TO: ALL HOLDERS OF TRAILING EDGE FLAP DRIVE POSITION TRANSMITTER GEARBOX AND HOUSING ASSEMBLY COMPONENT MAINTENANCE MANUAL 27-58-11

REVISION NO. 11 DATED JUL 01/00

HIGHLIGHTS

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

| CHAPTER/SECTION AND PAGE NO. | DESCRIPTION OF CHANGE |
|---|---|
| TITLE PAGE<br>1<br>REPAIR 3-1<br>601-603<br>701,703<br>1002-1007,1011-1017 | Added 256T3760-5, -6 gearbox assemblies with new housing assemblies with changed drain ports. |
| TITLE PAGE<br>1<br>TR & SB RECORD<br>1<br>REPAIR 4-1<br>601-602<br>701,703<br>1002,1004-1007,<br>1011-1017,1019-1020 | Added 256T3670-7, -8 gearbox assemblies with new cover assemblies with relocated nutplates per PRR B12761. |
| REPAIR-GEN<br>601-602 | Added Standard Practices. |
| REPAIR-GEN<br>602-603 | Updated True Position Dimensioning Symbols. |
| REPAIR-GEN<br>602<br>REPAIR 8-1<br>601 | Added Type 89 adhesive. |



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| CHAPTER/SECTION AND PAGE NO. | DESCRIPTION OF CHANGE |
|---|---|
| REPAIR 7-1<br>601 | Added optional drain port cover. |
| 1019-1020 | Edited without technical change. |



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COMPONENT
MAINTENANCE MANUAL

# TRAILING EDGE FLAP DRIVE POSITION TRANSMITTER GEARBOX AND HOUSING ASSEMBLY

# PART NUMBERS 256T3760-3 THRU -8 256T3767-1

COMPONENT MAINTENANCE MANUAL
WITH
ILLUSTRATED PARTS LIST



T21620

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REVISION RECORD

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

| REVISION NUMBER | REVISION DATE | DATE FILED | BY | REVISION NUMBER | REVISION DATE | DATE FILED | BY |
|---|---|---|---|---|---|---|---|
| | | | | | | | |

T21611



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TEMPORARY REVISION AND SERVICE BULLETIN RECORD

| BOEING SERVICE BULLETIN | BOEING TEMPORARY REVISION | OTHER DIRECTIVE | DATE OF INCORPORATION INTO MANUAL |
|---|---|---|---|
| 27-0058 | | PRR B10500-10<br>PRR B11438<br><br>PRR B12761 | APR 10/82<br>JAN 01/90<br>JAN 01/90<br>JUL 01/00 |



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| PAGE | DATE | CODE |
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| 27-58-11 | | |
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| *1 | JUL 01/00 | 01.1 |
| 2 | BLANK | |
| REVISION RECORD | | |
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| TR & SB RECORD | | |
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| 1 | JAN 01/90 | 01.1 |
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| 302 | BLANK | |
| CHECK | | |
| 501 | JAN 01/90 | 01.1 |
| 502 | BLANK | |
| REPAIR-GENERAL | | |
| *601 | JUL 01/00 | 01.1 |
| *602 | JUL 01/00 | 01.1 |
| *603 | JUL 01/00 | 01.1 |

| PAGE | DATE | CODE |
|---|---|---|
| REPAIR-GENERAL | | CONT. |
| 604 | BLANK | |
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| 601 | JAN 01/90 | 01.1 |
| 602 | JAN 01/90 | 01.1 |
| REPAIR 2-1 | | |
| 601 | JAN 01/90 | 01.1 |
| 602 | BLANK | |
| REPAIR 3-1 | | |
| *601 | JUL 01/00 | 01.1 |
| *602 | JUL 01/00 | 01.1 |
| *603 | JUL 01/00 | 01.1 |
| 604 | BLANK | |
| REPAIR 4-1 | | |
| *601 | JUL 01/00 | 01.1 |
| *602 | JUL 01/00 | 01.1 |
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| *601 | JUL 01/00 | 01.1 |
| 602 | BLANK | |
| REPAIR 8-1 | | |
| *601 | JUL 01/00 | 01.1 |
| 602 | BLANK | |
| REPAIR 9-1 | | |
| 601 | JAN 01/90 | 01.1 |
| 602 | BLANK | |

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| PAGE | DATE | CODE |
|---|---|---|
| REPAIR 10-1 | | |
| 601 | JAN 01/90 | 01.1 |
| 602 | JAN 01/90 | 01.1 |
| REPAIR 11-1 | | |
| 601 | JAN 01/90 | 01.1 |
| 602 | JAN 01/90 | 01.1 |
| REPAIR 12-1 | | |
| 601 | JAN 01/90 | 01.1 |
| 602 | JAN 01/90 | 01.1 |
| REPAIR 13-1 | | |
| 601 | JAN 01/90 | 01.1 |
| 602 | JAN 01/90 | 01.1 |
| ASSEMBLY | | |
| *701 | JUL 01/00 | 01.1 |
| 702 | JUL 01/90 | 01.101 |
| *703 | JUL 01/00 | 01.1 |
| 704 | JAN 01/90 | 01.1 |
| 705 | JAN 01/90 | 01.1 |
| 706 | BLANK | |
| FITS AND CLEARANCES | | |
| 801 | JAN 01/90 | 01.1 |
| 802 | JAN 01/90 | 01.1 |
| 803 | JAN 01/90 | 01.1 |
| 804 | JAN 01/90 | 01.1 |
| 805 | JAN 01/90 | 01.1 |
| 806 | JAN 01/90 | 01.1 |
| ILLUSTRATED PARTS LIST | | |
| 1001 | JAN 01/90 | 01.1 |
| *1002 | JUL 01/00 | 01.1 |
| *1003 | JUL 01/00 | 01.1 |
| *1004 | JUL 01/00 | 01.1 |
| *1005 | JUL 01/00 | 01.1 |
| *1006 | JUL 01/00 | 01.1 |
| *1007 | JUL 01/00 | 01.1 |
| 1008 | BLANK | |
| *1009 | JUL 01/00 | 01.1 |
| *1010 | JUL 01/00 | 01.1 |

| PAGE | DATE | CODE |
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| *1014 | JUL 01/00 | 01.1 |
| *1015 | JUL 01/00 | 01.1 |
| *1016 | JUL 01/00 | 01.1 |
| *1017 | JUL 01/00 | 01.1 |
| *1018 | JUL 01/00 | 01.1 |
| *1019 | JUL 01/00 | 01.1 |
| *1020 | JUL 01/00 | 01.1 |

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TABLE OF CONTENTS



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



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# INTRODUCTION

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

This manual is divided into separate sections:

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

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

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

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

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

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

Verification:

| | |
|---|---|
| Disassembly | MAR 29/83 |
| Assembly | MAR 29/83 |



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## TRAILING EDGE FLAP DRIVE POSITION TRANSMITTER GEARBOX AND HOUSING ASSEMBLY

### DESCRIPTION AND OPERATION

1. The TE flap drive position transmitter gearbox assembly consists of two meshing gears in an aluminum alloy housing and cover. The gearbox assembly provides signals for monitoring and controlling any possible asymmetric condition as well as providing flap position signals to the flight deck indicators and flap position modules.

2. The TE flap drive shaft bearing support housing assembly consists of an aluminum housing. The housing assembly is used to support the drive shaft bearing for the TE flap drive.

3. Leading Particulars (Approximate)

   A. Length -- 8 inches

   B. Width -- 6 inches

   C. Height -- 9 inches

   D. Weight -- 7 pounds



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## DISASSEMBLY

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

1. Remove Shaft Assembly (If applicable) (Ref IPL Fig. 1 and 2)

   A. Remove nut (220) and washer (225), then remove sleeve (230), sleeves (240A, IPL Fig. 1; 240, IPL Fig. 2) and coupling (235) from shaft assembly (270). Separate parts (230 thru 240A, IPL Fig. 1; 230 thru 240 IPL Fig. 2).

   B. Remove parts (250, 255), retainer (260) and shield (245). Remove shaft assembly and bearing (265) from gearbox.

      NOTE: Do not disassemble shaft assembly or remove bearing (265) from shaft assembly unless necessary for repair or replacement.

2. Disassemble Gearbox Assembly (Ref IPL Fig. 1)

   A. Remove bolt (10), washer (15) and fitting (20) from cover assembly (25A or 30A).

   B. Remove parts (35 thru 45) and remove cover assembly from housing assembly (180 or 185). Remove bearing (160).

      NOTE: Do not disassemble cover assembly or remove nameplate (210) from cover unless necessary for repair or replacement.

   C. Remove parts (85 thru 100) and remove gear assembly (105). Remove bearings (125, 187) and spacer (130) from housing assembly.

      NOTE: Do not disassemble gear assembly unless necessary for repair or replacement.

   D. Remove nut (135) and washer (140), then slide drive tang (145) off of driver gear (155). Remove key (150).

   E. Remove driver gear (155) and bearing (160) from housing assembly. Remove parts (165 thru 175) from housing assembly.

      NOTE: Do not disassemble housing assembly (180 or 185) unless necessary for repair or replacement.



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CHECK

1. Check all parts for obvious defects in accordance with standard industry practices. Refer to FITS AND CLEARANCES for design dimensions and wear limits.

2. Magnetic particle check per 20-20-01 -- driver gear (155, IPL Fig. 1), shield (245), fitting (280), shaft (285).

3. Penetrant check per 20-20-02 -- Cover (75A, IPL Fig. 1; 80A, IPL Fig. 1), collar (115, IPL Fig. 1), gear (120, IPL Fig. 1), drive tang (145, IPL Fig. 1), cover (175, IPL Fig. 1), housing (200, IPL Fig. 1; 205, IPL Fig. 1; 10, IPL Fig. 2), retainer (260, IPL Fig. 1), sleeve (230, IPL Fig. 1), coupling (235, IPL Fig. 1).



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# REPAIR - GENERAL

1. Content

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

| P/N | NAME | REPAIR |
|---|---|---|
| 256T3751 | SHAFT | 1-1 |
| 256T3753 | FITTING, END | 2-1 |
| 256T3761 | HOUSING | 3-1 |
| 256T3763 | COVER | 4-1 |
| 256T3773 | SHIELD | 5-1 |
| 256T3749 | COUPLING | 6-1 |
| 65B81978 | COVER | 7-1 |
| BAC27TCT0002 | NAMEPLATE | 8-1 |
| - - | MISC PARTS REFINISH | 9-1 |
| 256T3768 | GEAR | 10-1 |
| 256T3764 | GEAR | 11-1 |
| 256T3769 | TANG, DRIVE | 12-1 |
| 256T3767 | HOUSING | 13-1 |

2. Standard Practices

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

20-10-01 Repair and Refinish of High Strength Steel Parts
20-10-02 Machining of Alloy Steel
20-10-03 Shot Peening
20-10-04 Grinding of Chrome Plated Parts
20-10-05 Application and Finishing of Thermal Spray Coatings
20-30-02 Stripping of Protective Finishes



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20-41-01 Decoding Table for Boeing Finish Codes
20-41-02 Application of Chemical and Solvent Resistant Finishes
20-42-03 Hard Chrome Plating
20-42-05 Bright Cadmium Plating
20-43-01 Chromic Acid Anodizing
20-50-03 Bearing and Bushing Replacement
20-50-10 Application of Stencils, Insignia, Silk Screen, Part Numbering and Identification Markings
20-50-12 Application of Adhesives
20-60-02 Finishing Materials
20-60-03 Lubricants
20-60-04 Miscellaneous Materials

3. Material

NOTE: Equivalent substitutes may be used.

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

B. Corrosion Preventive Compound -- MIL-C-11796, Class 1 (Ref 20-60-02)

C. Grease -- MIL-G-23827 (Ref 20-60-03)

D. Grease -- BMS 3-24 (Ref 20-60-03)

E. Adhesive -- Type 70 (BMS 5-92, Type III) (Ref 20-60-04)

F. Adhesive -- Type 89 (BMS 5-105) (Ref 20-60-04)

4. Dimensioning Symbols

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



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

## EXAMPLES

| | |
|---|---|
| — \| 0.002 | STRAIGHT WITHIN 0.002 |
| ⊥ \| 0.002 \| B | PERPENDICULAR TO B WITHIN 0.002 |
| // \| 0.002 \| A | PARALLEL TO A WITHIN 0.002 |
| ○ \| 0.002 | ROUND WITHIN 0.002 |
| ⌭ \| 0.010 | CYLINDRICAL SURFACE MUST LIE BETWEEN TWO CONCENTRIC CYLINDERS, ONE OF WHICH HAS A RADIUS 0.010 INCH GREATER THAN THE OTHER |
| ⌒ \| 0.006 \| A | EACH LINE ELEMENT OF THE SURFACE AT ANY CROSS SECTION MUST LIE BETWEEN TWO PROFILE BOUNDARIES 0.006 INCH APART RELATIVE TO DATUM PLANE A |
| ⌓ \| 0.020 \| A | SURFACES MUST LIE WITHIN PARALLEL BOUNDARIES 0.02 INCH APART AND EQUALLY DISPOSED ABOUT TRUE PROFILE |
| ◎ \| ∅ 0.0005 \| C | CONCENTRIC TO C WITHIN 0.0005 DIAMETER |
| ≡ \| 0.010 \| A | SYMMETRICAL WITH A WITHIN 0.010 |
| ∠ \| 0.005 \| A | ANGULAR TOLERANCE 0.005 WITH A |
| ⌖ \| ∅ 0.002 Ⓢ \| B | LOCATED AT TRUE POSITION WITHIN 0.002 DIA RELATIVE TO DATUM B, REGARDLESS OF FEATURE SIZE |
| ⊥ \| ∅ 0.010 Ⓜ \| A<br>0.510 Ⓟ | AXIS IS TOTALLY WITHIN A CYLINDER OF 0.010-INCH DIAMETER, PERPENDICULAR TO, AND EXTENDING 0.510-INCH ABOVE, DATUM A, MAXIMUM MATERIAL CONDITION |
| [2.000]<br>OR<br>2.000<br>BSC | THEORETICALLY EXACT DIMENSION IS 2.000 |

NOTE: DATUM MAY APPEAR AT EITHER SIDE OF TOLERANCE FRAME

0.020 | A

A | 0.020

True Position Dimensioning Symbols
Figure 601



13223

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SHAFT ASSEMBLY - REPAIR 1-1

256T3751-1

NOTE: Refer to REPAIR-GEN for list of applicable standard practices. For repair of surfaces which may only require stripping and restoration of original finish, refer to Refinish instruction, Fig. 601 and Repair 2-1.

