INBOARD TRAILING EDGE FLAP SUPPORT NO. 3 LINKAGE ASSEMBLY

PART NUMBERS 113T1202-1,-2

COMPONENT MAINTENANCE MANUAL
WITH
ILLUSTRATED PARTS LIST

K86768

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

K85759

TEMPORARY REVISION AND SERVICE BULLETIN RECORD

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVE	DATE OF INCORPORATION INTO MANUAL

PAGE	DATE	CODE
27-52-86		
TITLE PAGE		
*1	MAR 01/00	01
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REVISION RECORD		
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TR & SB RECORD		
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LIST OF EFFECTIVE PAGES		
*1	MAR 01/00	01
THRU LAST PAGE		
CONTENTS		
*1	MAR 01/00	01
*2	BLANK	
INTRODUCTION		
*1	MAR 01/00	01
*2	BLANK	
DESCRIPTION & OPERATION		
*1	MAR 01/00	01
*2	MAR 01/00	01
DISASSEMBLY		
*301	MAR 01/00	01
*302	BLANK	
CLEANING		
*401	MAR 01/00	01
*402	BLANK	
CHECK		
*501	MAR 01/00	01
*502	MAR 01/00	01

PAGE	DATE	CODE
REPAIR-GENERAL		
*601	MAR 01/00	01
*602	MAR 01/00	01
REPAIR 1-1		
*601	MAR 01/00	01
*602	MAR 01/00	01
REPAIR 2-1		
*601	MAR 01/00	01
*602	MAR 01/00	01
*603	MAR 01/00	01
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REPAIR 2-2		
*601	MAR 01/00	01
*602	MAR 01/00	01
*603	MAR 01/00	01
*604	MAR 01/00	01
*605	MAR 01/00	01
*606	MAR 01/00	01
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*608	MAR 01/00	01
*609	MAR 01/00	01
*610	MAR 01/00	01
REPAIR 3-1		
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*602	MAR 01/00	01
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REPAIR 3-2		
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*602	MAR 01/00	01
*603	MAR 01/00	01
*604	MAR 01/00	01
*605	MAR 01/00	01
*606	MAR 01/00	01

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PAGE	DATE	CODE
REPAIR 3-2		CONT.
*607	MAR 01/00	01
*608	MAR 01/00	01
*609	MAR 01/00	01
*610	MAR 01/00	01
REPAIR 4-1		
*601	MAR 01/00	01
*602	MAR 01/00	01
*603	MAR 01/00	01
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REPAIR 5-1		
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*606	MAR 01/00	01
REPAIR 6-2		
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*602	MAR 01/00	01
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*605	MAR 01/00	01
*606	MAR 01/00	01
*607	MAR 01/00	01
*608	MAR 01/00	01
*609	MAR 01/00	01
*610	MAR 01/00	01
REPAIR 7-1		
*601	MAR 01/00	01
*602	MAR 01/00	01
*603	MAR 01/00	01
*604	MAR 01/00	01

PAGE	DATE	CODE
REPAIR 8-1		
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*603	MAR 01/00	01
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REPAIR 8-2		
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*602	MAR 01/00	01
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ASSEMBLY		
*701	MAR 01/00	01
*702	MAR 01/00	01
*703	MAR 01/00	01
*704	MAR 01/00	01
*705	MAR 01/00	01
*706	MAR 01/00	01
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FITS AND CLEARANCES		
*801	MAR 01/00	01
*802	MAR 01/00	01
*803	MAR 01/00	01
*804	MAR 01/00	01
*805	MAR 01/00	01
*806	MAR 01/00	01
*807	MAR 01/00	01
*808	MAR 01/00	01
*809	MAR 01/00	01
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* = REVISED, ADDED OR DELETED

PAGE	DATE	CODE
ILLUSTRATED PARTS LIST		
*1001	MAR 01/00	01
*1002	MAR 01/00	01
*1003	MAR 01/00	01
*1004	MAR 01/00	01
*1005	MAR 01/00	01
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*1007	MAR 01/00	01
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*1012	MAR 01/00	01
*1013	MAR 01/00	01
*1014	MAR 01/00	01
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*1016	MAR 01/00	01
*1017	MAR 01/00	01
*1018	MAR 01/00	01
*1019	MAR 01/00	01
*1020	MAR 01/00	01
*1021	MAR 01/00	01
*1022	MAR 01/00	01
*1023	MAR 01/00	01
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*1026	MAR 01/00	01
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*1028	MAR 01/00	01
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*1034	MAR 01/00	01
*1035	MAR 01/00	01
*1036	MAR 01/00	01
*1037	MAR 01/00	01
*1038	MAR 01/00	01
*1039	MAR 01/00	01
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PAGE	DATE	CODE

* = REVISED, ADDED OR DELETED

TABLE OF CONTENTS

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INTRODUCTION

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

This manual is divided into separate sections:

1. Title Page
2. Record of Revisions
3. Temporary Revision & Service Bulletin Record
4. List of Effective Pages
5. Table of Contents
6. Introduction
7. Procedures & IPL Sections

Refer to the Table of Contents for the page location of applicable sections.

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:

INBOARD TRAILING EDGE FLAP SUPPORT NO. 3 LINKAGE ASSEMBLY

DESCRIPTION AND OPERATION

1. Description

   A. The inboard trailing edge flap support No. 3 linkage assembly is made of fail-safe aluminum link and beam assemblies which are connected by pins. The linkage assembly is mounted to the left wing structure and holds the inboard trailing edge flap at its outboard position.

      NOTE: The flap support No. 6 linkage assembly is opposite to the No. 3 assembly. All references to the No. 3 linkage assembly apply to the No. 6 assembly, unless shown differently.

   B. In the procedures in this manual, the inboard trailing edge flap support No. 3 linkage assembly will be referred to as the linkage assembly.

2. Operation

   A. The trailing edge flap drive rotary actuators operate to extend the linkage assemblies and the flaps mounted to them.

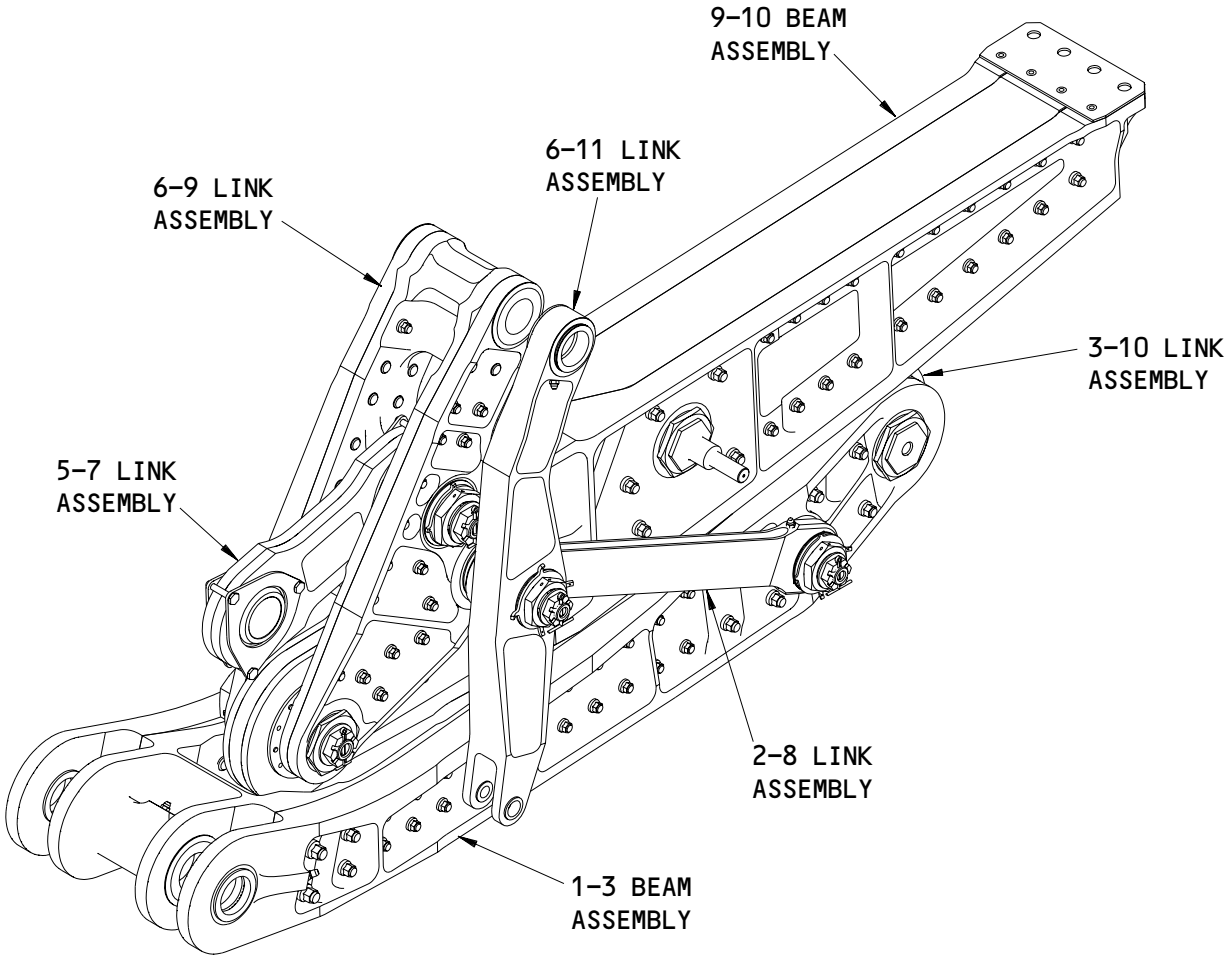
3. Leading Particulars (Approximate)

   A. Length -- 48 inches

   B. Width -- 12 inches

   C. Height -- 20 inches

   D. Weight -- 180 pounds



Inboard Trailing Edge Flap Support No. 3 Linkage Assembly
Figure 1

K86574

DISASSEMBLY

1. General

   A. This procedure has the data necessary to disassemble the linkage assembly.

   B. Disassemble this component sufficiently to isolate the defects, do the necessary repairs, and put the component back to a serviceable condition.

   C. Refer to the Standard Overhaul Practices Manual (SOPM) for details of the SOPM chapters identified in this procedure.

   D. Refer to IPL Fig. 1 for the item numbers.

2. Disassembly

   A. Parts Replacement

      NOTE: The parts which follow are recommended for replacement. Unless a procedure tells you to replace a part, replacement is optional.

      (1) Seal (475, 670)

      (2) Cotter pin (10, 110, 155, 410, 495)

   B. Procedure

      (1) Use standard industry procedures to disassemble this component.

         NOTE: Do not disassemble the link assemblies (50, 55, 370, 445, 530) or the beam assemblies (195, 605) unless it is necessary for repair or replacement.

         Refer to the manufacturer's instructions for the overhaul procedures for the 2-8 link assembly (150).

CLEANING

1. General

   A. This procedure has the data necessary to clean the linkage assembly.

   B. Refer to the Standard Overhaul Practices Manual (SOPM) for details of the SOPM chapters identified in this procedure.

   C. Refer to IPL Fig. 1 for the item numbers.

2. Cleaning

   A. References

      (1) SOPM 20-30-03, General Cleaning Procedures

   B. Procedure

      (1) Refer to the manufacturer's instructions to clean the bearings (380 (380, 455, 630, 665).

      (2) Use standard industry procedures and refer to SOPM 20-30-03 to clean the other parts.

CHECK

1. General

   A. This procedure has the data necessary to find defects in the material of the specified parts.

   B. Refer to FITS AND CLEARANCES for the design dimension and wear limits.

   C. Refer to the Standard Overhaul Practices Manual (SOPM) for details of the SOPM chapters identified in this procedure.

   D. Refer to IPL Fig. 1 for the item numbers.

2. Check

   A. References

      (1) SOPM 20-20-01, Magnetic Particle Inspection

      (2) SOPM 20-20-02, Penetrant Methods of Inspection

   B. Procedure

      (1) Use standard industry procedures to do a visual check of all the parts for defects. Do the penetrant or magnetic particle check if the visual check shows possible damage or if you suspect possible damage on the parts listed below:

      (2) Do a magnetic particle check (SOPM 20-20-01) of these parts:

         (a) Special washer (390)

         (b) Special nut (25, 125, 170, 345, 425)

         (c) Retainer (470, 655)

         (d) Outer pin (45, 145, 190, 365, 440, 525)

         (e) Bushing (85, 225, 395, 550, 565, 615, 625)

      (3) Do a penetrant check (SOPM 20-20-02) of these parts:

         (a) Special washer (30, 130, 175, 350, 430, 520)

         (b) Inner pin (40, 140, 185, 360, 435, 510)

(c) Link (100, 105)

(d) Outer strap (305, 310), inner beam (315)

(e) Link half (490)

(f) Side link (590, 595), center link (600)

(g) Outer plate (730, 735), inner beam (740)

REPAIR - GENERAL

1. General

A. Instructions for repair, refinish, and replacement of the specified subassembly parts are included in each REPAIR when applicable:

PART NUMBER	NAME	REPAIR
---	REFINISH OF OTHER PARTS	1-1
113T1221	LINK, 6-9	2-1, 2-2
113T1222	BEAM, 1-3	3-1, 3-2
113T1223	LINK, 3-10	4-1
113T1224	LINK, 5-7	5-1
113T1226	BEAM, 9-10	6-1, 6-2
113T1263	PIN, OUTER	7-1
113T2066	LINK, 6-11	8-1, 8-2

2. Dimensioning Symbols

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

—	STRAIGHTNESS
▱	FLATNESS
⊥	PERPENDICULARITY (OR SQUARENESS)
//	PARALLELISM
○	ROUNDNESS
⌭	CYLINDRICITY
⌒	PROFILE OF A LINE
⌓	PROFILE OF A SURFACE
◎	CONCENTRICITY
⌯	SYMMETRY
∠	ANGULARITY
↗	RUNOUT
↗↗	TOTAL RUNOUT
⌴	COUNTERBORE OR SPOTFACE
⌵	COUNTERSINK
⌖	THEORETICAL EXACT POSITION OF A FEATURE (TRUE POSITION)
∅	DIAMETER
S ∅	SPHERICAL DIAMETER
R	RADIUS
SR	SPHERICAL RADIUS
()	REFERENCE
BASIC (BSC) OR [DIM]	A THEORETICALLY EXACT DIMENSION USED TO DESCRIBE SIZE, SHAPE OR LOCATION OF A FEATURE. FROM THIS FEATURE PERMISSIBLE VARIATIONS ARE ESTABLISHED BY TOLERANCES ON OTHER DIMENSIONS OR NOTES.
[-A-]	DATUM
Ⓜ	MAXIMUM MATERIAL CONDITION (MMC)
Ⓛ	LEAST MATERIAL CONDITION (LMC)
Ⓢ	REGARDLESS OF FEATURE SIZE (RFS)
Ⓟ	PROJECTED TOLERANCE ZONE
FIM	FULL INDICATOR MOVEMENT

EXAMPLES

— | 0.002	STRAIGHT WITHIN 0.002
⊥ | 0.002 | B	PERPENDICULAR TO DATUM B WITHIN 0.002
// | 0.002 | A	PARALLEL TO DATUM A WITHIN 0.002
○ | 0.002	ROUND WITHIN 0.002
⌭ | 0.010	CYLINDRICAL SURFACE MUST LIE BETWEEN TWO CONCENTRIC CYLINDERS, ONE OF WHICH HAS A RADIUS 0.010 INCH GREATER THAN THE OTHER
⌒ | 0.006 | A	EACH LINE ELEMENT OF THE SURFACE AT ANY CROSS SECTION MUST LIE BETWEEN TWO PROFILE BOUNDARIES 0.006 INCH APART RELATIVE TO DATUM A
⌓ | 0.020 | A	SURFACES MUST LIE WITHIN PARALLEL BOUNDARIES 0.020 INCH APART AND EQUALLY DISPOSED ABOUT TRUE PROFILE
◎ | ∅ 0.0005 | C	CONCENTRIC TO DATUM C WITHIN 0.0005 DIAMETER
⌯ | 0.010 | A	SYMMETRICAL WITH DATUM A WITHIN 0.010
∠ | 0.005 | A	ANGULAR TOLERANCE 0.005 WITH DATUM A
⌖ | ∅ 0.002 Ⓢ | B	LOCATED AT TRUE POSITION WITHIN 0.002 DIA RELATIVE TO DATUM B, REGARDLESS OF FEATURE SIZE
⊥ | ∅ 0.010 Ⓜ | A 0.510 Ⓟ	AXIS IS TOTALLY WITHIN A CYLINDER OF 0.010 INCH DIAMETER, PERPENDICULAR TO DATUM A, AND EXTENDING 0.510 INCH ABOVE DATUM A, MAXIMUM MATERIAL CONDITION
[2.000] OR 2.000 BSC	THEORETICALLY EXACT DIMENSION IS 2.000

True Position Dimensioning Symbols
Figure 601

K85791

REFINISH OF OTHER PARTS - REPAIR 1-1

1. General

   A. This procedure has the data necessary to refinish the parts which are not given in the specified repairs.

   B. Refer to the Standard Overhaul Practices Manual (SOPM) for details of the SOPM chapters identified in this procedure.

   C. Refer to IPL Fig. 1 for the item numbers.

2. Refinish of Other Parts

   A. General

      (1) Instructions for the repair of the parts listed in Table 601 are for repair of the initial finish.

   B. Consumable Materials

      NOTE: Equivalent material can be used.

      (1) C00259 Primer - BMS 10-11, Type 1 (SOPM 20-60-02)

   C. References

      (1) SOPM 20-30-02, Stripping of Protective Finishes

      (2) SOPM 20-30-03, General Cleaning Procedures

      (3) SOPM 20-41-01, Decoding Table for Boeing Finish Codes

      (4) SOPM 20-41-02, Application of Chemical and Solvent Resistant Finishes

      (5) SOPM 20-42-05, Bright Cadmium Plating

      (6) SOPM 20-43-01, Chromic Acid Anodizing

      (7) SOPM 20-60-02, Finishing Materials

   D. Procedure

IPL FIG. & ITEM	MATERIAL	FINISH
IPL Fig. 1		
Special washer (20, 120,165,340,390, 420,430,505)	15-5PH CRES, 180-200 ksi	Passivate (F-17.25, which replaces F-17.09).
Special nut (25, 125,170,345,425)	15-5PH CRES, 180-200 ksi	Apply BMS 3-8 dry film lubricant on the threads and external surfaces.
Special washer (30, 130,175,350,520)	15-5PH CRES, 180-200 ksi	Chrome plate (F-15.03), 0.0005-0.0010 inch thick. Plating is optional on the ID and the OD.
Plate (465), retainer (470)	15-5PH CRES, 180-200 ksi	Cadmium plate (F-15.06) and apply BMS 10-11, type 1 primer (F-20.02).
Plate (465A,465B, 655), retainer (470A,470B,660)	15-5PH CRES, 180-200 ksi	Cadmium plate (F-15.06).

Refinish Details
Table 601

6-9 LINK ASSEMBLY - REPAIR 2-1

113T1221-51

1. General

   A. This procedure has the data necessary to repair and refinish the 6-9 link assembly (530).

   B. Refer to the Standard Overhaul Practices Manual (SOPM) for details of the SOPM chapters identified in this procedure.

   C. Refer to the REPAIR - GENERAL (27-52-86/601, REPAIR - GENERAL) for the Standard True Position Dimensioning Symbols shown in the repair.

   D. Refer to IPL Fig. 1 for the item numbers.

   E. In the procedures that follow, the group of parts that include the links (590, 595, 600) and the applicable fasteners is referred to as the link (no assigned part number).

2. Bushing Replacement

   A. Consumable Materials

      NOTE: Equivalent material can be used.

      (1) A00359 Sealant -- BMS 5-95 (SOPM 20-60-04)

   B. References

      (1) SOPM 20-50-03, Bearing and Bushing Replacement

      (2) SOPM 20-60-04, Miscellaneous Materials

   C. Procedure

      NOTE: The co-axial bushings must be replaced in full sets so that the machined bushing bores will be aligned.

      (1) Remove the bushings (540, 545, 550, 555, 560, 565) from the link.

      (2) Install the new bushings with sealant. Use the shrink-fit procedure. Refer to SOPM 20-50-03.

      (3) Machine the bushing bores to the dimensions shown in Fig. 601.

(4) Fillet seal the bushing flanges with sealant.

3. Lube Fitting Replacement

A. Consumable Materials

NOTE: Equivalent material can be used.

(1) D00633 Grease -- BMS 3-33 (SOPM 20-60-03)

B. References

(1) SOPM 20-60-03, Lubricants

C. Procedure (Fig. 601)

(1) Remove the lube fitting (535).

(2) Apply grease to the threads of the replacement lube fitting. Install the lube fitting and tighten it to 25-30 pounds of torque.

(3) Apply grease to the lube fitting until you can see the grease flow, to make sure that the lube passage is clean.

4. Link Assembly (530) Refinish

A. Consumable Materials

NOTE: Equivalent material can be used.

(1) C00032 Enamel -- BMS 10-60, Type 1 (SOPM 20-60-02)

(2) C00259 Primer -- BMS 10-11, Type 1 (SOPM 20-60-02)

B. References

(1) SOPM 20-30-02, Stripping of Protective Finishes

(2) SOPM 20-41-01, Decoding Table For Boeing Finish Codes

(3) SOPM 20-41-02, Application of Chemical and Solvent Resistant Finishes

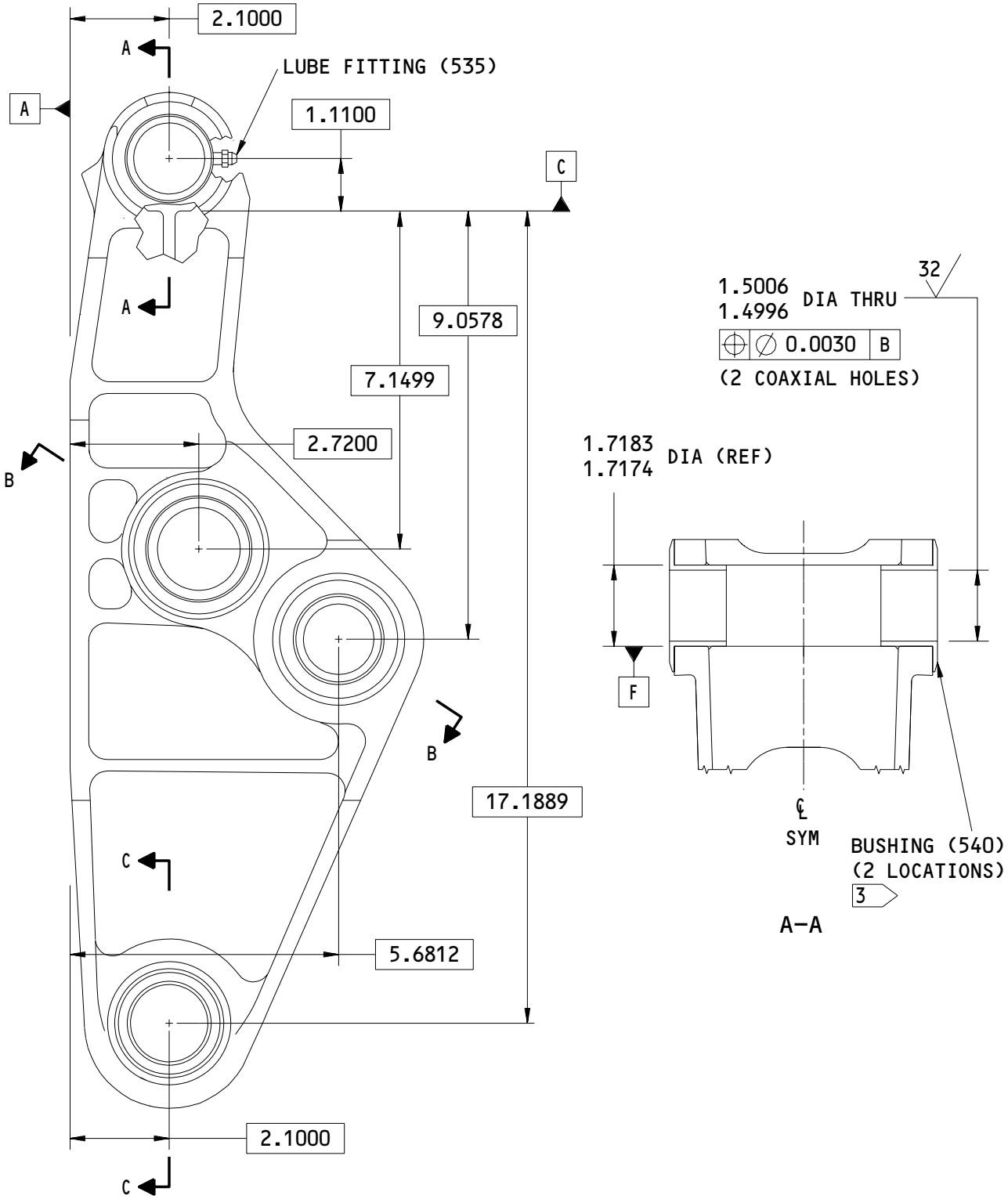
(4) SOPM 20-43-03, Chemical Conversion Coatings for Aluminum

(5) SOPM 20-60-02, Finishing Materials

C. Procedure (Fig. 601)

(1) Chemical treat (F-17.10) bare machined surfaces, as necessary.

(2) Apply BMS 10-11, type 1 primer (F-14.995, which replaces SRF-14.995), then apply BMS 10-60 enamel (F-14.9813, which replaces SRF-14.9813). Do not apply primer or enamel on the bushing flanges, bushing bores, the lube fitting (535), or the lubrication holes.



113T1221-51
6-9 Link Assembly Repair
Figure 601 (Sheet 1)

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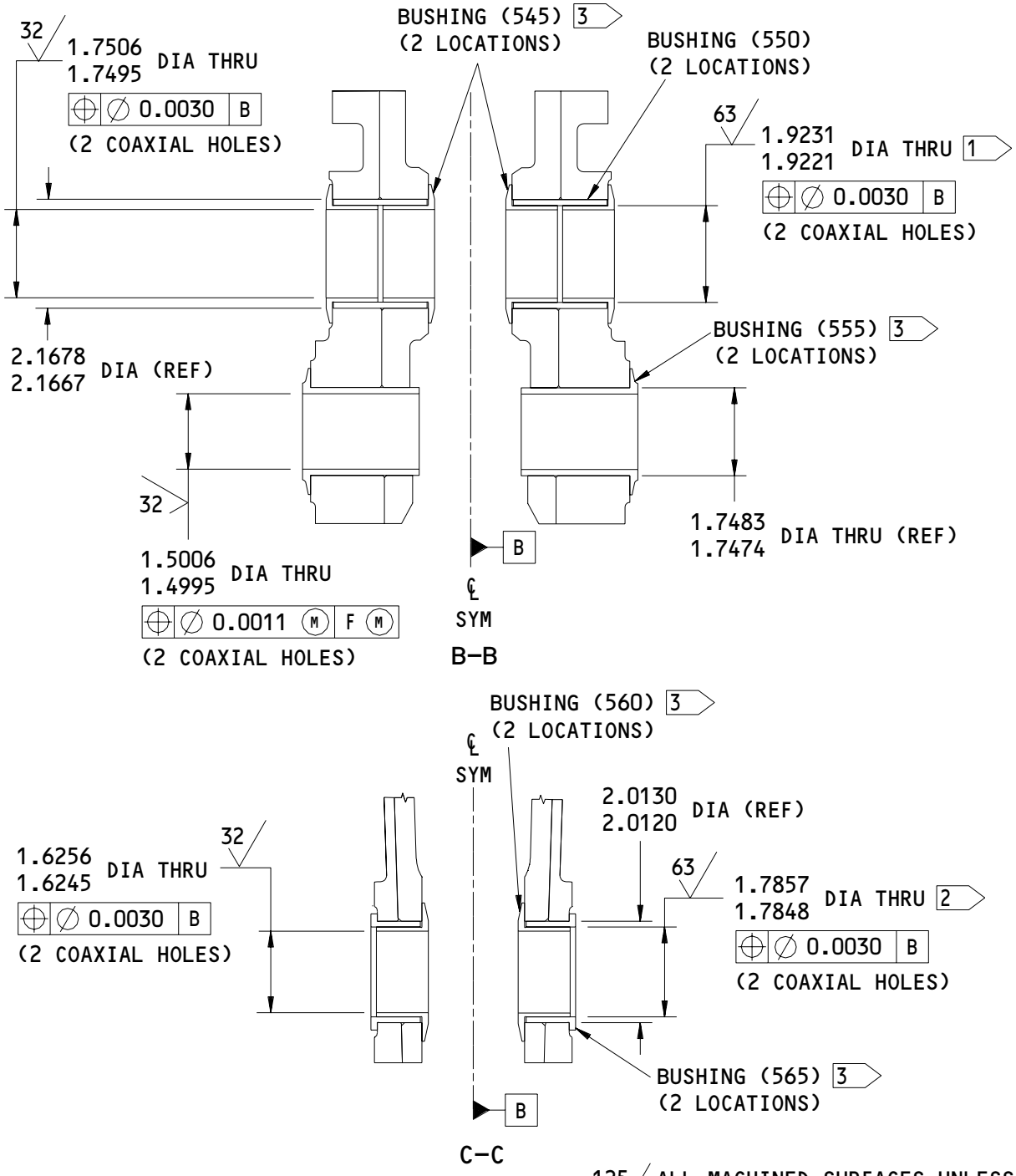


1 INNER DIAMETER OF BUSHING (550)

2 INNER DIAMETER OF BUSHING (565)

3 FILLET SEAL THE BUSHING FLANGE

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

113T1221-51
6-9 Link Assembly Repair
Figure 601 (Sheet 2)

L03438

6-9 LINK ASSEMBLY - REPAIR 2-2

113T1221-51

1. General

A. This procedure has the data necessary to repair and refinish the 6-9 link (no assigned part number). The link refers to the group of parts that includes the links (590, 595, 600) and the applicable fasteners.

B. Refer to the Standard Overhaul Practices Manual (SOPM) for details of the SOPM chapters identified in this procedure.

C. Refer to the REPAIR - GENERAL (27-52-86/601, REPAIR - GENERAL) for the Standard True Position Dimensioning Symbols shown in the repair.

D. Refer to IPL Fig. 1 for the item numbers.

E. General repair details:

(1)	Material:	Aluminum alloy
(2)	Shot peen:	All repaired surfaces Shot size: Refer to SOPM 20-10-03 Intensity 0.012A Coverage 2.0

2. Bushing Hole Repair

A. References

(1) SOPM 20-10-03, Shot Peening

(2) SOPM 20-20-01, Magnetic Particle Inspection

(3) SOPM 20-20-02, Penetrant Methods of Inspection

(4) SOPM 20-41-01, Decoding Table for Boeing Finish Codes

(5) SOPM 20-42-05, Bright Cadmium Plating

(6) SOPM 20-43-03, Chemical Conversion Coatings for Aluminum

B. Procedure

(1) Machine the link as necessary to remove defects. Do not machine the bushing hole more than the repair limit shown in Fig. 601.

NOTE: Do not remove the fasteners or disassemble the link. Machine the link as a unit.

(2) Break all sharp edges 0.03-0.05 inch.

(3) Do a penetrant check of the machined surfaces. Refer to SOPM 20-20-02.

(4) Shot peen the machined area. Refer to SOPM 20-10-03.

(5) Chemical treat (F-17.10) the machined surface.

(6) Make the oversized bushing. Refer to Fig. 602.

(a) Bushing material:

1) Bushing (540, 555) -- Al-Ni-Bronze, AMS 4640 (AMS 4880 optional for bushing (540) only)

2) Bushing (550, 565) -- 15-5PH CRES, 180-200 ksi

(b) Break all sharp edges.

(c) Do a magnetic particle check of the oversized bushing (550, 565). Refer to SOPM 20-20-01.

(d) Cadmium plate (F-15.06) the oversized bushing (540, 550, 555, 565) on the surfaces shown on Fig. 603. Plating is optional on the other surfaces.

(7) Install the oversized bushing as shown in Repair 2-1.

3. Link Refinish

A. Consumable Materials

NOTE: Equivalent material can be used.

(1) C00259 Primer -- BMS 10-11, Type 1 (SOPM 20-60-02)

B. References

(1) SOPM 20-30-02, Stripping of Protective Finishes

(2) SOPM 20-41-01, Decoding Table For Boeing Finish Codes

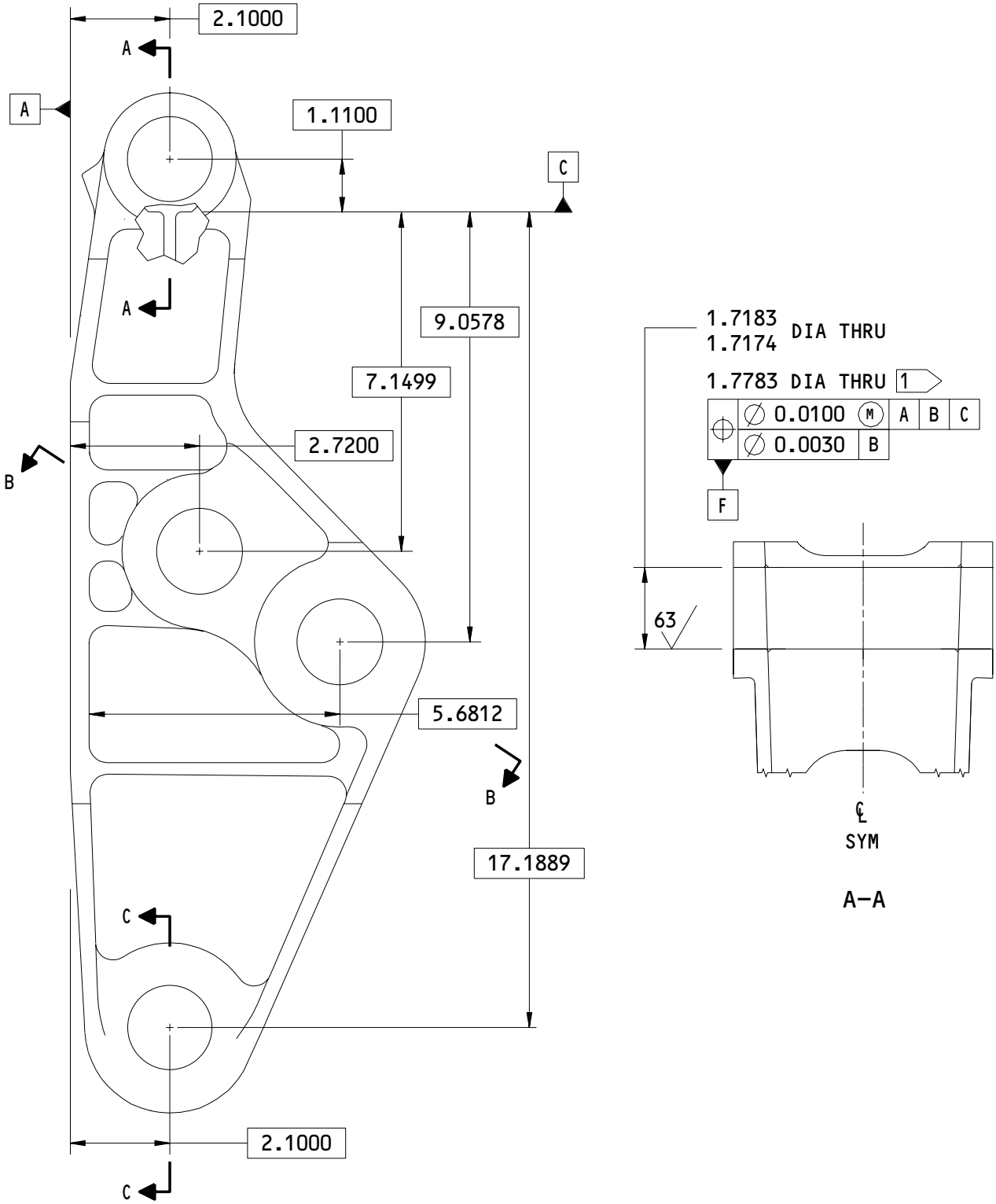
(3) SOPM 20-41-02, Application of Chemical and Solvent Resistant Finishes

(4) SOPM 20-43-01, Chromic Acid Anodizing

(5) SOPM 20-60-02, Finishing Materials

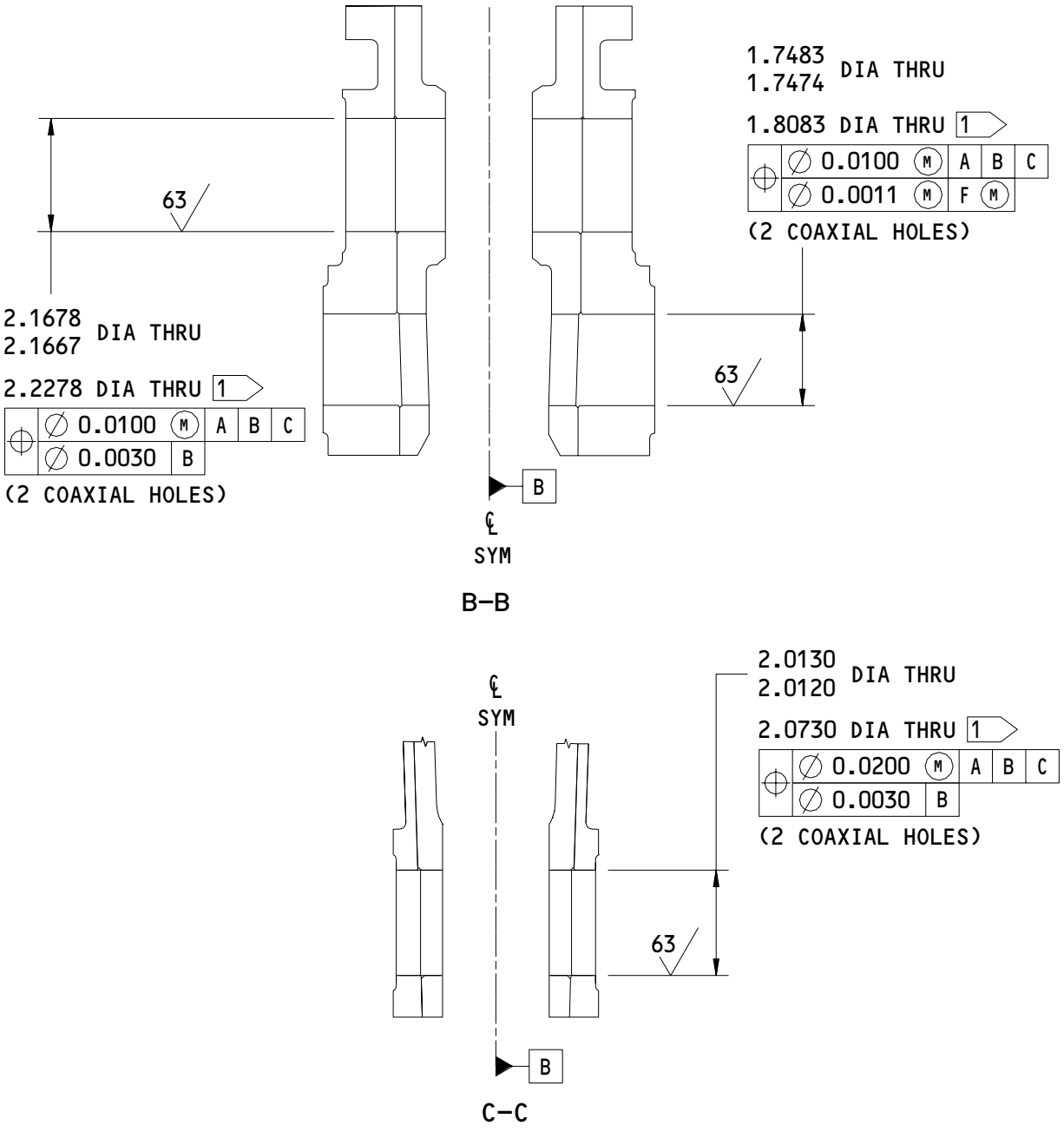
C. Procedure (Fig. 601)

(1) Link -- Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply BMS 10-11, type 1 primer (F-20.02), but not on the bushing holes.



