TO: ALL HOLDERS OF AILERON CONTROL RIGHT WHEEL WELL QUADRANT ASSEMBLY
COMPONENT MAINTENANCE MANUAL 27-11-12

REVISION NO. 3 DATED JUN 01/95

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 TR & SB RECORD 1 REPAIR 1-1 601-602 1002-1003,1005-1023	Added top assembly 251T1300-6 with new CRES bearings and quadrant assembly 251T1315-3 to improve corrosion resistance per PRR B12597.
TITLE PAGE 1 1002-1003,1005-1023	Added top assembly 251T1300-7 with support assembly 251T1333-3 and new CRES bearings to improve corrosion resistance.
301 701	Edited without technical change.
REPAIR 2-1 601-602	Added support assembly 251T1333-3 with bracket 251T1319-2 for additional edge margin and clearance.

BOEING

COMPONENT
MAINTENANCE MANUAL

AILERON CONTROL RIGHT WHEEL WELL QUADRANT ASSEMBLY

PART NUMBER 251T1300-4 THRU -7

COMPONENT MAINTENANCE MANUAL
WITH
ILLUSTRATED PARTS LIST

143671

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

TEMPORARY REVISION AND SERVICE BULLETIN RECORD

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVE	DATE OF INCORPORATION INTO MANUAL
		PRR B10500-20 PRR B12597	OCT 10/84 JUN 01/95

PAGE	DATE	CODE
27-11-12		
TITLE PAGE		
*1	JUN 01/95	01.1
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REVISION RECORD		
1	OCT 10/84	01
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TR & SB RECORD		
*1	JUN 01/95	01.1
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*1	JUN 01/95	01
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601	OCT 10/84	01
602	OCT 10/84	01
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*601	JUN 01/95	01.1
*602	JUN 01/95	01.1
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1001	OCT 10/84	01
*1002	JUN 01/95	01.1
*1003	JUN 01/95	01.1
*1004	JUN 01/95	01.1
*1005	JUN 01/95	01.1
*1006	JUN 01/95	01.1

* = REVISED, ADDED OR DELETED

PAGE	DATE	CODE
ILLUSTRATED PARTS LIST		CONT.
*1007	JUN 01/95	01.1
*1008	JUN 01/95	01.1
*1009	JUN 01/95	01.1
*1010	JUN 01/95	01.1
*1011	JUN 01/95	01.1
*1012	JUN 01/95	01.1
*1013	JUN 01/95	01.1
*1014	JUN 01/95	01.1
*1015	JUN 01/95	01.1
*1016	JUN 01/95	01.1
*1017	JUN 01/95	01.1
*1018	JUN 01/95	01.1
*1019	JUN 01/95	01.1
*1020	JUN 01/95	01.1
*1021	JUN 01/95	01.1
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TABLE OF CONTENTS

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.

Verification:

Disassembly May 6/86
Assembly May 6/86

AILERON CONTROL RIGHT WHEEL WELL QUADRANT ASSEMBLY

DESCRIPTION AND OPERATION

1. The aileron control right wheel well quadrant assembly consists of a quadrant assembly mounted in a support assembly and a debris guard assembly which is attached to the support assembly by two shear out rivets.

2. The quadrant assembly receives a cable input from the aileron control feel and trim mechanism and transfers to the lateral control central actuator torque tube via a control rod. The debris guard assembly protects the quadrant assembly from debris in the wheel well. Two shear-out rivets attaching debris guard assembly to the support assembly will shear when a heavy object hits the debris guard assembly.

3. Leading Particulars (Approximate)

   Length -- 14 inches
   Width -- 8 inches
   Height -- 20 inches
   Weight -- 7 pounds

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. Parts Replacement (IPL Fig. 1)

   NOTE: The following parts are recommended for replacement. Unless otherwise noted, actual replacement of parts may be based on in-service experience.

   A. Nuts (20, 160, 185, 240)

   B. Bolts (35)

   C. Collars (40)

   D. Rivets (45, 125, 220)

2. Disassembly (IPL Fig. 1)

   A. Remove rivets (45, 125) then remove bolts (5, 10), washers (15A), bushings (25, 30), nuts (20), debris guard assembly (50 or 85) and fitting (130) from support assembly (245).

   B. Remove bolts (35), collar (40), bushings (42) and separate fitting (130) from debris guard assembly (50 or 85).

      NOTE: Do not disassemble debris guard assembly unless necessary for repair or replacement.

   C. Remove bolt (135), washer (140A), spacer (155), nut (160) and separate quadrant assembly (190) from support assembly (245). Remove bushing (145) from support assembly.

   D. Remove bearing (165), spacers (150, 180), screw (170), washer (175A) and nut (185) from quadrant assembly (190).

      NOTE: Do not disassembly quadrant assembly unless necessary for repair or replacement.

E. Remove nut (240), spacer (235). Remove rivets (220), retainer (225), spacer (237) and bolt (230) from support assembly (245).

NOTE: Do not disassemble support assembly unless necessary for repair or replacement.

CLEANING

1. Clean all parts except sealed bearings using standard industry practices (Ref 20-30-03).

2. Clean teflon sealed bearings per manufacturer's instructions.

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 bolt (135) per 20-20-01.

4. Penetrant check the following parts (Ref IPL Fig. 1) per 20-20-02.

   A. Fitting (130)

   B. Crank (210)

   C. Quadrant (215)

   D. Brackets (280, 285, 300, 360 thru 375)

REPAIR - GENERAL

1. Content

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

P/N	NAME	REPAIR
251T1315	QUADRANT	1-1
251T1333	SUPPORT	2-1
251T1363	GUARD, DEBRIS	3-1
251T1376	GUARD, DEBRIS	4-1
- - -	MISC PARTS REFINISH	5-1

2. Standard Practices

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

   20-30-02 Stripping of Protective Finishes
   20-30-03 General Cleaning Procedures
   20-41-01 Decoding Table for Boeing Finish Codes
   20-41-02 Application of Chemical and Solvent Resistant Finishes
   20-42-05 Bright Cadmium Plating
   20-43-01 Chromic Acid Anodizing
   20-50-03 Bearing Installation and Retention
   20-50-05 Application of Aluminum Foil and Other Markers

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, color BAC702 white (Ref 20-60-02)

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

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

143683

QUADRANT ASSY - REPAIR 1-1

251T1315-2, -3

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

1. Bearing Replacement

   A. Remove bearing.

   B. Install bearing with grease and roller swage per 20-50-03.

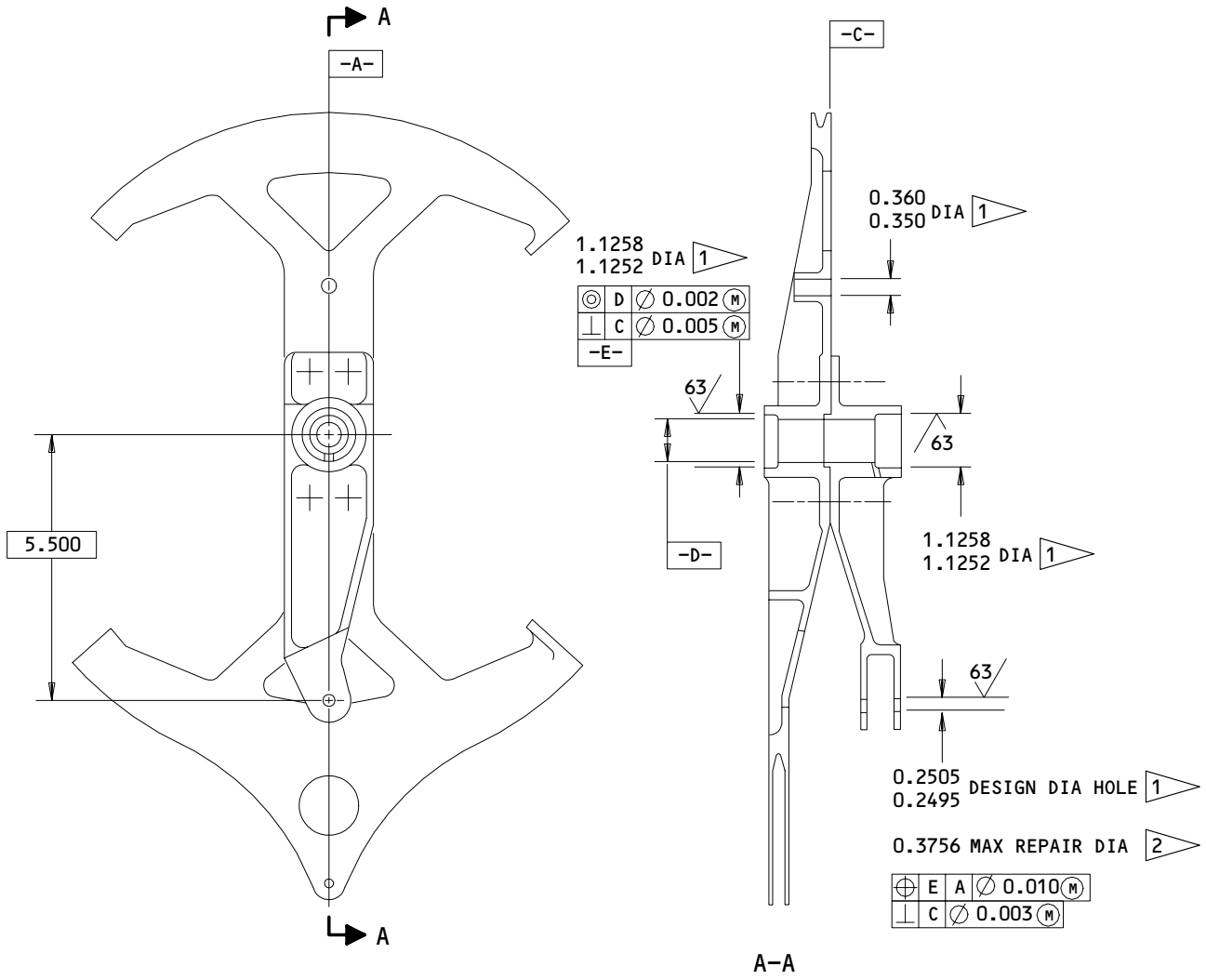
2. Bolt Hole Repair (Fig. 601)

