TO: ALL HOLDERS OF TRAILING EDGE FLAP DRIVE CONTROL UNIT ASSEMBLY COMPONENT MAINTENANCE MANUAL 27-51-16

REVISION NO. 6 DATED NOV 01/05

HIGHLIGHTS

All data formerly in manual 27-51-15 is included in this manual 27-51-16.

CHAPTER/SECTION AND PAGE NO.	DESCRIPTION OF CHANGE
TITLE PAGE 1	Added assembly 250T1008-4, made by rework of 256T3160-4 per SB 767-27-0080.
TR & SB RECORD 1 302 1011	
REPAIR-GEN 601	Edited without technical change.
REPAIR-GEN 602-603	Updated the True Position Dimensioning symbols.
1002-1009,1013-1021	Updated the Illustrated Parts List.
1012	Added details of the marker to the illustration.

COMPONENT
MAINTENANCE MANUAL

TRAILING EDGE FLAP DRIVE
POWER CONTROL UNIT ASSEMBLY

PART NUMBERS 256T3160-2,-4,-5
250T1008-4

COMPONENT MAINTENANCE MANUAL
WITH
ILLUSTRATED PARTS LIST

24228

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
767-27-0080		PRR B10298 PRR 11528	JAN 10/82 OCT 10/86 NOV 01/05

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1001	OCT 01/87	01
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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	Jan 26/83
Assembly	Jan 26/83

TRAILING EDGE FLAP DRIVE CONTROL UNIT ASSEMBLY

DESCRIPTION AND OPERATION

1. The trailing edge flap drive control unit assembly consists of an input cam, a follow-up cam and a summing lever housed in an aluminum alloy housing, and a cover.

2. Input signals from the pilot rotate the input cam which positions the valve input shaft to apply hydraulic pressure to the flap drive motor. As the flap reaches the selected position, the follow-up cam rotates changing the position of the valve input shaft and stopping hydraulic fluid flow.

3. Leading Particulars (Approximate)

   Width -- 11 inches
   Depth -- 9 inches
   Height -- 12 inches
   Weight -- 18 pounds

DISASSEMBLY

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

1. Parts Replacement (IPL Fig. 1)

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

   A. Gasket (45)

   B. Bolts (170, 195), collars (175, 200)

2. Disassembly (IPL Fig. 1)

   A. Remove cover (40) and gasket (45) by removing screws (30) and washers (35).

   B. For PCU assembly 256T3160-1

      (1) Remove the bolts (5), washers (10), and nuts (15) and remove the arms (25) from the input shaft (135) and the shaft (270).

   C. For PCU assembly 256T3160-4, -5

      (1) Remove the bolt (5A) and collar (17) and remove the arm (20) from the input shaft (135).

      (2) Remove the bolt (5), washer (10), and nut (15) and remove the arm (25) from the shaft (270).

   D. Remove bolts (55), washers (60) and remove housing cover assembly (50) by pulling straight out of housing assembly (90).

   E. Removal of parts from housing assembly (90).

      (1) Deleted

      (2) Remove nuts (260), washers (255), spacers (267), bolts (250) and spring (265) from housing assembly (90) and shaft (270).

      (3) Pull shaft (270) and attached summing lever (325) straight out of housing assembly (90).

      (4) Remove bolt (235), bushing (240), washer (245) and nut (260) and separate summing lever (325) from shaft (270).

      (5) Remove bearings (305) and spacer (310) from summing lever (325).

(6) Remove nuts (225), washers (230) and remove cam followers (220) from summing lever (325). Remove bearings (305, 315).

(7) Restrain cam assembly (190) and remove nut (140), washer (145). Push cam assembly (190) out of housing assembly (90) and remove bearings (150) and spacer (160).

(8) Remove bolts (195) and collars (200) and separate cam (215) from shaft (210).

NOTE: Do not remove plug (205) from shaft (210) unless necessary for repair or replacement.

(9) Remove input shaft (135) and attached sector gear (130) from housing (90). Separate sector gear (130), spacer (137) from input shaft (135).

(10) Remove bearings (120, 315) from housing (90).

NOTE: Do not disassemble housing assembly (90) unless necessary for repair or replacement.

Do not remove nameplate (330) from housing assembly (90) unless necessary for repair or replacement.

Do not remove the bolts (87) and collars (88) from the housing assembly (90A) unless necessary for repair or replacement.

(11) Remove drain cover (85) by removing parts (75, 80).

F. Restrain cam assembly (165) and remove nut (140), washer (145). Push cam assembly (165) out of housing cover assembly (50) and remove bearings (150) and spacer (155).

G. Separate cam (185) from shaft (180) by removing bolt (170) and collar (175).

H. Remove bearings (120, 320) from housing cover assembly (50).

NOTE: Do not disassemble housing cover assembly (50) unless necessary for repair or replacement.

CLEANING

1. Clean all parts except teflon sealed bearings using standard industry practices and information contained in 20-30-03.

2. Clean teflon sealed bearings per manufacturer's recommended procedures.

CHECK

1. Check all parts for obvious defects in accordance with standard industry practices. Refer to FITS AND CLEARANCES for design dimensions and wear limits.

2. Penetrant check per 20-20-02 the following listed parts:

   A. Pilot input arm (20, IPL Fig. 1)

   B. Arm (24)

   C. Housing (115)

   D. Housing cover (70)

   E. Drain cover (85)

   F. Input sector gear (130)

   G. Valve input arm (25)

   H. Spacer (137)

   I. Shafts (180, 210)

   J. Srping (26)

3. Magnetic particle check per 20-20-01 the following listed parts:

   A. Cams (185, 215)

   B. Input shaft (135)

   C. Cam follower (220)

   D. Summing lever (325)

   E. Shaft (270)

4. Check spring (265):

   A. Extend spring to 5.15-5.17 inches. Check that load is 7.01-8.57 pounds.

   B. Extend spring to 6.59-6.61 inches. Check that load is 12.37-15.11 pounds.

REPAIR - GENERAL

1. Content

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

P/N	NAME	REPAIR
256T3161	HOUSING	1-1
256T3163	COVER, HOUSING	2-1
256T3187	SHAFT	3-1
256T3173	CAM FOLLOWER	4-1
65B81978	COVER	5-1
- - -	MISC PARTS REFINISH	6-1

2. Standard Practices

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

B. 20-10-01 Repair and Refinish of High Strength Steel Parts
20-10-04 Grinding of Chrome Plated Parts
20-11-03 Repair of Electrical Terminations and Electrical Bonding Areas
20-30-02 Stripping of Protective Finishes
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

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 the 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

HOUSING ASSEMBLY - REPAIR 1-1

256T3161-7, -18, -20

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

1. Bushing Replacement (Fig. 601)

A. For bushing (105):

(1) Remove the damaged bushing (105) from the housing assembly (90).

(2) Prepare the housing and bushing surfaces for electrical bonding per 20-11-03. The total resistance across the bond is 0.0005 ohm maximum.

(3) Install the new bushing (105) on the housing assembly (90) per SOPM 20-50-03. Use the shrink-fit method. Do not apply finish to the hole and do not install the bushing with grease.

(4) Machine the inside diameter of the bushing (105) to the dimension specified in Fig. 601.

