TO: ALL HOLDERS OF LEFT HAND LATERAL CENTRAL CONTROL ACTUATOR INPUT CRANK TORQUE TUBE AND BRACKET ASSEMBLY COMPONENT MAINTENANCE MANUAL 27-11-16

REVISION NO. 13 DATED JUL 01/04

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	Add top assembly 251T1305-17 per PRR B13232.
1	
TR & SB RECORD	
1	
301	
401	
501	
REPAIR 2-1	
601,604	
REPAIR 3-1	
601,603	
REPAIR 4-1	
601-603	
REPAIR 5-1	
601-603	
REPAIR 6-1	
601-602	
702,705	
803-805	
1002-1013,1017-1025, 1033-1036,1038-1050	
REPAIR 1-1	Identified bracket-cage 251T1322-9 in REPAIR 1-1 and
601	IPL Fig. 2 Sheet 3 as Item 57.
1029,1033,1047	
REPAIR 2-1	Revised refinish requirements for bracket assembly
602	251T1323-3 in REPAIR 2-1, Fig. 601.

CHAPTER/SECTION AND PAGE NO.	DESCRIPTION OF CHANGE
REPAIR 3-1 602-603	Revised requirements for bracket assembly 251T1324 in REPAIR 3-1, Fig. 601 and Fig. 602.
REPAIR 5-1 602	Revised requirements for input crank assembly 251T1346-4, -5, -6 in REPAIR 5-1, Fig. 601 Sheet 1.

LEFT-HAND LATERAL CENTRAL CONTROL ACTUATOR INPUT CRANK TORQUE TUBE AND BRACKET ASSEMBLY

PART NUMBER 251T1305-9 THRU -17

COMPONENT MAINTENANCE MANUAL
WITH
ILLUSTRATED PARTS LIST

13251

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

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PAGE	DATE	CODE
ASSEMBLY		
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ILLUSTRATED PARTS LIST		
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*1003	JUL 01/04	01.1
*1004	JUL 01/04	01.1
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*1006	JUL 01/04	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.

LEFT HAND LATERAL CENTRAL CONTROL ACTUATOR INPUT CRANK TORQUE TUBE AND BRACKET ASSEMBLY

DESCRIPTION AND OPERATION

1. The left hand lateral central control actuator input crank torque tube and bracket assembly consists of a torque tube assembly, two aluminum bracket assemblies and a brace assembly. The torque tube and bracket assembly transmits inputs from the aileron control feel mechanism assembly through control rods to the lateral central control actuators.

2. Leading Particulars (approximate)

   Length -- 22 inches
   Width -- 10 inches
   Height -- 10 inches
   Weight -- 6 lbs.

DISASSEMBLY

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

1. Use standard industry practices to disassemble this component.

NOTE: Do not disassemble bolt assembly (5A, IPL Fig. 1; 5, IPL Fig. 2; 5, IPL Fig. 3), bracket assemblies (60, 75A, IPL Fig. 1; 55, 65, IPL Fig. 2; 55, 65, IPL Fig. 3), brace assembly (90, IPL Fig. 1; 80, IPL Fig. 2; 80, IPL Fig. 3), tube assembly (120H thru 120L, IPL Fig. 1; 120, IPL Fig. 2; 120, IPL Fig. 3), or remove bracket (250, IPL Fig. 1) or grommet (255, IPL Fig. 1) or water shield (260, IPL Fig. 2; 230, IPL Fig. 3) unless necessary for repair or replacement.

CLEANING

1. Clean all parts except bearings using standard industry practices (Ref 20-30-03) and additional procedures in the following steps.

2. Clean all sealed bearings (70, 85, 100, 105A, IPL Fig. 1; 60, 75, 100, 105, 185, IPL Fig. 2; 60, 75, 100, 105, IPL Fig. 3) per manufacturer's instructions. Clean all other bearings per SOPM 20–30–01.

CHECK

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

2. Magnetic particle check per SOPM 20-20-01 -- Bushing (43, 45, IPL Fig. 1; 45, IPL Fig. 2; 45, IPL Fig. 3).

3. Penetrant check per SOPM 20-20-02 -- Bolt (15A, IPL Fig. 1; 15, IPL Fig. 2; 15, IPL Fig. 3), bracket (65, 80A, IPL Fig. 1; 57, 70, IPL Fig. 2; 57, 70, IPL Fig. 3), brace (97, 98, IPL Fig. 1; 90, 95, IPL Fig. 2; 90, 95, IPL Fig. 3), sleeve (110, 115, IPL Fig. 1; 110, 115, IPL Fig. 2; 110, 115, IPL Fig. 3), fittings (125A, 135A, 165, IPL Fig. 1; 125, 135, 165, IPL Fig. 2; 125, 135, IPL Fig. 3), crank (145, 155, 195A, 200C, IPL Fig. 1; 145, 155, 210, 225, IPL Fig. 2; 140, 145, 180, 195, IPL Fig. 3), tube (215, 220, IPL Fig. 1; 235, 240, IPL Fig. 2; 205, 210, IPL Fig. 3).

REPAIR - GENERAL

1. Content

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

P/N	NAME	REPAIR
251T1322	BRACKET	1-1
251T1323	BRACKET	2-1
251T1324	BRACE	3-1
251T1345	TORQUE TUBE	4-1
251T1346	INPUT CRANK	5-1
- -	MISC PARTS REFINISH	6-1
- -	BUSHING SEALING	7-1

2. Standard Practices

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

   20-41-01 Decoding Table for Boeing Finish Codes
   20-41-02 Application of Chemical and Solvent Resistant Finishes
   20-43-01 Chromic Acid Anodizing
   20-50-03 Bearing Installation and Retention

3. Materials

   NOTE: Equivalent substitutes may be used.

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

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

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

   D. Deleted.

E. Deleted.

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

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

BRACKET ASSEMBLY - REPAIR 1-1

251T1322-1, -3, -5, -7, -8

NOTE: Refer to REPAIR-GEN for list of applicable standard practices. For repair of bracket (65, IPL Fig. 1; 57, IPL Fig. 2; 57, IPL Fig. 3) which may only require restoration of original finish, refer to Refinish instructions.

1. Bearing Replacement

   A. Remove the bearing (70, IPL Fig. 1; 60, IPL Fig. 2; 60, IPL Fig. 3) from the cage bracket (65, IPL Fig. 1; 57, IPL Fig. 2; 57, IPL Fig. 3).

   B. Install the replacement bearing (70, IPL Fig. 1; 60, IPL Fig. 2; 60, IPL Fig. 3) with BMS 3-24 grease and roller swage (SOPM 20-50-03).

2. Refinish

   A. Bracket (65, IPL Fig. 1) -- Chromic acid anodize and apply one coat of BMS 10-11, Type 1 primer (F-18.13) all over. Omit primer from all holes except in 0.363-0.327 inch diameter hole. Material: Aluminum alloy.

   B. Bracket (57, IPL Fig. 2; 57, IPL Fig. 3) - Boric acid-sulfuric acid anodize (F-17.35) and apply a layer of BMS 10-11, Type 1 primer (F-20.02) and apply a layer of BMS 10-60 enamel (SRF-14.9812) all over. Omit primer (F-20.02) from all the holes. Material: Aluminum alloy.

BRACKET ASSEMBLY - REPAIR 2-1

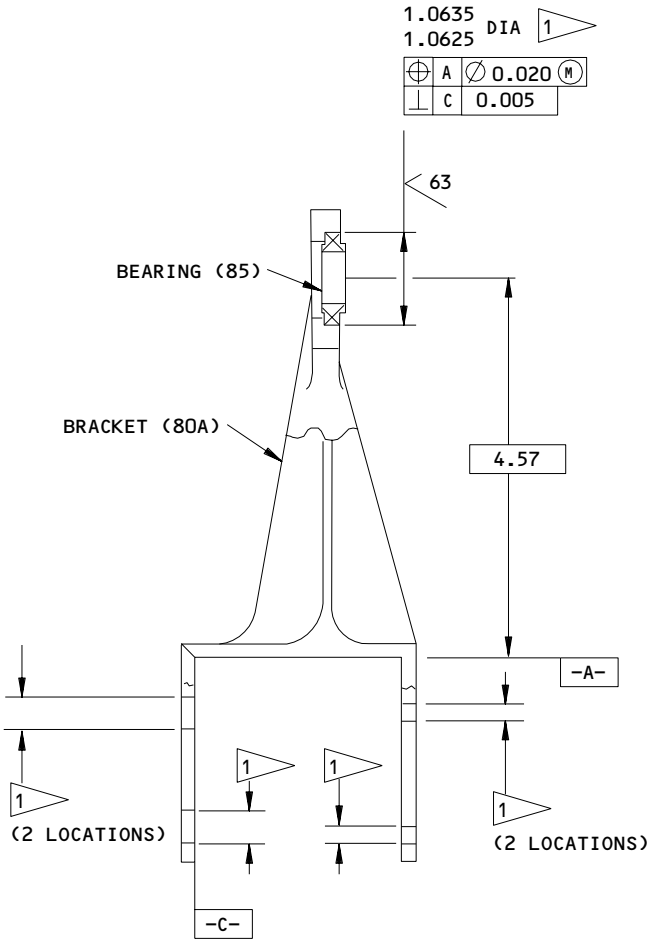
251T1323-3, -5

NOTE: Refer to REPAIR-GEN for list of applicable standard practices. For repair of bracket (80A, IPL Fig. 1; 70, IPL Fig. 2; 70, IPL Fig. 3) which may only require restoration of the original finish, refer to Refinish instructions, Figs. 601 and 602.

1. Bearing Replacement (Fig. 601 and 602)

   A. Remove the bearing (85, IPL Fig. 1; 75, IPL Fig. 2; 75, IPL Fig. 3) from the cage bracket (80A, IPL Fig. 1; 70, IPL Fig. 2).

   B. Install the replacement bearing (85, IPL Fig. 1; 75, IPL Fig. 2; 75, IPL Fig. 3) with BMS 5-95 sealant and roller swage (SOPM 20-50-03).



REFINISH

BRACKET (80A) -- CHROMIC ACID ANODIZE (F-17.04) AND APPLY ONE COAT OF BMS 10-11, TYPE 1 PRIMER (F-20.03) ALL OVER EXCEPT AS NOTED 1

1 OMIT PRIMER FROM THIS SURFACE

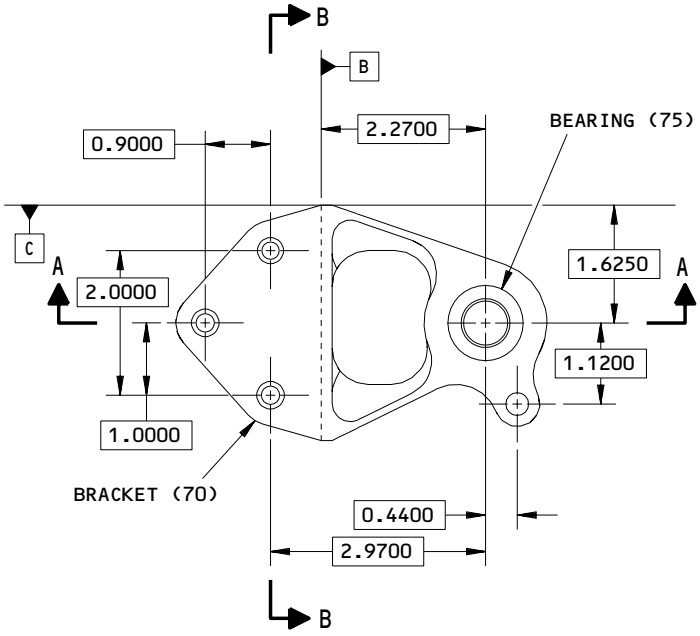
MATERIAL: AL ALLOY

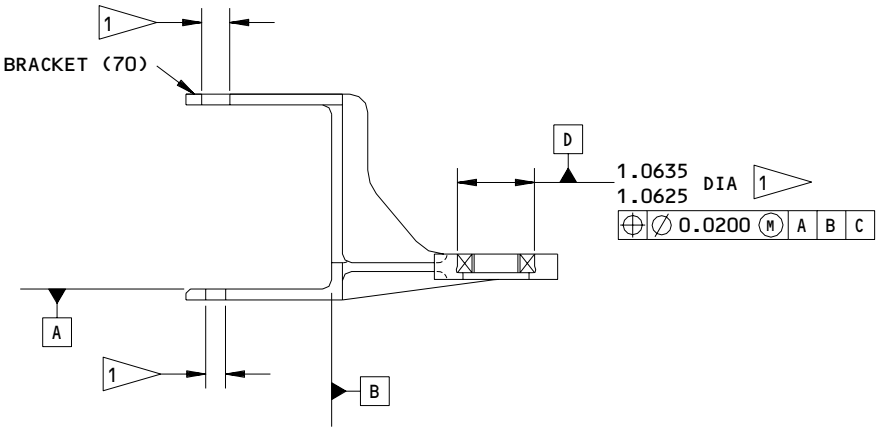
ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

251T1323-3
Bracket Assembly - Bearing Replacement
Figure 601

13256

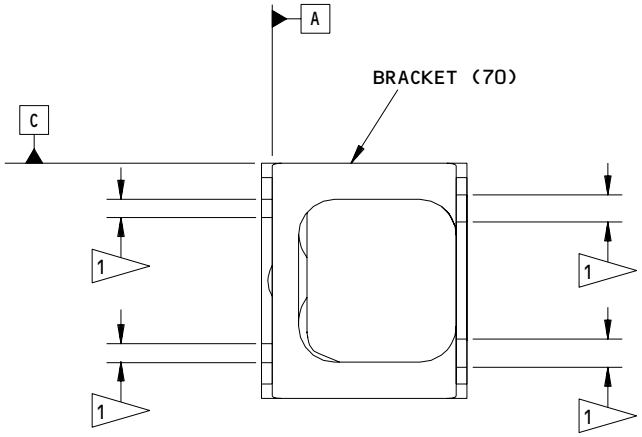




A-A

251T1323-5
Bracket Assembly - Bearing Replacement
Figure 602 (Sheet 1)

K25756



B-B

REFINISH

BRACKET (70) -- BORIC ACID-SULFURIC ACID ANODIZE (F-17.35) AND APPLY A LAYER OF BMS 10-11, TYPE 1 PRIMER (F-20.02) AND APPLY A LAYER OF BMS 10-60 ENAMEL (SRF-14.9813) ALL OVER EXCEPT AS NOTED BY 1

1 OMIT PRIMER (F-20.02) AND ENAMEL (SRF-14.9813) ON THIS SURFACE

MATERIAL: AL ALLOY

ITEM NUMBERS REFER TO IPL FIG. 2,3

ALL DIMENSIONS ARE IN INCHES

251T1323-5
Bracket Assembly - Bearing Replacement
Figure 602 (Sheet 2)

K25768

BRACE ASSEMBLY - REPAIR 3-1

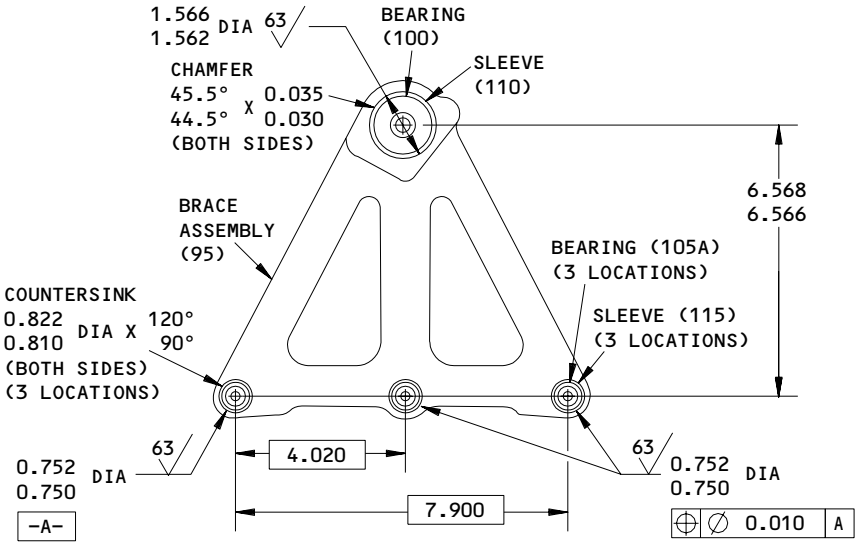
251T1324-1, -3, -4, -5

NOTE: Refer to REPAIR-GEN for list of applicable standard practices. For repair of brace (97, 98, IPL Fig. 1; 90, 95, IPL Fig. 2; 90, 95, IPL Fig. 3) which may only require stripping and restoration of the original finish, refer to Refinish instructions, Figs. 601 and 602.

1. Bearing Replacement (Fig. 601 and 602)

   A. Remove the bearings (100, 105A, IPL Fig. 1; 100, 105, IPL Fig. 2; 100, 105, IPL Fig. 3) and sleeves (110, 115, IPL Fig. 1; 110, 115, IPL Fig. 2; 110, 115, IPL Fig. 3) from the brace (97, 98, IPL Fig. 1; 90, 95, IPL Fig. 1; 90, 95, IPL Fig. 2).

   B. Install the new sleeves (110, 115, IPL Fig. 1; 110, 115, IPL Fig. 2) and new bearings (85, IPL Fig. 1; 75, IPL Fig. 2; 75, IPL Fig. 3) into brace (97, 98, IPL Fig. 1; 90, 95, IPL Fig. 2; 90, 95, IPL Fig. 3) with BMS 5-95 sealant and roller swage (SOPM 20-50-03). After roller swage, fill gap in sleeves (110, 115, IPL Fig. 1; 110, 115, IPL Fig. 2; 110, 115, IPL Fig. 3) with BMS 5-95 sealant.



REFINISH

BRACE (97,98) -- CHROMIC ACID ANODIZE AND APPLY ONE COAT OF BMS 10-11, TYPE 1 PRIMER (F-18.13) ALL OVER EXCEPT OMIT PRIMER FROM ALL HOLES.

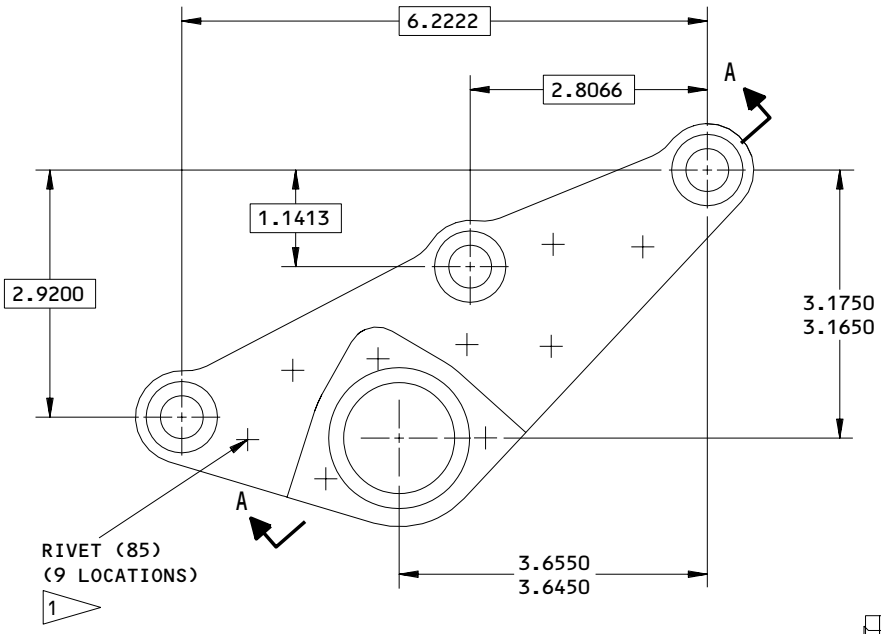
BRACE ASSEMBLY (90) -- APPLY ONE COAT BMS 10-11, TYPE 1 PRIMER (F-14.9961)

MATERIAL: AL ALLOY

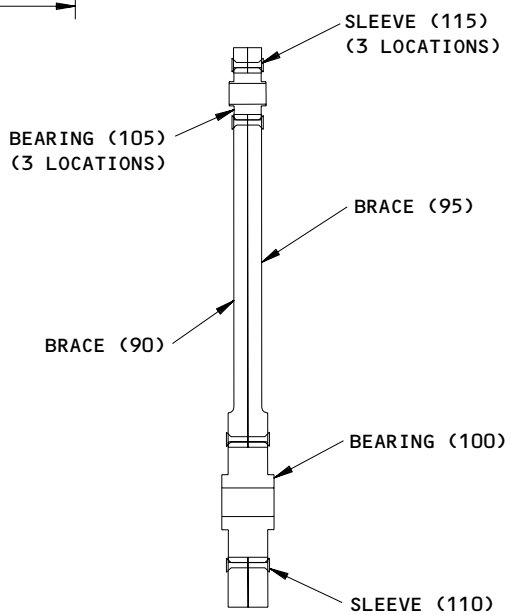
ALL DIMENSIONS ARE IN INCHES

ITEM NUMBERS REFER TO IPL FIG. 1

251T1324-1,-3
Brace Assembly - Bearing Replacement
Figure 601



251T1325-4,-5



A-A

REFINISH

BRACE (90,95) -- BORIC ACID-SULFURIC ACID ANODIZE (F-17.31) AND APPLY A LAYER OF BMS 10-11, TYPE 1 PRIMER (F-20.02) AND APPLY A LAYER OF BMS 10-60 ENAMEL (SRF-14.9813)

MATERIAL: AL ALLOY

ITEM NUMBERS REFER TO IPL FIG. 2,3

ALL DIMENSIONS ARE IN INCHES

1 TOUCH UP FINISH WITH BMS 10-11, TYPE 1 PRIMER (F-20.02) AND A LAYER OF BMS 10-60 ENAMEL (SRF-14.9813)

251T1324-4,-5
Brace Assembly - Bearing Replacement
Figure 602

K25840

TORQUE TUBE ASSEMBLY - REPAIR 4-1

251T1345-9,-10,-11,-12,-13

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

1. Parts Replacement (Fig. 601)

   A. Remove rivets (130, 140, 150, 160, 170, 180, IPL Fig. 1; 130, 140, 150, 160, 170, 180, IPL Fig. 2; 130, IPL Fig. 3) and parts to be replaced as necessary.