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

   B. Manufacture repair bushing per Fig. 602.

   C. Install repair bushing per 20-50-03 except use wet sealant.

   D. Machine bushing ID to design dimension and finish shown.



REFINISH

APPLY 1 COAT OF ENAMEL (F-21.03)
ALL OVER EXCEPT OMIT ENAMEL ON SURFACE
INDICATED BY 1

1 OMIT ENAMEL THIS SURFACE

2 REPAIR LIMIT FOR INSTL OF REPAIR BUSHING

REPAIR

REF 2

125 MACHINED SURFACE UNLESS SHOWN DIFFERENTLY

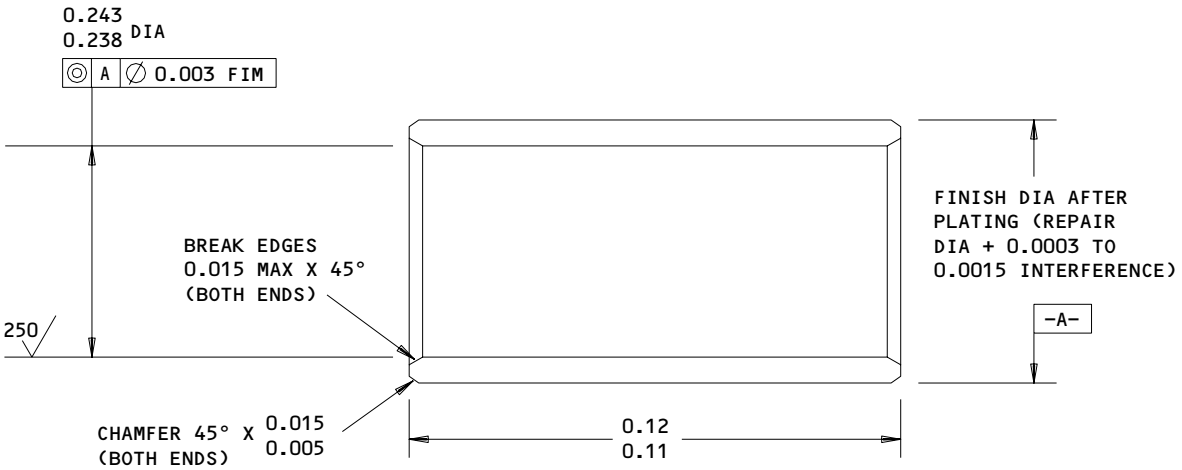
BREAK SHARP EDGES 0.008R

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

251T1315-2,-3
Quadrant Assembly Repair
Figure 601

143872



MATERIAL: AL-NI-BR PER AMS 4640

63 ALL MACHINED SURFACES EXCEPT AS NOTED

CADMIUM PLATE (F-15.06) ALL OVER

PLATING ON ID OPTIONAL

DIMENSIONS APPLY AFTER PLATING

ALL DIMENSIONS ARE IN INCHES

Repair Bushing Details
Figure 602

SUPPORT ASSY - REPAIR 2-1

251T1333-2, -3

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.

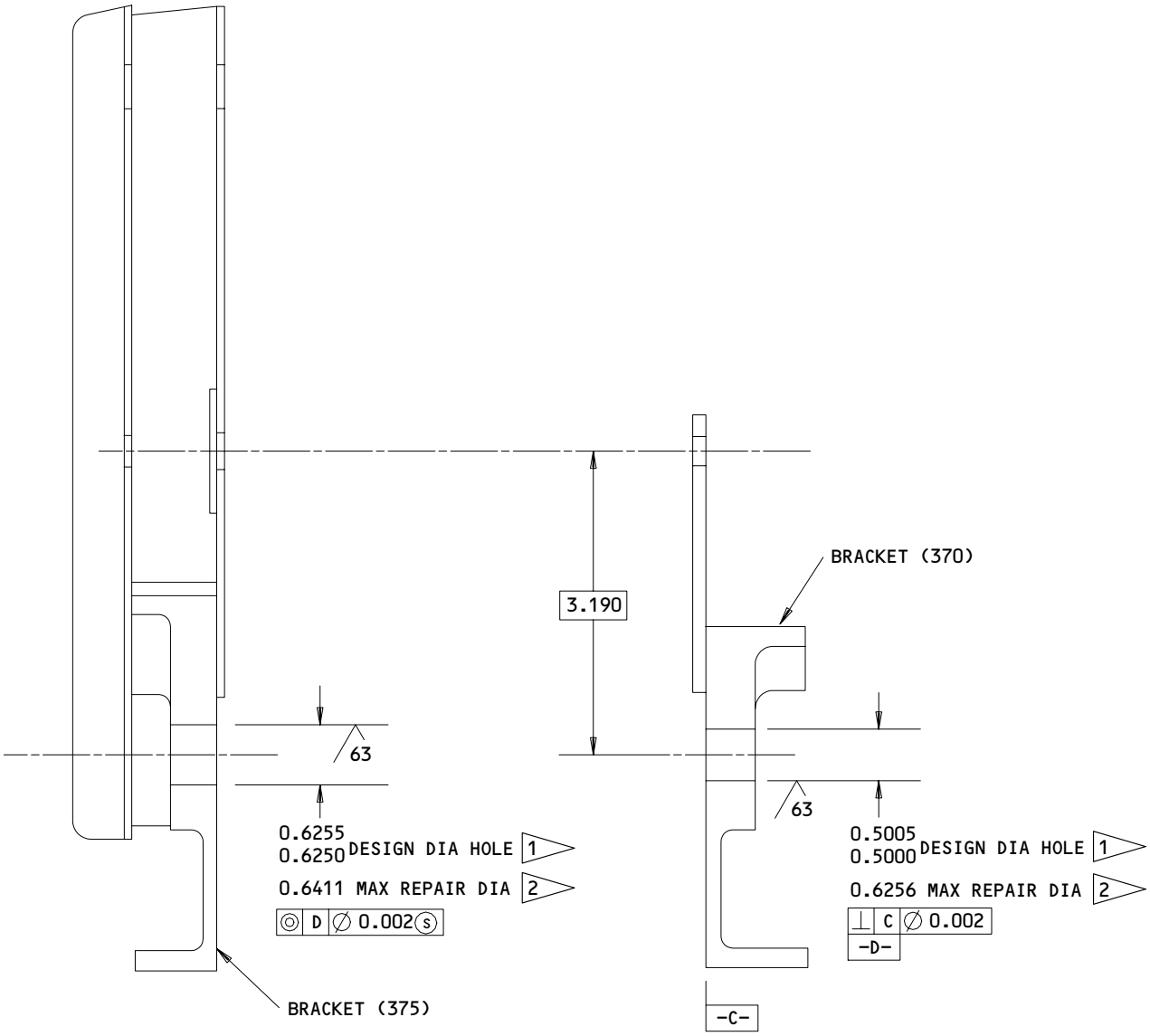
1. Bolt Hole Repair (Fig. 601)

