TO: ALL HOLDERS OF MAIN LANDING GEAR HINGE BELLCRANK ASSEMBLY COMPONENT MAINTENANCE MANUAL 32-12-10

REVISION NO. 2 DATED NOV 01/00

HIGHLIGHTS

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

CHAPTER/SECTION AND PAGE NO.	DESCRIPTION OF CHANGE
TITLE PAGE 1	Added bellcrank assemblies 149T6080-9, -10 with changed gear support link for a better fit per PRR B13229.
TR & SB RECORD 1	Deleted assemblies 149T6080-3, -4.
DESCRIPTION & OPERATION 2 REPAIR 3-1 604-605 REPAIR 3-2 603-604 706-710 1002-1010,1013, 1021-1029	
DESCRIPTION & OPERATION 1 401 501 REPAIR-GEN 601 REPAIR 1-1 601-603 REPAIR 2-1 601-602 REPAIR 2-2 601-602	Added clarifications and updated callouts.

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BOEING

COMPONENT
MAINTENANCE MANUAL

MAIN LANDING GEAR DOOR HINGE BELLCRANK ASSEMBLY

PART NUMBERS 149T6080-9,-10

COMPONENT MAINTENANCE MANUAL
WITH
ILLUSTRATED PARTS LIST

K14978

REVISION RECORD

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

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

TEMPORARY REVISION AND SERVICE BULLETIN RECORD

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVE	DATE OF INCORPORATION INTO MANUAL
		PRR B13115-1 PRR B13229	NOV 01/99 NOV 01/00

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*1	NOV 01/00	01
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*301	NOV 01/00	01.101
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*401	NOV 01/00	01.1
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* = REVISED, ADDED OR DELETED

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REPAIR 6-2		
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REPAIR 7-2		
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* = REVISED, ADDED OR DELETED

PAGE	DATE	CODE
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*1004	NOV 01/00	01.1
*1005	NOV 01/00	01.1
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*[1] Not Applicable.

INTRODUCTION

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

This manual is divided into separate sections:

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

Refer to the Table of Contents for the page location of applicable sections.

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:

DESCRIPTION AND OPERATION

1. Description

A. The hinge bellcrank assembly includes forward and aft center hinge assemblies, the bellcrank assembly, the push rod assembly, the link assembly, the arm assembly, the clevis assembly, and other support brackets and tie.

2. Operation

A. The hinge bellcrank assembly is attached to the main landing gear actuator and the main landing gear door assembly. It holds up the main landing gear door during take off and landing. When the main landing gear is in the down position the actuator pushes the hinge bellcrank assembly and the door to the open position. When the main landing gear is in the up position the actuator pulls the hinge bellcrank assembly and the door to the closed position.

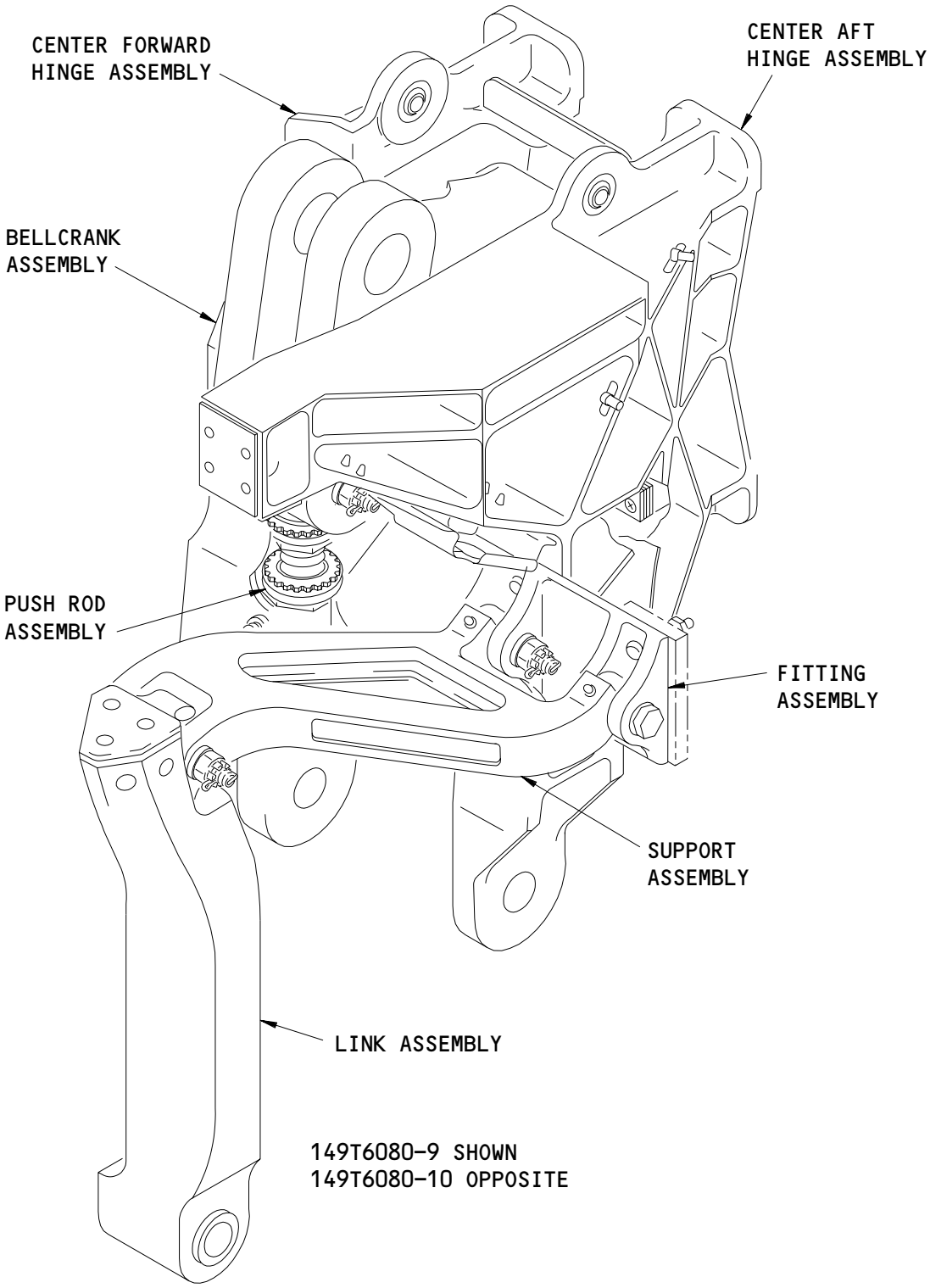
3. Leading Particulars (Approximate)

A. Length -- 30 inches

B. Width -- 33 inches

C. Height -- 33 inches

D. Weight -- 15 pounds



Hinge Bellcrank Assembly
Figure 1

K15175

DISASSEMBLY

1. General

   A. This procedure has the necessary data necessary to disassemble the main landing gear hinge bellcrank assembly.

   B. Disassemble this component sufficiently to isolate the defects, do the necessary repairs, and put the component back to a serviceable condition.

   C. Refer to IPL Fig. 1 for item numbers.

2. Disassembly

   A. Procedure

      (1) Use standard industry procedures and the steps shown below to disassemble this component.

      (2) Remove the cotter pin (10), the bolt (15), the washers (20, 25), the nut (30), and the link assembly (35) from the gear support assembly (130).

      (3) Remove the cotter pin (105), the bolt (110), the washers (115, 120), the nuts (125), and the gear support assembly (130) from the fitting assembly (190).

      (4) Remove the bolts (170), the collars (175), the shims (180A, 185A), and the fitting assembly (190) from the center aft hinge assembly (580).

      (5) Remove the cotter pin (210), the bolt (215), the washers (220, 225, 235), the nut (230), and the push rod assembly (240) from the bellcrank assembly (335).

      (6) If necessary, disassemble the push rod assembly (240) as follows:

         (a) Remove the female rod end assembly (255), the lock nut (245), and lock washer (250) from the sleeve (305).

(b) Remove the male rod end assembly (285), the lock nut (275), and the lock washer (280) from the sleeve (305).

(7) Refer to CMM 32-32-44 for the repair instructions of the main landing gear actuator.

(8) Remove the cotter pin (310), the bolt (315), the washers (320, 325), the nut (330), and the bellcrank assembly (335) from the center forward hinge assembly (550) and the center aft hinge assembly (580).

(9) Remove the bolts (375), the collars (380), the shims (385), and the stabilize tie (390) from the center forward hinge assembly (550) and the center aft hinge assembly (580).

(10) Remove the bolts (395), the collars (400), the shims (405), and the stop assembly (410) from the center forward hinge assembly (550) and the center aft hinge assembly (580).

(11) If necessary, disassemble the stop assembly (410) as follows:

(a) Remove the bolts (415), the washers (420), and the nuts (425) from the pad (430) and the stop (442).

(b) Remove the pad (430), the shim (435), and the filler (440) from the stop (442).

(12) Remove the bolts (445), the washers (450, 460), the bushings (455), the nuts (465), and the cross link assembly (470) from the center forward hinge assembly (550) and the center aft hinge assembly (580).

(13) Remove the bushings (307, 312, 545) from the center forward hinge assembly (550) and the center aft hinge assembly (580).

(14) Remove the bolts (490, 495), the collars (500), and the bracket assembly (505) from the center forward hinge assembly (550) and the center aft hinge assembly (580).

(15) If necessary, remove the bolts (590, 605), the collars (595, 610) and the pads (600, 615 or 620) from the aft center hinge fitting (625 or 630).

CLEANING

1. General

   A. This procedure has the necessary data to clean the hinge bellcrank assembly.

   B. Refer to the Standard Overhaul Practices Manual (SOPM) for details of the SOPM subjects identified in the procedure.

   C. Refer to IPL Fig. 1 for item numbers.

2. Cleaning

   A. References

      (1) SOPM 20-30-01, Cleaning and Relubrication of Anti-Friction Bearings

      (2) SOPM 20-30-03, General Cleaning Procedures

   B. Procedure

      (1) Clean the bearings (560, 565, 622, 623) as specified in SOPM 20-30-01.

      (2) Clean all other parts by standard industry procedures and the instructions in SOPM 20-30-03.

CHECK

1. General

   A. This procedure has the necessary data to find defects in the material of the specified parts.

   B. Refer to FITS AND CLEARANCES for the design dimension and wear limits.

   C. Refer to the Standard Overhaul Practices Manual (SOPM) for details of the SOPM subjects identified in the procedure.

   D. Refer to IPL Fig. 1 for item numbers.

2. Check

   A. References

      (1) SOPM 20-20-01, Magnetic Particle Inspection

      (2) SOPM 20-20-02, Penetrant Methods of Inspection

   B. Procedure

      (1) Use standard industry procedures to do visual check of all the parts for defects. Do the penetrant or magnetic particle check if the visual check shows possible defects or if you think there are defects on the parts.

      (2) Do a magnetic particle check (SOPM 20-20-01) of these parts:

         (a) Lock Nut (245)

         (b) Lock Washer (250)

         (c) Rod End (270, 300)

         (d) Sleeve (305)

      (3) Do a penetrant check (SOPM 20-20-02) of these parts:

         (a) Fittings (95, 100, 160, 165, 205, 485, 570, 575, 625, 630)

         (b) Bellcrank (370)

         (c) Pad (600)

REPAIR - GENERAL

1. General

A. Instructions for repair, refinish, and replacement of the specified subassembly parts are included in each REPAIR when applicable:

PART NUMBER	NAME	REPAIR
---	REFINISH OF OTHER PARTS	1-1
149T6931	HINGE ASSEMBLY	2-1 thru 2-4
149T6935	LINK ASSEMBLY	3-1, 3-2
149T6955	BELLCRANK ASSEMBLY	4-1, 4-2
149T6956	ROD END ASSEMBLY	5-1 thru 5-4
149T6963	FITTING ASSEMBLY	6-1, 6-2
149T6988	FITTING ASSEMBLY	7-1, 7-2
149T7801	SUPPORT ASSEMBLY	8-1, 8-2

2. Dimensioning Symbols

A. Standard True Position Dimensioning Symbols used in the applicable repair procedures are shown in SOPM 20-00-00.

REFINISH OF OTHER PARTS - REPAIR 1-1

1. General

   A. This procedure has the data necessary to refinish the parts which are not given in the specified repairs.

   B. Refer to the Standard Overhaul Practices Manual (SOPM) for details of the SOPM subjects identified in this procedure.

   C. Refer to IPL Fig. 1 for item numbers.

2. Refinish of Other Parts

   A. General

      (1) Instructions for the repair of the parts listed in Table 601 are for repair of the initial finish.

   B. Consumable Materials

      NOTE: Equivalent material can be used.

      (1) C00064 Coating -- MIL-C-5541, Colored film (SOPM 20-43-03)

      (2) C00259 Primer -- BMS 10-11, Type 1 (SOPM 20-60-02)

      (3) C00308 Compound -- MIL-C-11796, Class 1 (SOPM 20-41-03)

      (4) D00113 Lubricant -- BMS 3-8, Type 8, Dry film (SOPM 20-50-08)

   C. References

      (1) SOPM 20-30-02, Stripping of Protective Finishes

      (2) SOPM 20-30-03, General Cleaning Procedures

      (3) SOPM 20-41-01, Decoding Table for Boeing Finish Codes

      (4) SOPM 20-41-05, Application of Corrosion Inhibiting Compounds

      (5) SOPM 20-42-01, Low Hydrogen Embrittlement Cadmium Plating

      (6) SOPM 20-42-02, Low Hydrogen Embrittlement Cadmium-Titanium Alloy Plating

(7) SOPM 20-42-03, Hard Chrome Plating

(8) SOPM 20-43-03, Chemical Conversion Coatings for Aluminum

(9) SOPM 20-44-01, Application of Special Purpose Coatings and Finishes

(10) SOPM 20-50-07, Lubrication

(11) SOPM 20-50-08, Application of Bonded Solid Film Lubricants

(12) SOPM 20-60-02, Finishing Materials

(13) SOPM 20-60-03, Lubricants

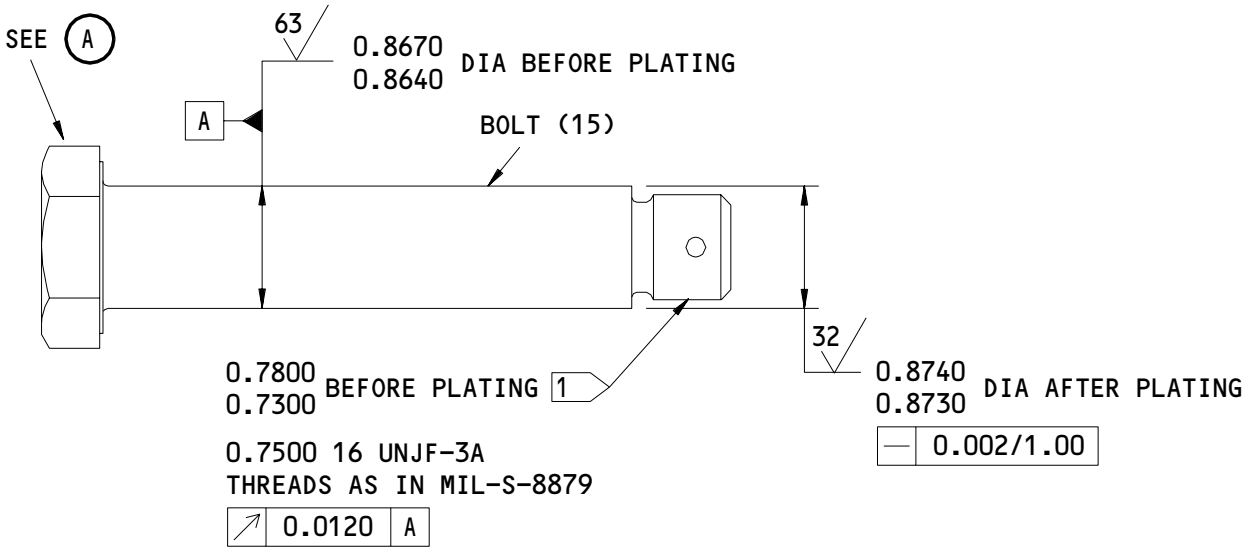
D. Procedure

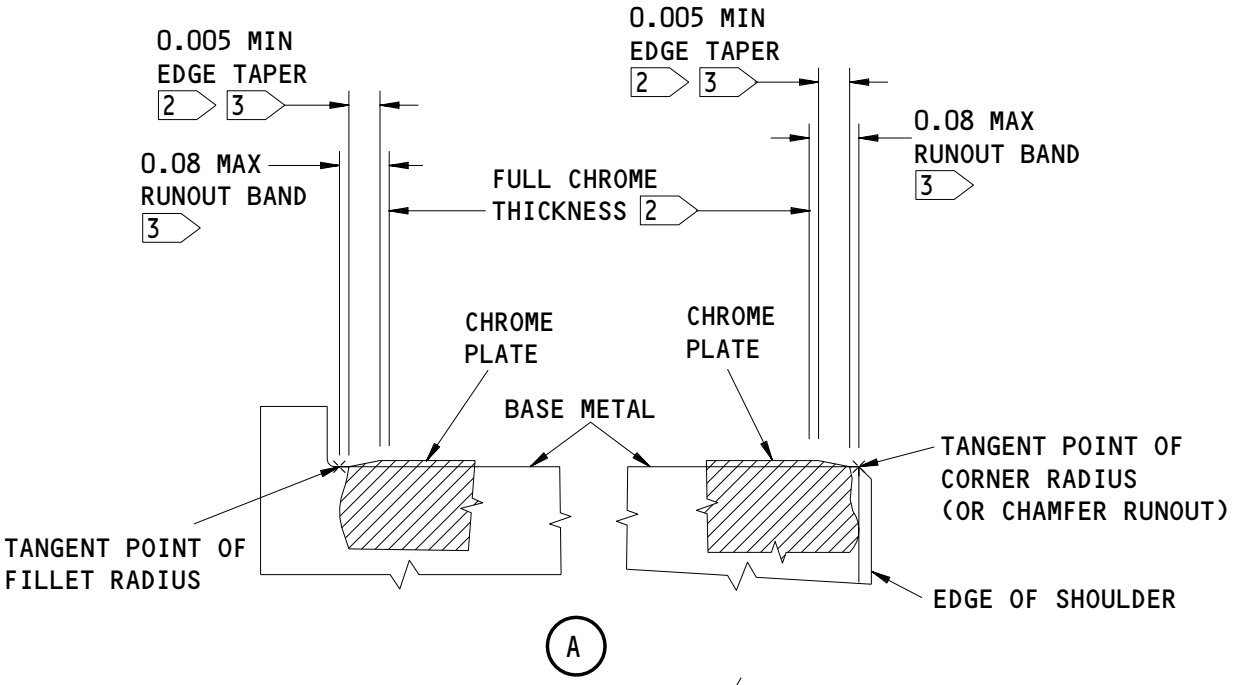
IPL FIG. & ITEM	MATERIAL	FINISH
IPL Fig. 1		
Bolt (15)	15-5PH Cres 180-200 ksi	Passivate (F-17.25). Chrome plate (F-15.34). Wipe the chrome plate with BMS 10-11, Type 1 primer (F-19.45) as shown in Fig. 601.
Pad (60, 65)	Copper Beryllium Alloy	Cadmium plate (F-15.06) and apply BMS 10-11, Type 1 primer (F-20.02). Apply no finish (F-25.01) to rounded surface.
Filler (75)	Aluminum sheet	Boric acid-sulfuric acid anodize (F-17.31). Apply BMS 10-11, Type 1 primer (F-20.03).
Bolt (215, 315)	4340M Bar 275-300 ksi	Chrome plate, cadmium-titanium plate, and apply primer and corrosion preventive compound as shown in Fig. 602.

Refinish Details
Table 601 (Sheet 1)

IPL FIG. & ITEM	MATERIAL	FINISH
IPL Fig. 1 (Cont)		
Lock Nut (245, 275)	15-5PH Cres 180-200 ksi	Passivate (F-17.25). Apply BMS 3-8, Type 8 solid film lubricant (F-19.10) to the threads.
Lock Washer (250, 280)	15-5PH Cres 125-145 ksi	Passivate (F-17.25).
Sleeve (305)	15-5PH Cres 180-200 ksi	Passivate (F-17.25). Apply BMS 3-8, Type 8 solid film lubricant (F-19.10) to the inside and outside threads.
Tie (390)	Aluminum Alloy	Boric acid-sulfuric acid anodize (F-17.31) and BMS 10-11, Type 1 primer (F-20.03).
Filler (440)	Aluminum Alloy	Chemical treat (F-17.07). Apply BMNS 10-11, Type 1 primer (F-20.03).
Pad (600)	15-5PH Cres 150-170 ksi	Cadmium plate (F-15.06) and apply BMS 10-11, Type 1 primer (F-20.02). Apply no finish (F-25.01) to rounded surface.
Pad (615, 620)	Al-Ni-Br Alloy	Cadmium plate (F-15.06) and apply BMS 10-11, Type 1 primer (F-20.02). Apply no finish (F-25.01) to rounded surface.

Refinish Details
Table 601 (Sheet 2)





1 MASK BEFORE SHOT PEEN

2 APPLY 0.003 MINIMUM INCH THICKNESS OF CHROME PLATE (F-15.34) AND BMS 10-11, TYPE 1 PRIMER (F-19.45) ONTO THIS SURFACE

3 CHROME PLATE EDGES MUST HAVE A TAPER FINISH

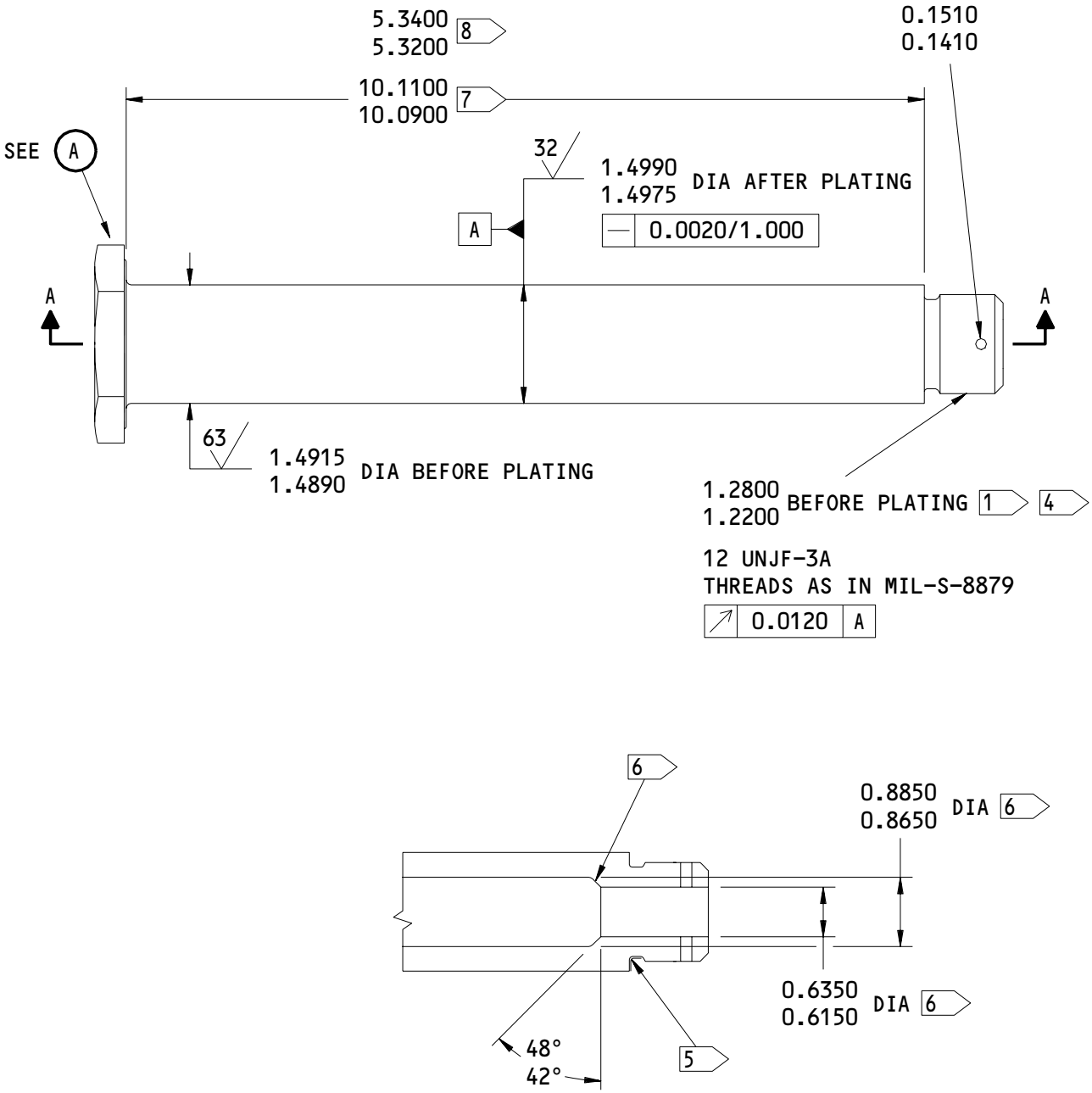
125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

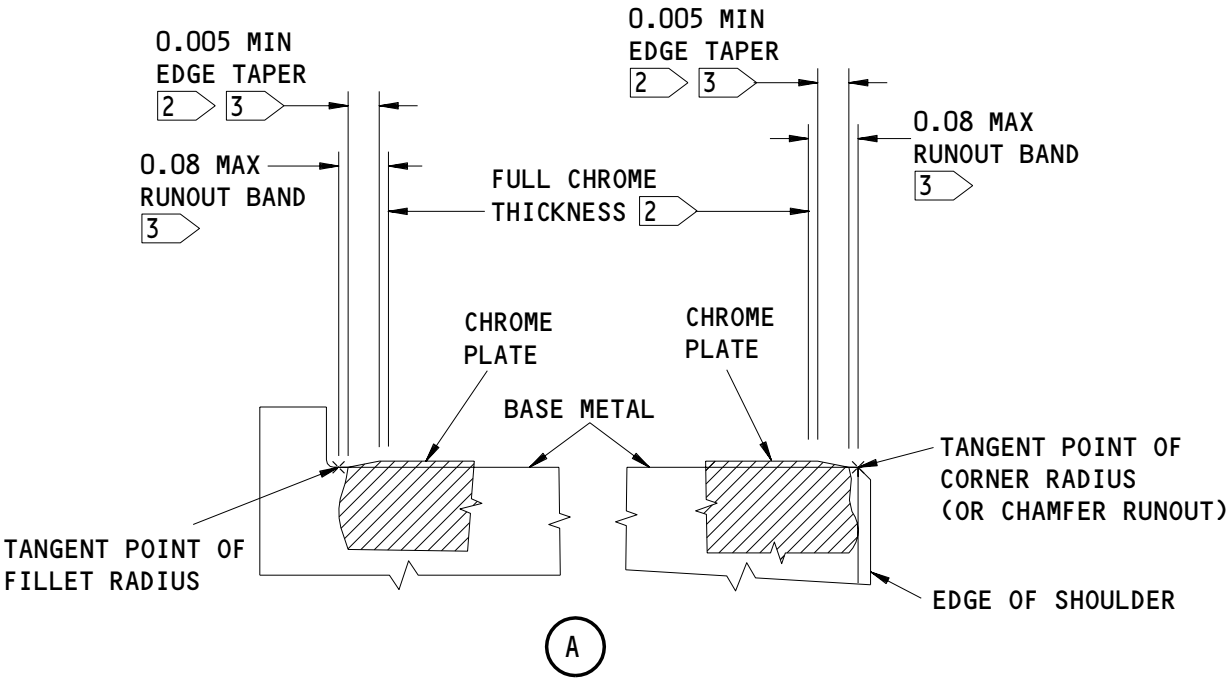
ALL DIMENSIONS ARE IN INCHES

149T6985-14
Bolt Refinish
Figure 601



A-A

149T6985-10,-11
Bolt Refinish
Figure 602 (Sheet 1)



1. MASK BEFORE SHOT PEEN
2. APPLY 0.003 MINIMUM INCH THICKNESS OF CHROME PLATE (F-15.34) AND BMS 10-11, TYPE 1 PRIMER (F-19.45) ONTO THIS SURFACE
3. CHROME PLATE EDGES MUST HAVE A TAPER FINISH
4. APPLY 0.0005-0.0007 INCH THICK OF CADMIUM-TITANIUM PLATE (F-15.32) AND CHROMATE POST PLATE TREATMENT. APPLY WIPE ON BMS 10-11, TYPE 1 PRIMER (F-19.45) ON THIS SURFACE
5. APPLY CADMIUM-TITANIUM PLATE, BAKE FOR 12 HOURS MINIMUM AT 350°-400°F AND APPLY CHROMATE POST-PLATE TREATMENT (F-15.01). PLUS APPLY A LAYER OF BMS 10-11, TYPE 1 PRIMER (F-20.02) AS SHOWN IN SOPM 20-41-02 ON THIS SURFACE
6. APPLY CADMIUM-TITANIUM PLATE, BAKE FOR 12 HOURS MINIMUM AT 350°-400°F AND APPLY CHROMATE POST-PLATE TREATMENT (F-15.01). PLUS APPLY TWO LAYERS OF BMS 10-11, TYPE 1 PRIMER (F-20.03). PLUS CLEAN AND APPLY THE INSIDE DIAMETER OF THE PART WITH MIL-C-11796, CLASS 1 CORROSION PREVENTIVE COMPOUND (F-19.03)
7. 149T6985-10
8. 149T6985-11

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

149T6985-10,-11
Bolt Refinish
Figure 602 (Sheet 2)

HINGE ASSEMBLY - REPAIR 2-1

149T6931-29,-30

1. General

   A. This procedure has the data necessary to repair the forward center hinge assembly (550, 555).

   B. Refer to the Standard Overhaul Practices Manual (SOPM) for details of the SOPM subjects identified in the procedure.

   C. Refer to IPL Fig. 1 for item numbers.

2. Bearing Replacement

   A. Consumable Materials

      NOTE: Equivalent material can be used.

      (1) A00359 Sealant -- BMS 5-95 (SOPM 20-60-04)

   B. References

      (1) SOPM 20-50-03, Bushing and Bearing Replacement

      (2) SOPM 20-60-04, Miscellaneous Materials

   C. Procedure (Fig. 601)

      (1) Remove the bearing(s) (560, 565) from the forward center hinge fitting (570 or 575).

      (2) Install the bearing(s) (560, 565) onto the forward center hinge fitting (570 or 575) with BMS 5-95 sealant and roller swage them (SOPM 20-50-03).

3. Forward Center Fitting Assembly Refinish

A. Consumable Materials

NOTE: Equivalent material can be used.

(1) C00259 Primer -- BMS 10-11, Type 1 (SOPM 20-60-02)

(2) C00260 Enamel -- BMS 10-11, Type 2 (SOPM 20-60-02)

B. References

(1) SOPM 20-30-03, General Cleaning Procedure

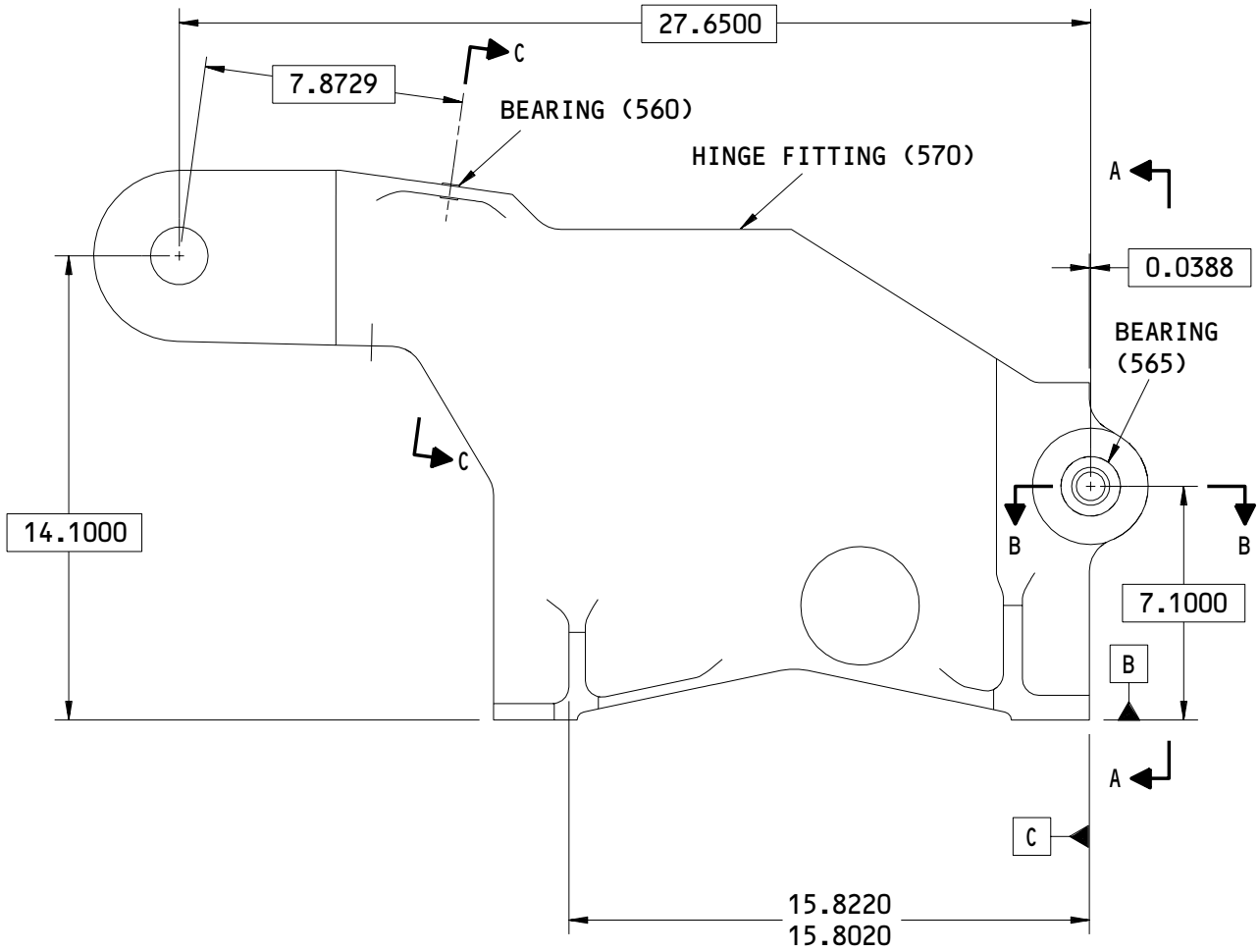
(2) SOPM 20-44-01, Application of Special Purpose Coatings

(3) SOPM 20-60-02, Finishing Materials

C. Procedure

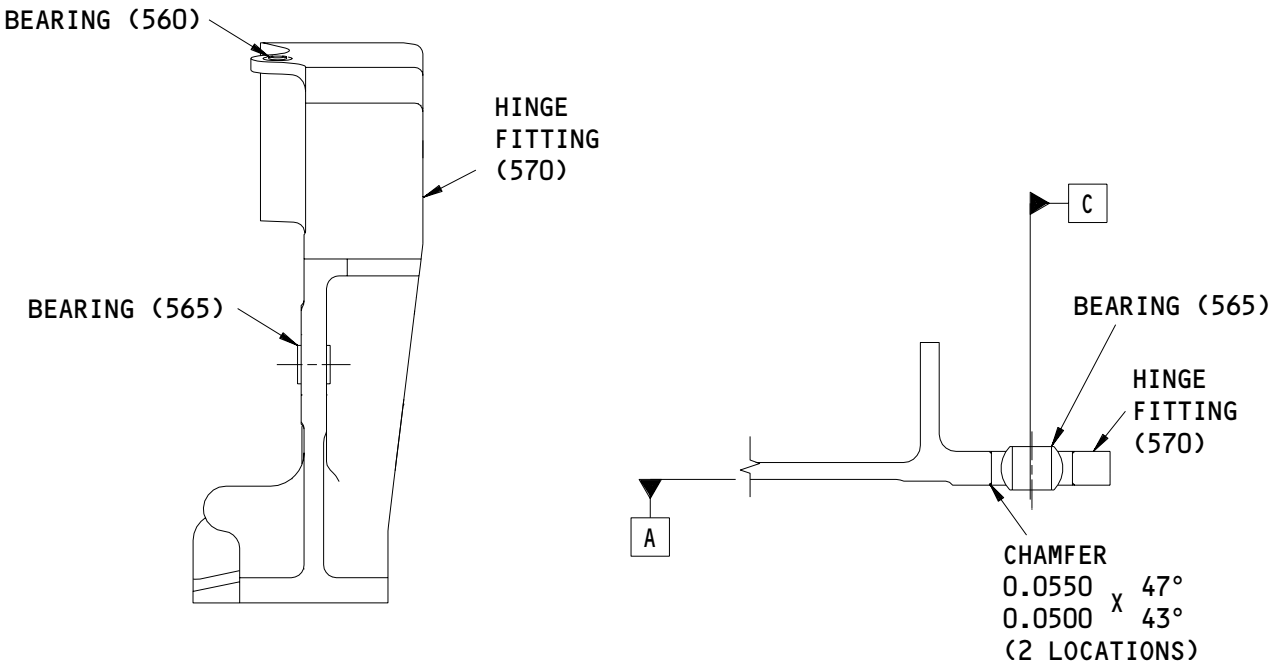
(1) Apply BMS 10-11, type 1 primer (F-21.121) to all surfaces.

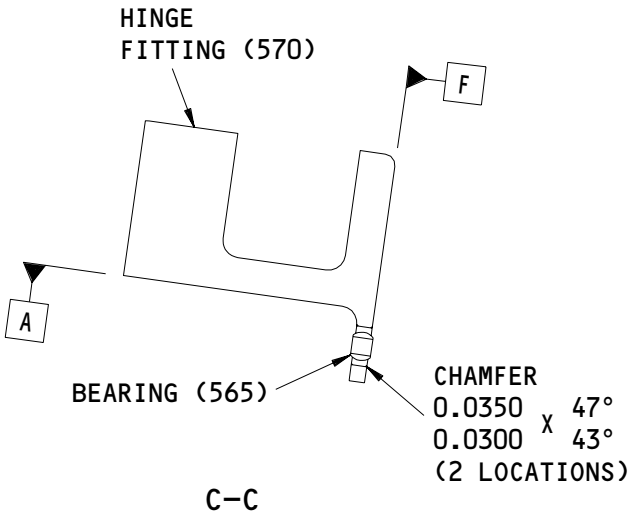
(2) Apply BMS 10-11, type 2 enamel (F-21.17) but not on the bearings, wear pad, or hole surfaces.



149T6931-29 SHOWN
149T6931-30 OPPOSITE

149T6931-29,-30
Forward Center Hinge Assembly Repair
Figure 601 (Sheet 1)





ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

149T6931-29,-30
Forward Center Hinge Assembly Repair
Figure 601 (Sheet 2)

K20621

FITTING - REPAIR 2-2

149T6931-33, -34

1. General

A. This procedure has the data necessary to repair and refinish the forward center hinge fitting (570 or 575).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for details of the SOPM subjects identified in the procedure.

C. Refer to IPL Fig. 1 for item numbers.

D. General repair details:

(1) Materials: Aluminum alloy

(2) Shot Peen: All surfaces
Intensity 0.012A2

2. Forward Center Hinge Fitting Repair

A. Consumable Materials

NOTE: Equivalent material can be used.

(1) C00064 Coating -- MIL-C-5541, Colored Film (SOPM 20-43-03)

(2) C00259 Primer -- BMS 10-11, Type 1 (SOPM 20-60-02)

B. References

(1) SOPM 20-10-03, Shot Peening

(2) SOPM 20-30-02, Stripping of Protective Finishes

(3) SOPM 20-30-03, General Cleaning Procedures

(4) SOPM 20-41-01, Decoding Table for Boeing Finish Codes

(5) SOPM 20-41-02, Application of Chemical and Solvent Resistant Finishes

(6) SOPM 20-43-01, Chromic Acid Anodizing

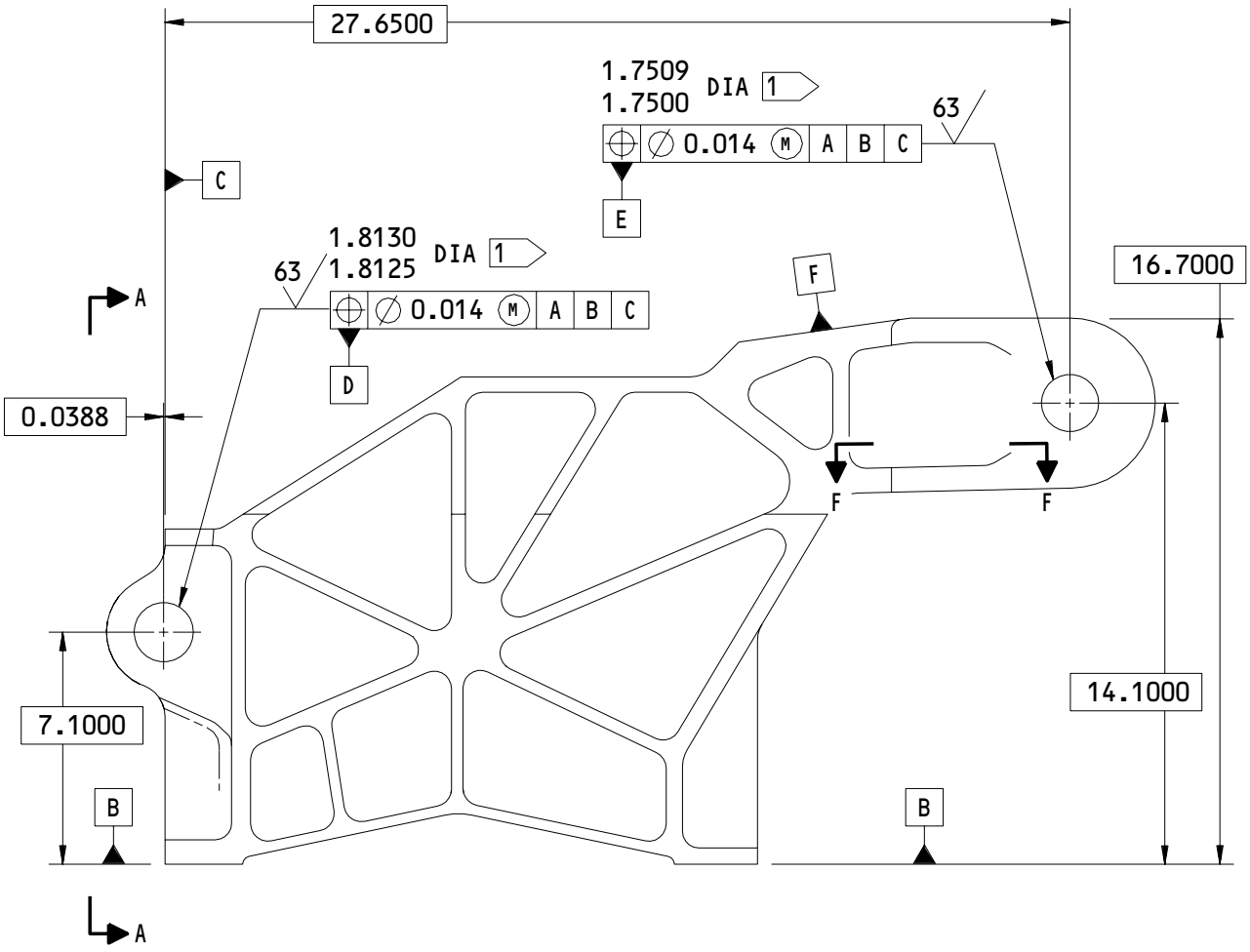
(7) SOPM 20-43-03, Chemical Conversion Coatings for Aluminum

(8) SOPM 20-60-02, Finishing Materials

C. Procedure (Fig. 601)

(1) Boric acid - sulfuric acid anodize (F-17.31) and apply BMS 10-11, type 1 primer (F-20.03) unless shown differently.