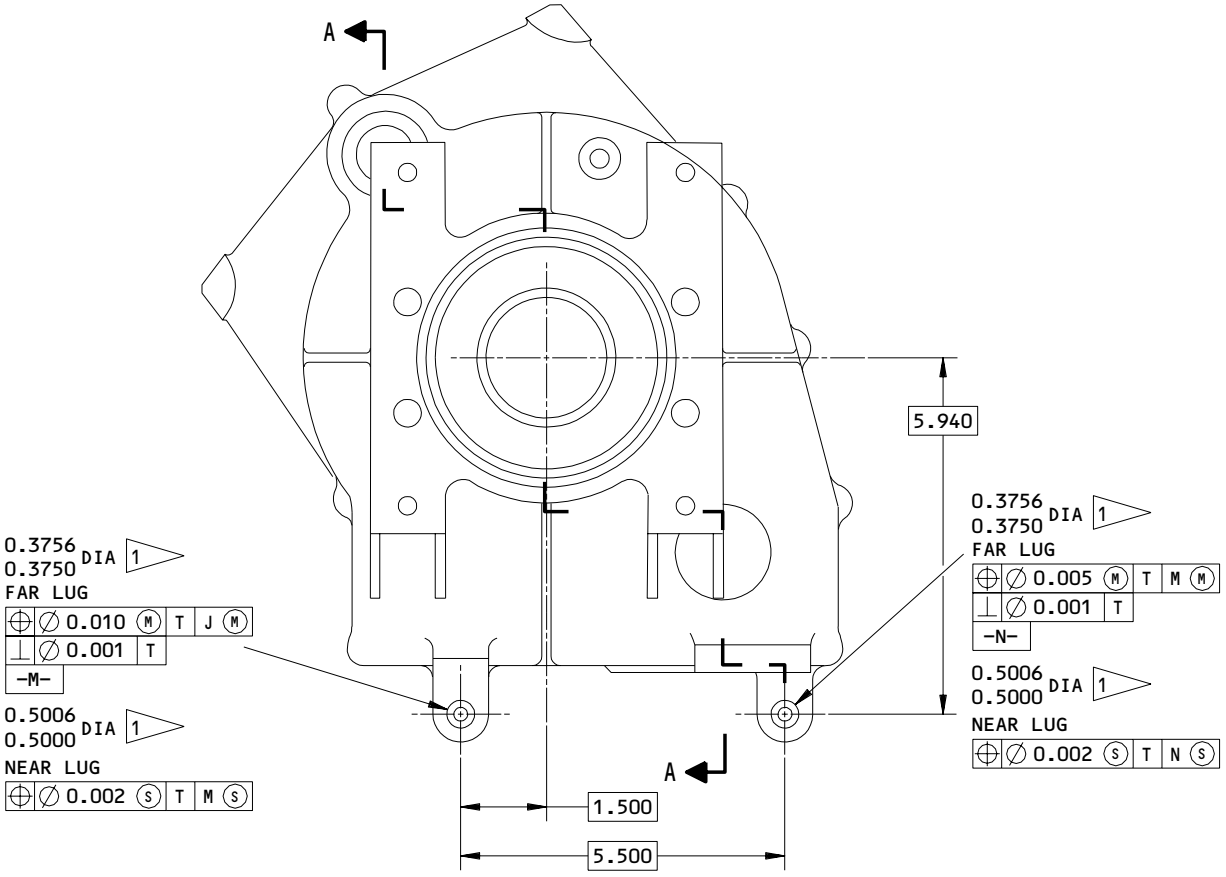
(5) Fillet seal the bushing flange and bushing end with BMS 5-26 sealant SOPM 20-50-19.

B. For bushing (110):

(1) Remove the damaged bushing (110) from the housing assembly (90).

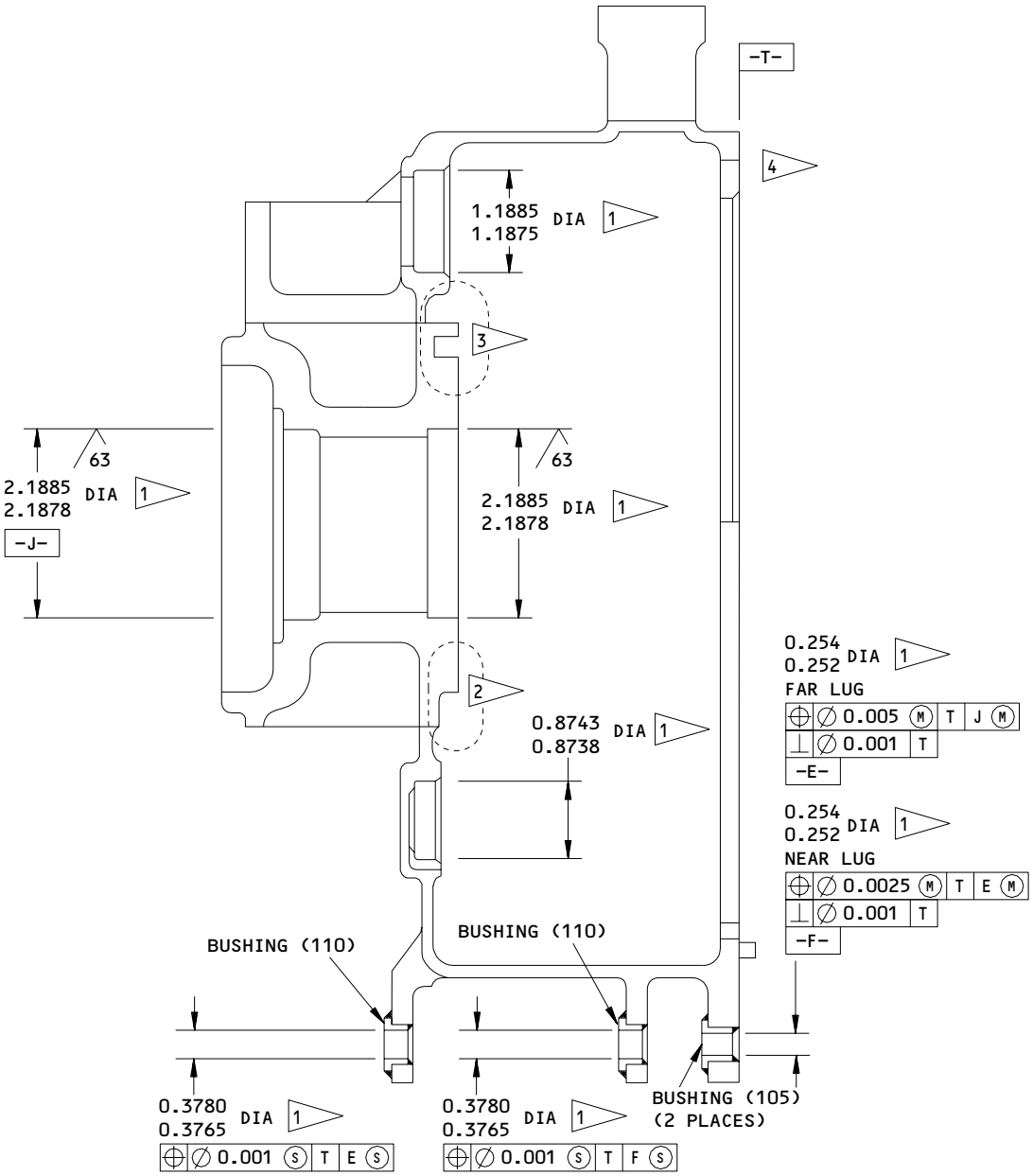
(2) Install the new bushing (110) on the housing assembly (90) with BMS 5-95 sealant per SOPM 20-50-03. Use the shrink-fit method.

(3) Machine the inside diameter of the bushing (110) to the dimension specified in Fig. 601.



256T3161-7,-18,-20
Bushing Replacement and Housing Refinish
Figure 601 (Sheet 1)

91052



REFINISH

HOUSING (90) – ANODIZE (F-17.05) AND APPLY 1 COAT OF BMS 10-11, TYPE 1 PRIMER (F-20.02) ALL OVER EXCEPT AS NOTED IN 1

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

1 OMIT PRIMER THIS DIAMETER

2 256T3161-7,-18 ONLY (2 PLACES)

3 256T3161-20 ONLY (2 PLACES)

4 OMIT PRIMER ON MATING SURFACE FOR COVER

256T3161-7,-18,-20

Bushing Replacement and Housing Refinish
Figure 601 (Sheet 2)

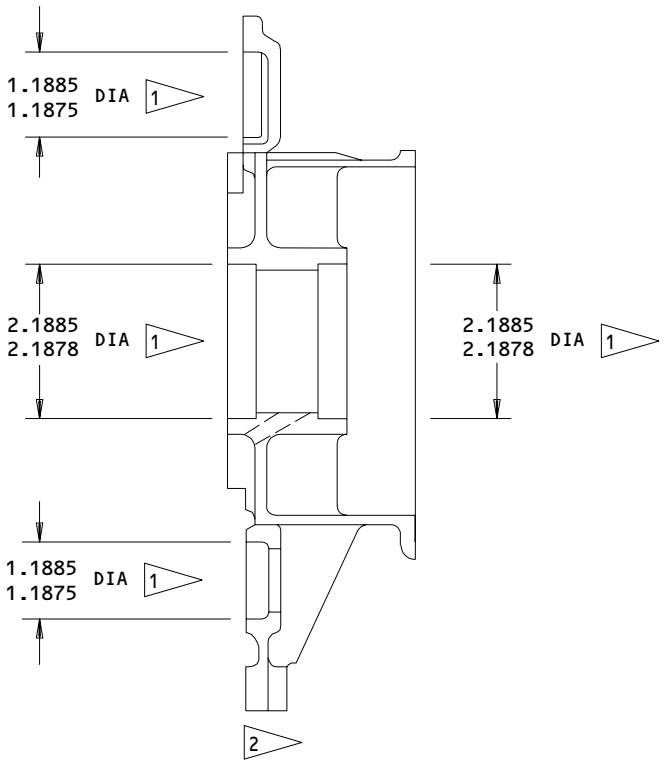
24233

COVER, HOUSING - REPAIR 2-1

256T3163-1

1. Plating Repair

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



REFINISH

ANODIZE (F-17.05) ALL OVER AND APPLY 1 COAT OF BMS 10-11, TYPE 1 PRIMER (F-20.02) EXCEPT AS NOTED IN 1.

