TO: ALL HOLDERS OF FIXED LEADING EDGE AT NACELLE KRUEGER SEAL DRIVE MECHANISM ASSEMBLY COMPONENT MAINTENANCE MANUAL 27-81-96

REVISION NO. 2 DATED NOV 01/99

HIGHLIGHTS

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

CHAPTER/SECTION AND PAGE NO.	DESCRIPTION OF CHANGE
TITLE PAGE 1 801-804 1004-1013,1017-1034	Added 114T6400-13, -14 top assemblies, with optional lever assembly now standard.
TITLE PAGE 1 REPAIR 4-1 601 1004-1013,1017-1034	Added 114T6450-7, -8 top assemblies, with new bearing in link assembly.
TR & SB RECORD 1 CONTENTS 1 INTRODUCTION 1 DESCRIPTION & OPERATION 1 301 501 REPAIR-GEN 601	Sent page without technical change.

CHAPTER/SECTION AND PAGE NO.	DESCRIPTION OF CHANGE
REPAIR 1-1 601 REPAIR 2-1 601 REPAIR 2-2 601 REPAIR 3-1 601 REPAIR 5-1 601-602 REPAIR 5-2 601 REPAIR 6-1 601 REPAIR 6-2 601 701 1001	HIGHLIGHT CONTINUED FROM PREVIOUS PAGE
REPAIR-GEN 602-603	Updated True Position Dimensioning Symbols.
REPAIR 7-1 601	Changed finish on part.
1002	Updated Vendors List.

BOEING

COMPONENT
MAINTENANCE MANUAL

FIXED LEADING EDGE AT NACELLE KRUEGER SEAL DRIVE MECHANISM ASSEMBLY

PART NUMBERS 114T6400-5,-6,-9,-10,-13,-14 114T6450-3,-4,-7,-8

COMPONENT MAINTENANCE MANUAL
WITH
ILLUSTRATED PARTS LIST

58630

BOEING
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
		PRR B10012	OCT 10/82
		PRR B10450	OCT 10/82
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*[1] Special instructions not required. Use standard industry practices and information contained in 20-30-01 and 20-30-03.

INTRODUCTION

The instructions in this manual provide the information necessary to perform maintenance functions including test, fault isolation, and replacement of defective components.

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.

FIXED LEADING EDGE AT NACELLE KRUEGER SEAL DRIVE MECHANISM ASSEMBLY

DESCRIPTION AND OPERATION

1. The Krueger seal drive mechanism consists of two aluminum alloy lever assemblies and four aluminum alloy link assemblies. The two lever assemblies are anchored at one end to the leading edge structure. The link assemblies are attached to the lever assemblies and to the rotary actuator and the Krueger seal assembly.

2. The mechanism assembly translates the angular rotation of the rotary actuator to the Krueger seal assembly during extension and retraction of the leading edge slat system.

3. Leading Particulars (Approximate)

   Length -- 6 inches (folded)
   Height -- 9 inches (folded)
   Width -- 4 inches
   Weight -- 4 pounds

DISASSEMBLY

NOTE: Disassemble this component only as necessary to complete fault isolation, determine the serviceability of parts, perform required repairs, and restore the unit to serviceable condition.

1. Disassemble the drive mechanism assembly using standard industry practices.

CHECK

1. Check all parts for obvious defects in accordance with standard industry practices. Refer to Fits and Clearances for design dimensions.

2. Penetrant check per 20-20-02 -- levers (50, 50A, 255), links (70, 125, 170, 220).

3. Magnetic particle check lever (50B), links (70A, 70B, 125A, 170A) per 20-20-01.

REPAIR - GENERAL

1. Content

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

P/N	NAME	REPAIR
114T6401	LEVER	1-1
114T6410	LEVER	1-1
114T6427	LEVER	1-1
114T6402	LEVER	2-1, 2-2
114T6425	LEVER	2-1
114T6403	LINK	3-1
114T6424	LINK	4-1
114T6404	LINK	4-1
114T6422	LINK	4-1
114T6407	LINK	5-1, 5-2
114T6423	LINK	5-1
114T6408	LINK	6-1, 6-2
114T6426	LEVER	6-1
--	MISCELLANEOUS PARTS REFINISH	7-1

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 Finish
20-50-12 Application of Adhesives

3. Materials

NOTE: Equivalent substitutes may be used.

A. Primer -- BMS 10-11, Type 1 (Ref 20-60-02)

B. Enamel -- BMS 10-60, Color Gray Gloss (BAC707) (Ref 20-60-02)

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

D. Grease -- BMS 3-24 (Ref 20-60-03)

4. Dimensioning Symbols

A. Standard True Position Dimensioning Symbols used in the 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

58632

LEVER ASSEMBLY - REPAIR 1-1

114T6401-1
114T6410-1
114T6427-1

NOTE: Refer to REPAIR-GENERAL for list of applicable standard practices. For repair of surfaces which may only require restoration of original finish, refer to Refinish instructions. For item numbers, refer to IPL Fig. 1.

1. Bushing Replacement; 114T6401-1, 114T6410-1 only

   A. Remove bushings.

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

   C. Fillet seal bushing flanges with sealant, BMS 5-95.

2. Bushing Replacement; 114T6427-1 only (Fig. 601)

   A. Remove bushings.

   B. Coat lever ID with BMS 3-24 grease.

   C. Install replacement bushings using shrink-fit method. Refer to 20-50-03.

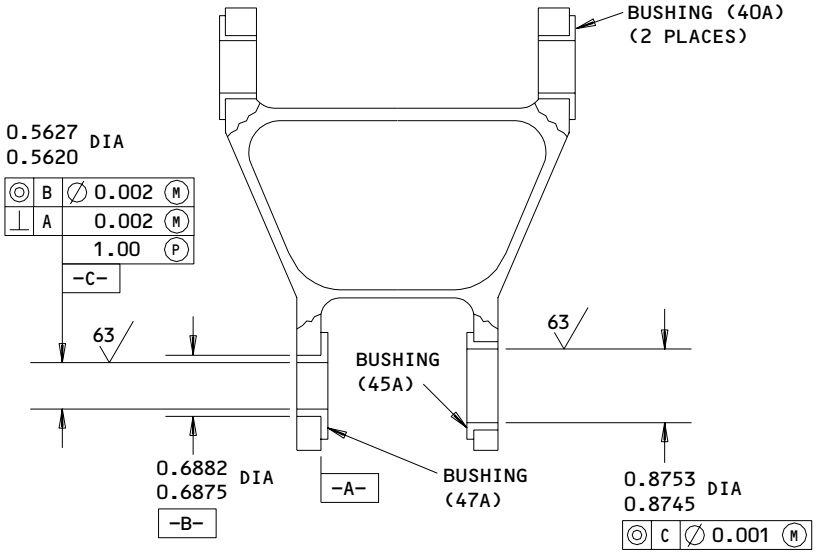
   D. Machine bushings ID to dimension and finish shown.

   E. Seal bushing flanges with sealant.

3. Refinish

   A. Lever (50, 50A) -- Chromic acid anodize and apply one coat of primer, BMS 10-11, type 1 (F-18.13), then apply enamel, BMS 10-60, gloss color gray (707) (SRF-14.9813), except omit primer and enamel in bores for bushings. Material: Al alloy.

   B. Lever (50B) -- Fig. 601



REFINISH

LEVER (50B) -- ABRASIVE BLAST CLEAN PER 20-30-03 THEN PASSIVATE (F-17.09) ALL OVER. APPLY ONE COAT BMS 10-11, TYPE 1, PRIMER (F-20.02) AND APPLY BMS 10-60 GRAY GLOSS ENAMEL (SRF-14.9813) ALL OVER, EXCEPT OMIT PRIMER AND ENAMEL FROM BUSHING HOLES

MATERIAL: 15-5PH CRES (150-170 KSI)

ALL DIMENSIONS ARE IN INCHES

114T6427-1
Bushing Replacement
Figure 601

290064

LEVER ASSEMBLY - REPAIR 2-1

114T6402-1
114T6425-1

NOTE: Refer to REPAIR-GENERAL for a list of applicable standard practices. For repair of surfaces which may only require restoration of original finish, refer to Refinish instructions, Fig. 601. For item numbers, refer to IPL Fig. 1.

1. Bushing Replacement (Fig. 601)

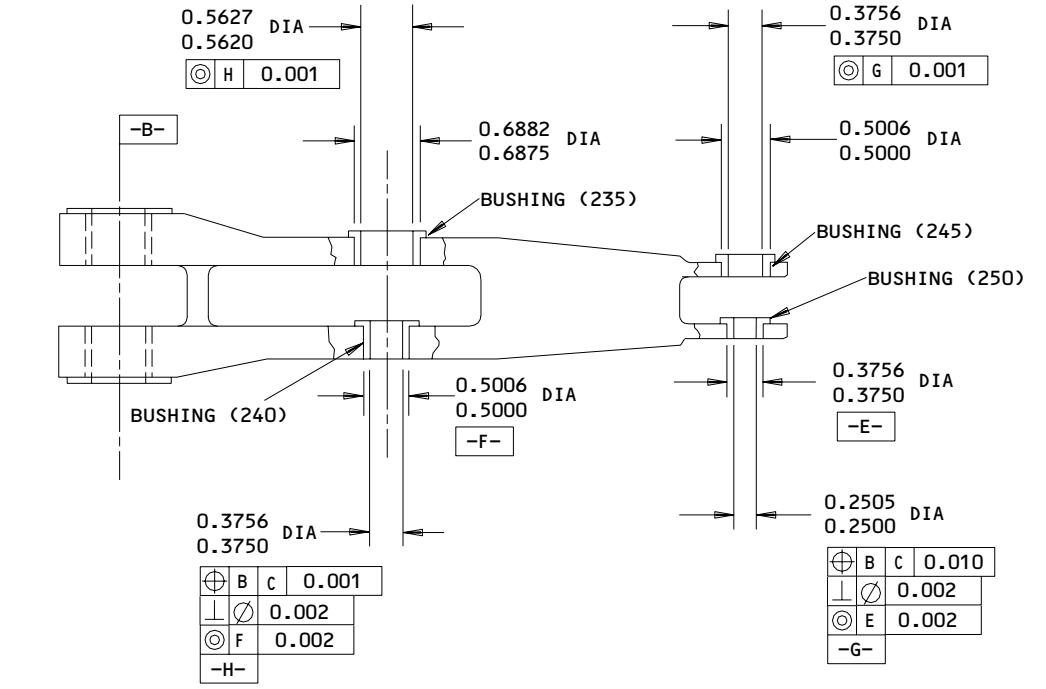
A. Remove bushings.

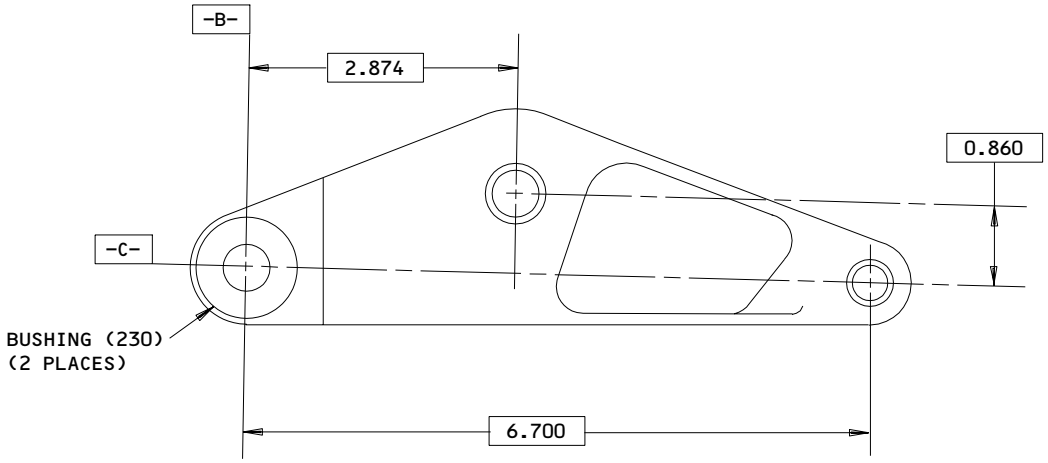
B. 114T6402-1 only: If corrosion or damage exists in bore refer to REPAIR 2-2 for repair procedures.

