TO: ALL HOLDERS OF OUTBOARD LEADING EDGE SLAT DRIVE CONTROL UNIT ASSEMBLY
COMPONENT MAINTENANCE MANUAL 27-81-55

REVISION NO. 14 DATED JUL 01/00
HIGHLIGHTS

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

CHAPTER/SECTION AND PAGE NO.	DESCRIPTION OF CHANGE
TITLE PAGE	Added top assembly 256T2760-9 with new housing assembly.
1	
301-302	
501	
REPAIR 2-1	
601	
705	
1002-1003,1005-1009, 1013-1024	
REPAIR-GEN	Added Standard Practices.
601	
REPAIR-GEN	Edited without technical change.
601	
REPAIR 1-1	
601	
REPAIR 3-1	
601	
REPAIR 5-1	
601	
REPAIR 6-1	
601	
REPAIR 9-1	
601	
REPAIR 10-1	
601-602	
702-704,706-708	
802-803	
1010-1012	

CHAPTER/SECTION AND PAGE NO.	DESCRIPTION OF CHANGE
REPAIR 2-1 601	Added check of the electrical resistance after bushing installation.
REPAIR 2-1 602-603	Changed true position dimension callouts for bushing replacement in housing.
705	Identified transformers as substitute kit assemblies.

OUTBOARD LEADING EDGE SLAT DRIVE CONTROL UNIT ASSEMBLY

PART NUMBERS 256T2760-4,-5,-6,-9

COMPONENT MAINTENANCE MANUAL
WITH
ILLUSTRATED PARTS LIST

3898

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 B10298	OCT 10/81
		PRR B10663	JUL 10/83
		PRR B10751	JUL 10/83
		PRR B11488	JUL 10/87
		PRR B12249	OCT 01/92
27-0108R3			MAR 01/96

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27-81-55		
TITLE PAGE		
*1	JUL 01/00	01.1
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REVISION RECORD		
1	JUL 10/83	01
2	BLANK	
TR & SB RECORD		
1	MAR 01/96	01.1
2	BLANK	
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1	JUL 10/83	01.1
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*301	JUL 01/00	01.1
*302	JUL 01/00	01.1
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401	JUL 10/83	01
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502	JUL 10/83	01

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*601	JUL 01/00	01.1
602	SEP 01/95	01.1
603	SEP 01/95	01.1
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*601	JUL 01/00	01.1
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*603	JUL 01/00	01.1
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REPAIR 8-1		
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602	BLANK	

* = REVISED, ADDED OR DELETED

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REPAIR 9-1		
*601	JUL 01/00	01.1
602	BLANK	
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*602	JUL 01/00	01.1
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701	OCT 01/89	01.1
*702	JUL 01/00	01.1
*703	JUL 01/00	01.1
*704	JUL 01/00	01.1
*705	JUL 01/00	01.1
*706	JUL 01/00	01.1
*707	JUL 01/00	01.1
*708	JUL 01/00	01.1
FITS AND CLEARANCES		
801	JUL 10/83	01.1
*802	JUL 01/00	01.1
*803	JUL 01/00	01.1
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1001	JUL 10/83	01
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*1005	JUL 01/00	01.1
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*1010	JUL 01/00	01.1
*1011	JUL 01/00	01.1
*1012	JUL 01/00	01.1
*1013	JUL 01/00	01.1
*1014	JUL 01/00	01.1

PAGE	DATE	CODE
ILLUSTRATED PARTS LIST		CONT.
*1015	JUL 01/00	01.1
*1016	JUL 01/00	01.1
*1017	JUL 01/00	01.1
*1018	JUL 01/00	01.1
*1019	JUL 01/00	01.1
*1020	JUL 01/00	01.1
*1021	JUL 01/00	01.1
*1022	JUL 01/00	01.1
*1023	JUL 01/00	01.1
*1024	JUL 01/00	01.1

* = REVISED, ADDED OR DELETED

TABLE OF CONTENTS

INTRODUCTION

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

This manual is divided into separate sections:

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

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

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

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

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

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

Verification:

Disassembly	Mar 3/83
Assembly	Mar 3/83

OUTBOARD LEADING EDGE SLAT DRIVE CONTROL UNIT ASSEMBLY

DESCRIPTION AND OPERATION

1. The outboard leading edge slat drive control unit assembly consists of an input cam, a follow-up cam and a summing lever housed in an aluminum alloy housing and cover. A quill shaft connects to a sensor assembly which in turn connects to two transformers.

2. Input signals from the pilot rotate the input cam which positions the valve input shaft to apply hydraulic pressure to the slat drive motor. When the slat reaches the selected position, the follow-up cam rotates changing the position of the valve input shaft and stopping hydraulic fluid flow. The quill shaft transmits signals from the gearbox to the sensor.

3. Leading Particulars (Approximate)

   Width -- 9 inches
   Depth -- 11 inches
   Height -- 12 inches
   Weight -- 20 pounds

DISASSEMBLY

1. Parts Replacement

   NOTE: The following parts are recommended for replacement. Unless otherwise specified, the actual replacement of parts may be based on in-service experience.

   A. Gasket (65)

   B. Lockwire

2. Disassembly (IPL Fig. 1)

   CAUTION: USE EXTREME CARE WHEN REMOVING COVER ASSEMBLY (35). DO NOT TWIST, BIND OR BREAK WIRES ON TRANSFORMERS (80, 81, 83).

   A. Remove screws (40), washers (45A) and carefully pull cover assembly (35) away from housing cover assembly (85).

   B. Remove lockwire, bolts (75), clamps (70) and remove transformers (80, 81, 83) from sensor assembly (110).

   C. Remove screws (30) and remove transformers (80, 81, 83) from cover assembly (35).

      NOTE: Do not remove nutplate (50) from cover (60) unless repair or replacement is necessary.

   D. Remove bolts (115), washers (120A) and remove sensor assembly (110) and shaft (395). Pull shaft (395) straight out of sensor assembly (110). Remove packing (400A) from shaft.

   E. Disassemble sensor assembly (110).

      (1) Remove bolts (125), washers (130) and nuts (135). Separate bearing support ring (145) from sensor support plate (140) and remove gears (160) and spline shaft assembly (165).

      (2) Remove pin (170) and separate spline shaft (180) from input pinion gear (175).

      (3) Remove bearings (150, 155) from bearing support ring (145) and sensor support plate (140).

   F. Remove bolts (5), washers (10A) and nuts (15A) and remove pilot input arm (20B) and valve input arm (25).

G. Stand unit on housing assembly (205A) with cam assembly (290A) shaft facing down and remove bolts (90), washers (95A) and carefully remove cover assembly (85) by pulling straight away from housing assembly (205A).

H. Remove bearings (280, 405) from cover assembly (85).

I. Remove pilot input shaft (420) with attached parts from housing assembly (205A). Separate washer (410) and sector gear (415) from shaft.

J. Remove bolts (225A), washers (230), spacers (235A) and nuts (240A) from shaft (270) and housing assembly (205A) and remove spring (245).

K. Remove shaft (270) and attached parts from housing assembly (205A).

L. Deleted

M. Remove bolt (250), bushing (260), nut (265A) and separate summing lever (365) from shaft (270).

N. Remove nuts (340A), washers (345) and cam followers (360) from summing lever (365). Remove bearings (285, 350, 355) and bushing (255) from summing lever.

O. Remove nut (370) and washer (375) on cover assembly (85) and remove input cam assembly (315A) from cover assembly (85). Remove bearings (390) and spacer (380) from cover assembly (85).

NOTE: Do not remove inserts (100) from cover (105) unless repair or replacement is necessary.

Do not disassemble input cam assembly (315A) unless repair or replacement is necessary.

P. Remove nut (370), washer (375) and cam assembly (290A) from housing assembly (205A). Remove bearings (275, 390, 405) and spacer (385) from housing assembly (205A).

NOTE: Do not disassemble housing assembly (205A) unless necessary for repair or replacement.

Do not disassemble cam assembly (290A) unless repair or replacement is necessary.

Q. Remove drain cover (200) by removing parts (185, 190A).

CLEANING

1. Clean all parts except bearings using standard industry practices and information contained in 20-30-03.

2. Clean teflon sealed bearings per manufacturer's instructions.

CHECK

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

2. Penetrant check per 20-20-02 the following listed parts:

   A. Support plate (140)

   B. Spline shaft (180)

   C. Input pinion gear (175)

   D. Gear (160)

   E. Support ring (145)

   F. Pilot input arm (20B)

   G. Shaft (395)

   H. Housing (222)

   I. Housing cover (105)

   J. Input sector gear (415)

   K. Valve input arm (25)

   L. Shafts (310, 335A)

3. Magnetic particle check per 20-20-01 the following listed parts:

   A. Cams (305A, 330A)

   B. Pilot input shaft (420)

   C. Cam follower (360)

   D. Summing lever (365)

4. Check spring (245):

   A. Extend spring to 5.16 inches, check that load is 7.01-8.57 lb.

   B. Extend spring to 6.60 inches, check that load is 12.37-15.11 lb.

REPAIR - GENERAL

1. Content

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

P/N	NAME	REPAIR
256T2684-2	SPLINE SHAFT AND GEAR	1-1
256T3161-11	HOUSING	2-1
256T3163-3	COVER, HOUSING	3-1
256T3187	SHAFT	4-1
256T3173	FOLLOWER, CAM	5-1
65B81978	COVER	6-1
256T2681	RING, SUPPORT	7-1
256T2682	PLATE, SUPPORT	8-1
256T2686	GEAR, INPUT PINION	9-1
- -	MISCELLANEOUS PARTS	10-1

2. Standard Practices

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

SOPM 20-11-03, Repair of Electrical Terminations and Electrical Bonding Areas
SOPM 20-30-02, Stripping of Protective Finishes
SOPM 20-41-01, Decoding Table for Boeing Finish Codes
SOPM 20-41-02, Application of Chemical and Solvent Resistant Finishes
SOPM 20-43-01, Chromic Acid Anodizing
SOPM 20-50-03, Bearing and Bushing Replacement
SOPM 20-60-02, Finishing Materials
SOPM 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. Sealant -- BMS 5-95 (Ref 20-60-04)

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

SPLINE SHAFT AND GEAR ASSEMBLY - REPAIR 1-1

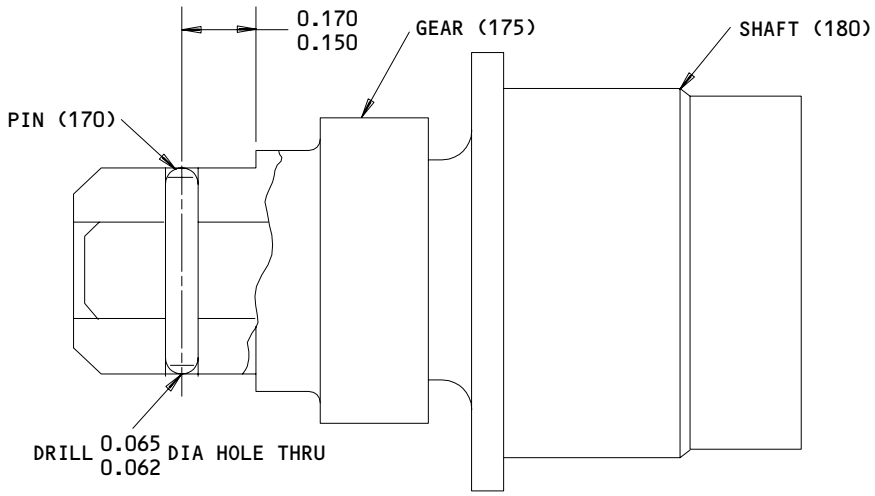
256T2684-2, -3

1. Parts Replacement (Fig. 601)

A. Assemble gear (175) on shaft (180).

B. Drill 0.062-0.065-inch diameter hole through gear (175) and shaft (180), maintain dimension shown. Remove gear from shaft.

C. Assemble gear (175), shaft (180) and spring pin (170) using wet primer.



ALL DIMENSIONS ARE IN INCHES

Parts Replacement
Figure 601

3961

HOUSING ASSEMBLY - REPAIR 2-1

256T3161-11, -21

NOTE: Refer to REPAIR - GENERAL for a list of applicable standard practices. For repair of housing (222) surfaces which may only require stripping and restoration of original finish, refer to Refinish instructions, Fig. 601.

