LEADING EDGE HIGH LIFT CONTROL INSTALLATION COMPONENTS

PART NUMBER SEE CONTENTS

COMPONENT MAINTENANCE MANUAL
WITH
ILLUSTRATED PARTS LIST

REVISION RECORD

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

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

TEMPORARY REVISION AND SERVICE BULLETIN RECORD

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVE	DATE OF INCORPORATION INTO MANUAL
		PRR B10517-4	APR 10/83

PAGE	DATE	CODE
27-81-35		
TITLE PAGE		
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2	BLANK	
REVISION RECORD		
1	JUL 10/83	01.1
2	BLANK	
TR & SB RECORD		
1	JUL 10/83	01.1
2	BLANK	
LIST OF EFFECTIVE PAGES		
*1	NOV 01/03	01
THRU LAST PAGE		
CONTENTS		
1	SEP 01/95	01.1
2	BLANK	
INTRODUCTION		
1	JUL 10/83	01.1
2	BLANK	
REPAIR-GENERAL		
601	MAR 01/99	01.1
602	MAR 01/99	01.1
603	SEP 01/95	01.1
604	BLANK	
REPAIR 1-1		
601	JUL 01/99	01.1
602	SEP 01/95	01.1
603	JUL 01/99	01.1
604	BLANK	
REPAIR 2-1		
601	MAR 01/99	01.1
602	MAR 01/99	01.1
603	MAR 01/99	01.1

PAGE	DATE	CODE
REPAIR 2-1		CONT.
604	JUL 01/99	01.1
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606	MAR 01/99	01.1
607	MAR 01/99	01.1
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REPAIR 3-1		
601	JUL 01/99	01.1
602	JUL 01/99	01.1
603	JUL 01/99	01.1
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REPAIR 4-1		
601	JAN 10/84	01.1
602	MAR 01/99	01.1
603	MAR 01/99	01.1
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REPAIR 5-1		
601	MAR 01/99	01.101
602	MAR 01/99	01.1
603	MAR 01/99	01.1
604	BLANK	
FITS AND CLEARANCES		
801	MAR 01/99	01.1
802	MAR 01/99	01.1
803	MAR 01/99	01.1
804	BLANK	
SPECIAL TOOLS		
901	SEP 01/95	01.1
902	BLANK	
ILLUSTRATED PARTS LIST		
1001	JUL 10/83	01.1
1002	MAR 01/99	01.1
1003	SEP 01/95	01.1
1004	JUL 01/99	01.1
1005	JUL 01/99	01.1

* = REVISED, ADDED OR DELETED

PAGE	DATE	CODE
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1009	JUL 01/99	01.1
1010	JUL 01/99	01.1
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1024	JUL 01/99	01.101
1025	JUL 01/99	01.101
1026	BLANK	

PAGE	DATE	CODE

* = REVISED, ADDED OR DELETED

TABLE OF CONTENTS

NOTE: This manual contains overhaul data for various installation components in the Leading Edge High Lift Control System. Overhaul functions which cannot be performed by use of standard industry practices are included in the repair instructions for each component.

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.

REPAIR - GENERAL

1. Content

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

2. Standard Practices

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

20-10-01	Repair and Refinish of High Strength Steel Parts
20-10-03	Shot Peening
20-10-04	Grinding of Chrome Plated Parts
20-20-01	Magnetic Particle Inspection
20-20-02	Penetrant Methods of Inspection
20-30-02	Stripping of Protective Finishes
20-41-01	Decoding Table for Boeing Finish Codes
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
20-60-02	Finishing Materials
20-60-03	Lubricants
20-60-04	Miscellaneous Materials

3. Materials

   NOTE: Equivalent substitutes may be used.

   A. Enamel -- BMS 10-11, type 2, color BAC702 white gloss (Ref 20-60-02)

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

   C. Primer -- BMS 10-11, type 1 (Ref 20-60-02)

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

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

F. Compound -- Corrosion Inhibiting (Ref 20-60-02)

4. Dimensioning Symbols

A. Standard True Position Dimensioning Symbols used in 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 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 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] OR 2.000 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

80213

QUADRANT ASSEMBLY - REPAIR 1-1

256T1111-8 THRU -12

NOTE: Refer to REPAIR-GEN for list of applicable standard practices. Item numbers refer to IPL Fig. 1.

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

2. Magnetic particle check per 20-20-01 -- Shaft (45).

3. Penetrant check per 20-20-02 -- Quadrant (95), bracket (70D).

4. Refinish parts according to Fig. 601.

5. Bearing Replacement

   A. Remove the bearing (50, 55).

   B. install the new bearing with MIL-G-23827 grease (Ref 20-50-03).

6. Bushing Replacement

   A. Remove the bushing (40).

   B. Install the new bushing (Ref 20-50-03).

7. Shaft (45) Repair (Fig. 602)

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

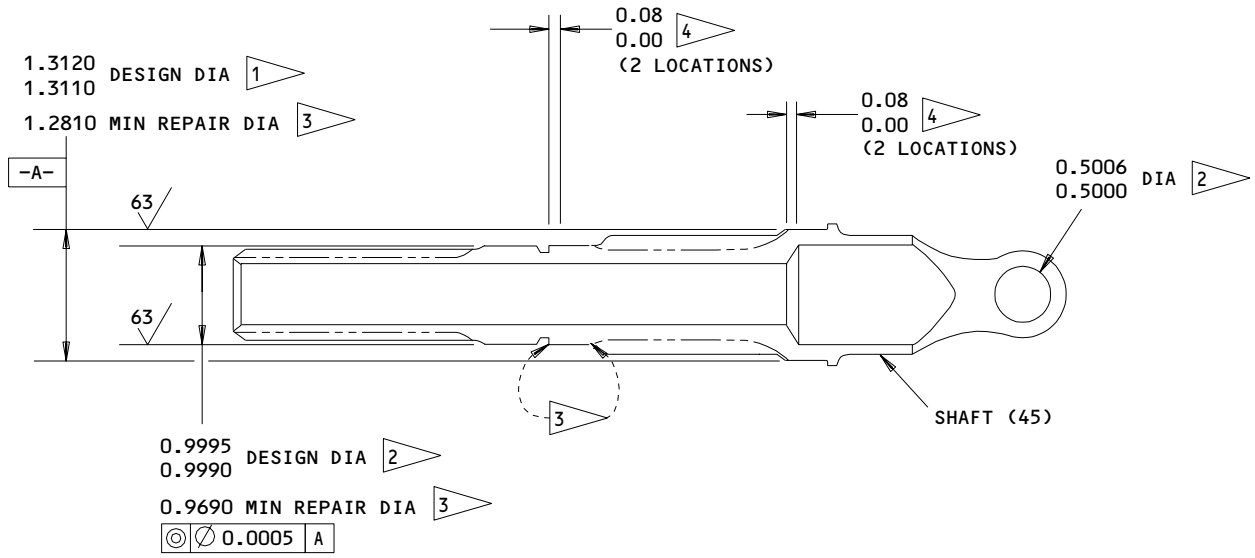
   B. Shot peen as indicated.

   C. Build up repaired area with chrome plate and grind to design dimension and finish shown. Observe 0.015 maximum plating thickness.

8. Assemble using standard industry practices, except tighten nut (30), using socket 6MIT65B04002-9, to 100-135 lb-in. above self-locking torque. Maximum side play shall be 0.020 inch after nut torque requirement is met.

IPL FIG. & ITEM	MATERIAL	FINISH
Fig. 1		
Washer (60,65) Bracket (70D)	Al alloy	Chromic acid or sulfuric acid anodize (F-17.05) and apply one coat of BMS 10-11, type 1 primer (F-20.02) all over, except no primer on bracket bearing bores.
Quadrant (95)	Al alloy	Chromic acid or sulfuric acid anodize (F-17.05) all over. Apply one coat of BMS 10-11, type 1 primer (F-20.02) all over except no primer on internal splines.

Refinish Details
Figure 601



REFINISH

SHAFT (45)--CADMIUM PLATE (F-17.09) ALL OVER, BUT NOT ON THE SURFACES SHOWN

1. DIMENSIONS APPLY AFTER PLATING
2. NO CADMIUM PLATE ON THIS SURFACE
3. BUILD UP WITH CHROME PLATE (F-15.03) AND GRIND TO DESIGN DIMENSION AND FINISH SHOWN 0.005 MINIMUM PLATING THICKNESS
4. OBSERVE PLATING RUNOUT. STOP PLATING 0.00-0.02 FROM INTERFACE EDGE AND FILLET RADII

REPAIR

REF 3 4

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK SHARP EDGES 0.008 R

SHOT PEEN: 170-460 SHOT SIZE
0.014A INTENSITY
2.0 COVERAGE

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

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

256T1111-8 THRU -12
Quadrant Assembly - Shaft Repair
Figure 602

K00208

CONTROL SHAFT ASSEMBLY - REPAIR 2-1

256T1116-1, -2, -10, -14, -15, -16

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

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

   A. Do a check of splined components as follows:

      (1) Do a visual check of all bearing surfaces on the splines for evidence of wear or pitting. Use of magnification is recommended.

      (2) If no obvious sign of wear on spline bearing surfaces is detected, repair finish and reassemble in respective assemblies.

      (3) If any signs of wear are detected on any of the splines, replace splined components with new parts in the respective assemblies.

          NOTE: Visual detection of wear requires judgement. If there is any question concerning interpretation of wear, replace splined components with new parts.

2. Magnetic particle check per 20-20-01 -- Yoke (55, 57, IPL Fig. 2) coupling (30), fitting (35, 37C, 80, 105) and shaft (85B).

3. Penetrant check per 20-20-02 -- Tubes (60, 63A, 65, 67A, 90A, 110A).

4. Refinish tubes (60, 63A, 65, 67A, 90A, 110A) according to Fig. 601.

5. Refinish the yoke (55, 57), coupling (30), and fittings (35, 37C, 80) according to Fig. 602.

6. Refinish the fitting (37B, 105) and the shaft (85B) according to the Refinish instructions on Fig. 603.

7. Replace the coupling (30), fitting (35, 37B, 105), yoke assembly (43A), or tube (90A).

   A. Remove the rivets (20, 25, 70, 75, 95) or fasteners (28), and disassemble the parts on the tube (60, 63A, 67A, 90A, 110A).

   B. Drill 0.160-0.164 inch diameter rivet holes, or 0.260-0.263 inch diameter fastener holes, to match the existing holes in the mating parts.

   C. Apply BMS 10-11, type 1 primer or BMS 5-95 sealant to the mating surfaces, as shown in Fig. 604, then install the new parts. Apply primer to the fastener holes, then immediately install the rivets or fasteners. Refer to Fig. 604 for the dimensions and rivet installation instructions. Make sure that the parts have no radial play after the rivets or fasteners are installed.

   D. Install the expansion plugs (40, 100) after the shaft end fittings are permanently attached to the tube. Deform the plugs until they are flat. Some spring back is permitted.

8. Replace the bushing (50, 52).

   A. Remove the existing bushing (50, 52).

   B. Install the new bushing (Ref 20-50-03).

9. Shaft (85A) and Fitting (37B, 105) Repair (Fig. 603).

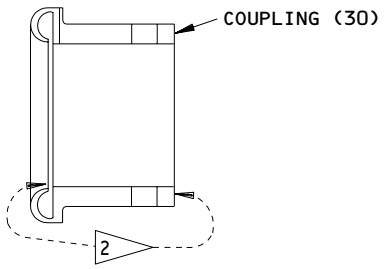
   A. Machine the bearing surface as required, within the repair limits shown, to remove defects.

   B. Shot peen as indicated.

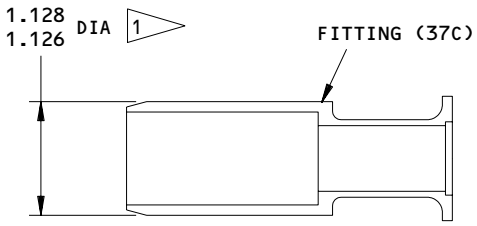
C. Build up the repaired area with chrome plate and grind to design dimension and finish shown. Observe 0.015 maximum plating thickness.

