TO: ALL HOLDERS OF AILERON CONTROL COMPONENTS COMPONENT MAINTENANCE MANUAL 27-11-10

REVISION NO. 2 DATED JUL 01/99

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 on the Record of Revision Sheet.

CHAPTER/SECTION AND PAGE NO.	DESCRIPTION OF CHANGE
TITLE PAGE 1 REPAIR 4-1 601-604 1002,1004-1005,1007, 1009,1011-1015	Added 251T1512-6 fitting assembly.
CONTENTS 1 REPAIR 3-1 601	Added check instruction to repair instruction for 251T1512-5 fitting assembly.
REPAIR 3-1 602-604	Edited illustration without technical change.

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BOEING

COMPONENT
MAINTENANCE MANUAL

AILERON CONTROL COMPONENTS

PART NUMBERS 251T1289-1
251T1509-1
251T1512-5,-6

COMPONENT MAINTENANCE MANUAL
WITH
ILLUSTRATED PARTS LIST

143952

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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

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TEMPORARY REVISION AND SERVICE BULLETIN RECORD

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVE	DATE OF INCORPORATION INTO MANUAL

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PAGE	DATE	CODE
27-11-10		
TITLE PAGE		
*1	JUL 01/99	01.1
2	BLANK	
REVISION RECORD		
1	OCT 10/84	01
2	BLANK	
TR & SB RECORD		
1	OCT 10/84	01
2	BLANK	
LIST OF EFFECTIVE PAGES		
*1	JUL 01/99	01
THRU LAST PAGE		
CONTENTS		
*1	JUL 01/99	01.1
2	BLANK	
INTRODUCTION		
1	OCT 10/84	01
2	BLANK	
REPAIR-GENERAL		
601	OCT 10/84	01
602	OCT 10/84	01
REPAIR 1-1		
601	OCT 10/84	01
602	OCT 10/84	01
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601	JUL 10/85	01.1
602	JUL 10/85	01.1
REPAIR 3-1		
*601	JUL 01/99	01.1
*602	JUL 01/99	01.1
*603	JUL 01/99	01.1

PAGE	DATE	CODE
REPAIR 3-1		CONT.
*604	JUL 01/99	01.1
REPAIR 4-1		
*601	JUL 01/99	01.1
*602	JUL 01/99	01.1
*603	JUL 01/99	01.1
*604	JUL 01/99	01.1
ILLUSTRATED PARTS LIST		
1001	OCT 10/84	01
*1002	JUL 01/99	01.1
*1003	JUL 01/99	01.1
*1004	JUL 01/99	01.1
*1005	JUL 01/99	01.1
*1006	JUL 01/99	01.1
*1007	JUL 01/99	01.1
*1008	JUL 01/99	01.1
*1009	JUL 01/99	01.1
*1010	JUL 01/99	01.1
*1011	JUL 01/99	01.1
*1012	JUL 01/99	01.1
*1013	JUL 01/99	01.1
*1014	JUL 01/99	01.1
*1015	JUL 01/99	01.1
*1016	BLANK	

* = REVISED, ADDED OR DELETED

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TABLE OF CONTENTS

NOTE: This manual contains overhaul data for various components of the Aileron Control Installation. Functions which cannot be performed by the use of standard industry practices are included in the repair instructions for each component.

AILERON CONTROL COMPONENTS

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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.

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REPAIR - GENERAL

1. Content

   A. Each separate repair includes, as applicable, check, repair and refinish instructions.

2. Standard Practices

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

      20-21-01 Magnetic Particle Inspection
      20-20-02 Penetrant Methods of Inspection
      20-30-02 Stripping of Protective Finish
      20-41-01 Decoding Table for Boeing Finish Codes
      20-41-02 Application of Chemical and Solvent Resistant Finishes
      20-42-03 Hard Chrome Plating
      20-43-01 Chromic Acid Anodizing
      20-50-03 Bearing Installation and Retention
      20-60-03 Lubricants

3. Materials

   NOTE: Equivalent substitutes may be used.

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

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

   C. Enamel -- BMS 10-11, type 2, gloss gray (BAC 707) (Ref 20-60-02)

   D. Grease -- BMS 3-24 (Ref 20-60-03)

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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

143966

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LINK ASSEMBLY - REPAIR 1-1

251T1289-1

NOTE: Refer to REPAIR-GEN for list of applicable standard practices. For repair of surfaces which may only require restoration of original finish, refer to Refinish instructions, Fig. 601. Item numbers refer to IPL Fig. 1.

1. Penetrant check link (35) per 20-20-02.

2. Repair

   A. Bearing Replacement (Fig. 601)

      (1) Remove bearing (30).

      (2) Install replacement bearing with wet BMS 5-95 sealant and roller or anvil swage bearing over housing per 20-50-03. After swaging, bearing must withstand a push-out load of 1095 pounds.

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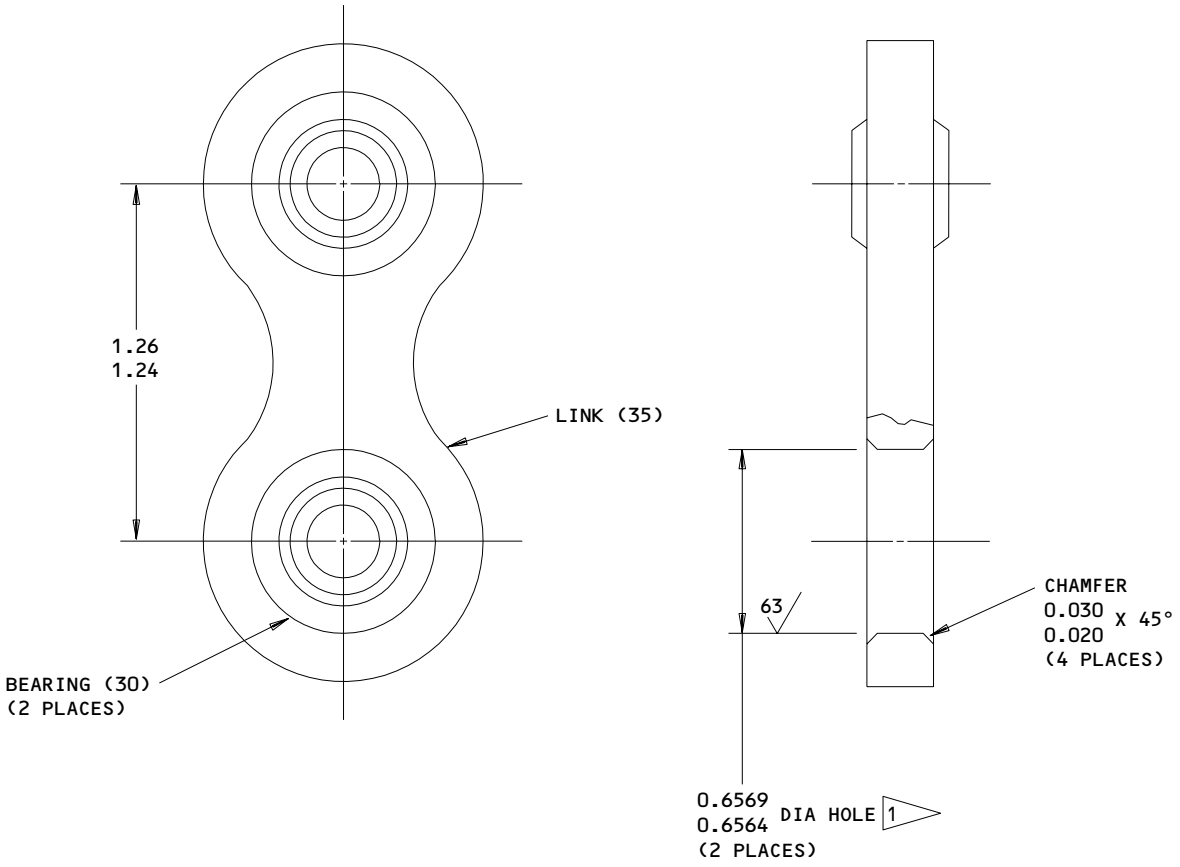