1. Bushing Replacement (Fig. 601)

   A. Remove bushings (215, 218).

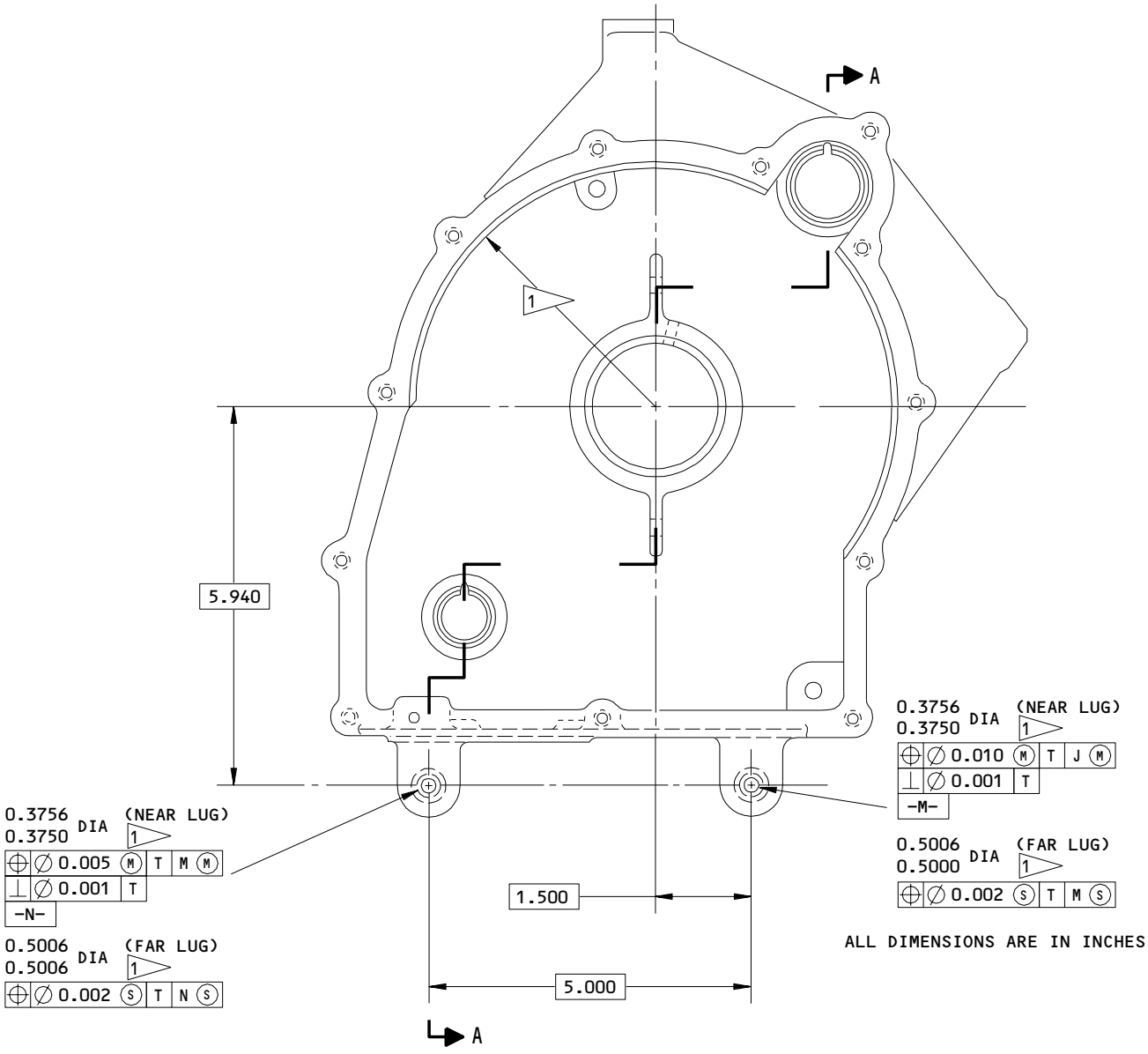
   B. Prepare housing and bushing surfaces for electrical bonding per 20-11-03.

   C. Install new bushings by shrink-fit method per SOPM 20-50-03, but do not install with grease.

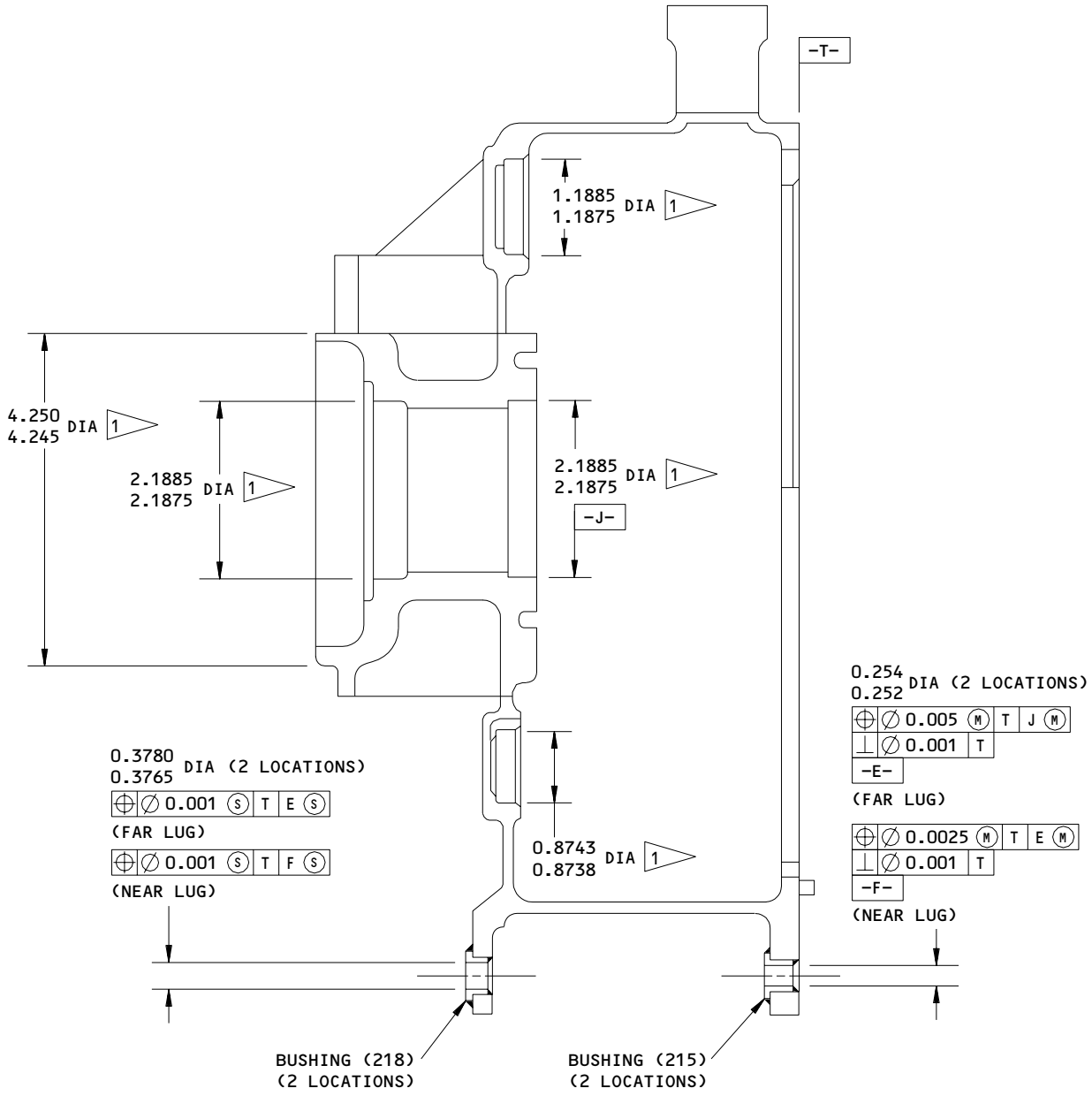
   D. Make sure that the electrical resistance between the housing and the bushings is not more than 0.0005 ohm.

   E. Machine bushings to dimensions shown.

   F. Fillet seal flange and end of bushings with sealant.



256T3161-11,-21
Bushing Replacement and Housing Refinish
Figure 601 (Sheet 1)



A-A

REFINISH

HOUSING: ANODIZE (F-17.05) AND APPLY 1 COAT OF BMS 10-11, TYPE 1 PRIMER (F-20.02) ALL OVER EXCEPT AS NOTED IN 1

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

1 OMIT PRIMER THIS DIAMETER

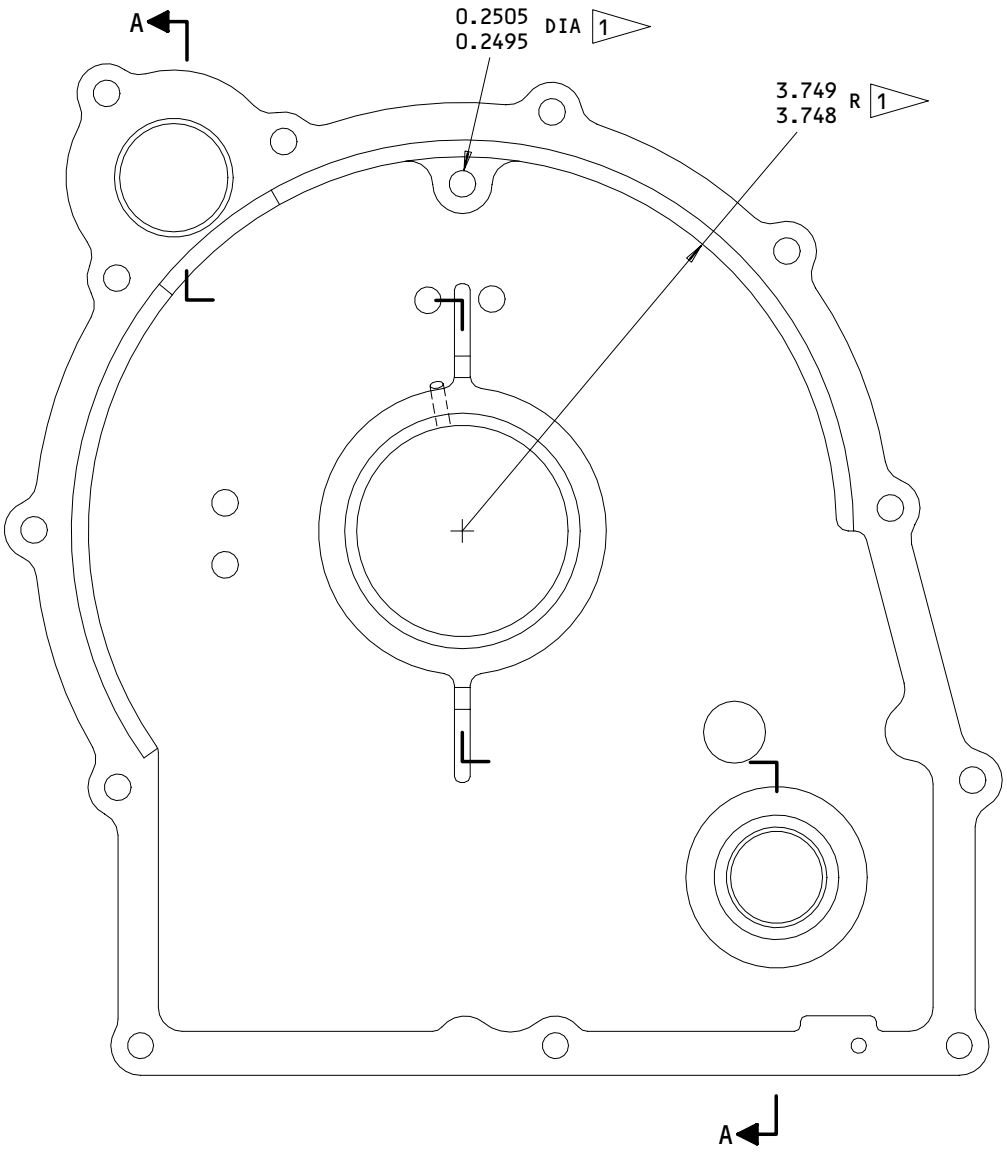
256T3161-11,-21
Bushing Replacement and Housing Refinish
Figure 601 (Sheet 2)