1 NO PRIMER THIS SURFACE

2 NO PRIMER ON MATING SURFACE FOR HOUSING

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

Housing Cover Repair and Refinish
Figure 601

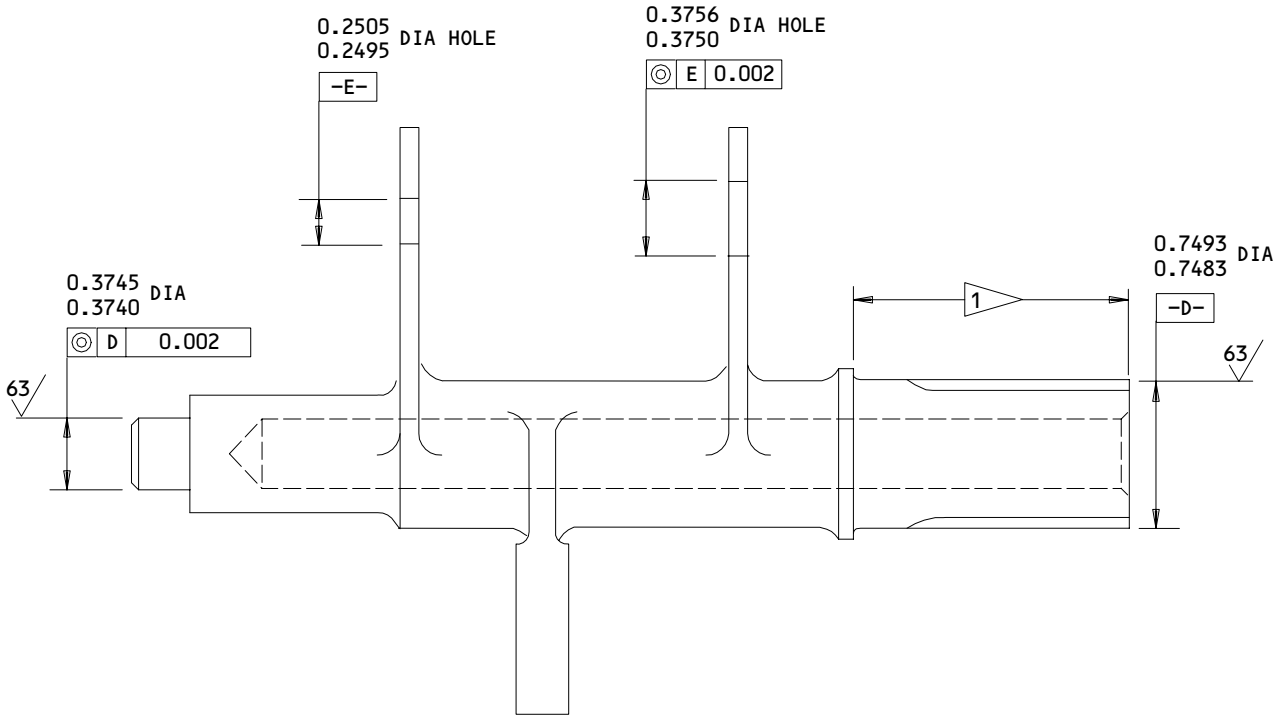
24235

SHAFT - REPAIR 3-1

256T3187-1

1. Plating Repair

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



REFINISH

PASSIVATE (F-17.09) ALL OVER AND CADMIUM PLATE (F-15.25) AREA INDICATED IN 1

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

ALL DIMENSIONS ARE IN INCHES

Shaft Refinish
Figure 601

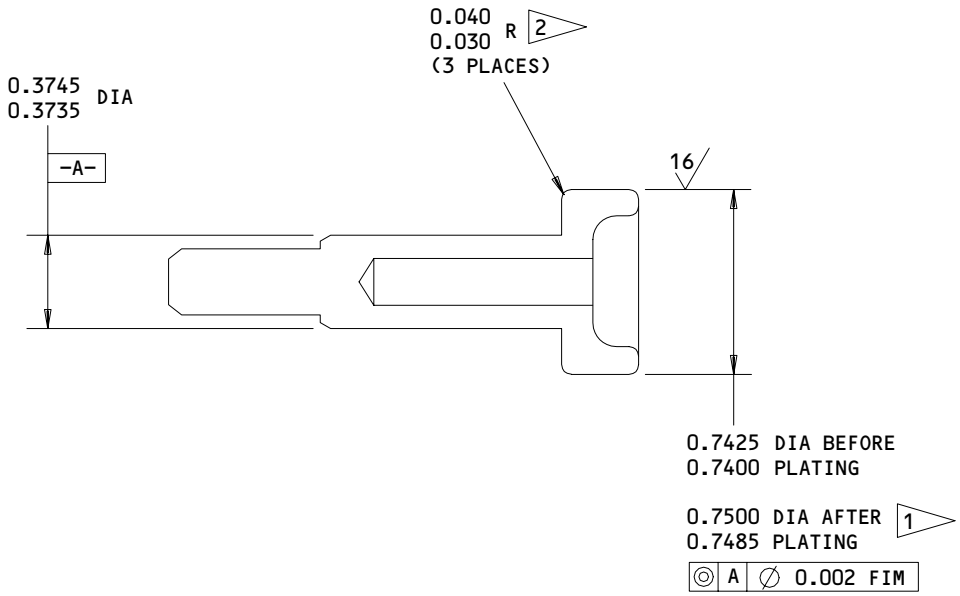
24236

FOLLOWER, CAM - REPAIR 4-1

256T3173-1

1. Plating Repair

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



REFINISH

PASSIVATE (F-17.09) EXCEPT AS NOTED

MATERIAL: 15-5PH CRES, 150-170 KSI

ALL DIMENSIONS ARE IN INCHES

1 CHROME PLATE (F-15.03) 0.003 MIN AFTER GRINDING

2 CHROME PLATE TO RUNOUT AROUND EDGE RADIUS

Cam Follower Refinish
Figure 601

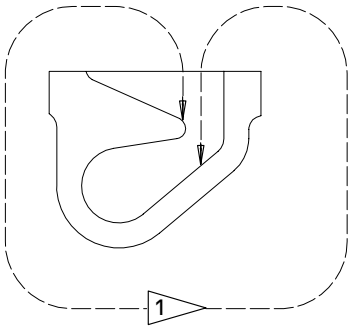
24237

COVER, DRAIN - REPAIR 5-1

65B81978-1, -4

1. Plating Repair

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



REFINISH

CHROMIC ACID ANODIZE (F-17.02) ALL OVER
AND APPLY 1 COAT OF BMS 10-11, TYPE 1 PRIMER
(F-20.02) TO SURFACES INDICATED BY 1

MATERIAL: AL ALLOY

Cover Repair
Figure 601

24238

MISCELLANEOUS PARTS REFINISH - REPAIR 6-1

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

IPL FIG. & ITEM	MATERIAL	FINISH
Fig. 1		
Arms (20,25)	Al alloy	Chromic acid anodize and apply one coat BMS 10-11, type 1 primer (F-18.13) all over except omit primer on spline.
Cover (40)	Al alloy	Chemical treat surfaces and apply one coat BMS 10-11, type 1 (F-18.06) plus apply one coat BMS 10-11, type 1 primer (F-20.02) all over.
Cam (185,215)	15-5PH CRES, 180-200 ksi	Cadmium plate (F-15.06) in 1.4370-1.4375 diameter bore only, plate thickness 0.0002-0.0004 inch. Passivate (F-17.09) all other surfaces.
Shaft (180,210)	Al alloy	Chromic acid anodize (F-17.04).
Summing lever (325)	15-5PH CRES	Passivate (F-17.09).
Gear (130)	Al alloy	Chromic acid anodize and apply one coat BMS 10-11, type 1 primer (F-18.13) except omit primer on gear and spline.
Input shaft (135)	15-5PH CRES, 150-170 ksi	Passivate (F-17.09) all interior surfaces and cadmium plate (F-15.25) on all exterior surfaces.

Refinish Details
Figure 601

ASSEMBLY

1. Materials

NOTE: Equivalent substitutes may be used.

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

B. Grease -- MIL-G-23827 (Ref 20-60-03)

C. Adhesive -- Type 38 (Ref 20-50-12)

D. Adhesive -- Type 70 (Ref 20-50-12)

E. Sealant -- BMS 5-26 (Ref 20-60-04)

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

G. Primer -- BMS 10-11, type 1 (Ref 20-60-02)

2. Equipment

NOTE: Equivalent substitutes may be used.

A. Rigging Pins -- 0.250-inch diameter

B. Jig Assembly -- A27060-12

3. Assembly (IPL Fig. 1)

NOTE: Install bearings per 20-50-03. Install bearing (22) using BMS 5-95 sealant.

A. Install drain cover (85) on housing assembly (90) and secure with parts (75, 80).

B. Assemble cam (185) on shaft (180) with sealant on faying surfaces and secure with bolt (170) and collar (175). Install fasteners with wet primer. Fillet seal contact areas between cam and shaft with sealant.