IPL FIG. & ITEM	MATERIAL	FINISH
Fig. 2		
Tube (60,65,90A, 110A)	Al alloy	Chemical treat and apply one layer of primer all over (F-18.07), but do not apply primer on the mating surfaces, approximately 2 inches on each end.
Tube (63A,67A)	Al alloy	Chemical treat and apply one layer of primer all over (F-18.07), but do not apply primer on the mating surfaces, approximately 2 inches on each end. Apply corrosion inhibiting compound to inner surfaces, but do not apply compound on the mating surfaces.

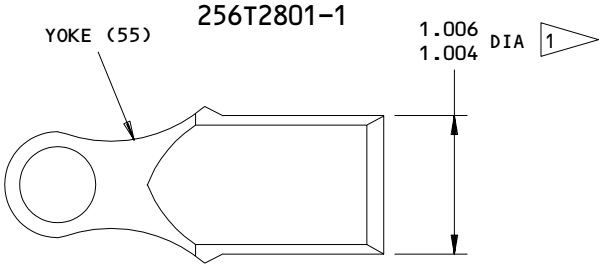
Refinish Details
Figure 601



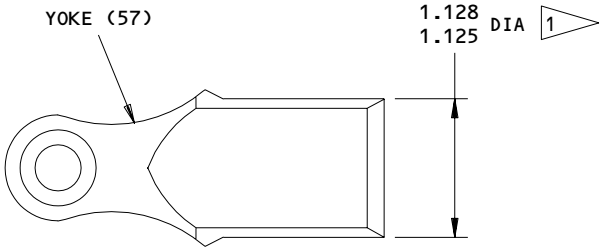
COUPLING
256T2801-1



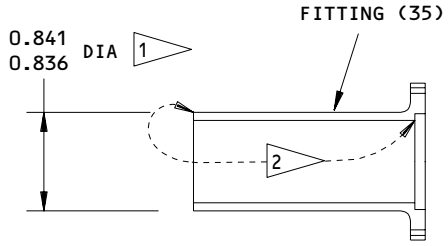
FITTING
256T1141-2



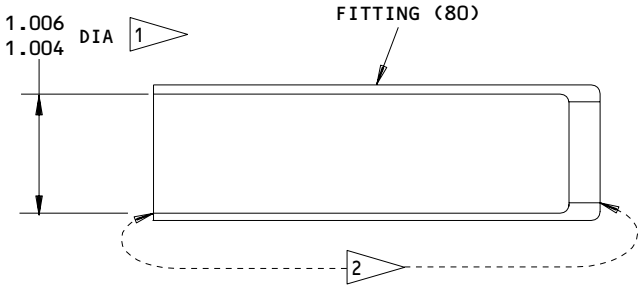
YOKE
256T1107-4



YOKE
256T1143-4



FITTING
256T2806-1



FITTING
256T1125-3

REFINISH

COUPLING (30), FITTINGS (35,80)--CADMIUM PLATE (F-15.02) ALL OVER, AND APPLY ONE LAYER OF PRIMER (F-20.02) ON THE SURFACES SHOWN.

YOKE (55)--PASSIVATE (F-17.09) AND CADMIUM PLATE (F-15.06) ALL OVER, BUT DO NOT PLATE THE BUSHING BORES.

YOKE (57, FITTING (37C)--CADMIUM PLATE (F-15.06) EXTERIOR SURFACES. PLATING THROW-IN IS PERMITTED ON THE ID, AND ON THE BUSHING BORES OF THE YOKE.

MATERIAL: YOKE (55,57), FITTING (37C)
15-5PH CRES, 180-200 KSI

COUPLING (30)
4140 STEEL, 150-170 KSI

FITTING (35,80)
4340 STEEL, 150-170 KSI

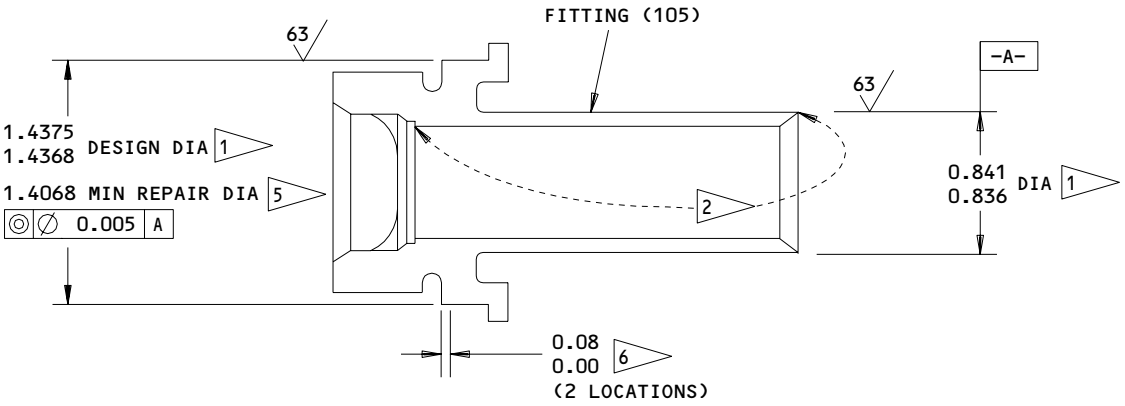
ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

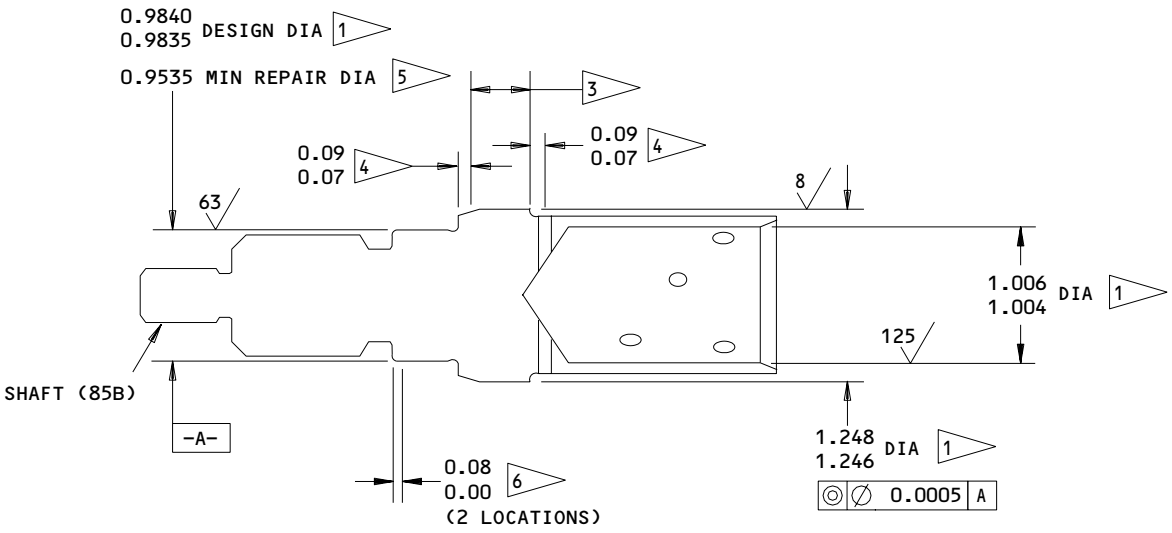
1 DIMENSIONS APPLY AFTER PLATING

2 APPLY PRIMER ON THESE SURFACES

256T1116-1,-2,-10,-14,-15,-16
Control Shaft Assembly - Refinish Details
Figure 602



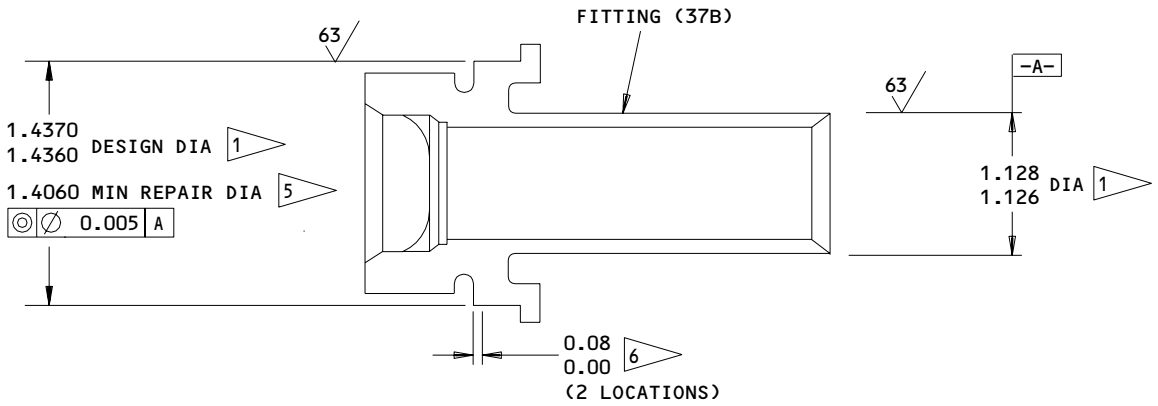
FITTING
256T2802-1



SHAFT
256T2504-4

256T1116-1,-2,-10,-14,-15,-16
Control Shaft Assembly - Repair Details
Figure 603 (Sheet 1)

4121



FITTING
256T1140-2

REFINISH

FITTING (105)--CADMIUM PLATE (F-15.02) ALL OVER AND APPLY ONE LAYER OF PRIMER (F-20.02) ON THE SURFACES SHOWN

SHAFT (85B)--CADMIUM PLATE (F-15.02) ALL OVER, BUT NOT ON THE SURFACE TO BE CHROME PLATED. CHROME PLATE (F-15.03) THE SURFACES SHOWN