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

   B. Manufacture repair bushing per Fig. 602.

   C. Install repair bushing per 20-50-03 except use wet sealant.

   D. Machine bushing ID to design dimension and finish shown.



REFINISH

TOUCH UP ALL UNPAINTED AREAS BY APPLYING ALODINE TO BARE ALUMINUM SURFACE AND 1 COAT OF PRIMER AND ENAMEL (F-21.16) EXCEPT OMIT ENAMEL IN ALL HOLES AND OMIT PRIMER AND ENAMEL IN HOLES INDICATED BY 1

1 OMIT PRIMER AND ENAMEL THIS SURFACE

2 REPAIR DIA FOR INSTL OF REPAIR BUSHING

REPAIR

REF 2

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK SHARP EDGES 0.008R

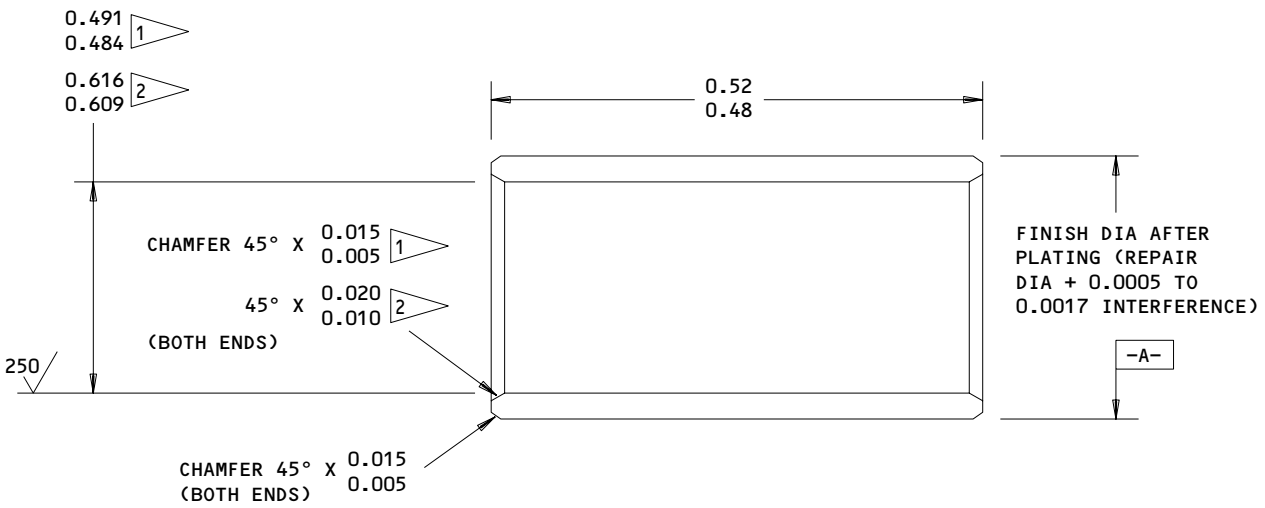
MATERIAL: AL ALLOY

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

251T1333-2,-3
Support Assembly Repair
Figure 601

143935



MATERIAL: AL-NI-BR PER AMS 4640

63 ALL MACHINED SURFACES EXCEPT AS NOTED

CADMIUM PLATE (F-15.06) ALL OVER

PLATING ON ID OPTIONAL

DIMENSIONS APPLY AFTER PLATING

ALL DIMENSIONS ARE IN INCHES

1 FOR 0.5005 0.5000 DESIGN DIA HOLE

2 FOR 0.6255 0.6250 DESIGN DIA HOLE

Repair Bushing Details
Figure 602

143879

DEBRIS GUARD ASSY - REPAIR 3-1

251T1363-1, -9

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

1. Marker Replacement

   A. Remove damaged marker.

   B. Install replacement marker per 20-50-05.

2. Refinish

   A. Braze assembly (100) -- Phosphate coat (F-14.14) and apply 1 coat of primer (F-20.02) and enamel (SRF-14.905-702) on exterior surfaces. Overspray allowed on open areas of screen.

   B. Braze assembly (100A) -- Phosphate coat (F-14.14) and apply 1 coat of primer (F-20.02) and enamel (SRF-14.905-702) on exterior surfaces. Omit primer and enamel from open areas of screen.

DEBRIS GUARD ASSY - REPAIR 4-1

251T1376-1

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

1. Marker Replacement

   A. Remove damaged marker.

   B. Install replacement marker per 20-50-05.

2. Refinish

   A. Welded assembly (65) -- Phosphate coat (F-14.14) and apply 1 coat of primer (F-20.02) and enamel (SRF-14.905-702) on exterior surfaces. Omit primer and enamel from open areas of screen.

MISCELLANEOUS PARTS REFINISH - REPAIR 5-1

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

IPL FIG. & ITEM	MATERIAL	FINISH
Fig. 1		
Fitting (130)	Al alloy	Chromic acid anodize and apply 1 coat of primer (F-18.13) then apply enamel (F-21.03) except omit primer and enamel in hole.
Bolt (135)	15-5PH CRES 180-200 ksi	Cadmium plate (F-15.06) all over.
Crank (210), quadrant (215)	Al alloy	Chromic acid anodize and apply 1 coat of primer (F-18.13) all over.
Brackets (280,285, 300)	Al alloy	Chromic acid anodize and apply 1 coat of primer (F-18.13) then apply enamel (SRF-14.905-702) all over.
Bracket (325)	Al alloy	Chemical treat and apply 1 coat of primer (F-18.06) then apply enamel (SRF-14.905-702) all over.
Bracket assembly (330)		Apply 1 coat of enamel (SRF-14.905-702) all over.
Doubler (340), bracket (345)	Al alloy	Chemical treat and apply 1 coat of primer (F-18.06) all over.
Brackets (360 thru 375)	Al alloy	Chromic acid anodize and apply 1 coat of primer (F-18.13) then apply enamel (F-21.03) all over.

Refinish Details
Figure 601

ASSEMBLY

1. Material

   NOTE: Equivalent substitutes may be used.

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

2. Assembly (IPL Fig. 1)

   A. Install bolt (230), spacers (235, 237), and nut (240) on support assembly (245).

   B. Install retainer (225) and secure with rivets (220).

   C. Install screw (170), washer (175A), spacer (180) and nut (185) on quadrant assembly (190).

   D. Apply a thin coat of grease to all surfaces of bearing (165) and install spacer (150) and bearing (165) in quadrant assembly (190).

   E. Apply a thin coat of grease to all surfaces of bushing (145) and install bushing in support assembly (245).

   F. Apply a thin coat of grease to shank and threads of bolt (135) and threads of nut (160). Position quadrant assembly (190) in support assembly (245) and install bolt (135), spacer (155), washer (140A) and nut (160). Tighten nut to 80-110 lb-ins.

   G. Apply a thin coat of grease to bushings (42). Position fitting (130) on debris guard assembly (50 or 85) and install bolt (35), bushings (42) and collar (40).

