TO: ALL HOLDERS OF OUTBOARD AILERON COMPONENTS COMPONENT MAINTENANCE MANUAL 27-11-02

REVISION NO. 7 DATED OCT 01/89

HIGHLIGHTS

Pages which have been added or revised are outlined below together with the highlights of the revision. Remove and insert the affected pages as listed and enter Revision No. and date to the Record of Revision Sheet.

CHAPTER/SECTION AND PAGE NO.	DESCRIPTION OF CHANGE
TITLE PAGE 1 TR & SB RECORD 1 REPAIR 3-1 601-602 1002-1004,1006-1010, 1013-1016,1025-1031	Added top assemblies 252T1200-8 and -9 with new stainless steel bearings to improve corrosion resistance per PRR B11857.
1002-1004,1006-1010, 1013-1016,1025-1031	Replaced bearing BACB10AP5 with improved corrosion resistance stainless steel bearing BACB10FS5R.

OUTBOARD AILERON COMPONENTS
PART NUMBERS 252T1200-5 THRU -9
252T1211-1

COMPONENT MAINTENANCE MANUAL
WITH
ILLUSTRATED PARTS LIST

BOEING
COMPONENT
MAINTENANCE MANUAL

REVISION RECORD

- Retain this record in front of manual. On receipt of revision, insert revised pages in the manual, and enter revision number, date inserted and initial.

REVISION NUMBER	REVISION DATE	DATE FILED	BY	REVISION NUMBER	REVISION DATE	DATE FILED	BY

7804

BOEING
COMPONENT
MAINTENANCE MANUAL

TEMPORARY REVISION AND SERVICE BULLETIN RECORD

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVE	DATE OF INCORPORATION INTO MANUAL
		PRR B11857	OCT 01/89

PAGE	DATE	CODE
27-11-02		
TITLE PAGE		
*1	OCT 01/89	01.1
2	BLANK	
REVISION RECORD		
1	JAN 10/85	01.1
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TR & SB RECORD		
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LIST OF EFFECTIVE PAGES		
*1	OCT 01/89	01
THRU LAST PAGE		
CONTENTS		
1	JAN 10/85	01.1
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INTRODUCTION		
1	JAN 10/85	01.1
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DESCRIPTION & OPERATION		
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DISASSEMBLY		
301	JAN 10/85	01.1
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CHECK		
501	JAN 10/85	01.1
502	BLANK	
REPAIR-GENERAL		
601	APR 01/88	01.1
602	JAN 10/85	01.1
REPAIR 1-1		
601	JAN 10/85	01.1
602	BLANK	
REPAIR 2-1		
601	JAN 10/85	01.1
602	JAN 10/85	01.1
REPAIR 3-1		
*601	OCT 01/89	01.1
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REPAIR 4-1		
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REPAIR 5-1		
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ASSEMBLY		
701	JAN 10/85	01.1
702	BLANK	
FITS AND CLEARANCES		
801	JAN 10/85	01.1
802	JAN 10/85	01.1
803	JAN 10/85	01.1
804	BLANK	
ILLUSTRATED PARTS LIST		
1001	JAN 10/85	01.1
*1002	OCT 01/89	01.1
*1003	OCT 01/89	01.1
*1004	OCT 01/89	01.1
*1005	OCT 01/89	01.1
*1006	OCT 01/89	01.1
*1007	OCT 01/89	01.1
*1008	OCT 01/89	01.1

* = REVISED, ADDED OR DELETED

PAGE	DATE	CODE
ILLUSTRATED PARTS LIST		CONT.
*1009	OCT 01/89	01.1
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*1012	OCT 01/89	01.1
*1013	OCT 01/89	01.1
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*1023	OCT 01/89	01.1
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*1025	OCT 01/89	01.1
*1026	OCT 01/89	01.1
*1027	OCT 01/89	01.1
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*1029	OCT 01/89	01.1
*1030	OCT 01/89	01.1
*1031	OCT 01/89	01.1
*1032	BLANK	

PAGE	DATE	CODE

* = REVISED, ADDED OR DELETED

COMPONENT
MAINTENANCE MANUAL

TABLE OF CONTENTS

*[1] Special instructions not required. Use standard industry practices and information contained in 20-30-03.

INTRODUCTION

The instructions in this manual provide the information necessary to perform maintenance functions ranging from simple checks and replacement to complete shop-type repair.

This manual is divided into separate sections:

1. Title Page
2. Record of Revisions
3. Temporary Revision & Service Bulletin Record
4. List of Effective Pages
5. Table of Contents
6. Introduction
7. Procedures & IPL Sections

Refer to the Table of Contents for the page location of applicable sections. An asterisked flagnote *[ ] in place of the page number indicates that no special instructions are provided since the function can be performed using standard industry practices.

The beginning of the REPAIR section includes a list of the separate repairs, a list of applicable standard Boeing practices, and an explanation of the True Position Dimensioning symbols used.

An explanation of the use of the Illustrated Parts List is provided in the Introduction to that section.

All weights and measurements used in the manual are in English units, unless otherwise stated. When metric equivalents are given they will be in parentheses following the English units.

Design changes, optional parts, configuration differences and Service Bulletin modifications create alternate part numbers. These are identified in the Illustrated Parts List (IPL) by adding an alphabetical character to the basic item number. The resulting item number is called an alpha-variant. Throughout the manual, IPL basic item number references also apply to alpha-variants unless otherwise indicated.

DESCRIPTION AND OPERATION

NOTE: This manual contains overhaul data for various components of the outboard aileron installation. Overhaul functions which cannot be performed by use of standard industry practices are included in the repair instructions for each component.

DISASSEMBLY

NOTE: Disassemble this component only as necessary to complete fault isolation, determine the serviceability of parts, perform required repairs, and restore the unit to serviceable condition.

1. Disassemble using standard industry practices.

   NOTE: Do not remove bearings (55, 115), bushings (60, 75), lube fittings (80, 120) or inserts (85) unless repair or replacement is necessary (Ref IPL Fig. 1). Do not remove bearing (40, IPL Fig. 2) unless repair or replacement is necessary.

CHECK

1. Check all parts for obvious defects in accordance with standard industry practices.

2. Refer to FITS AND CLEARANCES for design dimensions and wear limits.

3. Magnetic particle check per 20-20-01 -- Pin (35), link (125) (IPL Fig. 1).

4. Penetrant check per 20-20-02 -- Link (65, IPL Fig. 1) trunnion (90, IPL Fig. 1), bellcrank (45, IPL Fig. 2).

REPAIR - GENERAL

1. Content

   A. Repair, refinish and replacement procedures are included in separate repair sections as follows:

P/N	NAME	REPAIR
252T1253	PIN	1-1
252T1270	LINK	2-1
252T1271	BELLCRANK	3-1
252T1272	REACTION LINK	4-1
252T1273	TRUNNION	5-1
- - -	MISC PARTS REFINISH	6-1

2. Standard Practices

   A. Refer to the following standard practices as applicable, for details of procedures in individual repairs.

   20-10-04 Grinding of Chrome Plated Parts
   20-30-02 Stripping of Protective Finishes
   20-41-01 Decoding Table for Boeing Finish Codes
   20-42-03 Hard Chrome Plating
   20-42-05 Bright Cadmium Plating
   20-43-01 Chromic Acid Anodizing
   20-50-03 Bearing Installation and Retention

3. Materials

   NOTE: Equivalent substitutes may be used.

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

   B. Grease -- MIL-G-23827 (Ref 20-60-03)

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

4. Dimensioning Symbols

A. Standard True Position Dimensioning Symbols used in applicable repair procedures are shown in Fig. 601.

—	STRAIGHTNESS
▱	FLATNESS
⊥	PERPENDICULARITY (OR SQUARENESS)
//	PARALLELISM
○	ROUNDNESS
⌭	CYLINDRICITY
⌒	PROFILE OF A LINE
⌓	PROFILE OF A SURFACE
◎	CONCENTRICITY
⌯	SYMMETRY
∠	ANGULARITY
↗	RUNOUT
⌖	THEORETICAL EXACT POSITION OF A FEATURE (TRUE POSITION)
∅	DIAMETER
BASIC (BSC) OR [DIM]	A THEORETICALLY EXACT DIMENSION USED TO DESCRIBE SIZE, SHAPE OR LOCATION OF A FEATURE FROM WHICH PERMISSIBLE VARIATIONS ARE ESTABLISHED BY TOLERANCES ON OTHER DIMENSIONS OR NOTES.
[-A-]	DATUM
Ⓜ	MAXIMUM MATERIAL CONDITION (MMC)
Ⓢ	REGARDLESS OF FEATURE SIZE (RFS)
Ⓟ	PROJECTED TOLERANCE ZONE

EXAMPLES

— 0.002	STRAIGHT WITHIN 0.002
⊥ B 0.002	PERPENDICULAR TO B WITHIN 0.002
// A 0.002	PARALLEL TO A WITHIN 0.002
○ 0.002	ROUND WITHIN 0.002
⌭ 0.010	CYLINDRICAL SURFACE MUST LIE BETWEEN TWO CONCENTRIC CYLINDERS, ONE OF WHICH HAS A RADIUS 0.010 INCH GREATER THAN THE OTHER
⌒ A 0.006	EACH LINE ELEMENT OF THE SURFACE AT ANY CROSS SECTION MUST LIE BETWEEN TWO PROFILE BOUNDARIES 0.006 INCH APART IN RELATION TO DATUM PLANE A
⌓ A 0.020	SURFACES MUST LIE WITHIN PARALLEL BOUNDARIES 0.02 INCH APART AND EQUALLY DISPOSED ABOUT TRUE PROFILE
◎ C ∅ 0.0005	CONCENTRIC TO C WITHIN 0.0005 DIAMETER (FULL INDICATOR MOVEMENT)
⌯ A 0.010	SYMMETRICAL WITH A WITHIN 0.010
∠ A 0.005	ANGULAR TOLERANCE 0.005 WITH A
⌖ B ∅ 0.002 Ⓢ	LOCATED AT TRUE POSITION WITHIN 0.002 DIA IN RELATION TO DATUM B, REGARDLESS OF FEATURE SIZE
⊥ A ∅ 0.010 Ⓜ 0.510 Ⓟ	AXIS IS TOTALLY WITHIN A CYLINDER OF 0.010-INCH DIAMETER, PERPENDICULAR TO, AND EXTENDING 0.510-INCH ABOVE, DATUM A, MAXIMUM MATERIAL CONDITION
[2.000] OR 2.000 BSC	EXACT DIMENSION IS 2.000

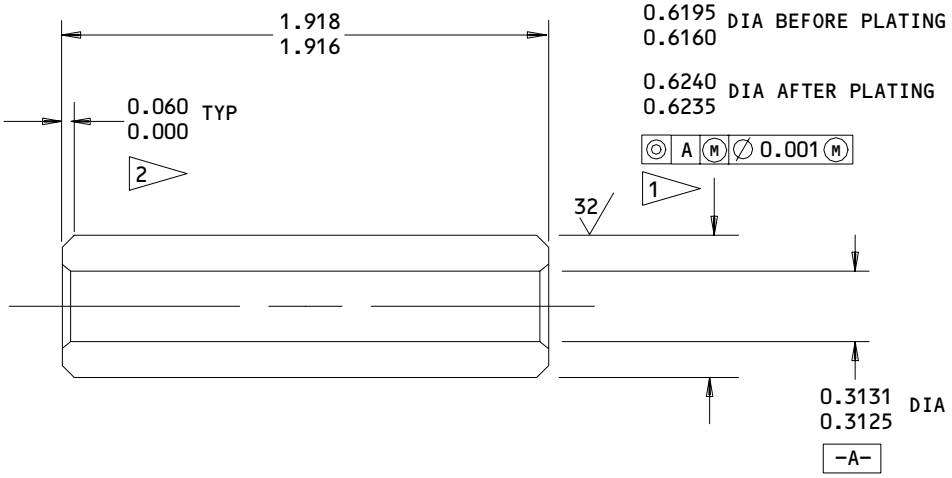
True Position Dimensioning Symbols
Figure 601

PIN - REPAIR 1-1

252T1253-2

1. Plating Repair

NOTE: Repair consists of stripping and restoration of original finish. Refer to Refinish instruction in Fig. 601 and to REPAIR-GEN for list of applicable standard practices.