REFINISH

LINK (35) -- CHEMICAL TREAT OR CHROMIC ACID ANODIZE AND APPLY TWO COATS OF BMS 10-11, TYPE 1, PRIMER (F-18.03). APPLY ONE COAT BMS 10-11, TYPE II ENAMEL, COLOR 707 GRAY GLOSS (F-21.02).

1 OMIT PRIMER AND ENAMEL THIS SURFACE

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

ITEM NUMBERS REFER TO IPL FIG. 1

251T1289-1
Link Assembly Repair
Figure 601

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ROD ASSEMBLY - REPAIR 2-1

251T1509-1

NOTE: Refer to REPAIR-GEN for list of applicable standard practices. For repair of surfaces which may only require restoration of original finish, refer to Refinish instructions, Fig. 601. Item numbers refer to IPL Fig. 2.

1. Magnetic particle inspect fitting (40, 45) and body (50) per 20-20-01.

2. Repair

   A. Bearing Replacement (Fig. 601)

      (1) Remove rod bearing (35).

      (2) Position new rod bearing in fitting to dimension shown. Drill holes in new bearing using fitting as a guide.

      (3) Install bearing in fitting (40, 45) with BMS 5-95 sealant on faying surfaces.

      (4) Install rivets (30) with BMS 5-95 sealant.

   B. Fitting Replacement (Fig. 601)

      (1) Remove end assembly (20, 25) from body (50) by loosening nut (15) and unscrewing.

      (2) Install end assembly (20, 25) using BMS 3-24 grease on both internal body threads and external fitting threads.

      (3) Adjust rod length to reference dimension shown and tighten nuts (15).

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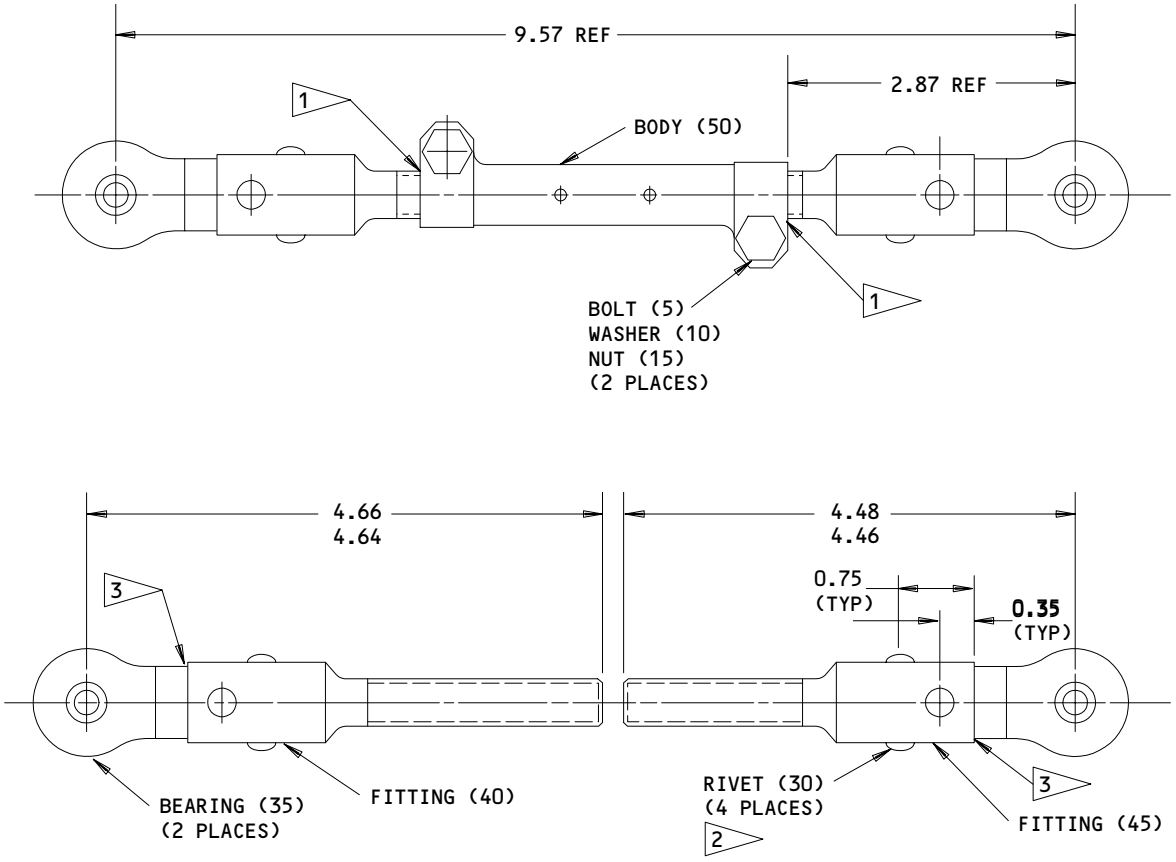

REFINISH

FITTING (40,45), BODY (50,50A) -- PASSIVATE (F-17.09)

1 APPLY BMS 3-24 GREASE ON BOTH INTERNAL AND EXTERNAL THREADS

2 INSTALL RIVET (30) WITH BMS 5-95 SEALANT

3 ASSEMBLE WITH BMS 5-95 SEALANT ON FAYING SURFACES

MATERIAL: FITTING (40,45), BODY (50,50A) -- 15-5PH CRES 150-170 KSI

ALL DIMENSIONS ARE IN INCHES

ITEM NUMBERS REFER TO IPL FIG. 2

251T1509-1

Rod Assembly Repair
Figure 601

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FITTING ASSEMBLY - REPAIR 3-1

251T1512-5

NOTE: Refer to REPAIR-GEN for list of applicable standard practices. For repair of surfaces which may only require restoration of original finish, refer to Refinish instructions, Fig. 601. Item numbers refer to IPL Fig. 3.

Do not disassemble bracket (15), bolt (30), spacer (35), collar (50) or nutplates (25) unless necessary for repair or replacement.

1. Penetrant inspect fitting (70), bracket (15) and spacer (65) per 20-20-02.

2. Bushing Replacement (Fig. 601)

   A. Remove bushing (55).

   B. Install replacement bushing per 20-50-03 with BMS 3-24 grease.

3. Hole Repair (Fig. 601)

   A. Machine hole oversize as required, within repair limit shown to remove defects.

   B. Check the fitting (70) hole to the dimension shown in Fig. 601.

   C. Manufacture repair bushing per Fig. 601.

      NOTE: Repair bushing is special oversize bushing to replace installation part. Bushings are not part of assembly.