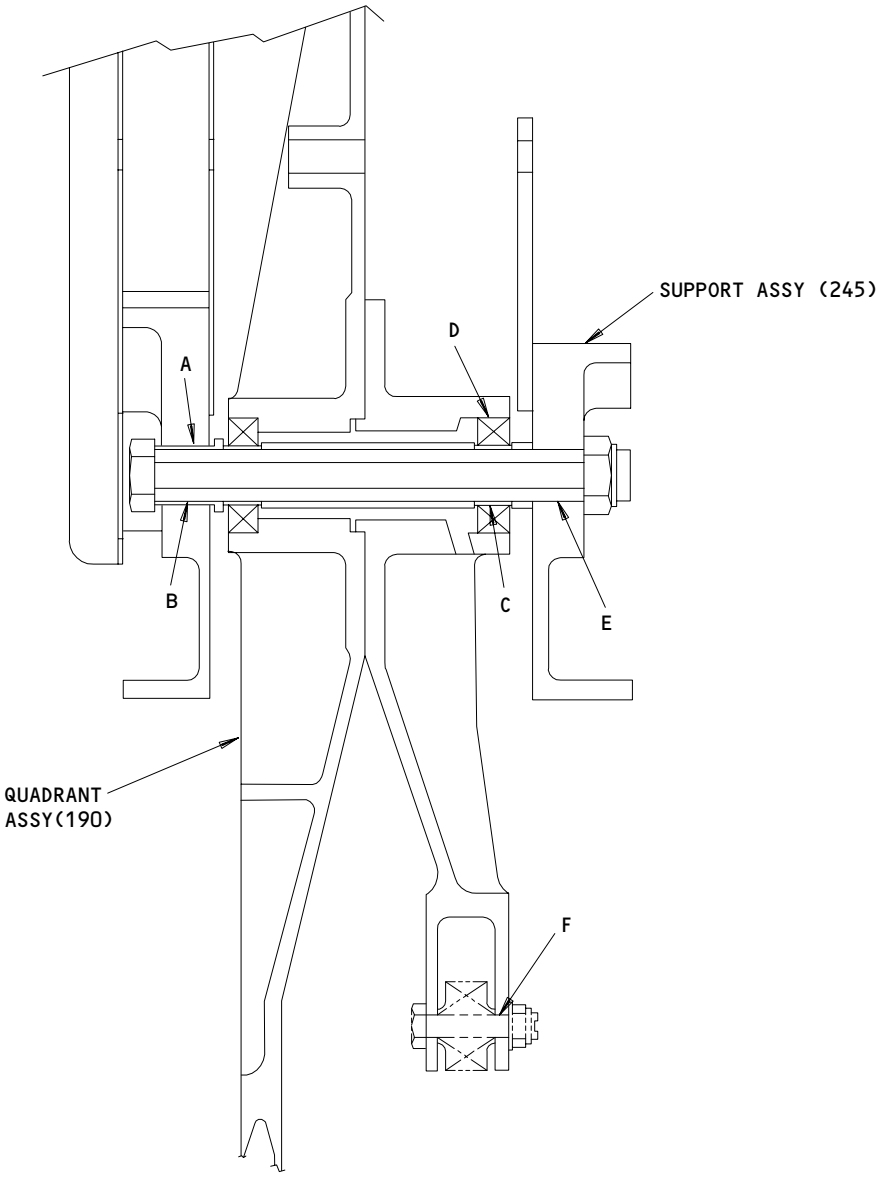
   H. Apply a thin coat of grease to bushings (25) and bolts (5, 10). Position debris guard assembly (50 or 85) on support assembly (245) and secure with bolts (5, 10) washers (15A), bushing (25) and nuts (20).

   CAUTION: RIVETS (45, 125) ARE SHEAR RIVETS. SUBSTITUTION OF RIVETS IS NOT ALLOWED.

   I. Install rivets (45, 125). If debris guard assembly (50 or 85) is replaced, drill 0.254-0.265 in. diameter rivet holes using hole locations on support assembly (245) for rivet (45, 125).

3. Store this component using standard industry practices and information contained in 20-44-02.

FITS AND CLEARANCES



Fits and Clearances
Figure 801 (Sheet 1)

Ref Letter Fig.801	Mating Item No. IPL Fig.1	Design Dimension				Service Wear Limit		
		Dimension		Assembly Clearance		Dimension		Maximum Clearance
		Min	Max	Min	Max	Min	Max	
A	ID 245 OD 145	0.6250 0.6240	0.6255 0.6245	0.0005	0.0015	0.6220	0.6280	0.0035
B	ID 145 OD 135	0.5000 0.4989	0.5006 0.4994	0.0006	0.0017	0.4969	0.5031	0.0037
C	ID 165 OD 135	0.4997 0.4989	0.5000 0.4994	0.0003	0.0011	0.4969	0.5025	0.0031
D	ID 190 OD 165	1.1252 1.1246	1.1258 1.1250	0.0002	0.0012	1.1226	1.1282	0.0032
E	ID 245 OD 135	0.5000 0.4989	0.5005 0.4994	0.0006	0.0016	0.4969	0.5030	0.0036
F	ID 190 OD *[1]	0.2495 0.2485	0.2505 0.2495	0.0000	0.0020	0.2465	0.2535	0.0040

*[1] INSTALLATION PART BACB30NF4

ALL DIMENSIONS ARE IN INCHES

Fits and Clearances
Figure 801 (Sheet 2)

143950

FOR TORQUE VALUES OF STANDARD FASTENERS, REFER TO 20-50-01			
ITEM NO. IPL FIG. 1	NAME	TORQUE	
		POUND-INCHES	POUND-FEET
160	NUT	80-110	

Torque Table
Figure 802

143951

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

K8455 RHP BEARINGS PLC RHP AEROSPACE
OLDENDS LANE
STONEHOUSE GL10 3RM UK

0PTK6 SPS TECHNOLOGIES INC AEROSPACE PRODUCTS DIV
5195 W 4700 SPO BOX 18459
KEARNS, UTAH 84118

06725 AIR INDUSTRIES CORPORATION
12570 KNOTT STREET
GARDEN GROVE, CALIFORNIA 92641-3932

08524 DEUTSCH FASTENER CORP SEE CODE V97928

09192 ALUMINUM COMPANY OF AMERICA VERNON WORKS
5151 ALCOA AVENUE
VERNON, CALIFORNIA 90058-3715

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

15653 MICRODOT INC AEROSPACE FASTENING SYS KAYNAR MFG DIV
800 SOUTH STATE COLLEGE BLVD PO BOX 3001
FULLERTON, CALIFORNIA 92634-3001

