TO: ALL HOLDERS OF FORWARD TRUNNION SUPPORT MACHINED ASSEMBLY COMPONENT MAINTENANCE MANUAL 57-54-37

REVISION NO. 1 DATED JUL 01/02

HIGHLIGHTS

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

CHAPTER/SECTION AND PAGE NO.	DESCRIPTION OF CHANGE
TITLE PAGE	Added assemblies 112T1600-7, -8, -11, -12, -15, -16,
1	-19, -20. Deleted 112T1600-3, -4.
301	
REPAIR 5-1	
601,603	
REPAIR 5-2	
601,603-605	
706-708	
1002-1006,1008-1010,	
1013-1015,1018-1023	
CONTENTS	Added clarifications and updated callouts.
1	
DESCRIPTION & OPERATION	
1	
301-302	
501	
REPAIR-GEN	
601	
REPAIR 1-1	
601-603	
REPAIR 2-1	
601-603	
REPAIR 2-2	
601-604	
REPAIR 3-1	
601-603	

CHAPTER/SECTION AND PAGE NO.	DESCRIPTION OF CHANGE
REPAIR 3-2 601-602,604 REPAIR 4-1 601-606 REPAIR 5-1 601-603 REPAIR 5-2 601-606 REPAIR 6-1 601-602 REPAIR 6-2 601-603 701-703,705-708, 710-711 802-803 1002-1006,1019-1023	HIGHLIGHT CONTINUED FROM PREVIOUS PAGE
702-703,706-708	Deleted instructions which cannot be done until the unit is installed on the airplane.

BOEING

COMPONENT
MAINTENANCE MANUAL

FORWARD TRUNNION SUPPORT MACHINED ASSEMBLY

PART NUMBERS 112T1600-7,-8,-11,-12, -15,-16,-19,-20

COMPONENT MAINTENANCE MANUAL
WITH
ILLUSTRATED PARTS LIST

K25078

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

K25079

TEMPORARY REVISION AND SERVICE BULLETIN RECORD

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

PAGE	DATE	CODE
57-54-37		
TITLE PAGE		
*1	JUL 01/02	01.1
2	BLANK	
REVISION RECORD		
1	JUL 01/99	01
2	BLANK	
TR & SB RECORD		
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LIST OF EFFECTIVE PAGES		
*1	JUL 01/02	01
THRU LAST PAGE		
CONTENTS		
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2	BLANK	
INTRODUCTION		
1	JUL 01/99	01
2	BLANK	
DESCRIPTION & OPERATION		
*1	JUL 01/02	01.1
2	JUL 01/99	01
DISASSEMBLY		
*301	JUL 01/02	01.1
*302	JUL 01/02	01.1
CHECK		
*501	JUL 01/02	01.1
502	BLANK	
REPAIR-GENERAL		
*601	JUL 01/02	01.1
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REPAIR 1-1		
*601	JUL 01/02	01.1
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REPAIR 2-1		
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REPAIR 2-2		
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*602	JUL 01/02	01.1
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*604	JUL 01/02	01.1
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REPAIR 3-2		
*601	JUL 01/02	01.1
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REPAIR 4-1		
*601	JUL 01/02	01.1
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*605	JUL 01/02	01.1
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REPAIR 5-1		
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PAGE	DATE	CODE
REPAIR 5-2		
*601	JUL 01/02	01.1
*602	JUL 01/02	01.1
*603	JUL 01/02	01.1
*604	JUL 01/02	01.1
*605	JUL 01/02	01.1
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REPAIR 6-1		
*601	JUL 01/02	01.1
*602	JUL 01/02	01.1
REPAIR 6-2		
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ASSEMBLY		
*701	JUL 01/02	01.1
*702	JUL 01/02	01.1
*703	JUL 01/02	01.1
704	JUL 01/99	01
*705	JUL 01/02	01.1
*706	JUL 01/02	01.1
*707	JUL 01/02	01.1
*708	JUL 01/02	01.1
709	JUL 01/99	01
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*711	JUL 01/02	01.1
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FITS AND CLEARANCES		
801	JUL 01/99	01
*802	JUL 01/02	01.1
*803	JUL 01/02	01.1
804	BLANK	
ILLUSTRATED PARTS LIST		
1001	JUL 01/99	01
*1002	JUL 01/02	01.1
*1003	JUL 01/02	01.1
*1004	JUL 01/02	01.1

PAGE	DATE	CODE
ILLUSTRATED PARTS LIST		CONT.
*1005	JUL 01/02	01.1
*1006	JUL 01/02	01.1
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*1008	JUL 01/02	01.1
*1009	JUL 01/02	01.1
*1010	JUL 01/02	01.1
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*1013	JUL 01/02	01.1
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*1022	JUL 01/02	01.1
*1023	JUL 01/02	01.1
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* = REVISED, ADDED OR DELETED

TABLE OF CONTENTS

*[1] Not Applicable.

*[2] Special instructions are 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 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:

FORWARD TRUNNION SUPPORT MACHINED ASSEMBLY

DESCRIPTION AND OPERATION

1. Description

   A. The forward trunnion support machined assembly includes aluminum bracket assemblies, three aluminum fitting assemblies, two fuse pins, a titanium tension strap, and a housing assembly.

2. Operation

   A. The forward trunnion support machined assembly attaches the main landing gear forward trunnion to the wing box.

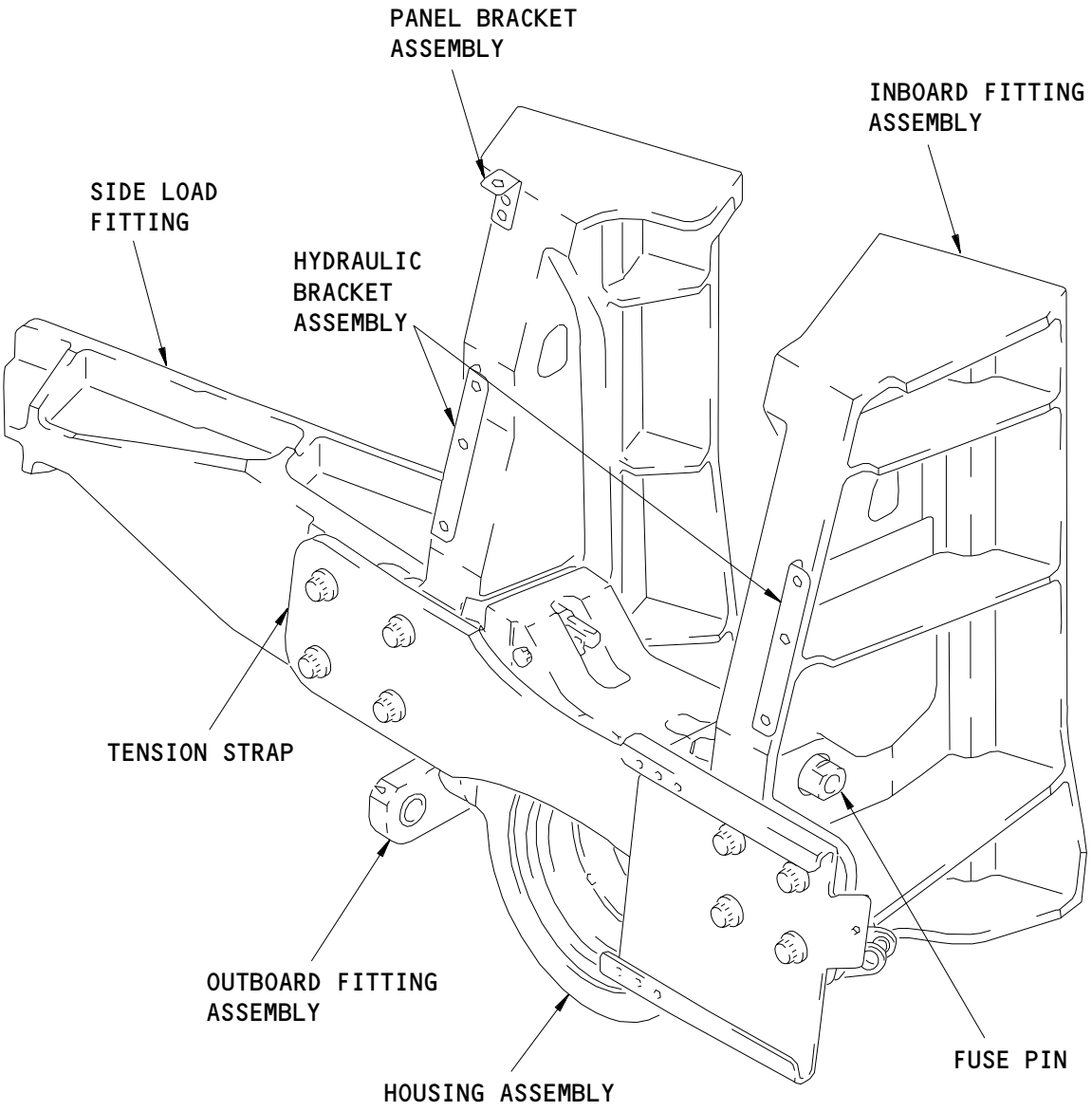
3. Leading Particulars (Approximate)

   A. Length -- X inches

   B. Width -- X inches

   C. Height -- X inches

   D. Weight -- X pounds



Forward Trunnion Support Machined Assembly
Figure 1

K25088

DISASSEMBLY

1. General

   A. This procedure has the necessary data to disassemble the forward trunnion support machined 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. Use standard industry procedures and these steps.

   B. Remove the bolts (10), the nuts (15) and the bracket assemblies (20, 40, 60) from the inboard and outboard fitting assemblies (300, 345).

   C. Remove the bolts (145, 150, 155), the washers (160, 165), the collars (170), the 287T6115-4001 or -4002 wiring bundle bracket assembly (if attached), the tension strap (205), and the panel support fitting assembly (210) from the inboard and outboard fitting assemblies (300, 345).

   D. Remove the cotton pins (115), the bolts (120), the washers (125, 130), and nuts (135) from the fuse pin (140) and inboard and outboard fitting assemblies (300, 345).

   E. Remove the fuse pin (140) from the housing assembly (260), the inboard and outboard fitting assemblies (300, 345).

   F. Remove the cotter pins (230), the bolts (235), the washers (240, 245), and nuts (250) from the fuse pin (255) and the inboard and outboard fitting assemblies (300, 345).

G. Remove the fuse pins (255), the bearing plates (290, 295), and housing assembly (260) from the inboard and outboard fitting assemblies (300, 345).

H. Remove the bolts (325), the collars (330), and the side load fitting (335) from outboard fitting assembly (345).

CHECK

1. General

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

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

C. Refer to the Standard Overhaul Practices Manual (SOPM) for details of the SOPM subjects identified in this 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 a visual check of all the parts for defects. Do the penetrant or magnetic particle check if the visual check finds possible defects on the parts listed below.

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

(a) Bearing Button (310, 355)

(b) Fuse Pin (140, 255)

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

(a) Bushings (100, 105, 275, 280)

(b) Fittings (315, 320, 335, 340, 360, 365)

(c) Housing (285)

(d) Tension Strap (205)

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
112T1601	FITTING ASSEMBLY	2-1, 2-2
112T1602	FITTING ASSEMBLY	3-1, 3-2
112T1611	FUSE PIN	4-1
112T1612	HOUSING ASSEMBLY	5-1
113T1992	FITTING ASSEMBLY	6-1

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) C00033 Coating -- BMS 10-60, Type 2 enamel 707 (SOPM 20-60-02)

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

   C. References

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

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

      (3) SOPM 20-42-05, Bright Cadmium Plating

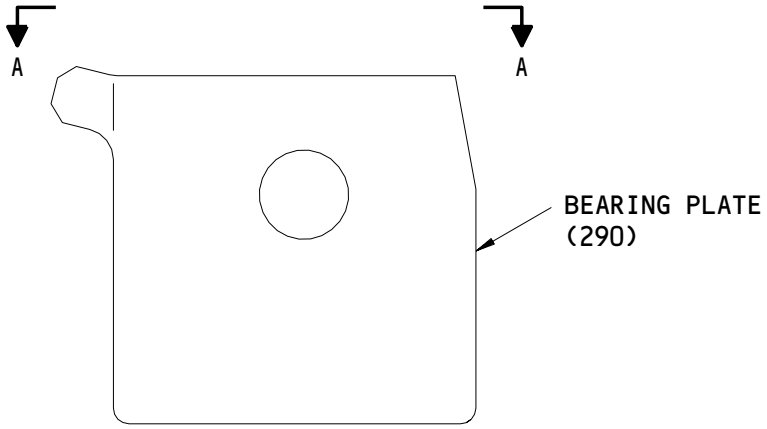
      (4) SOPM 20-43-01, Chromic Acid Anodizing

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

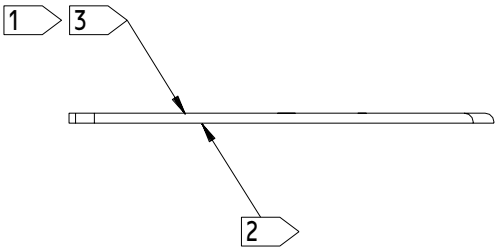
      (6) SOPM 20-60-04, Miscellaneous Materials

IPL FIG. & ITEM	MATERIAL	FINISH
IPL Fig. 1		
Bracket (35)	Al alloy	Chemical treat (F-17.07) and apply BMS 10-11, Type 1 primer (F-20.02).
Bracket (55, 75)	Al alloy	Chemical treat (F-17.07) and apply BMS 10-11, Type 1 primer (F-20.03).
Bushing (100, 105)	Cu-Be	Cadmium plate (F-15.06) the outside diameter and flange.
Bracket (195, 200)	304 CRES	Passivate (F-17.25).
Strap (205)	Ti alloy	Clean (F-14.882) and apply BMS 10-11, Type 1 primer (F-20.02) and BMS 10-60 enamel (F-14.9813, which replaces SRF-14.9813).
Bearing Plate (290, 295)	15-5PH CRES 125-145 ksi	Passivate (F-17.25) unless shown by flagnotes 1 and 2 in Fig. 601.

Refinish Details
Table 601



112T1610-1 SHOWN
112T1610-2 OPPOSITE



A-A

1 CADMIUM PLATE (F-15.06). APPLY BMS 10-11, TYPE 1 PRIMER (F-20.02)

2 NO PLATING OR PRIMER

3 PART NUMBER AND VENDOR IDENTIFICATION NUMBER LOCATION

ITEM NUMBERS REFER TO IPL FIG. 1

112T1610-1,-2
Bearing Plate Refinish
Figure 601

K25881

FITTING ASSEMBLY - REPAIR 2-1

112T1601-1, -2, -5, -6

1. General

   A. This procedure has the data necessary to repair the outboard veritical fitting assembly (345, 350).

   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. Bearing Button 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 20-50-19, General Sealing

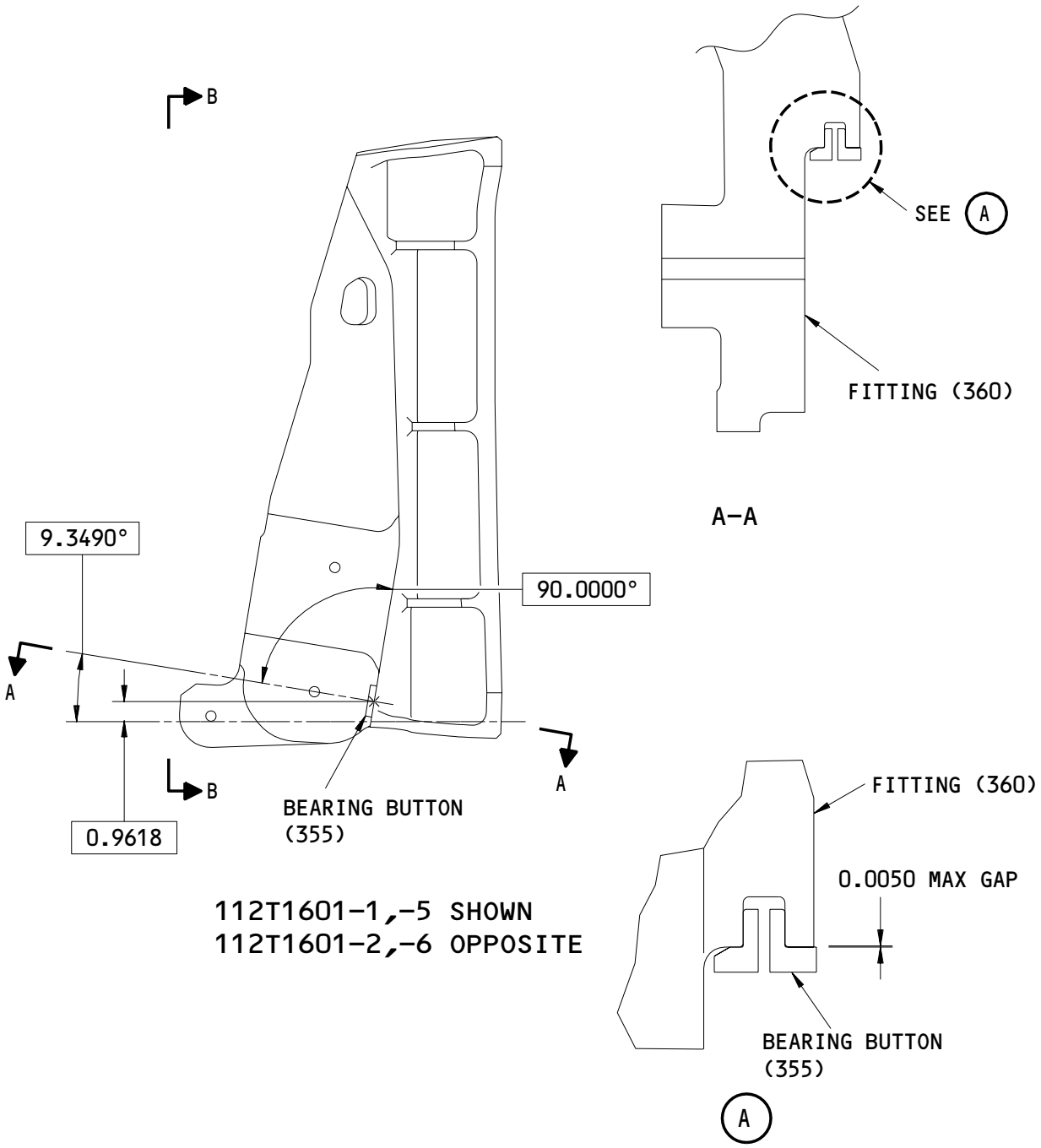
      (3) SOPM 20-60-04, Miscellaneous Materials

   C. Procedure (Fig. 601)

      (1) Remove the old bearing button (355) from the fitting (360 or 365).