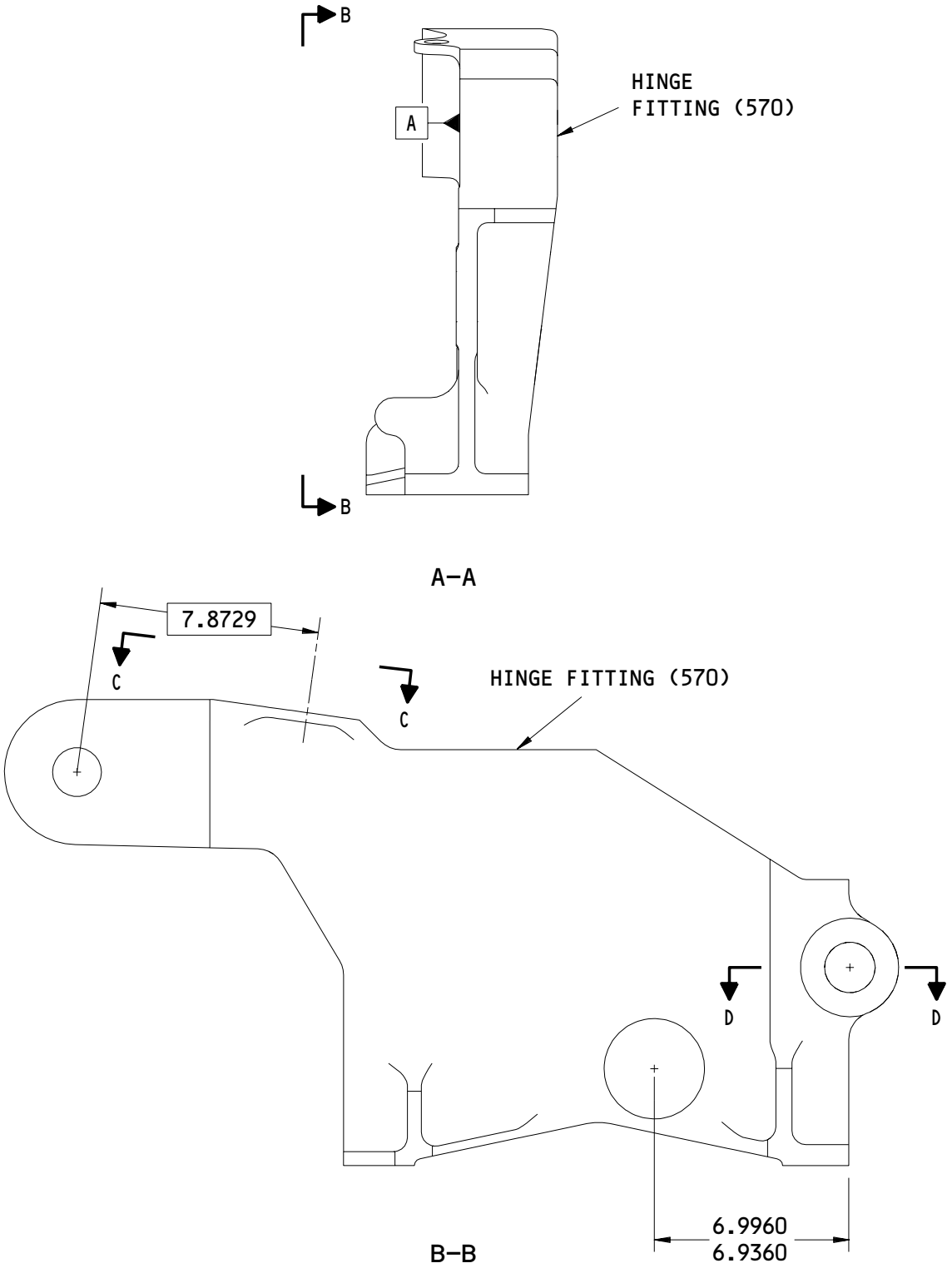
(2) Chemical treat (F-17.10) surface shown.



149T6931-33 SHOWN
149T6931-34 OPPOSITE

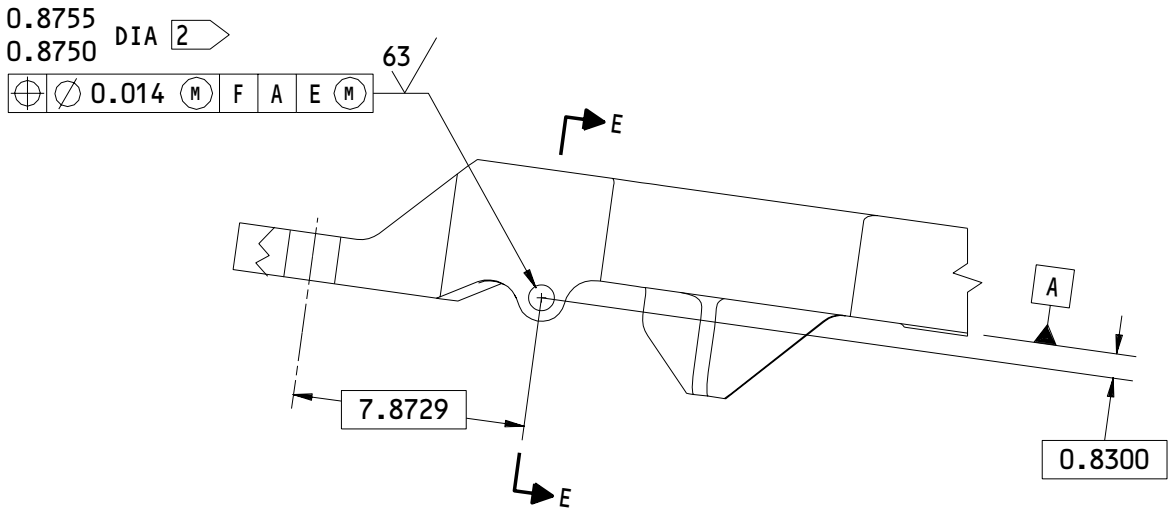
149T6931-33,-34
Hinge Fitting Repair
Figure 601 (Sheet 1)

K20636

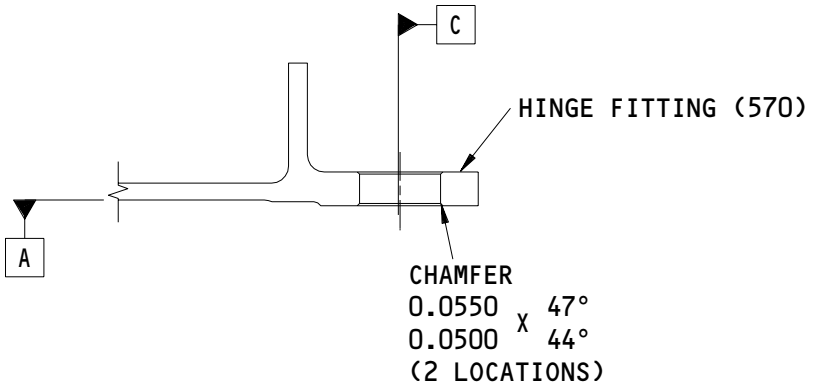


149T6931-33,-34
Hinge Fitting Repair
Figure 601 (Sheet 2)

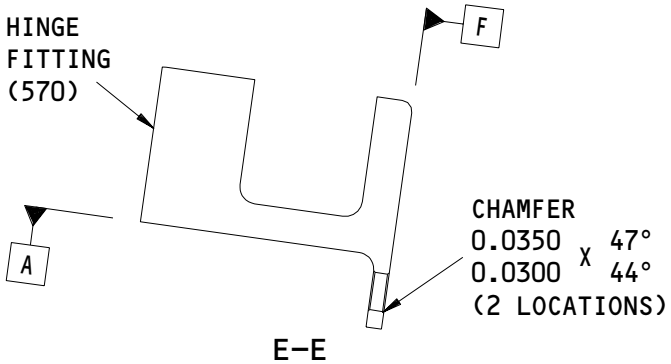
K20645



C–C

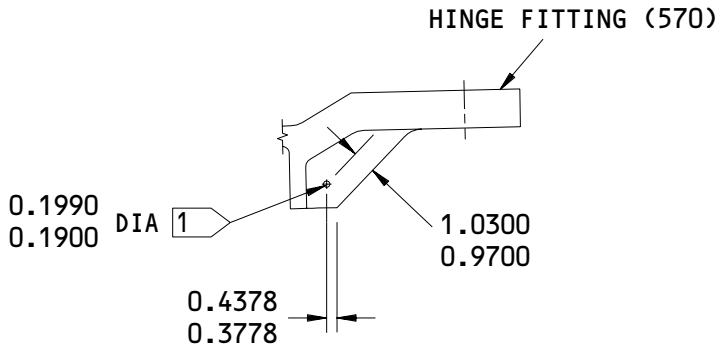


D–D



E–E

149T6931-33,-34
Hinge Fitting Repair
Figure 601 (Sheet 3)



F–F

1 DO NOT PUT PRIMER (F-20.03) IN THIS SURFACE

2 CHEMICAL TREAT (F-17.10) THIS SURFACE WITH MIL-C-5541 COLORED FILM

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

149T6931-33,-34
Hinge Fitting Repair
Figure 601 (Sheet 4)

K20677

HINGE ASSEMBLY - REPAIR 2-3

149T6931-31, -32

1. General

   A. This procedure has the data necessary to repair the aft center hinge assembly (580, 585).

   B. Refer to the Standard Overhaul Practices Manual (SOPM) for details of the SOPM subjects identified in the procedure.

   C. Refer to IPL Fig. 1 for item numbers.

2. Bearing Replacement

   A. Consumable Materials

      NOTE: Equivalent material can be used.

      (1) A00359 Sealant -- BMS 5-95 (SOPM 20-60-04)

   B. References

      (1) SOPM 20-50-03, Bushing and Bearing Replacement

      (2) SOPM 20-60-04, Miscellaneous Materials

   C. Procedure (Fig. 601)

      (1) Remove the bearing(s) (622, 623) from the aft center hinge fitting (625 or 630).

      (2) Install the bearing(s) (622, 623) onto the aft center hinge fitting (625 or 630) with BMS 5-95 sealant and roller swage them (SOPM 20-50-03).

3. Aft Center Fitting Assembly Refinish

A. Consumable Materials

NOTE: Equivalent material can be used.

(1) C00259 Primer -- BMS 10-11, Type 1 (SOPM 20-60-02)

(2) C00260 Enamel -- BMS 10-11, Type 2 (SOPM 20-60-02)

B. References

(1) SOPM 20-30-03, General Cleaning Procedure

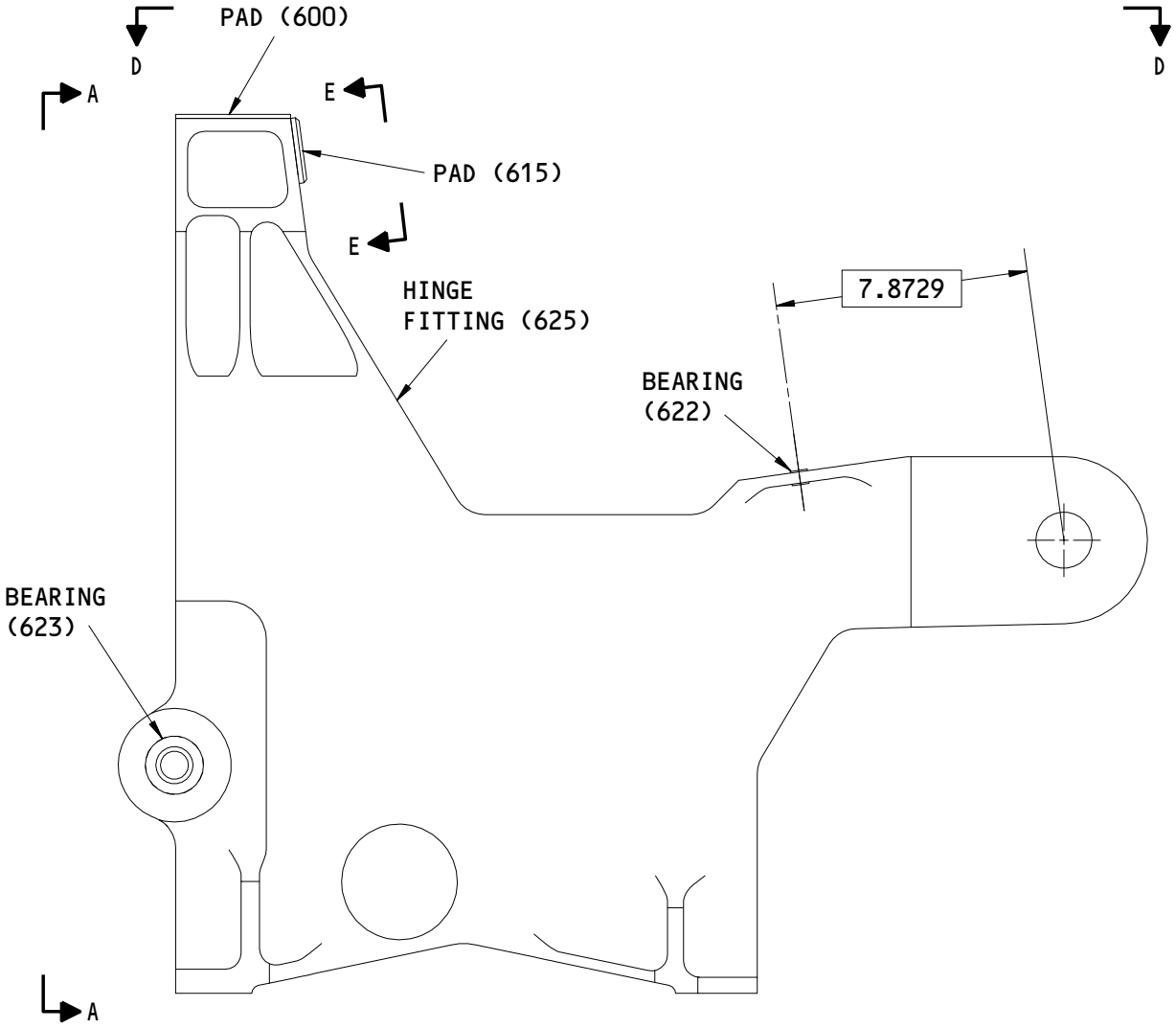
(2) SOPM 20-44-01, Application of Special Purpose Coatings

(3) SOPM 20-60-02, Finishing Materials

C. Procedure

D. Apply BMS 10-11, type 1 primer (F-21.121) to all surfaces.

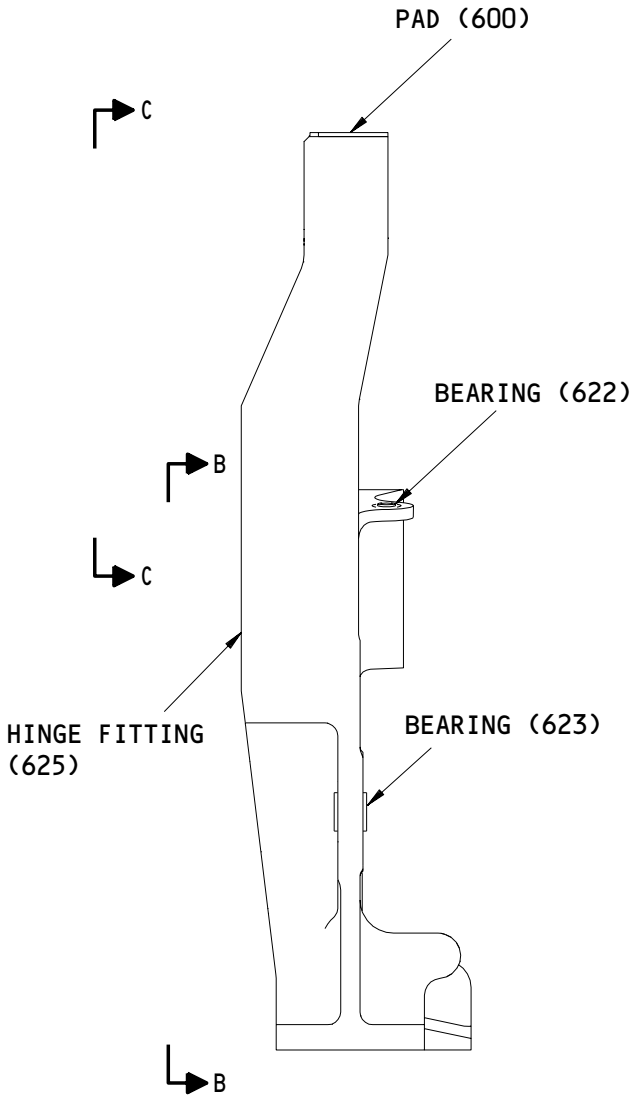
E. Apply BMS 10-11, type 2 enamel (F-21.17) but not on the bearings, wear pad, or hole surfaces.



149T6931-31 SHOWN
149T6931-32 OPPOSITE

149T6931-31,-32
Aft Center Hinge Assembly Repair
Figure 601 (Sheet 1)

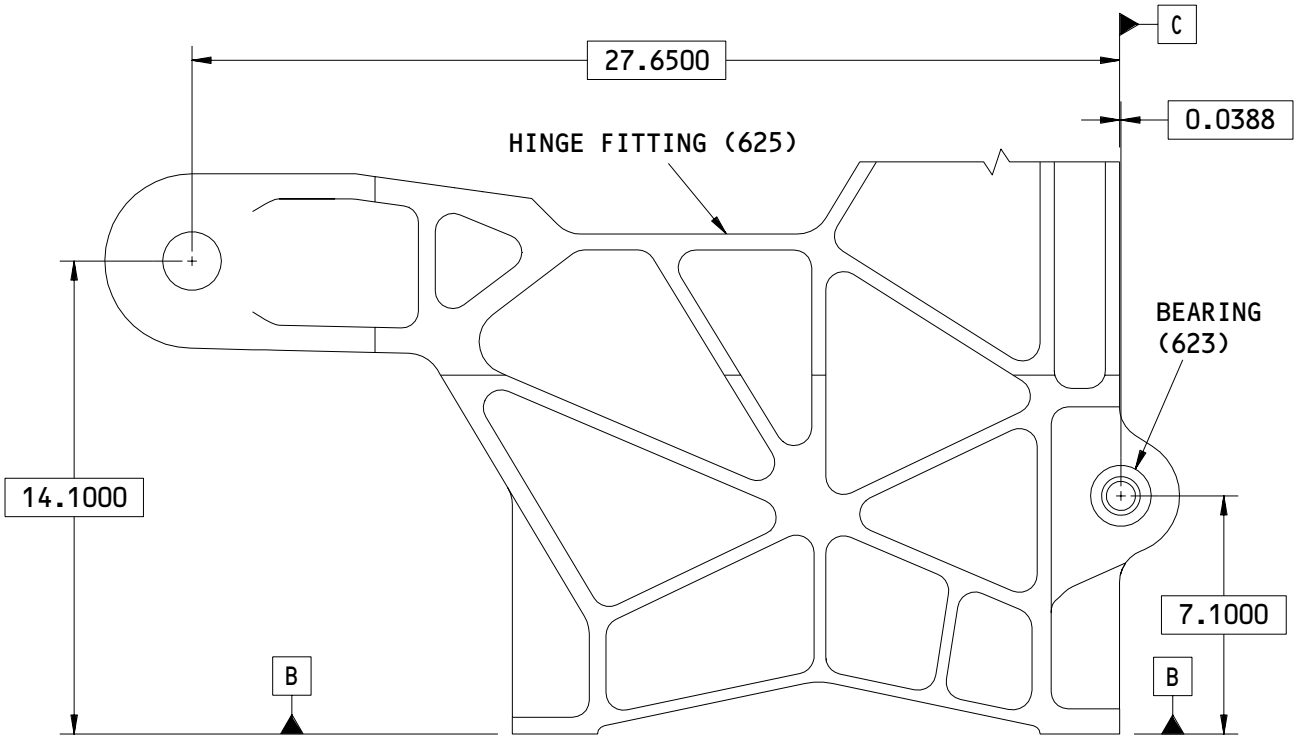
K20926



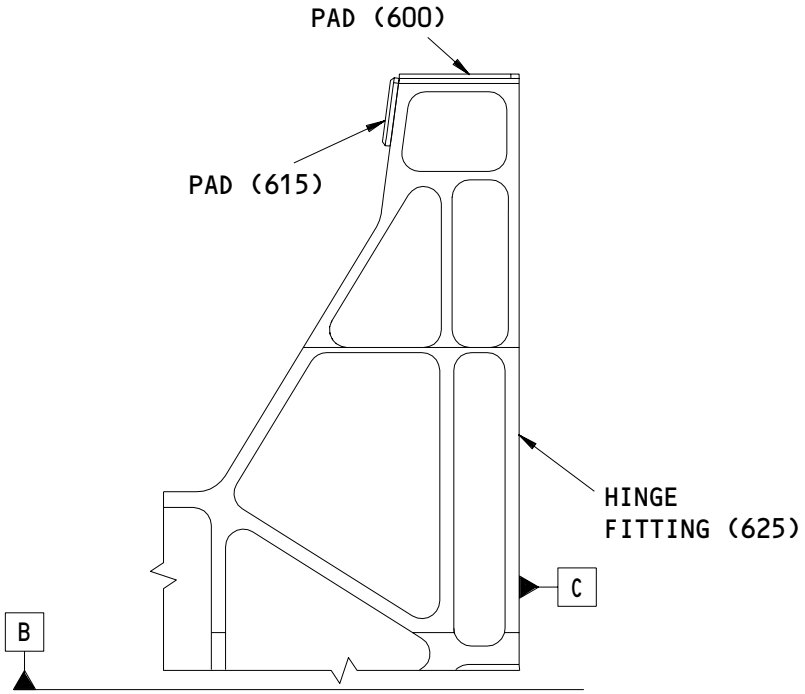
A–A

149T6931-31,-32
Aft Center Hinge Assembly Repair
Figure 601 (Sheet 2)

K20927

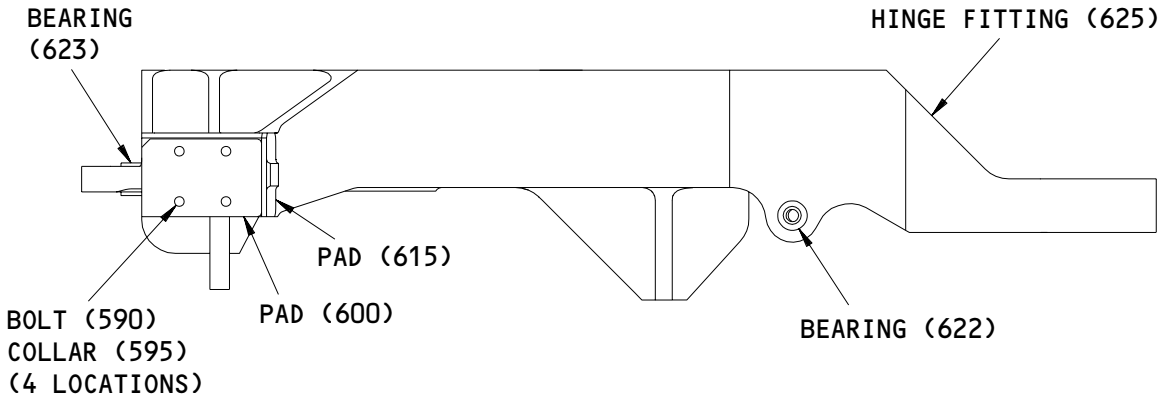


B–B

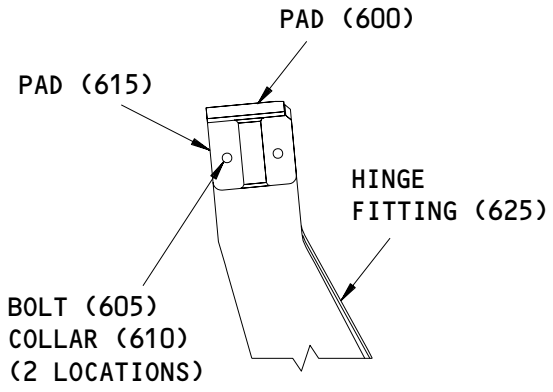


C–C

149T6931-31,-32
Aft Center Hinge Assembly Repair
Figure 601 (Sheet 3)



D–D



E–E

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

149T6931-31,-32
Aft Center Hinge Assembly Repair
Figure 601 (Sheet 4)

K20939

FITTING - REPAIR 2-4

149T6931-35, -36

1. General

A. This procedure has the data necessary to repair and refinish the aft center hinge fitting (625 or 630).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for details of the SOPM subjects identified in the procedure.

C. Refer to IPL Fig. 1 for item numbers.

D. General repair details:

(1) Materials: Aluminum alloy

(2) Shot Peen: All surfaces
Intensity 0.012A2

2. Aft Center Hinge Fitting Repair

A. Consumable Materials

NOTE: Equivalent material can be used.

(1) C00259 Primer -- BMS 10-11, Type 1 (SOPM 20-60-02)

B. References

(1) SOPM 20-10-03, Shot Peening

(2) SOPM 20-30-02, Stripping of Protective Finishes

(3) SOPM 20-30-03, General Cleaning Procedures

(4) SOPM 20-41-01, Decoding Table for Boeing Finish Codes

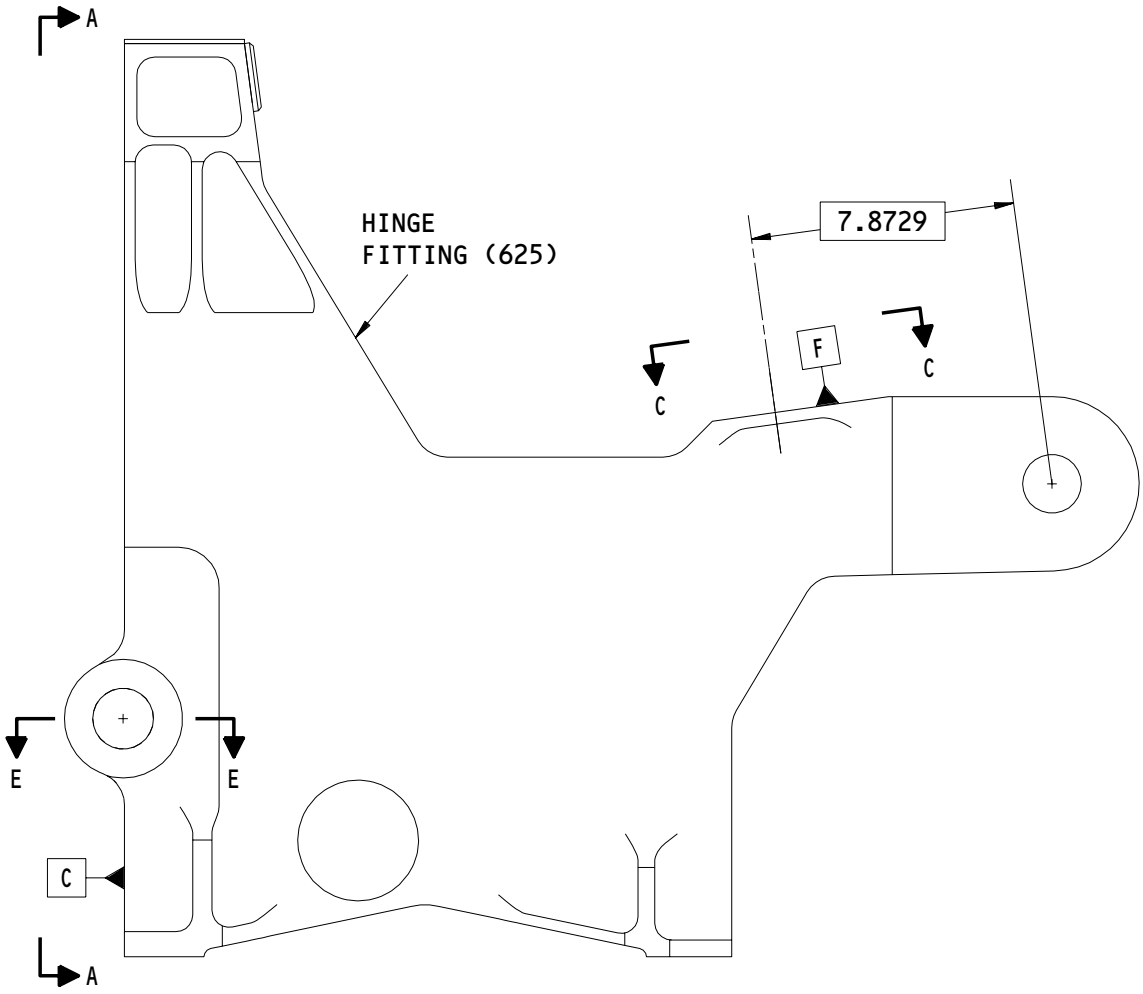
(5) SOPM 20-41-02, Application of Chemical and Solvent Resistant Finishes

(6) SOPM 20-43-01, Chromic Acid Anodizing

(7) SOPM 20-60-02, Finishing Material

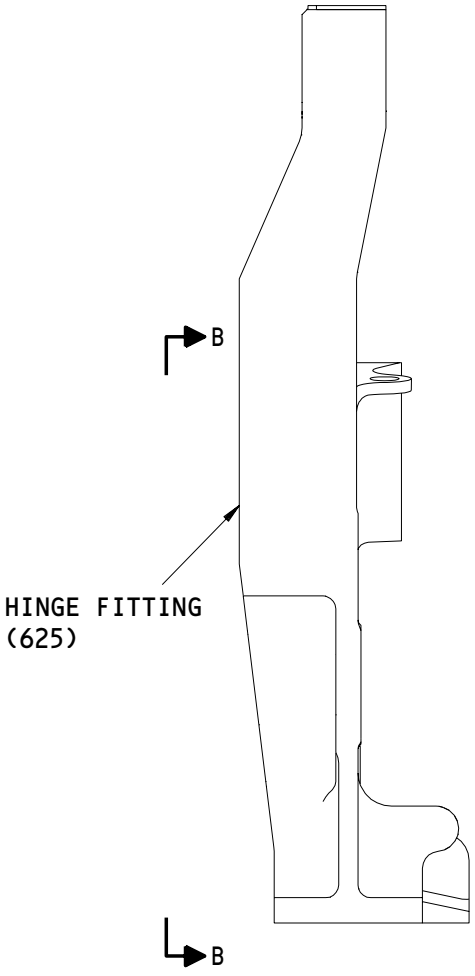
C. Procedure (Fig. 601)

(1) Boric acid - sulfuric acid anodize (F-17.31) and apply BMS 10-11, type 1 primer (F-20.03) unless shown differently.



149T6931-35 SHOWN
149T6931-36 OPPOSITE

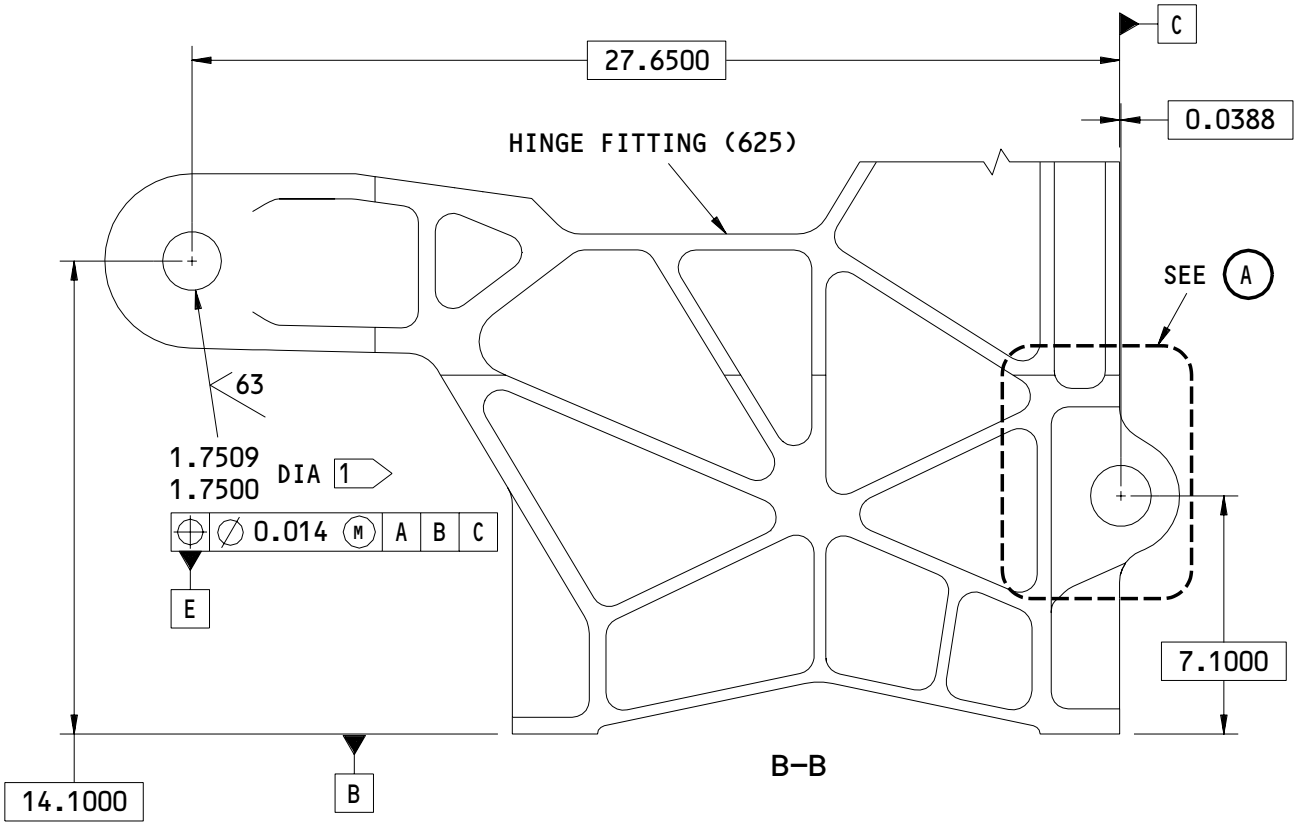
149T6931-35,-36
Aft Center Hinge Fitting Repair
Figure 601 (Sheet 1)

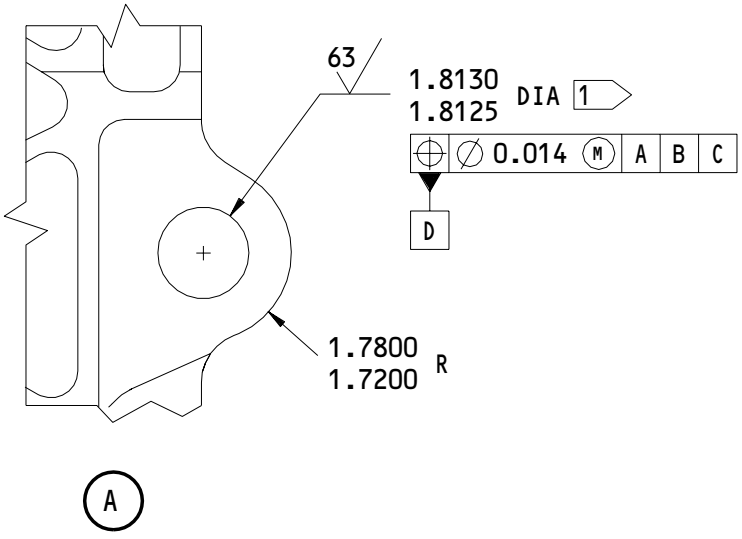


A–A

149T6931-35,-36
Aft Center Hinge Fitting Repair
Figure 601 (Sheet 2)

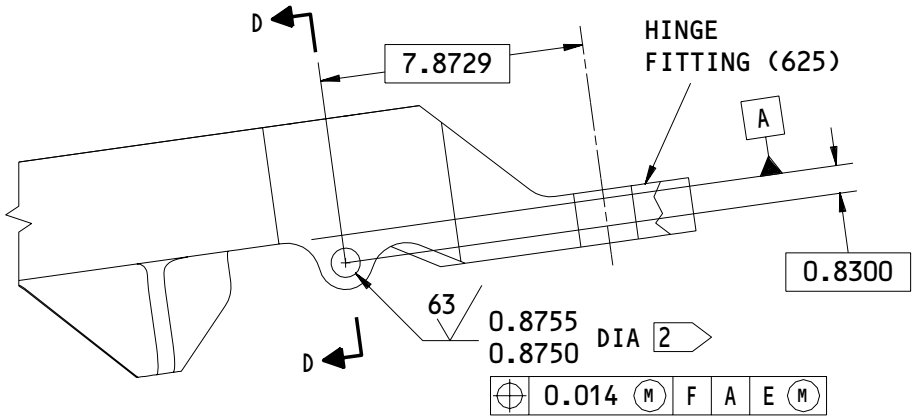
K20943



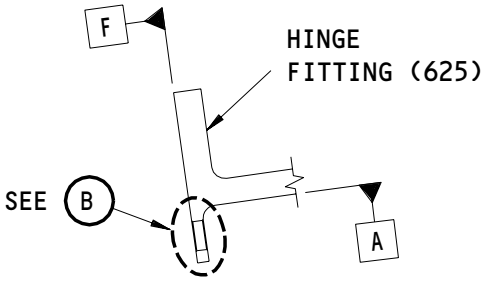


149T6931-35,-36
Aft Center Hinge Fitting Repair
Figure 601 (Sheet 3)

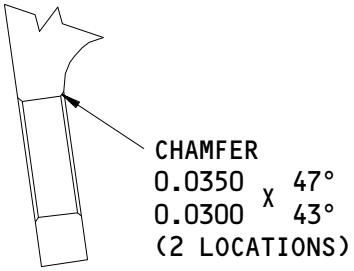
K20961



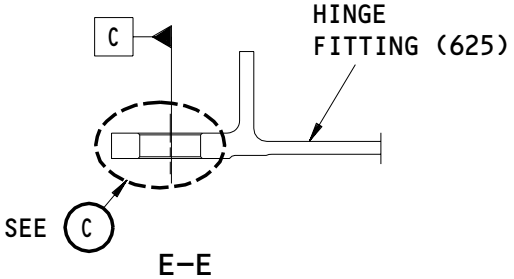
C–C



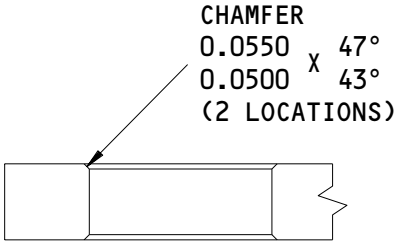
D–D



B



E–E



C

1 DO NOT PUT PRIMER (F-20.03) IN THIS SURFACE

2 CHEMICAL TREAT (F-17.01) THIS SURFACE WITH MIL-C-5541 COLORED FILM

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

149T6931-35,-36
Aft Center Hinge Fitting Repair
Figure 601 (Sheet 4)

K20976

LINK ASSEMBLY - REPAIR 3-1

149T6935-7, -8

1. General

   A. This procedure has the data necessary to repair the link assembly (35, 40).

   B. Refer to the Standard Overhaul Practices Manual (SOPM) for details of the SOPM subjects identified in the procedure.

   C. Refer to IPL Fig. 1 for item numbers.

2. Bushing Replacement

   A. Consumable Materials

      NOTE: Equivalent material can be used.

      (1) D00633 Grease -- BMS 3-33 (SOPM 20-60-03)

      (2) A00359 Sealant -- BMS 5-95 (SOPM 20-60-04)

   B. References

      (1) SOPM 20-50-03, Bushing and Bearing Replacement

      (2) SOPM 20-50-07, Lubrication

      (3) SOPM 20-60-03, Lubricants

      (4) SOPM 20-60-04, Miscellaneous Materials

   C. Procedure (Fig. 601)

      (1) Remove the bushing(s) (80, 85) from the link fitting (95).

(2) If you find defects on the link, refer to REPAIR 3-2 for repair instructions.

(3) Install replacement bushing(s) (80, 85) onto the link fitting (95) with BMS 3-33 grease by the shrink-fit procedure (SOPM 20-50-03).

(4) Machine the bushings to design dimensions and finish if necessary.

(5) Apply BMS 5-95 fillet sealant to the edges of the bushings.

3. Lube Fitting Replacement

A. Consumable Materials

NOTE: Equivalent material can be used.

(1) D00633 Grease -- BMS 3-33 (SOPM 20-60-03)

B. References

(1) SOPM 20-50-01, Bolt and Nut Installation

(2) SOPM 20-50-07, Lubrication

(3) SOPM 20-60-03, Lubricants

C. Procedure (Fig. 601)

(1) Remove the lube fitting (90) from the link fitting (95).

