TO: ALL HOLDERS OF RUDDER ACTUATOR LINK ASSEMBLY COMPONENT MAINTENANCE MANUAL 27-21-70

REVISION NO. 2 DATED NOV 01/99

HIGHLIGHTS

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

CHAPTER/SECTION AND PAGE NO.	DESCRIPTION OF CHANGE
TITLE PAGE	Added 25T3100-5 for latest engineering.
1	
REPAIR 1-1	
601-602	
1004-1006	

BOEING

COMPONENT
MAINTENANCE MANUAL

RUDDER ACTUATOR LINK ASSEMBLY

PART NUMBERS 252T3100-3,-5

COMPONENT MAINTENANCE MANUAL
WITH
ILLUSTRATED PARTS LIST

13376

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
	27-12		JUL 01/89

PAGE	DATE	CODE
27-21-70		
TITLE PAGE		
*1	NOV 01/99	01.1
2	BLANK	
REVISION RECORD		
1	OCT 01/87	01
2	BLANK	
TR & SB RECORD		
1	JUL 01/89	01.1
2	BLANK	
LIST OF EFFECTIVE PAGES		
*1	NOV 01/99	01
THRU LAST PAGE		
CONTENTS		
1	OCT 01/87	01
2	BLANK	
INTRODUCTION		
1	OCT 01/87	01
2	BLANK	
DESCRIPTION & OPERATION		
1	OCT 01/87	01
2	BLANK	
DISASSEMBLY		
301	OCT 01/87	01
302	BLANK	
CHECK		
501	OCT 01/87	01
502	BLANK	
REPAIR-GENERAL		
601	OCT 01/87	01
602	OCT 01/87	01
REPAIR 1-1		
*601	NOV 01/99	01.1
*602	NOV 01/99	01.1
REPAIR 2-1		
601	OCT 01/87	01
602	OCT 01/87	01
603	OCT 01/87	01
604	BLANK	
REPAIR 3-1		
601	OCT 01/87	01
602	BLANK	
REPAIR 4-1		
601	OCT 01/87	01
602	OCT 01/87	01
ASSEMBLY		
701	OCT 01/87	01
702	BLANK	
FITS AND CLEARANCES		
801	JUL 01/89	01.1
802	JUL 01/89	01.1
803	JUL 01/89	01.1
804	JUL 01/89	01.1
ILLUSTRATED PARTS LIST		
1001	OCT 01/87	01
1002	OCT 01/87	01
1003	JUL 01/89	01.1
*1004	NOV 01/99	01.1
*1005	NOV 01/99	01.1
*1006	NOV 01/99	01.1
*1007	NOV 01/99	01.101
*1008	BLANK	

* = REVISED, ADDED OR DELETED

TABLE OF CONTENTS

*[1] Special instructions not required. Use standard industry practices.

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 12/83
Assembly	MAY 12/83

RUDDER ACTUATOR LINK ASSEMBLY

DESCRIPTION AND OPERATION

1. The rudder actuator link assembly consists of a hanger link, a reaction link assembly and a trunnion assembly. The reaction link fastens to the trunnion on one end. The other end attaches to the rudder. The hanger link fastens to the trunnion assembly and provides a mounting surface for attachment to the vertical stabilizer rear spar. The assembly is a movable linkage device that serves as a platform for the rudder power control actuator and transmits mechanical movement to the rudder.

2. Leading Particulars (Approximate)

   Length -- 21 inches
   Width -- 12 inches
   Height -- 10 inches
   Weight -- 3 pounds

DISASSEMBLY

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

1. Disassembly (IPL Fig. 1)

   A. Remove bolt (5), washer (10), nut (15) and bushing (20) from trunnion assembly (125), and separate hanger link (25) and rod end (40) from trunnion assembly (125).

   B. Remove nut (35), washer (30), and rod end (40) from hanger link (25).

      NOTE: Nut (35) has been tightened to 1000-1200 lb-in. during assembly.

   C. Remove nut (55), washer (50A) and rod end (45) from reaction link (117A).

      NOTE: Nut (55) has been tightened to 2500-3000 lb-in. during assembly.

   CAUTION: LINK ASSY (117A) AND CAP (115A) ARE MATCHED PARTS AND CANNOT BE INTERCHANGED.

   D. Remove parts (60A thru 80) and separate trunnion assembly (125) from reaction link assembly (85). Reassemble reaction link assembly to keep parts together.

      NOTE: Do not remove bushings (95) from cap (115A) or bushings (110), inserts (119) and pin (118) from reaction link (119H). Do not remove bushing (130), fittings (120, 122) or inserts (135) from trunnion (140) unless necessary for repair or replacement.

CHECK

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

2. Magnetic particle check per 20-20-01 -- Hanger link (25), cap (80) and trunnion (140).

3. Penetrant check per 20-20-02 -- Cap (115A) and link assembly (117A).

REPAIR - GENERAL

1. Content

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

P/N	NAME	REPAIR
252T3111	REACTION LINK	1-1
252T3172	TRUNNION	2-1
- - -	MISC PARTS REFINISH	3-1
252T3171	HANGER LINK	4-1

2. Standard Practices

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

   20-10-01 Repair and Refinish of High Strength Steel Parts
   20-30-02 Stripping of Protective Finishes
   20-30-03 General Cleaning Procedures
   20-41-01 Decoding Table for Boeing Finish Codes
   20-42-03 Hard Chrome Plating
   20-42-05 Bright Cadmium Plating
   20-43-01 Chromic Acid Anodizing
   20-50-03 Bearing Installation and Retention

3. Materials

   NOTE: Equivalent substitutes may be used.

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

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

4. Dimensioning Symbols

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

⏤	STRAIGHTNESS
▱	FLATNESS
⊥	PERPENDICULARITY (OR SQUARENESS)
//	PARALLELISM
○	ROUNDNESS
⌭	CYLINDRICITY
⌒	PROFILE OF A LINE
⌓	PROFILE OF A SURFACE
◎	CONCENTRICITY
⌯	SYMMETRY
∠	ANGULARITY
↗	RUNOUT
⌰	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
⊥ | 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 RELATIVE 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
⌯ | 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 RELATIVE 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

(NOTE THAT ⌓ | A | 0.020 MAY ALSO APPEAR AS ⌓ | 0.020 | A)

True Position Dimensioning Symbols
Figure 601

13379

REACTION LINK ASSEMBLY - REPAIR 1-1

252T3111-1, -6

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

CAUTION: LINK ASSY (117A) AND CAP (115A) ARE MATCHED PARTS AND CANNOT BE INTERCHANGED.

