

 **BOEING**
COMPONENT
MAINTENANCE MANUAL

TO: ALL HOLDERS OF OUTBOARD TRAILING EDGE FLAP INSTALLATION COMPONENTS
COMPONENT MAINTENANCE MANUAL 27-51-96

REVISION NO. 9 DATED JUL 01/04

HIGHLIGHTS

Pages which have been added or revised are outlined below together with the highlights of the revision. Remove and insert the affected pages as listed and enter Revision No. 4 dated Jul 01/89 on the Record of Revision Sheet.

CHAPTER/SECTION

AND PAGE NO.

DESCRIPTION OF CHANGE

TITLE PAGE

Added crank arm assembly 113T1339-31, -32 with new crank halves per PRR B13063-52.

1

TR & SB RECORD

1

501

REPAIR 3-1

601-603

1003-1008,1019-1022

TITLE PAGE

Added crank arm assembly 113T1359-27, -28 with new crank halves per PRR B13063-52.

1

TR & SB RECORD

1

501

REPAIR 4-1

601-603

1003-1008,1011-1015,

1019-1022,1027-1030,

1033,1035,1037,1039,

1041,1043,1045

TITLE PAGE

Added new link assembly 113T1015-5 with smaller bushings.

1

REPAIR-GEN

602

REPAIR 9-1

601,603

27-51-96

HIGHLIGHTS

01.1

Page 1

Jul 01/04

 **BOEING**
COMPONENT
MAINTENANCE MANUAL

<u>CHAPTER/SECTION AND PAGE NO.</u>	<u>DESCRIPTION OF CHANGE</u>
1003-1008,1011-1015, 1019-1022,1027-1030, 1033,1035,1037,1039, 1041,1043,1045	HIGHLIGHT CONTINUED FROM PREVIOUS PAGE
REPAIR-GEN 601	Added Standard Practices.
REPAIR 3-1 602 REPAIR 4-1 602	Changed True Position Dimensioning callouts.
REPAIR 9-1 602 1011-1018,1024-1026, 1033,1035,1037,1039, 1041,1045	Edited without technical change.
1002	Updated the Vendors List.

27-51-96

HIGHLIGHTS

01.1

Page 2

Jul 01/04

OUTBOARD TRAILING EDGE FLAP INSTALLATION COMPONENTS

PART NUMBERS 113T1015-1,-3,-5
113T1114-5
13T1337-7,-8,-15,-16,-19,-20
113T1339-1,-2,-7,-8,-13,
-14,-19,-20,-29 THRU -32
113T1352-7
113T1359-1,-2,-7,-8,-13,
-14,-19,-20,-25 THRU -28
113T1363-1,-4
113T1364-1,-4

COMPONENT MAINTENANCE MANUAL
WITH
ILLUSTRATED PARTS LIST

27-51-96

TITLE PAGE

Page 1

Jul 01/04

01.1

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

27-51-96

REVISION RECORD

01

Page 1

Jul 10/83

TEMPORARY REVISION AND SERVICE BULLETIN RECORD

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVE	DATE OF INCORPORATION INTO MANUAL
767-27-0080 767-57-0069		PRR B10450 PRR B11528 PRR B12671 PRR B13063-52	JUL 10/84 JAN 10/87 APR 01/91 JUL 01/99 NOV 01/00 JUL 01/04

27-51-96

TR & SB RECORD

01.1

Page 1

Jul 01/04

PAGE	DATE	CODE	PAGE	DATE	CODE
27-51-96			REPAIR 1-1		
			601	JUL 01/99	01.1
			602	JUL 01/99	01.1
TITLE PAGE			603	JUL 01/99	01.1
*1	JUL 01/04	01.1	604	BLANK	
2	BLANK				
REVISION RECORD			REPAIR 2-1		
1	JUL 10/83	01	601	JUL 01/99	01.1
2	BLANK		602	JUL 01/99	01.1
TR & SB RECORD			REPAIR 3-1		
*1	JUL 01/04	01.1	*601	JUL 01/04	01.1
2	BLANK		*602	JUL 01/04	01.1
LIST OF EFFECTIVE PAGES			*603	JUL 01/04	01.1
*1	JUL 01/04	01	604	BLANK	
THRU LAST PAGE					
CONTENTS			REPAIR 4-1		
1	JUL 10/83	01	*601	JUL 01/04	01.1
2	BLANK		*602	JUL 01/04	01.1
INTRODUCTION			*603	JUL 01/04	01.1
1	JUL 10/83	01	604	BLANK	
2	BLANK		REPAIR 5-1		
DESCRIPTION & OPERATION			601	JUL 01/99	01.1
1	JUL 10/83	01	602	JUL 01/99	01.1
2	BLANK		REPAIR 6-1		
CHECK			601	JUL 01/99	01.1
*501	JUL 01/04	01.1	602	JUL 01/99	01.1
502	BLANK		REPAIR 7-1		
REPAIR-GENERAL			601	JUL 01/99	01.1
*601	JUL 01/04	01.1	602	JUL 01/99	01.1
*602	JUL 01/04	01.1	REPAIR 8-1		
603	JUL 01/99	01.1	601	JUL 01/99	01.1
604	BLANK		602	JUL 01/99	01.1
			REPAIR 9-1		
			*601	JUL 01/04	01.1
			*602	JUL 01/04	01.1
			*603	JUL 01/04	01.1
			604	BLANK	

* = REVISED, ADDED OR DELETED

27-51-96

EFFECTIVE PAGES
CONTINUED Page 1
01 Jul 01/04

PAGE	DATE	CODE	PAGE	DATE	CODE
REPAIR 10-1			ILLUSTRATED PARTS LIST		CONT.
601	JUL 01/99	01.1	*1039	JUL 01/04	01.1
602	JUL 01/99	01.1	*1040	JUL 01/04	01.1
ILLUSTRATED PARTS LIST			*1041	JUL 01/04	01.1
1001	JUL 10/83	01	*1042	JUL 01/04	01.1
*1002	JUL 01/04	01.1	*1043	JUL 01/04	01.1
*1003	JUL 01/04	01.1	*1044	JUL 01/04	01.1
*1004	JUL 01/04	01.1	*1045	JUL 01/04	01.1
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*1007	JUL 01/04	01.1			
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*1014	JUL 01/04	01.1			
*1015	JUL 01/04	01.1			
*1016	JUL 01/04	01.1			
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*1036	JUL 01/04	01.1			
*1037	JUL 01/04	01.1			
*1038	JUL 01/04	01.1			

* = REVISED, ADDED OR DELETED

27-51-96

EFFECTIVE PAGES
LAST PAGE Page 2
01 Jul 01/04

TABLE OF CONTENTS

<u>Paragraph Title</u>	<u>Page</u>
Description and Operation	1
Testing and Trouble Shooting (not applicable)	
Disassembly (not applicable)	
Cleaning*[1]	
Check.	501
Repair	601
Assembly (not applicable)	
Fits and Clearances (not applicable)	
Special Tools (not applicable)	
Illustrated Parts List	1001

*[1] Special instructions not required. Use standard industry practices and information contained in 20-30-03.

INTRODUCTION

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

This manual is divided into separate sections:

- | | |
|---|------------------------------|
| 1. Title Page | 4. List of Effective Pages |
| 2. Record of Revisions | 5. Table of Contents |
| 3. Temporary Revisions &
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.

27-51-96

INTRODUCTION

01

Page 1

Jul 10/83



OUTBOARD TRAILING EDGE FLAP INSTALLATION COMPONENTS

DESCRIPTION AND OPERATION

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

27-51-96

DESCRIPTION & OPERATION

01

Page 1

Jul 10/83

CHECK

1. Check all parts for obvious defects in accordance with standard industry practices.
2. Refer to FITS AND CLEARANCES for design dimensions and wear limits.
3. Magnetic particle check the following parts per 20-20-01.
 - A. Crank half (40, 45, 47, 48, 50, 55, 57, 58, 60, 65, 70, 72, 75, 77, IPL Fig. 2)
 - B. Crank half (40, 45, 47, 48, 50, 55, 57, 58, 60, 65, 70, 72, 75, 77, IPL Fig. 3)
 - C. Bushing (15, 20, IPL Fig. 2)
 - D. Bushing (15, 20, IPL Fig. 3)
 - E. Link (15, IPL Fig. 8)
 - F. Link (25, IPL Fig. 9)
4. Penetrant check the following parts per 20-20-02.
 - A. Fitting (60, 65, 70, 75, IPL Fig. 1)
 - B. Bushing (10, IPL Fig. 2)
 - C. Bushing (10, IPL Fig. 3)
 - D. Link (25, IPL Fig. 4)
 - E. Link (25, IPL Fig. 5)
 - F. Link (15, IPL Fig. 6)
 - G. Link (15, IPL Fig. 7)
 - H. Link (25, IPL Fig. 10)

27-51-96

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>
113T1337	FITTING	1-1
113T1337	FITTING	2-1
113T1339	CRANK	3-1
113T1359	CRANK	4-1
113T1363	LINK	5-1
113T1364	LINK	6-1
113T1114	LINK	7-1
113T1352	LINK	8-1
113T1015	LINK	9-1
113T1382	LINK	10-1

2. Standard Practices

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

- B. 20-30-02 Stripping of Protective Finishes
20-30-02 Stripping of Protective Finishes
20-30-03 General Cleaning Procedures
20-41-01 Decoding Table for Boeing Finish Codes
20-41-02 Application of Chemical and Solvent Resistant Finishes
20-43-01 Chromic Acid Anodizing
20-50-03 Bearing and Bushing Replacement
20-60-02 Finishing Materials
20-60-03 Lubricants
20-60-04 Miscellaneous Materials

3. Materials

NOTE: Equivalent substitutes may be used.

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

27-51-96

REPAIR-GENERAL

01.1

Page 601

Jul 01/04

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

C. Enamel -- BMS 10-60, BAC707 Gray Gloss (Ref 20-60-02)

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

4. Dimensioning Symbols

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

27-51-96

REPAIR-GENERAL

01.1

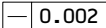
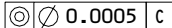
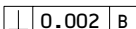
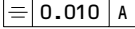
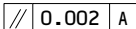
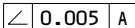
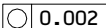
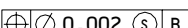
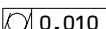
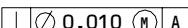
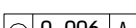
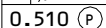
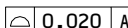
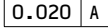
Page 602

Jul 01/04

—	STRAIGHTNESS
▭	FLATNESS
⊥	PERPENDICULARITY (OR SQUARENESS)
//	PARALLELISM
○	ROUNDNESS
⊙	CYLINDRICITY
⌒	PROFILE OF A LINE
△	PROFILE OF A SURFACE
◎	CONCENTRICITY
≡	SYMMETRY
∠	ANGULARITY
↗	RUNOUT
↗↗	TOTAL RUNOUT
⊔	COUNTERBORE OR SPOTFACE
∇	COUNTERSINK

⊕	THEORETICAL EXACT POSITION OF A FEATURE (TRUE POSITION)
∅	DIAMETER
S ∅	SPHERICAL DIAMETER
R	RADIUS
SR	SPHERICAL RADIUS
()	REFERENCE
BASIC (BSC) OR	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.
DIM	
-A-	DATUM
Ⓜ	MAXIMUM MATERIAL CONDITION (MMC)
Ⓛ	LEAST MATERIAL CONDITION (LMC)
Ⓢ	REGARDLESS OF FEATURE SIZE (RFS)
Ⓟ	PROJECTED TOLERANCE ZONE
FIM	FULL INDICATOR MOVEMENT

EXAMPLES

 0.002	STRAIGHT WITHIN 0.002	 0.0005 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	AXIS IS TOTALLY WITHIN A CYLINDER OF 0.010-INCH DIAMETER, PERPENDICULAR TO,
 0.006 A	EACH LINE ELEMENT OF THE SURFACE AT ANY CROSS SECTION MUST LIE BETWEEN TWO PROFILE BOUNDARIES 0.006 INCH APART RELATIVE TO DATUM PLANE A	 0.510 Ⓟ	AND EXTENDING 0.510-INCH ABOVE, DATUM A, MAXIMUM MATERIAL CONDITION
 0.020 A	SURFACES MUST LIE WITHIN PARALLEL BOUNDARIES 0.02 INCH APART AND EQUALLY DISPOSED ABOUT TRUE PROFILE	2.000	THEORETICALLY EXACT DIMENSION IS 2.000
		OR	
		2.000	
		BSC	
		 0.020 A	
		A 0.020	

NOTE: DATUM MAY APPEAR AT EITHER SIDE OF TOLERANCE FRAME

True Position Dimensioning Symbols
Figure 601

27-51-96

REPAIR-GENERAL

01.1

Page 603

Jul 01/99

FITTING ASSEMBLY – REPAIR 1-1

113T1337-7, -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. Bushing Replacement (Fig. 601) (Ref IPL Fig. 1)

- A. Remove bushings (40 or 45, 50 or 55).
- B. Install replacement bushings (40 or 45) with wet sealant.
- C. Machine bore of bushing (40 or 45) to dimensions shown.
- D. Install replacement bushing (50 or 55) with wet sealant.
- E. Machine bore of bushing (50 or 55) to dimensions shown.
- F. Fillet seal bushing flanges with sealant.

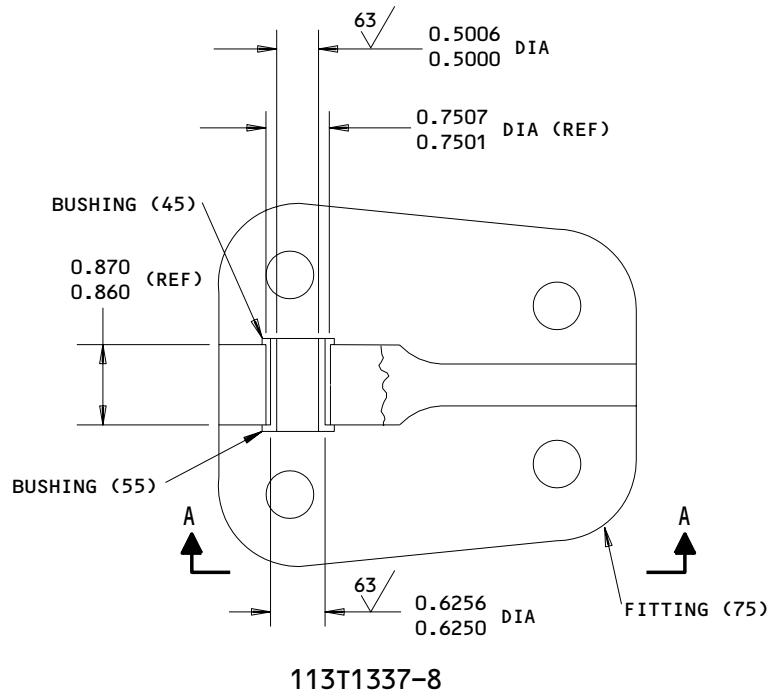
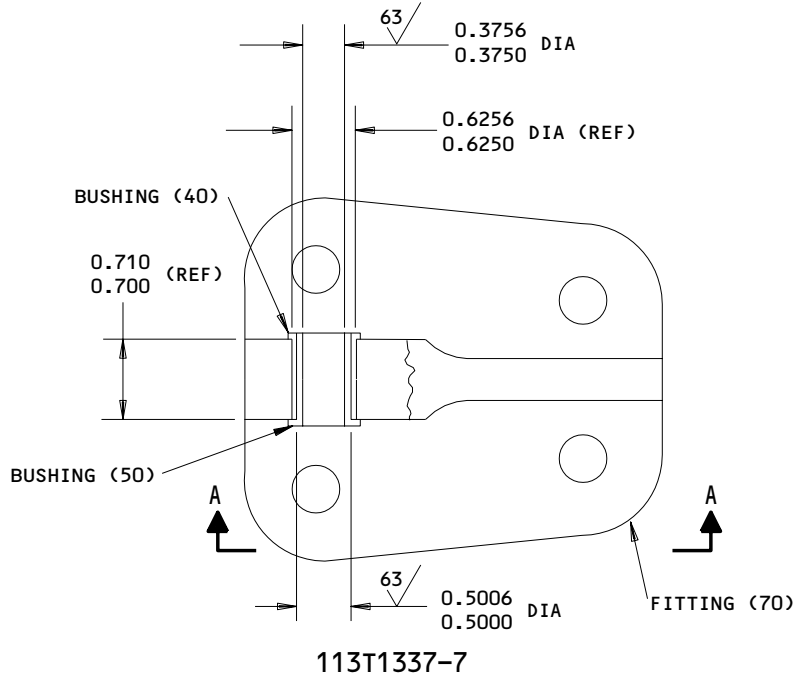
27-51-96

REPAIR 1-1

01.1

Page 601

Jul 01/99



113T1337-7,-8
 Fitting Assembly - Bushing Replacement and Refinish
 Figure 601 (Sheet 1)

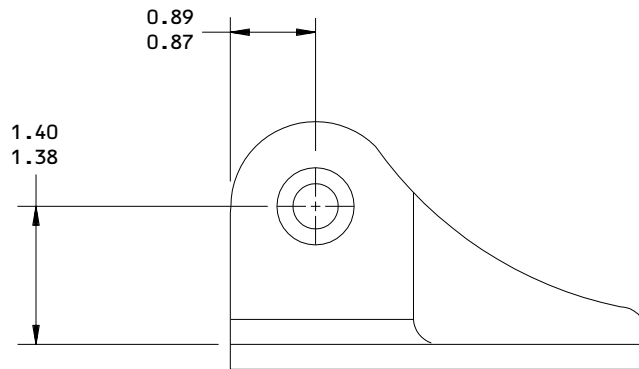
27-51-96

REPAIR 1-1

Page 602

Jul 01/99

01.1



A-A

REFINISH

FITTING (70) -- CHROMIC ACID ANODIZE AND APPLY
BMS 10-11, TYPE 1 PRIMER (F-18.13) ALL OVER,
BUT DO NOT APPLY PRIMER IN THE HOLES

FITTING ASSEMBLY (5B) -- APPLY BMS 10-11, TYPE 1
PRIMER (SRF-14.995) AND BMS 10-60 ENAMEL
(SRF-14.9813) ALL OVER, BUT NOT ON THE BUSHINGS

MATERIAL: ALUMINUM ALLOY
ITEM NUMBERS REFER TO IPL FIG. 1
ALL DIMENSIONS ARE IN INCHES

113T1337-7,-8
Fitting Assembly - Bushing Replacement and Refinish
Figure 601 (Sheet 2)

27-51-96

REPAIR 1-1

01.1

Page 603

Jul 01/99

FITTING ASSEMBLY – REPAIR 2-1

113T1337-15, -16, -19, -20

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

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

- A. Remove bushings (40 or 45, 50 or 55).
- B. Install replacement bushings (40 or 45) with wet sealant.
- C. Machine bore of bushing (40 or 45) to dimensions shown.
- D. Install replacement bushing (50 or 55) with wet sealant.
- E. Machine bore of bushing (50 or 55) to dimensions shown.
- F. Fillet seal bushing flanges with sealant.

