TO: ALL HOLDERS OF MAIN LANDING GEAR BRAKE QUADRANT ASSEMBLY COMPONENT MAINTENANCE MANUAL 32-41-23.

REVISION NO. 1 DATED SEP 01/94

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
REPAIR-GEN 601	Added reference to 32-00-05 for standard repair of high-strength steel parts.
REPAIR-GEN 602-603	Changed the standard location of the datum letters.
REPAIR 4-1 601	Changed a diameter callout on bearing shaft 69B81260-1.

MAIN LANDING GEAR BRAKE QUADRANT ASSEMBLY

PART NUMBER 253T3526-1,-2

COMPONENT MAINTENANCE MANUAL
WITH
ILLUSTRATED PARTS LIST

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 B11452	APR 10/86

PAGE	DATE	CODE
32-41-23		
TITLE PAGE		
1	APR 10/86	01
2	BLANK	
REVISION RECORD		
1	APR 10/86	01
2	BLANK	
TR & SB RECORD		
1	APR 10/86	01
2	BLANK	
LIST OF EFFECTIVE PAGES		
*1	SEP 01/94	01
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CONTENTS		
1	APR 10/86	01
2	BLANK	
INTRODUCTION		
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2	BLANK	
DESCRIPTION & OPERATION		
1	APR 10/86	01
2	BLANK	
DISASSEMBLY		
301	APR 10/86	01
302	BLANK	
CHECK		
501	APR 10/86	01
502	BLANK	
REPAIR-GENERAL		
*601	SEP 01/94	01.1
*602	SEP 01/94	01.1
*603	SEP 01/94	01.1
*604	BLANK	
REPAIR 1-1		
601	APR 10/86	01
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602	APR 10/86	01
REPAIR 3-1		
601	APR 10/86	01
602	BLANK	
REPAIR 3-2		
601	APR 10/86	01
602	APR 10/86	01
603	APR 10/86	01
604	BLANK	
REPAIR 4-1		
*601	SEP 01/94	01.1
602	BLANK	
REPAIR 5-1		
601	APR 10/86	01
602	BLANK	
ASSEMBLY		
701	APR 10/86	01
702	APR 10/86	01
703	APR 10/86	01
704	BLANK	
ILLUSTRATED PARTS LIST		
1001	APR 10/86	01
1002	APR 10/86	01
1003	APR 10/86	01
1004	BLANK	
1005	APR 10/86	01
1006	APR 10/86	01
1007	APR 10/86	01

REPAIR-GENERAL CONT.

* = REVISED, ADDED OR DELETED

PAGE	DATE	CODE	PAGE	DATE	CODE
ILLUSTRATED PARTS LIST		CONT.			
1008	APR 10/86	01			

* = REVISED, ADDED OR DELETED

TABLE OF CONTENTS

*[1] Special instructions not required. Use standard industry practices.

INTRODUCTION

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

This manual is divided into separate sections:

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

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

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

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

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

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

Verification:

Disassembly
Assembly

MAIN LANDING GEAR BRAKE QUADRANT ASSEMBLY

DESCRIPTION AND OPERATION

1. The main landing gear brake quadrant assembly consists of cranks and quadrant mounted on a shaft. Bearing shafts provide turning surfaces. Inputs transmitted from the brake system rotate the quadrant to operate the brakes by cables.

2. Leading Particulars (Approximate)

   Length -- 8 inches
   Width -- 8 inches
   Height -- 6 inches
   Weight -- 5 pounds

DISASSEMBLY

NOTE: Disassemble this component only as necessary to complete fault isolation, determine the serviceability of parts, perform required repairs and restore the unit to serviceable condition. Refer to IPL Fig. 1 for item numbers.

1. Left-Hand Quadrant

   A. Remove bolt (10), washer (15) and nut (20) from crank (25).

   B. Remove crank (25) and nut (30) from shaft (85).

   C. Remove crank (40), spacers (55, 60), and bearing (35) from shaft. Do not remove bearing (45) from crank (50) unless necessary for repair or replacement.

   D. Remove parts (75, 70, 65) and quadrant (80) from shaft (85).

   E. Remove spring pin (170) and separate bearing shaft (175) from shaft (85).

2. Right-Hand Quadrant

   A. Remove nut (90) from outer shaft (165). Remove crank (95), bearing (115), and spacer (110) from shaft. Do not remove bearing (100) from crank (105) unless necessary for repair or replacement.

   B. Remove bolt (125), washer (130), and nut (135) from crank (140); then remove crank (140) from shaft (165).

   C. Remove parts (155, 150, 145) and quadrant (160) from shaft (165).

   D. Remove spring pin (170) and separate bearing shaft (175) from shaft (165).

CHECK

1. Check all parts for obvious defects in accordance with standard industry practices.

2. Penetrant check per 20-20-02:

   A. Cranks (25, 30 or 90, 50 or 105)

   B. Spacers (55 or 110, 60, 120)

   C. Quadrant (80 or 160)

   D. Shaft (85 or 165)

3. Magnetic particle check per 20-20-01:

   A. Bearing shaft (175)

REPAIR - GENERAL

1. Content

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

P/N	NAME	REPAIR
253T3527	SHAFT	1-1
253T3528	QUADRANT	2-1
253T3529	CRANK	3-1
69B81260	BEARING SHAFT	4-1
- - -	MISCELLANEOUS PARTS REFINISH	5-1

2. Standard Practices

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

   20-30-02 Stripping of Protective Finishes
   20-41-01 Decoding Table for Boeing Finish Codes
   20-42-05 Bright Cadmium Plating
   20-43-01 Chromic Acid Anodizing
   20-50-02 Installation of Safetying Devices
   20-50-03 Bearing Installation and Retention
   32-00-05 Repair of High Strength Steel Landing Gear Parts

3. Materials

   NOTE: Equivalent substitutes can be used.