C. Install replacement bushings per 20-50-03, except use wet sealant.

D. Machine bushing ID to dimension shown.

E. Fillet seal bushings flanges with sealant.



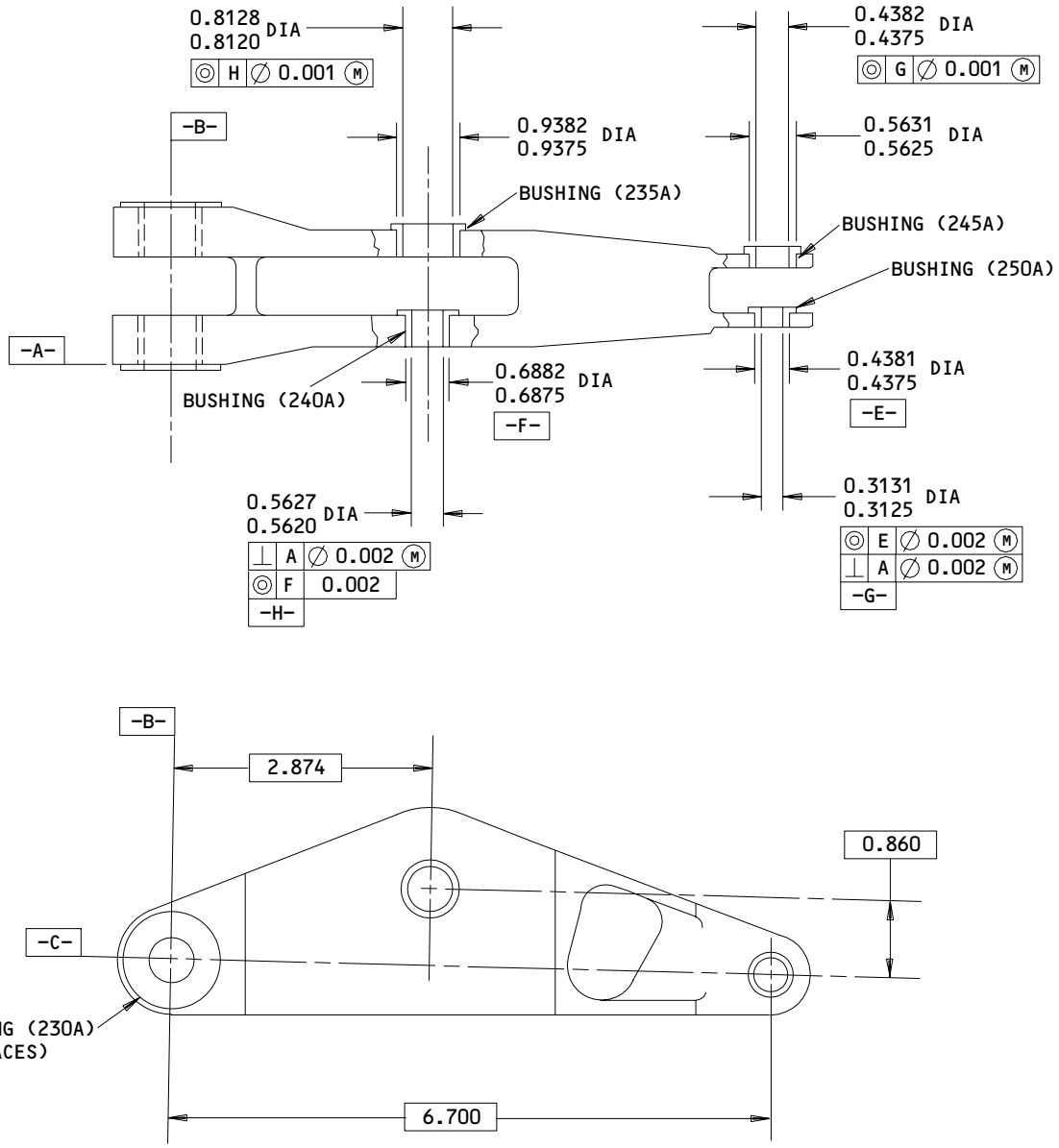


114T6402-1 SHOWN

REFINISH

CHROMIC ACID ANODIZE AND APPLY 1 COAT OF PRIMER (F-18.13) PLUS APPLY ENAMEL, BMS 10-60 (SRF-14.9813) ALL OVER EXCEPT OMIT PRIMER AND ENAMEL IN BORES FOR BUSHING

114T6402-1
114T6425-1
Bushing Replacement
Figure 601 (Sheet 1)



114T6425-1 SHOWN

REFINISH

CHROMIC ACID ANODIZE AND APPLY 1 COAT OF PRIMER (F-18.13) PLUS APPLY ENAMEL, BMS 10-60 (SRF-14.9813) ALL OVER EXCEPT OMIT PRIMER AND ENAMEL IN BORES FOR BUSHING

125 MACHINED SURFACES EXCEPT AS NOTED

ALL DIMENSIONS ARE IN INCHES

114T6402-1
114T6425-1
Bushing Replacement
Figure 601 (Sheet 2)

LEVER - REPAIR 2-2

114T6402-2

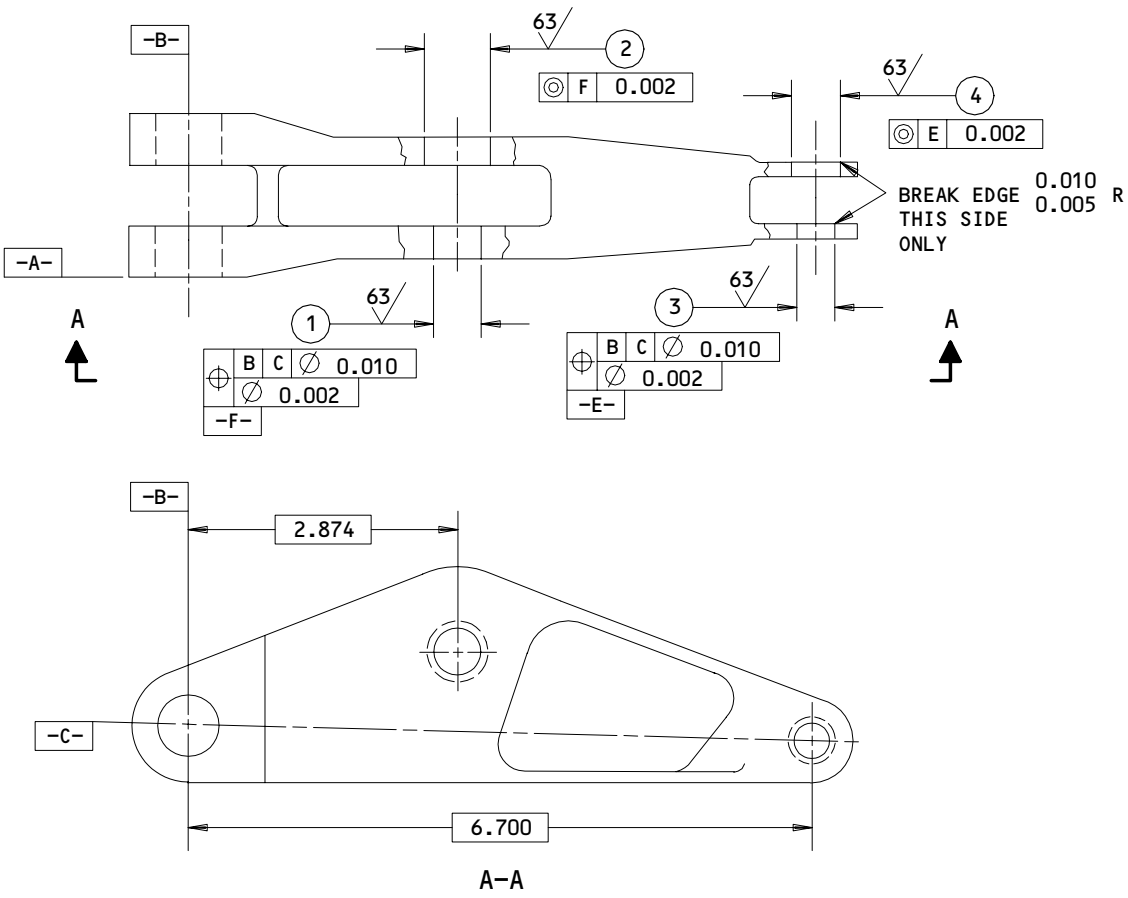
NOTE: Refer to REPAIR-GENERAL for a list of applicable standard practices. For repair of surfaces which may only require stripping and restoration of original finish, refer to Refinish instructions, Fig. 601.

1. Installation of Oversize Bushing (Fig. 601)

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

B. Manufacture bushings (Fig. 602), as required, to compensate for the amount of material removed.

C. Install bushing per REPAIR 2-1.



A-A

HOLE LOCATION	DESIGN DIA	REPAIR DIA 1
1	0.5006 0.5000	0.5606
2	0.6882 0.6875	0.7482
3	0.3756 0.3750	0.4356
4	0.5006 0.5000	0.5606

1 MAX REPAIR DIA FOR INSTALLATION OF OVERSIZE BUSHING

REPAIR

REF 1

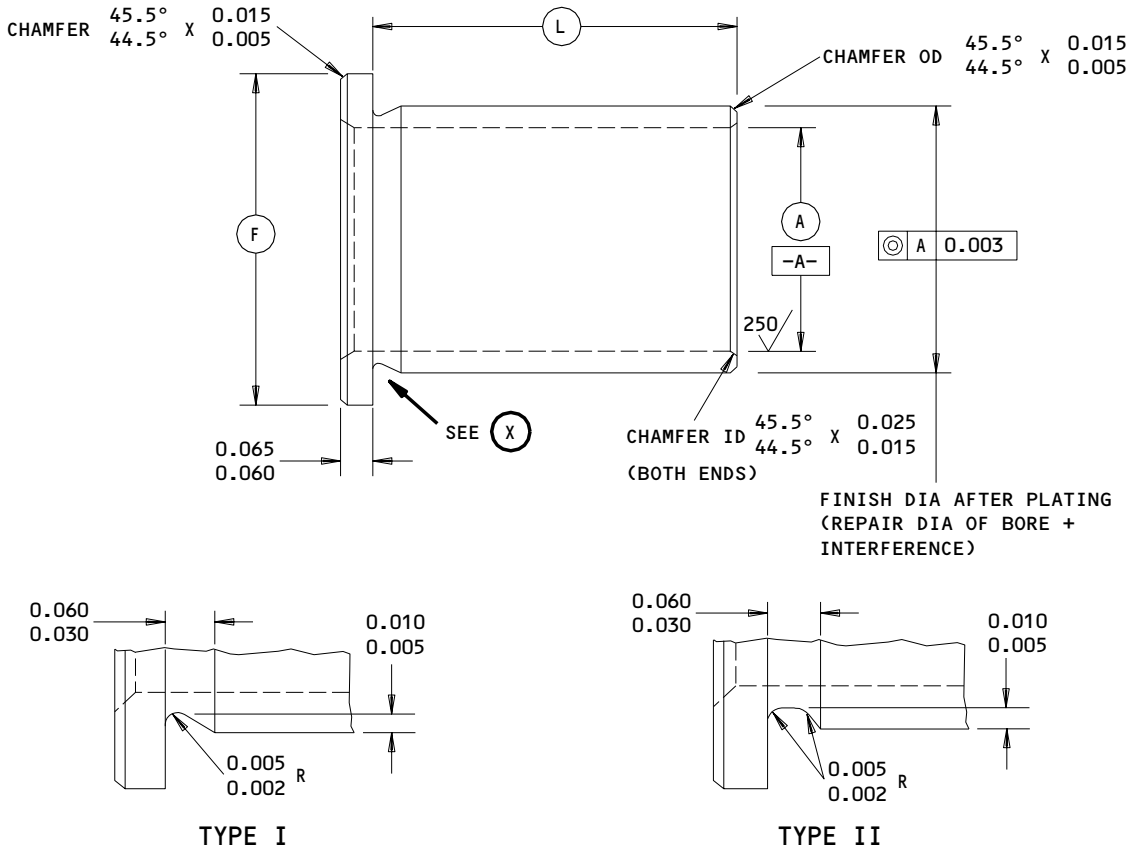
125 OR BETTER ALL MACHINED SURFACES EXCEPT AS NOTED

BREAK ALL SHARP EDGES 0.020 / 0.010 R

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

114T6402-2
Lever Repair
Figure 601



TYPE I OR TYPE II UNDERCUT OPTIONAL
NO UNDERCUT REQUIRED FOR BUSHING AT HOLE
LOCATION (3) (FIG. 601)

(X)

HOLE LOCATION (FIG. 601)	(A)	(L)	(F)	INTERFERENCE
(1)	0.366 0.359	0.300 0.295	0.710 0.700	0.0016 0.0004
(3)	0.241 0.234	0.140 0.135	0.540 0.530	0.0015 0.0003

ALL DIMENSIONS ARE IN INCHES

DIMENSIONS APPLY AFTER PLATING

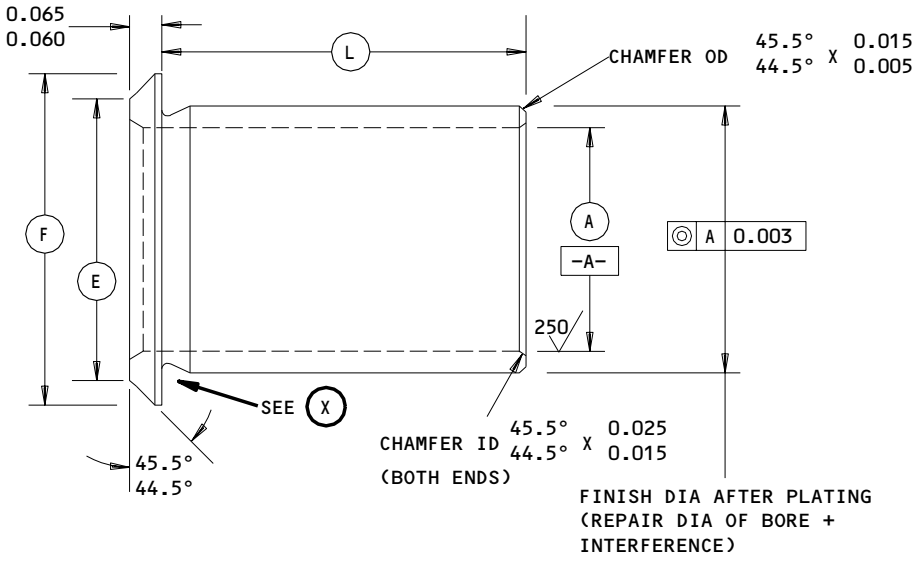
MATERIAL: 15-5 PH CRES PER AMS 5639, 180-200 KSI

