

 **BOEING**
COMPONENT
MAINTENANCE MANUAL

TO: ALL HOLDERS OF SPEED BRAKE LEVER INSTALLATION COMPONENTS COMPONENT
MAINTENANCE MANUAL 27-62-41

REVISION NO. 6 DATED MAR 01/99

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 to the Record of Revision Sheet.

CHAPTER/SECTION

AND PAGE NO.

DESCRIPTION OF CHANGE

CONTENTS

Added rod assemblies 69B82839-21 and 254N1016-1.

1

REPAIR 4-1

601-603

1007,1014-1015

REPAIR-GEN

Added standard practices.

601

REPAIR 4-1

Changed refinish of rods.

601

REPAIR 4-1

Changed assembly procedures for rod assemblies.

601-602

603

Updated Vendors List.

1003-1004

Added Numerical Parts List Index.

1007

Added optional bearing on shaft assembly.

1008,1011,1013

Edited without technical change.

27-62-41

HIGHLIGHTS

01.1

Page 1

Mar 01/99



SPEED BRAKE LEVER INSTALLATION COMPONENTS

SEE CONTENTS FOR P/N

COMPONENT MAINTENANCE MANUAL
WITH
ILLUSTRATED PARTS LIST

27-62-41

TITLE PAGE

Page 1

Jul 10/83

01.1

REVISION RECORD

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

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

27-62-41

REVISION RECORD

01.1

Page 1

Jul 10/83

SPEED BRAKE LEVER
INSTL COMPONENTS
SEE CONTENTS FOR P/N



TEMPORARY REVISION AND SERVICE BULLETIN RECORD

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

27-62-41

TR & SB RECORD

01.1

Page 1

Jul 10/83

PAGE	DATE	CODE	PAGE	DATE	CODE
27-62-41			REPAIR 4-1		
			*601	MAR 01/99	01.1
			*602	MAR 01/99	01.1
			*603	MAR 01/99	01.1
			*604	BLANK	
			ILLUSTRATED PARTS LIST		
			1001	JUL 10/83	01.1
			*1002	MAR 01/99	01.1
			*1003	MAR 01/99	01.1
			*1004	MAR 01/99	01.1
			*1005	BLANK	
			*1006	MAR 01/99	01.1
			*1007	MAR 01/99	01.1
			*1008	MAR 01/99	01.1
			*1009	BLANK	
			*1010	MAR 01/99	01.1
			*1011	MAR 01/99	01.1
			*1012	MAR 01/99	01.1
			*1013	MAR 01/99	01.1
			*1014	MAR 01/99	01.1
			*1015	MAR 01/99	01.1
			*1016	BLANK	
TITLE PAGE					
1	JUL 10/83	01.1			
2	BLANK				
REVISION RECORD					
1	JUL 10/83	01.1			
2	BLANK				
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LIST OF EFFECTIVE PAGES					
*1	MAR 01/99	01			
THRU LAST PAGE					
CONTENTS					
*1	MAR 01/99	01.1			
2	BLANK				
INTRODUCTION					
1	JUL 10/83	01.1			
2	BLANK				
REPAIR-GENERAL					
*601	MAR 01/99	01.1			
602	BLANK				
REPAIR 1-1					
601	JUL 10/83	01.1			
602	BLANK				
REPAIR 2-1					
601	JUL 10/83	01.1			
602	BLANK				
REPAIR 3-1					
601	JUL 10/83	01.1			
602	BLANK				

* = REVISED, ADDED OR DELETED

27-62-41

EFFECTIVE PAGES
 LAST PAGE Page 1
 01 Mar 01/99

TABLE OF CONTENTS

NOTE: This manual contains overhaul data for various components of the Speed Brake Lever Installation. Functions which cannot be performed by the use of standard industry practices are included in the repair instructions for each component.

