

 **BOEING**
COMPONENT
MAINTENANCE MANUAL

TO: ALL HOLDERS OF INBOARD TRAILING EDGE FLAP TRACK AND BEAM ASSEMBLY
COMPONENT MAINTENANCE MANUAL 27-51-98

REVISION NO. 7 DATED APR 01/92

HIGHLIGHTS

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

CHAPTER/SECTION

AND PAGE NO.

1002-1004,1006-1008,
1012-1023

DESCRIPTION OF CHANGE

Edited the Illustrated Parts List without technical
change due to printing error.

27-51-98

HIGHLIGHTS

01.1

Page 1

Apr 01/92

**INBOARD TRAILING EDGE
FLAP TRACK AND BEAM ASSEMBLY**

PART NUMBERS 113T2000-61,-71,-89,-90,-103

COMPONENT MAINTENANCE MANUAL
WITH
ILLUSTRATED PARTS LIST

27-51-98

TITLE PAGE
Page 1
Jan 01/92

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



TEMPORARY REVISION AND SERVICE BULLETIN RECORD

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVE	DATE OF INCORPORATION INTO MANUAL
767-27-0080R1		PRR B11313 PRR B11528 MC 0220MK6016 PRR B11528-1	APR 10/86 OCT 01/87 JAN 01/92 JAN 01/92

27-51-98

TR & SB RECORD

01.1

Page 1

Jan 01/92



BOEING
COMPONENT
MAINTENANCE MANUAL

PAGE	DATE	CODE	PAGE	DATE	CODE
27-51-98			REPAIR 1-1		
			601	JAN 01/92	01.1
			602	JAN 01/92	01.1
TITLE PAGE			REPAIR 2-1		
1	JAN 01/92	01.1	601	JUL 10/85	01.1
2	BLANK		602	JUL 10/85	01.1
REVISION RECORD			603	JAN 10/86	01.1
1	JUL 10/85	01.1	604	BLANK	
2	BLANK		REPAIR 3-1		
TR & SB RECORD			601	JUL 10/85	01.1
1	JAN 01/92	01.1	602	BLANK	
2	BLANK		ASSEMBLY		
LIST OF EFFECTIVE PAGES			701	JAN 01/92	01.1
*1	APR 01/92	01	702	JAN 01/92	01.1
THRU LAST PAGE			ILLUSTRATED PARTS LIST		
CONTENTS			1001	JUL 10/85	01.1
1	JUL 10/85	01.1	*1002	APR 01/92	01.1
2	BLANK		*1003	APR 01/92	01.1
INTRODUCTION			*1004	APR 01/92	01.1
1	JUL 10/85	01.1	*1005	APR 01/92	01.1
2	BLANK		*1006	APR 01/92	01.1
DESCRIPTION & OPERATION			*1007	APR 01/92	01.1
1	APR 10/86	01.1	*1008	APR 01/92	01.1
2	BLANK		*1009	BLANK	
DISASSEMBLY			*1010	APR 01/92	01.1
301	JAN 01/92	01.1	*1011	APR 01/92	01.1
302	BLANK		*1012	APR 01/92	01.1
CHECK			*1013	APR 01/92	01.1
501	JUL 10/85	01.1	*1014	APR 01/92	01.1
502	BLANK		*1015	APR 01/92	01.1
REPAIR-GENERAL			*1016	APR 01/92	01.1
601	JUL 10/85	01.1	*1017	APR 01/92	01.1
602	OCT 01/87	01.1	*1018	APR 01/92	01.1
			*1019	APR 01/92	01.1
			*1020	APR 01/92	01.1
			*1021	APR 01/92	01.1
			*1022	APR 01/92	01.1
			*1023	APR 01/92	01.1
			*1024	BLANK	

* = REVISED, ADDED OR DELETED

27-51-98

EFFECTIVE PAGES
LAST PAGE Page 1
01 Apr 01/92



TABLE OF CONTENTS

<u>Paragraph Title</u>	<u>Page</u>
Description and Operation	1
Testing and Trouble Shooting (not applicable)	
Disassembly	301
Cleaning.*[1]	
Check	501
Repair.	601
Assembly.	701
Fits and Clearances	801
Special Tools (not applicable)	
Illustrated Parts List.	1001

*[1] Special instructions not required. Use standard industry practices.

27-51-98

CONTENTS
Page 1
Jul 10/85

01.1

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.

27-51-98

INTRODUCTION

01.1

Page 1

Jul 10/85

INBOARD TRAILING EDGE FLAP TRACK AND BEAM ASSEMBLY

DESCRIPTION AND OPERATION

1. Description and Operation

A. The trailing edge flap track assemblies are the tracks used to support and guide the TE flaps during extension and retraction. The beam is part of the support structure of the track. Tracks and beams consist of steel or aluminum forgings, bushings and bearings.

B. Leading Particulars (Approximate)

(1) Track

Length -- 45 inches
Width -- 2 inches
Height -- 19 inches
Weight -- 19 pounds

(2) Beam

Length -- 32 inches
Width -- 4 inches
Height -- 6 inches
Weight -- 10 pounds

27-51-98

DESCRIPTION & OPERATION

01.1

Page 1

Apr 10/86

DISASSEMBLY

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

1. Disassembly (IPL Fig. 1)

- A. If still attached, remove beam assembly (260) and plate assembly (315, 320) with attached parts from track assembly (30) off the tapered end.
- B. Remove bolt (5), washer (10), washer (15), nut (20), bushing (25) and link assembly (26) from track assembly (30).

NOTE: Do not remove bearing (27) from link assembly (26) unless necessary for repair or replacement.

Do not remove bearing (35) from track assembly (30) unless necessary for repair or replacement.

- C. Remove bolts (150, 235, 240), washers (155, 160, 245, 250), nuts (165, 255), bridge (170), wear plates (171) and beam assembly (260) from plate assemblies (315, 320).
- D. Remove bolt assembly (190), washer (205), spacers (220, 225), bearing (230), lockwasher (210) and nut (215) from plate assemblies (315, 320).
- E. Remove bolt assemblies (55), washers (75), bushings (95), bearings (100), washers (80, 85), and nuts (90A) from plate assemblies (315, 320).
- F. Remove bolt assemblies (105), washers (125), bearings (145), bushings (140), washers (130) and nuts (135A) from plate assemblies (315, 320).
- G. Remove nuts (185), washers (180) and roller bearings (175) from plate assemblies (315, 320).

27-51-98

DISASSEMBLY

01.1

Page 301

Jan 01/92

CHECK

1. Check all parts for obvious defects in accordance with standard industry practices.
2. Magnetic particle check the following parts per 20-20-01.
 - A. Track (30, IPL Fig. 1)
3. Penetrant check the following parts per 20-20-02.
 - A. Beam assembly (260, IPL Fig. 1)
 - B. Plate (355, 360 IPL Fig. 1)
 - C. Support link assembly (26 IPL Fig. 1)

27-51-98

01.1
CHECK
Page 501
Jul 10/85

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>
113T1230	TRACK	1-1
113T1213	PLATE	2-1
- - -	MISC PARTS REFINISH	3-1

2. Standard Practices

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

- 20-30-02 Stripping or Protective Finishes.
- 20-40-01 Decoding Table for Boeing Finish Codes
- 20-41-02 Application of Chemical and Solvent Resistant Finishes
- 20-50-03 Bearing Installation and Retention
- 20-42-02 Low Hydrogen Embrittlement Cadmium Titanium Alloy Plating
- 20-50-02 Installation of Safetying Devices

3. Materials

NOTE: Equivalent substitutes may be used.

