TO: ALL HOLDERS OF CONTROL STAND FLAP CONTROL LEVER ASSEMBLY COMPONENT MAINTENANCE MANUAL 27-51-80

REVISION NO. 5 DATED MAR 01/04

HIGHLIGHTS

All data formerly in manual 27-51-81 is included in this manual 27-51-80.

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

CHAPTER/SECTION AND PAGE NO.	DESCRIPTION OF CHANGE
501	Revised step 5.B. to change the spring compression requirements from 0.924 to 1.286 inches.
REPAIR 2-1 601-602 803	Revised middle lever, REPAIR 2-1 for P/N 253T5720-1 and Fig. 601 for chrome plate repair.
803	Revised Fits and Clearances Fig. 802 (Sheet 2) to include Service Wear Limits dimensions for (A) and (B).

CONTROL STAND FLAP CONTROL LEVER ASSEMBLY

PART NUMBER 253T5710-1,-2,-3

COMPONENT MAINTENANCE MANUAL
WITH
ILLUSTRATED PARTS LIST

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
27-51-80		
TITLE PAGE		
1	JUL 01/99	01.1
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REVISION RECORD		
1	OCT 01/87	01
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TR & SB RECORD		
1	OCT 01/87	01
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LIST OF EFFECTIVE PAGES		
*1	MAR 01/04	01
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1	OCT 01/87	01
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601	MAR 01/00	01.1
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PAGE	DATE	CODE
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601	MAR 01/00	01.1
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ILLUSTRATED PARTS LIST		
1001	OCT 01/87	01
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1004	JUL 01/99	01.1
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TABLE OF CONTENTS

INTRODUCTION

The instructions in this manual provide the information necessary to perform maintenance functions ranging from simple checks and replacement to complete shop-type repair.

This manual is divided into separate sections:

1. Title Page
2. Record of Revisions
3. Temporary Revision & Service Bulletin Record
4. List of Effective Pages
5. Table of Contents
6. Introduction
7. Procedures & IPL Sections

Refer to the Table of Contents for the page location of applicable sections. An asterisked flagnote *[ ] in place of the page number indicates that no special instructions are provided since the function can be performed using standard industry practices.

The beginning of the REPAIR section includes a list of the separate repairs, a list of applicable standard Boeing practices, and an explanation of the True Position Dimensioning symbols used.

An explanation of the use of the Illustrated Parts List is provided in the Introduction to that section.

All weights and measurements used in the manual are in English units, unless otherwise stated. When metric equivalents are given they will be in parentheses following the English units.

Design changes, optional parts, configuration differences and Service Bulletin modifications create alternate part numbers. These are identified in the Illustrated Parts List (IPL) by adding an alphabetical character to the basic item number. The resulting item number is called an alpha-variant. Throughout the manual, IPL basic item number references also apply to alpha-variants unless otherwise indicated.

Verification:

Disassembly	Mar 29/83
Assembly	Mar 29/83

CONTROL STAND FLAP CONTROL LEVER ASSEMBLY

DESCRIPTION AND OPERATION

1. Description

A. The 253T5710-1 and -2 control stand flap control lever assemblies each have an upper lever, middle lever, lower lever, quadrant, link assembly, and pivot assembly.

B. The 253T5710-3 control stand flap control lever assembly has a handle, handle assembly, quadrant assembly, link assembly, and pivot assembly.

2. Operation

A. 253T5710-1 and -2 Lever Assemblies

(1) When the pilot pulls up on the flap lever knob, the middle lever slides on the lower lever against a spring force. The lug on the middle lever is released from the flap position detent. This permits the lever and quadrant to be turned to change the flap position.

(2) When the knob is released at the applicable flap position, the spring force moves the middle lever down, and the lever lug can go back in the position detent.

B. 253T5710-3 Lever Assembly

(1) When the pilot pulls up on the flap lever knob, the handle slides in the handle assembly against a spring force. The lug on the handle is released from the flap position detent. This permits the handle and quadrant to be turned to change the flap position.

(2) When the knob is released at the applicable flap position, the spring force moves the handle down, and the lug can go back in the position detent.

3. Leading Particulars (approximate)

Length (overall) -- 13 inches (253T5710-1, -2)
16 inches (253T5710-3)
Height (overall) -- 7 inches
Width (overall) -- 2 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. Disassemble the 253T5710-1 or -2 lever assembly (IPL Fig. 1).

   A. Remove the pins (5, IPL Fig. 1) and the knob (10) from the upper lever (15).

   B. If lockwire is installed to hold the spring pin (20), remove the lockwire.

   C. Remove the pin (20), then remove the middle lever (25) from the lower lever (145).

      NOTE: Do not remove the rivets (30A) unless necessary for repair or replacement.

   D. Remove the spring (35) and the stop (40).

   E. Remove the nut (55), washers (50), bolt (45), and dowel pin (60) to release the quadrant (90) from the lower lever (145).

   F. Remove the bolt (65) and the bearing retainer (75).

   G. Remove the pivot assembly (115), one bearing (70), and the spacer (80) from the lower lever (145).

      NOTE: Do not disassemble the pivot assembly (115) unless necessary for repair or replacement.

   H. Remove the lockwire and pins (140) from the retainer (85), then remove the retainer.

   I. Remove the rivets (100), then remove the link assembly (95) from the lower lever (145).

      NOTE: Do not remove the bearing (105) from the link assembly (95), or the bearing (70) from the quadrant side of the lower lever (145), unless necessary for repair or replacement.

2. Disassemble the 253T5710-3 lever assembly (IPL Fig. 2).

A. Remove the bolt (5), washers (10, 15), and nut (20), then remove the link assembly (25) from the handle assembly (60).

B. Remove the bolt (100A), then remove the bearing retainer (120), pivot assembly (105), bearing (125), and spacer (130) from the quadrant assembly (135).

NOTE: Do not disassemble the pivot assembly (105) unless necessary for repair or replacement.

C. Remove the bolts (90) and collars (95), then remove the quadrant assembly (135) from the handle assembly (60).

NOTE: Do not remove the bearing (140) from the quadrant (145) unless necessary for repair or replacement.

D. If lockwire is installed to hold the spring pin (50), remove the lockwire. Remove the spring pin from the handle assembly (60).

E. Remove the rivets (65), then remove the cover plate (70) and the handle (55) from the handle (75). Remove the stop (85) and the spring (80) from the handle (55).

F. Remove the pins (40), then remove the knob (45) from the handle (55).

CLEANING

1. Clean all parts except bearing (IPL Fig. 1; 70, 105), (IPL Fig. 2; 30, 125, 140) using standard industry practices per 20-30-05.

2. Clean teflon-sealed bearing (IPL Fig. 1; 70, 105), (IPL Fig. 2; 30, 125, 140) per manufacturer's instructions.

CHECK

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

2. Do a magnetic particle check of the following parts. Refer to 20-20-01.

   A. Upper lever (IPL Fig. 1; 15), middle lever (25), bearing retainer (75), pivot (135), lower lever (145).

   B. Handle (IPL Fig. 2; 55, 75), cover plate (70), stop (85), pivot (115), bearing retainer (120).

3. Do a penetrant check of the following parts. Refer to 20-20-02.

   A. Spacer (IPL Fig. 1; 80), retainer (85), quadrant (90), plate (110).

   B. Link (IPL Fig. 2; 35), spacer (130), quadrant (145).

4. Do a check of the spring (IPL Fig. 1; 35).

   A. Compress the spring to 0.75 inch and make sure that the load is 4.7-5.7 pounds.

   B. Compress the spring to 1.16 inch and make sure that the load is 3.1-3.9 pounds.

5. Do a check of the spring (IPL Fig. 2; 80).

   A. Compress the spring to 0.924 inch and make sure that the load is 3.87-4.73 pounds.

   B. Compress the spring to 1.286 inches and make sure that the load is 3.06-3.74 pounds.

6. Do a check of the bearings (IPL Fig. 1; 70, 105), (IPL Fig. 2; 30, 125, 140).

   A. Make sure that the bearing turns freely and smoothly. If there is too much noise or the cleaned bearing is too loose, replace the bearing.

   B. Do a check of the surfaces of the inner and outer races. If you see a change in color of the surfaces, wear or pits, cracks, corrosion, or other damage, replace the bearing.

REPAIR - GENERAL

1. Content

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

P/N	NAME	REPAIR
253T5719	PIVOT	1-1
253T5720	LEVER, MIDDLE	2-1
253T5721	LEVER, LOWER	3-1
253T5729	LINK	4-1
- -	MISC PARTS REFINISH	5-1
253T5718	QUADRANT	6-1
253T5728	LINK	7-1
254W6022	HANDLE	8-1

2. Standard Practices

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

20-10-02 Machining of Alloy Steel
20-10-04 Grinding of Chrome Plated Parts
20-20-01 Magnetic Particle Inspection
20-20-02 Penetrant Methods of Inspection
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
20-42-03 Hard Chrome Plating
20-42-05 Bright Cadmium Plating
20-43-01 Chromic Acid Anodizing
20-50-03 Bearing and Bushing Replacement
20-50-08 Application of Bonded Solid Film Lubricant
20-60-02 Finishing Materials
20-60-03 Lubricants

3. Materials

NOTE: Equivalent substitutes may be used.

A. Lubricant -- Solid Film, BMS 3-8, class A (Ref 20-60-03)

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

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

4. Dimensioning Symbols

A. Standard True Positioning 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
[⊥ | 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

PIVOT ASSEMBLY - REPAIR 1-1

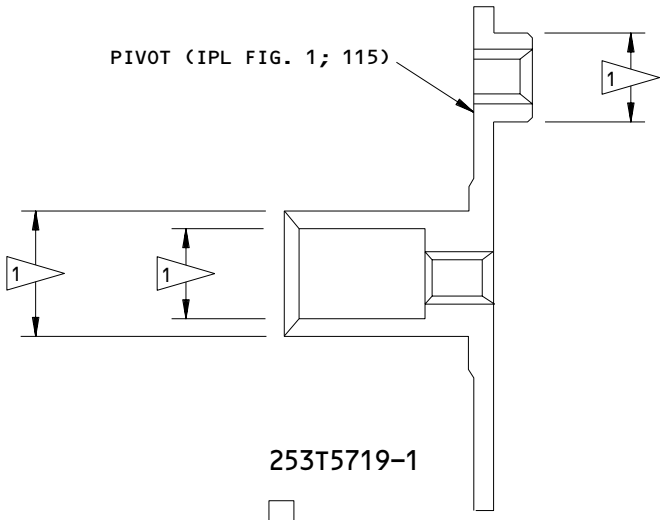
253T5719-1, -3

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.