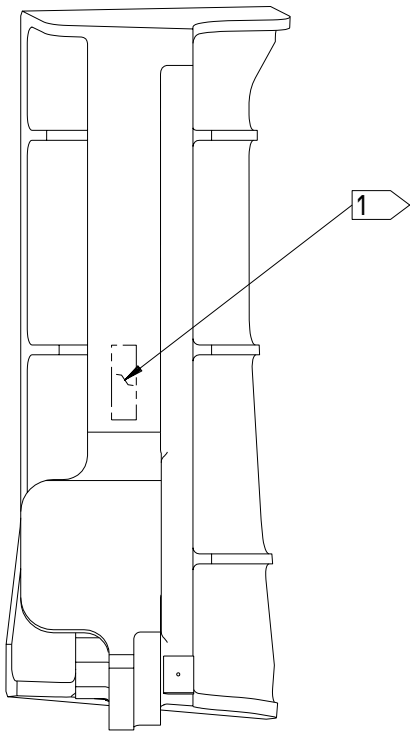
      (2) Install a replacement bearing button (355) in the fitting (360 or 365) with BMS 5-95 sealant by the shrink-fit procedure (SOPM 20-50-03).

      (3) Fillet seal the bearing button (355) edges with BMS 5-95 sealant (SOPM 20-50-19).



112T1601-1,-2,-5,-6
Fitting Assembly Repair
Figure 601 (Sheet 1)

K25893



B–B

1 PART NUMBER AND VENDOR IDENTIFICATION LOCATION

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

112T1601-1,-2,-5,-6
Fitting Assembly Repair
Figure 601 (Sheet 2)

K25895

FITTING - REPAIR 2-2

112T1601-3, -4, -7, -8

1. General

A. This procedure has the data necessary to refinish the fitting (360, 365).

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.

D. General repair details:

(1) Material: Al alloy

(2) Shot peen: All surfaces, but not on surfaces identified by flagnote 1 in Fig. 601
Intensity 0.016A2, Over spray is permitted

2. Fitting Refinish

A. Consumable Materials

NOTE: Equivalent material can be used.

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

B. References

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

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

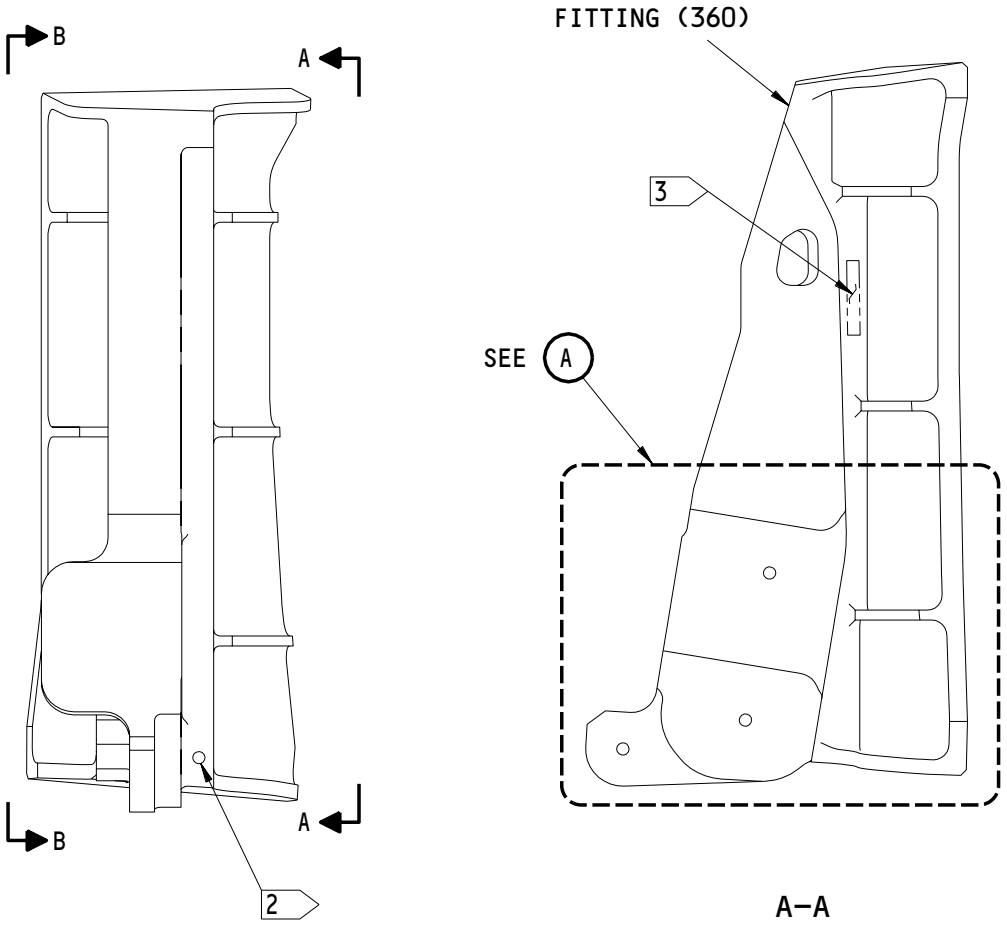
(3) SOPM 20-30-03, General Cleaning Procedures

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

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

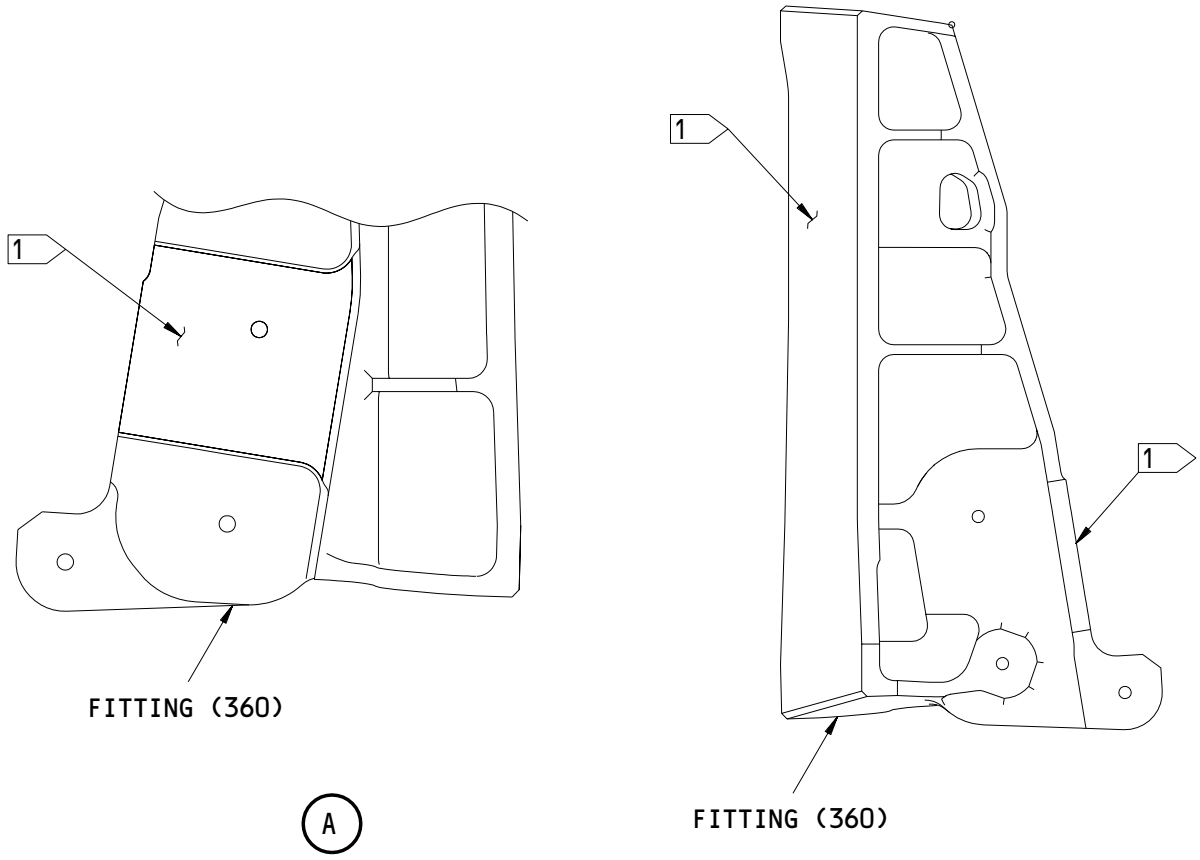
C. Procedure (Fig. 601)

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



112T1601–3,–7 SHOWN
112T1601–4,–8 OPPOSITE

112T1610–3,–4,–7,–8
Fitting Refinish
Figure 601 (Sheet 1)



1 DO NOT SHOT PEEN THIS SURFACE

2 DO NOT PUT PRIMER IN THIS HOLE

3 PART NUMBER AND SERIAL NUMBER LOCATION

ITEM NUMBERS REFER TO IPL FIG. 1

112T1610-3,-4,-7,-8
Fitting Refinish
Figure 601 (Sheet 2)

K25886

FITTING ASSEMBLY - REPAIR 3-1

112T1602-1, -2

1. General

   A. This procedure has the data necessary to repair the inboard vertical fitting assembly (300, 305).

   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 Button 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 20-50-19, General Sealing

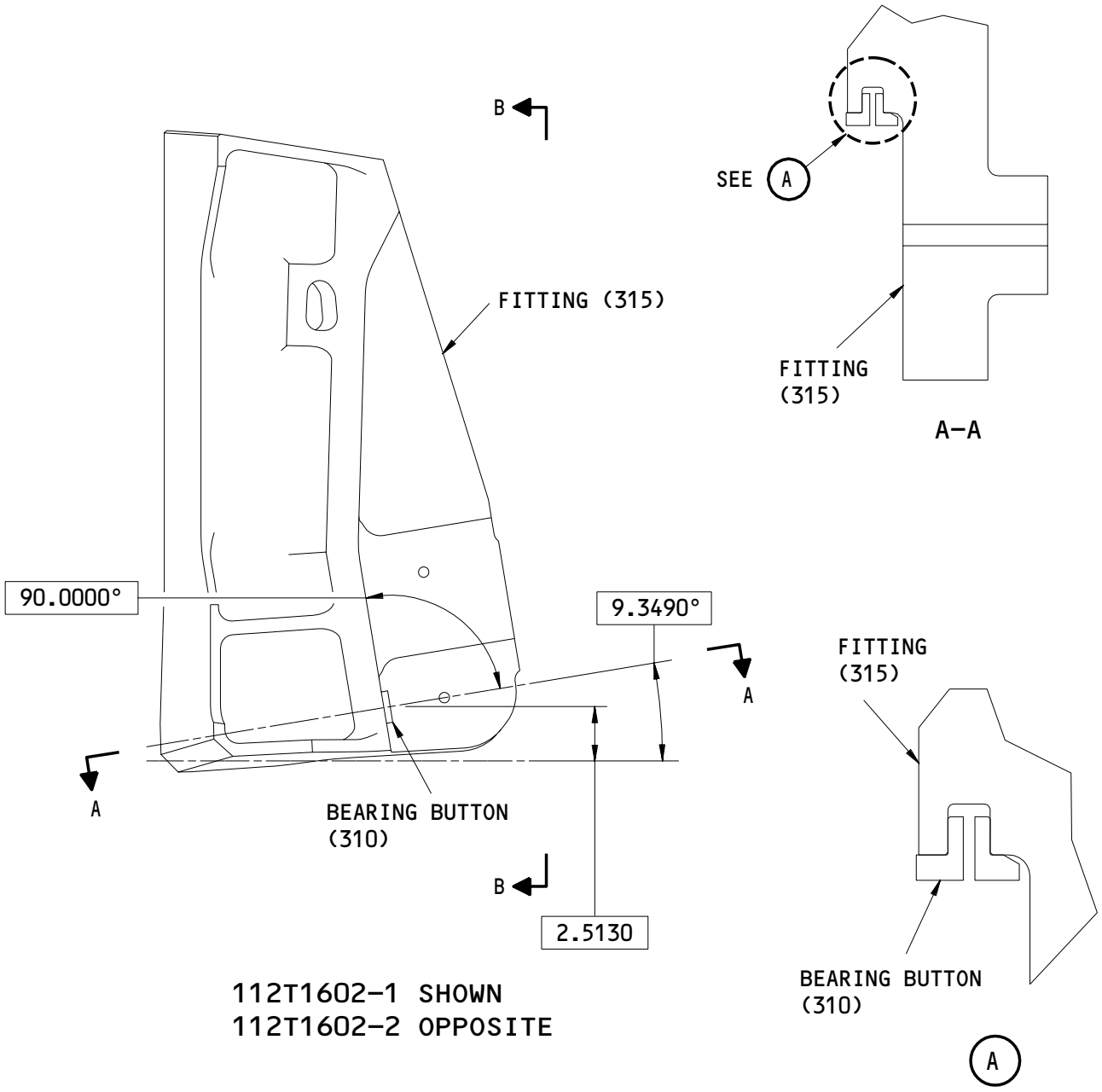
      (3) SOPM 20-60-04, Miscellaneous Materials

   C. Procedure (Fig. 601)

      (1) Remove the old bearing button (310) from the fitting (315 or 320) as shown in Fig. 601.

      (2) Install a replacement bearing button (310) in the fitting (315 or 320) with BMS 5-95 sealant by the shrink-fit procedure (SOPM 20-50-03).

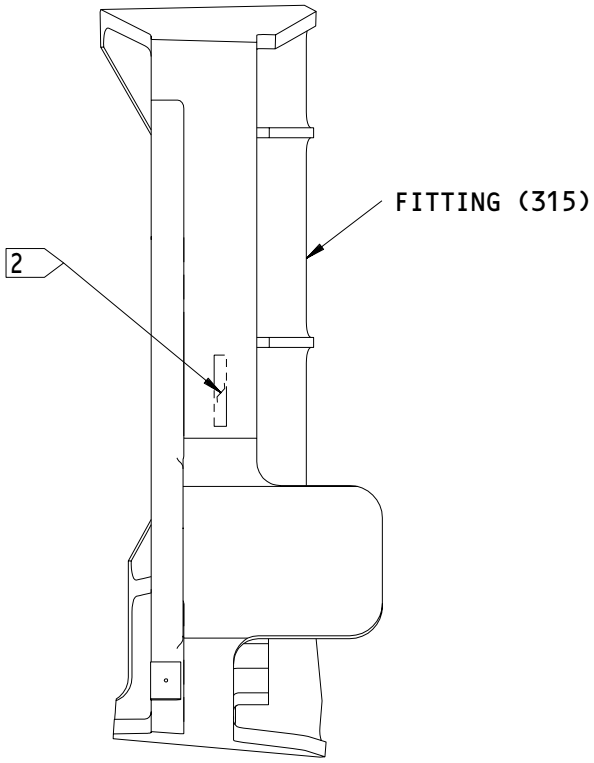
      (3) Fillet seal the bearing button (310) edges with BMS 5-95 sealant (SOPM 20-50-19).



112T1602–1 SHOWN
112T1602–2 OPPOSITE

112T1602–1,–2
Fitting Assembly Repair
Figure 601 (Sheet 1)

K26118



B–B

1 PART NUMBER AND VENDOR IDENTIFICATION LOCATION

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

112T1602-1,-2
Fitting Assembly Repair
Figure 601 (Sheet 2)

K26119

FITTING - REPAIR 3-2

112T1602-3, -4

1. General

A. This procedure has the data necessary to refinish the fitting (315, 320).

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) Material: Al alloy

(2) Shot Peen: All surfaces, but not on surfaces identified by flagnote 1 in Fig. 601
Intensity 0.016A2, Over spray is permitted

2. Fitting Refinish

A. Consumable Materials

NOTE: Equivalent material can be used.