- A. Primer -- BMS 10-11, type 1 (Ref 20-41-02)
- B. Enamel -- BMS 10-60 gray gloss enamel (Ref 20-60-20)
- C. Sealant -- BMS 5-95 (Ref 20-60-04)

4. Dimensioning Symbols

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

—	STRAIGHTNESS	\oplus	THEORETICAL EXACT POSITION OF A FEATURE (TRUE POSITION)
\square	FLATNESS	\varnothing	DIAMETER
\perp	PERPENDICULARITY (OR SQUARENESS)	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.
//	PARALLELISM	DIM	
\bigcirc	ROUNDNESS	-A-	DATUM
\bigcirc	CYLINDRICITY	\textcircled{M}	MAXIMUM MATERIAL CONDITION (MMC)
\frown	PROFILE OF A LINE	\textcircled{S}	REGARDLESS OF FEATURE SIZE (RFS)
\triangle	PROFILE OF A SURFACE	\textcircled{P}	PROJECTED TOLERANCE ZONE
\odot	CONCENTRICITY		
\equiv	SYMMETRY		
\sphericalangle	ANGULARITY		
\nearrow	RUNOUT		

EXAMPLES

$\text{—} \quad 0.002$	STRAIGHT WITHIN 0.002	$\textcircled{\odot} \text{ C } \varnothing \quad 0.0005$	CONCENTRIC TO C WITHIN 0.0005 DIAMETER (FULL INDICATOR MOVEMENT)
$\perp \text{ B } \quad 0.002$	PERPENDICULAR TO B WITHIN 0.002	$\equiv \text{ A } \quad 0.010$	SYMMETRICAL WITH A WITHIN 0.010
$\parallel \text{ A } \quad 0.002$	PARALLEL TO A WITHIN 0.002	$\sphericalangle \text{ A } \quad 0.005$	ANGULAR TOLERANCE 0.005 WITH A
$\bigcirc \quad 0.002$	ROUND WITHIN 0.002	$\oplus \text{ B } \varnothing \quad 0.002 \textcircled{S}$	LOCATED AT TRUE POSITION WITHIN 0.002 DIA IN RELATION TO DATUM B, REGARDLESS OF FEATURE SIZE
$\bigcirc \quad 0.010$	CYLINDRICAL SURFACE MUST LIE BETWEEN TWO CONCENTRIC CYLINDERS, ONE OF WHICH HAS A RADIUS 0.010 INCH GREATER THAN THE OTHER	$\perp \text{ A } \varnothing \quad 0.010 \textcircled{M}$ $0.510 \textcircled{P}$	AXIS IS TOTALLY WITHIN A CYLINDER OF 0.010-INCH DIAMETER, PERPENDICULAR TO, AND EXTENDING 0.510-INCH ABOVE, DATUM A, MAXIMUM MATERIAL CONDITION
$\frown \text{ A } \quad 0.006$	EACH LINE ELEMENT OF THE SURFACE AT ANY CROSS SECTION MUST LIE BETWEEN TWO PROFILE BOUNDARIES 0.006 INCH APART IN RELATION TO DATUM PLANE A	2.000	EXACT DIMENSION IS 2.000
$\triangle \text{ A } \quad 0.020$	SURFACES MUST LIE WITHIN PARALLEL BOUNDARIES 0.02 INCH APART AND EQUALLY DISPOSED ABOUT TRUE PROFILE	OR 2.000 BSC	

True Position Dimensioning Symbols
Figure 601

27-51-98

REPAIR-GENERAL

01.1 Page 602

Oct 01/87

TRACK ASSEMBLY – REPAIR 1-1

113T1230-1, -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 (IPL Fig. 1, Fig. 601)

- A. Remove bushings (40, 45).
- B. Install bushings with wet BMS 5-95 sealant per 20-50-03.
- C. Machine bushings as shown.
- D. Fillet seal bushing flanges.

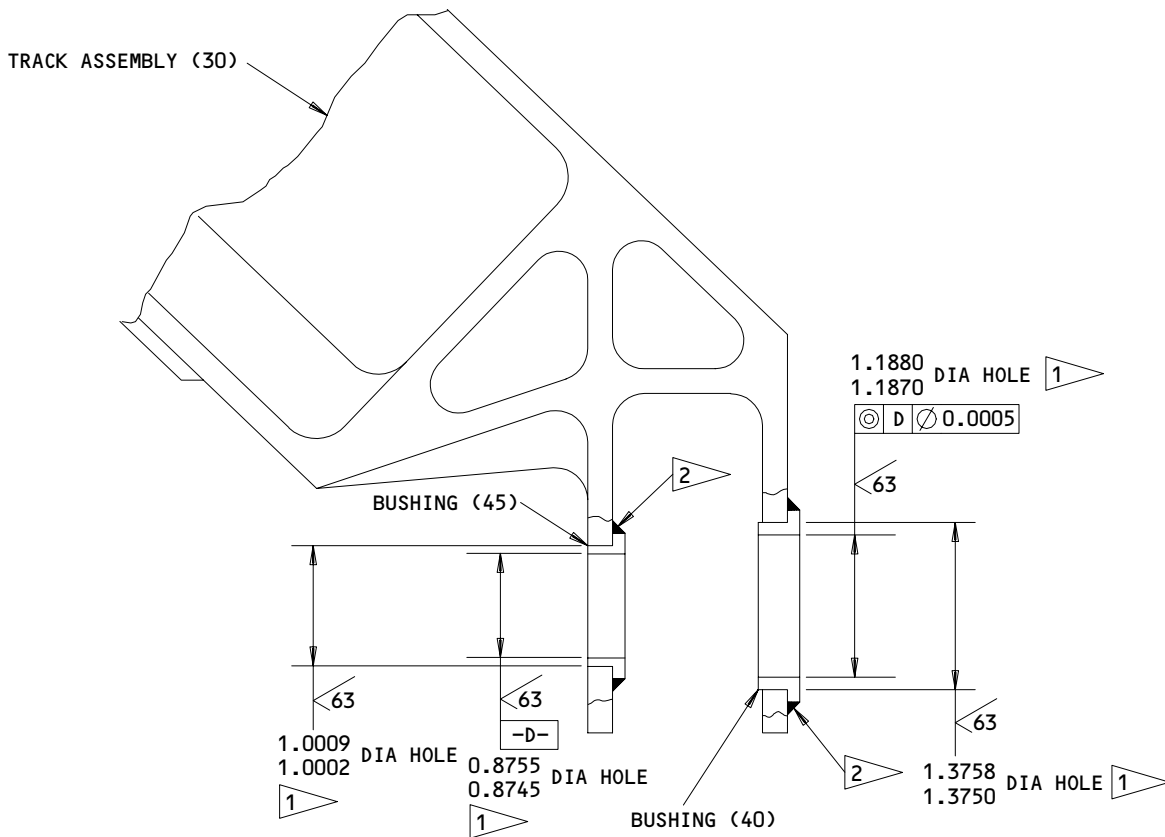
27-51-98

REPAIR 1-1

01.1

Page 601

Jan 01/92



REFINISH

TRACK (30) - CADMIUM - TITANIUM PLATE (F-15.01)
 AND APPLY ONE COAT BMS 10-11, TYPE I, PRIMER
 (F-20.02). APPLY BMS 10-60 BOEING COLOR 707
 GRAY GLOSS ENAMEL (SRF-14.9813).

