

 **BOEING**  
COMPONENT  
MAINTENANCE MANUAL

TO: ALL HOLDERS OF RIB BRACE STRUT ASSEMBLIES COMPONENT MAINTENANCE MANUAL  
27-81-36

REVISION NO. 2 DATED OCT 10/85

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.

NOTE: Page 603 of Repair 2-1 presents duplicate information. Pages 603 and 604 of Repair 2-1 should therefore be removed and destroyed.

CHAPTER/SECTION

AND PAGE NO.

DESCRIPTION OF CHANGE

DESCRIPTION & OPERATION      Incorporated minor non-technical editorial changes.

1

REPAIR 4-1

601

1005,1009,1011,1013

REPAIR 2-1    11,1013

Revised datum reference.

602

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HIGHLIGHTS

01.1

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## RIB BRACE STRUT ASSEMBLIES

PART NUMBER 114T0135-1  
114T0136-3  
114T0137-1  
114T0138-1

COMPONENT MAINTENANCE MANUAL  
WITH  
ILLUSTRATED PARTS LIST

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TITLE PAGE  
Page 1  
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01.1

114T0135  
114T0136  
114T0137  
114T0138



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

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REVISION RECORD

01.1

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143964

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TEMPORARY REVISION AND SERVICE BULLETIN RECORD

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

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TR & SB RECORD

01.1

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 **BOEING**  
 COMPONENT  
 MAINTENANCE MANUAL

PAGE	DATE	CODE	PAGE	DATE	CODE
27-81-36			REPAIR 2-1		
			601	JAN 10/85	01.1
			*602	OCT 10/85	01.1
TITLE PAGE			REPAIR 3-1		
1	JAN 10/85	01.1	601	JAN 10/85	01.1
2	BLANK		602	JAN 10/85	01.1
REVISION RECORD			REPAIR 4-1		
1	JAN 10/85	01.1	*601	OCT 10/85	01.1
2	BLANK		602	JAN 10/85	01.1
TR & SB RECORD			ILLUSTRATED PARTS LIST		
1	JAN 10/85	01.1	1001	JAN 10/85	01.1
2	BLANK		1002	JAN 10/85	01.1
LIST OF EFFECTIVE PAGES			1003	BLANK	
*1	OCT 10/85	01	1004	JAN 10/85	01.1
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1	JAN 10/85	01.1	1010	JAN 10/85	01.1
2	BLANK		*1011	OCT 10/85	01.1
DESCRIPTION & OPERATION			1012	JAN 10/85	01.1
*1	OCT 10/85	01.1	*1013	OCT 10/85	01.1
2	BLANK		1014	BLANK	
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501	JAN 10/85	01.1			
502	BLANK				
REPAIR-GENERAL					
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\* = REVISED, ADDED OR DELETED

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

## 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 &<br>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.

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INTRODUCTION

01.1

Page 1

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RIB BRACE STRUT ASSEMBLIES

DESCRIPTION AND OPERATION

1. Description and Operation

- A. The rib brace strut assemblies consist of machined aluminum struts with bushings.
- B. The rib brace main, lower, and mid struts form a truss, which supports the leading edge auxiliary track at ISS 263.36.
- C. The rib brace ISS 190.537 strut supports the leading edge auxiliary track at ISS 190.537.

2. Leading Particulars of 114T0135-1 (Approximate)

Length -- 21 inches  
Diameter -- 1 inch  
Weight -- TBP

3. Leading Particulars of 114T0136-3 (Approximate)

Length -- 11 inches  
Diameter -- 1 inch  
Weight -- TBP

4. Leading Particulars of 114T0137-1 (Approximate)

Length -- 6 inches  
Width -- 4 inches  
Height -- 1 inch  
Weight -- TBP

5. Leading Particulars of 114T0138-1 (Approximate)

Length -- 35 inches  
Diameter -- 1 inch  
Weight -- TBP



114T0135  
114T0136  
114T0137  
114T0138



CHECK

1. Check all parts for obvious defects in accordance with standard industry practices.
2. Penetrant check the following parts per 20-20-02.
  - A. Strut (45, IPL Fig. 1)
  - B. Strut (25, IPL Fig. 2)
  - C. Strut (20, IPL Fig. 3)
  - | D. Strut (25, IPL Fig. 4)

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CHECK

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REPAIR – GENERAL

1. Content

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

<u>P/N</u>	<u>NAME</u>	<u>REPAIR</u>
114T0135	STRUT, RIB BRACE MAIN	1-1
114T0136	STRUT, RIB BRACE MID	2-1
114T0137	STRUT, RIB BRACE LWR	3-1
114T0138	STRUT, RIB BRACE ISS 190.537	4-1

2. Standard Practices

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

20-30-02 Stripping of Protective Finishes  
20-30-03 General Cleaning Procedures  
20-41-01 Decoding Table for Boeing Finish Codes  
20-41-02 Application of Chemical and Solvent Resistant Finishes  
20-43-01 Chromic Acid Anodizing  
20-50-03 Bearing Installation and Retention

3. Materials

NOTE: Equivalent substitutes may be used.