(1) C00259 Coating -- BMS 10-11, Type 1 primer (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

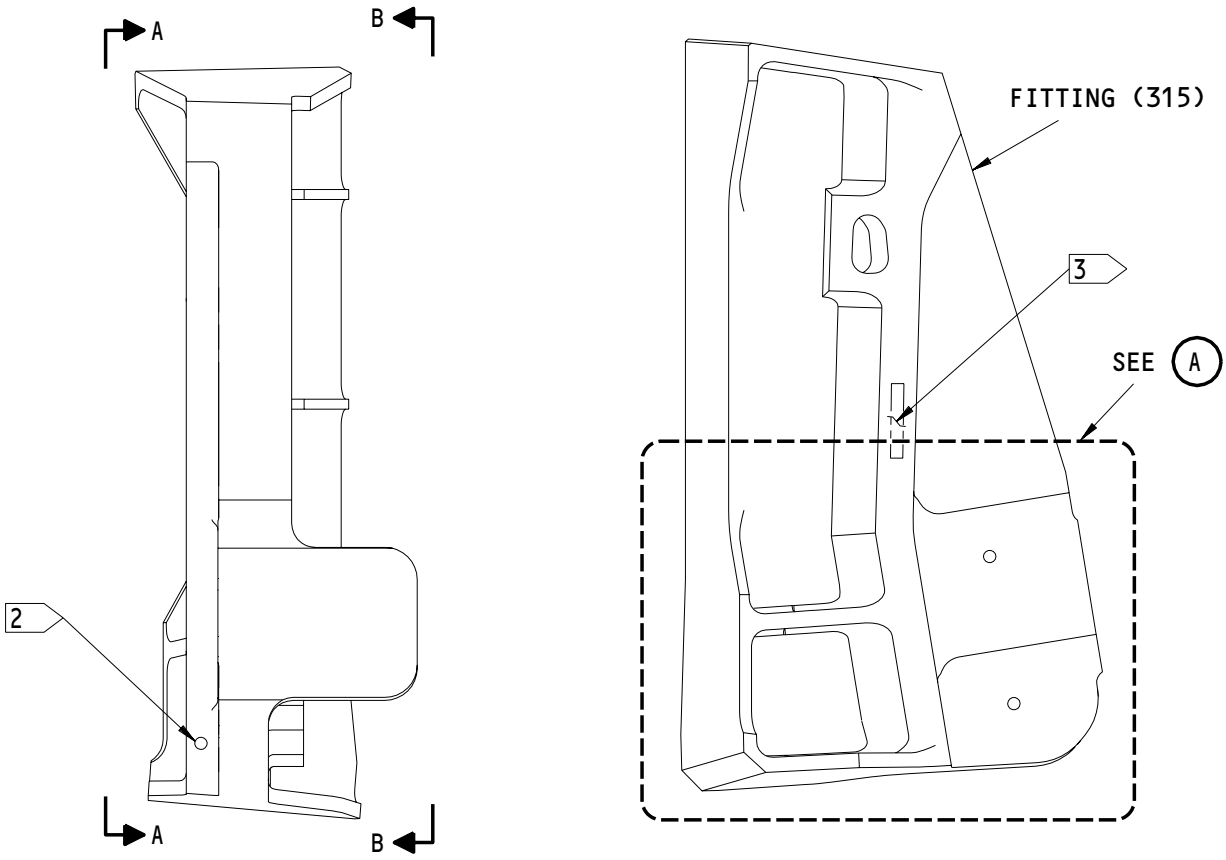
(4) SOPM 20-41-01, Decoding Table for Boeing Finish Codes

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

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

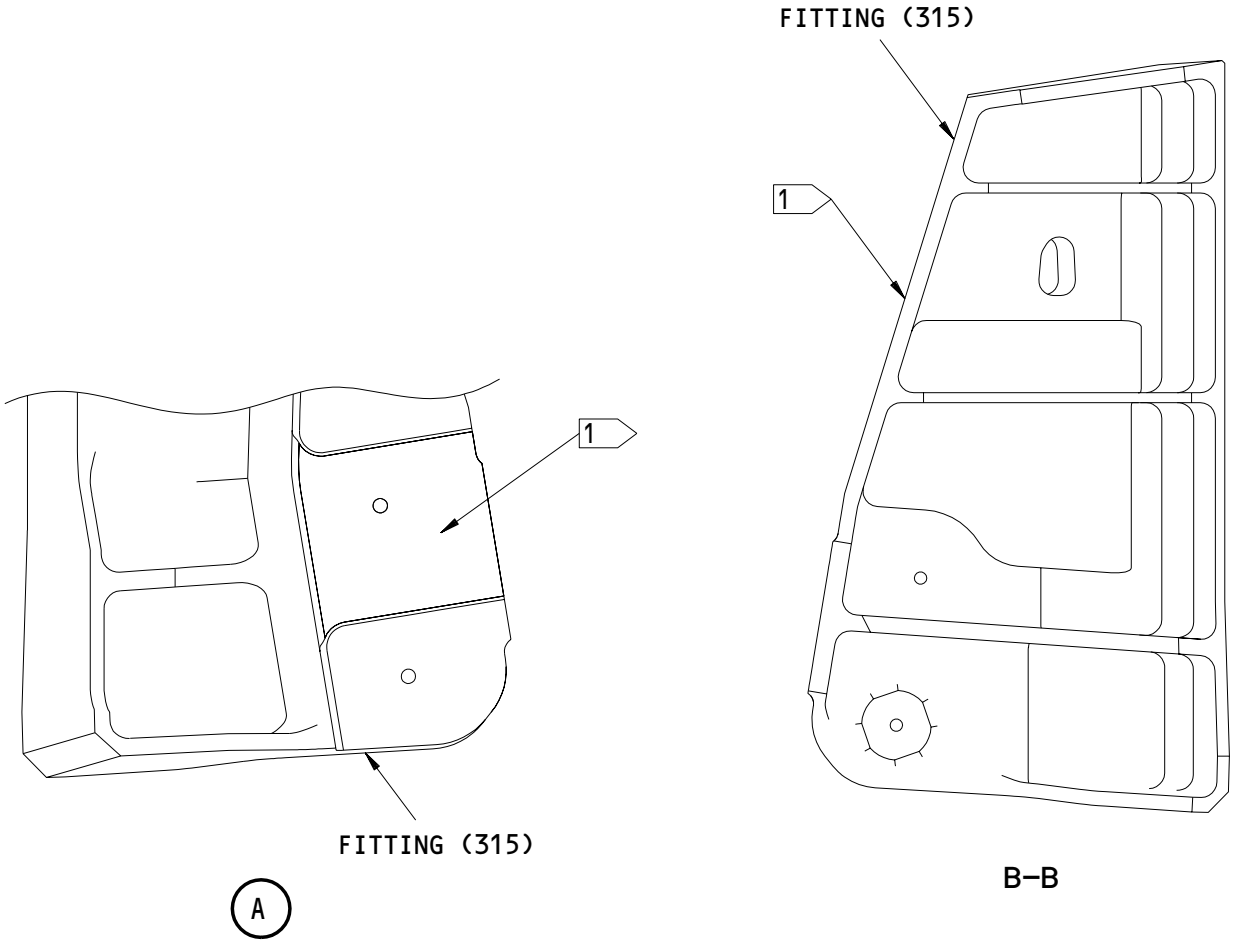
C. Procedure (Fig. 601)

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



112T1602–3 SHOWN
112T1602–4 OPPOSITE

112T1602–3,–4
Fitting Refinish
Figure 601 (Sheet 1)



1 DO NOT SHOT PEEN THIS SURFACE

2 DO NOT PUT PRIMER IN THIS HOLE

3 PART NUMBER AND SERIAL NUMBER LOCATION

ITEM NUMBERS REFER TO IPL FIG. 1

112T1602-3,-4
Fitting Refinish
Figure 601 (Sheet 2)

K26135

FUSE PIN - REPAIR 4-1

112T1611-1, -2

1. General

A. This procedure has the data necessary to refinish the fuse pin (140, 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.

D. General repair details:

(1) Material: 15-5PH

(2) HT TR: 150-170 Ksi

(3) Shot Peen: All surfaces, unless shown differently
Intensity 0.016A2, Coverage 2.0,
Over spray is allowed

2. Fuse Pin Refinish

A. Consumable Materials

NOTE: Equivalent material can be used.

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

(2) G00034 Fabric -- BMS 15-5, cheese cloth (SOPM 20-60-04)

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 20-41-02, Application of Chemical and Solvent Resistant Finishes

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

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

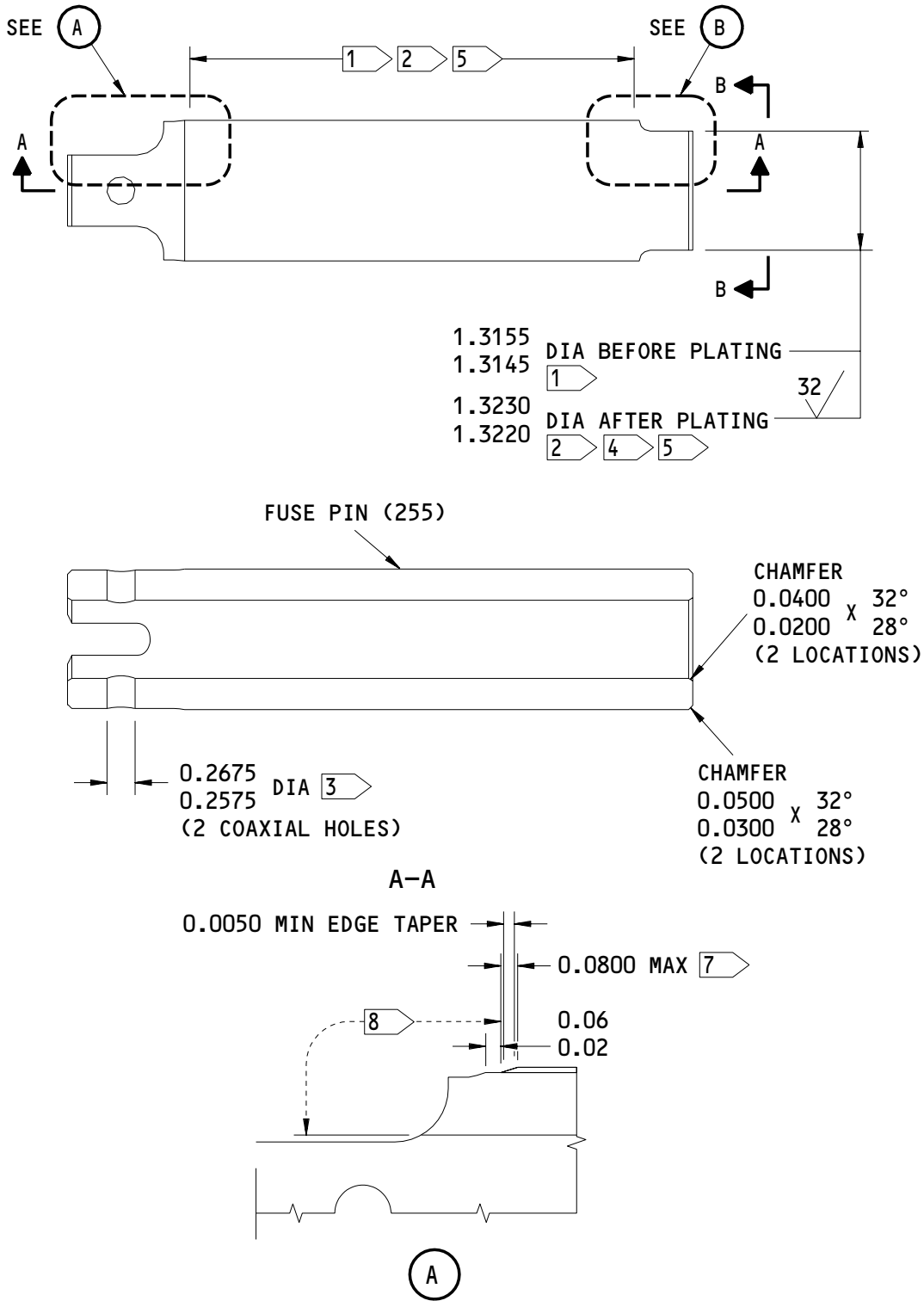
(7) SOPM 20-60-02, Finishing Materials

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

C. Procedure (Fig. 601, 602)

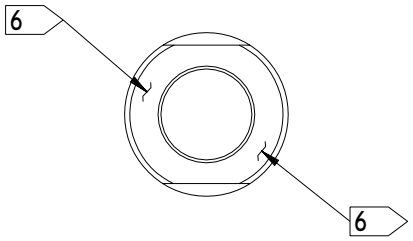
(1) Chrome plate and apply primer as indicated.

(2) Passivate (F-17.25) other surfaces.

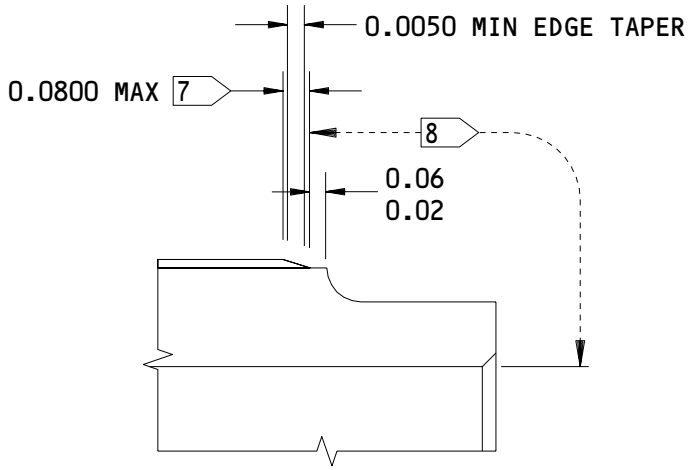


112T1611-1
Fuse Pin Refinish
Figure 601 (Sheet 1)

K25915



B–B



1 SHOT PEEN THIS SURFACE BEFORE CHROME PLATE

2 CHROME PLATE (F-15.34), 0.003 MINIMUM THICK

3 DO NOT SHOT PEEN THIS HOLE

4 WIPE CHROME PLATE WITH PRIMER (F-19.45)

5 GRIND CHROME PLATE TO AFTER PLATING DIMENSION AS NECESSARY

6 PART NUMBER, LOT NUMBER, VENDOR CODE AND ROCKWELL HARDNESS DATA LOCATION

7 CHROME PLATE RUNOUT

8 OVERSPRAY IS PERMITTED ON THIS SURFACE

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

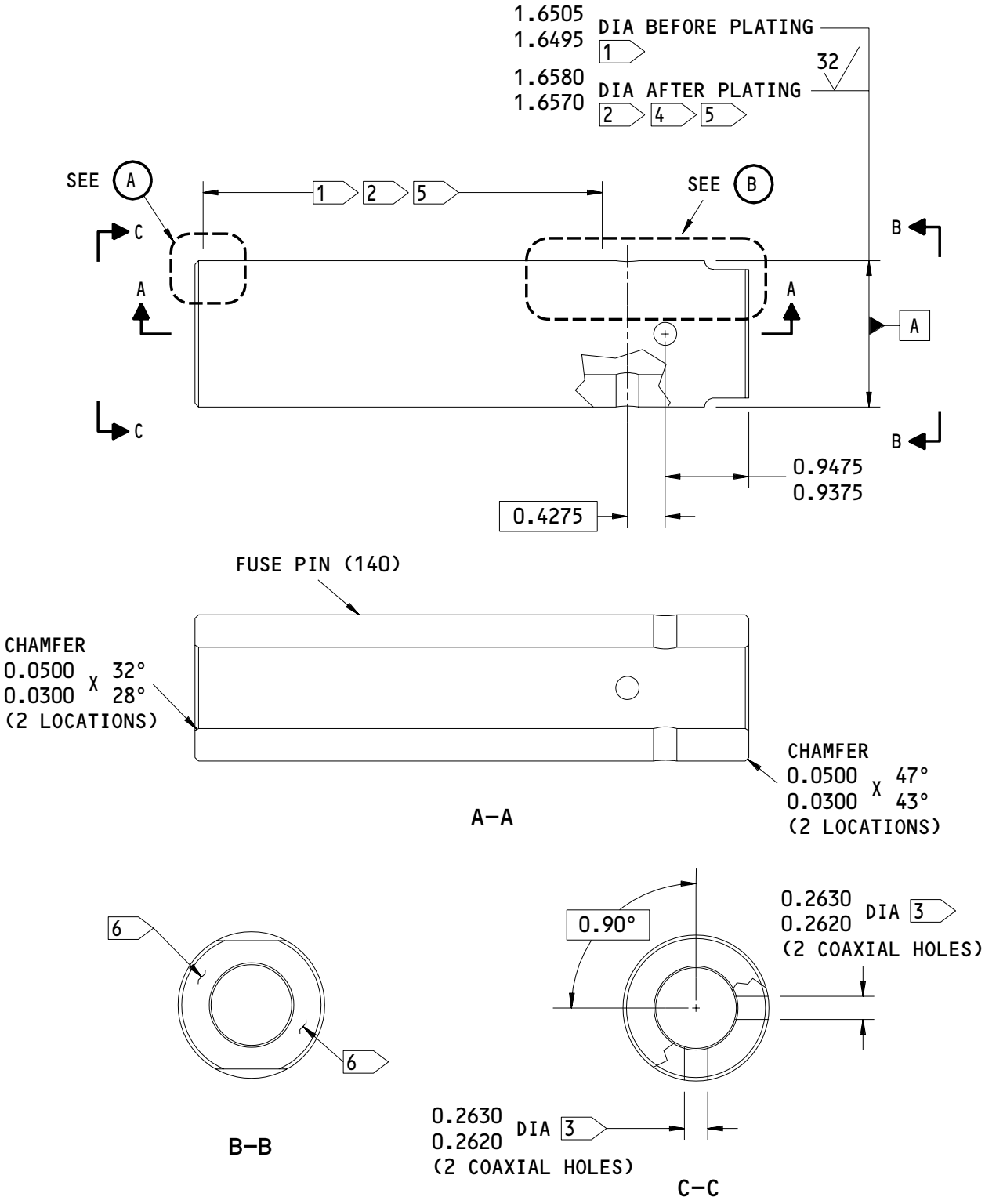
BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

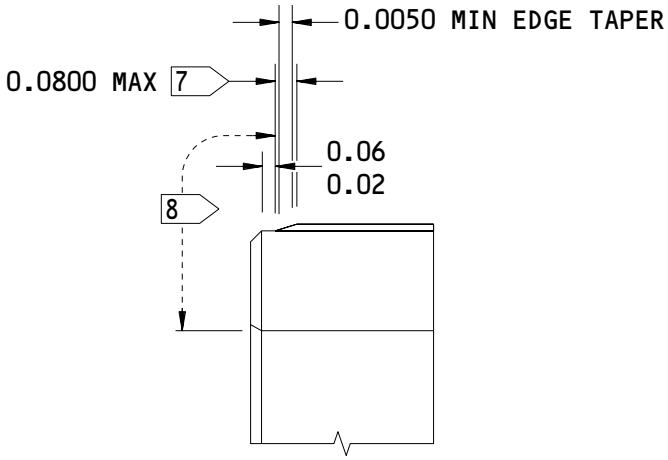
112T1611-1
Fuse Pin Refinish
Figure 601 (Sheet 2)

K25925

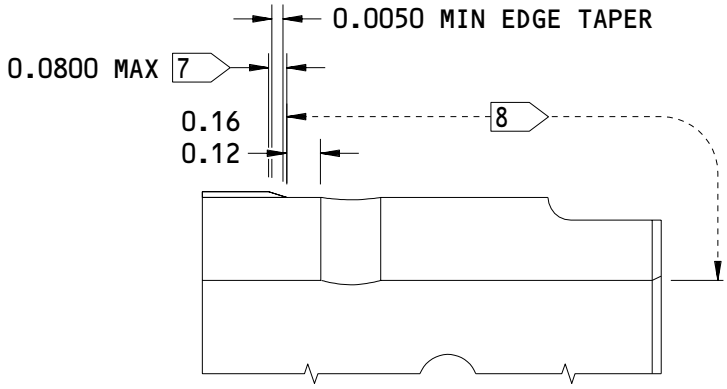


112T1611-2
Fuse Pin Refinish
Figure 602 (Sheet 1)

K25951



A



B

1 SHOT PEEN THIS SURFACE BEFORE CHROME PLATE

2 CHROME PLATE (F-15.34), 0.003 MINIMUM THICK

3 DO NOT SHOT PEEN THIS HOLE

4 WIPE CHROME PLATE WITH PRIMER (F-19.45)

5 GRIND CHROME PLATE TO AFTER PLATING DIMENSION AS NECESSARY

6 PART NUMBER, LOT NUMBER, VENDOR CODE AND ROCKWELL HARDNESS DATA LOCATION

7 CHROME PLATE RUNOUT

8 OVERSPRAY IS PERMITTED ON THIS SURFACE

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

112T1611-2
Fuse Pin Refinish
Figure 602 (Sheet 2)

K25956

HOUSING ASSEMBLY - REPAIR 5-1

112T1612-1, -5

1. General

   A. This procedure has the data necessary to repair the housing assembly (260).

   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. References

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

   B. Procedure (Fig. 601)

      (1) Remove the old bushings (275, 280) from the housing (285).