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

4. Dimensioning Symbols

A. Standard True Position Dimensioning Symbols used in applicable repair procedures are shown in Fig. 601.

—	STRAIGHTNESS
▱	FLATNESS
⊥	PERPENDICULARITY (OR SQUARENESS)
//	PARALLELISM
○	ROUNDNESS
⌭	CYLINDRICITY
⌒	PROFILE OF A LINE
⌓	PROFILE OF A SURFACE
◎	CONCENTRICITY
≡	SYMMETRY
∠	ANGULARITY
↗	RUNOUT
↗↗	TOTAL RUNOUT
⌴	COUNTERBORE OR SPOTFACE
∨	COUNTERSINK
⌖	THEORETICAL EXACT POSITION OF A FEATURE (TRUE POSITION)
∅	DIAMETER
S ∅	SPHERICAL DIAMETER
R	RADIUS
SR	SPHERICAL RADIUS
()	REFERENCE
BASIC (BSC) OR [DIM]	A THEORETICALLY EXACT DIMENSION USED TO DESCRIBE SIZE, SHAPE OR LOCATION OF A FEATURE FROM WHICH PERMISSIBLE VARIATIONS ARE ESTABLISHED BY TOLERANCES ON OTHER DIMENSIONS OR NOTES.
[-A-]	DATUM
Ⓜ	MAXIMUM MATERIAL CONDITION (MMC)
Ⓛ	LEAST MATERIAL CONDITION (LMC)
Ⓢ	REGARDLESS OF FEATURE SIZE (RFS)
Ⓟ	PROJECTED TOLERANCE ZONE
FIM	FULL INDICATOR MOVEMENT

EXAMPLES

[— | 0.002]	STRAIGHT WITHIN 0.002
[⊥ | 0.002 | B]	PERPENDICULAR TO B WITHIN 0.002
[// | 0.002 | A]	PARALLEL TO A WITHIN 0.002
[○ | 0.002]	ROUND WITHIN 0.002
[⌭ | 0.010]	CYLINDRICAL SURFACE MUST LIE BETWEEN TWO CONCENTRIC CYLINDERS, ONE OF WHICH HAS A RADIUS 0.010 INCH GREATER THAN THE OTHER
[⌒ | 0.006 | A]	EACH LINE ELEMENT OF THE SURFACE AT ANY CROSS SECTION MUST LIE BETWEEN TWO PROFILE BOUNDARIES 0.006 INCH APART RELATIVE TO DATUM PLANE A
[⌓ | 0.020 | A]	SURFACES MUST LIE WITHIN PARALLEL BOUNDARIES 0.02 INCH APART AND EQUALLY DISPOSED ABOUT TRUE PROFILE
[◎ | ∅ 0.0005 | C]	CONCENTRIC TO C WITHIN 0.0005 DIAMETER
[≡ | 0.010 | A]	SYMMETRICAL WITH A WITHIN 0.010
[∠ | 0.005 | A]	ANGULAR TOLERANCE 0.005 WITH A
[⌖ | ∅ 0.002 Ⓢ | B]	LOCATED AT TRUE POSITION WITHIN 0.002 DIA RELATIVE TO DATUM B, REGARDLESS OF FEATURE SIZE
[⊥ | ∅ 0.010 Ⓜ | A] [0.510 Ⓟ]	AXIS IS TOTALLY WITHIN A CYLINDER OF 0.010-INCH DIAMETER, PERPENDICULAR TO, AND EXTENDING 0.510-INCH ABOVE, DATUM A, MAXIMUM MATERIAL CONDITION
[2.000] OR 2.000 BSC	THEORETICALLY EXACT DIMENSION IS 2.000

NOTE: DATUM MAY APPEAR AT EITHER SIDE OF TOLERANCE FRAME [0.020 | A] [A | 0.020]

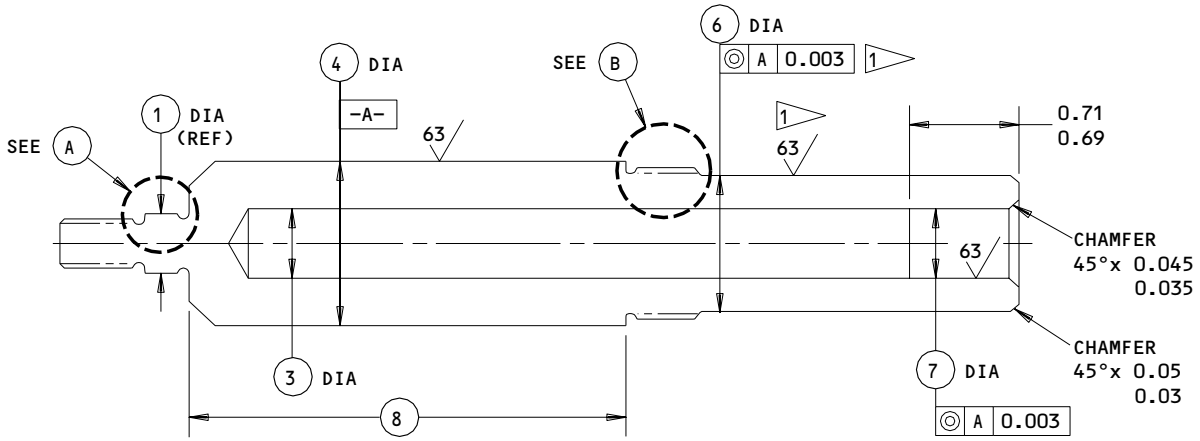
True Position Dimensioning Symbols
Figure 601

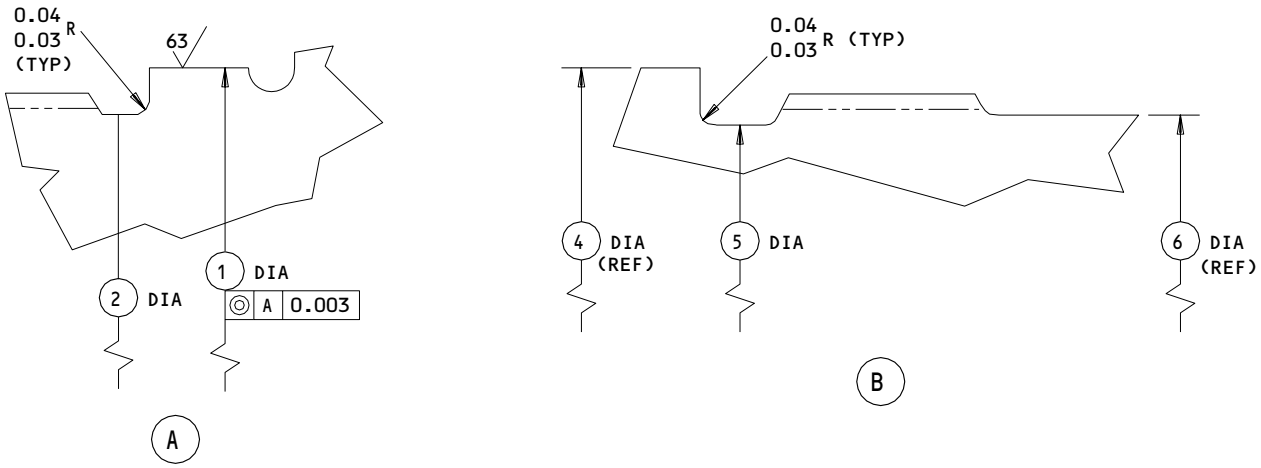
SHAFT - REPAIR 1-1

253T3527-1, -2

1. Plating Repair

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





	1	2	3	4	5	6 1	6 2	7	8 1	8 2
DESIGN DIM	0.3752 0.3747	0.252 0.247	0.44 0.42	1.0618 1.0608	0.9197 0.9097	0.906 0.905	0.90 0.88	0.4415 0.4405	2.802 2.792	4.779 4.769