C. Assemble cam (215) on shaft (210) with sealant on faying surfaces and secure with bolts (195) and collars (200). Install fasteners with wet primer. Fillet seal contact areas between cam and shaft with sealant.

D. Assemble summing lever (325).

(1) Apply a light coat of grease, MIL-G-23827 to bearings (305, 315) and install bearings on summing lever (325).

(2) Apply a light coat of grease, MIL-G-23827 to cam followers (220) and insert cam followers thru bearing installed in step (1). Secure cam followers with washers (230) and nuts (225).

(3) Apply a light coat of grease, MIL-G-23827 to bearings (305) and spacer (310) and install bearings (305) and spacer (310) on summing lever (325).

E. Position summing lever (325) on shaft (270) as shown in Fig. 701. Secure summing lever (325) to shaft (270) with bolt (235), bushing (240), washer (245) and nut (260). Install bolt (235) with bolthead direction as shown.

F. Assemble parts in housing cover assembly (50)

(1) Bond gasket (45) to housing cover assembly (50) per 20-50-12, type 38.

(2) Lightly coat bearings (120, 150, 320) with grease, MIL-G-23827 and install bearings and spacer (155) in housing cover assembly (50).

(3) Apply a light coat of grease, MIL-G-23827, to input cam assembly (165) and install in housing cover assembly (50). Install rigging pin to secure cam assembly (165).

(4) Apply a light film of grease MIL-G-23827 to threads of nut (140) and install nut and washer (145) on cam assembly (165). Tighten nut to contact without exceeding 5 pound-inches above self-locking torque.

(5) Remove rigging pin and check that cam assembly (165) rotates smoothly for two complete revolutions in either direction. Reinstall rigging pin and temporarily tape to housing cover assembly (50) to prevent cam assembly from rotating.

G. Assemble parts in housing assembly (90).

(1) Lightly coat bearings (120, 150, 315) with grease, MIL-G-23827 and install bearings and spacer (160) in housing assembly (90).

(2) Install follow-up cam assembly (190) in housing assembly (90) and install rigging pin to secure cam assembly (190).

(3) Apply a light film of grease, MIL-G-23827 to threads of nut (140) and install nut and washer (145) on cam assembly (190). Tighten nut to contact without exceeding 5 pound-inches above self-locking torque.

(4) Remove rigging pin and check that cam assembly (190) rotates smoothly for two complete revolution in either direction. Reinstall rigging pin and temporarily tape to housing assembly (90) to prevent cam assembly (190) from rotating.

(5) Position spring (265) on housing assembly (90) and shaft (270) and install spacers (267), washers (255), bolts (250) and nuts (260). Install fasteners with grease, BMS 3-24.

(6) Install shaft (270) with attached summing lever (325) on bearing (315) in housing assembly (40) with cam follower (220) engages slot in follow-up cam assembly (190).

(7) If cam follower (220) can not engage slot in follow-up cam assembly (190), the summing lever (325) is installed backward. Remove and reinstall summing lever (325).

(8) Apply a light film of grease, BMS 3-24 to shaft (135). Apply a light film of grease, MIL-G-23827 to splines of sector gear (130). Install sector gear (130) and spacer (137) on shaft (135).

(9) Install shaft (135) with attached parts thru bearing (120) in housing assembly (90).

(10) Apply grease, BMS 3-24 to splines of shaft (135) and arm (20). Install arm (20) on shaft (135) with matching bolt cut out.

(11) For PCU assembly 256T3160-2. Install the input arm (20, 20A) on the input shaft (135):

(a) Apply BMS 3-24 grease to the shank and threads of bolts (5).

(b) Install the bolt (5) thru the arm (20, 20A) in the direction shown in IPL Fig. 1.

(c) Secure the bolt (5) with washer (10) and nut (15).

(12) For PCU assembly 256T3160-4, -5. Install the input arm (20B) on the input shaft (135):

(a) Apply BMS 3-24 grease to the shank and threads of bolts (5A).

(b) Install the bolt (5A) thru the arm (20B) in the direction shown in IPL Fig. 1.

(c) Secure the bolt (5A) with collar (17).

(13) Check that summing lever (325) is in the position shown in Fig. 701 to ease further assembly.

(14) Locate arm (20) at position shown in Fig. 701 using jig assembly A27060-12, and secure arm in this position.

H. Apply grease, BMS 3-24 to bolt holes in housing assembly (90) and cover assembly (50).

I. Install cover assembly (50) with attached parts on housing assembly (90) with summing lever (325), arm (20) in position indicated and rigging pins fixing cam assembly (190) to housing assembly and cam assembly (165) to cover assembly. Secure with bolts (55), washers (60).

J. Apply grease BMS 3-24 to bolt hole of arm (25) and to all areas of bolt cutout on shaft (270) and to shank of bolt (5), faces of washer (10).

K. Install arm (25) on shaft (270) with matching bolt cutout on both arm and shaft. Install bolt (5), washer (10) and nut (15) thru cutout in arm and shaft. Install bolt with bolt direction shown in IPL Fig. 1.

L. Assembly check:

(1) Remove rigging pin on cover assembly only and rotate pilot input arm (20) manually thru an arc of 60 degrees clockwise when viewed as shown in Fig. 701 Sheet 1 and return. Maintain a hold back force to resist spring while returning the pilot arm to original position.

(2) Install rigging pin back on housing cover assembly (60) and remove rigging pin on housing assembly (90). Drive follow-up cam assembly (190) manually thru an arc of 298 degrees counterclockwise (viewing at housing assembly (90)) and return.

(3) Unit shall operate without binding in both directions.

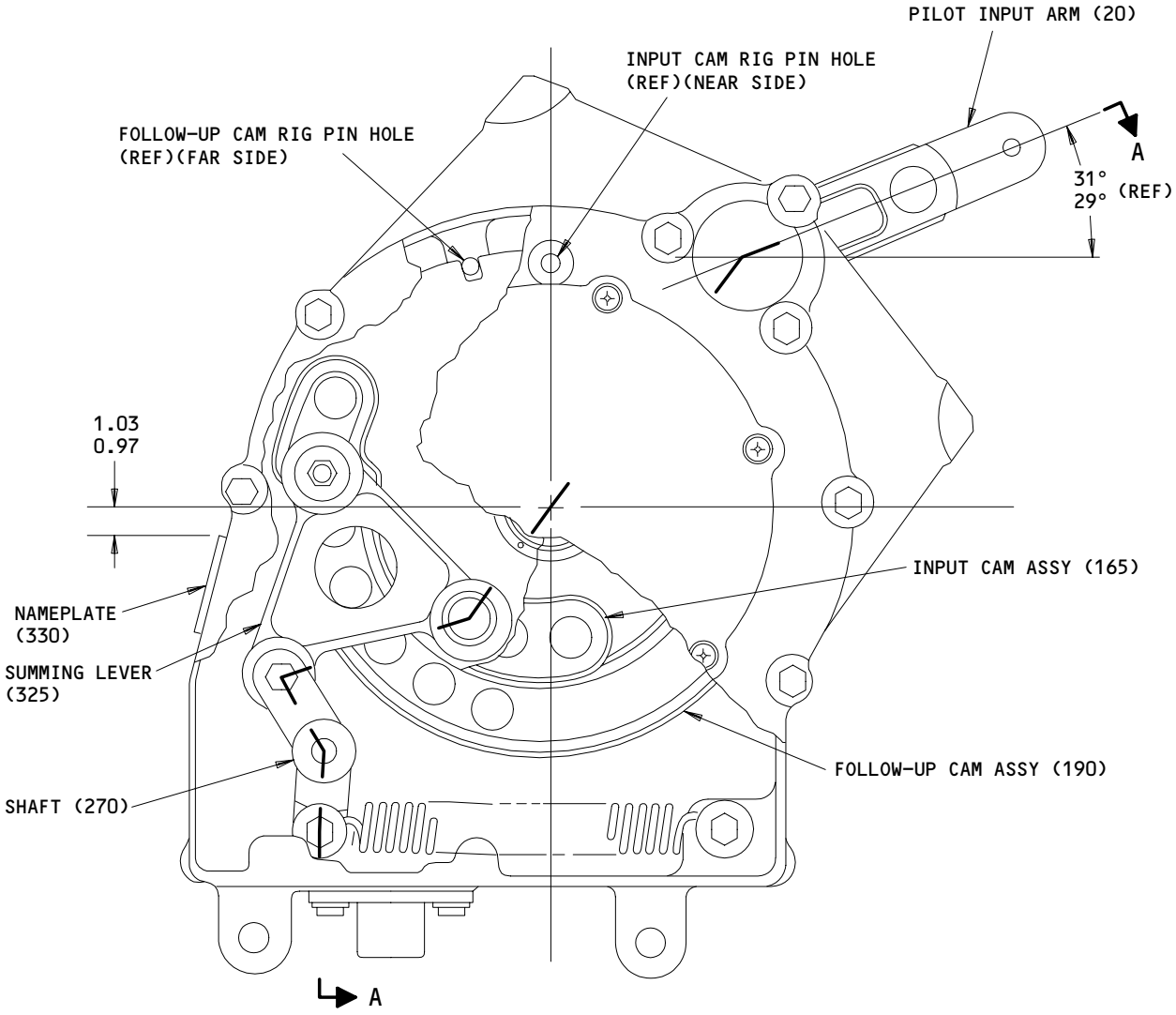
M. Apply grease, BMS 3-24 to screw (30) holes in housing cover assembly (60) and cover (40).

