TO: ALL HOLDERS OF INBD TE FLAP INSTL COMPONENTS COMPONENT MAINTENANCE MANUAL 27-51-84

REVISION NO. 5 DATED MAR 01/00

HIGHLIGHTS

All data formerly in manual 27-51-93 is included in this manual 27-51-84.

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

CHAPTER/SECTION AND PAGE NO.	DESCRIPTION OF CHANGE
TITLE PAGE 1 501 REPAIR 3-1 601-604 1002-1007,1009-1015, 1017,1019,1021,1023, 1025-1026,1028-1030	Added 113T1218-5 link assembly per latest engineering.
TITLE PAGE 1 REPAIR-GEN 601 REPAIR 9-1 601-603	Deleted 113T1232-7 and -8 link support.
501 REPAIR 1-1 602 REPAIR 4-1 602	Edited text and illustrations per latest engineering.

CHAPTER/SECTION AND PAGE NO.	DESCRIPTION OF CHANGE
REPAIR 6-1 601 REPAIR 6-2 601-606	Added repair instruction for bell crank assembly 113T1248.

INBOARD TRAILING EDGE FLAP INSTALLATION COMPONENTS

PART NUMBERS 113T1211-1,-2,-7,-8,-13,-14
113T1216-1,-2
113T1218-1,-5
113T1219-1,-2,-5,-6
113T1232-13,-14
113T1248-7,-9,-11,-13,-15,-17,-19

COMPONENT MAINTENANCE MANUAL
WITH
ILLUSTRATED PARTS LIST

58651

REVISION RECORD

- Retain this record in front of manual. On receipt of revision, insert revised pages in the manual, and enter revision number, date inserted and initial.

REVISION NUMBER	REVISION DATE	DATE FILED	BY	REVISION NUMBER	REVISION DATE	DATE FILED	BY

TEMPORARY REVISION AND SERVICE BULLETIN RECORD

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVE	DATE OF INCORPORATION INTO MANUAL
27-0080		PRR B11528-1	OCT 01/89 APR 01/92

PAGE	DATE	CODE
27-51-84		
TITLE PAGE		
*1	MAR 01/00	01.1
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REVISION RECORD		
1	OCT 01/87	01
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TR & SB RECORD		
1	APR 01/92	01.1
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LIST OF EFFECTIVE PAGES		
*1	MAR 01/00	01
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2	BLANK	
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*501	MAR 01/00	01.1
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*601	MAR 01/00	01.1
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*604	MAR 01/00	01.1
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ILLUSTRATED PARTS LIST		
1001	OCT 01/87	01
*1002	MAR 01/00	01.1
*1003	MAR 01/00	01.1
*1004	MAR 01/00	01.1
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*1013	MAR 01/00	01.1
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*1015	MAR 01/00	01.1
*1016	MAR 01/00	01.1
*1017	MAR 01/00	01.1
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*1019	MAR 01/00	01.1
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*1021	MAR 01/00	01.1
*1022	MAR 01/00	01.1
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*1029	MAR 01/00	01.1
*1030	MAR 01/00	01.1

PAGE	DATE	CODE

* = 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.

DESCRIPTION AND OPERATION

NOTE: This manual contains overhaul data for various components of the inboard trailing edge flap installation. Overhaul functions which cannot be performed by use of standard industry practices are included in the repair instructions for each component.

CHECK

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

2. Refer to FITS AND CLEARANCES for design dimensions and wear limits.

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

   A. Arm Fitting (105, 110, 112, 115, 120, 122, IPL Fig. 1).

   B. Support Fitting (20, 25, 30, 35 Fig. 4)

   C. Shaft (20, 25, IPL Fig. 2)

4. Penetrant check the following parts per 20-20-02.

   A. Crank (25, 30, IPL Fig. 5)

   B. Link Half (30, 35, IPL Fig. 3)

   C. Link (45, 50, 55, 60, IPL Fig. 9).

   D. Link (40, 45, IPL Fig. 10).

REPAIR - GENERAL

1. Contents

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

P/N	NAME	REPAIR
113T1211	ARM	1-1
113T1216	SHAFT	2-1
113T1218	LINK	3-1
113T1219	FITTING	4-1
	DELETED	5-1
113T1248	BELLCRANK	6-1, 6-2
	DELETED	7-1
	DELETED	8-1
113T1232	SUPPORT	9-1

2. Standard Practices

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

20-10-04 Grinding of Chrome Plated Parts
20-30-02 Stripping of Protective Finishes
20-41-01 Decoding Table for Boeing Finish Codes
20-43-03 Hard Chrome Plating
20-43-01 Chromic Acid Anodizing
20-50-03 Bearing Installation and Retention

3. Materials

NOTE: Equivalent substitutes may be used.

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

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

C. Enamel -- BMS 10-60, BAC 707 Gray Gloss (Ref 20-60-02)

D. Corrosion Preventive Compound -- MIL-C-11796, Class 1 (Ref 20-60-03)

—	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

58654

ARM ASSEMBLY - REPAIR 1-1

113T1211-1, -2, -7, -8, -13, -14

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 instruction, Fig. 601.

Do not disassemble arms (105, 110, 112, 115, 120, 122) unless necessary for repair or replacement.

1. Bushing Replacement (Ref IPL Fig. 1 and Fig. 601)

   A. Remove bushings (60, 65, 70).

   B. Install replacement bushings (60) with wet sealant (Ref 20-50-03).

   C. Machine bushing bore to dimensions shown.

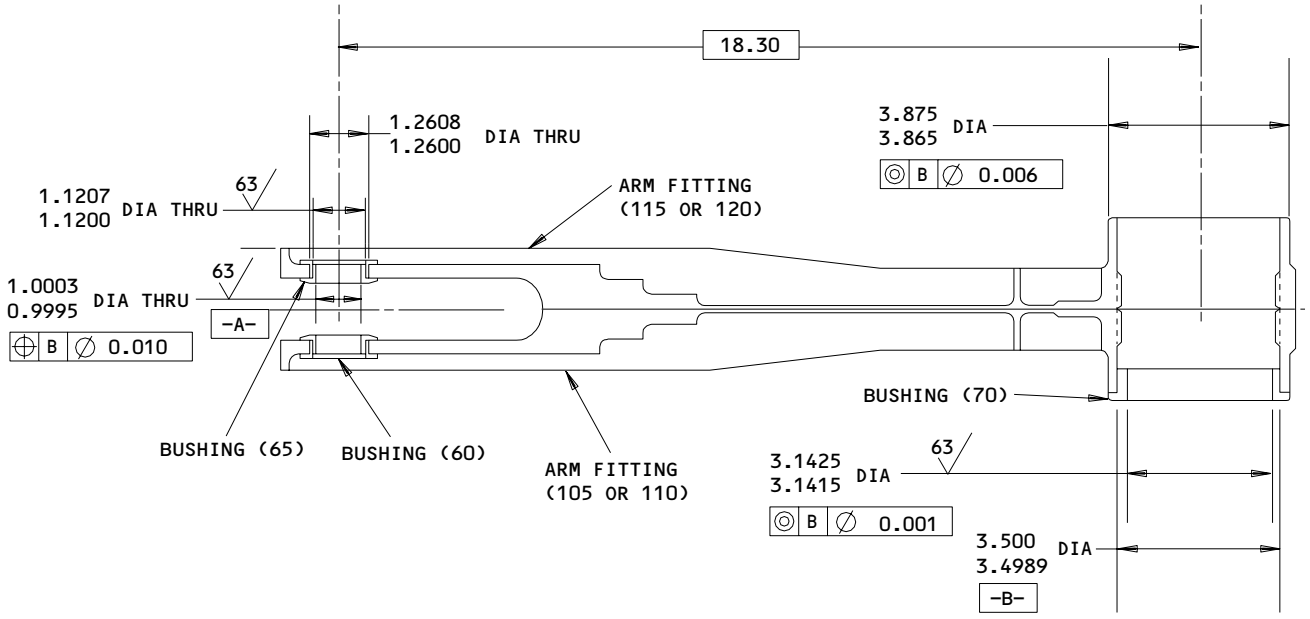
   D. Install replacement bushings (65) with wet sealant (Ref 20-50-03).

   E. Machine bushing bore to dimension shown.

   F. Install replacement bushing (70) with wet sealant (Ref 20-50-03).

   G. Machine bushing bore to dimensions shown.

   H. Fillet seal flanges with sealant.



REFINISH

ARM FITTING (105,110,112,115,120,122) -- CADMIUM-TITANIUM ALLOY PLATE (0.0005-0.0007 INCH), AND CHROMATE POST PLATE (F-15.32) TREATMENT AND APPLY ONE COAT OF BMS 10-11, TYPE 1 PRIMER (F-20.02) ALL OVER, EXCEPT OMIT CADMIUM AND PRIMER FROM SPLINES AND 3.50 DIA BORE. WIPE-ON PRIMER (F-19.45) ON SPLINES AND 3.50 DIA BORE

ARM ASSY (5,10) -- APPLY BMS 10-60, BAC707 GRAY GLOSS ENAMEL (SRF-14.9813) ALL OVER EXCEPT NO ENAMEL ON BUSHED HOLES, SPLINES AND 3.50 DIA BORE

MATERIAL: 4330M STEEL HEAT TREATED TO 220-240 KSI

ALL DIMENSIONS ARE IN INCHES

ITEM NUMBERS REFER TO IPL FIG. 1

113T1211-1,-2,-7,-8,-13,-14
Arm Assembly Repair
Figure 601

59675

SHAFT ASSEMBLY - REPAIR 2-1

113T1216-1, -2

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 instruction, Fig. 601.

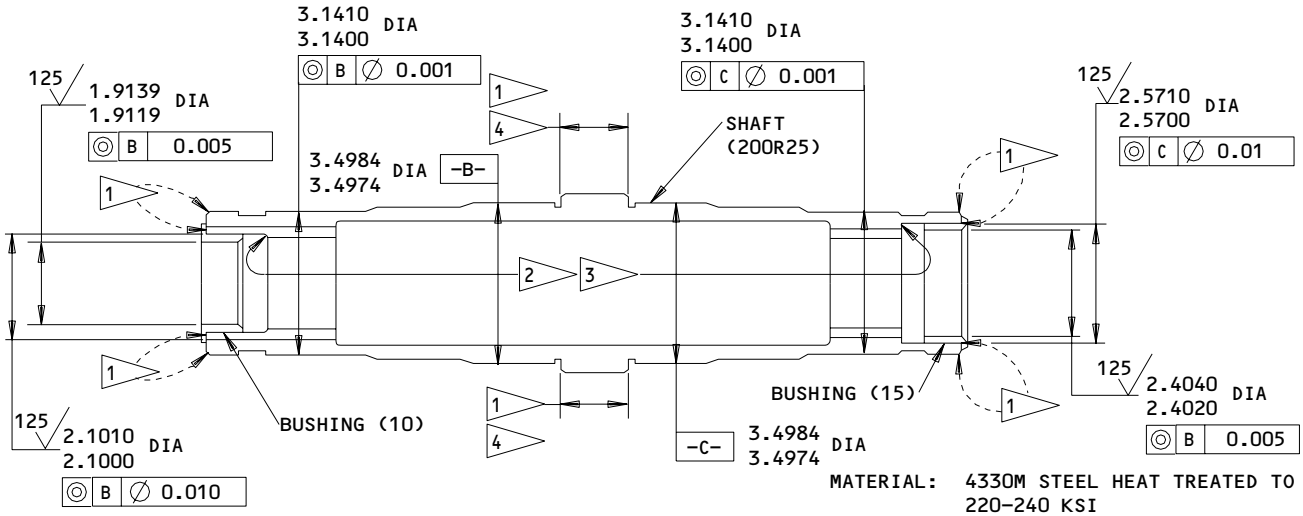
1. Bushing Replacement (Ref IPL Fig. 2 and Fig. 601)

   A. Remove bushings (10, 15).

   B. Install replacement bushings with wet sealant BMS 5-95 (Ref 20-50-03).

   C. Machine bushing bore to dimensions shown.

   D. Fillet seal flanges with sealant BMS 5-95.



MATERIAL: 4330M STEEL HEAT TREATED TO 220-240 KSI

REFINISH

CADMIUM-TITANIUM ALLOY PLATE (0.0005 TO 0.0007 INCH) AND APPLY CHROMATE POST PLATE (F-15.32) ALL OVER. APPLY ONE COAT OF PRIMER BMS 10-11 TYPE 1 (F-20.02) 1. PERAPPLY WIPE-ON PRIMER (F-19.45) ALL OVER EXCEPT AS NOTED BY 2

ALL DIMENSIONS ARE IN INCHES

ITEM NUMBERS REFER TO IPL FIG. 2

3. APPLY CORROSION PREVENTIVE COMPOUND MIL-C-11796 CLASS 1 (F-19.03)

4. APPLY BMS 10-60, BAC707 GRAY GLOSS ENAMEL (SRF-14-9813)

Shaft Assembly Repair
Figure 601

59685

LINK ASSEMBLY - REPAIR 3-1

113T1218-1, -5

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

NOTE: Do not disassemble link half (30, 35) unless necessary for repair or replacement.