1. End Fitting Replacement (Ref IPL Fig. 1 and 2)

   A. Remove rivets (275) and end fitting (280).

   B. Position replacement end fitting per Fig. 601 and drill rivet holes using holes in shaft (285) as pattern.

   C. Install end fitting in shaft and rivet in place as shown. Install rivets with grease, BMS 3-24.

   D. Check that rivets are seated at shaft OD tangent point as a minimum and that parts are free of radial play.

2. Bearing Seat Repair (Fig. 601)

   A. Machine bearing seat as required, within repair limit shown, to remove defects.

   B. Shot peen as indicated.

   C. Build up repaired area with chrome plate, and grind to design dimensions and finish shown. Chrome plate must not exceed 0.010 inch after grinding.



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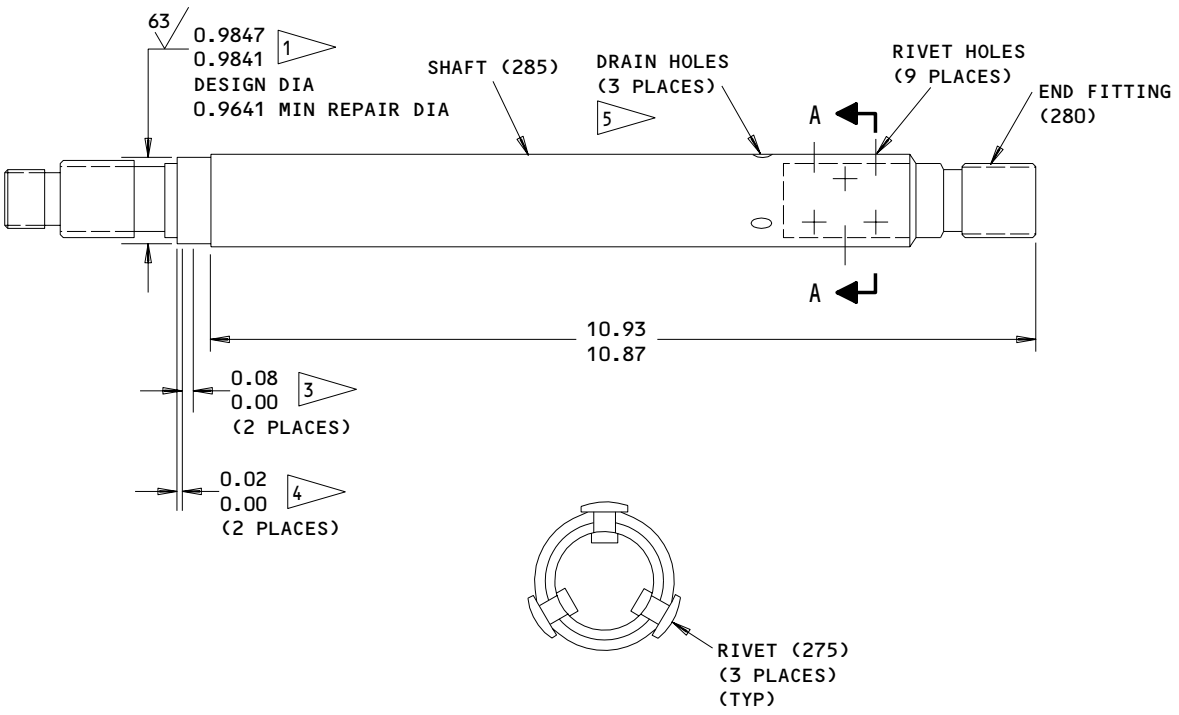


A-A

REFINISH

SHAFT (285):
CADMIUM PLATE (F-15.02) ALL OVER EXCEPT AS NOTED BY 1. ON INTERNAL BORES, PHOSPHATE COAT (F-18.02) AND APPLY TWO COATS OF BMS 10-11, TYPE 1 PRIMER (F-20.03) PLUS CORROSION PREVENTIVE COMPOUND MIL-C-11796, CLASS 1 (F-19.03). APPLY 1 COAT OF BMS 10-11, TYPE 1 PRIMER (F-20.02) ON ALL OD'S EXCEPT BEARING SEAT, SPLINE AND THREADS

1 DO NOT PLATE

FOR REFINISH OF END FITTING (280), REFER TO REPAIR 2-1.

2 BUILD UP WITH CHROME PLATE (F-15.03) AND GRIND TO DESIGN DIMENSIONS AND FINISH SHOWN. OBSERVE RUNOUT AT EDGES AND RELIEF GROOVE AS INDICATED

3 PLATING RUNOUT

4 END OF PLATING

5 ENSURE DRAIN HOLES ARE CLEAR

REPAIR

REF 2 3 4

125 ALL MACHINED SURFACES EXCEPT AS NOTED

BREAK SHARP EDGES 0.01-0.02 R

SHOT PEEN: SHOT NO. 170-460
INTENSITY 0.016A
COVERAGE 2.0

MATERIAL: 4340 STEEL, 150-170 KSI

ALL DIMENSIONS ARE IN INCHES

SHAFT (285) SHOWN. OPTIONAL SHAFT (285A) IDENTICAL EXCEPT FOR RIVET PATTERN

256T3751-1
Shaft Assembly Repair
Figure 601



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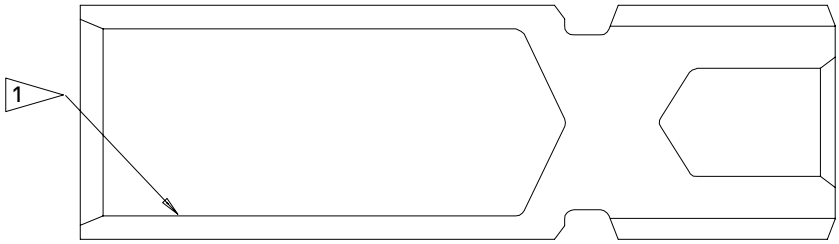
FITTING, END - REPAIR 2-1

256T3753-1

1. Plating Repair

NOTE: Repair consists of restoration of original finish. Refer to Refinish instructions, Fig. 601 and to REPAIR-GEN for list of applicable standard practices.




REFINISH

CADMIUM PLATE (F-15.02) ALL OVER EXCEPT AS NOTED IN 1

1 PHOSPHATE COAT (F-18.02) AND APPLY 2 COATS OF BMS 10-11, TYPE 1 PRIMER (F-20.03). COAT ID WITH CORROSION PREVENTIVE COMPOUND, MIL-C-11796, CLASS 1 (F-19.03)

MATERIAL: 4340 STEEL, 150-170 KSI

Fitting Refinish
Figure 601

T21614



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## HOUSING ASSEMBLY - REPAIR 3-1

256T3761-1, -2, -7, -8

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

1. Bearing Replacement (Ref IPL Fig. 1)

   A. Remove bearing (187).

   B. Lightly coat all surfaces of replacement bearing with grease, MIL-G-23827, and install in housing.

2. Mounting Surface Repair (Fig. 601)

   A. Machine mounting surfaces to remove corrosion and defects. Maximum material removal 0.010.

3. Bearing Seat Repair (Fig. 601)

   A. Machine bearing seats as required, within wear limit shown, to remove defects.

   B. Build up repaired area with plasma flame spray coating per 20-10-05 (BMS 10-67, type 10).

   C. Machine to design dimensions and finish shown.



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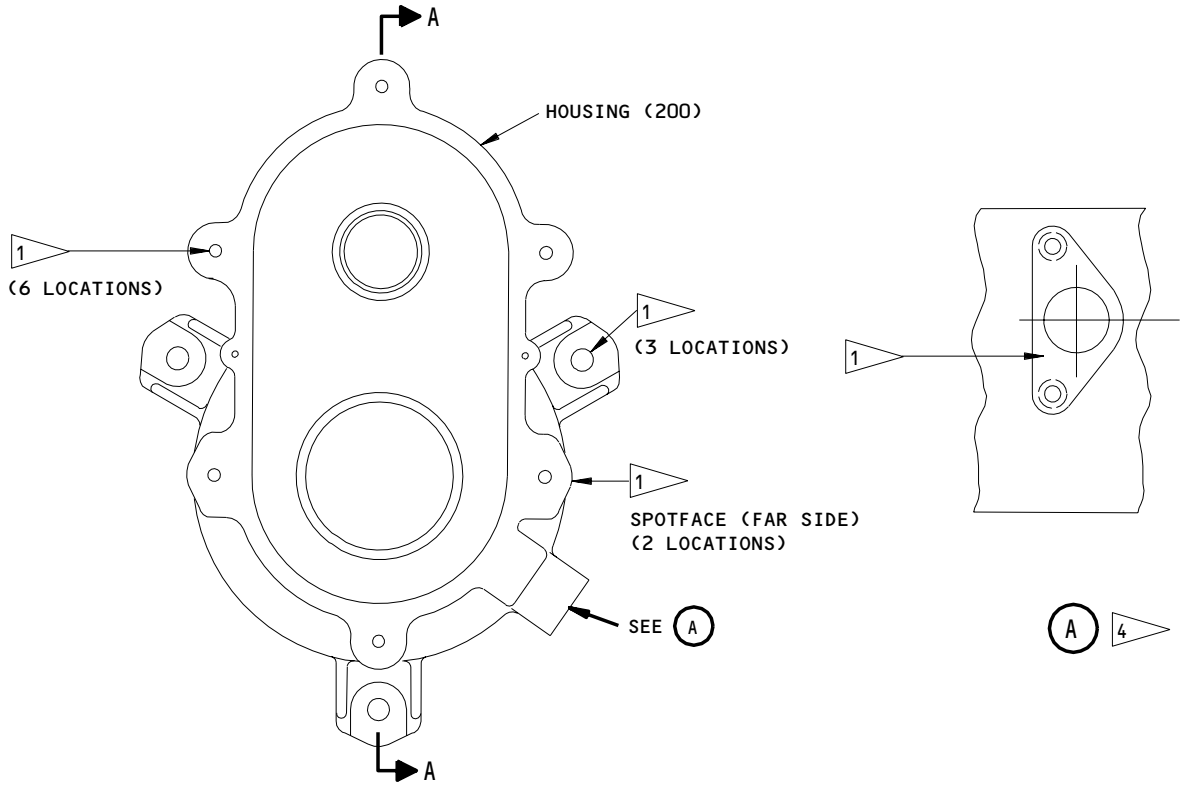


256T3761-1,-7 SHOWN
256T3761-2,-8 OPPOSITE

256T3761-1,-2,-7,-8
Housing Assembly Repair
Figure 601 (Sheet 1)



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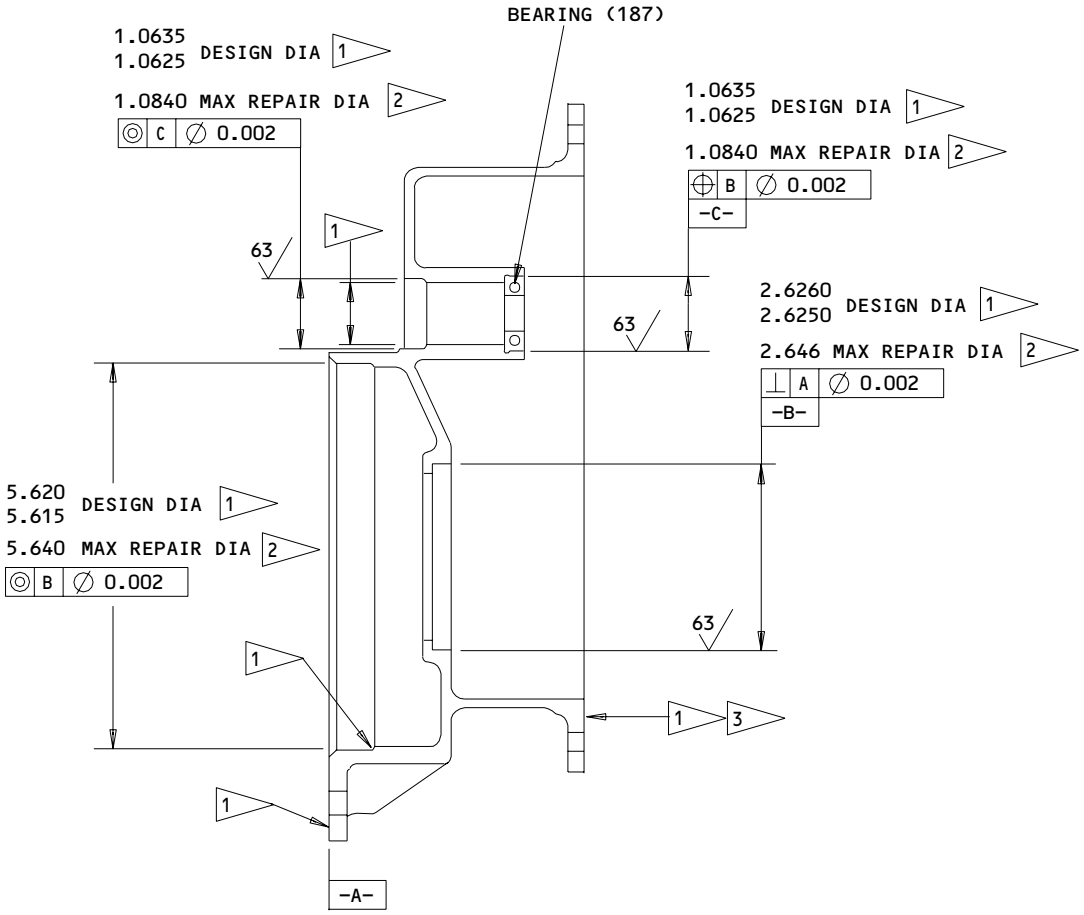


A-A

REFINISH

ANODIZE (F-17.05) AND APPLY 1 COAT OF BMS 10-11, TYPE 1 PRIMER (F-20.02) EXCEPT OMIT PRIMER AS NOTED.

1. NO PRIMER ON THIS SURFACE
2. BUILD UP WITH PLASMA FLAME SPRAY COATING AS SHOWN IN SOPM 20-10-05 (BMS 10-67, TYPE 10) AND MACHINE TO DESIGN DIMENSIONS AND FINISH
3. MACHINE AS REQUIRED (0.010 MAX) TO REMOVE DEFECTS
4. 256T3761-1,-2 ONLY

REPAIR

REF 2 3

MATERIAL: AL ALLOY

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

256T3761-1,-2,-7,-8
Housing Assembly Repair
Figure 601 (Sheet 2)



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COVER - REPAIR 4-1

256T3763-8, -9, -12, -13

1. Plating Repair

   NOTE: Repair consists of restoration of original finish. Refer to Refinish instructions, Fig. 601 and to REPAIR-GEN for list of applicable standard practices.

