TO: ALL HOLDERS OF OUTBOARD TRAILING EDGE FLAP DEFLECTION CONTROL CARRIAGE ASSEMBLY COMPONENT MAINTENANCE MANUAL 27-51-20

REVISION NO. 5 DATED NOV 01/03

HIGHLIGHTS

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

CHAPTER/SECTION AND PAGE NO.	DESCRIPTION OF CHANGE
REPAIR 2-1 601	Edited without technical change.

OUTBOARD TRAILING EDGE FLAP DEFLECTION CONTROL CARRIAGE ASSEMBLY AND INBOARD AUXILIARY CARRIAGE ASSEMBLY

PART NUMBERS 113T1358-2,-3,-5 113T1385-1

COMPONENT MAINTENANCE MANUAL
WITH
ILLUSTRATED PARTS LIST

100696

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

PAGE	DATE	CODE
27-51-20		
TITLE PAGE		
1	MAR 01/00	01.1
2	BLANK	
REVISION RECORD		
1	MAR 01/00	01.1
2	BLANK	
TR & SB RECORD		
1	MAR 01/00	01.1
2	BLANK	
LIST OF EFFECTIVE PAGES		
*1	NOV 01/03	01
THRU LAST PAGE		
CONTENTS		
1	MAR 01/00	01.1
2	BLANK	
INTRODUCTION		
1	MAR 01/00	01.1
2	BLANK	
DESCRIPTION & OPERATION		
1	MAR 01/00	01.1
2	BLANK	
DISASSEMBLY		
301	MAR 01/00	01.1
302	BLANK	
CHECK		
501	MAR 01/00	01.1
502	BLANK	
REPAIR-GENERAL		
601	MAR 01/00	01.1
602	BLANK	

PAGE	DATE	CODE
REPAIR 1-1		
601	MAR 01/00	01.1
602	BLANK	
REPAIR 2-1		
*601	NOV 01/03	01.1
602	MAR 01/00	01.1
603	MAR 01/00	01.1
604	BLANK	
ASSEMBLY		
701	MAR 01/00	01.1
702	MAR 01/00	01.1
703	MAR 01/00	01.1
704	MAR 01/00	01.1
FITS AND CLEARANCES		
801	MAR 01/00	01.1
802	MAR 01/00	01.1
803	MAR 01/00	01.1
804	MAR 01/00	01.1
ILLUSTRATED PARTS LIST		
1001	MAR 01/00	01.1
1002	MAR 01/00	01.1
1003	MAR 01/00	01.1
1004	MAR 01/00	01.1
1005	MAR 01/00	01.1
1006	MAR 01/00	01.1
1007	MAR 01/00	01.1
1008	MAR 01/00	01.1
1009	MAR 01/00	01.1
1010	MAR 01/00	01.1
1011	MAR 01/00	01.1
1012	MAR 01/00	01.1
1013	MAR 01/00	01.1
1014	MAR 01/00	01.1
1015	MAR 01/00	01.1
1016	MAR 01/00	01.1

* = REVISED, ADDED OR DELETED

TABLE OF CONTENTS

*[1] Special instructions not required. Use standard industry practices and information contained in 20-30-03.

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.

OUTBOARD TRAILING EDGE FLAP DEFLECTION CONTROL CARRIAGE ASSEMBLY

AND INBOARD AUXILIARY CARRIAGE ASSEMBLY

DESCRIPTION AND OPERATION

1. The outboard trailing edge flap deflection control carriage assembly and the inboard auxiliary carriage assy each consists of a pair of carriages which are bolted together to form a unit. Two cam followers and two track roller bearings are mounted on the carriages. The assembly is attached to the outboard end of the outboard flap through a spherical bearing. In operation, the carriage rollers ride on a wing-mounted track to guide and control the end of the flap as the flap is extended.

2. Leading Particulars (Approximate)
For 113T1358:

Length -- 5 inches
Width -- 4 inches
Height -- 4 inches
Weight -- 3.6 pounds

For 113T1385:
Length -- 6 inches
Width -- 3 inches
Height -- 4 inches
Weight -- 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. Standard industry practices are sufficient for disassembly of this component.

NOTE: Do not remove lube fittings (IPL Fig. 1, 10; IPL Fig. 2, 70) from bolt assemblies (IPL Fig. 1, 5) and pin assy (IPL Fig. 2, 65) unless necessary for replacement.

CHECK

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

2. Magnetic particle check the following parts per SOPM 20-20-01.

   A. For IPL Fig. 1

      (1) Bolt (15)

      (2) Washers (25, 60)

      (3) Carriage (70, 85)

   B. For IPL Fig. 2

      (1) Washers (35, 55)

3. Penetrant check the following parts per SOPM 20-20-02.

   A. For IPL Fig. 2

      (1) Plate (85)

REPAIR - GENERAL

1. Content

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

P/N	NAME	REPAIR
--	MISC PARTS REFINISH	1-1
113T1386	PLATE	2-1

2. Standard Practices

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

   20-30-02 Stripping of Protective Finishes
   20-30-03 General Cleaning Procedures
   20-41-01 Decoding Table for Boeing Finish Codes
   20-41-02 Application of Chemical and Solvent Resistant Finishes
   20-42-05 Bright Cadmium Plating

3. Materials

   NOTE: Equivalent substitutes may be used.

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

MISCELLANEOUS PARTS REFINISH - REPAIR 1-1

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

IPL FIG. & ITEM	MATERIAL	FINISH
Fig. 1		
Bolt (15)	15-5PH CRES 180-200 ksi	Cadmium plate (F-15.02) all over except in holes.
Washer (25)	15-5PH CRES 180-200 ksi	Passivate (F-17.09)
Shim (50)	Al alloy	Chemical treat and apply one coat primer, BMS 10-11, type 1 (F-18.06)
Washer (60)	15-5PH CRES 180-200 ksi	Cadmium plate (F-15.06)
Carriage (70,70A, 70B,85,85A,85B)	17-4 PH CRES 180 ksi min	Cadmium plate (F-15.06)
Carriage (70C,85C)	15-5PH CRES 180-200 ksi	Passivate (F-17.25)
Fig. 2		
Washer (35)	15-5PH CRES 180-200 ksi	Passivate (F-17.09)
Washer (55,60)	15-5PH CRES 180-200 ksi	Passivate (F-17.25)

Refinish Details
Figure 601

PLATE - REPAIR 2-1

113T1386-1

1. General

A. This procedure has the data necessary to refinish the plate (85).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for details of the SOPM chapters identified in this procedure.

C. Refer to the REPAIR - GENERAL (27-51-20/601, REPAIR - GENERAL) for the Standard True Position Dimensioning Symbols shown in the repair.