1. Bushing Replacement (IPL Fig. 3, 10 and Fig. 601)

   A. Remove bushings (5, 10).

   B. Install replacement bushings (5) with wet sealant (20-50-03).

   C. Machine bushing bore to dimensions shown.

   D. Install replacement bushings (10) with wet sealant (20-50-03).

   E. Machine bore to dimensions shown.

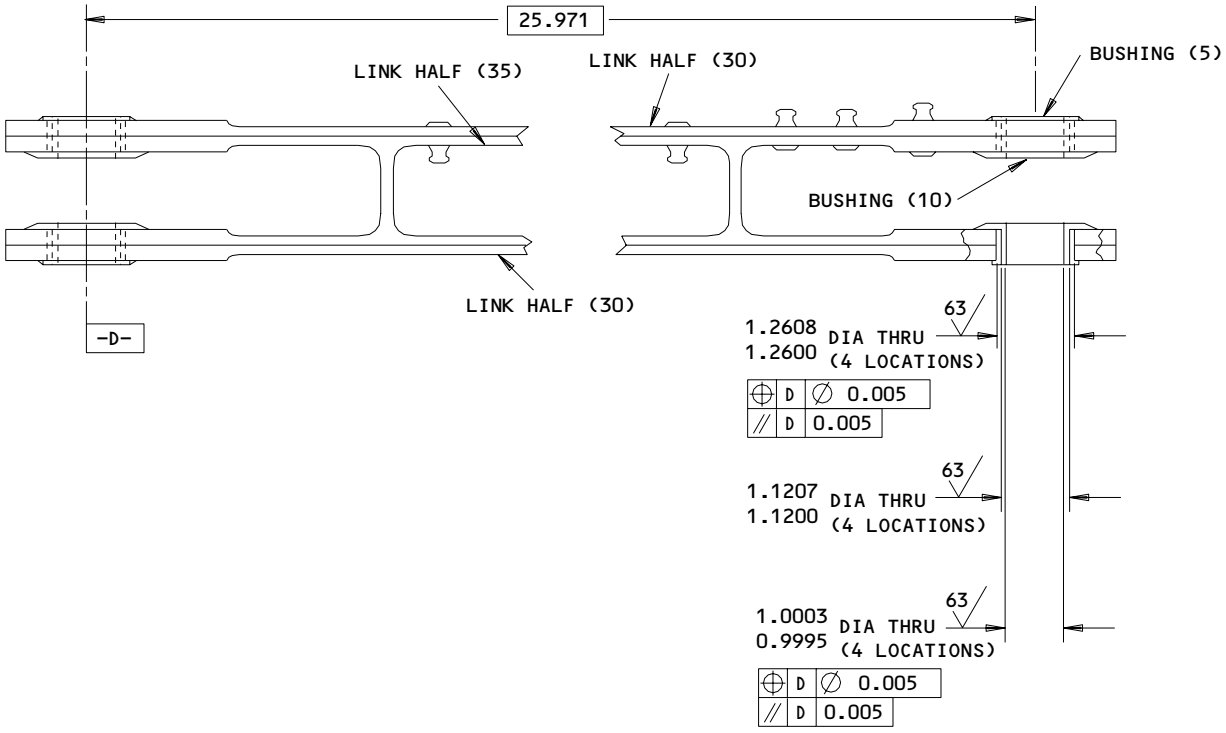
   F. Fillet seal flanges with sealant.

2. Refinish

   A. Link assembly (IPL Fig. 3; 1), (IPL Fig. 10; 1A) -- Apply BMS 10-11, Type 1 primer (SRF-14.995) and apply BMS 10-60 enamel (SRF-14.9813) all over except in bushing holes.

   B. Link (IPL Fig. 3; 30, 35) -- Chromic acid anodize and apply BMS 10-11, Type 1 primer (F-18.13) all over except no primer in holes. Material: Aluminum alloy.

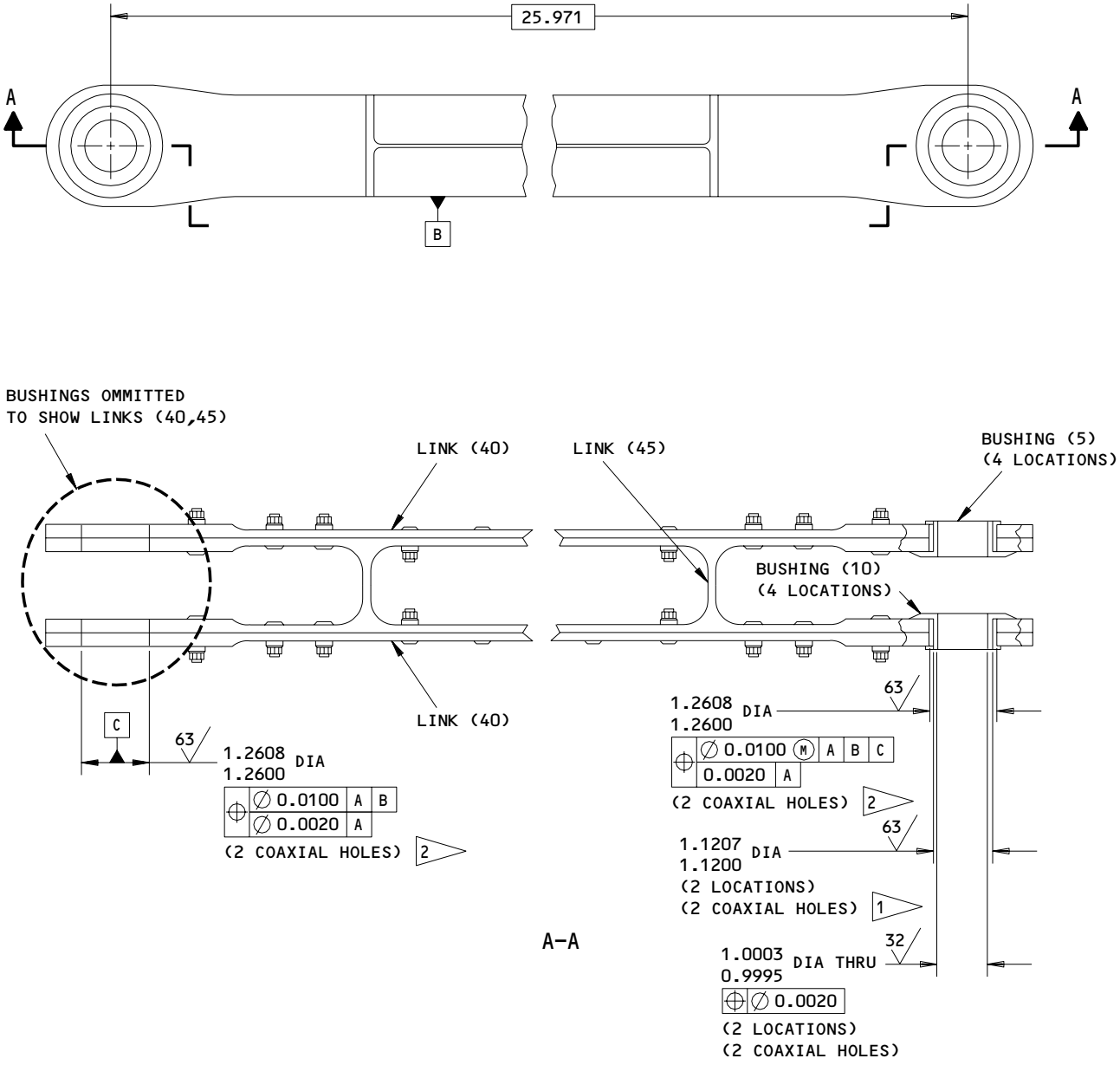
C. Link (IPL Fig. 10; 40, 45) -- Boric acid-sulfuric acid anodize (F-17.31). Apply BMS 10-11, Type 1 primer (F-20.03) all over except no primer in holes. Material: Aluminum alloy.



ALL DIMENSIONS ARE IN INCHES

ITEM NUMBERS REFER TO IPL FIG. 3

113T1218-1
Link Assembly Repair
Figure 601



1 INSIDE DIAMETER OF BUSHING (5)

2 INSIDE DIAMETER OF LINKS (40,45)

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES 0.02-0.03

ITEM NUMBERS REFER TO IPL FIG. 10

ALL DIMENSIONS ARE IN INCHES

113T1218-5
Link Assembly Repair
Figure 602

K67245

SUPPORT FITTING - REPAIR 4-1

113T1219-1, -2, -5, -6

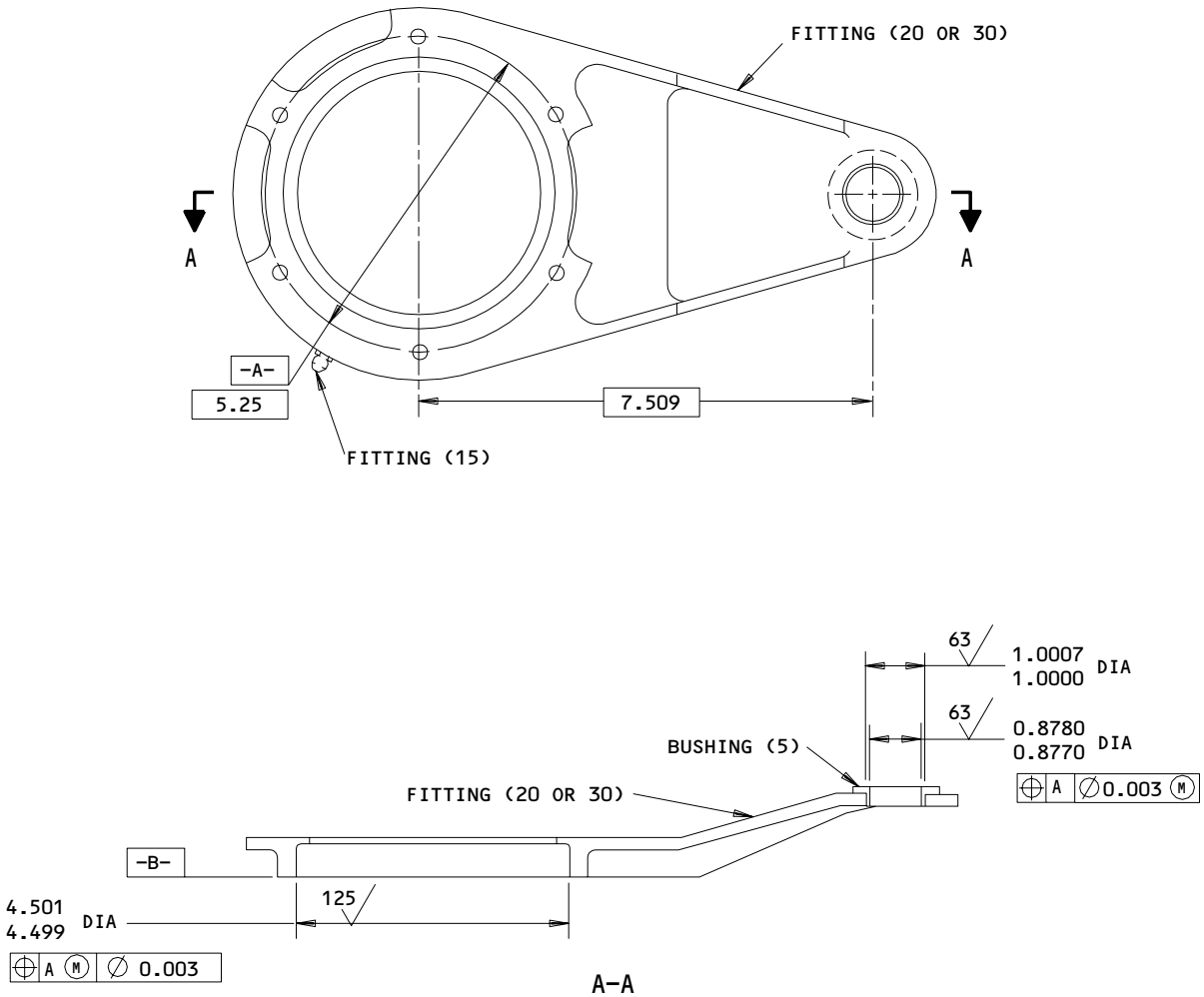
NOTE: Refer to REPAIR-GEN for list of applicable standard practices. For repair of surfaces which may only require stripping and restoration of original finish, refer to Refinish instruction, Fig. 601.