   D. Attach repair bushing to fitting assembly with aluminum wire and attach tag stating "Special Oversize Bushing Must Be Used."

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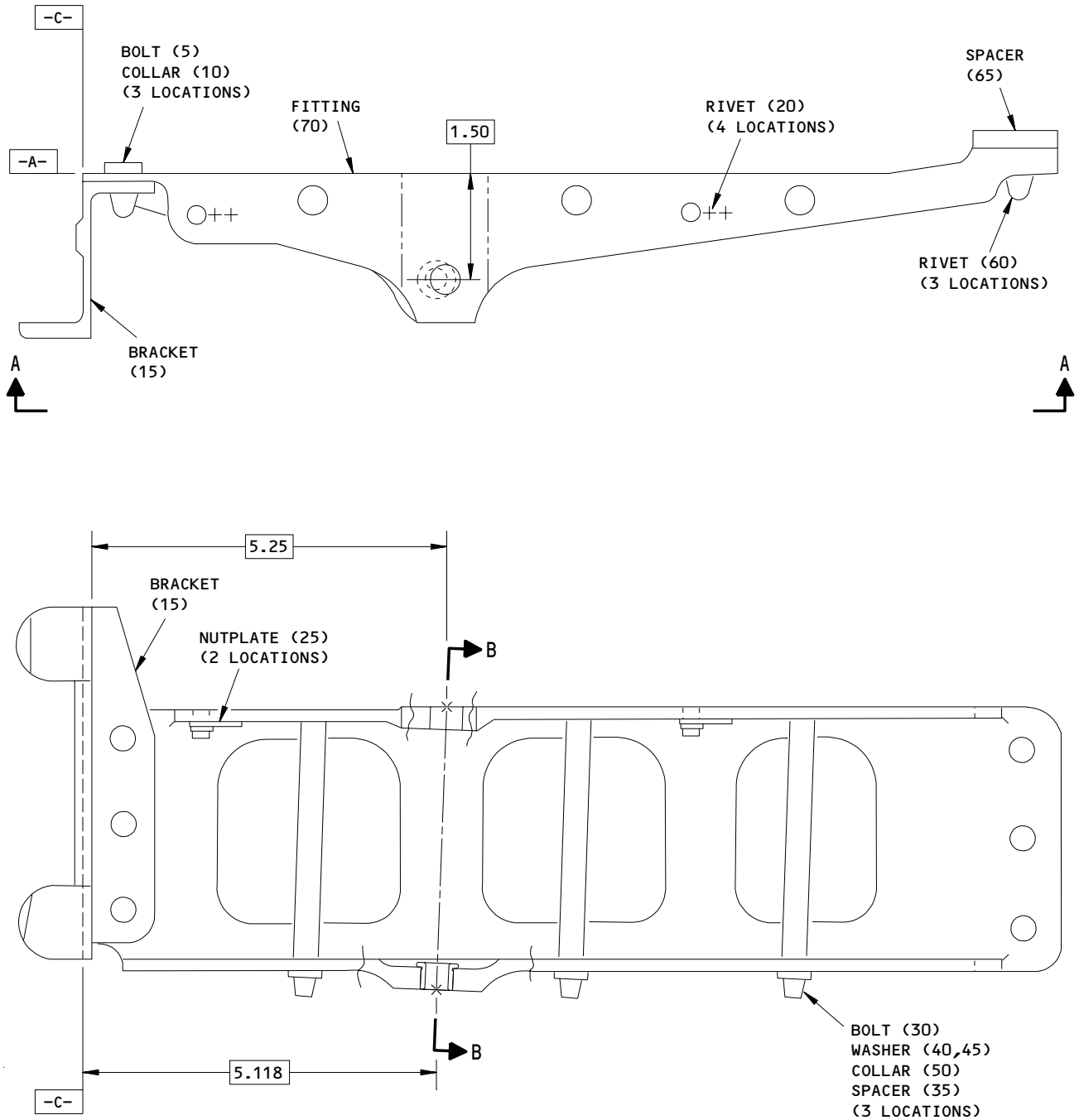

A-A

251T1512-5
Fitting Assembly Repair
Figure 601 (Sheet 1)

144036

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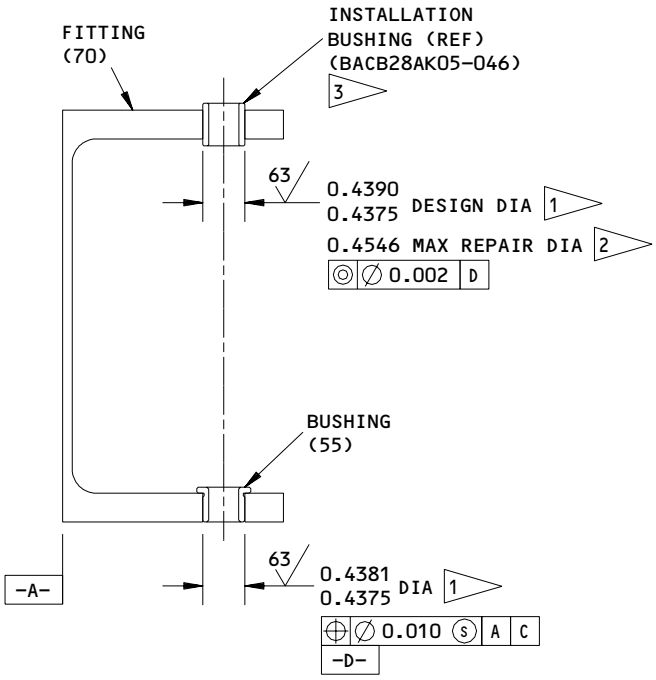

B-B

REFINISH

FITTING (70), SPACER (65), BRACKET (15) -- CHROMIC ACID ANODIZE AND APPLY ONE LAYER OF BMS 10-11, TYPE 1 PRIMER (F-18.13) UNLESS SHOWN DIFFERENTLY

REPAIR

REF 2 3

MATERIAL: FITTING (70), SPACER (65) AND BRACKET (15) - Al ALLOY

ITEM NUMBERS REFER TO IPL FIG. 3

ALL DIMENSIONS ARE IN INCHES

1 NO PRIMER THIS SURFACE

2 REPAIR LIMIT FOR INSTALLATION OF REPAIR BUSHING

3 OVERSIZE BUSHING REPLACES BACB28AK05-064 INSTALLATION PART. ATTACH TO ASSEMBLY. TAG ASSEMBLY TO USE OVERSIZE BUSHING DURING INSTALLATION

251T1512-5
Fitting Assembly Repair
Figure 601 (Sheet 2)