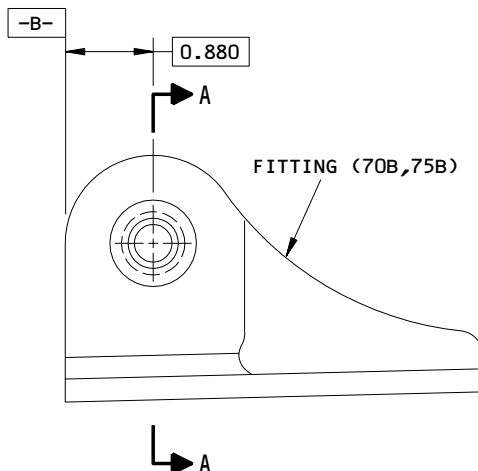
27-51-96

REPAIR 2-1

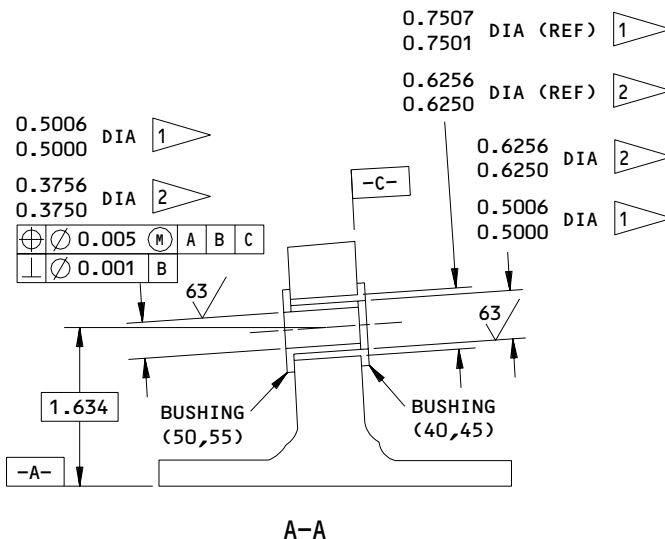
Page 601

Jul 01/99

01.1



113T1337-15,-20 SHOWN
 113T1337-16,-19 OPPOSITE



REFINISH

FITTING (70B,75B) -- CHROMIC ACID ANODIZE AND APPLY BMS 10-11, TYPE 1 PRIMER (F-18.13) ALL OVER, BUT DO NOT APPLY PRIMER IN THE HOLES

FITTING ASSEMBLY (5B,5C) -- APPLY BMS 10-11, TYPE 1 PRIMER (SRF-14.995) AND BMS 10-60 ENAMEL (SRF-14.9813) ALL OVER, BUT NOT ON THE BUSHINGS

MATERIAL: ALUMINUM ALLOY

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

- 1 113T1337-15,-16
- 2 113T1337-19,-20

113T1337-15,-16,-19,-20
 Fitting Assembly - Bushing Replacement and Refinish
 Figure 601

27-51-96

REPAIR 2-1

Page 602

Jul 01/99

01.1

NO. 1 CRANK, CRANK ARM ASSEMBLY – REPAIR 3-1

113T1339-1, -2, -7, -8, -13, -14, -19, -20, -29 THRU -32

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

1. Bushing Replacement (Fig. 601) (Ref IPL Fig. 2)
 - A. Remove bolt (25), washers (30) and nut (35) from crank arm assembly.
 - B. Remove bushings (10, 15, 20).
 - C. Install replacement bushings (15) with wet sealant. Align splines and install parts (25, 30, 35) on crank arm assembly.
 - D. Machine bore of bushings (15) to dimensions shown.
 - E. Remove parts (25, 30, 35) from crank arm assembly.
 - F. Install replacement bushings (10, 20) with wet sealant.
 - G. Apply sealant to faying surface of crank halves, align splines and install parts (25, 30, 35) on crank arm assembly. Install bolt (25) with sealant. Remove sealant from splines.
 - H. Machine bore of bushings (10, 20) to dimensions shown.
 - I. Fillet seal bushing flanges with sealant.

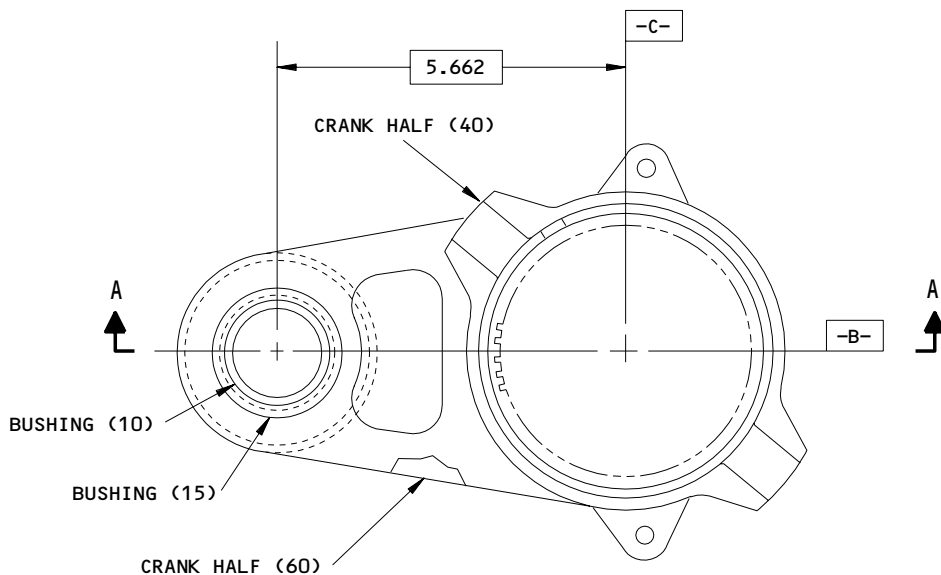
27-51-96

REPAIR 3-1

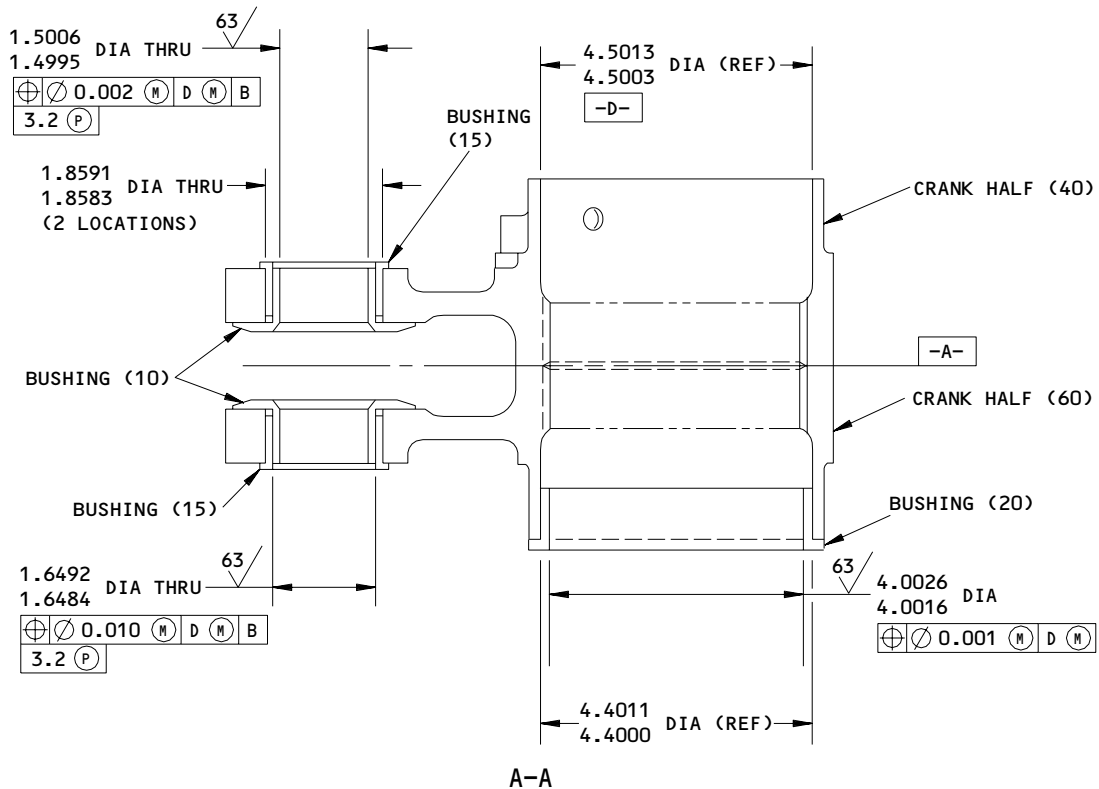
01.1

Page 601

Jul 01/04



113T1339-1 SHOWN
 113T1339-2 OPPOSITE
 OTHER ASSEMBLIES SIMILAR



113T1339-1,-2,-7,-8,-13,-14,-19,-20,-29 thru -32
 Crank Arm Assembly Repair
 Figure 601 (Sheet 1)

27-51-96

REPAIR 3-1
 Page 602
 Jul 01/04

01.1

REFINISH

CRANK HALF (40 THRU 77) -- CADMIUM-TITANIUM
PLATE (F-15.32) AND APPLY BMS 10-11, TYPE 1
PRIMER (F-20.02), BUT DO NOT APPLY PRIMER IN
THE BOLT HOLES, OR ON THE SPLINES AND 4.40 OR
4.50 INCH DIAMETER BORE

ARM ASSEMBLY (1,5) -- APPLY BMS 10-60 ENAMEL
(SRF-14.9813) ALL OVER, BUT NOT ON THE BUSHINGS,
SPLINES, AND 4.50 INCH DIAMETER HOLE. WIPE THE
SPLINES WITH PRIMER (F-19.45)

MATERIAL: 4330M STEEL, 220-240 KSI

ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

113T1339-1,-2,-7,-8,-13,-14,-19,-20,-29 thru -32
Crank Arm Assembly Repair
Figure 601 (Sheet 2)

27-51-96

REPAIR 3-1

Page 603

Jul 01/04

01.1

NO. 2 CRANK, CRANK ARM ASSEMBLY – REPAIR 4-1

113T1359-1, -2, -7, -8, -13, -14, -19, -20, -25 THRU -28

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

1. Bushing Replacement (Fig. 601) (Ref IPL Fig. 3)

- A. Remove bolt (25), washers (30) and nut (35) from crank arm assembly.
- B. Remove bushings (10, 15, 20).
- C. Install replacement bushings (15) with wet sealant. Align splines and install parts (20, 30, 35) on crank arm assembly.
- D. Machine bore of bushings (15) to dimensions shown.
- E. Remove parts (25, 30, 35) from crank arm assembly.
- F. Install replacement bushings (10, 20) with wet sealant.
- G. Apply sealant to faying surface of crank halves, align splines and install parts (25, 30, 35) on crank arm assembly. Install bolt (25) with sealant. Remove sealant from splines.
- H. Machine bore of bushings (10, 20) to dimensions shown.
- I. Fillet seal bushing flanges with sealant.

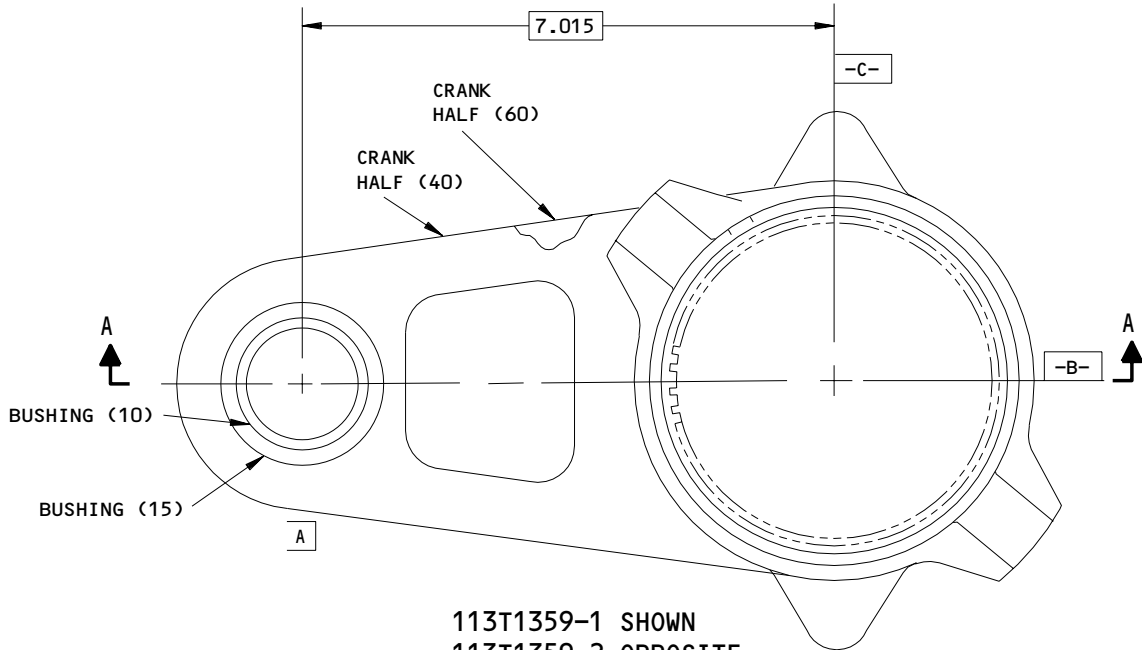
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REPAIR 4-1

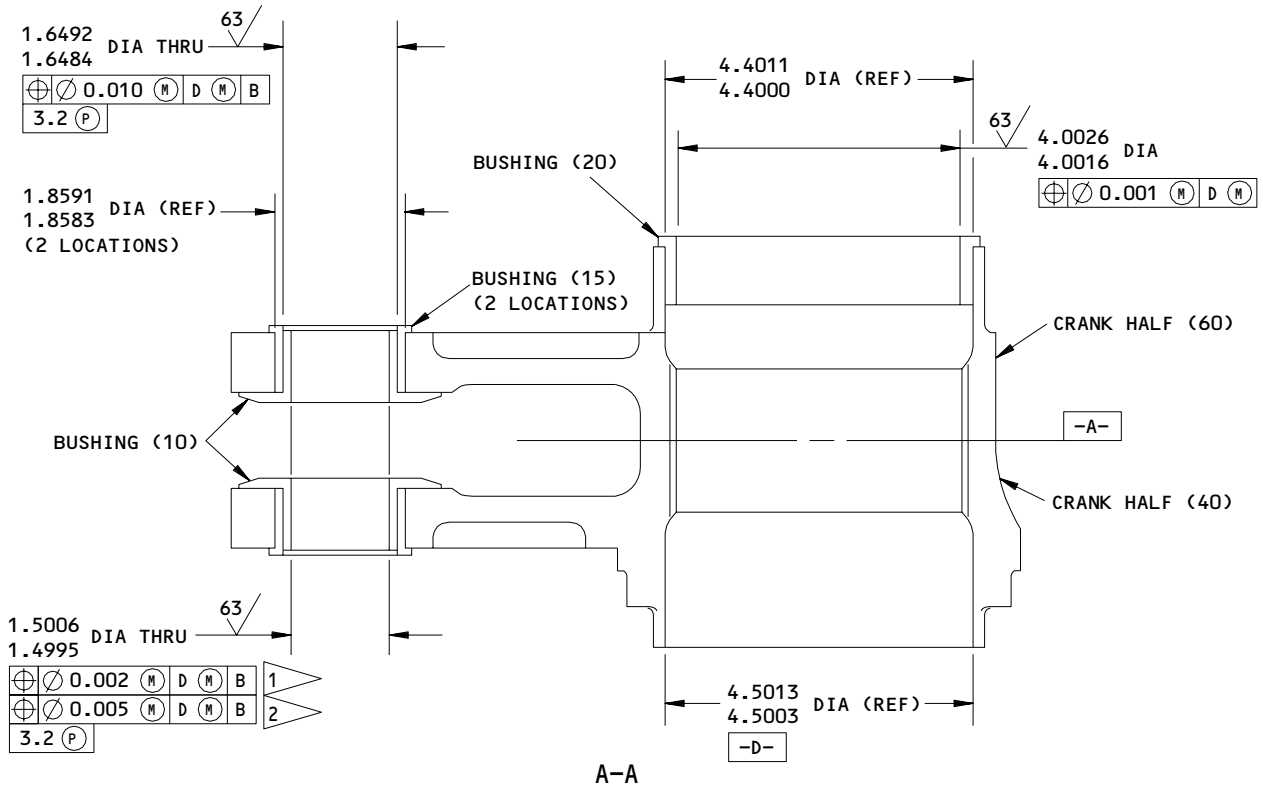
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Page 601

Jul 01/04



113T1359-1 SHOWN
 113T1359-2 OPPOSITE
 OTHER ASSEMBLIES SIMILAR



113T1359-1,-2,-7,-8,-13,-14,-19,-20,-25 thru -28
 Crank Arm Assembly Repair
 Figure 601 (Sheet 1)

27-51-96

REPAIR 4-1

Page 602

Jul 01/04

01.1

REFINISH

CRANK HALF (40 THRU 77) -- CADMIUM-TITANIUM
PLATE (F-15.32) AND APPLY BMS 10-11,TYPE 1
PRIMER (F-20.02), BUT DO NOT APPLY PRIMER IN
THE BOLT HOLES, OR ON THE SPLINES AND 4.40 OR
4.50 INCH DIAMETER BORE.

MATERIAL: 4330M STEEL, 220-240 KSI
ITEM NUMBERS REFER TO IPL FIG. 3
ALL DIMENSIONS ARE IN INCHES

ARM ASSEMBLY (1,5) -- APPLY BMS 10-60 ENAMEL
(SRF-14.9813) ALL OVER, BUT NOT ON THE BUSHINGS,
SPLINES AND 4.50 INCH DIAMETER HOLE. WIPE
THE SPLINES WITH PRIMER (F-19.45).

- 1 113T1359-1,-2,-7,-8,-13,-14,-19,-20,-25,-26
- 2 113T1359-27,-28

113T1359-1,-2,-7,-8,-13,-14,-19,-20,-25 thru -28
Crank Arm Assembly Repair
Figure 601 (Sheet 2)

27-51-96

REPAIR 4-1

Page 603

Jul 01/04

01.1

LINK ASSEMBLY – REPAIR 5-1

113T1363-1, -4

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

- | 1. Bushing Replacement (Fig. 601) (Ref IPL Fig. 4)
 - | A. Remove bushing (5, 10, 15, 20).
 - | B. Install replacement bushing with wet sealant.
 - | C. Machine bore to dimensions shown.
 - | D. Fillet seal bushing flange with sealant.