REFINISH

CHROMIC ACID ANODIZE (F-17.02) ALL OVER

1 253T3527-1

2 253T3527-2

REPAIR

(SAME AS REFINISH)

125 MACHINE FINISH EXCEPT AS NOTED

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

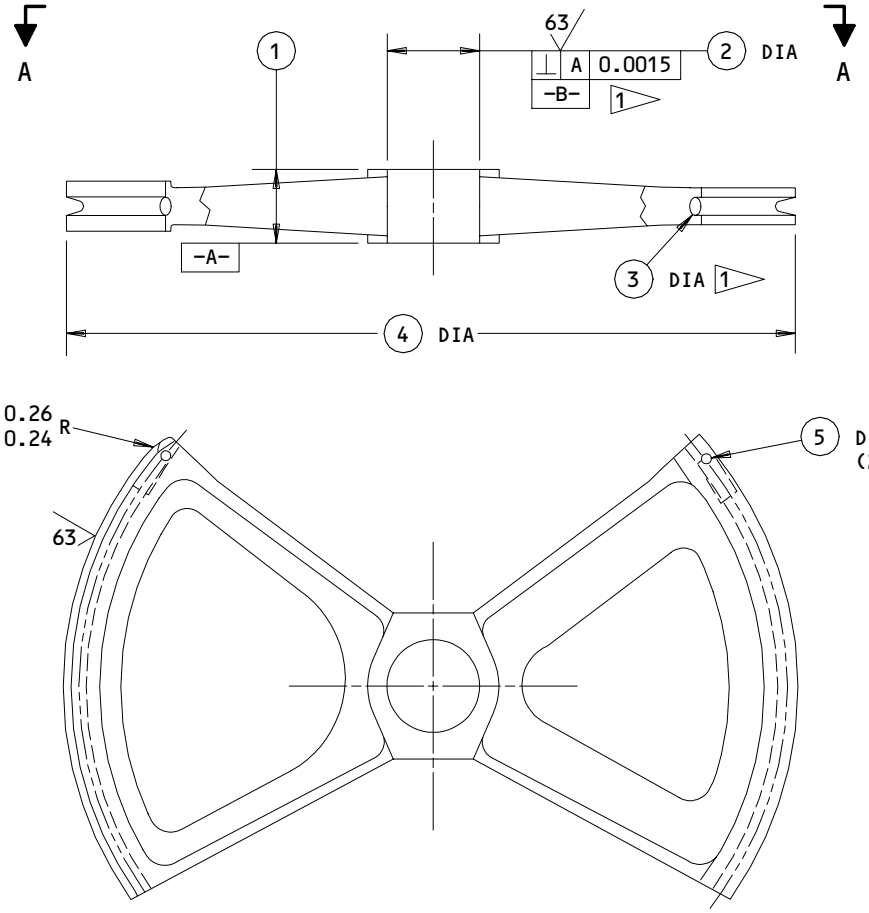
253T3527-1,-2
Shaft Repair and Refinish
Figure 601

QUADRANT ASSEMBLY - REPAIR 2-1

253T3528-1, -2

1. Coating Repair

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



A-A

	1	2	3	4	5
DESIGN DIM	0.805 0.795	1.0635 1.0620	0.224 0.221	8.381 8.371	0.083 0.073

REFINISH

ANODIZE (F-17.05) AND APPLY PRIMER,
BMS 10-11, TYPE 1 (F-20.02) EXCEPT AS NOTED.

1 OMIT PRIMER THIS AREA

REPAIR

(SAME AS REFINISH)
125 MACHINE FINISH EXCEPT AS NOTED
(250 FINISH ON FORGED SURFACES)

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

253T3528-1,-2
Quadrant Details
Figure 601

209574

CRANK ASSEMBLY - REPAIR 3-1

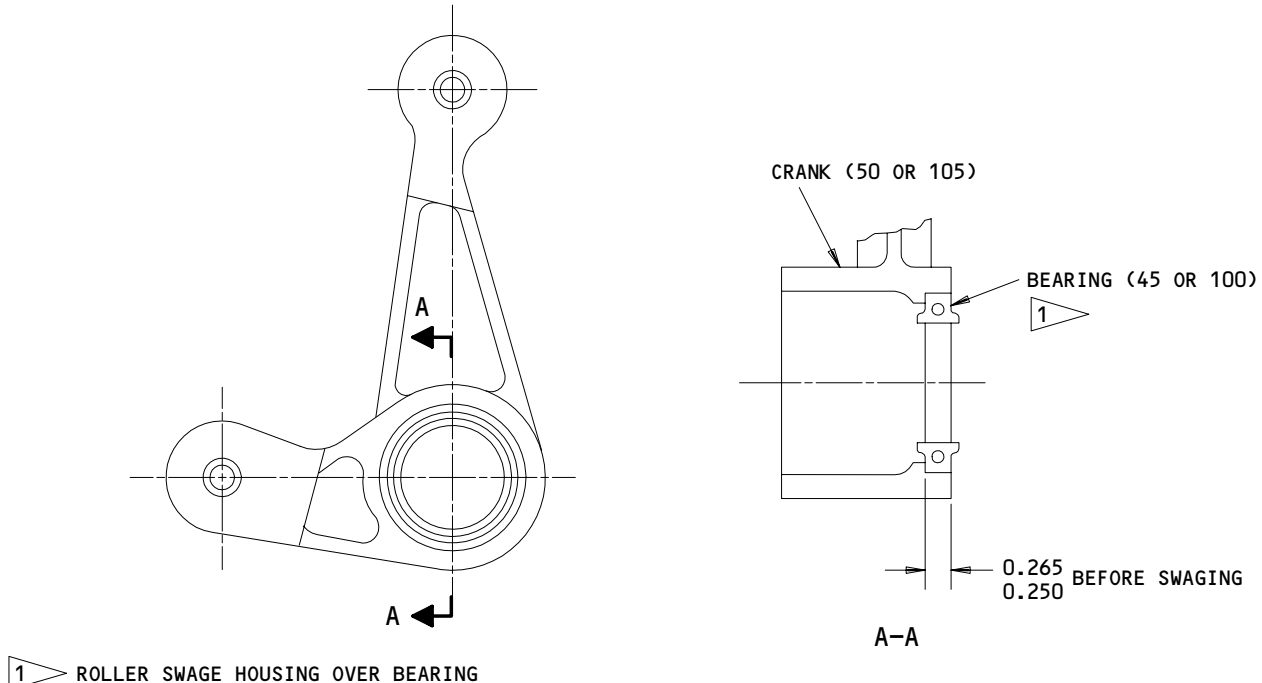
253T3529-1

NOTE: Refer to REPAIR-GEN for list of applicable standard practices. Refer to IPL Fig. 1 for item numbers. For repair of surfaces which may require only restoration of original finish, refer to Refinish instructions, REPAIR 3-2.

