

 **BOEING**  
COMPONENT  
MAINTENANCE MANUAL

TO: ALL HOLDERS OF MLG DOOR HINGE BELLCRANK ASSEMBLY - COMPONENT MAINTENANCE  
MANUAL 32-12-05

REVISION NO.11 DATED MAR 01/01

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 bellcrank assemblies 149T6902-107 and -108 with a new filler in the 149T6962 upstop fitting.

1

1005-1020,1024,  
1027-1029,1031-1035,  
1039,1042-1043

REPAIR 10-1

Added clarifications and updated callouts.

601

701-702

1005-1020,1027-1043

1005-1020,1040

Changed part number callout of washer (585).

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HIGHLIGHTS

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MAIN LANDING GEAR DOOR HINGE  
BELLCRANK ASSEMBLY

PART NUMBERS 149T6902-5,-6,-39,-40,  
-43 THRU -46,  
-69 THRU -72,  
-107,-108

COMPONENT MAINTENANCE MANUAL  
WITH  
ILLUSTRATED PARTS LIST

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REVISION RECORD

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

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


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## TEMPORARY REVISION AND SERVICE BULLETIN RECORD

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVE	DATE OF INCORPORATION INTO MANUAL
32-7 32-24R1		PRR B10183 PRR B10036 PRR B10787 MC B1323-001K MC B1323-001K PRR B11491-1	JUL 10/81 JUL 10/81 OCT 10/84 APR 10/85 APR 10/85 JAN 10/87

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TR &amp; SB RECORD

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*1	MAR 01/01	01.1	601	NOV 01/00	01.1
2	BLANK		602	NOV 01/00	01.1
REVISION RECORD			REPAIR 1-1		
1	JUL 10/83	01	601	JUN 01/95	01.1
2	BLANK		602	JUN 01/95	01.1
TR & SB RECORD			603	JUN 01/95	01.1
1	JAN 10/87	01.1	604	BLANK	
2	BLANK		REPAIR 1-2		
LIST OF EFFECTIVE PAGES			601	JUN 01/95	01.1
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			606	BLANK	

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REPAIR 5-2			803	JUN 01/95	01.1
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REPAIR 6-1			808	OCT 10/86	01.101
601	OCT 10/84	01.1	ILLUSTRATED PARTS LIST		
602	BLANK		1001	JUL 10/83	01
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602	APR 10/85	01.1	1004	JAN 10/84	01.1
603	OCT 10/86	01.1	*1005	MAR 01/01	01.1
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602	BLANK		*1011	MAR 01/01	01.1
REPAIR 8-1			*1012	MAR 01/01	01.1
601	JAN 10/87	01.1	*1013	MAR 01/01	01.1
602	BLANK		*1014	MAR 01/01	01.1
REPAIR 9-1			*1015	MAR 01/01	01.1
601	NOV 01/00	01.1	*1016	MAR 01/01	01.1
602	BLANK		*1017	MAR 01/01	01.1
REPAIR 10-1			*1018	MAR 01/01	01.1
*601	MAR 01/01	01.1	*1019	MAR 01/01	01.1
602	JUN 01/95	01.1	*1020	MAR 01/01	01.1
ASSEMBLY			*1021	MAR 01/01	01.101
*701	MAR 01/01	01.1	*1022	MAR 01/01	01.101
*702	MAR 01/01	01.1	*1023	MAR 01/01	01.101
703	APR 10/85	01.101	*1024	MAR 01/01	01.1
704	JAN 10/87	01.1	*1025	MAR 01/01	01.101
			*1026	MAR 01/01	01.101
			*1027	MAR 01/01	01.1
			*1028	MAR 01/01	01.1
			*1029	MAR 01/01	01.1
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			*1032	MAR 01/01	01.1

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*1033	MAR 01/01	01.1			
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*1036	MAR 01/01	01.1			
*1037	MAR 01/01	01.1			
*1038	MAR 01/01	01.1			
*1039	MAR 01/01	01.1			
*1040	MAR 01/01	01.1			
*1041	MAR 01/01	01.1			
*1042	MAR 01/01	01.1			
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## INTRODUCTION

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

This manual is divided into separate sections:

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

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

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

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

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

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

Verification:

Assembly

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INTRODUCTION

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BELLCRANK ASSEMBLY - MLG DOOR HINGE

DESCRIPTION AND OPERATION

1. Description and Operation

A. The bellcrank assembly is a hinged assembly which transmits and regulates the opening and closing motion of the main landing gear door. Two stops, one on each side of the bellcrank, stop the door at the fully closed and the fully open position.

2. Leading Particulars (approximate)

Length -- 29 inches

Width -- 24 inches

Height -- 14 inches

Weight -- 98 pounds

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DESCRIPTION & OPERATION

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DISASSEMBLY

1. Use standard industry practices for disassembly of this component.

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.

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DISASSEMBLY

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CLEANING

1. Clean all parts by standard industry practices and the data in SOPM 20-30-03.

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CHECK

NOTE: Refer to IPL Fig. 1 for item numbers.

1. Examine all parts for obvious defects with standard industry practices.  
Refer to Fits and Clearances for design dimensions and wear limits.
2. Magnetic particle check per 20-20-01 -- Plates (445, 455), link tube (735), bushings (495, 510), stop (10), pins (365, 380).
3. Penetrant check per 20-20-02 -- Bellcrank (550, 553), bushings (500, 505, 515), fittings (165, 170, 220, 225, 305, 310, 355, 470, 475, 480, 485, 665, 668, 670, 673), stop (90), washers (370, 375).

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CHECK

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REPAIR – GENERAL1. Content

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

<u>P/N</u>	<u>NAME</u>	<u>REPAIR</u>
149T6931	ACTUATOR SUPPORT FITTING	1-1, 1-2
149T6955	BELLCRANK ASSEMBLY	2-1, 2-2
149T6963	FITTING ASSEMBLY	3-1
149T6988	FITTING ASSEMBLY	4-1, 4-2
149T6989	FITTING ASSEMBLY	5-1, 5-2
149T7801	FITTING ASSEMBLY	6-1, 6-2
149T6986	PIN	7-1
149T6985	BOLT	8-1
BACB30UU10K46	BOLT	8-1
BACB28AK12-066	BUSHING	9-1
- - - -	MISCELLANEOUS PARTS REFINISH	10-1

2. Standard Practices

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

20-10-04	Grinding of Chrome Plated Parts
20-30-02	Stripping of Protective Finishes
20-30-03	General Cleaning Procedures
20-41-01	Decoding Table for Boeing Finish Codes
20-41-02	Application of Chemical and Solvent Resistant Finishes
20-42-02	Low Hydrogen Embrittlement Cadmium-Titanium Alloy Plating
20-42-03	Hard Chrome Plating
20-43-01	Chromic Acid Anodizing
20-50-03	Bearing and Bushing Replacement
20-60-02	Finishing Materials
20-60-03	Lubricants
20-60-04	Miscellaneous Materials

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### 3. Materials

NOTE: Equivalent substitutes can be used.

- A. Enamel -- BMS 10-11, type 2, BAC702 white gloss (Ref 20-60-02)
- B. Grease -- BMS 3-24 (Ref 20-60-03)
- C. Primer -- BMS 10-11, type 1 (Ref 20-60-02)
- D. 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 SOPM 20-00-00.

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ACTUATOR SUPPORT ASSEMBLY – REPAIR 1-1

149T6931-1 thru -4, -9 thru -12,  
-17 thru -20, -25 thru -28

**NOTE:** Refer to REPAIR-GENERAL for a list of applicable standard practices. Refer to IPL Fig. 1 for item numbers. For repair of surfaces which is only replacement of the original finish, refer to Refinish instructions, REPAIR 1-2.

1. Bushing (410, 415, 420, 422, 425, 427, 428A) Replacement

- A. Remove the bushings.
- B. If you find defects on the support, refer to REPAIR 1-2 for repair instructions.
- C. Install bushings per SOPM 20-50-03 with wet BMS 5-95 sealant.
- D. Machine bushings (410, 415, 420, 422, 425, 428A) as shown.
- E. Fillet seal all around the bushing flanges with BMS 5-95 sealant.

2. Bearing (430, 435) Replacement

- A. Remove the bearings.
- B. Install the replacement bearings per SOPM 20-50-03 with BMS 3-24 grease. Roller or anvil stake the bearings over the housing.

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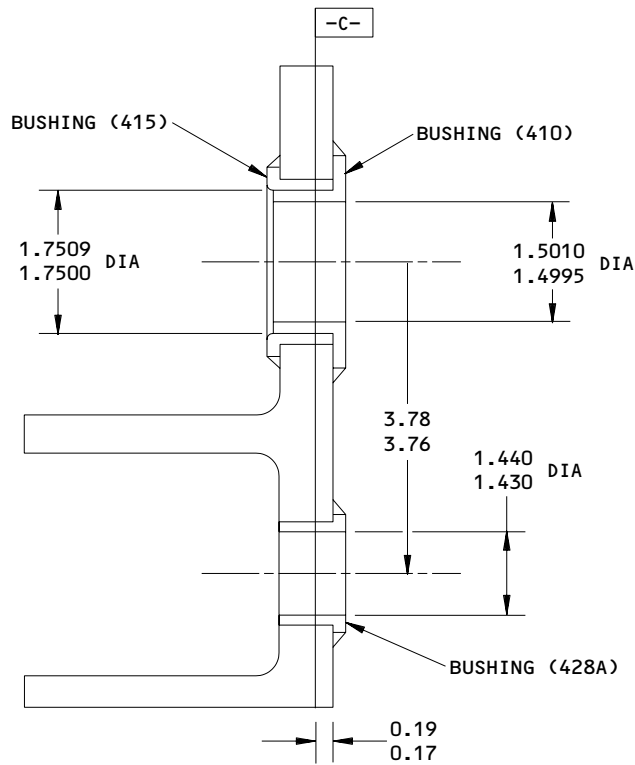
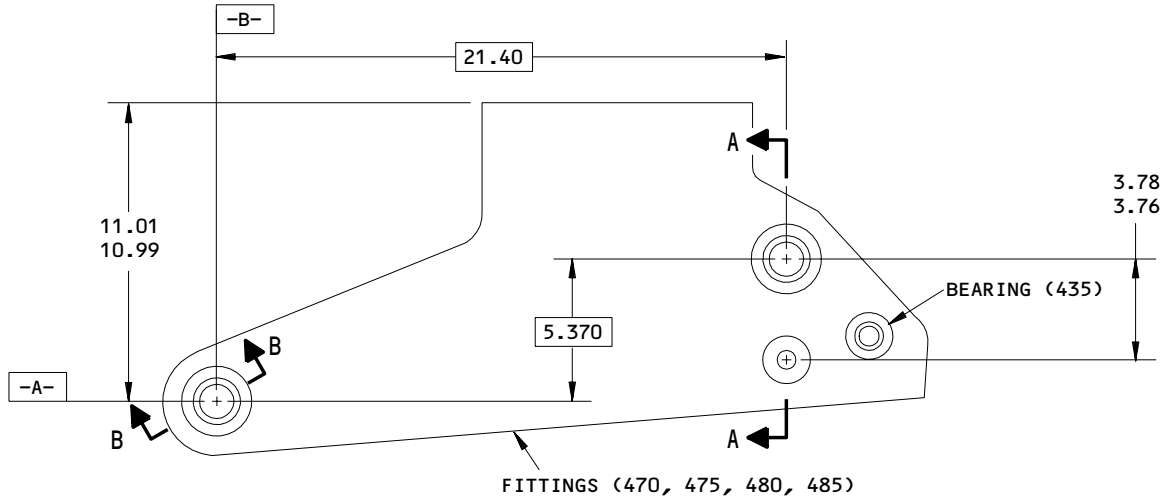
REPAIR 1-1

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149T6931-1 THRU -4,-9 THRU -12,-17 THRU -20,-25 THRU -28  
 A-A

ITEM NUMBERS REFER TO IPL FIG. 1  
 ALL DIMENSIONS ARE IN INCHES

Actuator Support Assembly Bushing Replacement  
 Figure 601 (Sheet 1)

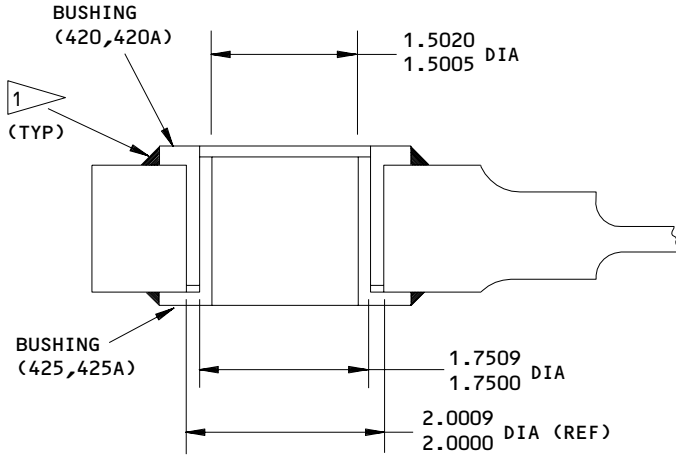
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REPAIR 1-1

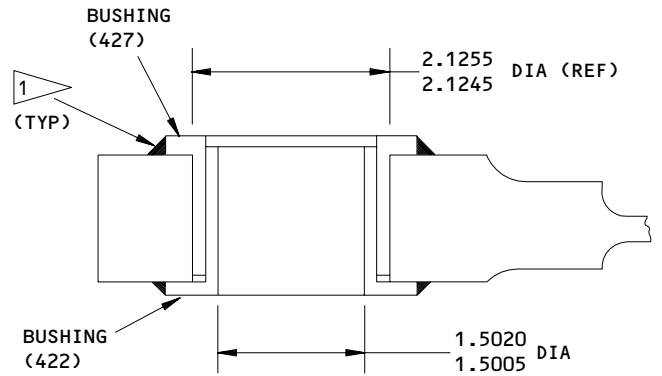
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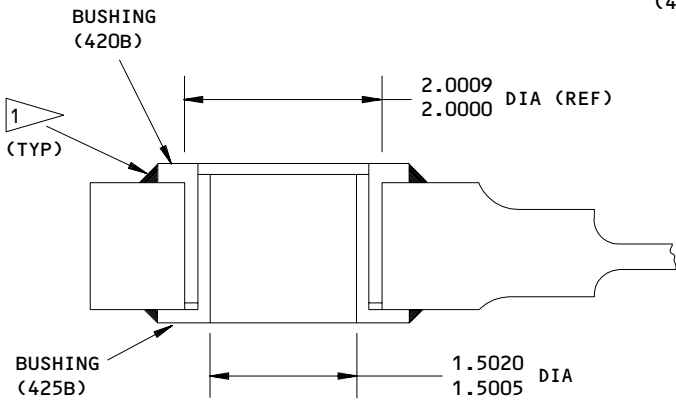
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149T6931-1 THRU -4,-17 THRU -20,-25,-26  
 B-B



149T6931-9 THRU -12  
 B-B



149T6931-27,-28  
 B-B

⊕	⊘ 0.002	Ⓜ	A	B
	⊘ 0.001	Ⓢ		

1 BMS 5-95 SEALANT

ITEM NUMBERS REFER TO IPL FIG. 1  
 ALL DIMENSIONS ARE IN INCHES

Actuator Support Fitting Bushing Replacement  
 Figure 601 (Sheet 2)

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REPAIR 1-1

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ACTUATOR SUPPORT - REPAIR 1-2

149T6931

NOTE: Refer to REPAIR-GENERAL for a list of applicable standard practices. For repair which is only replacement of the original finish, refer to Refinish instructions, Fig. 601.

1. Lug Faces and Holes (Fig. 601)

## A. Method 1 - Installation of oversize smaller nested bushing

- (1) Remove the inner bushing (422). Keep bushing (427) in the hole for now.
- (2) Machine the bore of bushing (427), as necessary, within repair limits, to remove defects. If more material removal than this is necessary, remove the bushing completely and use Method 2.
- (3) Cadmium plate the bore of bushing (427) per 20-42-05, type 2, class 2 (F-15.06).
- (4) Make an oversize bushing as shown in Fig. 602, to make allowance for the amount of material removed in step (2).
- (5) Install the bushing per REPAIR 1-1.

## B. Method 2 - Installation of other oversize bushings

- (1) Remove all of the bushings from the hole.
- (2) Machine the hole as necessary, within repair limits, to remove defects.
- (3) Shot peen and chromic acid anodize the machined hole, as indicated.
- (4) Make oversize bushings as necessary, as shown in Fig. 602 to make allowance for the amount of material removed.
- (5) Install the bushings per REPAIR 1-1.

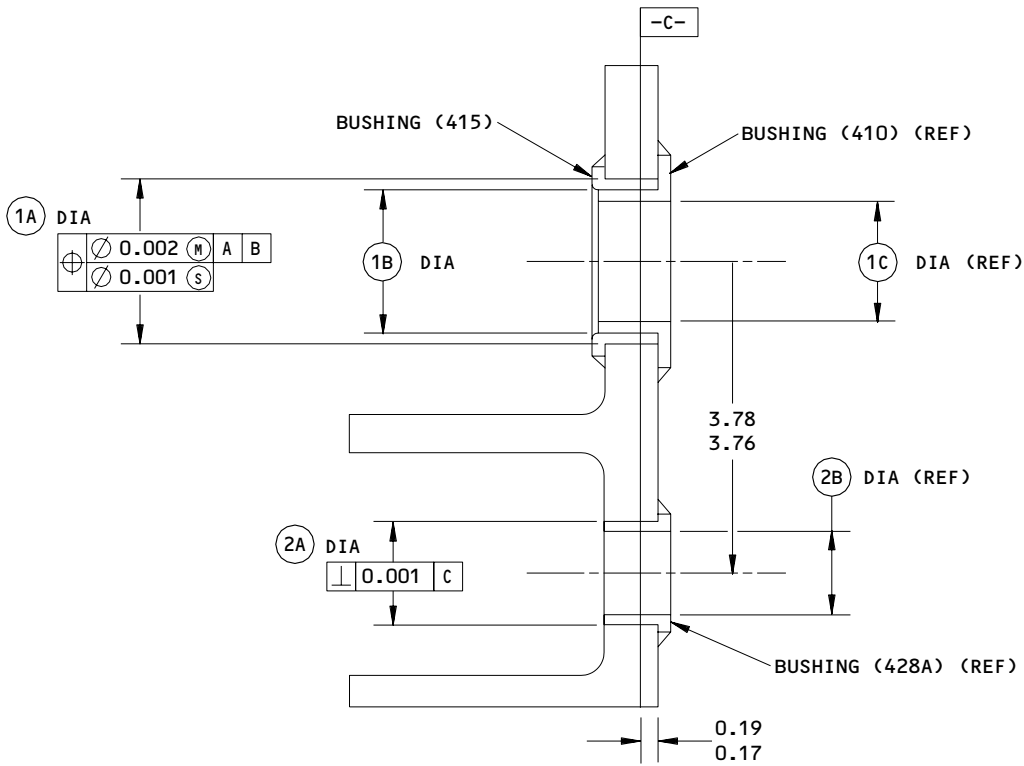
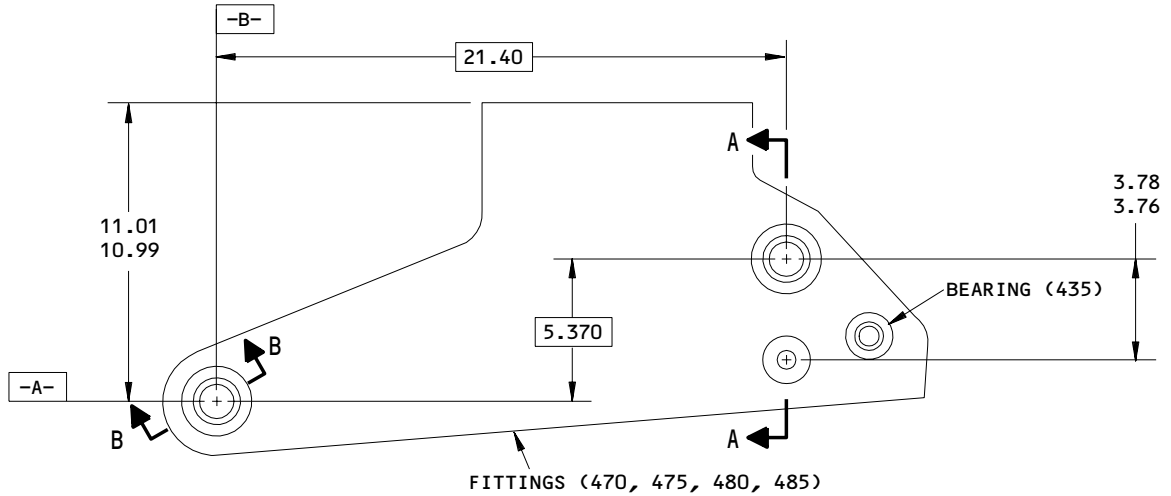
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REPAIR 1-2

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149T6931-1 THRU -4,-9 THRU -12,-17 THRU -20,-25 THRU -28  
 A-A

ITEM NUMBERS REFER TO IPL FIG. 1  
 ALL DIMENSIONS ARE IN INCHES

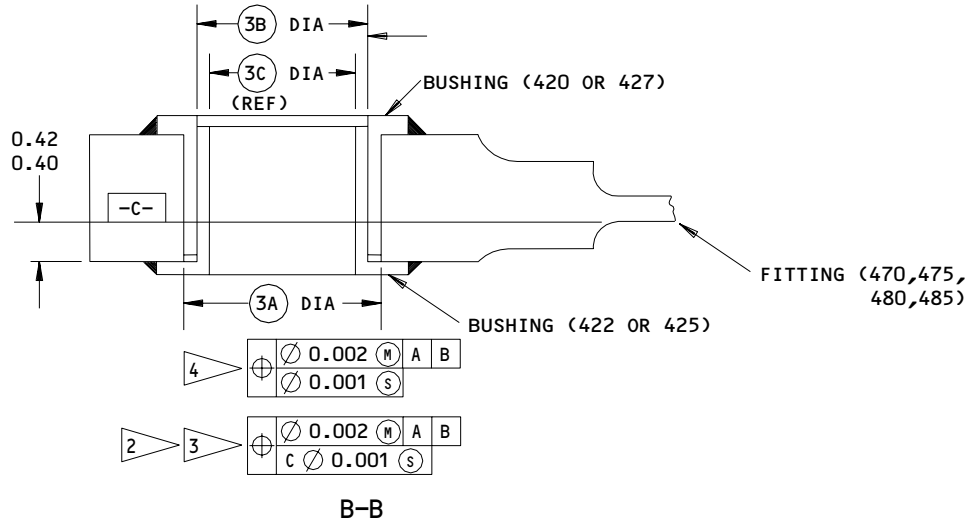
Actuator Support Fitting Repair  
 Figure 601 (Sheet 1)

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REFERENCE NUMBER	1A	1B	1C	2A	2B	3A	3A	3B	3B
DESIGN DIMENSION (ID)	2.0009 2.0000	1.7509 1.7500	1.5010 1.4995	1.5629 1.5619	1.440 1.430	2.0009 2.0000	2.1255 2.1245	1.7509 1.7500	1.8045 1.8036
REPAIR LIMIT <sup>1</sup>	--	1.8109	--	--	--	--	2.1855	--	1.8645

REFERENCE NUMBER	3C
DESIGN DIMENSION	1.5020 1.5005
REPAIR LIMIT	--

**REFINISH**

CHROMIC ACID ANODIZE AND APPLY PRIMER BMS 10-11, TYPE 1 (F-18.13), BUT NO PRIMER IN HOLES.

AFTER BUSHING AND BEARING INSTALLATION APPLY WHITE ENAMEL BMS 10-11, TYPE 2 (F-21.03) ALL OVER BUT NOT ON BUSHINGS OR BEARINGS.

<sup>1</sup> LIMIT FOR INSTALLATION OF OVERSIZE BUSHING

<sup>2</sup> 149T6931-1 THRU -4, -17 THRU -20

<sup>3</sup> 149T6931-9 THRU -12

<sup>4</sup> 149T6931-25 THRU -28

**REPAIR**

REF <sup>1</sup>

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

SHOT PEEN: 0.023-0.055 SHOT SIZE  
 0.010 A INTENSITY  
 2.0 COVERAGE

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

Actuator Support Fitting Repair  
 Figure 601 (Sheet 2)

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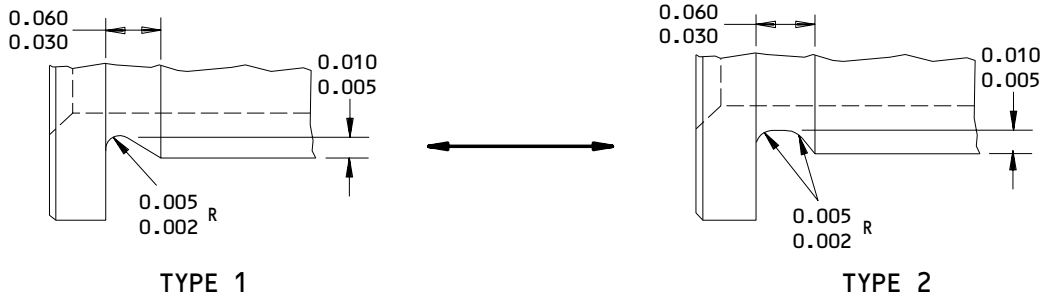
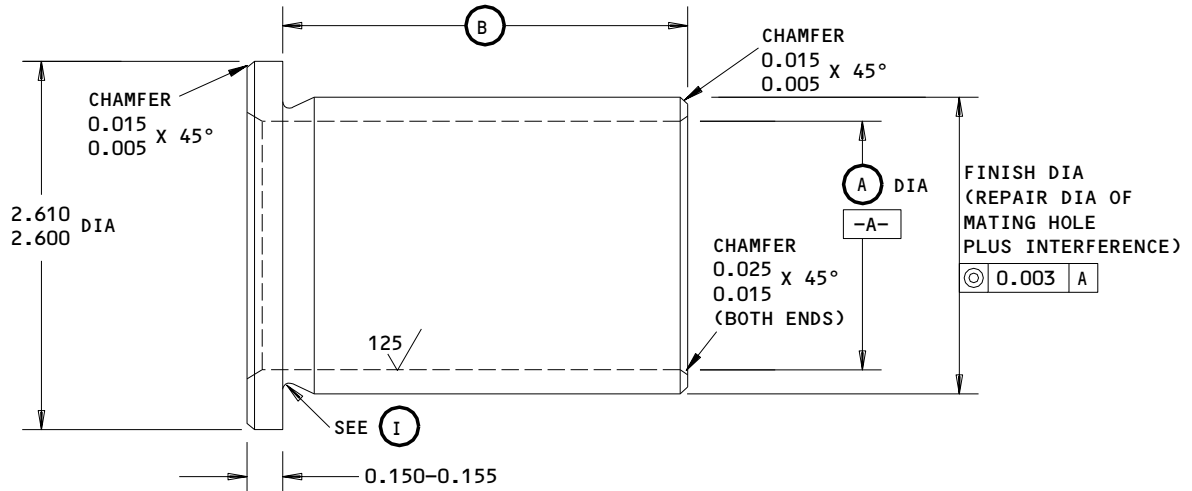
REPAIR 1-2

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UNDERCUT TYPE 1 OR TYPE 2 OPTIONAL

I

HOLE LOCATION (FIG. 601)	REPLACES BUSHING (IPL FIG. 1)	A	B	INTERFERENCE	MATERIAL
3B	(422) 012T2400-48	1.5015 1.5006	1.350 1.345	0.0017 0.0001	1
3A	(427) 012T2400-49	1.8045 1.8036	1.250 1.245	0.0031 0.0012	2
1B	(410) 012T2400-24	1.486 1.469	0.730 0.725	0.0029 0.0011	1

FINISH: CADMIUM PLATE (F-15.06)

- 1 AL-NI-BRZ PER AMS 4640
- 2 15-5PH CRES, 180-200 KSI

63/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

ALL DIMENSIONS APPLY AFTER PLATING

ALL DIMENSIONS ARE IN INCHES

Oversize Bushing Details  
Figure 602

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REPAIR 1-2

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BELLCRANK ASSEMBLY – REPAIR 2-1

149T6955-8, -11

**NOTE:** Refer to REPAIR-GENERAL for a list of applicable standard practices.  
Refer to IPL Fig. 1 for item numbers.

**1. Bushing Replacement (Fig. 601)**

- A. Remove the old bushings.
- B. If you find defects on the bellcrank, refer to REPAIR 2-2 for repair instructions.
- C. Install replacement bushings by the shrink-fit method (SOPM 20-50-03).
- D. Machine the bushings to design dimensions and finish as shown in Fig. 601.
- E. Fillet seal around the bushing flanges and fill the gap between bushings (518 or 519) with BMS 5-95 sealant.