113T1221-51
6-9 Link Repair
Figure 601 (Sheet 1)

L03540



1 REPAIR LIMIT

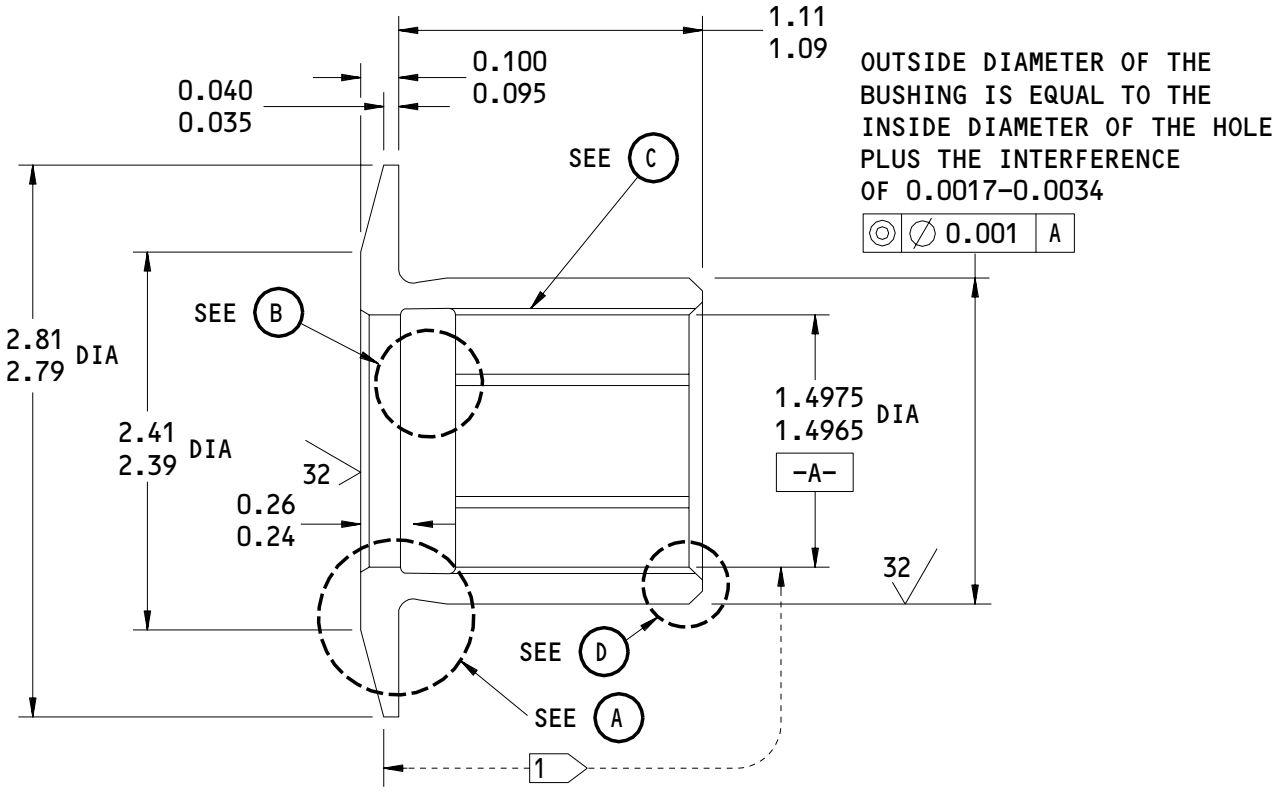
125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

ITEM NUMBERS REFER TO IPL FIG. 1

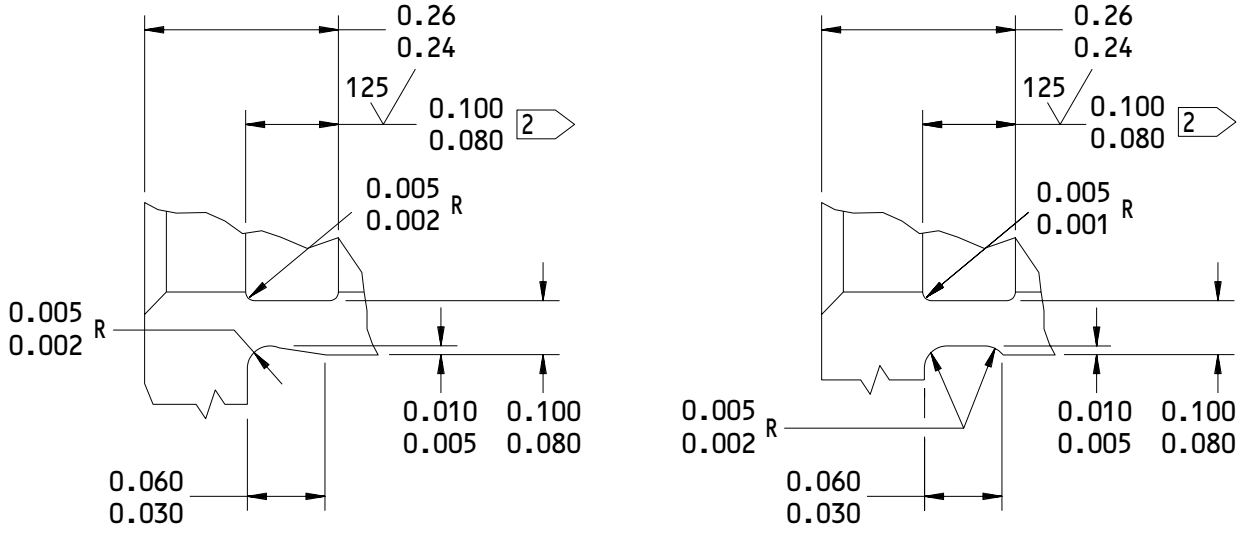
ALL DIMENSIONS ARE IN INCHES

113T1221-51
6-9 Link Assembly Repair
Figure 601 (Sheet 2)

L03547



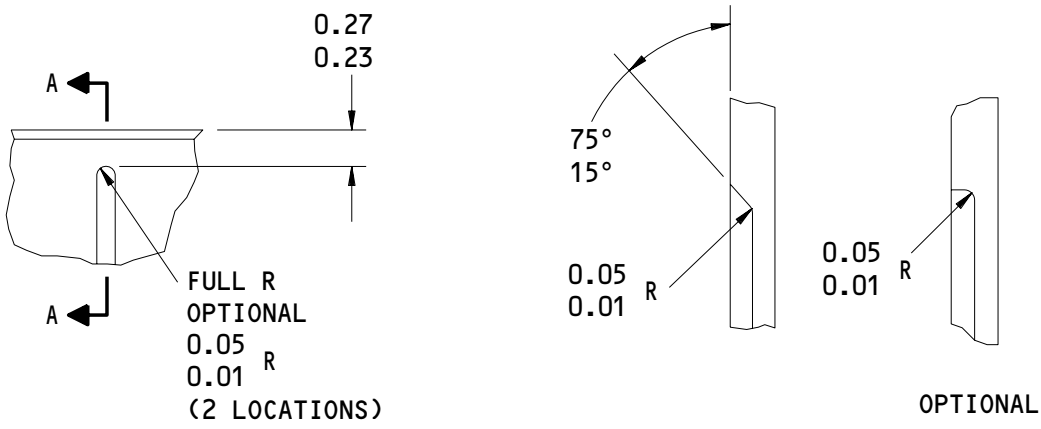
OVERSIZE REPLACEMENT FOR BUSHING (540)



A

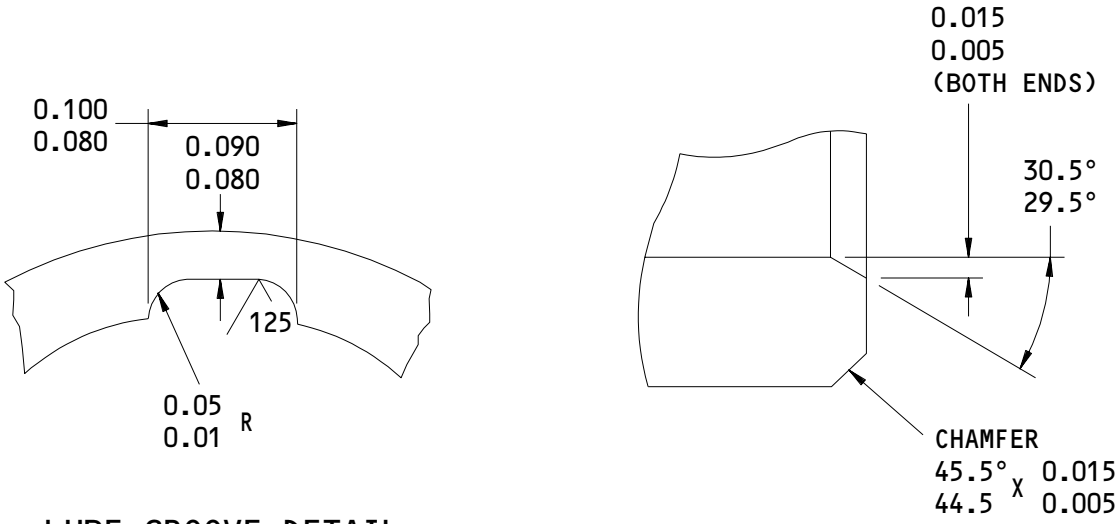
Oversize Bushing Details
Figure 602 (Sheet 1)

L03563



LUBE GROOVE TERMINATION

B



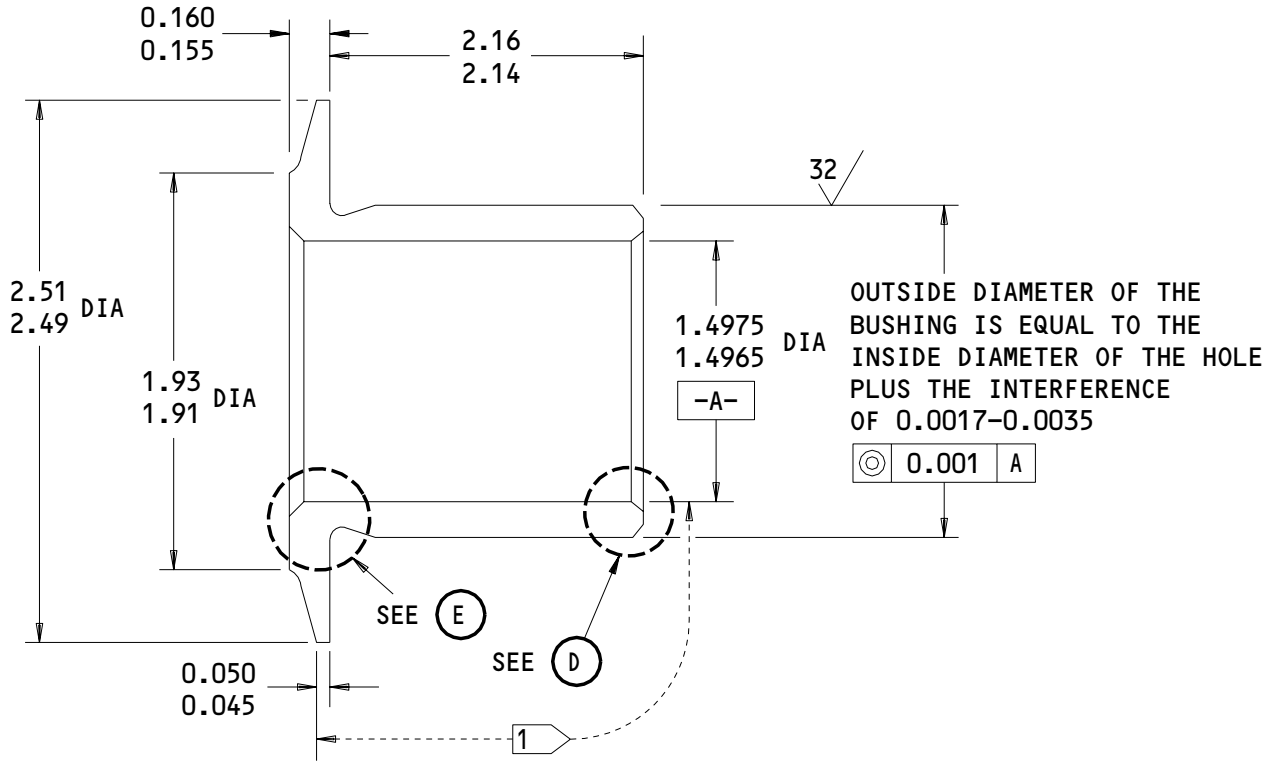
LUBE GROOVE DETAIL
6 GROOVES EQUALLY SPACED ON INNER FACE

C

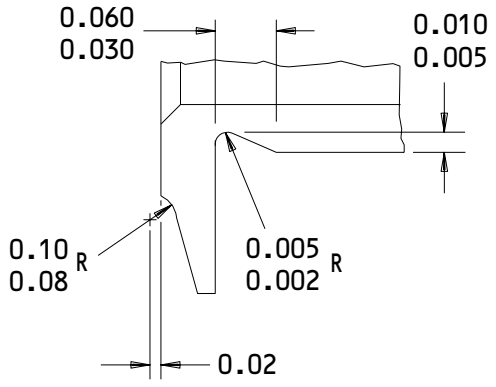
D

Oversize Bushing Details
Figure 602 (Sheet 2)

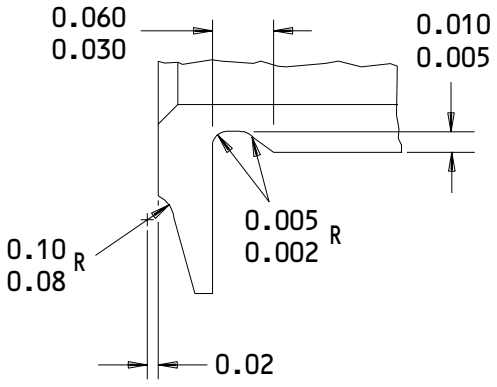
L03567



OVERSIZE REPLACEMENT FOR BUSHING (555)



TYPE 1

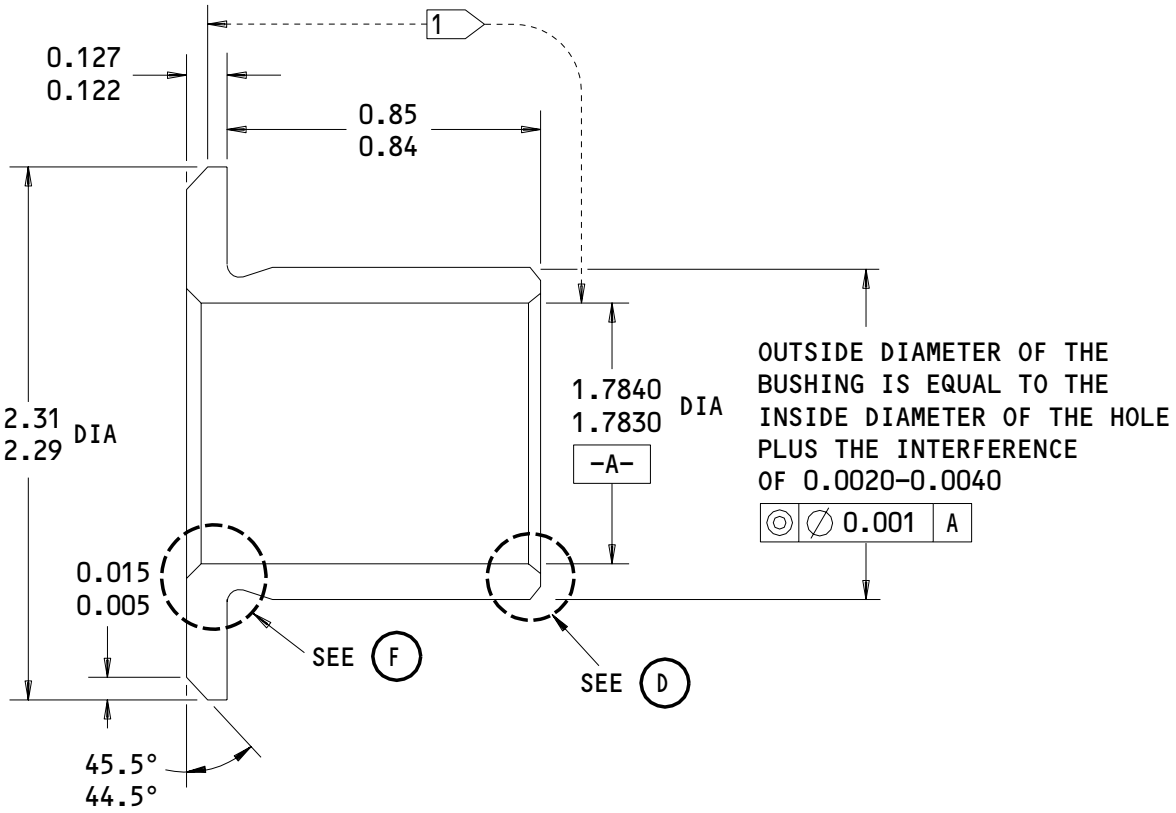


TYPE 2

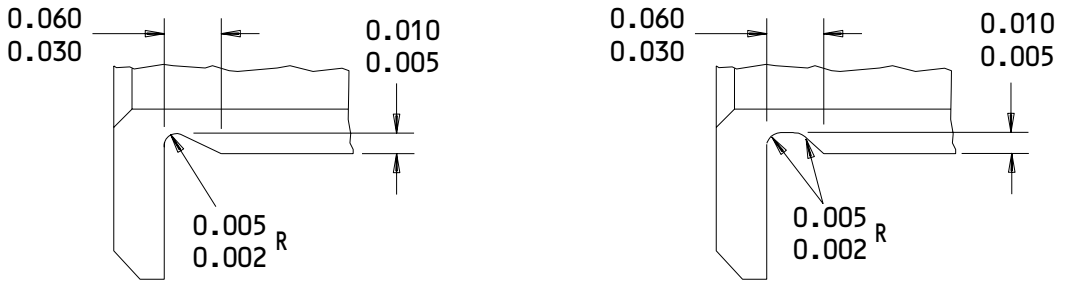
E

Oversize Bushing Details
Figure 602 (Sheet 3)

L03576



OVERSIZE REPLACEMENT FOR BUSHING (565)



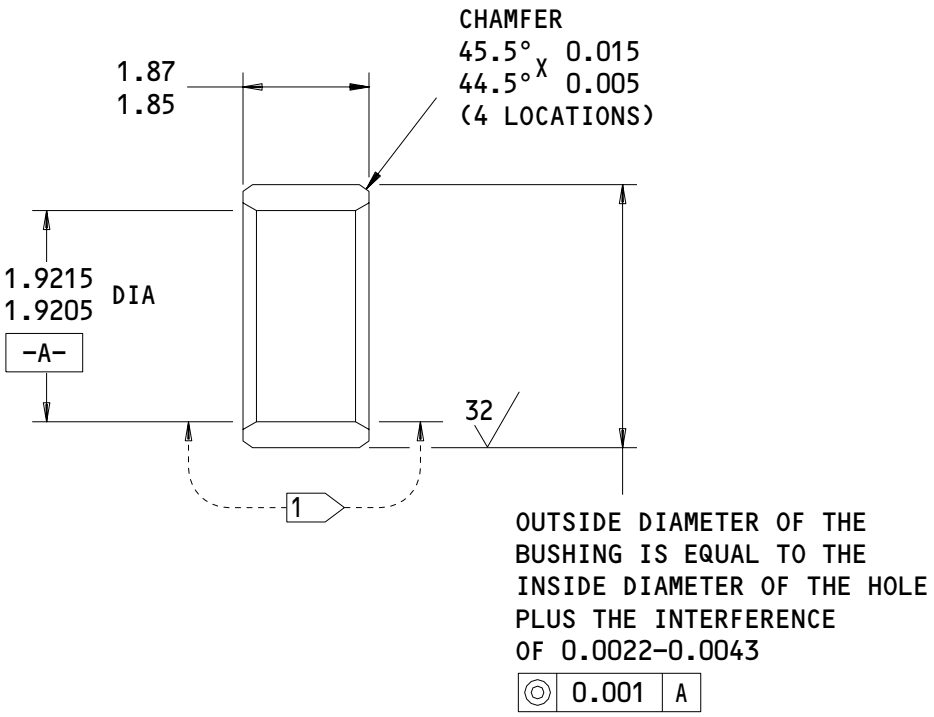
TYPE 1

TYPE 2

F

Oversize Bushing Details
Figure 602 (Sheet 4)

L03580



OVERSIZE REPLACEMENT FOR BUSHING (550)

1 CADMIUM PLATE THESE SURFACES. PLATING IS OPTIONAL ON ALL OTHER SURFACES

2 OPTIONAL CIRCUMFERENTIAL LUBE GROOVE

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

DIMENSIONS APPLY AFTER PLATING

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

Oversize Bushing Details
Figure 602 (Sheet 5)

L03599

1-3 BEAM ASSEMBLY - REPAIR 3-1

113T1222-41

1. General

A. This procedure has the data necessary to repair and refinish the 1-3 beam assembly (195).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for details of the SOPM chapters identified in this procedure.

C. Refer to the REPAIR - GENERAL (27-52-86/601, REPAIR - GENERAL) for the Standard True Position Dimensioning Symbols shown in the repair.

D. Refer to IPL Fig. 1 for the item numbers.

E. In the procedures that follow, the group of parts that include the inner beam (315), outer straps (305, 310), and the applicable fasteners is referred to as the beam.

2. Bushing Replacement

A. Consumable Materials

NOTE: Equivalent material can be used.

(1) A00359 Sealant -- BMS 5-95 (SOPM 20-60-04)

B. References

(1) SOPM 20-50-03, Bearing and Bushing Replacement

(2) SOPM 20-60-04, Miscellaneous Materials

C. Procedure

NOTE: The co-axial bushings must be replaced in full sets so that the machined bushing bores will be aligned.

(1) Remove the bushings (210, 215, 220, 225, 230) from the beam.

(2) Install the new bushings with sealant. Use the shrink-fit procedure. Refer to SOPM 20-50-03.

(3) Machine the bushing bores to the dimensions shown in Fig. 601.

(4) Machine a 0.02-0.03 inch x 44-46 degree chamfer on the ends of the bushing bores, as shown in Fig. 601.

3. Lube Fitting Replacement

A. Consumable Materials

NOTE: Equivalent material can be used.

(1) D00633 Grease -- BMS 3-33 (SOPM 20-60-03)

B. References

(1) SOPM 20-60-03, Lubricants

C. Procedure (Fig. 601)

(1) Remove the lube fitting (200, 205).

(2) Apply grease to the threads of the replacement lube fitting. Install the lube fitting and tighten it to 25-30 pounds of torque.

(3) Apply grease to the lube fitting until you can see the grease flow, to make sure that the lube passage is clean.

4. Beam Assembly (195) Refinish

A. Consumable Materials

NOTE: Equivalent material can be used.

(1) C00032 Enamel -- BMS 10-60, Type 1 (SOPM 20-60-02)

(2) C00259 Primer -- BMS 10-11, Type 1 (SOPM 20-60-02)

B. References

(1) SOPM 20-30-02, Stripping of Protective Finishes

(2) SOPM 20-41-01, Decoding Table For Boeing Finish Codes

(3) SOPM 20-41-02, Application of Chemical and Solvent Resistant Finishes

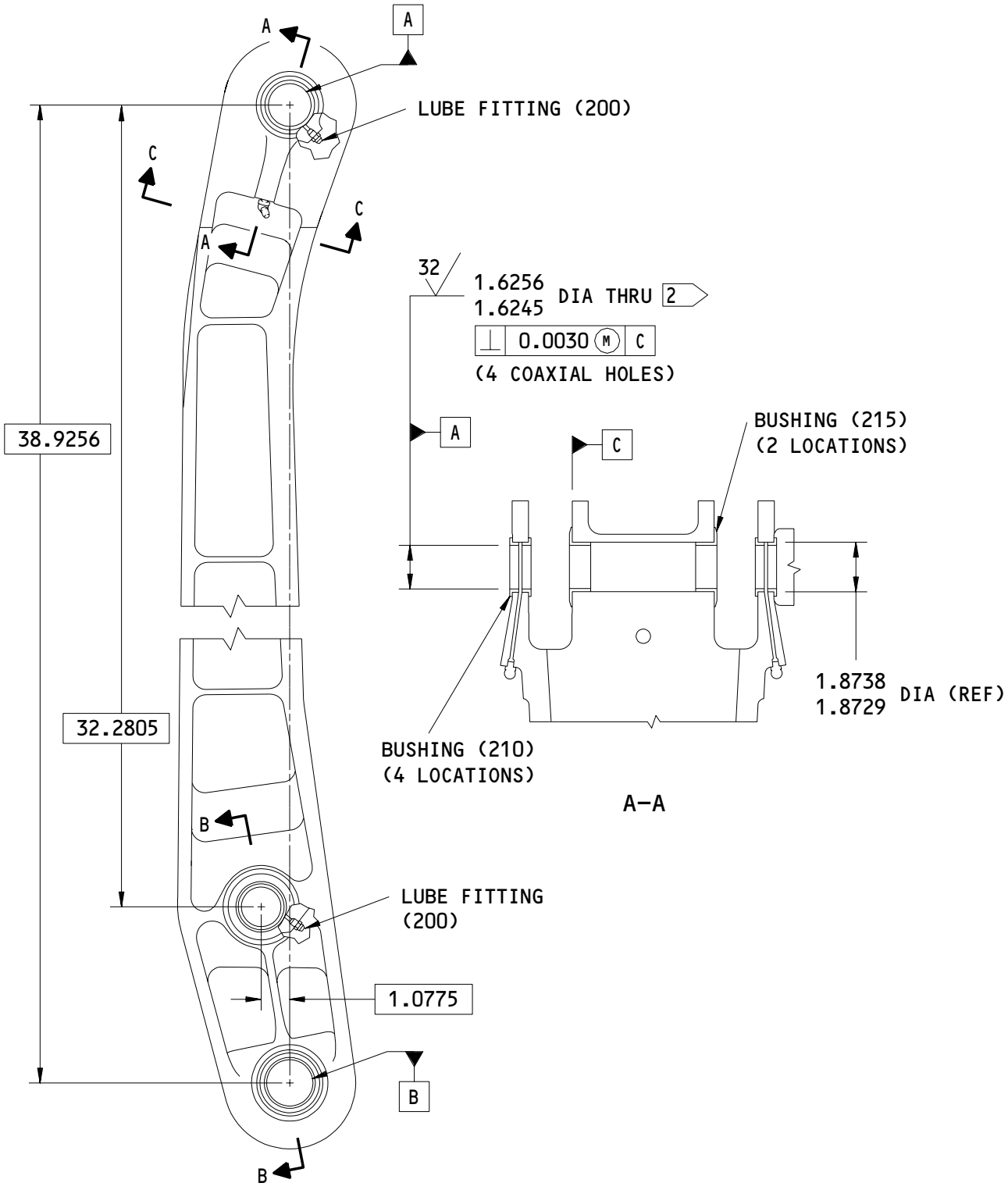
(4) SOPM 20-43-03, Chemical Conversion Coatings for Aluminum

(5) SOPM 20-60-02, Finishing Materials

C. Procedure (Fig. 601)

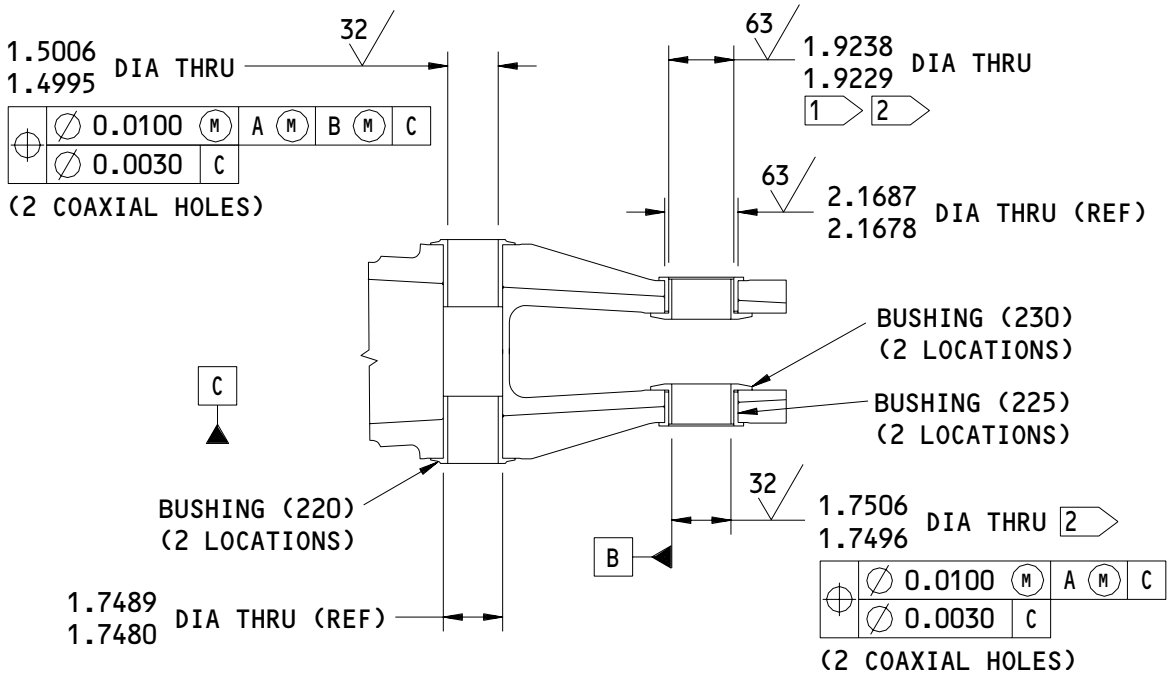
(1) Chemical treat (F-17.10) bare machined surfaces, as necessary.

(2) Apply BMS 10-11, type 1 primer (F-14.995, which replaces SRF-14.995), then apply BMS 10-60 enamel (F-14.9813, which replaces SRF-14.9813). Do not apply primer or enamel on the bushing flanges, bushing bores, the lube fittings (200, 205), or the lubrication holes.

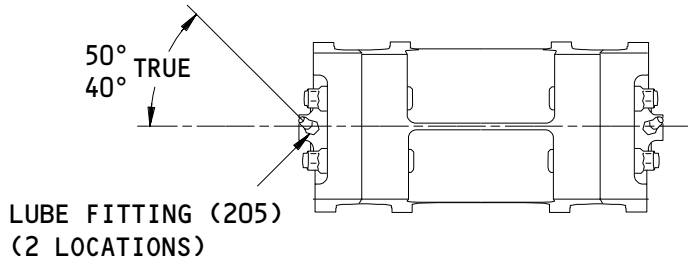


113T1222-41
1-3 Beam Assembly Repair
Figure 601 (Sheet 1)

L03614



B–B



C–C

1 INNER DIAMETER OF BUSHING (230)

2 MACHINE THE CHAMFER AT BOTH ENDS OF THE BUSHING BORE

3 FILLET SEAL THE BUSHING FLANGE

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

113T1222-41
1-3 Beam Assembly Repair
Figure 601 (Sheet 2)

1-3 BEAM ASSEMBLY - REPAIR 3-2

113T1222-41

1. General

A. This procedure has the data necessary to repair and refinish the 1-3 beam (no assigned part number). The beam refers to the group of parts that includes the inner beam (315), the outer straps (305, 310), and the applicable fasteners.

B. Refer to the Standard Overhaul Practices Manual (SOPM) for details of the SOPM chapters identified in this procedure.

C. Refer to the REPAIR - GENERAL (27-52-86/601, REPAIR - GENERAL) for the Standard True Position Dimensioning Symbols shown in the repair.

D. Refer to IPL Fig. 1 for the item numbers.

E. Gereral repair details:

(1)	Material:	Aluminum alloy
(2)	Shot peen:	All repaired surfaces Shot size: Refer to SOPM 20-10-03 Intensity 0.012A Coverage 2.0

2. Bushing Hole Repair

A. References

(1) SOPM 20-10-03, Shot Peening

(2) SOPM 20-20-01, Magnetic Particle Inspection

(3) SOPM 20-20-02, Penetrant Methods of Inspection

(4) SOPM 20-41-01, Decoding Table for Boeing Finish Codes

(5) SOPM 20-42-05, Bright Cadmium Plating

(6) SOPM 20-43-03, Chemical Conversion Coatings for Aluminum

B. Procedure

(1) Machine the beam as necessary to remove defects. Do not machine the bushing hole more than the repair limit shown in Fig. 601.

NOTE: Do not remove the fasteners or disassemble the beam. Machine the beam as a unit.

(2) Break all sharp edges 0.02-0.04 inch.

(3) Do a penetrant check of the machined surfaces. Refer to SOPM 20-20-02.

(4) Shot peen the machined area. Refer to SOPM 20-10-03.

(5) Chemical treat (F-17.10) the machined surfaces.

(6) Make the oversized bushing. Refer to Fig. 602.

(a) Bushing material:

1) Bushing (210, 215, 220) -- Al-Ni-Bronze, AMS 4640 (AMS 4880 optional for bushing (215, 220) only)

2) Bushing (225) -- 15-5PH CRES, 180-200 ksi

(b) Break all sharp edges. On bushing (210), break sharp edges 0.005-0.015 inch.

(c) Do a magnetic particle check of the oversized bushing (225). Refer to SOPM 20-20-01.

(d) Cadmium plate (F-15.06) the oversized bushing (215, 220, 225) on the surfaces shown on Fig. 603. Plating is optional on the other surfaces.

(e) Cadmium plate (F-15.36) the oversized bushing (210) on the external surfaces. Plating is optional in the bore.

(7) Install the oversized bushing as shown in Repair 3-1.

3. Beam Refinish

A. Consumable Materials

NOTE: Equivalent material can be used.

(1) C00259 Primer -- BMS 10-11, Type 1 (SOPM 20-60-02)

B. References

(1) SOPM 20-30-02, Stripping of Protective Finishes

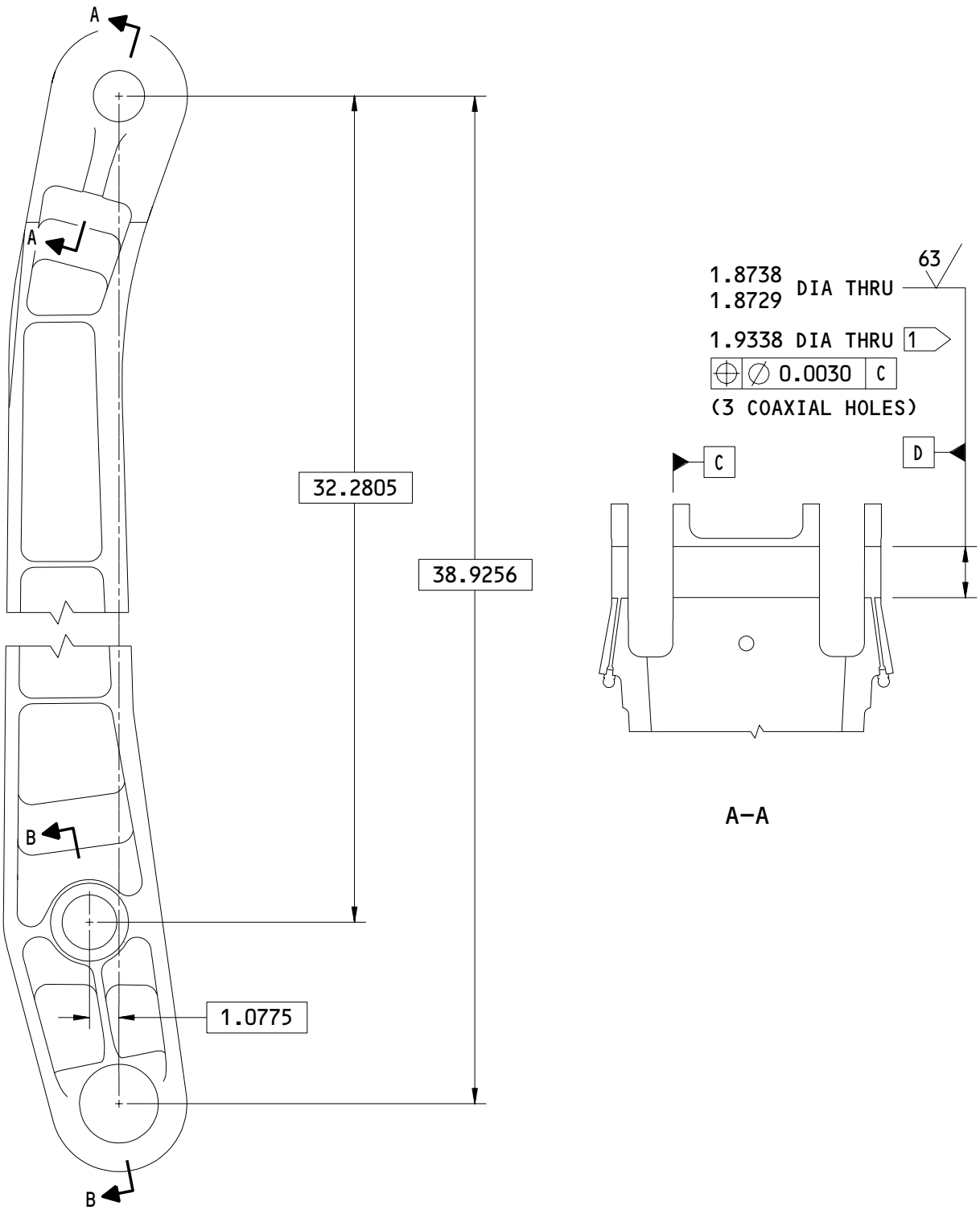
(2) SOPM 20-41-02, Application of Chemical and Solvent Resistant Finishes

(3) SOPM 20-43-01, Chromic Acid Anodizing

(4) SOPM 20-60-02, Finishing Materials

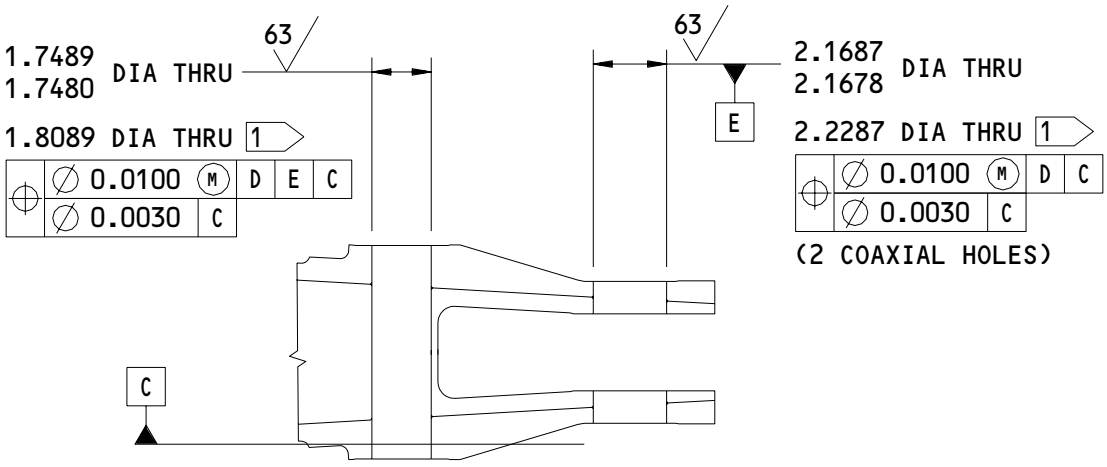
C. Procedure (Fig. 601)

(1) Beam -- Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply BMS 10-11, type 1 primer (F-20.02), but not on the bushing holes.



