TO: ALL HOLDERS OF AILERON CONTROL QUADRANT OVERRIDE ASSEMBLY COMPONENT MAINTENANCE MANUAL 27-11-26

REVISION NO. 10 DATED MAR 01/05

HIGHLIGHTS

All data formerly in manual 27-11-21 is included in this manual 27-11-26.

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
501	Specified penetrant check instead of magnetic particle check for 251T1536-2 spring
1014	Moved the item number callout for the quadrant assembly away from the cam
1014	Changed the IPL illustration to show more washers on the eyebolts

AILERON CONTROL QUADRANT OVERRIDE ASSEMBLY

PART NUMBERS 251T1505-2 THRU -10,-12 THRU -17, -19,-20

COMPONENT MAINTENANCE MANUAL
WITH
ILLUSTRATED PARTS LIST

13318

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 B10265	JUL 10/81
		PRR B12597	JUN 01/95
27-0142			JUL 01/99
27-0128			NOV 01/03
27A0175			NOV 01/03
		PRR B12901-21RS	JUL 01/04

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27-11-26		
TITLE PAGE		
1	JUL 01/04	01.1
2	BLANK	
REVISION RECORD		
1	OCT 01/87	01
2	BLANK	
TR & SB RECORD		
1	JUL 01/04	01.1
2	BLANK	
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*1	MAR 01/05	01
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1	OCT 01/87	01
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1	OCT 01/87	01
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301	JUL 01/04	01.1
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601	JUL 01/04	01.1
602	JUL 01/04	01.1
603	JUN 01/95	01.1
604	BLANK	
REPAIR 1-1		
601	NOV 01/04	01.1
602	JUL 01/04	01.1
603	JUL 01/04	01.1
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603	JUL 01/04	01.1
604	JUL 01/04	01.101
605	JUL 01/04	01.101
606	JUL 01/04	01.1
607	JUL 01/04	01.1
608	BLANK	
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601	NOV 01/99	01.1
602	BLANK	
ASSEMBLY		
701	JUL 01/04	01.1
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703	JUL 01/04	01.101
704	BLANK	

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FITS AND CLEARANCES		
801	JUL 01/04	01.1
802	JUL 01/04	01.1
803	JUL 01/04	01.1
804	BLANK	
ILLUSTRATED PARTS LIST		
1001	OCT 01/87	01
1002	JUL 01/04	01.1
1003	JUL 01/04	01.1
1004	JUL 01/04	01.1
1005	JUL 01/04	01.1
1006	JUL 01/04	01.1
1007	JUL 01/04	01.1
1008	JUL 01/04	01.1
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1019	JUL 01/04	01.1
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1021	JUL 01/04	01.1
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1023	JUL 01/04	01.1
1024	JUL 01/04	01.1
1025	JUL 01/04	01.1
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1036	NOV 01/04	01.101

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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 2/85
Assembly	May 2/85

AILERON CONTROL QUADRANT OVERRIDE ASSEMBLY

DESCRIPTION AND OPERATION

1. The aileron control quadrant override assembly consists of a quadrant with a cam, roller, lever and spring device to limit control wheel loads. A cable system from the copilot's control wheel drives the quadrant through a ±5 degree lost motion which provides input to the central control actuator.

2. Leading Particulars (approximate)

   Width -- 4 inches
   Length -- 10 inches
   Height -- 10 inches
   Weight -- 6.8 lbs

DISASSEMBLY

1. Parts Replacement

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

A. Cotter pin (121, IPL Fig. 1)

2. Disassembly (IPL Fig. 1)

WARNING: USE EXTREME CARE WHEN REMOVING SPRING (20), NUT (15) OR EYEBOLT (5). SPRINGS (20) ARE HEAVILY LOADED.

A. Slowly back off nuts (15B) on eyebolts (5) to relieve springs (20) tension. Remove nuts (15B), washers (10A) from eyebolts.

NOTE: Note number of washers (10A) to ease assembly.

B. Remove eyebolts (5) from springs (20) and unhook springs from quadrant assembly (125).

C. Remove bolt (25C), nut (30A,32), bushing (35B or 37), washer (27) and remove lever assembly (40A) from quadrant assembly (125).

NOTE: Do not disassemble lever assembly (40A) unless repair or replacement is necessary.

D. Remove bolt (80), washer (85A), nut (90) and remove cam (75A) and carrier assembly (95).

NOTE: Do not disassemble the carrier assembly (95), or remove the installation parts (900, 905) from the carrier, unless repair or replacement is necessary.

E. Remove bearings (110, 115), spacers (113, 120) from quadrant assembly (125).

NOTE: Bearings (110,115) are installed with grease. Remove bearings with shop hand tools.

F. Remove cotter pin (121A), pin (123) and washer (122A) from quadrant assembly (125).

NOTE: Do not disassemble quadrant assembly (125) unless repair or replacement is necessary.

CLEANING

1. Clean all parts except bearings using standard industry practices information contained in 20-20-03.

2. Clean all 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 per 20-20-01 -- Cam (75A), spring (20), bushing (35B, 37).

4. Penetrant check per 20-20-02 -- Spring (20A, 20B), carrier (105), lever (70A), quadrant (140).

5. Check springs (20).

   CAUTION: DO NOT EXTEND SPRING (20) BEYOND 7.6 INCHES OR PERMANENT DEFORMATION MAY RESULT.

   A. Extend spring to 5.6 inches and check that load is 29.2 to 35.8 lbs.

   B. Extend spring to 7.59 inches and check that load is 100.8 to 123.2 lbs.

REPAIR - GENERAL

1. Content

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

P/N	NAME	REPAIR
251T1539	LEVER	1-1
251T1521	CARRIER	2-1
251T1515	QUADRANT	3-1
- - -	MISC PARTS REFINISH	4-1

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
20-42-03 Hard Chrome Plating
20-42-05 Bright Cadmium Plating
20-43-01 Chromic Acid Anodizing
20-50-03 Bearing and Bushing Replacement
20-60-02 Finishing Materials
20-60-03 Lubricants
20-60-04 Miscellaneous Materials

3. Materials

NOTE: Equivalent substitutes may be used.

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

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

C. Enamel -- BMS 10-60, Type 1 (Ref 20-60-02)

D. Grease -- BMS 3-24 (Optional BMS 3-33) (Ref 20-60-03)

4. Dimensioning Symbols

A. Standard True Positioning 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
↗↗	TOTAL RUNOUT
⌴	COUNTERBORE OR SPOTFACE
∨	COUNTERSINK
⌖	THEORETICAL EXACT POSITION OF A FEATURE (TRUE POSITION)
∅	DIAMETER
S ∅	SPHERICAL DIAMETER
R	RADIUS
SR	SPHERICAL RADIUS
()	REFERENCE
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)
Ⓛ	LEAST MATERIAL CONDITION (LMC)
Ⓢ	REGARDLESS OF FEATURE SIZE (RFS)
Ⓟ	PROJECTED TOLERANCE ZONE
FIM	FULL INDICATOR MOVEMENT

EXAMPLES

[— | 0.002]	STRAIGHT WITHIN 0.002
[⊥ | 0.002 | B]	PERPENDICULAR TO B WITHIN 0.002
[// | 0.002 | A]	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
[⌒ | 0.006 | A]	EACH LINE ELEMENT OF THE SURFACE AT ANY CROSS SECTION MUST LIE BETWEEN TWO PROFILE BOUNDARIES 0.006 INCH APART RELATIVE TO DATUM PLANE A
[⌓ | 0.020 | A]	SURFACES MUST LIE WITHIN PARALLEL BOUNDARIES 0.02 INCH APART AND EQUALLY DISPOSED ABOUT TRUE PROFILE
[◎ | ∅ 0.0005 | C]	CONCENTRIC TO C WITHIN 0.0005 DIAMETER
[≡ | 0.010 | A]	SYMMETRICAL WITH A WITHIN 0.010
[∠ | 0.005 | A]	ANGULAR TOLERANCE 0.005 WITH A
[⌖ | ∅ 0.002 Ⓢ | B]	LOCATED AT TRUE POSITION WITHIN 0.002 DIA RELATIVE TO DATUM B, REGARDLESS OF FEATURE SIZE
[⊥ | ∅ 0.010 Ⓜ | A] [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	THEORETICALLY EXACT DIMENSION IS 2.000

NOTE: DATUM MAY APPEAR AT EITHER SIDE OF TOLERANCE FRAME [0.020 | A] [A | 0.020]

True Position Dimensioning Symbols
Figure 601

13320

LEVER ASSEMBLY - REPAIR 1-1

251T1539-3, -5, -7, -8

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

1. Bearing Replacement (IPL Fig. 1)

   A. Remove the bolt, (45), collar (50), bushing (55) and bearing (60) from the lever (70A) as shown in Fig. 601.

   B. Install the replacement bearing (60) on the lever (70A) with parts (45, 50, and 55).

2. Bushing (65A) Replacement

   A. Remove the bushings.

   B. Install the replacement bushings with wet BMS 5-95 sealant, and stake per SOPM 20-50-03.

3. Bolt Hole Repair (IPL Fig. 1)

   A. Machine the bolt holes oversize as required to remove defects. At Location 2 (Fig. 601), machine the hole a minimum of 0.060 inch oversize to make sure that the wall thickness of the repair bushing is a minimum of 0.030 inch. Do not machine more than the limits shown.

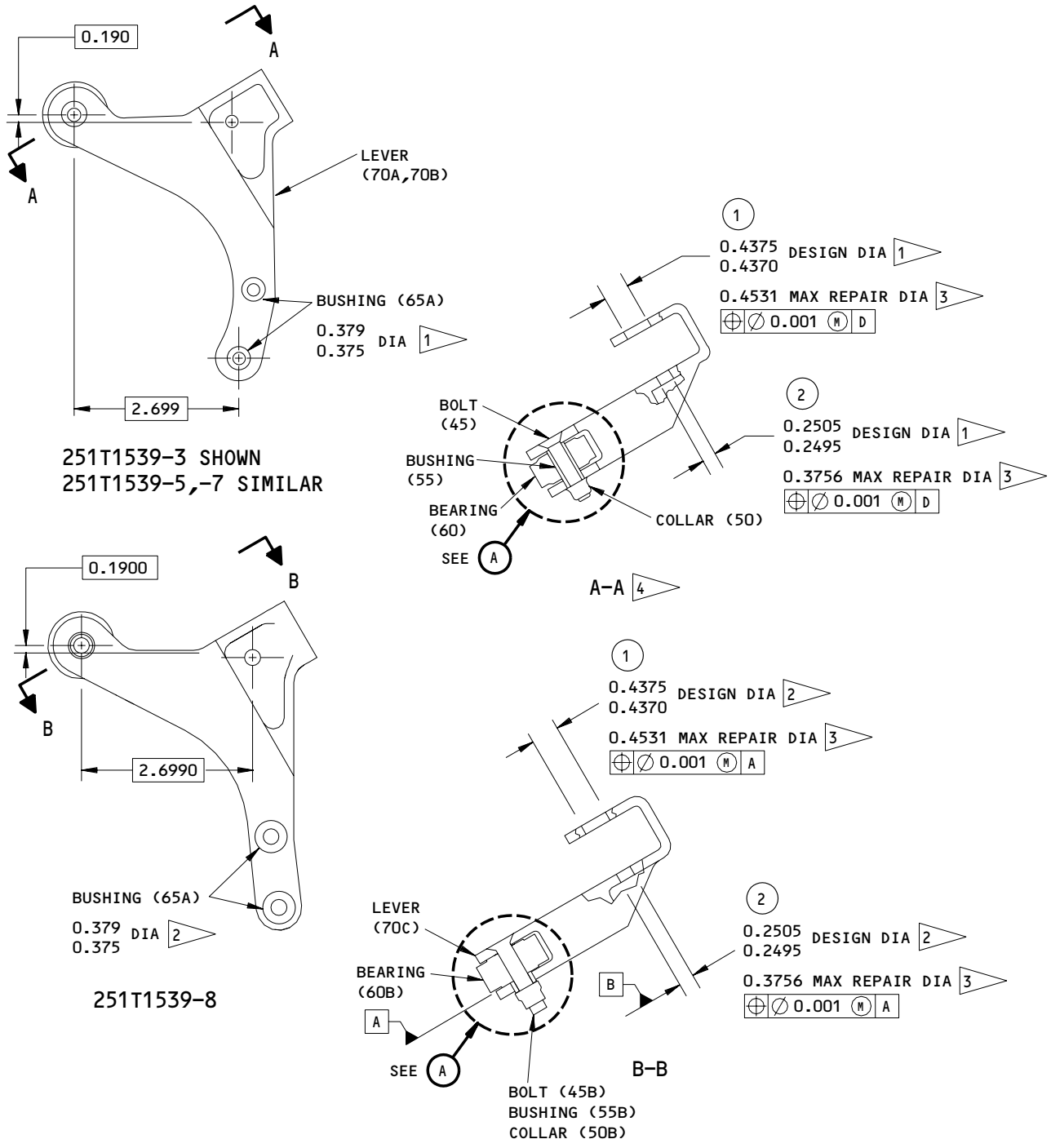
   B. Chemical treat (F-17.10) the machined surfaces.