   B. Install new part(s) on torque tube. Using holes in fittings (125A, 135A, 165, IPL Fig. 1; 125, 135, 165, IPL Fig. 2; 125, 135, IPL Fig. 3), cranks (145, 155, IPL Fig. 1; 145, 155, IPL Fig. 2; 140, 145, IPL Fig. 3) or crank assembly (175C, IPL Fig. 1; 175, IPL Fig. 2; 150, IPL Fig. 3) as applicable as guides, drill holes, as noted, in replacement.

      NOTE: Tube assembly (210, IPL Fig. 1; 230, IPL Fig. 2; 200, IPL Fig. 3) for parts replacement when fittings, cranks or crank assembly are replaced.

   C. Remove parts, deburr and reinstall with BMS 5-95 sealant.

   D. Secure with rivets shown.

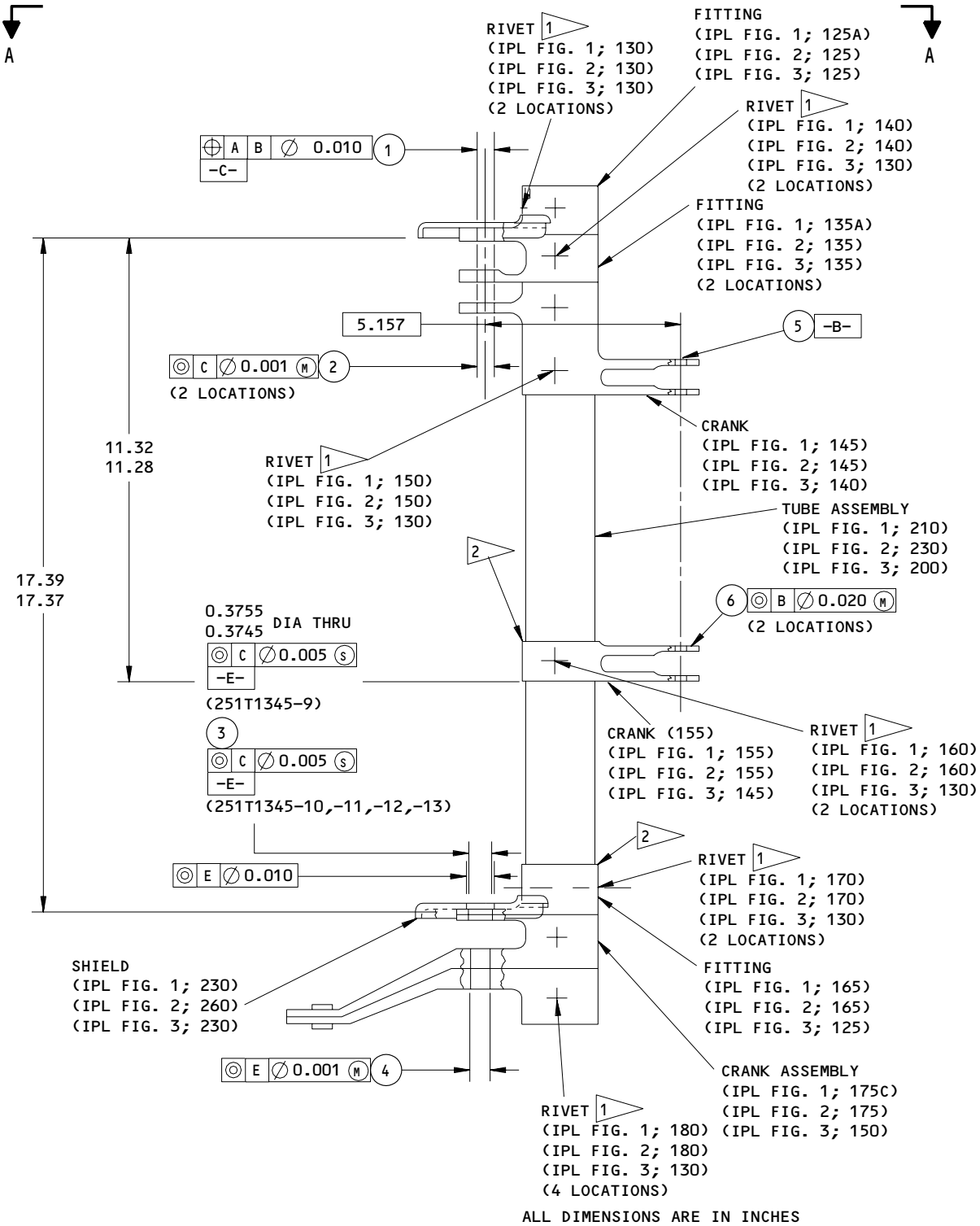
2. Hole Repair (Fig. 601)

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

   B. Manufacture repair bushing per Fig. 602.

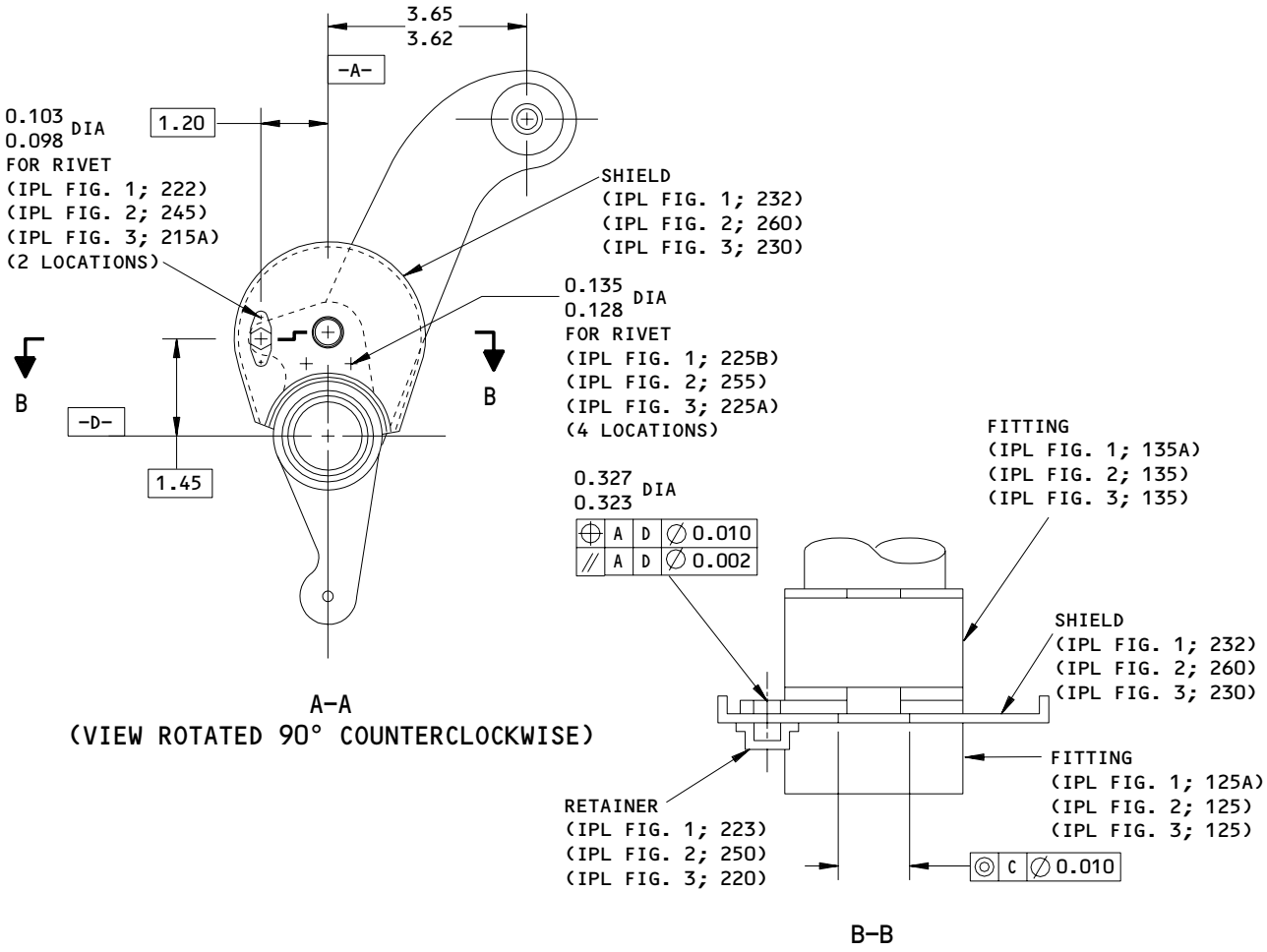
   C. Install repair bushing using shrink fit method with sealant, BMS 5-95.

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



251T1345-9 thru -13
Torque Tube Assembly - Parts Replacement
Figure 601 (Sheet 1)

13258



HOLE LOCATION	1	2	3	4	5	6
DESIGN DIA	0.6255 0.6245	0.5005 0.4995	0.6255 0.6245	0.5005 0.4995	0.2505 0.2495	0.2505 0.2495
MAX REPAIR DIA 3	0.6411	0.6256	0.6411	0.5161	0.3756	0.3756

1 0.263 / 0.260 DIA FOR RIVETS (IPL FIG. 1; 130,140,150,160,170,180)
(IPL FIG. 2; 130,140,150,160,170,180)
(IPL FIG. 3; 130)

2 FILLET SEAL WITH SEALANT, BMS 5-95 (TYPICAL)

3 REPAIR LIMITS FOR INSTALLATION OF REPAIR BUSHING

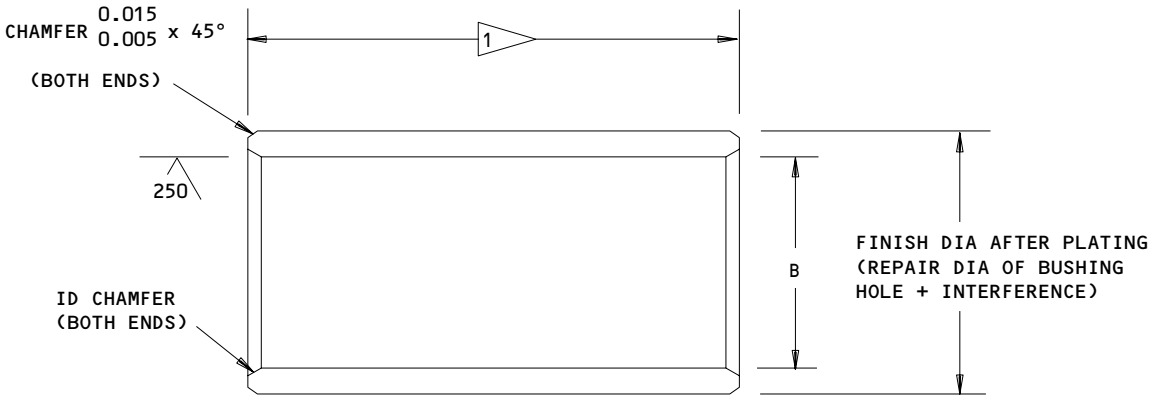
125 ALL MACHINED SURFACES

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

251T1345-9 thru -13
Torque Tube Assembly - Parts Replacement
Figure 601 (Sheet 2)

93092



HOLE LOCATION	(1)	(2)	(3)	(4)	(5)	(6)
B DIA	0.616 0.609	0.491 0.484	0.616 0.609	0.491 0.484	0.243 0.238	0.243 0.238
ID CHAMFER X 45°	0.020 0.010	0.015 0.005	0.020 0.010	0.015 0.005	0.015 MAX	0.015 MAX
INTERFERENCE	0.0017 0.0005	0.0017 0.0005	0.0017 0.0005	0.0017 0.0005	0.0011 0.0003	0.0011 0.0003

MATERIAL: AL-NI-BR PER AMS 4640

63 ALL MACHINED SURFACES EXCEPT AS NOTED

CADMIUM PLATE (F-15.06), PLATING ON ID OPTIONAL

DIMENSIONS APPLY AFTER PLATING

OD AND ID MUST BE PARALLEL AND CONCENTRIC WITHIN 0.003 TIR

ALL DIMENSIONS ARE IN INCHES

1 LUG THICKNESS +0.000/-0.005

Repair Bushing Details
Figure 602

INPUT CRANK ASSEMBLY - REPAIR 5-1

251T1346-4,-5,-6,-7

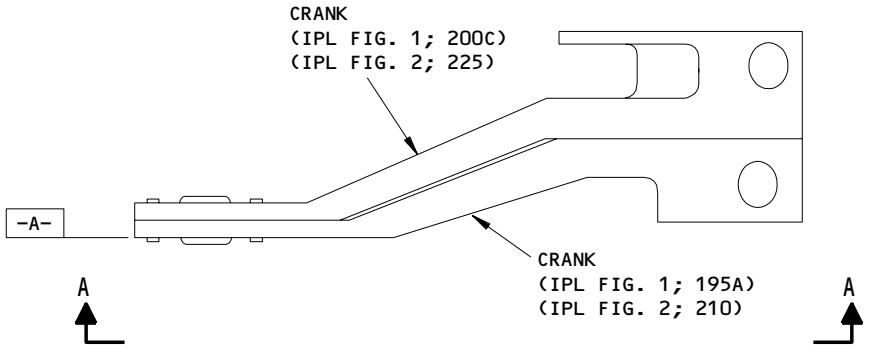
NOTE: Refer to REPAIR-GENERAL for a list of applicable standard practices. For repair of crank assembly (175C, IPL Fig. 1; 175, IPL Fig. 2; 150, IPL Fig. 3) which may only require restoration of original finish, refer to Refinish instructions, Fig. 601.

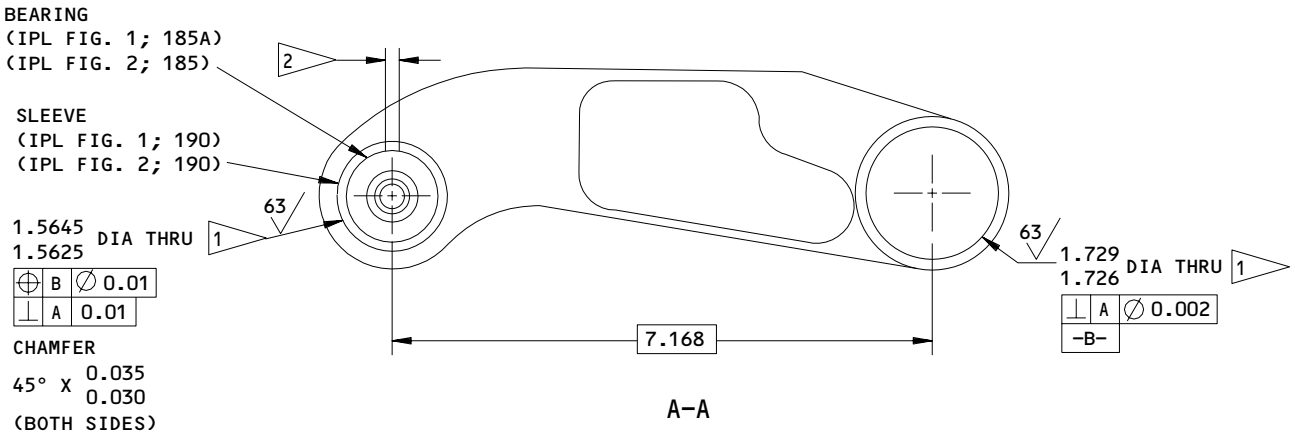
1. Bearing Replacement (Fig. 601)

   A. Remove the bearing (185A, IPL Fig. 1; 185, IPL Fig. 2; 155, IPL Fig. 3) and sleeve (190, 115, IPL Fig. 1; 190, IPL Fig. 2) from the cranks (195A, 200C, IPL Fig. 1; 210, 225, IPL Fig. 2)

   B. Install new sleeves (190, IPL Fig. 1; 190, IPL Fig. 2; 160, IPL Fig. 3) and new bearing (185A, IPL Fig. 1; 185, IPL Fig. 2) into cranks (195A, 200C, IPL Fig. 1; 210, 225, IPL Fig. 2; 180, 195, IPL Fig. 3) with BMS 5-24 grease and roller swage (SOPM 20-50-03).

   C. Fill gap in sleeve (IPL Fig. 1, 190; IPL Fig. 2, 190) with BMS 5-95 sealant.





REFINISH

CRANK ASSEMBLY (IPL FIG. 1; 175C),(IPL FIG. 2; 175) -- CHEMICAL TREAT (F-17.10) AND APPLY 1 COAT OF PRIMER (F-20.02) EXCEPT OMIT PRIMER FROM BEARING AND SLEEVE AND AS NOTED BY 1

CRANK (IPL FIG. 1; 195A,200B),(IPL FIG. 2; 210,225) CHROMIC ACID ANODIZE AND APPLY ONE COAT OF BMS 10-11, TYPE 1 PRIMER (F-18.13) ALL OVER EXCEPT AS SHOWN BY 1

1 OMIT PRIMER FROM THIS HOLE

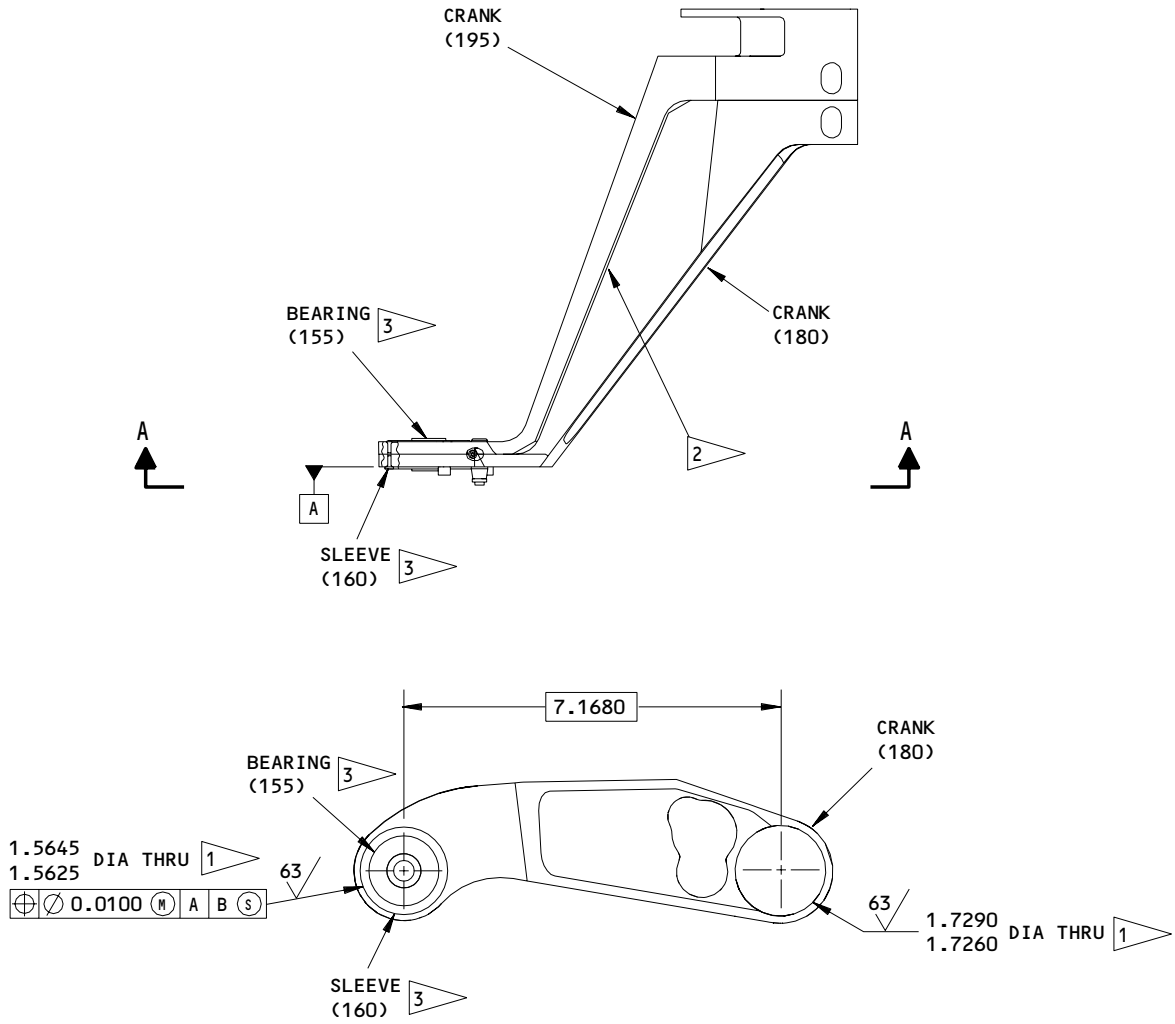
2 0.062 MAX GAP. FILL GAP WITH BMS 5-95 SEALANT

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

25IT1346-4,-5,-6
Input Crank Assembly - Parts Replacement
Figure 601

13259



A-A

REFINISH

CRANK ASSEMBLY (150) -- CHEMICAL TREAT (F-17.10) AND APPLY ONE COAT OF PRIMER (F-20.02) EXCEPT OMIT PRIMER FROM BEARING AND SLEEVE AND AS NOTED BY 1

CRANK (180,195) BORIC ACID - SULFURIC ACID ANODIZE (F-17.31) AND APPLY ONE COAT OF BMS 10-11, TYPE 1 PRIMER (F-20.02)

1 OMIT PRIMER FROM THIS HOLE

2 ASSEMBLE AND FILL GAP WITH BMS 5-95 SEALANT

3 INSTALL AND ROLLER SWAGE SLEEVE WITH BMS 3-24 GREASE. BMS 3-33 GREASE OPTIONAL

ITEM NUMBERS REFER TO IPL FIG. 3

ALL DIMENSIONS ARE IN INCHES

25IT1346-7
Input Crank Assembly - Parts Replacement
Figure 602

W89262

MISCELLANEOUS PARTS REFINISH - REPAIR 6-1

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

IPL FIG. & ITEM	MATERIAL	FINISH
Fig. 1		
Fitting (135A)	Al alloy	Chromic acid anodize and apply one coat BMS 10-11, type 1 primer (F-18.13) all over except omit primer from hole.
Fitting (125A,165) Crank (145,155)	Al alloy	Chromic acid anodize and apply one coat BMS 10-11, type 1 primer (F-18.13) all over except omit primer from all holes.
Shield (230,232) Bracket (250)	Al alloy	Chemical treat and apply one coat BMS 10-11, type 1 primer (F-18.06) all over.
Fig. 2		
Fitting (135)	Al alloy	Chromic acid anodize and apply one coat BMS 10-11, type 1 primer (F-18.13) all over except omit primer from all hole.
Fitting (125,165) Crank (145,155)	Al alloy	Chromic acid anodize and apply one coat BMS 10-11, type 1 primer (F-18.13) all over except omit primer from all holes.
Shield (260)	Al alloy	Chemical treat and apply one coat BMS 10-11, type 1 primer (F-18.06) all over.