FITTING (37B)--CADMIUM PLATE (F-15.06) EXTERIOR SURFACES. PLATING THROW-IN IS PREMITTED ON THE ID

1 DIMENSIONS APPLY AFTER PLATING

2 APPLY PRIMER ON THESE SURFACES

3 CHROME PLATE THIS AREA ONLY. 0.002 MINIMUM THICKNESS AFTER GRINDING. 8 MICROINCHES BEFORE AND AFTER PLATING

4 CHROME PLATE RUNOUT IN THIS AREA

5 BUILD UP WITH CHROME PLATE (F-15.03) AND GRIND TO DESIGN DIMENSION AND FINISH SHOWN. 0.005 MINIMUM PLATING THICKNESS

6 OBSERVE PLATING RUNOUT. STOP PLATING 0.00-0.02 FROM INTERFACE EDGE AND FILLET RADII

REPAIR

REF 5 6

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK SHARP EDGES 0.008 R

SHOT PEEN: 170-460 SHOT SIZE
0.014A INTENSITY
2.0 COVERAGE

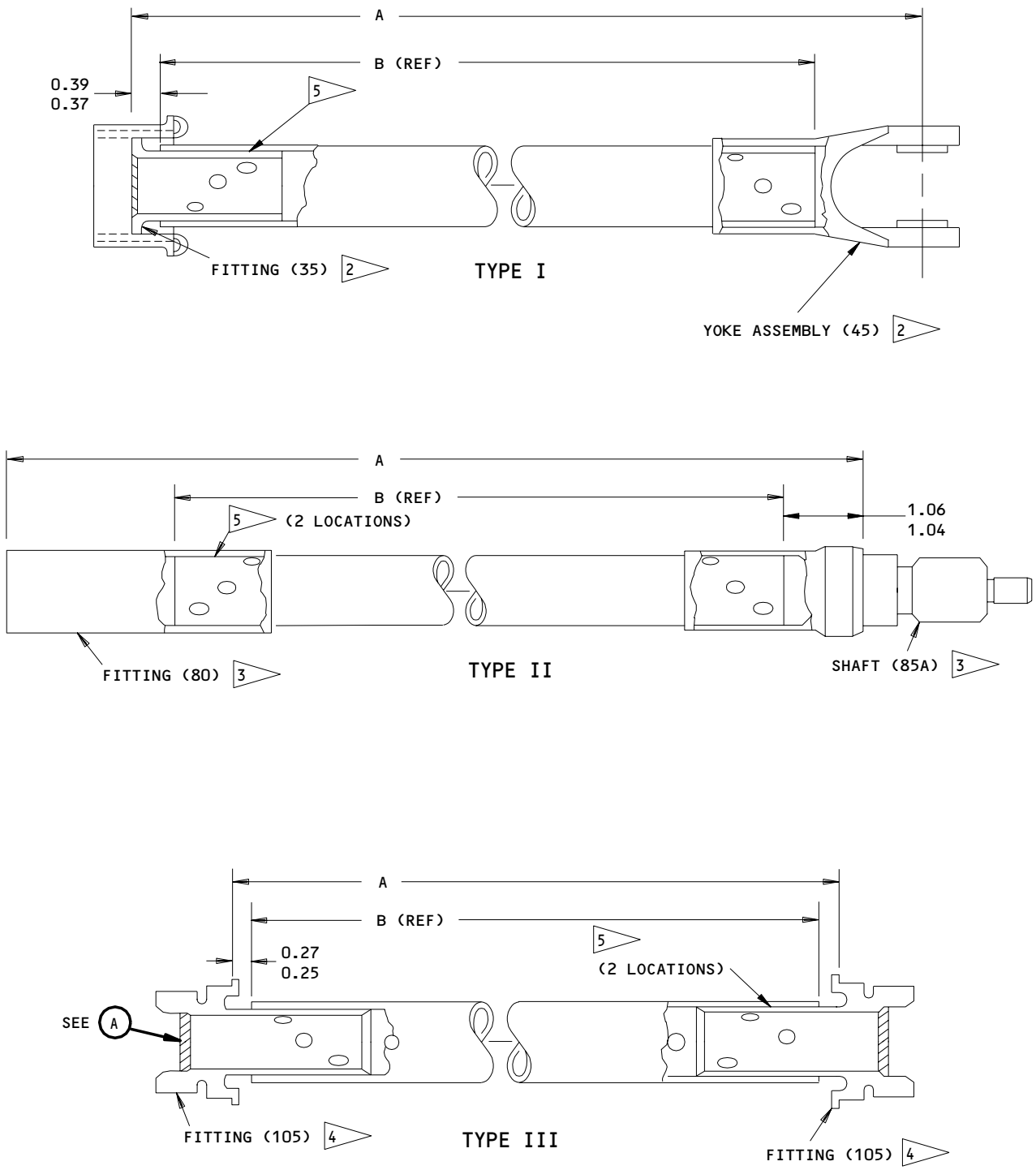
MATERIAL: FITTING (105)
4340 STEEL, 150-170 KSI

SHAFT (85B), FITTING (37B)
15-5PH CRES, 180-200 KSI

ITEM NUMBERS REFER TO IPL FIG. 2

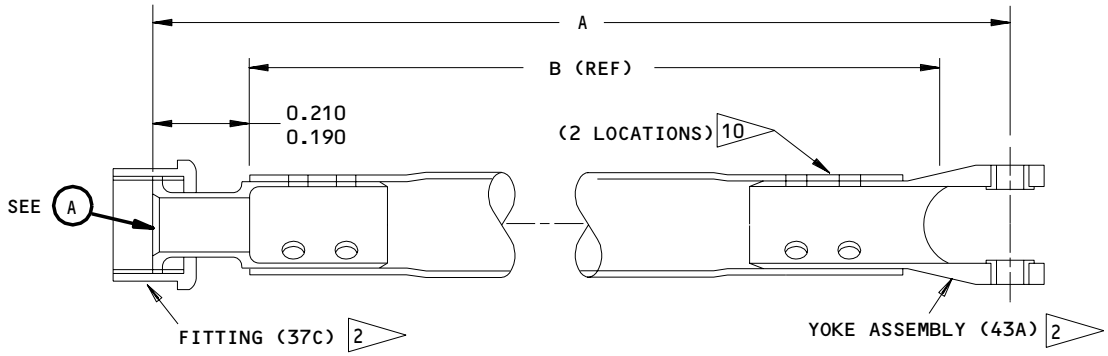
ALL DIMENSIONS ARE IN INCHES

256T1116-1,-2,-10,-14,-15,-16
Control Shaft Assembly - Repair Details
Figure 603 (Sheet 2)



256T1116-1,-2,-10,-14,-15,-16
Control Shaft Assembly - Replacement Diagram
Figure 604 (Sheet 1)

4127



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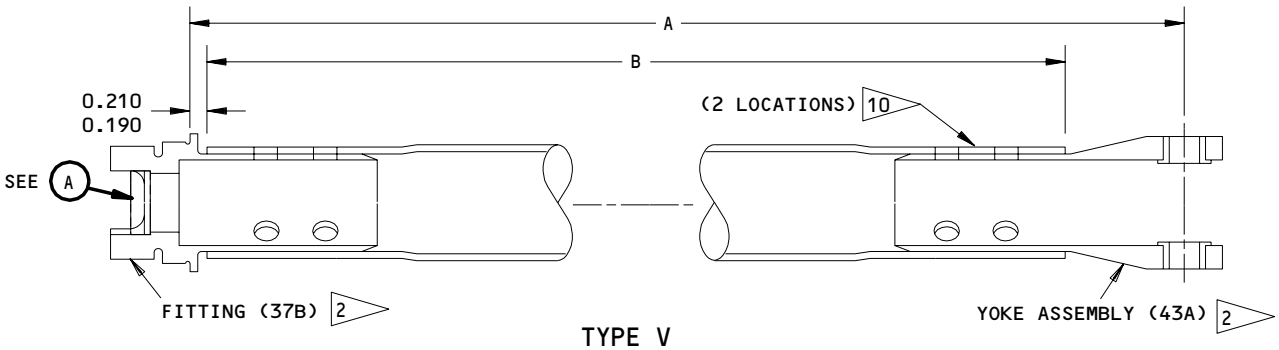

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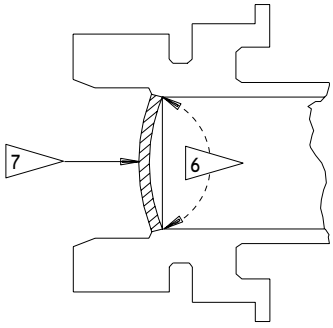
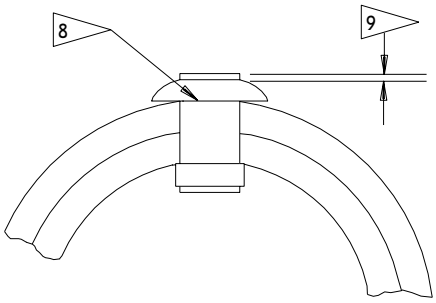


TYPICAL EXPANSION PLUG
INSTALLATION



TYPICAL INSTALLATION
OF NAS1398MW RIVET

A

256T1116-1,-2,-10,-14,-15,-16
Control Shaft Assembly - Replacement Diagram
Figure 604 (Sheet 2)

PART NUMBER	TYPE	ASSEMBLY LENGTH A 1	TUBE LENGTH B (REF)
256T1116-1	I	36.63 36.57	34.98 34.92
256T1116-2	I	37.51 37.45	35.86 35.80
256T1116-14	II	21.17 21.11	17.80 17.74
256T1116-10	III	60.49 60.43	59.97 59.91
256T1116-15	IV	36.625 36.575	33.85 33.81
256T1116-16	V	99.075 99.025	97.42 97.38

1 ASSEMBLIES TO BE STRAIGHT WITHIN 0.005 FIM PER FOOT OF LENGTH

2 CENTERLINE OF A SPLINE TOOTH ON FITTING (35,37B, OR 37C) TO BE ALIGNED WITH CENTERLINE OF YOKE ASSEMBLY BUSHINGS (50,52) WITHIN ±1°

3 CENTERLINE OF MISSING TOOTH ON SHAFT (85A) TO BE ALIGNED AT 179°-181° WITH CENTERLINE OF MISSING TOOTH SPACE IN FITTING (80)

4 SPLINE TEETH ON END FITTINGS TO BE ALIGNED WITHIN ±1°

5 APPLY WET PRIMER, BMS 10-11, TYPE 1 (F-20.06) TO MATING SURFACES ON ASSEMBLY

6 APPLY SEALANT, BMS 5-95, TO PLUG AND MATING COUNTERBORE BEFORE ASSEMBLY

7 INSTALL PLUG AFTER SHAFT END FITTINGS ARE PERMANENTLY ATTACHED TO TUBE. DEFORM PLUG UNTIL FLAT ON INSTALLATION - SOME SPRING BACK IS ALLOWED

8 FASTENER REQUIRED TO SEAT AT TANGENT POINT ONLY

9 0.010
0.000 PROTRUSION OF SHANK ALLOWED ABOVE COLLAR ON TUBE ASSEMBLY ENDS THAT HAVE COUPLING (30)

10 APPLY SEALANT, BMS 5-95, TO THIS SURFACE AT ASSEMBLY

ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

256T1116-1,-2,-10,-14,-15,-16
Control Shaft Assembly - Replacement Diagram
Figure 604 (Sheet 3)

K00409

SUPPORT ASSEMBLY - REPAIR 3-1

256T1128-1 THRU -4

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

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

2. Magnetic particle check per 20-20-01 -- Shaft (20, IPL Fig. 3).

3. Penetrant check per 20-20-02 -- Support (50).

4. Refinish parts according to Fig. 601 and 602.

5. Bushing (15) Replacement

   A. Remove the existing bushing (15).

   B. Install the new bushing (Ref 20-50-03).

6. Bearing (25, 30) Replacement

   A. Remove the bearing (25, 30).

   B. install the new bearing with MIL-G-23827 grease (Ref 20-50-03).

7. Shaft (20) Repair (Fig. 602)

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

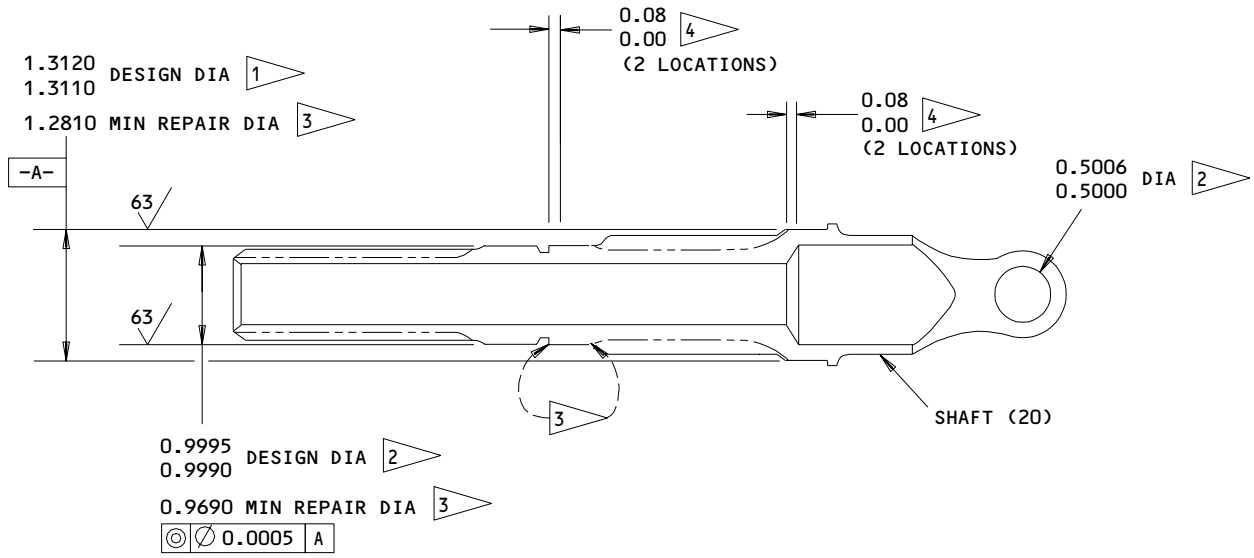
   B. Shot peen as indicated.

   C. Build up repaired area with chrome plate and grind to design dimension and finish shown. Observe 0.015 maximum plating thickness.

8. Assemble using standard industry practices except tighten nut (5), using socket 6MIT65B04002-9, to 100-135 lb-in. above self-locking torque.

IPL FIG. & ITEM	MATERIAL	FINISH
Fig. 3		
Washer (35,40)	Al alloy	Chromic acid or sulfuric acid anodize (F-17.05) and apply one coat of BMS 10-11, type 1 primer (F-20.02) all over.
Spacer (45)	Al alloy	Chromic acid anodize and apply one coat of BMS 10-11, type 1 primer (F-18.13) all over.
Support (50 thru 50D)	Al alloy	Chromic acid or sulfuric acid anodize (F-17.05). Apply one coat of BMS 10-11, type 1 primer (F-20.02) and one coat of BMS 10-11, type 2 enamel, color BAC702 white gloss (F-21.03) all over except no primer or enamel on bearing bores.
Support (50E)	Al alloy	Chromic acid anodize (F-17.04). Apply two coats of BMS 10-11, type 1 primer (F-20.03) all over except no primer on bearing bores.