D. Refer to IPL Fig. 2 for item numbers.

E. General repair details:

(1) Material: Titanium alloy

(2) Shot Peen Intensity 0.0008A

2. Plate Refinish

A. Consumable Materials

NOTE: Equivalent material can be used.

(1) Coating -- BMS 10-67, Type 15 thermal spray (SOPM 20-10-05)

B. References

(1) SOPM 20-10-03, Shot Peening

(2) SOPM 20-10-05, Application and Finishing of Thermal Spray Coatings

(3) SOPM 20-30-02, Stripping of Protective Finishes

(4) SOPM 20-41-01, Decoding Table For Boeing Finish Codes

(5) SOPM 20-60-02, Finishing Materials

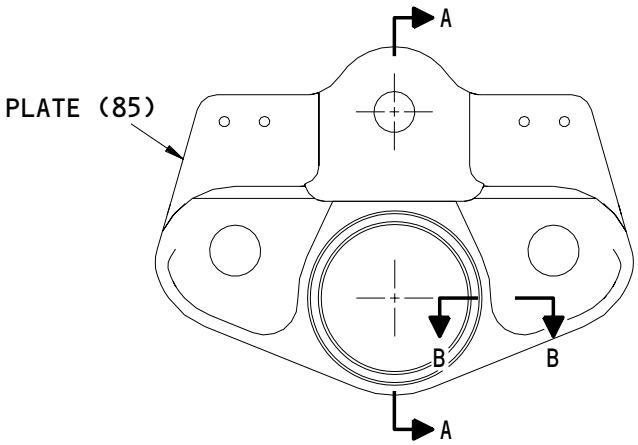
C. Procedure (Fig. 601)

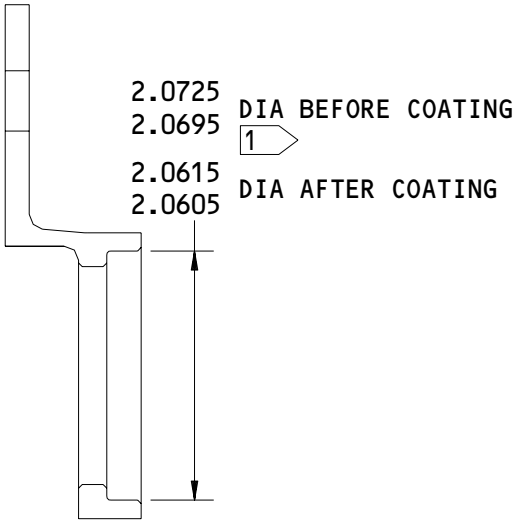
(1) Obey flagnotes 1 thru 3

(a) In area indicated by flagnote 1: 63 microinches RA surface roughness before shot peening.

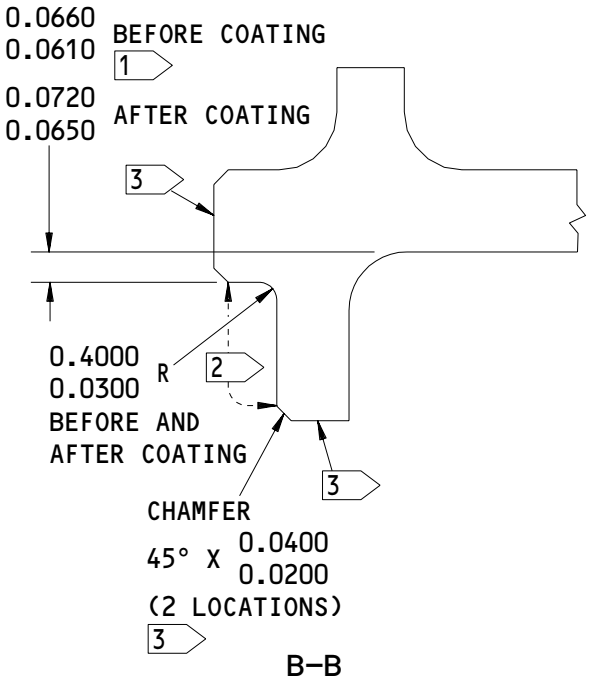
(b) In area indicated by flagnote 2: After shot peening, apply BMS 10-67, Type 15 thermal flame (F-15.381). The final thickness is 0.004-0.006 inch.

(c) In area indicated by flagnote 3: Coating runout area.





A–A



B–B

1 > 63 MICROINCHES RA SURFACE ROUGHNESS BEFORE SHOT PEENING

2 > AFTER SHOT PEENING, APPLY F-15.381. FINAL THICKNESS 0.004-0.006 INCH. COATING SURFACE ROUGHNESS 32 MICRO-INCHES RA MAXIMUM

3 > COATING RUNOUT AREA

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES 0.010-0.040

ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

113T1386-1
Plate Repair
Figure 601

K62945

ASSEMBLY

1. Materials

NOTE: Equivalent substitutes may be used.

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

B. Grease -- BMS 3-33 (SOPM 20-60-03)

C. Sealant -- BMS 5-26 (SOPM 20-60-04)

D. Sealant -- BMS 5-95 (SOPM 20-60-04)

2. Assembly (IPL Fig. 1)

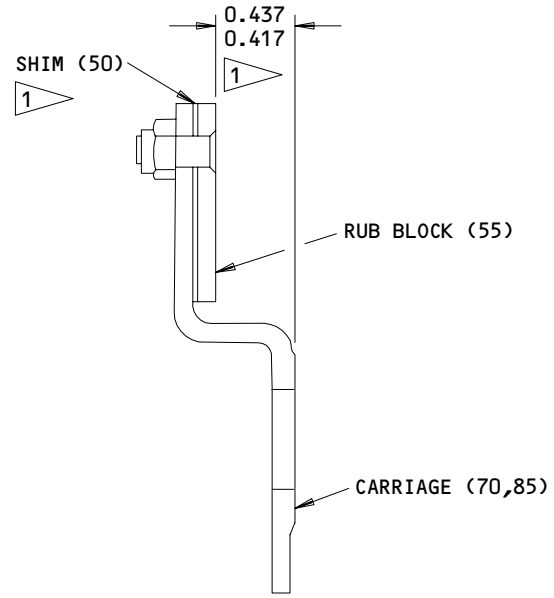
A. Position shims (50) and rub blocks (55) on carriages (70, 85). Remove laminations from shims to obtain dimensions shown in Fig. 701.

B. Apply primer to shims after delamination, then install shims and rub blocks with bolts (40) and nuts (45).

C. Install cam followers (80) on carriages and secure with washers (60) and nuts (65). Tighten nuts to 140-180 lb-in.

D. Assemble carriages (70, 85) with bearings (35, 75) in position. Install bolt assemblies (5), washers (20, 25), and nuts (30), with bolt heads facing same direction. Tighten nuts to 300-340 lb-in.

NOTE: Ensure that countersink on washers (20) faces bolt heads.