REFINISH

PASSIVATE (F-17.09)

1 CHROMIUM PLATE (F-15.03) THIS SURFACE ONLY. 0.002-0.004 PLATING THICKNESS AFTER GRINDING

2 PLATING RUNOUT AREA

MATERIAL: 15-5 CRES, 180-200 KSI

ALL DIMENSIONS ARE IN INCHES

252T1253-2

Pin Refinish
Figure 601

7809

LINK ASSEMBLY - REPAIR 2-1

252T1270-1

NOTE: Refer to REPAIR-GEN for list of applicable standard practices. For repair of surfaces which may only require stripping and restoration of original finish, refer to Refinish instruction, Fig. 601.

1. Bushing Replacement

   A. Remove bushing (60, IPL Fig. 1)

   B. Install replacement bushing using shrink-fit method.

   C. Machine ID to dimension shown in Fig. 601.

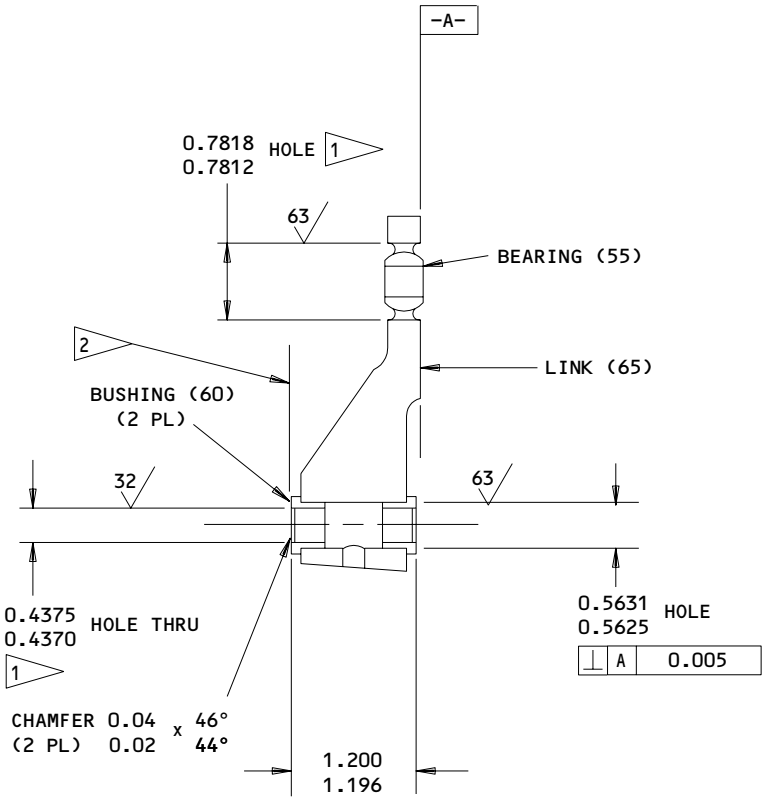
   D. Machine face of one bushing (observe flagnote 2, Fig. 601) to obtain indicated dimension between bushing faces, and chamfer as shown.

2. Bearing Replacement

   A. Remove bearing (55, IPL Fig. 1).

   B. Install replacement bearing and roller swage in place.

   C. Thoroughly lubricate with grease.



REFINISH

LINK (65):

CHROMIC ACID ANODIZE (F-17.04) AND APPLY ONE COAT OF PRIMER BMS 10-11, TYPE 1 (F-20.02) EXCEPT AS NOTED.

1 NO PRIMER ON THESE SURFACES

2 DO NOT MACHINE THIS SURFACE

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

ITEM NUMBERS REFER TO IPL FIG 1

252T1270-1
Link Assembly Repair
Figure 601

BELLCRANK ASSEMBLY - REPAIR 3-1

252T1271-1, -4

NOTE: Refer to REPAIR-GEN for list of applicable standard practices.

1. Bearing Replacement

   A. Remove bearing (40, IPL Fig. 2).

   B. Install replacement bearing using wet primer and roller swage in place.

2. Bearing Bore Rework (Fig. 601)

   A. Machine bore, within repair limits shown, as required to remove defects or if worn beyond service limit (Fig. 801).

   B. Manufacture bushing or bearing sleeve as shown.

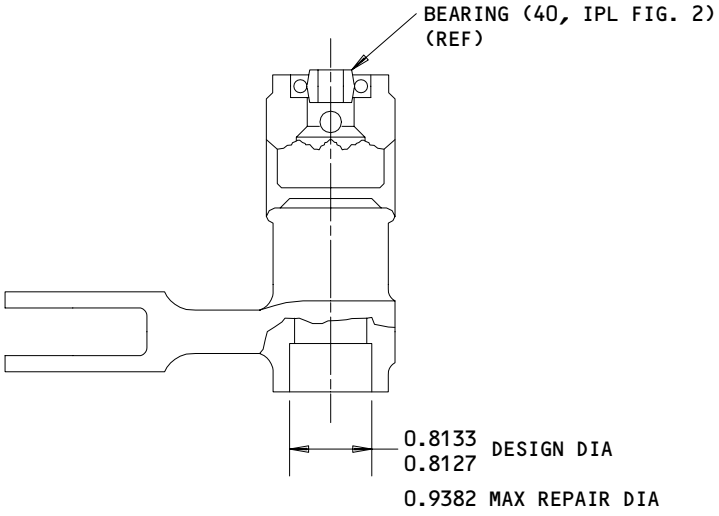
   C. Cadmium plate bushing 0.0003-0.0005 in. thick per 20-42-05.

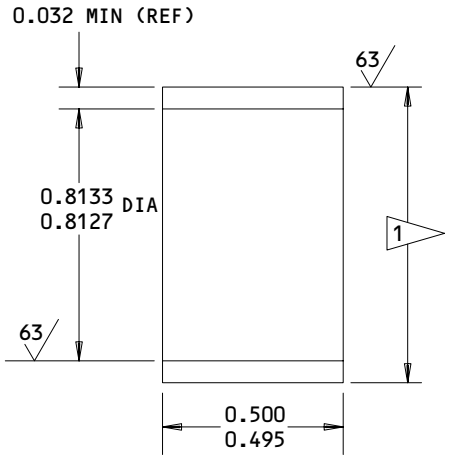
   D. Install bushing with wet sealant, BMS 5-95, per 20-50-03.

   E. If end of bushing is protruding, machine flush with bellcrank.

3. Refinish (Ref IPL Fig. 2)

   A. Bellcrank (45) -- Chromic acid anodize and apply one coat of primer (F-18.13) except no primer on surfaces of 0.8113-0.8118 in. and 0.8127-0.8133 in. diameter holes. Material: Aluminum alloy.





MANUFACTURED BUSHING

1 DIAMETER AFTER PLATING EQUAL TO REPAIR DIA OF BEARING BORE PLUS 0.0007-0.0021 INTERFERENCE

MATERIAL: AL-NI-BRONZE PER AMS 4640

ALL DIMENSIONS ARE IN INCHES

252T1271-1,-4
Bellcrank Assembly - Bearing Bore Repair
Figure 601

130786

REACTION LINK ASSEMBLY - REPAIR 4-1

252T1272-4

NOTE: Refer to REPAIR-GEN for list of applicable standard practices.

1. Bearing Replacement

   A. Remove bearing (115, IPL Fig. 1).

   B. Install replacement bearing and roller swage in place.

   C. Thoroughly lubricate with grease.

2. Refinish (IPL Fig. 1)

   A. Link (125) -- Passivate (F-17.09). Material: 15-5PH CRES, 180-200 ksi.

TRUNNION ASSEMBLY - REPAIR 5-1

252T1273-1

NOTE: Refer to REPAIR-GEN for list of applicable standard practices. For repair of surfaces which may only require stripping and restoration of original finish, refer to Refinish instruction, Fig. 601.