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

VENDORS

38443 MRC BEARINGS
402 CHANDLER STREET
JAMESTOWN, NEW YORK 14701-3802

40920 MPB MINIATURE PRECISION BEARING DIV
PRECISION PARK PO BOX 547
KEENE, NEW HAMPSHIRE 03431

42838 NATIONAL RIVET AND MANUFACTURING COMPANY
1-21 EAST JEFFERSON STREET
WAUPUN, WISCONSIN 53963-2028

43991 FAG BEARING INCORPORATED
118 HAMILTON AVENUE
STAMFORD, CONNECTICUT 06904

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

53551 ALLFAST FASTENING SYSTEMS INC
15200 EAST DON JULIAN ROAD PO BOX 3166
CITY OF INDUSTRY, CALIFORNIA 91745-1001

55580 BRILES RIVET CORP
2640 VISTA PACIFIC DRIVE
OCEANSIDE, CALIFORNIA 92056-3514

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

60516 WEST COAST AEROSPACE INC
812 MIRAFLORES STREET
SAN PEDRO, CALIFORNIA 90731-1439

VENDORS

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

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

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

85495 BRILES MFG CO SEE OMARK INDUSTRIES
PRECISION FASTENING SUB OF OMARK IND INC SEE DEUTSCH FASTENER CORP V08524

92215 FAIRCHILD IND INC FAIRCHILD AEROSP FASTNR DIV DESIGN & ENGRG
3000 WEST LOMITA BLVD
TORRANCE, CALIFORNIA 90505-5102

97928 DEUTSCH FASTENER CORP
3969 PARAMONT BOULEVARD
LAKEWOOD, CALIFORNIA 90712-4193

98996 OLYMPIA FASTENING INV SEE V53551

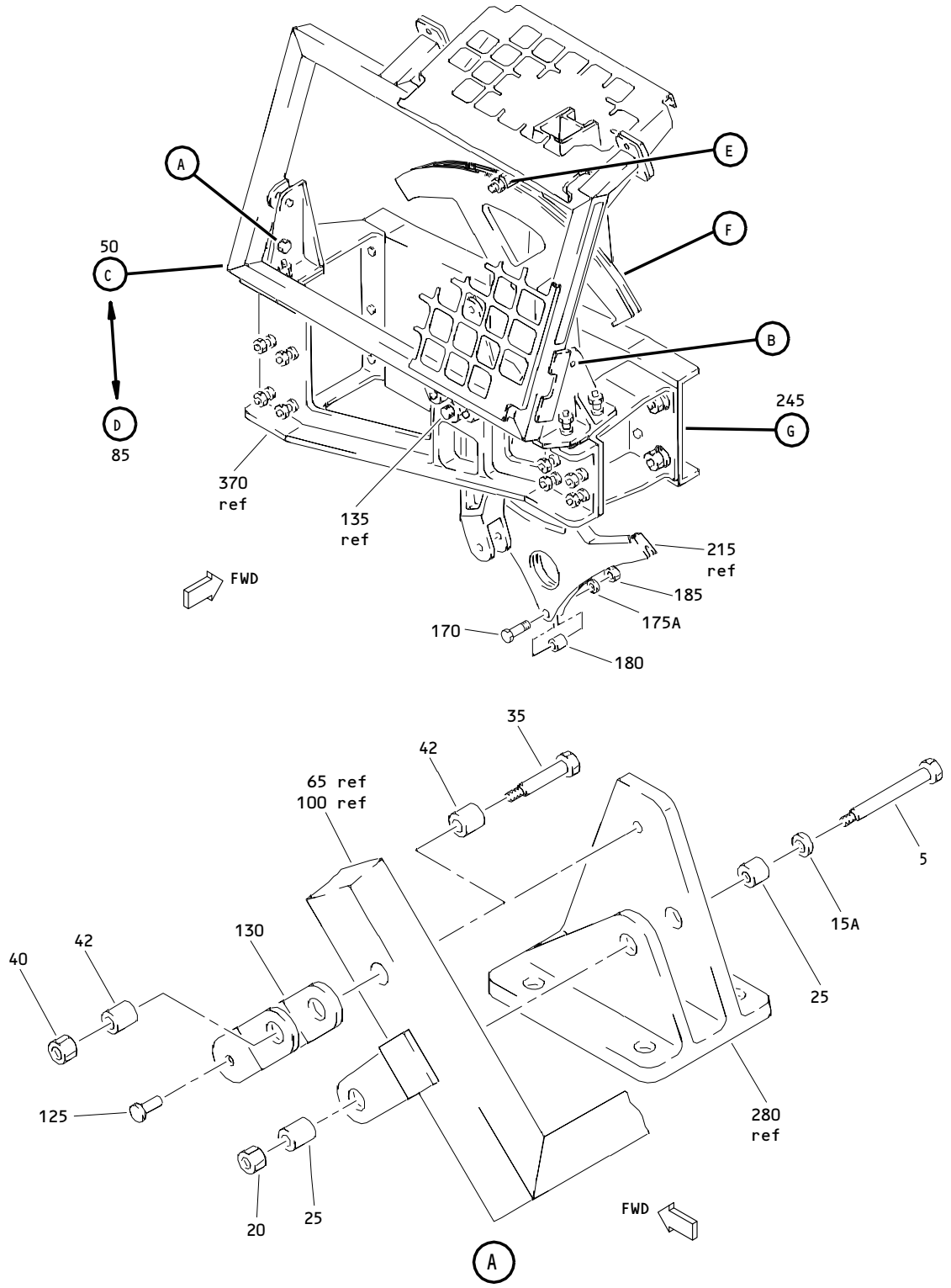
PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
ACMKP8AA39O8		1	165A	1
		1	195A	1
ACMKP8AP26LY198		1	195A	1
AF517-3-3		1	220	2
BACB1OAP8		1	165	1
		1	195	1
BACB1OFS8R		1	195A	1
BACB28AKO3-035		1	42	2
BACB28AKO4-035		1	25	3
BACB3OFM6-24		1	35	1
BACB3OMY6K4		1	260	1
BACB3OMY6K5		1	255	1
BACB3OMY6K6		1	250	4
BACB3OMY8K5		1	350	15
BACB3OMY8K6		1	200	4
BACB3ONF4-11		1	10	1
BACB3ONF4-13		1	5	1
BACB3ONF4-43		1	230	1
BACB3ONW6K18		1	290	2
BACB3OTZ6K16		1	310	4
BACC3OBE6		1	315	4
BACC3OM6		1	40	1
		1	275	6
		1	295	2
BACC3OM8		1	205	4
		1	355	15
BACN1OJC3		1	185	1
BACN1OJC4		1	20	2
		1	240	1
BACN1OJC8		1	160	1
BACR1OG43		1	225	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACR15BA4AD		1	55	4
		1	90	4
BACR15BB4AD		1	335	2
BACR15BB4AD6		1	125	1
BACR15BB4AD8		1	45	1
BACR15BB5AD		1	305	8
BACR15DR3P3		1	220	2
BACS40R9F20F		1	270	1
BACS40U3L2		1	265	1
BAC27TCT0301		1	75	1
		1	115	1
BAC27TCT0302		1	80	1
		1	120	1
BMN4122AD3-8		1	160	1
BRH10A3		1	185	1
BRH10A4		1	20	2
		1	240	1
B30NW6K18		1	290	2
CCR274SS3-3		1	220	2
HL10VAZ6-4		1	260	1
HL10VAZ6-5		1	255	1
HL10VAZ6-6		1	250	4
HL10VAZ8-5		1	350	15
HL10VAZ8-6		1	200	4
HL10V6-6		1	250	4
HL11VAZ6-18		1	290	2
HL18PB6-24		1	35	1
HL79-6		1	40	1
		1	275	6
HL79-6		1	295	2
HL79-8		1	205	4
		1	355	15

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
H10-3BAC		1	185	1
H10-4BAC		1	20	2
		1	240	1
H10-8BAC		1	160	1
LLMKP8A		1	165	1
		1	195	1
L800-6-6		1	250	4
L803-6K18		1	290	2
MCS28E		1	165	1
		1	195	1
MKP8A		1	165	1
		1	195	1
MKP8AFS428		1	165	1
		1	195	1
MKP8AG20		1	165	1
		1	195	1
MKP8ALY196		1	165	1
		1	195	1
MKP8ATT		1	165	1
		1	195	1
MKP8A2TS		1	165	1
		1	195	1
MKP8E6531		1	165	1
		1	195	1
NAS1149D0332J		1	175A	1
NAS1149D0416J		1	15A	2
NAS1149D0816J		1	140A	1
NAS42DD6-18		1	180	1
NAS42DD6-24		1	320	2
NAS42DD8-168		1	235	1
NAS463WDD416		1	237	1
NAS623-3-7		1	170	1
NAS75-8-008		1	155	1
NAS75-8-204		1	150	1
NS202101-02		1	185	1
NS202101-048		1	20	2
		1	240	1
RMLH9074-8		1	160	1
RMLH9075-3W		1	185	1

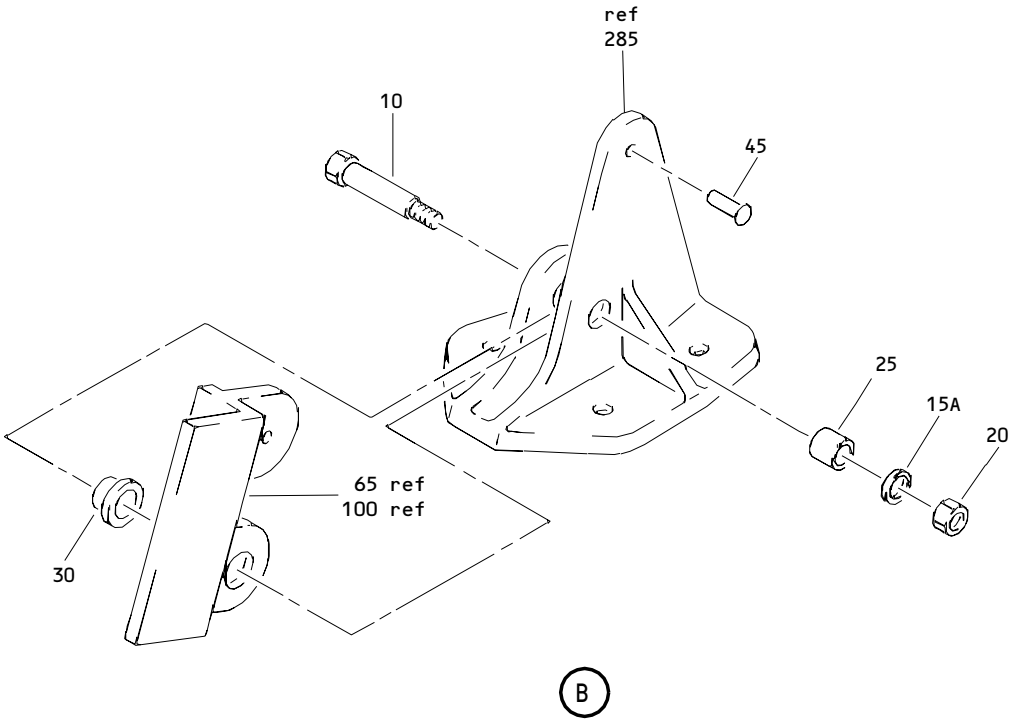
PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
RMLH9075-4W		1	20	2
		1	240	1
RV570A3-3		1	220	2
T6S1032J		1	185	1
T6S428J		1	20	2
		1	240	1
VN303A02		1	185	1
VN303A048		1	20	2
		1	240	1
WC22-6-24		1	35	1
2SC3C06		1	315	4
251T1288-8		1	105	1
251T1300-4		1	1	RF
251T1300-5		1	1A	RF
251T1300-6		1	1B	RF
251T1300-7		1	1C	RF
251T1313-1		1	370	1
251T1315-2		1	190	1
251T1315-3		1	190A	1
251T1316-2		1	215	1
251T1317-1		1	210	1
251T1318-1		1	375	1
251T1319-1		1	360	1
251T1319-2		1	360A	1
251T1332-1		1	365	1
251T1333-2		1	245	1
251T1333-3		1	245A	1
251T1336-1		1	300	1
251T1363-1		1	85	1
251T1363-10		1	100A	1
251T1363-2		1	100	1
251T1363-3		1	110	1
251T1363-9		1	85A	1
251T1365-1		1	280	1
251T1366-1		1	285A	1
251T1369-1		1	130	1
251T1370-2		1	325	1
251T1370-3		1	340	1
251T1370-5		1	330	1
251T1370-6		1	345	1
251T1373-1		1	60	2
		1	95	2
251T1374-1		1	285	1
251T1375-1		1	70	1
251T1376-1		1	50	1
251T1376-2		1	65	1
251T1544-4		1	135	1