113T1222-41
1-3 Beam Repair
Figure 601 (Sheet 1)

L03691



B–B

1 REPAIR LIMIT

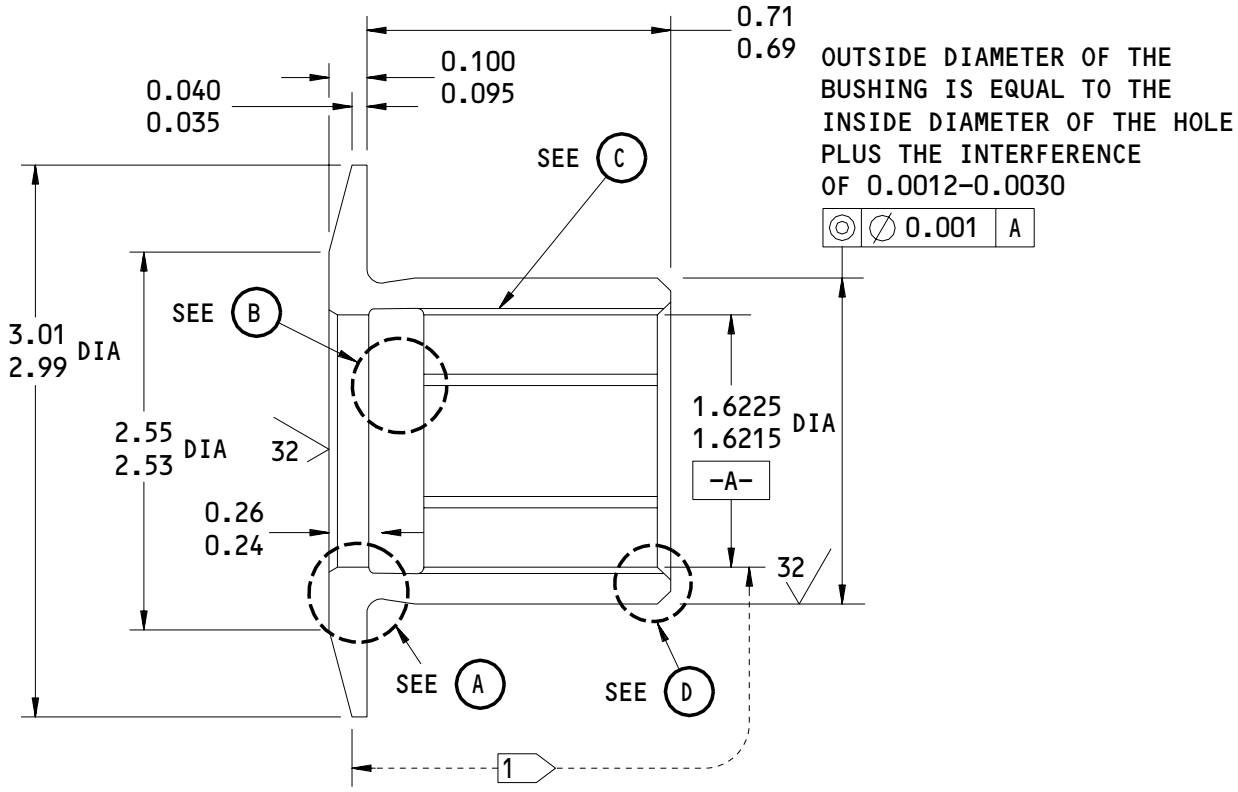
125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

ITEM NUMBERS REFER TO IPL FIG. 1

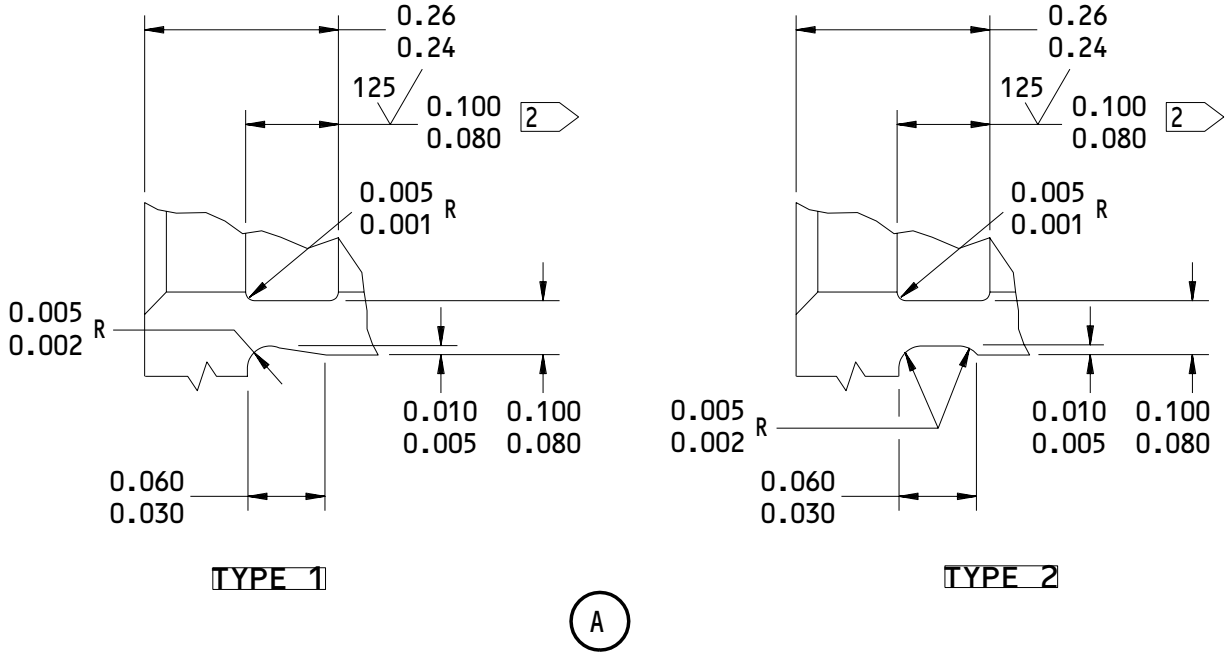
ALL DIMENSIONS ARE IN INCHES

113T1222-41
1-3 Beam Repair
Figure 601 (Sheet 2)

L03693

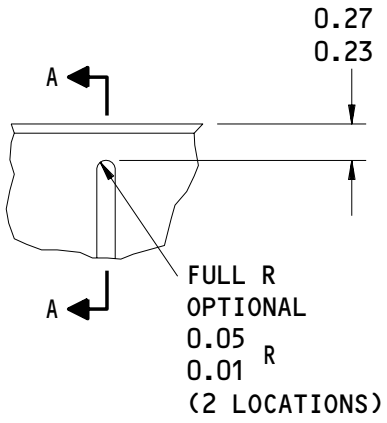


OVERSIZE REPLACEMENT FOR BUSHING (215)



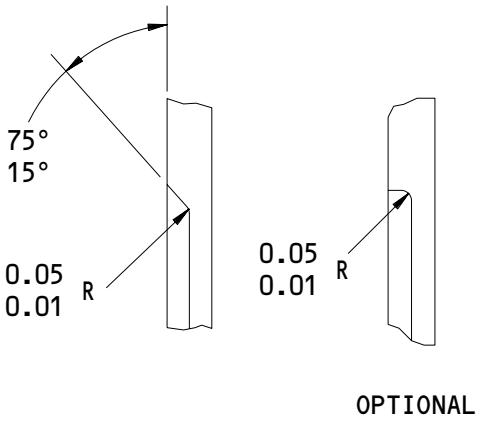
Oversize Bushing Details
Figure 602 (Sheet 1)

L03696

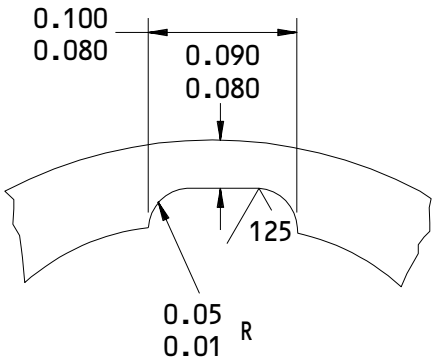


LUBE GROOVE TERMINATION

B

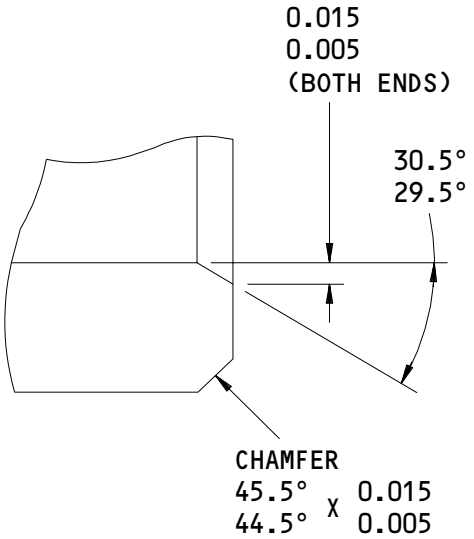


A–A



LUBE GROOVE DETAIL
6 GROOVES EQUALLY SPACED ON INNER FACE

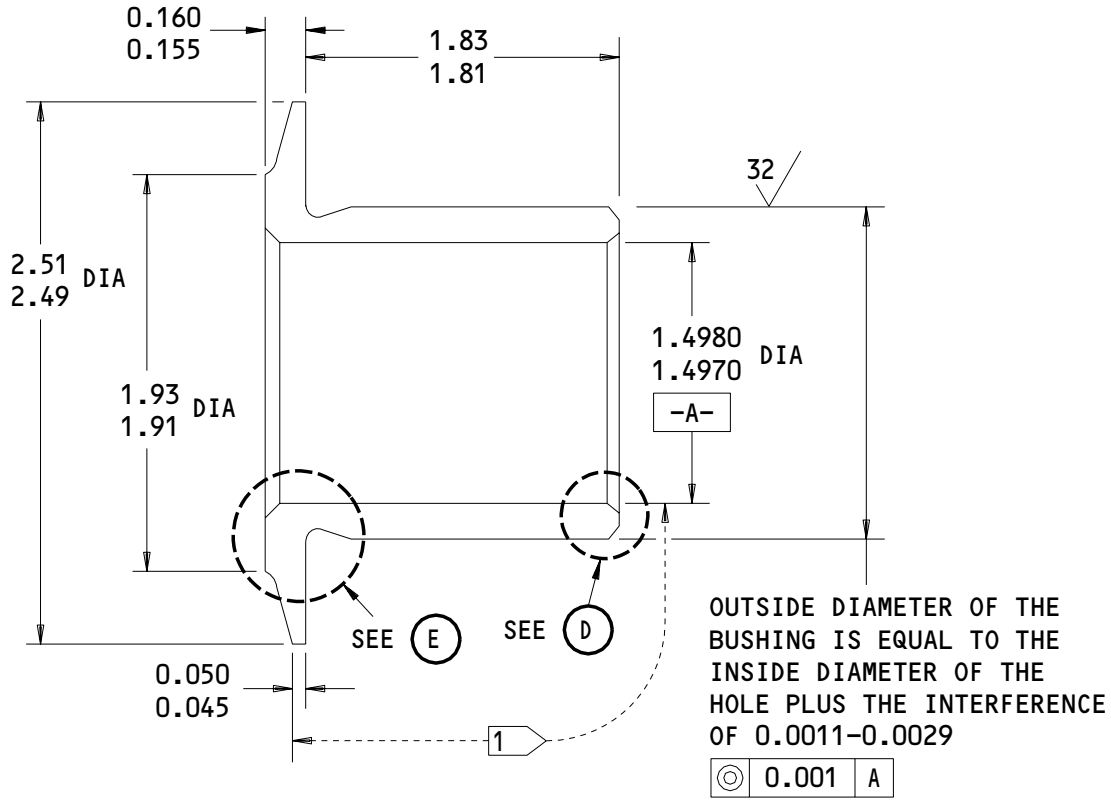
C



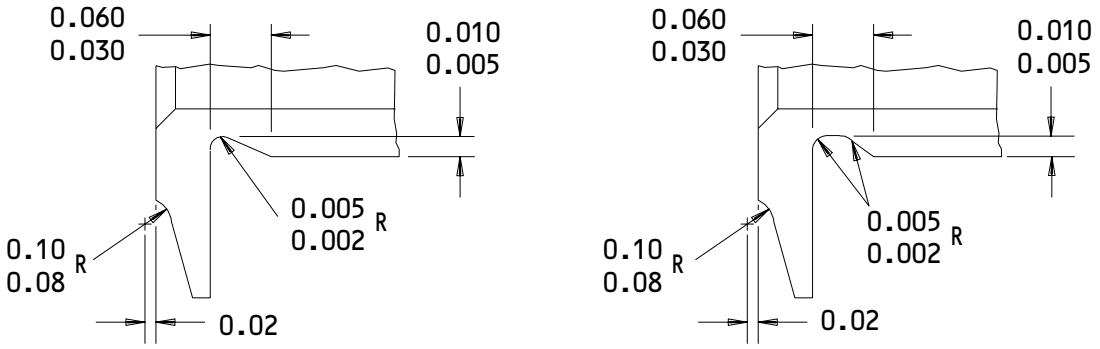
D

Oversize Bushing Details
Figure 602 (Sheet 2)

L03699



OVERSIZE REPLACEMENT FOR BUSHING (220)

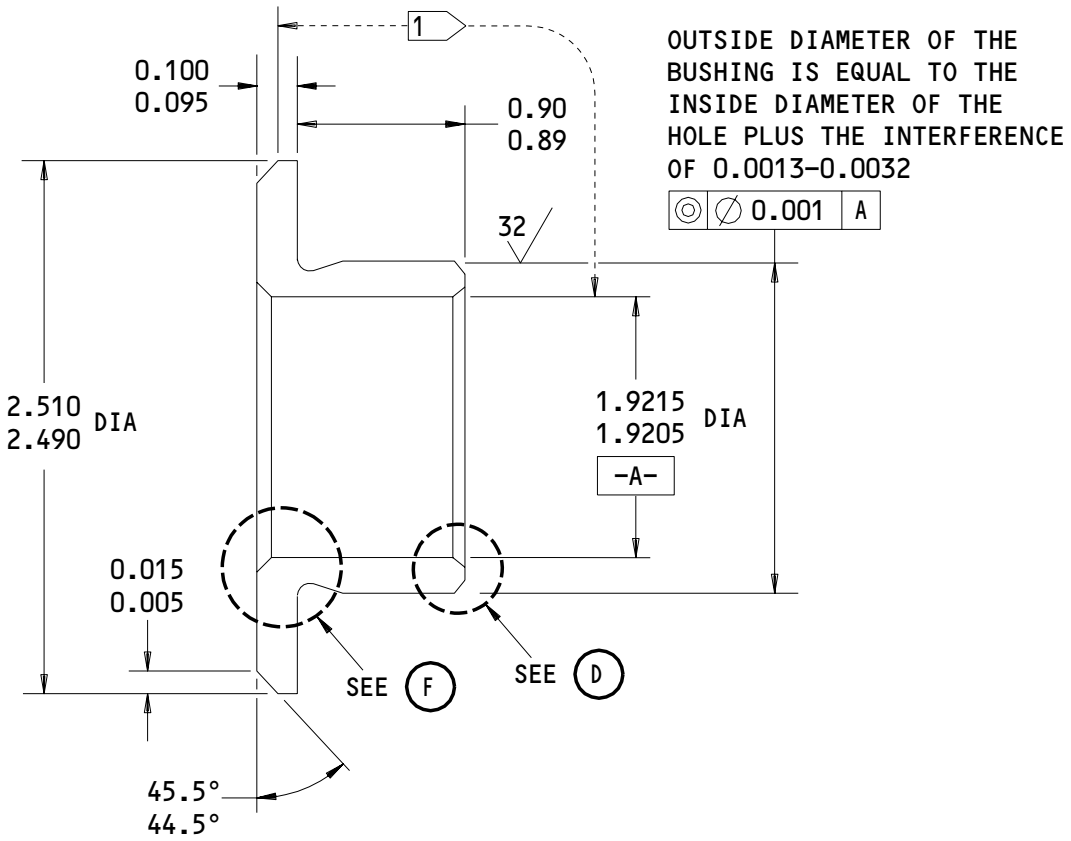


TYPE 1 TYPE 2

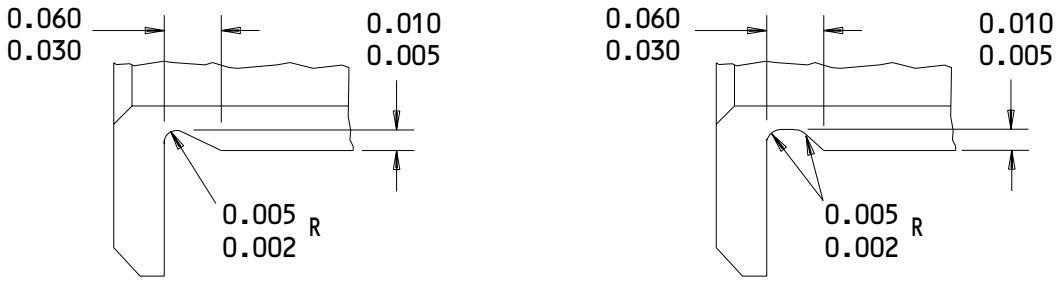
E

Oversize Bushing Details
Figure 602 (Sheet 3)

L03709

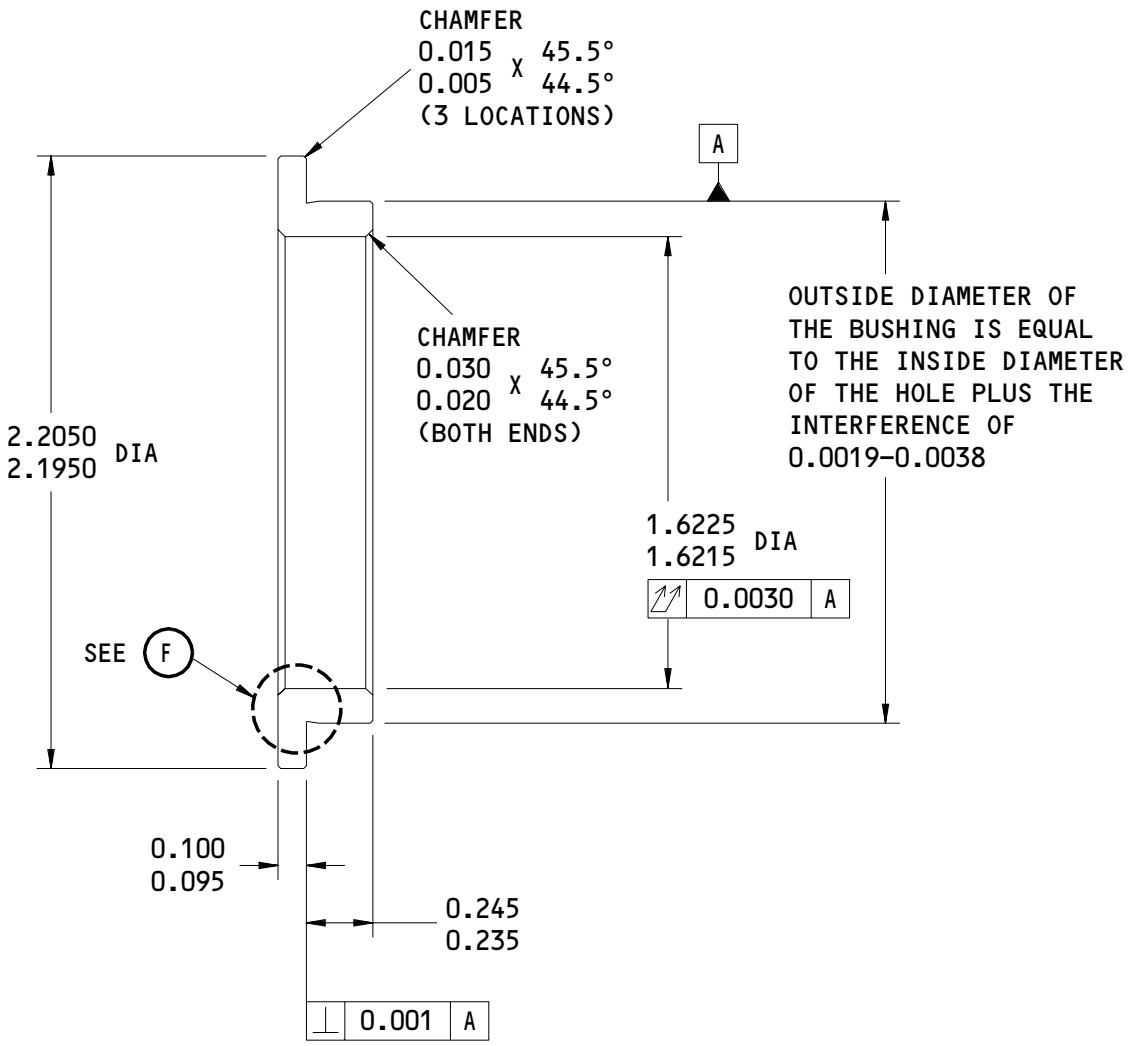


OVERSIZE REPLACEMENT FOR BUSHING (225)



Oversize Bushing Details
Figure 602 (Sheet 4)

L03714



OVERSIZE REPLACEMENT FOR BUSHING (210)

1 CADMIUM PLATE THESE SURFACES. PLATING IS OPTIONAL ON ALL OTHER SURFACES

2 OPTIONAL CIRCUMFERENTIAL LUBE GROOVE

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

DIMENSIONS APPLY AFTER PLATING

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

Oversize Bushing Details
Figure 602 (Sheet 5)

L03725

3-10 LINK ASSEMBLY - REPAIR 4-1

113T1223-41

1. General

   A. This procedure has the data necessary to repair and refinish the 3-10 link assembly (370).

   B. Refer to the Standard Overhaul Practices Manual (SOPM) for details of the SOPM chapters identified in this procedure.

   C. Refer to the REPAIR - GENERAL (27-52-86/601, REPAIR - GENERAL) for the Standard True Position Dimensioning Symbols shown in the repair.

   D. Refer to IPL Fig. 1 for the item numbers.

   E. In the procedures that follow, the group of parts that include the inner and outer segments (400, 405), and the applicable fasteners is referred to as the link.

2. Bearing Replacement

   A. Consumable Materials

      NOTE: Equivalent material can be used.

      (1) D00633 Grease -- BMS 3-33 (SOPM 20-60-03)

   B. References

      (1) SOPM 20-50-03, Bearing and Bushing Replacement

      (2) SOPM 20-60-03, Lubricants

   C. Procedure (Fig. 601)

      (1) Remove the bolts, retainer plate, and one seal from the bearing (380).

      (2) Remove the race, the other seal, and the bearing ball from the link.

      (3) Disassemble the replacement bearing (380). Make sure that the seals are installed in the bearing with grease.

(4) Install the race, one seal, and the bearing ball in the link with grease. Refer to SOPM 20-50-03.

(5) Install the retainer plate and the other seal. Attach the plate to the race with the six bolts.

3. Lube Fitting Replacement

A. Consumable Materials

NOTE: Equivalent material can be used.

(1) D00633 Grease -- BMS 3-33 (SOPM 20-60-03)

B. References

(1) SOPM 20-60-03, Lubricants

C. Procedure (Fig. 601)

(1) Remove the lube fitting (375).

(2) Apply grease to the threads of the replacement lube fitting. Install the lube fitting and tighten it to 25-30 pounds of torque.

(3) Apply grease to the lube fitting until you can see the grease flow, to make sure that the lube passage is clean.

4. Refinish

A. Consumable Materials

NOTE: Equivalent materials can be used.

(1) C00032 Enamel -- BMS 10-60, Type 1 (SOPM 20-60-02)

(2) C00259 Primer -- BMS 10-11, Type 1 (SOPM 20-60-02)

B. References

(1) SOPM 20-30-02, Stripping of Protective Finishes

(2) SOPM 20-30-03, General Cleaning Procedures

(3) SOPM 20-41-01, Decoding Table For Boeing Finish Codes

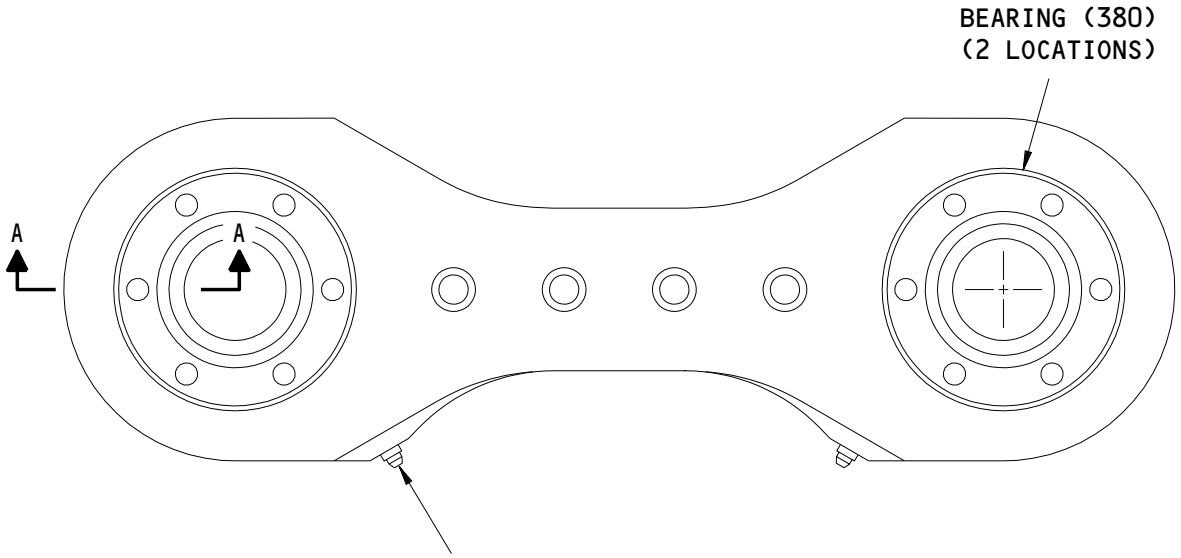
(4) SOPM 20-41-02, Application of Chemical and Solvent Resistant Finishes

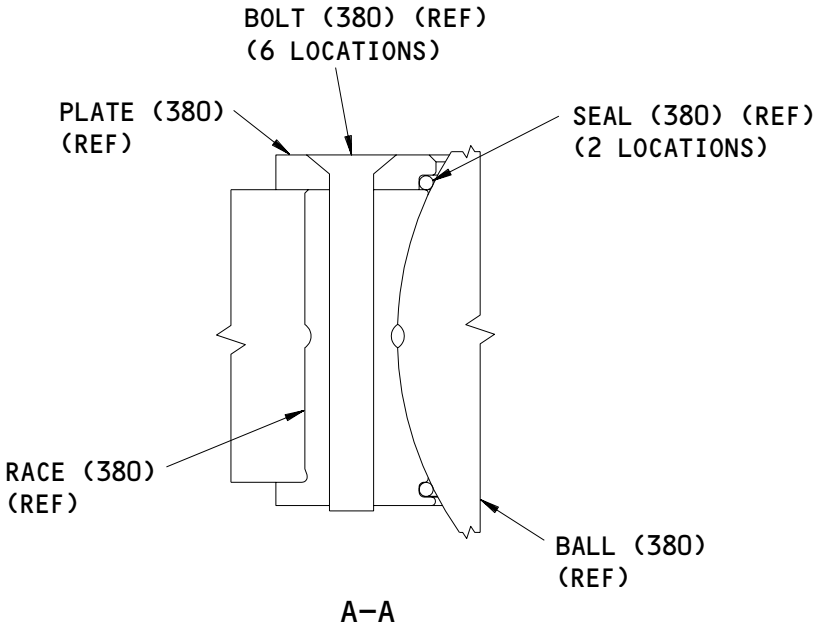
(5) SOPM 20-60-02, Finishing Materials

C. Procedure

(1) Link -- Clean the part (F-14.882). Refer to SOPM 20-30-03. Apply BMS 10-11, type 1 primer (F-20.02).

(2) Link assembly (370) -- Apply BMS 10-11, type 1 primer (F-14.995, which replaces SRF-14.995). Apply BMS 10-60 enamel (F-14.9813, which replaces SRF-14.9813). Do not apply primer or enamel on the bearings (380) or the lube fittings (375).





A–A

ITEM NUMBERS REFER TO IPL FIG. 1

113T1223-41
Link Assembly – Parts Replacement Details
Figure 601

L03737

5-7 LINK ASSEMBLY - REPAIR 5-1

113T1224-1

1. General

   A. This procedure has the data necessary to repair and refinish the 5-7 link assembly (445).

   B. Refer to the Standard Overhaul Practices Manual (SOPM) for details of the SOPM chapters identified in this procedure.

   C. Refer to the REPAIR - GENERAL (27-52-86/601, REPAIR - GENERAL) for the Standard True Position Dimensioning Symbols shown in the repair.

   D. Refer to IPL Fig. 1 for the item numbers.

   E. In the procedures that follow, the group of parts that include the link halves (490) and the applicable fasteners is referred to as the link (no assigned part number).

2. Bearing Replacement

   A. Consumable Materials

      NOTE: Equivalent materials can be used.

      (1) A00247 Sealant -- BMS 5-95 (SOPM 20-60-04)

      (2) G00376 Lockwire - MS20995C32

   B. References

      (1) SOPM 20-50-02, Installation of Safetying Devices

      (2) SOPM 20-50-03, Bearing and Bushing Replacement

      (3) SOPM 20-50-06, Installation of O-Rings and Teflon Seals

      (4) SOPM 20-60-04, Miscellaneous Materials

   C. Procedure

      (1) Remove the lockwire from the bolts (460).

(2) Remove the bolts (460), plate (465), and retainer (470) from the link.

(3) Remove the bearing (455) and seals (475) from the link.

(4) Install the replacement bearing and seals. Refer to SOPM 20-50-06.

(5) Apply sealant to the faying surfaces of the plate, retainer, and the link. Keep the sealant off of the bearing ball. Make sure that the sealant does not cause a blockage of the lubrication hole.

(6) Install the retainer (470), plate (465), and bolts (460). Tighten the two outside bolts (which do not go through the link) to 12-15 pound-inches.

NOTE: Use the standard torque on the other bolt (460) which goes through the link.

(7) Install lockwire from the bolt heads to the plate. Refer to SOPM 20-50-10.

3. Refinish

A. Consumable Materials

NOTE: Equivalent materials can be used.

(1) C00259 Primer -- BMS 10-11, Type 1 (SOPM 20-60-02)

(2) C00032 Enamel - BMS 10-60, Type 1 (SOPM 20-60-02)

B. References

(1) SOPM 20-30-02, Stripping of Protective Finishes

(2) SOPM 20-41-01, Decoding Table For Boeing Finish Codes

(3) SOPM 20-41-02, Application of Chemical and Solvent Resistant Finishes

(4) SOPM 20-42-05, Bright Cadmium Plating

(5) SOPM 20-43-01, Chromic Acid Anodizing

(6) SOPM 20-60-02, Finishing Materials

C. Procedure

(1) Plate (465), retainer (470) - Cadmium plate (F-15.06) and apply BMS 10-11, type 1 primer (F-20.02). Material: 15-5PH CRES, 180-200 ksi.

(2) Plate (465A, 465B), retainer (470A, 470B) - Cadmium plate (F-15.06). Material: 15-5PH CRES, 180-200 ksi.

(3) Link half (490) - Chromic acid anodize and apply BMS 10-11, type 1 primer (F-18.13). Material: Aluminum alloy.

(4) Link assembly (445) -- Apply BMS 10-11, type 1 primer (F-14.995, which replaces SRF-14.995), then apply BMS 10-60 enamel (F-14.9813, which replaces SRF-14.9813). Do not apply primer or enamel on the bearings (455), seals 475), or the lube fitting (450).

9-10 BEAM ASSEMBLY - REPAIR 6-1

113T1226-51

1. General

   A. This procedure has the data necessary to repair and refinish the 9-10 beam assembly (605).

   B. Refer to the Standard Overhaul Practices Manual (SOPM) for details of the SOPM chapters identified in this procedure.

   C. Refer to the REPAIR - GENERAL (27-52-86/601, REPAIR - GENERAL) for the Standard True Position Dimensioning Symbols shown in the repair.

   D. Refer to IPL Fig. 1 for the item numbers.

   E. In the procedures that follow, the group of parts that include the inner beam (740), outer plates (730, 735), and the applicable fasteners is referred to as the beam.

2. Bearing (630) Replacement

   A. Consumable Materials

      NOTE: Equivalent material can be used.

      (1) A00359 Sealant -- BMS 5-95 (SOPM 20-60-04)

   B. References

      (1) SOPM 20-50-03, Bearing and Bushing Replacement

      (2) SOPM 20-60-04, Miscellaneous Materials

   C. Procedure

      (1) Remove the bearing (630) from the beam.

      CAUTION: DO NOT MOVE THE BEARING BALL MORE THAN 5 DEGREES OUT OF ALIGNMENT OR THE SEALS CAN BE DAMAGED.

      (2) Install the replacement bearing with sealant. Refer to SOPM 20-50-03.

(3) Roller swage the bearing outer ring on both sides. Refer to SOPM 20-50-03.

3. Bearing (665) Replacement

A. Consumable Materials

NOTE: Equivalent material can be used.

(1) D00013 Grease -- BMS 3-33 (SOPM 20-60-03)

B. References

(1) SOPM 20-50-03, Bearing and Bushing Replacement

(2) SOPM 20-50-06, Installation of O-Rings and Teflon Seals

(3) SOPM 20-60-03, Lubricants

C. Procedure

(1) Remove the bolts (650), plate (655), and one seal (670) from the beam.

(2) Remove the retainer (660), the other seal (670), and the bearing (665) from the beam.

(3) Install the bearing (665), seals (670), and retainer (660) in the beam with grease. Refer to SOPM 20-50-03. Attach the plate (655) to the retainer with the bolts (650). Tighten the bolts to 20-25 pound-inches.

4. Bushing Replacement

A. Consumable Materials

NOTE: Equivalent material can be used.

(1) A00359 Sealant -- BMS 5-95 (SOPM 20-60-04)

B. References

(1) SOPM 20-50-03, Bearing and Bushing Replacement

(2) SOPM 20-60-04, Miscellaneous Materials

C. Procedure

NOTE: The co-axial bushings must be replaced in full sets so that the machined bushing bores will be aligned.

(1) Remove the bushings (615, 620, 625) from the beam.

(2) Install the new bushings with sealant. Use the shrink-fit procedure. Refer to SOPM 20-50-03.

(3) Machine the bushing bores to the dimensions shown in Fig. 601.

(4) Machine a 0.02-0.03 inch x 44-46 degree chamfer on the ends of the bushing bores, as shown in Fig. 601.

(5) Fillet seal the bushing flange with sealant.

5. Lube Fitting Replacement

A. Consumable Materials

NOTE: Equivalent material can be used.

(1) D00633 Grease -- BMS 3-33 (SOPM 20-60-03)

B. References

(1) SOPM 20-60-03, Lubricants

C. Procedure (Fig. 601)

(1) Remove the lube fitting (610).

(2) Apply grease to the threads of the replacement lube fitting. Install the lube fitting and tighten it to 25-30 pounds of torque.

(3) Apply grease to the lube fitting until you can see the grease flow, to make sure that the lube passage is clean.

6. Beam Assembly (605) Refinish

A. Consumable Materials

NOTE: Equivalent material can be used.

(1) C00032 Enamel -- BMS 10-60, Type 1 (SOPM 20-60-02)

(2) C00259 Primer -- BMS 10-11, Type 1 (SOPM 20-60-02)

B. References

(1) SOPM 20-30-02, Stripping of Protective Finishes

(2) SOPM 20-41-01, Decoding Table For Boeing Finish Codes

(3) SOPM 20-41-02, Application of Chemical and Solvent Resistant Finishes

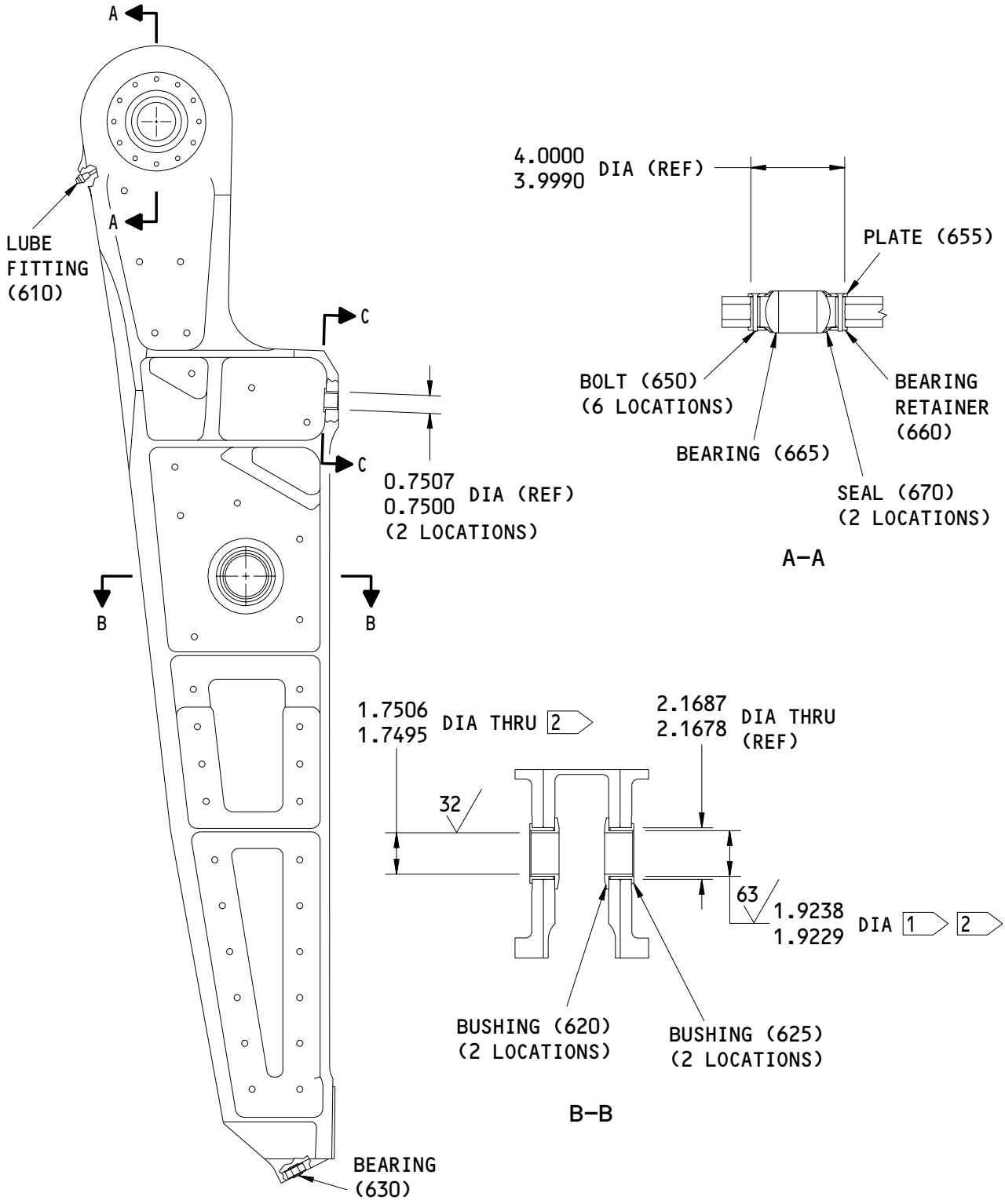
(4) SOPM 20-43-03, Chemical Conversion Coatings for Aluminum

(5) SOPM 20-60-02, Finishing Materials

C. Procedure (Fig. 601)

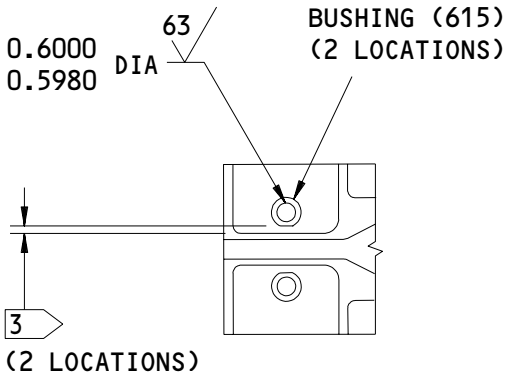
(1) Chemical treat (F-17.10) bare machined surfaces, as necessary.

(2) Apply BMS 10-60 enamel (F-14.9813, which replaces SRF-14.9813). Do not apply enamel on the bearings (630, 665), bushing flanges, bushing bores, the lube fitting (535), the lubrication holes, or on the top of the shim (645).



113T1226-51
9-10 Beam Assembly Repair
Figure 601 (Sheet 1)

L03766



C–C

1 INNER DIAMETER OF BUSHING (625)

2 MACHINE THE CHAMFER AT BOTH ENDS OF THE BUSHING BORE

3 FLAT EDGE OF FLANGE IS PARALLEL TO WEB ±5 DEGREES

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

113T1226-51
9-10 Beam Assembly Repair
Figure 601 (Sheet 2)

L03772

9-10 BEAM ASSEMBLY - REPAIR 6-2

113T1226-51

1. General

A. This procedure has the data necessary to repair and refinish the 9-10 beam (no assigned part number). The beam refers to the group of parts that includes the inner beam (740), the outer plates (730, 735), and the applicable fasteners .

B. Refer to the Standard Overhaul Practices Manual (SOPM) for details of the SOPM chapters identified in this procedure.

C. Refer to the REPAIR - GENERAL (27-52-86/601, REPAIR - GENERAL) for the Standard True Position Dimensioning Symbols shown in the repair.

D. Refer to IPL Fig. 1 for the item numbers.

E. General repair details;

(1)	Material:	Aluminum alloy
(2)	Shot peen:	All repaired surfaces Shot size: Refer to SOPM 20-10-03 Intensity 0.012A Coverage 2.0

2. Bushing Hole Repair

A. References

(1) SOPM 20-10-03, Shot Peening

(2) SOPM 20-20-01, Magnetic Particle Inspection

(3) SOPM 20-20-02, Penetrant Methods of Inspection

(4) SOPM 20-41-01, Decoding Table for Boeing Finish Codes

(5) SOPM 20-42-05, Bright Cadmium Plating

(6) SOPM 20-43-03, Chemical Conversion Coatings for Aluminum

B. Procedure

(1) Machine the beam as necessary to remove defects. Do not machine the bushing or bearing hole more than the repair limit shown in Fig. 601.

NOTE: Do not remove the fasteners or disassemble the beam. Machine the beam as a unit.

(2) Break all sharp edges 0.02-0.04 inch.

(3) Do a penetrant check of the beam. Refer to SOPM 20-20-02.

(4) Shot peen the machined area. Refer to SOPM 20-10-03.

(5) Chemical treat (F-17.10) the machined surface.

(6) Make the oversized bushing or bearing retainer. Refer to Fig. 602.

(a) Material:

1) Bushing (615, 625) -- 15-5PH CRES, 180-200 ksi

2) Retainer (660) -- 15-5PH CRES, 180-200 ksi

(b) Break all sharp edges.

(c) Do a magnetic particle check of the oversized bushing (615, 625) or bearing retainer (660). Refer to SOPM 20-20-01.

(d) Cadmium plate (F-16.06) the oversized bushing (615) on the surfaces shown on Fig. 603. Plating is optional on the other surfaces.

(e) Cadmium plate (F-15.06) the oversized bushing (625) on the surfaces shown on Fig. 603. Plating is optional on the other surfaces.

(f) Cadmium plate (F-15.06) the oversized bearing retainer (660) all over.

(7) Install the oversized bushing as shown in Repair 2-1.

3. Beam Refinish

A. Consumable Materials

NOTE: Equivalent material can be used.