MATERIAL: 4330M STEEL, 275-300 KSI

ALL DIMENSIONS ARE IN INCHES

ITEM NUMBERS REFER TO IPL FIG. 1

1 OMIT PRIMER AND ENAMEL THIS SURFACE

2 FILLET SEAL BUSHINGS WITH BMS 5-95 SEALANT

113T1230-1,-3,-5
 Flap Track Assembly - Repair
 Figure 601

27-51-98

REPAIR 1-1

01.1

Page 602

Jan 01/92

PLATE ASSEMBLY – REPAIR 2-1

113T1213-7, -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 (IPL Fig. 1, Fig. 601)
 - A. Remove bushings (325, 330, 335, 340, 345, 350)
 - B. Install bushings with wet BMS 5-95 per 20-50-03.
 - C. Machine bushings as shown.
 - D. Fillet seal bushing flanges.

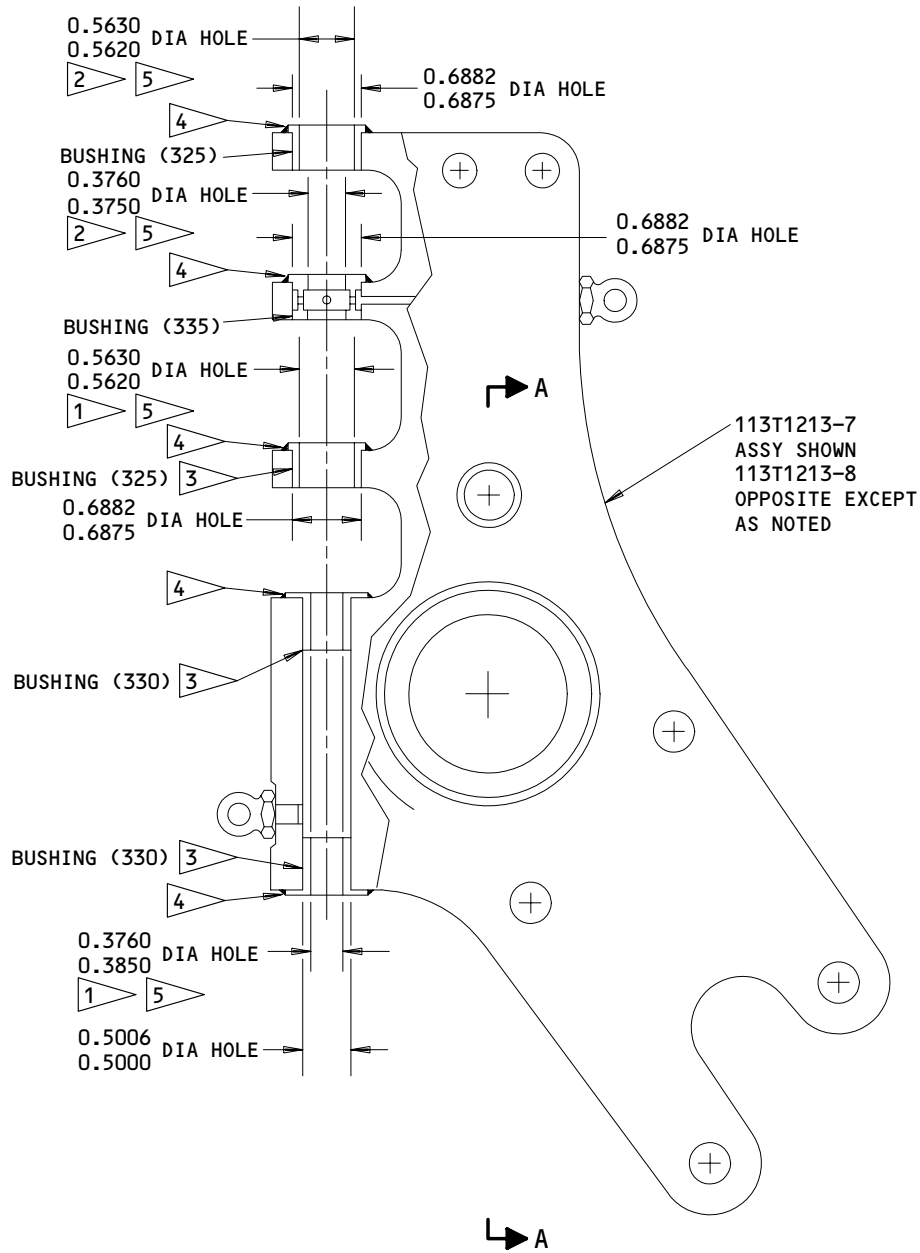
27-51-98

REPAIR 2-1

01.1

Page 601

Jul 10/85



113T1213-7,-8
 Plate Assembly - Repair
 Figure 601 (Sheet 1)

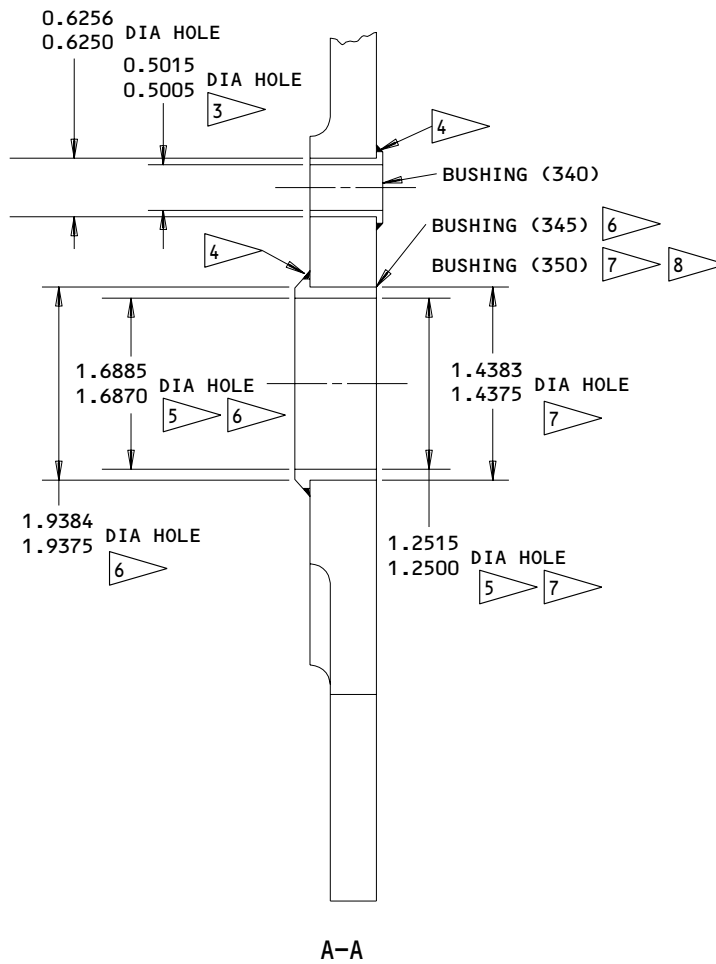
27-51-98

REPAIR 2-1

Page 602

Jul 10/85

01.1



REFINISH

PLATE (315,320) CHROMIC ACID ANODIZE, AND APPLY ONE COAT BMS 10-11 TYPE 1 PRIMER (F-18.13). APPLY BMS 10-60 BOEING COLOR 707 GRAY GLOSS ENAMEL (SRF-14.9813)

- 1 HOLES IN LINE WITHIN 0.0005
- 2 HOLES IN LINE WITHIN 0.0005
- 3 BUSHINGS MAY BE SHRINK FIT
- 4 FILLET SEAL BUSHINGS WITH BMS 5-95 SEALANT
- 5 OMIT PRIMER AND ENAMEL THIS SURFACE
- 6 113T1213-7 ONLY
- 7 113T1213-8 ONLY
- 8 FLANGE THIS SIDE 113T1213-8 ONLY

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

113T1213-7,-8
Plate Assembly - Repair
Figure 601 (Sheet 2)

27-51-98

REPAIR 2-1
Page 603
Jan 10/86

01.1

MISCELLANEOUS PARTS REFINISH – REPAIR 3-1

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

IPL FIG. & ITEM	MATERIAL	FINISH
<u>Fig. 1</u> Link assy (26)	Al alloy	Chromic acid anodize and apply one coat BMS 10-11 type I primer (F-18.13), plus BMS 10-60 gray gloss enamel (SRF-14.9813). No paint or primer in holes.
Beam assy (260)	Al alloy	Chromic acid anodize and apply one coat BMS10-11 type 1 primer (F-18.13), plus BMS 10-60 gray enamel (SRF-14.9813). No paint or primer in holes.

