TO: ALL HOLDERS OF TAIL SKID INSTALLATION COMPONENTS COMPONENT MAINTENANCE MANUAL 32-71-06

REVISION NO. 1 DATED JUL 01/01

HIGHLIGHTS

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

CHAPTER/SECTION AND PAGE NO.	DESCRIPTION OF CHANGE
TITLE PAGE 1 REPAIR 1-1 601 1002-1004,1006-1008, 1011-1012	Added door assembly 148T7703-6 with a different finish.
TITLE PAGE 1 REPAIR 2-1 601,603-607 1002-1004,1006-1008, 1011-1012	Added lever assembly 163T1000-3 with decreased lube fitting height for a better fit.
TITLE PAGE 1 CONTENTS 1 REPAIR-GEN 601-602 REPAIR 1-1 601 REPAIR 2-1 601-602,607,610 REPAIR 3-1 601-602	Added clarifications and updated callouts.

CHAPTER/SECTION AND PAGE NO.	DESCRIPTION OF CHANGE
REPAIR 4-1	HIGHLIGHT CONTINUED FROM PREVIOUS PAGE
601-602	
REPAIR 5-1	
601-602	
REPAIR 6-1	
601-602	
REPAIR 7-1	
601	
REPAIR 8-1	
601	
1002-1004,1006-1008,	
1011-1012	

TAIL SKID INSTALLATION COMPONENTS

PART NUMBERS 148T7703-1,-6
163T1000-1,-3
163T3002-1,-2
163T3004-1
163T3005-1
163T3006-1

COMPONENT MAINTENANCE MANUAL
WITH
ILLUSTRATED PARTS LIST

BOEING
COMPONENT
MAINTENANCE MANUAL

REVISION RECORD

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

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

TEMPORARY REVISION AND SERVICE BULLETIN RECORD

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVE	DATE OF INCORPORATION INTO MANUAL

PAGE	DATE	CODE
32-71-06		
TITLE PAGE		
*1	JUL 01/01	01.1
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	JUL 01/01	01
THRU LAST PAGE		
CONTENTS		
*1	JUL 01/01	01.1
2	BLANK	
INTRODUCTION		
1	APR 10/86	01
2	BLANK	
REPAIR-GENERAL		
*601	JUL 01/01	01.1
*602	JUL 01/01	01.1
REPAIR 1-1		
*601	JUL 01/01	01.1
602	BLANK	
REPAIR 2-1		
*601	JUL 01/01	01.1
*602	JUL 01/01	01.1
*603	JUL 01/01	01.1
*604	JUL 01/01	01.1
*605	JUL 01/01	01.1
*606	JUL 01/01	01.1
*607	JUL 01/01	01.1

PAGE	DATE	CODE
REPAIR 2-1		CONT.
608	APR 10/86	01
609	APR 10/86	01
*610	JUL 01/01	01.1
REPAIR 3-1		
*601	JUL 01/01	01.1
*602	JUL 01/01	01.1
REPAIR 4-1		
*601	JUL 01/01	01.1
*602	JUL 01/01	01.1
REPAIR 5-1		
*601	JUL 01/01	01.1
*602	JUL 01/01	01.1
REPAIR 6-1		
*601	JUL 01/01	01.1
*602	JUL 01/01	01.1
REPAIR 7-1		
*601	JUL 01/01	01.1
602	APR 10/86	01
REPAIR 8-1		
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ILLUSTRATED PARTS LIST		
1001	APR 10/86	01
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*1009	BLANK	
*1010	JUL 01/01	01.1
*1011	JUL 01/01	01.1
*1012	JUL 01/01	01.1

* = REVISED, ADDED OR DELETED

TABLE OF CONTENTS

NOTE: This manual contains overhaul data for various components of the Tail Skid Installation. Overhaul functions which cannot be performed by use of standard industry practices are included in the repair instructions for each component.

INTRODUCTION

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

This manual is divided into separate sections:

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

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

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

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

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

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

REPAIR - GENERAL

1. Content

   A. Each separate repair, as applicable, includes check, repair, and refinish instructions.

2. Standard Practices

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

SOPM 20-20-01	Magnetic Particle Inspection
SOPM 20-20-02	Penetrant Methods of Inspection
SOPM 20-30-03	General Cleaning Procedures
SOPM 20-41-01	Decoding Table for Boeing Finish Codes
SOPM 20-41-02	Application of Chemical and Solvent Resistant Finishes
SOPM 20-41-04	Application and Repair of Interior Decorative Finishes
SOPM 20-42-05	Bright Cadmium Plating
SOPM 20-43-01	Chromic Acid Anodizing
SOPM 20-50-03	Bearing and Bushing Replacement
SOPM 20-50-05	Application of Aluminum Foil and Other Markers
SOPM 20-50-19	General Sealing
SOPM 20-60-02	Finishing Materials
SOPM 20-60-03	Lubricants
SOPM 20-60-04	Miscellaneous Materials

3. Materials

NOTE: Equivalent substitutes can be used.

A. Antistatic Coating -- BMS 10-21, type 3 (SOPM 20-60-04)

B. Corrosion Preventive Compound -- MIL-C-11796, class 1 (SOPM 20-60-03)

C. Enamel -- BMS 10-11, type 2 (SOPM 20-60-02)

D. Enamel -- BMS 10-60, type 2 (SOPM 20-60-02)

E. Grease -- BMS 3-33 or MIL-G-23827 (SOPM 20-60-03)

F. Primer -- BMS 10-11, type 1 (SOPM 20-60-02)

G. Primer -- BMS 10-79, type 2 (SOPM 20-60-02)

H. Protective Finish -- Type 41 (SOPM 20-60-02)

I. Sealant -- BMS 5-95 (SOPM 20-60-04)

4. Dimensioning Symbols

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

TAIL SKID DOOR ASSEMBLY - REPAIR 1-1

148T7703-1, -3

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

1. Seal Replacement

   A. Remove the old seal (65) and seal retainer (70).

   B. Install a replacement seal and seal retainer.

   C. Install plugs (75) and seal them with type 68 adhesive (SOPM 20-50-12).

2. Refinish

   A. Bond Assembly (80)

      (1) 148T7703-2 -- External Surfaces: Prepare the surface (SRF-14.672). Apply BMS 10-21, type 3 coating (F-14.685, which replaces SRF-14.68). Apply BMS 10-103, type 1 primer and BMS 10-60, type 2 enamel (F-19.41-707). Internal surfaces: Prepare the surface (SRF-14.672, which replaces F-14.67). Apply BMS 10-103, type 1 primer and BMS 10-60, type 2 enamel (F-19.41-707).

      (2) 148T7703-7 -- External surfaces: Prepare the surface (F-14.679). Apply BMS 10-21, type 3 coating (F-14.685). Apply BMS 10-103, type 1 primer (F-14.692) and BMS 10-60, type 2 enamel (F-19.39-707). Internal surfaces: Prepare the surface (F-14.679). Apply BMS 10-103, type 1 primer (F-14.692) and BMS 10-60, type 2 enamel (F-19.39-707).

   B. Seal Retainer (70) -- Chemical treat and apply BMS 10-11, type 1 primer (F-18.06) and BMS 10-11, type 2 enamel (F-21.02).

LEVER FITTING ASSEMBLY - REPAIR 2-1

163T1000-1, -3

NOTE: Refer to REPAIR-GEN for a list of applicable standard practices. Refer to IPL Fig. 2 for item numbers.

1. Check

   A. Magnetic particle examine lever (5) (SOPM 20-20-01).

2. Repair

   A. Bushing Replacement (Fig. 601)

      (1) Remove the old bushings.

      (2) If you find defects on the lever surfaces, refer to par. 2.B. for repair instructions.

      (3) Install replacement bushings by the shrink-fit method (SOPM 20-50-03). Install bushings (5, 10) with grease, and install bushings (15) with wet BMS 5-95 sealant.

      (4) Seal the bushings per Fig. 605, or per SOPM 20-50-19.

      (5) Apply grease at the lube fittings until you see grease at the ID of the bushings, to make sure the lube passages are not blocked.

   B. Lug Faces and Holes (Fig. 602).

      (1) Installation of Oversize Bushings

         (a) Machine as required, within repair limits, to remove defects.