1. Bearing Replacement (Fig. 601)

   A. Remove bearing (45 or 100) from crank (50 or 105).

   B. Install and roller swage new bearing with wet BMS 10-11, type 1 primer per 20-50-03.



253T3529-1

Bearing Replacement
Figure 601

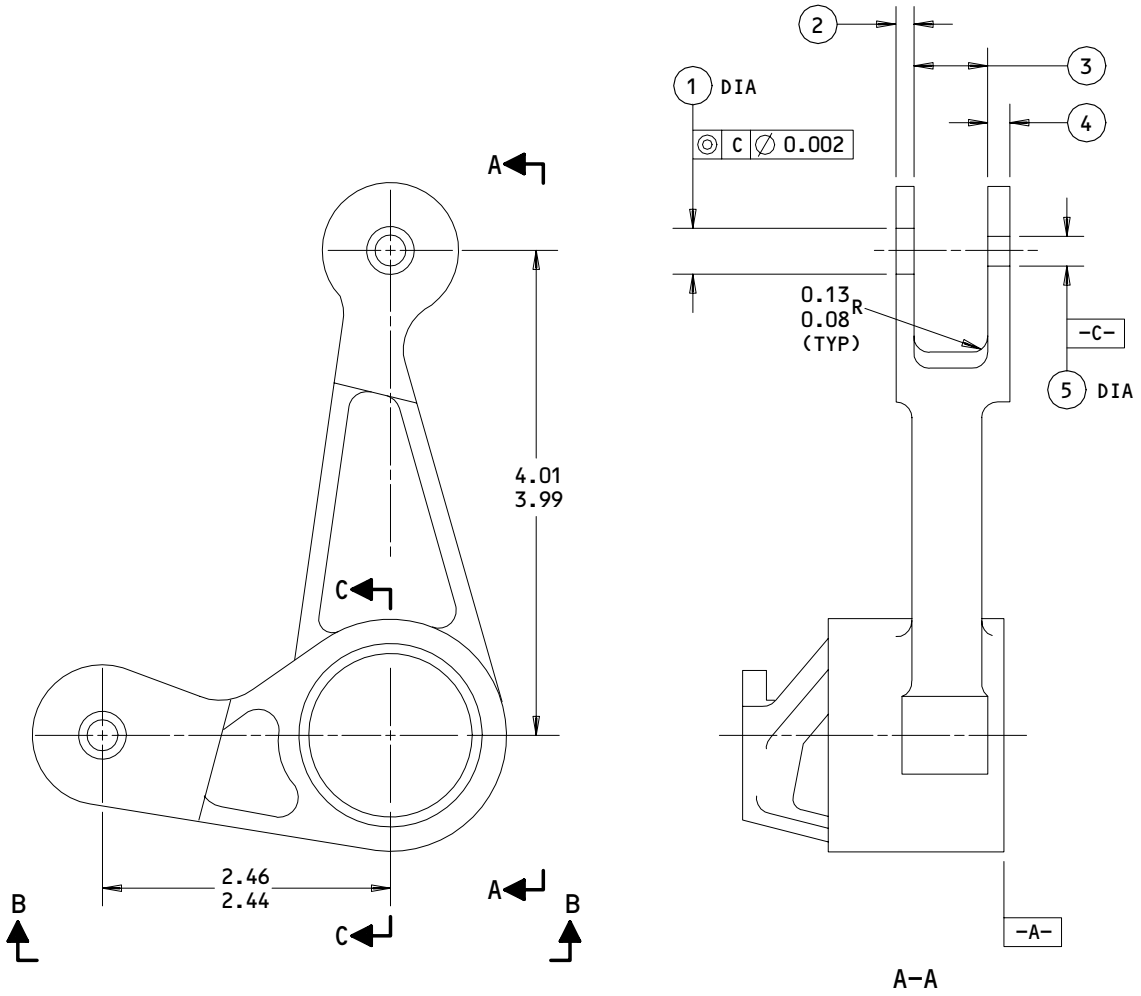
209926

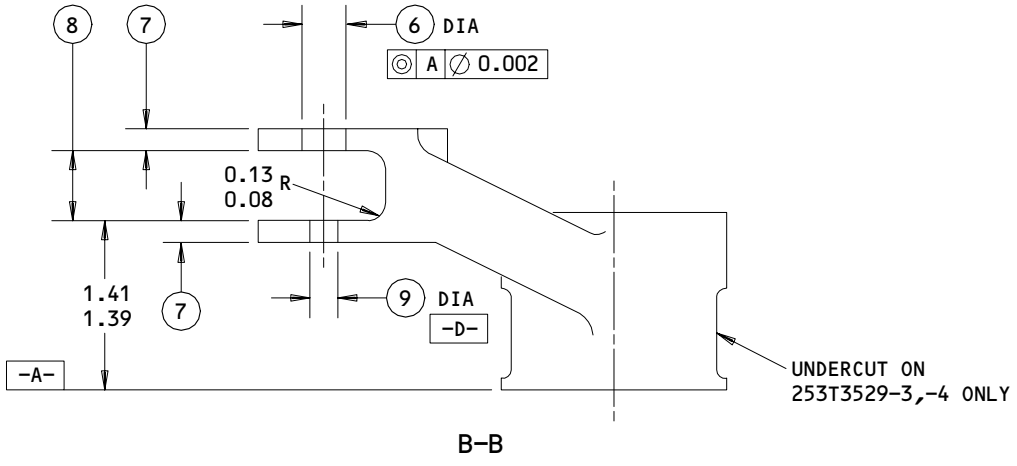
CRANK - REPAIR 3-2

253T3529-2, -3, -4

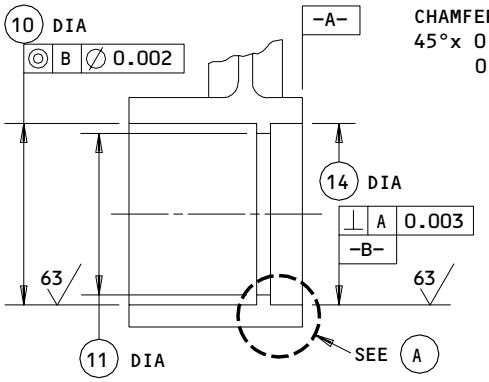
1. Coating Repair

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

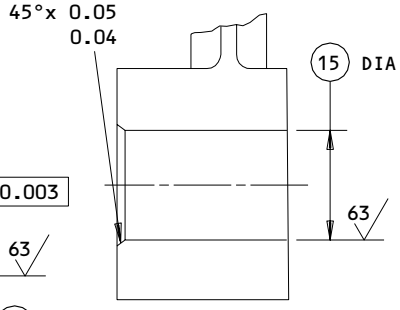




253T3529-2,-3,-4
Crank Repair and Refinish
Figure 601 (Sheet 1)