1. Bushing Replacement (Fig. 601)

   A. Remove bushings (95, IPL Fig. 1) from cap (115A) and bushings (110) from link assembly (117A).

   B. Install new bushings (95) with wet BMS 5-95 sealant on cap (115A) per 20-50-03.

   C. Install new bushings (110) with wet BMS 5-95 sealant on link assembly (117A) per 20-50-03.

   D. Temporarily assemble cap and link assembly with bolts (60A) and washers (65A). Tighten bolts to 550-670 lb-in.

      NOTE: BACW12OBP7CD washers may be substituted for washers (65A) for temporary assembly.

   E. Machine bushing bores to dimensions shown.

   F. Fillet seal bushing flanges with sealant.

2. Insert Replacement (IPL Fig. 1)

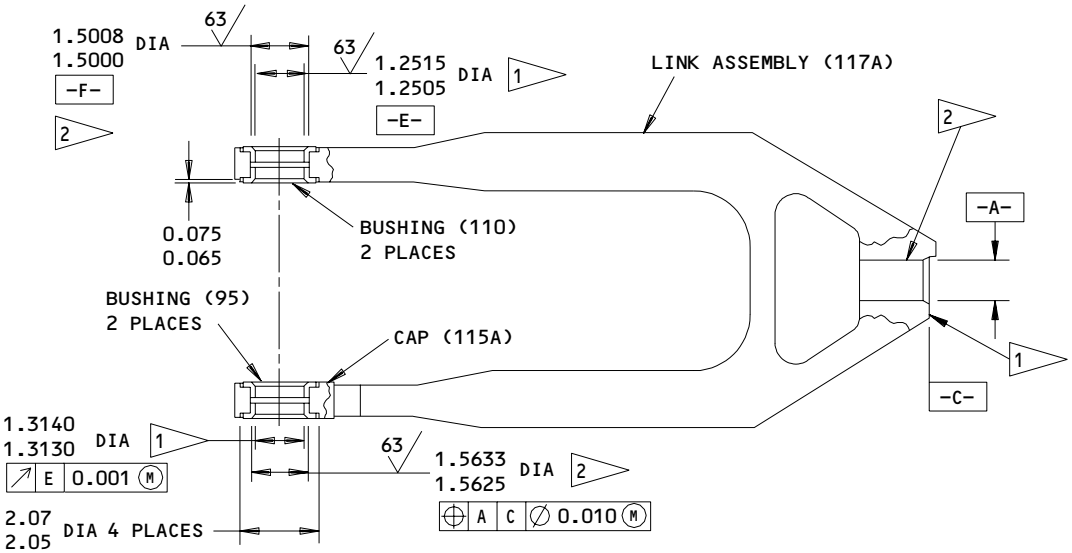
   A. Remove inserts (119).

   B. Install insert (119) 3/4 to 1-1/2 turn below top surface of tapped holes, then remove tang. Install inserts (119) with primer.

3. Pin Replacement

   A. Remove pins (118).

   B. Install pin (118) with sealant.



REFINISH

LINK ASSEMBLY (85, 85A) -- APPLY ONE COAT PRIMER, BMS10-11, TYPE 1 (F-20.02) ALL OVER EXCEPT AS NOTED BY 1 2

LINK (119H, 119J) -- CHROMIC ACID ANODIZE (F-17.04)
CAP(115A) -- CHROMIC ACID ANODIZE (F-17.04)

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

ITEM NUMBERS REFER TO IPL FIG. 1

1 OMIT PRIMER THIS SURFACE

2 APPLY COLORED CHEMICAL COATING (F-17.10)

Link Assembly - Bushing Replacement
Figure 601

13395

TRUNNION ASSEMBLY - REPAIR 2-1

252T3172-1

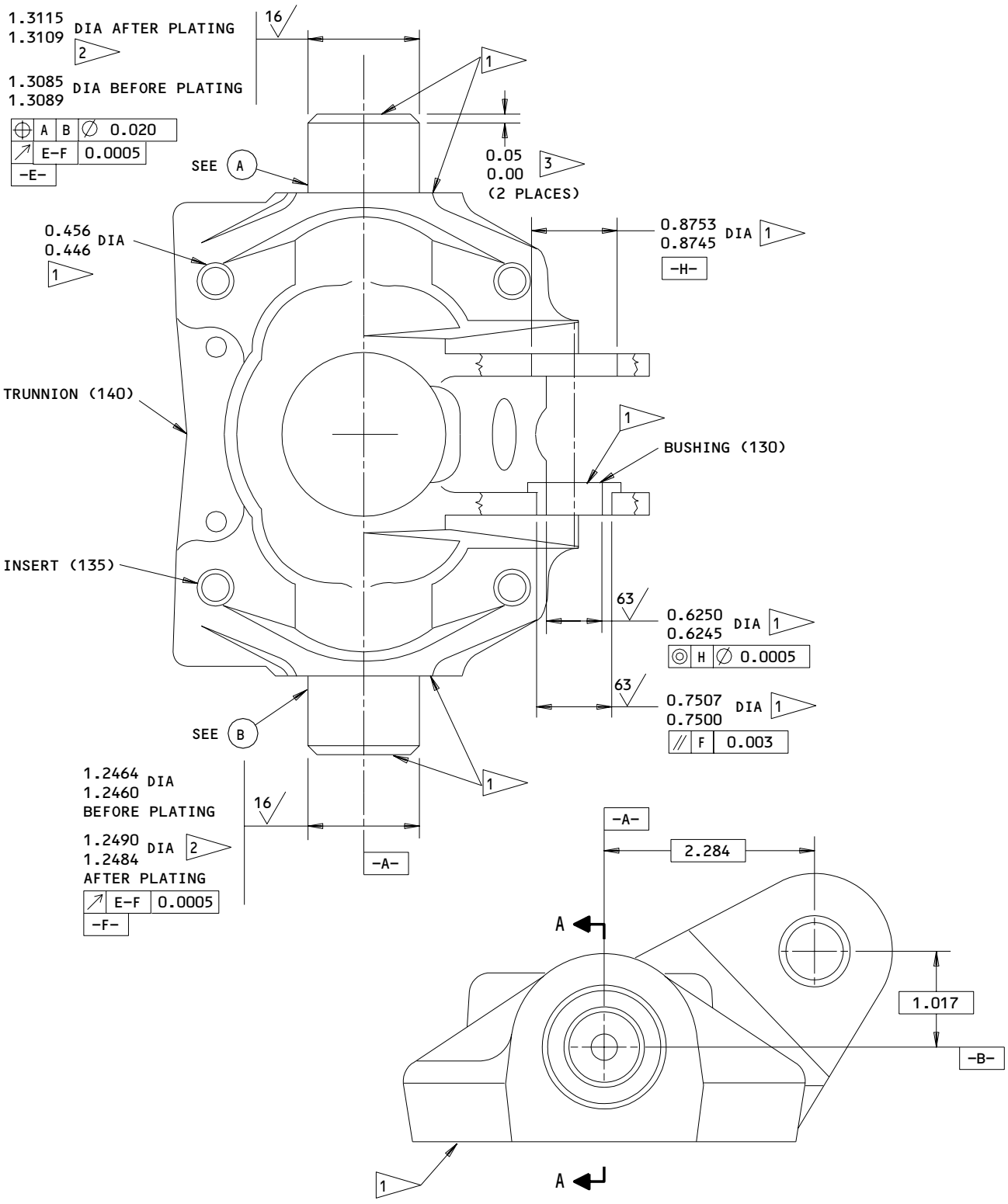
NOTE: Refer to REPAIR-GEN for list of applicable standard practices. For repair of trunnion (140, IPL Fig. 1) surfaces which may only require stripping and restoration of original finish, refer to Refinish instructions, Fig. 601.