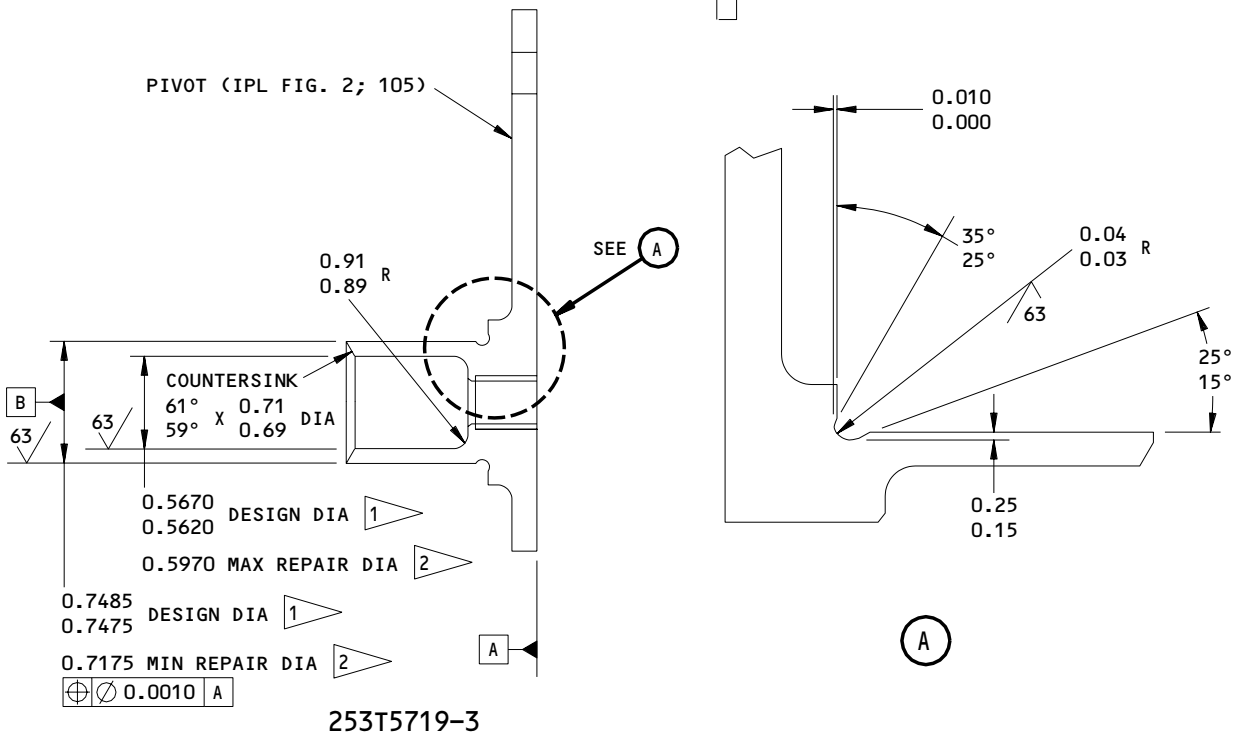
1. Repair (Fig. 601)

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

B. Build up with chrome plate (F-15.03) and machine to design dimensions and finish shown.



253T5719-1



253T5719-3

REFINISH

PIVOT (IPL FIG. 1; 115) -- CADMIUM PLATE AND APPLY BMS 10-11, TYPE 1 PRIMER (F-16.01), UNLESS SHOWN DIFFERENTLY

PIVOT (IPL FIG. 2; 105) -- CADMIUM PLATE (F-16.06) AND APPLY BMS 10-11, TYPE 1 PRIMER (F-20.02), UNLESS SHOWN DIFFERENTLY

1 DO NOT APPLY PRIMER ON THIS SURFACE

2 BUILD UP WITH CHROME PLATE (F-15.03), 0.03-0.015 SINGLE PLATE THICKNESS, AND GRIND TO DESIGN DIMENSION AND FINISH SHOWN

REPAIR

REF 2

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

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

BREAK ALL SHARP EDGES

SHOT PEEN: (SOPM 20-10-03)

ALL DIMENSIONS ARE IN INCHES

253T5719-1,-3
Pivot Assembly Repair
Figure 601

7936

LEVER, MIDDLE - REPAIR 2-1

253T5720-1

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.

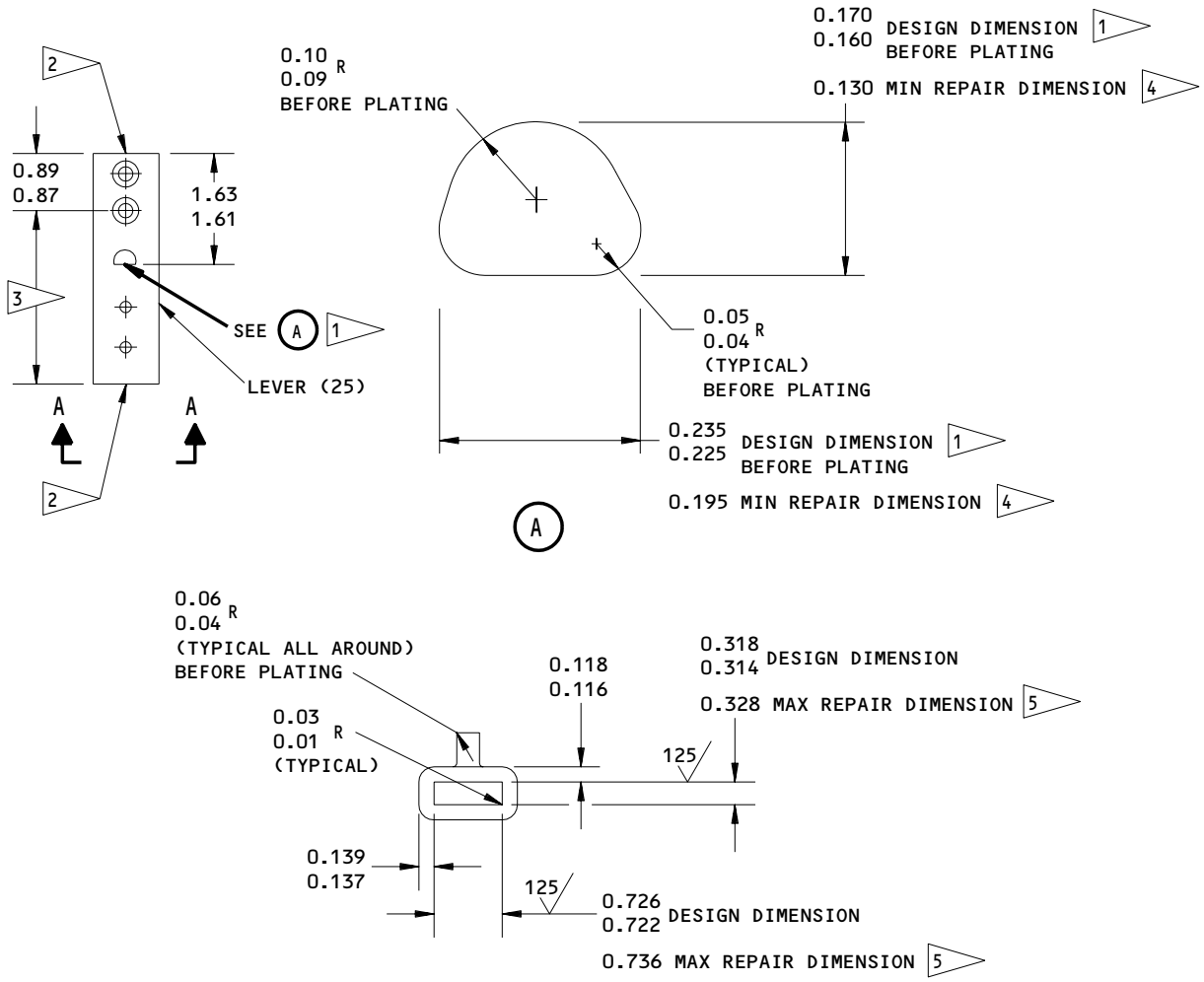
1. Repair (Fig. 601)

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

   B. Do a magnetic particle check (SOPM 20-20-01) of the machined area.

   C. Build up with chrome plate (F-15.03) and machine to design dimensions and finish shown. Chrome plate not to exceed thickness of 0.015 inches.