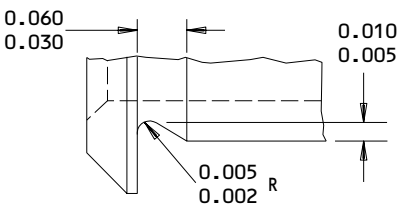
63 OR BETTER ON ALL MACHINED SURFACES EXCEPT AS NOTED

BREAK SHARP EDGES 0.008 R

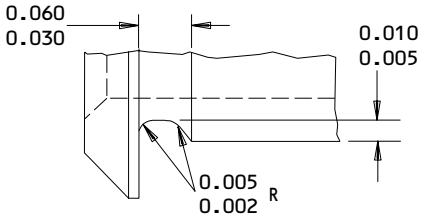
CADMIUM PLATE (F-15.06). PLATING IN BORE OPTIONAL

Oversize Bushing Details
Figure 602 (Sheet 1)





TYPE I



TYPE II

TYPE I OR TYPE II UNDERCUT OPTIONAL
UNDERCUT NOT REQUIRED FOR BUSHING
AT HOLE LOCATION (4) (FIG. 601)

(X)

HOLE LOCATION (FIG. 601)	(A)	(L)	(E)	(F)	INTERFERENCE
(2)	0.553 0.547	0.300 0.295	0.710 0.700	0.810 0.800	0.0019 0.0005
(4)	0.366 0.359	0.140 0.135	0.540 0.530	0.630 0.620	0.0016 0.0004

DIMENSIONS APPLY AFTER PLATING

ALL DIMENSIONS ARE IN INCHES

MATERIAL: AL-NI-BR PER AMS 4640

63 OR BETTER ON ALL MACHINED SURFACES EXCEPT AS NOTED

BREAK ALL SHARP EDGES 0.008 R

CADMIUM PLATE (F-15.06). PLATING IN BORE OPTIONAL

Oversize Bushing Details
Figure 602 (Sheet 2)

LINK ASSEMBLY - REPAIR 3-1

114T6403-1, -3
114T6424-1

NOTE: Refer to REPAIR-GENERAL for a list of applicable standard practices. For repair of surfaces which may only require restoration of original finish, refer to Refinish instructions.

1. Bearing Replacement

   A. On 114T6425-1 assembly, remove washers (67).

   B. Remove bearings.

   C. Install replacement bearings and roller swage per 20-50-03.

   D. Install washers (67), as required, and bond per 20-50-12, type 44.

2. Refinish

   A. Link (70, IPL Fig. 1) -- Chromic acid anodize and apply one coat of primer, BMS 10-11, type 1 (F-18.13), then apply enamel BMS 10-60, gloss, color gray (BAC 707) (SRF-14.9813), except omit primer and enamel in bores for bearings. Material: Al alloy.

   B. Link (70A, 70B, IPL Fig. 1) -- Passivate (F-17.09) all over and apply one coat of primer (abrasive blast clean only per 20-30-03) (F-20.02) and apply enamel BMS 10-60, gloss, color gray (BAC 707) (SRF-14.9813), except omit primer and enamel in bores for bearings. Material: 15.5PH CRES 180-200 ksi.

LINK ASSEMBLY - REPAIR 4-1

114T6404-1
114T6422-1, -3

NOTE: Refer to REPAIR-GENERAL for a list of applicable standard practices. For repair of surfaces which may only require restoration of original finish, refer to Refinish instructions.

1. Bearing Replacement

A. On 114T6422-1, -3 assemblies, remove washers (217).

B. Remove bearings.

C. Install replacement bearings and roller swage per 20-50-03.

D. Install washers (217), as required, and bond per 20-50-12, type 44.

2. Refinish

A. Link (220) -- Chromic acid anodize and apply one coat of primer, BMS 10-11, type 1 (F-18.13), then apply enamel, BMS 10-60, gloss, color gray (BAC 707) (SRF-14.9813), except omit primer and enamel in bores for bearings. Material: Al alloy.

LINK ASSEMBLY - REPAIR 5-1

114T6407-1
114T6423-1

NOTE: Refer to REPAIR-GENERAL for a list of applicable standard practices. For repair of surfaces which may only require restoration of original finish, refer to Refinish instructions , Fig. 601 or Fig. 602 in REPAIR 5-2. For item numbers, refer to IPL Fig. 1.

1. Bushing (115) Replacement; 114T6407-1 only (Fig. 601)

   A. Remove bushings.

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

   C. Fillet seal bushing flanges with sealant.

2. Bushings (105, 110) Replacement; 114T6407-1 only (Fig. 601)

   A. Remove bushings (105, 110) as applicable.

   B. If corrosion exists in bores of bushing (105) or link (120), refer to REPAIR 5-2 for repair procedures.

   C. Install bushing (105) per 20-50-03, excetp use wet sealant.

   D. Machine bushing (105 ID to dimension and finish shown.

   E. Install bushing (110) inside bushing (105) per 20-50-03, except use wet sealant.

   F. Machine bushing (110 ID to dimension and finish shown.

   G. Fillet seal bushing flanges with sealant.

3. Bushing (115A) Replacement; 114T6423-1 only (Fig. 602)

   A. Remove bushings.

   B. Coat link ID with BMS 3-24 grease.

   C. Install replacement bushings using the shrink-fit method.

   D. Seal bushing flanges.

4. Bushing (105A, 110A) Replacement; 114T6423-1 only (Fig. 602)

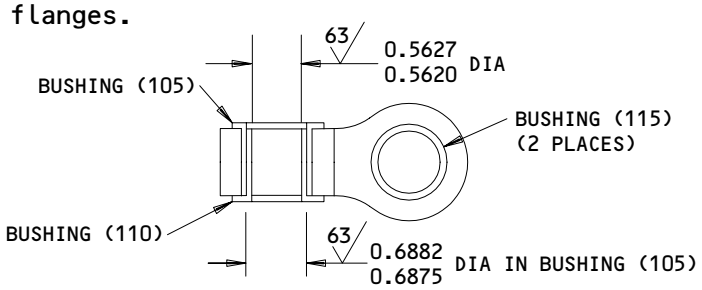
   A. Remove bushings.

   B. Coat link ID with BMS 3-24 grease.

C. Install replacement bushings using the shrink-fit method. Refer to 20-50-03.

D. Machine bushings ID to dimension and finish shown.

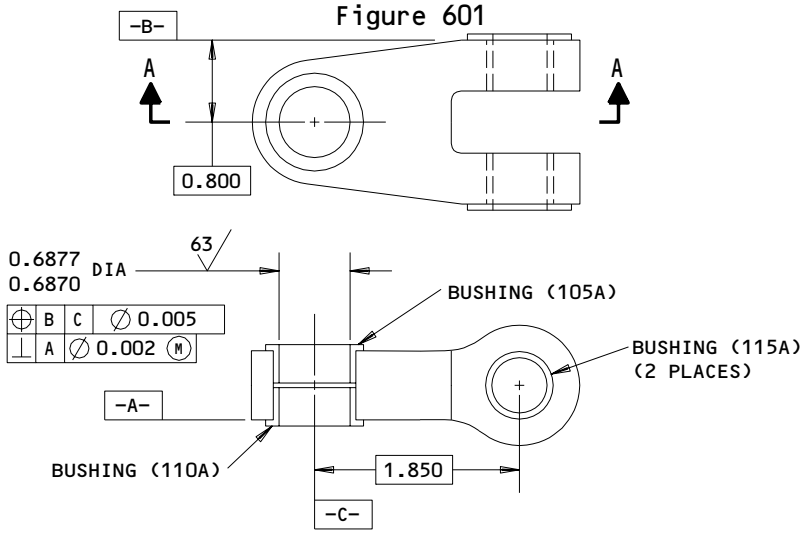
E. Seal bushing flanges.



ALL DIMENSIONS ARE IN INCHES

114T6407-1
Bushing Replacement
Figure 601

59019



A-A

REFINISH

LINK (100A) -- ABRASIVE BLAST CLEAN PER 20-30-03 AND PASSIVATE (F-17.09) ALL OVER. APPLY ONE COAT BMS 10-11, TYPE 1, PRIMER (F-20.02) AND APPLY BMS 10-60 GRAY GLOSS ENAMEL (SRF-14.9813) ALL OVER, EXCEPT OMIT PRIMER AND ENAMEL FROM BUSHING HOLES.

MATERIAL: 15-5PH CRES (150-170 KSI)

ALL DIMENSIONS ARE IN INCHES

114T6423-1
Bushing Replacement
Figure 602

290066

LINK - REPAIR 5-2

114T6407-2

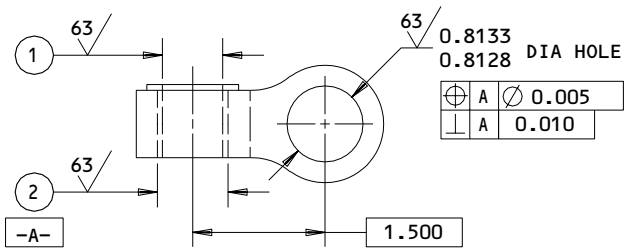
NOTE: Refer to REPAIR-GENERAL for a list of applicable standard practices. For repair of surfaces which may only require stripping and restoration of original finish, refer to Refinish instructions, Fig. 601.

1. Installation of Oversize Bushing (Fig. 601)

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

B. Manufacture bushings (Fig. 602), as required, to compensate for amount of material removed.

C. Install bushing per REPAIR 5-1.



HOLE LOCATION	DESIGN DIA	REPAIR DIA 1
1	0.6882 0.6875	0.7482
2	0.8132 0.8125	0.8732

REFINISH

CHROMIC ACID ANODIZE AND APPLY 1 COAT OF PRIMER (F-18.13) THEN APPLY ENAMEL (SRF-14.9813) EXCEPT OMIT PRIMER AND ENAMEL IN HOLES FOR BUSHINGS

1 REPAIR LIMITS FOR INSTALLATION OF OVERSIZE BUSHING

REPAIR

REF 1

125 OR BETTER ON ALL MACHINED SURFACES EXCEPT AS NOTED

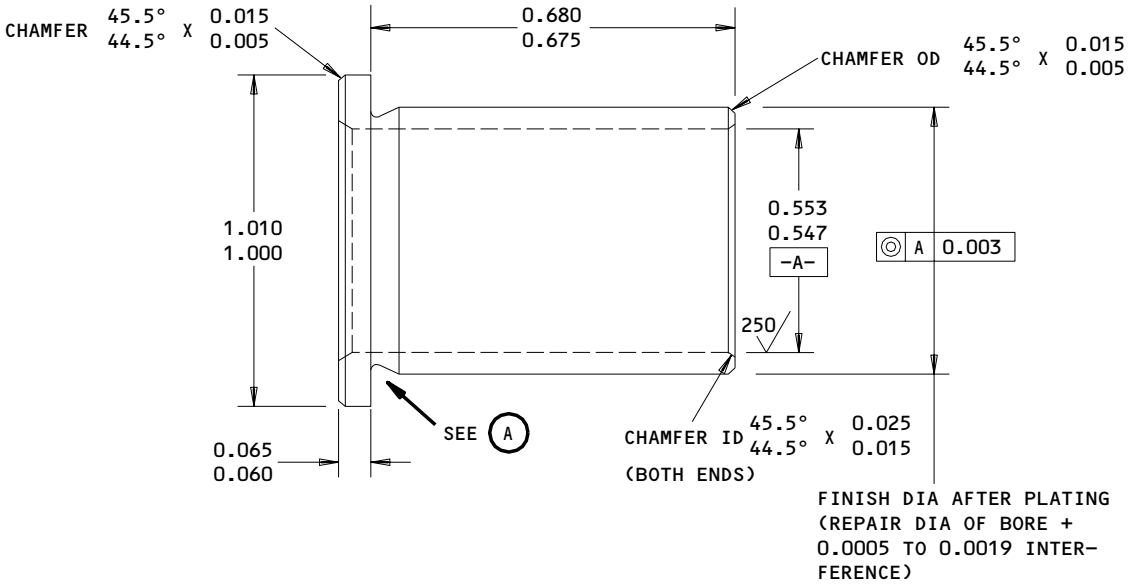
BREAK ALL SHARP EDGES 0.020 / 0.010 R

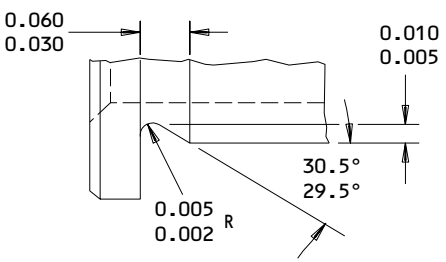
MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

