TO: ALL HOLDERS OF INBOARD TRAILING EDGE FLAP LINKAGE ASSEMBLY COMPONENT MAINTENANCE MANUAL 27-51-86

REVISION NO. 11 DATED NOV 01/05

HIGHLIGHTS

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

CHAPTER/SECTION AND PAGE NO.	DESCRIPTION OF CHANGE
TR & SB RECORD 1	Incorporated SB 767-27-0196 which modifies the existing 3-10 link assembly or replaces it with a new spares assembly 113T1223-47
REPAIR-GEN 603 REPAIR 3-1 601-602 1004,1011,1032-1033	
REPAIR-GEN 602	Edited without technical change

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BOEING

COMPONENT
MAINTENANCE MANUAL

INBOARD TRAILING EDGE FLAP LINKAGE ASSEMBLY

PART NUMBERS 113T2000-67,-68,-73 THRU -76, -85,-86,-99,-100, -131 THRU -134,-137, -138,-151 THRU -156, -195,-196, -203 THRU -206, -239 THRU -242, -295 THRU -298

COMPONENT MAINTENANCE MANUAL
WITH
ILLUSTRATED PARTS LIST

169792

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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

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TEMPORARY REVISION AND SERVICE BULLETIN RECORD

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1057	JUL 01/05	01.1
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1063	JUL 01/05	01.1
1064	JUL 01/05	01.1
1065	JUL 01/05	01.1
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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
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
Assembly

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INBOARD TRAILING EDGE FLAP LINKAGE ASSEMBLY
DESCRIPTION AND OPERATION

1. The inboard trailing edge flap linkage assembly consists of fail safe aluminum links and rolling element bearings which support the trailing edge flaps.

2. Leading Particulars (Approximate)

   Length -- 48 inches
   Width -- 12 inches
   Height -- 20 inches
   Weight -- 180 pounds

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DISASSEMBLY

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

1. Parts Replacement (IPL Fig. 1)

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

   A. Cotter pins (8, 80, 204, 308)

   B. Seals (40, 108, 280, 336, 772)

2. Disassembly (IPL Fig. 1)

   A. Use standard industry practices and the following special instructions to disassemble this component.

   WARNING: SPRING ASSEMBLY (492) IS HEAVILY LOADED. USE CARE WHILE REMOVING FITTING ASSEMBLY (648) TO AVOID INJURY TO PERSONNEL.

   B. Remove nuts (636). Insert a rod into the 0.62 inch dia hole in fitting assembly (648) to apply force reacting against force in spring assembly (492). Remove bolts (620, 624) and washers (632) and slowly release spring force using bolt (628) as a hinge.

   C. Remove bolt (380), washers (384, 388), bushing (396) and nut (392) attaching spring assembly (492) to fitting assembly (648). Separate spring assembly from fitting assembly. Remove bolt (628), fitting assembly (648) and shim (644).

      NOTE: Note thickness of shim (644) to facilitate assembly. Do not disassemble fitting assembly (648) unless repair or replacement is necessary.

   D. Remove parts (408, 412, 416). Pull out shaft assembly (456) and remove bellcrank assembly (420 or 424). Remove parts (380 thru 396) and spring assembly (492) from bellcrank.

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E. Remove lockbolts (516A, 520, 588) and collars (524, 592) and remove inboard and outboard support fittings (528 or 532, 596 or 598), shims (584, 616), stop fitting (556 or 558) and seals (480, 484, 488).

NOTE: Note thickness of shims (584, 616) to facilitate assembly. Do not disassemble fittings (528 or 532, 556 or 558, 596 or 598) unless necessary for repair or replacement.

F. Do not disassemble the following parts unless necessary for repair or replacement.

(1) Link assemblies (36, 236 or 238, 276, 768, 808)

(2) Beam assembly (112)

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CLEANING

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

2. Clean all sealed bearings per manufacturer's instructions.

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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. Carefully examine area around lubrication holes for hairline cracks.

4. Magnetic particle check per 20-20-01 the following listed items:

   A. Outer pins (24, 96, 220, 320, 756, IPL Fig. 1)

   B. Link half (304)

   C. Retainers (52, 288, 348, 784)

   D. Special washers (28, 100, 228, 324, 760)

   E. Inner pins (12A, 84A, 208A, 312A)

   F. Spring (512)

5. Penetrant check per 20-20-02 the following listed items:

   A. Side links (888, 896)

   B. Center fork link (892)

   C. Inner beam (736)

   D. Outer beam (728, 732)

   E. Link assy (36)

   F. Outer straps (192, 196)

   G. Links (272, 804)

   H. Fittings (548 or 552, 580 or 582, 612 or 614)

   I. Shaft (476)

   J. Bellcrank (452)

   K. Beam (200)

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L. Inner Pins (12, 84, 208, 312)

6. Extend spring assembly (492) to 12.06 inches (between centerlines of bearings). Check that load is 355-425 lbs.

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REPAIR - GENERAL

1. Content

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

P/N	NAME	REPAIR
113T1221	LINK - SPRT DRIVE	1-1
113T1222	BEAM - SPRT	2-1
113T1223	LINK	3-1
113T1224	LINK	4-1
113T1225	LINK - SPRT	5-1
113T1226	BEAM - SPRT	6-1
113T1229	LINK - SPRT	7-1
113T1263	PIN - OUTER	8-1
113T1719 113T1789	FITTING - INBD SUPPORT	9-1
113T1586 113T1726	FITTING - STOP	10-1
113T1731	SPRING	11-1
113T1737-1,-2,-9,-10, -19,-20	SHAFT AND BELLCRANK	12-1
113T1737-3,-11	SHAFT	13-1
113T1737-5,-6,-13,-14, -15,-16	BELLCRANK	14-1
113T1738	FITTING - SPRING ATTACH	15-1

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P/N	NAME	REPAIR
113T1743	FITTING- SPRING ATTACH	15-1
113T1009 113T1739	FITTING - OUTBD SUPPORT	16-1
- - -	MISC PARTS REFINISH	17-1
- - -	BUSHING SEALING	18-1
113T2066	LINK ASSEMBLY - SUPPORT	19-1

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
20-41-02 Application of Chemical and Solvent Resistant Finishes
20-42-01 Low Hydrogen Embrittlement Cadmium Plating
20-42-03 Hard Chrome Plating
20-42-05 Bright Cadmium Plating
20-43-01 Chromic Acid Anodizing
20-50-01 Bolt and Nut Installation
20-50-02 Installation of Safetying Devices
20-50-03 Bearing and Bushing Replacement
20-50-07 Lubrication
20-50-08 Application of Bonded Solid Film Lubricants
20-60-02 Finishing Materials
20-60-03 Lubricants
20-60-04 Miscellaneous Materials

3. Materials

NOTE: Equivalent substitutes may be used.

A. Enamel -- BMS 10-60, Gloss, Color Gray (Ref 20-60-02)

B. Lockwire -- MS20995NC40-3

C. Lubricant -- BMS 3-8, Type 8 (Ref 20-60-03)

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

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

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F. Lockwire -- MS20995C32

G. Grease -- BMS 3-33 (Ref 20-60-03)

4. Dimensioning Symbols

A. Standard True Position Dimensioning Symbols used in the applicable repair procedures are shown in Fig. 601.

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—	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

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SUPPORT DRIVE LINK ASSEMBLY - REPAIR 1-1

113T1221-13, -14, -20, -25, -27, -29, -31, -33, -39, -41

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

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

   A. Remove bushings (812, 816, 820, 824, 828, 832).

   B. Install new bushings using shrink fit method except use wet BMS 5-95 sealant (Ref 20-50-03).

   C. Machine the bushing bores to the dimensions and finish shown.

   D. Seal bushings per REPAIR 18-1.

2. Installation of Oversize Bushing (Fig. 602)

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

   B. Shot peen as indicated.

   C. Manufacture bushings (Fig. 603), as required, to compensate for amount of material removed.

   D. Install bushing per par. 1, steps B thru D.

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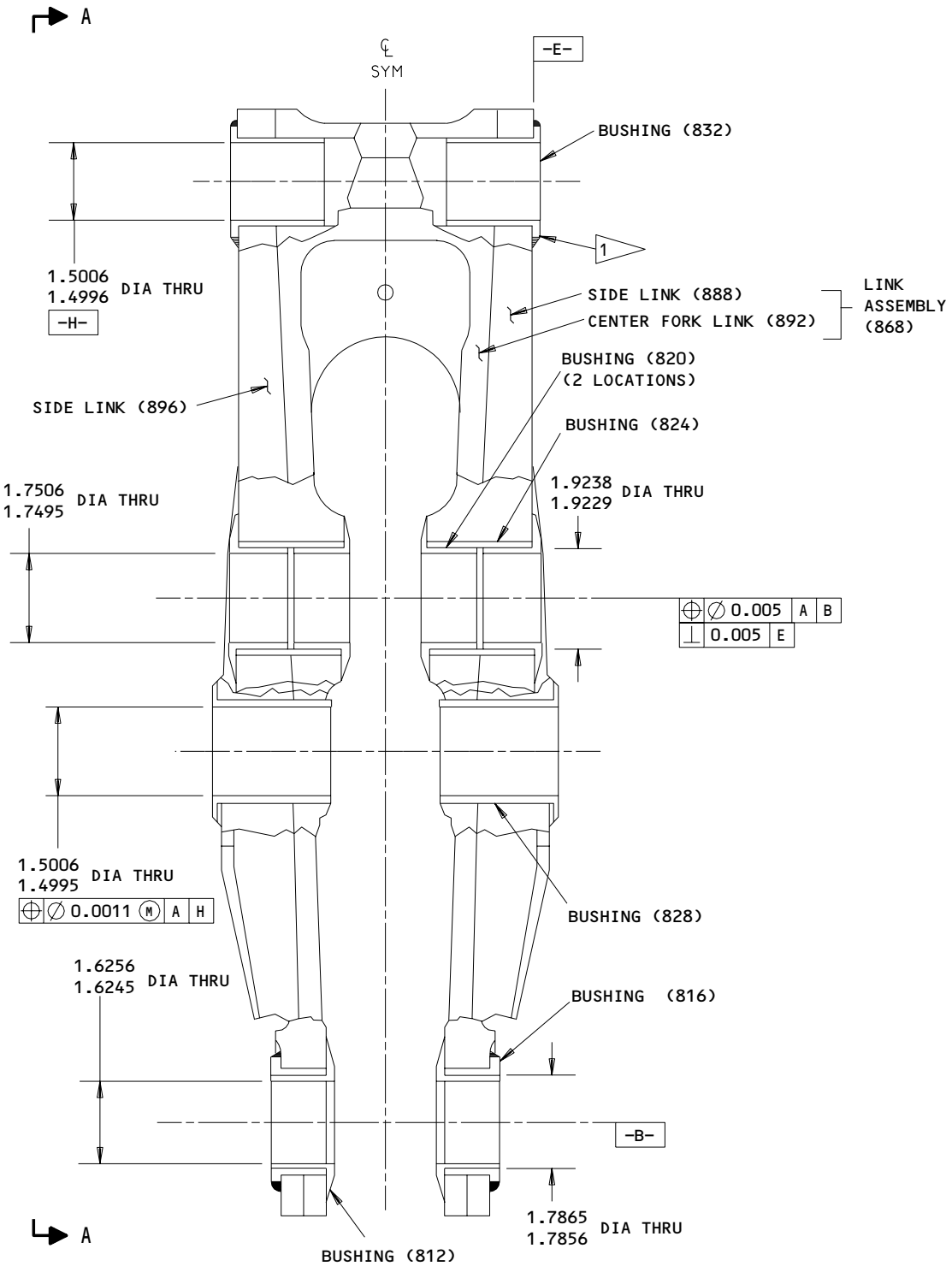

113T1221-13,-14,-20,-25,-27,-29,-31,-33,-39,-41
Bushing Replacement and Link Refinish
Figure 601 (Sheet 1)

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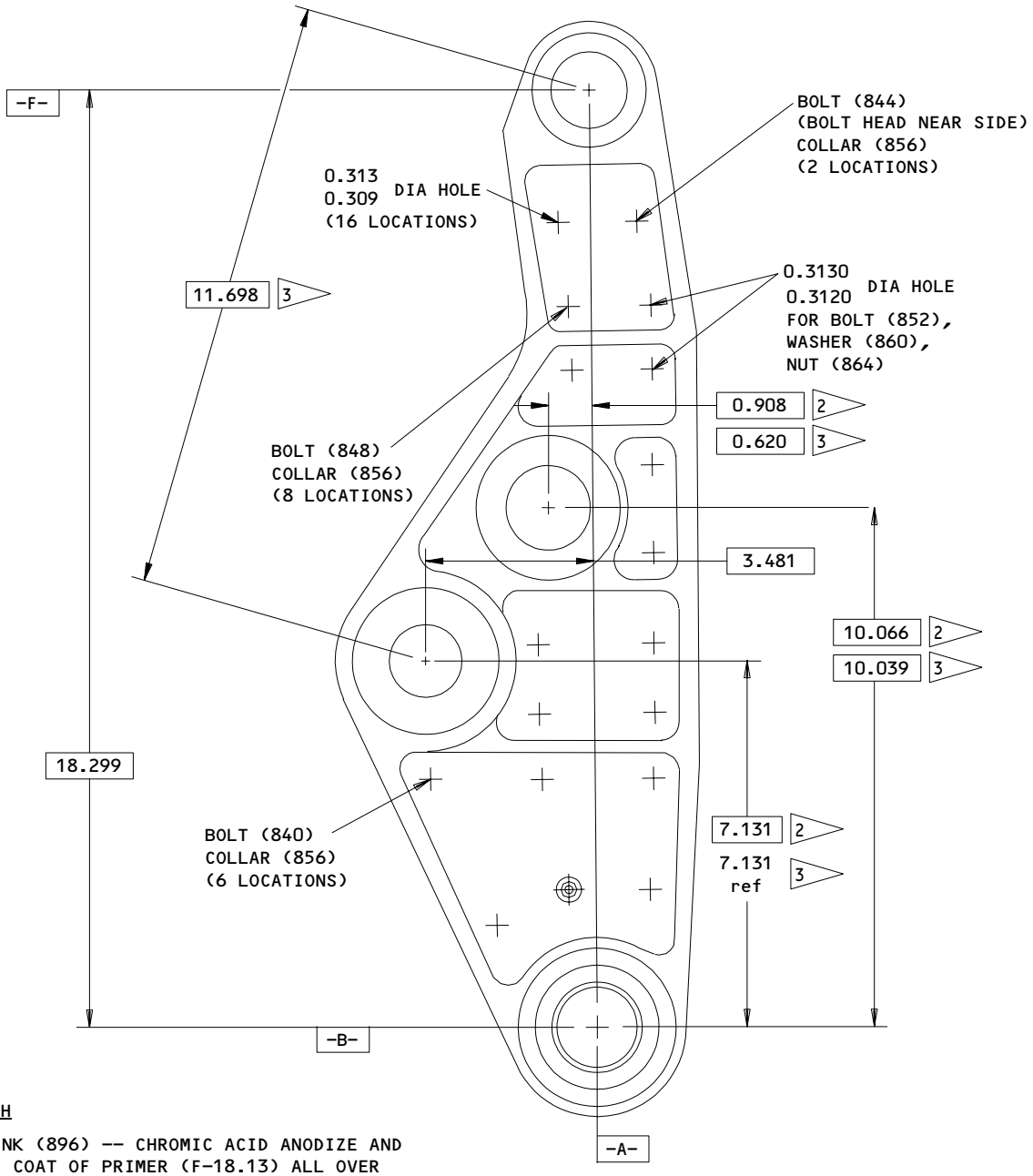

A-A

REFINISH

SIDE LINK (896) -- CHROMIC ACID ANODIZE AND APPLY 1 COAT OF PRIMER (F-18.13) ALL OVER

LINK ASSEMBLY (808) -- APPLY YELLOW EPOXY PRIMER (SRF-14.995) AND ENAMEL, BMS 10-60 (SRF-14.9813) ALL OVER EXCEPT ON BUSHINGS AND LUBE FITTING

1 FILLET SEAL WITH SEALANT, BMS 5-95

2 ASSEMBLIES 113T1221-13,-14,-20,-29

3 ASSEMBLIES 113T1221-25,-27,-31,-33,-39, -41 ONLY

63 MACHINED SURFACES IN BORES

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

ITEM NUMBERS REFER TO IPL FIG. 1

113T1221-13,-14,-20,-25,-27,-29,-31,-33,-39,-41
Bushing Replacement and Link Refinish
Figure 601 (Sheet 2)

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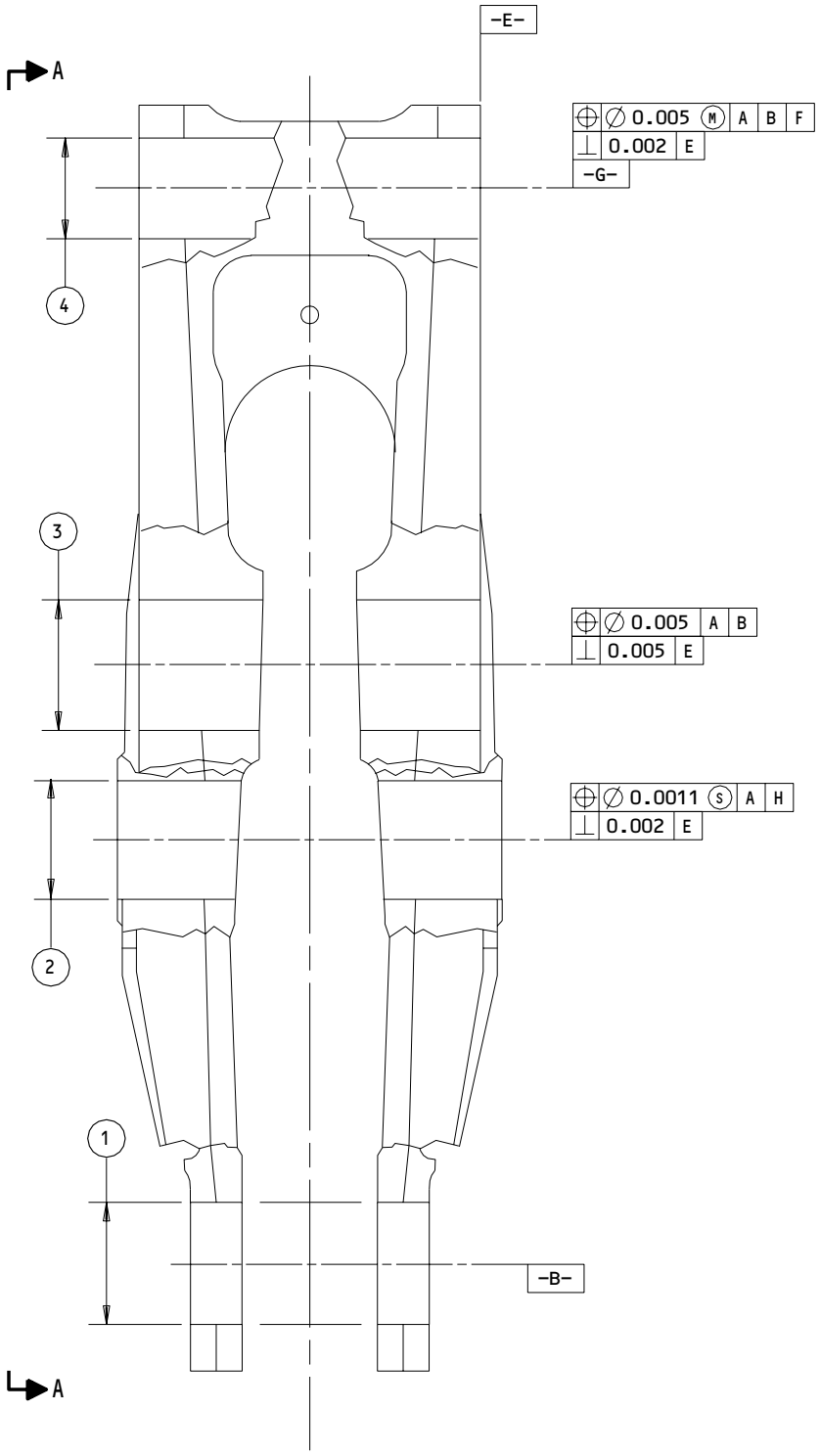

113T1221-13,-14,-20,-25,-27,-29,-31,-33,-39,-41
Link Repair
Figure 602 (Sheet 1)

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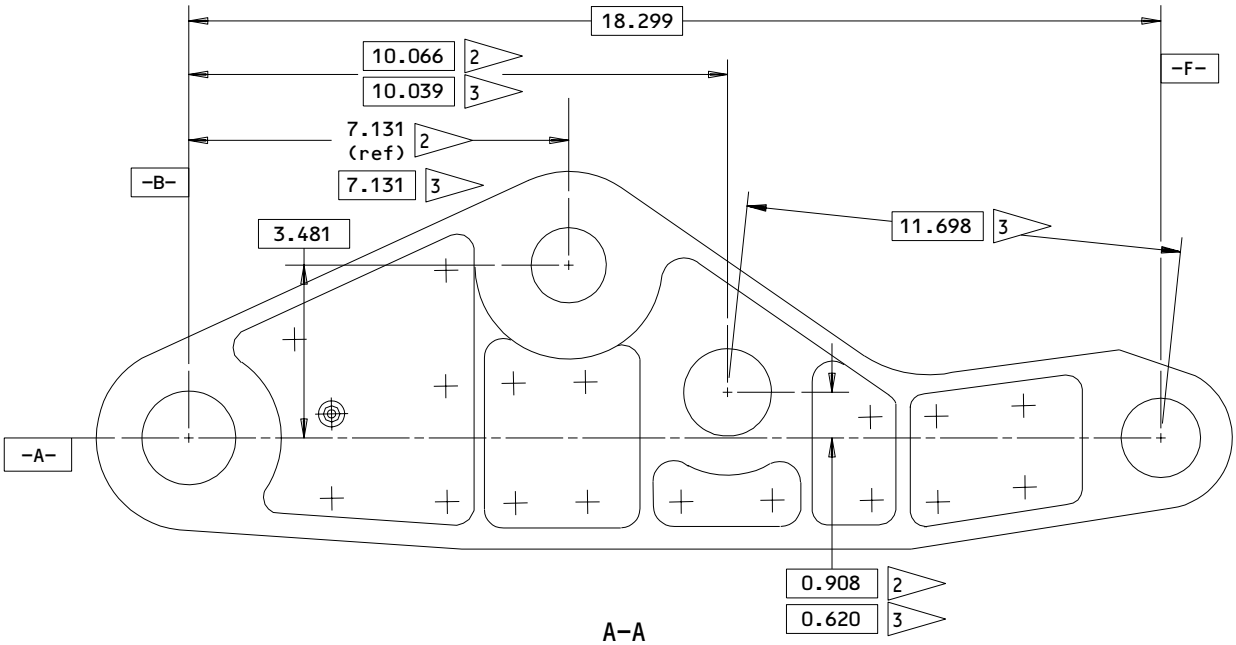
D19400



A-A
(ROTATE 90°CW)

HOLE LOCATION	DESIGN DIA	MAX REPAIR DIA 1
1	2.0137 2.0128 4 2.0737 2.0728 5	2.0737 4
2	1.7489 1.7480	1.8089
3	2.1687 2.1678	2.2287
4	1.7189 1.7181 4 1.7789 1.7781 5	

1 REPAIR LIMITS FOR INSTALLATION OF OVERSIZE BUSHINGS

2 113T1221-13,-14,-20,-29 ONLY

3 113T1221-25,-27,-31,-33,-39,-41 ONLY

4 113T1221-13,-14,-20,-25,-27,-39 ONLY

5 113T1221-29,-31,-33,-41 ONLY

REPAIR

REF 1

63 MACHINED SURFACES IN BORES

SHOT PEEN: (REF 20-10-03)
0.023-0.055 SHOT SIZE
0.012 A2 INTENSITY R

BREAK SHARP EDGES 0.05 / 0.03

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

113T1221-13,-14,-20,-25,-27,-29,-31,-33,-39,-41
Link Repair
Figure 602 (Sheet 2)

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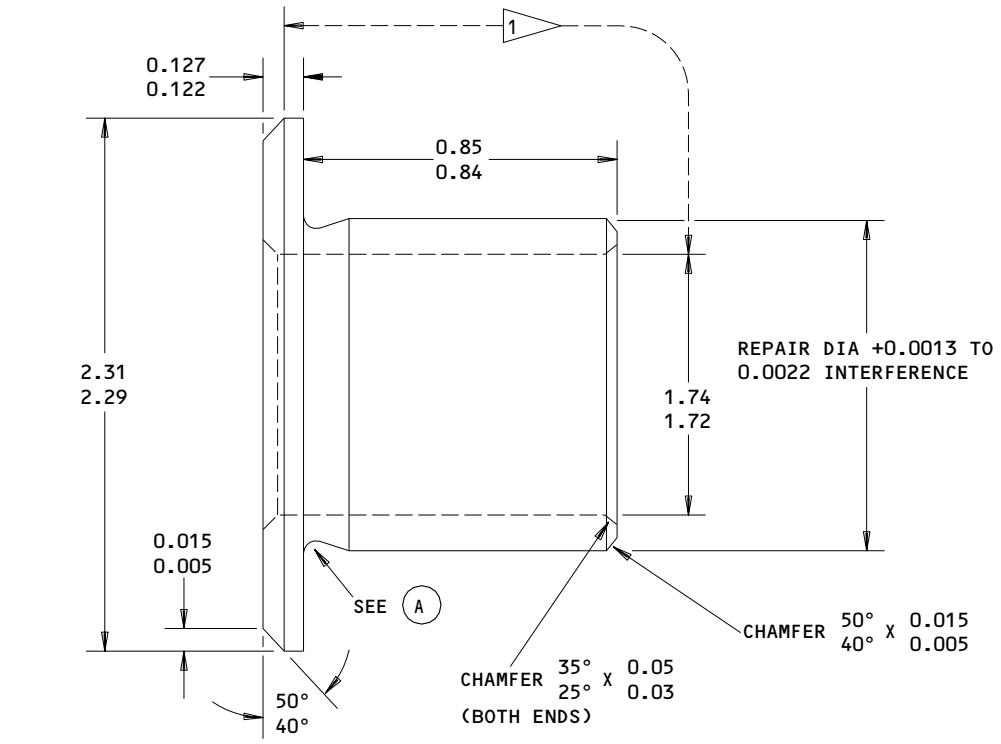

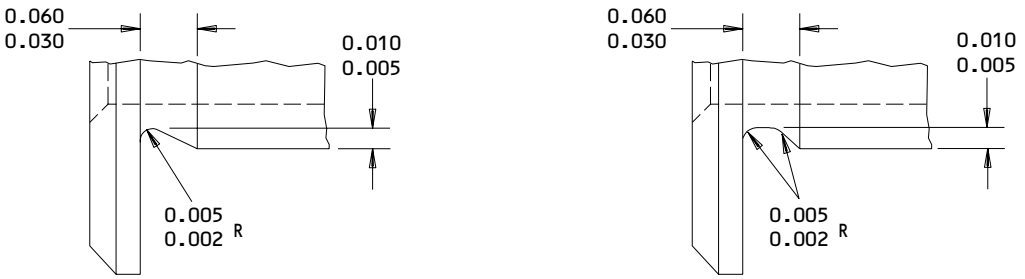

TYPE I TYPE II

UNDERCUT TYPE I OR TYPE II OPTIONAL

A

1 CADMIUM PLATE (F-15.06)

PLATING OPTIONAL ON ALL OTHER SURFACES

DIMENSIONS APPLY AFTER PLATING

63 ALL SURFACES EXCEPT AS NOTED

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

BREAK SHARP EDGES 0.008 R

CONCENTRICITY BETWEEN ID AND OD SHALL BE 0.003 MAX

ALL DIMENSIONS ARE IN INCHES

OVERSIZE BUSHING FOR HOLE LOCATION 1

Oversize Bushing Details
Figure 603 (Sheet 1)

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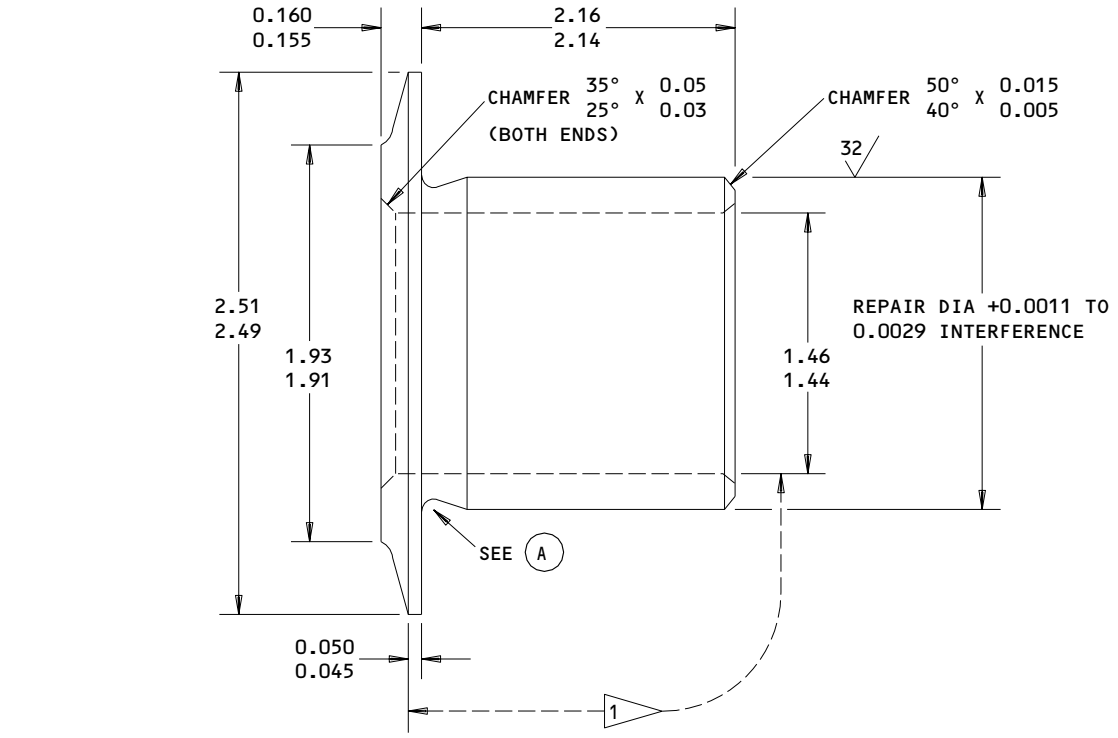

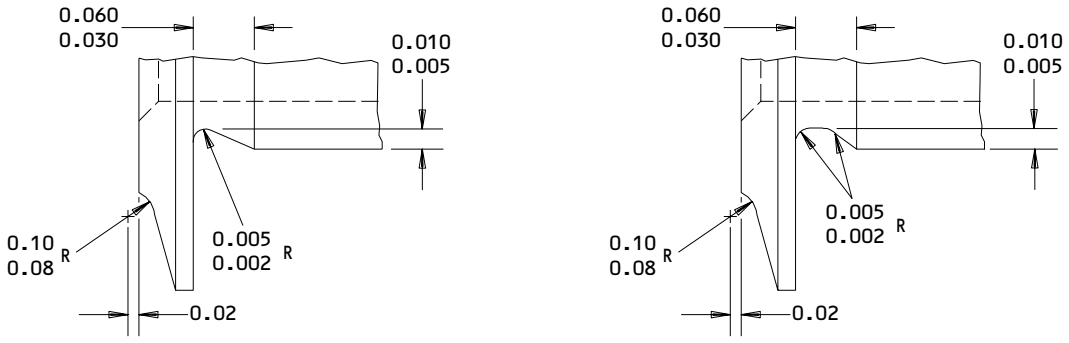

TYPE I TYPE II

UNDERCUT TYPE I OR TYPE II OPTIONAL

(A)

1 CADMIUM PLATE (F-15.06)

PLATING OPTIONAL ON ALL OTHER SURFACES

DIMENSIONS APPLY AFTER PLATING

MATERIAL: AL-NI-BR PER AMS 4640

63 ALL SURFACES EXCEPT AS NOTED

BREAK SHARP EDGES 0.008 R

CONCENTRICITY BETWEEN ID AND OD SHALL BE 0.003 MAX

ALL DIMENSIONS ARE IN INCHES

OVERSIZE BUSHING FOR HOLE LOCATION (2)

Oversize Bushing Details
Figure 603 (Sheet 2)

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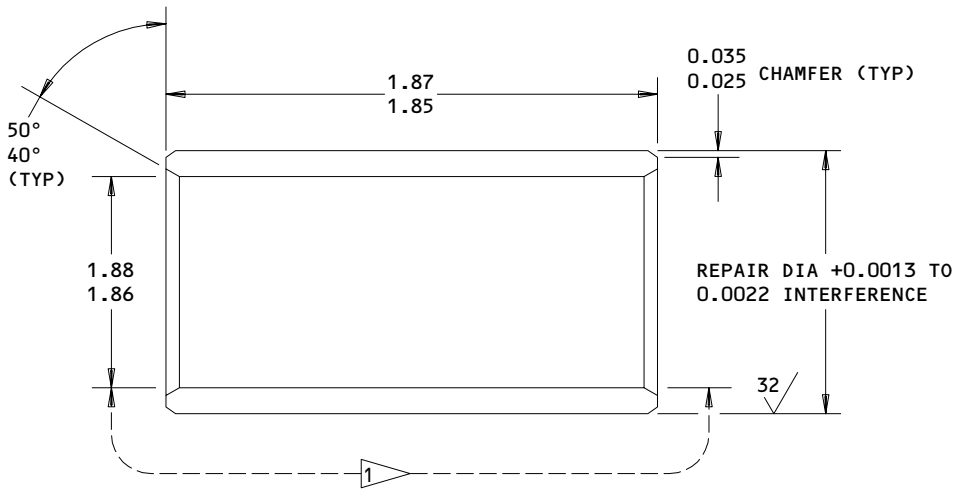

1 CADMIUM PLATE (F-15.06)

PLATING OPTIONAL ON ALL OTHER SURFACES

DIMENSIONS APPLY AFTER PLATING

MATERIAL: 15-5PH CRES, 180-200 KSI
AL-NI-BR PER AMS 4640

63 ALL SURFACES EXCEPT AS NOTED

BREAK SHARP EDGES 0.008 R

CONCENTRICITY BETWEEN ID AND OD SHALL BE 0.003 MAX

ALL DIMENSIONS ARE IN INCHES

OVERSIZE BUSHING FOR HOLE LOCATION (3)

Oversize Bushing Details
Figure 603 (Sheet 3)

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196404

SUPPORT BEAM ASSEMBLY - REPAIR 2-1

113T1222-1, -9, -11

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

1. Bushing Replacement (Fig. 601)

A. Remove bushings (116, 120, 128, 132, 136, 140) and spacers (124).

B. Install new bushings and spacers using shrink fit method except use wet BMS 5-95 sealant (Ref 20-50-03). Remove excess sealant between lubricated bushings and lube holes to allow grease to flow freely.

C. Machine the bushing bores to the dimensions and finish shown.

D. Seal bushings per REPAIR 18-1, except do not seal bushings (116, 120) on 113T1222-9, -11 assemblies.

2. Installation of Oversize Bushing (Fig. 602)

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

B. Shot peen as indicated.

C. Manufacture bushings (Fig. 603), as required, to compensate for amount of material removed.

D. Install bushing per par. 1, steps B thru D.

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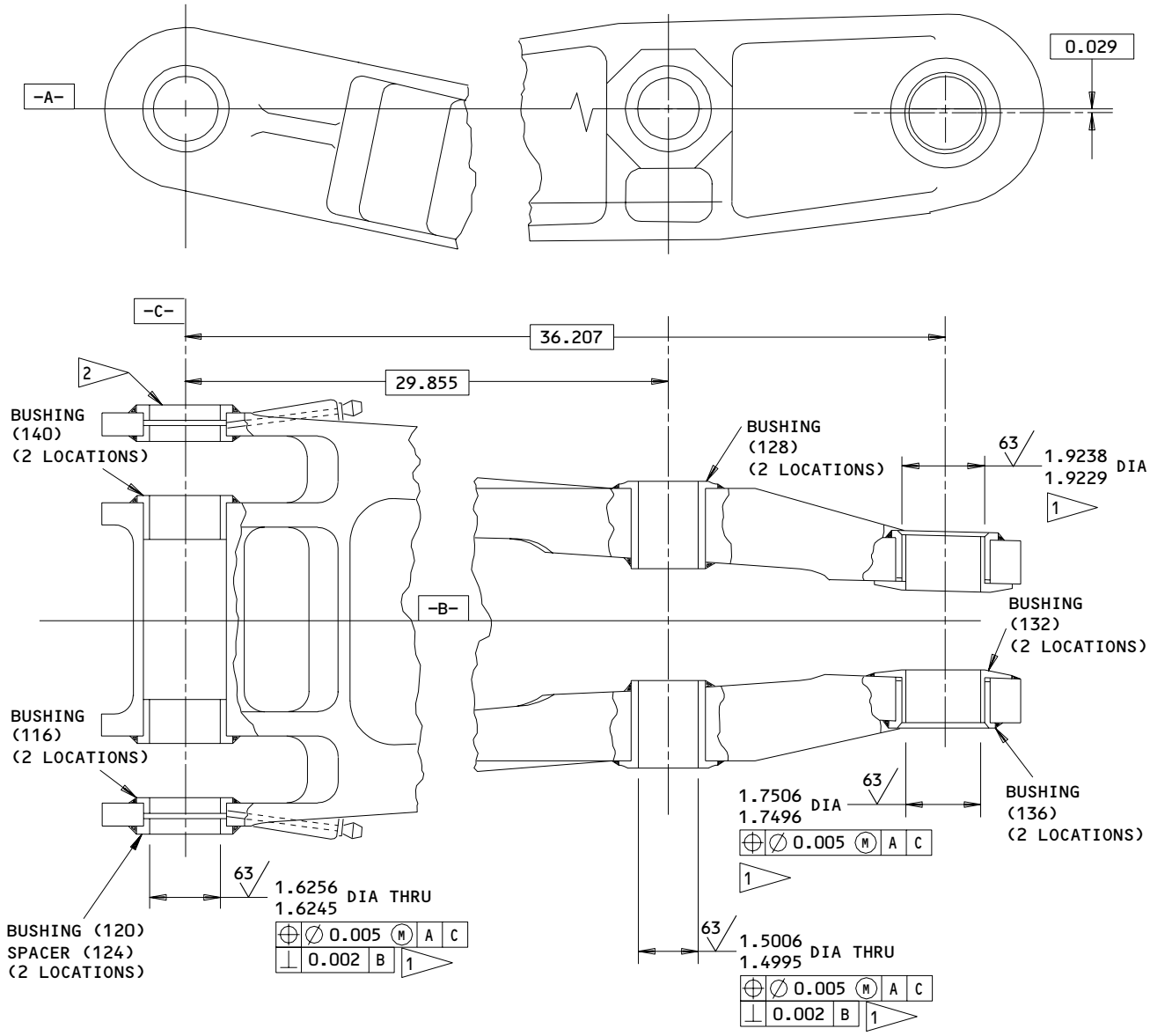

REFINISH

AFTER BUSHING INSTALLATION, APPLY YELLOW EPOXY PRIMER (SRF-14.995) AND ENAMEL, BMS 10-60 (SRF-14.9813) ALL OVER EXCEPT ON BUSHINGS AND LUBE FITTINGS.