1. Bushing Replacement (Ref IPL Fig. 4 and Fig. 601)

   A. Remove bushings (5, 10).

   B. Install replacement bushings with wet primer BMS 10-11 (Ref 20-50-03).

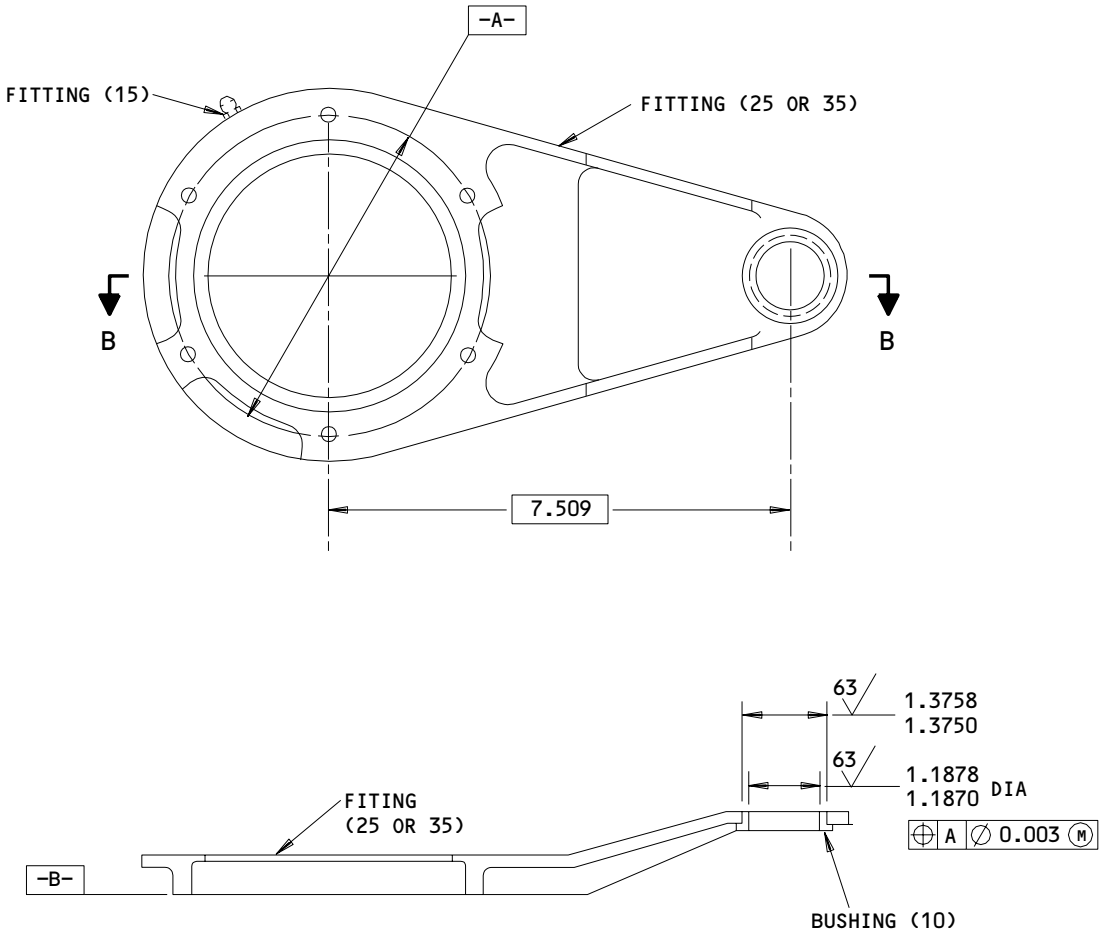
   C. Machine bushing bore to dimensions shown.



A-A

113T1219-1,-5

113T1219-1,-2,-5,-6
Support Fitting Repair
Figure 601 (Sheet 1)



113T1219-2,-6
B-B

REFINISH

FITTING (20,25,30,35) -- CADMIUM PLATE (0.0002 TO 0.0004) (F-15.02) AND APPLY ONE COAT OF PRIMER BMS 10-11, TYPE 1 (F-20.02) ALL OVER EXCEPT NO PRIMER IN HOLES

SUPPORT FITTING ASSEMBLY (1) -- APPLY BMS 10-60, BAC707 GRAY GLOSS ENAMEL (SRF-14.1913) ALL OVER EXCEPT BUSHINGS AND HOLES

MATERIAL: 15-5PH CRES HEAT TREATED TO 150-200 KSI

ALL DIMENSIONS ARE IN INCHES

ITEM NUMBERS REFER TO FIG. 4

113T1219-1,-2,-5,-6

Support Fitting Repair
Figure 601 (Sheet 2)

ARM ASSEMBLY - REPAIR 5-1

DELETED

BELLCRANK ASSEMBLY - REPAIR 6-1

113T1248-7, -9, -11, -13, -15, -17, -19

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 instruction, Fig. 601.

1. Bushing Replacement (Ref IPL Fig. 5 and Fig. 601)

   A. Remove bushings (5, 10, 15).

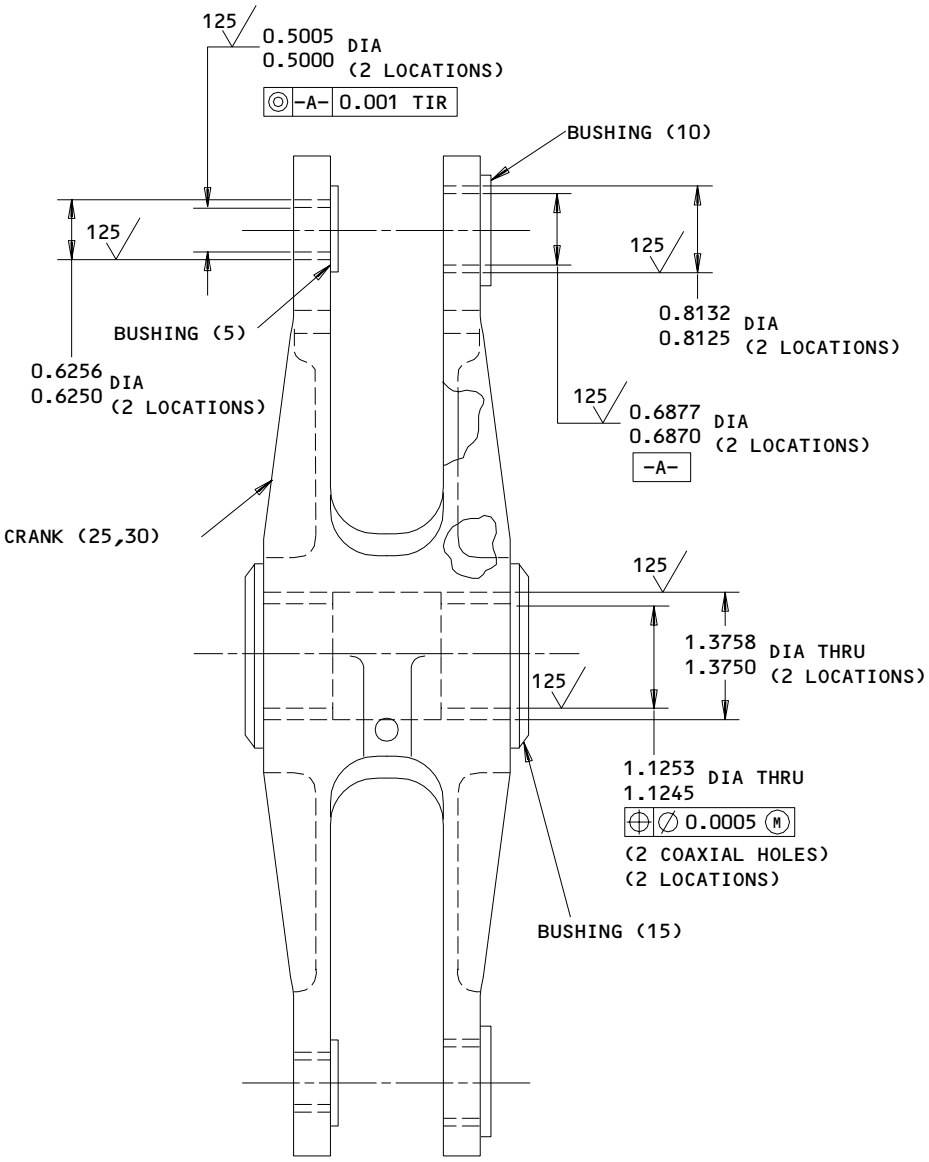
   B. Install replacement bushings with wet sealant.

   C. Machine bushing bore to dimension shown.

   D. Fillet seal bushing flanges with sealant.

2. Bellcrank Assembly Refinish

   A. Bellcrank assembly (1) -- Apply BMS 10-11, Type 1 primer (SRF-14.995) and apply BMS 10-60 enamel (SRF-14.9813) all over except no enamel and primer in bushing and lube holes.



ALL DIMENSIONS ARE IN INCHES

ITEM NUMBERS REFER TO IPL FIG. 5

113T1248-7,-9,-11,-13,-15,-17,-19
Bellcrank Assembly Repair
Figure 601

59779

BELLCRANK - REPAIR 6-2

113T1248-8, -10, -12, -16, -18

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

1. Bellcrank Repair (IPL Fig. 5 and Fig. 601 thru 604)

A. Machine the worn or damaged holes for the bushings (5, 10, 15), as necessary, to remove defects, cracks, and/or corrosion up to the limit shown in Fig. 601.

B. Break all the sharp edges as shown in Fig. 601.

C. Do a penetrant check as shown in SOPM 20-20-02.

D. Shot peen the hole per SOPM 20-10-03.
Intensity: 0.008A, coverage: 2.0.

E. Make the oversize bushings to replace the damaged bushings (5) as shown in Fig. 602 and in the following instructions.

(1) Bushing material -- 15-5PH CRES
Optional: 17-4PH CRES

(2) Break all the sharp edges.

(3) Do a magnetic particle check as shown in SOPM 20-20-01.

(4) Cadmium plate (F-15.06).
Optional: Zinc-nickel plate (F-15.40)

(5) Make sure the interference between the bushing outside diameter and the oversize hole inside diameter as shown in Fig. 602.

(6) Install the oversize bushings as shown in REPAIR 6-1.

F. Make the oversize bushings to replace the damaged bushings (10) as shown in Fig. 603 and in the following instructions.

(1) Bushing material -- Aluminum-nickel bronze

(2) Break all the sharp edges.

(3) Do a penetrant check as shown in SOPM 20-20-02.

(4) Cadmium plate (F-15.06).

(5) Make sure the interference between the bushing outside diameter and the oversize hole inside diameter as shown in Fig. 602.

(6) Install the oversize bushings as shown in REPAIR 6-1.

G. Make the oversize bushings to replace the damaged bushings (15) as shown in Fig. 604 and in the following instructions.

(1) Bushing material -- Aluminum-nickel bronze

(2) Break all the sharp edges.

(3) Do a penetrant check as shown in SOPM 20-20-02.

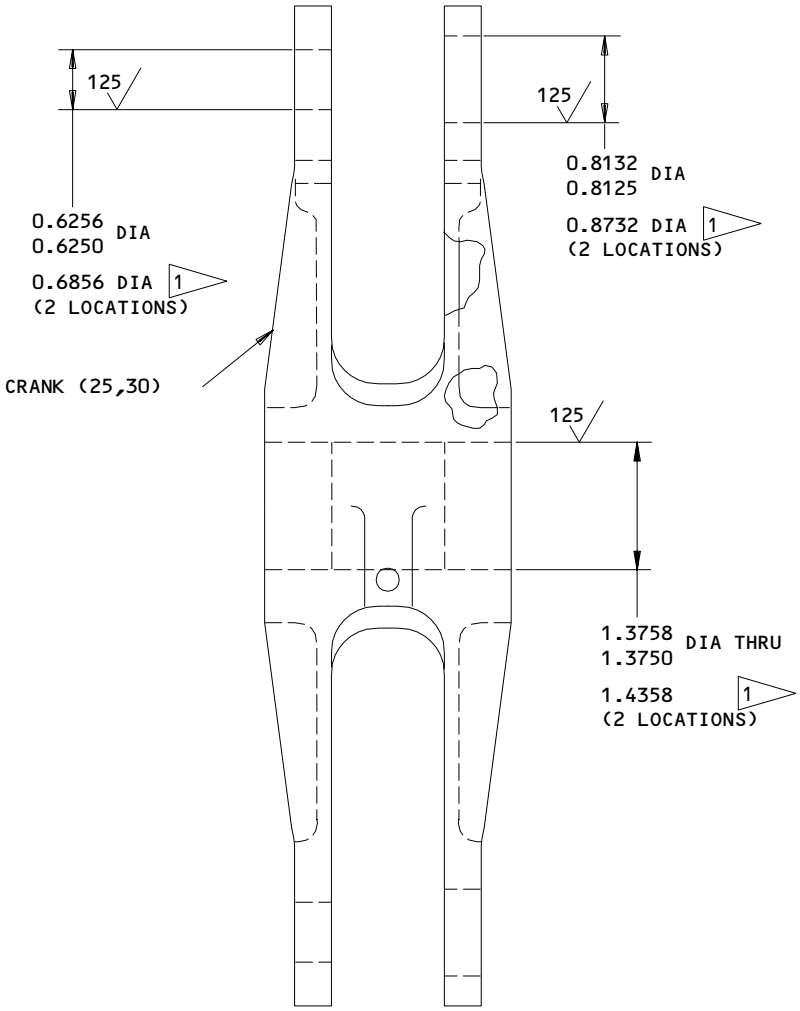
(4) Cadmium plate (F-15.06) on area indicated by flagnote 2. Cadmium plate is optional on all other areas.

(5) Make sure the interference between the bushing outside diameter and the oversize hole inside diameter as shown in Fig. 602.

(6) Install the oversize bushings as shown in REPAIR 6-1.

2. Bellcrank Refinish

A. Crank (25, 30) -- Chromic acid anodize and apply BMS 10-11, Type 1 primer (F-18.13) all over except no primer in bushing and lube holes.