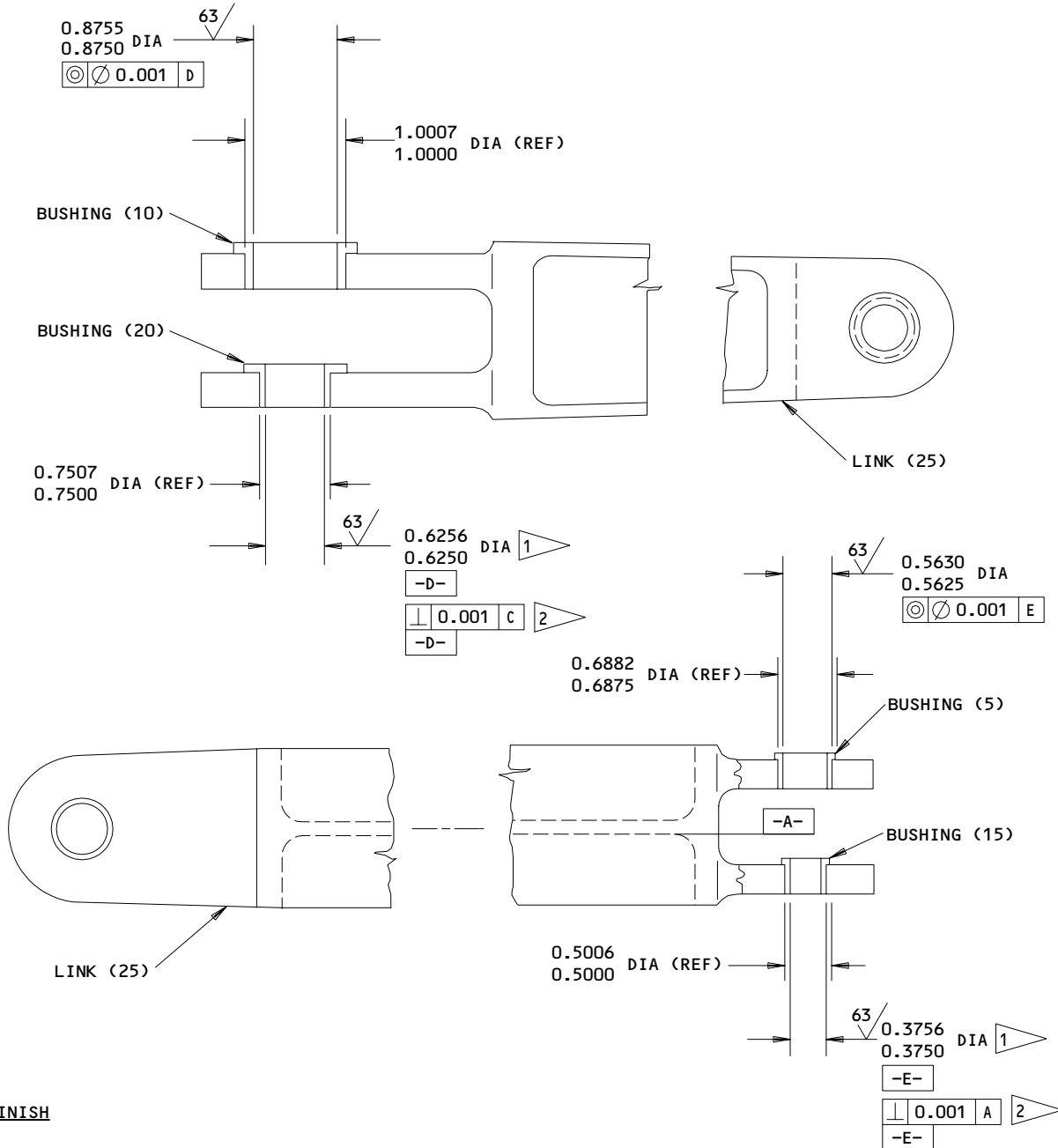
27-51-96

REPAIR 5-1

01.1

Page 601

Jul 01/99



REFINISH

LINK (25) -- CHROMIC ACID ANODIZE AND APPLY BMS 10-11, TYPE 1 PRIMER (F-18.13), BUT DO NOT APPLY PRIMER IN THE HOLES

LINK ASSEMBLY (1) -- APPLY BMS 10-11, TYPE 1 PRIMER (SRF-14.995) AND BMS 10-60 ENAMEL (SRF-14.9813) ALL OVER, BUT NOT ON THE BUSHINGS

MATERIAL: ALUMINUM ALLOY

ITEM NUMBERS REFER TO IPL FIG. 4

ALL DIMENSIONS ARE IN INCHES

- 1 FOR 113T1363-1
- 2 FOR 113T1363-4

113T1363-1,-4
 Link Assembly Repair
 Figure 601

27-51-96

REPAIR 5-1

Page 602

Jul 01/99

01.1

LINK ASSEMBLY – REPAIR 6-1

113T1364-1, -4

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

- | 1. Bushing Replacement (Fig. 601) (Ref IPL Fig. 5)
 - | A. Remove bushing (5, 15, 20).
 - | B. Install replacement bushing with wet sealant.
 - | C. Machine bore to dimensions shown.
 - | D. Fillet seal bushing flange with sealant.

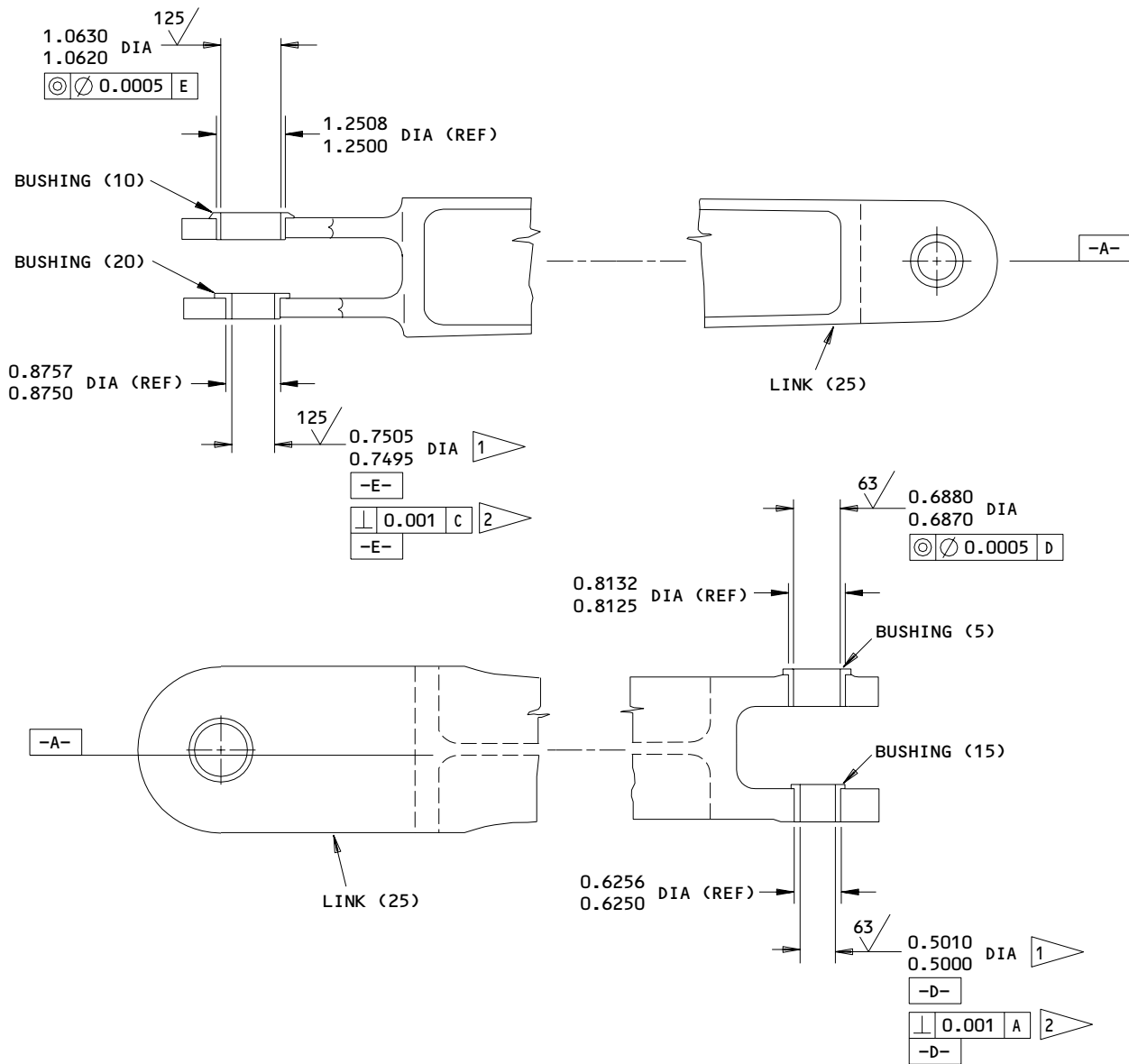
27-51-96

REPAIR 6-1

01.1

Page 601

Jul 01/99



REFINISH

LINK (25) -- CHROMIC ACID ANODIZE AND APPLY BMS 10-11, TYPE 1 PRIMER (F-18.13), BUT DO NOT APPLY PRIMER IN THE HOLES

LINK ASSEMBLY (1) -- APPLY BMS 10-11, TYPE 1 PRIMER (SRF-14.995) AND BMS 10-60 ENAMEL (SRF-14.9813) ALL OVER, BUT NOT ON THE BUSHINGS

MATERIAL: ALUMINUM ALLOY

ITEM NUMBERS REFER TO IPL FIG. 5

ALL DIMENSIONS ARE IN INCHES

- 1 FOR 113T1364-1
- 2 FOR 113T1364-4

113T1364-1,-4
 Link Assembly Repair
 Figure 601

27-51-96

REPAIR 6-1

Page 602

Jul 01/99

01.1

LINK ASSEMBLY – REPAIR 7-1

113T1114-5

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

- | 1. Bushing Replacement (Fig. 601) (Ref IPL Fig. 6)
 - | A. Remove bushing (5, 10).
 - | B. Install replacement bushing with wet sealant per 20-50-03.
 - | C. Machine bushing ID to dimensions shown.
 - | D. Fillet seal bushing flange with sealant.

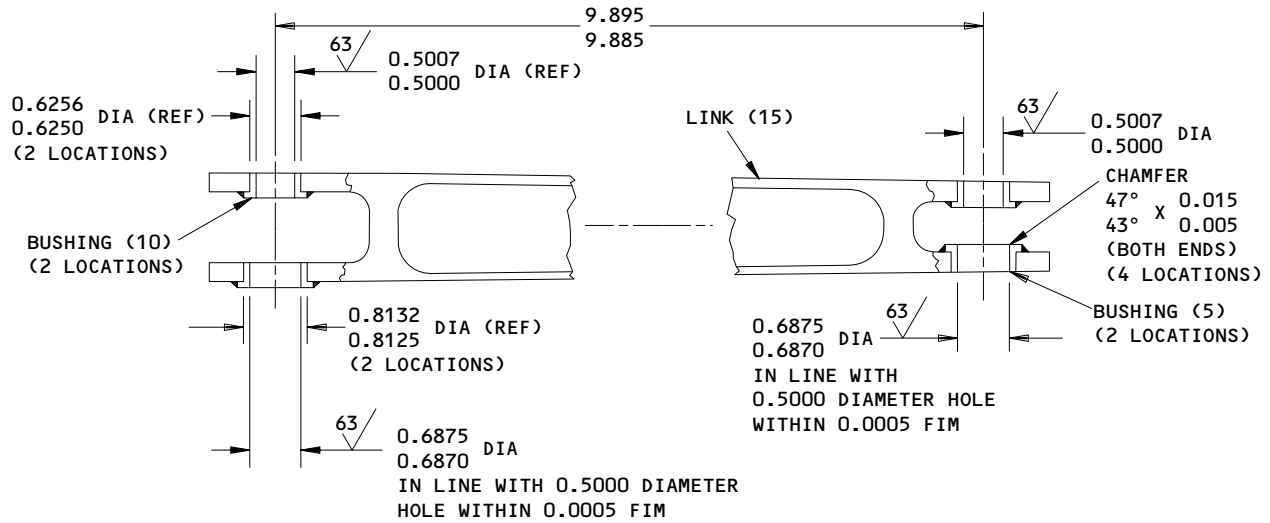
27-51-96

REPAIR 7-1

01.1

Page 601

Jul 01/99



REFINISH

LINK (15) -- CHROMIC ACID ANODIZE AND APPLY BMS 10-11, TYPE 1 PRIMER (F-18.13) ALL OVER BUT DO NOT APPLY PRIMER IN THE BUSHING HOLES

LINK ASSEMBLY (1) -- APPLY BMS 10-60 ENAMEL (SRF-14.9813) ALL OVER, BUT NOT ON THE BUSHING BORES OR FLANGE FACES

MATERIAL: ALUMINUM ALLOY

ITEM NUMBERS REFER TO IPL FIG. 6

ALL DIMENSIONS ARE IN INCHES

113T1114-5
 Link Assembly Repair
 Figure 601

27-51-96

REPAIR 7-1

Page 602

Jul 01/99

01.1

LINK ASSEMBLY – REPAIR 8-1

113T1352-7

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

- | 1. Bushing Replacement (Fig. 601) (Ref IPL Fig. 7)
 - | A. Remove bushing (5, 10).
 - | B. Install replacement bushing with wet sealant per 20-50-03.
 - | C. Machine bushing ID to dimensions shown.
 - | D. Fillet seal bushing flange with sealant.

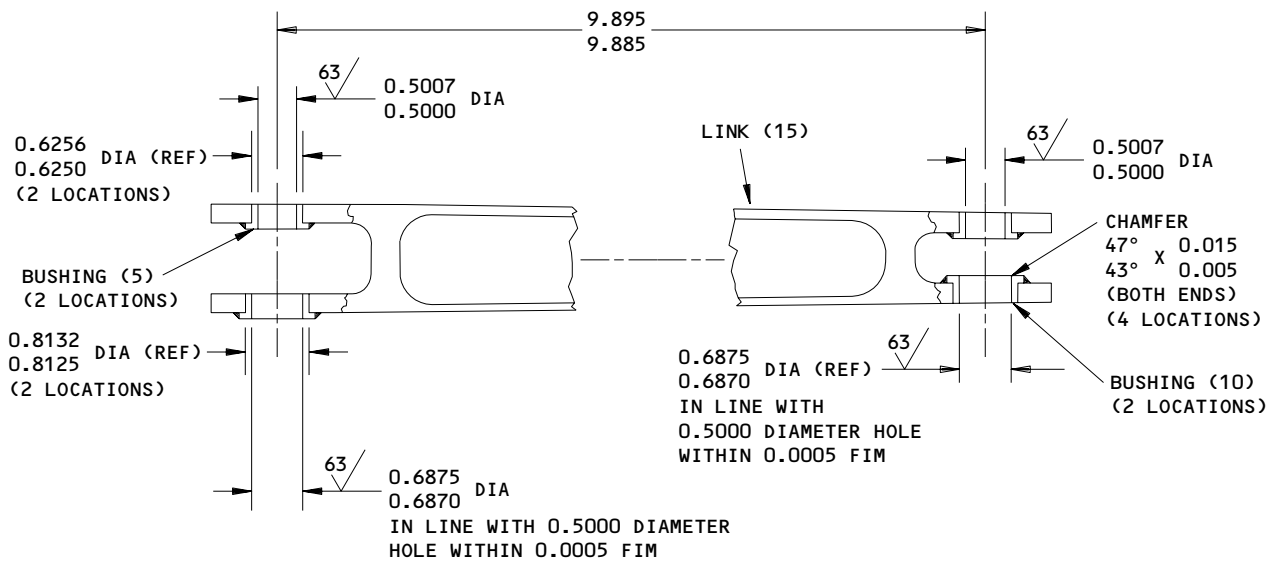
27-51-96

REPAIR 8-1

01.1

Page 601

Jul 01/99



REFINISH

LINK (15) -- CHROMIC ACID ANODIZE AND APPLY BMS 10-11, TYPE 1 PRIMER (F-18.13), ALL OVER BUT DO NOT APPLY PRIMER IN THE BUSHING HOLES

LINK ASSEMBLY (1) -- APPLY BMS 10-60 ENAMEL (SRF-14.9813) ALL OVER, BUT NOT ON THE BUSHING BORES OR FLANGE FACES

MATERIAL: ALUMINUM ALLOY

ITEM NUMBERS REFER TO IPL FIG. 7

ALL DIMENSIONS ARE IN INCHES

113T1352-7
 Link Assembly Repair
 Figure 601

27-51-96

REPAIR 8-1

Page 602

Jul 01/99

01.1

LINK ASSEMBLY – REPAIR 9-1

113T1015-1, -3, -5

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

1. Bushing Replacement (Fig. 601) (Ref IPL Fig. 8)

- A. Remove bushing (5, 10).
- B. Install replacement bushing (5, 10) per 20-50-03.
- C. Machine bushing ID to dimensions shown.
- D. Deleted.

2. Bushing Replacement (Fig. 602) (IPL Fig. 9)

- A. Remove bushing (5, 10, 15, 20).
- B. Install replacement bushing (5, 10, 15, 20) per 20-50-03. On assembly 113T1015-5, install bushings with BMS 3-33 grease.
- C. Machine bushing ID to dimensions shown.