1 CHAMFER BOTH ENDS 46° X 0.03, 44° X 0.02

2 INSTALL BUSHINGS (120) AND SPACERS (124) WITH WET SEALANT, BMS 5-95. REMOVE EXCESS SEALANT FROM FACE OF BUSHING BUT LEAVE FILLET SEAL AT OUTSIDE DIAMETER OF SPACER

ALL DIMENSIONS ARE IN INCHES

113T1222-1,-9,-11
Bushing Replacement
Figure 601

169813

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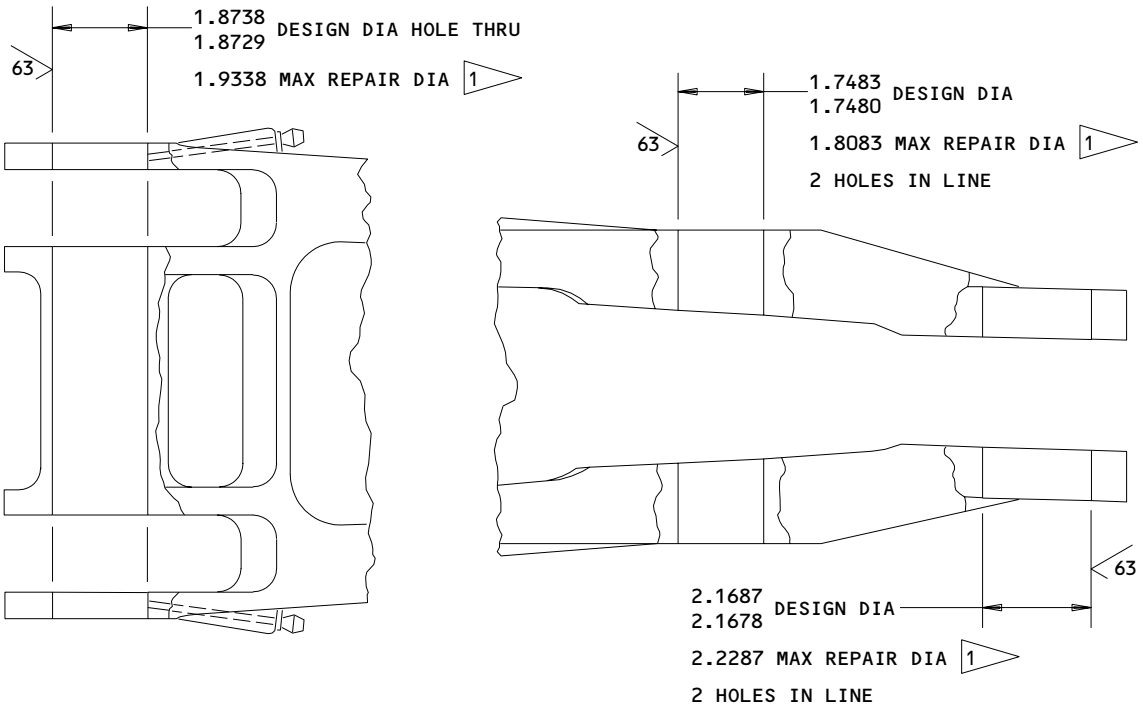

1 REPAIR LIMITS FOR INSTALLATION OF OVERSIZE BUSHING

REPAIR

REF 1

SHOT PEEN: (REF 20-10-03)
0.023-0.055 SHOT SIZE
0.012 A2 INTENSITY

125 ALL SURFACES EXCEPT AS NOTED

BREAK SHARP EDGES $\begin{matrix}0.04\\0.02\end{matrix}$ R

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

113T1222-1,-9,-11
Beam Repair
Figure 602

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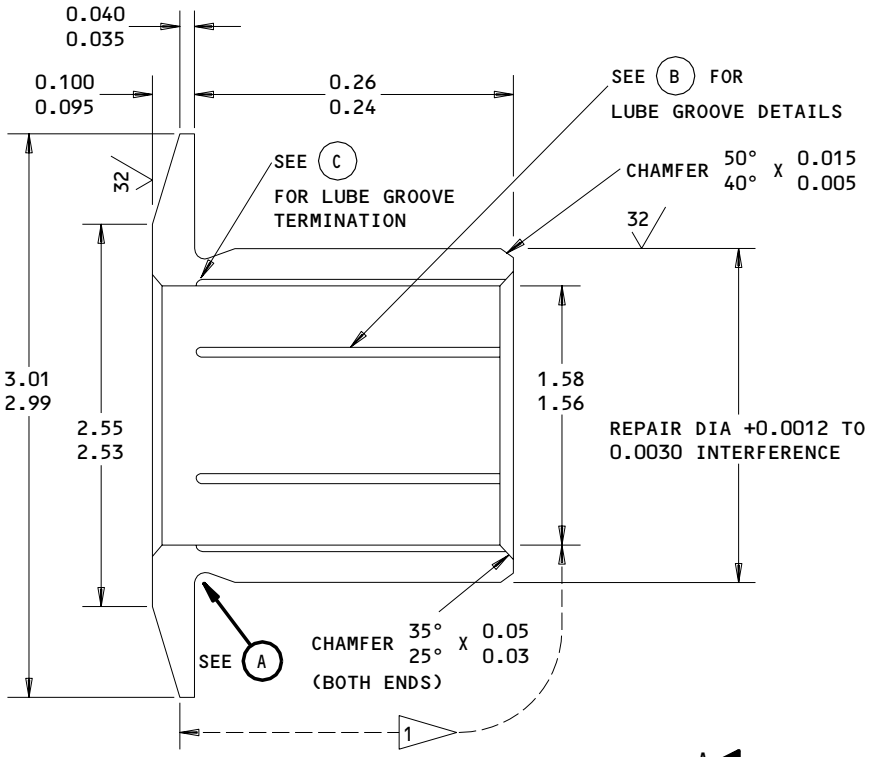
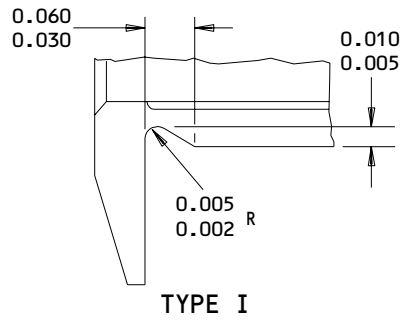
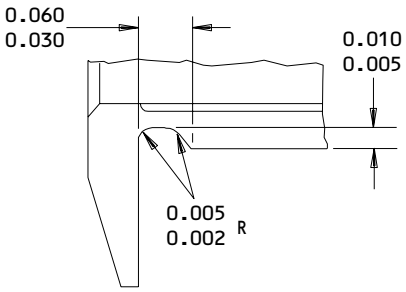




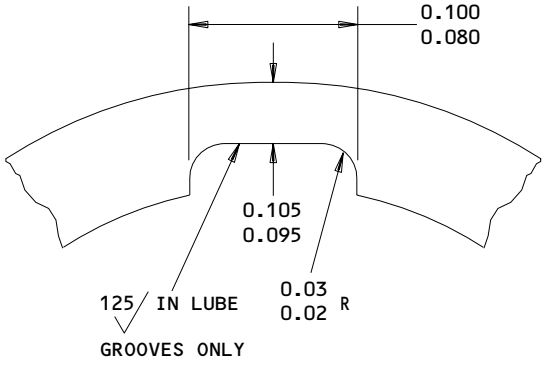
TYPE I



TYPE II

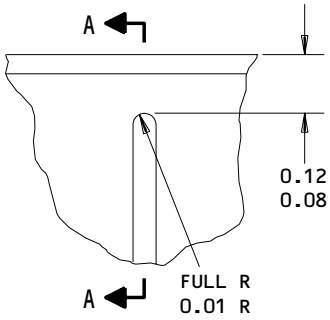
UNDERCUT TYPE I OR
TYPE II OPTIONAL

A



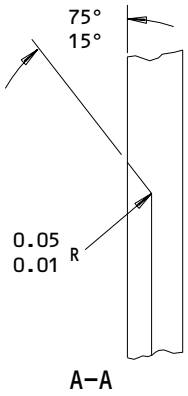
TYPICAL LUBE GROOVE DETAIL
6 GROOVES EQUALLY SPACED ON
INNER FACE OF BUSHING

B



LUBE GROOVE
TERMINATION DETAIL

C



A-A

1 CADMIUM PLATE (F-15.06)

PLATING OPTIONAL ON ALL OTHER SURFACES

DIMENSIONS APPLY AFTER PLATING

MATERIAL: AL-NI-BR PER AMS 4640

63 ALL SURFACES EXCEPT AS NOTED

BREAK SHARP EDGES 0.008 R

CONCENTRICITY BETWEEN ID AND OD SHALL BE
0.003 MAX

ALL DIMENSIONS ARE IN INCHES

OVERSIZE BUSHING TO REPLACE BUSHING (116)

Oversize Bushing Details
Figure 603 (Sheet 1)

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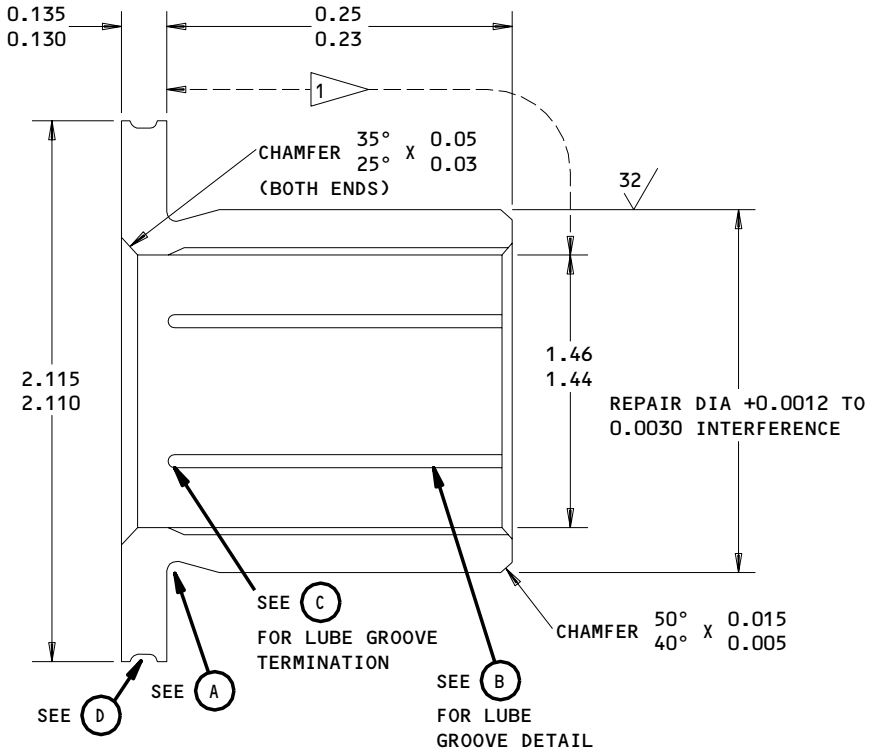

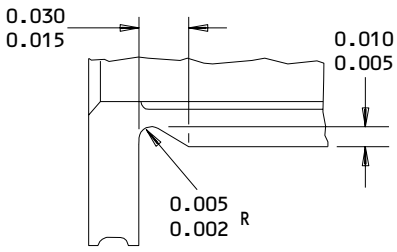

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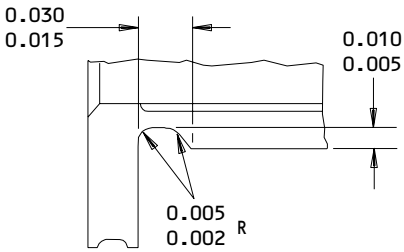
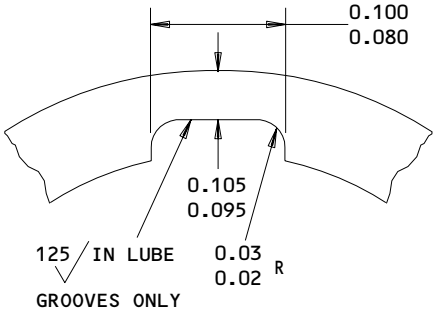


TYPE II

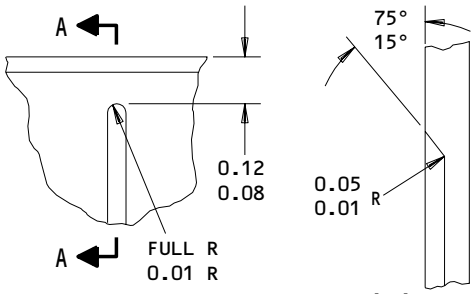
UNDERCUT TYPE I OR
TYPE II OPTIONAL

A



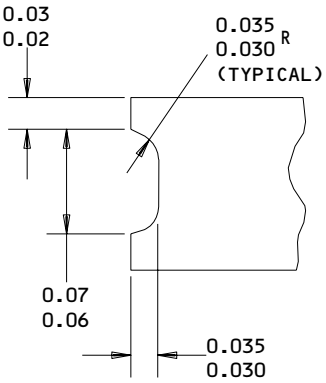
TYPICAL LUBE GROOVE DETAIL
6 GROOVES EQUALLY SPACED ON
INNER FACE OF BUSHING

B



LUBE GROOVE TERMINATION DETAIL

C



D

1 CADMIUM PLATE (F-15.06)

PLATING OPTIONAL ON ALL OTHER SURFACES

DIMENSIONS APPLY AFTER PLATING

MATERIAL: AL-NI-BR PER AMS 4640

63 ALL SURFACES EXCEPT AS NOTED

BREAK SHARP EDGES 0.008 R

CONCENTRICITY BETWEEN ID AND OD SHALL BE
0.003 MAX

ALL DIMENSIONS ARE IN INCHES

OVERSIZE BUSHING TO REPLACE BUSHING (120)

Oversize Bushing Details
Figure 603 (Sheet 2)

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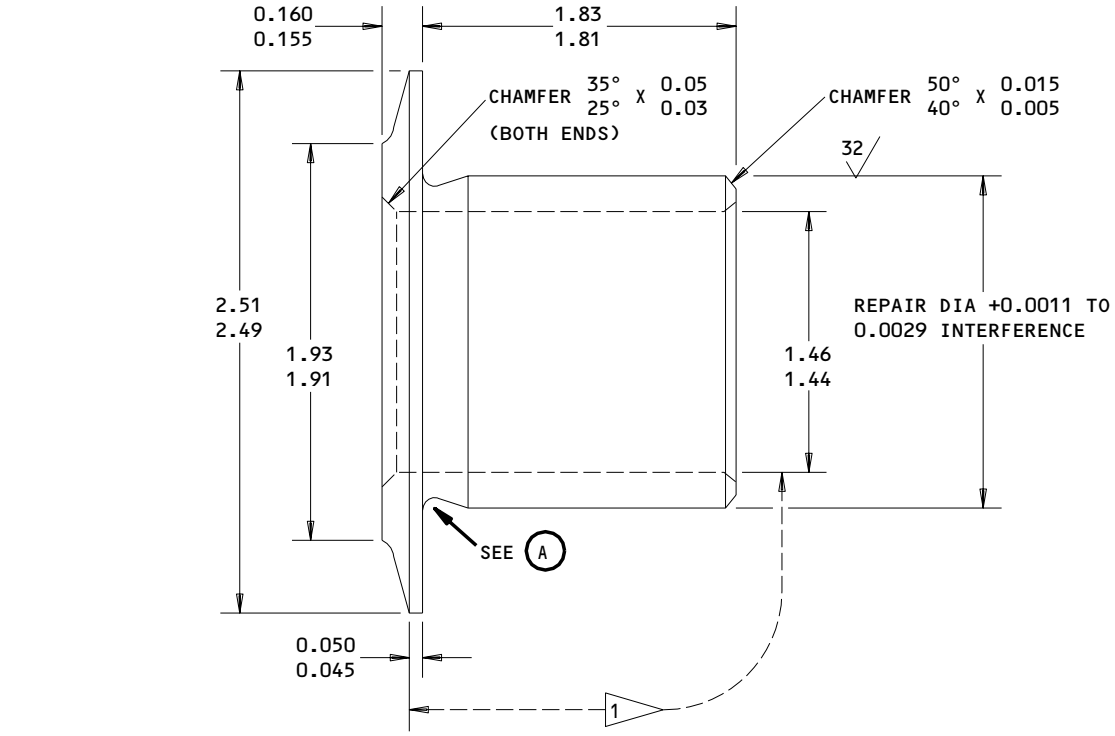
199407



UNDERCUT TYPE I OR TYPE II OPTIONAL

A

1 CADMIUM PLATE (F-15.06)

PLATING OPTIONAL ON ALL OTHER SURFACES

DIMENSIONS APPLY AFTER PLATING

MATERIAL: AL-NI-BR PER AMS 4640

63 ALL SURFACES EXCEPT AS NOTED

BREAK SHARP EDGES 0.008 R

CONCENTRICITY BETWEEN ID AND OD SHALL BE 0.003 MAX

ALL DIMENSIONS ARE IN INCHES

OVERSIZE BUSHING TO REPLACE BUSHING (128)

Oversize Bushing Details
Figure 603 (Sheet 3)

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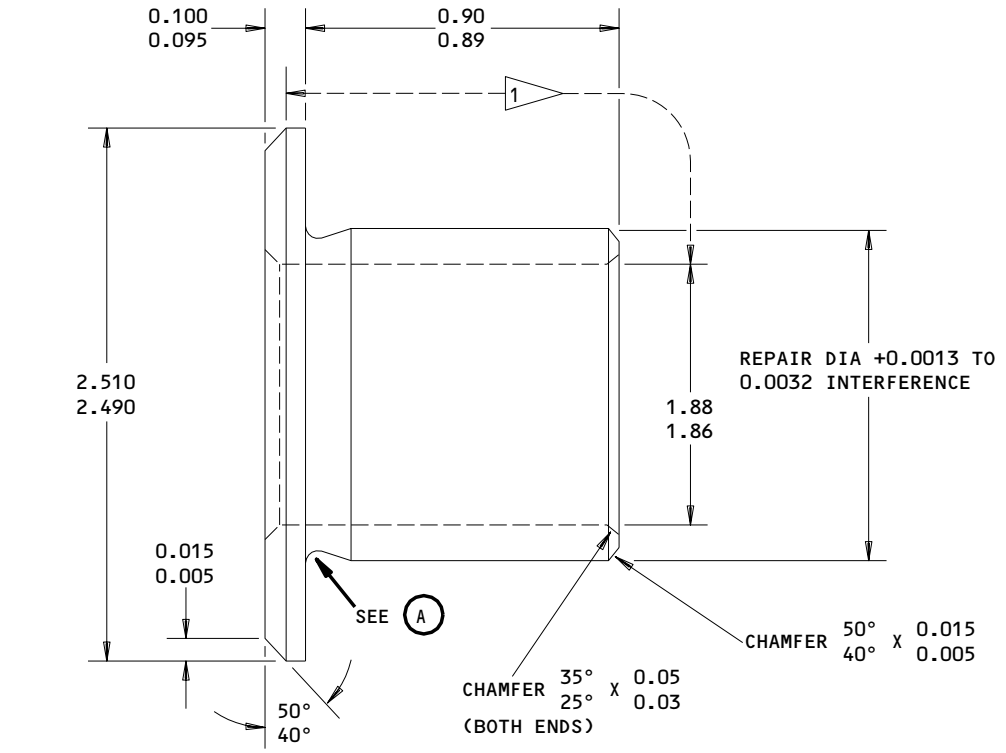
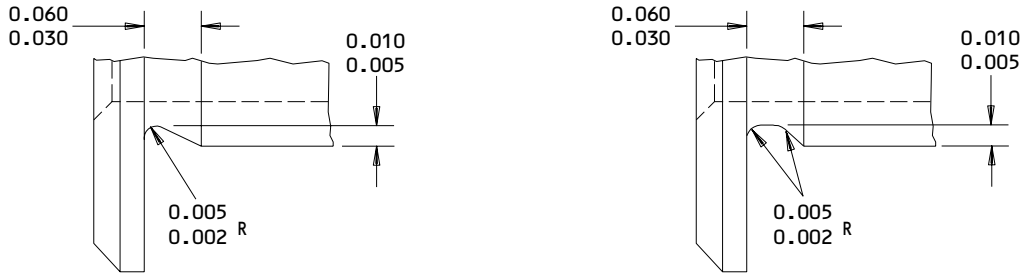
199408





UNDERCUT TYPE I OR TYPE II OPTIONAL

A

1 CADMIUM PLATE (F-15.06)

PLATING OPTIONAL ON ALL OTHER SURFACES

DIMENSIONS APPLY AFTER PLATING

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

63 ALL SURFACES EXCEPT AS NOTED

BREAK SHARP EDGES 0.008 R

CONCENTRICITY BETWEEN ID AND OD SHALL BE 0.003 MAX

ALL DIMENSIONS ARE IN INCHES

OVERSIZE BUSHING TO REPLACE BUSHING (136)

Oversize Bushing Details
Figure 603 (Sheet 4)

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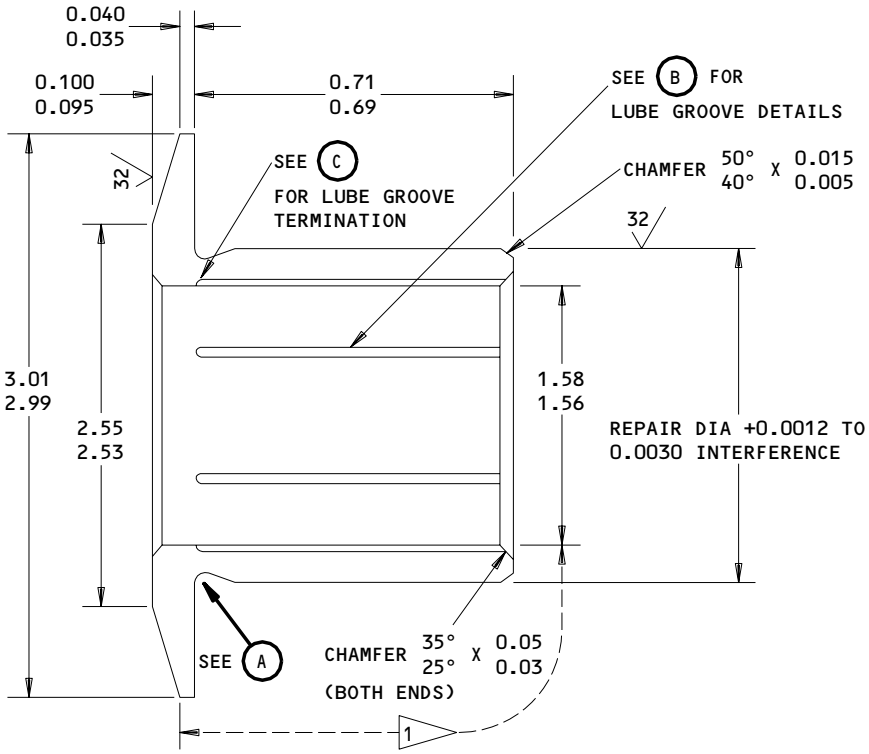
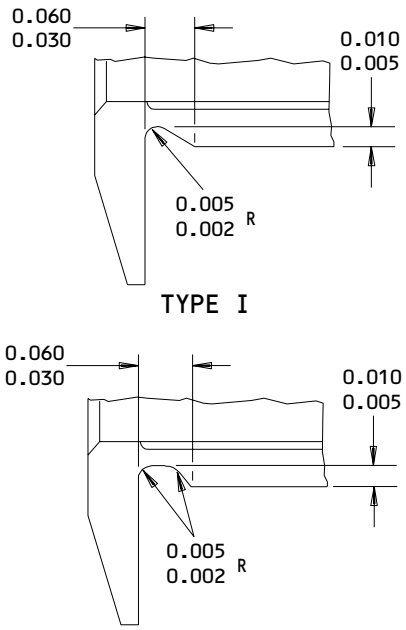
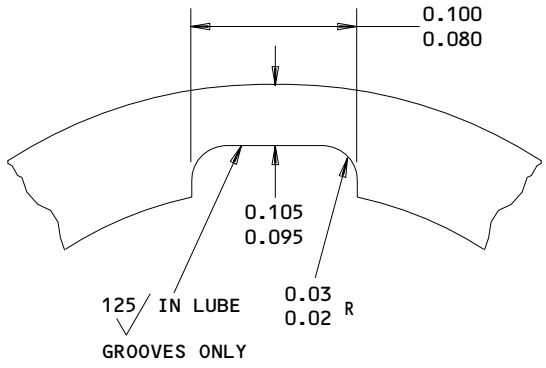
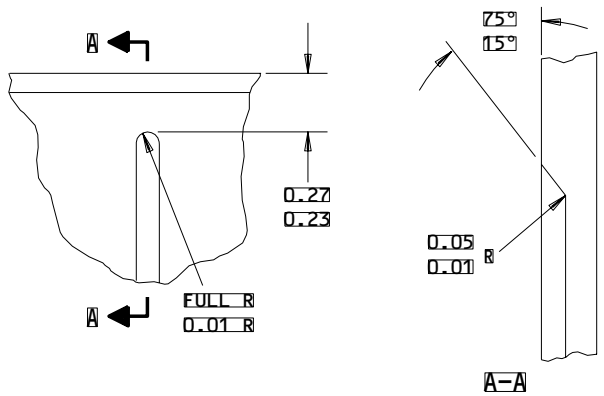




UNDERCUT TYPE I OR
TYPE II OPTIONAL
(A)



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



LUBE GROOVE TERMINATION DETAIL
(C)

1 CADMIUM PLATE (F-15.06)

PLATING OPTIONAL ON ALL OTHER SURFACES

DIMENSIONS APPLY AFTER PLATING

MATERIAL: AL-NI-BR PER AMS 4640

63 ALL SURFACES EXCEPT AS NOTED

BREAK SHARP EDGES 0.008 R

CONCENTRICITY BETWEEN ID AND OD SHALL BE
0.003 MAX

ALL DIMENSIONS ARE IN INCHES

OVERSIZE BUSHING TO REPLACE BUSHING (140)

Oversize Bushing Details
Figure 603 (Sheet 5)

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LINK ASSEMBLY - REPAIR 3-1

113T1223-1

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

1. Bearing Replacement (IPL Fig. 1)

A. Remove bolts (44) and bearing retainers (48, 52).

B. Remove bearings (56) and seals (40).

C. Install new bearings (56) and seals (40) (Ref 20-50-03). On assemblies 113T1223-47, and on assembly 113T1223-1 modified per SB 767-27-0196, install the bearings with BMS 3-33 grease.

CAUTION: MAKE SURE THAT THE SEALANT DOES NOT CONTAMINATE THE BEARING, OR THE BEARING CAN MALFUNCTION.

D. Apply BMS 5-95 sealant to faying surface between the bearing retainers (48, 52) and the outer segment (72).

E. Install bearing retainers (48, 52) and secure with bolts (44). Tighten bolts 12-15 lb-in.

F. Lockwire bolts (44) to retainers (48, 52) per 20-50-02.

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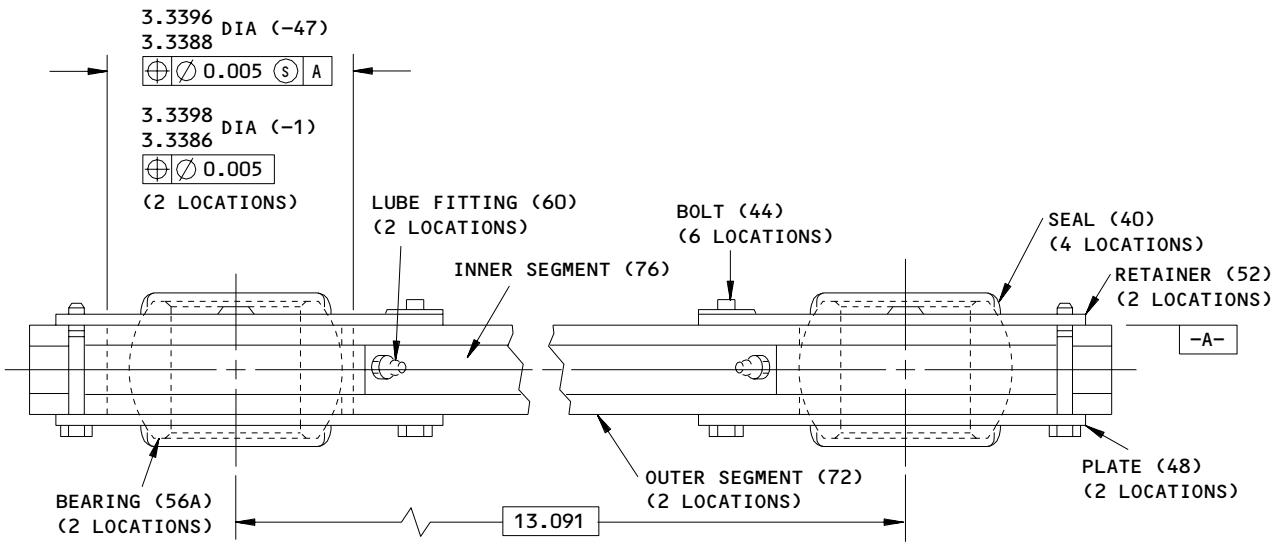

REFINISH

LINK ASSEMBLY (36) -- AFTER BEARING INSTALLATION, APPLY YELLOW EPOXY PRIMER (SRF-14.995) AND ENAMEL, BMS 10-60 (SRF-14.9813) ALL OVER EXCEPT ON BEARING, SEALS AND LUBE FITTINGS

PLATE (48,48A), RETAINER (52,52A) -- PASSIVATE (F-17.09)

PLATE (48B), RETAINER (52B) -- PASSIVATE (F-17.09) AND APPLY BMS 10-11, TYPE 1 PRIMER (F-20.02).

SEGMENT (72,76) -- APPLY PHOSPHATE-FLUORIDE COATING (F-14.881) AND APPLY BMS 10-11, TYPE 1 PRIMER (F-20.02) ALL OVER EXCEPT NO PRIMER IN LUBE HOLE (SRF-14.881 OPTIONAL).

MATERIAL:
PLATE (48), RETAINER (52) -- 15-5PH CRES, 180-200 KSI
SEGMENT (72,76) -- TI-6AL-4V TITANIUM

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

113T1223-1,-47
Bearing Replacement and Link Assembly Refinish
Figure 601

169817

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SUPPORT LINK ASSEMBLY - REPAIR 4-1

113T1224-1

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

1. Bearing Replacement

A. Remove bolts (776), plates (780), retainers (784).

B. Remove bearings (788) and seals (772).

C. Install new bearings and seals (Ref 20-50-03).

D. Apply BMS 5-95 sealant to faying surface between retainers (784) and link (804), and to faying surface between plates (780) and link (804). Make sure that sealant does not cause blockage of the lubricant path. Make sure that sealant does not contaminate bearing.

E. Install bearing retainers (784), plates (780) and bolts (776). Lockwire bolts to plates per 20-50-02.

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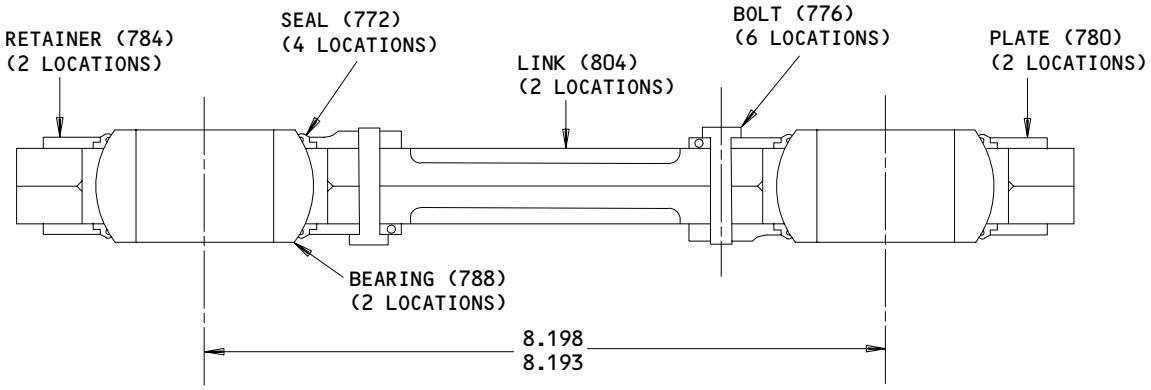

REFINISH

LINK ASSEMBLY (768) -- AFTER BEARING INSTALLATION, APPLY YELLOW EPOXY PRIMER (SRF-14.995) AND ENAMEL, BMS 10-60 (SRF-14.9813) ALL OVER EXCEPT ON BEARINGS, SEALS, AND LUBE FITTINGS.

PLATE (780,780A), RETAINER (784,784A) -- CADMIUM PLATE (F-15.06).

PLATE (780B), RETAINER (784B) -- CADMIUM PLATE (F-15.06) AND APPLY ONE COAT OF BMS 10-11, TYPE 1 PRIMER (F-20.02).

LINK (804) -- CHROMIC ACID ANODIZE AND APPLY ONE COAT OF BMS 10-11, TYPE 1 PRIMER (F-18.13).

MATERIAL:
LINK (804) -- ALUM ALLOY
PLATE (780), RETAINER (784) -- 15-5 PH CRES, 180-200 KSI

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

113T1224-1
Bearing Replacement and Link Assembly Refinish
Figure 601

169823

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SUPPORT LINK ASSEMBLY - REPAIR 5-1

113T1225-1

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

1. Bearing Replacement

A. Remove bolts (284).

B. Remove bearing retainers (288) and plates (292).

C. Remove bearings (296) and seals (280).

D. Install new bearings and seals (Ref 20-50-03).

E. Apply BMS 5-95 sealant to faying surface between retainers (288) and link (304), and to faying surface between plates (292) and link (304). Make sure that sealant does not contaminate bearing.

F. Install bearing retainers (288), plates (292) and bolts (284).

G. Lockwire bolts per 20-50-02.

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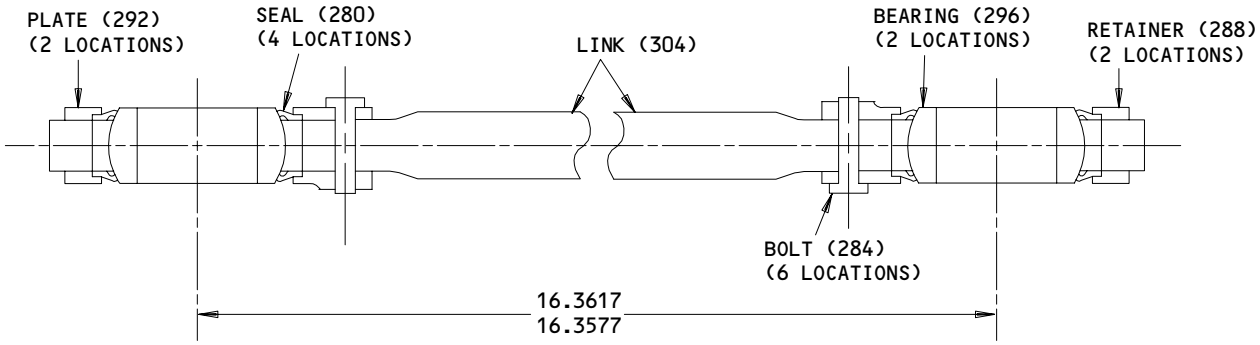

REFINISH

LINK ASSEMBLY (276) -- AFTER BEARING INSTALLATION, APPLY ENAMEL, BMS 10-60 (SRF-14.9813) ALL OVER EXCEPT ON BEARINGS AND LUBE FITTINGS

RETAINER (288,288A), PLATE (292,292A) -- PASSIVATE (F-17.09)

RETAINER (288B), PLATE (292B) -- CADMIUM PLATE (F-15.06) AND APPLY ONE COAT OF BMS 10-11, TYPE 1 PRIMER (F-20.02)

LINK (304) -- APPLY 1 COAT OF PRIMER, BMS 10-11, TYPE 1 (F-20.02) ALL OVER EXCEPT OMIT PRIMER IN THREADED HOLES AND BEARING BORES.