(1) C00259 Primer -- BMS 10-11, Type 1 (SOPM 20-60-02)

B. References

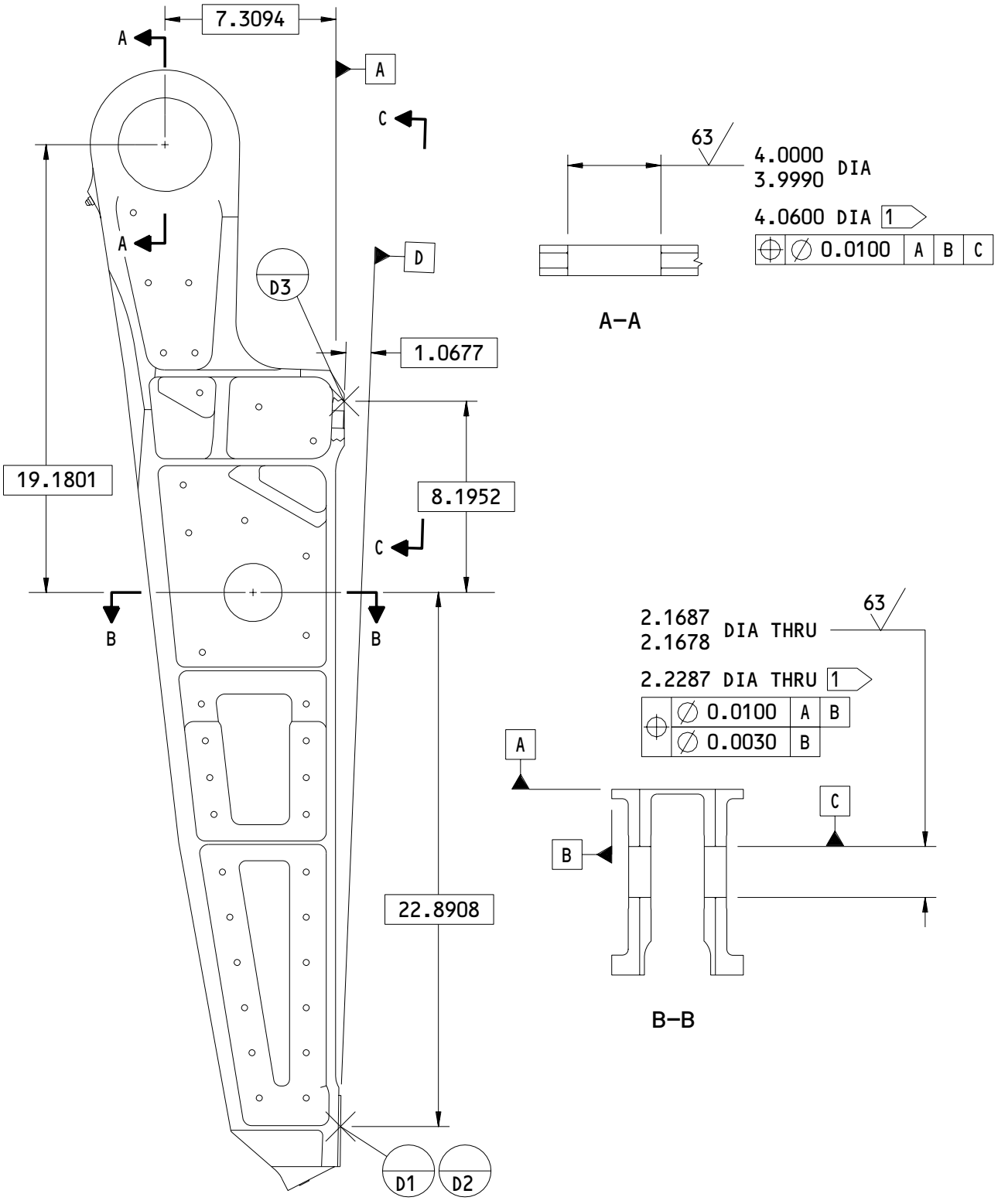
(1) SOPM 20-10-03, Shot Peening

(2) SOPM 20-41-01, Decoding Table For Boeing Finish Codes

(3) SOPM 20-60-02, Finishing Materials

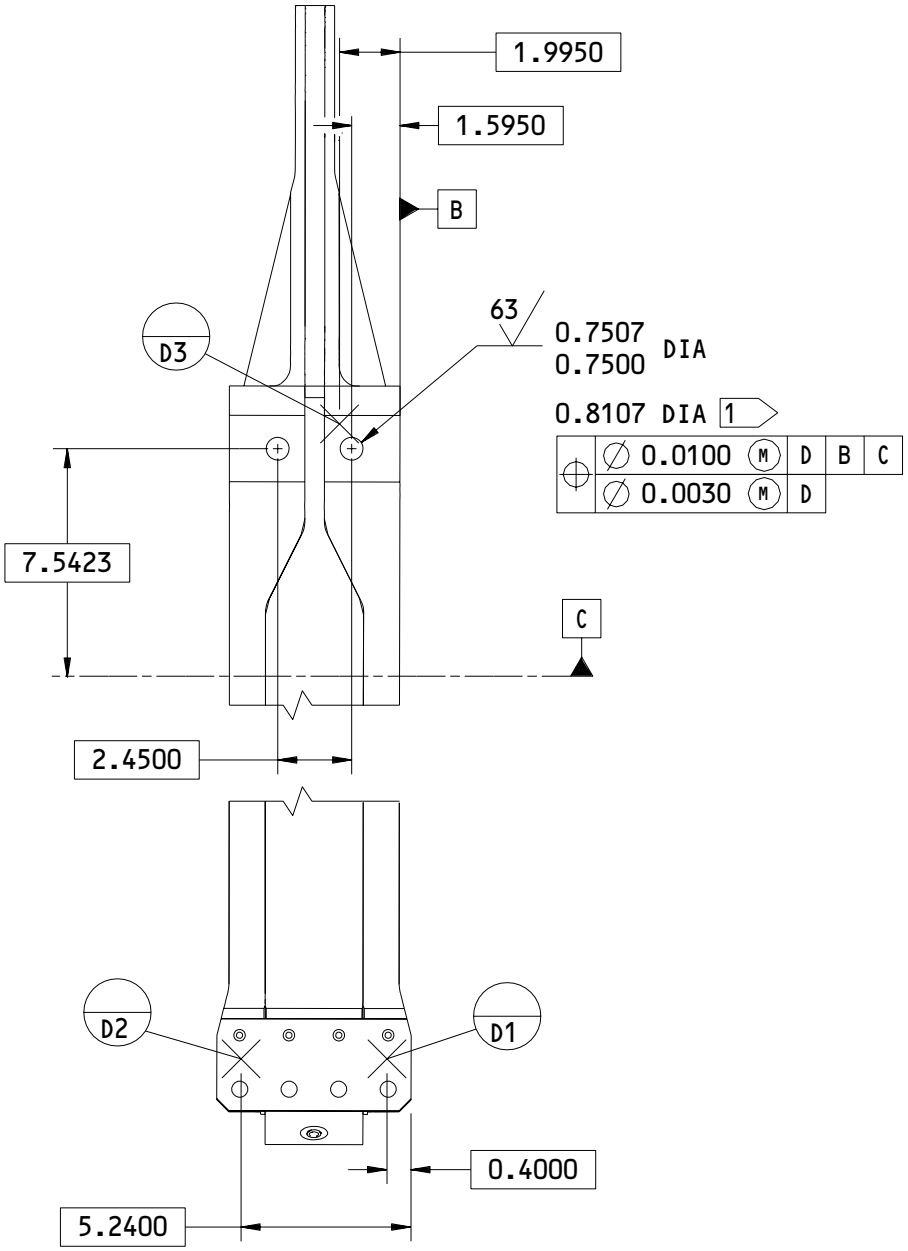
C. Procedure (Fig. 601)

(1) Passivate (F-17.25, which replaces F-17.09).



113T1226-51
9-10 Beam Repair
Figure 601 (Sheet 1)

L03817



C–C

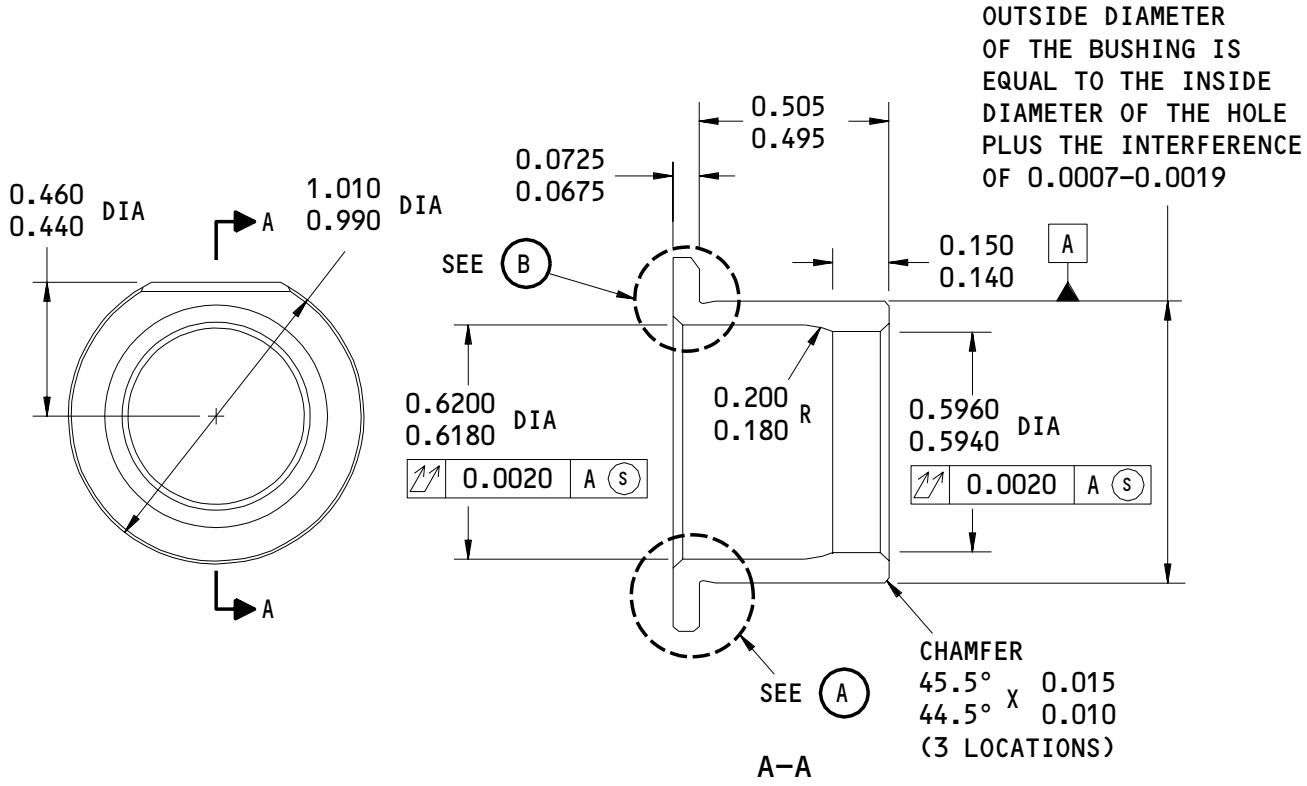
1 REPAIR LIMIT

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

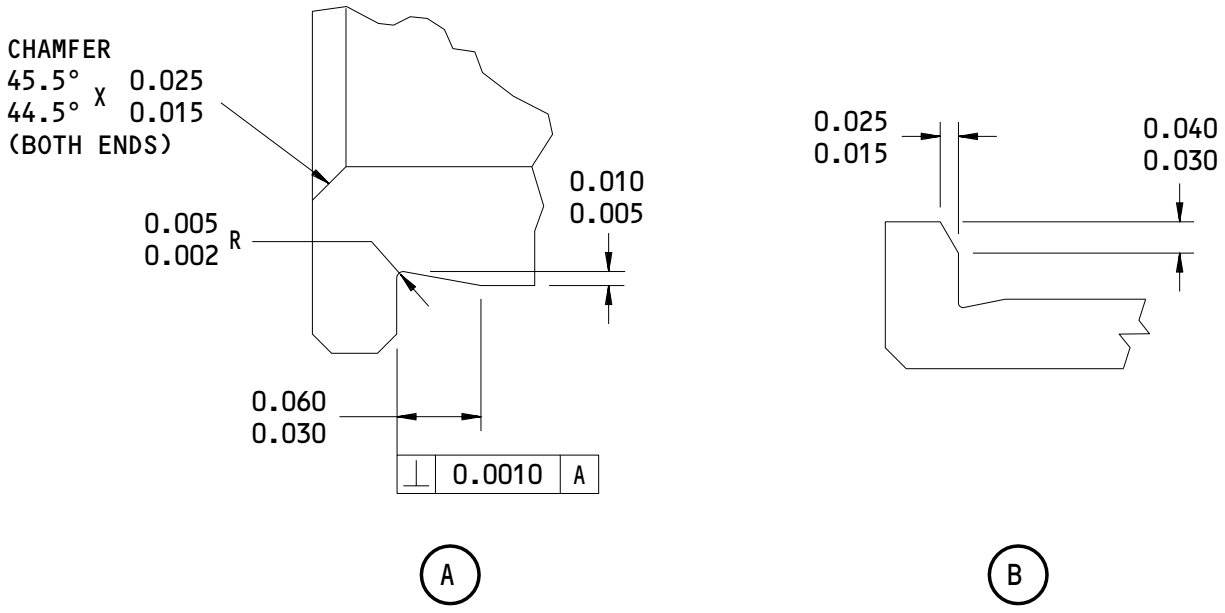
ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

113T1226-51
9-10 Beam Repair
Figure 601 (Sheet 2)

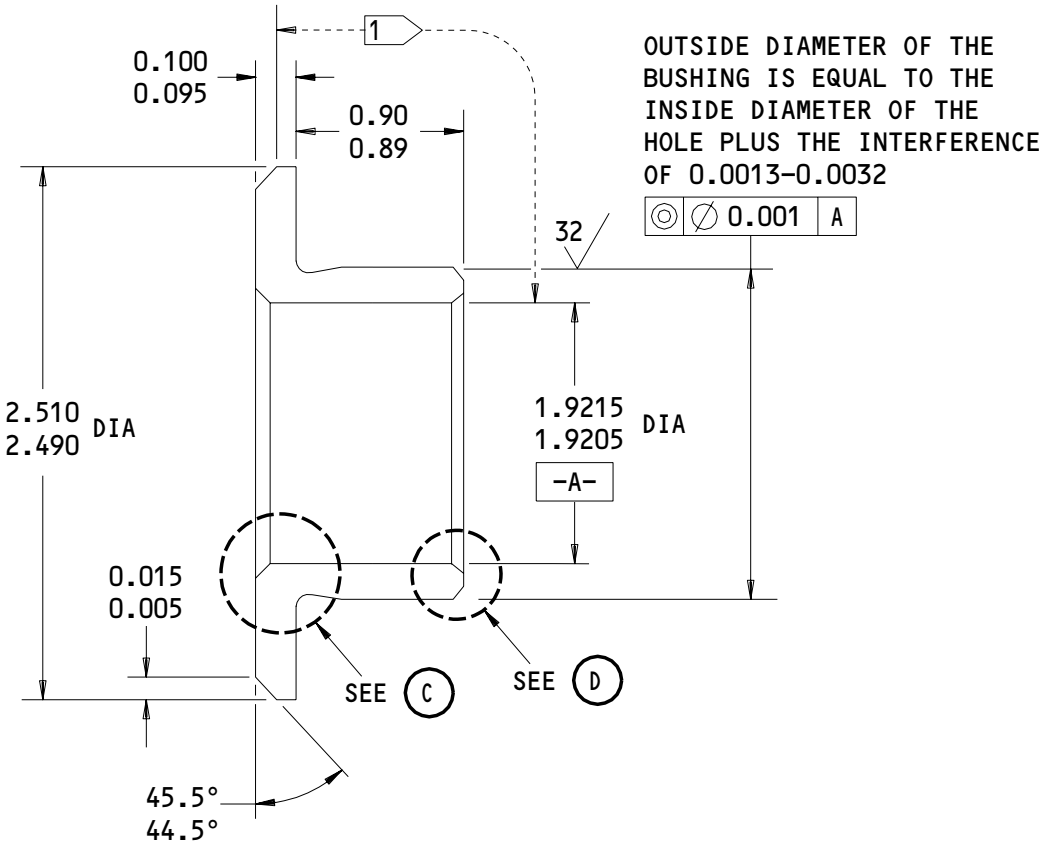


OVERSIZE REPLACEMENT FOR BUSHING (615)

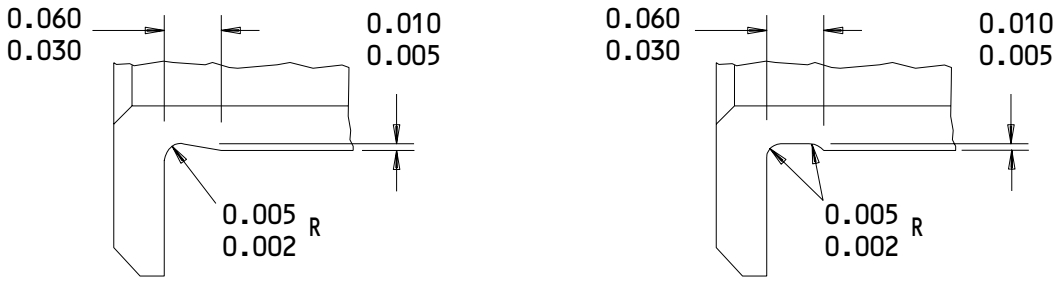


Oversize Bushing Details
Figure 602 (Sheet 1)

L03852



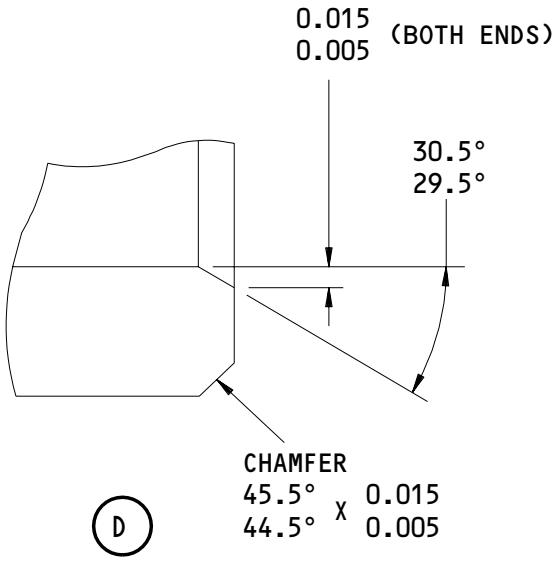
OVERSIZE REPLACEMENT FOR BUSHING (625)



C

Oversize Bushing Details
Figure 602 (Sheet 2)

L03854



1 CADMIUM PLATE THESE SURFACES. PLATING IS OPTIONAL ON ALL OTHER SURFACES

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

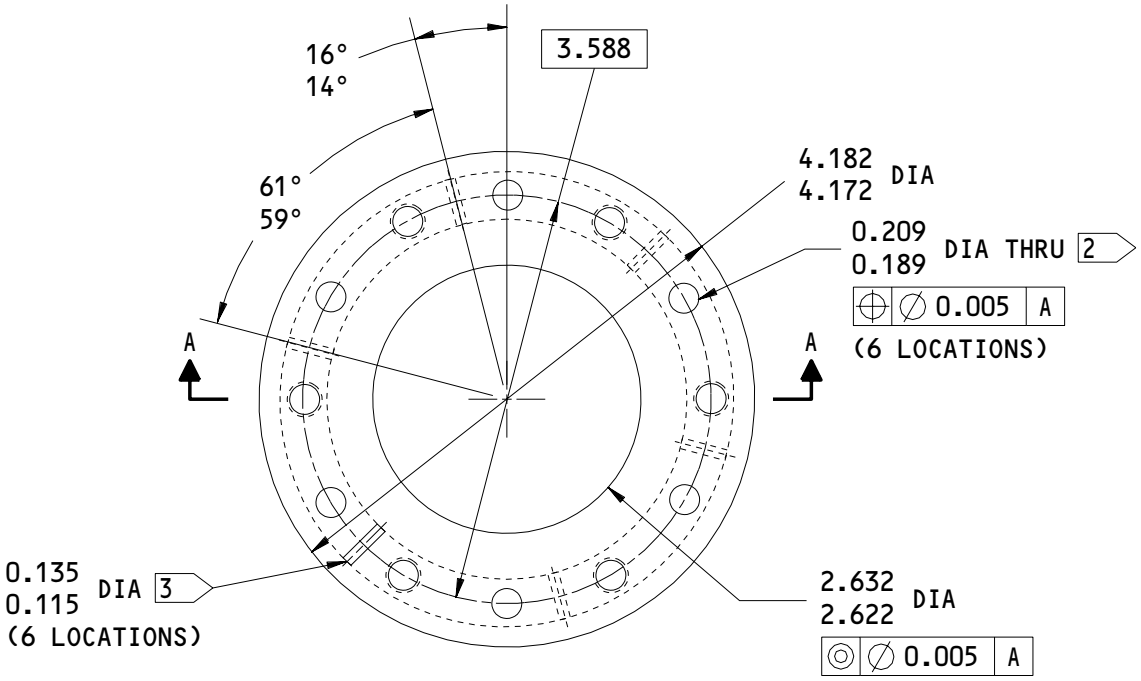
DIMENSIONS APPLY AFTER PLATING

ITEM NUMBER REFER TO IPL FIG. 1

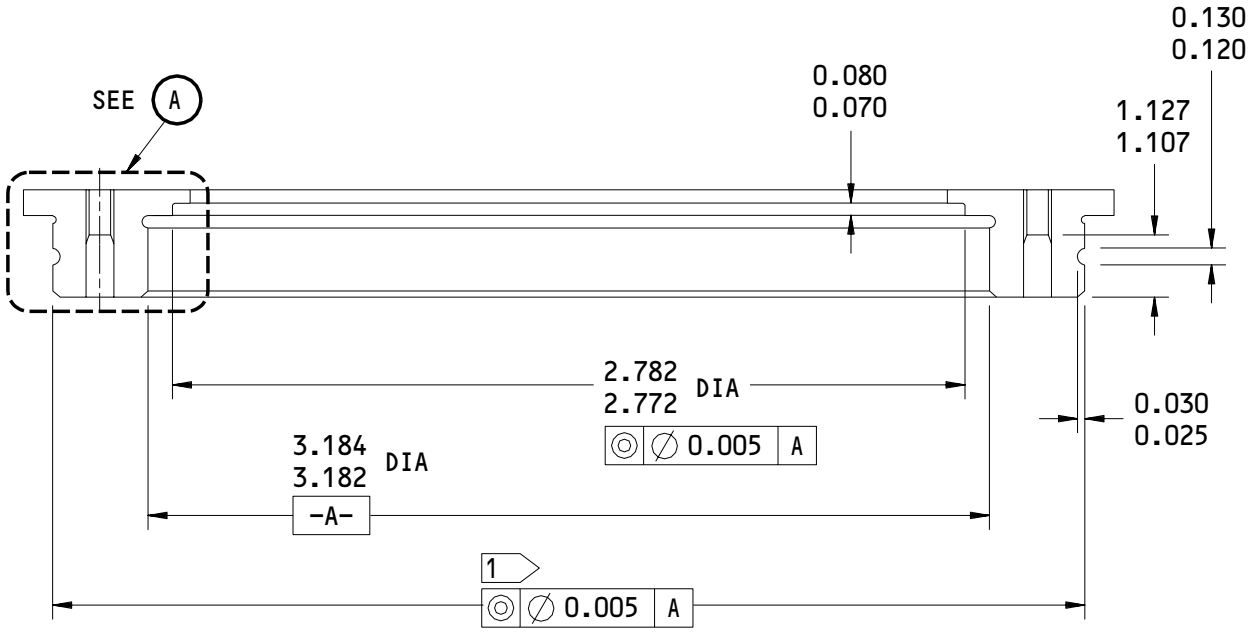
ALL DIMENSIONS ARE IN INCHES

Oversize Bushing Details
Figure 602 (Sheet 3)

L03864



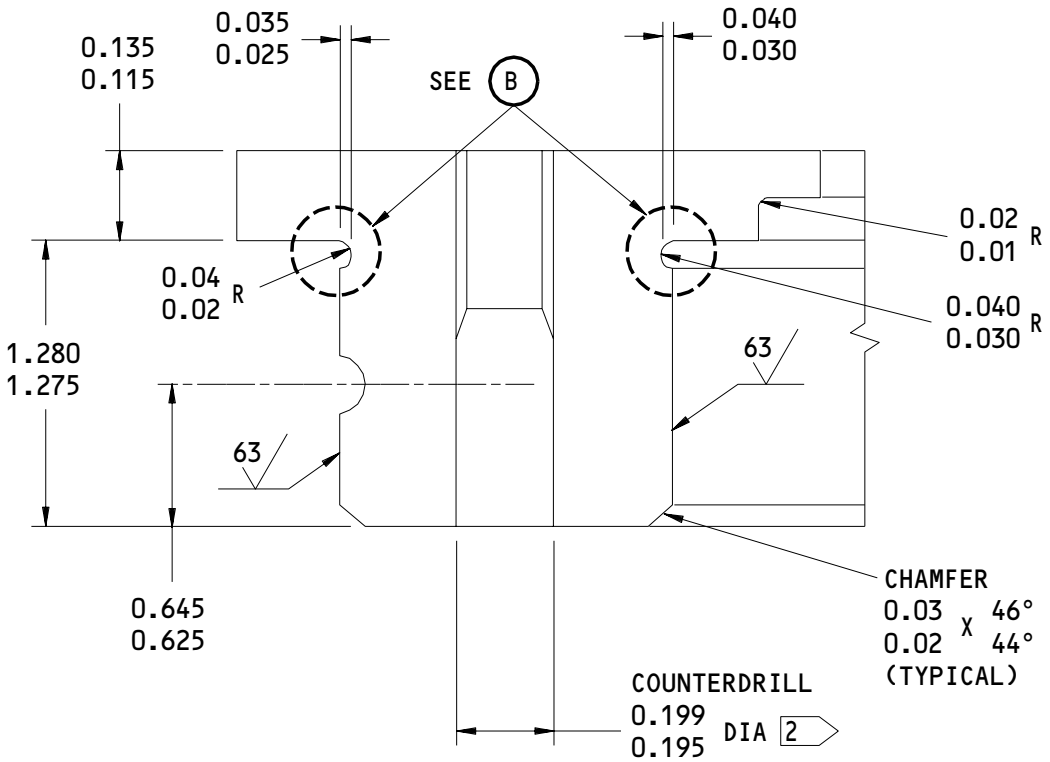
OVERSIZE REPLACEMENT FOR BEARING RETAINER (660)

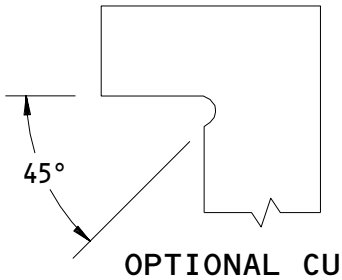


A–A

Oversize Bearing Retainer Details
Figure 603 (Sheet 1)

L03947





OPTIONAL CUT

B

1 THE OUTSIDE DIAMETER OF THE RETAINER AFTER PLATING IS EQUAL TO THE INSIDE DIAMETER OF THE HOLE PLUS THE INTERFERENCE OF 0.0010-0.0030

2 EQUAL SPACES BETWEEN THE HOLES

3 GREASE HOLE IS AT EQUAL DISTANCES FROM THE ADJACENT HOLES

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

DIMENSIONS APPLY AFTER PLATING

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

Oversize Bearing Retainer Details
Figure 603 (Sheet 2)

L03963

OUTER PIN - REPAIR 7-1

113T1263-2, -5 THRU -8

1. General

A. This procedure has the data necessary to repair and refinish the outer pin (45, 145, 190, 365, 440, 525).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for details of the SOPM chapters identified in this procedure.

C. Refer to the REPAIR - GENERAL (27-52-86/601, REPAIR - GENERAL) for the Standard True Position Dimensioning Symbols shown in the repair.

D. Refer to IPL Fig. 1 for the item numbers.

E. General repair details:

(1) Material: 15-5PH CRES, 180-200 ksi

(2) Shot peen: All repaired surfaces
Shot size 0.017-0.046
Intensity 0.016A
Coverage 2.0

2. Outer Pin Repair

A. References

(1) SOPM 20-10-01, Repair and Refinish of High Strength Steel Parts

(2) SOPM 20-10-02, Machining of Alloy Steel

(3) SOPM 20-10-03, Shot Peening

(4) SOPM 20-10-04, Grinding of Chrome-Plated Parts

(5) SOPM 20-20-01, Magnetic Particle Inspection

(6) SOPM 20-42-03, Hard Chrome Plating

B. Procedure

(1) Machine the outer pin (45, 145, 190, 365, 440, 525) outer diameter as necessary to remove defects. Do not machine the diameter more than the repair limit shown in Fig. 601.

(2) Break all sharp edges.

(3) Do a magnetic particle check of the outer pin. Refer to SOPM 20-20-01.

(4) Shot peen the machined area. Refer to SOPM 20-10-03.

(5) Apply chrome plate (F-15.03) to the machined area. Chrome plate is not permitted in the fillet radii or on the edges of the part.

(6) Grind the chrome plate to the design dimensions and finish shown in Fig. 601. Make sure that the chrome plate is at least 0.003 inch thick after you grind the surface. The chrome plate runout is 0.000-0.008 inch, and must stop at the edge of the repaired surface. Refer to SOPM 20-10-04.

3. Outer Pin Refinish

A. References

(1) SOPM 20-10-04, Grinding of Chrome Plated Parts

(2) SOPM 20-30-03, General Cleaning Procedures

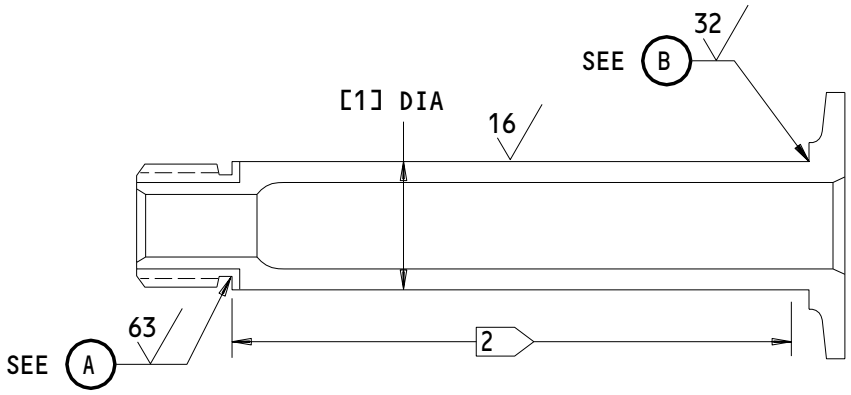
(3) SOPM 20-42-03, Hard Chrome Plating

B. Procedure (Fig. 601)

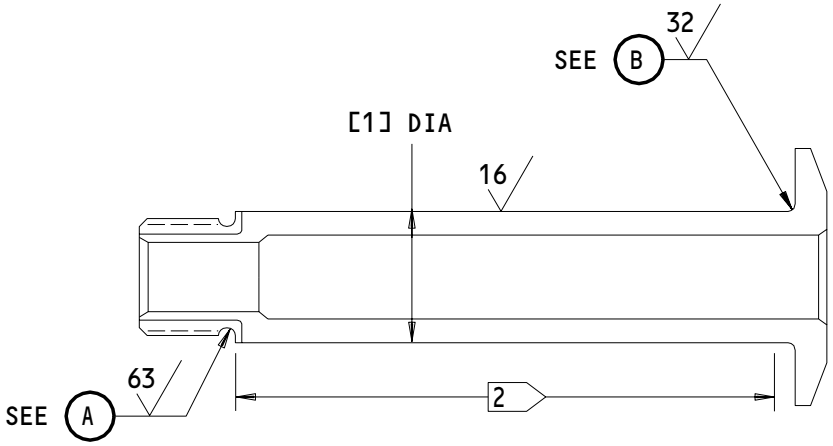
(1) Chrome plate (F-15.03) the surfaces shown in Fig. 601. Chrome plate is not permitted in the fillet radii or on the edges of the part.

(2) Grind the chrome plate to the design dimensions and finish shown in Fig. 601. Make sure that the chrome plate is at least 0.003 inch thick after you grind the surface. The chrome plate runout is 0.000-0.008 inch, and must stop at the edge of the refinished surface, as shown. Refer to SOPM 20-10-04.

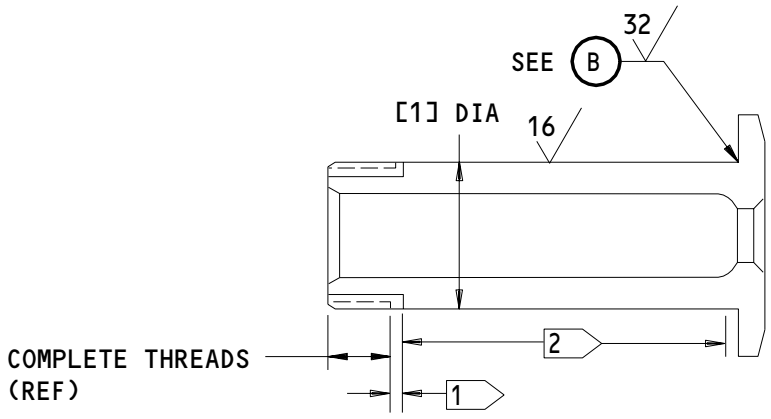
(3) Passivate (F-17.25, which replaces F-17.09) all other surfaces.



113T1263-2,-6



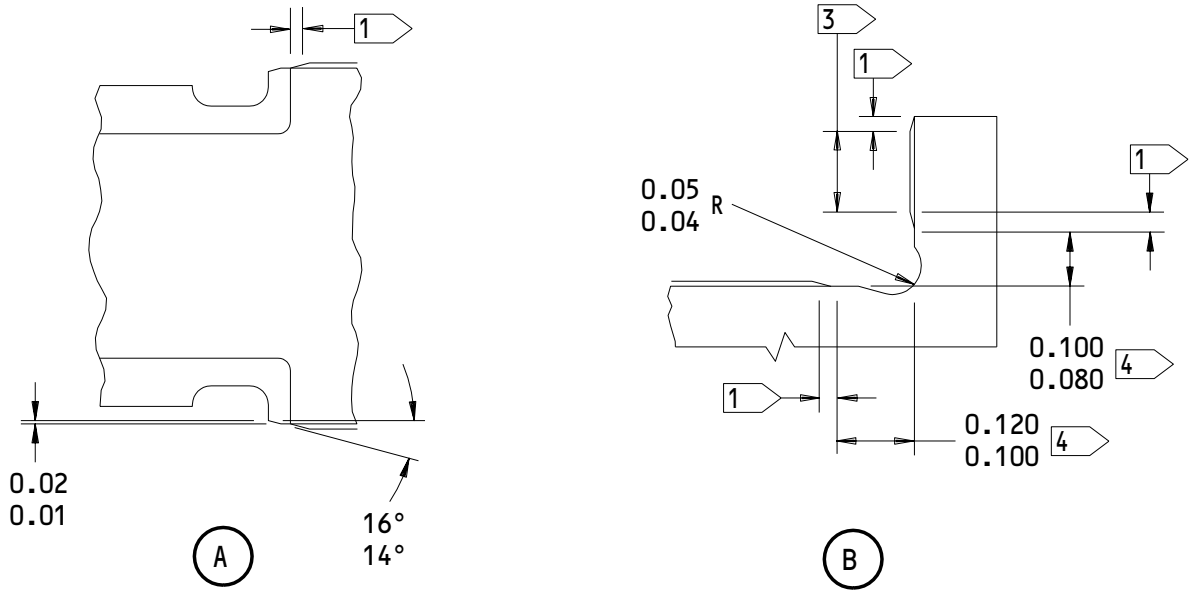
113T1263-5,-8



113T1263-7

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

L03983



PIN PART NO.	ITEM NO.	[1]	[1] 5
113T1263-2	145	1.4990 1.4984	1.4911
113T1263-5	440	1.7490 1.7484	1.7400
113T1263-6	45	1.4990 1.4984	1.4911
113T1263-7	525	1.6240 1.6234	1.6156
113T1263-8	190,365	1.7490 1.7484	1.7400

1 > 0.000-0.080 CHROME PLATE RUNOUT AREA

2 > CHROME PLATE

3 > CHROME PLATE THIS SURFACE (113T1263-7,-8 ONLY), 0.001 MINIMUM THICKNESS

4 > NO CHROME PLATE IN THIS AREA

5 > REPAIR LIMIT

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

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

6-11 LINK ASSEMBLY - REPAIR 8-1

113T2066-41, 42

1. General

   A. This procedure has the data necessary to repair and refinish the 6-11 link assembly (50, 55).

   B. Refer to the Standard Overhaul Practices Manual (SOPM) for details of the SOPM chapters identified in this procedure.

   C. Refer to the REPAIR - GENERAL (27-52-86/601, REPAIR - GENERAL) for the Standard True Position Dimensioning Symbols shown in the repair.

   D. Refer to IPL Fig. 1 for the item numbers.

2. Bushing Replacement

   A. Consumable Materials

      NOTE: Equivalent material can be used.

      (1) A00359 Sealant -- BMS 5-95 (SOPM 20-60-04)

   B. References

      (1) SOPM 20-50-03, Bearing and Bushing Replacement

      (2) SOPM 20-60-04, Miscellaneous Materials

   C. Procedure

      NOTE: The co-axial bushings must be replaced in full sets so that the machined bushing bores will be aligned.

      (1) Remove the bushings (65, 70, 80, 85, 90, 95), and the spacer (75), if applicable, from the link (100, 105).

      (2) Install the new bushings with sealant. Use the shrink-fit procedure. Refer to SOPM 20-50-03.

      (3) Install the replacement spacer (75) with sealant applied as a fay surface seal. Install the bushing (70). Make sure that there is no sealant on the outer face of the spacer after the bushing (70) is installed. Refer to Fig. 601.

(4) Machine the bushing bores to the dimensions shown in Fig. 601.

(5) Fillet seal the bushing flanges with sealant.

3. Lube Fitting Replacement

A. Consumable Materials

NOTE: Equivalent material can be used.

(1) D00633 Grease -- BMS 3-33 (SOPM 20-60-03)

B. References

(1) SOPM 20-60-03, Lubricants

C. Procedure (Fig. 601)

(1) Remove the lube fitting (60).

(2) Apply grease to the threads of the replacement lube fitting. Install the lube fitting and tighten it to 25-30 pounds of torque.

(3) Apply grease to the lube fitting until you can see the grease flow, to make sure that the lube passage is clean.

4. Link Assembly (50) Refinish

A. Consumable Materials

NOTE: Equivalent material can be used.

(1) C00032 Enamel -- BMS 10-60, Type 1 (SOPM 20-60-02)

(2) C00259 Primer -- BMS 10-11, Type 1 (SOPM 20-60-02)

B. References

(1) SOPM 20-30-02, Stripping of Protective Finishes

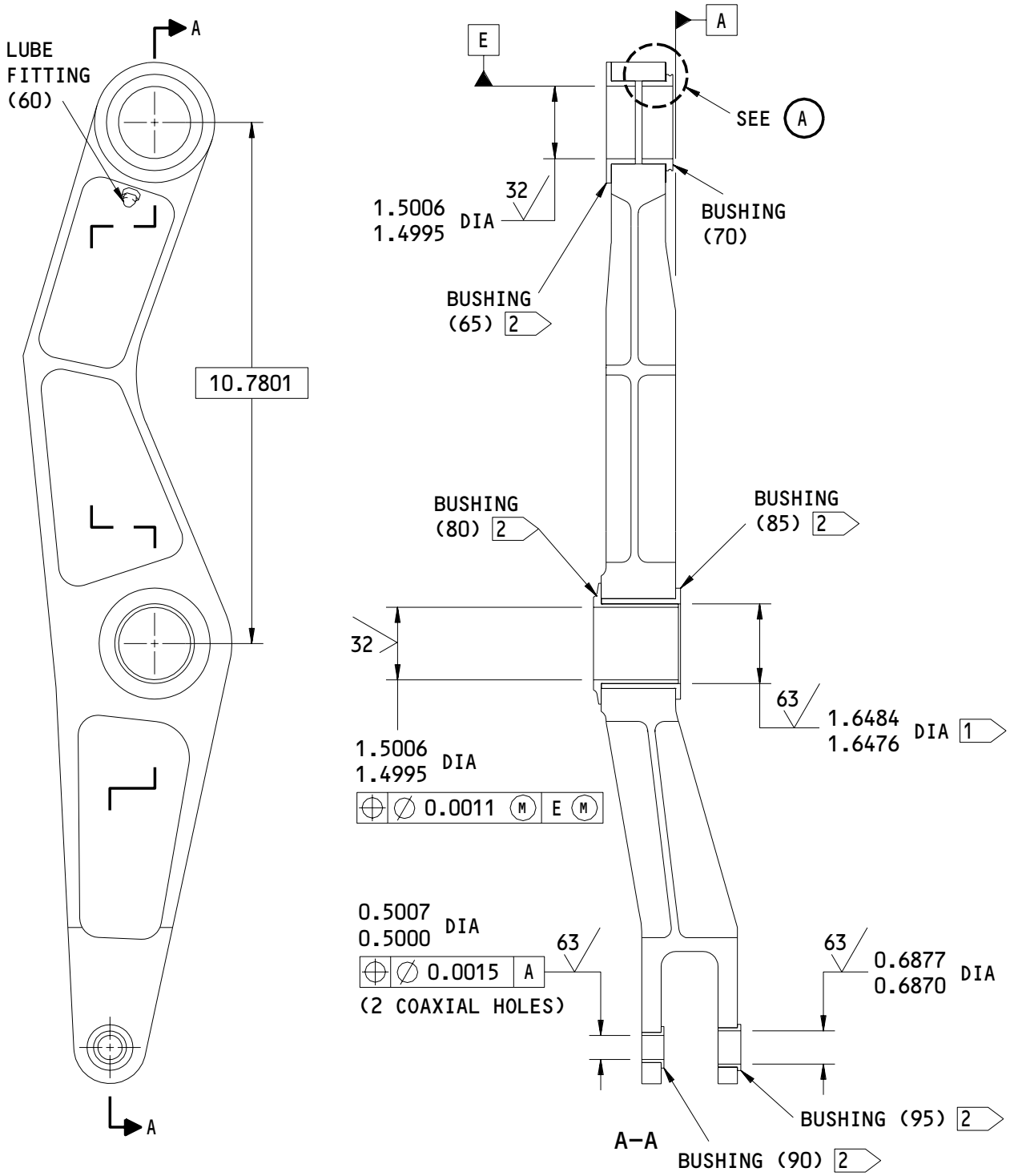
(2) SOPM 20-41-01, Decoding Table For Boeing Finish Codes

(3) SOPM 20-41-02, Application of Chemical and Solvent Resistant Finishes

(4) SOPM 20-60-02, Finishing Materials

C. Procedure (Fig. 601)

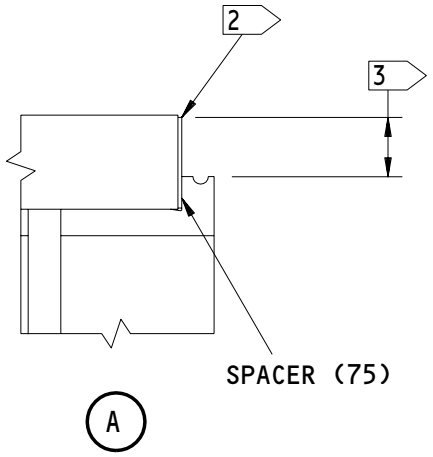
(1) Apply BMS 10-11, type 1 primer (F-14.995, which replaces SRF-14.995), then apply BMS 10-60 enamel (F-14.9813, which replaces SRF-14.9813). Do not apply primer or enamel on the bushing flanges, bushing bores, spacer (75), lube fitting (60), or the lubrication holes.