1 DELAMINATE SHIM (50) AS REQUIRED TO OBTAIN INDICATED DIMENSION

Shim and Rub Block Installation
Figure 701

101161

3. Assembly (IPL Fig. 2)

A. Assemble the inboard auxiliary carriage assembly (IPL Fig. 2, 1A).

(1) Install the shims (25) and the rub pads (20) on the plates (25):

(a) Position the shims (25) and the rub pads (20) on the plates (85). Remove the laminations from the shims (25) as required to obtain the dimensions shown in Fig. 702.

(b) Apply primer to the shims (25) after delamination, then install shims (25) and the rub pads (20) on the plates (85) with bolts (5), washers (10), and nuts (15).

(c) Tighten nuts (15) to 5 pound-inches beyond run-on torque.

(2) Install the bearing assemblies (40) on the plates (85):

(a) Install the bearing assemblies (40) on the plates (85) with washers (35) and nuts (30).

(b) Torque the nuts (30) to 220-300 pound-inches.

(3) Assemble the inboard auxiliary carriage assembly (1A):

(a) Install the bearing (45) between the plates (85) with BMS 5-95 sealant or BMS 5-26 sealant. Do not get the sealant on the seals or the spherical ball of the bearing (45).

(b) Install the bearings (80) between the plates (85).

(c) Apply a thin film of BMS 3-33 grease on all surfaces of the pin assemblies (65).

(d) Install the pin assemblies (65) thru the plates (85) and the bearings (80) with washers (55, 60) and nuts (50).

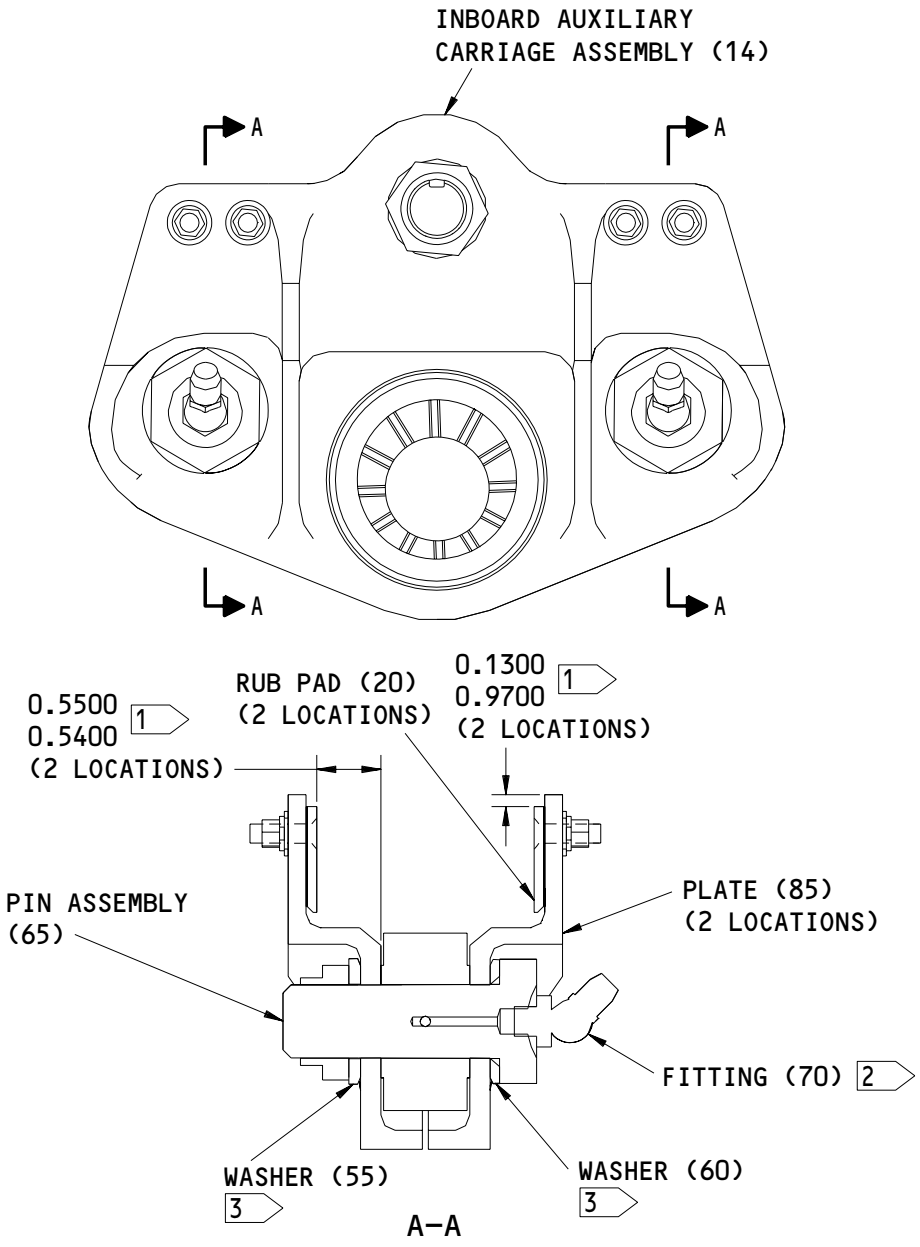
1) Make sure the chamfer side of the washers (55, 60) are facing the plates (85).

2) Make sure the lube fittings (70) of the pin assmeblies (65) are on the same side as the serrated face of the bearings (80).

3) Make sure the orientation of the lube fittings (70) is as shown in Fig. 702.

4) Tighten the nuts (50) to 380-460 pound-inches.

(4) Grease the pin assemblies (65) with BMS 3-33 grease.



