

 **BOEING**  
COMPONENT  
MAINTENANCE MANUAL

TO: ALL HOLDERS OF TRAILING EDGE FLAP DRIVE BEARING SUPPORT ASSEMBLY COMPONENT  
MAINTENANCE MANUAL 27-51-83

REVISION NO. 0 DATED OCT 01/87

HIGHLIGHTS

All data formerly in manual 27-51-91 is included in this manual 27-51-83.

CHAPTER/SECTION

AND PAGE NO.

ALL PAGES

DESCRIPTION OF CHANGE

We are incorporating an improved computer program with this revision cycle which makes it necessary to reissue all previously issued pages, whether or not any significant changes have been made to those pages. In some cases revision bars appear on lines containing no changes; however, such anomalies can be quickly resolved by referring to the specific highlights. Pages unchanged in this revision cycle bear Jul 10/83 dates, irrespective of when the last significant changes were made.

Please remove and destroy all previously issued pages and insert these pages in their place.

ALL PAGES

Added part number to top of pages.

1005-1006

Changed part no. of nut.

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HIGHLIGHTS

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Page 1

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TRAILING EDGE FLAP DRIVE  
BEARING SUPPORT ASSEMBLY  
PART NUMBER 256T3600-5,-6,-7,-8

COMPONENT MAINTENANCE MANUAL  
WITH  
ILLUSTRATED PARTS LIST

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TITLE PAGE

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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

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TR & SB RECORD

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PAGE	DATE	CODE	PAGE	DATE	CODE
27-51-83			ILLUSTRATED PARTS LIST		
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1	OCT 01/87	01	1004	OCT 01/87	01
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TR & SB RECORD					
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### 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                                      | 4. List of Effective Pages   |
| 2. Record of Revisions                             | 5. Table of Contents         |
| 3. Temporary Revision &<br>Service Bulletin Record | 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.

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INTRODUCTION

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TRAILING EDGE FLAP DRIVE BEARING SUPPORT ASSEMBLY

DESCRIPTION AND OPERATION

1. Description and Operation

A. The trailing edge flap drive bearing support assemblies consist of aluminum angles and rod assemblies which support the drive shaft for the trailing edge flap.

2. Leading Particulars (Approximate)

- A. Width -- 8.5 inches (256T3600-5, -6)  
6.0 inches (256T3600-7, -8)
- B. Length -- 10.0 inches (256T3600-5, -6)  
8.0 inches (256T3600-7, -8)
- C. Height -- 11.5 inches (256T3600-5, -6)  
7.0 inches (256T3600-7, -8)
- D. Weight -- 3 pounds

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DESCRIPTION & OPERATION

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CHECK

1. Check all parts for obvious defects in accordance with standard industry practices.
2. Magnetic particle check per 20-20-01 -- Bearing housing (160, IPL Fig. 1).
3. Penetrant check per 20-20-02 -- Clevis (85).

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REPAIR – GENERAL1. Content

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

<u>P/N</u>	<u>NAME</u>	<u>REPAIR</u>
--	MISC PARTS REFINISH	1-1

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
20-43-01	Chromic Acid Anodizing

3. Materials

NOTE: Equivalent substitutes may be used.

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

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REPAIR-GENERAL

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MISCELLANEOUS PARTS REFINISH – REPAIR 1-1

NOTE: Repair of these parts consists of restoration of original finish.

IPL FIG. & ITEM	MATERIAL	FINISH
<u>Fig. 1</u>  Clevis (85) Angle (110,115, 120,125,130,135) Bracket (140,145)  Bearing housing (160)	Al alloy    15-5PH CRES, 180-200 ksi	Chromic acid anodize and apply one coat of BMS 10-11, type 1 primer (F-18.13) all over.   Passivate (F-17.09) all over.

Refinish Details  
Figure 601

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REPAIR 1-1

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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.