HOUSING COVER - REPAIR 3-1

256T3163-3

1. Plating Repair

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



REFINISH

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

MATERIAL: AL ALLOY

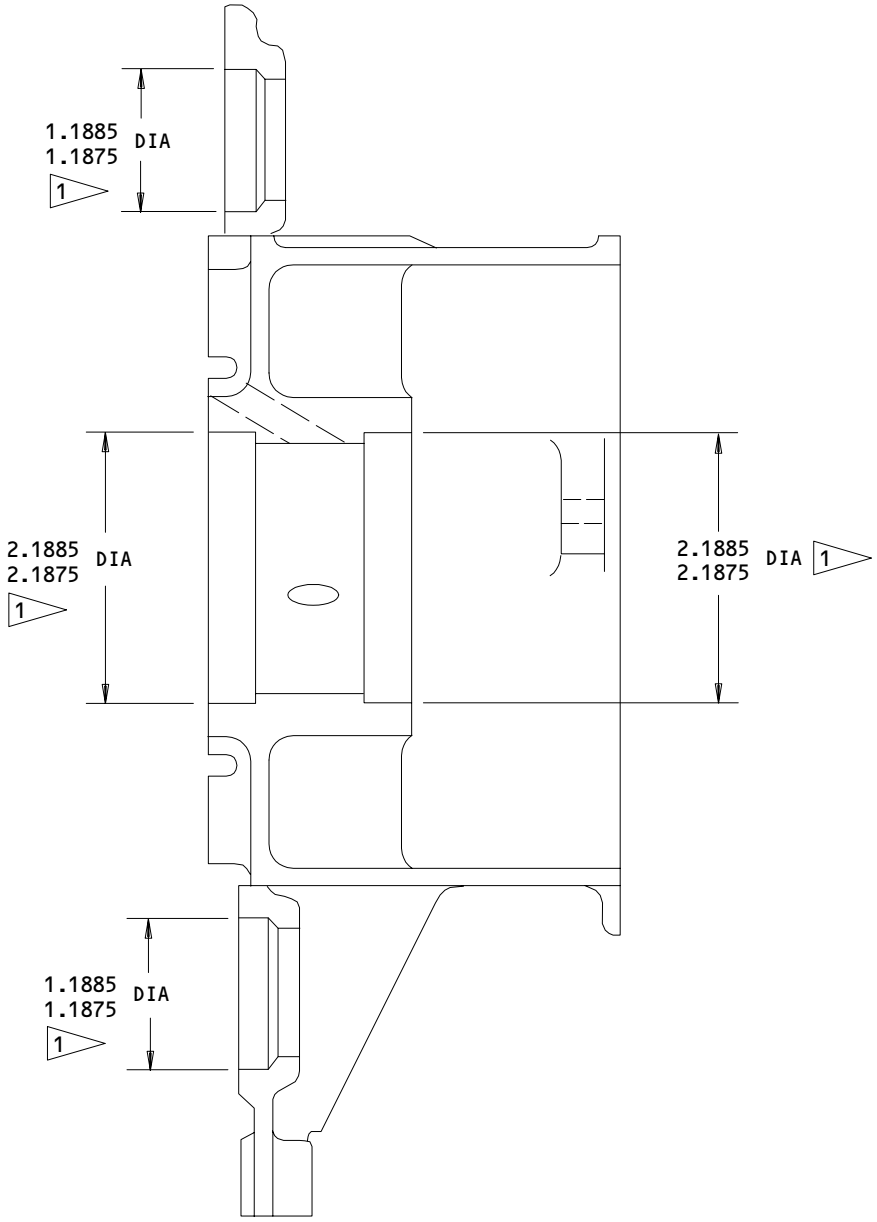
ALL DIMENSIONS ARE IN INCHES

1 NO PRIMER THIS AREA

256T3163-3

Housing Cover Repair and Refinish
Figure 601 (Sheet 1)

680152



A–A

REFINISH

ANODIZE (F–17.05) ALL OVER AND APPLY 1 COAT OF BMS 10–11, TYPE 1 PRIMER (F–20.02) EXCEPT AS NOTED IN 1

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

1 NO PRIMER THIS AREA

256T3163–3

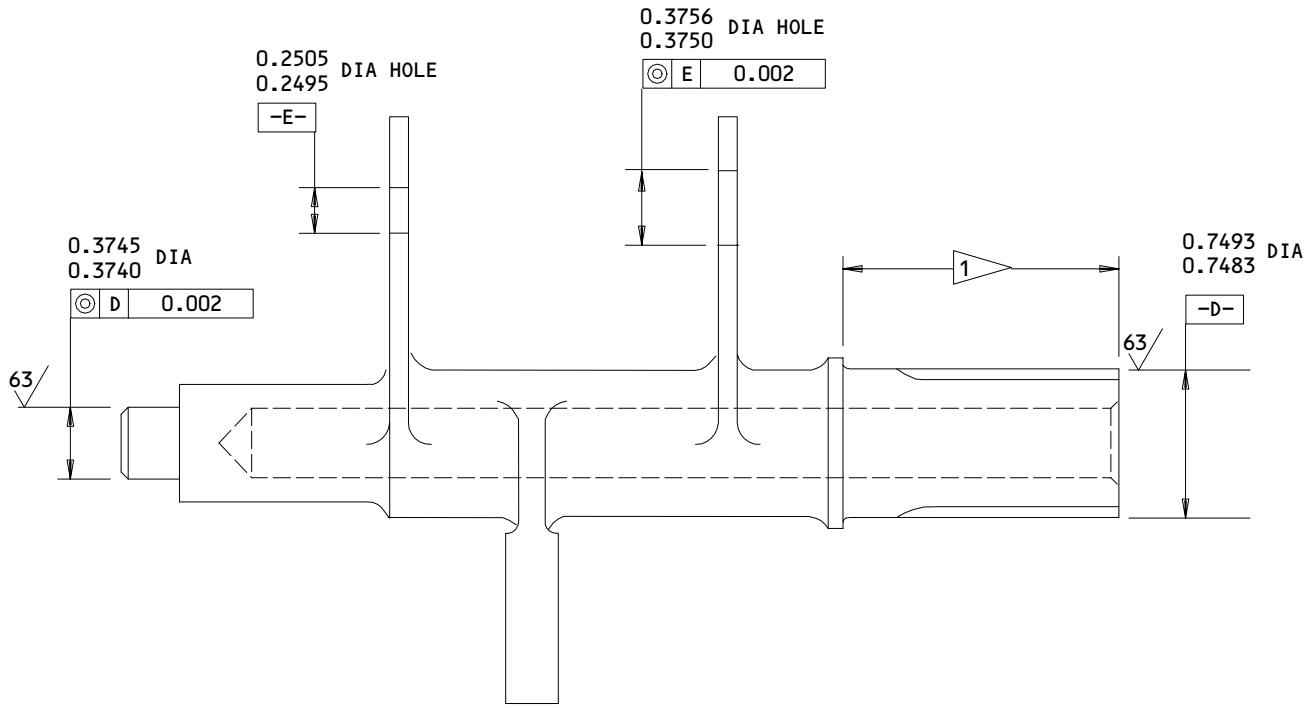
Housing Cover Repair and Refinish
Figure 601 (Sheet 2)

