

 **BOEING**
COMPONENT
MAINTENANCE MANUAL

TO: ALL HOLDERS OF INBOARD TRAILING EDGE FLAP LINKAGE ASSEMBLY COMPONENT
MAINTENANCE MANUAL 27-51-88

REVISION NO. 3 DATED NOV 01/05

HIGHLIGHTS

All data formerly in manual 27-51-95 is included in this manual 27-51-88.

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

Incorporated SB 767-27-0196 which modifies the existing 3-10 link assembly or replaces it with a new spares assembly 113T1223-47

1

REPAIR-GEN

603

REPAIR 1-1

601-602

1005,1010,1028-1029

REPAIR-GEN

Edited without technical change

602

1010,1014,1039-1040,

1045-1049,1055,1058,

1060,1062-1063,1066,

1068

REPAIR-GEN

Updated the True Position Dimensioning symbols

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1038,1041,1044,1062

Updated the IPL

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INBOARD TRAILING EDGE FLAP LINKAGE ASSEMBLY

PART NUMBER 113T2000-3,-4

COMPONENT MAINTENANCE MANUAL
WITH
ILLUSTRATED PARTS LIST

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TITLE PAGE

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REVISION RECORD

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

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

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REVISION RECORD

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TEMPORARY REVISION AND SERVICE BULLETIN RECORD

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVE	DATE OF INCORPORATION INTO MANUAL
767-27-0196		PRR B10450 PRR B10903 PRR C12218-1	JUL 10/83 JUL 10/83 APR 10/85 NOV 01/05

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TR & SB RECORD

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*1008	NOV 01/05	01.101	*1049	NOV 01/05	01.1
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*1010	NOV 01/05	01.1	1051	OCT 01/90	01.1
*1011	NOV 01/05	01.101	1052	OCT 01/90	01.1
*1012	NOV 01/05	01.101	1053	OCT 01/90	01.1
*1013	NOV 01/05	01.101	1054	OCT 01/90	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 | 4. List of Effective Pages |
| 2. Record of Revisions | 5. Table of Contents |
| 3. Temporary Revision &
Service Bulletin Record | 6. Introduction |
| | 7. Procedures & IPL Sections |

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

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

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

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

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

Verification:

Disassembly	Mar 9/82
Assembly	Mar 9/82

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INTRODUCTION

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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)

| A. Length -- 48 inches
| Width -- 12 inches
| Height -- 20 inches
| Weight -- 180 pounds

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DESCRIPTION & OPERATION

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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 (10, 100, 250, 390)

B. Seals (50, 133, 355, 422, 900)

2. Disassembly (IPL Fig. 1)

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

WARNING: SPRING ASSEMBLY (610) IS HEAVILY LOADED. USE CARE WHILE REMOVING FITTING ASSEMBLY (760) TO AVOID INJURY TO PERSONNEL.

B. Remove nuts (750). Insert bar into 0.62 inch dia. hole in fitting assembly (760) to apply force reacting against force in spring assembly (610). Remove bolts (730, 735) and washers (745) and slowly release spring force using bolt (740) as a hinge.

C. Remove bolt (475), washers (480, 485), bushing (495) and nut (490) attaching spring assembly (610) to fitting assembly (760). Separate spring assembly from fitting assembly. Remove bolt (740), fitting assembly (760) and shim (757).

NOTE: Note thickness of shim (757) to facilitate assembly. Do not disassemble fitting assembly (760) unless repair or replacement is necessary.

D. Remove parts (510, 515, 520). Pull out shaft assembly (570) and remove bellcrank assembly (525 or 530). Remove parts (475 thru 495) and spring assembly (610) from bellcrank.

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- E. Remove lockbolts (640A, 645, 705) and collars (650, 710) and remove inboard and outboard support fittings (715 or 718, 655 or 660), shims (700, 725), stop fitting (690 or 691) and seals (595 thru 605).

NOTE: Note thickness of shims (700, 725) to facilitate assembly. Do not disassemble fittings (655 or 660, 690 or 691, 715 or 718) unless necessary for repair or replacement.

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

- (1) Link assemblies (45, 290 or 295, 350, 895, 927B)
- (2) Beam assembly (135)

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DISASSEMBLY

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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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CLEANING
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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 (30, 120, 270, 405, 880, IPL Fig. 1)
 - B. Link half (385, 924)
 - C. Retainers (60, 360, 430, 906)
 - D. Support link assy (350)
 - E. Special washers (35, 125, 280, 410, 885A)
 - F. Inner pins (15, 105, 255, 395)
 - G. Spring (635)
5. Penetrant check per 20-20-02 the following listed items:
 - A. Side links (966A, 994)
 - B. Center fork link (997)
 - C. Inner beam (850)
 - D. Outer beam (845B)
 - E. Link assy (45)
 - F. Outer straps (235, 240)
 - G. Links (340, 345)
 - H. Fittings (680 or 685, 698 or 699, 723 or 724)
 - I. Shaft (592)
 - J. Bellcrank (565)

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- K. Beam (245)
 - L. Inner pins (15A, 105A, 255A, 395A)
6. Extend spring assembly (610) to 12.06 inches (between centerlines of bearings). Check that load is 355-425 lbs.

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CHECK
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REPAIR – GENERAL

1. Content

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

<u>P/N</u>	<u>NAME</u>	<u>REPAIR</u>
113T1223	LINK	1-1
113T1263	PIN, OUTER	2-1
113T1222	BEAM – SPRT	3-1, 3-2
113T1229	LINK – SPRT	4-1, 4-2
113T1225	LINK – SPRT	5-1
113T1226	BEAM – SPRT	6-1, 6-2
113T1224	LINK – SPRT	7-1
113T1221	LINK – SPRT DRIVE	8-1, 8-2
113T1719	FITTING – INBD SUPPORT	9-1
113T1739	FITTING – OUTBD SUPPORT	10-1
113T1009	FITTING – OUTBD SUPPORT	10-1
113T1731	SPRING	11-1
113T1726	FITTING – STOP	12-1
113T1737-1,-2,-9,-10	SHAFT AND BELLCRANK	13-1
113T1737-3,-11	SHAFT	14-1
113T1737-5,-6,-13,-14	BELLCRANK	15-1
113T1738	FITTING – SPRING ATTACH	16-1

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<u>P/N</u>	<u>NAME</u>	<u>REPAIR</u>
113T1743	FITTING- SPRING ATTACH	16-1
- - -	MISC PARTS REFINISH	17-1
- - -	BUSHING SEALING	18-1

2. Standard Practices

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

- 20-10-03 Shot Peening
- 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)
- F. Lockwire -- MS20995C32

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| 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	⊕	THEORETICAL EXACT POSITION OF A FEATURE (TRUE POSITION)
▭	FLATNESS	∅	DIAMETER
⊥	PERPENDICULARITY (OR SQUARENESS)	S ∅	SPHERICAL DIAMETER
//	PARALLELISM	R	RADIUS
○	ROUNDNESS	SR	SPHERICAL RADIUS
⊘	CYLINDRICITY	()	REFERENCE
⌒	PROFILE OF A LINE	BASIC (BSC) OR	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.
△	PROFILE OF A SURFACE	DIM	
◎	CONCENTRICITY	-A-	DATUM
≡	SYMMETRY	Ⓜ	MAXIMUM MATERIAL CONDITION (MMC)
∠	ANGULARITY	Ⓛ	LEAST MATERIAL CONDITION (LMC)
↗	RUNOUT	Ⓢ	REGARDLESS OF FEATURE SIZE (RFS)
↗↗	TOTAL RUNOUT	Ⓟ	PROJECTED TOLERANCE ZONE
⊐	COUNTERBORE OR SPOTFACE	FIM	FULL INDICATOR MOVEMENT
∇	COUNTERSINK		

EXAMPLES

— 0.002

STRAIGHT WITHIN 0.002

◎ ∅ 0.0005 C

CONCENTRIC TO C WITHIN 0.0005 DIAMETER

⊥ 0.002 B

PERPENDICULAR TO B WITHIN 0.002

≡ 0.010 A

SYMMETRICAL WITH A WITHIN 0.010

// 0.002 A

PARALLEL TO A WITHIN 0.002

∠ 0.005 A

ANGULAR TOLERANCE 0.005 WITH A

○ 0.002

ROUND WITHIN 0.002

⊕ ∅ 0.002 Ⓢ B

LOCATED AT TRUE POSITION WITHIN 0.002 DIA RELATIVE TO DATUM B, REGARDLESS OF FEATURE SIZE

⊘ 0.010

CYLINDRICAL SURFACE MUST LIE BETWEEN TWO CONCENTRIC CYLINDERS, ONE OF WHICH HAS A RADIUS 0.010 INCH GREATER THAN THE OTHER

⊥ ∅ 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

⌒ 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

2.000

THEORETICALLY EXACT DIMENSION IS 2.000

▭ 0.020 A

SURFACES MUST LIE WITHIN PARALLEL BOUNDARIES 0.02 INCH APART AND EQUALLY DISPOSED ABOUT TRUE PROFILE

OR
 2.000
 BSC

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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LINK ASSEMBLY – REPAIR 1-1

113T1223-1, -47

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 (65) and bearing retainers (55, 60).
- B. Remove bearings (70) and seals (50).
- C. Install new bearings (70) and seals (50) (Ref 20-50-03). On assembly 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 (55, 60) and the outer segment (90).
- E. Install bearing retainers (55, 60) and secure with bolts (65). Tighten bolts 12-15 lb-in.
- F. Lockwire bolts (65) to retainers (55, 60) per 20-50-02.

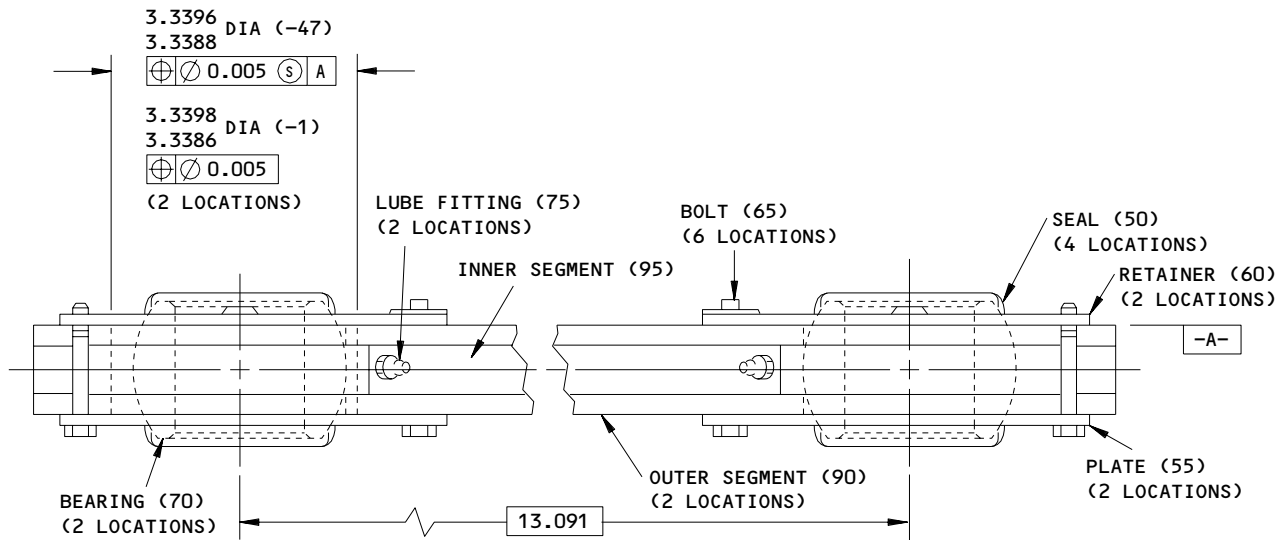
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REFINISH

LINK ASSEMBLY (45) -- 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 (55,55A), RETAINER (60,60A) -- PASSIVATE (F-17.09)

PLATE (55B), RETAINER (60B) -- PASSIVATE (F-17.09) AND APPLY BMS 10-11, TYPE 1 PRIMER (F-20.02).

SEGMENT (90,95) -- 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 (55), RETAINER (60) -- 15-5PH CRES,
 180-200 KSI

SEGMENT (90,95) -- TI-6AL-4V TITANIUM

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

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

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PIN, OUTER - REPAIR 2-1

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 instruction, 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.

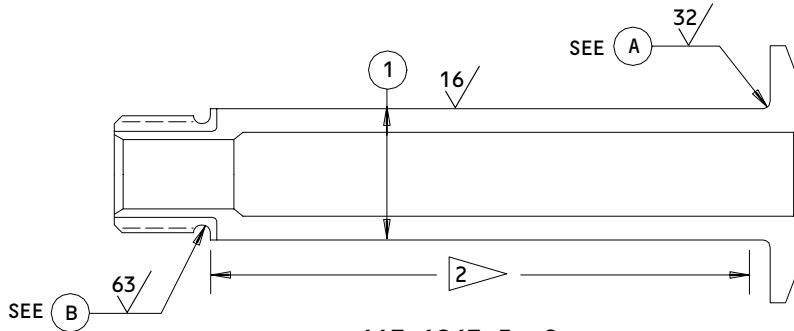
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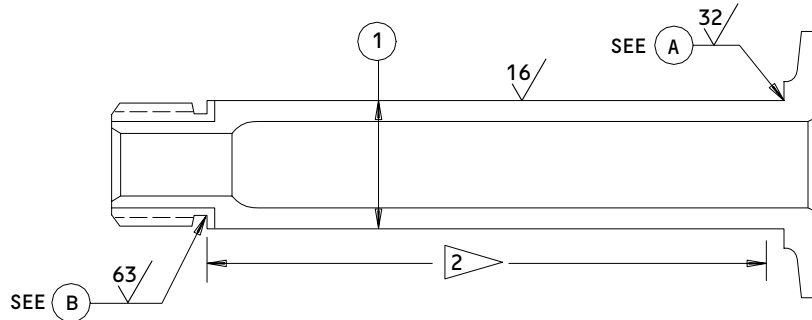
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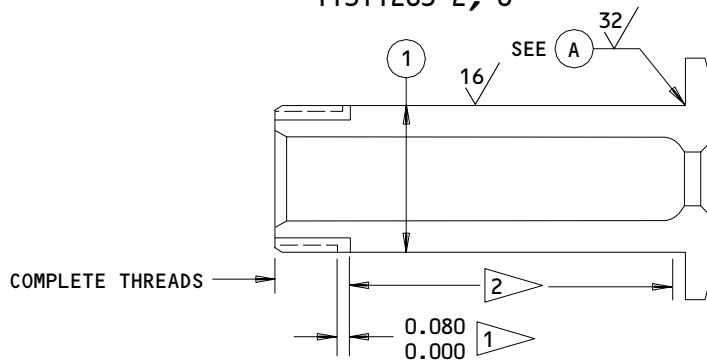
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113T1263-5,-8



113T1263-2,-6



ALL DIMENSIONS ARE IN INCHES

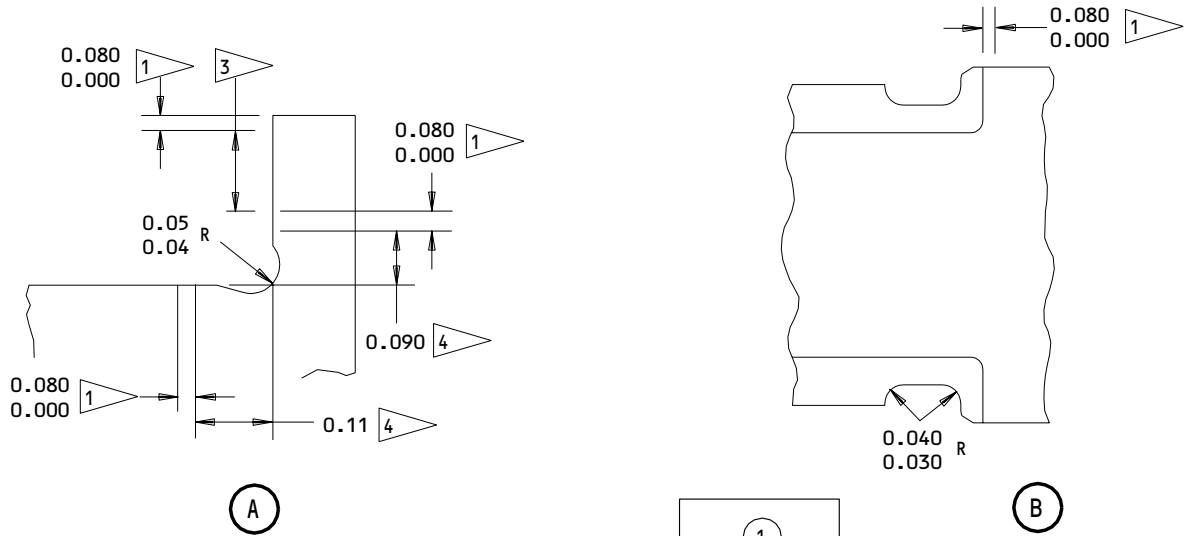
113T1263-7
 Pin Refinish
 Figure 601 (Sheet 1)

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		(1)
PIN 113T1263-2, -6	DESIGN DIA	1.4990 1.4984
	MIN REPAIR DIA 5	1.4684
PIN 113T1263-5, -8	DESIGN DIA	1.7490 1.7484
	MIN REPAIR DIA 5	1.7184
PIN 113T1263-7	DESIGN DIA	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 RUN OUT AREA
- 2 CHROME PLATE (F-15.03) THIS SURFACE
- 3 CHROME PLATE (F-15.03) 0.001 MIN PLATING THICKNESS (113T1263-2,-6 THRU -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 DIM 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 EXCEPT AS NOTED

BREAK SHARP EDGES 0.04 R
0.02

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

ALL DIMENSIONS ARE IN INCHES

113T1263-2,-5 THRU -8

Pin Refinish
Figure 601 (Sheet 2)

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REPAIR 2-1

01

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BEAM ASSEMBLY - SUPPORT - REPAIR 3-1

113T1222-1, -5, -9

NOTE: Refer to REPAIR-GEN for list of applicable standard practices. For repair of beam (135) which may only require stripping and restoration of original finish, refer to Refinish Instructions, Fig. 601.

1. Bushing Replacement (Fig. 601)

- A. Remove bushings and spacers.
- 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. Check dimensions and machine as necessary.
- D. Seal bushings per REPAIR 18-1.

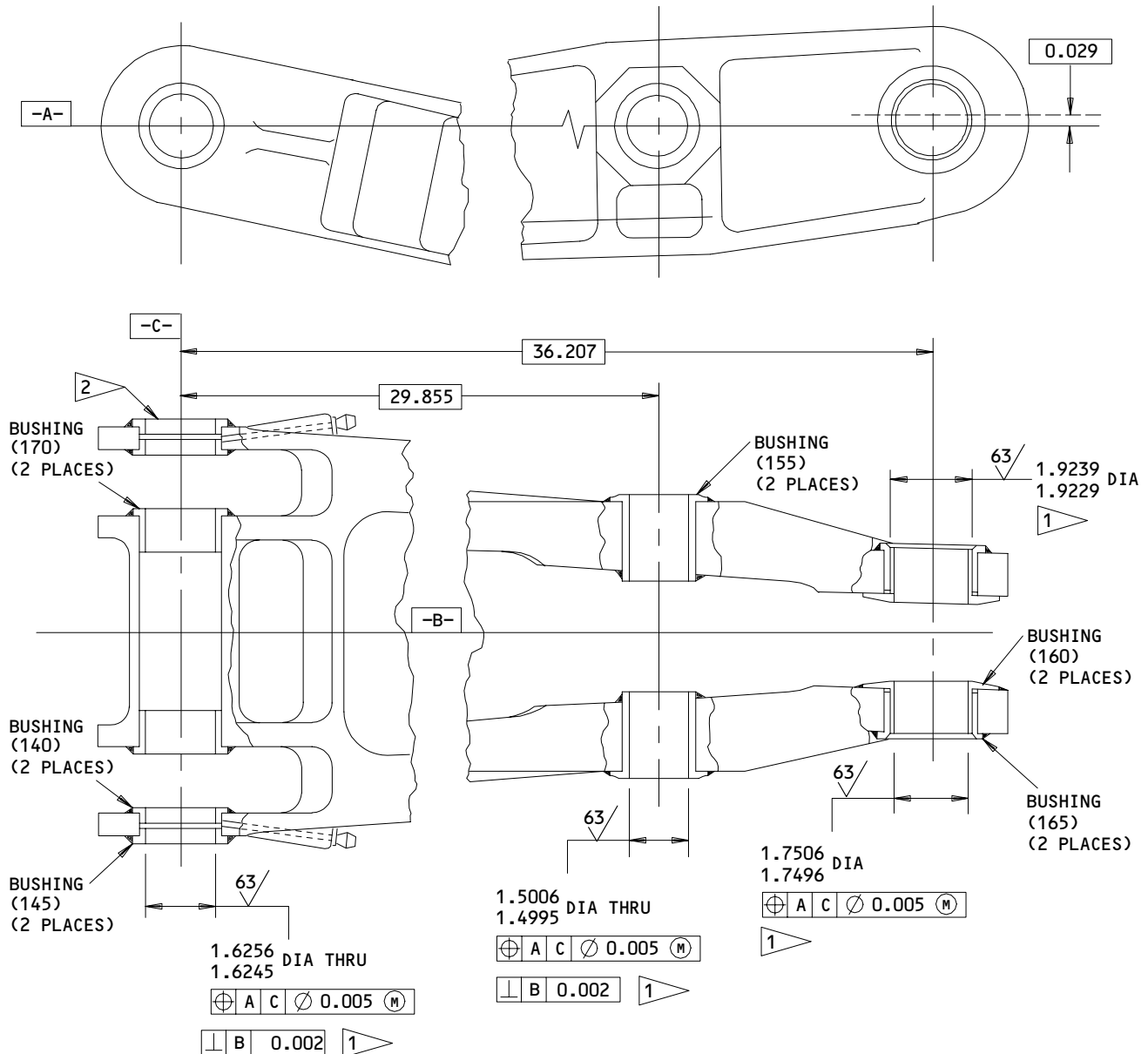
27-51-88

REPAIR 3-1

01

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113T1222-1,-5,-9
 Bushing Replacement
 Figure 601

27-51-88

REPAIR 3-1

01

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SUPPORT BEAM - REPAIR 3-2

113T1222-1, -5, -9

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

1. Installation of Oversize Bushing (Fig. 601)

- A. Machine hole, as required, within repair limits shown to remove defects.
- B. Shot peen as indicated.
- C. Manufacture bushings (Fig. 602), as required, to compensate for amount of material removed.
- D. Install bushing per REPAIR 3-1.

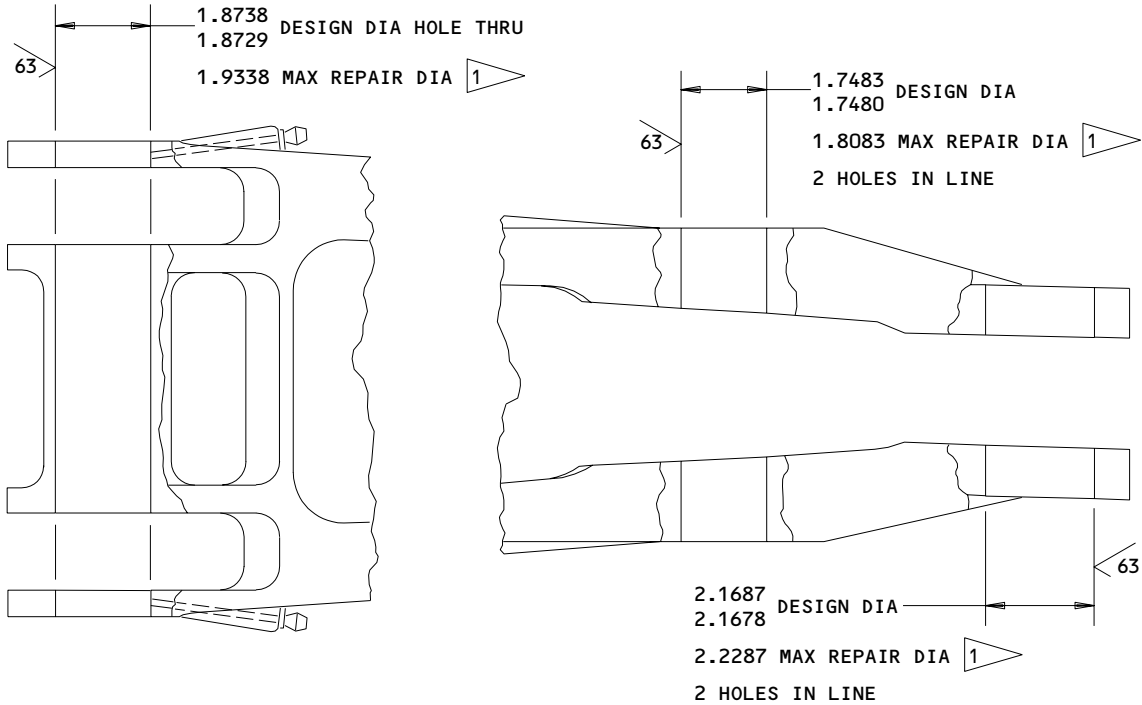
27-51-88

REPAIR 3-2

01

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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 0.04 R
 0.02 R

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

113T1222-1,-5,-9

Beam Repair
 Figure 601

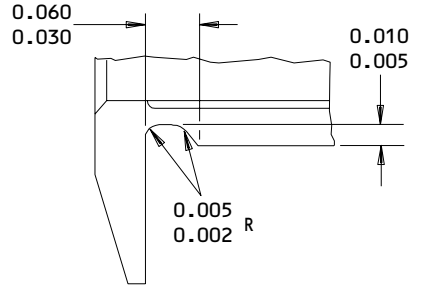
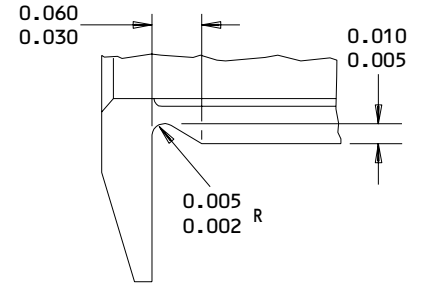
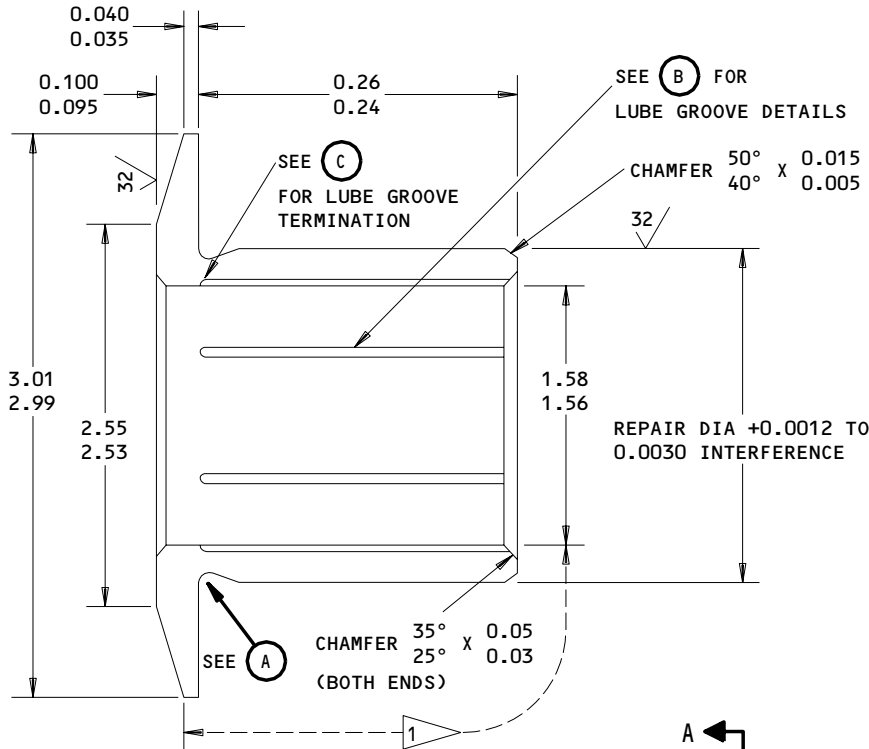
27-51-88

REPAIR 3-2

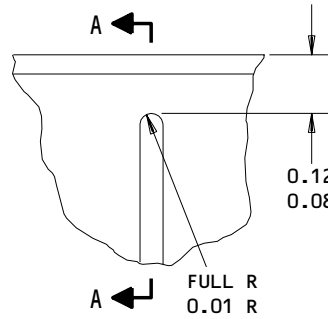
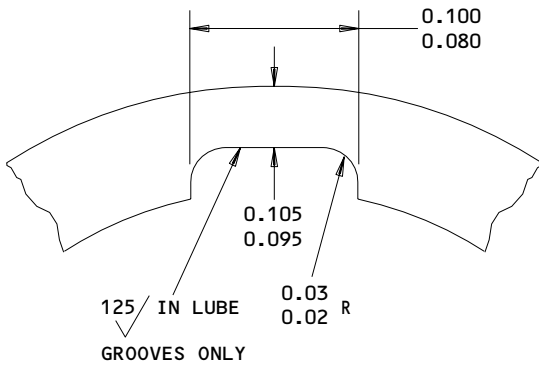
Page 602

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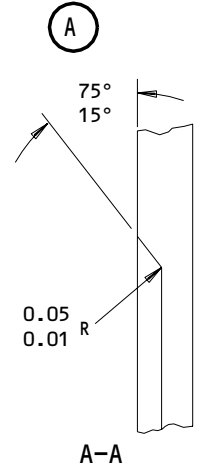
01



UNDERCUT TYPE I OR TYPE II OPTIONAL



LUBE GROOVE TERMINATION DETAIL



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

(B)

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 MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

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 602 (Sheet 1)

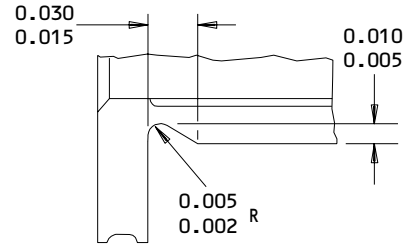
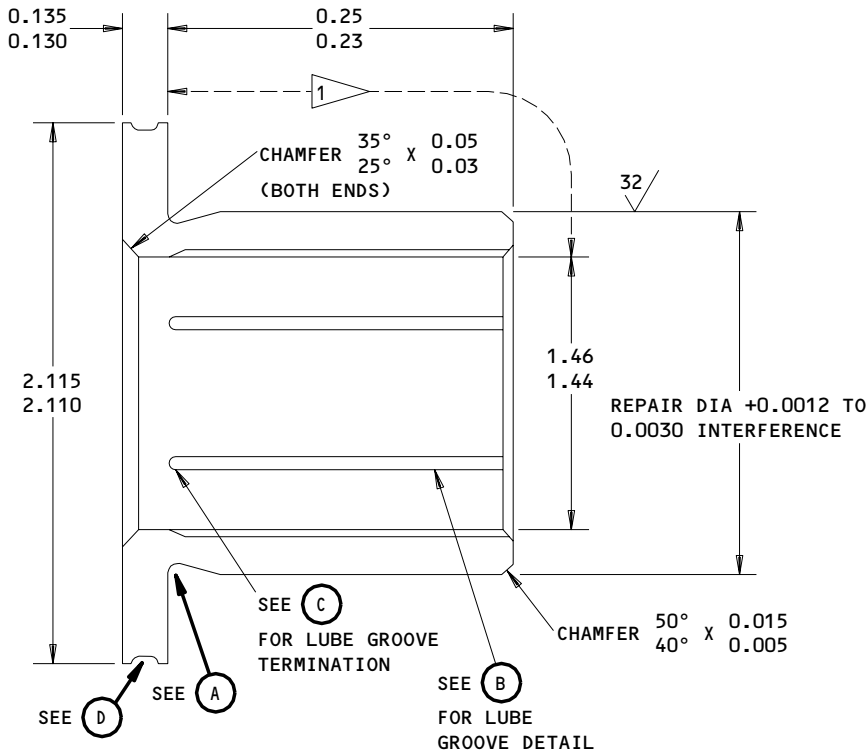
27-51-88

