TO: ALL HOLDERS OF AUXILIARY TRACK FITTING ASSEMBLY COMPONENT MAINTENANCE MANUAL 27-81-37

REVISION NO. 1 DATED JAN 01/89

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
DESCRIPTION & OPERATION 1	Added weight to leading particulars.
REPAIR-GEN 602	Added latest configuration of instruction page.
REPAIR 2-1 601-602	Added part number to Fig. 601.

BOEING

COMPONENT
MAINTENANCE MANUAL

AUXILIARY TRACK FITTING ASSEMBLIES

PART NUMBER 114T0111-1
114T0112-1,-2

COMPONENT MAINTENANCE MANUAL
WITH
ILLUSTRATED PARTS LIST

144656

COMPONENT
MAINTENANCE MANUAL

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

PAGE	DATE	CODE
27-81-37		
TITLE PAGE		
1	OCT 10/84	01
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REVISION RECORD		
1	OCT 10/84	01
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TR & SB RECORD		
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LIST OF EFFECTIVE PAGES		
*1	JAN 01/89	01
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601	OCT 10/84	01
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REPAIR 2-1		
*601	JAN 01/89	01.1
*602	JAN 01/89	01.1
ILLUSTRATED PARTS LIST		
1001	OCT 10/84	01
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1003	BLANK	
1004	OCT 10/84	01
1005	OCT 10/84	01
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* = REVISED, ADDED OR DELETED

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TABLE OF CONTENTS

*[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
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.

AUXILIARY TRACK FITTING ASSEMBLIES

DESCRIPTION AND OPERATION

1. Description

   A. The auxiliary track fitting assemblies consist of an adjustment aft fitting with bushings and a strut lower fitting with bushings.

2. Operation

   A. The adjustment aft fitting assembly supports the aft end of the leading edge auxiliary track and provides angular adjustment through a linkage.

   B. The strut lower fitting assembly supports the lower end of the rib brace strut at ISS 190.53.

3. Leading Particulars of 114T0111-1 (Approximate)

   Length -- 2 inches
   Width -- 4 inches
   Height -- 1 inch
   Weight -- 3 pounds

4. Leading Particulars of 114T0112-1, -2 (Approximate)

   Length -- 5 inches
   Width -- 1 inch
   Height -- 5 inches
   Weight -- 4 pounds

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. Fitting (20, IPL Fig. 1)

   B. Fitting (15, IPL Fig. 2)

REPAIR - GENERAL

1. Content

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

P/N	NAME	REPAIR
114TO111	FITTING, AUXILIARY TRACK ADJUSTMENT AFT	1-1
114TO112	FITTING, AUXILIARY TRACK STRUT LOWER	2-1

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
▱	FLATNESS
⊥	PERPENDICULARITY (OR SQUARENESS)
//	PARALLELISM
○	ROUNDNESS
⌭	CYLINDRICITY
⌒	PROFILE OF A LINE
⌓	PROFILE OF A SURFACE
◎	CONCENTRICITY
⌯	SYMMETRY
∠	ANGULARITY
↗	RUNOUT
⌖	THEORETICAL EXACT POSITION OF A FEATURE (TRUE POSITION)
∅	DIAMETER
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)
Ⓢ	REGARDLESS OF FEATURE SIZE (RFS)
Ⓟ	PROJECTED TOLERANCE ZONE

EXAMPLES

— 0.002	STRAIGHT WITHIN 0.002
⊥ B 0.002	PERPENDICULAR TO B WITHIN 0.002
// A 0.002	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
⌒ A 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
⌓ A 0.020	SURFACES MUST LIE WITHIN PARALLEL BOUNDARIES 0.02 INCH APART AND EQUALLY DISPOSED ABOUT TRUE PROFILE
◎ C ∅ 0.0005	CONCENTRIC TO C WITHIN 0.0005 DIAMETER (FULL INDICATOR MOVEMENT)
⌯ A 0.010	SYMMETRICAL WITH A WITHIN 0.010
∠ A 0.005	ANGULAR TOLERANCE 0.005 WITH A
⌖ B ∅ 0.002 Ⓢ	LOCATED AT TRUE POSITION WITHIN 0.002 DIA IN RELATION TO DATUM B, REGARDLESS OF FEATURE SIZE
⊥ A ∅ 0.010 Ⓜ 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	EXACT DIMENSION IS 2.000