Refinish Details
Figure 601



REFINISH

SHAFT (20)--CADMIUM PLATE (F-17.09) ALL OVER, BUT NOT ON THE SURFACES SHOWN

1 DIMENSIONS APPLY AFTER PLATING

2 NO CADMIUM PLATE ON THIS SURFACE

3 BUILD UP WITH CHROME PLATE (F-15.03) AND GRIND TO DESIGN DIMENSION AND FINISH SHOWN 0.005 MINIMUM PLATING THICKNESS

4 OBSERVE PLATING RUNOUT. STOP PLATING 0.00-0.02 FROM INTERFACE EDGE AND FILLET RADII

REPAIR

REF 3 4

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK SHARP EDGES 0.008 R

SHOT PEEN: 170-460 SHOT SIZE
0.014A INTENSITY
2.0 COVERAGE

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

ITEM NUMBERS REFER TO IPL FIG. 3

ALL DIMENSIONS ARE IN INCHES

256T1128-1 Thru -4
Support Assembly - Shaft Repair
Figure 602

209614

DRIVE SHAFT ASSEMBLY - REPAIR 4-1

256T2857-1

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

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

2. Magnetic particle check per 20-20-01 -- Yoke (20, IPL Fig. 4) and fitting (30).

3. Penetrant check per 20-20-02 -- Tube (35)

4. Refinish parts per Fig. 601 and 602.

5. Parts Replacement (Fig. 602).

   A. Remove rivets (10,25) to disassemble drive shaft assembly.

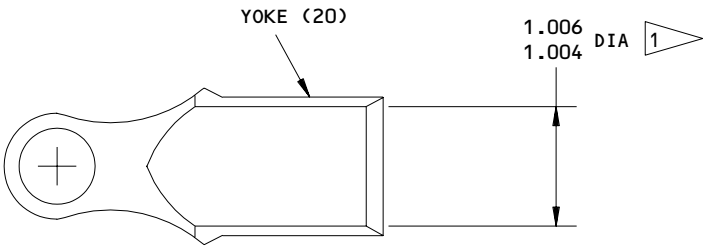
   B. Position replacement part as shown in Fig. 602 and drill 0.160-0.164 in. dia rivet holes, using holes in existing parts as a pattern.

   C. Apply sealant to indicated faying surfaces only, and install replacement part. Secure parts with rivets installed with sealant. After riveting, check that parts have no radial play.

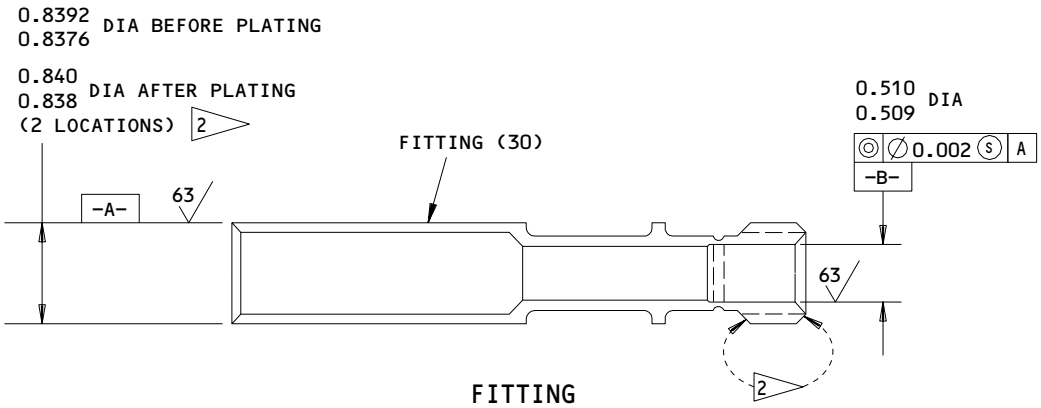
6. Bushing (15) Replacement

   A. Remove bushing (15) from yoke assembly (5).

   B. Install replacement bushing per 20-50-03.



YOKE
256T1107-4



FITTING
256T2855-1

REFINISH

YOKE (20)--PASSIVATE (F-17.09) AND CADMIUM PLATE (F-15.06) ALL OVER, BUT DO NOT PLATE THE BUSHING BORES.

FITTING (30)--CADMIUM TITANIUM ALLOY PLATE ALL EXTERIOR SURFACES (REFER TO 20-42-02). THROW-IN IS PERMITTED AT THE TWO ENDS. APPLY PHOSPHATE TREATMENT ALL OVER. APPLY ONE LAYER OF PRIMER (F-20.02) ON THE EXTERIOR SURFACES, BUT NOT ON THE SURFACES SHOWN. APPLY TWO LAYERS OF PRIMER (F-20.03) ON THE INTERIOR SURFACES.

1 DIMENSIONS APPLY AFTER PLATING

2 DO NOT APPLY PRIMER ON THESE SURFACES

MATERIAL: YOKE (20)
15-5PH CRES, 180-200 KSI

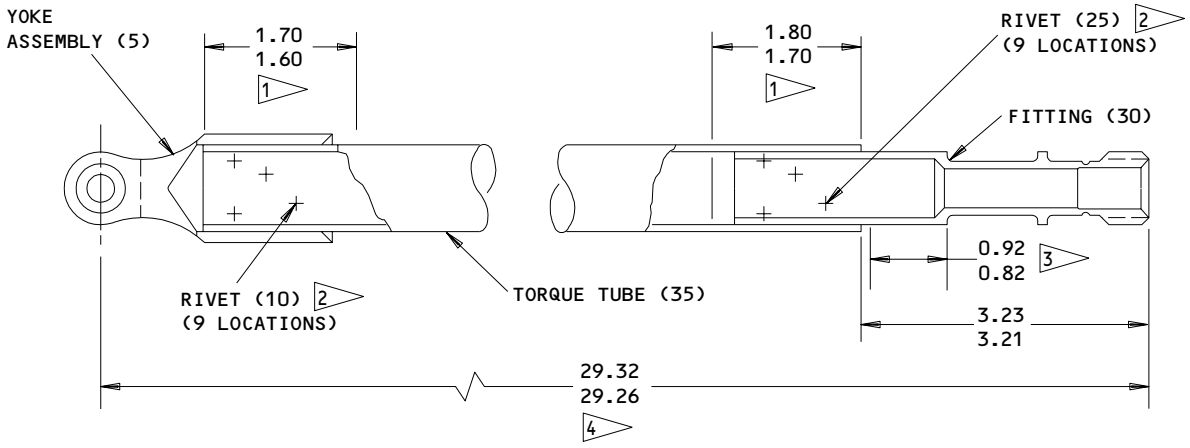
FITTING (30)
4330M STEEL, 220-240 KSI

ITEM NUMBERS REFER TO IPL FIG. 4

ALL DIMENSIONS ARE IN INCHES

256T2857-1
Drive Shaft Assembly - Refinish Details
Figure 601

80216



REFINISH

TUBE (35)--CHEMICAL TREAT AND APPLY ONE LAYER OF PRIMER (F-18.07), BUT NOT ON THE SURFACES SHOWN

MATERIAL: AL ALLOY

ITEM NUMBERS REFER TO IPL FIG. 4

ALL DIMENSIONS ARE IN INCHES

1 DO NOT APPLY PRIMER ON THESE FAYING SURFACES. APPLY SEALANT, BMS 5-95 (BMS 5-26, TYPE II, CLASS A OPTIONAL) BEFORE ASSEMBLY

2 INSTALL RIVETS WITH SEALANT, BMS 5-95 (BMS 5-26 OPTIONAL)

3 NO SEALANT PERMITTED IN THIS AREA

4 ASSEMBLY TO BE STRAIGHT WITHIN 0.005 FIM PER FOOT OF LENGTH

256T2857-1
Drive Shaft Assembly - Tube Refinish and Parts Replacement
Figure 602

80217

SUPPORT BRACKET ASSEMBLY - REPAIR 5-1

256T2601-5, -7

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

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

2. Penetrant check support bracket (15, IPL Fig. 5) per 20-20-02.

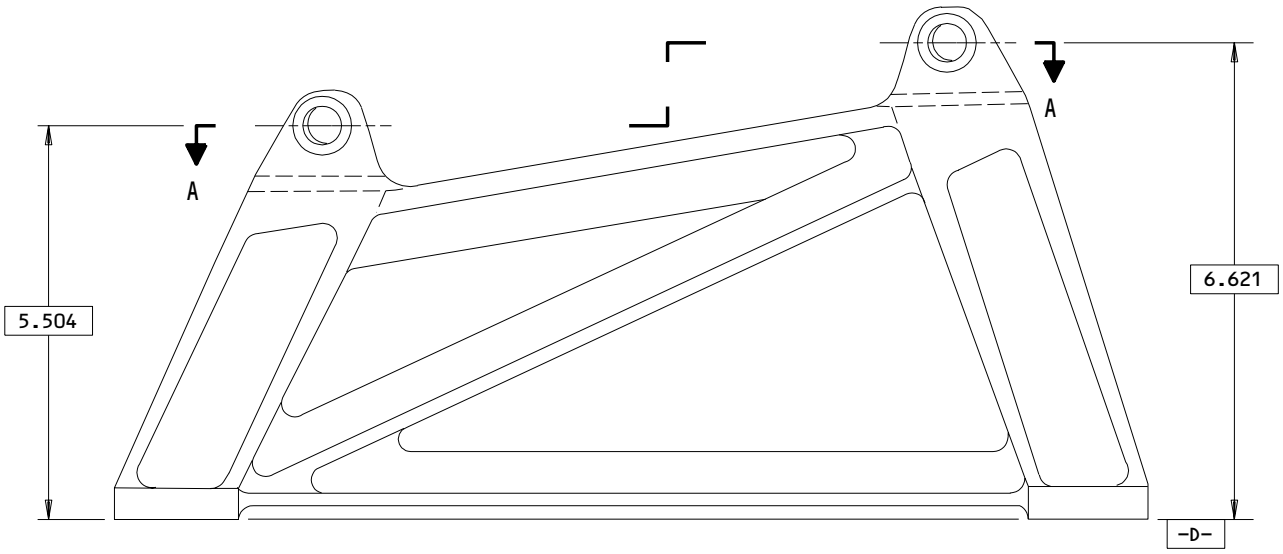
3. Replace bushings (5, 10) as follows.