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

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

113T1225-1
Bearing Replacement and Link Assembly Refinish
Figure 601

169783

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SUPPORT BEAM ASSEMBLY - REPAIR 6-1

113T1226-31 thru -36, -43, -44, -59, -60

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

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

   A. Remove bushings (356, 360, 364, 368, 640).

   B. Install new bushings using shrink fit method except use wet BMS 5-95 sealant (Ref 20-50-03).

   C. Machine bushing bores to the dimensions and finish shown.

   D. Seal bushings per REPAIR 18-1.

2. Bearing Replacement (IPL Fig. 1)

   A. Remove bolts (340).

   B. Remove bearing retainer (348), plate (344).

   C. Remove bearings (352, 372) and seals (336).

   D. Install new bearings and seals (Ref 20-50-03).

   E. Install bearing retainer and plate.

   F. Install bolts.

3. Installation of Oversize Bushing (Fig. 602)

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

   B. Shot peen as indicated.

   C. Manufacture bushings (Fig. 603), as required, to compensate for amount of material removed.

   D. Install bushing per par. 1, steps B thru D.

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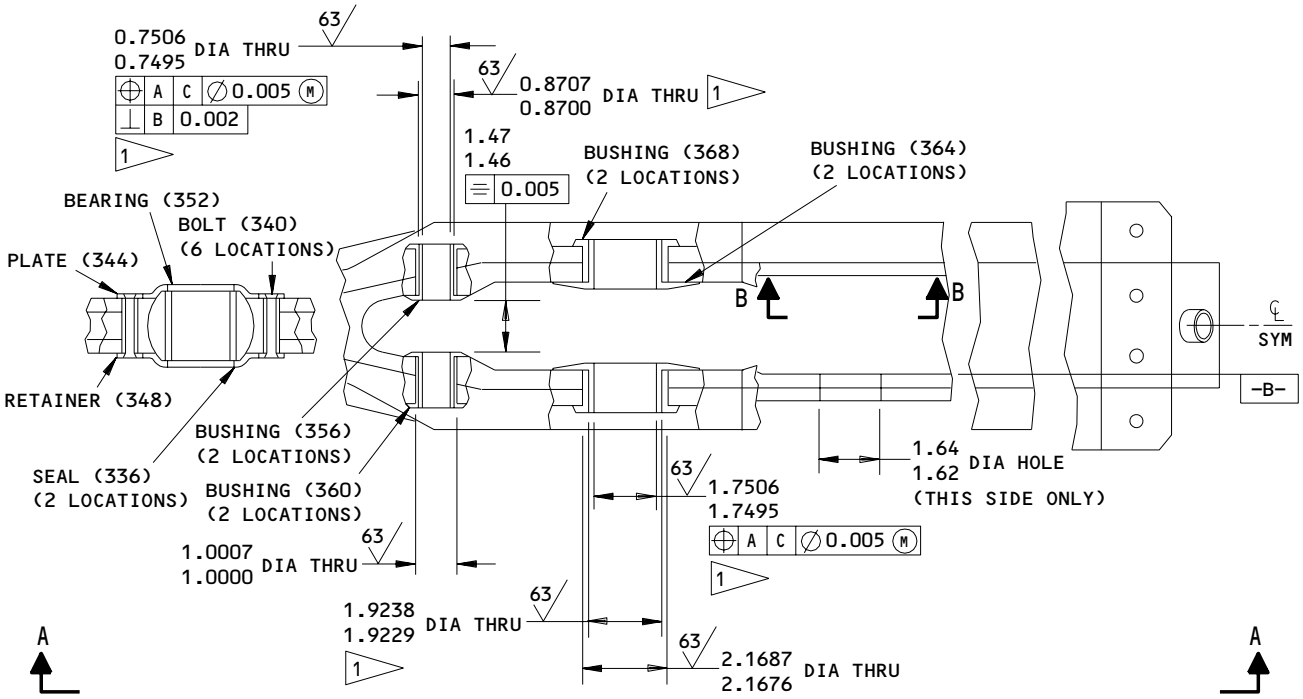

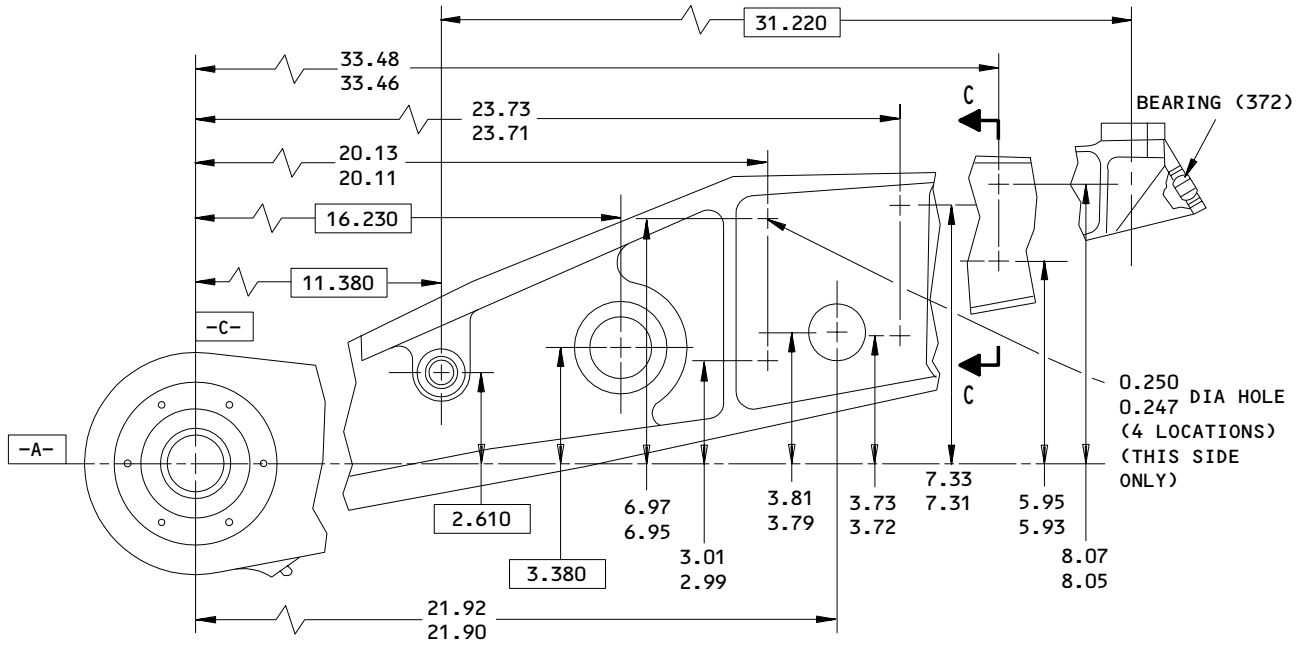

A-A

113T1226-31,-33,-35,-43,-59 SHOWN
113T1226-32,-34,-36,-44,-60 OPPOSITE

Parts Replacement and Beam Refinish
Figure 601 (Sheet 1)

169784

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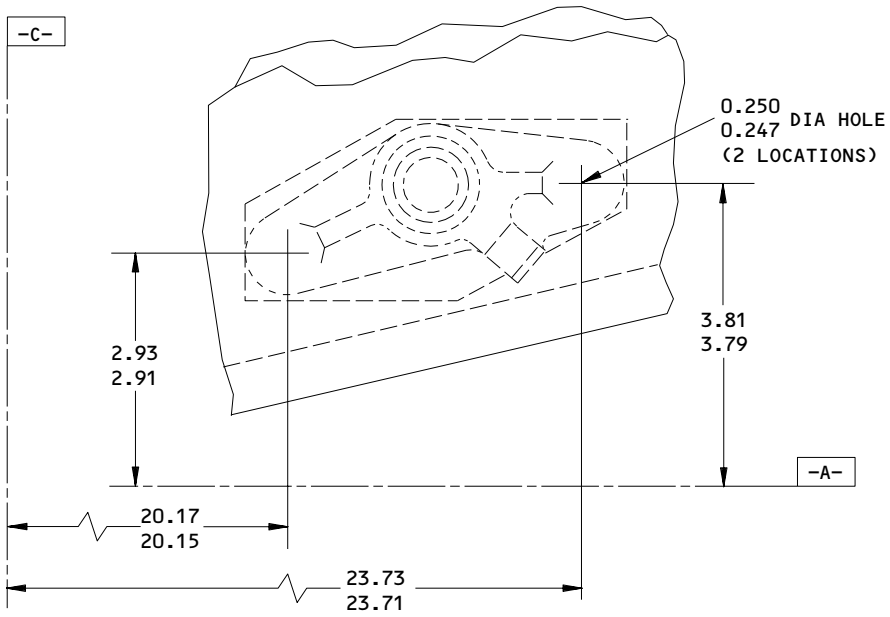
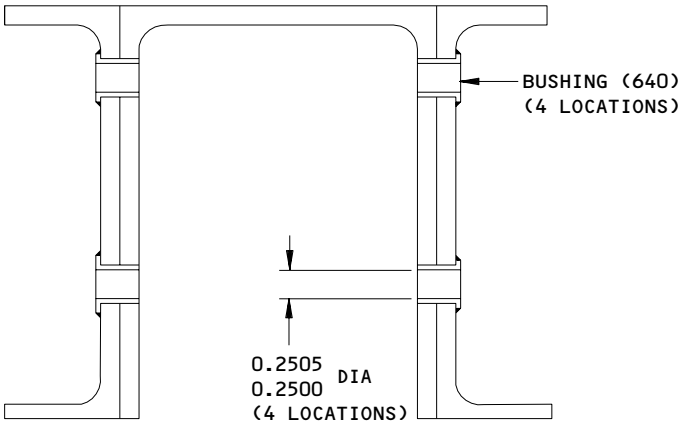


B-B



C-C

REFINISH

APPLY YELLOW EPOXY PRIMER (SRF-14.995) AND ENAMEL, BMS 10-60 (SRF-14.9813) ALL OVER EXCEPT OMIT PRIMER AND ENAMEL ON BUSHINGS, AND LUBE FITTINGS

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

113T1226-31,-33,-35,-43,-59 SHOWN
113T1226-32,-34,-36,-44,-60 OPPOSITE

Parts Replacement and Beam Refinish
Figure 601 (Sheet 2)

169785

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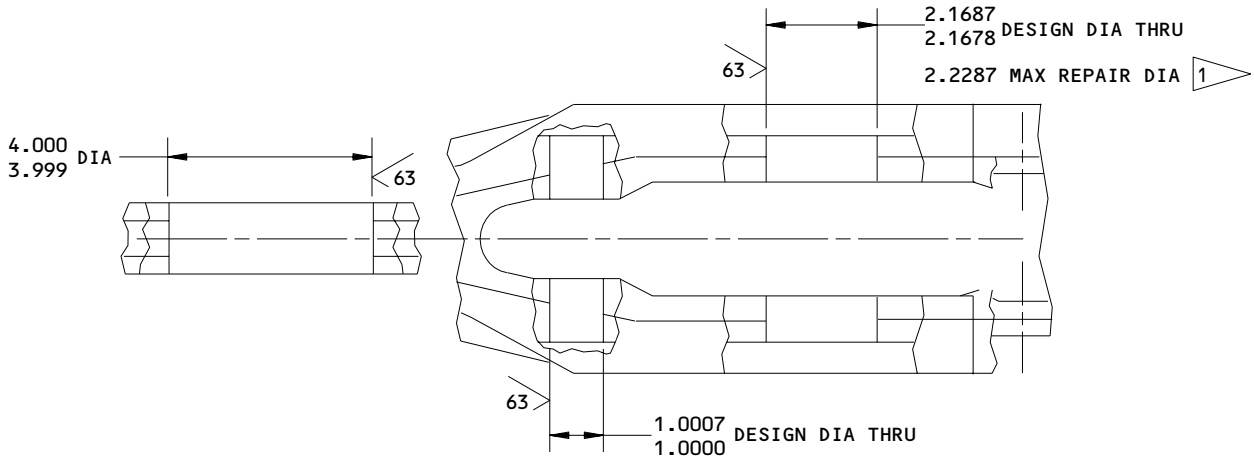

1 REPAIR LIMIT FOR INSTALLATION OF OVERSIZE BUSHING

REPAIR

REF 1

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK SHARP EDGES 0.04 / 0.02 R

SHOT PEEN: (SOPM 20-10-03)
0.023-0.055 SHOT SIZE
0.012 A2 INTENSITY

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

113T1226-31 THRU -36,-43,-44,-59,-60

Beam Repair
Figure 602

199411

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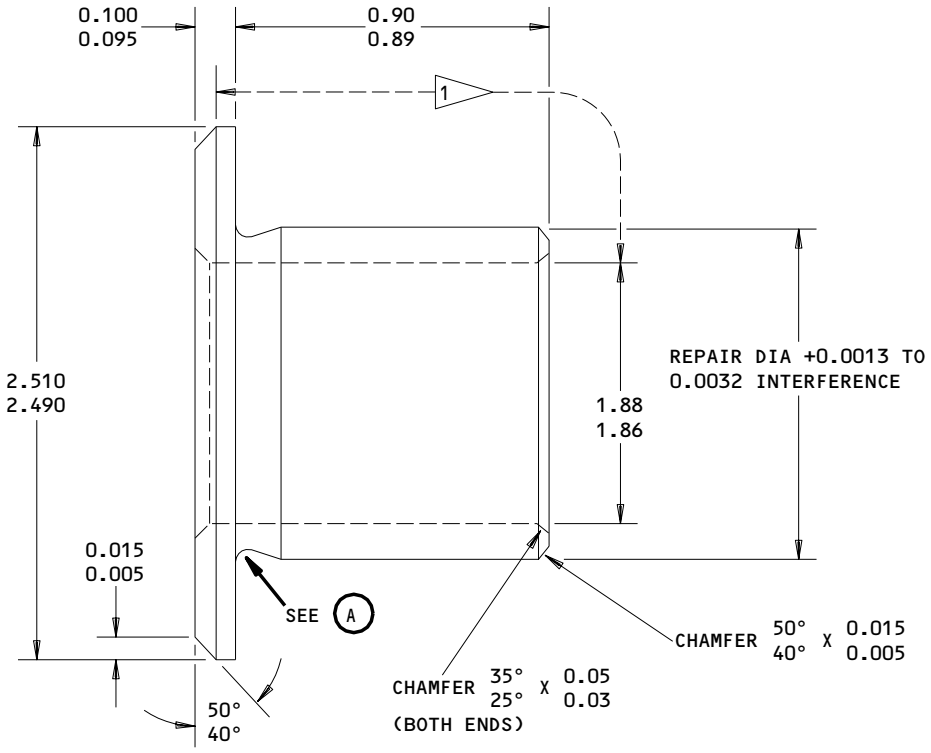

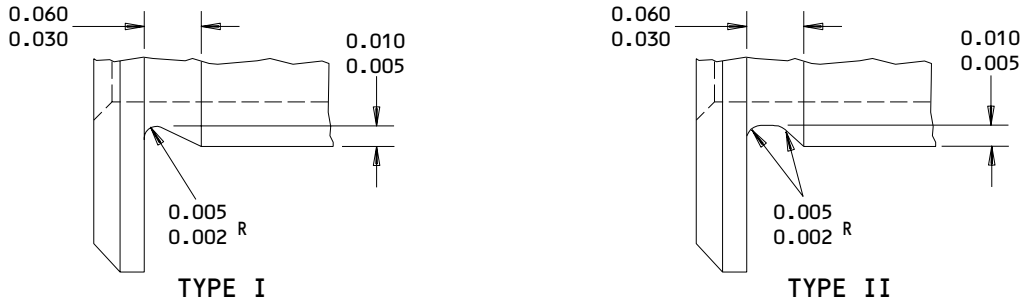

UNDERCUT TYPE I OR TYPE II OPTIONAL

A

1 CADMIUM PLATE (F-15.06)

PLATING OPTIONAL ON ALL OTHER SURFACES

DIMENSIONS APPLY AFTER PLATING

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

63 ALL SURFACES EXCEPT AS NOTED

BREAK SHARP EDGES 0.008 R

CONCENTRICITY BETWEEN ID AND OD SHALL BE

Oversize Bushing Details
Figure 603

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SUPPORT LINK ASSEMBLY - REPAIR 7-1

113T1229-1, -2, -9, -10, -13, -14

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

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

A. Remove bushings (240, 244, 248, 252, 256, 260) and spacer (264).

B. Apply a coat of wet BMS 5-95 to mating surfaces of spacer. Install new bushings and new spacer using shrink fit method (Ref 20-50-03) except use wet BMS 5-95 sealant.

C. Remove excess sealant between lubricated bushings, bushing and spacer faces and lube holes to allow grease to flow freely.

D. Machine bushing bores to the dimensions and finish shown.

E. Fillet seal bushings and spacer per REPAIR 18-1, except do not fillet seal bushing (260).

2. Installation of Oversize Bushing (Fig. 602)

A. Machine hole, as required, within repair limits shown to remove defects and break sharp edges.

B. Shot peen as indicated.

C. Manufacture bushings (Fig. 603), as required, to compensate for amount of material removed.

D. Install bushing per par. 1, steps B. thru E.

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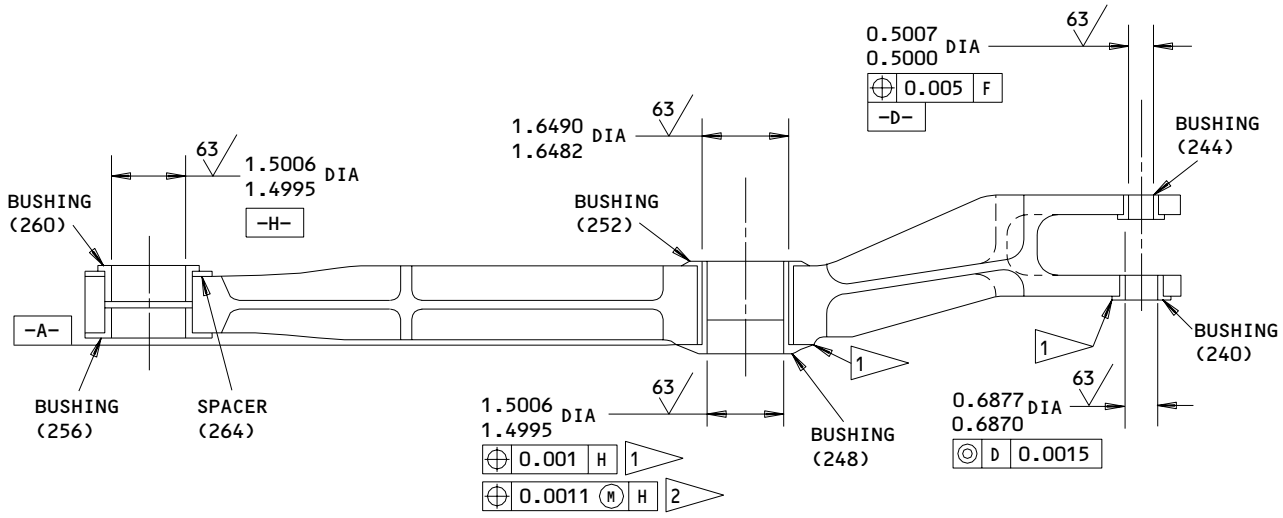

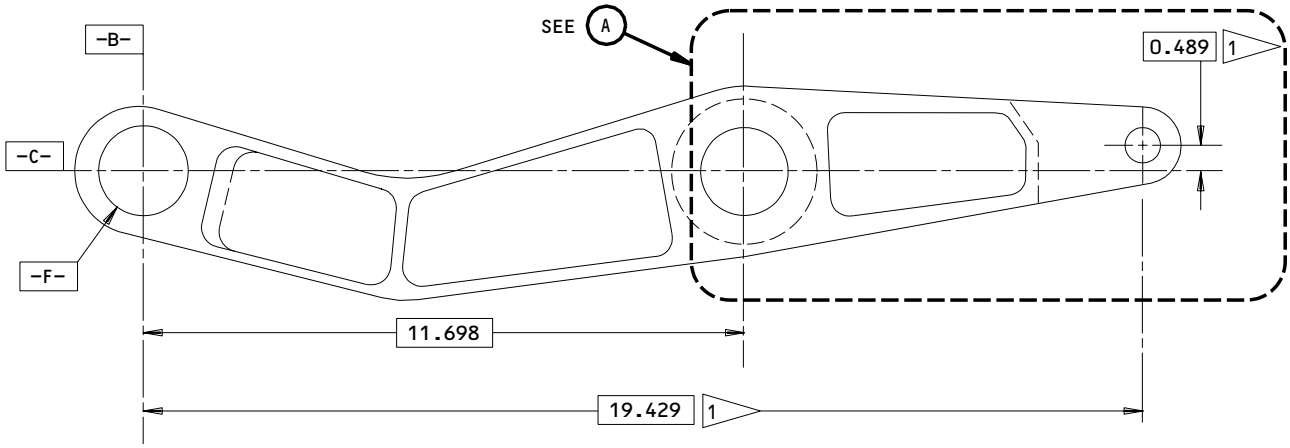

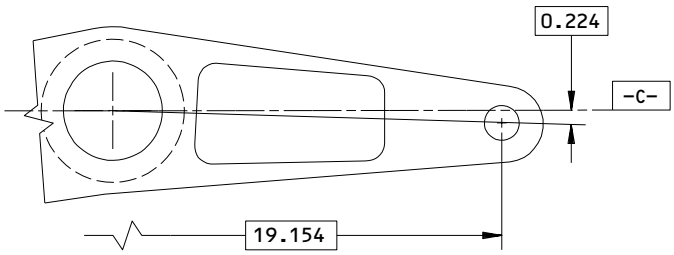

A 2

REFINISH

AFTER BUSHING INSTALLATION, APPLY YELLOW EPOXY PRIMER (SRF-14.995) AND ENAMEL, BMS 10-60 (SRF-14.9813)ALL OVER EXCEPT ON BUSHINGS AND LUBE FITTINGS

1 113T1229-1,-2,-13,-14 ONLY

2 113T1229-9,-10 ONLY

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

113T1229-1,-2,-9,-10,-13,-14
Bushing Replacement
Figure 601

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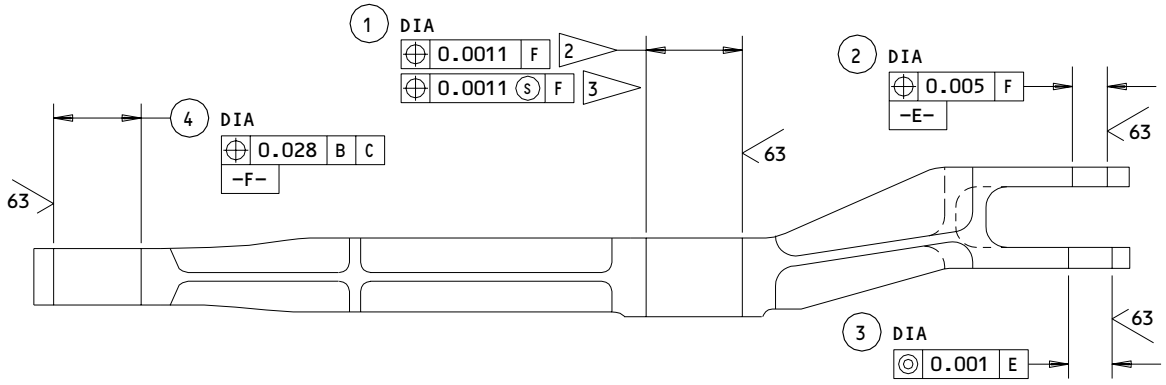

HOLE LOCATION	DESIGN DIA	MAX REPAIR DIA 1
1	1.8589 1.8580	1.9189
2	0.6257 0.6250	0.6857
3	0.8132 0.8125	0.8732
4	1.7189 1.7181	

REFINISH

CHROMIC ACID ANODIZE AND APPLY 1 COAT OF PRIMER (F-18.13) ALL OVER EXCEPT OMIT PRIMER IN ALL HOLES

1 REPAIR DIA FOR INSTALLATION OF OVERSIZE BUSHING

2 113T1229-1,-2,-13,-14 ONLY

3 113T1229-9,-10 ONLY

REPAIR

REF 1

SHOT PEEN: (REF 20-10-03)
0.023-0.055 SHOT SIZE
0.012 A2 INTENSITY

125 ALL MACHINED SURFACES EXCEPT AS NOTED

BREAK SHARP EDGES 0.03 / 0.02 R

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

113T1229-1,-2,-9,-10,-13,-14
Link Repair
Figure 602

199413

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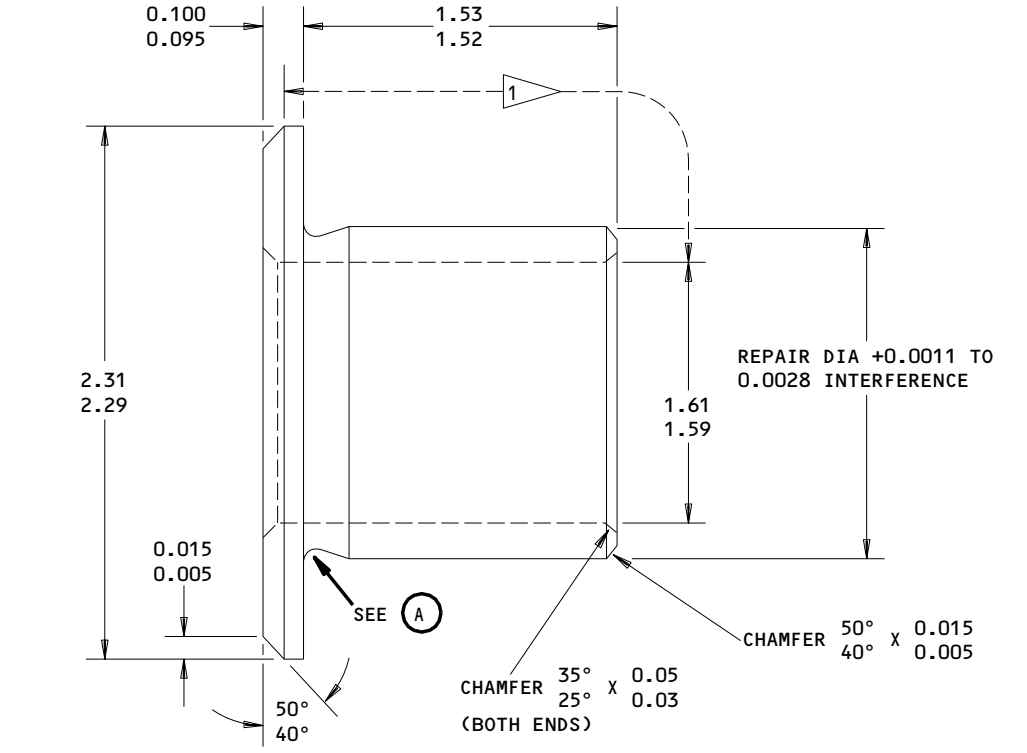

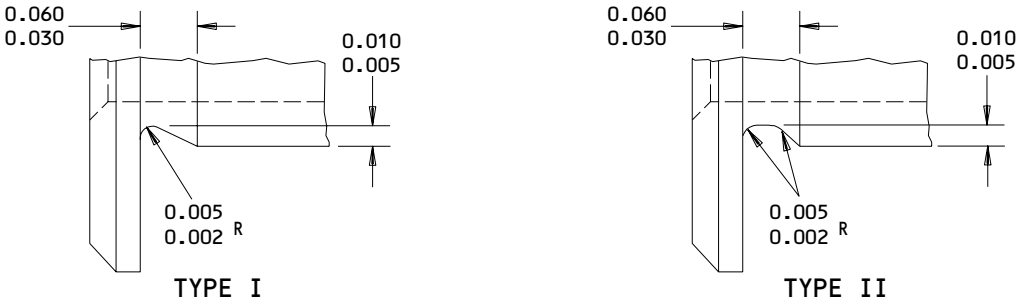

UNDERCUT TYPE I OR TYPE II OPTIONAL

A

1 CADMIUM PLATE (F-15.06)

PLATING OPTIONAL ON ALL OTHER SURFACES

DIMENSIONS APPLY AFTER PLATING

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

63 ALL SURFACES EXCEPT AS NOTED

BREAK SHARP EDGES 0.008 R

CONCENTRICITY BETWEEN ID AND OD SHALL BE 0.003 MAX

ALL DIMENSIONS ARE IN INCHES

OVERSIZE BUSHING FOR HOLE LOCATION 1

Oversize Bushing Details
Figure 603 (Sheet 1)

199414

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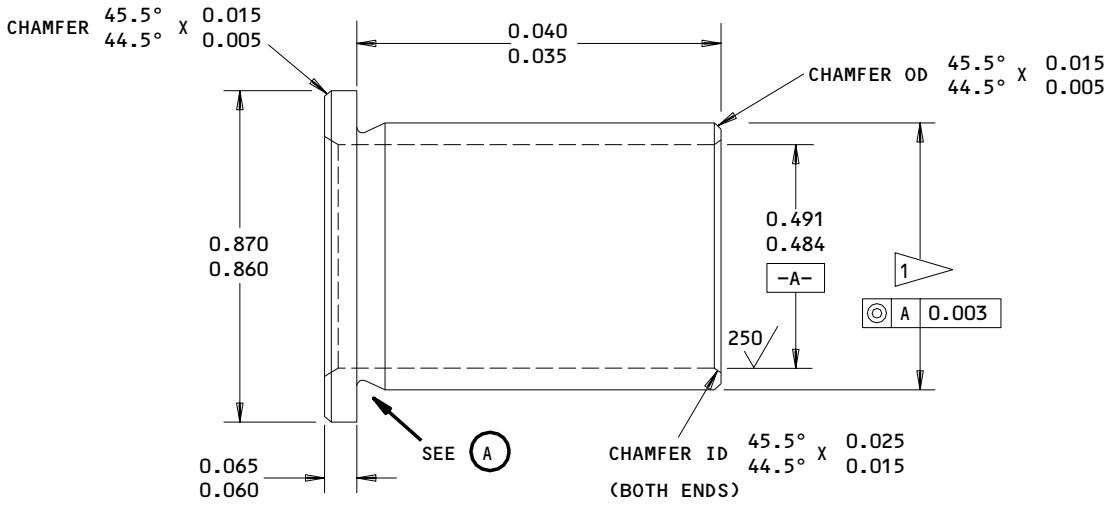

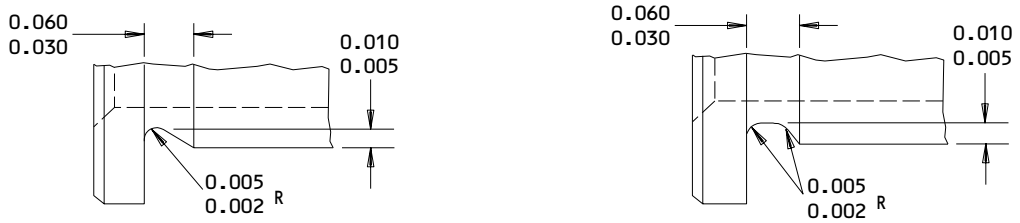

TYPE I TYPE II

UNDERCUT TYPE I OR TYPE II OPTIONAL

(A)

CADMIUM PLATE (F-15.06)

PLATING OPTIONAL IN BORE

1 FINISH DIA AFTER PLATING
(REPAIR DIA OF BORE +0.0004 TO 0.0027 INTERFERENCE)

DIMENSIONS APPLY AFTER PLATING

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

63 ALL SURFACES EXCEPT AS NOTED

BREAK SHARP EDGES 0.008 R

ALL DIMENSIONS ARE IN INCHES

OVERSIZE BUSHING FOR HOLE LOCATION (2)

Oversize Bushing Details
Figure 603 (Sheet 2)

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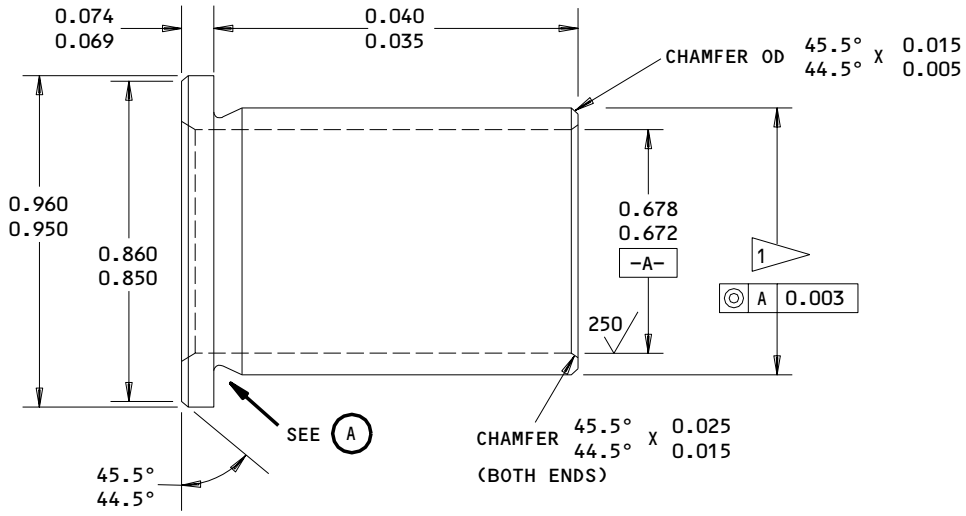
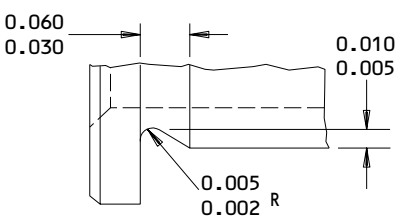
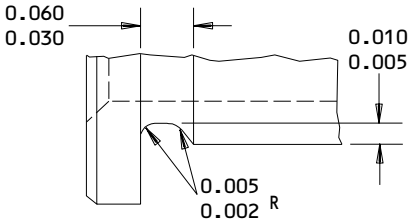




TYPE I



TYPE II

UNDERCUT TYPE I OR TYPE II OPTIONAL

A

CADMIUM PLATE (F-15.06)

PLATING OPTIONAL IN BORE

1 FINISH DIA AFTER PLATING
(REPAIR DIA OF BORE +0.0004 TO 0.0027 INTERFERENCE)

DIMENSIONS APPLY AFTER PLATING

MATERIAL: AL-NI-BR PER AMS 4640

63 ALL SURFACES EXCEPT AS NOTED

BREAK SHARP EDGES 0.008 R

ALL DIMENSIONS ARE IN INCHES

OVERSIZE BUSHING FOR HOLE LOCATION 3

Oversize Bushing Details
Figure 603 (Sheet 3)

199416

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PIN, OUTER - REPAIR 8-1

113T1263-2, -5 thru -8

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. Shank Repair (Fig. 601)

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

   B. Shot peen as indicated.

   C. Build up repair surface with chrome plate and grind to design dimensions and finish shown.

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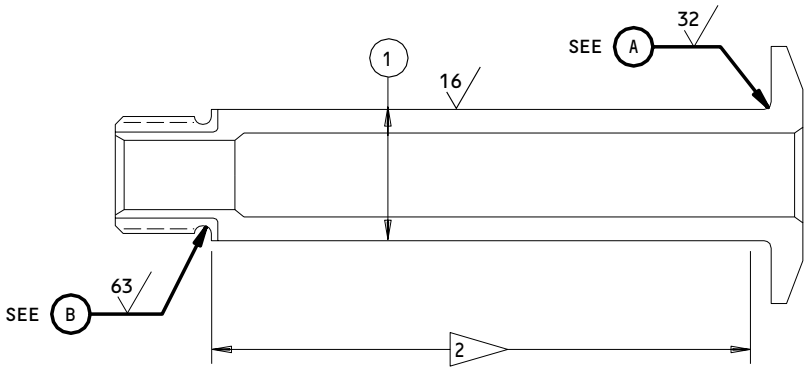
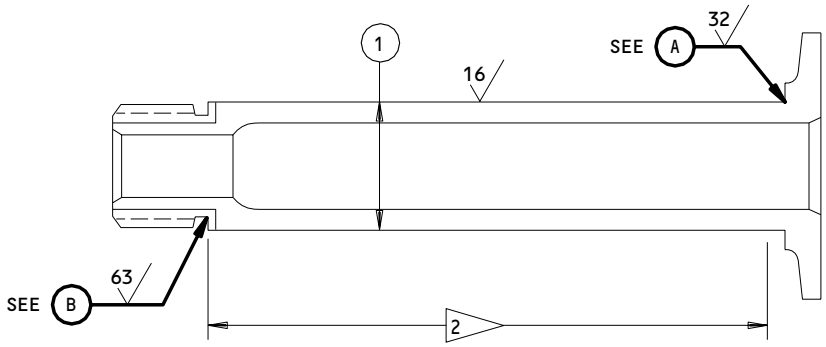
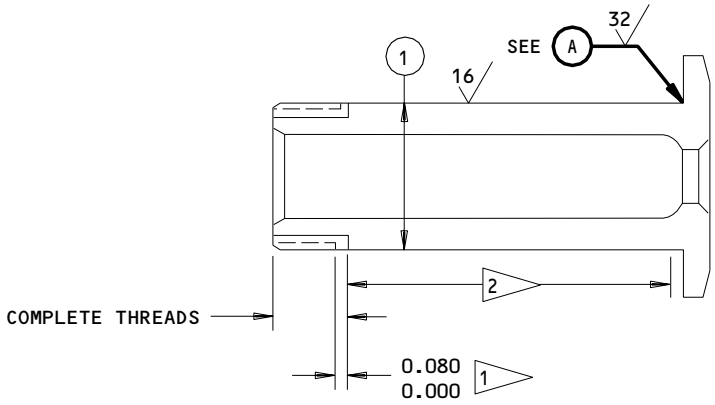


113T1263-5,-8



113T1263-2,-6



113T1263-7

ALL DIMENSIONS ARE IN INCHES

113T1263-2,-5 Thru -8
Pin Repair
Figure 601 (Sheet 1)

169787

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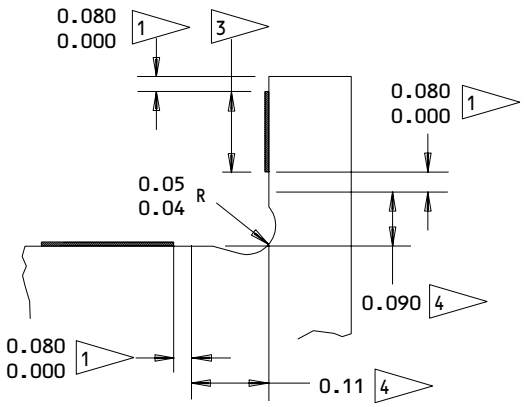
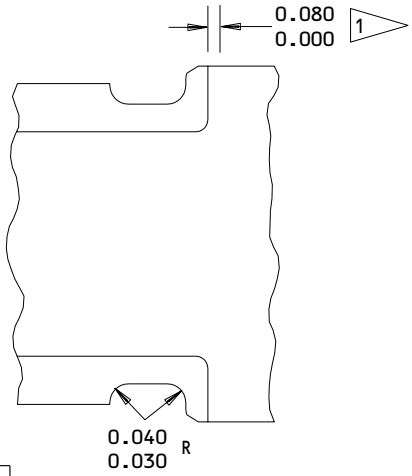


A



B

		(1)	
		DIA BEFORE PLATING	DIA AFTER PLATING
113T1263-2,-6	DESIGN DIM	1.4924 1.4914	1.4990 1.4984
	MIN REPAIR DIA (5)	---	1.4684
113T1263-5,-8	DESIGN DIM	1.7424 1.7414	1.7490 1.7484
	MIN REPAIR DIA (5)	---	1.7184
113T1263-7	DESIGN DIM	1.6174 1.6164	1.6240 1.6234
	MIN REPAIR DIA (5)	---	1.5934

REFINISH

PASSIVATE (F-17.09) ALL OVER AND CHROME PLATE AS NOTED

1. CHROME PLATE RUNOUT AREA
2. CHROME PLATE (F-15.03) THIS SURFACE
3. CHROME PLATE (F-15.03) 0.001 MIN PLATING THICKNESS (113T1263-7,-8 ONLY)
4. NO CHROME PLATE THIS AREA
5. BUILD UP WITH CHROME PLATE (F-15.03) 0.003 TO 0.015 SINGLE PLATE THICKNESS AND GRIND TO DESIGN DIMENSION AND FINISH SHOWN

REPAIR

REF 5

SHOT PEEN: (REF 20-10-03)
0.017-0.046 SHOT SIZE
0.016 A2 INTENSITY

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK SHARP EDGES 0.04 / 0.02 R

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

ALL DIMENSIONS ARE IN INCHES

113T1263-2,-5 Thru -8
Pin Repair
Figure 601 (Sheet 2)

169788

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FITTING ASSEMBLY - REPAIR 9-1

113T1719-1, -2
113T1789-1, -2

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

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

A. Remove existing bushing (604) and spacer (608).

B. Install new spacer with sealant, BMS 5-95. Wipe excess sealant from edges of the spacer.

C. Check dimension and machine bushing to dimension and finish as shown. Install the new bushing into the existing fitting (612 or 614) with grease, MIL-G-23827, per SOPM 20-50-03.

D. Install the fitting assembly (596 or 598) on the beam assembly (332B), then machine the bushing bore to the dimension and finish shown.