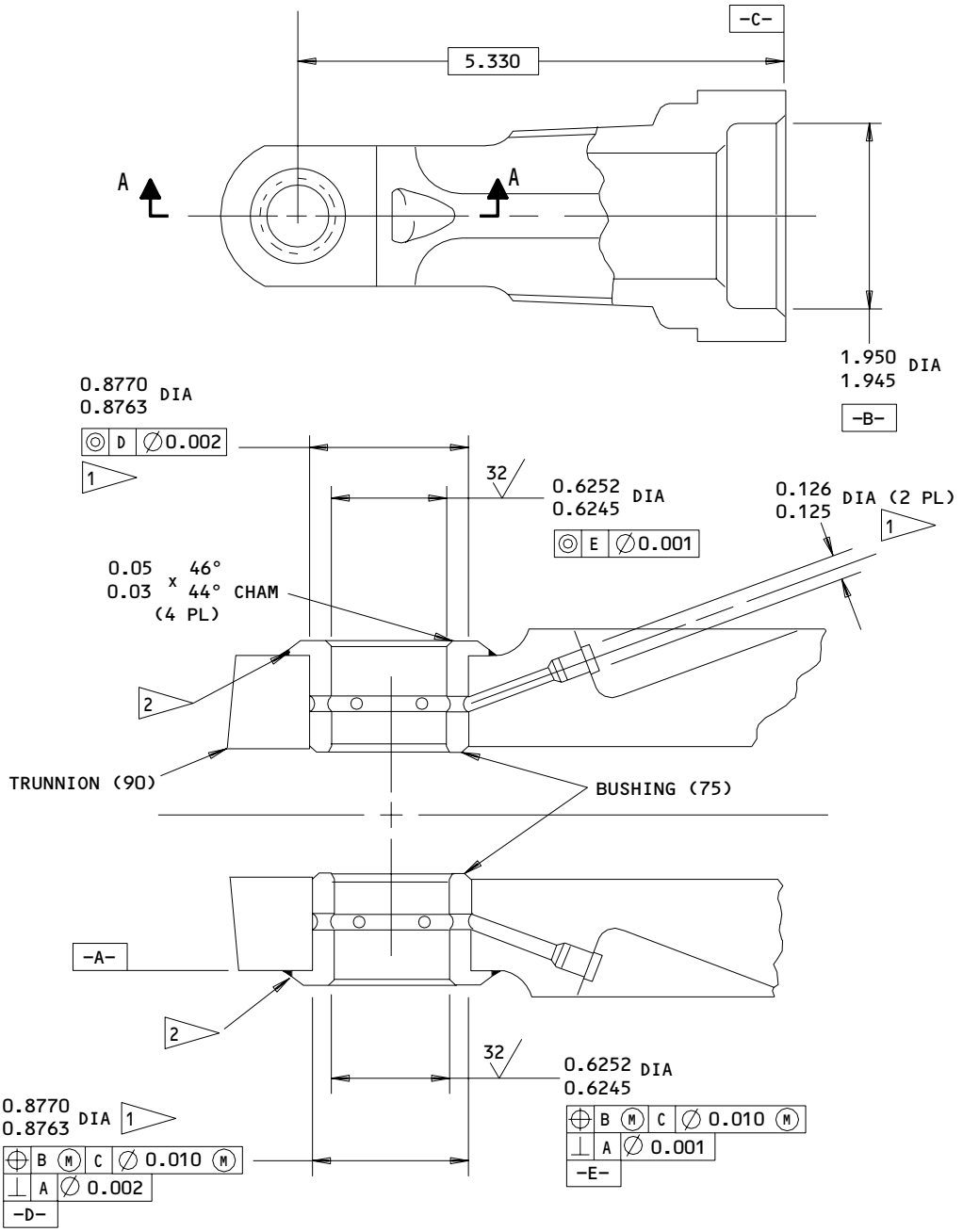
1. Bushing Replacement

A. Remove bushing (75, IPL Fig. 1).

B. Install replacement bushing using shrink-fit method.

C. Machine ID to dimension provided in Fig. 601 and chamfer as indicated.

D. Fillet seal bushing flanges with sealant.



A-A

REFINISH

TRUNNION (90):
CHROMIC ACID ANODIZE PLUS ONE COAT PRIMER (F-18.13) EXCEPT AS NOTED.

1 NO PRIMER THIS SURFACE

2 FILLET SEAL

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

ITEM NUMBERS REFER TO IPL FIG. 1

252T1273-1
Trunnion Assembly Repair
Figure 601

MISCELLANEOUS PARTS REFINISH - REPAIR 6-1

1. Repair of parts listed in Fig. 601 consists of restoration of the original finish.

IPL FIG. & ITEM	MATERIAL	FINISH
Fig. 2		
Filler (60,130, 155,250)	Al alloy	Alodize or chromic acid anodize. Apply one coat BMS 10-11, type 1 primer (SRF-2.30).
Bracket (65,93, 117,135,140,190, 210 thru 220,230, 280,300 thru 315, 325) Filler (160,255) Beam (235,330)	Al alloy	Chemical treat surface and apply one coat BMS 10-11, type 1 primer (F-18.06).
Bracket (115,205) Cleat (225,320)	Al alloy	Chromic acid anodize and apply one coat BMS 10-11, type 1 primer (F-18.13).

Refinish Details
Figure 601

ASSEMBLY

1. Materials

   NOTE: Equivalent substitutes may be used.

   A. Corrosion Preventive Compound -- MIL-C-16173, Grade 2 (Ref 20-60-03)

   B. Grease -- MIL-G-23827 (Ref 20-60-03)

2. Lubrication (IPL Fig. 1)

   A. Apply thin coat of corrosion preventive compound to mating threads of nut (95) and bearing (105).

   B. Thoroughly lubricate linkage assembly with grease applied through lube fittings in trunnion assembly (70). Rotate parts to ensure full coverage and wipe off excess.

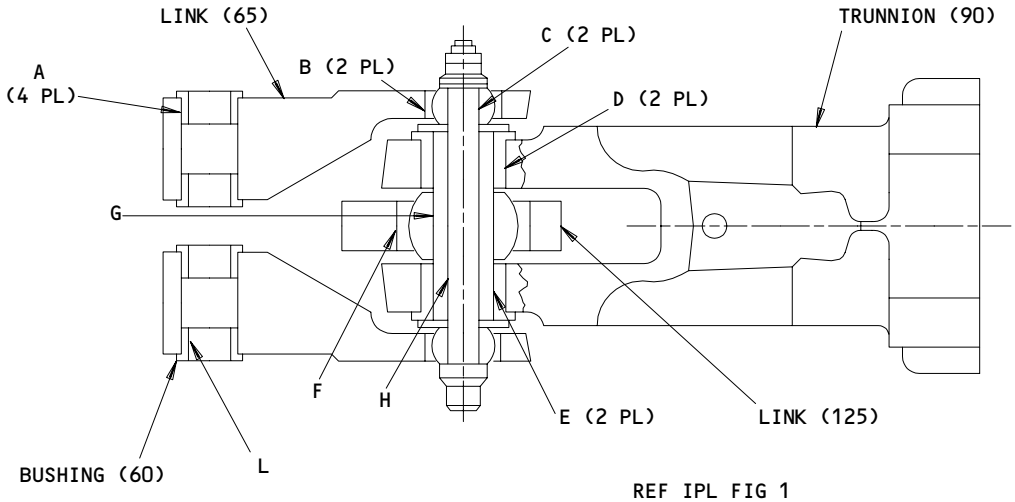
3. Assembly (IPL Fig. 1)

   A. Use standard industry practices for assembly of this component, observing special torque values given below.

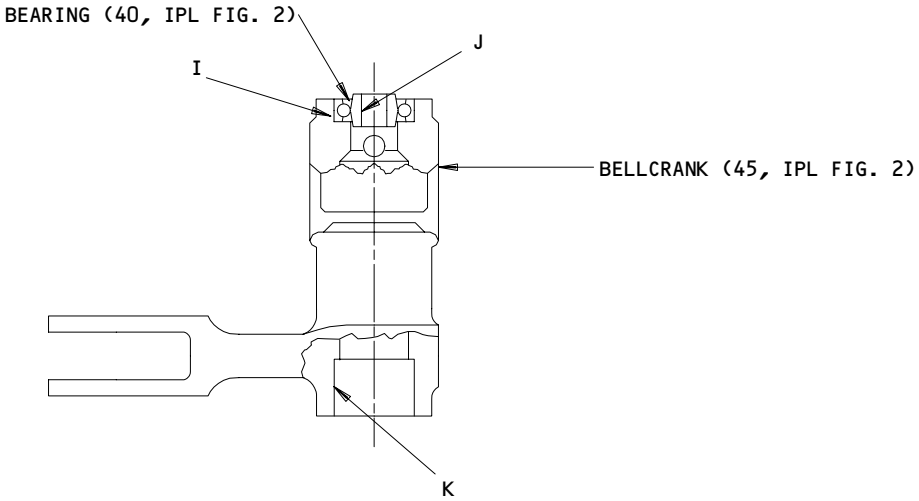
      (1) Tighten nut (45) to 130-200 lb-in.

      (2) Tighten nut (95) to 800-1000 lb-in.

FITS AND CLEARANCES



REF IPL FIG 1



Fits and Clearances
Figure 801 (Sheet 1)

Ref Letter Fig.801	Mating Item No. IPL Fig.	Design Dimension				Service Wear Limit		
		Dimension		Assembly Clearance *[1]		Dimension		Maximum Clearance
		Min	Max	Min	Max	Min	Max	
A	ID 65 OD 60	0.5625 0.5636	0.5631 0.5642	−0.0017	−0.0005			
B	ID 65 OD 55	0.7813 0.7808	0.7816 0.7813	0.0000	0.0008	0.7788	0.7843	0.0030
C	ID 55 OD 20	0.3125 0.3110	0.3129 0.3120	0.0005	0.0019	0.3099	0.3150	0.0030
D	ID 90 OD 75	0.8763 0.8776	0.8770 0.8783	−0.0020	−0.0006			
E	ID 75 OD 35	0.6245 0.6235	0.6252 0.6240	0.0005	0.0017	0.6222	0.6270	0.0030
F	ID 125 OD 115	1.3126 1.3119	1.3131 1.3125	0.0001	0.0012	1.3106	1.3150	0.0025
G	ID 115 OD 35	0.6250 0.6235	0.6254 0.6240	0.0010	0.0019	0.6224	0.6270	0.0030
H	ID 35 OD 20	0.3125 0.3110	0.3131 0.3120	0.0005	0.0021	0.3101	0.3150	0.0030
I	ID 45 *[2] OD 40 *[2]	0.8113 0.8121	0.8118 0.8125	−0.0012	−0.0003			
J	ID 40 *[2]	0.3122	0.3125				0.3150	
K	ID 45 *[2]	0.8127	0.8133				0.8150	
L	ID 60	0.4370	0.4375				0.4395	

*[1] NEGATIVE VALUES DENOTE INTERFERENCE FIT

*[2] IPL FIGURE 2

ALL DIMENSIONS ARE IN INCHES

Fits and Clearances
Figure 801 (Sheet 2)

FOR TORQUE VALUES OF STANDARD FASTENERS, REFER TO 20-50-01			
ITEM NO. IPL FIG. 1	NAME	TORQUE	
		POUND-INCHES	POUND-FEET
45	NUT	130-200	
95	NUT	800-1000	

Torque Table
Figure 802

ILLUSTRATED PARTS LIST

1. This section lists and illustrates replaceable or repairable component parts. The Illustrated Parts Catalog contains a complete explanation of the Boeing part numbering system.

2. Indentures show parts relationships as follows:

    Assembly
      Detail Parts for Assembly
      Subassembly
      Attaching Parts for Subassembly
        Detail Parts for Subassembly

    Detail Installation Parts (Included only if installation parts may be returned to shop as part of assembly)

3. One use code letter (A, B, C, etc.) is assigned in the EFF CODE column for each variation of top assembly. All listed parts are used on all top assemblies except when limitations are shown by use code letter opposite individual part entries.

4. Letter suffixes (alpha-variants) are added to item numbers for optional parts, Service Bulletin modification parts, configuration differences (except left- and right-hand parts), product improvement parts, and parts added between two sequential item numbers. The alpha-variant is not shown on illustrations when appearance and location of all variants of the part is the same.

5. Service Bulletin modifications are shown by the notations PRE SB XXXX and POST SB XXXX.

    A. When a new top assembly part number is assigned by Service Bulletin, the notations appear at the top assembly level only. The configuration differences at detail part level are then shown by use code letter.

    B. When the top assembly part number is not changed by the Service Bulletin, the notations appear at the detail part level.

6. Parts Interchangeability

Optional (OPT)	The parts are optional to and interchangeable with other parts having the same item number.
Supersedes, Superseded By (SUPSDS, SUPSD BY)	The part supersedes and is not interchangeable with the original part.
Replaces, Replaced By (REPLS, REPLD BY)	The part replaces and is interchangeable with, or is an alternate to, the original part.

VENDORS

06710 VALLEY-TODECO INCORPORATED
12975 BRADLEY AVENUE
SYLMAR, CALIFORNIA 91342-3830
FORMERLY IN NORTH HOLLYWOOD, CALIFORNIA
FORMERLY VALLEY BOLT CORP VB0097

06725 AIR INDUSTRIES CORPORATION
12570 KNOTT STREET
GARDEN GROVE, CALIFORNIA 92641-3932
FORMERLY AIR INDUSTRIES OF CALIF IN GARDENA, CALIF.