   A. Remove bushings (5, 10).

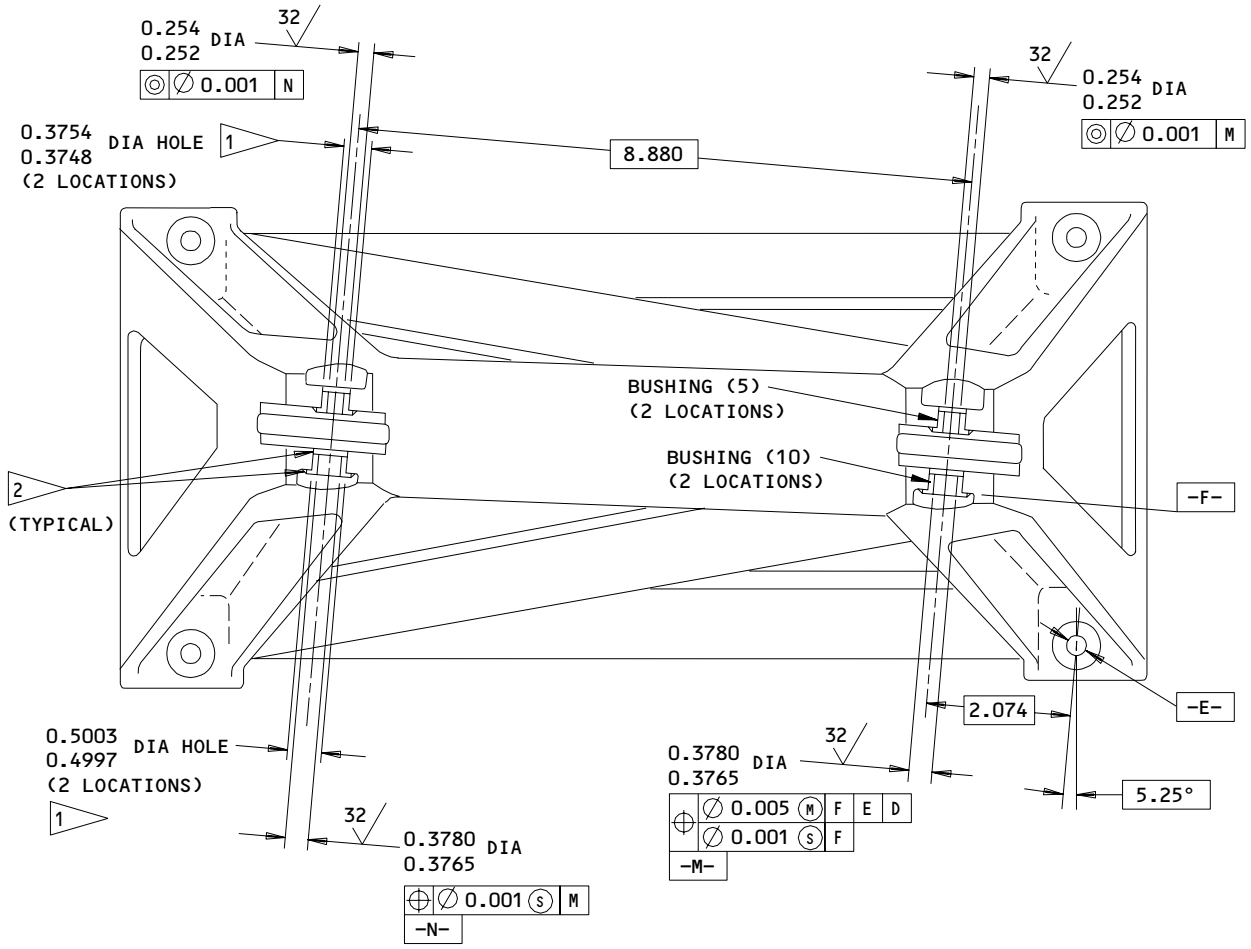
   B. Install replacement bushings per 20-50-03, except use wet sealant, BMS 5-95.

   C. Machine bushing bores per Fig. 601.

   D. Fillet seal both ends of each bushing with sealant.



256T2601-5,-7
Bracket Assembly - Bushing Replacement and Refinish
Figure 601 (Sheet 1)



A-A

REFINISH

BRACKET (15)--CHROMIC ACID OR SULFURIC ACID ANODIZE (F-17.05). APPLY ONE LAYER OF PRIMER (F-20.02), BUT NOT IN THE HOLES SHOWN

1 NO PRIMER THIS SURFACE
2 FILLET SEAL THE ENDS OF THE BUSHING

MATERIAL: BRACKET -- AL ALLOY

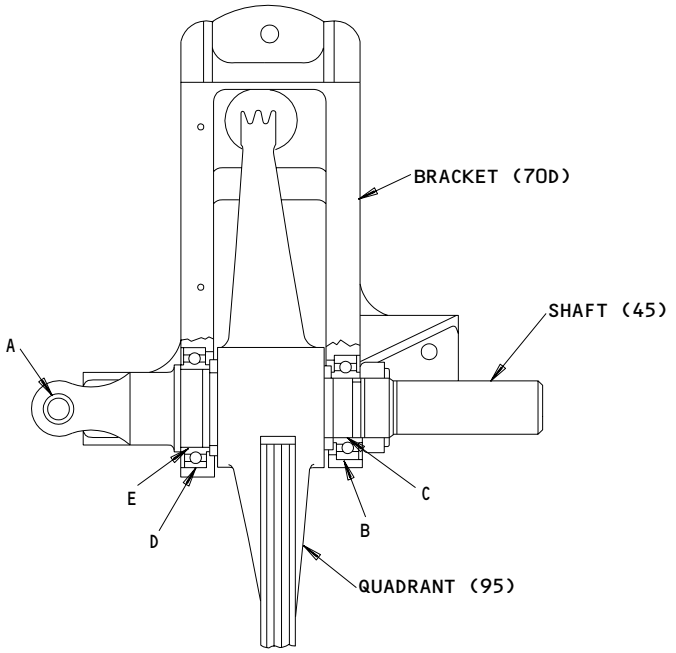
ITEM NUMBERS REFER TO IPL FIG. 5

ALL DIMENSIONS ARE IN INCHES

256T2601-5,-7
Bracket Assembly - Bushing Replacement and Refinish
Figure 601 (Sheet 2)

140137

FITS AND CLEARANCES



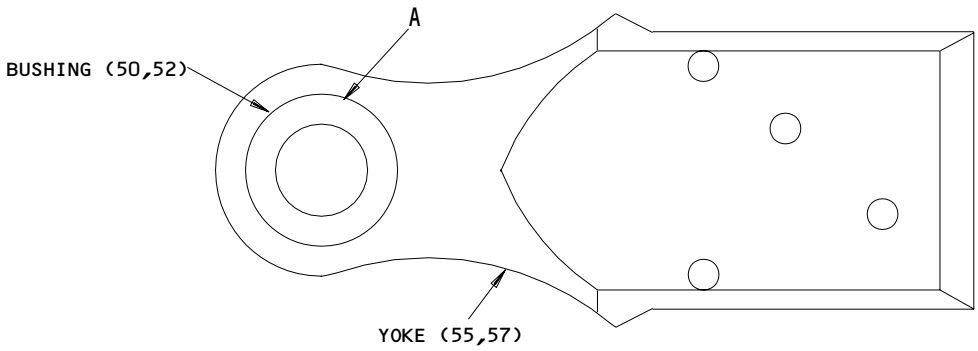
Ref Letter Fig.801	Mating Item No. IPL Fig.1	Design Dimension				Service Wear Limit		
		Dimension		Assembly Clearance 1		Dimension		Maximum Clearance
		Min	Max	Min	Max	Min	Max	
A	ID 45 OD 40B	0.5000 0.5010	0.5006 0.5016	-0.0016	-0.0004	0.5006	0.5010	0.0000
B	ID 70D OD 50	1.7500 1.7490	1.7510 1.7500	0.0000	0.0020	1.7460	1.7530	0.0040
C	ID 50 OD 45	0.9990 0.9990	1.0000 0.995	-0.0005	0.0010	0.9950	1.0035	0.0040
D	ID 70D OD 55	2.0625 2.0615	2.0635 2.0625	0.0000	0.0020	2.0585	2.0665	0.0040
E	ID 55 OD 45	1.3120 1.3110	1.3130 1.3120	0.0000	0.0020	1.3080	1.3160	0.0040

1 NEGATIVE VALUES DENOTE INTERFERENCE FIT

ALL DIMENSIONS ARE IN INCHES

Fits and Clearances
Figure 801

FITS AND CLEARANCES



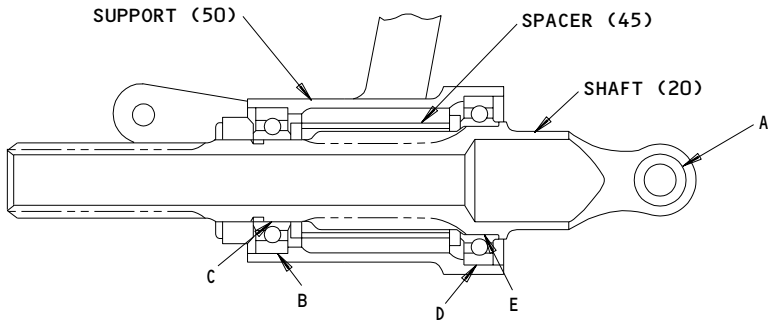
Ref Letter Fig.802	Mating Item No. FIG. NO.2	Design Dimension				Service Wear Limit		
		Dimension		Assembly Clearance 1		Dimension		Maximum Clearance
		Min	Max	Min	Max	Min	Max	
A	ID 55,57	0.5000	0.5006	-0.0015	-0.0004		0.5010	0.0000
	OD 50,52	0.5010	0.5015			0.5006		

1 NEGATIVE VALUES DENOTE INTERFERENCE FIT

ALL DIMENSIONS ARE IN INCHES

Fits and Clearances
Figure 802

FITS AND CLEARANCES



Ref Letter Fig.803	Mating Item No. IPL Fig.3	Design Dimension				Service Wear Limit		
		Dimension		Assembly Clearance 1		Dimension		Maximum Clearance
		Min	Max	Min	Max	Min	Max	
A	ID 20 OD 15B	0.5000 0.5010	0.5006 0.5016	-0.0016	-0.0004	0.5006	0.5010	0.0000
B	ID 50 OD 25	1.7500 1.7490	1.7510 1.7500	0.0000	0.0020	1.7460	1.7530	0.0040
C	ID 25 OD 20	0.9990 0.9990	1.0000 0.995	-0.0005	0.0010	0.9950	1.0035	0.0040
D	ID 50 OD 30	2.0625 2.0615	2.0635 2.0625	0.0000	0.0020	2.0585	2.0665	0.0040
E	ID 30 OD 20	1.3120 1.3110	1.3130 1.3120	0.0000	0.0020	1.3080	1.3160	0.0040

1 NEGATIVE VALUES DENOTE INTERFERENCE FIT

ALL DIMENSIONS ARE IN INCHES

Fits and Clearances
Figure 803

SPECIAL TOOLS, FIXTURES AND EQUIPMENT

NOTE: Equivalent substitutes may be used.

1. Assembly Equipment -- 6MIT65B04002-9

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

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

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

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

72962 ELASTIC STOP NUT A DIV OF HARTFORD INDUSTRIES INC
2330 VAUXHALL ROAD
UNION, NEW JERSEY 07083-5038

73287 HUBBARD, M.D. SPRING CO INC
595 SOUTH LAPEER PO BOX 425
OXFORD, MICHIGAN 48051-8231

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

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

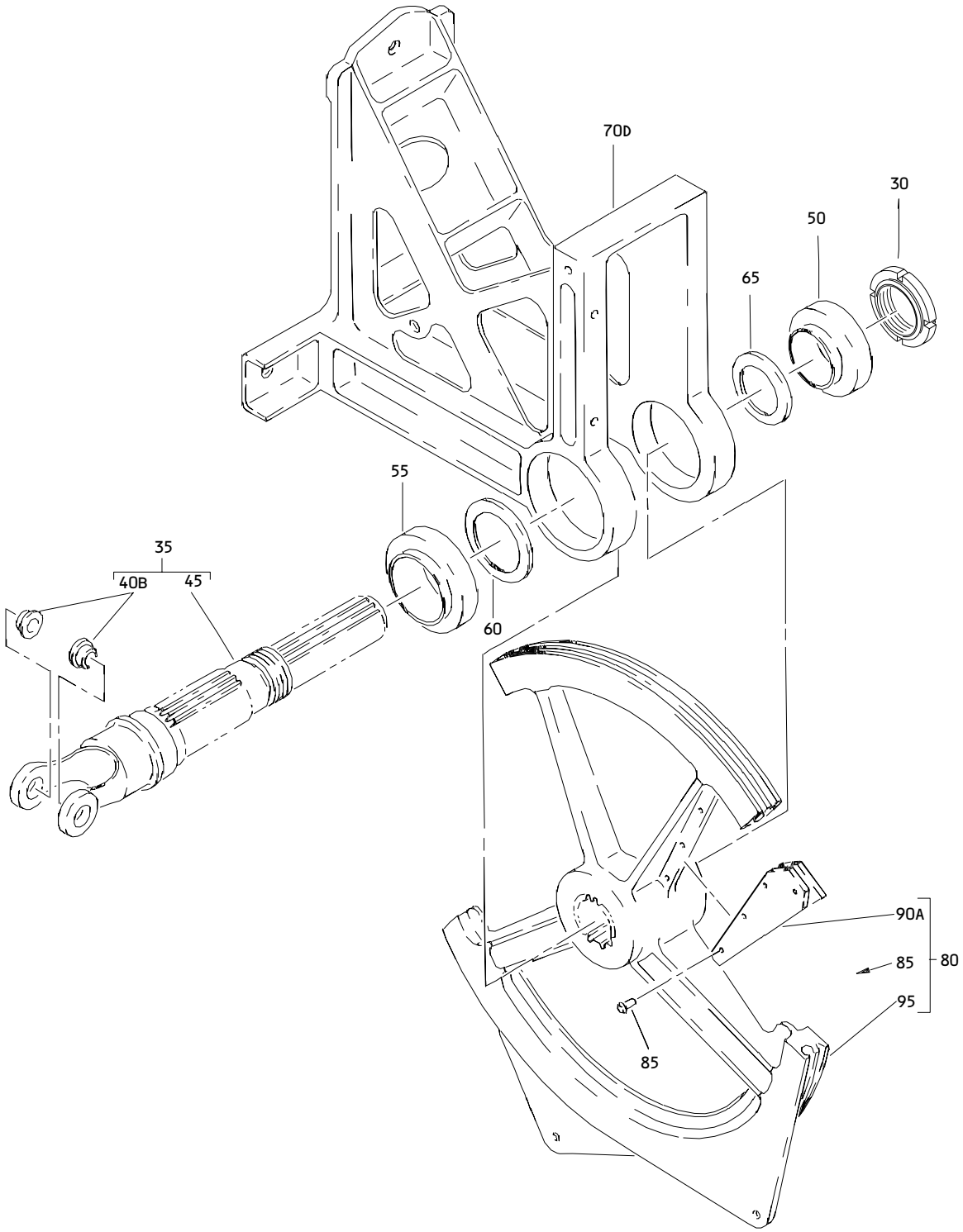
98524 MONOGRAM INDUSTRIES INC AEROSPACE FASTENERS DIV
3423 SOUTH GARFIELD AVENUE PO BOX 6847
LOS ANGELES, CALIFORNIA 90022-0547