1 DELAMINATE SHIM (25) AS REQUIRED TO OBTAIN THE INDICATED DIMENSION

2 MAKE SURE ORIENTATION OF FITTING (70) IS AS SHOWN

3 MAKE SURE THE CHAMFER SIDE FACES THE PLATE (85) AS SHOWN

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

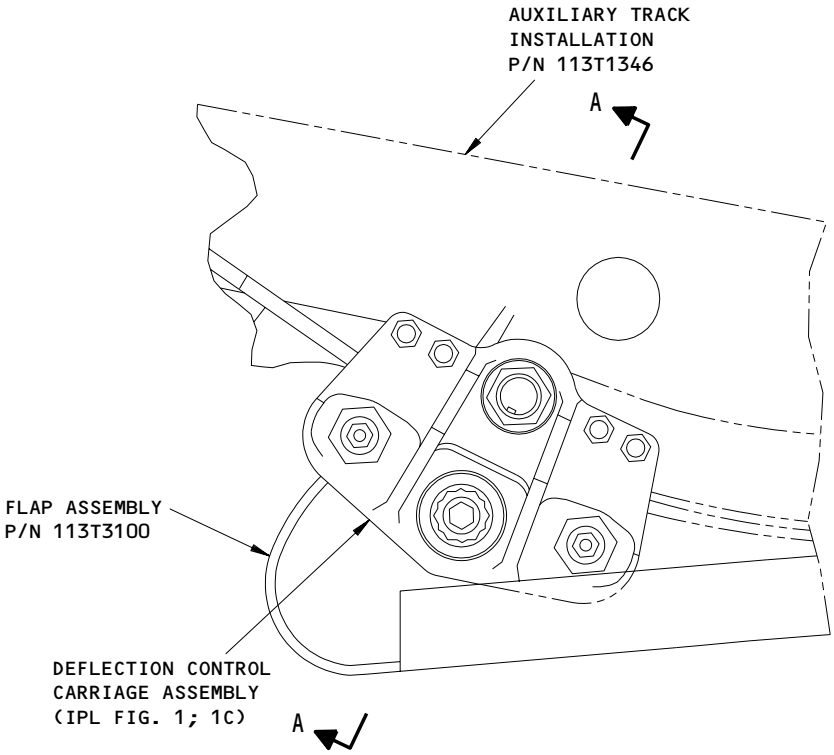
ITEM NUMBERS REFER TO IPL FIG. 2

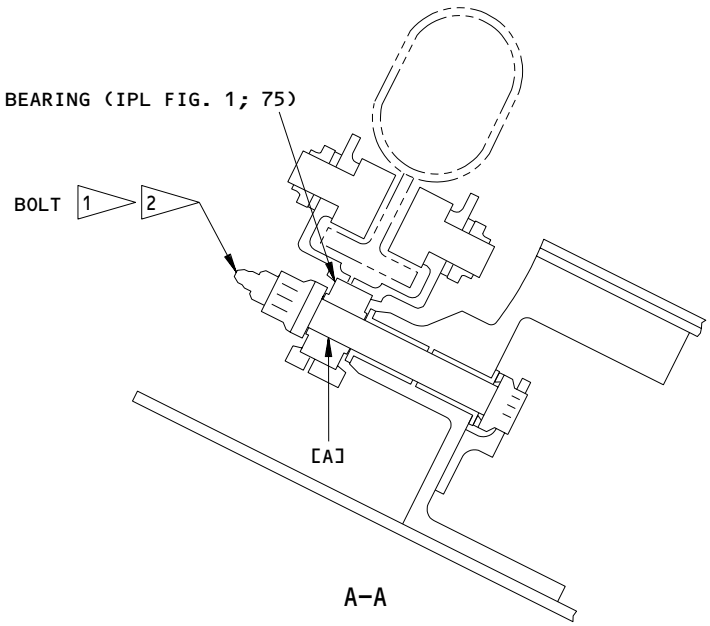
ALL DIMENSIONS ARE IN INCHES

Inboard Auxiliary Carriage Assembly
Figure 702

K63268

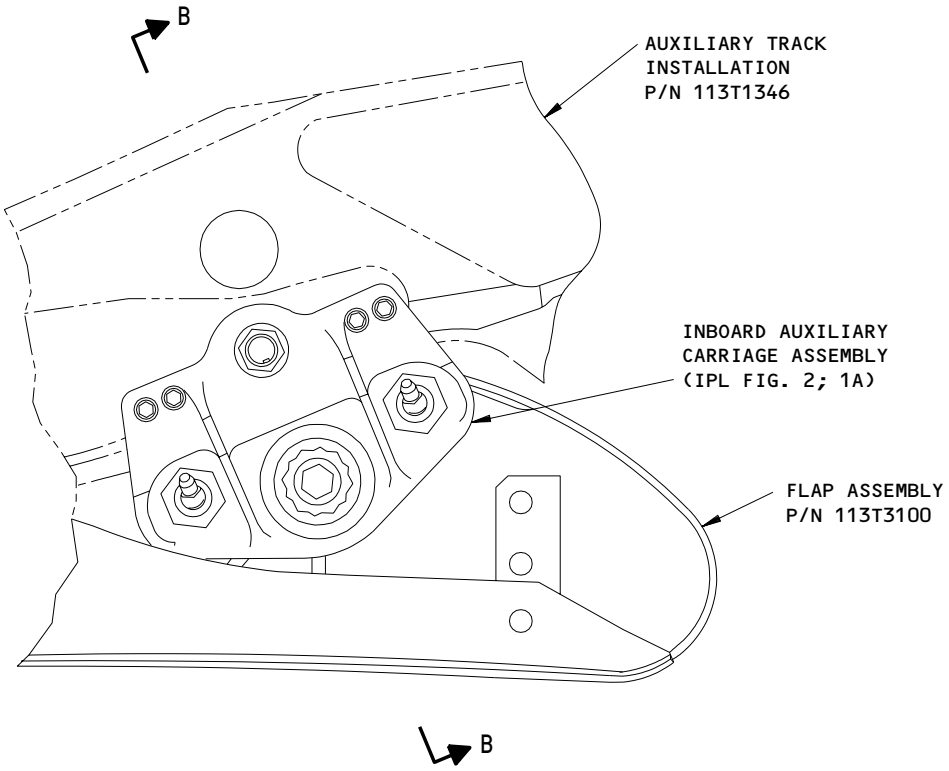
FITS AND CLEARANCES

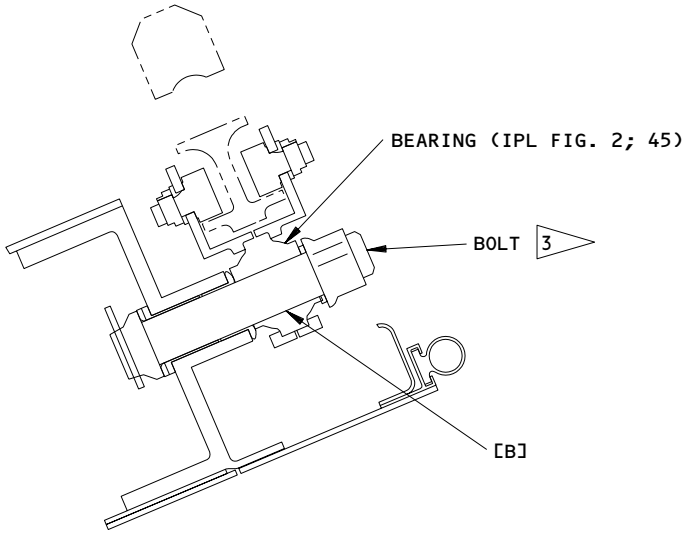




Fits and Clearances
Figure 801 (Sheet 1)

142936





B-B

Fits and Clearances
Figure 801 (Sheet 2)