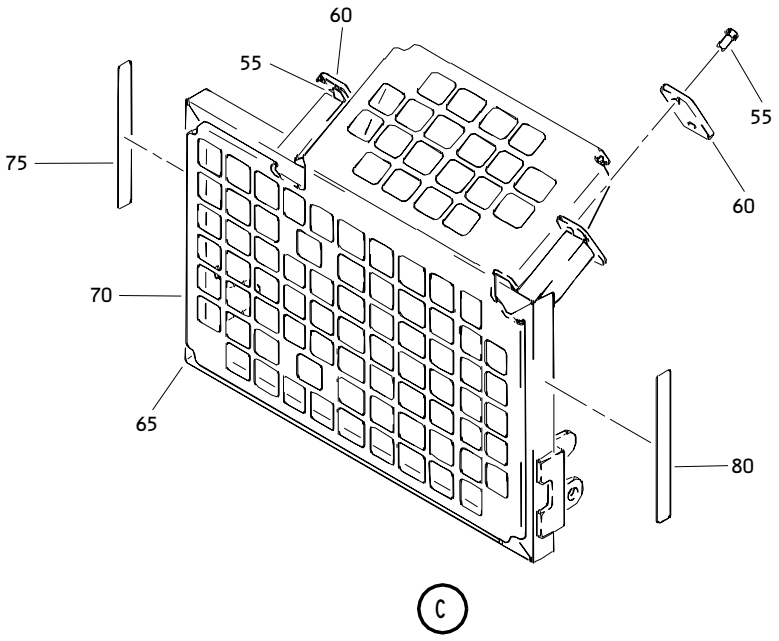
PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
251T3742-1		1	30	1
251T3742-16		1	145	1
48FT820		1	160	1
62550-6-24		1	35	1
66014-6		1	40	1
		1	275	6
		1	295	2
66014-8		1	205	4
		1	355	15
6800D048		1	225	1
96-02		1	185	1
96-048		1	20	2
		1	240	1



Aileron Control Right Wheel Well Quadrant Assembly
Figure 1 (Sheet 1)

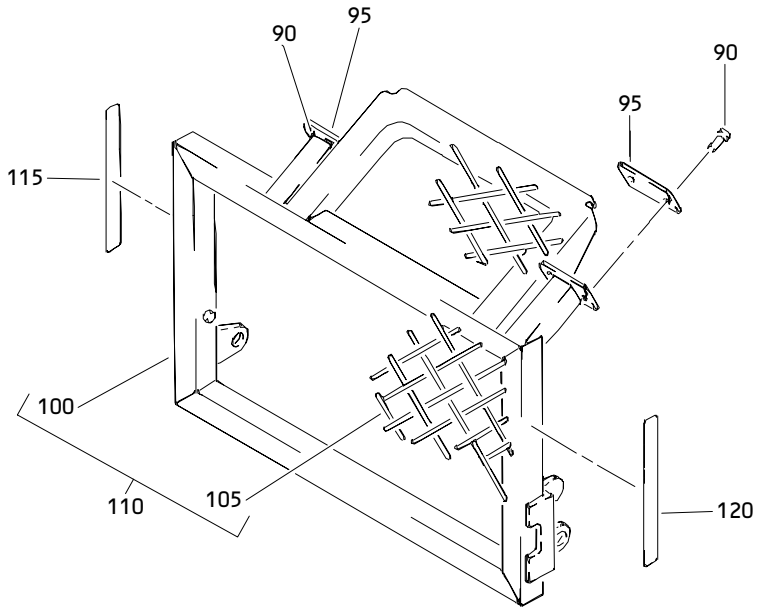
T93553





Aileron Control Right Wheel Well Quadrant Assembly
Figure 1 (Sheet 2)

T93554



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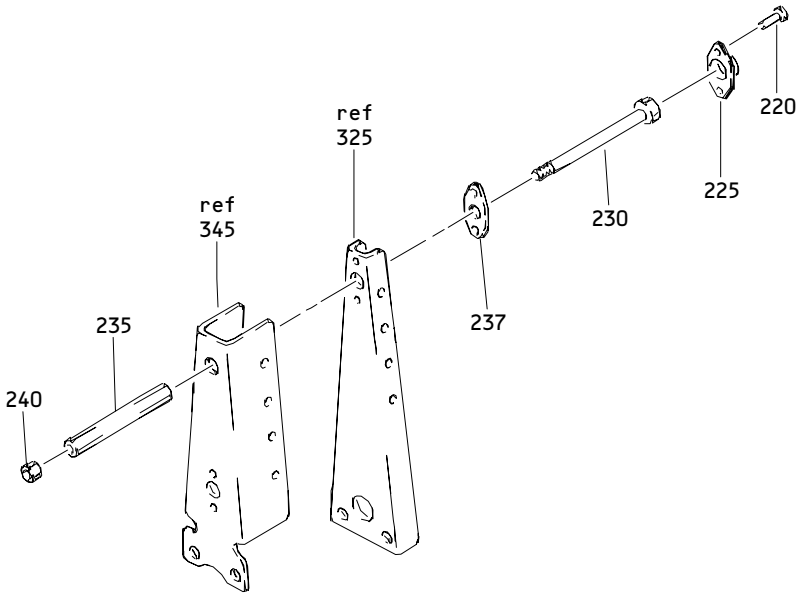