2. Mounting Surface Repair

   A. Machine mounting surface to remove defects and corrosion. Maximum material removal 0.010.

3. Bearing Seat Repair

   A. Machine bearing seat, within wear limit shown, to remove defects.

   B. Build up repaired area with plasma flame spray coating per 20-10-05 (BMS 10-67, type 10).

   C. Machine to design dimensions and finish shown.



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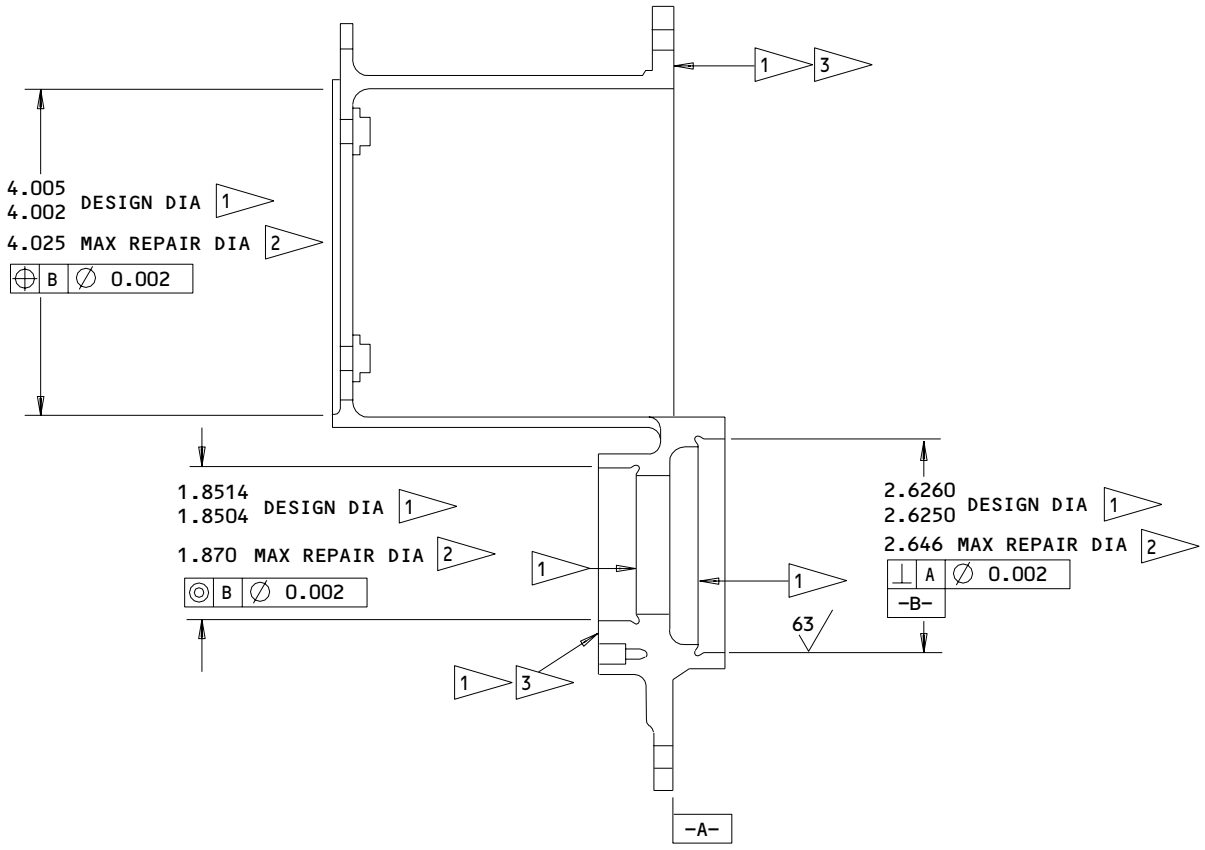


REFINISH

ANODIZE (F-17.05) AND APPLY 1 COAT OF BMS 10-11, TYPE 1 PRIMER (F-20.02) EXCEPT OMIT PRIMER AS NOTED.

1. NO PRIMER ON THIS SURFACE
2. BUILD UP WITH PLASMA FLAME SPRAY COATING AS SHOWN IN SOPM 20-10-05 (BMS 10-67, TYPE 10) AND MACHINE TO DESIGN DIMENSIONS AND FINISH
3. MACHINE AS REQUIRED (0.010 MAX) TO REMOVE DEFECTS

REPAIR

REF 2 3

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

256T3763-8,-9,-12,-13
Cover Repair
Figure 601

T21616



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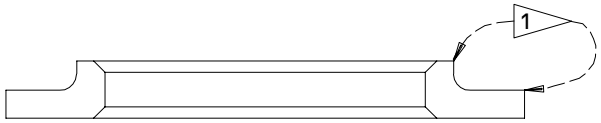
SHIELD, BEARING - REPAIR 5-1

256T3773-1

1. Plating Repair

NOTE: Repair consists of restoration of original finish. Refer to Refinish instructions, Fig. 601 and to REPAIR-GEN for list of applicable standard practices.




REFINISH

CADMIUM PLATE (F-15.02) AND APPLY 1 COAT OF BMS 10-11, TYPE 1 PRIMER EXCEPT OMIT PRIMER AS NOTED BY 1

MATERIAL: 4340 STEEL, 150-170 KSI

Shield Refinish
Figure 601

T21617



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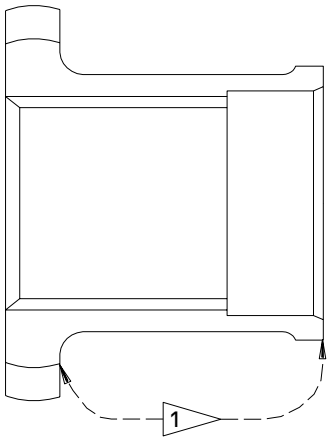
COUPLING - REPAIR 6-1

256T3749-1

1. Plating Repair

NOTE: Repair consists of restoration of original finish. Refer to Refinish instructions, Fig. 601 and to REPAIR-GEN for list of applicable standard practices.




REFINISH

CADMIUM PLATE (F-15.02)
ALL OVER AND APPLY 1 COAT
OF BMS 10-11, TYPE 1 PRIMER
(F-20.02) AS INDICATED BY 1

MATERIAL: 4340 STEEL, 150-170 KSI

Coupling Refinish
Figure 601

12512



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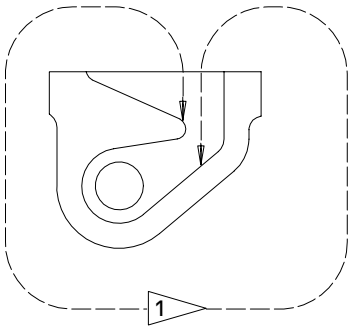
COVER - REPAIR 7-1

65B81978-3, -4

1. Plating Repair

NOTE: Repair consists of restoration of original finish. Refer to Refinish instructions, Fig. 601 and to REPAIR-GEN for list of applicable standard practices.




REFINISH

CHROMIC ACID ANODIZE (F-17.02) ALL OVER
AND APPLY 1 COAT OF BMS 10-11, TYPE 1 PRIMER
(F-20.02) TO SURFACES INDICATED BY 1

MATERIAL: AL ALLOY

Cover Refinish
Figure 601

T21619



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NAMEPLATE - REPAIR 8-1

BAC27TCT0002

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

1. Nameplate Replacement (Ref IPL Fig. 1)

   A. Steel stamp assembly number and serial number on nameplate (210).

   B. Bend to conform to cover (75A or 80A) contour at location shown in IPL Fig. 1. Bond nameplate in place with adhesive per 20-50-12, type 89 (type 70 optional). Make sure that the adhesive covers 100 percent of the faying surface.



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MISCELLANEOUS PARTS REFINISH - REPAIR 9-1

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

| IPL FIG. & ITEM | MATERIAL | FINISH |
|---|---|---|
| Fig. 1 | | |
| Fitting (20) | Al alloy | Chemical treat and apply one coat BMS 10-11, type 1 primer (F-18.05) all over. |
| Collar (115) | Al alloy | Chromic acid anodize and apply one coat BMS 10-11, type 1 primer (F-18.13) all over. |
| Gear (120) | Al alloy | Chromic acid anodize and apply 1 coat BMS 10-11, type 1 primer (F-18.13) except no primer on gear teeth. |
| Sleeve (230) | 4140 Steel 150-170 ksi | Cadmium plate (F-15.02) all over. |
| Retainer (260) | Al alloy | Chromic acid or sulfuric acid anodize (F-17.05) and apply one coat BMS 10-11, type 1 primer. |

Refinish Details
Figure 601



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DRIVER GEAR - REPAIR 10-1

256T3768-1

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

1. Bearing Replacement (IPL Fig. 1, Fig. 601)

   A. Remove bearing (160).

   B. Install new bearing (160) per 20-50-03).

2. Bearing Seat Repair (Fig. 601)

   A. Machine bearing seat as required, within repair limit shown, to remove defects.

   B. Shot peen as indicated.

   C. Build up repaired area with chrome plate, and grind to design dimensions and finish shown. Chrome plate must not exceed 0.010 inch after grinding.

3. Drive Tang Seat Repair

   A. Machine drive tang seat, within repair limit shown, to remove defects.

   B. Build up repaired area with plasma flame spray coating per 20-10-05 (BMS 10-67, type 11).

   C. Machine to design dimensions and finish shown.

   D. Machine keyway to dimensions shown.



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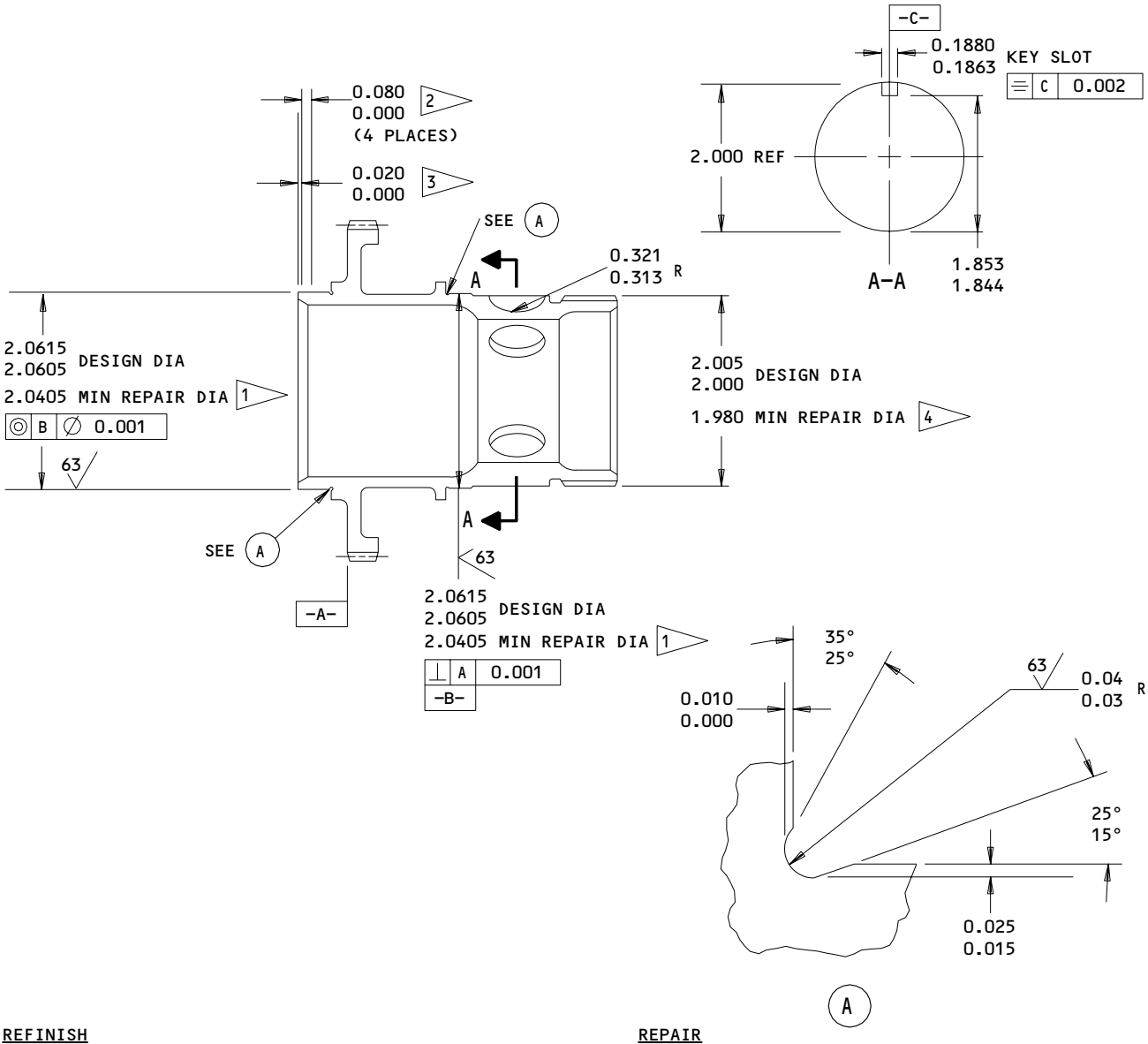


REFINISH

CADMIUM PLATE (F-15.02) ALL OVER

1 BUILD UP WITH CHROME PLATE (F-15.03) AND GRIND TO DESIGN DIMENSIONS AND FINISH SHOWN. OBSERVE RUNOUT AT EDGES AND RELIEF GROOVE AS INDICATED

2 PLATING RUNOUT

3 END OF PLATING

4 BUILD UP WITH PLASMA FLAME SPRAY COATING PER 20-10-05 (BMS 10-67, TYPE 11) AND MACHINE TO DESIGN DIMENSIONS AND FINISH SHOWN