1 REPAIR LIMIT

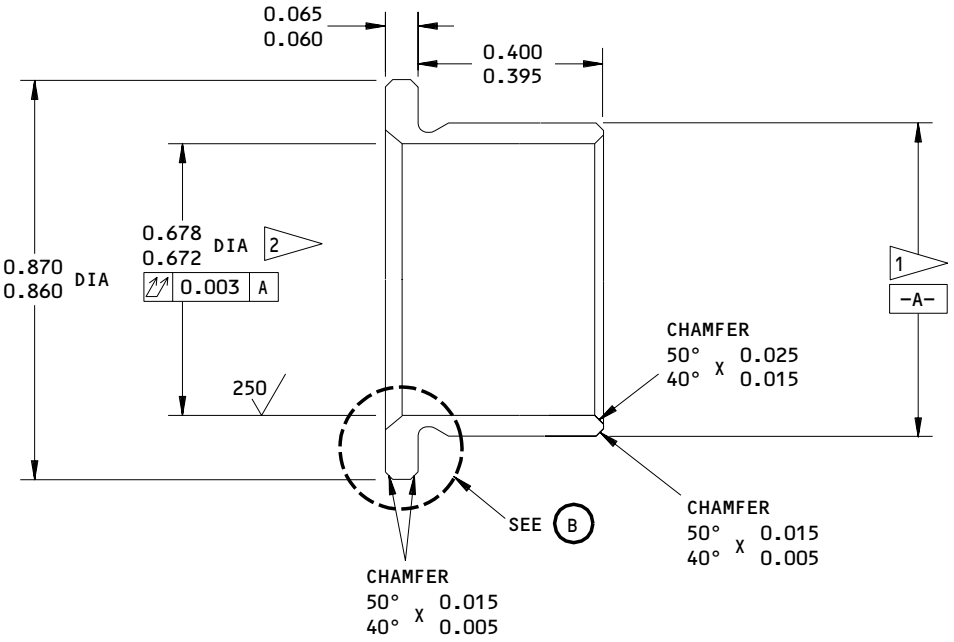
ALL DIMENSIONS ARE IN INCHES

ITEM NUMBERS REFER TO IPL FIG. 5

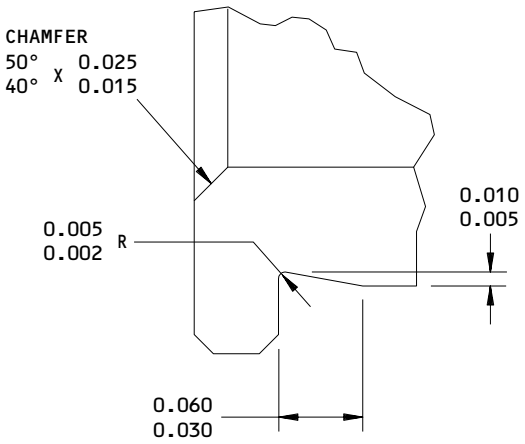
113T1248-8,-10,-12,-16,-18

Bellcrank Repair
Figure 601

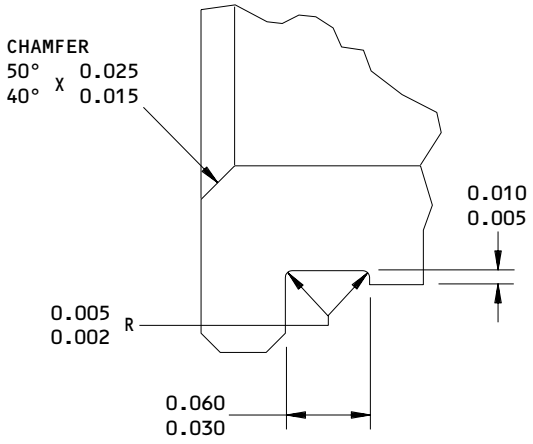
L04174



OVERSIZE REPLACEMENT FOR BUSHING (5)



TYPE 1



TYPE 2

B

1 THE OUTSIDE DIAMETER OF THE BUSHING IS EQUAL TO THE BUSHING HOLE INSIDE DIAMETR PLUS INTERFERENCE 0.0005-0.0016

2 THE BUSHING INSIDE DIAMETER TO BE MACHINED UPON INSTALLATION AS SHOWN IN REPAIR

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

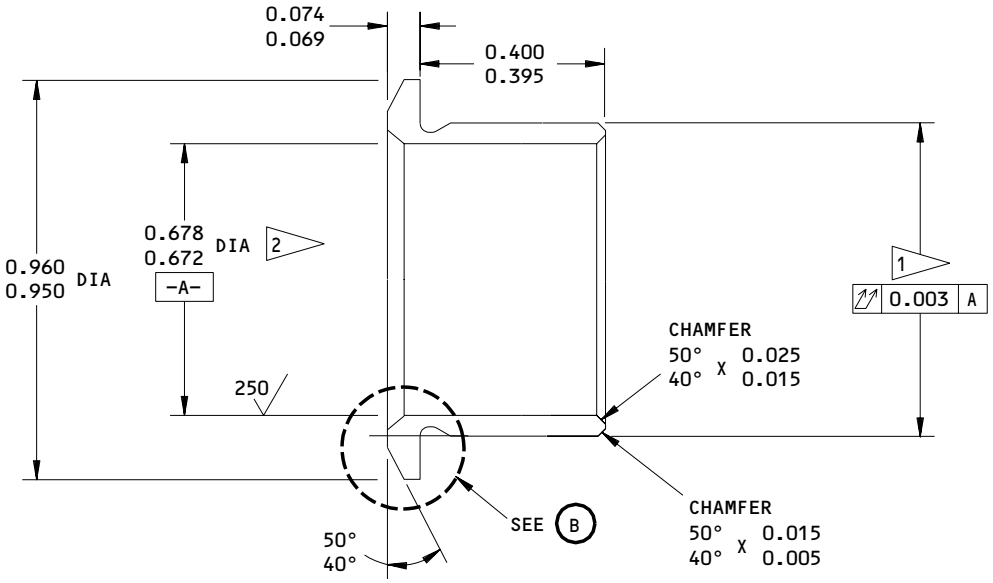
BREAK ALL SHARP EDGES

ITEM NUMBER REFER TO IPL FIG. 5

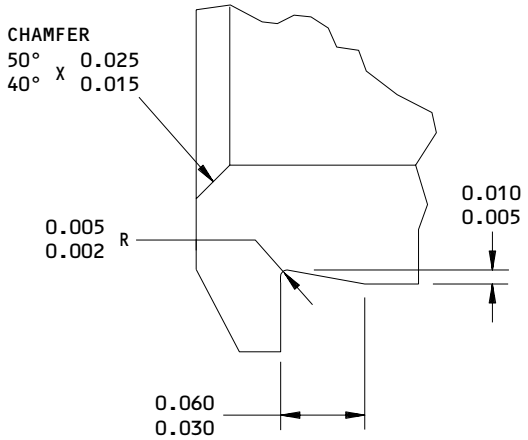
ALL DIMENSIONS ARE IN INCHES

Oversize Bushing Details
Figure 602

L04202

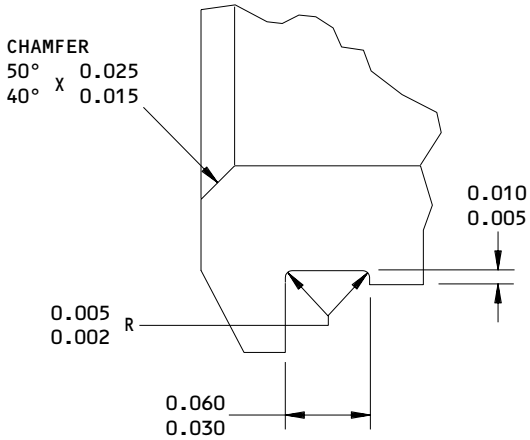


OVERSIZE REPLACEMENT FOR BUSHING (10)



TYPE 1

B



TYPE 2

1 THE OUTSIDE DIAMETER OF THE BUSHING IS EQUAL TO THE BUSHING HOLE INSIDE DIAMETR PLUS INTERFERENCE 0.0005–0.0019

2 THE BUSHING INSIDE DIAMETER TO BE MACHINED UPON INSTALLATION AS SHOWN IN REPAIR

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

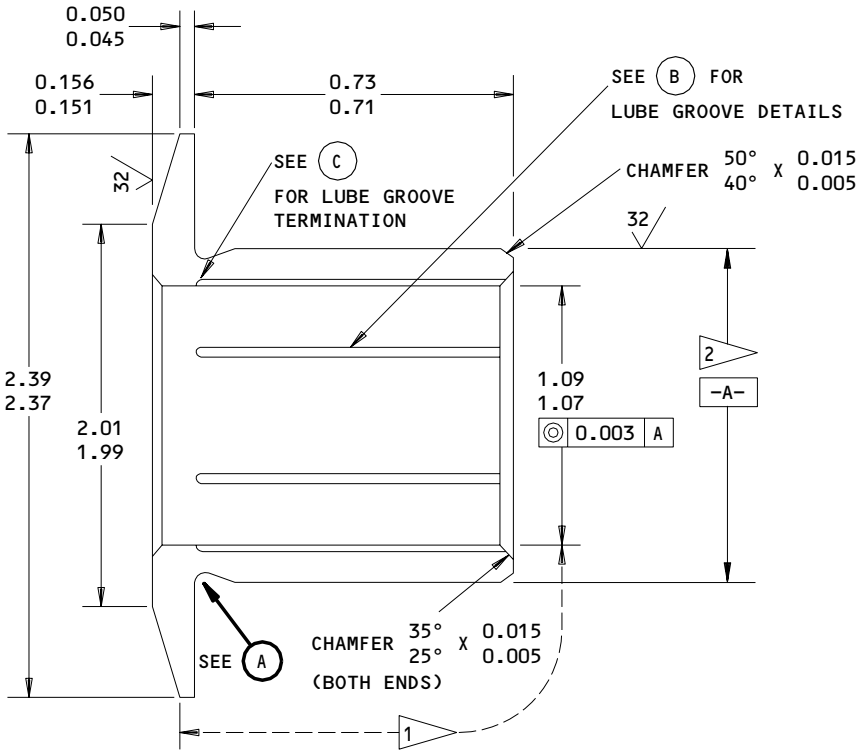
BREAK ALL SHARP EDGES

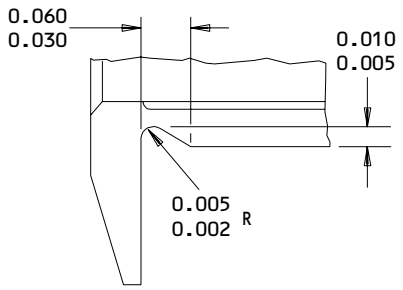
ITEM NUMBER REFER TO IPL FIG. 5

ALL DIMENSIONS ARE IN INCHES

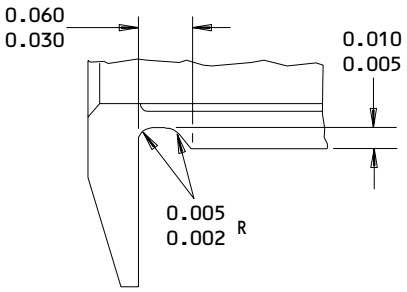
Oversize Bushing Details
Figure 603

L04464





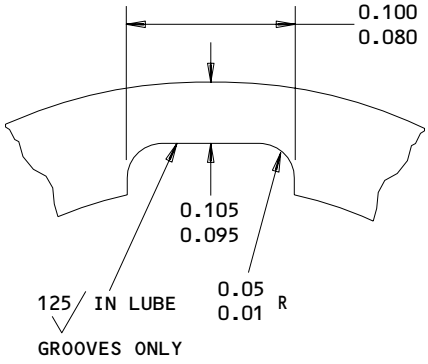
TYPE I



TYPE II

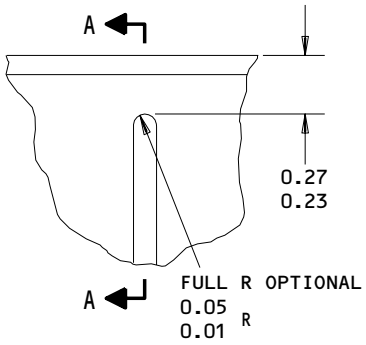
UNDERCUT TYPE I OR
TYPE II OPTIONAL

A



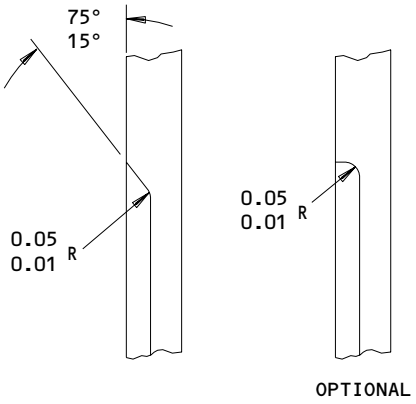
TYPICAL LUBE GROOVE DETAIL
6 GROOVES EQUALLY SPACED ON
INNER FACE OF BUSHING

B



LUBE GROOVE
TERMINATION DETAIL

C



A-A

1 CADMIUM PLATE (F-15.06)

2 THE OUTSIDE DIAMETER OF THE BUSHING IS EQUAL TO THE BUSHING HOLE INSIDE DIAMETER PLUS INTERFERENCE 0.0009-0.0025

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBER REFER TO IPL FIG. 5

ALL DIMENSIONS ARE IN INCHES

OVERSIZE REPLACEMENT FOR BUSHING (15)