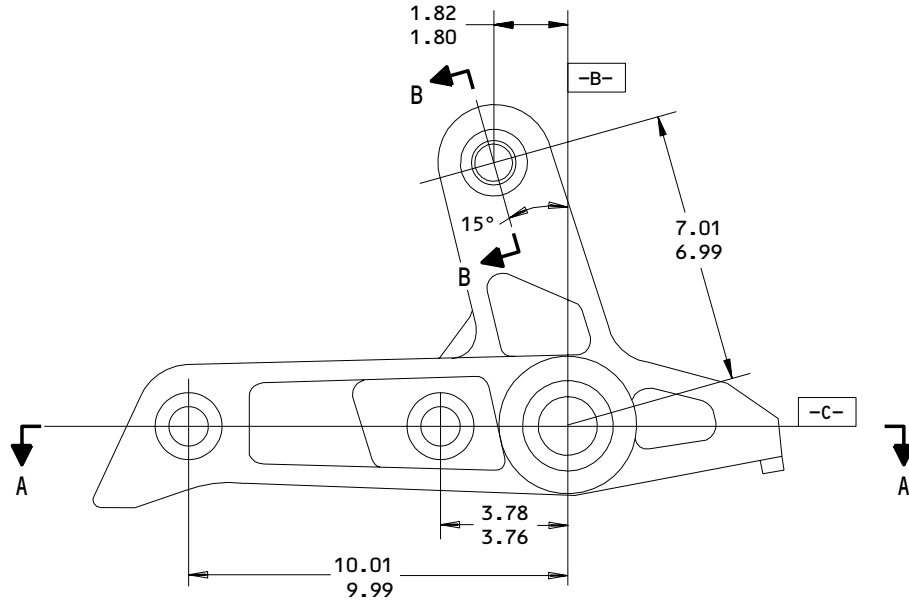
**32-12-05**

REPAIR 2-1

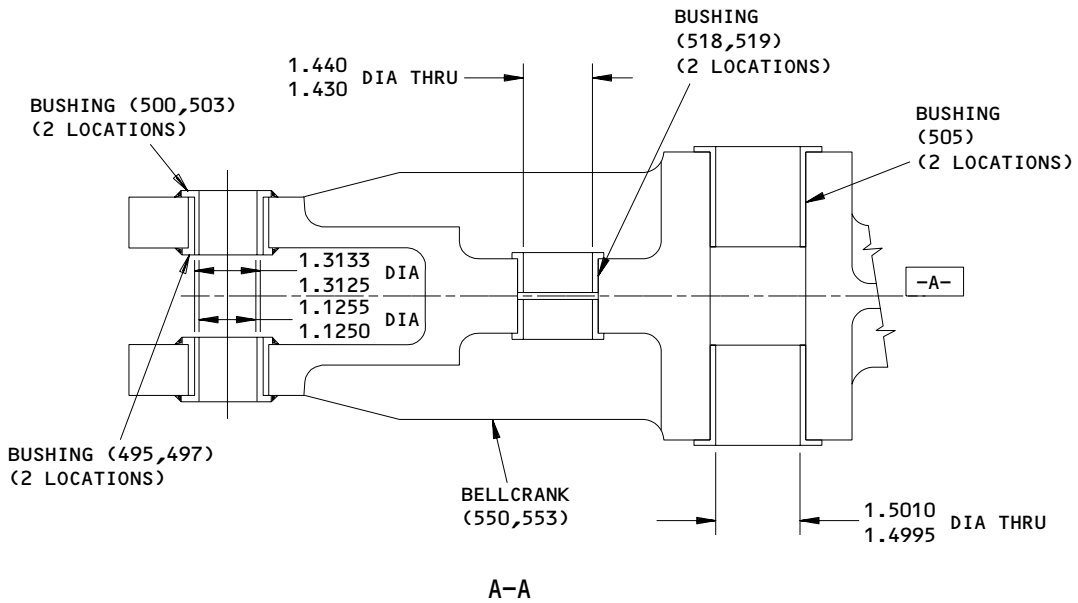
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149T6955-11 SHOWN



149T6955-5,-11  
 Bellcrank Assembly Bushing Replacement  
 Figure 601 (Sheet 1)

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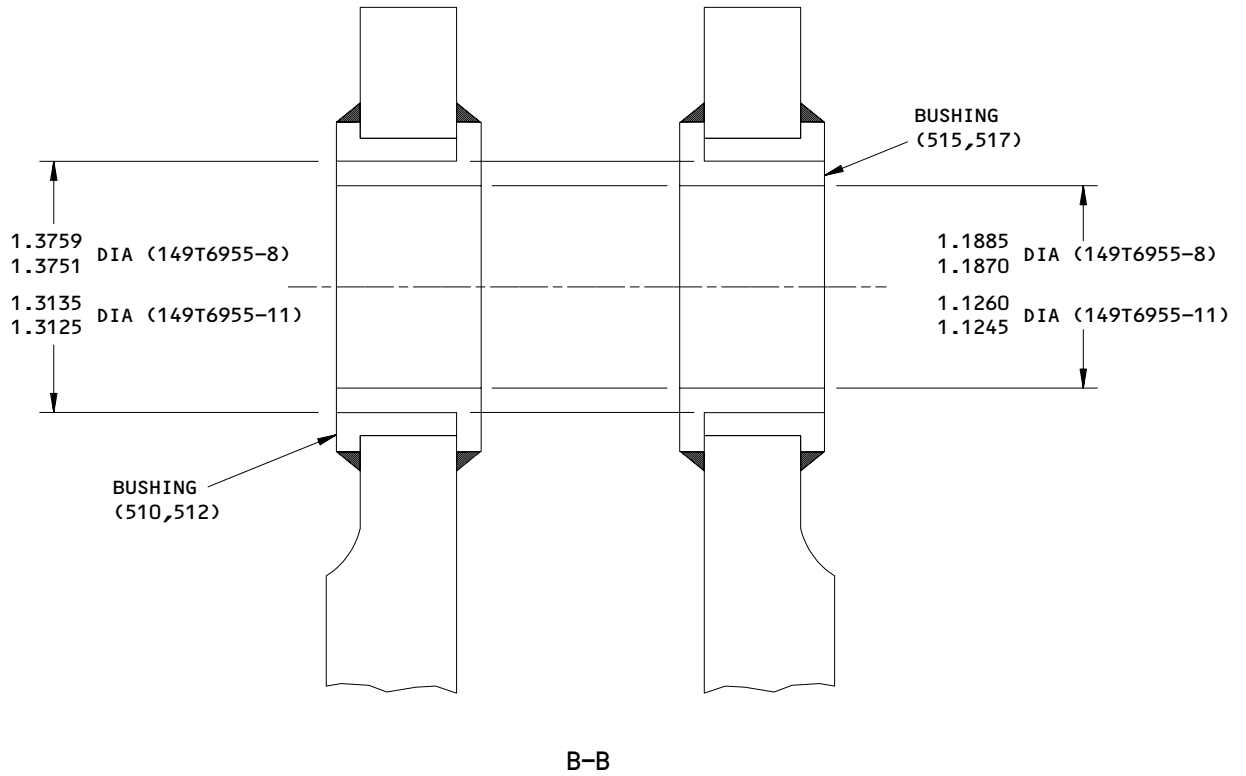
REPAIR 2-1

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125/ ALL MACHINED SURFACES UNLESS SHOWN  
 DIFFERENTLY

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

149T6955-8,-11  
 Bellcrank Assembly Bushing Replacement  
 Figure 601 (Sheet 2)

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REPAIR 2-1

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BELLCRANK ASSEMBLY – REPAIR 2-2

149T6955-8, -11

**NOTE:** Refer to REPAIR-GENERAL for a list of applicable standard practices.

**1. Repair** (Fig. 601)

- A. Machine as required, within repair limits, to remove defects.
- B. Chemical treat the machined surfaces.
- C. Make oversize bushing (Fig. 602) to adjust for the material removed.
- D. Install the bushings per REPAIR 2-1.

**2. Refinish**

- A. Bellcrank (550, 553) -- Chromic acid anodize and apply BMS 10-11, type 1 primer (F-18.13) and BMS 10-11, type 2 enamel (F-21.03), but no primer or enamel in holes for bushings. Material: Al alloy.

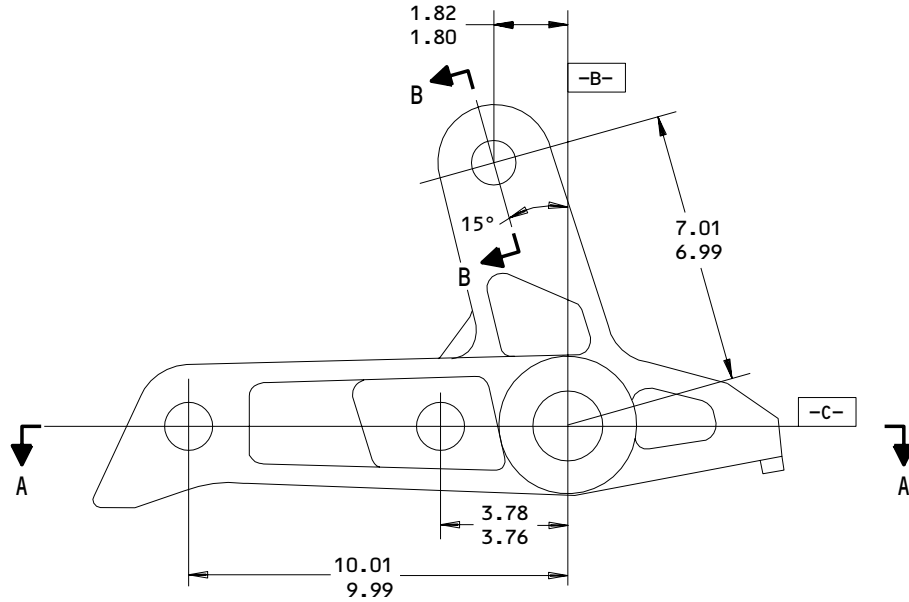
**32-12-05**

REPAIR 2-2

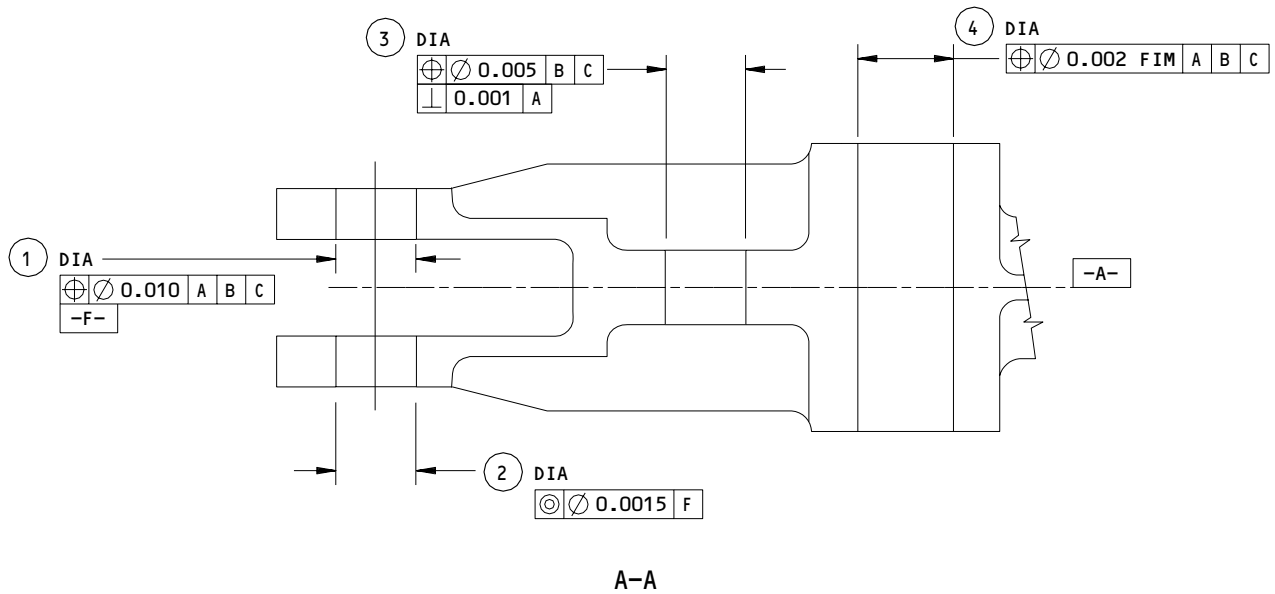
01.1

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149T6955-9 SHOWN



149T6955-2,-9  
 Bellcrank Repair  
 Figure 601 (Sheet 1)

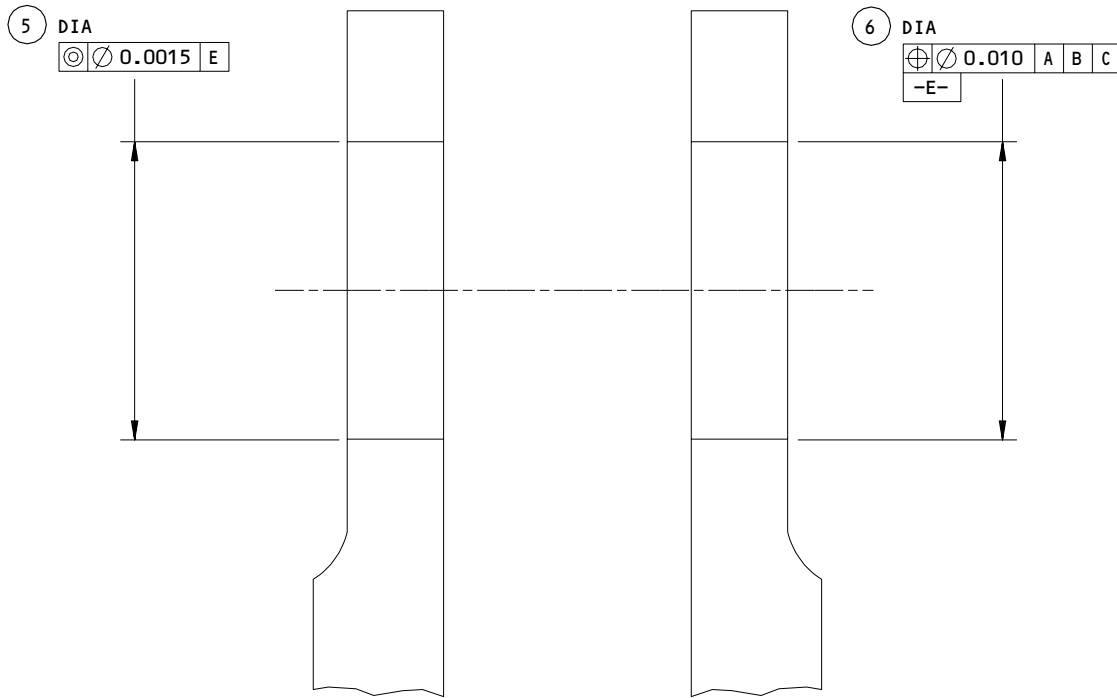
**32-12-05**

REPAIR 2-2

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01.1



B-B

REFERENCE NUMBER	①	②	③	④	⑤ 1	⑤ 2	⑥ 1	⑥ 2
DESIGN DIMENSION	1.5007 1.4999	1.5007 1.4999	1.5629 1.5619	1.7009 1.7000	1.5631 1.5625	1.5007 1.4999	1.5631 1.5625	1.5007 1.4999
REPAIR LIMIT <sup>3</sup>	1.5607	1.5607	1.6229	1.7609	1.6231	1.5607	1.6231	1.5607

- 1 149T6955-9
- 2 149T6955-2
- 3 LIMIT FOR INSTALLATION OF OVERSIZE BUSHING

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

149T6955-2,-9  
 Bellcrank Repair  
 Figure 601 (Sheet 2)

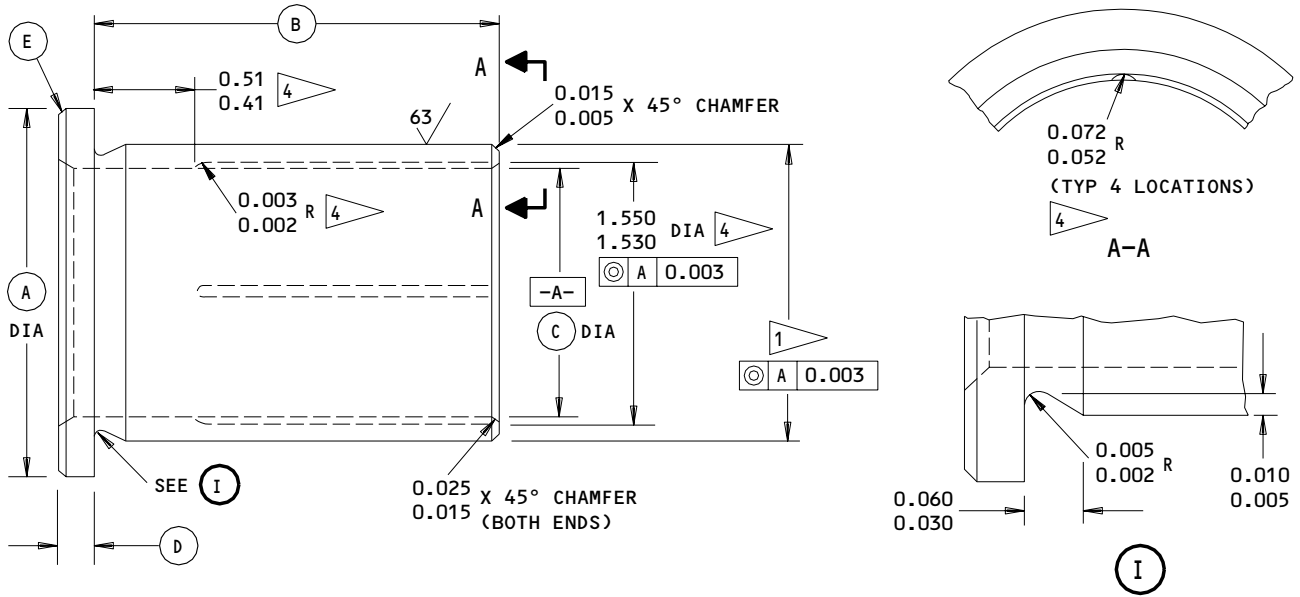
**32-12-05**

REPAIR 2-2

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HOLE LOCATION (FIG. 601)	BUSHING ITEM NO. (IPL FIG 1)	A	B	C	D	E	INTERFERENCE	MATERIAL
① ②	(495) 149T6922-1	1.760 1.740	0.990 0.970	1.298 1.283	0.070 0.060	0.030 0.020 X 45°	0.0024 0.0008	②
① ②	(497) 149T6922-19	1.760 1.740	1.090 1.070	1.298 1.283	0.070 0.060	0.030 0.020 X 45°	0.0024 0.0008	③
③	(518) 149T6955-6	1.760 1.740	0.700 0.695	1.356 1.344	0.060 0.055	---	0.0024 0.0008	⑤
③	(519) 149T6955-10	1.760 1.740	1.000 0.995	1.356 1.344	0.060 0.055	---	0.0024 0.0008	⑤
④	(505) 149T6922-3	2.060 2.050	1.60 1.40	1.480 1.470	0.155 0.150	0.125 0.105 X 45°	0.0028 0.0010	③
⑤ ⑥	(510) 149T6922-5	1.760 1.790	0.490 0.470	1.298 1.283	0.070 0.060	0.030 0.010 X 45°	0.0024 0.0008	②
⑤ ⑥	(512) 149T6922-17	1.810 1.790	0.590 0.570	1.356 1.344	0.070 0.060	0.030 0.020 X 45°	0.0024 0.0008	②

- ① FINISH DIA (REPAIR DIA OF HOLE PLUS INTERFERENCE)
- ② 15-5PH CRES, 180-200 KSI
- ③ AL-NI-BRZ PER AMS 4640
- ④ LUBRICATION CHANNEL, ON BUSHING (505) ONLY
- ⑤ 17-4PH CRES, 180-200 KSI

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

CADMIUM PLATE (F-15.06). NO PLATING IN ID

DIMENSIONS APPLY AFTER PLATING

ALL DIMENSIONS ARE IN INCHES

Oversize Bushing Details  
 Figure 602

**32-12-05**

REPAIR 2-2

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FITTING ASSEMBLY – REPAIR 3-1

149T6963-1

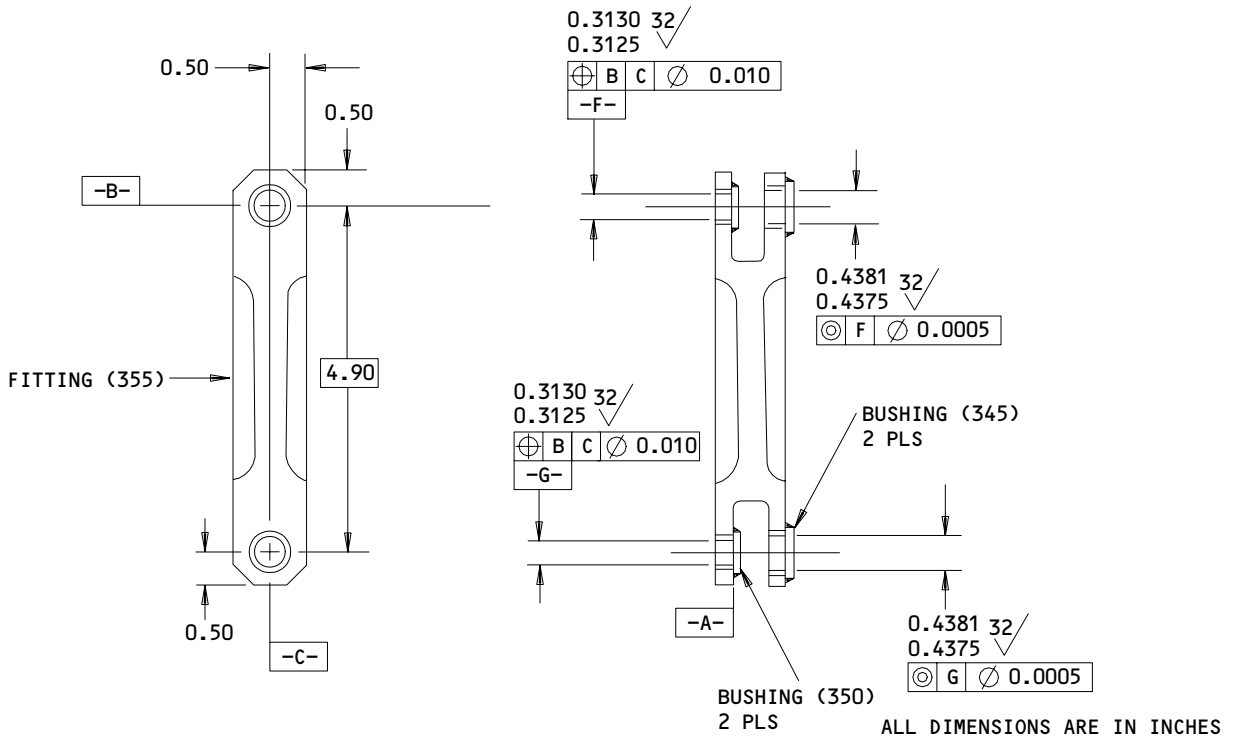
**NOTE:** Refer to REPAIR-GENERAL for list of applicable standard practices.

1. Bushing (345, 350) Replacement (IPL Fig. 1)

- A. Remove bushings.
- B. Install bushings per 20-50-03 using wet BMS 5-95 sealant.
- C. Machine bushings as shown in Fig. 601.
- D. Fillet seal entire periphery of bushing flanges with BMS 5-95 sealant.

2. Refinish

- A. Fitting (355) -- Chromic acid anodize, type 1, and apply one coat BMS 10-11, type 1 primer omitting primer in bushing holes (F-18.13). Apply one coat BMS 10-11, type 2 enamel, BAC702 white gloss omitting enamel in bushing holes (F-21.03). Material: Aluminum alloy.



Cross Link Fitting Assembly Repair  
 Figure 601

**32-12-05**

REPAIR 3-1

01

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FITTING ASSEMBLY - REPAIR 4-1

149T6988-1, -2

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

1. Bushing (155, 160) Replacement (IPL Fig. 1)

- A. Remove bushings.
- B. Install bushings per 20-50-03 using wet BMS 5-95 sealant.
- C. Machine bushings as shown in Fig. 601.
- D. Remove cadmium plating from flange surface of bushing (155) and chromium plate, Class 2A, 0.001 to 0.002 inch thick with 63 microinch finish.
- E. Fillet seal entire periphery of flanges on both ends of bushings with BMS 5-95 sealant.

