENSIONS: 28 x 37 x 53 inches (711 x 940 x 1346 mm)

NOTE: B54005-35 supersedes B54005-20.

757
ILLUSTRATED TOOL AND EQUIPMENT MANUAL



PW2000 Engines Strut Sling
Figure 1



757

ILLUSTRATED TOOL AND EQUIPMENT MANUAL

PART NUMBER: B54006-1, -12

NAME: ALIGN FIXTURE - NACELLE SIDE LINK

AIRPLANE MAINTENANCE: YES

COMPONENT MAINTENANCE: NO

USAGE & DESCRIPTION: The B54006-1 align fixture is used on 757-200 airplanes equipped with RB211-535 or PW2000 engine before line number 736 that have not incorporated Service Bulletins SB 757-54-0034 or SB 757-54-0035.

The B54006-12 align fixture is used on 757 airplanes equipped with RB211-535 or PW2000 engine.

The B54006 align fixture is used to determine the location of the engine nacelle side brace link assembly bushings. The location is transferred from the align fixture to the link. The link may be drilled and bushed using a customer-furnished B54007 drill jig or other boring fixture. Refer to the current B54006 drawing for complete usage instructions. The B54006-1 and -12 consists of:

B54006-1		
QUANTITY	NOMENCLATURE	PART NUMBER
1	FIXTURE ASSEMBLY	B54006-2
1	PIN	B54006-8
1	PIN	B54006-9
1	STORAGE BOX	

B54006-1 2		
QUANTITY	NOMENCLATURE	PART NUMBER
1	FIXTURE ASSEMBLY	B54006-13
1	DRILL HANDLE ASSEMBLY	B54006-14
1	CAP ASSEMBLY	B54006-15
1	SOCKET HEAD CAP SCREW	B54006-16
1	STORAGE BOX	

WEIGHT: B56006-1 - 5 lbs (2.3 kg)
B56006-12 - 6 lbs (2.7 kg)

DIMENSIONS: B56006-1 - 4 x 9 x 12 inches (102 x 229 x 305 mm)
B56006-12 - 3 x 7 x 8 inches (76 x 178 x 203 mm)



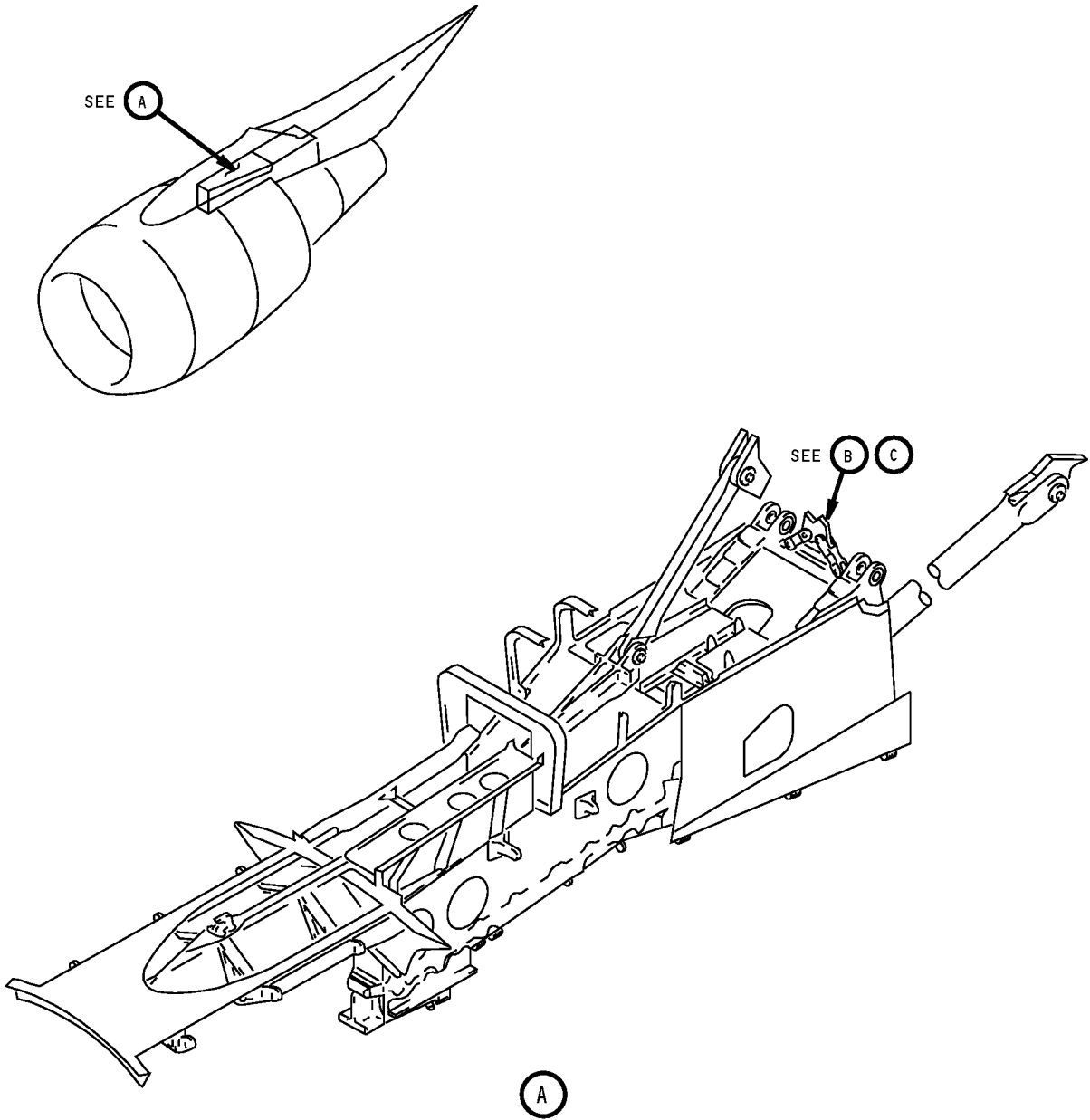
757

ILLUSTRATED TOOL AND EQUIPMENT MANUAL

NOTE:

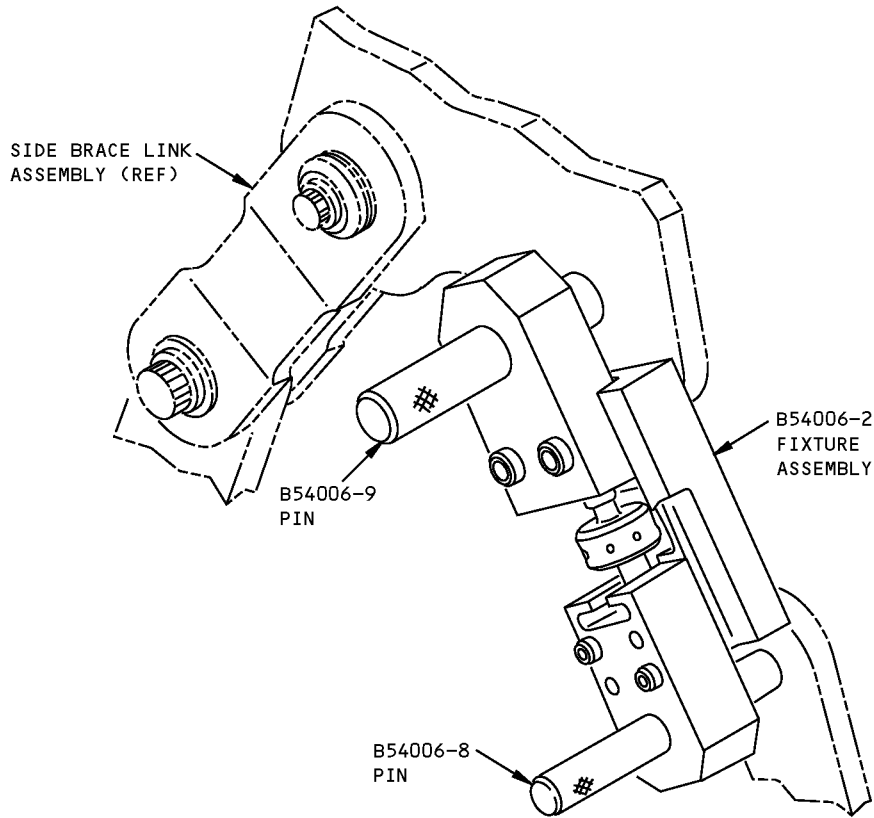
B54006-12 replaces B54006-1 for future procurement.

757
ILLUSTRATED TOOL AND EQUIPMENT MANUAL



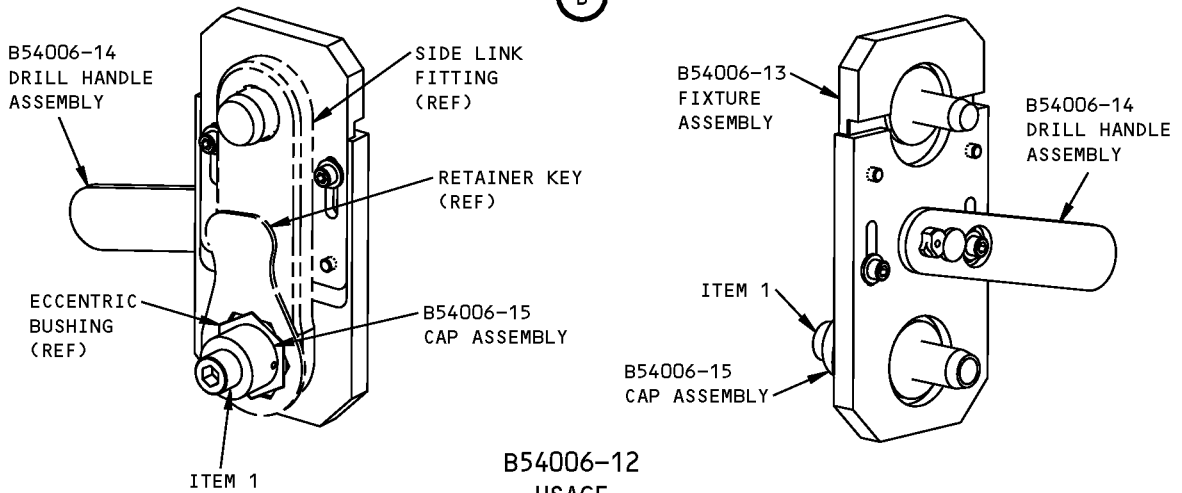
Nacelle Side Link Align Fixture
Figure 1 (Sheet 1 of 2)

757
ILLUSTRATED TOOL AND EQUIPMENT MANUAL



B54006-1
USAGE

(B)



B54006-12
USAGE

(C)

Nacelle Side Link Align Fixture
Figure 1 (Sheet 2 of 2)



757

ILLUSTRATED TOOL AND EQUIPMENT MANUAL

REPAIRABLE/REPLACEABLE PARTS			
ITEM NO.	PART NO.	NOMENCLATURE	VENDOR CODE
1	B54006-16	SOCKET HEAD CAP SCREW	



757

ILLUSTRATED TOOL AND EQUIPMENT MANUAL

PART NUMBER: B54008-1, -2

NAME: ALIGN FIXTURE - NACELLE DIAGONAL BRACE

AIRPLANE MAINTENANCE: YES

COMPONENT MAINTENANCE: NO

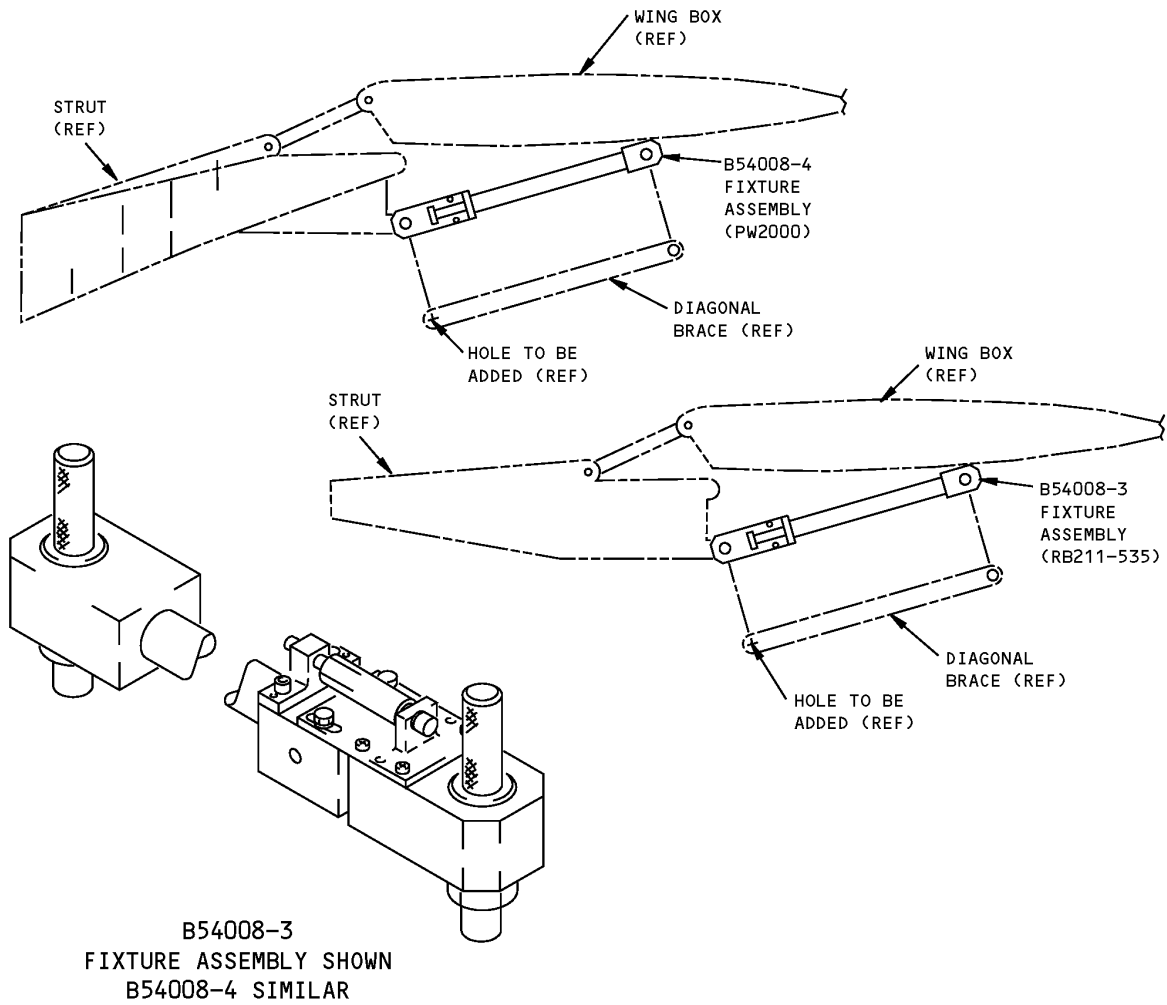
USAGE & DESCRIPTION: The B54008-1 align fixture is used on 757 airplanes equipped with RB211-535 engines prior to line number 736 and not incorporating Service Bulletin SB 757-54-0035. The B54008-2 align fixture is used on 757 airplanes equipped with PW2000 engines prior to line number 736 and not incorporating Service Bulletin SB 757-54-0034.