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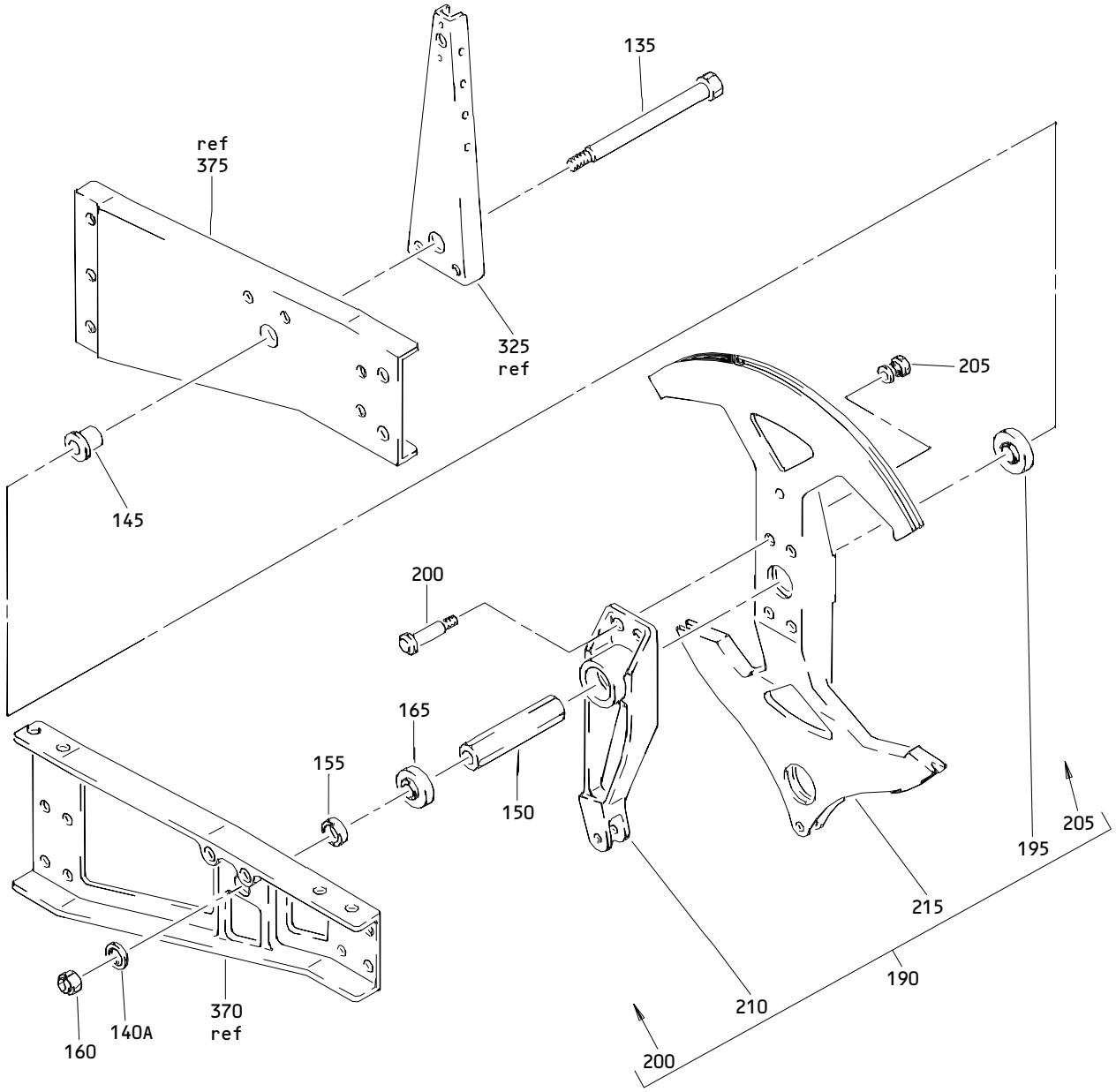
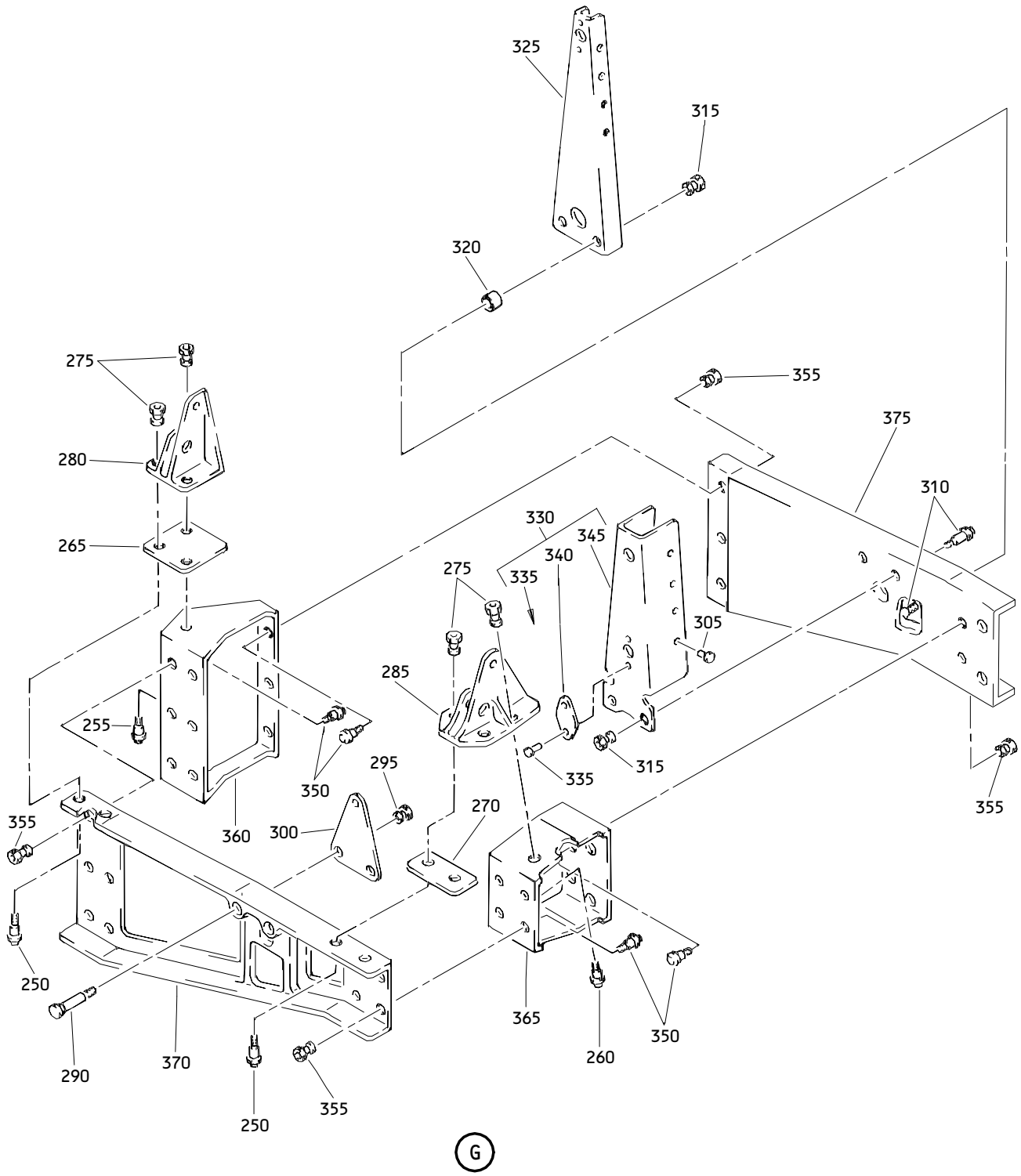
Aileron Control Right Wheel Well Quadrant Assembly
Figure 1 (Sheet 3)

T93555



Aileron Control Right Wheel Well Quadrant Assembly
Figure 1 (Sheet 4)

T93556



Aileron Control Right Wheel Well Quadrant Assembly
Figure 1 (Sheet 5)

T93557

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	-1	251T1300-4		QUADRANT ASSY-AIL. CONT RT WHEEL WELL	A	RF
	-1A	251T1300-5		QUADRANT ASSY-AIL. CONT RT WHEEL WELL	B	RF
R	-1B	251T1300-6		QUADRANT ASSY-AIL. CONT RT WHEEL WELL	C	RF
R	-1C	251T1300-7		QUADRANT ASSY-AIL. CONT RT WHEEL WELL	D	RF
	5	BACB30NF4-13		.BOLT		1
	10	BACB30NF4-11		.BOLT		1
	15	AN960PD416L		DELETED		
R	15A	NAS1149D0416J		.WASHER		2
	20	H10-4BAC		.NUT- (V15653) (SPEC BACN10JC4) (OPT NS202101-048 (V80539)) (OPT RMLH9075-4W (V72962)) (OPT T6S428J (V71087)) (OPT VN303A048 (V92215)) (OPT 96-048 (V80539)) (OPT BRH10A4 (V52828))		2
	25	BACB28AK04-035		.BUSHING		3
R	30	251T3742-1		.BUSHING		1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-35	HL18PB6-24		.BOLT- (V56878) (SPEC BACB30FM6-24) (OPT HL18PB6-24 (V73197)) (OPT HL18PB6-24 (V92215)) (OPT HL18PB6-24 (V97928)) (OPT HL18PB6-24 (V80539)) (OPT WC22-6-24 (V60516)) (OPT 62550-6-24 (V56878)) (OPT HL18PB6-24 (V60516)) (OPT HL18PB6-24 (V08524))		1
	40	HL79-6		.COLLAR- (V56878) (SPEC BACC30M6) (OPT HL79-6 (V73197)) (OPT HL79-6 (V92215)) (OPT 66014-6 (V56878))		1
	42	BACB28AK03-035		.BUSHING		2
	45	BACR15BB4AD8		.RIVET- (V09192) (SPEC BACR15BB4AD8) (OPT BACR15BB4AD8 (V42838)) (OPT BACR15BB4AD8 (V53551)) (OPT BACR15BB4AD8 (V55580))		1
R	50	251T1376-1		.GUARD ASSY-DEBRIS (OPT ITEMS 85, 85A)	A	1
R	-50A	251T1376-1		.GUARD ASSY-DEBRIS (OPT ITEM 85B)	B-D	1
	55	BACR15BA4AD		..RIVET- (SIZE DETERMINE ON INST)		4
	60	251T1373-1		..COVER		2