REPAIR 3-2

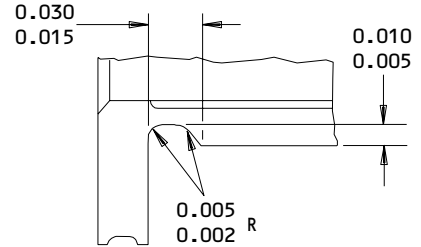
01

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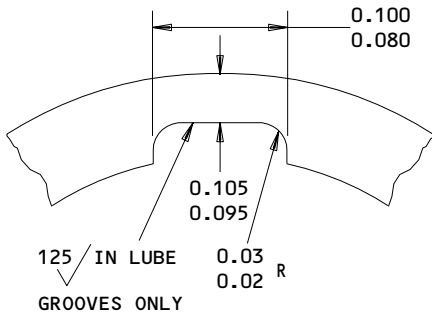
TYPE I



TYPE II

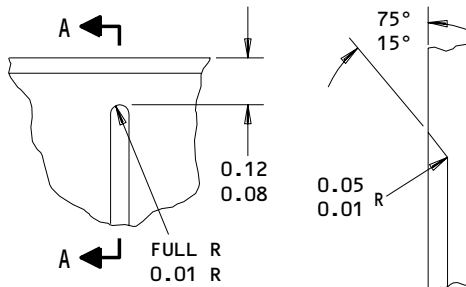
UNDERCUT TYPE I OR
TYPE II OPTIONAL

(A)



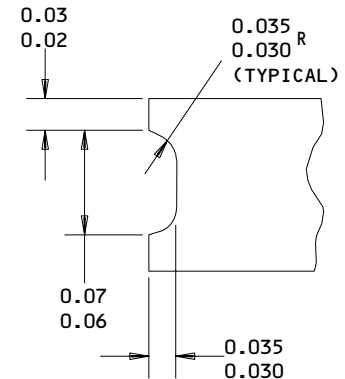
TYPICAL LUBE GROOVE DETAIL
6 GROOVES EQUALLY SPACED ON
INNER FACE OF BUSHING

(B)



LUBE GROOVE TERMINATION DETAIL

(C)



(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 (145)

Oversize Bushing Details
Figure 602 (Sheet 2)

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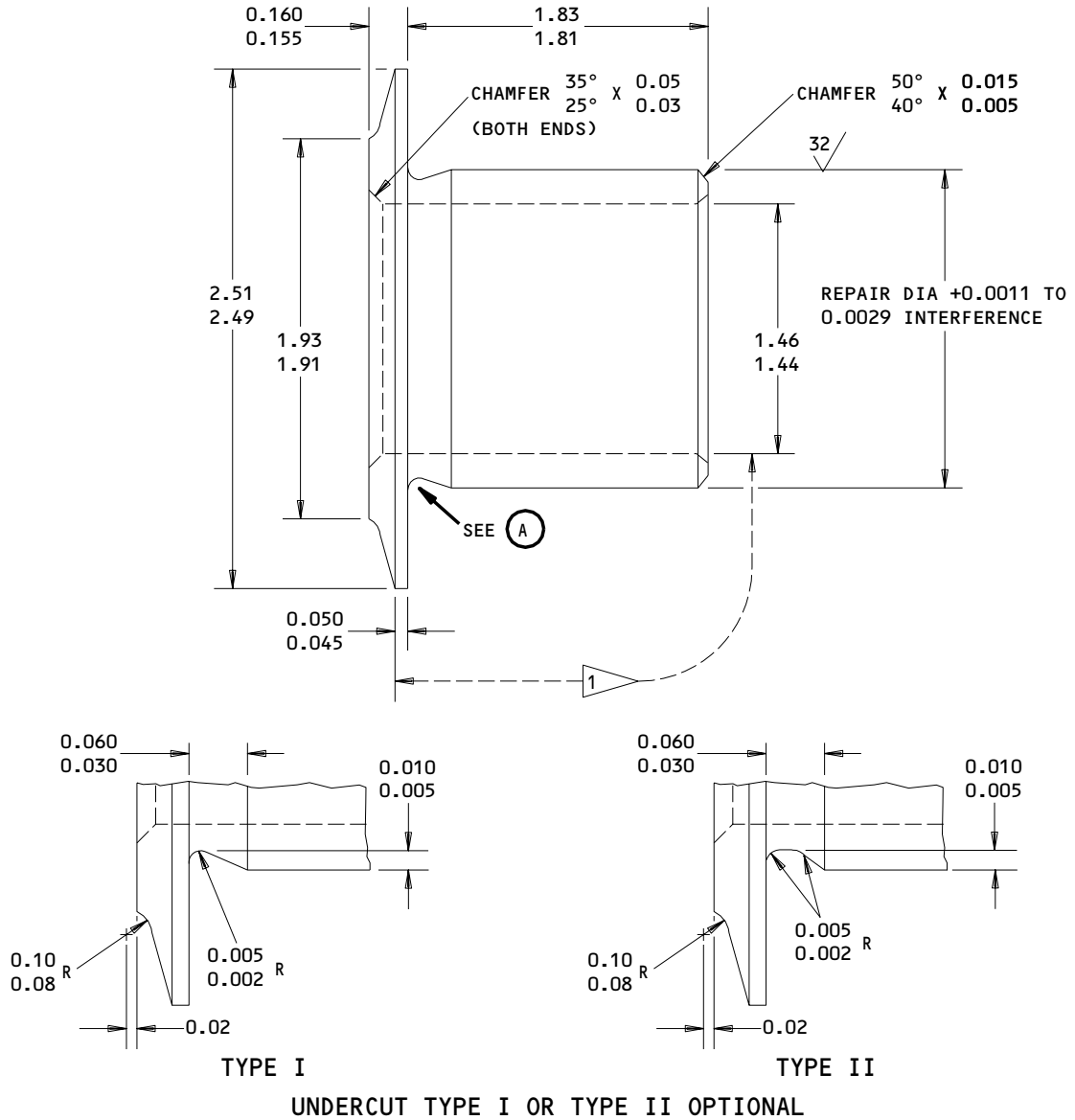
REPAIR 3-2

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01

BOEING
COMPONENT
MAINTENANCE MANUAL



(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

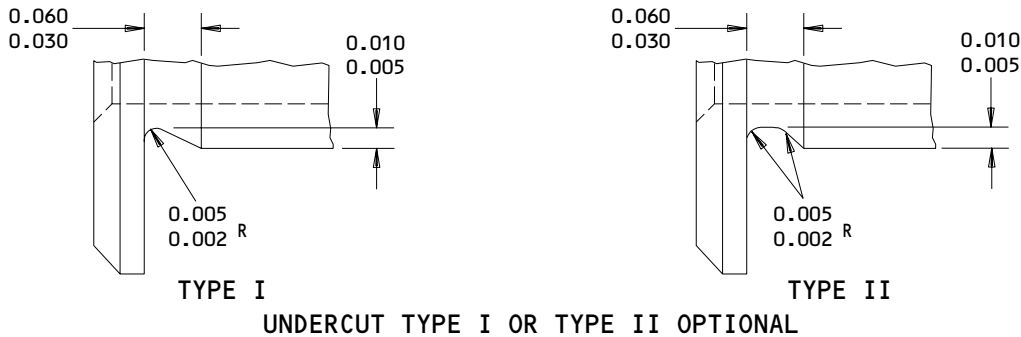
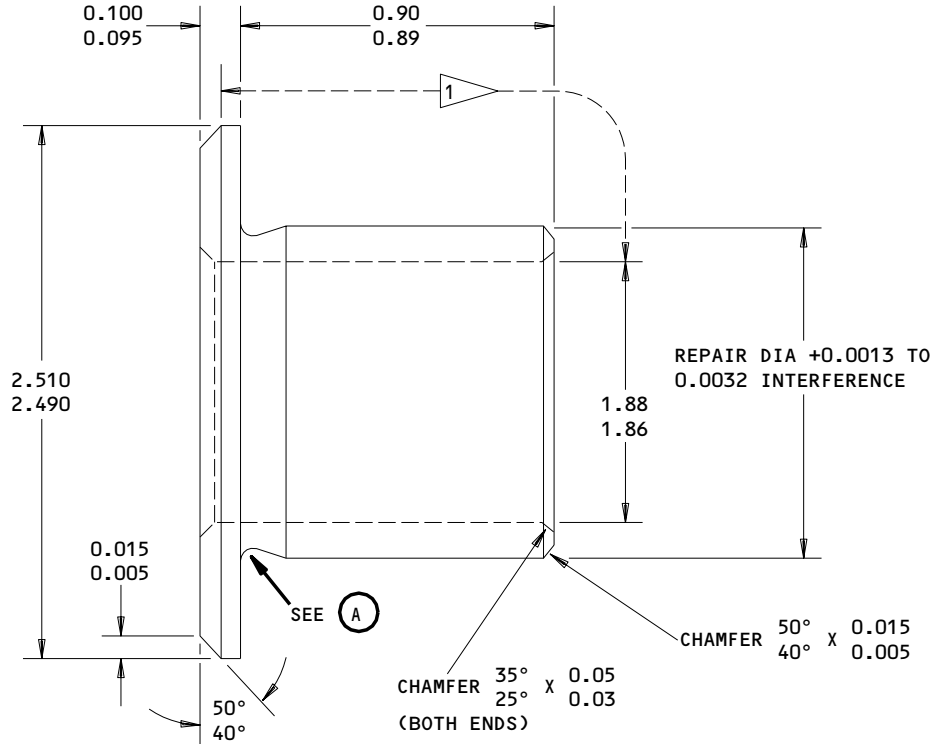
OVERSIZE BUSHING TO REPLACE BUSHING (155)

Oversize Bushing Details
Figure 602 (Sheet 3)

27-51-88

REPAIR 3-2
Page 605
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01



(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 (165)

Oversize Bushing Details
 Figure 602 (Sheet 4)

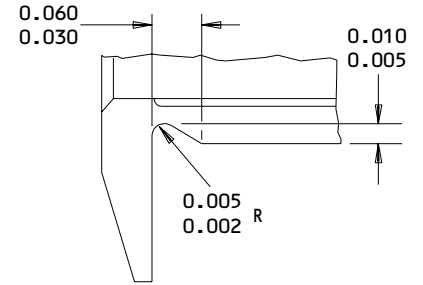
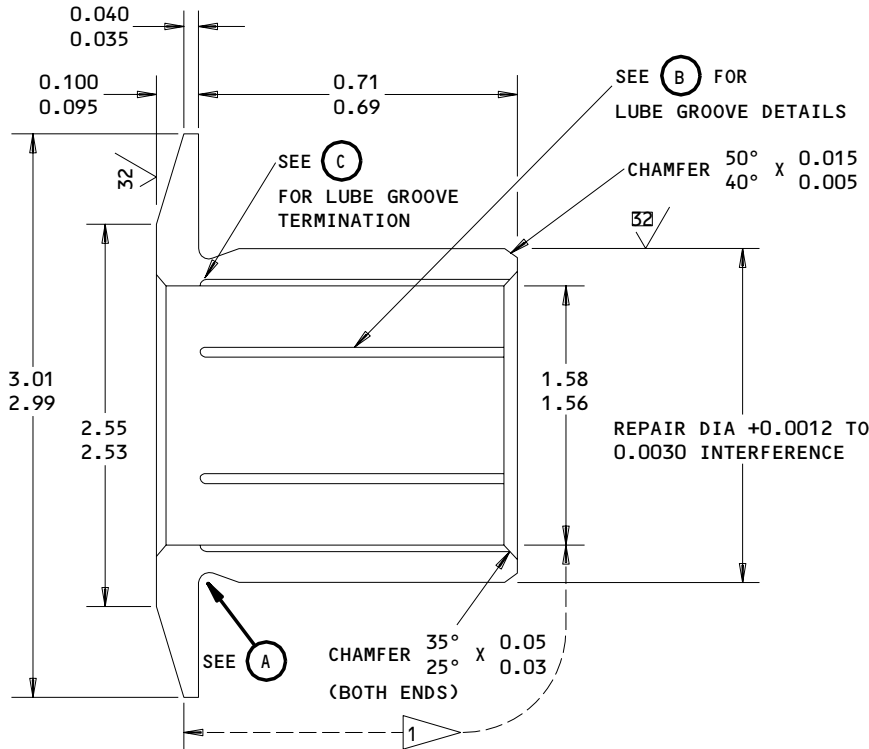
27-51-88

REPAIR 3-2

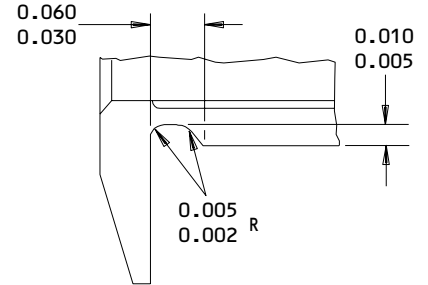
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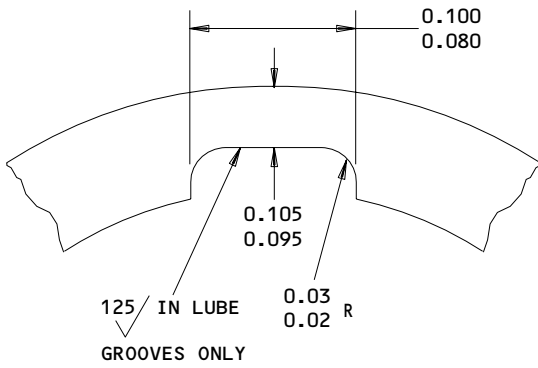


TYPE I



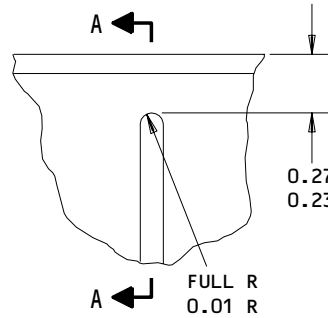
TYPE II

UNDERCUT TYPE I OR TYPE II OPTIONAL



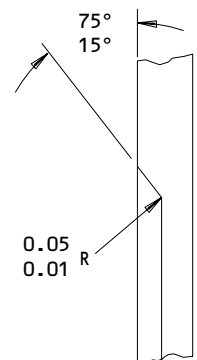
TYPICAL LUBE GROOVE DETAIL
6 GROOVES EQUALLY SPACED ON
INNER FACE OF BUSHING

(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 (170)

Oversize Bushing Details
Figure 602 (Sheet 5)

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REPAIR 3-2

01

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LINK ASSEMBLY - SUPPORT - REPAIR 4-1

113T1229-1, -2, -5, -6

NOTE: Refer to REPAIR-GEN for list of applicable standard practices. For repair of link (290,295) which may only require stripping and restoration of the original finish, refer to Refinish instructions, Fig. 601.

1. Bushing Replacement (Fig. 601)

- A. Remove bushings (300 thru 325) and spacer (330).
- B. Install new bushings and new spacer 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. Check dimensions and machine as necessary.
- D. Seal bushings per REPAIR 18-1.

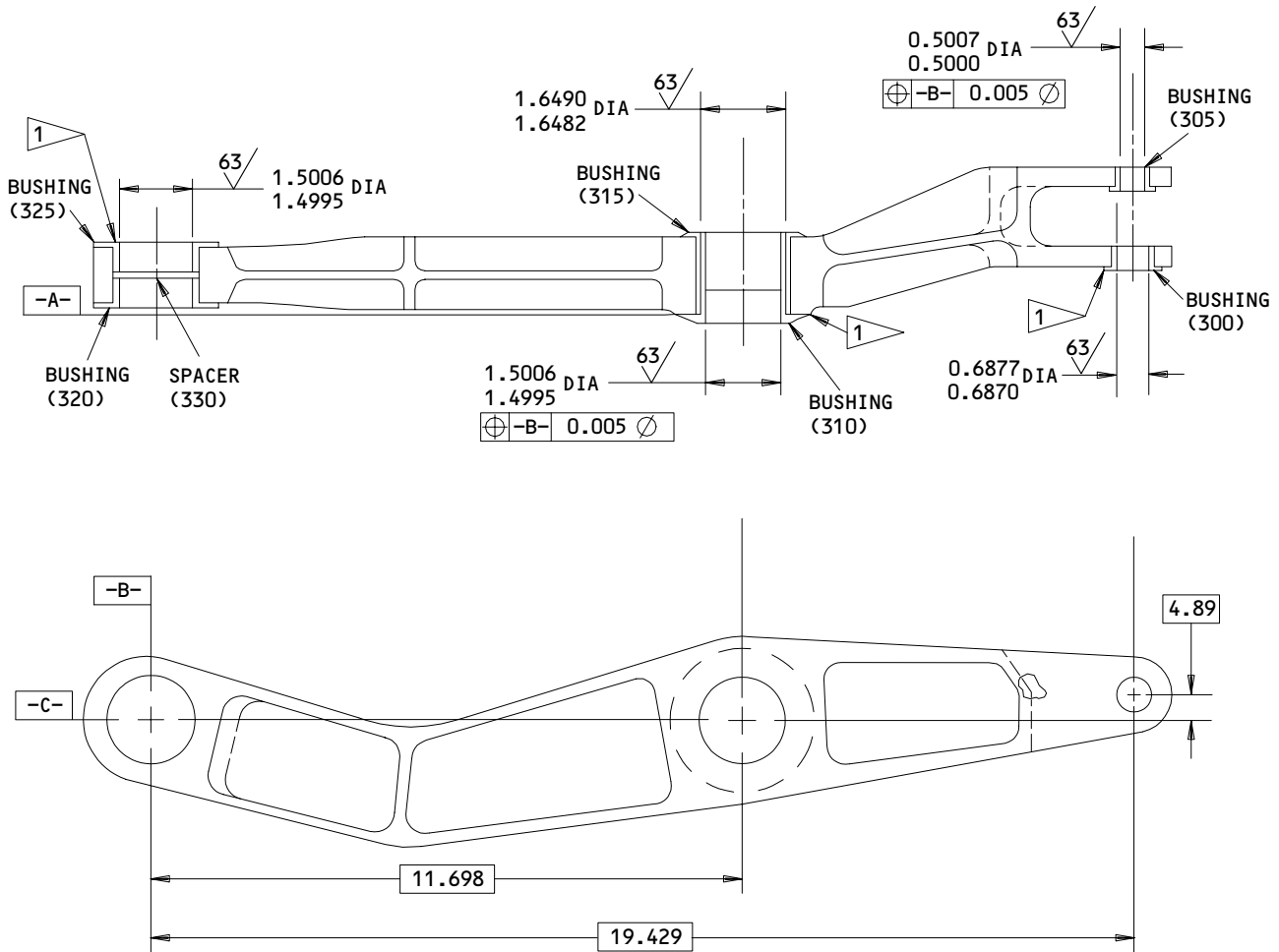
27-51-88

REPAIR 4-1

01

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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

ALL DIMENSIONS ARE IN INCHES

113T1229-1,-2,-5,-6
 Bushing Replacement
 Figure 601

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REPAIR 4-1

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SUPPORT LINK - REPAIR 4-2

113T1229-3, -4, -7, -8

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

1. Installation of Oversize Bushing (Fig. 601)

- A. Machine hole, as required, within repair limits shown to remove defects.
- B. Shot peen as indicated.
- C. Manufacture bushings (Fig. 602), as required, to compensate for amount of material removed.
- D. Install bushing per REPAIR 4-2.

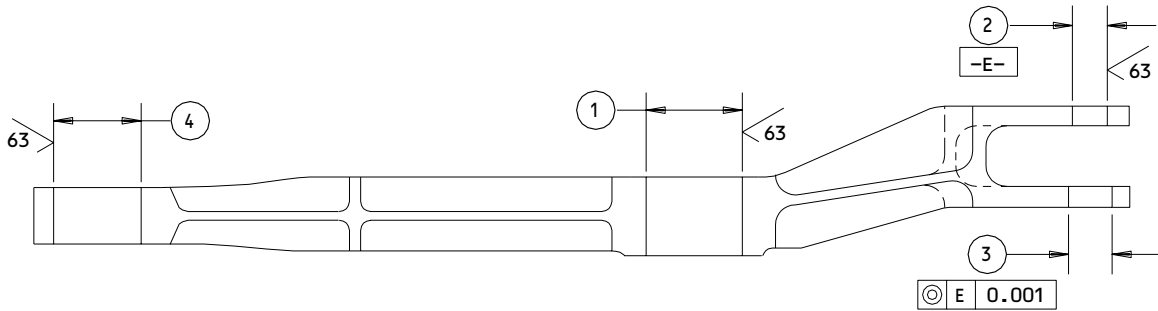
27-51-88






REPAIR 4-2

01

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
HOLE LOCATION	DESIGN DIA	MAX REPAIR DIA 
	1.8589 1.8580	1.9189
	0.6257 0.6250	0.6857
	0.8132 0.8125	0.8732
	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

 REPAIR DIA FOR INSTALLATION OF OVERSIZE BUSHING

REPAIR

REF 

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 R
 0.02

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

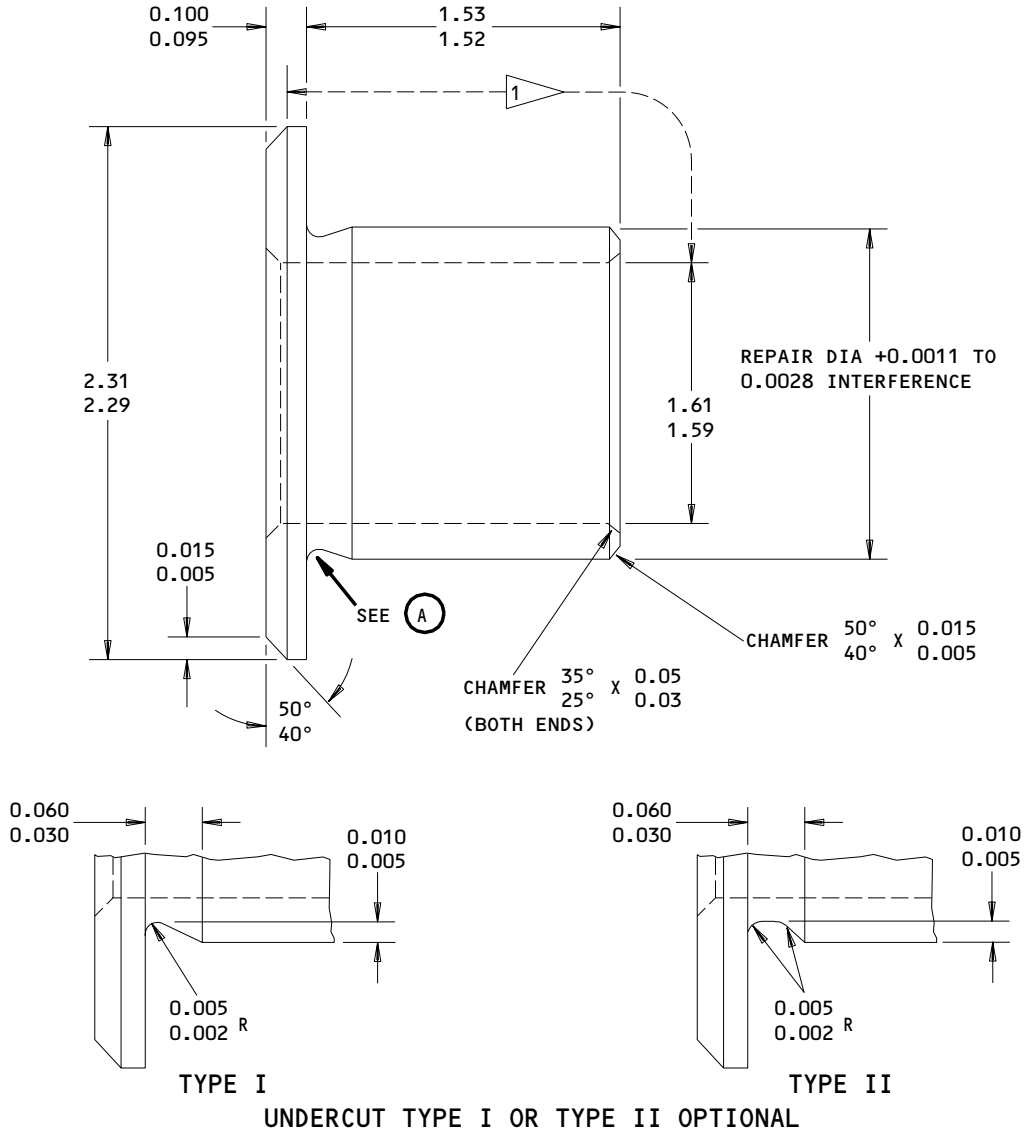
113T1229-3,-4,-7,-8

Link Repair
 Figure 601

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REPAIR 4-2
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01



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 602 (Sheet 1)

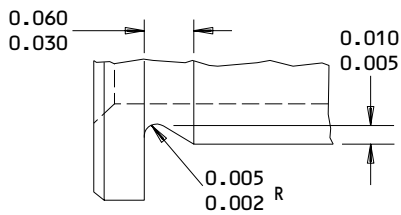
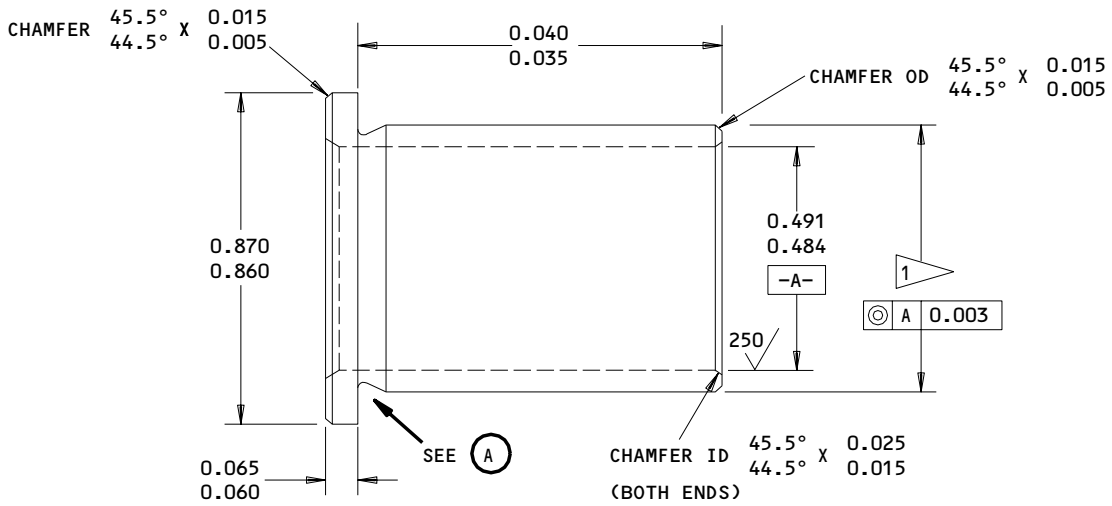
27-51-88

REPAIR 4-2

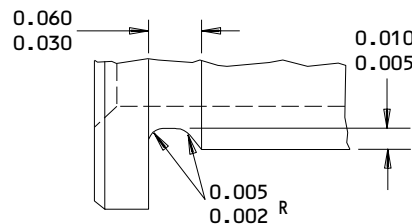
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TYPE I



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: 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 602 (Sheet 2)

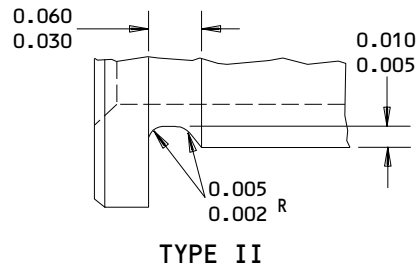
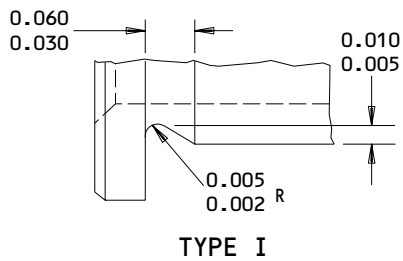
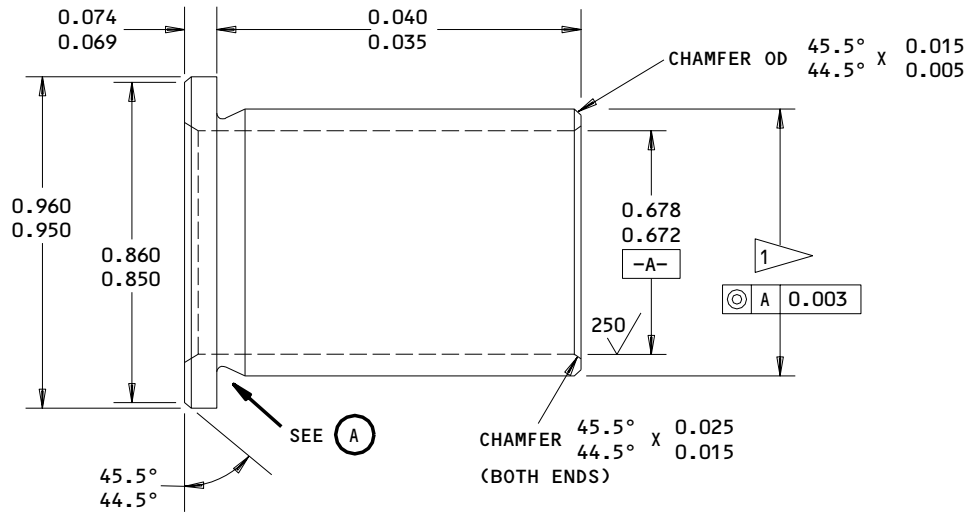
27-51-88

REPAIR 4-2

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01



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 602 (Sheet 3)

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REPAIR 4-2

01

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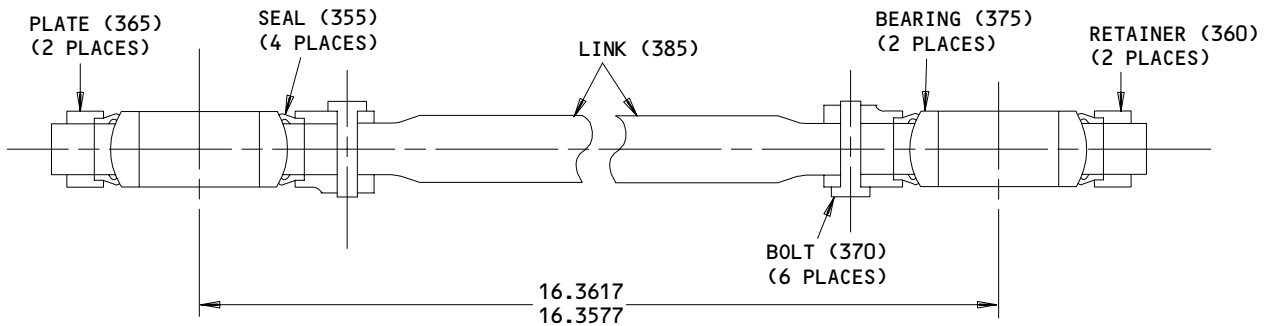
LINK ASSEMBLY - SUPPORT - REPAIR 5-1

113T1225-1

NOTE: Refer to REPAIR-GEN for list of applicable standard practices. For repair of link (350) which may only require stripping and restoration of the original finish, refer to Refinish Instructions, Fig. 601.

1. Bearing Replacement

- A. Remove bolts (370).
- B. Remove bearing retainers (360, 365).
- C. Remove bearings (375) and seals (355).
- D. Install new bearings and seals (Ref 20-50-03).
- E. Apply BMS 5-95 sealant to faying surface between bearing retainers (360, 365) and link (385). Make sure that sealant does not contaminate bearing.
- F. Install bearing retainers.
- G. Install bolts and lockwire.



REFINISH

LINK (385):

APPLY 1 COAT OF PRIMER, BMS 10-11, TYPE 1 (F-20.02) ALL OVER EXCEPT OMIT PRIMER IN THREADED HOLES AND BEARING BORES.
AFTER BEARING INSTALLATION, APPLY ENAMEL, BMS 10-60 (SRF-14.9813) ALL OVER EXCEPT ON BEARINGS AND LUBE FITTINGS.