2. Refinish

- A. Fitting (165, 170) -- Chromic acid anodize, type 1, and apply one coat BMS 10-11, type 1 primer omitting primer in bushing holes (F-18.13).  
Material: Aluminum alloy.
- B. Fitting assembly (95, 100) -- Apply one coat BMS 10-11, type 2 enamel, BAC702 white gloss (F-21.03) omitting enamel on bushings.

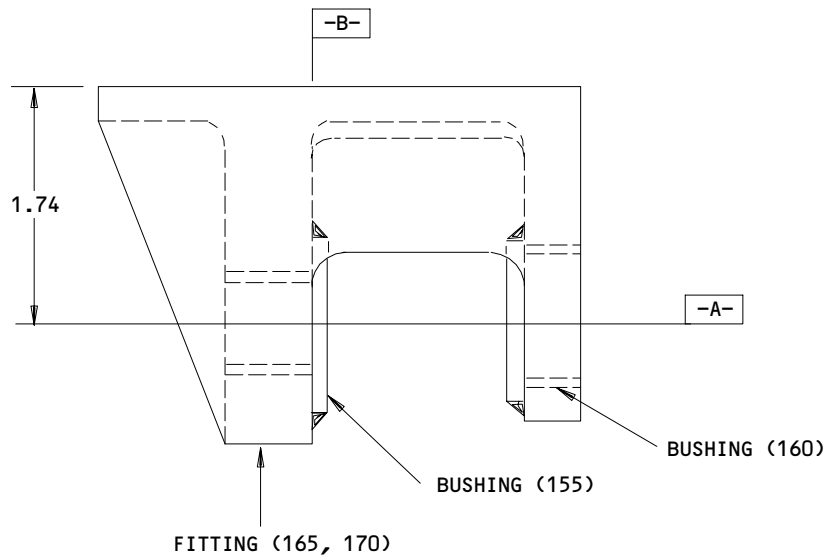
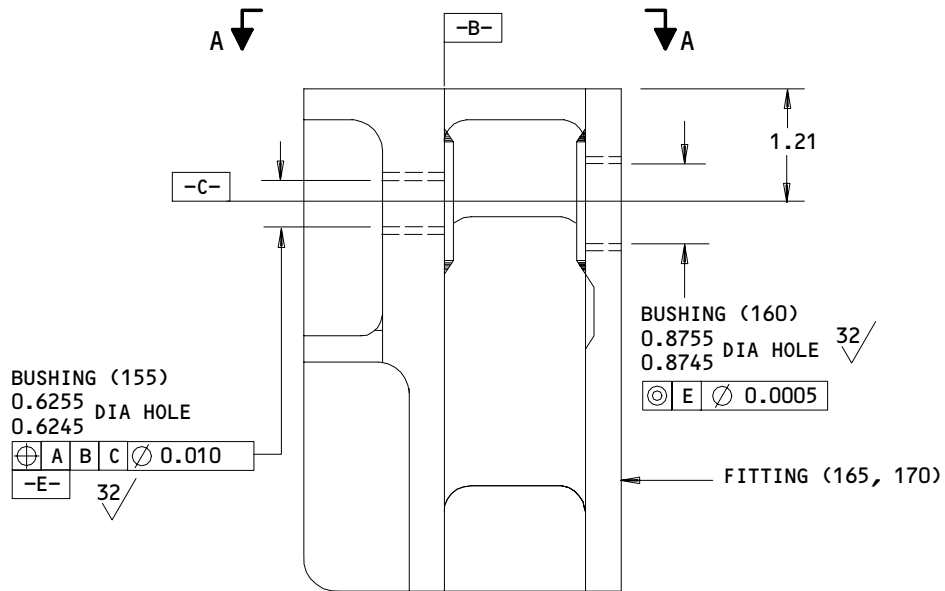
**32-12-05**

REPAIR 4-1

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A-A  
 Fitting Assembly Repair  
 Figure 601

ALL DIMENSIONS ARE IN INCHES

**32-12-05**

REPAIR 4-1

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01.1



FITTING ASSEMBLY - REPAIR 4-2

149T6988-1, -2

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

1. Repair (IPL Fig. 1)

## A. Method 1 - Installation of oversize bushing replacing bushing (615).

- (1) Machine bushing (160), if and as required, to a maximum diameter of 0.9355 inch, concentric with bushing (155) within 0.0005 inch.
- (2) Fabricate oversize bushing to provide a 0.0005-0.0020 inch clearance per Fig. 602.

## B. Method 2 - Installation of oversize bushings replacing bushings (155, 160)

- (1) Remove bushings (155, 160).
- (2) Machine fitting (165, 170), if and as required, per Fig. 601.
- (3) Shot peen and chromic acid anodize, type 1 oversize bushing holes per Fig. 601.
- (4) Fabricate oversize bushing to replace bushing (155) per Fig. 603.
- (5) Fabricate oversize bushing to replace bushing (160) per Fig. 604.
- (6) Install oversize bushing per REPAIR 4-1.

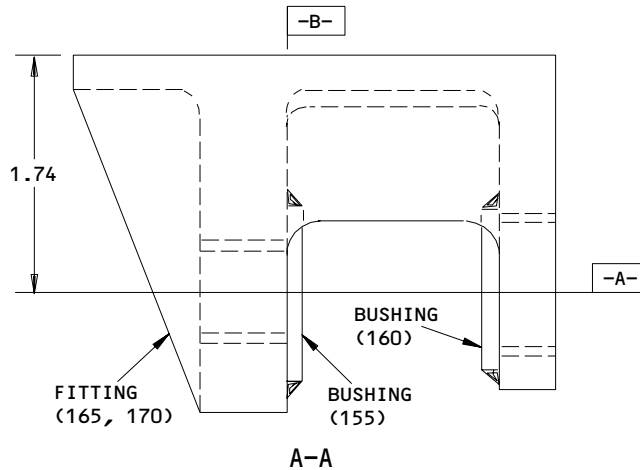
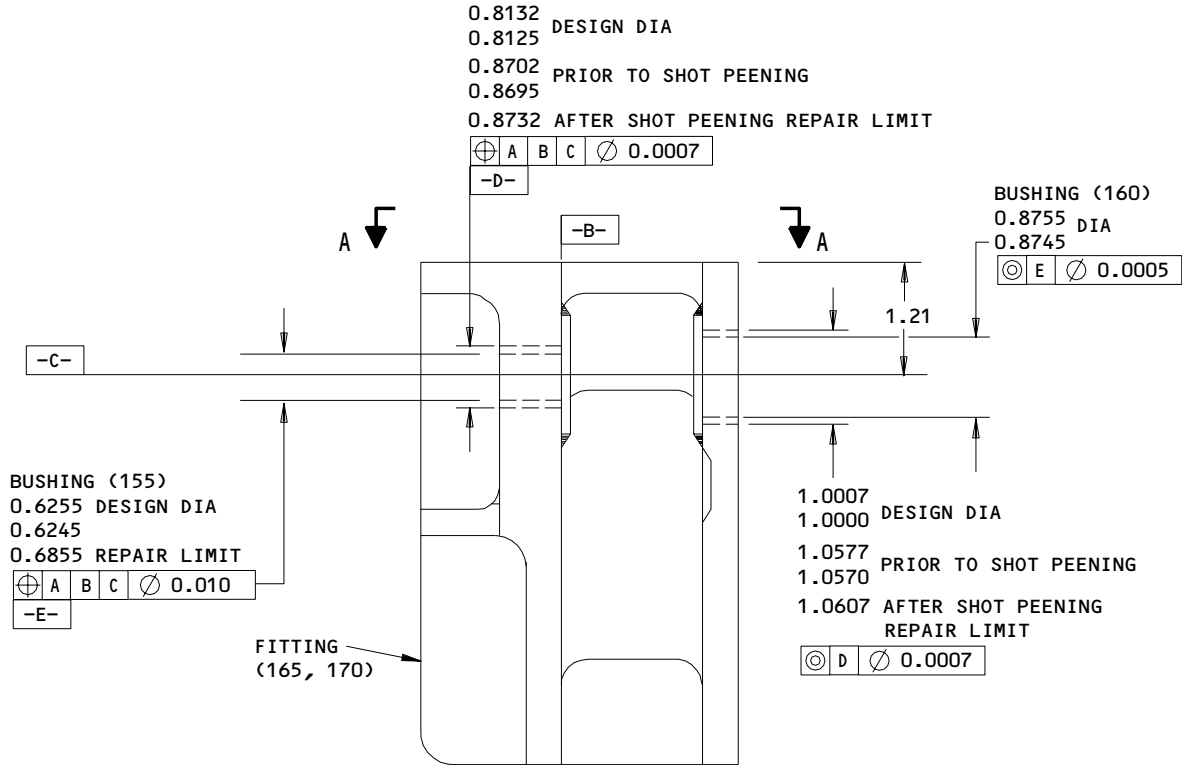
**32-12-05**

REPAIR 4-2

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**COMPONENT  
MAINTENANCE MANUAL**

**REFINISH:**

REFER TO REPAIR 4-1

**REPAIR:**

$32/\sqrt{\text{in}}$  ALL MACHINED SURFACES  
 SHOT PEEN: 0.023-0.055 SHOT SIZE  
 0.012 A INTENSITY  
 2.0 COVERAGE  
 MATERIAL: 7075-T73 AL ALLOY  
 ALL DIMENSIONS ARE IN INCHES

149T6988-1,-2  
 Fitting Assembly Repair  
 Figure 601

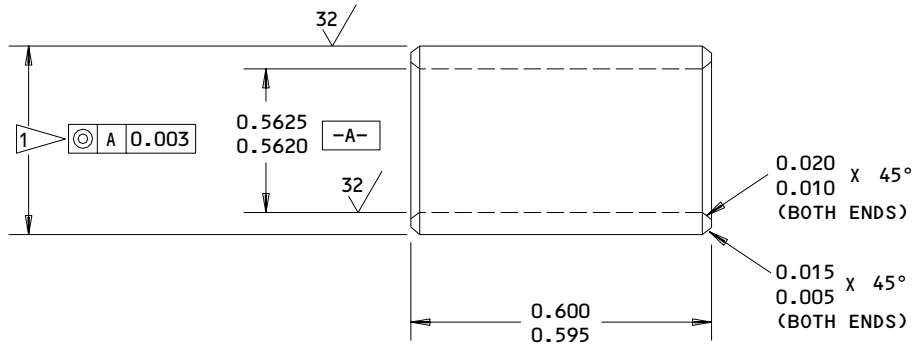
**32-12-05**

REPAIR 4-2

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

FINISH: CADMIUM PLATE (0.001-0.002) PER  
 20-42-05, CLASS 2 ON OUTSIDE  
 DIAMETER ONLY

ANGULAR TOLERANCE, ±0.5 DEG

ALL DIMENSIONS ARE IN INCHES

DIMENSIONS APPLY AFTER PLATING

1 FINISH DIA (REPAIR DIA OF BUSHING (160)  
 MINUS CLEARANCE OF 0.0005-0.0020)

Oversize Bushing Details  
 Figure 602

143646

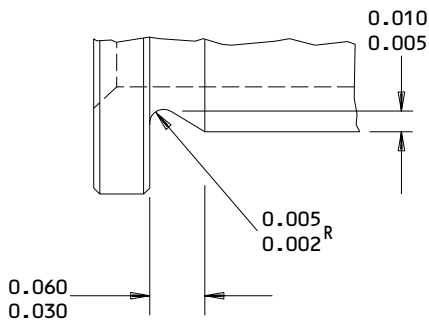
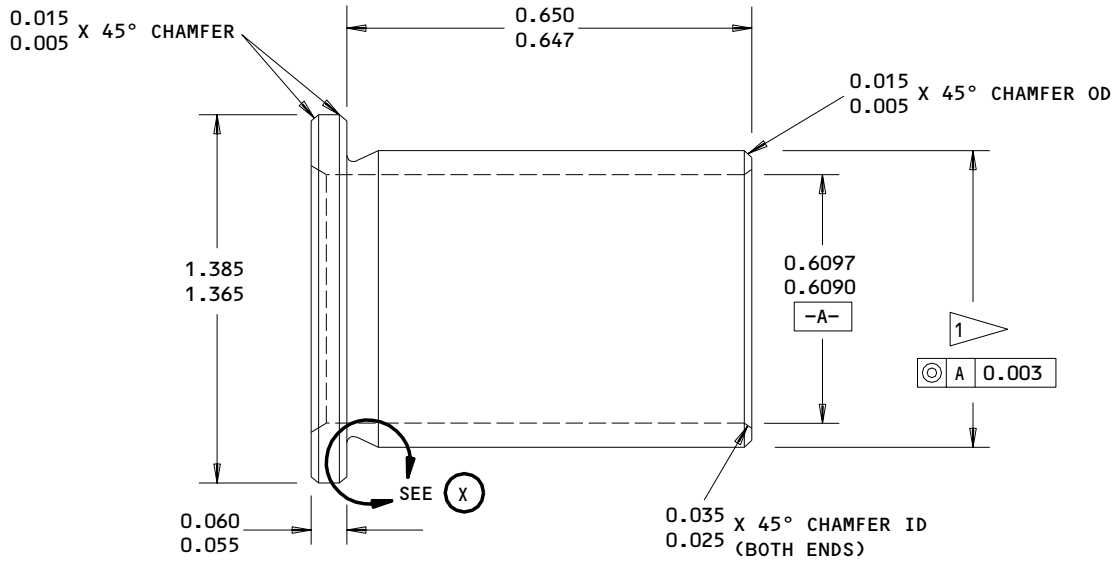
**32-12-05**

REPAIR 4-2

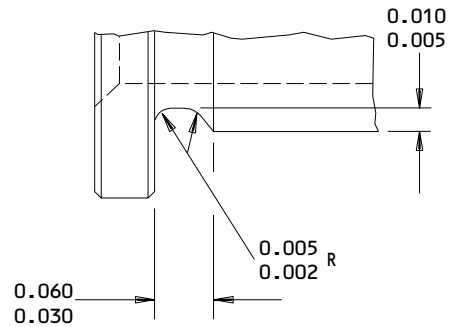
01.1

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TYPE 1



TYPE 2

UNDERCUT-TYPE 1 OR TYPE 2 OPTIONAL



REPLACEMENT BUSHING FOR BUSHING (155)

1 FINISH DIA (REPAIR DIA OF FITTING PLUS  
0.0000-0.0017 INTERFERENCE)

ALL DIMENSIONS ARE IN INCHES

DIMENSIONS APPLY AFTER PLATING

63/ ALL MACHINED SURFACES

MATERIAL: 17-4 PH CRES, R<sub>c</sub> 40-43

FINISH: CADMIUM PLATE PER 20-42-05, TYPE 2,  
CLASS 2; PLATING ON BORE IS OPTIONAL

Oversize Bushing Details  
 Figure 603

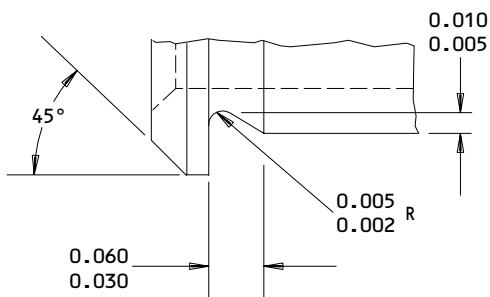
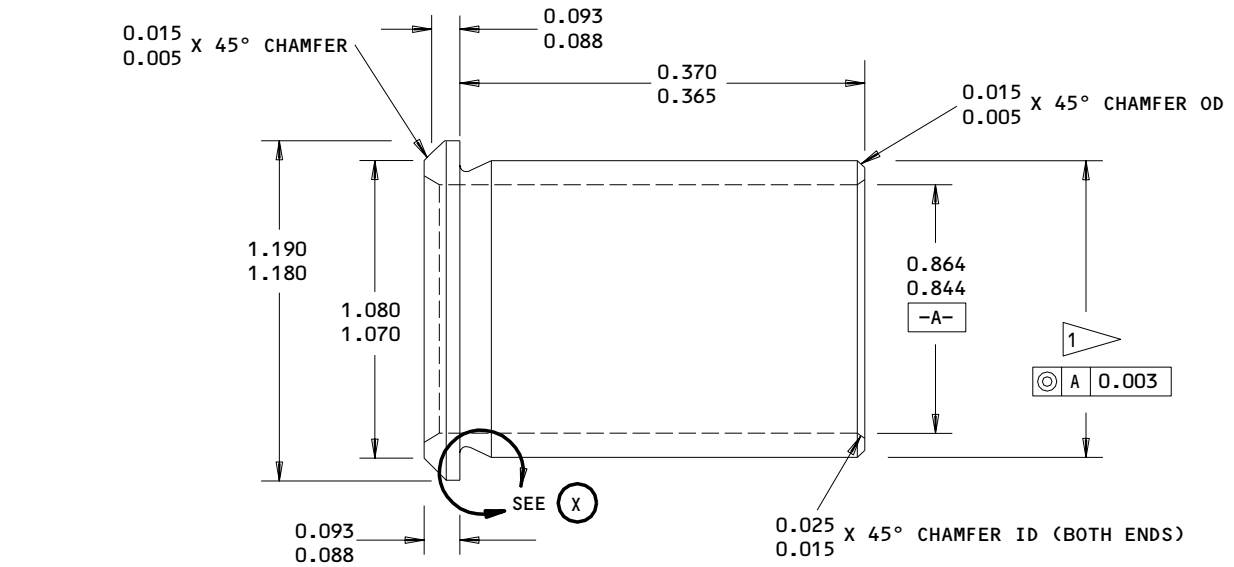
**32-12-05**

REPAIR 4-2

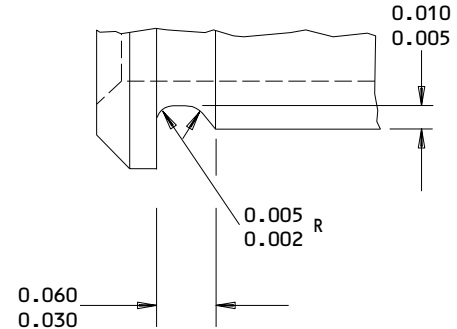
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TYPE 1



TYPE 2

UNDERCUT-TYPE 1 OR 2 OPTIONAL



REPLACEMENT BUSHING FOR BUSHING (160)

ANGULAR TOLERANCE:  $\pm 5^\circ$

63/ ALL MACHINED SURFACES

MATERIAL: AL-NI-BR PER AMS 4640

FINISH: CADMIUM PLATE PER 20-42-05, CLASS 2

ALL DIMENSIONS ARE IN INCHES

1 FINISH DIA (REPAIR DIA OF FITTING PLUS 0.0007-0.0021 INTERFERENCE)

Oversize Bushing Details  
 Figure 604

**32-12-05**

REPAIR 4-2

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01.1

FITTING ASSEMBLY - REPAIR 5-1

149T6989-1, -2

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

1. Bushing (210, 215) Replacement (IPL Fig. 1)

- A. Remove bushings.
- B. Install bushings per 20-50-03 using wet BMS 5-95 sealant.
- C. Machine bushings as shown in Fig. 601.
- D. Fillet seal entire periphery of flanges on both ends of bushings with BMS 5-95 sealant.

2. Refinish

- A. Fittings (220, 225) -- Chromic acid anodize, type 1, and apply one coat BMS 10-11, type 1 primer omitting primer in bushing holes (F-18.13).  
Material: Aluminum alloy.
- B. Fitting Assembly (175, 180) -- Apply one coat BMS 10-11, type 2 enamel, BAC702 white gloss (F-21.03) all over except on bushings.

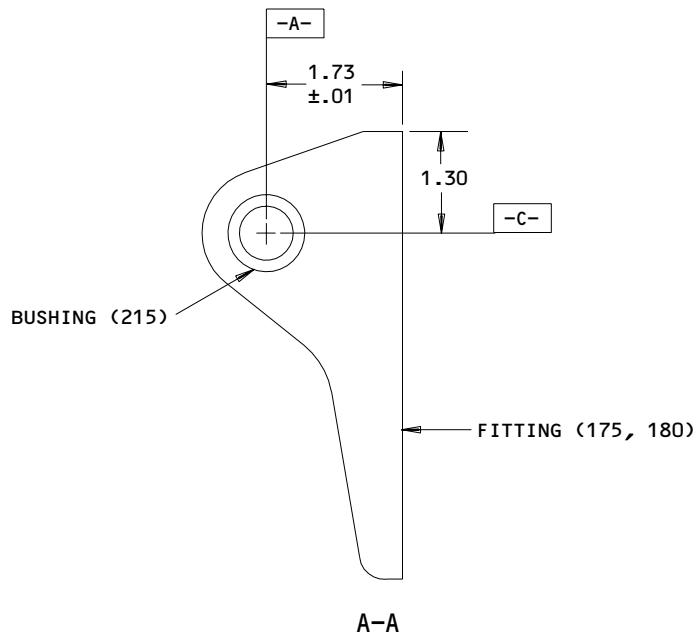
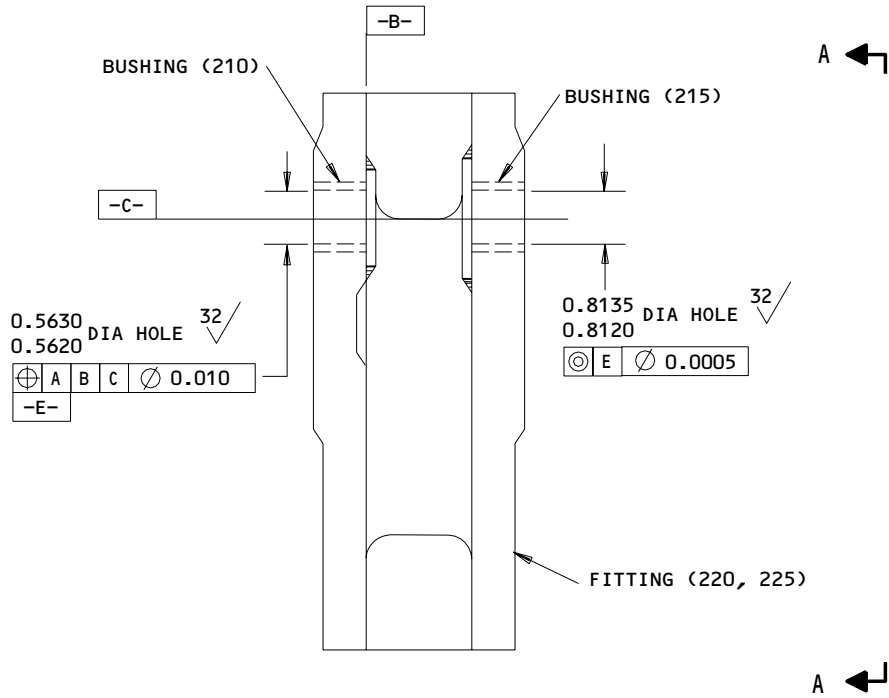
**32-12-05**

REPAIR 5-1

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ALL DIMENSIONS ARE IN INCHES

149T6989-1,-2  
 Fitting Assembly Repair  
 Figure 601

**32-12-05**

REPAIR 5-1

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01.1

FITTING ASSEMBLY - REPAIR 5-2

149T6989-1, -2

NOTE: Refer to REPAIR-GENERAL for a list of applicable standard practices.  
Refer to IPL Fig. 1 for item numbers.

1. Repair (Fig. 601)

## A. Method 1 - Installation of oversize equivalent of bushing (620)

NOTE: REPAIR 6-2 provides bushing fabrication information and additional repair procedures necessary to complete this repair. Be sure to do the repair on fitting assembly (555, 557, 560, 563) per REPAIR 6-2 or you will get too much clearance upon assembly.

- (1) Machine bushing (215) as necessary, to a maximum diameter of 0.8735 inch concentric with bushing (210) within 0.0005 inch, and a 32 micro-inch finish (repair diameter should match repair diameter of bushing (640)).

## B. Method 2 - Installation of other oversize bushings.

- (1) Remove the bushings.
- (2) Machine holes as necessary, within repair limits, to remove defects.
- (3) Shot peen and chromic acid anodize machined holes as indicated.
- (4) Make oversize bushings as shown in Fig. 602, as necessary to make allowance for amount of material removed in step (2).
- (5) Install the bushings per REPAIR 5-1.