K67013

REF LETTER	REF IPL		DESIGN DIMENSION*				SERVICE WEAR LIMIT*		
	FIG. NO.	MATING ITEM NO.	DIMENSION		ASSEMBLY CLEARANCE		DIMENSION		MAXIMUM CLEARANCE
			MIN	MAX	MIN	MAX	MIN	MAX	
[A]	1	ID 75 OD 1	0.5000 0.4985	0.5004 0.4995	0.0005	0.0019		0.5045	0.0050
[A]	1	ID 75A OD 2	0.5000 0.4985	0.5005 0.4995	0.0005	0.0020		0.5025	0.0050
[B]	2	ID 45 OD 3	0.8745 0.8726	0.8750 0.8740	0.0005	0.0024		0.8780	0.0050

* ALL DIMENSIONS ARE IN INCHES

1 INSTALLATION BOLT P/N 113T1318-1 IS USED WITH BEARING P/N BACB10EN08

2 INSTALLATION BOLT P/N 113T1318-7 IS USED WITH BEARING P/N BACB10FH08

3 INSTALLATION BOLT P/N 113T1318-5

Fits and Clearances
Figure 801 (Sheet 3)

K67114

REF IPL		NAME	TORQUE*	
FIG. NO.	ITEM NO.		POUND-INCHES	POUND-FEET
1	30	Nut	300-340	
1	65	Nut	140-180	
2	30	Nut	220-300	
2	50	Nut	380-400	

* REFER TO SOPM 20-50-01 FOR TORQUE VALUES OF STANDARD FASTENERS.

Torque Table
Figure 802

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

S0352	NIPPON MINIATURE BEARING CO LTD TOKYO, JAPAN
0PTK6	SPS TECHNOLOGIES INC AEROSPACE PRODUCTS DIV 5195 W 4700 SPO BOX 18459 KEARNS, UTAH 84118
02758	NETWORKS ELECTRONIC CORP U S BEARING DIV 9750 DE SOTO AVENUE CHATSWORTH, CALIFORNIA 91311-4409
06725	AIR INDUSTRIES CORPORATION 12570 KNOTT STREET GARDEN GROVE, CALIFORNIA 92641-3932
09455	BFM TRANSPORT DYNAMICS CORP 3131 WEST SEGERSTROM AVENUE PO BOX 1953 SANTA ANA, CALIFORNIA 92702-1953
15653	KAYNAR TECHNOLOGY KAYNAR DIV 800 SOUTH STATE COLLEGE BLVD PO BOX 3001 FULLERTON, CALIFORNIA 92634-3001
15860	NEW HAMPSHIRE BALL BEARINGS, INCORPORATED ASTRO DIVISION 155 LEXINGTON AVENUE LACONIA, NEW HAMPSHIRE 03246-2937
16746	SPECLINE INCORPORATED 2230 MOUTON DR CARSON CITY, NEVADA 89706
23589	NIPPON MINATURE BEARING CORP SEE NMB CORP V50294

VENDORS

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

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

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

60380 TORRINGTON CO BEARINGS DIV SUBSIDIARY OF INGERSOLL-RAND CORP
59 FIELD STREET PO BOX 1008
TORRINGTON, CONNECTICUT 06790-4942

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

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

71087 BOOTS ACFT NUT DIV TOWNSEND CO SEE TEXTRON INC CHERRY
FASTENER TOWNSEND DIV V11815

72962 HARVARD INDUSTRIES INC
3 WERNER WAY SUITE 210
LEBANON, NEW JERSEY 08833

VENDORS

73134 IMO INDUSTRIES INC HEIM BEARINGS DIV
60 ROUND HILL ROAD PO BOX 430
FAIRFIELD, CONNECTICUT 06430

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

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

81376 SOUTHWEST PRODUCTS COMPANY
2240 BUENA VISTA STREET
IRVINDALE, CALIFORNIA 91706

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

92215 FAIRCHILD IND INC FAIRCHILD AEROSPACE FASTENER DIV
3010 W LOMITA BLVD
TORRANCE, CALIFORNIA 90505-5102

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

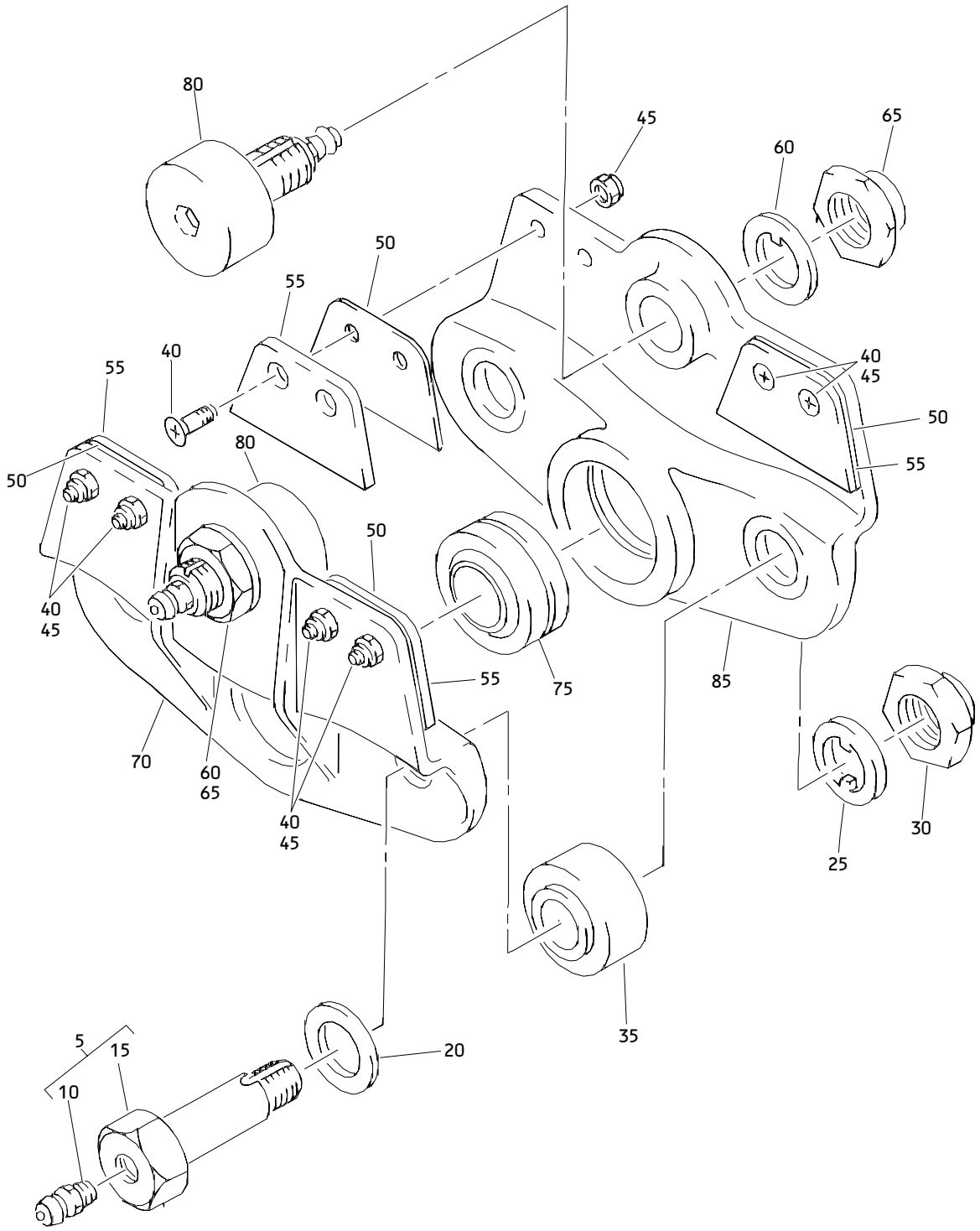
97613 SARGENT CONTROLS & AEROSPACE/KAHR BEARING DIV
5675 W BURLINGAME RD
TUCSON, ARIZONA 85743