SHAFT - REPAIR 4-1

256T3187-1

1. Plating Repair

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



REFINISH

PASSIVATE (F-17.09) ALL OVER AND CADMIUM PLATE (F-15.25) AREA INDICATED IN 1

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

ALL DIMENSIONS ARE IN INCHES

Shaft Refinish
Figure 601

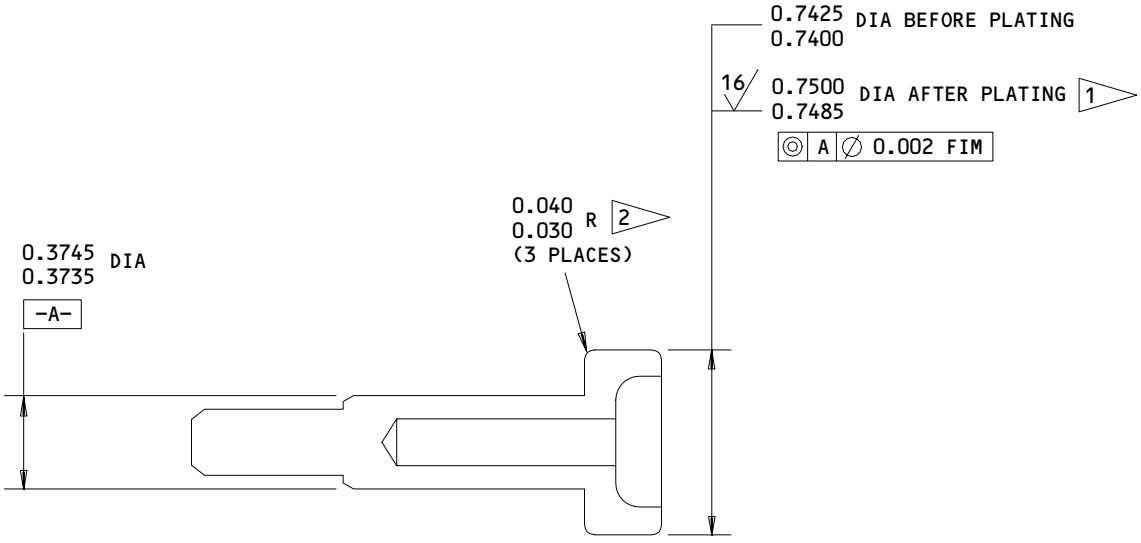
3979

CAM FOLLOWER - REPAIR 5-1

256T3173-1

1. Plating Repair

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



REFINISH

PASSIVATE (F-17.09) EXCEPT AS NOTED

1 CHROME PLATE (F-15.03) 0.003 MIN AFTER GRINDING

2 CHROME PLATE TO RUN OUT AROUND EDGE RADIUS

MATERIAL: 15-5PH CRES, 150-170 KSI

ALL DIMENSIONS ARE IN INCHES

Cam Follower Refinish
Figure 601

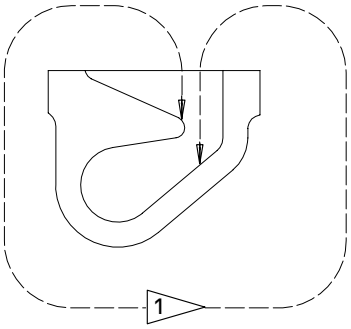
3986

DRAIN COVER - REPAIR 6-1

65B81978-1

1. Plating Repair

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



REFINISH

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

MATERIAL: AL ALLOY

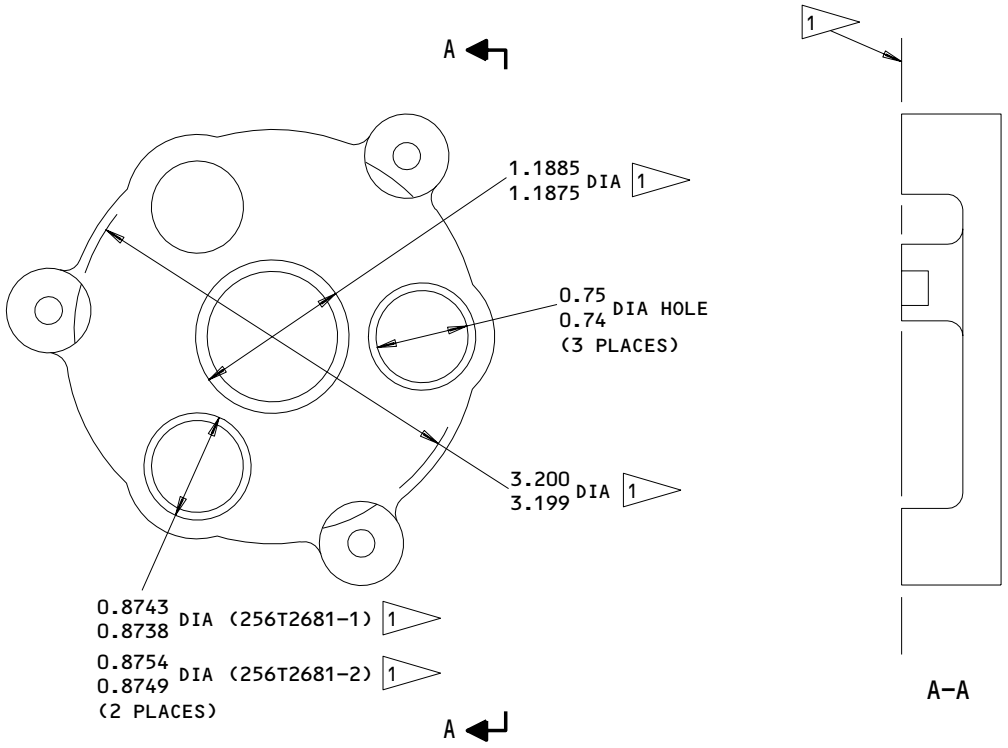
Cover Repair
Figure 601

SUPPORT RING - REPAIR 7-1

256T2681-1, -2

1. Plating Repair

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



REFINISH

CHROMIC ACID ANODIZE AND APPLY 1 COAT OF PRIMER (F-18.13) EXCEPT OMIT PRIMER IN AREA INDICATED BY 1

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

Support Ring Refinish
Figure 601

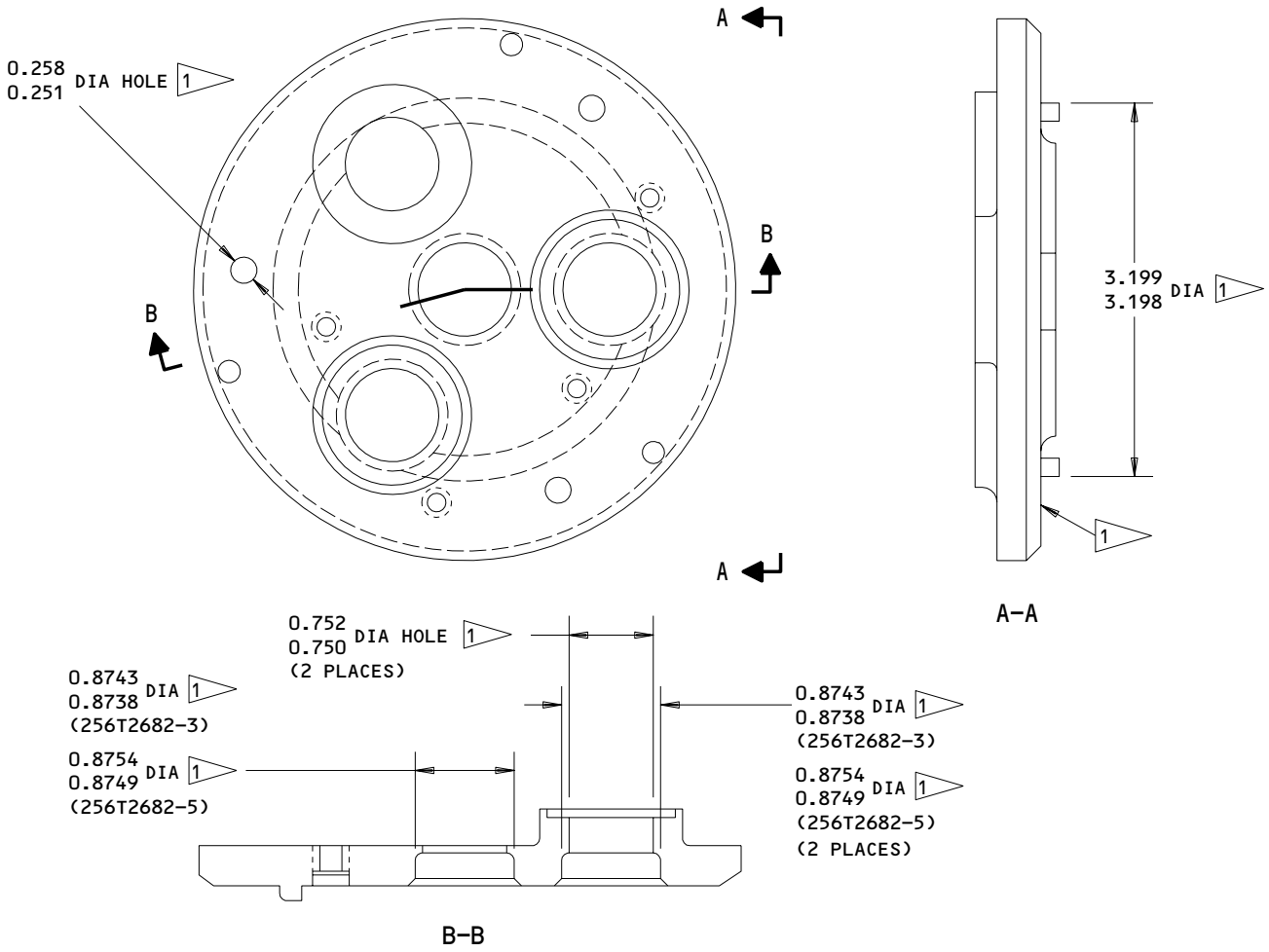
91548

SUPPORT PLATE - REPAIR 8-1

256T2682-3, -5

1. Plating Repair

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



REFINISH

CHROMIC ACID ANODIZE AND APPLY 1 COAT OF PRIMER (F-18.13) EXCEPT OMIT PRIMER IN AREA INDICATED BY 1

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

Support Plate Refinish
Figure 601

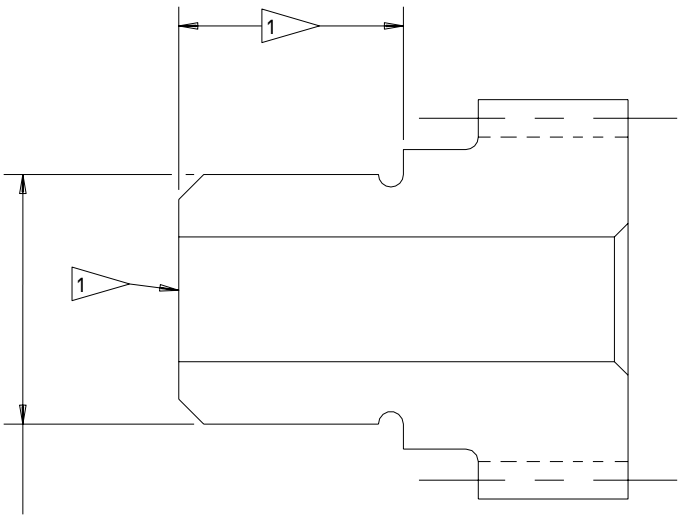
91570

INPUT PINION GEAR - REPAIR 9-1

256T2686-2, -3

1. Plating Repair

NOTE: Repair consists of stripping and restoration of original finish. Refer to Refinish instruction in Fig. 601 and to REPAIR - GENERAL for a list of applicable standard practices.



REFINISH

SULFURIC ACID HARD ANODIZE (F-17.06) EXCEPT AS NOTED BY 1. (256T2686-2 ONLY)

NO FINISH (256T2686-3 ONLY)

MATERIAL: AL ALLOY (256T2686-2)
NYLON (256T2686-3)

1 CHROMIC ACID ANODIZE (F-17.04), 0.02 RUN-OUT ACCEPTABLE

Input Pinion Gear Refinish
Figure 601

624983

MISCELLANEOUS PARTS - REPAIR 10-1

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

IPL FIG. & ITEM	MATERIAL	FINISH
Fig. 1		
Arm (20B,25)	A1 alloy	Chromic acid anodize and apply 1 coat of BMS 10-11 type 1 primer (F-18.13) all over except omit primer on spline.
Cover (60)	Al alloy	Chemical treat surfaces and apply 1 coat of BMS 10-11 type 1 (F-18.06) plus apply 1 coat of BMS 10-11, type 1 primer (F-20.02) all over.
Shaft (180)	Al alloy	Chromic acid anodize and apply 1 coat of BMS 10-11 type 1 primer (F-18.13) all over. Omit primer on internal splines, 0.7483-0.7493 in. OD bearing seat (next to flange), and 0.1872-0.1877 in. dia shaft.
Gear (160)	Al alloy	Hard anodize (F-17.06) and apply 1 coat of BMS 10-11 type 1 primer (F-20.02) except omit primer on bearing faying surfaces, gear teeth, and spline.
Gear (160A)	Nylon	No finish.
Cam (305A,330A)	15-5PH CRES, 180-200 ksi	Cadmium plate (F-15.06) 1.4370-1.4375 in. bore. Passivate (F-17.09) all other surfaces.
Shaft (310,335A)	Al alloy	Chromic acid anodize (F-17.04).

Refinish Details
Figure 601 (Sheet 1)

IPL FIG. & ITEM	MATERIAL	FINISH
Summing lever (365)	15-5PH CRES, 180-200 ksi	Passivate (F-17.09).
Shaft (395)	Al alloy	Chromic acid anodize (F-17.02).
Gear (415)	Al alloy	Chromic acid anodize and apply 1 coat of BMS 10-11 type 1 primer (F-18.13) except omit primer on gear and spline.
Input shaft (420)	15-5PH CRES, 150-170 ksi	Passivate (F-17.09) on all interior surfaces and cadmium plate (F-15.02) on all exterior surfaces.

Refinish Details
Figure 601 (Sheet 2)

ASSEMBLY

1. Materials

NOTE: Equivalent substitutes may be used.

A. Adhesive -- Type 38 (Ref 20-50-12)

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

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

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

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

2. Equipments

NOTE: Equivalent substitutes may be used.

A. Rigging Pins -- 0.250 inch diameter

B. Jig Assembly -- A27060-1

3. Assembly (IPL Fig. 1)

A. Assemble sensor assembly (110).

(1) Apply a thin film of grease to bearings (150, 155) and install bearings on support plate assembly (140) and bearing support ring (145).

(2) Install spline shaft assembly (165) and gears (160) on bearing support ring (145).

(3) Install support plate assembly (140) on bearing support ring (145) and secure with bolts (125), washers (130) and nuts (135).

B. Assemble follow-up cam assembly (290A).

(1) Coat faying surfaces of cam (305A) and shaft (310) with sealant and install cam on shaft.

(2) Secure cam (305A) to shaft (310) with bolts (295) and collars (300). Install fasteners with wet primer.

(3) Fillet seal contact area between cam (305A) and shaft (310) with sealant.

C. Assemble input cam assembly (315A).

(1) Coat faying surfaces of cam (330A) and shaft (335A) with sealant and install cam on shaft.

(2) Secure cam (330A) to shaft (335A) with bolt (320) and collar (325). Install fasteners with wet primer.

(3) Fillet seal contact area between cam (330A) and shaft (335A) with sealant.

D. Assemble summing lever (365) and shaft (270).

(1) Apply a thin film of grease to bearings (285, 350, 355) and install bearings and bushing (255) in summing lever (365).

(2) Install cam followers (360) and secure with washers (345) and nuts (340A). Check that cam followers rotate freely.

(3) Apply corrosion preventive compound to shank of bolt (250).

CAUTION: INSTALL BOLT (250) AS INDICATED OR INTERFERENCE MAY RESULT.

(4) Position summing lever (365) on shaft (270) as shown in Fig. 701 and secure with bolt (250), bushing (260) and nut (265A). Install bolt with bolthead direction shown in Fig. 701.

E. Install parts in cover assembly (85).

(1) Apply a thin film of grease to bearings (280, 390, 405) and install bearings and spacer (380) on cover assembly (85).

(2) Apply a thin film of grease to input cam assembly (315A) and install input cam assembly on cover assembly (85). Insert rigging pin through hole in cover assembly to secure cam (330A).

(3) Apply a light film of grease to threads of nut (370) and install washer (375) and nut (370) on cam assembly (315A). Tighten nut to a maximum 5 pound-inches above the self-locking torque of the nut. The shaft shall not bind when rotated for two complete revolutions in the clockwise and counterclockwise directions.

(4) Remove rigging pin and check that cam (315A) rotates smoothly. Reinstall rigging pin and temporarily tape to cover assembly (85) to prevent cam assembly (315A) from rotating.

F. Install parts in housing assembly (205A).

(1) Install drain cover (200) and secure with bolts (185) and washers (190A).

(2) Apply a thin film of grease to bearings (275, 390, 405) and install bearings and spacer (385) in housing assembly (205A).

(3) Install follow-up cam assembly (290A) on housing assembly (205A) and insert rigging pin thru hole in housing assembly to secure cam (305A) in place.

(4) Apply a light film of grease to threads of nut (370) and install washer (375) and nut on cam assembly (290A). Tighten nut to a maximum 5 pound-inches above the self-locking torque of the nut. The shaft shall not bind when rotated for two complete revolutions in the clockwise and counterclockwise directions.

(5) Remove rigging pin and check that cam assembly (290A) rotates freely. Reinstall rigging pin and tape to housing assembly (205A) to prevent cam assembly (290A) from rotating.

(6) Apply a light coat of corrosion preventive compound to bolts (225A).

(7) Install spring (245) on housing assembly (205A) and shaft (270) and secure with bolts (225A), washers (230), spacers (235A) and nuts (240A).

(8) Install shaft (270) on bearing (275) in housing assembly (205A) with cam follower (360) seated in slot of follow-up cam (305A).

(9) If cam follower (360) on summing lever (365) cannot be seated in slot of cam (305A), the summing lever (365) is installed backward on shaft (270). Remove parts and reinstall summing lever (365) on shaft (270).

(10) Apply corrosion preventive compound to splines of input shaft (420) and gear (415). Apply a thin film of grease to gear (415) and install gear and washer (410) on shaft.

(11) Install shaft (420) on bearing (405) in housing assembly (205A).

G. Install cover assembly (85) on housing assembly (205A).

(1) Temporarily install pilot input arm (20B) on shaft (420) with matching bolt cut out.

(2) Rotate pilot input arm (20B) as required until arm is in position indicated in Fig. 701 using jig assembly A27060-2. Remove jig assembly A27060-2 and pilot input arm. Use care not to rotate shaft while removing pilot input arm.

NOTE: This will set the position of sector gear (415) to mate with gear teeth in cam shaft (335A).

(3) Install cover assembly (85) on housing assembly (205A).

NOTE: Rotate shaft (270) slightly using valve input arm (25) to facilitate seating of cam follower (360) in input cam (330A) slot.

(4) Install pilot input arm (20B) on input shaft (420) with matching bolt cutout and insert bolt (5) through bolthole. Check position of pilot input arm (20B) with jig assembly A27060-2.

(5) If pilot input arm (20B) position is not as indicated, repeat step (2) and (3) as required. Remove bolt (5), pilot input arm (20B) and jig assembly A27060-2.

(6) Secure cover assembly (85) to housing assembly (205A) using bolts (90) and washers (95A). Install bolts with corrosion preventive compound.

H. Apply corrosion preventive compound to bolt (5). Install pilot input arm (20B) on shaft (420) with matching bolt cutout and secure with bolt (5), washer (10A) and nut (15A). Install bolt (5) in direction shown.

I. Apply corrosion preventive compound to bolt (5). Install valve input arm (25) on shaft (270) with matching bolt cutout and secure with bolt (5), washer (10A) and nut (15A). Install bolt (5) in direction shown.

J. Assembly check

(1) Remove rigging pin on cover assembly (85) with rigging pin on housing assembly (205A) still in place.

(2) Rotate pilot input arm (20B) manually through an arc of 60 degrees clockwise (viewing at cover assembly (85)) and return. Check that rotation of arm is free of binding in both directions.

NOTE: Maintain the hold back force to resist spring force while returning arm to original position.

(3) Install rigging pin on cover assembly (85) and remove rigging pin on housing assembly (205A).

(4) Rotate follow-up cam shaft (310) thru an arc of 280 degrees clockwise (viewing at housing assembly (205A)) and return. Check that rotation of shaft is free of binding in both directions.