B54008 is used during strut installation to determine the location of the diagonal brace assembly bushings. The location is transferred from the B54008 to the B54011 drill jig. The B54011 drill jig is adjusted to the determined hole location by the B54008 and supports the diagonal brace for drilling. Refer to AMM 54-51-01 for complete usage instructions. B54008-1 consists of a B54008-3 fixture assembly contained in a storage box. B54008-2 consists of a B54008-4 fixture assembly contained in a storage box.

WEIGHT: 27 lbs (12 kg)

DIMENSIONS: 6 x 12 x 52 inches (152 x 305 x 1321 mm)

ILLUSTRATED TOOL AND EQUIPMENT MANUAL



**Nacelle Diagonal Brace Align Fixture
Figure 1**



757

ILLUSTRATED TOOL AND EQUIPMENT MANUAL

PART NUMBER: B54010-30

NAME: DRILL JIG - NACELLE DIAGONAL BRACE, RB211-535

AIRPLANE MAINTENANCE: YES

COMPONENT MAINTENANCE: NO

USAGE & DESCRIPTION: The B54010-30 drill jig is used on 757-200 airplanes equipped with RB211-535 engines, built prior to line number 736 and not incorporating Service Bulletin SB 757-54-0035. B54010 is used during strut installation to support the diagonal brace assembly for drilling. B54010 is used in conjunction with a B54008-1 align fixture and can be adjusted to the exact length determined by the B54008-1 align fixture. A customer supplied-furnished automatic feed drill motor is used for drilling holes in the diagonal brace. Refer to AMM 54-51-01 for complete usage instructions. B54010-30 consists of:

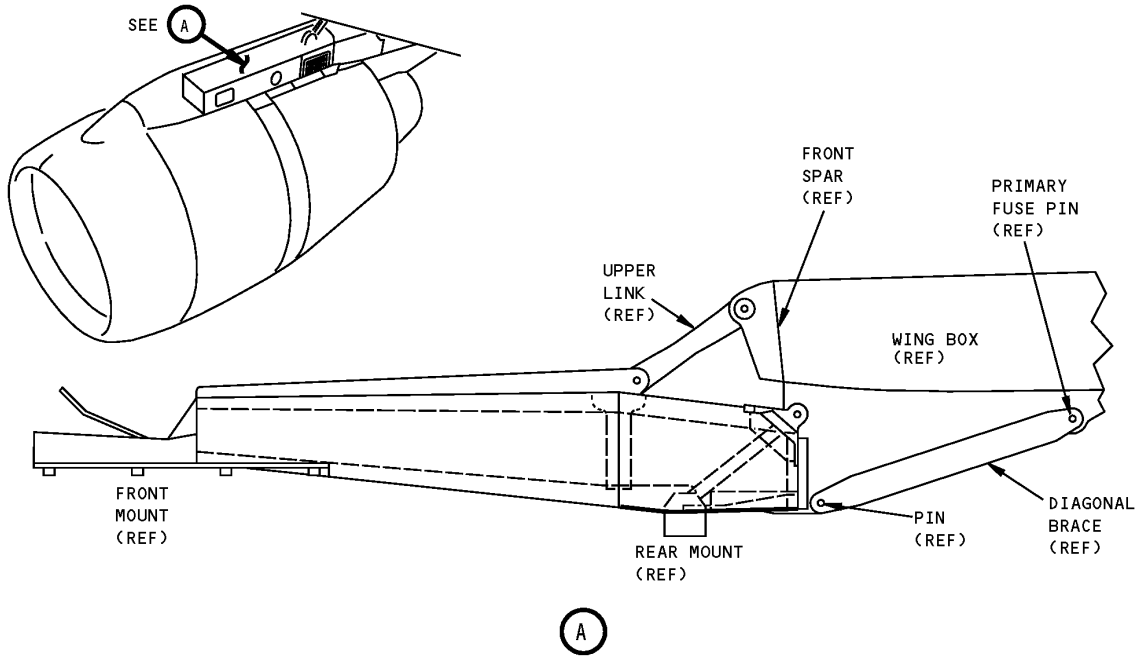
B54010-30		
QUANTITY	NOMENCLATURE	PART NUMBER
1	JIG ASSEMBLY	B54010-2
1	PIN	B54010-31
1	PIN	B54010-34
1	STORAGE BOX	

WEIGHT: 140 lbs (64 kg)

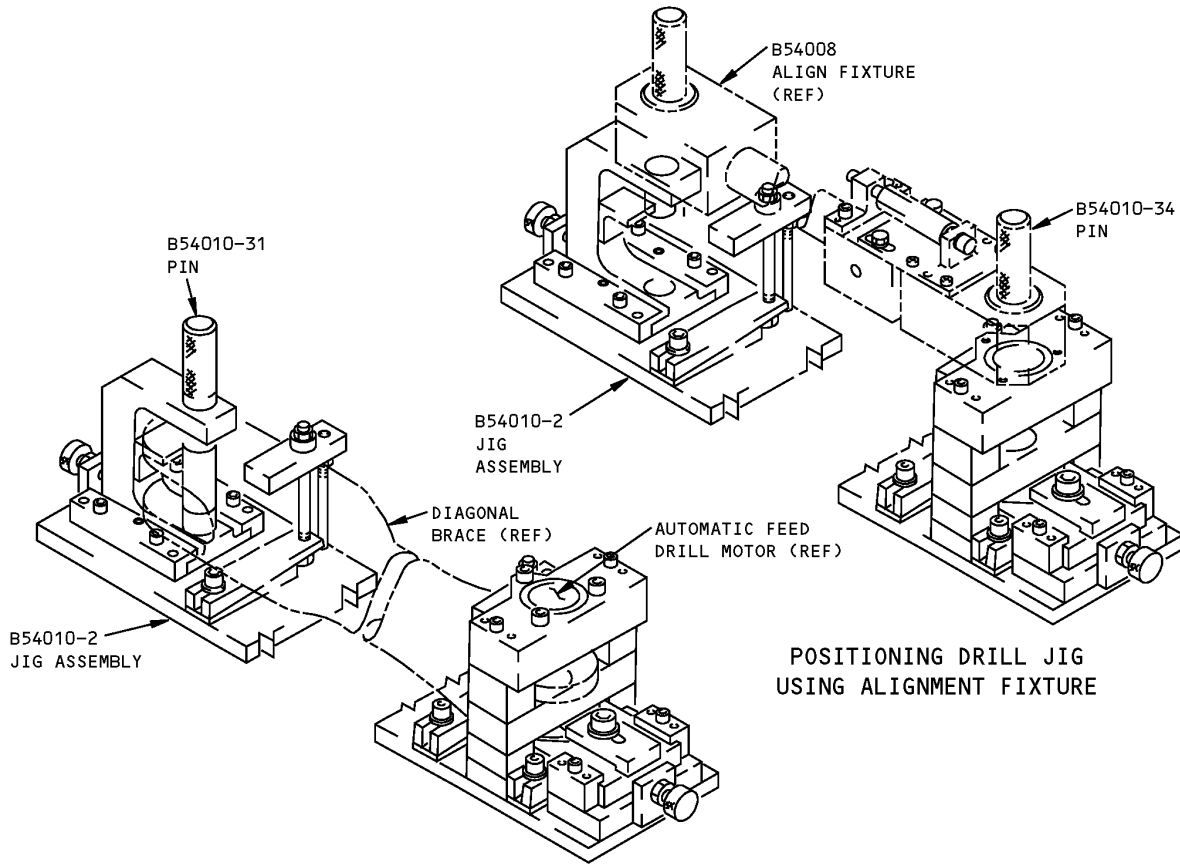
DIMENSIONS: 12 x 12 x 60 inches (305 x 305 x 1524 mm)

NOTE: B54010-30 supersedes B54010-1.

757
ILLUSTRATED TOOL AND EQUIPMENT MANUAL



RB211-535 Nacelle Diagonal Brace Drill Jig
Figure 1 (Sheet 1 of 2)



DIAGONAL BRACE ASSEMBLY IN DRILL JIG
DRILLED AND BUSHED

RB211-535 Nacelle Diagonal Brace Drill Jig
Figure 1 (Sheet 2 of 2)



757

ILLUSTRATED TOOL AND EQUIPMENT MANUAL

PART NUMBER: B54011-1

NAME: DRILL JIG - NACELLE DIAGONAL BRACE, PW2000

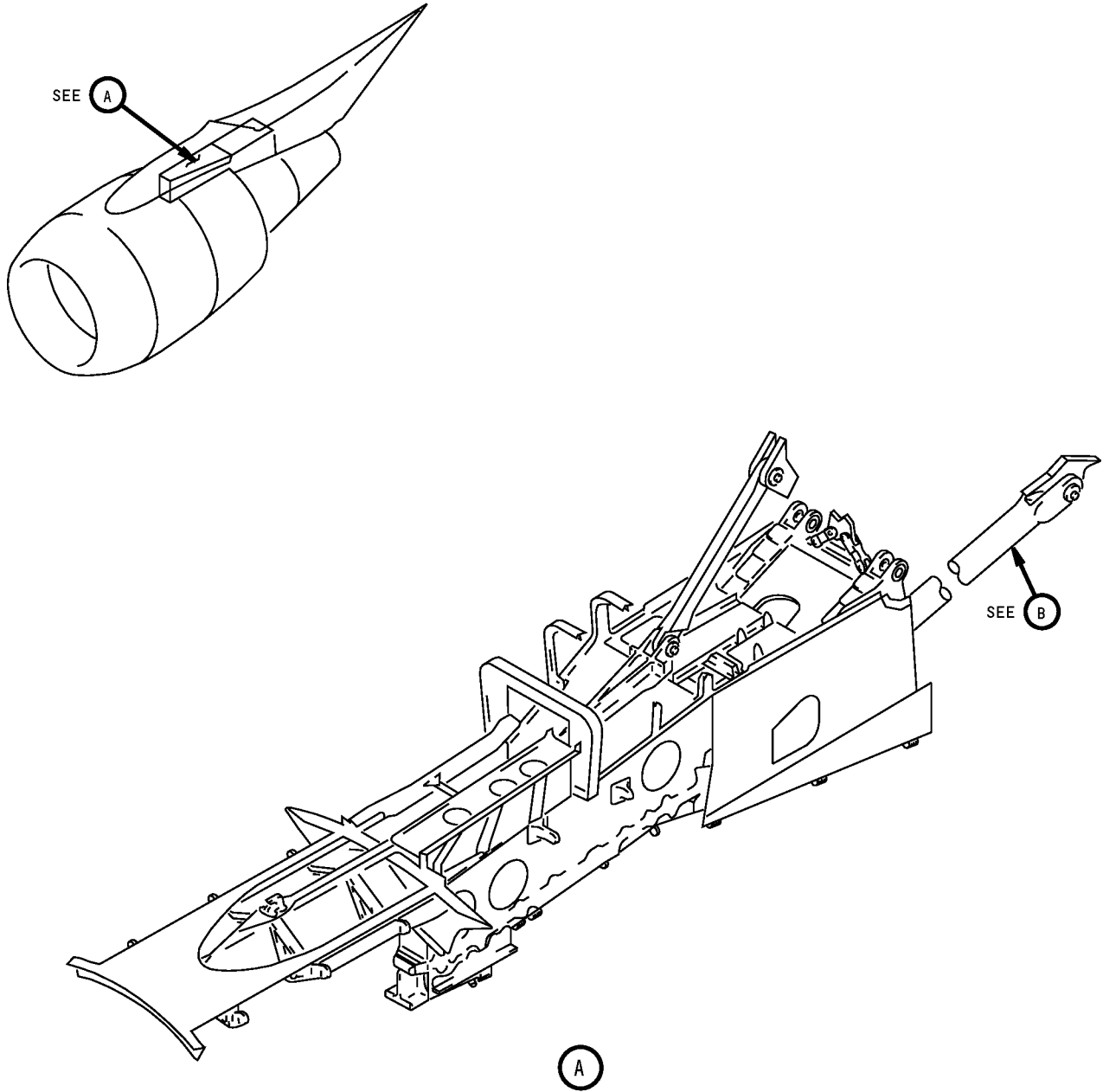
AIRPLANE MAINTENANCE: YES

COMPONENT MAINTENANCE: NO

USAGE & DESCRIPTION: The B54011-1 drill jig is used on 757-200 airplanes equipped with PW2000 engines built prior to line number 736, that do not incorporate Service Bulletin SB 757-54-0034. B54011 is used during strut installation to support the diagonal brace assembly for drilling. B54011 is used in conjunction with a B54008-2 align fixture and can be adjusted to the exact length determined by the align fixture. A customer-furnished automatic feed drill motor is used to drill holes in the diagonal brace. Refer to AMM 54-51-01 for complete usage instructions. B54011-1 consists of a B54011-2 jig assembly and a B54011-4 pin, both contained in a storage box.