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

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
ABWEN08		1	75	1
AG8-31		1	75A	1
AKBY14-4003N1		2	45	1
ASBFH08		1	75A	1
ATF8		1	35	2
BACB10EN08		1	75	1
BACB10ET08		1	35	2
BACB10FH08		1	75A	1
BACB10GH08J		1	35A	2
BACB10GH10J		2	80	2
BACB30NW5K3		1	40	8
BACB30VF08K4		2	5	8
BACN10JC08		1	45	8
BACN10JC08CM		1	45A	8
BACN10JC10CM		2	50	2
BACN10JC7CM		1	30	2
BACN10JC8		1	65	2
BACN10JC8CD		1	65A	2
BACN10JC8CM		2	30	2
BACN10YR08CM		2	15	8
BACW10CT16C		1	20	2
BLR08-2588		1	75A	1
BMN4122AD3-8		1	65	2
BMN4122A8		1	65	2
BMN4122CPD8-8		1	65A	2
BMN4122C1D2-10		2	50	2
BMN4122C1D2-8		2	30	2
BRH10A08		1	45	8
BWP08A110		1	75A	1
B30NW5K3		1	40	8
CF2586		1	80	2
HL11VAZ5-3		1	40	8
HU08-204		1	75A	1
H01-10BAC		2	50	2
H01-8BAC		2	30	2
H10-08BAC		1	45	8
H10-8BAC		1	65	2
H51650-8BAC		1	65A	2
H52732-08CM		2	15	8
KRP151008VT		1	80A	2
		2	40	2

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
KWB08-58		1	75A	1
L803-5K3		1	40	8
MS15004-1		1	10	2
MS15004-2		2	70	2
NAS1149CN832R		2	10	8
NES14-48BA		2	45	1
NS202101-82		1	45	8
PLH508CM		2	15	8
RMLH9074-8		1	65	2
RMLH9075-82W		1	45	8
S012T237-102		2	45	1
T6S832J		1	45	8
VN303A82		1	45	8
WC8-3		1	75A	1
03-524-08E001		1	75	1
102LH9074-8		1	65A	2
109LH9074-10		2	50	2
109LH9074-8		2	30	2
113T1318-2		1	5	2
113T1318-4		1	15	2
113T1354-1		1	85	1
113T1354-2		1	70	1
113T1354-3		1	85A	1
113T1354-4		1	70A	1
113T1354-5		1	85C	1
113T1354-6		1	70C	1
113T1356-1		1	25	2
113T1356-2		1	60	2
113T1356-4		2	35	2
113T1358-2		1	1D	RF
113T1358-3		1	1E	RF
113T1358-5		1	1F	RF
113T1366-3		1	55	4
113T1366-4		1	50	4
113T1366-5		1	50A	4
113T1385-1		1	3	RF
		2	1A	RF
113T1386-1		2	85	2
113W1021-45		2	75	2
113W1021-67		2	65	2
113W1025-20		2	55	2
113W1025-44		2	60	2
113W1026-13		2	25	4
113W1432-7		2	20	4
48FT820		1	65	2

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
69235-1018CM		2	50	2
69235-820CD		1	65A	2
69235-820CM		2	30	2
8AFC1021		1	35	2
96-82		1	45	8