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

ALL DIMENSIONS ARE IN INCHES

Bearing Replacement and Link Refinish
Figure 601

27-51-88

REPAIR 5-1

01.1

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BEAM ASSEMBLY - SUPPORT - REPAIR 6-1

113T1226-17 THRU -20, -25 THRU -28

NOTE: Refer to REPAIR-GEN for list of applicable standard practices. For repair of beam (420, 421) which may only require stripping and restoration or the original finish, refer to Refinish instructions, Fig. 601.

1. Bushing Replacement (Fig. 601)

- A. Remove bushings.
- B. Install new bushings using shrink fit method except use wet BMS 5-95 sealant (Ref 20-50-03).
- C. Check dimensions and machine as necessary.
- D. Seal bushings per REPAIR 18-1.

2. Bearing Replacement

- A. Remove bolts (435).
- B. Remove bearing retainers (425, 430).
- C. Remove bearings (440, 465) and seals (422).
- D. Install new bearings and seals (Ref 20-50-03).
- E. Install bearing retainers.
- F. Install bolts.

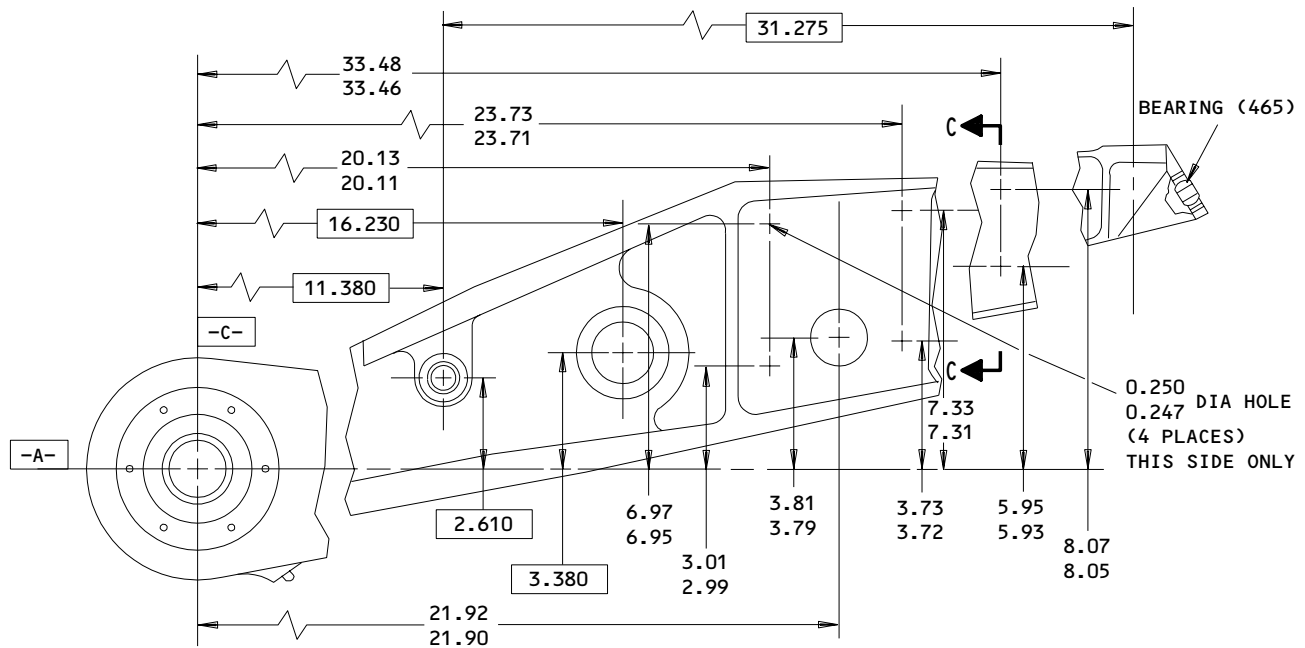
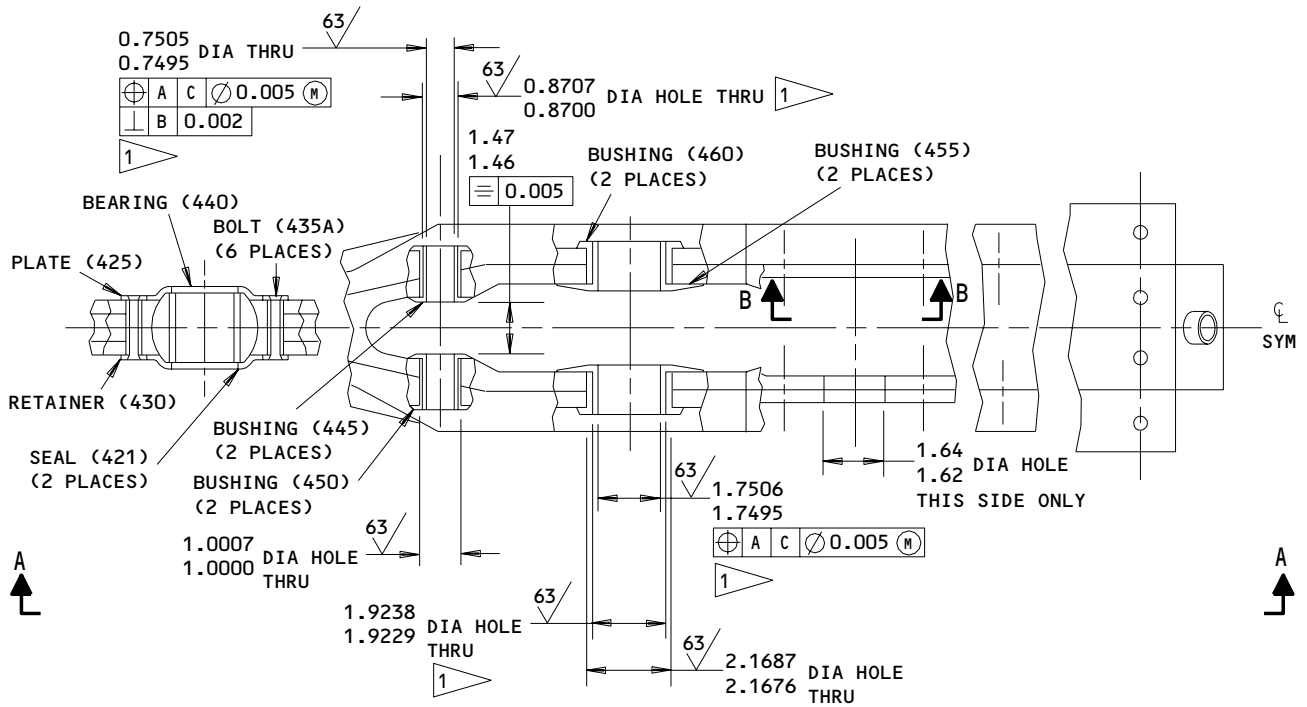
27-51-88

REPAIR 6-1

01

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A-A

113T1226-17,-19,-25,-27 (SHOWN)
 113T1226-18,-20,-26,-28 (OPP)

Parts Replacement and Beam Refinish
 Figure 601 (Sheet 1)

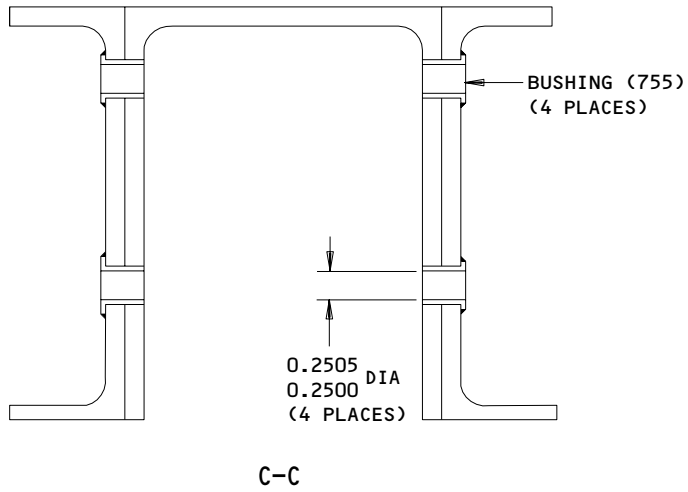
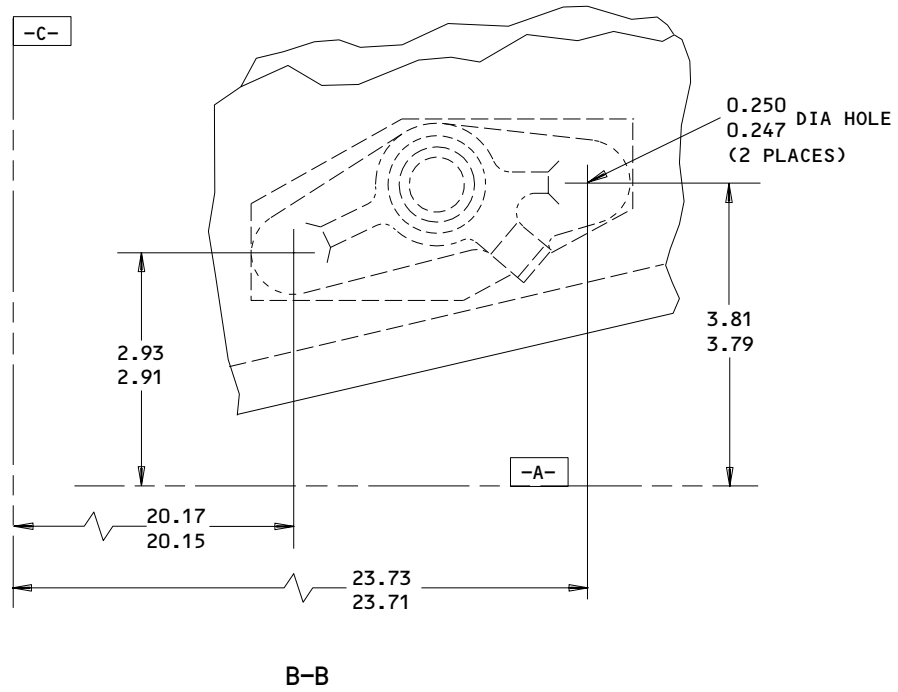
27-51-88

REPAIR 6-1

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01



REFINISH

ALL DIMENSIONS ARE IN INCHES

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

113T1226-17,-19,-25,-27 (SHOWN)
 113T1226-18,-20,-26,-28 (OPP)
 Parts Replacement and Beam Refinish
 Figure 601 (Sheet 2)

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REPAIR 6-1
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01

BEAM - REPAIR 6-2

113T1226-17 thru -20, -25 thru -28

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

1. Installation of Oversize Bushing (Fig. 601)

- A. Machine hole, as required, within repair limits shown to remove defects.
- B. Shot peen as indicated.
- C. Manufacture bushings (Fig. 602), as required, to compensate for amount of material removed.
- D. Install bushing per REPAIR 6-1.

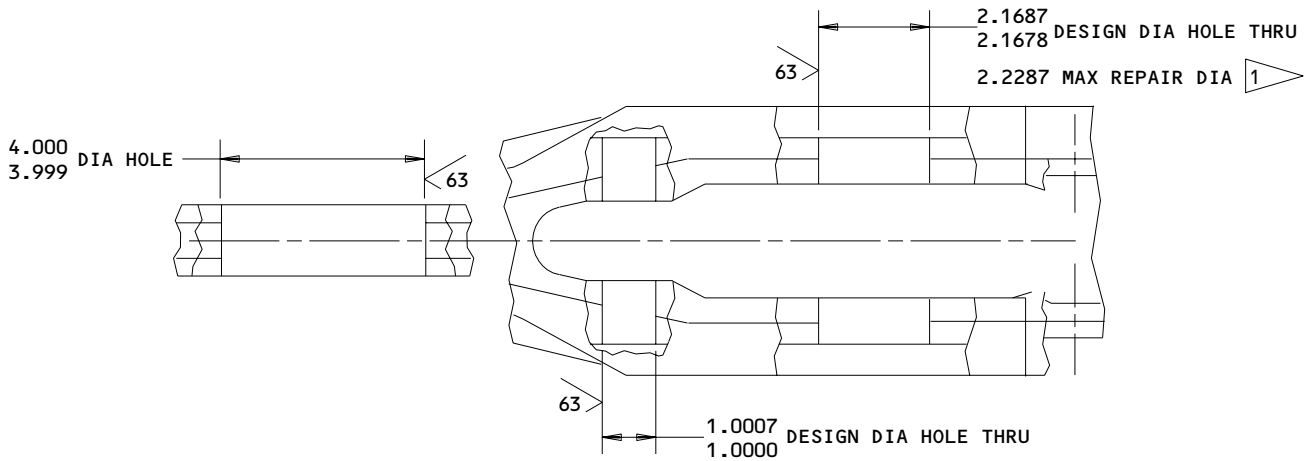
27-51-88

REPAIR 6-2

01

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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 0.04
 0.02 R

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

113T1226-17 THRU -20,-25 THRU -28

Beam Repair
 Figure 601

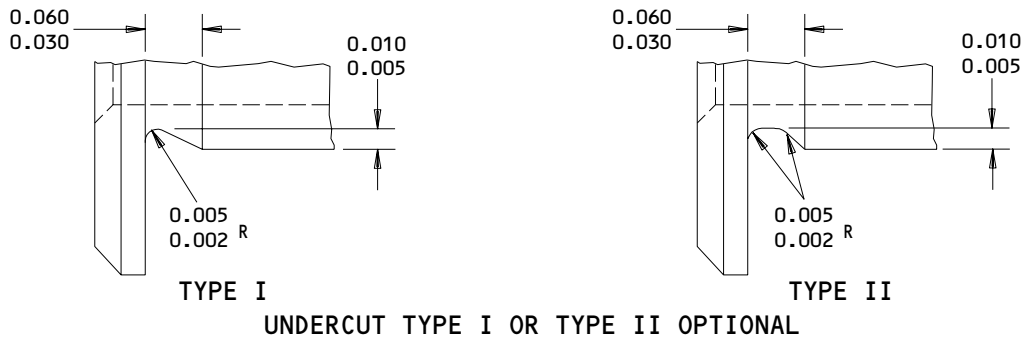
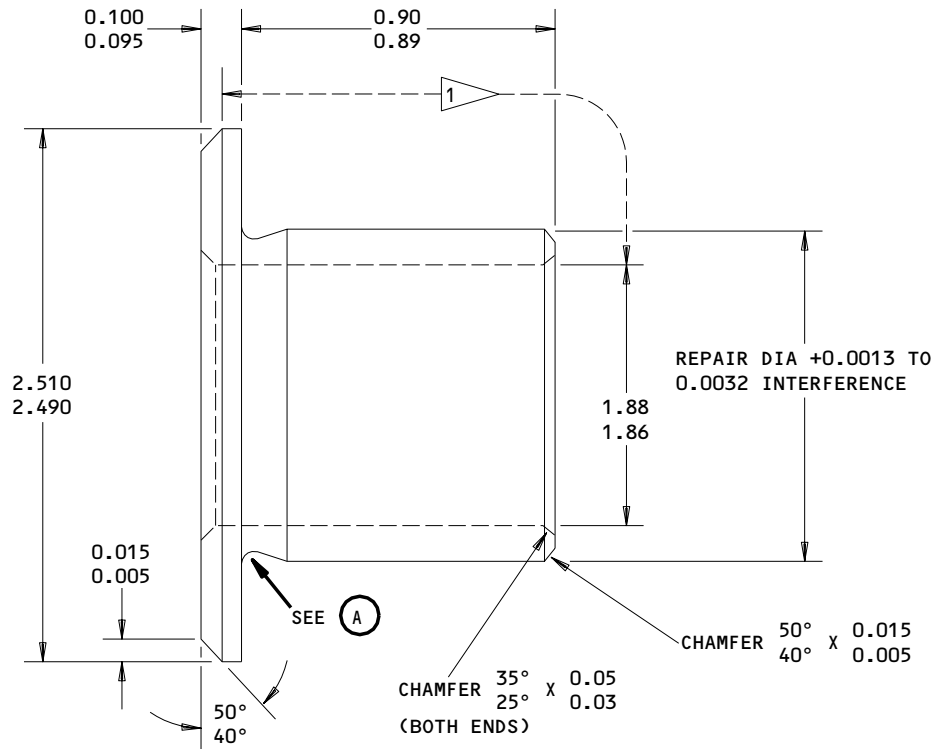
27-51-88

REPAIR 6-2

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(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 Details
Figure 602

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REPAIR 6-2

01

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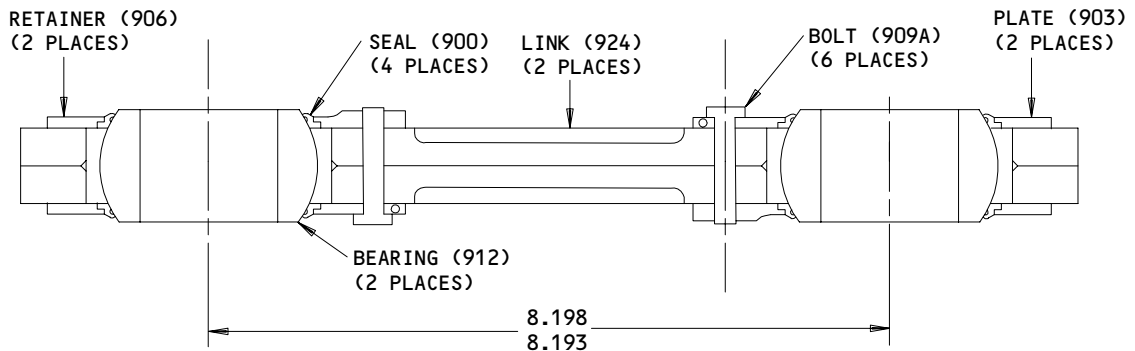
LINK ASSEMBLY - SUPPORT - REPAIR 7-1

113T1224-1

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

- A. Remove bolts (909A), plates (903), retainers (906).
- B. Remove bearings (912) and seals (900).
- C. Install new bearings and seals (Ref 20-50-03).
- D. Apply BMS 5-95 sealant to faying surface between retainers (906) and link (924), and to faying surface between plates (903) and link (924). Make sure that sealant does not cause blockage of the lubricant path. Make sure that sealant does not contaminate bearing.
- E. Install bearing retainers (906), plates (903) and bolts (909). Lockwire bolts to plates per 20-50-02.



REFINISH

ALL DIMENSIONS ARE IN INCHES

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

Bearing Replacement and Link Refinish
Figure 601

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REPAIR 7-1

01.1

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LINK ASSEMBLY - SUPPORT DRIVE - REPAIR 8-1

113T1221-13 THRU -15

NOTE: Refer to REPAIR-GEN for 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)

- A. Remove bushings.
- B. Install new bushings using shrink fit method except use wet BMS 5-95 sealant (Ref 20-50-03).
- C. Check dimensions and machine as necessary.
- D. Seal bushings per REPAIR 18-1.

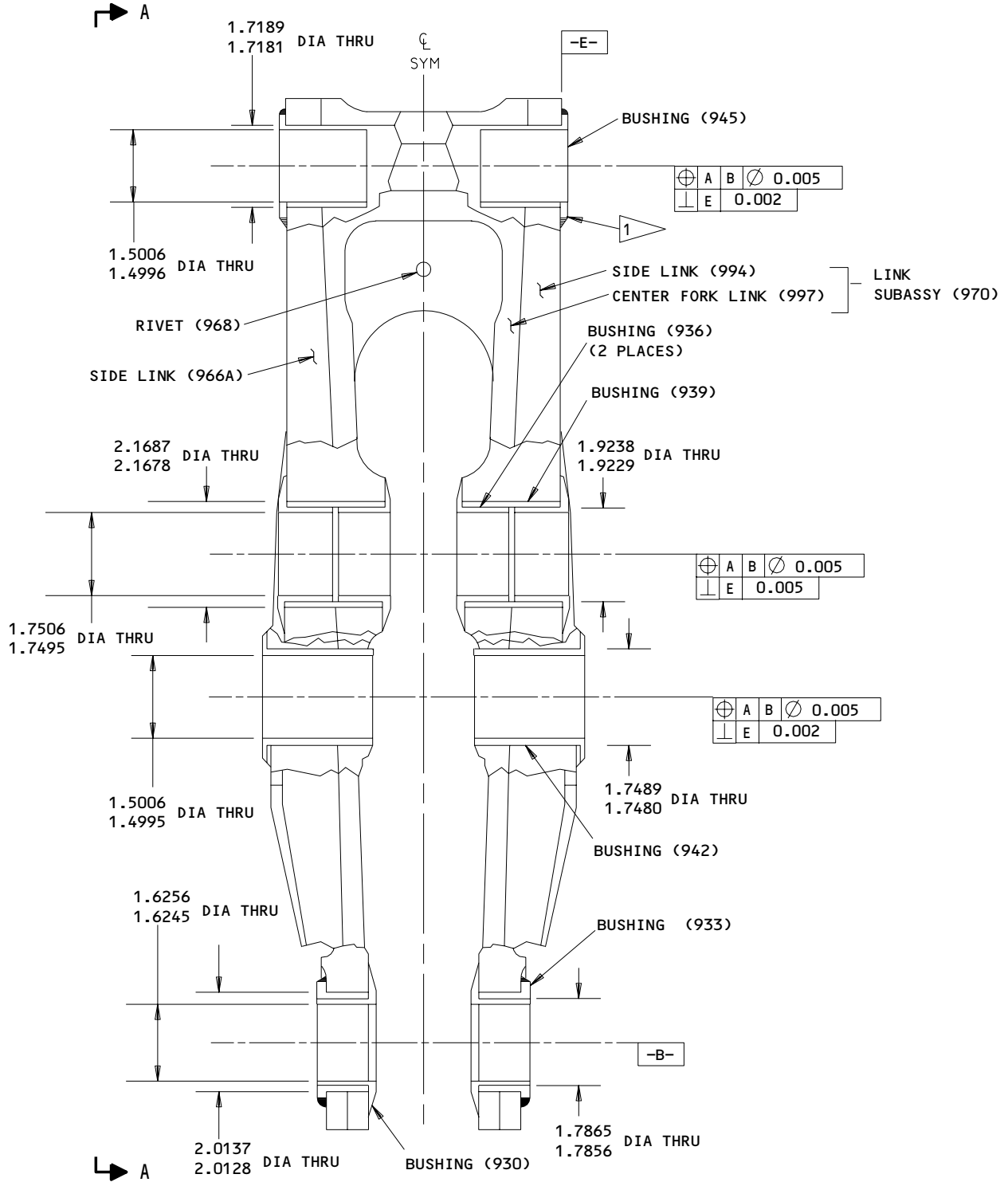
27-51-88

REPAIR 8-1

01

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ALL DIMENSIONS ARE IN INCHES
 ITEM NUMBERS REFER TO IPL FIG.1

113T1221-13,-14,-15
 Bushing Replacement and Link Refinish
 Figure 601 (Sheet 1)

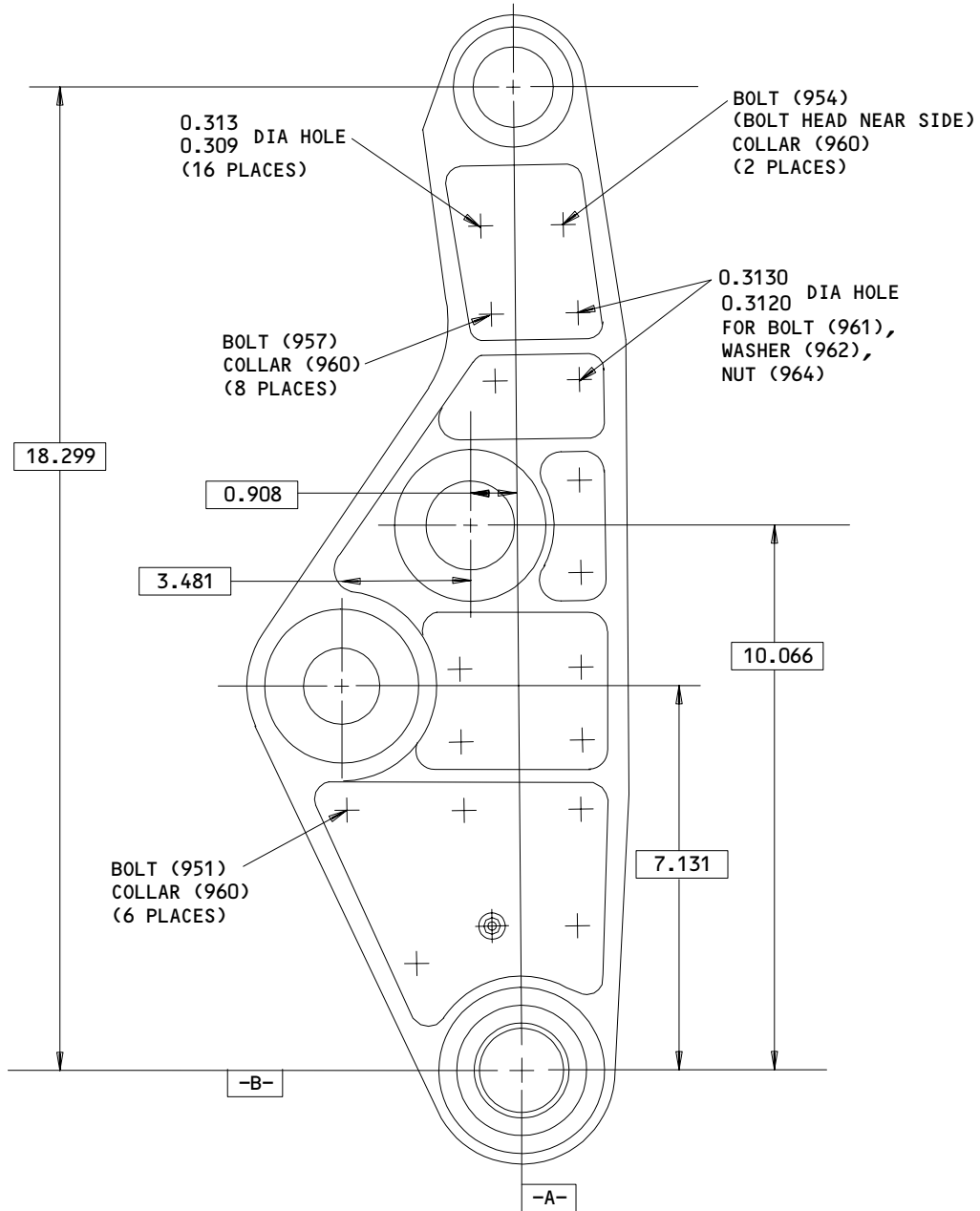
27-51-88

REPAIR 8-1

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REFINISH

SIDE LINK (966A) -- CHROMIC ACID ANODIZE AND APPLY 1 COAT OF PRIMER (F-18.13) ALL OVER

LINK ASSY (927B) -- 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

A-A

63/ MACHINED SURFACES IN BORES

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

ITEM NUMBERS REFER TO IPL FIG. 1

113T1221-13,-14,-15
Bushing Replacement and Link Refinish
Figure 601 (Sheet 2)

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REPAIR 8-1

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SUPPORT LINK - REPAIR 8-2

113T1221-13 thru -15

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

1. Installation of Oversize Bushing (Fig. 601)

- A. Machine hole, as required, within repair limits shown to remove defects.
- B. Shot peen as indicated.
- C. Manufacture bushings (Fig. 602), as required, to compensate for amount of material removed.
- D. Install bushing per REPAIR 8-1.