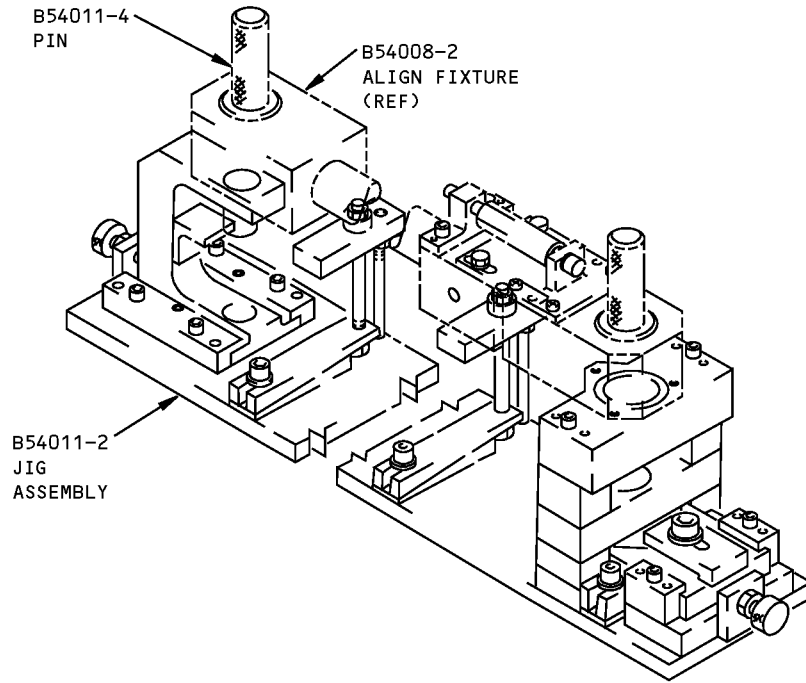
WEIGHT: 140 lbs (64 kg)

DIMENSIONS: 60 x 12 x 12 inches (305 x 305 x 1524 mm)

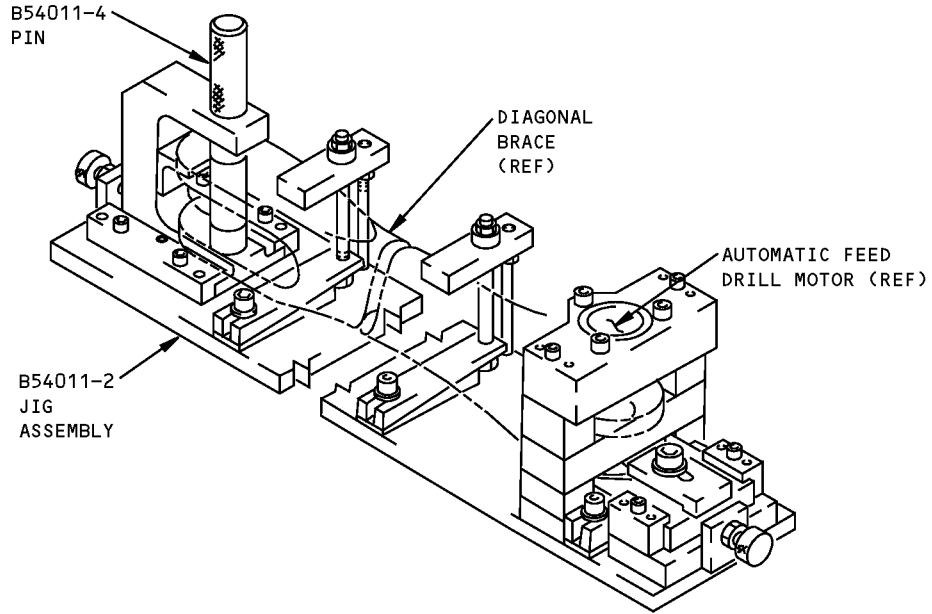


**PW2000 Nacelle Diagonal Brace Drill Jig
Figure 1 (Sheet 1 of 2)**

ILLUSTRATED TOOL AND EQUIPMENT MANUAL



**POSITIONING DRILL JIG
USING ALIGNMENT FIXTURE**



**DIAGONAL BRACE ASSEMBLY IN DRILL JIG
DRILLED AND BUSHED**

**PW2000 Nacelle Diagonal Brace Drill Jig
Figure 1 (Sheet 2 of 2)**



757

ILLUSTRATED TOOL AND EQUIPMENT MANUAL

PART NUMBER: B54007-1

NAME: DRILL JIG - NACELLE SIDE LINK

AIRPLANE MAINTENANCE: YES

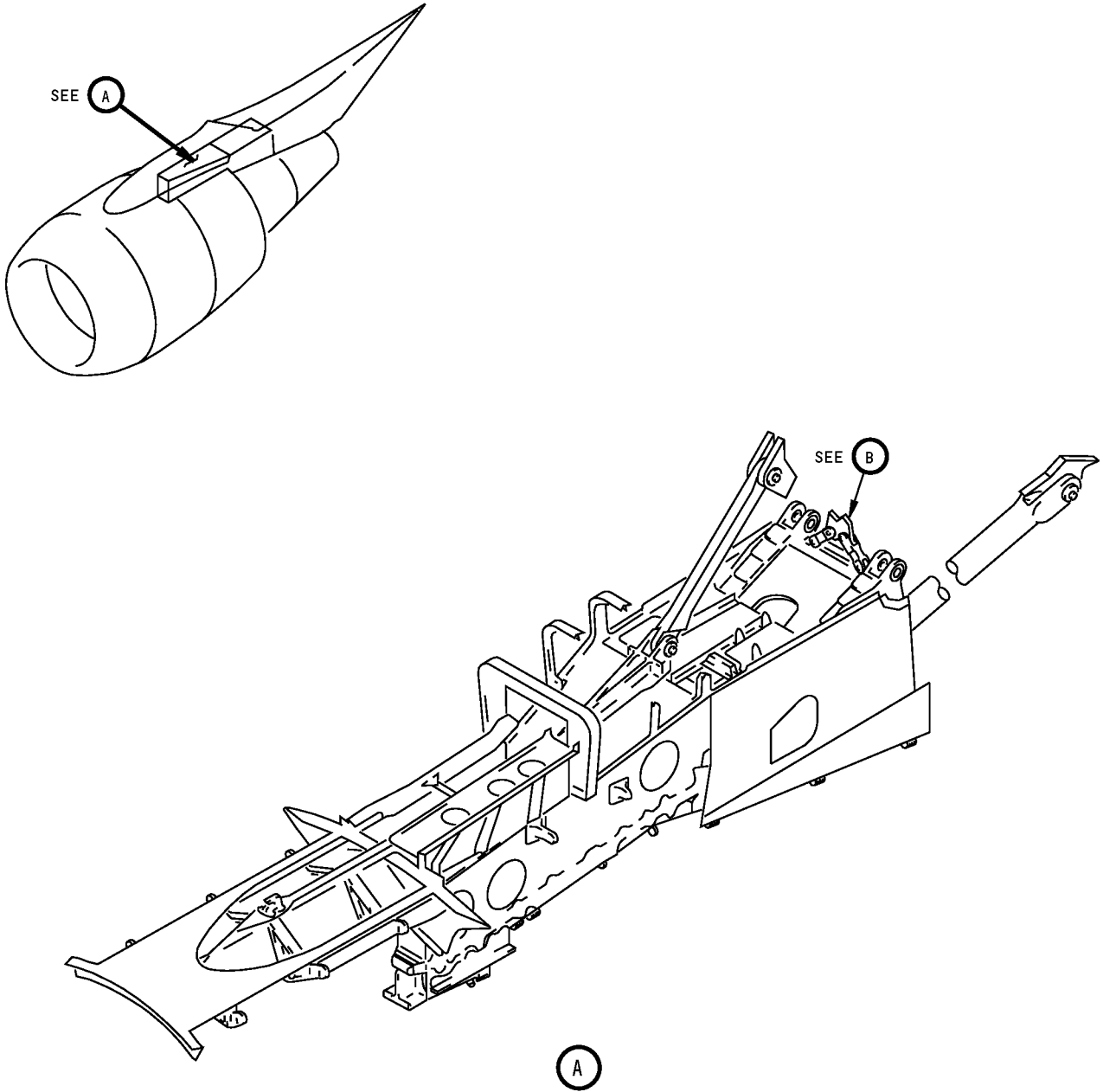
COMPONENT MAINTENANCE: NO

USAGE & DESCRIPTION: The B54007-1 drill jig is used on 757-200 airplanes built before line number 736 that have not incorporated Service Bulletins SB 757-54-0034 (PW2000 engines) or SB 757-54-0035 (RB211-535 engines). B54007 is used during strut installation to support the nacelle side link assembly for drilling. B54007 is used in conjunction with the B54006 align fixture for drilling. Refer to AMM 54-51-01 for complete usage instructions. B54007-1 consists of:

B54007-1		
QUANTITY	NOMENCLATURE	PART NUMBER
1	JIG ASSEMBLY	B54007-2
1	PIN	B54007-27
1	PIN	B54007-28
1	PIN	B54007-29
1	STORAGE BOX	

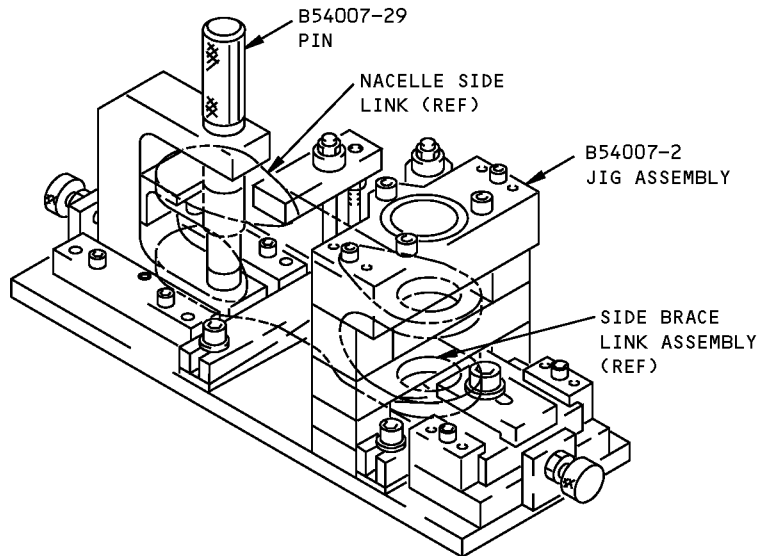
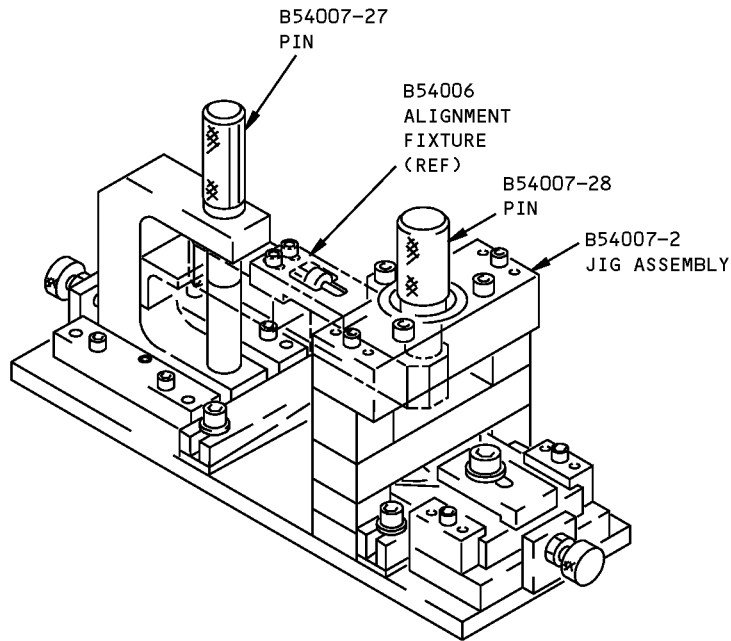
WEIGHT: 75 lbs (34 kg)

DIMENSIONS: 8 x 10 x 22 inches (203 x 254 x 559 mm)



**Nacelle Side Link Drill Jig
Figure 1 (Sheet 1 of 2)**

757
ILLUSTRATED TOOL AND EQUIPMENT MANUAL



(B)

Nacelle Side Link Drill Jig
Figure 1 (Sheet 2 of 2)