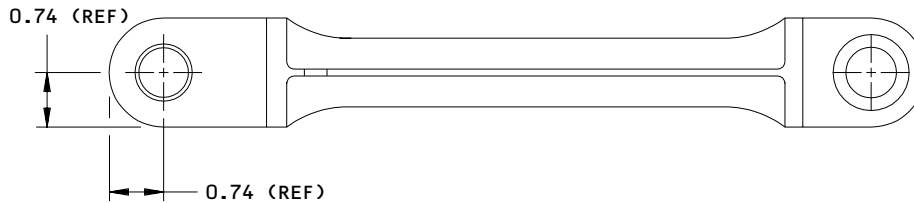
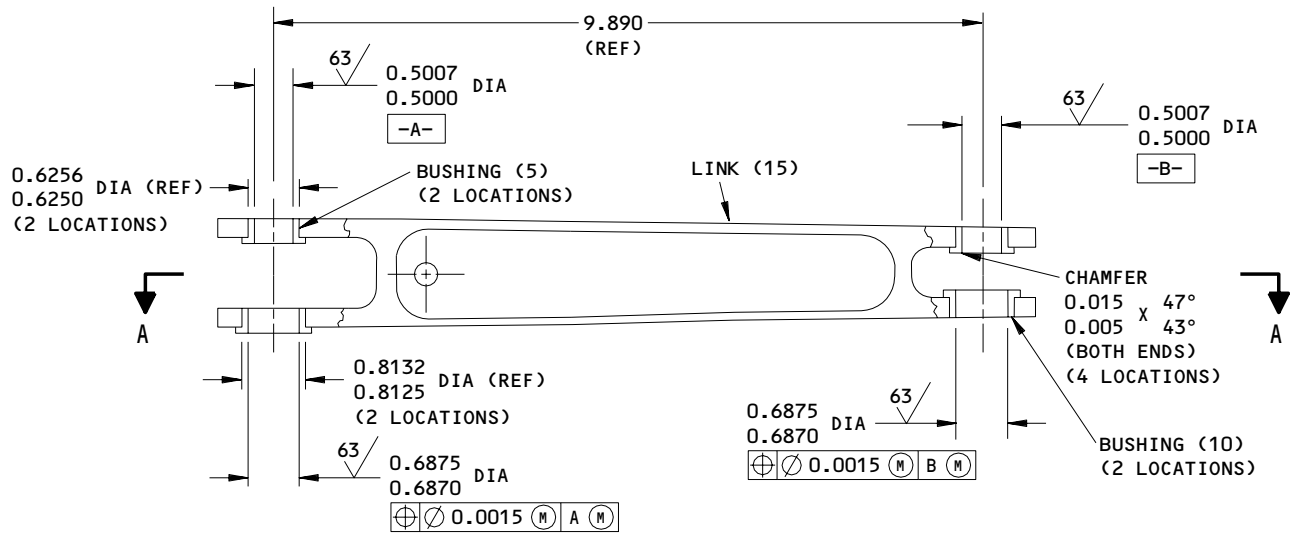
27-51-96

REPAIR 9-1

01.1

Page 601

Jul 01/04



A-A

REFINISH

LINK (15) APPLY BMS 10-11, TYPE 1 PRIMER (F-18.12) ALL OVER BUT DO NOT APPLY PRIMER IN THE BUSHING HOLES

LINK ASSEMBLY (1) -- APPLY BMS 10-11, TYPE 1 PRIMER (SRF-14.995) AND BMS 10-60 ENAMEL (SRF-14.9813) ALL OVER, BUT NOT ON THE BUSHINGS

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

ITEM NUMBERS REFER TO IPL FIG. 8

ALL DIMENSIONS ARE IN INCHES

113T1015-1
 Link Assembly Repair
 Figure 601

27-51-96

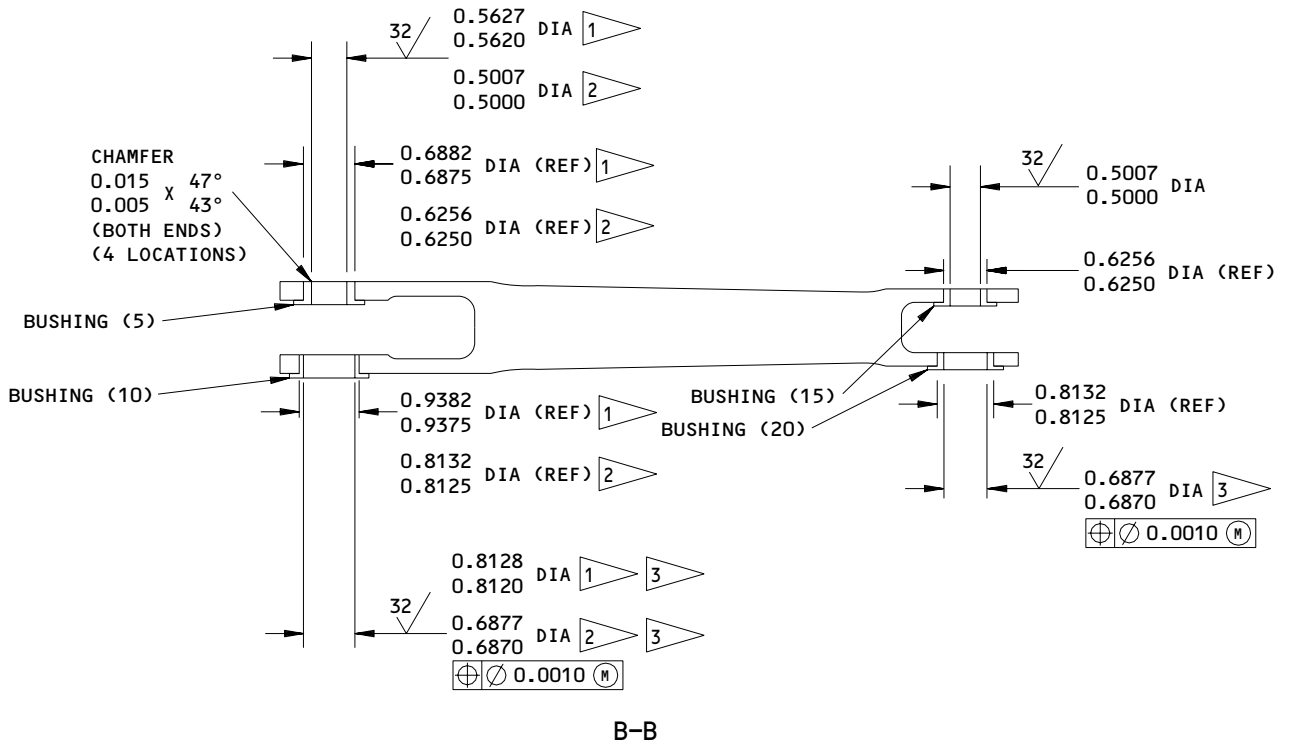
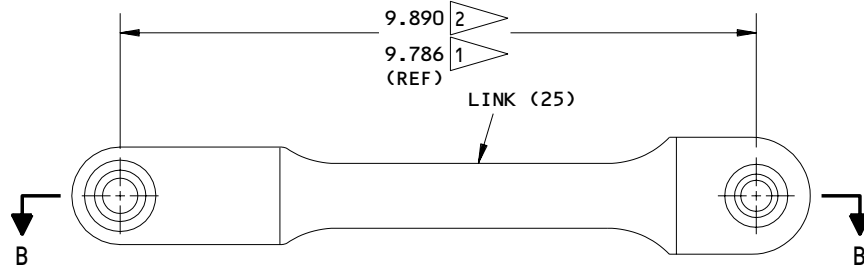
REPAIR 9-1

Page 602

Jul 01/04

01.1

BOEING
COMPONENT
MAINTENANCE MANUAL



REFINISH

LINK (25) -- PASSIVATE (F-17.25)

- 1 113T1015-3
- 2 113T1015-5
- 3 TWO COAXIAL HOLES AFTER BUSHING INSTALLATION

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

ITEM NUMBERS REFER TO IPL FIG. 9

ALL DIMENSIONS ARE IN INCHES

113T1015-3,-5
Link Assembly Repair
Figure 602

27-51-96

REPAIR 9-1

Page 603

Jul 01/04

01.1

LINK ASSEMBLY – REPAIR 10-1

113T1382-1

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

1. Bushing Replacement (Fig. 601) (IPL Fig. 10)

A. Remove bushing (5, 10, 15, 20).

B. Install replacement bushing (5, 10, 15, 20) with wet sealant. Use the shrink-fit method per 20-50-03.

C. Machine bushing ID to dimensions shown.

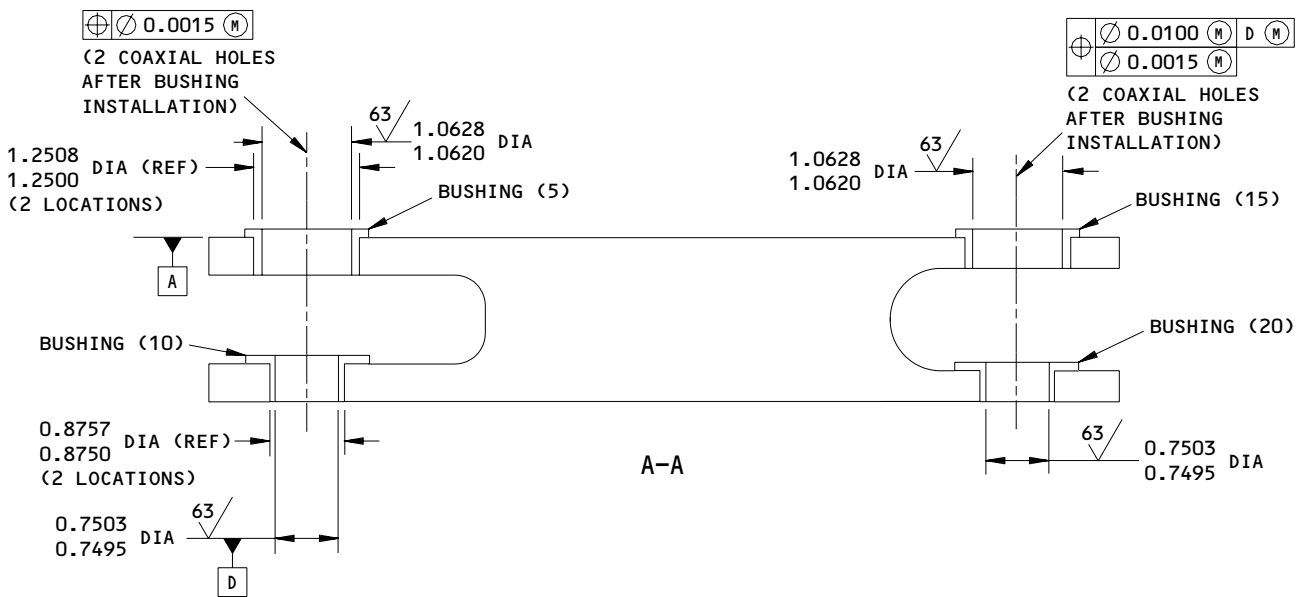
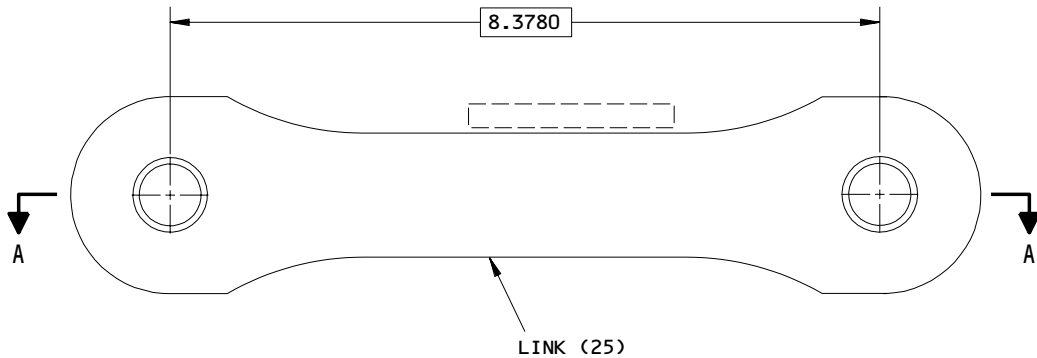
27-51-96

REPAIR 10-1

01.1

Page 601

Jul 01/99



REFINISH

LINK (25)--BORIC ACID-SULFURIC ACID ANODIZE (F-17.31) AND APPLY BMS 10-11, TYPE 1 PRIMER (F-20.02) ALL OVER, BUT DO NOT APPLY PRIMER IN THE BUSHING HOLES

MATERIAL: ALUMINUM ALLOY
 ITEM NUMBERS REFER TO IPL FIG. 10
 ALL DIMENSIONS ARE IN INCHES

113T1382-1
 Link Assembly Repair
 Figure 601

27-51-96
 REPAIR 10-1
 Page 602
 Jul 01/99

01.1

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 are 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.

27-51-96

ILLUSTRATED PARTS LIST

01

Page 1001

Jul 10/83

VENDORS

11815 CHERRY AEROSPACE FASTENERS DIV OF TEXTRON
1224 EAST WARNER AVENUE PO BOX 2157
SANTA ANA, CALIFORNIA 92707-0157
FORMERLY IN LOS ANGELES, CALIF , FORMERLY CHERRY FASTENERS
TOWNSEND DIV OF TEXTRON INC V71087

15653 ALOCA GLOBAL FASTEMERS INC DIV KAYNARE PRODUCTS
800 S STATE COLLEGE BLVD
FULLERTON, CALIFORNIA 92831-3001
FORMERLY VK6405 MICRODOT AEROSP LTD; FORMERLY KAYNAR TECH
FORMERLY FAIRCHILD FASTENERS KAYNAR DIV

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

72962 HARVARD INDUSTRIES INC
3 WERNER WAY SUITE 210
LEBANON, NEW JERSEY 08833
FORMERLY AMERACE CORP ESNA DIV
FORMERLY ELASTIC STOP NUT IN UNION, NJ

80539 SPS TECHNOLOGIES INC DIV AERPSOACE - SANTA ANA
2701 SOUTH HARBOR BOULEVARD
SANTA ANA, CALIFORNIA 92704-5803
FORMERLY NUTT-SHEL DIV OF SPC WESTERN CO V80539
AND STANDARD PRESSED STEEL WESTERN DIV V17279

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

27-51-96

ILLUSTRATED PARTS LIST
01.1 Page 1002
Jul 01/04

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACB28AM09B034A		4	5	1
BACB28AM11B023A		6	5	2
		7	10	2
BACB28AM11B042A		5	5	1
BACB28AM14B026A		4	10	1
BACB28AM17B040A		5	10	1
BACB28AP06P034		4	15	1
BACB28AP08-019		8	10	2
		9	15	1
BACB28AP08-029		9	5A	1
BACB28AP08P023		6	10	2
		7	5	2
BACB28AP08P042		5	15	1
BACB28AP08P069		1	40	1
BACB28AP09-029		9	5	1
BACB28AP10P026		4	20	1
BACB28AP10P085		1	45	1
BACB28AP12P040		5	20	1
BACB28AT11B019		8	5	2
BACB28AT11B019A		9	20	1
BACB28AT11B029A		9	10A	1
BACB28AT13B029A		9	10	1
BACB28AT17B034C		10	15	1
BACB28AT17B043C		10	5	1
BACB28AX12C034		10	20	1
BACB28AX12C043		10	10	1
BACB30NR4K5		2	25	2
		3	25	2
BACN10JC4		2	35	2
		3	35	2
BACN10JC4CD		2	35A	2
		3	35A	2
BACW10BP4AP		2	30	4
		3	30	4
BRH10A4		2	35	2
		3	35	2

27-51-96

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BRH10C4D		2	35A	2
		3	35A	2
H10-4BAC		2	35	2
		3	35	2
H51650-4BAC		2	35A	2
		3	35A	2
NS202101-048		2	35	2
		3	35	2
NS202486-048		2	35A	2
NS202486-048		3	35A	2
RMLH9075-4W		2	35	2
		3	35	2
T6C428JCD		2	35A	2
		3	35A	2
T6S428J		2	35	2
		3	35	2
VN303A048		2	35	2
		3	35	2
102LH9075-4W		2	35A	2
		3	35A	2
113T1015-1		1	38	RF
		8	1A	RF
113T1015-2		8	15	1
113T1015-3		1	38A	RF
		9	1A	RF
113T1015-4		9	25	1
113T1015-5		1	38B	RF
		9	1B	RF
113T1015-6		9	25A	1
113T1114-5		1	36	RF
		6	1	RF
113T1114-6		6	15	1
113T1312-1		2	20	1
		3	20	1
113T1312-13		2	20A	1
		3	20A	1
113T1312-2		2	10	2
		3	10	2
113T1312-3		2	15	2
		3	15	2
113T1337-10		1	75	1
113T1337-15		1	5F	RF
113T1337-16		1	5G	RF
113T1337-17		1	70B	1
113T1337-18		1	75B	1

27-51-96

 ILLUSTRATED PARTS LIST
 01.1 Page 1004
 Jul 01/04

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
113T1337-19		1	5H	RF
113T1337-20		1	5J	RF
113T1337-21		1	70C	1
113T1337-22		1	75C	1
113T1337-7		1	5B	RF
113T1337-8		1	5C	RF
113T1337-9		1	70	1
113T1339-1		1	10	RF
		2	1	RF
113T1339-10		2	55	1
113T1339-11		2	65	1
113T1339-13		1	10B	RF
		2	1B	RF
113T1339-14		1	15B	RF
		2	5B	RF
113T1339-15		2	47	1
113T1339-16		2	57	1
113T1339-17		2	70	1
113T1339-18		2	75	1
113T1339-19		1	10C	RF
		2	1C	RF
113T1339-2		1	15	RF
		2	5	RF
113T1339-20		1	15C	RF
		2	5C	RF
113T1339-21		2	47A	1
113T1339-22		2	57A	1
113T1339-23		2	70A	1
113T1339-24		2	75A	1
113T1339-25		2	40A	1
113T1339-26		2	50A	1

27-51-96

ILLUSTRATED PARTS LIST
01.1 Page 1005
Jul 01/04

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
113T1339-27		2	60A	1
113T1339-29		1	10D	RF
		2	1D	RF
113T1339-3		2	40	1
113T1339-30		1	15D	RF
		2	5D	RF
113T1339-31		1	10E	RF
		2	1E	RF
113T1339-32		1	15E	RF
		2	5E	RF
113T1339-37		2	48	1
113T1339-38		2	58	1
113T1339-39		2	72	1
113T1339-4		2	50	1
113T1339-40		2	77	1
113T1339-5		2	60	1
113T1339-7		1	10A	RF
		2	1A	RF
113T1339-8		1	15A	RF
		2	5A	RF
113T1339-9		2	45	1
113T1347-36		1	50	1
113T1347-37		1	55	1
113T1352-7		1	37	RF
		7	1	RF
113T1352-8		7	15	1
113T1359-1		1	20	RF
		3	1	RF
113T1359-10		3	50B	1
		3	55	1
113T1359-11		3	60B	1
		3	65	1