Refinish Details
Figure 601

27-51-98

REPAIR 3-1

01.1

Page 601

Jul 10/85

ASSEMBLY

1. Assembly

- A. Install bearings (145) on plate assemblies (315, 320) with bolt assembly (105), washers (125), spacers (140), washers (130) and nuts (135A).
- B. Install bearings (100) on plate assemblies (315, 320) with bolt assemblies (55), washers (75), spacers (95), washers (80), washers (85) and nuts (90A).
- C. Install roller bearings (175), on plate assemblies (315, 320) with washers (180) and nuts (185). Lock nuts (185) by bending up a tab of washers (180).
- D. Install support link assembly (26) on track assembly (30) with bolt (5), washer (10), spacer (25), washer (15) and nut (20).
- E. Install plate assemblies (315, 320) on either side of beam assembly (260) with bolts (235, 240), washers (245), washers (250) and nuts (255).

NOTE: Holes in common between plate assemblies (315, 320) and beam assembly (260) to be match bored upon assembly (Fig. 701).
- F. Install bearing (230) and bushings (220, 225) between plate assemblies (315, 320) with bolt assembly (190), washer (205), washer (210) and nut (215). Bend one tab of washer (210) up against a flat of nut (215) to lock nut.
- G. Install bridge (170) and plates (171) between plates (315, 320) with bolts (150), washers (155) and nuts (160).
- H. Slide track assembly (30), small end first, between bearing (230) and bridge (170) on plate assemblies (315, 320). Make sure that the lower flange of the track assembly (30) slides between bearing (230) and roller bearings (175).

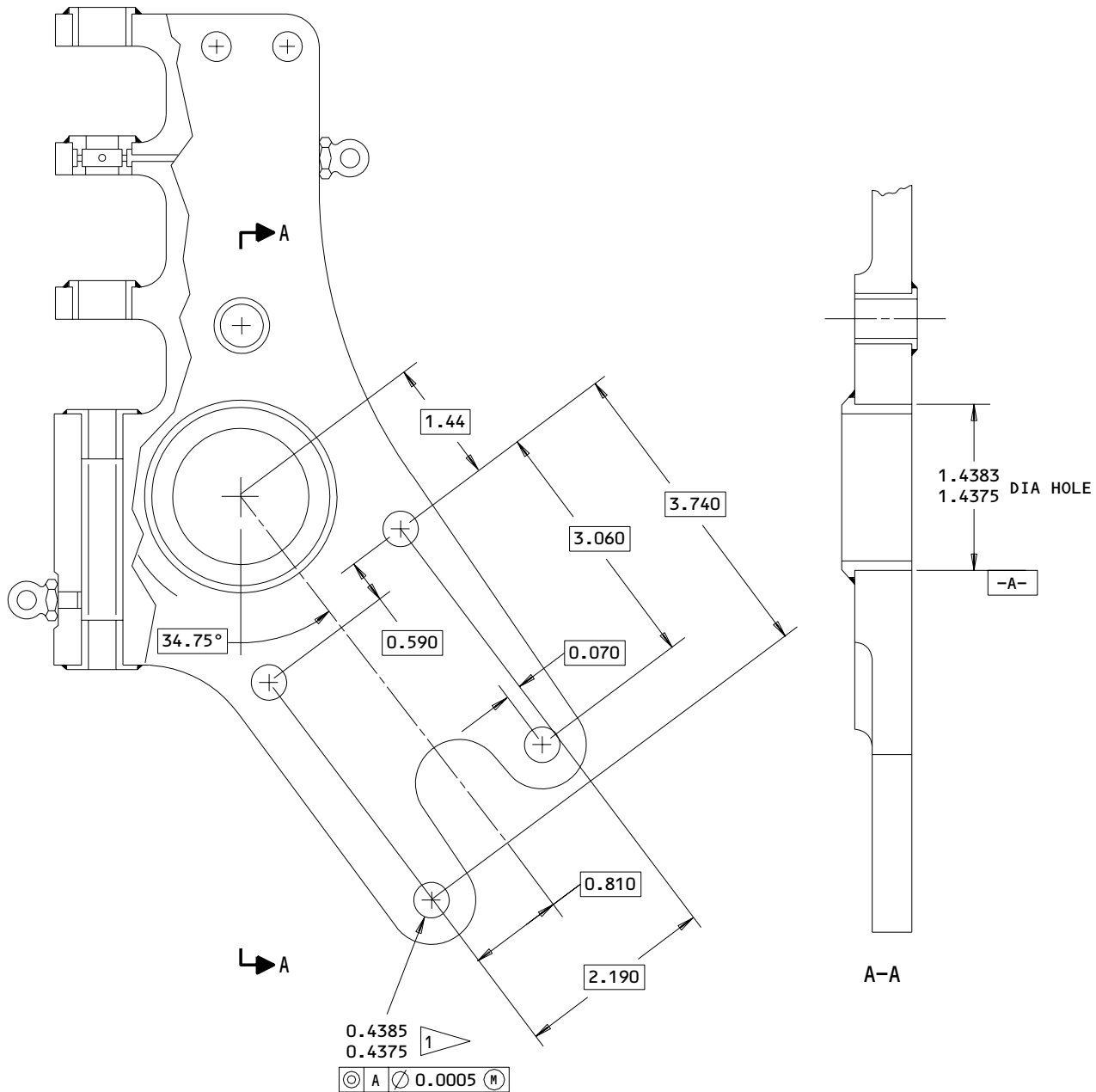
2. Storage

- A. Prepare and store component in accordance with standard industry practices.

27-51-98

ASSEMBLY
Page 701
Jan 01/92

01.1



ALL DIMENSIONS ARE IN INCHES
 ITEM NUMBERS REFER TO IPL FIGURE 1

1 HOLES MATCH BORED WITH HOLES
 IN BEAM ASSEMBLY (260).

113T1213-7,-8
 Plate/Beam Match Boring
 Figure 701

27-51-98

ASSEMBLY
 Page 702
 Jan 01/92

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 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.