757

ILLUSTRATED TOOL AND EQUIPMENT MANUAL

PART NUMBER: B54012-1

NAME: JIG EQUIPMENT - SIDE LINK, STRUT

AIRPLANE MAINTENANCE: YES

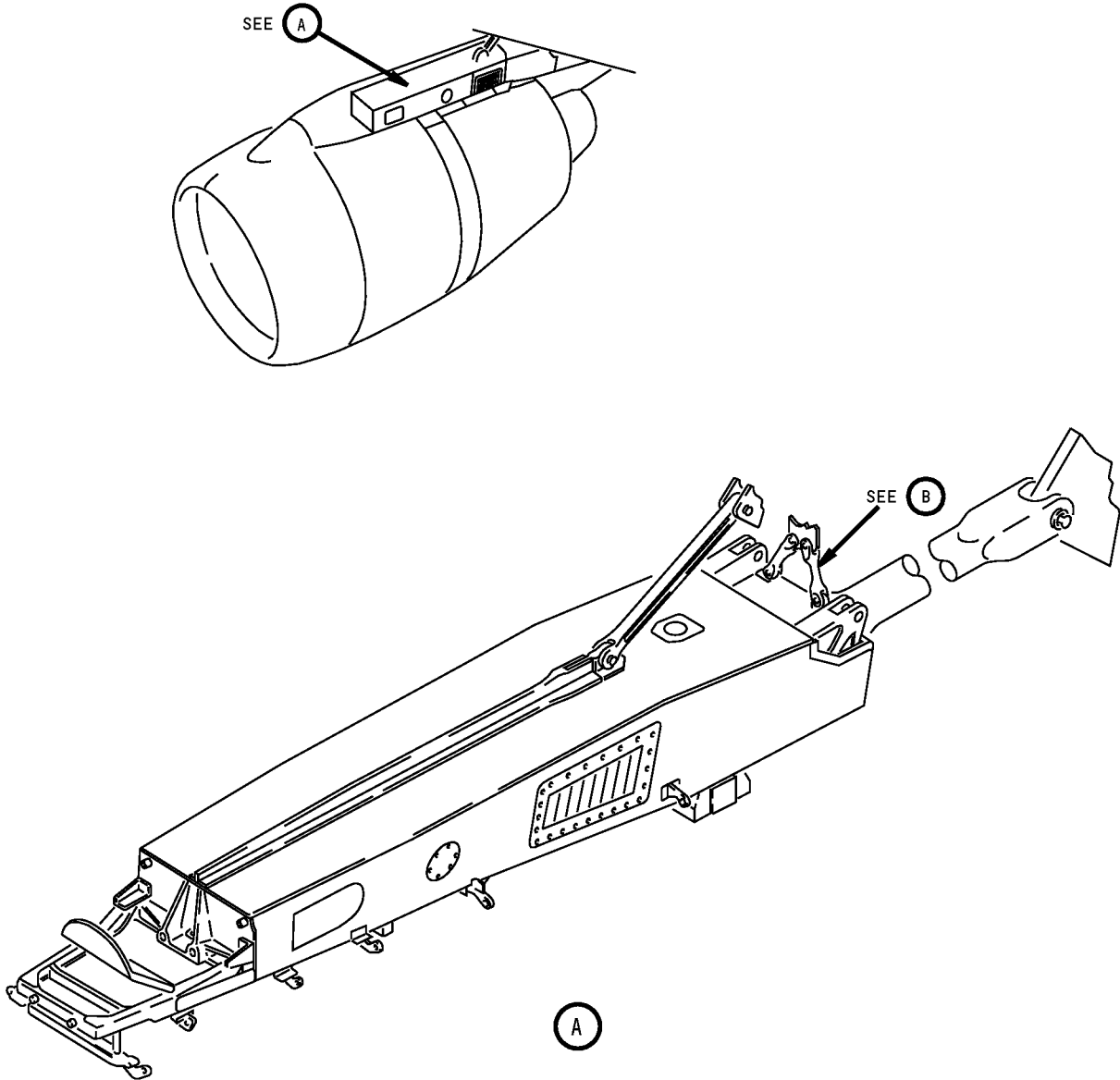
COMPONENT MAINTENANCE: NO

USAGE & DESCRIPTION: The B54012-1 jig equipment is used on all 757 airplanes. B54012 is used to install an eccentric bushing into the side link assembly and to drill an undersized hole through the retainer from the hole in the side link assembly. Refer to the current B54012 drawing for complete usage instructions. B54012-1 of:

B54012-1		
QUANTITY	NOMENCLATURE	PART NUMBER
1	STAND ASSEMBLY	B54012-2
1	SLEEVE ASSEMBLY	B54012-3
1	NUT ASSEMBLY	B54012-4
1	DRILL BUSHING ASSEMBLY	B54012-5
1	BUSHING	B54012-7
1	STORAGE BOX	

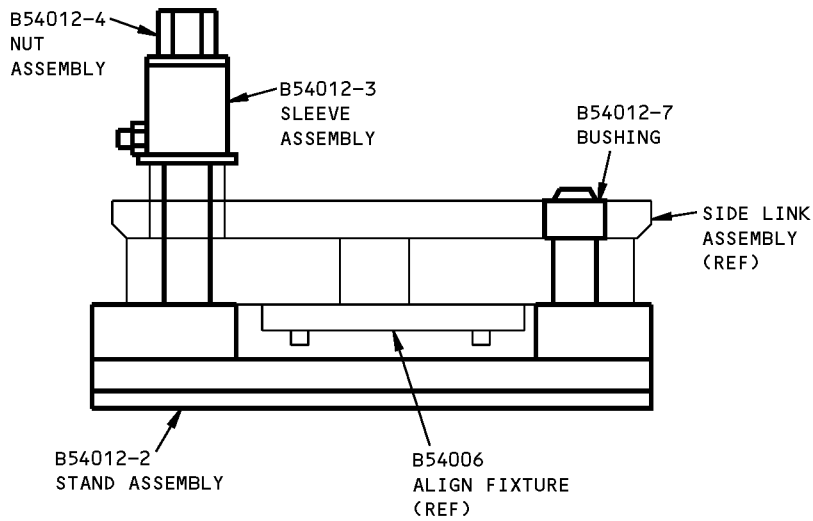
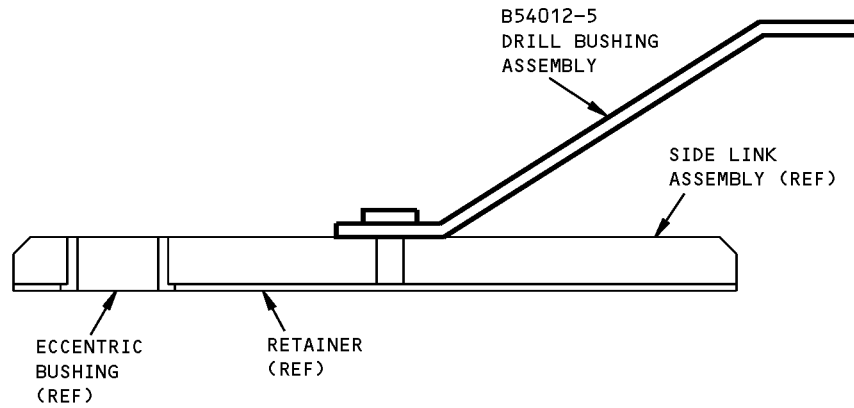
WEIGHT: 8 lbs (3.6 kg)

DIMENSIONS: 7 x 8 x 10 inches (178 x 203 x 254 mm)



Strut Side Link Jig Equipment
Figure 1 (Sheet 1 of 2)

ILLUSTRATED TOOL AND EQUIPMENT MANUAL

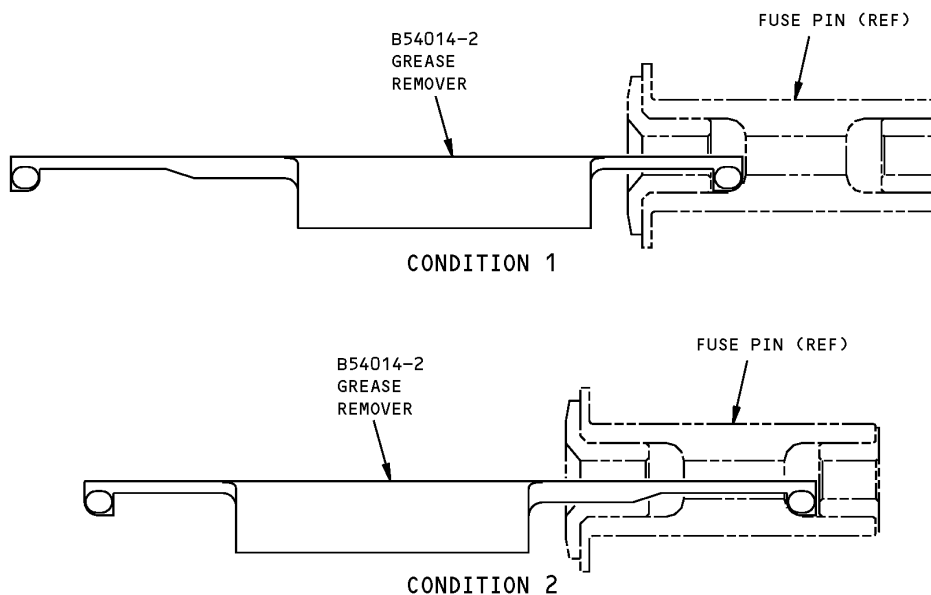


**Strut Side Link Jig Equipment
Figure 1 (Sheet 2 of 2)**

ILLUSTRATED TOOL AND EQUIPMENT MANUAL

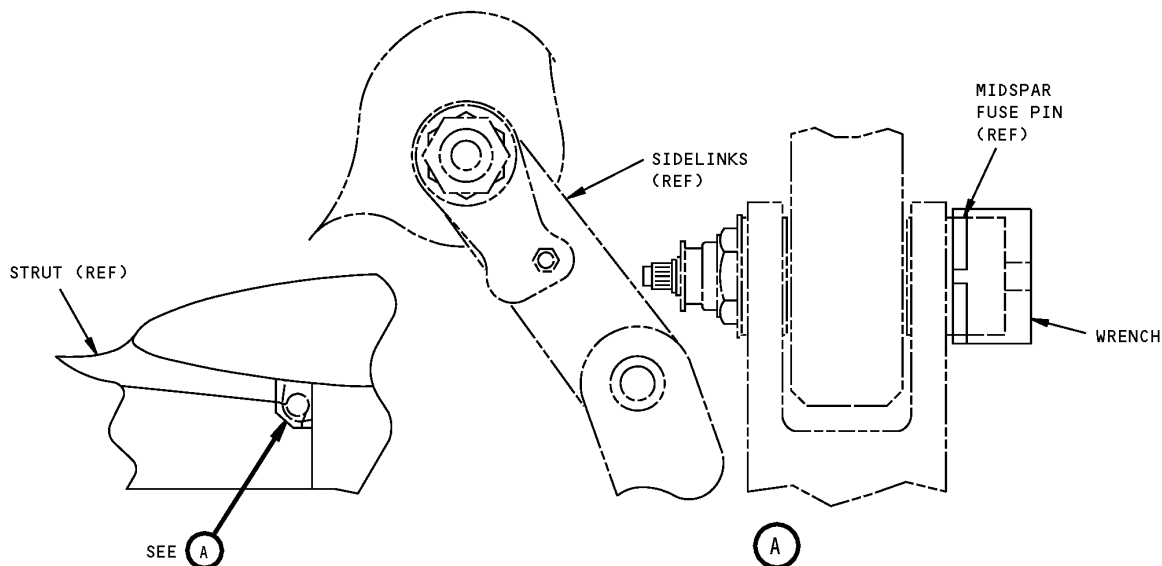
PART NUMBER: B54014-1**NAME:** GREASE REMOVER - MIDSPAR FUSE PIN**AIRPLANE MAINTENANCE:** YES**COMPONENT MAINTENANCE:** NO

USAGE & DESCRIPTION: The B54014-1 grease remover is used on 757-200 airplanes. B54014 is used to remove grease from interior of the mid-spar fuse pin assembly for inspection purposes. Refer to Maintenance Manual 54-51-02 for complete usage instructions for 757-200 airplanes with RB211-535 engines. Refer to Maintenance Manual 54-51-01 for complete usage instructions for 757-200 airplanes with PW2000 engines. B54014-1 consists of a B54014-2 grease remover contained in a storage box.

WEIGHT: 15 lbs (7 kg)**DIMENSIONS:** 1 x 1 x 11 inches (25 x 25 x 279 mm)

**Midspar Fuse Pin Grease Remover
Figure 1**

ILLUSTRATED TOOL AND EQUIPMENT MANUAL

PART NUMBER: B54015-1**NAME:** TORQUE WRENCH - MIDSPAR FUSE PIN IMMOBILIZER**AIRPLANE MAINTENANCE:** YES**COMPONENT MAINTENANCE:** NO**USAGE & DESCRIPTION:** The B54015-1 torque wrench is used on all 757 airplanes. B54015 restrains the midspar fuse pin while applying torque to the nut. Refer to the current B54015 drawing for complete usage instructions. B54015-1 consists of a B54015-2 wrench contained in a storage box.**WEIGHT:** 2 lbs (0.9 kg)**DIMENSIONS:** 2 x 4 x 8 inches (51 x 51 x 203 mm)**NOTE:** B54018 replaces B54015 for future procurement.