   D. Apply BMS 3-8 solid film lubricant, on interior surfaces as shown.



A-A

REFINISH

APPLY CHROME PLATE (F-15.03), 0.003-0.005 THICK, ON EXTERNAL SURFACES ONLY. SANDBLAST ALL EXTERNAL SURFACES TO GET A MATTE FINISH, UNLESS SHOWN DIFFERENTLY

1. DO NOT SANDBLAST THIS AREA
2. APPLY 0.050-0.080 R EDGE BREAK ALL AROUND
3. APPLY DRY FILM LUBRICANT BMS 3-8, ON INTERNAL SURFACES IN THIS AREA. OVERSPRAY PERMITTED ON THE REMAINING INTERNAL SURFACES. REFER TO SOPM 20-50-08
4. APPLY CHROME PLATE (F-15.03) TO SURFACES OF THE DETENT LUG. DO NOT EXCEED 0.015 CHROME PLATE THICKNESS. MAKE SURE LOWER SIDE OF PIN DOES NOT RECEIVE EXCESSIVE CHROME PLATE.
5. BUILD UP WITH CHROME PLATE (F-15.03) AND MACHINE TO DESIGN DIMENSIONS AND FINISH SHOWN

REPAIR

REF 4 5

MATERIAL: 17-4PH CRES, 180 KSI MINIMUM

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

253T5720-1
Middle Lever Repair
Figure 601

7923

LEVER, LOWER - REPAIR 3-1

253T5721-2, -4

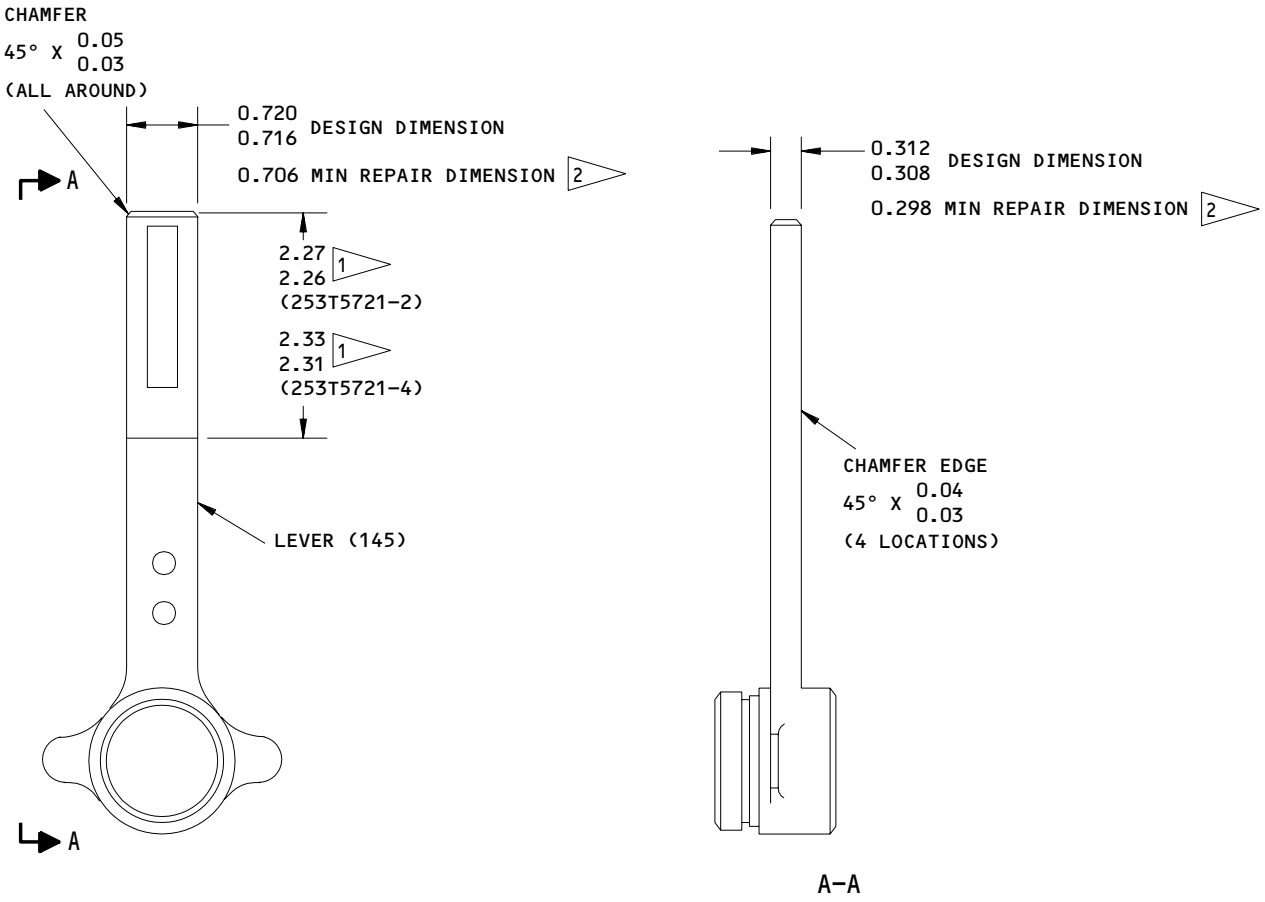
NOTE: Refer to REPAIR-GEN for list of applicable standard practices. For repair of surfaces which may only require stripping and restoration of original finish, refer to Refinish instructions, Fig. 601.

1. Lower Lever Repair (Fig. 601)

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

   B. Build up with chrome plate (F-15.03), and machine to design dimensions and finish shown.

   C. Apply solid film lubricant BMS 3-8 as shown.



REFINISH

PASSIVATE (F-17.09) ALL OVER AND APPLY DRY FILM LUBRICANT BMS 3-8 CLASS A ON SURFACES SHOWN

1 APPLY DRY FILM LUBRICANT TO ALL SURFACES IN THIS AREA.
KEEP 63 SURFACE FINISH

2 BUILD UP WITH CHROME PLATE (F-15.03) AND GRIND TO DESIGN DIMENSION SHOWN

REPAIR

REF 2

BREAK SHARP EDGES

125 ALL MACHINED SURFACES

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

ALL DIMENSIONS ARE IN INCHES

253T5721-2,-4
Lower Lever Repair
Figure 601

7933

LINK ASSEMBLY - REPAIR 4-1

253T5729-1

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.

1. Bearing Replacement (IPL Fig. 1)

   A. Remove bearing (105).

   B. Install replacement bearing (105) using BMS 10-11 type 1 wet primer and roller swage per 20-50-03.

2. Refinish

   A. Plate (110) -- Chromic acid anodize and apply one coat of BMS 10-11, type 1 primer (F-18.13) except no primer in 1.502-1.504 and 0.6243-0.6288 inch dia holes. Material: Aluminum alloy.

MISC PARTS REFINISH - REPAIR 5-1

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

IPL FIG. & ITEM	MATERIAL	FINISH
Fig. 1		
Upper lever (15)	17-4PH CRES 180 ksi min.	Matte finish chrome plate (F-14.111) all over.
Spring (35)	Music wire	Cadmium plate (SRF-1.92), but do not apply primer).
Stop (40)	8630 steel or 4130 steel	Cadmium plate (F-15.02) all over.
Spacer (80), retainer (85)	Aluminum alloy	Chromic acid anodize and apply BMS 10-11, type 1 primer (F-18.13), but do not apply primer to the ID of the retainer.
Quadrant (90,90A)	Aluminum alloy	Chromic acid anodize (F-17.04) and apply BMS 10-11, type 1 primer (F-20.03), but do not apply primer to the 1.500-1.503 inch diameter hole.
Quadrant (90B)	Aluminum alloy	Boric acid-sulfuric acid anodize (F-17.31) and apply BMS 10-11, type 1 primer (F-20.03), but do not apply primer to the 1.500-1.503 inch diameter hole.

Refinish Details
Figure 601 (Sheet 1)

IPL FIG. & ITEM	MATERIAL	FINISH
Fig. 2		
Cover plate (70)	15-5PH CRES 180-200 ksi	Passivate (F-17.25). Apply BMS 3-8 solid film lubricant on both sides.
Spring (80)	Music wire	Cadmium plate (F-15.06).
Stop (85)	8630 steel or 4130 steel	Cadmium plate (F-15.02) all over.
Spacer (130)	Aluminum alloy	Chromic acid anodize and apply BMS 10-11, type 1 primer (F-18.13).

Refinish Details
Figure 601 (Sheet 2)

QUADRANT - REPAIR 6-1

253T5718-4

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.

1. Bearing Replacement (IPL Fig. 2)

   A. Remove the bearing (140).

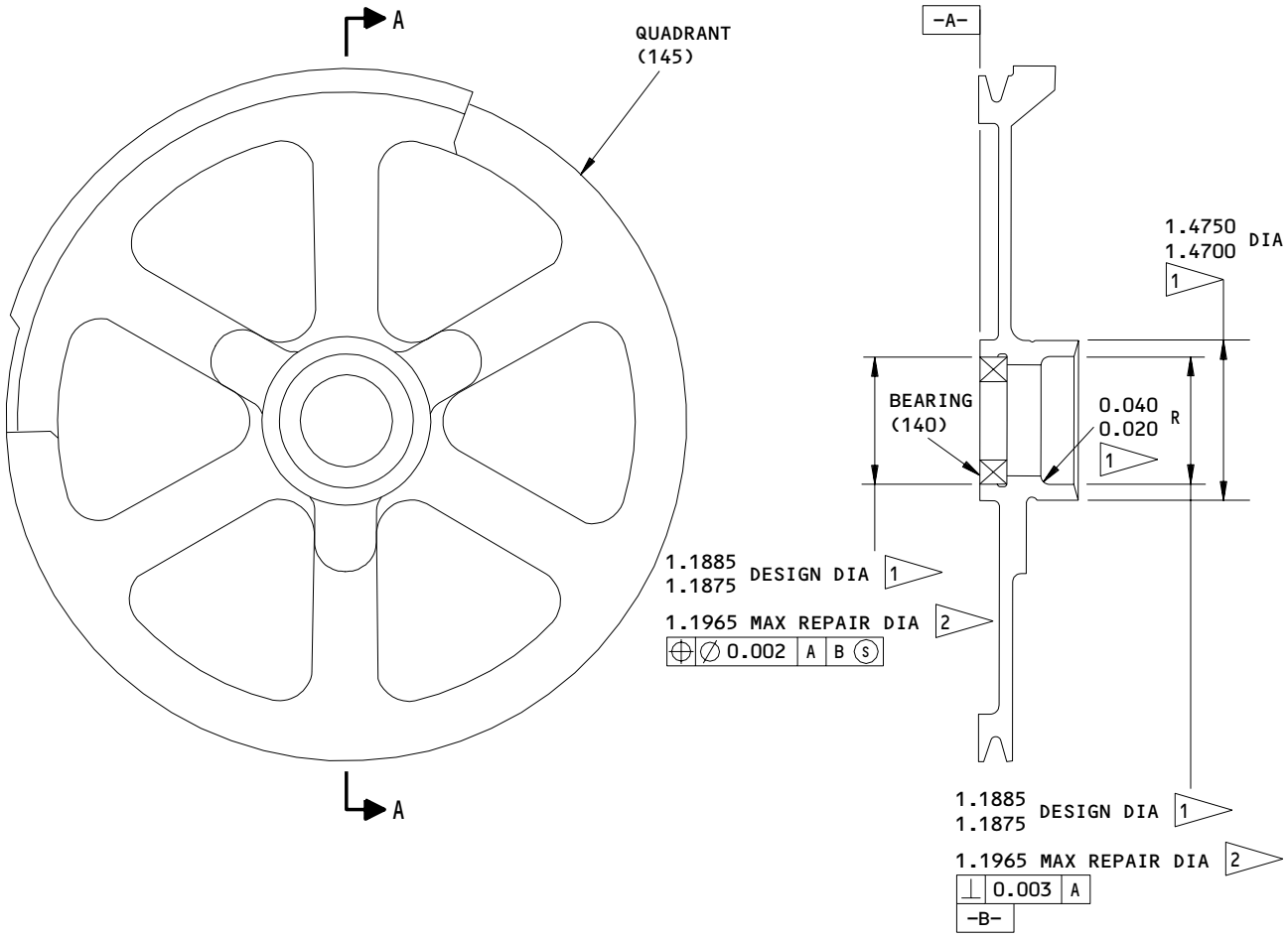
   B. Install the new bearing with BMS 3-24 grease. Refer to 20-50-03.