(2) Install a replacement lube fitting (90) onto the link fitting (95) with BMS 3-33 grease. Tighten the lube fitting(s) (190) to 25-30 pound-inches.

(3) Make sure that the lube fitting (90) passage is not blocked. Apply BMS 3-33 grease to the lube fitting (90) until grease appears in the inside diameter if the bushing(s) (80).

4. Link Assembly Refinish

A. Consumable Materials

NOTE: Equivalent material can be used.

(1) C00260 Enamel -- BMS 10-11, Type 2 (SOPM 20-60-02)

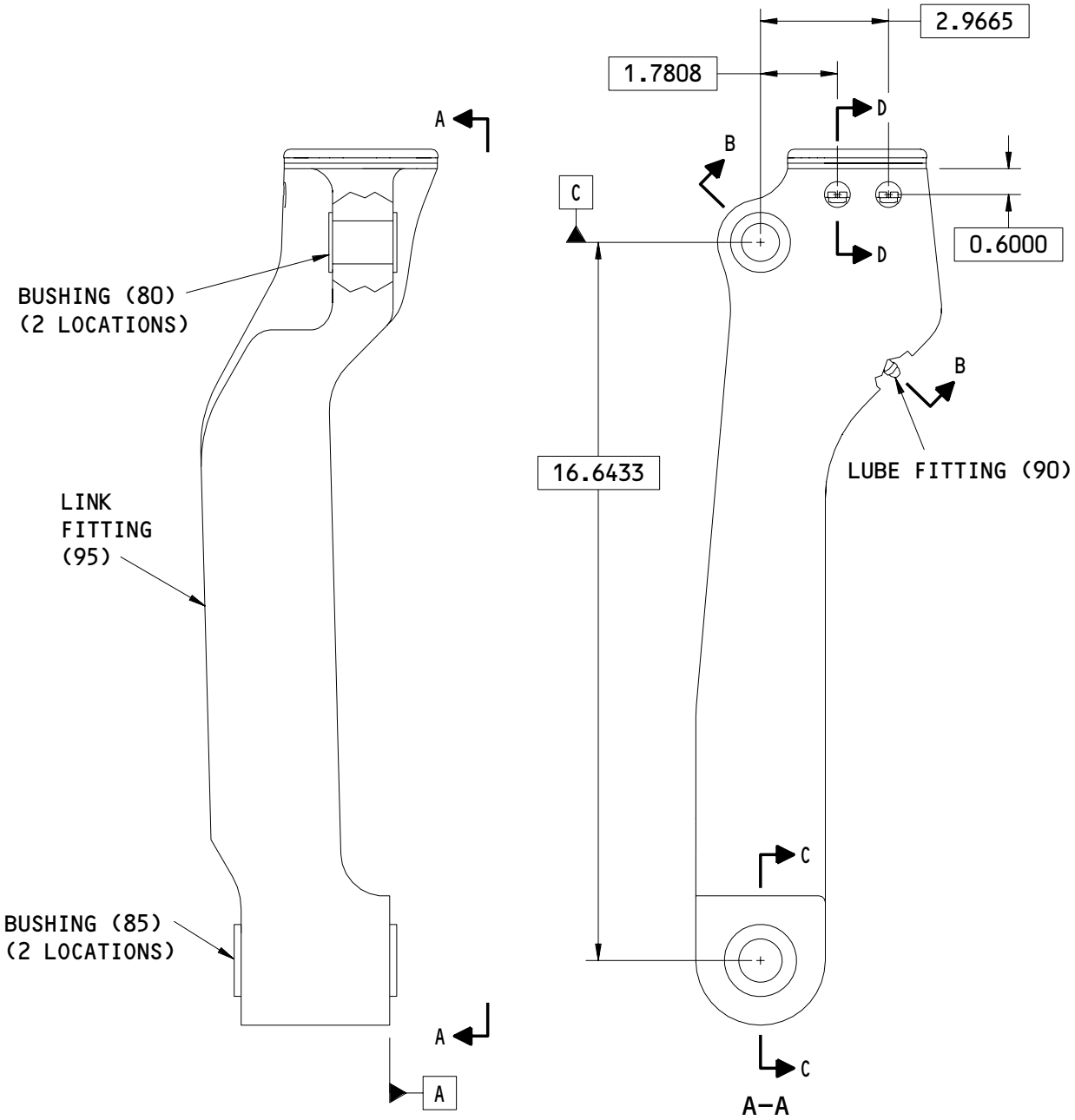
B. References

(1) SOPM 20-30-03, General Cleaning Procedures

(2) SOPM 20-60-02, Finishing Materials

C. Procedure

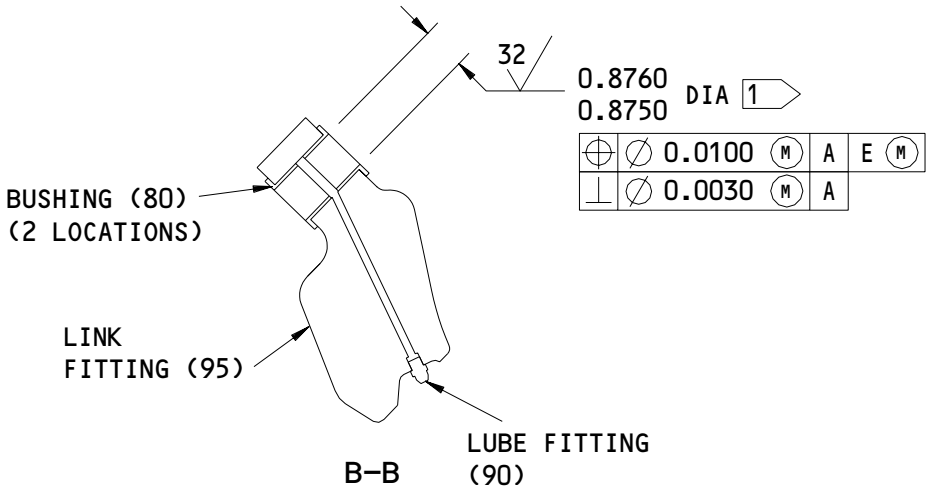
(1) Apply BMS 10-11, type 2 enamel (F-21.17) to all surfaces but not on the bushing flanges, lube fitting, or wear pad.



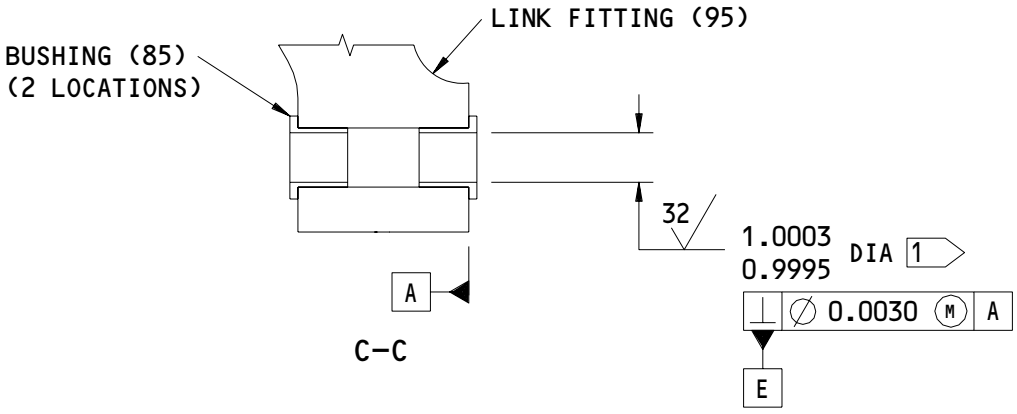
149T6935–7 SHOWN
149T6935–8 OPPOSITE

149T6935–7,–8
Link Assembly Repair
Figure 601 (Sheet 1)

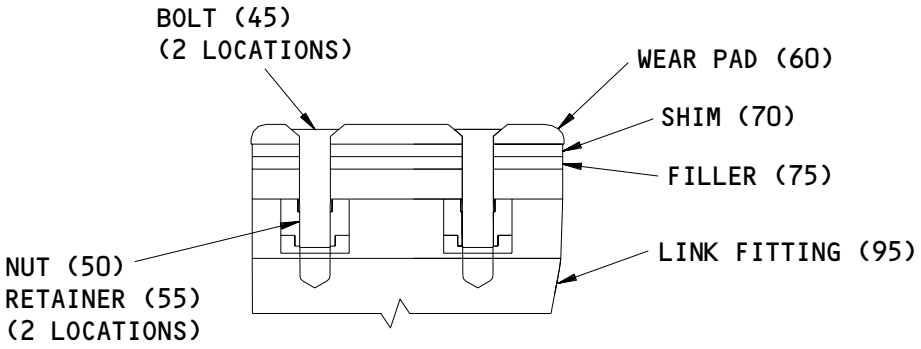
K21276



B–B



C–C



D–D

1 INSTALLED DIMENSION. ADJUST TO THIS SIZE IF NECESSARY

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

149T6935-7,-8
Link Assembly Repair
Figure 601 (Sheet 2)

LINK FITTING - REPAIR 3-2

149T6935-9, -10

1. General

   A. This procedure has the data necessary to repair and refinish the link fitting (95).

   B. Refer to the Standard Overhaul Practices Manual (SOPM) for details of the SOPM subjects identified in the procedure.

   C. Refer to IPL Fig. 1 for item numbers.

   D. General repair details:

      (1) Materials: Aluminum alloy

      (2) Shot Peen: All surfaces, but not in hole surfaces
      Intensity 0.014A2

2. Link Fitting Repair

   A. Consumable Materials

      NOTE: Equivalent material can be used.

      (1) C00259 Primer -- BMS 10-11, Type 1 (SOPM 20-60-02)

   B. References

      (1) SOPM 20-10-03, Shot Peening

      (2) SOPM 20-30-02, Stripping of Protective Finishes

      (3) SOPM 20-30-03, General Cleaning Procedures

      (4) SOPM 20-41-01, Decoding Table for Boeing Finish Codes

      (5) SOPM 20-41-02, Application of Chemical and Solvent Resistant Finishes

(6) SOPM 20-43-01, Chromic Acid Anodizing

(7) SOPM 20-60-02, Finishing Materials

C. Procedure (Fig. 601)

(1) Machine as necessary, within repair limits, to remove defects.

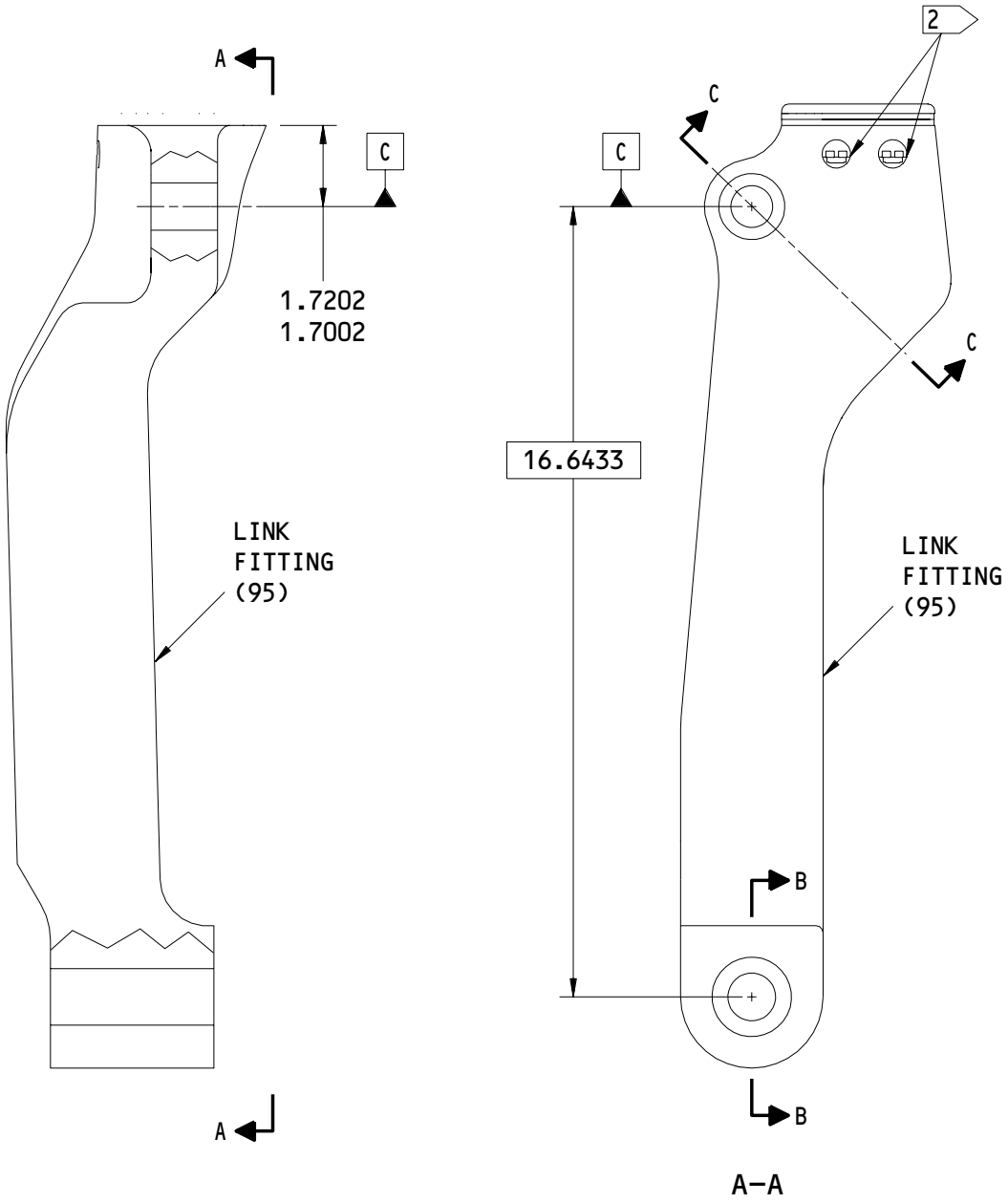
(2) Refinish as indicated.

(3) Make oversize bushings (Fig. 602), as necessary to adjust for the amount of material removed.

(4) Install the bushings as shown in REPAIR 3-1.

3. Refinish

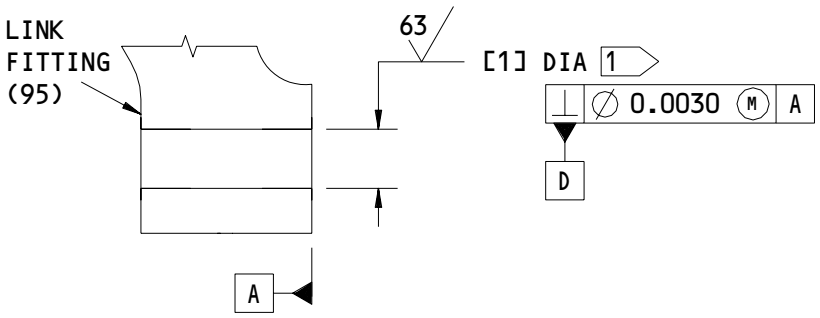
A. Boric acid - sulfuric acid anodize (F-17.31) and apply BMS 10-11, type 1 primer (F-20.03) unless shown differently.



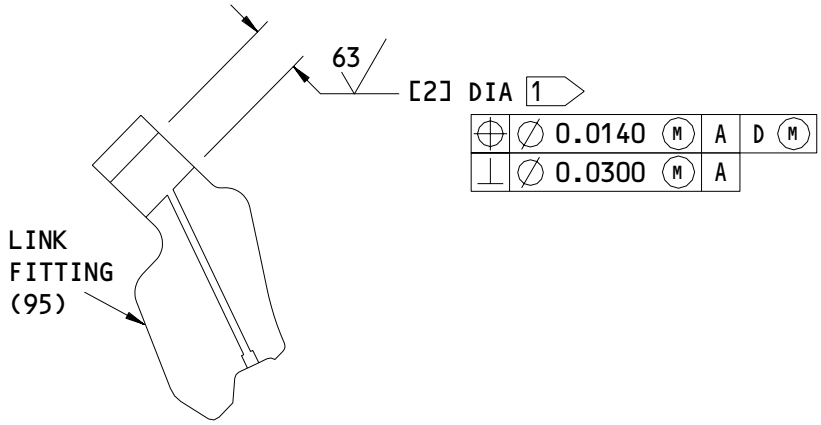
149T6935–9 SHOWN
149T6935–10 OPPOSITE

149T6935-9,-10
Link Fitting Repair
Figure 601 (Sheet 1)

K21294



B–B



C–C

REFERENCE NUMBER	[1]	[2]
DESIGN DIMENSION	1.1882 1.1875	1.0007 1.0000
REPAIR LIMIT 3	1.1907	1.0029

1 DO NOT PAINT THIS SURFACE

2 APPLY FINISH (F-17.31 + F-20.03) ON THIS SURFACE

3 REPAIR LIMIT FOR INSTALLATION OF OVERSIZE BUSHINGS

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

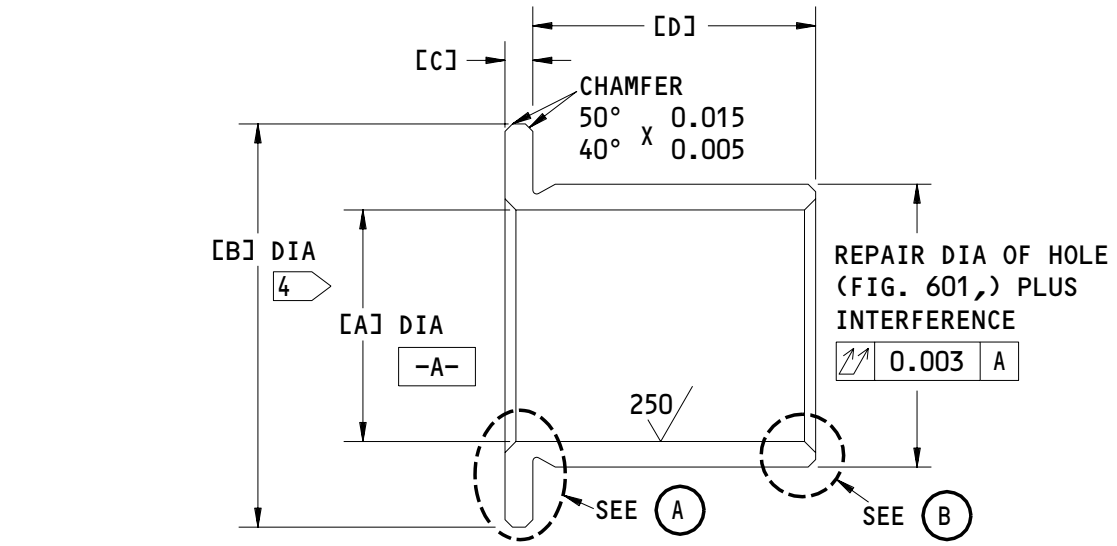
BREAK ALL SHARP EDGES

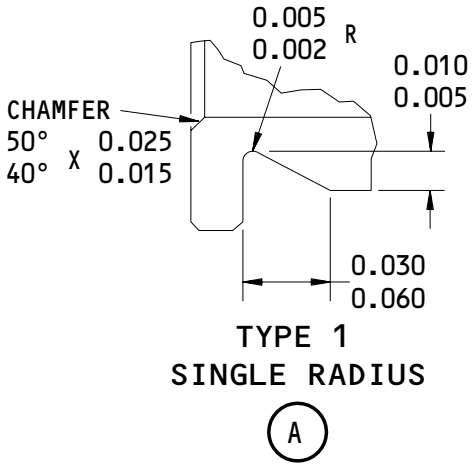
ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

149T6935-9,-10
Link Fitting Repair
Figure 601 (Sheet 2)

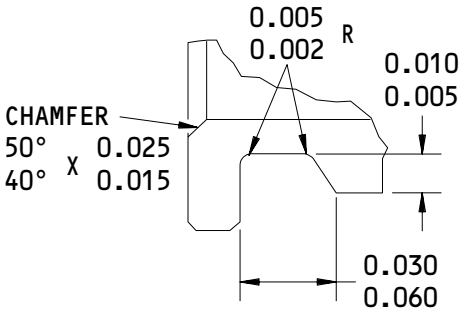
K21305





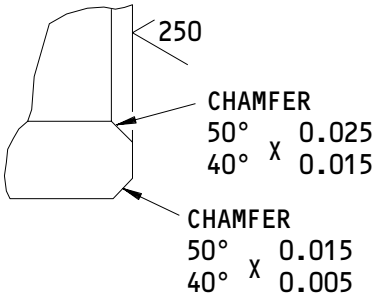
TYPE 1
SINGLE RADIUS

A



TYPE 2
DOUBLE RADII
(OPTIONAL)

A



B

Oversize Bushing Details
Figure 602 (Sheet 1)

HOLE LOCATION (FIGURE 601)	REPLACES BUSHING	[A]	[B] 4	[C]	[D]	INTER-FERENCE	MATERIAL	FINISH
[1]	BACB28AP16P100 (85)	0.988 0.969	1.680 1.670	0.167 0.162	1.000 0.995	0.0012 0.0024	2	3
[2]	BACB28AU14B060C (80)	0.864 0.844	1.400 1.390	0.093 0.088	0.600 0.595	0.0010 0.0022	1	3

1 ALUMINUM-BRONZE HEAT TREAT HR50 OR TQ50 AS IN AMS4640

2 17-4PH OR 15-5PH CRES 40-43HRC (180-200 KSI)

3 CADMIUM PLATE (F-15.06) OR ZINC PLATE (F-15.40), BUT OPT IN BORE

4 PLUS AMOUNT OF HOLE OVERSIZE

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES 0.005 MAX

DIMENSIONS ARE AFTER PLATING, BUT NOT THE BORE WHICH WILL BE MACHINED AFTER INSTALLATION

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

Oversize Bushing Details
Figure 602 (Sheet 2)

K21957

BELLCRANK ASSEMBLY - REPAIR 4-1

149T6955-13

1. General

A. This procedure has the data necessary to repair the bellcrank assembly (335).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for details of the SOPM subjects identified in the procedure.

C. Refer to IPL Fig. 1 for item numbers.

2. Bushing Replacement

A. Consumable Materials

NOTE: Equivalent material can be used.

(1) A00359 Sealant -- BMS 5-95 (SOPM 20-60-04)

B. References

(1) SOPM 20-50-03, Bushing and Bearing Replacement

(2) SOPM 20-60-04, Miscellaneous Materials

C. Procedure (Fig. 601)

(1) Remove the bushing(s) (340, 345, 350, 355, 360) from the bellcrank (370).

(2) If you find defects on the bellcrank, refer to REPAIR 4-2 for repair instructions.

(3) Install replacement bushing(s) (340, 345, 350, 355, 360) into the bellcrank (370) with BMS 5-95 sealant by the shrink-fit procedure (SOPM 20-50-03).

(4) If necessary, machine the bushing(s) (340, 345, 350, 355, 360) to deisgn dimensions and finish.

(5) Apply BMS 5-95 fillet sealant to the edges of the bushings.

3. Lube Fitting Replacement

A. Consumable Materials

NOTE: Equivalent material can be used.

(1) D00633 Grease -- BMS 3-33 (SOPM 20-60-03)

B. References

(1) SOPM 20-50-01, Bolt and Nut Installation

(2) SOPM 20-50-07, Lubrication

(3) SOPM 20-60-03, Lubricants

C. Procedure (Fig. 601)

(1) Remove the lube fitting (365) from the bellcrank (370).

(2) Install a replacement lube fitting (365) onto the bellcrank (370) with BMS 3-33 grease. Tighten the lube fitting (365) to 25-30 pound-inches.

4. Fitting Assembly Refinish

A. Consumable Materials

NOTE: Equivalent material can be used.

(1) C00260 Enamel -- BMS 10-11, Type 2 (SOPM 20-60-02)

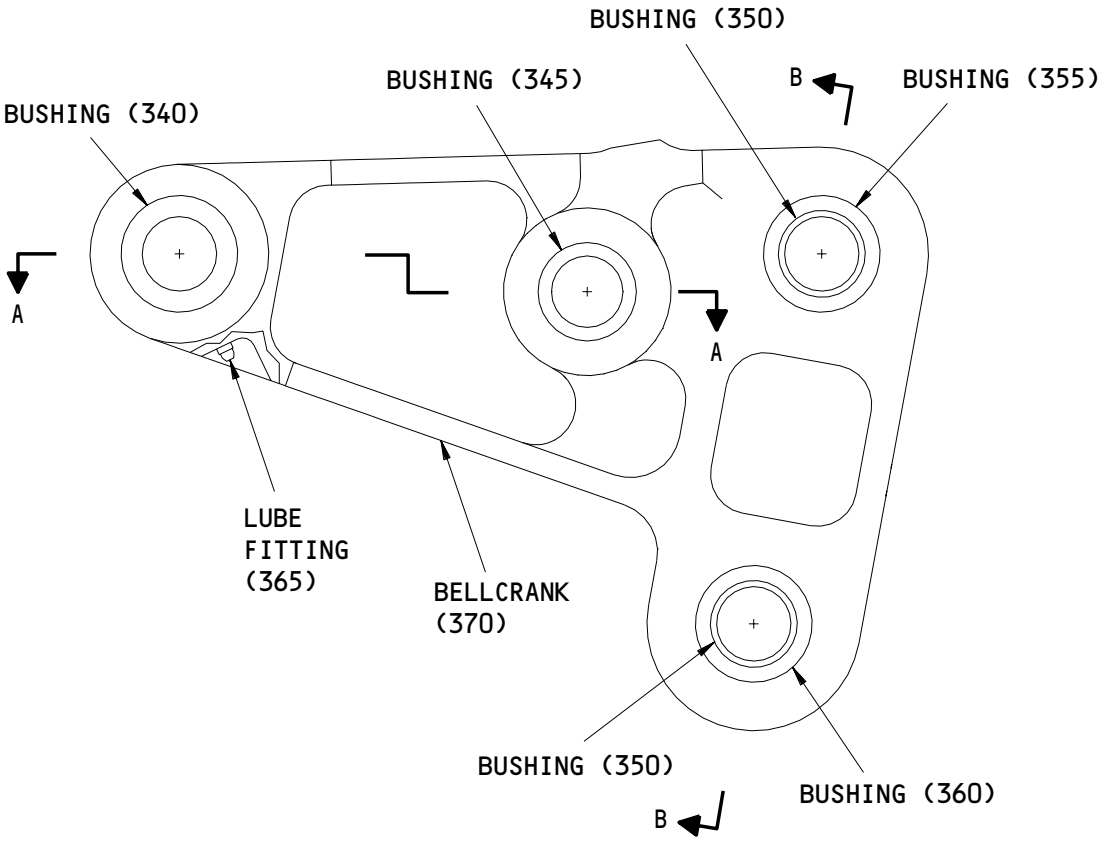
B. References

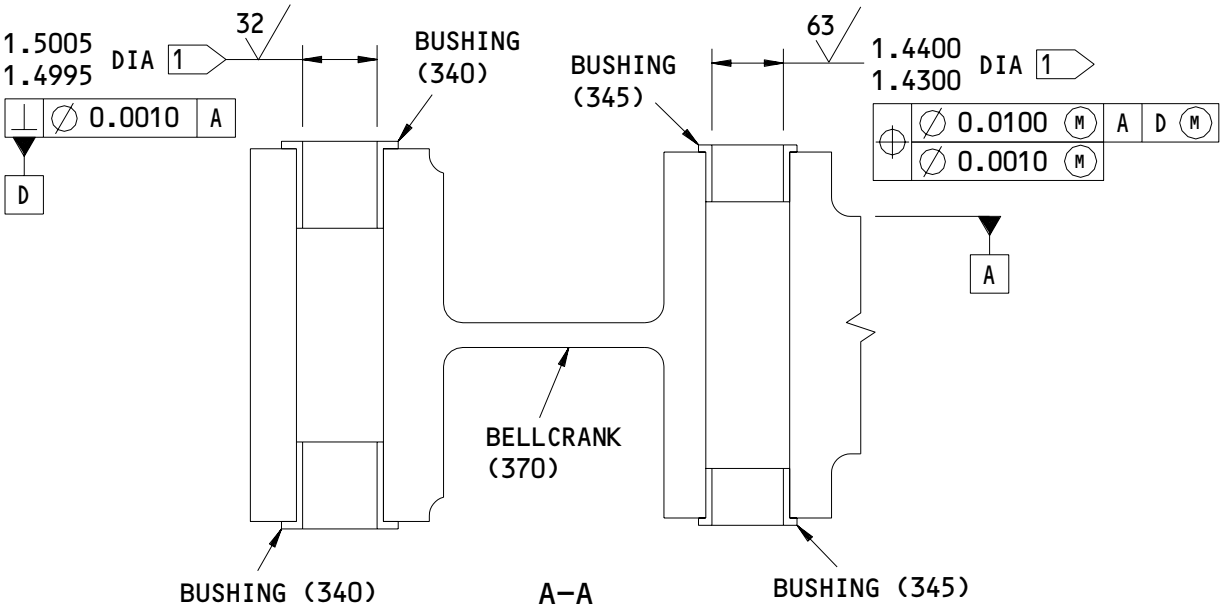
(1) SOPM 20-30-03, General Cleaning Procedure

(2) SOPM 20-60-02, Finishing Materials

C. Procedures

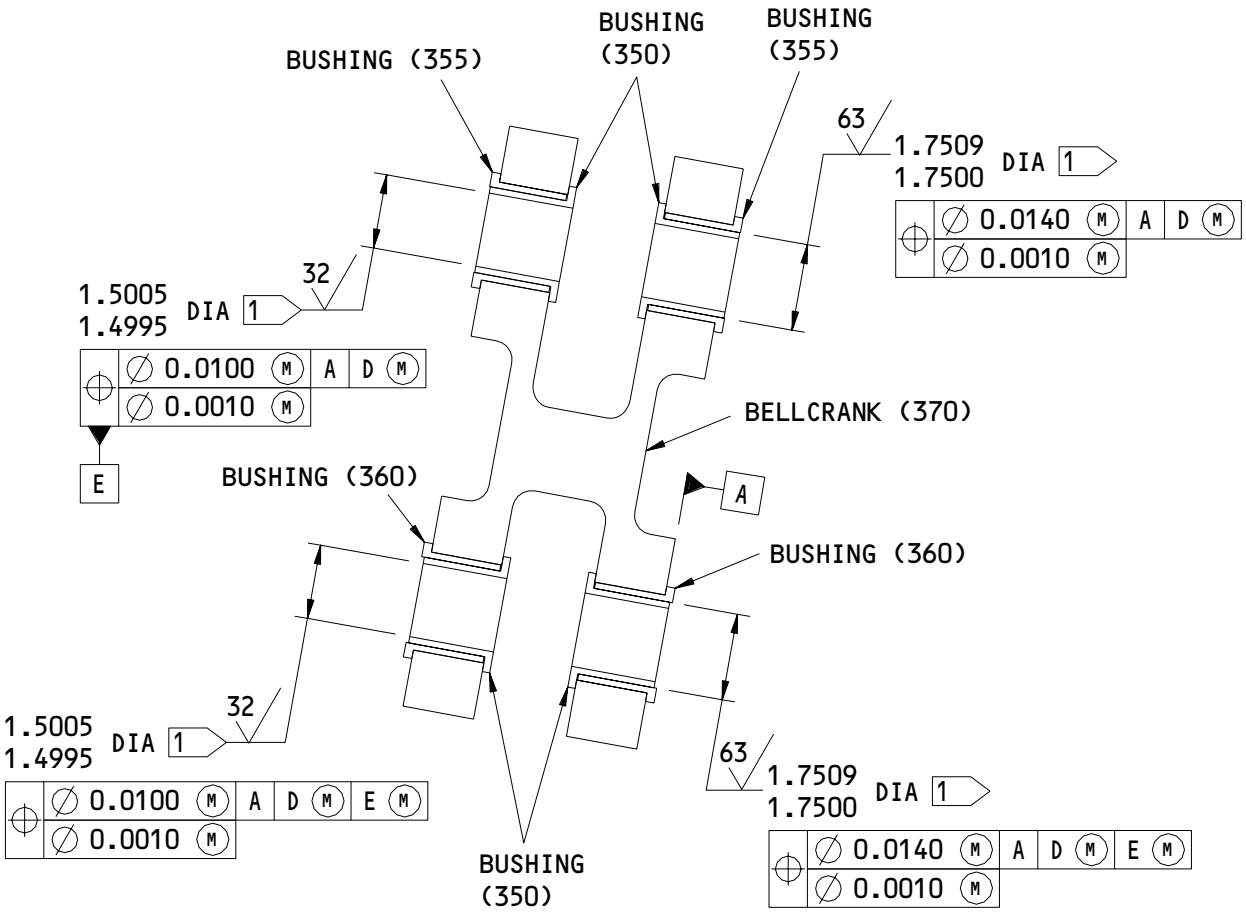
(1) Apply BMS 10-11, type 2 enamel (F-21.15) but not on the bushings or lube fitting.





149T6955-13
Bellcrank Assembly Repair
Figure 601 (Sheet 1)

K21058



B–B

1 INSTALLED DIMENSION. SIZE IF NECESSARY

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

149T6955-13
Bellcrank Assembly Repair
Figure 601 (Sheet 2)

K21084

BELLCRANK - REPAIR 4-2

149T6955-14

1. General

A. This procedure has the data necessary to repair and refinish the bellcrank (370).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for details of the SOPM subjects identified in the procedure.

C. Refer to IPL Fig. 1 for item numbers.

D. General repair details:

(1) Materials: Aluminum alloy

(2) Shot Peen: All surfaces, but not in hole surfaces
Intensity 0.014A

2. Fitting Repair

A. Consumable Materials

NOTE: Equivalent material can be used.

(1) C00259 Primer -- BMS 10-11, Type 1 (SOPM 20-60-02)

B. References

(1) SOPM 20-10-03, Shot Peening

(2) SOPM 20-30-02, Stripping of Protective Finishes

(3) SOPM 20-30-03, General Cleaning Procedures

(4) SOPM 20-41-01, Decoding Table for Boeing Finish Codes

(5) SOPM 20-41-02, Application of Chemical and Solvent Resistant Finishes

(6) SOPM 20-43-01, Chromic Acid Anodizing

(7) SOPM 20-60-02, Finishing Material

C. Procedure (Fig. 601)

(1) Machine as necessary, within repair limits shown in Fig. 601 to remove the defects.

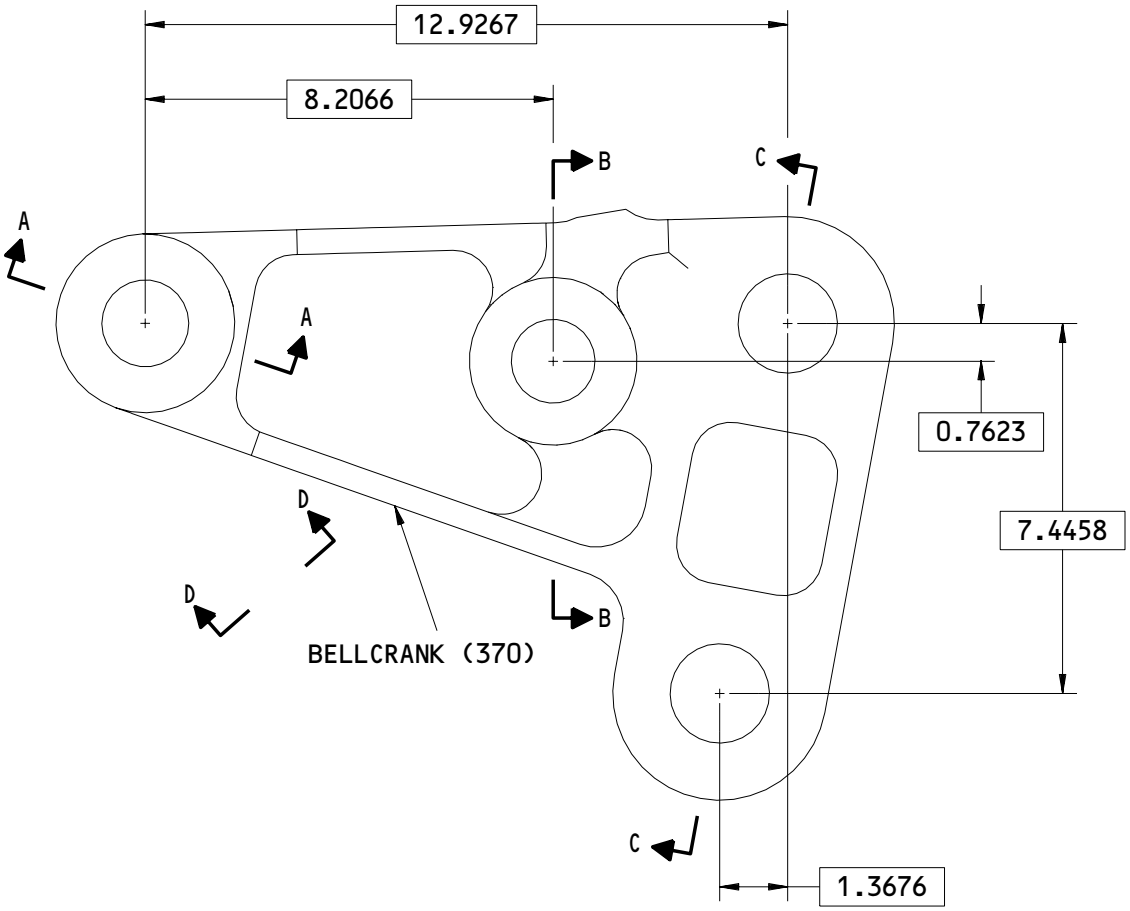
(2) Refinish as indicated.

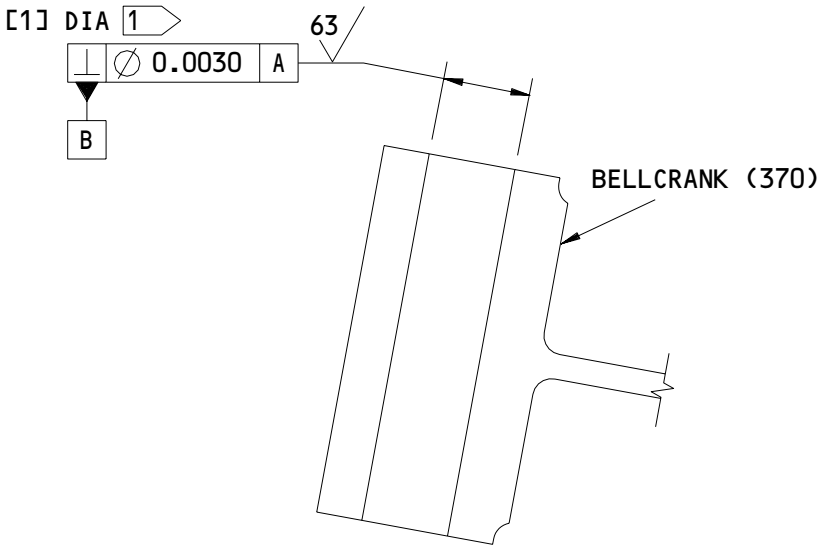
(3) Make oversize bushings (Fig. 602), as necessary to compensate for the amount of material removed in step 2.C.(1).

(4) Install the bushings as shown in REPAIR 4-1.

3. Refinish

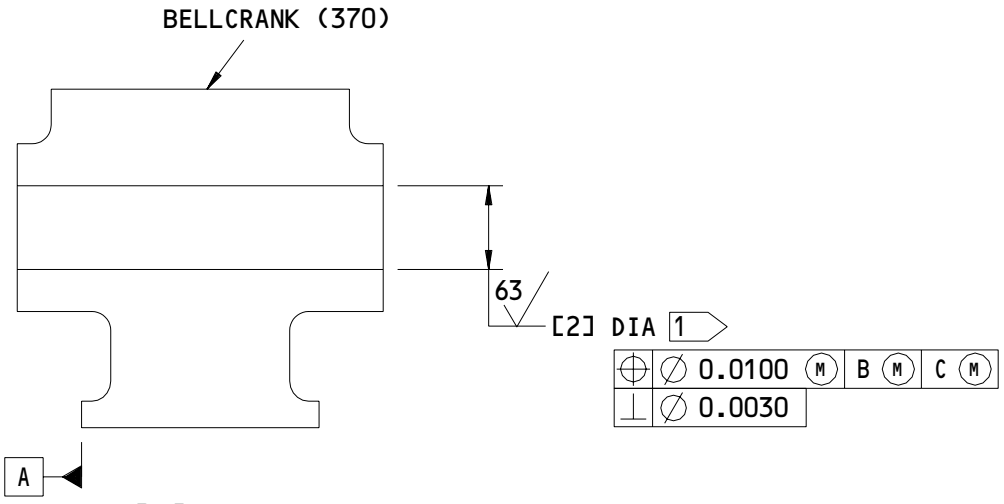
A. Boric acid - sulfuric acid anodize (F-17.31) and apply BMS 10-11, type 1 primer (F-20.03) unless shown differently.