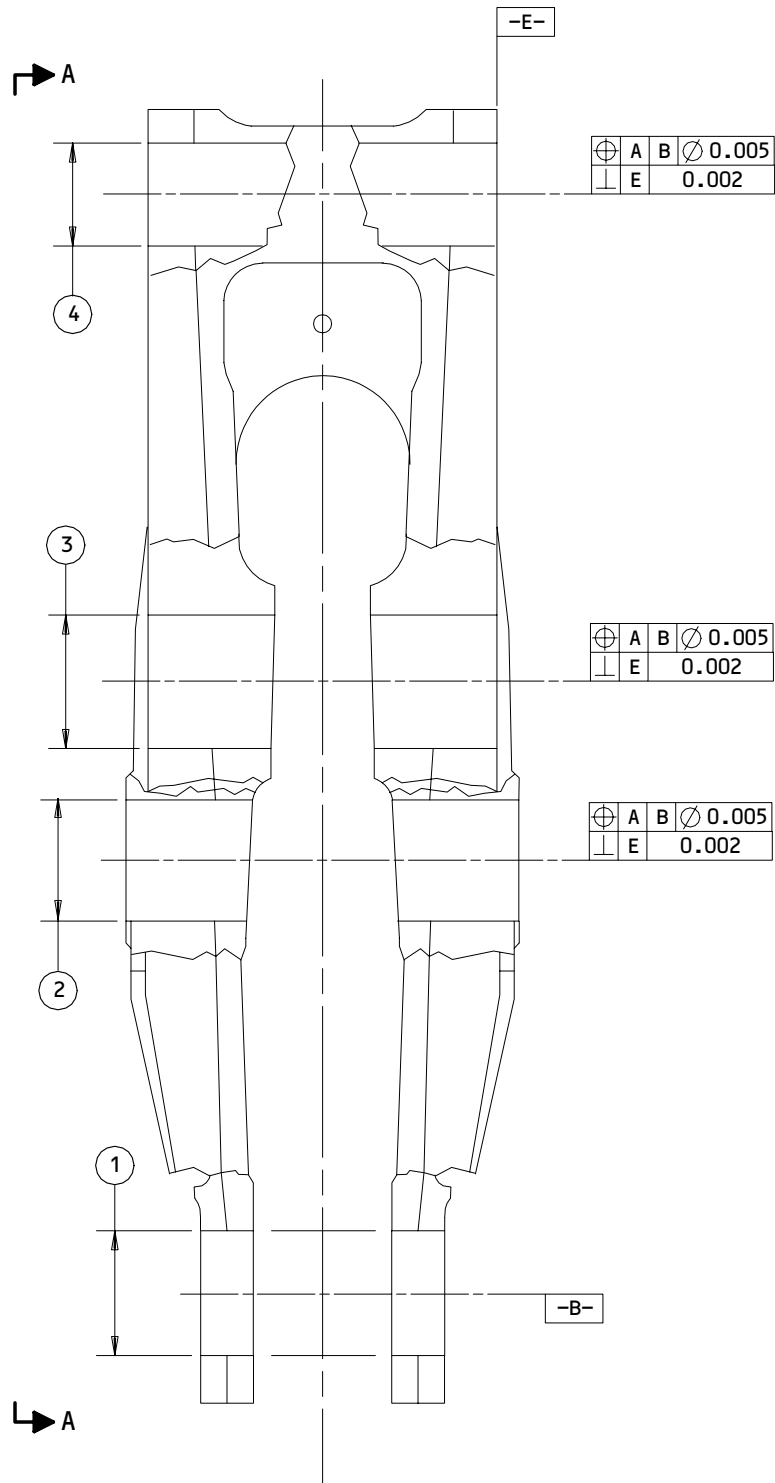
27-51-88

REPAIR 8-2

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113T1221-13,-14,-15

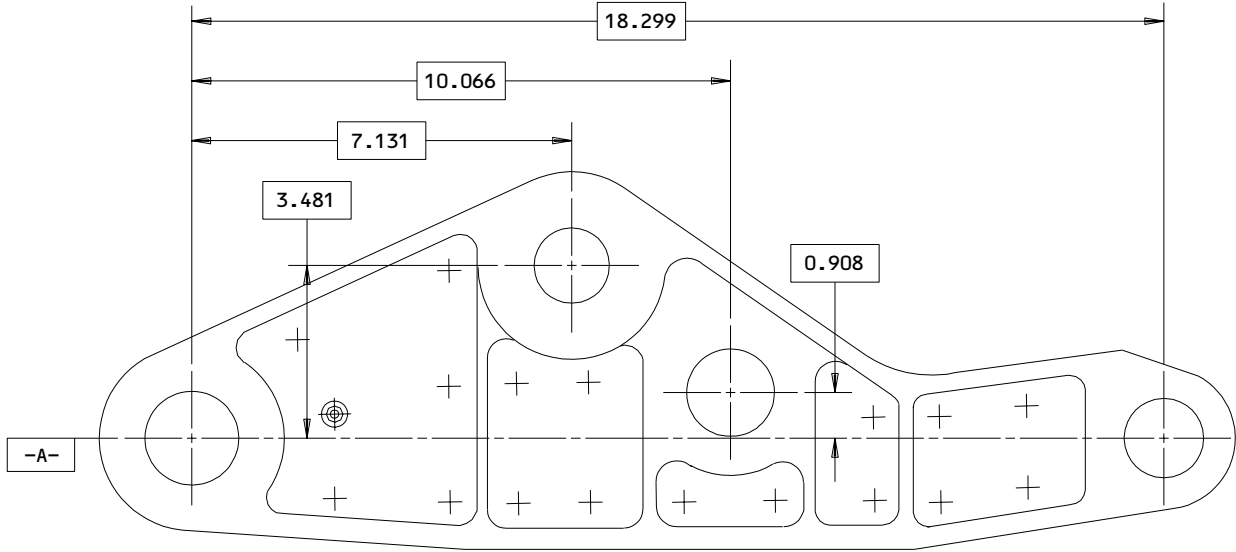
Link Repair
 Figure 601 (Sheet 1)

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REPAIR 8-2
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181129



A-A
(ROTATE 90°CW)

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

① REPAIR LIMITS FOR INSTALLATION OF
OVERSIZE BUSHINGS

REPAIR

REF ①

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

63/ MACHINED SURFACES IN BORES

BREAK SHARP EDGES 0.05
0.03 R

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

113T1221-13,-14,-15

Link Repair
Figure 601 (Sheet 2)

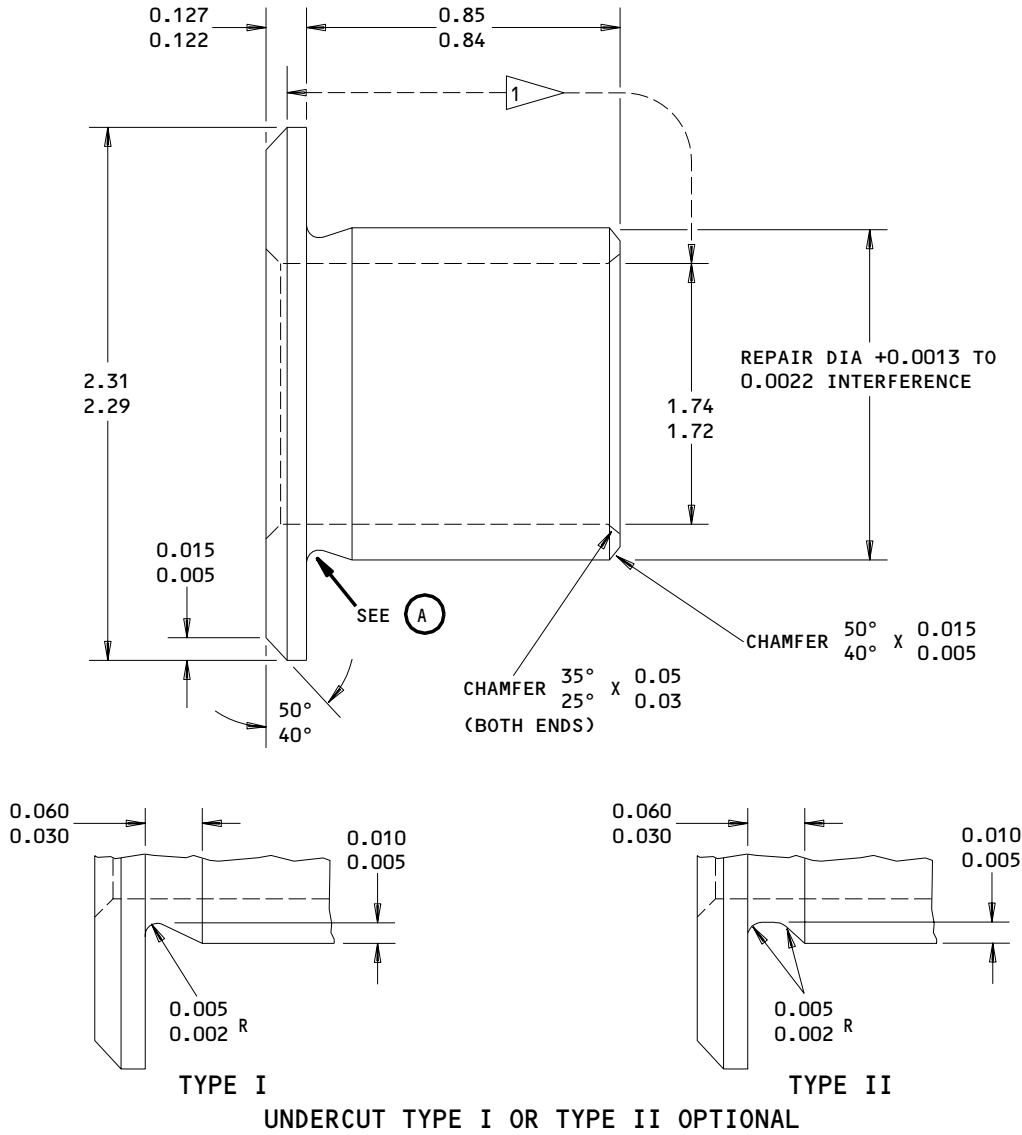
27-51-88

REPAIR 8-2

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(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 602 (Sheet 1)

27-51-88

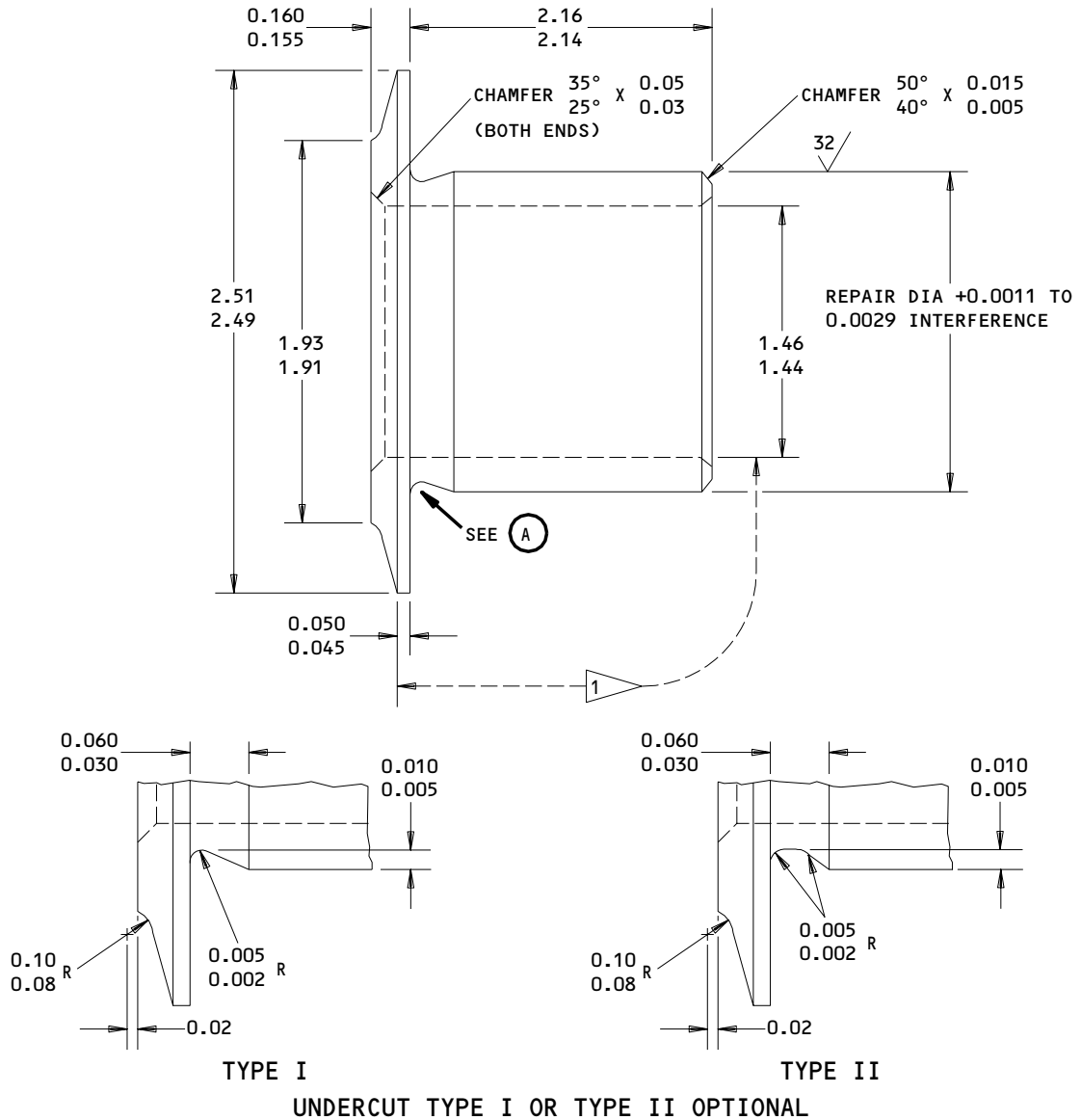
REPAIR 8-2

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BOEING
COMPONENT
MAINTENANCE MANUAL



(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 602 (Sheet 2)

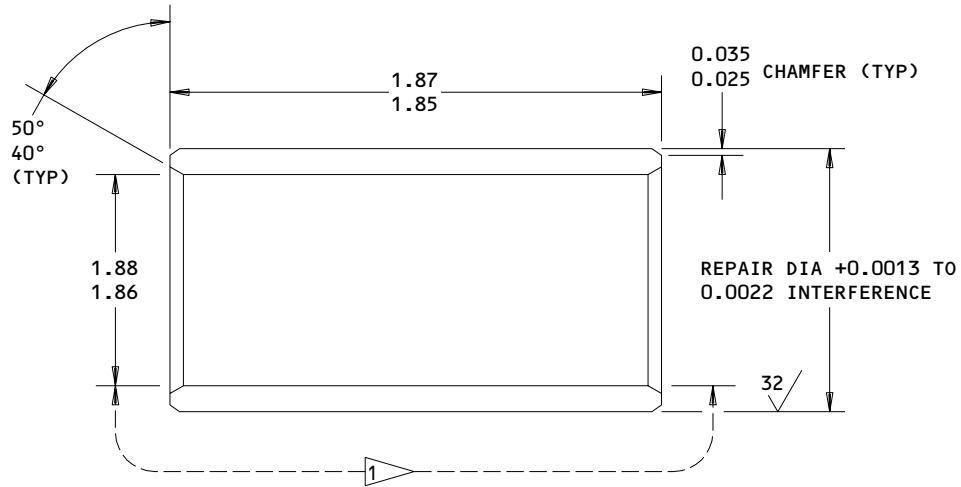
27-51-88

REPAIR 8-2

01

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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 602 (Sheet 3)

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REPAIR 8-2

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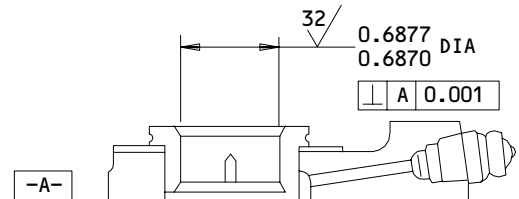
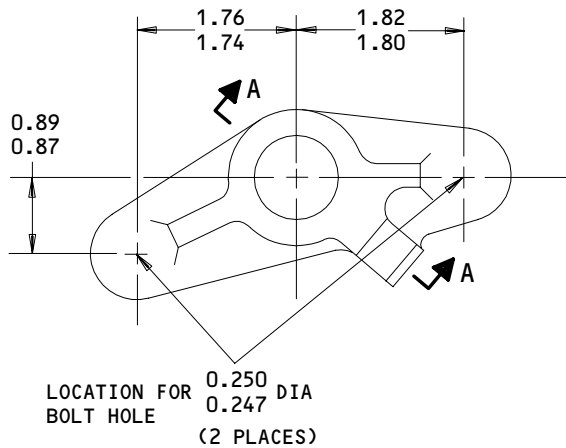
FITTING ASSEMBLY - REPAIR 9-1

113T1719-1, -2

NOTE: Refer to REPAIR-GEN for list of applicable standard practices. For repair of fitting (715, 718, IPL Fig. 1) 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 bushing and spacer.
- B. Install new spacer with wet sealant, BMS 5-95. Wipe all excess sealant from edges of spacer then install bushing with grease, MIL-G-23827 per 20-50-03.
- C. Check dimension and machine bushing to dimension and finish as shown.



A-A

REFINISH

FITTING (715):
CHROMIC ACID ANODIZE AND
APPLY 1 COAT OF PRIMER,
BMS 10-11, TYPE 1 (F-18.03)
ALL OVER EXCEPT OMIT PRIMER
ON ALL HOLES

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

Bushing Replacement and Fitting Refinish
Figure 601

27-51-88

REPAIR 9-1

01

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FITTING ASSEMBLY - REPAIR 10-1

113T1739-1, -2
113T1009-1, -2

NOTE: Refer to REPAIR-GEN for list of applicable standard practices. For repair of fitting (655, 660, 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 bushing and spacer.
- B. Install new spacer and bushing with wet sealant, BMS 5-95 per 20-50-03. Fillet seal edges of spacer only with sealant. Remove excess sealant from exposed surfaces of bushing, spacer and lube passage.
- C. Check dimension and machine bushing to dimension and finish shown.

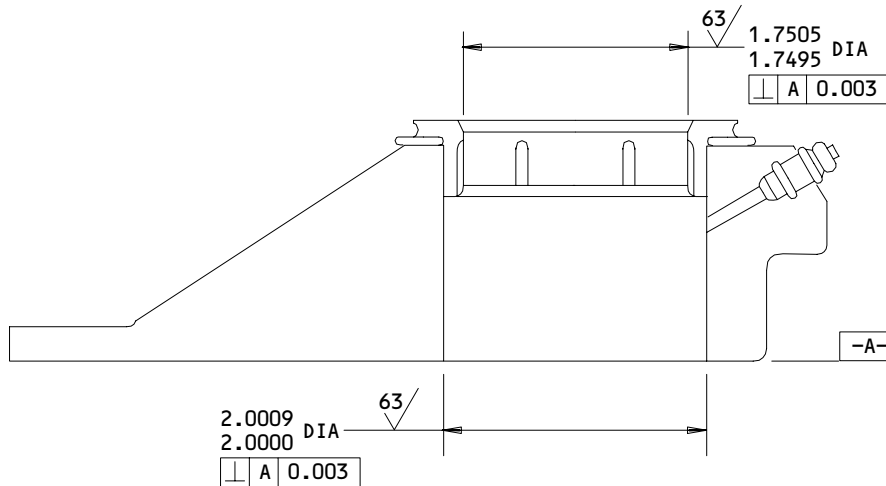
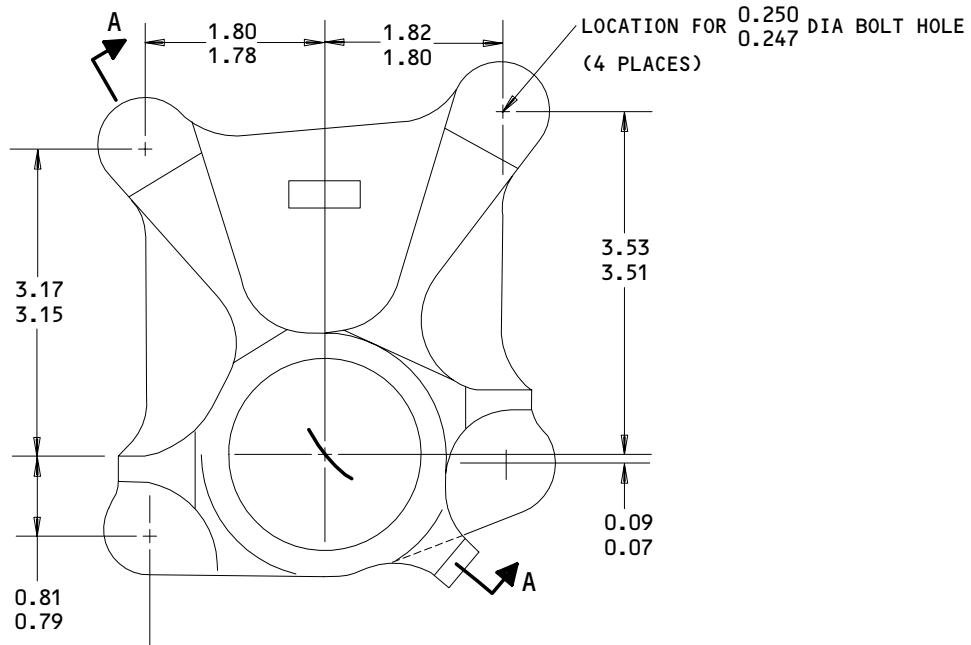
27-51-88

REPAIR 10-1

01

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A-A

REFINISH

FITTING (655) -- 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 INSTALLTION, APPLY ENAMEL, BMS 10-60 (SRF-14.9813) ALL OVER EXCEPT ON BUSHING AND LUBE FITTING

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

113T1739-1,-2
 113T1009-1,-2
Bushing Replacement and Fitting Refinish
Figure 601

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REPAIR 10-1

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SPRING ASSEMBLY – REPAIR 11-1

113T1731-1

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

- A. Remove existing bearings.
- 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. Refinish

- A. Spring (635) -- Passivate (F-17.09). Material 17-7PH CRES.
- B. Terminal (625, 630) -- Passivate (F-17.09). Material: 15-5PH CRES, 180-200 ksi.

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REPAIR 11-1

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FITTING ASSEMBLY - REPAIR 12-1

113T1726-1, -2

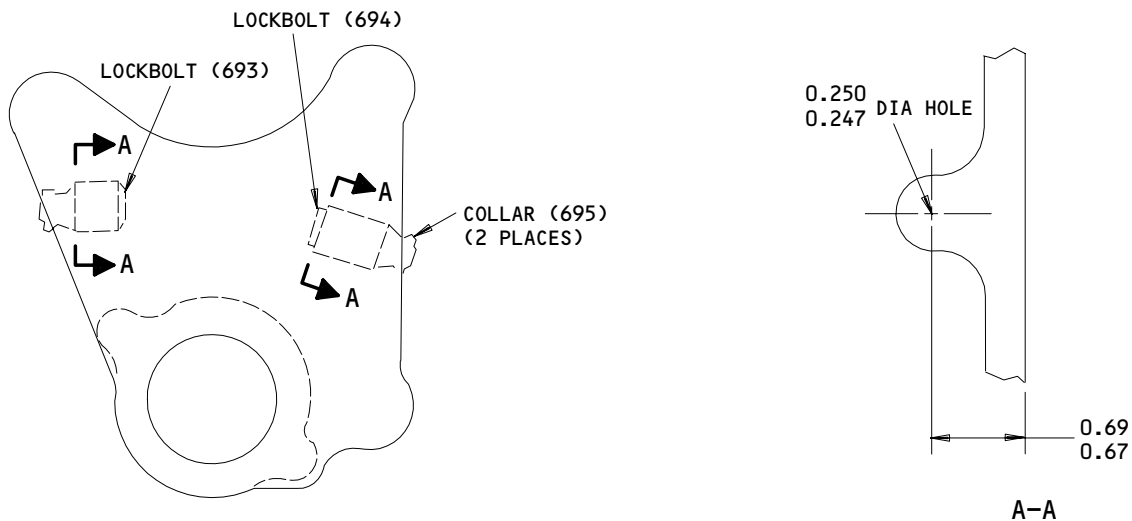
NOTE: Refer to REPAIR-GEN for list of applicable standard practices. For repair of fitting (698, 699) surfaces which may only consist of stripping and restoration of original finish, refer to Refinish instructions, Fig. 601.

1. Lockbolts (693, 694) and Collars (695) Replacement (Fig. 601)

- A. Remove existing lockbolts (693, 694) and collars (695).
- B. Install new lockbolts (693, 694) and collars(695) as shown.

2. Thrust Plate Replacement

- A. Remove existing thrust plate (696) and rivets (697).
- B. Install new thrust plate with sealant, BMS 5-95 on faying surfaces. Check that the holes in thrust plate (696) are concentric to holes in fittings (698 or 699) within 0.005 FIM.
- C. Install rivets (697) countersunk both ends. Check that rivet heads are flush to 0.005 inch below surface.



REFINISH

FITTING (698, 699):

CHROMIC ACID ANODIZE AND APPLY
1 COAT OR PRIMER, BMS 10-11,
TYPE 1 (F-18.13) ALL OVER

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

Parts Replacement and Fitting Refinish
Figure 601

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REPAIR 12-1

01

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SHAFT AND BELLCRANK ASSEMBLY – REPAIR 13-1

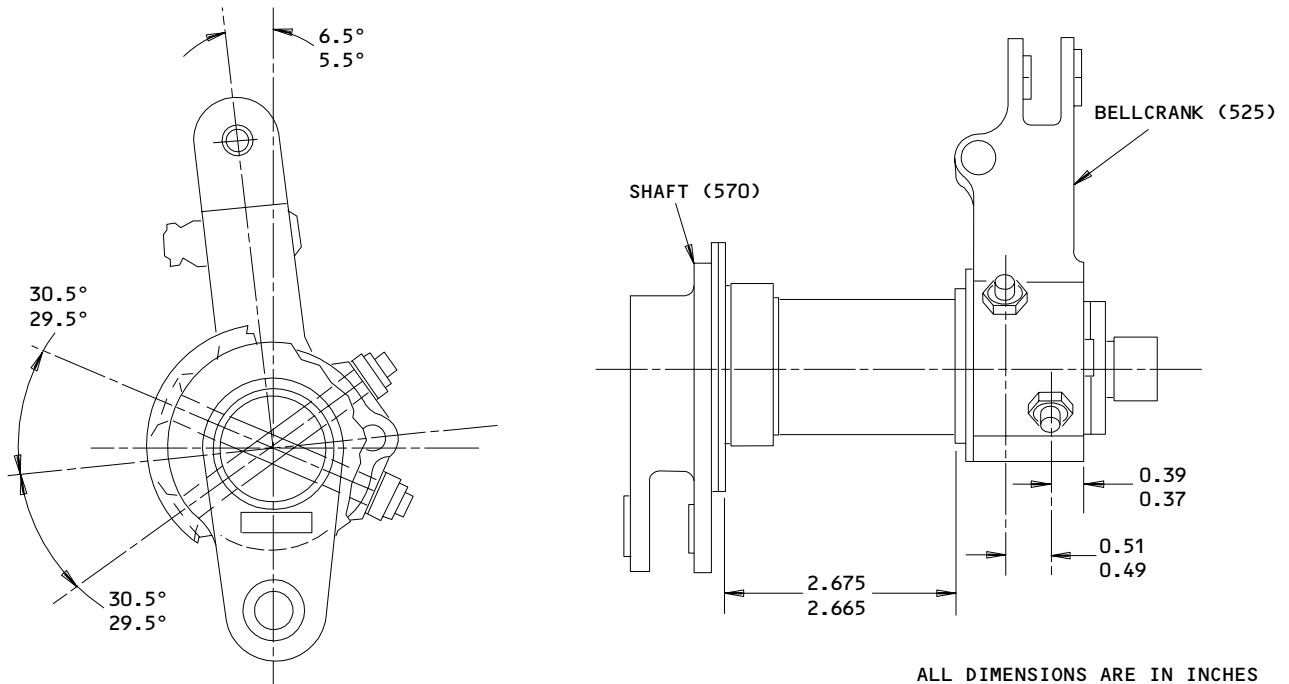
113T1737-1, -2, -9, -10

1. Parts Replacement (Fig. 601)

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

- A. Remove bolts (510), washers (515), nuts (520) and separate shaft (510) and bellcrank (525 or 530).
- B. Position replacement part as shown. Drill 0.247-0.250 dia holes thru as indicated.
- C. Install bolts (510), washers (515), nuts (520). Tighten nuts (520) finger tight.

NOTE: Fasteners will be removed and reinstalled during assembly.



Parts Replacement
Figure 601

14563

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REPAIR 13-1

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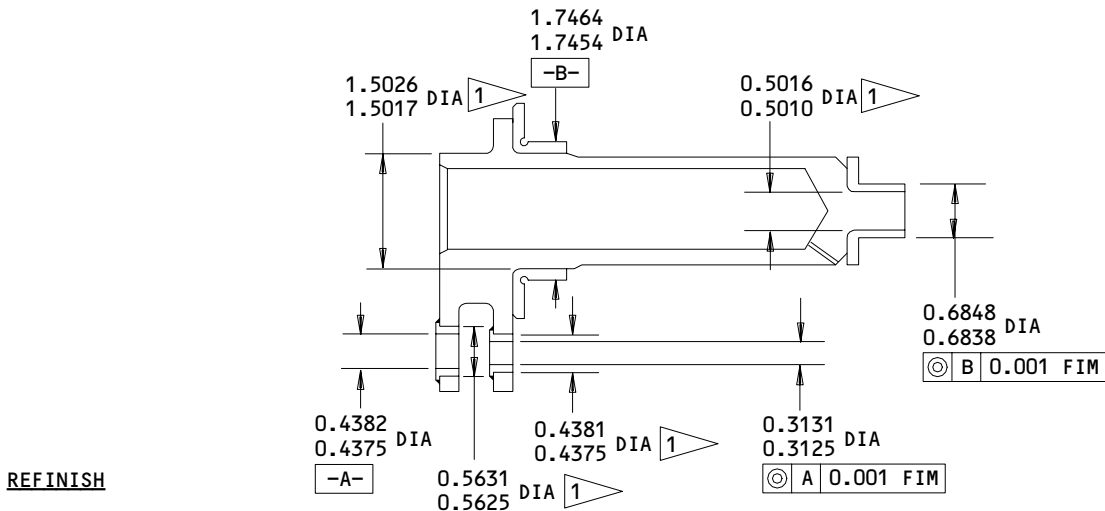
SHAFT ASSEMBLY - REPAIR 14-1

113T1737-3, -11

NOTE: Refer to REPAIR-GEN for list of applicable standard practices. For repair of shaft (592, 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.
- B. Install new bushings using shrink fit method per 20-50-03 except use wet sealant, BMS 5-95.
- C. Machine bushings to dimensions and finish shown.
- D. Seal bushing flanges per REPAIR 18-1.



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

MACHINED SURFACES NOT TO EXCEED 125°

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

Bushing Replacement and Shaft Refinish
Figure 601

27-51-88

REPAIR 14-1

01

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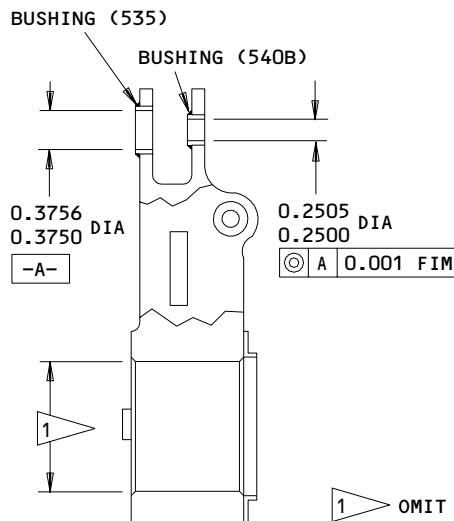
BELLCRANK ASSEMBLY - REPAIR 15-1

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

NOTE: Refer to REPAIR-GEN for list of applicable standard practices. For repair of bellcrank (525, 530, 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.
- B. Install new bushings using shrink fit method per 20-50-03 except use wet sealant, BMS 5-95.
- C. Machine bushing to dimensions and finish shown.
- D. Seal bushings per REPAIR 18-1.



REFINISH

BELL CRANK (525) -- 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 AND AS NOTED BY 1. AFTER BUSHING INSTALLATION, APPLY ENAMEL, BMS 10-60 (SRF-14.9813) ALL OVER EXCEPT ON BUSHING BORES AND FLANGES

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

MACHINED SURFACES NOT TO EXCEED 125/

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

Bushing Replacement and Bellcrank Refinish
Figure 601

14564

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REPAIR 15-1

01.1

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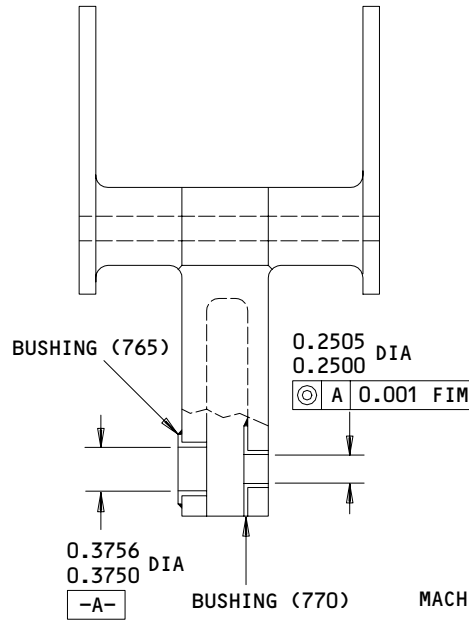
FITTING ASSEMBLY – REPAIR 16-1

113T1738-1
113T1743-1

NOTE: Refer to REPAIR-GEN for list of applicable stancard practices. For repair of fitting (775, 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.
- B. Install new bushings using shrink fit method per 20-50-03 except use wet sealant, BMS 5-95.
- C. Machine bushings to dimensions and finish shown.
- D. Seal bushings for REPAIR 18-1.



REFINISH

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

MACHINED SURFACES NOT TO EXCEED 125/

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

Bushing Replacement and Fitting Refinish
Figure 601

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REPAIR 16-1

01

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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
<u>Fig. 1</u>		
Pin (15,105,255,395), Washer (20,110,260), Retainer (55,60,360,365)	15-5PH CRES, 180-200 ksi	Passivate (F-17.09) all over.
Pin (15A, 105A, 255A,395A)	Titanium alloy	No finish.
Washer (35,125, 280,410,885A)	15-5PH CRES, 180-200 ksi	Chrome plate (0.0005-0.0010 thick, F-15.03) all over except on ID and OD.
Nut (40,130,285, 415,890)	15-5PH CRES,	Apply BMS 3-8 dry film lubricant on threads and exterior surfaces.
Retainer (425,430, 903,906)	15-5PH CRES,	Cadmium plate (F-15.06) all over.
End cap (870,875)	15-5PH CRES, 180-200 ksi	Apply BMS 3-8, type 8 dry film lubricant all over.
Segment (90,95)	TI-6AL-4V Titanium	Apply phosphate fluoride coating (SRF-14.881) and apply one coat BMS 10-11, type 1 primer (F-20.02) all over except no primer in lube hole (SRF-14.881 optional).
Strap (235,240, 858), Beam (245, 840B,845B,850), Link (618)	Al alloy	Chromic acid anodize type 1, and apply one coat BMS 10-11, type 1 primer (F-18.13) all over.

Refinish Details
Figure 601 (Sheet 1)

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REPAIR 17-1

01

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IPL FIG. & ITEM	MATERIAL	FINISH
Link (340,345)	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.
Thrust plate (696)	301 CRES	Cadmium plate (F-15.06) and apply one coat of primer, BMS 10-11, type 1 (F-20.02) all over.