**32-12-05**

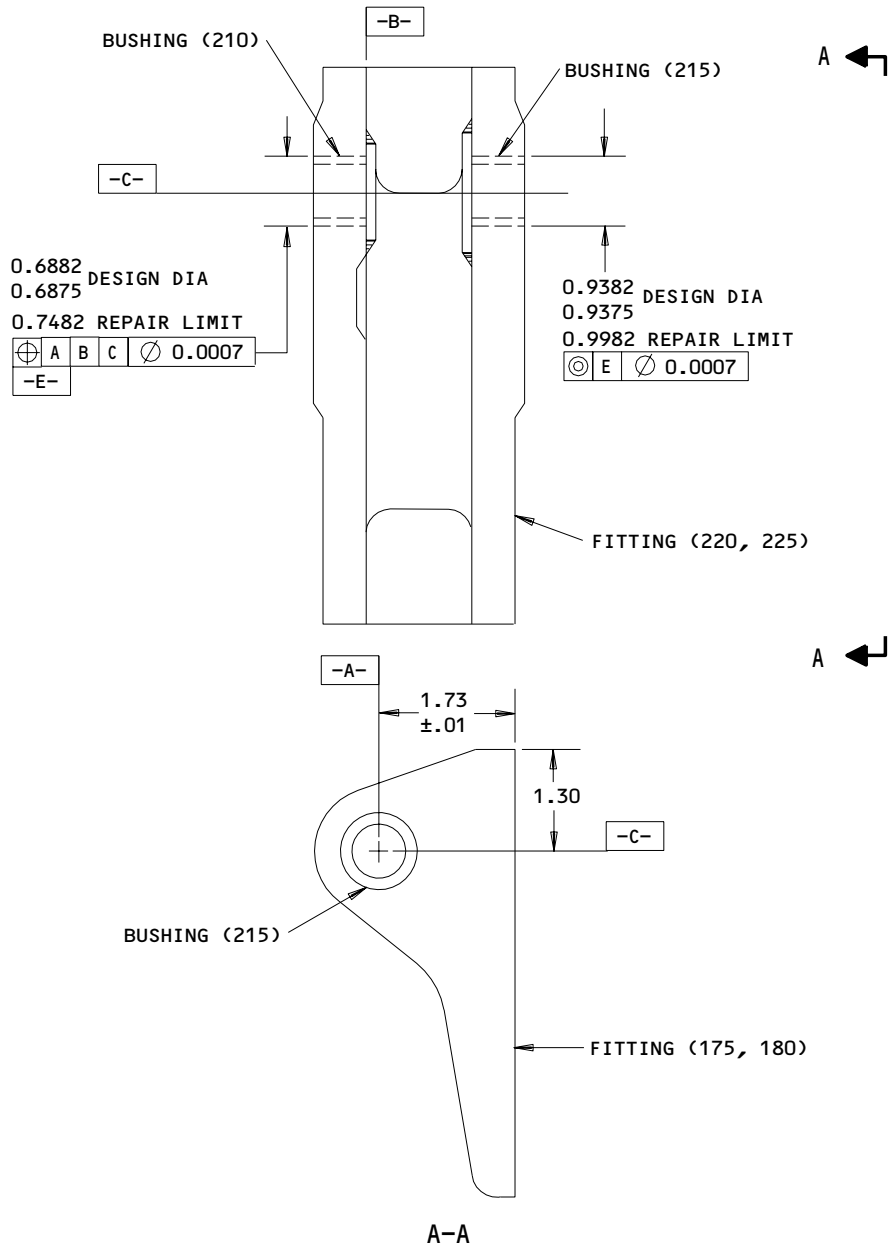
REPAIR 5-2

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**FINSIH:**

REFER TO REPAIR 5-1

**REPAIR:**

32/ ALL MACHINED SURFACES

SHOT PEEN: 0.023-0.055 SHOT SIZE  
 0.012 A INTENSITY  
 2.0 COVERAGE

MATERIAL: 7075-T73 AL ALLOY

ALL DIMENSIONS ARE IN INCHES

149T6989-1, -2  
 Fitting Assembly Repair  
 Figure 601

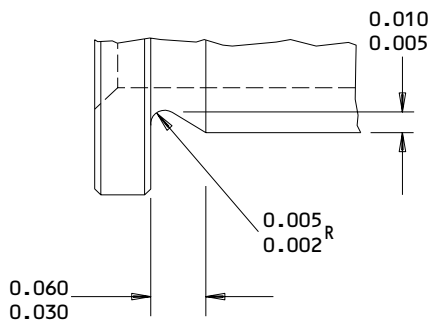
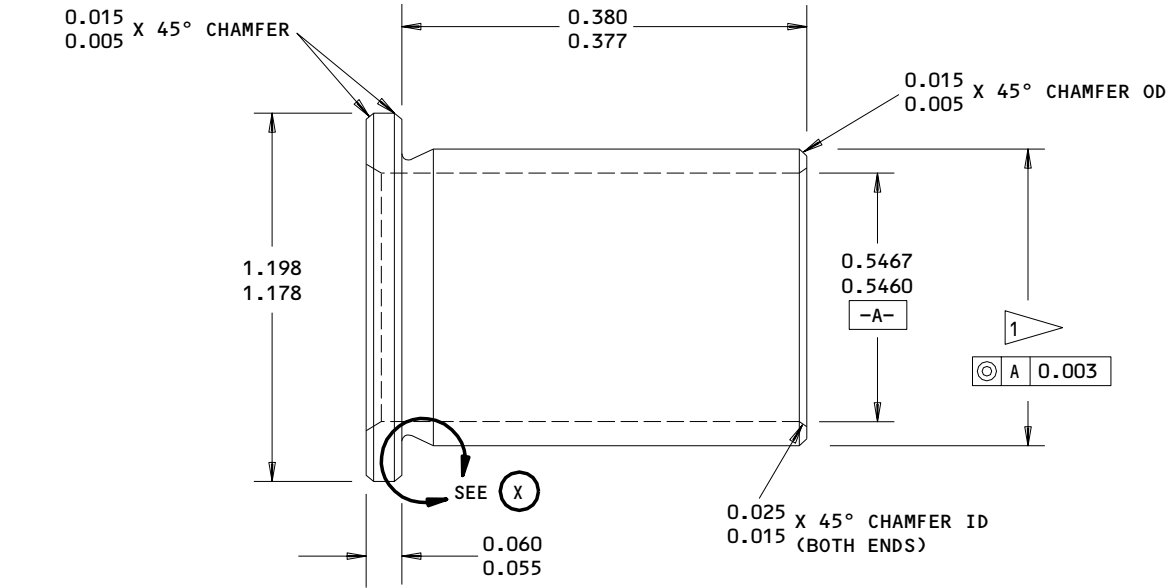
**32-12-05**

REPAIR 5-2

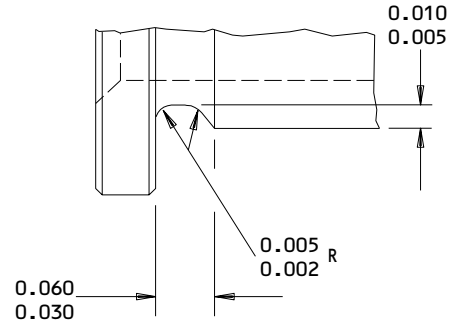
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TYPE 1



TYPE 2

UNDERCUT-TYPE 1 OR TYPE 2 OPTIONAL



REPLACEMENT BUSHING FOR BUSHING (210)

1 FINISH DIA (REPAIR DIA OF FITTING PLUS 0.0000-0.0017 INTERFERENCE)

63/ ALL MACHINED SURFACES

ALL DIMENSIONS ARE IN INCHES

MATERIAL: 17-4 PH CRES, R-50-54

DIMENSIONS APPLY AFTER PLATING

FINISH: CADMIUM PLATE PER 20-42-03, TYPE 2, CLASS 2; PLATING ON BORE IS OPTIONAL

Oversize Bushing Details  
 Figure 602

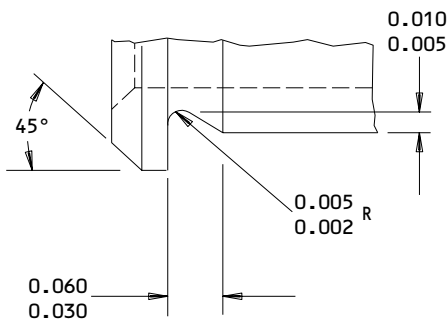
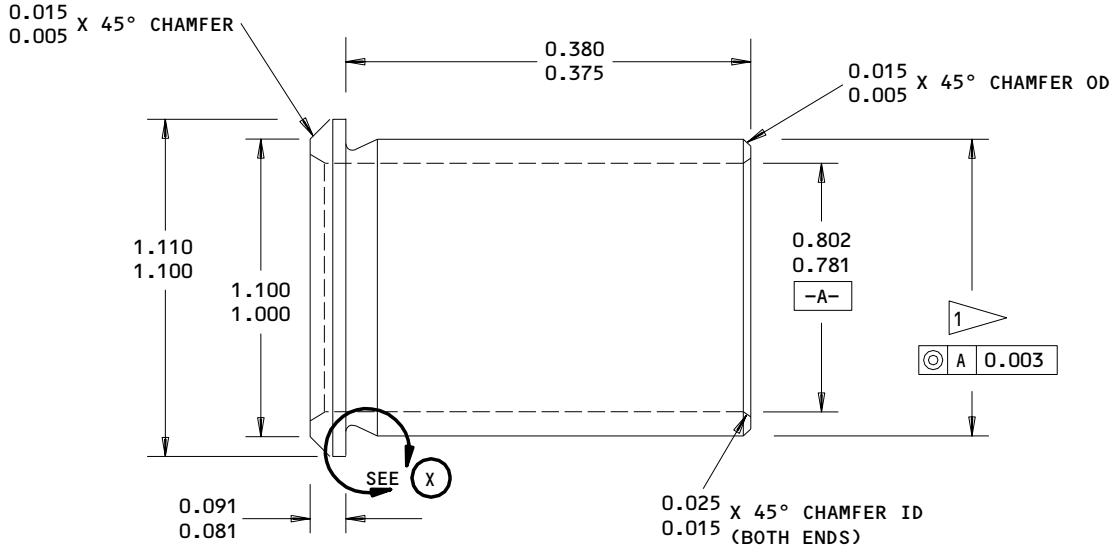
**32-12-05**

REPAIR 5-2

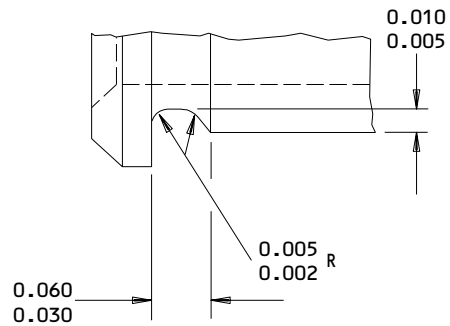
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TYPE 1



TYPE 2

UNDERCUT-TYPE 1 OR TYPE 2 OPTIONAL



REPLACEMENT BUSHING FOR BUSHING (215)

1 FINISH DIA (REPAIR LIMIT OF FITTING PLUS  
0.0007-0.0021 INTERFERENCE)

ALL DIMENSIONS ARE IN INCHES

ALL DIMENSIONS APPLY AFTER PLATING

63/ ALL MACHINED SURFACES

MATERIAL: AL-NI-BR PER AMS 4640

FINISH: CADMIUM PLATE PER 20-42-05, TYPE 2,  
CLASS 2

Oversize Bushing Details  
 Figure 603

**32-12-05**

REPAIR 5-2

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01.1

FITTING ASSEMBLY - REPAIR 6-1

149T7801-5, -6, -9, -10, -15, -16

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

1. Bushing (640, 645, 655, 650) Replacement (IPL Fig. 1)

- A. Remove bushings.
- B. Install bushings (645, 650) per 20-50-03 using wet BMS 5-95 sealant.
- C. Install bushings (640, 655) per 20-50-03 using BMS 3-24 grease.
- D. Machine bushings as follows:
  - (1) Bushing (640) -- ID at 0.8120-0.8135 inch with a finish of 32 microinch and concentric with each other within 0.003 inch.
  - (2) Bushing (655) -- ID at 0.8745-0.8755 inch with a finish of 32 microinch and concentric with each other within 0.003 inch.
  - (3) Bushing (645) -- ID at 1.0615-1.0635 inch with a finish of 32 microinch and concentric with each other within 0.003 inch.

2. Refinish

- A. Fittings (665, 668, 670, 673) -- Chromic acid anodize, type 1, and apply one coat BMS 10-11, type 1 primer omitting primer in bushing holes (F-18.13). Material: Aluminum alloy.
- B. Fitting Assembly (555, 560) -- Apply one coat BMS 10-11, type 2 enamel, BAC702 white gloss (F-21.03) all over except on bushings (640, 645, 655, 650) and lube fittings (660).

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REPAIR 6-1

01.1

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FITTING ASSEMBLY - REPAIR 6-2

149T7801-5, -6, -9, -10, -15, -16

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

1. Repair (IPL Fig. 1)

- A. Method 1 - Installation of oversize bushings replacing bushings (610, 620)

CAUTION: INSTALLATION OF OVERSIZE BUSHING REPLACING BUSHING (620) REQUIRES SIMULTANEOUS REPAIR OF FITTING ASSEMBLY (95). FAILURE TO PERFORM REPAIR OF FITTING ASSEMBLY (95) MAY DAMAGE PARTS DURING ASSEMBLY.

- (1) Refer to REPAIR 5-2 for repair of fitting assembly (95).
- (2) Machine bushings (640), if and as required, to a maximum diameter of 0.8735 inch, concentric within 0.003 inch of each other, and a 32 AA finish (repair diameter should match repair diameter of bushing (215)).
- (3) Machine bushings (655), if and as required, to a maximum diameter of 0.9355 inch concentric within 0.003 inch of each other, and a 32 AA finish.
- (4) Fabricate oversize bushings per Fig. 601.

- B. Method 2 - Installation of oversize bushings replacing bushing (640, 655)

- (1) Remove bushings.
- (2) Machine fitting (665, 667, 670, 672), if and as required, to a maximum diameter of 0.9975 inch for oversize bushing replacing bushing (640) and 1.0607 inch for oversize bushing replacing bushing (655); concentric with each other within 0.003 inch and 63 AA finish.
- (3) Shot peen (optional) bushing holes with 0.023-0.055 shot size, 0.014A intensity, and 2.0 coverage.
- (4) Chromic acid anodize, type 1 bushing holes.
- (5) Fabricate oversize bushing per Fig. 602.
- (6) Install bushing per REPAIR 6-1.

**32-12-05**

REPAIR 6-2

01.1

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C. Method 3 - Installation of oversize bushing replacing bushing (725)

- (1) Machine bushing (645), if and as required, up to a maximum diameter of 1.1235, concentric with bushing (650) within 0.003 inch, and 32 AA finish.
- (2) Fabricate oversize bushing per Fig. 601.

D. Method 4 - Installation of oversize bushing replacing bushing (645, 650)

- (1) Remove bushings.
- (2) Machine fitting (655, 667, 670, 672), if and as required, to a maximum diameter of 1.3108 inch concentric with bushing (650) hole within 0.003 inch and 63 AA finish for oversize bushing replacing bushing (645), and 0.9982 inch and 63 AA finish for oversize bushing replacing bushing (650).
- (3) Shot peen (optional) bushing hole with 0.023-0.055 shot size, 0.014 A intensity, and 2.0 coverage.
- (4) Chromic acid anodize, type 1 bushing hole.
- (5) Fabricate oversize bushing replacing bushing (645) per Fig. 602.
- (6) Fabricate oversize bushing replacing bushing (650) per Fig. 603.
- (7) Install oversize bushing per REPAIR 6-1.

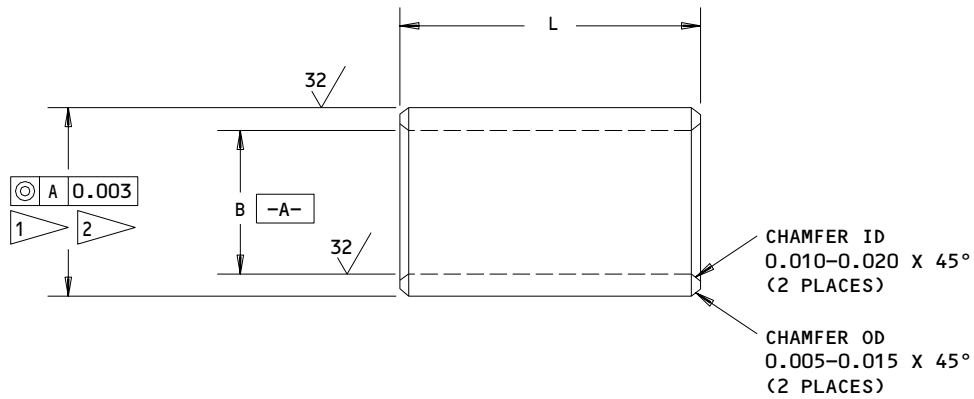
**32-12-05**

REPAIR 6-2

01.1

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BUSHING ITEM NO.	B	L	CLEARANCE
610 REF	0.6250 0.6245	1.340 1.335	0.0020 0.0005
620 REF	0.5625 0.5620	1.530 1.525	0.0025 0.0005
725 REF	0.7500 0.7495	0.660 0.655	0.0030 0.0000

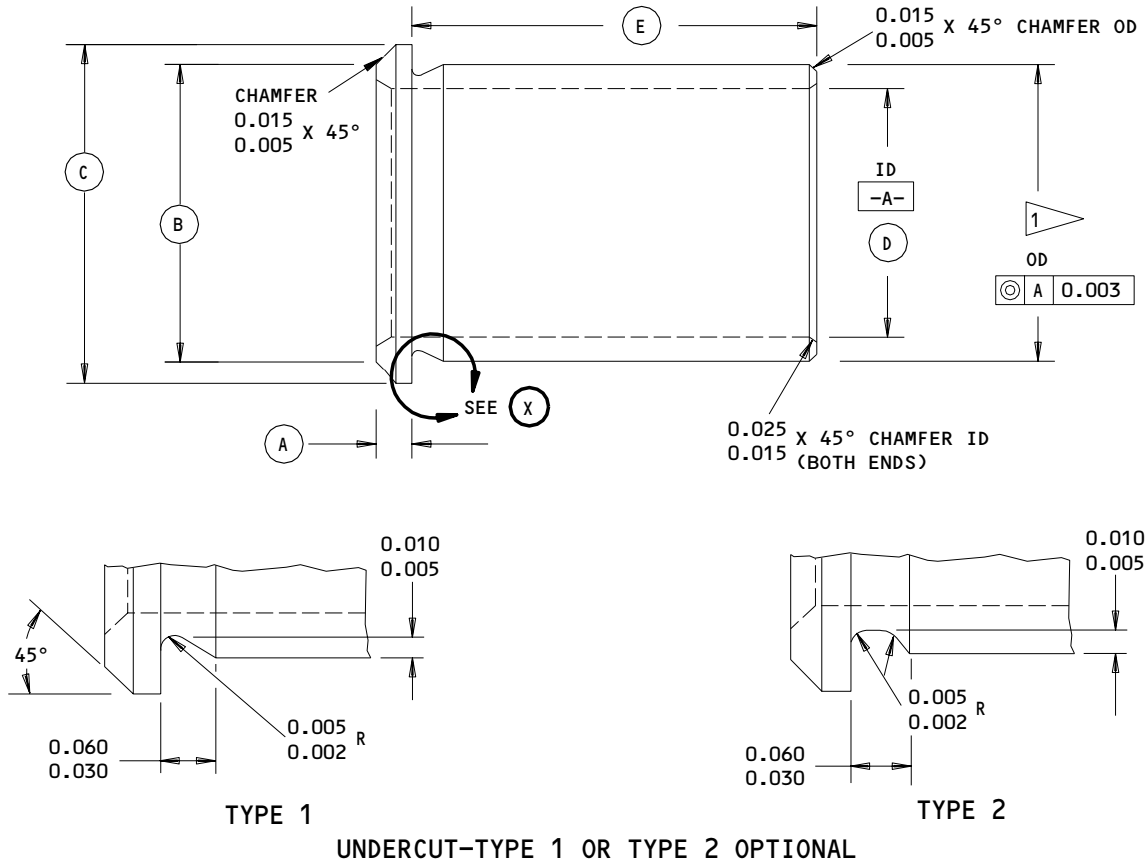
- 1 FINISH DIA (REPAIR DIA OF FITTING BUSHINGS MINUS CLEARANCE)
- 2 DIMENSIONS APPLY AFTER PLATING

MATERIAL: 15-5PH CRES, 180-200 KSI  
 FINISH: CHROME PLATE, 0.001-0.002 THICKNESS, CLASS 2, OD ONLY  
 ANGULAR TOLERANCE, ±0.5°  
 ALL DIMENSIONS ARE IN INCHES

Oversize Bushing Details  
 Figure 601

**32-12-05**  
 REPAIR 6-2  
 Page 603  
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
01.1



(X)

BUSHING ITEM NO.	A	B	C	D	E	INTERFERENCE
640 REF	0.086 0.081	1.010 1.000	1.110 1.100	0.802 0.781	0.280 0.275	0.0021 0.0007
645 REF	0.111 0.106	1.310 1.300	1.470 1.460	1.051 1.031	0.300 0.295	0.0024 0.0008
655 REF	0.093 0.088	1.080 1.070	1.190 1.180	0.864 0.844	0.510 0.505	0.0021 0.0007

 FINISH DIA (REPAIR DIA OF FITTING PLUS INTERFERENCE)

 ALL MACHINED SURFACES

ALL DIMENSIONS ARE IN INCHES

MATERIAL: AL-NI-BR PER AMS 4640

DIMENSIONS APPLY AFTER PLATING

FINISH: CADMIUM PLATE PER 20-42-05, TYPE 2, CLASS 2

 Oversize Bushing Details  
 Figure 602

**32-12-05**

REPAIR 6-2

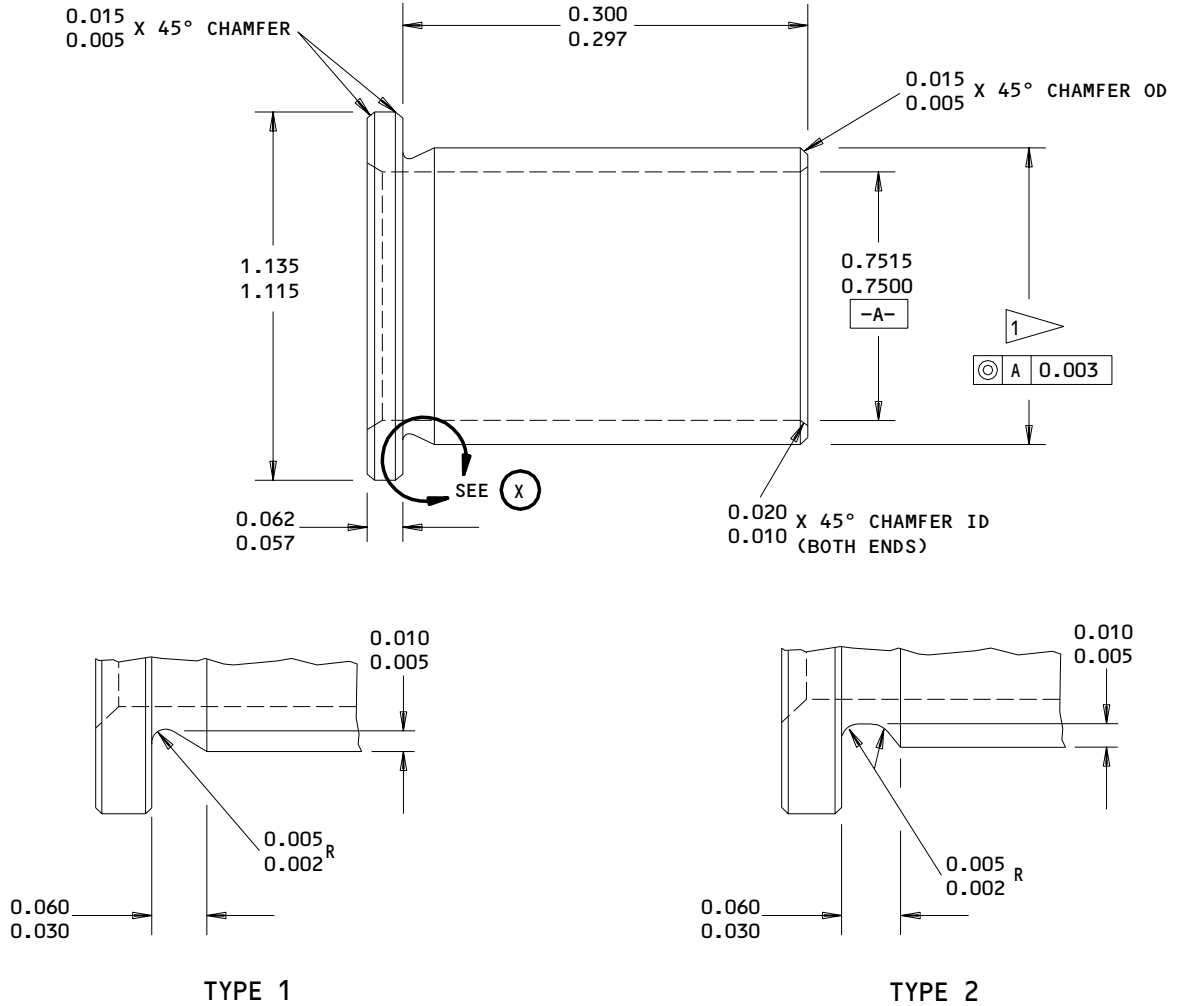
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**BOEING**  
**COMPONENT**  
**MAINTENANCE MANUAL**



UNDERCUT-TYPE 1 OR TYPE 2 OPTIONAL



REPLACEMENT BUSHING FOR BUSHING (650)

1 FINISH DIA (REPAIR DIA OF FITTING PLUS 0.0001-0.0018 INTERFERENCE)

63/ ALL MACHINED SURFACES

ALL DIMENSIONS ARE IN INCHES

MATERIAL: 17-4 PH CRES, R<sub>c</sub> 40-43

DIMENSIONS APPLY AFTER PLATING

FINISH: CADMIUM PLATE PER 20-42-05, TYPE 2, CLASS 2; PLATING OF BORE IS OPTIONAL

Oversize Bushing Details  
 Figure 603

**32-12-05**

REPAIR 6-2

01.1

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
SPECIAL PINS - REPAIR 7-1

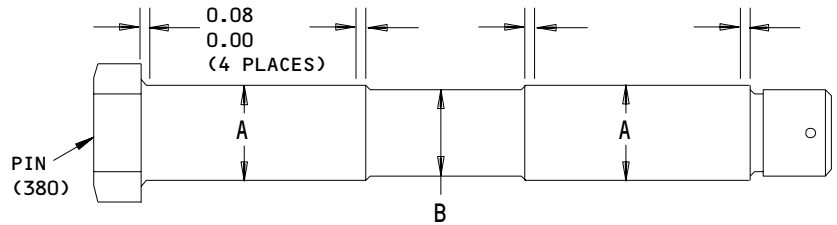
149T6986-1, -3, -5, -6, -9


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

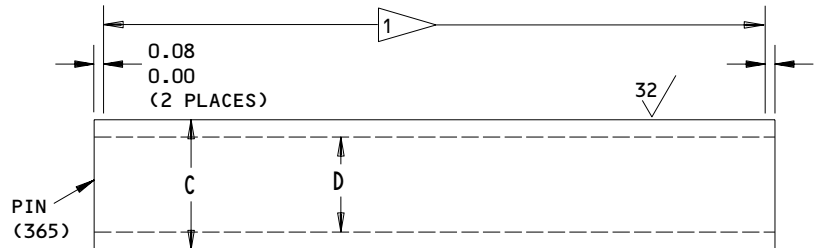
1. Repair (Fig. 601, 602)


- A. Chrome plate, Class 2A, with single plate thickness 0.003 inch minimum on surface indicated.
- B. Cadmium-titanium alloy plate, bake 12 hours minimum at 375 ±25°F, and apply chromate post plate treatment per 20-42-02 (F-15.01) on surfaces shown.
- C. Grind chrome plate per 20-10-04 to dimensions shown.