- A. Sealant -- BMS 5-95 (Ref 20-60-04)  
B. Primer -- BMS 10-11, Type 1 (Ref 20-60-02)

4. Dimensioning Symbols

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

—	STRAIGHTNESS	$\oplus$	THEORETICAL EXACT POSITION OF A FEATURE (TRUE POSITION)
$\square$	FLATNESS	$\varnothing$	DIAMETER
$\perp$	PERPENDICULARITY (OR SQUARENESS)	BASIC (BSC) OR	A THEORETICALLY EXACT DIMENSION USED TO DESCRIBE SIZE, SHAPE OR LOCATION OF A FEATURE FROM WHICH PERMISSIBLE VARIATIONS ARE ESTABLISHED BY TOLERANCES ON OTHER DIMENSIONS OR NOTES.
//	PARALLELISM	<b>DIM</b>	
$\bigcirc$	ROUNDNESS	<b>-A-</b>	DATUM
$\bigcirc$	CYLINDRICITY	$\textcircled{M}$	MAXIMUM MATERIAL CONDITION (MMC)
$\frown$	PROFILE OF A LINE	$\textcircled{S}$	REGARDLESS OF FEATURE SIZE (RFS)
$\triangle$	PROFILE OF A SURFACE	$\textcircled{P}$	PROJECTED TOLERANCE ZONE
$\odot$	CONCENTRICITY		
$\equiv$	SYMMETRY		
$\sphericalangle$	ANGULARITY		
$\nearrow$	RUNOUT		

EXAMPLES

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

True Position Dimensioning Symbols  
 Figure 601

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REPAIR-GENERAL

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114T0138



RIB BRACE MAIN STRUT ASSEMBLY - REPAIR 1-1

114T0135-1

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. Bushing Replacement (IPL Fig. 1)
  - A. Remove bushings (25 thru 40).
  - B. Install bushings (25 thru 40) per 20-50-03 except use wet BMS 5-95 sealant. Machine bores to dimensions and finish shown (Fig. 601).
  - C. Fillet seal flanges of bushings using BMS 5-95 sealant.

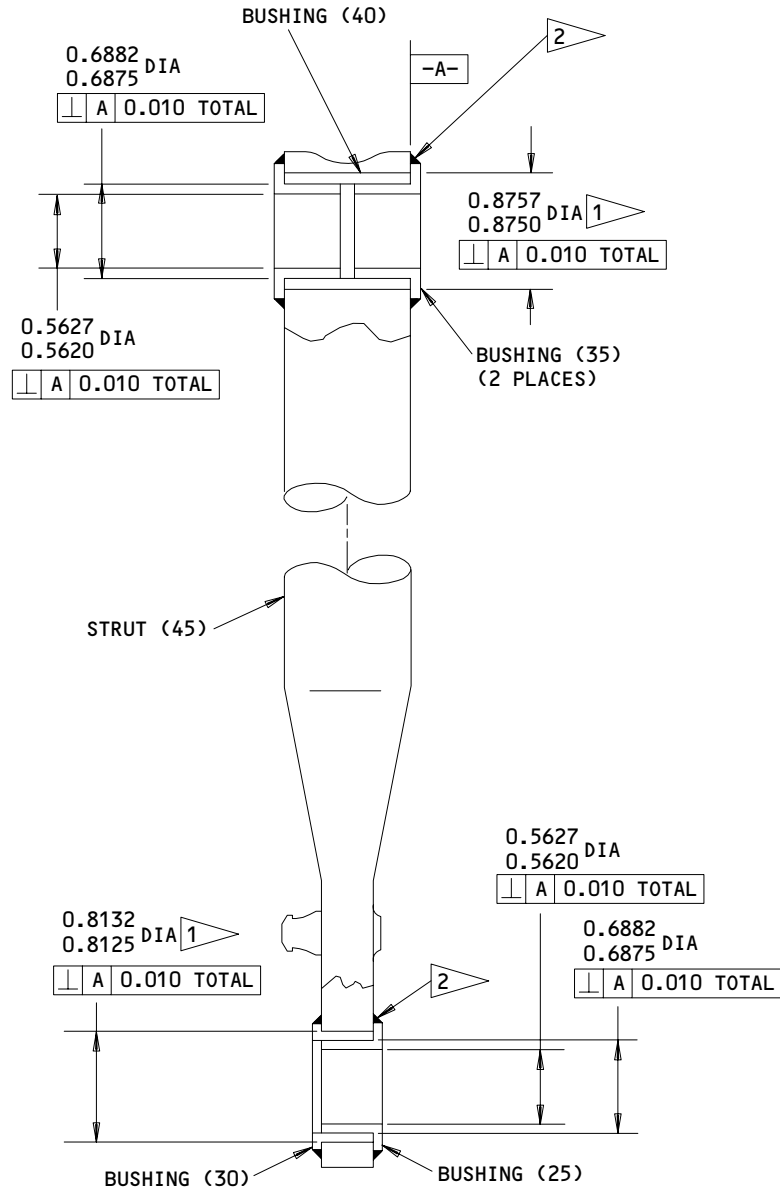
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REPAIR 1-1