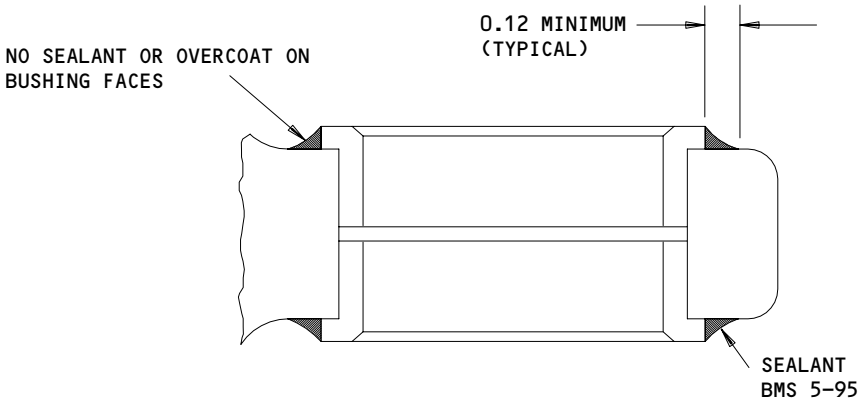
Refinish Details
Figure 601 (Sheet 1)

IPL FIG. & ITEM	MATERIAL	FINISH
Fig. 3		
Fitting (135)	Al alloy	Chromic acid anodize and apply one coat BMS 10-11, Type 1 primer (F-18.13) all over except omit primer from all holes.
Fitting (125)	Al alloy	Chromic acid anodize and apply one coat BMS 10-11, Type 1 primer (F-18.13) all over except omit primer from all holes.
Crank (140, 145)	Al alloy	Chromic acid anodize and apply one coat BMS 10-11, Type 1 primer (F-18.13) all over except omit primer from all holes.
Shield (230)	Al alloy	Chemical treat and apply one coat BMS 10-11, Type 1 primer (F-18.06) all over.

Refinish Details
Figure 601 (Sheet 2)

BUSHING SEALING - REPAIR 7-1

1. Seal all flanged bushings after installation per Fig. 601



1. CLEAN AREAS OF SEALANT APPLICATION WITH SOLVENT.

2. APPLY FILLET OF SEALANT TO EDGES OF BUSHINGS AS SHOWN.

ALL DIMENSIONS ARE IN INCHES

251T1305
Bushing Sealing
Figure 601

13260

ASSEMBLY

1. Materials

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

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

2. Assembly (Fig. 701, IPL Fig. 1)

   A. Install bushings (43) on torque tube assembly (120H) with wet sealant and fillet seal bushing flange with sealant. On assemblies 251T1305-10 thru -15, install bushing (45) on torque tube assembly (120J thru 120L) with wet sealant and fillet seal bushing flange with sealant.

   B. Install bracket (250) with grommet (255) on bracket assembly (75A) with spacer between bracket (250) and bracket assembly (75A) and secure with bolts (235), spacers (240A), and collars (245).

   C. Position bracket assembly (75A) on torque tube assembly (120H thru 120L) and install bushing (50). Install bushing with grease.

      NOTE: After installation of bracket assembly (75A) and bushing (50), a gap of approximately 0.125 inches will exist between bearing (85) and bushing (50). This gap is per design.

   CAUTION: DO NOT RE-TIGHTEN NUT (40) AFTER TIGHTENING NUT (35).

   D. Install bracket assembly (60) thru bracket assembly (75A) onto torque tube assembly (120H thru 120L). Install bolt assembly (5A), washer (20A, 25A, 30) and nuts (35, 40). First tighten nut (40) to 60-80 lb-ins. Then tighten nut (35) to 30-40 lb-ins. Do not re-tighten nut (40).

   CAUTION: DO NOT RE-TIGHTEN NUT (40) AFTER TIGHTENING NUT (35).

   E. On 251T1305-9 assembly, install bushing (53) on torque tube assembly (120H) with grease. Position brace assembly (90), bushing (45) and washer (42) on torque tube assembly and install bolt assembly (5A), washers (20A,25A,30) and nuts (35, 40). First tighten nut (40) to 60-80 lb-ins. Then tighten nut (35) to 30-40 lb-ins. Do not re-tighten nut (40).

CAUTION: DO NOT RE-TIGHTEN NUT (40) AFTER TIGHTENING NUT (35).

F. On assemblies 251T1305-10 thru -15, install bushing (55A) on torque tube assembly (120J, 120K, or 120L) with grease. Position brace assembly (90), bushing (45) and washer (42) on torque tube assembly as shown in Fig. 701 on torque tube assembly and install bolt assembly (5A), washers (20A, 25A, 30) and nuts (35, 40). First tighten nut (40) to 60-80 lb-ins. Then tighten nut (35) to 30-40 lb-ins. Do not re-tighten nut (40).

3. Assembly (Fig. 702, IPL Fig. 2 and Fig. 3)

A. Install bushing (45) on torque tube assembly (120) with wet sealant and fillet seal bushing flange with sealant.

B. Position bracket assembly (IPL Fig. 2, 65) on torque tube assembly (120) and install bushing (50). Install bushing with grease.

NOTE: After installation of bracket assembly (65) and bushing (50), a gap of approximately 0.125 inches will exist between the bearing (75) and bushing (50). This gap is per design.

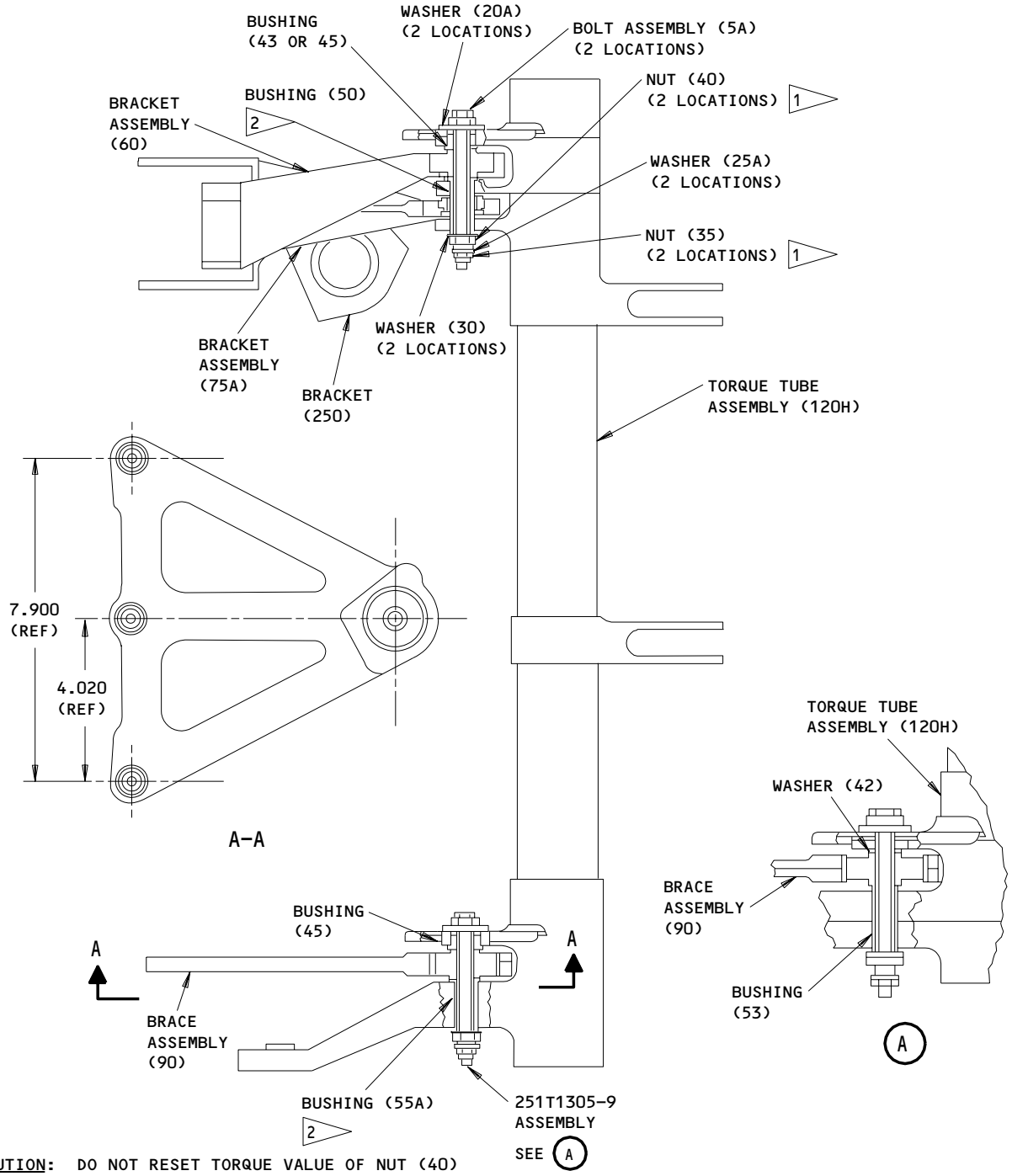
CAUTION: DO NOT RE-TIGHTEN NUT (40) AFTER TIGHTENING NUT (35).

C. Install bracket assembly (55) and bracket assembly (65) onto torque tube assembly (120). Install bolt assembly (5), washers (20, 25, 30) and nuts (35, 40). First tighten nut (40) to 60-80 lb-ins. Then tighten (35) to 30-40 lb-ins. Do not re-tighten nut (40).

CAUTION: DO NOT RE-TIGHTEN NUT (40) AFTER TIGHTENING NUT (35).

D. Install bushing (50) on torque tube assembly (120) with grease. Position brace assembly (80) and bushing (50) on torque tube assembly and install bolt assembly (5), washers (20, 25, 30) and nuts (35, 40). First tighten nut (40) to 60-80 lb. ins. Then tighten (35) to 30-40 lb-ins. Do not re-tighten nut (40).

4. Use standard industry practices and information contained in 20-44-02 to store this component.



CAUTION: DO NOT RESET TORQUE VALUE OF NUT (40) OR OVER-TORQUE WILL RESULT.

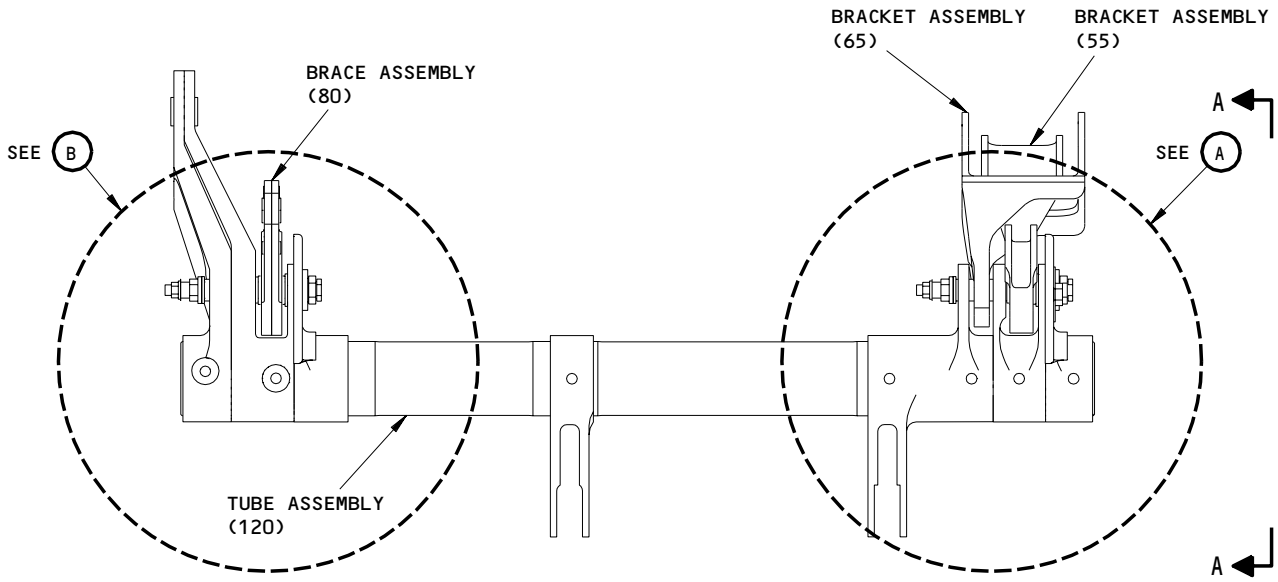
1 FIRST TIGHTEN NUT (40) TO 60-80 POUND-INCHES THEN TIGHTEN NUT (35) TO 30-40 POUND-INCHES

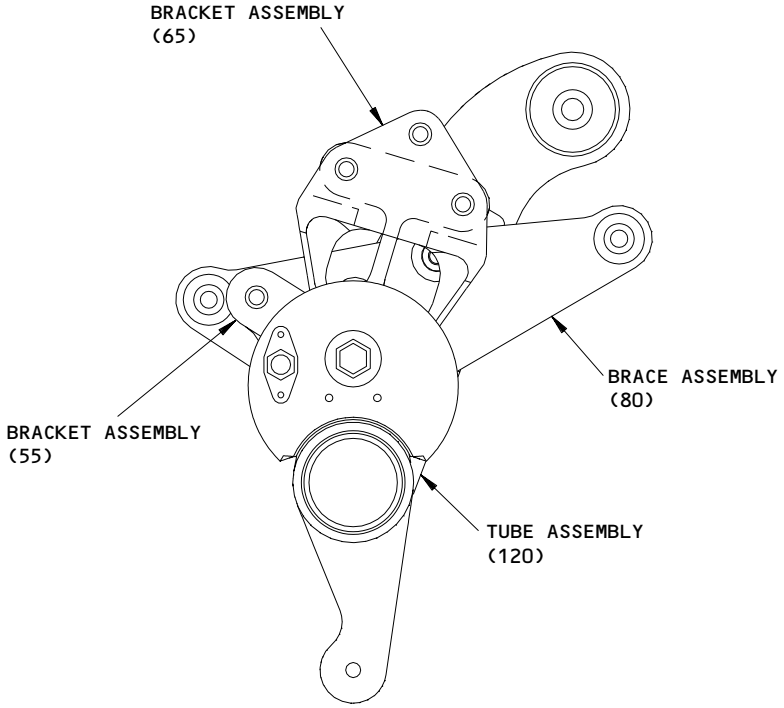
2 INSTALL WITH BMS 3-24 GREASE

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

Assembly Details
Figure 701

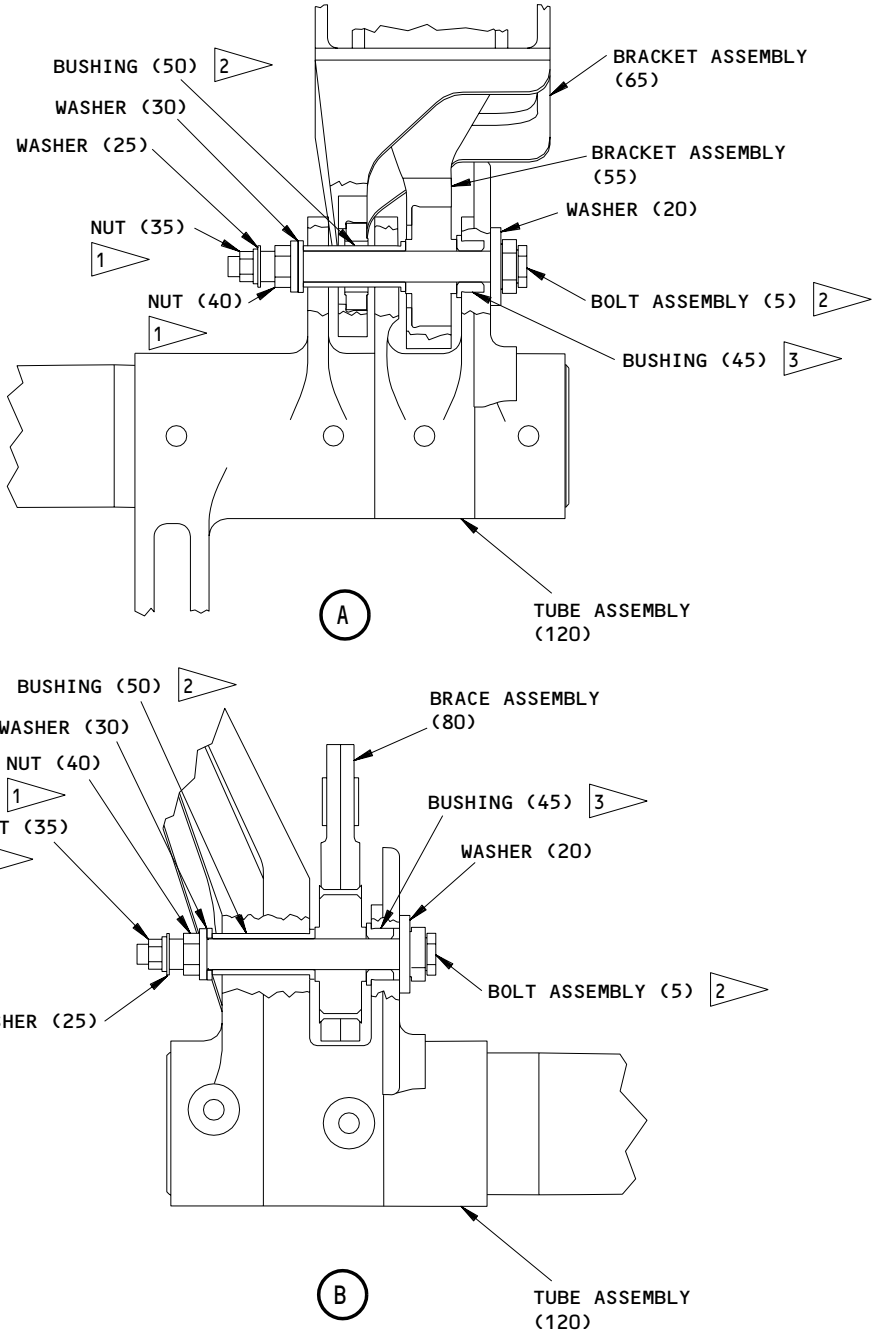




A-A

Assembly Details
Figure 702 (Sheet 1)

K25965



CAUTION: DO NOT RESET TORQUE VALVE OF NUT (40) OR OVER-TORQUE WILL RESULT

1 FIRST TIGHTEN NUT (40) TO 60-80 POUND-INCHES

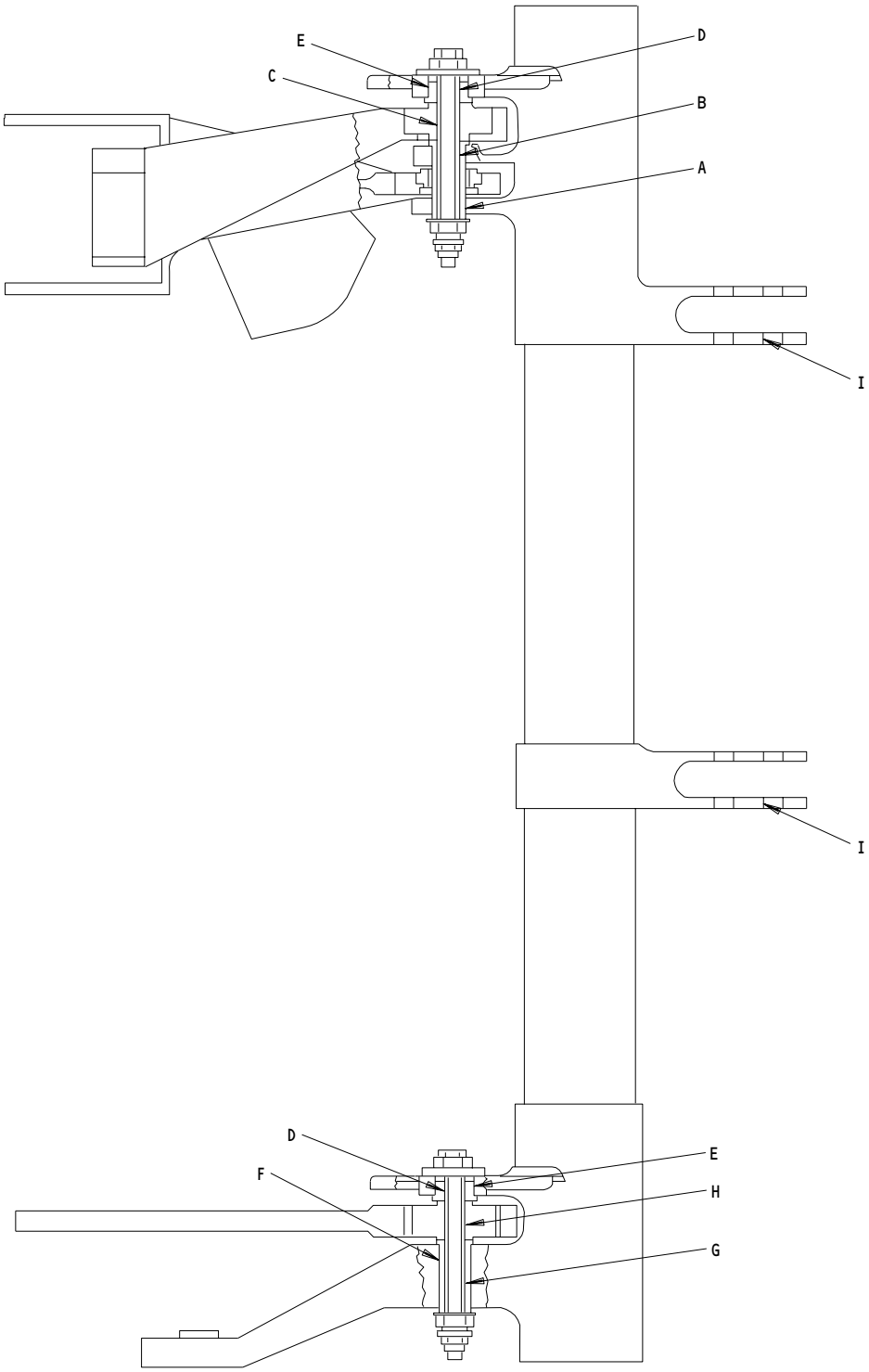
2 INSTALL WITH BMS 3-24 GREASE

3 INSTALL WITH BMS 5-95 SEALANT. FILLET SEAL FLANGE WITH BMS 5-95 SEALANT

ITEM NUMBERS REFER TO IPL FIG. 2,3

Assembly Details
Figure 702 (Sheet 2)