27-51-96

 ILLUSTRATED PARTS LIST
 01.1 Page 1006
 Jul 01/04

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
113T1359-13		1	20B	RF
		3	1B	RF
113T1359-14		1	25B	RF
		3	5B	RF
113T1359-15		3	47	1
113T1359-16		3	57	1
113T1359-17		3	70	1
113T1359-18		3	75	1
113T1359-19		1	20C	RF
		3	1C	RF
113T1359-2		1	25	RF
		3	5	RF
113T1359-20		1	25C	RF
		3	5C	RF
113T1359-21		3	47A	1
113T1359-22		3	57A	1
113T1359-23		3	70A	1
113T1359-24		3	75A	1
113T1359-25		1	20D	RF
		3	1D	RF
113T1359-26		1	25D	RF
		3	5D	RF
113T1359-27		1	20E	RF
		3	1E	RF
113T1359-28		1	25E	RF
		3	5E	RF
113T1359-29		3	48	1
113T1359-3		3	40	1
113T1359-30		3	58	1
113T1359-31		3	72	1
113T1359-32		3	77	1
113T1359-4		3	50	1
113T1359-5		3	60	1
113T1359-7		1	20A	RF
		3	1A	RF
113T1359-8		1	25A	RF
		3	5A	RF

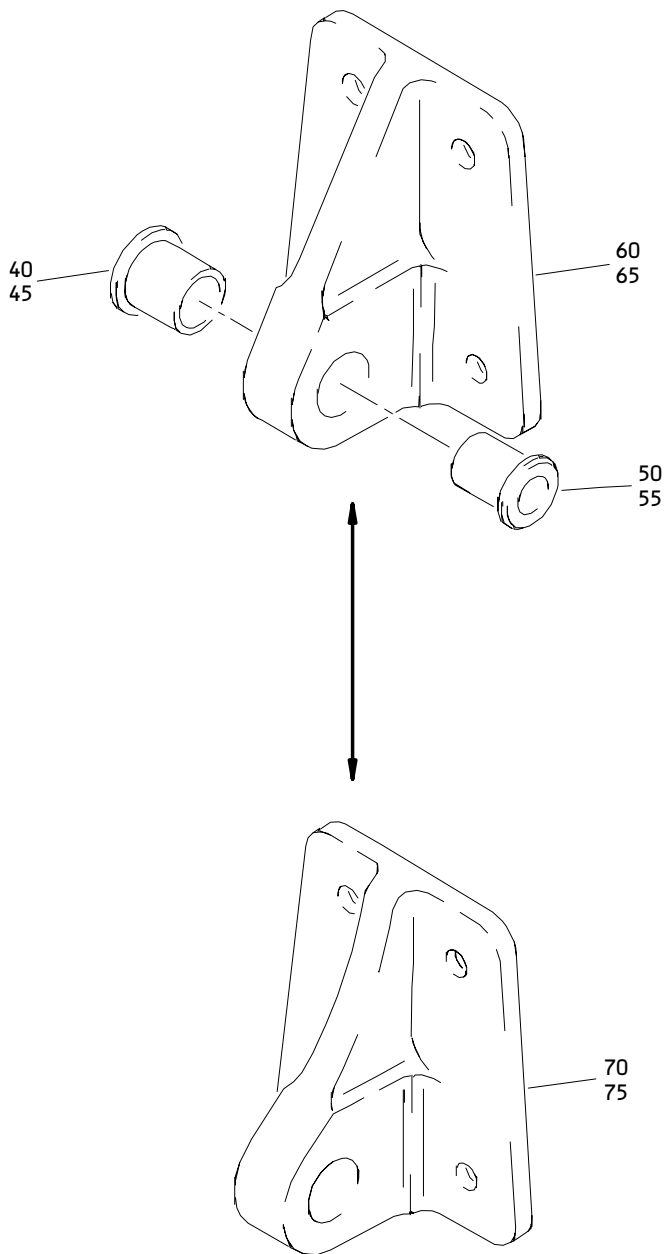
27-51-96

ILLUSTRATED PARTS LIST
01.1 Page 1007
Jul 01/04

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
113T1359-9		3	40B	1
		3	45	1
113T1363-1		1	30	RF
		4	1	RF
113T1363-2		4	25	1
113T1363-4		1	30A	RF
		4	1A	RF
113T1363-5		4	25A	1
113T1364-1		1	35	RF
		5	1	RF
113T1364-2		5	25	1
113T1364-4		1	35A	RF
		5	1A	RF
113T1364-5		5	25A	1
113T1382-1		1	7	RF
		10	1A	RF
113T1382-3		10	25	1
96-048		2	35	2
		3	35	2

27-51-96

ILLUSTRATED PARTS LIST
 01.1 Page 1008
 Jul 01/04



Side Brace Support No. 1 and 2 Fitting Assembly
Figure 1

27-51-96

ILLUSTRATED PARTS LIST
01.1 Page 1010
Jul 01/04

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-			OUTBD TE FLAP INSTL COMPONENTS		
-5	113T1337-1		DELETED		
-5A	113T1337-2		DELETED		
-5B	113T1337-7		FITTING ASSY-SPRT NO. 1 AND NO. 2 SIDE BRACE SPRT	C	RF
-5C	113T1337-8		FITTING ASSY-SPRT NO. 1 AND NO. 2 SIDE BRACE SPRT	D	RF
-5D	113T1337-11		DELETED		
-5E	113T1337-12		DELETED		
-5F	113T1337-15		FITTING ASSY-SPRT NO. 1 AND NO. 2 SIDE BRACE SPRT (LH)	AB	RF
-5G	113T1337-16		FITTING ASSY-SPRT NO. 1 AND NO. 2 SIDE BRACE SPRT (RH)	AC	RF
-5H	113T1337-19		FITTING ASSY-SPRT NO. 1 AND NO. 2 SIDE BRACE SPRT (LH)	AF	RF
-5J	113T1337-20		FITTING ASSY-SPRT NO. 1 AND NO. 2 SIDE BRACE SPRT (RH)	AG	RF
R -7	113T1382-1		LINK ASSY-INBD AUX (FOR DETAILS SEE FIG. 10)	AL	RF
-10	113T1339-1		ARM ASSY-NO. 1 CRANK, CRANK (LH) (PRE SB 767-27-0080) (FOR DETAILS SEE FIG. 2)	E	RF

27-51-96

ILLUSTRATED PARTS LIST
01.1 Page 1011
Jul 01/04

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01- -10A	113T1339-7		ARM ASSY-NO. 1 CRANK, CRANK (LH) (FOR DETAILS SEE FIG. 2)	F	RF
-10B	113T1339-13		ARM ASSY-NO. 1 CRANK, CRANK (LH) (POST SB 767-27-0080) (FOR DETAILS SEE FIG. 2)	S	RF
-10C	113T1339-19		ARM ASSY-NO. 1 CRANK, CRANK (VARIABLE) (LH) (PRE SB 767-27-0080) (FOR DETAILS SEE FIG. 2)	W	RF
-10D	113T1339-29		ARM ASSY-NO. 1 CRANK, CRANK (LH) (FOR DETAILS SEE FIG. 2)	B	RF
R -10E	113T1339-31		ARM ASSY-NO. 1 CRANK, CRANK (LH) (FOR DETAILS SEE FIG. 2)	AN	RF
-15	113T1339-2		ARM ASSY-NO. 1 CRANK, CRANK (RH) (PRE SB 767-27-0080) (FOR DETAILS SEE FIG. 2)	G	RF
-15A	113T1339-8		ARM ASSY-NO. 1 CRANK, CRANK (RH) (FOR DETAILS SEE FIG. 2)	H	RF
-15B	113T1339-14		ARM ASSY-NO. 1 CRANK, CRANK (RH) (POST SB 767-27-0080) (FOR DETAILS SEE FIG. 2)	T	RF
-15C	113T1339-20		ARM ASSY-NO. 1 CRANK, CRANK (VARIABLE) (RH) (PRE SB 767-27-0080) (FOR DETAILS SEE FIG. 2)	X	RF
-15D	113T1339-30		ARM ASSY-NO. 1 CRANK, CRANK (RH) (FOR DETAILS SEE FIG. 2)	AA	RF
R -15E	113T1339-32		ARM ASSY-NO. 1 CRANK, CRANK (RH) (FOR DETAILS SEE FIG. 2)	AP	RF

27-51-96

ILLUSTRATED PARTS LIST
01.1 Page 1012
Jul 01/04

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01- -20	113T1359-1		ARM ASSY-NO. 2 CRANK, CRANK (LH) (PRE SB 767-27-0080) (FOR DETAILS SEE FIG. 3)	J	RF
-20A	113T1359-7		ARM ASSY-NO. 2 CRANK, CRANK (LH) (FOR DETAILS SEE FIG. 3)	K	RF
-20B	113T1359-13		ARM ASSY-NO. 2 CRANK, CRANK (LH) (POST SB 767-27-0080) (FOR DETAILS SEE FIG. 3)	U	RF
-20C	113T1359-19		ARM ASSY-NO. 2 CRANK, CRANK (VARIABLE) (LH) (PRE SB 767-27-0080) (FOR DETAILS SEE FIG. 3)	Y	RF
-20D	113T1359-25		ARM ASSY-NO. 2 CRANK, CRANK (LH) (FOR DETAILS SEE FIG. 3)	AH	RF
R -20E	113T1359-27		ARM ASSY-NO. 2 CRANK, CRANK (LH) (FOR DETAILS SEE FIG. 3)	AQ	RF
-25	113T1359-2		ARM ASSY-NO. 2 CRANK, CRANK (RH) (PRE SB 767-27-0080) (FOR DETAILS SEE FIG. 3)	L	RF
-25A	113T1359-8		ARM ASSY-NO. 2 CRANK, CRANK (RH) (FOR DETAILS SEE FIG. 3)	M	RF
-25B	113T1359-14		ARM ASSY-NO. 2 CRANK, CRANK (RH) (POST SB 767-27-0080) (FOR DETAILS SEE FIG. 3)	V	RF
-25C	113T1359-20		ARM ASSY-NO. 2 CRANK, CRANK (VARIABLE) (RH) (PRE SB 767-27-0080) (FOR DETAILS SEE FIG. 3)	Z	RF
-25D	113T1359-26		ARM ASSY-NO. 2 CRANK, CRANK (RH) (FOR DETAILS SEE FIG. 3)	AJ	RF
R -25E	113T1359-28		ARM ASSY-NO. 2 CRANK, CRANK (RH) (FOR DETAILS SEE FIG. 3)	AR	RF

27-51-96

ILLUSTRATED PARTS LIST
01.1 Page 1013
Jul 01/04

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-30	113T1363-1		LINK ASSY-SIDE BRACE SPRT (FOR DETAILS SEE FIG. 4)	N	RF
-30A	113T1363-4		LINK ASSY-SIDE BRACE SPRT (FOR DETAILS SEE FIG. 4)	AD	RF
-35	113T1364-1		LINK ASSY-SIDE BRACE SPRT NO. 2 (FOR DETAILS SEE FIG. 5)	P	RF
-35A	113T1364-4		LINK ASSY-SIDE BRACE SPRT NO. 2 (FOR DETAILS SEE FIG. 5)	AE	RF
-36	113T1114-5		LINK ASSY-OUTBD TE FLAP DEFLECTION CONT TRACK (PRE SB 767-57-0069) (FOR DETAILS SEE FIG. 6)	Q	RF
-37	113T1352-7		LINK ASSY-OUTBD TE FLAP DEFLECTION CONT TRACK (FOR DETAILS SEE FIG. 7)	R	RF
-38	113T1015-1		LINK ASSY-OUTBD TE FLAP DEFLECTION CONT TRACK (PRE SB 767-57-0069) (FOR DETAILS SEE FIG. 8)	A	RF
-38A	113T1015-3		LINK ASSY-OUTBD TE FLAP DEFLECTION CONT TRACK (POST SB 767-57-0069) (FOR DETAILS SEE FIG. 9)	AK	RF
R -38B	113T1015-5		LINK ASSY-AUX SUPT (FOR DETAILS SEE FIG. 9)	AM	RF
40	BACB28AP08P069		.BUSHING	C,AF, AG	1
45	BACB28AP10P085		.BUSHING	D,AB, AC	1
50	113T1347-36		.BUSHING	C,AF, AG	1

27-51-96

 ILLUSTRATED PARTS LIST
 01.1 Page 1014
 Jul 01/04

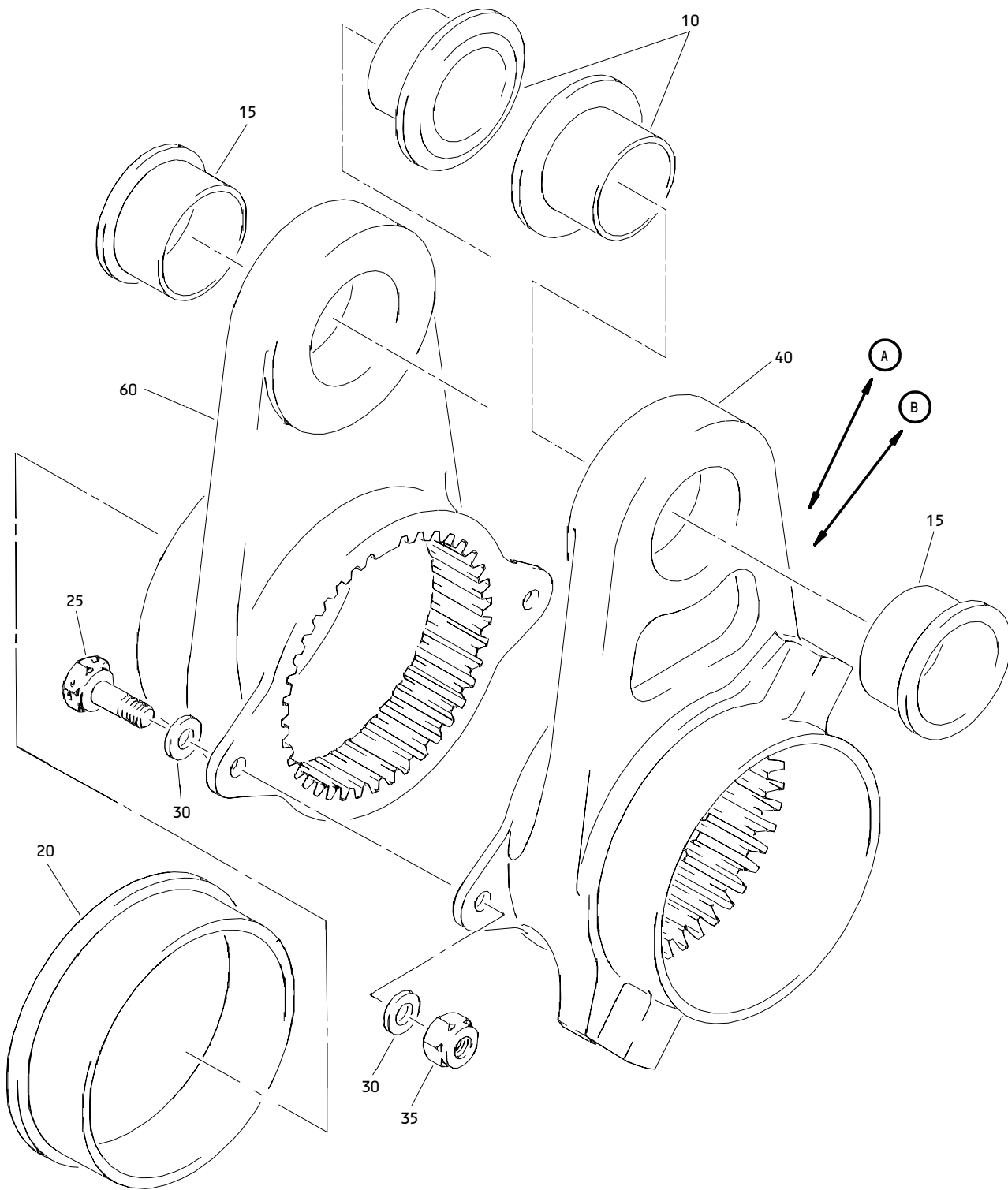
FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-55	113T1347-37		.BUSHING	D,AB,AC	1
60	113T1337-3		DELETED		
65	113T1337-4		DELETED		
70	113T1337-9		.FITTING	C	1
-70A	113T1337-13		DELETED		
-70B	113T1337-17		.FITTING	AB	1
-70C	113T1337-21		.FITTING	AG	1
75	113T1337-10		.FITTING	D	1
-75A	113T1337-14		DELETED		
-75B	113T1337-18		.FITTING	AC	1
-75C	113T1337-22		.FITTING	AF	1

R

- Item Not Illustrated

27-51-96

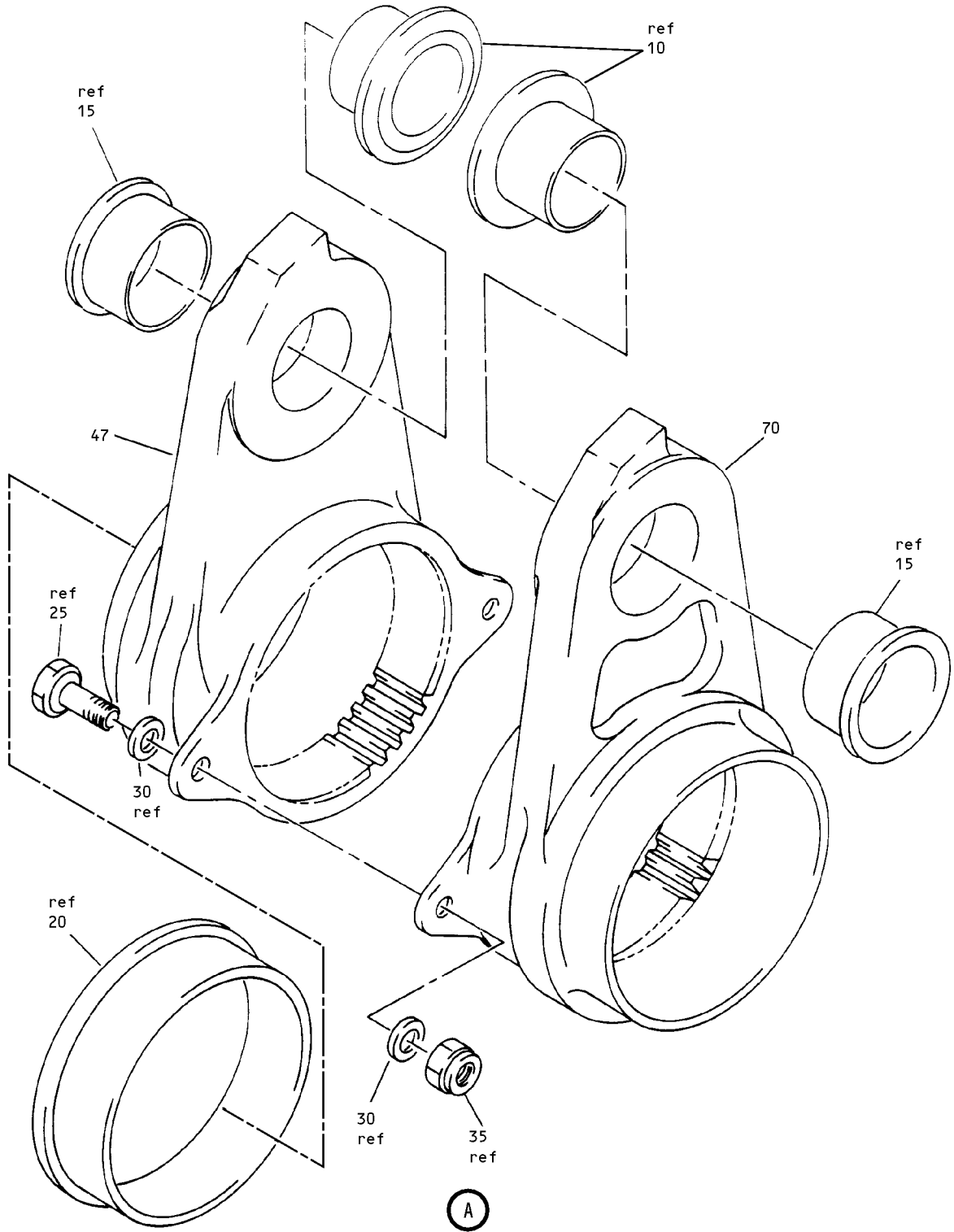
ILLUSTRATED PARTS LIST
01.1 Page 1015
Jul 01/04