K. Install packing (400A) on quill shaft (395) and install quill shaft thru cover assembly (85).

NOTE: The packing (400A) must be clean and dry. Use a light, quick rap of a rubber mallet to slip the end of the quillshaft (395) through the shaft (335A).

L. Install sensor assembly (110) on cover assembly (85) and secure with bolts (115) and washers (120A). Install bolts with corrosion preventive compound. Lockwire bolts (115) to sensor assembly (110) using double twist method per 20-50-02.

M. Bond gasket (65) to cover assembly (85) per SOPM 20-50-12, type 38.

N. Install splined ends of transformers (80, 81, 83) on sensor assembly (110). Install clamps (70) and secure with bolts (75). Tighten bolts to 10-30 pound-inches.

O. Install splined ends of transformers (80, 81, 83) on sensor assembly (110). Install clamps (70) and secure with bolts (75). Tighten bolts to 10-30 pound-inches.

NOTE: Install transformer with black index mark on splined shaft aligned with black index mark on body to facilitate adjustment. Lockwiring of bolts (75) will be done after transformer adjustment (Ref CMM 27-81-82 TESTING/TROUBLE SHOOTING).

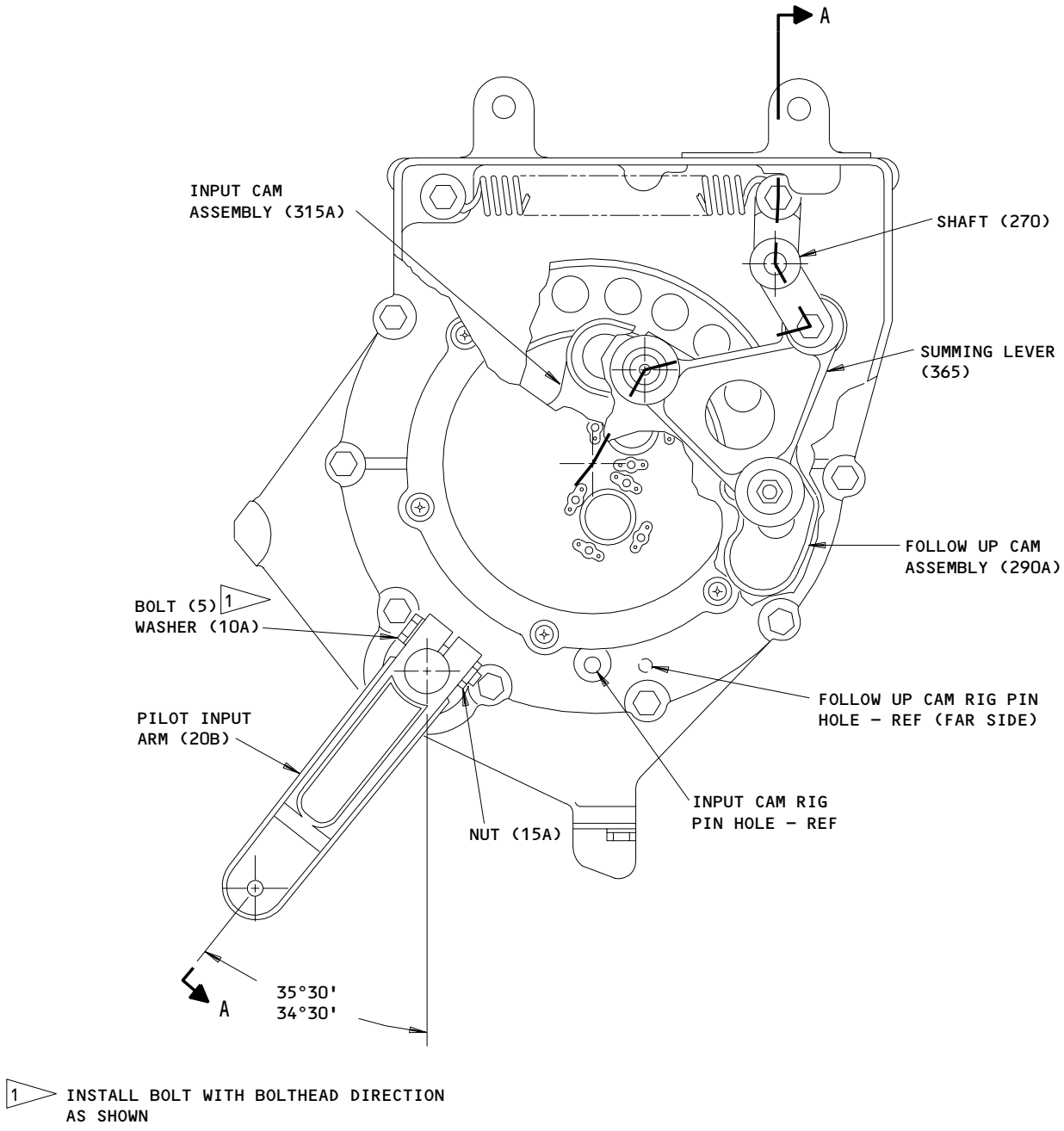
P. Install connector of transformers (80, 81, 83) on cover assembly (35) and secure with screws (30). Fillet seal around connector and nutplates (50) with sealant.

Q. Install cover assembly (35) on cover assembly (85) and secure with screws (40) and washers (45A). Install screws with corrosion preventive compound.

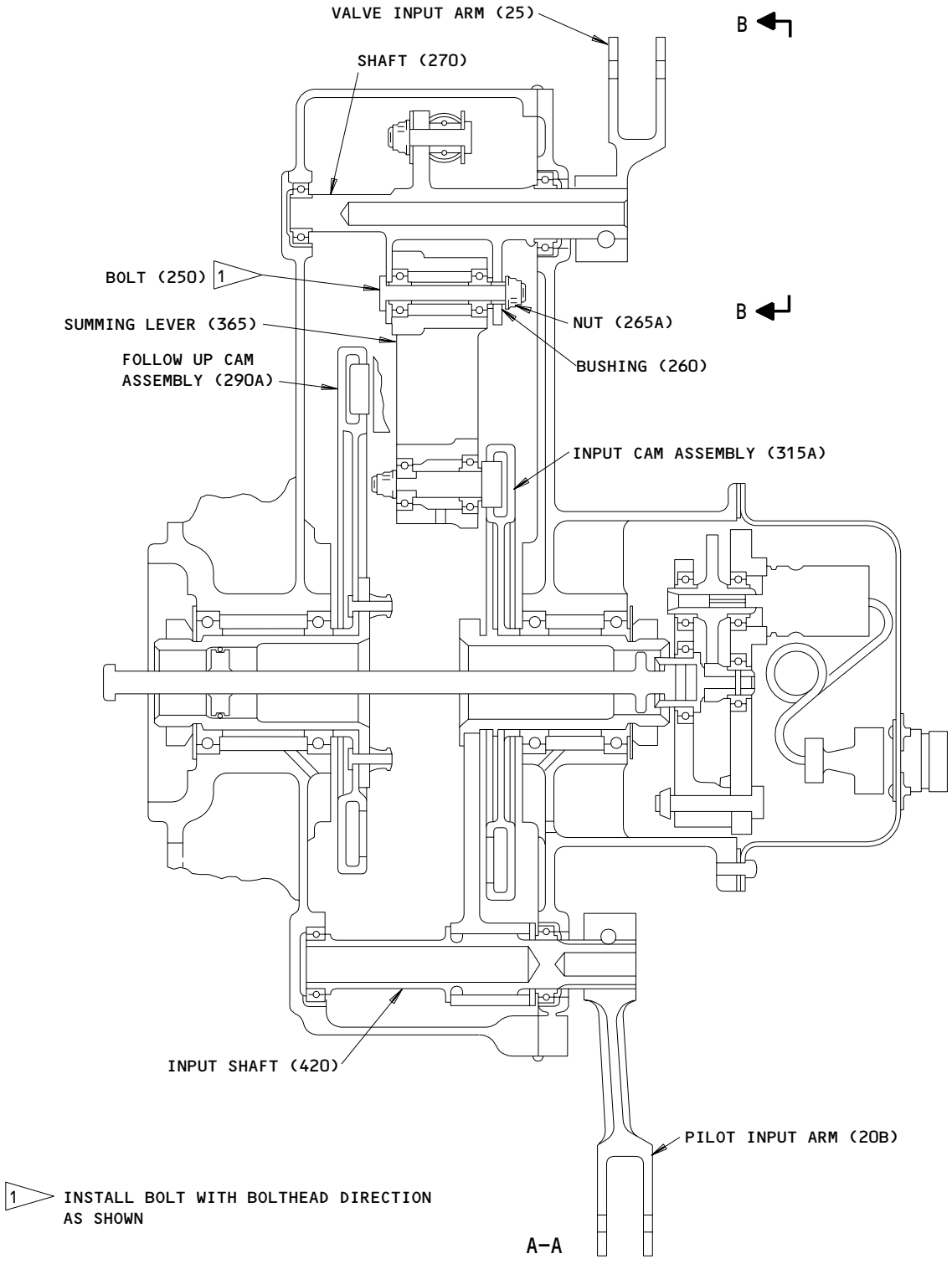
R. Rotate quill shaft through an arc of 200 degrees clockwise (viewing at housing assembly (205A)) and return. Check that the rotation is free of binding in both direction.

S. Fillet seal seam around cover assembly (85) and housing assembly (205A) with sealant.

4. Store this unit using standard industry practices and information contained in 20-44-02.

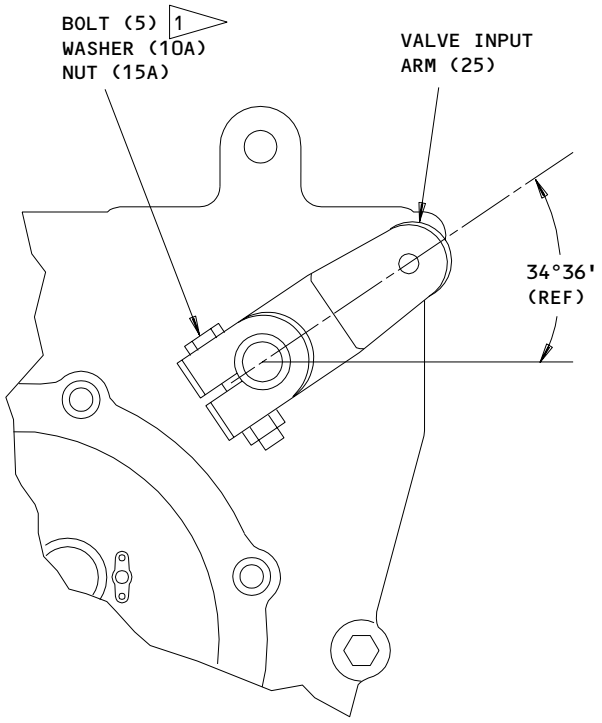


Assembly Details
Figure 701 (Sheet 1)



Assembly Details
Figure 701 (Sheet 2)

19551



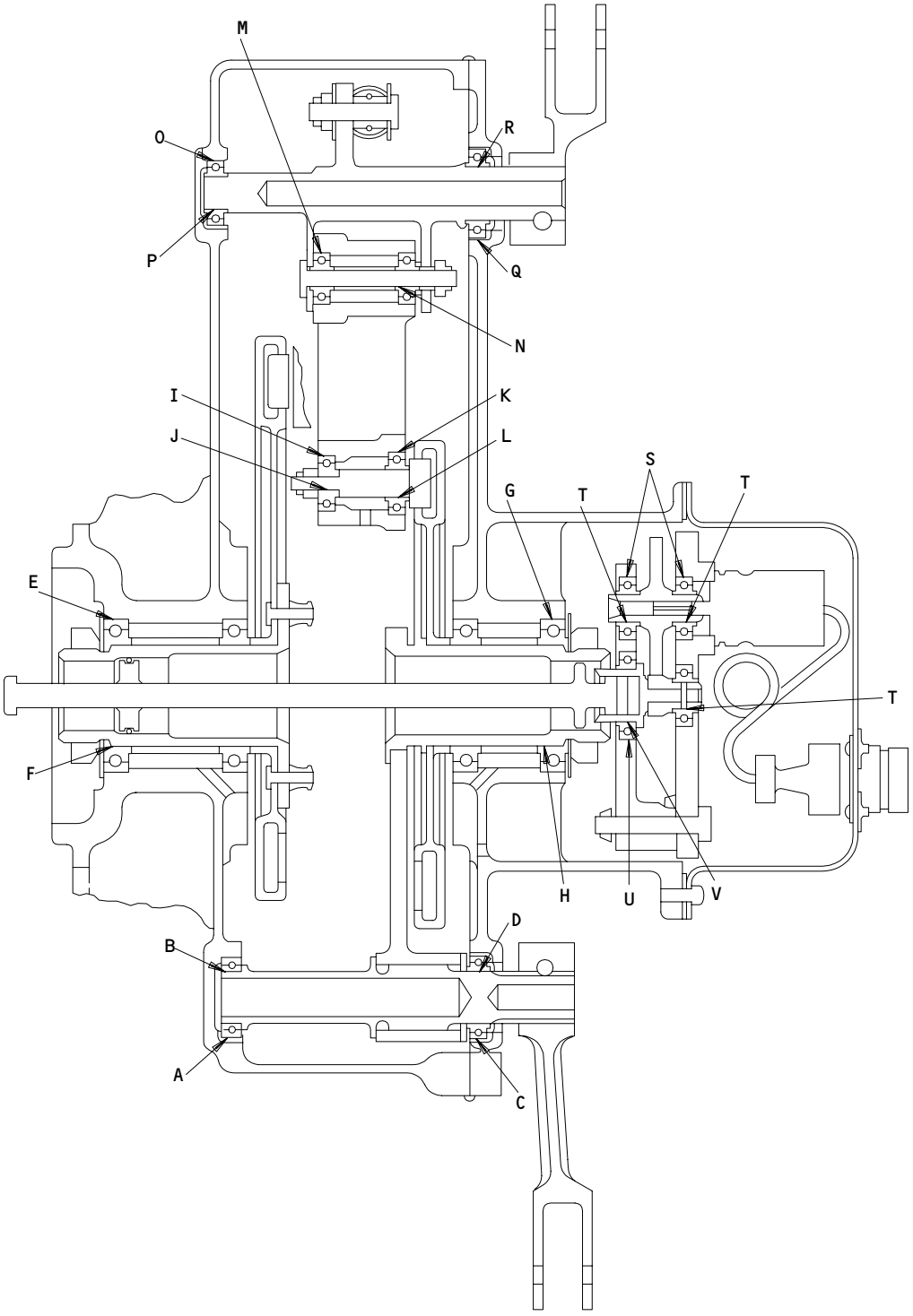
B-B

1 INSTALL BOLT WITH BOLT HEAD DIRECTION AS SHOWN

Assembly Details
Figure 701 (Sheet 3)