Oversize Bushing Details
Figure 604

L04490

BELLCRANK ASSEMBLY - REPAIR 7-1

DELETED

BELLCRANK ASSEMBLY - REPAIR 8-1

DELETED

LINK SUPPORT - REPAIR 9-1

113T1232-13, -14

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

1. Bearing Replacement (Ref IPL Fig. 9 and Fig. 601)

   A. Remove the bolts (15) and collars (20).

   B. Remove the seals (25, 30).

   C. Remove bearings (35, 40).

   D. Install the replacement bearing (40) with wet BMS 5-95 sealant as specified by 20-50-03.

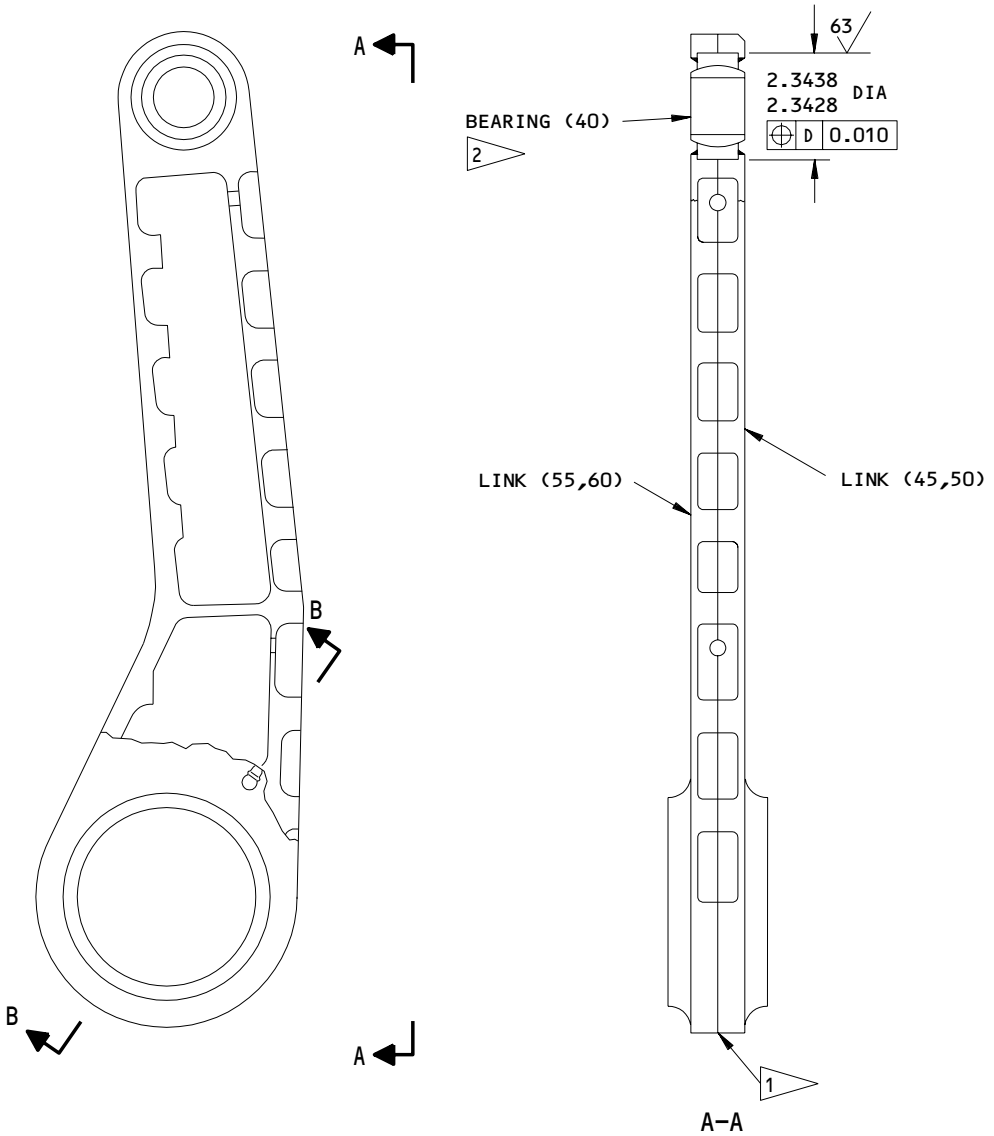
   E. Install the replacement bearing (35) with MIL-G-23827 grease as specified by 20-50-03.

   F. Install the replacement seals (25, 30) as shown in Fig. 601 with MIL-G-23827 grease.

   CAUTION: THE SEALS (25, 30) MUST BE INSTALLED AS SHOWN IN FIGURE 601. FAILURE TO DO SO WILL CAUSE BEARING DAMAGE DUE TO A LACK OF LUBRICATION.

   G. Apply a thin layer of BMS 5-95 sealant to the links (45, 50, 55, 60) before they are attached.

   H. Install the bolts (15) and collars (20).



REFINISH

LINK (45,50,55,60) -- CHROMIC ACID ANODIZE AND APPLY ONE COAT OF PRIMER BMS 10-11, TYPE 1 (F-18.13) ALL OVER EXCEPT NO PRIMER IN BUSHING AND LUBE HOLES

SUPPORT (1A,5) -- APPLY BMS 10-60, BAC707 GRAY GLOSS ENAMEL (SRF-14.9813) ALL OVER EXCEPT NO ENAMEL AND PRIMER IN HOLES

1 SEAL WITH BMS 5-95 SEALANT

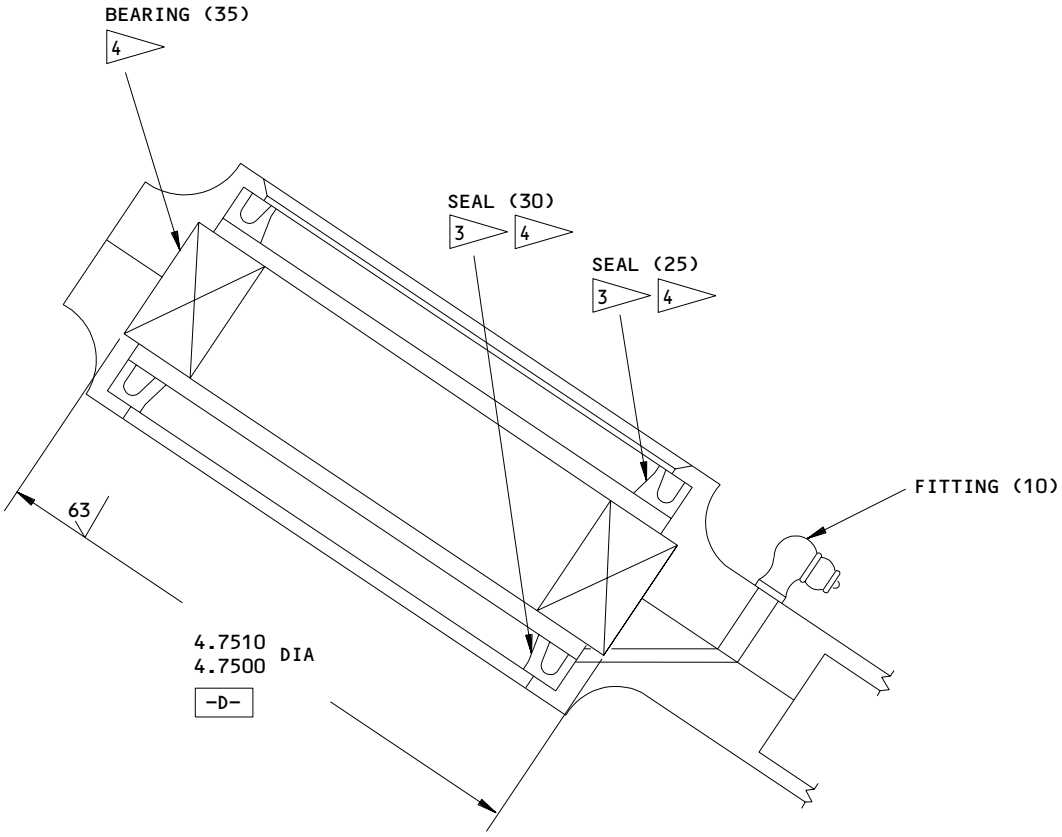
2 INSTALL WITH WET BMS 5-95 SEALANT AND FILLET SEAL THE BEARING EDGES AFTER INSTALLATION WITH BMS 5-95 SEALANT

MATERIAL: AL ALLOY

ITEM NUMBERS REFER TO IPL FIG. 9

ALL DIMENSIONS ARE IN INCHES

113T1232-13,-14
Link Support Repair
Figure 601 (Sheet 1)



B-B

3 SEALS MUST BE INSTALLED AS SHOWN
FAILURE TO DO SO WILL CAUSE BEARING
DAMAGE DUE TO A LACK OF LUBRICATION

4 INSTALL WITH MIL-G-23827 GREASE

113T1232-13,-14
Link Support Repair
Figure 601 (Sheet 2)

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

0PTK6	SPS TECHNOLOGIES INC AEROSPACE PRODUCTS DIV 5195 W 4700 SPO BOX 18459 KEARNS, UTAH 84118
06725	AIR INDUSTRIES CORPORATION 12570 KNOTT STREET GARDEN GROVE, CALIFORNIA 92641-3932
08524	DEUTSCH FASTENER CORP SEE CODE V97928
15860	NEW HAMPSHIRE BALL BEARINGS, INCORPORATED ASTRO DIVISION 155 LEXINGTON AVENUE LACONIA, NEW HAMPSHIRE 03246-2937
5M902	FAIRCHILD IND INC FAIRCHILD AEROSPACE FASTENER DIV 3016 W LOMITA BLVD TORRANCE, CALIFORNIA 90505-5103
50294	NEW HAMPSHIRE BALL BEARINGS INC 9730 INDEPENDENCE AVENUE PO BOX 2515 CHATSWORTH, CALIFORNIA 91311-4323
50632	KAMATICS CORP SUB OF KAMAN CORP 1335 BLUE HILLS ROAD BLOOMFIELD, CONNECTICUT 06002-1304
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

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

77896 REXNORD INC BEARING OPERATION
2400 CURTIS STREET
DOWNERS GROVE, ILLINOIS 60515-4005

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

9N513 VOI SHAN/CHATSWORTH DIV OF VSI CORP SUB OF FAIRCHILD IND
CHATSWORTH, CALIFORNIA 91311-5013
COMPANY NO LONGER WISHES TO BE CONSIDERED FOR FED CONTRCTG

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

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

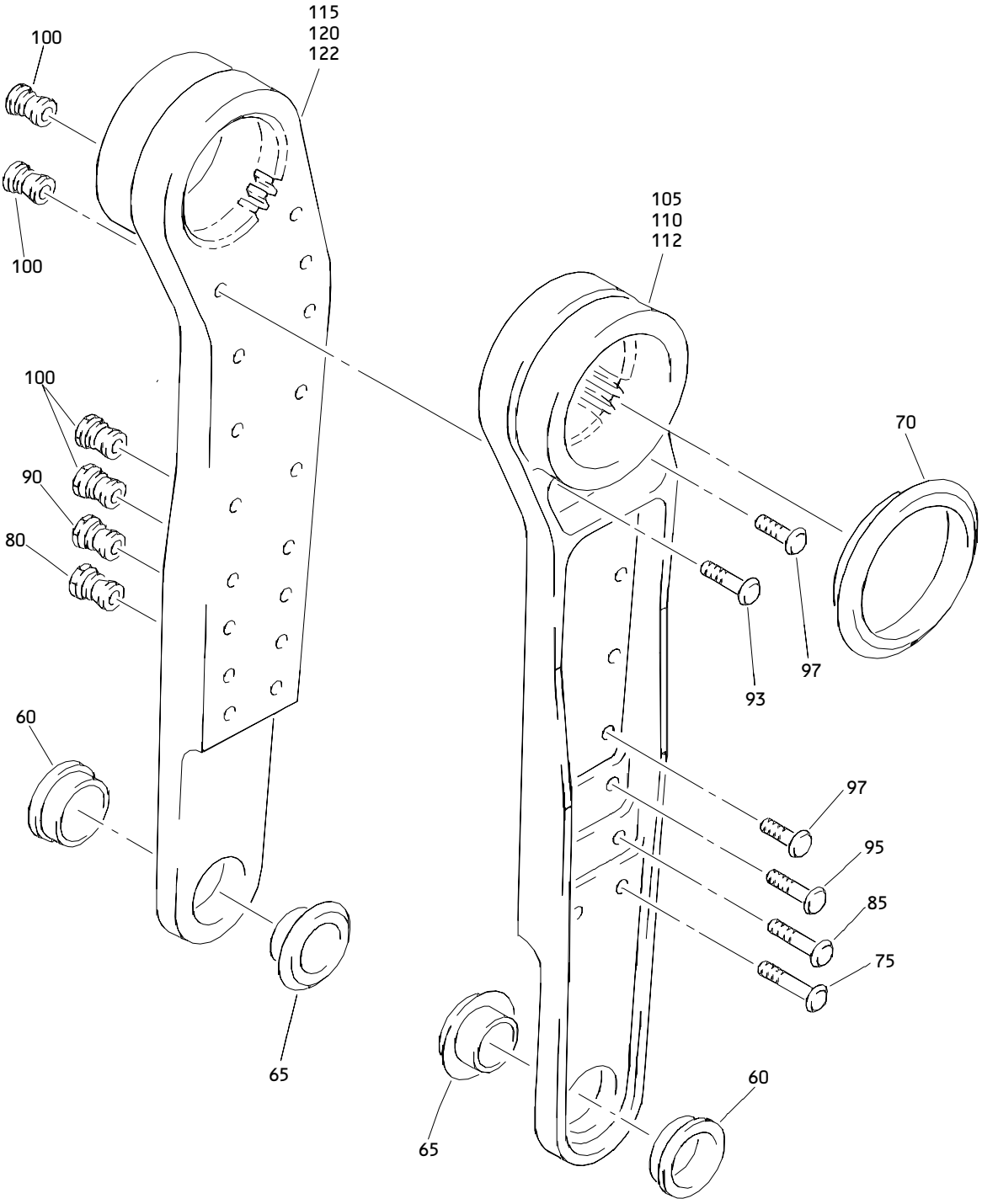
97928 DEUTSCH FASTENER CORP
3969 PARAMONT BOULEVARD
LAKEWOOD, CALIFORNIA 90712-4193