True Position Dimensioning Symbols
Figure 601

142862

AFT FITTING ASSEMBLY - REPAIR 1-1

114TO111-1

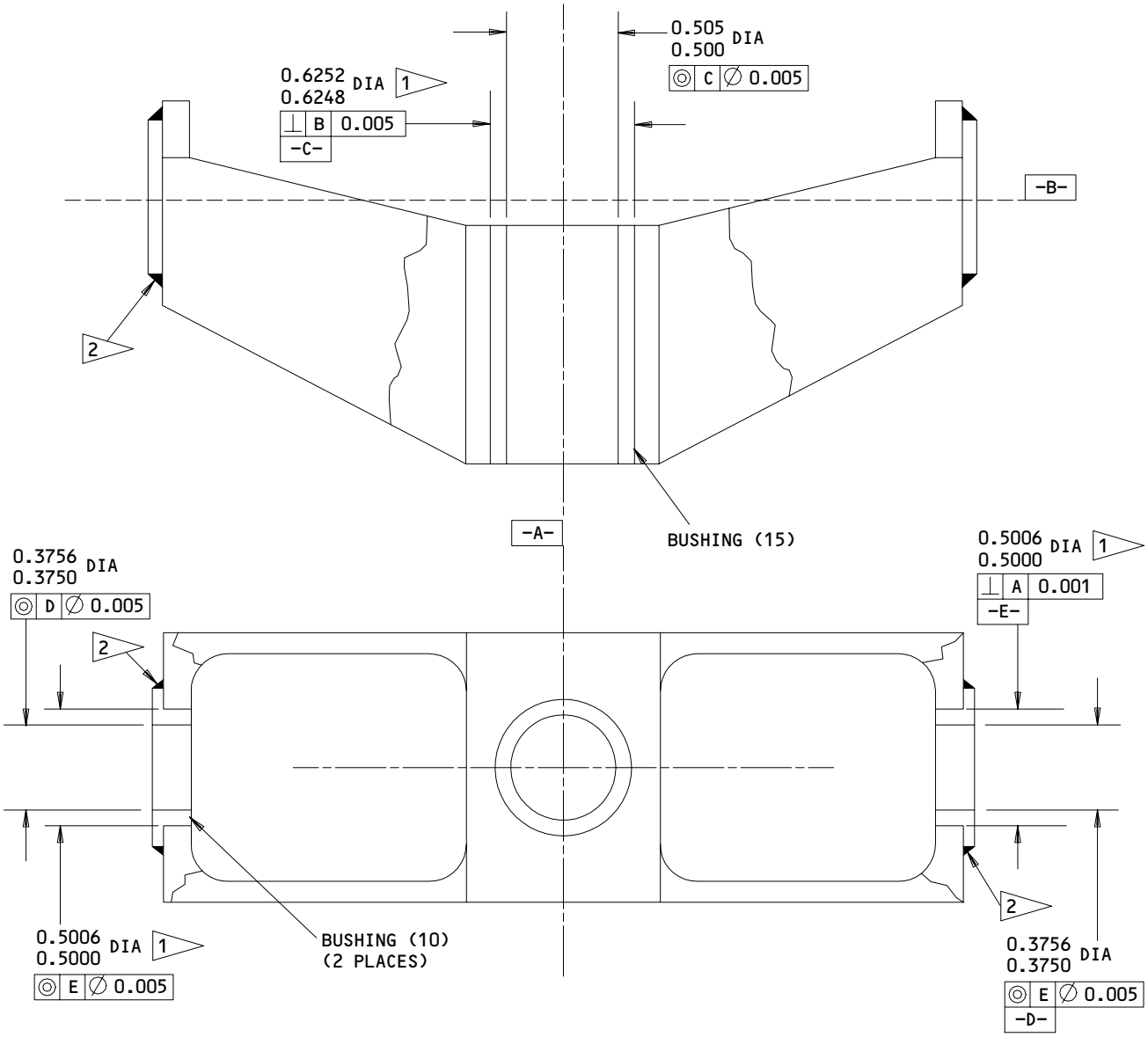
NOTE: Refer to REPAIR-GEN for list of applicable standard practices. For repair of surfaces which may only require stripping and restoration of original finish, refer to REFINISH instruction, Fig. 601.