A 		B	
AFTER CHROME PLATE		AFTER CAD PLATE	
MAX	MIN	MAX	MIN
1.1141	1.1126	1.0657	1.0552



C 		D	
AFTER CHROME PLATE		AFTER CAD PLATE	
MAX	MIN	MAX	MIN
1.4990	1.4975	1.1161	1.1146



 CHROME PLATE SINGLE PLATE THICKNESS 0.003 MINIMUM (F-15.03)

ALL DIMENSIONS ARE IN INCHES

Special Pin Repair  
 Figure 601

20400

**32-12-05**

REPAIR 7-1

01.1

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BOLTS - REPAIR 8-1

149T6985-6, BACB30UU10K46

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

1. Repair (565A, 750A, IPL Fig. 1)

A. Chromium plate, single plate thickness 0.003-0.015 inch, per 20-42-03.

B. Grind chrome plate per 20-10-04 to the following dimensions:

(1) Bolt (565A) -- 0.6230-0.6240 inch diameter

(2) Bolt (750A) -- 1.1225-1.1240 inch diameter

**32-12-05**

REPAIR 8-1

01.1

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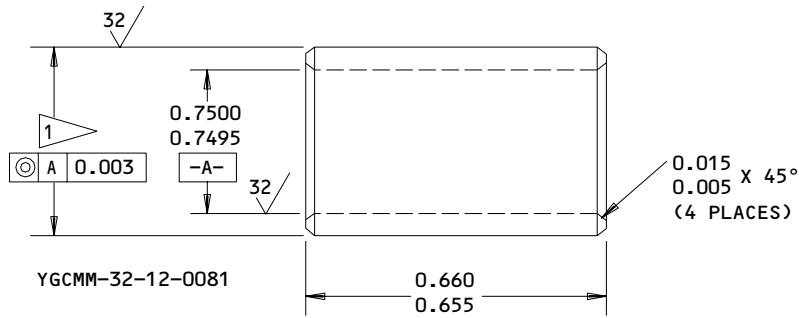
BUSHING - REPAIR 9-1

BACB28AK12-066

**NOTE:** Refer to REPAIR-GEN for a list of applicable standard practices.  
 Refer to IPL Fig. 1 for item numbers.

**1. Oversize Equivalent of Bushing (695) (Fig. 601)**

- A. If you repaired attach fitting assembly 149T7803 per CMM 32-12-02, make an oversize equivalent of bushing (695) as shown, to get a 0.0000-0.0030 inch clearance with the repaired diameter of attach fitting assembly 149T7803.



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

FINISH: CHROME PLATE, 0.001-0.002 THICKNESS,  
 CLASS 2, OD ONLY

DIMENSIONS APPLY AFTER PLATING

ALL DIMENSIONS ARE IN INCHES

ANGULAR TOLERANCE,  $\pm 0.5$  DEG

**1** FINISH DIA (REPAIR OF ATTACH FITTING  
 ASSY, 149T7803 (REF) DIAMETER MINUS  
 0.0000-0.0030 CLEARANCE)

Oversize Bushing Details  
 Figure 601

169216

**32-12-05**

REPAIR 9-1

01.1

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**BOEING**  
 COMPONENT  
 MAINTENANCE MANUAL
MISCELLANEOUS PARTS REFINISH – REPAIR 10-1

1. Repair of parts listed in Fig. 601 is only replacement of the original finish. Refer to REPAIR-GENERAL for a list of applicable standard practices.

IPL FIG. & ITEM	MATERIAL	FINISH
<u>Fig. 1</u>		
Link Tube (735)	15-5PH CRES, 180-200 ksi	Passivate (F-17.25, which replaces (F-17.09) all over, apply BMS 10-11, type 1 primer (F-20.02) on OD only, and apply white BMS 10-11, type 2 enamel (F-21.03) on OD only.
Serrated Plate (445,455)	15-5PH CRES, 180-200 ksi	Passivate (F-17.25, which replaces F-17.09) all over on side with serrations. Cadmium plate and apply BMS 10-11, type 1 primer (F-16.01) on opposite side.
Upstop Fitting (305, 310)	Al alloy	Chromic acid anodize and apply BMS 10-11, type 1 primer (F-18.13) white BMS 10-11, type 2 enamel (F-21.03) all over.
Pad (285)	A1-Ni-Bronze	Cadmium plate (F-15.06).
Stop (10)	15-5PH CRES, 180-200 ksi	Cadmium plate and apply BMS 10-11, type 1 primer (F-16-01) white BMS 10-11, type 2 enamel (F-21-03).
Stop Assembly (45)		Chemical treat and apply primer and enamel to damaged paint and bare areas (F-21.12) but not on pad (60).

Refinish Details  
 Figure 601 (Sheet 1)

**32-12-05**

REPAIR 10-1

01.1

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IPL FIG. & ITEM	MATERIAL	FINISH
Stop (90)	Al alloy	Chromic acid anodize and apply BMS 10-11, type 1 primer (F-18.13) and white BMS 10-11, type 2 enamel (F-21.03).
Shim (80)	Al alloy	Chemical treat and apply BMS 10-11, type 1 primer (F-18.06).
Wear Pad (625)	Cu-Be	Cadmium plate and apply BMS 10-11, type 1 primer (F-16.01).
Bushing (495,510)	15-5PH CRES, 180-200 ksi	Cadmium plate (F-15.06) all over but not on ID.
Bushing (500,515)	Al-Ni-Bronze	Cadmium plate (F-15.06) all over but not on ID.
Bushing (410,425)	Al-Ni-Bronze	Cadmium plate (F-15.06).
Bushing (415,420)	15-5PH CRES	Cadmium plate (F-15.06).
Washer (370,375)		Cadmium plate and apply BMS 10-11, type 1 primer (F-16.01). Apply white BMS 10-11, type 2 enamel (F-21.03).
Washer (595)		Chromium plate (F-15.03) both sides.

Refinish Details  
 Figure 601 (Sheet 2)

**32-12-05**

REPAIR 10-1

01.1

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ASSEMBLY1. Materials

NOTE: Equivalent substitutes can be used.

- A. Foam -- Last-A-Foam FRL-6720, Class 7 (SOPM 20-60-04)
- B. Grease -- BMS 3-33 or BMS 3-24 (SOPM 20-60-03)
- C. Grease -- BMS 3-33 or MIL-G-23827 (SOPM 20-60-03)
- D. Lubricant, Solid Film -- MIL-L-8937, type 6, class 1 (SOPM 20-50-08)
- E. Sealant -- BMS 5-95 (SOPM 20-60-04)

2. Assembly (IPL Fig. 1)

- A. Use standard industry practices and these special steps.
- B. Apply solid film lubricant on threads of link tube (735).
- C. Fill link tube (735) cavity with foam as shown in Fig. 701.
- D. Center wear pad (625) on fitting (665, 668, 670, 673) and fay surface seal with BMS 5-95 sealant.
- E. Install bolts (630) with wet sealant applied to shank and head.
- F. Install bushings (335, 695, 725) with BMS 3-33 or BMS 3-24 grease.
- G. Install bolts (365, 315, 565A, 570A, 675A, 705A) and spacer (380) with BMS 3-24 grease.
- H. Tighten nut (385) to 180-240 pound-inches. Back off to nearest slot and install cotter pin (360) per SOPM 20-50-02. Install washer (377) if necessary to maintain a 0.02-0.06 inch clearance between bushing flanges on bellcrank assembly (492, 494) and fitting assembly (400, 405).
- I. Tighten nut (753) to 180-240 pound-inches. Back off to nearest slot and install cotter pin (748) per SOPM 20-50-02.

**32-12-05**ASSEMBLY  
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01.1

- J. Adjust bolts (565A) to decrease the clearance under bolt (565A) head and fitting (165) to a minimum. Replace bushing (615) if clearance is less than 0.005 inch.
- K. Install bolts (15, 20, 25, 30, 50, 105, 110, 115, 120, 123, 125, 130, 135, 185, 190, 195, 197, 240, 250A, 255A, 260A, 265A) with wet BMS 5-95 sealant.
- L. Center slots in fittings (470, 475) and serrated plates (445, 455) to remove the overlap along the width.
- M. Install cotter pins (360) per SOPM 20-50-02.
- N. Install fitting assembly (555, 560).
  - (1) Apply a layer of BMS 3-33 or BMS 3-24 grease to mating surfaces of bolts (565A, 575A), bushings (610, 615, 620), and washers (585, 590, 595, 600, 605) before you install them.
  - (2) Adjust bushing (610) as necessary to get the gaps shown in Fig. 702.
- O. Apply BMS 3-33 or BMS 3-24 grease at lube fittings (660) until you see grease come out on the ID of bushings (640, 655).

**32-12-05**

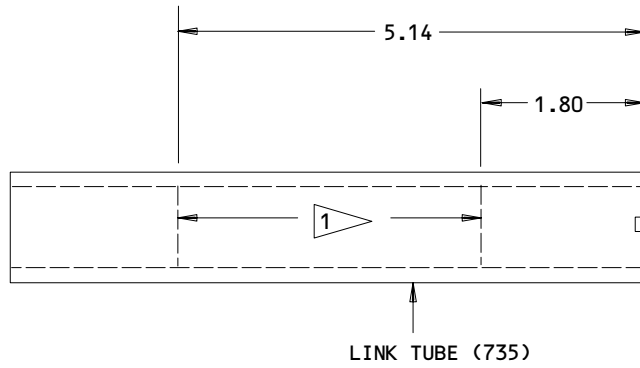
ASSEMBLY

01.1

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1 FILL WITH LAST-A-FOAM, FRL-6720, CLASS 7.

ALL DIMENSIONS ARE IN INCHES

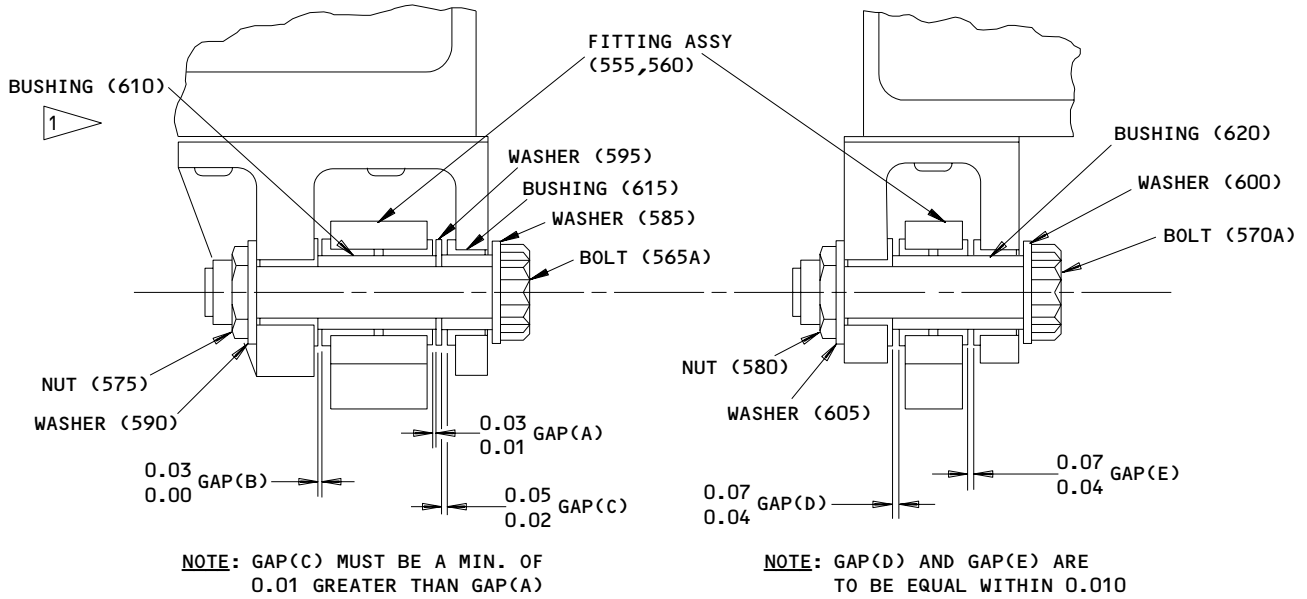
Link Tube Assembly  
Figure 701

20399

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ASSEMBLY  
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01.101



1 TRIM IF NECESSARY TO OBTAIN GAP(A)

ALL DIMENSIONS ARE IN INCHES

**Bellcrank Assy Installation  
 Figure 702**

169598

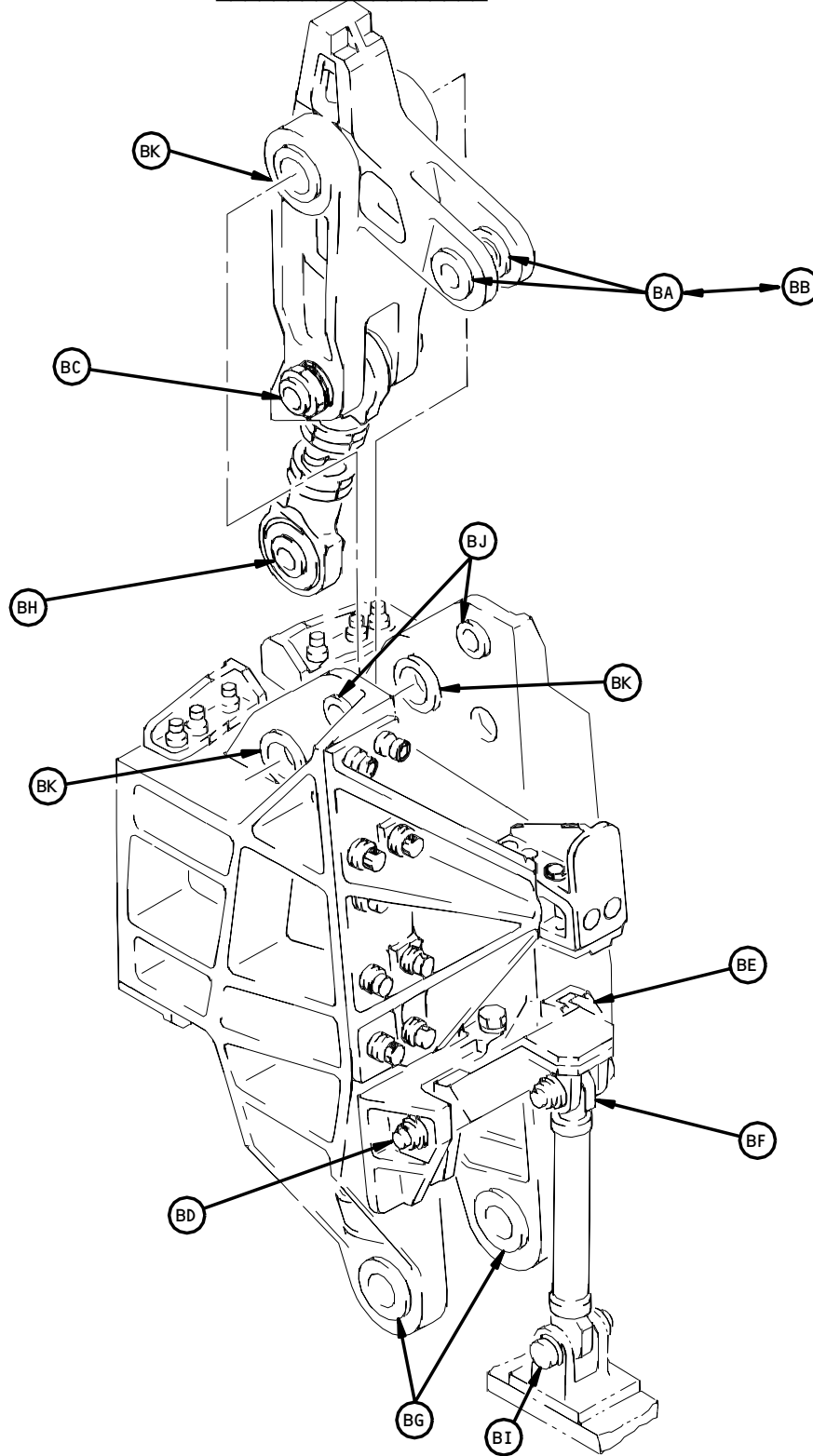
**32-12-05**

ASSEMBLY  
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**BOEING**  
COMPONENT  
MAINTENANCE MANUAL

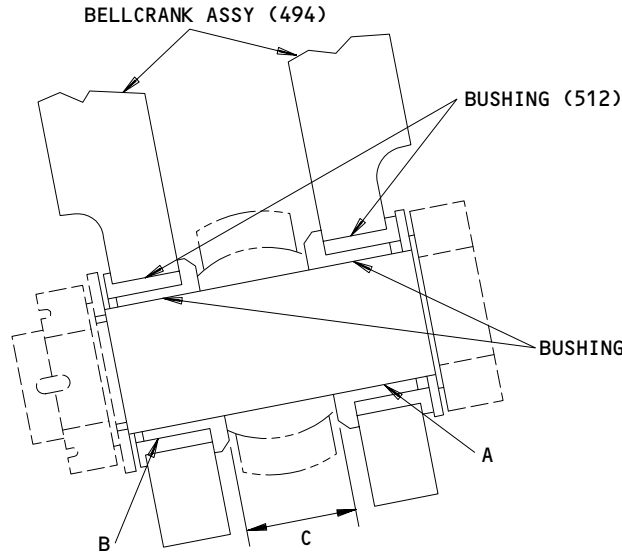
FITS AND CLEARANCES



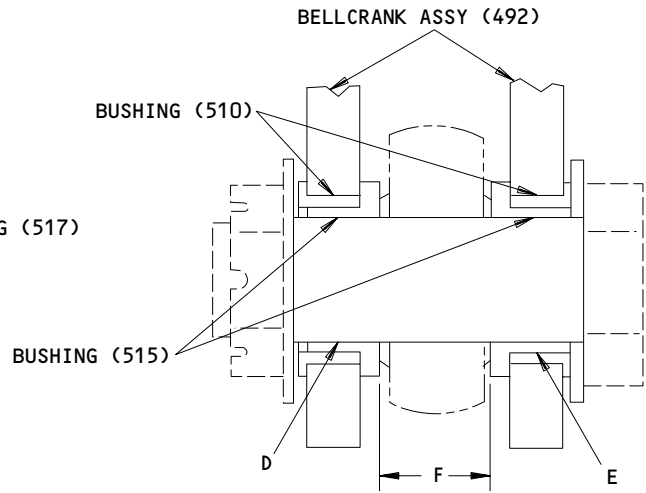
Fits and Clearances  
Figure 801 (Sheet 1)

**32-12-05**

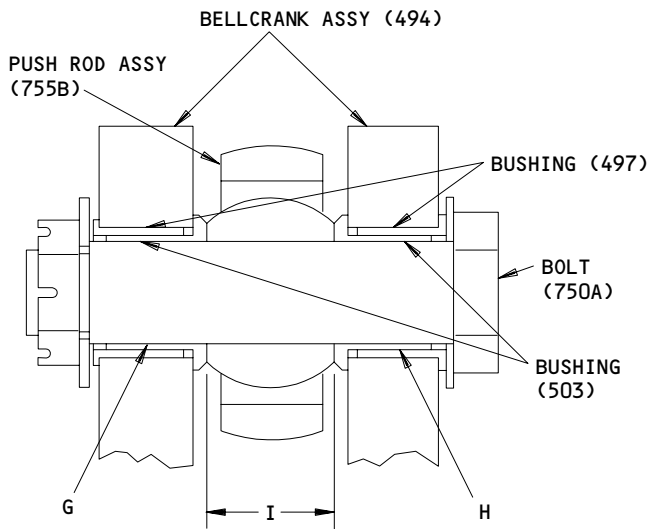
FITS AND CLEARANCES  
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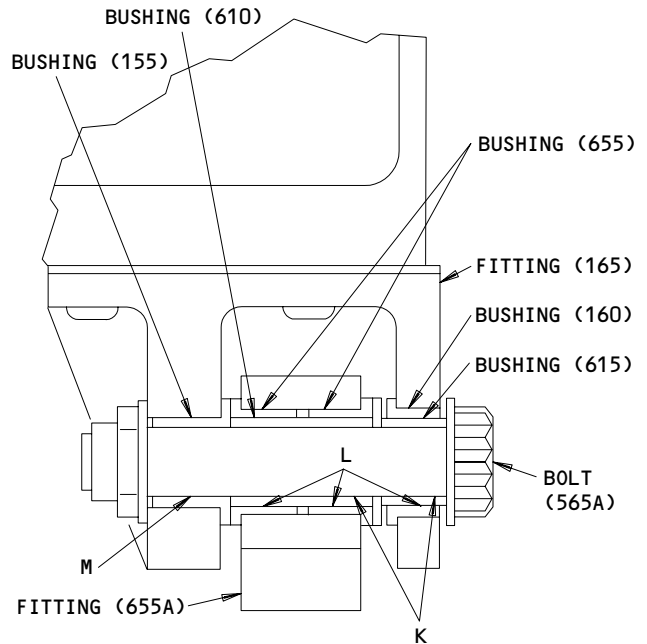
(BA)



(BB)



(BC)

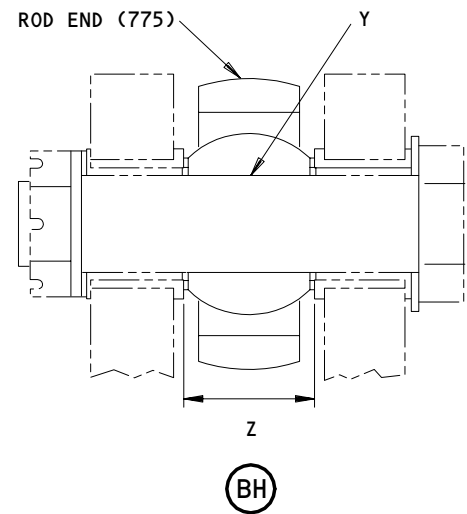
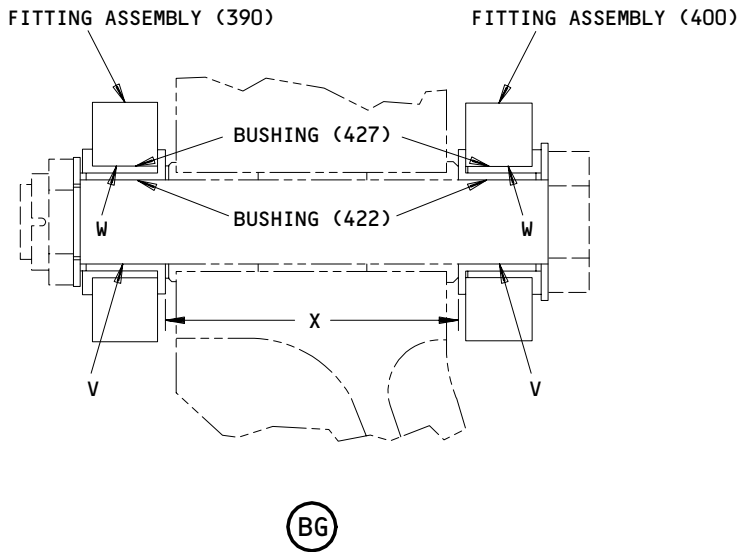
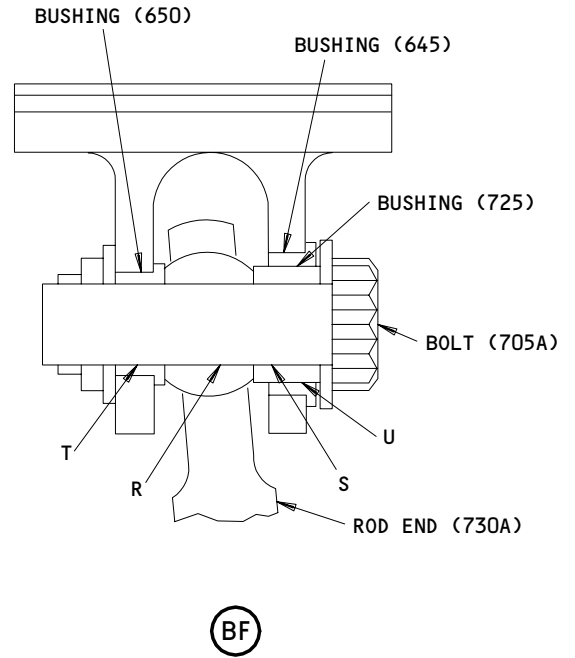
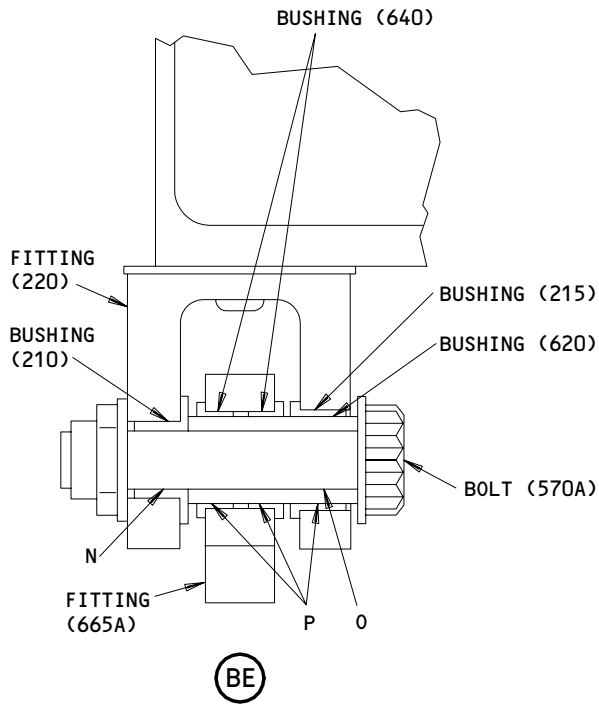


(BD)

Fits and Clearances  
 Figure 801 (Sheet 2)

**32-12-05**

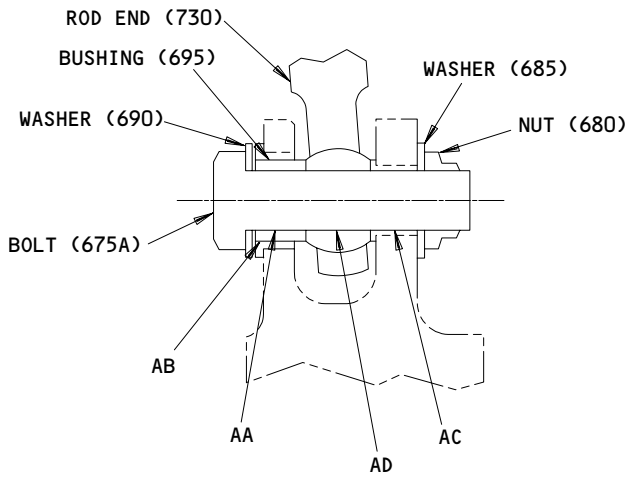
FITS AND CLEARANCES  
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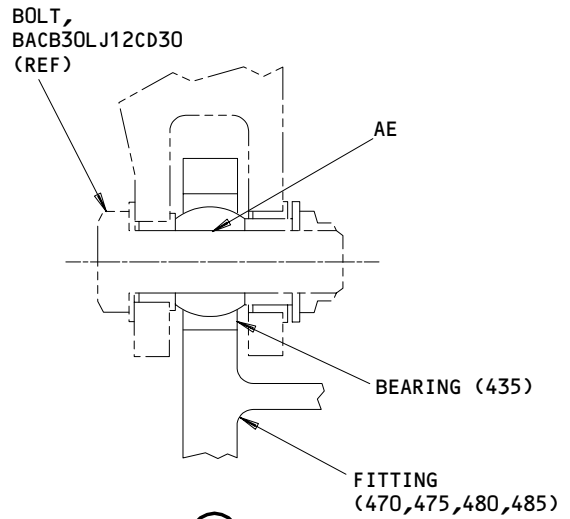
Fits and Clearances  
 Figure 801 (Sheet 3)