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
ADB18-301NC		9	40	1
BACB10FB18C		9	40	1
BACB28AM11B040A		6	10	2
BACB28AM19B019		5	10	1
BACB28AP08P040		6	5	2
BACB28AP14-019		5	5	1
BACB30MB10A22		1	85	2
BACB30MB12A34		1	75	2
BACB30MB8A13		1	97	2
BACB30MB8A5		1	93	9
BACB30MB8A8		1	95	2
BACB30MY6K4		4	15	38
BACB30MY6K8		4	20	4
BACB30MY8K20		9	15	15
BACB30NX6K5		10	20	8
BACB30NX6K8		10	15	4
BACB30VT6K5		10	25	30
BACC30M6		4	25	42
BACC30M8		9	20	15
BACC30X10		1	90	2
BACC30X12		1	80	2
BACC30X8		1	100	13
BACN10YT3CD		10	30	12
BACN10ZV3		10	35	30
B8941CK		9	35	1
DAT56-76A1-503		9	35	1
HL10VAZ6-4		4	15	38
HL10VAZ6-8		4	20	4
HL10VAZ8-20		9	15	15
HL1187-10		1	90	2
HL1187-12		1	80	2
HL1187-8		1	100	13
HL12-5		10	20	8
HL12-8		10	15	4
HL12VAZ6-5		10	20	8
HL12VAZ6-8		10	15	4
HL448UC10-22		1	85	2
HL448UC12-34		1	75	2
HL448UC8-13		1	97	2
HL448UC8-5		1	93	9
HL448UC8-8		1	95	2
HL79-6		4	25	42
HL79-8		9	20	15
HL87-10		1	90	2
HL87-12		1	80	2

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
HL87-8		1	100	13
HST10AG6-5		10	25	30
HTFB18C		9	40	1
KNDB18-69		9	40	1
KSC145700BZ18C		9	40	1
L8006K4		4	15	38
L802-6K5		10	20	8
L802-6K8		10	15	4
MS15001-1		6	20	1
MS15001-4		9	10	1
MS15004-1		5	15	1
NRRS18FBC		9	40	1
WC44810-22		1	85	2
WC44812-34		1	75	2
WC4488-13		1	97	2
WC4488-5		1	93	9
WC4488-8		1	95	2
WES18C		9	40	1
113T1211-1		1	5	RF
113T1211-10		1	120A	1
113T1211-11		1	110	1
113T1211-12		1	110A	1
113T1211-13		1	5B	RF
113T1211-14		1	10B	RF
113T1211-15		1	122	1
113T1211-16		1	122A	1
113T1211-17		1	112	1
113T1211-18		1	112A	1
113T1211-19		1	122B	1
113T1211-2		1	10	RF
113T1211-20		1	122C	1
113T1211-21		1	112B	1
113T1211-22		1	112C	1
113T1211-3		1	115	1
113T1211-4		1	115A	1
113T1211-5		1	105	1
113T1211-6		1	105A	1
113T1211-7		1	5A	RF
113T1211-8		1	10A	RF
113T1211-9		1	120	1
113T1216-1		1	25	RF
		3	1	RF
113T1216-2		1	30	RF
		3	5	RF
113T1216-3		3	20	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
113T1216-4		3	25	1
113T1218-1		1	35	RF
		4	1	RF
113T1218-2		4	35	1
113T1218-3		4	30	2
113T1218-5		1	35A	RF
		10	1A	RF
113T1218-7		10	45	1
113T1218-9		10	40	2
113T1219-1		1	40	RF
		5	1	RF
113T1219-2		1	40A	RF
		5	1A	RF
113T1219-3		5	20	1
113T1219-4		5	25	1
113T1219-5		1	40B	RF
		5	1B	RF
113T1219-6		1	40C	RF
		5	1C	RF
113T1219-7		5	30	1
113T1219-8		5	35	1
113T1232-10		9	60	1
113T1232-13		1	50A	RF
		9	1A	RF
113T1232-14		1	55A	RF
113T1232-14		9	5	RF
113T1232-5		9	45	1
113T1232-6		9	50	1
113T1232-9		9	55	1
113T1248-10		6	30	1
113T1248-11		1	45B	RF
		6	1B	RF
113T1248-12		6	30A	1
113T1248-13		1	45C	RF
		6	1C	RF
113T1248-15		1	45D	RF
		6	1D	RF
113T1248-16		6	30B	1
113T1248-17		1	45E	RF
		6	1E	RF
113T1248-18		6	30C	1
113T1248-19		1	45F	RF
		6	1F	RF

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
113T1248-7		1	45	RF
		6	1	RF
113T1248-8		6	25	1
113T1248-9		1	45A	RF
		6	1A	RF
113T1256-32		9	30	1
113T1256-62		9	25	1
113T1256-64		9	25A	1
113T1312-11		3	10	1
113T1312-12		3	15	1
113T1312-9		1	70	1
113T1347-33		6	15	2
113T1347-93		4	10	4
		10	10	4
113T1347-94		4	5	4
		10	5	4
113T1347-95		1	65	2
113T1347-96		1	60	2
60B00178-25		9	35	1
66014-6		4	25	42
66014-8		9	20	15
69308-10A22		1	85	2
69308-12A34		1	75	2
69308-8A13		1	97	2
69308-8A5		1	93	9
69308-8A8		1	95	2



6/9 Drive Arm Assembly
Figure 1

T64670

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-			INBD TE FLAP INSTL COMPONENTS		
	-5	113T1211-1		ARM ASSY-6/9 DRIVE (LH) (PRE SB 767-27-0080)	A	RF
	-5A	113T1211-7		ARM ASSY-6/9 DRIVE (LH)	B	RF
	-5B	113T1211-13		ARM ASSY-6/9 DRIVE (LH) (POST SB 767-27-0080)	E	RF
	-10	113T1211-2		ARM ASSY-6/9 DRIVE (RH) (PRE SB 767-27-0080)	C	RF
	-10A	113T1211-8		ARM ASSY-6/9 DRIVE (RH)	D	RF
	-10B	113T1211-14		ARM ASSY-6/9 DRIVE (RH) (POST SB 767-27-0080)	F	RF
	-25	113T1216-1		SHAFT ASSY-6/6 OUTER (LH) (FOR DETAILS SEE FIG. 2)	J	RF
	-30	113T1216-2		SHAFT ASSY-6/6 OUTER (RH) (FOR DETAILS SEE FIG. 2)	K	RF
	-35	113T1218-1		LINK ASSY-5/7 (FOR DETAILS SEE FIG. 3)	L	RF
R	-35A	113T1218-5		LINK ASSY-5/7 (FOR DETAILS SEE FIG. 10)	Y	RF
	-40	113T1219-1		FITTING ASSY-SPRT (FOR DETAILS SEE FIG. 4)	M	RF
	-40A	113T1219-2		FITTING ASSY-SPRT (FOR DETAILS SEE FIG. 4)	N	RF
	-40B	113T1219-5		FITTING ASSY-SPRT (FOR DETAILS SEE FIG. 4)	P	RF
	-40C	113T1219-6		FITTING ASSY-SPRT (FOR DETAILS SEE FIG. 4)	Q	RF
	-45	113T1248-7		CRANK ASSY-AFT FLAP DRIVE BELL (FOR DETAILS SEE FIG. 5)	R	RF
	-45A	113T1248-9		CRANK ASSY-AFT FLAP DRIVE BELL (PRE SB 767-27-0080) (FOR DETAILS SEE FIG. 5)	S	RF
	-45B	113T1248-11		CRANK ASSY-AFT FLAP DRIVE BELL (FOR DETAILS SEE FIG. 5)	T	RF
	-45C	113T1248-13		CRANK ASSY-AFT FLAP DRIVE BELL (VARIABLE) (FOR DETAILS SEE FIG. 5)	U	RF
	-45D	113T1248-15		CRANK ASSY-AFT FLAP DRIVE BELL (FOR DETAILS SEE FIG. 5)	V	RF

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	-45E	113T1248-17		CRANK ASSY-AFT FLAP DRIVE BELL (POST SB 767-27-0080) (FOR DETAILS SEE FIG. 5)	W	RF
	-45F	113T1248-19		CRANK ASSY-AFT FLAP DRIVE BELL (VARIABLE) (FOR DETAILS SEE FIG. 5)	X	RF
	-50A	113T1232-13		LINK ASSY-SPRT (FOR DETAILS SEE FIG. 9)	G	RF
	-50B	113T1232-7		DELETED		
	-55A	113T1232-14		LINK ASSY-SPRT (FOR DETAILS SEE FIG. 9)	H	RF
	-55B	113T1232-8		DELETED		
	60	113T1347-96		.BUSHING	A-F	2
	65	113T1347-95		.BUSHING	A-F	2
	70	113T1312-9		.BUSHING	A-F	1
R	75	WC44812-34		.BOLT- (V60516) (SPEC BACB30MB12A34) (OPT HL448UC12-34 (V73197)) (OPT HL448UC12-34 (V92215)) (OPT HL448UC12-34 (V97928)) (OPT 69308-12A34 (V56878)) (OPT HL448UC12-34 (V80539)) (OPT HL448UC12-34 (V08524)) (OPT HL448UC12-34 (V9N513))	A-F	2

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-80	HL1187-12		.COLLAR- (V73197) (SPEC BACC30X12) (OPT HL1187-12 (V73197)) (OPT HL87-12 (V92215)) (OPT HL1187-12 (V56878)) (OPT HL1187-12 (V92215)) (OPT HL87-12 (V56878)) (OPT HL1187-12 (V5M902))	A-F	2
85	HL448UC10-22		.BOLT- (V56878) (SPEC BACB30MB10A22) (OPT HL448UC10-22 (V73197)) (OPT HL448UC10-22 (V92215)) (OPT HL448UC10-22 (V97928)) (OPT 69308-10A22 (V56878)) (OPT HL448UC10-22 (V80539)) (OPT HL448UC10-22 (V08524)) (OPT HL448UC10-22 (V9N513)) (OPT WC44810-22 (V60516))	A-F	2

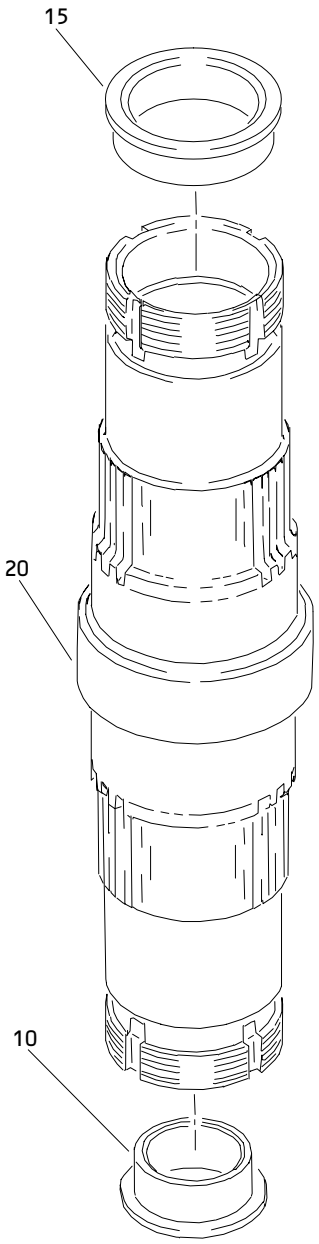
FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-90	HL1187-10		.COLLAR- (V73197) (SPEC BACC30X10) (OPT HL87-10 (V73197)) (OPT HL87-10 (V92215)) (OPT HL1187-10 (V56878)) (OPT HL1187-10 (V92215)) (OPT HL87-10 (V56878)) (OPT HL1187-10 (V5M902))	A-F	2
93	HL448UC8-5		.BOLT- (V56878) (SPEC BACB30MB8A5) (OPT HL448UC8-5 (V73197)) (OPT HL448UC8-5 (V92215)) (OPT HL448UC8-5 (V97928)) (OPT 69308-8A5 (V56878)) (OPT HL448UC8-5 (V80539)) (OPT HL448UC8-5 (V08524)) (OPT HL448UC8-5 (V9N513)) (OPT WC4488-5 (V60516))	A-F	9

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-95	HL448UC8-8		.BOLT- (V56878) (SPEC BACB30MB8A8) (OPT HL448UC8-8 (V73197)) (OPT HL448UC8-8 (V92215)) (OPT HL448UC8-8 (V97928)) (OPT 69308-8A8 (V56878)) (OPT HL448UC8-8 (V80539)) (OPT HL448UC8-8 (V08524)) (OPT HL448UC8-8 (V9N513)) (OPT WC4488-8 (V60516))	A-F	2
R	97	HL448UC8-13		.BOLT- (V56878) (SPEC BACB30MB8A13) (OPT HL448UC8-13 (V73197)) (OPT HL448UC8-13 (V92215)) (OPT HL448UC8-13 (V97928)) (OPT 69308-8A13 (V56878)) (OPT HL448UC8-13 (V80539)) (OPT HL448UC8-13 (V08524)) (OPT HL448UC8-13 (V9N513)) (OPT WC4488-13 (V60516))	A-F	2