1. Bushing Replacement (Fig. 601)

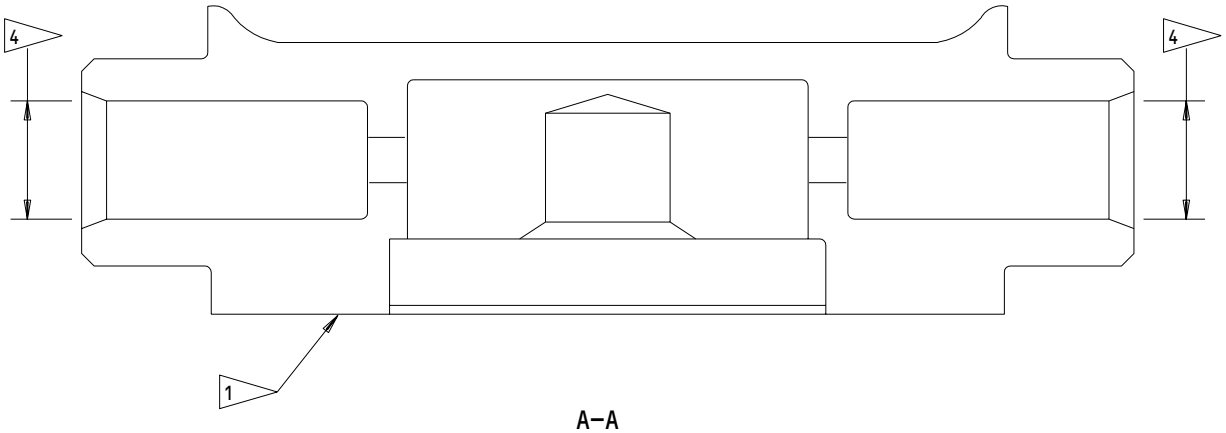
   A. Remove bushing (130, IPL Fig. 1) from trunnion (140).

   B. Install new bushing (130) on trunnion (140) per 20-50-03.

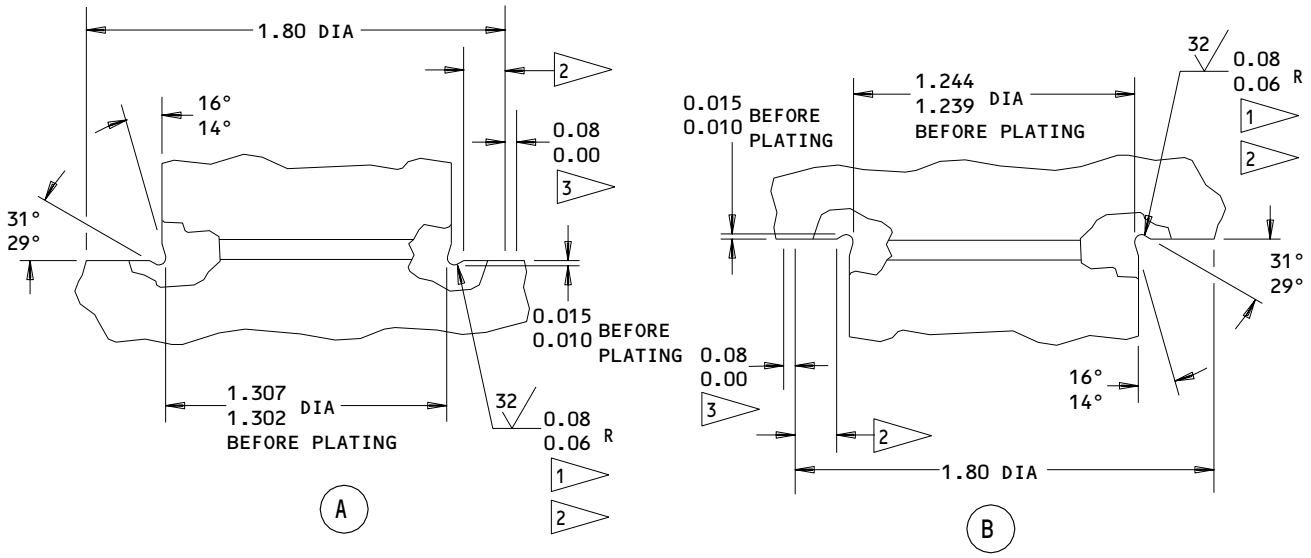
   C. Machine bushing bore to dimensions and finish as shown.