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**REFINISH**

STRUT (45) -- CHEMICAL TREAT INTERIOR & EXTERIOR SURFACES AND APPLY ONE COAT BMS 10-11 TYPE 1 PRIMER (F-18.07) EXCEPT AS NOTED

125/ ALL MACHINED SURFACES

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

ITEM NUMBERS REFER TO IPL FIG. 1

1 NO PRIMER THIS SURFACE

2 FILLET SEAL WITH BMS 5-95

114T0135-1

Main Strut Assembly Repair  
 Figure 601

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RIB BRACE MID STRUT ASSEMBLY – REPAIR 2-1

114T0136-3

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

1. Bushing Replacement (IPL Fig. 2)

- A. Remove bushings (5 thru 20).
- B. Install bushings (5 thru 20) per 20-50-03 except use wet BMS 5-95 sealant. Machine bores and finish to dimensions shown (Fig. 601).
- C. Fillet seal flanges of bushings using BMS 5-95 sealant.

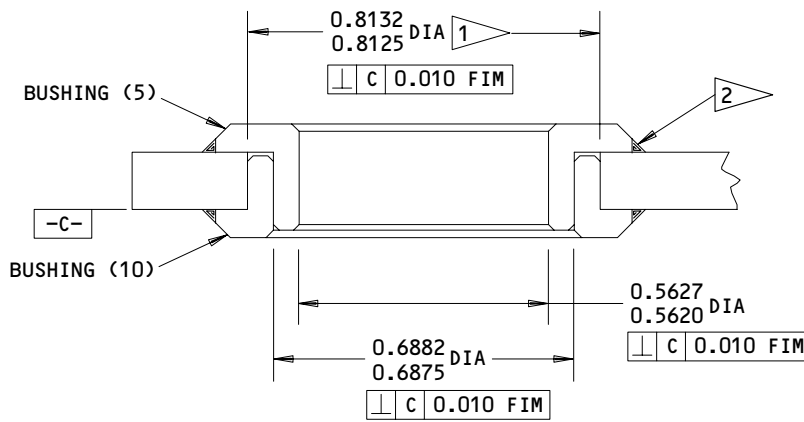
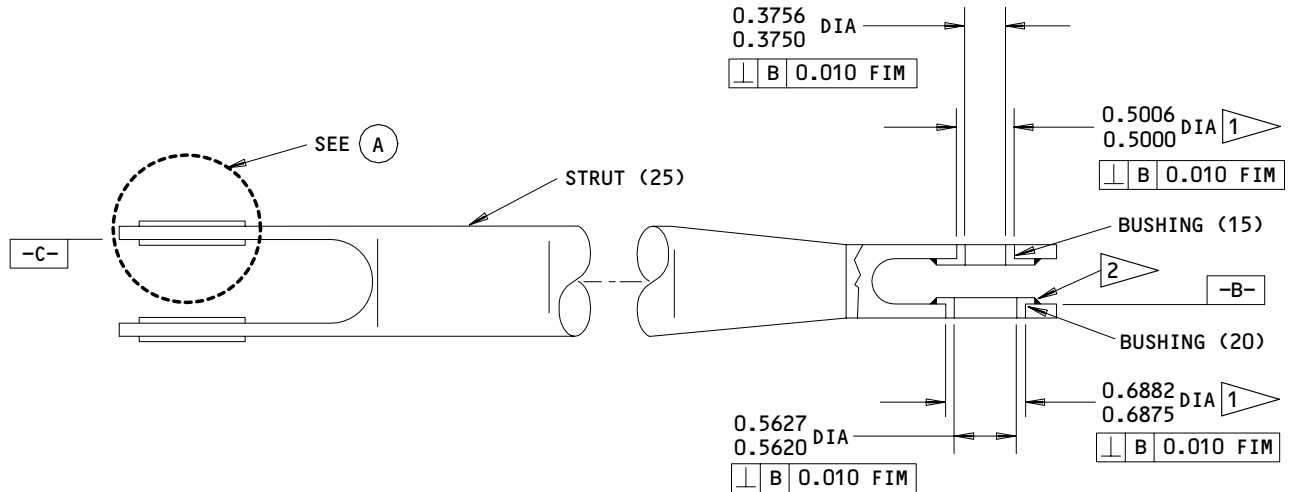
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REPAIR 2-1

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(TYPICAL)

(A)

**REFINISH**

STRUT (25) -- CHEMICAL TREAT INTERIOR & EXTERIOR SURFACES AND APPLY ONE COAT BMS 10-11 TYPE 1 PRIMER (F-18.07) EXCEPT AS NOTED

1 NO PRIMER THIS SURFACE

2 FILLET SEAL WITH BMS 5-95

125/ ALL MACHINED SURFACES

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

ITEM NUMBERS REFER TO IPL FIG. 2

114T0136-3

Mid Strut Assembly Repair  
 Figure 601

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114T0138



RIB BRACE LOWER STRUT ASSEMBLY – REPAIR 3-1

114T0137-1

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. Bushing Replacement (IPL Fig. 3)

- A. Remove bushings (5 thru 15).
- B. Install bushings (5 thru 15) per 20-50-03 except use wet BMS 5-95 sealant. Machine bores and finish to dimensions shown (Fig. 601).
- C. Fillet seal flanges of bushings using BMS 5-95 sealant.