         (b) Shot-peen, cadmium-titanium plate and apply primer BMS 10-11, type 1.

         (c) Make oversize bushings (Fig. 603 and 604) as necessary to adjust for the material removed.

         (d) Install the bushings per par. 2.A.

   C. Refinish

      (1) For repair of surfaces which is only replacement of the original finish, refer to Refinish instructions, Fig. 602.

3. Assembly

A. Install attach clips (55, 60, 65, 70) with faying surface sealant.

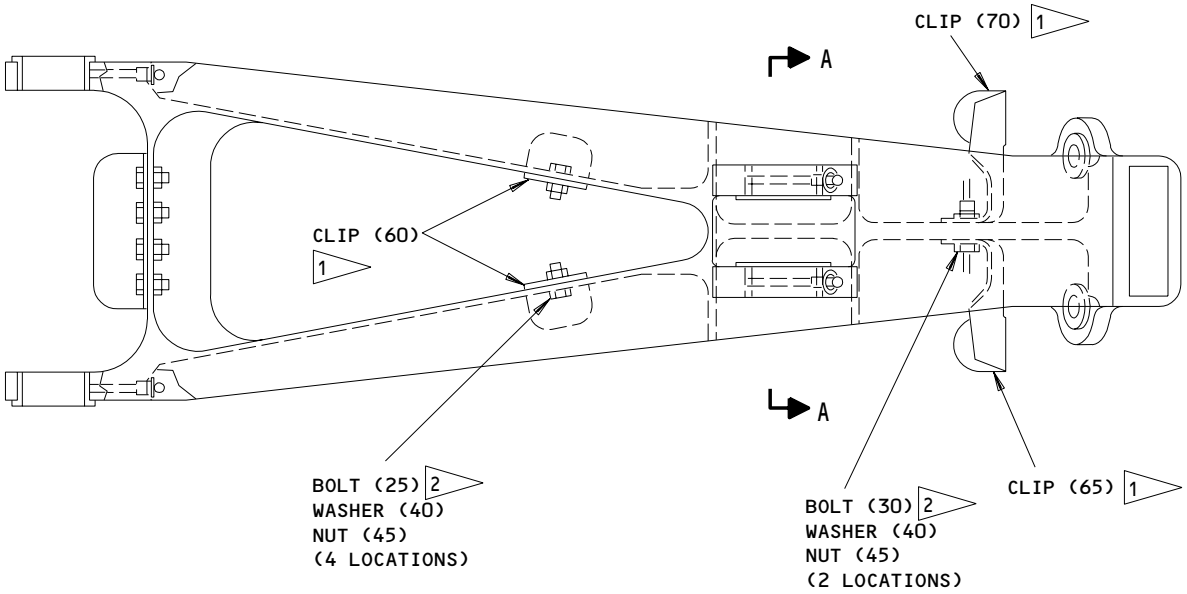
B. Install bolts (25, 30, 35) with sealant.

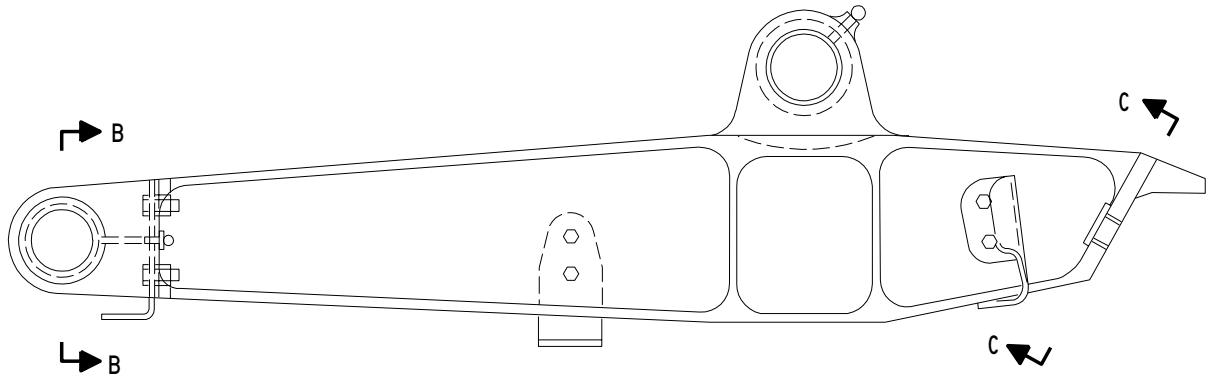
(1) Apply sealant to the shank of the bolts. Make sure all of the threads of the bolt are covered with sealant before you put the bolt into the hole.

(2) Install bolts (25, 30, 35), washers (40) and nuts (45).

(3) Tighten nuts within the application time of sealant. Clean off unwanted sealant.

(4) Fillet seal the bolts.

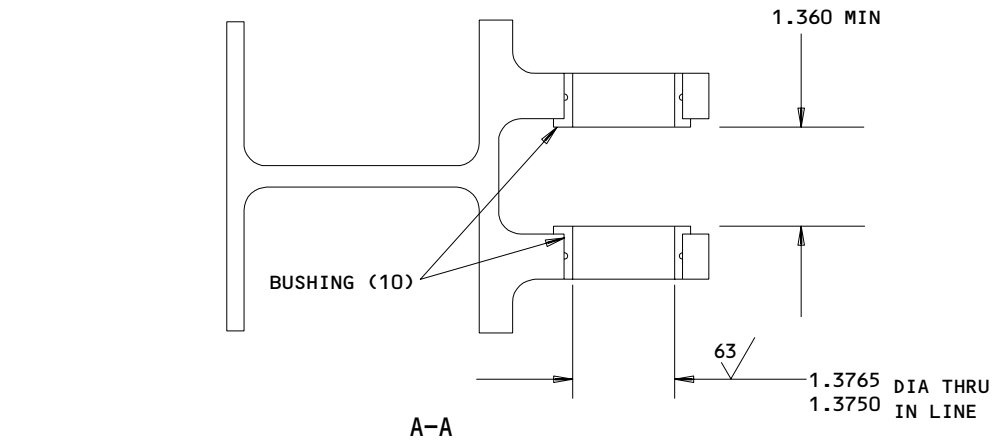




ALL DIMENSIONS ARE IN INCHES

163T1000-1,-3
Bushing Replacement
Figure 601 (Sheet 1)