      (2) Install replacement bushings (275, 280) in the housing (285), with no installation finish, by the shrink-fit procedure. (SOPM 20-50-03).

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 old fitting(s) (265) from the housing (285).

(2) If you find defects on the inserts, refer to par. 4 for repair instructions.

(3) Install replacement lube fitting(s) (265) in the housing (285) with BMS 3-33 grease. Tighten the lube fittings to 25-30 pound-inches.

(4) Make sure that the lube passages are not blocked. Apply BMS 3-33 grease at the lube fittings until you see grease in the inside diameter of the housing.

4. Threaded Insert 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

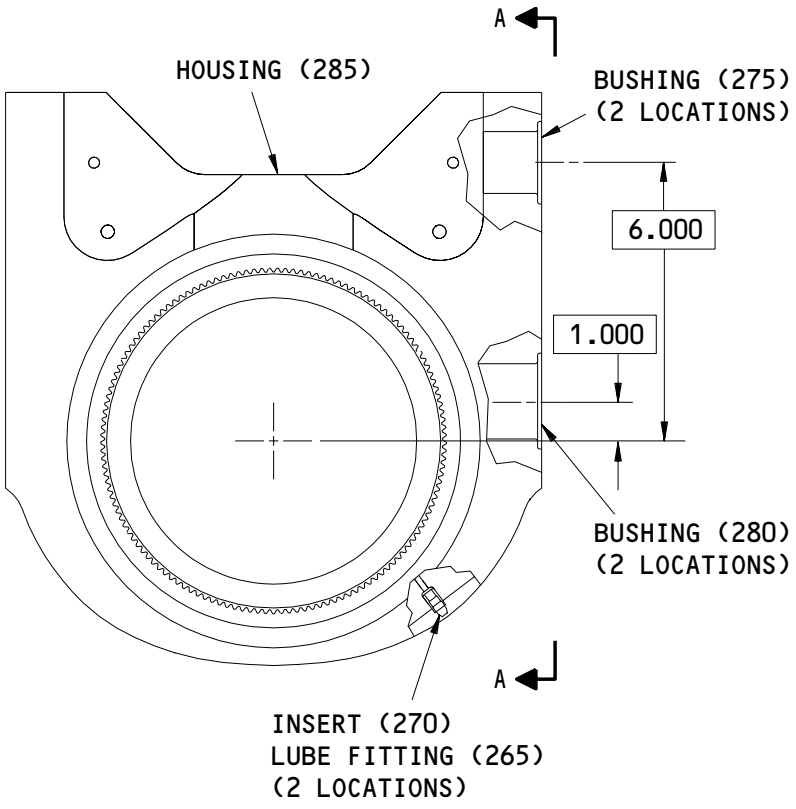
(3) SOPM 20-60-03, Lubricants

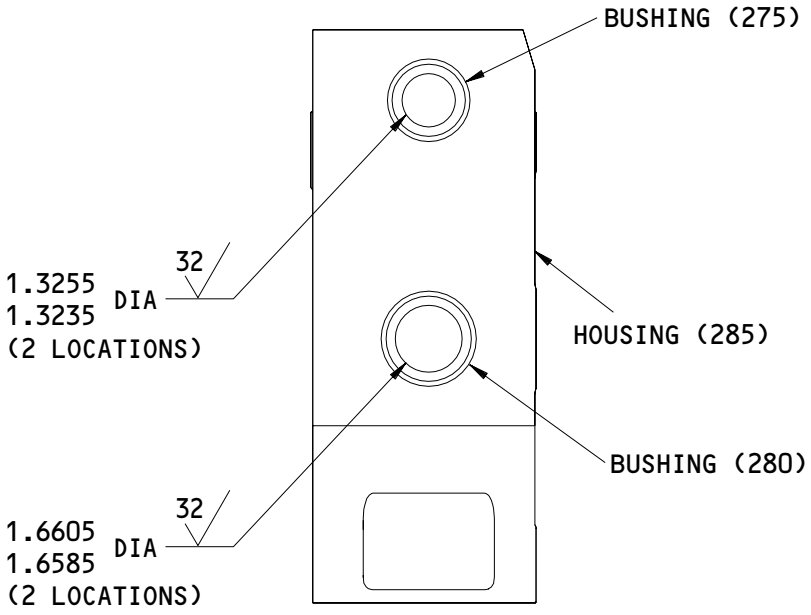
C. Procedure (Fig. 601)

(1) Remove the old threaded insert(s) (270) from the housing (285).

(2) Install replacement threaded insert(s) (270) in the housing (285) with BMS 3-33 grease by the shrink-fit procedure (SOPM 20-50-03).

(3) Put the threaded insert(s) (270) flush to the machined surface of housing (285) within plus or minus 0.02 inch.





A–A

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

112T1612-1,-5
Housing Assembly Repair
Figure 601

HOUSING - REPAIR 5-2

112T1612-3, -7

1. General

A. This procedure has the data necessary to repair and refinish the housing (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.

D. General repair details:

(1) Materials: Titanium alloy

(2) Shot Peen: All surfaces but not splines, threads or lube holes. Intensity 0.014-0.019A2

2. Housing Repair

A. References

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

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

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

B. Procedure (Fig. 601)

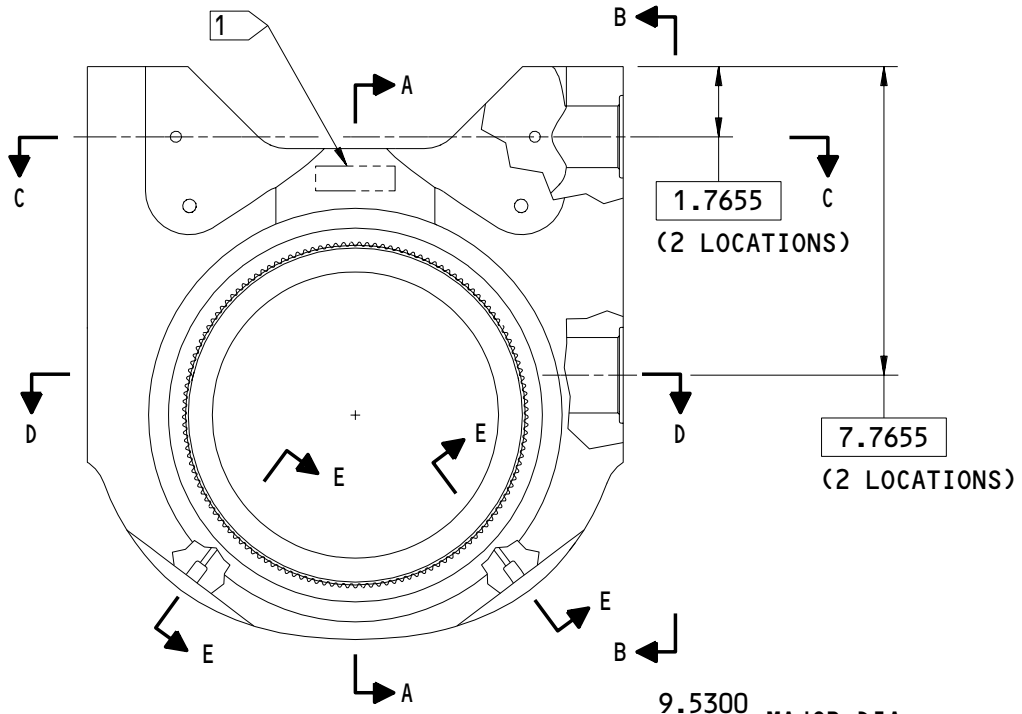
(1) Machine as necessary, within repair limits, to remove defects.

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

(3) Install the bushings as shown in REPAIR 5-1.

3. Housing Refinish

A. The housing has no finish (F-25.01).



9.5300
9.4700 MAJOR DIA

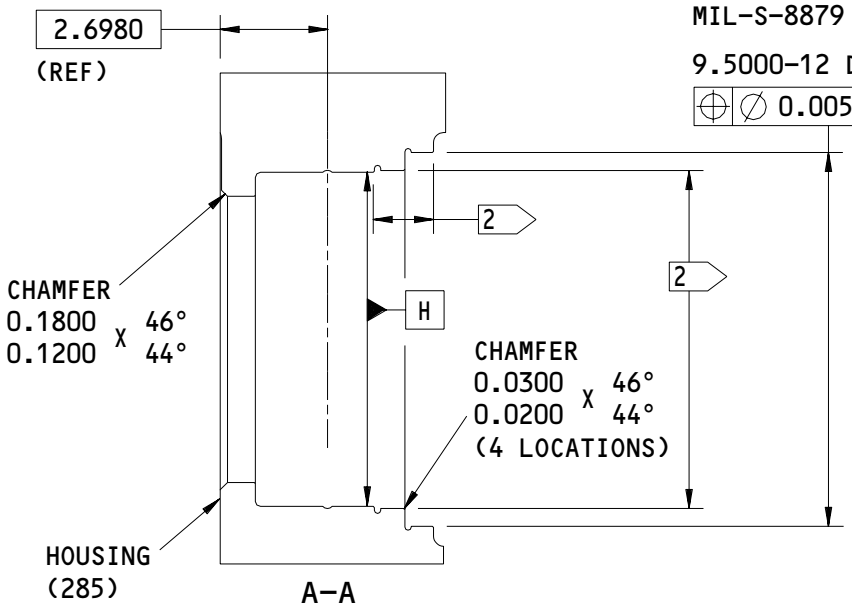
9.4531
9.4459 PITCH DIA

9.4288
9.4188 MINOR DIA

MIL-S-8879 AS IN 2

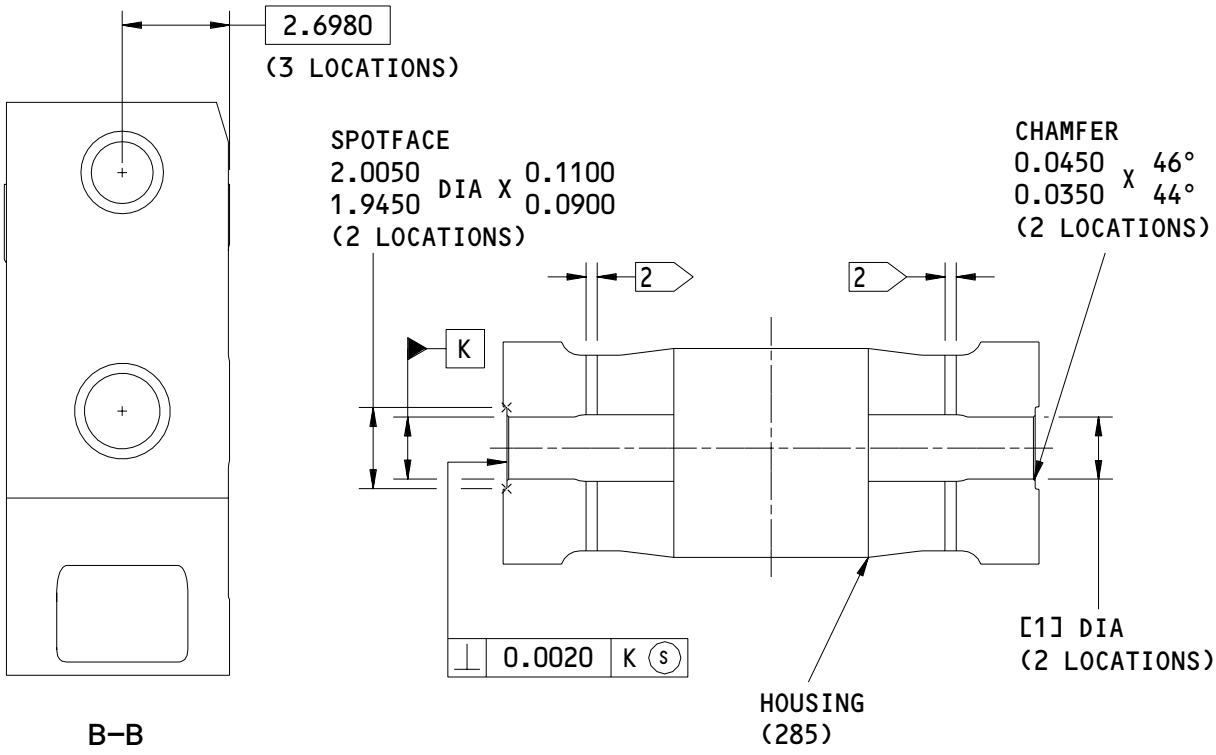
9.5000-12 DIA UNJS-3B OTHER THREAD

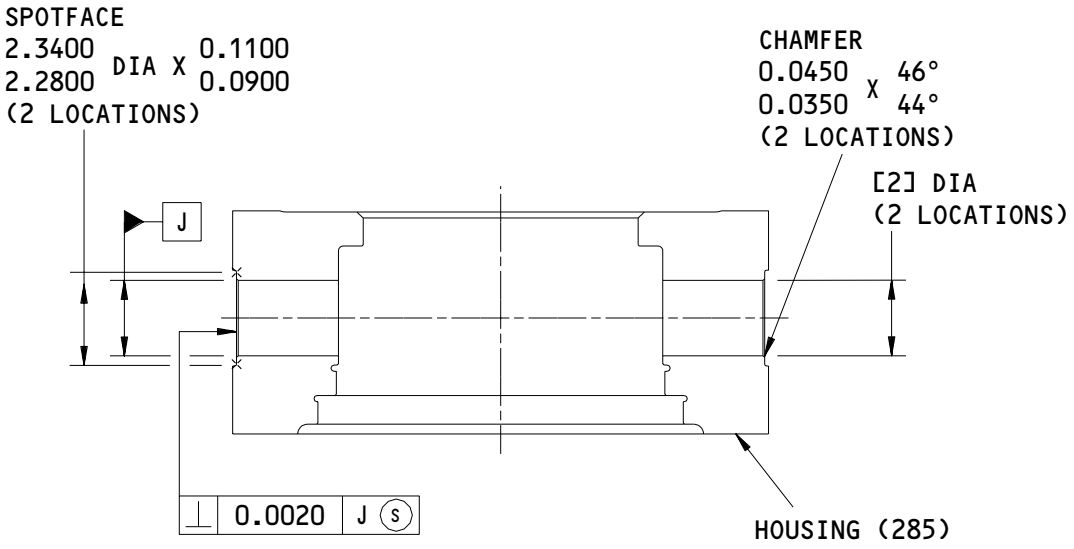
⌖ ∅ 0.0050 M H M



112T1612-3,-7
Housing Repair
Figure 601 (Sheet 1)

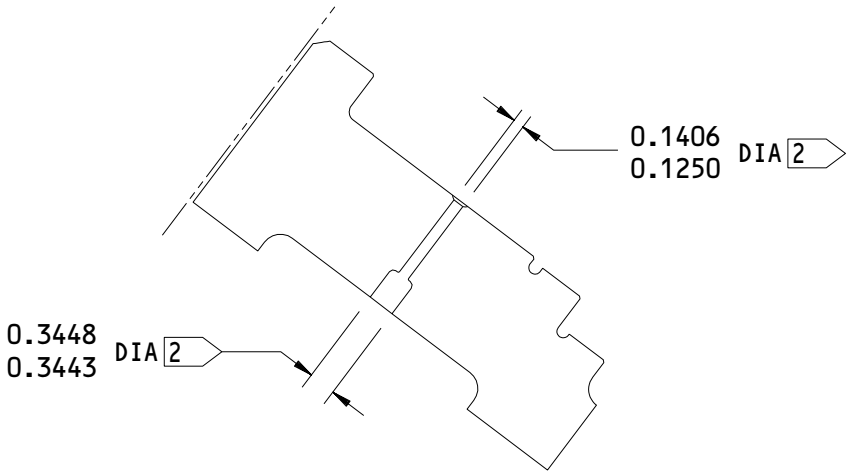
K26045





112T1612-3,-7
Housing Repair
Figure 601 (Sheet 2)