1. Bushing Replacement (IPL Fig. 1)

   A. Remove bushings (10, 15).

   B. Install bushings (10, 15) 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.



REFINISH

FITTING (20) -- 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 NO. REFER TO IPL FIG. 1

114T0111-1
Aft Fitting Assembly Repair
Figure 601

142875

STRUT LOWER FITTING ASSEMBLY - REPAIR 2-1

114T0112-1, -2

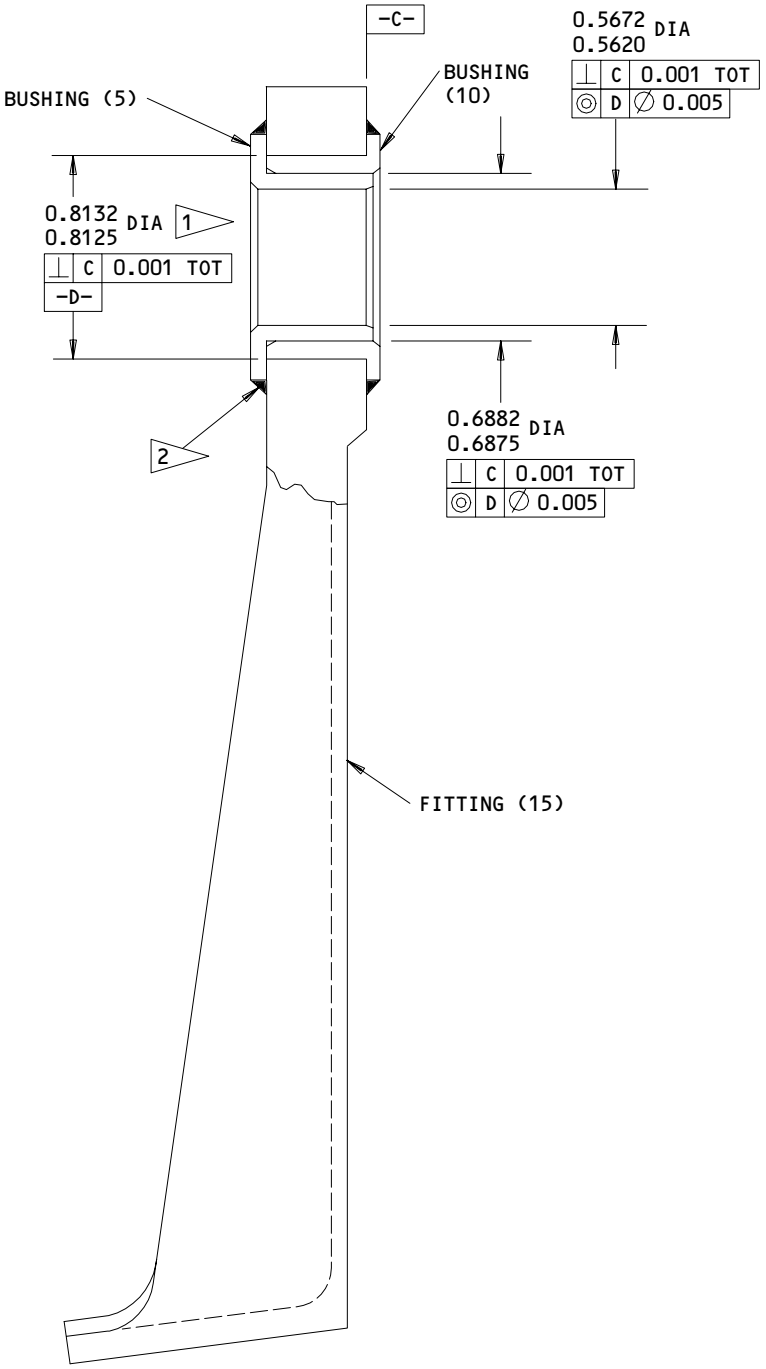
NOTE: Refer to REPAIR-GEN for list of applicable standard practices. For repair of surfaces which may only require stripping and restoration of original finish, refer to REFINISH instruction, Fig. 601.