NOTE: The fitting assembly is installed so the concentricity requirement with the bushing (540) in the opposing fitting assembly (528 or 532) can be met. If a new fitting assembly (596 or 598) is used, the bushing (604) can be machined before the fitting assembly is installed on the beam assembly. The new fitting assembly must be put in the correct location on the support beam assembly in order to meet the concentricity requirement before the bolt holes in the fitting are machined. Refer to ASSEMBLY.

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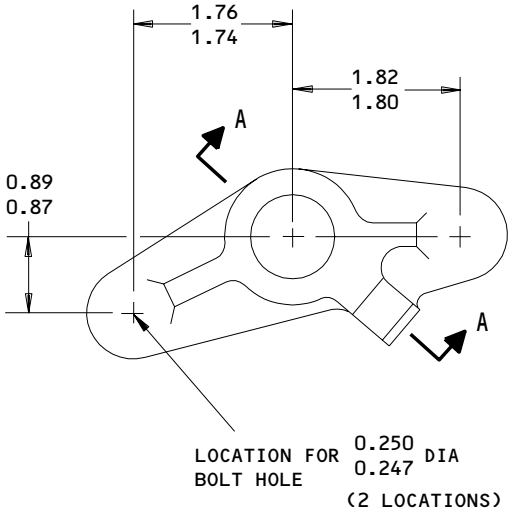
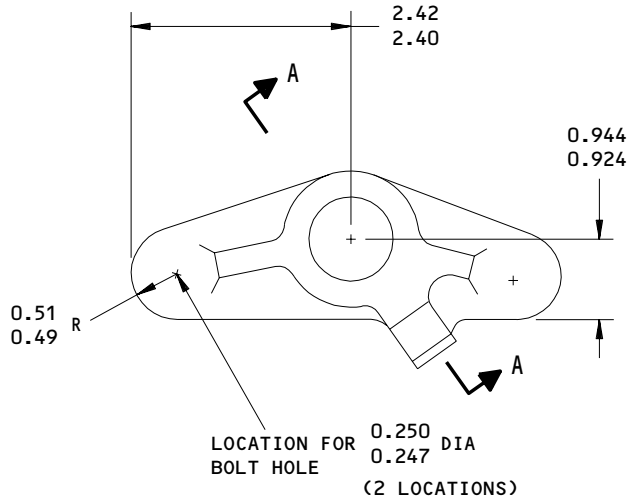
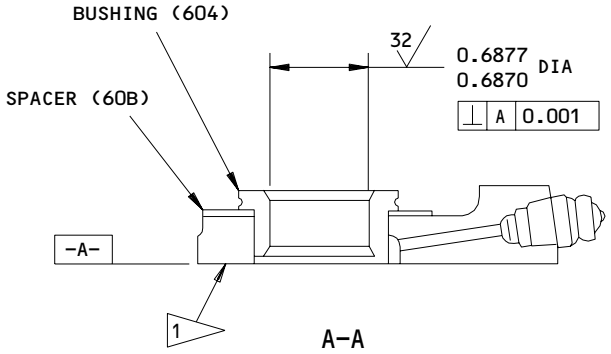


113T1719-1,-2



113T1789-1,-2



113T1719-1,-2
113T1789-1,-2
Bushing Replacement and Fitting Refinish
Figure 601 (Sheet 1)

169789

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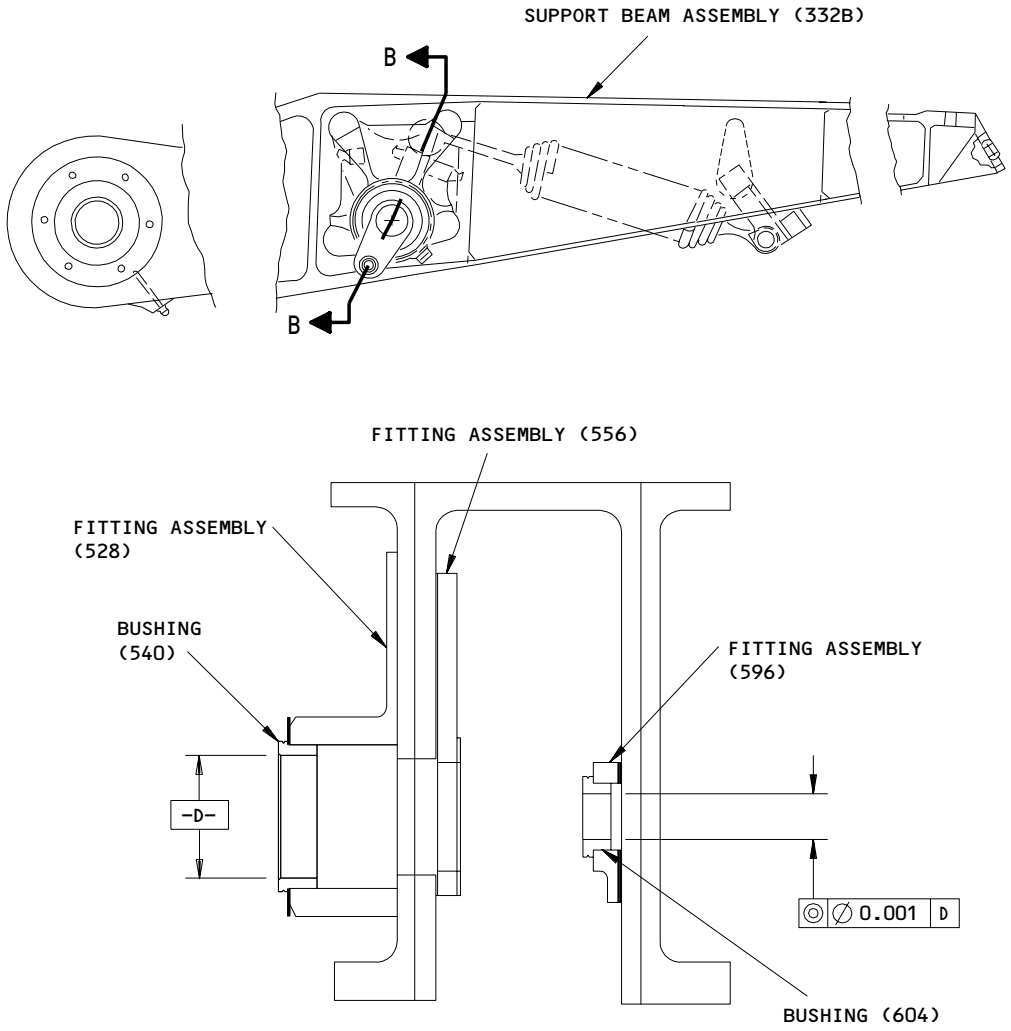

(SHAFT ASSEMBLY, BELLCRANK ASSEMBLY AND SEALS NOT SHOWN)
B-B

REFINISH

FITTING (612) -- CHROMIC ACID ANODIZE AND APPLY 1 COAT OF PRIMER, BMS 10-11, TYPE 1 (F-18.13) ALL OVER EXCEPT OMIT PRIMER ON ALL HOLES FITTING ASSEMBLY (596) -- CLEAN AND APPLY 1 COAT OF PRIMER, BMS 10-11, TYPE 1, YELLOW, (SRF-14.995) AND APPLY 707 GRAY GLOSS ENAMEL (SRF-14.9813) EXCEPT ON FAYING SURFACE, BUSHING, AND LUBE FITTING.

1 FAYING SURFACE

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

113T1719-1,-2
113T1789-1,-2
Bushing Replacement and Fitting Refinish
Figure 601 (Sheet 2)

L92148

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FITTING ASSEMBLY - REPAIR 10-1

113T1586-1, -2
113T1726-1, -2

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

1. Lockbolts (560, 564) and Collars (568) Replacement (Fig. 601)

   A. Remove existing lockbolts (560, 564) and collars (568).

   B. Install new lockbolts (560, 564) and collars (568) as shown.

2. Thrust Plate Replacement

   A. Remove existing thrust plate (572) and rivets (576).

   B. Install new thrust plate with sealant, BMS 5-95 on faying surface. Check that the holes in thrust plate (572) are concentric to holes in fitting (580) within 0.005 FIM.

   C. Install rivets (576) countersunk both ends. Check that rivet heads are flush to 0.005 inch below surface.

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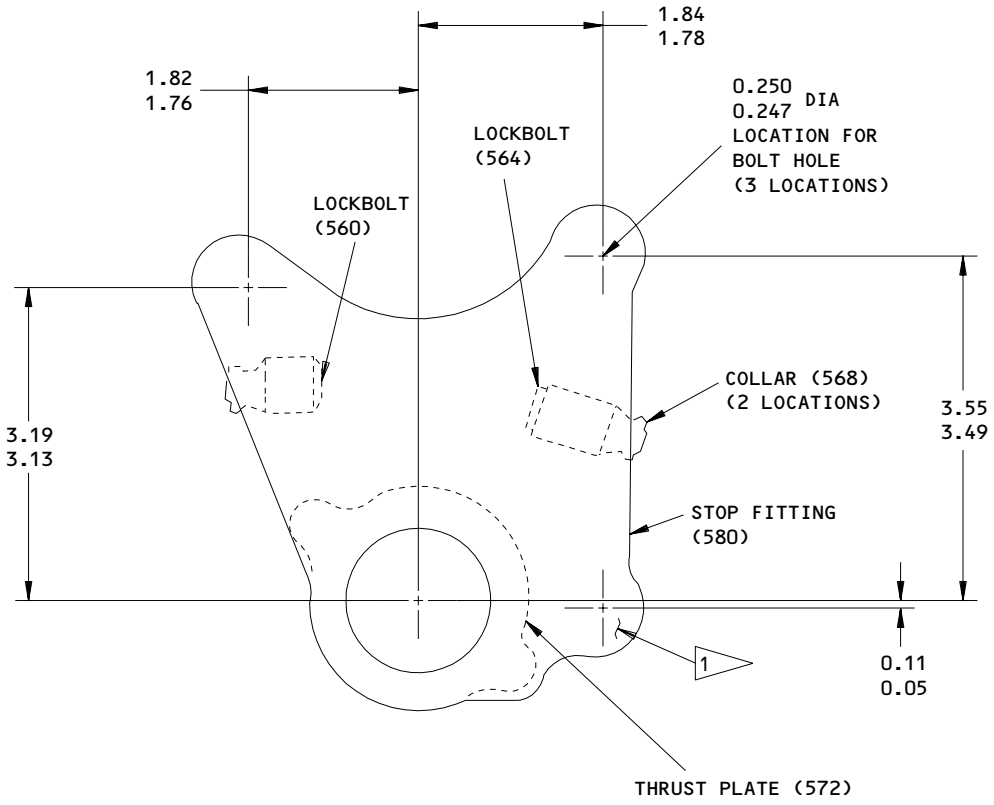

REFINISH

FITTING (580) -- CHROMIC ACID ANODIZE AND APPLY 1 COAT OF PRIMER, BMS 10-11, TYPE 1 (F-18.13) ALL OVER FITTING ASSEMBLY (556) -- CLEAN AND APPLY 1 COAT OF PRIMER, BMS 10-11, TYPE 1, YELLOW, (SRF-14.995) AND APPLY 707 GRAY GLOSS ENAMEL (SRF-14.9813) EXCEPT ON FAYING SURFACE.

1 FAYING SURFACE

MATERIAL: AL ALLOY

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

113T1586-1,-2
113T1726-1,-2
Parts Replacement and Fitting Refinish
Figure 601

169791

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SPRING ASSEMBLY - REPAIR 11-1

113T1731-1, -5

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

1. Bearing Replacement for 113T1731-1

   A. Remove existing bearings (496).

   B. Install new bearings and roller swage per 20-50-03 except use wet sealant, BMS 5-95. Fillet seal edges of bearings with sealant.

2. Insert Replacement for 113T1731-5

   A. Remove existing inserts (514, 515).

   B. Install new inserts by using a slight overbend on spring and snap inserts in place.

      NOTE: Inserts must withstand 50 lbs. minimum load before snapping out of place.

3. Refinish

   A. Spring (512) -- Passivate (F-17.09). Material: 17-7PH CRES.

   B. Terminal (504, 508) -- Passivate (F-17.09). Material: 15-5PH CRES, 180-200 ksi.

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SHAFT AND BELLCRANK ASSEMBLY - REPAIR 12-1

113T1737-1, -2, -9, -10, -19, -20

1. Parts Replacement (Fig. 601)

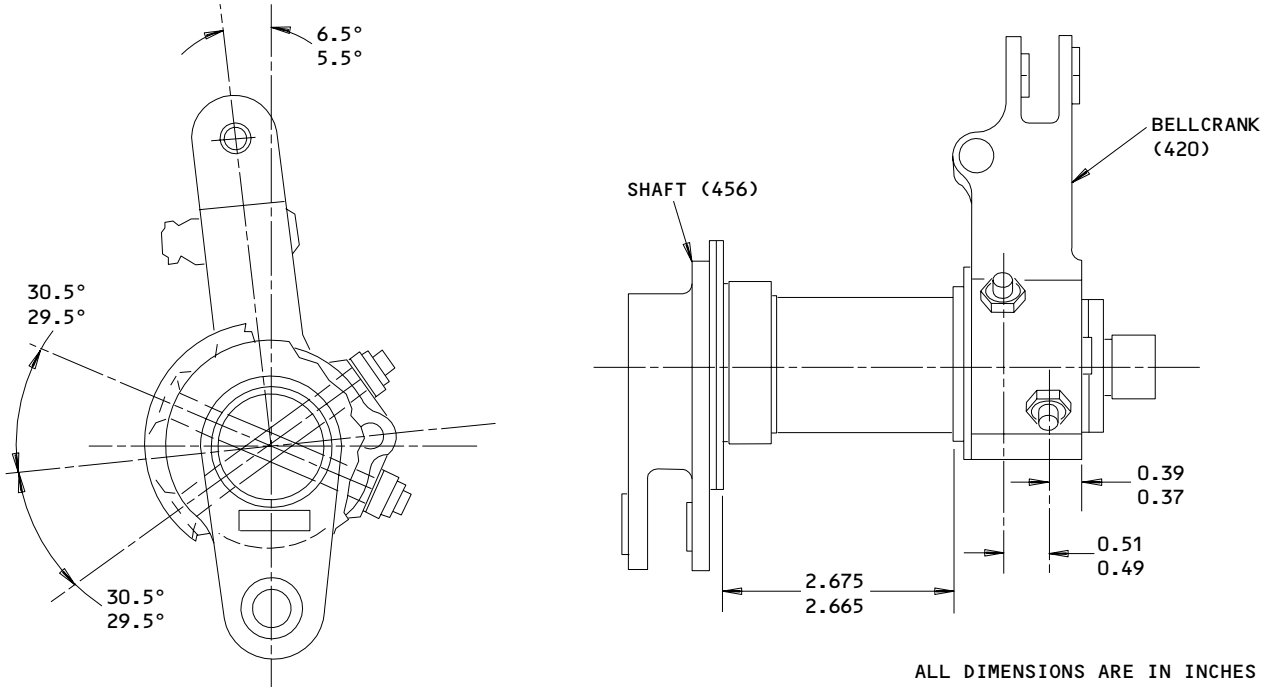
NOTE: Refer to REPAIR-GEN for list of applicable standard practices.

A. Remove bolts (408), washers (412), nuts (416) and separate shaft (456) and bellcrank (420 or 424).

B. Position replacement part as shown. Drill 0.247-0.250 dia holes thru as indicated.

C. Install bolts (408), washers (412), nuts (416). Tighten nuts (416) finger tight.

NOTE: Fasteners will be removed and reinstalled during assembly.



Parts Replacement
Figure 601

169830

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SHAFT ASSEMBLY - REPAIR 13-1

113T1737-3, -11

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

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

A. Remove existing bushings (464A, 468, 472).

B. Install new bushings using shrink fit method per 20-50-03 except use wet sealant, BMS 5-95.

C. Machine bushing bores to the dimensions and finish shown.

D. Seal bushing flanges per REPAIR 18-1.

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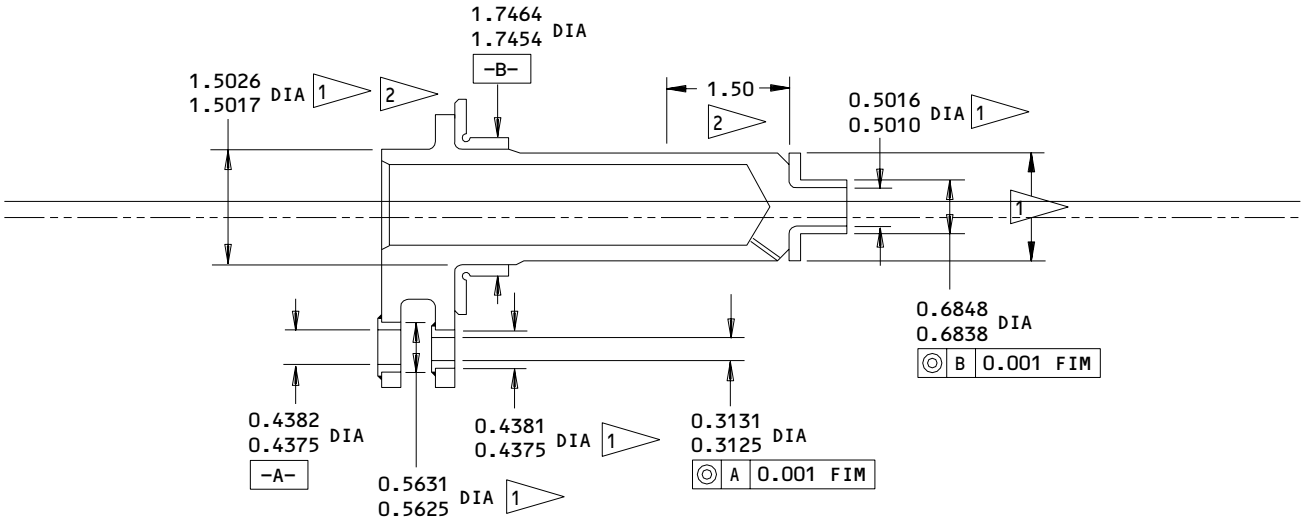

REFINISH

CHROMIC ACID ANODIZE AND APPLY 1 COAT OF PRIMER, BMS 10-11, TYPE 1 (F-18.13) ALL OVER EXCEPT AS NOTED IN 1. AFTER BUSHING INSTALLATION, APPLY ENAMEL, BMS 10-60 (SRF-14.9813) ALL OVER EXCEPT ON BUSHINGS

1 OMIT PRIMER THIS SURFACE

2 OMIT ENAMEL THIS SURFACE

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

Bushing Replacement and Shaft Refinish
Figure 601

169833

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BELLCRANK ASSEMBLY - REPAIR 14-1

113T1737-5, -6, -13, -14, -15, -16

NOTE: Refer to REPAIR-GEN for list of applicable standard practices. For repair of bellcrank (420, 424, IPL Fig. 1) surfaces which may only consist of stripping and restoration of original finish, refer to Refinish Instructions, Fig. 601.

1. Bushing Replacement (Fig. 601)

A. Remove existing bushings (428, 432A).

B. Install new bushings using shrink fit method per 20-50-03 except use wet sealant, BMS 5-95.

C. Machine bushing bores to the dimensions and finish shown.

D. Seal bushings per REPAIR 18-1.

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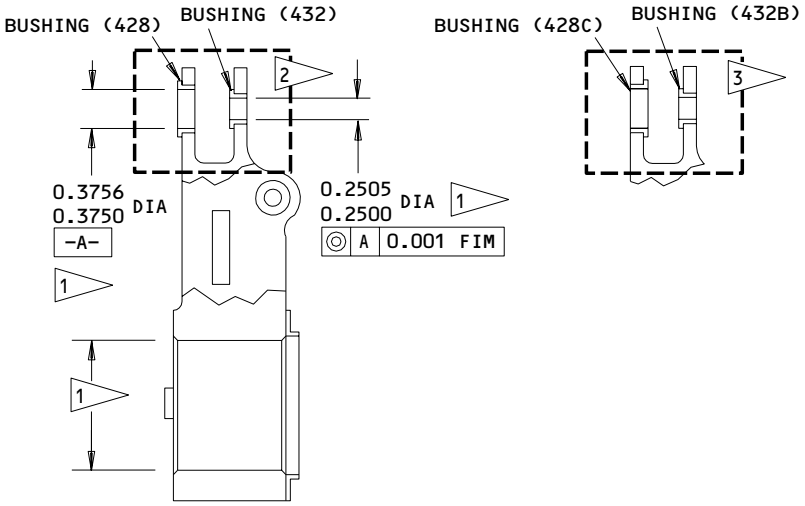

REFINISH

BELL CRANK (452) -- CHROMIC ACID ANODIZE AND APPLY 1 COAT OF PRIMER, BMS 10-11, TYPE 1 (F-18.13) ALL OVER EXCEPT OMIT PRIMER IN BUSHING HOLES AS NOTED BY 1. AFTER BUSHING INSTALLATION, APPLY ENAMEL, BMS 10-60 (SRF-14.9813) ALL OVER EXCEPT ON BUSHING BORES, FLANGES, AND BEARING DIA. WITHIN 1.50 DIA.

1 OMIT PRIMER FROM THIS AREA 113T1737-13,-14,-15,-16

2 113T1737-13,-14

3 113T1737-15,-16

REPAIR

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

Bushing Replacement and Bellcrank Refinish
Figure 601

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FITTING ASSEMBLY - REPAIR 15-1

113T1738-1
113T1743-1, -5

NOTE: Refer to REPAIR-GEN for list of applicable stancard practices. For repair of fitting surfaces which may only consist of strippingand restoration of original finish, refer to Refinish Instructions, Fig.601.

1. Bushing Replacement (Fig. 601)

A. Remove existing bushings (652, 656).

B. Install new bushings using shrink-fit method per 20-50-03 except use wet sealant, BMS 5-95.

NOTE: Flanges of both bushings (652B, 656B) are on the inside of the clevis on fitting assembly 113T1743-5 only.

C. Machine bushings to dimensions and finish shown.

D. Seal bushings per REPAIR 18-1, except do not seal bushings (652B, 656B).

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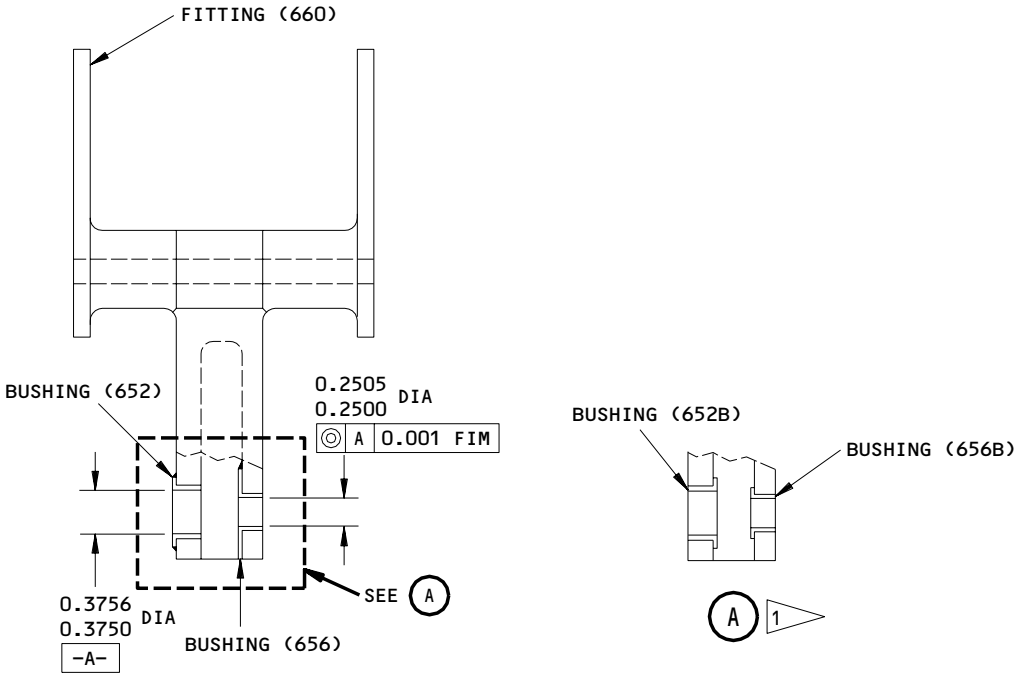

REFINISH

CHROMIC ACID ANODIZE AND APPLY 1 COAT OF PRIMER, BMS 10-11, TYPE 1 (F-18.13) ALL OVER EXCEPT NO PRIMER IN BUSHING HOLES. AFTER BUSHING INSTALLATION, APPLY ENAMEL, BMS 10-60 (SRF-14.9813) ALL OVER EXCEPT IN BUSHING BORES AND FACES

1 113T1743-5 ONLY

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: AL ALLOY

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

113T1738-1
113T1743-1,-5
Bushing Replacement and Fitting Refinish
Figure 601

169839

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FITTING ASSEMBLY - REPAIR 16-1

113T1009-1, -2, -9, -10
113T1739-1, -2, -7, -8

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

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

A. Remove existing bushing (540) and spacer (544).

B. Install the new spacer and bushing into the existing fitting (548 or 552) with sealant, BMS 5-95, per SOPM 20-50-03. Remove excess sealant from the exposed surfaces of the bushing and spacer, and from the lube passage. Fillet seal only the edges of the spacer with sealant.

C. Install the new bushing into the existing fitting (548 or 552) with grease, MIL-G-23827, per SOPM 20-50-03.

D. Install the fitting assembly (548 or 552) on the beam assembly (332B), then machine the bushing bore to the dimension and finish shown.

NOTE: The fitting assembly is installed so the concentricity requirement with the bushing (604) in the opposing fitting assembly (596) can be met. If a new fitting assembly (548 or 552) is used, the bushing (540) can be machined before the fitting assembly is installed on the beam assembly. The new fitting assembly must be put in the correct location on the support beam assembly in order to meet the concentricity requirement before the bolt holes in the fitting are machined. Refer to ASSEMBLY.

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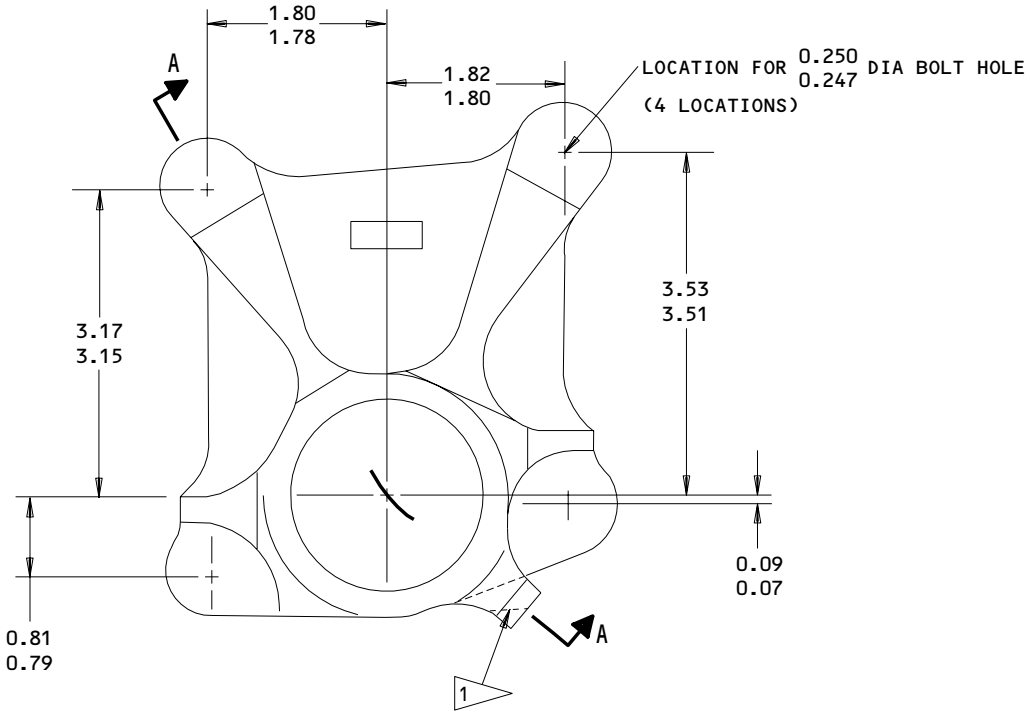

A-A

113T1739-1,-2,-7,-8
113T1009-1,-2,-9,-10
Bushing Replacement and Fitting Refinish
Figure 601 (Sheet 1)

169841

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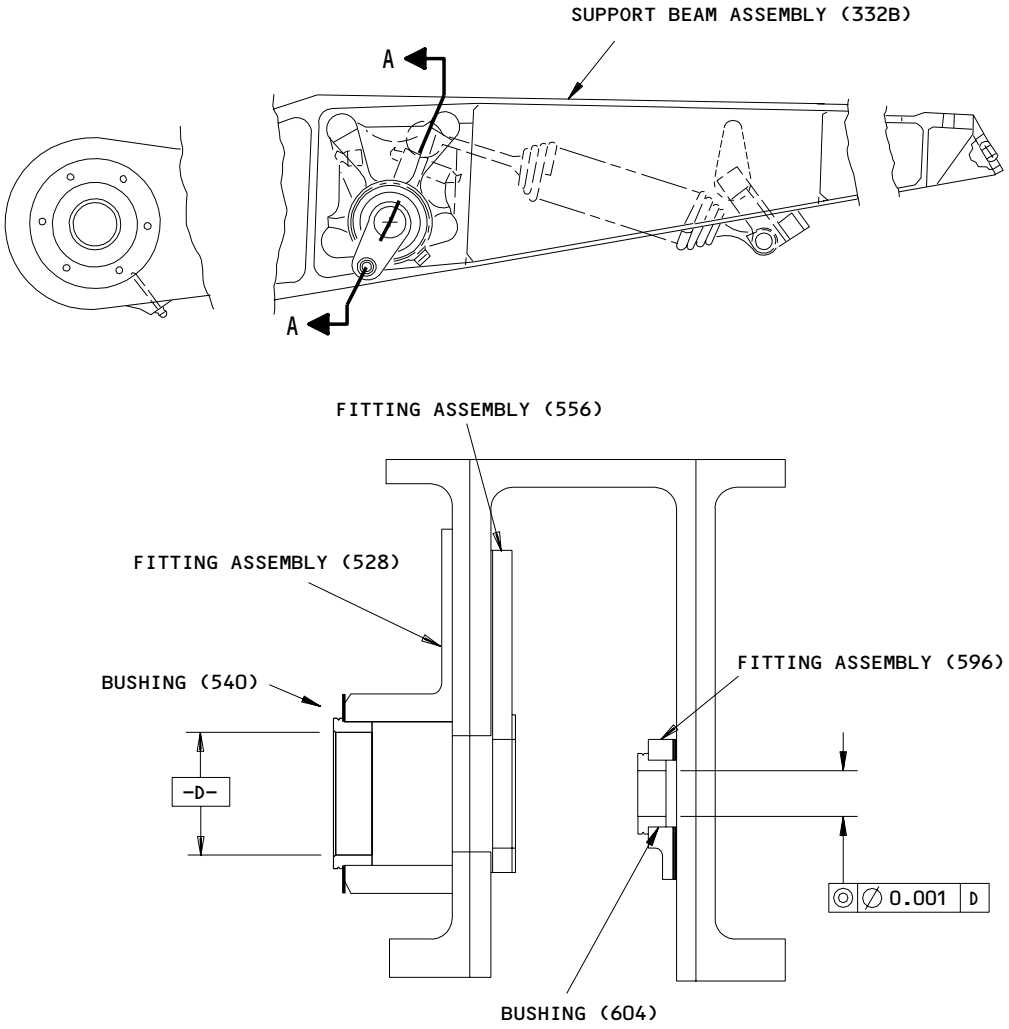

(SHAFT ASSEMBLY, BELLCRANK ASSEMBLY AND SEALS NOT SHOWN)
B-B

REFINISH

FITTING (548) -- CHROMIC ACID ANODIZE AND APPLY 1 COAT OF PRIMER, BMS 10-11, TYPE 1 (F-18.13) ALL OVER EXCEPT ON ALL HOLES. AFTER BUSHING INSTALLATION, APPLY ENAMEL, BMS 10-60 (SRF-14.9813) ALL OVER EXCEPT ON BUSHING AND LUBE FITTING

1 CORNER SHAVED ON ASSEMBLIES 113T1739-7,-8 AND 113T1009-9,-10 ONLY

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

113T1739-1,-2,-7,-8
113T1009-1,-2,-9,-10
Bushing Replacement and Fitting Refinish
Figure 601 (Sheet 2)

L92515

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MISC PARTS REFINISH - REPAIR 17-1

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

IPL FIG. & ITEM	MATERIAL	FINISH
Fig. 1		
Pin (12A,84A,208A, 312A), Washers (16,88,212)	15-5PH CRES, 180-200 ksi	Passivate (F-17.09) all over.
Washer (28,100, 228,324,760)	15-5PH CRES, 180-200 ksi	Chrome plate (0.0005-0.0010 thick, F-15.03) all over except on ID and OD.
Nuts (32,104,232, 328,764)	15-5PH CRES	Apply BMS 3-8 dry film lubricant on threads and exterior surfaces.
Retainer (348), plate (344)	15-5PH CRES	Cadmium plate (F-15.06) all over.
End cap (748,752)	15-5PH CRES, 180-200 ksi	Apply bms 3-8, type 8 dry film lubricant all over.
Straps (192,196 676), beam (200, 728,732,736),links (924)	Al alloy	Chromic acid anodize type 1, and apply one coat BMS 10-11, type 1 primer (F-18.13) all over.
Link (272,273)	Al alloy	Chromic acid anodize type 1, and apply one coat BMS 10-11, type 1 primer (F-18.13) except no primer in holes.

Refinish Details
Figure 601 (Sheet 1)

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IPL FIG. & ITEM	MATERIAL	FINISH
Thrust plate (572)	301 CRES	Cadmium plate (F-15.06) and apply one coat of primer, BMS 10-11, type 1 (F-20.02) all over.
Pins (12, 84, 208, 312)	Titanium alloy	No finish.

Refinish Details
Figure 601 (Sheet 2)

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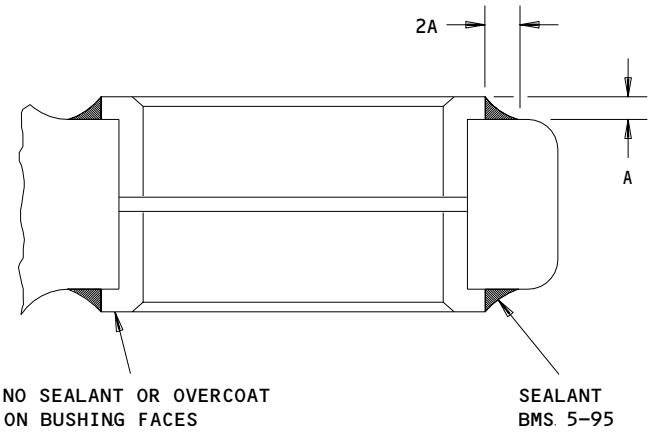
BUSHING SEALING - REPAIR 18-1

1. Seal all flanged bushings according to Fig. 601.



1. CLEAN AREAS OF SEALANT APPLICATION WITH SOLVENT.
2. APPLY FILLET OF SEALANT TO EDGES OF BUSHINGS AS SHOWN.

Bushing Sealant Application
Figure 601

169842

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SUPPORT LINK ASSEMBLY - REPAIR 19-1

113T2066-1, -2, -11, -12

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

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

A. Remove bushings (240, 244, 248, 252, 256, 260) and spacer (264).

B. Apply a coat of wet BMS 5-95 to mating surfaces of spacer. Install new bushings and new spacer using shrink fit method (Ref 20-50-03) except use wet BMS 5-95 sealant.

C. Remove excess sealant between lubricated bushings, bushing and spacer faces and lube holes to allow grease to flow freely.

D. Machine bushings to the dimensions and finish shown.

E. Fillet seal bushings and spacer per REPAIR 18-1.

2. Installation of Oversize Bushing (Fig. 602)

A. Machine hole, as required, within repair limits shown to remove defects and break sharp edges.

B. Shot peen as indicated.

C. Manufacture bushings (Fig. 603), as required, to compensate for amount of material removed.

D. Install bushing per par. 1, steps B. thru E.

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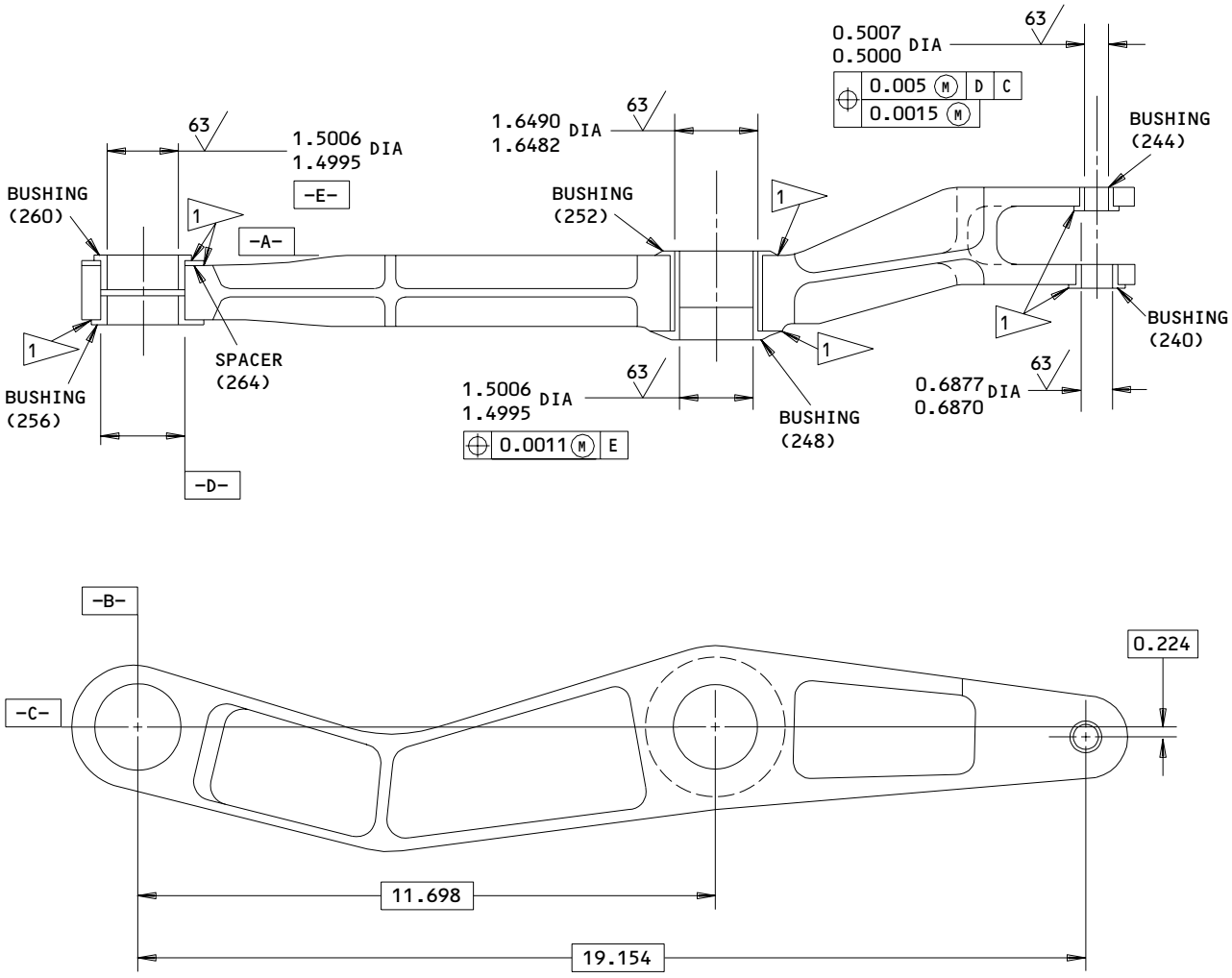

REFINISH

AFTER BUSHING INSTALLATION, APPLY YELLOW EPOXY PRIMER (SRF-14.995) AND ENAMEL, BMS 10-60 (SRF-14.9813) ALL OVER EXCEPT ON BUSHINGS, THREADED HOLES AND LUBE FITTINGS

1 FILLET SEAL BUSHING FLANGES AND SPACER AFTER INSTALLATION AS SHOWN IN REPAIR 18-1 USING BMS 5-95. REMOVE SEALANT FROM BUSHING FACES,SPACER AND LUBE PASSAGES TO ALLOW GREASE TO FLOW FREELY.