252T3172-1
Trunnion Assy - Bushing Replacement
Figure 601 (Sheet 1)



A–A



REFINISH

TRUNNION (140) -- PASSIVATE (F-17.09) ALL OVER. CADMIUM PLATE (F-15.06) ALL OVER EXCEPT AS NOTED IN 1 2

TRUNNION ASSY (125) -- APPLY ONE COAT BMS 10-11, TYPE 1 PRIMER (F-20.02) EXCEPT ON SURFACES FINISHED PER 2

BREAK EDGES 0.02-0.03R

MATERIAL: 15-5PH CRES, 180-200 KSI

ALL DIMENSIONS ARE IN INCHES

1 OMIT PRIMER ON THIS SURFACE

2 CHROME PLATE (F-15.34) SINGLE PLATE 0.0010-0.0015 THICKNESS

3 CHROME PLATE RUNOUT AREA

4 CADMIUM PLATE THROW-IN ALLOWED

252T3172-1
Trunnion Assy - Bushing Replacement
Figure 601 (Sheet 2)

182090

MISCELLANEOUS PARTS REFINISH - REPAIR 3-1

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

IPL FIG. & ITEM	MATERIAL	FINISH
Fig. 1		
Bushing (20)	15-5PH CRES, 180-200 ksi	Chromium plate (F-15.34).
Hanger link (25)	15-5PH 180-200 ksi	Cadmium plate and apply one coat primer, BMS 10-11, type 1 (F-16.01) except omit primer on 0.05-0.07 inch diameter holes and on chamfer surfaces.
Cap (80)	15-5PH CRES, 180-200 ksi	Passivate (F-17.09).

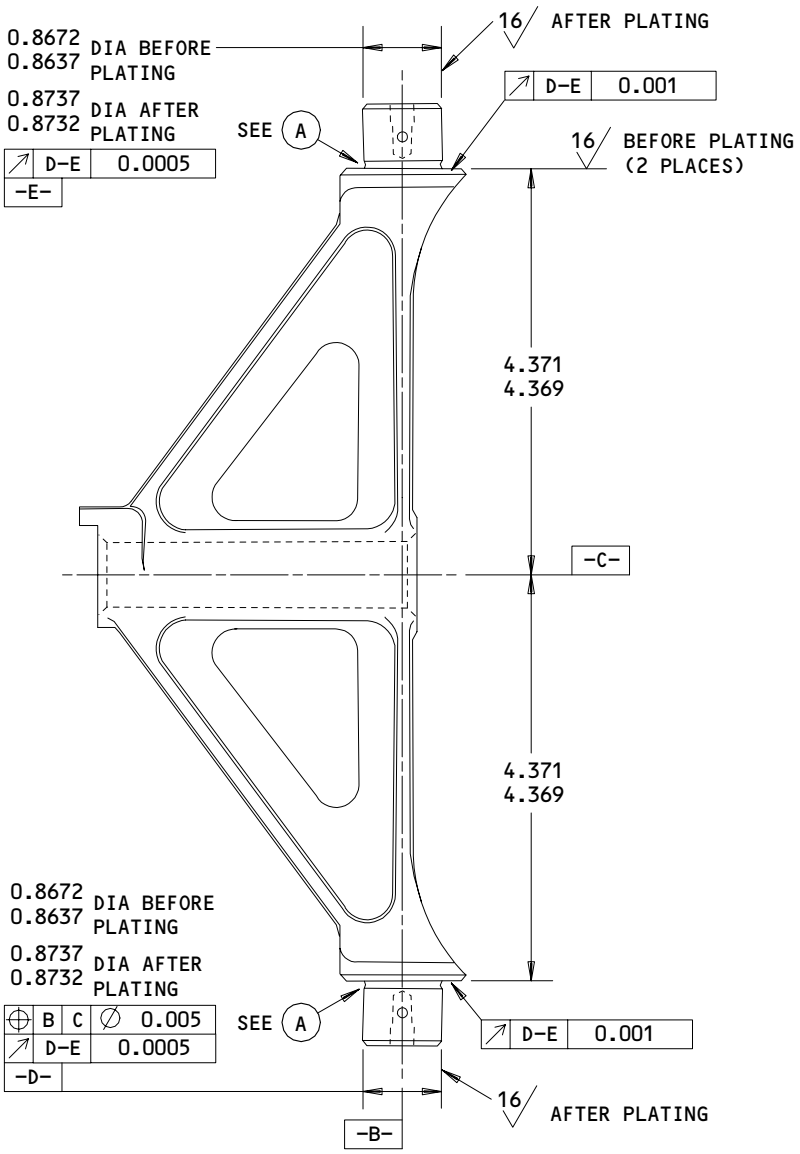
Refinish Details
Figure 601

HANGER LINK ASSEMBLY - REPAIR 4-1

252T3171-1

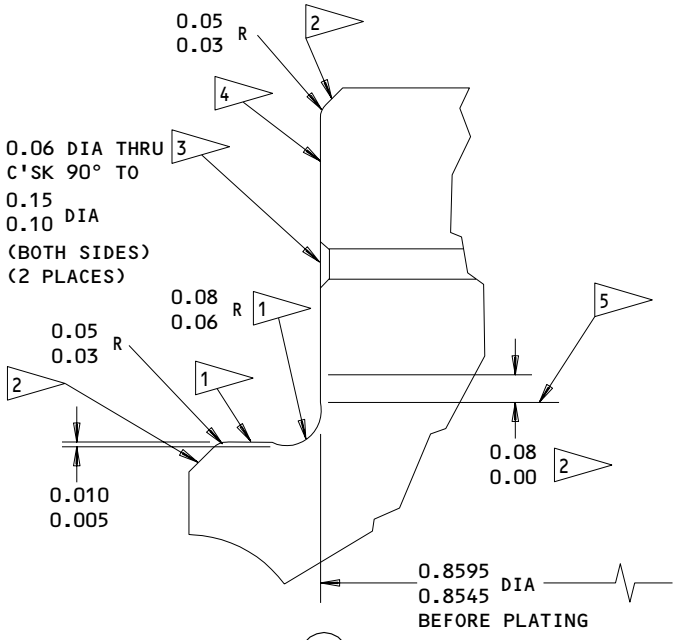
1. Plating Repair

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



Hanger Link Refinish
Figure 601 (Sheet 1)

182093



REFINISH

CADMIUM PLATE AND APPLY ONE COAT BMS 10-11 TYPE I PRIMER (F-16.01) ALL OVER EXCEPT AS NOTED.