K23791

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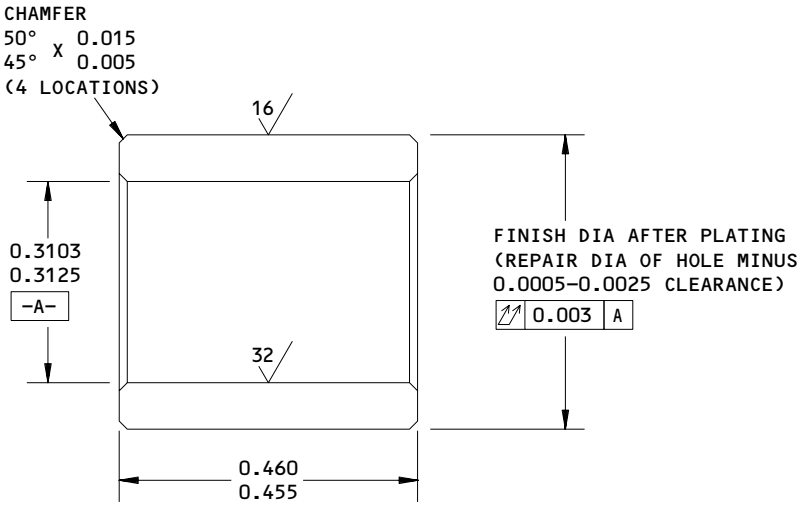

OVERSIZE REPLACEMENT FOR BUSHING BACB28AK05-046

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: AL-NI-BRONZE REFER TO AMS 4880 OR AMS 4640

BREAK SHARP EDGES 0.01-0.03 R

FINISH: CADMIUM PLATE 0.0003-0.0005 THICK REFER TO SOPM 20-42-05

ALL DIMENSIONS ARE IN INCHES

Bushing Detail
Figure 602

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FITTING ASSEMBLY - REPAIR 4-1

251T1512-6

NOTE: Refer to REPAIR-GEN for a list of applicable standard practices. For repair of surfaces which may only require restoration of original finish, refer to Refinish instructions, Fig. 601. Item numbers refer to IPL Fig. 6.

1. Penetrant inspect the fitting (30) per 20-20-02.

2. Bushing Replacement (Fig. 601)

   A. Remove the bushing (25) from the fitting (30).

   B. Install the replacement bushing per 20-50-03 with BMS 3-24 grease or BMS 5-95 sealant.

3. Hole Repair (Fig. 601)

   A. Machine hole oversize as required, within the repair limit shown to remove defects.

   B. Check the fitting (30) hole to the dimension shown in Fig. 601.

   C. Manufacture repair bushing per Fig. 602.

      NOTE: Repair bushing is special oversize bushing to replace installation part. Bushings are not part of assembly.

   D. Attach the repair bushing to the fitting (30) assembly with aluminum wire and attach tag stating "Special Oversize Bushing Must be Used."

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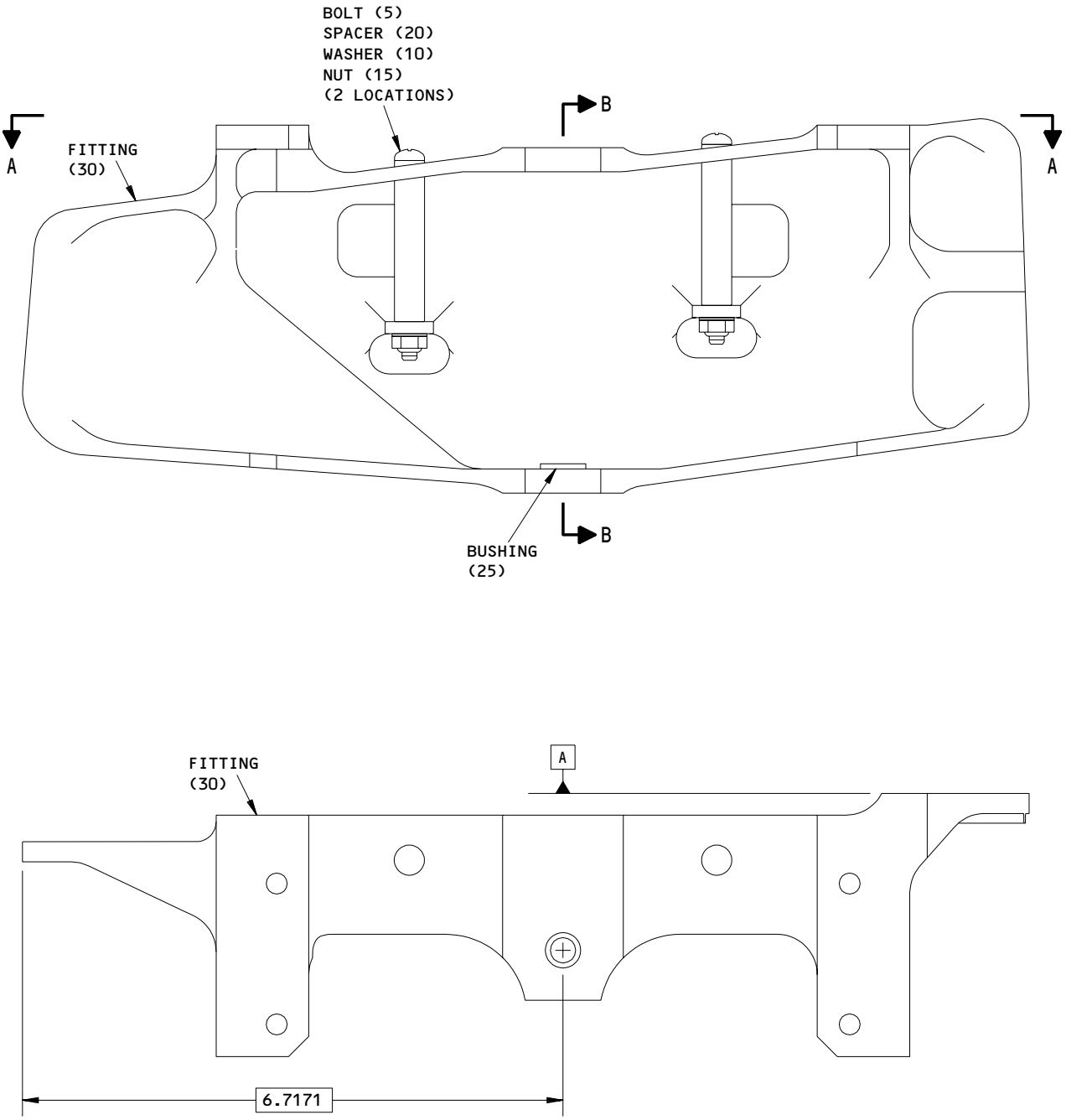

A-A

251T1512-6
Fitting Assembly Repair
Figure 601 (Sheet 1)

K23640

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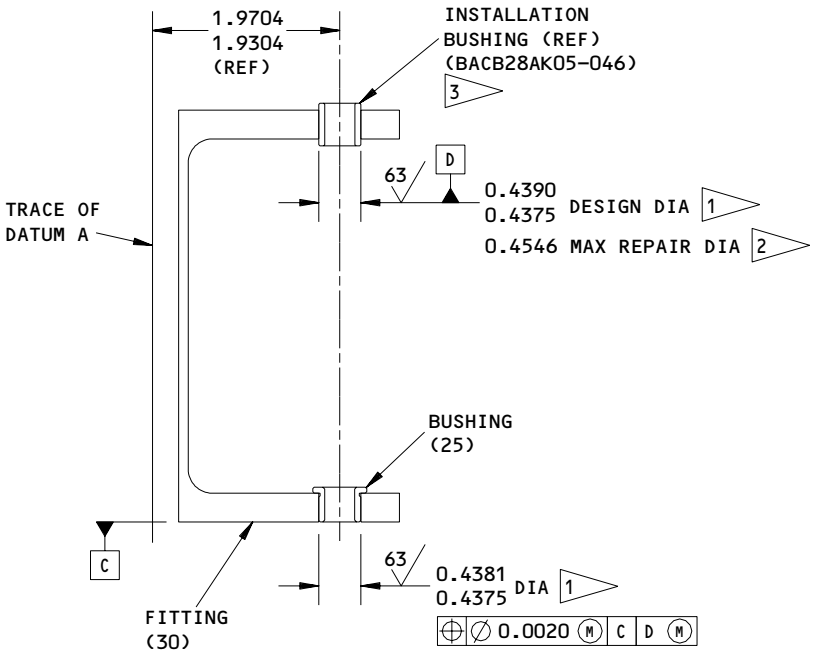