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

113T2006-1,-2,-11,-12
Bushing Replacement
Figure 601

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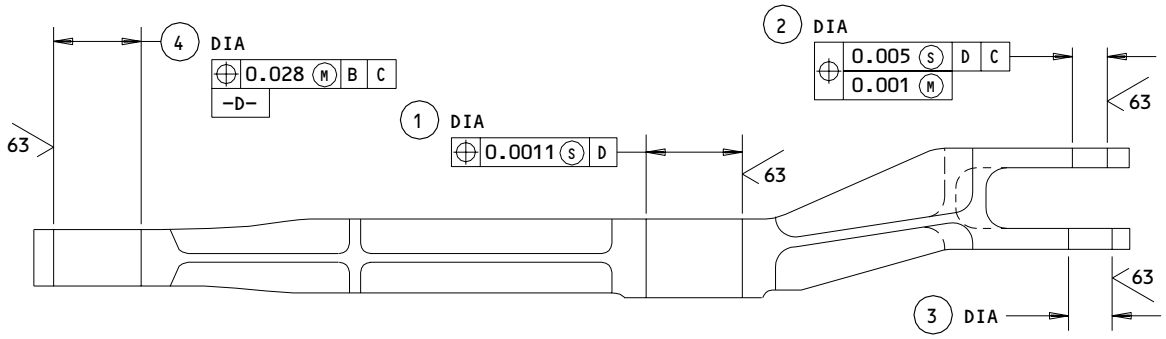

HOLE LOCATION	DESIGN DIA	MAX REPAIR DIA 1
1	1.8589 1.8580	1.9189
2	0.6257 0.6250	0.6857
3	0.8132 0.8125	0.8732
4	1.7189 1.7181	

REFINISH

CHROMIC ACID ANODIZE AND APPLY 1 COAT OF PRIMER (F-18.13) ALL OVER EXCEPT OMIT PRIMER IN ALL HOLES

1 REPAIR DIAMETER FOR INSTALLATION OF OVERSIZE BUSHING

REPAIR

REF 1

SHOT PEEN: (REF 20-10-03)
0.023-0.055 SHOT SIZE
0.01 A2 INTENSITY, COVERAGE 2.0

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK SHARP EDGES 0.03 / 0.02 R

MATERIAL: AL ALLOY 7075-T73

ALL DIMENSIONS ARE IN INCHES

113T2006-1,-2,-11,-12
Link Repair
Figure 602

890527

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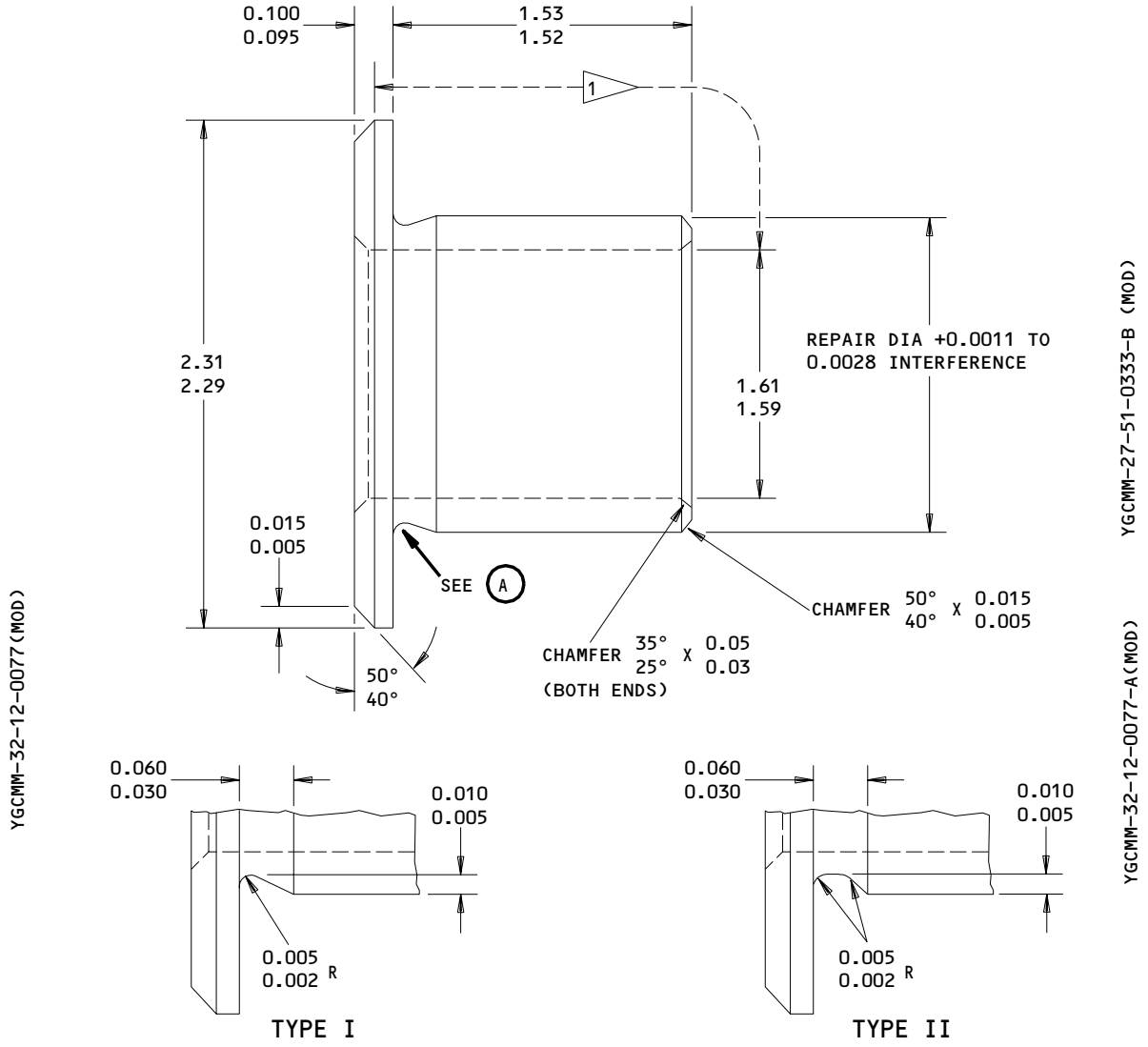

UNDERCUT TYPE I OR TYPE II OPTIONAL

A

1 CADMIUM PLATE (F-15.06)

PLATING OPTIONAL ON ALL OTHER SURFACES

DIMENSIONS APPLY AFTER PLATING

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

63 ALL SURFACES EXCEPT AS NOTED

BREAK SHARP EDGES 0.008 R

CONCENTRICITY BETWEEN ID AND OD SHALL BE 0.003 MAX

ALL DIMENSIONS ARE IN INCHES

OVERSIZE BUSHING FOR HOLE LOCATION 1

Oversize Bushing Details
Figure 603 (Sheet 1)

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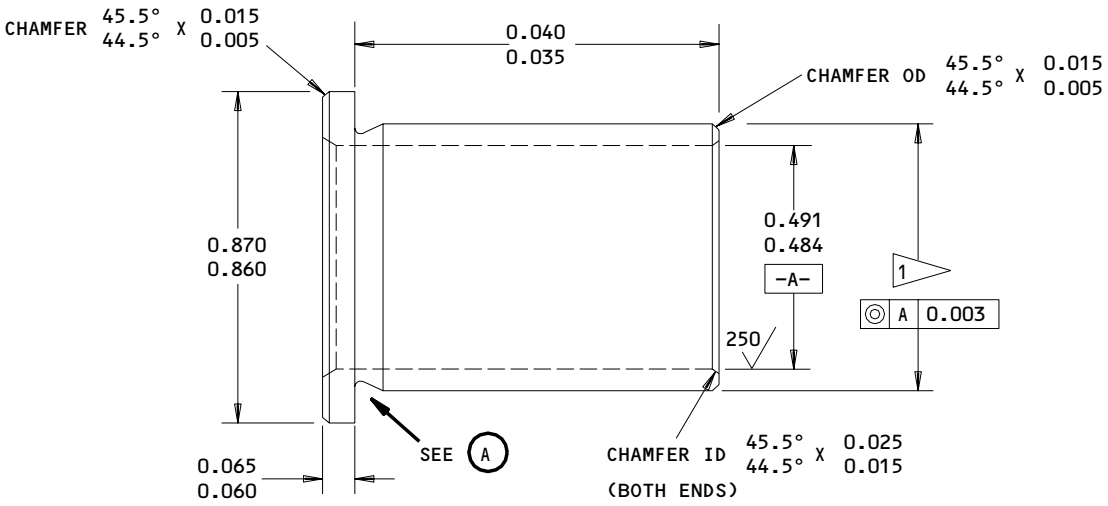
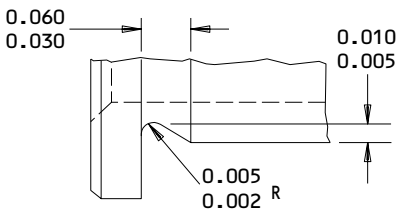
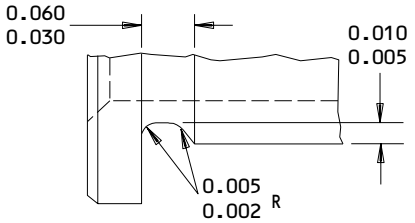




TYPE I



TYPE II

UNDERCUT TYPE I OR TYPE II OPTIONAL

(A)

CADMIUM PLATE (F-15.06)

PLATING OPTIONAL IN BORE

1 FINISH DIA AFTER PLATING
(REPAIR DIA OF BORE +0.0004 TO 0.0027 INTERFERENCE)

DIMENSIONS APPLY AFTER PLATING

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

63 ALL SURFACES EXCEPT AS NOTED

BREAK SHARP EDGES 0.008 R

ALL DIMENSIONS ARE IN INCHES

OVERSIZE BUSHING FOR HOLE LOCATION (2)

Oversize Bushing Details
Figure 603 (Sheet 2)

890530

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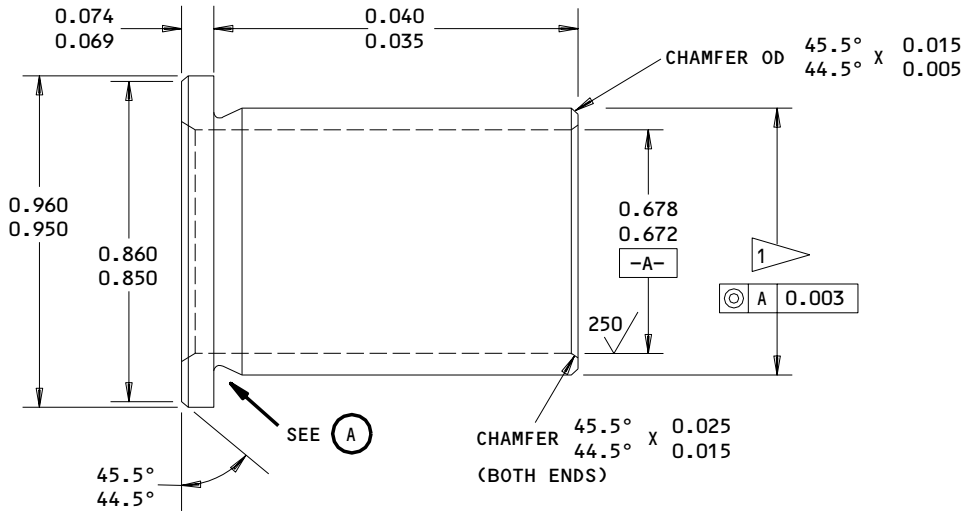
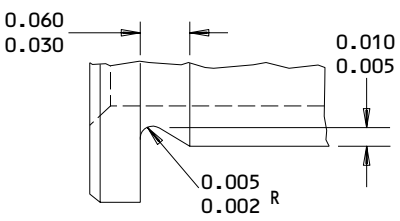
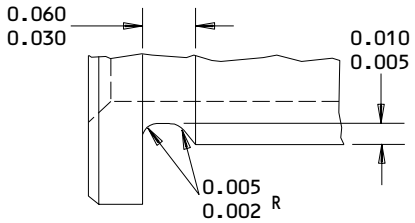




TYPE I



TYPE II

UNDERCUT TYPE I OR TYPE II OPTIONAL

(A)

CADMIUM PLATE (F-15.06)

PLATING OPTIONAL IN BORE

1 FINISH DIA AFTER PLATING
(REPAIR DIA OF BORE +0.0004 TO 0.0027 INTERFERENCE)

DIMENSIONS APPLY AFTER PLATING

MATERIAL: AL-NI-BR PER AMS 4640

63 ALL SURFACES EXCEPT AS NOTED

BREAK SHARP EDGES 0.008 R

ALL DIMENSIONS ARE IN INCHES

OVERSIZE BUSHING FOR HOLE LOCATION (3)

Oversize Bushing Details
Figure 603 (Sheet 3)

890531

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ASSEMBLY

1. Materials

NOTE: Equivalent substitutes may be used.

A. Lockwire -- MS20995NC40-3

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

2. Assembly (IPL Fig. 1)

A. Assemble beam assembly (332B or 334) (Fig. 701).

NOTE: Perform step (1) and (2) only if new parts are used to assemble the component.

(1) Locate fitting assemblies (528 or 532, 556 or 558) on beam and drill fastener holes at locations indicated in REPAIR 6-1, 10-1, 16-1. Use existing holes in beam as a pattern.

(2) Locate fitting assembly (596 or 598) on beam and drill fastener holes at locations indicated in REPAIR 6-1, 9-1. Use existing holes in beam as a pattern. Observe concentricity requirement with respect to fitting assembly (528 or 532) per Fig. 701.

(3) Temporarily assemble fitting assemblies (528 or 532, 556 or 558, 596 or 598) and shims (584, 616) on beam.

(4) Remove bolts (408), washers (412), nuts (416) and separate bellcrank assembly (420 or 424) from shaft assembly (456).

(5) Position bellcrank assembly (420 or 424) in beam and install shaft assembly (456). Temporarily secure bellcrank assembly to shaft assembly.

(6) Measure gap between bellcrank assembly (420 or 424) and fitting assembly (556 or 558) and between shaft assembly (456) and fitting assembly (596 or 598). Adjust thickness of shims (584, 616) as required so that gaps at both places are 0.003 maximum.

(7) Remove parts temporarily installed.

(8) Install seals (480, 484, 488) on fitting assemblies (528 or 532, 596 or 598) and bellcrank assembly (420 or 424).

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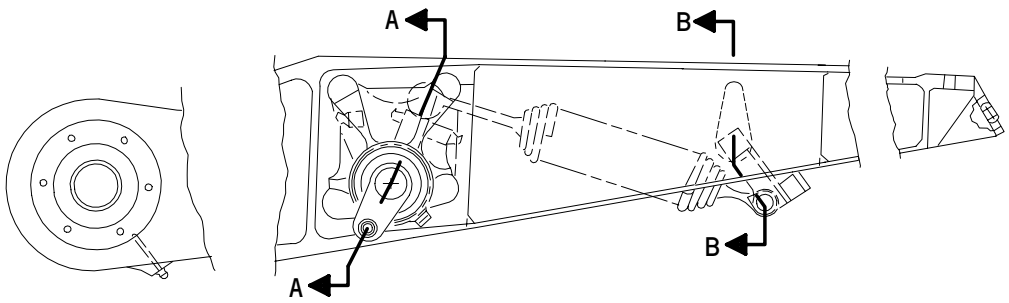

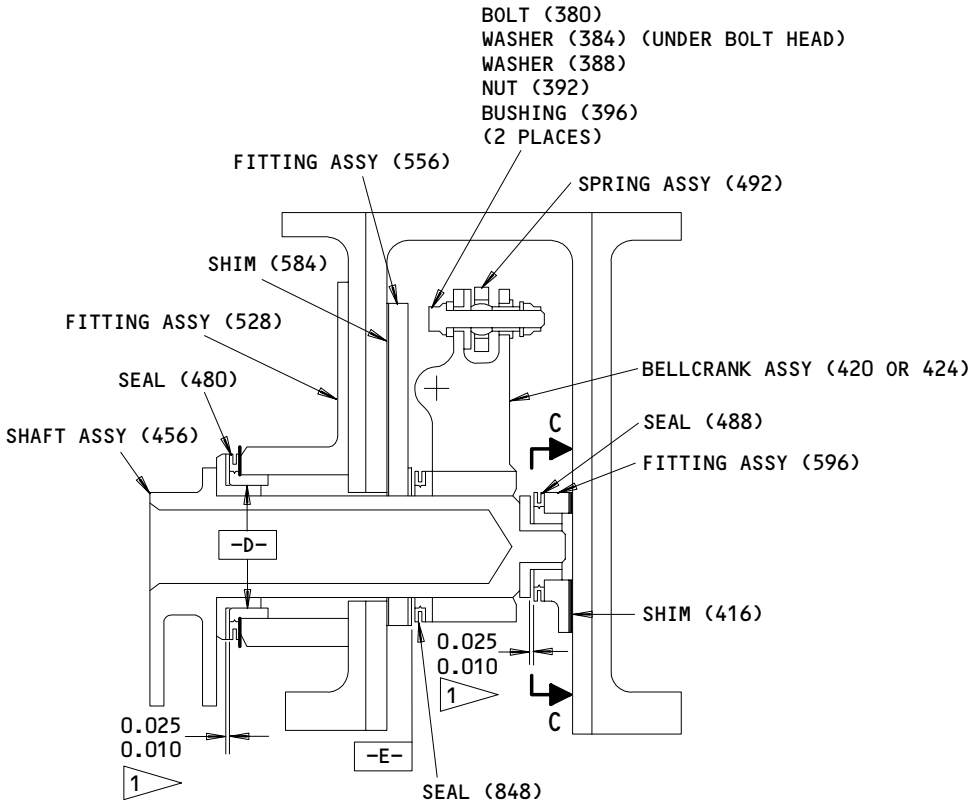

A-A

1 TOLERANCE WHEN GAP IS ZERO AT DATUM E

Beam Assembly Details
Figure 701 (Sheet 1)

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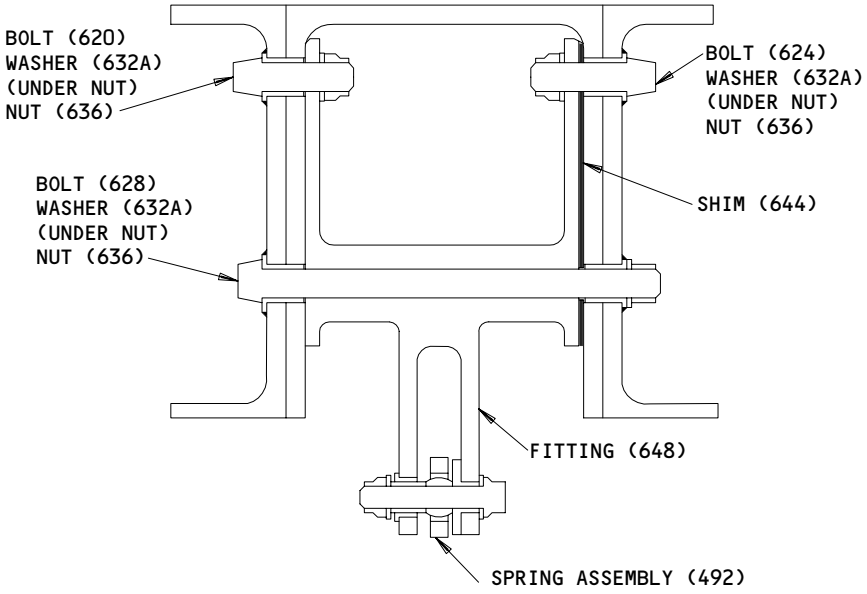
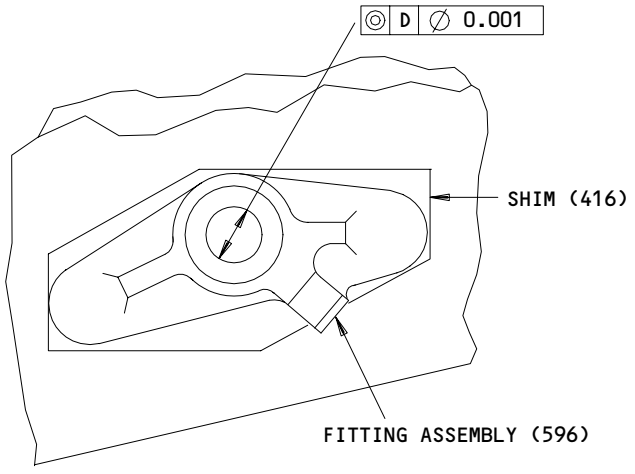


B–B



C–C

Beam Assembly Details
Figure 701 (Sheet 2)

169852

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(9) Apply one coat of primer to shims (584, 616). Position fitting assemblies (528 or 532, 556 or 558) and shim (584) on beam and secure with bolts (516, 520) and collars (524). Position fitting assembly (596 or 598) and shim (616) on beam and secure with bolts (588) and collars (592). Use care while installing parts to maintain concentricity requirement.

(10) Install spring assembly (492) on bellcrank assembly (420 or 424) and secure with parts (380 thru 396).

(11) Position bellcrank assembly (420 or 424) with attached spring assembly (492) between stops of fitting assembly (556 or 558) and install shaft assembly (456). Secure bellcrank assembly and shaft assembly with parts (408, 412, 416).

(12) Check gap per Fig. 701 and readjust shim (584, 616) if required.

(13) Position spring assembly (492) on fitting assembly (648) and secure with parts (380 thru 396).

(14) Position fitting assembly (648) and shim (644) in beam and check that maximum gap is 0.003 maximum. Adjust shim (644) thickness as required. Install bolt (628), washer (632) and nut (636).

(15) Insert a rod into the 0.62 inch diameter hole in fitting assembly (648) and apply force against the spring force to align bolt holes using bolt (628) as a hinge. Install bolts (620, 624), washers (632) and nuts (636).

B. Tighten nuts (20) to 800-1500 lb-in. Tighten nuts (32) to 2000-3000 lb-in.

C. Tighten nut (92) to 600-1000 lb-in. Tighten nut (104) to 1500-2000 lb-in.

D. Use washers (224) as required to obtain 0.005-0.025 inch gap between face of washer (228) and flange of bushing (252). Tighten nut (216) to 600-1000 lb-in. Tighten nut (232) to 1500-2000 lb-in.

E. Tighten nut (316) to 800-1500 lb-in. Tighten nut (328) to 3000-3700 lb-in.

F. Tighten nut (744) to 150-250 lb-in. Tighten nut (764) to 2000-3000 lb-in.

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G. Lockwire the following parts per 20-50-02:

(1) Nuts (32) to washers (28) (2 places)

(2) Nut (104) to washer (100) (2 places)

(3) Nut (232) to washer (228) (2 places)

(4) Nut (328) to washer (324) (2 places)

(5) Nut (764) to washer (760) (2 places)

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

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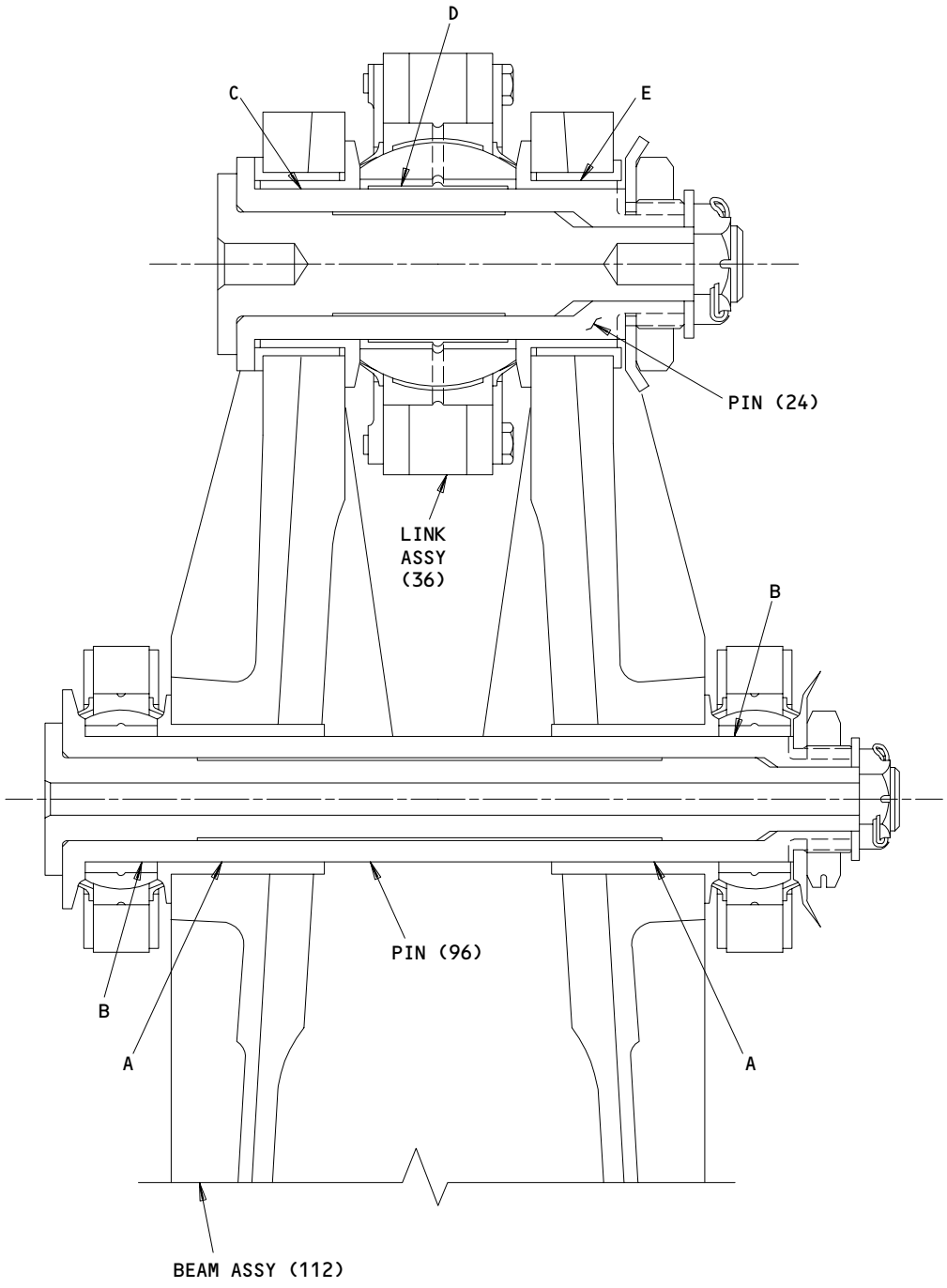
FITS AND CLEARANCES



Fits and Clearances
Figure 801 (Sheet 1)

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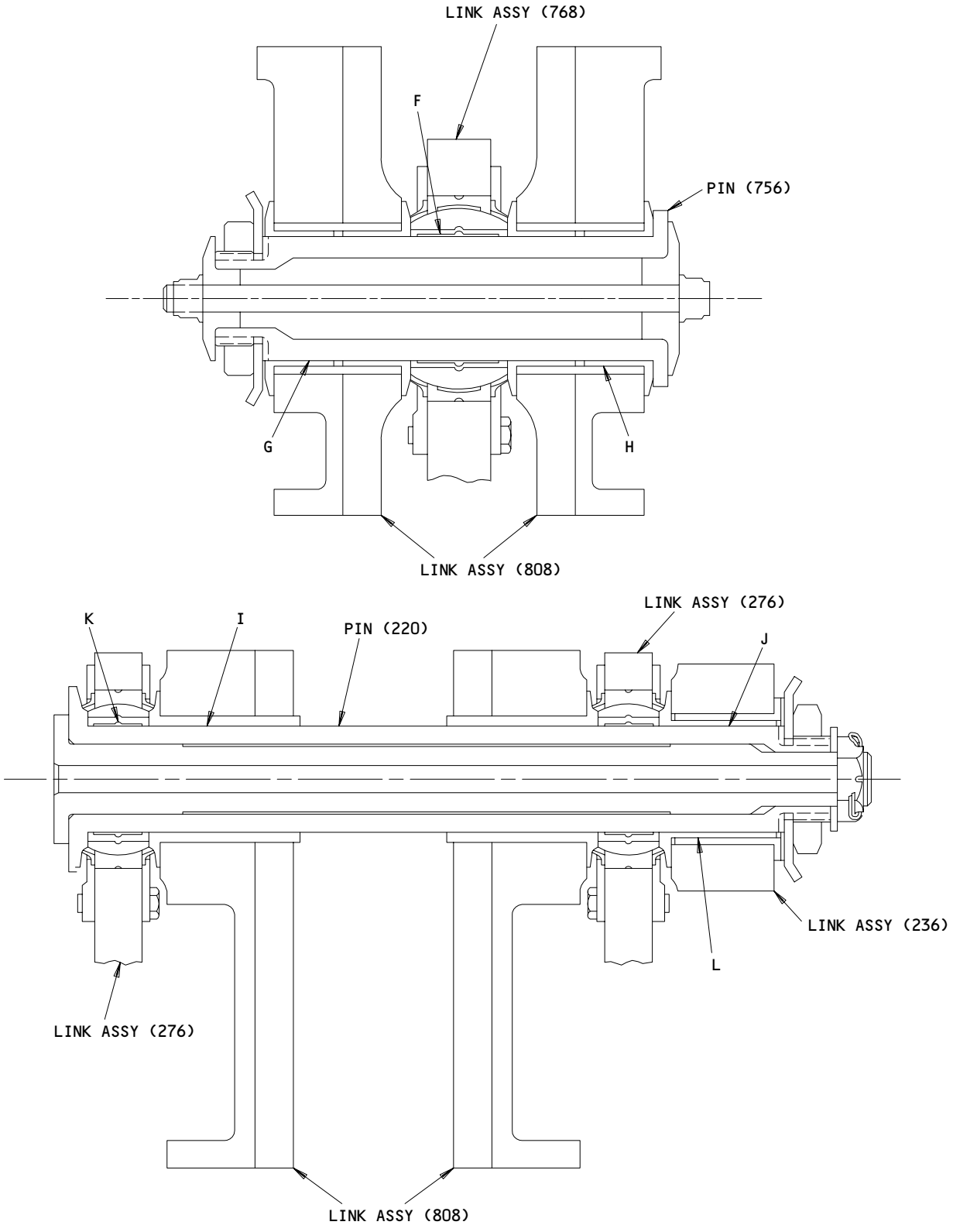

Fits and Clearances
Figure 801 (Sheet 2)

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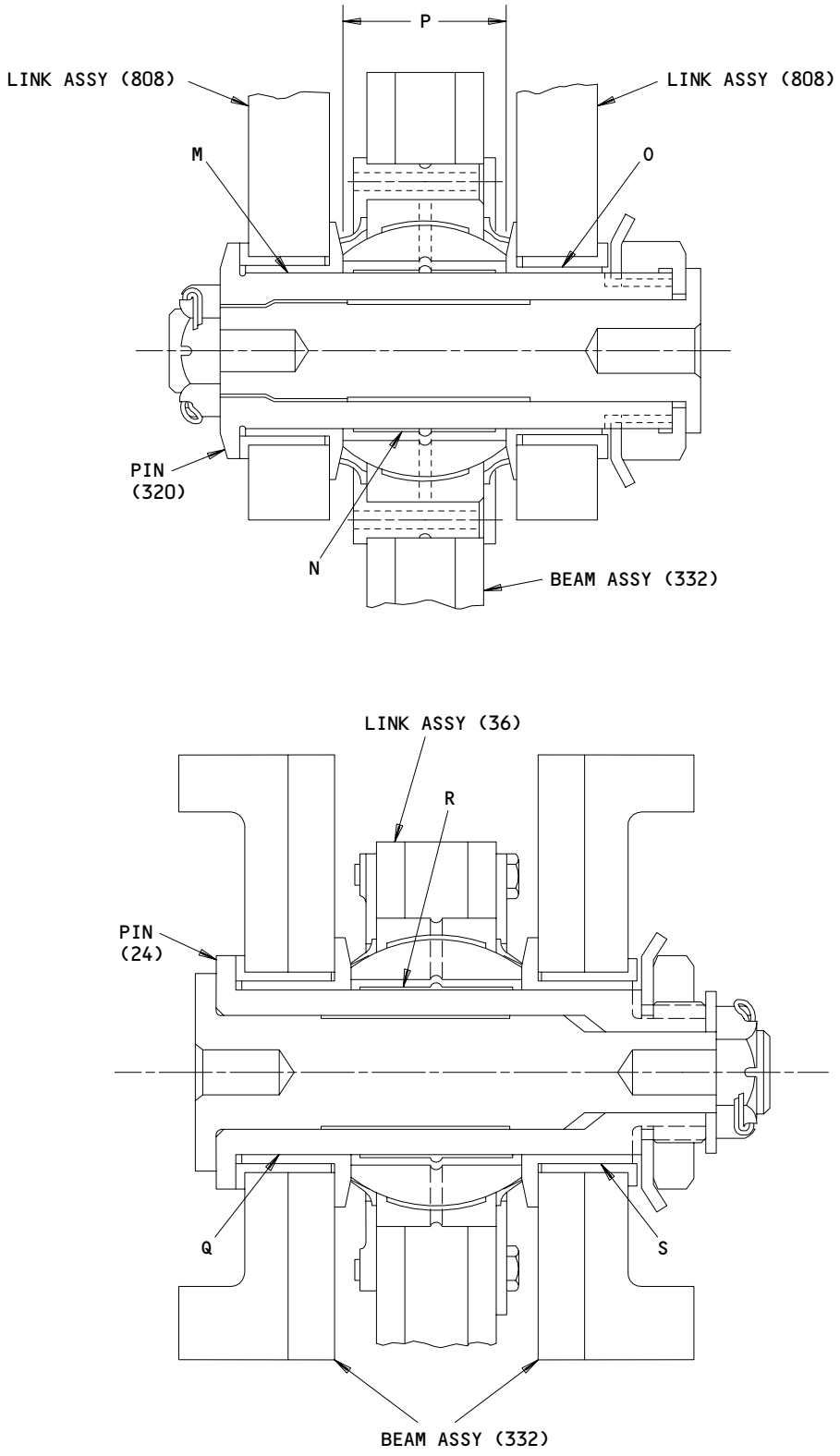

Fits and Clearances
Figure 801 (Sheet 3)

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Ref Letter Fig.801	Mating Item No. IPL Fig.1	Design Dimension				Service Wear Limit		
		Dimension		Assembly Clearance *[1]		Dimension		Maximum Clearance
		Min	Max	Min	Max	Min	Max	
	ID 116,120, 170 OD *[2]	1.6245 1.6234	1.6256 1.6240	0.0005	0.0022	1.6167	1.6329	0.0089
A	ID 128 OD 96	1.4995 1.4984	1.5006 1.4990	0.0005	0.0022	1.4922	1.5074	0.0084
B	ID 296 OD 96	1.5000 1.4984	1.5006 1.4990	0.0010	0.0022	1.4922	1.5074	0.0084
C	ID 132 OD 24	1.7496 1.7484	1.7506 1.7490	0.0006	0.0022	1.7411	1.7585	0.0095
D	ID 56 OD 24	1.7500 1.7484	1.7506 1.7490	0.0010	0.0022	1.7411	1.7585	0.0095
E	ID 136 OD 132	1.9229 1.9250	1.9238 1.9259	-0.0012	-0.0030			
F	ID 788 OD 756	1.7500 1.7484	1.7506 1.7490	0.0010	0.0022	1.7411	1.7585	0.0095
G	ID 820 OD 756	1.7495 1.7484	1.7506 1.7490	0.0005	0.0022	1.7411	1.7585	0.0095
H	ID 824 OD 820	1.9229 1.9250	1.9238 1.9259	-0.0012	-0.0030			
I	ID 828 OD 220	1.4995 1.4984	1.5006 1.4990	0.0005	0.0022	1.4906	1.5074	0.0084
J	ID 248 OD 220	1.4995 1.4984	1.5006 1.4990	0.0005	0.0022	1.4906	1.5074	0.0084
K	ID 296 OD 220	1.5000 1.4984	1.5006 1.4990	0.0010	0.0022	1.4906	1.5074	0.0084
L	ID 252 OD 248	1.6482 1.6500	1.6490 1.6509	-0.0010	-0.0027			
M	ID 812 OD 320	1.6245 1.6234	1.6256 1.6240	0.0005	0.0022	1.6167	1.6329	0.0089

ALL DIMENSIONS ARE IN INCHES

Fits and Clearances
Figure 801 (Sheet 4)

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Ref Letter Fig.801	Mating Item No. IPL Fig.1	Design Dimension				Service Wear Limit		
		Dimension		Assembly Clearance *[1]		Dimension		Maximum Clearance
		Min	Max	Min	Max	Min	Max	
N	ID 352 OD 320	1.6250 1.6234	1.6256 1.6240	0.0010	0.0022	1.6167	1.6329	0.0089
O	ID 816 OD 812	1.7856 1.7875	1.7865 1.7884	-0.0010	0.0022			
P	*[3]		1.8160				1.8460	
Q	ID 364 OD 24	1.7495 1.7484	1.7506 1.7490	0.0005	0.0022	1.7411	1.7585	0.0095
R	ID 56 OD 24	1.7500 1.7484	1.7506 1.7490	0.0010	0.0022	1.7411	1.7585	0.0095
S	ID 368 OD 364	1.9229 1.9250	1.9238 1.9259	-0.0012	-0.0030			
	ID 244 OD *[4]	0.5000 0.4990	0.5007 0.4995	0.0005	0.0017	0.4957	0.5045	0.0050
	ID 240 OD *[5]	0.6870 0.6860	0.6877 0.6865	0.0005	0.0017	0.6825	0.6917	0.0052