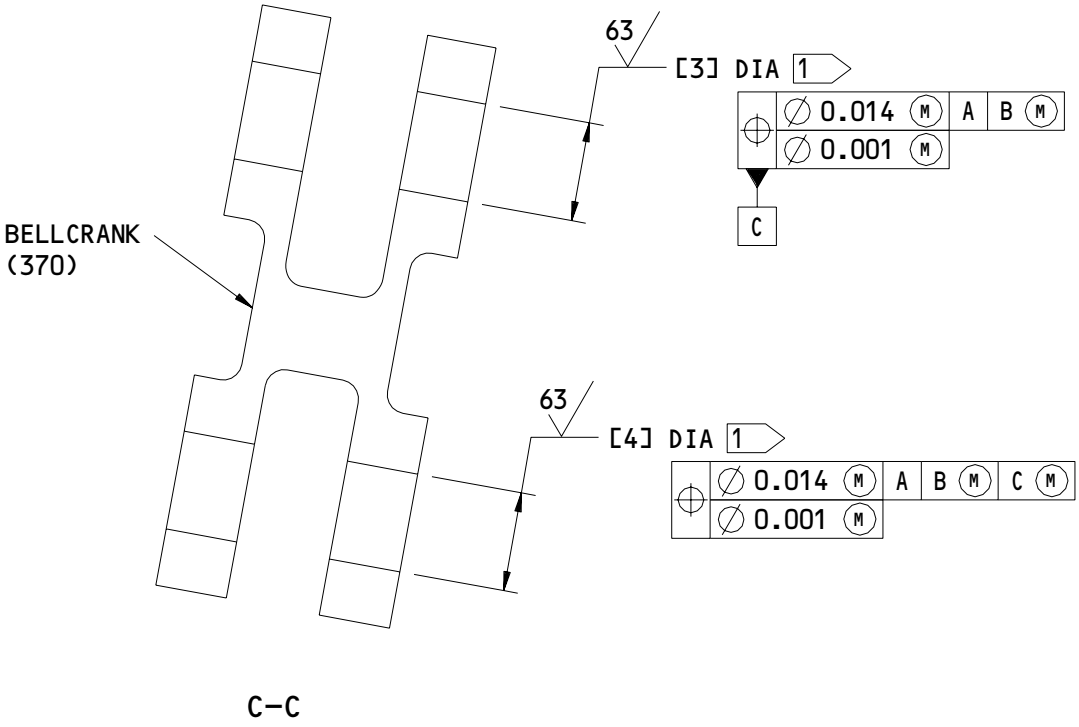




A–A

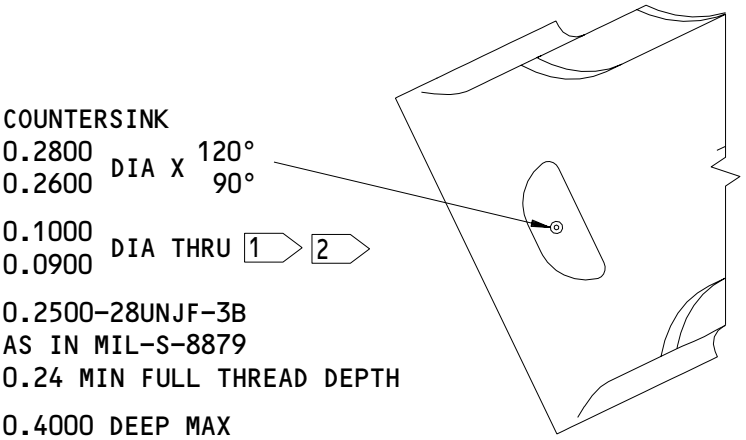
149T6955-14
Bellcrank Repair
Figure 601 (Sheet 1)





149T6955-14
Bellcrank Repair
Figure 601 (Sheet 2)

K21138



D–D

REFERENCE NUMBER	[1]	[2]	[3]	[4]
DESIGN DIMENSION	1.7509 1.7500	1.6883 1.6875	2.0009 2.0000	2.0009 2.0000
REPAIR LIMIT 3	1.7545 MAX	1.6908 MAX	2.0049 MAX	2.0049 MAX

1 DO NOT PUT PRIMER IN THIS SURFACE

2 DO NOT SHOT PEEN IN THIS SURFACE

3 REPAIR LIMIT

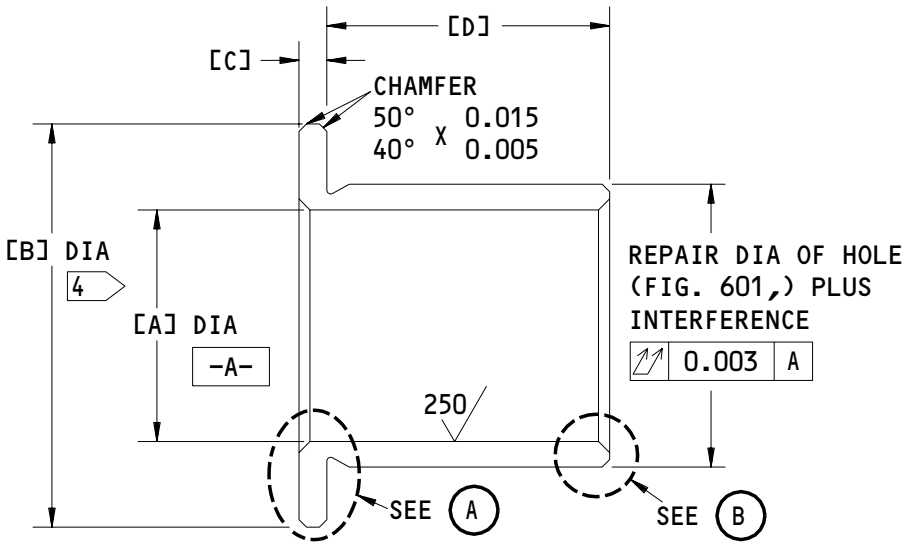
125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

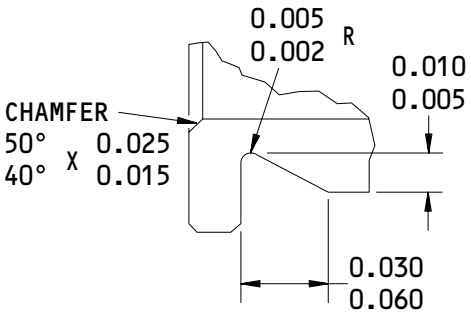
BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

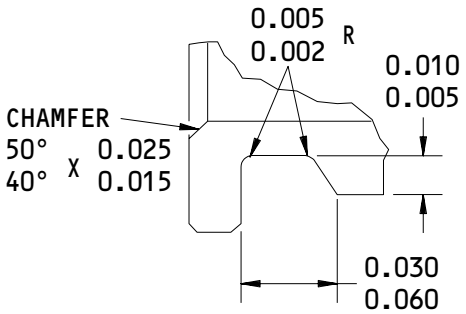
149T6955-14
Bellcrank Repair
Figure 601 (Sheet 3)





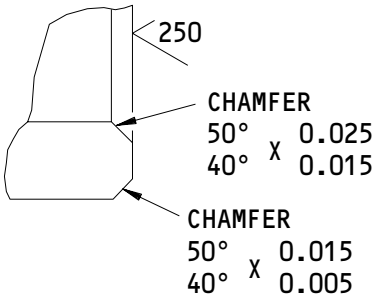
TYPE 1
SINGLE RADIUS

A



TYPE 2
DOUBLE RADII
(OPTIONAL)

A



TYPE 2
CHAMFER RETENTION

B

Oversized Bushing Details
Figure 602 (Sheet 1)

K21958

HOLE LOCATION (FIGURE 601)	REPLACES BUSHING	[A]	[B]	[C]	[D]	INTER-FERENCE	MATERIAL	FINISH
[1]	BACB28AU24B160C (340)	1.486 1.469	2.360 2.350	0.155 0.150	1.600 1.550	0.0017 0.0036	1	3
[2]	BACB28AT23D100C (345)	1.424 1.406	1.990 1.980	0.149 0.144	1.000 0.995	0.0025 0.1234	2	3
[3]	BACB28AT28D142C (355)	1.734 1.719	2.360 2.350	0.180 0.175	1.420 1.415	0.0020 0.0040	2	3
[4]	BACB28AT28D138C (360)	1.734 1.719	2.360 2.350	0.180 0.175	1.380 1.375	0.0020 0.0040	2	3

1 ALUMINUM-BRONZE HEAT TREAT HR50 OR TQ50 AS IN AMS4640

2 17-4PH OR 15-5PH CRES 40-43HRC (180-200 KSI)

3 CADMIUM PLATE AS SHOWN IN QQ-P-416, TYPE II,CLASS 2 OR ZINC NICKEL PLATE AS SHOWN IN AMS 2417, TYPE 2

4 OUTER DIAMETER OF THE REPLACEMENT BUSHING FLANGE MUST INCREASE IN THE SAME AMOUNT AS THE OUTER DIAMETER OF THE BUSHING SPIGOT

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES 0.005 MAX

DIMENSIONS ARE AFTER PLATING, NOT INCLUDING HOLE [B]

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

Oversized Bushing Details
Figure 602 (Sheet 2)

MALE ROD END ASSEMBLY - REPAIR 5-1

149T6956-6

1. General

   A. This procedure has the data necessary to repair the male rod end assembly (285).

   B. Refer to the Standard Overhaul Practices Manual (SOPM) for details of the SOPM subjects identified in the procedure.

   C. Refer to IPL Fig. 1 for item numbers.

2. Bearing Replacement

   A. Consumable Materials

      NOTE: Equivalent material can be used.

      (1) D00633 Grease -- BMS 3-33 (SOPM 20-60-03)

   B. References

      (1) SOPM 20-50-03, Bushing and Bearing Replacement

      (2) SOPM 20-50-07, Lubrication

      (3) SOPM 20-60-03, Lubricants

      (4) SOPM 20-60-04, Miscellaneous Materials

   C. Procedure (Fig. 601)

      (1) Remove the bearing (290) from the rod end (300).

      (2) Install a replacement bearing (290) into the rod end (300) with BMS 3-33 grease and roller swage (SOPM 20-50-03).

      (3) Apply BMS 3-33 grease onto the inside diameter of the bearing (290) as shown in SOPM 20-60-03.

3. Lube Fitting Replacement

A. Consumable Materials

NOTE: Equivalent material can be used.

(1) D00633 Grease -- BMS 3-33 (SOPM 20-60-03)

B. References

(1) SOPM 20-50-01, Bolt and Nut Installation

(2) SOPM 20-50-07, Lubrication

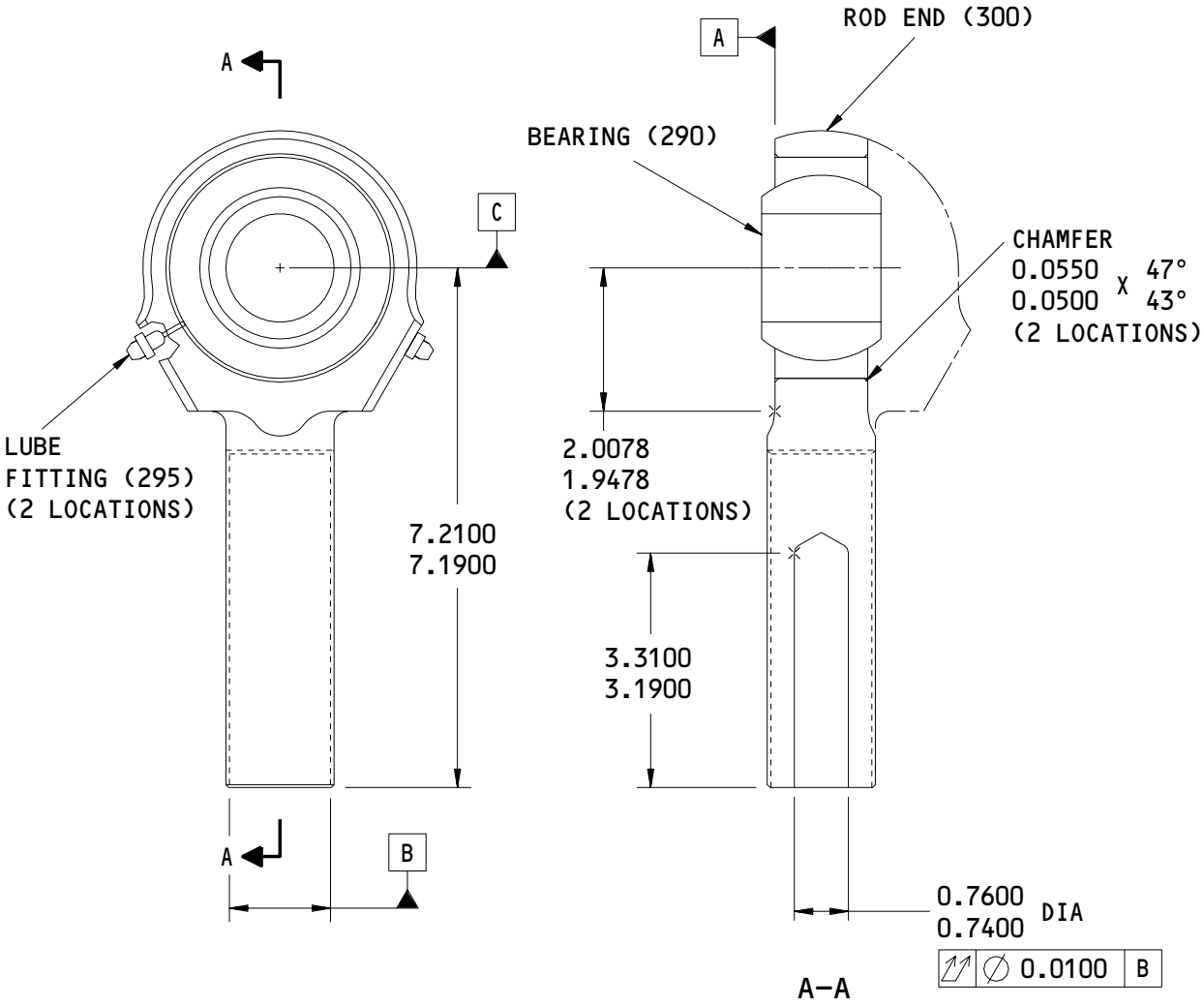
(3) SOPM 20-60-03, Lubricants

C. Procedure (Fig. 601)

(1) Remove the lube fitting(s) (295) from the rod end (300).

(2) Install replacement lube fitting(s) (295) onto the rod end (300) with BMS 3-33 grease. Tighten the lube fitting(s) (295) to 25-30 pound-inches.

(3) Make sure that the lube passage is not blocked. Apply BMS 3-33 grease to the lube fittings (295) until grease appears in the inside diameter of the bearing (290).



ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

149T6956-6
Male Rod End Assembly Repair
Figure 601

K21345

ROD END - REPAIR 5-2

149T6956-7

1. General

A. This procedure has the data necessary to refinish the rod end (300).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for details of the SOPM subjects identified in the procedure.

C. Refer to IPL Fig. 1 for item numbers.

D. General repair details:

(1) Materials: 15-5PH CRES
180-200 ksi

(2) Shot Peen: All surfaces, but not in hole surfaces
Intensity 0.016A2
Coverage 2.0

2. Rod End Refinish

A. Consumable Materials

NOTE: Equivalent material can be used.

(1) D00113 Grease -- BMS 3-8, Type 8 (SOPM 20-60-03)

B. References

(1) CMM 32-00-05, Repair of High Strength Steel Parts

(2) SOPM 20-10-03, Shot Peening

(3) SOPM 20-30-02, Stripping of Protective Finishes

(4) SOPM 20-30-03, General Cleaning Procedures

(5) SOPM 20-41-01, Decoding Table for Boeing Finish Codes

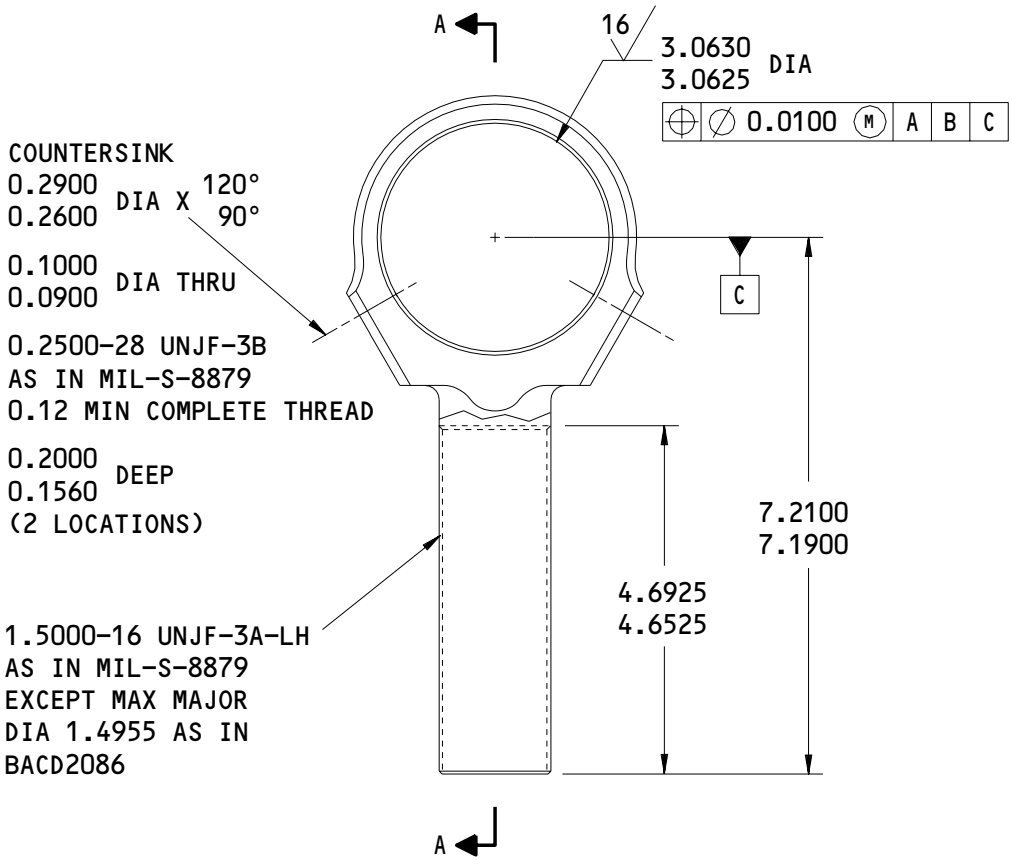
(6) SOPM 20-50-08, Application of Bonded Solid Film Lubricants

(7) SOPM 20-60-03, Lubricants

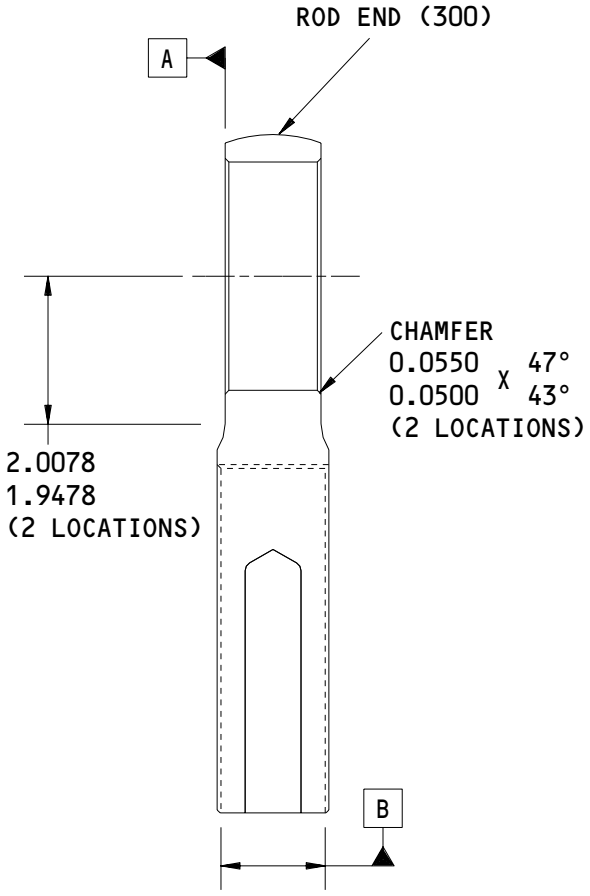
C. Procedure (Fig. 601)

(1) Passivate (F-17.25).

(2) Apply BMS 3-8, type 8 solid film lubricant (F-19.10) as shown.



149T6956-7
Rod End Repair
Figure 601 (Sheet 1)



A–A

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

149T6956-7
Rod End Repair
Figure 601 (Sheet 2)

K21362

FEMALE ROD END ASSEMBLY - REPAIR 5-3

149T6956-8

1. General

   A. This procedure has the data necessary to repair the female rod end assembly (255).

   B. Refer to the Standard Overhaul Practices Manual (SOPM) for details of the SOPM subjects identified in the procedure.

   C. Refer to IPL Fig. 1 for item numbers.

2. Bearing Replacement

   A. Consumable Materials

      NOTE: Equivalent material can be used.

      (1) D00633 Grease -- BMS 3-33 (SOPM 20-60-03)

   B. References

      (1) SOPM 20-50-03, Bushing and Bearing Replacement

      (2) SOPM 20-50-07, Lubrication

      (3) SOPM 20-60-03, Lubricants

      (4) SOPM 20-60-04, Miscellaneous Materials

   C. Procedure (Fig. 601)

      (1) Remove the bearing (260) from the rod end (270).

      (2) Install a replacement bearing (260) into the rod end (270) with BMS 3-33 grease and roller swage (SOPM 20-50-03).

      (3) Apply BMS 3-33 grease to the inside diameter of the bearing (260).

3. Lube Fitting Replacement

A. Consumable Materials

NOTE: Equivalent material can be used.

(1) D00633 Grease -- BMS 3-33 (SOPM 20-60-03)

B. References

(1) SOPM 20-50-01, Bolt and Nut Installation

(2) SOPM 20-50-07, Lubrication

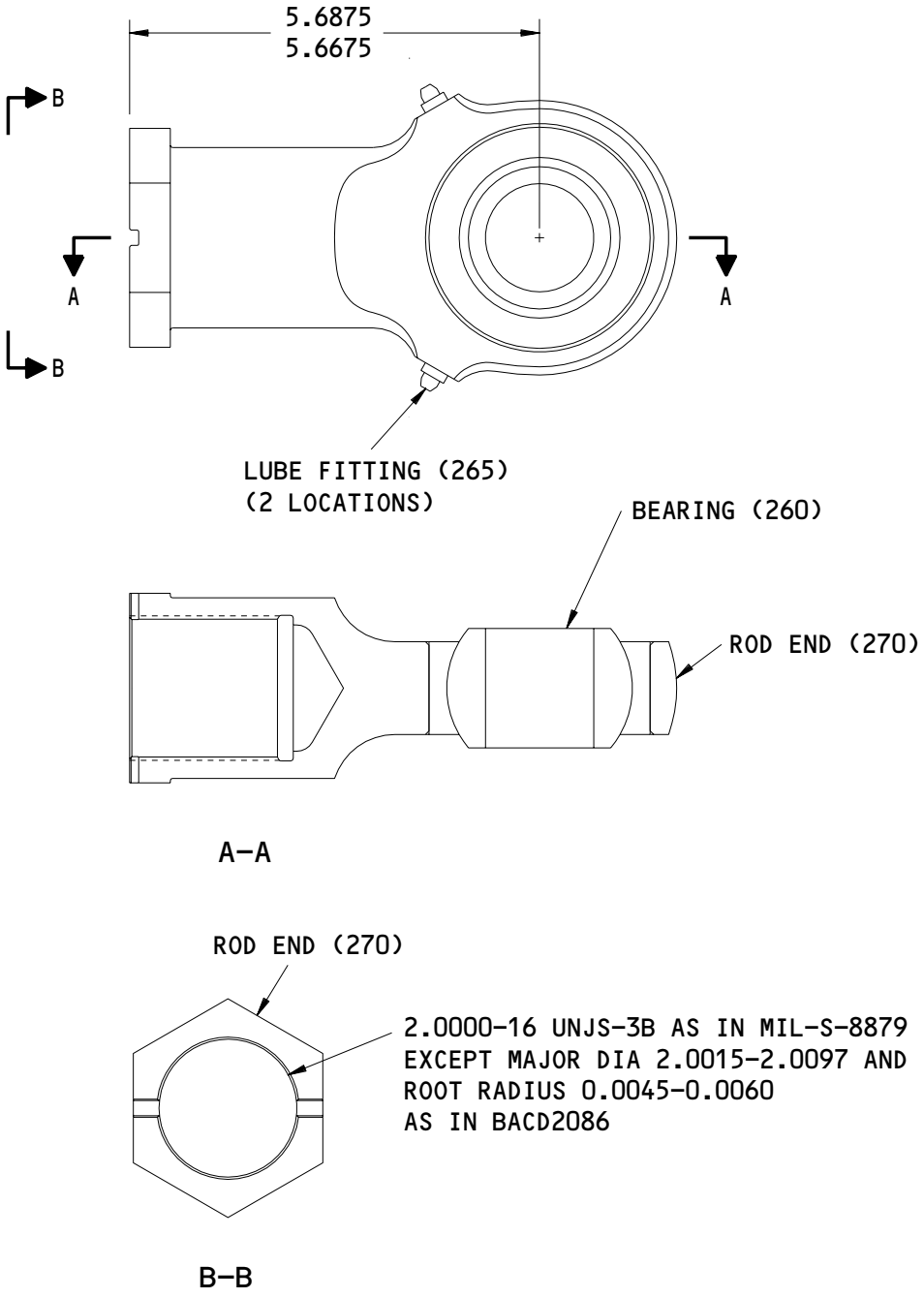
(3) SOPM 20-60-03, Lubricants

C. Procedure (Fig. 601)

(1) Remove the lube fitting(s) (265) from the rod end (270).

(2) Install replacement lube fitting(s) (265) onto the rod end (270) with BMS 3-33 grease. Tighten the lube fitting(s) (265) to 25-30 pound-inches.

(3) Make sure that the lube passage is not blocked. Apply BMS 3-33 grease to the lube fitting(s) (265) until grease appears in the inside diameter of the bearing (260).



ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

149T6956–8
Female Rod End Assembly Repair
Figure 601

ROD END - REPAIR 5-4

149T6956-9

1. General

A. This procedure has the data necessary to refinish the rod end (270).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for details of the SOPM subjects identified in the procedure.

C. Refer to IPL Fig. 1 for item numbers.

D. General repair details:

(1) Materials: 15-5PH Cres
180-200 Ksi

(2) Shot Peen: All surfaces, but not in hole surfaces
Intensity 0.016A2
Coverage 2.0

2. Rod End Finish

A. Consumable Materials

NOTE: Equivalent material can be used.

(1) D00113 Lubricant -- BMS 3-8, Type 8 (SOPM 20-60-03)

B. References

(1) CMM 32-00-05, Repair of High Strength Steel Parts

(2) SOPM 20-10-03, Shot Peening

(3) SOPM 20-30-02, Stripping of Protective Finishes

(4) SOPM 20-30-03, General Cleaning Procedures

(5) SOPM 20-41-01, Decoding Table for Boeing Finish Codes

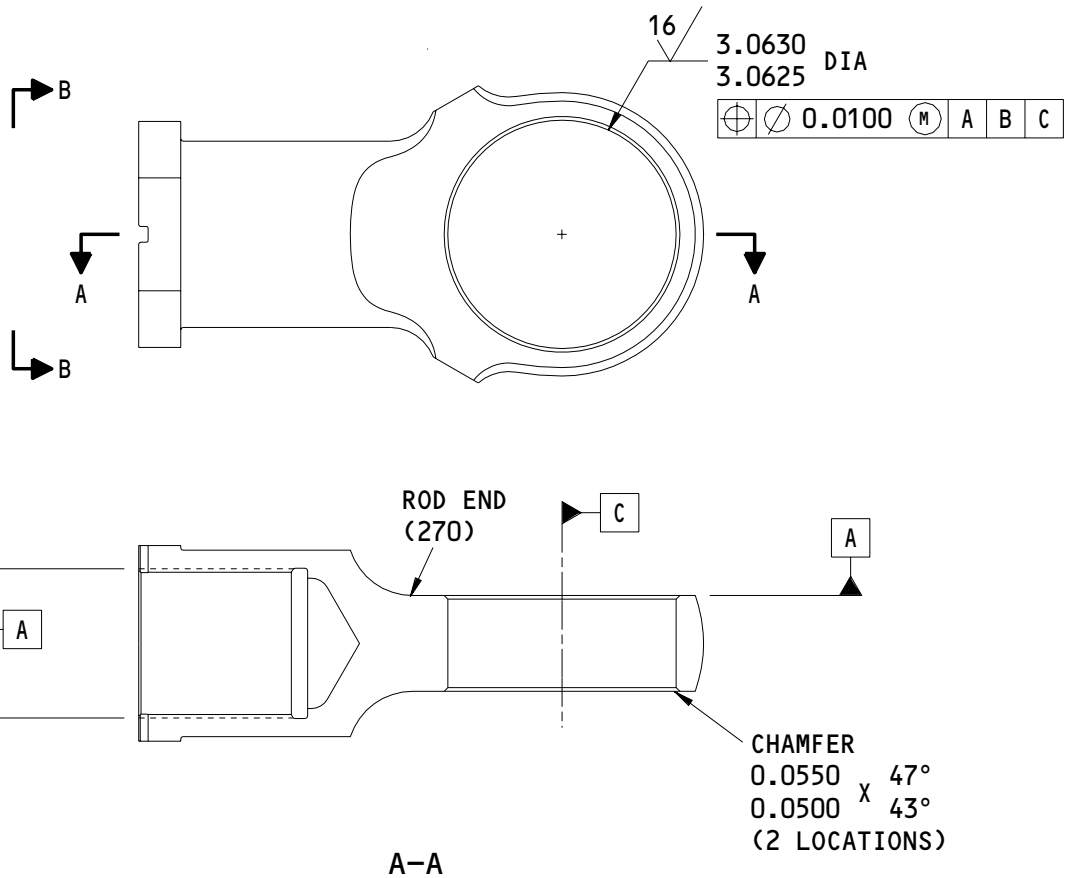
(6) SOPM 20-50-08, Application of Bonded Solid Film Lubricants

(7) SOPM 20-60-03, Lubricants

C. Procedure (Fig. 601)

(1) Passivate (F-17.25).

(2) Apply BMS 3-8, type 8 solid film lubricant (F-19.10) or optional lubricant (F-19.81) as shown.



125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

1 APPLY BMS 3–8 SOLID FILM LUBRICANT (F–19.10) IN THIS SURFACE. OPTIONAL LUBRICANT (F–19.81)

149T6956–9
Rod End Repair
Figure 601

K21399

FITTING ASSEMBLY - REPAIR 6-1

149T6963-3

1. General

   A. This procedure has the data necessary to repair the cross link fitting assembly (470).

   B. Refer to the Standard Overhaul Practices Manual (SOPM) for details of the SOPM subjects identified in the procedure.

   C. Refer to IPL Fig. 1 for item numbers.

2. Bushing Replacement

   A. Consumable Materials

      NOTE: Equivalent material can be used.

      (1) A00359 Sealant -- BMS 5-95 (SOPM 20-60-04)

   B. References

      (1) SOPM 20-50-03, Bushing and Bearing Replacement

      (2) SOPM 20-60-04, Miscellaneous Materials

   C. Procedure (Fig. 601)

      (1) Remove the bushing(s) (475, 480) from the fitting (485).

      (2) If you find defects on the fitting surfaces, refer to REPAIR 6-2 for repair instructions.

      (3) Install replacement bushing(s) (475, 480) into the fitting (485) with BMS 5-95 sealant by the shrink-fit procedure (SOPM 20-50-03).

      (4) If necessary, machine the bushing(s) (475, 480) to design dimensions and finish.

(5) Apply BMS 5-95 fillet sealant to the edges of the bushings.

3. Fitting Assembly Refinish

A. Consumable Materials

NOTE: Equivalent material can be used.

(1) C00260 Enamel -- BMS 10-11, Type 2 (SOPM 20-60-02)

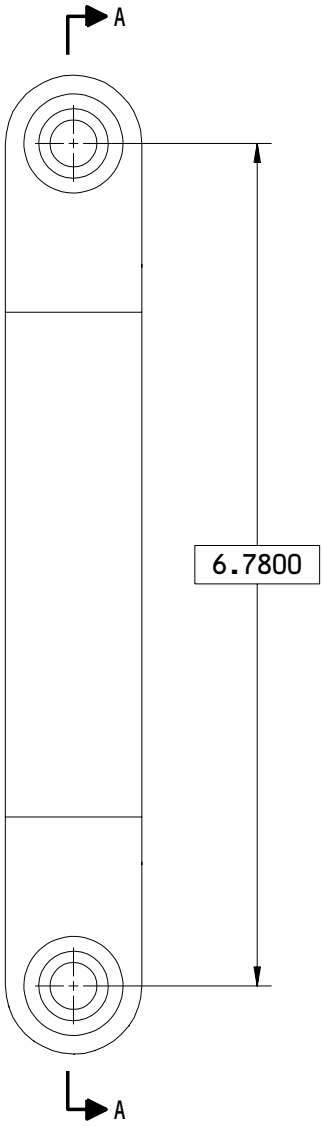
B. References

(1) SOPM 20-30-03, General Cleaning Procedure

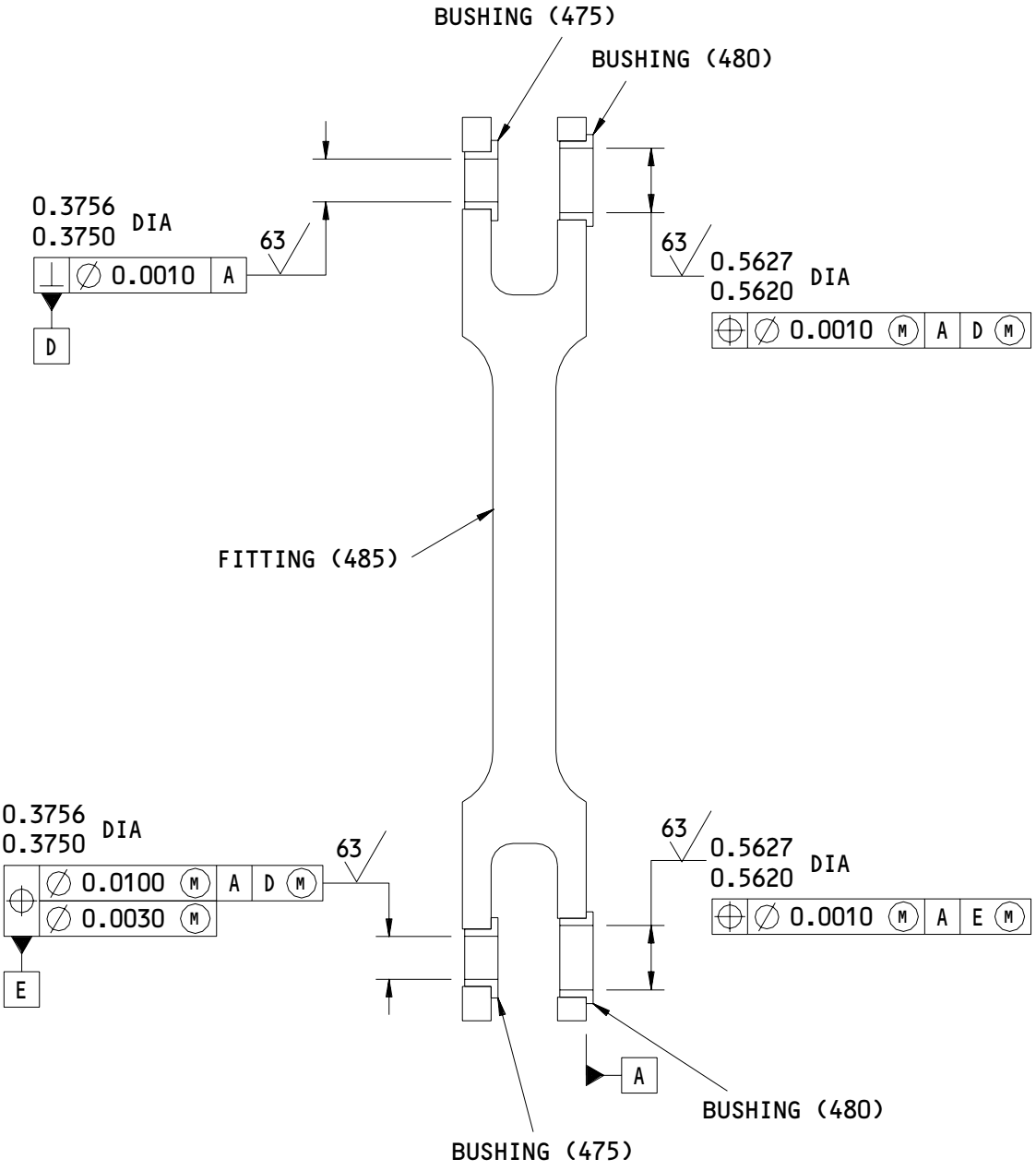
(2) SOPM 20-60-02, Finishing Materials

C. Procedure

(1) Apply BMS 10-11, type 2 enamel (F-21.17) but not on the bushings.



149T6963-3
Fitting Assembly Repair
Figure 601 (Sheet 1)



A–A

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

149T6963-3
Fitting Assembly Repair
Figure 601 (Sheet 2)

K21474

FITTING - REPAIR 6-2

149T6963-4

1. General

A. This procedure has the data necessary to repair and refinish the crosslink fitting (470).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for details of the SOPM subjects identified in the procedure.

C. Refer to IPL Fig. 1 for item numbers.

D. General repair details:

(1) Materials: Aluminum alloy

(2) Shot Peen: All surfaces, but not in hole surfaces
Intensity 0.012A2

2. Fitting Repair

A. Consumable Materials

NOTE: Equivalent material can be used.

(1) C00259 Primer -- BMS 10-11, Type 1 (SOPM 20-60-02)

B. References

(1) SOPM 20-10-03, Shot Peening

(2) SOPM 20-30-02, Stripping of Protective Finishes

(3) SOPM 20-30-03, General Cleaning Procedures

(4) SOPM 20-41-01, Decoding Table for Boeing Finish Codes

(5) SOPM 20-41-02, Application of Chemical and Solvent Resistant Finishes

(6) SOPM 20-43-01, Chromic Acid Anodizing

(7) SOPM 20-60-02, Finishing Material

C. Procedure (Fig. 601)

(1) Machine as necessary, within repair limits, to remove defects.

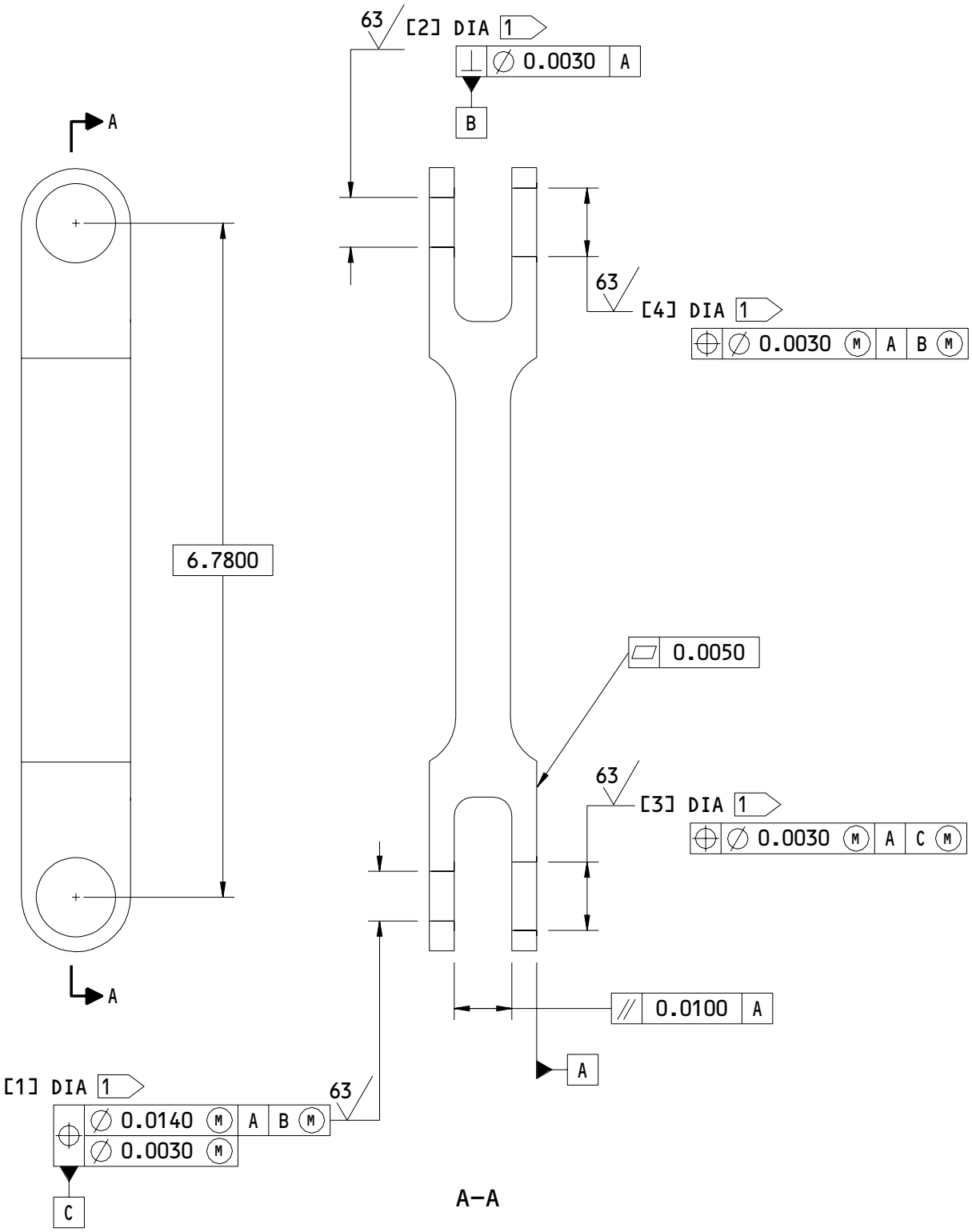
(2) Refinish as indicated.

(3) Make oversize bushings (Fig. 602), as necessary to adjust for the material removed in step (1).

(4) Install the bushings as shown in REPAIR 6-1.