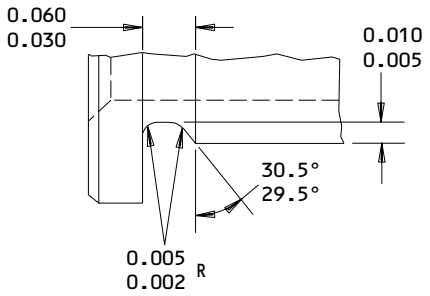
Link Repair
Figure 601

179961





TYPE I



TYPE II

TYPE II UNDERCUT OPTIONAL TO TYPE I

(A)

ALL DIMENSIONS ARE IN INCHES

DIMENSIONS APPLY AFTER PLATING

MATERIAL: AL-NI-BR PER AMS 4640

63 OR BETTER ON ALL MACHINED SURFACES EXCEPT AS NOTED

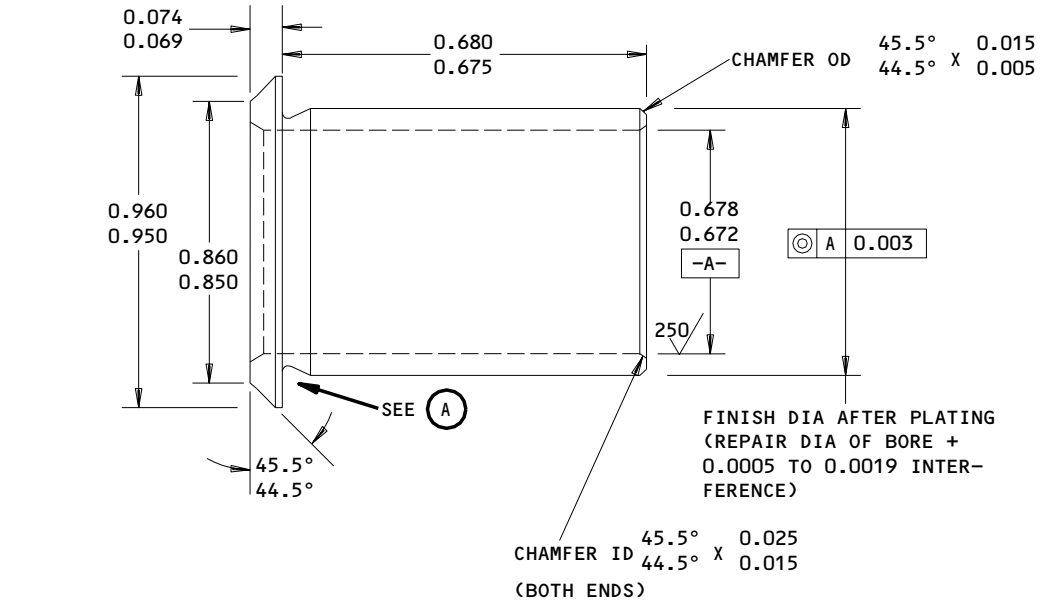
BREAK SHARP EDGES 0.008 R

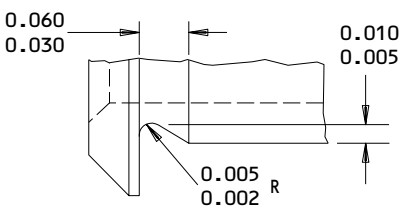
CADMIUM PLATE (F-15.06). PLATING IN BORE OPTIONAL

OVERSIZE BUSHING FOR HOLE LOCATION (1) (FIG. 601)

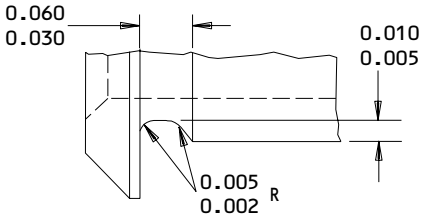
Oversize Bushing Details
Figure 602 (Sheet 1)

180057





TYPE I



TYPE II

TYPE I OR TYPE II UNDERCUT OPTIONAL

(A)

DIMENSIONS APPLY AFTER PLATING

ALL DIMENSIONS ARE IN INCHES

MATERIAL: AL-NI-BR PER AMS 4640

63 OR BETTER ON ALL MACHINED SURFACES EXCEPT AS NOTED

BREAK ALL SHARP EDGES 0.008 R

CADMIUM PLATE (F-15.06). PLATING IN BORE OPTIONAL

OVERSIZE BUSHING FOR HOLE LOCATION (2) (FIG. 601)

Oversize Bushing Details
Figure 602 (Sheet 2)

LINK ASSEMBLY - REPAIR 6-1

114T6408-1
114T6426-1

NOTE: Refer to REPAIR-GENERAL for a list of applicable standard practices. For repair of surfaces which may only require restoration of original finish, refer to Refinish instructions, Fig. 601 or Fig. 602 in REPAIR 6-2. For item numbers, refer to IPL Fig. 1.

1. Bearing (160) Replacement (Fig. 601 and 602)

   A. Remove bearing (160).

   B. Install new bearing (160) and roller swage per 20-50-03.

2. Bushing (165, 167) Replacement; 114T6408-1 only (Fig. 601)

   A. Remove bushings (165, 167). If corrosion or damage exists in holes, refer to REPAIR 6-2 for repair procedures.

   B. Install new bushings per 20-50-03, except use wet sealant.

   C. Machine bushings to dimensions and finish shown.

   D. Fillet seal bushing flanges with sealant.

3. Bushing (165A, 167A) Replacement; 114T6426-1 only (Fig. 602)

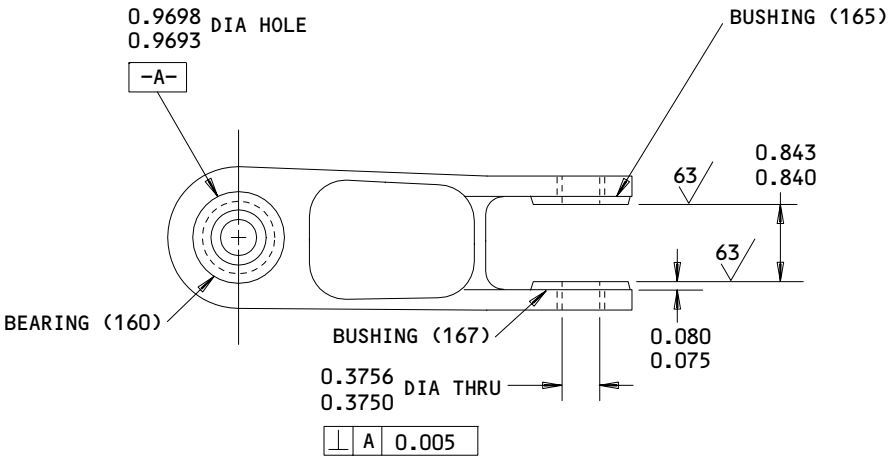
   A. Remove bushings (165A, 167A).

   B. Coat link ID with BMS 3-24 grease.

   C. Install replacement bushings using the shrink-fit method. Refer to 20-50-03.

   D. Machine bushings ID to dimension and finish shown.

   E. Seal bushing flanges with sealant.



125 MACHINED SURFACES EXCEPT AS NOTED

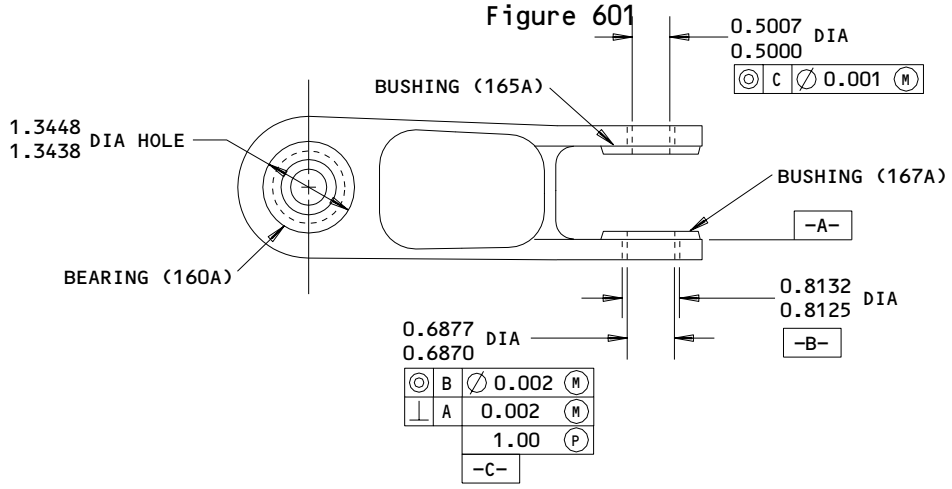
ALL DIMENSIONS ARE IN INCHES

BREAK SHARP EDGES 0.01-0.02 R
AFTER MACHINING

114T6408-1

Parts Replacement
Figure 601

59025



REFINISH

LINK (170A) -- ABRASIVE BLAST CLEAN PER 20-30-03 AND PASSIVATE (F-17.09) ALL OVER. APPLY ONE COAT BMS 10-11, TYPE 1, PRIMER (F-20.02) AND APPLY BMS 10-60 GRAY GLOSS ENAMEL (SRF-14.9813) ALL OVER, EXCEPT OMIT PRIMER AND ENAMEL FROM BEARING AND BUSHING HOLES.

125 MACHINED SURFACES EXCEPT AS NOTED

BREAK SHARP EDGES 0.01-0.02 R AFTER MACHINING

MATERIAL: 15-5PH CRES (150-170 KSI)

ALL DIMENSIONS ARE IN INCHES

114T6426-1
Parts Replacement
Figure 602

290068

LINK - REPAIR 6-2

114T6408-2

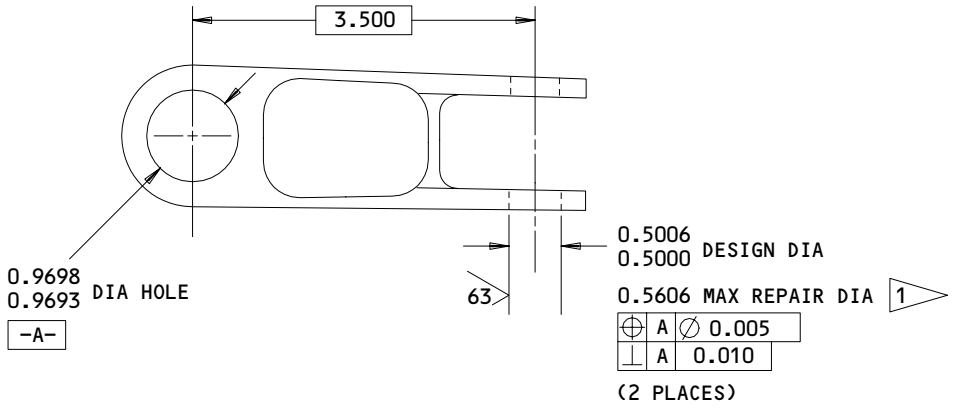
NOTE: Refer to REPAIR-GENERAL for a list of applicable standard practices. For repair of surfaces which may only require stripping and restoration of original finish, refer to Refinish instructions, Fig. 601.