FITS AND CLEARANCES



251T1305-9 SHOWN

Fits and Clearances
Figure 801 (Sheet 1)

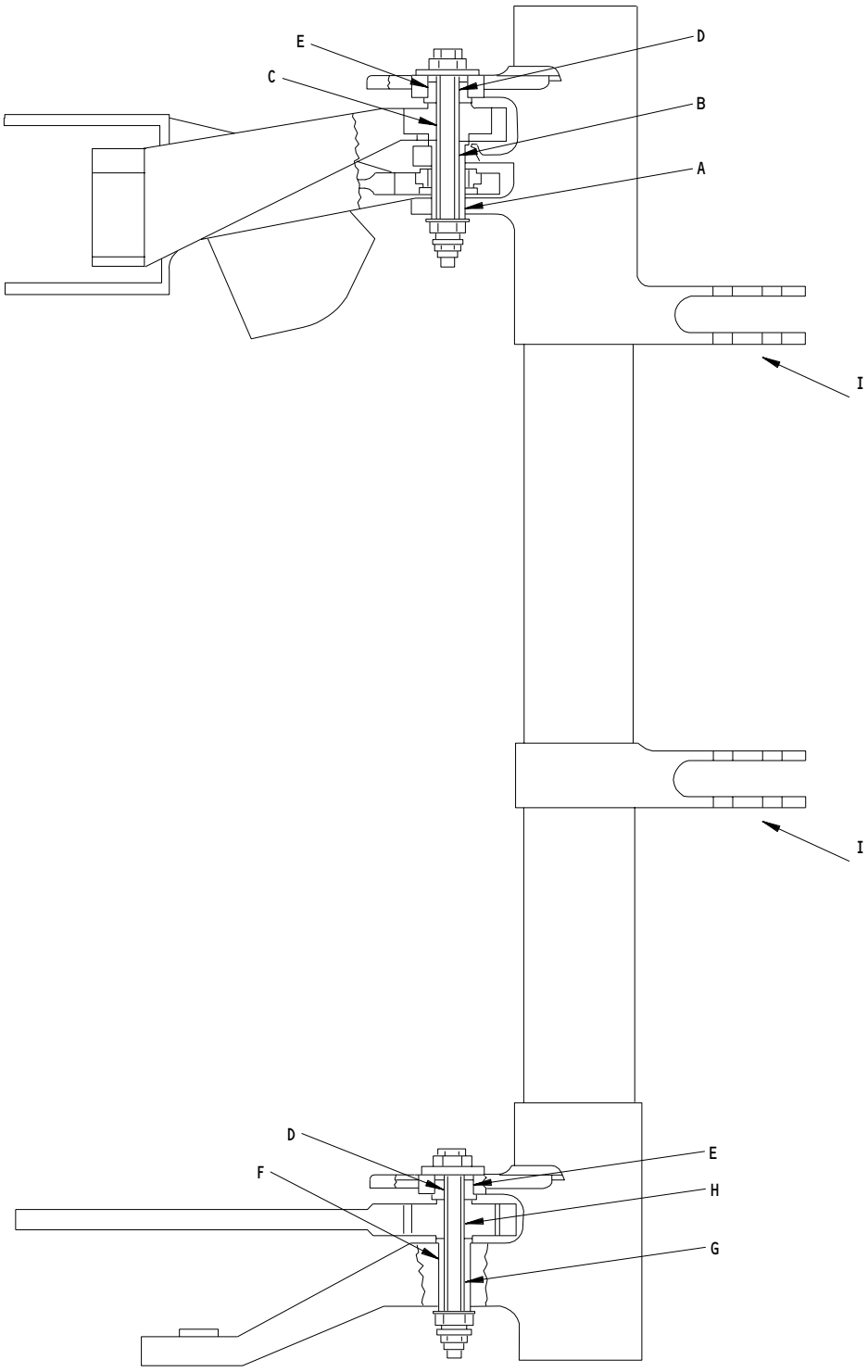
179399

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 120H OD 50	0.4995 0.4990	0.5005 0.4995	0.0000	0.0015	0.4976	0.5024	0.0029
B	ID 50 OD 15A	0.3750 0.3735	0.3756 0.3745	0.0005	0.0021	0.3725	0.3776	0.0031
C	ID 70 OD 15A	0.3745 0.3735	0.3750 0.3745	0.0000	0.0015	0.3725	0.3770	0.0025
D	ID 43,45 OD 15A	0.3745 0.3735	0.3755 0.3745	0.0000	0.0020	0.3725	0.3775	0.003
E	ID 120H ID 43,45	0.6245 0.6240	0.6255 0.6245	0.0000	0.0015	0.6225	0.6275	0.003
F	ID 120H OD 53	0.4995 0.4990	0.5005 0.4995	0.0000	0.0015	0.4975	0.5025	0.003
G	ID 53 OD 15A	0.3750 0.3735	0.3756 0.3745	0.0005	0.0021	0.3720	0.3781	0.0036
H	ID 100 ID 15A	0.3745 0.3735	0.3750 0.3745	0.0000	0.0015	0.3720	0.3775	0.003
I	ID 120H	0.2495	0.2505				0.2535	

ALL DIMENSIONS ARE IN INCHES

Fits and Clearances
Figure 801 (Sheet 2)

179400



251T1305-16,-17 SHOWN

Fits and Clearances
Figure 802 (Sheet 1)

Ref Letter Fig.802	Mating Item No. IPL Fig.2 and 3	Design Dimension				Service Wear Limit		
		Dimension		Assembly Clearance		Dimension		Maximum Clearance
		Min	Max	Min	Max	Min	Max	
A	ID 120 OD 50	0.4995 0.4990	0.5005 0.4995	0.0000	0.0015	0.4976	0.5024	0.0029
B	ID 50 OD 15	0.3750 0.3735	0.3756 0.3745	0.0005	0.0021	0.3725	0.3776	0.0031
C	ID 60 OD 15	0.3745 0.3735	0.3750 0.3745	0.0000	0.0015	0.3725	0.3770	0.0025
D	ID 45 OD 15	0.3745 0.3735	0.3755 0.3745	0.0000	0.0020	0.3725	0.3775	0.003
E	ID 120 ID 45	0.6245 0.6240	0.6255 0.6245	0.0000	0.0015	0.6225	0.6275	0.003
F	ID 120 OD 50	0.4995 0.4990	0.5005 0.4995	0.0000	0.0015	0.4975	0.5025	0.003
G	ID 50 OD 15	0.3750 0.3735	0.3756 0.3745	0.0005	0.0021	0.3720	0.3781	0.0036
H	ID 100 ID 15	0.3745 0.3735	0.3750 0.3745	0.0000	0.0015	0.3720	0.3775	0.003
I	ID 120	0.2495	0.2505				0.2535	

ALL DIMENSIONS ARE IN INCHES

Fits and Clearances
Figure 802 (Sheet 2)

K26036

FOR TORQUE VALUES OF STANDARD FASTENERS, REFER TO 20-50-01			
ITEM NO. IPL FIG.	NAME	TORQUE	
		POUND-INCHES	POUND-FEET
FIG. 1, 35	NUT	30 - 40	
FIG. 1, 40	NUT	60 - 80	
FIG. 2, 35	NUT	30 - 40	
FIG. 2, 40	NUT	60 - 80	
FIG. 3, 35	NUT	30 - 40	
FIG. 3, 40	NUT	60 - 80	

Torque Table
Figure 803

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

S0352 NIPPON MINIATURE BEARING CO LTD
TOKYO, JAPAN

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

06144 INDUSTRIAL TECTONICS BEARING CORP
18301 SOUTH SANTA FE AVENUE
RANCHO DOMINGUEZ, CALIFORNIA 90221
FORMERLY IN COMPTON, CALIFORNIA

09455 RBC TRANSPORT DYNAMICS CORP
3131 W SEGERSTROM AVE
SANTA ANA, CALIFORNIA 92704-5872
FORMERLY TRANSPORT DYNAMICS AEROSPACE DIV; FABROID DIV
TRANSPORT DYNAMICS V17571 & LEAR SEIGLER INC TRANSPORT DIV
V98076; FORMERLY BFM TRANSPORT DYNAMICS

11815 CHERRY AEROSPACE FASTENERS DIV OF TEXTRON
1224 EAST WARNER AVENUE PO BOX 2157
SANTA ANA, CALIFORNIA 92707-0157
FORMERLY IN LOS ANGELES, CALIF , FORMERLY CHERRY FASTENERS
TOWNSEND DIV OF TEXTRON INC V71087

15653 ALOCA GLOBAL FASTEMERS INC DIV KAYNARE PRODUCTS
800 S STATE COLLEGE BLVD
FULLERTON, CALIFORNIA 92831-3001
FORMERLY VK6405 MICRODOT AEROSP LTD; FORMERLY KAYNAR TECH
FORMERLY FAIRCHILD FASTENERS KAYNAR DIV

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

VENDORS

16746 SPECLINE INCORPORATED
2230 MOUTON DR
CARSON CITY, NV 89706
FORMERLY IN SUN VALLEY, CAIFORNIA

21335 TORRINGTON CO FAFNIR BEARING DIV
59 FIELD STREET
TORRINGTON, CONNECTICUT 06790-1008
FORMERLY FAFNIR BRG AND TEXTRON INC FAFNIR DIV IN
NEW BRITAIN, CONNECTICUT

21760 SCHATZ MANUFACTURING CO
FAIRVIEW AVENUE PO BOX 1191
POUGHKEEPSIE, NEW YORK 12601
FORMERLY FEDERAL BRG CO AND SCHATZ MFG CO V53268
FORMERLY SCHATZ MFG CO

30163 VALENTEC DAYRON INC
333 MAGUIRE BLVD PO BOX 140394
ORLANDO, FLORIDA 32814-0394

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

40920 MPB MINIATURE PRECISION BEARING DIV
PRECISION PARK PO BOX 547
KEENE, NEW HAMPSHIRE 03431
FORMERLY MPB CORP AND MINIATURE BRG DIV MPB CORP

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

5M902 FAIRCHILD IND INC FAIRCHILD AEROSPACE FASTENER DIV
3016 W LOMITA BLVD
TORRANCE, CALIFORNIA 90505-5103
FMLY IN REDONDO BEACH, CALIF

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

VENDORS

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

56878 SPS TECHNOLOGIES INC AEROSPACE AND INDUSTRIAL PRODUCTS DIV
301 HIGHLAND AVE
JENKINTOWN, PENNSYLVANIA 19046
FORMERLY STANDARD PRESSED STEEL

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

62554 SIMMONDS MECAERO FASTENERS INC
1734 SEQUOIA AVENUE
ORANGE, CALIFORNIA 92668

72962 HARVARD INDUSTRIES INC
3 WERNER WAY SUITE 210
LEBANON, NEW JERSEY 08833
FORMERLY AMERACE CORP ESNA DIV
FORMERLY ELASTIC STOP NUT IN UNION, NJ

73134 ROLLER BEARING COMPANYOF AMER DBA HEIM BEARINGS DIV
60 ROUND HILL RD
FAIRFIELD, CONNECTICUT 06430-0000
FORMERLY INCOM INTL HEIM DIV; HEIM UNIVERSAL CORP INCOM;
FORMERLY HEIM DIV INCOM INTL; IMO IND HEIM BEARINGS DIV

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 DIV AERPSOACE - SANTA ANA
2701 SOUTH HARBOR BOULEVARD
SANTA ANA, CALIFORNIA 92704-5803
FORMERLY NUTT-SHEL DIV OF SPC WESTERN CO V80539
AND STANDARD PRESSED STEEL WESTERN DIV V17279

81376 SMITH ACQUISITION COMPANY
2240 BUENA VISTA
BALDWIN PARK, CALIFORNIA 91706

VENDORS

83086 NEW HAMPSHIRE BALL BEARING, INC HITECH DIVISION
172 JAFFREY ROAD
PETERBOROUGH, NEW HAMPSHIRE 03458

92215 FAIRCHILD IND INC FAIRCHILD AEROSPACE FASTENER DIV
3010 W LOMITA BLVD
TORRANCE, CALIFORNIA 90505-5102
FORMERLY VOI-SHAN IN CULVER CITY, CALIF

97613 SARGENT CONTROLS & AEROSPACE/KAHR BEARING DIV
5675 W BURLINGAME RD
TUCSON, ARIZONA 85743
FORMERLY AETNA STEEL PROD KAHR BEARING DIV V96579
FORMERLY SARGENT IND KAHR BEARING DIV, BURBANK, CALIFORNIA

97928 SEE V17446 HUCK INTL
HUCK INTL SEE V17446 HUCK INTL
SEE V17446 HUCK INTL

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
ABW4-5		1	105A	3
		2	105	3
		3	105	3
ACMB538DDP818LY		2	75	1
		3	75	1
AN960-416L		1	25A	2
AN960-616		1	30	2
AN960PD616		1	42	1
ASR6-30		1	70	1
		1	100	1
		1	185A	1
		2	185	1
ASR6D30		3	155	1
AW4CRG		1	105A	3
		2	105	3
		3	105	3
BACB10CF10PP		1	85	1
BACB10CK6		1	70	1
		1	100	1
		1	185A	1
		2	185	1
BACB10CK6D		3	155	1
BACB10FU10		2	75	1
		3	75	1
BACB10X3T		1	105A	3
		2	105	3
		3	105	3
BACB30MY5K13		1	235	2
BACB30MY6K8		1	193	1
		2	200	1
		3	170	1
BACC30M5		1	245	2
BACC30M6		1	194	1
		2	205	1
		3	175	1
BACN10JC4		1	35	2
BACN10JC6		1	40	2
BACN10YR4CD		2	35	2
		3	35	2
BACN10YR6CD		2	40	2
		3	40	2
BACR10G141		1	223	1
		2	250	1
		3	220	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACR15BA4AD		1	225B	4
BACR15BA4AD		3	225A	4
BACR15BA5AD		1	96	16
		2	85	9
		2	255	4
		3	85	9
BACR15BA5D11		1	198	2
		2	220	2
		3	190	2
BACR15BA5D15		1	197	1
		2	215	1
		3	185	2
BACR15BA5D21		1	196	1
BACR15BB3AD		3	215A	2
BACR15BB4AD		1	222	2
		2	245	2
BACW10P20AL		1	20A	2
		2	20	2
		3	20	2
BRH10A4		1	35	2
BRH10A6		1	40	2
BSSR4806		1	105A	3
		2	105	3
		3	105	3
BWP3E115T		1	105A	3
		2	105	3
		3	105	3
B1355-4		1	223	1
		2	250	1
		3	220	1
B30MY5K13		1	235	2
B30MY6K8		1	193	1
		2	200	1
		3	170	1
B538-2TS		1	85	1
HL10VAZ5-13		1	235	2
HL10VAZ6-8		1	193	1
		2	200	1
		3	170	1
HL70-5		1	245	2
HL79-6		1	194	1
		2	205	1
		3	175	1
HU4-136		1	105A	3
		2	105	3
		3	105	3

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
H10-4BAC		1	35	2
H10-6BAC		1	40	2
H52732-4CD		2	35	2
		3	35	2
H52732-6CD		2	40	2
		3	40	2
KWB4CRG		1	105A	3
		2	105	3
		3	105	3
MS90354-0806		1	130	2
		1	140	2
		1	150	4
		1	160	2
		1	170	2
		1	180	4
		2	130	2
		2	140	2
		2	150	4
		2	160	2
		2	170	2
		2	180	4
		3	130	14
NAS1149D0432J		2	25	2
NAS1149D0432J		3	25	2
NAS1149D0663J		2	30	2
		3	30	2
NAS1368N20H		1	255	1
NAS42DD3-40FC		1	240A	2
NAS516-1A		1	192	1
		2	195	1
		3	165	1
NAS6704U47		1	10A	2
		2	10	2
		3	10	2
NS202101-048		1	35	2
PACMB538DDA3908		2	75	1
		3	75	1
PACMB538DDFS428		2	75	1
		3	75	1
PLH54CD		2	35	2
		3	35	2
PLH56CD		2	40	2
		3	40	2
RMLH9075-4W		1	35	2

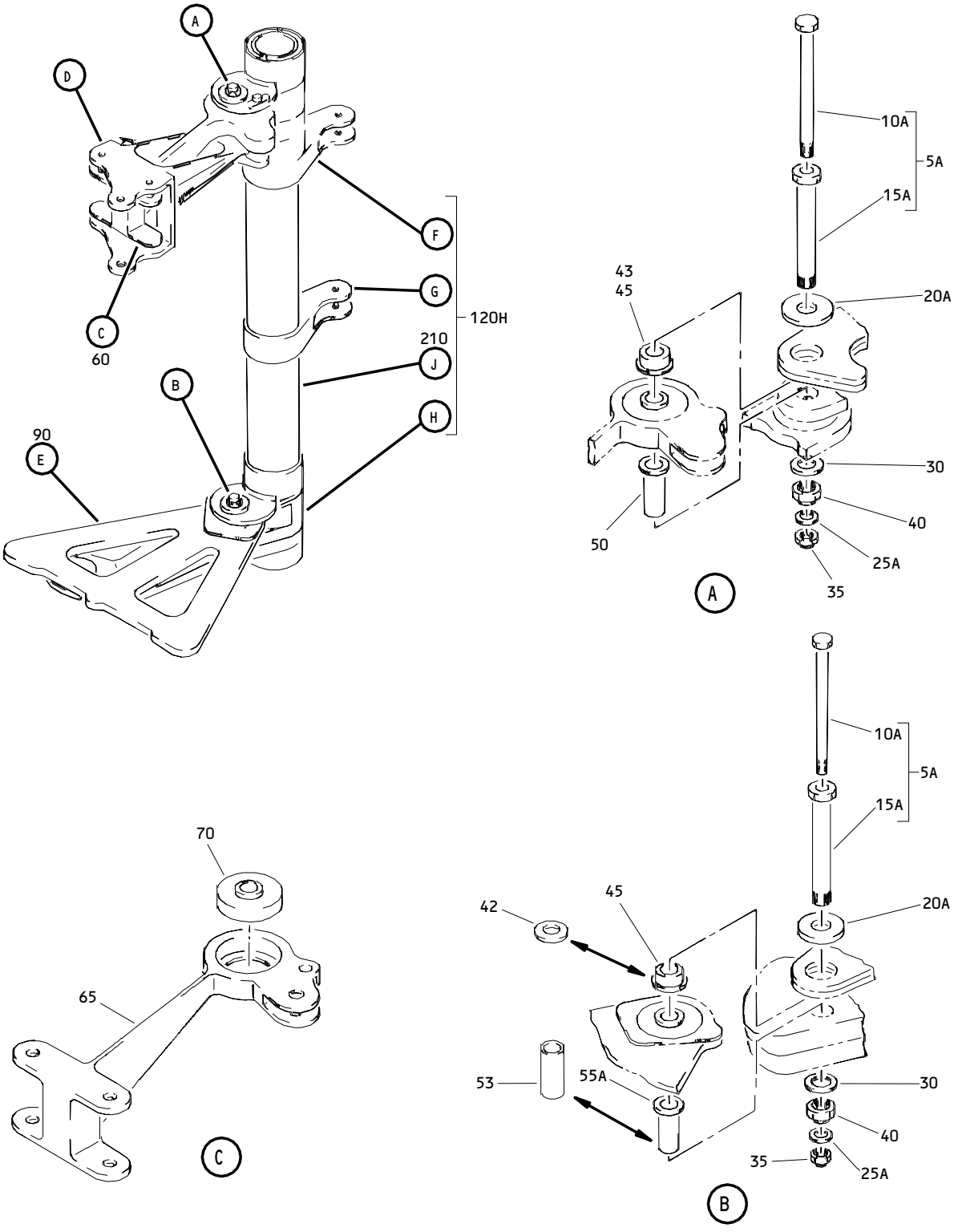
PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
RMLH9075-6		1	40	2
SA6-23A1-501		1	70A	1
		1	100A	1
		2	60	1
		2	100	1
		3	60	1
		3	100	1
SA6-23A1-503		3	155	1
SA6-23A4		1	70	1
		1	100	1
		1	185A	1
		2	185	1
SA6-23A51		3	155	1
SSMB538DDSD705		2	75	1
		3	75	1
SO12T236-400		1	70A	1
		1	100A	1
		1	185B	1
SO12T236-400		2	60	1
		2	100	1
		3	60	1
		3	100	1
T338E		1	85	1
T6S428J		1	35	2
VN303A048		1	35	2
WC4-1		1	105A	3
		2	105	3
		3	105	3
WS4E		1	105A	3
		2	105	3
		3	105	3
251T0200-10		1	15A	2
		2	15	2
		3	15	2
251T0200-65		1	5B	2
		2	5	2
		3	5	2
251T0200-9		1	5A	2
251T1305-10		1	1J	RF
251T1305-11		1	1K	RF
251T1305-12		1	1L	RF
251T1305-13		1	1M	RF
251T1305-14		1	1N	RF
251T1305-15		1	1P	RF