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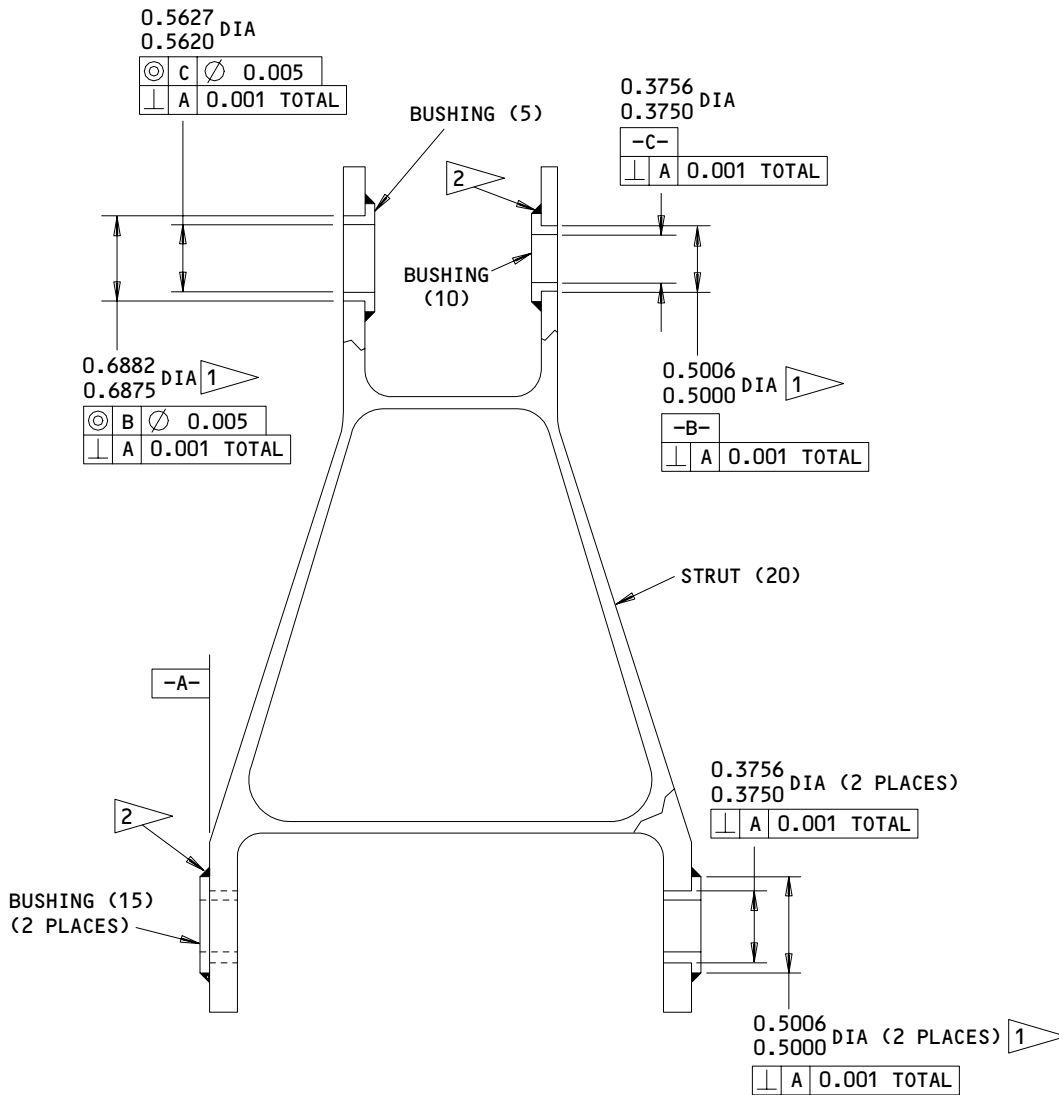
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**REFINISH**

STRUT (20) -- CHROMIC ACID ANODIZE AND APPLY ONE COAT BMS 10-11 TYPE 1 PRIMER (F-18.13) EXCEPT AS NOTED

125/ ALL MACHINED SURFACES

MATERIAL: AL ALLOY

1 NO PRIMER THIS SURFACE

ALL DIMENSIONS ARE IN INCHES

2 FILLET SEAL WITH BMS 5-95

ITEM NUMBERS REFER TO IPL FIG. 3

114T0137-1

Lower Strut Assembly Repair  
 Figure 601

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REPAIR 3-1

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114T0137  
114T0138



RIB BRACE STRUT ASSEMBLY - REPAIR 4-1

114T0138-1

**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. Bushing Replacement (IPL Fig. 4)
  - A. Remove bushings (5 thru 20).
  - B. Install new bushings per 20-50-03. Machine bores to dimensions and finish shown (Fig. 601).
  - C. Fillet seal flanges of bushings using BMS 5-95 sealant.