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACB10BW16		1	50	1
		3	25	1
BACB10BW21		1	55	1
		3	30	1
BACB28AR06A025A		1	40A	2
		2	50	2
		3	15A	2
		4	15	2
BACB28AY06A025B		2	50A	2
BACB28W4C25		5	5	2
BACB28W6B25		5	10	2
BACB30VL8C200D		2	28A	12
BACN10RF16		1	30	1
		3	5	1
BACR15BB4A		1	85	4
BR9080-16		1	30	1
		3	5	1
HP750A32		2	40	1
		2	100	2
KP16B		1	50	1
		3	25	1
KP16BFS428		1	50	1
		3	25	1
KP16BG27		1	50	1
		3	25	1
KP16BSD610		1	50	1
		3	25	1
KP16B2TS		1	50	1
		3	25	1
KP21B		1	55	1
		3	30	1
KP21BFS428		1	55	1
		3	30	1
KP21BG27		1	55	1
		3	30	1
KP21BLY196		1	55	1
		3	30	1
KP21BSD610		1	55	1
		3	30	1
KP21B2TS		1	55	1
		3	30	1
LLKP16B		1	50	1
		3	25	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
LLKP21B		1	55	1
LLKP21B		3	30	1
MBF2121S8-200		2	28A	12
MS21141U0803		2	28	12
NAS1398MW5-3		2	20	9
		2	70	9
		2	95	18
		4	10	9
		4	25	9
NAS1398MW5-4		2	25	9
		2	75	9
NAS1398MW5A3		4	10A	9
		4	25A	9
SL2822-16		1	30	1
		3	5	1
251T0101-173		2	63A	1
251T0101-174		2	67A	1
256T1102-5		1	95	1
256T1102-6		1	95A	1
256T1106-3		1	35	1
		3	10	1
256T1106-4		1	45	1
		3	20	1
256T1106-5		3	10A	1
256T1106-6		3	20A	1
256T1107-3		2	45	1
		4	5	1
256T1107-4		2	55	1
		4	20	1
256T1109-12		1	70G	1
256T1111-10		1	2C	RF
256T1111-11		1	2D	RF
256T1111-12		1	2E	RF
256T1111-8		1	2A	RF
256T1111-9		1	2B	RF
256T1113-1		3	50	1
256T1113-3		3	50A	1
256T1113-5		3	50C	1
		3	50D	1
256T1113-6		3	50B	1
256T1113-7		3	50E	1
256T1116-1		1	5	RF
		2	1	RF

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
256T1116-10		1	20A	RF
		2	15A	RF
256T1116-11		2	90A	1
256T1116-12		2	110A	1
256T1116-14		1	15B	RF
256T1116-14		2	10B	RF
256T1116-15		1	16	RF
		2	16	RF
256T1116-16		1	16A	RF
		2	16A	RF
256T1116-2		1	10	RF
		2	5	RF
256T1116-5		2	60	1
256T1116-6		2	65	1
256T1121-3		1	60	1
		3	35	1
256T1121-4		1	65	1
		3	40	1
256T1121-501		1	60A	1
256T1121-502		1	65A	1
256T1125-3		2	80	1
256T1128-1		1	25	RF
		3	1	RF
256T1128-2		1	25A	RF
		3	1A	RF
256T1128-3		1	25B	RF
		3	1B	RF
256T1128-4		1	25C	RF
		3	1C	RF
256T1129-1		3	45	1
256T1132-1		1	80	1
256T1132-3		1	90A	1
256T1140-2		2	37B	1
256T1141-2		2	37C	1
256T1143-3		2	43A	1
256T1143-4		2	55B	1
256T2504-4		2	85B	1
256T2601-5		1	28	RF
		5	1	RF
256T2601-6		5	15	1
256T2601-7		1	28A	RF
		5	1A	RF
256T2601-8		5	15A	1
256T2801-1		2	30	1
256T2802-1		2	105	2

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
256T2806-1		2	35	1
256T2855-1		4	30	1
256T2857-1		1	27	RF
		4	1	RF
256T2857-2		4	35	1
82631-1612		1	30	1
		3	5	1



Leading Edge High Lift Control Quadrant Assembly
Figure 1

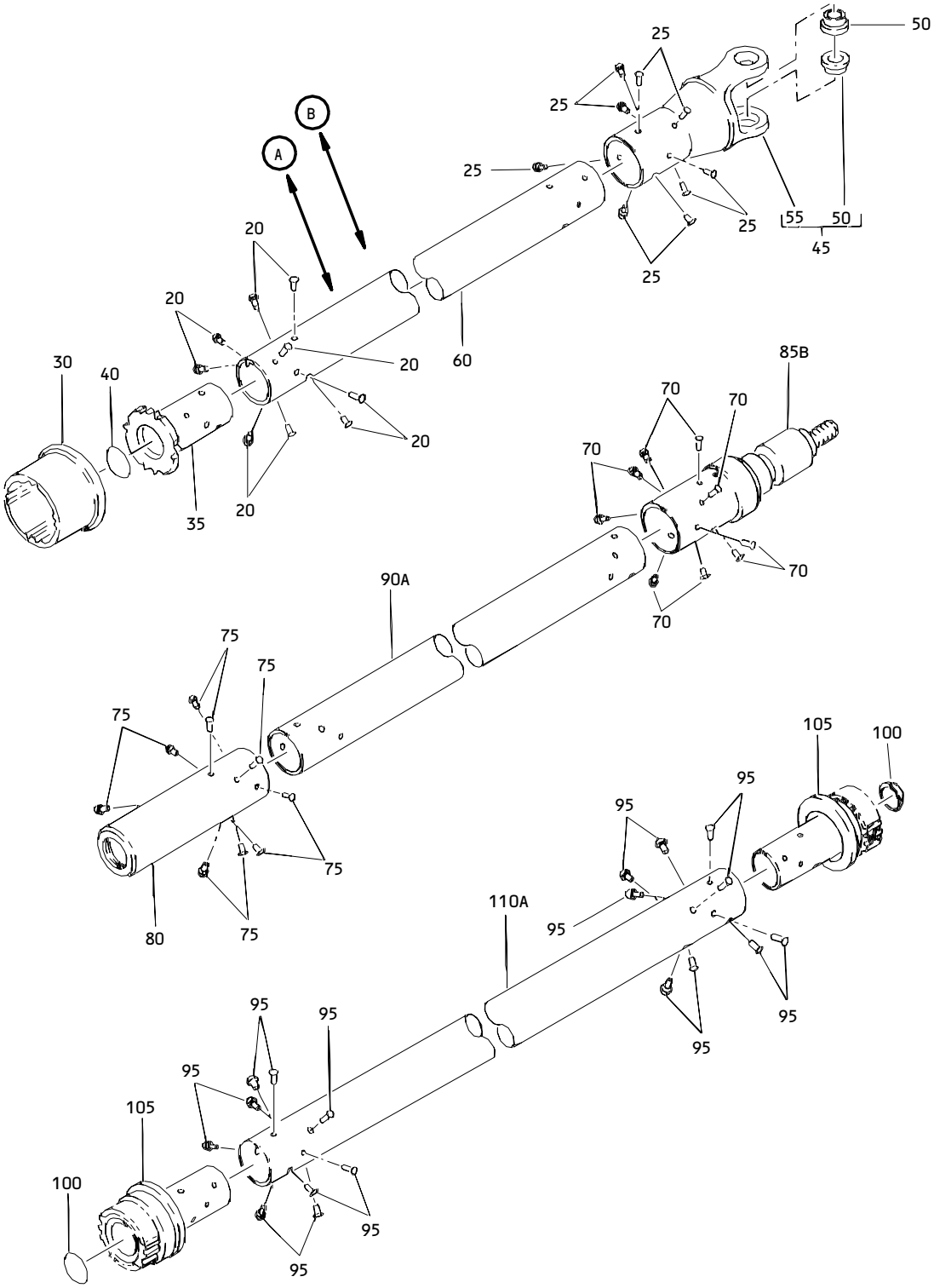
T72795

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	-1	256T1111-1		DELETED		
	-1A	256T1111-2		DELETED		
	-1B	256T1111-3		DELETED		
	-1C	256T1111-6		DELETED LEADING EDGE HIGH LIFT CONTROL INSTALLATION COMPONENTS		
	-2	256T1111-7		DELETED		
R	-2A	256T1111-8		QUADRANT ASSY-LE HIGH LIFT CONT	A	RF
R	-2B	256T1111-9		QUADRANT ASSY-LE HIGH LIFT CONT	K	RF
R	-2C	256T1111-10		QUADRANT ASSY-LE HIGH LIFT CONT	Q	RF
R	-2D	256T1111-11		QUADRANT ASSY-LE HIGH LIFT CONT	R	RF
R	-2E	256T1111-12		QUADRANT ASSY-LE HIGH LIFT CONT	S	RF
	-5	256T1116-1		SHAFT ASSY-LE SLAT CONT (FOR DETAILS SEE FIG. 2)	B	RF
	-10	256T1116-2		SHAFT ASSY-LE SLAT CONT (FOR DETAILS SEE FIG. 2)	C	RF
	-15	256T1116-3		DELETED		
	-15A	256T1116-9		DELETED		
	-15B	256T1116-14		SHAFT ASSY-LE SLAT CONT (FOR DETAILS SEE FIG. 2)	D	RF
R	-16	256T1116-15		SHAFT ASSY-LE SLAT CONT (FOR DETAILS SEE FIG. 2)	M	RF
R	-16A	256T1116-16		SHAFT ASSY-LE SLAT CONT (FOR DETAILS SEE FIG. 2)	N	RF
	-20	256T1116-4		DELETED		
	-20A	256T1116-10		SHAFT ASSY-LE SLAT CONT (FOR DETAILS SEE FIG. 2)	E	RF
R	-25	256T1128-1		SUPPORT ASSY-LE HIGH LIFT CONT UNIV SHAFT (FOR DETAILS SEE FIG.3)	F	RF
R	-25A	256T1128-2		SUPPORT ASSY-LE HIGH LIFT CONT UNIV SHAFT (FOR DETAILS SEE FIG.3)	L	RF