B-B

REFINISH

FITTING (30) - BORIC ACID - SULFURIC ACID ANODIZE (F-17.35) AND A LAYER OF BMS 10-11, TYPE 1 PRIMER (F-20.03) UNLESS SHOWN DIFFERENTLY

REPAIR

REF 2 3

MATERIAL: FITTING (30) - Al ALLOY

ITEM NUMBERS REFER TO IPL FIG. 6

ALL DIMENSIONS ARE IN INCHES

1 NO PRIMER THIS SURFACE

2 REPAIR LIMIT FOR INSTALLATION OF REPAIR BUSHING

3 OVERSIZE BUSHING REPLACES BACB28AK05-064 INSTALLATION PART. ATTACH TO ASSEMBLY. TAG ASSEMBLY TO USE OVERSIZE BUSHING DURING INSTALLATION

251T1512-6
Fitting Assembly Repair
Figure 601 (Sheet 2)

K23641

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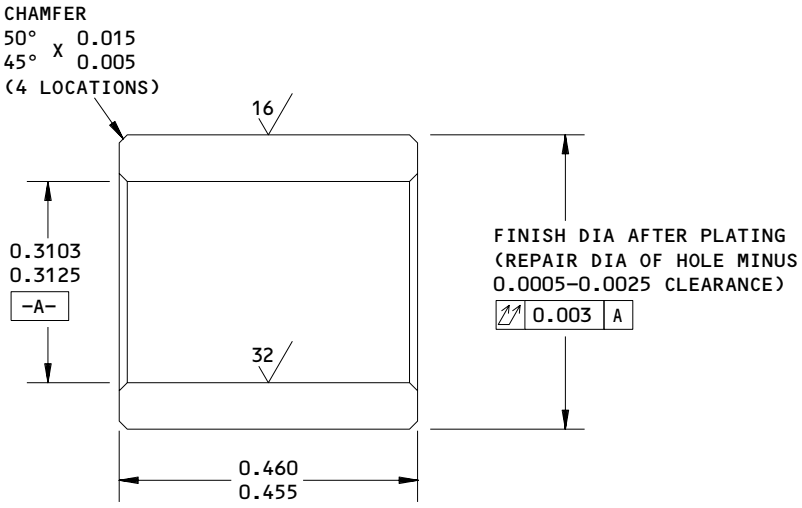

OVERSIZE REPLACEMENT FOR BUSHING BACB28AK05-046

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: AL-NI-BRONZE REFER TO AMS 4880 OR AMS 4640

BREAK SHARP EDGES 0.01-0.03 R

FINISH: CADMIUM PLATE 0.0003-0.0005 THICK REFER TO SOPM 20-42-05

ALL DIMENSIONS ARE IN INCHES

Bushing Detail
Figure 602

K22869

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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.

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VENDORS

S0352 NIPPON MINIATURE BEARING CO LTD
TOKYO, JAPAN

02758 NETWORKS ELECTRONIC CORP U S BEARING DIV
9750 DE SOTO AVENUE
CHATSWORTH, CALIFORNIA 91311-4409

09455 BFM TRANSPORT DYNAMICS CORP
3131 WEST SEGERSTROM AVENUE PO BOX 1953
SANTA ANA, CALIFORNIA 92702-1953

11815 CHERRY AEROSPACE FASTENERS DIV OF TEXTRON
1224 EAST WARNER AVENUE PO BOX 2157
SANTA ANA, CALIFORNIA 92707-0157

15653 KAYNAR TECHNOLOGY KAYNAR DIV
800 SOUTH STATE COLLEGE BLVD PO BOX 3001
FULLERTON, CALIFORNIA 92634-3001

15860 NEW HAMPSHIRE BALL BEARINGS, INCORPORATED ASTRO DIVISION
155 LEXINGTON AVENUE
LACONIA, NEW HAMPSHIRE 03246-2937

16746 SPECLINE INCORPORATED
2230 MOUTON DR
CARSON CITY, NV 89706

17446 HUCK MFG CO GOV CONTRACTS LOS ANGELES DIV SUB OF FED-MOGUL
900 WATSON CENTER ROAD
CARSON, CALIFORNIA 90745

21335 TORRINGTON CO FAFNIR BEARING DIV
59 FIELD STREET
TORRINGTON, CONNECTICUT 06790-4942

29666 HUCK MANUFACTURING CO SUB OF FEDERAL-MOGUL CORP
6 THOMAS
IRVINE, CALIFORNIA 92714

50294 NEW HAMPSHIRE BALL BEARINGS INC
9730 INDEPENDENCE AVENUE PO BOX 2515
CHATSWORTH, CALIFORNIA 91311-4323

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

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VENDORS

56644 AURORA BEARING CO
970 SOUTH LAKE STREET
AURORA, ILLINOIS 60506-5929

56878 SPS TECHNOLOGIES INC AEROSPACE AND INDUSTRIAL PRODUCTS DIV
HIGHLAND AVENUE
JENKINTOWN, PENNSYLVANIA 19046

60119 MONADNOCK CO THE
18301 ARENTH AVENUE PO BOX 1222
CITY OF INDUSTRY, CALIFORNIA 91749

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

72962 HARVARD INDUSTRIES INC
3 WERNER WAY SUITE 210
LEBANON, NEW JERSEY 08833

73134 IMO INDUSTRIES INC HEIM BEARINGS DIV
60 ROUND HILL ROAD PO BOX 430
FAIRFIELD, CONNECTICUT 06430

80539 SPS TECHNOLOGIES INC AEROSPACE PRODUCTS DIV
2701 SOUTH HARBOR BOULEVARD PO BOX 1259
SANTA ANA, CALIFORNIA 92702-1259