REPAIR

REF 1 2 3 4

125 ALL MACHINED SURFACES EXCEPT AS NOTED

BREAK SHARP EDGES 0.01-0.02 R

SHOT PEEN: SHOT NO. 170-460
INTENSITY 0.006A
COVERAGE 2.0

MATERIAL: 4340M STEEL 180-200 KSI

ALL DIMENSIONS ARE IN INCHES

256T3768-1
Driver Gear Repair
Figure 601



182291

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GEAR ASSEMBLY - REPAIR 11-1

256T3764-1

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

1. Bearing Seat Repair

   A. Machine bearing seats as required, within repair limit shown, to remove defects.

   B. Build up repaired area with plasma flame spray coating per 20-10-05 (BMS 10-67, type 10).

   C. Machine to design dimensions and finish shown.

2. Slot Repair

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

   B. Build up repaired area with plasma flame spray coating per 20-10-05 (BMS 10-67, type 10).

   C. Machine to design dimensions and finish shown.



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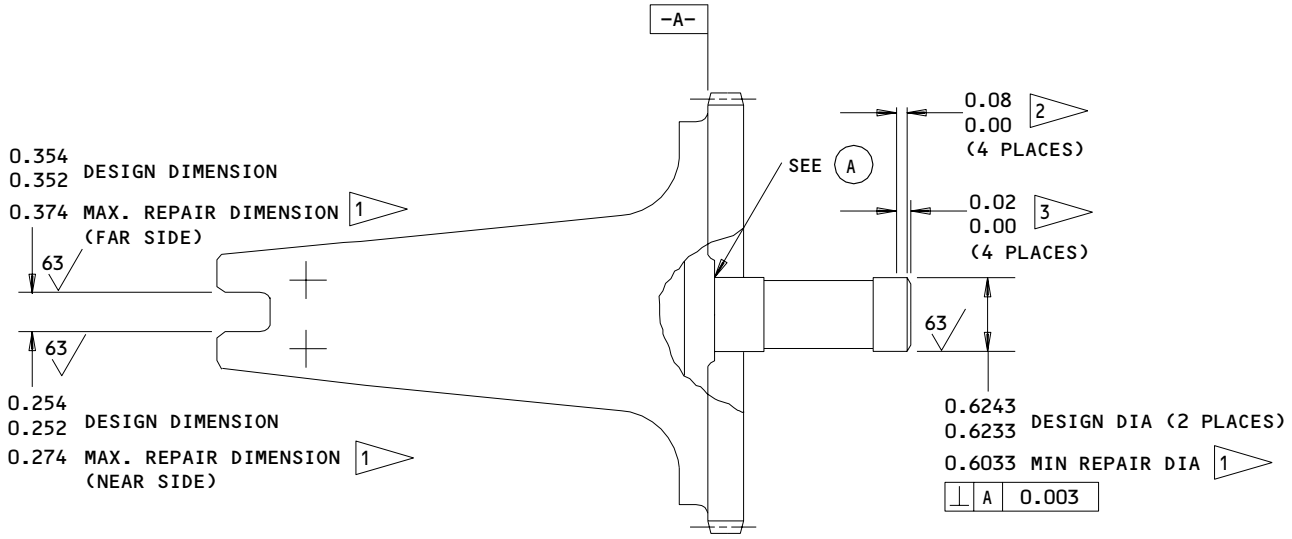


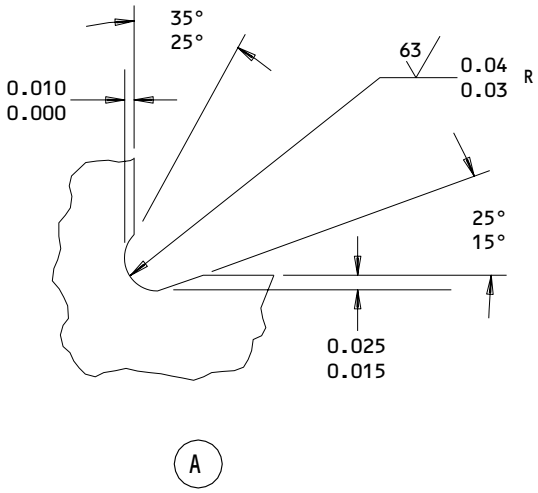


REFINISH

CHROMIC ACID ANODIZE AND APPLY ONE COAT OF BMS 10-11 TYPE 1 PRIMER (F-18.13) EXCEPT NO PRIMER ON GEAR TEETH

1 BUILD UP WITH PLASMA FLAME SPRAY COATING PER 20-10-05 (BMS 10-67, TYPE 10) AND MACHINE TO DESIGN DIMENSIONS AND FINISH SHOWN

2 PLATING RUNOUT

3 END OF PLATING

REPAIR

REF 1 2 3

125 ALL MACHINED SURFACES EXCEPT AS NOTED

BREAK SHARP EDGES 0.01-0.02 R

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

256T3764-1
Driven Gear Repair
Figure 601



182293

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DRIVE TANG - REPAIR 12-1

256T3769-1

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

1. I.D. Repair

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

   B. Build up with plasma flame spray coating per 20-10-05 (BMS 10-67, type 10).

   C. Machine to design dimensions and finish shown.

   D. Remachine keyway.

2. Drive Tang Repair

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

   B. Build up with plasma flame spray coating per 20-10-05 (BMS 10-67, type 10).

   C. Machine to design dimensions and finish shown.



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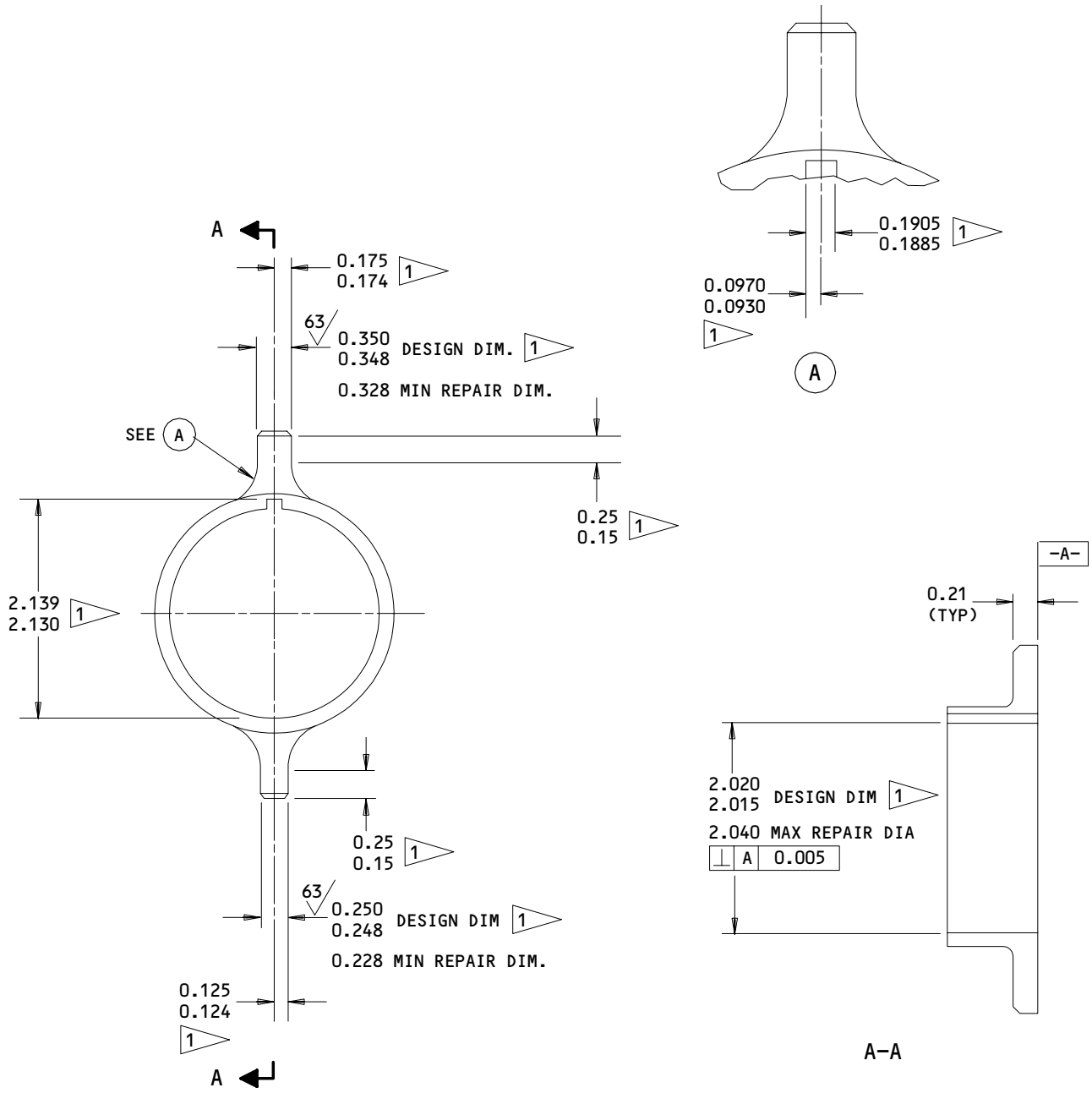


REFINISH

CHROMIC ACID ANODIZE PER 20-43-01

1 BUILD UP WITH PLASMA FLAME SPRAY COATING PER 20-10-05 (BMS 10-67, TYPE 10) AND MACHINE TO DESIGN DIMENSIONS AND FINISH SHOWN.

REPAIR

REF 1

125 ALL MACHINED SURFACES EXCEPT AS NOTED

BREAK ALL SHARP EDGES 0.01-0.02 R

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

256T3769-1
Drive Tang Repair
Figure 601



182278

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HOUSING - REPAIR 13-1

256T3767-2

1. Plating Repair

NOTE: Repair consists of restoration of original finish. Refer to refinish instructions, Fig. 601 and to REPAIR-GEN for list of applicable standard practices.

2. Mounting Surface Repair

A. Machine mounting surface to remove defects and corrosion. Maximum material removal 0.010.

3. Bearing Seat Repair

A. Machine bearing seat, within wear limit shown, to remove defects.

B. Build up repaired area with plasma flame spray coating per 20-10-05 (BMS 10-67, type 10).

C. Machine to design dimensions and finish shown.



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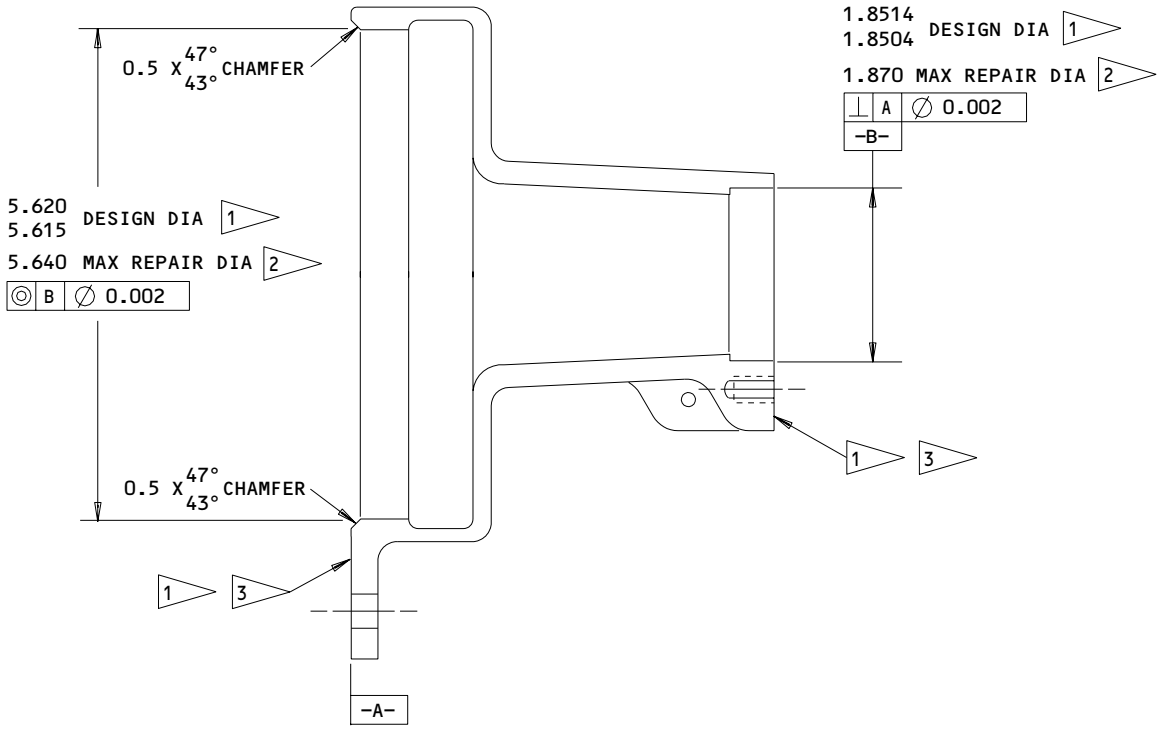


REFINISH

ANODIZE (F-17.05) AND APPLY 1 COAT OF BMS 10-11, TYPE 1 PRIMER (F-20.02) EXCEPT OMIT PRIMER AS NOTED BY 1

2 BUILD UP WITH PLASMA FLAME SPRAY COATING PER 20-10-05 (BMS 10-67, TYPE 10) AND MACHINE TO DESIGN DIMENSIONS AND FINISH

3 MACHINE AS REQUIRED (0.010 MAX) TO REMOVE DEFECTS

REPAIR

REF 2 3

MATERIAL: AL ALLOY

256T3767-1
Housing Repair
Figure 601



707832

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ASSEMBLY

1. Materials

NOTE: Equivalent substitutes may be used.

A. Grease -- MIL-G-23827 (Ref 20-60-03)

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

C. Sealant -- BMS 5-26 (Ref 20-60-04)

D. Sealant -- MIL-S-8802 (Ref 20-60-04)

2. Assembly (IPL Fig. 1)

A. On 256T3760-3, -4 assemblies only, install cover (175) on housing assembly (180 or 185) and secure with screws (165) and washers (170). Install screws with wet sealant BMS 5-95.

B. Lightly lubricate bearings (160) with grease and install bearings on driver gear (155).

CAUTION: DO NOT FILL HOUSING WITH GREASE OR OPERATION OF GEARBOX MAY BE ADVERSELY AFFECTED.

C. Coat faying surfaces and fill teeth of gear (155) with grease. Install gear then install key (150) and drive tang (145) on gear. Install washer (140) and nut (135). Tighten nut to 600-800 lb-in.

D. Lightly lubricate bearing (187) with grease and install in housing.

E. Install gear assembly (105) in housing (Ref Fig. 701).

(1) Coat faying surfaces and spline and fill teeth of gear (120) with grease.

(2) On 256T3760-3, -5, -7 assemlies, install gear assembly in housing assembly (180) with single dot index mark on gear (120) aligned with single dot index mark on gear (155). Secure with parts (85 thru 100). Install bolt (85) with wet sealant BMS 5-95.

(3) On 256T3760-4, -6, -8 assemblies, install gear assembly in housing assembly (185) with double dot index mark on gear (120) aligned with double dot index mark on gear (155). Secure with parts (85 thru 100). Install bolt (85) with wet sealant BMS 5-95.