   C. Manufacture an oversize bushing to replace bushing (35B, 37) (Fig. 601, Location 1) and/or a repair bushing for the bolt hole (Fig. 601, Location 2). Refer to Fig. 602.

      NOTE: If you repair the hole at Location 1, make an oversize plain bushing as shown, to replace either the flanged bushing (35B) or the plain bushing (37). The plain bushing, used with the washer (27) and nut (32) is the preferred configuration, to make sure that the bolt (25C) clamps the inner race of the bearing (115) without distorting the lever (70A). Refer to ASSEMBLY/701.

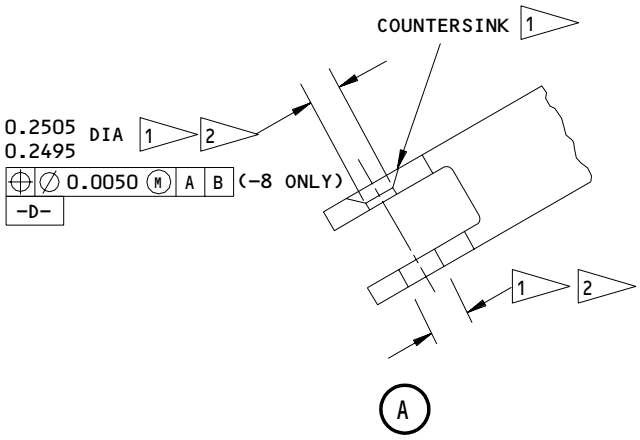
D. At Location 1, temporarily install the oversize bushing and attach a tag that states: "HOLE DIAMETER IS INCREASED: OVERSIZE PLAIN BUSHING MUST BE USED WITH WASHER AND NUT AT THIS LOCATION"

E. At Location 2, install the repair bushing with wet BMS 5-95 sealant, using the shrink-fit procedure as shown in SOPM 20-50-03. If necessary, machine the bushing ID to the design dimension.



251T1539-3,-5,-7,-8
Lever Assembly - Repair
Figure 601 (Sheet 1)

130890



REFINISH

LEVER (7OA,7OB) -- CHROMIC ACID ANODIZE AND APPLY BMS 10-11, TYPE 1 PRIMER (F-18.13) EXCEPT AS INDICATED BY 1.

LEVER (7OC) -- BORIC ACID-SULFURIC ACID ANODIZE (F-17.35). APPLY BMS 10-11, TYPE I PRIMER (F-20.02) AND BMS 10-60 ENAMEL (SRF-14.9813) EXCEPT AS INDICATED BY 2.

1 OMIT PRIMER FROM THIS SURFACE

2 OMIT PRIMER AND ENAMEL FROM THIS SURFACE

3 REPAIR LIMIT FOR INSTALLATION OF BUSHINGS

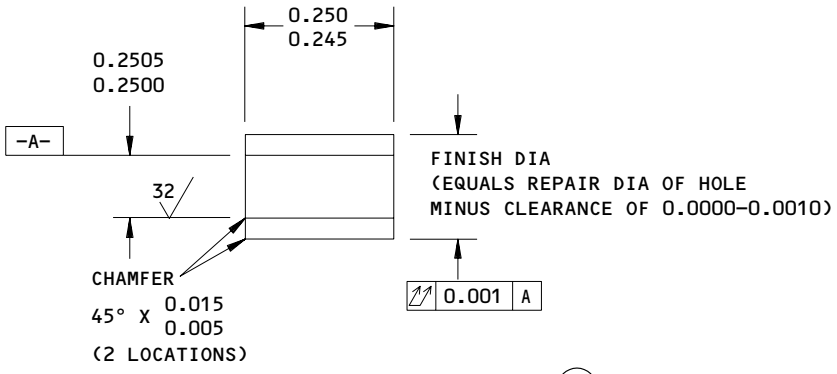
4 SEE VIEW B-B FOR 251T1539-7

MATERIAL: AL ALLOY

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

251T1539-3,-5,-7,-8
Lever Assembly - Repair
Figure 601 (Sheet 2)

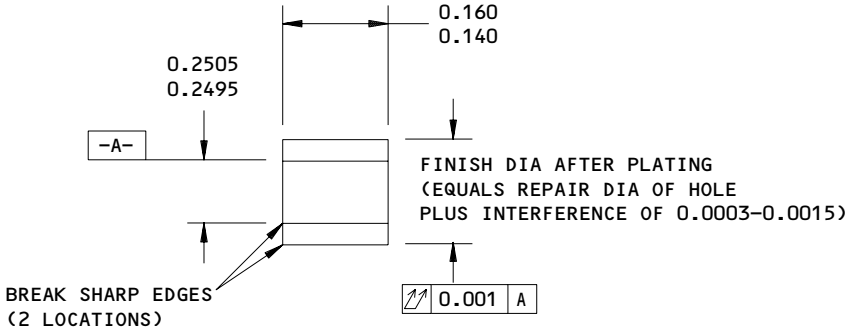


OVERSIZE BUSHING AT HOLE LOCATION (1) (FIGURE 601)

FINISH: NO FINISH (F-25.01)

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: 15-5PH OR 17-4PH CRES, 180-200 KSI



REPAIR BUSHING AT HOLE LOCATION (2) (FIGURE 601)

FINISH: CADMIUM PLATE 0.0003-0.0005 THICK AS SHOWN IN SOPM 20-42-05

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: AL-NI-BRONZE PER AMS 4880 OR AMS 4640

251T1539-3,-5,-7,-8
Repair Bushing Details
Figure 602

K25571

CARRIER ASSEMBLY - REPAIR 2-1

251T1521-1, -3, -5

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

1. Bearing Replacement (IPL Fig. 1)

   A. Remove the bearing (100) from the carrier (105) as shown in Fig. 601. Remove installation parts (900, 905) from the carrier.

   B. Install the replacement bearing (100) in the carrier (105) with BMS 5-95 sealant, and use the roller swage procedure as shown in SOPM 20-50-03.

   C. Apply a thin layer of BMS 3-24 grease to the spacer (905) and install it in the carrier. Install a new bearing (900) in the carrier per SOPM 20-50-03. Use a rod or bolt to keep the spacer aligned with the bearings until the override assembly is installed on the airplane.

2. Bolt Hole Repair (IPL Fig. 1)

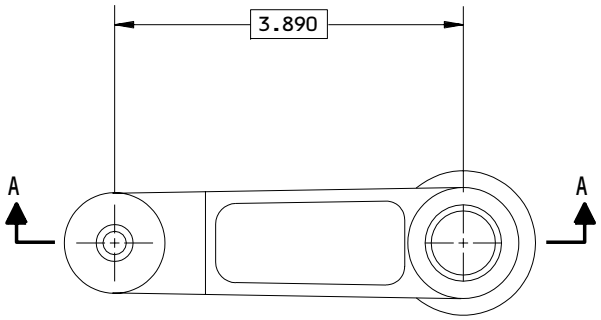
   A. Machine the bolt holes oversize as required to remove defects. At Location 2 (Fig. 601), machine the hole a minimum of 0.060 inch oversize to make sure that the wall thickness of the repair bushing is a minimum of 0.030 inch. Do not machine more than the limits shown.

   B. Chemical treat (F-17.10) the machined surfaces.

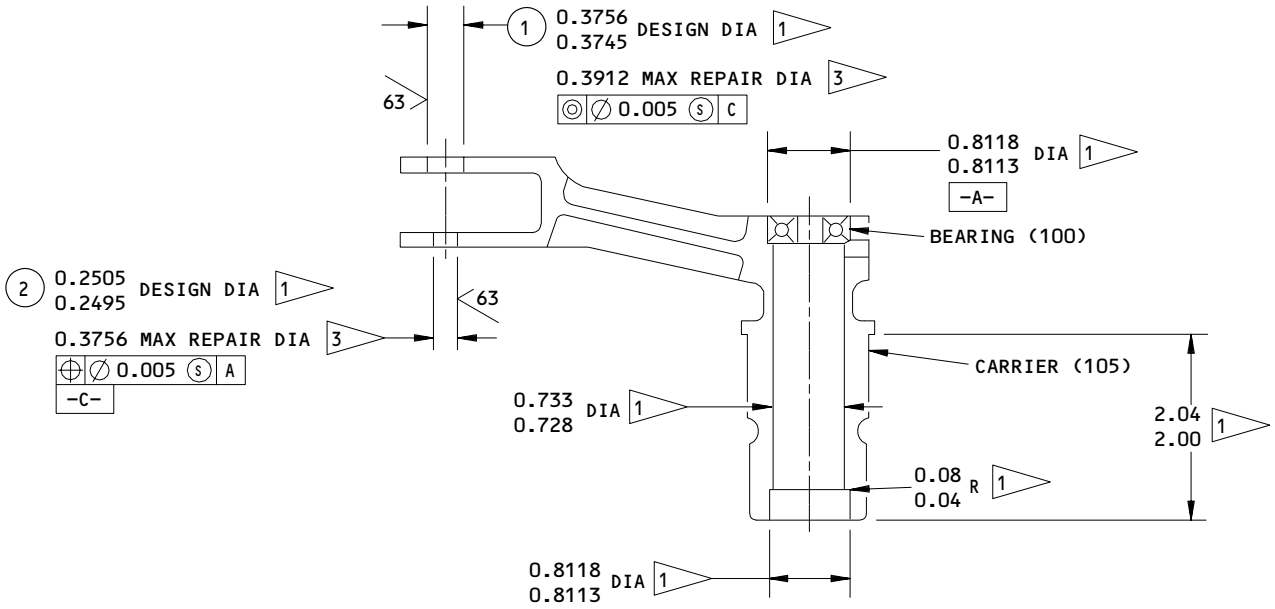
   C. Manufacture an oversize bushing to replace the BACB28AK04-025 or BACB28AK04-027 installation bushing (Fig. 601, Location 1) and/or a repair bushing for the bolt hole (Fig. 601, Location 2). Refer to Fig. 602.

   D. At Location 1, temporarily install the oversize bushing and attach a tag that states: "HOLE DIAMETER IS INCREASED: OVERSIZE BUSHING MUST BE USED AT THIS LOCATION"

E. At Location 2, install the repair bushing with wet BMS 5-95 sealant, using the shrink-fit procedure as shown in SOPM 20-50-03. If necessary, machine the bushing ID to the design dimension.