81376 SOUTHWEST PRODUCTS COMPANY
2240 BUENA VISTA STREET
IRVINDALE, CALIFORNIA 91706

92215 FAIRCHILD IND INC FAIRCHILD AEROSPACE FASTENER DIV
3010 W LOMITA BLVD
TORRANCE, CALIFORNIA 90505-5102

97613 SARGENT CONTROLS & AEROSPACE/KAHR BEARING DIV
5675 W BURLINGAME RD
TUCSON, ARIZONA 85743

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
ABG4V4		1	30	2
		1	30	2
AN960C416		2	10	2
BACB10CN4		1	30	2
BACB28X5M024		3	55	1
		6	25	1
BACB30GW6-61		3	30	3
BACB30NT3K34		6	5	2
BACB30NX6C5		3	5	3
BACC30K6		3	50	3
BACC30X6M		3	10	3
BACN10JC3		3	50A	3
BACN10JC3CD		6	15	2
BACN10JC4CM		2	15	2
BACN10JP4BCM		3	25	2
BACR15BA3AD3		3	20	4
BACR15BA4AD		3	60	2
BACW10CA3CCS		3	45	3
BACW10CA3CVS		3	40	3
BLN4-2230		1	30	2
BNG4F113		1	30	2
BRH10A3		3	50A	3
BRM100C4M		3	25	2
HG4-140		1	30	2
H10-3BAC		3	50A	3
KSBG4-57		1	30	2
K29646-3S		3	40	3
K29913-3S		3	45	3
MK2001-4BAC		3	25	2
MS14101-4		1	30A	2
MS20615-5MP		2	30	4
NAS1149D0332J		6	10	2
NAS623-3-61		3	30A	3
NAS6704-10		2	5	2
NBG4A		1	30	2
NC4G1		1	30	2
NS103198SE048		3	25	2
NS202101-02		3	50A	3
RMLH9075-3W		3	50A	3
RR4H11FS436		2	35	2
SALPYT6-61		3	30	3
T6S1032J		3	50A	3
T8081C428		3	25	2
VN201D1-048		3	25	2
VN303A02		3	50A	3
109A9207M4		3	25	2

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
2DCC6		3	50	3
251T1289-1		1	5	RF
251T1289-2		1	35	1
251T1507-1		2	45	1
251T1507-2		2	40	1
251T1508-1		2	50	1
251T1508-2		2	50A	1
251T1509-1		1	10	RF
		2	1	RF
251T1509-2		2	20	1
251T1509-3		2	25	1
251T1512-5		1	15	RF
		3	1	RF
251T1512-6		1	15A	RF
		6	1	RF
251T1552-4		3	15	1
251T1575-3		3	65	1
251T1575-5		3	70	1
251T1575-6		6	30	1
251T3741-26		3	35	3
251T3741-47		6	20	2
55768-4		1	30	2
70186-3S		3	40	3
70189-3S		3	45	3
922005-3		3	40	3
922006-3		3	45	3
942005-3		3	40	3
942006-3		3	45	3
96-02		3	50A	3

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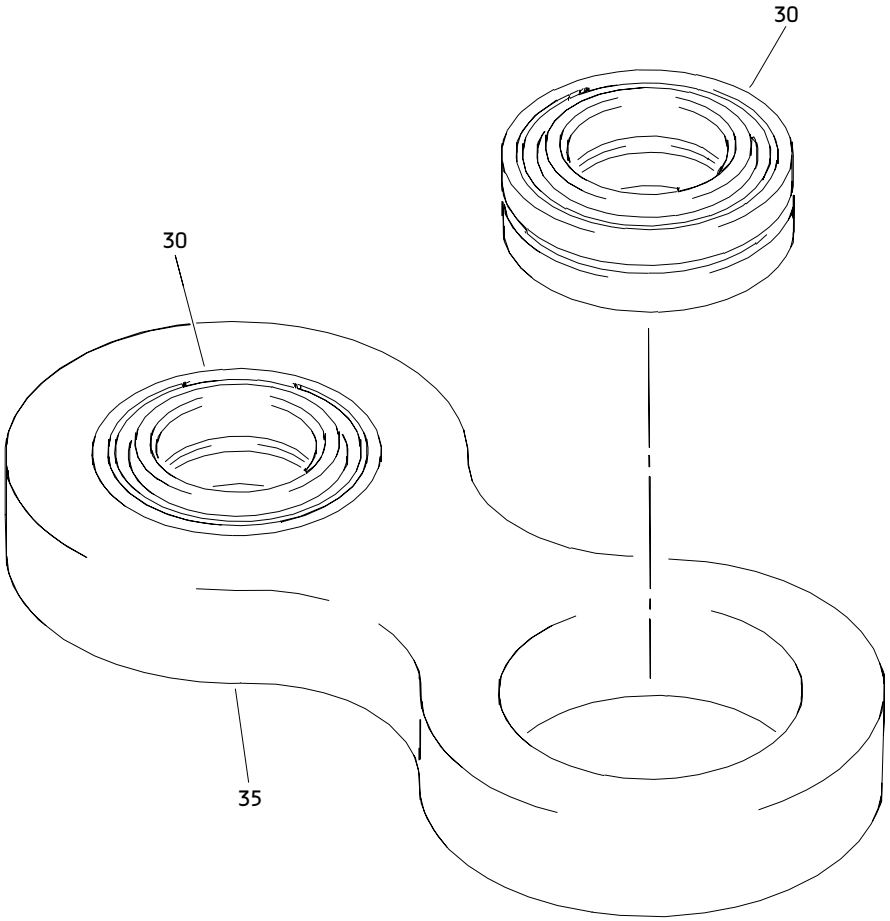

Aileron Control Debris Guard Link Assembly
Figure 1

T93939

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	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-			COMPONENTS-AILERON CONTROL		
	-5	251T1289-1		LINK ASSY-AIL. CONT DEBRIS GUARD	A	RF
	-10	251T1509-1		ROD ASSY-AIL. CONT LATERAL CENTRAL CONT ACTR OUTPUT (FOR DETAILS SEE FIG. 2)	B	RF
	-15	251T1512-5		FITTING ASSY-RH OVERRIDE MECH QUADRANT SPRT (FOR DETAILS SEE FIG. 3)	C	RF
R	-15A	251T1512-6		FITTING ASSY-RH OVERRIDE MECH QUADRANT SPRT (FOR DETAILS SEE FIG. 6)	D	RF
	-20	252T1200-5		DELETED		
	-20A	252T1200-7		DELETED		
	-25	252T1200-6		DELETED		
	30	BNG4F113		.BEARING- (V16746) (SPEC BACB10CN4) (OPT BLN4-2230 (V81376)) (OPT HG4-140 (V02758)) (OPT KSBG4-57 (V97613)) (OPT 55768-4 (V09455)) (OPT NBG4A (V73134)) (OPT NC4G1 (V56644)) (OPT ABG4V4 (V50294)) (OPT AG4V25 (V15860)) (OPT ABG4V4 (VS0352)) (OPT ITEM 30A)	A	2
	-30A	MS14101-4		.BEARING- (OPT ITEM 30)	A	2
	35	251T1289-2		.LINK	A	1