K26055



E-E

REFERENCE NUMBER	[1]	[2]
DESIGN DIMENSION	1.5619 1.5614	1.8963 1.8958
REPAIR LIMIT 3	1.6219	1.9563

1 PART NUMBER, SERIAL NUMBER AND VENDOR NUMBER LOCATION

2 MASK THIS SURFACE BEFORE SHOT PEEN

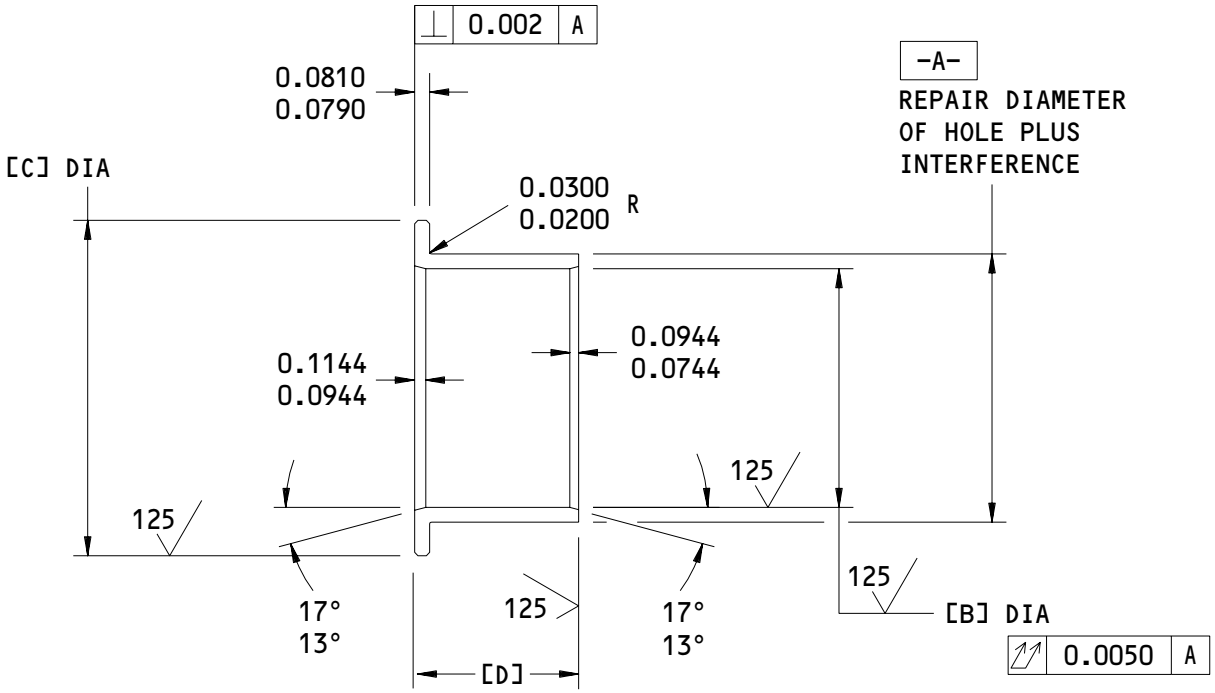
3 LIMIT FOR OVERSIZE BUSHING INSTALLATION

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

112T1612-3,-7
Housing Repair
Figure 601 (Sheet 3)

K26067



HOLE LOCATION (FIG. 601)	BUSHING REPLACES (IPL FIG. 1)	[B]	[C]	[D]	INTER-FERENCE
[1]	112T1614-1 (275)	1.3000 1.2800	1.8650 1.8450	1.4000 1.3900	0.0037 0.0028
[2]	112T1614-2 (280)	1.6350 1.6150	2.2000 2.1800	1.9950 1.9850	0.0044 0.0035

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: COPPER-BERYLLIUM (AMS 4535 OR AMS 4533)

FINISH: NO FINISH (F-25.01)

BREAK ALL SHARP EDGES 0.01-0.02 R

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

Oversize Bushing Details
Figure 602

K25869

FITTING ASSEMBLY - REPAIR 6-1

113T1992-11

1. General

   A. This procedure has the data necessary to repair the fitting assembly (210).

   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

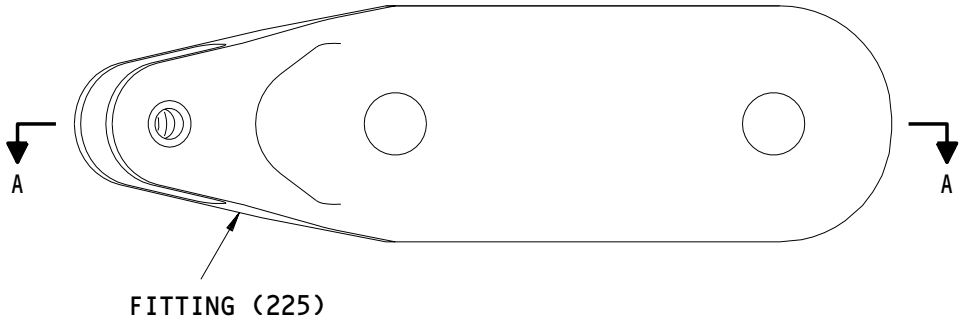
      (1) SOPM 20-50-03, Bushing and Bearing Replacement

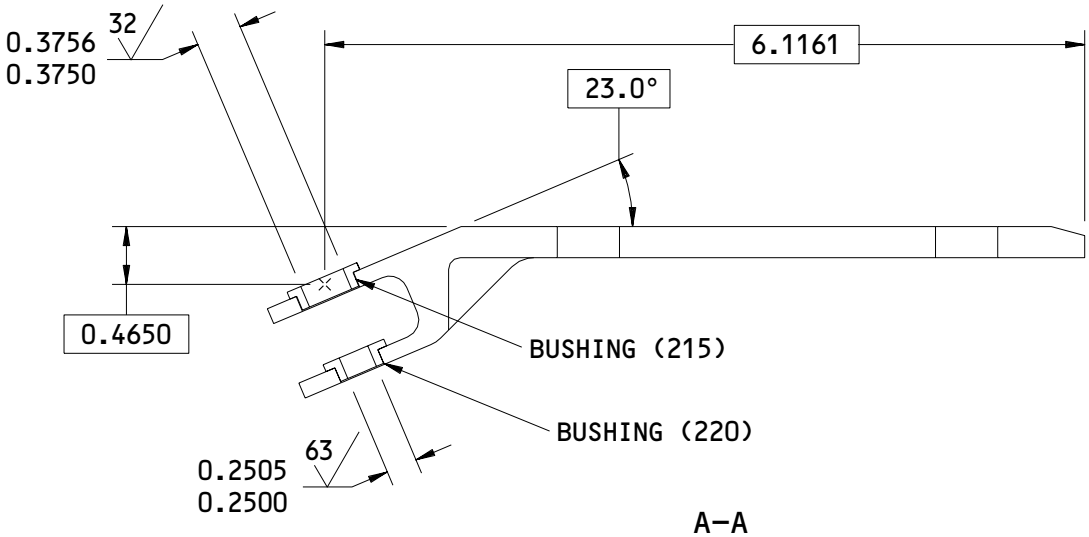
      (2) SOPM 20-60-04, Miscellaneous Materials

   C. Procedure (Fig. 601)

      (1) Remove the old bushings (215, 220) from the fitting (225).

      (2) Install replacement bushings (215, 220) in the fitting (225) with BMS 5-95 sealant by the shrink-fit procedure (SOPM 20-50-03).





ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

113T1992-11
Fitting Assembly Repair
Figure 601

K25970

FITTING - REPAIR 6-2

113T1992-13

1. General

A. This procedure has the data necessary to refinish the fitting (225).

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) Material: Aluminum alloy

2. Fitting Refinish

A. Consumable Materials

NOTE: Equivalent material can be used.

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

B. References

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

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

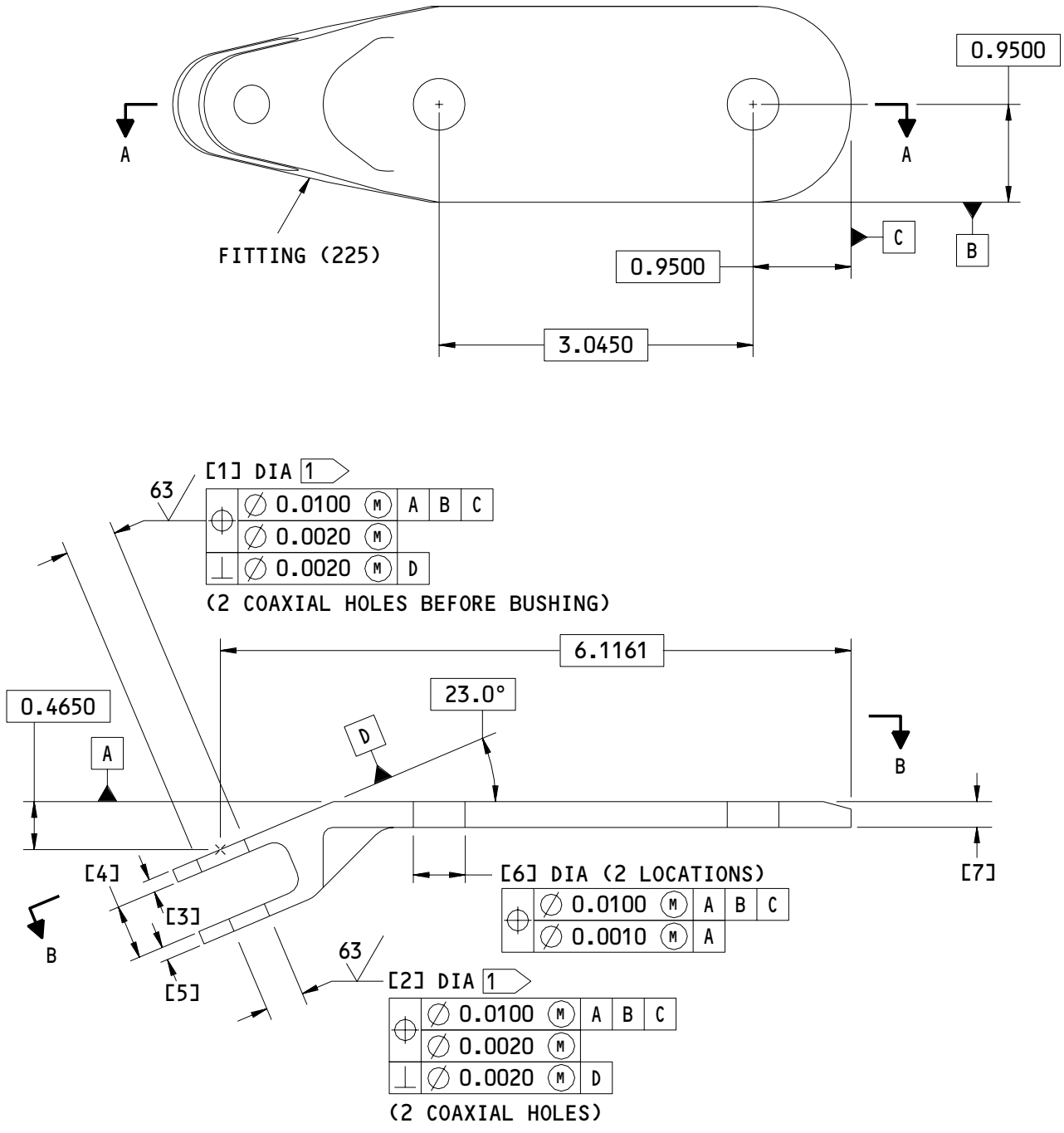
(3) SOPM 20-41-01, Decoding Table for Boeing Finish Codes

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

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

C. Procedure (Fig. 601)

(1) Boric acid-sulfuric acid anodize (F-17.31). Apply BMS 10-11, Type 1 primer (F-20.02) to all surfaces but not in holes for bushings.



A–A

113T1992–13
Fitting Refinish
Figure 601 (Sheet 1)

K25974

REFERENCE NUMBER	[1]	[2]	[3]	[4]	[5]	[6]	[7]
DESIGN DIMENSION	0.5006 0.5000	0.3756 0.3750	0.14 0.12	0.53 0.51	0.14 0.12	0.504 0.501	0.26 0.24
REPAIR LIMIT	--	--	--	--	--	--	--

1 DO NOT PUT PRIMER IN THESE HOLES

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

113T1992-13
Fitting Refinish
Figure 601 (Sheet 2)

K25976

ASSEMBLY

1. General

   A. This procedure has the necessary data to assemble the forward trunnion support machined assembly.

   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. Assembly

   A. Consumable Materials

      NOTE: Equivalent material can be used.

      (1) A00247 Sealant -- BMS 5-95 (SOPM 20-60-04)

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

   B. References

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

      (2) SOPM 20-50-02, Installation of Safetying Devices

      (3) SOPM 20-50-07, Lubrication

      (4) SOPM 20-50-19, General Sealing

      (5) SOPM 20-60-03, Lubricants

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

   C. Procedure

      (1) Use standard industry practices and these steps.

(2) Apply BMS 5-95 sealant on both faying surfaces of the side load fitting (335) and the outboard vertical fitting assembly (345) as shown in Fig. 701.

NOTE: Maximum gap between the side load fitting (335) and the outboard vertical fitting assembly (345) before fastener installation is 0.0050 inch.

(3) Apply BMS 5-95 sealant (SOPM 20-50-19, procedure 2) onto the bolts (325) and the collars (330).

(4) Install the side load fitting (335) onto the outboard vertical fitting assembly (345) with the bolts (325) and the collars (330). Install bolts (325) heads flush with the outboard vertical fitting assembly (345) surface within the limits shown (Fig. 701).

(5) Put the bearing plates (290, 295) and the housing assembly (260) between the inboard and outboard vertical fitting assemblies (300, 345) as shown in Fig. 702.

(6) Temporarily install the fuse pins (255) through the inboard and outboard vertical fitting assemblies (300, 345), the bearing plates (290, 295), and the housing assembly (260) as shown in Fig. 702, view A-A. These parts will be removed again when the unit is installed on the airplane.

(7) Temporarily install the bolts (235), the washers (240, 245), the nuts (250), and the cotter pins (230) into the housing assembly (260) and through the fuse pin (255). These parts will be removed again when the unit is installed on the airplane.

(8) Temporarily install the fuse pins (140) through the inboard and outboard vertical fitting assemblies (300, 345), and the housing assembly (260) as shown in Fig. 702, view B-B. These parts will be removed again when the unit is installed in the airplane.

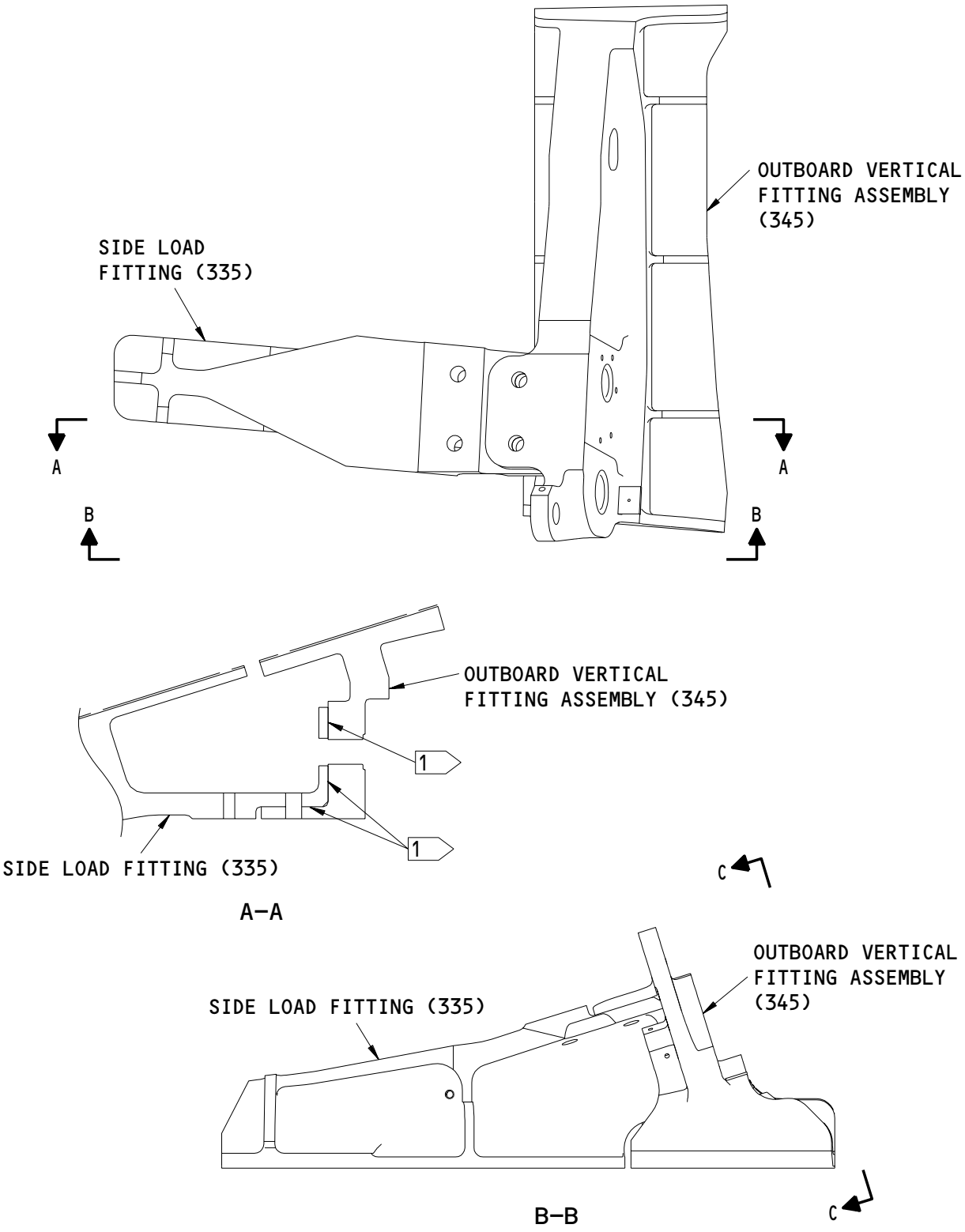
(9) Install the plastic inserts (110) into the fuse pins (140).