113T2066–41 SHOWN
113T2066–42 OPPOSITE

113T2066–41,–42
6–11 Link Assembly Repair
Figure 601 (Sheet 1)

L04053



1 INNER DIAMETER OF BUSHING (85)

2 FILLET SEAL THE BUSHING FLANGE

3 NO SEALANT IN THIS AREA OF THE SPACER

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

113T2066-41,-42
6-11 Link Assembly Repair
Figure 601 (Sheet 2)

6-11 LINK - REPAIR 8-2

113T2066-43, 44

1. General

A. This procedure has the data necessary to repair and refinish the 6-11 link (100, 105).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for details of the SOPM chapters identified in this procedure.

C. Refer to the REPAIR - GENERAL (27-52-86/601, REPAIR - GENERAL) for the Standard True Position Dimensioning Symbols shown in the repair.

D. Refer to IPL Fig. 1 for the item numbers.

E. General repair details:

(1)	Material:	Aluminum alloy
(2)	Shot peen:	All repaired surfaces Shot size: Refer to SOPM 20-10-03 Intensity 0.008A Coverage 2.0

2. Bushing Hole Repair

A. References

(1) SOPM 20-10-03, Shot Peening

(2) SOPM 20-10-04, Grinding of Chrome Plated Parts

(3) SOPM 20-20-01, Magnetic Particle Inspection

(4) SOPM 20-20-02, Penetrant Methods of Inspection

(5) SOPM 20-41-01, Decoding Table for Boeing Finish Codes

(6) SOPM 20-42-03, Hard Chrome Plating

(7) SOPM 20-42-05, Bright Cadmium Plating

B. Procedure

(1) Machine the link as necessary to remove defects. Do not machine the bushing hole more than the repair limit shown in Fig. 601.

(2) Break all sharp edges.

(3) Do a penetrant check of the link. Refer to SOPM 20-20-02.

(4) Shot peen the machined area. Refer to SOPM 20-10-03.

(5) Make the oversized bushing. Refer to Fig. 602.

(a) Bushing material:

1) Bushing (65, 70, 95) -- Al-Ni-Bronze, AMS 4640 (AMS 4880 optional for bushing (65, 70) only)

2) Bushing (85, 90) -- 15-5PH CRES, 180-200 ksi (17-7PH CRES optional for bushing (90) only)

(b) Break all sharp edges.

(c) Do a magnetic particle check of the oversized bushing (85, 90). Refer to SOPM 20-20-01.

(d) Cadmium plate (F-15.06) the oversized bushing (65, 70, 85) on the surfaces shown on Fig. 603. Plating is optional on the other surfaces.

(e) On bushing (70) only, chrome plate (F-15.03) the outer face of the flange. Grind to 0.0005-0.0010 inch thickness, with 32 microinch surface finish. Refer to SOPM 20-10-04.

(f) Cadmium plate (F-15.06) or zinc-nickel plate (AMS 2417, type 2) the oversized bushing (90, 95) all over. Plating is optional in the bore, or plating can run out in the bore.

(6) Install the oversized bushing as shown in Repair 8-1.

3. Link Refinish

A. Consumable Materials

NOTE: Equivalent material can be used.

(1) C00259 Primer -- BMS 10-11, Type 1 (SOPM 20-60-02)

B. References

(1) SOPM 20-30-02, Stripping of Protective Finishes

(2) SOPM 20-41-01, Decoding Table For Boeing Finish Codes

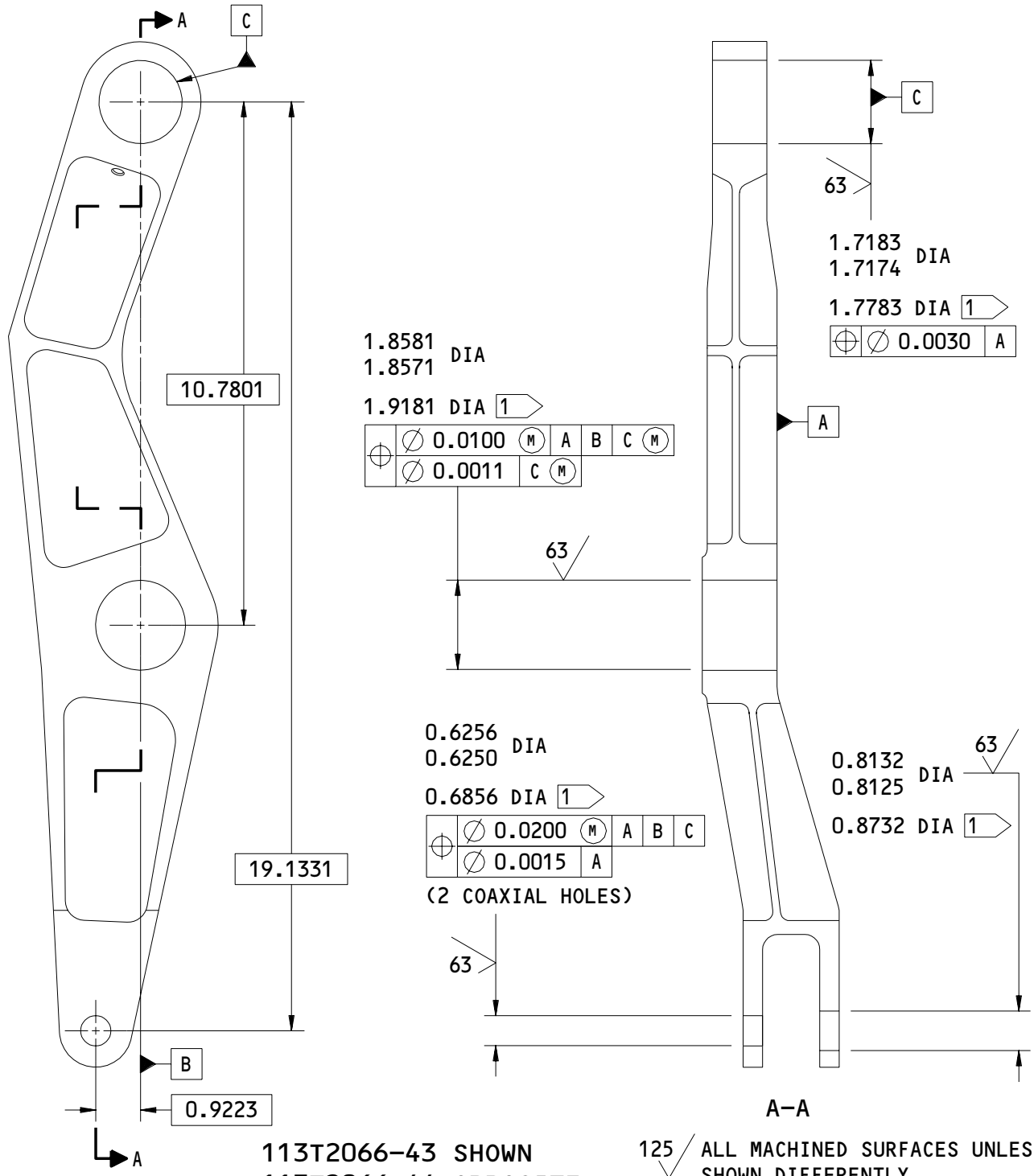
(3) SOPM 20-41-02, Application of Chemical and Solvent Resistant Finishes

(4) SOPM 20-43-01, Chromic Acid Anodizing

(5) SOPM 20-60-02, Finishing Materials

C. Procedure (Fig. 601)

(1) Link (100, 105) -- Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply BMS 10-11, type 1 primer (F-20.02), but not on the bushing holes.



113T2066-43 SHOWN
113T2066-44 OPPOSITE

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

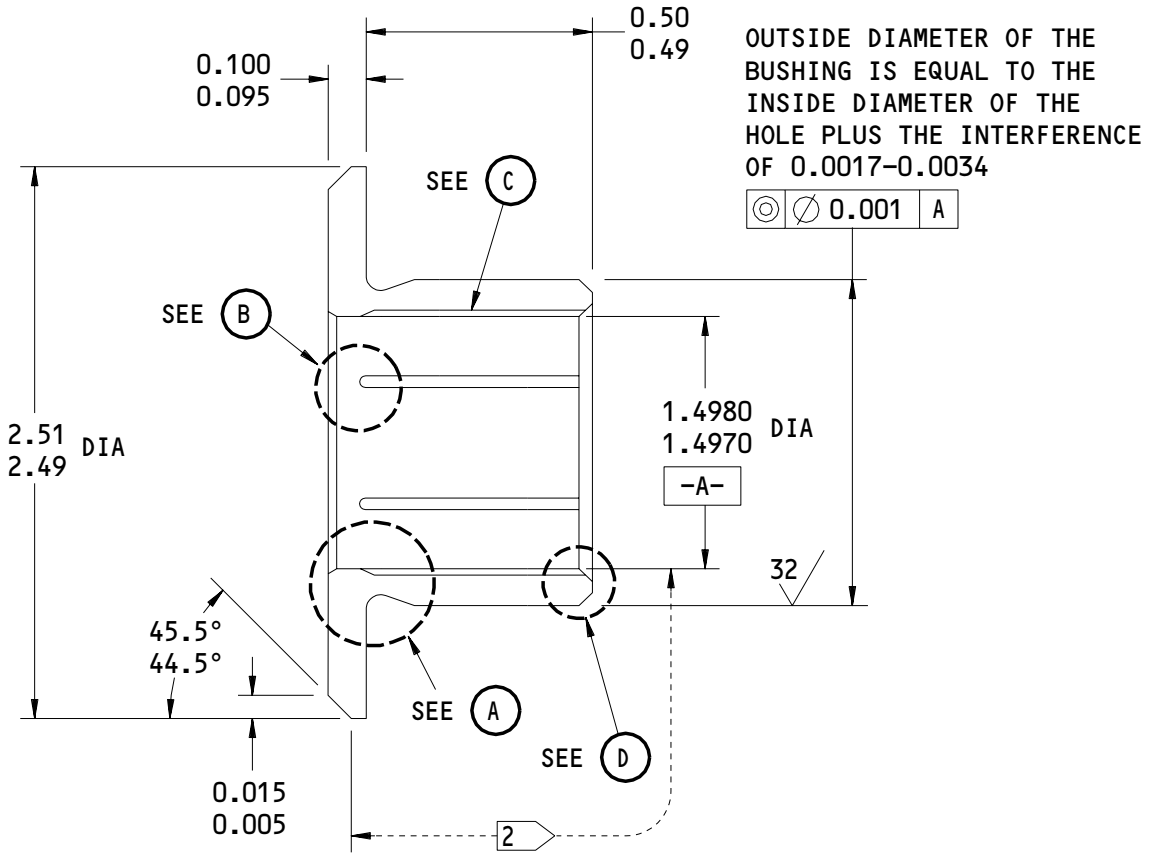
ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

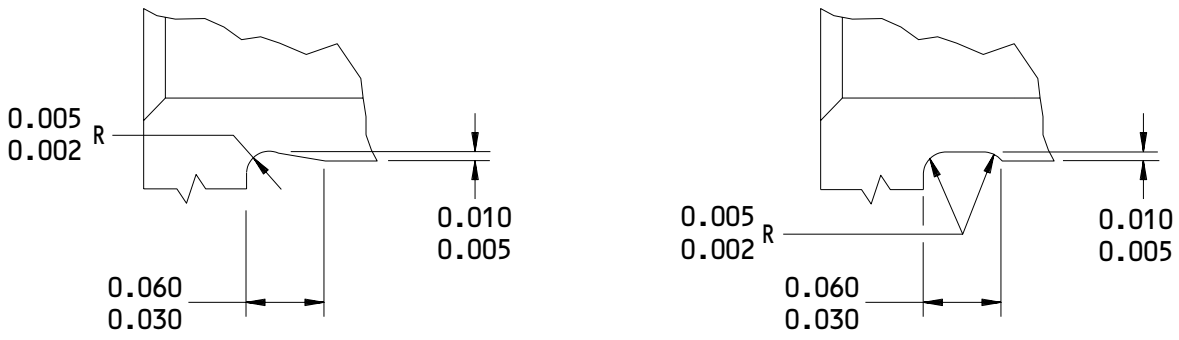
1 REPAIR LIMIT

113T2066-43,-44
6-11 Link Repair
Figure 601

L04108



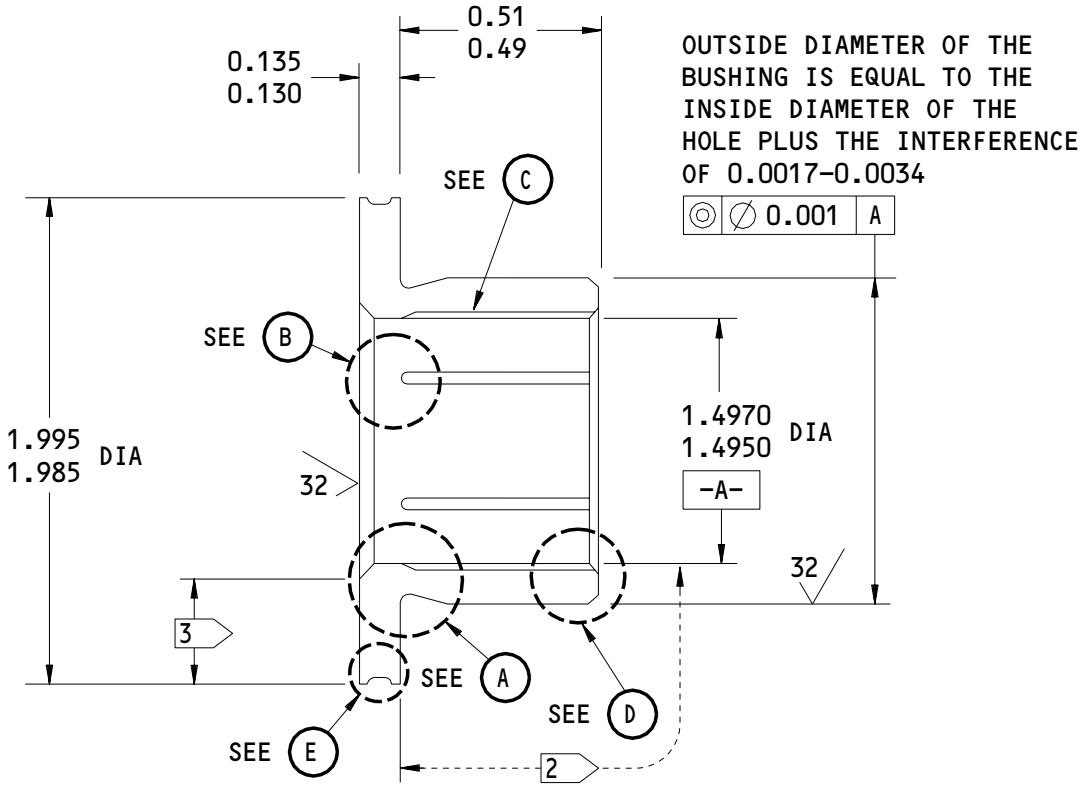
OVERSIZE REPLACEMENT FOR BUSHING (65)



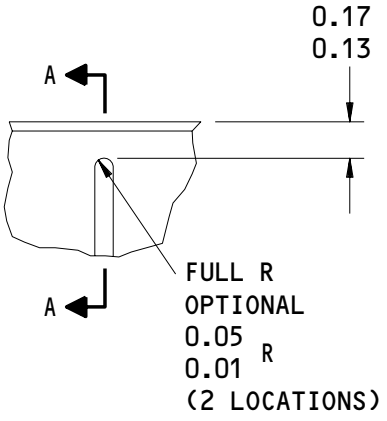
A

Oversize Bushing Details
Figure 602 (Sheet 1)

L04185

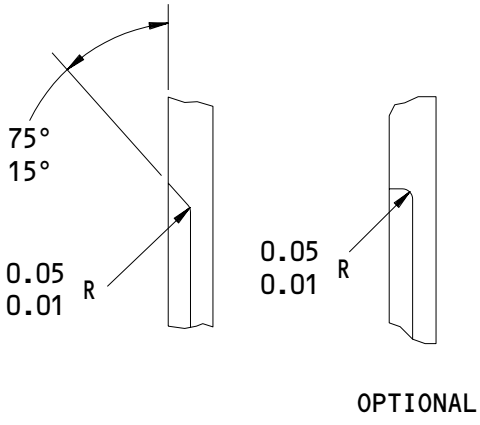


OVERSIZE REPLACEMENT FOR BUSHING (70)



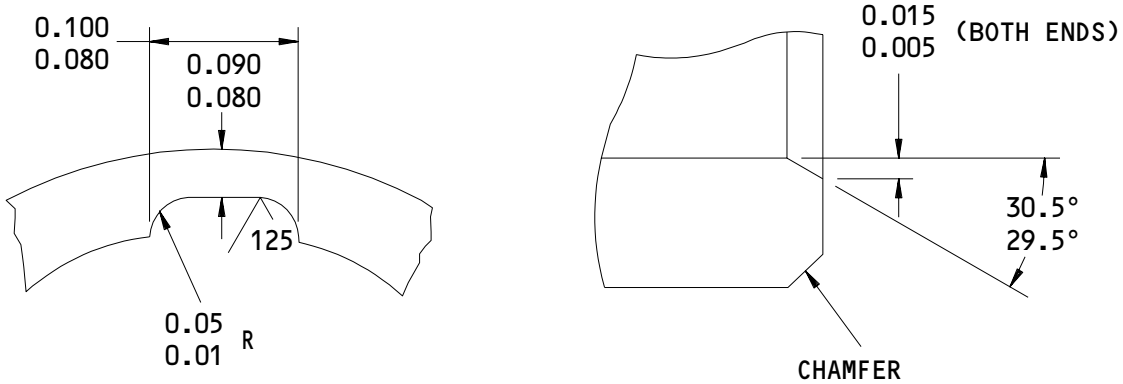
LUBE GROOVE TERMINATION

B



A-A

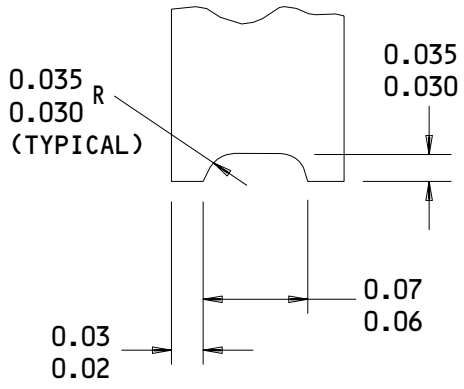
Oversize Bushing Details
Figure 602 (Sheet 2)



LUBE GROOVE DETAIL
6 GROOVES EQUALLY SPACED ON INNER FACE

C

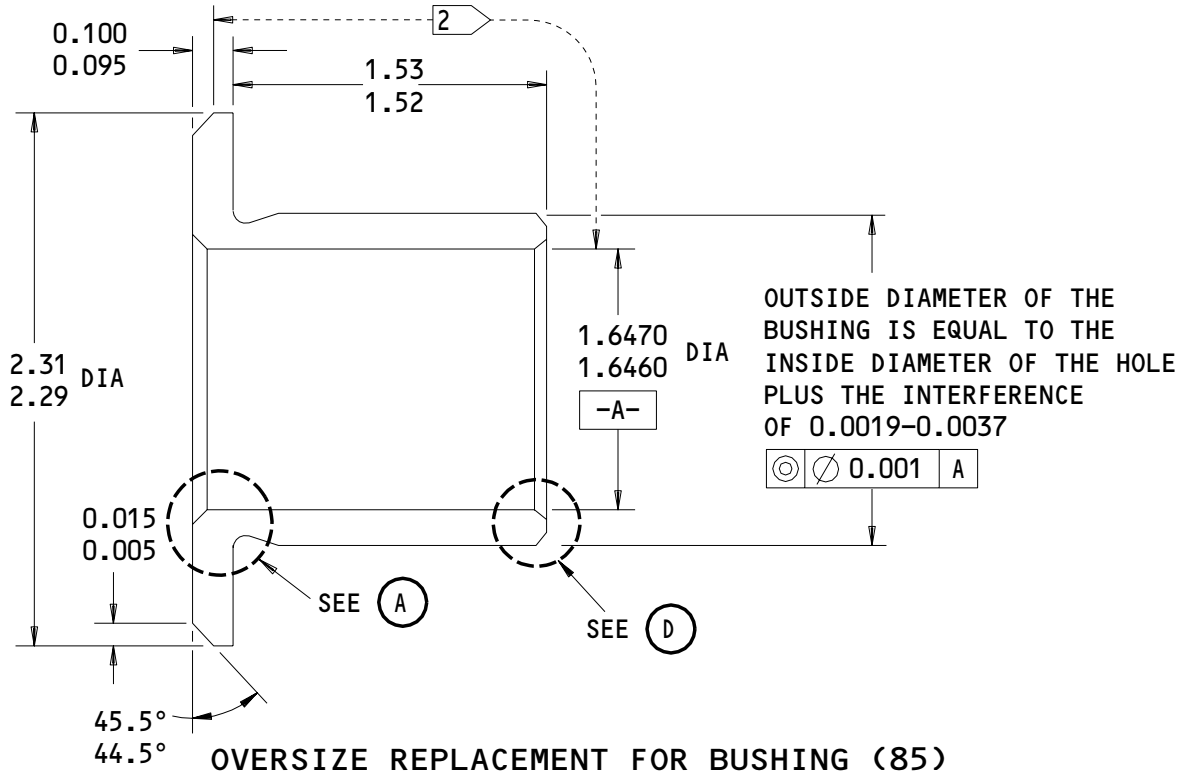
D



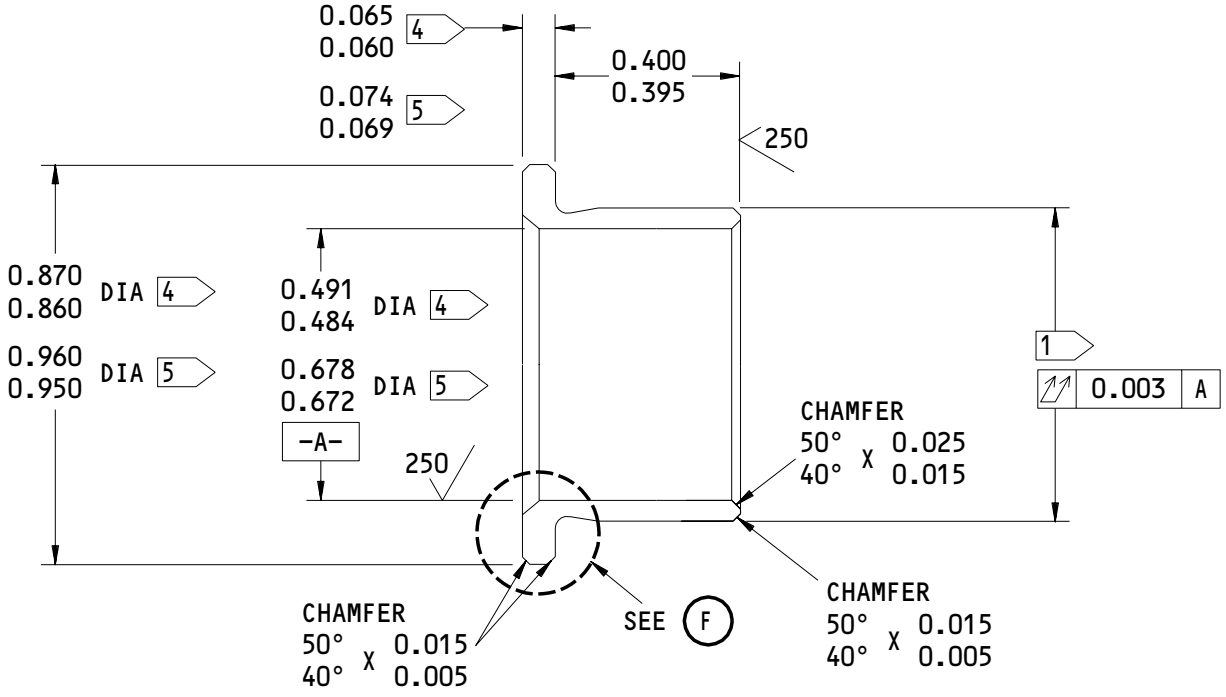
E

Oversize Bushing Details
Figure 602 (Sheet 3)

L04199

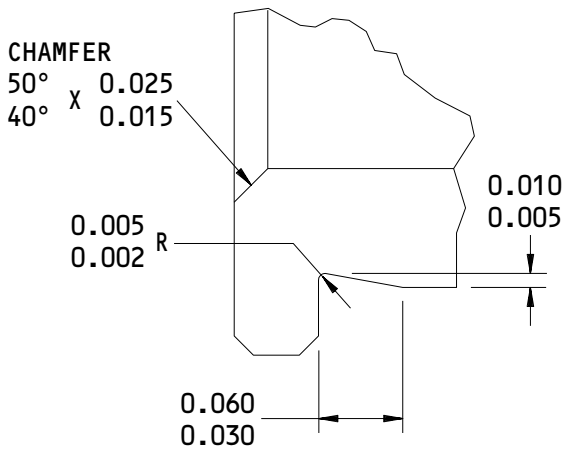


OVERSIZE REPLACEMENT FOR BUSHING (85)

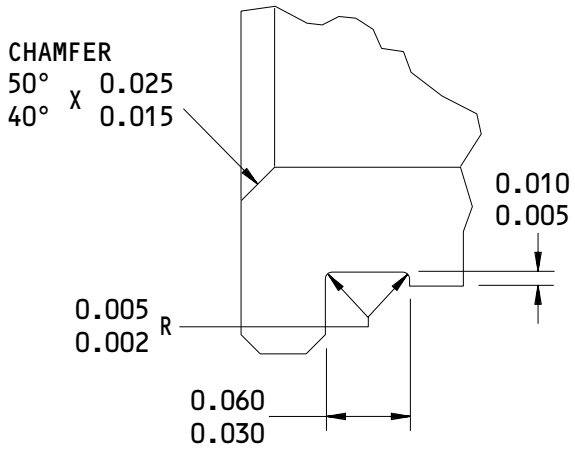


OVERSIZE REPLACEMENT FOR BUSHINGS (90,95)

Oversize Bushing Details
Figure 602 (Sheet 4)



TYPE 1



TYPE 2

(F)

1 THE OUTSIDE DIAMETERS OF BUSHINGS (90,95) ARE EQUAL TO THE INSIDE DIAMETERS OF THE HOLES IN THE LINKS, PLUS THE INTERFERENCE OF 0.0005-0.0016 FOR BUSHING (90), AND 0.0007-0.0019 FOR BUSHING (95)

2 CADMIUM PLATE THESE SURFACES. PLATING IS OPTIONAL ON ALL OTHER SURFACES

3 CHROME PLATE THIS SURFACE

4 FOR BUSHING (90)

5 FOR BUSHING (95)

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

DIMENSIONS APPLY AFTER PLATING

ITEM NUMBER REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

Oversize Bushing Details
Figure 602 (Sheet 5)

ASSEMBLY

1. General

   A. This procedure has the data necessary to assemble the linkage assembly.

   B. Refer to the Standard Overhaul Practices Manual (SOPM) for details of the SOPM chapters identified in this procedure.

   C. Refer to IPL Fig. 1 for the item numbers.

2. Assembly

   A. Consumable Materials

      NOTE: Equivalent material can be used.

      (1) D00633 Grease - BMS 3-33 (SOPM 20-60-03)

      (2) G02436 Lockwire - MS20995NC40

   B. References

      (1) SOPM 20-50-01, Bolt and Nut Installation

      (2) SOPM 20-50-02, Installation of Safetying Devices

      (3) SOPM 20-60-03, Lubricants

   C. Procedures (Fig. 701)

      (1) Use standard industry procedures and the steps shown below to assemble this component.

      (2) Procedures at Joint 2

         (a) Adjust the thickness of the laminated washer (135) so there is a gap of 0.005-0.025 inch along the shank of the outer pin (145). Make sure that the pin can move freely in the joint.

         (b) Tighten the special nut (125) to 1500-2000 pound-inches.

         (c) Tighten the nut (115) to 600-1000 pound-inches.

(3) Procedures at Joint 3

(a) Tighten the special nut (170) to 2000-3000 pound-inches.

(b) Tighten the nut (160) to 800-1500 pound-inches.

(4) Procedures at Joint 7

(a) Tighten the special nut (425) to 2000-3000 pound-inches.

(b) Tighten the nut (415) to 800-1500 pound-inches.

(5) Procedures at Joint 8

(a) Adjust the thickness of the laminated washer (135) so there is a gap of 0.005-0.025 inch along the shank of the outer pin (145). Make sure that the pin can move freely in the joint.

(b) Tighten the special nut (25) to 1500-2000 pound-inches.

(c) Tighten the nut (15) to 600-1000 pound-inches.

(6) Procedures at Joint 9

(a) Tighten the special nut (515) to 3000-3700 pound-inches.

(b) Tighten the nut (500) to 800-1500 pound-inches.

(7) Procedures at Joint 10

(a) Tighten the special nut (345) to 2000-3000 pound-inches.

(b) Tighten the nut (335) to 800-1500 pound-inches.

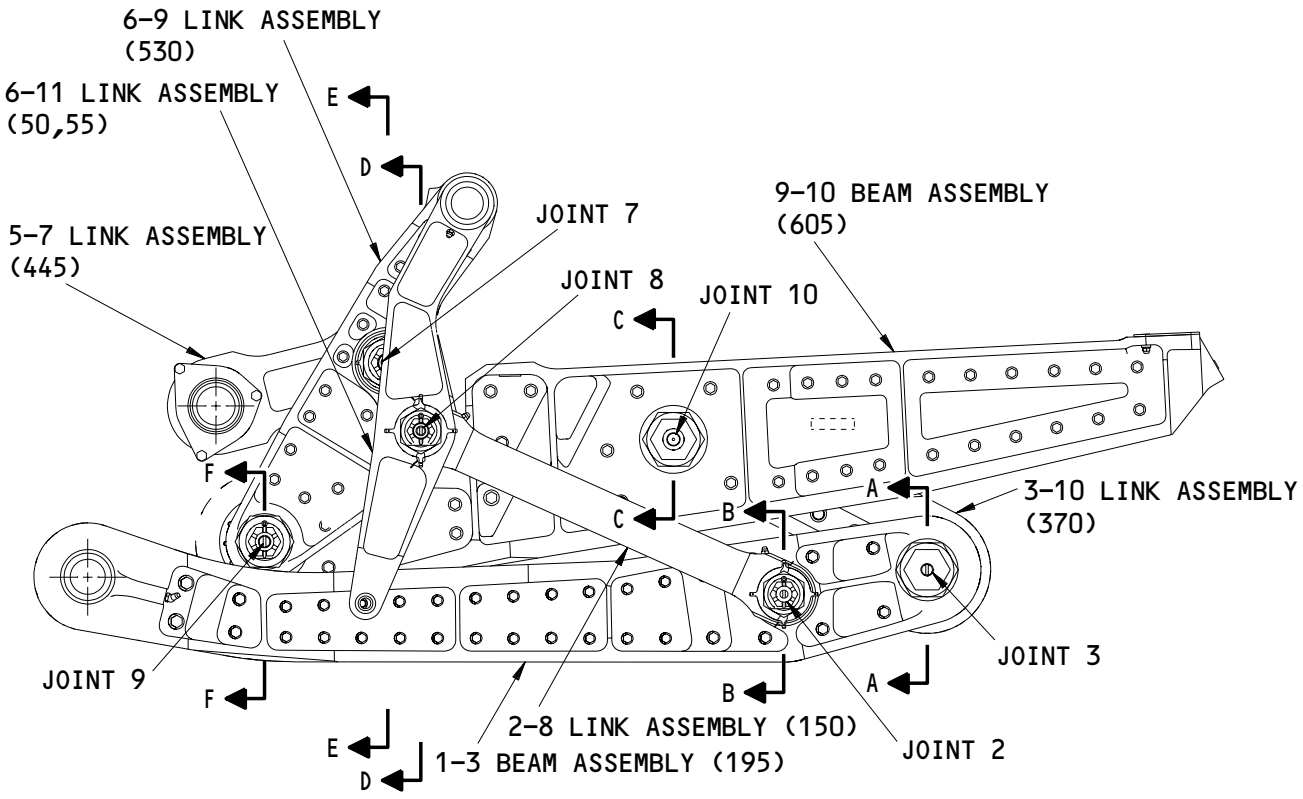
(c) Install the bolt (320), washer (325) and nut (330) through the nut (335) and the inner pin (360).

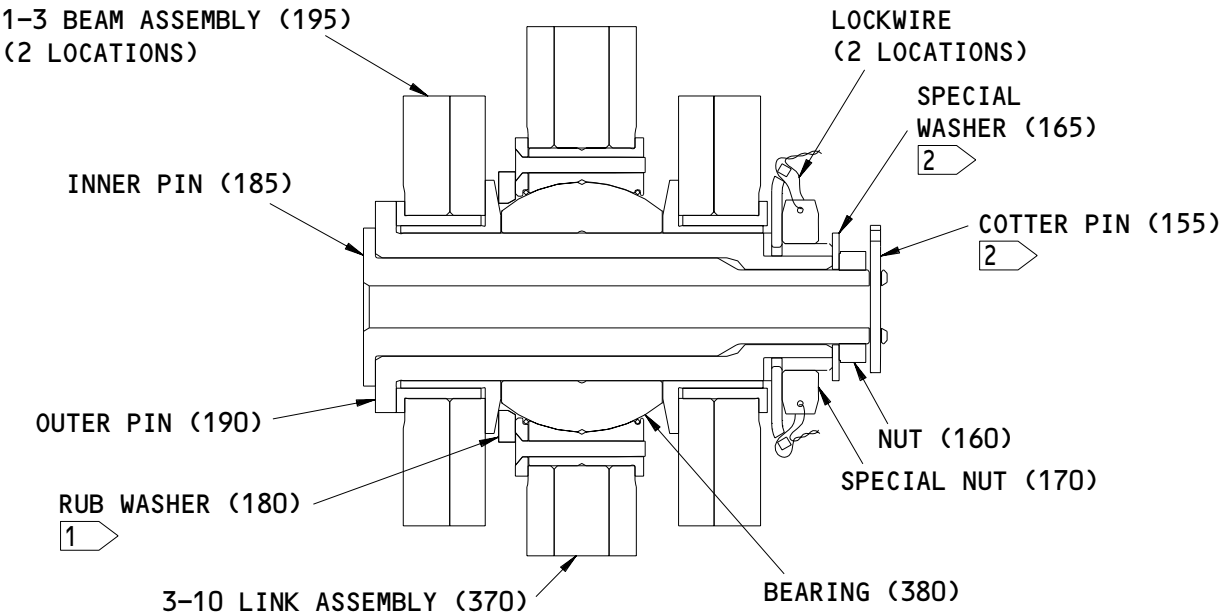
(d) Tighten the nut (330) until it is against the surface of the nut (335). Make sure that you can see two or more threads at the end of the bolt (320).

(8) Install the cotter pins (10, 110, 155, 410, 495) through the nuts (15, 115, 160, 415, 500) as shown in Fig. 701. Refer to SOPM 20-50-02.

(9) Install lockwire between the special nuts (25, 125, 170, 345, 425, 515) and the special washers (30, 130, 175, 350, 430, 520) as shown in Fig. 701. Refer to SOPM 20-50-02.

(10) Lubricate the joints through the lube fittings (60, 200, 205, 375, 450, 535, 610) with grease. Apply the grease until you can see the grease at the exits of the lube holes.