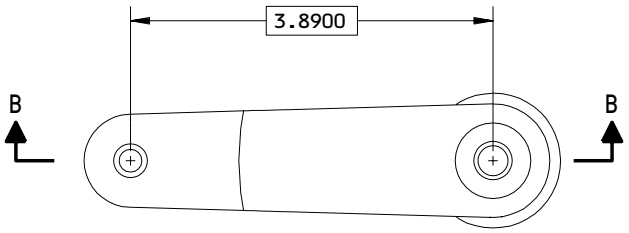
251T1521-1,-3



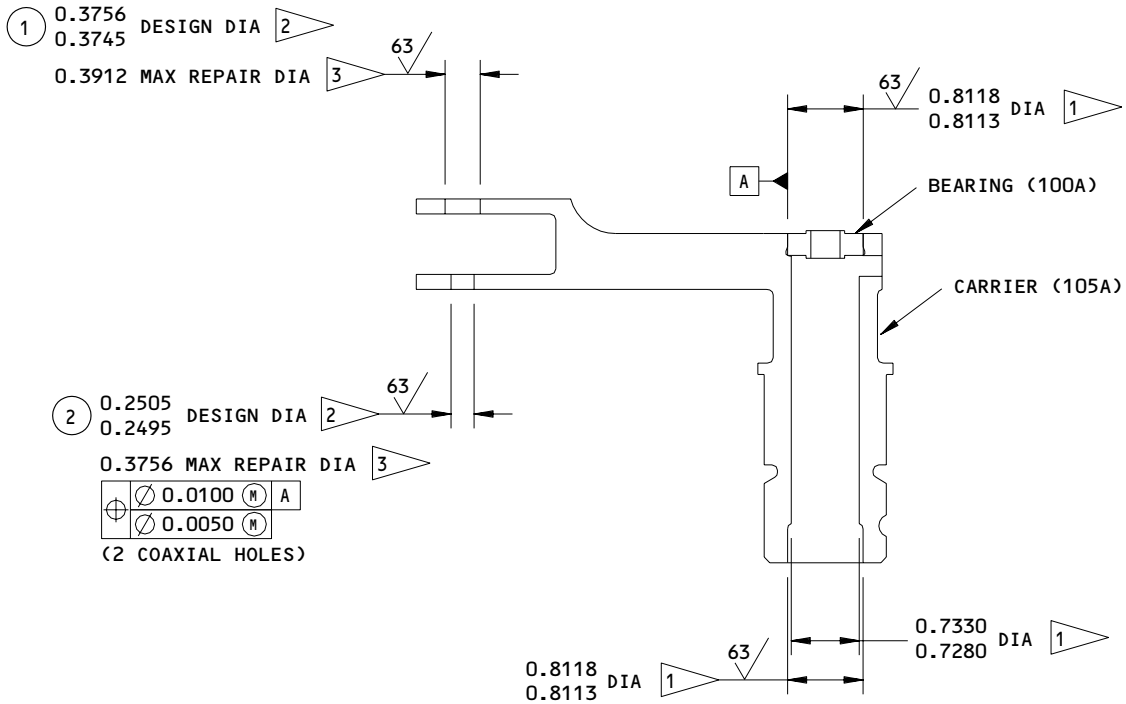
A-A

251T1521-1,-3,-5
Carrier Assembly - Repair
Figure 601 (Sheet 1)

13322



251T1521-5



B-B

REFINISH

CARRIER (105) -- CHROMIC ACID ANODIZE AND APPLY BMS 10-11, TYPE 1 PRIMER (F-18.13) ALL OVER EXCEPT AS INDICATED BY 1

CARRIER (105A) -- BORIC ACID-SULFURIC ACID ANODIZE (F-17.35). APPLY BMS 10-11, TYPE 1 PRIMER (F-20.02) AND BMS 10-60 ENAMEL (SRF-14.9813) ALL OVER EXCEPT AS INDICATED BY 2

1 OMIT PRIMER FROM THIS SURFACE

2 OMIT PRIMER AND ENAMEL FROM THIS SURFACE

3 REPAIR LIMIT FOR INSTALLATION OF BUSHINGS

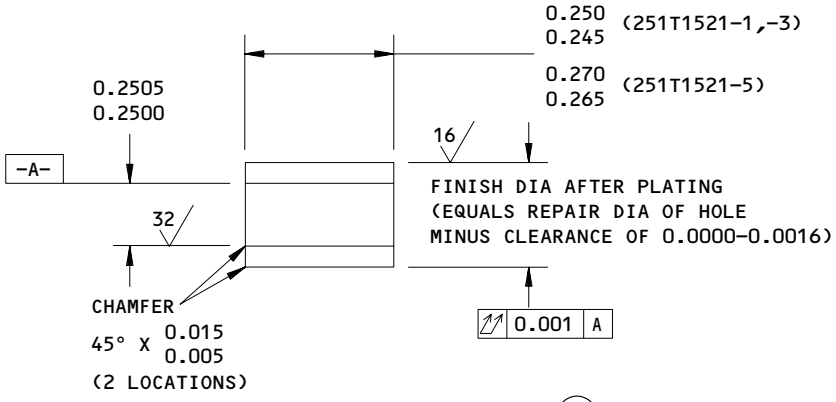
MATERIAL: AL ALLOY

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

251T1521-1,-3,-5
Carrier Assembly - Repair
Figure 601 (Sheet 2)

K25611

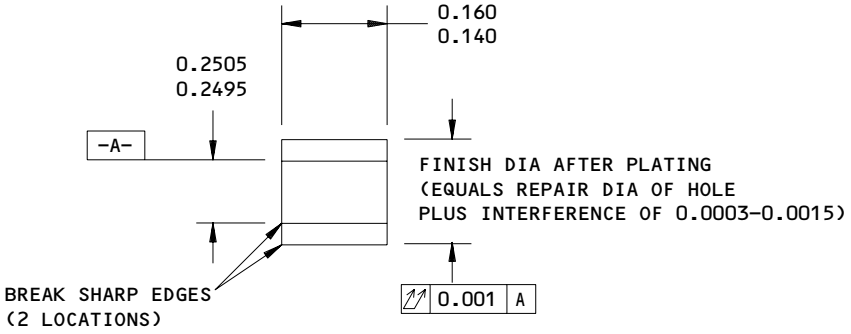


OVERSIZE BUSHING AT HOLE LOCATION (1) (FIGURE 601)

FINISH: CHROME PLATE 0.001-0.002 THICK ON OUTSIDE DIAMETER ONLY AS SHOWN IN SOPM 20-42-03

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: 15-5PH OR 17-4PH CRES, 180-200 KSI



REPAIR BUSHING AT HOLE LOCATION (2) (FIGURE 601)

FINISH: CADMIUM PLATE 0.0003-0.0005 THICK AS SHOWN IN SOPM 20-42-05

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: AL-NI-BRONZE PER AMS 4880 OR AMS 4640

251T1521-1,-3,-5
Repair Bushing Details
Figure 602

382943

QUADRANT ASSEMBLY - REPAIR 3-1

251T1515-4, -7, -9, -12, -13, -14

NOTE: Refer to REPAIR-GEN for list of applicable standard practices. For repair which may only require stripping and restoration of the original finish, refer to Refinish instructions, Fig. 601 and 602.

NOTE: Remove bearings (110,115) prior to working on quadrant assembly. Bearings (110,115) are installed with grease and are removed using shop hand tools.

1. Bearing Replacement (Fig. 601 and 602)

A. For assemblies 251T1515-4, -7, -12, -13, -14, remove bearings (130A, 135) from quadrant (140 or 140A) as shown in Fig. 601. Remove bearings by pressing out per SOPM 20-50-03. Make sure area around bearing is supported to prevent damage or deformation of the quadrant.

NOTE: Tooling ST918A, Mandrel - Bearing Pressing and ST919, Bearing Support can be used to assist in pressing out bearings. ST919 (Body, item 1) can be used to support the quadrant assembly when pressing out bearings. Use ST918A-1312-1750 and ST919-1750 for bearing 130A. Use ST918A-250-750 and ST919-750 for bearing 135.

B. Install new bearings (130A, 135) on quadrant (140 or 140A) with BMS 10-11, Type 1 primer by roller swage procedure as shown in SOPM 20-50-03.

C. For assembly 251T1515-9, remove bearings (130B, 135A) from quadrant (140B) as shown in Fig. 602. Remove bearings by pressing out per SOPM 20-50-03. Make sure area around bearing is supported to prevent damage or deformation of the quadrant.

NOTE: Tooling ST918A, Mandrel - Bearing Pressing and ST919, Bearing Support can be used to assist in pressing out bearings. ST919 (Body, item 1) can be usd to support the quadrant assembly when pressing out bearings. Use ST918A-1312-1750 and ST919-1750 for bearing 130B. Use ST918A-25-750 and ST919-750 for bearing 135A.

D.stall new bearings (130B, 135A) on quadrant (140B) with BMS 5-95 sealant by roller swage procedure as shown in SOPM 20-50-03.

2. Bearing Bore Repair (Fig. 603)

A. Machine the bore for the bearing (130A, 135) as shown, to remove damage. Machine the radius at the bottom and the chamfer at the opening, as shown.

B. Do a penetrant check of the reworked area. Refer to SOPM 20-20-02.

C. Chromic acid anodize (F-17.02) the reworked area.

D. Apply BMS 10-11, Type 1 primer (F-20.02) to the reworked area.

E. Make a repair sleeve as shown.

(1) Make the repair sleeve from 6061-T6 aluminum alloy.

(2) Break all sharp edges. Refer to BAC 5300.

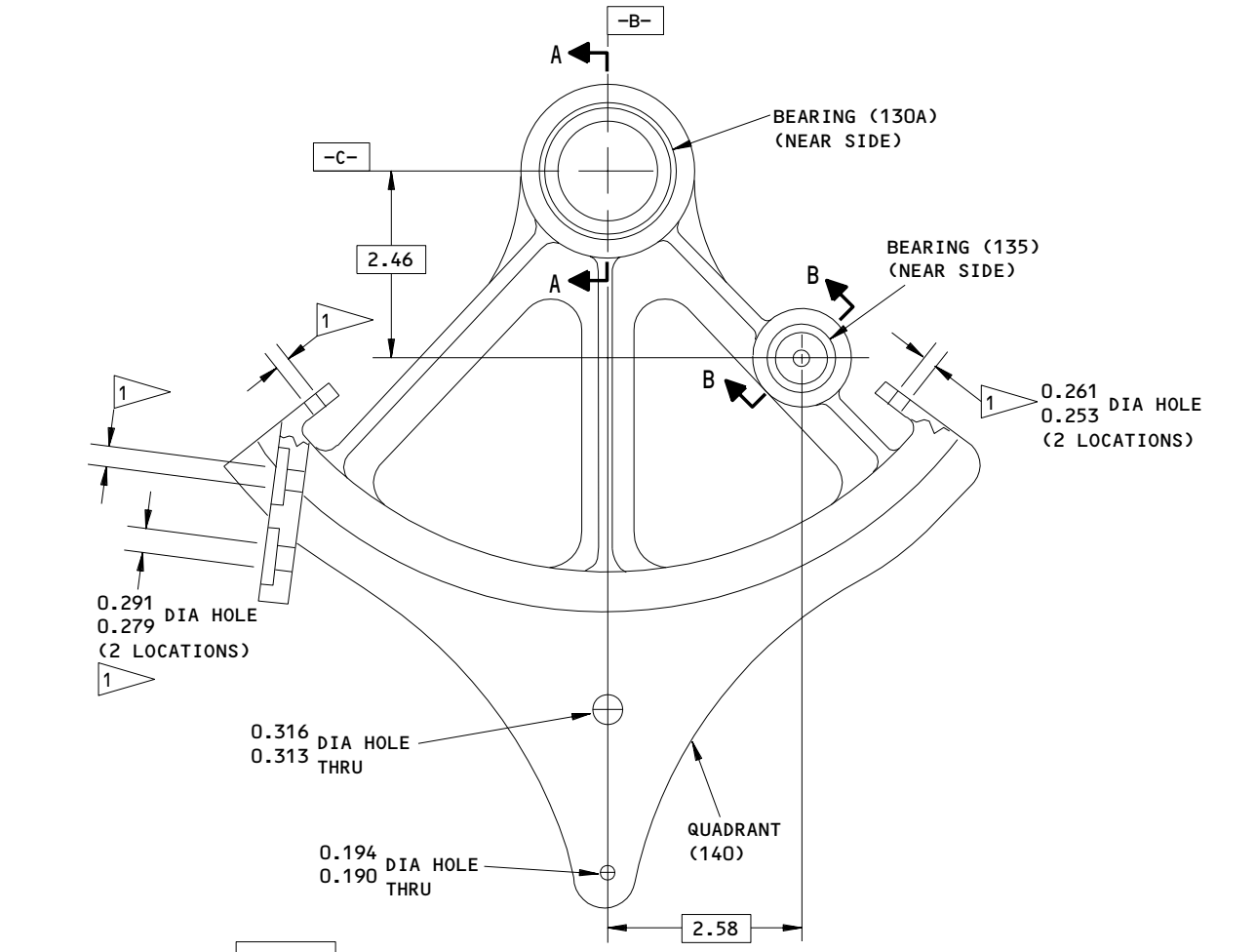
(3) Do a penetrant check of the repair sleeve. Refer to SOPM 20-20-02.

(4) Chromic acid anodize (F-17.02) the part.

F. Install the repair sleeve with BMS 5-95 sealant. Fill the split line with sealant also. Machine the sleeve surfaces if necessary.

G. Install the bearing (130A, 135) in the sleeve with BMS 5-95 sealant. Refer to SOPM 20-50-03.

H. Roller swage the sleeve over the bearing. Refer to SOPM 20-50-03.



A-A
(BEARING (130A) OMITTED FOR CLARITY)

B-B
(BEARING (135) OMITTED FOR CLARITY)

REFINISH

QUADRANT (140) -- CHROMIC ACID ANODIZE OR SULFURIC ACID ANODIZE (F-17.05) ALL OVER. APPLY BMS 10-11, TYPE 1 PRIMER (F-20.02) ALL OVER EXCEPT AS INDICATED BY 1.