3. Refinish (Fig. 601)

A. Boric acid - sulfuric acid anodize (F-17.31) and apply BMS 10-11, type 1 primer (F-20.03) unless shown differently.



149T6963-4
Fitting Repair
Figure 601 (Sheet 1)

K21475

REFERENCE NUMBER	[1]	[2]	[3]	[4]
DESIGN DIMENSION	0.5006 0.5000	0.5006 0.5000	0.6882 0.6875	0.6882 0.6875
REPAIR LIMIT 2	0.5021 MAX	0.5021 MAX	0.6900 MAX	0.6900 MAX

1 DO NOT PUT PRIMER (F-20.03) IN THIS SURFACE

2 REPAIR LIMIT

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

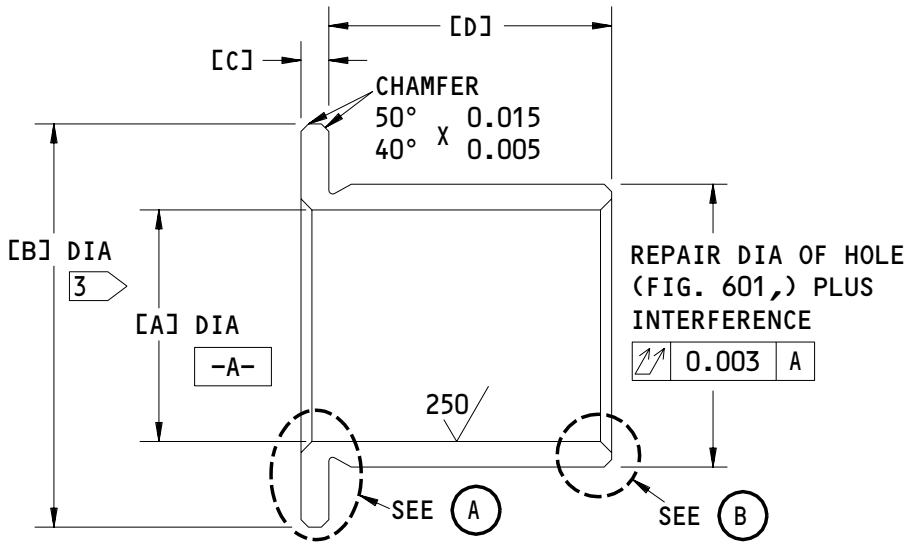
BREAK ALL SHARP EDGES

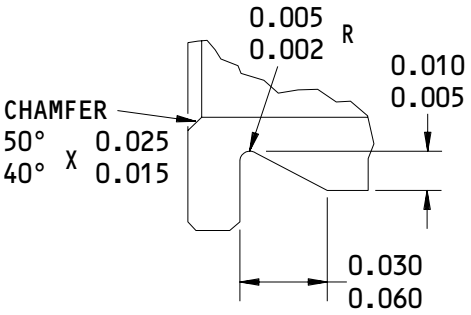
ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

149T6963-4
Fitting Repair
Figure 601 (Sheet 2)

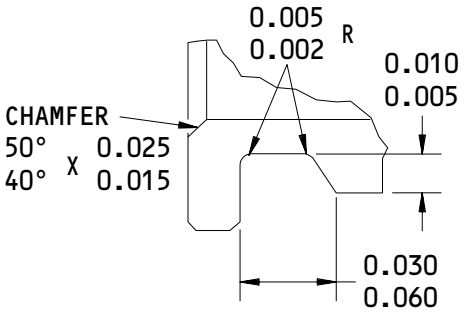
K21478





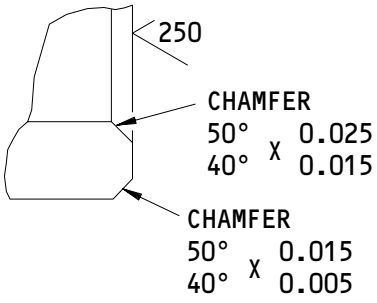
TYPE 1
SINGLE RADIUS

A



TYPE 2
DOUBLE RADII
(OPTIONAL)

A



TYPE 2
CHAMFER RETENTION

B

Oversized Bushing Details
Figure 602 (Sheet 1)

HOLE LOCATION (FIGURE 601)	REPLACES BUSHING	[A]	[B]	[C]	[D]	INTER-FERENCE	MATERIAL	FINISH
[1],[2]	BACB28AP06P023 (475)	0.366 0.359	0.710 0.700	0.065 0.060	0.230 0.225	0.0004 0.0015	1	2
[3],[4]	BACB28AT09B023C (480)	0.553 0.547	0.810 0.800	0.065 0.060	0.230 0.225	0.0006 0.0018	1	2

1 ALUMINUM-BRONZE AS IN AMS4640

2 CADMIUM PLATE AS SHOWN IN QQ-P-416, TYPE II, CLASS 2 OR ZINC NICKEL PLATE AS SHOWN IN AMS 2417, TYPE 2

3 OUTER DIAMETER OF THE REPLACEMENT BUSHING FLANGE MUST INCREASE IN THE SAME AMOUNT AS THE OUTER DIAMETER OF THE BUSHING SPIGOT

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES 0.005 MAX

DIMENSIONS ARE AFTER PLATING, NOT INCLUDING HOLE [B]

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

Oversized Bushing Details
Figure 602 (Sheet 2)

K21947

FITTING ASSEMBLY - REPAIR 7-1

149T6988-6

1. General

A. This procedure has the data necessary to repair the fitting assembly (190).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for details of the SOPM subjects identified in the procedure.

C. Refer to IPL Fig. 1 for item numbers.

2. Bushing Replacement

A. Consumable Materials

NOTE: Equivalent material can be used.

(1) D00633 Grease -- BMS 3-33 (SOPM 20-60-03)

(2) A00359 Sealant -- BMS 5-95 (SOPM 20-60-04)

B. References

(1) SOPM 20-50-03, Bushing and Bearing Replacement

(2) SOPM 20-50-07, Lubrication

(3) SOPM 20-60-03, Lubricants

(4) SOPM 20-60-04, Miscellaneous Materials

C. Procedure (Fig. 601)

(1) Remove the bushing(s) (195, 200) from the fitting (205).

(2) If you find defects on the fitting surfaces, refer to REPAIR 7-2 for repair instructions.

(3) Install replacement bushing(s) (195, 200) into the fitting (205) with BMS 5-95 sealant by the shrink-fit procedure (SOPM 20-50-03).

(4) If necessary, machine the bushings (195, 200) to design dimensions and finish.

(5) Apply BMS 5-95 fillet sealant to the edges of the bushings.

3. Fitting Assembly Refinish

A. Consumable Materials

NOTE: Equivalent material can be used.

(1) C00260 Enamel -- BMS 10-11, Type 2 (SOPM 20-60-02)

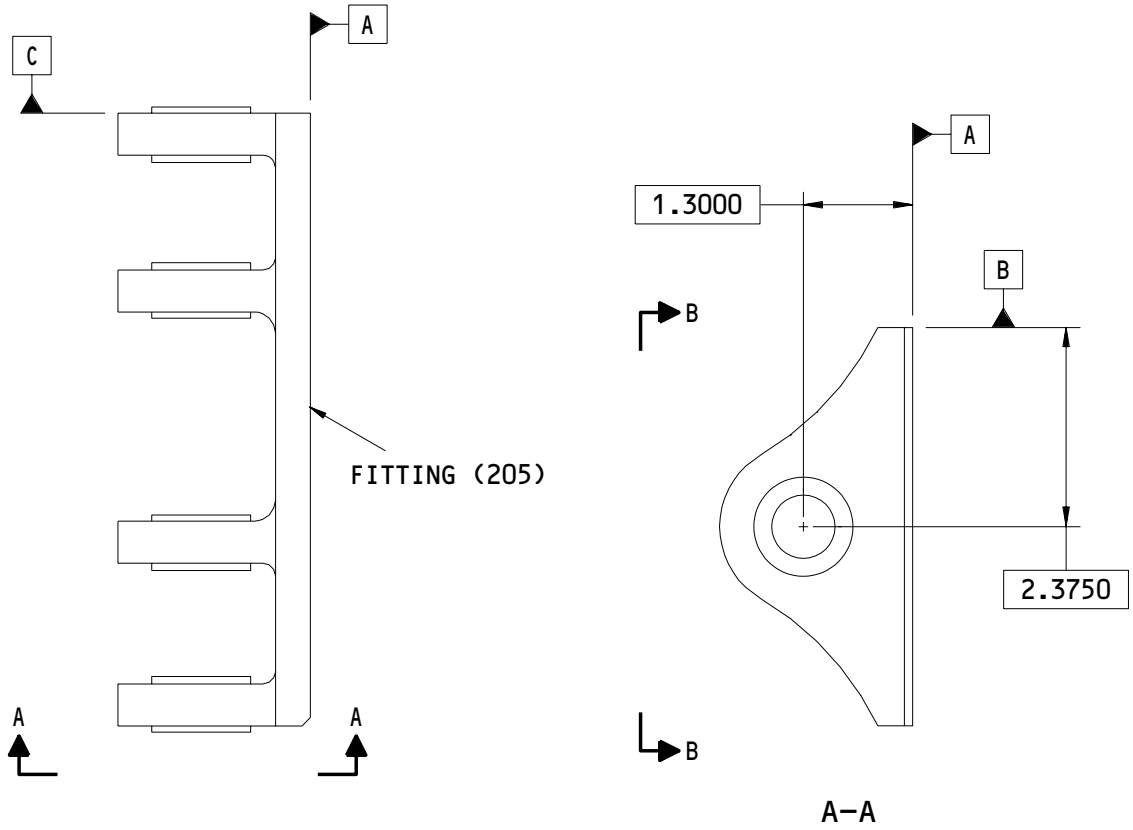
B. References

(1) SOPM 20-30-03, General Cleaning Procedure

(2) SOPM 20-60-02, Finishing Materials

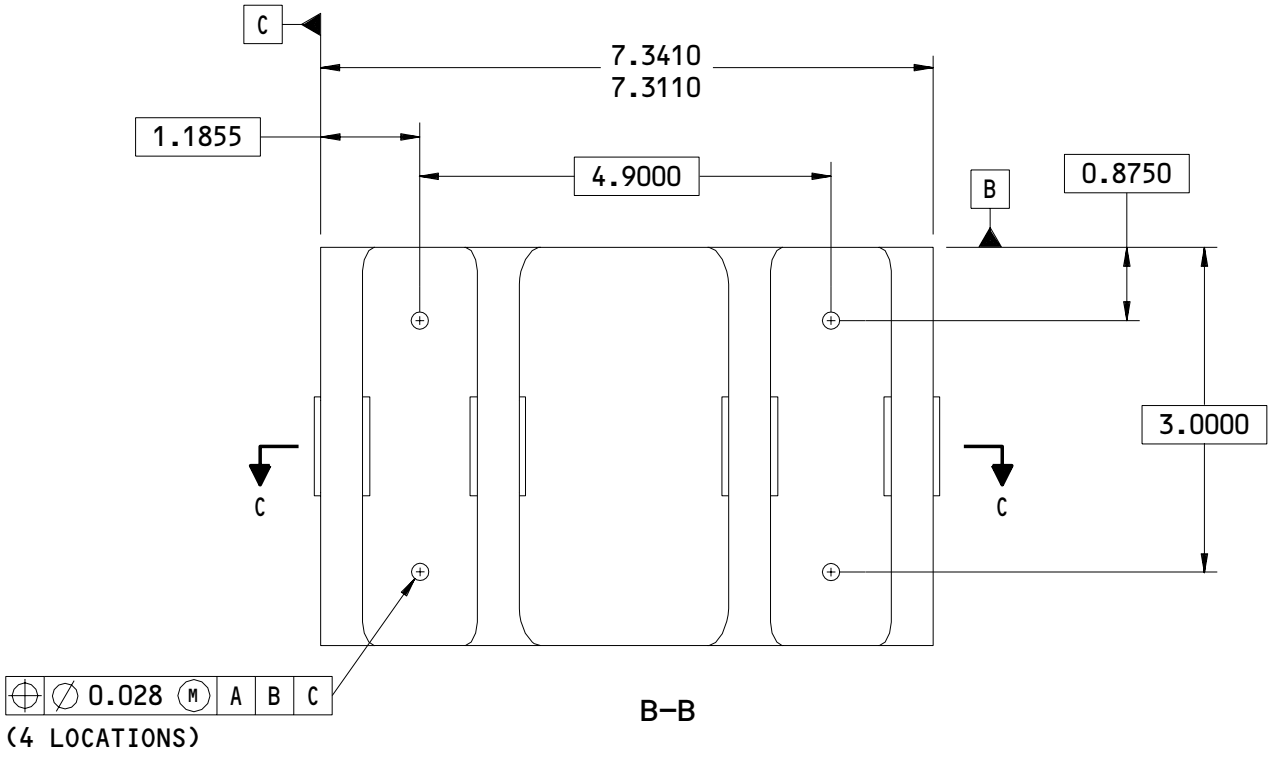
C. Procedures

(1) Apply BMS 10-11, type 2 enamel (F-21.15) but not on the bushings.

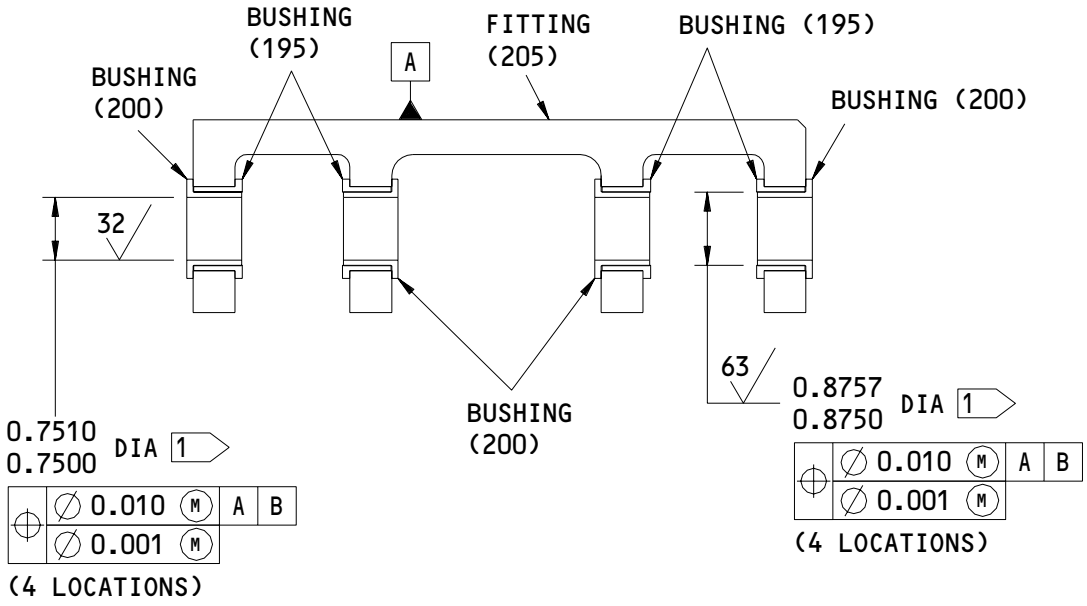


149T6988-6
Fitting Assembly
Figure 601 (Sheet 1)

K21917



B–B



C–C

1 INSTALLED DIMENSION. SIZE IF NECESSARY

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

149T6988-6
Fitting Assembly
Figure 601 (Sheet 2)

K21925

FITTING - REPAIR 7-2

149T6988-7

1. General

A. This procedure has the data necessary to repair and refinish the fitting (205).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for details of the SOPM subjects identified in the procedure.

C. Refer to IPL Fig. 1 for item numbers.

D. General repair details:

(1) Materials: Aluminum alloy

(2) Shot Peen: All surfaces, but not in hole surfaces
Intensity 0.014A2

2. Fitting Repair

A. Consumable Materials

NOTE: Equivalent material can be used.

(1) C00259 Primer -- BMS 10-11, Type 1 (SOPM 20-60-02)

(2) C00260 Enamel -- BMS 10-11, Type 2 (SOPM 20-60-02)

B. References

(1) SOPM 20-10-03, Shot Peening

(2) SOPM 20-30-02, Stripping of Protective Finishes

(3) SOPM 20-30-03, General Cleaning Procedures

(4) SOPM 20-41-01, Decoding Table for Boeing Finish Codes

(5) SOPM 20-41-02, Application of Chemical and Solvent Resistant Finishes

(6) SOPM 20-43-01, Chromic Acid Anodizing

(7) SOPM 20-60-02, Finishing Material

C. Procedure (Fig. 601)

(1) Machine as necessary, within repair limits to remove defects.

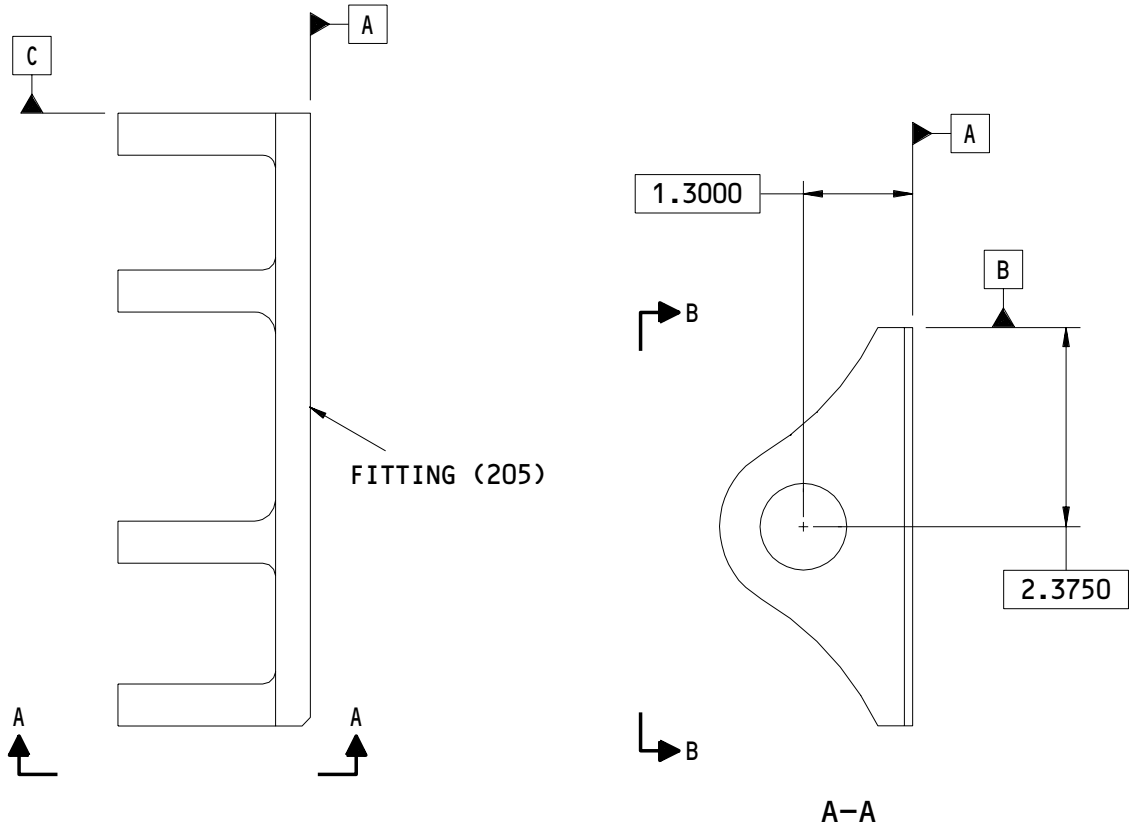
(2) Make oversize bushings (Fig. 602), as necessary to compensate for the material removed in step (1).

(3) Install the bushings as shown in REPAIR 7-1.

3. Refinish (Fig. 601)

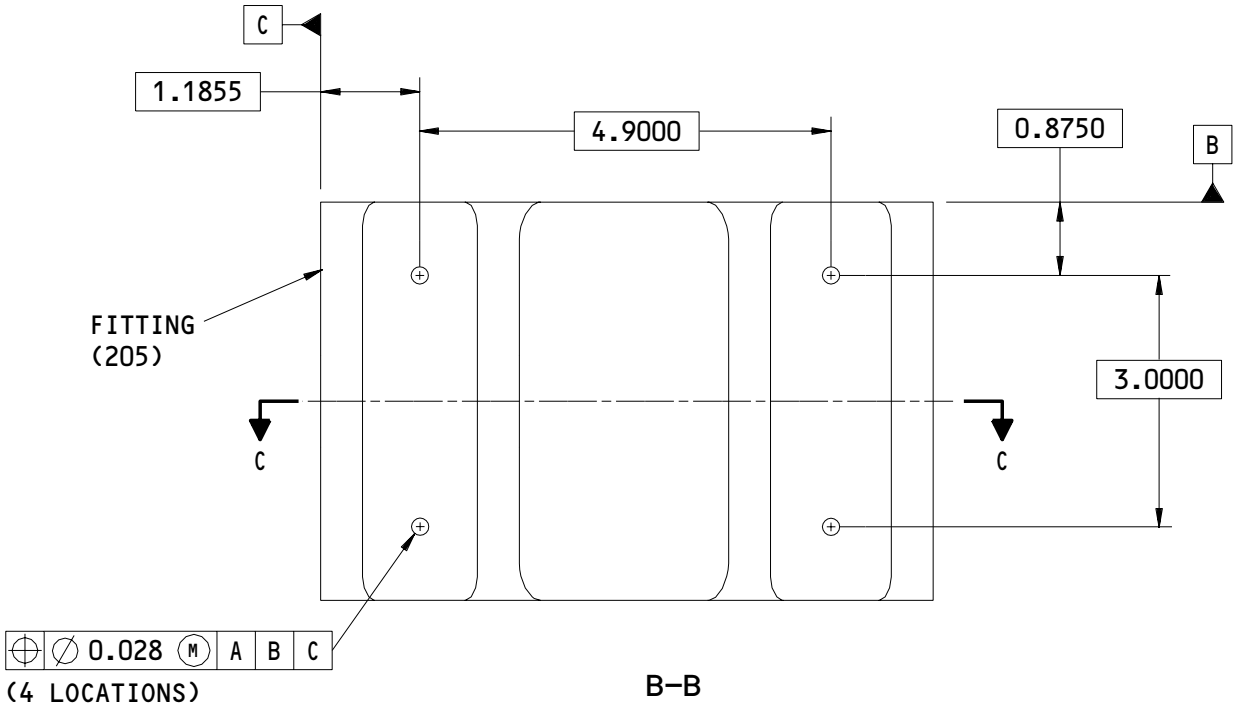
A. Boric acid - sulfuric acid anodize (F-17.31) and apply BMS 10-11, type1 primer (F-20.02) unless shown differently.

B. Apply BMS 10-11, type 2 enamel (F-21.15) but not on the bushings.

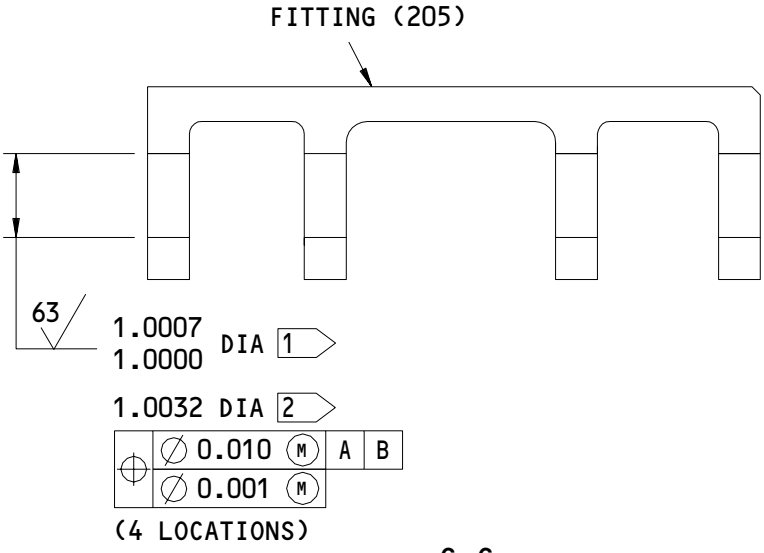


149T6988-7
Fitting Repair
Figure 601 (Sheet 1)

K21932



B–B



C–C

1 DO NOT PUT PRIMER (F-20.02) AND ENAMEL (F-21-15) IN THIS SURFACE

2 REPAIR LIMIT

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

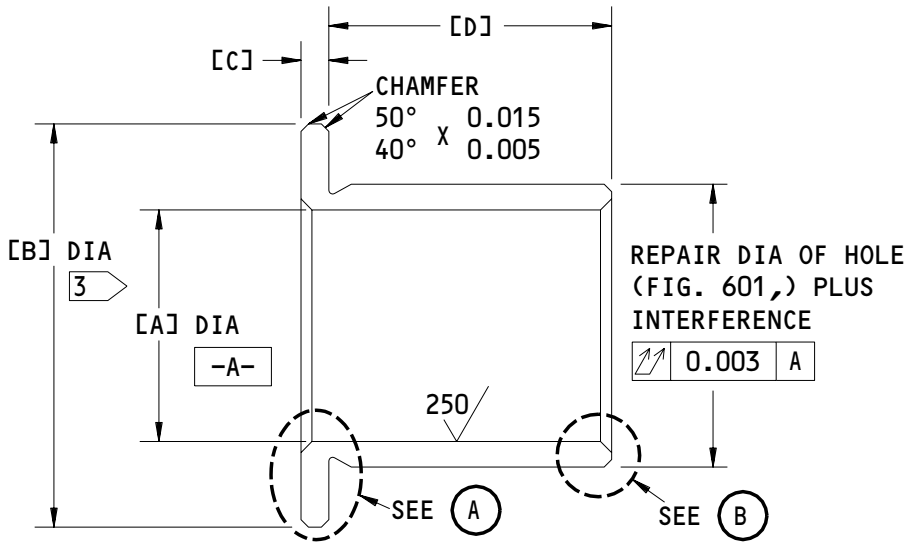
BREAK ALL SHARP EDGES

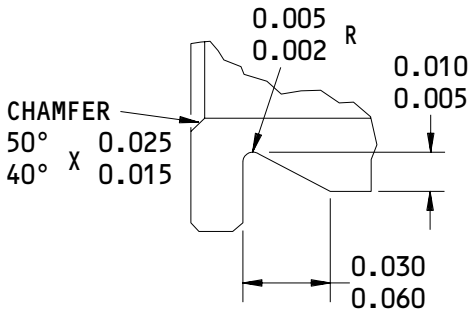
ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

149T6988-7
Fitting Repair
Figure 601 (Sheet 2)

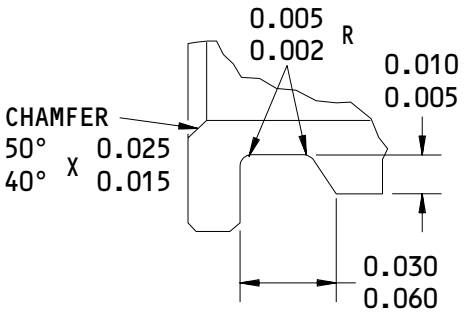
K21938





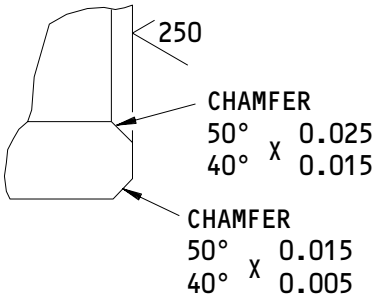
TYPE 1
SINGLE RADIUS

A



TYPE 2
DOUBLE RADII
(OPTIONAL)

A



TYPE 2
CHAMFER RETENTION

B

Oversized Bushing Details
Figure 602 (Sheet 1)

REPLACES BUSHING	[A]	[B]	[C]	[D]	INTER-FERENCE	MATERIAL	FINISH
BACB28AT14D049C (195)	0.864 0.844	1.190 1.180	0.093 0.088	0.049 0.044	0.0010 0.0022	1	2

1 15-5PH CRES AS IN AMS5659 OR 17-4PH CRES AS IN AMS5643

2 CADMIUM PLATE AS SHOWN IN QQ-P-416, TYPE II, CLASS 2 OR ZINC NICKEL PLATE AS SHOWN IN AMS 2417, TYPE 2

3 OUTER DIAMETER OF THE REPLACEMENT BUSHING FLANGE MUST INCREASE IN THE SAME AMOUNT AS THE OUTER DIAMETER OF THE BUSHING SPIGOT

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES 0.005 MAX

DIMENSIONS ARE AFTER PLATING, NOT INCLUDING HOLE [B]

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

Oversized Bushing Details
Figure 602 (Sheet 2)

K21965

SUPPORT ASSEMBLY - REPAIR 8-1

149T7801-17, -18

1. General

A. This procedure has the data necessary to repair the gear support assembly (130, 135).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for details of the SOPM subjects identified in the procedure.

C. Refer to IPL Fig. 1 for item numbers.

2. Bushing Replacement

A. Consumable Materials

NOTE: Equivalent material can be used.

(1) D00633 Grease -- BMS 3-33 (SOPM 20-60-03)

(2) A00359 Sealant -- BMS 5-95 (SOPM 20-60-04)

B. References

(1) SOPM 20-50-03, Bushing and Bearing Replacement

(2) SOPM 20-50-07, Lubrication

(3) SOPM 20-60-03, Lubricants

(4) SOPM 20-60-04, Miscellaneous Materials

C. Procedure (Fig. 601)

(1) Remove replacement bushing(s) (140, 145, 150) from the support fitting (160).

(2) If you find defects on the fitting surfaces, refer to REPAIR 8-2 for repair instructions.

(3) Install replacement bushing(s) (140, 145) into the support fitting (160) with BMS 5-95 sealant by the shrink-fit procedure (SOPM 20-50-03).

(4) Install replacement bushing(s) (150) into the support fitting (160) with BMS 3-33 grease by the shrink-fit procedure (SOPM 20-50-03).

(5) If necessary, machine the bushing(s) (140, 145, 150) to design dimensions and finish.

(6) Apply BMS 5-95 fillet sealant to the edges of the bushings.

3. Lube Fitting Replacement

A. Consumable Materials

NOTE: Equivalent material can be used.

(1) D00633 Grease -- BMS 3-33 (SOPM 20-60-03)

B. References

(1) SOPM 20-50-01, Bolt and Nut Installation

(2) SOPM 20-50-07, Lubrication

(3) SOPM 20-60-03, Lubricants

C. Procedure (Fig. 601)

(1) Remove the lube fittings (155) from the support fitting (160).

(2) Install replacement lube fittings (155) onto the support fitting (160) with BMS 3-33 grease. Tighten the lube fitting(s) (155) to 25-30 pound-inches.

(3) Make sure that the lube passage is not blocked. Apply BMS 3-33 grease to the lube fitting (155) until grease appears in the inside diameter if the bushing(s) (150).

4. Link Assembly Refinish

A. Consumable Materials

NOTE: Equivalent material can be used.

(1) C00260 Enamel -- BMS 10-11, Type 2 (SOPM 20-60-02)

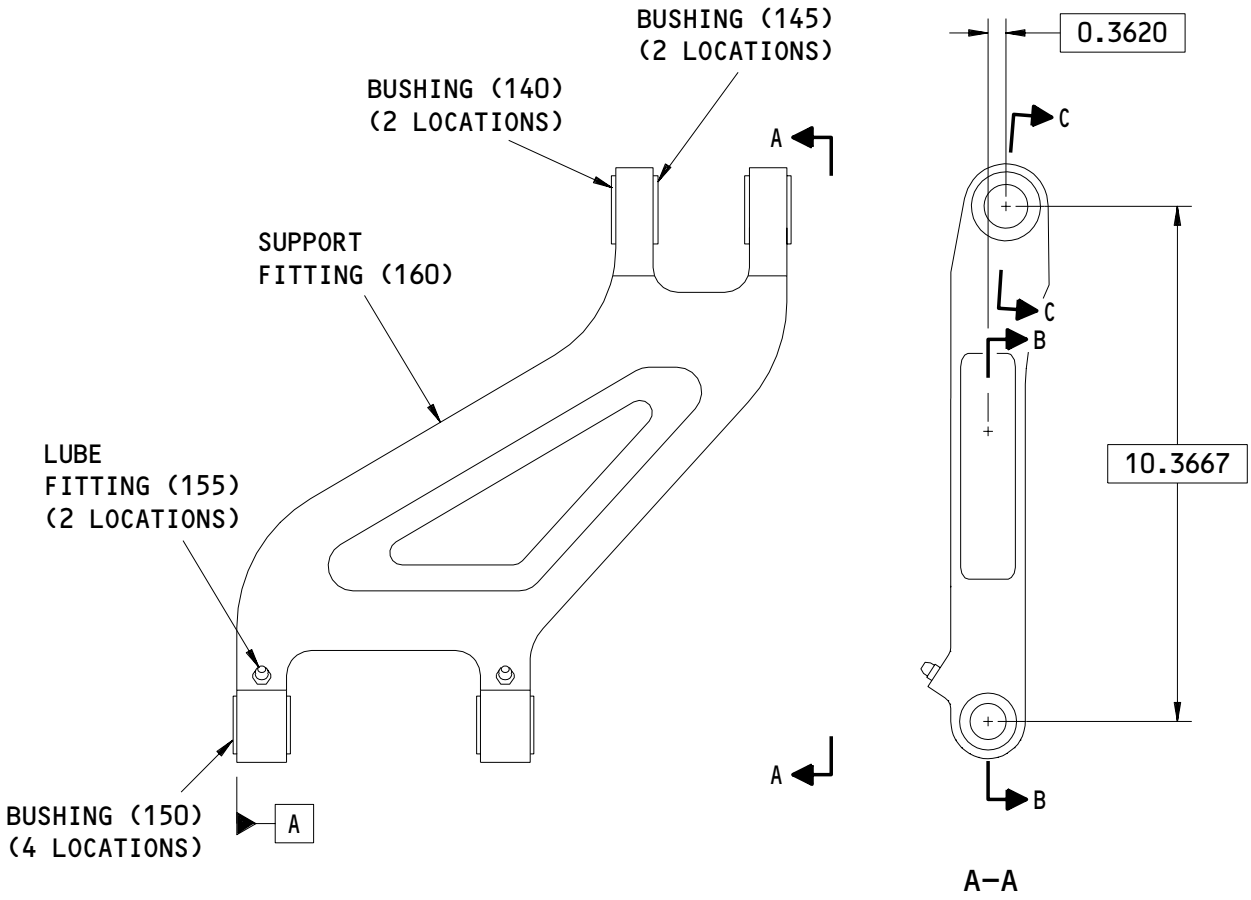
B. References

(1) SOPM 20-30-03, General Cleaning Procedures

(2) SOPM 20-60-02, Finishing Materials

C. Procedure

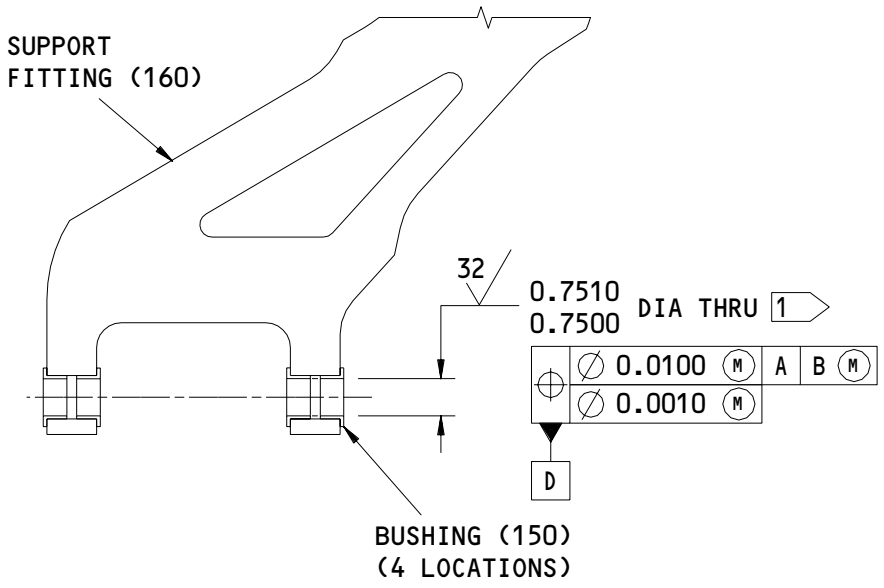
(1) Apply BMS 10-11, type 2 enamel (F-21.17) but not on the bushing flanges or lube fittings.



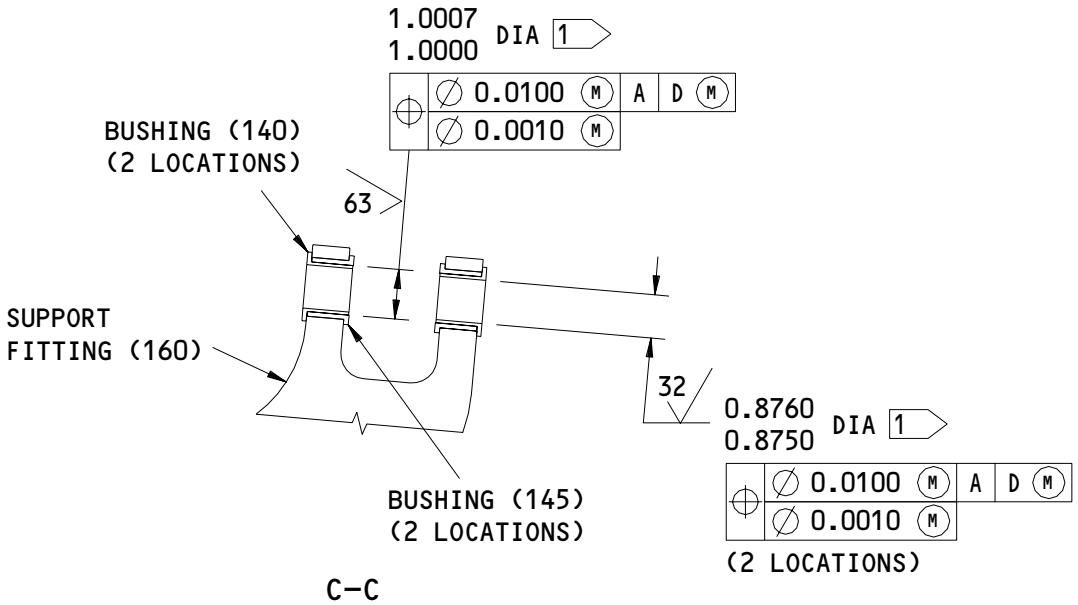
149T7801–17 SHOWN
149T7801–18 OPPOSITE

149T7801–17,–18
Support Gear Assembly
Figure 601 (Sheet 1)

K22056



B–B



C–C

1 INSTALLED DIMENSION. SIZE IF NECESSARY

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

149T7801-17,-18
Support Gear Assembly
Figure 601 (Sheet 2)

K22090

SUPPORT FITTING - REPAIR 8-2

149T7801-19, -20

1. General

A. This procedure has the data necessary to repair and refinish the support fitting (160, 165).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for details of the SOPM subjects identified in the procedure.

C. Refer to IPL Fig. 1 for item numbers.

D. General repair details:

(1) Materials: Aluminum alloy

(2) Shot Peen: All surfaces, but not in hole surfaces
Intensity 0.012A2

2. Support Fitting Repair

A. Consumable Materials

NOTE: Equivalent material can be used.

(1) C00259 Primer -- BMS 10-11, Type 1 (SOPM 20-60-02)

B. References

(1) SOPM 20-10-03, Shot Peening

(2) SOPM 20-30-02, Stripping of Protective Finishes

(3) SOPM 20-30-03, General Cleaning Procedures

(4) SOPM 20-41-01, Decoding Table for Boeing Finish Codes

(5) SOPM 20-41-02, Application of Chemical and Solvent Resistant Finishes

(6) SOPM 20-43-01, Chromic Acid Anodizing

(7) SOPM 20-60-02, Finishing Materials

C. Procedure (Fig. 601)

(1) Machine as necessary, within repair limits, to remove defects.

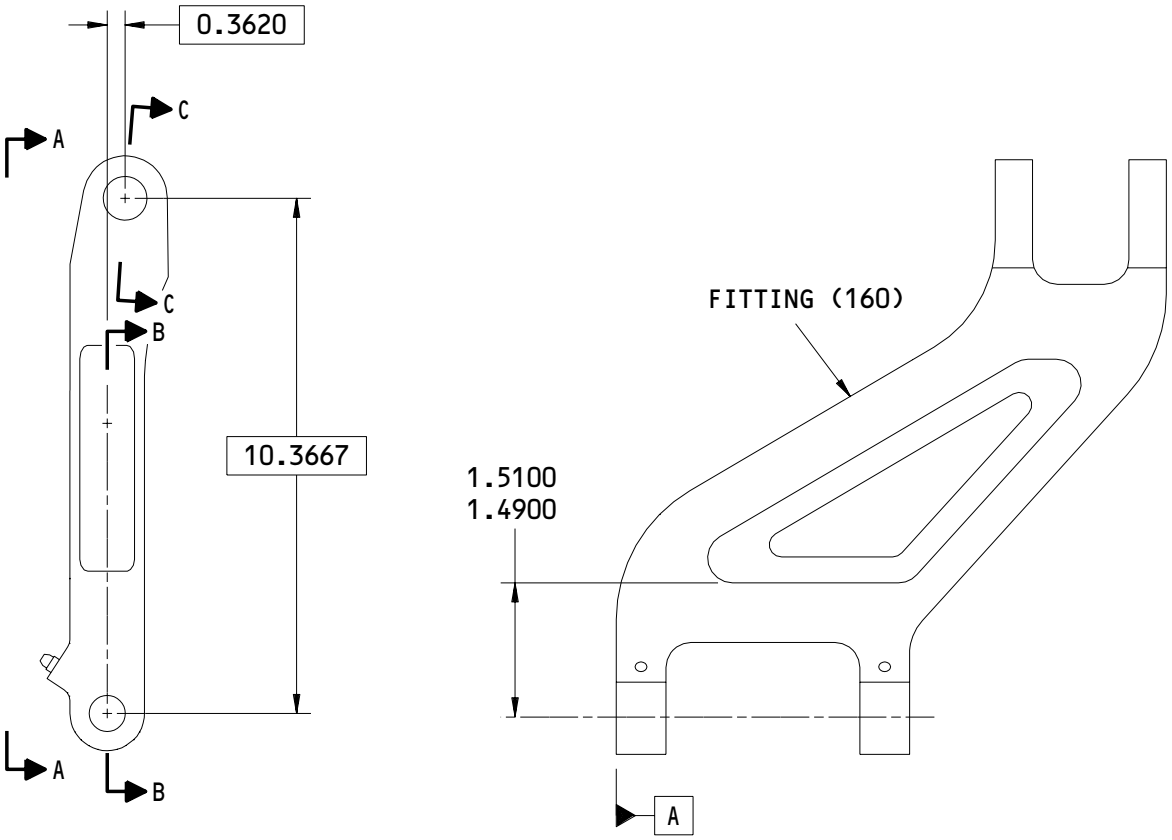
(2) Refinish as indicated.

(3) Make oversize bushings (Fig. 602), as necessary to adjust for the material removed in step (1).

(4) Install the bushings as shown in REPAIR 8-1.