27-51-98

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

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

16746 SPECLINE INCORPORATED
11185 TUXFORD STREET
SUN VALLEY, CALIFORNIA 91352-2632

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

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

27-51-98

ILLUSTRATED PARTS LIST
01.1 Page 1002
Apr 01/92

VENDORS

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

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

60380 TORRINGTON CO BEARINGS DIV SUBSIDIARY OF INGERSOLL-RAND CORP
59 FIELD STREET PO BOX 1008
TORRINGTON, CONNECTICUT 06790-4942

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

27-51-98

ILLUSTRATED PARTS LIST
01.1 Page 1003
Apr 01/92

VENDORS

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

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

81376 SOUTHWEST PRODUCTS COMPANY
2240 BUENA VISTA STREET
IRVINDALE, CALIFORNIA 91706

85495 BRILES MFG CO SEE OMARK INDUSTRIES
PRECISION FASTENING SUB OF OMARK IND INC SEE DEUTSCH
FASTENER CORP V08524

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

92555 LEE COMPANY
2 PETTIPAUG ROAD PO BOX 424
WESTBROOK, CONNECTICUT 06498-1543

92563 MCGILL MFG CO INC BEARINGS DIV
909 LAFAYETTE STREET
VALPARAISO, INDIANA 46383-4210

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

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

95879 ALEMITE DIVISION OF STEWART WARNER CORP
1826 DIVERSEY PARKWAY
CHICAGO, ILLINOIS 60614-1540

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

27-51-98

ILLUSTRATED PARTS LIST
01.1 Page 1004
Apr 01/92

VENDORS

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

27-51-98

ILLUSTRATED PARTS LIST
01.1 Page 1005
Apr 01/92

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
AD814V301NC		1	35	1
ATF20		1	230	1
ATL6		1	100	2
		1	145	2
BACB10ET20		1	230	1
BACB10EU06		1	100	2
		1	145	2
BACB10FB14GC		1	35	1
BACB1010FB14GC		1	27	2
BACB28AK06-057		1	95	2
		1	140	2
BACB28AK14-051		1	25	1
BACB28AK20-031		1	225	1
BACB28AK20-145		1	220	1
BACB28AM09B037A		1	325	4
BACB28AM19B021A		1	40	1
BACB28AM27B068A		1	345	1
BACB28AP06P060		1	330	4
BACB28AP08P068		1	340	2
BACB28AP14P018		1	45	1
BACB28AP20P068		1	350	1
BACB30LR3PU8		1	270	6
BACB30MY10K10		1	295	5
BACB30MY10K4		1	296	18
BACB30MY10K6		1	297	14
BACB30NM5K54		1	150	2
BACB30NM7K53		1	240	2
BACB30NM7K59		1	235	2
BACC30M10		1	300	37
BACN10JC5		1	165	2
BACN10JC6CD		1	90A	2
		1	135A	2
BACN10JC8		1	185	2
BACP20AX15A		1	60	2
		1	110	2
BACP20AX15AP		1	65	2
		1	115	2
BACW10BP14CD		1	10	1
BACW10BP14DP		1	15	1
BACW10BP20CD		1	205	1
BACW10BP5CD		1	155	2
BACW10BP5DP		1	160	2
BACW10BP6AP		1	80	2
BACW10BP6CD		1	75	2
BACW10BP7AC		1	245	4
BACW10BP7AP		1	250	4

27-51-98

 ILLUSTRATED PARTS LIST
 01.1 Page 1006
 Apr 01/92

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BLP16F243		1	290B	1
BMN4122AD3-8		1	185	2
BMN4122A8		1	185	2
BRH10A5		1	165	2
BRH10C6D		1	90A	2
		1	135A	2
B30MY10K10		1	295	5
B30MY10K4		1	296	18
B30MY10K6		1	297	14
CF2582		1	175	2
HL10VAZ10-10		1	295	5
HL10VAZ10-4		1	296	18
HL10VAZ10-6		1	297	14
HL79-10		1	300	37
HTFB14VC		1	35	1
H10-5BAC		1	165	2
H10-8BAC		1	185	2
H51650-6BAC		1	90A	2
		1	135A	2
KNDB14-70		1	35	1
LHCB16BA		1	290B	1
L80010K10		1	295	5
L80010K4		1	296	18
L80010K6		1	297	14
MS15001-1		1	265	1
MS15001-4		1	365	4
MS27111-3		1	85	2
		1	130	2
MS27111-5		1	180	2
NAS1804-14		1	20	1
NAS1804-7		1	255	4
NRRS14FBGC		1	35	1
PLGA1874020		1	65	2
		1	115	2
PLGA1875020		1	60	2
		1	110	2
RMLH9074-8		1	185	2
RMLH9075-5W		1	165	2
T6S524J		1	165	2
WES14GC		1	35	1
113T1167-1		1	260A	1
113T1167-11		1	275A	1
113T1167-12		1	280A	1
113T1167-3		1	305A	1
113T1167-4		1	310A	1
113T1212-1		1	260	1