06950 SCREWCORP VSI CORP AEROSPACE PRODUCTS DIV FAIRCHILD IND INC
13001 EAST TEMPLE AVE. PO BOX 730
CITY OF INDUSTRY, CALIFORNIA 91746-1417
FORMERLY SCREWCORP VB0096 AND VSI CORP SCREWCORP DIV
FORMERLY IN CULVER CITY, CALIFORNIA

08524 DEUTSCH FASTENER CORP
1315 E GRAND AVE
EL SEGUNDO, CALIFORNIA 90245-4323
FORMERLY IN LOS ANGELES, CALIFORNIA

09455 LEAR SIEGLER INC TRANSPORT DYNAMICS DIV
PO BOX 1953 3131 WEST SEGERSTROM STREET
SANTA ANA, CALIFORNIA 92702
FORMERLY TRANSPORT DYNAMICS AEROSPACE DIVN
FORMERLY FABROID DIVN TRANSPORT DYNAMICS V17571
FORMERLY LEAR SIEGLER INC TRANS SPT DIV V98076

10630 ANILLO INDUSTRIES, INCORPORATED
2090 NORTH GLASSELL
ORANGE, CALIFORNIA 92667
FORMERLY WESTERN WASHER DIV OF SENG CO V87487

11815 TOWNSEND DIV OF TEXTRON INC CHERRY FASTENER UNIT
BOX 2157 1224 EAST WARNER AVENUE
SANTA ANA, CALIFORNIA 92707
FORMERLY IN LOS ANGELES, CALIFORNIA
FORMERLY CHERRY FASTENERS TOWNSEND DIV OF TEXTRON INC V71087

15653 KAYNAR MICRODOT AEROSPACE FASTENING SYSTEM
800 SOUTH COLLEGE BLVD PO BOX 3001
FULLERTON, CALIFORNIA 92634
FORMERLY MICRODOT AEROSPACE FASTENING SYS DIV OF MICRODOT
INC IN PICO RIVERA, CALIFORNIA

VENDORS

15860 NEW HAMPSHIRE BALL BEARINGS, INCORPORATED ASTRO DIVISION
155 LEXINGTON AVENUE
LACONIA, NEW HAMPSHIRE 03246-2937
FORMERLY ASTRO BEARING CORP, LOS ANGELES, CALIF.

17943 FEDERAL MANUFACTURING CORPORATION
6910 FARMDALE AVENUE
NORTH HOLLYWOOD, CALIFORNIA 91605-6210
FORMERLY VB0098

21335 TEXTRON INC FAFNIR BEARING DIVISION
37 BOOTH STREET
NEW BRITAIN, CONNECTICUT 06050
FORMERLY FAFNIR BRG CO DIV OF TEXTRON INC

23294 AVALON MACHINE PRODUCTS INC
15337 ALLEN STREET
PARAMOUNT, CALIFORNIA 90723-4011

23589 NIPPON MINATURE BEARING CORP SEE NMB CORP V50294

27238 BRISTOL INDUSTRIES
630 EAST LAMBERT ROAD PO BOX 630
BREA, CALIFORNIA 92621-4119

27624 PAUL R BRILES INC P.B. FASTENER DIV
1700 WEST 132ND STREET PO BOX 1157
GARDENA, CALIFORNIA 90249-2008
FORMERLY P.B. FASTENER DIV OF PAUL BRILLES INC

38443 TRW INC BEARING DIV
402 CHANDLER STREET
JAMESTOWN, NEW YORK 14701-3802
FORMERLY MARLIN-ROCKWELL CORP DIV TRW INC

43991 FAG BEARING INCORPORATED
118 HAMILTON AVENUE
STAMFORD, CONNECTICUT 06904
FORMERLY NORMA-HOFFMAN BEARING CORPORATION
FORMERLY NORMA FAG BEARINGS CORPORATION

50294 NEW HAMPSHIRE BALL BEARINGS INC
9730 INDEPENDENCE AVENUE PO BOX 2515
CHATSWORTH, CALIFORNIA 91311-4323
FORMERLY NIPPON MINATURE BEARING CORP V23589 AND NMB
AMERICA INC AND NMB INC

VENDORS

52828 REPUBLIC FASTENER MFG CORP
1300 RANCHO CONEJO BLVD
NEWBURY PARK, CALIFORNIA 91320-1405
FORMERLY IN SYLMAR, CALIFORNIA

56878 SPS TECHNOLOGIES INC AEROSPACE AND INDUSTRIAL PRODUCTS DIV
HIGHLAND AVENUE
JENKINTOWN, PENNSYLVANIA 19046
USE APPLICABLE FACILITY CODE
FORMERLY STANDARD PRESSED STEEL

70265 ALL POWER MANUFACTURING COMPANY
13141 MOLETTE STREET
SANTA FE SPRINGS, CALIFORNIA 90670-5523
FORMERLY IN MONTEBELLO, CALIFORNIA

71087 BOOTS ACFT NUT DIV TOWNSEND CO SEE TEXTRON INC CHERRY
FASTENER TOWNSEND DIV V11815

72962 ELASTIC STOP NUT A DIV OF HARTFORD INDUSTRIES INC
2330 VAUXHALL ROAD
UNION, NEW JERSEY 07083-5038
FORMERLY AMERACE CORP ESNA DIV

73134 HEIM DIV INCOM INTERNATIONAL INC
60 ROUND HILL ROAD PO BOX 430
FAIRFIELD, CONNECTICUT 06430-5114
FORMERLY INCOM INTERNATIONAL INC HEIM DIV
FORMERLY HEIM UNIVERSAL CORP INCOM INTERNATIONAL INC

73197 HI-SHEAR TECHNOLOGY CORP
2600 SKYPARK DRIVE
TORRANCE, CALIFORNIA 90509

77896 REXNORD INC BEARING OPERATION
2400 CURTIS STREET
DOWNERS GROVE, ILLINOIS 60515-4005
FORMERLY SHAEFER BEARING DIV REX CHAINBELT
FORMERLY REX CHAINBELT INC BEARING DIV.

80539 SPS TECHNOLOGIES INC AEROSPACE PRODUCTS DIV
2701 SOUTH HARBOR BOULEVARD PO BOX 1259
SANTA ANA, CALIFORNIA 92702-1259
FORMERLY NUTT-SHEL DIV OF SPC WESTERN CO V80539 AND STANDARD
PRESSED STEEL WESTERN DIV V17279

VENDORS

92215 VOI-SHAN DIV OF VSI CORP SUB OF FAIRCHILD INDUSTRIAL INC
8463 HIGUERA STREET
CULVER CITY, CALIFORNIA 90230

93907 TEXTRON INC CAMCAR DIV
600 18TH AVENUE
ROCKFORD, ILLINOIS 61101

94892 MASTER MACHINE PRODUCTS CORPORATION
1551 SOUTH PRIMROSE AVE
MONROVIA, CALIFORNIA 91016-4542
FORMERLY IN HUNTINGTON PARK, CALIFORNIA

97613 SARGENT INDUSTRIES KAHR BEARING DIVISION
3010 NORTH SAN FERNANDO ROAD
BURBANK, CALIFORNIA 91503
FORMERLY AETNA STEEL PROD KAHR BEARING DIV V96579

97928 DEUTSCH FASTENER CORP
3969 PARAMONT BOULEVARD
LAKEWOOD, CALIFORNIA 90712
FORMERLY DUMONT AVIATION ASSOC IN LONG BEACH, CALIFORNIA
FORMERLY LITTON FASTENING SYSTEMS DIV OF LITTON SYSTEMS INC

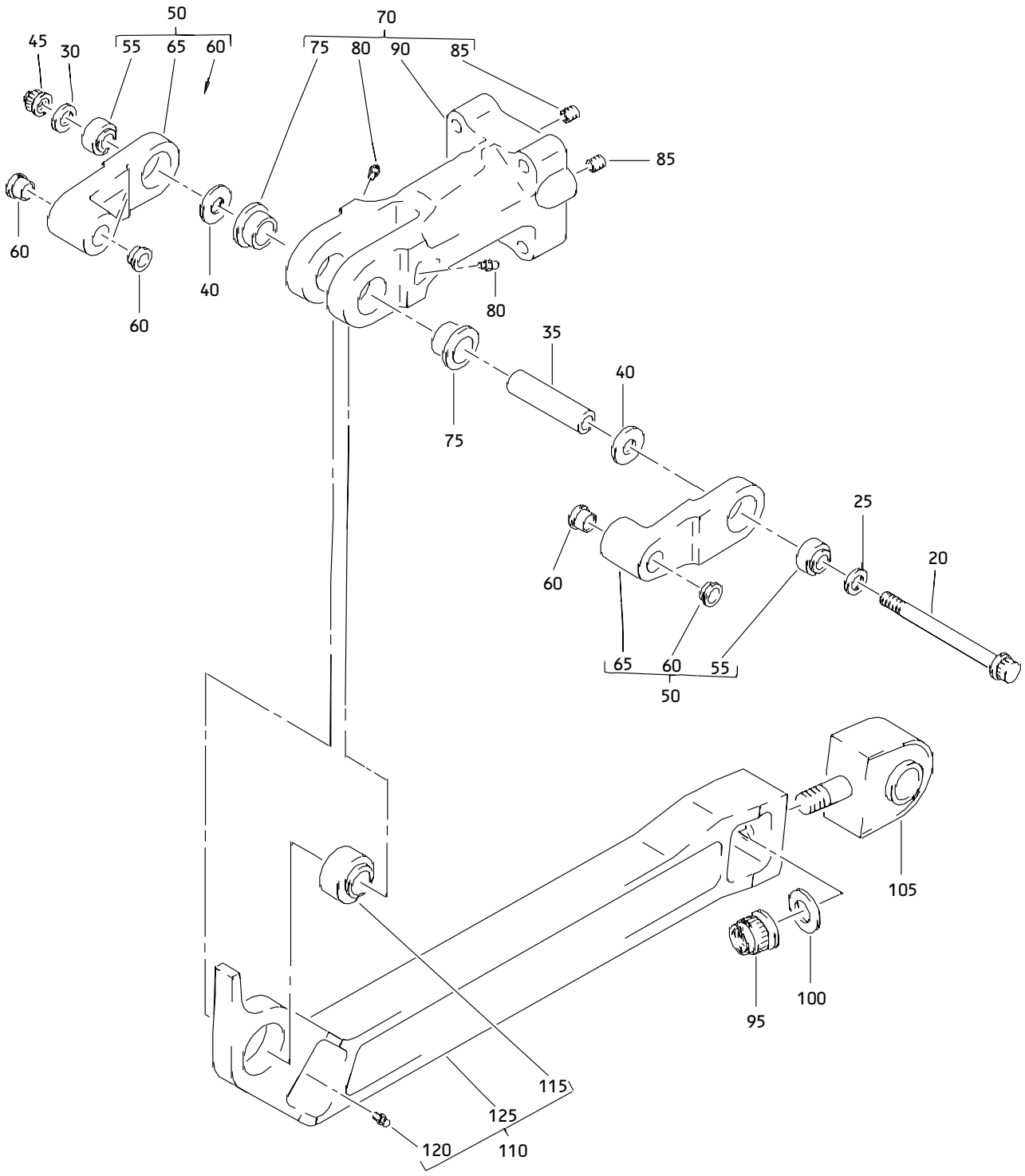
PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
AG10V28C		1	115	1
AG5V28C		1	55	2
AN960PD516		2	15	2
AN960PD516L		2	10	4
ASBEP05VC		1	55	2
ASBEP10VC		1	115	1
BACB10AP5		2	30	2
		2	40	2
BACB10EP05GC		1	55	2
BACB10EP10GC		1	115	1
BACB10FS5R		2	30A	2
		2	40A	2
BACB28AM07B025A		1	60	4
BACB30LE5-46		1	20	1
BACB30LJ5-56		2	5	2
BACB30MY6K3		2	170	4
BACC30M6		2	175	4
BACN10HR5CS		1	45	1
BACN10HR9CS		1	95	1
BACN10JC5		2	25	2
BACN10KH3		2	80	2
		2	110	2
		2	185	2
		2	275	4
BACR15BA3AD		2	55	2
		2	75	4
		2	105	4
		2	125	2
		2	150	5
		2	180	4
		2	245	5
		2	270	8