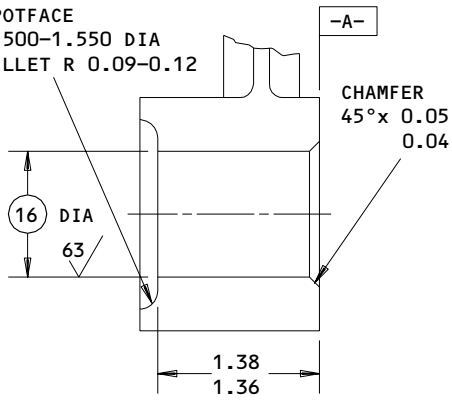


(253T3529-2)

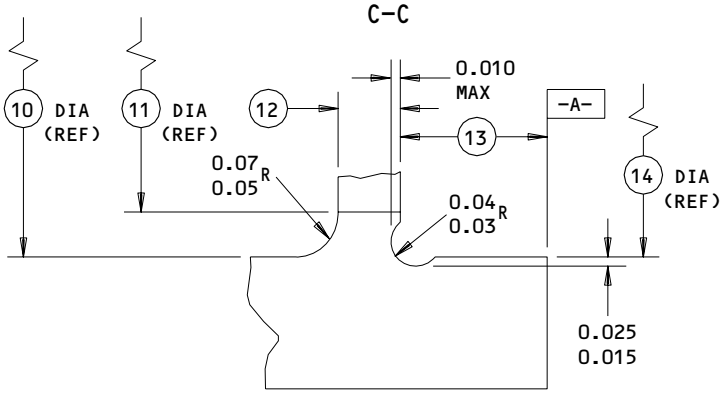


(253T3529-3)

C-C



(253T3529-4)



(253T3529-2)

A

	1	2	3	4	5	6	7	8	9
DESIGN DIM	0.3781 0.3766	0.15 0.13	0.615 0.605	0.20 0.18	0.2505 0.2495	0.3781 0.3766	0.17 0.15	0.615 0.605	0.2505 0.2495
REPAIR LIMIT	---	---	---	---	---	---	---	---	---

	10	11	12	13	14	15	16
DESIGN DIM	1.501 1.500	1.36 1.34	0.11 0.09	0.265 0.250	1.501 1.500	0.9077 0.9062	1.0635 1.0620
REPAIR LIMIT	---	---	---	---	---	---	---

REFINISH

ANODIZE (F-17.05) ALL OVER. APPLY PRIMER, BMS 10-11, TYPE 1 (F-20.02) EXCEPT OMIT PRIMER IN ALL HOLES.

REPAIR

(SAME AS REFINISH)

125 MACHINE FINISH EXCEPT AS NOTED

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

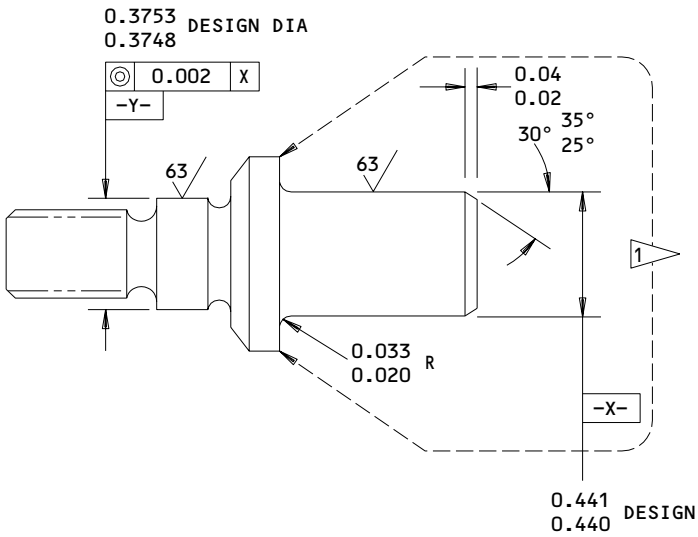
253T3529-2,-3,-4
Crank Repair and Refinish
Figure 601 (Sheet 2)

SHAFT - REPAIR 4-1

69B81260-1

1. Plating Repair

A. Repair is only replacement of the original finish. Refer to Refinish instructions, Fig. 601 and to REPAIR-GEN for a list of applicable standard practices.



REFINISH

CADMIUM PLATE (F-15.02) AREAS SHOWN BY 1.
PASSIVATE (F-17.09) ALL OTHER AREAS

REPAIR

(SAME AS REFINISH)

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: 17-4PH CRES, 180-200 KSI

ALL DIMENSIONS ARE IN INCHES

69B81260-1
Bearing Shaft Repair and Refinish
Figure 601

209515

MISCELLANEOUS PARTS REFINISH - REPAIR 5-1

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

IPL FIG. & ITEM	MATERIAL	FINISH
Fig. 1 Spacers (55 or 110, 60, 120)	Al alloy	Treat interior and exterior surfaces per MIL-C-5541 and apply one coat BMS 10-11, type 1 primer (F-18.07) except omit primer on interior surface.

Refinish Details
Figure 601

ASSEMBLY

1. Materials

   NOTE: Equivalent substitutes may be used.

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

2. Left-Hand Quadrant (IPL Fig. 1) (Fig. 701)

   A. Coat bearing shaft (175) with grease and install in shaft (85). Install pin (170) in shaft (85) and peen over shaft material for positive retention at both ends of pin.

   B. Coat mating surfaces of quadrant (80) and shaft (85) with grease; then install quadrant on shaft. Install parts (65, 70, 75).

   C. Install spacer (55) and bearing (35) per 20-50-03 in crank (40).

   D. Install spacer (60), crank (40), and nut (30) on shaft (85). With nut thread and locking insert fully engaged with the shaft thread, measure the max torque to rotate nut. Tighten nut with an additional torque of 100-200 lb-in.

   E. Coat mating surfaces of crank (25) and shaft (85) with grease; then install crank on shaft. Install bolt (10), washer (15) and nut (20).