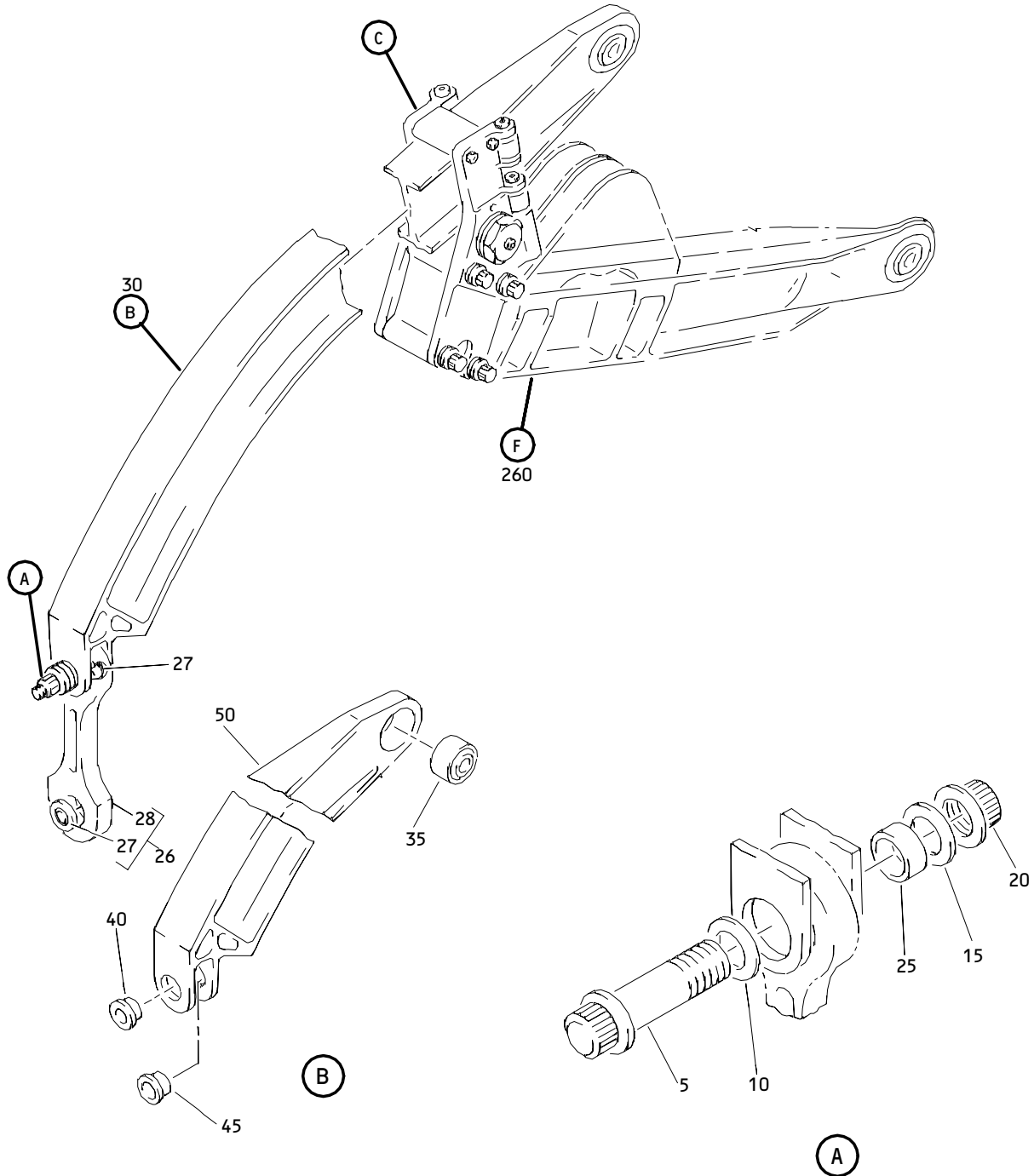
27-51-98

ILLUSTRATED PARTS LIST
01.1 Page 1007
Apr 01/92

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
113T1212-3		1	305	1
113T1212-4		1	310	1
113T1213-10		1	360	1
113T1213-11		1	170	1
113T1213-12		1	171	2
113T1213-7		1	315	1
113T1213-8		1	320	1
113T1213-9		1	355	1
113T1230-1		1	30	1
113T1230-2		1	50	1
113T1230-3		1	30A	1
113T1230-4		1	50A	1
113T1230-5		1	30B	1
113T1254-34		1	210	1
113T1256-28		1	285	2
113T1262-16		1	215	1
113T1264-21		1	190	1
113T1264-22		1	200	1
113T1264-28		1	5	1
113T1264-33		1	105	2
113T1264-34		1	120	2
113T1264-35		1	55	2
113T1264-36		1	70	2
113T1267-11		1	275	1
113T1267-12		1	280	1
113T1294-1		1	26	1
113T1294-2		1	28	1
113T1347-107		1	335	2
113T1347-110		1	330A	4
113T2000-103		1	1D	RF
113T2000-61		1	1	RF
113T2000-71		1	1A	RF
113T2000-89		1	1B	RF
113T2000-90		1	1C	RF
1684B		1	195	1
20AFC2040		1	230	1
48FT820		1	185	2
6AL1618		1	100	2
		1	145	2
60B00178-651		1	175	2
60B00180-243		1	290B	1
96-054		1	165	2

27-51-98

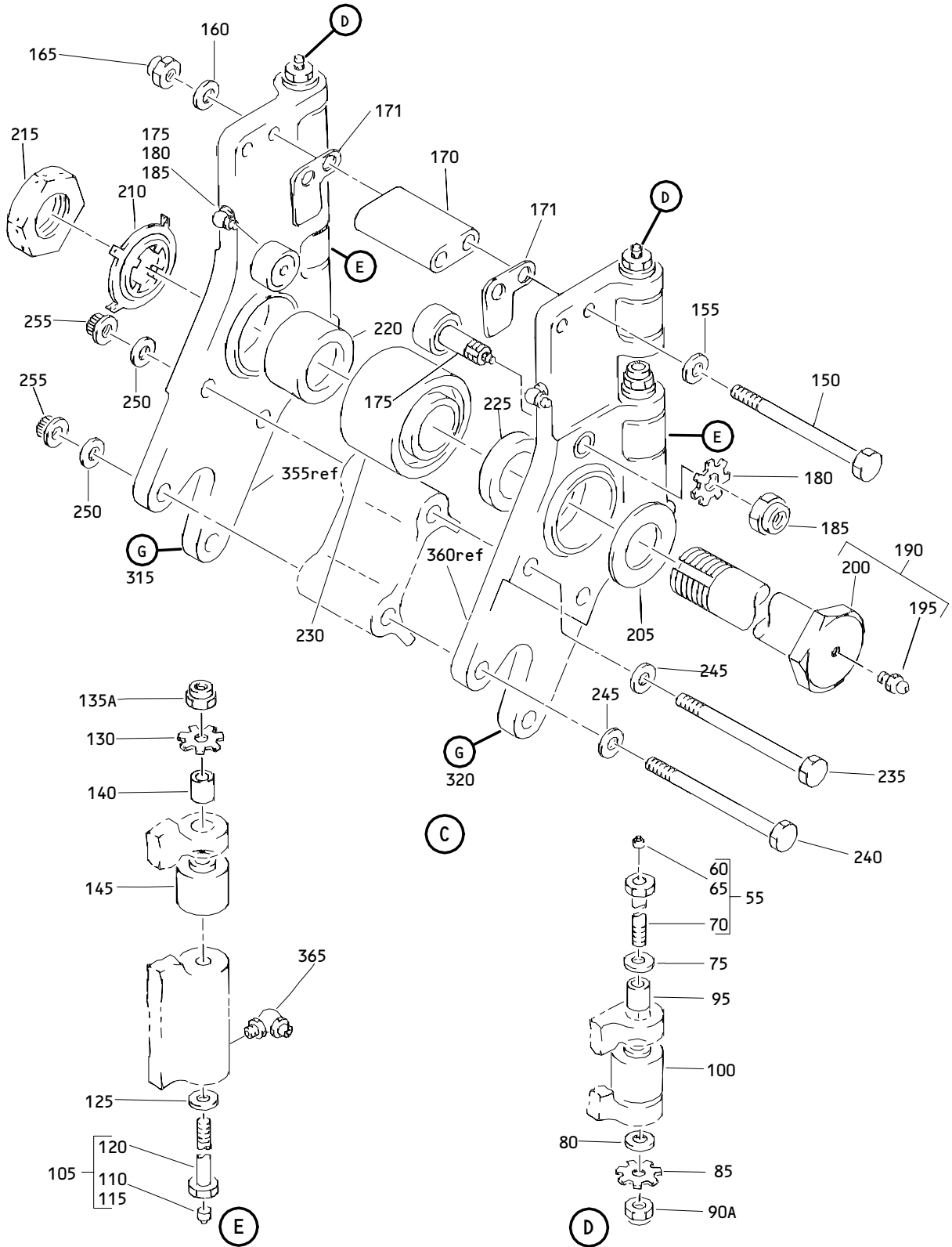
 ILLUSTRATED PARTS LIST
 01.1 Page 1008
 Apr 01/92



Inboard Trailing Edge Flap Track Beam Assembly
 Figure 1 (Sheet 1)