N. Install cover (40) on housing cover assembly (50) and secure with screws (30), washers (35).

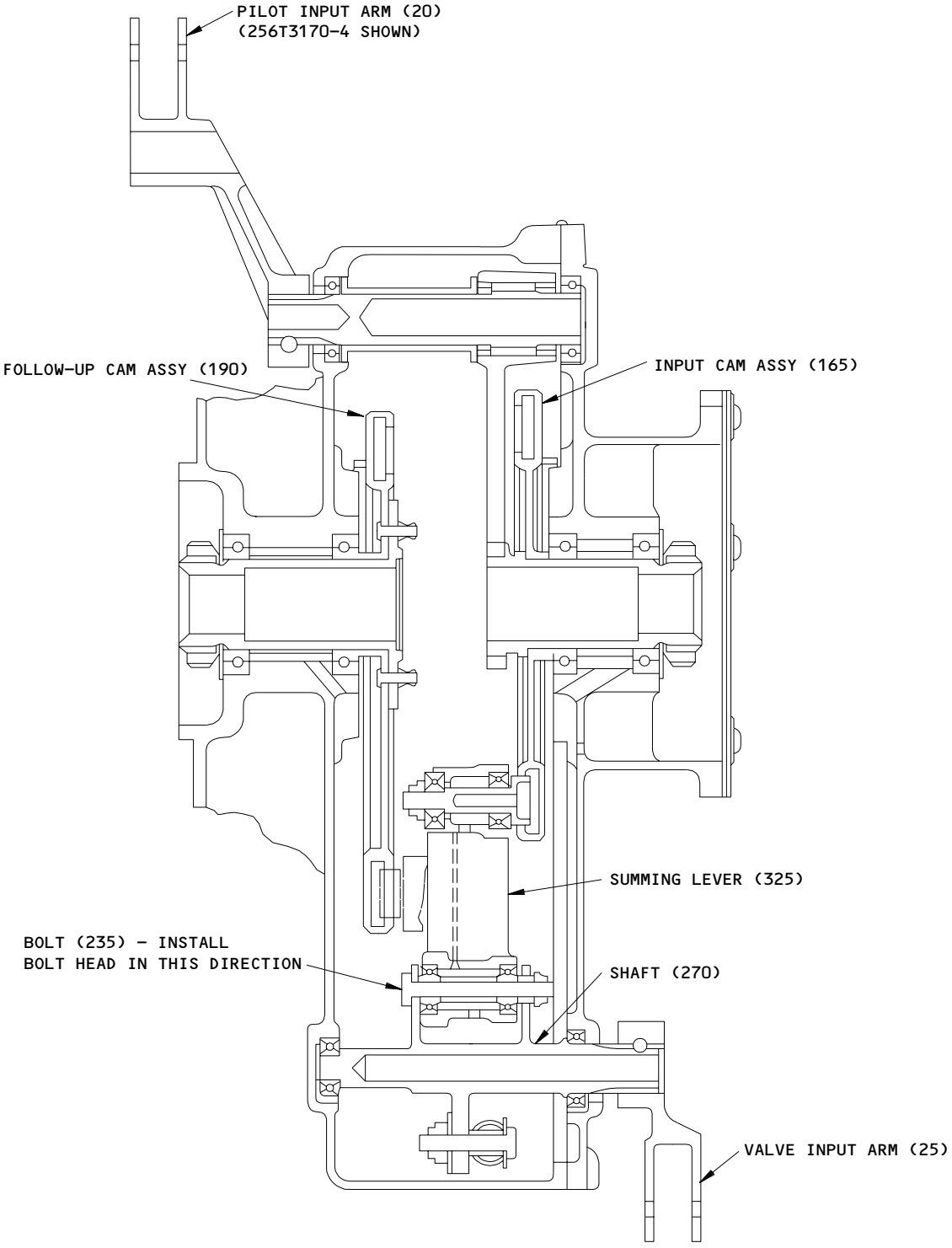
O. Apply sealant to contact areas between housing cover assembly (50) and housing assembly (90).

P. If removed, install nameplate (330) per dimension shown in Fig. 701, and bond per 20-50-12, type 70.

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

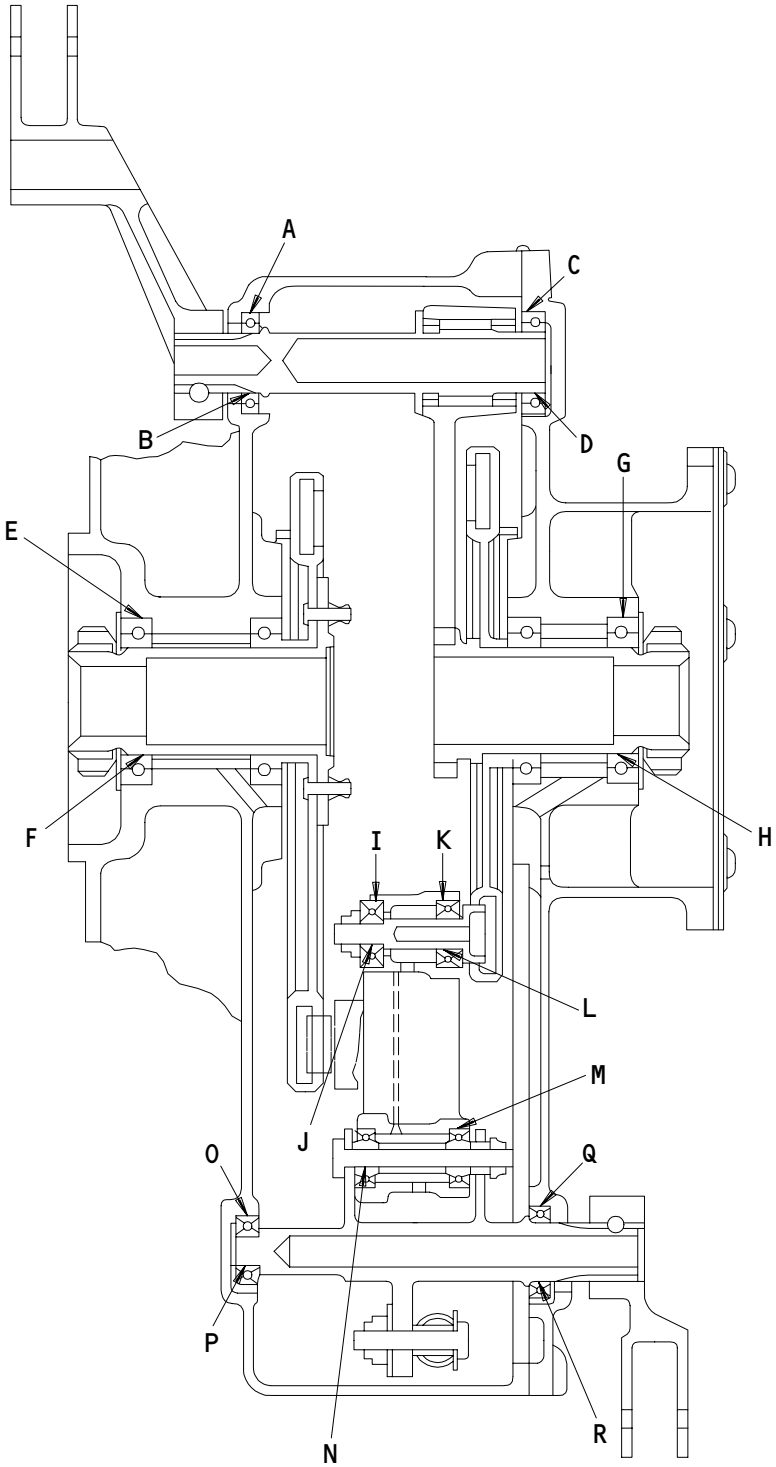


Assembly Details
Figure 701 (Sheet 1)



A-A

Assembly Details
Figure 701 (Sheet 2)



Fits and Clearances
Figure 801 (Sheet 1)