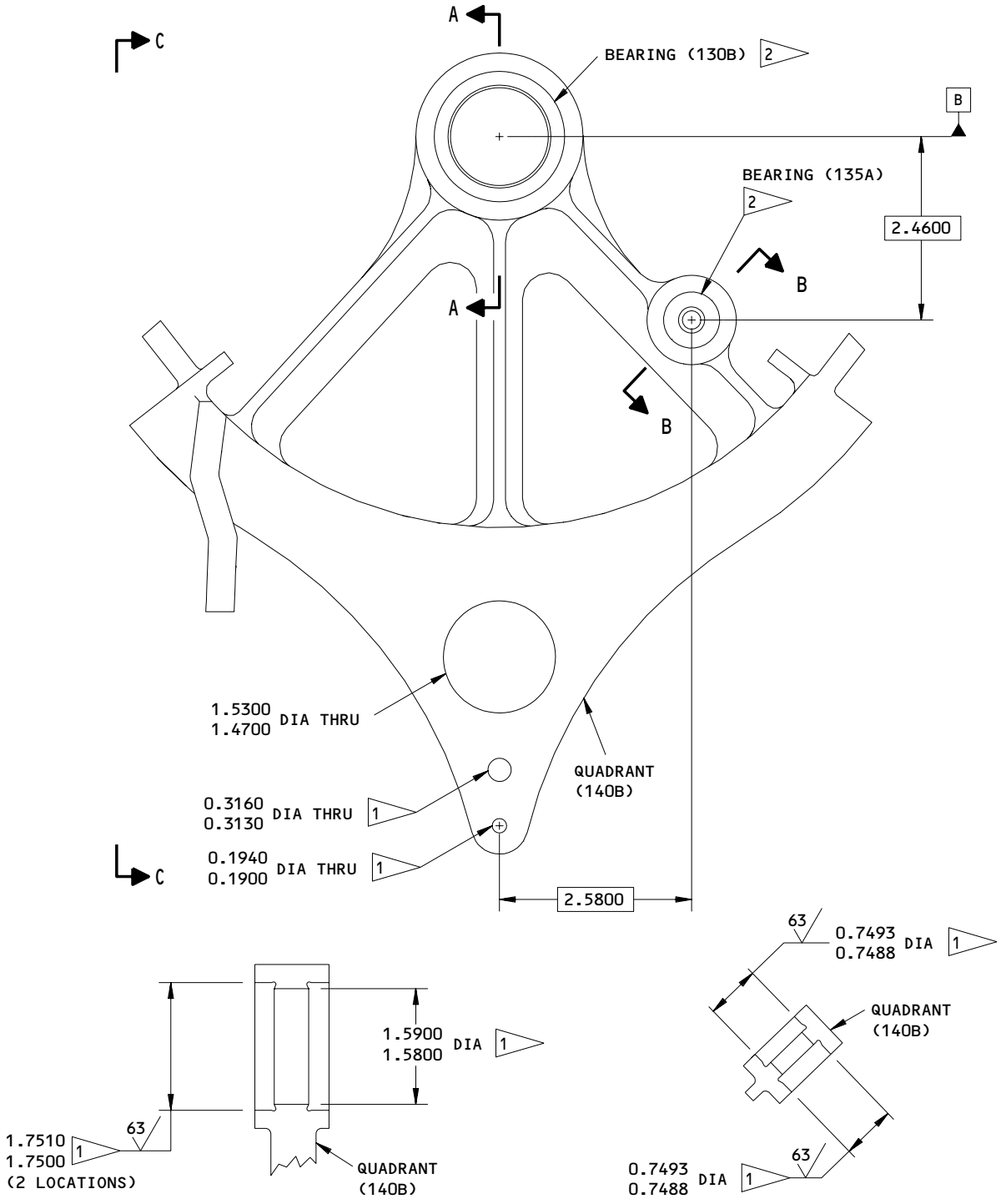
1 OMIT PRIMER FROM THIS SURFACE.

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

251T1515-4,-7,-12,-13,-14
Quadrant Assembly - Bearing Replacement
Figure 601

13325

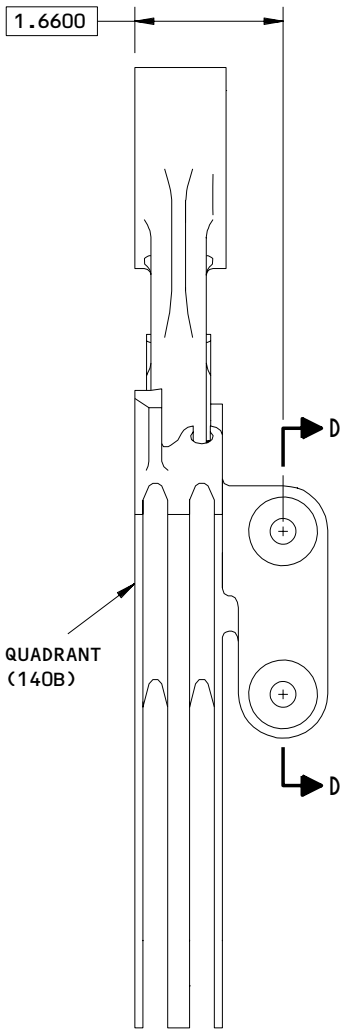


BEARING (130B) NOT SHOWN
A-A

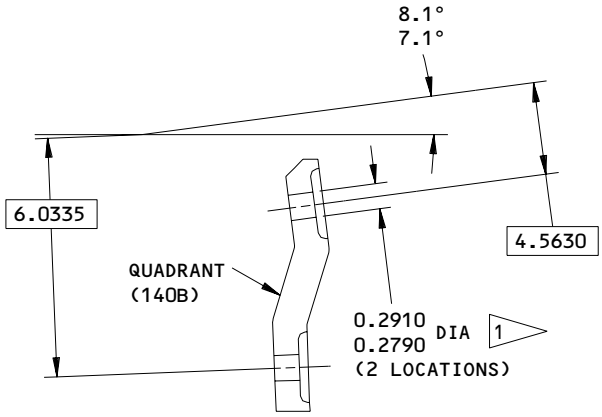
BEARING (135A) NOT SHOWN
B-B

251T1515-9
Quadrant Assy - Bearing Replacement
Figure 602 (Sheet 1)

K25663



C–C



D–D

REFINISH

QUADRANT (140B) -- 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

1 OMIT PRIMER AND ENAMEL FROM THIS SURFACE

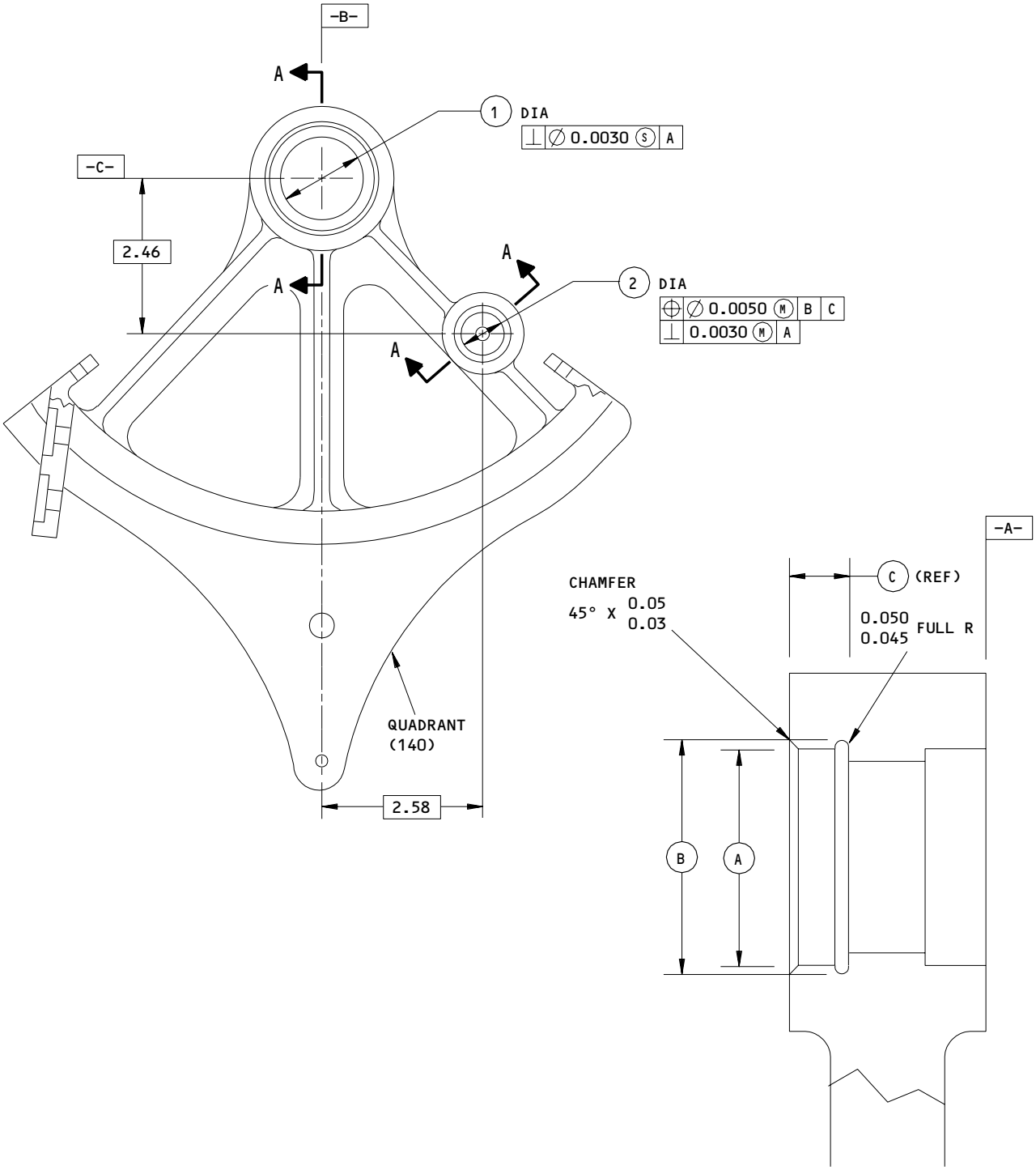
2 NEAR SIDE

MATERIAL: AL ALLOY

ITEM NUMBERS REFER TO IPL FIG. 1

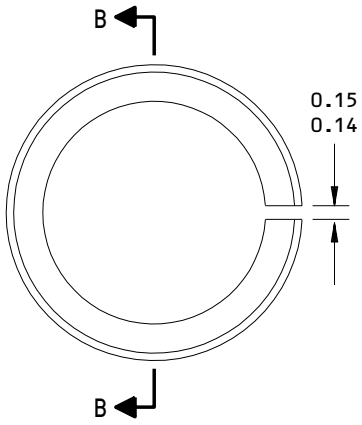
ALL DIMENSIONS ARE IN INCHES

251T1515–9
Quadrant Assy – Bearing Replacement
Figure 602 (Sheet 2)

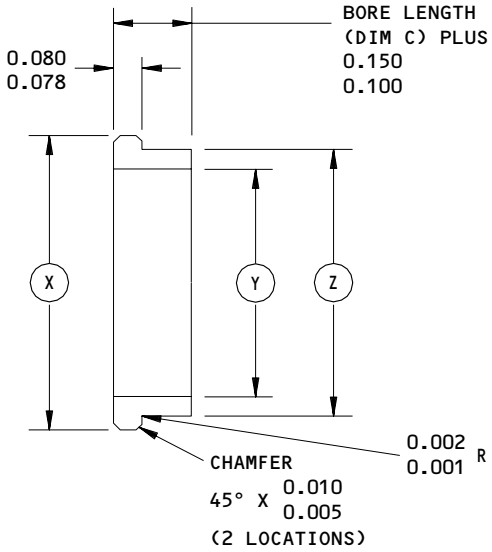


251T1515-4,-7,-9,-12,-13,-14
Bearing Bore Repair
Figure 603 (Sheet 1)

422759



REPAIR SLEEVE



B–B

DIAMETER LOCATION	BEARING (REF)	(A)	(B)	(C) (REF)
1	130A	1.811 1.810	1.901 1.899	0.265 0.250
2	135	0.810 0.809	0.899 0.897	0.234 0.219

TABLE 1
REWORK DIMENSIONS

DIAMETER LOCATION	(X)	(Y) 1	(Z)
1	1.854 1.852	1.7510 1.7500	1.810 1.808
2	0.853 0.851	0.7493 0.7488	0.809 0.807

TABLE 2
REPAIR SLEEVE DIMENSIONS

1 DESIGN DIAMETER OF THE BEARING BORE

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

FINISH: CHROMIC ACID ANODIZE (F-17.02)

MATERIAL: 6061-T6 ALUMINUM ALLOY

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

251T1515-4,-7,-9,-12,-13,-14
Bearing Bore Repair
Figure 603 (Sheet 2)

422764

MISC PARTS REFINISH - REPAIR 4-1

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

IPL FIG. & ITEM	MATERIAL	FINISH
Fig. 1		
Cam (75A)	15-5PH CRES, 150-170 ksi	Cadmium plate and apply one coat of BMS 10-11, type 1, primer all over (F-16.01) except no primer on splines or cam profile
Spring (20)	9254 Steel wire	Apply two coats BMS 10-11, type 1 primer (F-20.03), all over.
Bushing (35B)	4340 Steel 125-145 ksi	Cadmium plate (F-15.06) all over.