27-51-98

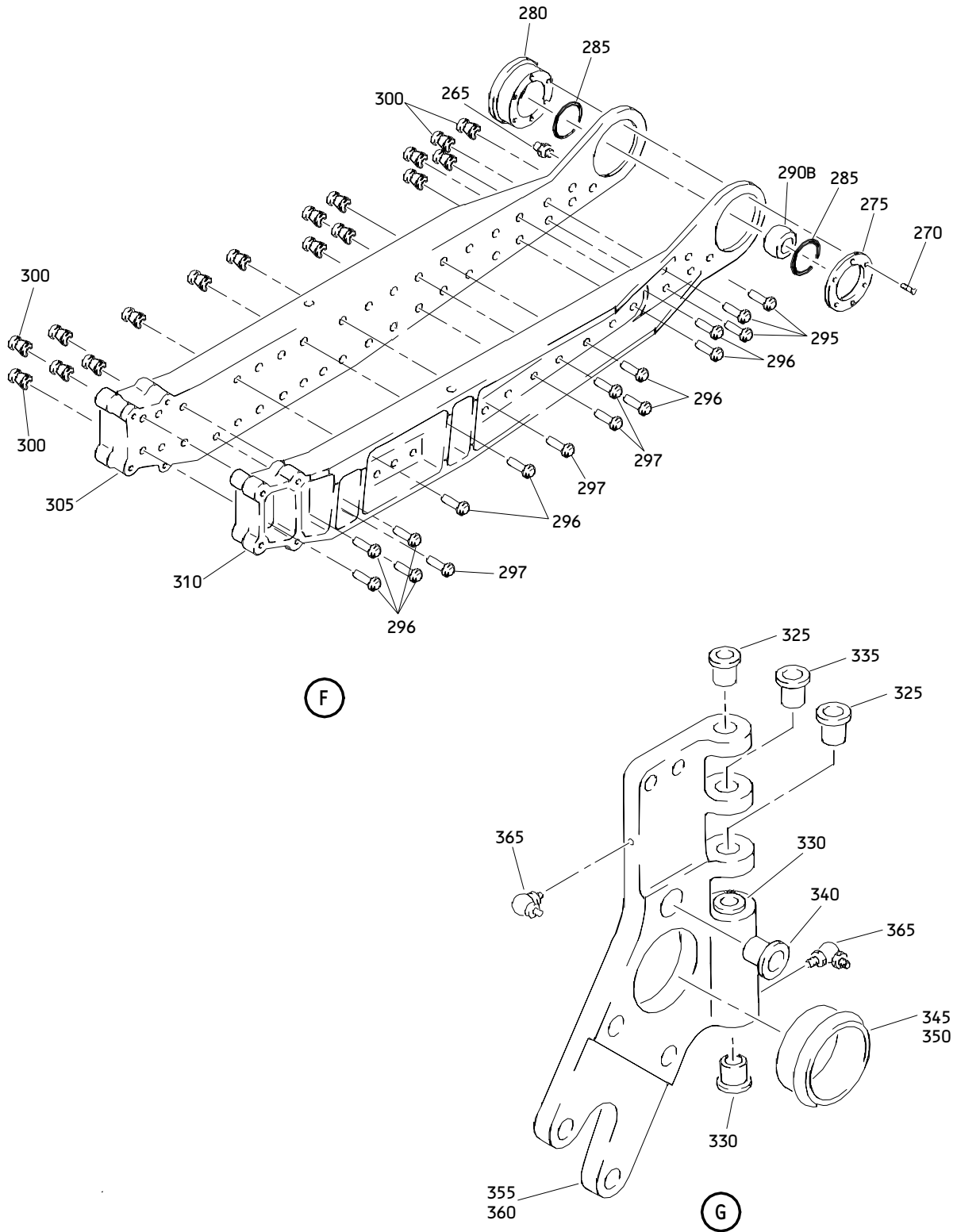
ILLUSTRATED PARTS LIST
 01.1 Page 1010
 Apr 01/92



Inboard Trailing Edge Flap Track Beam Assembly
Figure 1 (Sheet 2)

27-51-98

ILLUSTRATED PARTS LIST
01.1 Page 1011
Apr 01/92



**Inboard Trailing Edge Flap Track Beam Assembly
 Figure 1 (Sheet 3)**

27-51-98

**ILLUSTRATED PARTS LIST
 01.1 Page 1012
 Apr 01/92**

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01- -1	113T2000-61		TRACK BEAM ASSY-INBD TE FLAP	A	RF
-1A	113T2000-71		TRACK BEAM ASSY-INBD TE FLAP	B	RF
-1B	113T2000-89		TRACK BEAM ASSY-INBD TE FLAP	C	RF
-1C	113T2000-90		TRACK BEAM ASSY-INBD TE FLAP	D	RF
-1D	113T2000-103		TRACK BEAM ASSY-INBD TE FLAP (VARIABLE)	E	RF
5	113T1264-28		.BOLT		1
10	BACW10BP14CD		.WASHER- (V10630) (SPEC BACW10BP14CD)		1
15	BACW10BP14DP		.WASHER- (V10630) (SPEC BACW10BP14DP)		1
20	NAS1804-14		.NUT		1
25	BACB28AK14-051		.BUSHING- (V23294) (SPEC BACB28AK14-051) (OPT BACB28AK14-051 (V70265)) (OPT BACB28AK14-051 (V94892))		1
26	113T1294-1		.LINK ASSY-SUPT TRACK		1
27	BACB1010FB14GC		..BEARING		2
28	113T1294-2		..LINK		1
30	113T1230-1		.TRACK ASSY- (PRE SB 767-27-0080)	A,B	1
-30A	113T1230-3		.TRACK ASSY	C,D	1
-30B	113T1230-5		.TRACK ASSY-(VARIABLE) (PRE SB 767-27-0080)	E	1
-30C	113T1230-3		.TRACK ASSY- (POST SB 767-27-0080)	A,B,E	1

27-51-98

ILLUSTRATED PARTS LIST
01.1 Page 1013
Apr 01/92

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-35	AD814V301NC		..BEARING- (V15860) (SPEC BACB10FB14GC) (OPT HTFB14VC (V50294)) (OPT KNDB14-70 (V97613)) (OPT KSC145700BZ14GC (V50632)) (OPT NRRS14FBGC (V73134)) (OPT WES14GC (V73134))		1
40	BACB28AM19B021A		..BUSHING- (V23294) (SPEC BACB28AM19B021A) (OPT BACB28AM19B021A (V70265)) (OPT BACB28AM19B021A (V94892))		1
45	BACB28AP14P018		..BUSHING- (V23294) (SPEC BACB28AP14P018) (OPT BACB28AP14P018 (V70265)) (OPT BACB28AP14P018 (V94892))		1
50	113T1230-2		..TRACK- (USED ON ITEMS 30, 30B)	A,B,E	1
-50A	113T1230-4		..TRACK	C,D	1
-50B	113T1230-4		..TRACK- (USED ON ITEM 30C)	A,B,E	1

27-51-98

 ILLUSTRATED PARTS LIST
 01.1 Page 1014
 Apr 01/92

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-55	113T1264-35		.BOLT ASSY		2
60	PLGA1875020		..PIN- (V92555) (SPEC BACP20AX15A)		1
65	PLGA1874020		..PIN- (V92555) (SPEC BACP20AX15AP)		1
70	113T1264-36		..BOLT		1
75	BACW10BP6CD		.WASHER- (V10630) (SPEC BACW10BP6CD)		2
80	BACW10BP6AP		.WASHER- (V10630) (SPEC BACW10BP6AP)		2
85	MS27111-3		.WASHER		2
90	H10-6BAC		DELETED		
90A	BRH10C6D		.NUT- (V52828) (SPEC BACN10JC6CD) (OPT H51650-6BAC (V15653))		2
95	BACB28AK06-057		.BUSHING- (V23294) (SPEC BACB28AK06-057) (OPT BACB28AK06-057 (V70265)) (OPT BACB28AK06-057 (V94892))		2
100	ATL6		.BEARING- (V60380) (SPEC BACB10EU06) (OPT 6AL1618 (V92563))		2

27-51-98

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
105	113T1264-33		.BOLT ASSY		2
110	PLGA1875020		..PIN- (V92555) (SPEC BACP20AX15A)		1
115	PLGA1874020		..PIN- (V92555) (SPEC BACP20AX15AP)		1
120	113T1264-34		..BOLT		1
125	BACW10BP6CD		.WASHER- (V10630) (SPEC BACW10BP6CD)		2
130	MS27111-3		.WASHER		2
135	H10-6BAC		DELETED		
135A	BRH10C6D		.NUT- (V52828) (SPEC BACN10JC6CD) (OPT H51650-6BAC (V15653))		2
140	BACB28AK06-057		.BUSHING- (V23294) (SPEC BACB28AK06-057) (OPT BACB28AK06-057 (V70265)) (OPT BACB28AK06-057 (V94892))		2
145	ATL6		.BEARING- (V60380) (SPEC BACB10EU06) (OPT 6AL1618 (V92563))		2
150	BACB30NM5K54		.BOLT		2
155	BACW10BP5CD		.WASHER- (V10630) (SPEC BACW10BP5CD)		2
160	BACW10BP5DP		.WASHER- (V10630) (SPEC BACW10BP5DP)		2