1. Installation of Oversize Bushing (Fig. 601)

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

   B. Manufacture bushings (Fig. 602), as required, to compensate for amount of material removed.

   C. Install bushing per REPAIR 6-1.



REFINISH

CHROMIC ACID ANODIZE AND APPLY 1 COAT OF PRIMER (F-18.13) PLUS APPLY 1 COAT OF ENAMEL (SRF-14.9813) EXCEPT OMIT PRIMER AND ENAMEL IN BORES FOR BEARING AND BUSHINGS

1 REPAIR LIMIT FOR INSTALLATION OF OVERSIZE BUSHING

REPAIR

REF 1

125 OR BETTER ON ALL MACHINED SURFACES EXCEPT AS NOTED

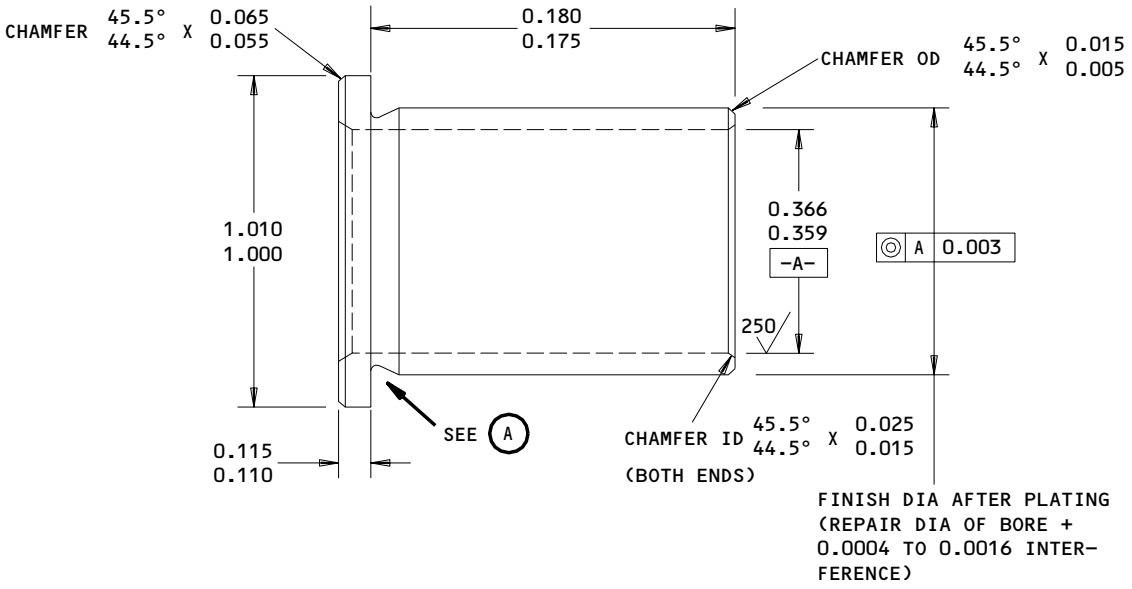
BREAK ALL SHARP EDGES 0.020 / 0.010 R

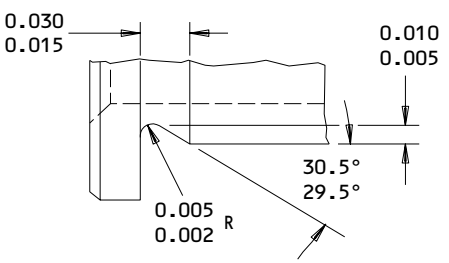
MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

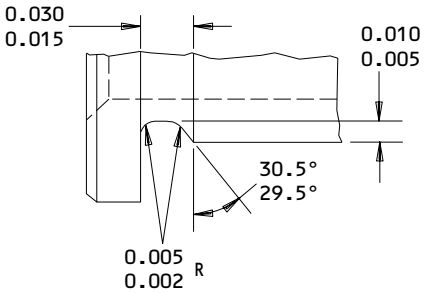
Link Repair
Figure 601

180059





TYPE I



TYPE II

TYPE II UNDERCUT OPTIONAL TO TYPE I

A

ALL DIMENSIONS ARE IN INCHES

DIMENSIONS APPLY AFTER PLATING

MATERIAL: 15-5PH CRES PER AMS 5639, 180-200 KSI

63 OR BETTER ON ALL MACHINED SURFACES EXCEPT AS NOTED

BREAK SHARP EDGES 0.008 R

CADMIUM PLATE (F-15.06). PLATING IN BORE OPTIONAL

Oversize Bushing Details
Figure 602

180061

MISCELLANEOUS PARTS REFINISH - REPAIR 7-1

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

IPL FIG. & ITEM	MATERIAL	FINISH
Fig. 1 Spacer (20)	15-5PH CRES 150-170 ksi	Cadmium plate and apply one coat primer, BMS 10-11, type 1 (F-16.01)
Sleeve (30,32,33)	15-5PH CRES 180-200 ksi	Chrome plate (F-15.03) on O.D. only. Grind to 16 microinch finish and 0.6235-0.6240 dia (114T6409-3) or 0.8735-0.8740 dia (114T6409-10,-11). Optional: Grind undersize to 16 microinch finish and flash chrome plate (F-15.03) to final diameter. 0.0005 minimum plate thickness. Hand buff with 600 grit or finer if necessary to get required finish.

Refinish Details
Figure 601

ASSEMBLY

1. Materials

NOTE: Equivalent substitutes may be used.

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

2. Assembly (IPL Fig. 1)

A. Assemble this component using standard industry practices and the following special instructions.

B. Apply a light coat of grease to shanks of bolts (5, 75, 130, 175) before assembly.

C. Install bolts (5, 130) with bolt heads on the outboard side. Install bolts (5A, 130A) with bolt heads on the inboard side.

D. Install bolt (175) with bolt head on the inboard side.

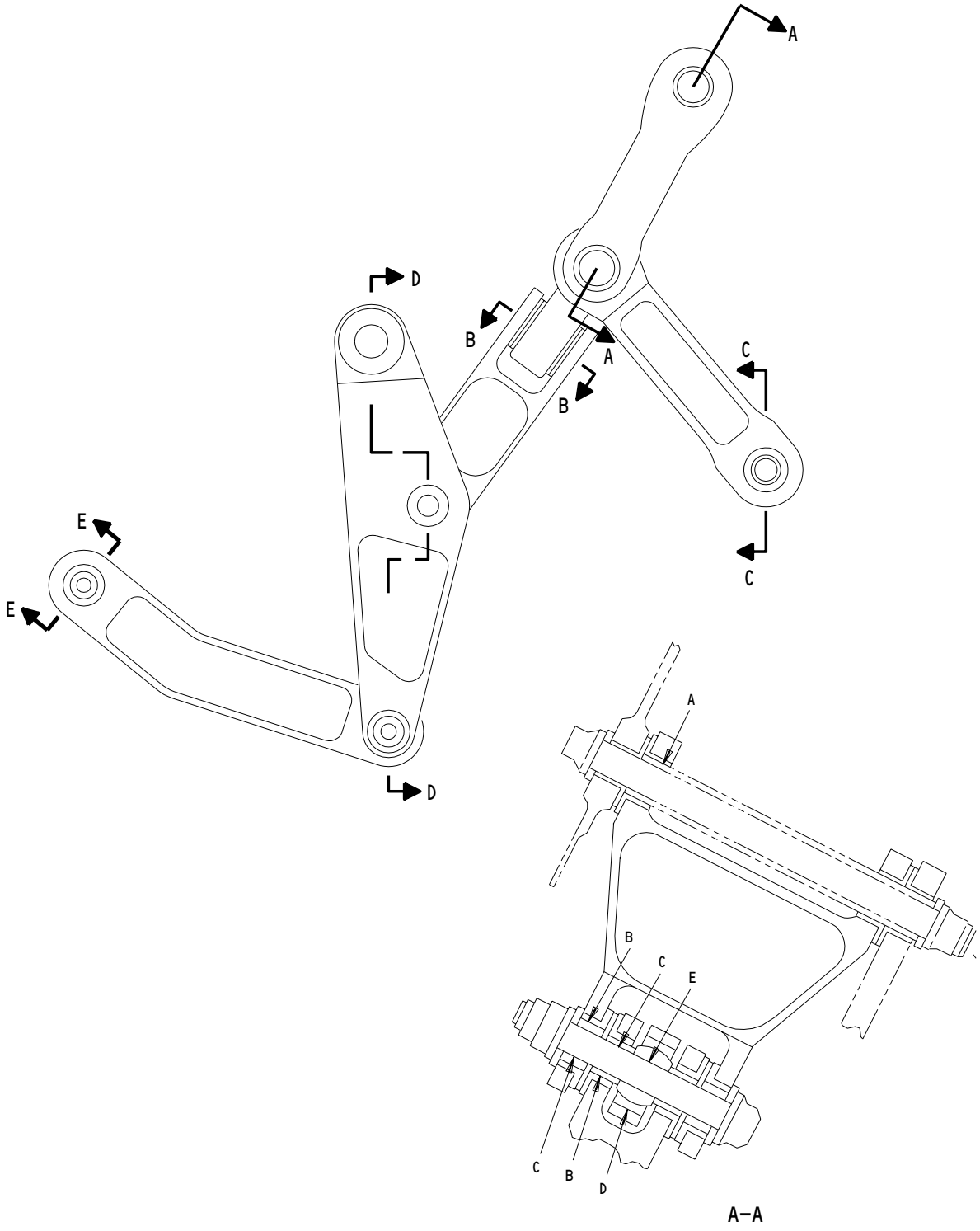
E. Install bolt (75) with bolt head upward.

F. Tighten nut (25) to 320-440 lb-in. Tighten nut (25A) to 700-920 lb-in.

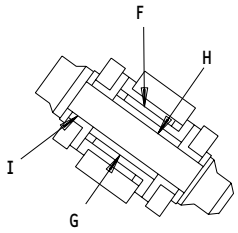
G. Tighten nuts (90, 145) to 160-190 lb-in. Tighten nut (90A) to 440-650 lb-in. Tighten nut (145A) to 700-920 lb-in.

H. Tighetn nut (195) to 50-75 lb-in. Tighten nut (195A) to 145-180 lb-in.

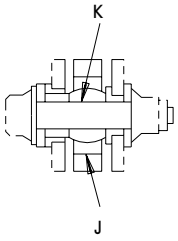
I. Install washer (190) with countersunk part over bushing (250) flange.



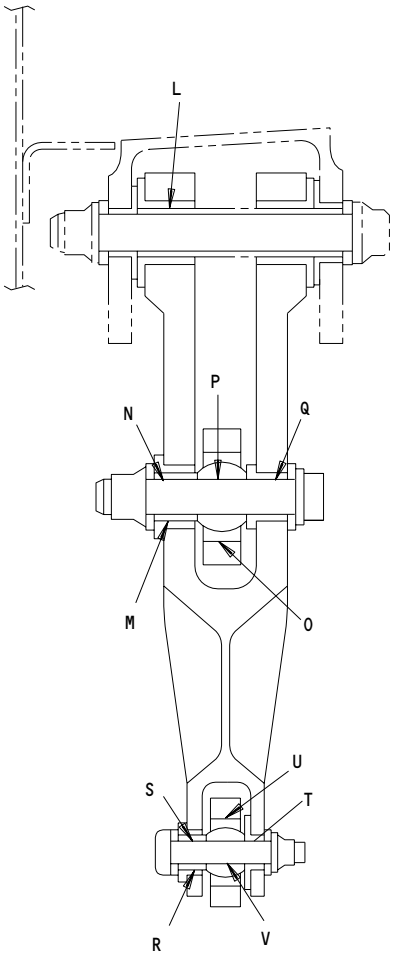
114T6400-5,-6,-9,-10,-13,-14
Fits and Clearances
Figure 801 (Sheet 1)



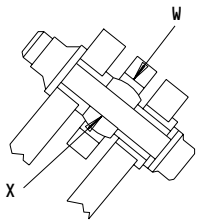
B–B



C–C



D–D



E–E

114T6400-5,-6,-9,-10,-13,-14
Fits and Clearances
Figure 801 (Sheet 2)

59384

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 40	0.5630	0.5640	0.0015	0.0030		0.5665	0.0050
	OD 2	0.5610	0.5615			0.5590		
B	ID 45,115	0.6255	0.6265	0.0015	0.0030		0.6290	0.0050
	OD 30	0.6235	0.6240			0.6215		
C	ID 30	0.4890	0.4400	0.0020	0.0035		0.4420	0.0050
	OD 5	0.4365	0.4370			0.4350		
D	ID 70	1.0005	1.0010	0.0005	0.0015			
	OD 60	0.9995	1.0000					
E	ID 60	0.4375	0.4379	0.0005	0.0014		0.4420	0.0050
	OD 5	0.4365	0.4370			0.4329		
F	ID 105	0.6875	0.6882	−0.0018	−0.0005			
	OD 110	0.6887	0.6893					
G	ID 110	0.5620	0.5627	0.0005	0.0017		0.5665	0.0050
	OD 95	0.5610	0.5615			0.5577		
H	ID 95	0.3750	0.3755	0.0005	0.0015		0.3795	0.0050
	OD 75	0.3740	0.3745			0.3705		
I	ID 165	0.3750	0.3756	0.0005	0.0016		0.3795	0.0050
	OD 75	0.3740	0.3745			0.3705		
J	ID 70	0.7818	0.7823	0.0005	0.0015			
	OD 65	0.7808	0.7813					
K	ID 65	0.3125	0.3129	0.0005	0.0014		0.3170	0.0050
	OD 3	0.3115	0.3120			0.3079		
L	ID 230	0.5630	0.5640	0.0015	0.0030		0.5665	0.0050
	OD 4	0.5610	0.5615			0.5590		
M	ID 235	0.5620	0.5627	0.0005	0.0017		0.5665	0.0050
	OD 150	0.5610	0.5615			0.5577		

114T6400-5,-6,-9,-10,-13,-14
Fits and Clearances
Figure 801 (Sheet 3)