Ref Letter Fig.801	Mating Item No. IPL Fig.1	Design Dimension				Service Wear Limit		
		Dimension		Assembly Clearance		Dimension		Maximum Clearance
		Min	Max	Min	Max	Min	Max	
A	ID 90	1.1875	1.1885	0.0000	0.0020			
	OD 120	1.1865	1.1875					
B	ID 120	0.7493	0.7507	0.0000	0.0024			
	OD 135	0.7483	0.7493					
C	ID 70	1.1875	1.1885	0.0000	0.0020			
	OD 120	1.1865	1.1875					
D	ID 120	0.7493	0.7507	0.0000	0.0024			
	OD 135	0.7483	0.7493					
E	ID 90	2.1875	2.1885	0.0000	0.0020			
	OD 150	2.1865	2.1875					
F	ID 150	1.4370	1.4380	0.0000	0.0015			
	OD 210	1.4365	1.4370					
G	ID 70	2.1875	2.1885	0.0000	0.0020			
	OD 150	2.1865	2.1875					
H	ID 150	1.4370	1.4380	0.0000	0.0015			
	OD 180	1.4365	1.4370					
I	ID 325	0.7490	0.7495	-0.0010 *[1]	0.0000			
	OD 305	0.7495	0.7500					
J	ID 305	0.2495	0.2500	0.0000	0.0015			
	OD 220	0.2485	0.2495					

ALL DIMENSIONS ARE IN INCHES

Fits and Clearances
Figure 801 (Sheet 2)

Ref Letter Fig.801	Mating Item No. IPL Fig.		Design Dimension				Service Wear Limit		
			Dimension		Assembly Clearance		Dimension		Maximum Clearance
			Min	Max	Min	Max	Min	Max	
K	ID	325	0.8740	0.8745	-0.0010 *[1]	0.0000			
	OD	315	0.8745	0.8750					
L	ID	315	0.3745	0.3750	0.0000	0.0015			
	OD	220	0.3735	0.3745					
M	ID	325	0.7490	0.7495	-0.0010 *[1]	0.0000			
	OD	305	0.7495	0.7500					
N	ID	305	0.2495	0.2500	0.0000	0.0015			
	OD	235	0.2485	0.2495					
O	ID	90	0.8738	0.8743	-0.0012 *[1]	-0.0002 *[1]			
	OD	315	0.8745	0.8750					
P	ID	315	0.3745	0.3750	0.0000	0.0010			
	OD	270	0.3740	0.3745					
Q	ID	70	1.1875	1.1885	0.0000	0.0020			
	OD	320	1.1865	1.1875					
R	ID	320	0.7493	0.7500	0.0000	0.0017			
	OD	270	0.7483	0.7493					

*[1] INTERFERENCE FIT

ALL DIMENSIONS ARE IN INCHES

Fits and Clearances
Figure 801 (Sheet 3)

FOR TORQUE VALUE OF STANDARD FASTENERS, REFER TO 20-50-01			
ITEM NO. IPL FIG. 1	NAME	TORQUE	
		POUND-INCHES	POUND-FEET
140	Nut	5 *[1]	

*[1] ABOVE SELF-LOCKING TORQUE OF NUT

Torque Table
Figure 802

SPECIAL TOOLS, FIXTURES AND EQUIPMENT

NOTE: Equivalent substitutes may be used.

1. Jig Assembly -- A27060-12 (supersedes A27060-3)

2. Rigging Pin -- 0.250 inch diameter (2 required).

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

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

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 BEARING CORP
10 FAIRVIEW AVENUE PO BOX 1191
POUGHKEEPSIE, NEW YORK 12601-1312
FORMERLY FEDERAL BRG CO AND SCHATZ MFG CO V53268
FORMERLY SCHATZ MFG CO

VENDORS

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 ALCOA GLOBAL FASTENERS INC, DIV OF VOI-SHAN PRODUCTS
3000 W LOMITA BLVD
TORRANCE, CALIFORNIA 90505-5103
FORMERLY FAIRCHILD INC INC FAIRCHILD AEROSPACE FASTENERS DIV

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

VENDORS

72962 HARVARD INDUSTRIES INC
3 WERNER WAY SUITE 210
LEBANON, NEW JERSEY 08833
FORMERLY ESNA V7A079
FORMERLY ELASTIC STOP NUT IN UNION, NJ

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

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

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

97393 SHUR-LOK CORPORATION
2541 WHITE ROAD PO BOX 19584
IRVINE, CALIFORNIA 92623-9584
FORMERLY SHUR LOK CORP VB0060
FORMERLY IN SANTA ANA, CALIFORNIA 92714

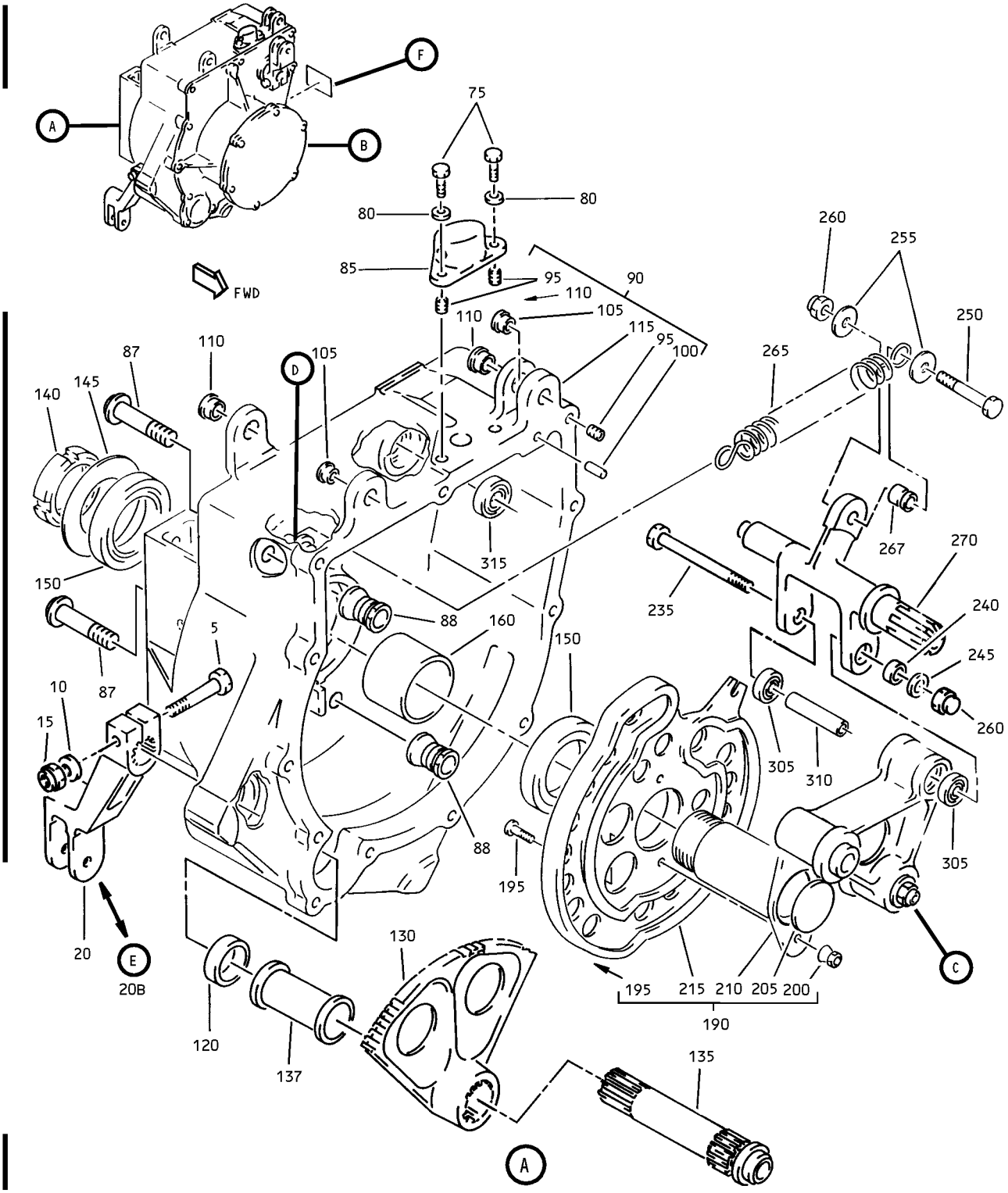
PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
AN960-10		1	80	2
AN960-10L		1	35	6
AN960D10		1	60	12
AN960D416L		1	10	2
		1	245	1
BACB10BW23		1	150	4
BACB10BX4		1	305	4
BACB10BX6		1	315	3
BACB10CF12PP		1	120	2
		1	320	1
BACB28AK04-025		1	240	1
BACB28AK04-089		1	310	1
BACB28AP04P032		1	105	2
BACB28W6B022		1	110	2
BACB30MY5K3		1	87	2
BACB30MY6K4		1	170	1
		1	195	2
BACB30TZ8K18		1	5A	1
BACC30BE8		1	17	1
BACC30M5		1	88	2
BACC30M6		1	175	1
		1	200	2
BACN10JC4		1	15	2
		1	225	2
		1	260	3
BACN10RF22		1	140	2
BACW10P11AL		1	255	4
BACW10P231D		1	230	2
BAC27ECT58		1	330A	1
BAC27TCT0002		1	330	1
BRH10A4		1	15	2
		1	225	2
		1	260	3
BR9080-22		1	140	2
B539-2TS		1	120	2
		1	320	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
B539DD		1	120	2
		1	320	1
B539DDFS101		1	120	2
		1	320	1
B539DDFS428		1	120	2
		1	320	1
B539DDNJC		1	120	2
		1	320	1
B539DDP		1	120	2
B539DDP		1	320	1
B539FS101		1	120	2
		1	320	1
B539SSG27		1	120	2
		1	320	1
CS204E		1	305	4
CS206E		1	315	3
HL70-5		1	88	2
HL79-6		1	175	1
		1	200	2
H10-4BAC		1	15	2
		1	225	2
		1	260	3
KP23B		1	150	4
KP4A		1	305	4
KP4AFS428		1	305	4
KP4AG27		1	305	4
KP4ALY196		1	305	4
KP4ANJC		1	305	4
KP4ASD610		1	305	4
KP4A2TS		1	305	4
KP6A		1	315	3
KP6AFS428		1	315	3