**32-12-05**

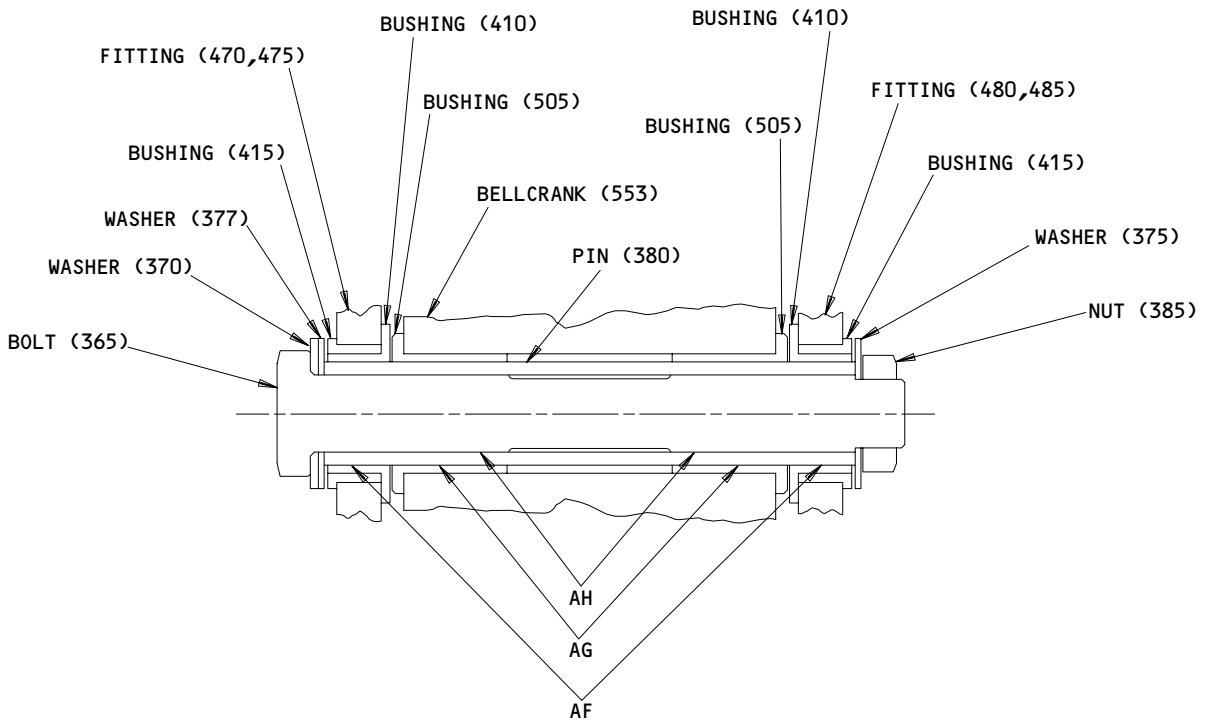
FITS AND CLEARANCES  
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(BI)



(BJ)












(BK)

Fits and Clearances  
 Figure 801 (Sheet 4)

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**BOEING**  
 COMPONENT  
 MAINTENANCE MANUAL





REF LETTER	REF IPL	DESIGN DIMENSION*				SERVICE WEAR LIMIT*		
	FIG. 1, MATING ITEM NO.	DIMENSION		ASSEMBLY CLEARANCE 		DIMENSION		MAXIMUM CLEARANCE
		MIN	MAX	MIN	MAX	MIN	MAX	
A	ID 517	1.1870	1.1885	0.0005	0.0035	1.1816	1.1919	0.0054
	OD 	1.1850	1.1865					
B	ID 512	1.3751	1.3759	-0.0024	-0.0008			
	OD 517	1.3767	1.3775					
C	 3	1.0300	1.0350	0.000	0.0354			0.0540
	 517	1.0350	1.0654					
D	ID 515	1.1245	1.1260	0.0005	0.0035	1.1193	1.1292	0.0052
	OD 	1.1225	1.1240					
E	ID 510	1.3125	1.3133	-0.0024	-0.0008			
	OD 515	1.3141	1.3149					
F	 3	1.0300	1.0350	0.0000	0.0354			0.0540
	 515	1.0350	1.0654					
G	ID 503	1.1250	1.1255	0.0010	0.0030	1.1198	1.1292	0.0052
	OD 750A	1.1225	1.1240					
H	ID 497	1.4999	1.5007	-0.0024	-0.0008			
	OD 503	1.5015	1.5023					
I	 755B	1.4520	1.4770	0.0000	0.0574			0.0870
	 503	1.4770	1.5094					
J	ID 755B	1.1250	1.1255	0.0010	0.0030			0.0052
	OD 750A	1.1225	1.1240					
K	ID 610,615	0.6245	0.6250	0.0005	0.0020	0.6195	0.6290	0.0050
	OD 565A	0.6230	0.6240					
L	ID 160,655	0.8745	0.8755	0.0005	0.0020	0.8687	0.6290	0.0050
	OD 610,615	0.8735	0.8740					

\* ALL DIMENSIONS ARE IN INCHES

Fits and Clearances  
 Figure 801 (Sheet 5)

32-12-05

FITS AND CLEARANCES  
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Ref Letter Fig.801	Mating Item No. Fig.1	Design Dimensions				Service Wear Limit		
		Dimensions (inches)		Assembly Clearance (inch) 		Dimension Limits (inches)		Maximum Allowable Clearance (inch)
		Min	Max	Min	Max	Min	Max	
M	ID 155	0.6245	0.6255	0.0005	0.0025	0.6195	0.6290	0.0050
	OD 565A	0.6230	0.6240					
N	ID 210	0.5620	0.5630	0.0005	0.0025	0.5570	0.5665	0.005
	OD 570A	0.5605	0.5615					
O	ID 620	0.5620	0.5625	0.0005	0.0020	0.5570	0.5665	0.005
	OD 570A	0.5605	0.5615					
P	ID 640	0.8120	0.8135	0.0005	0.0025	0.8066	0.8169	0.0054
	OD 620	0.8110	0.8115					
Q	ID 215	0.8120	0.8135	0.0005	0.0025	0.8066	0.8169	0.0054
	OD 620	0.8110	0.8115					
R	ID 730A	0.7500	0.7504	0.001	0.0024	0.7448	0.7542	0.0052
	OD 705A	0.7480	0.7490					
S	ID 725	0.7495	0.7500	0.0005	0.0020	0.7443	0.7542	0.0052
	OD 705A	0.7480	0.7490					
T	ID 650	0.7500	0.7515	0.0010	0.0035	0.7448	0.7542	0.0052
	OD 705A	0.7480	0.7490					
U	ID 645	1.0615	1.0635	0.000	0.0030	1.0551	1.0679	0.0064
	OD 725	1.0605	1.0615					
V	ID 422	1.5005	1.5020	0.0015	0.0045	1.4942	1.5053	0.0063
	OD 	1.4975	1.4990					
W	ID 470A, 480A	2.1245	2.1255	-0.0031	-0.0012			
	OD 427	2.1267	2.1276					
X	390A, 400A 							0.0013 






Fits and Clearances  
Figure 801 (Sheet 6)

# 32-12-05









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








**BOEING**  
 COMPONENT  
 MAINTENANCE MANUAL

REF LETTER	REF IPL	DESIGN DIMENSION*				SERVICE WEAR LIMIT*		
	FIG. 1, MATING ITEM NO.	DIMENSION		ASSEMBLY CLEARANCE		DIMENSION		MAXIMUM CLEARANCE
		MIN	MAX	MIN	MAX	MIN	MAX	
Y	ID 775	1.1250	1.1255	0.0010	0.0030	1.1198	1.1292	0.0052
	OD 	1.1225	1.1240					
Z	ID 775	1.798	1.814	0.006	0.032			0.048
	OD 							
AA	ID 695	0.7495	0.7500	0.0005	0.0020	0.7442	0.7542	0.0052
	OD 675A	0.7480	0.7490					
AB	ID 	1.0615	1.0635	0.0000	0.0030	1.0551	1.0679	0.0064
	OD 695	1.0605	1.0615					
AC	ID 	0.7500	0.7515	0.0010	0.0035	0.7448	0.7542	0.0052
	OD 675A	0.7480	0.7490					
AD	ID 730A	0.7500	0.7504	0.0010	0.0024	0.7448	0.7542	0.0052
	OD 675A	0.7480	0.7490					
AE	ID 435	0.7500	0.7504	0.0010	0.0024	0.7410	0.7580	0.009
	OD 	0.7480	0.7490					
AF	ID 410	1.4995	1.5010	0.0005	0.0035	1.4932	1.5053	0.0063
	OD 365	1.4975	1.4990					
AG	ID 505	1.4995	1.5010	0.0005	0.0035	1.4932	1.5053	0.0063
	OD 365	1.4975	1.4990					
AH	ID 365	1.1146	1.1161	0.0005	0.0035	1.1094	1.1193	0.0052
	OD 380	1.1126	1.1141					

\* ALL DIMENSIONS ARE IN INCHES

-  NEGATIVE VALUES IDENTIFY AN INTERFERENCE FIT
-  BOLT, 149T6985-5 (REF)
-  BEARING BALL IN ROD 273T4521 (REF)
-  END CLEARANCE, BALL TO BUSHING
-  BOLT, 149T6985-1 (REF)
-  BOLT, 149T6985-3 (REF)
-  CENTER BEAM DOOR 149T6910-1 OR -29 (REF CMM 32-12-02)
-  BOLT, 149T6985-7 (REF)

-  TOTAL GAP BETWEEN FITTING ASSEMBLIES AND CENTER BEAM (REF)
-  BUSHING BACB28AM17B035A IN ATTACH FITTING 149T7803 (REF CMM 32-12-01)
-  BUSHING, BACB28X12C047 (REF)
-  BOLT, BACB30LJ12CD30 (REF)
-  OUTSIDE DIMENSION ACROSS BALL FACES
-  INSIDE DIMENSION BETWEEN FLANGE FACES

Fits and Clearances  
 Figure 801 (Sheet 7)

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FITS AND CLEARANCES

FOR TORQUE VALUES OF STANDARD FASTENERS, REFER TO 20-50-01		
ITEM NO. IPL FIG.	NAME	TORQUE
		POUND-INCHES
385	Nut	180-240
753	Nut	180-240

**NOTE:** Tighten nut to listed value, back off to nearest slot and install cotter pin per 20-50-02.

Torque Table  
 Figure 802

**32-12-05**



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.

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ILLUSTRATED PARTS LIST

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VENDORS

06710 VALLEY-TODECO INCORPORATED  
12975 BRADLEY AVENUE  
SYLMAR, CALIFORNIA 91342

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

06950 VSI CORP SCREWCORP DIV  
13001 EAST TEMPLE AVENUE  
CITY OF INDUSTRY, CALIFORNIA 91746

08524 DEUTSCH FASTENER CORPORATION  
PO BOX 92925 7001 WEST IMPERIAL HIGHWAY  
LOS ANGELES, CALIFORNIA 90045

09455 LEAR SIEGLER INC TRANSPORT DYNAMICS DIV  
PO BOX 1953 3131 WEST SEGERSTROM STREET  
SANTA ANA, CALIFORNIA 92702

10630 ANILLO INDUSTRIES, INCORPORATED  
2090 NORTH GLASSELL  
ORANGE, CALIFORNIA 92667

11815 TOWNSEND DIV OF TEXTRON INC CHERRY FASTENER UNIT  
BOX 2157 1224 EAST WARNER AVENUE  
SANTA ANA, CALIFORNIA 92707

15653 KAYNAR MICRODOT FASTENING SYSTEMS HIGH-TECH DIV  
PO BOX 3001 800 SOUTH STATE COLLEGE BLVD  
FULLERTON, CALIFORNIA 92634

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

17943 FEDERAL MANUFACTURING CORPORATION  
6910 FARMDALE AVENUE  
NORTH HOLLYWOOD, CALIFORNIA 91605

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

23589 NIPPON MINATURE BEARING CORP SEE NMB CORP V50294

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ILLUSTRATED PARTS LIST  
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**BOEING**  
COMPONENT  
MAINTENANCE MANUALVENDORS

27624 PAUL R BRILES INC P.B. FASTENER DIV  
1700 WEST 132ND STREET PO BOX 1157  
GARDENA, CALIFORNIA 90249

50294 NMB INC  
9730 INDEPENDENCE AVENUE  
CHATSWORTH, CALIFORNIA 91311

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

56878 SPS TECHNOLOGIES INC  
HIGHLAND AVENUE  
JENKINTOWN, PENNSYLVANIA 19046  
USE APPLICABLE FACILITY CODE

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

72962 AMERACE CORP ESNA DIV  
2330 VAUXHALL ROAD  
UNION, NEW JERSEY 07083  
ELASTIC STOP NUT DIV AMERACE CORP SEE ESNA DIV AMERACE CORP  
ESNA DIV OF AMERACE CORP SEE AMERACE CORP ESNA DIV

73134 HEIM DIV INCOM INTERNATIONAL INC  
60 ROUND HILL ROAD  
FAIRFIELD, CONNECTICUT 06430

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

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

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VENDORS

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

92595 AUTOMATIC SCREW MACHINE PRODUCTS CO  
PO BOX 1608 709 2ND AVENUE SE  
DECATUR, ALABAMA 35602

93907 TEXTRON INC CAMCAR DIV  
600 18TH AVENUE  
ROCKFORD, ILLINOIS 61101

94892 MASTER MACHINE PRODUCTS CORPORATION  
2069 RANDOLPH STREET  
HUNTINGTON PARK, CALIFORNIA 90255

95879 ALEMITE DIVISION OF STEWART WARNER CORP  
1826 DIVERSEY PARKWAY  
CHICAGO, ILLINOIS 60614

97613 SARGENT INDUSTRIES KAHR BEARING DIVISION  
3010 NORTH SAN FERNANDO ROAD  
BURBANK, CALIFORNIA 91503

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

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ILLUSTRATED PARTS LIST  
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**BOEING**  
 COMPONENT  
 MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
AN960PD10		1	70	3
		1	535	
AN960PD416L		1	293	2
AN960PD616L		1	303S	2
ARBL18-5		1	770	1
		1	775	1
ARH18E102		1	770	1
		1	775	1
BACB10EP05GC		1	430	1
BACB10EP12GC		1	435	1
BACB28AA9C038		1	210	1
BACB28AK05-037		1	335	
BACB28AK05-25		1	335A	
BACB28AK09-153		1	620	1
BACB28AK10-060		1	615	1
BACB28AK10-134		1	610	1
BACB28AK12-066		1	695	1
		1	725	1
BACB28AM07A025		1	345	2
BACB28AM13B028A		1	640	2
BACB28AM13B038A		1	215	1
BACB28AM14B037A		1	160	1
BACB28AM14B051A		1	655	2
BACB28AM17B030A		1	645	1
BACB28AP05P025		1	350	2
BACB28W22C065		1	428A	1
BACB28W22C65		1	428	
BACB28X12C030		1	650	1
BACB30LJ5U19		1	315	2
BACB30MT6K16		1	255	2
BACB30MT6K18		1	265	2
BACB30MT6K20		1	250	2
BACB30MT6K23		1	260	2
BACB30MY10K10		1	460A	6
BACB30MY10K12		1	450A	6
BACB30NJ10K46		1	565	1
BACB30NJ12K34		1	705	1
BACB30NJ12K36		1	675	1
BACB30NJ9K36		1	570	1
BACB30NN3K20		1	530	
BACB30NN3K9		1	65	3
BACB30NN6K18		1	530A	
BACB30NBK16		1	290A	2
BACB30NW12K9		1	303M	2
BACB30NW6K		1	631	2
BACB30NW6K17		1	632	4
BACB30NW6K18		1	530B	2

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACB30NW6K9		1	630	1
BACB30NW8K		1	634	4
BACB30NW8K14		1	290	2
BACB30NW8K9		1	633	1
BACB30NX10K11		1	30A	2
		1	240A	2
BACB30NX10K12		1	25B	2
BACB30NX10K13		1	30	2
BACB30NX10K14		1	25A	2
BACB30NX10K16		1	125	1
BACB30NX10K19		1	130	1
BACB30NX10K20		1	120	1
BACB30NX10K21		1	123	1
BACB30NX10K8		1	302	2
BACB30NX12K11		1	302M	2
BACB30NX12K13		1	195	1
BACB30NX12K14		1	197	1
BACB30NX8K11		1	20B	1
		1	50A	6
		1	185A	1
BACB30NX8K12		1	17B	1
		1	190A	1
BACB30NX8K13		1	20	1
BACB30NX8K14		1	17	1
BACB30NX8K16		1	110	1
BACB30NX8K17		1	115	1
BACB30NX8K18		1	105	1
BACB30NX8K19		1	135	1
BACB30NX8K8		1	302G	2
BACB30US6K16		1	255A	2
BACB30US6K18		1	265A	2
BACB30US6K20		1	250A	2
BACB30US6K23		1	260A	2
BACB30UU10K46		1	565A	1
BACB30UU12K34		1	705A	1
BACB30UU12K36		1	675A	1
BACB30UU9K36		1	570A	1
BACC30M10		1	453	6
		1	465	6
BACC30M6		1	635	6
		1	636	
		1	540A	2
BACC30M8		1	295	2
		1	637	
		1	638	

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**BOEING**  
 COMPONENT  
 MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACC30X10		1	40	4
		1	145	4
		1	245	2
		1	302S	2
BACC30X12		1	205	2
		1	303G	2
BACC30X8		1	35	2
		1	55	6
		1	140	4
		1	200	2
		1	303	2
BACF3F017R025AN		1	300L	1
BACN10HR6		1	280	8
BACN10JC10		1	575	1
BACN10JC12		1	680	1
		1	710	1
BACN10JC3CM		1	75A	3
BACN10JC3CN		1	75	
		1	540	
BACN10JC4CD		1	297	2
BACN10JC5CM		1	330	2
BACN10JC6CD		1	303W	2
BACN10JC9		1	580	1
BACN10JD116		1	753	1
BACN10JD116ASU		1	385	1
BACS40R06U016		1	545	AR
BACS40R10C051F		1	85	1
BACS40R15B25F		1	304M	1
BACS40R15B44F		1	44	2
BACS40R17E25F		1	300	1
BACS40R21D57F		1	207	1
BACS40R29B30F		1	77	
		1	93	1
BACS40R29B44F		1	43	1
BACS40R36D57F		1	150	1
BACW10BN10SC		1	585	1
BACW10BN10SP		1	590	1
BACW10BN105C		1	585A	
BACW10BN12SC		1	690	1
		1	720	1
BACW10BN12SP		1	685	1
		1	715	1
BACW10BN5UC		1	320	
BACW10BN5UP		1	325	
BACW10BN9SC		1	600	1
BACW10BN9SP		1	605	1
BACW10BP5ACU		1	320A	2

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACW10BP5APU		1	325A	2
BACW10BP6ACU		1	270	8
BACW10BP6APU		1	275	8
HL10VAZ10-7		1	460	
HL10VAZ10-9		1	450	
HL12VAZ10-10		1	240	
HL12VAZ10-12		1	25	
HL12VAZ10-16		1	15A	
HL12VAZ8-10		1	50	
		1	185	
HL12VAZ8-11		1	190	
HL12VAZ8-12		1	15	
		1	20A	
HL12VAZ8-13		1	17A	
MK1216-26-2G		1	730A	2
MS15001-1		1	520	1
MS24665-377		1	748	1
NAS509-17C		1	740	2
NAS509-24		1	760	1
		1	765	1
NAS509L24		1	765A	1
NAS513-16		1	745	2
S012T234-1		1	730	
		1	730A	2
S012T234-318		1	770	1
		1	775	1
S012T234-318-8		1	775A	1
012T2400-24		1	410	1
012T2400-25		1	415	1
012T2400-27		1	420	1
		1	420A	1
012T2400-28		1	425	1
		1	425A	1
012T2400-48		1	422	1
012T2400-49		1	427	1
012T2400-50		1	420B	1
012T2400-51		1	425B	1
149T6813-1		1	12	1
149T6815-1		1	304	1
149T6815-2		1	304B	1
149T6815-3		1	304A	1
149T6815-4		1	304C	1
149T6902-107		1	1H	RF
149T6902-108		1	5H	RF
149T6902-16		1	375	
149T6902-20		1	595	1
149T6902-25		1	335B	2

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**BOEING**  
 COMPONENT  
 MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
149T6902-26		1	377	
149T6902-27		1	1A	
149T6902-28		1	5A	
149T6902-29		1	373	
149T6902-30		1	376	
149T6902-39		1	1B	RF
149T6902-40		1	5B	RF
149T6902-41		1	1C	
149T6902-42		1	5C	
149T6902-43		1	1D	RF
149T6902-44		1	5D	RF
149T6902-45		1	1E	RF
149T6902-46		1	5E	RF
149T6902-47		1	751	1
149T6902-48		1	752	1
		1	375A	1
149T6902-5		1	1	RF
149T6902-6		1	5	RF
149T6902-69		1	1F	RF
149T6902-70		1	5F	RF
149T6902-71		1	1G	RF
149T6902-72		1	5G	RF
149T6922-1		1	495	2
149T6922-17		1	512	2
149T6922-18		1	517	2
149T6922-19		1	497	2
149T6922-20		1	503	2
149T6922-3		1	505	2
149T6922-5		1	510	2
149T6922-7		1	500	2
149T6922-8		1	515	2
149T6931-1		1	390	1
149T6931-10		1	395A	1
149T6931-11		1	405A	1
149T6931-12		1	400A	1
149T6931-13		1	470A	1
149T6931-14		1	475A	1
149T6931-15		1	485A	1
149T6931-16		1	480A	1
149T6931-17		1	390B	1
149T6931-18		1	395B	1
149T6931-19		1	405B	1
149T6931-2		1	395	1
149T6931-20		1	400B	1
149T6931-21		1	470B	1
149T6931-22		1	475B	1
149T6931-23		1	485B	1

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
149T6931-24		1	480B	1
149T6931-25		1	390C	1
149T6931-26		1	395C	1
149T6931-27		1	405C	1
149T6931-28		1	400C	1
149T6931-3		1	405	1
149T6931-4		1	400	1
149T6931-5		1	470	1
149T6931-6		1	475	1
149T6931-7		1	485	1
149T6931-8		1	480	1
149T6931-9		1	390A	1
149T6935-1		1	700	1
149T6955-1		1	490	
149T6955-10		1	519	2
149T6955-11		1	492	1
149T6955-12		1	525B	1
149T6955-2		1	550	1
149T6955-3		1	525	
149T6955-4		1	490A	
149T6955-5		1	525A	
149T6955-6		1	518	2
149T6955-8		1	494	1
149T6955-9		1	553	1
149T6956-1		1	755	1
149T6956-2		1	780	1
149T6956-3		1	755A	1
149T6956-4		1	780A	1
149T6962-1		1	230	1
149T6962-10		1	310A	1
149T6962-15		1	230B	1
149T6962-16		1	235B	1
149T6962-2		1	235	1
149T6962-3		1	305	1
149T6962-4		1	310	1
149T6962-5		1	285	
		1	301	1
149T6962-6		1	304G	4
149T6962-7		1	230A	1
149T6962-8		1	235A	1
149T6962-9		1	305A	1
149T6963-1		1	340	1
149T6965-1		1	445	
149T6965-10		1	447	1
149T6965-11		1	457	1
149T6965-12		1	456	1
149T6965-13		1	448	1

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
149T6965-15		1	456A	1
149T6965-16		1	457A	1
149T6965-2		1	455	
149T6965-5		1	455A	
149T6965-6		1	445A	
149T6965-9		1	446	1
149T6979-1		1	625	
149T6979-3		1	625A	1
149T6979-4		1	625B	1
149T6980-1		1	735	1
149T6985-2		1	750	1
149T6985-6		1	750A	1
149T6988-1		1	95	1
149T6988-2		1	100	1
149T6988-3		1	165	1
149T6988-4		1	170	1
149T6988-5		1	155	1
149T6989-1		1	175	1
149T6989-2		1	180	1
149T6989-3		1	220	1
149T6989-4		1	225	1
149T6990-1		1	10	1
149T6991-1		1	45	1
149T6991-2		1	90	1
149T6991-3		1	60	1
149T6991-4		1	80	3
149T7801-1		1	555	
149T7801-10		1	560B	1
		1	563A	
149T7801-11		1	667	1
149T7801-12		1	672	1
149T7801-13		1	668	1
149T7801-15		1	555C	1
149T7801-16		1	673	1
		1	560C	1
149T7801-2		1	560	
149T7801-3		1	665	
149T7801-4		1	670	
149T7801-5		1	557	
		1	555A	1
149T7801-6		1	563	
		1	560A	1
149T7801-7		1	665A	1
149T7801-8		1	670A	1
149T7801-9		1	555B	1
		1	557A	
1728B		1	660	2

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
ARH18E102		1	770	1
		1	775	1
ASBEP05VC		1	430	2
ASBEP12VC		1	435	2
BACB10EP05GC		1	430	2
BACB10EP12GC		1	435	2
BACB28AA9C038		1	210	1
BACB28AK09-153		1	620	1
BACB28AK10-060		1	615	1
BACB28AK10-134		1	610	1
BACB28AK12-066		1	695	1
		1	725	1
BACB28AM07A025		1	345	2
BACB28AM13B028A		1	640	2
BACB28AM13B038A		1	215	1
BACB28AM14B037A		1	160	1
BACB28AM14B051A		1	655	2
BACB28AM17B030A		1	645	1
BACB28AP05P025		1	350	2
BACB28W22C065		1	428A	2
BACB28X12C030		1	650	1
BACB30LJ5U19		1	315	2
BACB30MT6K16		1	255	2
BACB30MT6K18		1	265	2
BACB30MT6K20		1	250	2
BACB30MT6K23		1	260	2
BACB30MY10K10		1	460A	6
BACB30MY10K12		1	450A	6
BACB30NJ10K46		1	565	1
BACB30NJ12K34		1	705	1
BACB30NW6K17		1	632	4
BACB30NW6K18		1	530B	2
BACB30NW6K9		1	630	2
BACB30NW8K		1	634	4
BACB30NW8K14		1	290	2

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACB30NX10K14		1	25A	2
BACB30NX10K16		1	125	1
BACB30NX10K19		1	130	1
BACB30NX10K20		1	120	1
BACB30NX10K21		1	123	1
BACB30NX10K8		1	302	2
BACB30NX12K11		1	302M	2
BACB30NX12K13		1	195	1
BACB30NX12K14		1	197	1
BACB30NX8K11		1	20B	1
		1	50A	6
		1	185A	1
BACC30M6		1	540A	2
		1	635	6
		1	636	2
BACC30M8		1	295	2
		1	637	1
		1	638	4
BACC30X8		1	35	2
		1	55	6
		1	140	4
		1	200	2
		1	303	2
BACN10HR6		1	280	8
BACN10JC10		1	575	1
BACN10JC12		1	680	1
		1	710	1
BACN10JC3CM		1	75A	3
BACN10JC4CD		1	297	2
BACN10JC5CM		1	330	2
BACN10JC6CD		1	303W	2
BACN10JC9		1	580	1
BACN10JD116		1	753	1