No. 1 Crank Arm Assembly
Figure 2 (Sheet 1)

27-51-96

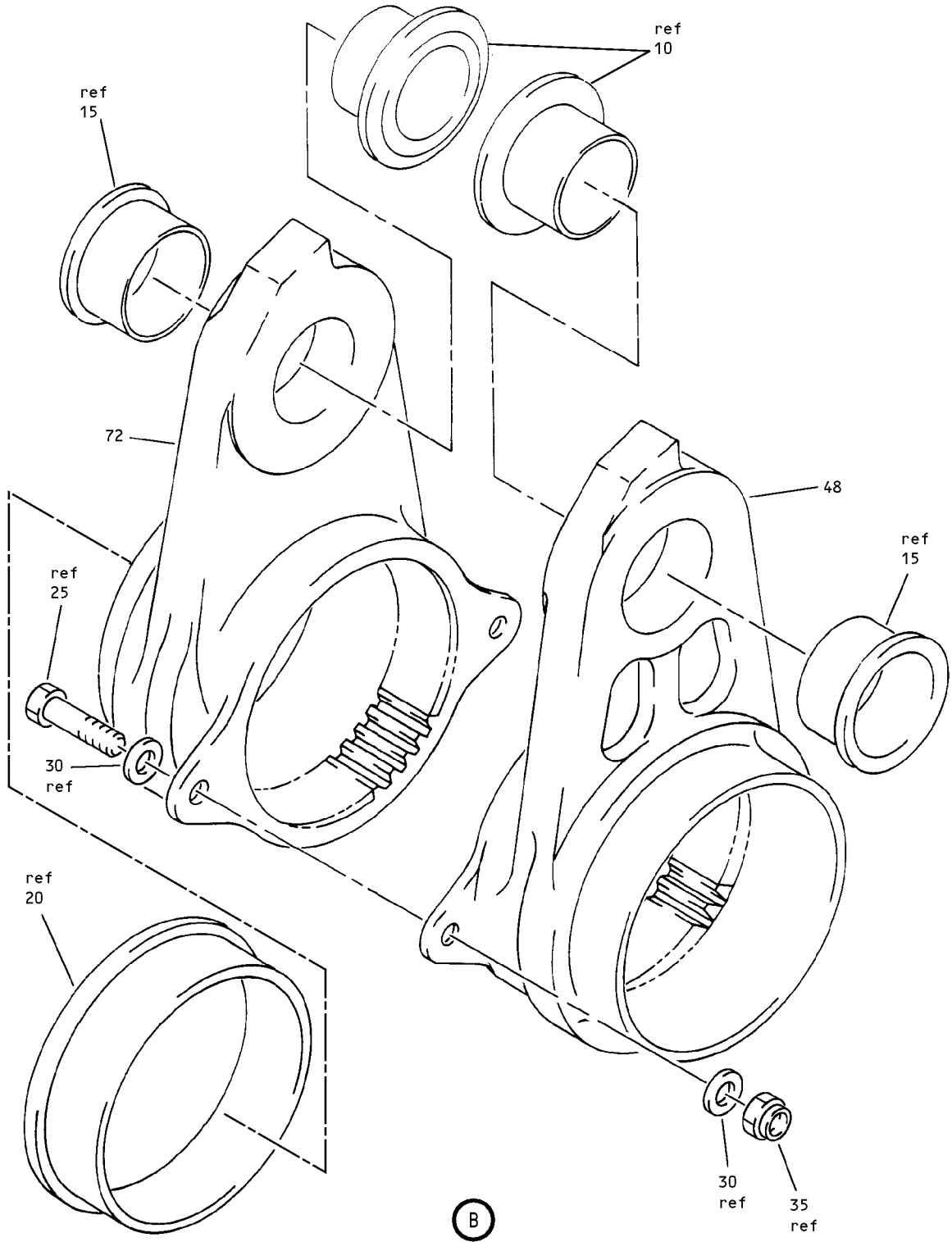
ILLUSTRATED PARTS LIST
01.1 Page 1016
Jul 01/04



No. 1 Crank Arm Assembly
Figure 2 (Sheet 2)

27-51-96

ILLUSTRATED PARTS LIST
01.1 Page 1017
Jul 01/04



No. 1 Crank Arm Assembly
 Figure 2 (Sheet 3)

27-51-96

ILLUSTRATED PARTS LIST
 01.1 Page 1018
 Jul 01/04

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02- -1	113T1339-1		ARM ASSY-NO. 1 CRANK. CRANK (LH) (PRE SB 767-27-0080)	E	RF
-1A	113T1339-7		ARM ASSY-NO. 1 CRANK. CRANK (LH)	F	RF
-1B	113T1339-13		ARM ASSY-NO. 1 CRANK. CRANK (LH) (POST SB 767-27-0080)	S	RF
-1C	113T1339-19		ARM ASSY-NO. 1 CRANK. CRANK (VARIABLE) (LH) (PRE SB 767-27-0080)	W	RF
-1D	113T1339-29		ARM ASSY-NO. 1 CRANK. CRANK (LH)	B	RF
R -1E	113T1339-31		ARM ASSY-NO. 1 CRANK. CRANK (LH)	AN	RF
-5	113T1339-2		ARM ASSY-NO. 1 CRANK. CRANK (RH) (PRE SB 767-27-0080)	G	RF
-5A	113T1339-8		ARM ASSY-NO. 1 CRANK. CRANK (RH)	H	RF
-5B	113T1339-14		ARM ASSY-NO. 1 CRANK. CRANK (RH) (POST SB 767-27-0080)	T	RF
-5C	113T1339-20		ARM ASSY-NO. 1 CRANK. CRANK (VARIABLE) (RH) (PRE SB 767-27-0080)	X	RF
-5D	113T1339-30		ARM ASSY-NO. 1 CRANK. CRANK (RH)	AA	RF
R -5E	113T1339-32		ARM ASSY-NO. 1 CRANK. CRANK (RH)	AP	RF
10	113T1312-2		.BUSHING	B,E-H ,S,T, W,X,A A,AN, AP	2
15	113T1312-3		.BUSHING	B,E-H ,S,T, W,X,A A,AN, AP	2
20	113T1312-1		.BUSHING	B,E-H ,W,X, AA	1
-20A	113T1312-13		.BUSHING	S,T,A N,AP	1

27-51-96

ILLUSTRATED PARTS LIST
01.1 Page 1019
Jul 01/04

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-25	BACB30NR4K5		.BOLT	B,E-H ,S,T, W,X,A A,AN, AP	2
30	BACW10BP4AP		.WASHER	B,E-H ,S,T, W,X,A A,AN, AP	4
35	BRH10A4		.NUT- (V52828) (SPEC BACN10JC4) (OPT T6S428J (V11815)) (OPT 96-048 (V80539)) (OPT VN303A048 (V92215)) (OPT RMLH9075-4W (V72962)) (OPT NS202101-048 (V80539)) (OPT H10-4BAC (V15653))	B,E-H ,S,T, W,X,A A	2
R -35A	BRH10C4D		.NUT- (V52828) (SPEC BACN10JC4CD) (OPT T6C428JCD (V11815)) (OPT NS202486-048 (V80539)) (OPT 102LH9075-4W (V72962)) (OPT H51650-4BAC (V15653))	AN,AP	2

27-51-96

 ILLUSTRATED PARTS LIST
 01.1 Page 1020
 Jul 01/04

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-40	113T1339-3		.CRANK HALF- (OPT ITEM 40A)	B,E,W	1
-40A	113T1339-25		.CRANK HALF- (OPT ITEM 40)	B,E,W	1
-45	113T1339-9		.CRANK HALF	F	1
47	113T1339-15		.CRANK HALF- (OPT ITEM 47A)	S	1
-47A	113T1339-21		.CRANK-HALF (OPT ITEM 47)	S	1
R 48	113T1339-37		.CRANK-HALF	AN	1
-50	113T1339-4		.CRANK HALF- (OPT ITEM 50A)	G,X,A A	1
-50A	113T1339-26		.CRANK HALF- (OPT ITEM 50)	G,X,A A	1
-55	113T1339-10		.CRANK HALF	H	1
-57	113T1339-16		.CRANK HALF- (OPT ITEM 57A)	T	1
-57A	113T1339-22		.CRANK-HALF (OPT ITEM 57)	T	1
R -58	113T1339-38		.CRANK-HALF	AP	1
60	113T1339-5		.CRANK HALF- (OPT ITEM 60A)	B,E,G ,W,X, AA	1
-60A	113T1339-27		.CRANK HALF- (OPT ITEM 60)	B,E,G ,W,X, AA	1
-65	113T1339-11		.CRANK HALF	F,H	1
70	113T1339-17		.CRANK HALF- (OPT ITEM 70A)	S	1
-70A	113T1339-23		.CRANK-HALF (OPT ITEM 70)	S	1

27-51-96

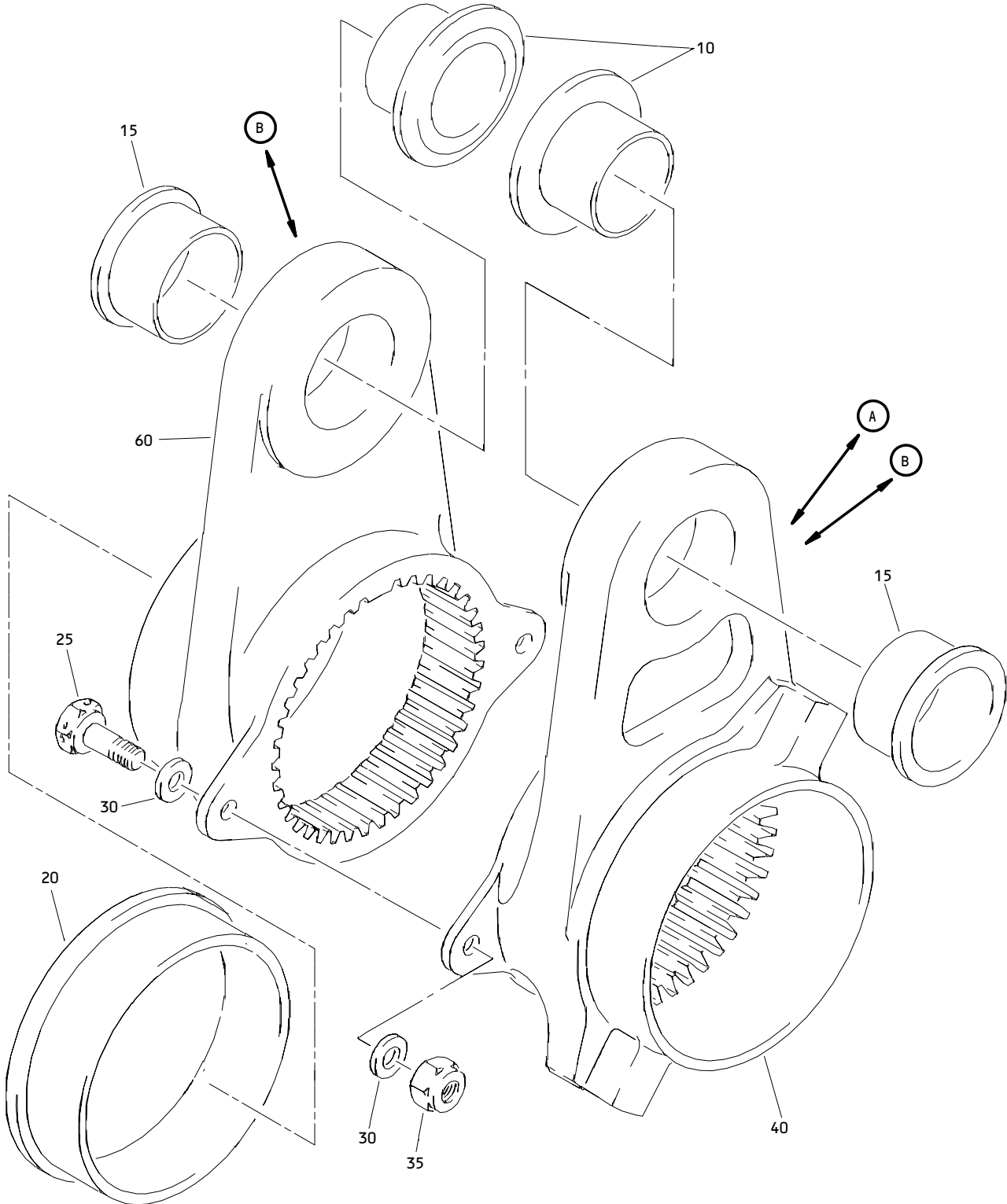
ILLUSTRATED PARTS LIST
01.1 Page 1021
Jul 01/04

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 02- 72	113T1339-39		.CRANK-HALF	AN	1
-75	113T1339-18		.CRANK HALF- (OPT ITEM 75A)	T	1
-75A	113T1339-24		.CRANK-HALF (OPT ITEM 75)	T	1
R -77	113T1339-40		.CRANK-HALF	AP	1

- Item Not Illustrated

27-51-96

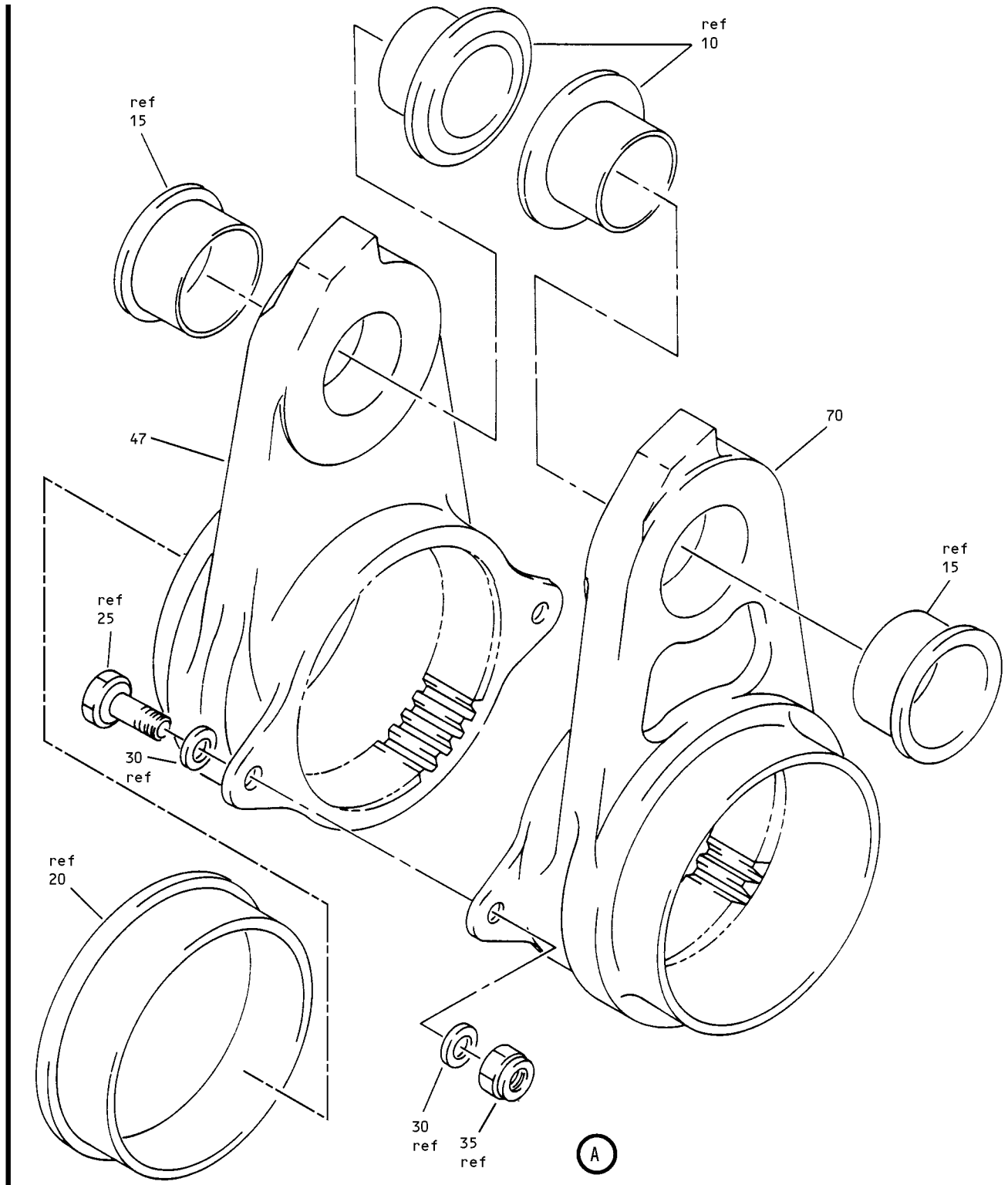
ILLUSTRATED PARTS LIST
 01.1 Page 1022
 Jul 01/04



No. 2 Crank Arm Assembly
Figure 3 (Sheet 1)