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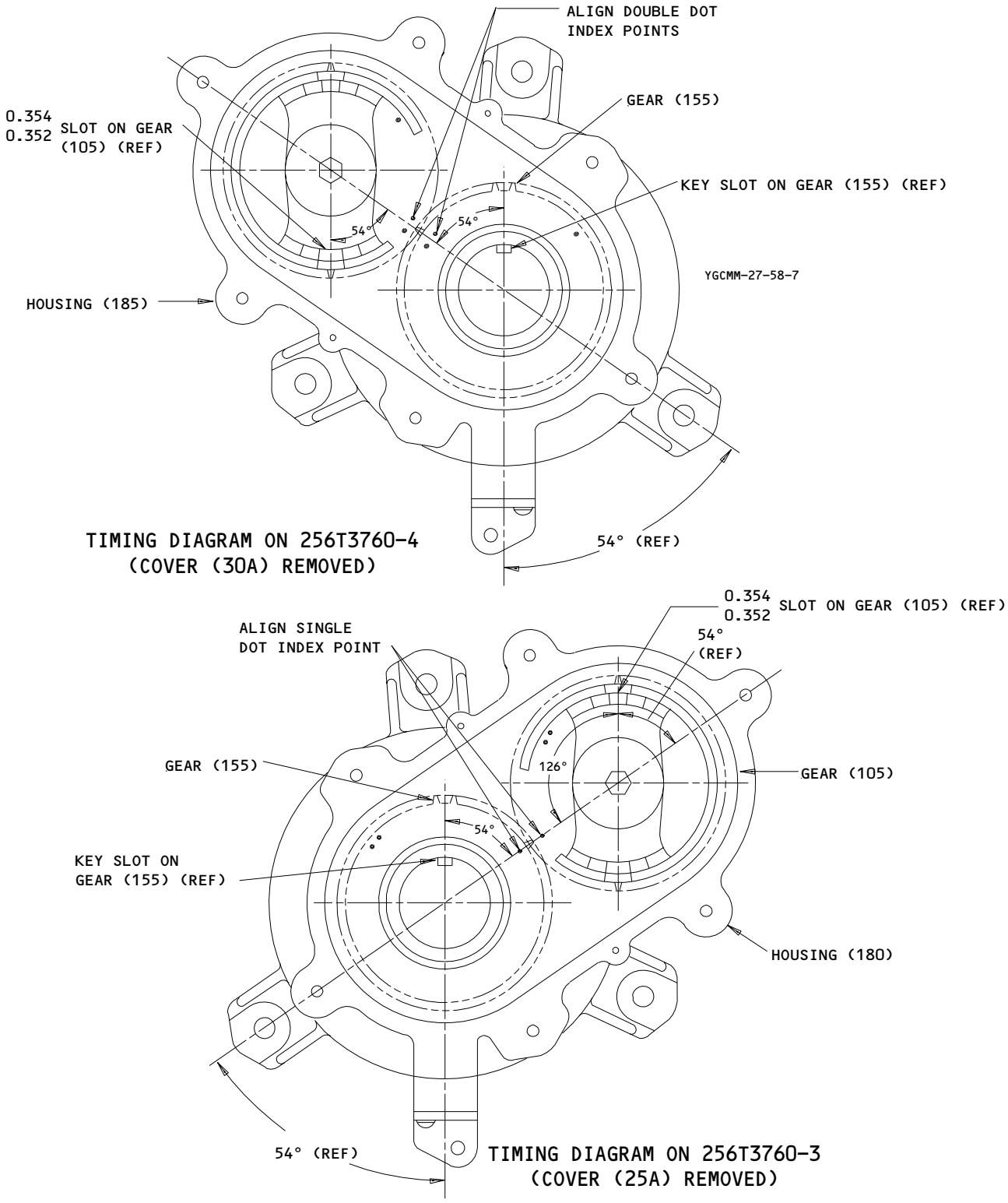


Assembly Details
Figure 701



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F. Lightly lubricate bearing (125) and spacer (130) with grease and install in housing.

G. Install cover assembly (25A or 30A) and secure with parts (35 thru 45). Install bolt (35) with wet sealant BMS 5-95. Fillet seal contact areas of cover and housing assembly with sealant BMS 5-26 (MIL-S-8802 is optional on 256T3670-3, -4 assemblies only).

H. Install fitting (20) on cover assembly and secure with parts (10, 15). Tighten bolt (10) to 45-50 lb-in.

I. Check that gears and bearings are free to rotate with no evidence of binding in any position.

J. Install shaft assembly (270) (if applicable).

(1) Press bearing (265) on shaft assembly (270) and install shaft assembly in gearbox.

(2) Install retainer (260), shield (245) and secure with parts (250, 255). Fill cavity between shield and bearing (265) with grease. Lockwire bolts (250) to cover per 20-50-02, using double twist method (Ref Fig. 702).

(3) Apply thin film of grease to gear teeth and splines of coupling (235). Install parts (230 thru 240A) on shaft and secure with parts (220, 225). Tighten nut (220) to 400-450 lb-in.

3. Assembly (IPL Fig. 2)

A. Install shaft assembly (270) (if applicable).

(1) Press bearing (265) on shaft assembly (270) and install shaft assembly in gearbox.



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(2) Install retainer (260), shield (245) and secure with parts (250, 255). Fill cavity between shield and bearing (265) with grease. Lockwire bolts (250) to cover per 20-50-02, using double-twist method (Fig. 702).

(3) Apply thin film of grease to gear teeth and splines of coupling (235). Install parts (230 thru 240) on shaft and secure with parts (220, 225). Tighten nut (220) to 400-450 pound-inches.

4. Storage

A. Use standard industry practices and information contained in 20-44-02 for storage of this component.



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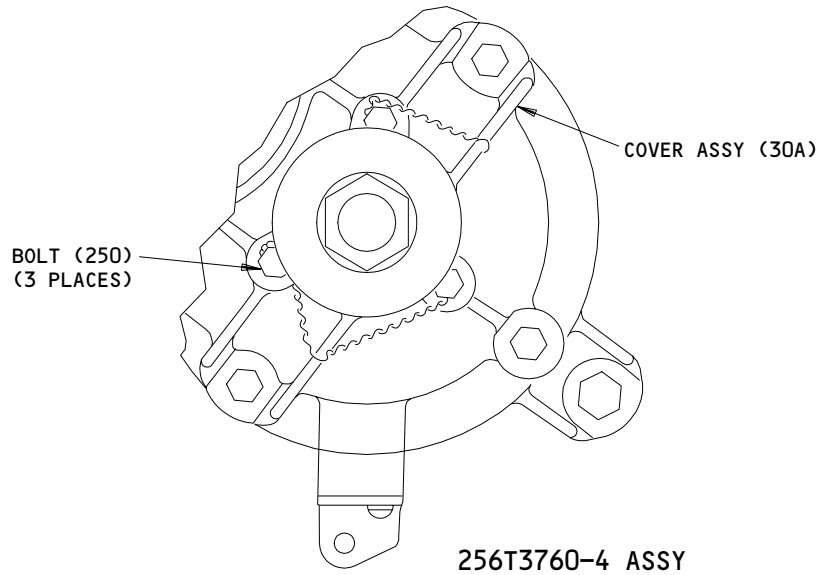
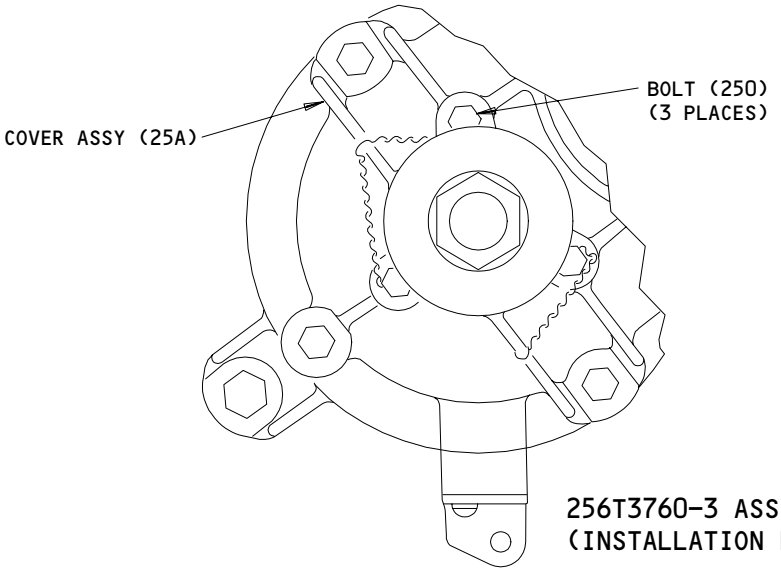



256T3760-4 ASSY
(INSTALLATION PARTS SHOWN)




256T3760-3 ASSY
(INSTALLATION PARTS SHOWN)

Lockwiring Details
Figure 702



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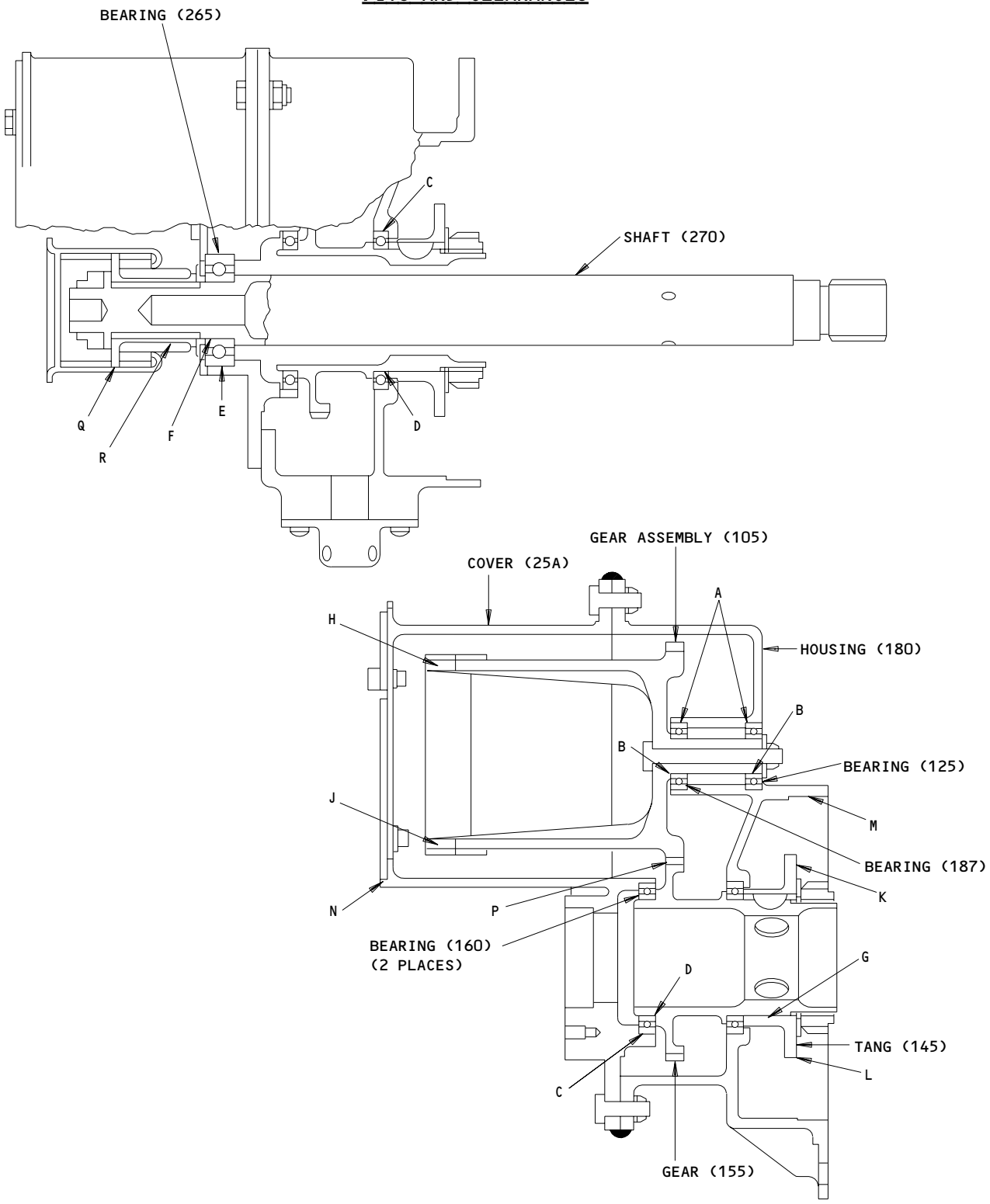
FITS AND CLEARANCES




Fits and Clearances
Figure 801 (Sheet 1)



T21624

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| Ref Letter Fig.801 | Mating Item No. IPL Fig. 1 | Design Dimension | | | | Service Wear Limit | | |
|---|---|---|---|---|---|---|---|---|
| | | Dimension | | Assembly Clearance | | Dimension | | Maximum Clearance |
| | | Min | Max | Min | Max | Min | Max | |
| A | ID 200,205<br>OD 125,187 | 1.0625<br>1.0620 | 1.0635<br>1.0625 | 0.0000 | 0.0015 | 1.0615 | 1.0640 | 0.0020 |
| B | ID 125,187<br>OD 105 | 0.6245<br>0.6233 | 0.6250<br>0.6243 | 0.0002 | 0.0017 | 0.6230 | 0.6253 | 0.0020 |
| C | ID 200,205<br>OD 160 | 2.6250<br>2.6243 | 2.6260<br>2.6250 | 0.0000 | 0.0017 | 2.6240 | 2.6263 | 0.0020 |
| D | ID 160<br>OD 155 | 2.0617<br>2.0605 | 2.0625<br>2.0615 | 0.0002 | 0.0020 | 2.0605 | 2.0625 | 0.0020 |
| E | ID 25,30<br>OD 265 (1) | 1.8504<br>1.8499 | 1.8514<br>1.8504 | 0.0000 | 0.0015 | 1.8494 | 1.8519 | 0.0020 |
| F | ID 265 (1)<br>OD 270 (1) | 0.9839<br>0.9841 | 0.9843<br>0.9847 | -0.0008 (2) | 0.0002 | 0.9841 | 0.9846 | 0.0005 |
| G | ID 145<br>OD 155 | 2.015<br>2.000 | 2.020<br>2.005 | 0.010 | 0.020 | 1.998 | 2.022 | 0.022 |
| H | 105 (3) | 0.352 | 0.354 | | | | 0.356 | |
| J | 105 (3) | 0.252 | 0.254 | | | | 0.256 | |
| K | 145 (9) | 0.348 | 0.350 | | | 0.344 | | |
| L | 145 (9) | 0.248 | 0.250 | | | 0.244 | | |
| M | ID 180 | 5.615 | 5.620 | | | | 5.622 | |
| N | ID 25 | 4.002 | 4.005 | | | | 4.010 | |