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
251T1305-16		1	1Q	RF
		2	1	RF
251T1305-17		1	1R	RF
		3	1	RF
251T1305-9		1	1H	RF
251T1322-1		1	60	1
251T1322-2		1	65	1
251T1322-3		1	60A	1
251T1322-4		1	65A	1
251T1322-5		1	60B	1
251T1322-6		1	65B	1
251T1322-7		1	60C	1
251T1322-8		2	55	1
		3	55	1
251T1322-9		2	57	1
		3	57	1
251T1323-3		1	75A	1
251T1323-4		1	80A	1
251T1323-5		2	65	1
251T1323-5		3	65	1
251T1323-6		2	70	1
		3	70	1
251T1324-1		1	90	1
251T1324-2		1	95	1
251T1324-3		1	90A	1
251T1324-4		2	80	1
251T1324-5		3	80	1
251T1325-2		1	195A	1
251T1325-3		1	195B	1
		2	210	1
251T1325-4		3	180	1
251T1326-2		1	200B	1
		2	225	1

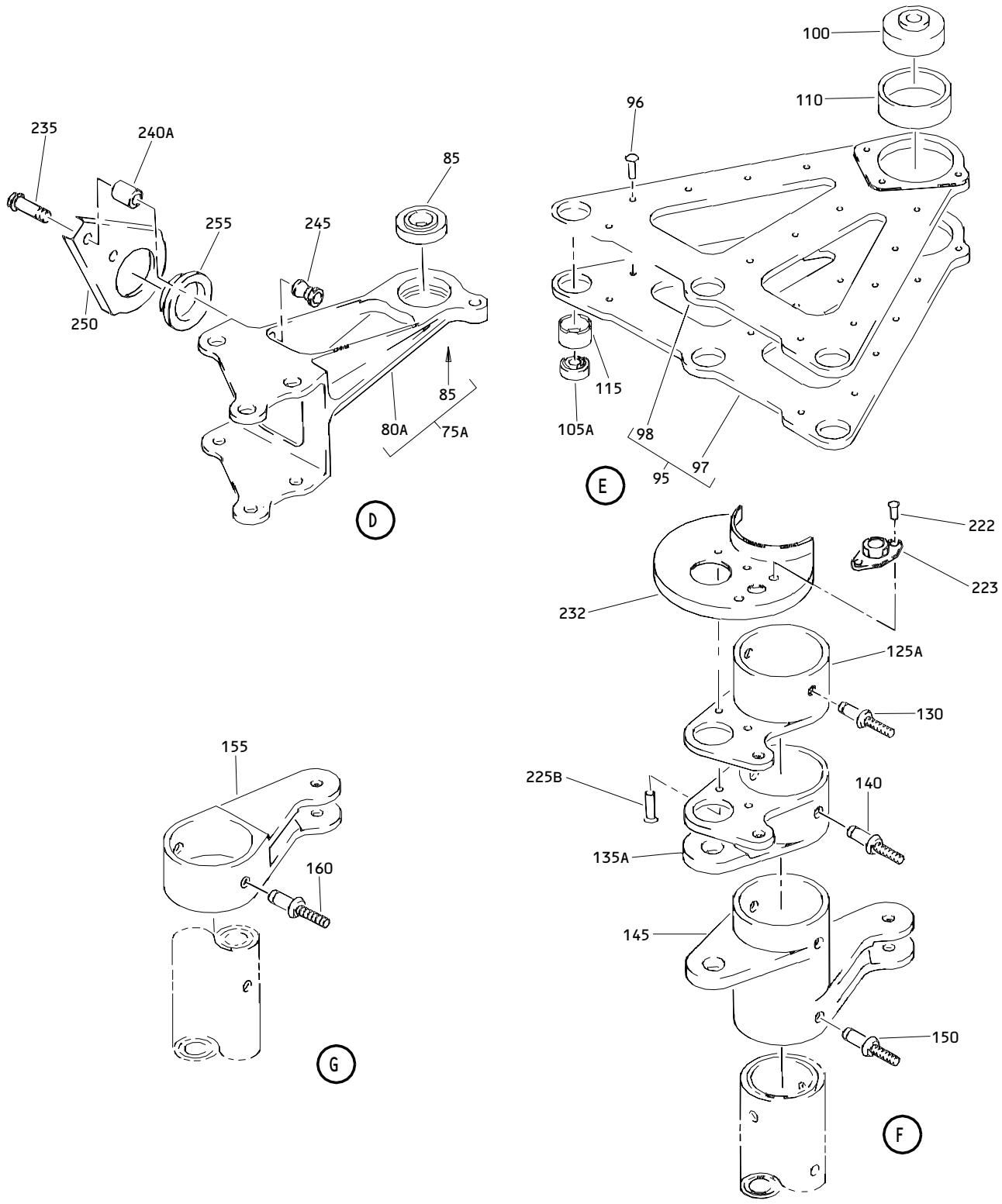
PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
251T1326-3		1	200C	1
251T1326-4		3	195	1
251T1328-1		1	210	1
		2	230	1
251T1328-2		1	215	1
		2	235	1
251T1328-3		1	220	1
		2	240	1
251T1328-4		3	200	1
251T1328-5		3	205	1
251T1328-6		3	210	1
251T1329-1		1	165	1
		2	165	1
251T1330-2		1	135A	1
		2	135	1
		3	135	1
251T1331-1		1	145	1
		2	145	1
		3	140	1
251T1337-1		1	155	1
		2	155	1
251T1337-2		3	145	1
251T1343-1		1	97	1
251T1343-2		1	98	1
251T1343-3		2	90	1
251T1343-4		2	95	1
251T1343-5		3	90	1
251T1343-6		3	95	1
251T1344-1		1	43	1
		1	45	2
		2	45	2

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
251T1344-1		3	45	2
251T1345-10		1	120J	1
251T1345-11		1	120K	1
251T1345-12		1	120L	1
		2	120	1
251T1345-13		3	120	1
251T1345-9		1	120H	1
251T1346-4		1	175C	1
251T1346-5		1	175D	1
251T1346-6		1	175E	1
		2	175	1
251T1346-7		3	150	1
251T1347-2		1	125A	1
		2	125	1
		3	125	1
251T1348-1		1	250	1
251T1348-2		1	230	1
251T1348-3		1	230A	1
		1	232	1
		2	260	2
		3	230	2
251T1362-1		1	115	3
		2	115	3
		3	115	3
251T1362-2		1	110	1
		2	110	1
		3	110	1
251T1377-1		1	190B	1
		2	190	1
		3	160	1
251T3741-25		1	53	1
251T3742-9		1	50	1
		1	55A	1
		2	50	2
		3	50	2

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
55303		1	105A	3
		2	105	3
		3	105	3
66014-5		1	245	2
66014-6		1	194	1
		2	205	1
		3	175	1
69-38919-18		1	190	1
96-048		1	35	2
96-064		1	40	2

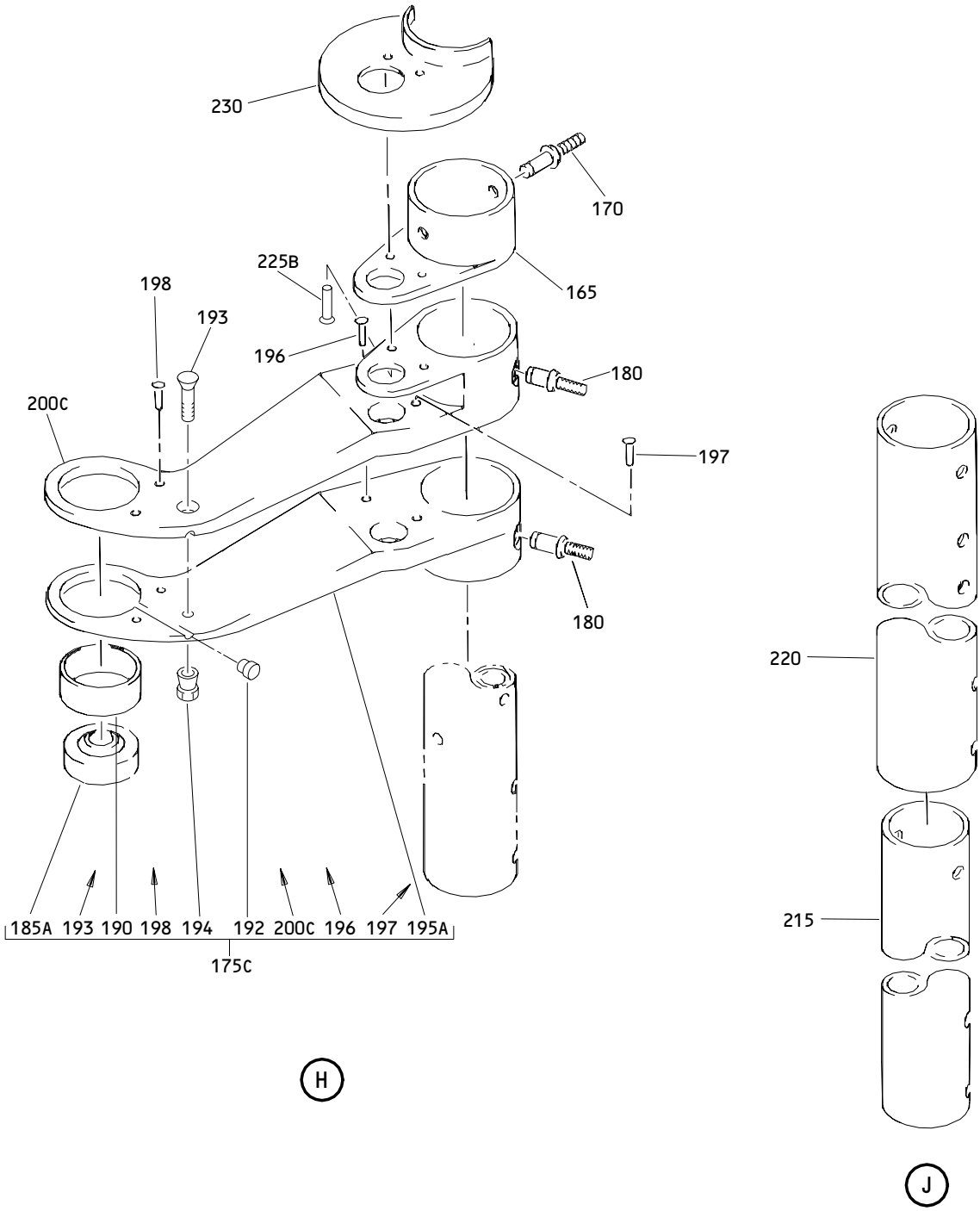


Left Hand Lateral Central Control Actuator Input Crank
Torque Tube And Bracket Assembly
Figure 1 (Sheet 1)



Left Hand Lateral Center Control Actuator Input Crank
Torque Tube And Bracket Assembly
Figure 1 (Sheet 2)

T60315



Left Hand Lateral Central Control Actuator Input Crank Torque Tube and Bracket Assembly
Figure 1 (Sheet 3)

T60316

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	-1	251T1305-1		DELETED		
	-1A	251T1305-2		DELETED		
	-1B	251T1305-3		DELETED		
	-1C	251T1305-4		DELETED		
	-1D	251T1305-5		DELETED		
	-1E	251T1305-6		DELETED		
	-1F	251T1305-7		DELETED		
	-1G	251T1305-8		DELETED		
	-1H	251T1305-9		TUBE AND BRACKET ASSY-LH LATERAL CENTRAL CONT ACTR INPUT CRANK TORQUE	A	RF
	-1J	251T1305-10		TUBE AND BRACKET ASSY-LH LATERAL CENTRAL CONT ACTR INPUT CRANK TORQUE	B	RF
	-1K	251T1305-11		TUBE AND BRACKET ASSY-LH LATERAL CENTRAL CONT ACTR INPUT CRANK TORQUE	C	RF
	-1L	251T1305-12		TUBE AND BRACKET ASSY-LH LATERAL CENTRAL CONT ACTR INPUT CRANK TORQUE	D	RF
	-1M	251T1305-13		TUBE AND BRACKET ASSY-LH LATERAL CENTRAL CONT ACTR INPUT CRANK TORQUE	E	RF
	-1N	251T1305-14		TUBE AND BRACKET ASSY-LH LATERAL CENTRAL CONT ACTR INPUT CRANK TORQUE	F	RF
	-1P	251T1305-15		TUBE AND BRACKET ASSY-LH LATERAL CENTRAL CONT ACTR INPUT CRANK TORQUE	G	RF
	-1Q	251T1305-16		TUBE AND BRACKET ASSY-LH LATERAL CENTRAL CONT ACTR INPUT CRANK TORQUE (FOR DETAILS SEE FIG. 2)	H	RF
R	-1R	251T1305-17		TUBE AND BRACKET ASSY-LH LATERAL CENTRAL CONT ACTR INPUT CRANK TORQUE (FOR DETAILS SEE FIG. 3)	J	RF

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
5	251T0200-39		DELETED		
5A	251T0200-9		.BOLT ASSY	A-E	2
-5B	251T0200-65		.BOLT ASSY	F,G	2
10	NAS6704U46		DELETED		
10A	NAS6704U47		..BOLT	A-E	1
-10B	NAS6704U49		..BOLT	F,G	1
15	251T0200-40		DELETED		
15A	251T0200-10		..BOLT-OUTER HOLLOW	A-G	1
20	BACW10P108A		DELETED		
20A	BACW10P20AL		.WASHER	A-G	2
25	AN960-416		DELETED		
25A	AN960-416L		.WASHER	A-G	2
30	AN960-616		.WASHER	A-G	2
35	BRH10A4		.NUT- (V52828) (SPEC BACN10JC4) (OPT T6S428J (V11815)) (OPT 96-048 (V80539)) (OPT VN303A048 (V92215)) (OPT RMLH9075-4W (V72962)) (OPT NS202101-048 (V80539)) (OPT H10-4BAC (V15653))	A-G	2
40	BRH10A6		.NUT- (V52828) (SPEC BACN10JC6) (OPT 96-064 (V80539)) (OPT RMLH9075-6 (V72962)) (OPT H10-6BAC (V15653))	A-G	2
42	AN960PD616		.WASHER	A	1
43	251T1344-1		.BUSHING	A	1
45	251T1344-1		.BUSHING	B-G	2
50	251T3742-9		.BUSHING	A-G	1
53	251T3741-25		.BUSHING	A	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
55	251T3742-10		DELETED		
55A	251T3742-9		.BUSHING	B-G	1
60	251T1322-1		.BRACKET ASSY	A-C	1
-60A	251T1322-3		.BRACKET ASSY	D	1
-60B	251T1322-5		.BRACKET ASSY	E,F	1
-60C	251T1322-7		.BRACKET ASSY	G	1
65	251T1322-2		..BRACKET	A-C	1
-65A	251T1322-4		..BRACKET	D	1
-65B	251T1322-6		..BRACKET	E,F,G	1
70	ASR6-30		..BEARING- (VS0352) (SPEC BACB10CK6) (OPT SA6-23A4 (V77896)) (REPLACED BY ITEM 70B) (PRE SB 767-27-0128)	A-F	1
-70A	SA6-23A1-501		..BEARING- (V77896) (SPEC SO12T236-400)	G	1
-70B	SA6-23A1-501		..BEARING- (V77896) (REPLACES ITEM 70) (SPEC SO12T236-400) (POST 767-SB-27-0128)	A-F	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
75	251T1323-1		DELETED		
75A	251T1323-3		.BRACKET ASSY	A-G	1
80	251T1323-2		DELETED		
80A	251T1323-4		..BRACKET-CAGE	A-G	1
85	B538DDNJC		..BEARING- (V06144) (SPEC BACB10CF10PP) (OPT B538DDFS101 (V06144)) (OPT T338E (VK8455)) (OPT B538SSG27 (V30163)) (OPT B538DDFS428 (V21335)) (OPT B538DD (V38443)) (OPT B538-2TS (V43991)) (OPT B538FS101 (V06144)) (OPT B538DDP (V21760))	A-G	1
90	251T1324-1		.BRACE ASSY-LWR	A-F	1
-90A	251T1324-3		.BRACE ASSY-LWR	G	1
95	251T1324-2		..BRACE ASSY	A-G	1
96	BACR15BA5AD		...RIVET- (SIZE DETERMINE ON INST)	A-G	16
97	251T1343-1		...BRACE-LWR	A-G	1
98	251T1343-2		...BRACE-UPR	A-G	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
100	ASR6-30		..BEARING- (VS0352) (SPEC BACB10CK6) (OPT SA6-23A4 (V77896)) (REPLACED BY ITEM 100B) (PRE SB 767-27-0128)	A-F	1
-100A	SA6-23A1-501		..BEARING- (REPLACES ITEM 100) (SPEC S012T236-400)	G	1
-100B	SA6-23A1-501		..BEARING- (REPLACES ITEM 100) (SPEC S012T236-400) (POST SB 767-27-0128)	A-F	1
105	HU4-134		DELETED		
105A	BWP3E115T		..BEARING- (V16746) (SPEC BACB10X3T) (OPT AW4CRG (V15860)) (OPT BSSR4806 (V81376)) (OPT HU4-136 (V02758)) (OPT KWB4CRG (V97613)) (OPT WS4E (V73134)) (OPT 55303 (V09455)) (OPT WC4-1 (V56644)) (OPT ABW4-5 (VS0352))	A-G	3
110	251T1362-2		..SLEEVE	A-G	1
115	251T1362-1		..SLEEVE	A-G	3
119	BACR0G141		DELETED		
120	251T1345-1		DELETED		
120A	251T1345-2		DELETED		
-120B	251T1345-3		DELETED		
120C	251T1345-4		DELETED		
-120D	251T1345-5		DELETED		
120E	251T1345-6		DELETED		
-120F	251T1345-7		DELETED		
-120G	251T1345-8		DELETED		

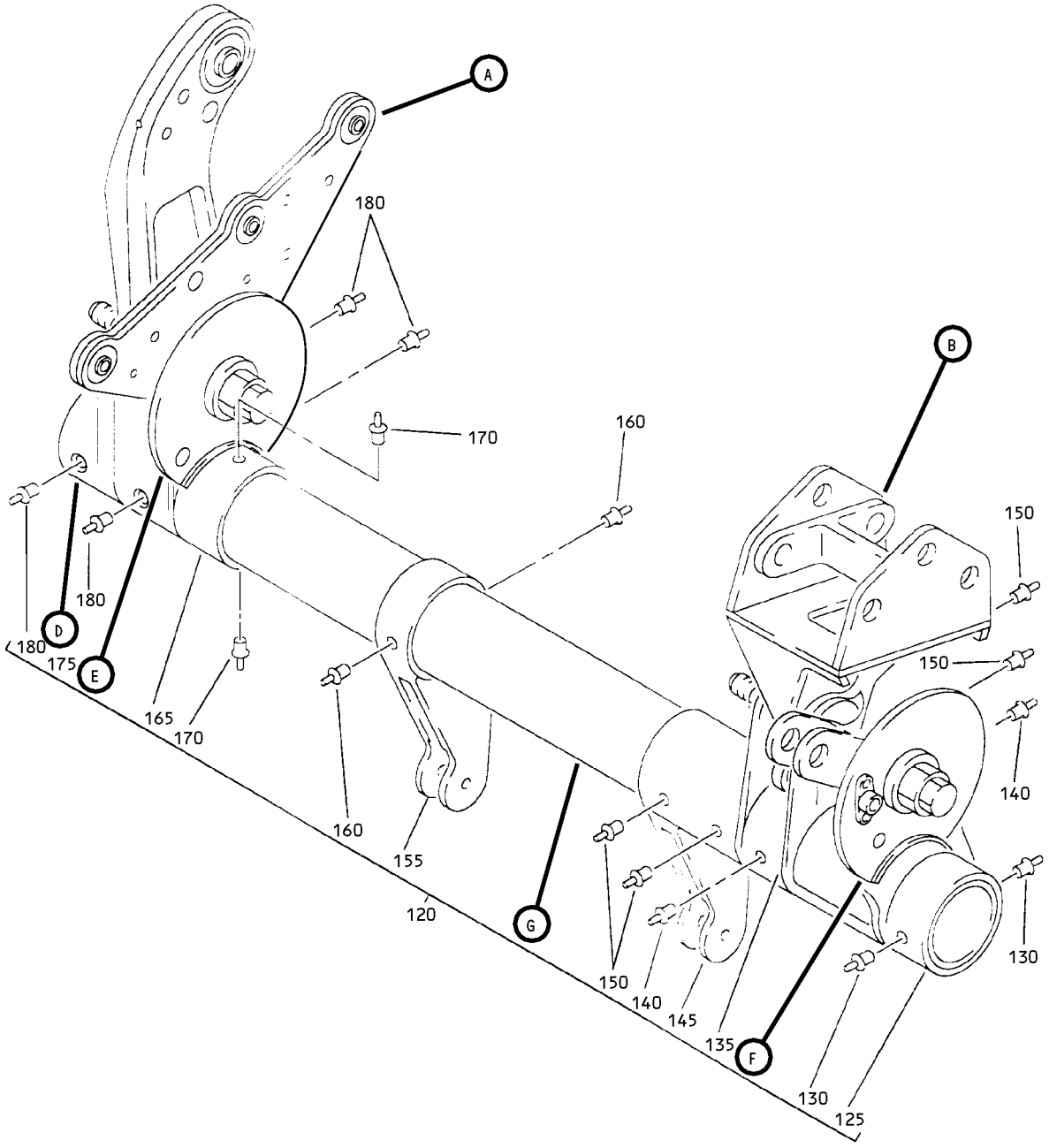
FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
120H	251T1345-9		.TUBE ASSY	A	1
-120J	251T1345-10		.TUBE ASSY	B	1
-120K	251T1345-11		.TUBE ASSY	C	1
-120L	251T1345-12		.TUBE ASSY	D-G	1
125	251T1347-1		DELETED		
125A	251T1347-2		..FITTING	A-G	1
			ATTACHING PARTS		
130	MS90354-0806		..RIVET	A-G	2
			-------*-------		
135	251T1330-1		DELETED		
135A	251T1330-2		..FITTING	A-G	1
			ATTACHING PARTS		
140	MS90354-0806		..RIVET	A-G	2
			-------*-------		
145	251T1331-1		..CRANK-OUTPUT	A-G	1
			ATTACHING PARTS		
150	MS90354-0806		..RIVET	A-G	4
			-------*-------		
155	251T1337-1		..CRANK-OUTPUT	A-G	1
			ATTACHING PARTS		
160	MS90354-0806		..RIVET	A-G	2
			-------*-------		
165	251T1329-1		..FITTING	A-G	1
			ATTACHING PARTS		
170	MS90354-0806		..RIVET	A-G	2
			-------*-------		
175	251T1346-1		DELETED		
175A	251T1346-2		DELETED		
-175B	251T1346-3		DELETED		
175C	251T1346-4		..CRANK ASSY-INPUT	A	1
-175D	251T1346-5		..CRANK ASSY-INPUT	B,C	1
-175E	251T1346-6		..CRANK ASSY-INPUT	D-G	1
			ATTACHING PARTS		