58642

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	
N	ID 150	0.3750	0.3755	0.0005	0.0015		0.3795	0.0050
	OD 130	0.3740	0.3745			0.3705		
O	ID 170	0.9693	0.9698	0.0005	0.0015			
	OD 160	0.9683	0.9688					
P	ID 160	0.3750	0.3754	0.0005	0.0014		0.3795	0.0050
	OD 130	0.3740	0.3745			0.3704		
Q	ID 240	0.3750	0.3756	0.0005	0.0016		0.3795	0.0050
	OD 130	0.3740	0.3745			0.3706		
R	ID 245	0.3750	0.3756	0.0005	0.0016		0.3795	0.0050
	OD 200	0.3740	0.3745			0.3706		
S	ID 200	0.2500	0.2505	0.0005	0.0015		0.2545	0.0050
	OD 175	0.2490	0.2495			0.2455		
T	ID 250	0.2500	0.2505	0.0005	0.0015		0.2545	0.0050
	OD 175	0.2490	0.2495			0.2455		
U	ID 220	0.7505	0.7510	0.0005	0.0015			
	OD 215	0.7495	0.7500					
V	ID 215	0.2500	0.2504	0.0005	0.0014		0.2545	0.0050
	OD 175	0.2490	0.2495			0.2454		
W	ID 220	0.7818	0.7823	0.0005	0.0015			
	OD 210	0.7808	0.7813					
X	ID 210	0.3125	0.3129	0.0005	0.0014		0.3170	0.0050
	OD 3	0.3115	0.3120			0.3079		

1 NEGATIVE VALUES DENOTE INTERFERENCE FIT

ALL DIMENSIONS ARE IN INCHES

2 INSTALLATION PART 114T6409-2

3 INSTALLATION PART BACB30LE5U

4 INSTALLATION PART 114T6409-1

114T6400-5,-6,-9,-10,-13,-14
Fits and Clearances
Figure 801 (Sheet 4)

58649

FOR TORQUE VALUES OF STANDARD FASTENERS, REFER TO 20-50-01			
ITEM NO. IPL FIG. 1	NAME	TORQUE	
		POUND-INCHES	POUND-FEET
25	NUT	320 - 440	
25A	NUT	700 - 920	
90	NUT	160 - 190	
90A	NUT	440 - 650	
145	NUT	160 - 190	
145A	NUT	700 - 920	
195	NUT	50 - 75	
195A	NUT	145 - 180	

Torque Table
Figure 802

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

S0352 NIPPON MINIATURE BEARING CO LTD
TOKYO, JAPAN

06710 LAMSON AND SESSIONS CO THE VALLEY-TODECO
12975 BRADLEY AVENUE
SYLMAR, CALIFORNIA 91342-3830

08524 DEUTSCH FASTENER CORP SEE CODE V97928

09455 BFM TRANSPORT DYNAMICS CORP
3131 WEST SEGERSTROM AVENUE PO BOX 1953
SANTA ANA, CALIFORNIA 92702-1953

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 92634-3001

15860 NEW HAMPSHIRE BALL BEARINGS, INCORPORATED ASTRO DIVISION
155 LEXINGTON AVENUE
LACONIA, NEW HAMPSHIRE 03246-2937

27238 BRISTOL INDUSTRIES
630 EAST LAMBERT ROAD PO BOX 630
BREA, CALIFORNIA 92621-4119

50294 NEW HAMPSHIRE BALL BEARINGS INC
9730 INDEPENDENCE AVENUE PO BOX 2515
CHATSWORTH, CALIFORNIA 91311-4323

VENDORS

50632 KAMATICS CORP SUB OF KAMAN CORP
1335 BLUE HILLS ROAD
BLOOMFIELD, CONNECTICUT 06002-1304

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

62554 SIMMONDS MECAERO FASTENERS INC
1734 SEQUOIA AVENUE
ORANGE, CALIFORNIA 92668

72962 HARVARD INDUSTRIES INC
3 WERNER WAY SUITE 210
LEBANON, NEW JERSEY 08833

73134 IMO INDUSTRIES INC HEIM BEARINGS DIV
60 ROUND HILL ROAD PO BOX 430
FAIRFIELD, CONNECTICUT 06430

81376 SOUTHWEST PRODUCTS COMPANY
2240 BUENA VISTA STREET
IRVINDALE, CALIFORNIA 91706

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

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

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
ADB06V301NC		1	210A	1
ADB09V301N		1	60B	1
ADB5V301N		1	210C	1
		1	65A	1
ADB5V301NC		1	65	1
		1	210	1
		1	65B	1
ADB6V301C		1	210B	1
ADB7V301NC		1	60	1
ADW04V301NC		1	215A	1
ADW06V301NC		1	160	1
ADW09V301N		1	160A	1
ADW4V301NC		1	215	1
ADW5V301NC		1	215A	1
ADW6V301NC		1	160	1
BACB10ES06GC		1	210B	1
BACB10FA04GC		1	215A	1
BACB10FA05GC		1	215A	1
BACB10FA06GC		1	160	1
BACB10FA09G		1	160A	1
BACB10FB05G		1	210C	1
		1	65A	1
BACB10FB05GC		1	65	1
		1	210	1
		1	65B	1
BACB10FB06GC		1	210A	1
BACB10FB07GC		1	60	1
BACB10FB09G		1	60B	1
BACB10FB09GC		1	60C	1
BACB28AK04-033		1	200	1
BACB28AK05-044		1	200A	1
BACB28AK06-050		1	150	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACB28AK06-084		1	95	1
BACB28AK08-114		1	95A	1
BACB28AK09-048		1	150B	1
BACB28AM06B014A		1	245	1
BACB28AM07B027A		1	245A	1
BACB28AM09B030A		1	235	1
BACB28AM11B031		1	105A	1
		1	110A	1
BACB28AM11B068A		1	105	1
BACB28AM13B029A		1	235A	1
BACB28AP04P014		1	250	1
BACB28AP05P027		1	250A	1
BACB28AP06P030		1	240	1
BACB28AP09P029		1	240A	1
BACB30LE6U23		1	75	1
		1	130	1
BACB30LE7U36		1	5	1
BACB30LE8U24		1	75A	1
BACB30LE9U26		1	130A	1
BACB30LE9U41		1	5A	1
BACB30LT4U16		1	175	1
BACB30US5-21		1	175A	1
BACN10HR5CS		1	195A	1
BACN10HR6CS		1	90	1
		1	145	1
BACN10HR7CS		1	25	1
BACN10HR8CS		1	90A	1
BACN10HR9CS		1	25A	1
		1	145A	1
BACW10BP4AC		1	180	1
BACW10BP4AP		1	185	1
BACW10BP5AC		1	180A	1
BACW10BP5AP		1	185A	1
BACW10BP6AC		1	80	1
		1	135	1
BACW10BP6AP		1	85	1
		1	140	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACW10BP7AC		1	10	1
BACW10BP7AP		1	15	1
BACW10BP8ACU		1	80A	1
BACW10BP8APU		1	85A	1
BACW10BP9AC		1	140A	1
BACW10BP9ACU		1	10A	1
BACW10BP9AP		1	135A	1
BACW10BP9APU		1	15A	1
BH003025CS		1	195A	1
BH003026CS		1	90	1
		1	145	1
BH003027CS		1	25	1
BH003028CS		1	90A	1
BH00303-5		1	195A	1
BH00303-6		1	90	1
		1	145	1
BH00303-7		1	25	1
BH00303-8		1	90A	1
BH003035		1	195A	1
BH003036		1	90	1
		1	145	1
BH003037		1	25	1
BH003038		1	90A	1
BH003039		1	25A	1
		1	145A	1
BMNN10HR6CS		1	90	1
		1	145	1
BMNN10HR8CS		1	90A	1
BMN10HRCPD3-6		1	90	1
		1	145	1
BMN10HRCPD3-8		1	90A	1
BMN10HRCPD3-9		1	25A	1
		1	145A	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BMN10HR5CS		1	195A	1
BMN10HR7CS		1	25	1
BMN5024CPD3-5		1	195A	1
BMN5024CPD3-6		1	90	1
		1	145	1
BMN5024CPD3-8		1	90A	1
BMN5024CPD3-9		1	25A	1
		1	145A	1
BMN5024CPD35		1	195A	1
BMN5024CPD36		1	90	1
		1	145	1
BMN5024CPD37		1	25	1
BMN5024CPD38		1	90A	1
BMN5024CPD39		1	25A	1
		1	145A	1
BMN5024CP3-7		1	25	1
CR59065CS		1	195A	1
CR59066CS		1	90	1
		1	145	1
CR59067CS		1	25	1
CR59068CS		1	90A	1
CR5908		1	90	1
		1	145	1
CR59085		1	195A	1
CR59087		1	25	1
CR59088		1	90A	1
CR59089		1	25A	1
		1	145A	1
HTES06VC		1	210B	1
HTFB05GC		1	65	1
		1	210	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
HTFB05V		1	210C	1
		1	65A	1
HTFB05VC		1	65	1
		1	210	1
		1	65B	1
HTFB06GC		1	210A	1
HTFB07GC		1	60	1
HTFB07VC		1	60	1
HTFB09GC		1	60C	1
HTFB09V		1	60B	1
H39953		1	25	1
		1	90	1
		1	145	1
		1	25A	1
		1	90A	1
		1	145A	1
		1	195A	1
H39953-6		1	90	1
		1	145	1
H39953-7		1	25	1
H39953-8		1	90A	1
H39953-9		1	25A	1
		1	145A	1
H965CS		1	195A	1
H966CS		1	90	1
		1	145	1
H967CS		1	25	1
H968CS		1	90A	1
KNDB06-70		1	210A	1
KNDB09-62		1	60B	1
KNDB09-70		1	60C	1
KNDB5-62		1	210C	1
		1	65A	1
KNDB5-70		1	65	1
		1	210	1
		1	65B	1
KNDB6-64		1	210B	1
KNDB7-70		1	60	1