- Item Not Illustrated

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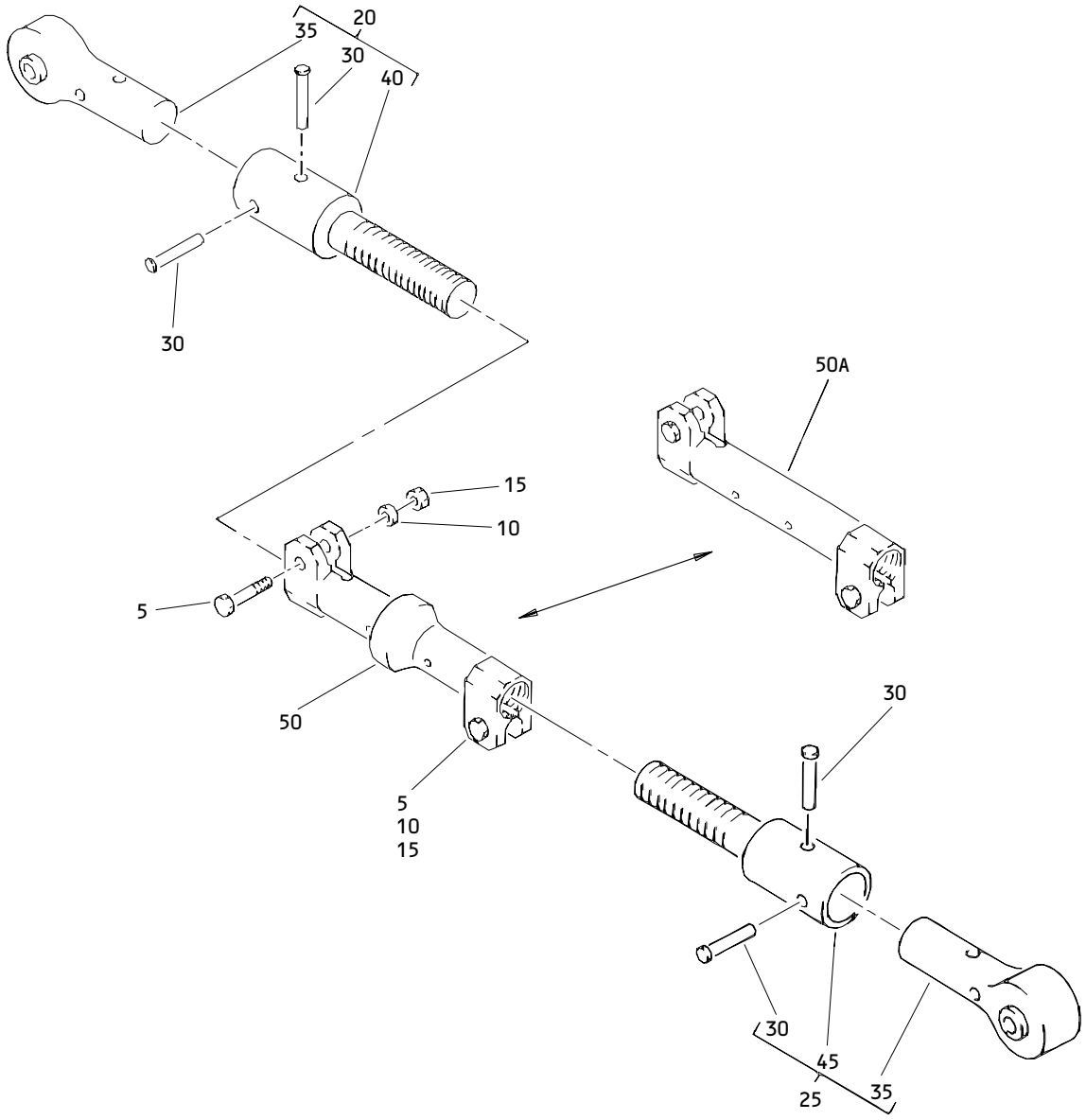

Aileron Control Lateral Central Control Actuator Output Rod Assembly
Figure 2

T93940

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-					
-1	251T1509-1		ROD ASSY-AIL. CONT LATERAL CENTRAL CONT ACTR OUTPUT	B	RF
5	NAS6704-10		.BOLT	B	2
10	AN960C416		.WASHER	B	2
15	BACN10JC4CM		.NUT	B	2
20	251T1509-2		.END ASSY	B	1
25	251T1509-3		.END ASSY	B	1
30	MS20615-5MP		..RIVET- (SIZE DETERMINE ON INST)	B	2
35	RR4H11FS436		..BEARING- (V21335)	B	1
40	251T1507-2		..FITTING- (USED ON ITEM 20)	B	1
45	251T1507-1		..FITTING- (USED ON ITEM 25)	B	1
50	251T1508-1		.BODY- (OPT ITEM 50A)	B	1
50A	251T1508-2		.BODY- (OPT ITEM 50)	B	1

- Item Not Illustrated

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
03-					

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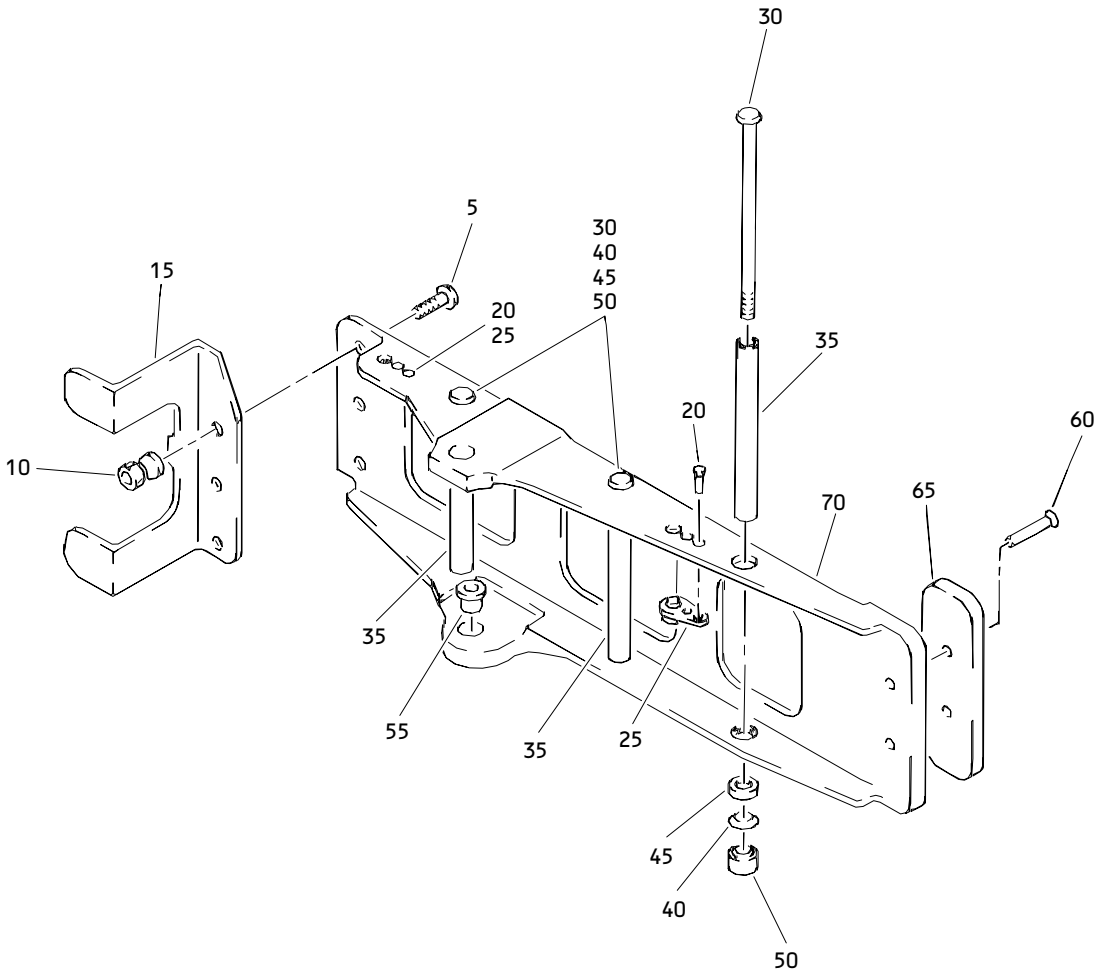