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
180	MS90354-0806		..RIVET -------*-------	A-G	4
185	KSP6		DELETED		
185A	ASR6-30		...BEARING- (VS0352) (SPEC BACB10CK6) (OPT SA6-23A4 (V77896)) (RPLCD BY ITEM 185B)	A-G	1
-185B	S012T236-400		...BEARING- (RPLCS ITEM 185A)	A-G	1
190	69-38919-18		...SLEEVE- (MFD FROM SH AL QQ-A-327 OR 6061-0 PER WW-T-789 OPT 6061-T6 ROD QQ-A-225/8 F2.10 .062 IN .624 IN 4.92 IN)	A-C	1
-190A	251T0377-1		DELETED		
-190B	251T1377-1		...SLEEVE-RETAINING	D-G	1
192	NAS516-1A		...FITTING-LUBE	D-G	1
193	HL10VAZ6-8		...BOLT- (V60516) (SPEC BACB30MY6K8) (OPT B30MY6K8 (V97928))	D-G	1
194	HL79-6		...COLLAR- (V5M902) (SPEC BACC30M6) (OPT HL79-6 (V73197)) (OPT HL79-6 (V92215)) (OPT 66014-6 (V56878)) (OPT HL79-6 (V56878))	D-G	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
195	251T1325-1		DELETED		
195A	251T1325-2		...CRANK	A-C	1
-195B	251T1325-3		...CRANK	D-G	1
			ATTACHING PARTS		
196	BACR15BA5D21		...RIVET	A	1
197	BACR15BA5D15		...RIVET	A-G	1
198	BACR15BA5D11		...RIVET	A-G	2
			-------*-------		
200	251T1326-1		DELETED		
200A	251T1326-2		DELETED		
-200B	251T1326-2		...CRANK	B-G	1
200C	251T1326-3		...CRANK	A	1
210	251T1328-1		..TUBE ASSY	A-G	1
215	251T1328-2		...TUBE-INNER	A-G	1
220	251T1328-3		...TUBE-OUTER	A-G	1
222	BACR15BB4AD		..RIVET-	A-G	2
			(SIZE DETERMINE ON INST)		
223	B1355-4		..RETAINER-	A-G	1
			(V80539)		
			(SPEC BACR10G141)		
			(OPT B1355-4		
			(V80539))		
225	BACR15FT4AD		DELETED		
225A	BACR15BB4AD		DELETED		
225B	BACR15BA4AD		..RIVET-	A-G	4
			(SIZE DETERMINE ON INST)		
230	251T1348-2		..SHIELD-WATER	A,B	1
-230A	251T1348-3		..SHIELD-WATER	C-G	1
232	251T1348-3		..SHIELD-WATER	A-G	1
235	HL10VAZ5-13		.BOLT-	A-G	2
			(V60516)		
			(SPEC BACB30MY5K13)		
			(OPT B30MY5K13		
			(V97928))		

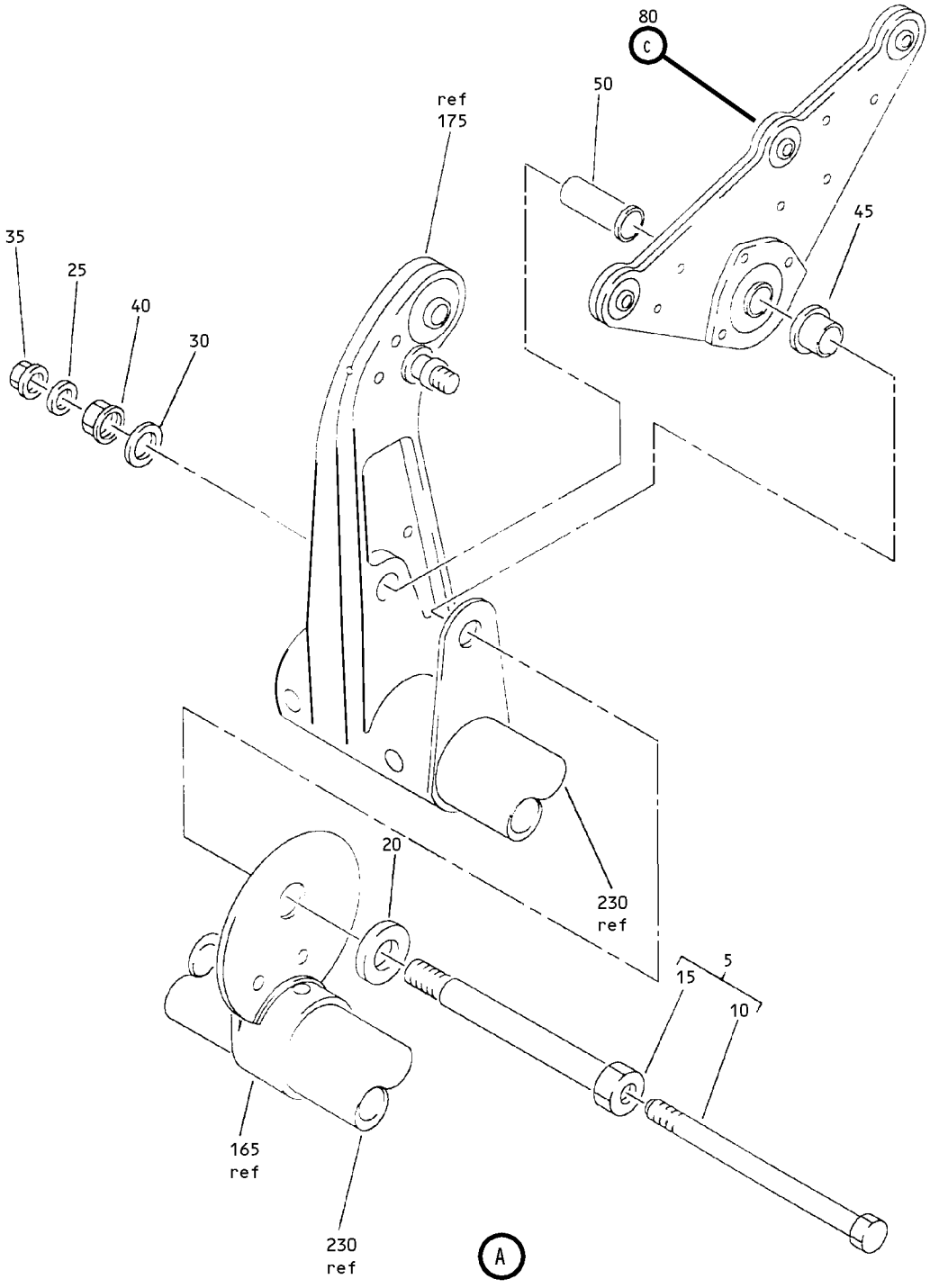
	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	240	NAS42DD5-40		DELETED		
	240A	NAS42DD3-40FC		.SPACER	A-G	2
	245	HL70-5		.COLLAR- (V5M902) (SPEC BACC30M5) (OPT HL70-5 (V73197)) (OPT HL70-5 (V92215)) (OPT 66014-5 (V56878)) (OPT HL70-5 (V56878))	A-G	2
	250	251T1348-1		.BRACKET	A-G	1
R	255	NAS1368N20H		.GROMMET	A-G	1

- Item Not Illustrated



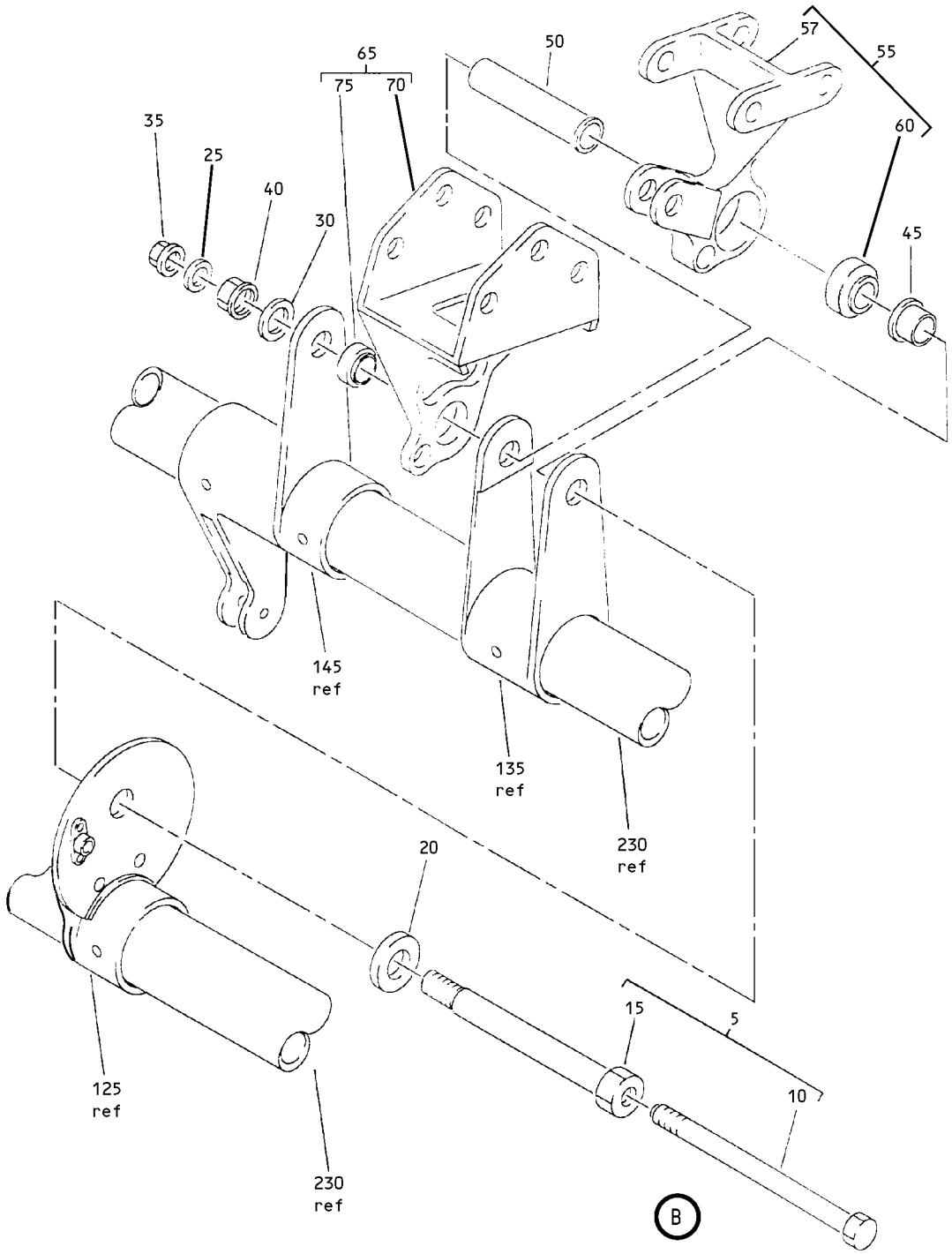
Left Hand Lateral Center Control Actuator Input Crank
Torque Tube And Bracket Assembly
Figure 2 (Sheet 1)

K26064



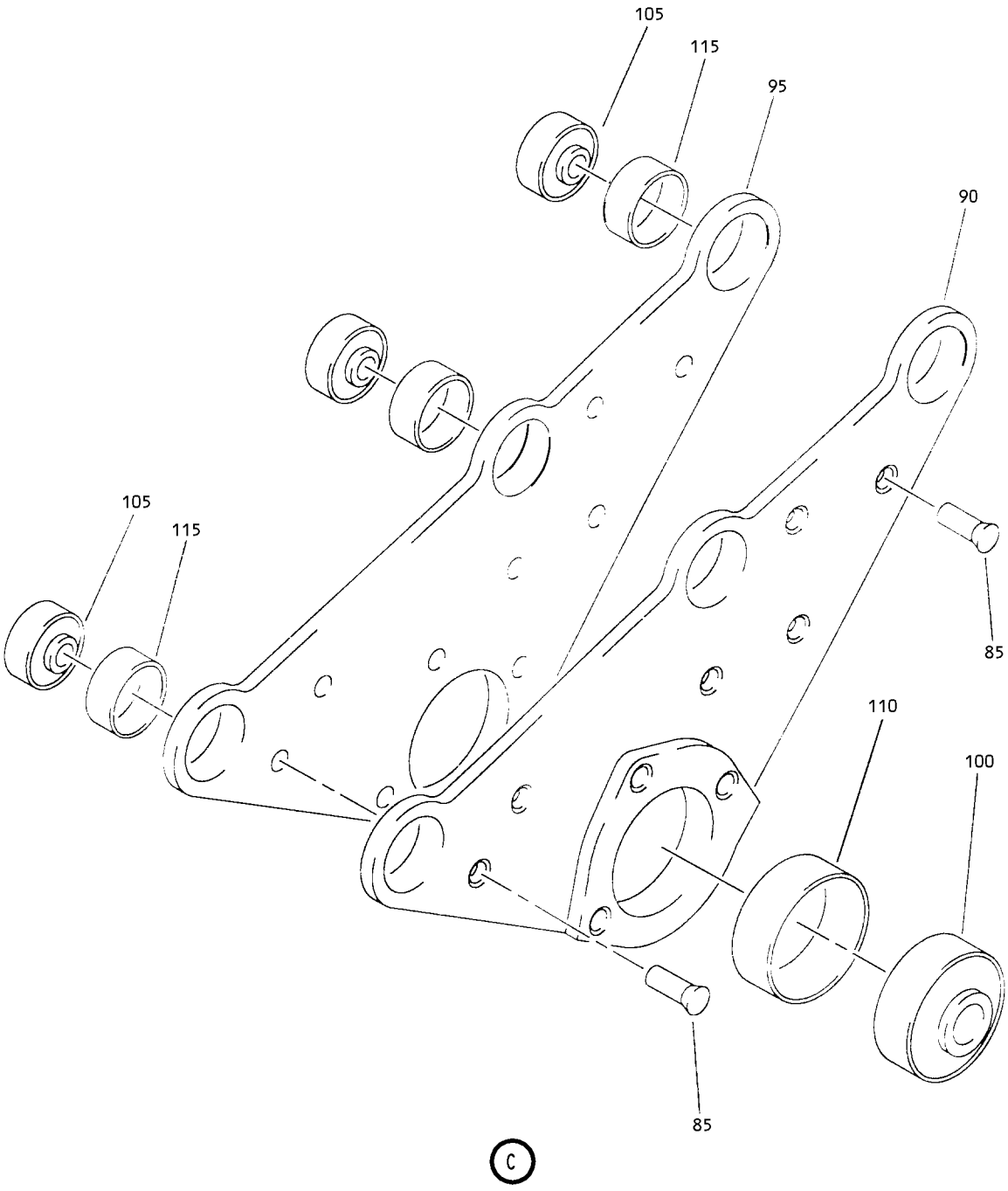
Left Hand Lateral Center Control Actuator Input Crank
Torque Tube And Bracket Assembly
Figure 2 (Sheet 2)

K26089



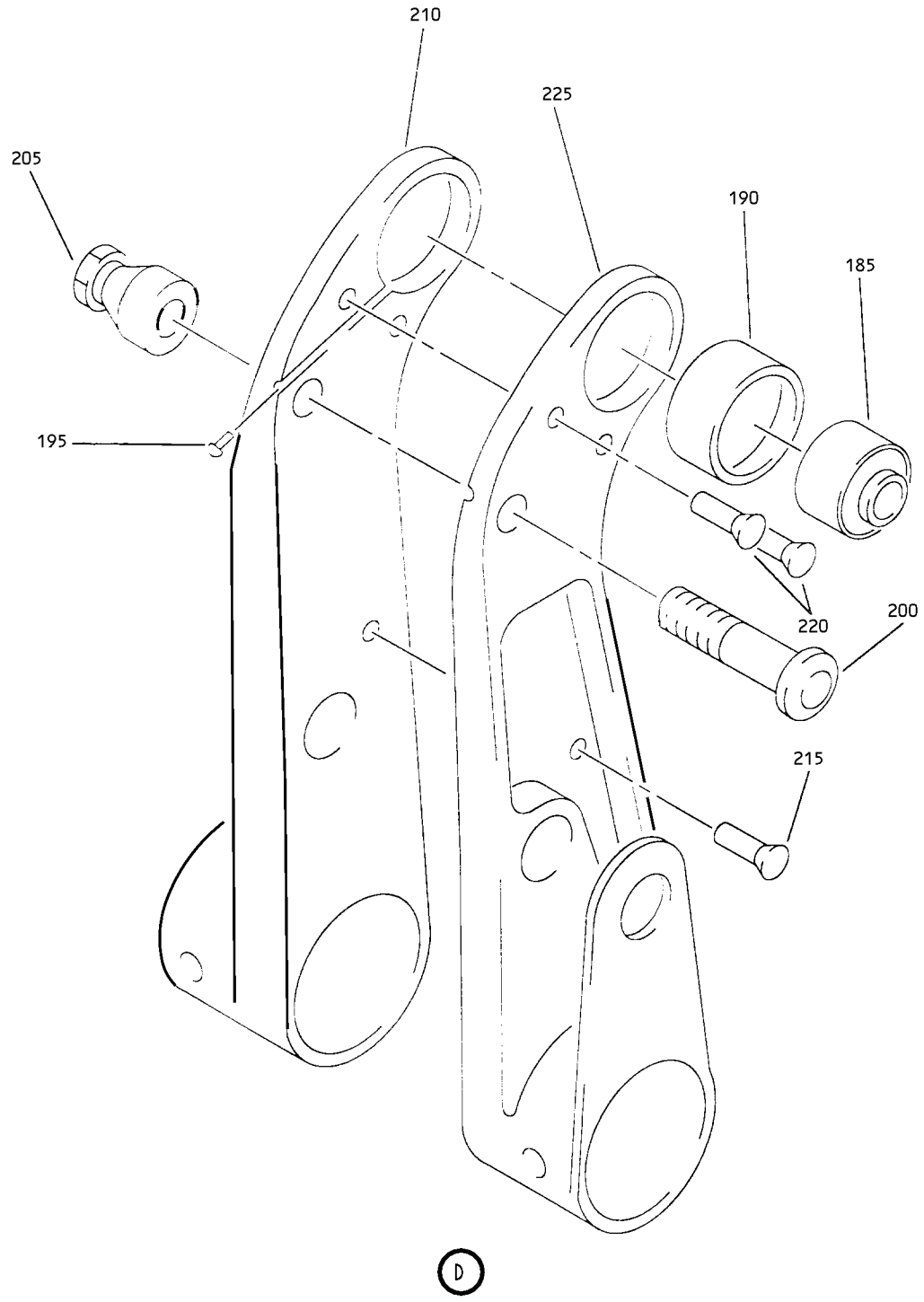
Left Hand Lateral Center Control Actuator Input Crank
Torque Tube And Bracket Assembly
Figure 2 (Sheet 3)