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
KP6AG27		1	315	3
KP6ANJC		1	315	3
KP6A2TS		1	315	3
KP6BLY196		1	315	3
KP6BSD610		1	315	3
LLKP23B		1	150	4
LLKP4A		1	305	4
LLKP6A		1	315	3
MS21209F1-15		1	65	12
		1	95	14
MS27643-4G		1	22	1
NAS603-8		1	30	6
NAS607-3-4P		1	100	1
NAS6603-3		1	75	2
NAS6604-11		1	250	2
NAS6604-18		1	5	2
NAS6604-29		1	235	1
NAS6703-3		1	55	12
NS202101-048		1	15	2
		1	225	2
		1	260	3
RMLH9075-4W		1	15	2
		1	225	2
		1	260	3
SL2822-22		1	140	2
T339E		1	120	2
		1	320	1
T6S428J		1	15	2
		1	225	2
		1	260	3
VN303A048		1	15	2
		1	225	2
		1	260	3
2SC3C08		1	17	1
256T1008-4		1	1C	RF
256T2689-2		1	45	1
256T2690-2		1	40	1
256T3106-1		1	215C	1
256T3160-2		1	1	RF
256T3160-4		1	1A	RF
256T3160-5		1	1B	RF
256T3161-17		1	115A	1
256T3161-18		1	90A	1

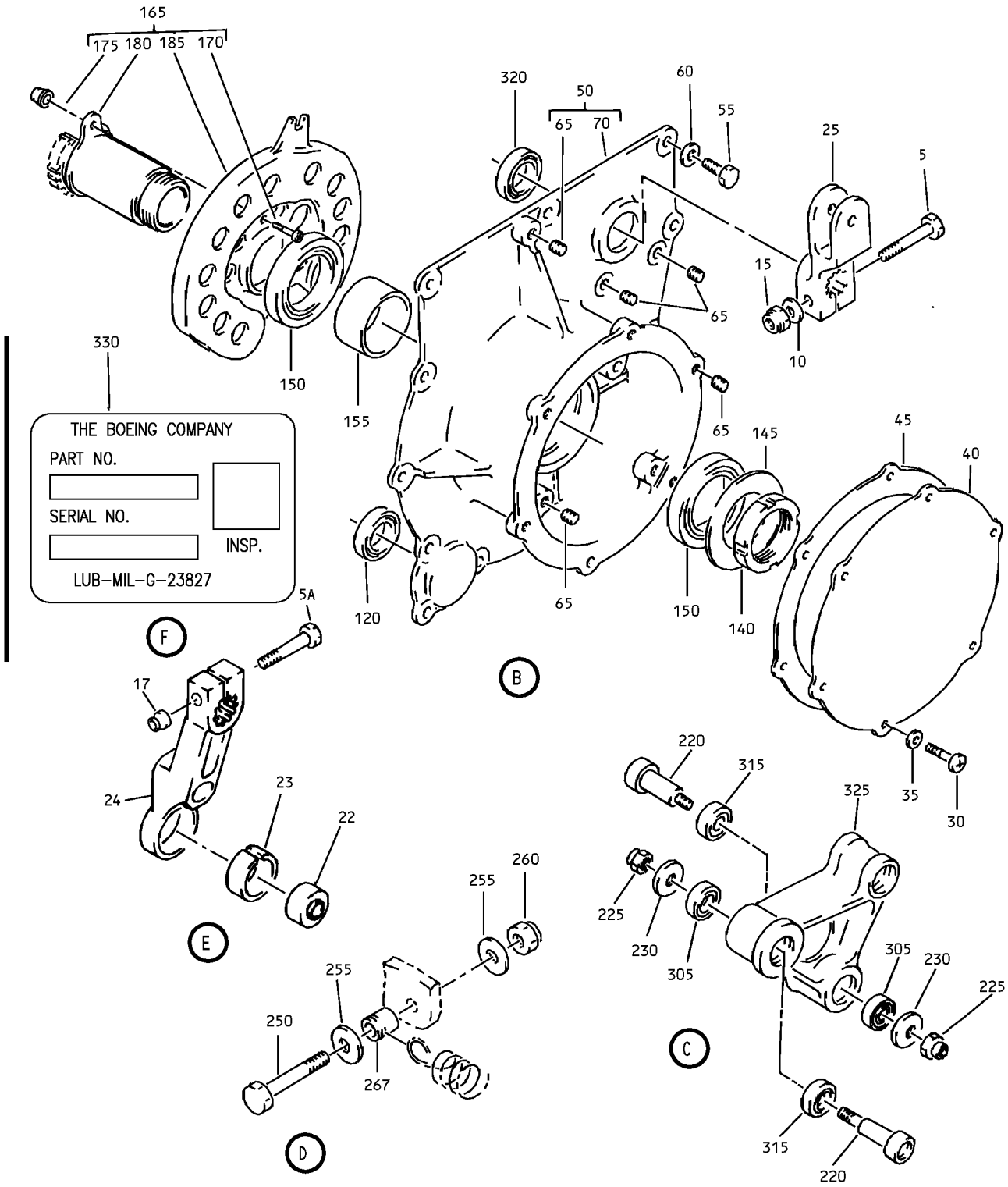
PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
256T3161-19		1	115B	1
256T3161-20		1	90B	1
256T3161-7		1	90	1
256T3161-8		1	115	1
256T3163-1		1	50	1
256T3163-2		1	70	1
256T3165-2		1	165	1
256T3166-1		1	185	1
256T3167-1		1	180	1
256T3168-4		1	135	1
256T3169-1		1	130	1
256T3169-3		1	130A	1
256T3170-4		1	20	1
256T3170-5		1	20A	1
256T3173-1		1	220	2
256T3177-1		1	25	1
256T3177-3		1	25A	1
256T3178-1		1	265	1
256T3179-1		1	155	1
256T3179-2		1	160	1
256T3180-1		1	145	2
256T3181-3		1	190	1
256T3181-6		1	190A	1
256T3181-7		1	190B	1
256T3182-1		1	215	1
256T3183-1		1	210	1
256T3184-2		1	267	2
256T3185-1		1	137	1
256T3186-1		1	205	1
256T3187-1		1	270	1
256T3188-1		1	325	1
256T3189-1		1	270A	1
256T3190-1		1	325A	1
256T3191-1		1	215A	1
256T3192-1		1	20B	1
256T3192-2		1	24	1
256T3192-4		1	24A	1
256T3194-1		1	215B	1
65B81978-1		1	85	1
65B81978-4		1	85A	1
66014-5		1	88	2
66014-6		1	175	1
		1	200	2
69-38919-48		1	23	1
82631-2212		1	140	2

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
96-048		1	15	2
		1	225	2
		1	260	3



Trailing Edge Flap Drive Power Control Unit Assembly
Figure 1 (Sheet 1)

T58295



Trailing Edge Flap Drive Power Control Unit Assembly
Figure 1 (Sheet 2)