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACN10JD116ASU		1	385	1
BACS40R06U016		1	545	1
BACS40R10C051F		1	85	1
BACS40R15B25F		1	304M	1
BACS40R15B44F		1	44	2
BACS40R17E25F		1	300	1
BACS40R21D57F		1	207	1
BACS40R29B30F		1	93	1
BACS40R29B44F		1	43	1
BACS40R36D57F		1	150	1
BACW10BN9SC		1	600	1
BACW10BN9SP		1	605	1
BACW10BP5ACU		1	320A	2
BACW10BP5APU		1	325A	2
BACW10BP6ACU		1	270	8
BACW10BP6APU		1	275	8
BMNN10HR6		1	280	8
BMN4122AD3-10		1	575	1
BMN4122AD3-12		1	680	1
		1	710	1
BMN4122AD3-9		1	580	1
BRH10C4D		1	297	2
BRH10C6D		1	303W	2
BR1110C3M		1	75A	3
BR1110C5M		1	330	2
HL1187-10		1	40	4
		1	145	4
		1	245	2
		1	302S	2
HL1187-12		1	205	2
		1	303G	2

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
HL1187-8		1	35	2
		1	55	6
		1	140	4
		1	200	2
		1	303	2
HL12VAZ10-11		1	30A	2
HL12VAZ10-11		1	240A	2
HL12VAZ10-12		1	25B	2
HL12VAZ10-13		1	30	2
HL12VAZ10-14		1	25A	2
HL12VAZ12-11		1	302M	2
HL12VAZ12-13		1	195	1
HL12VAZ12-14		1	197	1
HL12VAZ8-11		1	20B	1
		1	50A	6
		1	185A	1
HL12VAZ8-12		1	17B	1
		1	190A	1
HL12VAZ8-13		1	20	1
HL12VAZ8-14		1	17	1
HL12VAZ8-16		1	110	1
HL12VAZ8-17		1	115	1
HL12VAZ8-18		1	105	1
HL12VAZ8-19		1	135	1
HL12VAZ8-8		1	302G	2
HL79-10		1	453	6
		1	465	6
HL79-6		1	540A	2
		1	635	6
		1	636	2
HL79-8		1	295	2
		1	637	1
		1	638	4

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
HL87-10		1	40	4
		1	145	4
		1	245	2
		1	302S	2
HL87-12		1	205	2
		1	303G	2
HL87-8		1	35	2
		1	55	6
		1	140	4
		1	200	2
H01-3BAC		1	303	2
		1	75A	3
		1	330	2
		1	575	1
H01-5BAC		1	680	1
H10-10BAC		1	710	1
H10-12BAC		1	435	2
KSB12-58		1	430	2
KSB5-52-58		1	430	2
LHB05EPGC		1	435	2
LHB12EPGC		1	435	2
LHB12GC		1	435	2
MK1216-26-2G		1	730A	2
MS15001-1		1	520	1
MS24665-377		1	360	1
		1	748	1
NAS509-17C		1	740	2
NAS509-24		1	760	1
		1	765	1
NAS509L24		1	765A	1
NAS513-16		1	745	2
NS202101SE02		1	75A	3

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
NS202486-048		1	297	2
RMLH22-6		1	280	8
RMLH9074-10		1	575	1
RMLH9074-12		1	680	1
		1	710	1
RMLH9074-9		1	580	1
SL7058S624		1	280	8
S012T234-1		1	730A	2
S012T234-318		1	770	1
		1	775	1
S012T234-318-8		1	775A	1
T6C1032JM		1	75A	3
T6C428CD		1	297	2
T6C524JM		1	330	2
VN303D02		1	75A	3
012T2400-49		1	427	2
012T2400-50		1	420B	2
012T2400-51		1	425B	2
03-525-05E003C		1	430	2
03-525-12E003C		1	435	2
102LH9075-4W		1	297	2
109LH9075-3W		1	75A	3
109LH9075-5W		1	330	2
149T6813-1		1	12	1
149T6815-1		1	304	1
149T6815-2		1	304B	1
149T6815-3		1	304A	1
149T6815-4		1	304C	1
149T6902-20		1	595	1
149T6902-25		1	335B	2
149T6902-39		1	1B	RF
149T6902-40		1	5B	RF
149T6902-43		1	1D	RF
149T6902-44		1	5D	RF
149T6902-45		1	1E	RF

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
149T6902-46		1	5E	RF
149T6902-47		1	370A	1
		1	751	1
149T6902-48		1	375A	1
		1	752	1
149T6902-5		1	1	RF
149T6902-51		1	377A	1
149T6902-6		1	5	RF
149T6902-69		1	1F	RF
149T6902-70		1	5F	RF
149T6922-19		1	497	2
149T6922-20		1	503	2
149T6922-3		1	505	2
149T6922-5		1	510	2
149T6922-7		1	500	2
149T6922-8		1	515	2
149T6931-1		1	390	1
149T6931-10		1	395A	1
149T6931-11		1	405A	1
149T6931-12		1	400A	1
149T6931-13		1	470A	1
149T6931-14		1	475A	1
149T6931-15		1	485A	1
149T6931-16		1	480A	1
149T6931-17		1	390C	1
149T6931-18		1	395C	1
149T6931-19		1	405C	1
149T6931-2		1	395	1
149T6931-20		1	400C	1
149T6931-21		1	470B	1
149T6931-22		1	475B	1
149T6931-23		1	485B	1
149T6931-24		1	480B	1
149T6931-25		1	390B	1
149T6931-26		1	395B	1

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
149T6931-27		1	405B	1
149T6931-28		1	400B	1
149T6931-3		1	405	1
149T6931-4		1	400	1
149T6931-5		1	470	1
149T6955-10		1	519	2
149T6955-11		1	492	1
149T6955-12		1	525B	1
149T6955-2		1	550	1
149T6955-6		1	518	2
149T6955-8		1	494	1
149T6955-9		1	553	1
149T6956-1		1	755	1
149T6956-2		1	780	1
149T6956-3		1	755A	1
149T6956-4		1	780A	1
149T6962-1		1	230	1
149T6962-10		1	310A	1
149T6962-2		1	235	1
149T6962-3		1	305	1
149T6962-4		1	310	1
149T6962-5		1	301	1
149T6962-6		1	304G	4
149T6962-7		1	230A	1
149T6962-8		1	235A	1
149T6962-9		1	305A	1
149T6963-1		1	340	1
149T6963-2		1	355	1
149T6965-10		1	447	1
149T6965-11		1	457	1
149T6965-12		1	456	1
149T6965-13		1	448	1
149T6965-15		1	456A	1
149T6965-16		1	457A	1
149T6965-9		1	446	1

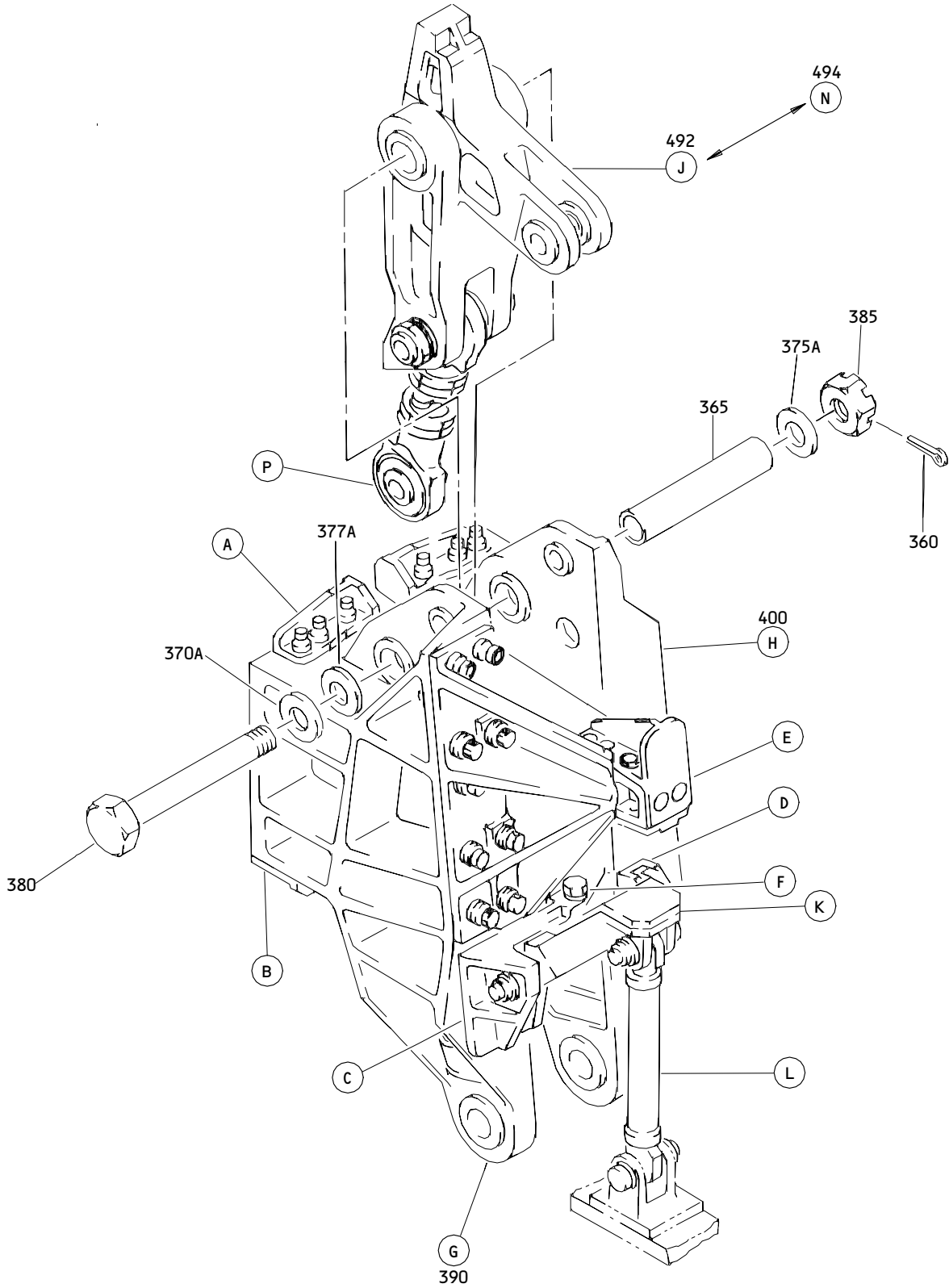
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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
149T6979-3		1	625A	1
149T6979-4		1	625B	1
149T6980-1		1	735	1
149T6985-2		1	750	1
149T6985-6		1	750A	1
149T6986-1		1	365	1
149T6986-3		1	380	1
149T6988-1		1	95	1
149T6988-2		1	100	1
149T6988-3		1	165	1
149T6989-4		1	225	1
149T6990-1		1	10	1
149T6991-1		1	45	1
149T6991-2		1	90	1
149T6991-3		1	60	1
149T6991-4		1	80	3
149T7801-10		1	560B	1
149T7801-11		1	667	1
149T7801-12		1	672	1
149T7801-13		1	668	1
149T7801-15		1	555C	1
149T7801-16		1	560C	1
		1	673	1
149T7801-5		1	555A	1
149T7801-6		1	560A	1
149T7801-7		1	665A	1
149T7801-8		1	670A	1
149T7801-9		1	555B	1
1728B		1	660	2
48FT1018		1	575	1
48FT1216		1	680	1
		1	710	1
48FT918		1	580	1
66014-10		1	453	6
		1	465	6

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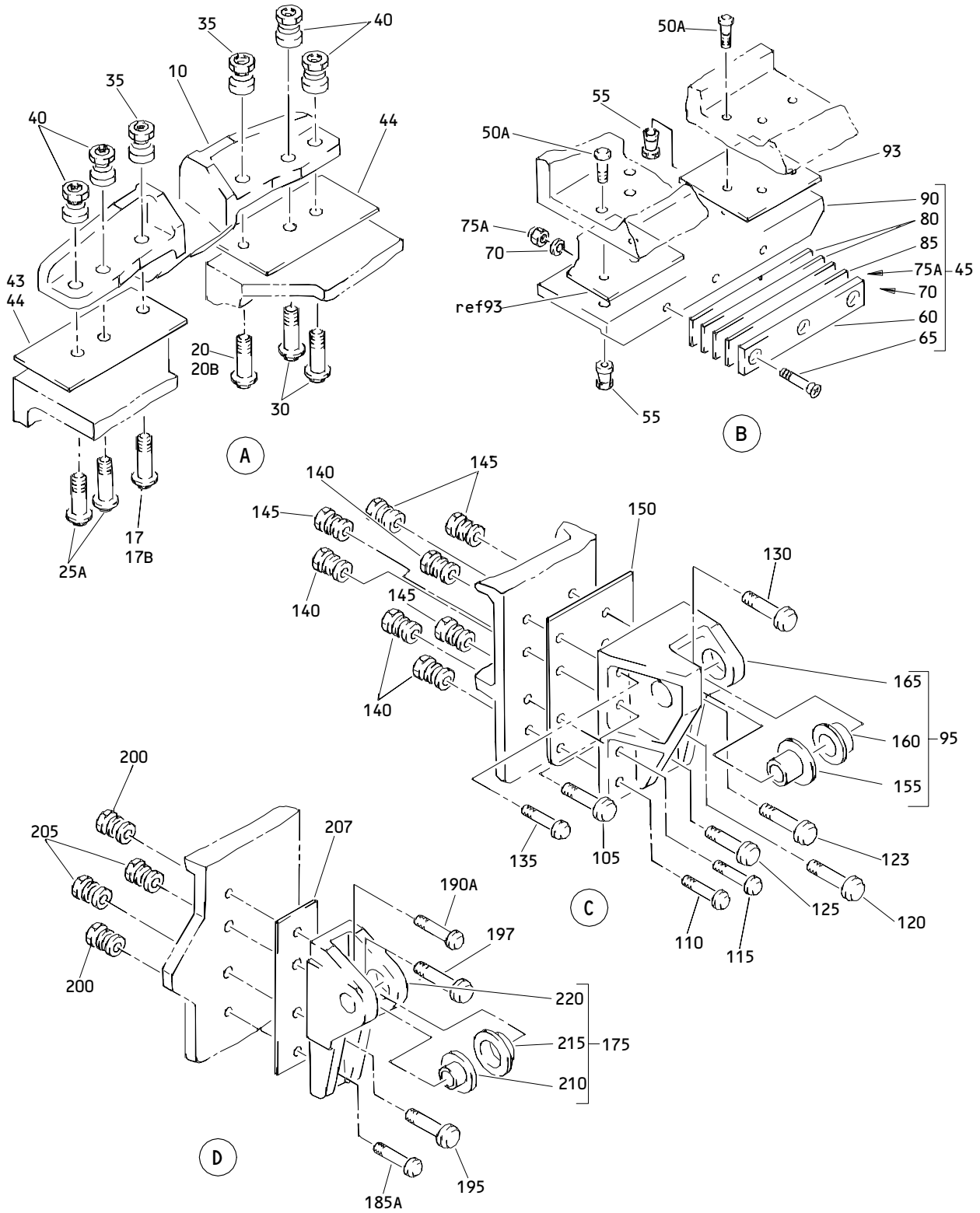
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Main Landing Gear Door Hinge Bellcrank Assembly  
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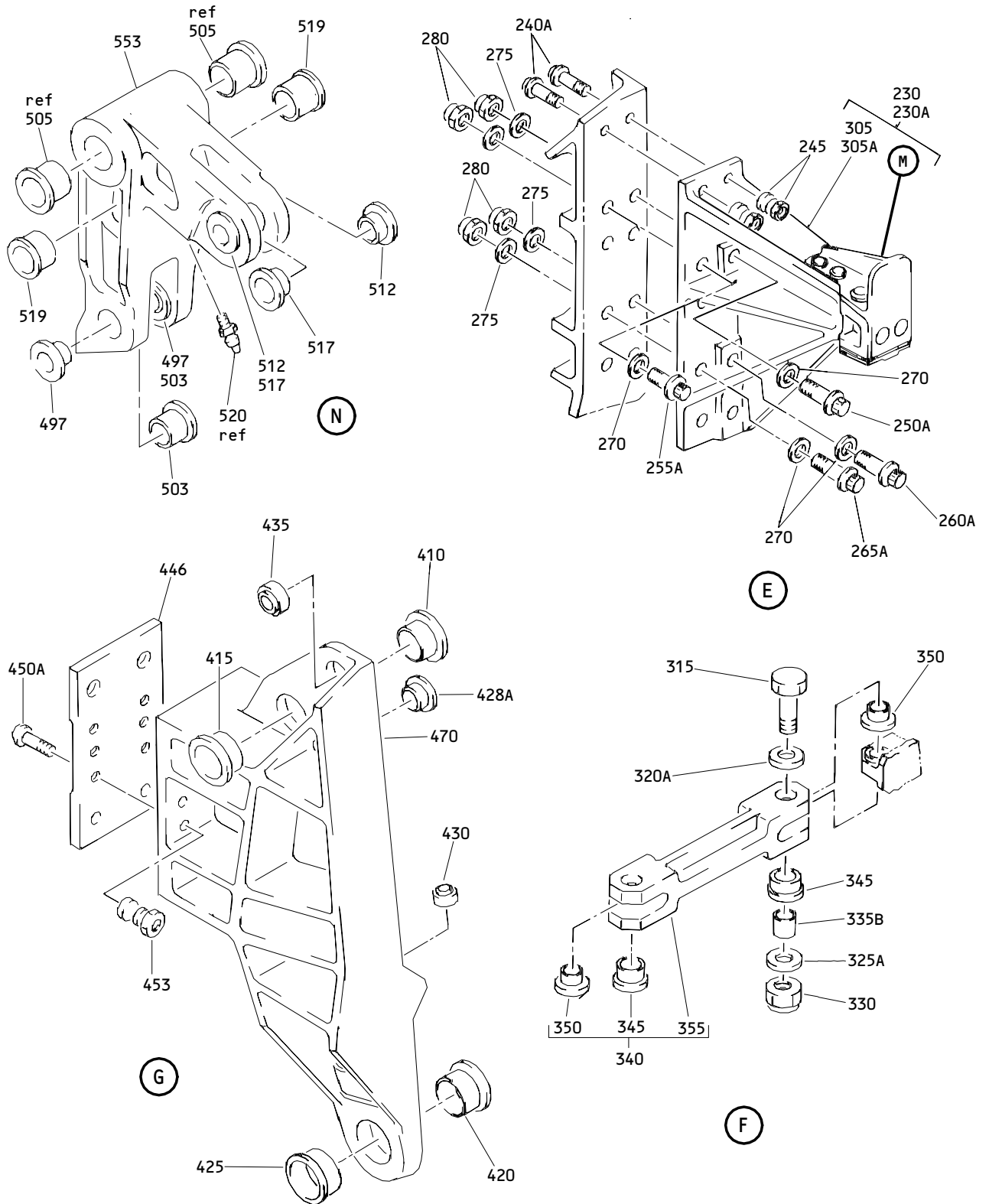


Main Landing Gear Door Hinge Bellcrank Assembly  
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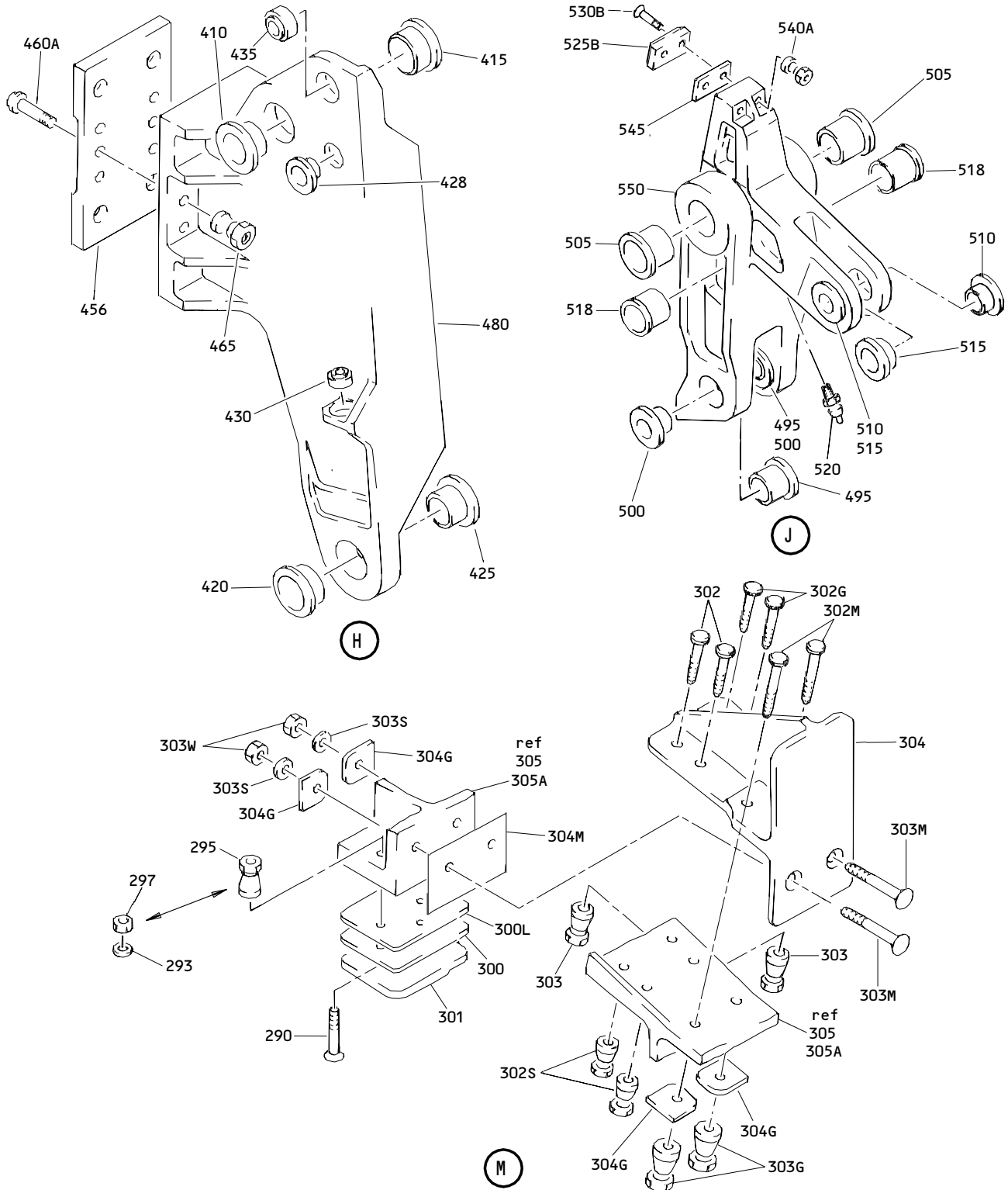