**Midspar Fuse Pin Immobilizer Torque Wrench
Figure 1**



757

ILLUSTRATED TOOL AND EQUIPMENT MANUAL

PART NUMBER: B54017-22

NAME: SLING EQUIPMENT - FUSE PIN, REMOVAL/INSTALLATION - RB211-535 ENGINE

AIRPLANE MAINTENANCE: YES

COMPONENT MAINTENANCE: NO

USAGE & DESCRIPTION: B54017-22 sling equipment is used on all 757 airplanes that are equipped with RB211-535 engines. B54017 is used to support the installed engine and strut during removal and installation of the diagonal brace or mid-spar fuse pins. Major equipment used with the B54017 sling equipment includes an overhead crane capable of lifting 12,000 lbs, a 0 to 20,000 lb capacity dynamometer and B54018 fuse pin kit. Refer to AMM 54-51-02 for complete usage instructions. B54017-22 consists of :

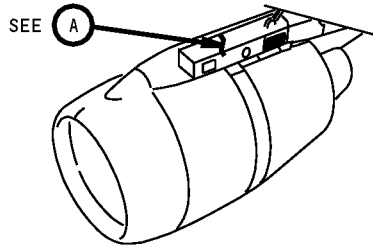
B54017-22		
QUANTITY	NOMENCLATURE	PART NUMBER
1	SLING ASSEMBLY	B54017-2
2	LIFT LINK ASSEMBLY	B54017-19
4	SLING LINK	G-341-3/4
2	ANCHOR SHACKLE	G-2130-1.0
1	STORAGE BOX	

WEIGHT: 320 lbs (145 kg)

DIMENSIONS: 18 x 24 x 88 (457 x 610 x 2235 mm)

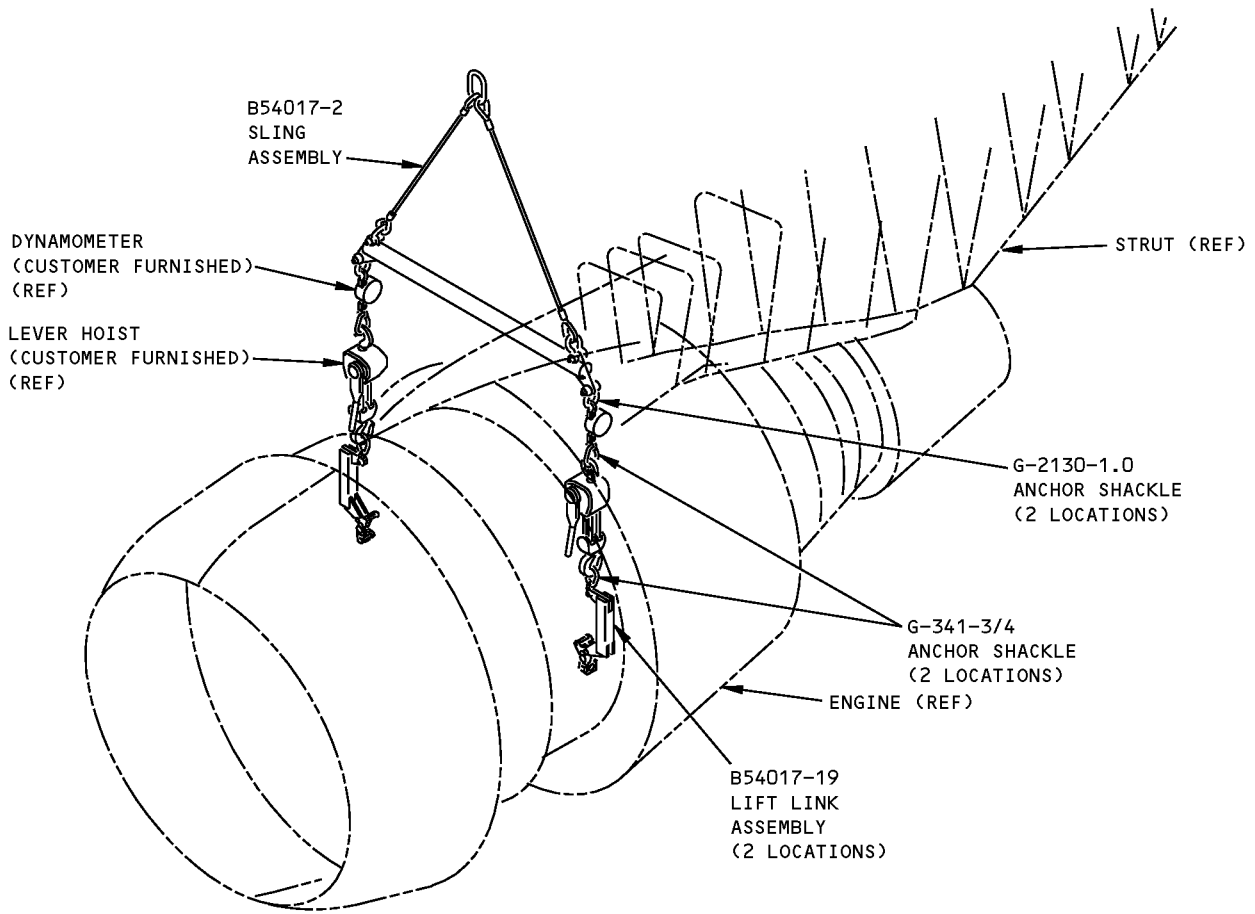
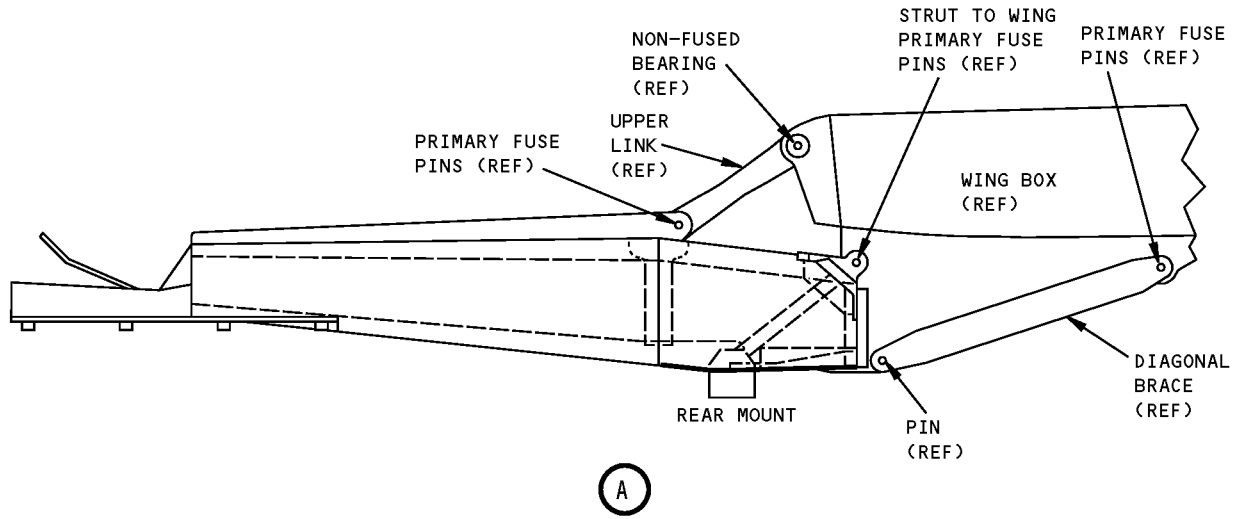
NOTE: B54017-22 supersedes B54017-18.
B54017 replaces B54009 for future procurement.

ILLUSTRATED TOOL AND EQUIPMENT MANUAL



**RB211-535 Engine Fuse Pin, Removal/Installation Sling Equipment
Figure 1 (Sheet 1 of 2)**

ILLUSTRATED TOOL AND EQUIPMENT MANUAL



**RB211-535 Engine Fuse Pin, Removal/Installation Sling Equipment
Figure 1 (Sheet 2 of 2)**



757

ILLUSTRATED TOOL AND EQUIPMENT MANUAL

PART NUMBER: B54018-29, -42, -44, -45

NAME: REMOVAL/INSTALLATION KIT - FUSE PIN

AIRPLANE MAINTENANCE: YES

COMPONENT MAINTENANCE: NO

USAGE & DESCRIPTION: The B54018-29 and -42 removal/installation kits are used on 757-200 airplanes. The B54018-44 removal/installation kit is used on 757-300 airplanes only. The B54018-45 removal/installation kit contains all of the components of B54018-29, -42 and -44 and is used on all 757-200/300 airplanes. B54018 is used to remove or install strut fuse pins. Refer to AMM 54-51-01, AMM 54-51-02 and AMM 54-51-05 for complete usage instructions. B54018-29, -42, -44 and -45 consists of:

B54018-29		
QUANTITY	NOMENCLATURE	PART NUMBER
1	PULLER ASSEMBLY	B54018-30
1	5/16" FLANGE NUT	B54018-4
1	MIDSPAR SLUG ASSEMBLY	B54018-31
2	3/8" FLANGE NUT	B54018-6
1	PULLER PLATE	B54018-26
1	SLUG	B54018-8
1	SLUG	B54018-9
1	SLUG	B54018-10
1	SLUG	B54018-11
1	SLUG	B54018-12
1	SLIDE SCREW	B54018-13
1	SLIDE HAMMER	CG240-9
1	STORAGE BOX	

B54018-42		
QUANTITY	NOMENCLATURE	PART NUMBER
1	PULLER ASSEMBLY	B54018-30
1	5/16" FLANGE NUT	B54018-4
1	MIDSPAR SLUG ASSEMBLY	B54018-31
2	3/8" FLANGE NUT	B54018-6
1	PULLER PLATE	B54018-26
1	SLUG	B54018-8



757

ILLUSTRATED TOOL AND EQUIPMENT MANUAL

B54018-42		
QUANTITY	NOMENCLATURE	PART NUMBER
1	SLUG	B54018-9
1	SLUG	B54018-10
1	SLUG	B54018-11
1	SLUG	B54018-12
1	SLIDE SCREW	B54018-13
1	SLIDE HAMMER	CG240-9
1	SPANNER WRENCH ASSEMBLY	B54018-38
1	STORAGE BOX	

B54018-44		
QUANTITY	NOMENCLATURE	PART NUMBER
1	PULLER ASSEMBLY	B54018-46
1	5/16" FLANGE NUT	B54018-4
1	MIDSPAR SLUG ASSEMBLY	B54018-47
1	SLUG	B54018-9
1	SLUG	B54018-51
1	SLUG	B54018-52
1	SLUG	B54018-53
1	SLIDE SCREW	B54018-13
1	SLIDE HAMMER	CG240-9
1	SPANNER WRENCH ASSEMBLY	B54018-48
1	STORAGE BOX	

B54018-45		
QUANTITY	NOMENCLATURE	PART NUMBER
1	PULLER ASSEMBLY	B54018-30
1	PULLER ASSEMBLY	B54018-46
1	5/16" FLANGE NUT	B54018-4
1	MIDSPAR SLUG ASSEMBLY	B54018-31
1	MIDSPAR SLUG ASSEMBLY	B54018-47
2	3/8" FLANGE NUT	B54018-6
1	PULLER PLATE	B54018-26
1	SLUG	B54018-8



757

ILLUSTRATED TOOL AND EQUIPMENT MANUAL

B54018-45		
QUANTITY	NOMENCLATURE	PART NUMBER
1	SLUG	B54018-9
1	SLUG	B54018-10
1	SLUG	B54018-11
1	SLUG	B54018-12
1	SLUG	B54018-51
1	SLUG	B54018-52
1	SLUG	B54018-53
1	SLIDE SCREW	B54018-13
1	SLIDE HAMMER	CG240-9
1	SPANNER WRENCH ASSEMBLY	B54018-38
1	SPANNER WRENCH ASSEMBLY	B54018-48
1	STORAGE BOX	

WEIGHT:

B54018-29,-42 and -44 - 9 lbs (4.1 kg)
B54018-45 - 14 lbs (6 kg)

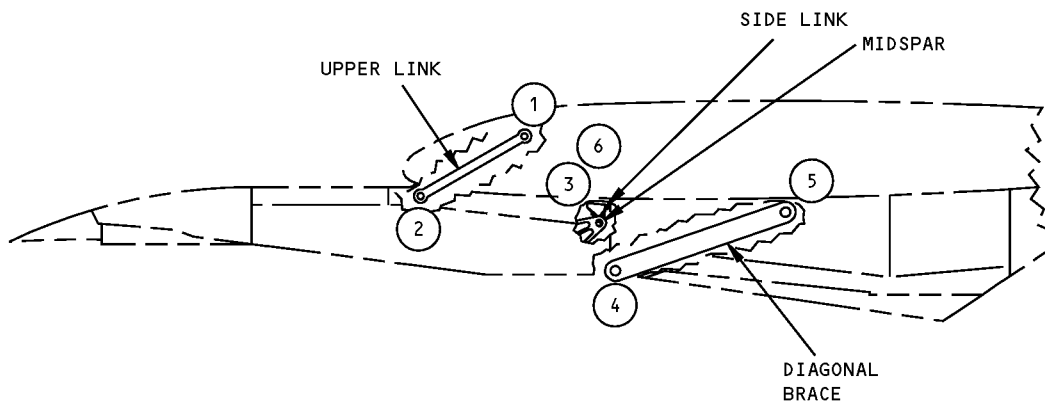
DIMENSIONS:

B54018-29, -42 and -44 - 3 x 11 x 20 inches (76 x 279 x 508 mm)
B54018-45 - 3 x 11 x 35 inches (76 x 279 x 889 mm)

NOTE:

B54018-42 replaces B54018-29 for future procurement.
B54018-29 supersedes B54018-24.
B54018 replaces A54008 (757 only) and B54015 for future procurement.