K26117



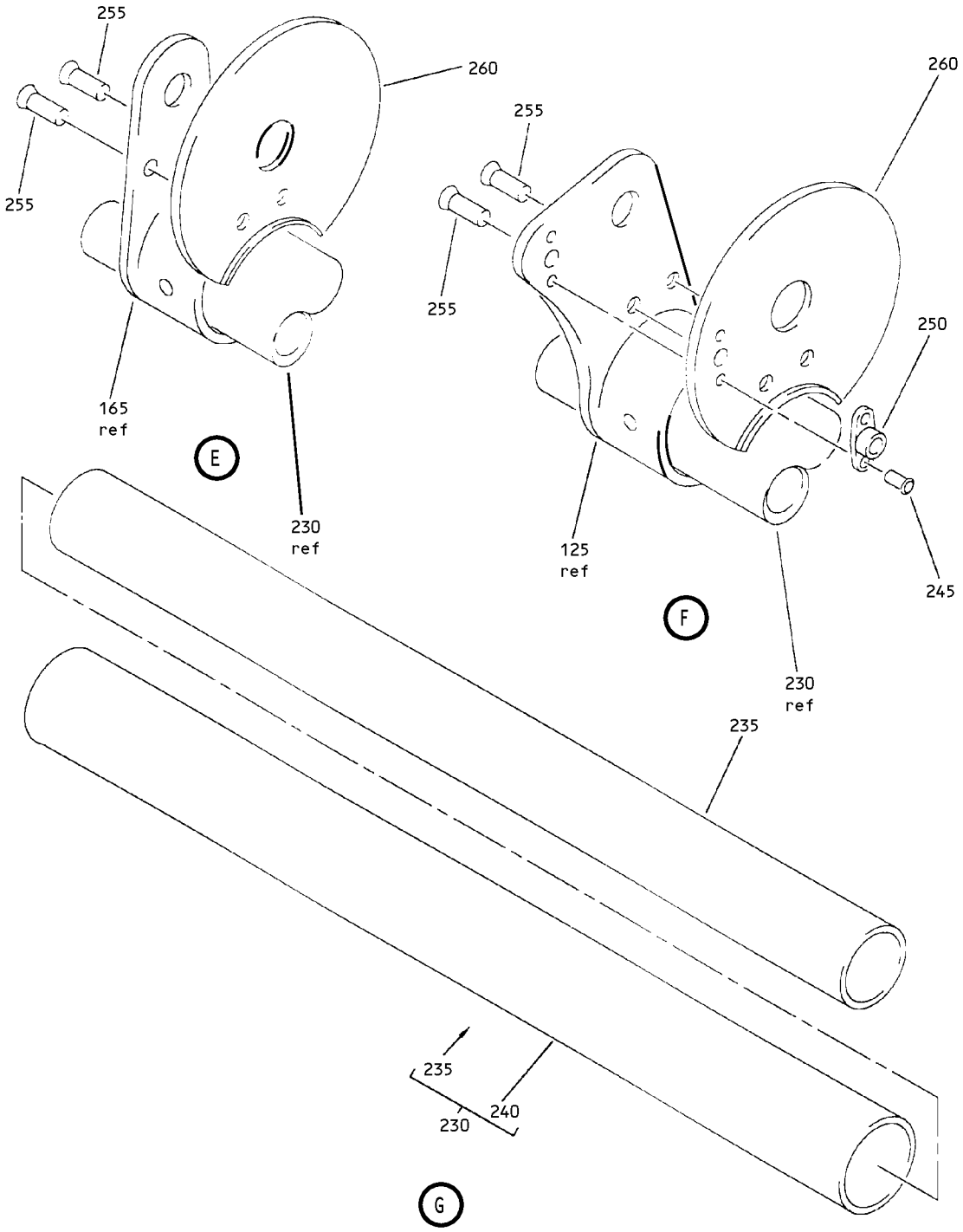
Left Hand Lateral Center Control Actuator Input Crank
Torque Tube And Bracket Assembly
Figure 2 (Sheet 4)

K26122



Left Hand Lateral Center Control Actuator Input Crank
Torque Tube And Bracket Assembly
Figure 2 (Sheet 5)

K26138



Left Hand Lateral Center Control Actuator Input Crank
Torque Tube And Bracket Assembly
Figure 2 (Sheet 6)

K26150

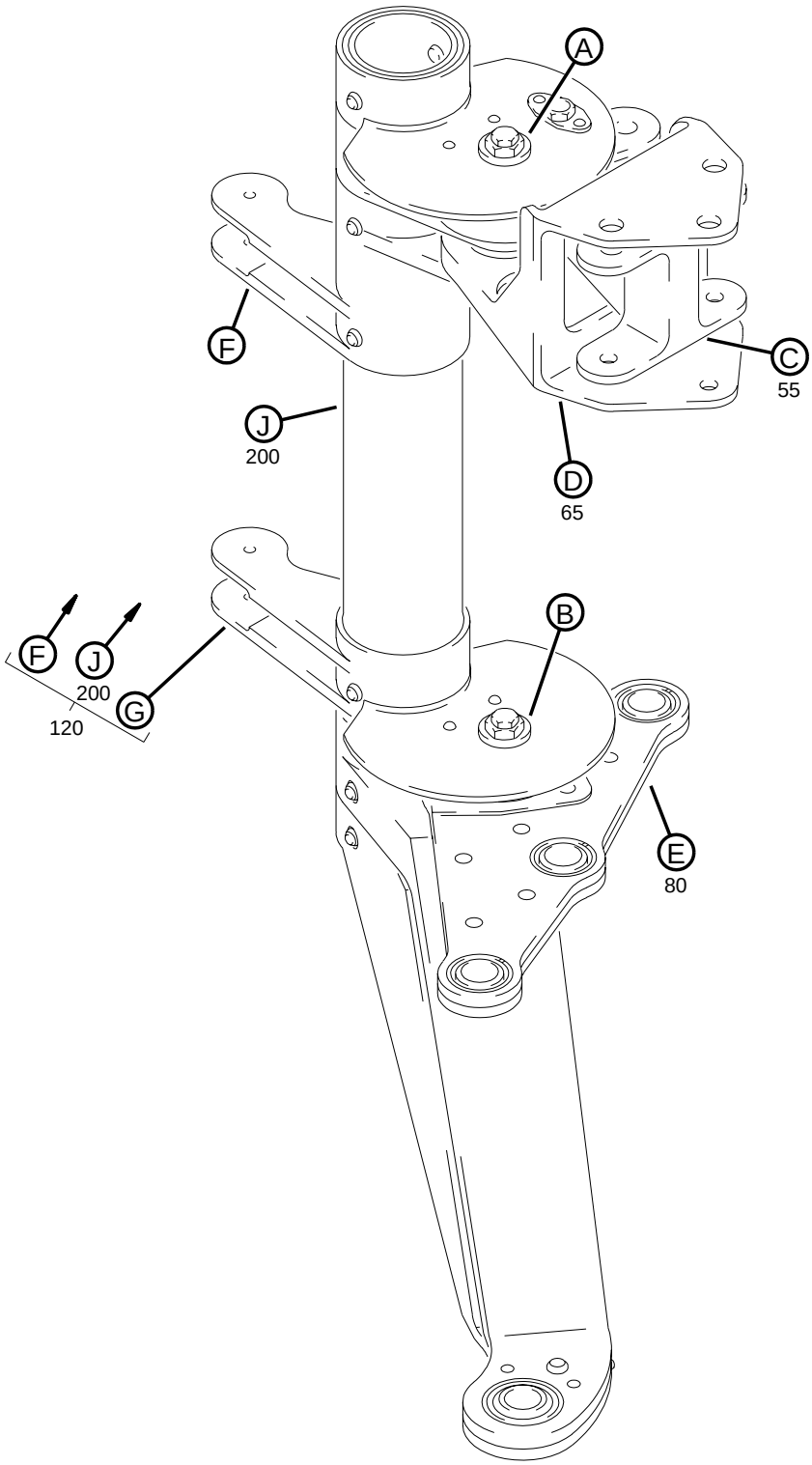
	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	02- -1	251T1305-16		TUBE AND BRACKET ASSY-LH LATERAL CENTRAL CONT ACTR INPUT CRANK TORQUE	H	RF
	5	251T0200-65		.BOLT ASSY	H	2
	10	NAS6704U49		..BOLT	H	1
	15	251T0200-10		..BOLT-OUTER HOLLOW	H	1
	20	BACW10P20AL		.WASHER	H	2
	25	NAS1149D0432J		.WASHER	H	2
	30	NAS1149D0663J		.WASHER	H	2
	35	H52732-4CD		.NUT- (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))	H	2
	40	H52732-6CD		.NUT- (V15653) (SPEC BACN10YR6CD) (OPT PLH56CD (V62554))	H	2
	45	251T1344-1		.BUSHING	H	2
	50	251T3742-9		.BUSHING	H	2
	55	251T1322-8		.BRACKET ASSY	H	1
R	57	251T1322-9		..BRACKET	H	1
	60	SA6-23A1-501		..BEARING- (V77896) (SPEC SO12T236-400)	H	1
	65	251T1323-5		.BRACKET ASSY	H	1
	70	251T1323-6		..BRACKET-CAGE	H	1
	75	PACMB538DDFS428		..BEARING- (V21335) (SPEC BACB10FU10) (OPT SSMB538DDSD705 (V83086)) (OPT PACMB538DDA3908 (V21335)) (OPT ACMB538DDP818LY (V40920))	H	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-					
80	251T1324-4		.BRACE ASSY-LWR	H	1
85	BACR15BA5AD		..RIVET- (SIZE DETERMINE ON INST)	H	9
90	251T1343-3		..BRACE-LWR	H	1
95	251T1343-4		..BRACE-UPR	H	1
100	SA6-23A1-501		..BEARING- (SPEC S012T236-400)	H	1
105	BWP3E115T		..BEARING- (V16746) (SPEC BACB10X3T) (OPT AW4CRG (V15860)) (OPT BSSR4806 (V81376)) (OPT HU4-136 (V02758)) (OPT KWB4CRG (V97613)) (OPT WS4E (V73134)) (OPT 55303 (V09455)) (OPT WC4-1 (V56644)) (OPT ABW4-5 (VS0352))	H	3
110	251T1362-2		..SLEEVE	H	1
115	251T1362-1		..SLEEVE	H	3
120	251T1345-12		.TUBE ASSY	H	1
125	251T1347-2		..FITTING ATTACHING PARTS	H	1
130	MS90354-0806		..RIVET -------*-------	H	2
135	251T1330-2		..FITTING ATTACHING PARTS	H	1
140	MS90354-0806		..RIVET -------*-------	H	2

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-					
145	251T1331-1		..CRANK-OUTPUT	H	1
			ATTACHING PARTS		
150	MS90354-0806		..RIVET	H	4
			-------*-------		
155	251T1337-1		..CRANK-OUTPUT	H	1
			ATTACHING PARTS		
160	MS90354-0806		..RIVET	H	2
			-------*-------		
165	251T1329-1		..FITTING	H	1
			ATTACHING PARTS		
170	MS90354-0806		..RIVET	H	2
			-------*-------		
175	251T1346-6		..CRANK ASSY-INPUT	H	1
			ATTACHING PARTS		
180	MS90354-0806		..RIVET	H	4
			-------*-------		
185	ASR6-30		...BEARING-	H	1
			(V50352)		
			(SPEC BACB10CK6)		
			(OPT SA6-23A4		
			(V77896))		
190	251T1377-1		...SLEEVE-RETAINING	H	1
195	NAS516-1A		...FITTING-LUBE	H	1
200	HL10VAZ6-8		...BOLT-	H	1
			(V60516)		
			(SPEC BACB30MY6K8)		
			(OPT B30MY6K8		
			(V97928))		
205	HL79-6		...COLLAR-	H	1
			(V5M902)		
			(SPEC BACC30M6)		
			(OPT HL79-6		
			(V73197))		
			(OPT HL79-6		
			(V92215))		
			(OPT 66014-6		
			(V56878))		
			(OPT HL79-6		
			(V56878))		
210	251T1325-3		...CRANK	H	1
			ATTACHING PARTS		
215	BACR15BA5D15		...RIVET	H	1
220	BACR15BA5D11		...RIVET	H	2
			-------*-------		

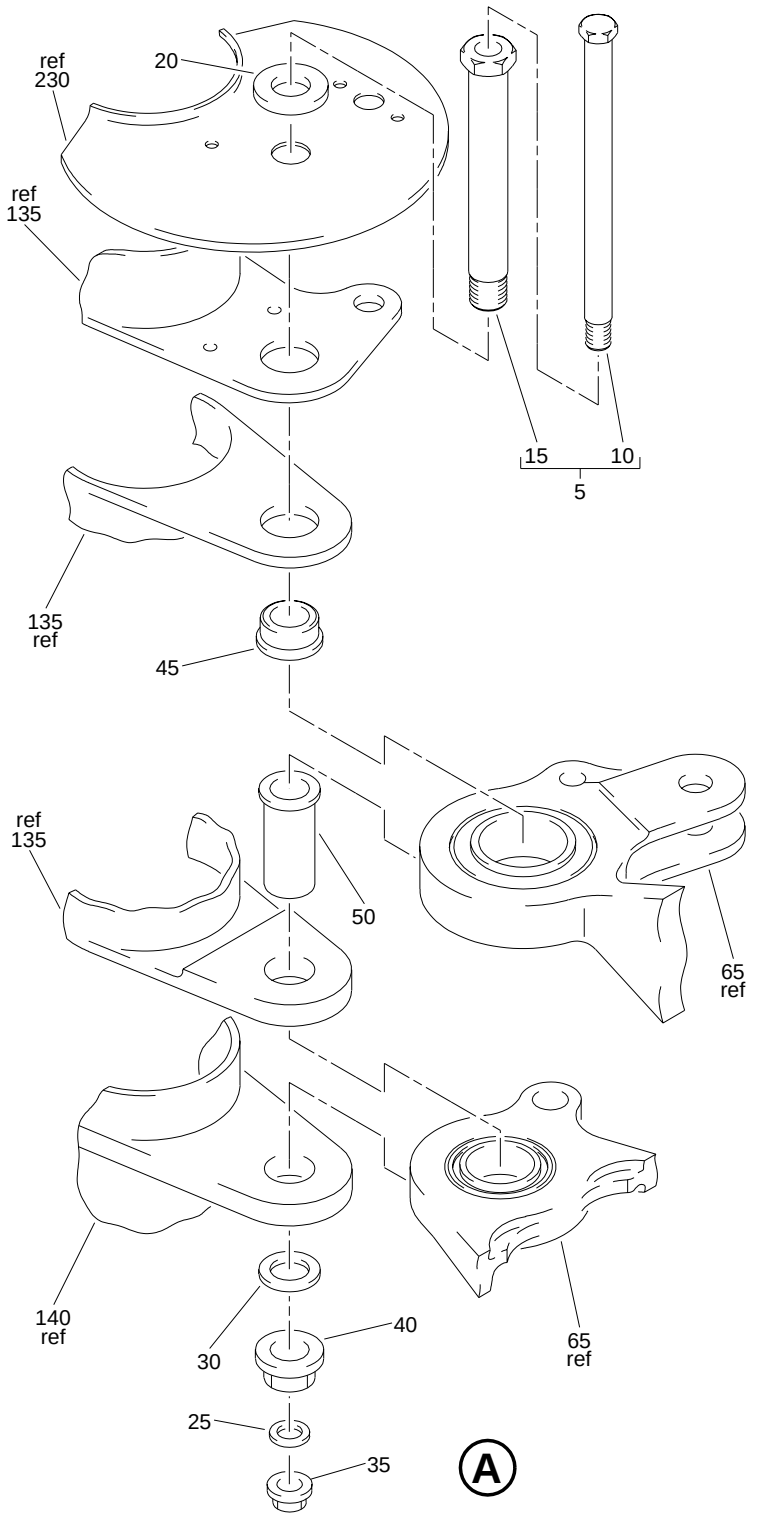
FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-					
225	251T1326-2		...CRANK	H	1
230	251T1328-1		..TUBE ASSY	H	1
235	251T1328-2		...TUBE-INNER	H	1
240	251T1328-3		...TUBE-OUTER	H	1
245	BACR15BB4AD		..RIVET- (SIZE DETERMINE ON INST)	H	2
250	B1355-4		..RETAINER- (V80539) (SPEC BACR10G141) (OPT B1355-4 (V80539))	H	1
255	BACR15BA5AD		..RIVET- (SIZE DETERMINE ON INST)	H	4
260	251T1348-3		..SHIELD-WATER	H	2

- Item Not Illustrated



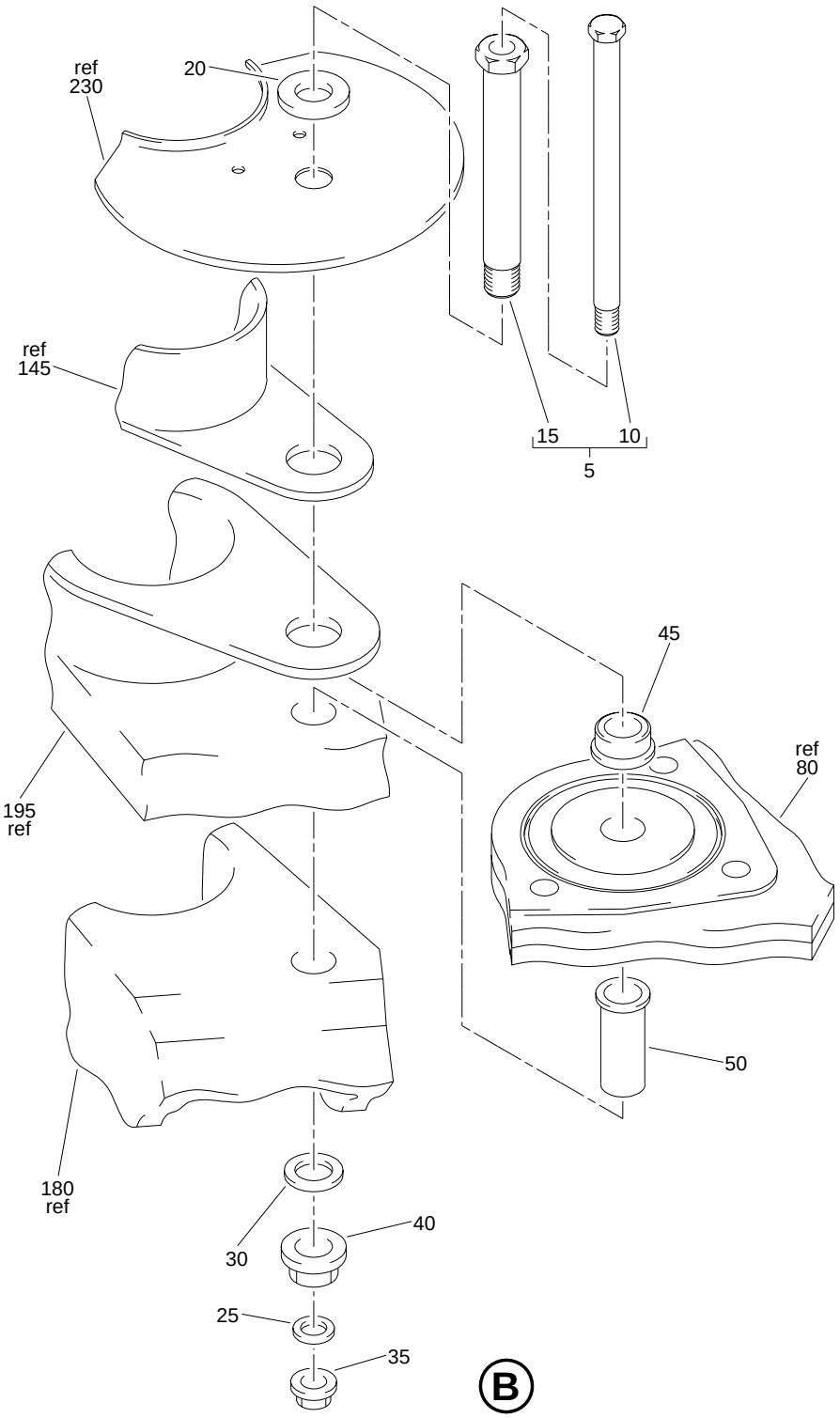
Left Hand Lateral Center Control Actuator Input Crank Torque Tube
and Bracket Assembly
Figure 3 (Sheet 1)

W89331



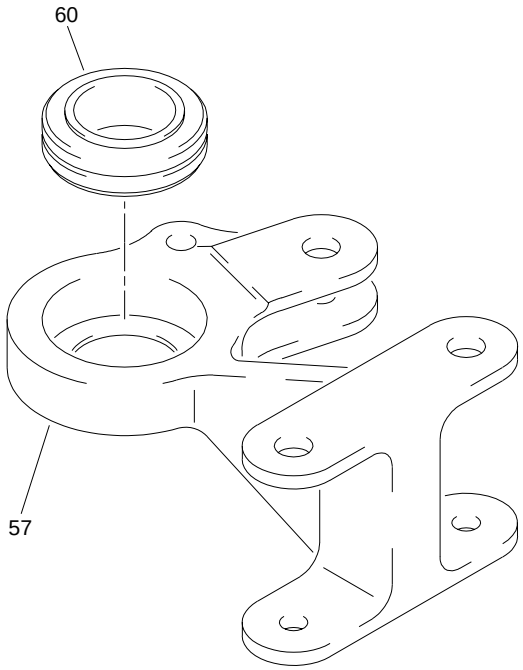
Left Hand Lateral Center Control Actuator Input Crank Torque Tube
and Bracket Assembly
Figure 3 (Sheet 2)

W89337

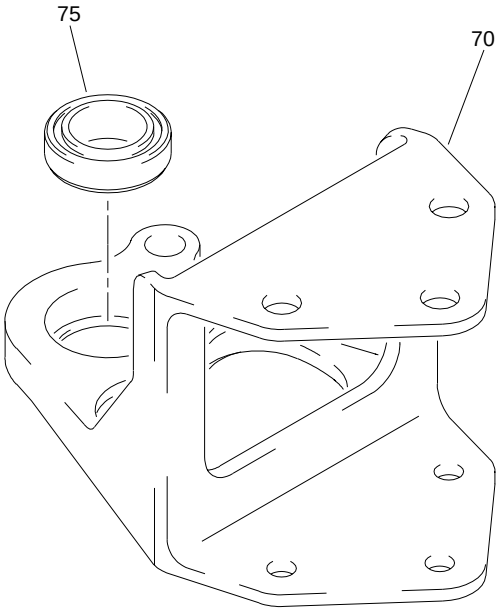


Left Hand Lateral Center Control Actuator Input Crank Torque Tube
and Bracket Assembly
Figure 3 (Sheet 3)