209184

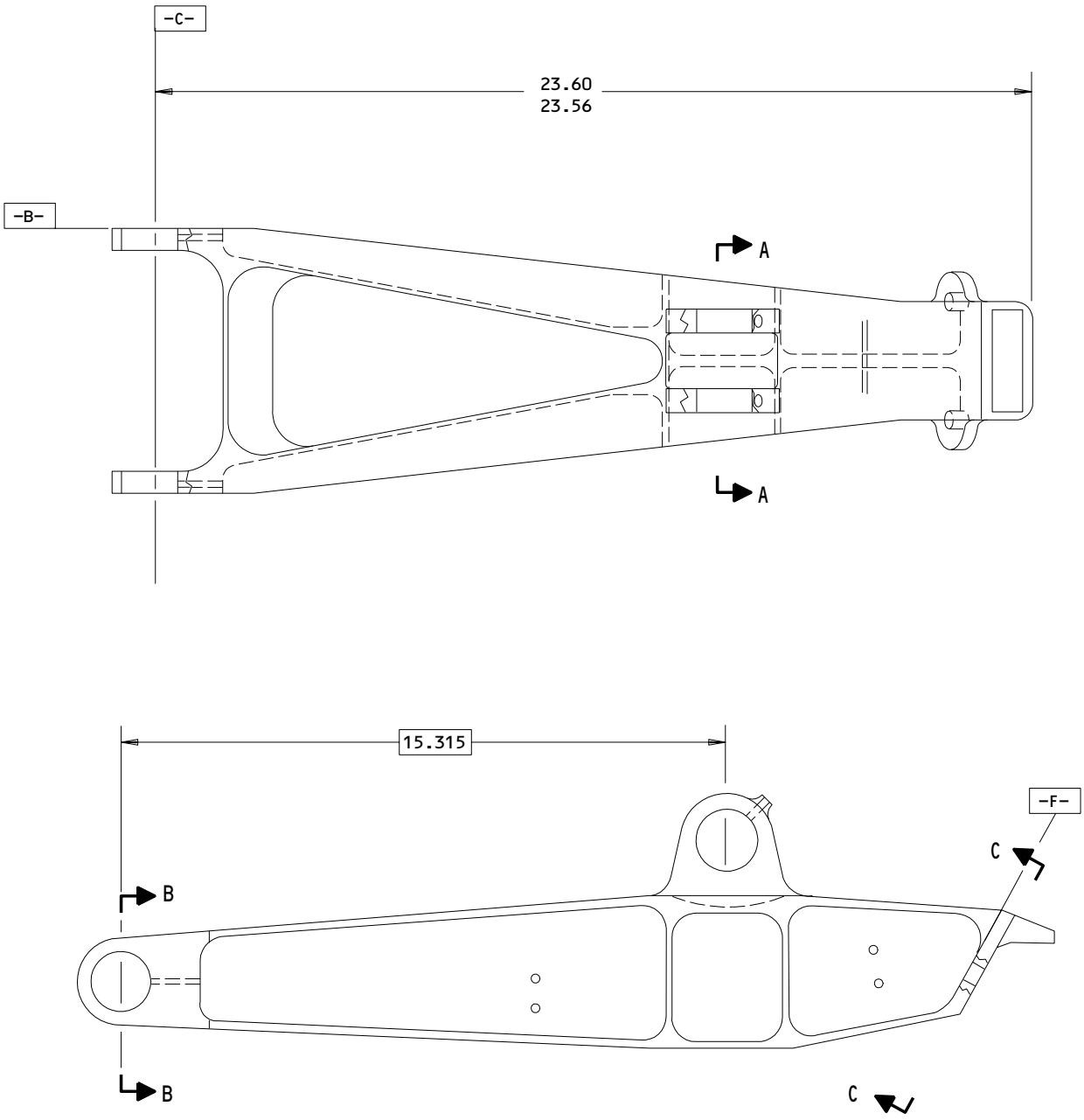


1 FAY SURFACE SEAL

2 INSTALL THE BOLT WITH SEALANT, AND FILLET SEAL THE BOLT

ALL DIMENSIONS ARE IN INCHES

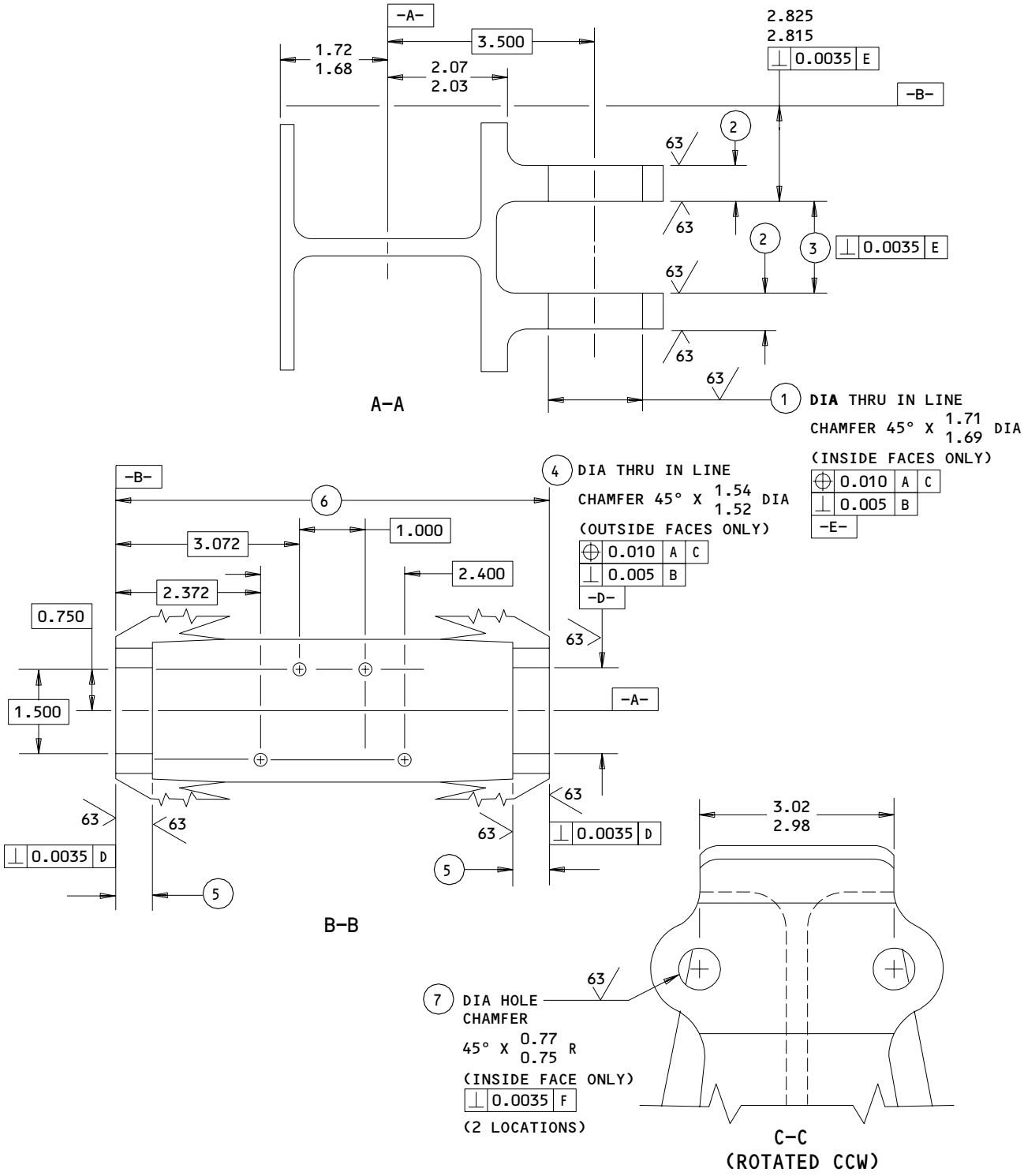
163T1000-1,-3
Bushing Replacement
Figure 601 (Sheet 2)



ALL DIMENSIONS ARE IN INCHES

163T1000-2,-4
Lever Repair and Refinish
Figure 602 (Sheet 1)

209303



ALL DIMENSIONS ARE IN INCHES

163T1000-2,-4
Lever Repair and Refinish
Figure 602 (Sheet 2)

209312

	(1)	(2)	(3)	(4)	(5)	(6)	(7)
DESIGN DIM	1.5765 1.5750	0.610 0.590	1.510 1.490	1.4165 1.4150	0.610 0.590	7.1434 7.1384	0.6665 0.6650
REPAIR LIMIT	1.6365 ▷1	0.575 ▷2	1.525 ▷2	1.4765 ▷1	0.575 ▷2	7.1084 ▷2	0.7265 ▷1

REFINISH

CADMIUM-TITANIUM PLATE (F-15.01). APPLY BMS 10-11, TYPE I, PRIMER (F-20.02). AFTER BUSHING AND LUBE FITTING INSTALLATION, APPLY BMS 10-60 COLOR 707 GRAY GLOSS ENAMEL (F-14.9813, WHICH REPLACES SRF-14.9813) BUT NOT ON BUSHINGS OR LUBE FITTINGS

▷1 LIMIT FOR INSTALLATION OF OVERSIZE BUSHINGS

▷2 LUG FACE MACHINING REQUIREMENTS:

1. MATERIAL REMOVED FROM ANY FACE MUST NOT BE MORE THAN HALF THE DIFFERENCE BETWEEN THE DESIGN DIMENSION AND REPAIR LIMIT
2. FLAT SURFACE MUST BE MINIMUM OF 0.02 LARGER THAN FLANGE DIAMETER OF BUSHING TO BE INSTALLED
3. BLEND MISMATCH STEPS TO 0.18-0.26 RADIUS OR IF WITHIN 0.10 OF LUG FILLET RADIUS, USE SAME RADIUS AS LUG FILLET. BREAK SHARP EDGES 0.03-0.07 R