*[1] NEGATIVE VALUES DENOTE INTERFERENCE FIT
*[2] INSTALLATION PART 113T1263-1
*[3] DIMENSION BETWEEN FLANGE FACES OF BUSHINGS (812)
*[4] INSTALLATION PART BACB30LJ8U
*[5] BACB28AK08

ALL DIMENSIONS ARE IN INCHES

Fits and Clearances
Figure 801 (Sheet 5)

199501

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FOR TORQUE VALUES OF STANDARD FASTENERS, REFER TO 20-50-01		
Item No. IPL Fig. 1	Name	Torque Pound-Inches
20, 316	NUT	800-1500
32, 764	NUT	2000-3000
92, 216	NUT	600-1000
104, 232	NUT	1500-2000
328	NUT	3000-3700
744	NUT	150-250

Torque Table
Figure 802

169853

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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

S0352	NIPPON MINIATURE BEARING CO LTD TOKYO, JAPAN
0PTK6	SPS TECHNOLOGIES INC AEROSPACE PRODUCTS DIV 5195 W 4700 SPO BOX 18459 KEARNS, UTAH 84118
02758	NETWORKS ELECTRONIC CORP U S BEARING DIV 9750 DE SOTO AVENUE CHATSWORTH, CALIFORNIA 91311-4409 FORMERLY U S BEARING DIV NETWORKS ELEC CORP
06725	AIR INDUSTRIES CORPORATION 12570 KNOTT STREET GARDEN GROVE, CALIFORNIA 92641-3932 FORMERLY AIR INDUSTRIES OF CALIF IN GARDENA, CALIF.
08524	DEUTSCH FASTENER CORP SEE CODE V97928
15860	NEW HAMPSHIRE BALL BEARINGS, INCORPORATED ASTRO DIVISION 155 LEXINGTON AVENUE LACONIA, NEW HAMPSHIRE 03246-2937 FORMERLY ASTRO BEARING CORP, LOS ANGELES, CALIF.
16746	SPECLINE INCORPORATED 2230 MOUTON DR CARSON CITY, NV 89706 FORMERLY IN SUN VALLEY, CAIFORNIA
5M902	FAIRCHILD IND INC FAIRCHILD AEROSPACE FASTENER DIV 3016 W LOMITA BLVD TORRANCE, CALIFORNIA 90505-5103 FMLY IN REDONDO BEACH, CALIF
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 FORMERLY STANDARD PRESSED STEEL
60516	WEST COAST AEROSPACE INC 812 MIRAFLORES STREET SAN PEDRO, CALIFORNIA 90731-1439

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VENDORS

73134 IMO INDUSTRIES INC HEIM BEARINGS DIV
60 ROUND HILL ROAD PO BOX 430
FAIRFIELD, CONNECTICUT 06430
FORMERLY INCOM INTL INC HEIM DIV; FORMERLY HEIM UNIVERSAL CORP INCOM INTL INC; FORMERLY HEIM DIV INCOM INTL

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
FORMERLY NUTT-SHEL DIV OF SPC WESTERN CO V80539 AND STANDARD PRESSED STEEL WESTERN DIV V17279

81376 SOUTHWEST PRODUCTS COMPANY
2240 BUENA VISTA STREET
IRVINDALE, CALIFORNIA 91706
FORMERLY IN MONROVIA, CALIFORNIA 91016

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

976113 SARGENT CONTROLS & AEROSPACE/KAHR BEARING DIV
5675 W BURLINGAME RD
TUCSON, ARIZONA 85743
FORMERLY AETNA STEEL PROD KAHR BEARING DIV V96579
FORMERLY SARGENT IND KAHR BEARING DIV, BURBANK, CALIFORNIA

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
ADB04V301NC		1	496	2
ADW05V301NC		1	372	1
AN960C416		1	412	2
AN960JD516L		1	860A	2
		1	886A	2
AN960PD516L		1	860	2
		1	886	2
ASB24-101		1	296A	4
ASB26-103		1	352A	1
ASB28-101		1	788B	2
ASB28-102		1	56A	2
ASSB24-101		1	296A	4
ASSB28-18		1	788B	2
ASSB28-19		1	56A	2
BACB10FA05GC		1	372	1
BACB10FB04GC		1	496	2
BACB10JA28ABNJ01		1	56B	2
		1	56C	2
BACB28AK04-035		1	396	2
BACB28AK04-065		1	396A	2
BACB28AM04B038A		1	640	4
BACB28AM06B013A		1	428A	1
BACB28AM06B019A		1	428	1
		1	652	1
BACB28AM07B019A		1	460	1
BACB28AM11B040A		1	240	1
BACB28AP04P014		1	656B	1
BACB28AP04P015		1	432B	1
BACB28AP08P040		1	244	1
BACB28AT04B038C		1	640A	4
BACB28AT06B014C		1	652B	1
BACB28AT06B015C		1	428C	1
BACB28AT11B040C		1	240A	1
BACB30FM8A12		1	564	1
BACB30FM8A15		1	444	1
BACB30FM8A7		1	560	1
BACB30LE4-10		1	620	1
BACB30LE4-11		1	624	1

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACB30LE4-16		1	380	2
BACB30LE4-60		1	628	1
BACB30LE6-111		1	740A	1
BACB30LH3P20		1	340A	6
BACB30LH4-38		1	408	2
BACB30LJ4HSU15		1	776	6
BACB30LJ4HSU20		1	44	6
BACB30LJ4H10		1	284	12
BACB30LJ5-14		1	852	2
		1	885	2
BACB30LR3P20		1	340	6
BACB30MR6K111		1	740	1
BACB30MY10K10		1	840	6
		1	872	6
BACB30MY10K12		1	696	2
		1	844	2
		1	876	2
BACB30MY10K14		1	700	2
		1	848	8
		1	880	8
BACB30MY10K16		1	704	4
BACB30MY10K6		1	152	12
BACB30MY10K7		1	156	16
BACB30MY10K9		1	160	8
BACB30MY12K11		1	168	4
BACB30MY12K14		1	172	8
BACB30MY12K16		1	176	4
BACB30MY12K21		1	712	3
BACB30MY14K16		1	184	4
BACB30MY14K47		1	720	2
BACB30MY14K48		1	720A	2
BACB30MY8K13		1	588	2
BACB30MY8K15		1	520	1
BACB30MY8K16		1	64	5
BACB30MY8K21		1	516A	3
BACB30MY8K4		1	680	12
BACB30MY8K6		1	664	4
BACB30MY8K7		1	684	18
BACB30MY8K8		1	796	6
BACB30NW8K7		1	688	2
BACB30VT8K12		1	564A	1
BACB30VT8K7		1	560A	1

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACC30AB8S		1	68	5
BACC30BL8		1	568A	2
BACC30M10		1	164	36
		1	708	8
		1	856	16
		1	884	16
BACC30M12		1	180	16
		1	716	3
BACC30M14		1	188	4
		1	724	2
BACC30M8		1	448	1
		1	524	4
		1	568	2
BACC30M8		1	592	2
		1	672	4
		1	692	32
		1	800	6
BACN10JC4CM		1	416	2
BACN10JC5		1	864	2
		1	887	2
BACN10JD112AU		1	92	1
		1	216	1
BACN10JD114AU		1	20	2
		1	316	1
BACR15BA5AD		1	436	2
		1	576	2
BACR15BB8D8		1	866	1
BACS40R011C020F		1	668A	2
BACS40R11C20F		1	668	2
BACW10BP4C		1	384	2
BACW10BP4P		1	388	2
		1	632	3
BLP28F237		1	352A	1
BLP28F240		1	788B	2
B30MY10K10		1	840	6
		1	872	6
B30MY10K12		1	696	2
		1	844	2
		1	876	2
B30MY10K14		1	700	2
		1	848	8
		1	880	8
B30MY10K16		1	704	4
B30MY10K6		1	152	12
B30MY10K7		1	156	16
B30MY10K9		1	160	8
B30MY12K11		1	168	4

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
B30MY12K14		1	172	8
B30MY12K16		1	176	4
B30MY14K16		1	184	4
B30MY14K47		1	720	2
B30MY8K13		1	588	2
B30MY8K15		1	520	1
B30MY8K16		1	64	5
B30MY8K4		1	680	12
B30MY8K6		1	664	4
B30MY8K7		1	684	18
B30MY8K8		1	796	6
B30NW8K7		1	688	2
HL10VAZ10-10		1	840	6
		1	872	6
HL10VAZ10-12		1	696	2
		1	844	2
		1	876	2
HL10VAZ10-14		1	700	2
		1	848	8
		1	880	8
HL10VAZ10-16		1	704	4
HL10VAZ10-6		1	152	12
HL10VAZ10-7		1	156	16
HL10VAZ10-9		1	160	8
HL10VAZ12-11		1	168	4
HL10VAZ12-14		1	172	8
HL10VAZ12-16		1	176	4
HL10VAZ12-21		1	712	3
HL10VAZ14-16		1	184	4
HL10VAZ14-47		1	720	2
HL10VAZ14-48		1	720A	2
HL10VAZ8-13		1	588	2

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
HL10VAZ8-15		1	520	1
HL10VAZ8-16		1	64	5
HL10VAZ8-21		1	516A	3
HL10VAZ8-4		1	680	12
HL10VAZ8-6		1	664	4
HL10VAZ8-7		1	684	18
HL10VAZ8-8		1	796	6
HL11VAZ8-7		1	688	2
HL440UC8-12		1	564	1
HL440UC8-15		1	444	1
HL440UC8-7		1	560	1
HL79-10		1	164	36
		1	708	8
		1	856	16
		1	884	16
HL79-12		1	180	16
		1	716	3
HL79-14		1	188	4
		1	724	2
HL79-8		1	448	1
		1	524	4
		1	568	2
		1	592	2
		1	672	4
		1	692	32
		1	800	6
HL97DU8		1	68	5
HSP26-108		1	352A	1
HST10AG8-12		1	564A	1
HST10AG8-7		1	560A	1
HST79-8		1	568A	2

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
HST79CY8		1	568A	2
HTFB04GC		1	496	2
KNDB04-70		1	496	2
KSC14570OBZ04GC		1	496	2
KSC15220OBZ05GC		1	372	1
KWDB05-35		1	372	1
LHCB24BA		1	296A	4
LHCB26BAD		1	352A	1
LHCB28BA		1	788B	2
LHCB28BAD		1	56A	2
L803-8K7		1	688	2
MS15001-1		1	144	1
		1	268	1
		1	376	1
		1	536	1
		1	600	1
		1	792	2
		1	836	1
MS15001-3		1	148	2
MS15004-1		1	60	2
		1	300	4
MS21042L5		1	864A	2
		1	887A	2
MS24665-376		1	8	2
		1	80	1
		1	204	1
		1	308	1
NAS1804-4		1	392	2
		1	636	3
NAS1805-4L		1	392A	2
		1	636A	3
NAS1805-6		1	744A	1
NES04FBGC		1	496	2
SWKRS05-350SC		1	372	1
WC130-8-12		1	564	1
WC130-8-15		1	444	1

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
WC130-8-7		1	560	1
WES05FAGC		1	372	1
WHTFA05VC		1	372	1
113T1009-1		1	528A	1
113T1009-10		1	532C	1
113T1009-2		1	532A	1
113T1009-3		1	548A	1
113T1009-4		1	552A	1
113T1009-7		1	548C	1
113T1009-8		1	552C	1
113T1009-9		1	528C	1
113T1105-9		1	224	1
113T1221-11		1	888A	1
113T1221-12		1	896A	1
113T1221-13		1	808A	1
113T1221-14		1	808	1
113T1221-16		1	868A	1
113T1221-18		1	868	1
113T1221-19		1	868B	1
113T1221-2		1	892	1
113T1221-20		1	808C	1
113T1221-21		1	888E	1
113T1221-22		1	896E	1
113T1221-23		1	892A	1
113T1221-24		1	868C	1
113T1221-25		1	808D	1
113T1221-26		1	868D	1
113T1221-27		1	808E	1
113T1221-28		1	868E	1
113T1221-29		1	808F	1
113T1221-30		1	868H	1
113T1221-31		1	808G	1
113T1221-32		1	868G	1
113T1221-33		1	808J	1
113T1221-34		1	892B	1
113T1221-35		1	892C	1
113T1221-39		1	808M	1
113T1221-40		1	868J	1
113T1221-41		1	808N	1
113T1221-42		1	868K	1
113T1222-1		1	112	1
113T1222-11		1	112C	1
113T1222-2		1	200	1
113T1222-3		1	192	1
113T1222-4		1	196	1

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
113T1222-7		1	192B	1
113T1222-8		1	196B	1
113T1222-9		1	112A	1
113T1223-1		1	36	1
		1	36A	1
113T1223-2		1	76	1
113T1223-3		1	72	2
113T1223-47		1	36B	1
113T1224-1		1	768	1
113T1224-2		1	804	2
113T1225-1		1	276	2
113T1225-2		1	304	2
113T1226-10		1	584	1
113T1226-15		1	644	1
113T1226-2		1	736	1
113T1226-21		1	728	1
113T1226-22		1	732	1
113T1226-29		1	676	1
113T1226-30		1	662	1
113T1226-31		1	332B	1
113T1226-32		1	334	1
113T1226-33		1	332D	1
113T1226-34		1	334A	1
113T1226-35		1	332F	1
113T1226-36		1	334B	1
113T1226-43		1	332H	1
113T1226-44		1	334C	1
113T1226-59		1	332K	1
113T1226-60		1	334D	1
113T1226-9		1	616	1
113T1229-1		1	236	1
113T1229-10		1	238A	1
113T1229-11		1	272B	1
113T1229-12		1	274A	1
113T1229-13		1	236D	1
113T1229-14		1	238B	1
113T1229-15		1	272E	1
113T1229-16		1	274B	1
113T1229-2		1	238	1

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
113T1229-3		1	272	1
113T1229-4		1	274	1
113T1229-9		1	236B	1
113T1254-11		1	16	6
		1	314	3
113T1254-13		1	88	3
		1	212	3
113T1254-3		1	228	1
113T1254-4		1	28	2
113T1254-46		1	760	1
113T1254-6		1	324	1
113T1254-9		1	100	1
113T1256-20		1	772	4
113T1256-21		1	336	2
113T1256-22		1	280	8
113T1256-25		1	40	4
113T1256-27		1	108	6
113T1256-40		1	480	1
113T1256-41		1	484	1
113T1256-42		1	488	1
113T1256-49		1	108A	6
113T1256-53		1	480A	1
113T1256-54		1	484A	1
113T1256-55		1	488A	1
113T1258-1		1	748	1
113T1258-2		1	752	1
113T1262-3		1	104	1
		1	232	1
113T1262-4		1	32	2
		1	764	1
113T1262-6		1	328	1
113T1263-2		1	96	1
113T1263-5		1	756	1
113T1263-6		1	220	1
113T1263-7		1	320	1

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
113T1263-8		1	24	2
113T1264-2		1	84A	1
113T1264-3		1	208A	1
113T1264-37		1	84	1
113T1264-38		1	208	1
113T1264-41		1	12	2
113T1264-42		1	312	1
113T1264-6		1	12A	2
113T1264-7		1	312A	1
113T1267-1		1	48A	2
113T1267-15		1	52	2
113T1267-16		1	48	2
113T1267-17		1	288	4
113T1267-18		1	292	4
113T1267-19		1	784	2
113T1267-2		1	52A	2
113T1267-20		1	780	2
113T1267-21		1	52B	2
113T1267-22		1	48B	2
113T1267-23		1	288B	4
113T1267-24		1	292B	4
113T1267-25		1	784B	2
113T1267-26		1	780B	2
113T1267-3		1	288A	4
113T1267-4		1	292A	4
113T1267-5		1	780A	2
113T1267-6		1	784A	2
113T1267-7		1	344	1
113T1267-8		1	348	1
113T1347-111		1	816A	2
113T1347-112		1	832A	2
113T1347-40		1	116	2
113T1347-41		1	140	2
113T1347-42		1	128	2
113T1347-43		1	132	2
		1	364	2

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
113T1347-44		1	136	2
		1	368	2
113T1347-45		1	832	2
113T1347-46		1	820	4
113T1347-47		1	824	2
113T1347-48		1	828	2
113T1347-49		1	812	2
113T1347-50		1	816	2
113T1347-55		1	120	2
113T1347-58		1	356	2
113T1347-59		1	360	2
113T1347-63		1	264	1
113T1347-64		1	124	2
113T1347-68		1	248	1
113T1347-69		1	252	1
113T1347-70		1	256	1
113T1347-72		1	260	1
113T1347-79		1	432A	1
		1	656	1
113T1347-80		1	464A	1
113T1347-81		1	468	1
113T1347-82		1	472	1
113T1347-83		1	540	1
113T1347-84		1	604	1
113T1347-85		1	544	1
113T1347-86		1	608	1
113T1397-1		1	452A	1
113T1397-3		1	452C	1
113T1447-10		1	896D	1
113T1447-13		1	888F	1
113T1447-14		1	896F	1
113T1447-15		1	888G	1
113T1447-16		1	896G	1
113T1447-5		1	888	1
113T1447-6		1	896	1
113T1447-7		1	888B	1
		1	896H	1
113T1447-8		1	896B	1
113T1447-9		1	888D	1
113T1586-1		1	556C	1
113T1586-2		1	558B	1
113T1586-3		1	580C	1
113T1586-4		1	582A	1
113T1716-1		1	504	1
113T1716-2		1	508	1

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
113T1719-1		1	596	1
113T1719-2		1	598	1
113T1719-3		1	612	1
113T1719-4		1	614	1
113T1726-1		1	556	1
113T1726-2		1	558	1
113T1726-3		1	580	1
113T1726-4		1	582	1
113T1726-5		1	572	1
113T1731-1		1	492	1
113T1731-2		1	500	1
113T1731-3		1	512	1
113T1731-5		1	513	1
113T1731-6		1	515	1
113T1731-7		1	514	2
113T1737-1		1	400	1
113T1737-10		1	404A	1
113T1737-11		1	456A	1
113T1737-12		1	476A	1
113T1737-13		1	420A	1
113T1737-14		1	424A	1
113T1737-15		1	420D	1
113T1737-16		1	424D	1
113T1737-17		1	452B	1
113T1737-19		1	400B	1
113T1737-2		1	404	1
113T1737-20		1	404B	1
113T1737-3		1	456	1
113T1737-4		1	476	1
113T1737-5		1	420	1
113T1737-6		1	424	1
113T1737-7		1	452	1
113T1737-8		1	440	1
113T1737-9		1	400A	1
113T1738-1		1	648	1

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
113T1738-2		1	660	1
113T1739-1		1	528	1
113T1739-2		1	532	1
113T1739-3		1	548	1
113T1739-4		1	552	1
113T1739-5		1	548B	1
113T1739-6		1	552B	1
113T1739-7		1	528B	1
113T1739-8		1	532B	1
113T1743-1		1	648A	1
113T1743-2		1	660A	1
113T1743-5		1	648B	1
113T1789-1		1	596C	1
113T1789-2		1	598B	1
113T1789-3		1	612B	1
113T1789-4		1	314A	1
		1	614A	1
113T2000-100		1	4F	RF
113T2000-131		1	1G	RF
113T2000-132		1	4G	RF
113T2000-133		1	1H	RF
113T2000-134		1	4H	RF
113T2000-137		1	1J	RF
113T2000-138		1	4J	RF
113T2000-151		1	1K	RF
113T2000-152		1	4K	RF
113T2000-153		1	1L	RF
113T2000-154		1	4L	RF
113T2000-155		1	1M	RF
113T2000-156		1	4M	RF
113T2000-195		1	1N	RF
113T2000-196		1	4N	RF
113T2000-203		1	1P	RF
113T2000-204		1	4P	RF
113T2000-205		1	1Q	RF

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
113T2000-206		1	4Q	RF
113T2000-239		1	1R	RF
113T2000-240		1	4R	RF
113T2000-241		1	1S	RF
113T2000-242		1	4S	RF
113T2000-295		1	1T	RF
113T2000-296		1	4T	RF
113T2000-297		1	1U	RF
113T2000-298		1	4U	RF
113T2000-67		1	1B	RF
113T2000-68		1	4B	RF
113T2000-73		1	1C	RF
113T2000-74		1	4C	RF
113T2000-75		1	1D	RF
113T2000-76		1	4D	RF
113T2000-85		1	1E	RF
113T2000-86		1	4E	RF
113T2000-99		1	1F	RF
113T2066-1		1	236F	1
113T2066-10		1	274D	1
113T2066-11		1	236L	1
113T2066-12		1	238F	1
113T2066-2		1	238C	1
113T2066-3		1	272F	1
113T2066-4		1	274C	1
113T2066-9		1	272H	1
60B00180-230		1	296A	4
60B00180-237		1	352A	1
60B00180-240		1	788B	2
60B00180-241		1	56A	2
66014-10		1	164	36
		1	708	8
		1	856	16
		1	884	16
66014-12		1	180	16
		1	716	3
66014-14		1	188	4
		1	724	2
66014-8		1	448	1
		1	524	4
		1	568	2

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
66014-8		1	592	2
		1	672	4
		1	692	32
		1	800	6
67067-8A12		1	564	1
67067-8A15		1	444	1
67067-8A7		1	560	1

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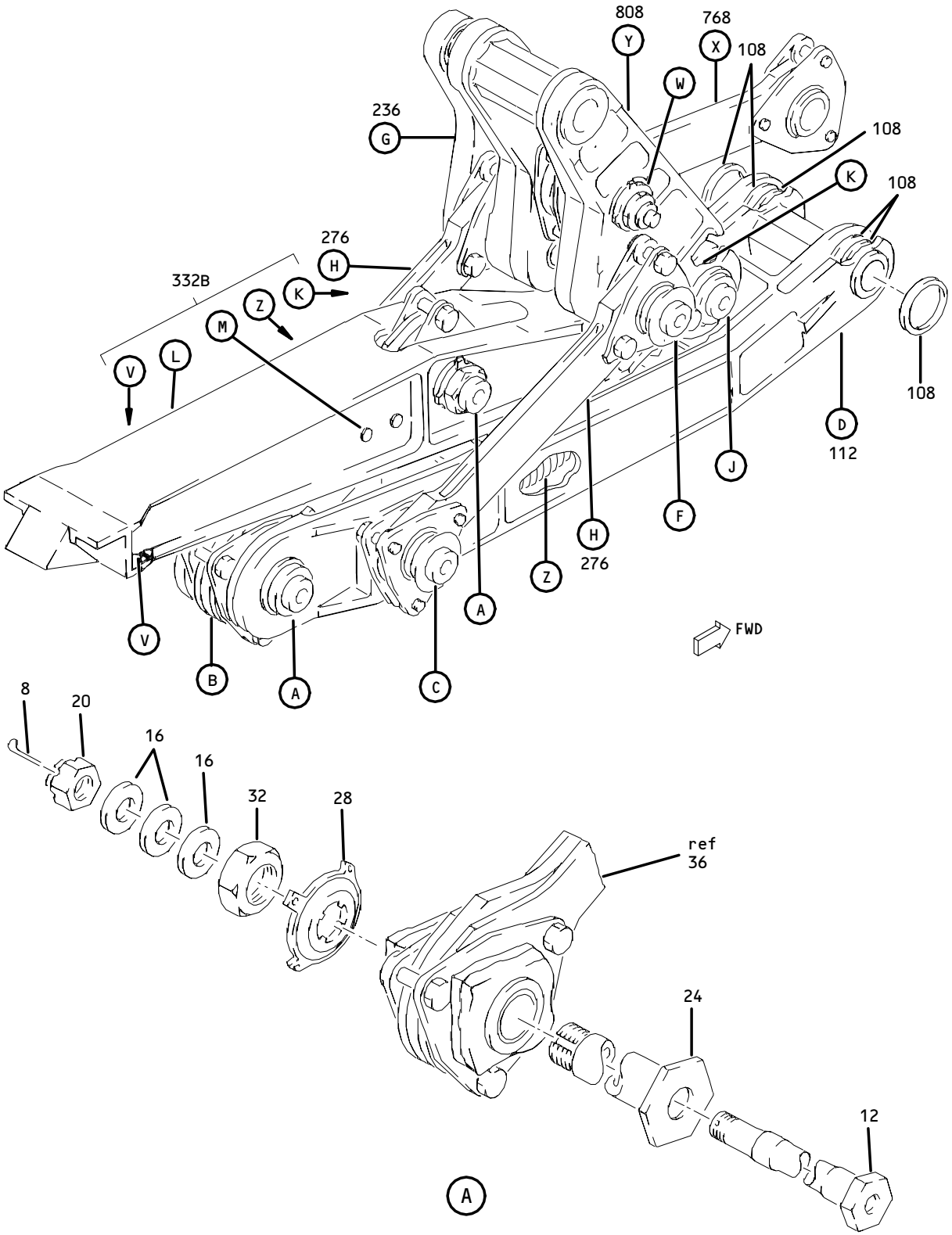

Inboard Trailing Edge Flap Linkage Assembly
Figure 1 (Sheet 1)

T99410

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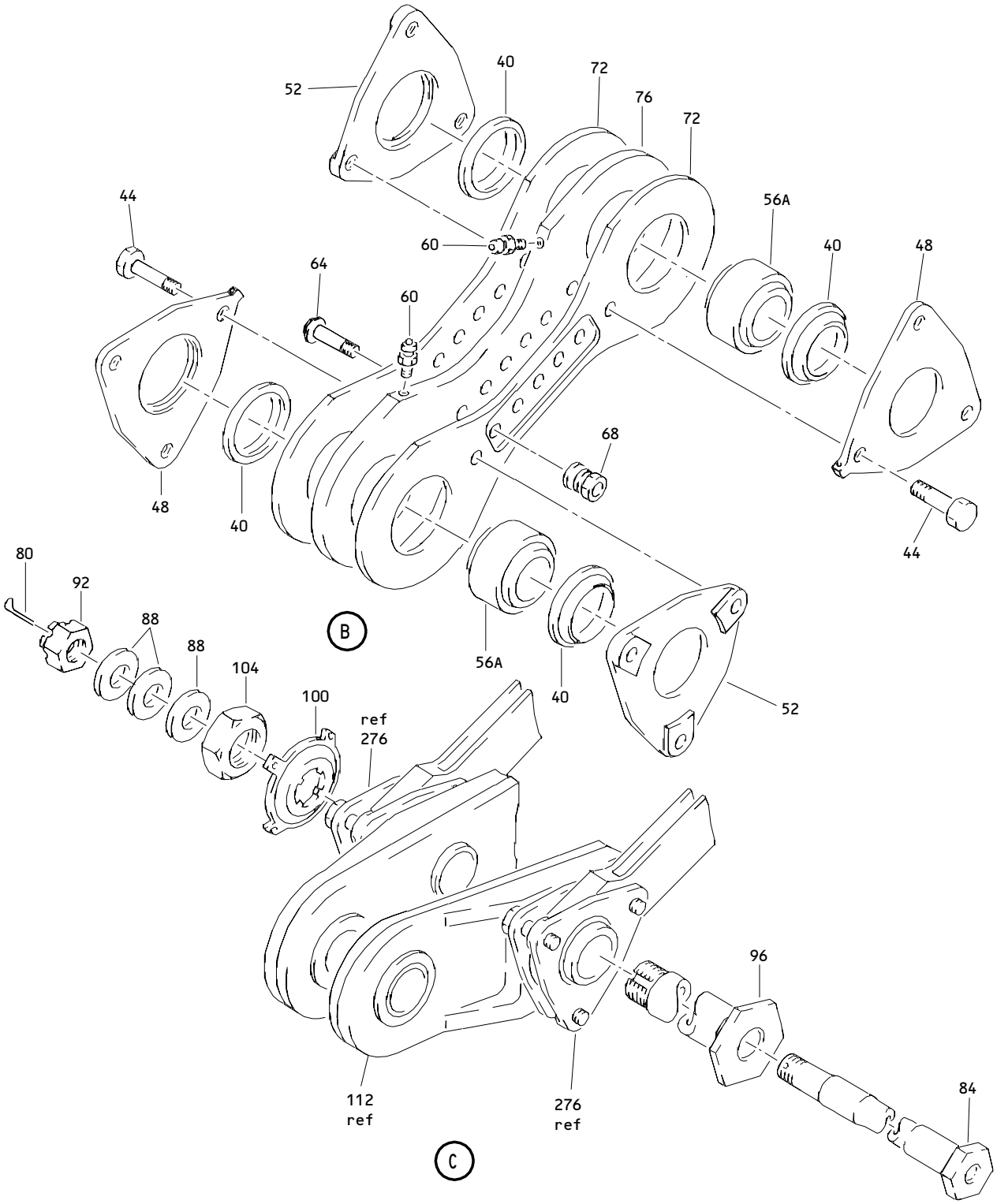

Inboard Trailing Edge Flap Linkage Assembly
Figure 1 (Sheet 2)

T99411

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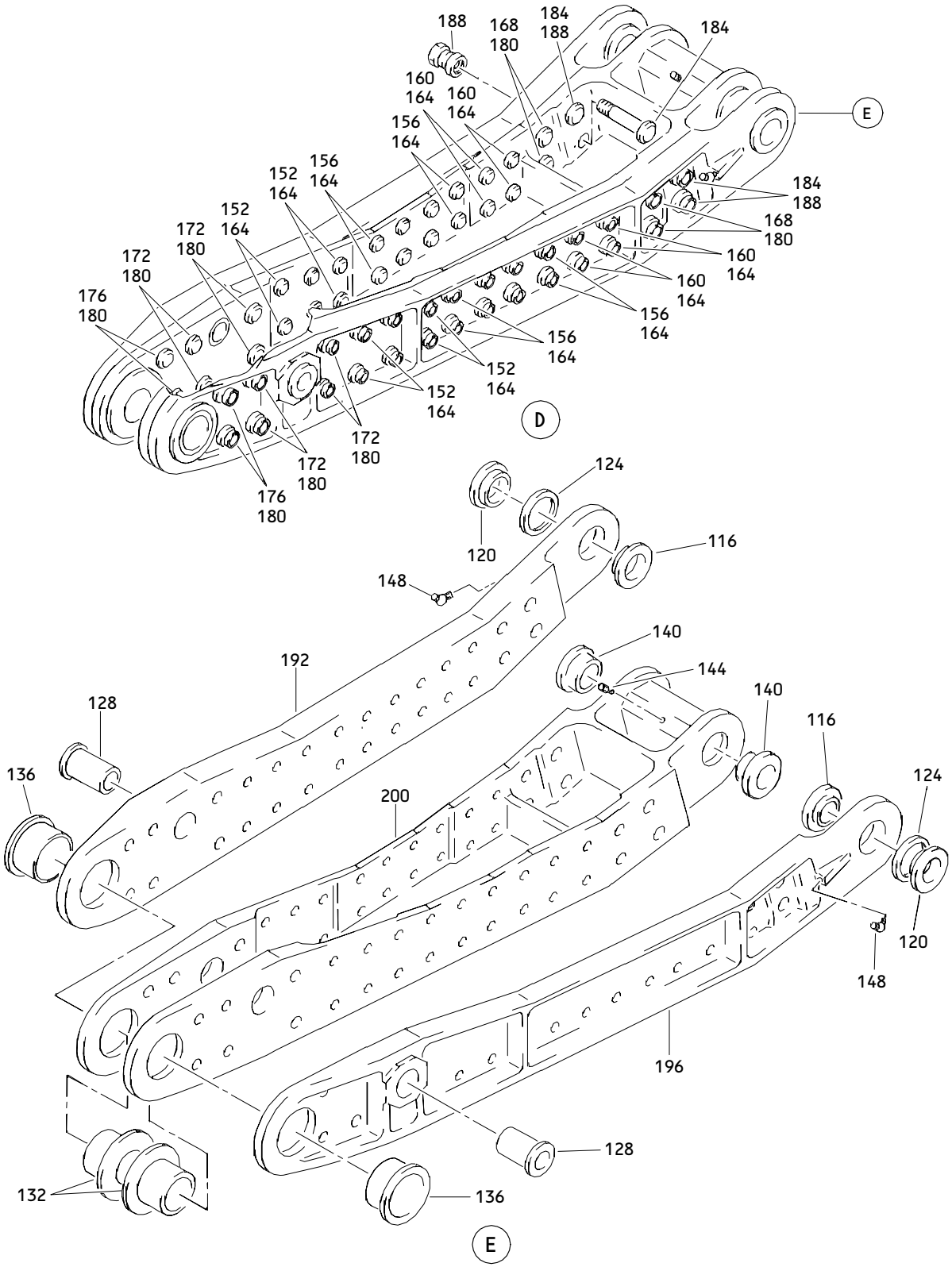

Inboard Trailing Edge Flap Linkage Assembly
Figure 1 (Sheet 3)

T99412

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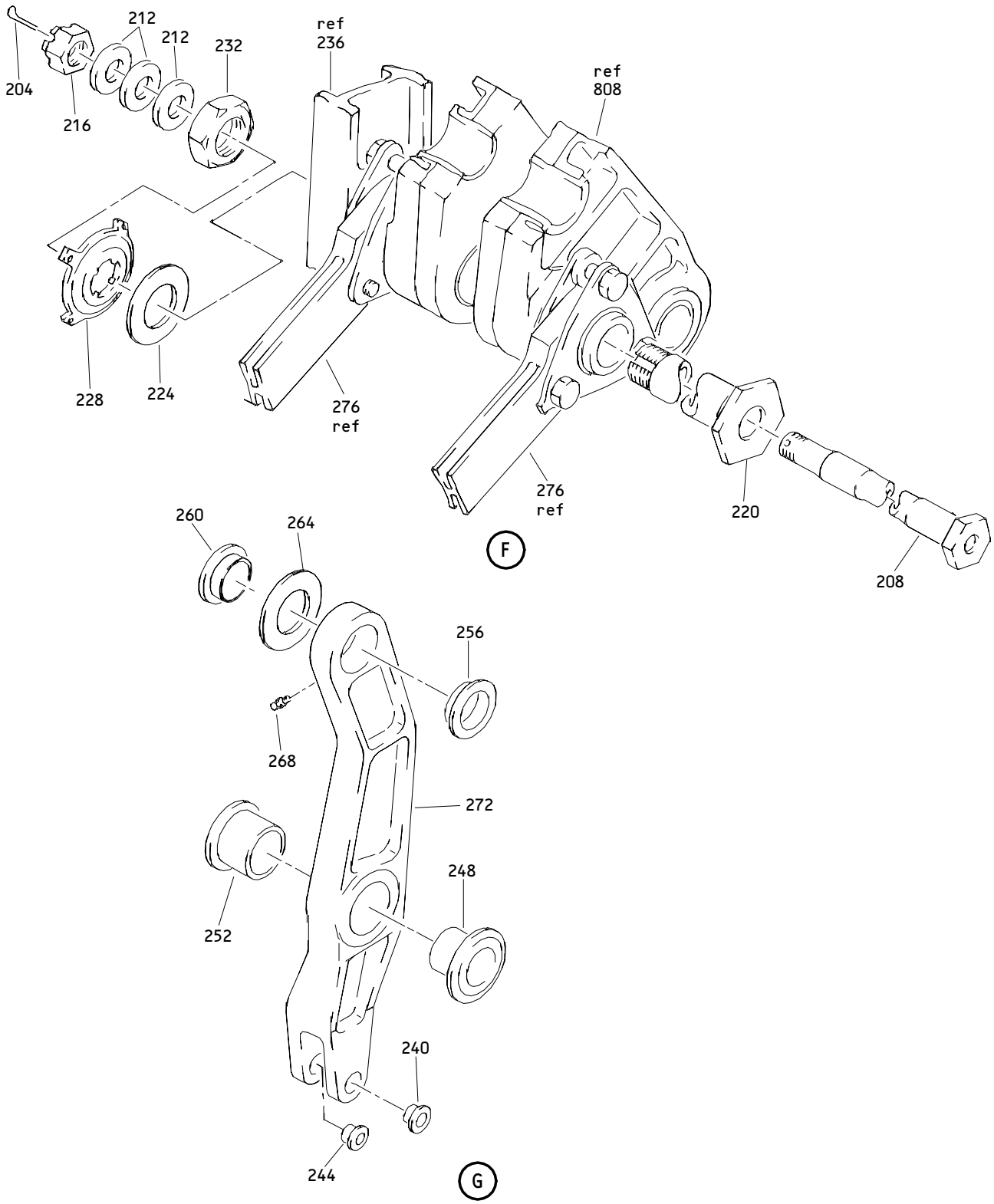

Inboard Trailing Edge Flap Linkage Assembly
Figure 1 (Sheet 4)

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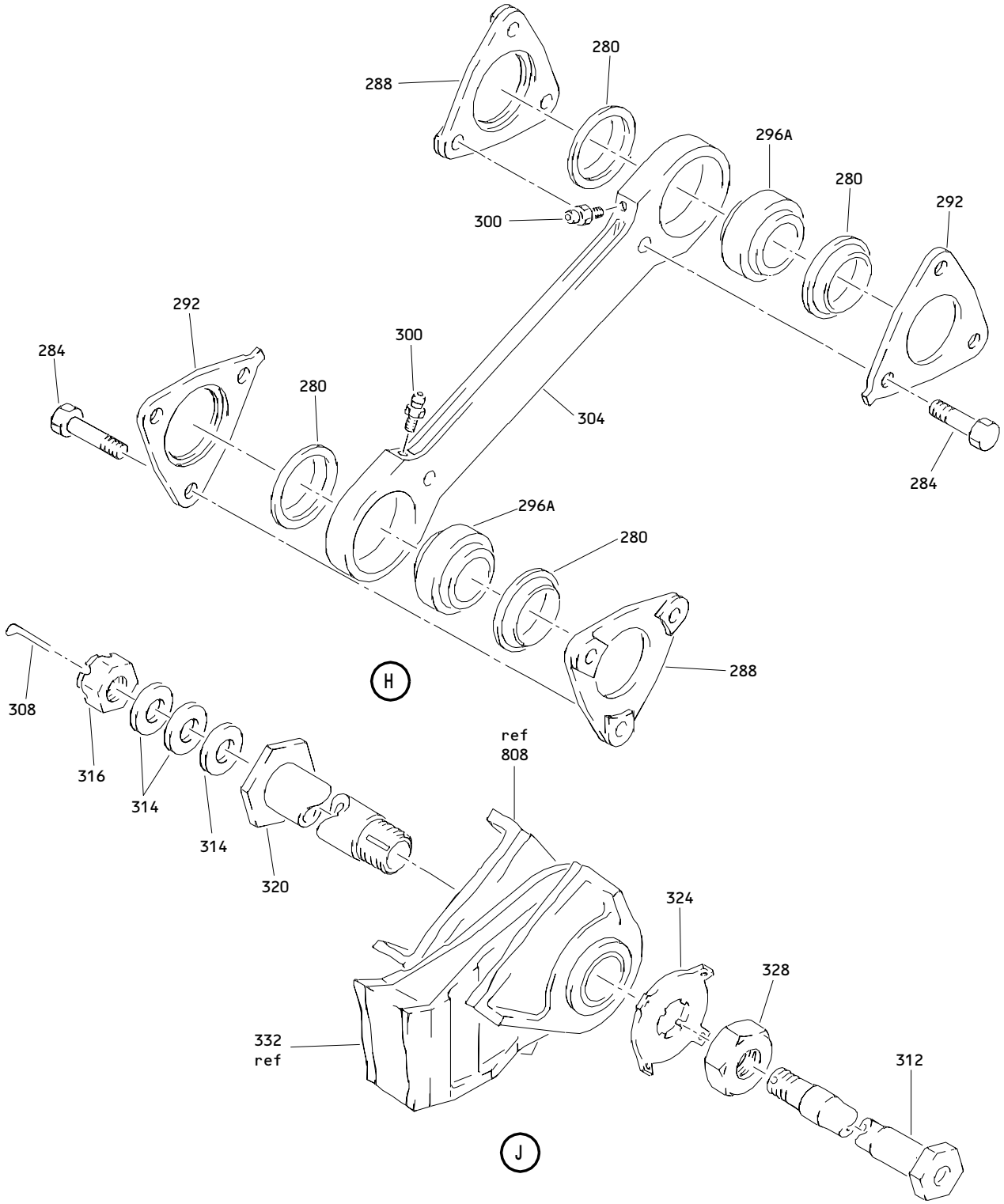