1. CHROME PLATE (F-15.34) SINGLE PLATE THICKNESS 0.0005-0.0010. NO GRINDING ALLOWED. 16 FINISH BEFORE PLATING
2. CHROME PLATE RUNOUT AREA
3. NO CHROME PLATE THIS AREA
4. CHROME PLATE (F-15.03) WITH 0.003 MIN THICKNESS. 16 FINISH BEFORE PLATING
5. START RUNOUT PER 4 AT EDGE OF RADIUS. CHROME PLATE PER 4 MUST NOT EXTEND INTO RADIUS

125 ALL MACHINED SURFACES

BREAK SHARP EDGES 0.02-0.03

MATERIAL: 15-5PH CRES, 180-200 KSI

ALL DIMENSIONS ARE IN INCHES

252T3171-1

Hanger Link Refinish
Figure 601 (Sheet 2)

182091

ASSEMBLY

1. Materials

   NOTE: Equivalent substitutes may be used.

   A. Grease -- MIL-G-23827, BMS 3-24 (Ref 20-60-03)

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

2. Assembly (IPL Fig. 1)

   CAUTION: LINK ASSY (117A) AND CAP (115A) ARE MATCHED PARTS AND CANNOT BE INTERCHANGED.

   A. Remove temporary fasteners attaching cap (115A) to link assembly (117A). Install one end of trunnion assembly (125) in link assy (117A) and the other end in cap (115A). Lubricate faying surfaces of cap and link assy with BMS 3-24 grease, and install parts (60A thru 80) to secure. Tighten bolt (60A) to 400-500 lb-in.

   B. Lubricate shank and threads of rod end (45) with BMS 3-24 grease and install rod end (45), washer (50A) and nut (55) on reaction link assy (117A). Tighten nut (55) to 2500-3000 lb-in.

   C. Lubricate shank and threads of rod end (40) with BMS 3-24 grease and install rod end (40), washer (30) and nut (35) on hanger link (25). Tighten nut (35) to 1000-1200 lb-in.

   D. Install rod end (40) on trunnion assembly (125) and install bolt (5), washer (10), bushing (20) and nut (15). Tighten nut (15) to 300-350 lb-in.

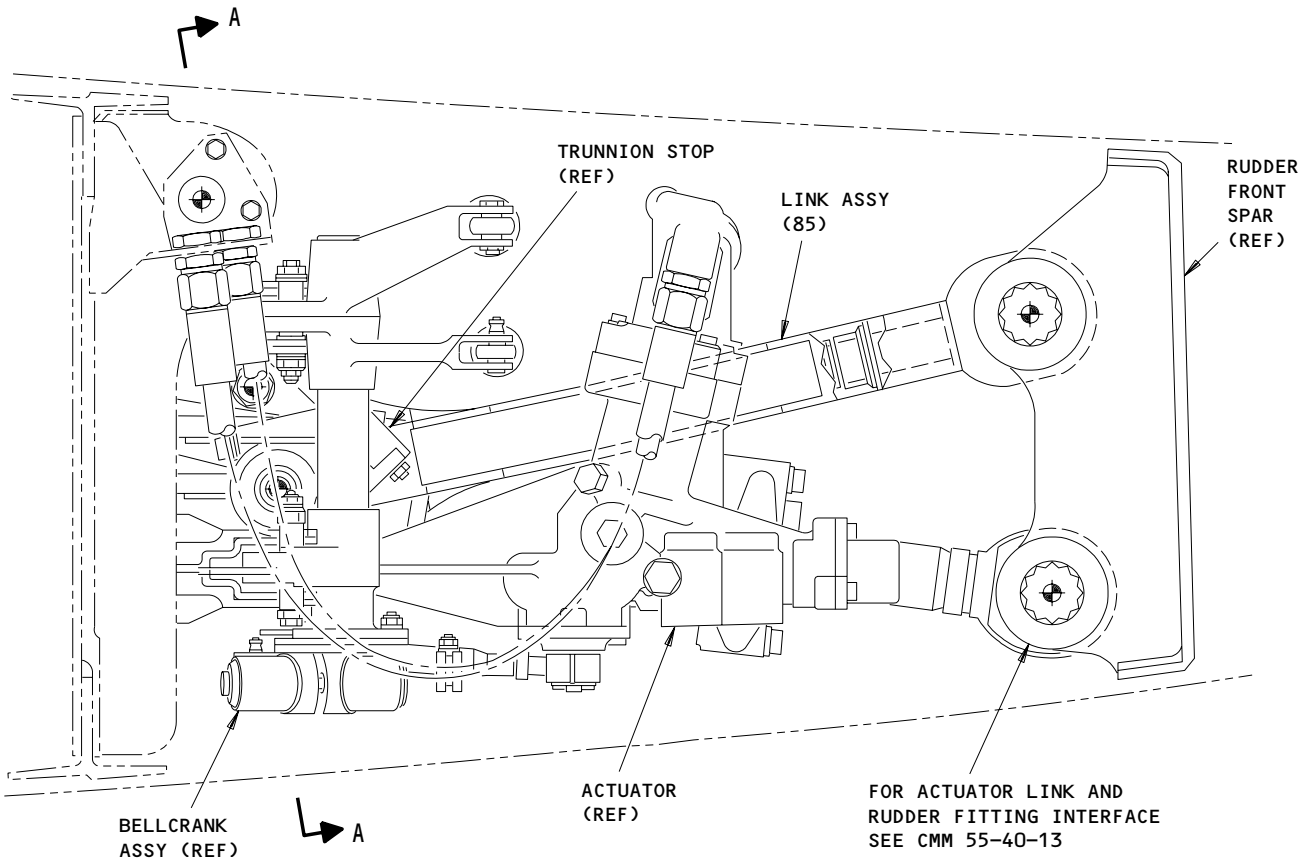
   E. Lubricate hanger link (25), reaction link assembly (85) and trunnion assembly (125) with MIL-G-23827 grease thru grease fittings. Rotate parts to ensure full coverage and wipe off excess. Ensure that all parts rotate freely without binding.