3. Refinish (Fig. 601)

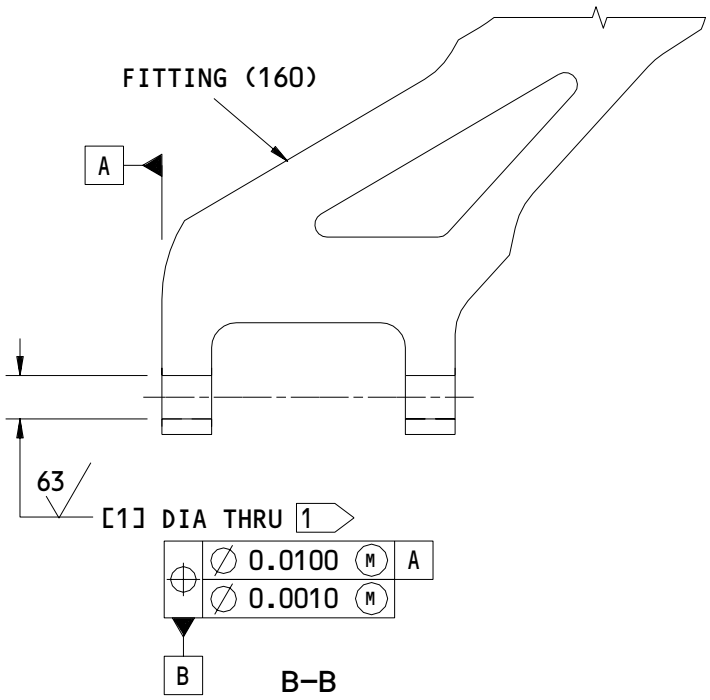
A. Boric acid - sulfuric acid anodize (F-17.31) and apply BMS 10-11, type 1 primer (F-20.03) unless shown differently.

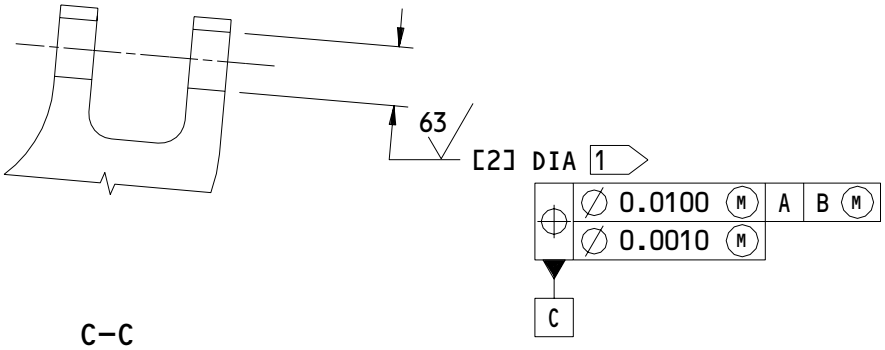


149T7801–19 SHOWN
149T7801–20 OPPOSITE

149T7801–19,–20
Support Fitting
Figure 601 (Sheet 1)

K22134





149T7801-19,-20
Support Fitting
Figure 601 (Sheet 2)

K22148

REFERENCE NUMBER	[1]	[2]
DESIGN DIMENSION	0.8757 0.8750	1.1882 1.1875
REPAIR LIMIT 2	0.8777 MAX	1.1907 MAX

1 DO NOT PUT PRIMER (F-20.03) IN THIS SURFACE

2 REPAIR LIMIT

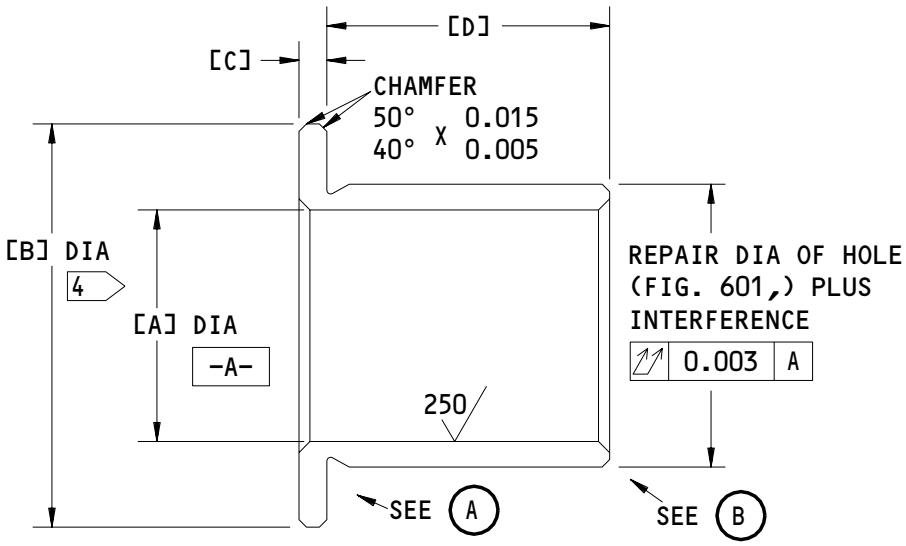
125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

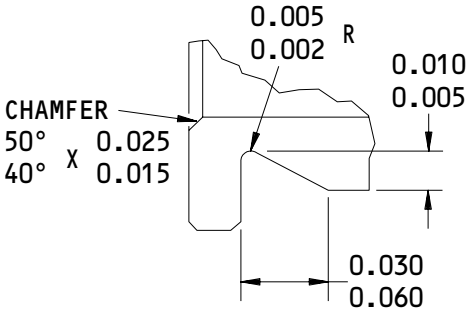
BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

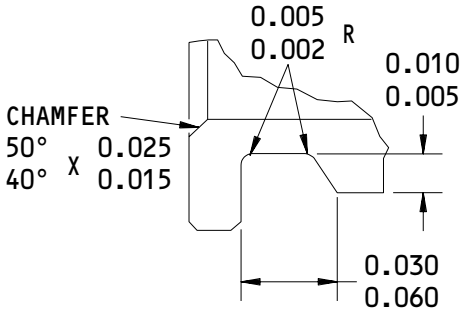
149T7801-19,-20
Support Fitting
Figure 601 (Sheet 3)





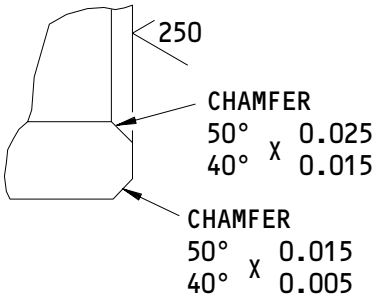
TYPE 1
SINGLE RADIUS

A



TYPE 2
DOUBLE RADII
(OPTIONAL)

A



TYPE 2
CHAMFER RETENTION

B

Oversized Bushing Details
Figure 602 (Sheet 1)

K21951

HOLE LOCATION (FIG. 601)	REPLACES BUSHING	[A]	[B]	[C]	[D]	INTER-FERENCE	MATERIAL	FINISH
[1]	BACB28AU12BO40C (150)	0.739 0.734	1.190 1.180	0.080 0.075	0.400 0.350	0.0008 0.0020	1	3
[2]	BACB28AT16DO74C (145)	0.988 0.969	1.400 1.390	0.105 0.100	0.750 0.740	0.0012 0.0025	2	3

1 ALUMINUM-BRONZE HEAT TREAT HR50 OR TQ50 AS IN AMS4640

2 17-4PH OR 15-5PH CRES 40-43HRC (180-200 KSI)

3 CADMIUM PLATE AS SHOWN IN QQ-P-416, TYPE II,CLASS 2 OR ZINC NICKEL PLATE AS SHOWN IN AMS 2417, TYPE 2

4 OUTER DIAMETER OF THE REPLACEMENT BUSHING FLANGE MUST INCREASE IN THE SAME AMOUNT AS THE OUTER DIAMETER OF THE BUSHING SPIGOT

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES 0.005 MAX

DIMENSIONS ARE AFTER PLATING, NOT INCLUDING HOLE [B]

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

Oversized Bushing Details
Figure 602 (Sheet 2)

K21956

ASSEMBLY

1. General

   A. This procedure has the necessary data necessary to assemble the main landing gear hinge bellcrank assembly.

   B. Refer to the Standard Overhaul Practices Manual (SOPM) for details of the SOPM subjects identified in the procedure.

   C. Refer to IPL Fig. 1 for item numbers.

2. Assembly

   A. References

      (1) SOPM 20-50-01, Bolt and Nut Installation

   B. Procedure

      (1) Use standard industry procedures and the steps shown below to assemble this component.

      (2) If necessary, install the pads (600, 615 or 620) onto the aft center hinge fitting (625 or 630) as follows:

         (a) Apply BMS 5-95 fay surface sealant between the pads (600, 615 or 620) and the aft center hinge fitting (625 or 630).

         (b) Install the pad (600) onto the aft center hinge fitting (625 or 630) with the bolts (590) and the collars (595).

         (c) Install the pad (615 or 620) onto the aft center hinge fitting (625 or 630) with the bolts (605), and the collars (610).

      (3) Install the bushings (545) onto the center forward hinge assembly (550) and the center aft hinge assembly (580) with BMS 5-95 sealant by the press-fit procedure (SOPM 20-50-03).

      (4) Apply BMS 5-95 sealant to bolts (490, 495) before installation.

(5) Install the bracket assembly (505) onto the center aft hinge assembly (580) with the bolts (490, 495) and the collars (500) as shown in Fig. 701, view A-A.

(6) Apply BMS 3-33 grease to the bolts (445) and the bushings (455).

(7) Install the cross link assembly (470) onto the center forward hinge assembly (550) and the center aft hinge assembly (580) with the bolts (445), the washers (450, 460), the bushings (455), and the nuts (465) as shown in Fig. 701, view B-B.

(8) If necessary, assemble the stop assembly (410) as follows:

(a) Position the filler (440), the shim (435), and the pad (430) onto the stop (442).

(b) Install the bolts (415), the washers (420), and the nuts (425) onto the pad (430) and the stop (442).

(9) Adjust the gap with shim(s) (405) as shown.

(10) Install the shims (405) and the stop assembly (410) onto the center forward hinge assembly (550) and the center aft hinge assembly (580) with the bolts (395) and the collars (400) as shown in Fig. 701, view C-C.

(11) Adjust the gap with shim(s) (385) as shown.

(12) Install the shims (385) and the stabilizer tie (390) onto the center forward hinge assembly (550) and the center aft hinge assembly (580) with the bolts (375) and the collars (380) as shown in Fig. 701, view D-D.

(13) Install the bushings (307, 312) onto the center forward hinge assembly (550) and the center aft hinge assembly (580) with BMS 5-95 sealant by the shrink-fit procedure (SOPM 20-50-03). If necessary, machine the bushings (307) to dimensions shown in Fig. 701, view E-E.

(14) Apply BMS 3-33 grease to the bolt (315).

(15) Install the bellcrank assembly (335) from the center forward hinge assembly (550) and the center aft hinge assembly (580) with the bolt (315), the washers (320, 325), and the nut (330).

(16) Tighten the nut (330) to 180-240 pound-inches. Back off the nut to the nearest slot and install the cotter pin (310).

(17) Apply BMS 3-33 grease to the bolt (215) before installation.

(18) If necessary, Install the main landing gear actuator onto the bellcrank assembly (335) with the bolt (215), the washers (220, 225, 235), and the nut (230) as shown in Fig. 701, view F-F.

(19) Tighten the nut (230) to 180-240 pound-inches. Back off the nut to the nearest slot and install the cotter pin (210).

(20) If necessary, assemble the push rod assembly (240) as follows:

(a) Install the lock nut (245) fully onto the sleeve (305).

(b) Put the lock washer (250) on the face of the hex and of the rod end assembly (255).

(c) Install the sleeve (305) with the lock nut (245) into the rod end assembly (255) and lock washer (250). Turn the sleeve (305) in until it gets to the bottom in the rod end assembly (255) then back it out one full turn.

(d) Install the lock nut (275) fully onto the threaded portion of the rod end assembly (285).

(e) Put the lock washer (280) on the face of the hex end of the sleeve (305).

(f) Install the rod end (285) with the lock nut (275) into the above assembly. Turn the rod end (285) with the lock nut (275) in until the distance between centers is within the dimension shown in Fig. 702 and with the rod ends aligned as shown within ±2 degrees.

(g) For final adjustment, turn the sleeve (305) up to 1/4 turn in the clockwise or counter clockwise direction. Keep the rod ends parallel to within ±2 degrees. Tighten the lock nuts (245, 275) to 20-30 pound-feet. Do not break the lock washers (250) into the lock nuts (245, 275).

(21) Apply BMS 3-33 grease to the bolt (215) before installation.

(22) Install the push rod assembly (240) onto the bellcrank assembly (335) with the bolt (215), the washers (220, 225, 235), and the nut (230) as shown in Fig. 701, view F-F.

(23) Tighten the nut (230) to 180-240 pound-inches. Back off the nut to the nearest slot and install the cotter pin (210).

(24) Adjust shim(s) (180, 185) as shown.

(25) Install the fitting assembly (190) onto the center aft hinge assembly (580) with the shims (180, 185), the bolts (170), and the collars (175) as shown in Fig. 701, view G-G.

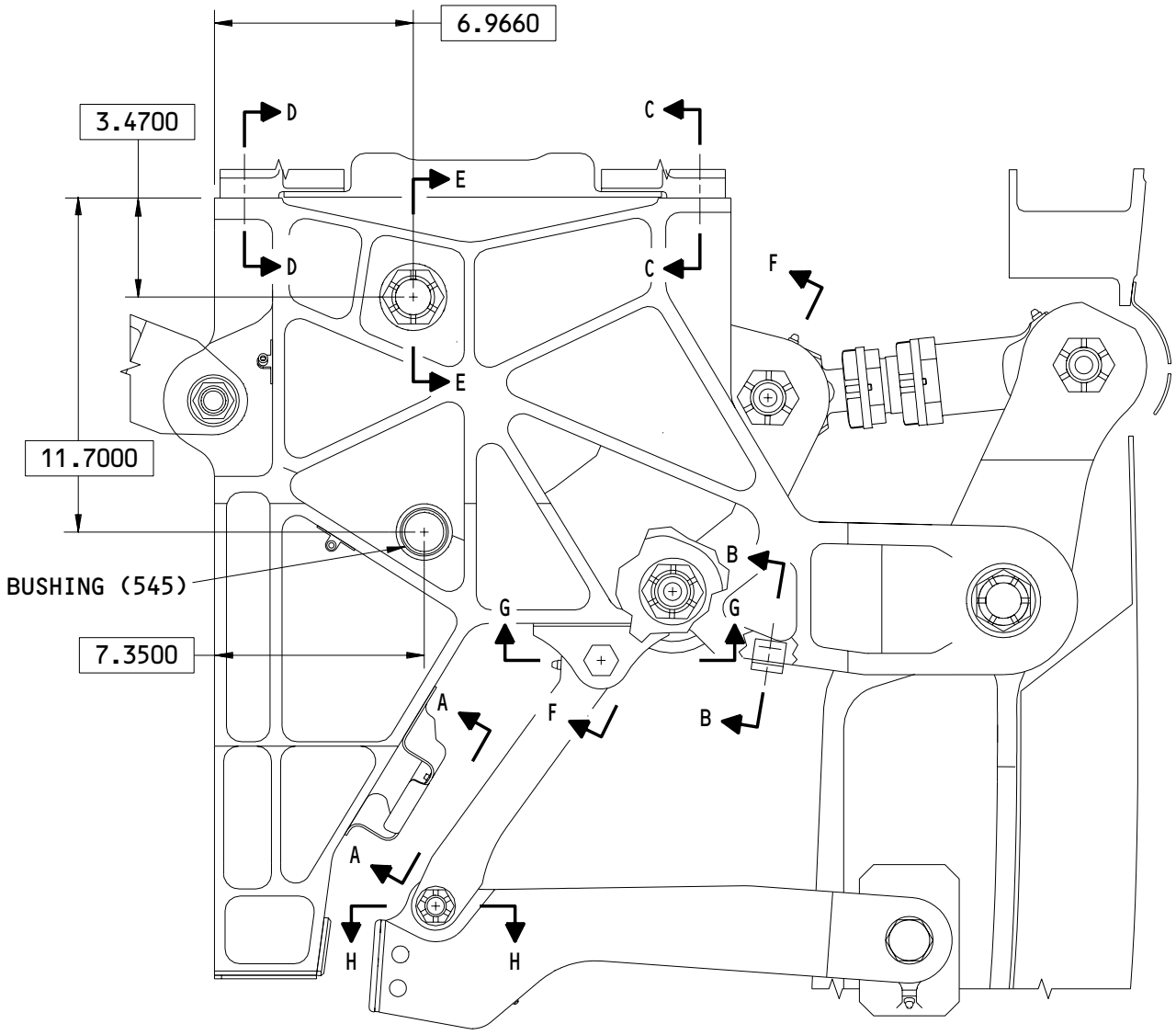
(26) Apply BMS 3-33 grease to the bolt (110) before installation.

(27) Install the gear support assembly (130) onto the fitting assembly (190) with the bolt (110), the washers (115, 120), the nuts (125) and cotter pins (105).

(28) Apply BMS 3-33 grease to the bolt (15) before installation.

(29) Install the link assembly (35) onto the gear support assembly (130) with the bolt (15), the washers (20, 25), and the nut (30) as shown in Fig. 701, view H-H.

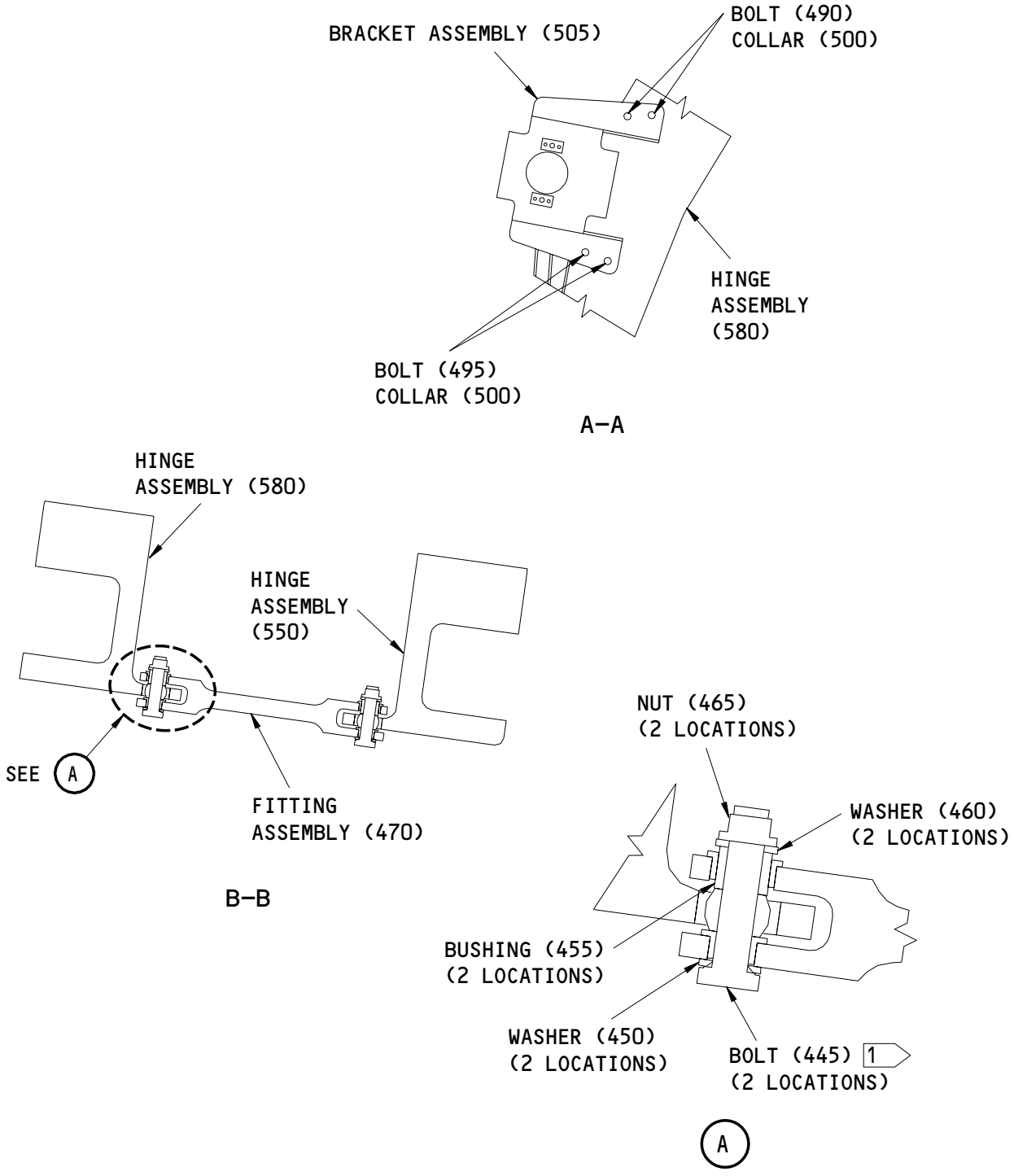
(30) Tighten the nut (30) to 180-240 pound-inches. Back off the nut to the nearest slot and install the cotter pin (10).



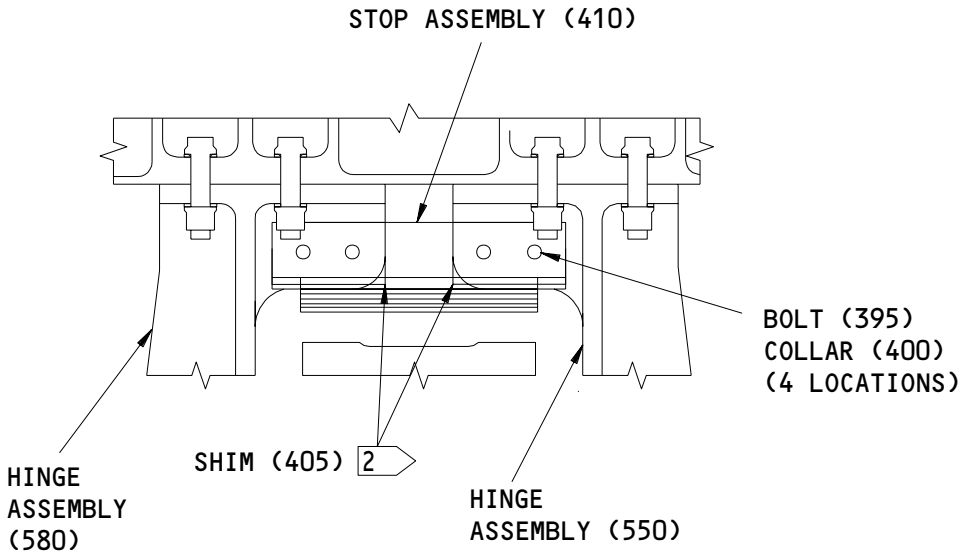
149T6080-7 SHOWN
149T6080-8 OPPOSITE

149T6080-7,-8
Hinge Bell Crank Assembly
Figure 701 (Sheet 1)

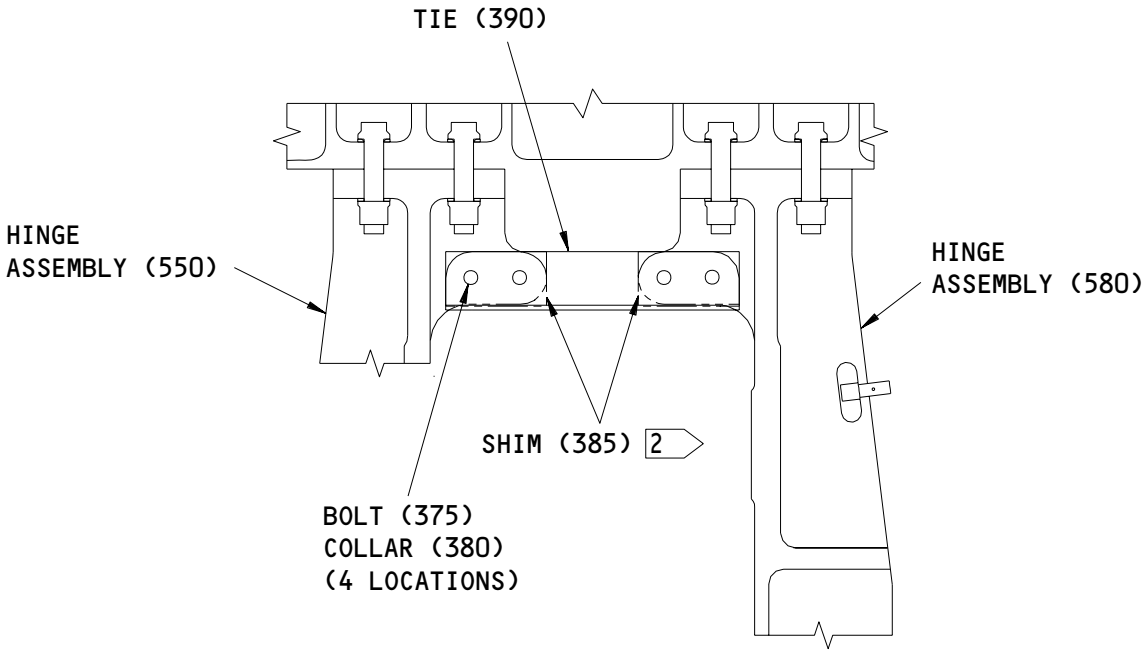
K22379



149T6080-7,-8
Hinge Bell Crank Assembly
Figure 701 (Sheet 2)



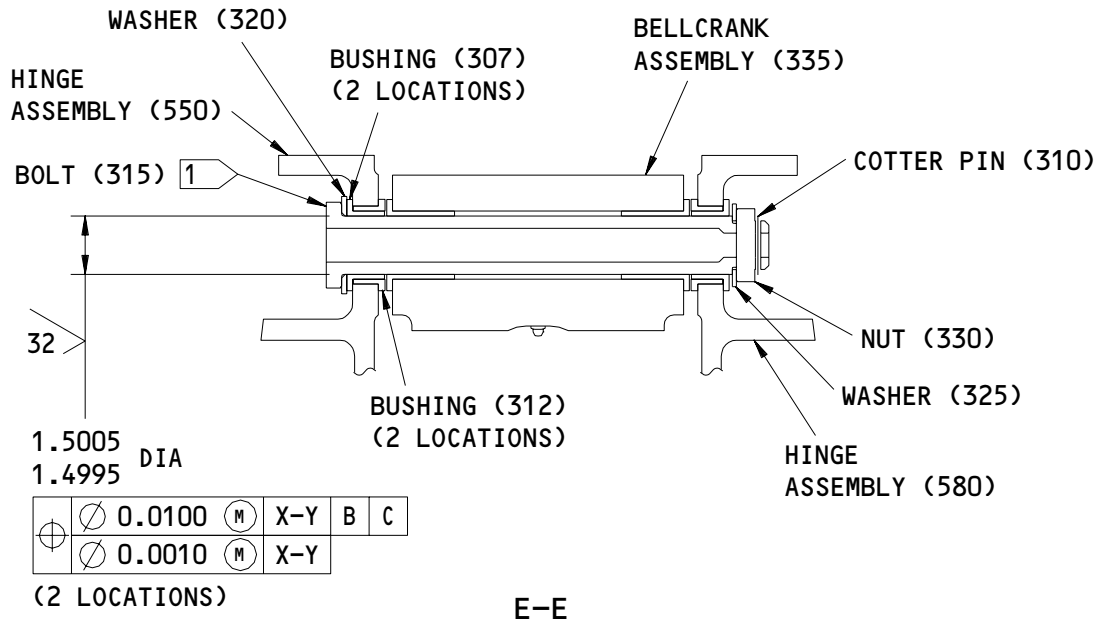
C–C



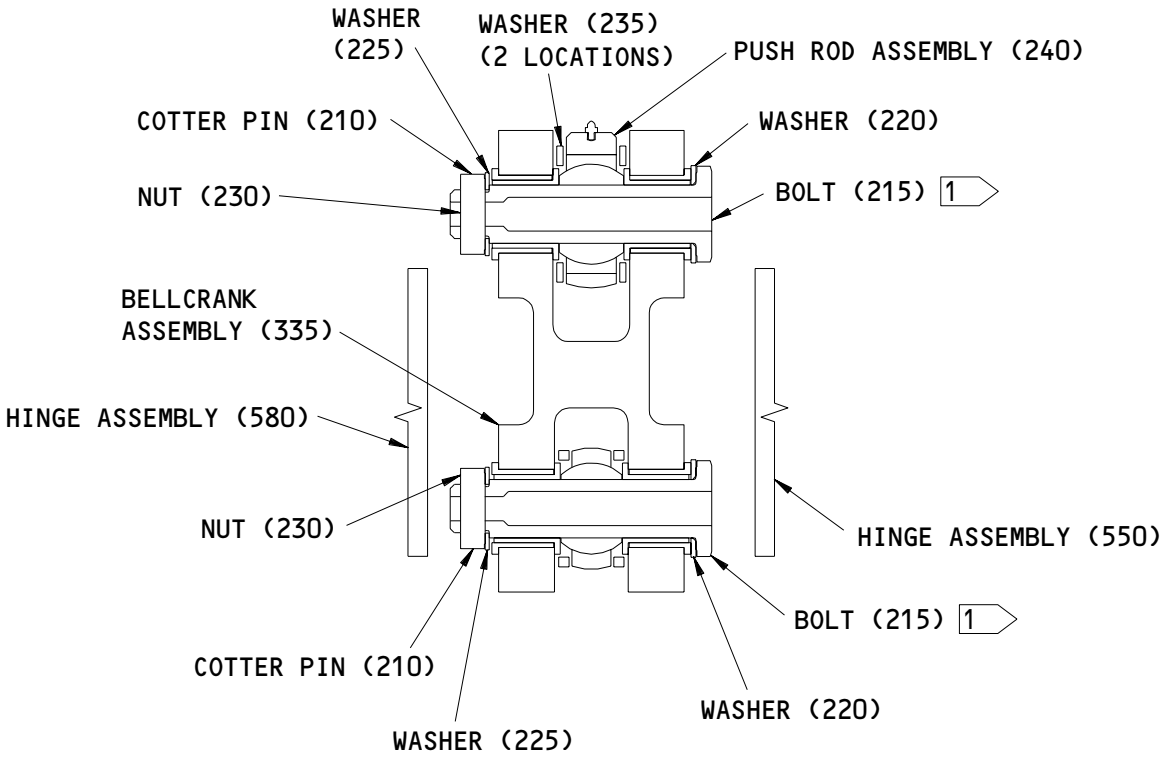
D–D

149T6080-7,-8
Hinge Bell Crank Assembly
Figure 701 (Sheet 3)

K22448



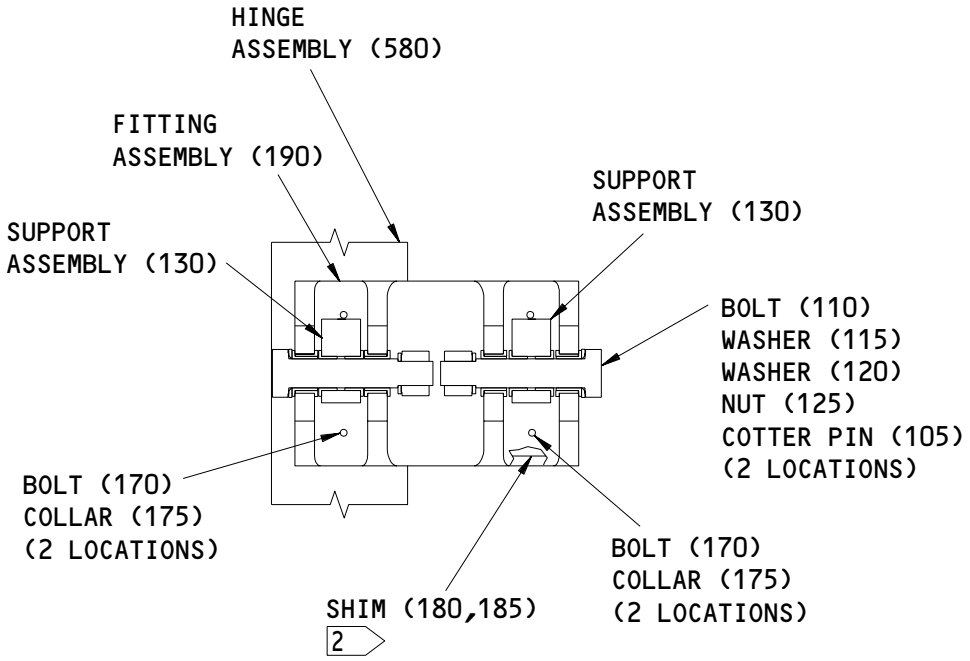
E–E



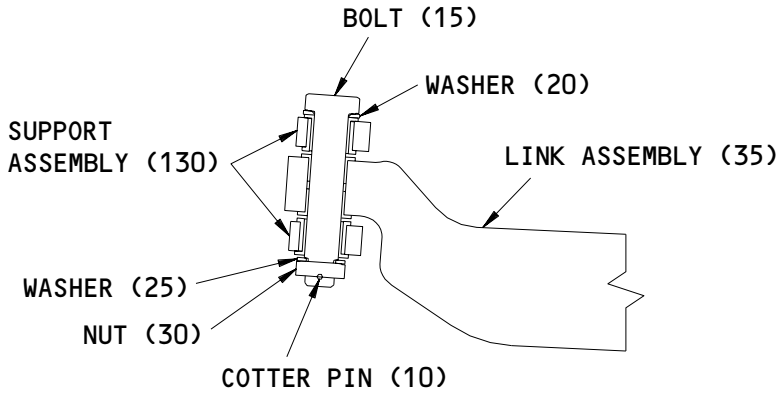
F–F

149T6080-7,-8
Hinge Bell Crank Assembly
Figure 701 (Sheet 4)

K22477



G–G



H–H

1 BOLT HEAD NEAR SIDE

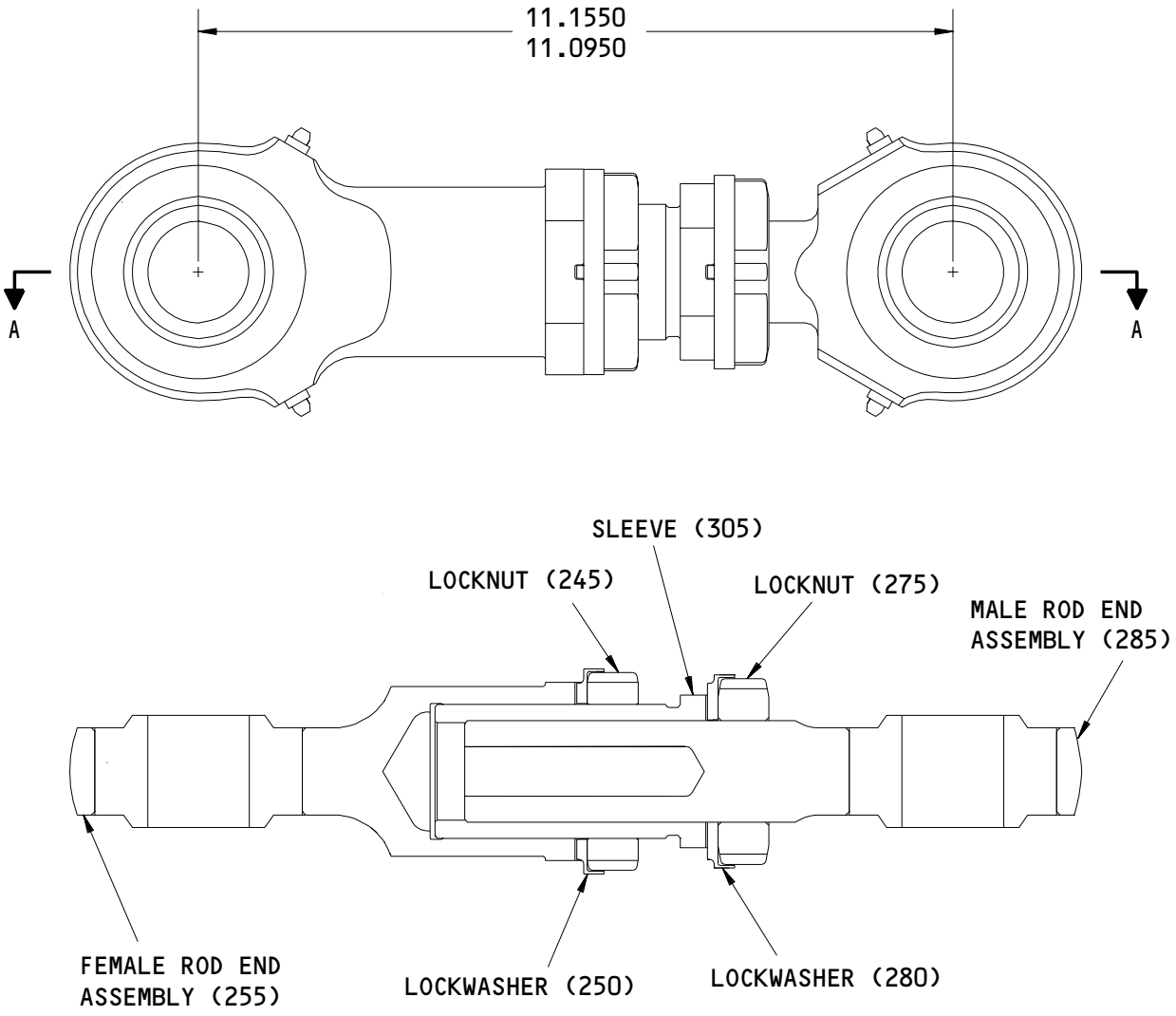
2 INSTALL SHIM ON EITHER SIDE ONLY WHEN NECESSARY. PEEL 0.003 INCH LAMINATION TO ADJUST THE GAP TO A MAXIMUM OF 0.005 INCH. APPLY FINISH (F-20.05) AFTER DELAMINATION

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

149T6080-7,-8
Hinge Bell Crank Assembly
Figure 701 (Sheet 5)