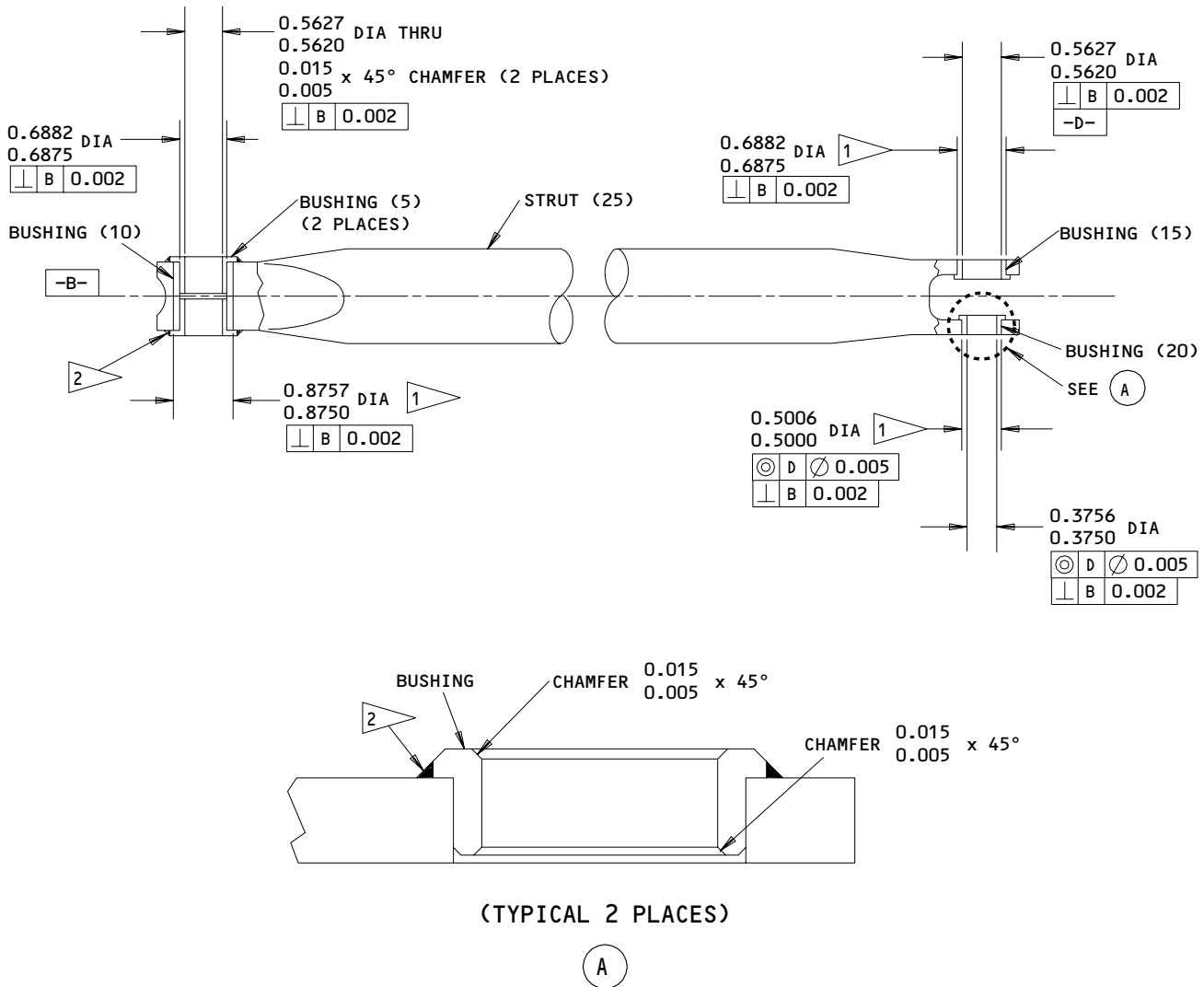
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**REFINISH**

STRUT (25) -- CHROMIC ACID ANODIZE AND APPLY ONE COAT BMS 10-11 TYPE 1 PRIMER (F-18.13) EXCEPT AS NOTED

- 1 NO PRIMER THIS SURFACE
- 2 FILLET SEAL WITH BMS 5-95

125/ ALL MACHINED SURFACES

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

ITEM NUMBERS REFER TO IPL FIG. 4

Strut Assembly Repair  
 Figure 601

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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.