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACR15BA5AD		2	200	13
		2	285	1
BACR15BB5AD		2	295	16
BACR15FT5AD		2	265	4
BACR15FT6AD		2	70	2
		2	100	2
		2	195	2
		2	290	1
BACW10BP5CD		1	25	1
BACW10BP5DP		1	30	1
BACW10BP9DP		1	100	1
BH00303-5		1	45	1
BMN5024CPD3-5		1	45	1
BMN5024CPD3-9		1	95	1
BMN5024CPD5		1	45	1
BMN5024CPD9		1	95	1
BRH10A5		2	25	2
B30MY6K3		2	170	4
F29779-3		2	80	2
		2	110	2
		2	185	2
		2	275	4
HL10VAZ6-3		2	170	4
HL79-6		2	175	4
H10-5BAC		2	25	2
H39953-5		1	45	1
H39953-9		1	95	1
KSB5-52-58		1	55	2
LHB10GC		1	115	1
LLMKP5A		2	30	2
		2	40	2
L8006K3		2	170	4

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
MKP5A		2	30	2
		2	40	2
MKP5AFS428		2	30	2
		2	40	2
MKP5AG20		2	30	2
		2	40	2
MKP5ATT		2	30	2
		2	40	2
MKP5A2TS		2	30	2
		2	40	2
MKP5E6531		2	30	2
		2	40	2
MS21209F1-15		1	85	2
NAS43DD5-173		2	20	2
NAS516-1A		1	80	2
		1	120	1
NS103225-02		2	80	2
		2	110	2
		2	185	2
		2	275	4
RMF9209M3		2	80	2
		2	110	2
		2	185	2
		2	275	4
RMLH9075-5W		2	25	2
SL7059C524		1	45	1
S012T236-1		1	105	1
S012T236-13		1	105A	1
T6S524J		2	25	2
03-525-05E003C		1	55	2
03-525-10E003C		1	115	1
109LH9031-5		1	45	1
109LH9031-9		1	95	1
252T1200-5		1	5A	RF
		2	1	RF
252T1200-6		1	5B	RF
		2	1A	RF
252T1200-7		1	5C	RF
		2	1B	RF
252T1200-8		1	5D	RF
		2	1C	RF

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
252T1200-9		1	5E	RF
		2	1D	RF
252T1211-1		1	10	RF
252T1213-11		2	50	1
252T1213-15		2	145	1
252T1213-16		2	240	1
252T1213-17		2	50A	1
252T1213-19		2	50B	1
252T1213-3		2	120	1
252T1213-5		2	120A	1
252T1213-6		2	160	1
		2	255	1
252T1230-1		2	315	1
252T1230-10		2	305	1
252T1230-12		2	93	1
252T1230-14		2	220	1
252T1230-15		2	230	1
		2	325	1
252T1230-16		2	117	1
252T1230-2		2	140	1
252T1230-3		2	230A	1
252T1230-5		2	210	1
252T1230-6		2	215	1
252T1230-7		2	135	1
252T1230-9		2	310	1
252T1232-1		2	225	1
		2	320	1
252T1233-1		2	235	1
		2	330	1
252T1250-2		1	75	2
252T1252-1		1	40	2
252T1253-2		1	35	1
252T1270-1		1	50	2
252T1270-2		1	65	1
252T1271-1		2	35	2
252T1271-2		2	45	2
252T1271-4		2	35A	2
252T1272-4		1	110	1
252T1272-5		1	125	1
252T1273-1		1	70	1
252T1273-2		1	90	1
272T1272-1		2	95	1
272T1272-2		2	115	1
272T1273-1		2	260	2
272T1273-2		2	280	2

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
272T1273-3		2	300	1
272T1410-1		2	65	1
272T1410-2		2	165	1
272T1410-3		2	85	1
272T1410-4		2	190	1
272T1410-5		2	65A	1
272T1410-6		2	90	1
272T1414-2		2	205	1
50-3361-4222		2	60	2
		2	130	2
		2	155	4
		2	250	4
67832AS524		1	45	1
67832AS918		1	95	1
96-054		2	25	2



Outboard Aileron Components
Figure 1

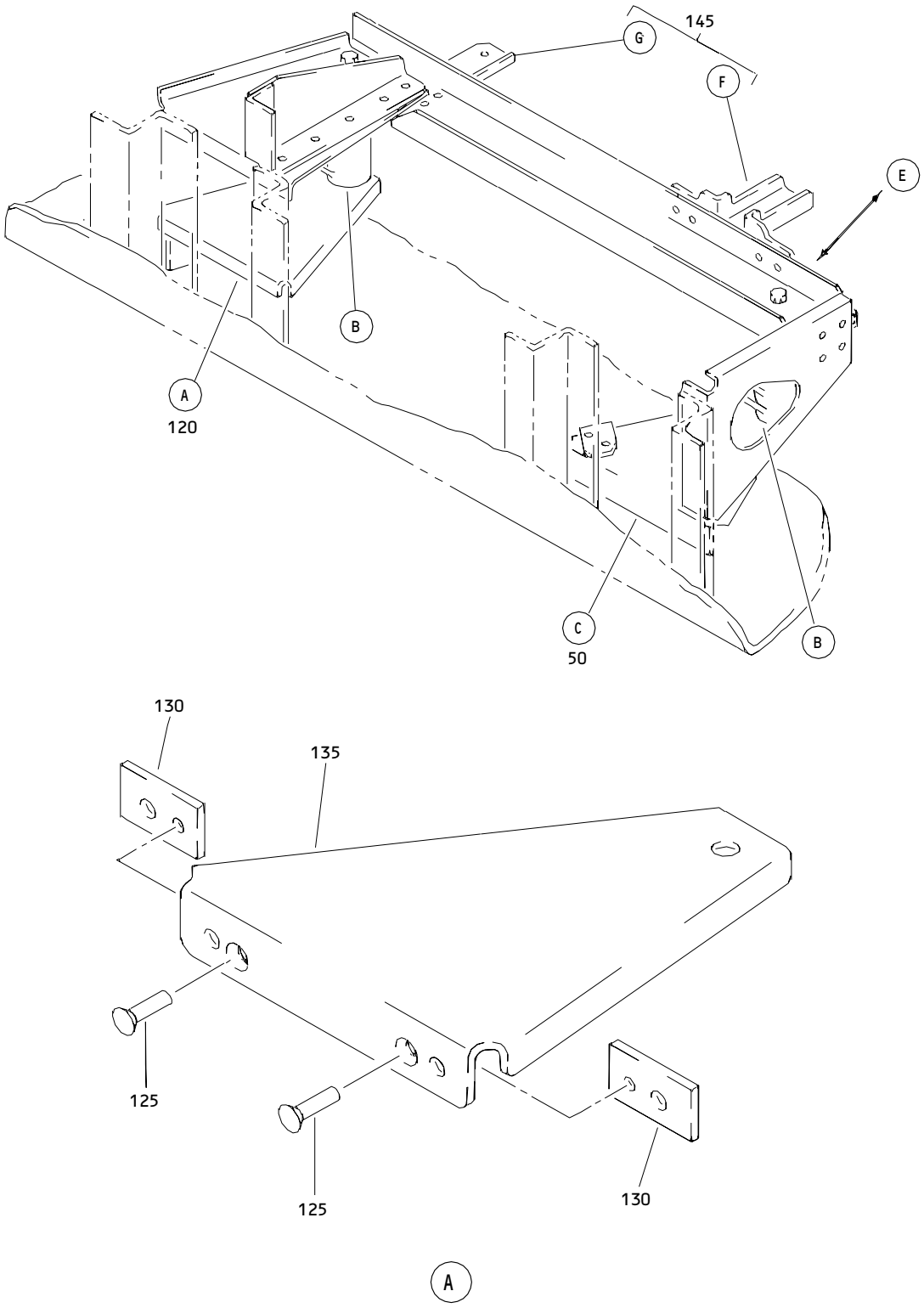
T54879

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-			OUTBOARD AILERON COMPONENTS		
	-5	252T1271-1		DELETED		
	-5A	252T1200-5		BRACKET ASSY-OUTBD AIL. ACTR (FOR DETAILS SEE FIG. 2)	C	RF
	-5B	252T1200-6		BRACKET ASSY-OUTBD AIL. ACTR (FOR DETAILS SEE FIG. 2)	D	RF
	-5C	252T1200-7		BRACKET ASSY-OUTBD AIL. ACTR (FOR DETAILS SEE FIG. 2)	E	RF
R	-5D	252T1200-8		BRACKET ASSY-OUTBD AIL. ACTR (FOR DETAILS SEE FIG. 2)	F	RF
R	-5E	252T1200-9		BRACKET ASSY-OUTBD AIL. ACTR (FOR DETAILS SEE FIG. 2)	G	RF
	-10	252T1211-1		LINKAGE ASSY-OUTBD AIL. ACTUATOR	B	RF
	20	BACB30LE5-46		.BOLT- (V06710) (SPEC BACB30LE5-46) (OPT BACB30LE5-46 (V06725)) (OPT BACB30LE5-46 (V08524)) (OPT BACB30LE5-46 (V17943)) (OPT BACB30LE5-46 (V27624)) (OPT BACB30LE5-46 (V80539)) (OPT BACB30LE5-46 (V92215)) (OPT BACB30LE5-46 (V93907)) (OPT BACB30LE5-46 (V97928))	B	1