Refinish Details
Figure 601

ASSEMBLY

1. Materials

NOTE: Equivalent substitutes may be used.

A. Grease -- BMS 3-24 (Optional BMS 3-33) (Ref 20-60-03)

2. Assembly (IPL Fig. 1)

A. Install spacers (113, 120) and bearings (110, 115) on quadrant assembly (125). Install bearings with grease.

B. Install pin (123), washer (122A) and cotter pin (121A) on quadrant assembly (125).

C. Coat faying surfaces and bolt cutout of carrier assembly (95), splines of cam (75A), threads of bolt (80), nut (90) and faces of washer (85A) with grease. Install carrier assembly (95) on quadrant assembly (125) and assemble cam (75A) on carrier assembly with matching bolt cutout. Install fasteners (80, 85A, 90).

D. Apply a layer of grease to the threads and shank of the bolt (25C). Put the lever assembly (40A) on the quadrant assembly (125) and install the fasteners as follows.

(1) On assemblies 251T1505-2 thru -8, and -12 thru -17, install the flanged bushing (35B), bolt (25C or 25D), and nut (30A or 30B), or optionally, install the plain bushing (37A), bolt (25F), washer (27A), and nut (30A or 30B).

NOTE: The preferred configuration is the plain bushing, used with the longer bolt and the washer, to make sure that the bolt clamps the inner race of the bearing (115) without distorting the lever.

(2) On assemblies 251T1505-9, -10, -19, and -20, install the plain bushing (37), bolt (25E), washer (27), and nut (32).

E. Apply a layer of grease to the outer race of the bearing (60), the holes in the eyebolts (5), the ID of the bushings (65A), and the hooks of the springs (20).

WARNING: USE EXTREME CARE WHEN INSTALLING EYEBOLT (5). SPRINGS (20) ARE HEAVILY LOADED AFTER INSTALLATION.

F. Install a spring (20) on the inner bushing (65A) and eyebolt (5), then install the eyebolt in the inner hole of the quadrant assembly (125) with the nut (15B). Adjust the spring tension to get a detent breakout torque of 105-115 lb-in.

NOTE: The breakout torque is measured on the carrier assembly (95) with the quadrant assembly (125) secured. Breakout occurs when a 0.002 inch to 0.004 inch shim can be installed between the cam (75A) and the roller (60) on the unloaded side.

G. Measure the gap between the shoulder of the inner eyebolt and the quadrant assembly and fill the gap with washers (10A).

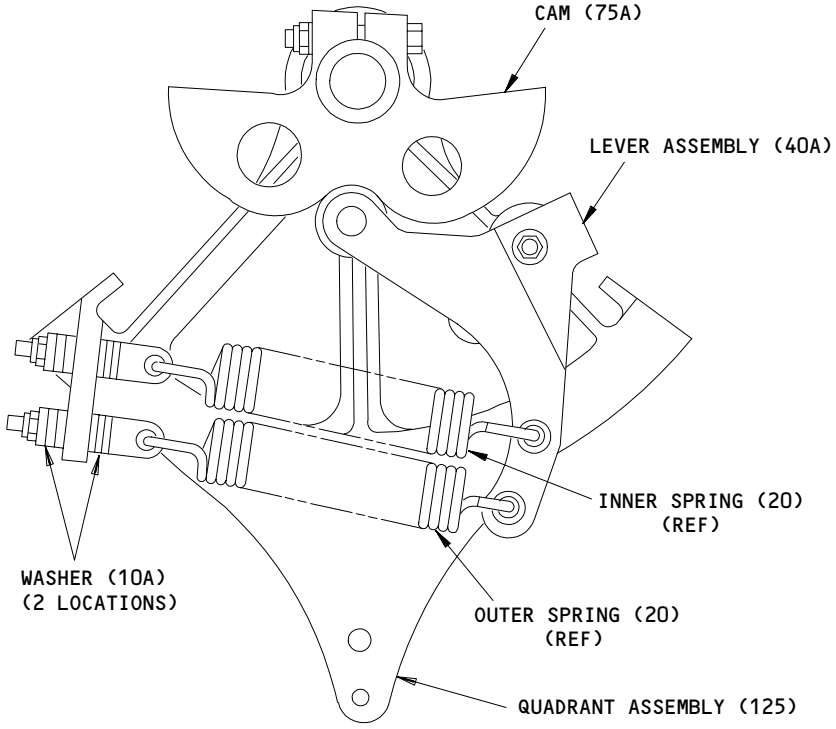
H. Install a spring (20) on the outer bushing (65A) and eyebolt (5), then install the eyebolt in the outer hole of the quadrant assembly (125) with the nut (15B). Adjust the spring tension to get a detent breakout torque of 195-205 lb-in.

NOTE: The breakout torque is measured on the carrier assembly (95) the quadrant assembly (125) secured. Breakout occurs when a 0.002 inch to 0.004 inch shim can be installed between the cam (75A) and the roller (60) on the unloaded side.

I. Measure the gap between the shoulder of the outer eyebolt and the quadrant assembly and fill the gap with washers (10A).

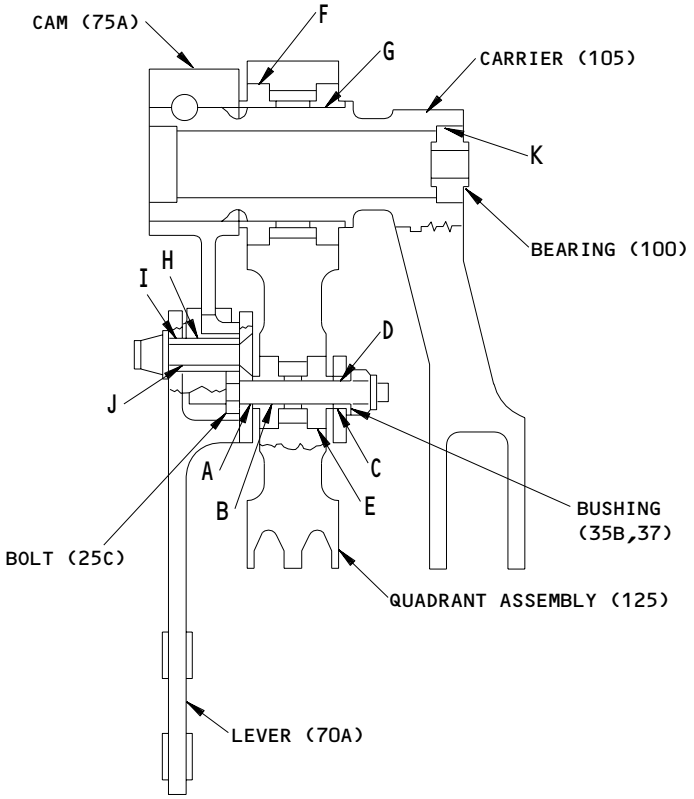
3. Storage

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



Assembly Details
Figure 701

13327



Fits and Clearances
Figure 801 (Sheet 1)

Ref Letter Fig.801	Mating Item No. IPL Fig.	Design Dimension				Service Wear Limit		
		Dimension		Assembly Clearance 1		Dimension		Maximum Clearance
		Min	Max	Min	Max	Min	Max	
A	ID 70A OD 25C	0.2495 0.2485	0.2505 0.2495	0.0000	0.0020	0.2465	0.2535	0.0040
B	ID 115,135 OD 25C	0.2497 0.2485	0.2500 0.2495	0.0002	0.0015	0.2465	0.2530	0.0035
C	ID 70A OD 35B,37	0.4370 0.4365	0.4375 0.4370	0.0000	0.0010	0.4345	0.4400	0.0030
D	ID 35B,37 OD 25C	0.2500 0.2485	0.2505 0.2495	0.0005	0.0020	0.2465	0.2535	0.004
E	ID 140 OD 135,115	0.7488 0.7496	0.7493 0.7500	-0.0012	-0.0003			
F	ID 140 OD 110,130A	1.7500 1.7490	1.7510 1.7500	0.0000	0.0020	1.747	1.754	0.0040
G	ID 110,130A OD 105	1.3118 1.3110	1.3132 1.3120	-0.0002	0.0022	1.3090	1.3162	0.0042
H	ID 60 OD 55	0.3743 0.3756	0.3750 0.3761	-0.0018	-0.0006			
H	ID 60 OD 55A	0.3743 0.3740	0.3750 0.3745	-0.0002	0.0010			
I	ID 70A OD 55	0.3765 0.3756	0.3775 0.3761	0.0004	0.0019			
I	ID 70B,70C OD 55A,55B, 55C	0.3750 0.3740	0.3760 0.3745	0.0005	0.0020			

Fits and Clearances
Figure 801 (Sheet 2)

30434

Ref Letter Fig.801	Mating Item No. IPL Fig.	Design Dimension				Service Wear Limit		
		Dimension		Assembly Clearance 1		Dimension		Maximum Clearance
		Min	Max	Min	Max	Min	Max	
J	ID 55 OD 45	0.2500 0.2485	0.2515 0.2495	0.0005	0.0030			
J	ID 55A,55B, 55C OD 45A,45B, 45C	0.2500 0.2485	0.2505 0.2495	0.0005	0.0020			
K	ID 105 OD 100	0.8113 0.8121	0.8118 0.8125	-0.0012	-0.0003	0.8118	0.8125	0.0000

* ALL DIMENSIONS ARE IN INCHES

1 NEGATIVE VALUE IS FOR AN INTERFERENCE FIT

Fits and Clearances
Figure 801 (Sheet 3)

370434

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

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

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

07484 ACCURATE BUSHING CO INC
443 NORTH AVENUE
GARWOOD, NEW JERSEY 07027-1014
FORMERLY V83132 SMITH BRG DIV OF ACCURATE BUSHING CO

08524 DEUTSCH FASTENER CORP SEE CODE V97928

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

VENDORS

17446 HUCK INTL INC AEROSPACE FASTENER DIV
900 WATSON CENTER ROAD
CARSON, CALIFORNIA 90745-4201
FORMERLY V32134 REXNORD INC; FORMERLY V97928 HUCK INTL

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

VENDORS

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

50294 NEW HAMPSHIRE BALL BEARINGS, INC PRECISION DIVISION
9700 INDEPENDENCE AVENUE
CHATSWORTH, CALIFORNIA 91311
FORMERLY NIPPON MINATURE BEARING CORP V23589 AND NMB AMERICA INC AND NMB INC

50632 KAMATICS CORP SUB OF KAMAN CORP
1335 BLUE HILLS ROAD
BLOOMFIELD, CONNECTICUT 06002-1304

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

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

60380 TORRINGTON CO BEARINGS DIV SUBSIDIARY OF INGERSOLL-RAND CORP
59 FIELD STREET PO BOX 1008
TORRINGTON, CONNECTICUT 06790-1008
FORMERLY TORRINGTON BEARING COMPANY

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

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

VENDORS

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

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

9N513 VOI SHAN/CHATSWORTH DIV OF VSI CORP SUB OF FAIRCHILD IND
CHATSWORTH, CALIFORNIA 91311-5013
COMPANY NO LONGER WISHES TO BE CONSIDERED FOR FED CONTRCTG