Fits and Clearances
Figure 801 (Sheet 2)



13226

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| Ref Letter Fig.801 | Mating Item No. IPL Fig. 1 | Design Dimension | | | | Service Wear Limit | | |
|---|---|---|---|---|---|---|---|---|
| | | Dimension | | Assembly Clearance | | Dimension | | Maximum Clearance |
| | | Min | Max | Min | Max | Min | Max | |
| P | 105<br>155 | | | 0.0001 (4) | 0.0021 (4) | | | 0.010 (4) |
| Q | 230 (1) (6)<br>235 (1) (5) | 1.8663 | 1.5342 | 0.000 (4) | 0.0029 (4) | 1.8521 | 1.5506 | 0.009 (4) |
| R | 235 (1) (8)<br>270 (1) (7) | 1.0264 | 0.8648 | 0.000 (4) | 0.003 (4) | 1.0104 | 0.8809 | 0.009 (4) |

(1) INSTALLATION PARTS
(2) INTERFERENCE FIT
(3) SLOT WIDTH
(4) BACKLASH
(5) MIN MEASUREMENT OVER TWO 0.120 PINS
(6) MAX MEASUREMENT BETWEEN TWO 0.1080 PINS
(7) MIN MEASUREMENT OVER TWO 0.060 PINS
(8) MAX MEASUREMENT BETWEEN TWO 0.054 PINS
(9) TANG WIDTH

ALL DIMENSIONS ARE IN INCHES

Fits and Clearances
Figure 801 (Sheet 3)



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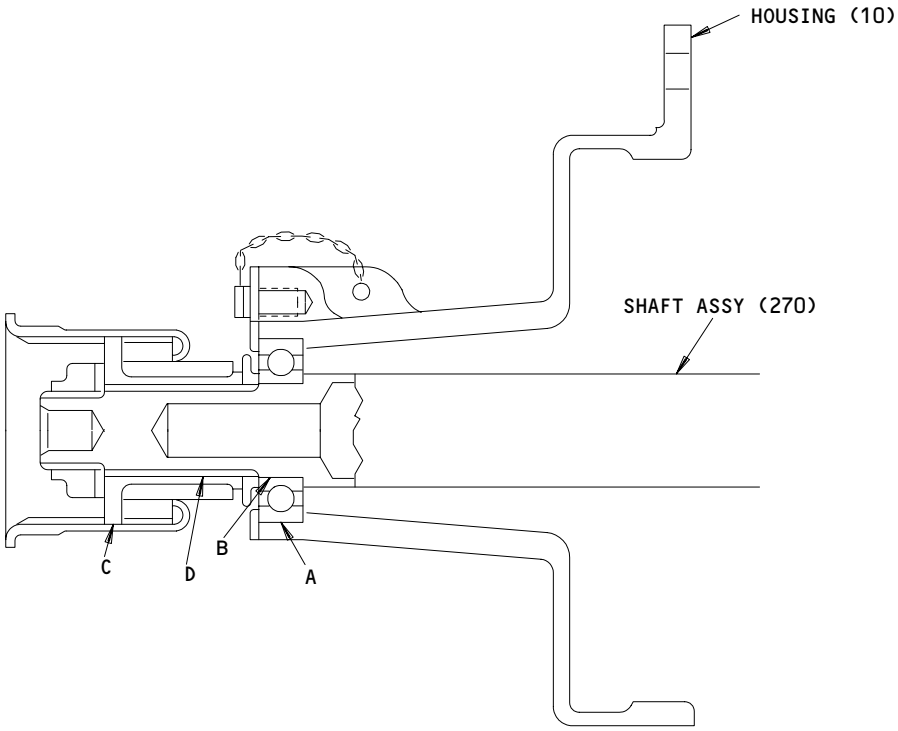
FITS AND CLEARANCES




Fits and Clearances
Figure 802 (Sheet 1)



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| Ref Letter Fig.801 | Mating Item No. IPL Fig. 2 | Design Dimension | | | | Service Wear Limit | | |
|---|---|---|---|---|---|---|---|---|
| | | Dimension | | Assembly Clearance | | Dimension | | Maximum Clearance |
| | | Min | Max | Min | Max | Min | Max | |
| A | ID 10<br>OD 265 [1] | 1.8504<br>1.8499 | 1.8514<br>1.8504 | 0.000 | 0.0015 | 1.8494 | 1.8519 | 0.0020 |
| B | ID 265 [1]<br>OD 270 [1] | 0.9839<br>0.9841 | 0.9843<br>0.9847 | -0.0008 [2] | 0.0002 | 0.9841 | 0.9846 | 0.0005 |
| C | ID 230 [1] [3]<br>OD 235 [1] [4] | 1.8663 | 1.5342 | 0.000 [5] | 0.0029 [5] | 1.8521 | 1.5506 | 0.009 [5] |
| D | ID 235 [1] [6]<br>OD 270 [1] [7] | 1.0264 | 0.8648 | 0.000 [5] | 0.003 [5] | 1.0104 | 0.8809 | 0.009 [5] |

[1] INSTALLATION PARTS
[2] INTERFERENCE FIT
[3] MAX MEASUREMENT BETWEEN TWO 0.1080 PINS
[4] MIN MEASUREMENT OVER TWO 0.120 PINS
[5] BACKLASH
[6] MAX MEASUREMENT BETWEEN TWO 0.054 PINS
[7] MIN MEASUREMENT OVER TWO 0.060 PINS

NEGATIVE VALUES DENOTE INTERFERENCE FIT
ALL DIMENSIONS ARE IN INCHES

Fits and Clearances
Figure 802 (Sheet 2)



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| FOR TORQUE VALUES OF STANDARD FASTENERS, REFER TO 20-50-01 | | | | |
|---|---|---|---|---|
| ITEM NO. IPL FIG. 1 | ITEM NO. IPL FIG. 2 | NAME | TORQUE | |
| | | | POUND-INCHES | POUND-FEET |
| 10 | ---- | BOLT | 45 - 50 | |
| 135 | ---- | NUT | 600 - 800 | |
| 220 | 220 | NUT | 400 - 450 | |

Torque Table
Figure 803

182298



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## ILLUSTRATED PARTS LIST

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

2. Indentures show parts relationships as follows:

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

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

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

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

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

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

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

6. Parts Interchangeability

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



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VENDORS

K8455 RHP BEARINGS PLC RHP AEROSPACE
OLDENDS LANE
STONEHOUSE GL10 3RM UK

06144 INDUSTRIAL TECTONICS BEARING CORP
18301 SOUTH SANTA FE AVENUE
RANCO DOMINQUEZ, CALIFORNIA 90221

11815 CHERRY AEROSPACE FASTENERS DIV OF TEXTRON
1224 EAST WARNER AVENUE PO BOX 2157
SANTA ANA, CALIFORNIA 92707-0157

15653 KAYNAR TECHNOLOGY KAYNAR DIV
800 SOUTH STATE COLLEGE BLVD PO BOX 3001
FULLERTON, CALIFORNIA 92831-3001

21335 TORRINGTON CO FAFNIR BEARING DIV
59 FIELD STREET
TORRINGTON, CONNECTICUT 06790-4942

21760 SCHATZ MANUFACTURING CO
FAIRVIEW AVENUE PO BOX 1191
POUGHKEEPSIE, NEW YORK 12601

29337 HOOVER GROUP INC BALL AND ROLLER DIV
2220 PENDLEY ROAD PO BOX 899
CUMMING, GEORGIA 30130-8671

38443 MRC BEARINGS
402 CHANDLER STREET
JAMESTOWN, NEW YORK 14701-3802

40920 MPB MINIATURE PRECISION BEARING DIV
PRECISION PARK PO BOX 547
KEENE, NEW HAMPSHIRE 03431

43991 FAG BEARING INCORPORATED
118 HAMILTON AVENUE
STAMFORD, CONNECTICUT 06904

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

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



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VENDORS

62554 SIMMONDS MECAERO FASTENERS INC
1734 SEQUOIA AVENUE
ORANGE, CALIFORNIA 92668

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

72962 HARVARD INDUSTRIES INC
3 WERNER WAY SUITE 210
LEBANON, NEW JERSEY 08833

78118 SPLIT BALL BEARING DIV OF MPB CORP
HIGHWAY 4
LEBANON, NEW HAMPSHIRE 03766-7301

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

83086 NEW HAMPSHIRE BALL BEARINGS, INCORPORATED
ROUTE 202
PETERBOROUGH, NEW HAMPSHIRE 03458

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

97393 SHUR-LOK CORPORATION
2541 WHITE ROAD PO BOX 19584
IRVINE, CALIFORNIA 92713

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



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| PART NUMBER | AIRLINE PART NO. | FIG. | ITEM | TTL REQ |
|---|---|---|---|---|
| AN743Z13 | | 1 | 60A | 1 |
| AN960PD10L | | 1 | 15 | 1 |
| | | 1 | 170 | 2 |
| | | 1 | 255 | 3 |
| | | 2 | 255 | 3 |
| AN960PD1216 | | 1 | 225 | 1 |
| | | 2 | 225 | 1 |
| AN960PD416 | | 1 | 40 | 6 |
| AN960PD416L | | 1 | 90 | 1 |
| BACB10AS10 | | 1 | 125 | 1 |
| | | 1 | 187 | 1 |
| BACB10AS33 | | 1 | 160 | 2 |
| BACB10BA25PP | | 1 | 265 | 1 |
| | | 2 | 265 | 1 |
| BACB30NR4K30 | | 1 | 85 | 1 |
| BACB30NR4K7 | | 1 | 35 | 6 |
| BACN10JC12 | | 1 | 220 | 1 |
| | | 2 | 220 | 1 |
| BACN10JC4 | | 1 | 45 | 6 |
| | | 1 | 100 | 1 |
| BACN10JP3A | | 1 | 70 | 3 |
| BACN10RF32 | | 1 | 135 | 1 |
| BACN10YR4CD | | 1 | 45A | 6 |
| | | 1 | 100A | 1 |
| BACR15BA3AD | | 1 | 65 | 6 |
| BACR15BB4AD | | 1 | 55A | 2 |
| | | 1 | 110 | 4 |
| BACW10P87AL | | 1 | 140 | 1 |
| BACW10P93D | | 1 | 95 | 1 |
| BAC27TCT0002 | | 1 | 210 | 1 |
| BMN4122AD3-12 | | 1 | 220 | 1 |
| | | 2 | 220 | 1 |
| BRM200A3 | | 1 | 70 | 3 |
| BR9080-3212 | | 1 | 135 | 1 |
| C105RRP0ZZ | | 1 | 265 | 1 |
| | | 2 | 265 | 1 |
| C105RRP1P28LY19 | | 1 | 265 | 1 |
| | | 2 | 265 | 1 |
| H10-12BAC | | 1 | 220 | 1 |
| | | 2 | 220 | 1 |
| H52732-4CD | | 1 | 45A | 6 |
| | | 1 | 100A | 1 |
| LLMB545 | | 1 | 160 | 2 |



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| PART NUMBER | AIRLINE PART NO. | FIG. | ITEM | TTL REQ |
|---|---|---|---|---|
| LL105KS | | 1 | 265 | 1 |
| | | 2 | 265 | 1 |
| MB538-2TS | | 1 | 125 | 1 |
| | | 1 | 187 | 1 |
| MB538DD | | 1 | 125 | 1 |
| | | 1 | 187 | 1 |
| MB538DDFS428 | | 1 | 125 | 1 |
| | | 1 | 187 | 1 |
| MB538DDLY196 | | 1 | 125 | 1 |
| | | 1 | 187 | 1 |
| MB538DDSD610 | | 1 | 125 | 1 |
| | | 1 | 187 | 1 |
| MB538TT | | 1 | 125 | 1 |
| | | 1 | 187 | 1 |
| MB545-2TS | | 1 | 160 | 2 |
| MK1000-3BAC | | 1 | 70 | 3 |
| MS21209F1-15 | | 1 | 50 | 3 |
| | | 1 | 195 | 2 |
| | | 2 | 5 | 3 |
| MS35756-34 | | 1 | 150 | 1 |
| MS90354-6 | | 1 | 275 | 9 |
| | | 2 | 275 | 9 |
| MT338E | | 1 | 125 | 1 |
| | | 1 | 187 | 1 |
| MT345E | | 1 | 160 | 2 |
| NAS1149D0316J | | 1 | 15A | 1 |
| NAS1149D0416J | | 1 | 90A | 1 |
| NAS1149D0463J | | 1 | 40A | 6 |
| NAS43DD10-67 | | 1 | 130 | 1 |
| NAS607-2-3P | | 1 | 190 | 2 |
| NAS623-3-2 | | 1 | 165 | 2 |
| NAS6603-3 | | 1 | 10 | 1 |
| NAS6603H1 | | 1 | 250 | 3 |
| | | 2 | 250 | 3 |
| NS103197-02 | | 1 | 70 | 3 |
| PKTLL105P1 | | 1 | 265 | 1 |
| | | 2 | 265 | 1 |
| PLH54CD | | 1 | 45A | 6 |
| | | 1 | 100A | 1 |
| RMLH9074-12 | | 1 | 220 | 1 |
| | | 2 | 220 | 1 |
| SL2822-32 | | 1 | 135 | 1 |
| T8076S1032 | | 1 | 70 | 3 |
| VN202A1-02 | | 1 | 70 | 3 |