Refinish Details
 Figure 601 (Sheet 2)

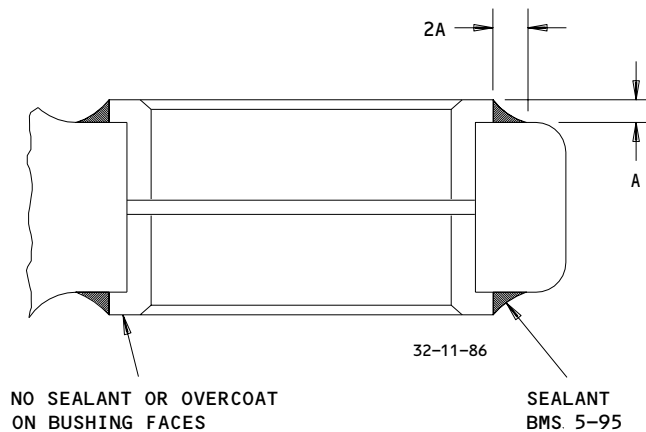
27-51-88

REPAIR 17-1
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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

4355

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REPAIR 18-1

01

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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)

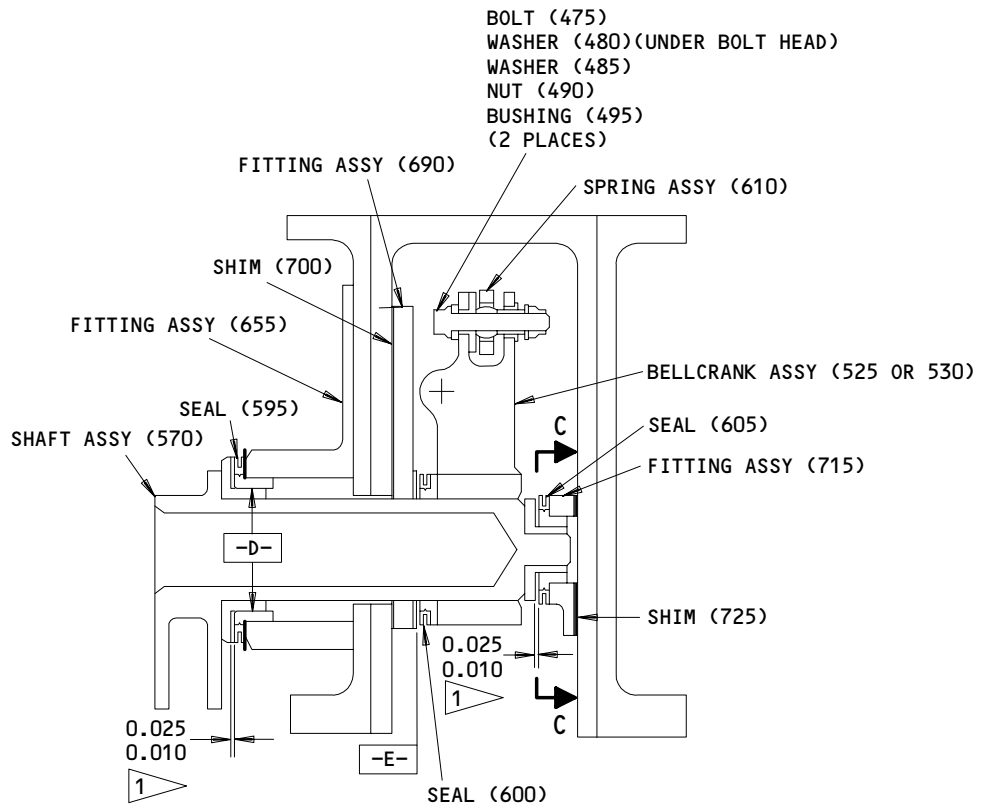
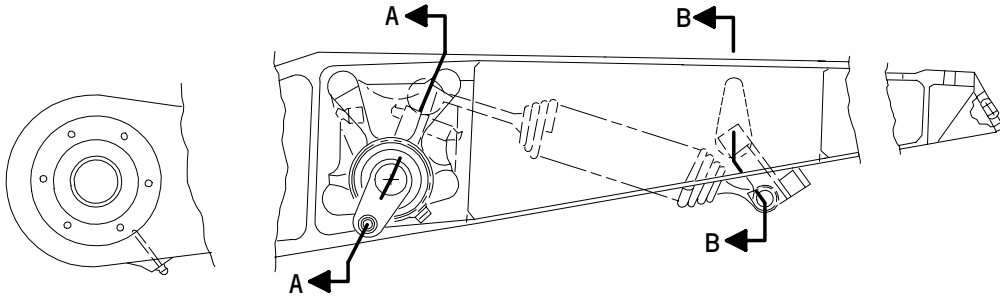
- A. Assemble beam assembly (420B or 421B) (Fig. 701)

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

- (1) Locate fitting assemblies (655, 690) on beam and drill fastener holes at locations indicated in REPAIR 6-1, 10-1, 12-1.
- (2) Locate fitting assembly (715) on beam and drill fastener hole at locations indicated in REPAIR 6-1, 9-1. Observe concentricity requirement with respect to fitting assembly (655) per Fig. 701.
- (3) Temporarily assemble fitting assemblies (655, 690, 715) and shims (700, 725) on beam.
- (4) Remove bolts (510) washers (515), nuts (520) and separate bellcrank assembly (525) from shaft assembly (570).
- (5) Position bellcrank assembly (525) in beam and install shaft assembly (570). Temporarily secure bellcrank assembly to shaft assembly.
- (6) Measure gap between bellcrank assembly (525) and fitting assembly (690) and between shaft assembly (570) and fitting assembly (715). Adjust thickness of shims (700, 725) as required so that gaps at both places are 0.003 max.
- (7) Remove parts temporarily installed.

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01 ASSEMBLY
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A-A

1 TOLERANCE WHEN GAP IS ZERO AT DATUM E.

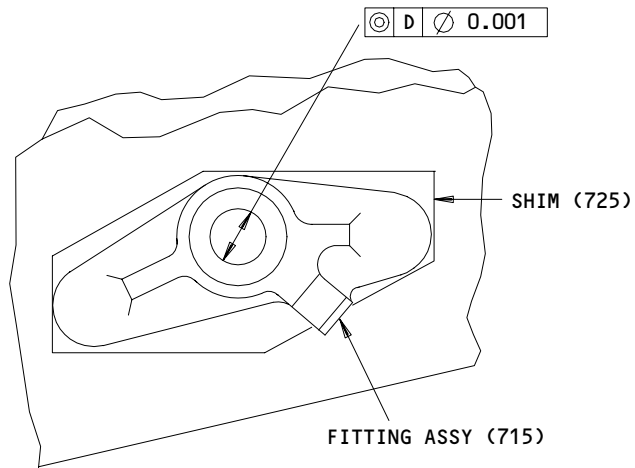
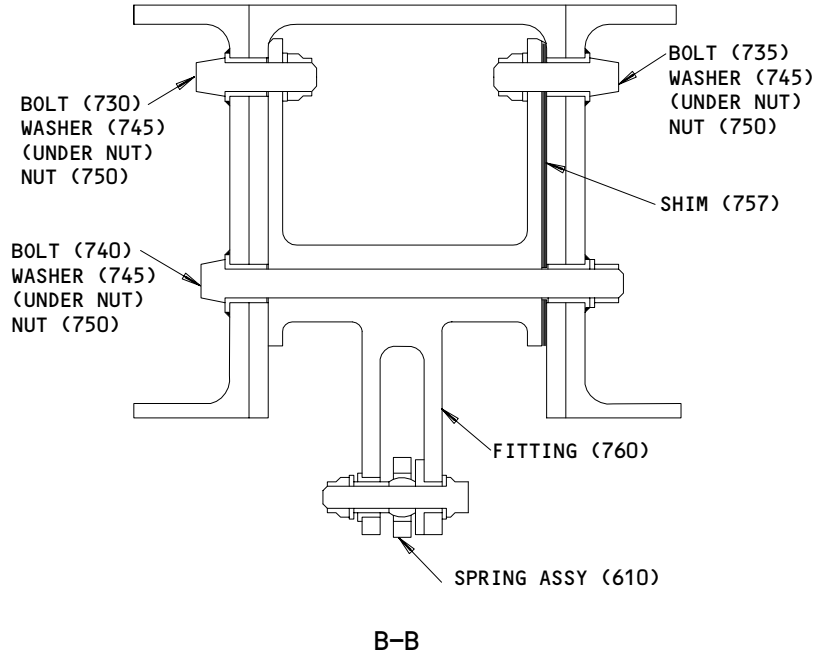
Beam Assembly Details
 Figure 701 (Sheet 1)

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ASSEMBLY
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01

14587



Beam Assembly Details
Figure 701 (Sheet 2)

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01 ASSEMBLY
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- (8) Install seals (595, 600, 605) on fitting assemblies (655, 715) and bellcrank assembly (525).
 - (9) Apply 1 coat of primer to shims (700, 725). Position fitting assemblies (655, 690) and shim (700) on beam and secure with bolts (640A, 645) and collars (650). Position fitting assembly (715) and shim (725) on beam and secure with bolts (705) and collars (710). Use care while installing parts to maintain concentricity requirement.
 - (10) Install spring assembly (610) on bellcrank assembly (525) and secure with parts (475 thru 495).
 - (11) Position bellcrank assembly (525) with attached spring assembly (610) between stops of fitting assembly (690) and install shaft assembly (570). Secure bellcrank assembly and shaft assembly with parts (510, 515, 520).
 - (12) Check gap per Fig. 701 and readjust shims (700, 725) if required.
 - (13) Position spring assembly (610) on fitting assembly (760) and secure with parts (475 thru 495).
 - (14) Position fitting assembly (760) and shim (757) in beam and check that gap is 0.003 maximum. Adjust shim (757) thickness as required. Install bolt (740), washer (745) and nut (750).
 - (15) Insert bar into a 0.62 inch diameter hole in fitting assembly (760) and apply force against spring force to align bolt holes using bolt (740) as a hinge. Install bolts (730, 735), washers (745) and nuts (750).
- B. Tighten nuts (25) to 800-1500 pound-inch. Tighten nuts (40) to 2000-3000 pound-inch.
- C. Tighten nut (115) to 600-1000 pound-inch. Tighten nut (130) to 1500-2000 pound-inch.
- D. Use washers (275) as required to obtain 0.005-0.025 inch gap between face of washer (280) and flange of bushing (315). Tighten nut (265) to 600-1000 pound-inch. Tighten nut (285) to 1500-2000 pound-inch.
- E. Tighten nut (400) to 800-1500 pound-inch. Tighten nut (415) to 3000-3700 pound-inch.

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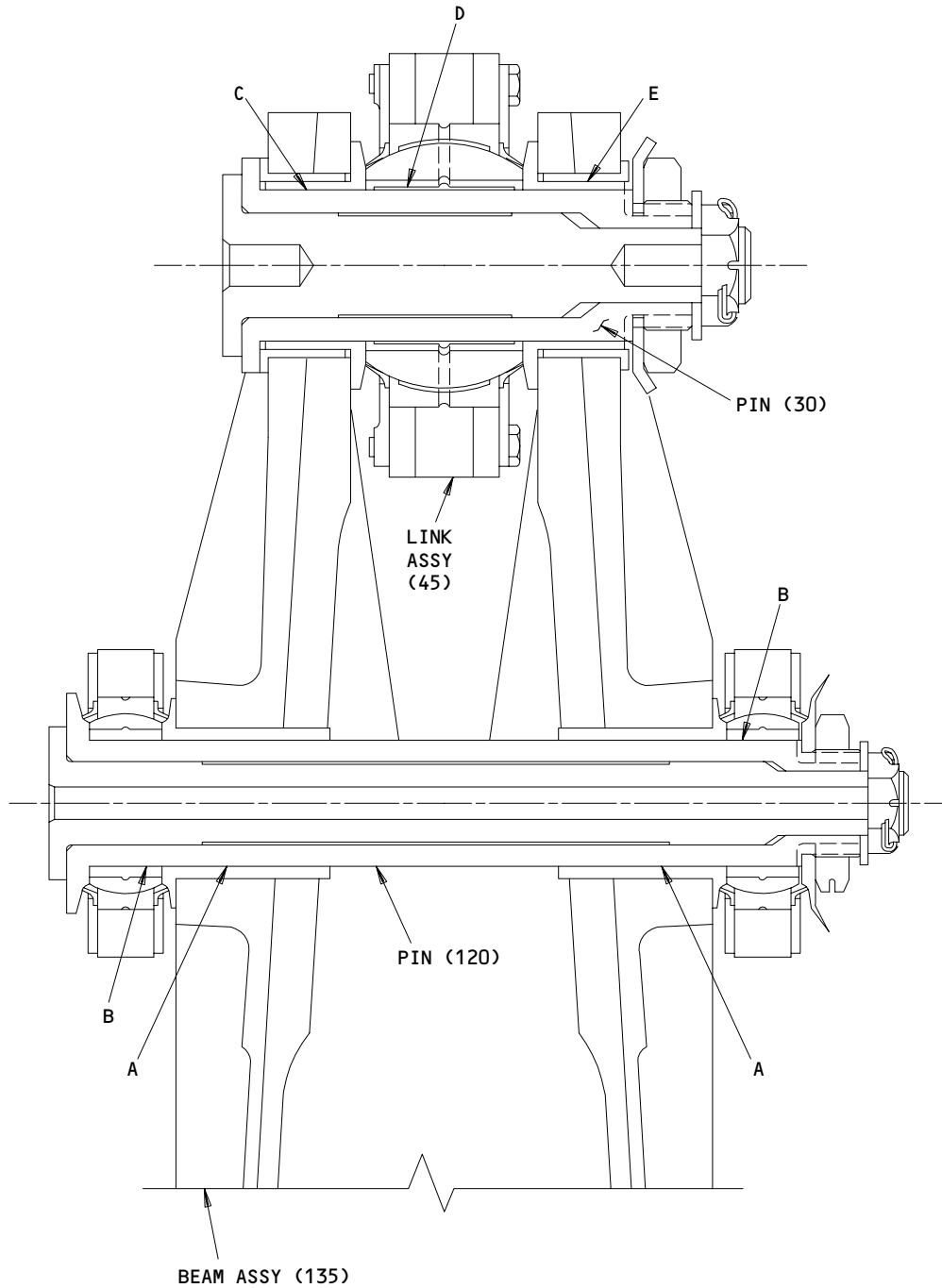
- F. Tighten nuts (865) to 150-250 pound-inch. Tighten nut (890) to 2000-3000 pound-inch.
- G. Lockwire the following parts per 20-50-02.
 - (1) Nuts (40) to washers (35) (2 places)
 - (2) Nut (130) to washer (125) (2 places)
 - (3) Nut (285) to washer (280) (2 places)
 - (4) Nut (415) to washer (410) (2 places)
 - (5) Nut (890) to washer (885A) (2 places)
- 3. Store this component using standard industry practices and information contained in 20-44-02.

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FITS AND CLEARANCES

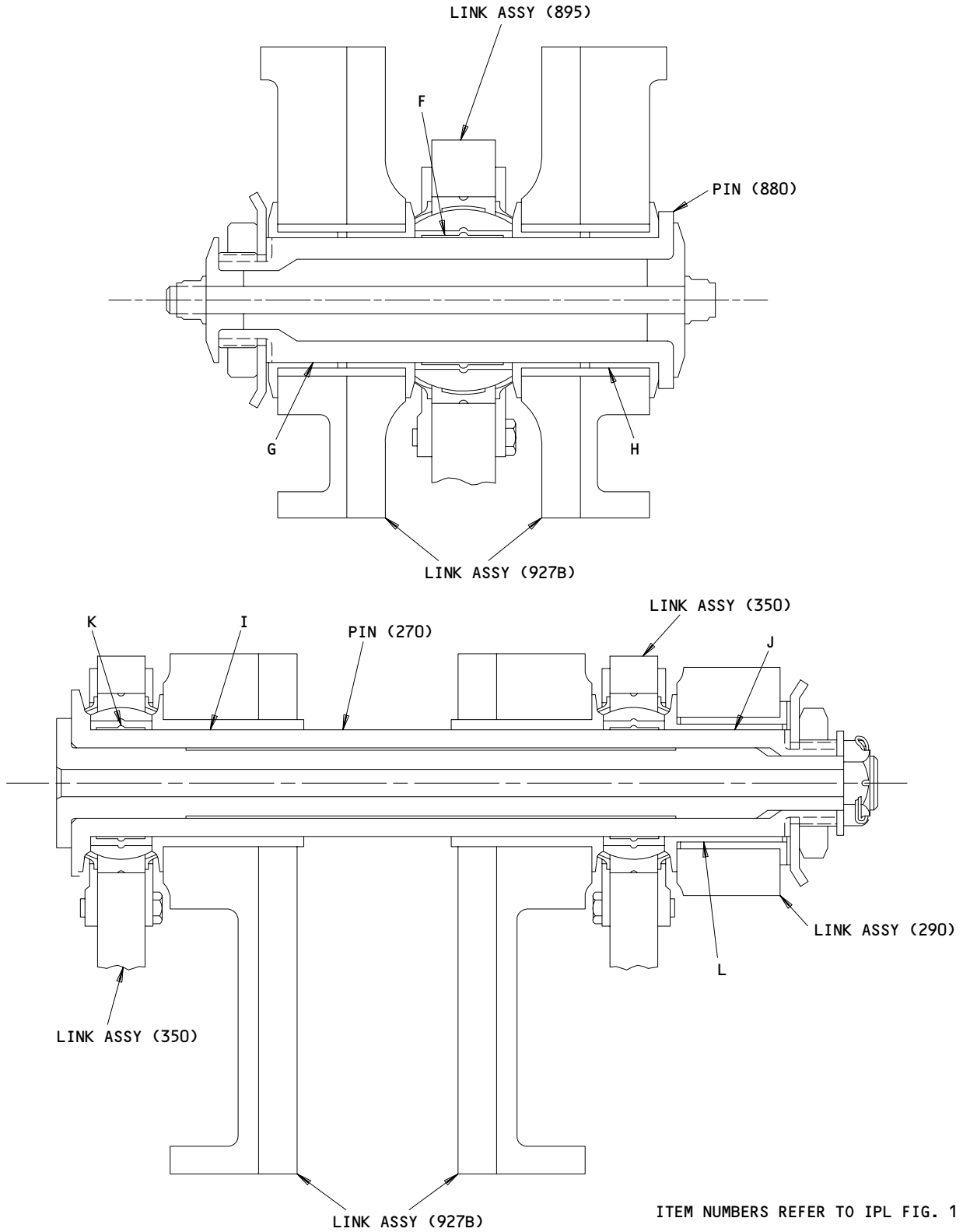


ITEM NUMBERS REFER TO IPL FIG. 1

Fits and Clearances
Figure 801 (Sheet 1)

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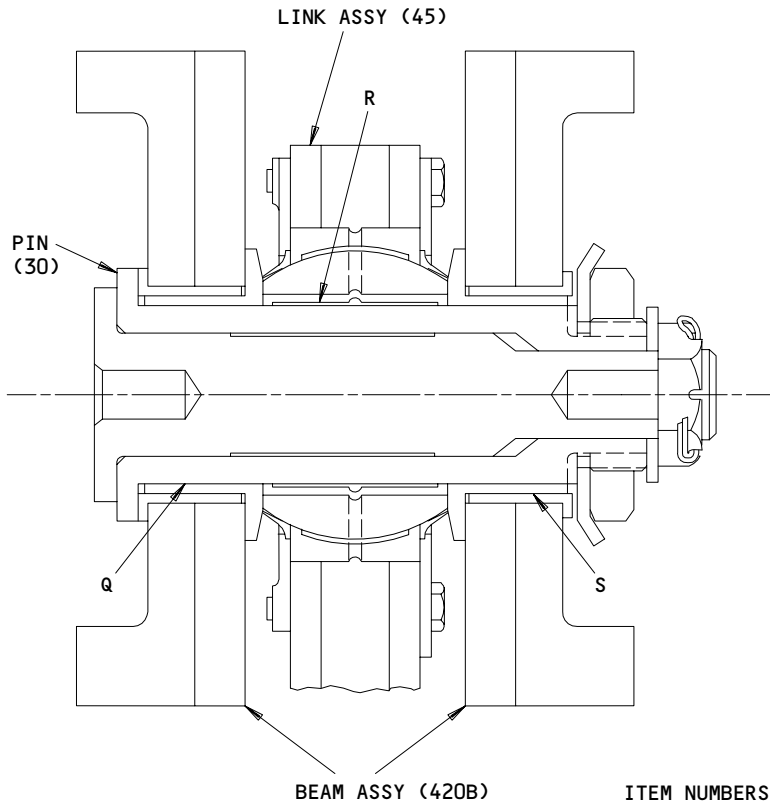
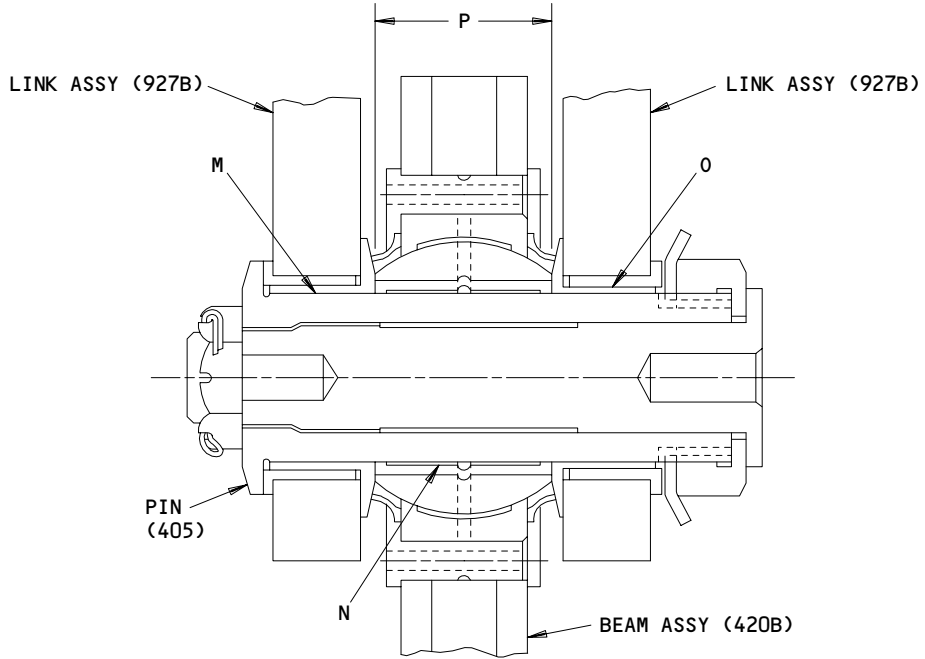


ITEM NUMBERS REFER TO IPL FIG. 1

**Fits and Clearances
 Figure 801 (Sheet 2)**

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ITEM NUMBERS REFER TO IPL FIG. 1

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 140,145, 170 OD *[2]	1.6245 1.6234	1.6256 1.6240	0.0005	0.0022	1.6167	1.6329	0.0089
A	ID 155 OD 120	1.4995 1.4984	1.5006 1.4990	0.0005	0.0022	1.4922	1.5074	0.0084
B	ID 375 OD 120	1.5000 1.4984	1.5006 1.4990	0.0010	0.0022	1.4922	1.5074	0.0084
C	ID 160 OD 30	1.7496 1.7484	1.7506 1.7490	0.0006	0.0022	1.7411	1.7585	0.0095
D	ID 70 OD 30	1.7500 1.7484	1.7506 1.7490	0.0010	0.0022	1.7411	1.7585	0.0095
E	ID 165 OD 160	1.9229 1.9250	1.9238 1.9259	-0.0012	-0.0030			
F	ID 912 OD 880	1.7500 1.7484	1.7506 1.7490	0.0010	0.0022	1.7411	1.7585	0.0095
G	ID 936 OD 880	1.7495 1.7484	1.7506 1.7490	0.0005	0.0022	1.7411	1.7585	0.0095
H	ID 939 OD 936	1.9229 1.9250	1.9238 1.9259	-0.0012	-0.0030			
I	ID 942 OD 270	1.4995 1.4984	1.5006 1.4990	0.0005	0.0022	1.4906	1.5074	0.0084
J	ID 310 OD 270	1.4995 1.4984	1.5006 1.4990	0.0005	0.0022	1.4906	1.5074	0.0084
K	ID 375 OD 270	1.5000 1.4984	1.5006 1.4990	0.0010	0.0022	1.4906	1.5074	0.0084
L	ID 315 OD 310	1.6482 1.6500	1.6490 1.6509	-0.0010	-0.0027			
M	ID 930 OD 405	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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 FITS AND CLEARANCES
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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 440	1.6250	1.6256	0.0010	0.0022	1.6167	1.6329	0.0089
	OD 405	1.6234	1.6240					
O	ID 933	1.7856	1.7865	-0.0010	0.0022			
	OD 930	1.7875	1.7884					
P	*[3]		1.8160				1.8460	
Q	ID 455	1.7495	1.7506	0.0005	0.0022	1.7411	1.7585	0.0095
	OD 30	1.7484	1.7490					
R	ID 70	1.7500	1.7506	0.0010	0.0022	1.7411	1.7585	0.0095
	OD 30	1.7484	1.7490					
S	ID 460	1.9229	1.9238	-0.0012	-0.0030			
	OD 455	1.9250	1.9259					
	ID 305	0.5000	0.5007	0.0005	0.0017	0.4957	0.5045	0.0050
	OD *[4]	0.4990	0.4995					
	ID 300	0.6870	0.6877	0.0005	0.0017	0.6825	0.6917	0.0052
	OD *[5]	0.6860	0.6865					

- *[1] NEGATIVE VALUES DENOTE INTERFERENCE FIT
- *[2] INSTALLATION PART 113T1263-1
- *[3] DIMENSION BETWEEN FLANGE FACES OF BUSHINGS (930)
- *[4] INSTALLATION PART BACB30LJ8U
- *[5] BACCB28AK08

ALL DIMENSIONS ARE IN INCHES

Fits and Clearances
Figure 801 (Sheet 5)

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FITS AND CLEARANCES
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FOR TORQUE VALUES OF STANDARD FASTENERS, REFER TO 20-50-01

Item No. Fig. 1	Name	Torque Pound-Inches
25, 400	NUT	800-1500
40, 890	NUT	2000-3000
115, 265	NUT	600-1000
130, 285	NUT	1500-2000
415	NUT	3000-3700
865	NUT	150-250

Torque Table
 Figure 802

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FITS AND CLEARANCES
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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

06710 LAMSON AND SESSIONS CO THE VALLEY-TODECO
12975 BRADLEY AVENUE
SYLMAR, CALIFORNIA 91342-3830

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

06950 SCREWCORP VSI CORP AEROSPACE PRODUCTS DIV FAIRCHILD IND INC
13001 EAST TEMPLE AVE. PO BOX 730
CITY OF INDUSTRY, CALIFORNIA 91746-1417

08524 DEUTSCH FASTENER CORP SEE CODE V97928

10630 ANILLO INDUSTRIES, INCORPORATED
2090 NORTH GLASSELL
ORANGE, CALIFORNIA 92667

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

15653 KAYNAR MICRODOT AEROSPACE FASTENING SYSTEM
800 SOUTH COLLEGE BLVD PO BOX 3001
FULLERTON, CALIFORNIA 92634-3001

15860 NEW HAMPSHIRE BALL BEARINGS, INCORPORATED ASTRO DIVISION
155 LEXINGTON AVENUE
LACONIA, NEW HAMPSHIRE 03246-2937

17943 FEDERAL MANUFACTURING CORPORATION
6910 FARMDALE AVENUE
NORTH HOLLYWOOD, CALIFORNIA 91605-6210

23294 AVALON MACHINE PRODUCTS INC
15337 ALLEN STREET
PARAMOUNT, CALIFORNIA 90723-4011

27624 PAUL R BRILES INC P.B. FASTENER DIV
1700 WEST 132ND STREET PO BOX 1157
GARDENA, CALIFORNIA 90249-2008

50294 NEW HAMPSHIRE BALL BEARINGS INC
9730 INDEPENDENCE AVENUE PO BOX 2515
CHATSWORTH, CALIFORNIA 91311-4323

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ILLUSTRATED PARTS LIST
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VENDORS

50632 KAMATICS CORP SUB OF KAMAN CORP
1335 BLUE HILLS ROAD
BLOOMFIELD, CONNECTICUT 06002-1304

52828 REPUBLIC FASTENER MFG CORP
1300 RANCHO CONEJO BLVD
NEWBURY PARK, CALIFORNIA 91320-1405

56878 SPS TECHNOLOGIES INC AEROSPACE AND INDUSTRIAL PRODUCTS DIV
HIGHLAND AVENUE
JENKINTOWN, PENNSYLVANIA 19046
USE APPLICABLE FACILITY CODE

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

70265 ALL POWER MANUFACTURING COMPANY
13141 MOLETTE STREET
SANTA FE SPRINGS, CALIFORNIA 90670-5523

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

72962 ELASTIC STOP NUT A DIV OF HARTFORD INDUSTRIES INC
2330 VAUXHALL ROAD
UNION, NEW JERSEY 07083-5038

73134 HEIM DIV INCOM INTERNATIONAL INC
60 ROUND HILL ROAD PO BOX 430
FAIRFIELD, CONNECTICUT 06430-5114

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

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ILLUSTRATED PARTS LIST
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VENDORS

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

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

92595 AUTOMATIC SCREW MACHINE PRODUCTS CO
PO BOX 1608 709 2ND AVENUE SE
DECATUR, ALABAMA 35602

93907 TEXTRON INC CAMCAR DIV
600 18TH AVENUE
ROCKFORD, ILLINOIS 61101

94892 MASTER MACHINE PRODUCTS CORPORATION
1551 SOUTH PRIMROSE AVE
MONROVIA, CALIFORNIA 91016-4542

97613 SARGENT INDUSTRIES KAHR BEARING DIVISION
3010 NORTH SAN FERNANDO ROAD
BURBANK, CALIFORNIA 91504-2524

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

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ILLUSTRATED PARTS LIST
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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
ADB4V301NC		1	615	2
ADW5V301NC		1	465	1
AN960C416		1	515	2
AN960PD516L		1	962	2
		1	988	2
ASB24-101		1	375	2
ASB28-101		1	912	2
ASB28-102		1	70	2
BACB10FA05GC		1	465	1
BACB10FB04GC		1	615	2
BACB10JA28ABNJ01		1	70B	2
		1	70C	2
BACB28AK04-035		1	495	2
BACB28AM04B038A		1	755	4
BACB28AM06B013A		1	535A	1
BACB28AM06B019A		1	535	1
		1	765	1
BACB28AM07B019A		1	575	1
BACB28AM11B040A		1	300	1
BACB28AP08P040		1	305	1
BACB30FM8A12		1	694	1
BACB30FM8A15		1	555	1
BACB30FM8A7		1	693	1
BACB30LE4-10		1	730	1
BACB30LE4-11		1	735	1
BACB30LE4-16		1	475	2
BACB30LE4-60		1	740	1
BACB30LE6-111		1	860	1
BACB30LH4-38		1	510	2
BACB30LJ4HSU15		1	909A	6
BACB30LJ4HSU20		1	65	6
BACB30LJ4H10		1	370	6
BACB30LJ5-14		1	961	2
		1	985	2
BACB30LR3P20		1	435A	6
BACB30MR6K111		1	860A	1
BACB30MY10K10		1	951	6
		1	973	6
BACB30MY10K12		1	800	2
		1	954	2
		1	976	2
BACB30MY10K14		1	805	2
		1	957	8
		1	979	10
BACB30MY10K16		1	810	4
BACB30MY10K6		1	185	12
BACB30MY10K7		1	190	16

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACB30MY10K9		1	195	8
BACB30MY12K11		1	205	4
BACB30MY12K14		1	210	8
BACB30MY12K16		1	215	4
BACB30MY12K21		1	820A	3
BACB30MY14K16		1	225	4
BACB30MY14K47		1	830	2
BACB30MY8K13		1	705	2
BACB30MY8K15		1	645	1
BACB30MY8K16		1	80	5
BACB30MY8K21		1	640A	3
BACB30MY8K4		1	780	12
BACB30MY8K6		1	852	4
BACB30MY8K7		1	785	18
BACB30MY8K8		1	918	6
BACB30NW8K7		1	790	2
BACC30AB8S		1	85	5
BACC30M10		1	200	36
		1	815	8
		1	960	16
		1	982	18
BACC30M12		1	220	16
		1	825	3
BACC30M14		1	230	4
		1	835	2
BACC30M8		1	560	1
		1	650	4
		1	695	2
		1	710	2
		1	795	32
		1	854	4
		1	921	6
BACN10JC4CM		1	520	2
BACN10JC5		1	964	2
		1	991	2
BACN10JD112AU		1	115	1
		1	265	1
BACN10JD114AU		1	25	2
		1	400	1
BACR15BA5AD		1	545	2
		1	697	2
BACR15BB8D8		1	968	1
BACS40R11C20F		1	856	2
BACW10BP4C		1	480	2
BACW10BP4P		1	485	2
		1	745	3
BRH10A5		1	964	2