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

92563 MCGILL MFG CO INC BEARINGS DIV
909 LAFAYETTE STREET
VALPARAISO, INDIANA 46383-4210

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

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
AAMK5RAP		1	100A	1
		1	100B	1
		1	900B	1
ACMB542DDP818LY		1	110B	1
		1	130B	1
ACMKP04AP510LY1		1	135A	1
ACMKP04RJAP510L		1	115C	1
		1	135D	1
ACMKP3AFS428		1	135B	1
ACMKP4AA3908		1	115A	1
ACMKP4AFS428		1	115A	1
ACMKP5AA3908		1	100A	1
		1	900B	1
ACMKP5AFS428		1	100A	1
		1	900B	1
ACMKP5AP26LY198		1	100A	1
		1	900B	1
AMB542DDNJC		1	110C	1
		1	130C	1
AMCS24EG7A		1	115A	1
AN43B14		1	5	2
ATF6		1	60	1
BACB10AP4		1	115	1
		1	135	1
BACB10AP5		1	100	1
BACB10AP5		1	900	1
BACB10CF21PP		1	110	1
		1	130A	1
BACB10ET06		1	60	1
BACB10FS04		1	135A	1
BACB10FS04J		1	135B	1
BACB10FS04RJ		1	115C	1
		1	135D	1
BACB10FS05R		1	900D	1
BACB10FS4R		1	115A	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACB10FS5R		1	100A	1
		1	900B	1
BACB10FS5RJ		1	100C	1
BACB10FU21		1	110B	1
		1	130B	1
BACB10FU21J		1	110C	1
		1	130C	1
BACB28BA0407025		1	37	1
BACB28B4-265P		1	65A	2
BACB30ND8-13		1	45	1
BACB30ND8-14		1	45A	1
BACB30NF4-17		1	25C	1
BACB30NR4K17		1	25D	1
BACB30NR4K18		1	25E	1
BACB30NY8K14		1	45B	1
BACC30BH8		1	50B	1
BACC30M8		1	50	1
BACC30X8		1	50A	1
BACN10JC4CD		1	30A	1
BACN10JC4CM		1	15C	2
BACN10JC4CM		1	90	1
BACN10YR4CD		1	15B	2
		1	30B	1
		1	32	1
		1	90A	1
BACP18BC02C06P		1	121A	1
BACP18BD2C35		1	123A	1
BRH10C4D		1	30A	1
BRH10C4M		1	15C	2
		1	90	1
B542-2TS		1	110	1
		1	130A	1
B542DD		1	110	1
		1	130A	1
B542DDFS101		1	110	1
		1	130A	1

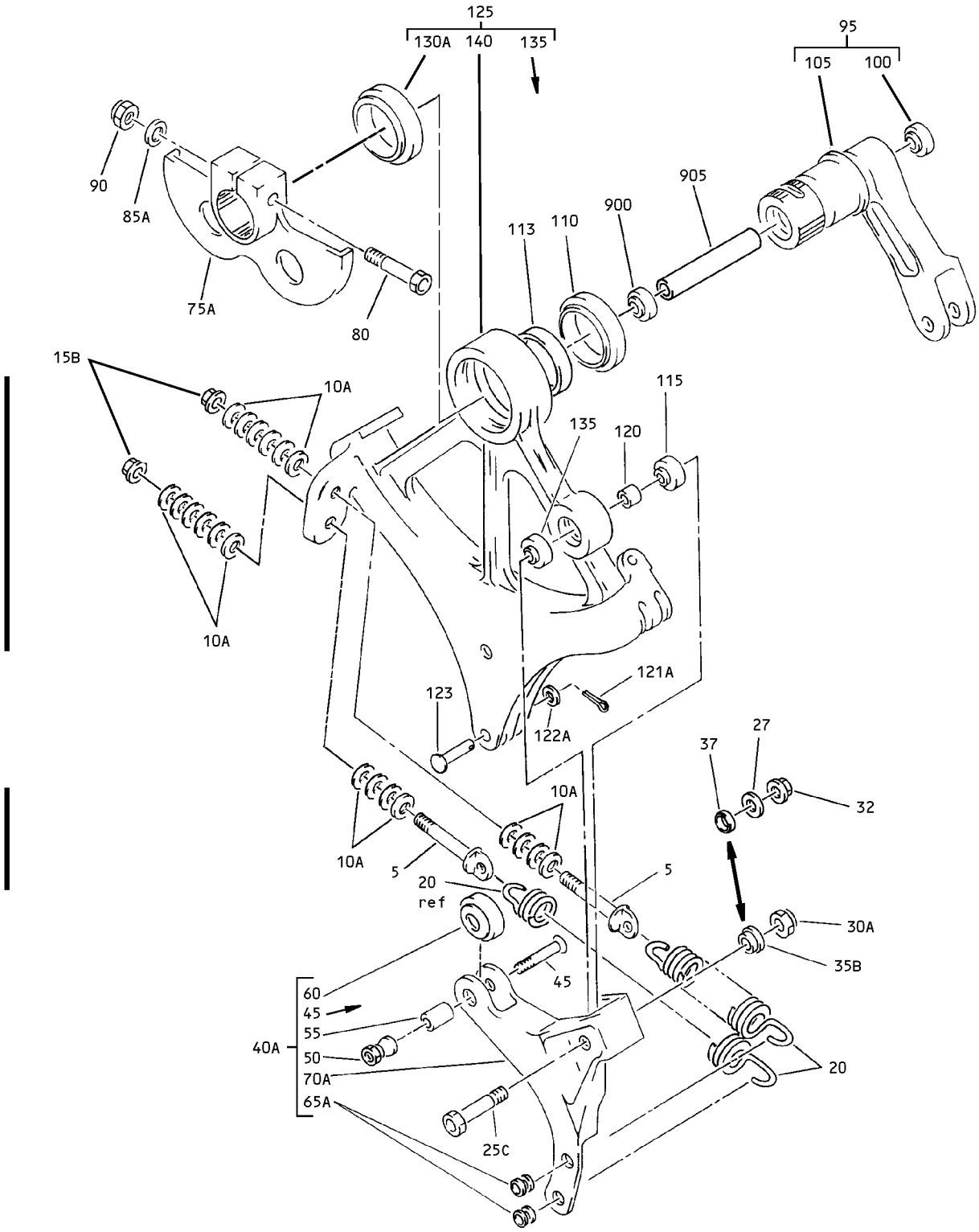
PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
B542DDFS428		1	110	1
		1	130A	1
B542DDNJC		1	110	1
		1	130A	1
B542DDP		1	110	1
		1	130A	1
B542FS101		1	110	1
		1	130A	1
B542SSG27		1	110	1
		1	130A	1
HL1087-8		1	50B	1
HL13VAZ8-14		1	45B	1
HL13V14		1	45B	1
HL525-8-13		1	45	1
HL525-8-14		1	45A	1
HL79-8		1	50	1
HL87-8		1	50A	1
HO1-4BAC		1	15C	2
		1	90	1
H51650-4BAC		1	30A	1
H52732-4CD		1	15B	2
		1	30B	1
		1	32	1
		1	90A	1
KRP173406FT		1	60A	1
LLMKP4A		1	115	1
		1	135	1
LLMKP5A		1	100	1
		1	900	1
L801-8K14		1	45B	1
MCS204E		1	115	1
		1	135	1
MCS24E		1	115	1
		1	135	1
MCS25E		1	100	1
		1	900	1
MKP4A		1	115	1
		1	135	1
MKP4AFS428		1	115	1
		1	135	1
MKP4AG20		1	115	1
		1	135	1
MKP4ALY196		1	115	1
		1	135	1
MKP4ANJC		1	115	1
		1	135	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
MKP4ASD610		1	115	1
		1	135	1
MKP4ATT		1	115	1
		1	135	1
MKP4A2TS		1	115	1
		1	135	1
MKP4E6531		1	115	1
		1	135	1
MKP5A		1	100	1
MKP5A		1	900	1
MKP5AFS428		1	100	1
		1	900	1
MKP5AG20		1	100	1
		1	900	1
MKP5ALY196		1	100	1
		1	900	1
MKP5ANJC		1	100	1
		1	900	1
MKP5ASD610		1	100	1
		1	900	1
MKP5ATT		1	100	1
		1	900	1
MKP5A2TS		1	100	1
		1	900	1
MKP5E6531		1	100	1
		1	900	1
MS20392-2C35		1	123	1
NAS1149C0463R		1	85A	1
NAS1149D0363J		1	122A	1
NAS1149D0463J		1	10A	20
		1	27	1
NAS43DD4-13		1	120	1
NAS43DD5-173		1	905A	1
NAS43DD5-173FC		1	905	1
NAS43DD5-189FC		1	905B	1
NAS6704-24		1	80	1
NAS75-4-022		1	55	1
NS202101SE048		1	15C	2
NS202486-048		1	30A	1
PACMB542DDA3908		1	110B	1
		1	130B	1
PACMB542DDFS428		1	110B	1
		1	130B	1
PACMKP04AA3908		1	135A	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
PACMKP04RJAA390		1	115C	1
		1	135D	1
PACMKP04RJAFS42		1	115C	1
		1	135D	1
PACMKP4AA3908		1	115A	1
PLH54CD		1	15B	2
		1	30B	1
		1	32	1
		1	90A	1
SMCS25EG7A		1	100A	1
		1	900B	1
SSMB542DDSD624		1	110C	1
		1	130C	1
SSMB542DDSD705		1	110B	1
		1	130B	1
SSMKP04AP		1	135A	1
SSMKP04RJAP		1	115C	1
		1	135D	1
SSMKP04RJASD705		1	115C	1
		1	135D	1
SSMKP4ASD524		1	135B	1
SSMKP4ASD529		1	115C	1
		1	135D	1
SSMKP5ASD706		1	100A	1
		1	900B	1
SSMK4RAP		1	115A	1
T342E		1	110	1
		1	130A	1
T6C428JCD		1	30A	1
T6C428JM		1	15C	2
		1	90	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
VN303D048		1	15C	2
		1	90	1
YAF06B		1	60	1
102LH9075-4W		1	30A	1
109LH9075-4W		1	15C	2
		1	90	1
251T1505-10		1	1J	RF
251T1505-12		1	1L	RF
251T1505-13		1	1M	RF
251T1505-14		1	1N	RF
251T1505-15		1	1P	RF
251T1505-16		1	1Q	RF
251T1505-17		1	1R	RF
251T1505-19		1	1S	RF
251T1505-2		1	1A	RF
251T1505-20		1	1K	RF
251T1505-3		1	1B	RF
251T1505-4		1	1C	RF
251T1505-5		1	1D	RF
251T1505-6		1	1E	RF
251T1505-7		1	1F	RF
251T1505-8		1	1G	RF
251T1505-9		1	1H	RF
251T1515-10		1	140B	1
251T1515-12		1	125D	1
251T1515-13		1	125E	1
251T1515-14		1	125C	1
251T1515-4		1	125	1
251T1515-5		1	140	1
251T1515-7		1	125A	1
251T1515-8		1	140A	1
251T1515-9		1	125B	1
251T1521-1		1	95	1
251T1521-2		1	105	1
251T1521-3		1	95A	1
251T1521-4		1	105A	1
251T1521-5		1	95B	1
251T1522-2		1	75A	1
251T1522-3		1	75B	1
251T1522-4		1	75C	1
251T1536-1		1	20	2
251T1536-2		1	20A	2
251T1539-3		1	40A	1
251T1539-4		1	70A	1
251T1539-5		1	40B	1
251T1539-6		1	70B	1
251T1539-7		1	40C	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
251T1539-8		1	40F	1
251T1539-9		1	70C	1
251T1582-1		1	113	1
251T3741-37		1	55A	1
251T3742-21		1	35B	1
251T3743-1		1	55B	1
6AFC817		1	60	1
66014-8		1	50	1
69309-8-13		1	45	1
69309-8-14		1	45A	1
9NS202101SE048		1	90	1
97E48		1	15C	2
		1	90	1



Aileron Control Quadrant Override Assembly
Figure 1

T55328

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-1A	251T1505-2		OVERRIDE ASSY-AIL. CONT QUADRANT (PRE SB 767-27A0175)	A	RF
-1B	251T1505-3		OVERRIDE ASSY-AIL. CONT QUADRANT (PRE SB 767-27A0175)	B	RF
-1C	251T1505-4		OVERRIDE ASSY-AIL. CONT QUADRANT (PRE SB 767-27A0175)	C	RF
-1D	251T1505-5		OVERRIDE ASSY-AIL. CONT QUADRANT (PRE SB 767-27A0175)	D	RF
-1E	251T1505-6		OVERRIDE ASSY-AIL. CONT QUADRANT (PRE SB 767-27A0175)	E	RF
-1F	251T1505-7		OVERRIDE ASSY-AIL. CONT QUADRANT (PRE SB 767-27A0175)	F	RF
-1G	251T1505-8		OVERRIDE ASSY-AIL. CONT QUADRANT	G	RF
-1H	251T1505-9		OVERRIDE ASSY-AIL. CONT QUADRANT	H	RF
-1J	251T1505-10		OVERRIDE ASSY-AIL. CONT QUADRANT	J	RF
-1K	251T1505-20		OVERRIDE ASSY-AIL. CONT QUADRANT	K	RF
-1L	251T1505-12		OVERRIDE ASSY-AIL. CONT QUADRANT (REWORK) (POST SB 767-27A0175)	L	RF
-1M	251T1505-13		OVERRIDE ASSY-AIL. CONT QUADRANT (REWORK) (POST SB 767-27A0175)	M	RF
-1N	251T1505-14		OVERRIDE ASSY-AIL. CONT QUADRANT (REWORK) (POST SB 767-27A0175)	N	RF
-1P	251T1505-15		OVERRIDE ASSY-AIL. CONT QUADRANT (REWORK) (POST SB 767-27A0175)	P	RF
-1Q	251T1505-16		OVERRIDE ASSY-AIL. CONT QUADRANT (REWORK) (POST SB 767-27A0175)	Q	RF
-1R	251T1505-17		OVERRIDE ASSY-AIL. CONT QUADRANT (REWORK) (POST SB 767-27A0175)	R	RF