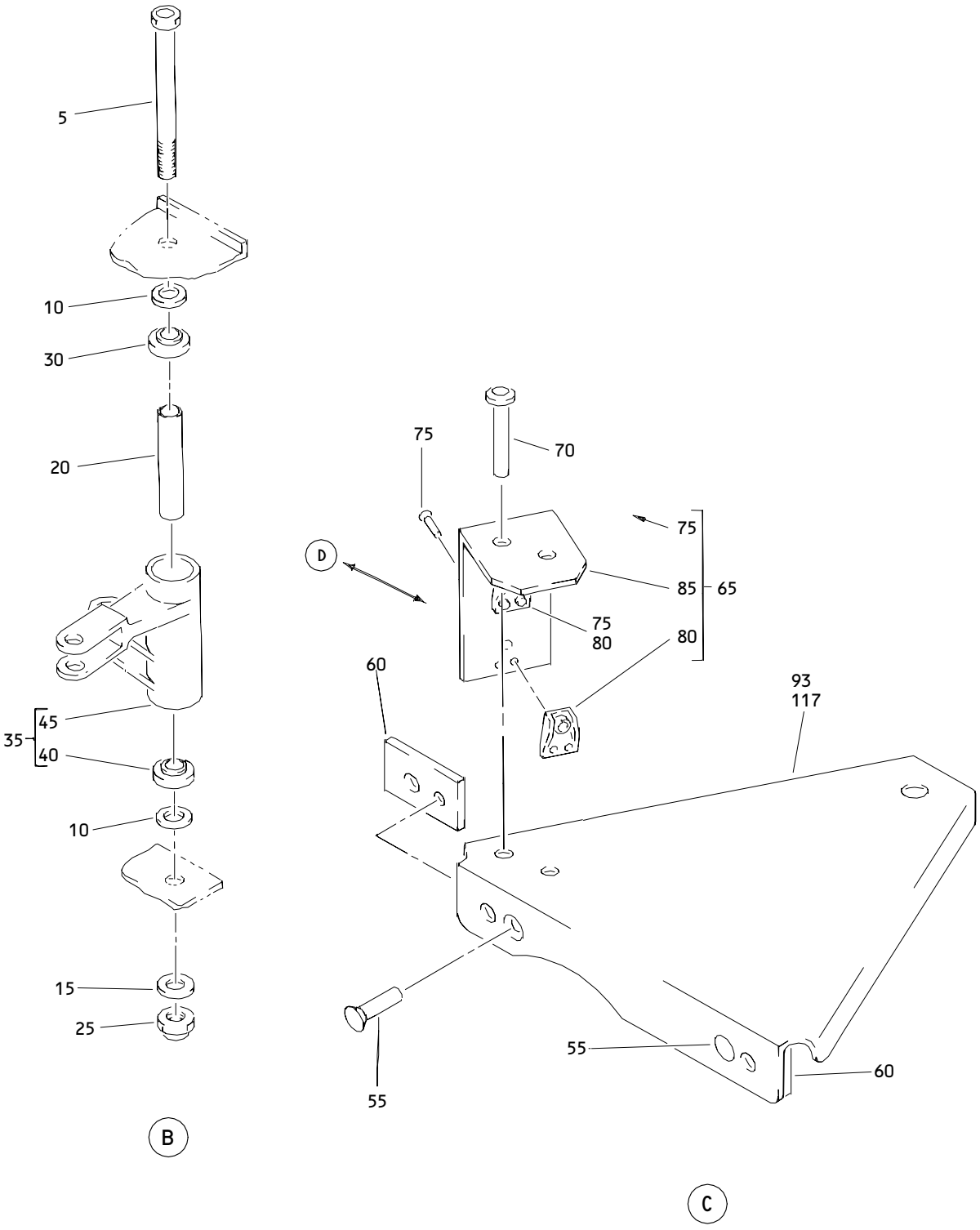
FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
25	BACW10BP5CD		.WASHER- (V10630) (SPEC BACW10BP5CD)	B	1
30	BACW10BP5DP		.WASHER- (V10630) (SPEC BACW10BP5DP)	B	1
35	252T1253-2		.PIN	B	1
40	252T1252-1		.WASHER	B	2
45	BMN5024CPD5		.NUT- (V08524) (SPEC BACN10HR5CS) (OPT H39953-5 (V15653)) (OPT SL7059C524 (V11815)) (OPT 109LH9031-5 (V72962)) (OPT 67832AS524 (V56878)) (OPT BMN5024CPD3-5 (V08524)) (OPT BH00303-5 (V27238))	B	1
50	252T1270-1		.LINK ASSY	B	2
55	AG5V28C		..BEARING- (V15860) (SPEC BACB10EP05GC) (OPT ASBEP05VC (V50294)) (OPT KSB5-52-58 (V97613)) (OPT LHB05EPGC (V73134)) (OPT 03-525-05E003C (V09455))	B	1
60	BACB28AM07B025A		..BUSHING- (V23294) (SPEC BACB28AM07B025A) (OPT BACB28AM07B025A (V70265)) (OPT BACB28AM07B025A (V94892))	B	2

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	65	252T1270-2		..LINK	B	1
	70	252T1273-1		.TRUNNION ASSY	B	1
	75	252T1250-2		..BUSHING	B	2
	80	NAS516-1A		..FITTING-LUBE	B	2
	85	MS21209F1-15		..INSERT	B	2
	90	252T1273-2		..TRUNNION	B	1
	95	BMN5024CPD9		.NUT- (V08524) (SPEC BACN10HR9CS) (OPT H39953-9 (V15653)) (OPT 109LH9031-9 (V72962)) (OPT 67832AS918 (V56878)) (OPT BMN5024CPD3-9 (V08524))	B	1
	100	BACW10BP9DP		.WASHER- (V10630) (SPEC BACW10BP9DP)	B	1
	105	DMD10-9A1-501		.BEARING- (V77896) (SPEC S012T236-1) (OPT ITEM 105A)	B	1
R	-105A	DMD10-9A1-502		.BEARING- (V77896) (SPEC S012T236-13) (OPT ITEM 105)	B	1
	110	252T1272-4		.LINK ASSY-REACTION	B	1

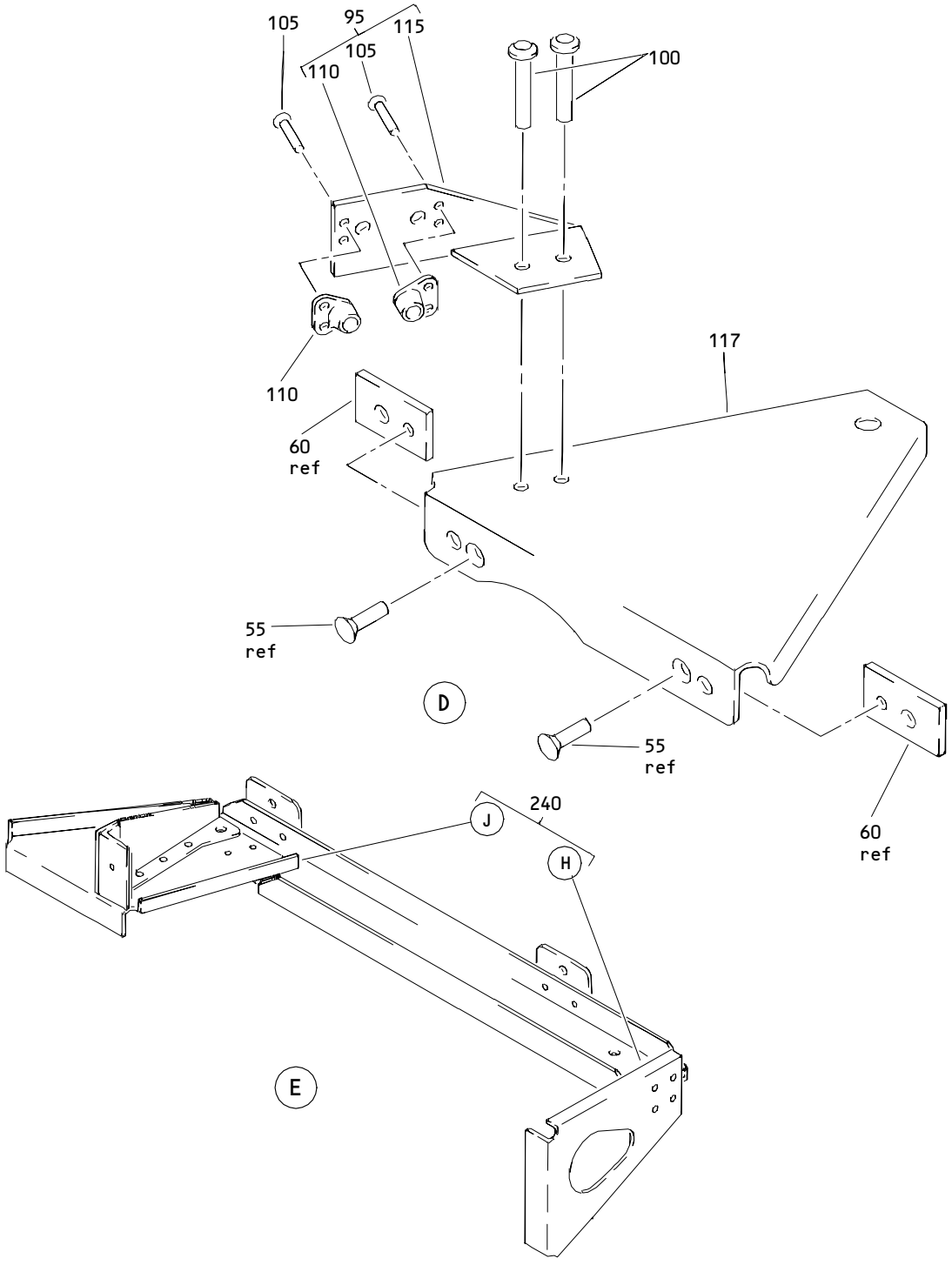
FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01- 115	AG10V28C		..BEARING- (V15860) (SPEC BACB10EP10GC) (OPT ASBEP10VC (V23589)) (OPT KSB10-58 (V97613)) (OPT LHB10GC (V73134)) (OPT 03-525-10E003C (V09455))	B	1
120	NAS516-1A		..FITTING-LUBE	B	1
125	252T1272-5		..LINK	B	1



Outboard Aileron Actuator Bracket Assembly
Figure 2 (Sheet 1)