SPEED BRAKE LEVER INSTALLATION COMPONENTS

<u>PART NUMBER</u>	<u>NOMENCLATURE</u>	<u>PAGE</u>
- - - -	REPAIR-GENERAL	601, REPAIR-GEN
253T5611	SHAFT	601, REPAIR 1-1
253T5616	HOUSING	601, REPAIR 2-1
69B82756	HOUSING	601, REPAIR 3-1
69B82839	ROD	601, REPAIR 4-1
254N1016		
- - - -	ILLUSTRATED PARTS LIST	1001

27-62-41

CONTENTS

01.1

Page 1

Mar 01/99

INTRODUCTION

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

This manual is divided into separate sections:

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

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

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

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

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

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

27-62-41

INTRODUCTION

01.1

Page 1

Jul 10/83

REPAIR – GENERAL

1. Content

- A. Each separate repair includes, as applicable, check, repair and refinish instructions.

2. Standard Practices

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

20-20-01 Magnetic Particle Inspection
20-20-02 Penetrant Methods of Inspection
20-30-01 Cleaning and Relubricating Antifriction Bearings
20-30-02 Stripping of Protective Finishes
20-30-03 General Cleaning Procedures
20-41-01 Decoding Table for Boeing Finish Codes
20-41-05 Application of Corrosion Inhibiting Compounds
20-43-01 Chromic Acid Anodizing
20-43-03 Chemical Conversion Coatings for Aluminum
20-50-03 Bearing and Bushing Replacement
20-60-02 Finishing Materials
20-60-03 Lubricants
20-60-04 Miscellaneous Materials

3. Materials

NOTE: Equivalent substitutes may be used.

- A. Primer -- BMS 10-11, type 1 (Ref 20-60-02)
B. Grease -- MIL-G-23827 (Ref 20-60-03)
C. Corrosion Inhibiting Compound -- BMS 3-23, Type II (Ref 20-60-04)

27-62-41

REPAIR-GENERAL

01.1

Page 601

Mar 01/99

| SHAFT ASSEMBLY – REPAIR 1-1

| 253T5611-5

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

1. Check (IPL Fig. 1)

A. Check for obvious defects in accordance with standard industry practices.

| B. Magnetic particle check per 20-20-01 -- Shaft (115A)

2. Repair (IPL Fig. 1)

A. Bearing Replacement

(1) Remove bearing (105)

(2) Clean replacement bearing to remove all grease; no lubrication required. With rivet and bearing in position, check that roller turns freely.

| (3) Install rivet using machine squeeze method. Check that roller turns freely.

B. Refinish

| (1) Shaft (115A) -- Passivate (F-17.09). Material: 17-4PH CRES, 180 ksi.

27-62-41

REPAIR 1-1

01.1

Page 601

Jul 10/83

HOUSING ASSEMBLY – REPAIR 2-1

253T5616-1

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

1. Check (IPL Fig. 2)

A. Check for obvious defects in accordance with standard industry practices.

| B. Penetrant check per 20-20-02 -- Housing (10)

2. Repair (IPL Fig. 2)

A. Bearing Replacement

(1) Remove bearing (5).

(2) Install replacement bearing using wet primer and roller swage in place.

B. Refinish

(1) Housing (10) -- Chromic acid or sulfuric acid anodize (F-17.05) and apply one coat of primer (F-20.02) except no primer on 0.8739-0.8744 and 0.8748-0.8754 inch dia. holes. Material: Aluminum alloy.

27-62-41

REPAIR 2-1

01.1

Page 601

Jul 10/83

HOUSING ASSEMBLY - REPAIR 3-1

69B82756-1, -3, -5

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

1. Check (IPL Fig. 4)

- A. Check for obvious defects in accordance with standard industry practices.
- B. Penetrant check per 20-20-02 -- Housing (10).

2. Repair (IPL Fig. 4)

A. Bearing Replacement

- (1) Remove bearing (5).
- (2) Install replacement bearing with wet primer and roller swage in place.

B. Refinish

- (1) Housing (10) -- Chromic acid anodize (F-17.02) and apply one coat of primer (F-20.02) except no primer on 0.8740-0.8745 inch dia. holes.
Material: Aluminum alloy.

3. Storage

- A. Attach paper tag to assembly with aluminum wire. Mark tag with identifying number and serial number.

27-62-41

REPAIR 3-1

01.1

Page 601

Jul 10/83

ROD ASSEMBLY – REPAIR 4-1

69B82839-1, -13, -15, -17, -19, -21
254N1016-1

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

1. Check

A. Check all parts for obvious defects in accordance with standard industry practices.

2. Repair (IPL Fig. 5)

A. Refinish

(1) Rod (25, 25A, 25C) -- Chemical treat inner and outer surfaces and apply one layer of primer (F-18.07). Apply corrosion inhibiting compound (F-19.26) on inner surface only.