1. Bushing Replacement (IPL Fig. 2)

   A. Remove bushings (5, 10).

   B. Install bushings (5, 10) 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.



REFINISH

FITTING (15) -- 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 NO. REFER TO IPL FIG. 2

114T0112-1,-2
Strut Lower Fitting Assembly Repair
Figure 601

142881

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

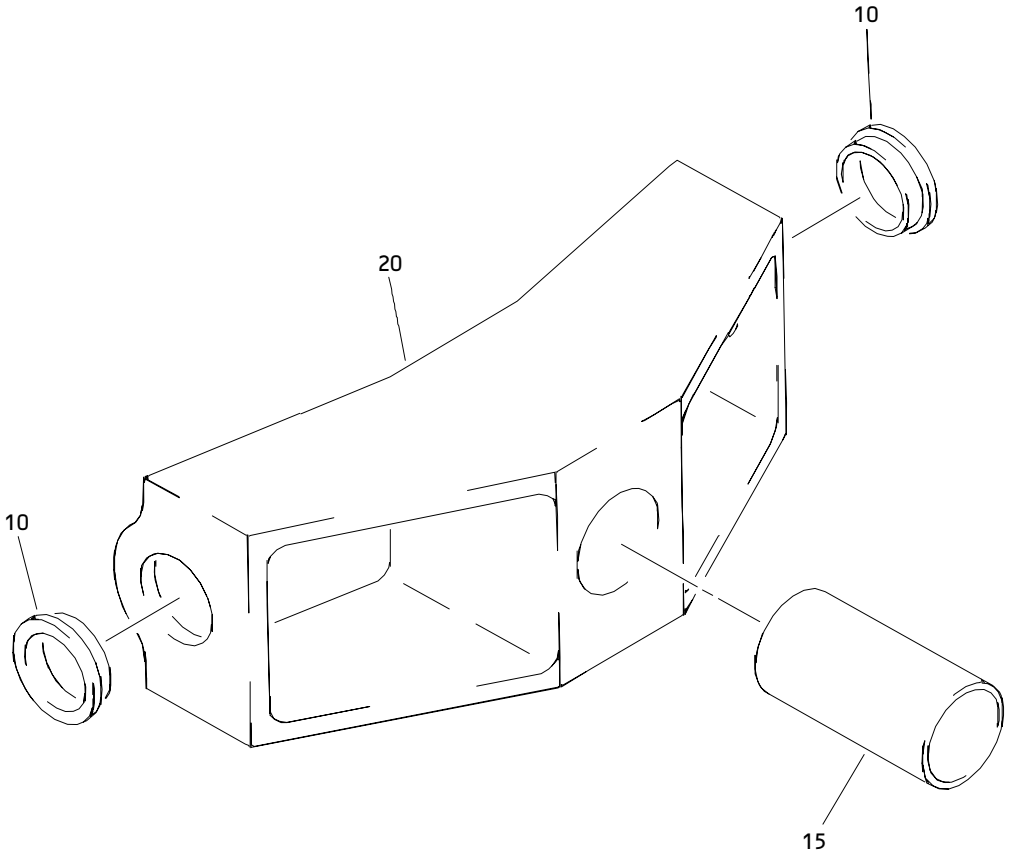
Optional (OPT)	The parts are optional to and interchangeable with other parts having the same item number.
Supersedes, Superseded By (SUPSDS, SUPSD BY)	The part supersedes and is not interchangeable with the original part.
Replaces, Replaced By (REPLS, REPLD BY)	The part replaces and is interchangeable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