K22492

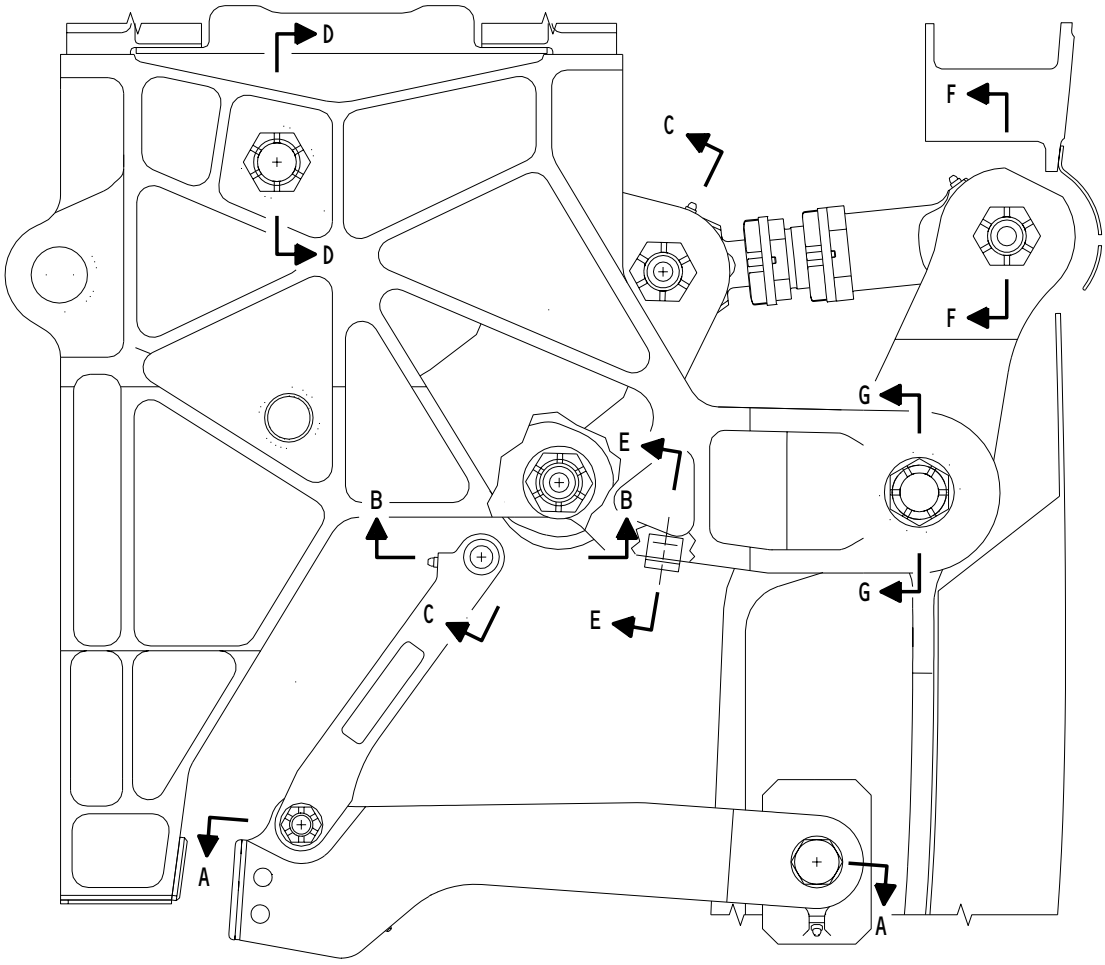


A–A

ITEM NUMBERS REFER TO IPL FIG. 1

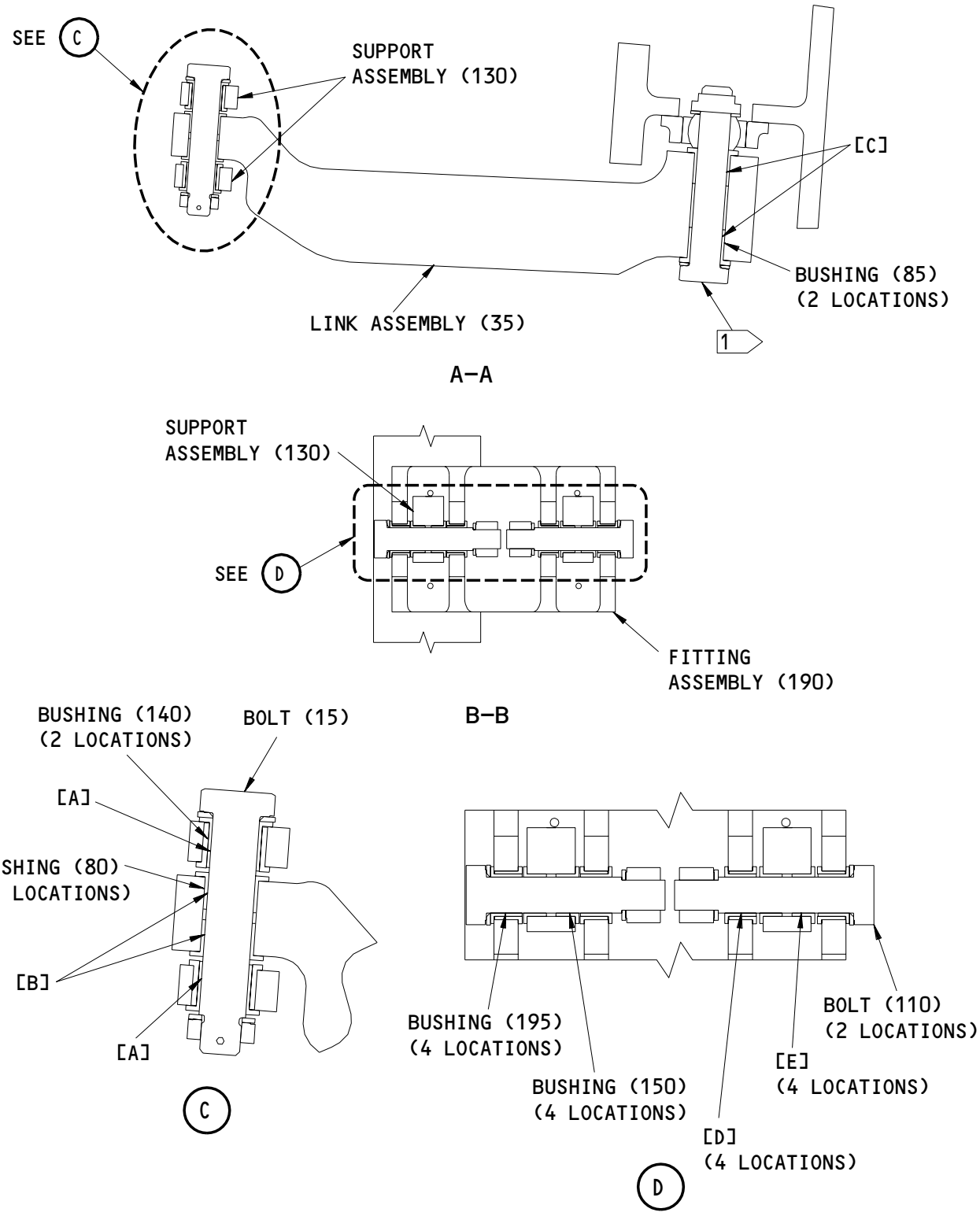
ALL DIMENSIONS ARE IN INCHES

149T6956-5
Push Rod Assembly
Figure 702



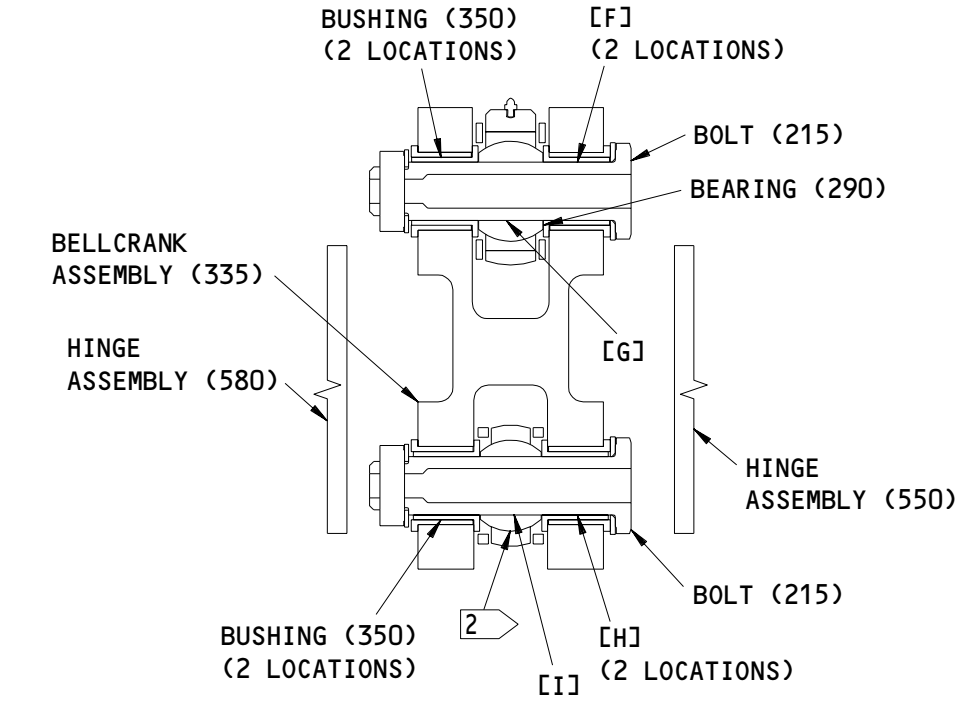
Fits and Clearances
Figure 801 (Sheet 1)

K22511

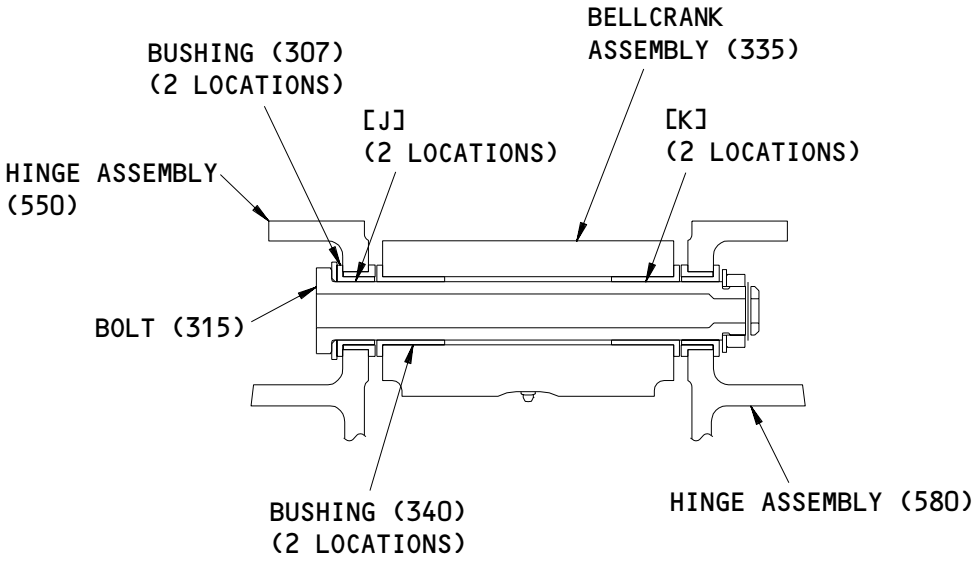


Fits and Clearances
Figure 801 (Sheet 2)

K22542



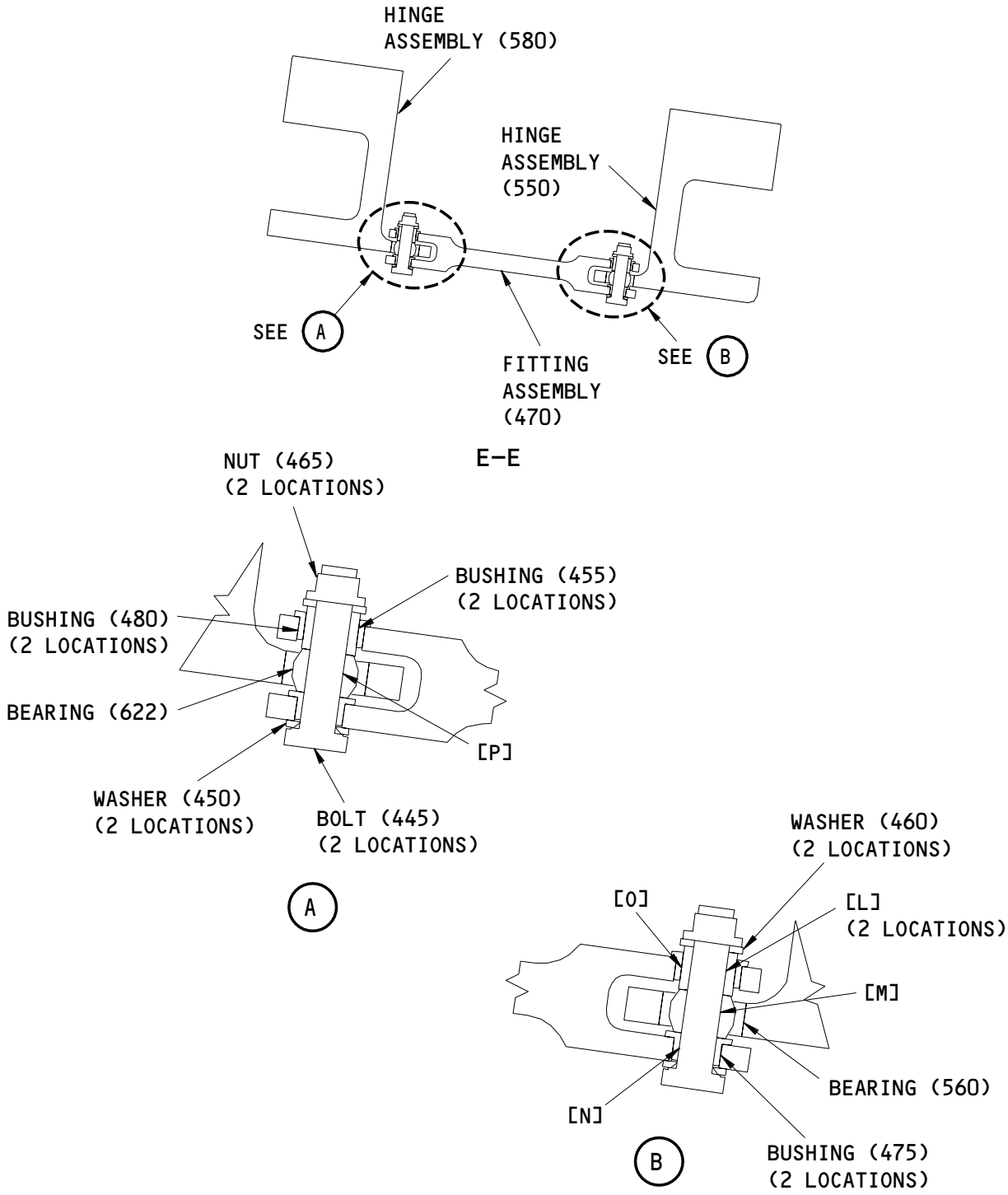
C–C



D–D

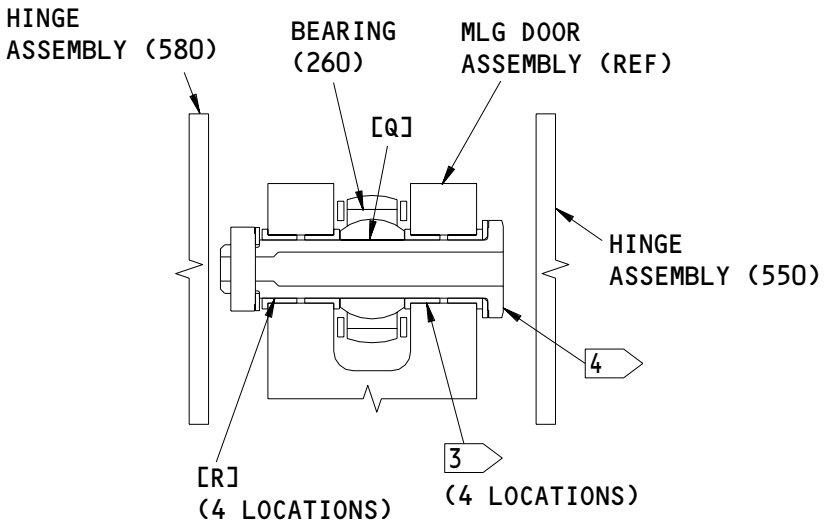
Fits and Clearances
Figure 801 (Sheet 3)

K22564

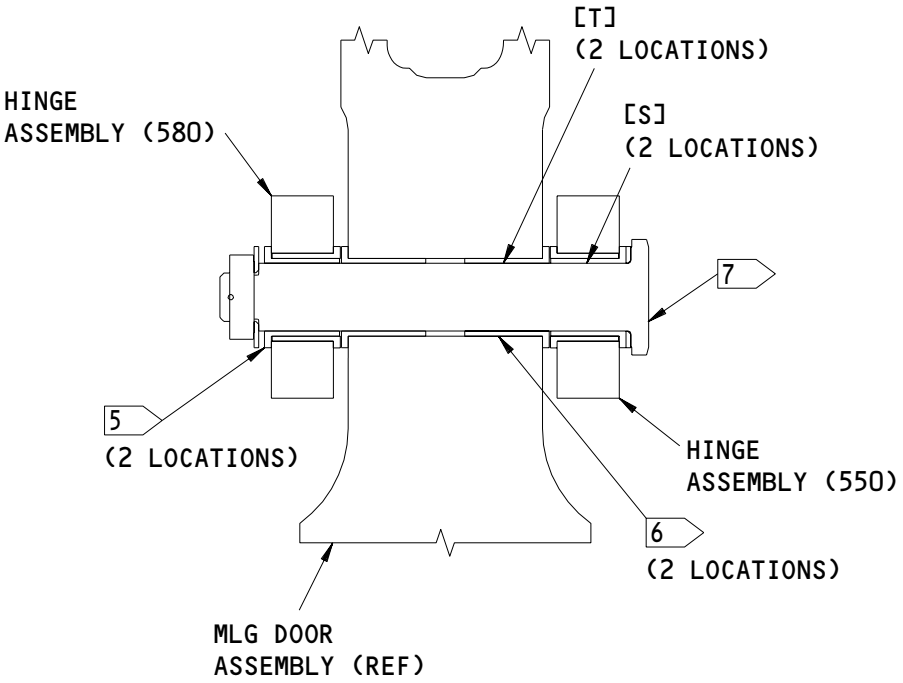


Fits and Clearances
Figure 801 (Sheet 4)

K22583



F–F



G–G

ITEM NUMBERS REFER TO IPL FIG. 1

Fits and Clearances
Figure 801 (Sheet 5)

K22584

REF LETTER	REF IPL FIG. 1, MATING ITEM NO.	DESIGN DIMENSION*				SERVICE WEAR LIMIT*		
		DIMENSION		ASSEMBLY CLEARANCE		DIMENSION		MAXIMUM CLEARANCE
		MIN	MAX	MIN	MAX	MIN	MAX	
[A]	ID 140	0.8750	0.8760		0.0030		0.8790	0.0050
	OD 15	0.8730	0.8740	0.0010		0.8700		
[B]	ID 80	0.8750	0.8760		0.0030		0.8790	0.0050
	OD 15	0.8730	0.8740	0.0010		0.8700		
[C]	ID 85	0.9995	1.0003		0.0023		1.0042	0.0052
	OD 1	0.9980	0.9990	0.0005		0.9943		
[D]	ID 200	0.7500	0.7510		0.0030		0.7540	0.0050
	OD 110	0.7480	0.7490	0.0010		0.7450		
[E]	ID 150	0.7500	0.7510		0.0030		0.7540	0.0050
	OD 110	0.7480	0.7490	0.0010		0.7450		
[F]	ID 350	1.4995	1.5005		0.0030		1.5053	0.0063
	OD 215	1.4975	1.4990	0.0005		1.4932		
[G]	ID 290	1.5000	1.5005		0.0030		1.5055	0.0063
	OD 215	1.4975	1.4990	0.0010		1.4937		
[H]	ID 350	1.4995	1.5005		0.0030		1.5053	0.0063
	OD 215	1.4975	1.4990	0.0005		1.4932		

* ALL DIMENSIONS ARE IN INCHES

1 > INSTALLATION BOLT 149T6986-11

2 > MAIN LANDING GEAR DOOR HINGE BEARING 27OT0002-42

3 > MAIN LANDING GEAR DOOR HINGE BUSHING BACB28AT24B075C

4 > INSTALLATION BOLT 149T6985-12

5 > INSTALLATION BUSHING 149T6942-3

6 > MAIN LANDING GEAR DOOR HINGE BUSHING BACB28AU2B200C

7 > INSTALLATION BOLT 149T6985-13

Fits and Clearances
Figure 801 (Sheet 6)

K22620

REF LETTER	REF IPL FIG. 1, MATING ITEM NO.	DESIGN DIMENSION*				SERVICE WEAR LIMIT*		
		DIMENSION		ASSEMBLY CLEARANCE		DIMENSION		MAXIMUM CLEARANCE
		MIN	MAX	MIN	MAX	MIN	MAX	
[I]	ID 2	1.4995	1.5000		0.0025		1.5053	0.0063
	OD 215	1.4975	1.4990	0.0005		1.4932		
[J]	ID 307	1.4995	1.5005		0.0030		1.5053	0.0063
	OD 315	1.4975	1.4990	0.0005		1.4932		
[K]	ID 340	1.4995	1.5005		0.0030		1.5053	0.0063
	OD 315	1.4750	1.4990	0.0005		1.4932		
[L]	ID 455	0.3750	0.3755		0.0020		0.3799	0.0054
	OD 445	0.3735	0.3745	0.0005		0.3696		
[M]	ID 560	0.3750	0.3755		0.0020		0.3799	0.0054
	OD 445	0.3735	0.3745	0.0005		0.3696		
[N]	ID 475	0.3590	0.3669		0.0020		0.3799	0.0054
	OD 445	0.3735	0.3745	0.0005		0.3696		
[O]	ID 480	0.5620	0.5627		0.0017		0.5680	0.0065
	OD 455	0.5610	0.5615	0.0005		0.5555		
[P]	ID 622	0.3750	0.3755		0.0020		0.3799	0.0054
	OD 445	0.3735	0.3745	0.0005		0.3696		

* ALL DIMENSIONS ARE IN INCHES

1 > INSTALLATION BOLT 149T6986-11

2 > MAIN LANDING GEAR DOOR HINGE BEARING 27OT0002-42

3 > MAIN LANDING GEAR DOOR HINGE BUSHING BACB28AT24B075C

4 > INSTALLATION BOLT 149T6985-12

5 > INSTALLATION BUSHING 149T6942-3

6 > MAIN LANDING GEAR DOOR HINGE BUSHING BACB28AU2B200C

7 > INSTALLATION BOLT 149T6985-13

Fits and Clearances
Figure 801 (Sheet 7)

K40483

REF LETTER	REF IPL FIG. 1, MATING ITEM NO.	DESIGN DIMENSION*				SERVICE WEAR LIMIT*		
		DIMENSION		ASSEMBLY CLEARANCE		DIMENSION		MAXIMUM CLEARANCE
		MIN	MAX	MIN	MAX	MIN	MAX	
[Q]	ID 260	1.5000	1.5005		0.0030		1.5053	0.0063
	OD 4	1.4975	1.4990	0.0010		1.4937		
[R]	ID 3	1.4995	1.5005		0.0030		1.5053	0.0063
	OD 4	1.4975	1.4990	0.0005		1.4932		
[S]	ID 5	1.7495	1.7505		0.0030		1.7562	0.0072
	OD 7	1.7475	1.7490	0.0005		1.7423		
[T]	ID 6	1.7495	1.7505		0.0030		1.7562	0.0072
	OD 7	1.7475	1.7490	0.0005		1.7423		

* ALL DIMENSIONS ARE IN INCHES

1 > INSTALLATION BOLT 149T6986-11

2 > MAIN LANDING GEAR DOOR HINGE BEARING 270T0002-42

3 > MAIN LANDING GEAR DOOR HINGE BUSHING BACB28AT24B075C

4 > INSTALLATION BOLT 149T6985-12

5 > INSTALLATION BUSHING 149T6942-3

6 > MAIN LANDING GEAR DOOR HINGE BUSHING BACB28AU2B200C

7 > INSTALLATION BOLT 149T6985-13

Fits and Clearances
Figure 801 (Sheet 8)

K40504

ILLUSTRATED PARTS LIST

1. This section lists and illustrates replaceable or repairable component parts. The Illustrated Parts Catalog contains a complete explanation of the Boeing part numbering system.

2. Indentures show parts relationships as follows:

    Assembly
      Detail Parts for Assembly
      Subassembly
      Attaching Parts for Subassembly
        Detail Parts for Subassembly

    Detail Installation Parts (Included only if installation parts may be returned to shop as part of assembly)

3. One use code letter (A, B, C, etc.) is assigned in the EFF CODE column for each variation of top assembly. All listed parts are used on all top assemblies except when limitations are shown by use code letter opposite individual part entries.

4. Letter suffixes (alpha-variants) are added to item numbers for optional parts, Service Bulletin modification parts, configuration differences (Except left- and right-hand parts), product improvement parts, and parts added between two sequential item numbers. The alpha-variant is not shown on illustrations when appearance and location of all variants of the part is the same.

5. Service Bulletin modifications are shown by the notations PRE SB XXXX and POST SB XXXX.

    A. When a new top assembly part number is assigned by Service Bulletin, the notations appear at the top assembly level only. The configuration differences at detail part level are then shown by use code letter.

    B. When the top assembly part number is not changed by the Service Bulletin, the notations appear at the detail part level.

6. Parts Interchangeability

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

VENDORS

0PTK6 SPS TECHNOLOGIES INC AEROSPACE PRODUCTS DIV
5195 W 4700 SPO BOX 18459
KEARNS, UTAH 84118

06725 AIR INDUSTRIES CORPORATION
12570 KNOTT STREET
GARDEN GROVE, CALIFORNIA 92641-3932
FORMERLY AIR INDUSTRIES OF CALIF IN GARDENA, CALIF.

11815 CHERRY AEROSPACE FASTENERS DIV OF TEXTRON
1224 EAST WARNER AVENUE PO BOX 2157
SANTA ANA, CALIFORNIA 92707-0157
FORMERLY IN LOS ANGELES, CALIF , FORMERLY CHERRY FASTENERS
TOWNSEND DIV OF TEXTRON INC V71087

15653 KAYNAR TECHNOLOGY KAYNAR DIV
800 SOUTH STATE COLLEGE BLVD PO BOX 3001
FULLERTON, CALIFORNIA 92831-3001
FORMERLY MICRODOT AEROSP LTD VK6405

16746 SPECLINE INCORPORATED
2230 MOUTON DR
CARSON CITY, NV 89706
FORMERLY IN SUN VALLEY, CAIFORNIA

5M902 FAIRCHILD IND INC FAIRCHILD AEROSPACE FASTENER DIV
3016 W LOMITA BLVD
TORRANCE, CALIFORNIA 90505-5103
FMLY IN REDONDO BEACH, CALIF

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

56644 AURORA BEARING CO
970 SOUTH LAKE STREET
AURORA, ILLINOIS 60506-5929

56878 SPS TECHNOLOGIES INC AEROSPACE AND INDUSTRIAL PRODUCTS DIV
HIGHLAND AVENUE
JENKINTOWN, PENNSYLVANIA 19046
FORMERLY STANDARD PRESSED STEEL

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

VENDORS

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

72962 HARVARD INDUSTRIES INC
3 WERNER WAY SUITE 210
LEBANON, NEW JERSEY 08833
FORMERLY AMERACE CORP ESNA DIV
FORMERLY ELASTIC STOP NUT IN UNION, NJ

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

80539 SPS TECHNOLOGIES INC AEROSPACE PRODUCTS DIV
2701 SOUTH HARBOR BOULEVARD PO BOX 1259
SANTA ANA, CALIFORNIA 92702-1259
FORMERLY NUTT-SHEL DIV OF SPC WESTERN CO V80539
AND STANDARD PRESSED STEEL WESTERN DIV V17279

92215 FAIRCHILD IND INC FAIRCHILD AEROSPACE FASTENER DIV
3010 W LOMITA BLVD
TORRANCE, CALIFORNIA 90505-5102
FORMERLY VOI-SHAN IN CULVER CITY, CALIF

97393 SHUR-LOK CORPORATION
2541 WHITE ROAD PO BOX 19584
IRVINE, CALIFORNIA 92713
FORMERLY SHUR LOK CORP VB0060
FORMERLY IN SANTA ANA, CALIFORNIA 92714

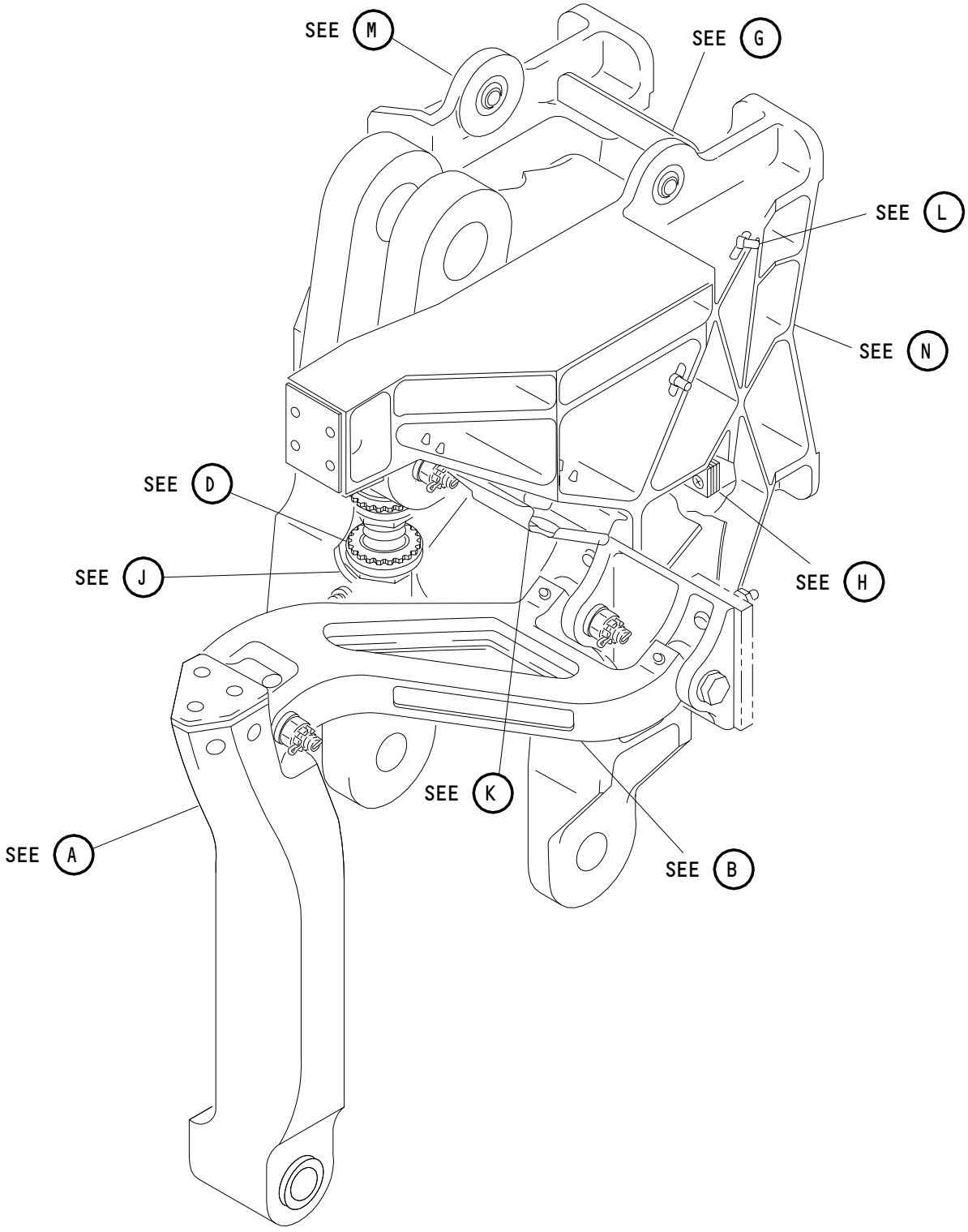
PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACB10GB06GC		1	560	1
		1	622	1
BACB10GB14GC		1	565	1
		1	623	1
BACB10GB24GC		1	260	1
		1	290	1
BACB28AK06-045		1	455	2
BACB28AP06P023		1	475	2
BACB28AP16P100		1	85	2
BACB28AT09B023C		1	480	2
BACB28AT14D049C		1	195	4
BACB28AT16D074C		1	145	2
BACB28AT23D034C		1	545	2
BACB28AT23D100C		1	345	2
BACB28AT28D064C		1	312	2
BACB28AT28D138C		1	355	2
BACB28AT28D142C		1	360	2
BACB28AU12B040C		1	150	4
BACB28AU12B058C		1	200	4
BACB28AU14B060C		1	80	2
BACB28AU14B084C		1	140	2
BACB28AU24B082C		1	304A	2
BACB28AU24B156C		1	350	4
BACB28AU24B160C		1	340	2
BACB30LJ6CD20		1	445	2
BACB30NN3K15		1	415	5
BACB30NZ6K9		1	590	4
BACB30NZ8K9		1	605	2
BACB30PW12CD45		1	110	2
BACB30VF5K12		1	45	3
BACB30VT10K12		1	375	4

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACB30VT12K13		1	395	4
BACB30VT5K7		1	495	2
BACB30VT5K8		1	490	2
BACB30YK16K15		1	170	2
BACC30BL10		1	380	4
BACC30BL12		1	400	4
BACC30BL5		1	500	4
BACC30CP16C		1	175	2
BACC30M6		1	595	4
BACC30M8		1	610	2
BACN10GH3B8C		1	540A	2
BACN10JD10CD		1	125	2
BACN10JD112CD		1	30A	1
BACN10JD120CD		1	230	2
BACN10JD120CD		1	330	1
BACN10JN06CD		1	520	2
BACN10YR3CD		1	425	5
BACN10YR6CD		1	465	2
BACN10ZC5CD		1	50	3
BACP18BC04A12P		1	105	2
BACP18BC04C16P		1	10	1
BACP18BC04C18P		1	210	2
		1	310	1
BACR10AL5AC		1	55	3
BACR15BA3AD		1	515	4
BACR15BB4AD8C		1	535	4
BACS40R012E061F		1	435	1
BACS40R014B026P		1	385	1
BACS40R016B029P		1	405	1
BACS40R024C043F		1	185	1
BACS40R024E043F		1	180	1
BACW10BP12CD		1	115	2
BACW10BP12DP		1	25	1
		1	120	2
BACW10BP14CD		1	20	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACW10BP20DP		1	225	2
		1	325	1
BACW10BP24CD		1	220	2
		1	320	1
BACW10BP6CD		1	450	2
BACW10BP6DP		1	460	2
BNG14H118C		1	565	1
		1	623	1
BNG24H118C		1	260	1
		1	290	1
BNH06H118C		1	560	1
		1	622	1
BRFM20C06LD		1	520	2
HLT422AP16-15		1	170	2
HL523AZ6-9		1	590	4
HL523AZ8-9		1	605	2
HL79-6		1	595	4
HL79-8		1	610	2
HST10AG10-12		1	375	4
HST10AG12-13		1	395	4
HST10AG5-7		1	495	2
HST10AG5-8		1	490	2
HST79-10		1	380	4
HST79-12		1	400	4
HST79-5		1	500	4
HST79CY10		1	380	4
HST79CY12		1	400	4
HST79CY5		1	500	4
H52732-3CD		1	425	5
H52732-6CD		1	465	2
L804-6K9		1	590	4
L804-8K9		1	605	2
MF51637-06		1	520	2
MS15001-1		1	90	1
		1	155	2
		1	365	1
MS15004-1		1	265	2
		1	295	2
NAS1149D0363J		1	420	5
NC06G10C		1	560	1
		1	622	1
NC14G10C		1	565	1
		1	623	1
NC24G10C		1	260	1
		1	290	1
NS202487-62		1	520	2

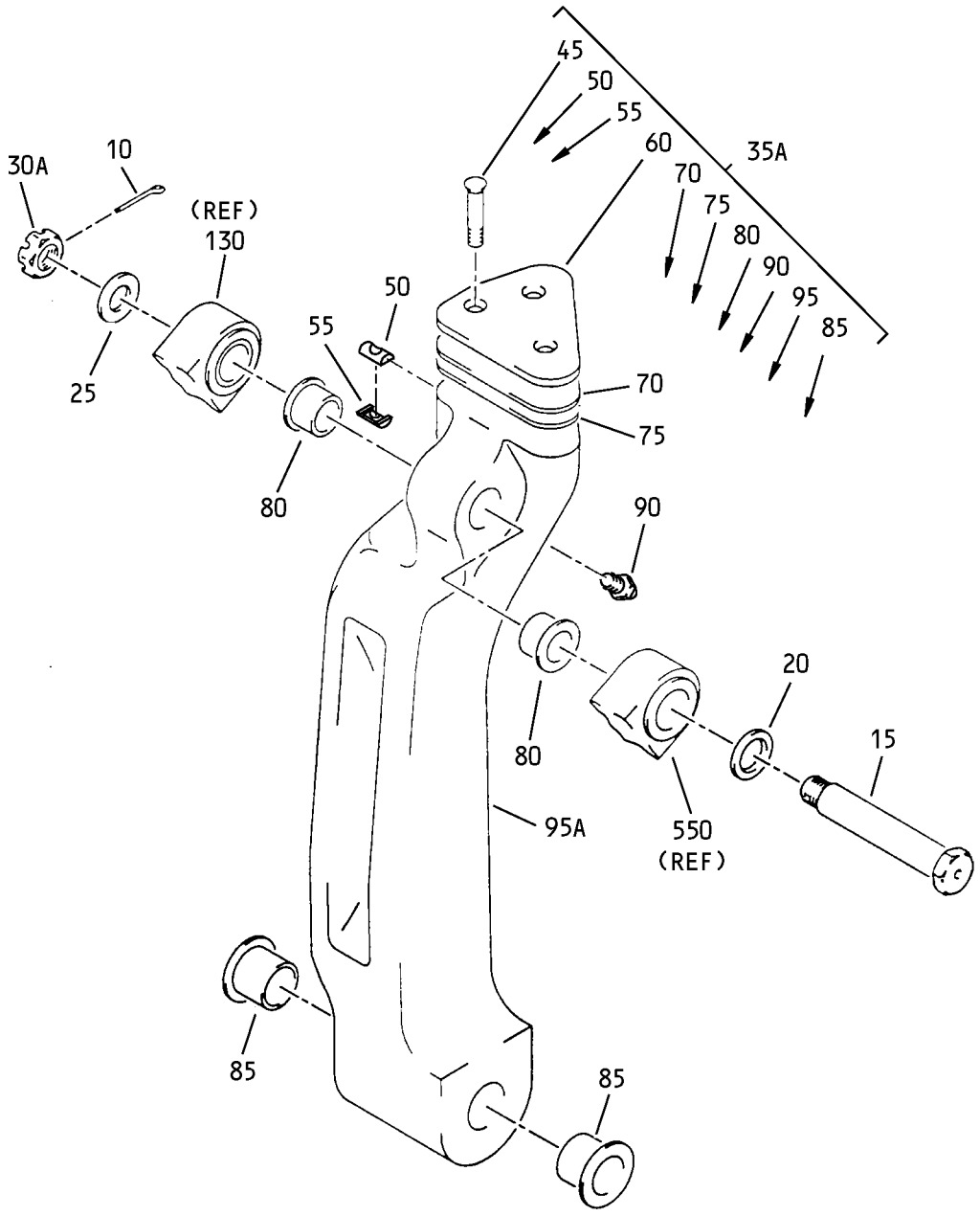
PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
PLH53CD		1	425	5
PLH56CD		1	465	2
SLR4001-5AC		1	55	3
SLR50-5AC		1	55	3
SL4113-5CDBAC		1	50	3
T8301C632CD		1	520	2
102B13171-5		1	50	3
102F9201M62		1	520	2
149T6080-10		1	5A	RF
149T6080-9		1	1B	RF
149T6813-3		1	390	1
149T6909-1		1	275	1
149T6909-2		1	245	1
149T6931-29		1	550	1
149T6931-30		1	555	1
149T6931-31		1	580	1
149T6931-32		1	585	1
149T6931-33		1	570	1
149T6931-34		1	575	1
149T6931-35		1	625	1
149T6931-36		1	630	1
149T6931-37		1	615	1
149T6931-38		1	600	1
149T6931-40		1	620	1
149T6934-1		1	280	1
149T6934-2		1	250	1
149T6935-10		1	100A	1
149T6935-7		1	35A	1
149T6935-8		1	40A	1
149T6935-9		1	95A	1
149T6950-2		1	235	2
149T6954-1		1	75	1
149T6954-2		1	70	1
149T6955-13		1	335	1
149T6955-14		1	370	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
149T6956-10		1	305	1
149T6956-5		1	240	1
149T6956-6		1	285	1
149T6956-7		1	300	1
149T6956-8		1	255	1
149T6956-9		1	270	1
149T6963-3		1	470	1
149T6963-4		1	485	1
149T6979-5		1	60	1
149T6979-6		1	65	1
149T6985-10		1	315	1
149T6985-11		1	215	2
149T6985-14		1	15	1
149T6988-6		1	190	1
149T6988-7		1	205	1
149T6991-5		1	410	1
149T6991-6		1	442	1
149T6991-7		1	430	1
149T6991-8		1	440	3
149T7801-17		1	130	1
149T7801-18		1	135	1
149T7801-19		1	160	1
149T7801-20		1	165	1
284T0240-1		1	505	1
284T0240-2		1	510	1
284T0240-3		1	525	1
284T0240-4		1	530	1
66014-6		1	595	4
66014-8		1	610	2
92834-524CD		1	50	3



Hinge Bellcrank Assembly
Figure 1 (Sheet 1)

K15247

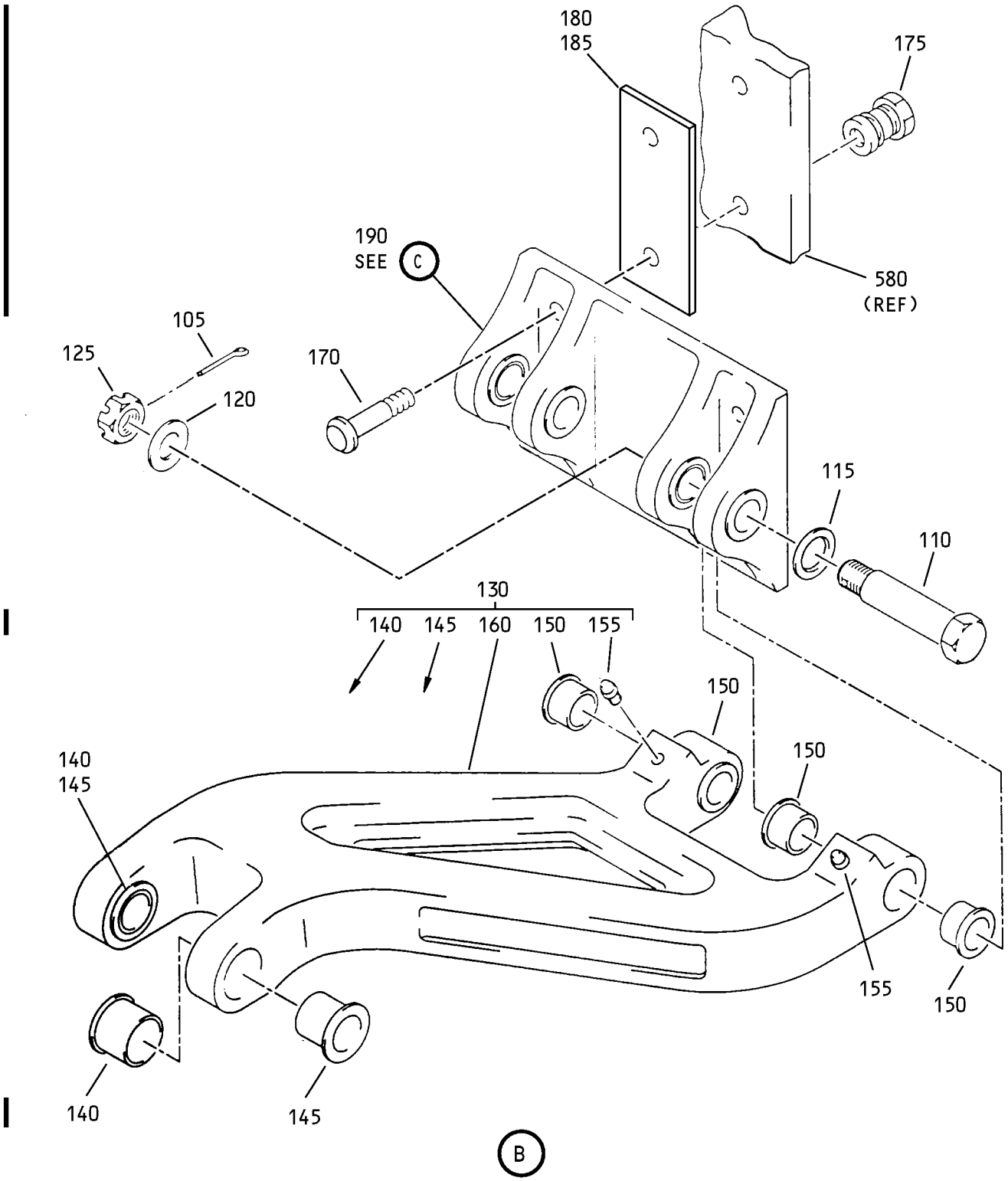


VIEW ROTATED 180° COUNTERCLOCKWISE

(A)

