

FITTING ASSY - STRUT SUPPORT, EXHAUST FRAME

PART NUMBER 149T7375-1

COMPONENT MAINTENANCE MANUAL
WITH
ILLUSTRATED PARTS LIST

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TITLE PAGE

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REVISION RECORD

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

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

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TEMPORARY REVISION AND SERVICE BULLETIN RECORD

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

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TR & SB RECORD

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BOEING
 COMPONENT
 MAINTENANCE MANUAL

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* = REVISED, ADDED OR DELETED

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

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INTRODUCTION

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

This manual is divided into separate sections:

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

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

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

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

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

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

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FITTING ASSEMBLY - STRUT SUPPORT, EXHAUST FRAME

DESCRIPTION AND OPERATION

1. Description and Operation

A. The strut support fitting assembly is a forged and machined aluminum fitting with two bushings. It is non-operational by itself.

2. Leading Particulars

Length -- 4 inches
Width -- 3 inches
Thickness -- 2 inches
Weight -- 0.4 pounds

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DISASSEMBLY

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

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

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CHECK

1. Check for obvious defects in accordance with standard industry practices.
2. Penetrant check per 20-20-02 -- Fitting (15, IPL Fig. 1)

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REPAIR – GENERAL1. Contents

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

<u>P/N</u>	<u>NAME</u>	<u>REPAIR</u>
149T7375	STRUT SUPPORT FRAME	1-1

2. Standard Practices

- A. Refer to the following standard practices as applicable, for details of procedures in individual repairs.
- B. 20-30-01 Stripping of Protective Finishes
 20-30-03 General Cleaning Procedures
 20-41-01 Decoding Table for Boeing Finish Codes
 20-41-02 Application of Chemical and Solvent Resistant Finishes
 20-43-03 Alodizing
 20-50-03 Bearing Installation and Retention

3. Material

NOTE: Equivalent substitutes may be used.

- A. Alodine 1200 (Colored film) (Ref 20-43-03)
- B. Enamel -- BMS 10-11, type II, color BAC702 white gloss (ref 20-60-02)
- C. Primer -- BMS 10-11, type I (ref 20-60-02)
 -- BMS 10-11, type I, yellow (ref 20-60-02)
- D. Sealant -- BMS 5-95 (ref 20-60-04)

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4. Dimensioning Symbols

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

—	STRAIGHTNESS	\oplus	THEORETICAL EXACT POSITION OF A FEATURE (TRUE POSITION)
\square	FLATNESS	\varnothing	DIAMETER
\perp	PERPENDICULARITY (OR SQUARENESS)	BASIC (BSC) OR	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.
//	PARALLELISM	DIM	
\bigcirc	ROUNDNESS	-A-	DATUM
\bigcirc	CYLINDRICITY	\textcircled{M}	MAXIMUM MATERIAL CONDITION (MMC)
\frown	PROFILE OF A LINE	\textcircled{S}	REGARDLESS OF FEATURE SIZE (RFS)
\triangle	PROFILE OF A SURFACE	\textcircled{P}	PROJECTED TOLERANCE ZONE
\odot	CONCENTRICITY		
\equiv	SYMMETRY		
\sphericalangle	ANGULARITY		
\nearrow	RUNOUT		

EXAMPLES

$\text{—} \quad 0.002$	STRAIGHT WITHIN 0.002	$\textcircled{\odot} \text{ C } \varnothing \quad 0.0005$	CONCENTRIC TO C WITHIN 0.0005 DIAMETER (FULL INDICATOR MOVEMENT)
$\perp \text{ B } \quad 0.002$	PERPENDICULAR TO B WITHIN 0.002	$\equiv \text{ A } \quad 0.010$	SYMMETRICAL WITH A WITHIN 0.010
$\parallel \text{ A } \quad 0.002$	PARALLEL TO A WITHIN 0.002	$\sphericalangle \text{ A } \quad 0.005$	ANGULAR TOLERANCE 0.005 WITH A
$\bigcirc \quad 0.002$	ROUND WITHIN 0.002	$\oplus \text{ B } \varnothing \quad 0.002 \textcircled{S}$	LOCATED AT TRUE POSITION WITHIN 0.002 DIA IN RELATION TO DATUM B, REGARDLESS OF FEATURE SIZE
$\bigcirc \quad 0.010$	CYLINDRICAL SURFACE MUST LIE BETWEEN TWO CONCENTRIC CYLINDERS, ONE OF WHICH HAS A RADIUS 0.010 INCH GREATER THAN THE OTHER	$\perp \text{ A } \varnothing \quad 0.010 \textcircled{M}$ $0.510 \textcircled{P}$	AXIS IS TOTALLY WITHIN A CYLINDER OF 0.010-INCH DIAMETER, PERPENDICULAR TO, AND EXTENDING 0.510-INCH ABOVE, DATUM A, MAXIMUM MATERIAL CONDITION
$\frown \text{ A } \quad 0.006$	EACH LINE ELEMENT OF THE SURFACE AT ANY CROSS SECTION MUST LIE BETWEEN TWO PROFILE BOUNDARIES 0.006 INCH APART IN RELATION TO DATUM PLANE A	2.000	EXACT DIMENSION IS 2.000
$\triangle \text{ A } \quad 0.020$	SURFACES MUST LIE WITHIN PARALLEL BOUNDARIES 0.02 INCH APART AND EQUALLY DISPOSED ABOUT TRUE PROFILE	OR 2.000 BSC	

True Position Dimensioning Symbols
Figure 601

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REPAIR-GENERAL

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FITTING ASSEMBLY - STRUT SUPPORT, EXHAUST FRAME REPAIR 1-1

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

1. Bushing Replacement (5, 10, IPL Fig. 1)

- A. Remove bushings.
- B. Install bushings per 20-50-03.
- C. Machine bushings per Fig. 601.
- D. Fillet seal bushings (5, 10), both sides, with sealant BMS 5-95.