757
ILLUSTRATED TOOL AND EQUIPMENT MANUAL



SLUG	ENGINE	USAGE LOCATION
B54018-31	RB211-535 AND PW2000 ENGINES	③ MIDSPAR
B54018-8	RB211-535 ENGINE ONLY	④ DIAGONAL BRACE, STRUT
B54018-9	PW2000 ENGINE ONLY	④ DIAGONAL BRACE, STRUT
B54018-10	RB211-535 AND PW2000 ENGINES	⑤ DIAGONAL BRACE, WING
B54018-11	RB211-535 AND PW2000 ENGINES	① UPPER LINK, WING
B54018-12	RB211-535 AND PW2000 ENGINES	② UPPER LINK, STRUT
B54018-38	RB211-535 AND PW2000 ENGINES	⑥ SIDE LINK, STRUT

B54018-29, -42

Fuse Pin Removal/Installation Kit
Figure 1 (Sheet 1 of 5)



757
ILLUSTRATED TOOL AND EQUIPMENT MANUAL

SLUG	ENGINE	USAGE LOCATION
B54018-47	PW2000 ENGINE	③ MIDSPAR
B54018-9	PW2000 ENGINE	④ DIAGONAL BRACE, STRUT
B54018-51	PW2000 ENGINE	⑤ DIAGONAL BRACE, WING
B54018-52	PW2000 ENGINE	① UPPER LINK, WING
B54018-53	PW2000 ENGINE	② UPPER LINK, STRUT
B54018-48	PW2000 ENGINE	⑥ SIDE LINK, STRUT

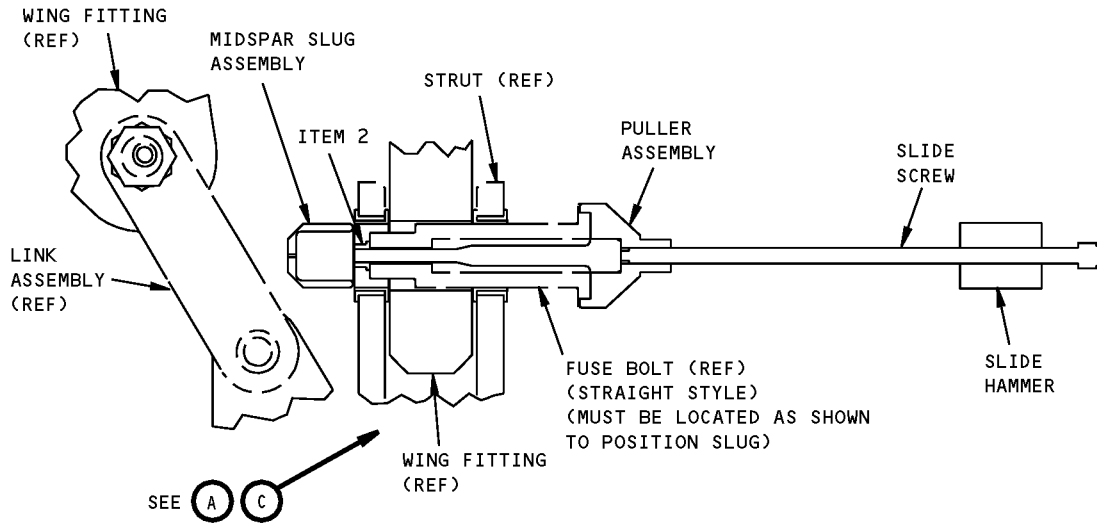
B54018-44

SLUG	ENGINE	USAGE LOCATION
B54018-31	RB211-535 AND PW2000 ENGINES (757-200)	③ MIDSPAR
B54018-47	PW2000 ENGINE ONLY (757-300)	③ MIDSPAR
B54018-8	RB211-535 ENGINE ONLY (757-200)	④ DIAGONAL BRACE, STRUT
B54018-9	PW2000 ENGINE ONLY (757-200,-300)	④ DIAGONAL BRACE, STRUT
B54018-10	RB211-535 AND PW2000 ENGINES (757-200)	⑤ DIAGONAL BRACE, WING
B54018-51	PW2000 ENGINE ONLY (757-300)	⑤ DIAGONAL BRACE, WING
B54018-11	RB211-535 AND PW2000 ENGINES (757-200)	① UPPER LINK, WING
B54018-52	PW2000 ENGINE ONLY (757-300)	① UPPER LINK, WING
B54018-12	RB211-535 AND PW2000 ENGINES (757-200)	② UPPER LINK, STRUT
B54018-53	PW2000 ENGINE ONLY (757-300)	② UPPER LINK, STRUT
B54018-38	RB211-535 AND PW2000 ENGINES (757-200)	⑥ SIDE LINK, STRUT
B54018-48	PW2000 ENGINE ONLY (757-300)	⑥ SIDE LINK, STRUT

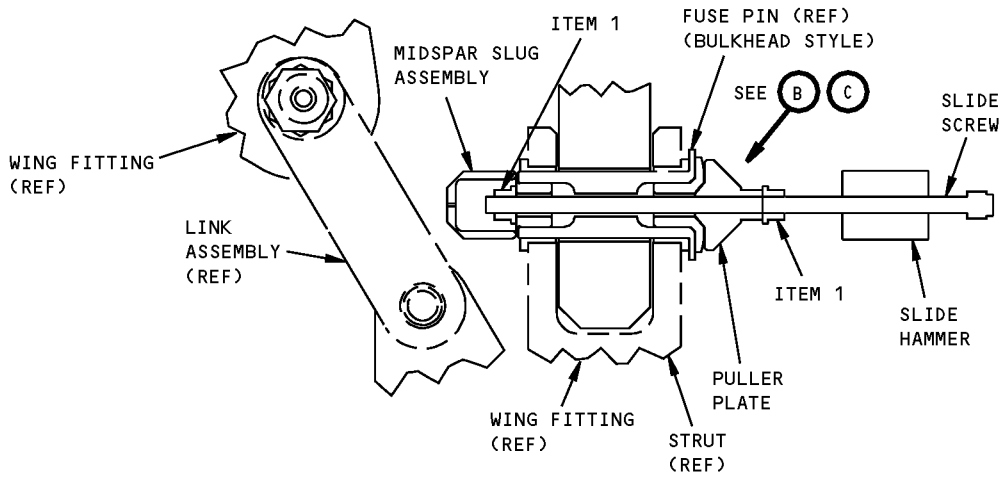
B54018-45

Fuse Pin Removal/Installation Kit
Figure 1 (Sheet 2 of 5)

ILLUSTRATED TOOL AND EQUIPMENT MANUAL



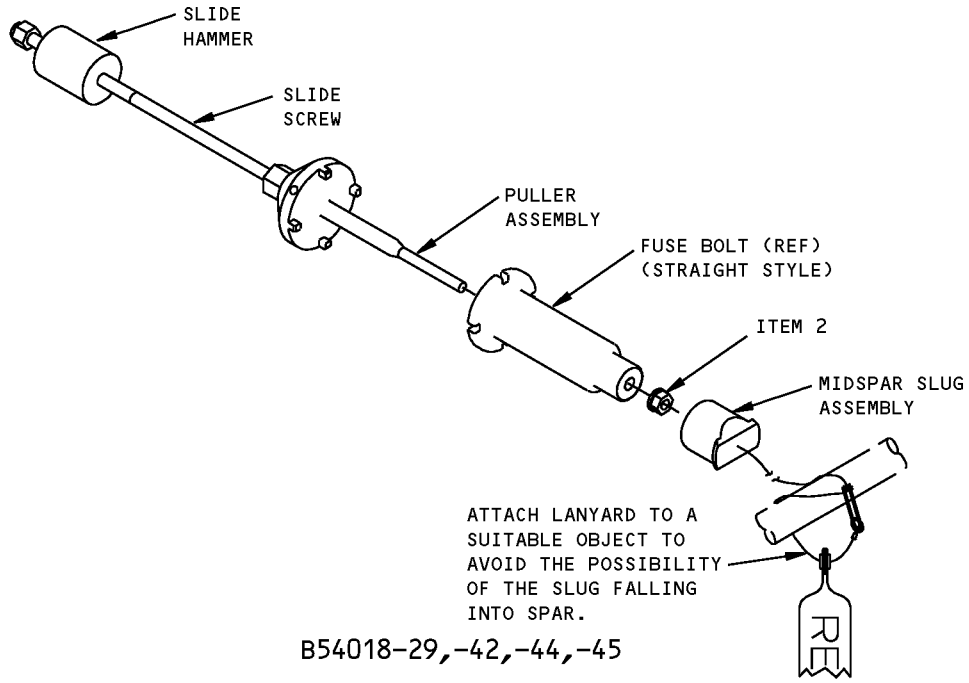
**SET-UPS FOR MIDSPAR PINS
B54018-29,-42,-44,-45**