19552

FITS AND CLEARANCES



Fits and Clearances
Figure 801 (Sheet 1)

Ref Letter Fig.801	Mating Item No. IPL Fig.	Design Dimension				Service Wear Limit		
		Dimension		Assembly Clearance		Dimension		Maximum Clearance
		Min	Max	Min	Max	Min	Max	
A	ID 205A OD 405	1.1875 1.1865	1.1885 1.1875	0.0000	0.0020			
B	ID 405 OD 420	0.7493 0.7483	0.7507 0.7493	0.0000	0.0024			
C	ID 85 OD 405	1.1875 1.1865	1.1885 1.1875	0.0000	0.0020			
D	ID 405 OD 420	0.7493 0.7483	0.7507 0.7493	0.0000	0.0024			
E	ID 205A OD 390	2.1875 2.1865	2.1885 2.1875	0.0000	0.0020			
F	ID 390 OD 310	1.4370 1.4365	1.4380 1.4370	0.0000	0.0015			
G	ID 85 OD 390	2.1875 2.1865	2.1885 2.1875	0.0000	0.0020			
H	ID 390 OD 335A	1.4370 1.4365	1.4380 1.4370	0.0000	0.0015			
I	ID 365 OD 350	0.7490 0.7495	0.7495 0.7500	-0.0010 1	0.0000			
J	ID 350 OD 360	0.2495 0.2485	0.2500 0.2495	0.0000	0.0015			
K	ID 365 OD 355	0.8740 0.8745	0.8745 0.8750	-0.0010 1	0.0000			

1 INTERFERENCE FIT
ALL DIMENSIONS ARE IN INCHES

Fits and Clearances
Figure 801 (Sheet 2)

Ref Letter Fig.801	Mating Item No. IPL Fig.	Design Dimension				Service Wear Limit		
		Dimension		Assembly Clearance		Dimension		Maximum Clearance
		Min	Max	Min	Max	Min	Max	
L	ID 355 OD 360	0.3745 0.3735	0.3750 0.3745	0.0000	0.0015			
M	ID 365 OD 285	0.7490 0.7495	0.7495 0.7500	−0.0010 1	0.0000			
N	ID 285 OD 250	0.2495 0.2485	0.2500 0.2495	0.0000	0.0015			
O	ID 205A OD 275	0.8738 0.8745	0.8743 0.8750	−0.0012 1	−0.0002 1			
P	ID 275 OD 270	0.3745 0.3740	0.3750 0.3745	0.0000	0.0010			
Q	ID 85 OD 280	1.1875 1.1865	1.1885 1.1875	0.0000	0.0020			
R	ID 280 OD 270	0.7493 0.7483	0.7507 0.7493	0.0000	0.0024			
S	ID 140,145 OD 150	0.8738 0.8746	0.8743 0.8750	−0.0012 1	−0.0003 1			
T	ID 150 OD 160,175	0.3747 0.3748	0.3750 0.3753	−0.0006 1	0.0002			
U	ID 145 OD 155	1.1875 1.1865	1.1885 1.1875	0.0000	0.0020			
V	ID 155 OD 180	0.7493 0.7483	0.7507 0.7493	0.0000	0.0024			

1 INTERFERENCE FIT

ALL DIMENSIONS ARE IN INCHES

Fits and Clearances
Figure 801 (Sheet 3)

FOR TORQUE VALUE OF STANDARD FASTENERS, REFER TO 20-50-01			
ITEM NO. IPL FIG. 1	NAME	TORQUE	
		POUND-INCHES	POUND-FEET
370	NUT	5 MAX *[1]	

* ABOVE SELF-LOCKING TORQUE OF NUT

Torque Table
Figure 802

SPECIAL TOOLS, FIXTURES AND EQUIPMENT

NOTE: Equivalent substitutes may be used.

1. Jig Assembly - A27060-1

2. Rigging Pin -- 0.250 inch diameter (2 required)

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

K8455	RHP BEARINGS PLC RHP AEROSPACE OLDENDS LANE STONEHOUSE GL10 3RM UK
0PTK6	SPS TECHNOLOGIES INC AEROSPACE PRODUCTS DIV 5195 W 4700 SPO BOX 18459 KEARNS, UTAH 84118
06144	INDUSTRIAL TECTONICS BEARING CORP 18301 SOUTH SANTA FE AVENUE RANCO DOMINQUEZ, CALIFORNIA 90221
06725	AIR INDUSTRIES CORPORATION 12570 KNOTT STREET GARDEN GROVE, CALIFORNIA 92641-3932
08524	DEUTSCH FASTENER CORP SEE CODE V97928
11815	CHERRY AEROSPACE FASTENERS DIV OF TEXTRON 1224 EAST WARNER AVENUE PO BOX 2157 SANTA ANA, CALIFORNIA 92707-0157
15653	KAYNAR TECHNOLOGY KAYNAR DIV 800 SOUTH STATE COLLEGE BLVD PO BOX 3001 FULLERTON, CALIFORNIA 92831-3001
19710	MPC PRODUCTS CORP 7426 NORTH LINDER AVENUE SKOKIE, ILLINOIS 60077-3219
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

VENDORS

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

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

43991 FAG BEARING INCORPORATED
118 HAMILTON AVENUE
STAMFORD, CONNECTICUT 06904

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

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

60516 WEST COAST AEROSPACE INC
812 MIRAFLORES STREET
SAN PEDRO, CALIFORNIA 90731-1439

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

73197 HI-SHEAR TECHNOLOGY CORP
2600 SKYPARK DRIVE
TORRANCE, CALIFORNIA 90509

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

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

VENDORS

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

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

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

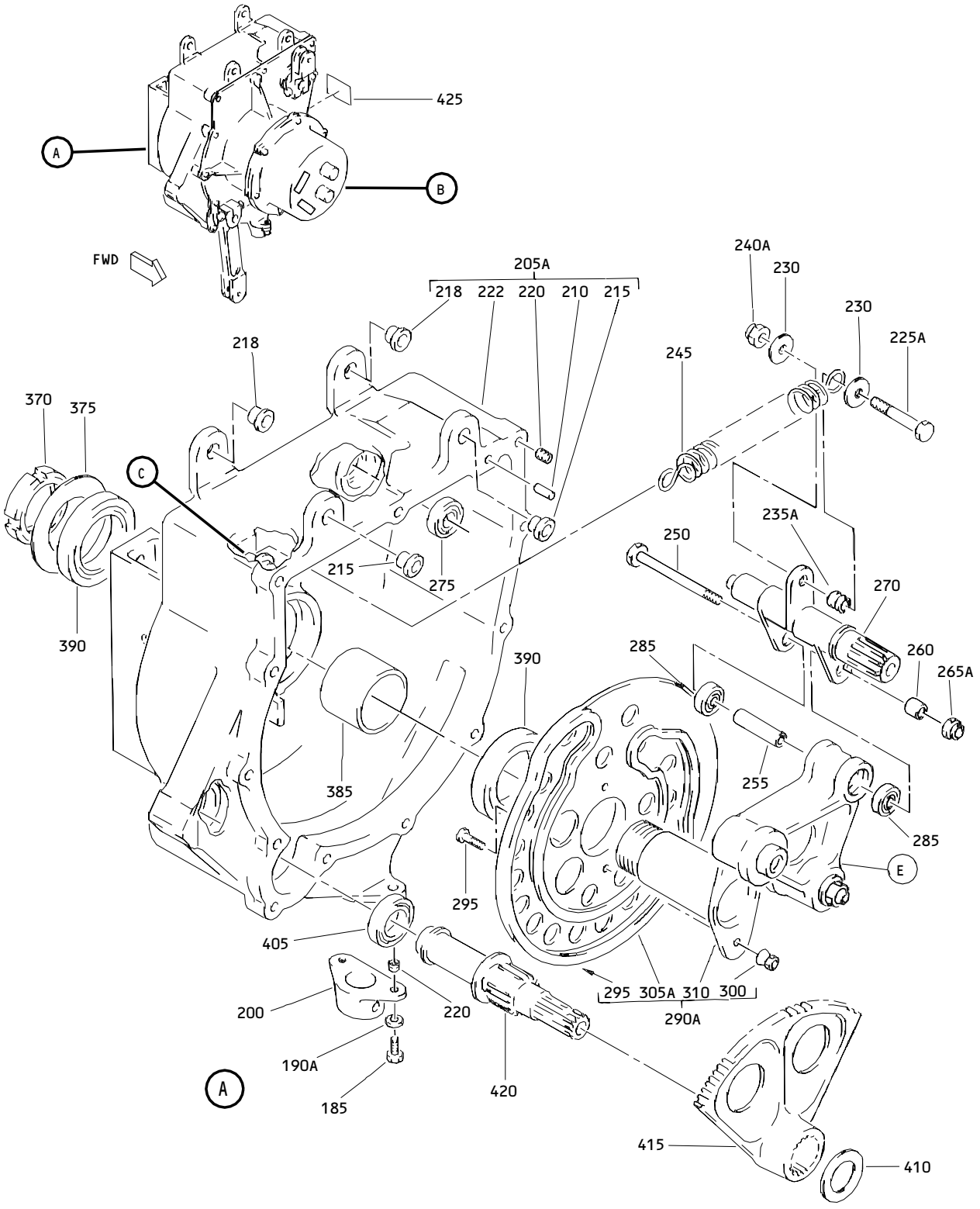
PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
AN960-416		1	130	3
BACB10AP6		1	150	5
BACB10BW23		1	390	4
BACB10BX4		1	285	2
		1	350	2
BACB10BX6		1	275	1
		1	355	2
BACB10CF12PP		1	155	1
		1	280	1
		1	405	2
BACB28AK04-025		1	260	1
BACB28AK04-089		1	255	1
BACB28AP04P032		1	215	2
BACB28W6B022		1	218	2
BACB30MY6K4		1	295	2
		1	320	1
BACC30M6		1	300	2
		1	325	1
BACN10JC4		1	135	3
BACN10JC4CD		1	15A	2
		1	240A	2
		1	265A	1
		1	340A	2
BACN10JP04A		1	50	8
BACN10RF22		1	370	2
BACR15BA3AD		1	55	16
BACW10P11AL		1	230	4
BACW10P149AL		1	410	1
BACW10P231D		1	345	2
BAC27ECT58		1	425A	1
BAC27TCT0002		1	425	1
BAC27TCT0280		1	430	1
BAC27TCT0282		1	435	1
BRM200A04L		1	50	8
B539-2TS		1	155	1
		1	280	1
		1	405	2
B539DD		1	155	1
		1	280	1
		1	405	2
B539DDFS101		1	155	1
		1	280	1
		1	405	2
B539DDFS428		1	155	1
		1	280	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
B539DDFS428		1	405	2
B539FS101		1	155	1
		1	280	1
		1	405	2
B539SSG27		1	155	1
		1	280	1
		1	405	2
CS204E		1	285	2
		1	350	2
CS206E		1	275	1
		1	355	2
HL10VAZ6-4		1	295	2
		1	320	1
HL79-6		1	300	2
		1	325	1
KP23B		1	390	4
KP4A		1	285	2
		1	350	2
KP4AFS428		1	285	2
		1	350	2
KP4AG27		1	285	2
		1	350	2
KP4ALY196		1	285	2
		1	350	2
KP4ASD610		1	285	2
		1	350	2
KP4A2TS		1	285	2
		1	350	2
KP6A		1	275	1
		1	355	2
KP6AFS428		1	275	1
		1	355	2
KP6AG27		1	275	1
		1	355	2
KP6A2TS		1	275	1
		1	355	2
KP6BLY196		1	275	1
		1	355	2
KP6BSD610		1	275	1
		1	355	2
LLKP23B		1	390	4
LLKP4A		1	285	2
		1	350	2
LLKP6A		1	275	1
		1	355	2
LLMKP6A		1	150	5