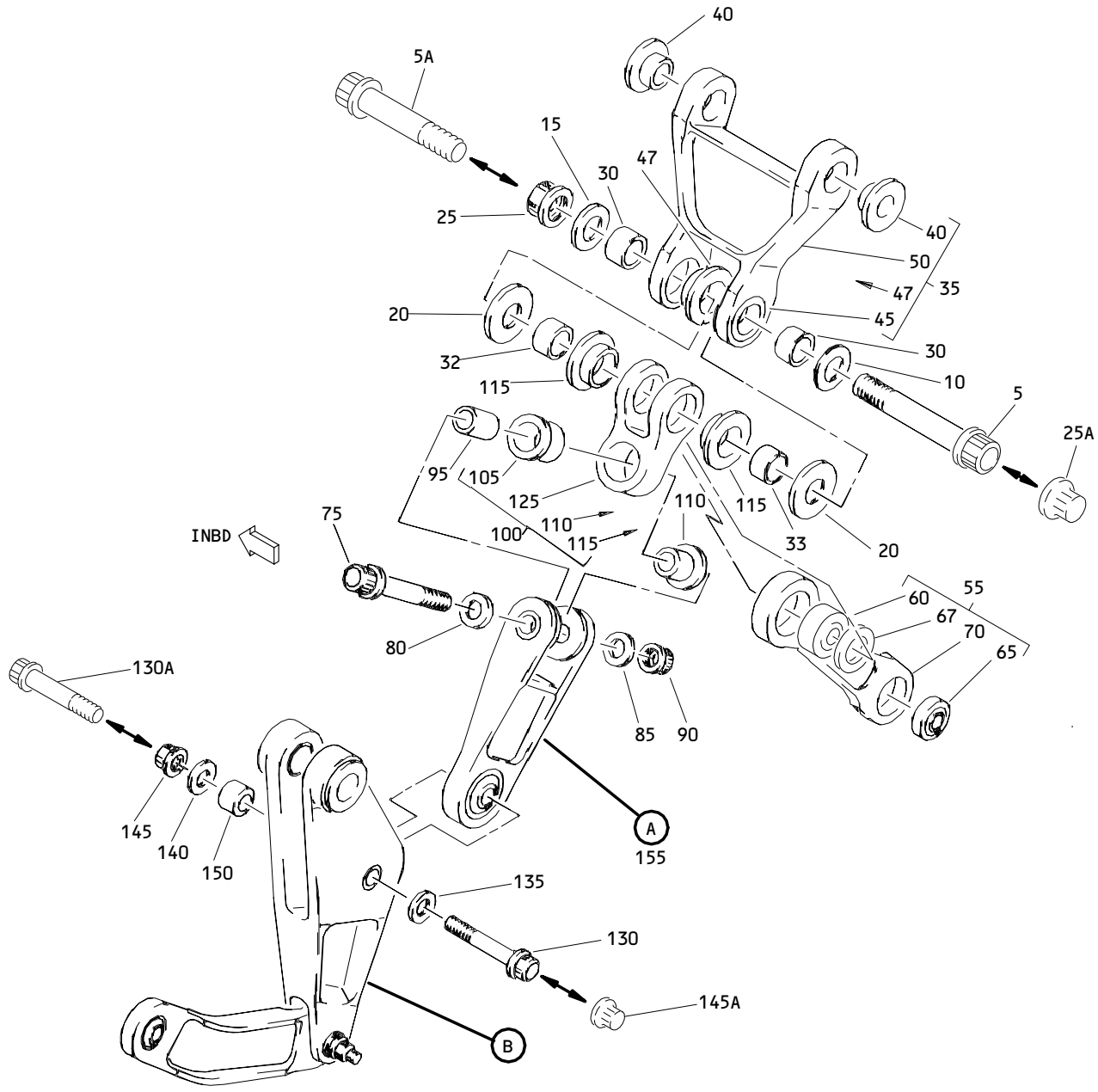
PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
KSC13090OB6GC		1	210B	1
KSC14570OBZG5		1	210C	1
		1	65A	1
KSC14570OBZ06GC		1	210A	1
KSC14570OBZ09G		1	60B	1
KSC14570OBZ09GC		1	60C	1
KSC14570OBZ5GC		1	65	1
		1	210	1
		1	65B	1
KSC14570OBZ7GC		1	60	1
KSC15220OBZ09G		1	160A	1
KSC15220OBZ4GC		1	215	1
KSC15220OBZ5CC		1	215A	1
KSC15220OBZ6CC		1	160	1
KWDB09-33		1	160A	1
KWDB4-35		1	215	1
KWDB5-35		1	215A	1
KWDB6-35		1	160	1
M81934-2-09A010		1	40	2
M81934-2-09A016		1	230	2
M81934-2-10A009		1	45	1
		1	47	2
		1	115	2
M81934-2-11A018		1	230A	2
M81934-2-11C018		1	40A	2
M81934-2-14C014		1	115A	2
NAS1805-4		1	195	1
NES06FBGC		1	210A	1
NES09FBG		1	60B	1
NRRS05FBG		1	210C	1
		1	65A	1
NRRS05FBGC		1	65	1
		1	210	1
		1	65B	1
NRRS07FBGC		1	60	1
NRR06ESGC		1	210B	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
RMLH225CS		1	195A	1
RMLH226CS		1	90	1
		1	145	1
RMLH227CS		1	25	1
RMLH228CS		1	90A	1
SL70509		1	25	1
SL705095		1	195A	1
SL705096		1	90	1
		1	145	1
SL705098		1	90A	1
SL705099		1	25A	1
		1	145A	1
SL7059C624		1	90	1
		1	145	1
SWKRS05-350SC		1	215A	1
SWKRS09-350S		1	160A	1
VAL280095CS		1	195A	1
VAL280096CS		1	90	1
		1	145	1
VAL280097CS		1	25	1
VAL280098CS		1	90A	1
WES05G		1	65A	1
WES05GC		1	65B	1
WES09FAG		1	160A	1
WHTFA04VC		1	215	1
WHTFA05VC		1	215A	1
WHTFA06VC		1	160	1
WHTFA09V		1	160A	1
WRRS04FAGC		1	215	1
WRRS05FAGC		1	215A	1
WRRS06FACC		1	160	1
012T2400-19		1	110	1
012T2400-20		1	165	1
		1	167	1
012T2400-52		1	165A	1
012T2400-53		1	167A	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
012T2400-54		1	47A	1
012T2400-55		1	45A	1
03-825-06E010		1	210B	1
109LH90301		1	25A	1
		1	145A	1
109LH9031-6		1	90	1
		1	145	1
109LH9031-7		1	25	1
109LH9031-8		1	90A	1
109LH9031-9		1	25A	1
		1	145A	1
109LH90315		1	195A	1
109LH90316		1	90	1
		1	145	1
109LH90317		1	25	1
109LH90318		1	90A	1
114T6318-4		1	20A	2
114T6400-10		1	2A	RF
114T6400-13		1	1E	RF
114T6400-14		1	2D	RF
114T6400-5		1	1A	RF
114T6400-6		1	2	RF
114T6400-9		1	1B	RF
114T6401-1		1	35	1
114T6401-2		1	50	1
114T6402-1		1	225	1
114T6402-2		1	255	1
114T6403-1		1	55	1
114T6403-2		1	70	1
114T6403-3		1	55A	1
114T6403-4		1	70A	1
114T6404-1		1	205	1
114T6404-2		1	220	1
114T6406-1		1	190	1
114T6407-1		1	100	1
114T6407-2		1	125	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
114T6408-1		1	155	1
114T6408-2		1	170	1
114T6409-10		1	32A	1
114T6409-11		1	33A	1
114T6409-3		1	30	2
		1	32	1
		1	33	1
114T6410-1		1	35A	1
114T6410-2		1	50A	1
114T6422-1		1	205A	1
114T6422-2		1	220A	1
114T6422-3		1	210C	1
114T6423-1		1	100A	1
114T6423-2		1	125A	1
114T6424-1		1	55B	1
114T6424-2		1	70B	1
114T6425-1		1	225A	1
114T6425-2		1	255A	1
114T6426-1		1	155A	1
114T6426-2		1	170A	1
114T6427-1		1	35B	1
114T6427-2		1	50B	1
114T6428-1		1	217	2
114T6428-2		1	67	2
114T6450-3		1	1C	RF
114T6450-4		1	2B	RF
114T6450-7		1	1D	RF
114T6450-8		1	2C	RF
67832AS5		1	195A	1
67832AS6		1	90	1
67832AS6		1	145	1
67832AS624		1	90	1
		1	145	1
67832AS7		1	25	1

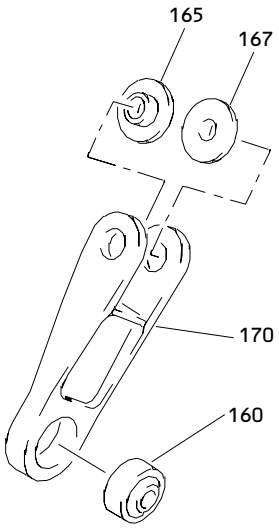
PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
67832AS8		1	90A	1
67832AS820		1	90A	1
67832AS9		1	25A	1
		1	145A	1
67832AS918		1	25A	1
		1	145A	1
678325CS		1	195A	1
678326CS		1	90	1
		1	145	1
678327CS		1	25	1
678328CS		1	90A	1



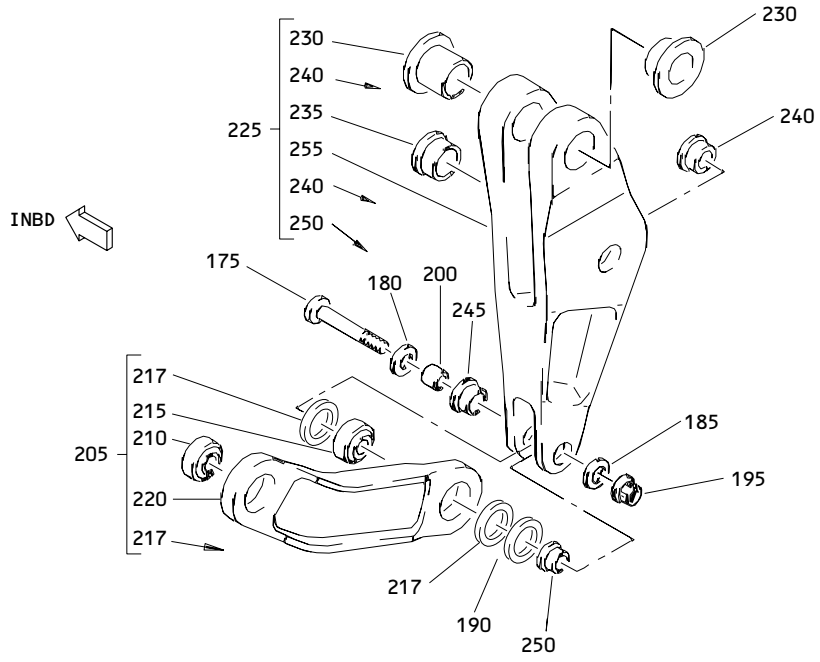
114T6400-5 ASSEMBLY SHOWN

Fixed Leading Edge At Nacelle Krueger Seal Drive Mechanism Assembly
Figure 1 (Sheet 1)

T64516



A



B

Fixed Leading Edge At Nacelle Krueger Seal Drive Mechanism Assembly
Figure 1 (Sheet 2)

T64517

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-1	114T6400-2		DELETED		
-1A	114T6400-5		MECHANISM ASSY-FXD AT NAC KRUEGER SEAL DRIVE (LH)	A	RF
-1B	114T6400-9		MECHANISM ASSY-FXD AT NAC KRUEGER SEAL DRIVE (LH)	C	RF
-1C	114T6450-3		MECHANISM ASSY-FXD AT NAC KRUEGER SEAL DRIVE (LH)	E	RF
-1D	114T6450-7		MECHANISM ASSY-FXD AT NAC KRUEGER SEAL DRIVE (LH)	F	RF
-1E	114T6400-13		MECHANISM ASSY-FXD AT NAC KRUEGER SEAL DRIVE (LH)	J	RF
-2	114T6400-6		MECHANISM ASSY-FXD AT NAC KRUEGER SEAL DRIVE (RH)	B	RF
-2A	114T6400-10		MECHANISM ASSY-FXD AT NAC KRUEGER SEAL DRIVE (RH)	D	RF
-2B	114T6450-4		MECHANISM ASSY-FXD AT NAC KRUEGER SEAL DRIVE (RH)	G	RF
-2C	114T6450-8		MECHANISM ASSY-FXD AT NAC KRUEGER SEAL DRIVE (RH)	H	RF
-2D	114T6400-14		MECHANISM ASSY-FXD AT NAC KRUEGER SEAL DRIVE (RH)	K	RF
5	BACB30LE7U36		.BOLT	A-D,J,K	1
-5A	BACB30LE9U41		.BOLT	E-H	1
10	BACW10BP7AC		.WASHER	A-D,J,K	1
-10A	BACW10BP9ACU		.WASHER	E-H	1
15	BACW10BP7AP		.WASHER	A-D,J,K	1
-15A	BACW10BP9APU		.WASHER	E-H	1
20	114T6318-2		DELETED		
20A	114T6318-4		.WASHER	A-D,J,K	2

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-25	H39953-7		.NUT- (V15653) (SPEC BACN10HR7CS) (OPT 109LH9031-7 (V72962)) (OPT 67832AS720 (V56878)) (OPT BMN5024CP3-7 (V97928)) (OPT BH00303-7 (V27238)) (OPT BH003037 (V27238)) (OPT BMN5024CPD37 (V97928)) (OPT CR59087 (V62554)) (OPT H39953 (V15653)) (OPT SL70509 (V11815)) (OPT 109LH90317 (V72962)) (OPT 67832AS7 (V56878)) (OPT BH003027CS (V27238)) (OPT BMN10HR7CS (V97928)) (OPT CR59067CS (V62554)) (OPT H967CS (V15653)) (OPT RMLH227CS (V72962)) (OPT VAL280097CS (V06710)) (OPT 678327CS (V56878))	A-D,J,K	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-25A	H39953-9		.NUT- (V15653) (SPEC BACN10HR9CS) (OPT 109LH9031-9 (V72962)) (OPT 67832AS918 (V56878)) (OPT BMN5024CPD3-9 (V97928)) (OPT BMN5024CPD3-9 (V08524)) (OPT BMN10HRCPD3-9 (V97928)) (OPT BH003039 (V27238)) (OPT BMN5024CPD39 (V97928)) (OPT CR59089 (V62554)) (OPT H39953 (V15653)) (OPT SL705099 (V11815)) (OPT 109LH90301 (V72962)) (OPT 67832AS9 (V56878))	E-H	1
30	114T6409-3		.SLEEVE	A-D,J,K	2
32	114T6409-3		.SLEEVE	A-D,J,K	1
-32A	114T6409-10		.SLEEVE	E-H	1
33	114T6409-3		.SLEEVE	A-D,J,K	1
-33A	114T6409-11		.SLEEVE	E-H	1
35	114T6401-1		.LEVER ASSY- (REPLD BY ITEM 35A)	A-D	1
-35A	114T6410-1		.LEVER ASSY- (REPLS ITEM 35)	A-D	1
-35B	114T6427-1		.LEVER ASSY-UPR	E-H	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-35C	114T6410-1		.LEVER ASSY	J,K	1
40	M81934-2-09A010		..BEARING	A-D,J,K	2
-40A	M81934-2-11C018		..BUSHING	E-H	2
45	M81934-2-10A009		..BEARING	A-D,J,K	1
-45A	012T2400-55		..BUSHING-FLANGED	E-H	1
47	M81934-2-10A009		..BEARING	A-D,J,K	1
-47A	012T2400-54		..BUSHING-FLANGED	E-H	1
50	114T6401-2		..LEVER- (USED ON ITEM 35)	A-D	1
-50A	114T6410-2		..LEVER- (USED ON ITEMS 35A, 35C)	A-D,J,K	1
-50B	114T6427-2		..LEVER	E-H	1
55	114T6403-1		.LINK ASSY	A,B	1
-55A	114T6403-3		.LINK ASSY	C,D,J,K	1
-55B	114T6424-1		.LINK ASSY	E-H	1
60	ADB7V301NC		..BEARING- (V15860) (SPEC BACB10FB07GC) (OPT HTFB07VC (V50294)) (OPT KNDB7-70 (V97613)) (OPT KSC145700BZ7GC (V50632)) (OPT NRRS07FBGC (V73134)) (OPT HTFB07GC (VS0352))	A-D,J,K	1
60A	BACB10FB07G		DELETED		