      NOTE: Fitting (122) should be aligned toward fitting (120) per IPL Fig. 1.

3. Storage

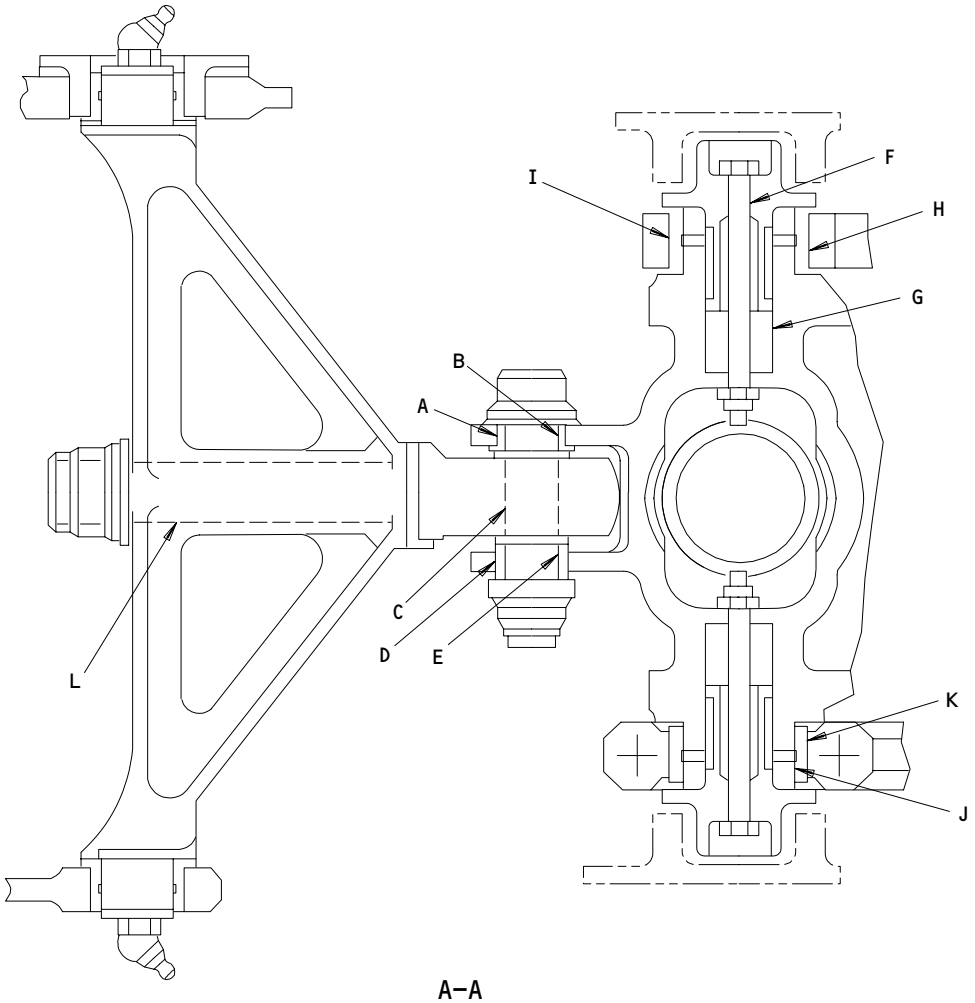
   A. Prepare and store component in accordance with standard industry practices.

FITS AND CLEARANCES



Fits and Clearances
Figure 801 (Sheet 1)

653994



A–A

Fits and Clearances
Figure 801 (Sheet 2)

653995

Ref Letter Fig.801	Mating Item No. IPL Fig.1	Design Dimension				Service Wear Limit		
		Dimension		Assembly Clearance 1		Dimension		Maximum Clearance
		Min	Max	Min	Max	Min	Max	
A	ID 140 OD 130	0.7500 0.7512	0.7507 0.7519	-0.0019	-0.0005	0.7500	0.7512	0.0000
B	ID 130 OD 5	0.6245 0.6230	0.6250 0.6240	0.0005	0.0020			
C	ID 40 OD 5	0.6245 0.6230	0.6250 0.6240	0.0005	0.0020			
D	ID 140 OD 20	0.8745 0.8735	0.8753 0.8740	0.0005	0.0018			
E	ID 20 OD 5	0.6245 0.6230	0.6250 0.6240	0.0005	0.0020			
F	ID 80 OD 70A	0.2500 0.2485	0.2600 0.2497	0.0003	0.0015			
G	ID 140 OD 80	0.7500 0.7540	0.7530 0.7560	-0.0060	-0.0010	0.7500	0.7540	0.0000
H	ID 110,110A OD 140	1.2505 1.2484	1.2515 1.2490	0.0015	0.0031	1.2480	1.2515	0.0035
I	ID 119H,119J OD 110,110A	1.5000 1.5017	1.5008 1.5026	-0.0026	-0.0009	1.5000	1.5017	0.0000
J	ID 95,95A OD 140	1.3130 1.3109	1.3140 1.3115	0.0015	0.0031	1.3105	1.3145	0.0040
K	ID 119H,119J OD 95,95A	1.5625 1.5643	1.5633 1.5652	-0.0027	-0.0010	1.5625	1.5643	0.0000
L	ID 25 OD 40	0.7513 0.7503	0.7523 0.7513	0.0000	0.0020			

1 NEGATIVE NUMBERS DENOTE INTERFERENCE FIT

ALL DIMENSIONS ARE IN INCHES

Fits and Clearances
Figure 801 (Sheet 3)

653992

FOR TORQUE VALUES OF STANDARD FASTENERS, REFER TO 20-50-01			
ITEM NO. IPL FIG. 1	NAME	TORQUE	
		POUND-INCHES	POUND-FEET
15	NUT	300-350	
35	NUT	1000-1200	
55	NUT	2500-3000	
60A	BOLT	400-500	