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
L8006K4		1	295	2
		1	320	1
MCS26E		1	150	5
MK1000-04BAC		1	50	8
MS16562-191		1	170	1
MS21209F1-15		1	100	12
		1	141	4
		1	220	14
NAS1149D0363H		1	95A	12
		1	120A	3
NAS1149D0416H		1	10A	2
NAS1149F0332P		1	45A	6
		1	190A	2
NAS1611-118A		1	400A	1
NAS600-5		1	30	8
NAS603-8		1	40	6
NAS607-3-4P		1	210	1
NAS6603-3		1	185	2
NAS6603H5		1	75	4
NAS6603H5		1	115	3
NAS6604-11		1	225A	2
NAS6604-18		1	5	2
NAS6604-29		1	250	1
NAS6604H18		1	125	3
NAS6703-3		1	90	12
NS103197-40		1	50	8
R19A		1	80	1
		1	81	1
		1	83A	1
R21A		1	80A	1
		1	81A	1
		1	83B	1
SL2822-22		1	370	2
S256T002-1		1	80	1
		1	81	1
		1	83A	1
S256T002-3		1	80A	1
		1	81A	1
		1	83B	1
T339E		1	155	1
		1	280	1
		1	405	2
T8076S440		1	50	8
256T2668-1		1	330A	1

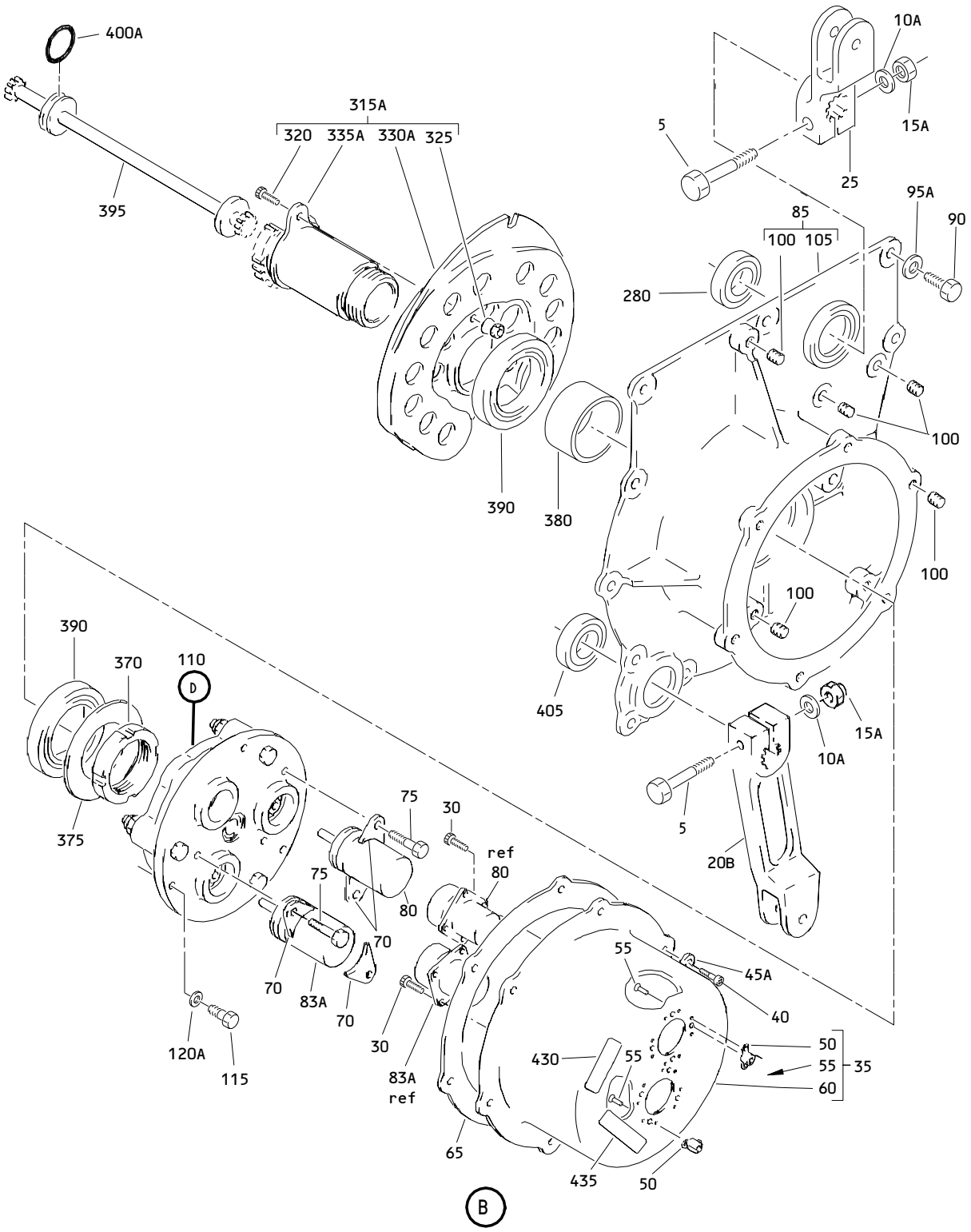
PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
256T2680-2		1	110	1
256T2680-3		1	110A	1
256T2680-4		1	110B	1
256T2681-1		1	145	1
256T2681-2		1	145A	1
256T2682-1		1	140	1
256T2682-3		1	143	1
256T2682-4		1	140A	1
256T2682-5		1	144	1
256T2683-3		1	35	1
256T2683-4		1	60	1
256T2684-2		1	165	1
256T2684-3		1	165A	1
256T2685-1		1	180	1
256T2686-2		1	175	1
256T2686-3		1	175A	1
256T2687-3		1	160	2
256T2687-4		1	160A	2
256T2688-2		1	70	4
256T2689-2		1	65	1
256T2760-4		1	1A	RF
256T2760-5		1	1B	RF
256T2760-6		1	1C	RF
256T2760-7		1	80E	1
256T2760-8		1	80F	1
256T2760-9		1	1D	RF
256T2766-1		1	305A	1
256T2767-1		1	20B	1
256T2767-3		1	20C	1
256T3103-1		1	395	1
256T3161-11		1	205A	1
256T3161-12		1	222	1
256T3161-21		1	205B	1
256T3161-22		1	222A	1
256T3163-3		1	85	1
256T3163-4		1	105	1
256T3165-3		1	315A	1
256T3167-1		1	335A	1
256T3168-3		1	420	1
256T3169-1		1	415	1
256T3169-3		1	415A	1
256T3173-1		1	360	2
256T3177-1		1	25	1
256T3177-3		1	25A	1
256T3178-1		1	245	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
256T3179-1		1	380	1
256T3179-2		1	385	1
256T3180-1		1	375	2
256T3181-5		1	290A	1
256T3183-2		1	310	1
256T3184-2		1	235A	2
256T3187-1		1	270	1
256T3188-1		1	365	1
256T3189-1		1	270A	1
256T3190-1		1	365A	1
3A1-260A		1	83C	1
65B81978-1		1	200	1
65B81978-4		1	200A	1
66014-6		1	300	2
		1	325	1
82631-2212		1	370	2



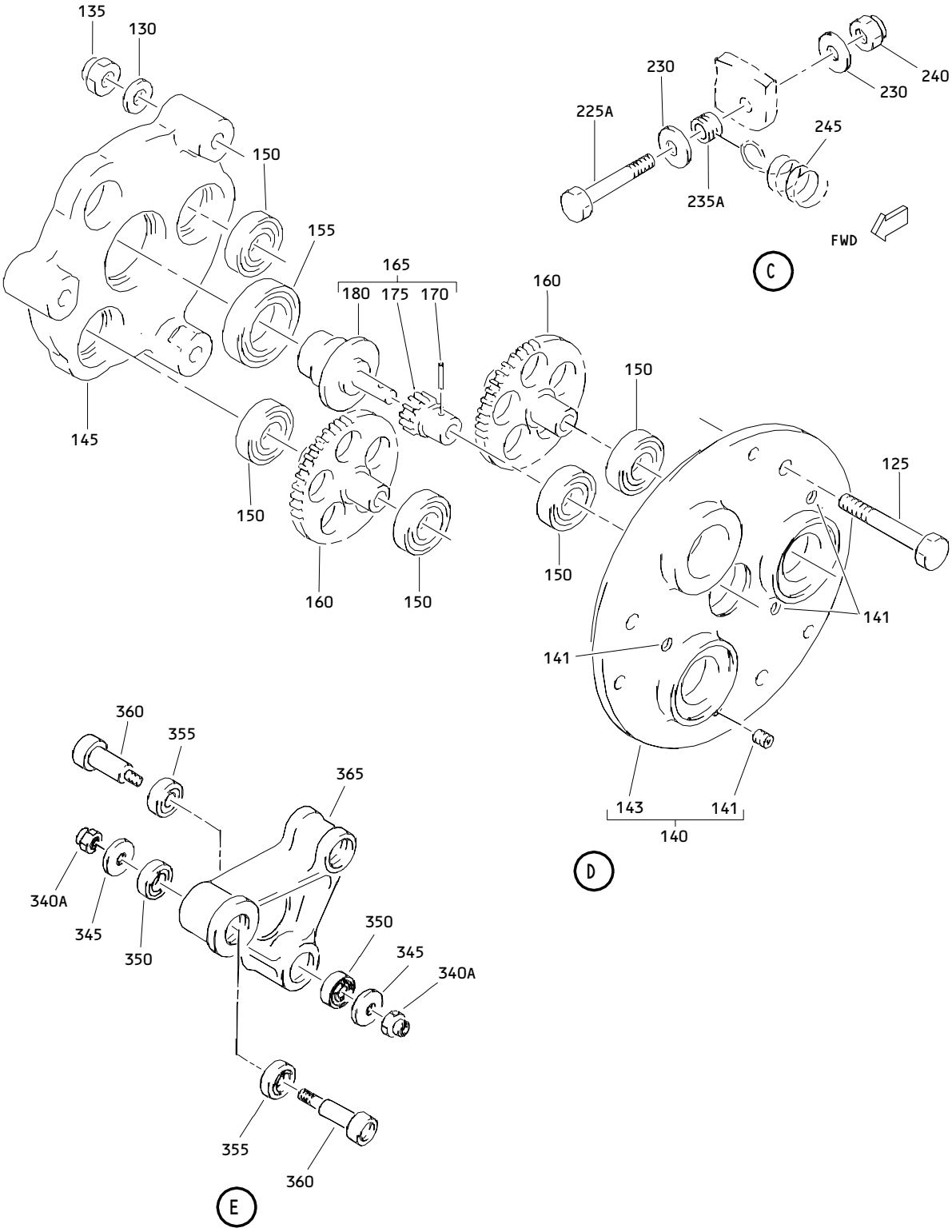
Outboard Leading Edge Slat Drive Control Unit Assembly
Figure 1 (Sheet 1)

T77452



Outboard Leading Edge Slat Drive Control Unit Assembly
Figure 1 (Sheet 2)

T77453



Outboard Leading Edge Slat Drive Control Unit Assembly
Figure 1 (Sheet 3)

T77454

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	-1	256T2760-2		DELETED		
R	-1A	256T2760-4		UNIT ASSY-OUTBD LE SLAT DRIVE CONT (PRE SB 27-0108R3)	A	RF
R	-1B	256T2760-5		UNIT ASSY-OUTBD LE SLAT DRIVE CONT	B	RF
R	-1C	256T2760-6		UNIT ASSY-OUTBD LE SLAT DRIVE CONT (POST SB 27-0108R3)	C	RF
R	-1D	256T2760-9		UNIT ASSY-OUTBD LE SLAT DRIVE CONT	D	RF
R	5	NAS6604-18		.BOLT		2
	10	AN960D416L		DELETED		
R	10A	NAS1149D0416H		.WASHER		2
	15	BACN10JC4		DELETED		
R	15A	BACN10JC4CD		.NUT		2
	20	256T2765-1		DELETED		
	-20A	256T2765-3		DELETED		
R	20B	256T2767-1		.ARM-PILOT INPUT (OPT ITEM 20C)		1
R	-20C	256T2767-3		.ARM-PILOT INPUT (OPT ITEM 20B)		1
R	25	256T3177-1		.ARM-VALVE INPUT (OPT ITEM 25A)		1
R	-25A	256T3177-3		.ARM-VALVE INPUT (OPT ITEM 25)		1
R	30	NAS600-5		.SCREW		8
R	35	256T2683-3		.COVER ASSY-POSITION SENSOR ATTACHING PARTS		1
R	40	NAS603-8		.SCREW		6
	45	AN960-10L		DELETED		
R	45A	NAS1149F0332P		.WASHER		6
				-------*-------		