   C. Roller swage the quadrant (145) over the bearing. The depth of the swage must be 0.003-0.005 inch. Refer to 20-50-03.

2. Bearing Hole Repair (Fig. 601)

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

   B. Build up with hard anodize (F-17.06), and machine to design dimensions and finish shown. Make sure that the thickness of the anodize is not more than 0.0040 inch.



REFINISH

QUADRANT (145)--BORIC ACID-SULFURIC ACID ANODIZE (F-17.31) AND APPLY BMS 10-11, TYPE 1 PRIMER (F-20.03) ALL OVER, UNLESS SHOWN DIFFERENTLY.

1 DO NOT APPLY PRIMER ON THIS SURFACE

2 HARD ANODIZE AND MACHINE TO DESIGN DIMENSIONS AND FINISH SHOWN

REPAIR

REF 2

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: ALUMINUM ALLOY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

253T5718-4
Quadrant Assembly Repair
Figure 601

K11126

LINK ASSEMBLY - REPAIR 7-1

253T5728-3

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.

1. Bearing Replacement (IPL Fig. 2)

   A. Remove the bearing (30).

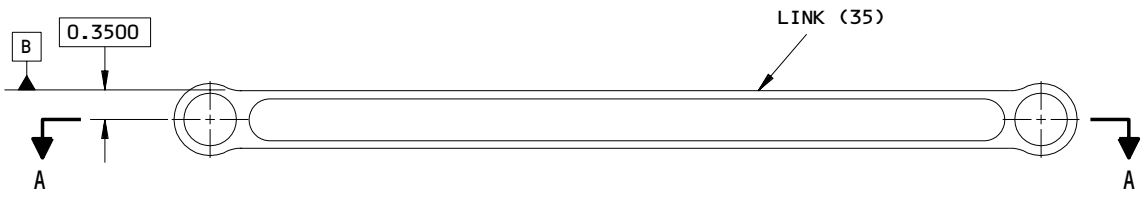
   B. Install the new bearing with wet primer (F-20.06). Refer to 20-50-03.

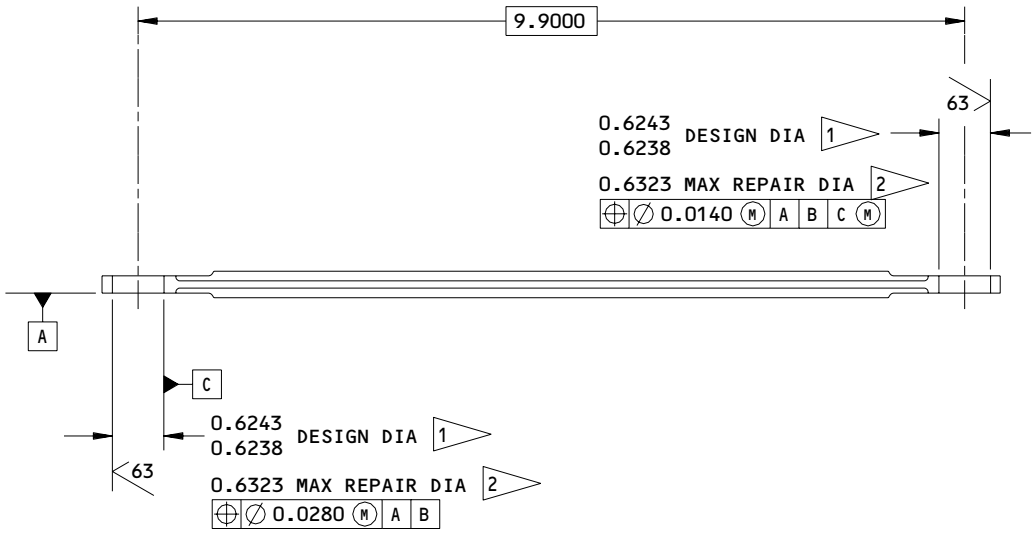
   C. Roller swage the link (35) over the bearing. Refer to 20-50-03.

2. Bearing Hole Repair (Fig. 601)

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

   B. Build up with hard anodize (F-17.06), and machine to design dimensions and finish shown. Make sure that the thickness of the anodize is not more than 0.0040 inch.





A-A

REFINISH

BORIC ACID-SULFURIC ACID ANODIZE (F-17.31) AND APPLY BMS 10-11, TYPE 1 PRIMER (F-20.02) ALL OVER, UNLESS SHOWN DIFFERENTLY

1 DO NOT APPLY PRIMER ON THIS SURFACE

2 HARD ANODIZE AND MACHINE TO DESIGN DIMENSION AND FINISH SHOWN

REPAIR

REF 2

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: ALUMINUM ALLOY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