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VENDORS

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

22599 ESNA DIV OF AMERACE CORPORATION  
16150 STAGG STREET  
VAN NUYS, CALIFORNIA 91407

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

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

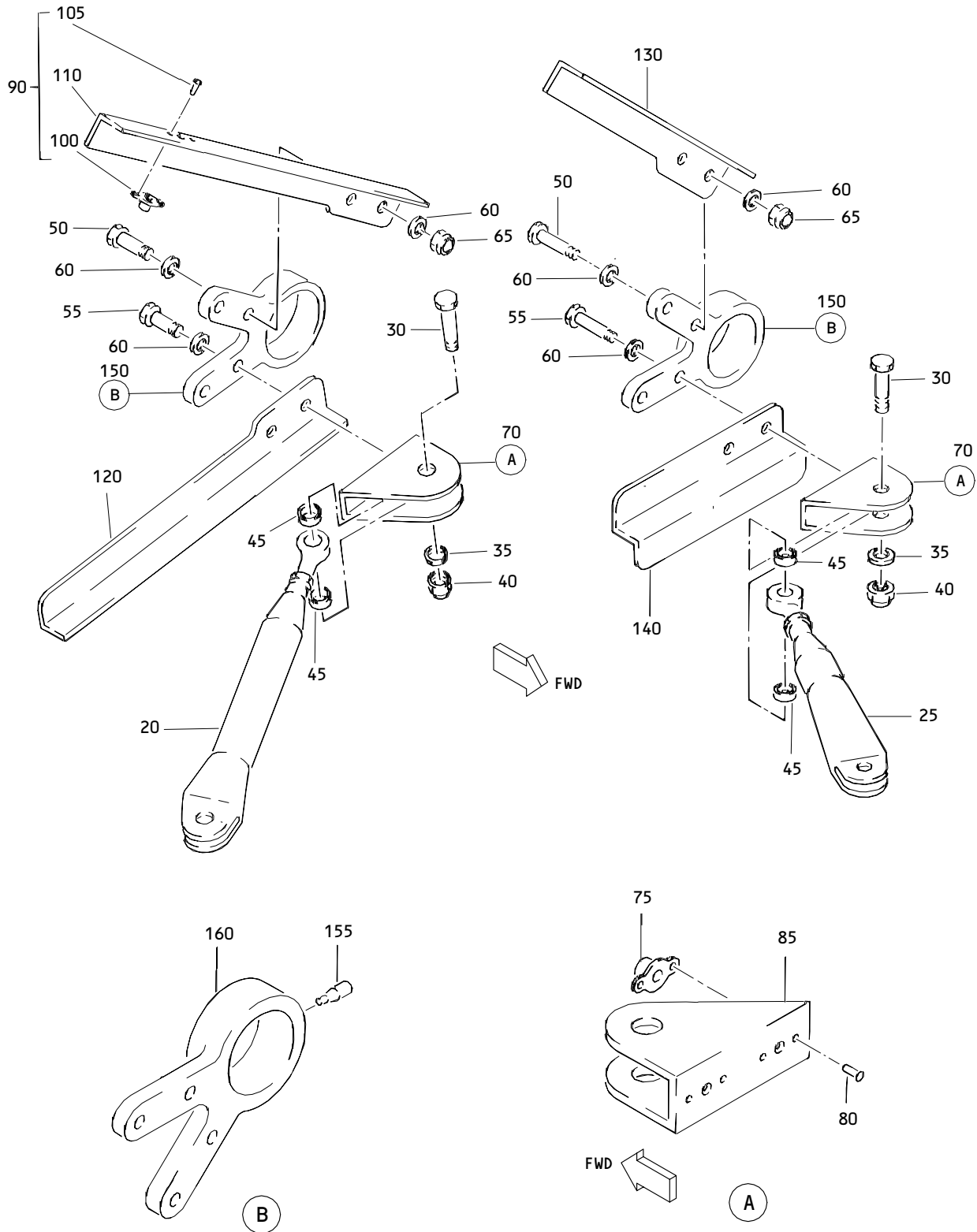
72962 ESNA DIV OF AMERACE CORP  
2330 VAUXHALL ROAD  
UNION, NEW JERSEY 07083

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

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

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Trailing Edge Flap Drive Bearing Support Assembly  
 Figure 1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01- -1	256T3600-5		SUPPORT ASSY-TE FLAP DRIVE BRG (LH)	A	RF
-5	256T3600-6		SUPPORT ASSY-TE FLAP DRIVE BRG (RH)	B	RF
-10	256T3600-7		SUPPORT ASSY-TE FLAP DRIVE BRG (LH)	C	RF
-15	256T3600-8		SUPPORT ASSY-TE FLAP DRIVE BRG (RH)	D	RF
20	251T0100-504		.ROD ASSY- (FOR DETAILS SEE 27-00-11 FIG. 01K)	AB	1
25	251T0100-503		.ROD ASSY- (FOR DETAILS SEE 27-00-11 FIG. 01K)	CD	1
30	BACB30NR4K13		ATTACHING PARTS .BOLT		1
35	AN960PD416L		.WASHER		1
40	BRH10A4		.NUT- (V52828) (SPEC BACN10JC4) (OPT H10-4BAC (V15653)) (OPT NS202101-048 (V80539)) (OPT RMLH9075-4W (V72962)) (OPT T6S428J (V71087)) (OPT VN303A048 (V92215)) (OPT 96-048 (V80539))		1
45	BACB28AK04-019		.BUSHING -----*		2
50	BACB30NR4K6		.BOLT		2
55	BACB30NR4K8		.BOLT		2
60	AN960PD416L		.WASHER		6

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-65	BRH10A4		.NUT- (V52828) (SPEC BACN10JC4) (REFER TO ITEM 40 FOR OPTIONAL PARTS)		2
70	256T3604-1		.CLEVIS ASSY		1
75	BRM200A4		..NUTPLATE- (V52828) (SPEC BACN10JP4A) (OPT MK1000-4BAC (V15653)) (OPT NS103197-048 (V80539)) (OPT RMA9201M4 (V22599)) (OPT RMA9201M4 (V72962)) (OPT T8076S428 (V71087)) (OPT VN202A1-048 (V92215)) ATTACHING PARTS		2
80	BACR15BA3AD		..RIVET -----*		4
85	256T3604-2		..CLEVIS		1
90	256T3602-1		.ANGLE ASSY	A	1
-95	256T3602-2		.ANGLE ASSY	B	1
100	BRM200A3		..NUTPLATE- (V52828) (SPEC BACN10JP3A) (OPT MK1000-3BAC (V15653)) (OPT NS103197-02 (V80539)) (OPT RMA9201M3 (V22599)) (OPT RMA9201M3 (V72962)) (OPT T8076S1032 (V71087)) (OPT VN202A1-02 (V92215)) ATTACHING PARTS		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01- 105	BACR15BA3AD		..RIVET -----*-----		2
110	256T3602-3		..ANGLE	A	1
-115	256T3602-4		..ANGLE	B	1
120	256T3602-5		.ANGLE	A	1
-125	256T3602-6		.ANGLE	B	1
130	256T3602-7		.ANGLE	C	1
-135	256T3602-8		.ANGLE	D	1
140	256T3605-1		.BRACKET	C	1
-145	256T3605-2		.BRACKET	D	1
150	256T3603-1		.HOUSING ASSY		1
155	NAS516-1		..FITTING-LUBE		1
160	256T3603-2		..HOUSING-BRG		1

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