3. Right hand quadrant (Fig. 702)

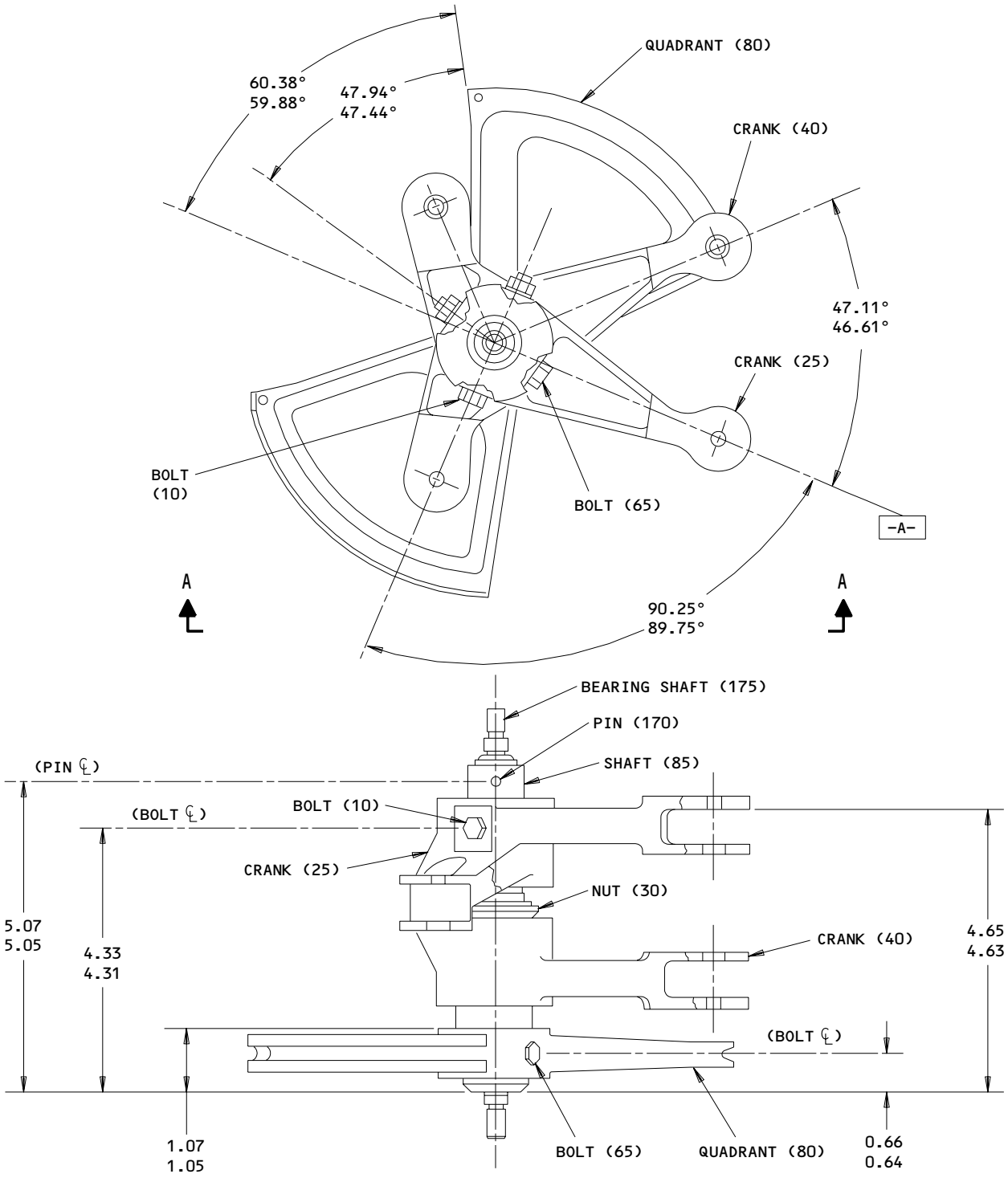
   A. Coat bearing shaft (175) with grease and install in shaft (165). Install pin (170) in shaft (165) and peen over shaft material for positive retention at both ends of pin.

   B. Coat mating surfaces of quadrant (160) and shaft (165) with grease; then install quadrant on shaft. Install parts (145, 150, 155).

   C. Coat mating surfaces of crank (140) and shaft (165) with grease; then install crank on shaft. Install bolt (125), washer (130), and nut (135).

   D. Install spacer (110) and bearing (115) per 20-50-03 in crank (95).

   E. Install spacer (120), crank (95), and nut (90) on shaft (165). With nut thread and locking insert fully engaged with the shaft thread, measure the max torque to rotate nut. Tighten nut with an additional torque of 100-200 lb-in.