REPAIR

REF ▷1 ▷2

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

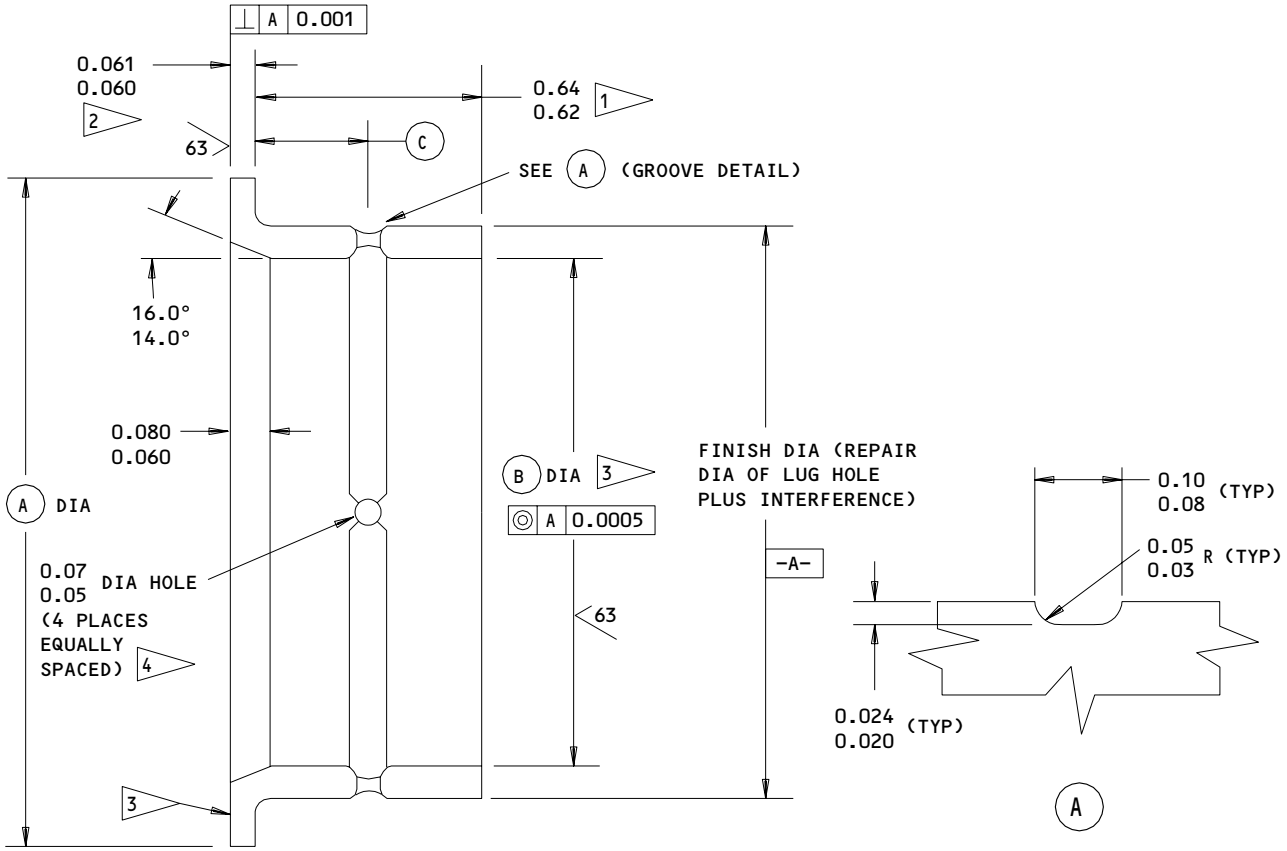
BREAK CORNERS 0.06-0.09 R UNLESS SHOWN DIFFERENTLY

SHOT PEEN: 0.016-0.033 SHOT SIZE
0.012 A2 INTENSITY

MATERIAL: 4340M STEEL (275-300 KSI)

ALL DIMENSIONS ARE IN INCHES

163T1000-2,-4
Lever Repair and Refinish
Figure 602 (Sheet 3)



HOLE LOCATION (FIG. 602)	A	B	C	INTER-FERENCE
1	1.93 1.87	1.3798 1.3783	0.32 0.30	0.0007- 0.0034
4	1.71 1.65	1.2547 1.2532	0.29 0.27	0.0008- 0.0038

1 MINUS AMOUNT REMOVED FROM LUG FACE

2 PLUS AMOUNT REMOVED FROM LUG FACE

3 NO PLATING ON ID AND BUSHING FACE

4 HOLES TO INTERSECT GROOVES

125 ALL MACHINED SURFACES EXCEPT AS NOTED

BREAK SHARP EDGES 0.01-0.02 R

CADMIUM PLATE 0.0003-0.0005 THICK, EXCEPT AS NOTED

MATERIAL: AL-NI-BRZ PER AMS 4640

ALL DIMENSIONS ARE IN INCHES

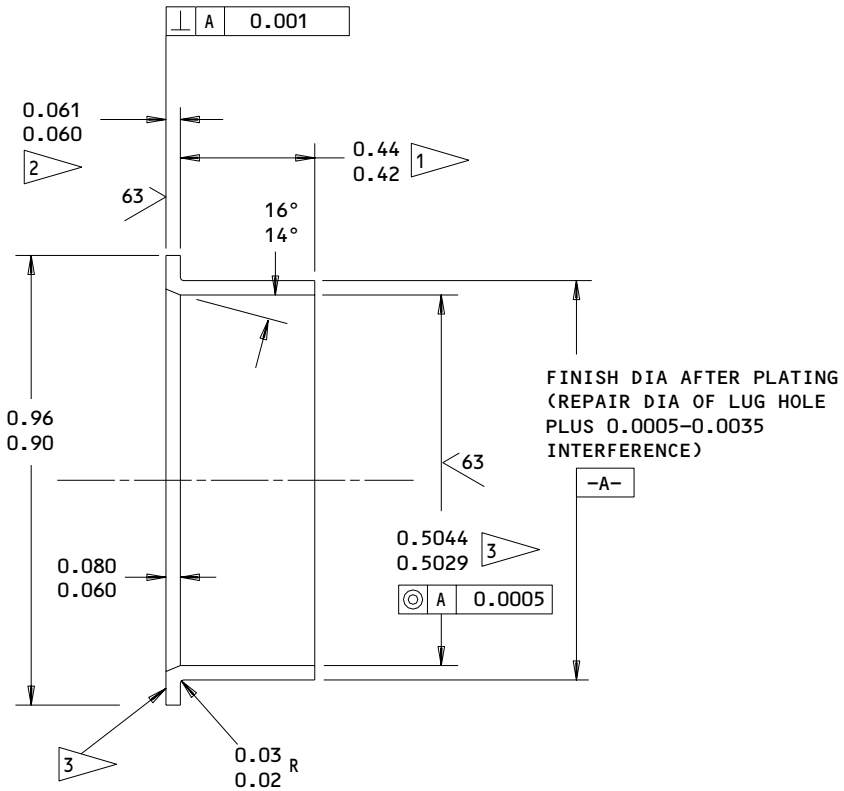
ALL DIMENSIONS APPLY BEFORE PLATING

HOLE LOCATION (1) - REPLACES BUSHING 163T3001-2 (10, IPL FIG. 2)

HOLE LOCATION (4) - REPLACES BUSHING 163T3001-1 (5, IPL FIG. 2)

Oversize Bushing Details
Figure 603

209499



1 MINUS AMOUNT REMOVED FROM LUG FACE

2 PLUS AMOUNT REMOVED FROM LUG FACE

3 NO PLATING ALLOWED BUSHING ID AND FACE

125 ALL MACHINED SURFACES EXCEPT AS NOTED

BREAK SHARP EDGES 0.01–0.02 R

CADMIUM PLATE (F–15.06, 0.0003 MIN) ALL OVER EXCEPT AS NOTED

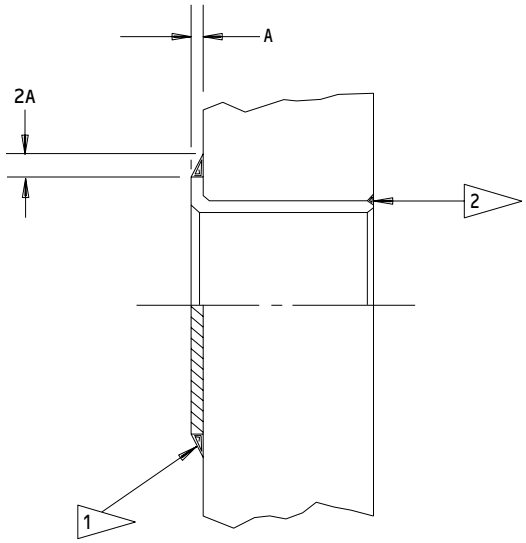
MATERIAL: AL–NI–BRZ PER AMS 4640

ALL DIMENSIONS ARE IN INCHES

HOLE LOCATION (7) FIG. 602

REPLACES BUSHING 163T3001-4 (15, IPL FIG. 2)