T58296

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	-1	256T3160-2		UNIT ASSY-TE FLAP DRIVE CONT	A	RF
	-1A	256T3160-4		UNIT ASSY-TE FLAP DRIVE CONT (PRE SB 767-27-0080)	B	RF
	-1B	256T3160-5		UNIT ASSY-TE FLAP DRIVE CONT	C	RF
R	-1C	256T1008-4		HOUSING ASSY- (POST SB 767-27-0080)	D	RF
	5	NAS6604-18		.BOLT	A	2
	5A	BACB30TZ8K18		.BOLT	B-D	1
	10	AN960D416L		.WASHER		2
	15	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	2
	17	2SC3C08		.COLLAR- (V17446) (SPEC BACC30BE8) (OPT 2SC3C08 (V92215))	B-D	1
	20	256T3170-4		.ARM-INPUT (OPT ITEM 20A)	A	1
	-20A	256T3170-5		.ARM-INPUT (OPT ITEM 20)	A	1
	20B	256T3192-1		.ARM ASSY-INPUT	B-D	1
	22	MS27643-4G		..BEARING	B-D	1
	23	69-38919-48		..SLEEVE- (MFD FROM SH AL QQ-A-250/11 F25.01 .005SF .063IN X .593IN X 3.14 IN)	B-D	1
	24	256T3192-2		..ARM- (OPT ITEM 024A)	B-D	1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	-24A	256T3192-4		..ARM-	B-D	1
				(OPT ITEM 024)		
	25	256T3177-1		.ARM-VALVE INPUT		1
				(OPT ITEM 25A)		
	-25A	256T3177-3		.ARM-VALVE INPUT		1
				(OPT ITEM 25)		
	30	NAS603-8		.SCREW		6
	35	AN960-10L		.WASHER		6
	40	256T2690-2		.COVER		1
	45	256T2689-2		.GASKET		1
	50	256T3163-1		.COVER ASSY-HSG		1
				ATTACHING PARTS		
	55	NAS6703-3		.BOLT		12
	60	AN960D10		.WASHER		12
				-------*-------		
	65	MS21209F1-15		..INSERT		12
	70	256T3163-2		..COVER		1
	75	NAS6603-3		.BOLT		2
	80	AN960-10		.WASHER		2
	85	65B81978-1		.COVER-DRAIN		1
				(OPT ITEM 85A)		
	-85A	65B81978-4		.COVER-DRAIN		1
				(OPT ITEM 85)		
R	87	BACB30MY5K3		.BOLT-	D	2
				(POST SB 767-27-0080)		
R	88	HL70-5		.COLLAR-	D	2
				(V5M902)		
				(SPEC BACC30M5)		
				(OPT HL70-5		
				(V73197))		
				(OPT HL70-5		
				(V92215))		
				(OPT 66014-5		
				(V56878))		
				(OPT HL70-5		
				(V56878))		
				(POST SB 767-27-0080)		

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	90	256T3161-7		.HOUSING ASSY	A	1
	-90A	256T3161-18		.HOUSING ASSY	B,D	1
	-90B	256T3161-20		.HOUSING ASSY	C	1
R	95	MS21209F1-15		..INSERT		14
	96	MS21209F1-10		DELETED		
	100	NAS607-3-4P		..PIN-DOWEL		1
	105	BACB28AP04P032		..BUSHING		2
	110	BACB28W6B022		..BUSHING		2
	112	BACR15FT5AD		DELETED		
	113	BACB2B011A2E1TY		DELETED		
	115	256T3161-8		..HOUSING	A	1
	-115A	256T3161-17		..HOUSING	B	1
	-115B	256T3161-19		..HOUSING	C	1
R	-115C	256T3161-17		..HOUSING- (REWORKED BY SB 767-27-0080) (POST SB 767-27-0080)	D	1
	120	B539DDNJC		.BEARING- (V06144) (SPEC BACB10CF12PP) (OPT B539DDFS101 (V06144)) (OPT T339E (VK8455)) (OPT B539SSG27 (V30163)) (OPT B539DDFS428 (V21335)) (OPT B539DD (V38443)) (OPT B539-2TS (V43991)) (OPT B539FS101 (V06144)) (OPT B539DDP (V21760))		2

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
130	256T3169-1		.GEAR-INPUT SECTOR (OPT ITEM 130A)		1
-130A	256T3169-3		.GEAR-INPUT SECTOR (OPT ITEM 130)		1
135	256T3168-4		.SHAFT-INPUT		1
137	256T3185-1		.SPACER-INPUT SHAFT		1
140	SL2822-22		.NUT- (V97393) (SPEC BACN10RF22) (OPT 82631-2212 (V56878)) (OPT BR9080-22 (V72962))		2
145	256T3180-1		.WASHER		2
150	KP23BSD610		.BEARING- (V83086) (SPEC BACB10BW23) (OPT KP23B2TS (V43991)) (OPT KP23B (V38443)) (OPT LLKP23B (V38443)) (OPT KP23BG27 (V30163)) (OPT KP23BFS428 (V21335)) (OPT KP23BLY196 (V40920))		4

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	155	256T3179-1		.SPACER-BRG (MFD FROM AL 2024-T3 WW-T-70013 F-18.13 1.625 IN. X 0.058 WALL 1.1 IN. LG)		1
	160	256T3179-2		.SPACER-BRG (MFD FROM AL 2024-T3 WW-T-70013 F-18.13 1.625 IN. X .058 WALL X 1.5 IN. LG)		1
	165	256T3165-2		.CAM ASSY-INPUT		1
	170	BACB30MY6K4		..BOLT		1
	175	HL79-6		..COLLAR- (V5M902) (SPEC BACC30M6) (OPT HL79-6 (V73197)) (OPT HL79-6 (V92215)) (OPT 66014-6 (V56878)) (OPT HL79-6 (V56878))		1
	180	256T3167-1		..SHAFT		1
	185	256T3166-1		..CAM		1
	190	256T3181-3		.CAM ASSY-FOLLOWUP	A	1
	-190A	256T3181-6		.CAM ASSY-FOLLOWUP	B	1
	-190B	256T3181-7		.CAM ASSY-FOLLOWUP	C	1
R	-190C	256T3181-7		.CAM ASSY-FOLLOWUP (POST SB 767-27-0080)	D	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
195	BACB30MY6K4		..BOLT		2
200	HL79-6		..COLLAR-		2
			(V5M902)		
			(SPEC BACC30M6)		
			(OPT HL79-6		
			(V73197))		
			(OPT HL79-6		
			(V92215))		
			(OPT 66014-6		
			(V56878))		
			(OPT HL79-6		
			(V56878))		
205	256T3186-1		..PLUG		1
210	256T3183-1		..SHAFT		1
215	256T3182-1		..CAM-	A	1
			(OPT ITEM 215C)		
-215A	256T3191-1		..CAM	B	1
-215B	256T3194-1		..CAM	C,D	1
-215C	256T3106-1		..CAM-	A	1
			(OPT ITEM 215)		
220	256T3173-1		.FOLLOWER-CAM		2
225	BRH10A4		.NUT-		2
			(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))		
230	BACW10P231D		.WASHER		2
235	NAS6604-29		.BOLT		1
240	BACB28AK04-025		.BUSHING		1
245	AN960D416L		.WASHER		1
250	NAS6604-11		.BOLT		2
255	BACW10P11AL		.WASHER		4

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
260	BRH10A4		.NUT-		3
			(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))		
265	256T3178-1		.SPRING		1
267	256T3184-2		.SPACER-SPR		2
270	256T3187-1		.SHAFT-		1
			(OPT ITEM 270A)		
-270A	256T3189-1		.SHAFT-		1
			(OPT ITEM 270)		
305	KP4ANJC		.BEARING-		4
			(V06144)		
			(SPEC BACB10BX4)		
			(OPT KP4AFS428		
			(V21335))		
			(OPT KP4A2TS		
			(V43991))		
			(OPT LLKP4A		
			(V38443))		
			(OPT KP4AG27		
			(V30163))		
			(OPT KP4A		
			(V38443))		
			(OPT KP4ALY196		
			(V40920))		
			(OPT KP4ASD610		
			(V83086))		
			(OPT CS204E		
			(VK8455))		
			(OPT KP4A		
			(V21760))		
310	BACB28AK04-089		.BUSHING		1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
315	KP6ANJC		.BEARING- (V06144) (SPEC BACB10BX6) (OPT KP6AFS428 (V21335)) (OPT KP6A2TS (V43991)) (OPT LLKP6A (V38443)) (OPT KP6AG27 (V30163)) (OPT KP6A (V38443)) (OPT KP6BLY196 (V40920)) (OPT KP6BSD610 (V83086)) (OPT CS206E (VK8455)) (OPT KP6A (V21760))		3
320	B539DDNJC		.BEARING- (V06144) (SPEC BACB10CF12PP) (OPT B539DDFS101 (V06144)) (OPT T339E (VK8455)) (OPT B539SSG27 (V30163)) (OPT B539DDFS428 (V21335)) (OPT B539DD (V38443)) (OPT B539-2TS (V43991)) (OPT B539FS101 (V06144)) (OPT B539DDP (V21760))		1
325	256T3188-1		.LEVER-SUMMING (OPT ITEM 325A)		1
-325A	256T3190-1		.LEVER-SUMMING (OPT ITEM 325)		1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-330	BAC27TCT0002		.NAMEPLATE- (OPT ITEM 330A)		1
-330A	BAC27ECT58		.NAMEPLATE- (OPT ITEM 330)		1

- Item Not Illustrated