253T5728-3
Link Assembly Repair
Figure 601

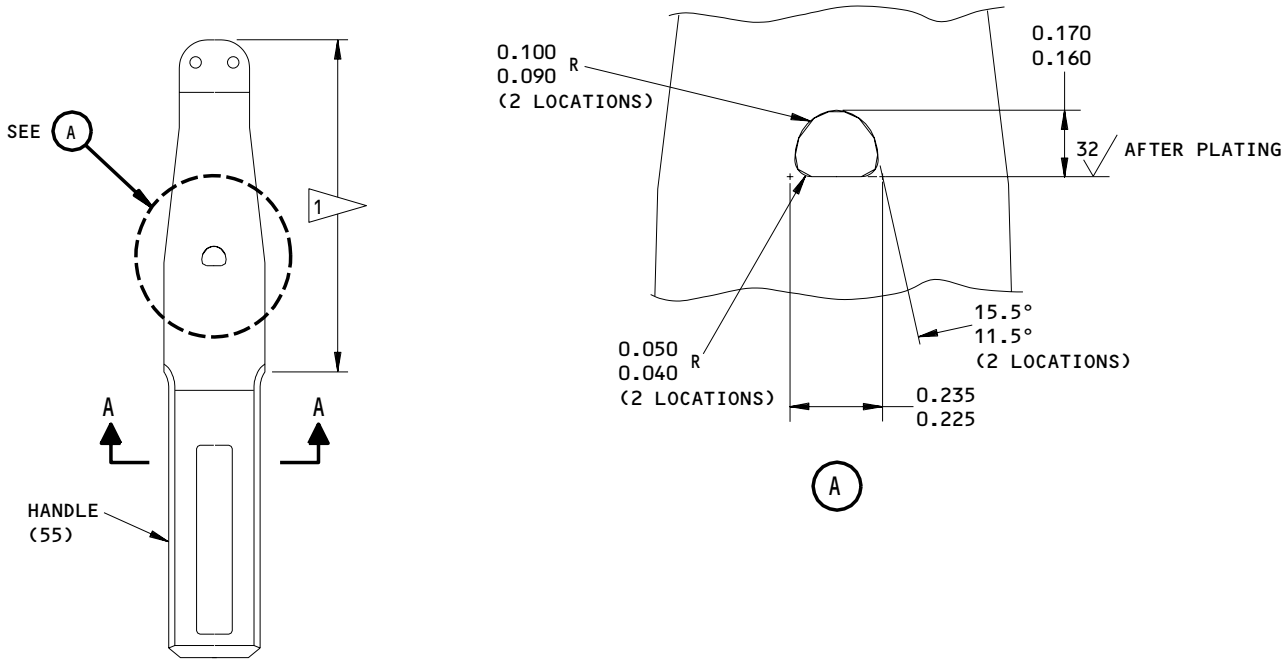
L05995

HANDLE - REPAIR 8-1

254W6022-2, -3

1. Plating Repair (Fig. 601)

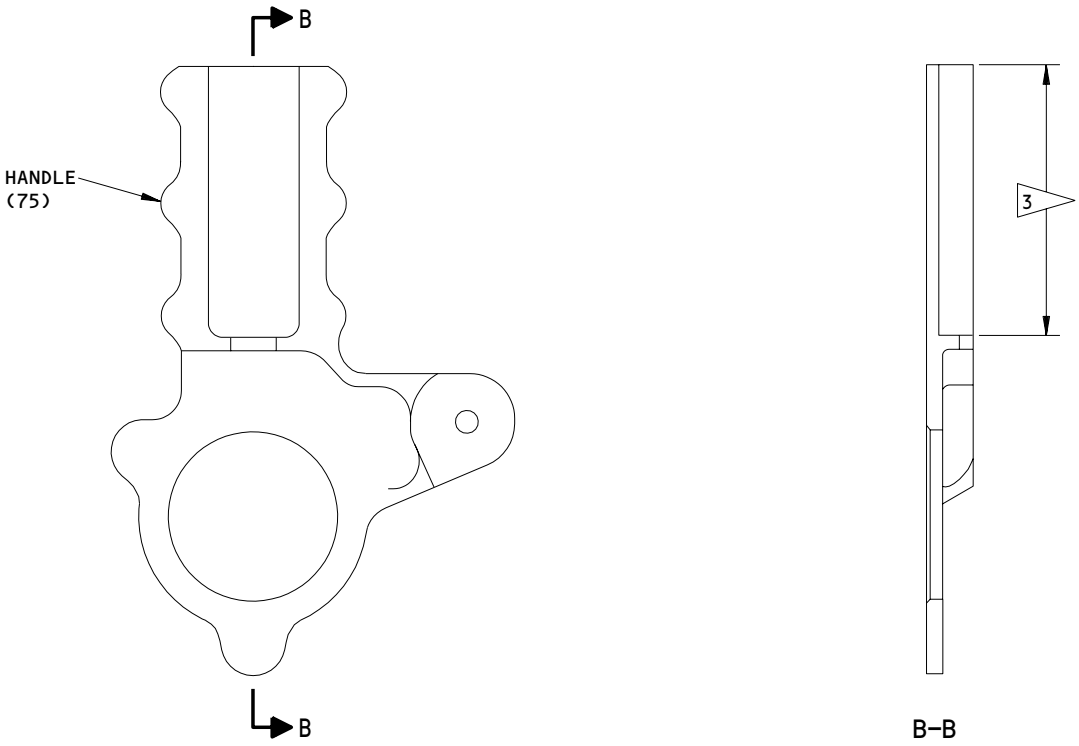
NOTE: Repair consists of restoration of original finish. Refer to Refinish instruction, Fig. 601 and to REPAIR-GEN for list of applicable standard practices.



254W6022-2

254W6022-2,-3
Handle Refinish
Figure 601 (Sheet 1)

K11273



254W6022-3

REFINISH

HANDLE (55)--PASSIVATE (F-17.25) ALL OVER.
APPLY CHROME PLATE AS SHOWN

HANDLE (75)--CADMIUM PLATE (F-16.06) AND
APPLY DRY FILM LUBRICANT AS SHOWN

1 APPLY MATTE FINISH CHROME PLATE (F-14.111)
IN THIS AREA

2 APPLY THIN DENSE CHROME PLATE ON ALL
SURFACES OF THE DETENT LUG,
0.0003-0.0005 THICK. REFER TO
SOPM 20-42-03, CLASS 4

3 APPLY DRY FILM LUBRICANT, BMS 3-8, ON THE
INTERNAL SURFACES SHOWN.
REFER TO SOPM 20-50-08

MATERIAL: 15-5PH CRES
180-200 KSI

ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

254W6022-2,-3
Handle Refinish
Figure 601 (Sheet 2)

K11333

RETAINER, BEARING - REPAIR 9-1

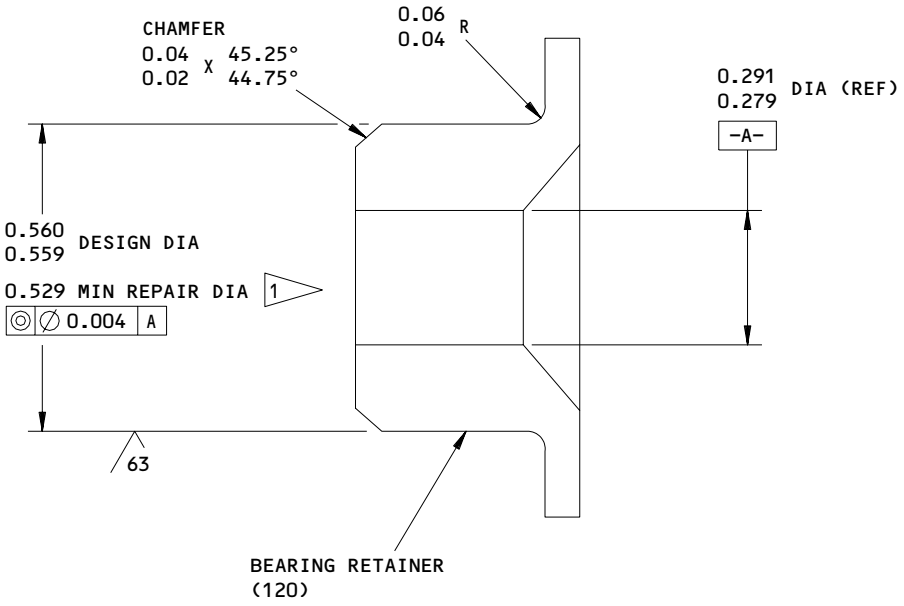
253T5423-1

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.

1. Repair (Fig. 601)

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

B. Build up with chrome plate (F-15.03) and machine to design dimensions and finish shown.



REFINISH

PASSIVATE (F-17.25) ALL OVER

1 BUILDUP WITH CHROME PLATE (F-15.03), 0.003 TO 0.015 SINGLE PLATE THICKNESS AND GRIND TO DESIGN DIMENSION AND FINISH SHOWN

REPAIR

REF 1

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

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

BREAK ALL SHARP EDGES

SHOT PEEN: (SOPM 20-10-03)

ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

253T5423-1
Bearing Retainer Repair
Figure 601

ASSEMBLY

1. Materials

NOTE: Equivalent substitutes may be used.

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

B. Lockwire -- MS20995C20

C. Lockwire -- MS20995NC20

2. Assembly

A. Use standard industry procedures for assembly of this component.

B. For the 253T5710-1 or -2 lever assembly, use the additional procedures that follow. Refer to IPL Fig. 1.

(1) Install bearings (70) per 20-50-03. Roller swage lower lever (145) to retain bearing on quadrant side only.

(2) Pins (5) must be flush to 0.005 inch below surface of knob (10).

(3) Install bolt (45) on quadrant (90) using BMS 10-11 type 1 wet primer.

(4) Install dowel pin (60) on quadrant (90) using BMS 10-11 type 1 wet primer.

(5) Apply one coat of BMS 10-11 type 1 primer on faying surface between plate (110) and lower lever (145).

(6) Install MS20995C20 lockwire to hold pins (140) in retainer (85).

(7) Ball stake the middle lever (25) at one place on each side of the hole for the spring pin (5). Distortion of the plated surface is permitted. Optional: Install MS20995NC20 lockwire through the hole in the spring pin and around the middle lever (25). (Ref 20-50-02).

(8) After assembly, make sure that the force necessary to lift the lever (15) against the spring (35) is not more than 7.0 pounds. Make sure that the spring returns the handle smoothly to its original position (handle vertical).

C. For the 253T5710-3 lever assembly, use the additional procedures that follow. Refer to IPL Fig. 2.

(1) Make sure that the pins (40) are flush to 0.005 inch below the surface of the knob (45).

(2) Install the bearing (125) with BMS 10-11, type 1 primer. Refer to 20-50-03.

(3) Assemble the quadrant assembly (135) to the handle assembly (60) with BMS 10-11, type 1 primer applied to the faying surfaces. Apply primer to the bolts (90) before installation.

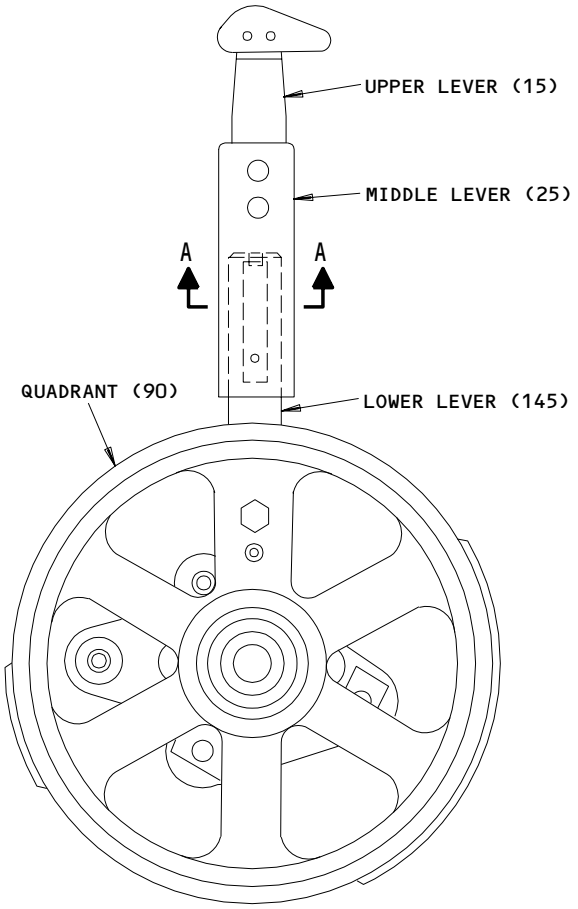
(4) Ball stake the handle assembly (60) at one place on each side of the hole for the spring pin (50). Distortion of the plated surface is permitted. Optional: Install MS20995NC20 lockwire through the hole in the spring pin and around the handle assembly (60). Refer to 20-50-02.

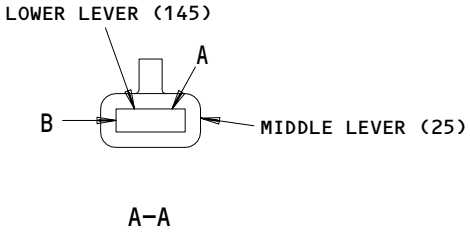
(5) After assembly, make sure that the force necessary to lift the knob (45) and handle assembly (60) is not more than 5.5 pounds.