(2) Rod (25B) -- Chemical treat inner and outer surfaces and apply one layer of primer (F-18.07).

(3) Rod (25E) -- Anodize and apply one layer of primer (F-18.13).

(4) Rod (25F, 25G) -- Anodize (F-17.31).

B. Material

(1) Rods: Aluminum alloy.

3. Assembly

A. Use standard industry practices for assembly of this component and additional procedure in par. B or C.

B. Assemble rod assembly 69B82839-1, -13, -15, -17, -19, -21.

(1) Install the nuts (15) and rod end bearings (20) on the rod (25).

27-62-41

REPAIR 4-1

01.1

Page 601

Mar 01/99

- (2) Adjust the bearings so that they are approximately centered on the rod, with the distance between the bearing centers as shown in Fig. 601. Make sure that the rod goes into the rod end bearings far enough to cause a blockage of the inspection holes.

NOTE: The rod assemblies are set to the design dimensions during installation on the airplane.

- (3) Tighten the nuts.

Assy No. 69B82839	Distance Between Bearing Centers (Inches)
-1	6.45
-13	3.25
-15	4.88
-17	5.42
-19	3.25
-21	3.00

Rod Assembly Length Adjustment
 Figure 601

C. Assemble rod assembly 254N1016-1.

- (1) Install the nuts (16, 17) and rod end bearings (21, 22) on the rod (25G).
- (2) Adjust the bearing (22) so that the bearing center is located as shown in Fig. 602. Tighten the nut (17).
- (3) Adjust the bearing (21) so that the distance between the bearing centers is as shown in Fig. 602. Tighten the nut (16).

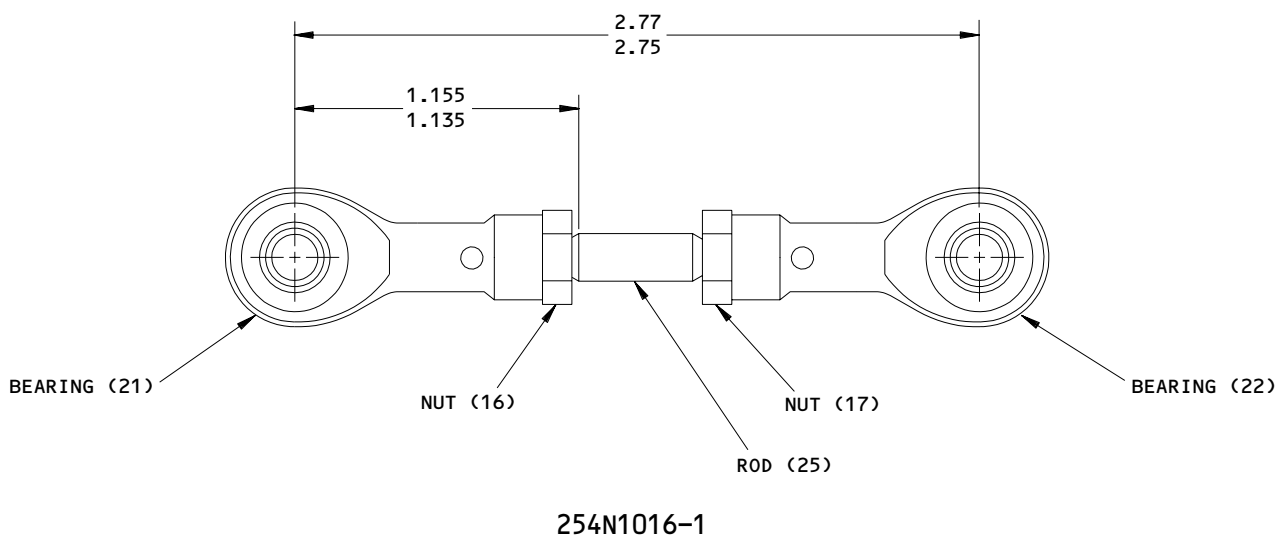
27-62-41

REPAIR 4-1

01.1

Page 602

Mar 01/99



ITEM NUMBERS REFER TO IPL FIG. 5
ALL DIMENSIONS ARE IN INCHES

69B82839-1,-13,-15,-17,-19,-21
254N1016-1
Rod Assembly - Assembly Details
Figure 602