27-51-96

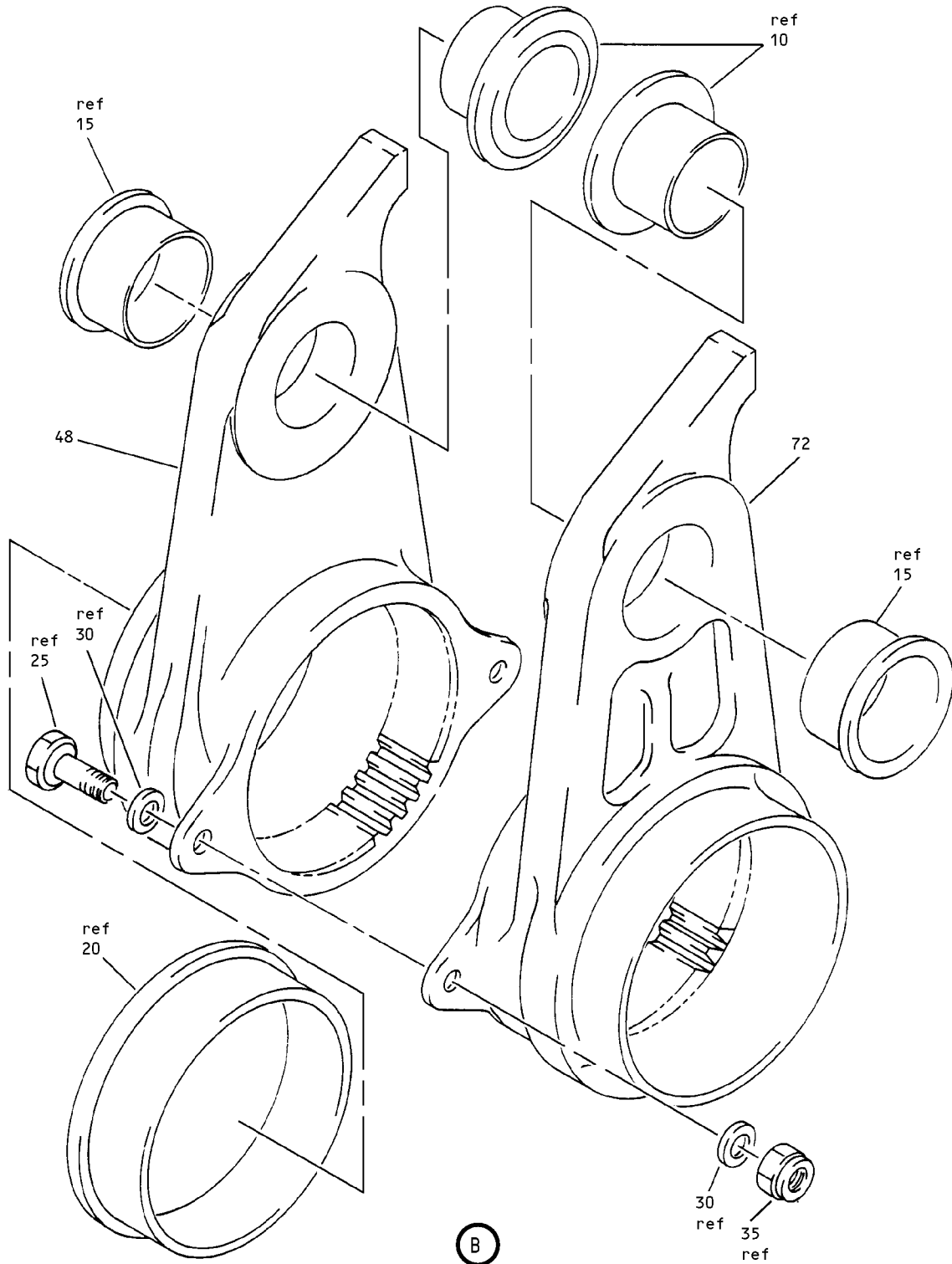
ILLUSTRATED PARTS LIST
01.1 Page 1024
Jul 01/04



No. 2 Crank Arm Assembly
Figure 3 (Sheet 2)

27-51-96

ILLUSTRATED PARTS LIST
01.1 Page 1025
Jul 01/04



No. 2 Crank Arm Assembly
 Figure 3 (Sheet 3)

27-51-96

ILLUSTRATED PARTS LIST
 01.1 Page 1026
 Jul 01/04

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
03- -1	113T1359-1		ARM ASSY-NO. 2 CRANK, CRANK (LH) (PRE SB 767-27-0080)	J	RF
-1A	113T1359-7		ARM ASSY-NO. 2 CRANK, CRANK (LH)	K	RF
-1B	113T1359-13		ARM ASSY-NO. 2 CRANK, CRANK (LH) (POST SB 767-27-0080)	U	RF
-1C	113T1359-19		ARM ASSY-NO. 2 CRANK, CRANK (VARIABLE) (LH) (PRE SB 767-27-0080)	Y	RF
-1D	113T1359-25		ARM ASSY-NO. 2 CRANK, CRANK (LH)	AH	RF
R -1E	113T1359-27		ARM ASSY-NO. 2 CRANK, CRANK (LH)	AQ	RF
-5	113T1359-2		ARM ASSY-NO. 2 CRANK, CRANK (RH) (PRE SB 767-27-0080)	L	RF
-5A	113T1359-8		ARM ASSY-NO. 2 CRANK, CRANK (RH)	M	RF
-5B	113T1359-14		ARM ASSY-NO. 2 CRANK, CRANK (RH) (POST SB 767-27-0080)	V	RF
-5C	113T1359-20		ARM ASSY-NO. 2 CRANK, CRANK (VARIABLE) (RH) (PRE SB 767-27-0080)	Z	RF
-5D	113T1359-26		ARM ASSY-NO. 2 CRANK, CRANK (RH)	AJ	RF
R -5E	113T1359-28		ARM ASSY-NO. 2 CRANK, CRANK (RH)	AR	RF

27-51-96

ILLUSTRATED PARTS LIST
01.1 Page 1027
Jul 01/04

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
03- 10	113T1312-2		.BUSHING	J-M,U ,V,Y, Z,AH, AJ,AQ ,AR	2
15	113T1312-3		.BUSHING	J-M,U ,V,Y, Z,AH, AJ,AQ ,AR	2
20	113T1312-1		.BUSHING	J-M,Y ,Z,AH ,AJ	1
-20A	113T1312-13		.BUSHING	U,V,A Q,AR	1
25	BACB30NR4K5		.BOLT	J-M,U ,V,Y, Z,AH, AJ,AQ ,AR	2
30	BACW10BP4AP		.WASHER	J-M,U ,V,Y, Z,AH, AJ,AQ ,AR	4

27-51-96

 ILLUSTRATED PARTS LIST
 01.1 Page 1028
 Jul 01/04

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
03-35	BRH10A4		.NUT- (V52828) (SPEC BACN10JC4) (OPT T6S428J (V11815)) (OPT 96-048 (V80539)) (OPT VN303A048 (V92215)) (OPT RMLH9075-4W (V72962)) (OPT NS202101-048 (V80539)) (OPT H10-4BAC (V15653))	J-M,U ,V,Y, Z	2
R -35A	BRH10C4D		.NUT- (V52828) (SPEC BACN10JC4CD) (OPT T6C428JCD (V11815)) (OPT NS202486-048 (V80539)) (OPT 102LH9075-4W (V72962)) (OPT H51650-4BAC (V15653))	AH,AJ ,AQ,A R	2
40	113T1359-3		.CRANK HALF	J,Y	1
R -40A	113T1359-3		.CRANK HALF- (OPT ITEM 40B)	AH	1
R -40B	113T1359-9		.CRANK HALF- (OPT ITEM 40A)	AH	1

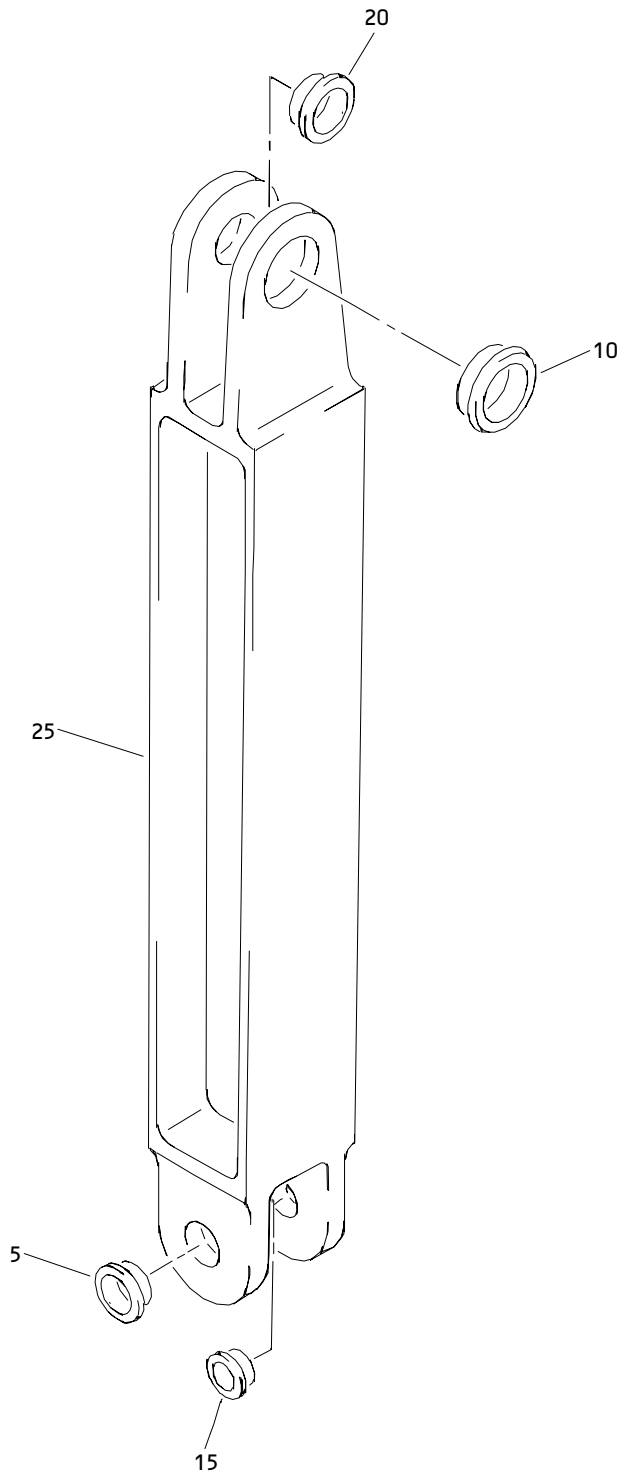
27-51-96

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
03-					
-45	113T1359-9		.CRANK HALF	K	1
47	113T1359-15		.CRANK HALF-	U	1
			(OPT ITEM 47A)		
-47A	113T1359-21		.CRANK-HALF	U	1
			(OPT ITEM 47)		
R 48	113T1359-29		.CRANK-HALF	AQ	1
-50	113T1359-4		.CRANK HALF	L,Z	1
R -50A	113T1359-4		.CRANK HALF-	AJ	1
			(OPT ITEM 50B)		
R -50B	113T1359-10		.CRANK HALF-	AJ	1
			(OPT ITEM 50A)		
-55	113T1359-10		.CRANK HALF	M	1
-57	113T1359-16		.CRANK HALF-	V	1
			(OPT ITEM 57A)		
-57A	113T1359-22		.CRANK-HALF	V	1
			(OPT ITEM 57)		
R -58	113T1359-30		.CRANK-HALF	AR	1
60	113T1359-5		.CRANK HALF	J,L,Y	1
				Z	
R -60A	113T1359-5		.CRANK HALF-	AH,AJ	1
			(OPT ITEM 60B)		
R -60B	113T1359-11		.CRANK HALF-	AH,AJ	1
			(OPT ITEM 60A)		
-65	113T1359-11		.CRANK HALF	K,M	1
70	113T1359-17		.CRANK HALF-	U	1
			(OPT ITEM 70A)		
-70A	113T1359-23		.CRANK-HALF	U	1
			(OPT ITEM 70)		
R 72	113T1359-31		.CRANK-HALF	AQ	1
-75	113T1359-18		.CRANK HALF-	V	1
			(OPT ITEM 75A)		
-75A	113T1359-24		.CRANK-HALF	V	1
			(OPT ITEM 75)		
R -77	113T1359-32		.CRANK-HALF	AR	1

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27-51-96

 ILLUSTRATED PARTS LIST
 01.1 Page 1030
 Jul 01/04



Outboard Trailing Edge Flap - Side Brace Support Link Assembly
Figure 4

27-51-96

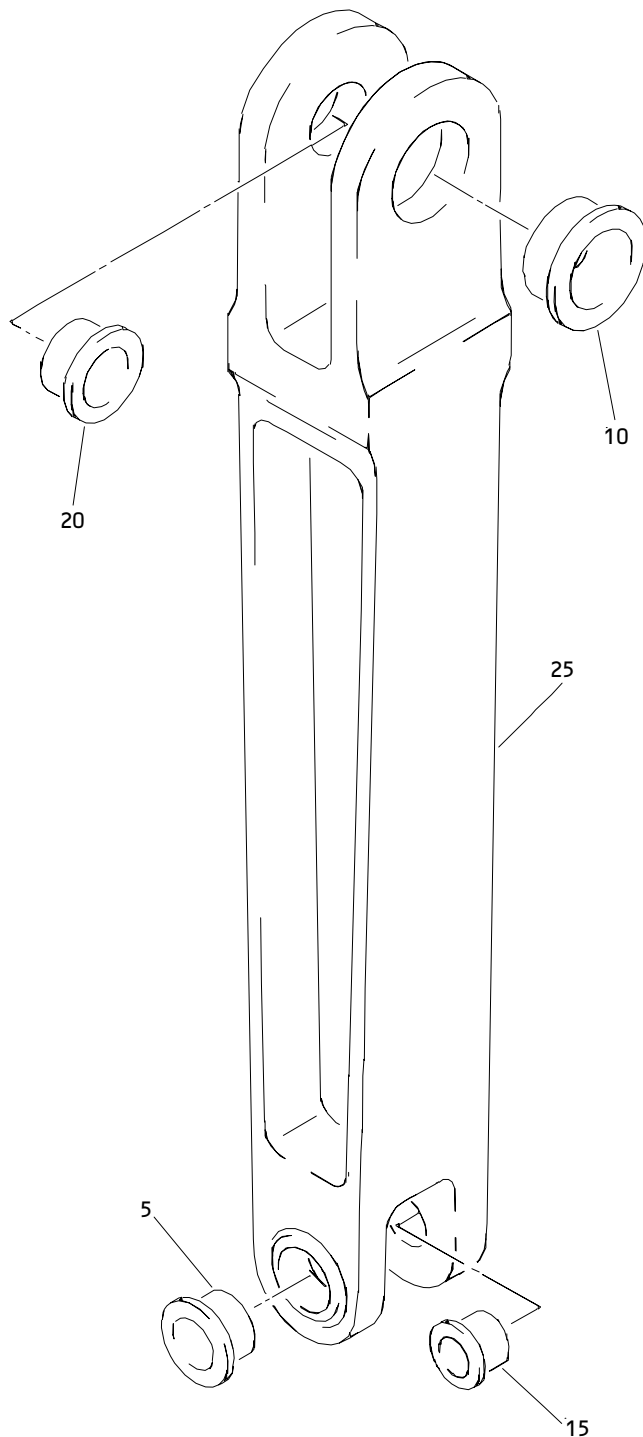
ILLUSTRATED PARTS LIST
01.1 Page 1032
Jul 01/04

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
04-					
-1	113T1363-1		LINK ASSY-SIDE BRACE SPRT	N	RF
-1A	113T1363-4		LINK ASSY-SIDE BRACE SPRT	AD	RF
5	BACB28AM09B034A		.BUSHING	N,AD	1
10	BACB28AM14B026A		.BUSHING	N,AD	1
15	BACB28AP06P034		.BUSHING	N,AD	1
20	BACB28AP10P026		.BUSHING	N,AD	1
25	113T1363-2		.LINK	N	1
-25A	113T1363-5		.LINK	AD	1

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27-51-96

ILLUSTRATED PARTS LIST
 01.1 Page 1033
 Jul 01/04



Side Brace Support No. 2 Link Assembly
Figure 5

27-51-96

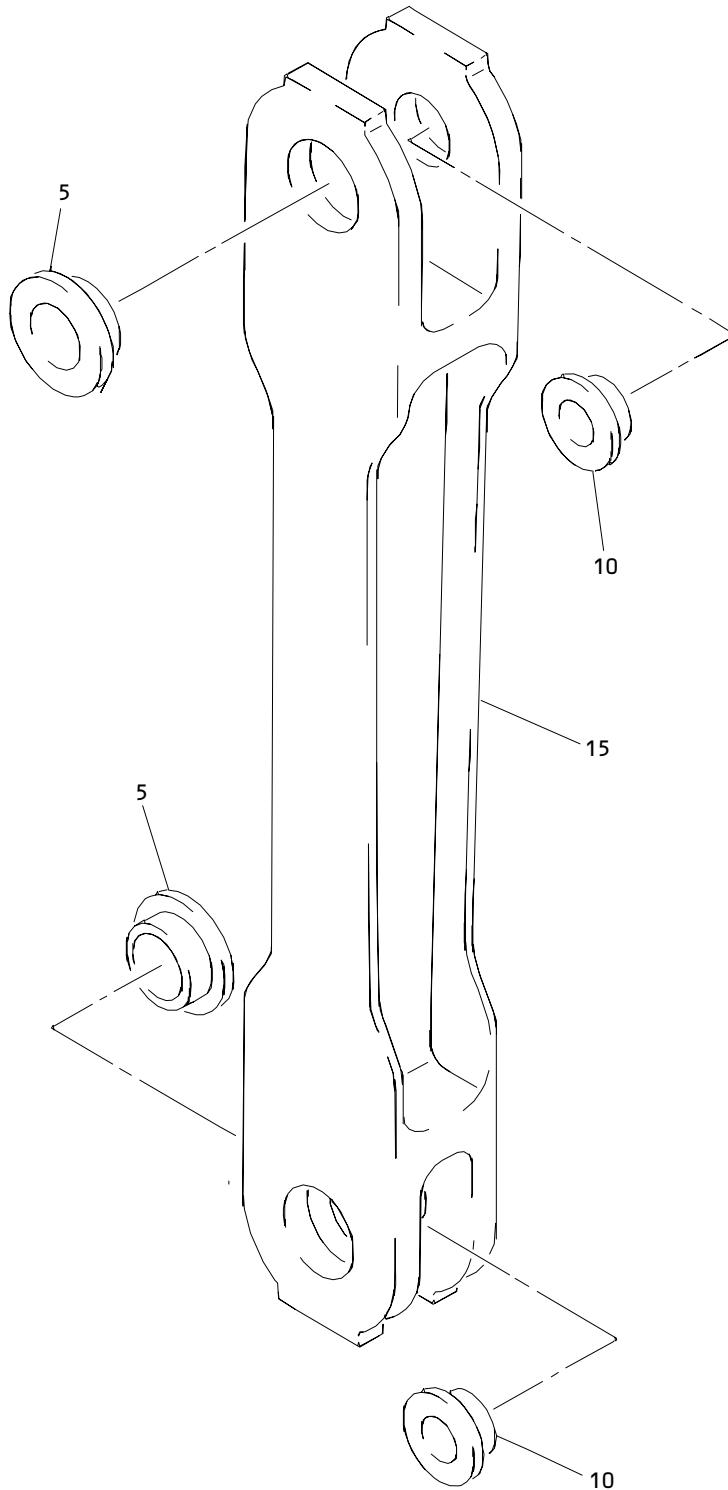
ILLUSTRATED PARTS LIST
01.1 Page 1034
Jul 01/04