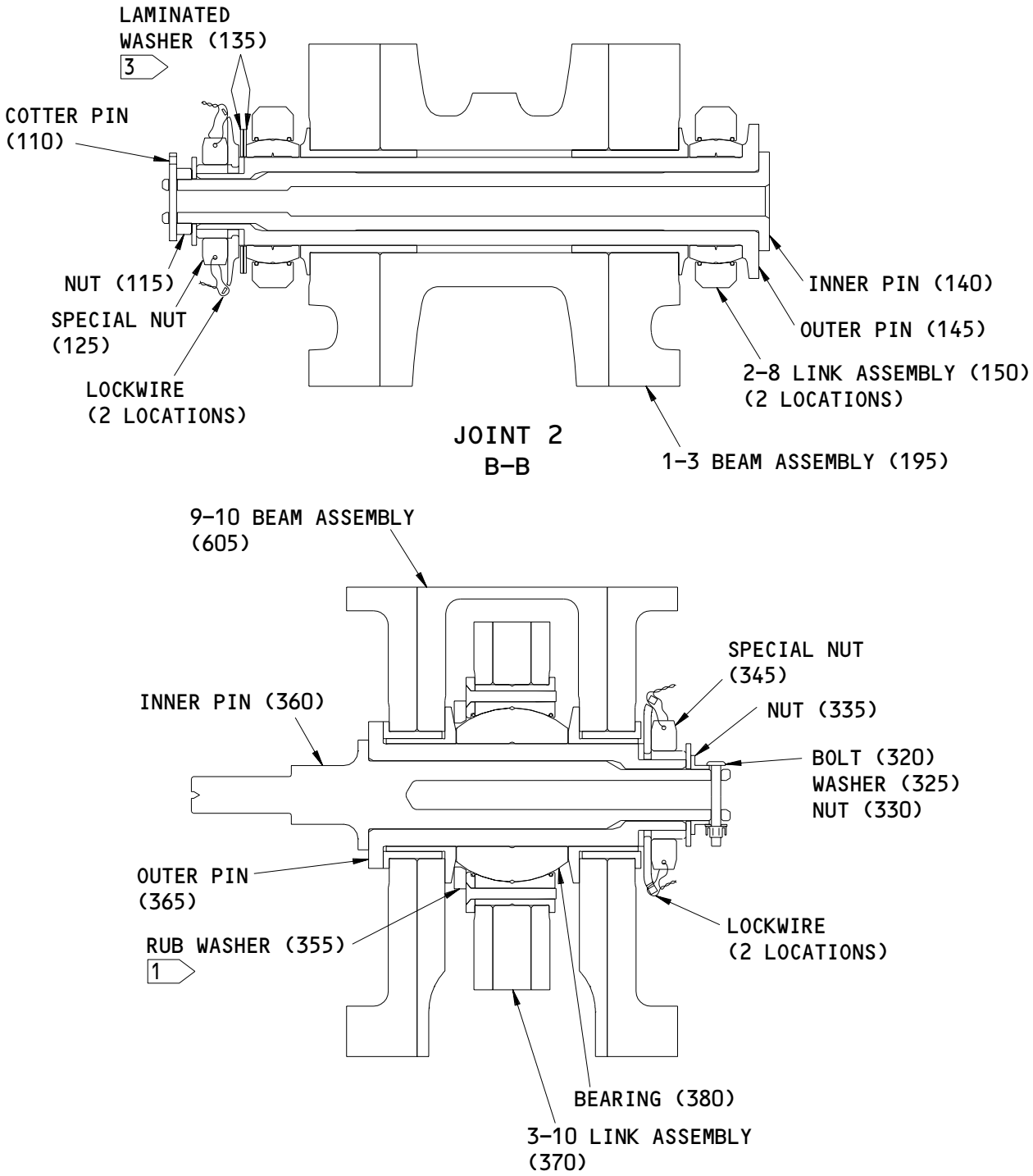




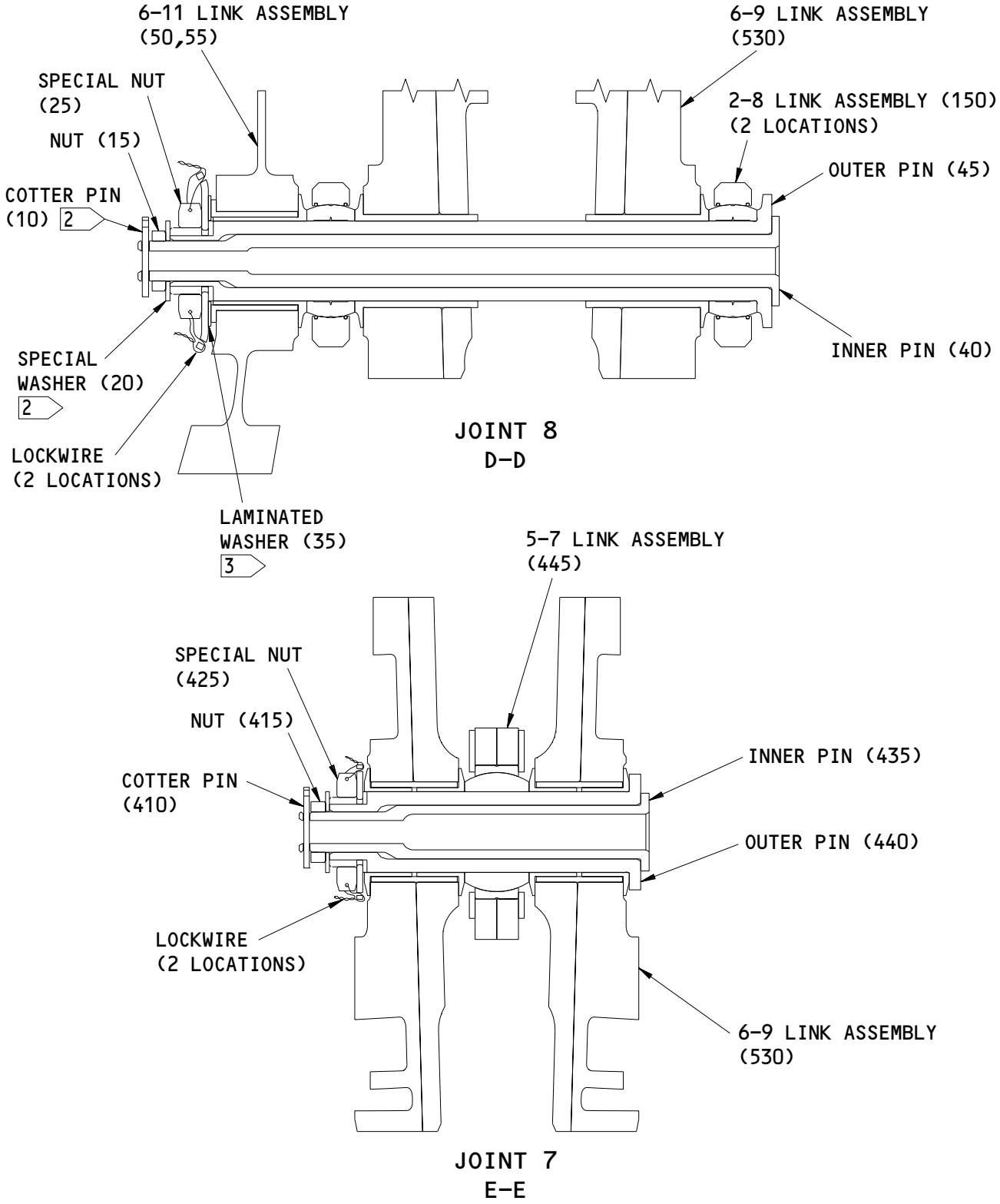
JOINT 3
A-A

Assembly Details
Figure 701 (Sheet 1)

L04068



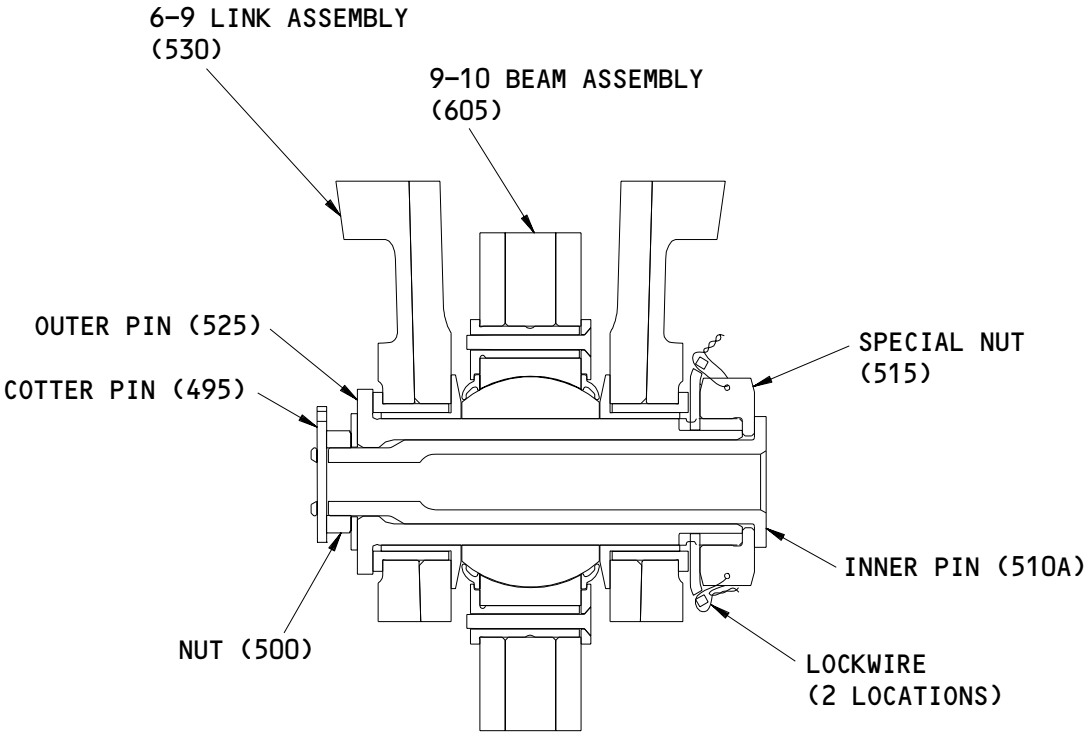
Assembly Details
Figure 701 (Sheet 2)



JOINT 8
D-D

JOINT 7
E-E

Assembly Details
Figure 701 (Sheet 3)



JOINT 9
F-F

1 INSTALL THE RUB WASHER ON THE SIDE OF THE BEARING NEAREST TO THE HEADS OF THE PINS

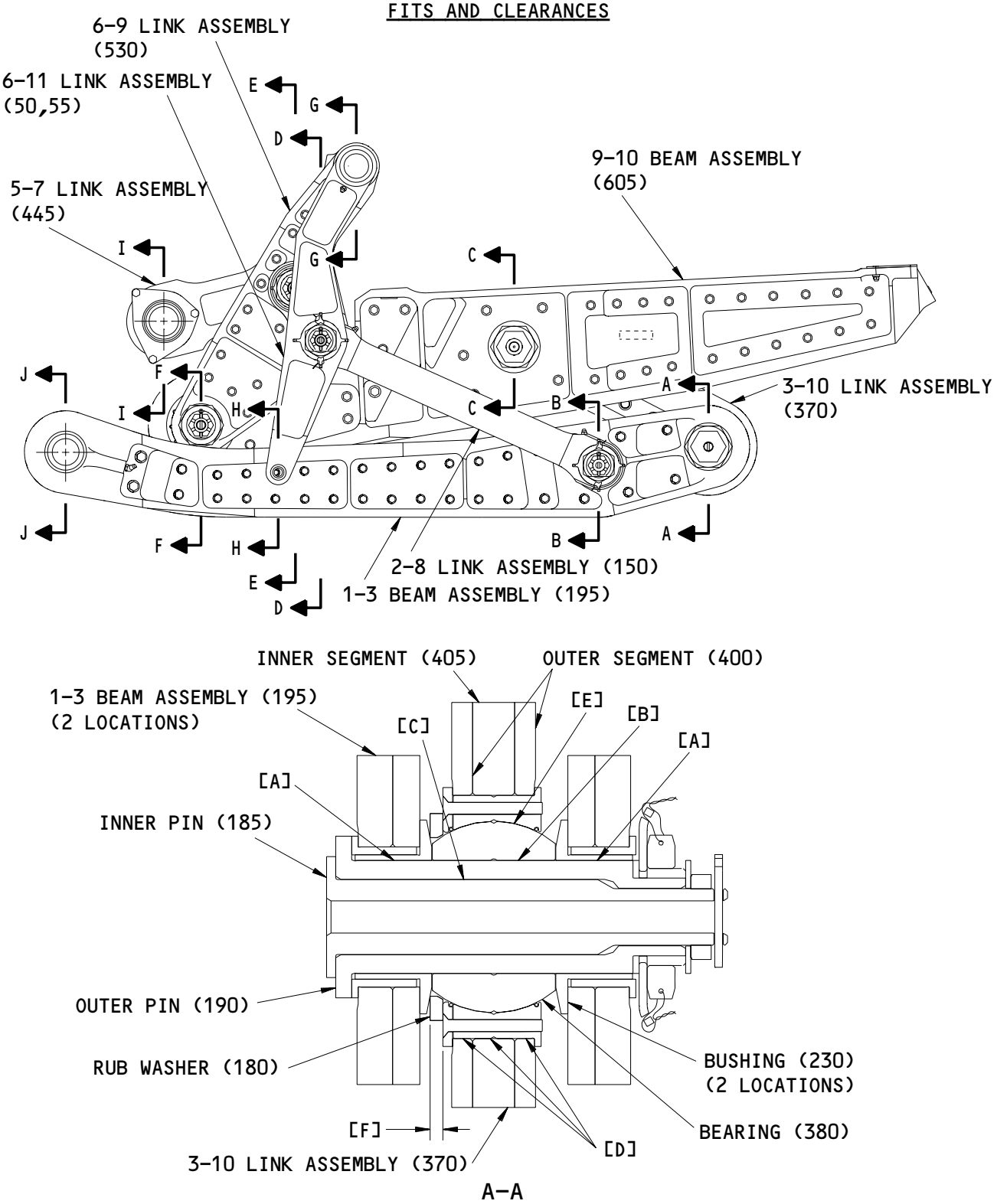
2 INSTALL ONE MORE WASHER IF NECESSARY TO ALIGN THE HOLE FOR THE COTTER PIN INSTALLATION

3 ADJUST WASHER THICKNESS TO GET A 0.005-0.0025 GAP

ITEM NUMBERS REFER TO IPL FIG. 1

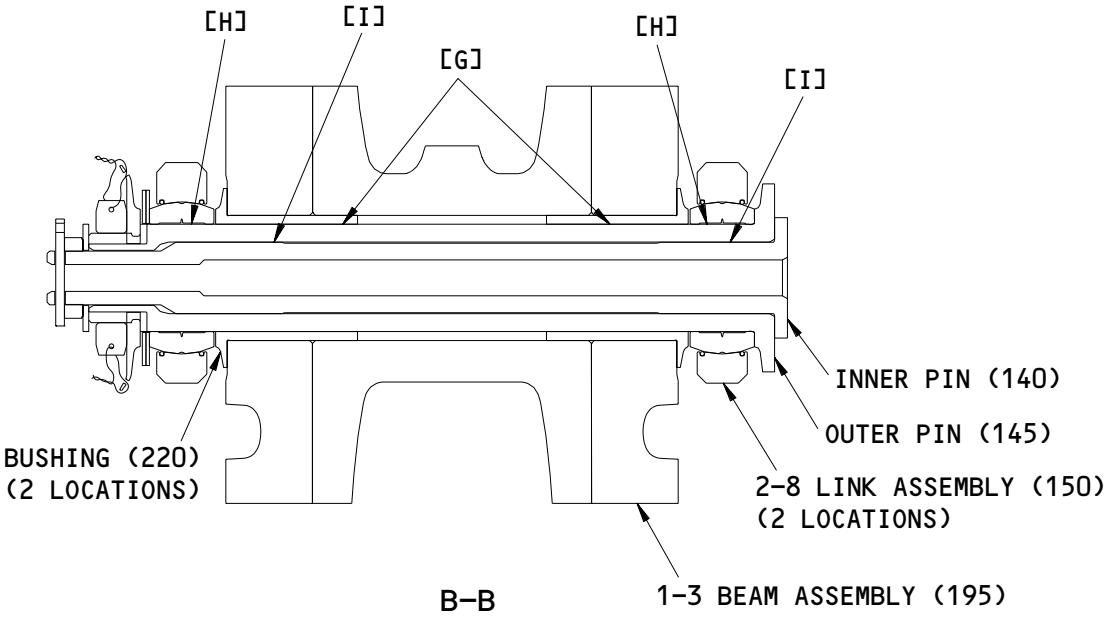
ALL DIMENSIONS ARE IN INCHES

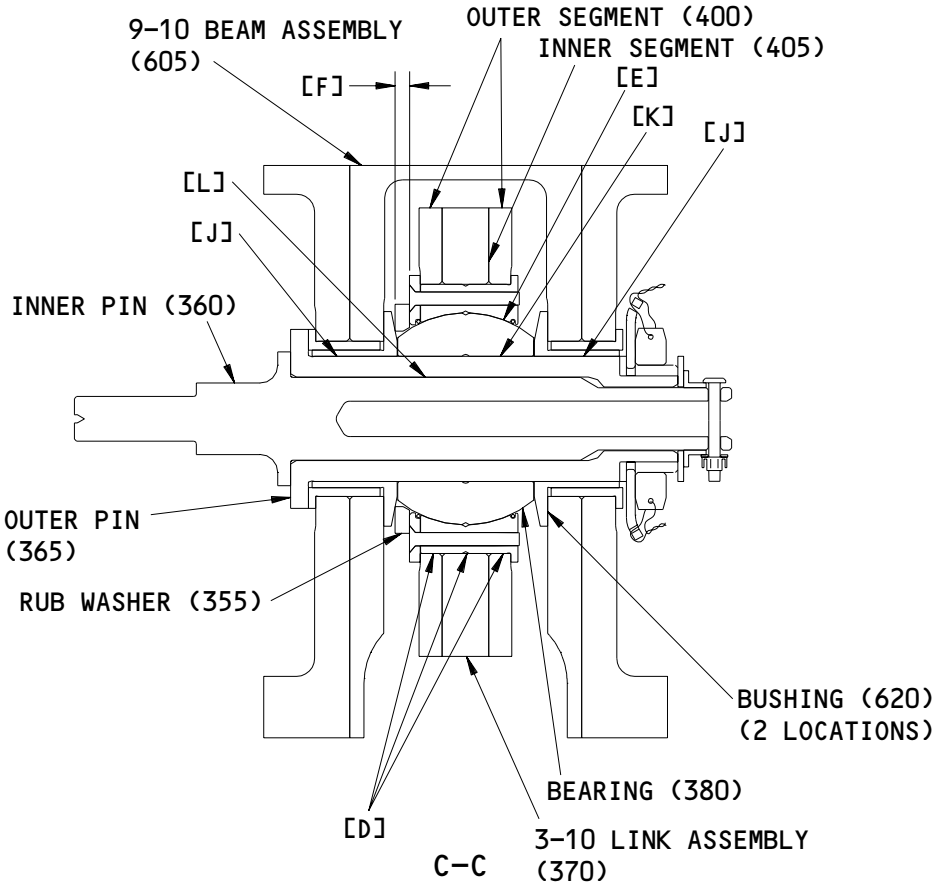
Assembly Details
Figure 701 (Sheet 4)



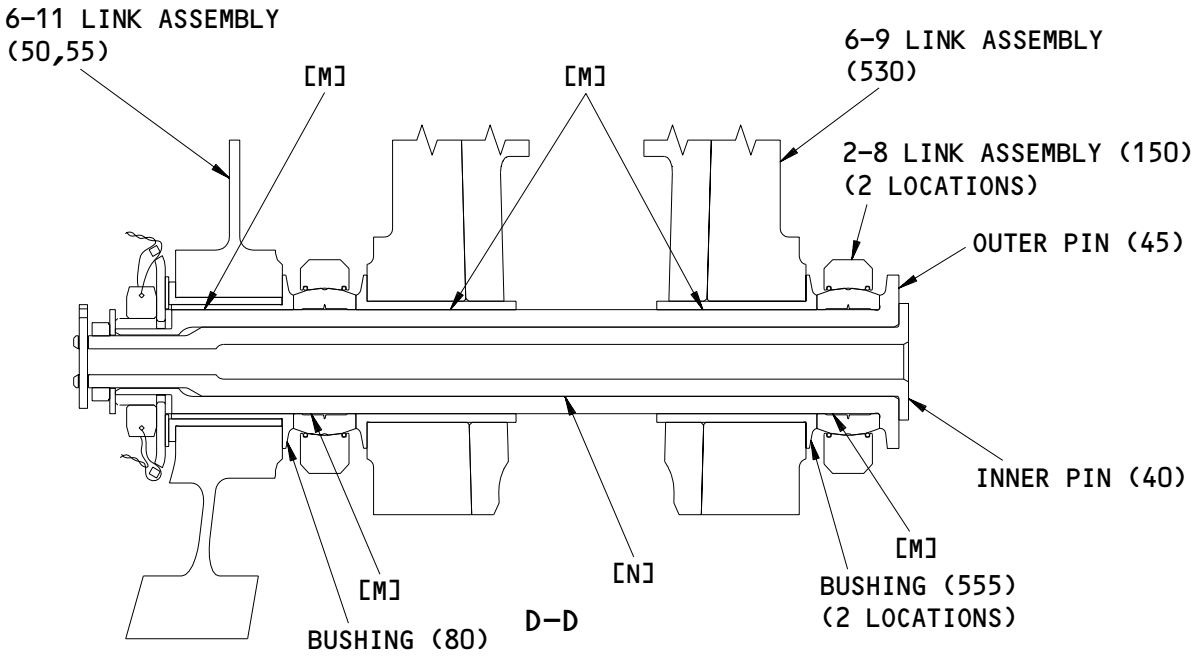
Fits and Clearances
Figure 801 (Sheet 1)

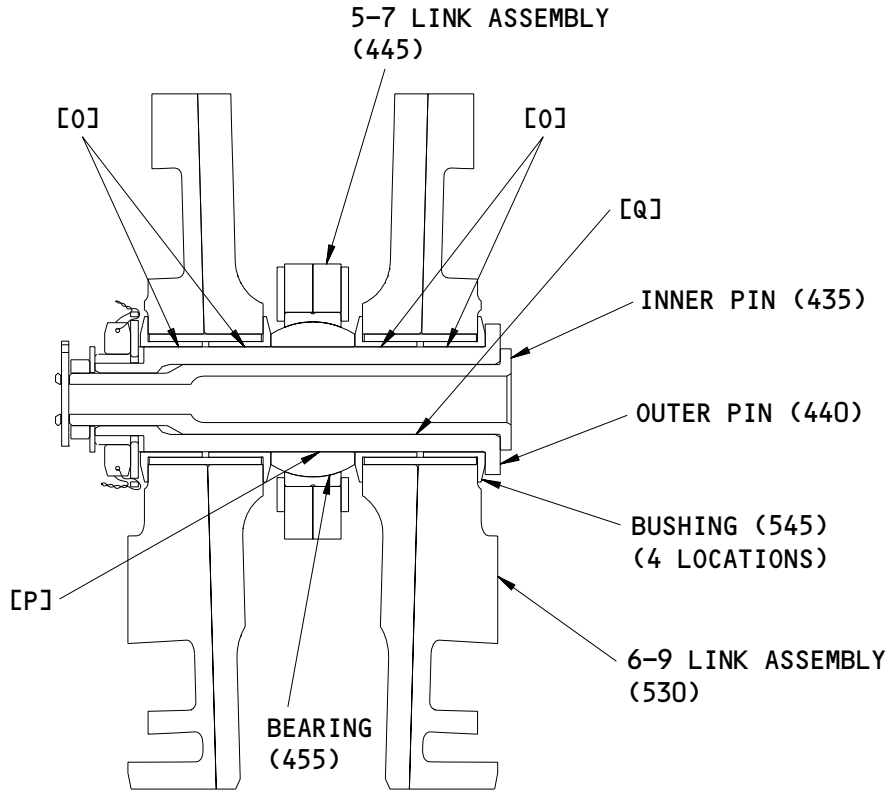
K94628





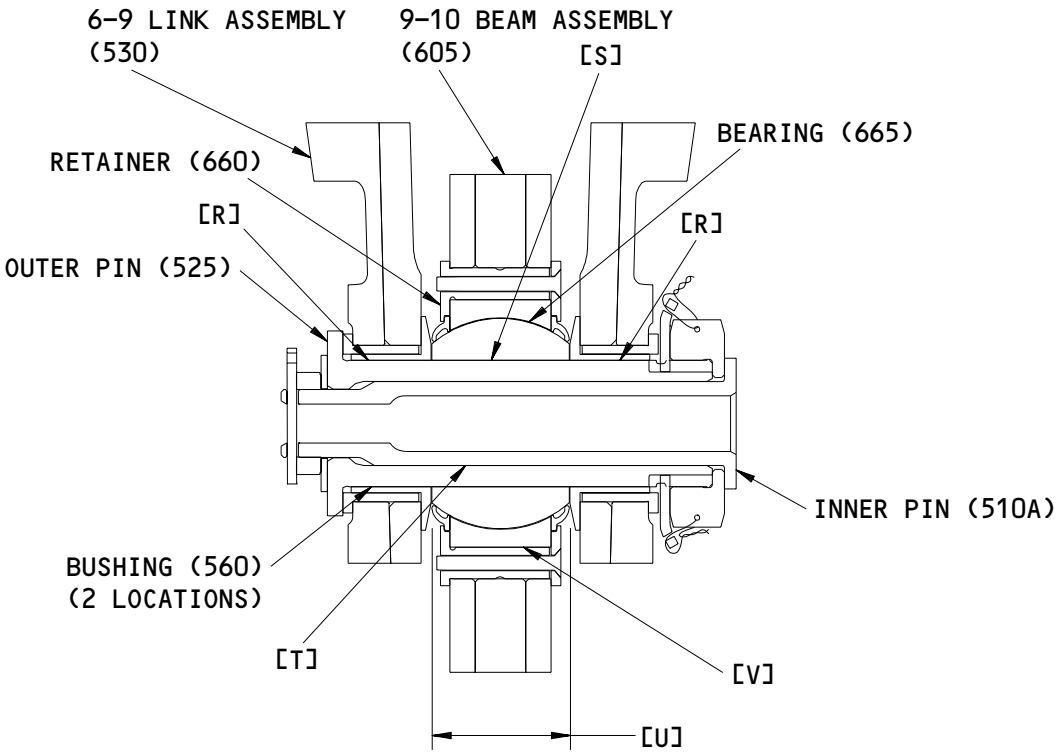
Fits and Clearances
Figure 801 (Sheet 2)



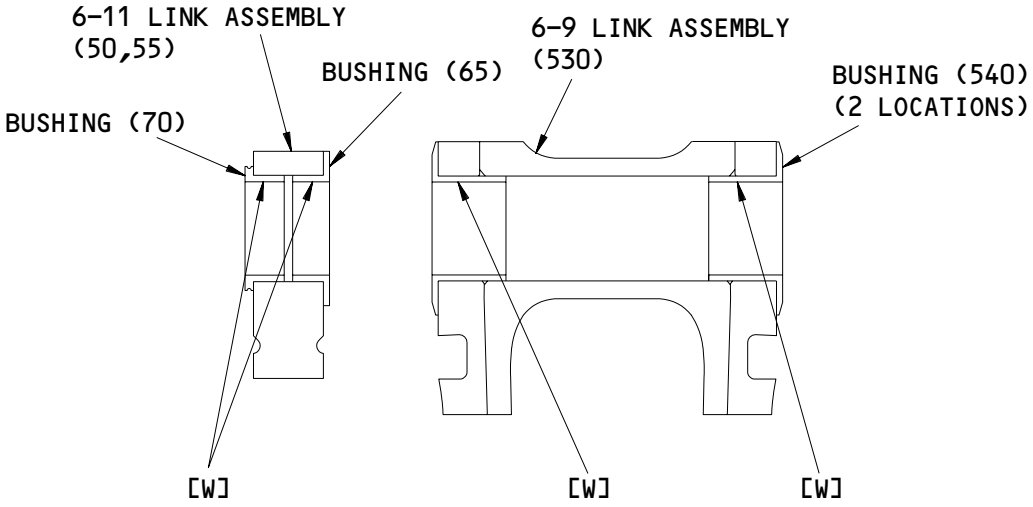


Fits and Clearances
Figure 801 (Sheet 3)

K95018



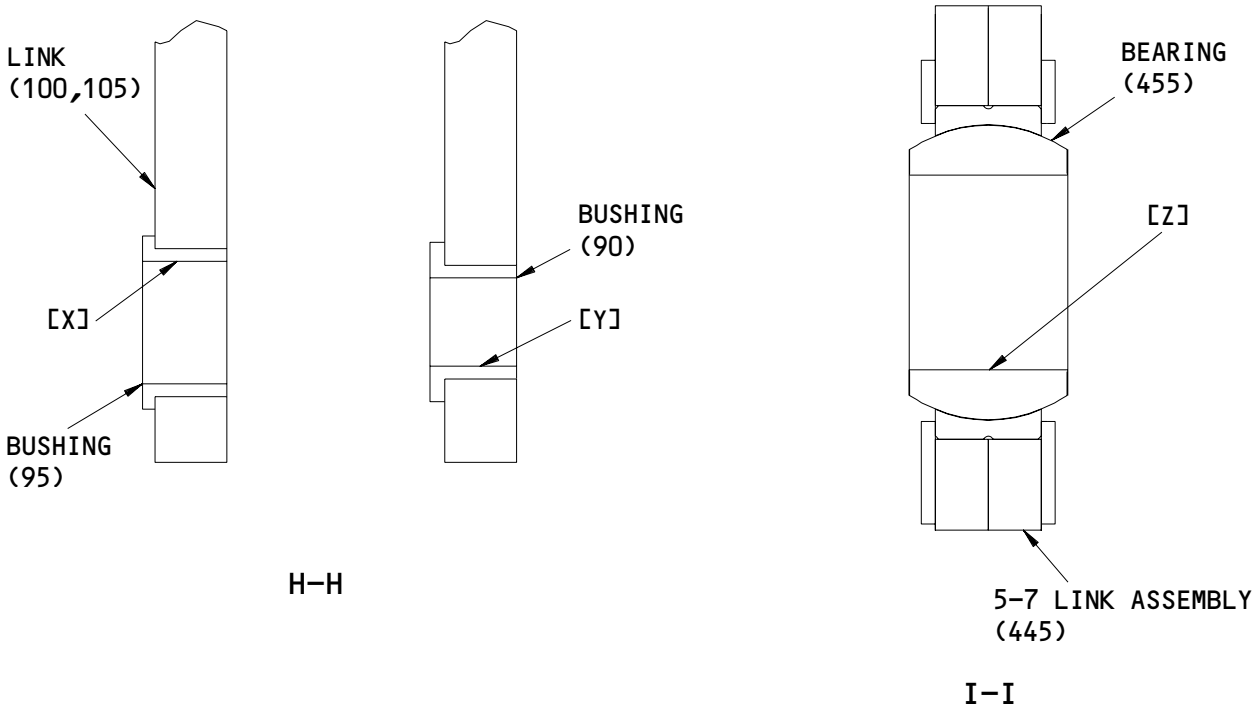
F-F

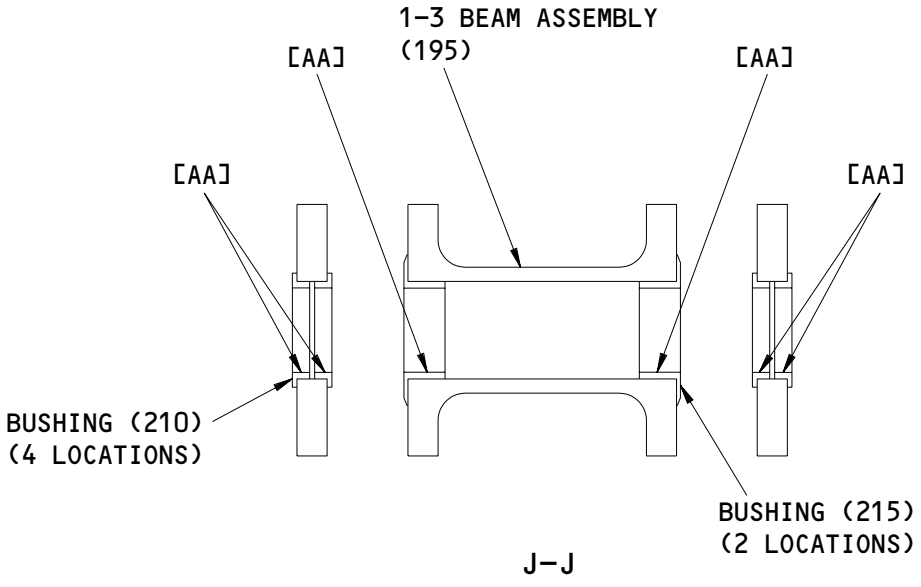


G-G

Fits and Clearances
Figure 801 (Sheet 4)

K95499





Fits and Clearances
Figure 801 (Sheet 5)

K95553

REF LETTER	REF IPL FIG. 1, MATING ITEM NO.	DESIGN DIMENSION* DIMENSION MIN	DESIGN DIMENSION* DIMENSION MAX	DESIGN DIMENSION* ASSEMBLY CLEARANCE MIN	DESIGN DIMENSION* ASSEMBLY CLEARANCE MAX	SERVICE WEAR LIMIT* DIMENSION MIN	SERVICE WEAR LIMIT* DIMENSION MAX	SERVICE WEAR LIMIT* MAXIMUM CLEARANCE
[A]	ID 230 OD 190	1.7496 1.7484	1.7506 1.7490	0.0006	0.0022	1.7401	1.7585	0.0095
[B]	ID 380 OD 190	1.7495 1.7484	1.7505 1.7490	0.0005	0.0021	1.7400	1.7585	0.0095
[C]	ID 190 OD 185	1.1630 1.1590	1.1660 1.1610	0.0020	0.0070	1.1560	1.1680	0.0070
[D]	ID 400,405 OD 380	3.7600 3.7590	3.7610 3.7600	0.0000	0.0020	3.7450	3.7750	0.0150
[E]	ID 380 1 OD 380 1	2.9625 2.9605	2.9635 2.9610	0.0015	0.0030	2.9505	2.9730	0.0120
[F]	180,355 2	0.1900	0.2100			0.1500		
[G]	ID 220 OD 145	1.4995 1.4984	1.5006 1.4990	0.0005	0.0022	1.4911	1.5074	0.0084
[H]	ID 150 OD 145	1.4995 1.4984	1.5005 1.4990	0.0005	0.0021	1.4911	1.5074	0.0084
[I]	ID 145 OD 140	1.0000 0.9970	1.0030 0.9980	0.0020	0.0060	0.9938	1.0042	0.0062
[J]	ID 620 OD 365	1.7495 1.7484	1.7506 1.7490	0.0005	0.0022	1.7400	1.7585	0.0095
[K]	ID 380 OD 365	1.7495 1.7484	1.7505 1.7490	0.0005	0.0021	1.7400	1.7585	0.0095
[L]	ID 365 OD 360	1.1630 1.1590	1.1660 1.1610	0.0020	0.0070	1.1560	1.1680	0.0070

Fits and Clearances
Figure 801 (Sheet 6)

K95639

REF LETTER	REF IPL FIG. 1, MATING ITEM NO.	DESIGN DIMENSION* DIMENSION MIN	DESIGN DIMENSION* DIMENSION MAX	DESIGN DIMENSION* ASSEMBLY CLEARANCE MIN	DESIGN DIMENSION* ASSEMBLY CLEARANCE MAX	SERVICE WEAR LIMIT* DIMENSION MIN	SERVICE WEAR LIMIT* DIMENSION MAX	SERVICE WEAR LIMIT* MAXIMUM CLEARANCE
[M]	ID 80,150,555	1.4995	1.5005	0.0005	0.0021		1.5074	0.0084
	OD 45	1.4984	1.4990			1.4911		
[N]	ID 45	1.0000	1.0030	0.0020	0.0070		1.0050	0.0070
	OD 40	0.9960	0.9980			0.9930		
[O]	ID 545	1.7495	1.7506	0.0005	0.0022		1.7585	0.0095
	OD 440	1.7484	1.7490			1.7400		
[P]	ID 455	1.7500	1.7506	0.0010	0.0022		1.7585	0.0095
	OD 440	1.7484	1.7490			1.7405		
[Q]	ID 440	1.1630	1.1660	0.0020	0.0070		1.1680	0.0070
	OD 435	1.1590	1.1610			1.1560		
[R]	ID 560	1.6245	1.6256	0.0005	0.0022		1.6329	0.0089
	OD 525	1.6234	1.6240			1.6156		
[S]	ID 665	1.6250	1.6256	0.0010	0.0022		1.6329	0.0089
	OD 525	1.6234	1.6240			1.6161		
[T]	ID 525	1.0800	1.0830	0.0020	0.0070		1.0850	0.0070
	OD 510A	1.0760	1.0780			1.0730		
[U]	560 3	1.7760	1.8060				1.8260	
[V]	ID 660	3.1820	3.1840	0.0000	0.0025		3.1970	0.0150
	OD 665	3.1815	3.1820			3.1670		
[W]	ID 65,70,540	1.4996	1.5006				1.5074	
	OD 4							
[X]	ID 95	0.6870	0.6877				0.6915	
	OD 4							

Fits and Clearances
Figure 801 (Sheet 7)

K95678

REF LETTER	REF IPL FIG. 1, MATING ITEM NO.	DESIGN DIMENSION*				SERVICE WEAR LIMIT*		
		DIMENSION		ASSEMBLY CLEARANCE		DIMENSION		MAXIMUM CLEARANCE
		MIN	MAX	MIN	MAX	MIN	MAX	
[Y]	ID 90 OD 4	0.5000	0.5007				0.5045	
[Z]	ID 455 OD 4	1.7500	0.7506				0.7585	
[AA]	ID 210,215 OD 4	1.6245	1.6256				1.6329	

*ALL DIMENSIONS ARE IN INCHES

1 SPHERICAL DIAMETER

2 THICKNESS

3 DISTANCE BETWEEN BUSHING (560) FLANGES

4 INSTALLATION PART

Fits and Clearances
Figure 801 (Sheet 8)

K95715

REF IPL		NAME	TORQUE*	
FIG. NO.	ITEM NO.		POUND-INCHES	POUND-FEET
1	60,200,205 375,535	Lube Fitting	25-30	
1	15,115	Nut	600-1000	
1	160,335 415,500	Nut	800-1500	
1	25,125	Special Nut	1500-2000	
1	170,345, 425	Special Nut	2000-3000	
1	515	Special Nut	3000-3700	
1	380	Bolt 1	20-25	
1	650	Bolt	20-25	

* REFER TO SOPM 20-50-01 FOR TORQUE VALUES OF STANDARD FASTENERS

1 PART OF BEARING (380)

Torque Table
Figure 802

K95790

ILLUSTRATED PARTS LIST

1. This section lists and illustrates replaceable or repairable component parts. The Illustrated Parts Catalog contains a complete explanation of the Boeing part numbering system.

2. Indentures show parts relationships as follows:

    Assembly
      Detail Parts for Assembly
      Subassembly
      Attaching Parts for Subassembly
        Detail Parts for Subassembly

    Detail Installation Parts (Included only if installation parts may be returned to shop as part of assembly)

3. One use code letter (A, B, C, etc.) is assigned in the EFF CODE column for each variation of top assembly. All listed parts are used on all top assemblies except when limitations are shown by use code letter opposite individual part entries.

4. Letter suffixes (alpha-variants) are added to item numbers for optional parts, Service Bulletin modification parts, configuration differences (Except left- and right-hand parts), product improvement parts, and parts added between two sequential item numbers. The alpha-variant is not shown on illustrations when appearance and location of all variants of the part is the same.

5. Service Bulletin modifications are shown by the notations PRE SB XXXX and POST SB XXXX.

    A. When a new top assembly part number is assigned by Service Bulletin, the notations appear at the top assembly level only. The configuration differences at detail part level are then shown by use code letter.

    B. When the top assembly part number is not changed by the Service Bulletin, the notations appear at the detail part level.

6. Parts Interchangeability

Optional (OPT)	The parts are optional to and interchangeable with other parts having the same item number.
Supersedes, Superseded By (SUPSDS, SUPSD BY)	The part supersedes and is not interchangeable with the original part.
Replaces, Replaced By (REPLS, REPLD BY)	The part replaces and is interchangeable with, or is an alternate to, the original part.

VENDORS

S0352 NIPPON MINIATURE BEARING CO LTD
TOKYO, JAPAN

0PTK6 SPS TECHNOLOGIES INC AEROSPACE PRODUCTS DIV
5195 W 4700 SPO BOX 18459
KEARNS, UTAH 84118

02758 NETWORKS ELECTRONIC CORP U S BEARING DIV
9750 DE SOTO AVENUE
CHATSWORTH, CALIFORNIA 91311-4409

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

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

16746 SPECLINE INCORPORATED
2230 MOUTON DR
CARSON CITY, NV 89706

17446 HUCK MFG CO GOV CONTRACTS LOS ANGELES DIV SUB OF FED-MOGUL
900 WATSON CENTER ROAD
CARSON, CALIFORNIA 90745

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

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

56878 SPS TECHNOLOGIES INC AEROSPACE AND INDUSTRIAL PRODUCTS DIV
HIGHLAND AVENUE
JENKINTOWN, PENNSYLVANIA 19046

57606 REXNORD CORP
2175 UNION PL
SIMI VALLEY, CALIFORNIA 93065-1661

VENDORS

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

73134 IMO INDUSTRIES INC HEIM BEARINGS DIV
60 ROUND HILL ROAD PO BOX 430
FAIRFIELD, CONNECTICUT 06430

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

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

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

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

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

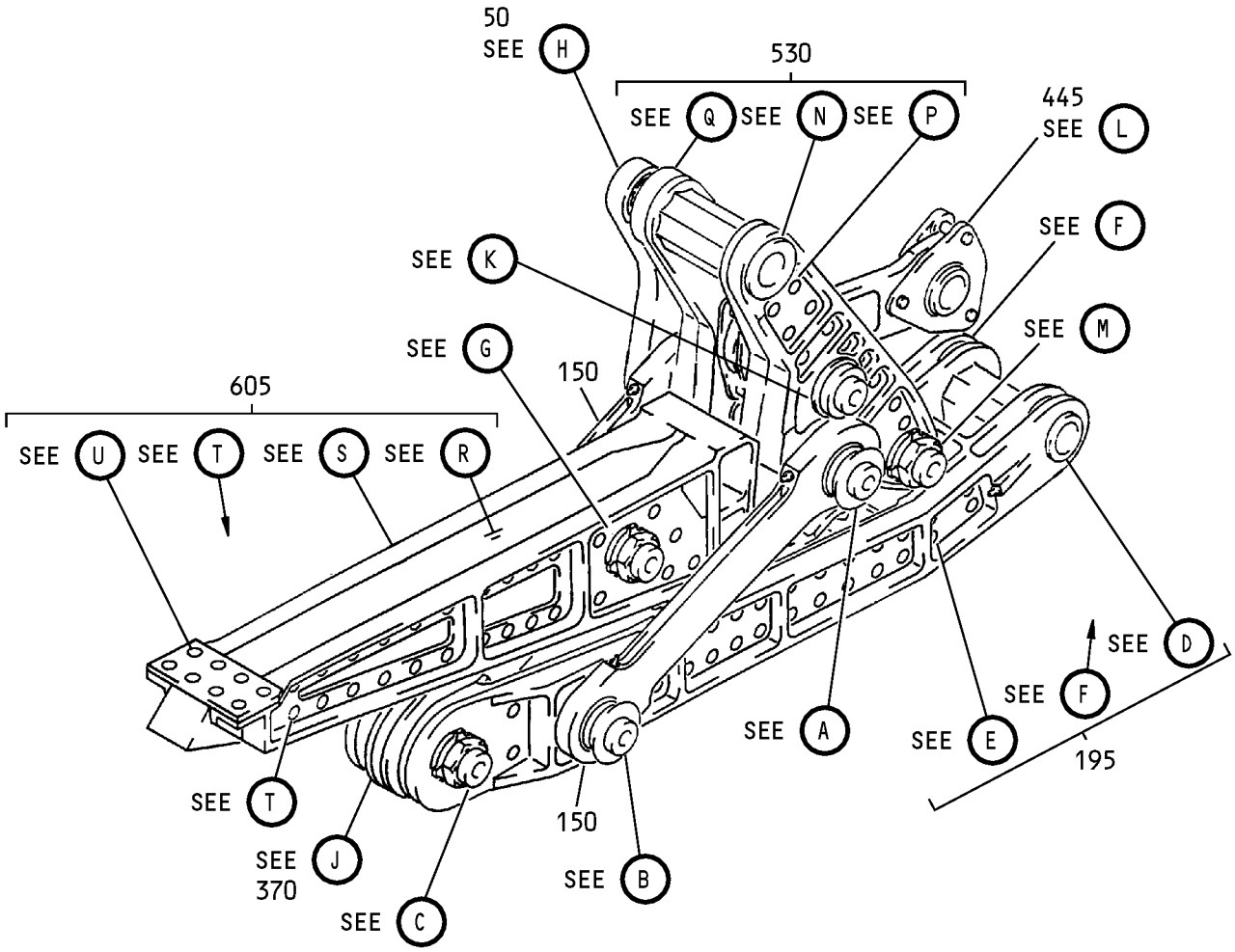
PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
ADW5V301NC		1	630	1
ASB26-103		1	665	1
ASB28-101		1	455	2
ASSB28-18		1	455	2
BACB10FA05GC		1	630	1
BACB28AP08P040		1	90	1
BACB28AT11B040C		1	95	1
BACB30LH3PU20		1	650	6
BACB30LH4PU17		1	385	4
BACB30LJ4HSU15		1	460	6
BACB30MB5A17NU		1	320A	1
BACB30MY8K8		1	480	6
BACB30NX10K6		1	695	4
BACB30NX12K15		1	250	4
BACB30NX12K16		1	260	4
		1	680	12
BACB30NX12K17		1	675	3
BACB30NX12K20		1	255	8
BACB30NX12K21		1	685	5
BACB30NX12K23		1	245	4
BACB30NX14K34		1	690	1
BACB30NX14K38		1	235	2
BACB30NX14K39		1	240	2
BACB30VT10K10		1	580	12
		1	700	4
BACB30VT10K12		1	285	12
		1	570	8
BACB30VT10K13		1	280	14
BACB30VT10K14		1	275	6
		1	575	16
BACB30VT10K15		1	270	6
BACB30VT10K17		1	265	6
BACB30VT10K6		1	705	32
BACB30VT5HK17		1	320	1
BACB30YP8K9		1	635	4
BACC30M8		1	485	6
BACN10JC08CM		1	330	1
BACN10JD112AU		1	15	1
		1	115	1
BACN10JD114AU		1	160	1
		1	415	1
		1	500	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACN10YT5CD		1	720	4
BACN10YT6CD		1	295	20
		1	710	20
BACN10YT7CD		1	290	4
		1	715	1
BACN10ZV4		1	640	4
BACN10ZV5		1	300	44
		1	585	36
		1	725	36
BACN11N114CS		1	335	1
BACP18BC04A14P		1	10	1
		1	110	1
		1	155	1
		1	410	1
		1	495	1
BLP28F237		1	665	1
BLP28F240		1	455	2
HL10VAZ8-8		1	480	6
HL12VAZ10-6		1	695	4
HL12VAZ12-15		1	250	4
HL12VAZ12-16		1	260	4
		1	680	12
HL12VAZ12-17		1	675	3
HL12VAZ12-20		1	255	8
HL12VAZ12-21		1	685	5
HL12VAZ12-23		1	245	4
HL12VAZ14-34		1	690	1
HL12VAZ14-38		1	235	2
HL79-8		1	485	6
HSP26-108		1	665	1
HST10AG10-10		1	580	12
		1	700	4
HST10AG10-12		1	285	12
		1	570	8
HST10AG10-13		1	280	14
HST10AG10-14		1	275	6
		1	575	16
HST10AG10-15		1	270	6
HST10AG10-17		1	265	6
HST10AG10-6		1	705	32