27-62-41

REPAIR 4-1
Page 603
Mar 01/99

01.1

ILLUSTRATED PARTS LIST

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

2. Indentures show parts relationships as follows:

Assembly

Detail Parts for Assembly

Subassembly

Attaching Parts for Subassembly

Detail Parts for Subassembly

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

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

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

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

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

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

6. Parts Interchangeability

Optional
(OPT)

The parts are optional to and interchangeable with other parts having the same item number.

Supersedes, Superseded By
(SUPSDS, SUPSD BY)

The part supersedes and is not interchangeable with the original part.

Replaces, Replaced By
(REPLS, REPLD BY)

The part replaces and is interchangeable with, or is an alternate to, the original part.

27-62-41

ILLUSTRATED PARTS LIST

01.1

Page 1001

Jul 10/83

VENDORS

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

30163 VALENTEC DAYRON INC
333 MAGUIRE BLVD PO BOX 140394
ORLANDO, FLORIDA 32814-0394

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

43991 FAG BEARING INCORPORATED
118 HAMILTON AVENUE
STAMFORD, CONNECTICUT 06904

56644 AURORA BEARING CO
970 SOUTH LAKE STREET
AURORA, ILLINOIS 60506-5929

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

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

27-62-41

ILLUSTRATED PARTS LIST
01.1 Page 1002
Mar 01/99

SPEED BRAKE LEVER
 INSTL COMPONENTS
 SEE CONTENTS FOR P/N

 **BOEING**
 COMPONENT
 MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
AW3-5		5	20A	2
		5	21	1
AW3-7		5	22	1
BACB10AC6A		2	5	1
		4	5	1
BCRE12370		1	105B	2
HHKSP6A		2	5	1
		4	5	1
KBE3-103		5	22A	1
KBE3-61		5	20	2
		5	21A	1
KSP6A		2	5	1
		4	5	1
KSP6AE9440A		2	5	1
		4	5	1
KSP6AFS428		2	5	1
		4	5	1
KSP6AG27		2	5	1
		4	5	1
KSP6A2TS		2	5	1
		4	5	1
MS21209F1-15		1	100	1
MS35649-204		5	17	1
NAS671-10		5	15	2
		5	16	1
SR2-6EE		1	105	2
253T5611-4		1	115A	1
253T5611-5		1	5A	RF
253T5616-1		1	10	RF
		2	1	RF
253T5616-2		2	10	1
254N1016-1		1	35F	RF
		5	1F	RF