Main Landing Gear Door Hinge Bellcrank Assembly  
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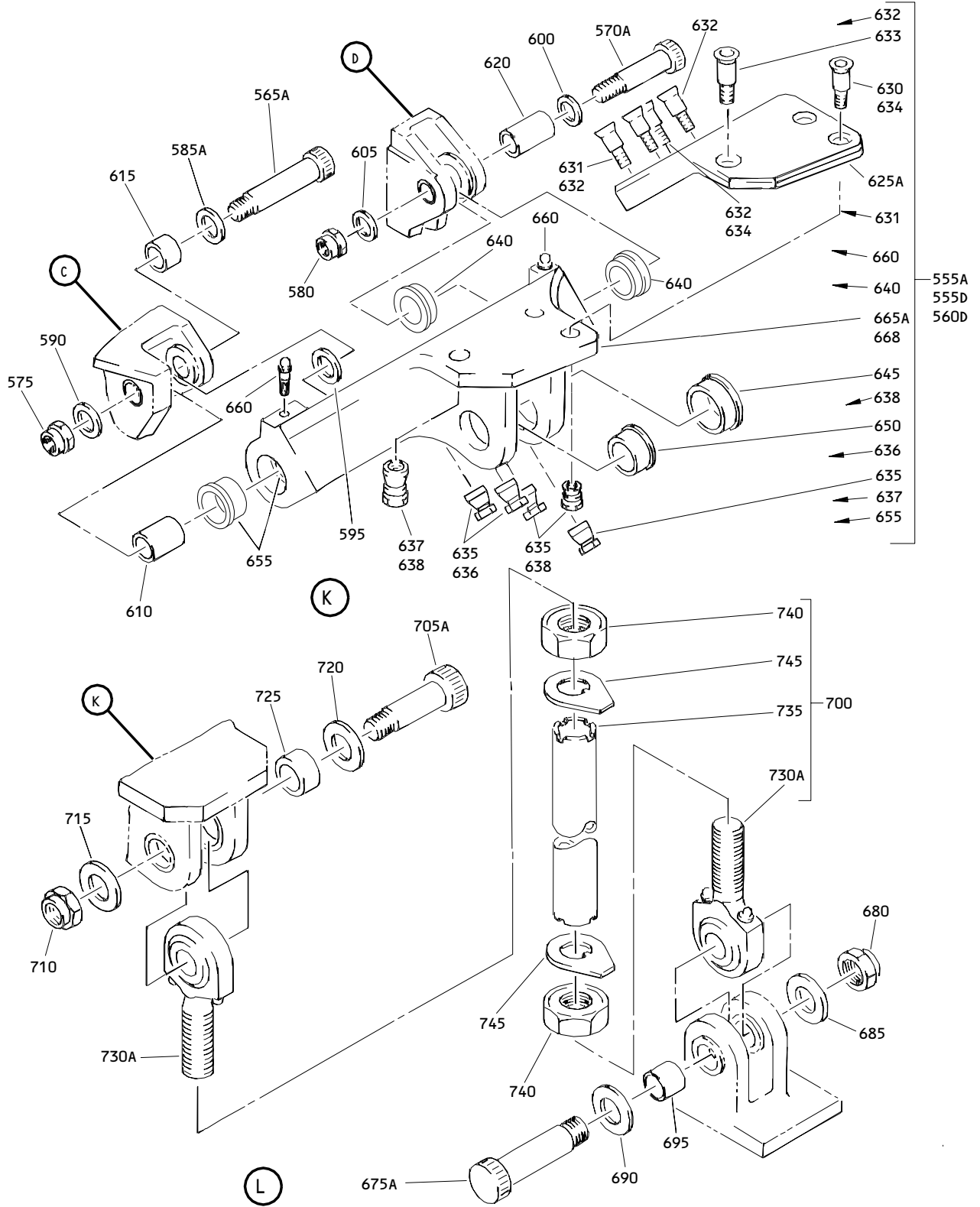
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Main Landing Gear Door Hinge Bellcrank Assembly  
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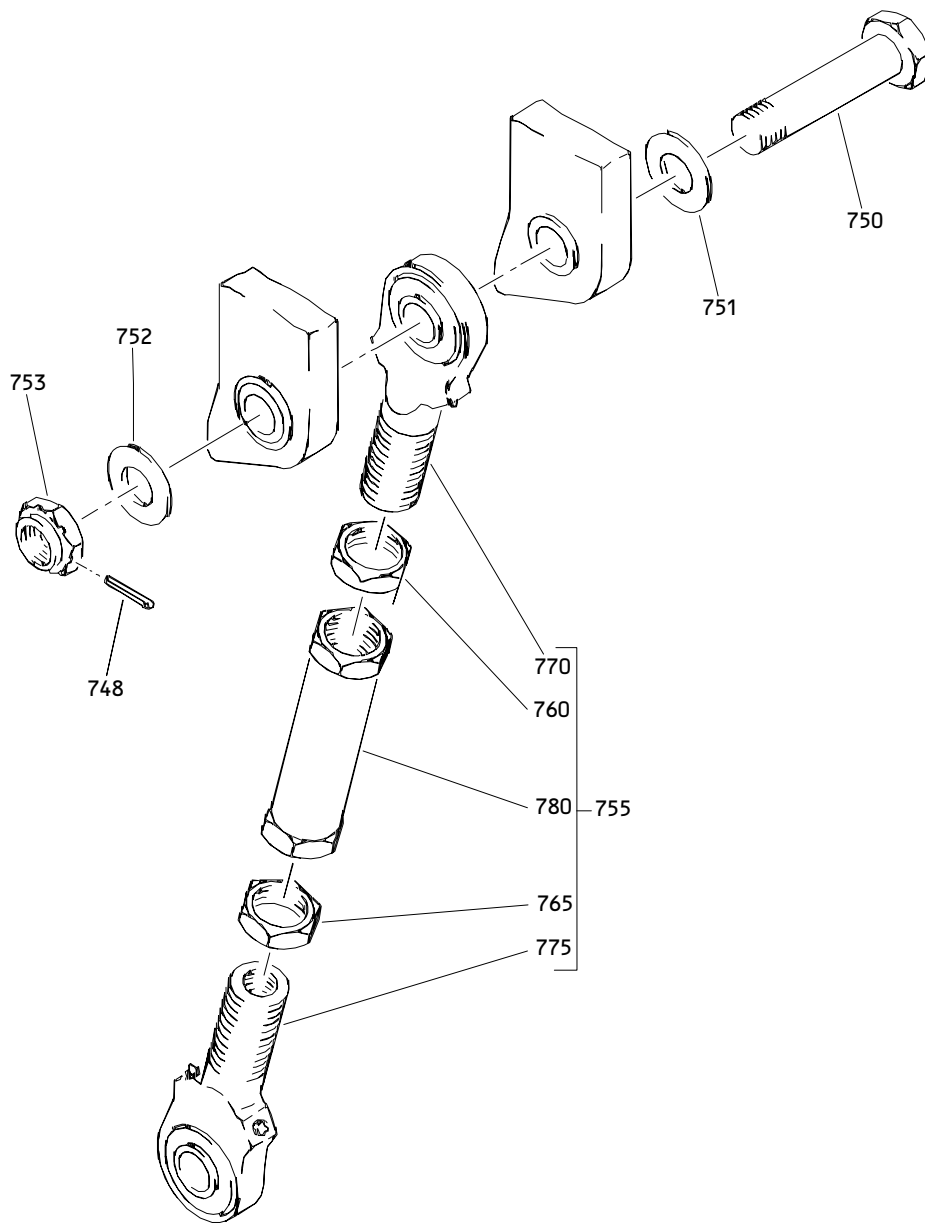
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Main Landing Gear Door Hinge Bellcrank Assembly  
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Main Landing Gear Door Hinge Bellcrank Assembly  
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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01- -1	149T6902-5		BELLCRANK ASSY-MLG DOOR HINGE (LH)	A	RF
-1A	149T6902-27		DELETED		
-1B	149T6902-39		BELLCRANK ASSY-MLG DOOR HINGE (LH)	C	RF
-1C	149T6902-41		DELETED		
-1D	149T6902-43		BELLCRANK ASSY-MLG DOOR HINGE (LH)	E	RF
-1E	149T6902-45		BELLCRANK ASSY-MLG DOOR HINGE (LH)	G	RF
-1F	149T6902-69		BELLCRANK ASSY-MLG DOOR HINGE (LH)	I	RF
-1G	149T6902-71		BELLCRANK ASSY-MLG DOOR HINGE (LH)	K	RF
-1H	149T6902-107		BELLCRANK ASSY-MLG DOOR HINGE (LH)	M	RF
-5	149T6902-6		BELLCRANK ASSY-MLG DOOR HINGE (RH)	B	RF
-5A	149T6902-28		DELETED		
-5B	149T6902-40		BELLCRANK ASSY-MLG DOOR HINGE (RH)	D	RF
-5C	149T6902-42		DELETED		
-5D	149T6902-44		BELLCRANK ASSY-MLG DOOR HINGE (RH)	F	RF
-5E	149T6902-46		BELLCRANK ASSY-MLG DOOR HINGE (RH)	H	RF
-5F	149T6902-70		BELLCRANK ASSY-MLG DOOR HINGE (RH)	J	RF
-5G	149T6902-72		BELLCRANK ASSY-MLG DOOR HINGE (RH)	L	RF
-5H	149T6902-108		BELLCRANK ASSY-MLG DOOR HINGE (RH)	N	RF
10	149T6990-1		.STOP	A-H	1
-12	149T6813-1		.TIE-STABILIZING ATTACHING PARTS	I-N	1
15	HL12VAZ8-12		DELETED		
15A	HL12VAZ10-16		DELETED		
17	BACB30NX8K14		.BOLT	A-H	1
17A	HL12VAZ8-13		DELETED		
17B	BACB30NX8K12		.BOLT	I-N	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
20	BACB30NX8K13		.BOLT	A-H	1
20A	HL12VAZ8-12		DELETED		
20B	BACB30NX8K11		.BOLT	I-N	1
25	HL12VAZ10-12		DELETED		
25A	BACB30NX10K14		.BOLT	A-H	2
-25B	BACB30NX10K12		.BOLT	I-N	2
30	BACB30NX10K13		.BOLT	A-H	2
-30A	BACB30NX10K11		.BOLT	I-N	2
35	BACC30X8		.COLLAR		2
40	BACC30X10		.COLLAR		4
			-----*		
43	BACS40R29B44F		.SHIM	A-H	1
44	BACS40R15B44F		.SHIM	I-N	2
45	149T6991-1		.STOP ASSY		1
			ATTACHING PARTS		
50	HL12VAZ8-10		DELETED		
50A	BACB30NX8K11		.BOLT		6
55	BACC30X8		.COLLAR		6
			-----*		
60	149T6991-3		..PAD		1
			ATTACHING PARTS		
65	BACB30NN3K9		..BOLT		3
70	AN960PD10		..WASHER		3
75	BACN10JC3CN		DELETED		
75A	BACN10JC3CM		..NUT		3
77	BACS40R29B30F		DELETED		
80	149T6991-4		..SHIM		3
85	BACS40R10C051F		..SHIM		1
			-----*		
90	149T6991-2		..STOP		1
93	BACS40R29B30F		.SHIM		1
95	149T6988-1		.FITTING ASSY	ACEGI KM	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01- -100	149T6988-2		.FITTING ASSY	BDFHJ LN	1
			ATTACHING PARTS		
105	BACB30NX8K18		.BOLT		1
110	BACB30NX8K16		.BOLT		1
115	BACB30NX8K17		.BOLT		1
120	BACB30NX10K20		.BOLT		1
123	BACB30NX10K21		.BOLT		1
125	BACB30NX10K16		.BOLT		1
130	BACB30NX10K19		.BOLT		1
135	BACB30NX8K19		.BOLT		1
140	BACC30X8		.COLLAR		4
145	BACC30X10		.COLLAR		4
150	BACS40R36D57F		.SHIM		1
			-----*-----		
155	149T6988-5		..BUSHING		1
160	BACB28AM14B037A		..BUSHING		1
165	149T6988-3		..FITTING		1
			(USED ON ITEM 95)		
-170	149T6988-4		..FITTING		1
			(USED ON ITEM 100)		
175	149T6989-1		.FITTING ASSY	ACEGI KM	1
-180	149T6989-2		.FITTING ASSY	BDFHJ LN	1
			ATTACHING PARTS		
185	HL12VAZ8-10		DELETED		
185A	BACB30NX8K11		.BOLT		1
190	HL12VAZ8-11		DELETED		
190A	BACB30NX8K12		.BOLT		1

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01-					
195	BACB30NX12K13		.BOLT		1
197	BACB30NX12K14		.BOLT		1
200	BACC30X8		.COLLAR		2
205	BACC30X12		.COLLAR		2
207	BACS40R21D57F		.SHIM		1
			-----*-----		
210	BACB28AA9C038		..BUSHING		1
215	BACB28AM13B038A		..BUSHING		1
220	149T6989-3		..FITTING (USED ON ITEM 175)		1
-225	149T6989-4		..FITTING (USED ON ITEM 180)		1
230	149T6962-1		.FITTING ASSY	A	1
230A	149T6962-7		.FITTING ASSY	CEGIK	1
-230B	149T6962-15		.FITTING ASSY	M	1
-235	149T6962-2		.FITTING ASSY	B	1
-235A	149T6962-8		.FITTING ASSY	DFHJL	1
-235B	149T6962-16		.FITTING ASSY ATTACHING PARTS	N	1
240	HL12VAZ10-10		DELETED		
240A	BACB30NX10K11		.BOLT		2
245	BACC30X10		.COLLAR		2
250	BACB30MT6K20		.BOLT		2
			(SUPSD BY ITEM 250A)		
250A	BACB30US6K20		.BOLT		2
			(SUPSDS ITEM 250)		
255	BACB30MT6K16		.BOLT		2
			(SUPSD BY ITEM 255A)		
255A	BACB30US6K16		.BOLT		2
			(SUPSDS ITEM 255)		

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01- 260	BACB30MT6K23		.BOLT (SUPSD BY ITEM 260A)		2
260A	BACB30US6K23		.BOLT (SUPSDS ITEM 260)		2
265	BACB30MT6K18		.BOLT (SUPSD BY ITEM 265A)		2
265A	BACB30US6K18		.BOLT (SUPSDS ITEM 265)		2
270	BACW10BP6ACU		.WASHER		8
275	BACW10BP6APU		.WASHER		8
280	BACN10HR6		.NUT -----*		8
285	149T6962-5		DELETED		
290	BACB30NW8K14		..BOLT (USED ON ITEMS 230,230A, 235,235A)		2
-290A	BACB30NWBK16		..BOLT (USED ON ITEMS 230B, 235B)		2
293	AN960PD416L		..WASHER (USED ON ITEMS 230A, 230B,235A,235B)		2
295	BACC30M8		..COLLAR (USED ON ITEMS 230,235)		2
297	BACN10JC4CD		..NUT (USED ON ITEMS 230A, 230B,235A,235B)		2
300	BACS40R17E25F		..SHIM		1
300L	BACF3F017R025AN		..FILLER (USED ON ITEMS 230B, 235B)		1
301	149T6962-5		..PAD		1
302	BACB30NX10K8		..BOLT (USED ON ITEMS 230A, 230B,235A,235B)		2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-302G	BACB30NX8K8		..BOLT (USED ON ITEMS 230A, 230B,235A,235B)		2
302M	BACB30NX12K11		..BOLT (USED ON ITEMS 230A, 230B,235A,235B)		2
302S	BACC30X10		..COLLAR (USED ON ITEMS 230A, 230B,235A,235B)		2
303	BACC30X8		..COLLAR (USED ON ITEMS 230A, 230B,235A,235B)		2
303G	BACC30X12		..COLLAR (USED ON ITEMS 230A, 230B,235A,235B)		2
303M	BACB30NW12K9		..BOLT (USED ON ITEMS 230A, 230B,235A,235B)		2
303S	AN960PD616L		..WASHER (USED ON ITEMS 230A, 230B,235A,235B)		2
303W	BACN10JC6CD		..NUT (USED ON ITEMS 230A, 230B,235A,235B)		2
304	149T6815-1		..FITTING (USED ON ITEMS 230A, 230B)		1
-304A	149T6815-3		..FITTING (OPT) (USED ON ITEMS 230A, 230B)		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01- -304B	149T6815-2		..FITTING (USED ON ITEMS 235A, 235B)		1
-304C	149T6815-4		..FITTING (OPT) (USED ON ITEMS 235A, 235B)		1
304G	149T6962-6		..FILLER (USED ON ITEMS 230A, 230B,235A,235B)		4
304M	BACS40R15B25F		..SHIM (USED ON ITEMS 230A, 230B,235A,235B)		1
305	149T6962-3		..FITTING (USED ON ITEM 230)		1
305A	149T6962-9		..FITTING (USED ON ITEMS 230A, 230B)		1
-310	149T6962-4		..FITTING (USED ON ITEM 235)		1
-310A	149T6962-10		..FITTING (USED ON ITEMS 235A, 235B)		1
315	BACB30LJ5U19		.BOLT		2
320	BACW10BN5UC		DELETED		
320A	BACW10BP5ACU		.WASHER		2
325	BACW10BN5UP		DELETED		
325A	BACW10BP5APU		.WASHER		2
330	BACN10JC5CM		.NUT		2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
335	BACB28AK05-037		DELETED		
335A	BACB28AK05-25		DELETED		
335B	149T6902-25		.BUSHING		2
340	149T6963-1		.FITTING ASSY		1
345	BACB28AM07A025		..BUSHING		2
350	BACB28AP05P025		..BUSHING		2
355	149T6963-2		..FITTING		1
360	MS24665-377		.PIN		1
365	149T6986-1		.PIN		1
370	149T6902-15		DELETED		
370A	149T6902-47		.WASHER		1
-373	149T6902-29		DELETED		
375	149T6902-16		DELETED		
375A	149T6902-48		.WASHER		1
-376	149T6902-30		DELETED		
377	149T6902-26		DELETED		
377A	149T6902-51		.WASHER		1
380	149T6986-3		.PIN		1
385	BACN10JD116ASU		.NUT		1
390	149T6931-1		.FITTING ASSY	AG	1
-390A	149T6931-9		.FITTING ASSY	CI	1
-390B	149T6931-17		.FITTING ASSY	E	1
-390C	149T6931-25		.FITTING ASSY	KM	1
-395	149T6931-2		.FITTING ASSY	BH	1
-395A	149T6931-10		.FITTING ASSY	DJ	1
-395B	149T6931-18		.FITTING ASSY	F	1
-395C	149T6931-26		.FITTING ASSY	LN	1
400	149T6931-4		.FITTING ASSY	AG	1
-400A	149T6931-12		.FITTING ASSY	CI	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-400B	149T6931-20		.FITTING ASSY	E	1
-400C	149T6931-28		.FITTING ASSY	KM	1
-405	149T6931-3		.FITTING ASSY	BH	1
-405A	149T6931-11		.FITTING ASSY	DJ	1
-405B	149T6931-19		.FITTING ASSY	F	1
-405C	149T6931-27		.FITTING ASSY	LN	1
410	012T2400-24		..BUSHING		1
415	012T2400-25		..BUSHING		1
420	012T2400-27		..BUSHING (USED ON ITEMS 390,390B, 395,395B,400,400B,405, 405B)		1
-420A	012T2400-27		..BUSHING (OPT) (USED ON ITEMS 390C, 395C,400C,405C)		1
-420B	012T2400-50		..BUSHING (USED ON ITEMS 390C, 395C,400C,405C)		1
-422	012T2400-48		..BUSHING (USED ON ITEMS 390A, 395A,400A,405A)		1
425	012T2400-28		..BUSHING (USED ON ITEMS 390,390B, 395,395B,400,400B,405, 405B)		1
-425A	012T2400-28		..BUSHING (OPT) (USED ON ITEMS 390C, 395C,400C,405C)		1
-425B	012T2400-51		..BUSHING (USED ON ITEMS 390C, 395C,400C,405C)		1
-427	012T2400-49		..BUSHING (USED ON ITEMS 390A, 395A,400A,405A)		1
428	BACB28W22C65		DELETED		
428A	BACB28W22C065		..BUSHING (USED ON ITEMS 390A, 390B,395A,395B,400A, 400B,405A,405B)		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
430	BACB10EP05GC		..BEARING		1
435	BACB10EP12GC		..BEARING		1
445	149T6965-1		DELETED		
445A	149T6965-6		DELETED		
446	149T6965-9		..PLATE (USED ON ITEM 390)		1
-447	149T6965-10		..PLATE (USED ON ITEM 395)		1
-448	149T6965-13		..PLATE (USED ON ITEMS 390A, 390B,395A,395B) ATTACHING PARTS		1
450	HL10VAZ10-9		DELETED		
450A	BACB30MY10K12		..BOLT (USED ON ITEMS 390,390A, 390B,395,395A,395B)		6
453	BACC30M10		..COLLAR (USED ON ITEMS 390,390A, 390B,395,395A,395B) -----*-----		6
455	149T6965-2		DELETED		
455A	149T6965-5		DELETED		
456	149T6965-12		..PLATE (USED ON ITEM 400)		1
-456A	149T6965-15		..PLATE (USED ON ITEMS 400A, 400B)		1
-457	149T6965-11		..PLATE (USED ON ITEM 405)		1
-457A	149T6965-16		..PLATE (USED ON ITEMS 405A, 405B) ATTACHING PARTS		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01- 460 460A	HL10VAZ10-7 BACB30MY10K10		DELETED ..BOLT (USED ON ITEMS 400,400A, 400B,405,405A,405B)		6
465	BACC30M10		..COLLAR (USED ON ITEMS 400,400A, 400B,405,405A,405B)		6
470	149T6931-5		*----- ..FITTING (USED ON ITEM 390)		1
-470A	149T6931-13		..FITTING (USED ON ITEMS 390A, 390B)		1
-470B	149T6931-21		..FITTING (USED ON ITEM 390C)		1
-475	149T6931-6		..FITTING (USED ON ITEM 395)		1
-475A	149T6931-14		..FITTING (USED ON ITEMS 395A, 395B)		1
-475B	149T6931-22		..FITTING (USED ON ITEM 395C)		1
480	149T6931-8		..FITTING (USED ON ITEM 400)		1
-480A	149T6931-16		..FITTING (USED ON ITEMS 400A, 400B)		1
-480B	149T6931-24		..FITTING (USED ON ITEM 400C)		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-485	149T6931-7		..FITTING (USED ON ITEM 405)		1
-485A	149T6931-15		..FITTING (USED ON ITEMS 405A, 405B)		1
-485B	149T6931-23		..FITTING (USED ON ITEM 405C)		1
490	149T6955-1		DELETED		
490A	149T6955-4		DELETED		
492	149T6955-11		.BELLCRANK ASSY (PRE SB 32-7 OR SB 32-24)	A-H	1
494	149T6955-8		.BELLCRANK ASSY (POST SB 32-7 OR SB 32-24)	I-N	1
495	149T6922-1		..BUSHING (USED ON ITEM 492)		2
497	149T6922-19		..BUSHING (USED ON ITEM 494)		2
500	149T6922-7		..BUSHING (USED ON ITEM 492)		2
503	149T6922-20		..BUSHING (USED ON ITEM 494)		2
505	149T6922-3		..BUSHING		2
510	149T6922-5		..BUSHING (USED ON ITEM 492)		2
512	149T6922-17		..BUSHING (USED ON ITEM 494)		2
515	149T6922-8		..BUSHING (USED ON ITEM 492)	ABDFG	2
517	149T6922-18		..BUSHING (USED ON ITEM 494)		2
518	149T6955-6		..BUSHING (USED ON ITEM 492)		2
519	149T6955-10		..BUSHING (USED ON ITEM 494)		2
520	MS15001-1		..FITTING-LUBE		1
525	149T6955-3		DELETED		
525A	149T6955-5		DELETED		
525B	149T6955-12		..PAD (USED ON ITEM 492)		1
			ATTACHING PARTS		

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
530	BACB30NN3K20		DELETED		
530A	BACB30NN6K18		DELETED		
530B	BACB30NW6K18		..BOLT (USED ON ITEM 492)		2
535	AN960PD10		DELETED		
540	BACN10JC3CN		DELETED		
540A	BACC30M6		..COLLAR (USED ON ITEM 492)		2
545	BACS40R06U016		..SHIM (USED ON ITEM 492)		AR
			*-----*		
550	149T6955-2		..BELLCRANK (USED ON ITEM 492)		1
553	149T6955-9		..BELLCRANK (USED ON ITEM 494)		1
555	149T7801-1		DELETED		
555A	149T7801-5		.FITTING ASSY-GR SPRT (OPT)	ACEG	1
-555B	149T7801-9		.FITTING ASSY-GR SPRT (OPT)	ACEG	1
-555C	149T7801-15		.FITTING ASSY-GR SPRT	ACEGI KM	1
-557	149T7801-5		DELETED		
-557A	149T7801-9		DELETED		
-560	149T7801-2		DELETED		
-560A	149T7801-6		.FITTING ASSY-GR SPRT (OPT)	BDFH	1
-560B	149T7801-10		.FITTING ASSY-GR SPRT (OPT)	BDFH	1
-560C	149T7801-16		.FITTING ASSY-GR SPRT	BDFHJ LN	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-563	149T7801-6		DELETED		
-563A	149T7801-10		DELETED		
			ATTACHING PARTS		
565	BACB30NJ10K46		.BOLT (SUPSD BY ITEM 565A)		1
565A	BACB30UU10K46		.BOLT (SUPSDS ITEM 565)		1
570	BACB30NJ9K36		.BOLT (SUPSD BY ITEM 570A)		1
570A	BACB30UU9K36		.BOLT (SUPSDS ITEM 570)		1
575	BACN10JC10		.NUT		1
580	BACN10JC9		.NUT		1
585	BACW10BN10SC		.WASHER		1
585A	BACW10BN105C		DELETED		
590	BACW10BN10SP		.WASHER		1
595	149T6902-20		.WASHER		1
600	BACW10BN9SC		.WASHER		1
605	BACW10BN9SP		.WASHER		1
610	BACB28AK10-134		.BUSHING		1
615	BACB28AK10-060		.BUSHING		1
620	BACB28AK09-153		.BUSHING -----*-----		1
625	149T6979-1		DELETED		
625A	149T6979-3		..PAD-WEAR (USED ON ITEMS 555A, 555B,555C)		1
-625B	149T6979-4		..PAD-WEAR (USED ON ITEMS 560A, 560B,560C)		1
			ATTACHING PARTS		
630	BACB30NW6K9		..BOLT	*[2]	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-631	BACB30NW6K		..BOLT (SIZE DETERMINE ON INST)	*[1]	2
632	BACB30NW6K17		..BOLT	*[2]	4
633	BACB30NW8K9		..BOLT	*[2]	1
634	BACB30NW8K		..BOLT (SIZE DETERMINE ON INST)	*[1]	4
635	BACC30M6		..COLLAR	*[2]	6
R 636	BACC30M6		..COLLAR	*[1]	
637	BACC30M8		..COLLAR	*[2]	
638	BACC30M8		..COLLAR	*[1]	
			-----*		
640	BACB28AM13B028A		..BUSHING		2
645	BACB28AM17B030A		..BUSHING		1
650	BACB28X12C030		..BUSHING		1
655	BACB28AM14B051A		..BUSHING		2
660	1728B		..FITTING-LUBE (V95879)		2
665	149T7801-3		DELETED		
665A	149T7801-7		..FITTING (USED ON ITEM 555A)		1
-667	149T7801-11		..FITTING (USED ON ITEM 555B)		1
668	149T7801-13		..FITTING (USED ON ITEM 555C)		1
670	149T7801-4		DELETED		
-670A	149T7801-8		..FITTING (USED ON ITEM 560A)		1
-672	149T7801-12		..FITTING (USED ON ITEM 560B)		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01- -673	149T7801-16		..FITTING (USED ON ITEM 560C)		1
675	BACB30NJ12K36		.BOLT (SUPSD BY ITEM 675A)		1
675A	BACB30UU12K36		.BOLT (SUPSDS ITEM 675)		1
680	BACN10JC12		.NUT		1
685	BACW10BN12SP		.WASHER		1
690	BACW10BN12SC		.WASHER		1
695	BACB28AK12-066		.BUSHING		1
700	149T6935-1		.LINK ASSY ATTACHING PARTS		1
705	BACB30NJ12K34		.BOLT (SUPSD BY ITEM 705A)		1
705A	BACB30UU12K34		.BOLT (SUPSDS ITEM 705)		1
710	BACN10JC12		.NUT		1
715	BACW10BN12SP		.WASHER		1
720	BACW10BN12SC		.WASHER		1
725	BACB28AK12-066		.BUSHING -----*-----		1
730	S012T234-1		DELETED		
730A	MK1216-26-2G		..ROD END ASSY (V73134) (SPEC S012T234-1)		2
735	149T6980-1		..TUBE		1
740	NAS509-17C		..NUT		2
745	NAS513-16		..WASHER		2
748	MS24665-377		.PIN-COTTER		1
750	149T6985-2		.BOLT (PRE SB 32-7 OR SB 32-24)	A-H	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01- -750A	149T6985-6		.BOLT (POST SB 32-7 (POST SB 32-7 OR SB 32-24)	I-N	1
751	149T6902-47		.WASHER		1
752	149T6902-48		.WASHER		1
753	BACN10JD116		.NUT		1
755	149T6956-1		.PUSHROD ASSY (OPT)	A-H	1
-755A	149T6956-3		.PUSHROD ASSY		1
760	NAS509-24		..NUT		1
765	NAS509-24		..NUT (USED ON ITEM 755)		1
-765A	NAS509L24		..NUT (USED ON ITEM 755A)		1
770	ARH18E102		..ROD END (V50294) (SPEC S012T234-318) (OPT ARH18E102 (VS0352)) (OPT ARBL18-5 (V15860))		1
775	ARH18E102		..ROD END (V50294) (SPEC S012T234-318) (OPT ARH18E102 (VS0352)) (OPT ARBL18-5 (V15860)) (USED ON ITEM 755)		1
-775A	S012T234-318-8		..ROD END (USED ON ITEM 755A)		1
780	149T6956-2		..PUSHROD (USED ON ITEM 755)		1
-780A	149T6956-4		..PUSHROD (USED ON ITEM 755A)		1

\*[1] USED ON 149T7801-15, -16

\*[2] USED ON 149T7801-5, -6, -9, -10

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