3. Storage

A. Use standard industry procedures to prepare and store this component.

FITS AND CLEARANCES





A-A

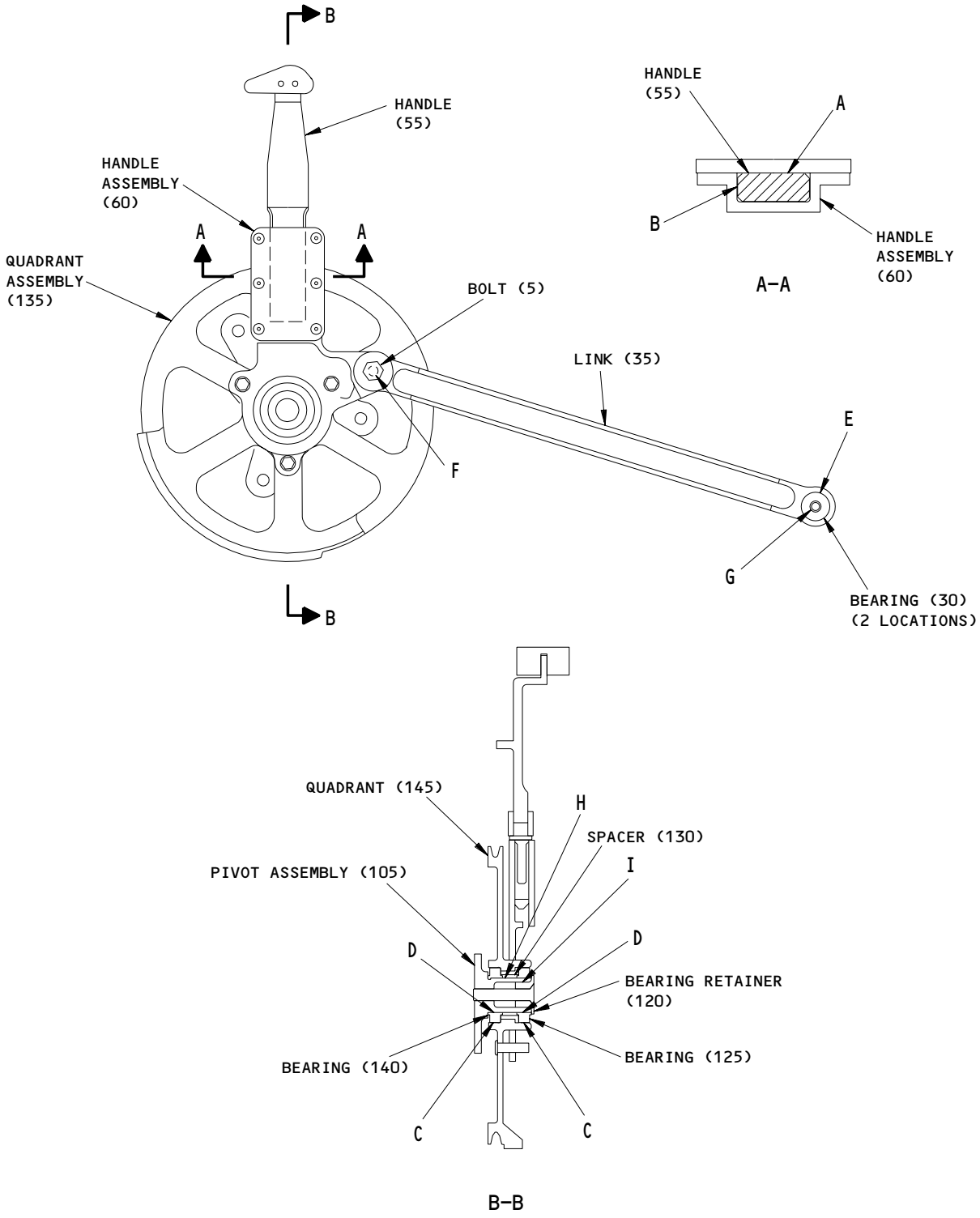
Ref Letter Fig.801	Mating Item No. IPL Fig. 1	Design Dimension				Service Wear Limit		
		Dimension		Assembly Clearance		Dimension		Maximum Clearance
		Min	Max	Min	Max	Min	Max	
A	25	0.722	0.726	0.002	0.010		0.735	0.015
	145	0.716	0.720			0.707		
B	25	0.314	0.318	0.002	0.010		0.327	0.015
	145	0.308	0.312			0.299		

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

Fits and Clearances
Figure 801

91511



Fits and Clearances
Figure 802 (Sheet 1)

K11379

Ref Letter Fig.802	Mating Item No. IPL Fig. 2	Design Dimension				Service Wear Limit		
		Dimension		Assembly Clearance 1		Dimension		Maximum Clearance
		Min	Max	Min	Max	Min	Max	
A	ID 60 OD 55	0.302 0.296	0.306 0.300	0.002	0.010	0.294	0.3160	0.0220
B	ID 60 OD 55	0.802 0.796	0.806 0.800	0.002	0.010	0.794	0.8160	0.0220
C	ID 145 OD 125,140	1.1875 1.1870	1.1885 1.1875	0.0000	0.0015	1.1860	1.1905	0.0045
D	ID 125,140 OD 105	0.7495 0.7475	0.7500 0.7485	0.0010	0.0025	0.7465	0.7510	0.0045
E	ID 35 OD 30	0.6238 0.6245	0.6243 0.6250	-0.0012	-0.0002	0.6235	0.6253	0.0018
F	ID 30 OD 5	0.1895 0.1885	0.1900 0.1895	0.0000	0.0015	0.1865	0.1910	0.0045
G	ID 30 OD 2	0.1895 0.1885	0.1900 0.1895	0.0000	0.0015	0.1875	0.1910	0.0035
H	ID 130 OD 105	0.7520 0.7475	0.7570 0.7485	0.0035	0.0095	0.7465	0.7630	0.0165
I	ID 105 OD 120	0.5620 0.5590	0.5670 0.5600	0.0020	0.0080	0.5570	0.5690	0.0120

1 NEGATIVE NUMBERS DENOTE INTERFERENCE FIT

2 INSTALLATION PART - BACB30NN38K BOLT

ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

Fits and Clearances
Figure 802 (Sheet 2)

L06185

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

0PTK6 SPS TECHNOLOGIES INC AEROSPACE PRODUCTS DIV
5195 W 4700 SPO BOX 18459
KEARNS, UTAH 84118

06144 INDUSTRIAL TECTONICS BEARING CORP
18301 SOUTH SANTA FE AVENUE
RANCO DOMINQUEZ, CALIFORNIA 90221

06725 AIR INDUSTRIES CORPORATION
12570 KNOTT STREET
GARDEN GROVE, CALIFORNIA 92641-3932

11815 CHERRY AEROSPACE FASTENERS DIV OF TEXTRON
1224 EAST WARNER AVENUE PO BOX 2157
SANTA ANA, CALIFORNIA 92707-0157

15653 KAYNAR TECHNOLOGY KAYNAR DIV
800 SOUTH STATE COLLEGE BLVD PO BOX 3001
FULLERTON, CALIFORNIA 92634-3001

21335 TORRINGTON CO FAFNIR BEARING DIV
59 FIELD STREET
TORRINGTON, CONNECTICUT 06790-4942

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

VENDORS

40920 MPB MINIATURE PRECISION BEARING DIV
PRECISION PARK PO BOX 547
KEENE, NEW HAMPSHIRE 03431

43991 FAG BEARING INCORPORATED
118 HAMILTON AVENUE
STAMFORD, CONNECTICUT 06904

5M902 FAIRCHILD IND INC FAIRCHILD AEROSPACE FASTENER DIV
3016 W LOMITA BLVD
TORRANCE, CALIFORNIA 90505-5103

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

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

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

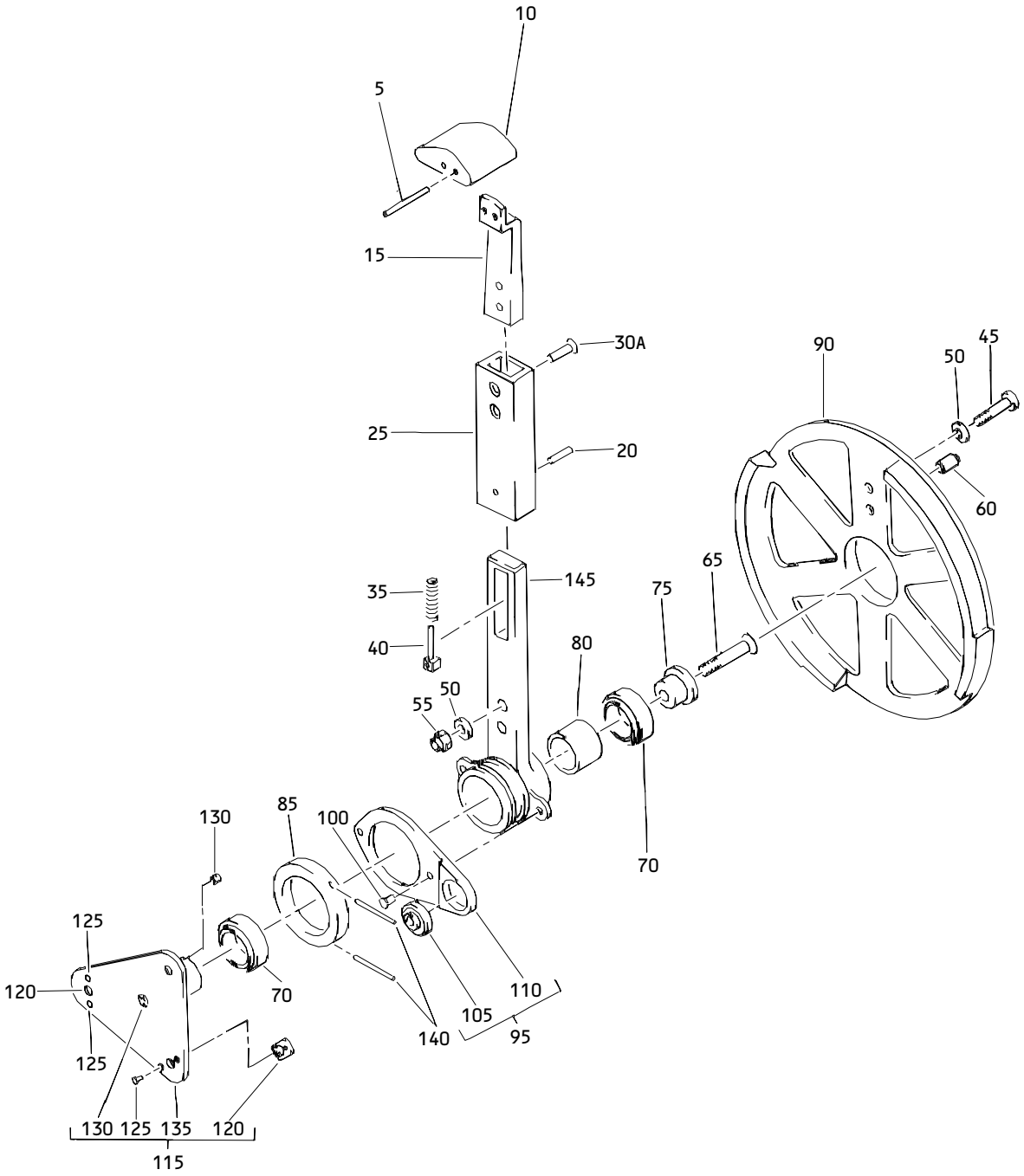
83086 NEW HAMPSHIRE BALL BEARINGS, INCORPORATED
ROUTE 202
PETERBOROUGH, NEW HAMPSHIRE 03458