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	-1S	251T1505-19		OVERRIDE ASSY-AIL. CONT QUADRANT (REWORK)	S	RF
	5	AN43B14		.EYEBOLT		2
	10	AN960PD416		DELETED		
R	10A	NAS1149D0463J		.WASHER		AR
	15	BACN10JC4		DELETED		
	-15A	BACN10JC4CD		DELETED		
	15B	H52732-4CD		.NUT- (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))	A-F, H-S	2
	-15C	BRH10C4M		.NUT- (V52828) (SPEC BACN10JC4CM) (OPT T6C428JM (V11815)) (OPT 97E48 (V80539)) (OPT 109LH9075-4W (V72962)) (OPT VN303D048 (V92215)) (OPT H01-4BAC (V15653)) (OPT NS202101SE048 (V80539))	G	2
	16	BRH10C4M		DELETED		
	17	NAS1149D0463J		DELETED		
	20	251T1536-1		.SPRING (OPT ITEM 20B)	A-E, L-Q	2
	-20A	251T1536-2		.SPRING	F-K,R ,S	2
	-20B	251T1536-2		.SPRING (OPT ITEM 20)	A-E, L-Q	2

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
25	BACB30NF4-15		DELETED		
25A	BACB30NF4-20		DELETED		
25B	BACB30NF4-19		DELETED		
25C	BACB30NF4-17		.BOLT (ITEM 25C OR ITEM 25D USED WITH ITEM 35B OPT TO ITEM 25F USED WITH ITEM 27A AND ITEM 37A)	A-D, L-P	1
-25D	BACB30NR4K17		.BOLT (ITEM 25C OR ITEM 25D USED WITH ITEM 35B OPT TO ITEM 25F USED WITH ITEM 27A AND ITEM 37A)	E-G,Q ,R	1
-25E	BACB30NR4K18		.BOLT	H-K,S	1
-25F	BACB30NR4K18		.BOLT (ITEM 25C OR ITEM 25D USED WITH ITEM 35B OPT TO ITEM 25F USED WITH ITEM 27A AND ITEM 37A)	A-G, L-R	1
27	NAS1149D0463J		.WASHER	H-K,S	1
-27A	NAS1149D0463J		.WASHER (ITEM 25C OR ITEM 25D USED WITH ITEM 35B OPT TO ITEM 25F USED WITH ITEM 27A AND ITEM 37A)	A-G L-R	1
30	BACN10JC4		DELETED		
30A	BRH10C4D		.NUT- (V52828) (SPEC BACN10JC4CD) (OPT T6C428JCD (V11815)) (OPT NS202486-048 (V80539)) (OPT 102LH9075-4W (V72962)) (OPT H51650-4BAC (V15653))	G	1
-30B	PLH54CD		.NUT- (V62554) (SPEC BACN10YR4CD) (OPT H52732-4CD (V15653))	A-F, L-R	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
32	H52732-4CD		.NUT- (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))	H-K,S	1
35	251T3742-1		DELETED		
35A	251T3742-4		DELETED		
35B	251T3742-21		.BUSHING-FLANGED (ITEM 25C OR ITEM 25D USED WITH ITEM 35B OPT TO ITEM 25F USED WITH ITEM 27A AND ITEM 37A)	A-G, L-R	1
37	BACB28BA0407025		.BUSHING-PLAIN	H-K,S	1
-37A	BACB28BA0407025		.BUSHING-PLAIN (ITEM 25C OR ITEM 25D USED WITH ITEM 35B OPT TO ITEM 25F USED WITH ITEM 27A AND ITEM 37A)	A-G, L-R	1
40A	251T1539-3		.LEVER ASSY (PRE SB 767-27-0142)	A-C, L-N	1
-40B	251T1539-5		.LEVER ASSY- (PRE SB 767-27-0142)	D,E,P ,Q	1
-40C	251T1539-7		.LEVER ASSY	F,H,K ,R,S	1
-40D	251T1539-9		DELETED		
-40E	251T1539-7		.LEVER ASSY- (POST SB 767-27-0142)	A-E, L-Q	1
-40F	251T1539-8		.LEVER ASSY	G,J	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-45	HL525-8-13		..BOLT- (V60516) (SPEC BACB30ND8-13) (OPT HL525-8-13 (V97928)) (OPT HL525-8-13 (V56878)) (OPT HL525-8-13 (V92215)) (OPT 69309-8-13 (V56878)) (OPT HL525-8-13 (V80539)) (USED ON ITEM 40A)	A-C, L-N	1
-45A	HL525-8-14		..BOLT- (V60516) (SPEC BACB30ND8-14) (OPT HL525-8-14 (V56878)) (OPT HL525-8-14 (V73197)) (OPT HL525-8-14 (V92215)) (OPT 69309-8-14 (V56878)) (OPT HL525-8-14 (V80539)) (OPT HL525-8-14 (V97928)) (USED ON ITEM 40B)	D,E,P ,Q	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01- -45B	HL13VAZ8-14		..BOLT- (V56878) (SPEC BACB30NY8K14) (OPT HL13VAZ8-14 (V73197)) (OPT HL13VAZ8-14 (V92215)) (OPT HL13VAZ8-14 (V97928)) (OPT L801-8K14 (V06725)) (OPT HL13VAZ8-14 (V08524)) (OPT HL13V14 (V06725)) (OPT HL13VAZ8-14 (V17446))	F-K,R ,S	1
-45C	HL13VAZ8-14		..BOLT- (V56878) (SPEC BACB30NY8K14) (OPT HL13VAZ8-14 (V73197)) (OPT HL13VAZ8-14 (V92215)) (OPT HL13VAZ8-14 (V97928)) (OPT L801-8K14 (V06725)) (OPT HL13VAZ8-14 (V08524)) (OPT HL13V14 (V06725)) (OPT HL13VAZ8-14 (V17446)) (USED ON ITEM 40E)	A-E, L-Q	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-50	HL79-8		..COLLAR- (V5M902) (SPEC BACC30M8) (OPT HL79-8 (V73197)) (OPT HL79-8 (V92215)) (OPT 66014-8 (V56878)) (OPT HL79-8 (V56878)) (USED ON ITEMS 40A, 40B)	A-E, L-Q	1
-50A	HL1187-8		..COLLAR- (V5M902) (SPEC BACC30X8) (OPT HL87-8 (V73197)) (OPT HL87-8 (V92215)) (OPT HL1187-8 (V56878)) (OPT HL1187-8 (V92215)) (OPT HL87-8 (V56878)) (OPT HL1187-8 (V73197))	F,H,K ,R,S	1
-50B	HL1087-8		..COLLAR- (V9N513) (SPEC BACC30BH8) (OPT HL1087-8 (V92215)) (OPT HL1087-8 (V73197)) (OPT HL1087-8 (V56878))	G,J	1
-50C	HL1087-8		DELETED		

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-50D	HL1187-8		..COLLAR-	A-E,	1
			(V5M902)	L-Q	
			(SPEC BACC30X8)		
			(OPT HL87-8		
			(V92215))		
			(OPT HL87-8		
			(V73197))		
			(OPT HL1187-8		
			(V56878))		
			(OPT HL1187-8		
			(V92215))		
			(OPT HL87-8		
			(V56878))		
			(OPT HL1187-8		
			(V73197))		
			(USED ON ITEM 40E)		
55	NAS75-4-022		..BUSHING-	A-C,	1
			(USED ON ITEM 40A)	L-N	
			(PRE SB 767-27-0142)		
-55A	251T3741-37		..BUSHING-	D,E,P	1
			(USED ON ITEM 40B)	,Q	
			(PRE SB 767-27-0142)		
-55B	251T3743-1		..BUSHING-	F-K,R	1
			(USED ON ITEMS 40C, 40F)	,S	
-55C	251T3743-1		..BUSHING-	A-E,	1
			(USED ON ITEM 40E)	L-Q	
			(POST SB 767-27-0142)		
60	ATF6		..BEARING-	A-E,	1
			(V60380)	L-Q	
			(SPEC BACB10ET06)		
			(OPT 6AFC817		
			(V92563))		
			(OPT YAF06B		
			(V07484))		
			(USED ON ITEM 40A, 40B)		
-60A	KRP173406FT		..BEARING-	F-K,R	1
			(V50632)	,S	
-60B	KRP173406FT		..BEARING-	A-E,	1
			(V50632)	L-Q	
			(USED ON ITEM 40E)		
65A	BACB28B4-265P		..BUSHING		2
70A	251T1539-4		..LEVER-	A-C,	1
			(USED ON ITEM 40A)	L-N	

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	-70B	251T1539-6		..LEVER- (USED ON ITEMS 40B, 40C, 40E)	A-F,H,K-S	1
R	-70C	251T1539-9		..LEVER	G,J	1
	75A	251T1522-2		.CAM- (OPT ITEMS 75B, 75C)	A,L	1
	-75B	251T1522-3		.CAM- (OPT ITEMS 75A, 75C)	A,L	1
	-75C	251T1522-4		.CAM- (OPT ITEMS 75A, 75B)	A,L	1
	-75D	251T1522-4		.CAM	B-K,M-S	1
				ATTACHING PARTS		
	80	NAS6704-24		.BOLT		1
	85	AN960-416		DELETED		
	85A	NAS1149C0463R		.WASHER		1
	90	BRH10C4M		.NUT- (V52828) (SPEC BACN10JC4CM) (OPT T6C428JM (V11815)) (OPT 97E48 (V80539)) (OPT 109LH9075-4W (V72962)) (OPT VN303D048 (V92215)) (OPT 9NS202101SE048 (VA8053)) (OPT H01-4BAC (V15653))	G	1
	-90A	H52732-4CD		.NUT- (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554)) -------*-------	A-F,H-S	1
	95	251T1521-1		.CARRIER ASSY-LOST MOTION	A-D,L-P	1
	-95A	251T1521-3		.CARRIER ASSY-LOST MOTION	E,F,H,K,Q-S	1
	-95B	251T1521-5		.CARRIER ASSY-LOST MOTION	G,J	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-100	MKP5ANJC		..BEARING- (V06144) (SPEC BACB10AP5) (OPT LLMKP5A (V38443)) (OPT MKP5AFS428 (V21335)) (OPT MKP5ATT (V43991)) (OPT MKP5A2TS (V43991)) (OPT MKP5E6531 (V21335)) (OPT MKP5AG20 (V38443)) (OPT MKP5ALY196 (V40920)) (OPT MKP5A (V38443)) (OPT MCS25E (VK8455)) (OPT MKP5ASD610 (V83086)) (REPLD BY ITEM 100C) (PRE SB 767-27-0128)	A-D, L-P	1
-100A	ACMKP5AFS428		..BEARING- (V21335) (SPEC BACB10FS5R) (OPT ACMKP5AP26LY198 (V40920)) (OPT SSMKP5ASD706 (V83086)) (OPT ACMKP5AA3908 (V21335)) (OPT SMCS25EG7A (VK8455)) (OPT AAMK5RAP (V21760)) (REPLD BY ITEM 100C)	E-K, Q-S	1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	-100B	ACMKP5AFS428		..BEARING- (V21335) (SPEC BACB10FS5R) (OPT ACMKP5AP26LY198 (V40920)) (OPT SSMKP5ASD706 (V83086)) (OPT ACMKP5AA3908 (V21335)) (OPT SMCS25EG7A (VK8455)) (OPT AAMK5RAP (V21760)) (REPLD BY ITEM 100C) (POST SB 767-27-0128)	A-D, L-P	1
R	-100C	BACB10FS5RJ		..BEARING- (REPLS ITEMS 100, 100A, 100B)	A-J, L-R	1
	105	251T1521-2		..CARRIER-MOTION	A-F,H ,K-S	1
	-105A	251T1521-4		..CARRIER-MOTION	G,J	1
	110	B542DDNJC		.BEARING- (V06144) (SPEC BACB10CF21PP) (OPT B542-2TS (V43991)) (OPT B542DDFS428 (V21335)) (OPT B542SSG27 (V30163)) (OPT T342E (VK8455)) (OPT B542DDFS101 (V06144)) (OPT B542DD (V38443)) (OPT B542FS101 (V06144)) (OPT B542DDP (V21760)) (REPLD BY ITEM 110E) (PRE SB 767-27A0175)	A-F	1
	-110A	BAC10FU21		DELETED		