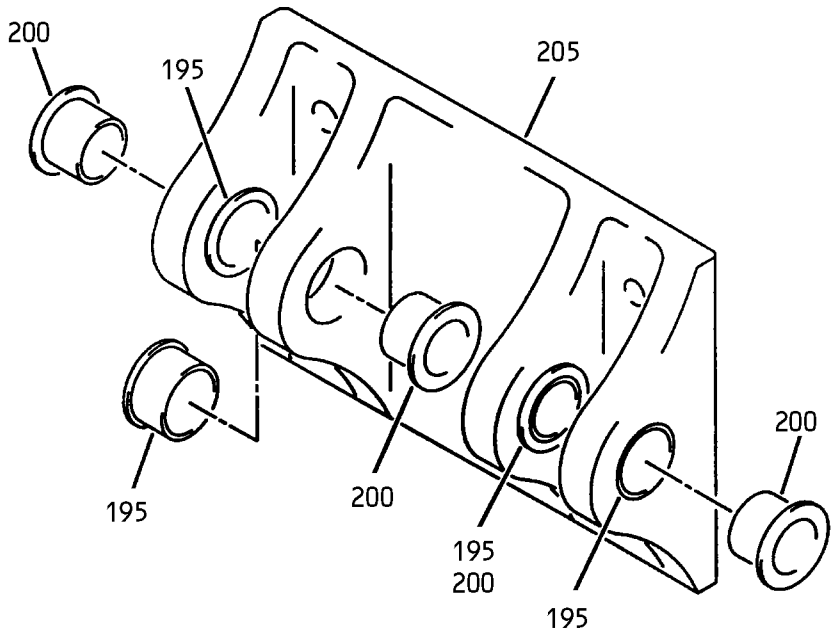
Hinge Bellcrank Assembly
Figure 1 (Sheet 2)

K15249



Hinge Bellcrank Assembly
Figure 1 (Sheet 3)

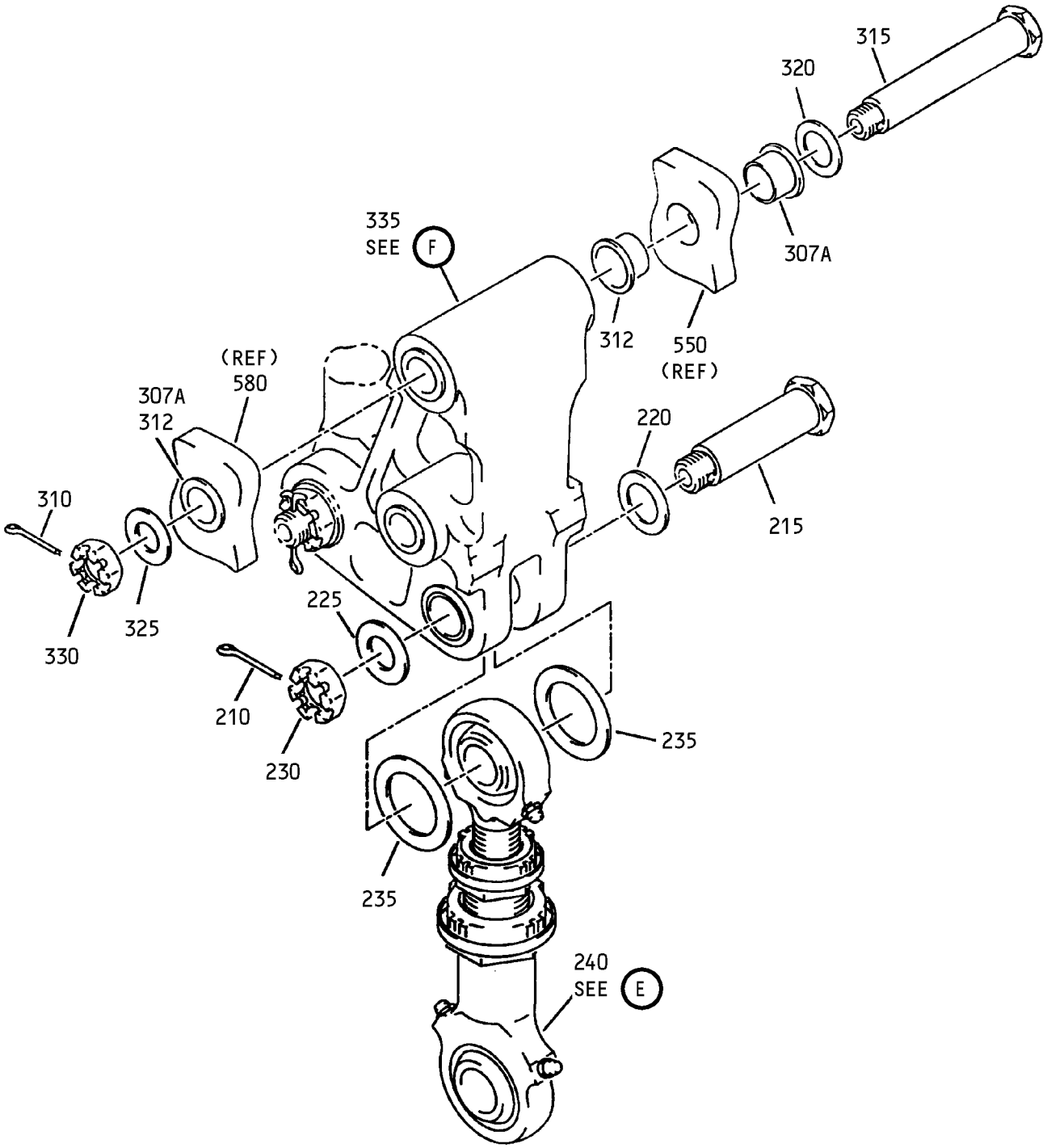
K15352



C

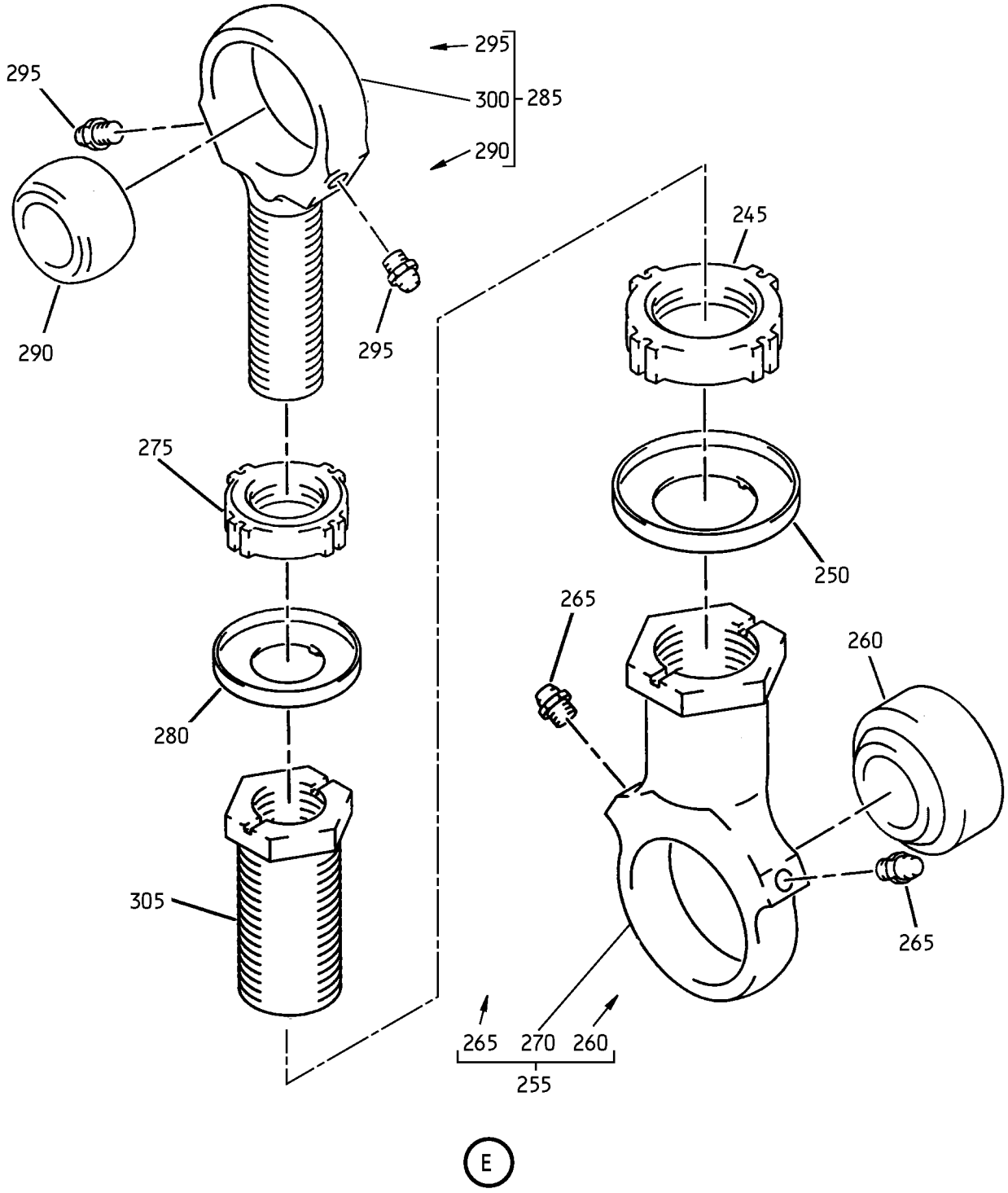
Hinge Bellcrank Assembly
Figure 1 (Sheet 4)

K17007



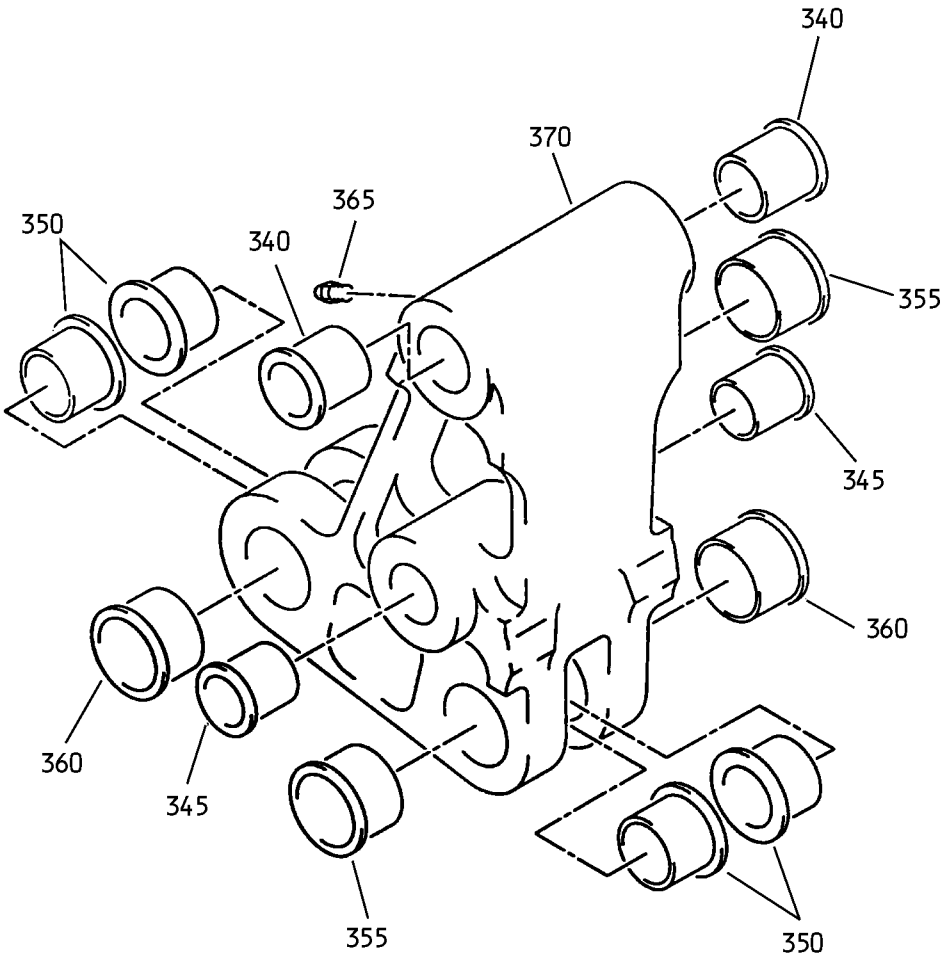
Hinge Bellcrank Assembly
Figure 1 (Sheet 5)

K17028

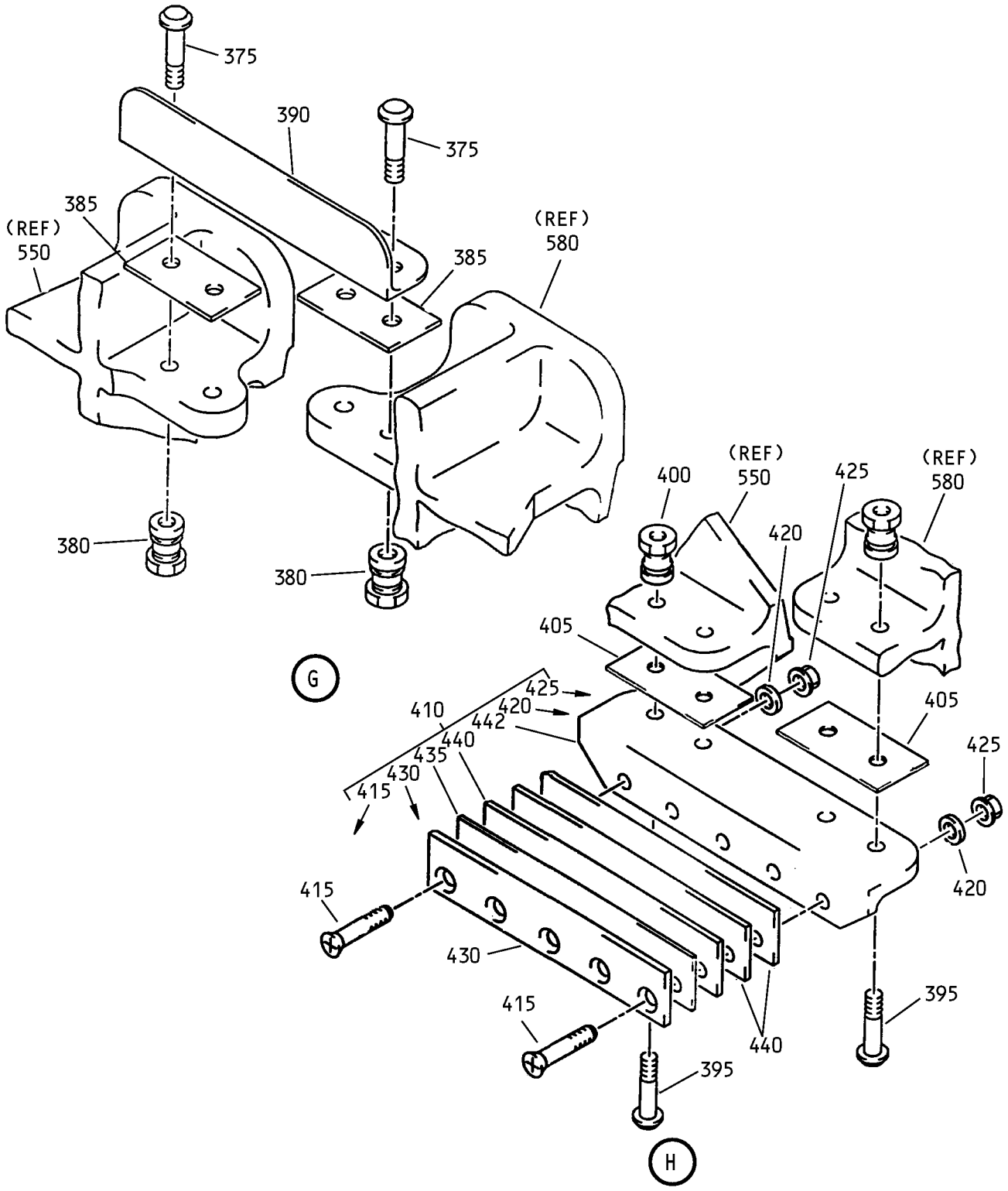


Hinge Bellcrank Assembly
Figure 1 (Sheet 6)

K17052

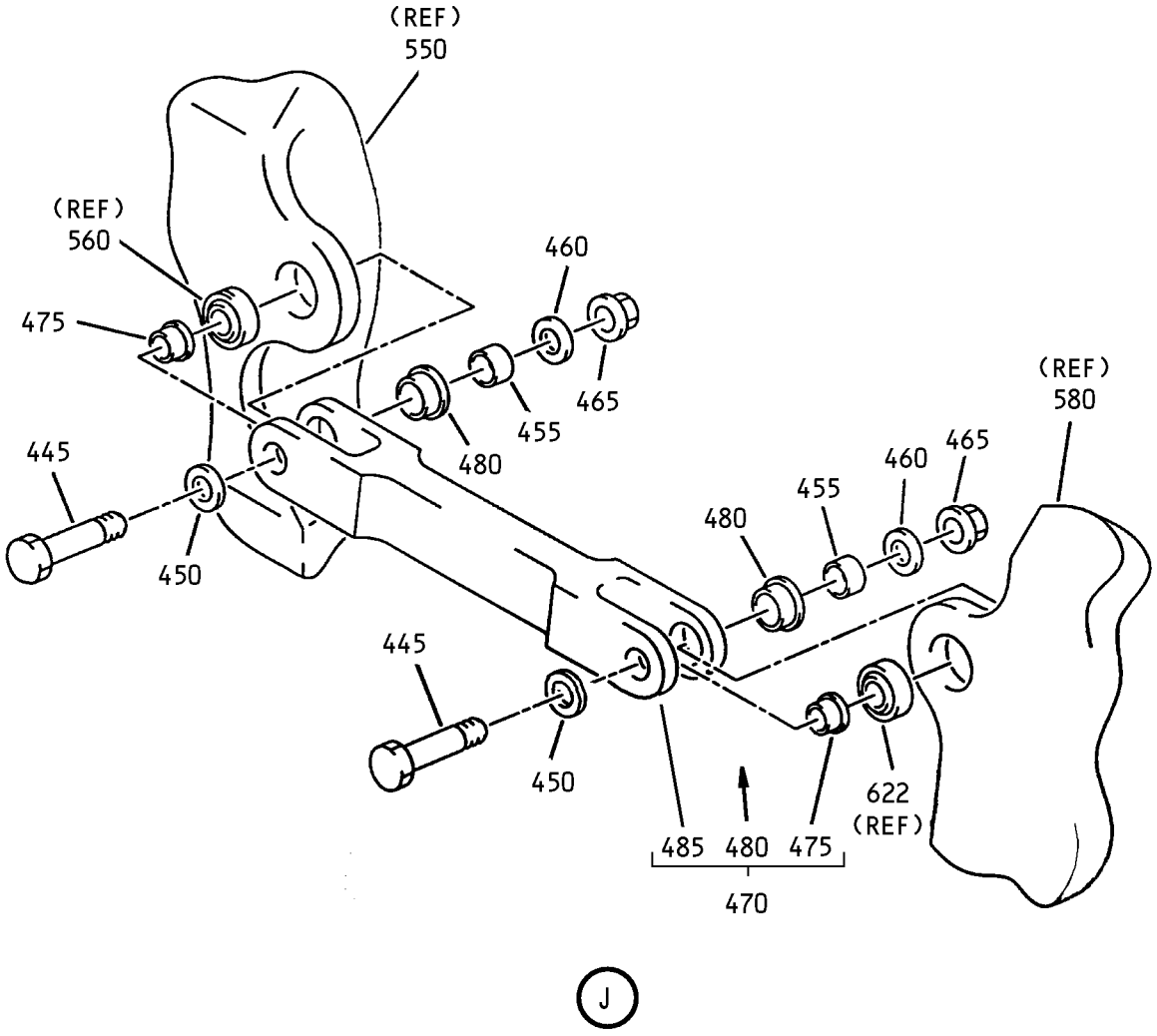


Hinge Bellcrank Assembly
Figure 1 (Sheet 7)



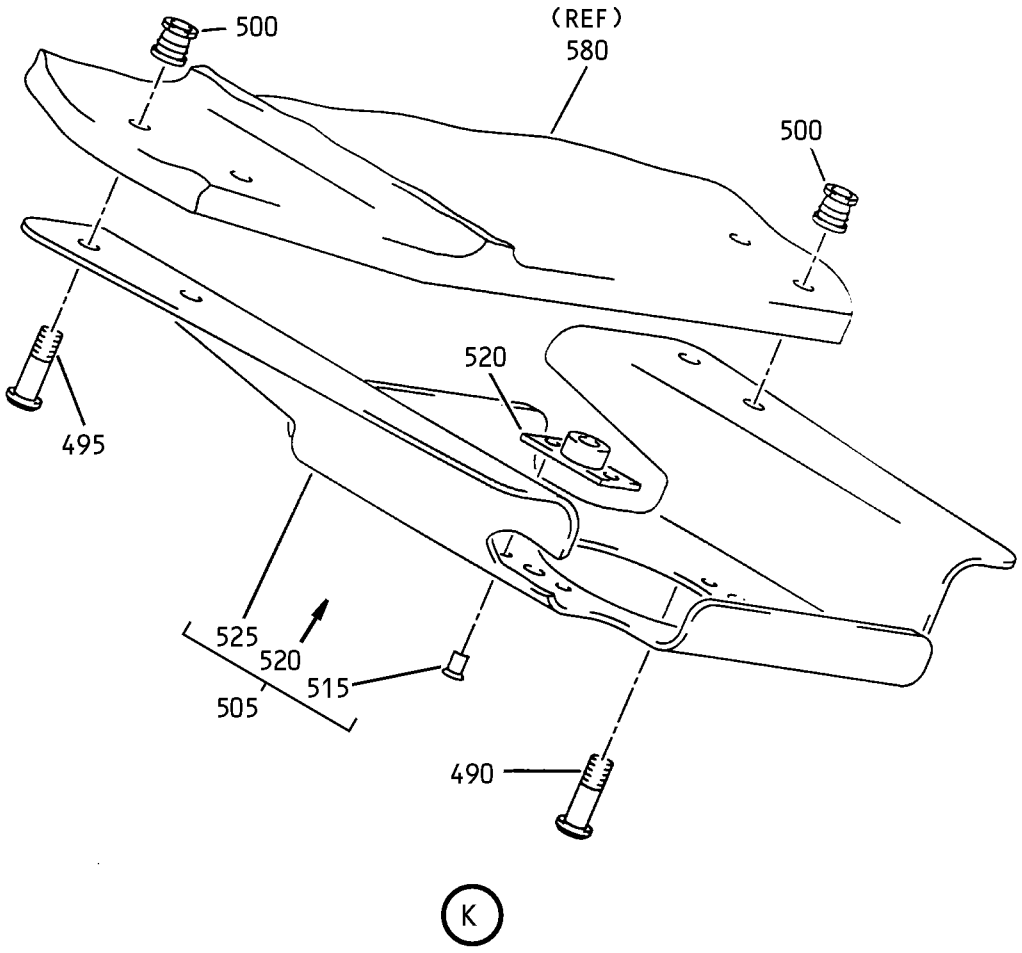
Hinge Bellcrank Assembly
Figure 1 (Sheet 8)

K17109



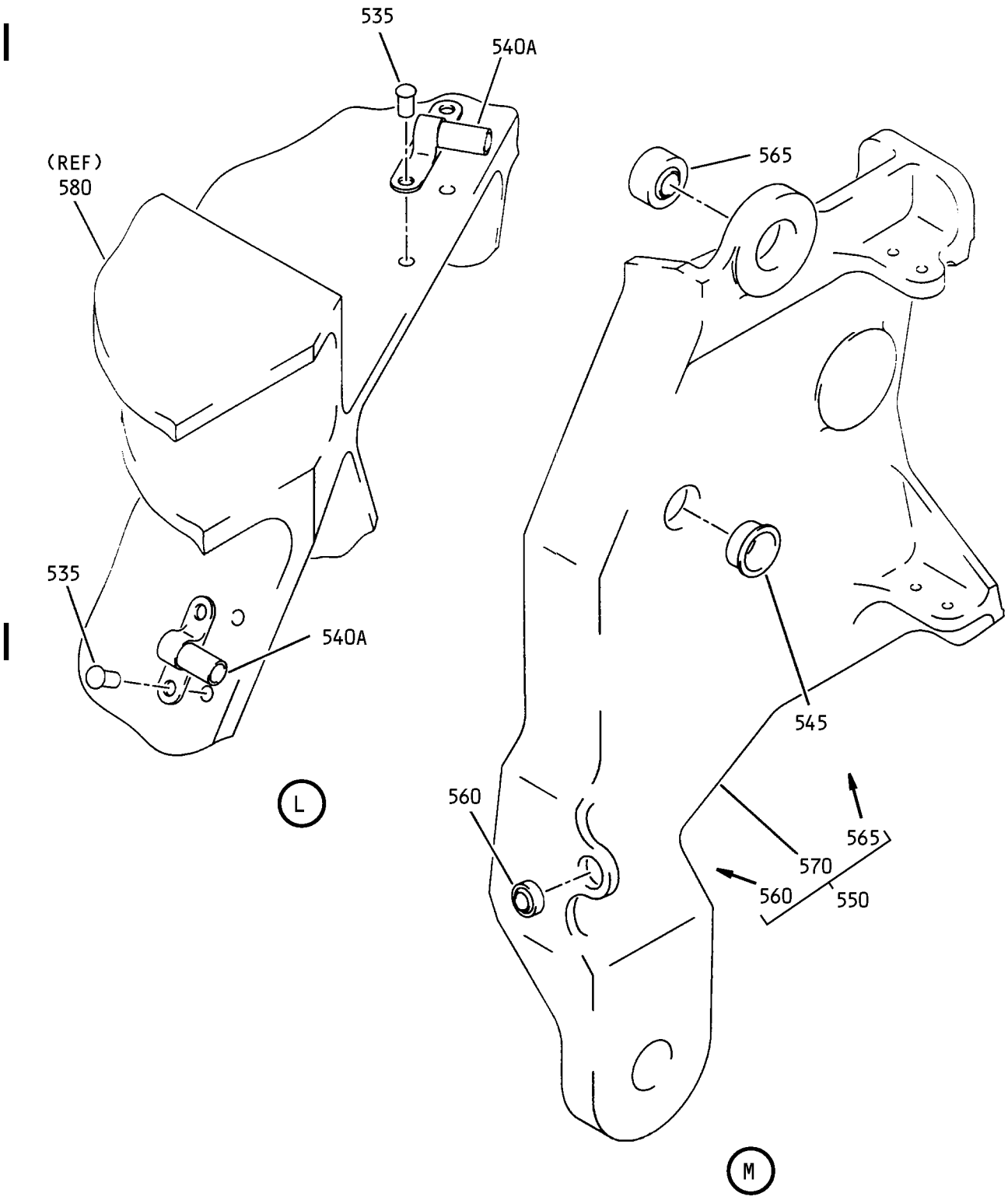
Hinge Bellcrank Assembly
Figure 1 (Sheet 9)

K17135



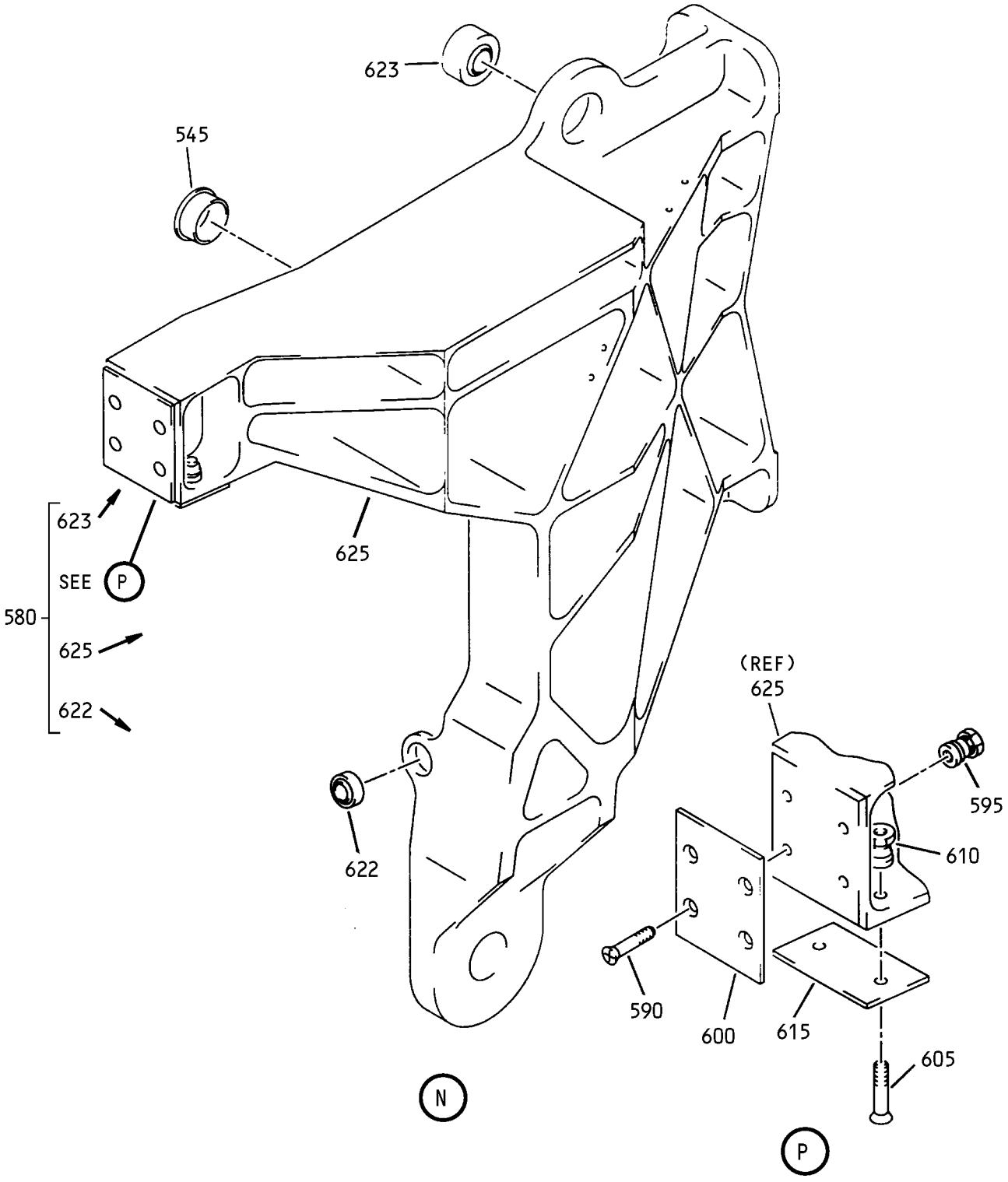
Hinge Bellcrank Assembly
Figure 1 (Sheet 10)

K17138



Hinge Bellcrank Assembly
Figure 1 (Sheet 11)

K17150



Hinge Bellcrank Assembly
Figure 1 (Sheet 12)

K17155

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	-1A	149T6080-3		DELETED		
R	-1B	149T6080-9		BELLCRANK ASSY-HINGE MLG DOOR	C	RF
	-5	149T6080-4		DELETED		
R	-5A	149T6080-10		BELLCRANK ASSY-HINGE	D	RF
	10	BACP18BC04C16P		.PIN-COTTER		1
	15	149T6985-14		.BOLT		1
	20	BACW10BP14CD		.WASHER		1
	25	BACW10BP12DP		.WASHER		1
	30	BACN10JD112DP		DELETED		
	30A	BACN10JD112CD		.NUT		1
	35	149T6935-3		DELETED		
R	35A	149T6935-7		.LINK ASSY-UP LOCK	C	1
	-40	149T6935-4		DELETED		
R	-40A	149T6935-8		.LINK ASSY-UP LOCK	D	1
	45	BACB30VF5K12		..BOLT		3
	50	SL4113-5CDBAC		..NUT- (V97393) (SPEC BACN10ZC5CD) (OPT 102B13171-5 (V72962)) (OPT 92834-524CD (V56878))		3
	55	SLR4001-5AC		..RETAINER- (V97393) (SPEC BACR10AL5AC) (OPT SLR50-5AC (V97393))		3
	60	149T6979-5		..PAD-WEAR	C	1
	-65	149T6979-6		..PAD-WEAR	D	1
	70	149T6954-2		..SHIM		1
	75	149T6954-1		..FILLER		1
	80	BACB28AU14B060C		..BUSHING		2
	85	BACB28AP16P100		..BUSHING		2
R	90	MS15001-1		..FITTING-LUBE		1
	95	149T6935-5		DELETED		
R	95A	149T6935-9		..FITTING-LINK	C	1
	-100	149T6935-6		DELETED		

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
R	-100A	149T6935-10		..FITTING-LINK	D	1
	105	BACP18BC04A12P		.PIN-COTTER		2
	110	BACB30PW12CD45		.BOLT		2
	115	BACW10BP12CD		.WASHER		2
	120	BACW10BP12DP		.WASHER		2
	125	BACN10JD10CD		.NUT		2
	130	149T7801-17		.FITTING ASSY-GEAR SPRT	C	1
	-135	149T7801-18		.FITTING ASSY-GEAR SPRT	D	1
	140	BACB28AU14B084C		..BUSHING		2
	145	BACB28AT16D074C		..BUSHING		2
	150	BACB28AU12B040C		..BUSHING		4
	155	MS15001-1		..FITTING-LUBE		2
	160	149T7801-19		..FITTING-GEAR SUPT	C	1
	-165	149T7801-20		..FITTING-GEAR SUPT	D	1
	170	HLT422AP16-15		.BOLT- (V06725) (SPEC BACB30YK16K15) (OPT HLT422AP16-15 (V97928))		2
	175	BACC30CP16C		.COLLAR		2
R	180	BACS40R024E043F		.SHIM		1
R	185	BACS40R024C043F		.SHIM		1
	190	149T6988-6		.FITTING ASSY		1
	195	BACB28AT14D049C		..BUSHING		4
	200	BACB28AU12B058C		..BUSHING		4
	205	149T6988-7		..FITTING		1
	210	BACP18BC04C18P		.PIN-COTTER		2
	215	149T6985-11		.BOLT		2
	220	BACW10BP24CD		.WASHER		2
	225	BACW10BP20DP		.WASHER		2
	230	BACN10JD120CD		.NUT		2
	235	149T6950-2		.WASHER-ANTI-ROTATION		2
	240	149T6956-5		.ROD ASSY-PUSH		1
	245	149T6909-2		..NUT-LOCK		1
	250	149T6934-2		..WASHER-LOCK		1
	255	149T6956-8		..END ASSY-ROD FEMALE		1
	260	NC24G10C		...BEARING-SPHERICAL (V56644) (SPEC BACB10GB24GC) (OPT BNG24H118C (V16746))		1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	265	MS15004-1		...FITTING-LUBE		2
	270	149T6956-9		...ROD END		1
	275	149T6909-1		..NUT-LOCK		1
	280	149T6934-1		..WASHER-LOCK		1
	285	149T6956-6		..END ASSY-ROD MALE		1
	290	NC24G10C		...BEARING-SPHERICAL (V56644) (SPEC BACB10GB24GC) (OPT BNG24H118C (V16746))		1
	295	MS15004-1		...FITTING-LUBE		2
	300	149T6956-7		...ROD END		1
R	304A	BACB28AU24B082C		.BUSHING		2
	305	149T6956-10		..SLEEVE-THREADED		1
	307	BACB28AV24B082C		DELETED		
	310	BACP18BC04C18P		.PIN-COTTER		1
	312	BACB28AT28D064C		.BUSHING		2
	315	149T6985-10		.BOLT		1
	320	BACW10BP24CD		.WASHER		1
	325	BACW10BP20DP		.WASHER		1
	330	BACN10JD120CD		.NUT		1
	335	149T6955-13		.BELLCRANK ASSY		1
	340	BACB28AU24B160C		..BUSHING		2
	345	BACB28AT23D100C		..BUSHING		2
	350	BACB28AU24B156C		..BUSHING		4
	355	BACB28AT28D138C		..BUSHING		2
	360	BACB28AT28D142C		..BUSHING		2
	365	MS15001-1		..FITTING-LUBE		1
	370	149T6955-14		..BELLCRANK		1
	375	HST10AG10-12		.BOLT- (VOPTK6) (SPEC BACB30VT10K12) (OPT HST10AG10-12 (V06725)) (OPT HST10AG10-12 (V56878)) (OPT HST10AG10-12 (V73197))		4

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
380	HST79CY10		.COLLAR- (V73197) (SPEC BACC30BL10) (OPT HST79-10 (V92215)) (OPT HST79CY10 (V56878)) (OPT HST79CY10 (V5M902))		4
385	BACS40R014B026P		.SHIM		AR
390	149T6813-3		.TIE-STABLIZE		1
395	HST10AG12-13		.BOLT- (VOPTK6) (SPEC BACB30VT12K13) (OPT HST10AG12-13 (V06725)) (OPT HST10AG12-13 (V56878)) (OPT HST10AG12-13 (V73197))		4
400	HST79CY12		.COLLAR- (V73197) (SPEC BACC30BL12) (OPT HST79CY12 (V56878)) (OPT HST79CY12 (V5M902)) (OPT HST79-12 (V92215))		4

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
405	BACS40R016B029P		.SHIM		AR
410	149T6991-5		.STOP ASSY		1
415	BACB30NN3K15		..BOLT		5
420	NAS1149D0363J		..WASHER		5
425	H52732-3CD		..NUT- (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))		5
430	149T6991-7		..PAD		1
435	BACS40R012E061F		..SHIM		1
440	149T6991-8		..FILLER		3
442	149T6991-6		..STOP		1
445	BACB30LJ6CD20		.BOLT		2
450	BACW10BP6CD		.WASHER		2
455	BACB28AK06-045		.BUSHING		2
460	BACW10BP6DP		.WASHER		2
465	H52732-6CD		.NUT- (V15653) (SPEC BACN10YR6CD) (OPT PLH56CD (V62554))		2
470	149T6963-3		.FITTING ASSY-CROSS LINK		1
475	BACB28AP06P023		..BUSHING		2
480	BACB28AT09B023C		..BUSHING		2
485	149T6963-4		..FITTING		1
490	HST10AG5-8		.BOLT- (VOPTK6) (SPEC BACB30VT5K8) (OPT HST10AG5-8 (V06725)) (OPT HST10AG5-8 (V56878)) (OPT HST10AG5-8 (V73197))		2

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
495	HST10AG5-7		.BOLT-		2
			(VOPTK6)		
			(SPEC BACB30VT5K7)		
			(OPT HST10AG5-7		
			(V06725))		
			(OPT HST10AG5-7		
			(V56878))		
			(OPT HST10AG5-7		
			(V73197))		
500	HST79CY5		.COLLAR-		4
			(V73197)		
			(SPEC BACC30BL5)		
			(OPT HST79-5		
			(V92215))		
			(OPT HST79CY5		
			(V56878))		
			(OPT HST79CY5		
			(V5M902))		
505	284T0240-1		.BRACKET ASSY	C	1
-510	284T0240-2		.BRACKET ASSY	D	1
515	BACR15BA3AD		..RIVET-		4
			(SIZE DETERMINE ON INST)		
520	BRFM20C06LD		..NUTPLATE-		2
			(V52828)		
			(SPEC BACN10JN06CD)		
			(OPT T8301C632CD		
			(V11815))		
			(OPT 102F9201M62		
			(V72962))		
			(OPT NS202487-62		
			(V80539))		
			(OPT MF51637-06		
			(V15653))		
525	284T0240-3		..BRACKET	C	1
-530	284T0240-4		..BRACKET	D	1
535	BACR15BB4AD8C		.RIVET		4
540	BACN10GH3B8		DELETED		
540A	BACN10GH3B8C		.NUTPLATE		2
545	BACB28AT23D034C		.BUSHING		2
550	149T6931-29		.FITTING ASSY-FWD CTR	C	1
-555	149T6931-30		.FITTING ASSY-FWD CTR	D	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
560	NC06G10C		..BEARING- (V56644) (SPEC BACB10GB06GC) (OPT BNH06H118C (V16746))		1
565	NC14G10C		..BEARING- (V56644) (SPEC BACB10GB14GC) (OPT BNG14H118C (V16746))		1
570	149T6931-33		..FITTING-FWD CTR HINGE	C	1
-575	149T6931-34		..FITTING-FWD CTR HINGE	D	1
580	149T6931-31		.FITTING ASSY-AFT CRT	C	1
-585	149T6931-32		.FITTING ASSY-AFT CTR	D	1
590	HL523AZ6-9		..BOLT- (V73197) (SPEC BACB30NZ6K9) (OPT L804-6K9 (V06725)) (OPT HL523AZ6-9 (V56878)) (OPT HL523AZ6-9 (V92215)) (OPT HL523AZ6-9 (V97928)) (OPT HL523AZ6-9 (V0PTK6)) (OPT HL523AZ6-9 (V60516)) (OPT HL523AZ6-9 (V06725))		4

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
595	HL79-6		..COLLAR-		4
			(V56878)		
			(SPEC BACC30M6)		
			(OPT HL79-6		
			(V73197))		
			(OPT HL79-6		
			(V92215))		
			(OPT 66014-6		
			(V56878))		
			(OPT HL79-6		
			(V5M902))		
600	149T6931-38		..PAD		1
605	HL523AZ8-9		..BOLT-		2
			(V73197)		
			(SPEC BACB30NZ8K9)		
			(OPT L804-8K9		
			(V06725))		
			(OPT HL523AZ8-9		
			(V56878))		
			(OPT HL523AZ8-9		
			(V92215))		
			(OPT HL523AZ8-9		
			(V97928))		
			(OPT HL523AZ8-9		
			(VOPTK6))		
			(OPT HL523AZ8-9		
			(V60516))		
			(OPT HL523AZ8-9		
			(V06725))		

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
610	HL79-8		..COLLAR- (V56878) (SPEC BACC30M8) (OPT HL79-8 (V73197)) (OPT HL79-8 (V92215)) (OPT 66014-8 (V56878)) (OPT HL79-8 (V5M902))		2
615	149T6931-37		..PAD	C	1
-620	149T6931-40		..PAD	D	1
622	NC06G10C		..BEARING- (V56644) (SPEC BACB10GB06GC) (OPT BNH06H118C (V16746))		1
623	NC14G10C		..BEARING- (V56644) (SPEC BACB10GB14GC) (OPT BNG14H118C (V16746))		1
625	149T6931-35		..FITTING-AFT CTR HINGE	C	1
-630	149T6931-36		..FITTING-AFT CTR HINGE	D	1

- Item Not Illustrated