Torque Table
Figure 802

13384

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

08524 DEUTSCH FASTENER CORPORATION
PO BOX 92925 7001 WEST IMPERIAL HIGHWAY
LOS ANGELES, CALIFORNIA 90045

15653 KAYNAR MFG COMPANY INC KAYLOCK DIV
PO BOX 3001 800 SOUTH STATE COLLEGE BLVD
FULLERTON, CALIFORNIA 92634

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

56878 SPS TECHNOLOGIES INC
HIGHLAND AVENUE
JENKINTOWN, PENNSYLVANIA 19046

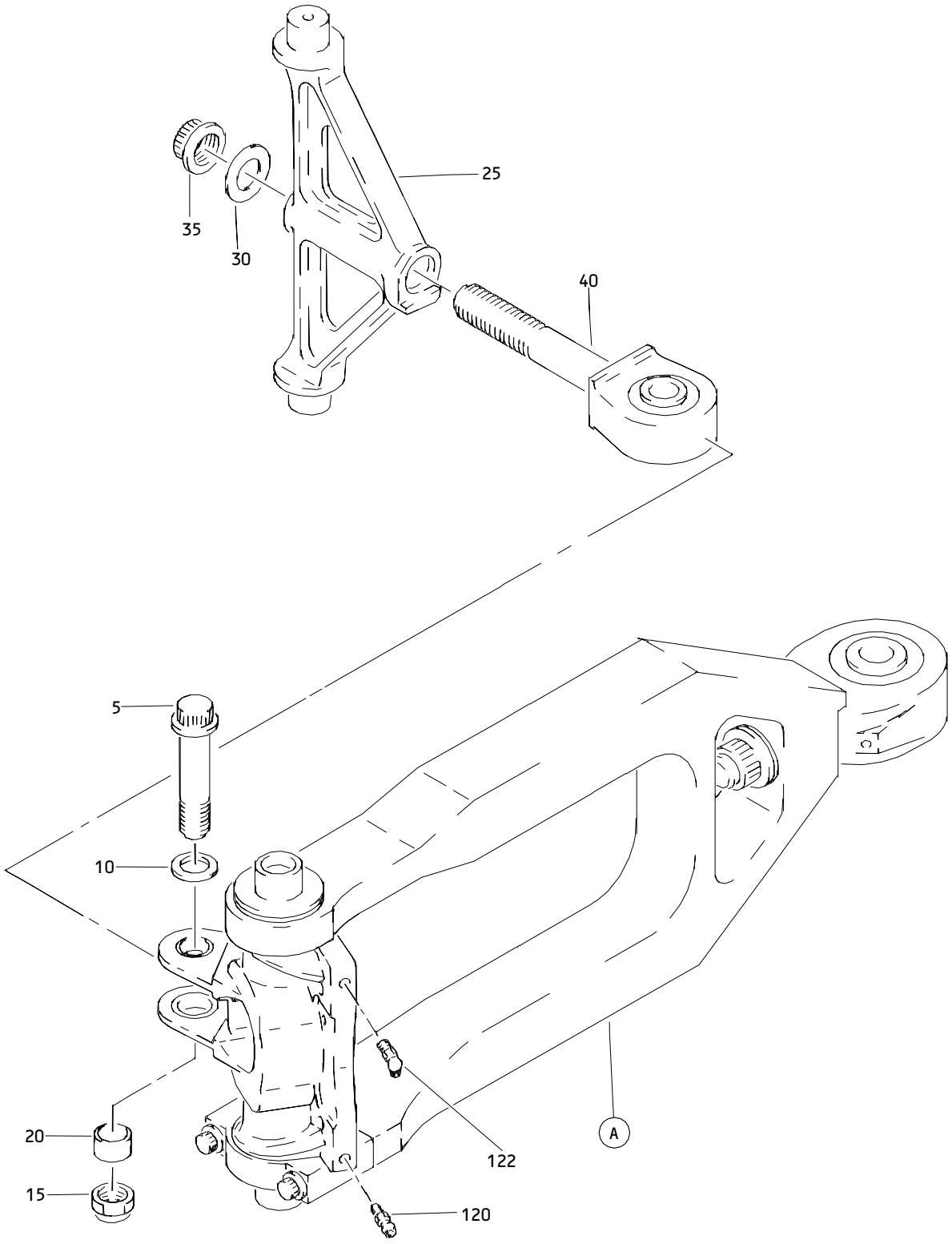
72962 ESNA DIV OF AMERACE CORP
2330 VAUXHALL ROAD
UNION, NEW JERSEY 07083

73197 HISHEAR CORPORATION
2600 SKYPARK DRIVE
TORRANCE, CALIFORNIA 90509

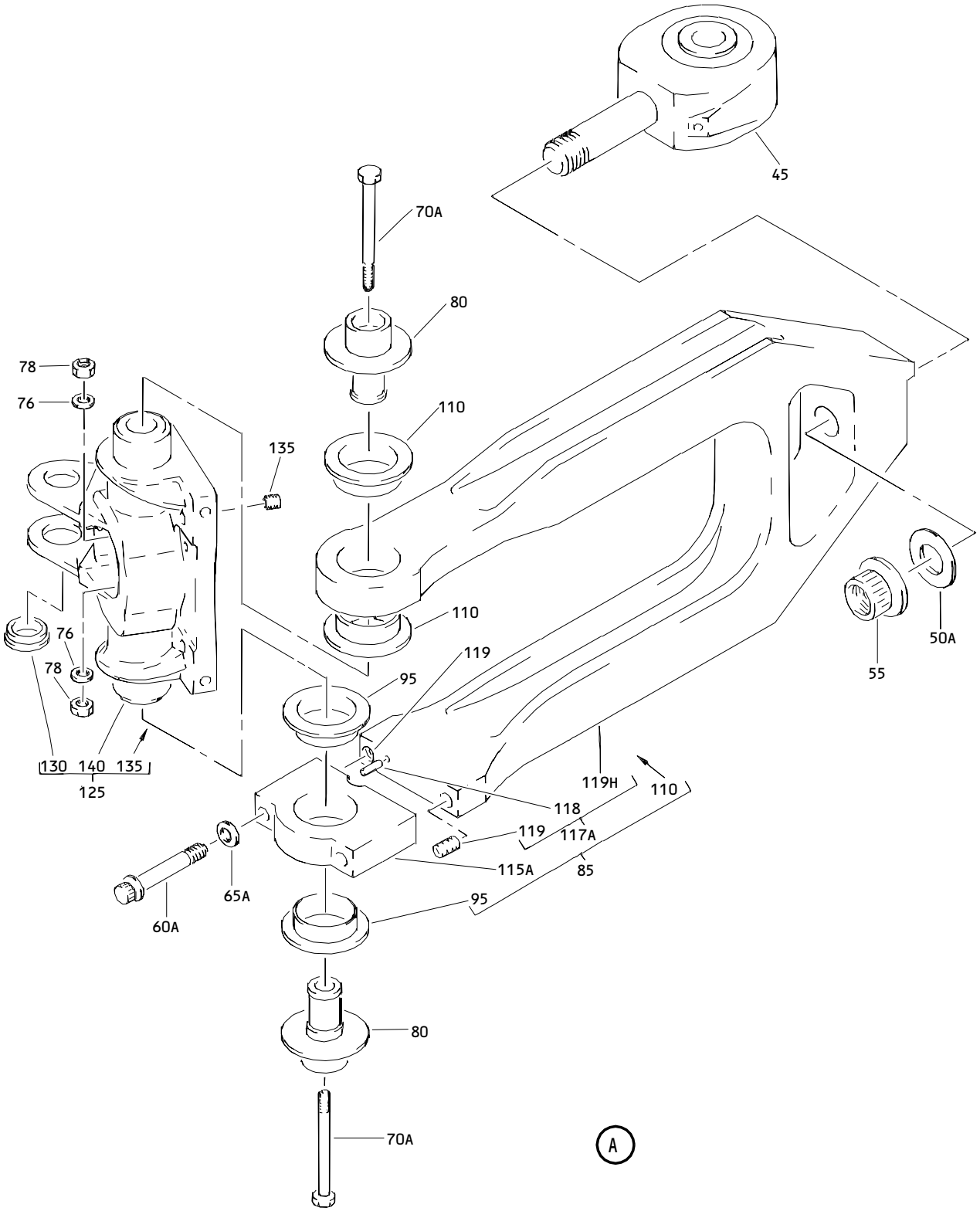
77896 REXNORD INC. BEARING DIVISION
2400 CURTIS STREET
DOWNERS GROVE, ILLINOIS 60515

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

97928 LITTON FASTENING SYSTEMS DIV OF LITTON SYSTEMS INC
3969 PARAMONT BOULEVARD
LAKEWOOD, CALIFORNIA 90712



Rudder Actuator Link Assembly
Figure 1 (Sheet 1)



Rudder Actuator Link Assembly
Figure 1 (Sheet 2)

T72723

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-1	252T3100-3		LINK ASSY-RUD ACTR	A	RF
1A	252T3100-5		LINK ASSY-RUD ACTR	B	RF
5	BACB30LT10-30		.BOLT		1
10	BACW10BP10ACU		.WASHER		1
15	BR1110C10M		.NUT-		1
			(V52828)		
			(SPEC BACN10JC10CM)		
			(OPT BMN4122C1D2-10 (V08524))		
			(OPT BMN4122C1D3-10 (V08524))		
			(OPT H01-10BAC (V15653))		
			(OPT 109LH9074-10 (V72962))		
			(OPT 69235-1018CM (V56878))		
20	BACB28AK10-041		.BUSHING		1
25	252T3171-1		.LINK		1
			ATTACHING PARTS		
30	AN960C1216		.WASHER		1
35	NAS1804-12		.NUT		1
			-------*-------		
40	DMD10-12C1-501		.ROD END		1
			(V77896)		
			(SPEC SO12T236-5)		
			(OPT ITEM 40A)		
40A	DMD10-12C1-502		.ROD END		1