W89342



C



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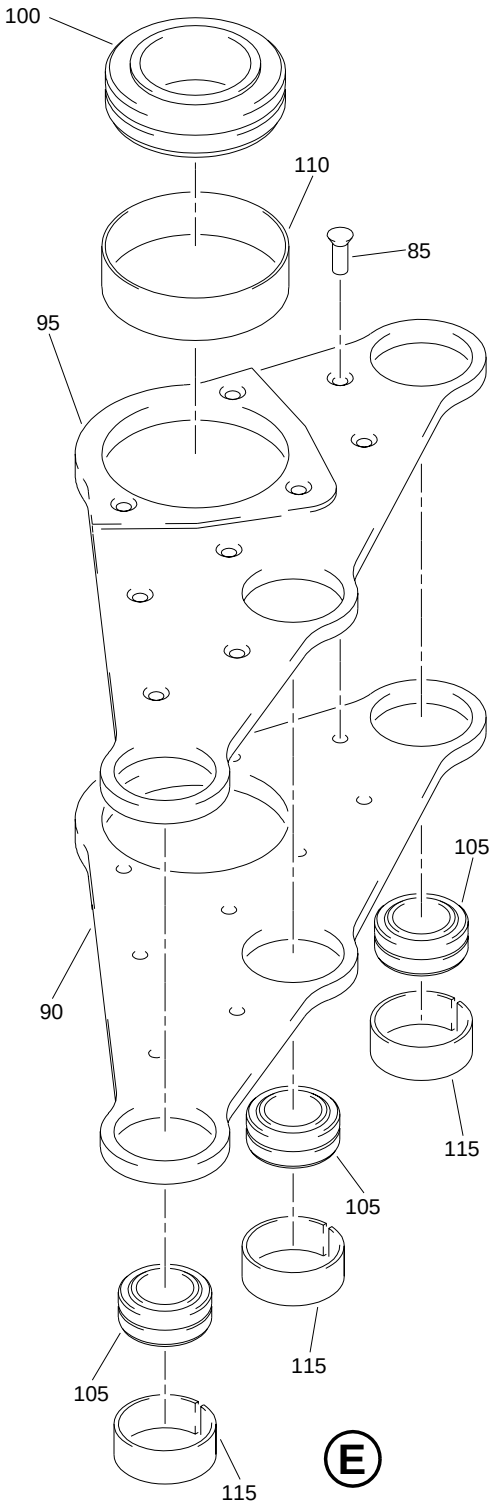
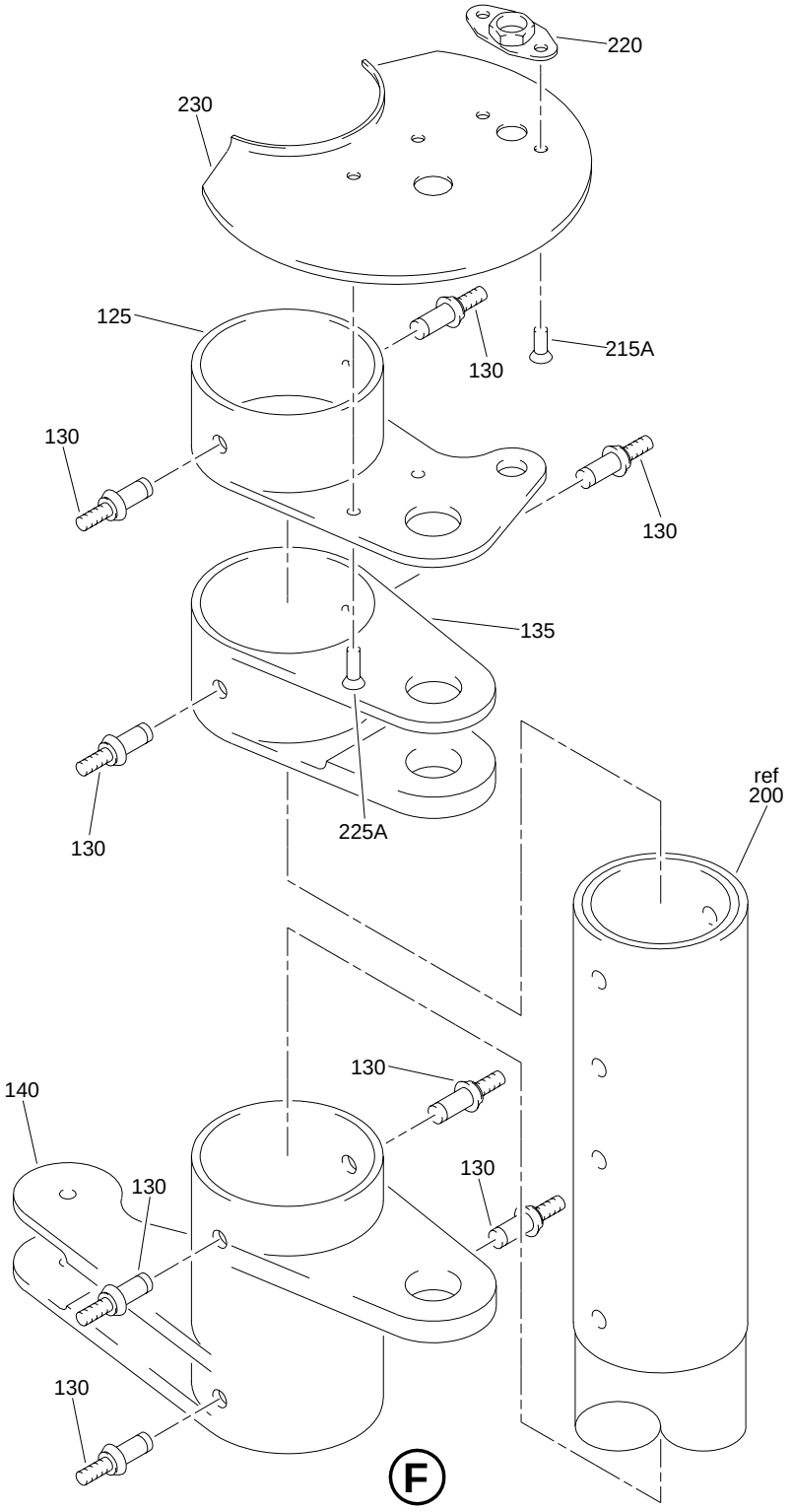
Left Hand Lateral Center Control Actuator Input Crank Torque Tube
and Bracket Assembly
Figure 3 (Sheet 4)

W89348



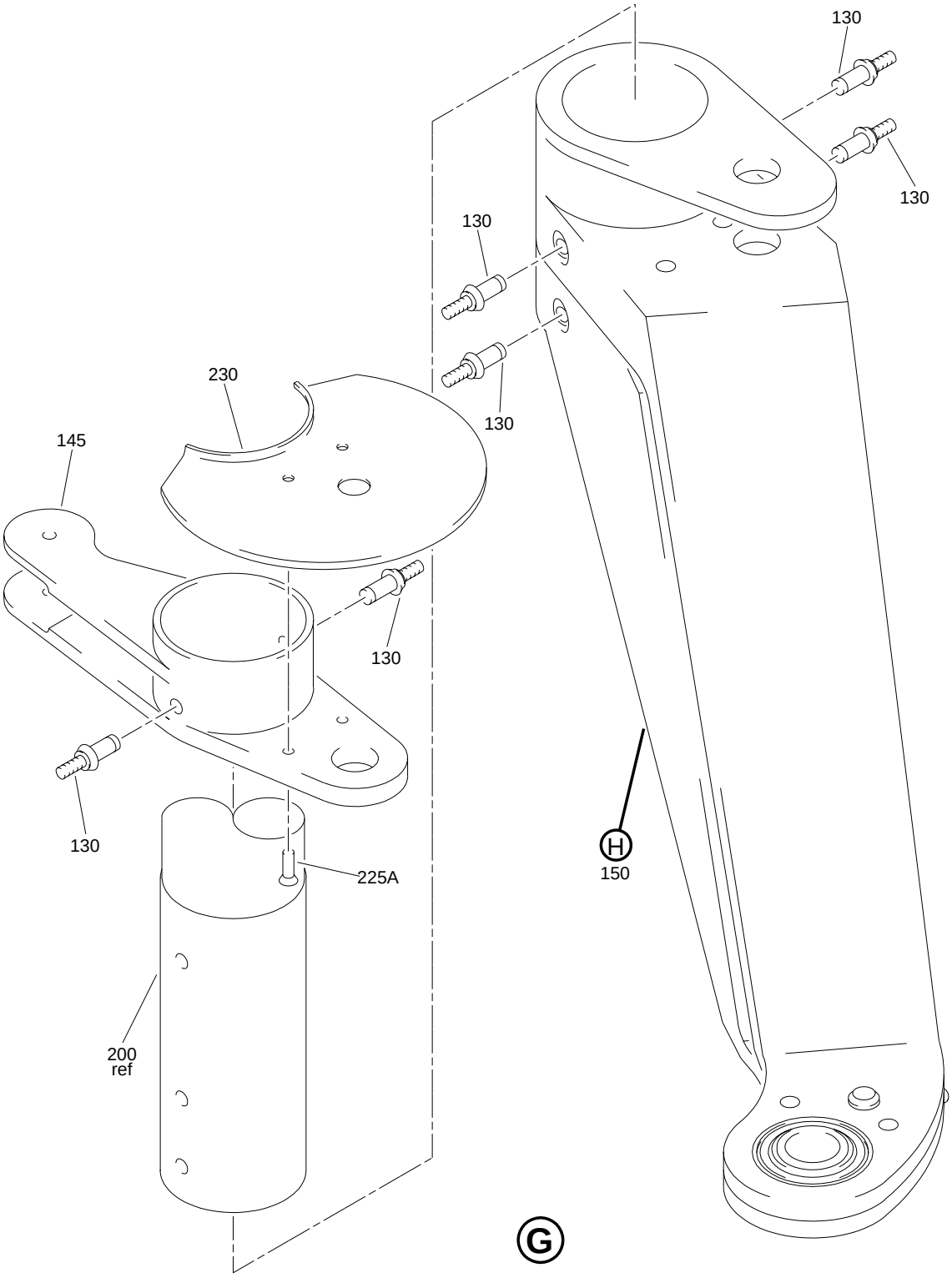
Left Hand Lateral Center Control Actuator Input Crank Torque Tube
and Bracket Assembly
Figure 3 (Sheet 5)

W89393



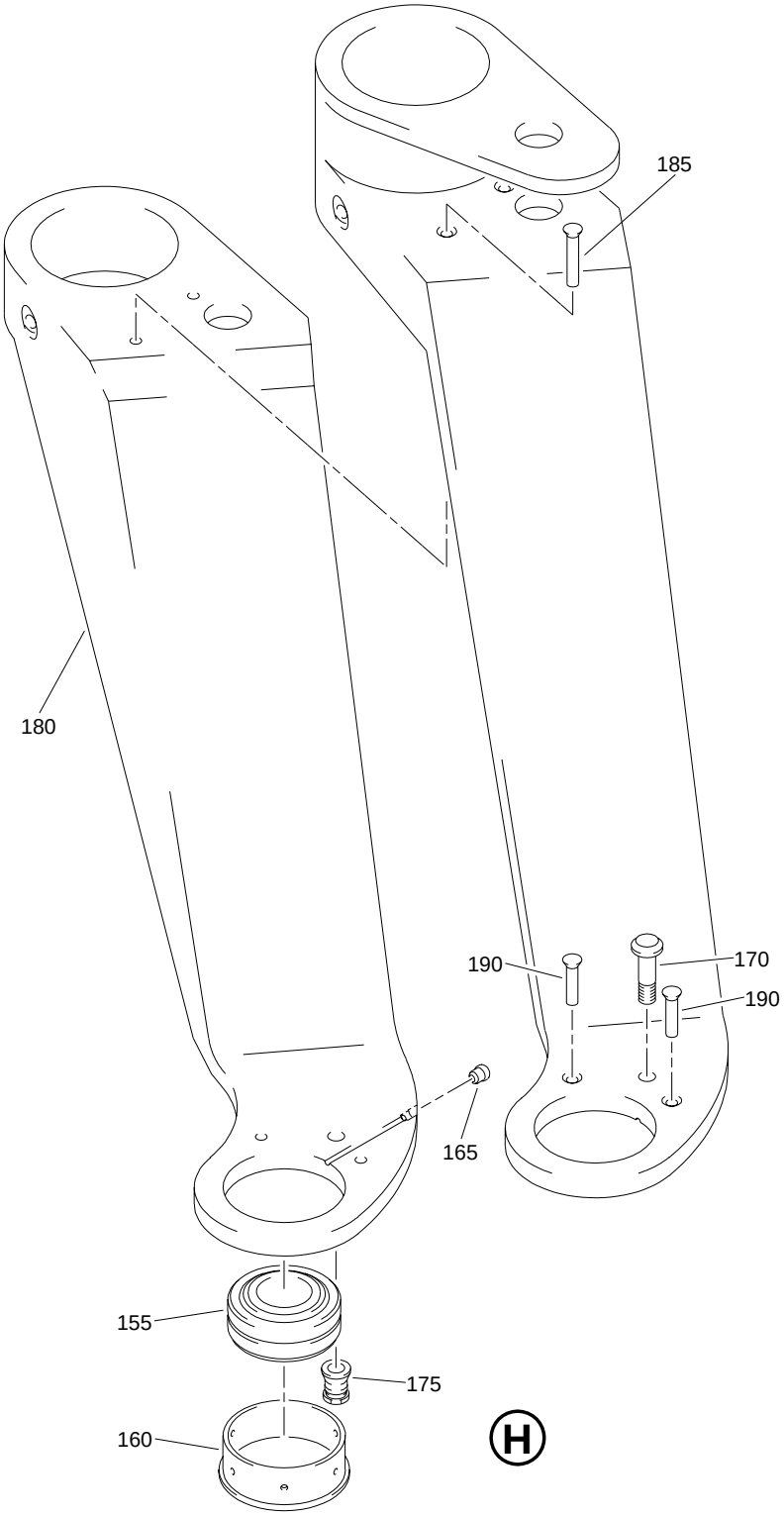
Left Hand Lateral Center Control Actuator Input Crank Torque Tube
and Bracket Assembly
Figure 3 (Sheet 6)

W89394

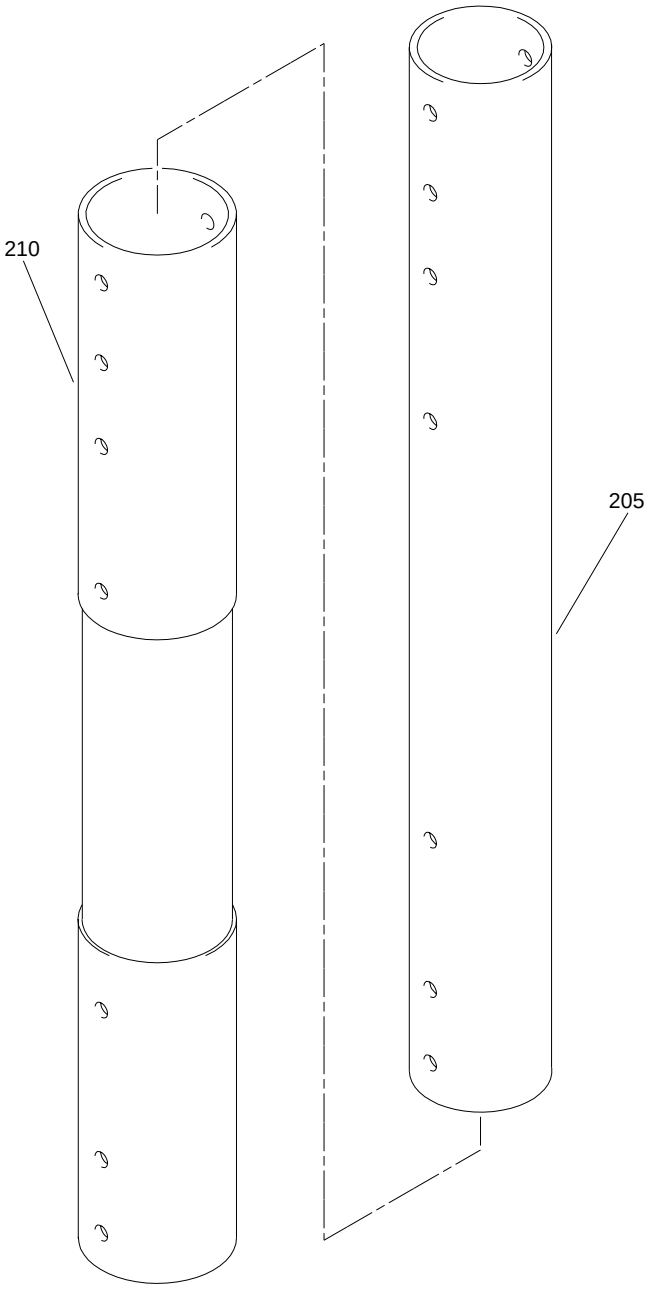


Left Hand Lateral Center Control Actuator Input Crank Torque Tube
and Bracket Assembly
Figure 3 (Sheet 7)

W89395



Left Hand Lateral Center Control Actuator Input Crank Torque Tube
and Bracket Assembly
Figure 3 (Sheet 8)



Left Hand Lateral Center Control Actuator Input Crank Torque Tube
and Bracket Assembly
Figure 3 (Sheet 9)

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	03-					
R	-1	251T1305-17		TUBE AND BRACKET ASSY-LH LATERAL CENTRAL CONT ACTR INPUT CRANK TORQUE	J	RF
R	5	251T0200-65		.BOLT ASSY	J	2
R	10	NAS6704U49		..BOLT	J	1
R	15	251T0200-10		..BOLT-OUTER HOLLOW	J	1
R	20	BACW10P20AL		.WASHER	J	2
R	25	NAS1149D0432J		.WASHER	J	2
R	30	NAS1149D0663J		.WASHER	J	2
R	35	H52732-4CD		.NUT- (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))	J	2
R	40	H52732-6CD		.NUT- (V15653) (SPEC BACN10YR6CD) (OPT PLH56CD (V62554))	J	2
R	45	251T1344-1		.BUSHING	J	2
R	50	251T3742-9		.BUSHING	J	2
R	55	251T1322-8		.BRACKET ASSY	J	1
R	57	251T1322-9		..BRACKET-CAGE	J	1
R	60	SA6-23A1-501		..BEARING- (V77896) (SPEC S012T236-400)	J	1
R	65	251T1323-5		.BRACKET ASSY	J	1
R	70	251T1323-6		..BRACKET-CAGE	J	1
R	75	PACMB538DDFS428		..BEARING- (V21335) (SPEC BACB10FU10) (OPT SSMB538DDSD705 (V83086)) (OPT PACMB538DDA3908 (V21335)) (OPT ACMB538DDP818LY (V40920))	J	1
R	80	251T1324-5		.BRACE ASSY-LWR	J	1
R	85	BACR15BA5AD		..RIVET- (SIZE DETERMINE ON INST)	J	9
R	90	251T1343-5		..BRACE-LWR	J	1
R	95	251T1343-6		..BRACE-UPR	J	1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	03-					
R	100	SA6-23A1-501		..BEARING- (SPEC S012T236-400)	J	1
R	105	BWP3E115T		..BEARING- (V16746) (SPEC BACB10X3T) (OPT AW4CRG (V15860)) (OPT BSSR4806 (V81376)) (OPT HU4-136 (V02758)) (OPT KWB4CRG (V97613)) (OPT WS4E (V73134)) (OPT 55303 (V09455)) (OPT WC4-1 (V56644)) (OPT ABW4-5 (VS0352))	J	3
R	110	251T1362-2		..SLEEVE	J	1
R	115	251T1362-1		..SLEEVE	J	3
R	120	251T1345-13		.TUBE ASSY	J	1
R	125	251T1347-2		..FITTING ATTACHING PARTS	J	1
R	130	MS90354-0806		..RIVET -------*-------	J	14
R	135	251T1330-2		..FITTING	J	1
R	140	251T1331-1		..CRANK-OUTPUT	J	1
R	145	251T1337-2		..CRANK-OUTPUT	J	1
R	150	251T1346-7		..CRANK ASSY-INPUT	J	1
R	155	SA6-23A1-503		...BEARING- (V77896) (SPEC BACB10CK6D) (OPT SA6-23A51 (V77896)) (OPT SA6-23A53 (V77896)) (OPT ASR6D30 (VS0352))	J	1
R	160	251T1377-1		...SLEEVE-RETAINING	J	1
R	165	NAS516-1A		...FITTING-LUBE	J	1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	03-					
R	170	HL10VAZ6-8		...BOLT- (V60516) (SPEC BACB30MY6K8) (OPT B30MY6K8 (V97928))	J	1
R	175	HL79-6		...COLLAR- (V5M902) (SPEC BACC30M6) (OPT HL79-6 (V73197)) (OPT HL79-6 (V92215)) (OPT 66014-6 (V56878)) (OPT HL79-6 (V56878))	J	1
R	180	251T1325-4		...CRANK ATTACHING PARTS	J	1
R	185	BACR15BA5D15		...RIVET	J	2
R	190	BACR15BA5D11		...RIVET -------*-------	J	2
R	195	251T1326-4		...CRANK	J	1
R	200	251T1328-4		..TUBE ASSY	J	1
R	205	251T1328-5		...TUBE-INNER	J	1
R	210	251T1328-6		...TUBE-OUTER	J	1
	215	BACR15BB4AD		DELETED		
R	215A	BACR15BB3AD		..RIVET- (SIZE DETERMINE ON INST)	J	2
R	220	B1355-4		..RETAINER- (V80539) (SPEC BACR10G141) (OPT B1355-4 (V80539))	J	1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	03-					
	225	BACR15BA5AD		DELETED		
R	225A	BACR15BA4AD		..RIVET- (SIZE DETERMINE ON INST)	J	4
R	230	251T1348-3		..SHIELD-WATER	J	2

- Item Not Illustrated