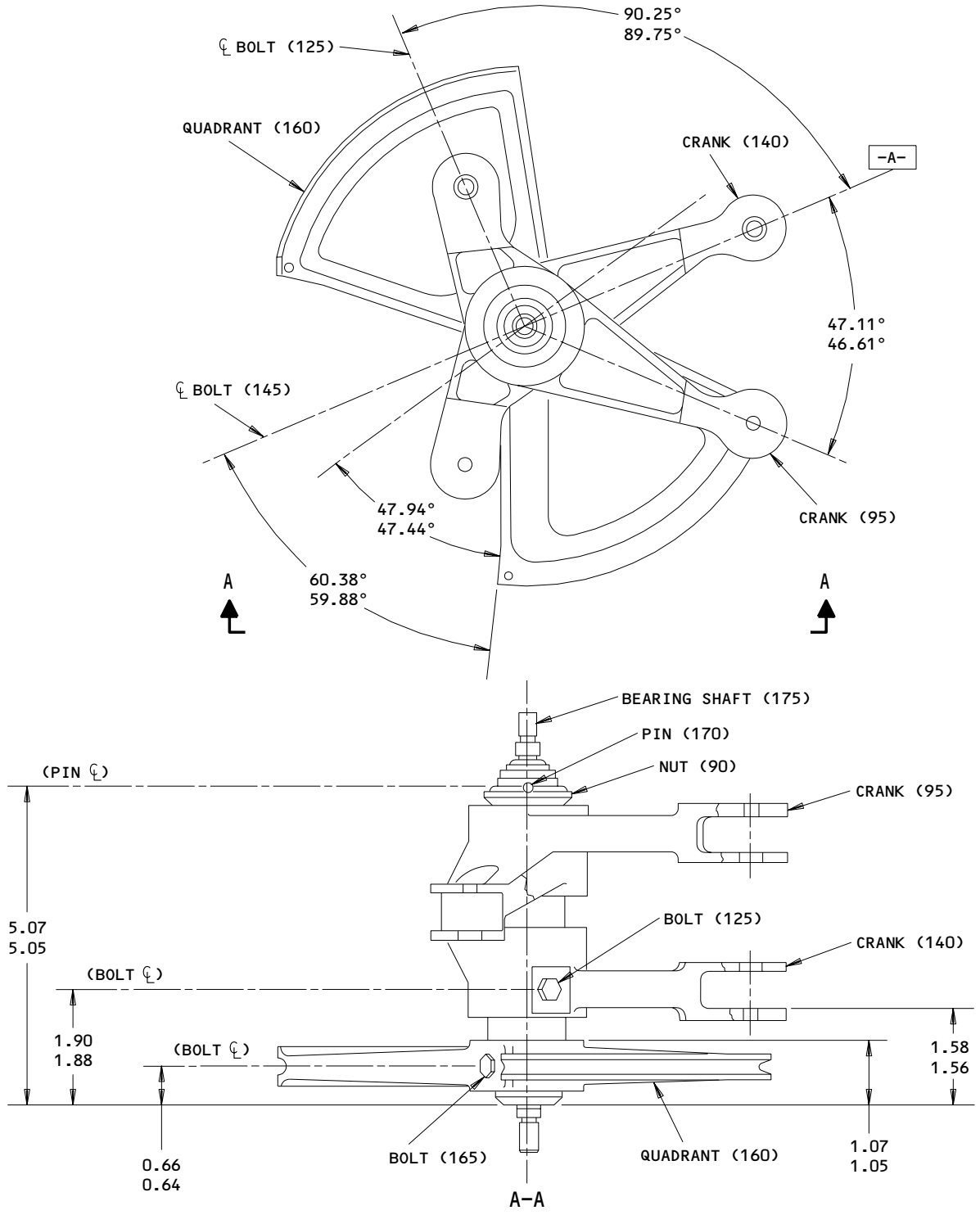


A-A

253T3526-2 (LH)

Assembly Details
Figure 701

209948



253T3526-2 (RH)

Assembly Details
Figure 702

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 are 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