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01- -60B	NES09FBG		..BEARING- (V73134) (SPEC BACB10FB09G) (OPT KSC14570OBZ09G (V50632)) (OPT KNDB09-62 (V97613)) (OPT HTFB09V (VS0352)) (OPT ADB09V301N (V15860)) (OPT ITEM 60C)	E-H	1
-60C	ADB09V301NC		..BEARING- (V15860) (SPEC BACB10FB09GC) (OPT HTFB09GC (VS0352)) (OPT KNDB09-70 (V97613)) (OPT KSC14570OBZ09GC (V50632)) (OPT ITEM 60B)	E-H	1
65	ADB5V301NC		..BEARING- (V15860) (SPEC BACB10FB05GC) (OPT HTFB05VC (V50294)) (OPT KNDB5-70 (V97613)) (OPT KSC14570OBZ5GC (V50632)) (OPT NRRS05FBGC (V73134)) (OPT HTFB05GC (VS0352))	A-D,J ,K	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-65A	ADB5V301N		..BEARING- (V15860) (SPEC BACB10FB05G) (OPT HTFB05V (V50294)) (OPT KNDB5-62 (V97613)) (OPT KSC145700BZG5 (V50632)) (OPT NRRS05FBG (V73134)) (OPT WES05G (V73134)) (OPT ITEM 65B)	E-H	1
-65B	ADB5V301NC		..BEARING- (V15860) (SPEC BACB10FB05GC) (OPT HTFB05VC (V50294)) (OPT KNDB5-70 (V97613)) (OPT KSC145700BZ5GC (V50632)) (OPT NRRS05FBGC (V73134)) (OPT WES05GC (V73134)) (OPT ITEM 65A)	E-H	1
67	114T6428-2		..WASHER	E-H	2
70	114T6403-2		..LINK	A,B	1
-70A	114T6403-4		..LINK	C,D,J,K	1
-70B	114T6424-2		..LINK	E-H	1
75	BACB30LE6U23		.BOLT	A-D,J,K	1
-75A	BACB30LE8U24		.BOLT	E-H	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-80	BACW10BP6AC		.WASHER	A-D,J,K	1
-80A	BACW10BP8ACU		.WASHER	E-H	1
85	BACW10BP6AP		.WASHER	A-D,J,K	1
-85A	BACW10BP8APU		.WASHER	E-H	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-90	H39953-6		.NUT- (V15653) (SPEC BACN10HR6CS) (OPT 109LH9031-6 (V72962)) (OPT 67832AS624 (V56878)) (OPT BMN5024CPD3-6 (V97928)) (OPT BH00303-6 (V27238)) (OPT SL7059C624 (V11815)) (OPT BH003036 (V27238)) (OPT BMN5024CPD36 (V97928)) (OPT CR5908 (V62554)) (OPT H39953 (V15653)) (OPT SL705096 (V11815)) (OPT 109LH90316 (V72962)) (OPT 67832AS6 (V56878)) (OPT BH003026CS (V27238)) (OPT BMNN10HR6CS (V97928)) (OPT CR59066CS (V62554)) (OPT H966CS (V15653)) (OPT RMLH226CS (V72962)) (OPT VAL280096CS (V06710)) (OPT 678326CS (V56878)) (OPT BMN10HRCPD3-6 (V97928))	A-D,J,K	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01- -90A	H39953-8		.NUT- (V15653) (SPEC BACN10HR8CS) (OPT 109LH9031-8 (V72962)) (OPT 67832AS820 (V56878)) (OPT BMN5024CPD3-8 (V97928)) (OPT BH00303-8 (V27238)) (OPT BMN10HRCPD3-8 (V97928)) (OPT BH003038 (V27238)) (OPT BMN5024CPD38 (V97928)) (OPT CR59088 (V62554)) (OPT H39953 (V15653)) (OPT SL705098 (V11815)) (OPT 109LH90318 (V72962)) (OPT 67832AS8 (V56878)) (OPT BH003028CS (V27238)) (OPT BMNN10HR8CS (V97928)) (OPT CR59068CS (V62554)) (OPT H968CS (V15653)) (OPT RMLH228CS (V72962)) (OPT VAL280098CS (V06710)) (OPT 678328CS (V56878))	E-H	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
95	BACB28AK06-084		.BUSHING	A-D,J ,K	1
-95A	BACB28AK08-114		.BUSHING	E-H	1
100	114T6407-1		.LINK ASSY-UPR	A-D,J ,K	1
-100A	114T6423-1		.LINK ASSY-UPR	E-H	1
105	BACB28AM11B068A		..BUSHING	A-D,J ,K	1
-105A	BACB28AM11B031		..BUSHING	E-H	2
110	012T2400-19		..BUSHING	A-D,J ,K	1
-110A	BACB28AM11B031		..BUSHING	E-H	2
115	M81934-2-10A009		..BEARING	A-D,J ,K	2
-115A	M81934-2-14C014		..BUSHING	E-H	2
125	114T6407-2		..LINK	A-D,J ,K	1
-125A	114T6423-2		..LINK	E-H	1
130	BACB30LE6U23		.BOLT	A-D,J ,K	1
-130A	BACB30LE9U26		.BOLT	E-H	1
135	BACW10BP6AC		.WASHER	A-D,J ,K	1
-135A	BACW10BP9AP		.WASHER	E-H	1
140	BACW10BP6AP		.WASHER	A-D,J ,K	1
-140A	BACW10BP9AC		.WASHER	E-H	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-145	H39953-6		.NUT- (V15653) (SPEC BACN10HR6CS) (OPT 109LH9031-6 (V72962)) (OPT 67832AS624 (V56878)) (OPT BMN5024CPD3-6 (V97928)) (OPT BH00303-6 (V27238)) (OPT SL7059C624 (V11815)) (OPT BH003036 (V27238)) (OPT BMN5024CPD36 (V97928)) (OPT CR5908 (V62554)) (OPT H39953 (V15653)) (OPT SL705096 (V11815)) (OPT 109LH90316 (V72962)) (OPT 67832AS6 (V56878)) (OPT BH003026CS (V27238)) (OPT BMNN10HR6CS (V97928)) (OPT CR59066CS (V62554)) (OPT H966CS (V15653)) (OPT RMLH226CS (V72962)) (OPT VAL280096CS (V06710)) (OPT 678326CS (V56878)) (OPT BMN10HRCPD3-6 (V97928))	A-D,J,K	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-150	H39953-9		.NUT- (V15653) (SPEC BACN10HR9CS) (OPT 109LH9031-9 (V72962)) (OPT 67832AS918 (V56878)) (OPT BMN5024CPD3-9 (V97928)) (OPT BMN5024CPD3-9 (V08524)) (OPT BMN10HRCPD3-9 (V97928)) (OPT BH003039 (V27238)) (OPT BMN5024CPD39 (V97928)) (OPT CR59089 (V62554)) (OPT H39953 (V15653)) (OPT SL705099 (V11815)) (OPT 109LH90301 (V72962)) (OPT 67832AS9 (V56878))	E-H	1
150	BACB28AK06-050		.BUSHING	A-D,J,K	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
150A	BACB28AK05-044		DELETED		
-150B	BACB28AK09-048		.BUSHING	E-H	1
155	114T6408-1		.LINK ASSY-LWR	A-D,J,K	1
-155A	114T6426-1		.LINK ASSY-LWR	E-H	1
160	ADW6V301NC		..BEARING- (V15860) (SPEC BACB10FA06GC) (OPT KSC152200BZ6CC (V50632)) (OPT KWDB6-35 (V97613)) (OPT WHTFA06VC (V50294)) (OPT WRRS06FACC (V73134)) (OPT ADW06V301NC (V15860))	A-D,J,K	1
-160A	SWKRS09-350S		..BEARING- (V81376) (SPEC BACB10FA09G) (OPT ADW09V301N (V15860)) (OPT KSC152200BZ09G (V50632)) (OPT KWDB09-33 (V97613)) (OPT WES09FAG (V73134)) (OPT WHTFA09V (VS0352))	E-H	1
165	012T2400-20		..BUSHING	A-D,J,K	1
-165A	012T2400-52		..BUSHING	E-H	1
167	012T2400-20		..BUSHING	A-D,J,K	1
-167A	012T2400-53		..BUSHING	E-H	1
170	114T6408-2		..LINK	A-D,J,K	1
-170A	114T6426-2		..LINK	E-H	1
175B	BACB30LT4U16		.BOLT	A-D,J,K	1
-175A	BACB30US5-21		.BOLT	E-H	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
180	BACW10BP4AC		.WASHER	A-D,J,K	1
-180A	BACW10BP5AC		.WASHER	E-H	1
185	BACW10BP4AP		.WASHER	A-D,J,K	1
-185A	BACW10BP5AP		.WASHER	E-H	1
190	114T6406-1		.WASHER	A-D,J,K	1
195	NAS1805-4		.NUT	A-D,J,K	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01- -195A	H39953-5		.NUT- (V15653) (SPEC BACN10HR5CS) (OPT 67832AS524 (V56878)) (OPT BMN5024CPD3-5 (V97928)) (OPT BH00303-5 (V27238)) (OPT BH003035 (V27238)) (OPT BMN5024CPD35 (V97928)) (OPT CR59085 (V62554)) (OPT H39953 (V15653)) (OPT SL705095 (V11815)) (OPT 109LH90315 (V72962)) (OPT 67832AS5 (V56878)) (OPT BH003025CS (V27238)) (OPT BMN10HR5CS (V97928)) (OPT CR59065CS (V62554)) (OPT H965CS (V15653)) (OPT RMLH225CS (V72962)) (OPT VAL280095CS (V06710)) (OPT 678325CS (V56878))	E-H	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
200	BACB28AK04-033		.BUSHING	A-D,J,K	1
-200A	BACB28AK05-044		.BUSHING	E-H	1
205	114T6404-1		.LINK ASSY	A-D,J,K	1
-205A	114T6422-1		.LINK ASSY	E,G	1
-205B	114T6422-3		.LINK ASSY	F,H	1
210	ADB5V301NC		..BEARING- (V15860) (SPEC BACB10FB05GC) (OPT HTFB05VC (V50294)) (OPT KNDB5-70 (V97613)) (OPT KSC145700BZ5GC (V50632)) (OPT NRRS05FBGC (V73134)) (OPT HTFB05GC (VS0352)) (OPT ITEM 210C)	A-D,J,K	1
-210A	ADB06V301NC		..BEARING- (V15860) (SPEC BACB10FB06GC) (OPT HTFB06GC (VS0352)) (OPT KNDB06-70 (V97613)) (OPT KSC145700BZ06GC (V50632)) (OPT NES06FBGC (V73134))	E,G	1
-210B	ADB6V301C		..BEARING- (V15860) (SPEC BACB10ES06GC) (OPT HTES06VC (V50294)) (OPT KNDB6-64 (V97613)) (OPT KSC130900B6GC (V50632)) (OPT NRR06ESGC (V73134)) (OPT 03-825-06E010 (V09455))	F,H	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01- -210C	ADB5V301N		..BEARING- (V15860) (SPEC BACB10FB05G) (OPT HTFB05V (V50294)) (OPT KNDB5-62 (V97613)) (OPT KSC145700BZG5 (V50632)) (OPT NRRS05FBG (V73134)) (OPT HTFB05V (V50352)) (OPT ITEM 210)	A-D,J ,K	1
215	ADW4V301NC		..BEARING- (V15860) (SPEC BACB10FA04GC) (OPT KSC152200BZ4GC (V50632)) (OPT KWDB4-35 (V97613)) (OPT WHTFA04VC (V50294)) (OPT WRRS04FAGC (V73134)) (OPT ADW04V301NC (V15860))	A-D,J ,K	1
-215A	ADW5V301NC		..BEARING- (V15860) (SPEC BACB10FA05GC) (OPT KSC152200BZ5CC (V50632)) (OPT KWDB5-35 (V97613)) (OPT WHTFA05VC (V50294)) (OPT WRRS05FAGC (V73134)) (OPT SWKRS05-350SC (V81376))	E-H	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
217	114T6428-1		..WASHER	E-H	2
220	114T6404-2		..LINK	A-D,J,K	1
-220A	114T6422-2		..LINK	E-H	1
225	114T6402-1		.LEVER ASSY-LWR	A-D,J,K	1
-225A	114T6425-1		.LEVER ASSY-LWR	E-H	1
230	M81934-2-09A016		..BEARING	A-D,J,K	2
-230A	M81934-2-11A018		..BUSHING	E-H	2
235	BACB28AM09B030A		..BUSHING	A-D,J,K	1
-235A	BACB28AM13B029A		..BUSHING	E-H	1
240	BACB28AP06P030		..BUSHING	A-D,J,K	1
-240A	BACB28AP09P029		..BUSHING	E-H	1
245	BACB28AM06B014A		..BUSHING	A-D,J,K	1
-245A	BACB28AM07B027A		..BUSHING	E-H	1
250	BACB28AP04P014		..BUSHING	A-D,J,K	1
-250A	BACB28AP05P027		..BUSHING	E-H	1
255	114T6402-2		..LEVER	A-D,J,K	1
-255A	114T6425-2		..LEVER	E-H	1

- Item Not Illustrated