Oversize Bushing Details
Figure 604



1 CONTINUOUS FILLET SEAL MUST GO TO THE TOP OF THE BUSHING FLANGE EDGE AND BE IN THE RATIO SHOWN. OPTIONAL: SEAL AS SHOWN IN SOPM 20-50-19. DO NOT APPLY SEALANT TO BUSHING FACE

2 FILL CAVITY AROUND BUSHING. MAKE SURE THE SEALANT IS FLUSH WITH THE SURFACE

Bushing Sealing Details
Figure 605

END CAP - REPAIR 3-1

163T3002-1, -2

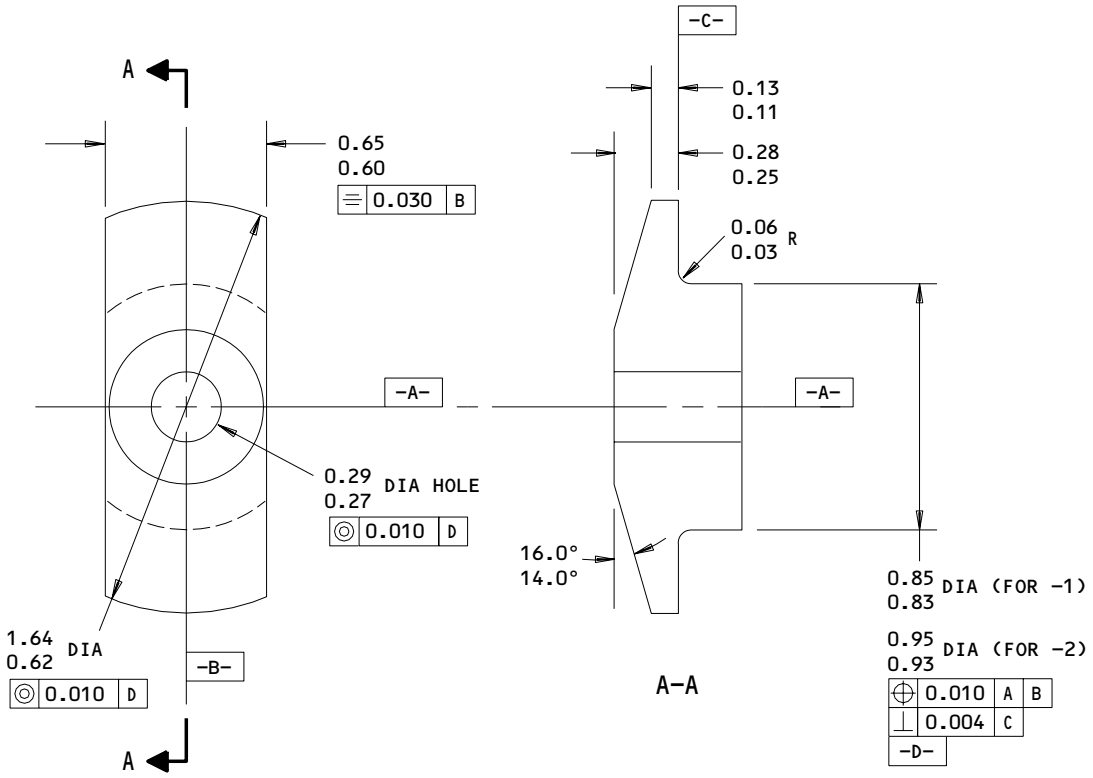
NOTE: Refer to REPAIR - GENERAL for a list of applicable standard practices.

1. Check

   A. Penetrant examine the cap (SOPM 20-20-02).

2. Repair (Fig. 601)

   A. Repair is only replacement of the original finish. Refer to Refinish instructions shown.



REFINISH

CHROMIC ACID ANODIZE AND APPLY BMS 10-11, TYPE 1, PRIMER (F-18.13)

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

163T3002-1,-2
Refinish Details
Figure 601

LEVER ATTACH PIN - REPAIR 4-1

163T3004-1

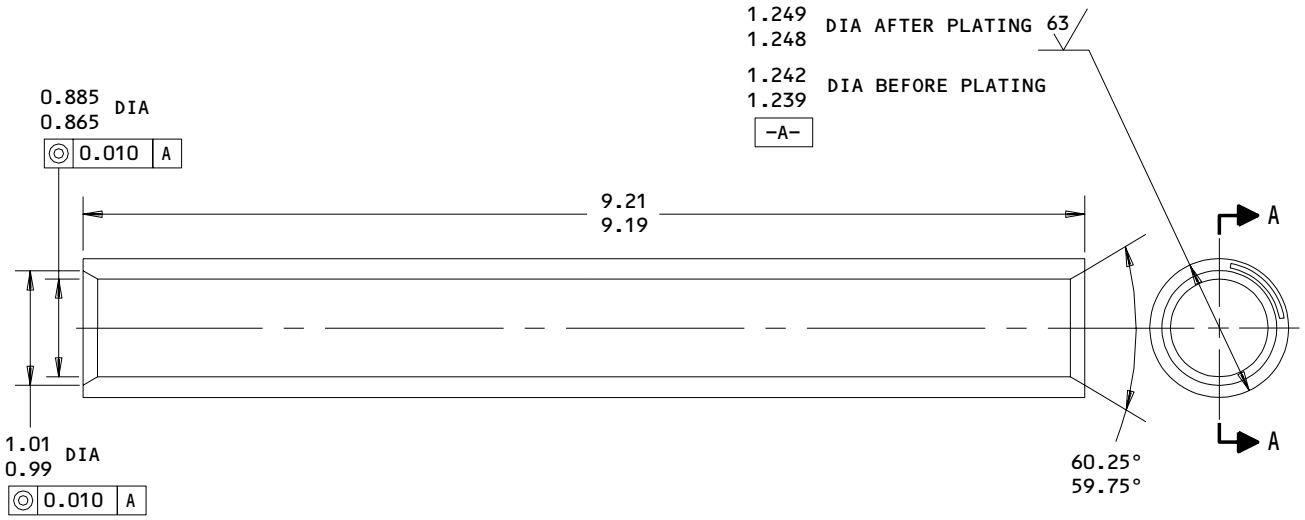
NOTE: Refer to REPAIR-GEN for a list of applicable standard practices.

1. Check

   A. Magnetic particle examine the pin (SOPM 20-20-01).

2. Repair (Fig. 601)

   A. Repair is only replacement of the original finish. Refer to Refinish instructions shown.



A-A

REFINISH

CHROME PLATE (F-15.34) THE OUTSIDE DIAMETER. WIPE THE PLATING WITH PRIMER (F-19.45). PASSIVATE (F-17.25, WHICH REPLACES F-17.09) ALL OTHER SURFACES

REPAIR

(SAME AS REFINISH)

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK EDGES 0.02-0.04 R

MATERIAL: 15-5PH CRES (180-200 KSI)