2. Refinish

- A. Fitting (15) -- Chromic acid anodize, type 1 and apply one coat BMS 10-11, type 1 primer (F-18.13); chromic acid anodize bushing bores (F-17.04) and omit primer. Apply BMS 10-11, type II, color BAC702 white gloss enamel (F-21.03); omit enamel from bushing bores.
- B. Fitting Assembly (1) -- Touch-up unpainted areas (F-21.12) as follows:
 - (1) Clean and apply alodine 1200 (colored film).
 - (2) Apply BMS 10-11, type I yellow primer and BMS 10-11, type II, color BAC702 white gloss enamel; omit primer and enamel from bushing holes. Material: Al alloy

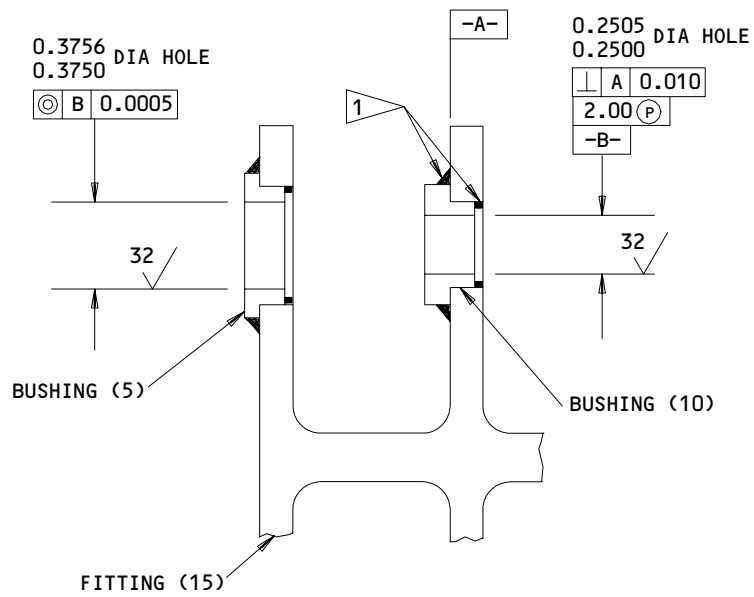
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1 FILLET SEAL (TYP) (BMS 5-95 SEALANT)

ALL DIMENSIONS ARE IN INCHES

**Bushing Replacement
 Figure 601**

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ILLUSTRATED PARTS LIST

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

2. Indentures show parts relationships as follows:

Assembly

Detail Parts for Assembly

Subassembly

Attaching Parts for Subassembly

Detail Parts for Subassembly

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

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

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

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

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

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

6. Parts Interchangeability

Optional
(OPT)

The parts are optional to and interchangeable with other parts having the same item number.

Supersedes, Superseded By
(SUPSDS, SUPSD BY)

The part supersedes and is not interchangeable with the original part.

Replaces, Replaced By
(REPLS, REPLD BY)

The part replaces and is interchangeable with, or is an alternate to, the original part.

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VENDORS

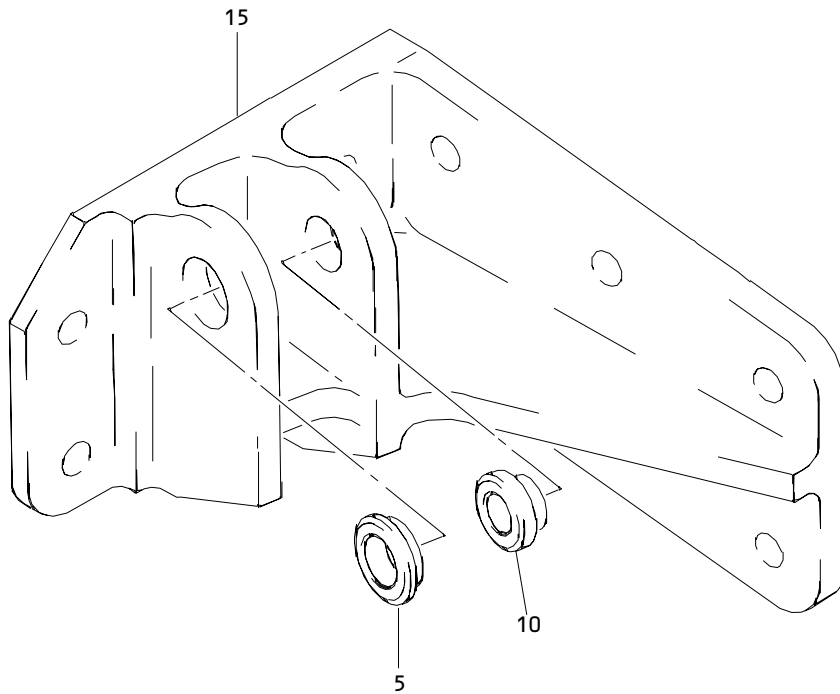
23294 AVALON MACHINE PRODUCTS INC
15337 ALLEN STREET
PARAMOUNT, CALIFORNIA 90723

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

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

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Exhaust Frame Strut Support Right Side Fitting Assembly
Figure 1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01- -1	149T7375-1		FITTING ASSY-EXHAUST FRAME STRUT SPRT R. S.		RF
5	BACB28AM06B013A		.BUSHING- (V23294) (SPEC BACB28AM06B013A) (OPT BACB28AM06B013A (V70265)) (OPT BACB28AM06B013A (V94892))		1
10	149T7221-1		.BUSHING		1
15	149T7375-2		.FITTING		1

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