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
100	HL1187-8		.COLLAR- (V73197) (SPEC BACC30X8) (OPT HL87-8 (V73197)) (OPT HL87-8 (V92215)) (OPT HL1187-8 (V56878)) (OPT HL1187-8 (V92215)) (OPT HL87-8 (V56878)) (OPT HL1187-8 (V5M902))	A-F	13
105	113T1211-5		.ARM FITTING	A	1
-105A	113T1211-6		.ARM FITTING	C	1
110	113T1211-11		.ARM FITTING	B	1
-110A	113T1211-12		.ARM FITTING	D	1
112	113T1211-17		.ARM FITTING- (OPT ITEM 112B)	E	1
-112A	113T1211-18		.ARM FITTING- (OPT ITEM 112C)	F	1
-112B	113T1211-21		.ARM FITTING- (OPT ITEM 112)	E	1
-112C	113T1211-22		.ARM FITTING- (OPT ITEM 112A)	F	1
115	113T1211-3		.ARM FITTING	A	1
-115A	113T1211-4		.ARM FITTING	C	1
120	113T1211-9		.ARM FITTING	B	1
-120A	113T1211-10		.ARM FITTING	D	1
122	113T1211-15		.ARM FITTING- (OPT ITEM 122B)	E	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-122A	113T1211-16		.ARM FITTING- (OPT ITEM 122C)	F	1
-122B	113T1211-19		.ARM FITTING- (OPT ITEM 122)	E	1
-122C	113T1211-20		.ARM FITTING- (OPT ITEM 122A)	F	1

- Item Not Illustrated

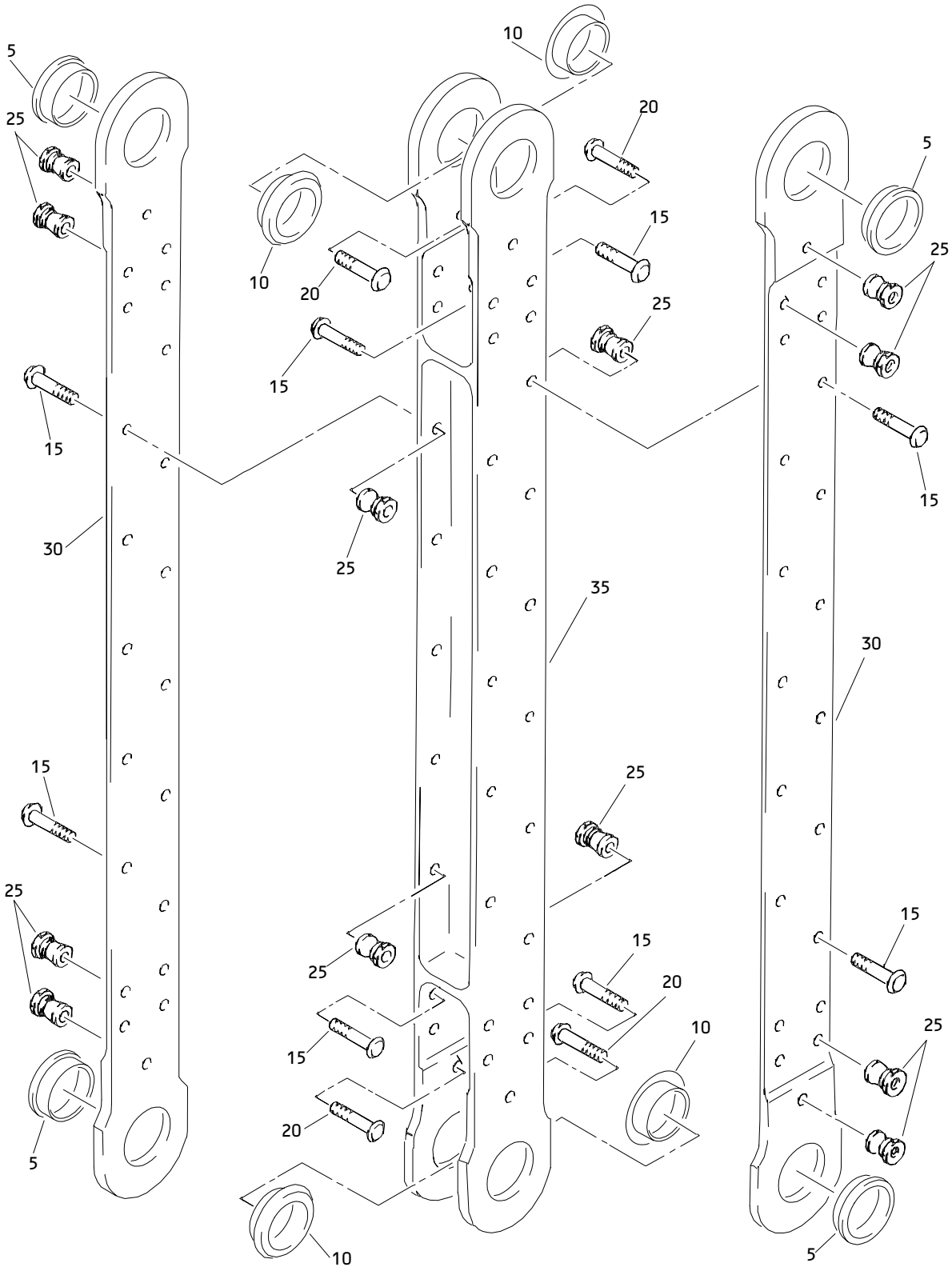


6-6 Outer Shaft Assembly
Figure 2

T64672

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-					
-1	113T1216-1		SHAFT ASSY-6/6 OUTER (LH)	J	RF
-5	113T1216-2		SHAFT ASSY-6/6 OUTER (RH)	K	RF
10	113T1312-11		.BUSHING	J,K	1
15	113T1312-12		.BUSHING	J,K	1
20	113T1216-3		.SHAFT	J	1
-25	113T1216-4		.SHAFT	K	1

- Item Not Illustrated

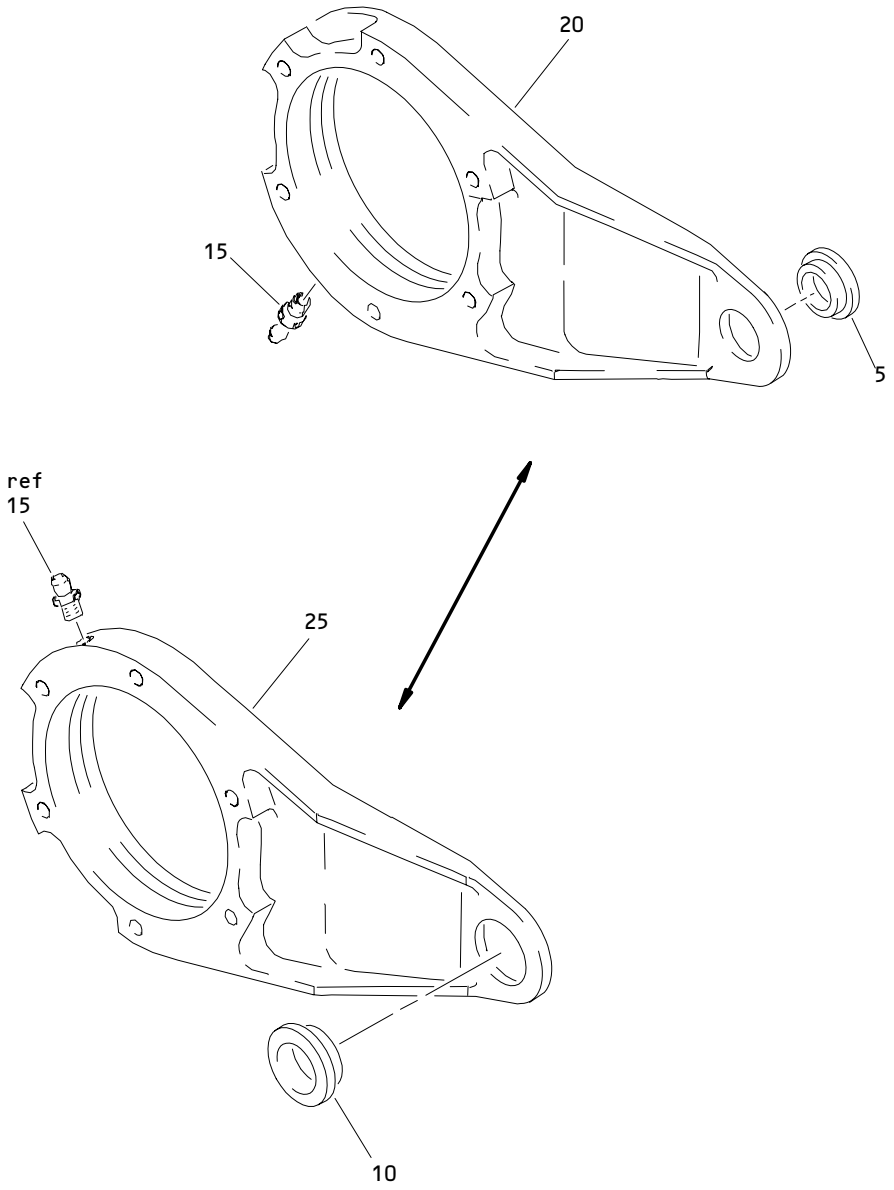


5-7 Link Assembly
Figure 3

T64673

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
03-					
-1	113T1218-1		LINK ASSY-5/7	L	RF
5	113T1347-94		.BUSHING	L	4
10	113T1347-93		.BUSHING	L	4
15	HL10VAZ6-4		.BOLT- (V60516) (SPEC BACB30MY6K4) (OPT HL10VAZ6-4 (VOPTK6)) (OPT HL10VAZ6-4 (V92215)) (OPT HL10VAZ6-4 (V97928)) (OPT L8006K4 (V06725)) (OPT HL10VAZ6-4 (V08524))	L	38
20	HL10VAZ6-8		.BOLT- (V60516) (SPEC BACB30MY6K8) (OPT HL10VAZ6-8 (VOPTK6))	L	4
25	HL79-6		.COLLAR- (V56878) (SPEC BACC30M6) (OPT HL79-6 (V73197)) (OPT HL79-6 (V92215)) (OPT 66014-6 (V56878))	L	42
30	113T1218-3		.LINK HALF	L	2
35	113T1218-2		.LINK HALF	L	1

- Item Not Illustrated

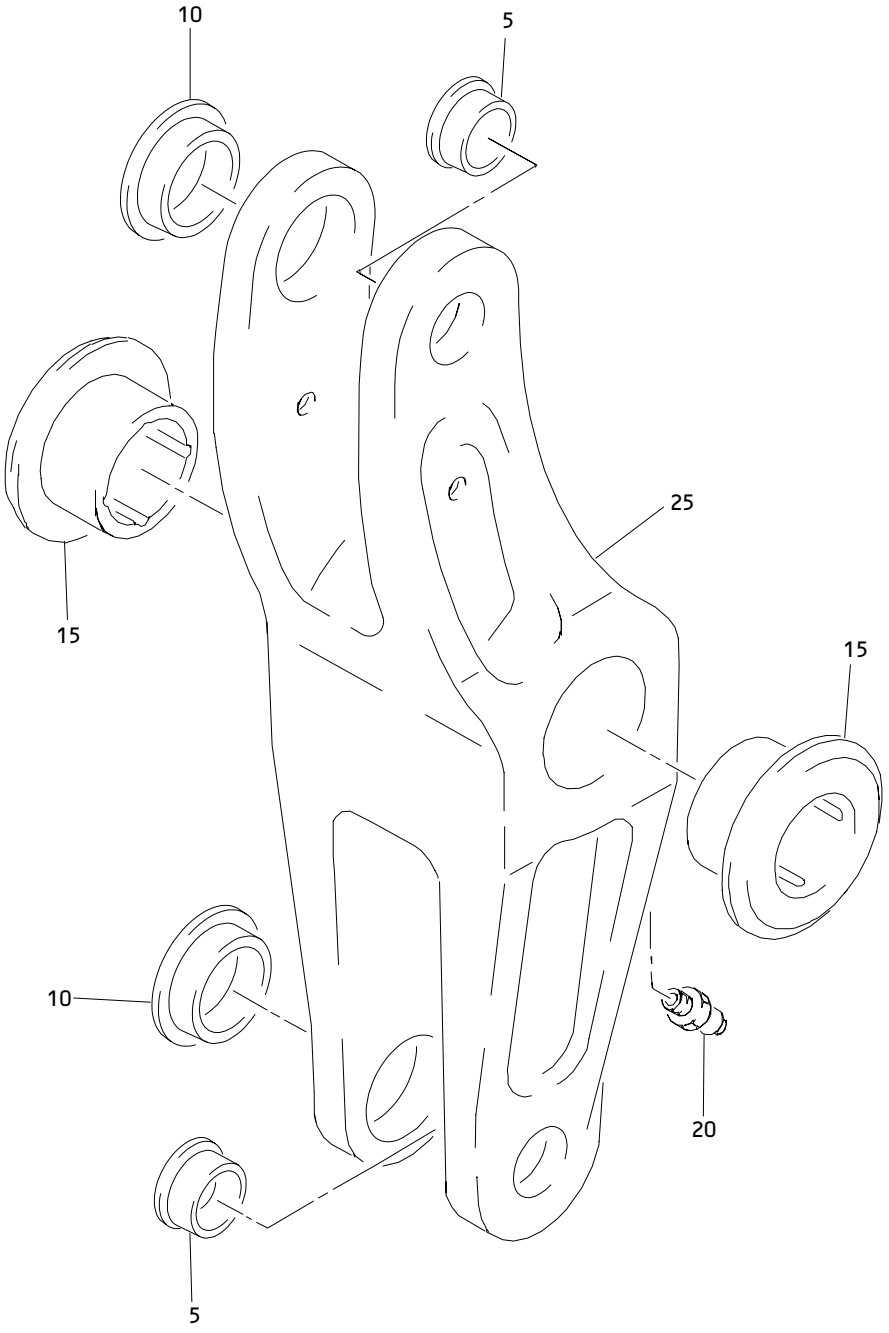


Support Fitting Assembly
Figure 4

T64674

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
04-					
-1	113T1219-1		FITTING ASSY-SPRT	M	RF
-1A	113T1219-2		FITTING ASSY-SPRT	N	RF
-1B	113T1219-5		FITTING ASSY-SPRT	P	RF
-1C	113T1219-6		FITTING ASSY-SPRT	Q	RF
5	BACB28AP14-019		.BUSHING	M,P	1
10	BACB28AM19B019		.BUSHING	N,Q	1
15	MS15004-1		.FITTING	M-Q	1
20	113T1219-3		.FITTING	M	1
25	113T1219-4		.FITTING	N	1
-30	113T1219-7		.FITTING	P	1
-35	113T1219-8		.FITTING	Q	1