(10) Temporarily install the bolts (120), the washers (125, 130), the nuts (135), and the cotter pins (115) into the inboard and outboard vertical fitting assemblies (300, 345) and through the fuse pins (140) as shown in Fig. 702, view C-C. These parts will be removed again when the unit is installed in the airplane.

(11) If you have it, temporarily install the 287T6115-4001 bracket with the tension strap (205) and the fitting assembly (210) onto the inboard and outboard vertical fitting assemblies (300, 345) with the bolts (145, 150, 155), the washers (160, 165) and the nuts (170), as shown in Fig. 702. These parts will be removed again when the unit is installed in the airplane.

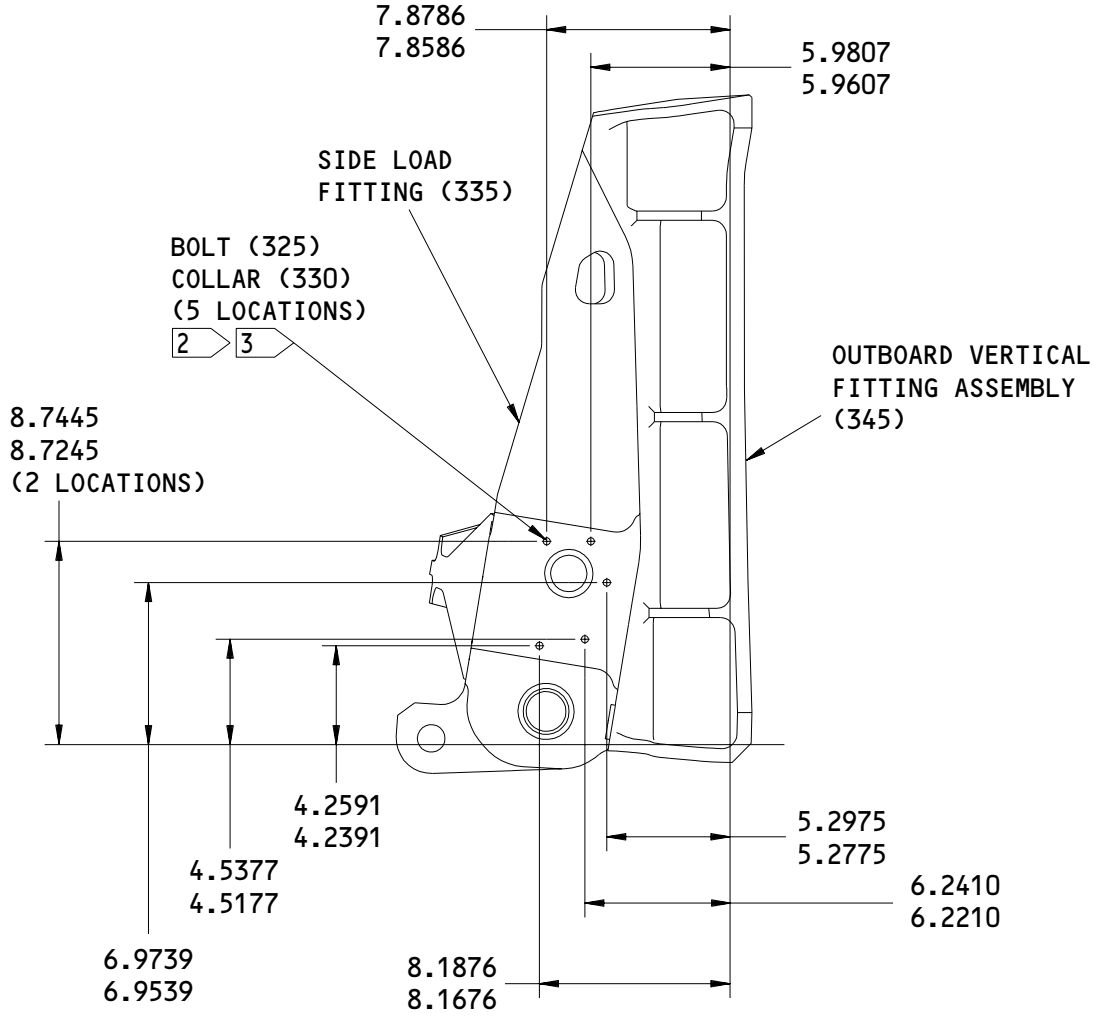
(12) Apply BMS 5-95 fay surface sealant between the bracket assemblies (20, 40, or 60) and the inboard and outboard vertical fitting assemblies (300, 345) as identified by flagnote 1 in Fig. 703.

(13) Install the bracket assemblies (20, 40 ot 60) onto the inboard and outboard fitting assemblies (300, 345) with the bolts (10) and nuts (15) with BMS 5-95 sealant as identified by flagnote 2 in Fig. 703.



Side Load and Vertical Fitting Assembly
Figure 701 (Sheet 1)

K26703



C–C

1 APPLY BMS 5-95 SEALANT TO BOTH FAYING SURFACES OF SIDE LOAD FITTING AND THE OUTBOARD VERTICAL FITTING ASSEMBLY

2 INSTALL FASTENER WITH BMS 5-95 SEALANT (SOPM 20-50-19, PROCEDURE 2)

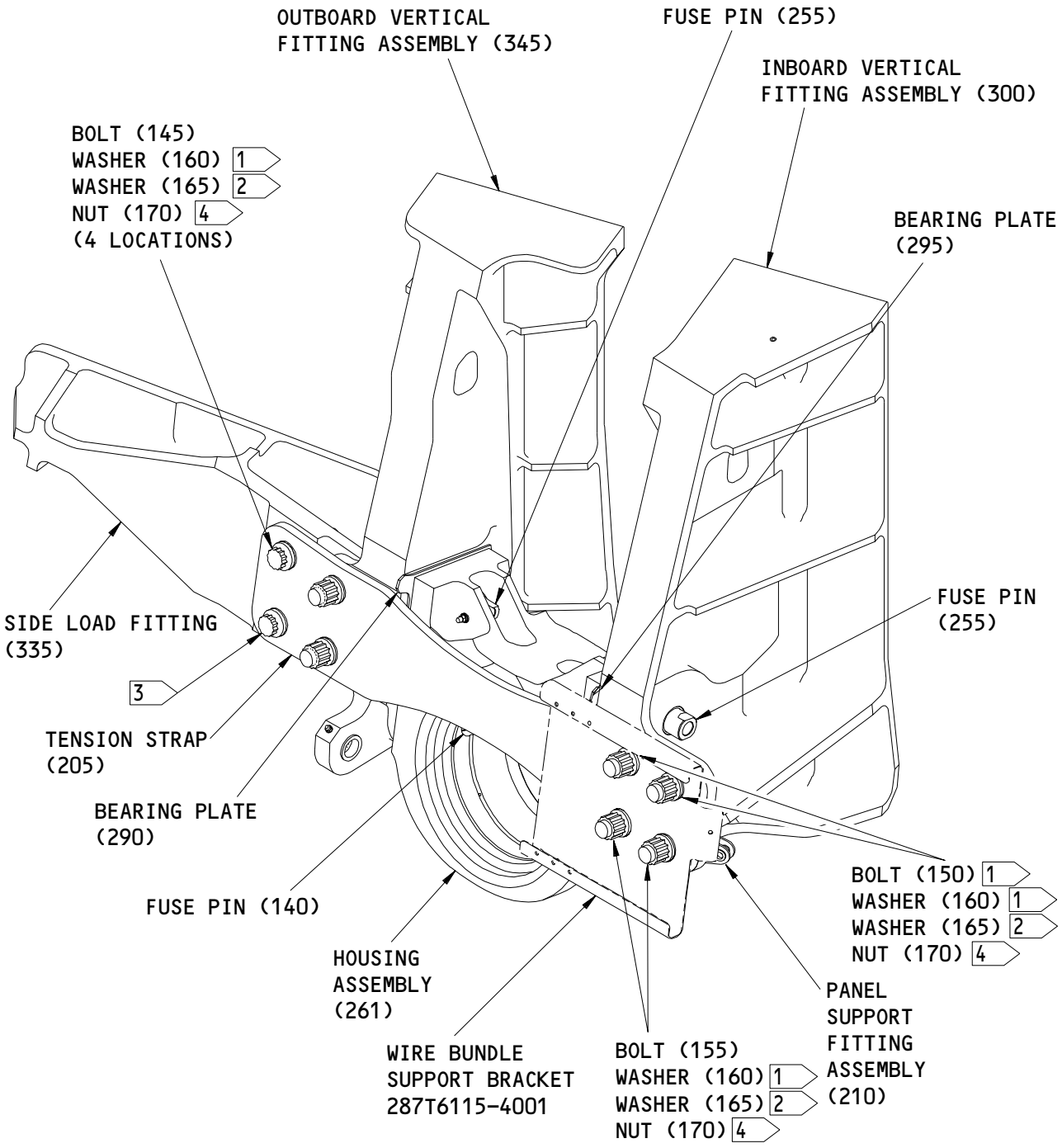
3 BOLT HEAD MUST BE INSTALLED FLUSH WITHIN 0.0030-0.0150 INCH OF THE OUTBOARD VERTICAL FITTING ASSEMBLY SURFACE

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

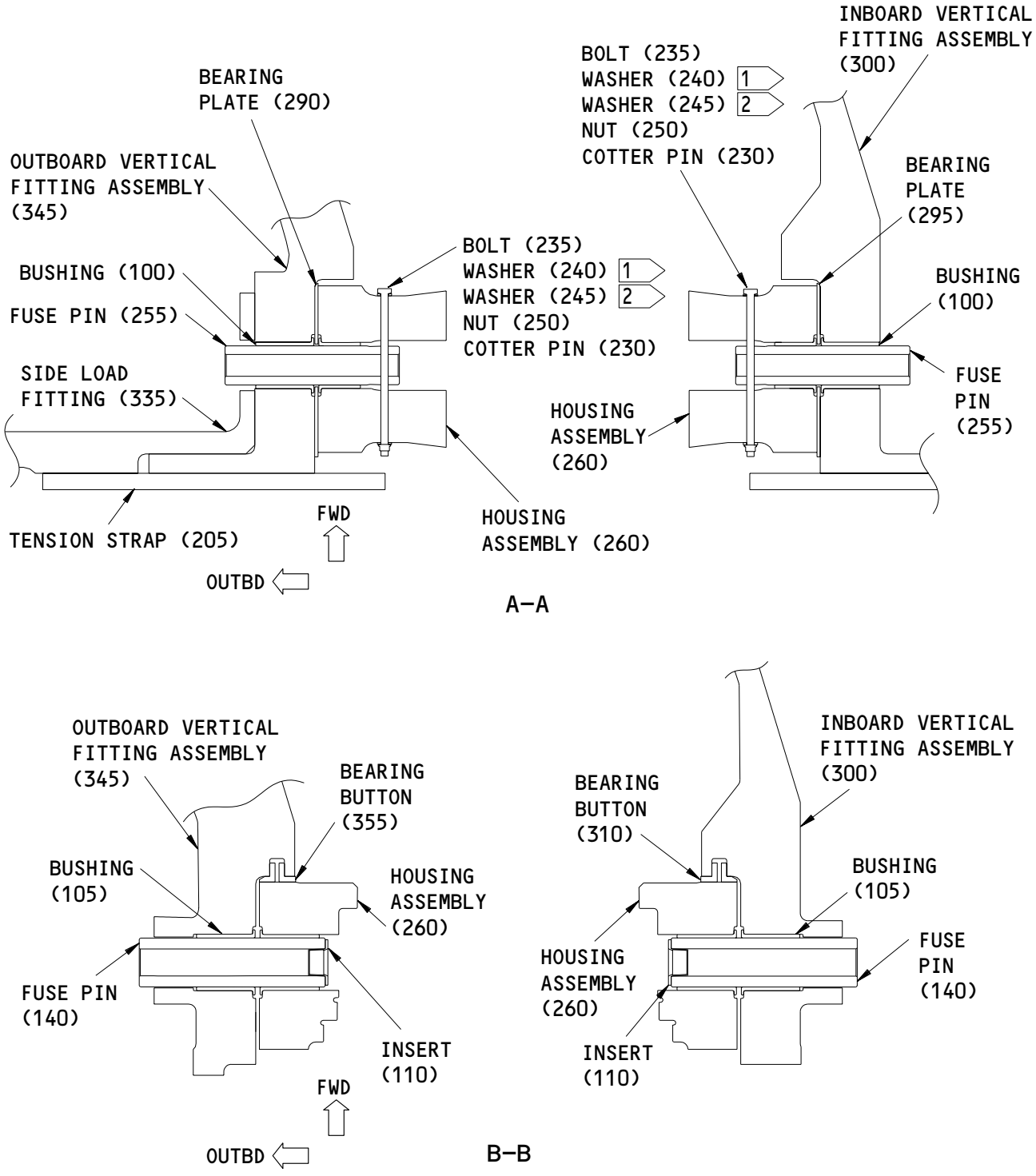
Side Load and Vertical Fitting Assembly
Figure 701 (Sheet 2)

K26723



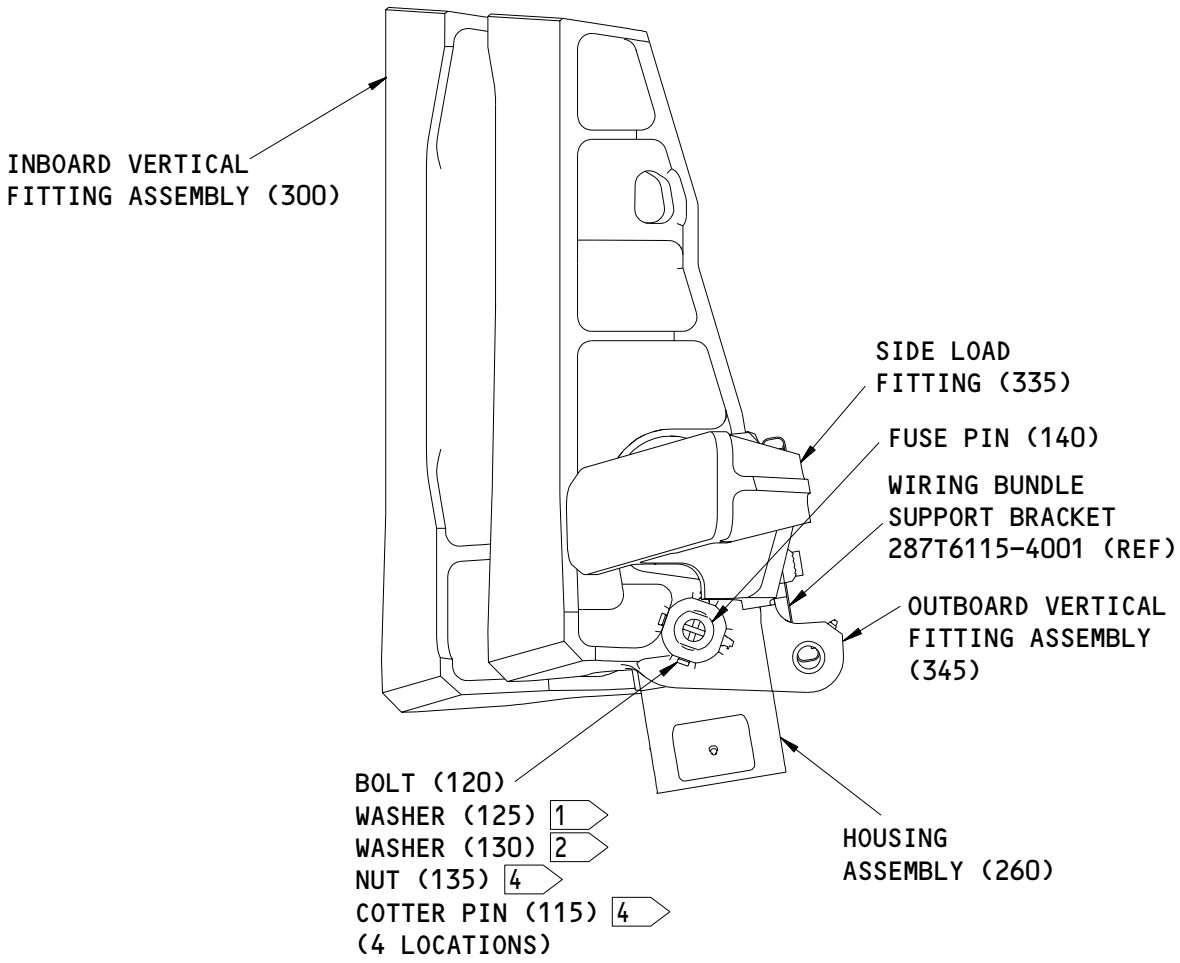
Forward Trunnion Support Machined Assembly
Figure 702 (Sheet 1)