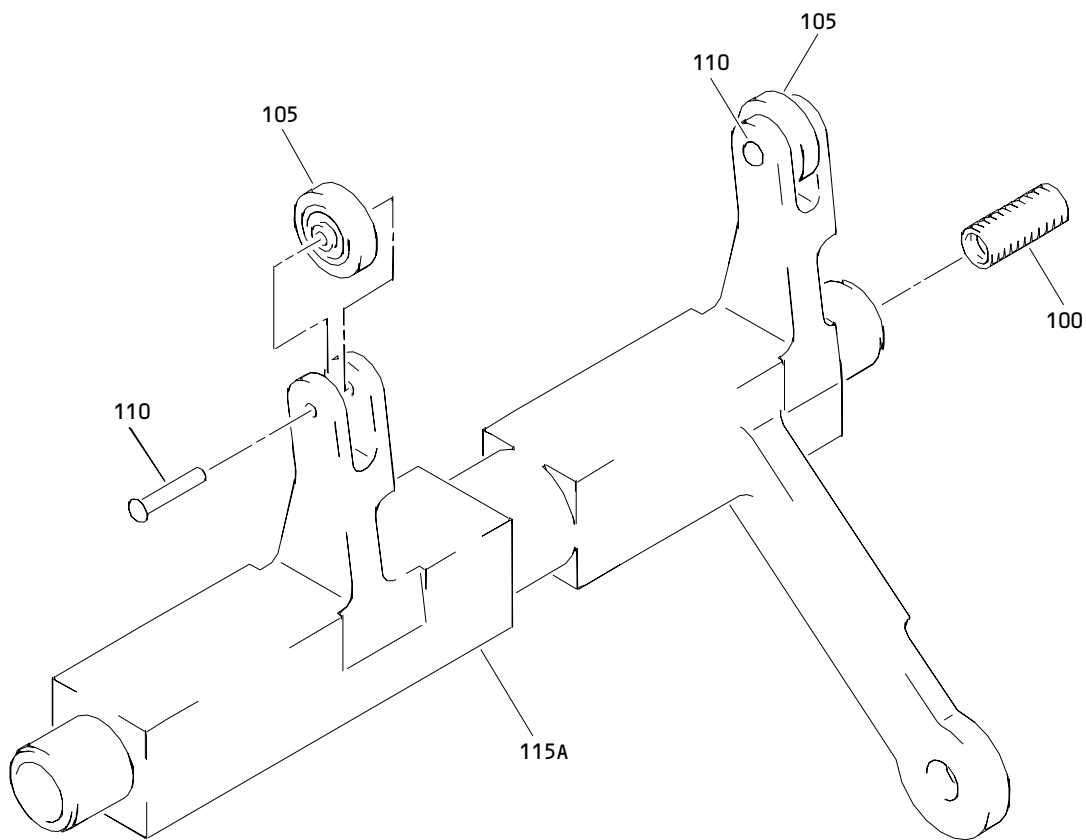
27-62-41

ILLUSTRATED PARTS LIST
 01.1 Page 1003
 Mar 01/99

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
254N1016-2		5	25G	1
65B84585-15		1	110	2
69B82756-1		1	20	RF
		4	1	RF
69B82756-2		4	10	1
69B82756-3		1	20A	RF
		4	1A	RF
69B82756-4		4	10A	1
69B82756-5		1	20B	RF
		4	1B	RF
69B82756-6		4	10B	1
69B82839-1		1	35B	RF
		5	1B	RF
69B82839-13		1	35	RF
		5	1	RF
69B82839-14		5	25	1
69B82839-15		1	35A	RF
		5	1A	RF
69B82839-16		5	25A	1
69B82839-17		1	35C	RF
		5	1C	RF
69B82839-18		5	25C	1
69B82839-19		1	35D	RF
		5	1D	RF
69B82839-20		5	25E	1
69B82839-21		1	35E	RF
		5	1E	RF
69B82839-22		5	25F	1