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| PART NUMBER | AIRLINE PART NO. | FIG. | ITEM | TTL REQ |
|---|---|---|---|---|
| 256T3749-1 | | 1 | 235 | 1 |
| | | 2 | 235 | 1 |
| 256T3751-1 | | 1 | 270 | 1 |
| | | 2 | 270 | 1 |
| 256T3752-1 | | 1 | 285 | 1 |
| | | 2 | 285 | 1 |
| 256T3752-2 | | 1 | 285A | 1 |
| | | 2 | 285A | 1 |
| 256T3753-1 | | 1 | 280 | 1 |
| | | 2 | 280 | 1 |
| 256T3760-3 | | 1 | 1A | RF |
| 256T3760-4 | | 1 | 5A | RF |
| 256T3760-5 | | 1 | 1B | RF |
| 256T3760-6 | | 1 | 5B | RF |
| 256T3760-7 | | 1 | 1C | RF |
| 256T3760-8 | | 1 | 5C | RF |
| 256T3761-1 | | 1 | 180 | 1 |
| 256T3761-10 | | 1 | 205A | 1 |
| 256T3761-2 | | 1 | 185 | 1 |
| 256T3761-3 | | 1 | 200 | 1 |
| 256T3761-4 | | 1 | 205 | 1 |
| 256T3761-7 | | 1 | 180A | 1 |
| 256T3761-8 | | 1 | 185A | 1 |
| 256T3761-9 | | 1 | 200A | 1 |
| 256T3763-10 | | 1 | 25B | 1 |
| 256T3763-11 | | 1 | 30B | 1 |
| 256T3763-12 | | 1 | 75B | 1 |
| 256T3763-13 | | 1 | 80B | 1 |
| 256T3763-6 | | 1 | 25A | 1 |
| 256T3763-7 | | 1 | 30A | 1 |
| 256T3763-8 | | 1 | 75A | 1 |
| 256T3763-9 | | 1 | 80A | 1 |
| 256T3764-1 | | 1 | 105 | 1 |
| 256T3765-1 | | 1 | 115 | 1 |
| 256T3765-2 | | 1 | 115A | 1 |
| 256T3766-1 | | 1 | 120 | 1 |
| 256T3767-1 | | 1 | 7 | RF |
| | | 2 | 1 | RF |
| 256T3767-2 | | 2 | 10 | 1 |
| 256T3768-1 | | 1 | 155 | 1 |
| 256T3769-1 | | 1 | 145 | 1 |
| 256T3771-1 | | 1 | 260 | 1 |
| | | 2 | 260 | 1 |
| 256T3773-1 | | 1 | 245 | 1 |
| | | 2 | 245 | 1 |
| 48FT1216 | | 1 | 220 | 1 |
| | | 2 | 220 | 1 |



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| PART NUMBER | AIRLINE PART NO. | FIG. | ITEM | TTL REQ |
|---|---|---|---|---|
| 6005TT | | 1 | 265 | 1 |
| | | 2 | 265 | 1 |
| 65B81978-3 | | 1 | 175 | 1 |
| 65B84033-18 | | 1 | 240A | 1 |
| | | 2 | 240 | 1 |
| 65B84034-3 | | 1 | 230 | 1 |
| | | 2 | 230 | 1 |
| 69B83592-2 | | 1 | 20 | 1 |
| 82631-3212 | | 1 | 135 | 1 |
| 9105LLT1C1-01 | | 1 | 265 | 1 |
| | | 2 | 265 | 1 |
| 9105NPPFS428 | | 1 | 265 | 1 |
| | | 2 | 265 | 1 |
| 993L05 | | 1 | 265 | 1 |
| | | 2 | 265 | 1 |



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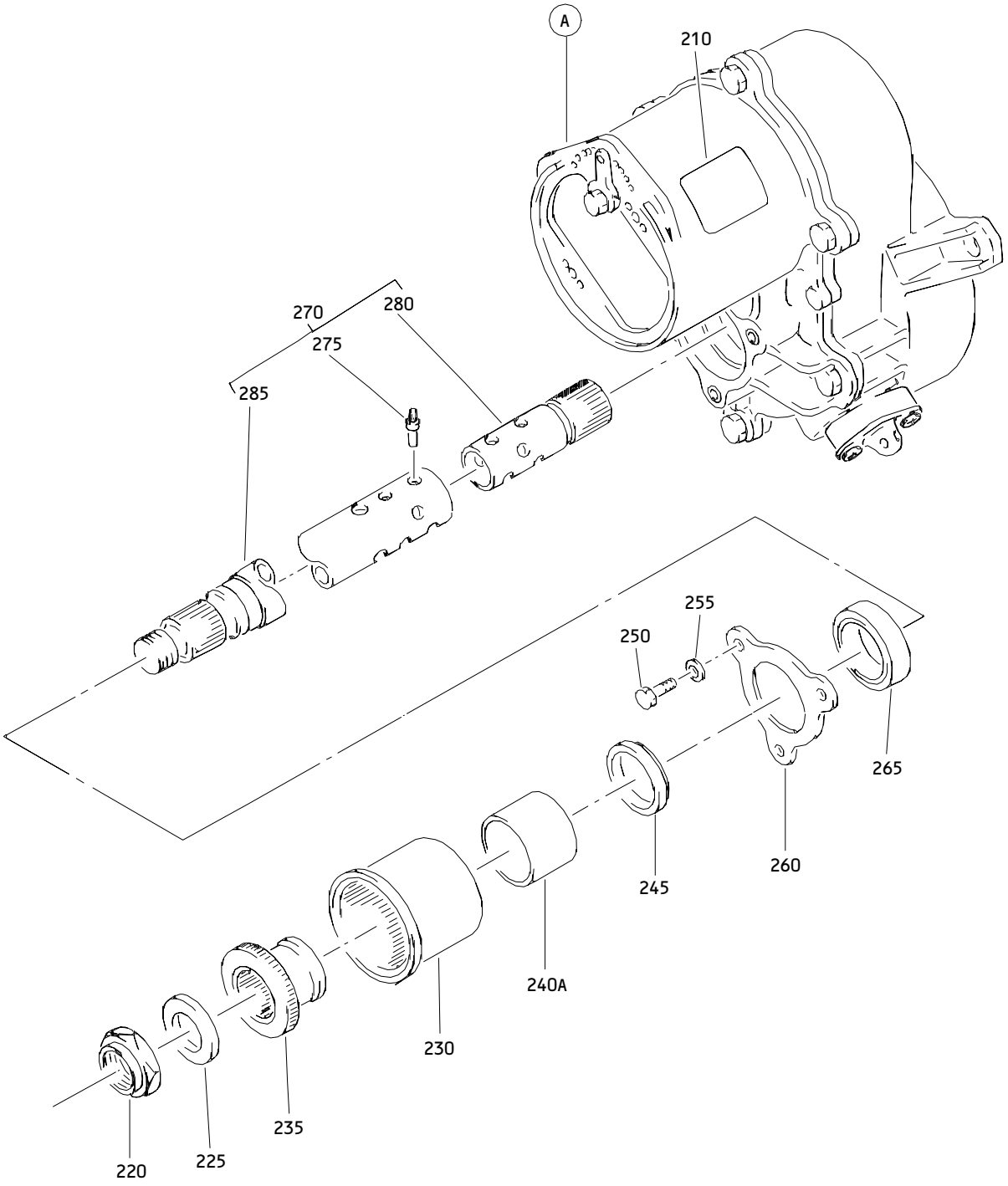


Trailing Edge Flap Drive Position Transmitter Gearbox Assembly
Figure 1 (Sheet 1)

T58751



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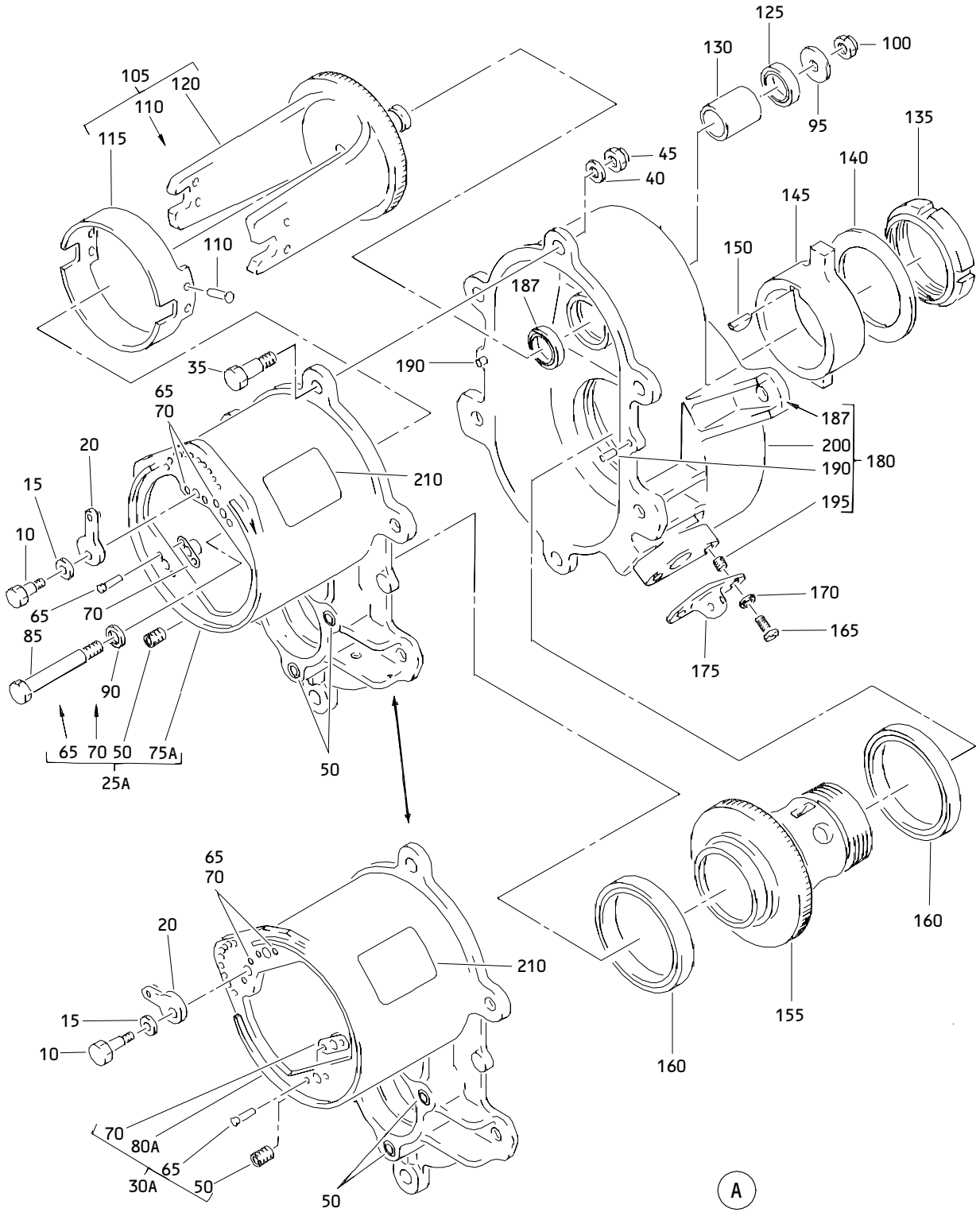


Trailing Edge Flap Drive Position Transmitter Gearbox Assembly
Figure 1 (Sheet 2)



T58752

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| | FIG. & ITEM | PART NO. | AIRLINE PART NUMBER | NOMENCLATURE 1234567 | EFF CODE | QTY PER ASSY |
|---|---|---|---|---|---|---|
| | 01- | | | | | |
| | -1 | 256T3760-1 | | DELETED | | |
| | -1A | 256T3760-3 | | GEARBOX ASSY-TE FLAP DRIVE POSITION XMTR (PRE SB 767-27-0058) | A | RF |
| R | -1B | 256T3760-5 | | GEARBOX ASSY-TE FLAP DRIVE POSITION XMTR | C | RF |
| R | -1C | 256T3760-7 | | GEARBOX ASSY-TE FLAP DRIVE POSITION XMTR | E | RF |
| | -5 | 256T3760-2 | | DELETED | | |
| | -5A | 256T3760-4 | | GEARBOX ASSY-TE FLAP DRIVE POSITION XMTR (PRE SB 767-27-0058) | B | RF |
| R | -5B | 256T3760-6 | | GEARBOX ASSY-TE FLAP DRIVE POSITION XMTR | D | RF |
| R | -5C | 256T3760-8 | | GEARBOX ASSY-TE FLAP DRIVE POSITION XMTR | F | RF |
| | -7 | 256T3767-1 | | HOUSING ASSY-TE FLAP DRIVE SHAFT BRG SPRT (POST SB 767-27-0058) (FOR DETAILS SEE FIG. 2) | G | RF |
| | 10 | NAS6603-3 | | .BOLT | A-F | 1 |
| | 15 | AN960PD10L | | .WASHER | A,B | 1 |
| R | -15A | NAS1149D0316J | | .WASHER | C-F | 1 |
| | 20 | 69B83592-2 | | .FITTING-ADJUSTMENT | A-F | 1 |
| | 25 | 256T3763-1 | | DELETED | | |
| | 25A | 256T3763-6 | | .COVER ASSY | A,C | 1 |
| R | -25B | 256T3763-10 | | .COVER ASSY | E | 1 |
| | 30 | 256T3763-2 | | DELETED | | |
| | 30A | 256T3763-7 | | .COVER ASSY | B,D | 1 |
| R | -30B | 256T3763-11 | | .COVER ASSY ATTACHING PARTS | F | 1 |



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| | FIG. & ITEM | PART NO. | AIRLINE PART NUMBER | NOMENCLATURE 1234567 | EFF CODE | QTY PER ASSY |
|---|---|---|---|---|---|---|
| | 01- | | | | | |
| | 35 | BACB30NR4K7 | | .BOLT | A-F | 6 |
| | 40 | AN960PD416 | | .WASHER | A,B | 6 |
| R | -40A | NAS1149D0463J | | .WASHER | C-F | 6 |
| | 45 | BACN10JC4 | | .NUT | A,B | 6 |
| R | -45A | H52732-4CD | | .NUT-<br>(V15653)<br>(SPEC BACN10YR4CD)<br>(OPT PLH54CD<br>(V62554))<br>-------*------- | C-F | 6 |
| | 50 | MS21209F1-15 | | ..INSERT | A-F | 3 |
| | 55 | BACR15BB4AD | | DELETED | | |
| | 55A | BACR15BB4AD | | ..RIVET-<br>(SIZE DETERMINE ON INST)<br>(NHA 256T3763) | A-F | 2 |
| | 60 | AN743Z13 | | DELETED | | |
| | 60A | AN743Z13 | | ..BRACKET | A-F | 1 |
| | 65 | BACR15BA3AD | | ..RIVET-<br>(SIZE DETERMINE ON INST) | A-F | 6 |
| | 70 | BRM200A3 | | ..NUTPLATE-<br>(V52828)<br>(SPEC BACN10JP3A)<br>(OPT MK1000-3BAC<br>(V15653))<br>(OPT NS103197-02<br>(V80539))<br>(OPT T8076S1032<br>(V71087))<br>(OPT T8076S1032<br>(V11815))<br>(OPT VN202A1-02<br>(V92215)) | A-F | 3 |