K26738



Forward Trunnion Support Machined Assembly
Figure 702 (Sheet 2)

K26751



C–C

1 > UNDER BOLT HEAD

2 > UNDER NUT

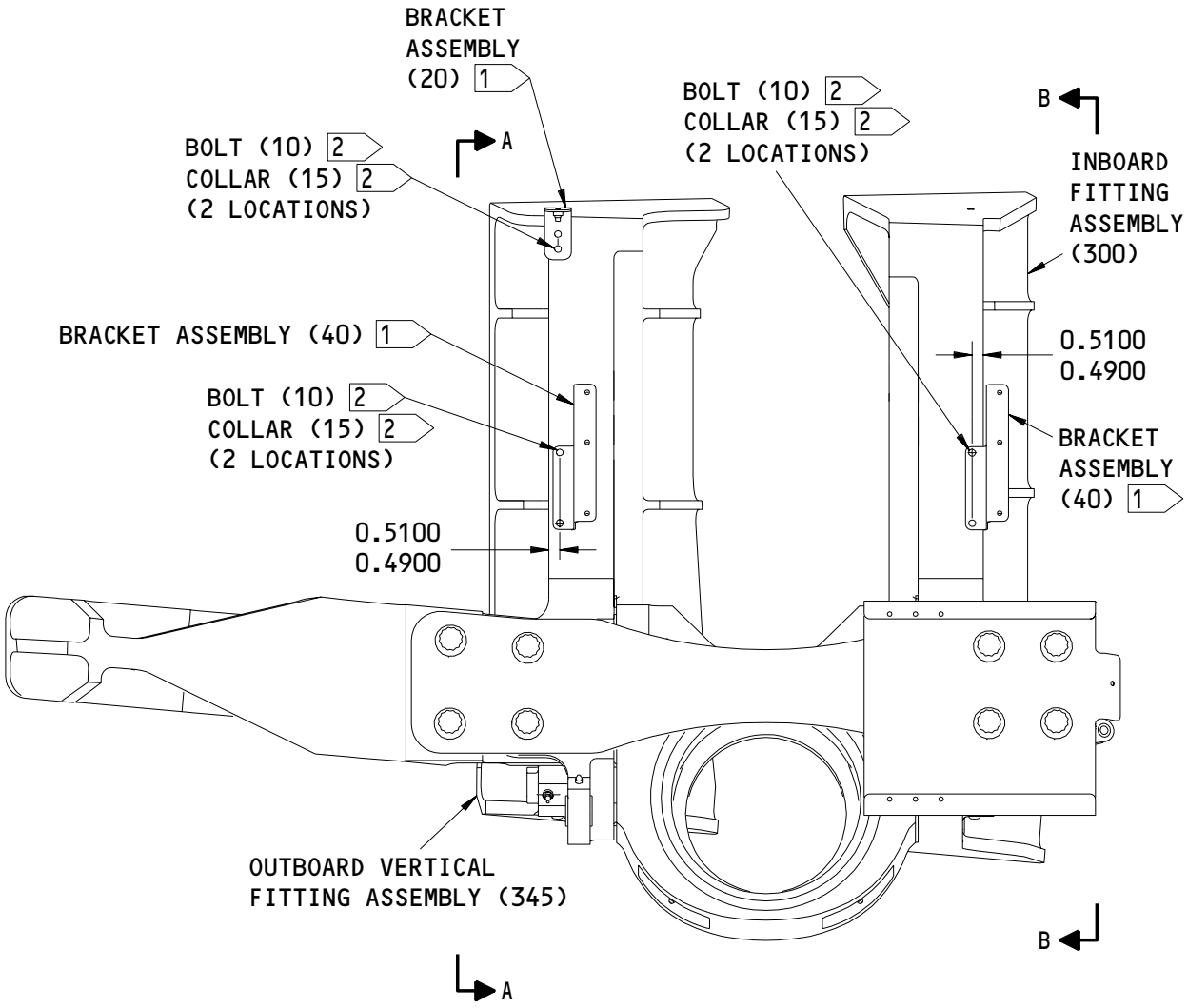
3 > DIRECTION AS SHOWN FOR 112T1600-19-20.
DIRECTION OPPOSITE FOR 112T1600-7,-8,
-11,-12,-15,-16

4 > INSTALL ONLY TEMPORARILY. NUT WILL BE
TIGHTENED AND COTTER PIN FULLY BENT
WHEN UNIT IS INSTALLED IN AIRPLANE

ITEM NUMBERS REFER TO IPL FIG. 1

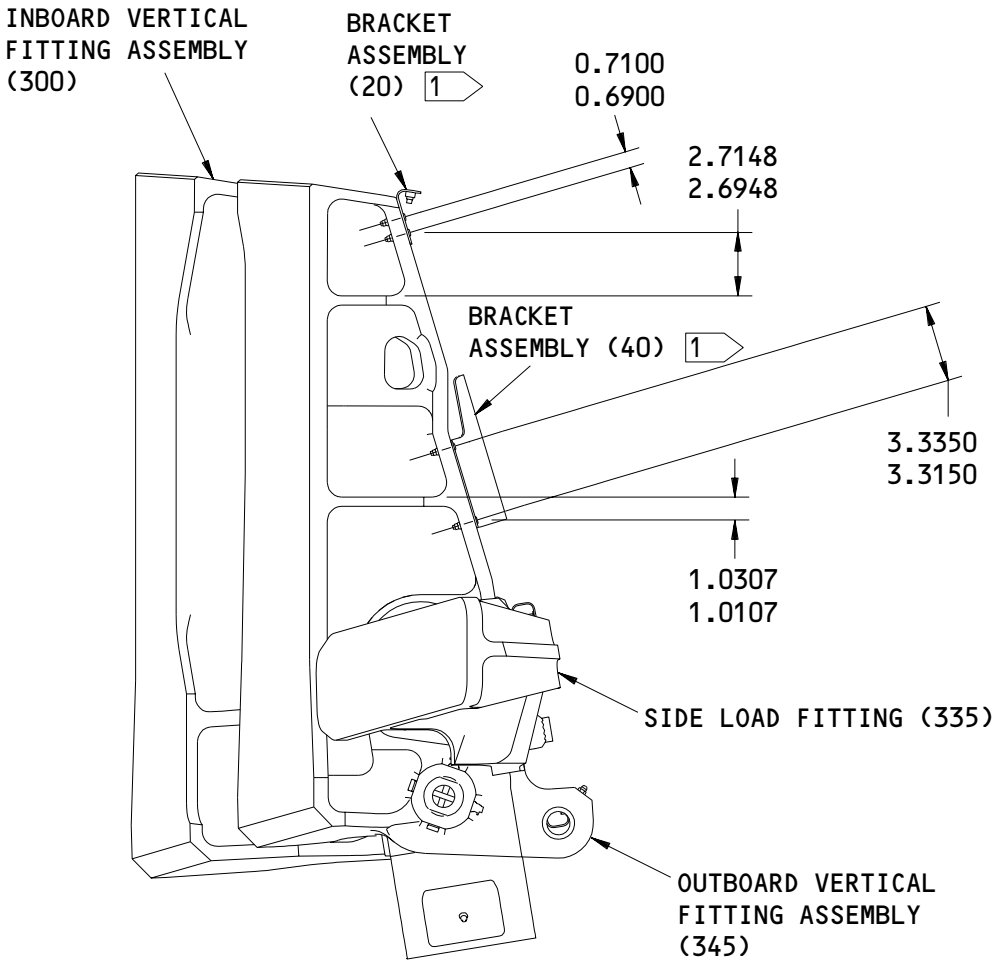
Forward Trunnion Support Machined Assembly
Figure 702 (Sheet 3)

K26776



Bracket Assembly Installation
Figure 703 (Sheet 1)

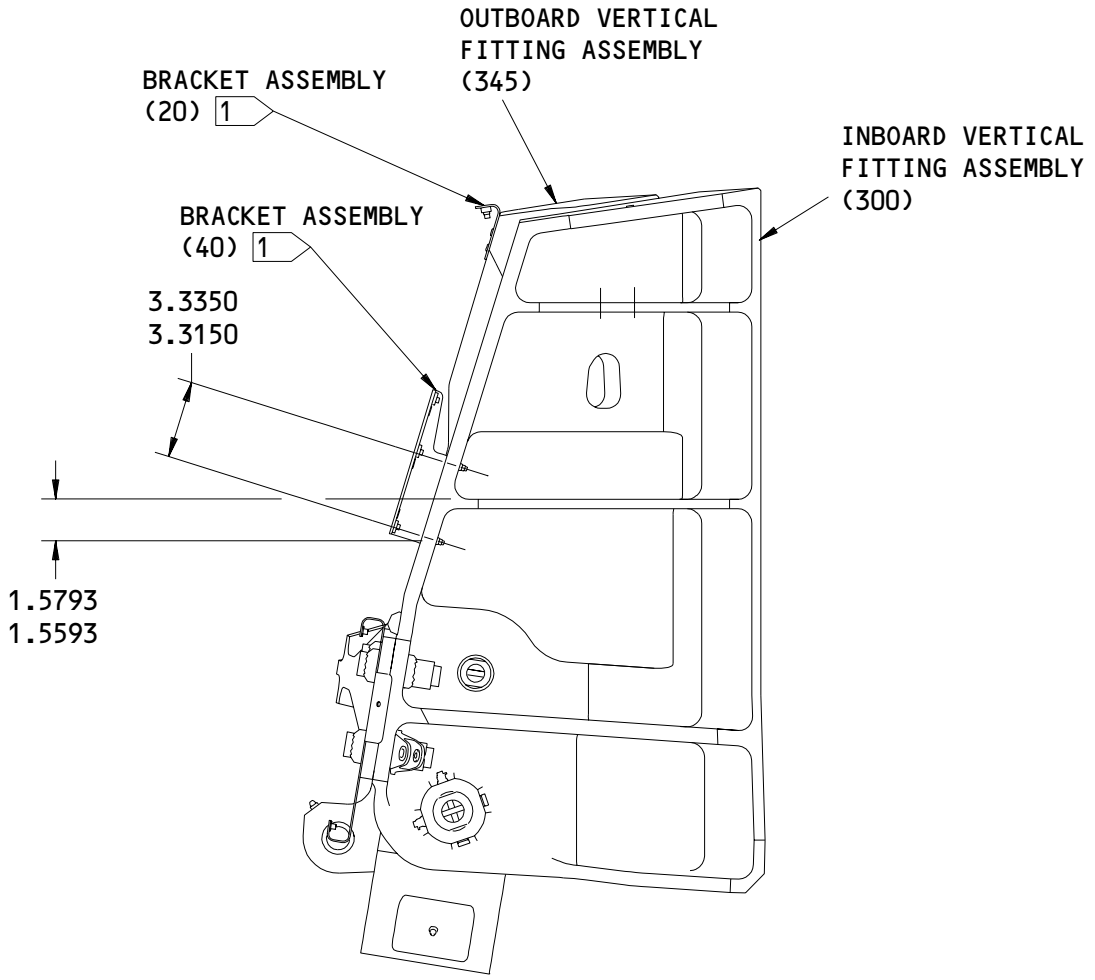
K26785



A–A

Bracket Assembly Installation
Figure 703 (Sheet 2)

K26800



B–B

1 APPLY BMS 5-95 FAY SURFACE SEALANT BETWEEN THE BRACKET ASSEMBLY AND THE VERTICAL FITTING ASSEMBLY

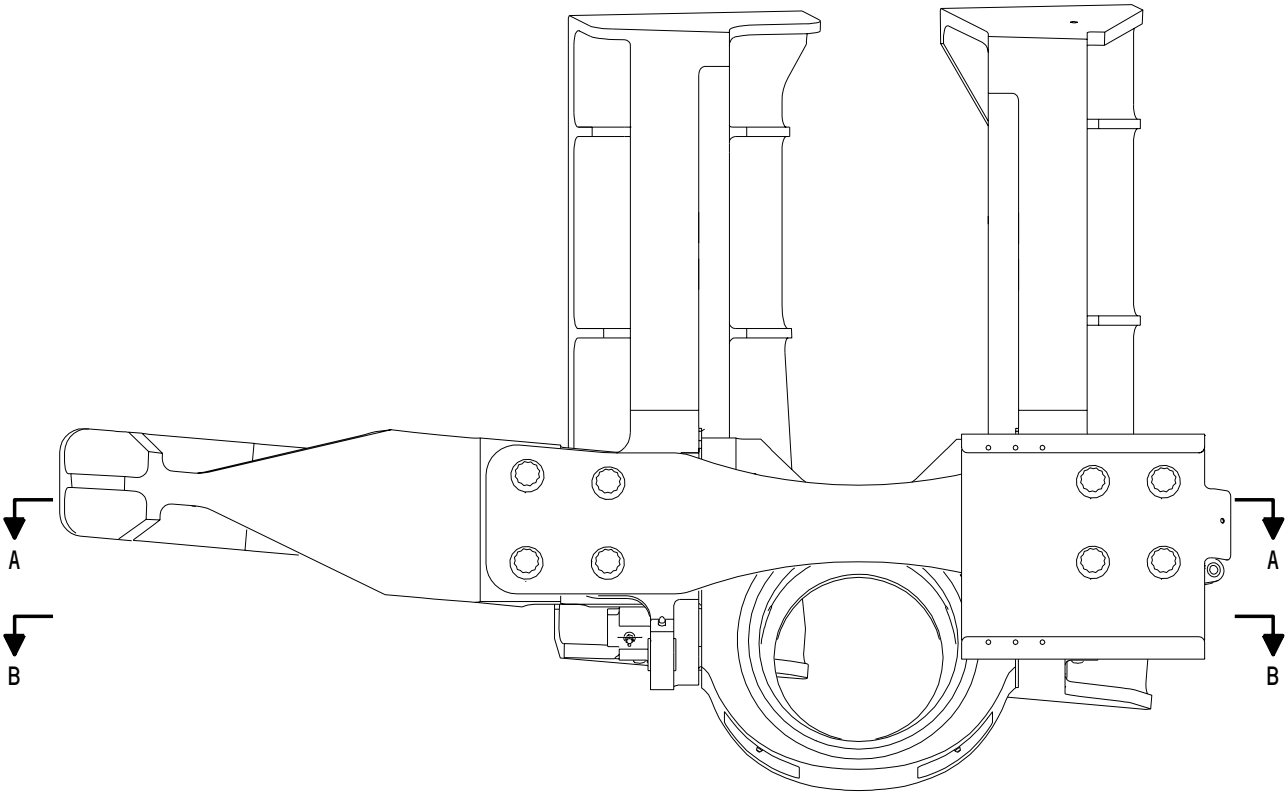
2 INSTALL THIS FASTENER WITH BMS 5-95 SEALANT (SOPM 20-50-19, PROCEDURE 2)

ITEM NUMBERS REFER TO IPL FIG. 1

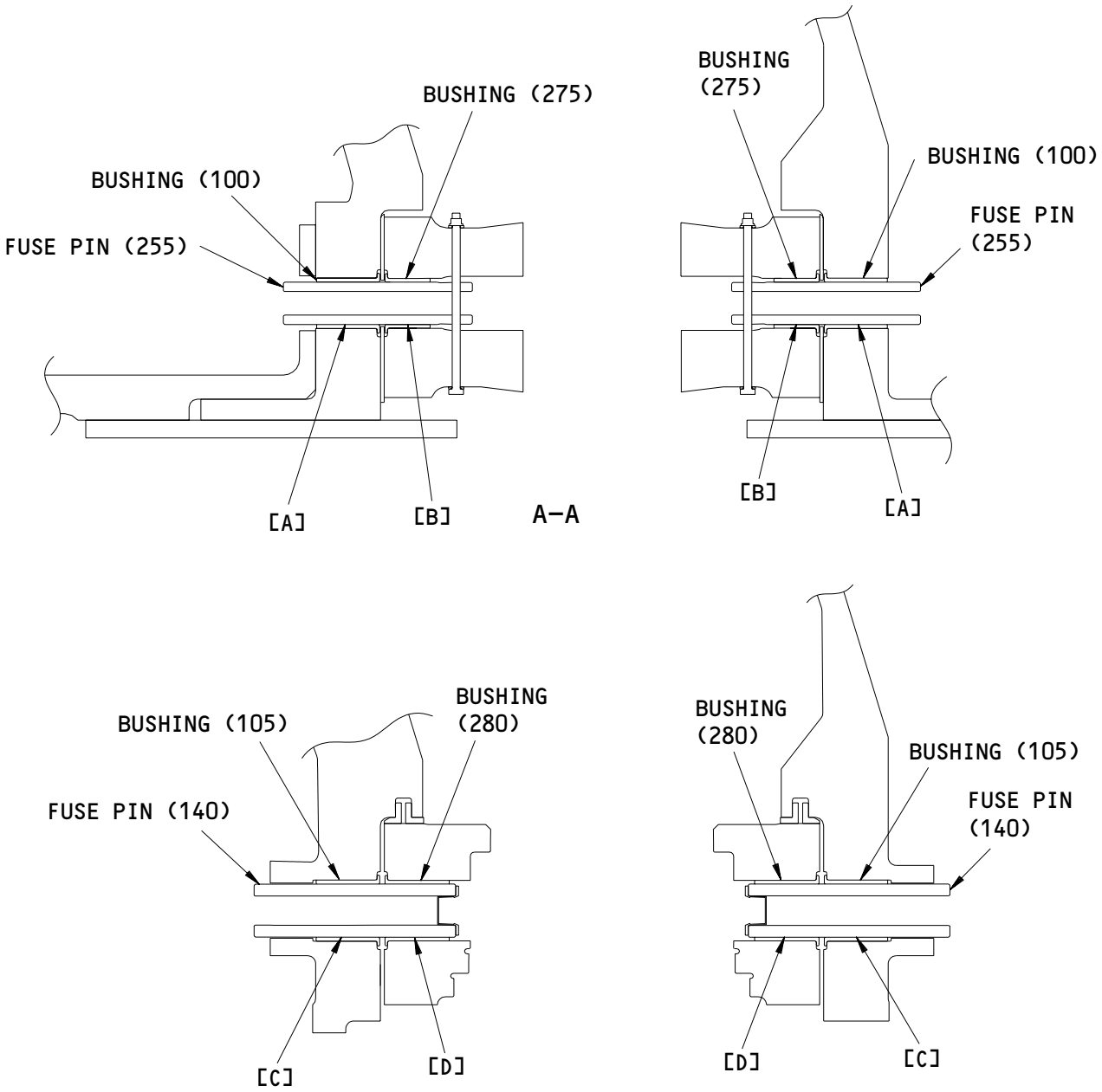
ALL DIMENSIONS ARE IN INCHES

Bracket Assembly Installation
Figure 703 (Sheet 3)