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
05- -1	113T1364-1		LINK ASSY-SIDE BRACE SPRT NO. 2	P	RF
-1A	113T1364-4		LINK ASSY-SIDE BRACE SPRT NO. 2	AE	RF
5	BACB28AM11B042A		.BUSHING	P,AE	1
10	BACB28AM17B040A		.BUSHING	P,AE	1
15	BACB28AP08P042		.BUSHING	P,AE	1
20	BACB28AP12P040		.BUSHING	P,AE	1
25	113T1364-2		.LINK	P	1
-25A	113T1364-5		.LINK	AE	1

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27-51-96

ILLUSTRATED PARTS LIST
 01.1 Page 1035
 Jul 01/04



Outboard Trailing Edge Flap Deflection Control Track Link Assembly
Figure 6

27-51-96

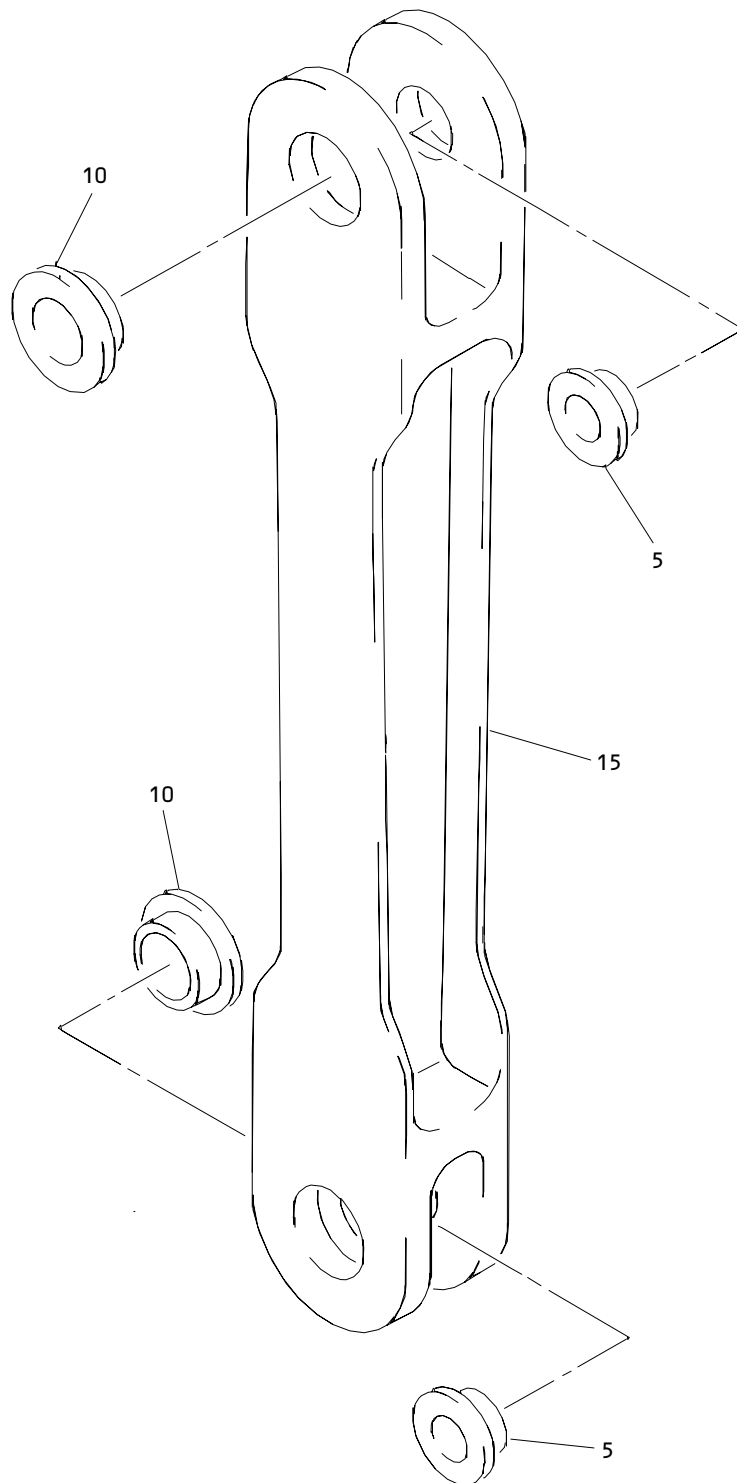
ILLUSTRATED PARTS LIST
01.1 Page 1036
Jul 01/04

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE	EFF CODE	QTY PER ASSY
			1234567		
06- -1	113T1114-5		LINK ASSY-OUTBD TE FLAP DEFLECTION CONT TRACK (PRE SB 767-57-0069)	Q	RF
5	BACB28AM11B023A		.BUSHING	Q	2
10	BACB28AP08P023		.BUSHING	Q	2
15	113T1114-6		.LINK	Q	1

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27-51-96

ILLUSTRATED PARTS LIST
 01.1 Page 1037
 Jul 01/04



Outboard Trailing Edge Flap Deflection Control Track Link Assembly
Figure 7

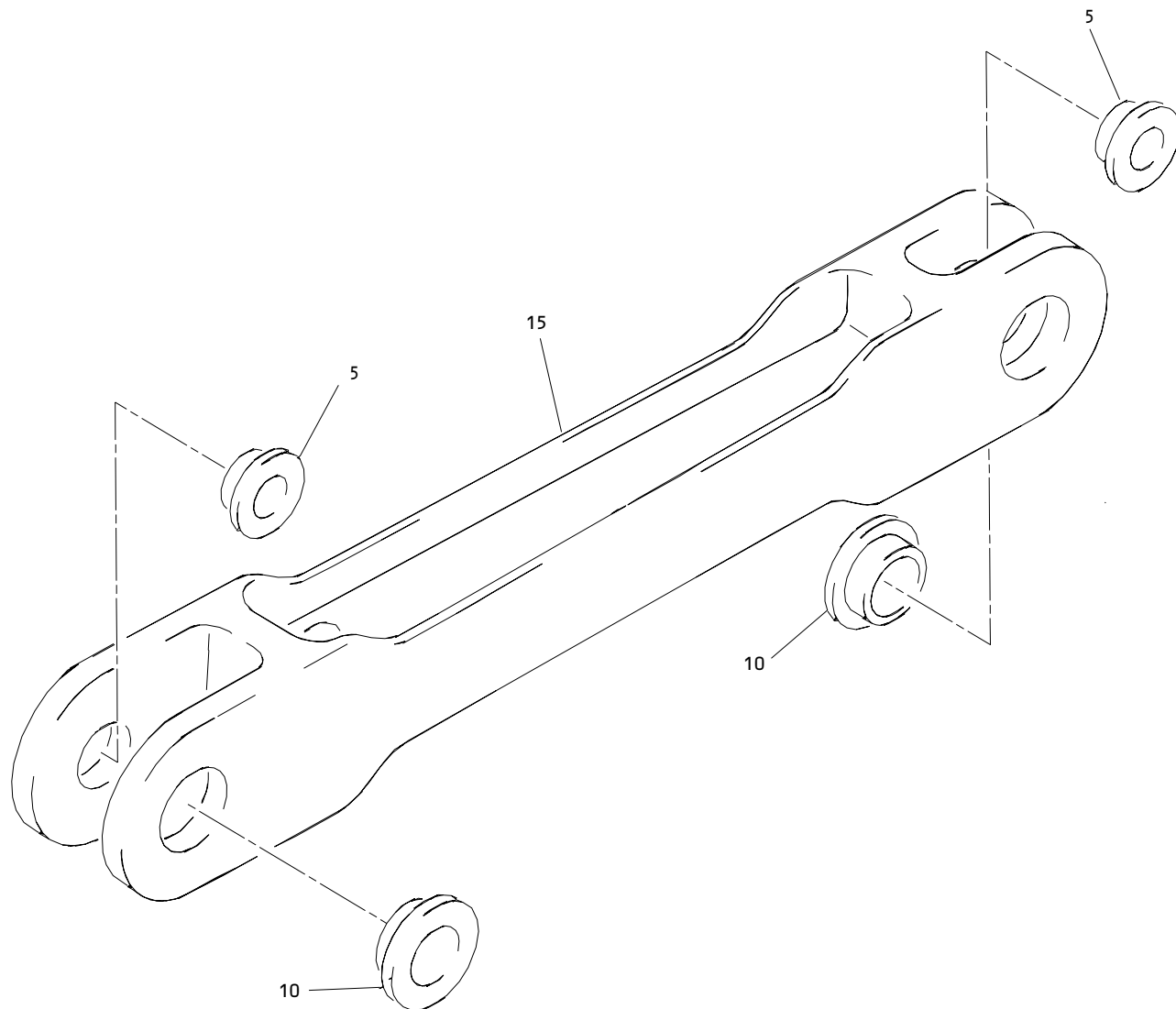
27-51-96

ILLUSTRATED PARTS LIST
01.1 Page 1038
Jul 01/04

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE	EFF CODE	QTY PER ASSY
			1234567		
07- -1	113T1352-7		LINK ASSY-OUTBD TE FLAP DEFLECTION CONT TRACK	R	RF
5	BACB28AP08P023		.BUSHING	R	2
10	BACB28AM11B023A		.BUSHING	R	2
15	113T1352-8		.LINK	R	1

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27-51-96



Outboard Trailing Edge Flap Deflection Control Track Link Assembly
Figure 8

27-51-96

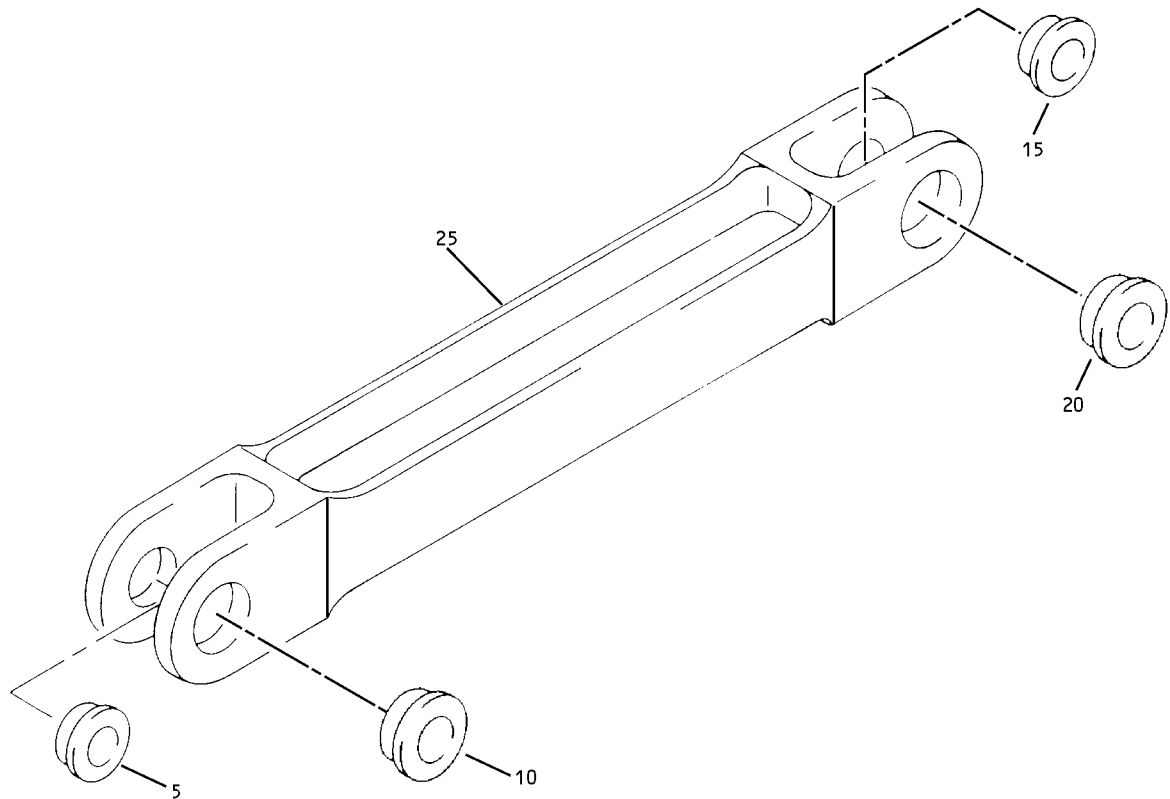
ILLUSTRATED PARTS LIST
01.1 Page 1040
Jul 01/04

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
08- -1A	113T1015-1		LINK ASSY-OUTBD TE FLAP DEFLECTION CONT TRACK (PRE SB 767-57-0069)	A	RF
5	BACB28AT11B019		.BUSHING	A	2
10	BACB28AP08-019		.BUSHING	A	2
15	113T1015-2		.LINK	A	1

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27-51-96

ILLUSTRATED PARTS LIST
 01.1 Page 1041
 Jul 01/04



Outboard Trailing Edge Flap Deflection Control Track Link Assembly
Figure 9

27-51-96

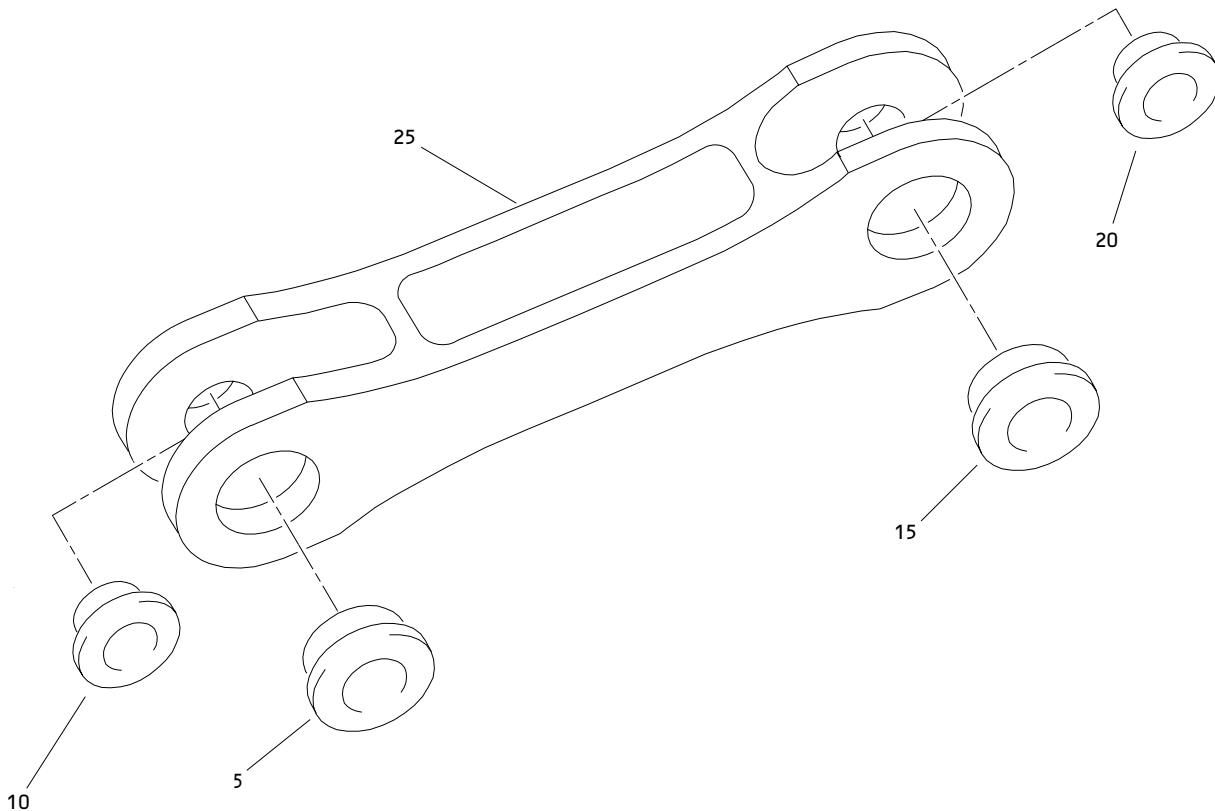
ILLUSTRATED PARTS LIST
01.1 Page 1042
Jul 01/04

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
09- -1A	113T1015-3		LINK ASSY-OUTBD TE FLAP DEFLECTION CONT TRACK (POST SB 767-57-0069)	AK	RF
R -1B	113T1015-5		LINK ASSY-AUX SUPT	AM	RF
5	BACB28AP09-029		.BUSHING	AK	1
R -5A	BACB28AP08-029		.BUSHING	AM	1
10	BACB28AT13B029A		.BUSHING	AK	1
R -10A	BACB28AT11B029A		.BUSHING	AM	1
15	BACB28AP08-019		.BUSHING	AK,AM	1
20	BACB28AT11B019A		.BUSHING	AK,AM	1
25	113T1015-4		.LINK	AK	1
R -25A	113T1015-6		.LINK	AM	1

- Item Not Illustrated

27-51-96

ILLUSTRATED PARTS LIST
01.1 Page 1043
Jul 01/04



Outboard Trailing Edge Flap Inboard Auxiliary Link Assembly
Figure 10

27-51-96

ILLUSTRATED PARTS LIST
01.1 Page 1044
Jul 01/04

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 10-					
R -1A	113T1382-1		LINK ASSY-INBD AUX	AL	RF
R 5	BACB28AT17B043C		.BUSHING	AL	1
R 10	BACB28AX12C043		.BUSHING	AL	1
R 15	BACB28AT17B034C		.BUSHING	AL	1
R 20	BACB28AX12C034		.BUSHING	AL	1
R 25	113T1382-3		.LINK	AL	1

- Item Not Illustrated

27-51-96