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
B30MY10K10		1	951	6
		1	973	6
B30MY10K12		1	800	2
		1	954	2
		1	976	2
B30MY10K14		1	805	2
		1	957	8
		1	979	10
B30MY10K16		1	810	4
B30MY10K6		1	185	12
B30MY10K7		1	190	16
B30MY10K9		1	195	8
B30MY12K11		1	205	4
B30MY12K14		1	210	8
B30MY12K16		1	215	4
B30MY12K21		1	820A	3
B30MY14K16		1	225	4
B30MY14K47		1	830	2
B30MY8K13		1	705	2
B30MY8K15		1	645	1
B30MY8K16		1	80	5
B30MY8K21		1	640A	3
B30MY8K4		1	780	12
B30MY8K6		1	852	4
B30MY8K7		1	785	18
B30MY8K8		1	918	6
B30NW8K7		1	790	2
HL10VAZ10-10		1	951	6
		1	973	6
HL10VAZ10-12		1	800	2
		1	954	2
		1	976	2
HL10VAZ10-14		1	805	2
		1	957	8
		1	979	10
HL10VAZ10-16		1	810	4
HL10VAZ10-6		1	185	12
HL10VAZ10-7		1	190	16
HL10VAZ10-9		1	195	8
HL10VAZ12-11		1	205	4
HL10VAZ12-14		1	210	8
HL10VAZ12-16		1	215	4
HL10VAZ12-21		1	820A	3
HL10VAZ14-16		1	225	4
HL10VAZ14-47		1	830	2
HL10VAZ8-13		1	705	2
HL10VAZ8-15		1	645	1

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
HL10VAZ8-16		1	80	5
HL10VAZ8-21		1	640A	3
HL10VAZ8-4		1	780	12
HL10VAZ8-6		1	852	4
HL10VAZ8-7		1	785	18
HL10VAZ8-8		1	918	6
HL11VAZ8-7		1	790	2
HL11V7		1	790	2
HL440UC8-12		1	694	1
HL440UC8-15		1	555	1
HL440UC8-7		1	693	1
HL79-10		1	200	36
		1	815	8
		1	960	16
		1	982	18
HL79-12		1	220	16
		1	825	3
HL79-14		1	230	4
		1	835	2
HL79-8		1	560	1
		1	650	4
		1	695	2
		1	710	2
		1	795	32
		1	854	4
		1	921	6
HL97DU8		1	85	5
HTFB04		1	615	2
H01-4BAC		1	520	2
H10-5BAC		1	964	2
KNDB4-70		1	615	2
KSC145700BZ4GC		1	615	2
KSC152200BZ5CC		1	465	1
KWDB5-35		1	465	1
LHCB24BA		1	375	2
LHCB26BAD		1	440	1
LHCB28BA		1	912	2
LHCB28BAD		1	70	2
L80010K10		1	951	6
		1	973	6
L80010K12		1	800	2
		1	954	2
		1	976	2
L80010K14		1	805	2
		1	957	8
		1	979	10
L80010K16		1	810	4

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 ILLUSTRATED PARTS LIST
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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
L80010K6		1	185	12
L80010K7		1	190	16
L80010K9		1	195	8
L80012K11		1	205	4
L80012K14		1	210	8
L80012K16		1	215	4
L80012K21		1	820A	3
L80014K16		1	225	4
L80014K47		1	830	2
L8008K13		1	705	2
L8008K15		1	645	1
L8008K16		1	80	5
L8008K21		1	640A	3
L8008K4		1	780	12
L8008K6		1	852	4
L8008K7		1	785	18
L8008K8		1	918	6
L803-8K7		1	790	2
MS15001-1		1	175	1
		1	335	1
		1	470	1
		1	665	1
		1	720	1
		1	915	2
		1	948	1
MS15001-3		1	180	2
MS15004-1		1	75	2
		1	380	2
MS24665-376		1	10	2
		1	100	1
		1	250	1
		1	390	1
NAS1804-4		1	490	2
		1	750	3
NAS1805-6		1	865	1
NRRS04FBGC		1	615	2
NS202101SE048		1	520	2
RMLH9075-5W		1	964	2
T6C428JM		1	520	2
T6S524J		1	964	2
VN303D048		1	520	2
WC130-8-12		1	694	1
WC130-8-15		1	555	1
WC130-8-7		1	693	1
WES04GC		1	615	2
WHTFA05VC		1	465	1
WRRS05FAGC		1	465	1

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
109LH9075-4W		1	520	2
113T1009-1		1	655A	1
		1	655D	1
113T1009-2		1	660B	1
		1	660E	1
113T1009-3		1	680A	1
113T1009-4		1	685A	1
113T1105-9		1	275	AR
113T1221-11		1	994	1
113T1221-12		1	966B	1
113T1221-13		1	927C	1
		1	927E	1
		1	927G	1
113T1221-14		1	927B	1
		1	927F	1
		1	927H	1
113T1221-15		1	927D	1
113T1221-16		1	970A	1
113T1221-17		1	970B	1
113T1221-18		1	970	1
113T1221-2		1	997	1
113T1221-6		1	997A	1
113T1222-1		1	135	1
		1	135C	1
		1	135E	1
113T1222-2		1	245	1
113T1222-3		1	235	1
		1	237	1
113T1222-4		1	240	1
		1	243	1
113T1222-5		1	135A	1
113T1222-6		1	245A	1
113T1222-7		1	237A	1
113T1222-8		1	243A	1
113T1222-9		1	135B	1
		1	135D	1
		1	135F	1
113T1223-1		1	45	1
		1	45A	1
113T1223-2		1	95	1
113T1223-3		1	90	2
113T1223-47		1	45B	1
113T1224-1		1	895	1
113T1224-2		1	924	2
113T1225-1		1	350	2
113T1225-2		1	385	1
113T1226-10		1	700	1

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
113T1226-15		1	757	1
113T1226-17		1	420B	1
		1	420F	1
113T1226-18		1	421B	1
		1	421F	1
113T1226-19		1	420C	1
113T1226-2		1	850	1
113T1226-20		1	421C	1
113T1226-21		1	840B	1
113T1226-22		1	845B	1
113T1226-23		1	840C	1
113T1226-24		1	845C	1
113T1226-25		1	420D	1
		1	420G	1
113T1226-26		1	421D	1
		1	421G	1
113T1226-27		1	420E	1
113T1226-28		1	421E	1
113T1226-29		1	858	1
113T1226-6		1	850A	1
113T1226-9		1	725	1
113T1229-1		1	290	1
		1	290B	1
113T1229-2		1	295	1
		1	295B	1
113T1229-3		1	340	1
113T1229-4		1	345	1
113T1229-5		1	290A	1
113T1229-6		1	295A	1
113T1229-7		1	340A	1
113T1229-8		1	345A	1
113T1254-11		1	20	AR
113T1254-13		1	110	1
		1	260	1
113T1254-3		1	280	1
113T1254-4		1	35	2
113T1254-46		1	885A	1
113T1254-6		1	410	1
113T1254-9		1	125	1
113T1256-20		1	900	4
113T1256-21		1	422	2
113T1256-22		1	355	4
113T1256-25		1	50	4
113T1256-27		1	133	6
113T1256-40		1	595	1
113T1256-41		1	600	1
113T1256-42		1	605	1

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
113T1256-49		1	133A	6
113T1256-53		1	595A	1
113T1256-54		1	600A	1
113T1256-55		1	605A	1
113T1258-1		1	870	1
113T1258-2		1	875	1
113T1262-3		1	130	1
		1	285	1
113T1262-4		1	40	2
		1	890	1
113T1262-6		1	415	1
113T1263-2		1	120	1
113T1263-5		1	880	1
113T1263-6		1	270	1
113T1263-7		1	405	1
113T1263-8		1	30	2
113T1264-2		1	105	1
113T1264-3		1	255	1
113T1264-37		1	105A	1
113T1264-38		1	255A	1
113T1264-41		1	15A	2
113T1264-42		1	395A	1
113T1264-6		1	15	2
113T1264-7		1	395	1
113T1267-1		1	55A	2
113T1267-15		1	60	2
113T1267-16		1	55	2
113T1267-17		1	360	2
113T1267-18		1	365	2
113T1267-19		1	906	2
113T1267-2		1	60A	2
113T1267-20		1	903	2
113T1267-21		1	60B	2
113T1267-22		1	55B	2
113T1267-23		1	360B	2
113T1267-24		1	365B	2
113T1267-25		1	906B	2
113T1267-26		1	903B	2
113T1267-3		1	360A	2
113T1267-4		1	365A	2
113T1267-5		1	903A	2
113T1267-6		1	906A	2
113T1267-7		1	425	1
113T1267-8		1	430	1
113T1347-40		1	140	2
113T1347-41		1	170	2
113T1347-42		1	155	2

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
113T1347-43		1	160	2
		1	455	2
113T1347-44		1	165	2
		1	460	2
113T1347-45		1	945	2
113T1347-46		1	936	4
113T1347-47		1	939	2
113T1347-48		1	942	2
113T1347-49		1	930	2
113T1347-50		1	933	2
113T1347-55		1	145	2
113T1347-58		1	445	2
113T1347-59		1	450	2
113T1347-63		1	330	1
113T1347-64		1	150	2
113T1347-68		1	310	1
113T1347-69		1	315	1
113T1347-70		1	320	1
113T1347-72		1	325	1
113T1347-79		1	770	1
		1	540B	1
113T1347-80		1	580B	1
113T1347-81		1	585	1
113T1347-82		1	590	1
113T1347-83		1	670	1
113T1347-84		1	721	1
113T1347-85		1	675	1
113T1347-86		1	722	1
113T1397-1		1	565A	1
113T1447-5		1	994	1
113T1447-6		1	966A	1
113T1716-1		1	625	1
113T1716-2		1	630	1
113T1719-1		1	715	1
113T1719-2		1	718	1
113T1719-3		1	723	1
113T1719-4		1	724	1
113T1726-1		1	690	1
113T1726-2		1	691	1
113T1726-3		1	698	1
113T1726-4		1	699	1
113T1726-5		1	696	1
113T1731-1		1	610	1
113T1731-2		1	620	1
113T1731-3		1	635	1

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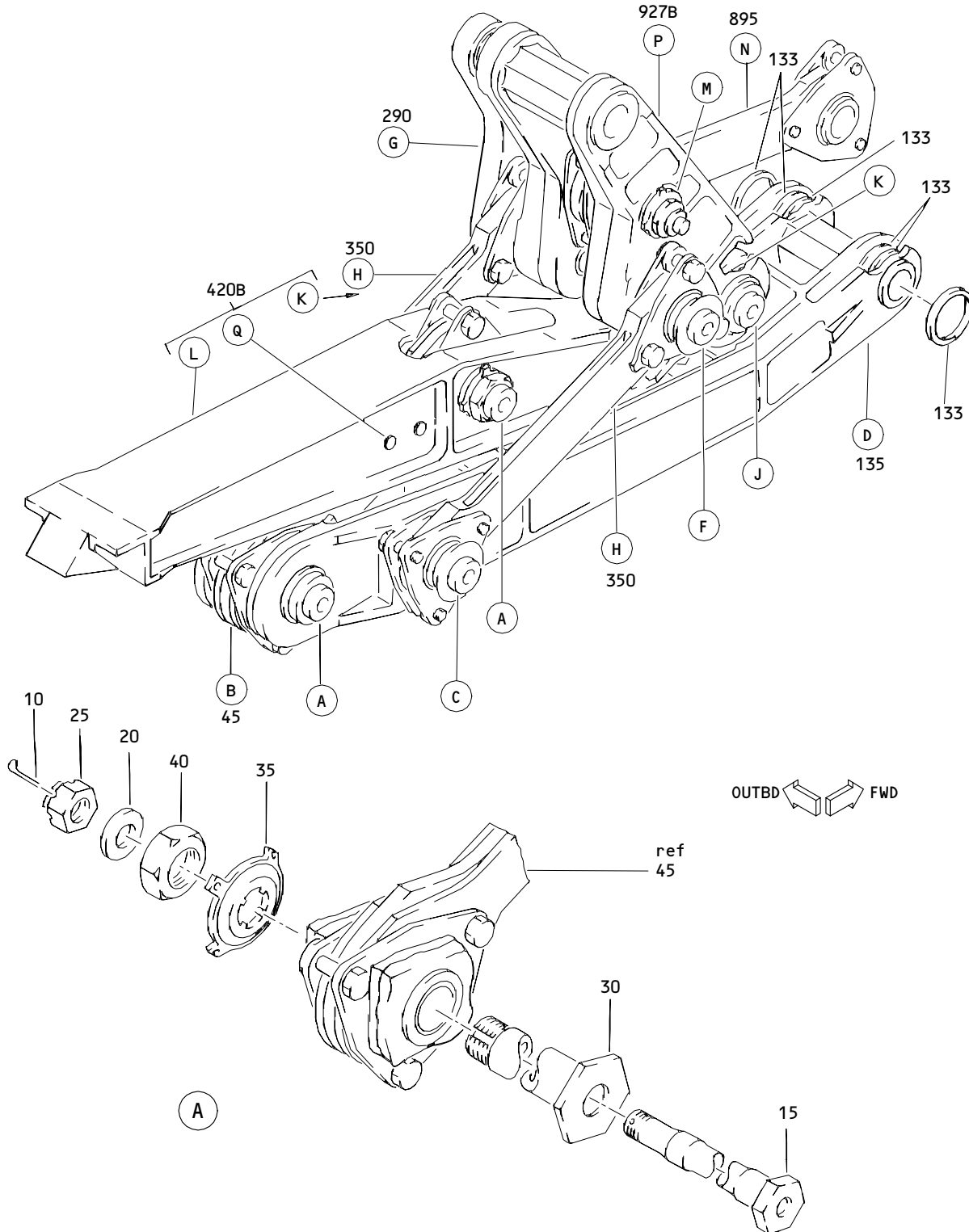
PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
113T1737-1		1	500	1
		1	500B	1
		1	500D	1
113T1737-10		1	505A	1
		1	505C	1
113T1737-11		1	570B	1
113T1737-12		1	593	1
113T1737-13		1	525B	1
113T1737-14		1	530B	1
113T1737-2		1	505	1
		1	505B	1
		1	505D	1
113T1737-3		1	570	1
113T1737-4		1	592	1
113T1737-5		1	525	1
		1	525C	1
113T1737-6		1	530	1
		1	530C	1
113T1737-7		1	565	1
113T1737-8		1	550	1
113T1737-9		1	500A	1
		1	500C	1
113T1738-1		1	760	1
		1	760B	1
		1	760D	1
113T1738-2		1	775	1
113T1739-1		1	655	1
		1	655C	1
		1	655E	1
113T1739-2		1	660	1
		1	660D	1
		1	660F	1
113T1739-3		1	680	1
113T1739-4		1	685	1
113T1743-1		1	760A	1
		1	760C	1
113T1743-2		1	775A	1
113T2000-3		1	1	RF
113T2000-4		1	5	RF
113T2000-5005		1	6A	1
113T2000-5006		1	7A	1
113T2000-5007		1	6	1
113T2000-5008		1	7	1
113T2000-5021		1	6B	1
113T2000-5022		1	7B	1
113T2000-5023		1	6C	1
113T2000-5024		1	7C	1

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
60B00180-230		1	375	2
60B00180-237		1	440	1
60B00180-240		1	912A	2
60B00180-241		1	70	2
66014-10		1	200	36
		1	815	8
		1	960	16
		1	982	18
66014-12		1	220	16
		1	825	3
66014-14		1	230	4
		1	835	2
66014-8		1	560	1
		1	650	4
		1	695	2
		1	710	2
		1	795	32
		1	854	4
		1	921	6
67067-8A12		1	694	1
67067-8A15		1	555	1
67067-8A7		1	693	1
96-054		1	964	2
97E48		1	520	2

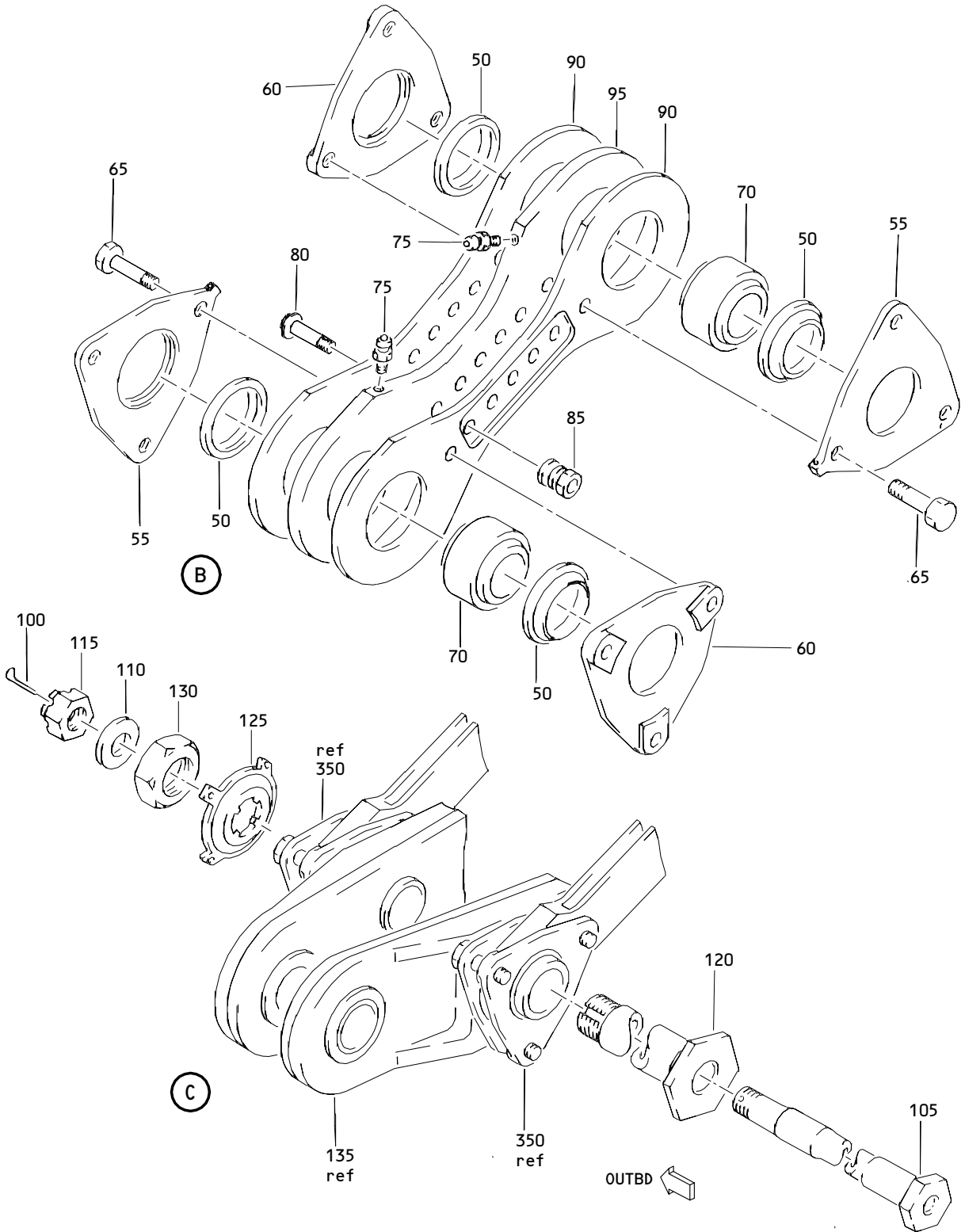
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Inboard Trailing Edge Flap Linkage Assembly
Figure 1 (Sheet 1)

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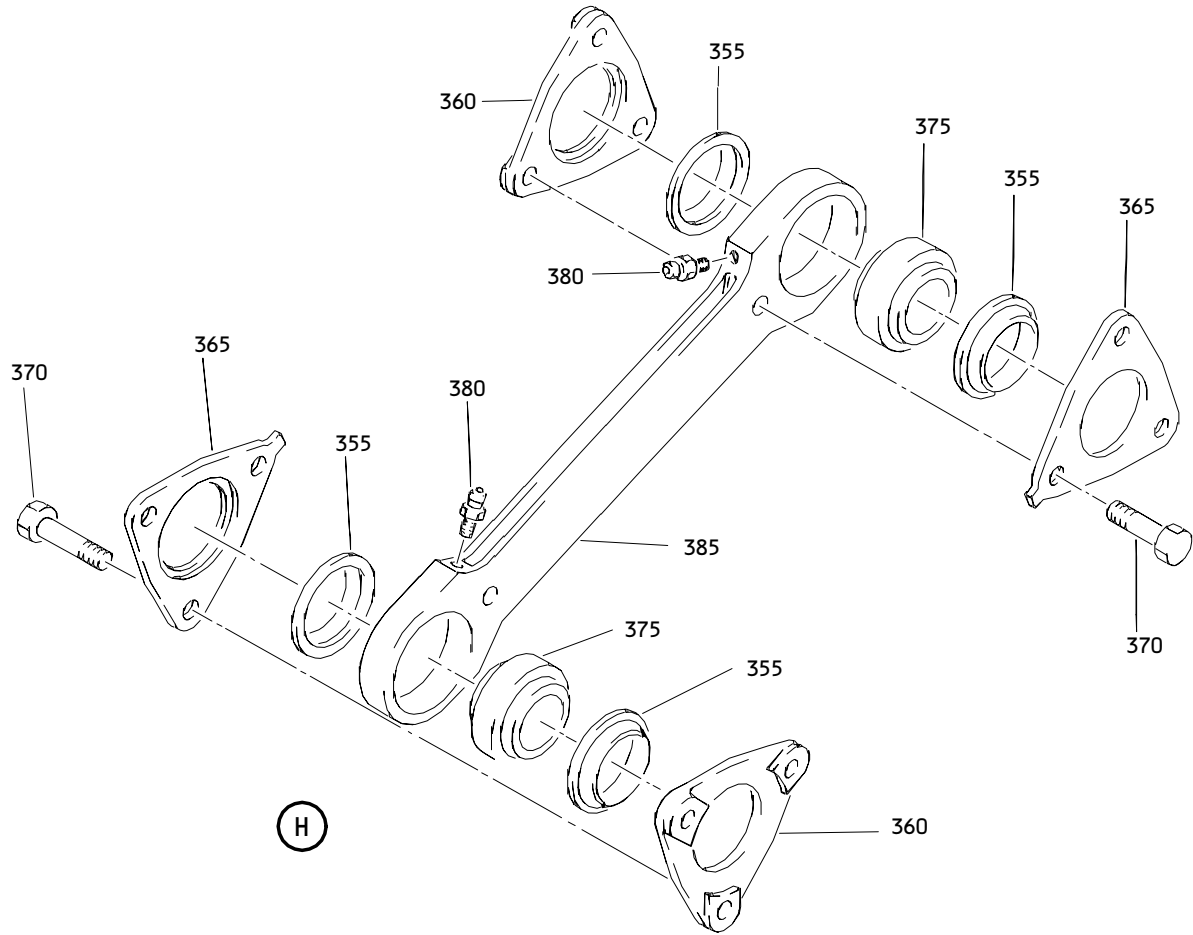
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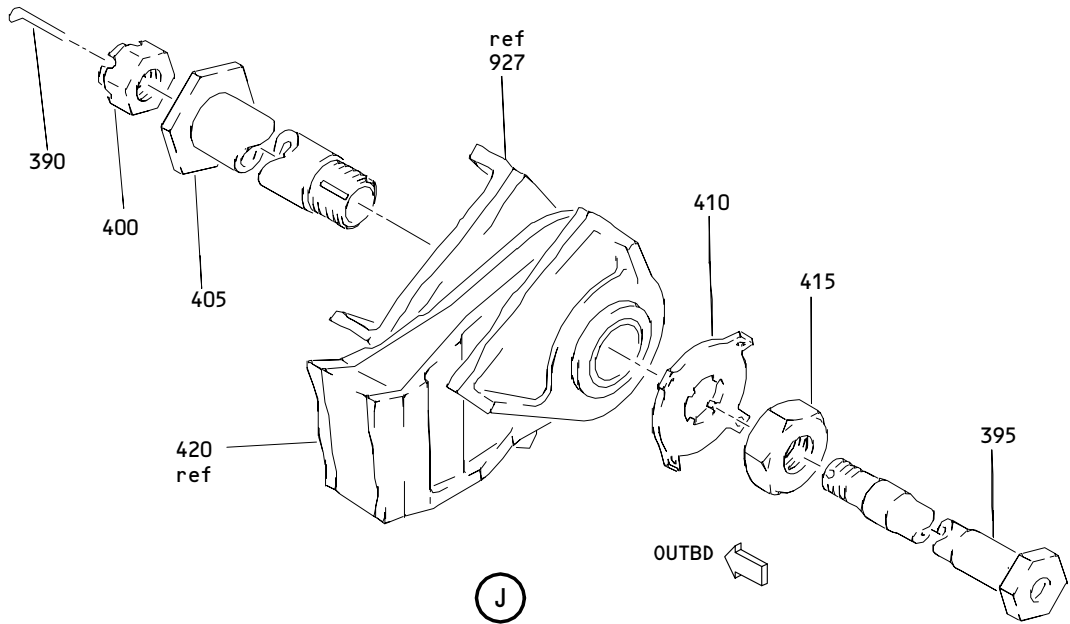
Inboard Trailing Edge Flap Linkage Assembly
Figure 1 (Sheet 2)

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(H)



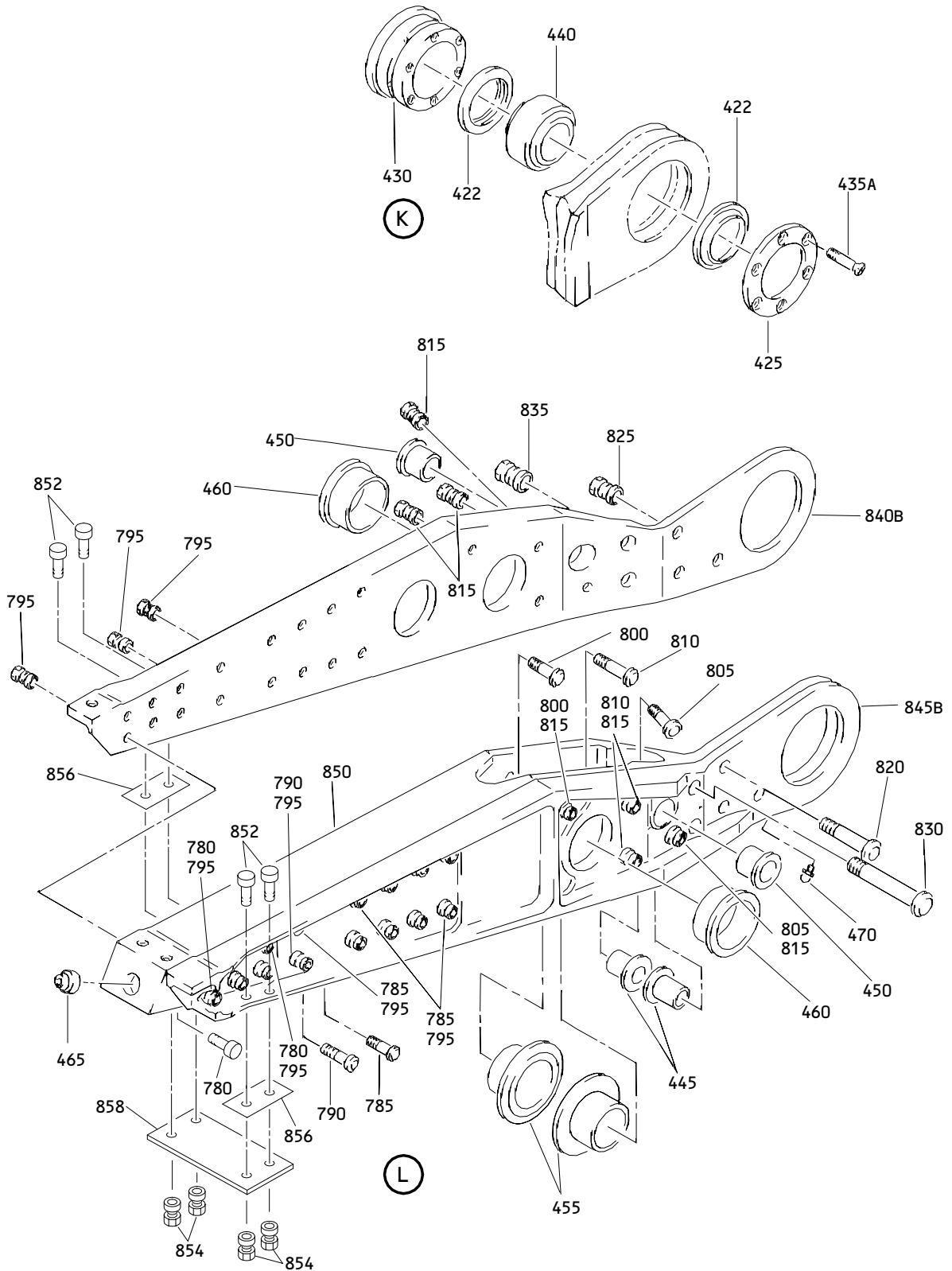
(J)

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

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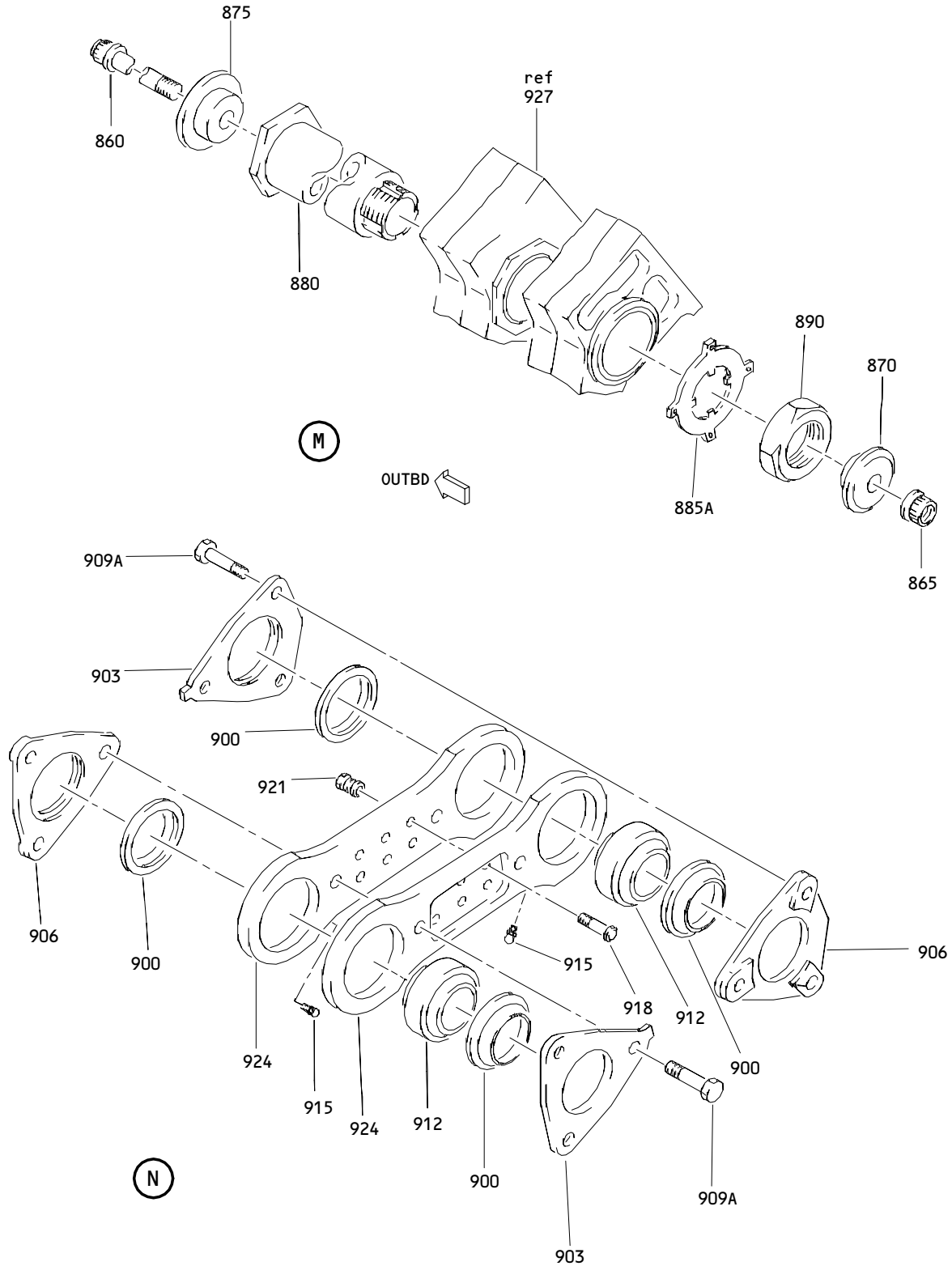
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Inboard Trailing Edge Flap Linkage Assembly
Figure 1 (Sheet 6)