27-51-98

 ILLUSTRATED PARTS LIST
 01.1 Page 1016
 Apr 01/92

 **BOEING**
COMPONENT
MAINTENANCE MANUAL

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-165	H10-5BAC		.NUT- (V15653) (SPEC BACN10JC5) (OPT RMLH9075-5W (V72962)) (OPT T6S524J (V71087)) (OPT 96-054 (V80539)) (OPT BRH10A5 (V52828))		2
170	113T1213-11		.BRIDGE		1
171	113T1213-12		.PLATE		2
175	CF2582		.BEARING-ROLLER (V92563) (SPEC 60B00178-651)		2
180	MS27111-5		.WASHER		2
185	H10-8BAC		.NUT- (V15653) (SPEC BACN10JC8) (OPT BMN4122A8 (V85495)) (OPT RMLH9074-8 (V72962)) (OPT 48FT820 (V56878)) (OPT BMN4122AD3-8 (V08524)) (OPT BMN4122AD3-8 (V97928))		2
190	113T1264-21		.BOLT ASSY		1
195	1684B		..FITTING-LUBE (V95879)		1
200	113T1264-22		..BOLT		1
205	BACW10BP20CD		.WASHER- (V10630) (SPEC BACW10BP20CD)		1

27-51-98

ILLUSTRATED PARTS LIST
01.1 Page 1017
Apr 01/92

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
210	113T1254-34		.WASHER		1
215	113T1262-16		.NUT		1
220	BACB28AK20-145		.BUSHING- (V23294) (SPEC BACB28AK20-145) (OPT BACB28AK20-145 (V70265)) (OPT BACB28AK20-145 (V94892))		1
225	BACB28AK20-031		.BUSHING- (V23294) (SPEC BACB28AK20-031) (OPT BACB28AK20-031 (V70265)) (OPT BACB28AK20-031 (V94892))		1
230	20AFC2040		.BEARING- (V92563) (SPEC BACB10ET20) (OPT ATF20 (V60380))		1
235	BACB30NM7K59		.BOLT- (V06710) (SPEC BACB30NM7K59) (OPT BACB30NM7K59 (V06725)) (OPT BACB30NM7K59 (V08524)) (OPT BACB30NM7K59 (V27624)) (OPT BACB30NM7K59 (V56878)) (OPT BACB30NM7K59 (V73197)) (OPT BACB30NM7K59 (V80539)) (OPT BACB30NM7K59 (V92215)) (OPT BACB30NM7K59 (V93907)) (OPT BACB30NM7K59 (V97928))		2

27-51-98

 ILLUSTRATED PARTS LIST
 01.1 Page 1018
 Apr 01/92

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-240	BACB30NM7K53		.BOLT- (V06710) (SPEC BACB30NM7K53) (OPT BACB30NM7K53 (V06725)) (OPT BACB30NM7K53 (V08524)) (OPT BACB30NM7K53 (V27624)) (OPT BACB30NM7K53 (V56878)) (OPT BACB30NM7K53 (V73197)) (OPT BACB30NM7K53 (V80539)) (OPT BACB30NM7K53 (V92215)) (OPT BACB30NM7K53 (V93907)) (OPT BACB30NM7K53 (V97928))		2
245	BACW10BP7AC		.WASHER- (V10630) (SPEC BACW10BP7AC)		4
250	BACW10BP7AP		.WASHER- (V10630) (SPEC BACW10BP7AP)		4
255	NAS1804-7		.NUT		4
260	113T1212-1		.BEAM ASSY-SPRT	A,C	1

27-51-98

ILLUSTRATED PARTS LIST
01.1 Page 1019
Apr 01/92

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-260A	113T1167-1		.BEAM ASSY-SPRT	B,D,E	1
-261	113T1167-1		DELETED		
265	MS15001-1		..FITTING-LUBE		1
270	BACB30LR3PU8		..BOLT- (V06710) (SPEC BACB30LR3PU8) (OPT BACB30LR3PU8 (V06725)) (OPT BACB30LR3PU8 (V06950)) (OPT BACB30LR3PU8 (V08524)) (OPT BACB30LR3PU8 (V17943)) (OPT BACB30LR3PU8 (V27624)) (OPT BACB30LR3PU8 (V80539)) (OPT BACB30LR3PU8 (V92215)) (OPT BACB30LR3PU8 (V97928))		6
275	113T1267-11		..RETAINER-BRG	A,C	1
-275A	113T1167-11		..RETAINER-BRG	B,D,E	1
-276	113T1167-11		DELETED		
280	113T1267-12		..RETAINER-BRG	A,C	1
-280A	113T1167-12		..RETAINER-BRG	B,D,E	1
-281	113T1167-12		DELETED		
285	113T1256-28		..SEAL		2
290	ABS16-101		DELETED		
290A	BLN16-2021		DELETED		
290B	BLP16F243		..BEARING- (V16746) (SPEC 60B00180-243) (OPT ABS16-101 (V50294)) (OPT LHC16BA (V73134)) (OPT BLN16-2021 (V81376))		1

27-51-98

 ILLUSTRATED PARTS LIST
 01.1 Page 1020
 Apr 01/92

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-295	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))		5
296	HL10VAZ10-4		..BOLT- (V56878) (SPEC BACB30MY10K4) (OPT B30MY10K4 (V97928)) (OPT HL10VAZ10-4 (V73197)) (OPT HL10VAZ10-4 (V92215)) (OPT HL10VAZ10-4 (V97928)) (OPT L80010K4 (V06725)) (OPT HL10VAZ10-4 (V08524))		18

27-51-98

ILLUSTRATED PARTS LIST
01.1 Page 1021
Apr 01/92

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-297	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))		14
300	HL79-10		..COLLAR- (V56878) (SPEC BACC30M10) (OPT HL79-10 (V73197)) (OPT HL79-10 (V92215)) (OPT 66014-10 (V56878))		37
305	113T1212-3		..BEAM	A,C	1
-305A	113T1167-3		..BEAM	B,D,E	1
-306	113T1167-3		DELETED		
310	113T1212-4		..BEAM	A,C	1
-310A	113T1167-4		..BEAM	B,D,E	1
-311	113T1167-4		DELETED		
315	113T1213-7		.PLATE ASSY		1
320	113T1213-8		.PLATE ASSY		1
325	BACB28AM09B037A		..BUSHING- (V23294) (SPEC BACB28AM09B037A) (OPT BACB28AM09B037A (V70265)) (OPT BACB28AM09B037A (V94892))		2
330	BACB28AP06P060		..BUSHING- (OPT ITEM 330A)		2
-330A	113T1347-110		..BUSHING- (OPT ITEM 330)		2
335	113T1347-107		..BUSHING		1

27-51-98

 ILLUSTRATED PARTS LIST
 01.1 Page 1022
 Apr 01/92

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-340	BACB28AP08P068		..BUSHING- (V23294) (SPEC BACB28AP08P068) (OPT BACB28AP08P068 (V70265)) (OPT BACB28AP08P068 (V94892))		1
345	BACB28AM27B068A		..BUSHING- (V23294) (SPEC BACB28AM27B068A) (OPT BACB28AM27B068A (V70265)) (OPT BACB28AM27B068A (V94892)) (USED ON ITEM 315)		1
350	BACB28AP20P068		..BUSHING- (V23294) (SPEC BACB28AP20P068) (OPT BACB28AP20P068 (V70265)) (OPT BACB28AP20P068 (V94892)) (USED ON ITEM 320)		1
355	113T1213-9		..PLATE (USED ON ITEM 315)		1
360	113T1213-10		..PLATE (USED ON ITEM 320)		1
365	MS15001-4		..FITTING-LUBE		2

27-51-98

ILLUSTRATED PARTS LIST
01.1 Page 1023
Apr 01/92