27-62-41

ILLUSTRATED PARTS LIST
 01.1 Page 1004
 Mar 01/99



Speed Brake Arming Shaft Assembly
Figure 1

27-62-41

ILLUSTRATED PARTS LIST
01.1 Page 1006
Mar 01/99

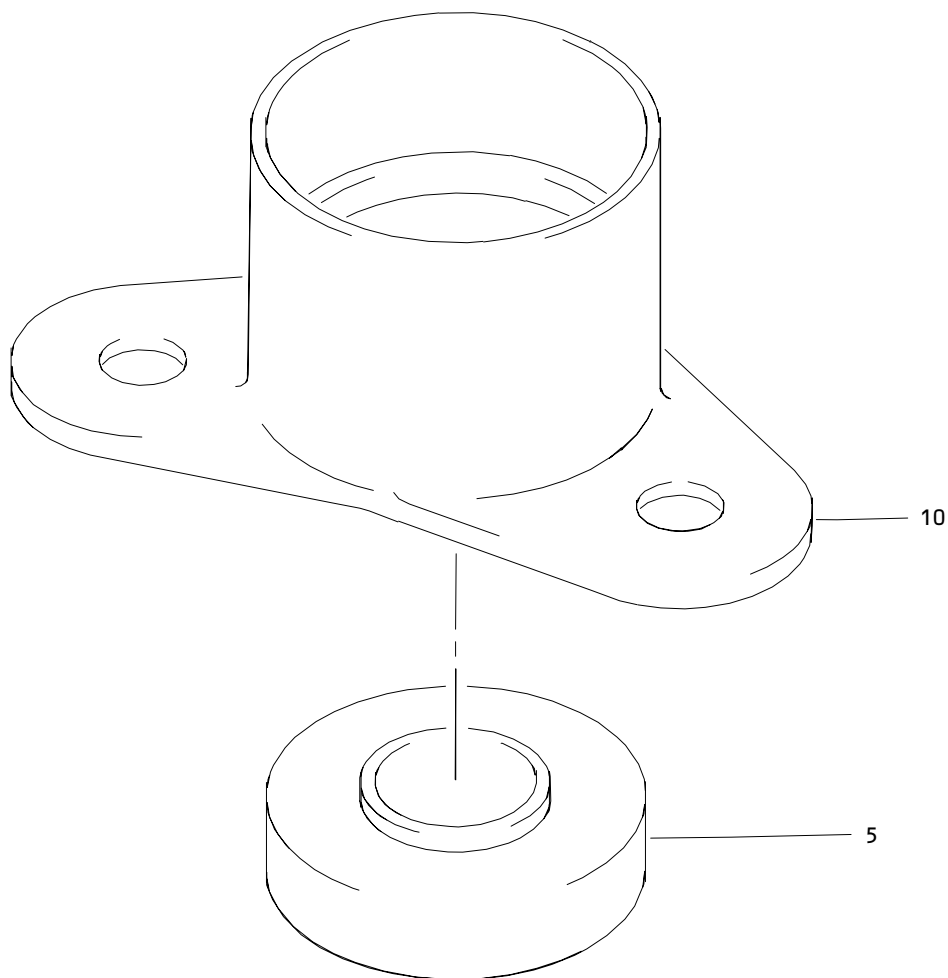
FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-			SPEED BRAKE COMPONENTS		
R -5	253T5611-1		DELETED		
R -5A	253T5611-5		SHAFT ASSY-SPEED BRAKE ARMING	A	RF
-10	253T5616-1		HOUSING ASSY-SPEED BRAKE ARMING BRG (FOR DETAILS SEE FIG. 2)	B	RF
-13	253T5612-1		DELETED		
-15	253T5612-4		DELETED		
-17	253T5612-6		DELETED		
R -20	69B82756-1		HOUSING ASSY-AUTO. SPEED BRAKE BRG (FOR DETAILS SEE FIG. 4)	D	RF
R -20A	69B82756-3		HOUSING ASSY-AUTO. SPEED BRAKE BRG (FOR DETAILS SEE FIG. 4)	F	RF
R -20B	69B82756-5		HOUSING ASSY-AUTO. SPEED BRAKE BRG (FOR DETAILS SEE FIG. 4)	G	RF
-35	69B82839-13		ROD ASSY-CONT STAND AIDS (FOR DETAILS SEE FIG. 5)	E	RF
R -35A	69B82839-15		ROD ASSY-CONT STAND AIDS (FOR DETAILS SEE FIG. 5)	H	RF
R -35B	69B82839-1		ROD ASSY-CONT STAND AIDS (FOR DETAILS SEE FIG. 5)	J	RF
R -35C	69B82839-17		ROD ASSY-CONT STAND AIDS (FOR DETAILS SEE FIG. 5)	K	RF
R -35D	69B82839-19		ROD ASSY-CONT STAND AIDS (FOR DETAILS SEE FIG. 5)	L	RF
R -35E	69B82839-21		ROD ASSY-CONT STAND AIDS (FOR DETAILS SEE FIG. 5)	C	RF
R -35F	254N1016-1		ROD ASSY-CONT STAND (FOR DETAILS SEE FIG. 5)	M	RF
-40	69B82839-1		DELETED		
-45	69B82839-17		DELETED		
100	MS21209F1-15		.INSERT	A	1
105	SR2-6EE		.BEARING- (V83086) (OPT ITEM 105A, 105B)	A	2
-105A	S618CE		.BEARING- (V83086) (OPT ITEMS 105, 105B)	A	2
R -105B	BCREF12370		.BEARING- (SSRI618EEHA7P25LDP) (OPT ITEMS 105, 105A)	A	2

27-62-41

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE	EFF CODE	QTY PER ASSY
			1234567		
01-					
110	65B84585-15		.RIVET	A	2
115	253T5611-2		DELETED		
R 115A	253T5611-4		.SHAFT	A	1