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

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

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

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

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

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

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

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

56878 SPS TECHNOLOGIES INC
HIGHLAND AVENUE
JENKINTOWN, PENNSYLVANIA 19046

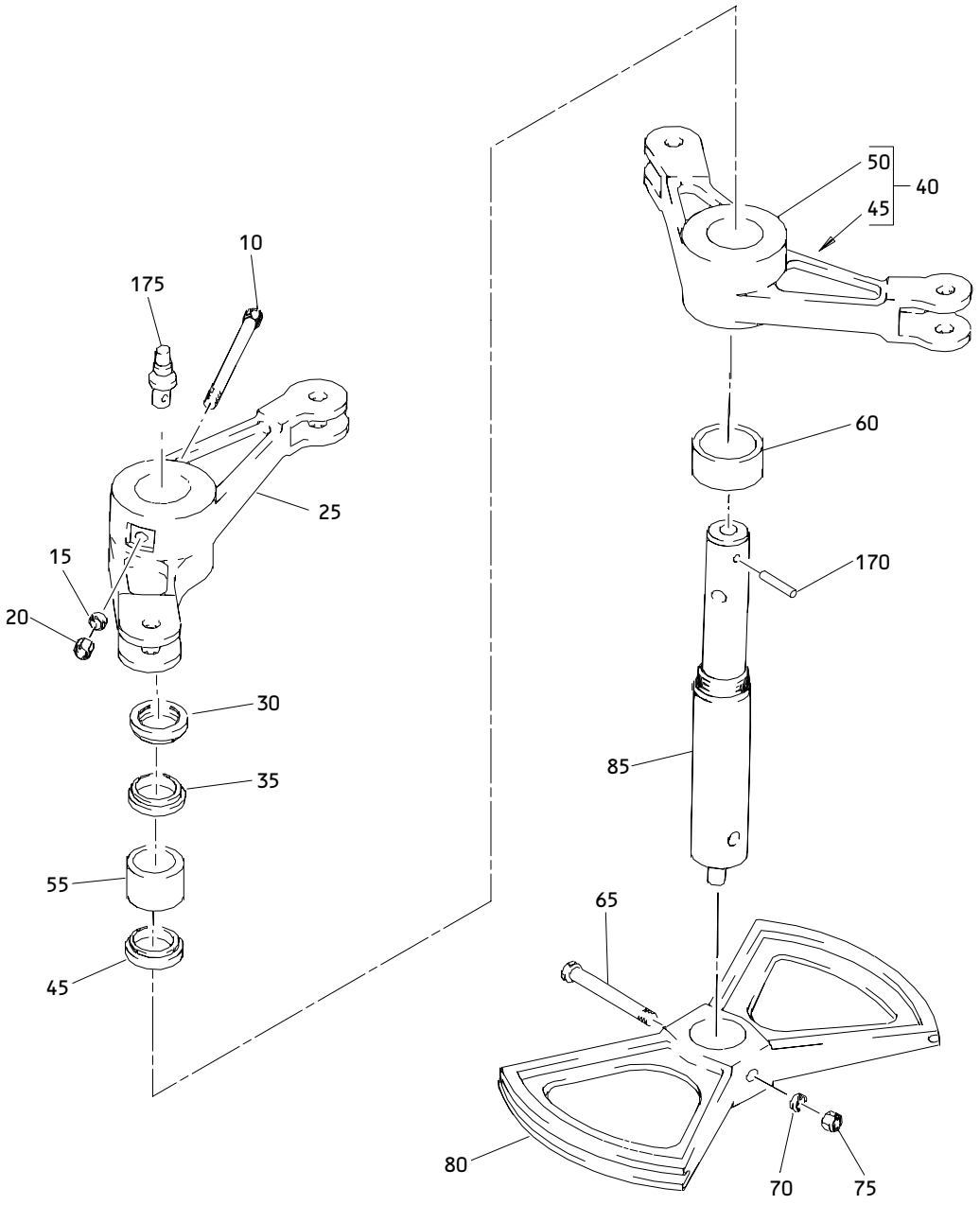
72962 AMERACE CORP ESNA DIV
2330 VAUXHALL ROAD
UNION, NEW JERSEY 07083

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

VENDORS

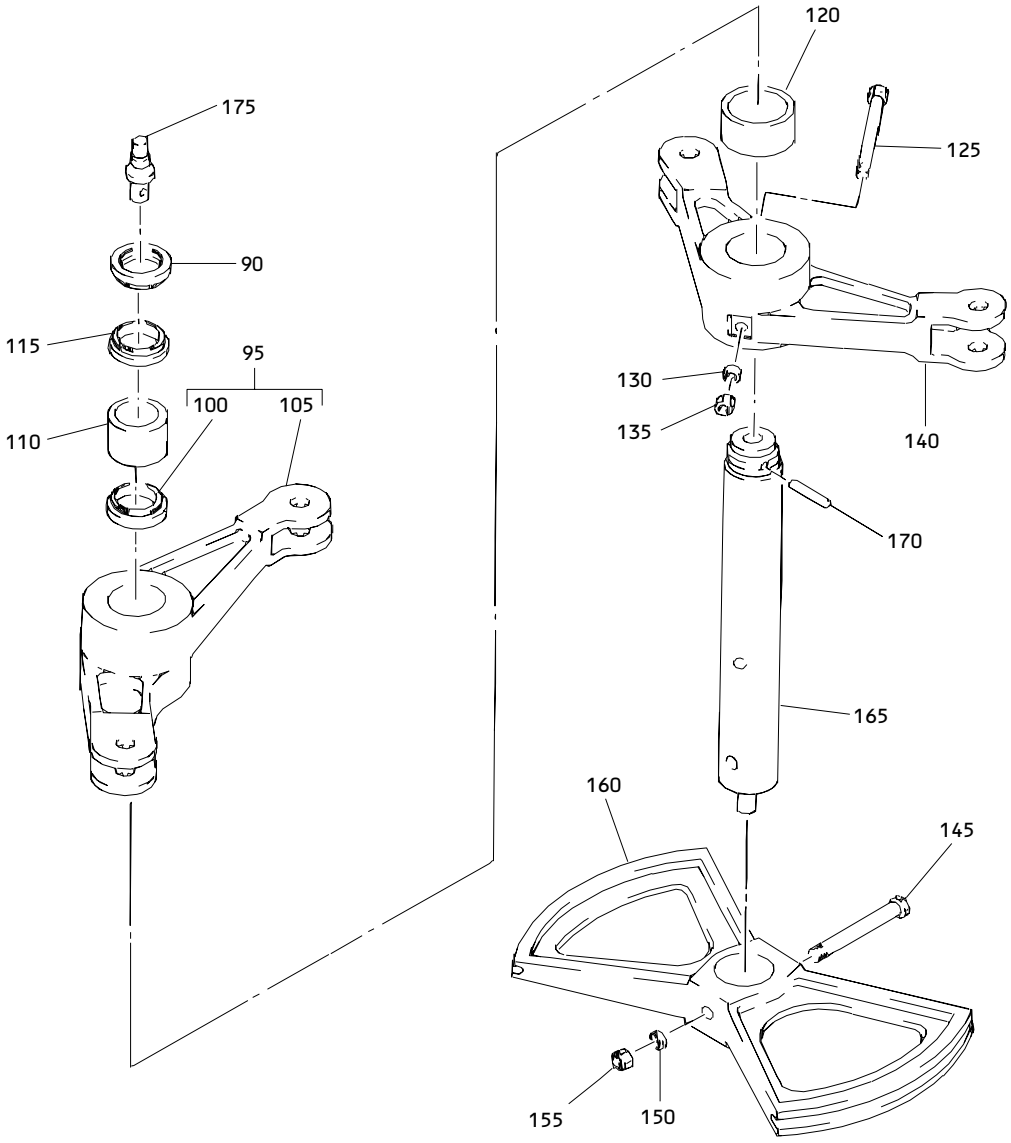
92215 VOI-SHAN DIV OF VSI CORP SUB OF FAIRCHILD INDUSTRIAL INC
8463 HIGUERA STREET
CULVER CITY, CALIFORNIA 90230

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



LH ASSEMBLY

253T3526-1
Main Landing Gear Brake Quadrant Assembly
Figure 1 (Sheet 1)



RH ASSEMBLY

253T3526-2

Main Landing Gear Brake Quadrant Assembly
Figure 1 (Sheet 2)

209299

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-1	253T3526-1		QUADRANT ASSY - MLG BRAKE (LH)	A	RF
-5	253T3526-2		QUADRANT ASSY - MLG BRAKE (RH)	B	RF
10	BACB30NF4-28		.BOLT- (V06710) (SPEC BACB30NF4-28) (OPT BACB30NF4-28) (V06725,V06950,V08524, V17943,V27624,V56878, V80539,V92215,V97928)	A	1
15	AN960JD416		.WASHER	A	1
20	BRH10C4MD		.NUT- (V52828) (SPEC BACN10JC4CD) (OPT H51650-4BAC (V15653)) (OPT 1022H9075-4W (V72962))	A	1
25	253T3529-3		.CRANK	A	1
30	BACN10RF242		.NUT	A	1
35	MS27646-41G		.BEARING	A	1
40	253T3529-1		.CRANK ASSY	A	1
45	MS27646-41G		..BEARING	A	1
50	253T3529-2		..CRANK	A	1
55	253T3520-6		.SPACER	A	1
60	253T3520-4		.SPACER	A	1
65	BACB30NF4-27		.BOLT- (V06710) (SPEC BACB30NF4-27) (FOR OPTIONAL VENDORS REFER TO ITEM 10)	A	1
70	AN960JD416		.WASHER	A	1
75	BRH10C4MD		.NUT- (V52828) (SPEC BACN10JC4CD) (FOR OPTIONAL PARTS REFER TO ITEM 20)	A	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
80	253T3528-1		.QUADRANT	A	1
-80A	253T3528-2		.QUADRANT (OPT)	A	1
85	253T3527-1		.SHAFT	A	1
90	BACN10RF242		.NUT	B	1
95	253T3529-1		.CRANK ASSY	B	1
100	MS27646-41G		..BEARING	B	1
105	253T3529-2		..CRANK	B	1
110	253T3520-6		.SPACER	B	1
115	MS27646-41G		.BEARING	B	1
120	253T3520-5		.SPACER	B	1
125	BACB30NF4-28		.BOLT- (V06710) (SPEC BACB30NF4-28) (FOR OPTIONAL PARTS REFER TO ITEM 10)	B	1
130	AN960JD416		.WASHER	B	1
135	BRH10C4MD		.NUT- (V52828) (SPEC BACN10JC4CD) (FOR OPTIONAL PARTS REFER TO ITEM 20)	B	1
140	253T3529-4		.CRANK	B	1
145	BACB30NF4-27		.BOLT- (V06710) (SPEC BACB30NF4-27) (FOR OPTIONAL VENDORS REFER TO ITEM 10)	B	1
150	AN960JD416		.WASHER	B	1
155	BRH10C4MD		.NUT- (V52828) (SPEC BACN10JC4CD) (FOR OPTIONAL PARTS REFER TO ITEM 20)	B	1
160	253T3528-1		.QUADRANT	B	1
160A	253T3528-2		.QUADRANT (OPT)	B	1
165	253T3527-2		.SHAFT	B	1
170	MS39086-150		.PIN, SPRING		1
175	69B81260-1		.SHAFT, BEARING		1