ALL DIMENSIONS ARE IN INCHES

163T3004-1
Lever Attach Pin Refinish
Figure 601

209507

ATTACH PIN - REPAIR 5-1

163T3005-1

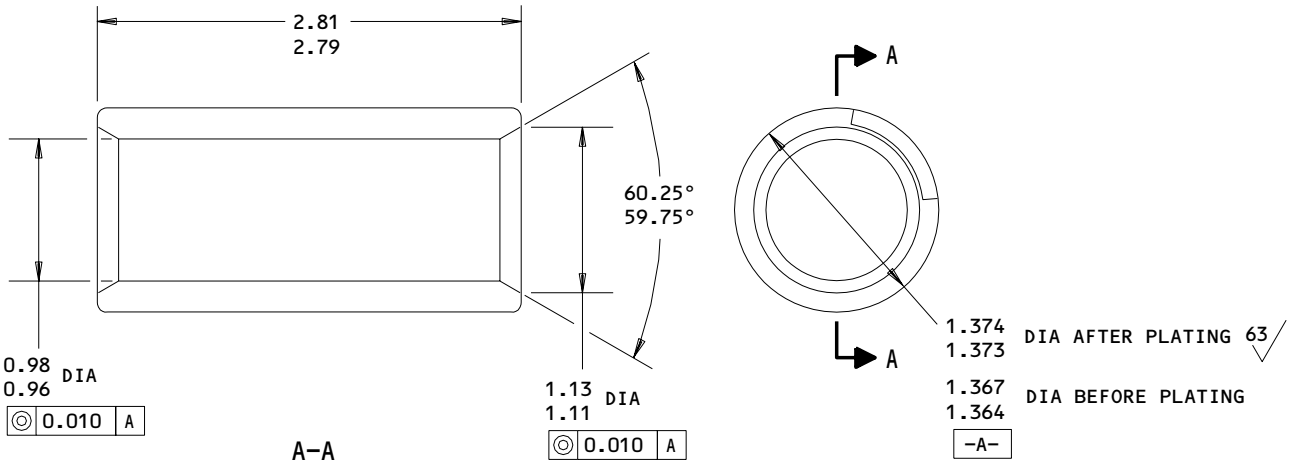
NOTE: Refer to REPAIR-GEN for a list of applicable standard practices.

1. Check

   A. Magnetic particle examine the pin (SOPM 20-20-01).

2. Repair (Fig. 601)

   A. Repair is only replacement of the original finish. Refer to Refinish instructions shown.



REFINISH

CHROME PLATE (F-15.34) THE OUTSIDE DIAMETER.
WIPE THE PLATING WITH PRIMER (F-19.45).
PASSIVATE (F-17.25, WHICH REPLACES F-17.09)
ALL OTHER SURFACES

REPAIR

(SAME AS REFINISH)

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK EDGES 0.02-0.04 R

MATERIAL: 15-5PH CRES (180-200 KSI)

ALL DIMENSIONS ARE IN INCHES

163T3005-1
Attach Pin Refinish
Figure 601

FUSE PIN - REPAIR 6-1

163T3006-1

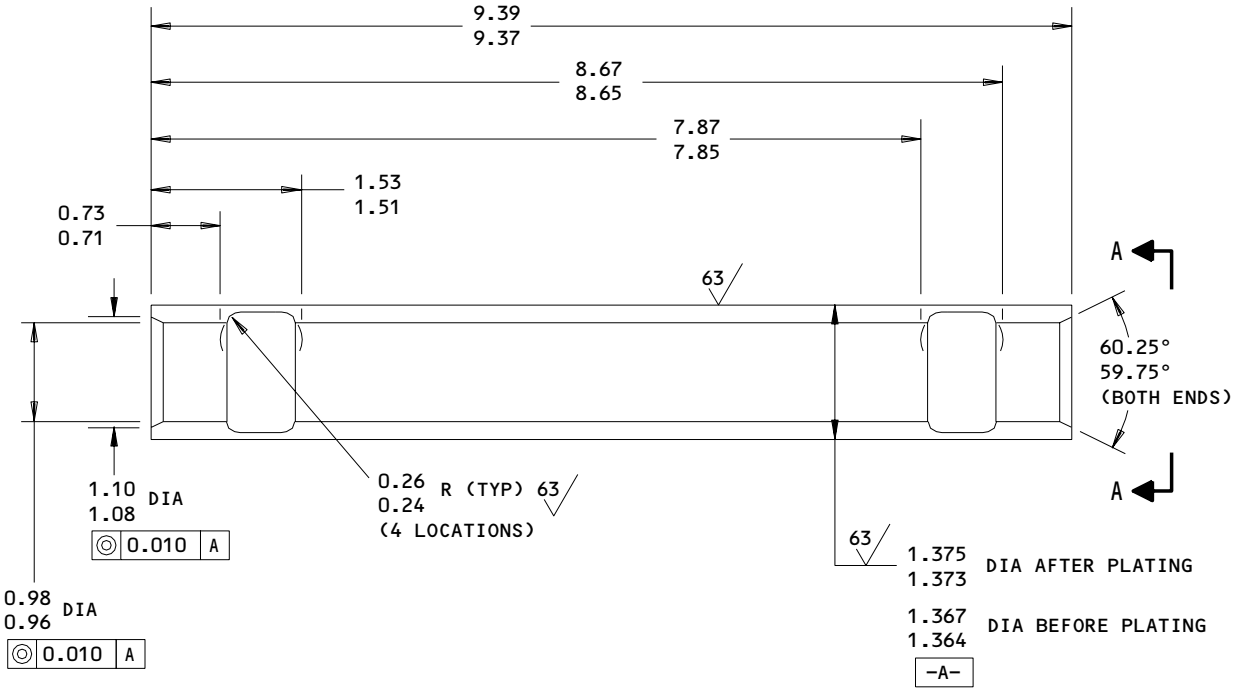
NOTE: Refer to REPAIR-GEN for a list of applicable standard practices.

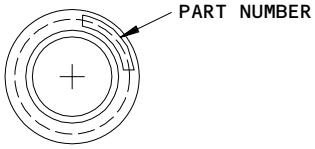
1. Check

   A. Magnetic particle examine the pin (SOPM 20-20-01).

2. Repair (Fig. 601)

   A. Repair is only replacement of the original finish. Refer to Refinish instructions shown.





A-A

REFINISH

CHROME PLATE (F-15.34) THE OUTSIDE DIAMETER. WIPE THE PLATING WITH PRIMER (F-19.45). CADMIUM PLATE (F-15.06) AND APPLY BMS 10-11, TYPE 1, PRIMER (F-20.03) ON ALL OTHER SURFACES. APPLY CORROSION PREVENTIVE COMPOUND (F-19.03) TO INSIDE DIAMETER

REPAIR

(SAME AS REFINISH)

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK CORNERS EQUIV TO 0.03 R UNLESS SHOWN DIFFERENTLY

SHOT PEEN: 0.017-0.046 SHOT SIZE
0.010 A2 INTENSITY

MATERIAL: 4330M STEEL (36 RC MINIMUM HARDNESS)

ALL DIMENSIONS ARE IN INCHES

163T3006-1
Refinish Details
Figure 601

209511

MARKER - REPAIR 7-1

BAC27TLG0008

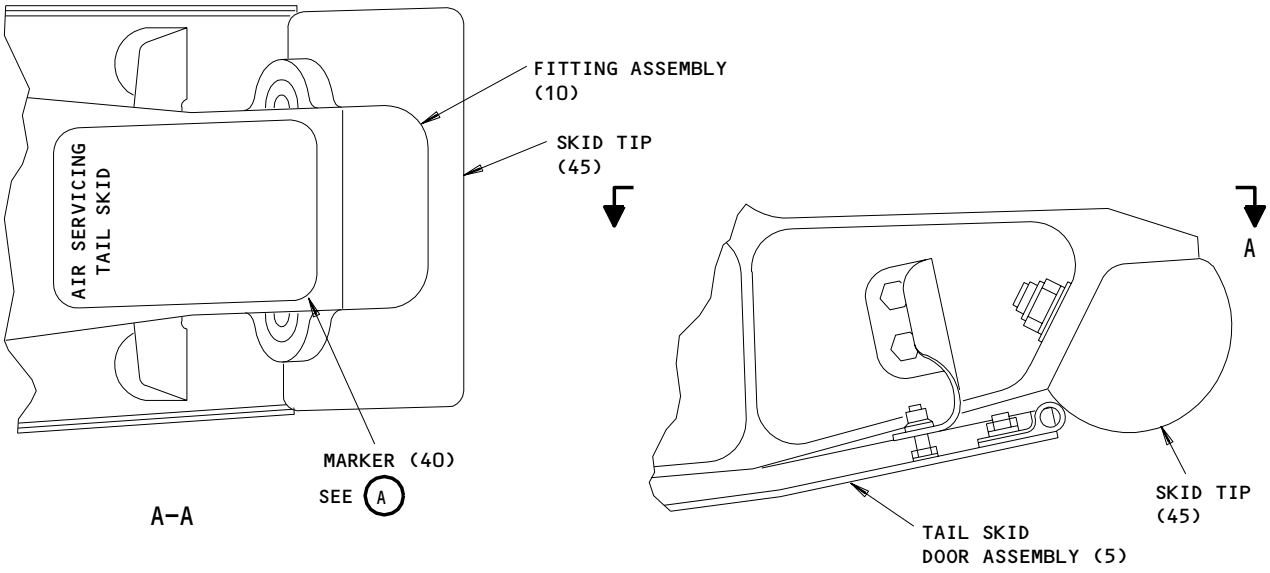
NOTE: Refer to REPAIR-GEN for a list of applicable standard practices. Refer to IPL Fig. 1 for item numbers.