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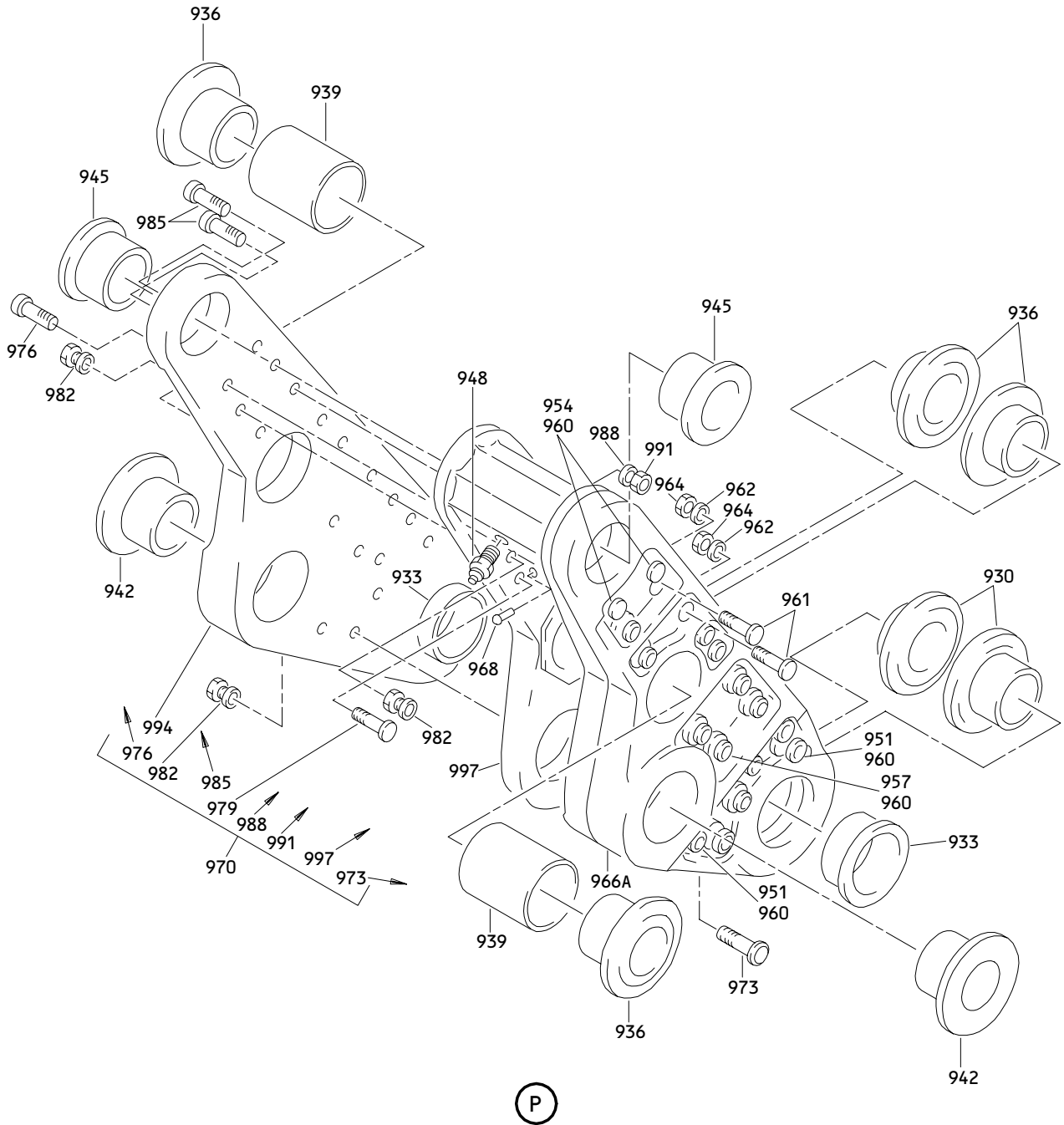
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**Inboard Trailing Edge Flap Linkage Assembly
 Figure 1 (Sheet 7)**

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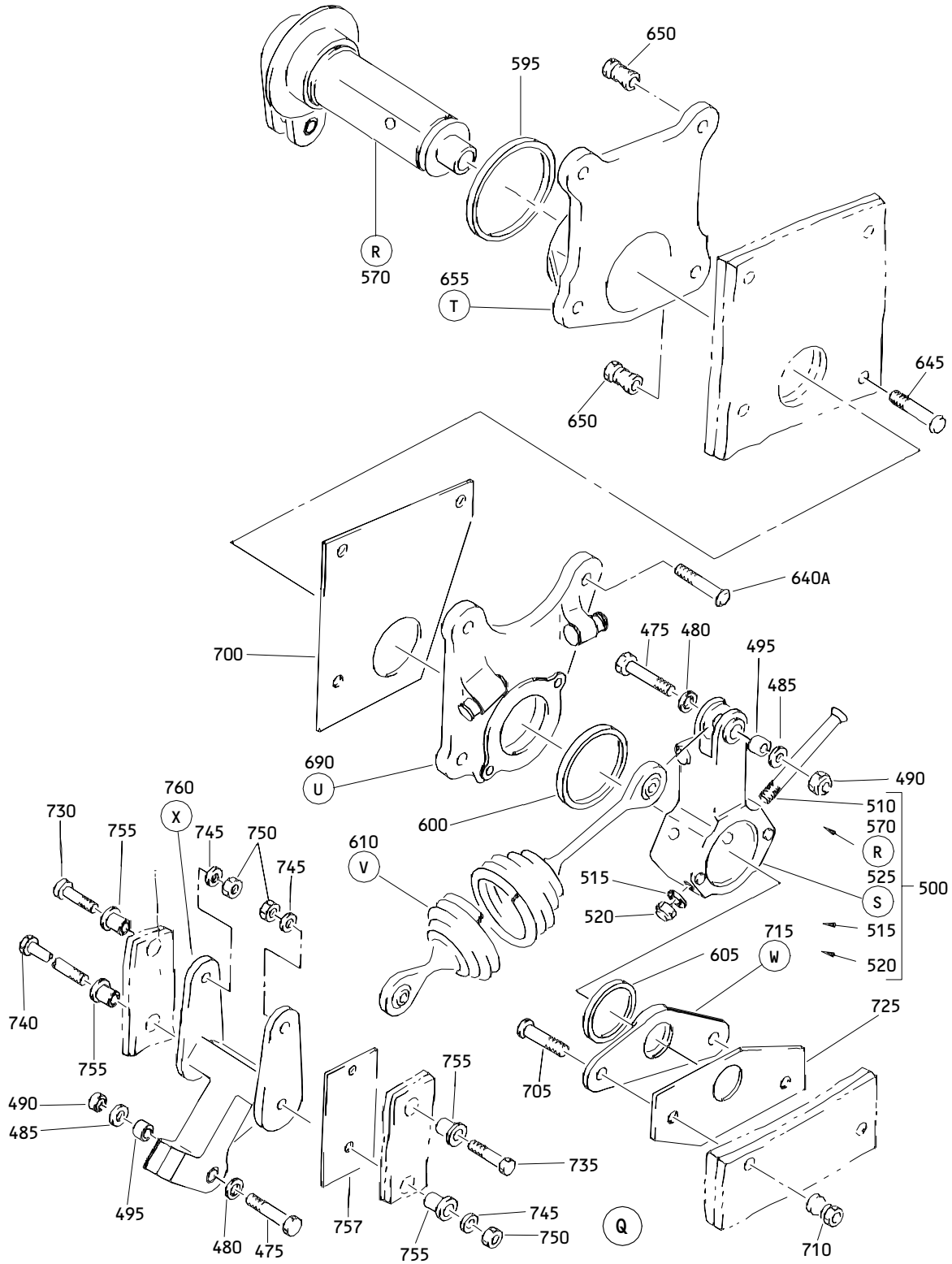
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Inboard Trailing Edge Flap Linkage Assembly
Figure 1 (Sheet 8)

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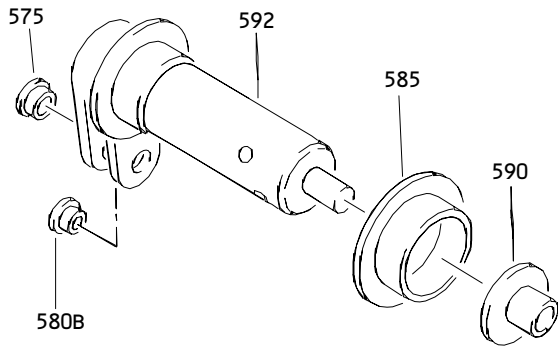
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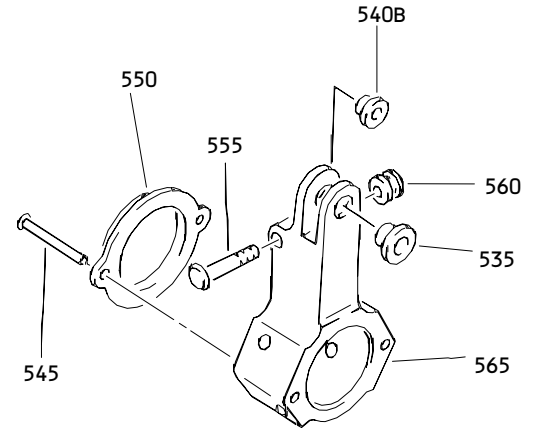
Inboard Trailing Edge Flap Linkage Assembly
Figure 1 (Sheet 9)

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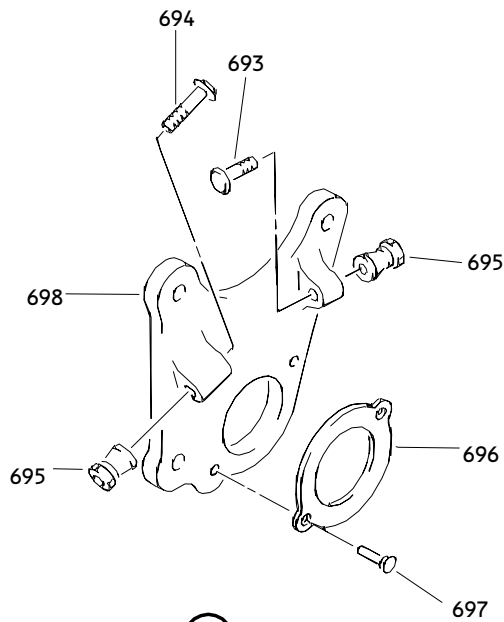
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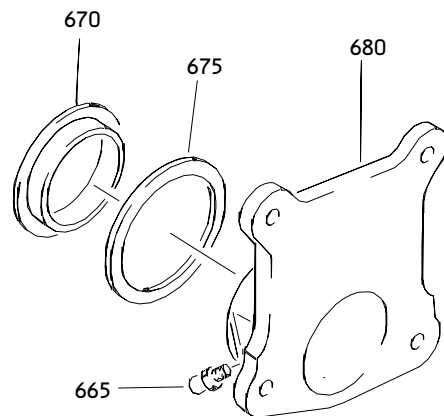
(R)



(S)



(U)

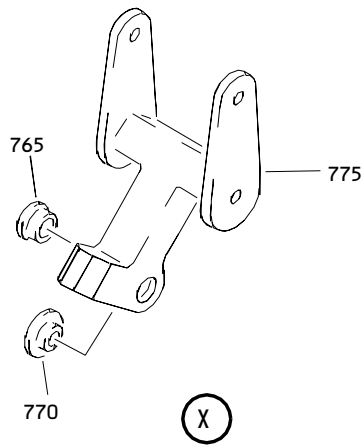
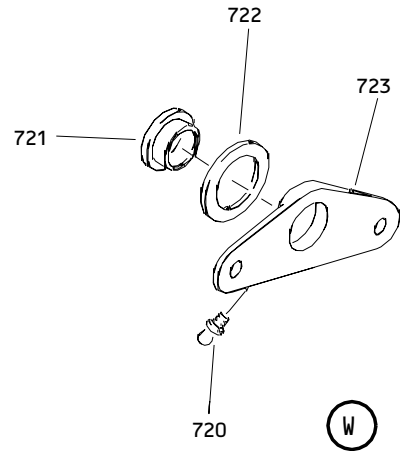
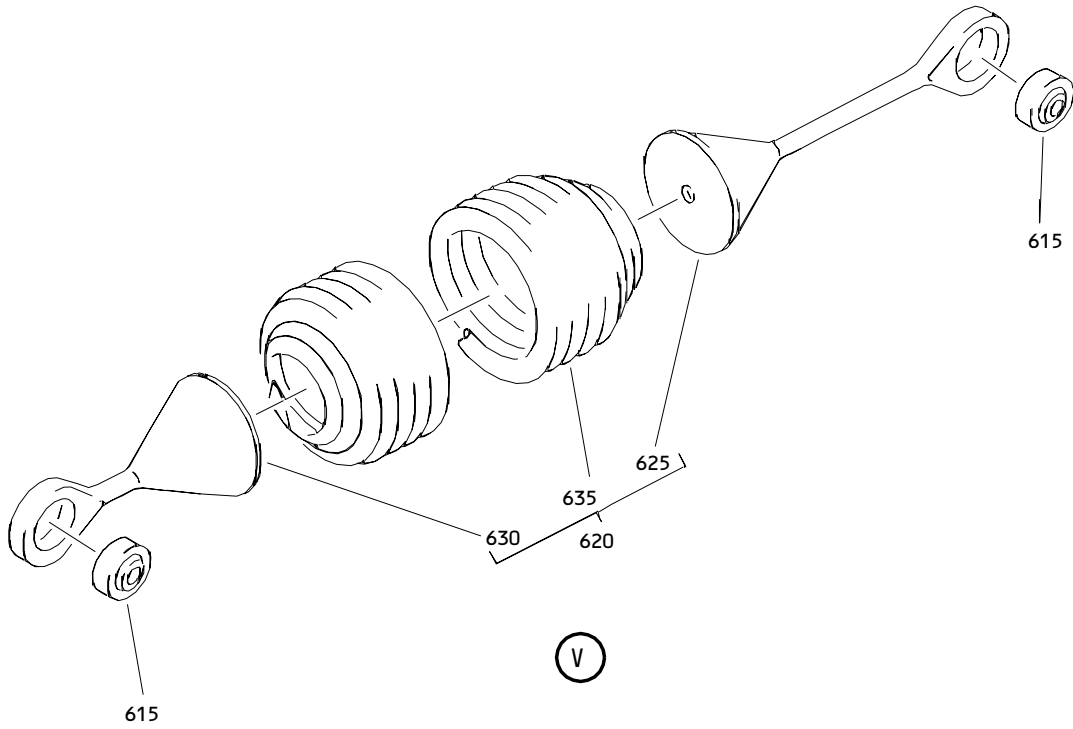


(T)

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

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

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-1	113T2000-3		LINKAGE ASSY-INBD TE FLAP	A	RF
-5	113T2000-4		LINKAGE ASSY-INBD TE FLAP	B	RF
-6	113T2000-5007		.LINKAGE ASSY- (REPLS ITEM 6C) (REPLD BY ITEMS 6A, 6B)	A	1
-6A	113T2000-5005		.LINKAGE ASSY- (REPLS ITEMS 6, 6C) (REPLD BY ITEM 6B)	A	1
-6B	113T2000-5021		.LINKAGE ASSY- (REPLS ITEMS 6, 6A, 6C)	A	1
-6C	113T2000-5023		.LINKAGE ASSY- (REPLD BY ITEMS 6, 6A, 6B)	A	1
-7	113T2000-5008		.LINKAGE ASSY- (REPLS ITEM 7C) (REPLD BY ITEMS 7A, 7B)	B	1
-7A	113T2000-5006		.LINKAGE ASSY- (REPLS ITEM 7, 7C) (REPLD BY ITEM 7B)	B	1
-7B	113T2000-5022		.LINKAGE ASSY- (REPLS ITEMS 7, 7A, 7C)	B	1
-7C	113T2000-5024		.LINKAGE ASSY- (REPLD BY ITEMS 7, 7A, 7B)	B	1
10	MS24665-376		..PIN-COTTER		2
15	113T1264-6		..PIN-INNER (OPT ITEM 15A)		2
-15A	113T1264-41		..PIN-INNER (OPT ITEM 15)		2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-20	113T1254-11		..WASHER-SPECIAL		AR
25	BACN10JD114AU		..NUT- (V15653) (SPEC BACN10JD114AU) (OPT BACN10JD114AU (V56878)) (OPT BACN10JD114AU (V72962)) (OPT BACN10JD114AU (V92595))		2
30	113T1263-8		..PIN-OUTER		2
35	113T1254-4		..WASHER-SPECIAL		2
40	113T1262-4		..NUT-SPECIAL		2
45	113T1223-1		..LINK ASSY (PRE SB 767-27-0196)		1
-45A	113T1223-1		..LINK ASSY (POST SB 767-27-0196) (OPT ITEM 45B)		1
-45B	113T1223-47		..LINK ASSY (POST SB 767-27-0196) (OPT ITEM 45A)		1
50	113T1256-25		...SEAL		4
55	113T1267-16		...PLATE-RTNR (OPT ITEMS 55A, 55B)		2
-55A	113T1267-1		...PLATE-RTNR (OPT ITEMS 55, 55B)		2
-55B	113T1267-22		...PLATE-RTNR (OPT ITEMS 55, 55A)		2
60	113T1267-15		...RETAINER-BRG (OPT ITEMS 60A, 60B)		2
-60A	113T1267-2		...RETAINER-BRG (OPT ITEMS 60, 60B)		2
-60B	113T1267-21		...RETAINER-BRG (OPT ITEMS 60, 60A)		2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-65	BACB30LJ4HSU20		...BOLT- (V06725) (SPEC BACB30LJ4HSU20) (OPT BACB30LJ4HSU20 (V06950)) (OPT BACB30LJ4HSU20 (V08524)) (OPT BACB30LJ4HSU20 (V17943)) (OPT BACB30LJ4HSU20 (V80539)) (OPT BACB30LJ4HSU20 (V92215)) (OPT BACB30LJ4HSU20 (V27624)) (OPT BACB30LJ4HSU20 (V97928))		6
70 70A	LHCB28BAD ASSB28-19		DELETED ...BEARING- (V15860) (SPEC 60B00180-241) (OPT ASB28-102 (VS0352)) (OPT LHCB23BAD (V73134)) (USED ON ITEM 45) (PRE SB 767-27-0196)		2
-70B	BACB10JA28- ABNJ01		...BEARING- (USED ON ITEM 45A) (POST SB 767-27-0196)		2
-70C	BACB10JA28- ABNJ01		...BEARING- (USED ON ITEM 45B)		2
75	MS15004-1		...FITTING		2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-80	HL10VAZ8-16		...BOLT- (V56878) (SPEC BACB30MY8K16) (OPT B30MY8K16 (V97928)) (OPT HL10VAZ8-16 (V73197)) (OPT HL10VAZ8-16 (V92215)) (OPT HL10VAZ8-16 (V97928)) (OPT L8008K16 (V06725)) (OPT HL10VAZ8-16 (V08524))		5
85	HL97DU8		...COLLAR- (V73197) (SPEC BACC30AB8S) (OPT HL97DU8 (V92215)) (OPT HL97DU8 (V56878))		5
90	113T1223-3		...SEGMENT-OUTER		2
95	113T1223-2		...SEGMENT-INNER		1
100	MS24665-376		..PIN-COTTER		1
105	113T1264-2		..PIN-INNER (OPT ITEM 105A)		1
-105A	113T1264-37		..PIN-INNER (OPT ITEM 105)		1
110	113T1254-13		..WASHER-SPECIAL		1
115	BACN10JD112AU		..NUT- (V15653) (SPEC BACN10JD112AU) (OPT BACN10JD112AU (V56878)) (OPT BACN10JD112AU (V72962)) (OPT BACN10JD112AU (V92595))		1
120	113T1263-2		..PIN-OUTER		1
125	113T1254-9		..WASHER-SPECIAL		1
130	113T1262-3		..NUT-SPECIAL		1
133	113T1256-27		..SEAL- (OPT ITEM 133A)		6

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BOEING
COMPONENT
MAINTENANCE MANUAL

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-133A	113T1256-49		..SEAL- (OPT ITEM 133)		6
135	113T1222-1		..BEAM ASSY-SPRT (OPT ITEMS 135A, 135B) (USED ON ITEMS 6, 6C, 7, 7C)		1
-135A	113T1222-5		..BEAM ASSY-SPRT (OPT ITEM 135, 135B) (USED ON ITEMS 6, 6C, 7, 7C)		1
-135B	113T1222-9		..BEAM ASSY-SPRT (OPT ITEMS 135, 135A) (USED ON ITEMS 6, 6C, 7, 7C)		1
-135C	113T1222-1		..BEAM ASSY-SPRT (USED ON ITEMS 6A, 7A) (OPT ITEM 135D)		1
-135D	113T1222-9		..BEAM ASSY-SPRT (USED ON ITEMS 6A, 7A) (OPT ITEM 135C)		1
-135E	113T1222-1		..BEAM ASSY-SPRT (REPLD BY ITEM 135F) (USED ON ITEMS 6B, 7B)		1
-135F	113T1222-9		..BEAM ASSY-SPRT (REPLS ITEM 135E) (USED ON ITEMS 6B, 7B)		1
140	113T1347-40		...BUSHING		2
145	113T1347-55		...BUSHING		2
150	113T1347-64		...SPACER		2
155	113T1347-42		...BUSHING		2
160	113T1347-43		...BUSHING		2
165	113T1347-44		...BUSHING		2
170	113T1347-41		...BUSHING		2
175	MS15001-1		...FITTING		1
180	MS15001-3		...FITTING		2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-185	HL10VAZ10-6		...BOLT- (V56878) (SPEC BACB30MY10K6) (OPT B30MY10K6 (V97928)) (OPT HL10VAZ10-6 (V73197)) (OPT HL10VAZ10-6 (V92215)) (OPT HL10VAZ10-6 (V97928)) (OPT L80010K6 (V06725)) (OPT HL10VAZ10-6 (V08524))		12
190	HL10VAZ10-7		...BOLT- (V56878) (SPEC BACB30MY10K7) (OPT B30MY10K7 (V97928)) (OPT HL10VAZ10-7 (V73197)) (OPT HL10VAZ10-7 (V92215)) (OPT HL10VAZ10-7 (V97928)) (OPT L80010K7 (V06725)) (OPT HL10VAZ10-7 (V08524))		16
195	HL10VAZ10-9		...BOLT- (V56878) (SPEC BACB30MY10K9) (OPT B30MY10K9 (V97928)) (OPT HL10VAZ10-9 (V73197)) (OPT HL10VAZ10-9 (V92215)) (OPT HL10VAZ10-9 (V97928)) (OPT L80010K9 (V06725)) (OPT HL10VAZ10-9 (V08524))		8

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-200	HL79-10		...COLLAR- (V56878) (SPEC BACC30M10) (OPT HL79-10 (V73197)) (OPT HL79-10 (V92215)) (OPT 66014-10 (V56878))		36
205	HL10VAZ12-11		...BOLT- (V56878) (SPEC BACB30MY12K11) (OPT B30MY12K11 (V97928)) (OPT HL10VAZ12-11 (V73197)) (OPT HL10VAZ12-11 (V92215)) (OPT HL10VAZ12-11 (V97928)) (OPT L80012K11 (V06725)) (OPT HL10VAZ12-11 (V08524))		4
210	HL10VAZ12-14		...BOLT- (V56878) (SPEC BACB30MY12K14) (OPT B30MY12K14 (V97928)) (OPT HL10VAZ12-14 (V73197)) (OPT HL10VAZ12-14 (V92215)) (OPT HL10VAZ12-14 (V97928)) (OPT L80012K14 (V06725)) (OPT HL10VAZ12-14 (V08524))		8

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-215	HL10VAZ12-16		...BOLT- (V56878) (SPEC BACB30MY12K16) (OPT B30MY12K16 (V97928)) (OPT HL10VAZ12-16 (V73197)) (OPT HL10VAZ12-16 (V92215)) (OPT HL10VAZ12-16 (V97928)) (OPT L80012K16 (V06725)) (OPT HL10VAZ12-16 (V08524))		4
220	HL79-12		...COLLAR- (V56878) (SPEC BACC30M12) (OPT HL79-12 (V73197)) (OPT HL79-12 (V92215)) (OPT 66014-12 (V56878))		16
225	HL10VAZ14-16		...BOLT- (V56878) (SPEC BACB30MY14K16) (OPT B30MY14K16 (V97928)) (OPT HL10VAZ14-16 (V73197)) (OPT HL10VAZ14-16 (V92215)) (OPT HL10VAZ14-16 (V97928)) (OPT L80014K16 (V06725)) (OPT HL10VAZ14-16 (V08524))		4

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-230	HL79-14		...COLLAR- (V56878) (SPEC BACC30M14) (OPT HL79-14 (V73197)) (OPT HL79-14 (V92215)) (OPT 66014-14 (V56878))		4
235	113T1222-3		...STRAP-OUTER (USED ON ITEMS 135, 135A, 135C, 135E)		1
-237	113T1222-3		...STRAP-OUTER (OPT ITEM 237A) (USED ON ITEMS 135B, 135D, 135F)		1
-237A	113T1222-7		...STRAP-OUTER (OPT ITEM 237) (USED ON ITEMS 135B, 135D, 135F)		1
240	113T1222-4		...STRAP-OUTER (USED ON ITEMS 135, 135A, 135C, 135E)		1
-243	113T1222-4		...STRAP-OUTER (OPT ITEM 243A) (USED ON ITEMS 135B, 135D, 135F)		1
-243A	113T1222-8		...STRAP-OUTER (OPT ITEM 243) (USED ON ITEMS 135B, 135D, 135F)		1
245	113T1222-2		...BEAM-INNER (USED ON ITEMS 135, 135B, 135C, 135D, 135E, 135F)		1
-245A	113T1222-6		...BEAM-INNER (USED ON ITEM 135A)		1
250	MS24665-376		..PIN-COTTER		1
255	113T1264-3		..PIN-INNER (OPT ITEM 255A)		1
-255A	113T1264-38		..PIN-INNER (OPT ITEM 255)		1
260	113T1254-13		..WASHER-SPECIAL		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-265	BACN10JD112AU		..NUT- (V15653) (SPEC BACN10JD112AU) (OPT BACN10JD112AU (V56878)) (OPT BACN10JD112AU (V72962)) (OPT BACN10JD112AU (V92595))		1
270	113T1263-6		..PIN-OUTER		1
275	113T1105-9		..WASHER-SPECIAL		AR
280	113T1254-3		..WASHER-SPECIAL		1
285	113T1262-3		..NUT-SPECIAL		1
290	113T1229-1		..LINK ASSY-SPRT (OPT ITEM 290A) (USED ON ITEMS 6, 6C)	A	1
-290A	113T1229-5		..LINK ASSY-SPRT (OPT ITEM 290) (USED ON ITEMS 6, 6C)	A	1
-290B	113T1229-1		..LINK ASSY-SPRT (USED ON ITEMS 6A, 6B)	A	1
-295	113T1229-2		..LINK ASSY-SPRT (OPT ITEM 295A) (USED ON ITEMS 7, 7C)	B	1
-295A	113T1229-6		..LINK ASSY-SPRT (OPT ITEM 295) (USED ON ITEMS 7, 7C)	B	1
-295B	113T1229-2		..LINK ASSY-SPRT (USED ON ITEMS 7A, 7B)	B	1
300	BACB28AM11B040A		...BUSHING- (V23294) (SPEC BACB28AM11B040A) (OPT BACB28AM11B040A (V70265)) (OPT BACB28AM11B040A (V94892))		1
305	BACB28AP08P040		...BUSHING- (V23294) (SPEC BACB28AP08P040) (OPT BACB28AP08P040 (V70265)) (OPT BACB28AP08P040 (V94892))		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
310	113T1347-68		...BUSHING		1
315	113T1347-69		...BUSHING		1
320	113T1347-70		...BUSHING		1
325	113T1347-72		...BUSHING		1
330	113T1347-63		...SPACER		1
335	MS15001-1		...FITTING		1
340	113T1229-3		...LINK- (USED ON ITEMS 290, 290B)	A	1
-340A	113T1229-7		...LINK- (USED ON ITEM 290A)	A	1
-345	113T1229-4		...LINK- (USED ON ITEMS 295, 295B)	B	1
-345A	113T1229-8		...LINK- (USED ON ITEM 295A)	B	1
350	113T1225-1		..LINK ASSY-SPRT		2
355	113T1256-22		...SEAL		4
360	113T1267-17		...RETAINER-BRG (OPT ITEM 360A, 360B)		2
-360A	113T1267-3		...RETAINER-BRG (OPT ITEM 360, 360B)		2
-360B	113T1267-23		...RETAINER-BRG (OPT ITEM 360, 360A)		2
365	113T1267-18		...PLATE-RTNR (OPT ITEM 365A, 365B)		2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-365A	113T1267-4		...PLATE-RTNR (OPT ITEM 365, 365B)		2
-365B	113T1267-24		...PLATE-RTNR (OPT ITEM 365, 365A)		2
370	BACB30LJ4H10		...BOLT- (V06725) (SPEC BACB30LJ4H10) (OPT BACB30LJ4H10 (V06950)) (OPT BACB30LJ4H10 (V08524)) (OPT BACB30LJ4H10 (V17943)) (OPT BACB30LJ4H10 (V80539)) (OPT BACB30LJ4H10 (V92215)) (OPT BACB30LJ4H10 (V27624)) (OPT BACB30LJ4H10 (V97928))		6
375	LHCB24BA		DELETED		
-375A	ASSB24-101		DELETED		
-375B	BLP24F230		...BEARING- (V16746) (SPEC 60B00180-230) (OPT ASB24-101 (VS0352)) (OPT LHCB24BA (V73134))		2
380	MS15004-1		...FITTING		2
385	113T1225-2		...LINK		1
390	MS24665-376		..PIN-COTTER		1
395	113T1264-7		..PIN-INNER (OPT ITEM 395A)		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01- -395A	113T1264-42		..PIN-INNER (OPT ITEM 395)		1
400	BACN10JD114AU		..NUT- (V15653) (SPEC BACN10JD114AU) (OPT BACN10JD114AU (V56878)) (OPT BACN10JD114AU (V72962)) (OPT BACN10JD114AU (V92595))		1
405	113T1263-7		..PIN-OUTER		1
405	113T1263-7		..PIN-OUTER		1
410	113T1254-6		..WASHER-SPECIAL		1
415	113T1262-6		..NUT-SPECIAL		1
420	113T1226-11		DELETED		
420A	113T1226-13		DELETED		
420B	113T1226-17		..BEAM ASSY-SPRT (OPT ITEM 420C) (USED ON ITEM 6)	A	1
-420C	113T1226-19		..BEAM ASSY-SPRT (OPT ITEM 420B) (USED ON ITEM 6)	A	1
-420D	113T1226-25		..BEAM ASSY-SPRT (OPT ITEM 420E) (USED ON ITEM 6C)	A	1
-420E	113T1226-27		..BEAM ASSY-SPRT (OPT ITEM 420D) (USED ON ITEM 6C)	A	1
-420F	113T1226-17		..BEAM ASSY-SPRT (USED ON ITEM 6A)	A	1
-420G	113T1226-25		..BEAM ASSY-SPRT (USED ON ITEM 6B)	A	1
421	113T1226-12		DELETED		
421A	113T1226-14		DELETED		
421B	113T1226-18		..BEAM ASSY-SPRT (OPT ITEM 421C) (USED ON ITEM 7)	B	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01- -421C	113T1226-20		..BEAM ASSY-SPRT (OPT ITEM 421B) (USED ON ITEM 7)	B	1
-421D	113T1226-26		..BEAM ASSY-SPRT (OPT ITEM 421E) (USED ON ITEM 7C)	B	1
-421E	113T1226-28		..BEAM ASSY-SPRT (OPT ITEM 421D) (USED ON ITEM 7C)	B	1
-421F	113T1226-18		..BEAM ASSY-SPRT (USED ON ITEM 7A)	B	1
-421G	113T1226-26		..BEAM ASSY-SPRT (USED ON ITEM 7B)	B	1
422	113T1256-21		...SEAL		2
425	113T1267-7		...PLATE-RTNR		1
430	113T1267-8		...RETAINER		1
435	BACB30LR3P26		DELETED		
435A	BACB30LR3P20		...BOLT- (V06710) (SPEC BACB30LR3P20) (OPT BACB30LR3P20 (V06725)) (OPT BACB30LR3P20 (V06950)) (OPT BACB30LR3P20 (V08524)) (OPT BACB30LR3P20 (V17943)) (OPT BACB30LR3P20 (V27624)) (OPT BACB30LR3P20 (V80539)) (OPT BACB30LR3P20 (V92215)) (OPT BACB30LR3P20 (V97928))		6