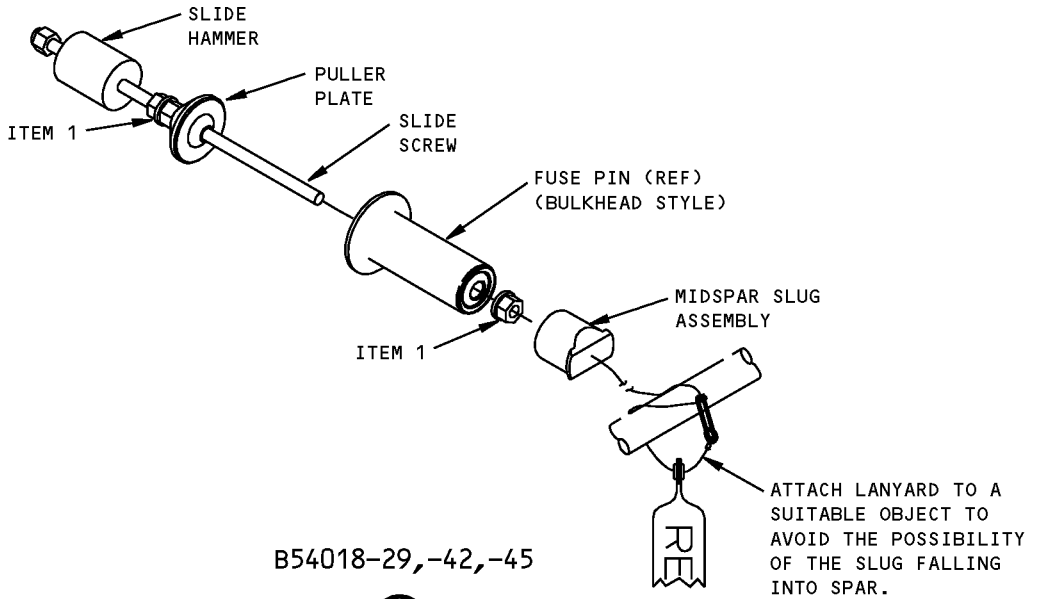
B54018-29,-42,-45

**Fuse Pin Removal/Installation Kit
Figure 1 (Sheet 3 of 5)**

ILLUSTRATED TOOL AND EQUIPMENT MANUAL



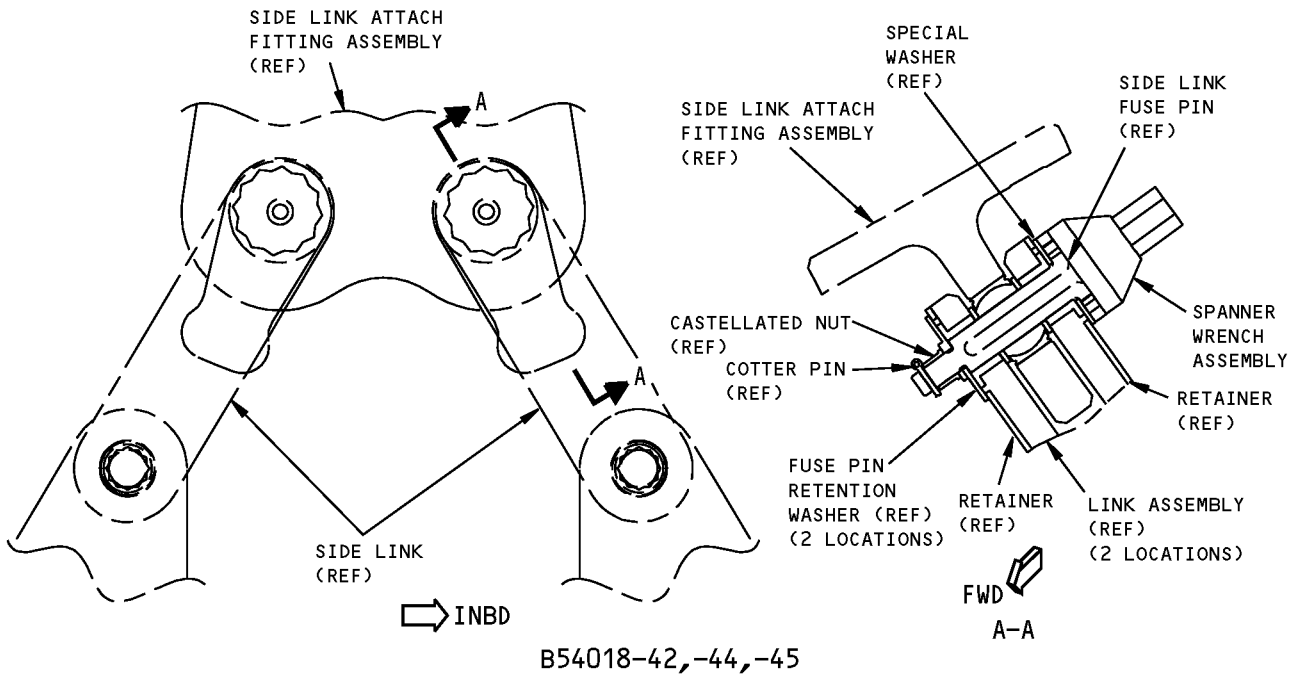
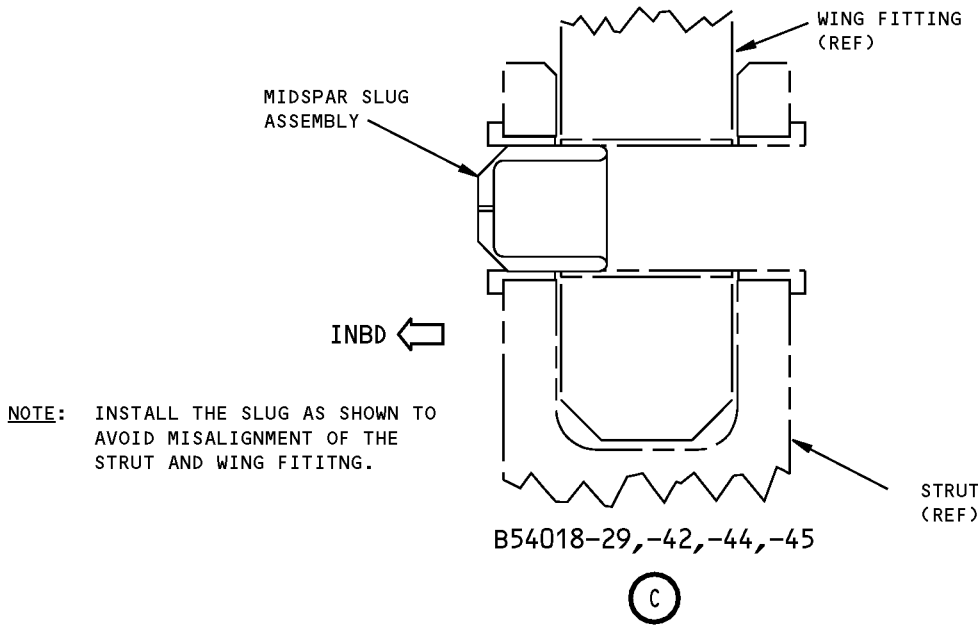
(A)



(B)

**Fuse Pin Removal/Installation Kit
Figure 1 (Sheet 4 of 5)**

ILLUSTRATED TOOL AND EQUIPMENT MANUAL



**Fuse Pin Removal/Installation Kit
Figure 1 (Sheet 5 of 5)**



757

ILLUSTRATED TOOL AND EQUIPMENT MANUAL

REPAIRABLE/REPLACEABLE PARTS			
ITEM NO.	PART NO.	NOMENCLATURE	VENDOR CODE
1	B54018-6	3/8" FLANGE NUT (3/8-16UNC-2B)	
1	CL-127 (OPTION)	3/8" FLANGE NUT (3/8-16UNC-2B)	V99862
2	B54018-4	5/16" FLANGE NUT (3/8-18UNC-2B)	
2	CL-126 (OPTION)	5/16" FLANGE NUT (3/8-18UNC-2B)	V99862



757

ILLUSTRATED TOOL AND EQUIPMENT MANUAL

PART NUMBER: B54019-23, -24, -40, -41

NAME: ADAPTER EQUIPMENT - STRUT UNLOAD, FORWARD ENGINE MOUNT

AIRPLANE MAINTENANCE: YES

COMPONENT MAINTENANCE: NO

USAGE & DESCRIPTION: B54019-23 or -40 adapter equipment is used on 757 airplanes equipped with PW2000 engines. The B54019-23 adapter uses 115VAC, 60/400HZ power. The B54019-10 adapter uses 220VAC, 50HZ power.

B54019-24 or -41 adapter equipment is used on 757 airplanes equipped with RB211-535 engines. The B54019-24 adapter uses 115VAC, 60/400HZ power. The B54019-41 adapter uses 220VAC, 50HZ power.

The B54019 adapter equipment is used after engine removal unload the engine mount strut, allowing removal of the wing/strut attach fuse pins. The B54019 is used in conjunction with a customer-furnished tripod jack. Refer to AMM 54-51-01 and AMM 54-51-02 for complete usage instructions. B54019-23, -24, -40 and -41 consists of:

B54019-23		
QUANTITY	NOMENCLATURE	PART NUMBER
1	ADAPTER BLOCK ASSEMBLY	B54019-2
1	JACK MOUNT ASSEMBLY	B54019-3
1	THREAD PROTECTOR	B54019-4
4	PROTECTOR	B54019-8
1	INDICATOR ASSEMBLY	B54019-25
1	CABLE ASSEMBLY	B54019-27
1	LOAD CELL ASSEMBLY	B54019-37
2	BOLT	NAS6610-14
4	WASHER	AN960JD1216
1	STORAGE BOX	

B54019-24		
QUANTITY	NOMENCLATURE	PART NUMBER
1	JACK MOUNT ASSEMBLY	B54019-3
1	INDICATOR ASSEMBLY	B54019-25
1	CABLE ASSEMBLY	B54019-27
1	ADAPTER BLOCK ASSEMBLY	B54019-17
1	ADAPTER BLOCK ASSEMBLY	B54019-18



757

ILLUSTRATED TOOL AND EQUIPMENT MANUAL

B54019-24		
QUANTITY	NOMENCLATURE	PART NUMBER
1	LOAD CELL ASSEMBLY	B54019-37
1	STORAGE BOX	

B54019-40		
QUANTITY	NOMENCLATURE	PART NUMBER
1	ADAPTER BLOCK ASSEMBLY	B54019-2
1	JACK MOUNT ASSEMBLY	B54019-3
1	THREAD PROTECTOR	B54019-4
4	PROTECTOR	B54019-8
1	INDICATOR ASSEMBLY	B54019-43
1	CABLE ASSEMBLY	B54019-27
1	LOAD CELL ASSEMBLY	B54019-37
2	BOLT	NAS6610-14
4	WASHER	AN960JD1216
1	STORAGE BOX	

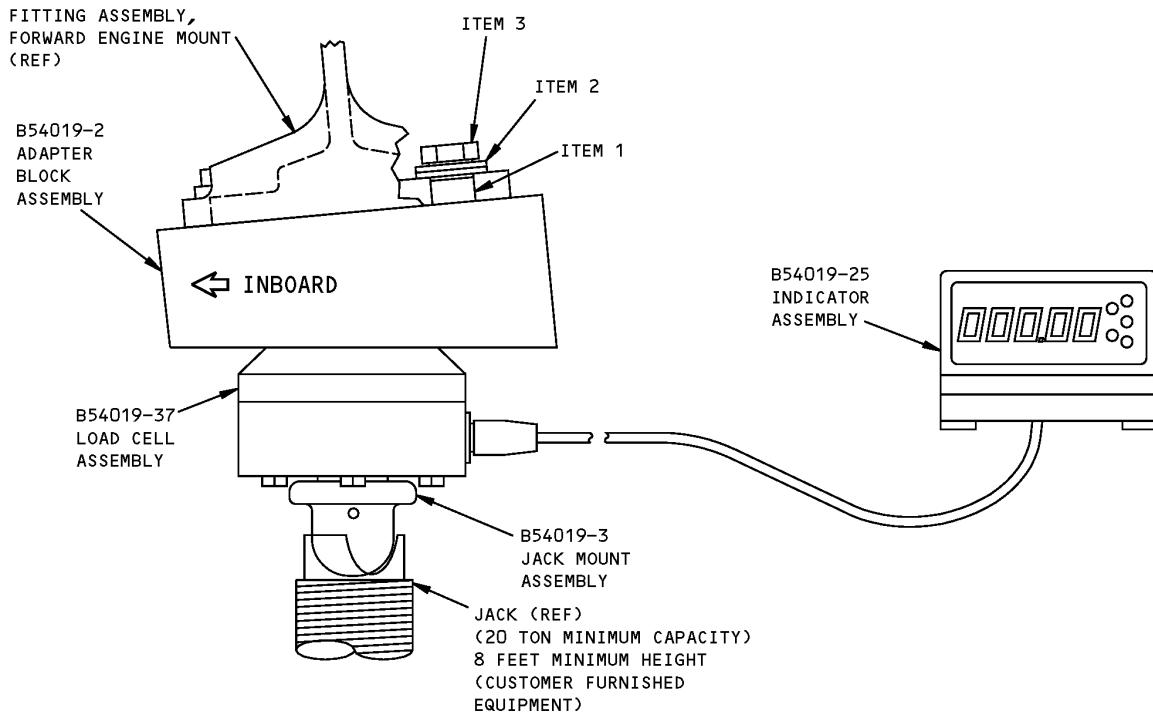
B54019-41		
QUANTITY	NOMENCLATURE	PART NUMBER
1	JACK MOUNT ASSEMBLY	B54019-3
1	INDICATOR ASSEMBLY	B54019-43
1	CABLE ASSEMBLY	B54019-27
1	ADAPTER BLOCK ASSEMBLY	B54019-17
1	ADAPTER BLOCK ASSEMBLY	B54019-18
1	LOAD CELL ASSEMBLY	B54019-37
1	STORAGE BOX	

WEIGHT: B54019-23, -40 - 10 lbs
B54019-24, -41 - 19 lbs

DIMENSIONS: B54019-23, -40 - 5 x 9 x 13 inches
B54019-24, -41 - 5 x 9 x 13 inches

NOTE: B54019-23 and -40 supersede B54019-1.
B54019-24 and -41 supersede B54019-15.

ILLUSTRATED TOOL AND EQUIPMENT MANUAL

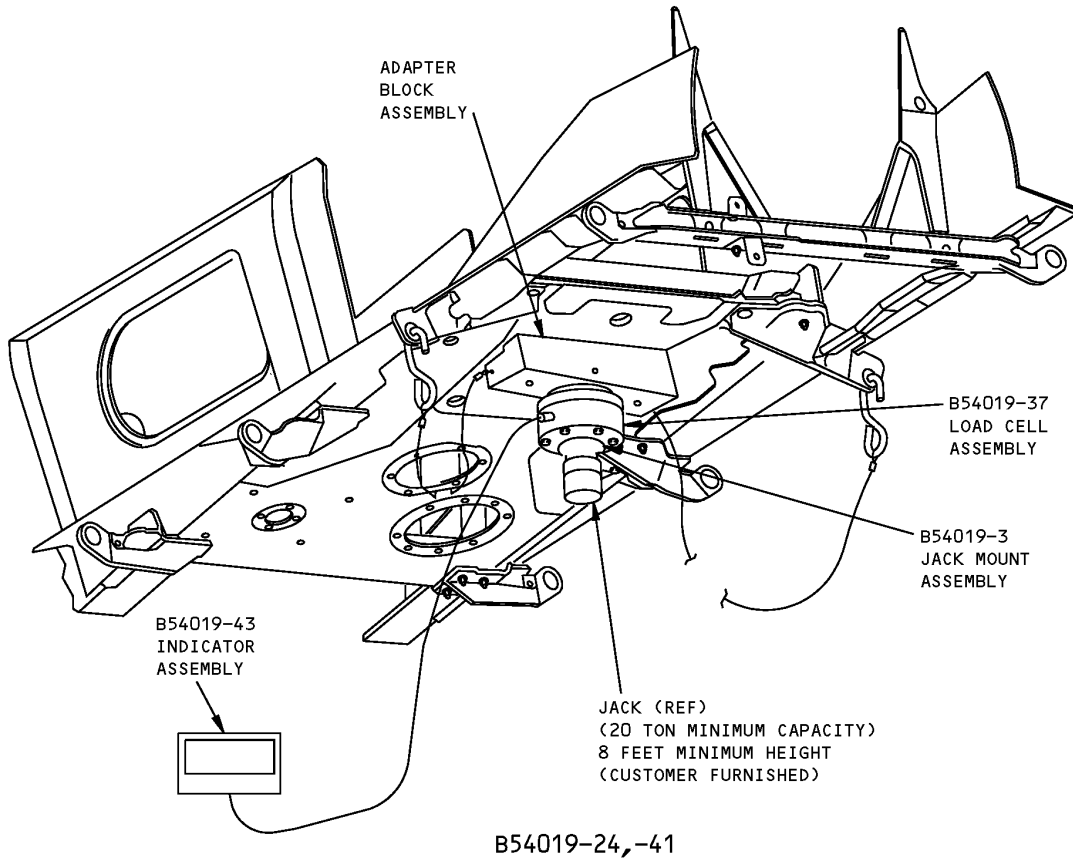


VIEW LOOKING AFT
LEFT SIDE PYLON SHOWN
RIGHT SIDE PYLON OPPOSITE

B54019-23, -40

**Forward Engine Mount Strut Unload Adapter Equipment
Figure 1 (Sheet 1 of 2)**

757
ILLUSTRATED TOOL AND EQUIPMENT MANUAL



Forward Engine Mount Strut Unload Adapter Equipment
Figure 1 (Sheet 2 of 2)

REPAIRABLE/REPLACEABLE PARTS			
ITEM NO.	PART NO.	NOMENCLATURE	VENDOR CODE
1	B54019-8	PROTECTOR	
2	AN960JD1216	WASHER	
3	AN960JD1216	BOLT	