Inboard Trailing Edge Flap Linkage Assembly
Figure 1 (Sheet 5)

T99414

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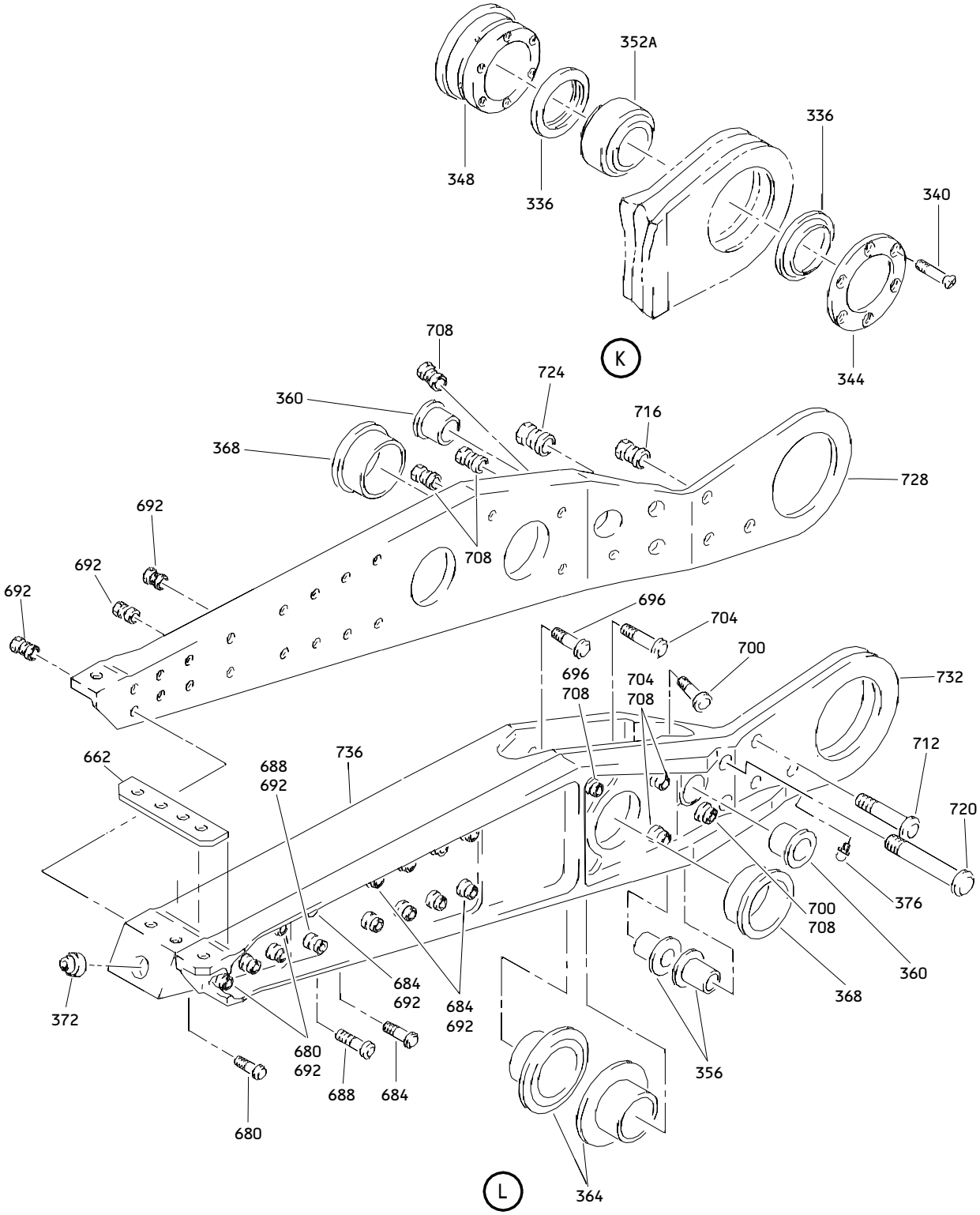

Inboard Trailing Edge Flap Linkage Assembly
Figure 1 (Sheet 6)

T99415

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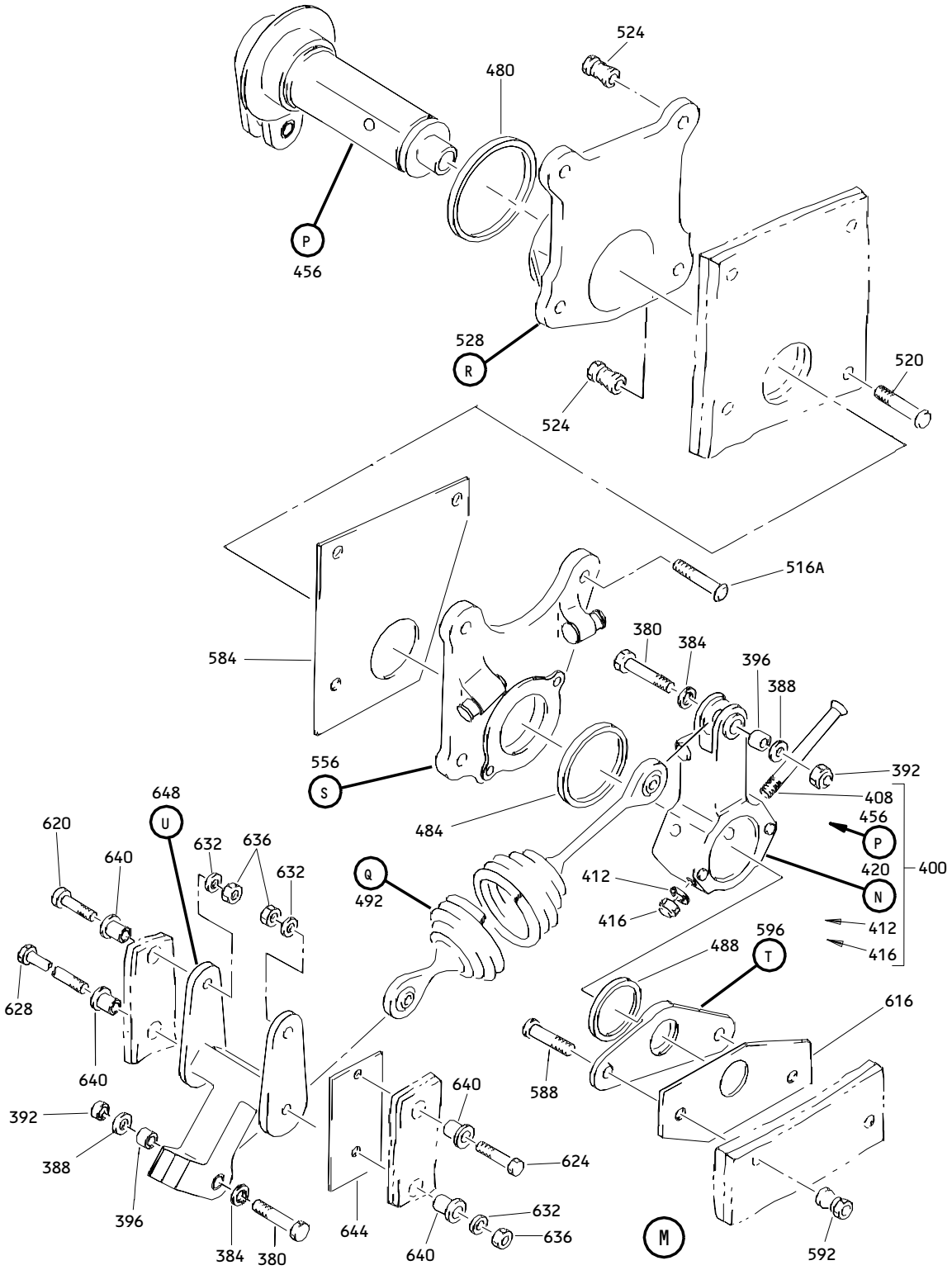

Inboard Trailing Edge Flap Linkage Assembly
Figure 1 (Sheet 7)

T99416

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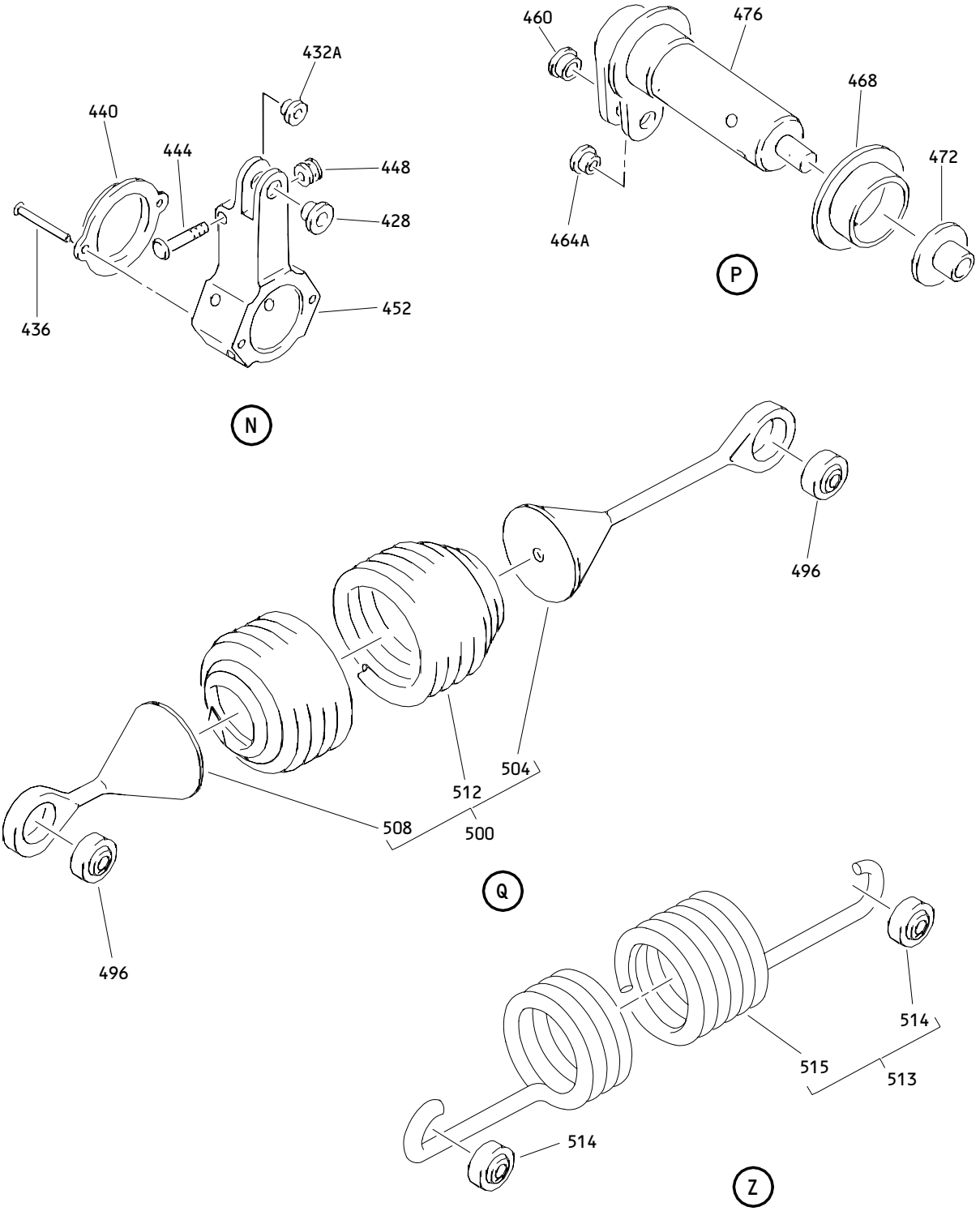

Inboard Trailing Edge Flap Linkage Assembly
Figure 1 (Sheet 8)

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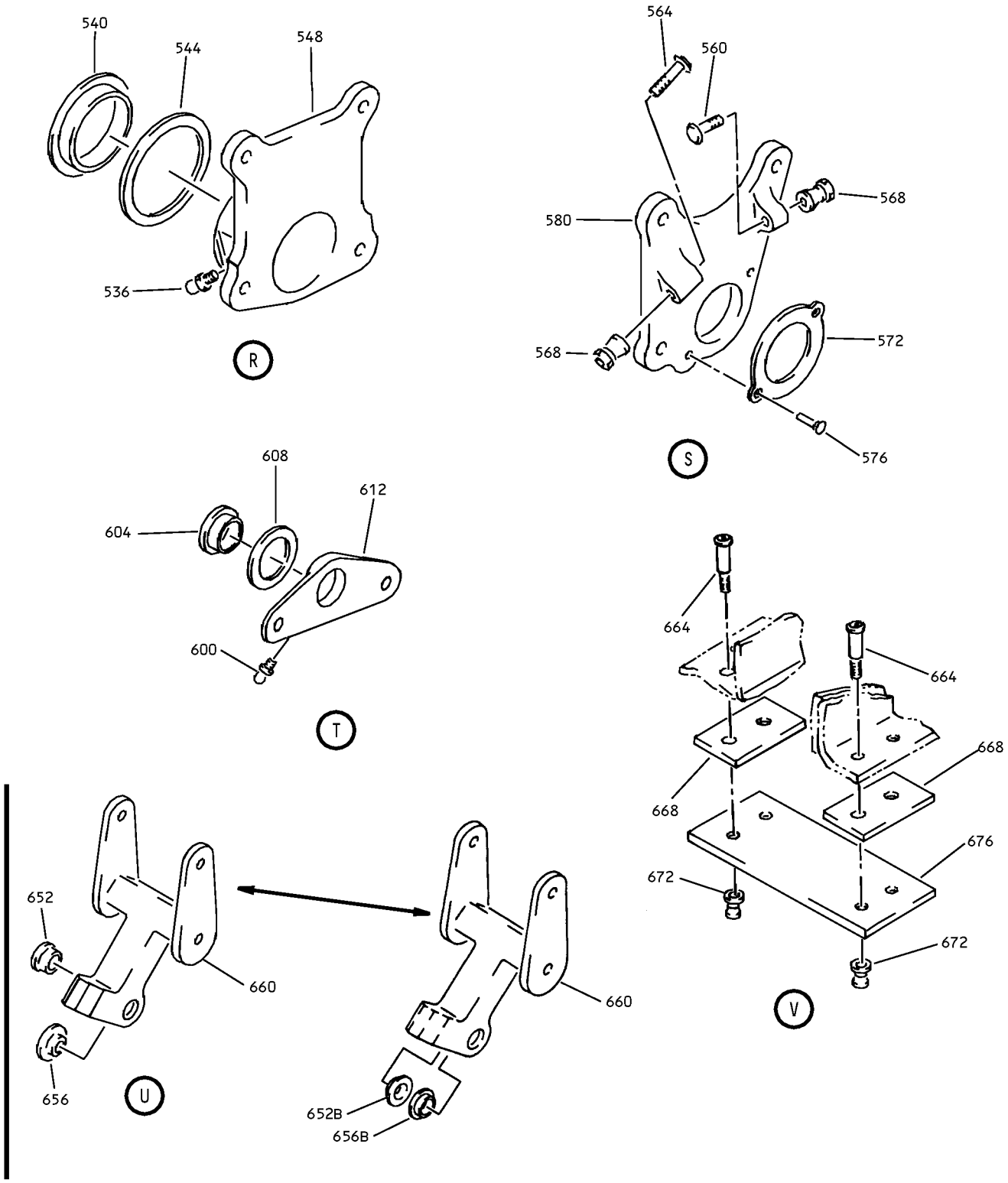

Inboard Trailing Edge Flap Linkage Assembly
Figure 1 (Sheet 9)

T99418

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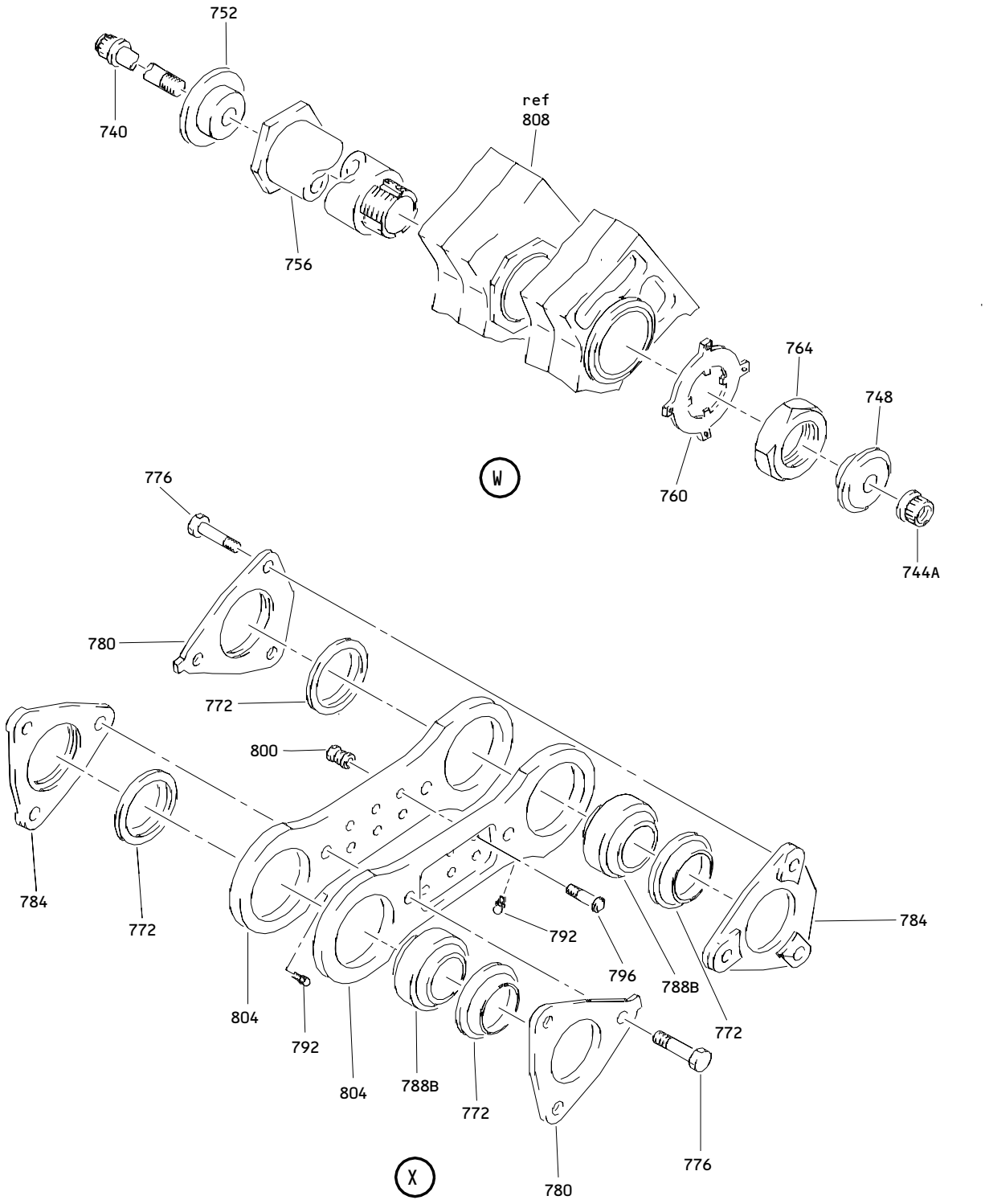

Inboard Trailing Edge Flap Linkage Assembly
Figure 1 (Sheet 10)

T99419

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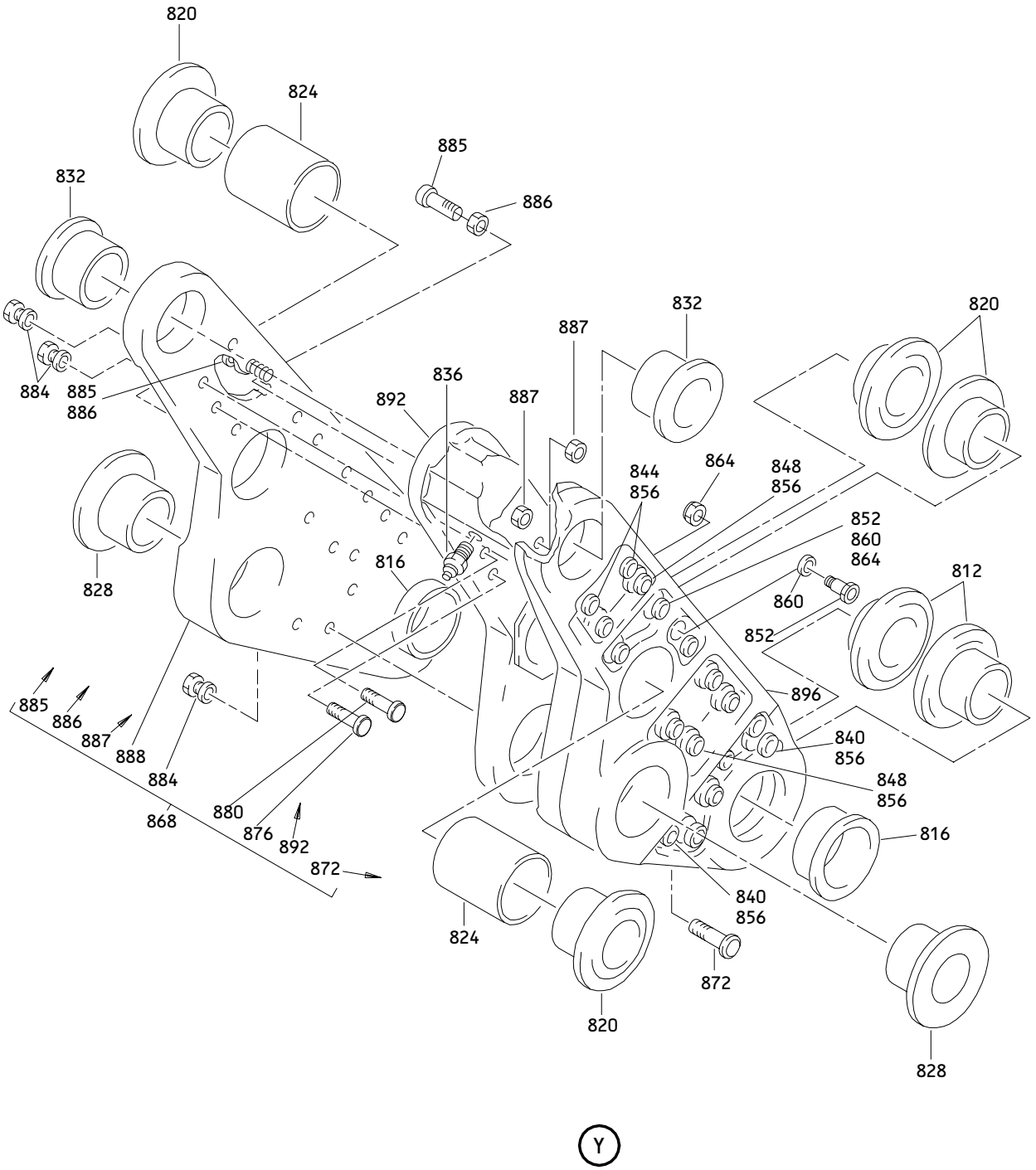

Inboard Trailing Edge Flap Linkage Assembly
Figure 1 (Sheet 11)

T99420

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-1B	113T2000-67		LINKAGE ASSY-INBD TE FLAP	A	RF
-1C	113T2000-73		LINKAGE ASSY-INBD TE FLAP	C	RF
-1D	113T2000-75		LINKAGE ASSY-INBD TE FLAP	E	RF
-1E	113T2000-85		LINKAGE ASSY-INBD TE FLAP	G	RF
-1F	113T2000-99		LINKAGE ASSY-INBD TE FLAP (VARIABLE)	J	RF
-1G	113T2000-131		LINKAGE ASSY-INBD TE FLAP	L	RF
-1H	113T2000-133		LINKAGE ASSY-INBD TE FLAP	M	RF
-1J	113T2000-137		LINKAGE ASSY-INBD TE FLAP	N	RF
-1K	113T2000-151		LINKAGE ASSY-INBD TE FLAP	S	RF
-1L	113T2000-153		LINKAGE ASSY-INBD TE FLAP	T	RF
-1M	113T2000-155		LINKAGE ASSY-INBD TE FLAP (VARIABLE)	U	RF
-1N	113T2000-195		LINKAGE ASSY-INBD TE FLAP	Y	RF
-1P	113T2000-203		LINKAGE ASSY-INBD TE FLAP	Z	RF
-1Q	113T2000-205		LINKAGE ASSY-INBD TE FLAP (VARIABLE)	AA	RF
-1R	113T2000-239		LINKAGE ASSY-INBD TE FLAP	AE	RF
-1S	113T2000-241		LINKAGE ASSY-INBD TE FLAP	AG	RF
-1T	113T2000-295		LINKAGE ASSY-INBD TE FLAP	AJ	RF
-1U	113T2000-297		LINKAGE ASSY-INBD TE FLAP	AL	RF
-4B	113T2000-68		LINKAGE ASSY-INBD TE FLAP	B	RF
-4C	113T2000-74		LINKAGE ASSY-INBD TE FLAP	D	RF
-4D	113T2000-76		LINKAGE ASSY-INBD TE FLAP	F	RF
-4E	113T2000-86		LINKAGE ASSY-INBD TE FLAP	H	RF
-4F	113T2000-100		LINKAGE ASSY-INBD TE FLAP (VARIABLE)	K	RF
-4G	113T2000-132		LINKAGE ASSY-INBD TE FLAP	P	RF
-4H	113T2000-134		LINKAGE ASSY-INBD TE FLAP	Q	RF
-4J	113T2000-138		LINKAGE ASSY-INBD TE FLAP	R	RF
-4K	113T2000-152		LINKAGE ASSY-INBD TE FLAP	V	RF
-4L	113T2000-154		LINKAGE ASSY-INBD TE FLAP	W	RF
-4M	113T2000-156		LINKAGE ASSY-INBD TE FLAP (VARIABLE)	X	RF
-4N	113T2000-196		LINKAGE ASSY-INBD TE FLAP	AB	RF
-4P	113T2000-204		LINKAGE ASSY-INBD TE FLAP	AC	RF
-4Q	113T2000-206		LINKAGE ASSY-INBD TE FLAP (VARIABLE)	AD	RF
-4R	113T2000-240		LINKAGE ASSY-INBD TE FLAP	AF	RF
-4S	113T2000-242		LINKAGE ASSY-INBD TE FLAP	AH	RF
-4T	113T2000-296		LINKAGE ASSY-INBD TE FLAP	AK	RF
-4U	113T2000-298		LINKAGE ASSY-INBD TE FLAP	AM	RF

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
8	MS24665-376		.PIN-COTTER		2
12	113T1264-41		.PIN-INNER		2
			(OPT ITEM 12A)		
-12A	113T1264-6		.PIN-INNER		2
			(OPT ITEM 12)		
16	113T1254-11		.WASHER-SPECIAL		AR
20	BACN10JD114AU		.NUT		2
24	113T1263-8		.PIN-OUTER		2
28	113T1254-4		.WASHER-SPECIAL		2
32	113T1262-4		.NUT-SPECIAL		2
36	113T1223-1		.LINK ASSY		1
			(PRE SB 767-27-0196)		
-36A	113T1223-1		.LINK ASSY		1
			(POST SB 767-27-0196)		
			(OPT ITEM 36B)		
-36B	113T1223-47		.LINK ASSY		1
			(POST SB 767-27-0196)		
			(OPT ITEM 36A)		
40	113T1256-25		..SEAL		4
44	BACB30LJ4HSU20		..BOLT		6
48	113T1267-16		..PLATE-RTNR		2
			(OPT ITEMS 48A, 48B)		
-48A	113T1267-1		..PLATE-RTNR		2
			(OPT ITEMS 48, 48B)		
-48B	113T1267-22		..PLATE-RTNR		2
			(OPT ITEMS 48, 48A)		
52	113T1267-15		..RETAINER-BRG		2
			(OPT ITEMS 52A, 52B)		
-52A	113T1267-2		..RETAINER-BRG		2
			(OPT ITEMS 52, 52B)		

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-52B	113T1267-21		..RETAINER-BRG (OPT ITEMS 52, 52A)		2
56	LHCB28BAD		DELETED		
56A	ASSB28-19		..BEARING- (V15860) (SPEC 60B00180-241) (OPT ASB28-102 (VS0352)) (OPT LHCB28BAD (V73134)) (USED ON ITEM 36) (PRE SB 767-27-0196))		2
-56B	BACB10JA28- ABNJ01		..BEARING- (USED ON ITEM 36A) (POST SB 767-27-0196))		2
-56C	BACB10JA28- ABNJ01		..BEARING- (USED ON ITEM 36B)		2
60	MS15004-1		..FITTING		2
64	HL10VAZ8-16		..BOLT- (V60516) (SPEC BACB30MY8K16) (OPT B30MY8K16 (V97928))		5
68	HL97DU8		..COLLAR- (V73197) (SPEC BACC30AB8S) (OPT HL97DU8 (V92215)) (OPT HL97DU8 (V56878))		5
72	113T1223-3		..SEGMENT-OUTER		2
76	113T1223-2		..SEGMENT-INNER		1
80	MS24665-376		.PIN-COTTER		1
84	113T1264-37		.PIN-INNER (OPT ITEM 84A)		1
-84A	113T1264-2		.PIN-INNER (OPT ITEM 84)		1
88	113T1254-13		.WASHER-SPECIAL		AR
92	BACN10JD112AU		.NUT		1
96	113T1263-2		.PIN-OUTER		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
100	113T1254-9		.WASHER-SPECIAL		1
104	113T1262-3		.NUT-SPECIAL		1
108	113T1256-27		.SEAL- (OPT ITEM 108A)	A-K	6
-108A	113T1256-49		.SEAL- (OPT ITEM 108)	A-K	6
112	113T1222-1		.BEAM ASSY-SPRT (OPT ITEM 112A)	A,B,E,F	1
-112A	113T1222-9		.BEAM ASSY-SPRT (OPT ITEM 112)	A,B,E,F	1
-112B	113T1222-9		.BEAM ASSY-SPRT	C,D,G-X,Z,AA,AC,AD	1
-112C	113T1222-11		.BEAM ASSY-SPRT	Y,AB	1
116	113T1347-40		..BUSHING		2
120	113T1347-55		..BUSHING		2
124	113T1347-64		..SPACER		2
128	113T1347-42		..BUSHING		2
132	113T1347-43		..BUSHING		2
136	113T1347-44		..BUSHING		2
140	113T1347-41		..BUSHING		2
144	MS15001-1		..FITTING		1
148	MS15001-3		..FITTING		2
152	HL10VAZ10-6		..BOLT- (V60516) (SPEC BACB30MY10K6) (OPT B30MY10K6 (V97928))		12
156	HL10VAZ10-7		..BOLT- (V60516) (SPEC BACB30MY10K7) (OPT B30MY10K7 (V97928))		16
160	HL10VAZ10-9		..BOLT- (V60516) (SPEC BACB30MY10K9) (OPT B30MY10K9 (V97928))		8

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
164	HL79-10		..COLLAR- (V56878) (SPEC BACC30M10) (OPT HL79-10 (V73197)) (OPT HL79-10 (V92215)) (OPT 66014-10 (V56878)) (OPT HL79-10 (V5M902))		36
168	HL10VAZ12-11		..BOLT- (V60516) (SPEC BACB30MY12K11) (OPT B30MY12K11 (V97928))		4
172	HL10VAZ12-14		..BOLT- (V60516) (SPEC BACB30MY12K14) (OPT B30MY12K14 (V97928))		8
176	HL10VAZ12-16		..BOLT- (V60516) (SPEC BACB30MY12K16) (OPT B30MY12K16 (V97928))		4
180	HL79-12		..COLLAR- (V56878) (SPEC BACC30M12) (OPT HL79-12 (V73197)) (OPT HL79-12 (V92215)) (OPT 66014-12 (V56878)) (OPT HL79-12 (V5M902))		16
184	HL10VAZ14-16		..BOLT- (V60516) (SPEC BACB30MY14K16) (OPT B30MY14K16 (V97928))		4

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-188	HL79-14		..COLLAR- (V56878) (SPEC BACC30M14) (OPT HL79-14 (V73197)) (OPT HL79-14 (V92215)) (OPT 66014-14 (V56878)) (OPT HL79-14 (V5M902))		4
192	113T1222-3		..STRAP-OUTER (USED ON ITEM 112)	A,B,E,F	1
-192A	113T1222-3		..STRAP-OUTER (OPT ITEM 192B) (USED ON ITEM 112A)	A,B,E,F	1
-192B	113T1222-7		..STRAP-OUTER (OPT ITEM 192A) (USED ON ITEM 112A)	A,B,E,F	1
-192C	113T1222-3		..STRAP-OUTER (OPT ITEM 192D)	C,D,G-X,Z,AA,AC,AD	1
-192D	113T1222-7		..STRAP-OUTER (OPT ITEM 192C)	C,D,G-X,Z,AA,AC,AD	1
-192E	113T1222-7		..STRAP-OUTER	Y,AB	1
-196	113T1222-4		..STRAP-OUTER (USED ON ITEM 112)	A,B,E,F	1
-196A	113T1222-4		..STRAP-OUTER (OPT ITEM 196B) (USED ON ITEM 112A)	A,B,E,F	1
-196B	113T1222-8		..STRAP-OUTER (OPT ITEM 196A) (USED ON ITEM 112A)	A,B,E,F	1
-196C	113T1222-4		..STRAP-OUTER (OPT ITEM 196D)	C,D,G-X,Z,AA,AC,AD	1
-196D	113T1222-8		..STRAP-OUTER (OPT ITEM 196C)	C,D,G-X,Z,AA,AC,AD	1
-196E	113T1222-8		..STRAP-OUTER	Y,AB	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
200	113T1222-2		..BEAM-INNER		1
204	MS24665-376		.PIN-COTTER		1
208	113T1264-38		.PIN-INNER (OPT ITEM 208A)		1
-208A	113T1264-3		.PIN-INNER (OPT ITEM 208)		1
212	113T1254-13		.WASHER-SPECIAL		AR
216	BACN10JD112AU		.NUT		1
220	113T1263-6		.PIN-OUTER		1
224	113T1105-9		.WASHER-SPECIAL		AR
228	113T1254-3		.WASHER-SPECIAL		1
232	113T1262-3		.NUT-SPECIAL		1
236	113T1229-1		.LINK ASSY-SPRT (PRE SB 767-27-0080)	A,C,E,M,S,AE,AJ	1
-236A	113T1229-2		DELETED		
-236B	113T1229-9		.LINK ASSY-SPRT (OPT ITEM 236F)	G,L,P,T	1
-236C	113T1229-10		DELETED		
-236D	113T1229-13		.LINK ASSY-SPRT (VARIABLE) (PRE SB 767-27-0080)	J,N,U	1
-236E	113T1229-14		DELETED		
-236F	113T2066-1		.LINK ASSY-SPRT (OPT ITEM 236B)	G,L,P,T	1
-236G	113T2066-2		DELETED		
-236H	113T2066-1		.LINK ASSY-SPRT (POST SB 767-27-0080)	A,C,E,J	1
-236J	113T2066-2		DELETED		
-236K	113T1229-9		.LINK ASSY-SPRT (OPT ITEM 236L)	Y,Z,AG,AL	1
-236L	113T2066-11		.LINK ASSY-SPRT (OPT ITEM 236K)	Y,Z,AG,AL	1
-236M	113T1229-13		.LINK ASSY-SPRT	AA	1
-236N	113T1229-10		DELETED		
-236P	113T2066-12		DELETED		
-236Q	113T1229-14		DELETED		

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	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
R	-238	113T1229-2		.LINK ASSY-SPRT (PRE SB 767-27-0080)	B,D,F,Q,V,AF,AK	1
R	-238A	113T1229-10		.LINK ASSY-SPRT (OPT ITEM 238C) ATTACHING PARTS	H,W	1
R	-238B	113T1229-14		.LINK ASSY-SPRT (VARIABLE) (PRE SB 767-27-0080) -------*-------	K,R,X	1
R	-238C	113T2066-2		.LINK ASSY-SPRT (OPT ITEM 238A)	H,W	1
R	-238D	113T2066-2		.LINK ASSY-SPRT (POST SB 767-27-0080)	B,D,F,K	1
R	-238E	113T1229-10		.LINK ASSY-SPRT (OPT ITEM 238F)	AB,AC,AH,AM	1
R	-238F	113T2066-12		.LINK ASSY-SPRT (OPT ITEM 238E)	AB,AC,AH,AM	1
R	-238G	113T1229-14		.LINK ASSY-SPRT	AD	1
	240	BACB28AM11B040A		..BUSHING- (USED ON ITEMS 236B, 236C, 236K, 236M, 236N, 236Q)		1
	-240A	BACB28AT11B040C		..BUSHING- (USED ON ITEMS 236F, 236G, 236L, 236Q)	G,H,L,P	1
	244	BACB28AP08P040		..BUSHING		1
	248	113T1347-68		..BUSHING		1
	252	113T1347-69		..BUSHING		1
	256	113T1347-70		..BUSHING		1
	260	113T1347-72		..BUSHING		1