VENDORS

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

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

56878 SPS TECHNOLOGIES INC  
HIGHLAND AVENUE  
JENKINTOWN, PENNSYLVANIA 19046

70265 ALL POWER MANUFACTURING COMPANY  
13141 MOLETTE STREET  
SANTE FE SPRINGS, CALIFORNIA 90670

73197 HI-SHEAR CORPORATION  
2600 SKYPARK DRIVE  
TORRANCE, CALIFORNIA 90509

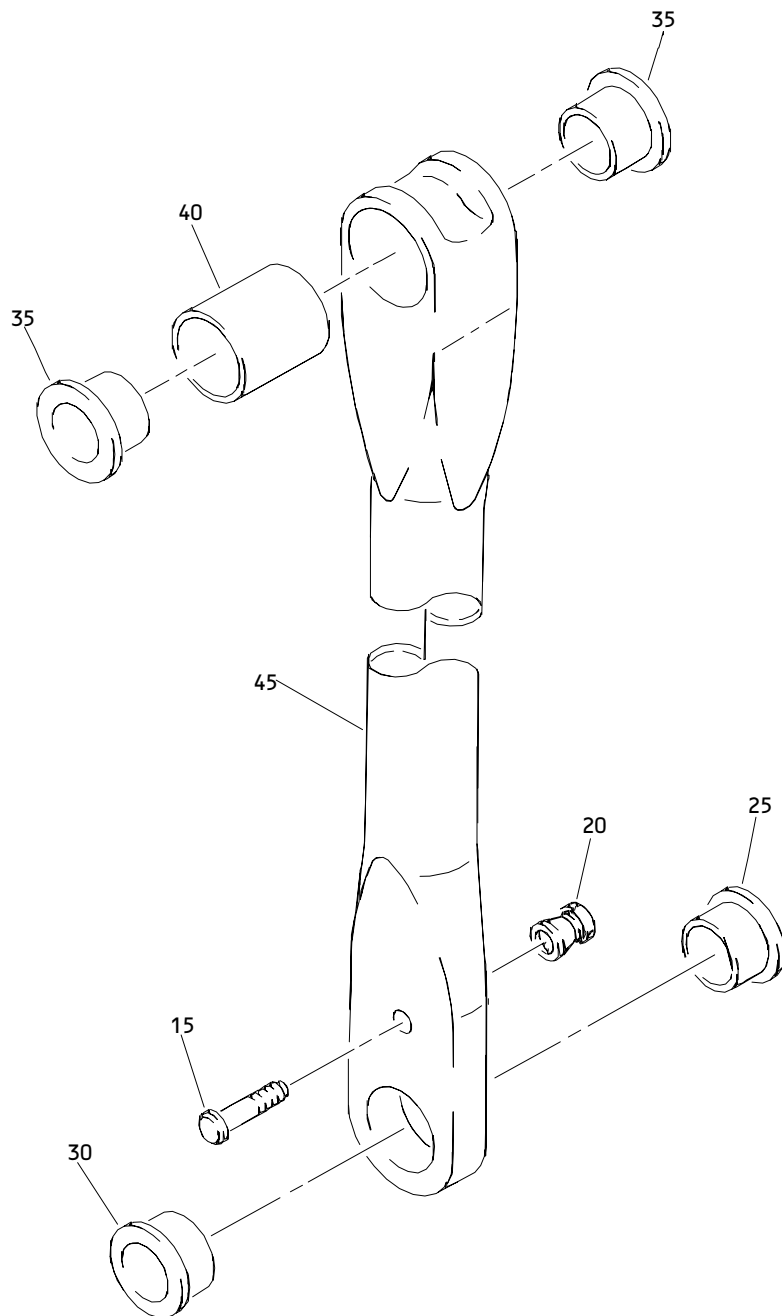
92215 VOI-SHAN DIV OF VSI CORP SUB OF FAIRCHILD INDUSTRIAL INC  
8463 HIGUERA STREET  
CULVER CITY, CALIFORNIA 90230

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

97928 LITTON FASTENING SYSTEMS DIV OF LITTON SYSTEMS INC  
3969 PARAMONT BOULEVARD  
LAKEWOOD, CALIFORNIA 90712

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Rib Brace Main Strut Assembly  
Figure 1

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 114T0138

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-1	114T0135-1		STRUT ASSY-RIB BRACE MAIN	A	RF
-5	114T0136-3		STRUT ASSY-RIB BRACE MID (FOR DETAILS SEE FIG. 2)	B	RF
-10	114T0137-1		STRUT ASSY-RIB BRACE LWR (FOR DETAILS SEE FIG. 3)	C	RF
-12	114T0138-1		STRUT ASSY-RIB BRACE ISS 190.537 (FOR DETAILS SEE FIG. 4)	D	RF
15	HL12VAZ6-7		.BOLT- (V56878) (SPEC BACB30NX6K7) (OPT HL12VAZ6-7 (V73197)) (OPT HL12VAZ6-7 (V92215)) (OPT HL12VAZ6-7 (V97928)) (OPT L802-6K7 (V06725))	A	1
20	HL1187-6		.COLLAR- (V73197) (SPEC BACC30X6) (OPT HL87-6 (V73197)) (OPT HL87-6 (V92215)) (OPT HL1187-6 (V56878)) (OPT HL1187-6 (V92215)) (OPT HL87-6 (V56878))	A	1