757

ILLUSTRATED TOOL AND EQUIPMENT MANUAL

PART NUMBER: B54009-19

NAME: SLING - RB211-535 ENGINE

AIRPLANE MAINTENANCE: YES

COMPONENT MAINTENANCE: NO

USAGE & DESCRIPTION: The B54009-19 sling is used on 757 airplanes equipped with RB211-535 engines. B54009 is used to support the engine and unload the diagonal brace during removal and installation of the diagonal brace. Refer to AMM 54-51-02 for complete usage instructions. B54009-19 consists of:

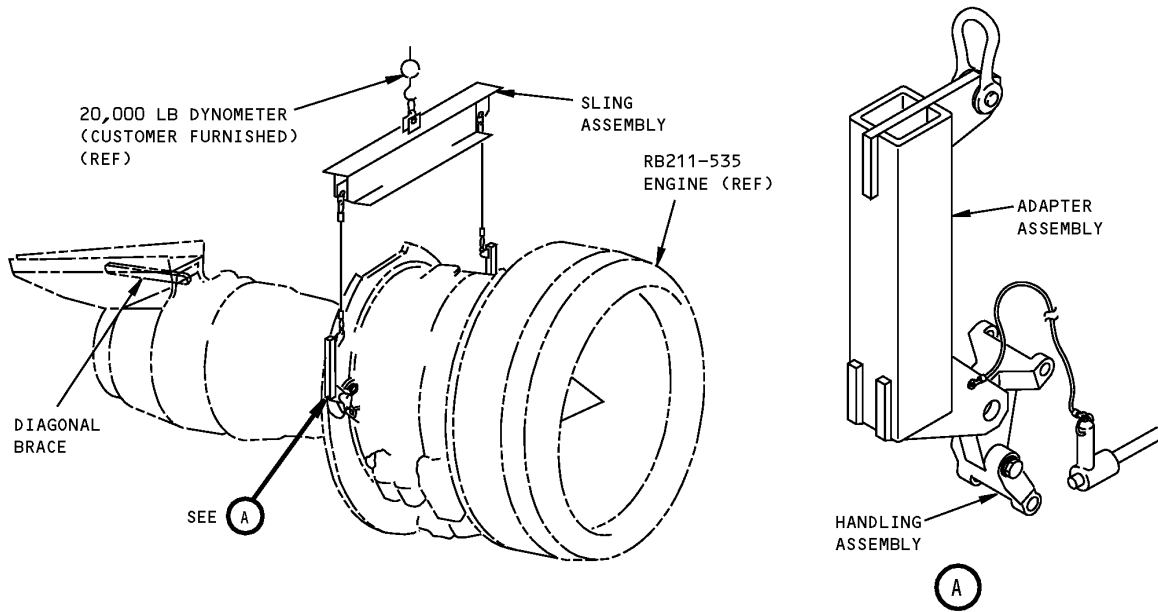
B54009-19		
QUANTITY	NOMENCLATURE	PART NUMBER
1	BEAM ASSEMBLY	B54009-2
2	ADAPTER ASSEMBLY	B54009-3
2	HANDLING ASSEMBLY	B54009-20
2	CABLE ASSEMBLY	B54009-5
4	SHACKLE	G-209-5/8
1	SHACKLE	G-2130-7/8
1	RING	G-341-1
2	CABLE ASSEMBLY	CL-23-KA-10.0LR
2	BALL LOCK PIN	NAS1343C5C2.1D
1	STORAGE BOX	

WEIGHT: 230 lbs (104 kg)

DIMENSIONS: 10 x 24 x 86 inches (254 x 610 x 2184 mm)

NOTE: B54009-19 supersedes B54009-1.
B54017 replaces B54009 for future procurement.

ILLUSTRATED TOOL AND EQUIPMENT MANUAL



**RB211-535 Engine Sling
Figure 1**



757

ILLUSTRATED TOOL AND EQUIPMENT MANUAL

PART NUMBER: B54013-38, -48

NAME: SLING EQUIPMENT - DIAGONAL BRACE UNLOAD, PW2000 SERIES ENGINE

AIRPLANE MAINTENANCE: YES

COMPONENT MAINTENANCE: NO

USAGE & DESCRIPTION: The B54013-38 and -48 sling equipment is used on 757 airplanes equipped with PW2000 series engines. B54013 is used to support the PW2000 series engine and unload the diagonal brace during removal and installation of the diagonal brace/midspar fuse pin. B54013 is used with the following customer-furnished equipment: a 13,000 lb capacity crane, a 0 - 20,000 lb dynamometer and a B54018 or A54008 fuse pin removal/installation kit. Refer to the current B54013 drawing and AMM 54-51-02 for complete usage instructions.

The B54013 consists of:

B54013-38		
QUANTITY	NOMENCLATURE	PART NUMBER
1	SLING ASSEMBLY	B54013-39
1	MASTER LINK	G-342-1 1/4
1	STORAGE BOX ASSEMBLY	F70313-4

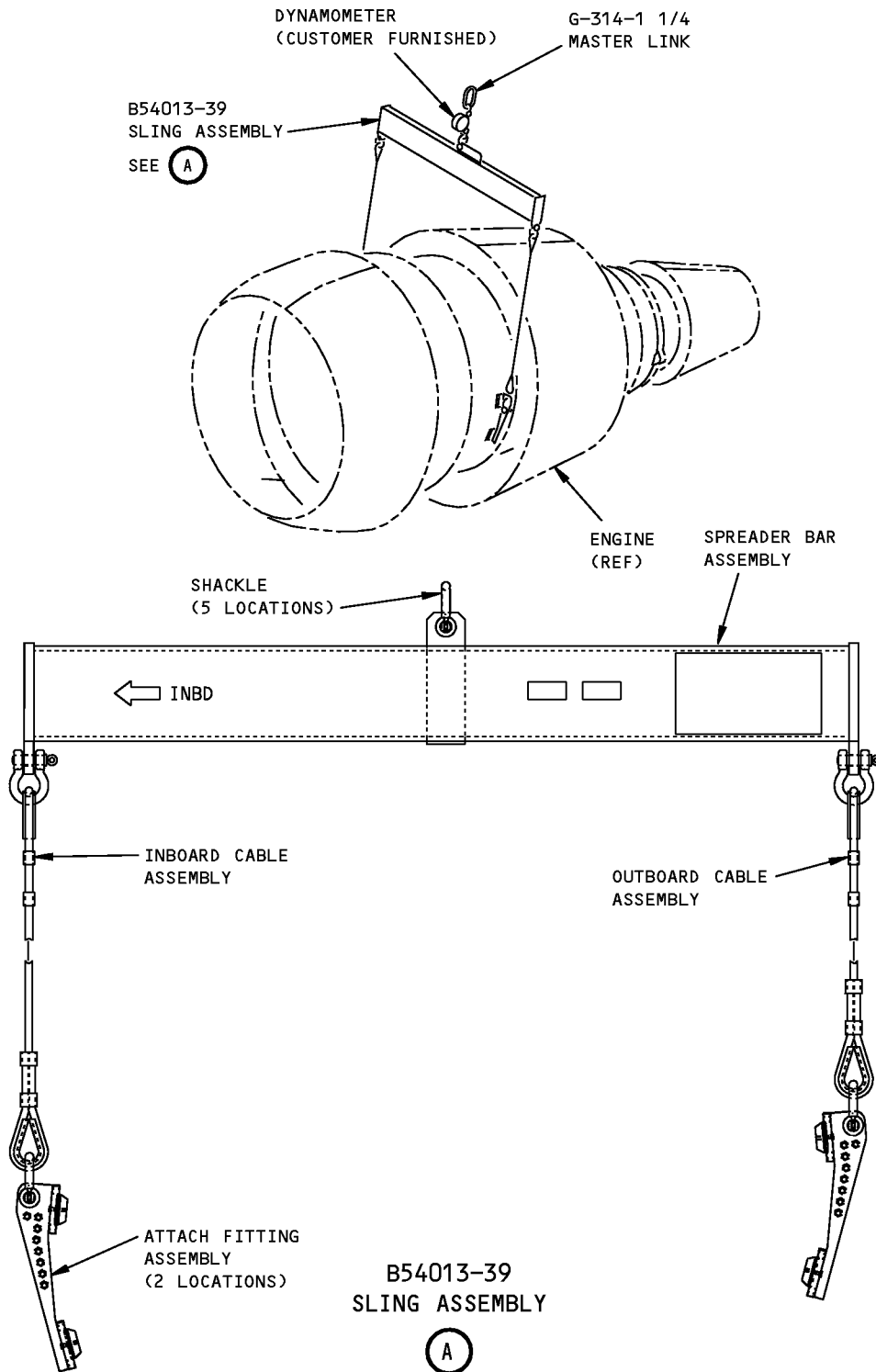
B54013-48		
QUANTITY	NOMENCLATURE	PART NUMBER
2	ATTACH FITTING ASSEMBLY	B54013-4
1	SLING ASSEMBLY	B54013-49
5	SHACKLE	G-209- 7/8
6	SLING LINK	G-341- 7/8
1	MASTER LINK	G-342-1 1/4
1	STORAGE BOX ASSEMBLY	F70313-3

WEIGHT: 420 lbs (191 kg)

DIMENSIONS: 24 x 24 x 100 inches (610 x 610 x 2540 mm)

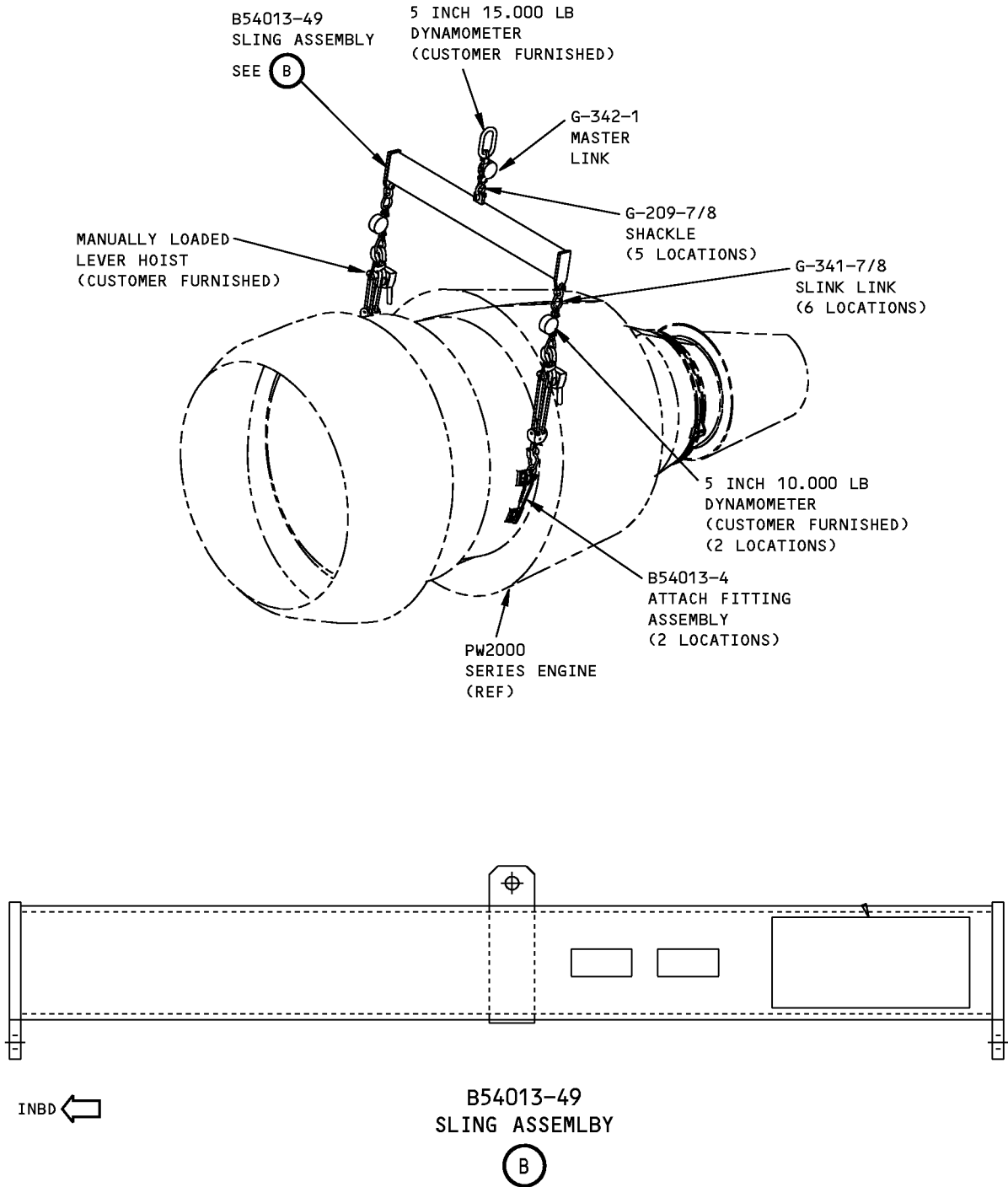
NOTE: B54013-38 supersedes B54013-1.
B54013-48 replaces B54013-38 for future procurement.

ILLUSTRATED TOOL AND EQUIPMENT MANUAL



**B54013-38 PW2000 Series Engine Diagonal Brace Unload Sling Equipment
Figure 1**

757
ILLUSTRATED TOOL AND EQUIPMENT MANUAL



B54013-49 PW2000 Series Engine Diagonal Brace Unload Sling Equipment
Figure 2