- Item Not Illustrated

27-62-41



Speed Brake Arming Bearing Housing Assembly
Figure 2

27-62-41

ILLUSTRATED PARTS LIST
01.1 Page 1010
Mar 01/99

SPEED BRAKE LEVER
 INSTL COMPONENTS
 SEE CONTENTS FOR P/N

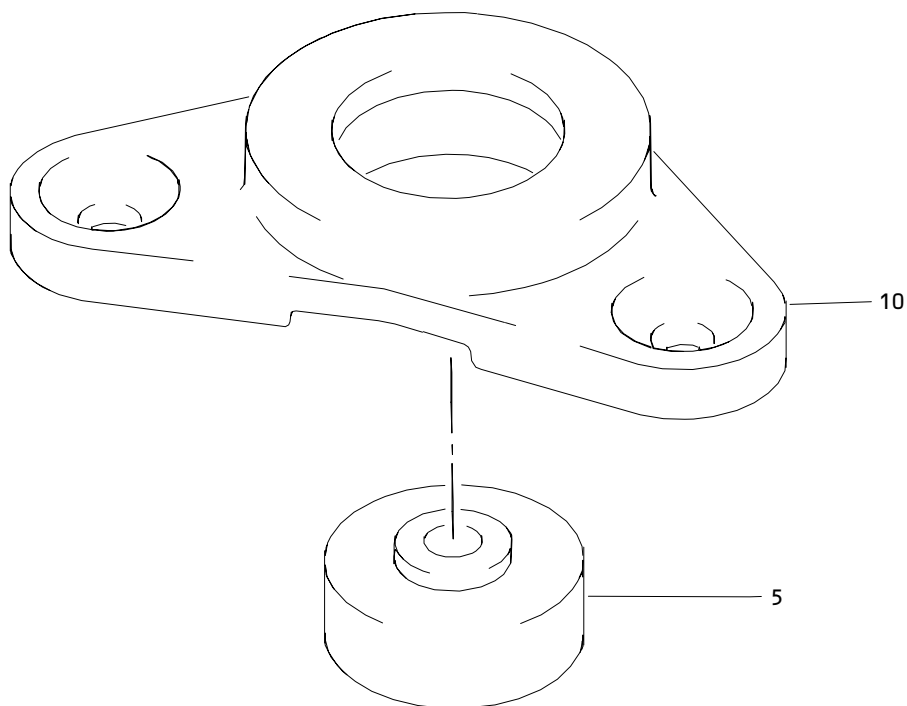
 **BOEING**
 COMPONENT
 MAINTENANCE MANUAL

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE	EFF CODE	QTY PER ASSY
			1234567		
02- -1	253T5616-1		HOUSING ASSY-SPEED BRAKE ARMING BRG	B	RF
R 5	KSP6A		.BEARING- (V38443) (SPEC BACB10AC6A) (OPT HHKSP6A (V38443)) (OPT KSP6AE9440A (V21335)) (OPT KSP6AFS428 (V21335)) (OPT KSP6A2TS (V43991)) (OPT KSP6AG27 (V30163))	B	1
10	253T5616-2		.HOUSING	B	1

- Item Not Illustrated

27-62-41

ILLUSTRATED PARTS LIST
 01.1 Page 1011
 Mar 01/99



Automatic Speed Brake Bearing Housing Assembly
Figure 4

27-62-41

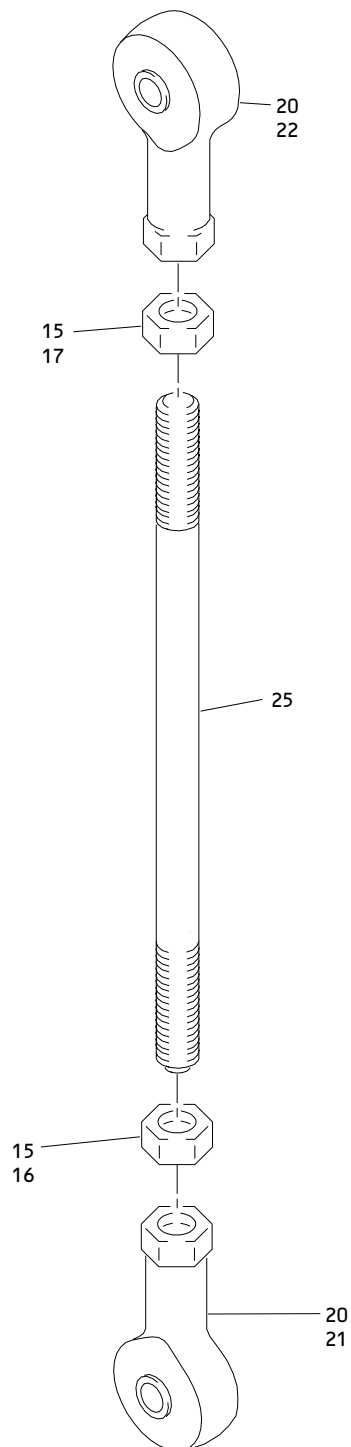
ILLUSTRATED PARTS LIST
01.1 Page 1012
Mar 01/99