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	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	264	113T1347-63		..SPACER		1
	268	MS15001-1		..FITTING		1
	272	113T1229-3		..LINK- (USED ON ITEMS 236, 236M)	A,C,E ,J,M, N,S,U ,AA, AE,AJ	1
	-272A	113T1229-4		DELETED		
	-272B	113T1229-11		..LINK- (OPT ITEM 272E) (USED ON ITEMS 236B, 236K)	G,L,P ,T,Y, Z,AG, AL	1
	-272C	113T1229-12		DELETED		
	-272D	113T1229-16		DELETED		
	-272E	113T1229-15		..LINK- (OPT ITEM 272B) (USED ON ITEMS 236B, 236K)	G,L,P ,T,Y, Z,AG, AL	1
	-272F	113T2066-3		..LINK- (USED ON ITEMS 236F, 236H)	A,C,E ,G,J, L,P,T	1
	-272G	113T2066-4		DELETED		
	-272H	113T2066-9		..LINK- (USED ON ITEM 236L)	Y,Z, AG,AL	1
	-272J	113T2066-10		DELETED		
R	-274	113T1229-4		..LINK- (USED ON ITEMS 238, 238G)	B,D,F ,K,Q, R,V,X ,AD, AF,AK	1
R	-274A	113T1229-12		..LINK- (OPT ITEM 274B) (USED ON ITEMS 238A, 238E)	H,W,A B,AC, AH,AM	1
R	-274B	113T1229-16		..LINK- (OPT ITEM 274A) (USED ON ITEMS 238A, 238E)	H,W,A B,AC, AH,AM	1
R	-274C	113T2066-4		..LINK- (USED ON ITEMS 238C, 238D)	B,D,F ,H,K, W	1
R	-274D	113T2066-10		..LINK- (USED ON ITEM 238F)	AB,AC AH,AM	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
276	113T1225-1		.LINK ASSY-SPRT		2
280	113T1256-22		..SEAL		4
284	BACB30LJ4H10		..BOLT		6
288	113T1267-17		..RETAINER-BRG (OPT ITEM 288A, 288B)		2
-288A	113T1267-3		..RETAINER-BRG (OPT ITEM 288, 288B)		2
-288B	113T1267-23		..RETAINER-BRG (OPT ITEM 288, 288A)		2
292	113T1267-18		..PLATE-RTNR (OPT ITEM 292A, 292B)		2
-292A	113T1267-4		..PLATE-RTNR (OPT ITEM 292, 292B)		2
-292B	113T1267-24		..PLATE-RTNR (OPT ITEM 292, 292A)		2
296	LHCB24BA		DELETED		
296A	ASSB24-101		..BEARING- (V15860) (SPEC 60B00180-230) (OPT ASB24-101 (VS0352)) (OPT LHCB24BA (V73134))		2
300	MS15004-1		..FITTING		2
304	113T1225-2		..LINK		1
308	MS24665-376		.PIN-COTTER		1
312	113T1264-42		.PIN-INNER (OPT ITEM 312A)		1
-312A	113T1264-7		.PIN-INNER (OPT ITEM 312)		1
314	113T1254-11		.WASHER-SPECIAL		AR

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	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
R	-314A	113T1789-4		DELETED		
	316	BACN10JD114AU		.NUT		1
	320	113T1263-7		.PIN-OUTER		1
	324	113T1254-6		.WASHER-SPECIAL		1
	328	113T1262-6		.NUT-SPECIAL		1
	332B	113T1226-31		.BEAM ASSY-SPRT	A	1
	-332C	113T1226-32		DELETED		
	-332D	113T1226-33		.BEAM ASSY-SPRT	C,E,G,J	1
	-332E	113T1226-34		DELETED		
	-332F	113T1226-35		.BEAM ASSY-SPRT	L,M,N	1
	-332G	113T1226-36		DELETED		
	-332H	113T1226-43		.BEAM ASSY-SPRT	S-U, Y-AA, AE,AG	1
	-332J	113T1226-44		DELETED		
	-332K	113T1226-59		.BEAM ASSY-SPRT	AJ,AL	1
R	-334	113T1226-32		.BEAM ASSY-SPRT	B	1
R	-334A	113T1226-34		.BEAM ASSY-SPRT	D,F,H,K	1
R	-334B	113T1226-36		.BEAM ASSY-SPRT	P,Q,R	1
R	-334C	113T1226-44		.BEAM ASSY-SPRT	V-X,AB-AD, AF,AH	1
R	-334D	113T1226-60		.BEAM ASSY-SPRT	AK,AM	1
	336	113T1256-21		..SEAL		2
	340	BACB30LR3P20		..BOLT	A-AH	6
	-340A	BACB30LH3P20		..BOLT	AJ-AM	6
	344	113T1267-7		..PLATE-RTNR		1
	348	113T1267-8		..RETAINER		1
	352	LHCB26BAD		DELETED		

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
352A	HSP26-108		..BEARING-		1
			(V02758)		
			(SPEC 60B00180-237)		
			(OPT ASB26-103		
			(VS0352))		
			(OPT LHCB26BAD		
			(V73134))		
			(OPT BLP28F237		
			(V16746))		
356	113T1347-58		..BUSHING		2
360	113T1347-59		..BUSHING		2
364	113T1347-43		..BUSHING		2
368	113T1347-44		..BUSHING		2
372	ADW05V301NC		..BEARING-		1
			(V15860)		
			(SPEC BACB10FA05GC)		
			(OPT SWKRS05-350SC		
			(V81376))		
			(OPT KSC152200BZ05GC		
			(V50632))		
			(OPT KWDB05-35		
			(V97613))		
			(OPT WES05FAGC		
			(V73134))		
			(OPT WHTFA05VC		
			(VS0352))		
376	MS15001-1		..FITTING		1
380	BACB30LE4-16		..BOLT		2
384	BACW10BP4C		..WASHER		2
388	BACW10BP4P		..WASHER		2
392	NAS1804-4		..NUT	A-AH	2
-392A	NAS1805-4L		..NUT	AJ-AM	2
396	BACB28AK04-035		..BUSHING	A-K	2
-396A	BACB28AK04-065		..BUSHING	L-AM	2
400	113T1737-1		..SHAFT ASSY-BELCRK	A,C,E	1
			(OPT ITEM 400A)	,G,J	
-400A	113T1737-9		..SHAFT ASSY-BELCRK	A,C,E	1
			(OPT ITEM 400)	,G,J	

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-400B	113T1737-19		..SHAFT ASSY-BELCRK	L,M,N ,S-U, Y-AA, AE,AG AJ,AL	1
-404	113T1737-2		..SHAFT ASSY-BELCRK (OPT ITEM 404A)	B,D,F ,H,K	1
-404A	113T1737-10		..SHAFT ASSY-BELCRK (OPT ITEM 404)	B,D,F ,H,K	1
-404B	113T1737-20		..SHAFT ASSY-BELCRK	P,Q,R ,V-X, AB-AD AF,AH AK,AM	1
408	BACB30LH4-38		...BOLT		2
412	AN960C416		...WASHER		2
416	BACN10JC4CM		...NUT		2
420	113T1737-5		...BELLCRANK ASSY- (USED ON ITEM 400)	A,C,E ,G,J	1
-420A	113T1737-13		...BELLCRANK ASSY- (OPT ITEM 420B) (USED ON ITEM 400A)	A,C,E ,G,J	1
-420B	113T1737-5		...BELLCRANK ASSY- (OPT ITEM 420A) (USED ON ITEM 400A)	A,C,E ,G,J	1
-420C	113T1737-5		...BELLCRANK ASSY- (OPT ITEM 420D)	L,M,N ,S-U, Y-AA, AE,AG AJ,AL	1
-420D	113T1737-15		...BELLCRANK ASSY- (OPT ITEM 420C)	L,M,N ,S-U, Y-AA, AE,AG AJ,AL	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-424	113T1737-6		...BELLCRANK ASSY- (USED ON ITEM 404)	B,D,F ,H,K	1
-424A	113T1737-14		...BELLCRANK ASSY- (OPT ITEM 424B) (USED ON ITEM 404A)	B,D,F ,H,K	1
-424B	113T1737-6		...BELLCRANK ASSY- (OPT ITEM 424A) (USED ON ITEM 404A)	B,D,F ,H,K	1
-424C	113T1737-6		...BELLCRANK ASSY- (OPT ITEM 424D)	P,Q,R ,V-X, AB-AD AF,AH AK,AM	1
-424D	113T1737-16		...BELLCRANK ASSY- (OPT ITEM 424C)	P,Q,R ,V-X, AB-AD AF,AH AK,AM	1
428	BACB28AM06B019A		....BUSHING-	A,C,E ,G,J	1
-428A	BACB28AM06B013A		....BUSHING- (USED ON ITEMS 424, 424B)	B,D,F ,H,K	1
-428B	BACB28AM06B019A		....BUSHING- (USED ON ITEM 424A)	B,D,F ,H,K	1
-428C	BACB28AT06B015C		....BUSHING	L-AM	1
432	113T1347-80		DELETED		
432A	113T1347-79		....BUSHING	A-K	1
-432B	BACB28AP04P015		....BUSHING	L-AM	1
436	BACR15BA5AD		....RIVET- (SIZE DETERMINE ON INST)		2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
440	113T1737-8		....SPACER		1
444	HL440UC8-15		....BOLT-		1
			(V56878)		
			(SPEC BACB30FM8A15)		
			(OPT HL440UC8-15 (V73197))		
			(OPT HL440UC8-15 (V92215))		
			(OPT HL440UC8-15 (V97928))		
			(OPT HL440UC8-15 (V80539))		
			(OPT WC130-8-15 (V60516))		
			(OPT 67067-8A15 (V56878))		
			(OPT HL440UC8-15 (V60516))		
			(OPT HL440UC8-15 (V08524))		
448	HL79-8		....COLLAR-		1
			(V56878)		
			(SPEC BACC30M8)		
			(OPT HL79-8 (V73197))		
			(OPT HL79-8 (V92215))		
			(OPT 66014-8 (V56878))		
			(OPT HL79-8 (V5M902))		
452	113T1737-7		....BELLCRANK-	A-K	1
			(USED ON ITEMS 420, 420B, 424, 424B)		

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-452A	113T1397-1		....BELLCRANK- (USED ON ITEMS 420A, 424A)	A-K	1
-452B	113T1737-17		....BELLCRANK- (OPT ITEM 452C)	L-AM	1
-452C	113T1397-3		....BELLCRANK- (OPT ITEM 452B)	L-AM	1
456	113T1737-3		...SHAFT ASSY- (USED ON ITEMS 400, 404)	A-K	1
-456A	113T1737-11		...SHAFT ASSY- (USED ON ITEMS 400A, 400B, 404A, 404B)		1
460	BACB28AM07B019A		....BUSHING		1
464	113T1347-79		DELETED		
464A	113T1347-80		....BUSHING		1
468	113T1347-81		....BUSHING		1
472	113T1347-82		....BUSHING		1
476	113T1737-4		....SHAFT- (USED ON ITEM 456)	A-K	1
-476A	113T1737-12		....SHAFT- (USED ON ITEM 456A)		1
480	113T1256-40		..SEAL- (OPT ITEM 480A)		1
-480A	113T1256-53		..SEAL- (OPT ITEM 480)		1
484	113T1256-41		..SEAL- (OPT ITEM 484A)		1
-484A	113T1256-54		..SEAL- (OPT ITEM 484)		1
488	113T1256-42		..SEAL- (OPT ITEM 488A)		1
-488A	113T1256-55		..SEAL- (OPT ITEM 488)		1
492	113T1731-1		..SPRING ASSY	A-K	1
496	ADB04V301NC		...BEARING- (V15860) (SPEC BACB10FB04GC) (OPT KNDB04-70 (V97613)) (OPT KSC145700BZ04GC (V50632)) (OPT NES04FBGC (V73134)) (OPT HTFB04GC (VS0352))	A-K	2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
500	113T1731-2		...SUB ASSY	A-K	1
504	113T1716-1		....TERMINAL	A-K	1
508	113T1716-2		....TERMINAL	A-K	1
512	113T1731-3		....SPRING	A-K	1
513	113T1731-5		..SPRING ASSY	L-AM	1
514	113T1731-7		...INSERT	L-AM	2
515	113T1731-6		...SPRING	L-AM	1
516A	HL10VAZ8-21		..BOLT- (V60516) (SPEC BACB30MY8K21) (OPT HL10VAZ8-21 (V73197))		3
520	HL10VAZ8-15		..BOLT- (V60516) (SPEC BACB30MY8K15) (OPT B30MY8K15 (V97928))		1
524	HL79-8		..COLLAR- (V56878) (SPEC BACC30M8) (OPT HL79-8 (V73197)) (OPT HL79-8 (V92215)) (OPT 66014-8 (V56878)) (OPT HL79-8 (V5M902))		4

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-528	113T1739-1		..FITTING ASSY-OUTBD SPRT (OPT ITEM 528A)	A	1
-528A	113T1009-1		..FITTING ASSY-OUTBD SPRT (OPT ITEM 528)	A	1
-528B	113T1739-7		..FITTING ASSY-OUTBD SPRT (OPT ITEM 528C)	C,E,G,J,L,M,N,S-U,Y-AA,AE,AGAJ,AL	1
-528C	113T1009-9		..FITTING ASSY-OUTBD SPRT (OPT ITEM 528B)	C,E,G,J,L,M,N,S-U,Y-AA,AE,AGAJ,AL	1
-532	113T1739-2		..FITTING ASSY-OUTBD SPRT (OPT ITEM 532A)	B	1
-532A	113T1009-2		..FITTING ASSY-OUTBD SPRT (OPT ITEM 532)	B	1
-532B	113T1739-8		..FITTING ASSY-OUTBD SPRT (OPT ITEM 532C)	D,F,H,K,P,Q,R,V-X,AB-ADAF,AHAK,AM	1
-532C	113T1009-10		..FITTING ASSY-OUTBD SPRT (OPT ITEM 532B)	D,F,H,K,P,Q,R,V-X,AB-ADAF,AHAK,AM	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
536	MS15001-1		...FITTING		1
540	113T1347-83		...BUSHING		1
544	113T1347-85		...SPACER		1
548	113T1739-3		...FITTING-OUTBD SPRT (USED ON ITEM 528)	A	1
-548A	113T1009-3		...FITTING-OUTBD SPRT (USED ON ITEM 528A)	A	1
-548B	113T1739-5		...FITTING-OUTBD SPRT (USED ON ITEM 528B)	C,E,G ,J,L, M,N, S-U, Y-AA AE,AG AJ,AL	1
-548C	113T1009-7		...FITTING-OUTBD SPRT (USED ON ITEM 528C)	C,E,G ,J,L, M,N, S-U, Y-AA AE,AG AJ,AL	1
-552	113T1739-4		...FITTING-OUTBD SPRT (USED ON ITEM 532)	B	1
-552A	113T1009-4		...FITTING-OUTBD SPRT (USED ON ITEM 532A)	B	1
-552B	113T1739-6		...FITTING-OUTBD SPRT (USED ON ITEM 532B)	D,F,H ,K,P, Q,R, V-X,A B-AD AF,AH AK,AM	1
-552C	113T1009-8		...FITTING-OUTBD SPRT (USED ON ITEM 532C)	D,F,H ,K,P, Q,R, V-X,A B-AD AF,AH AK,AM	1

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	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-556	113T1726-1		..FITTING ASSY-STOP	A	1
	-556A	113T1726-2		DELETED		
	-556B	113T1726-1		..FITTING ASSY-STOP (OPT ITEM 556C)	C,E,G,J,L,M,N,S-U,Y-AA AE,AG AJ,AL	1
	-556C	113T1586-1		..FITTING ASSY-STOP (OPT ITEM 556B)	C,E,G,J,L,M,N,S-U,Y-AA AE,AG AJ,AL	1
	-556D	113T1726-2		DELETED		
	-556E	113T1586-2		DELETED		
R	-558	113T1726-2		..FITTING ASSY-STOP	B	1
R	-558A	113T1726-2		..FITTING ASSY-STOP (OPT ITEM 558B)	D,F,H,K,P,Q,R,V-X,AB-AD AF,AH AK,AM	1
R	-558B	113T1586-2		..FITTING ASSY-STOP (OPT ITEM 558B)	D,F,H,K,P,Q,R,V-X,AB-AD AF,AH AK,AM	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-560	HL440UC8-7		...BOLT- (V56878) (SPEC BACB30FM8A7) (OPT HL440UC8-7 (V73197)) (OPT HL440UC8-7 (V92215)) (OPT HL440UC8-7 (V97928)) (OPT HL440UC8-7 (V80539)) (OPT WC130-8-7 (V60516)) (OPT 67067-8A7 (V56878)) (OPT HL440UC8-7 (V60516)) (OPT HL440UC8-7 (V08524)) (USED ON ITEMS 556, 556A, 556B, 556D)		1
-560A	HST10AG8-7		...BOLT- (V0PTK6) (SPEC BACB30VT8K7) (OPT HST10AG8-7 (V06725)) (OPT HST10AG8-7 (V56878)) (OPT HST10AG8-7 (V73197)) (USED ON ITEMS 556C, 556E)	C-AD	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-564	HL440UC8-12		...BOLT- (V56878) (SPEC BACB30FM8A12) (OPT HL440UC8-12 (V73197)) (OPT HL440UC8-12 (V92215)) (OPT HL440UC8-12 (V97928)) (OPT HL440UC8-12 (V80539)) (OPT WC130-8-12 (V60516)) (OPT 67067-8A12 (V56878)) (OPT HL440UC8-12 (V60516)) (OPT HL440UC8-12 (V08524)) (USED ON ITEMS 556, 556A, 556B, 556D)		1
-564A	HST10AG8-12		...BOLT- (VOPTK6) (SPEC BACB30VT8K12) (OPT HST10AG8-12 (V06725)) (OPT HST10AG8-12 (V56878)) (OPT HST10AG8-12 (V73197)) (USED ON ITEMS 556C, 556E)	C-AD	1
568	HL79-8		...COLLAR- (V56878) (SPEC BACC30M8) (OPT HL79-8 (V73197)) (OPT HL79-8 (V92215)) (OPT 66014-8 (V56878)) (OPT HL79-8 (V5M902)) (USED ON ITEMS 556, 556A, 556B, 556D)		2

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	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	-568A	HST79CY8		...COLLAR- (V73197) (SPEC BACC30BL8) (OPT HST79-8 (V56878)) (OPT HST79-8 (V92215)) (OPT HST79-8 (V5M902)) (USED ON ITEMS 556C, 556E)	C-AD	2
	572	113T1726-5		...PLATE-THRUST		1
	576	BACR15BA5AD		...RIVET- (SIZE DETERMINE ON INST)		2
	580	113T1726-3		...FITTING-STOP (USED ON ITEMS 556, 556B)	A,C,E ,G,J, L,M,N ,S-U, Y-AA AE,AG AJ,AL	1
|	-580A	113T1726-4		DELETED		
	-580C	113T1586-3		...FITTING- (USED ON ITEM 556C)	C,E,G ,J,L, M,N, S-U, Y-AA AE,AG AJ,AL	1
|	-580D	113T1586-4		DELETED		
R	-582	113T1726-4		...FITTING-STOP (USED ON ITEMS 558, 558A)	B,D,F ,H,K, P,Q,R ,V-X, AB-AD AF,AH AK,AM	1
| R	-582A	113T1586-4		...FITTING- (USED ON ITEM 558B)	D,F,H ,K,P, Q,R, V-X,A B-AD AF,AH AK,AM	1
|	584	113T1226-10		..SHIM		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
588	HL10VAZ8-13		..BOLT- (V60516) (SPEC BACB30MY8K13) (OPT B30MY8K13 (V97928))		2
592	HL79-8		..COLLAR- (V56878) (SPEC BACC30M8) (OPT HL79-8 (V73197)) (OPT HL79-8 (V92215)) (OPT 66014-8 (V56878)) (OPT HL79-8 (V5M902))		2
596	113T1719-1		..FITTING ASSY-INBD SPRT	A	1
-596A	113T1719-2		DELETED		
-596B	113T1719-1		..FITTING ASSY-INBD SPRT (OPT ITEM 596C)	C,E,G ,J,L, M,N, S-U, Y-AA AE,AG AJ,AL	1
-596C	113T1789-1		..FITTING ASSY-INBD SPRT (OPT ITEM 596B)	C,E,G ,J,L, M,N, S-U, Y-AA AE,AG AJ,AL	1
-596D	113T1719-2		DELETED		
-596E	113T1789-2		DELETED		

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	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
R	-598	113T1719-2		..FITTING ASSY-INBD SPRT	B	1
R	-598A	113T1719-2		..FITTING ASSY-INBD SPRT (OPT ITEM 598B)	D,F,H ,K,P, Q,R, V-X,A B-AD AF,AH AK,AM	1
R	-598B	113T1789-2		..FITTING ASSY-INBD SPRT (OPT ITEM 598A)	D,F,H ,K,P, Q,R, V-X,A B-AD AF,AH AK,AM	1
	600	MS15001-1		...FITTING		1
	604	113T1347-84		...BUSHING		1
	608	113T1347-86		...SPACER		1
	612	113T1719-3		...FITTING-SPRT (USED ON ITEMS 596, 596B)	A,C,E ,G,J, L,M,N ,S-U, Y-AA AE,AG AJ,AL	1
	-612A	113T1719-4		DELETED		
	-612B	113T1789-3		...FITTING- (USED ON ITEM 596C)	C,E,G ,J,L, M,N, S-U, Y-AA AE,AG AJ,AL	1
	-612C	113T1789-4		DELETED		

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	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
R	-614	113T1719-4		...FITTING-SPRT (USED ON ITEMS 598, 598A)	B,D,F,H,K,P,Q,R,V-X,AB-AD AF,AH AK,AM	1
R	-614A	113T1789-4		...FITTING- (USED ON ITEM 598B)	D,F,H,K,P,Q,R,V-X,AB-AD AF,AH AK,AM	1
	616	113T1226-9		..SHIM		1
	620	BACB30LE4-10		..BOLT		1
	624	BACB30LE4-11		..BOLT		1
	628	BACB30LE4-60		..BOLT		1
	632	BACW10BP4P		..WASHER		3
	636	NAS1804-4		..NUT	A-AH	3
	-636A	NAS1805-4L		..NUT	AJ-AM	3
	640	BACB28AM04B038A		..BUSHING	A-AH	4
	-640A	BACB28AT04B038C		..BUSHING	AJ-AM	4
	644	113T1226-15		..SHIM		1
	648	113T1738-1		..FITTING ASSY-SPR ATTACH (OPT ITEM 648A)	A-K	1
	-648A	113T1743-1		..FITTING ASSY-SPR ATTACH (OPT ITEM 648)	A-K	1
	-648B	113T1743-5		..FITTING ASSY-SPR ATTACH	L-AM	1
	652	BACB28AM06B019A		...BUSHING	A-K	1
	652A	BACB28AP04P014		DELETED		
R	652B	BACB28AT06B014C		...BUSHING	L-AM	1
	656	113T1347-79		...BUSHING	A-K	1
	656A	BACB28AT06B014C		DELETED		
R	656B	BACB28AP04P014		...BUSHING	L-AM	1
	660	113T1738-2		...FITTING- (USED ON ITEM 648)	A-K	1

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	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	-660A	113T1743-2		...FITTING- (USED ON ITEM 648A)	A-K	1
|	-660B	113T1743-2		...FITTING	L-AM	1
R	662	113T1226-30		..FITTING		1
	664	HL10VAZ8-6		..BOLT- (V60516) (SPEC BACB30MY8K6) (OPT B30MY8K6 (V97928))		4
|	668	BACS40R11C20F		..SHIM	A-AH	2
|	-668A	BACS40R011C020F		..SHIM	AJ-AM	2
	672	HL79-8		..COLLAR- (V56878) (SPEC BACC30M8) (OPT HL79-8 (V73197)) (OPT HL79-8 (V92215)) (OPT 66014-8 (V56878)) (OPT HL79-8 (V5M902))		4
	676	113T1226-29		..STRAP		1
	680	HL10VAZ8-4		..BOLT- (V60516) (SPEC BACB30MY8K4) (OPT B30MY8K4 (V97928))		12
	684	HL10VAZ8-7		..BOLT- (V60516) (SPEC BACB30MY8K7) (OPT B30MY8K7 (V97928))		18

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
688	HL11VAZ8-7		..BOLT- (V56878) (SPEC BACB30NW8K7) (OPT B30NW8K7 (V97928)) (OPT HL11VAZ8-7 (V73197)) (OPT HL11VAZ8-7 (V92215)) (OPT HL11VAZ8-7 (V97928)) (OPT L803-8K7 (V06725)) (OPT HL11VAZ8-7 (VOPTK6)) (OPT HL11VAZ8-7 (V60516))		2
692	HL79-8		..COLLAR- (V56878) (SPEC BACC30M8) (OPT HL79-8 (V73197)) (OPT HL79-8 (V92215)) (OPT 66014-8 (V56878)) (OPT HL79-8 (V5M902))		32
696	HL10VAZ10-12		..BOLT- (V60516) (SPEC BACB30MY10K12) (OPT B30MY10K12 (V97928))		2
700	HL10VAZ10-14		..BOLT- (V60516) (SPEC BACB30MY10K14) (OPT B30MY10K14 (V97928))		2
704	HL10VAZ10-16		..BOLT- (V60516) (SPEC BACB30MY10K16) (OPT B30MY10K16 (V97928))		4

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
708	HL79-10		..COLLAR- (V56878) (SPEC BACC30M10) (OPT HL79-10 (V73197)) (OPT HL79-10 (V92215)) (OPT 66014-10 (V56878)) (OPT HL79-10 (V5M902))		8
712	HL10VAZ12-21		..BOLT- (V60516) (SPEC BACB30MY12K21) (OPT HL10VAZ12-21 (V73197))		3
716	HL79-12		..COLLAR- (V56878) (SPEC BACC30M12) (OPT HL79-12 (V73197)) (OPT HL79-12 (V92215)) (OPT 66014-12 (V56878)) (OPT HL79-12 (V5M902))		3
720	HL10VAZ14-47		..BOLT- (V60516) (SPEC BACB30MY14K47) (OPT B30MY14K47 (V97928))	A-R	2
-720A	HL10VAZ14-48		..BOLT- (V60516) (SPEC BACB30MY14K48) (OPT HL10VAZ14-48 (V0PTK6))	S-AM	2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
724	HL79-14		..COLLAR- (V56878) (SPEC BACC30M14) (OPT HL79-14 (V73197)) (OPT HL79-14 (V92215)) (OPT 66014-14 (V56878)) (OPT HL79-14 (V5M902))		2
728	113T1226-21		..BEAM-OUTER		1
732	113T1226-22		..BEAM-OUTER		1
736	113T1226-2		..BEAM-INNER	A-AH	1
-736A	113T1226-58		..BEAM-INNER	AJ-AM	1
740	BACB30MR6K111		.BOLT- (OPT ITEM 740A)		1
-740A	BACB30LE6-111		.BOLT- (OPT ITEM 740)		1
744	BACN10GW6AS		DELETED		
744A	NAS1805-6		.NUT		1
748	113T1258-1		.CAP-END		1
752	113T1258-2		.CAP-END		1
756	113T1263-5		.PIN-OUTER		1
760	113T1254-46		.WASHER-SPECIAL		1
764	113T1262-4		.NUT-SPECIAL		1
768	113T1224-1		.LINK ASSY-SPRT		1
772	113T1256-20		..SEAL		4
776	BACB30LJ4HSU15		..BOLT		6
780	113T1267-20		..PLATE-RTNR (OPT ITEMS 780A, 780B)		2
-780A	113T1267-5		..PLATE-RTNR (OPT ITEMS 780, 780B)		2
-780B	113T1267-26		..PLATE-RTNR (OPT ITEMS 780, 780A)		2
784	113T1267-19		..RETAINER-BRGR (OPT ITEMS 784A, 784B)		2
-784A	113T1267-6		..RETAINER-BRGR (OPT ITEMS 784, 784B)		2
-784B	113T1267-25		..RETAINER-BRGR (OPT ITEMS 784, 784A)		2
788	LUCB28BA		DELETED		
-788A	BLP28F240		DELETED		

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
788B	ASSB28-18		..BEARING- (V15860) (SPEC 60B00180-240) (OPT ASB28-101 (VS0352)) (OPT BLP28F240 (V16746)) (OPT LHCB28BA (V73134))		2
792	MS15001-1		..FITTING		2
796	HL10VAZ8-8		..BOLT- (V60516) (SPEC BACB30MY8K8) (OPT B30MY8K8 (V97928))		6
800	HL79-8		..COLLAR- (V56878) (SPEC BACC30M8) (OPT HL79-8 (V73197)) (OPT HL79-8 (V92215)) (OPT 66014-8 (V56878)) (OPT HL79-8 (V5M902))		6
804	113T1224-2		..LINK HALF		2
808	113T1221-14		.LINK ASSY-SPRT DRIVE (OPT ITEM 808A)	A,B,E,F	1
-808A	113T1221-13		.LINK ASSY-SPRT DRIVE (OPT ITEM 808)	A,B,E,F	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-808C	113T1221-20		.LINK ASSY-SPRT DRIVE (OPT ITEM 808F) (PRE SB 767-27-0080)	C,D,M,Q,S,V	1
-808D	113T1221-25		.LINK ASSY-SPRT DRIVE (OPT ITEM 808G)	G,H,L,P,T,W,Y,Z,AB,AC	1
-808E	113T1221-27		.LINK ASSY-SPRT DRIVE (VARIABLE) (OPT ITEM 808J)	J,K,N,R,U,X,AA,AD	1
-808F	113T1221-29		.LINK ASSY-SPRT DRIVE (OPT ITEM 808C)	C,D,M,Q,S,V	1
-808G	113T1221-31		.LINK ASSY-SPRT DRIVE (OPT ITEM 808D)	G,H,L,P,T,W,Y,Z,AB,AC	1
-808J	113T1221-33		.LINK ASSY-SPRT DRIVE (VARIABLE) (OPT ITEM 808E)	J,K,N,R,U,X,AA,AD	1
-808K	113T1221-25		.LINK ASSY-SPRT DRIVE (OPT ITEM 808L) (POST SB 767-27-0080)	C,D,AG,AH,AL,AM	1
-808L	113T1221-31		.LINK ASSY-SPRT DRIVE (OPT ITEM 808K) (POST SB 767-27-0080)	C,D,AG,AH,AL,AM	1
-808M	113T1221-39		.LINK ASSY-SPRT DRIVE (OPT ITEM 808N)	AE,AF,AJ,AK	1
-808N	113T1221-41		.LINK ASSY-SPRT DRIVE (OPT ITEM 808M)	AE,AF,AJ,AK	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
812	113T1347-49		..BUSHING		2
816	113T1347-50		..BUSHING- (USED ON ITEMS 808, 808A, 808C, 808D, 808E, 808K, 808M)		2
-816A	113T1347-111		..BUSHING- (USED ON ITEMS 808F, 808G, 808J, 808L, 808N)	C,D, G-AM	2
820	113T1347-46		..BUSHING		4
824	113T1347-47		..BUSHING		2
828	113T1347-48		..BUSHING		2
832	113T1347-45		..BUSHING- (USED ON ITEMS 808, 808A, 808C, 808D, 808E, 808K, 808M)		2
-832A	113T1347-112		..BUSHING- (USED ON ITEMS 808F, 808G, 808J, 808L, 808N)	C,D, G-AM	2
836	MS15001-1		..FITTING		1
840	HL10VAZ10-10		..BOLT- (V60516) (SPEC BACB30MY10K10) (OPT B30MY10K10 (V97928))		6
844	HL10VAZ10-12		..BOLT- (V60516) (SPEC BACB30MY10K12) (OPT B30MY10K12 (V97928))		2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
848	HL10VAZ10-14		..BOLT- (V60516) (SPEC BACB30MY10K14) (OPT B30MY10K14 (V97928))		8
852	BACB30LJ5-14		..BOLT		2
856	HL79-10		..COLLAR- (V56878) (SPEC BACC30M10) (OPT HL79-10 (V73197)) (OPT HL79-10 (V92215)) (OPT 66014-10 (V56878)) (OPT HL79-10 (V5M902))		16
860	AN960PD516L		..WASHER- (USED ON ITEMS 808, 808A, 808B, 808C, 808E, 808F, 808J, 808M, 808N)	A-F,J,K,M,N,Q-S,U,V,X,AA AD-AF AJ,AK	2
-860A	AN960JD516L		..WASHER- (USED ON ITEMS 808D, 808G, 808K, 808L, 808N)	C,D,G,H,L,P,T,W,Y,Z,AB,AC AE,AF AJ,AK	2
864	BACN10JC5		..NUT- (USED ON ITEMS 808, 808A, 808B, 808C, 808E, 808F, 808J, 808M, 808N)	A-F,J,K,M,N,Q-S,U,V,X,AA AD-AF AJ,AK	2
-864A	MS21042L5		..NUT- (USED ON ITEMS 808D, 808G, 808K, 808L)	C,D,G,H,L,P,T,W,Y,Z,AB,AC AG,AH AL,AM	2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
866	BACR15BB8D8		..RIVET		1
868	113T1221-18		..LINK ASSY- (USED ON ITEM 808)	A,B,E ,F	1
-868A	113T1221-16		..LINK ASSY- (USED ON ITEM 808A)	A,B,E ,F	1
-868B	113T1221-19		..LINK ASSY- (USED ON ITEM 808C)	C,D,M ,Q,S, V	1
-868C	113T1221-24		..LINK ASSY- (USED ON ITEMS 808D, 808K)	C,D,G ,H,L, P,T,W ,Y,Z, AB,AC AG,AH AL,AM	1
-868D	113T1221-26		..LINK ASSY-(VARIABLE) (USED ON ITEM 808E)	J,K,N ,R,U, X,AA, AD	1
-868E	113T1221-28		..LINK ASSY- (USED ON ITEM 808F)	C,D,M ,Q,S, V	1
-868F	113T1221-28		DELETED		
-868G	113T1221-32		..LINK ASSY- (USED ON ITEM 808J)	J,K,N ,R,U, X,AA, AD	1
-868H	113T1221-30		..LINK ASSY- (USED ON ITEMS 808G, 808L)	C,D,G ,H,L, P,T,W ,Y,Z, AB,AC AG,AH AL,AM	1
-868J	113T1221-40		..LINK ASSY- (USED ON ITEM 808M)	AE,AF AJ,AK	1
-868K	113T1221-42		..LINK ASSY- (USED ON ITEM 808N)	AE,AF AJ,AK	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
872	HL10VAZ10-10		...BOLT- (V60516) (SPEC BACB30MY10K10) (OPT B30MY10K10 (V97928))		6
876	HL10VAZ10-12		...BOLT- (V60516) (SPEC BACB30MY10K12) (OPT B30MY10K12 (V97928))		2
880	HL10VAZ10-14		...BOLT- (V60516) (SPEC BACB30MY10K14) (OPT B30MY10K14 (V97928))		8
884	HL79-10		...COLLAR- (V56878) (SPEC BACC30M10) (OPT HL79-10 (V73197)) (OPT HL79-10 (V92215)) (OPT 66014-10 (V56878)) (OPT HL79-10 (V5M902))		16
885	BACB30LJ5-14		...BOLT		2
886	AN960PD516L		...WASHER- (USED ON ITEMS 868, 868A, 868B, 868D, 868E, 868G)	A-F,J,K,M,N,Q-S,U,V,X,AA,AD	2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01- -886A	AN960JD516L		...WASHER- (USED ON ITEMS 868C, 868H, 868J, 868K)	C,D,G,H,L,P,T,W,Y,Z,AB,AC AE-AM	2
887	BACN10JC5		...NUT- (USED ON ITEMS 868, 868A, 868B, 868D, 868E, 868G, 868J, 868K)	A-F,J,K,M,N,Q-S,U,V,X,AA AD-AF AJ,AK	2
-887A	MS21042L5		...NUT- (USED ON ITEMS 868C, 868H)	C,D,G,H,L,P,T,W,Y,Z,AB,AC AG,AH AL,AM	2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-888	113T1447-5		...LINK-SIDE (USED ON ITEM 868)	A,B,E,F	1
-888A	113T1221-11		...LINK-SIDE (USED ON ITEM 868A)	A,B,E,F	1
-888B	113T1447-7		...LINK-SIDE (USED ON ITEMS 868B, 868D)	C,D,J,K,M,N,Q-S,U,V,X,AA AD-AF AJ,AK	1
-888C	113T1447-21		DELETED		
-888D	113T1447-9		...LINK-SIDE (OPT ITEM 888E) (USED ON ITEM 868C)	C,D,G,H,L,P,T,W,Y,Z,AB,AC	1
-888E	113T1221-21		...LINK-SIDE (OPT ITEM 888D) (USED ON ITEM 868C)	C,D,G,H,L,P,T,W,Y,Z,AB,AC	1
-888F	113T1447-13		...LINK-SIDE (USED ON ITEMS 868E, 868G)	C,D,J,K,M,N,Q-S,U,V,X,AA AD-AF AJ,AK	1
-888G	113T1447-15		...LINK-SIDE (USED ON ITEM 868H)	C,D,G,H,L,P,T,W,Y,Z,AB,AC	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-892	113T1221-2		...LINK-CTR FORK (USED ON ITEMS 868, 868A, 868B, 868D, 868G)	A-F,J,K,M,N,Q-S,U,V,X,AA AD-AF AJ,AK	1
-892A	113T1221-23		...LINK-CTR FORK (USED ON ITEM 868C)	C,D,G,H,L,P,T,W,Y,Z,AB,AC	1
-892B	113T1221-34		...LINK-CTR FORK (USED ON ITEM 868E)	C,D,M,Q,S,V,AE,AF,AJ,AK	1
-892C	113T1221-35		...LINK-CTR FORK (USED ON ITEM 868H)	C,D,G,H,L,P,T,W,Y,Z,AB,AC	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01- 896	113T1447-6		..LINK-SIDE (USED ON ITEM 808)	A,B,E ,F	1
-896A	113T1221-12		..LINK-SIDE (USED ON ITEM 808A)	A,B,E ,F	1
-896B	113T1447-8		..LINK-SIDE (USED ON ITEMS 808C, 808E, 808M)	C,D,J ,K,M, N,Q-S ,U,V, X,AA AD-AF AJ,AK	1
-896C	113T1447-22		DELETED		
-896D	113T1447-10		..LINK-SIDE (OPT ITEM 896E) (USED ON ITEMS 808D, 808K)	C,D,G ,H,L, P,T,W ,Y,Z, AB,AC	1
-896E	113T1221-22		..LINK-SIDE (OPT ITEM 896D) (USED ON ITEMS 808D, 808K)	G,H,L ,P,T, W,Y,Z ,AB,A C	1
-896F	113T1447-14		..LINK-SIDE (USED ON ITEMS 808F, 808J, 808N)	C,D,M ,N, Q-S,U ,V,X, AA,AD	1
-896G	113T1447-16		..LINK-SIDE (USED ON ITEMS 808G, 808L)	C,D,G ,H,L, P,T,W ,Y,Z, AB,AC AG,AH AL,AM	1
-896H	113T1447-7		..LINK-SIDE (USED ON ITEM 808N)	AE,AF AJ,AK	1

- Item Not Illustrated

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