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| | FIG. & ITEM | PART NO. | AIRLINE PART NUMBER | NOMENCLATURE 1234567 | EFF CODE | QTY PER ASSY |
|---|---|---|---|---|---|---|
| | 01- | | | | | |
| | 75 | 256T3763-3 | | DELETED | | |
| | 75A | 256T3763-8 | | ..COVER | A,C | 1 |
| R | -75B | 256T3763-12 | | ..COVER | E | 1 |
| | 80 | 256T3763-4 | | DELETED | | |
| | 80A | 256T3763-9 | | ..COVER | B,D | 1 |
| R | -80B | 256T3763-13 | | ..COVER | F | 1 |
| | 85 | BACB30NR4K30 | | .BOLT | A-F | 1 |
| | 90 | AN960PD416L | | .WASHER | A,B | 1 |
| R | -90A | NAS1149D0416J | | .WASHER | C-F | 1 |
| | 95 | BACW10P93D | | .WASHER | A-F | 1 |
| | 100 | BACN10JC4 | | .NUT | A,B | 1 |
| R | -100A | H52732-4CD | | .NUT-<br>(V15653)<br>(SPEC BACN10YR4CD)<br>(OPT PLH54CD<br>(V62554)) | C-F | 1 |
| | 105 | 256T3764-1 | | .GEAR ASSY | A-F | 1 |
| | 110 | BACR15BB4AD | | ..RIVET-<br>(SIZE DETERMINE ON INST) | A-F | 4 |
| | 115 | 256T3765-1 | | ..COLLAR-<br>(OPT ITEM 115A) | A-F | 1 |
| | -115A | 256T3765-2 | | ..COLLAR-<br>(OPT ITEM 115) | A-F | 1 |
| | 120 | 256T3766-1 | | ..GEAR-DRIVEN | A-F | 1 |
| | 125 | MB538DDSD610 | | .BEARING-<br>(V83086)<br>(SPEC BACB10AS10)<br>(OPT MB538-2TS<br>(V43991))<br>(OPT MB538DDFS428<br>(V21335))<br>(OPT MB538TT<br>(V43991))<br>(OPT MT338E<br>(VK8455))<br>(OPT MB538DDLY196<br>(V40920))<br>(OPT MB538DD<br>(V06144)) | A-F | 1 |



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| FIG. & ITEM | PART NO. | AIRLINE PART NUMBER | NOMENCLATURE 1234567 | EFF CODE | QTY PER ASSY |
|---|---|---|---|---|---|
| 01- | | | | | |
| 130 | NAS43DD10-67 | | .SPACER | A-F | 1 |
| 135 | SL2822-32 | | .NUT- (V97393) (SPEC BACN10RF32) (OPT 82631-3212 (V56878)) (OPT BR9080-3212 (V72962)) | A-F | 1 |
| 140 | BACW10P87AL | | .WASHER | A-F | 1 |
| 145 | 256T3769-1 | | .TANG-DRIVER | A-F | 1 |
| 150 | MS35756-34 | | .KEY | A-F | 1 |
| 155 | 256T3768-1 | | .GEAR-DRIVER | A-F | 1 |
| 160 | MB545DDSD610 | | .BEARING- (V83086) (SPEC BACB10AS33) (OPT LLMB545 (V38443)) (OPT MB545-2TS (V43991)) (OPT MB545DDFS428 (V21335)) (OPT MB545TT (V43991)) (OPT MB545DDG20 (V38443)) (OPT MT345E (VK8455)) (OPT MB545DDLY196 (V40920)) (OPT MB545DD (V06144)) | A-F | 2 |



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| | FIG. & ITEM | PART NO. | AIRLINE PART NUMBER | NOMENCLATURE 1234567 | EFF CODE | QTY PER ASSY |
|---|---|---|---|---|---|---|
| | 01- | | | | | |
| | 165 | NAS623-3-2 | | .SCREW | A,B | 2 |
| | 170 | AN960PD10L | | .WASHER | A,B | 2 |
| | 175 | 65B81978-3 | | .COVER- | A,B | 1 |
| | | | | (OPT ITEM 175A) | | |
| R | -175A | 65B81978-4 | | .COVER- | A,B | 1 |
| | | | | (OPT ITEM 175) | | |
| | 180 | 256T3761-1 | | .HOUSING ASSY | A | 1 |
| R | -180A | 256T3761-7 | | .HOUSING ASSY | C,E | 1 |
| | -185 | 256T3761-2 | | .HOUSING ASSY | B | 1 |
| R | -185A | 256T3761-8 | | .HOUSING ASSY | D,F | 1 |
| | 187 | MB538DDSD610 | | ..BEARING- | A-F | 1 |
| | | | | (V83086) | | |
| | | | | (SPEC BACB10AS10) | | |
| | | | | (OPT MB538-2TS | | |
| | | | | (V43991)) | | |
| | | | | (OPT MB538DDFS428 | | |
| | | | | (V21335)) | | |
| | | | | (OPT MB538TT | | |
| | | | | (V43991)) | | |
| | | | | (OPT MT338E | | |
| | | | | (VK8455)) | | |
| | | | | (OPT MB538DDLY196 | | |
| | | | | (V40920)) | | |
| | | | | (OPT MB538DD | | |
| | | | | (V06144)) | | |
| | 190 | NAS607-2-3P | | ..PIN-DOWEL | A-F | 2 |
| | 195 | MS21209F1-15 | | ..INSERT | A-F | 2 |
| | 200 | 256T3761-3 | | ..HOUSING | A | 1 |
| R | -200A | 256T3761-9 | | ..HOUSING | C,E | 1 |
| | -205 | 256T3761-4 | | ..HOUSING | B | 1 |
| R | -205A | 256T3761-10 | | ..HOUSING | D,F | 1 |
| | 210 | BAC27TCT0002 | | .MARKER | A-F | 1 |
| | | | | INSTALLATION PARTS | | |
| | 220 | H10-12BAC | | NUT- | A-D | 1 |
| | | | | (V15653) | | |
| | | | | (SPEC BACN10JC12) | | |
| | | | | (OPT RMLH9074-12 | | |
| | | | | (V72962)) | | |
| | | | | (OPT 48FT1216 | | |
| | | | | (V56878)) | | |
| | | | | (OPT BMN4122AD3-12 | | |
| | | | | (V97928)) | | |



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| FIG. & ITEM | PART NO. | AIRLINE PART NUMBER | NOMENCLATURE 1234567 | EFF CODE | QTY PER ASSY |
|---|---|---|---|---|---|
| 01- | | | | | |
| 225 | AN960PD1216 | | WASHER | A-D | 1 |
| 230 | 65B84034-3 | | SLEEVE | A-D | 1 |
| 235 | 256T3749-1 | | COUPLING HALF-CROWNED | A-D | 1 |
| 240 | 65B84033-1 | | DELETED | | |
| 240A | 65B84033-18 | | SLEEVE | A-D | 1 |
| 245 | 256T3773-1 | | SHIELD-BRG | A-D | 1 |
| 250 | NAS6603H1 | | BOLT | A-D | 3 |
| 255 | AN960PD10L | | WASHER | A-D | 3 |
| 260 | 256T3771-1 | | RETAINER-BRG | A-D | 1 |
| 265 | 9105NPPFS428 | | BEARING-<br>(V21335)<br>(SPEC BACB10BA25PP)<br>(OPT LL105KS<br>(V38443))<br>(OPT 6005TT<br>(V43991))<br>(OPT 9105LLT1C1-01<br>(V21760))<br>(OPT 993L05<br>(V29337))<br>(OPT PKTLL105P1<br>(V78118))<br>(OPT C105RRPOZZ<br>(V40920))<br>(OPT C105RRP1P28LY196<br>(V40920)) | A-D | 1 |
| 270 | 256T3751-1 | | SHAFT ASSY | A-D | 1 |
| 275 | MS90354-6 | | .RIVET | A-D | 9 |
| 280 | 256T3753-1 | | .FITTING-END | A-D | 1 |



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| FIG. & ITEM | PART NO. | AIRLINE PART NUMBER | NOMENCLATURE 1234567 | EFF CODE | QTY PER ASSY |
|---|---|---|---|---|---|
| 01-285 | 256T3752-1 | | .SHAFT- (OPT ITEM 285A) | A-D | 1 |
| -285A | 256T3752-2 | | .SHAFT- (OPT ITEM 285) | A-D | 1 |

- Item Not Illustrated



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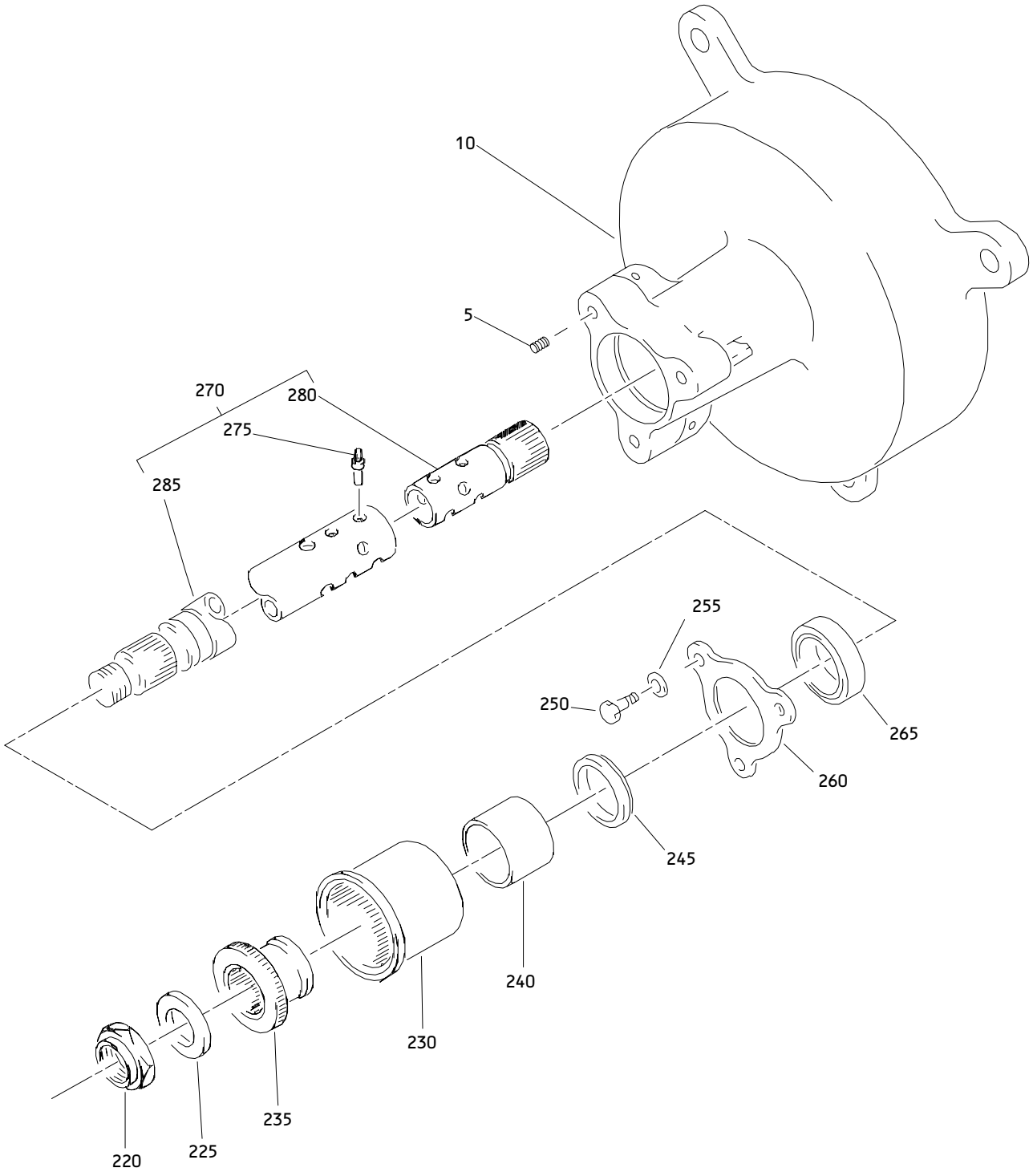


Trailing Edge Flap Drive Housing Assembly
Figure 2



707846
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| FIG. & ITEM | PART NO. | AIRLINE PART NUMBER | NOMENCLATURE 1234567 | EFF CODE | QTY PER ASSY |
|---|---|---|---|---|---|
| 02- | | | | | |
| -1 | 256T3767-1 | | HOUSING ASSY-TE FLAP DRIVE SHAFT BRG SPRT (POST SB 767-27-0058) | G | RF |
| 5 | MS21209F1-15 | | .INSERT | G | 3 |
| 10 | 256T3767-2 | | .HOUSING | G | 1 |
| | | | INSTALLATION PARTS | | |
| 220 | H10-12BAC | | NUT- (V15653) (SPEC BACN10JC12) (OPT RMLH9074-12 (V72962)) (OPT 48FT1216 (V56878)) (OPT BMN4122AD3-12 (V97928)) | G | 1 |
| 225 | AN960PD1216 | | WASHER | G | 1 |
| 230 | 65B84034-3 | | SLEEVE | G | 1 |
| 235 | 256T3749-1 | | COUPLING HALF-CROWNED | G | 1 |
| 240 | 65B84033-18 | | SLEEVE | G | 1 |
| 245 | 256T3773-1 | | SHIELD-BRG | G | 1 |
| 250 | NAS6603H1 | | BOLT | G | 3 |
| 255 | AN960PD10L | | WASHER | G | 3 |
| 260 | 256T3771-1 | | RETAINER-BRG | G | 1 |
| 265 | 9105NPPFS428 | | BEARING- (V21335) (SPEC BACB10BA25PP) (OPT LL105KS (V38443)) (OPT 6005TT (V43991)) (OPT 9105LLT1C1-01 (V21760)) (OPT 993L05 (V29337)) (OPT PKTLL105P1 (V78118)) (OPT C105RRP0ZZ (V40920)) (OPT C105RRP1P28LY196 (V40920)) | G | 1 |



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| FIG. & ITEM | PART NO. | AIRLINE PART NUMBER | NOMENCLATURE 1234567 | EFF CODE | QTY PER ASSY |
|---|---|---|---|---|---|
| 02- | | | | | |
| 270 | 256T3751-1 | | SHAFT ASSY | G | 1 |
| 275 | MS90354-6 | | .RIVET | G | 9 |
| 280 | 256T3753-1 | | .FITTING-END | G | 1 |
| 285 | 256T3752-1 | | .SHAFT- (OPT ITEM 285A) | G | 1 |
| -285A | 256T3752-2 | | .SHAFT- (OPT ITEM 285) | G | 1 |

- Item Not Illustrated



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