Outboard Trailing Edge Flap Deflection Control Carriage Assembly
Figure 1

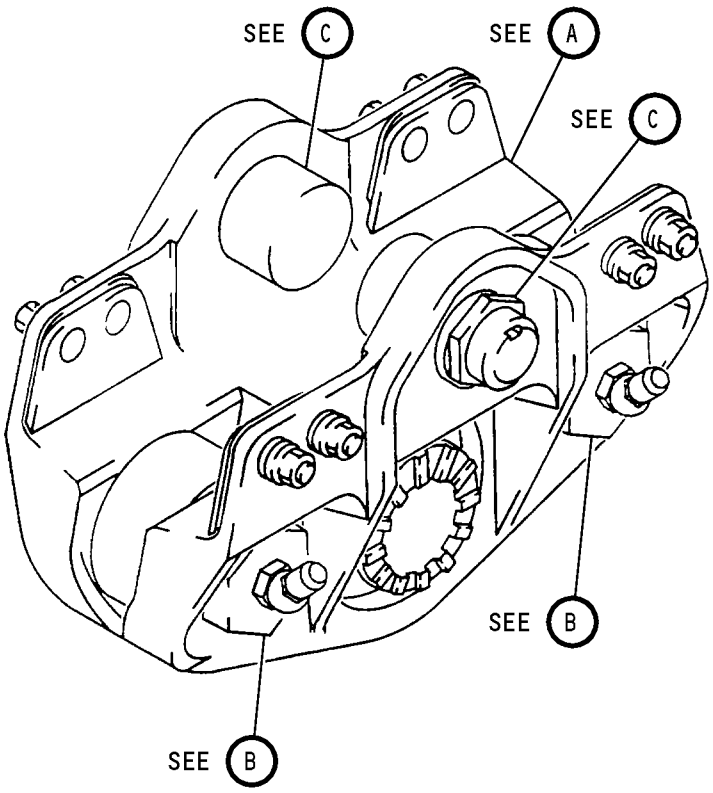
T80841

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	-1	113T1358-2		DELETED		
	-1A	113T1358-3		DELETED		
	-1B	113T1358-5		DELETED		
R				OUTBOARD T.E. FLAP CARRIAGE ASSEMBLY		
R	-1D	113T1358-2		CARRIAGE ASSY-DEFLECTION CONT	A	RF
R	-1E	113T1358-3		CARRIAGE ASSY-DEFLECTION CONT	B	RF
R	-1F	113T1358-5		CARRIAGE ASSY-DEFLECTION CONT	C	RF
R	-3	113T1385-1		CARRIAGE ASSY-INBD AUX (FOR DETAILS SEE FIG. 2)	D	RF
	5	113T1318-2		.BOLT ASSY	A-C	2
	10	MS15004-1		..FITTING-LUBE	A-C	1
	15	113T1318-4		..BOLT	A-C	1
	20	BACW10CT16C		.WASHER	A-C	2
	25	113T1356-1		.WASHER	A-C	2
	30	BACN10JC7CM		.NUT	A-C	2
	35	8AFC1021		.BEARING- (V92563) (SPEC BACB10ET08) (OPT ATF8 (V60380))	A,B	2
R	-35A	BACB10GH08J		.ROLLER	C	2
	40	HL11VAZ5-3		.BOLT- (V56878) (SPEC BACB30NW5K3) (OPT B30NW5K3 (V97928)) (OPT HL11VAZ5-3 (V73197)) (OPT HL11VAZ5-3 (V92215)) (OPT HL11VAZ5-3 (V97928)) (OPT L803-5K3 (V06725)) (OPT HL11VAZ5-3 (V0PTK6)) (OPT HL11VAZ5-3 (V60516))	A-C	8

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-45	H10-08BAC		.NUT- (V15653) (SPEC BACN10JC08) (OPT NS202101-82 (V80539)) (OPT RMLH9075-82W (V72962)) (OPT T6S832J (V71087)) (OPT VN303A82 (V92215)) (OPT 96-82 (V80539)) (OPT BRH10A08 (V52828))	A,B	8
R	-45A	BACN10JC08CM		.NUT	C	8
	50	113T1366-4		.SHIM	A,B	4
R	-50A	113T1366-5		.SHIM	C	4
	55	113T1366-3		.BLOCK-RUB	A-C	4
	60	113T1356-2		.WASHER	A-C	2
	65	H10-8BAC		.NUT- (V15653) (SPEC BACN10JC8) (OPT BMN4122A8 (V85495)) (OPT RMLH9074-8 (V72962)) (OPT 48FT820 (V56878)) (OPT BMN4122AD3-8 (V97928))	A,B	2
R	-65A	H51650-8BAC		.NUT- (V15653) (SPEC BACN10JC8CD) (OPT 102LH9074-8 (V72962)) (OPT 69235-820CD (V92215)) (OPT BMN4122CPD8-8 (V97928))	C	2
	70	113T1354-2		.CARRIAGE- (OPT ITEM 70A)	B	1
R	-70A	113T1354-4		.CARRIAGE- (OPT ITEM 70)	B	1
R	-70B	113T1354-2		.CARRIAGE	A	1

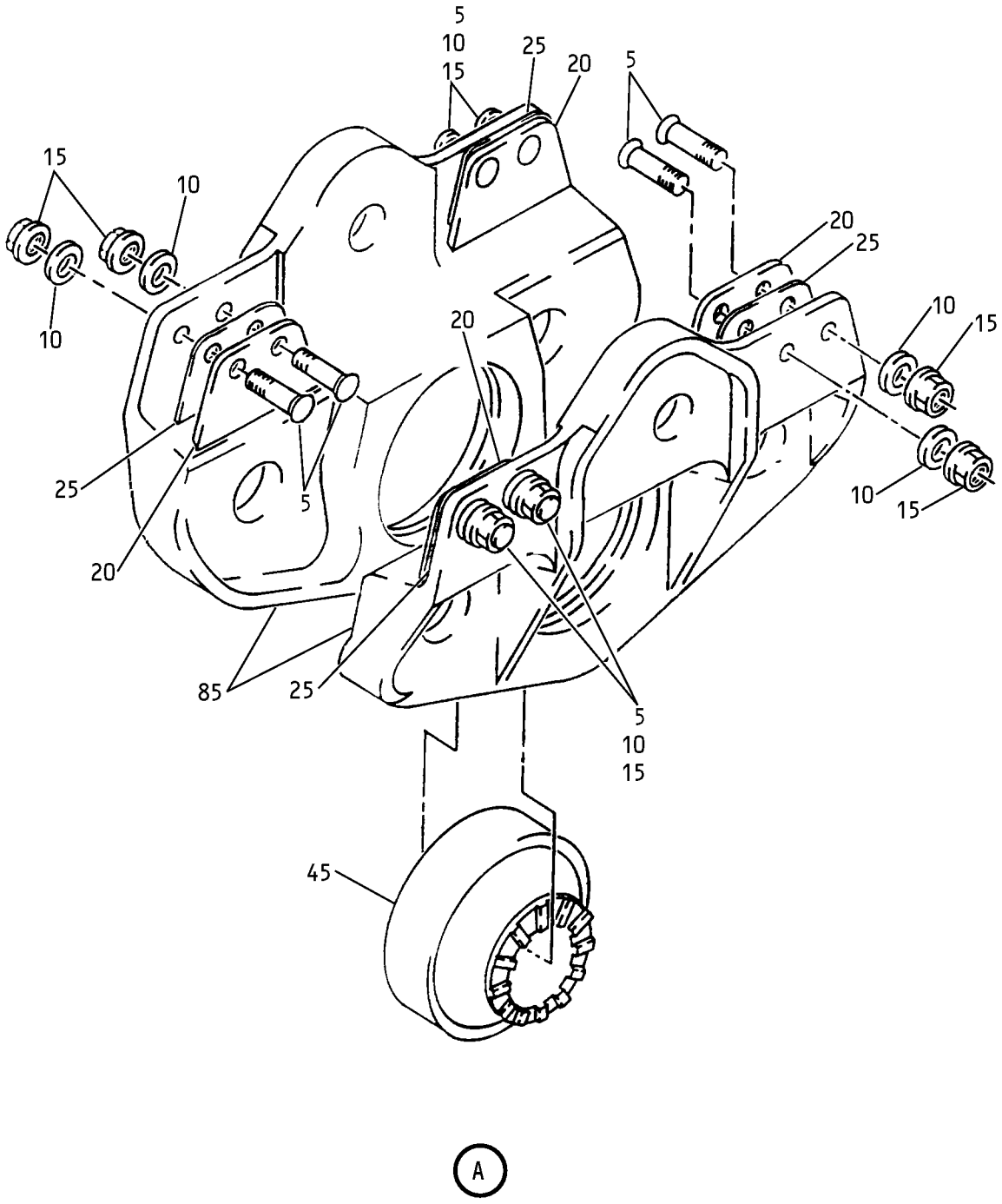
	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
R	-70C	113T1354-6		.CARRIAGE	C	1
	75	ABWEN08		.BEARING- (V23589) (SPEC BACB10EN08) (OPT KWB8-49 (V97613)) (OPT LHB08EN (V73134)) (OPT 03-524-08E001 (V09455))	A,B	1
R	-75A	BLR08-2588		.BEARING- (V81376) (SPEC BACB10FH08) (OPT BWP08A110 (V16746)) (OPT HU08-204 (V02758)) (OPT KWB08-58 (V97613)) (OPT LHB08EN (V73134)) (OPT AG8-31 (V15860)) (OPT WC8-3 (V56644)) (OPT ASBFH08 (VS0352))	C	1
	80	CF2586		.FOLLOWER-CAM (V92563)	A,B	2
R	-80A	KRP151008VT		.BEARING ASSY-CAM (V50632)	C	2
	85	113T1354-1		.CARRIAGE- (OPT ITEM 85A)	B	1
R	-85A	113T1354-3		.CARRIAGE- (OPT ITEM 85)	B	1
R	-85B	113T1354-1		.CARRIAGE	A	1
R	-85C	113T1354-5		.CARRIAGE	C	1