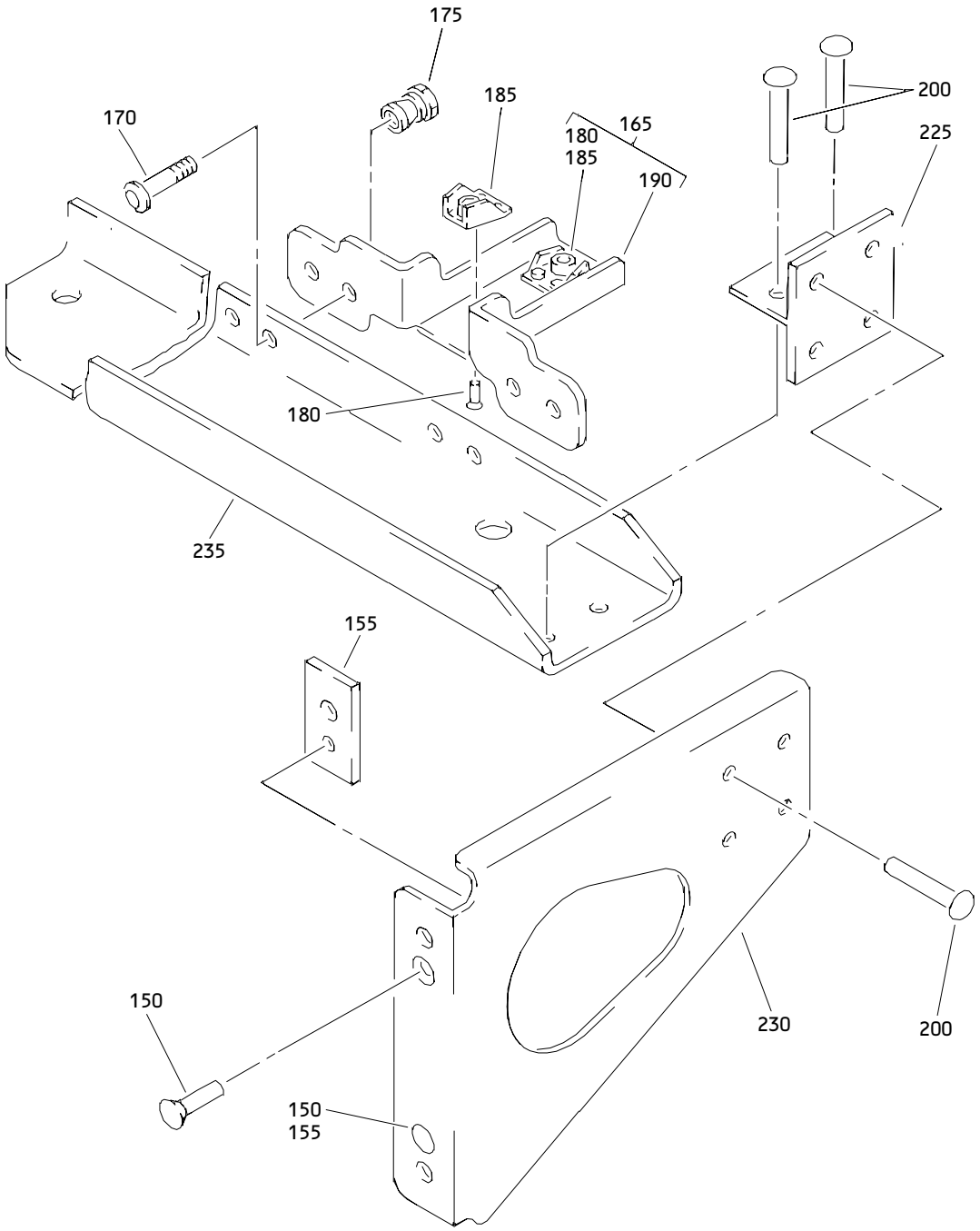


Outboard Aileron Actuator Bracket Assembly
Figure 2 (Sheet 2)

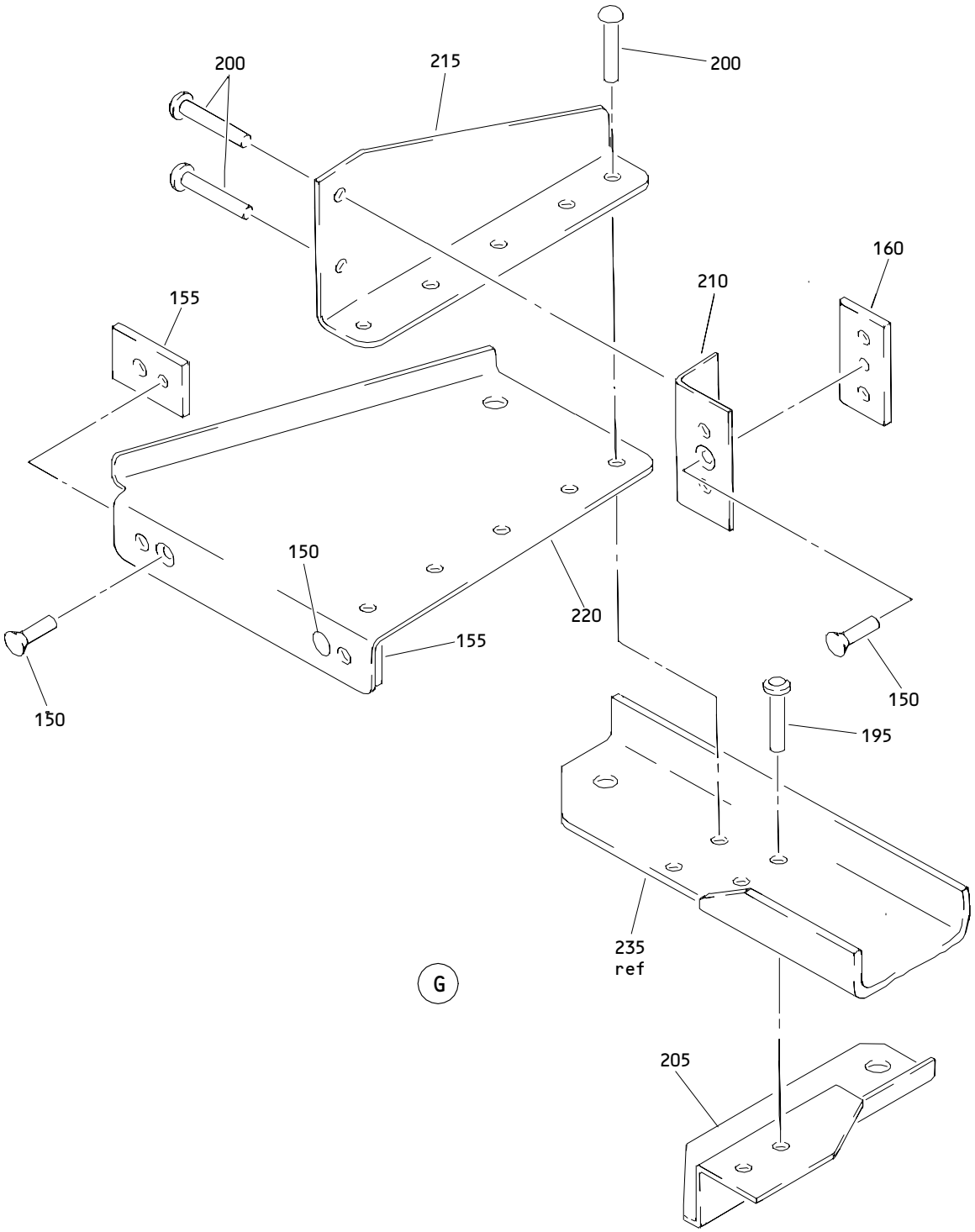


Outboard Aileron Actuator Bracket Assembly
Figure 2 (Sheet 3)

157122

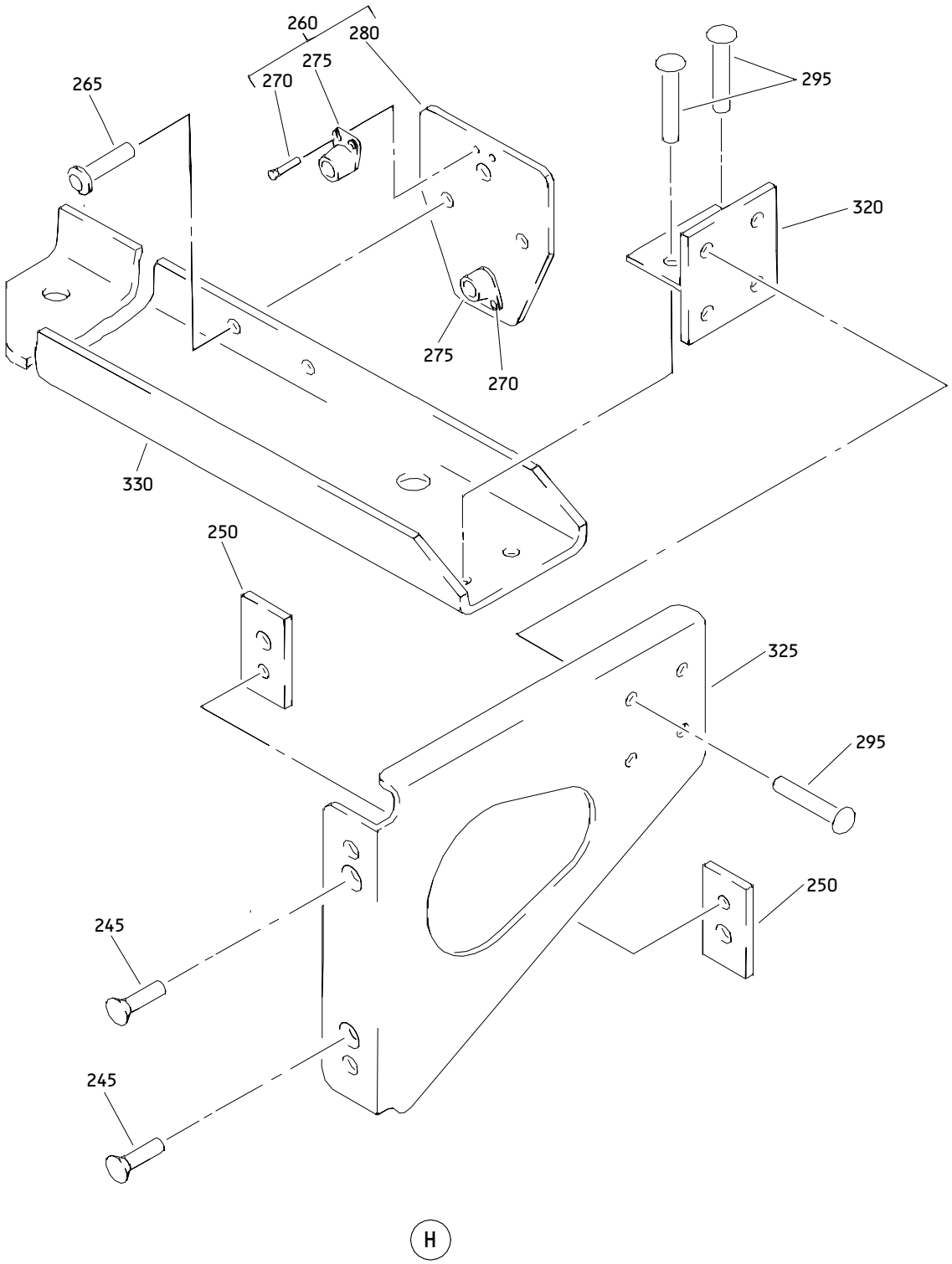


Outboard Aileron Actuator Bracket Assembly
Figure 2 (Sheet 4)