VENDORS

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

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

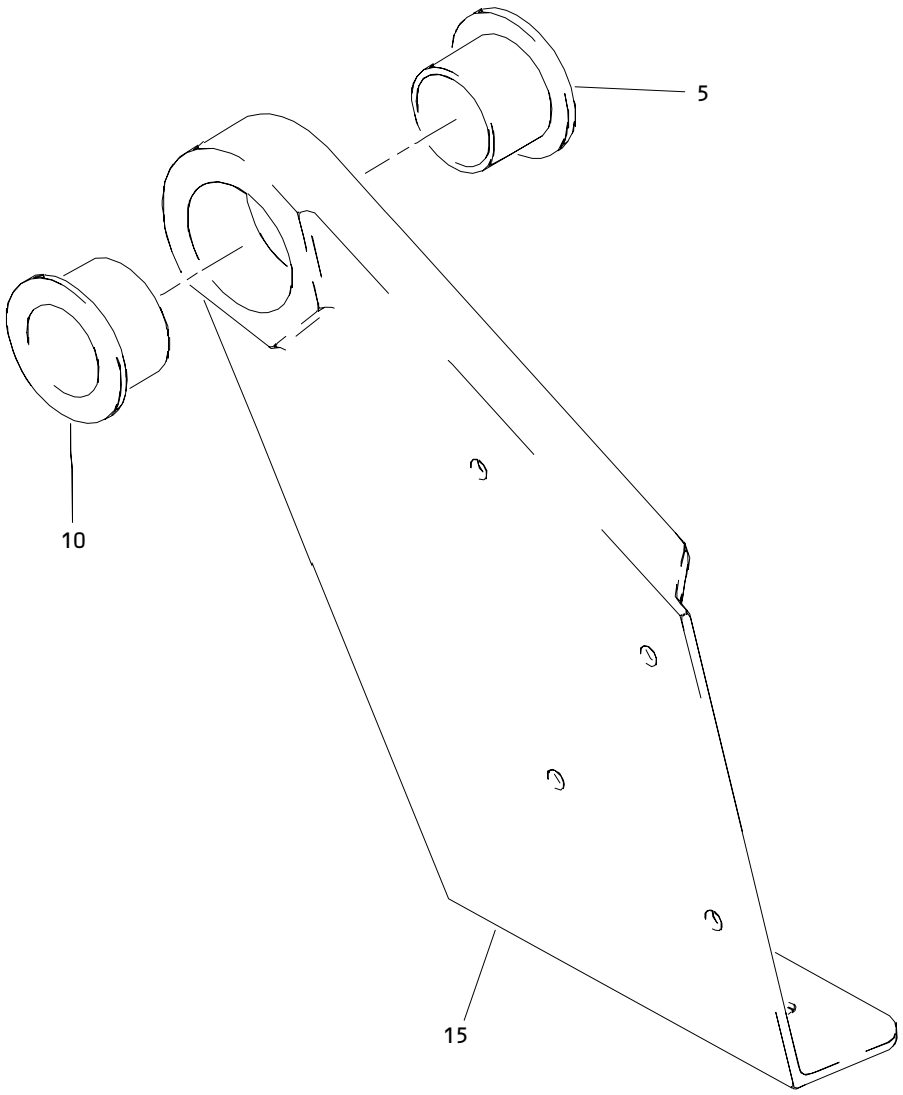
94892 MASTER MACHINE PRODUCTS CORPORATION
1551 SOUTH PRIMROSE AVE
MONROVIA, CALIFORNIA 91016



Auxiliary Track Adjustment Aft Fitting Assembly
Figure 1

T93154

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-1	114T0111-1		FITTING ASSY-AUX TRACK ADJUSTMENT AFT	A	RF
-5	114T0112-1		FITTING ASSY-AUX TRACK STRUT LWR (FOR DETAILS SEE FIG. 2)	B	RF
-5A	114T0112-2		FITTING ASSY-AUX TRACK STRUT LWR (FOR DETAILS SEE FIG. 2)	C	RF
10	BACB28AP06P014		.BUSHING- (V23294) (SPEC BACB28AP06P014) (OPT BACB28AP06P014 (V70265)) (OPT BACB28AP06P014 (V94892))	A	2
15	BACB28U8B109		.BUSHING- (V23294) (SPEC BACB28U8B109) (OPT BACB28U8B109 (V70265)) (OPT BACB28U8B109 (V94892))	A	1
20	114T0111-2		.FITTING	A	1



Auxiliary Track Strut Lower Fitting Assembly
Figure 2

T93153

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-					
-1	114T0112-1		FITTING ASSY-AUX TRACK STRUT LWR	B	RF
-1A	114T0112-2		FITTING ASSY-AUX TRACK STRUT LWR	C	RF
5	012T2400-1		.BUSHING	BC	1
10	012T2400-2		.BUSHING	BC	1
15	114T0112-3		.FITTING	B	1
-15A	114T0112-4		.FITTING	C	1