Right Hand Override Mechanism Quadrant Support Fitting Assembly
Figure 3

T93941

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
03-					
-1	251T1512-5		FITTING ASSY-RH OVERRIDE MECH QUADRANT SPRT	C	RF
5	BACB30NX6C5		.BOLT	C	3
10	BACC30X6M		.COLLAR	C	3
15	251T1552-4		.BRACKET-UPR ZEE	C	1
20	BACR15BA3AD3		.RIVET	C	4
25	BRM100C4M		.NUTPLATE- (V52828) (SPEC BACN10JP4BCM) (OPT MK2001-4BAC (V15653)) (OPT NS103198SE048 (V80539)) (OPT VN201D1-048 (V92215)) (OPT 109A9207M4 (V72962)) (OPT T8081C428 (V11815))	C	2
30	SALPYT6-61		.BOLT- (V11815) (SPEC BACB30GW6-61) (OPT SALPYT6-61 (V29666)) (OPT SALPYT6-61 (V17446)) (OPT ITEM 30A USED WITH ITEM 50A) (USED WITH ITEM 50)	C	3
-30A	NAS623-3-61		.BOLT- (OPT ITEM 30 USED WITH ITEM 50) (USED WITH ITEM 50A)	C	3

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
03-					
35	251T3741-26		.SPACER	C	3
40	K29646-3S		.WASHER- (V15653) (SPEC BACW10CA3CVS) (OPT 70186-3S (V56878)) (OPT 922005-3 (V60119)) (OPT 942005-3 (V60119))	C	3
45	K29913-3S		.WASHER- (V15653) (SPEC BACW10CA3CCS) (OPT 70189-3S (V56878)) (OPT 922006-3 (V60119)) (OPT 942006-3 (V60119))	C	3
50	2DCC6		.COLLAR- (V11815) (SPEC BACC30K6) (OPT 2DCC6 (V17446)) (USED WITH ITEM 30)	C	3
-50A	H10-3BAC		.NUT- (V15653) (SPEC BACN10JC3) (OPT NS202101-02 (V80539)) (OPT RMLH9075-3W (V72962)) (OPT T6S1032J (V71087)) (OPT VN303A02 (V92215)) (OPT 96-02 (V80539)) (OPT BRH10A3 (V52828)) (USED WITH ITEM 30A)	C	3

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
03-					
55	BACB28X5M024		.BUSHING	C	1
60	BACR15BA4AD		.RIVET- (SIZE DETERMINE ON INST)	C	2
65	251T1575-3		.SPACER	C	1
70	251T1575-5		.FITTING	C	1

- Item Not Illustrated

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
04- -1	252T1200-5		DELETED		

- Item Not Illustrated

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
05- -1	252T1200-6		DELETED		

- Item Not Illustrated

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
06-					

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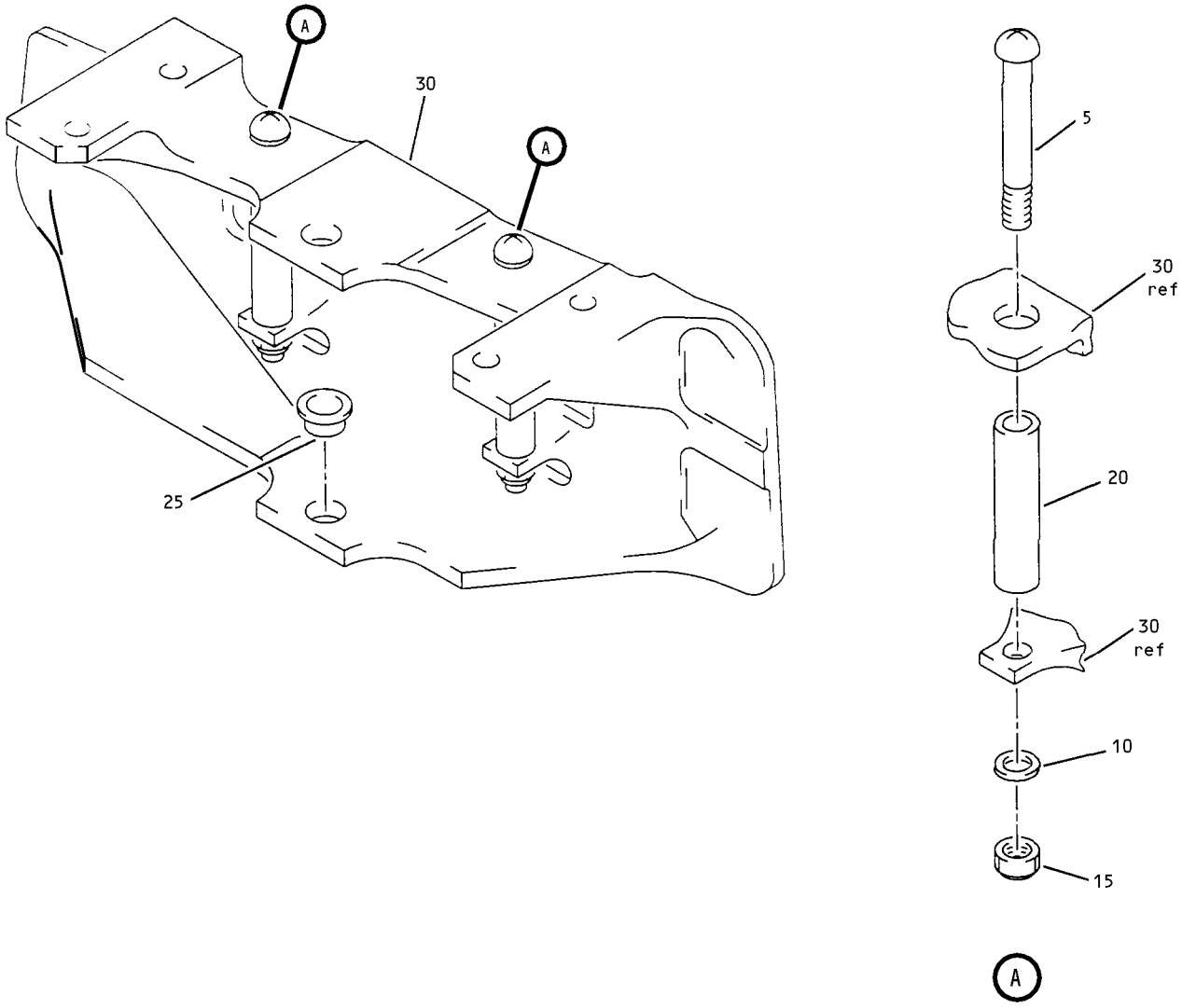

Right Hand Override Mechanism Quadrant Support Fitting Assembly
Figure 6

K22891

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	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	06-					
R	-1	251T1512-6		FITTING ASSY-RH OVERRIDE MECH QUADRANT SPRT	D	RF
R	5	BACB30NT3K34		.BOLT	D	2
R	10	NAS1149D0332J		.WASHER	D	2
R	15	BACN10JC3CD		.NUT	D	2
R	20	251T3741-47		.SPACER	D	2
R	25	BACB28X5M024		.BUSHING	D	1
R	30	251T1575-6		.FITTING	D	1

- Item Not Illustrated

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