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	65	251T1376-2		..WELD ASSY-FRAME		1
	70	251T1375-1		...SCREEN		1
	75	BAC27TCT0301		..MARKER-ALUMINUM FOIL		1
	80	BAC27TCT0302		..MARKER-ALUMINUM FOIL		1
	85	251T1363-1		.GUARD ASSY-DEBRIS (OPT ITEMS 50, 85A)	A	1
	-85A	251T1363-9		.GUARD ASSY-DEBRIS (OPT ITEMS 50, 85)	A	1
R	-85B	251T1363-9		.GUARD ASSY-DEBRIS (OPT ITEM 50A)	B-D	1
	90	BACR15BA4AD		..RIVET- (SIZE DETERMINE ON INST)		4
	95	251T1373-1		..COVER		2
	100	251T1363-2		..BRAZE ASSY- (USED ON ITEM 85)		1
	-100A	251T1363-10		..BRAZE ASSY- (USED ON ITEM 85A)		1
	105	251T1288-8		...SCREEN		1
	110	251T1363-3		...WELD ASSY-FRAME		1
	115	BAC27TCT0301		..MARKER-ALUMINUM FOIL		1
	120	BAC27TCT0302		..MARKER-ALUMINUM FOIL		1
	125	BACR15BB4AD6		.RIVET		1
	130	251T1369-1		.FITTING		1
	135	251T1544-4		.BOLT		1
	140	AN960JD816L		DELETED		
R	140A	NAS1149D0816J		.WASHER		1
	145	251T3742-16		.BUSHING		1
	150	NAS75-8-204		.SPACER		1
	155	NAS75-8-008		.SPACER		1
	160	H10-8BAC		.NUT- (V15653) (SPEC BACN10JC8) (OPT BMN4122A8 (V85495)) (OPT RMLH9074-8 (V72962)) (OPT 48FT820 (V56878)) (OPT BMN4122AD3-8 (V08524)) (OPT BMN4122AD3-8 (V97928))		1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-165	MKP8A		.BEARING (V38443) (SPEC BACB10AP8) (OPT LLMKP8A (V38443)) (OPT MKP8AFS428 (V21335)) (OPT MKP8ATT (V43991)) (OPT MKP8A2TS (V43991)) (OPT MKP8E6531 (V21335)) (OPT MKP8AG20 (V38443)) (OPT MKP8ALY196 (V40920)) (OPT MKP8A (V38443)) (OPT MCS28E (VK8455)) (REPLD BY ITEM 165A)	A,B	1
	-165A	ACMKP8AA3908		.BEARING (REPLS ITEM 165)		1
	170	NAS623-3-7		.SCREW		1
	175	AN960PD10L		DELETED		
R	175A	NAS1149D0332J		.WASHER		1
	180	NAS42DD6-18		.SPACER		1
	185	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))		1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-190	251T1315-2		.QUADRANT ASSY (REPLD BY ITEM 190A)	A,B	1
R	-190A	251T1315-3		.QUADRANT ASSY (REPLS ITEM 190)		1
	195	MKP8A		..BEARING- (V38443) (SPEC BACB10AP8) (OPT LLMKP8A (V38443)) (OPT MKP8AFS428 (V21335)) (OPT MKP8ATT (V43991)) (OPT MKP8A2TS (V43991)) (OPT MKP8E6531 (V21335)) (OPT MKP8AG20 (V38443)) (OPT MKP8ALY196 (V40920)) (OPT MKP8A (V38443)) (OPT MCS28E (VK8455)) (REPLD BY ITEM 195A)	A,B	1
R	-195A	ACMKP8AA3908		..BEARING- (V21335) (SPEC BACB10FS8R) (OPT ACMKP8AP26LY198 (V40920)) (REPLS ITEM 195)		1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
200	HL10VAZ8-6		..BOLT- (V60516) (SPEC BACB30MY8K6) (OPT HL10VAZ8-6 (VOPTK6))		4
205	HL79-8		..COLLAR- (V56878) (SPEC BACC30M8) (OPT HL79-8 (V73197)) (OPT HL79-8 (V92215)) (OPT 66014-8 (V56878))		4
210	251T1317-1		..CRANK		1
215	251T1316-2		..QUADRANT		1
220	AF517-3-3		.RIVET- (V53551) (SPEC BACR15DR3P3) (OPT CCR274SS3-3 (V11815)) (OPT RV570A3-3 (V98996))		2
225	6800D048		.RETAINER- (V80539) (SPEC BACR10G43)		1
230	BACB30NF4-43		.BOLT		1
235	NAS42DD8-168		.SPACER		1
237	NAS463WDD416		.SPACER		1
240	H10-4BAC		.NUT- (V15653) (SPEC BACN10JC4) (OPT NS202101-048 (V80539)) (OPT RMLH9075-4W (V72962)) (OPT T6S428J (V71087)) (OPT VN303A048 (V92215)) (OPT 96-048 (V80539)) (OPT BRH10A4 (V52828))		1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-245	251T1333-2		.SUPPORT ASSY	A-C	1
R	-245A	251T1333-3		.SUPPORT ASSY	D	1
	250	HL10VAZ6-6		..BOLT- (V60516) (SPEC BACB30MY6K6) (OPT HL10VAZ6-6 (V0PTK6)) (OPT HL10V6-6 (V73197)) (OPT HL10V6-6 (V80539)) (OPT HL10V6-6 (V92215)) (OPT L800-6-6 (V97928)) (OPT HL10VAZ6-6 (V73197)) (OPT HL10VAZ6-6 (V92215)) (OPT HL10VAZ6-6 (V97928)) (OPT L8006K6 (V06725))		4
	255	HL10VAZ6-5		..BOLT- (V60516) (SPEC BACB30MY6K5) (OPT HL10VAZ6-5 (V0PTK6))		1
	260	HL10VAZ6-4		..BOLT- (V60516) (SPEC BACB30MY6K4) (OPT HL10VAZ6-4 (V0PTK6))		1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
265	BACS40U3L2		..SHIM		AR
270	BACS40R9F20F		..SHIM		AR
275	HL79-6		..COLLAR- (V56878) (SPEC BACC30M6) (OPT HL79-6 (V73197)) (OPT HL79-6 (V92215)) (OPT 66014-6 (V56878))		6
280	251T1365-1		..BRACKET		1
285	251T1374-1		..BRACKET- (OPT ITEM 285A)		1
-285A	251T1366-1		..BRACKET- (OPT ITEM 285)		1
290	HL11VAZ6-18		..BOLT- (V56878) (SPEC BACB30NW6K18) (OPT B30NW6K18 (V97928)) (OPT HL11VAZ6-18 (V73197)) (OPT HL11VAZ6-18 (V92215)) (OPT HL11VAZ6-18 (V97928)) (OPT L803-6K18 (V06725)) (OPT HL11VAZ6-18 (VOPTK6)) (OPT HL11VAZ6-18 (V60516))		2
295	HL79-6		..COLLAR- (V56878) (SPEC BACC30M6) (OPT HL79-6 (V73197)) (OPT HL79-6 (V92215)) (OPT 66014-6 (V56878))		2

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
300	251T1336-1		..BRACKET		1
305	BACR15BB5AD		..RIVET- (SIZE DETERMINE ON INST)		8
310	BACB30TZ6K16		..BOLT		4
315	2SC3C06		..COLLAR- (V17446) (SPEC BACC30BE6) (OPT 2SC3C06 (V92215))		4
320	NAS42DD6-24		..SPACER		2
325	251T1370-2		..BRACKET-CABLE GUARD		1
330	251T1370-5		..BRACKET ASSY-CABLE GUARD		1
335	BACR15BB4AD		...RIVET- (SIZE DETERMINE ON INST)		2
340	251T1370-3		...DOUBLER		1
345	251T1370-6		...BRACKET		1
350	HL10VAZ8-5		..BOLT- (V60516) (SPEC BACB30MY8K5) (OPT HL10VAZ8-5 (VOPTK6))		15
355	HL79-8		..COLLAR- (V56878) (SPEC BACC30M8) (OPT HL79-8 (V73197)) (OPT HL79-8 (V92215)) (OPT 66014-8 (V56878))		15
360	251T1319-1		..BRACKET	A-C	1
R -360A	251T1319-2		..BRACKET	D	1
365	251T1332-1		..BRACKET		1
370	251T1313-1		..BRACKET		1
375	251T1318-1		..BRACKET		1