1. Marker Replacement (Fig. 601)

   A. Remove the bad marker (40).

   B. Apply a replacement marker as shown (SOPM 20-50-05).

   C. Apply type 41 clear protective finish (F-21.34) to all of the marker and approximately 0.50 inch out from the edge of the marker.



AIR SERVICING
TAIL SKID
— WARNING —

BEFORE SERVICING ENSURE THAT TAIL SKID CANNOT BE RETRACTED

1. INFLATE STRUT WITH DRY AIR OR NITROGEN THROUGH AIR VALVE TO 450-500 PSIG.
2. DEPRESS LOW PRESSURE INDICATOR BUTTON UNTIL IT LATCHES.
3. REDUCE PRESSURE TO 300-350 PSIG.
4. RESERVICE STRUT PER STEPS 1, 2, & 3 IF LOW PRESSURE INDICATOR BUTTON IS EXTENDED AND WILL NOT LATCH WHEN DEPRESSED.

BAC27TLG0008

A

ALL DIMENSIONS ARE IN INCHES

BAC27TLG0008

Marker Replacement
Figure 601

MISCELLANEOUS PARTS REFINISH - REPAIR 8-1

1. Repair of these parts is only replacement of the original finish. Refer to REPAIR-GENERAL for a list.

IPL FIG. & ITEM	MATERIAL	FINISH
Fig. 1		
Tip (45)	Nickel Alloy 718	Apply BMS 10-11, type 1 primer (SRF-12.205) and white lacquer gloss gloss (SRF-12.64). No finish in 0.45 diameter holes.

Refinish Details
Figure 601

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

15653 FAIRCHILD FASTENERS KAYNAR PRODUCTS DIV
800 S STATE COLLEGE BLVD
FULLERTON, CALIFORNIA 92831-3001
FORMERLY VK6405 MICRODOT AEROSP LTD; FORMERLY KAYNAR TECH
KAYNAR DIV

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

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

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

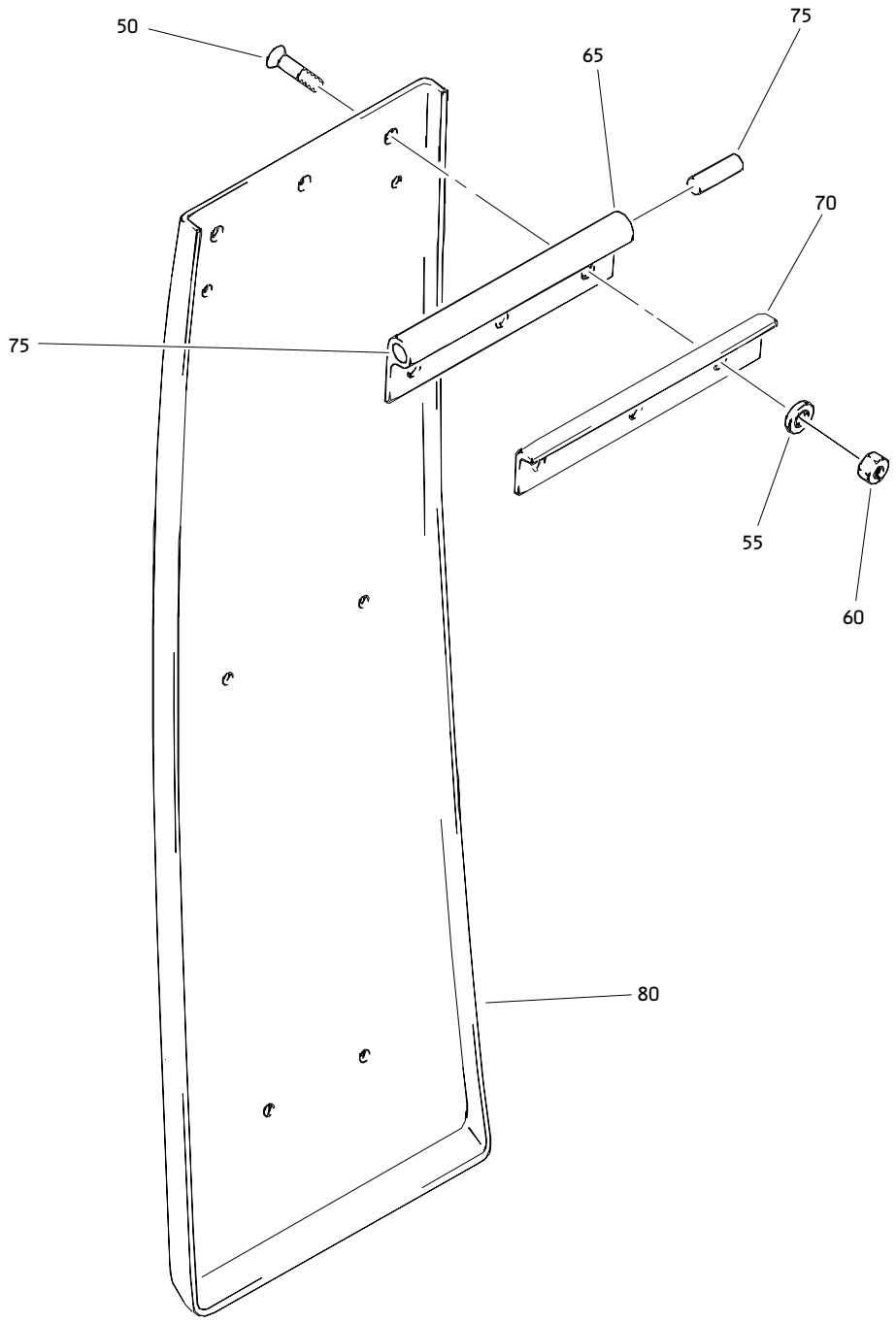
72962 HARVARD INDUSTRIES INC
3 WERNER WAY SUITE 210
LEBANON, NEW JERSEY 08833
FORMERLY AMERACE CORP ESNA DIV
FORMERLY ELASTIC STOP NUT IN UNION, NJ

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

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
AN960-10L		2	40	20
AN960KD10L		1	55	3
BACB30NN3K4		1	50	3
BACN10JC3		1	60	3
		2	45	10
BACN10YR3CD		1	60A	3
BAC27TLG0008		1	40	RF
		2	80	RF
BRH10A3		1	60	3
		2	45	10
H10-3BAC		1	60	3
		2	45	10
H52732-3CD		1	60A	3
MS15001-1		2	20	4
NAS1149D0332J		1	55A	3
NAS6603-4		2	25	6
NAS6603-6		2	35	2
NAS6603-9		2	30	2
NS202101-02		1	60	3
		2	45	10
PLH53CD		1	60A	3
		2	45	10
T6S1032J		1	60	3
		2	45	10
VN303A02		1	60	3
		2	45	10
148T7703-1		1	5	RF
148T7703-2		1	80	1
148T7703-3		1	65	1
148T7703-4		1	70	1
148T7703-5		1	75	2
148T7703-6		1	5A	RF
148T7703-7		1	80A	1
148T9337-10		2	70	1
148T9337-7		2	55	1
148T9337-8		2	60	2
148T9337-9		2	65	1
163T1000-1		1	10	RF
		2	1	RF
163T1000-2		2	75	1
163T1000-3		1	10A	RF
		2	1A	RF
163T1000-4		2	75A	1
163T3001-1		2	5	2
163T3001-12		2	15A	2
163T3001-2		2	10	2
163T3002-1		1	15	RF