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
R	50	BRM200A04L		..NUTPLATE- (V52828) (SPEC BACN10JP04A) (OPT MK1000-04BAC (V15653)) (OPT NS103197-40 (V80539)) (OPT T8076S440 (V71087)) (OPT T8076S440 (V11815)) (OPT VN202A1-40L (V92215))		8
R	55	BACR15BA3AD		..RIVET- (SIZE DETERMINE ON INST)		16
R	60	256T2683-4		..COVER		1
R	65	256T2689-2		.GASKET		1
R	70	256T2688-2		.CLAMP		4
R	75	NAS6603H5		.BOLT		4
R	80	R19A		.TRANSFORMER-ROTARY VAR DIFF (V19710) (SPEC S256T002-1) (OPT ITEM 80A)	A,B,D	1
R	-80A	R21A		.TRANSFORMER-ROTARY VAR DIFF (V19710) (SPEC S256T002-3) (OPT ITEM 80)	A,B,D	1
	80B	Y35A		DELETED		
	80C	R19A		DELETED		
	80D	R21A		DELETED		
R	-80E	256T2760-7		.KIT ASSY-SUBSTITUTION (OPT ITEM 80F)	C	1
R	-80F	256T2760-8		.KIT ASSY-SUBSTITUTION (OPT ITEM 80E)	C	1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
R	-81	R19A		..TRANSFORMER-ROTARY VAR DIFF (V19710) (SPEC S256T002-1) (USED ON ITEM 80E)	C	1
R	-81A	R21A		..TRANSFORMER-ROTARY VAR DIFF (V19710) (SPEC S256T002-3) (USED ON ITEM 80F)	C	1
	81B	Y35A		DELETED		
	81C	3A1-260A		DELETED		
	83	BACC45FM14C7P		DELETED		
R	83A	R19A		.TRANSFORMER-ROTARY VAR DIFF (V19710) (SPEC S256T002-1) (OPT ITEM 83B)	A,B	1
R	-83B	R21A		.TRANSFORMER-ROTARY VAR DIFF (V19710) (SPEC S256T002-3) (OPT ITEM 83A)	A,B	1
R	-83C	3A1-260A		.TRANSFORMER-ROTARY VAR DIFF (M548) (V19710) (SPEC S256T002-11)	C,D	1
R	85	256T3163-3		.COVER ASSY-HSG ATTACHING PARTS		1
R	90	NAS6703-3		.BOLT		12
	95	AN960D10		DELETED		
R	95A	NAS1149D0363H		.WASHER -------*-------		12

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
R	100	MS21209F1-15		..INSERT		12
R	105	256T3163-4		..COVER		1
R	110	256T2680-2		.SENSOR ASSY- (REPLD BY ITEM 110A)	A	1
R	-110A	256T2680-3		.SENSOR ASSY- (REPLS ITEM 110)	A	1
R	-110B	256T2680-4		.SENSOR ASSY	B	1
R	-110C	256T2680-3		.SENSOR ASSY- (OPT ITEM 10D)	C,D	1
R	-110D	256T2680-2		.SENSOR ASSY- (OPT ITEM 10C) ATTACHING PARTS	C,D	1
R	115	NAS6603H5		.BOLT		3
	120	AN960D10		DELETED		
R	120A	NAS1149D0363H		.WASHER -------*-------		3
R	125	NAS6604H18		..BOLT		3
R	130	AN960-416		..WASHER		3
R	135	BACN10JC4		..NUT		3
R	140	256T2682-1		..PLATE ASSY-SPRT (USED ON ITEM 110)	A,C,D	1
R	-140A	256T2682-4		..PLATE ASSY-SPRT (USED ON ITEMS 110A, 110B)		1
R	141	MS21209F1-15		...INSERT		4
	-142	MS21209F1-13		DELETED		
R	143	256T2682-3		...PLATE- (USED ON ITEM 140)	A,C,D	1
R	-144	256T2682-5		...PLATE- (USED ON ITEM 140A)		1
R	145	256T2681-1		..RING-BRG SPRT (USED ON ITEM 110)	A,C,D	1
R	-145A	256T2681-2		..RING-BRG SPRT (USED ON ITEMS 110A, 110B)		1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
R	150	MKP6A		..BEARING- (V38443) (SPEC BACB10AP6) (OPT LLMKP6A (V38443)) (OPT MKP6AFS428 (V21335)) (OPT MKP6ATT (V43991)) (OPT MKP6A2TS (V43991)) (OPT MKP6E6531 (V21335)) (OPT MKP6AG20 (V38443)) (OPT MKP6ALY196 (V40920)) (OPT MKP6A (V38443)) (OPT MCS26E (VK8455))		5
R	155	B539FS101		..BEARING- (V06144) (SPEC BACB10CF12PP) (OPT B539DDFS101 (V06144)) (OPT T339E (VK8455)) (OPT B539SSG27 (V30163)) (OPT B539DDFS428 (V21335)) (OPT B539DD (V38443)) (OPT B539-2TS (V43991))		1
R	160	256T2687-3		..GEAR AND SPLINE	A,C,D	2
R	-160A	256T2687-4		..GEAR AND SPLINE	B	2
R	165	256T2684-2		..SHAFT ASSY-SPLINE	A,C,D	1
R	-165A	256T2684-3		..SHAFT ASSY-SPLINE	B	1
R	170	MS16562-191		...PIN-SPR		1
R	175	256T2686-2		...GEAR-INPUT PINION	A,C,D	1
R	-175A	256T2686-3		...GEAR-INPUT PINION	B	1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
R	180	256T2685-1		...SHAFT		1
R	185	NAS6603-3		.BOLT		2
	190	AN960-10L		DELETED		
R	190A	NAS1149F0332P		.WASHER		2
R	200	65B81978-1		.COVER-DRAIN (OPT ITEM 200A)		1
R	-200A	65B81978-4		.COVER-DRAIN (OPT ITEM 200)		1
	205	256T0161-11		DELETED		
R	205A	256T3161-11		.HOUSING ASSY	A-C	1
R	-205B	256T3161-21		.HOUSING ASSY	D	1
R	210	NAS607-3-4P		..PIN-DOWEL		1
R	215	BACB28AP04P032		..BUSHING		2
R	218	BACB28W6B022		..BUSHING		2
R	220	MS21209F1-15		..INSERT		14
R	222	256T3161-12		..HOUSING	A-C	1
R	-222A	256T3161-22		..HOUSING	D	1
	225	NAS6604-20		DELETED		
R	225A	NAS6604-11		.BOLT		2
R	230	BACW10P11AL		.WASHER		4
	235	256T3184-1		DELETED		
R	235A	256T3184-2		.SPACER-SPR		2
	240	BACN10JC4		DELETED		
R	240A	BACN10JC4CD		.NUT		2
R	245	256T3178-1		.SPRING		1
R	250	NAS6604-29		.BOLT		1
R	255	BACB28AK04-089		.BUSHING		1
R	260	BACB28AK04-025		.BUSHING		1
	265	BACN10JC4		DELETED		
R	265A	BACN10JC4CD		.NUT		1
R	270	256T3187-1		.SHAFT- (OPT ITEM 270A)		1
R	-270A	256T3189-1		.SHAFT- (OPT ITEM 270)		1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R	01-275	KP6AFS428		.BEARING- (V21335) (SPEC BACB10BX6) (OPT KP6A2TS (V43991)) (OPT LLKP6A (V38443)) (OPT KP6AG27 (V30163)) (OPT KP6A (V38443)) (OPT KP6BLY196 (V40920)) (OPT KP6BSD610 (V83086)) (OPT CS206E (VK8455))		1
R	280	B539FS101		.BEARING- (V06144) (SPEC BACB10CF12PP) (OPT B539DDFS101 (V06144)) (OPT T339E (VK8455)) (OPT B539SSG27 (V30163)) (OPT B539DDFS428 (V21335)) (OPT B539DD (V38443)) (OPT B539-2TS (V43991))		1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
R	285	KP4AFS428		.BEARING- (V21335) (SPEC BACB10BX4) (OPT KP4A2TS (V43991)) (OPT LLKP4A (V38443)) (OPT KP4AG27 (V30163)) (OPT KP4A (V38443)) (OPT KP4ALY196 (V40920)) (OPT KP4ASD610 (V83086)) (OPT CS204E (VK8455))		2
	290	256T3181-2		DELETED		
R	290A	256T3181-5		.CAM ASSY-FOLLOWUP		1
R	295	HL10VAZ6-4		..BOLT- (V60516) (SPEC BACB30MY6K4) (OPT HL10VAZ6-4 (VOPTK6)) (OPT HL10VAZ6-4 (V92215)) (OPT HL10VAZ6-4 (V97928)) (OPT L8006K4 (V06725)) (OPT HL10VAZ6-4 (V08524))		2

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
R	300	HL79-6		..COLLAR- (V56878) (SPEC BACC30M6) (OPT HL79-6 (V73197)) (OPT HL79-6 (V92215)) (OPT 66014-6 (V56878))		2
	305	256T2764-1		DELETED		
R	305A	256T2766-1		..CAM		1
R	310	256T3183-2		..SHAFT		1
	315	256T3165-1		DELETED		
R	315A	256T3165-3		.CAM ASSY-INPUT		1
R	320	HL10VAZ6-4		..BOLT- (V60516) (SPEC BACB30MY6K4) (OPT HL10VAZ6-4 (VOPTK6)) (OPT HL10VAZ6-4 (V92215)) (OPT HL10VAZ6-4 (V97928)) (OPT L8006K4 (V06725)) (OPT HL10VAZ6-4 (V08524))		1
R	325	HL79-6		..COLLAR- (V56878) (SPEC BACC30M6) (OPT HL79-6 (V73197)) (OPT HL79-6 (V92215)) (OPT 66014-6 (V56878))		1
	330	256T2662-1		DELETED		
R	330A	256T2668-1		..CAM		1
	335	256T3167		DELETED		
R	335A	256T3167-1		..SHAFT		1
	340	BACN10JC4		DELETED		
R	340A	BACN10JC4CD		.NUT		2
R	345	BACW10P231D		.WASHER		2

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
R	350	KP4AFS428		.BEARING- (V21335) (SPEC BACB10BX4) (OPT KP4A2TS (V43991)) (OPT LLKP4A (V38443)) (OPT KP4AG27 (V30163)) (OPT KP4A (V38443)) (OPT KP4ALY196 (V40920)) (OPT KP4ASD610 (V83086)) (OPT CS204E (VK8455))		2
R	355	KP6AFS428		.BEARING- (V21335) (SPEC BACB10BX6) (OPT KP6A2TS (V43991)) (OPT LLKP6A (V38443)) (OPT KP6AG27 (V30163)) (OPT KP6A (V38443)) (OPT KP6BLY196 (V40920)) (OPT KP6BSD610 (V83086)) (OPT CS206E (VK8455))		2
R	360	256T3173-1		.FOLLOWER-CAM		2
R	365	256T3188-1		.LEVER-SUMMING (OPT ITEM 365A)		1
R	-365A	256T3190-1		.LEVER-SUMMING (OPT ITEM 365)		1
R	370	SL2822-22		.NUT- (V97393) (SPEC BACN10RF22) (OPT 82631-2212 (V56878))		2
R	375	256T3180-1		.WASHER		2

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
R	380	256T3179-1		.SPACER-BRG (MFD FROM TUBING AL 2024-T3 WW-T-700/3 F-18.13 1.625 IN 0.058 W X 1.1 IN LG)		1
R	385	256T3179-2		.SPACER-BRG (MFD FROM TUBING AL 2024-T3 WW-T-700/3 F-18.13 1.625 IN .058 WALL X 1.5 IN LG)		1
R	390	KP23B		.BEARING- (V38443) (SPEC BACB10BW23) (OPT KP23B2TS (V43991)) (OPT LLKP23B (V38443)) (OPT KP23BG27 (V30163)) (OPT KP23BFS428 (V21335)) (OPT KP23BLY196 (V40920)) (OPT KP23BSD610 (V83086))		4
R	395	256T3103-1		.SHAFT-QUILL SENSOR		1
	400	NAS1611-118		DELETED		
R	400A	NAS1611-118A		.PACKING		1
R	405	B539FS101		.BEARING- (V06144) (SPEC BACB10CF12PP) (OPT B539DDFS101 (V06144)) (OPT T339E (VK8455)) (OPT B539SSG27 (V30163)) (OPT B539DDFS428 (V21335)) (OPT B539DD (V38443)) (OPT B539-2TS (V43991))		2

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
R	410	BACW10P149AL		.WASHER		1
R	415	256T3169-1		.GEAR-INPUT SECTOR (OPT ITEM 415A)		1
R	-415A	256T3169-3		.GEAR-INPUT SECTOR (OPT ITEM 415)		1
R	420	256T3168-3		.SHAFT-INPUT		1
R	425	BAC27TCT0002		.MARKER- (OPT ITEM 425A)		1
R	-425A	BAC27ECT58		.MARKER- (OPT ITEM 425)		1
R	430	BAC27TCT0280		.MARKER-ALUMINUM FOIL-M544 XMTR NO. 1-PDU POSITION-INBD SLATS		1
R	435	BAC27TCT0282		.MARKER-ALUMINUM FOIL-M548 XMTR NO. 2-PDU POSITION-OUTBD SLATS		1

- Item Not Illustrated