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-110B	PACMB542DDFS428		.BEARING- (V21335) (SPEC BACB10FU21) (OPT SSMB542DDSD705 (V83086)) (OPT PACMB542DDA3908 (V21335)) (OPT ACMB542DDP818LY (V40920)) (REPLD BY ITEM 110E)	G	1
-110C	SSMB542DDSD624		.BEARING- (V83086) (SPEC BACB10FU21J) (OPT PACMB542DDFS428 (V21335)) (OPT AMB542DDNJC (V06144))	H-K,S	1
-110D	SSMB542DDSD624		.BEARING- (V83086) (SPEC BACB10FU21J) (OPT PACMB542DDFS428 (V21335)) (OPT AMB542DDNJC (V06144)) (POST SB 767-27A0175)	L-R	1
-110E	SSMB542DDSD624		.BEARING- (V83086) (SPEC BACB10FU21J) (OPT PACMB542DDFS428 (V21335)) (OPT AMB542DDNJC (V06144)) (REPLS ITEMS 110, 110B)	A-G	1
113	251T1582-1		.SPACER		1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-115	MKP4ANJC		.BEARING- (V06144) (SPEC BACB10AP4) (OPT MCS204E (VK8455)) (OPT LLMKP4A (V38443)) (OPT MKP4AFS428 (V21335)) (OPT MKP4ATT (V43991)) (OPT MKP4A2TS (V43991)) (OPT MKP4E6531 (V21335)) (OPT MKP4AG20 (V38443)) (OPT MKP4ALY196 (V40920)) (OPT MKP4A (V38443)) (OPT MCS24E (VK8455)) (OPT MKP4ASD610 (V83086)) (REPLD BY ITEM 115E) (PRE SB 767-27A0175)	A-D	1
-115A	ACMKP4AFS428		.BEARING- (V21335) (SPEC BACB10FS4R) (OPT PACMKP4AA3908 (V21335)) (OPT ACMKP4AA3908 (V21335)) (OPT AMCS24EG7A (VK8455)) (OPT SSMK4RAP (V21760)) (REPLD BY ITEM 115E)	E-G,Q,R	1
-115B	ACMKP4AFS428		DELETED		

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-115C	SSMKP4ASD529		.BEARING- (V50294) (SPEC BACB10FS04RJ) (OPT SSMKP04RJASD705 (V83086)) (OPT PACMKP04RJAA390 (V21335)) (OPT ACMKP04RJAP510L (V40920)) (OPT PACMKP04RJAFS42 (V21335)) (OPT SSMKP04RJAP (V21760))	H-K,S	1
-115D	SSMKP4ASD529		.BEARING- (V50294) (SPEC BACB10FS04RJ) (OPT SSMKP04RJASD705 (V83086)) (OPT PACMKP04RJAA390 (V21335)) (OPT ACMKP04RJAP510L (V40920)) (OPT PACMKP04RJAFS42 (V21335)) (OPT SSMKP04RJAP (V21760)) (POST SB 767-27A0175)	L-P	1
-115E	SSMKP4ASD529		.BEARING- (V50294) (SPEC BACB10FS04RJ) (OPT SSMKP04RJASD705 (V83086)) (OPT PACMKP04RJAA390 (V21335)) (OPT ACMKP04RJAP510L (V40920)) (OPT PACMKP04RJAFS42 (V21335)) (OPT SSMKP04RJAP (V21760)) (REPLS ITEMS 115, 115A)	A-G,Q,R	1
120	NAS43DD4-13		.SPACER	A-G,L-R	1
-120A	NAS43DD4-13FC		.SPACER	H-K,S	1
121	MS24665-134		DELETED		

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	121A	BACP18BC02C06P		.PIN-COTTER		1
	122	AN960JD10		DELETED		
	122A	NAS1149D0363J		.WASHER		1
	123	MS20392-2C35		.PIN	G	1
	-123A	BACP18BD2C35		.PIN	A-F, H-S	1
	125	251T1515-4		.QUADRANT ASSY- (PRE SB 767-27A0175)	A,B	1
	-125A	251T1515-7		.QUADRANT ASSY- (PRE SB 767-27A0175)	C-F	1
	-125B	251T1515-9		.QUADRANT ASSY	G,J	1
	-125C	251T1515-14		.QUADRANT ASSY	K	1
	-125D	251T1515-12		.QUADRANT ASSY- (POST SB 767-27A0175)	L,M	1
	-125E	251T1515-13		.QUADRANT ASSY- (POST SB 767-27A0175)	N-R	1
	-125F	251T1515-13		.QUADRANT ASSY	S	1
R	-125G	251T1515-7		.QUADRANT ASSY	G	1
	130A	B542DDNJC		..BEARING- (V06144) (SPEC BACB10CF21PP) (OPT B542-2TS (V43991)) (OPT B542DDFS428 (V21335)) (OPT B542SSG27 (V30163)) (OPT T342E (VK8455)) (OPT B542DDFS101 (V06144)) (OPT B542DD (V38443)) (OPT B542FS101 (V06144)) (OPT B542DDP (V21760)) (PRE SB 767-27A0175)	A-F	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-130B	PACMB542DDFS428		..BEARING- (V21335) (SPEC BACB10FU21) (OPT SSMB542DDSD705 (V83086)) (OPT PACMB542DDA3908 (V21335)) (OPT ACMB542DDP818LY (V40920)) (REPLD BY ITEM 130F)	G,J,K	1
-130C	SSMB542DDSD624		..BEARING- (V83086) (SPEC BACB10FU21J) (OPT PACMB542DDFS428 (V21335)) (OPT AMB542DDNJC (V06144)) (POST SB 767-27A0175)	L-R	1
-130D	SSMB542DDSD624		..BEARING- (V83086) (SPEC BACB10FU21J) (OPT PACMB542DDFS428 (V21335)) (OPT AMB542DDNJC (V06144))	S	1
-130E	B542DDNJC		..BEARING- (V06144) (SPEC BACB10CF21PP) (OPT B542-2TS (V43991)) (OPT B542DDFS428 (V21335)) (OPT B542SSG27 (V30163)) (OPT T342E (VK8455)) (OPT B542DDFS101 (V06144)) (OPT B542DD (V38443)) (OPT B542FS101 (V06144)) (OPT B542DDP (V21760)) (REPLD BY ITEM 130F)	H	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01- -130F	SSMB542DDSD624		..BEARING- (V83086) (SPEC BACB10FU21J) (OPT PACMB542DDFS428 (V21335)) (OPT AMB542DDNJC (V06144)) (REPLS ITEMS 130B, 130E)	G-K	1
135	MKP4ANJC		..BEARING- (V06144) (SPEC BACB10AP4) (OPT MCS204E (VK8455)) (OPT LLMKP4A (V38443)) (OPT MKP4AFS428 (V21335)) (OPT MKP4ATT (V43991)) (OPT MKP4A2TS (V43991)) (OPT MKP4E6531 (V21335)) (OPT MKP4AG20 (V38443)) (OPT MKP4ALY196 (V40920)) (OPT MKP4A (V38443)) (OPT MCS24E (VK8455)) (OPT MKP4ASD610 (V83086)) (REPLD BY ITEM 135G) (PRE SB 767-27A0175)	A-F,H	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-135A	SSMKP04ASD705		..BEARING- (V83086) (SPEC BACB10FS04) (OPT PACMKP04AA3908 (V21335)) (OPT ACMKP04AP510LY1 (V40920)) (OPT PACMKP04AFS428 (V21335)) (OPT SSMKP04AP (V21760)) (REPLD BY ITEM 135E)	G,J	1
-135B	ACMKP3AFS428		..BEARING- (V21335) (SPEC BACB10FS04J) (OPT PACMKP04JAA3908 (V21335)) (OPT SSMKP04JASD705 (V83086)) (OPT SSMKP4ASD524 (V50294)) (OPT SSMKP04AP (V21760)) (OPT PACMKP04JAFS428 (V21335)) (OPT ACMKP04JAP510LY (V40920))	K,S	1
-135C	ACMKP3AFS428		..BEARING- (V21335) (SPEC BACB10FS04J) (OPT PACMKP04JAA3908 (V21335)) (OPT SSMKP04JASD705 (V83086)) (OPT SSMKP4ASD524 (V50294)) (OPT SSMKP04AP (V21760)) (OPT PACMKP04JAFS428 (V21335)) (OPT ACMKP04JAP510LY (V40920)) (OPT ITEM 135D) (POST SB 767-27A0175)	L-R	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-135D	SSMKP4ASD529		..BEARING- (V50294) (SPEC BACB10FS04RJ) (OPT SSMKP04RJASD705 (V83086)) (OPT PACMKP04RJAA390 (V21335)) (OPT ACMKP04RJAP510L (V40920)) (OPT PACMKP04RJAFS42 (V21335)) (OPT SSMKP04RJAP (V21760)) (OPT ITEM 135C) (POST SB 767-27A0175)	L-R	1
-135E	ACMKP3AFS428		..BEARING- (V21335) (SPEC BACB10FS04J) (OPT PACMKP04JAA3908 (V21335)) (OPT SSMKP04JASD705 (V83086)) (OPT SSMKP4ASD524 (V50294)) (OPT SSMKP04AP (V21760)) (OPT PACMKP04JAFS428 (V21335)) (OPT ACMKP04JAP510LY (V40920)) (REPLS ITEM 135A)	G,J	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
135F	MKP4ANJC		DELETED		
-135G	SSMKP4ASD529		..BEARING- (V50294) (SPEC BACB10FS04RJ) (OPT SSMKP04RJASD705 (V83086)) (OPT PACMKP04RJAA390 (V21335)) (OPT ACMKP04RJAP510L (V40920)) (OPT PACMKP04RJAFS42 (V21335)) (OPT SSMKP04RJAP (V21760)) (REPLS ITEM 135)	A-F,H	1
140	251T1515-5		..QUADRANT	A,B,L,M	1
-140A	251T1515-8		..QUADRANT	C-F,H,K,N-S	1
-140B	251T1515-10		..QUADRANT	G,J	1
			INSTALLATION PARTS		
900	MKP5ANJC		BEARING- (V06144) (SPEC BACB10AP5) (OPT LLMKP5A (V38443)) (OPT MKP5AFS428 (V21335)) (OPT MKP5ATT (V43991)) (OPT MKP5A2TS (V43991)) (OPT MKP5E6531 (V21335)) (OPT MKP5AG20 (V38443)) (OPT MKP5ALY196 (V40920)) (OPT MKP5A (V38443)) (OPT MCS25E (VK8455)) (OPT MKP5ASD610 (V83086))	A-D, L-P	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01- -900A	MKP5ANJC		BEARING- (V06144) (SPEC BACB10AP5) (OPT LLMKP5A (V38443)) (OPT MKP5AFS428 (V21335)) (OPT MKP5ATT (V43991)) (OPT MKP5A2TS (V43991)) (OPT MKP5E6531 (V21335)) (OPT MKP5AG20 (V38443)) (OPT MKP5ALY196 (V40920)) (OPT MKP5A (V38443)) (OPT MCS25E (VK8455)) (OPT MKP5ASD610 (V83086)) (LIMITED)	E,Q	1
-900B	ACMKP5AFS428		BEARING- (V21335) (SPEC BACB10FS5R) (OPT ACMKP5AP26LY198 (V40920)) (OPT SSMKP5ASD706 (V83086)) (OPT ACMKP5AA3908 (V21335)) (OPT SMCS25EG7A (VK8455)) (OPT AAMK5RAP (V21760)) (LIMITED)	E,Q	1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	-900C	ACMKP5AFS428		BEARING- (V21335) (SPEC BACB10FS5R) (OPT ACMKP5AP26LY198 (V40920)) (OPT SSMKP5ASD706 (V83086)) (OPT ACMKP5AA3908 (V21335)) (OPT SMCS25EG7A (VK8455)) (OPT AAMK5RAP (V21760))	F,H,K,R,S	1
	-900D	BACB10FS05R		BEARING	G,J	1
	905	NAS43DD5-173FC		SPACER- (LIMITED)	A-F,H,K-S	1
R	-905A	NAS43DD5-173		SPACER- (LIMITED)	A-F,H,K-S	1
R	-905B	NAS43DD5-189FC		SPACER	G,J	1

- Item Not Illustrated