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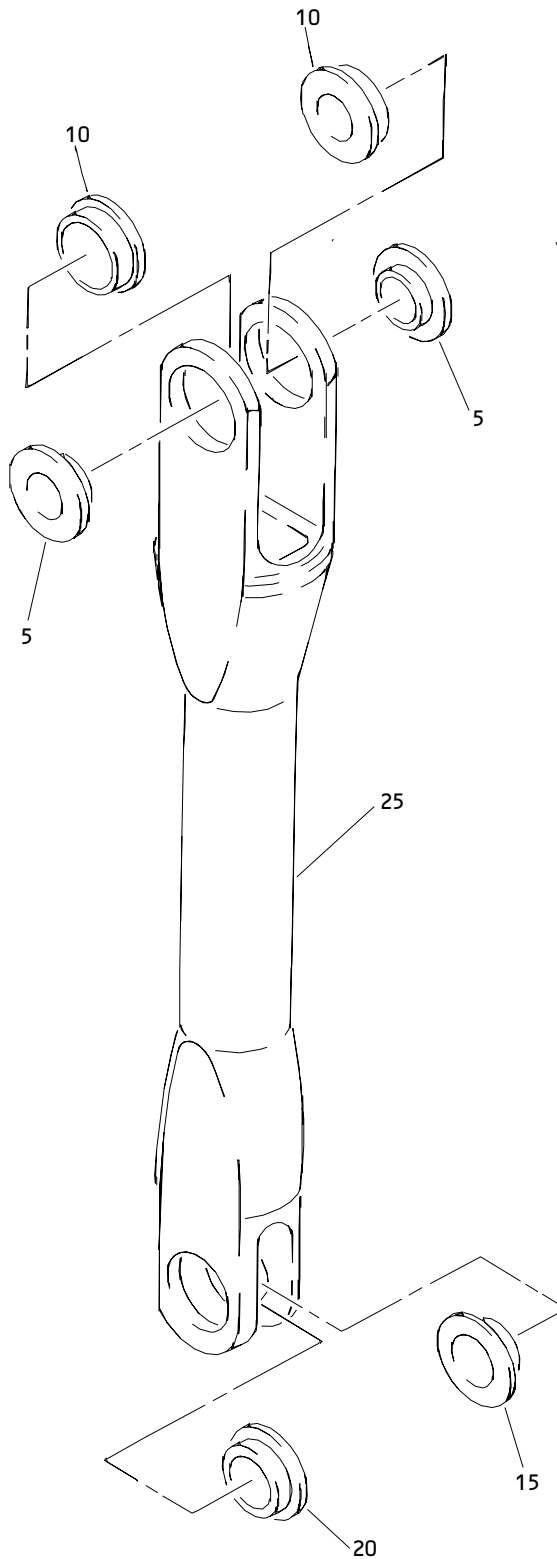
ILLUSTRATED PARTS LIST  
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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE	EFF CODE	QTY PER ASSY
			1234567		
01- 25 30 35 40	012T2400-1 012T2400-2 012T2400-22 BACB28U11C099		.BUSHING .BUSHING .BUSHING .BUSHING- (V23294) (SPEC BACB28U11C099) (V70265) (V94892)	A A A A	1 1 2 1
45	114T0135-2		.STRUT	A	1

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Rib Brace Middle Strut Assembly  
Figure 2

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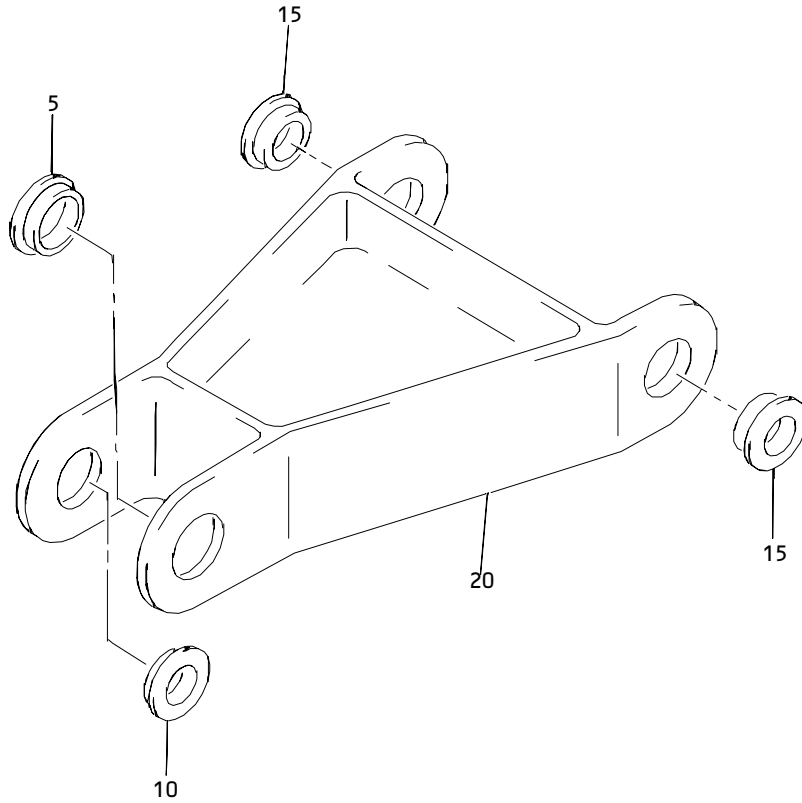
114T0135  
 114T0136  
 114T0137  
 114T0138