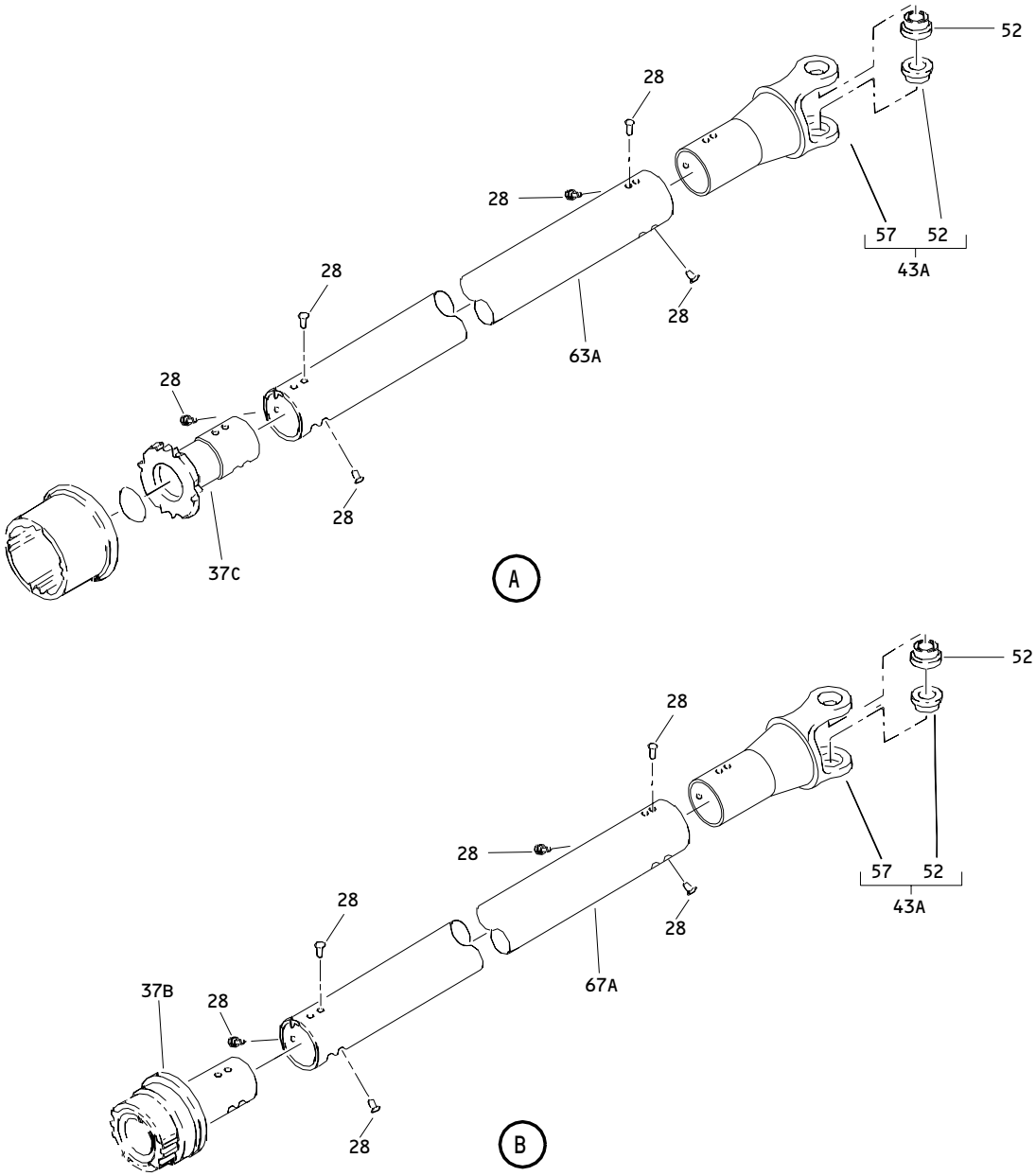
	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
R	-25B	256T1128-3		SUPPORT ASSY-LE HIGH LIFT CONT UNIV SHAFT (FOR DETAILS SEE FIG.3)	P	RF
R	-25C	256T1128-4		SUPPORT ASSY-LE HIGH LIFT CONT UNIV SHAFT (FOR DETAILS SEE FIG.3)	T	RF
	-27	256T2857-1		SHAFT ASSY-LE SLAT DRIVE KRUEGER SEAL FLAP DRIVE (FOR DETAILS SEE FIG. 4)	G	RF
R	-28	256T2601-5		BRACKET ASSY-INBD LE SLAT DRIVE PWR DRIVE UNIT SPRT (FOR DETAILS SEE FIG. 5)	H	RF
R	-28A	256T2601-7		BRACKET ASSY-INBD LE SLAT DRIVE PWR DRIVE UNIT SPRT (FOR DETAILS SEE FIG. 5)	J	RF
	30	SL2822-16		.NUT (V97393) (SPEC BACN10RF16) (OPT BR9080-16 (V72962)) (OPT 82631-1612 (V56878))	A,K, Q-S	1
	35	256T1106-3		.SHAFT ASSY-UNIV	A,K, Q-S	1
	40	BACB28AR06-025A		DELETED		
	40A	BACB28AR06A025A		DELETED		
	40B	BACB28AY06A025C		..BUSHING	A,K, Q-S	2
	45	256T1106-4		..SHAFT	A,K, Q-S	1
	50	KP16B		.BEARING- (V38443) (SPEC BACB10BW16) (OPT KP16B2TS (V43991)) (OPT LLKP16B (V38443)) (OPT KP16BG27 (V30163)) (OPT KP16BFS428 (V21335)) (OPT KP16BSD610 (V83086))	A,K, Q-S	1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	55	KP21B		.BEARING- (V38443) (SPEC BACB10BW21) (OPT KP21B2TS (V43991)) (OPT LLKP21B (V38443)) (OPT KP21BG27 (V30163)) (OPT KP21BFS428 (V21335)) (OPT KP21BLY196 (V40920)) (OPT KP21BSD610 (V83086))	A,K, Q-S	1
	60	256T1121-3		.WASHER- (LIMITED)	A,R,S	1
R	-60A	256T1121-501		.WASHER- (LIMITED)	A,K,Q	1
R	65	256T1121-4		.WASHER- (LIMITED)	A,R,S	1
R	65A	256T1121-502		.WASHER- (LIMITED)	A,K,Q	1
	70	256T1109-3		DELETED		
	70A	256T1109-5		DELETED		
	70B	256T1109-7		DELETED		
	70C	256T1109-8		DELETED		
R	70D	256T1109-9		.BRACKET-SPRT	A,Q,R	1
	-70E	256T1109-10		DELETED		
	-70F	256T1109-11		DELETED		
R	-70G	256T1109-12		.BRACKET-SPRT	K,S	1
	75	256T1102-3		DELETED		
	75A	256T1102-5		DELETED		
R	80	256T1132-1		.QUADRANT ASSY	A,K, Q-S	1
	-80A	256T1134-1		DELETED		
	85	BACR15BB4A		..RIVET- (SIZE DETERMINE ON INST)	A,K, Q-S	4

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-90	256T1132-2		DELETED		
R	90A	256T1132-3		..GUSSET	A,K, Q-S	1
R	95	256T1102-5		..QUADRANT- (OPT 256T1102-6)	A,K, Q-S	1
R	-95A	256T1102-6		..QUADRANT- (OPT 256T1102-5)	A,K, Q-S	1



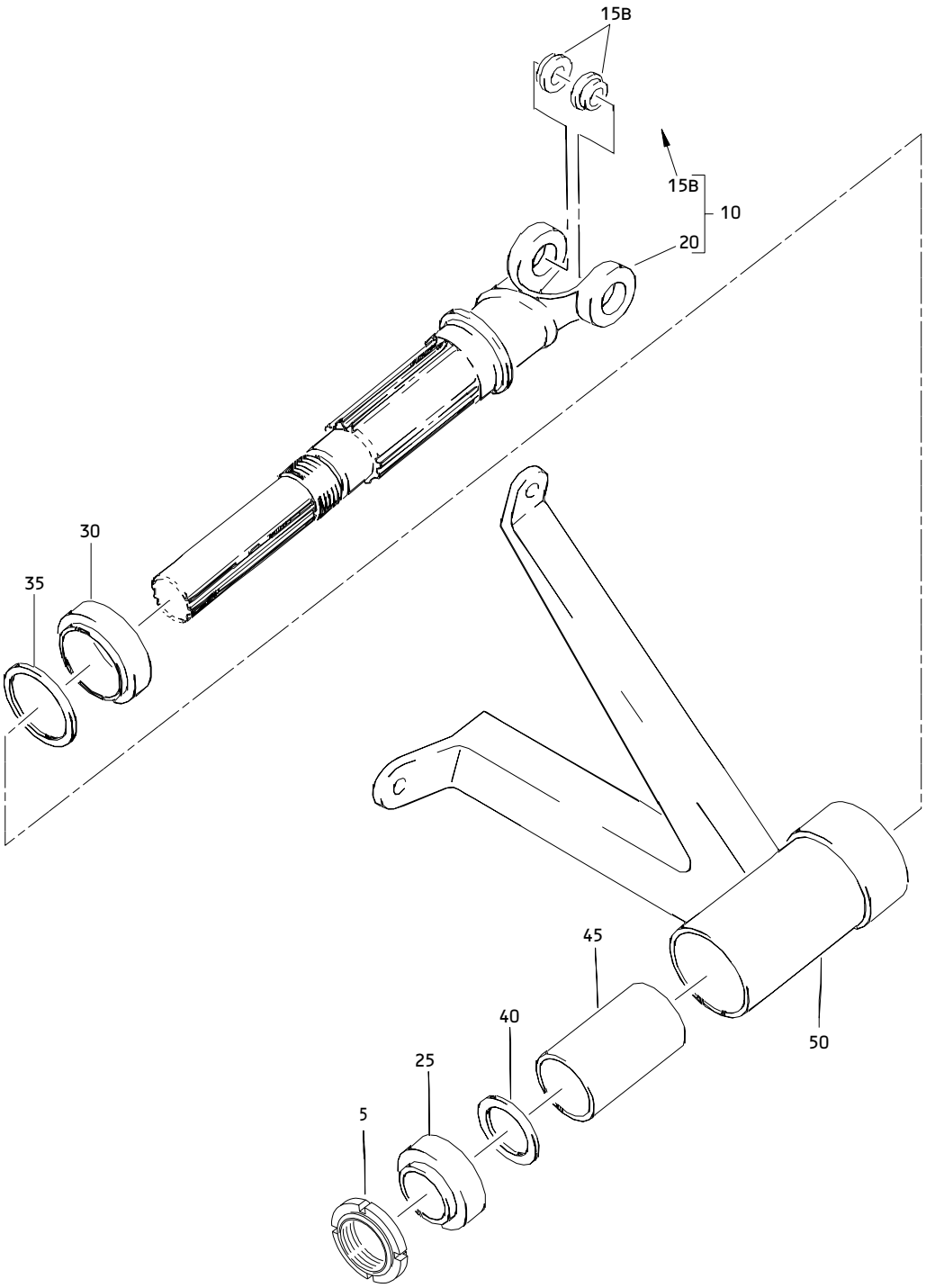
Leading Edge Slat Control Shaft Assembly
Figure 2 (Sheet 1)



Leading Edge Slat Control Shaft Assembly
Figure 2 (Sheet 2)

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	02-					
	-1	256T1116-1		SHAFT ASSY-LE SLAT CONT	B	RF
	-5	256T1116-2		SHAFT ASSY-LE SLAT CONT	C	RF
	-10	256T1116-3		DELETED		
	-10A	256T1116-9		DELETED		
	-10B	256T1116-14		SHAFT ASSY-LE SLAT CONT	D	RF
	-15	256T1116-4		DELETED		
	-15A	256T1116-10		SHAFT ASSY-LE SLAT CONT	E	RF
R	-16	256T1116-15		SHAFT ASSY-LE SLAT CONT	M	RF
R	-16A	256T1116-16		SHAFT ASSY-LE SLAT CONT	N	RF
	20	NAS1398MW5-3		.RIVET	B,C	9
	25	NAS1398MW5-4		.RIVET	B,C	9
R	28	MS21141U0803		.FASTENER- (OPT ITEM 28A)	M,N	12
R	-28A	MBF2121S8-200		.BOLT- (V9M502) (SPEC BACB30VL8C200D) (OPT MBF2121S8-200 (V98524)) (OPT ITEM 28)	M,N	12
	30	256T2801-1		.COUPLING	B,C,M	1
	35	256T2806-1		.FITTING	B,C	1
	37	256T1140-1		DELETED		
	37A	256T1141-1		DELETED		
R	37B	256T1140-2		.FITTING	N	1
R	37C	256T1141-2		.FITTING	M	1
	40	HP750A32		.PLUG-EXPANSION (V73287)	B,C,M ,N	1
	43	256T1143-1		DELETED		
R	43A	256T1143-3		.YOKE ASSY-HIGH LIFT CONT UNIV	M,N	1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	02-					
	45	256T1107-3		.YOKE ASSY-HIGH LIFT CONT UNIV	B,C	1
	50	BACB28AR06A025A		..BUSHING	B,C	2
R	50A	BACB28AY06A025B		DELETED		
R	50B	BACB28AY06A25CG		DELETED		
R	52	BACB28AY06A025B		..BUSHING- (OPT ITEM 52A)	M,N	2
R	-52A	BACB28AY06A25CG		..BUSHING- (OPT ITEM 52)	M,N	2
	55	256T1107-4		..YOKE	B,C	1
	55A	256T1143-2		DELETED		
	55B	256T1143-4		DELETED		
R	57	256T1143-4		..YOKE	M,N	1
	60	256T1116-5		.TUBE	B	1
R	63	256T0101-173		DELETED		
R	63A	251T0101-173		.TUBE	M	1
	-65	256T1116-6		.TUBE	C	1
R	67	256T0101-174		DELETED		
R	67A	251T0101-174		.TUBE	N	1
	70	NAS1398MW5-3		.RIVET	D	9
	75	NAS1398MW5-4		.RIVET	D	9
	80	256T1125-3		.FITTING	D	1
	85	256T2504-2		DELETED		
	85A	256T2504-3		DELETED		
	85B	256T2504-4		.SHAFT	D	1
	90	256T1116-7		DELETED		
	90A	256T1116-11		.TUBE	D	1
	95	NAS1398MW5-3		.RIVET	E	18
	100	HP750A32		.PLUG-EXPANSION (V73287)	E	2
	105	256T2802-1		.FITTING	E	2
	110	256T1116-8		DELETED		
	110A	256T1116-12		.TUBE	E	1