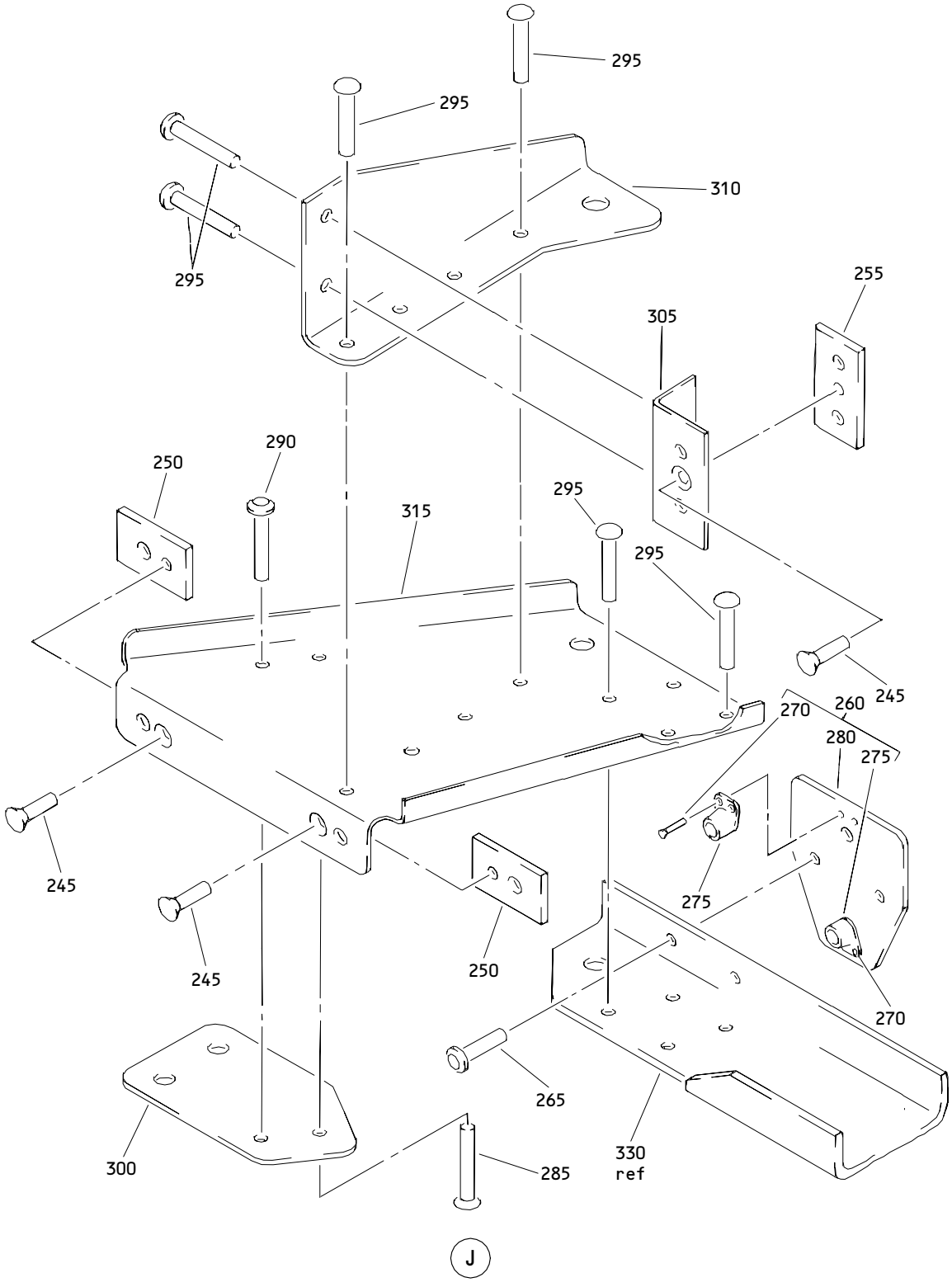


Outboard Aileron Actuator Bracket Assembly
Figure 2 (Sheet 5)

157126



Outboard Aileron Actuator Bracket Assembly
Figure 2 (Sheet 6)



Outboard Aileron Actuator Bracket Assembly
Figure 2 (Sheet 7)

157148

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	02-					
	-1	252T1200-5		BRACKET ASSY-OUTBD AIL. ACTR	C	RF
	-1A	252T1200-6		BRACKET ASSY-OUTBD AIL. ACTR	D	RF
	-1B	252T1200-7		BRACKET ASSY-OUTBD AIL. ACTR	E	RF
R	-1C	252T1200-8		BRACKET ASSY-OUTBD AIL. ACTR	F	RF
R	-1D	252T1200-9		BRACKET ASSY-OUTBD AIL. ACTR	G	RF
	5	BACB30LJ5-56		.BOLT- (V06710) (SPEC BACB30LJ5-56) (OPT BACB30LJ5-56 (V06725)) (OPT BACB30LJ5-56 (V06950)) (OPT BACB30LJ5-56 (V08524)) (OPT BACB30LJ5-56 (V17943)) (OPT BACB30LJ5-56 (V80539)) (OPT BACB30LJ5-56 (V27624)) (OPT BACB30LJ5-56 (V92215)) (OPT BACB30LJ5-56 (V97928))	C-G	2

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	02-					
	10	AN960PD516L		.WASHER	C-G	4
	15	AN960PD516		.WASHER	C-G	2
	20	NAS43DD5-173		.SPACER	C-G	2
	25	H10-5BAC		.NUT- (V15653) (SPEC BACN10JC5) (OPT RMLH9075-5W (V72962)) (OPT T6S524J (V71087)) (OPT 96-054 (V80539)) (OPT BRH10A5 (V52828))	C-G	2
	30	MKP5A		.BEARING- (V38443) (SPEC BACB10AP5) (OPT LLMKP5A (V38443)) (OPT MKP5AFS428 (V21335)) (OPT MKP5ATT (V43991)) (OPT MKP5A2TS (V43991)) (OPT MKP5E6531 (V21335)) (OPT MKP5AG20 (V38443)) (OPT ITEM 30B)	C-E	2
R	-30A	BACB10FS5R		.BEARING	F,G	2
	-30B	BACB10FS5R		.BEARING (PREF)	C-E	2

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	02-					
	35	252T1271-1		.BELLCRANK ASSY	C-E	2
R	-35A	252T1271-4		.BELLCRANK ASSY	F,G	2
	40	MKP5A		..BEARING- (V38443) (SPEC BACB10AP5) (OPT LLMKP5A (V38443)) (OPT MKP5AFS428 (V21335)) (OPT MKP5ATT (V43991)) (OPT MKP5A2TS (V43991)) (OPT MKP5E6531 (V21335)) (OPT MKP5AG20 (V38443)) (OPT ITEM 40B)	C-E	1
R	-40A	BACB10FS5R		..BEARING	F,G	1
	-40B	BACB10FS5R		..BEARING (PREF)	C-E	1
	45	252T1271-2		..BELLCRANK	C-G	1
	50	252T1213-11		.BRACKET ASSY	C	1
	-50A	252T1213-17		.BRACKET ASSY	D,F	1
	-50B	252T1213-19		.BRACKET ASSY	E,G	1
	55	BACR15BA3AD		..RIVET- (SIZE DETERMINE ON INST)	C-G	2
	60	50-3361-4222		..FILLER	C-G	2
	65	272T1410-1		..BRACKET ASSY	C	1
	-65A	272T1410-5		..BRACKET ASSY ATTACHING PARTS	E,G	1
	70	BACR15FT6AD		..RIVET- (SIZE DETERMINE ON INST) -------*-------	C,E,G	2
	75	BACR15BA3AD		...RIVET- (SIZE DETERMINE ON INST)	C,E,G	4
	80	NS103225-02		...NUTPLATE- (V80539) (SPEC BACN10KH3) (OPT RMF9209M3 (V72962)) (OPT F29779-3 (V15653))	C,E,G	2

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-					
85	272T1410-3		...BRACKET	C	1
-90	272T1410-6		...BRACKET	E,G	1
93	252T1230-12		..BRACKET	C,E,G	1
95	272T1272-1		..BRACKET ASSY ATTACHING PARTS	D,F	1
100	BACR15FT6AD		..RIVET- (SIZE DETERMINE ON INST) -------*-------	D,F	2
105	BACR15BA3AD		...RIVET- (SIZE DETERMINE ON INST)	D,F	4
110	NS103225-02		...NUTPLATE- (V80539) (SPEC BACN10KH3) (OPT RMF9209M3 (V72962)) (OPT F29779-3 (V15653))	D,F	2
115	272T1272-2		...BRACKET	D,F	1
117	252T1230-16		..BRACKET	D,F	1
120	252T1213-3		.BRACKET ASSY	C,E,G	1
-120A	252T1213-5		.BRACKET ASSY	D,F	1
125	BACR15BA3AD		..RIVET- (SIZE DETERMINE ON INST)	C-G	2
130	50-3361-4222		..FILLER	C-G	2
135	252T1230-7		..BRACKET	C,E,G	1
-140	252T1230-2		..BRACKET	D,F	1
145	252T1213-15		.BRACKET ASSY	C,E,G	1
150	BACR15BA3AD		..RIVET- (SIZE DETERMINE ON INST)	C,E,G	5

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-					
155	50-3361-4222		..FILLER	C,E,G	4
160	252T1213-6		..FILLER	C,E,G	1
165	272T1410-2		..BRACKET ASSY	C,E,G	1
			ATTACHING PARTS		
170	HL10VAZ6K3		..BOLT-	C,E,G	4
			(V56878)		
			(SPEC BACB30MY6K3)		
			(OPT B30MY6K3		
			(V97928))		
			(OPT HL10VAZ6-3		
			(V73197))		
			(OPT HL10VAZ6-3		
			(V92215))		
			(OPT HL10VAZ6-3		
			(V97928))		
			(OPT L8006K3		
			(V06725))		
			(OPT HL10VAZ6-3		
			(V08524))		
175	HL79-6		..COLLAR-	C,E,G	4
			(V56878)		
			(SPEC BACC30M6)		
			(OPT HL79-6		
			(V73197))		
			(OPT HL79-6		
			(V92215))		
			(OPT 66014-6		
			(V56878))		
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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-					
180	BACR15BA3AD		...RIVET- (SIZE DETERMINE ON INST)	C,E,G	4
185	NS103225-02		...NUTPLATE- (V80539) (SPEC BACN10KH3) (OPT RMF9209M3 (V72962)) (OPT F29779-3 (V15653))	C,E,G	2
190	272T1410-4		...BRACKET	C,E,G	1
195	BACR15FT6AD		..RIVET- (SIZE DETERMINE ON INST)	C,E,G	2
200	BACR15BA5AD		..RIVET- (SIZE DETERMINE ON INST)	C,E,G	13
205	272T1414-2		..BRACKET	C,E,G	1
210	252T1230-5		..BRACKET	C,E,G	1
215	252T1230-6		..BRACKET	C,E,G	1
220	252T1230-14		..BRACKET	C,E,G	1
225	252T1232-1		..CLEAT	C,E,G	1
230	252T1230-15		..BRACKET- (OPT ITEM 230A)	C,E,G	1
-230A	252T1230-3		..BRACKET- (OPT ITEM 230)	C,E,G	1
235	252T1233-1		..BEAM	C,E,G	1
240	252T1213-16		.BRACKET ASSY	D,F	1
245	BACR15BA3AD		..RIVET- (SIZE DETERMINE ON INST)	D,F	5
250	50-3361-4222		..FILLER	D,F	4
255	252T1213-6		..FILLER	D,F	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-					
260	272T1273-1		..BRACKET ASSY	D,F	2
			ATTACHING PARTS		
265	BACR15FT5AD		..RIVET-	D,F	4
			(SIZE DETERMINE ON INST)		
			-------*-------		
270	BACR15BA3AD		...RIVET-	D,F	4
			(SIZE DETERMINE ON INST)		
275	NS103225-02		...NUTPLATE-	D,F	2
			(V80539)		
			(SPEC BACN10KH3)		
			(OPT RMF9209M3		
			(V72962))		
			(OPT F29779-3		
			(V15653))		
280	272T1273-2		...BRACKET	D,F	1
285	BACR15BA5AD		..RIVET-	D,F	1
			(SIZE DETERMINE ON INST)		
290	BACR15FT6AD		..RIVET-	D,F	1
			(SIZE DETERMINE ON INST)		
295	BACR15BB5AD		..RIVET-	D,F	16
			(SIZE DETERMINE ON INST)		
300	272T1273-3		..BRACKET	D,F	1
305	252T1230-10		..BRACKET	D,F	1
310	252T1230-9		..BRACKET	D,F	1
315	252T1230-1		..BRACKET	D,F	1
320	252T1232-1		..CLEAT	D,F	1
325	252T1230-15		..BRACKET	D,F	1
330	252T1233-1		..BEAM	D,F	1