- Item Not Illustrated



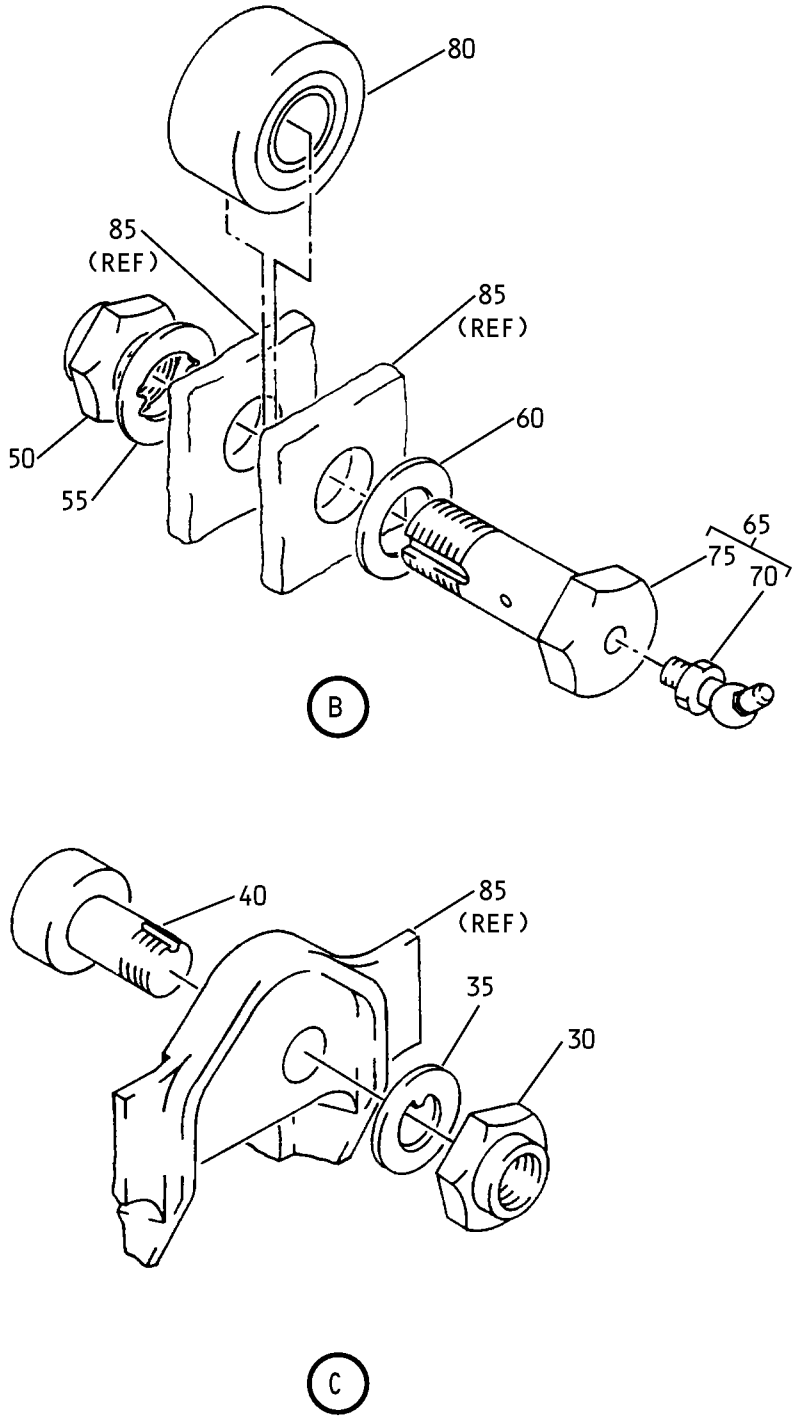
Inboard Auxiliary Carriage Assembly
Figure 2 (Sheet 1)

K62917



Inboard Auxiliary Carriage Assembly
Figure 2 (Sheet 2)

K62930



Inboard Auxiliary Carriage Assembly
Figure 2 (Sheet 3)

K62937

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	02-					
R	-1A	113T1385-1		CARRIAGE ASSY-INBD AUX	D	RF
R	5	BACB30VF08K4		.BOLT	D	8
R	10	NAS1149CN832R		.WASHER	D	8
R	15	H52732-08CM		.NUT- (V15653) (SPEC BACN10YR08CM) (OPT PLH508CM (V62554))	D	8
R	20	113W1432-7		.PAD-RUB	D	4
R	25	113W1026-13		.SHIM	D	AR
R	30	H01-8BAC		.NUT- (V15653) (SPEC BACN10JC8CM) (OPT BMN4122C1D2-8 (V85495)) (OPT 109LH9074-8 (V72962)) (OPT 69235-820CM (V56878)) (OPT BMN4122C1D2-8 (V97928))	D	2
R	35	113T1356-4		.WASHER	D	2
R	40	KRP151008VT		.BEARING ASSY- (V50632)	D	2
R	45	AKBY14-4003N1		.BEARING- (V15860) (SPEC S012T237-102) (OPT NES14-48BA (V73134))	D	1
R	50	H01-10BAC		.NUT- (V15653) (SPEC BACN10JC10CM) (OPT 109LH9074-10 (V72962)) (OPT 69235-1018CM (V56878)) (OPT BMN4122C1D2-10 (V97928))	D	2
R	55	113W1025-20		.WASHER	D	2
R	60	113W1025-44		.WASHER	D	2
R	65	113W1021-67		.PIN ASSY	D	2
R	70	MS15004-2		..FITTING	D	1
R	75	113W1021-45		..PIN	D	1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	02-					
R	80	BACB10GH10J		.BEARING	D	2
R	85	113T1386-1		.PLATE	D	2

- Item Not Illustrated