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

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
AN960D416		1	50	2
AN970-3		2	10	1
BACB10AC03LJ		2	30	2
BACB10AC3L		1	105	1
BACB10AS12		1	70	2
		2	125	1
		2	140	1
BACB10FP03LJ		2	30A	2
BACB30NM3K7		2	5	1
BACB30NN4K13		1	65	1
BACB30NN4K14		2	100A	1
BACB30NR4K10		1	45	1
BACB30VT6K6		2	90	3
BACB30VT6K8		1	47	2
BACC30BL		1	58	2
BACC30BL6		2	95	3
BACN10JC4		1	55	1
BACN10JN4		1	120	2
BACN10YR3CD		2	20	1
BACR15BA3AD		1	100	2
BACR15BA3D		1	125	4
HHKSP3L		1	105	1
HST10AG6-6		2	90	3
HST10AG6-8		1	47	2
HST79-6		2	95	3
HST79CY6		2	95	3
H52732-3CD		2	20	1
KSP3L		1	105	1
KSP3LE9440A		1	105	1
KSP3LFS428		1	105	1
KSP3LG27		1	105	1
KSP3L2TS		1	105	1
LLMB539		1	70	2
		2	125	1
		2	140	1
MB539-2TS		1	70	2
		2	125	1
MB539-2TS		2	140	1
MB539DD		1	70	2
		2	125	1
		2	140	1
MB539DDFS428		1	70	2
		2	125	1
		2	140	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
MB539DDG20		1	70	2
		2	125	1
		2	140	1
MB539DDLY196		1	70	2
		2	125	1
		2	140	1
MB539DDSD610		1	70	2
		2	125	1
		2	140	1
MB539TT		1	70	2
		2	125	1
		2	140	1
MF1000-4BAC		1	120	2
MS16562-213		1	20	1
MS16562-218		1	5	2
		1	140	2
MS20427M5		1	30B	2
MS206154M7		2	65	6
MS21209F4-10		1	130	2
MS21209F4-15		2	110	1
MS39086-129		2	50	1
MS39086-135		2	40	2
MT339E		1	70	2
		2	125	1
		2	140	1
NAS607-4-4		1	60	1
NAS620C10L		2	15	1
NS103218-048		1	120	2
PLH53CD		2	20	1
RMF9201M4		1	120	2
T8124S4S		1	120	2
VN252A048		1	120	2
253T4006-4		1	80	1
253T4006-8		2	130	1
253T5423-1		1	75	1
		2	120	1
253T5710-1		1	1	RF
253T5710-2		1	1A	RF
253T5710-3		1	1B	RF
253T5710-3		2	1	RF
253T5716-1		1	15	1
253T5718-1		1	90	1
253T5718-2		1	90A	1
253T5718-3		1	90B	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
253T5718-4		2	135	1
253T5718-5		2	145	1
253T5719-1		1	115	1
253T5719-2		1	135	1
253T5719-3		2	105	1
253T5719-4		2	115	1
253T5720-1		1	25	1
253T5721-2		1	145	1
253T5721-4		1	145A	1
253T5728-3		2	25	1
253T5728-4		2	35	1
253T5729-1		1	95	1
253T5729-2		1	110	1
253T5730-1		1	85	1
254W6021-2		2	60	1
254W6022-2		2	55	1
254W6022-3		2	75	1
254W6023-1		2	70	1
254W6027-1		2	80	1
65C14183-45		1	10	1
		2	45	1
66-14222-3		1	40	1
		2	85	1
66-21426-1		1	35	1