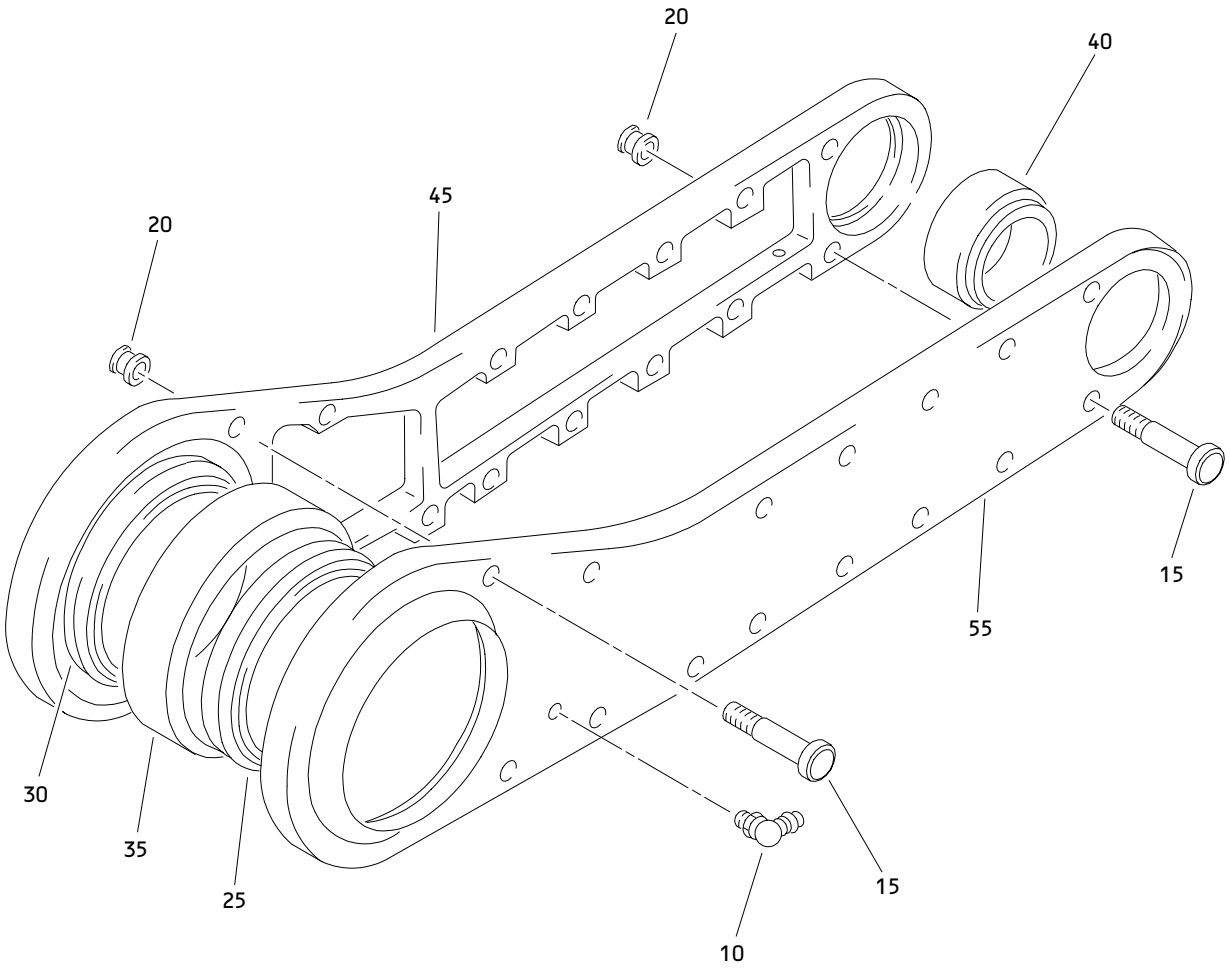
- Item Not Illustrated



Aft Flap Drive Bellcrank Assembly
Figure 5

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
05-					
-1	113T1248-7		CRANK ASSY-AFT FLAP DRIVE BELL	R	RF
-1A	113T1248-9		CRANK ASSY-AFT FLAP DRIVE BELL (PRE SB 767-27-0080)	S	RF
-1B	113T1248-11		CRANK ASSY-AFT FLAP DRIVE BELL	T	RF
-1C	113T1248-13		CRANK ASSY-AFT FLAP DRIVE BELL (VARIABLE)	U	RF
-1D	113T1248-15		CRANK ASSY-AFT FLAP DRIVE BELL	V	RF
-1E	113T1248-17		CRANK ASSY-AFT FLAP DRIVE BELL (POST SB 767-27-0080)	W	RF
-1F	113T1248-19		CRANK ASSY-AFT FLAP DRIVE BELL (VARIABLE)	X	RF
5	BACB28AP08P040		.BUSHING	R-X	2
10	BACB28AM11B040A		.BUSHING	R-X	2
15	113T1347-33		.BUSHING	R-X	2
20	MS15001-1		.FITTING	R-X	1
25	113T1248-8		.CRANK	R	1
-30	113T1248-10		.CRANK	S,U	1
-30A	113T1248-12		.CRANK	T	1
-30B	113T1248-16		.CRANK	V,X	1
-30C	113T1248-18		.CRANK	W	1

- Item Not Illustrated

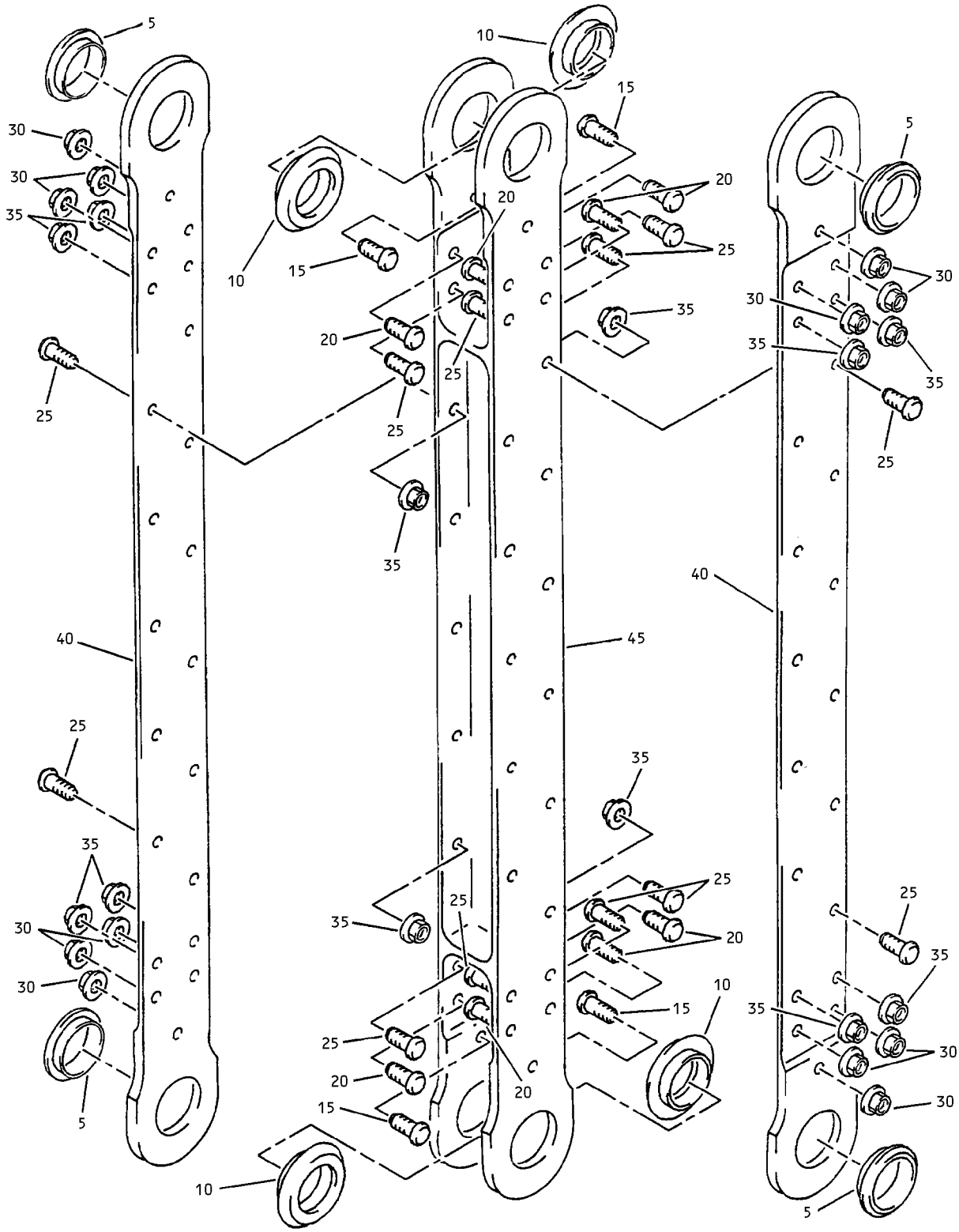


Support Link Assembly
Figure 9

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
09-					
-1A	113T1232-13		LINK ASSY-SPRT	G	RF
-1B	113T1232-7		DELETED		
-5	113T1232-14		LINK ASSY-SPRT	H	RF
-5A	113T1232-8		DELETED		
10	MS15001-4		.FITTING	G,H	1
15	HL10VAZ8-20		.BOLT- (V60516) (SPEC BACB30MY8K20) (OPT HL10VAZ8-20 (VOPTK6))	G,H	15
20	HL79-8		.COLLAR- (V56878) (SPEC BACC30M8) (OPT HL79-8 (V73197)) (OPT HL79-8 (V92215)) (OPT 66014-8 (V56878))	G,H	15
25	113T1256-62		.SEAL- (OPT ITEM 25A)	G,H	1
-25A	113T1256-64		.SEAL- (OPT ITEM 25)	G,H	1
-25B	113T1256-32		DELETED		
30	113T1256-32		.SEAL- (OPT ITEM 30A)	G,H	1
-30A	113T1256-44		.SEAL- (OPT ITEM 30)	G,H	1
-30B	113T1256-32		DELETED		

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
09-					
35	B8941CK		.BEARING- (V60380) (SPEC 60B00178-25) (OPT DAT56-76A1-503 (V77896))	G,H	1
-35A	60B00178-21		DELETED		
40	ADB18-301NC		.BEARING- (V15860) (SPEC BACB10FB18C) (OPT HTFB18C (V50294)) (OPT KNDB18-69 (V97613)) (OPT KSC145700BZ18C (V50632)) (OPT NRRS18FBC (V73134)) (OPT WES18C (V73134))	G,H	1
45	113T1232-5		.LINK	G	1
-50	113T1232-6		.LINK	H	1
55	113T1232-9		.LINK	G	1
-60	113T1232-10		.LINK	H	1

- Item Not Illustrated



5-7 Link Assembly
Figure 10

L08146

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	10-					
R	-1A	113T1218-5		LINK ASSY-5/7	Y	RF
R	5	113T1347-94		.BUSHING	Y	4
R	10	113T1347-93		.BUSHING	Y	4
R	15	HL12VAZ6-8		.BOLT- (V56878) (SPEC BACB30NX6K8) (OPT HL12VAZ6-8 (V73197)) (OPT HL12VAZ6-8 (V92215)) (OPT HL12VAZ6-8 (V97928)) (OPT L802-6K8 (V06725)) (OPT HL12-8 (V06725)) (OPT HL12VAZ6-8 (V97928))	Y	4
R	20	HL12VAZ6-5		.BOLT- (V56878) (SPEC BACB30NX6K5) (OPT HL12VAZ6-5 (V73197)) (OPT HL12VAZ6-5 (V92215)) (OPT HL12VAZ6-5 (V97928)) (OPT L802-6K5 (V06725)) (OPT HL12-5 (V06725)) (OPT HL12VAZ6-5 (V97928))	Y	8
R	25	HST10AG6-5		.BOLT- (VOPTK6) (SPEC BACB30VT6K5) (OPT HST10AG6-5 (V06725)) (OPT HST10AG6-5 (V56878)) (OPT HST10AG6-5 (V73197))	Y	30
R	30	BACN10YT3CD		.NUT	Y	12

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	10-					
R	35	BACN10ZV3		.NUT	Y	30
R	40	113T1218-9		.LINK-SIDE	Y	2
R	45	113T1218-7		.LINK-CTR	Y	1

- Item Not Illustrated