 **BOEING**  
 COMPONENT  
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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE	EFF CODE	QTY PER ASSY
			1234567		
02-					
-1	114T0136-3		STRUT ASSY-RIB BRACE MID		RF
5	012T2400-6		.BUSHING		2
10	012T2400-7		.BUSHING		2
15	012T2400-9		.BUSHING		1
20	012T2400-10		.BUSHING		1
25	114T0136-4		.STRUT		1

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Rib Brace Lower Strut Assembly  
Figure 3

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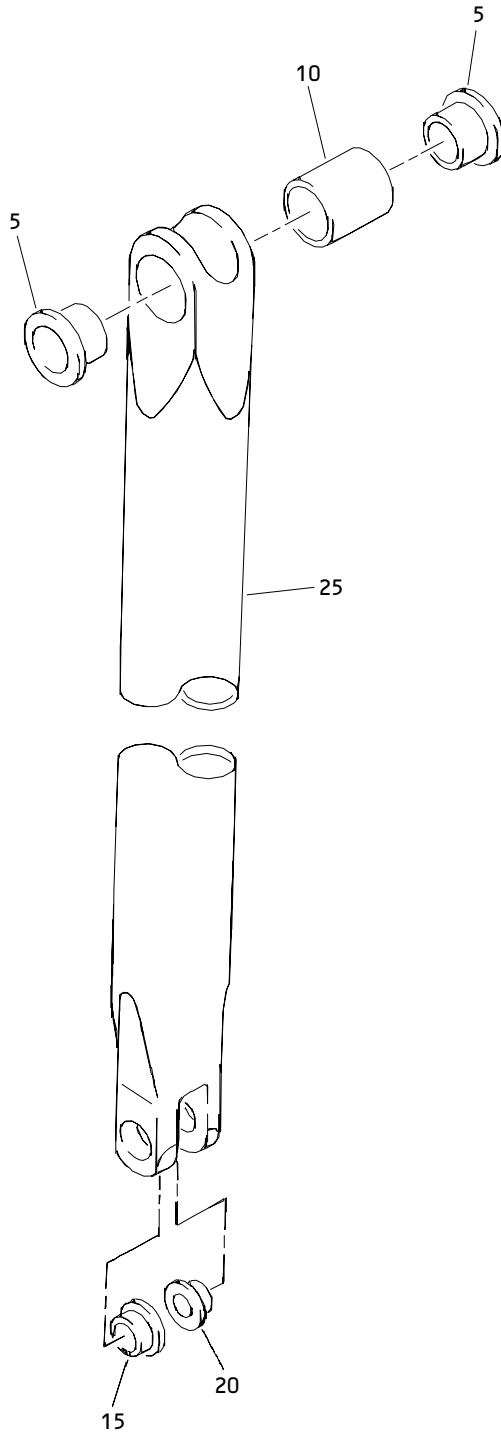
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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
03- -1 5	114T0137-1 BACB28AM09B014A		STRUT ASSY-RIB BRACE LWR .BUSHING- (V23294) (SPEC BACB28AM09B014A) (V70265) (V94892)		RF 1
10	BACB28AA6C014		.BUSHING- (V23294) (SPEC BACB28AA6C014) (V70265) (V94892)		1
15	BACB28AP06P020		.BUSHING- (V23294) (SPEC BACB28AP06P020) (V70265) (V94892)		2
20	114T0137-2		.STRUT		1

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ISS 190.537 Rib Brace Strut Assembly  
Figure 4

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114T0135  
 114T0136  
 114T0137  
 114T0138

 **BOEING**  
 COMPONENT  
 MAINTENANCE MANUAL

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
04- -1	114T0138-1		STRUT ASSY-RIB BRACE ISS 190.537		RF
5	012T2400-22		.BUSHING		2
10	BACB28U11C099		.BUSHING- (V23294) (SPEC BACB28U11C099) (V70265) (V94892)		1
15	BACB28AM09B018A		.BUSHING- (V23294) (SPEC BACB28AM09B018A) (V70265) (V94892)		1
20	BACB28AP06P018		.BUSHING- (V23294) (SPEC BACB28AP06P018) (V70265) (V94892)		1
25	114T0138-2		.STRUT		1

**27-81-36**

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