Control Stand Flap Control Lever Assembly
Figure 1

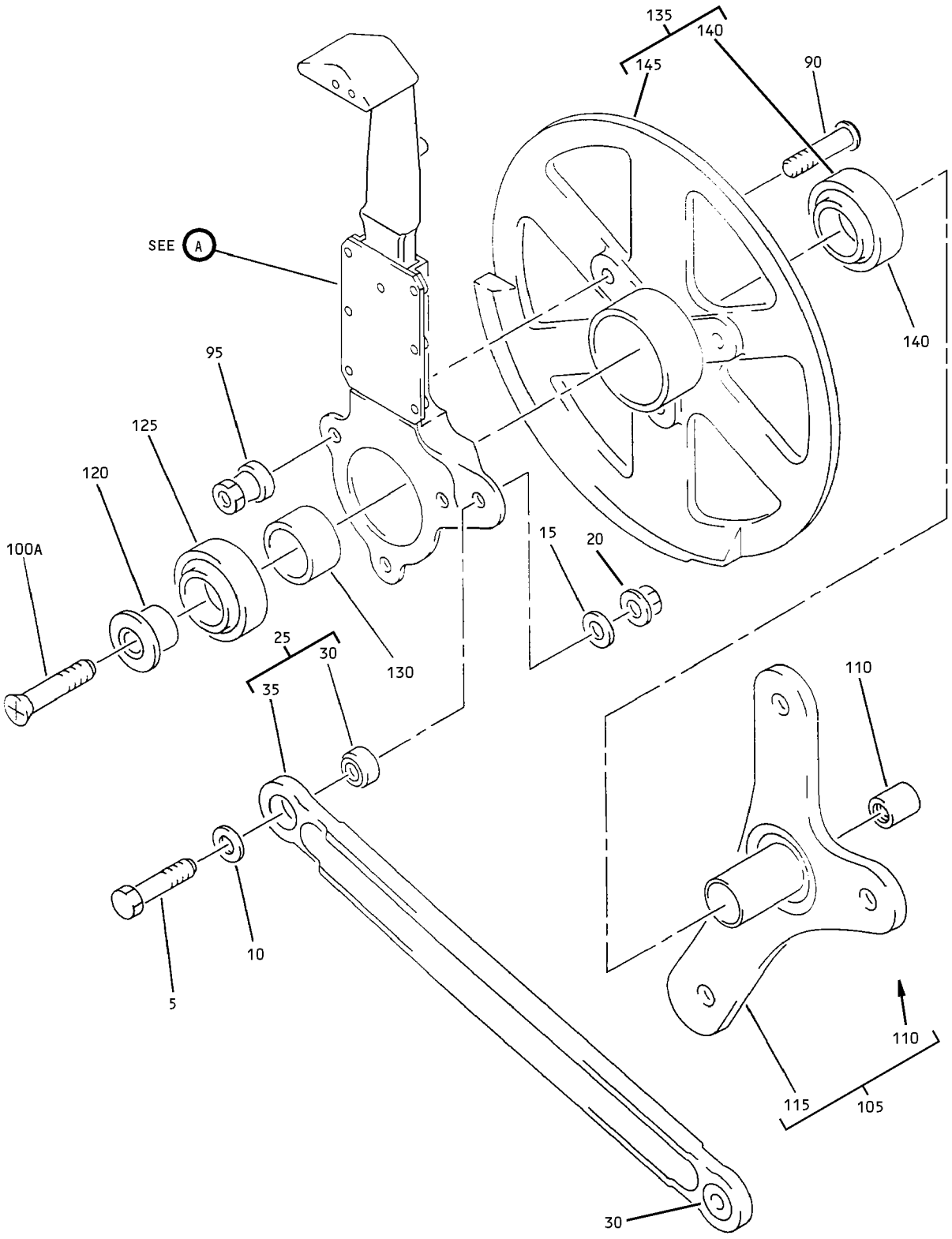
T56064

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-1	253T5710-1		LEVER ASSY-CONT STAND FLAP CONT	A	RF
-1A	253T5710-2		LEVER ASSY-CONT STAND FLAP CONT	B	RF
-1B	253T5710-3		LEVER ASSY-CONT STAND FLAP CONT (FOR DETAILS SEE FIG. 2)	C	RF
5	MS16562-218		.PIN-SPR	A,B	2
10	65C14183-45		.KNOB	A,B	1
15	253T5716-1		.LEVER-UPR	A,B	1
20	MS16562-213		.PIN-SPR	A,B	1
25	253T5720-1		.LEVER-MIDDLE	A,B	1
30	BACR15BA5D		DELETED		
30A	BACR15BA5AD		DELETED		
30B	MS20427M5		.RIVET- (SIZE DETERMINE ON INST) -------*-------	A,B	2
35	66-21426-1		.SPRING	A,B	1
40	66-14222-3		.STOP	A,B	1
45	BACB30NR4K10		.BOLT	A	1
47	HST10AG6-8		.BOLT- (VOPTK6) (SPEC BACB30VT6K8) (OPT HST10AG6-8 (V06725)) (OPT HST10AG6-8 (V56878)) (OPT HST10AG6-8 (V73197))	B	2
50	AN960D416		.WASHER	A	2
55	BACN10JC4		.NUT	A	1
58	BACC30BL		.COLLAR	B	2
60	NAS607-4-4		.PIN-DOWEL	A	1
65	BACB30NN4K13		.BOLT	A,B	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
70	MB539DDSD610		.BEARING- (V83086) (SPEC BACB10AS12) (OPT LLMB539 (V38443)) (OPT MB539-2TS (V43991)) (OPT MB539DDFS428 (V21335)) (OPT MB539TT (V43991)) (OPT MB539DDG20 (V38443)) (OPT MT339E (VK8455)) (OPT MB539DDLY196 (V40920)) (OPT MB539DD (V06144))	A,B	2
75	253T5423-1		.RETAINER-BRG	A,B	1
80	253T4006-4		.SPACER	A,B	1
85	253T5730-1		.RETAINER	A	1
90	253T5718-1		.QUADRANT- (OPT ITEM 90A)	A	1
-90A	253T5718-2		.QUADRANT- (OPT ITEM 90)	A	1
-90B	253T5718-3		.QUADRANT	B	1
95	253T5729-1		.LINK ASSY ATTACHING PARTS	A,B	1
100	BACR15BA3AD		.RIVET- (SIZE DETERMINE ON INST) -------*-------	A,B	2
105	KSP3L		..BEARING- (V38443) (SPEC BACB10AC3L) (OPT HHKSP3L (V38443)) (OPT KSP3LE9440A (V21335)) (OPT KSP3LFS428 (V21335)) (OPT KSP3L2TS (V43991)) (OPT KSP3LG27 (V30163))	A,B	1

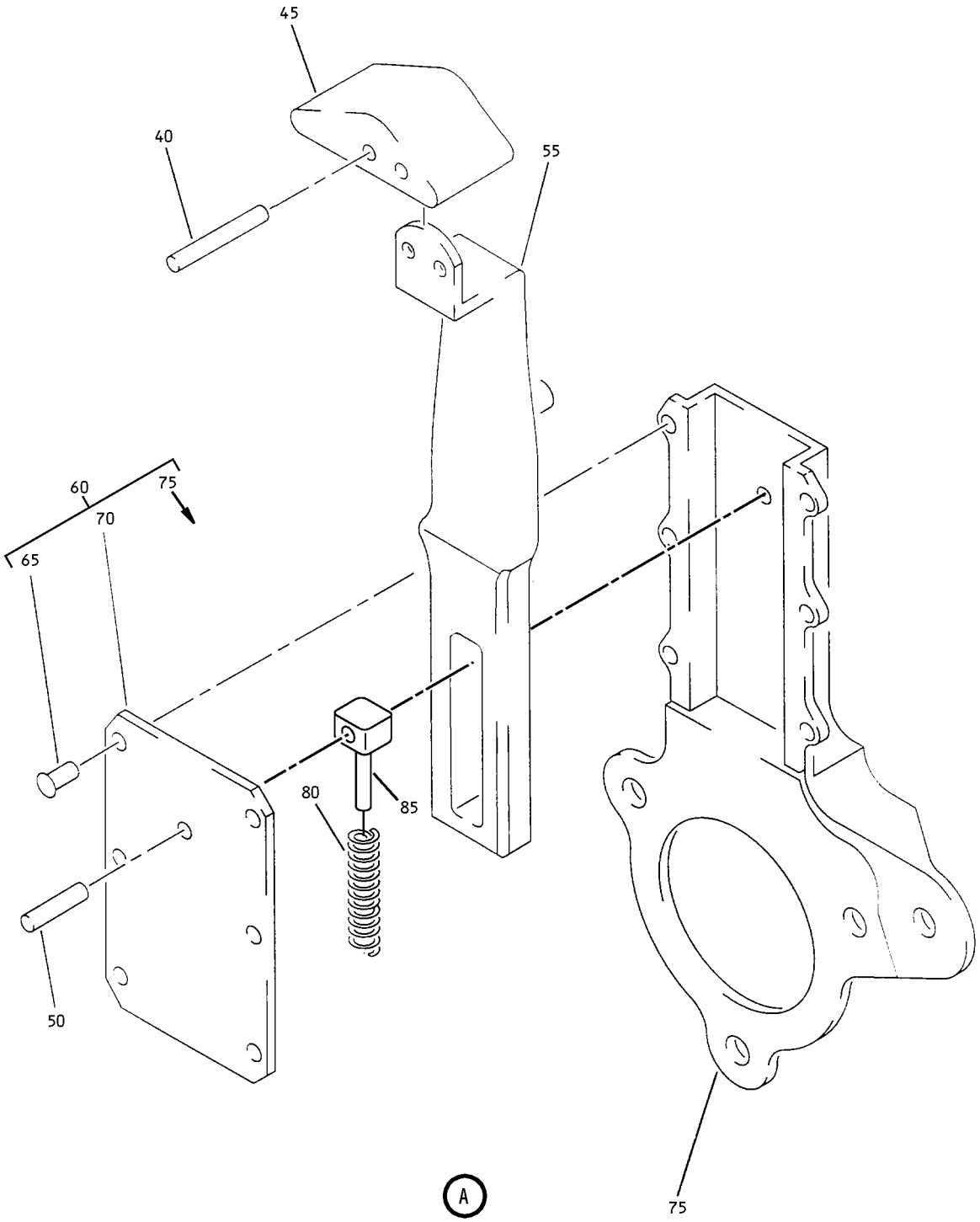
FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
110	253T5729-2		..PLATE	A,B	1
115	253T5719-1		.PIVOT ASSY	A,B	1
120	T8124S4S		..NUTPLATE-	A,B	2
			(V71087)		
			(SPEC BACN10JN4)		
			(OPT MF1000-4BAC		
			(V15653))		
			(OPT NS103218-048		
			(V80539))		
			(OPT RMF9201M4		
			(V72962))		
			(OPT VN252A048		
			(V92215))		
			(OPT VN252A048		
			(V92215))		
			(OPT T8124S4S		
			(V11815))		
			ATTACHING PARTS		
125	BACR15BA3D		..RIVET-	A,B	4
			(SIZE DETERMINE ON INST)		
			-------*-------		
130	MS21209F4-10		..INSERT	A,B	2
135	253T5719-2		..PIVOT	A,B	1
140	MS16562-218		.PIN-SPR	A	2
145	253T5721-2		.LEVER-LWR	A	1
-145A	253T5721-4		.LEVER-LWR	B	1

- Item Not Illustrated



Control Stand Flap Control Lever Assembly
Figure 2 (Sheet 1)

K11470



Control Stand Flap Control Lever Assembly
Figure 2 (Sheet 2)

K11563

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	02-					
R	-1	253T5710-3		LEVER ASSY-FLAP CONT.	C	RF
R	5	BACB30NM3K7		.BOLT	C	1
R	10	AN970-3		.WASHER	C	1
R	15	NAS620C10L		.WASHER	C	1
R	20	H52732-3CD		.NUT- (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))	C	1
R	25	253T5728-3		.LINK ASSY	C	1
R	30	BACB10AC03LJ		..BEARING- (OPT ITEM 30A)	C	2
R	-30A	BACB10FP03LJ		..BEARING- (OPT ITEM 30)	C	2
R	35	253T5728-4		..LINK	C	1
R	40	MS39086-135		.PIN	C	2
R	45	65C14183-45		.KNOB	C	1
R	50	MS39086-129		.PIN	C	1
R	55	254W6022-2		.HANDLE	C	1
R	60	254W6021-2		.HANDLE ASSY	C	1
R	65	MS206154M7		..RIVET	C	6
R	70	254W6023-1		..PLATE-COVER	C	1
R	75	254W6022-3		..HANDLE	C	1
R	80	254W6027-1		.SPRING	C	1
R	85	66-14222-3		.STOP	C	1
R	90	HST10AG6-6		.BOLT- (V0PTK6) (SPEC BACB30VT6K6) (OPT HST10AG6-6 (V06725)) (OPT HST10AG6-6 (V56878)) (OPT HST10AG6-6 (V73197))	C	3

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	02-					
R	95	HST79CY6		.COLLAR- (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V92215)) (OPT HST79CY6 (V56878)) (OPT HST79CY6 (V5M902))	C	3
	100	BACB30NM4K14		DELETED		
R	100A	BACB30NN4K14		.BOLT	C	1
R	105	253T5719-3		.PIVOT ASSY	C	1
R	110	MS21209F4-15		..INSERT	C	1
R	115	253T5719-4		..PIVOT	C	1
R	120	253T5423-1		.RETAINER-BRG	C	1
R	125	MB539DDSD610		.BEARING- (V83086) (SPEC BACB10AS12) (OPT LLMB539 (V38443)) (OPT MB539-2TS (V43991)) (OPT MB539DDFS428 (V21335)) (OPT MB539TT (V43991)) (OPT MB539DDG20 (V38443)) (OPT MT339E (VK8455)) (OPT MB539DDLY196 (V40920)) (OPT MB539DD (V06144))	C	1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	02-					
R	130	253T4006-8		.SPACER	C	1
R	135	253T5718-4		.QUADRANT ASSY	C	1
R	140	MB539DDSD610		..BEARING- (V83086) (SPEC BACB10AS12) (OPT LLMB539 (V38443)) (OPT MB539-2TS (V43991)) (OPT MB539DDFS428 (V21335)) (OPT MB539TT (V43991)) (OPT MB539DDG20 (V38443)) (OPT MT339E (VK8455)) (OPT MB539DDLY196 (V40920)) (OPT MB539DD (V06144))	C	1
R	145	253T5718-5		..QUADRANT	C	1

- Item Not Illustrated