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
KSC152200BZ5CC		1	630	1
KWDB5-35		1	630	1
LHCB26BAD		1	665	1
LHCB28BA		1	455	2
L802-10K6		1	695	4
L802-12K15		1	250	4
L802-12K16		1	260	4
		1	680	12
L802-12K17		1	675	3
L802-12K20		1	255	8
L802-12K21		1	685	5
L802-12K23		1	245	4
L802-14K34		1	690	1
L802-14K38		1	235	2
MS15001-1		1	60	1
		1	200	2
		1	450	2
		1	535	1
		1	610	1
MS15001-3		1	205	2
MS15004-1		1	375	2
NAS1149CN832R		1	325	1
P2A3080		1	380	2
P3A3560		1	150	2
SWKRS05-350SC		1	630	1
S113W102-209		1	150	2
S113W102-9		1	380	2
WHTFA05VC		1	630	1
WRRS05FAGC		1	630	1
113T1105-9		1	35	1
		1	135	2
113T1202-1		1	1A	RF
113T1202-2		1	5	RF
113T1221-51		1	530	1
113T1221-53		1	600	1
113T1221-55		1	590	1
113T1221-56		1	595	1
113T1222-41		1	195	1
113T1222-43		1	315	1

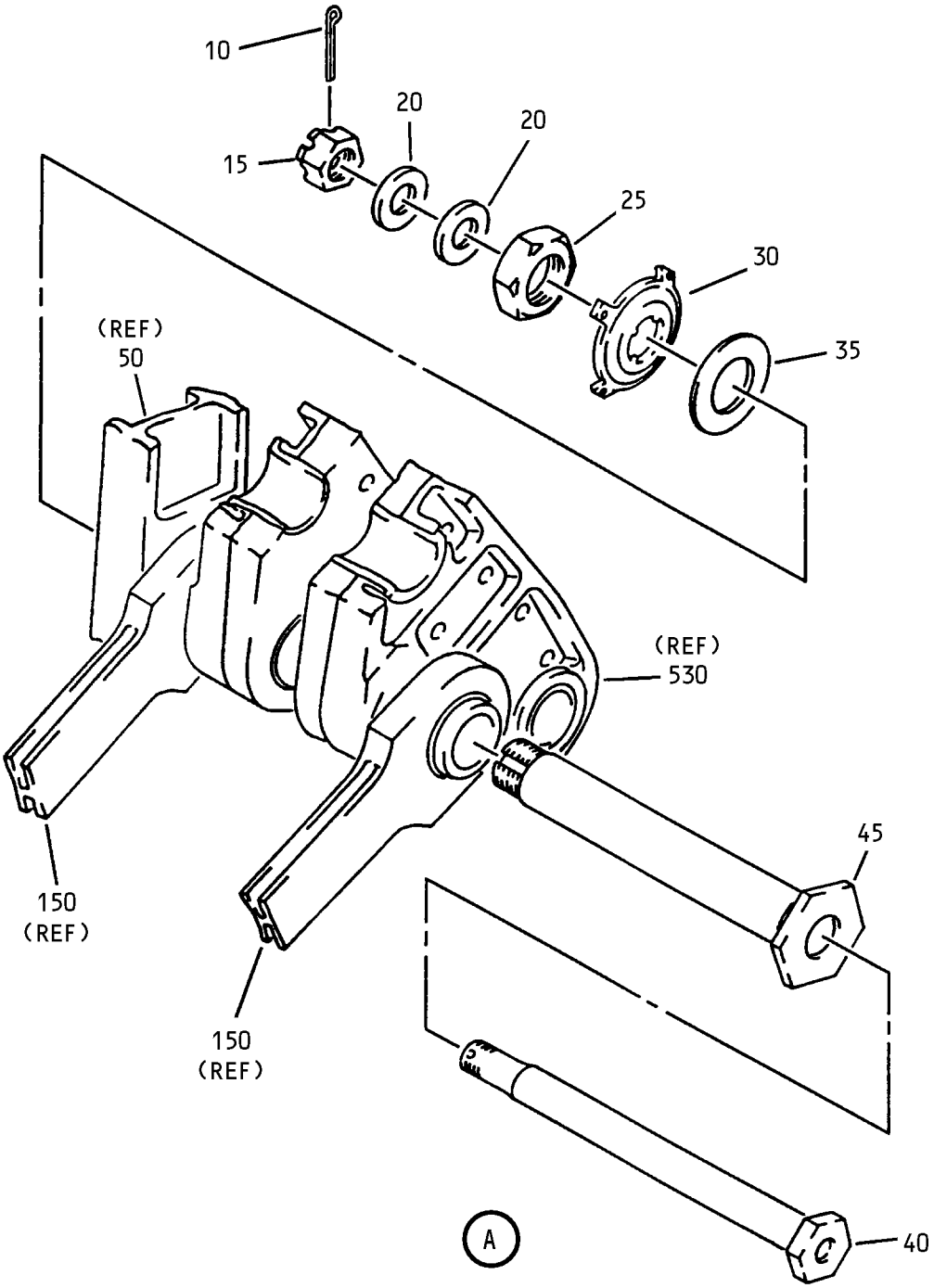
PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
113T1222-45		1	305	1
113T1222-46		1	310	1
113T1223-41		1	370	1
113T1223-43		1	405	1
113T1223-45		1	400	2
113T1224-1		1	445	1
113T1224-2		1	490	2
113T1226-51		1	605	1
113T1226-53		1	740	1
113T1226-55		1	730	1
113T1226-56		1	735	1
113T1226-57		1	645	1
113T1254-11		1	165	2
		1	340	1
		1	420	1
		1	505	1
113T1254-13		1	20	2
		1	120	1
113T1254-3		1	30	1
113T1254-4		1	175	1
113T1254-4		1	350	1
113T1254-46		1	430	1
113T1254-56		1	180	1
		1	355	1
113T1254-6		1	520	1
113T1254-61		1	390	4
113T1254-9		1	130	1
113T1256-20		1	475	4
113T1256-21		1	670	2
113T1262-3		1	25	1
		1	125	1
113T1262-4		1	170	1
		1	345	1
		1	425	1
113T1262-6		1	515	1
113T1263-2		1	145	1
113T1263-5		1	440	1
113T1263-6		1	45	1
113T1263-7		1	525	1
113T1263-8		1	190	1
		1	365	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
113T1264-37		1	140	1
113T1264-60		1	510A	1
113T1264-62		1	435	1
113T1264-63		1	185	1
113T1264-64		1	360	1
113T1264-73		1	40	1
113T1267-19		1	470A	2
113T1267-20		1	465A	2
113T1267-25		1	470	2
113T1267-26		1	465	2
113T1267-5		1	465B	2
113T1267-6		1	470B	2
113T1267-7		1	655	1
113T1267-8		1	660	1
113T1347-146		1	615	2
113T1347-157		1	210	4
113T1347-158		1	395	4
113T1347-41		1	215	2
113T1347-42		1	220	2
113T1347-43		1	230	2
		1	620	2
113T1347-44		1	225	2
		1	625	2
113T1347-45		1	540	2
113T1347-46		1	545	4
113T1347-47		1	550	2
113T1347-48		1	555	2
113T1347-49		1	560	2
113T1347-50		1	565	2
113T1347-63		1	75	1
113T1347-68		1	80	1
113T1347-69		1	85	1
113T1347-70		1	65	1
113T1347-72		1	70	1
113T2066-41		1	50	1
113T2066-42		1	55	1
113T2066-43		1	100	1
113T2066-44		1	105	1
60B00180-237		1	665	1
60B00180-240		1	455	2
66014-8		1	485	6



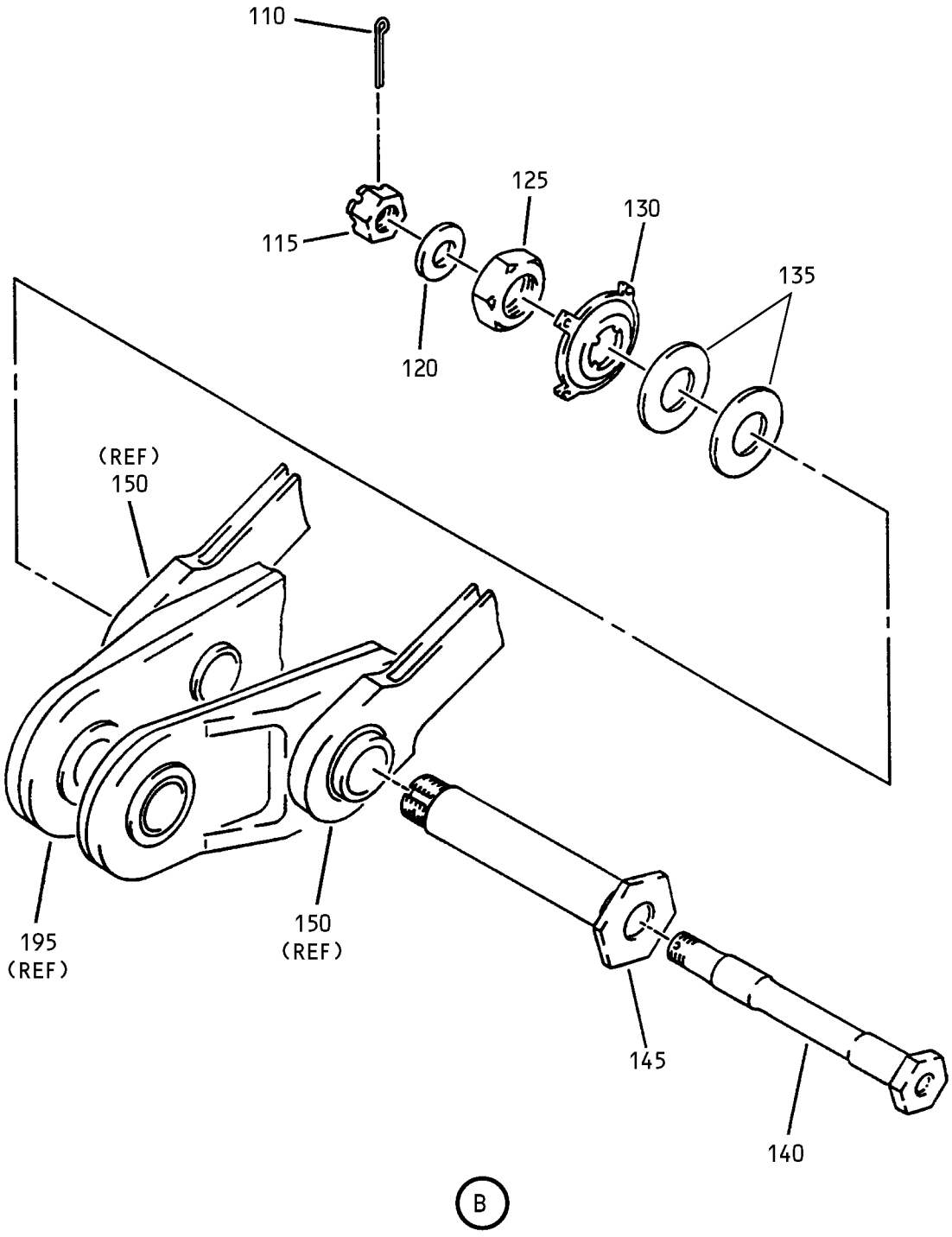
Inboard Trailing Edge Flap Support No. 3 Linkage Assembly
Figure 1 (Sheet 1)

K85846



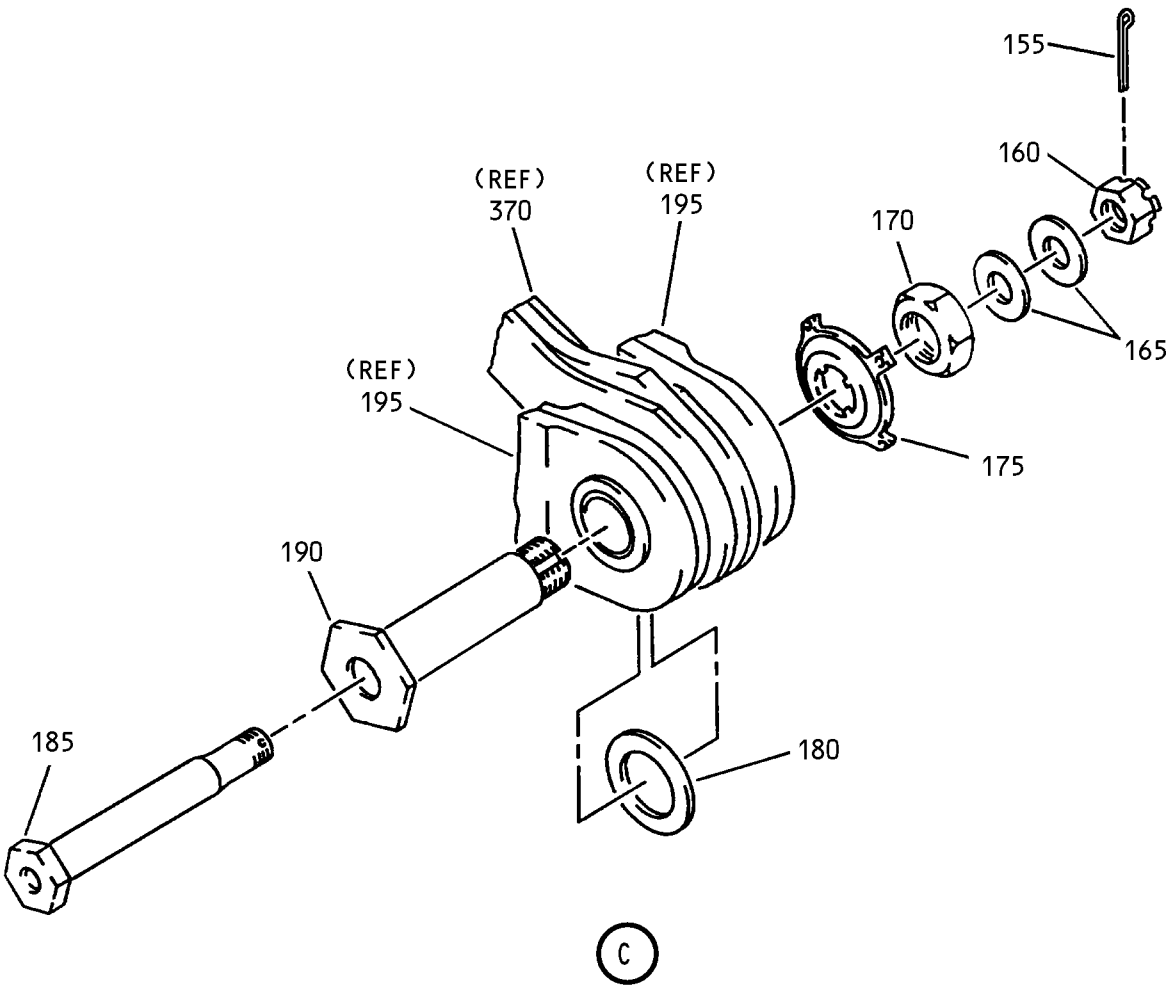
Inboard Trailing Edge Flap Support No. 3 Linkage Assembly
Figure 1 (Sheet 2)

K85849



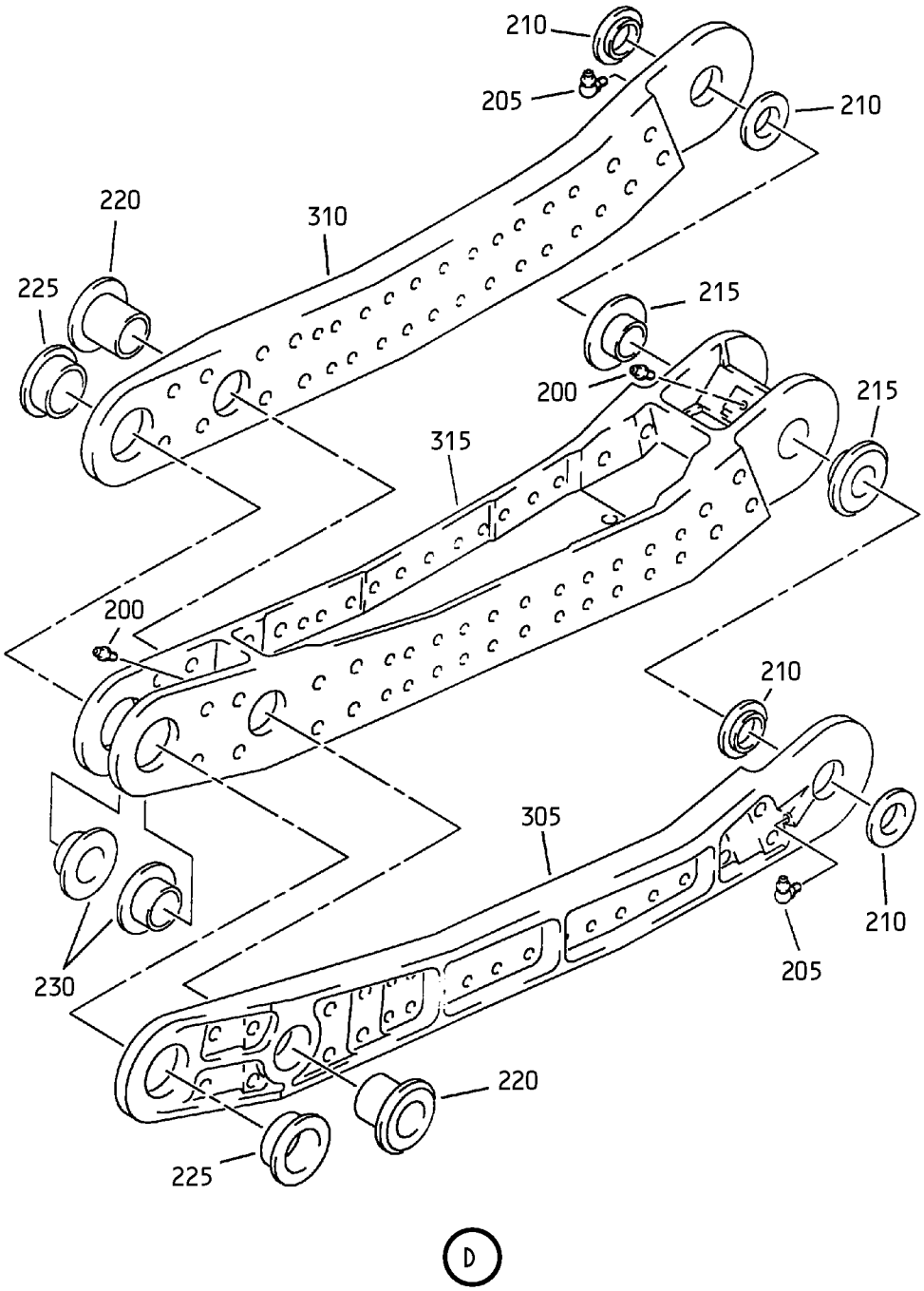
Inboard Trailing Edge Flap Support No. 3 Linkage Assembly
Figure 1 (Sheet 3)

K85862



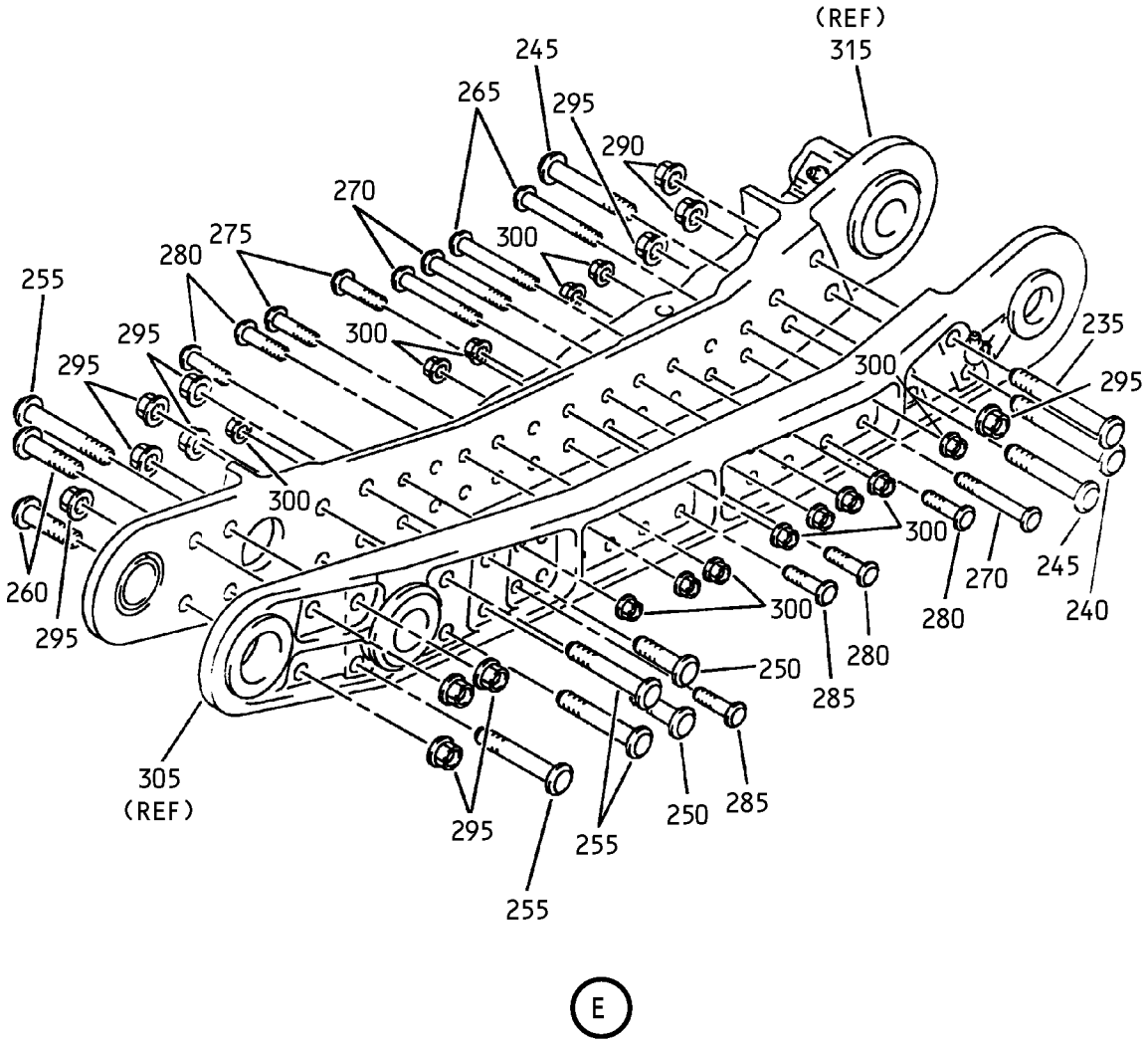
Inboard Trailing Edge Flap Support No. 3 Linkage Assembly
Figure 1 (Sheet 4)

K85865



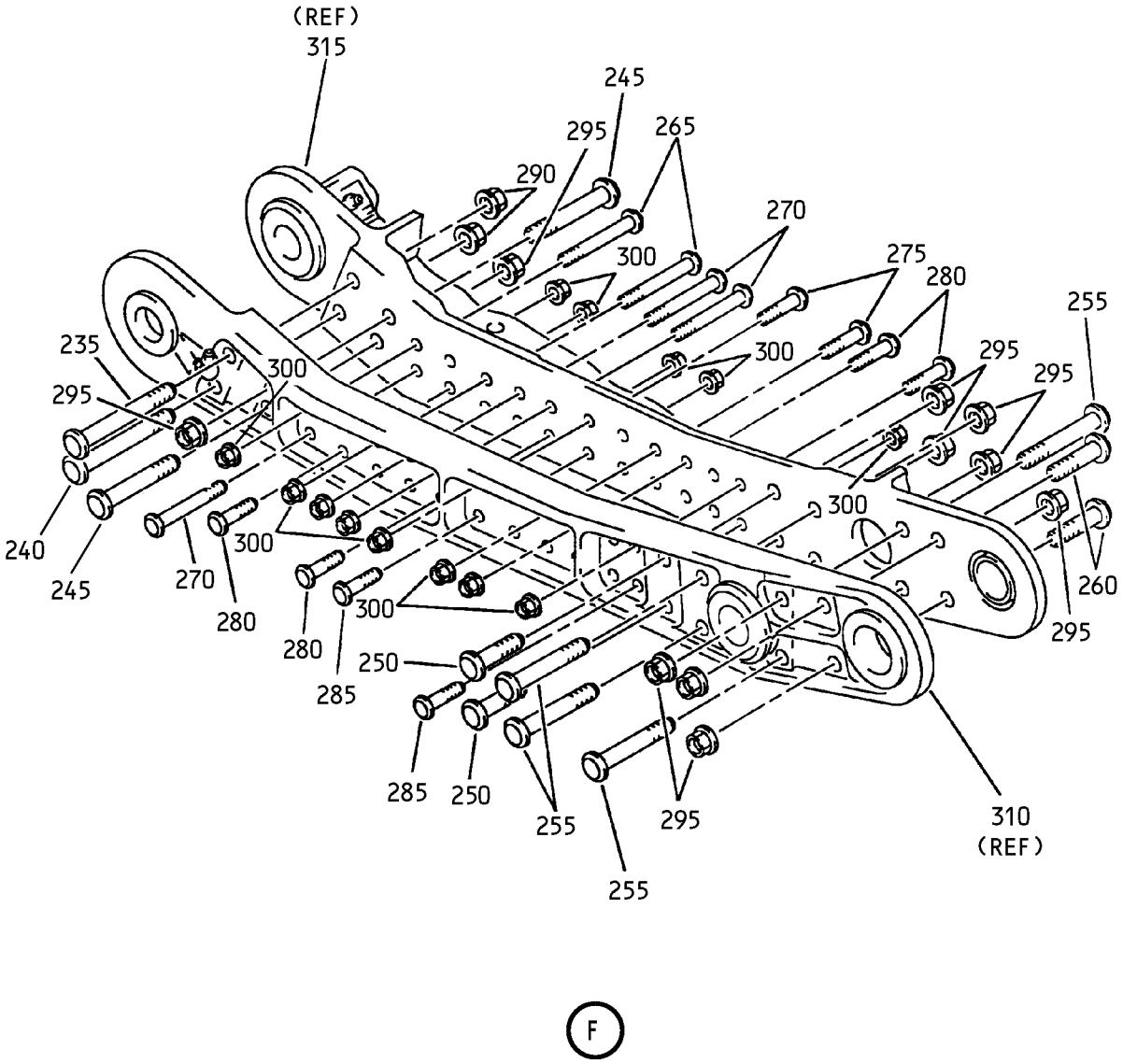
Inboard Trailing Edge Flap Support No. 3 Linkage Assembly
Figure 1 (Sheet 5)

K85881



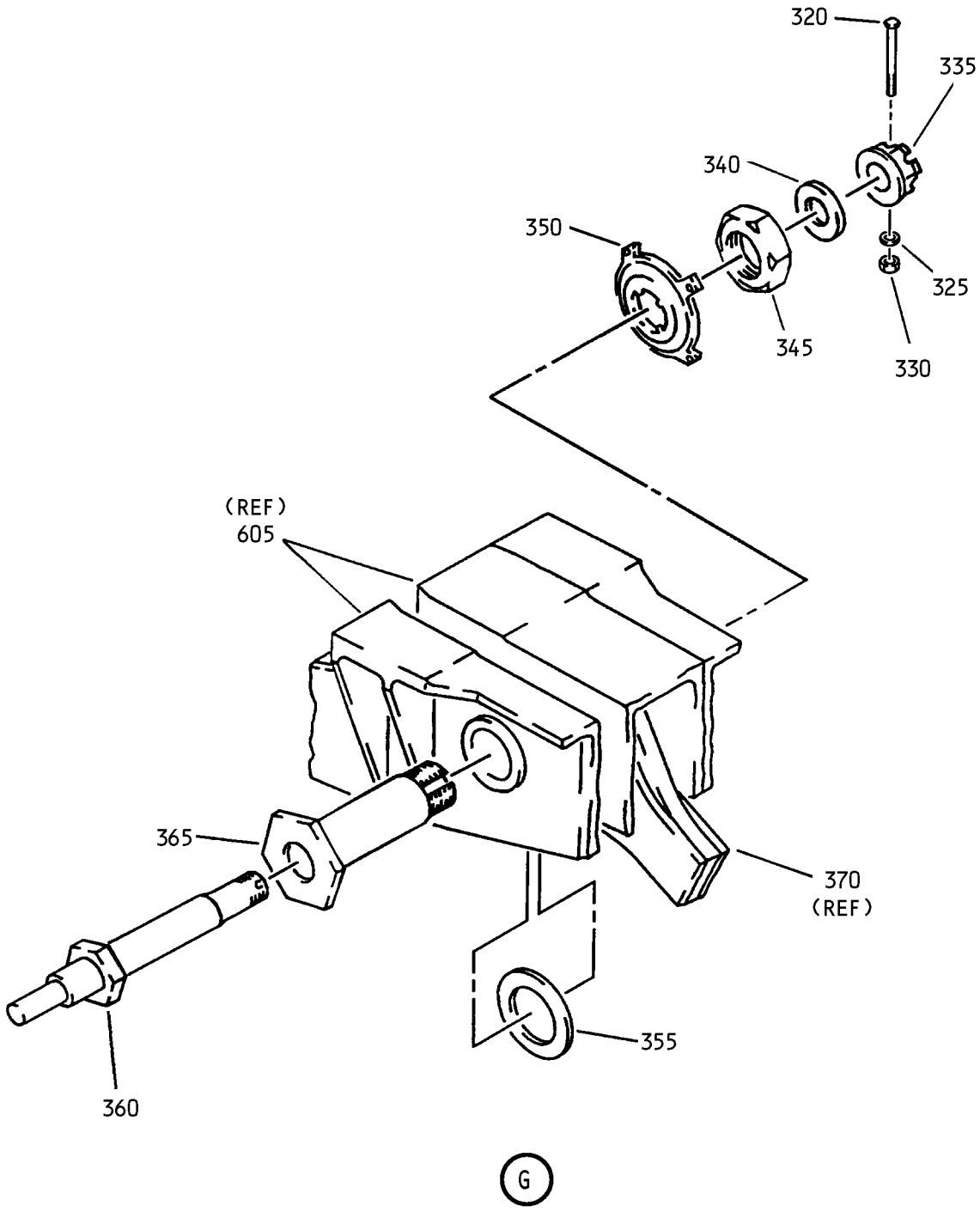
Inboard Trailing Edge Flap Support No. 3 Linkage Assembly
Figure 1 (Sheet 6)

K85931



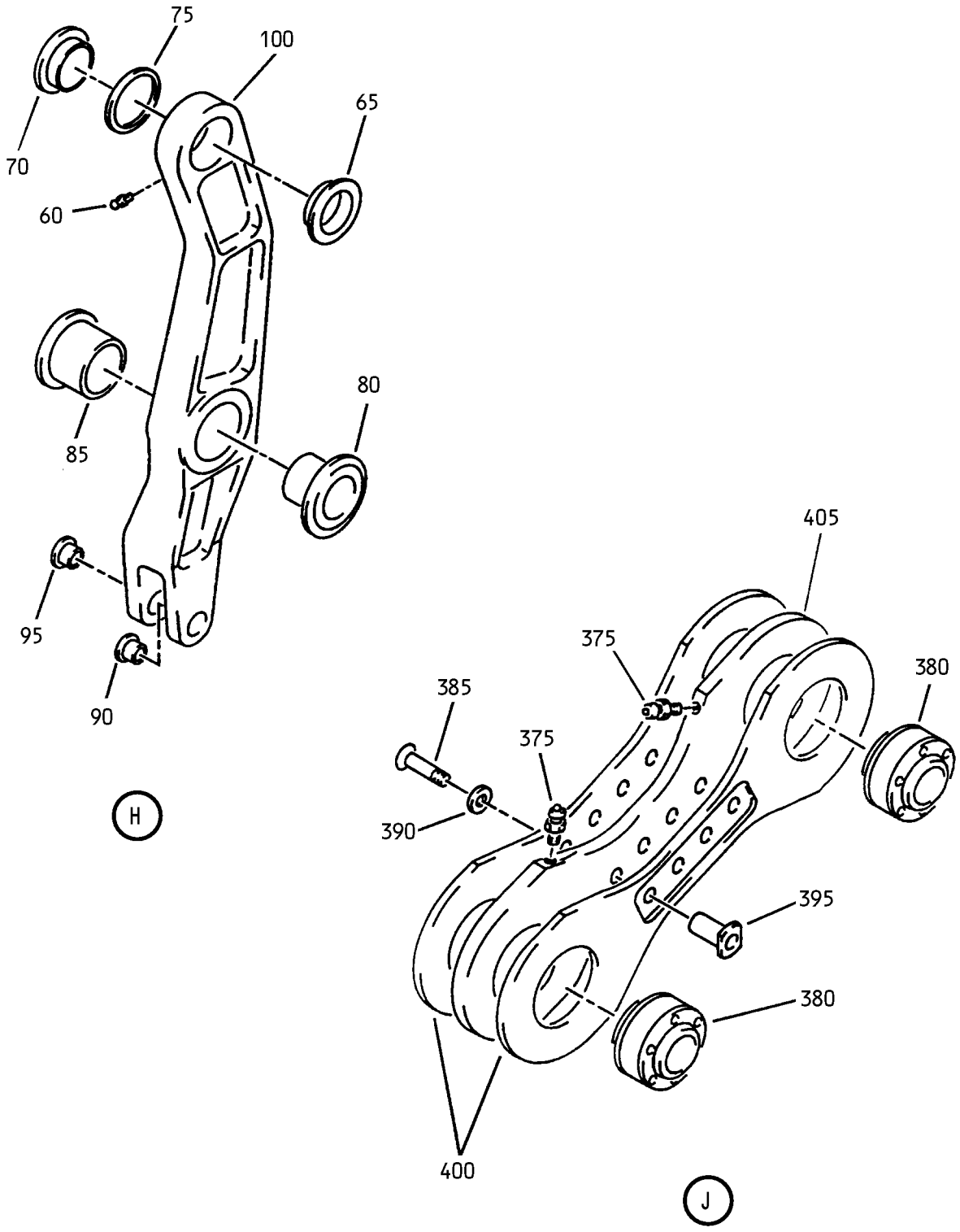
Inboard Trailing Edge Flap Support No. 3 Linkage Assembly
Figure 1 (Sheet 7)

K85989



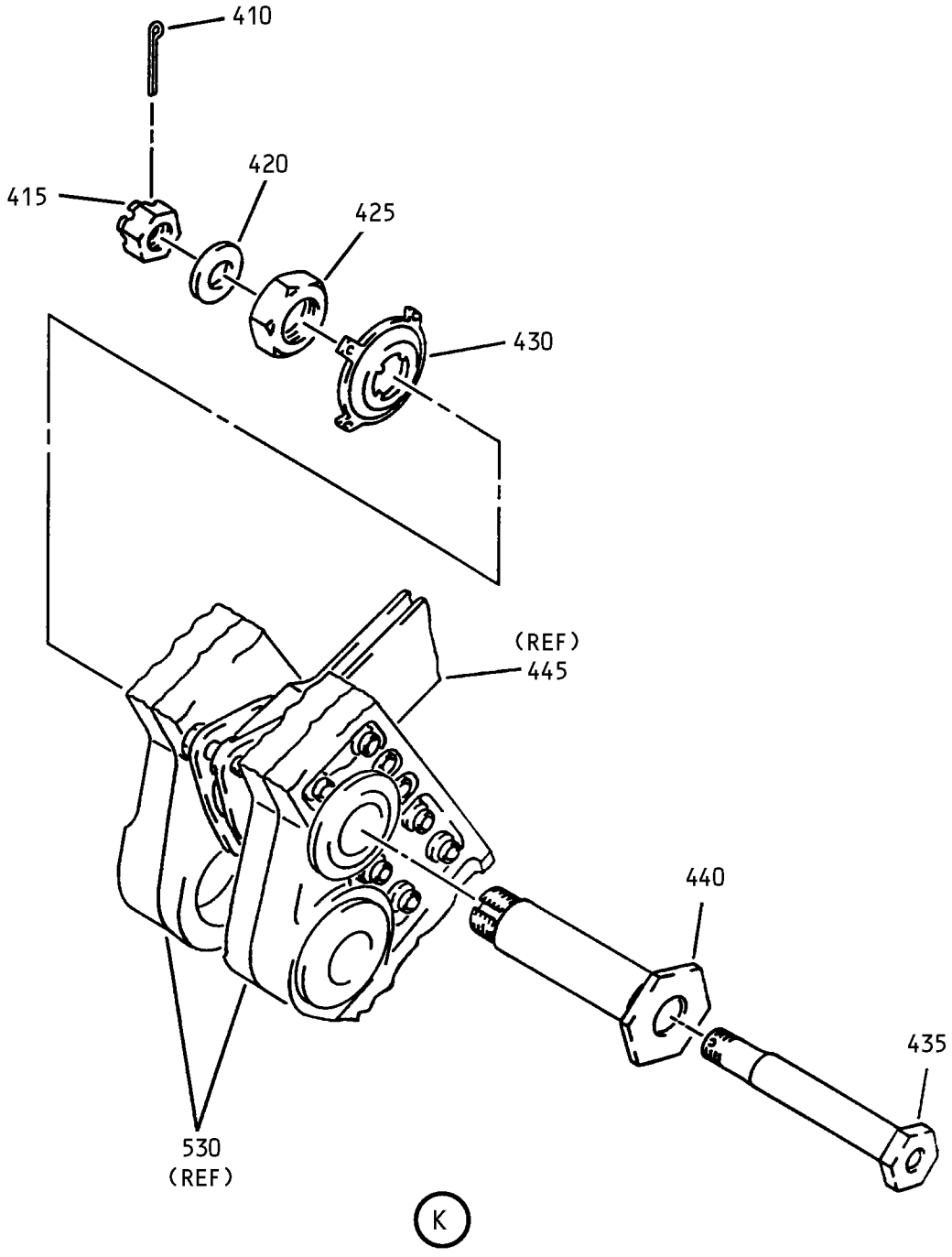
Inboard Trailing Edge Flap Support No. 3 Linkage Assembly
Figure 1 (Sheet 8)

K86073



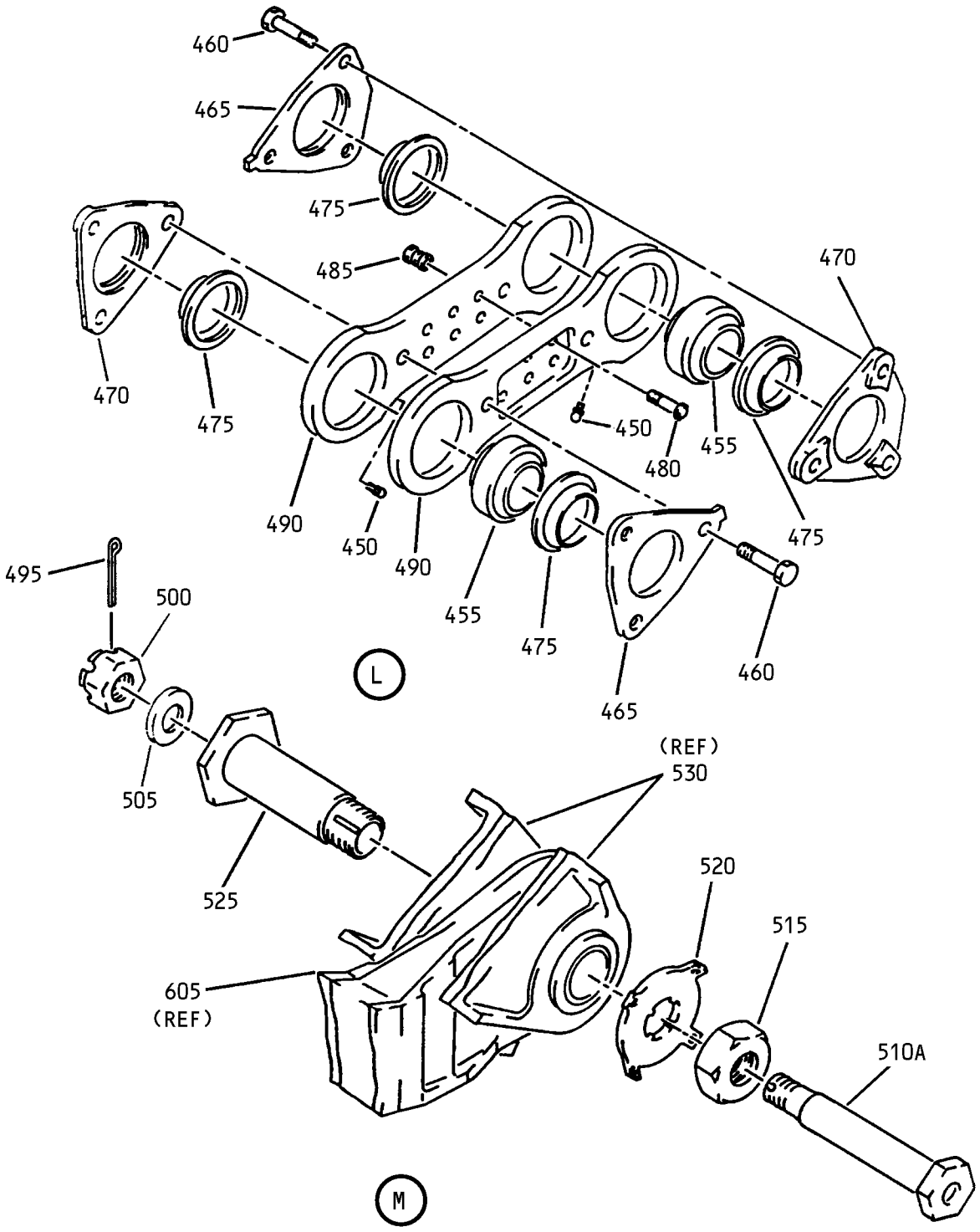
Inboard Trailing Edge Flap Support No. 3 Linkage Assembly
Figure 1 (Sheet 9)