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
163T3002-2		1	20	RF
163T3004-1		1	25	RF
163T3005-1		1	30	RF
163T3006-1		1	35	RF
284T0816-1		2	50	1
65-71561-1		1	45	RF
96-02		1	60	3
		2	45	10



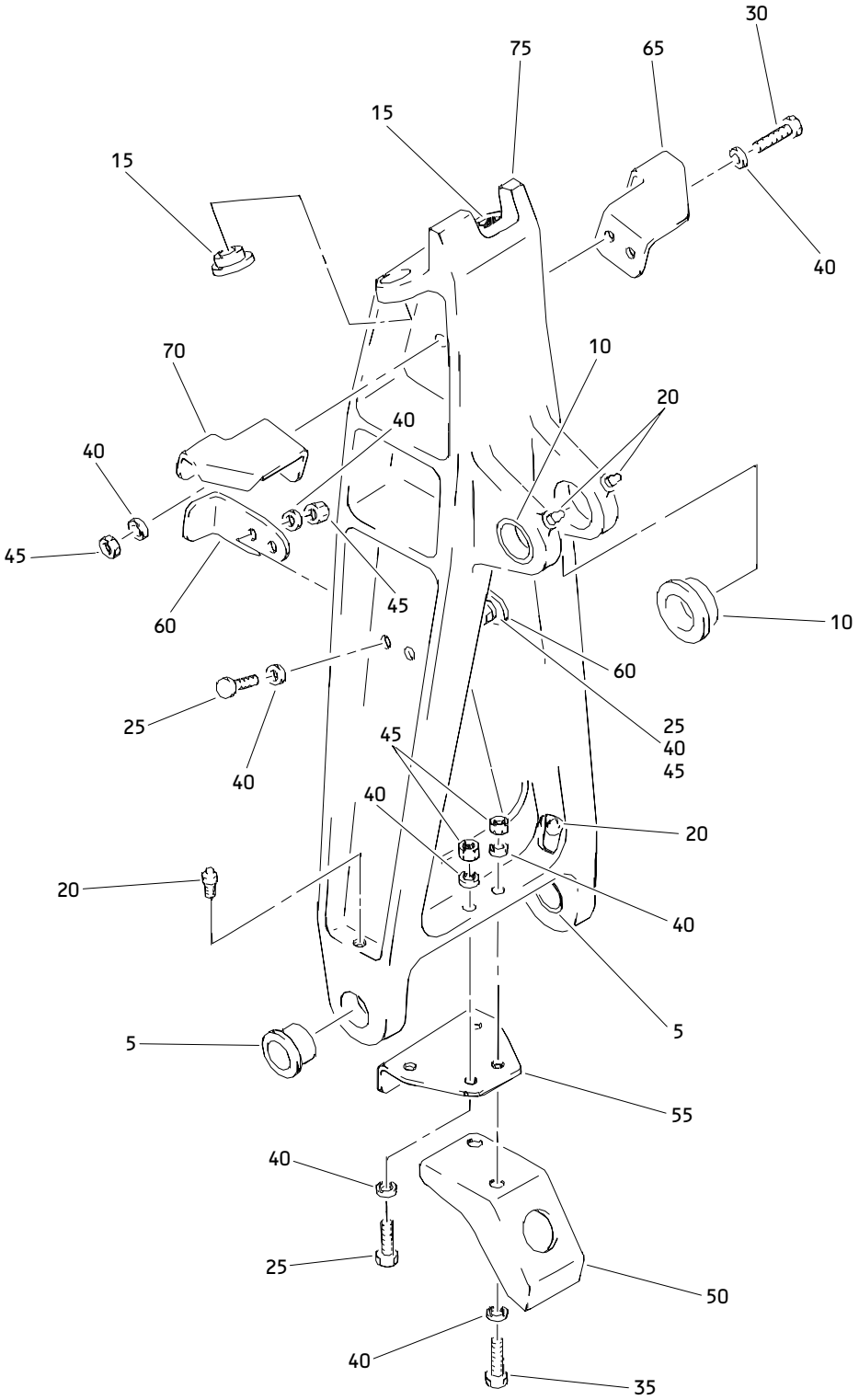
Tail Skid Door Assembly
Figure 1

U8490

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-			TAIL SKID INSTALLATION COMPONENTS		
	-5	148T7703-1		DOOR ASSY-TAIL SKID	A	RF
R	-5A	148T7703-6		DOOR ASSY-TAIL SKID	L	RF
R	-10	163T1000-1		FITTING ASSY-TAIL SKID LEVER (FOR DETAILS SEE FIG. 2)	B	RF
R	-10A	163T1000-3		FITTING ASSY-TAIL SKID LEVER (FOR DETAILS SEE FIG. 2)	K	RF
R	-15	163T3002-1		CAP-END	C	RF
R	-20	163T3002-2		CAP-END	D	RF
	-25	163T3004-1		PIN-ATTACH	E	RF
	-30	163T3005-1		PIN-ATTACH	F	RF
R	-35	163T3006-1		PIN-FUSE	G	RF
	-40	BAC27TLG0008		MARKER-SERVICING	H	RF
R	-45	65-71561-1		TIP-SKID	J	RF
	50	BACB30NN3K4		.BOLT	A,L	3
	55	AN960KD10L		.WASHER	A	3
R	-55A	NAS1149D0332J		.WASHER	L	3
	60	H10-3BAC		.NUT- (V15653) (SPEC BACN10JC3) (OPT NS202101-02 (V80539)) (OPT RMLH9075-3W (V72962)) (OPT T6S1032J (V71087)) (OPT VN303A02 (V92215)) (OPT 96-02 (V80539)) (OPT BRH10A3 (V52828))	A	3

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R	01- -60A	H52732-3CD		.NUT- (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))	L	3
R	65	148T7703-3		.SEAL- (MFD FROM STOCK ALTER 10-60754-350 X 5.60)	A,L	1
R	70	148T7703-4		.RETAINER-SEAL (MFD FROM 7075-0 AL CLAD SH PER QQ-A-250/13 STOCK .050 X 1.20 X 5.6 FIN F-18.06 F-21.02)	A,L	1
R	75	148T7703-5		.PLUG- (MFD FROM BMS1-23 SILICONE SPONGE)	A,L	2
	80	148T7703-2		.BOND ASSY	A	1
R	-80A	148T7703-7		.BOND ASSY	L	1

- Item Not Illustrated



Tail Skid Lever Fitting Assembly
Figure 2

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	02- -1	163T1000-1		FITTING ASSY-TAIL SKID LEVER	B	RF
R	-1A	163T1000-3		FITTING ASSY-TAIL SKID LEVER	K	RF
	5	163T3001-1		.BUSHING	B,K	2
	10	163T3001-2		.BUSHING	B,K	2
	15	163T3001-4		DELETED		
R	15A	163T3001-12		.BUSHING	B,K	2
	20	MS15001-1		.FITTING	B,K	4
	25	NAS6603-4		.BOLT	B,K	6
	30	NAS6603-9		.BOLT	B,K	2
	35	NAS6603-6		.BOLT	B,K	2
	40	AN960-10L		.WASHER	B,K	20
	45	H10-3BAC		.NUT- (V15653) (SPEC BACN10JC3) (OPT NS202101-02 (V80539)) (OPT RMLH9075-3W (V72962)) (OPT T6S1032J (V71087)) (OPT VN303A02 (V92215)) (OPT 96-02 (V80539)) (OPT BRH10A3 (V52828))	B,K	10
	50	284T0816-1		.SUPPORT ASSY-TARGET	B,K	1
	55	148T9337-7		.CLIP-ATTACH	B,K	1
	60	148T9337-8		.CLIP-ATTACH	B,K	2
	65	148T9337-9		.CLIP-ATTACH	B,K	1
	70	148T9337-10		.CLIP-ATTACH	B,K	1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	02-75	163T1000-2		.LEVER	B	1
R	-75A	163T1000-4		.LEVER	K	1
R	-80	BAC27TLG0008		MARKER-SERVICING	K	RF

- Item Not Illustrated