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01- 440 440A	LHCB26BAD HSP26-108		DELETED ...BEARING- (V02758) (SPEC 60B00180-237) (OPT ASB26-103 (VS0352)) (OPT LHCB26BAD (V73134)) (OPT BLP28F237 (V16746))		1
445	113T1347-58		...BUSHING		2
450	113T1347-59		...BUSHING		2
455	113T1347-43		...BUSHING		2
460	113T1347-44		...BUSHING		2
465	ADW5V301NC		...BEARING- (V15860) (SPEC BACB10FA05GC) (OPT KSC152200BZ5CC (V50632)) (OPT KWDB5-35 (V97613)) (OPT WHTFA05VC (V50294)) (OPT WRRS05FAGC (V73134))		1
470	MS15001-1		...FITTING		1
475	BACB30LE4-16		...BOLT- (V06710) (SPEC BACB30LE4-16) (OPT BACB30LE4-16 (V06725)) (OPT BACB30LE4-16 (V08524)) (OPT BACB30LE4-16 (V17943)) (OPT BACB30LE4-16 (V27624)) (OPT BACB30LE4-16 (V80539)) (OPT BACB30LE4-16 (V92215)) (OPT BACB30LE4-16 (V93907)) (OPT BACB30LE4-16 (V97928))		2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-480	BACW10BP4C		...WASHER- (V10630) (SPEC BACW10BP4C)		2
485	BACW10BP4P		...WASHER- (V10630) (SPEC BACW10BP4P)		2
490	NAS1804-4		...NUT		2
495	BACB28AK04-035		...BUSHING- (V23294) (SPEC BACB28AK04-035) (OPT BACB28AK04-035 (V70265)) (OPT BACB28AK04-035 (V94892))		2
500	113T1737-1		...SHAFT ASSY-BELCRK (OPT ITEM 500A) (USED ON ITEMS 420D, 420G)	A	1
-500A	113T1737-9		...SHAFT ASSY-BELCRK (OPT ITEM 500) (USED ON ITEMS 420D, 420G)	A	1
-500B	113T1737-1		...SHAFT ASSY-BELCRK (REPLD BY ITEM 500C) (USED ON ITEMS 420B, 420F)	A	1
-500C	113T1737-9		...SHAFT ASSY-BELCRK (REPLS ITEM 500B) (USED ON ITEMS 420B, 420F)	A	1
-500D	113T1737-1		...SHAFT ASSY-BELCRK (USED ON ITEMS 420C, 420E)	A	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-505	113T1737-2		...SHAFT ASSY-BELCRK (OPT ITEM 505A) (USED ON ITEMS 421D, 421G)	B	1
-505A	113T1737-10		...SHAFT ASSY-BELCRK (OPT ITEM 505) (USED ON ITEMS 421D, 421G)	B	1
-505B	113T1737-2		...SHAFT ASSY-BELCRK (REPLD BY ITEM 505C) (USED ON ITEMS 421B, 421F)	B	1
-505C	113T1737-10		...SHAFT ASSY-BELCRK (REPLS ITEM 505B) (USED ON ITEMS 421B, 421F)	B	1
-505D	113T1737-2		...SHAFT ASSY-BELCRK (USED ON ITEMS 421C, 421E)	B	1
510	BACB30LH4-38		...BOLT- (V06710) (SPEC BACB30LH4-38) (OPT BACB30LH4-38 (V06725)) (OPT BACB30LH4-38 (V06950)) (OPT BACB30LH4-38 (V08524)) (OPT BACB30LH4-38 (V17943)) (OPT BACB30LH4-38 (V27624)) (OPT BACB30LH4-38 (V80539)) (OPT BACB30LH4-38 (V92215)) (OPT BACB30LH4-38 (V97928))		2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01- 515 520	AN960C416 H01-4BAC	WASHER-NUT- (V15653) (SPEC BACN10JC4CM) (OPT NS202101SE048 (V80539)) (OPT T6C428JM (V11815)) (OPT VN303D048 (V92215)) (OPT 109LH9075-4W (V72962)) (OPT 97E48 (V80539))		2 2
525	113T1737-5	BELLCRANK ASSY- (USED ON ITEMS 500, 500B, 500D)	A	1
525A -525B	113T1737-14 113T1737-13		DELETEDBELLCRANK ASSY- (OPT ITEM 525C) (USED ON ITEMS 500A, 500C)	A	1
-525C	113T1737-5	BELLCRANK ASSY- (OPT ITEM 525B) (USED ON ITEMS 500A, 500C)	A	1
530	113T1737-6	BELLCRANK ASSY- (USED ON ITEMS 505, 505B, 505D)	B	1
530A -530B	113T1737-13 113T1737-14		DELETEDBELLCRANK ASSY- (OPT ITEM 530C) (USED ON ITEMS 505A, 505C)	B	1
-530C	113T1737-6	BELLCRANK ASSY- (OPT ITEM 530B) (USED ON ITEMS 505A, 505C)	B	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-535	BACB28AM06B019A	BUSHING- (V23294) (SPEC BACB28AM06B019A) (OPT BACB28AM06B019A (V70265)) (OPT BACB28AM06B019A (V94892)) (USED ON ITEMS 525, 525A, 530A)		1
-535A	BACB28AM06B013A	BUSHING- (V23294) (SPEC BACB28AM06B013A) (OPT BACB28AM06B013A (V70265)) (OPT BACB28AM06B013A (V94892)) (USED ON ITEM 530)	B	1
540	113T1347-79		DELETED		
540A	113T1347-80		DELETED		
540B	113T1347-79	BUSHING		1
545	BACR15BA5AD	RIVET- (SIZE DETERMINE ON INST)		2
550	113T1737-8	SPACER		1
555	HL440UC8-15	BOLT- (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))		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-560	HL79-8	COLLAR- (V56878) (SPEC BACC30M8) (OPT HL79-8 (V73197)) (OPT HL79-8 (V92215)) (OPT 66014-8 (V56878))		1
565	113T1737-7	BELLCRANK- (USED ON ITEMS 525, 530)		1
-565A	113T1397-1	BELLCRANK- (USED ON ITEMS 525A, 530A)		1
570	113T1737-3	SHAFT ASSY- (USED ON ITEMS 500, 500B, 500D, 505, 505B, 505D)		1
570A	113T1397-11		DELETED		
-570B	113T1737-11	SHAFT ASSY- (USED ON ITEMS 500A, 500C, 505A, 505C)		1
575	BACB28AM07B019A	BUSHING- (V23294) (SPEC BACB28AM07B019A) (OPT BACB28AM07B019A (V70265)) (OPT BACB28AM07B019A (V94892))		1
580	113T1347-80		DELETED		
580A	113T1347-79		DELETED		
580B	113T1347-80	BUSHING		1
585	113T1347-81	BUSHING		1
590	113T1347-82	BUSHING		1
592	113T1737-4	SHAFT- (USED ON ITEM 570)		1
-593	113T1737-12	SHAFT-FORGED (USED ON ITEM 570B)		1
595	113T1256-40		...SEAL- (OPT ITEM 595A)		1
-595A	113T1256-53		...SEAL- (OPT ITEM 595)		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-600	113T1256-41		...SEAL- (OPT ITEM 600A)		1
-600A	113T1256-54		...SEAL- (OPT ITEM 600)		1
605	113T1256-42		...SEAL- (OPT ITEM 605A)		1
-605A	113T1256-55		...SEAL- (OPT ITEM 605)		1
610	113T1731-1		...SPRING ASSY		1
615	ADB4V301NC	BEARING- (V15860) (SPEC BACB10FB04GC) (OPT HTFB04 (V50294)) (OPT KNDB4-70 (V97613)) (OPT KSC145700BZ4GC (V50632)) (OPT NRRS04FBGC (V73134)) (OPT WES04GC (V73134))		2
620	113T1731-2	SUB ASSY		1
625	113T1716-1	TERMINAL		1
630	113T1716-2	TERMINAL		1
635	113T1731-3	SPRING		1
640	BACB10MY8K19		DELETED		
640A	HL10VAZ8-21		...BOLT- (V56878) (SPEC BACB30MY8K21) (OPT B30MY8K21 (V97928)) (OPT HL10VAZ8-21 (V73197)) (OPT HL10VAZ8-21 (V92215)) (OPT HL10VAZ8-21 (V97928)) (OPT L8008K21 (V06725)) (OPT HL10VAZ8-21 (V08524))		3

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-645	HL10VAZ8-15		...BOLT- (V56878) (SPEC BACB30MY8K15) (OPT B30MY8K15 (V97928)) (OPT HL10VAZ8-15 (V73197)) (OPT HL10VAZ8-15 (V92215)) (OPT HL10VAZ8-15 (V97928)) (OPT L8008K15 (V06725)) (OPT HL10VAZ8-15 (V08524))		1
650	HL79-8		...COLLAR- (V56878) (SPEC BACC30M8) (OPT HL79-8 (V73197)) (OPT HL79-8 (V92215)) (OPT 66014-8 (V56878))		4
655	113T1739-1		...FITTING ASSY-OUTBD SPRT (OPT ITEM 655A) (USED ON ITEMS 420D, 420G)	A	1
-655A	113T1009-1		...FITTING ASSY-OUTBD SPRT (OPT ITEM 655) (USED ON ITEMS 420D, 420G)	A	1
655B	113T1739-1		DELETED		
-655C	113T1739-1		...FITTING ASSY-OUTBD SPRT (REPLD BY ITEM 655D) (USED ON ITEMS 420B, 420F)	A	1
-655D	113T1009-1		...FITTING ASSY-OUTBD SPRT (REPLS ITEM 655C) (USED ON ITEMS 420B, 420F)	A	1
-655E	113T1739-1		...FITTING ASSY-OUTBD SPRT (USED ON ITEMS 420C, 420E)	A	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-660	113T1739-2		...FITTING ASSY-OUTBD SPRT (OPT ITEM 660B) (USED ON ITEMS 421D, 421G)	B	1
660A	113T1009-1		DELETED		
-660B	113T1009-2		...FITTING ASSY-OUTBD SPRT (OPT ITEM 660) (USED ON ITEMS 421D, 421G)	B	1
660C	113T1739-2		DELETED		
-660D	113T1739-2		...FITTING ASSY-OUTBD SPRT (REPLD BY ITEM 660E) (USED ON ITEMS 421B, 421F)	B	1
-660E	113T1009-2		...FITTING ASSY-OUTBD SPRT (REPLS ITEM 660D) (USED ON ITEMS 421B, 421F)	B	1
-660F	113T1739-2		...FITTING ASSY-OUTBD SPRT (USED ON ITEMS 421C, 421E)	B	1
665	MS15001-1	FITTING-		1
665A	113T1009-2		DELETED		
670	113T1347-83	BUSHING		1
675	113T1347-85	SPACER		1
680	113T1739-3	FITTING-OUTBD SPRT (USED ON ITEMS 655, 655C, 655E)	A	1
-680A	113T1009-3	FITTING-OUTBD SPRT (USED ON ITEMS 655A, 655D)	A	1
-685	113T1739-4	FITTING-OUTBD SPRT (USED ON ITEMS 660, 660D, 660F)	B	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01- -685A	113T1009-4	FITTING-OUTBD SPRT (USED ON ITEMS 660B, 660E)	B	1
690	113T1726-1		...FITTING ASSY-STOP	A	1
-691	113T1726-2		...FITTING ASSY-STOP	B	1
693	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))		1
694	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))		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-695	HL79-8	COLLAR- (V56878) (SPEC BACC30M8) (OPT HL79-8 (V73197)) (OPT HL79-8 (V92215)) (OPT 66014-8 (V56878))		2
696	113T1726-5	PLATE-THRUST		1
697	BACR15BA5AD	RIVET- (SIZE DETERMINE ON INST)		2
698	113T1726-3	FITTING-STOP	A	1
-699	113T1726-4	FITTING-STOP	B	1
700	113T1226-10		...SHIM		1
705	HL10VAZ8-13		...BOLT- (V56878) (SPEC BACB30MY8K13) (OPT B30MY8K13 (V97928)) (OPT HL10VAZ8-13 (V73197)) (OPT HL10VAZ8-13 (V92215)) (OPT HL10VAZ8-13 (V97928)) (OPT L8008K13 (V06725)) (OPT HL10VAZ8-13 (V08524))		2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-710	HL79-8		...COLLAR- (V56878) (SPEC BACC30M8) (OPT HL79-8 (V73197)) (OPT HL79-8 (V92215)) (OPT 66014-8 (V56878))		2
715	113T1719-1		...FITTING ASSY-INBD SPRT	A	1
-718	113T1719-2		...FITTING ASSY-INBD SPRT	B	1
720	MS15001-1	FITTING		1
721	113T1347-84	BUSHING		1
722	113T1347-86	SPACER		1
723	113T1719-3	FITTING-SPRT	A	1
-724	113T1719-4	FITTING-SPRT	B	1
725	113T1226-9		...SHIM		1
730	BACB30LE4-10		...BOLT- (V06710) (SPEC BACB30LE4-10) (OPT BACB30LE4-10 (V06725)) (OPT BACB30LE4-10 (V08524)) (OPT BACB30LE4-10 (V17943)) (OPT BACB30LE4-10 (V27624)) (OPT BACB30LE4-10 (V80539)) (OPT BACB30LE4-10 (V92215)) (OPT BACB30LE4-10 (V93907)) (OPT BACB30LE4-10 (V97928))		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-735	BACB30LE4-11		...BOLT- (V06710) (SPEC BACB30LE4-11) (OPT BACB30LE4-11 (V06725)) (OPT BACB30LE4-11 (V08524)) (OPT BACB30LE4-11 (V17943)) (OPT BACB30LE4-11 (V27624)) (OPT BACB30LE4-11 (V80539)) (OPT BACB30LE4-11 (V92215)) (OPT BACB30LE4-11 (V93907)) (OPT BACB30LE4-11 (V97928))		1
740	BACB30LE4-60		...BOLT- (V06710) (SPEC BACB30LE4-60) (OPT BACB30LE4-60 (V06725)) (OPT BACB30LE4-60 (V08524)) (OPT BACB30LE4-60 (V17943)) (OPT BACB30LE4-60 (V27624)) (OPT BACB30LE4-60 (V80539)) (OPT BACB30LE4-60 (V92215)) (OPT BACB30LE4-60 (V93907)) (OPT BACB30LE4-60 (V97928))		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-745	BACW10BP4P		...WASHER- (V10630) (SPEC BACW10BP4P)		3
750	NAS1804-4		...NUT		3
755	BACB28AM04B038A		...BUSHING- (V23294) (SPEC BACB28AM04B038A) (OPT BACB28AM04B038A (V70265)) (OPT BACB28AM04B038A (V94892))		4
757	113T1226-15		...SHIM		1
760	113T1738-1		...FITTING ASSY-SPR ATTACH (OPT ITEM 760A) (USED ON ITEMS 420D, 420G, 421D, 421G)		1
-760A	113T1743-1		...FITTING ASSY-SPR ATTACH (OPT ITEM 760) (USED ON ITEMS 420D, 420G, 421D, 421G)		1
-760B	113T1738-1		...FITTING ASSY-SPR ATTACH (REPLD BY ITEM 760C) (USED ON ITEMS 420B, 420F, 421B, 421F)		1
-760C	113T1743-1		...FITTING ASSY-SPR ATTACH (REPLS ITEM 760B) (USED ON ITEMS 420B, 420F, 421B, 421F)		1
-760D	113T1738-1		...FITTING ASSY-SPR ATTACH (USED ON ITEMS 420C, 420E, 421C, 421E)		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01- 763 765	113T1738-1 BACB28AM06B019A		DELTEDBUSHING- (V23294) (SPEC BACB28AM06B019A) (OPT BACB28AM06B019A (V70265)) (OPT BACB28AM06B019A (V94892))		1
770 775	113T1347-79 113T1738-2	BUSHINGFITTING- (USED ON ITEMS 760, 760B, 760D)		1 1
-775A	113T1743-2	FITTING- (USED ON ITEMS 760A, 760C)		1
780	HL10VAZ8-4		...BOLT- (V56878) (SPEC BACB30MY8K4) (OPT B30MY8K4 (V97928)) (OPT HL10VAZ8-4 (V73197)) (OPT HL10VAZ8-4 (V92215)) (OPT HL10VAZ8-4 (V97928)) (OPT L8008K4 (V06725)) (OPT HL10VAZ8-4 (V08524))		12

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-785	HL10VAZ8-7		...BOLT- (V56878) (SPEC BACB30MY8K7) (OPT B30MY8K7 (V97928)) (OPT HL10VAZ8-7 (V73197)) (OPT HL10VAZ8-7 (V92215)) (OPT HL10VAZ8-7 (V97928)) (OPT L8008K7 (V06725)) (OPT HL10VAZ8-7 (V08524))		18
790	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 (V08524)) (OPT HL11V7 (V06725))		2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-795	HL79-8		...COLLAR- (V56878) (SPEC BACC30M8) (OPT HL79-8 (V73197)) (OPT HL79-8 (V92215)) (OPT 66014-8 (V56878))		32
800	HL10VAZ10-12		...BOLT- (V56878) (SPEC BACB30MY10K12) (OPT B30MY10K12 (V97928)) (OPT HL10VAZ10-12 (V73197)) (OPT HL10VAZ10-12 (V92215)) (OPT HL10VAZ10-12 (V97928)) (OPT L80010K12 (V06725)) (OPT HL10VAZ10-12 (V08524))		2
805	HL10VAZ10-14		...BOLT- (V56878) (SPEC BACB30MY10K14) (OPT B30MY10K14 (V97928)) (OPT HL10VAZ10-14 (V73197)) (OPT HL10VAZ10-14 (V92215)) (OPT HL10VAZ10-14 (V97928)) (OPT L80010K14 (V06725)) (OPT HL10VAZ10-14 (V08524))		2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-810	HL10VAZ10-16		...BOLT- (V56878) (SPEC BACB30MY10K16) (OPT B30MY10K16 (V97928)) (OPT HL10VAZ10-16 (V73197)) (OPT HL10VAZ10-16 (V92215)) (OPT HL10VAZ10-16 (V97928)) (OPT L80010K16 (V06725)) (OPT HL10VAZ10-16 (V08524))		4
815	HL79-10		...COLLAR- (V56878) (SPEC BACC30M10) (OPT HL79-10 (V73197)) (OPT HL79-10 (V92215)) (OPT 66014-10 (V56878))		8
820 820A	30MY12K21 HL10VAZ12-21		DELTED ...BOLT- (V56878) (SPEC BACB30MY12K21) (OPT B30MY12K21 (V97928)) (OPT HL10VAZ12-21 (V73197)) (OPT HL10VAZ12-21 (V92215)) (OPT HL10VAZ12-21 (V97928)) (OPT L80012K21 (V06725)) (OPT HL10VAZ12-21 (V08524))		3

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-825	HL79-12		...COLLAR- (V56878) (SPEC BACC30M12) (OPT HL79-12 (V73197)) (OPT HL79-12 (V92215)) (OPT 66014-12 (V56878))		3
830	HL10VAZ14-47		...BOLT- (V56878) (SPEC BACB30MY14K47) (OPT B30MY14K47 (V97928)) (OPT HL10VAZ14-47 (V73197)) (OPT HL10VAZ14-47 (V92215)) (OPT HL10VAZ14-47 (V97928)) (OPT L80014K47 (V06725)) (OPT HL10VAZ14-47 (V08524))		2
835	HL79-14		...COLLAR- (V56878) (SPEC BACC30M14) (OPT HL79-14 (V73197)) (OPT HL79-14 (V92215)) (OPT 66014-14 (V56878))		2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
840	113T1226-3		DELETED		
840A	113T1226-7		DELETED		
840B	113T1226-21		...BEAM-OUTER (USED ON ITEMS 420B, 420D, 420F, 420G, 421B, 421D, 421F, 421G)		1
-840C	113T1226-23		...BEAM-OUTER (USED ON ITEMS 420C, 421C, 420E, 421E)		1
845	113T1226-4		DELETED		
845A	113T1226-8		DELETED		
845B	113T1226-22		...BEAM-OUTER (USED ON ITEMS 420B, 420D, 420F, 420G, 421B, 421D, 421F, 421G)		1
-845C	113T1226-24		...BEAM-OUTER (USED ON ITEM 420C, 421C, 420E, 421E)		1
850	113T1226-2		...BEAM-INNER (USED ON ITEMS 420B, 420D, 420F, 420G, 421B, 421D, 421F, 421G)		1
-850A	113T1226-6		...BEAM-INNER (USED ON ITEM 420C, 421C, 420E, 421E)		1
852	HL10VAZ8-6		...BOLT- (V56878) (SPEC BACB30MY8K6) (OPT B30MY8K6 (V97928)) (OPT HL10VAZ8-6 (V73197)) (OPT HL10VAZ8-6 (V92215)) (OPT HL10VAZ8-6 (V97928)) (OPT L8008K6 (V06725)) (OPT HL10VAZ8-6 (V08524)) (USED ON ITEMS 420D, 420E, 420G, 421D, 421E, 421G)		4

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-854	HL79-8		...COLLAR- (V56878) (SPEC BACC30M8) (OPT HL79-8 (V73197)) (OPT HL79-8 (V92215)) (OPT 66014-8 (V56878)) (USED ON ITEMS 420D, 420E, 420G, 421D, 421E, 421G)		4
856	BACS40R11C20F		...SHIM- (USED ON ITEMS 420D, 420E, 420G, 421D, 421E, 421G)		2
858	113T1226-29		...STRAP- (USED ON ITEMS 420D, 420E, 420G, 421D, 421E, 421G)		1
860	BACB30LE6-111		..BOLT- (V06710) (SPEC BACB30LE6-111) (OPT BACB30LE6-111 (V06725)) (OPT BACB30LE6-111 (V08524)) (OPT BACB30LE6-111 (V17943)) (OPT BACB30LE6-111 (V27624)) (OPT BACB30LE6-111 (V80539)) (OPT BACB30LE6-111 (V92215)) (OPT BACB30LE6-111 (V93907)) (OPT BACB30LE6-111 (V97928)) (OPT ITEM 860A)		1
-860A	BACB30MR6K111		..BOLT- (OPT ITEM 860)		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
865	NAS1805-6		..NUT		1
870	113T1258-1		..CAP-END		1
875	113T1258-2		..CAP-END		1
880	113T1263-5		..PIN-OUTER		1
885	113T1254-4		DELETED		
885A	113T1254-46		..WASHER-SPECIAL		1
890	113T1262-4		..NUT-SPECIAL		1
895	113T1224-1		..LINK ASSY-SPRT		1
900	113T1256-20		...SEAL		4
903	113T1267-20		...PLATE-RTNR (OPT ITEMS 903A, 903B)		2
-903A	113T1267-5		...PLATE-RTNR (OPT ITEMS 903, 903B)		2
-903B	113T1267-26		...PLATE-RTNR (OPT ITEMS 903, 903A)		2
906	113T1267-19		...RETAINER-BRG (OPT ITEMS 906A, 906B)		2
-906A	113T1267-6		...RETAINER-BRG (OPT ITEMS 906, 906B)		2
-906B	113T1267-25		...RETAINER-BRG (OPT ITEMS 906, 906A)		2
909	BACB30LJ4HSU20		DELETED		
909A	BACB30LJ4HSU15		...BOLT		6
912	LHCB28BA		DELETED		
912A	BLP28F240		DELETED		
912B	ASSB28-18		...BEARING- (V15860) (SPEC 60B00180-240) (OPT ASB28-101 (VS0352)) (OPT LHCB28BA) (V73134)) (OPT BLP28F240 (V16746))		2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-915	MS15001-1		...FITTING		2
918	HL10VAZ8-8		...BOLT- (V56878) (SPEC BACB30MY8K8) (OPT B30MY8K8 (V97928)) (OPT HL10VAZ8-8 (V73197)) (OPT HL10VAZ8-8 (V92215)) (OPT HL10VAZ8-8 (V97928)) (OPT L8008K8 (V06725)) (OPT HL10VAZ8-8 (V08524))		6
921	HL79-8		...COLLAR- (V56878) (SPEC BACC30M8) (OPT HL79-8 (V73197)) (OPT HL79-8 (V92215)) (OPT 66014-8 (V56878))		6
924	113T1224-2		...LINK HALF		2
927	113T1221-1		DELETED		
927A	113T1221-5		DELETED		
927B	113T1221-14		..LINK ASSY-SPRT DRIVE (OPT ITEMS 927C, 927D) (USED ON ITEMS 6, 6C 7, 7C)		1
-927C	113T1221-13		..LINK ASSY-SPRT DRIVE (OPT ITEMS 927B, 927D) (USED ON ITEMS 6, 6C, 7, 7C)		1
-927D	113T1221-15		..LINK ASSY-SPRT DRIVE (OPT ITEMS 927B, 927C) (USED ON ITEMS 6, 6C, 7, 7C)		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01- -927E	113T1221-13		..LINK ASSY-SPRT DRIVE (OPT ITEM 927F) (USED ON ITEMS 6A, 7A)		1
-927F	113T1221-14		..LINK ASSY-SPRT DRIVE (OPT ITEM 927E) (USED ON ITEMS 6A, 7A)		1
-927G	113T1221-13		..LINK ASSY-SPRT DRIVE (REPLD BY ITEM 927H) (USED ON ITEMS 6B, 7B)		1
-927H	113T1221-14		..LINK ASSY-SPRT DRIVE (REPLS ITEM 927G) (USED ON ITEMS 6B, 7B)		1
930	113T1347-49		...BUSHING		2
933	113T1347-50		...BUSHING		2
936	113T1347-46		...BUSHING		4
939	113T1347-47		...BUSHING		2
942	113T1347-48		...BUSHING		2
945	113T1347-45		...BUSHING		2
948	MS15001-1		...FITTING		1
951	HL10VAZ10-10		...BOLT- (V56878) (SPEC BACB30MY10K10) (OPT B30MY10K10 (V97928)) (OPT HL10VAZ10-10 (V73197)) (OPT HL10VAZ10-10 (V92215)) (OPT HL10VAZ10-10 (V97928)) (OPT L80010K10 (V06725)) (OPT HL10VAZ10-10 (V08524))		6

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-954	HL10VAZ10-12		...BOLT- (V56878) (SPEC BACB30MY10K12) (OPT B30MY10K12 (V97928)) (OPT HL10VAZ10-12 (V73197)) (OPT HL10VAZ10-12 (V92215)) (OPT HL10VAZ10-12 (V97928)) (OPT L80010K12 (V06725)) (OPT HL10VAZ10-12 (V08524))		2
957	HL10VAZ10-14		...BOLT- (V56878) (SPEC BACB30MY10K14) (OPT B30MY10K14 (V97928)) (OPT HL10VAZ10-14 (V73197)) (OPT HL10VAZ10-14 (V92215)) (OPT HL10VAZ10-14 (V97928)) (OPT L80010K14 (V06725)) (OPT HL10VAZ10-14 (V08524))		8
960	HL79-10		...COLLAR- (V56878) (SPEC BACC30M10) (OPT HL79-10 (V73197)) (OPT HL79-10 (V92215)) (OPT 66014-10 (V56878))		16

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-961	BACB30LJ5-14		...BOLT- (V06710) (SPEC BACB30LJ5-14) (OPT BACB30LJ5-14 (V06725)) (OPT BACB30LJ5-14 (V06950)) (OPT BACB30LJ5-14 (V08524)) (OPT BACB30LJ5-14 (V17943)) (OPT BACB30LJ5-14 (V80539)) (OPT BACB30LJ5-14 (V27624)) (OPT BACB30LJ5-14 (V92215)) (OPT BACB30LJ5-14 (V97928))		2
962	AN960PD516L		...WASHER		2
963	113T1221-3		DELETED		
964	H10-5BAC		...NUT- (V15653) (SPEC BACN10JC5) (OPT RMLH9075-5W (V72962)) (OPT T6S524J (V71087)) (OPT 96-054 (V80539)) (OPT BRH10A5 (V52828))		2
966	113T1221-4		DELETED		
966A	113T1447-6		...LINK-SIDE (USED ON ITEMS 927B, 927F, 927H)		1
-966B	113T1221-12		...LINK-SIDE (USED ON ITEMS 927C, 927D, 927E, 927G)		1
968	BACR15BB8D8		...RIVET		1
970	113T1221-18		...LINK ASSY- (USED ON ITEMS 927B, 927F, 927H)		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01- -970A	113T1221-16		...LINK ASSY- (USED ON ITEMS 927C, 927E, 927G)		1
-970B	113T1221-17		...LINK ASSY- (USED ON ITEM 927D)		1
973	HL10VAZ10-10	BOLT- (V56878) (SPEC BACB30MY10K10) (OPT B30MY10K10 (V97928)) (OPT HL10VAZ10-10 (V73197)) (OPT HL10VAZ10-10 (V92215)) (OPT HL10VAZ10-10 (V97928)) (OPT L80010K10 (V06725)) (OPT HL10VAZ10-10 (V08524))		6
976	HL10VAZ10-12	BOLT- (V56878) (SPEC BACB30MY10K12) (OPT B30MY10K12 (V97928)) (OPT HL10VAZ10-12 (V73197)) (OPT HL10VAZ10-12 (V92215)) (OPT HL10VAZ10-12 (V97928)) (OPT L80010K12 (V06725)) (OPT HL10VAZ10-12 (V08524))		2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-979	HL10VAZ10-14	BOLT- (V56878) (SPEC BACB30MY10K14) (OPT B30MY10K14 (V97928)) (OPT HL10VAZ10-14 (V73197)) (OPT HL10VAZ10-14 (V92215)) (OPT HL10VAZ10-14 (V97928)) (OPT L80010K14 (V06725)) (OPT HL10VAZ10-14 (V08524))		10
982	HL79-10	COLLAR- (V56878) (SPEC BACC30M10) (OPT HL79-10 (V73197)) (OPT HL79-10 (V92215)) (OPT 66014-10 (V56878))		18
985	BACB30LJ5-14	BOLT		2
988	AN960PD516L	WASHER		2
991	BACN10JC5	NUT		2
994	113T1447-5	LINK-SIDE (USED ON ITEM 970)		1
-994A	113T1221-11	LINK-SIDE (USED ON ITEMS 970A, 970B)		1
997	113T1221-2	LINK-CTR FORK (USED ON ITEMS 970, 970A)		1
-997A	113T1221-6	LINK-CTR FORK (USED ON ITEM 970B)		1

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