K86075



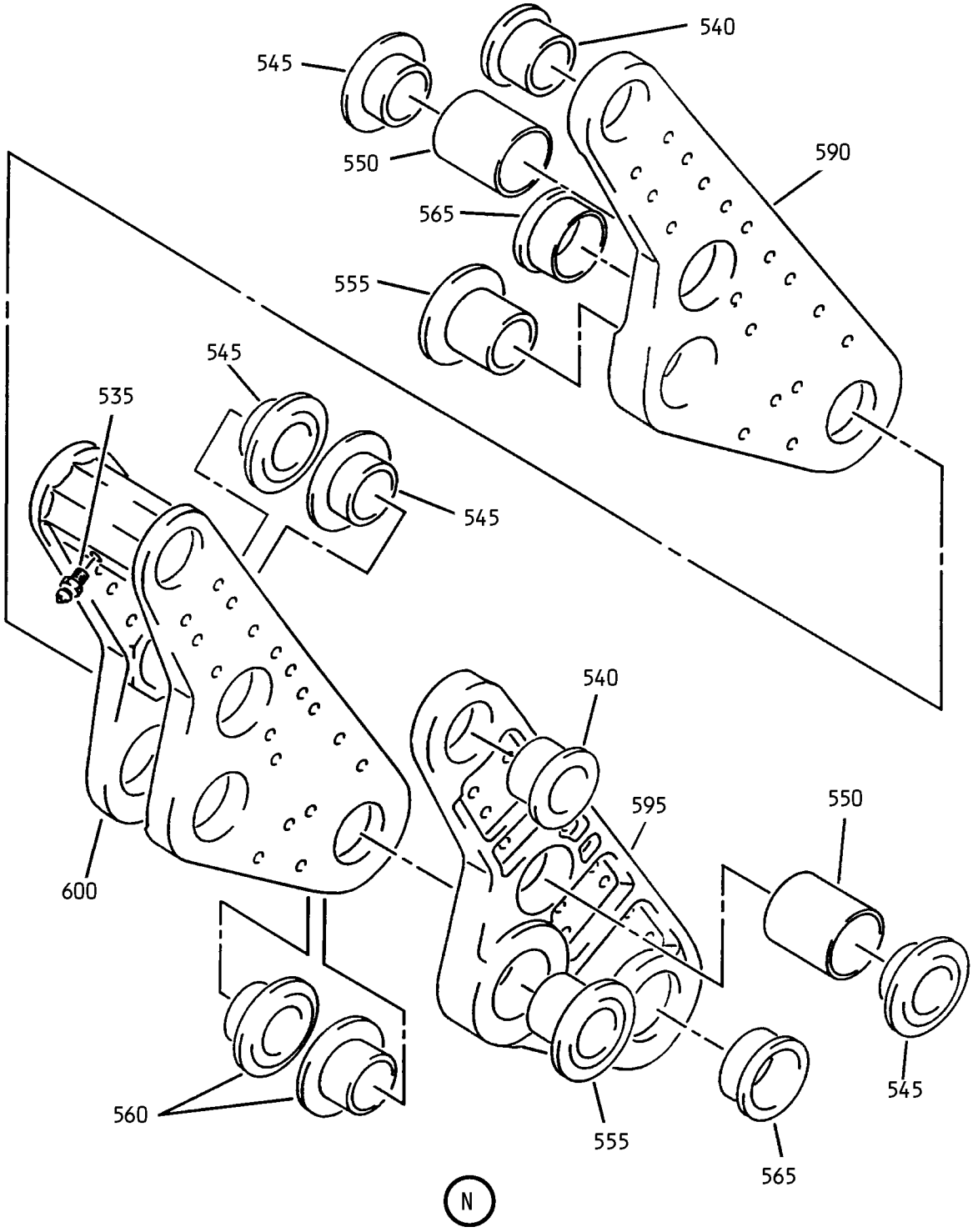
Inboard Trailing Edge Flap Support No. 3 Linkage Assembly
Figure 1 (Sheet 10)

K86080



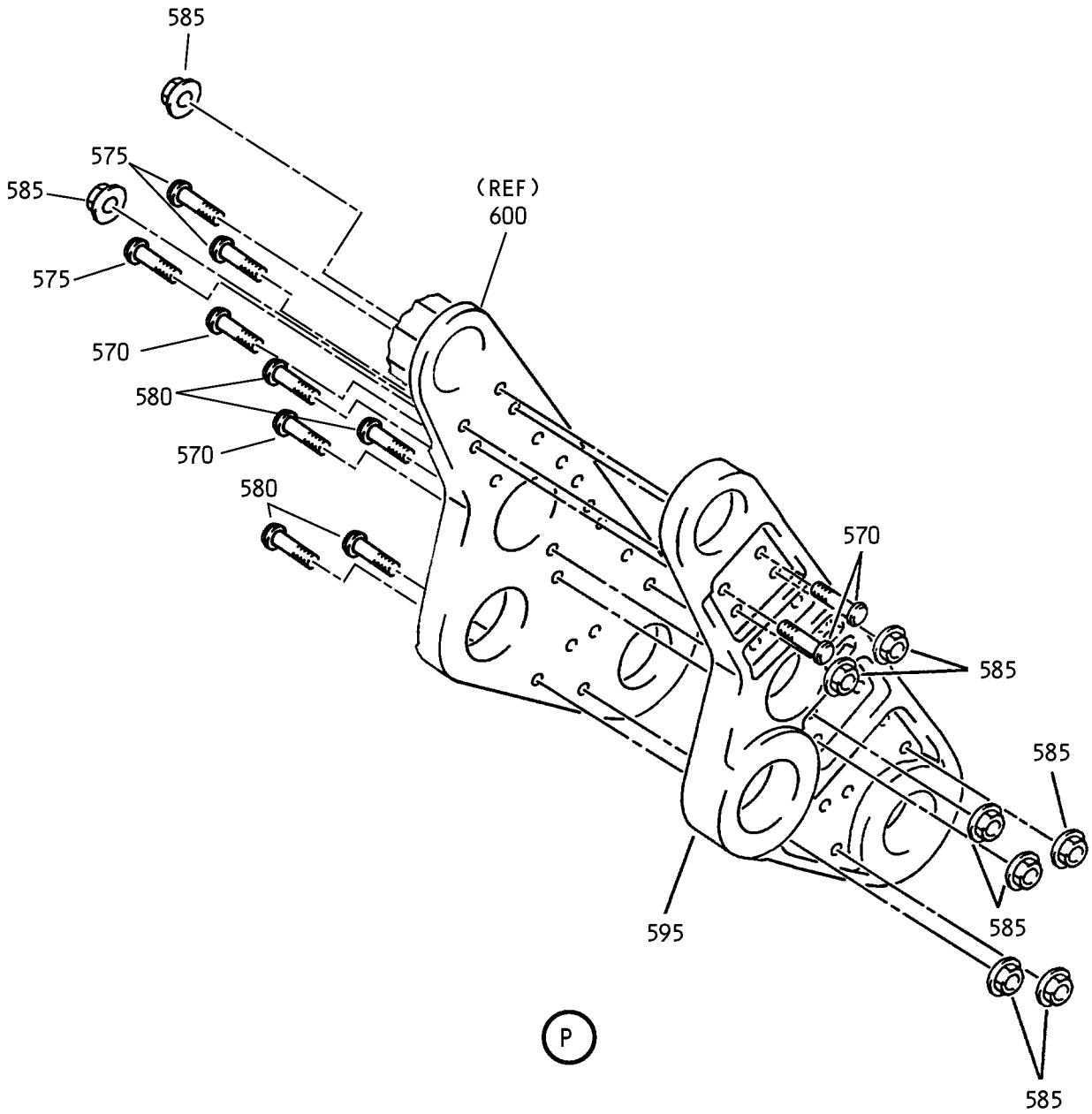
Inboard Trailing Edge Flap Support No. 3 Linkage Assembly
Figure 1 (Sheet 11)

K86218



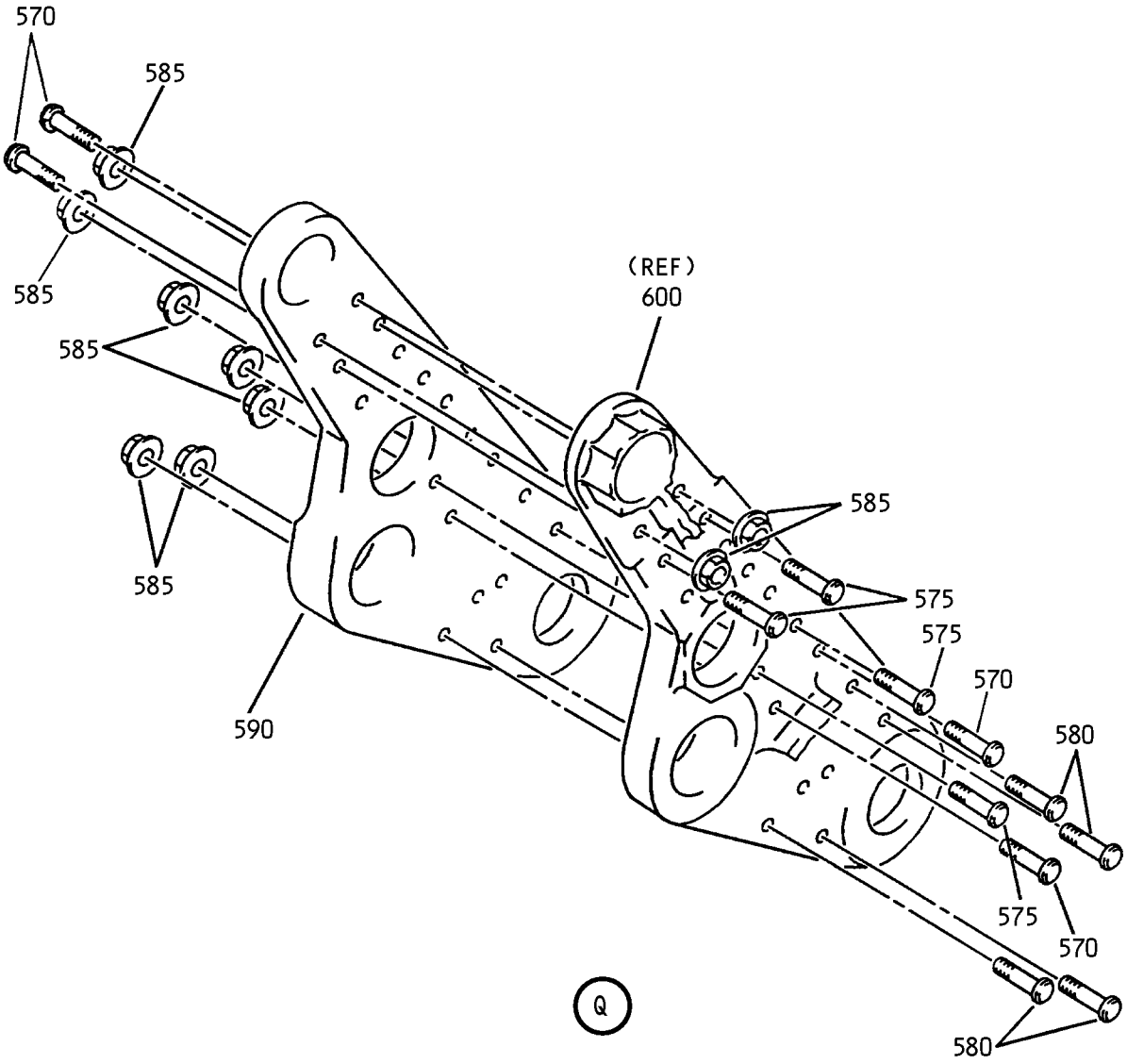
Inboard Trailing Edge Flap Support No. 3 Linkage Assembly
Figure 1 (Sheet 12)

K86227



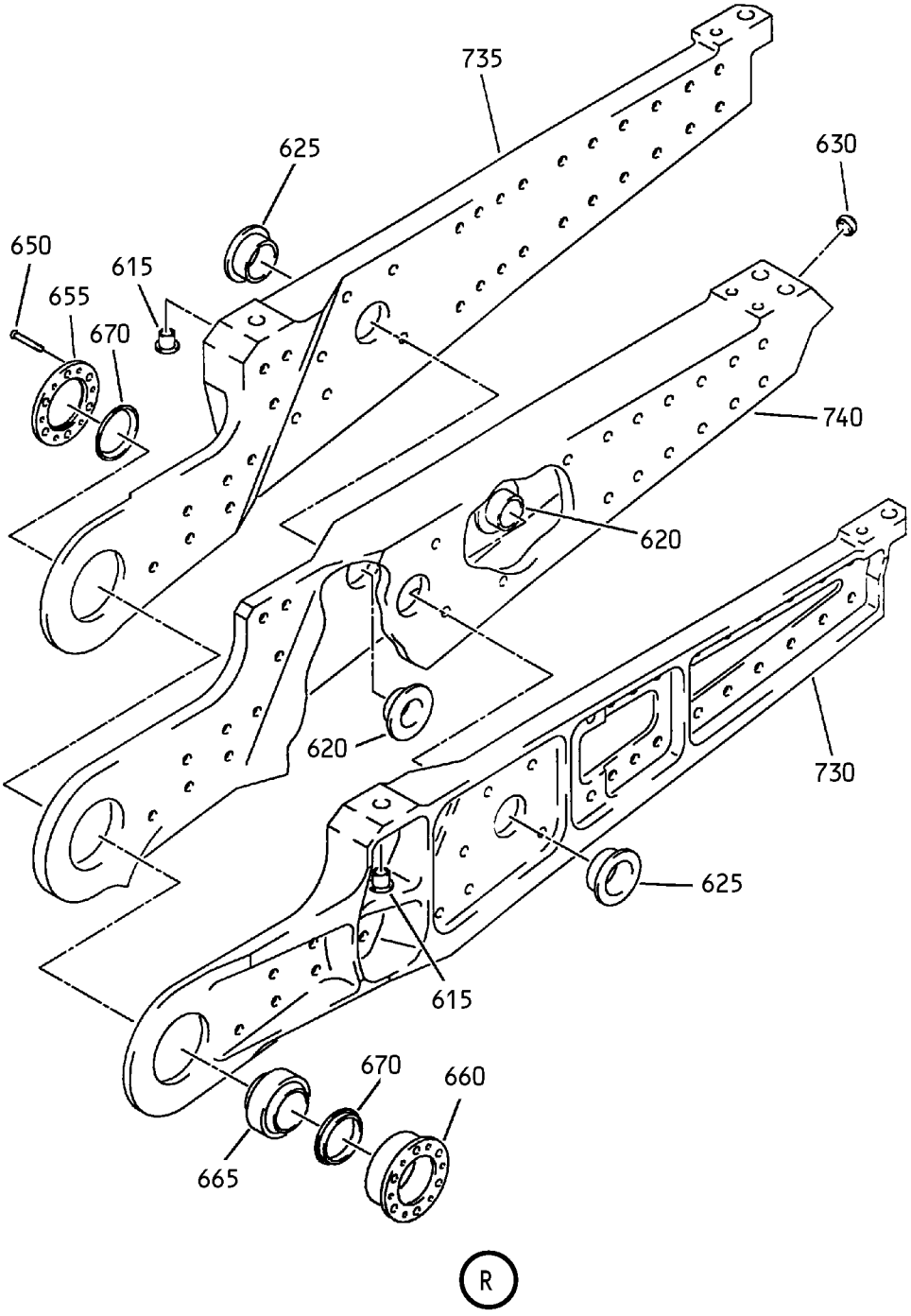
Inboard Trailing Edge Flap Support No. 3 Linkage Assembly
Figure 1 (Sheet 13)

K86319



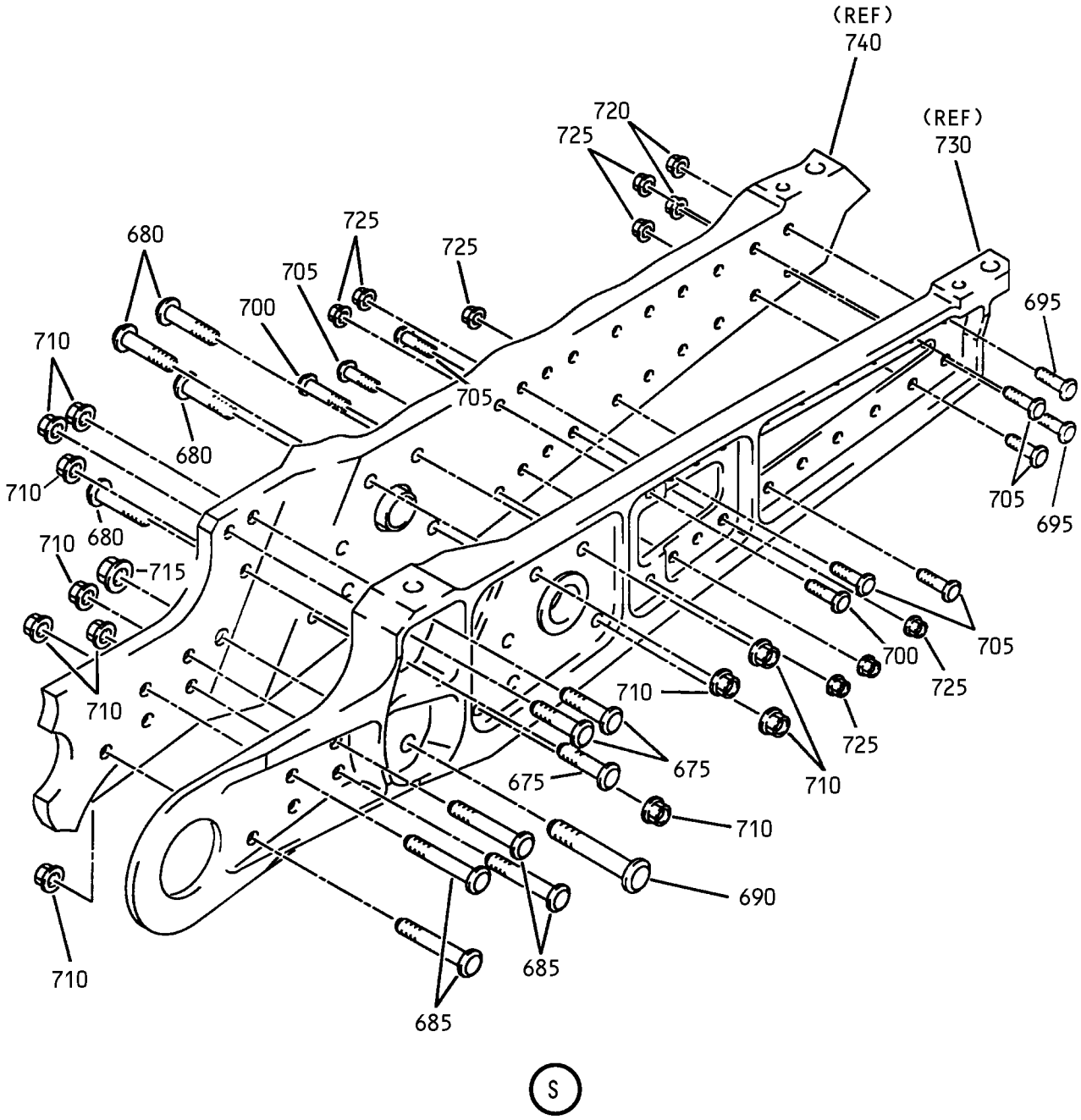
Inboard Trailing Edge Flap Support No. 3 Linkage Assembly
Figure 1 (Sheet 14)

K86370



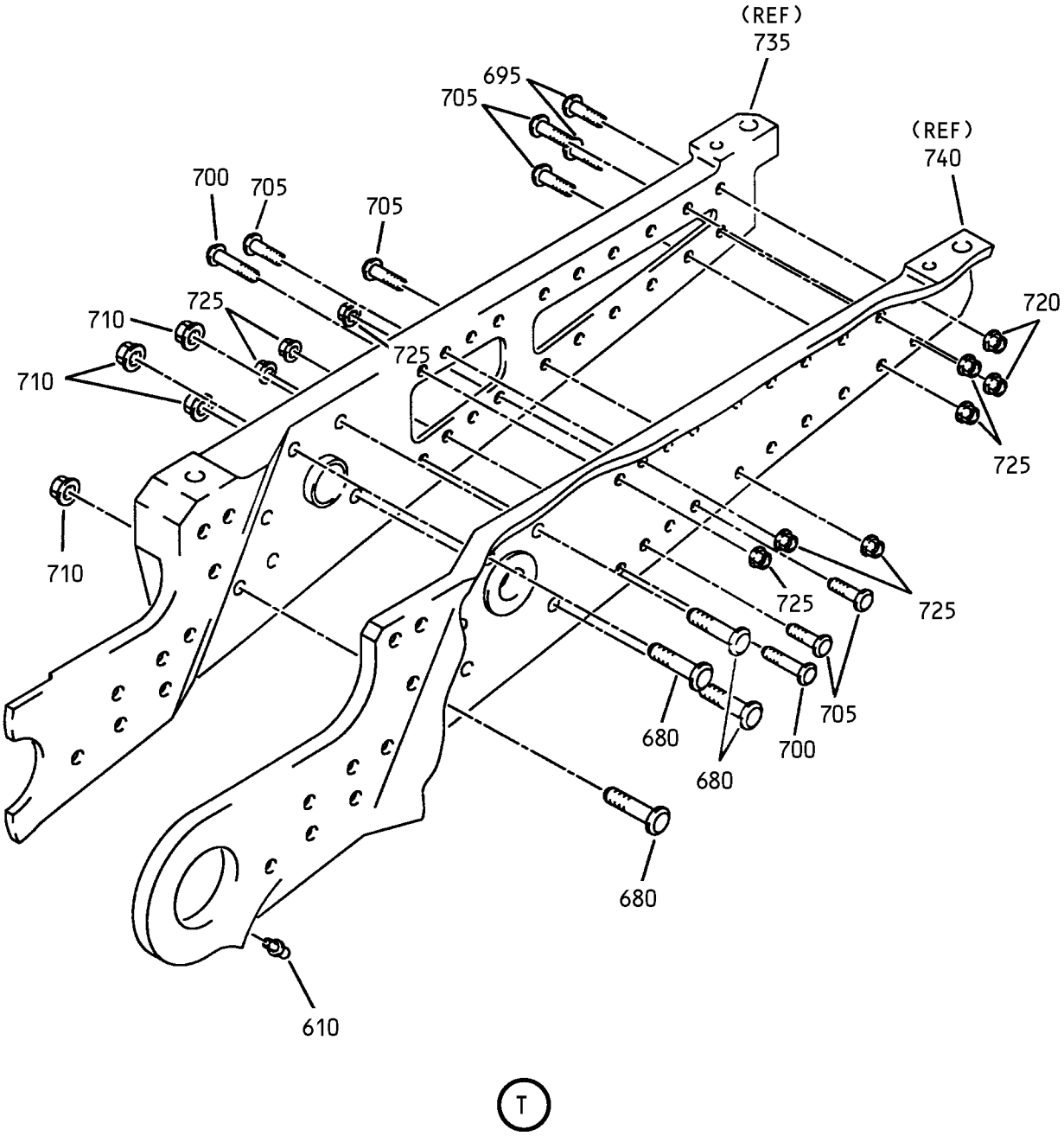
Inboard Trailing Edge Flap Support No. 3 Linkage Assembly
Figure 1 (Sheet 15)

K86519



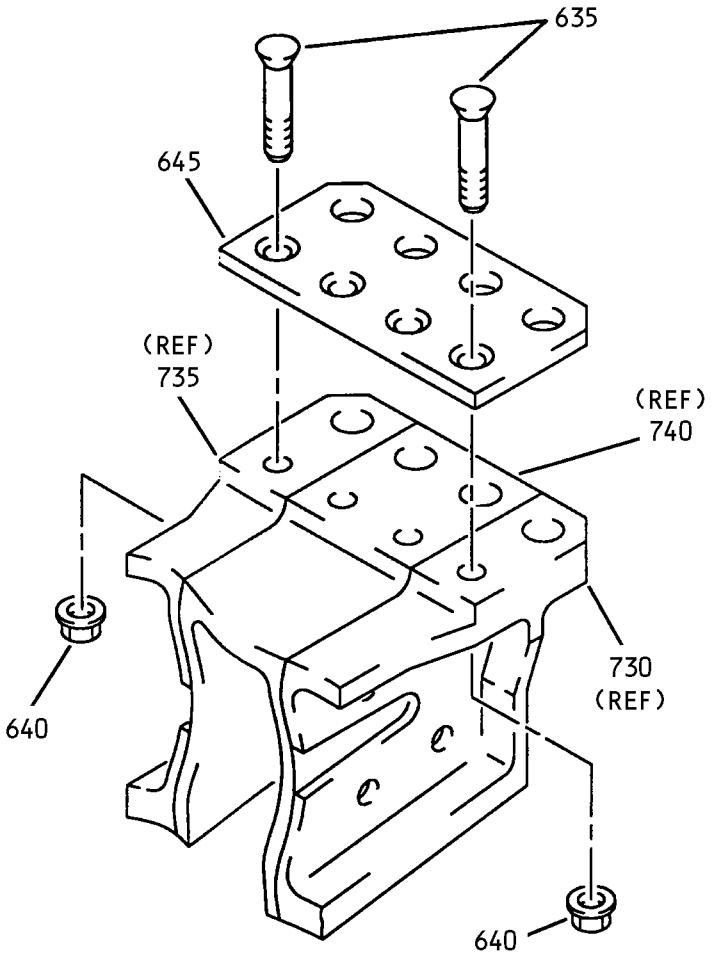
Inboard Trailing Edge Flap Support No. 3 Linkage Assembly
Figure 1 (Sheet 16)

K86521



Inboard Trailing Edge Flap Support No. 3 Linkage Assembly
Figure 1 (Sheet 17)

K86561



Inboard Trailing Edge Flap Support No. 3 Linkage Assembly
Figure 1 (Sheet 18)

K86563

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-1A	113T1202-1		LINKAGE ASSY-INBD TE FLAP	A	RF
-5	113T1202-2		LINKAGE ASSY-INBD TE FLAP	B	RF
10	BACP18BC04A14P		.PIN-COTTER		1
15	BACN10JD112AU		.NUT		1
20	113T1254-13		.WASHER-SPECIAL		AR
25	113T1262-3		.NUT-SPECIAL		1
30	113T1254-3		.WASHER-SPECIAL		1
35	113T1105-9		.WASHER-LAMINATED		1
40	113T1264-73		.PIN-INNER		1
45	113T1263-6		.PIN-OUTER		1
50	113T2066-41		.LINK ASSY-6/11	A	1
-55	113T2066-42		.LINK ASSY-6/11	B	1
60	MS15001-1		..FITTING-LUBE		1
65	113T1347-70		..BUSHING		1
70	113T1347-72		..BUSHING		1
75	113T1347-63		..SPACER		1
80	113T1347-68		..BUSHING		1
85	113T1347-69		..BUSHING		1
90	BACB28AP08P040		..BUSHING		1
95	BACB28AT11B040C		..BUSHING		1
100	113T2066-43		..LINK	A	1
-105	113T2066-44		..LINK	B	1
110	BACP18BC04A14P		.PIN-COTTER		1
115	BACN10JD112AU		.NUT		1
120	113T1254-13		.WASHER-SPECIAL		1
125	113T1262-3		.NUT-SPECIAL		1
130	113T1254-9		.WASHER-SPECIAL		1
135	113T1105-9		.WASHER-LAMINATED		AR
140	113T1264-37		.PIN-INNER		1
145	113T1263-2		.PIN-OUTER		1
150	P3A3560		.LINK ASSY-2/8 (V57606) (SPEC S113W102-209)		2
155	BACP18BC04A14P		.PIN-COTTER		1
160	BACN10JD114AU		.NUT		1
165	113T1254-11		.WASHER-SPECIAL		AR
170	113T1262-4		.NUT-SPECIAL		1
175	113T1254-4		.WASHER-SPECIAL		1
180	113T1254-56		.WASHER-RUB		1
185	113T1264-63		.PIN-INNER		1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
190	113T1263-8		.PIN-OUTER		1
195	113T1222-41		.BEAM ASSY-1/3		1
200	MS15001-1		..FITTING-LUBE		2
205	MS15001-3		..FITTING-LUBE		2
210	113T1347-157		..BUSHING		4
215	113T1347-41		..BUSHING		2
220	113T1347-42		..BUSHING		2
225	113T1347-44		..BUSHING		2
230	113T1347-43		..BUSHING		2
235	HL12VAZ14-38		..BOLT- (V56878) (SPEC BACB30NX14K38) (OPT HL12VAZ14-38 (V73197)) (OPT HL12VAZ14-38 (V92215)) (OPT HL12VAZ14-38 (V97928)) (OPT L802-14K38 (V06725)) (OPT HL12VAZ14-38 (VOPTK6)) (OPT HL12VAZ14-38 (V60516))		2
240	BACB30NX14K39		..BOLT		2
245	HL12VAZ12-23		..BOLT- (V56878) (SPEC BACB30NX12K23) (OPT HL12VAZ12-23 (V73197)) (OPT HL12VAZ12-23 (V92215)) (OPT HL12VAZ12-23 (V97928)) (OPT L802-12K23 (V06725)) (OPT HL12VAZ12-23 (VOPTK6)) (OPT HL12VAZ12-23 (V60516))		4

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-250	HL12VAZ12-15		..BOLT- (V56878) (SPEC BACB30NX12K15) (OPT HL12VAZ12-15 (V73197)) (OPT HL12VAZ12-15 (V92215)) (OPT HL12VAZ12-15 (V97928)) (OPT L802-12K15 (V06725)) (OPT HL12VAZ12-15 (VOPTK6)) (OPT HL12VAZ12-15 (V60516))		4
255	HL12VAZ12-20		..BOLT- (V56878) (SPEC BACB30NX12K20) (OPT HL12VAZ12-20 (V73197)) (OPT HL12VAZ12-20 (V92215)) (OPT HL12VAZ12-20 (V97928)) (OPT L802-12K20 (V06725)) (OPT HL12VAZ12-20 (VOPTK6)) (OPT HL12VAZ12-20 (V60516))		8

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-260	HL12VAZ12-16		..BOLT- (V56878) (SPEC BACB30NX12K16) (OPT HL12VAZ12-16 (V73197)) (OPT HL12VAZ12-16 (V92215)) (OPT HL12VAZ12-16 (V97928)) (OPT L802-12K16 (V06725)) (OPT HL12VAZ12-16 (VOPTK6)) (OPT HL12VAZ12-16 (V60516))		4
265	HST10AG10-17		..BOLT- (VOPTK6) (SPEC BACB30VT10K17) (OPT HST10AG10-17 (V06725)) (OPT HST10AG10-17 (V56878)) (OPT HST10AG10-17 (V73197))		6
270	HST10AG10-15		..BOLT- (VOPTK6) (SPEC BACB30VT10K15) (OPT HST10AG10-15 (V06725)) (OPT HST10AG10-15 (V56878)) (OPT HST10AG10-15 (V73197))		6

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
275	HST10AG10-14		..BOLT- (V0PTK6) (SPEC BACB30VT10K14) (OPT HST10AG10-14 (V06725)) (OPT HST10AG10-14 (V56878)) (OPT HST10AG10-14 (V73197))		6
280	HST10AG10-13		..BOLT- (V0PTK6) (SPEC BACB30VT10K13) (OPT HST10AG10-13 (V06725)) (OPT HST10AG10-13 (V56878)) (OPT HST10AG10-13 (V73197))		14
285	HST10AG10-12		..BOLT- (V0PTK6) (SPEC BACB30VT10K12) (OPT HST10AG10-12 (V06725)) (OPT HST10AG10-12 (V56878)) (OPT HST10AG10-12 (V73197))		12
290	BACN10YT7CD		..NUT		4
295	BACN10YT6CD		..NUT		20
300	BACN10ZV5		..NUT		44
305	113T1222-45		..STRAP-OUTER		1
310	113T1222-46		..STRAP-OUTER		1
315	113T1222-43		..BEAM-INNER		1
320	BACB30VT5HK17		.BOLT- (OPT ITEM 320A)		1
-320A	BACB30MB5A17NU		.BOLT- (OPT ITEM 320)		1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
325	NAS1149CN832R		.WASHER		1
330	BACN10JC08CM		.NUT		1
335	BACN11N114CS		.NUT		1
340	113T1254-11		.WASHER-SPECIAL		1
345	113T1262-4		.NUT-SPECIAL		1
350	113T1254-4		.WASHER-SPECIAL		1
355	113T1254-56		.WASHER-RUB		1
360	113T1264-64		.PIN-INNER		1
365	113T1263-8		.PIN-OUTER		1
370	113T1223-41		.LINK ASSY-3/10		1
375	MS15004-1		..FITTING-LUBE		2
380	P2A3080		..BEARING- (V57606) (SPEC S113W102-9)		2
385	BACB30LH4PU17		..BOLT		4
390	113T1254-61		..WASHER		4
395	113T1347-158		..BUSHING		4
400	113T1223-45		..SEGMENT-OUTER		2
405	113T1223-43		..SEGMENT-INNER		1
410	BACP18BC04A14P		.PIN-COTTER		1
415	BACN10JD114AU		.NUT		1
420	113T1254-11		.WASHER-SPECIAL		1
425	113T1262-4		.NUT-SPECIAL		1
430	113T1254-46		.WASHER-SPECIAL		1
435	113T1264-62		.PIN-INNER		1
440	113T1263-5		.PIN-OUTER		1
445	113T1224-1		.LINK ASSY-5/7		1
450	MS15001-1		..FITTING-LUBE		2
455	ASSB28-18		..BEARING- (V15860) (SPEC 60B00180-240) (OPT ASB28-101 (VS0352)) (OPT BLP28F240 (V16746)) (OPT LHCB28BA (V73134))		2

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
460	BACB30LJ4HSU15		..BOLT		6
465	113T1267-26		..PLATE- (OPT ITEMS 465A, 465B)		2
-465A	113T1267-20		..PLATE- (OPT ITEMS 465, 465B)		2
-465B	113T1267-5		..PLATE- (OPT ITEMS 465, 465A)		2
470	113T1267-25		..RETAINER- (OPT ITEMS 470A, 470B)		2
-470A	113T1267-19		..RETAINER- (OPT ITEMS 470, 470B)		2
-470B	113T1267-6		..RETAINER- (OPT ITEMS 470, 470A)		2
475	113T1256-20		..SEAL		4
480	HL10VAZ8-8		..BOLT- (V60516) (SPEC BACB30MY8K8) (OPT HL10VAZ8-8 (V0PTK6))		6
485	HL79-8		..COLLAR- (V56878) (SPEC BACC30M8) (OPT HL79-8 (V73197)) (OPT HL79-8 (V92215)) (OPT 66014-8 (V56878))		6
490	113T1224-2		..LINK HALF		2
495	BACP18BC04A14P		.PIN-COTTER		1
500	BACN10JD114AU		.NUT		1
505	113T1254-11		.WASHER-SPECIAL		1
510	113T1260-60		DELETED		
-510A	113T1264-60		.PIN-INNER		1
515	113T1262-6		.NUT-SPECIAL		1
520	113T1254-6		.WASHER-SPECIAL		1
525	113T1263-7		.PIN-OUTER		1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
530	113T1221-51		.LINK ASSY-6/9		1
535	MS15001-1		..FITTING-LUBE		1
540	113T1347-45		..BUSHING		2
545	113T1347-46		..BUSHING		4
550	113T1347-47		..BUSHING		2
555	113T1347-48		..BUSHING		2
560	113T1347-49		..BUSHING		2
565	113T1347-50		..BUSHING		2
570	HST10AG10-12		..BOLT- (VOPTK6) (SPEC BACB30VT10K12) (OPT HST10AG10-12 (V06725)) (OPT HST10AG10-12 (V56878)) (OPT HST10AG10-12 (V73197))		8
575	HST10AG10-14		..BOLT- (VOPTK6) (SPEC BACB30VT10K14) (OPT HST10AG10-14 (V06725)) (OPT HST10AG10-14 (V56878)) (OPT HST10AG10-14 (V73197))		16
580	HST10AG10-10		..BOLT- (VOPTK6) (SPEC BACB30VT10K10) (OPT HST10AG10-10 (V06725)) (OPT HST10AG10-10 (V56878)) (OPT HST10AG10-10 (V73197))		12
585	BACN10ZV5		..NUT		36
590	113T1221-55		..LINK-SIDE		1
595	113T1221-56		..LINK-SIDE		1
600	113T1221-53		..LINK-CTR		1
605	113T1226-51		.BEAM ASSY-9/10		1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
610	MS15001-1		..FITTING-LUBE		1
615	113T1347-146		..BUSHING		2
620	113T1347-43		..BUSHING		2
625	113T1347-44		..BUSHING		2
630	ADW5V301NC		..BEARING- (V15860) (SPEC BACB10FA05GC) (OPT KSC152200BZ5CC (V50632)) (OPT KWDB5-35 (V97613)) (OPT WHTFA05VC (V50294)) (OPT WRRS05FAGC (V73134)) (OPT SWKRS05-350SC (V81376))		1
635	BACB30YP8K9		..BOLT		4
640	BACN10ZV4		..NUT		4
645	113T1226-57		..SHIM-STRUCTURAL		1
650	BACB30LH3PU20		..BOLT		6
655	113T1267-7		..PLATE		1
660	113T1267-8		..RETAINER-BRG		1
665	HSP26-108		..BEARING- (V02758) (SPEC 60B00180-237) (OPT ASB26-103 (VS0352)) (OPT LHCB26BAD (V73134)) (OPT BLP28F237 (V16746))		1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
670	113T1256-21		..SEAL		2
675	HL12VAZ12-17		..BOLT- (V56878) (SPEC BACB30NX12K17) (OPT HL12VAZ12-17 (V73197)) (OPT HL12VAZ12-17 (V92215)) (OPT HL12VAZ12-17 (V97928)) (OPT L802-12K17 (V06725)) (OPT HL12VAZ12-17 (VOPTK6)) (OPT HL12VAZ12-17 (V60516))		3
680	HL12VAZ12-16		..BOLT- (V56878) (SPEC BACB30NX12K16) (OPT HL12VAZ12-16 (V73197)) (OPT HL12VAZ12-16 (V92215)) (OPT HL12VAZ12-16 (V97928)) (OPT L802-12K16 (V06725)) (OPT HL12VAZ12-16 (VOPTK6)) (OPT HL12VAZ12-16 (V60516))		12

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-685	HL12VAZ12-21		..BOLT- (V56878) (SPEC BACB30NX12K21) (OPT HL12VAZ12-21 (V73197)) (OPT HL12VAZ12-21 (V92215)) (OPT HL12VAZ12-21 (V97928)) (OPT L802-12K21 (V06725)) (OPT HL12VAZ12-21 (VOPTK6)) (OPT HL12VAZ12-21 (V60516))		5
690	HL12VAZ14-34		..BOLT- (V17446) (SPEC BACB30NX14K34) (OPT HL12VAZ14-34 (V60516)) (OPT HL12VAZ14-34 (VOPTK6)) (OPT HL12VAZ14-34 (V97928)) (OPT L802-14K34 (V06725)) (OPT HL12VAZ14-34 (V92215)) (OPT HL12VAZ14-34 (V73197)) (OPT HL12VAZ14-34 (V56878))		1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
695	HL12VAZ10-6		..BOLT- (V56878) (SPEC BACB30NX10K6) (OPT HL12VAZ10-6 (V73197)) (OPT HL12VAZ10-6 (V92215)) (OPT HL12VAZ10-6 (V97928)) (OPT L802-10K6 (V06725)) (OPT HL12VAZ10-6 (VOPTK6)) (OPT HL12VAZ10-6 (V60516))		4
700	HST10AG10-10		..BOLT- (VOPTK6) (SPEC BACB30VT10K10) (OPT HST10AG10-10 (V06725)) (OPT HST10AG10-10 (V56878)) (OPT HST10AG10-10 (V73197))		4
705	HST10AG10-6		..BOLT- (VOPTK6) (SPEC BACB30VT10K6) (OPT HST10AG10-6 (V06725)) (OPT HST10AG10-6 (V56878)) (OPT HST10AG10-6 (V73197))		32
710	BACN10YT6CD		..NUT		20
715	BACN10YT7CD		..NUT		1
720	BACN10YT5CD		..NUT		4
725	BACN10ZV5		..NUT		36
730	113T1226-55		..PLATE-OUTER		1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
735	113T1226-56		..PLATE-OUTER		1
740	113T1226-53		..BEAM-INNER		1

- Item Not Illustrated