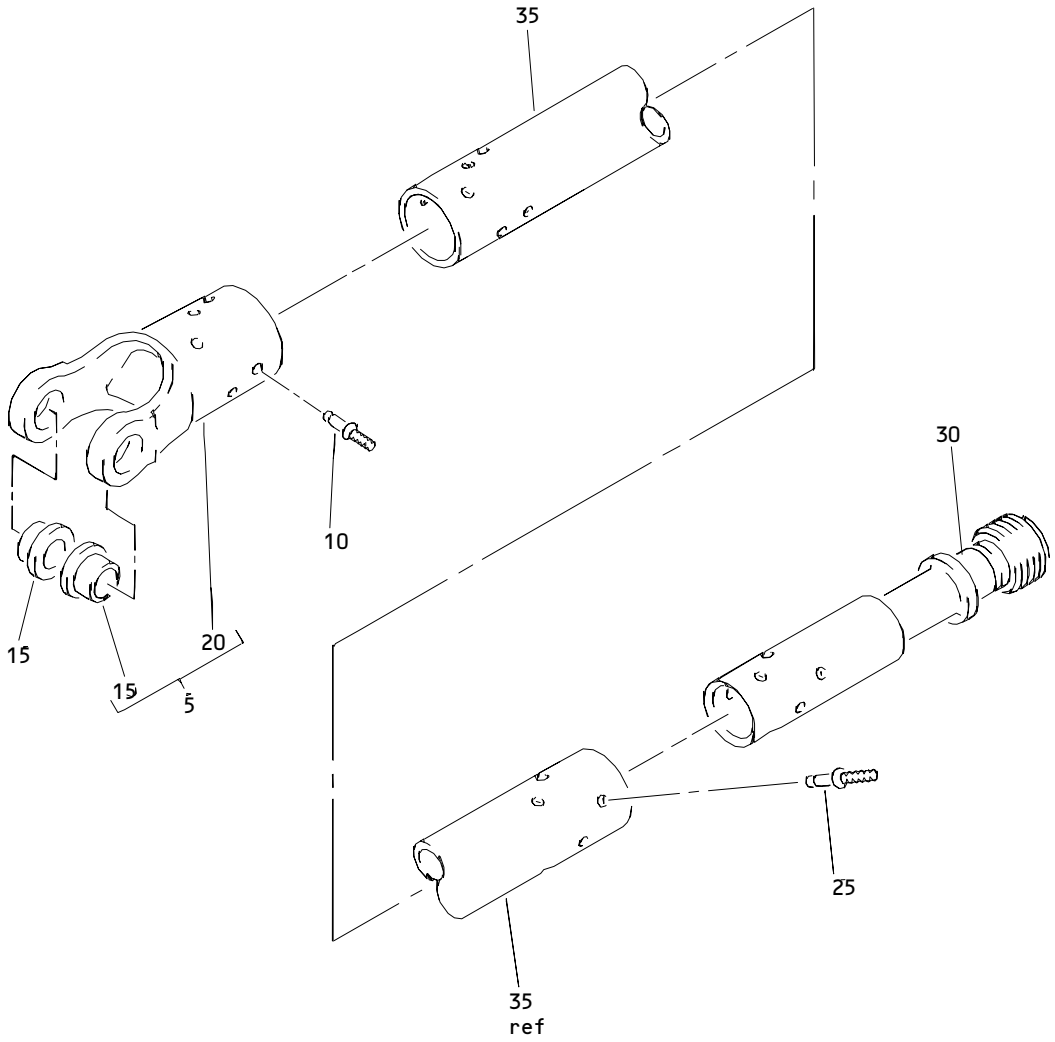


Leading Edge High Lift Control Universal Shaft Support Assembly
Figure 3

T40574

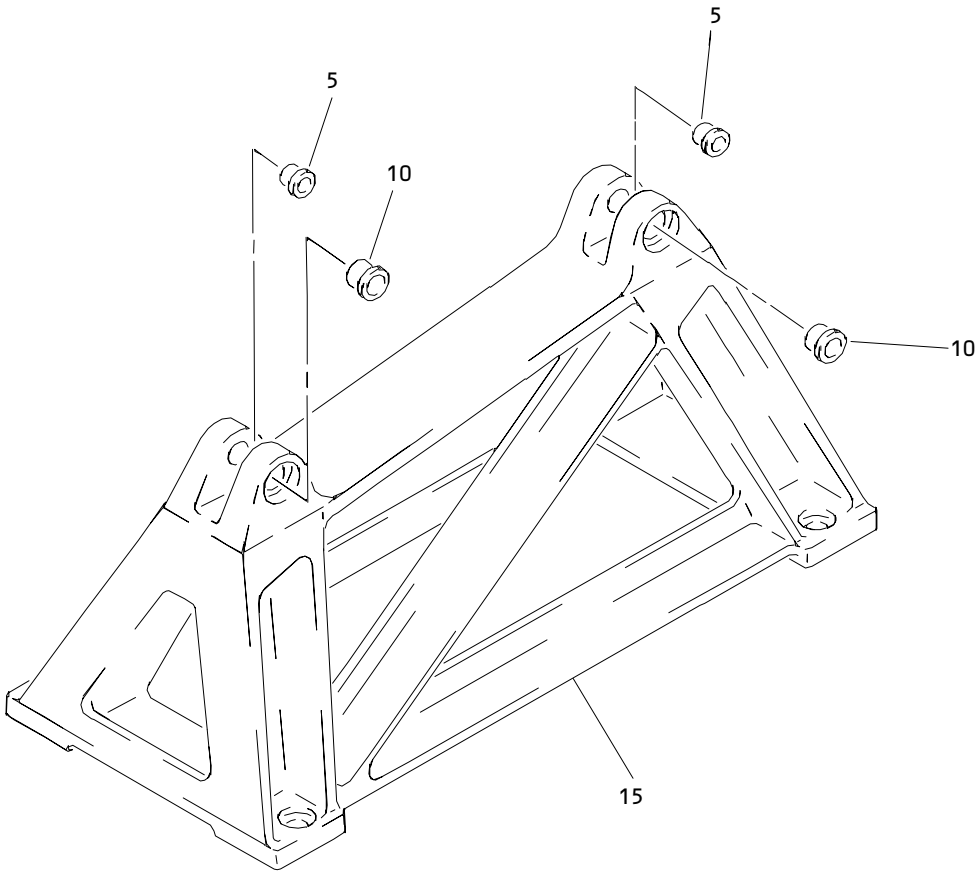
	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	03-					
R	-1	256T1128-1		SUPPORT ASSY-LE HIGH LIFT CONT UNIV SHAFT	F	RF
R	-1A	256T1128-2		SUPPORT ASSY-LE HIGH LIFT CONT UNIV SHAFT	L	RF
R	-1B	256T1128-3		SUPPORT ASSY-LE HIGH LIFT CONT UNIV SHAFT	P	RF
R	-1C	256T1128-4		SUPPORT ASSY-LE HIGH LIFT CONT UNIV SHAFT	T	RF
R	5	SL2822-16		.NUT- (V97393) (SPEC BACN10RF16) (OPT BR9080-16 (V72962)) (OPT 82631-1612 (V56878))	F,L,P,T	1
R	10	256T1106-3		.SHAFT ASSY-UNIV (OPT ITEM 10A)	F,P	1
R	-10A	256T1106-5		.SHAFT ASSY-UNIV (OPT ITEM 10)	F,P	1
R	-10B	256T1106-5		.SHAFT ASSY-UNIV	L,T	1
	15	BACB28AR06-025A		DELETED		
	15A	BACB28AR06A025A		DELETED		
R	15B	BACB28AY06A025C		..BUSHING	F,L,P,T	2
	20	256T1106-4		..SHAFT- (USED ON ITEM 10)	F,P	1
R	-20A	256T1106-6		..SHAFT- (USED ON ITEMS 10A, 10B)	F,L,P,T	1
R	25	KP16B		.BEARING- (V38443) (SPEC BACB10BW16) (OPT KP16B2TS (V43991)) (OPT LLKP16B (V38443)) (OPT KP16BG27 (V30163)) (OPT KP16BFS428 (V21335)) (OPT KP16BSD610 (V83086))	F,L,P,T	1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	03-					
R	30	KP21B		.BEARING- (V38443) (SPEC BACB10BW21) (OPT KP21B2TS (V43991)) (OPT LLKP21B (V38443)) (OPT KP21BG27 (V30163)) (OPT KP21BFS428 (V21335)) (OPT KP21BLY196 (V40920)) (OPT KP21BSD610 (V83086))	F,L,P,T	1
R	35	256T1121-3		.WASHER	F,L,P,T	1
R	40	256T1121-4		.WASHER	F,L,P,T	1
R	45	256T1129-1		.SPACER-BRG	F,L,P,T	1
R	50	256T1113-1		.SUPPORT-DBL BRG (OPT ITEMS 50A, 50C)	F	1
R	-50A	256T1113-3		.SUPPORT-DBL BRG (OPT ITEMS 50, 50C)	F	1
R	-50B	256T1113-6		.SUPPORT-DBL BRG	L	1
R	-50C	256T1113-5		.SUPPORT-DBL BRG (OPT ITEMS 50, 50A)	F	1
R	-50D	256T1113-5		.SUPPORT-DBL BRG	P	1
R	-50E	256T1113-7		.SUPPORT-DBL BRG	T	1



Leading Edge Slat Drive Krueger Seal Flap Drive Shaft Assembly
Figure 4

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	04-					
	-1	256T2857-1		SHAFT ASSY-LE SLAT DRIVE KRUEGER SEAL FLAP DRIVE	G	RF
	5	256T1107-3		.YOKE ASSY-HIGH LIFT CONT UNIV	G	1
	10	NAS1398MW5-3		.RIVET- (OPT ITEM 10A)	G	9
R	-10A	NAS1398MW5A3		.RIVET- (OPT ITEM 10)	G	9
				-------*-------		
	15	BACB28AR06A025A		..BUSHING	G	2
	20	256T1107-4		..YOKE	G	1
	25	NAS1398MW5-3		.RIVET- (OPT ITEM 25A)	G	9
R	-25A	NAS1398MW5A3		.RIVET- (OPT ITEM 25)	G	9
	30	256T2855-1		.FITTING	G	1
	35	256T2857-2		.TUBE-TORQUE	G	1



Inboard Leading Edge Slat Drive Power Drive Unit Support Bracket Assembly
Figure 5

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	05-					
R	-1	256T2601-5		BRACKET ASSY-INBD LE SLAT DRIVE PWR DRIVE UNIT SPRT	H	RF
R	-1A	256T2601-7		BRACKET ASSY-INBD LE SLAT DRIVE PWR DRIVE UNIT SPRT	J	RF
R	5	BACB28W4C25		.BUSHING	H,J	2
R	10	BACB28W6B25		.BUSHING	H,J	2
R	15	256T2601-6		.BRACKET	H	1
R	-15A	256T2601-8		.BRACKET	J	1