SPEED BRAKE LEVER
 INSTL COMPONENTS
 SEE CONTENTS FOR P/N

 **BOEING**
 COMPONENT
 MAINTENANCE MANUAL

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 04- -1	69B82756-1		HOUSING ASSY-AUTO. SPEED BRAKE BRG	D	RF
R -1A	69B82756-3		HOUSING ASSY-AUTO. SPEED BRAKE BRG	F	RF
R -1B	69B82756-5		HOUSING ASSY-AUTO. SPEED BRAKE BRG	G	RF
R 5	KSP6A		.BEARING- (V38443) (SPEC BACB10AC6A) (OPT HHKSP6A (V38443)) (OPT KSP6AE9440A (V21335)) (OPT KSP6AFS428 (V21335)) (OPT KSP6A2TS (V43991)) (OPT KSP6AG27 (V30163))	D,F,G	1
R 10	69B82756-2		.HOUSING	D	1
R -10A	69B82756-4		.HOUSING	F	1
R -10B	69B82756-6		.HOUSING	G	1

- Item Not Illustrated



Control Stand Aids Rod Assembly
Figure 5

27-62-41

ILLUSTRATED PARTS LIST
01.1 Page 1014
Mar 01/99

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
05-					
R -1	69B82839-13		ROD ASSY-CONT STAND AIDS	E	RF
R -1A	69B82839-15		ROD ASSY-CONT STAND AIDS	H	RF
R -1B	69B82839-1		ROD ASSY-CONT STAND AIDS	J	RF
R -1C	69B82839-17		ROD ASSY-CONT STAND AIDS	K	RF
R -1D	69B82839-19		ROD ASSY-CONT STAND AIDS	L	RF
R -1E	69B82839-21		ROD ASSY-CONT STAND AIDS	C	RF
R -1F	254N1016-1		ROD ASSY-CONT STAND	M	RF
-5	69B82839-1		DELETED		
-10	69B82839-17		DELETED		
15	NAS671-10		.NUT	C,E, H-L	2
R 16	NAS671-10		.NUT	M	1
R 17	MS35649-204		.NUT	M	1
20	KBE3-61		.BEARING-ROD END (V97613) (OPT ITEM 20A)	C,E, H-L	2
R -20A	AW3-5		.BEARING-ROD END (V56644) (OPT ITEM 20)	C,E, H-L	2
R 21	AW3-5		.BEARING-ROD END (V56644) (OPT ITEM 21A)	M	1
R -21A	KBE3-61		.BEARING-ROD END (V97613) (OPT ITEM 21)	M	1
R 22	AW3-7		.BEARING-ROD END (V56644) (OPT ITEM 22A)	M	1
R -22A	KBE3-103		.BEARING-ROD END (V97613) (OPT ITEM 22)	M	1
25	69B82839-14		.ROD	E	1
R -25A	69B82839-16		.ROD	H	1
R -25B	69B82839-3		.ROD	J	1
R -25C	69B82839-18		.ROD	K	1
-25D	69B82839-11		DELETED		
R -25E	69B82839-20		.ROD	L	1
R -25F	69B82839-22		.ROD	C	1
R -25G	254N1016-2		.ROD	M	1
-30	69B82839-3		DELETED		
-35	69B82839-18		DELETED		

- Item Not Illustrated

27-62-41

ILLUSTRATED PARTS LIST
 01.1 Page 1015
 Mar 01/99