			(V77896)		
			(SPEC SO12T236-17)		
			(OPT ITEM 40)		
45	DMD14-16A1-501		.ROD END		1
			(V77896)		
			(SPEC SO12T236-4)		
			(OPT ITEM 45A)		
45A	DMD14-16A1-502		.ROD END		1
			(V77896)		
			(SPEC SO12T236-16)		
			(OPT ITEM 45)		

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
50	BACW10BP16		DELETED		
50A	BACW10BP16DP		.WASHER		1
55	NAS1804-16		.NUT-		1
			(OPT ITEM 55A)		
-55A	BACN10GW162		.NUT-		1
			(OPT ITEM 55)		
60	BACB30LE7-32		DELETED		
60A	BACB30LE7-36		BOLT		2
65	AN960PD716		DELETED		
65A	BACW10BP7CD		.WASHER		2
70	HL40-8-40		DELETED		
70A	BACB30NR4K43		.BOLT		2
75	HL97PB8		DELETED		
76	AN960XC416L		.WASHER		2
78	BACN10JC4CM		.NUT		2
80	252T3154-1		.CAP	A	2
80A	252T3154-2		.CAP	B	2
			(OPT ITEM 80B)		
80B	252T3154-3		.CAP	B	2
			(OPT ITEM 80A)		
85	252T3111-1		.LINK ASSY		1
			(OPT ITEM 85A)		
85A	252T3111-6		.LINK ASSY		1
			(OPT ITEM 85)		
95	252T3131-2		..BUSHING		2
			(USED ON ITEM 85)		
95A	252T3131-4		..BUSHING		2
			(USED ON ITEM 85A)		
110	252T3131-1		..BUSHING		2
			(USED ON ITEM 85)		
110A	252T3131-3		..BUSHING		2
			(USED ON ITEM 85A)		
115	252T3151-1		DELETED		
115A	252T3151-2		..CAP		1
117	252T3170-1		DELETED		
117A	252T3170-4		..LINK ASSY		1
			(USED ON ITEM 85)		
-117B	252T3170-6		..LINK ASSY		1
			(USED ON ITEM 85A)		
118	NAS607-3-4P		...PIN-STRAIGHT		1
119	MS21209F7-15L		...INSERT		2
119H	252T3170-5		...LINK		1
			(USED ON ITEM 117A)		

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
119J	252T3170-7		...LINK (USED ON ITEM 117B)		1
120	MS15720-1		.FITTING - LUBRICATION		1
122	MS15004-3		.FITTING - LUBRICATION		1
125	252T3172-1		.TRUNNION ASSY		1
130	BACB28AP10P023		..BUSHING		1
135	MS21209F7-15L		..INSERT		4
140	252T3172-2		..TRUNNION		1