K26835



Fits and Clearances
Figure 801 (Sheet 1)



Fits and Clearances
Figure 801 (Sheet 2)

K26840

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 100	1.3235	1.3255	0.0005	0.0035		1.3305	0.0070
	OD 255	1.3220	1.3230			1.3145		
[B]	ID 275	1.3235	1.3255	0.0005	0.0035		1.3305	0.0070
	OD 255	1.3220	1.3230			1.3145		
[C]	ID 105	1.6585	1.6605	0.0005	0.0035		1.6655	0.0070
	OD 140	1.6570	1.6580			1.6495		
[D]	ID 280	1.6585	1.6605	0.0005	0.0035		1.6655	0.0070
	OD 140	1.6570	1.6580			1.6495		

* ALL DIMENSIONS ARE IN INCHES

Fits and Clearances
Figure 801 (Sheet 3)

K26842

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

06710 LAMSON AND SESSIONS CO THE VALLEY-TODECO
12975 BRADLEY AVENUE
SYLMAR, CALIFORNIA 91342-3830
FORMERLY VALLEY BOLT CORP VB0097 IN NORTH HOLLYWOOD, CA

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

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

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

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

VENDORS

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

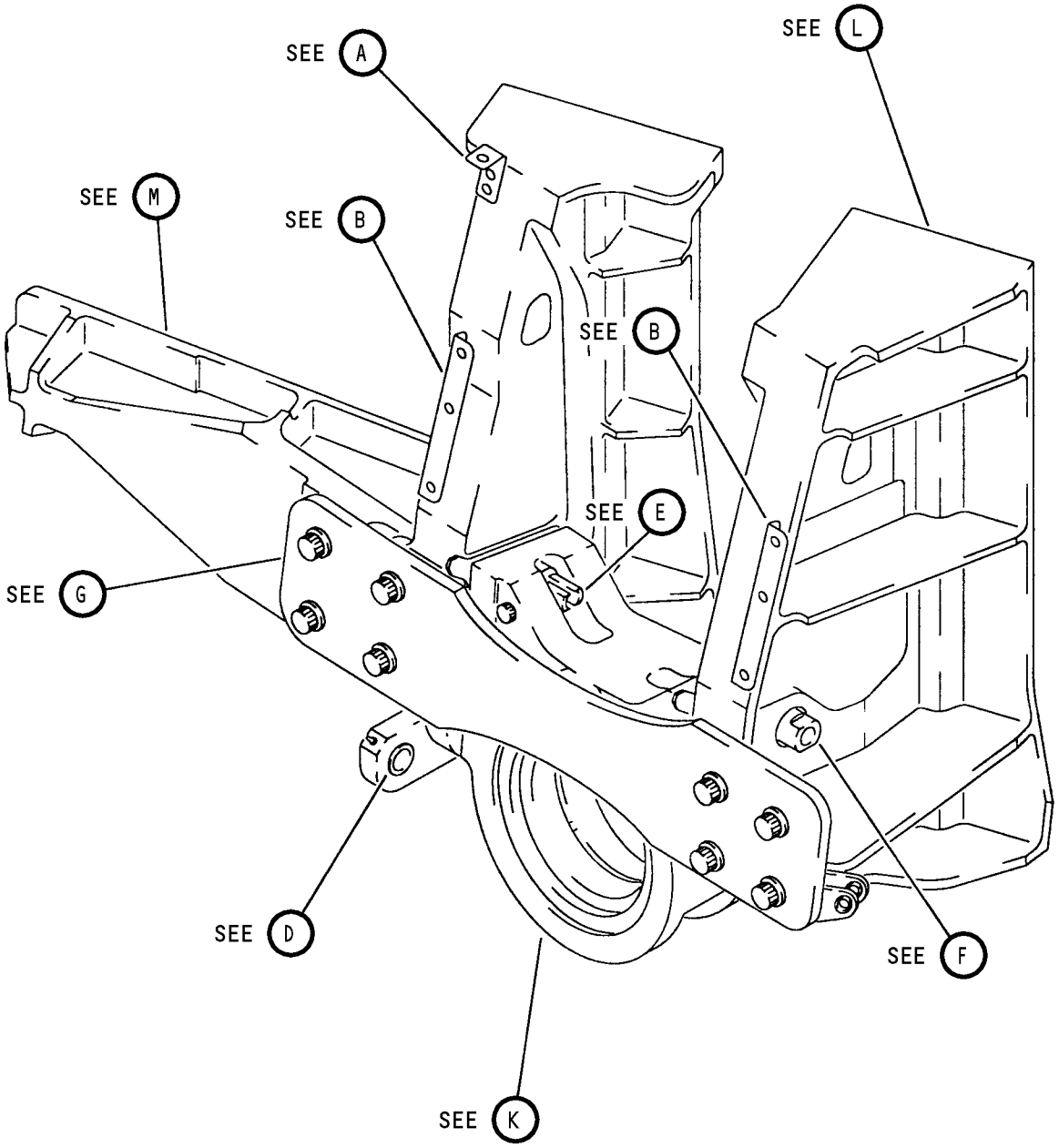
95760 PROTECTIVE CLOSURES CO. INC.
2150 ELMWOOD AVENUE
BUFFALO, NEW YORK 14207-1910

97928 HUCK INTL INC
3969 PARAMOUNT BLVD
LAKEWOOD, CALIFORNIA 90712-4193

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACB28AP04P012		1	220	1
BACB28AT06B012C		1	215	1
BACB28AT16B040C		1	95	2
BACB28Y3M055		1	80	1
BACB30US14K24		1	150	2
BACB30US14K28		1	155	2
BACB30US14K35		1	145	4
BACB30UU4K44DH		1	120	4
		1	236	2
BACB30UU4K81DH		1	235	2
BACB30VT6K12		1	10A	6
BACB30YP10K40		1	325	5
BACC30BL10		1	330	5
BACC30BL6		1	15	6
BACN10HR14CD		1	170	8
BACN10KB3F		1	50	4
		1	70	4
BACN10KE3B5CD		1	30	1
BACN10YR4CD		1	135	4
BACN10YR4CM		1	250	2
		1	251	2
BACP18BC02A06P		1	115	4
		1	230	2
BACR15BA3AD		1	25	2
		1	45	8
		1	65	8
BACW10BP14ACU		1	160	8
BACW10BP14DP		1	165	8
BACW10BP4ACU		1	240	2
		1	241	2
BACW10BP4APU		1	245	2
		1	246	2
BACW10BP4CD		1	125	4
BACW10BP4DP		1	130	4
BMN5024CWD314		1	170	8
BRFR220C3-5D		1	30	1
BRF100A3		1	50	4
		1	70	4
CR603014		1	170	8
F2000-3		1	50	4
		1	70	4
F51747-3-5CD		1	30	1
HST10AG6-12		1	10A	6

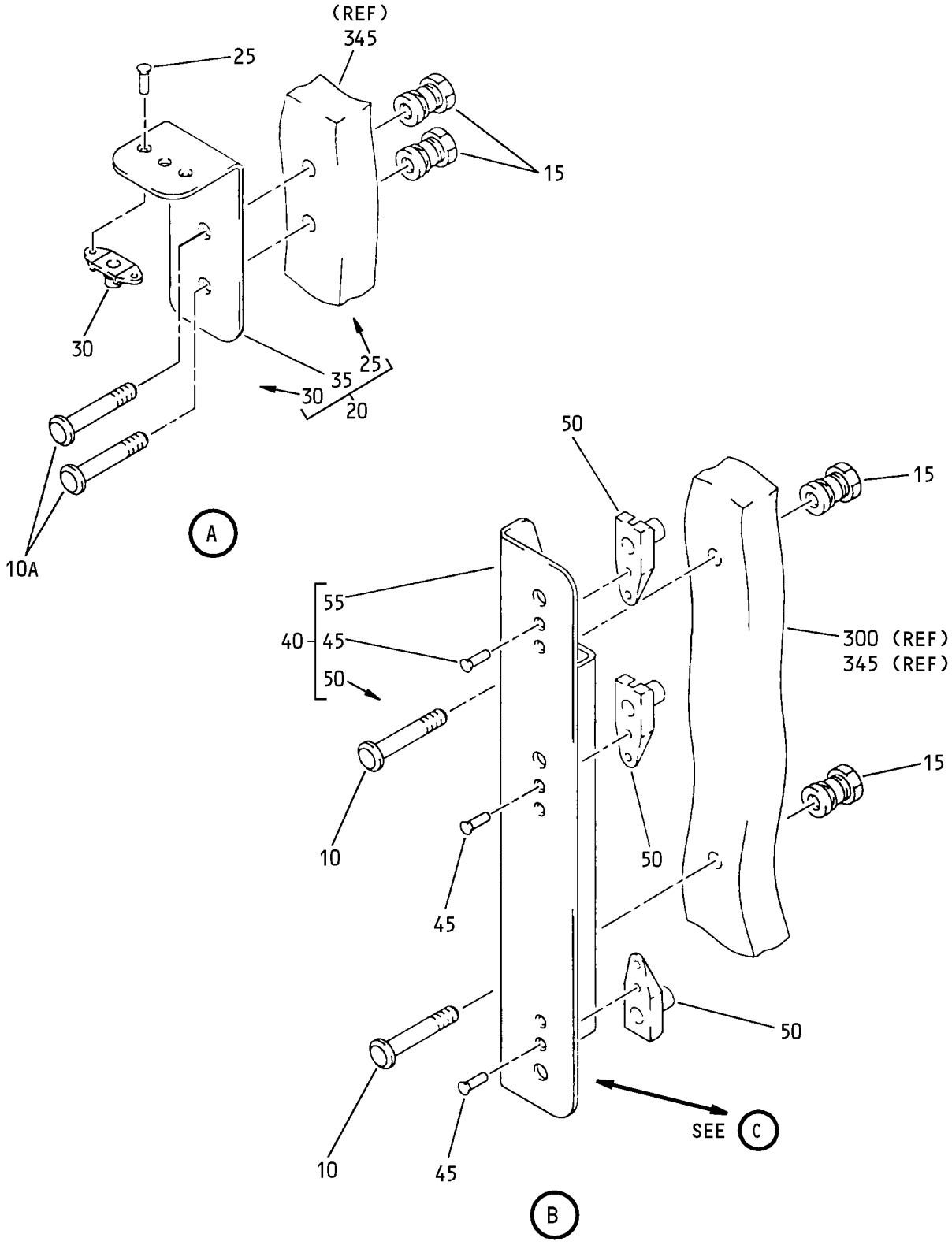
PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
HST79-10		1	330	5
HST79-6		1	15	6
HST79CY10		1	330	5
HST79CY6		1	15	6
H51560-14		1	170	8
H52732-4CD		1	135	4
H52732-4CM		1	250	2
		1	251	2
MS15001-1		1	85	1
MS15004-1		1	265	2
NS103185-02		1	50	4
		1	70	4
NS202493-02-5		1	30	1
PLH54CD		1	135	4
PLH54CM		1	250	2
		1	251	2
RMF9207-3		1	50	4
		1	70	4
SL7108C14		1	170	8
T8114S1032S		1	50	4
		1	70	4
VCU0005D14		1	170	8
VN151A1-02		1	50	4
		1	70	4
WC331K10-40		1	325	5
WW12		1	110	2
102A9213-5-3		1	30	1
102CH9031-14		1	170	8
102LH903114		1	170	8
112T1600-11		1	1C	RF
112T1600-12		1	5B	RF
112T1600-15		1	1D	RF
112T1600-16		1	5C	RF
112T1600-19		1	1E	RF
112T1600-20		1	5D	RF
112T1600-7		1	1B	RF
112T1600-8		1	5A	RF
112T1601-1		1	345	1
112T1601-2		1	350	1
112T1601-3		1	360	1
112T1601-4		1	365	1
112T1601-5		1	345A	1
112T1601-6		1	350A	1
112T1601-7		1	360A	1
112T1601-8		1	365A	1
112T1602-1		1	300	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
112T1602-2		1	305	1
112T1602-3		1	315	1
112T1602-4		1	320	1
112T1605-1		1	310	1
		1	355	1
112T1606-1		1	205	1
112T1607-1		1	335	1
112T1607-2		1	340	1
112T1609-1		1	100	2
112T1609-2		1	105	2
112T1610-1		1	290	1
112T1610-2		1	295	1
112T1611-1		1	255	2
112T1611-2		1	140	2
112T1612-1		1	260	1
112T1612-3		1	285	1
112T1612-5		1	261	1
112T1612-7		1	286	1
112T1614-1		1	275	2
112T1614-2		1	280	2
113T1648-5		1	20	1
113T1648-6		1	35	1
113T1992-11		1	210	1
113T1992-13		1	225	1
161W7010-1		1	90	1
		1	270	2
272T1454-1		1	60	2
272T1454-2		1	75	2
272T1455-8		1	40A	2
272T1455-9		1	55A	2
67832CD14		1	170	8
67832CD1414		1	170	8



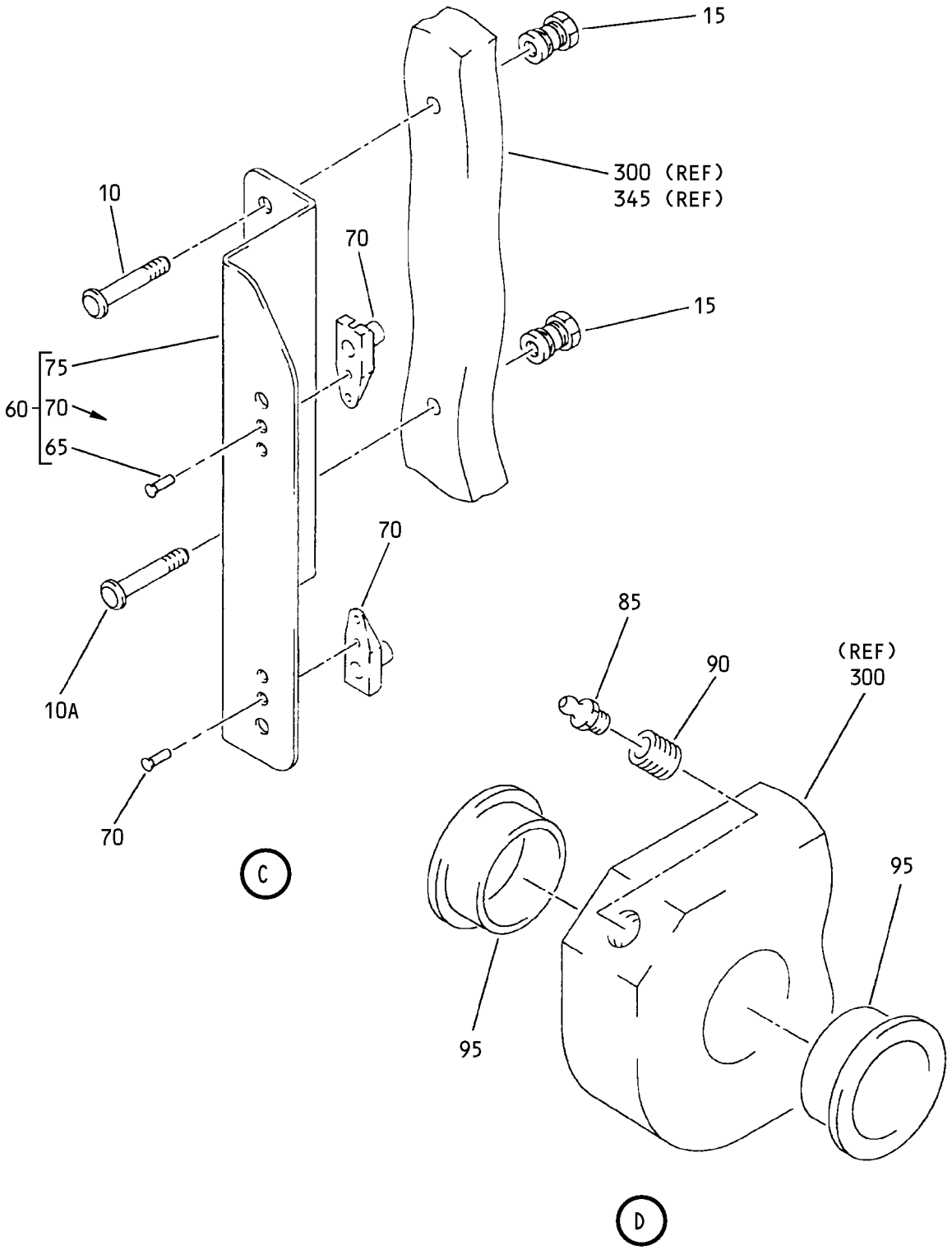
Forward Trunnion Support Machined Assembly
Figure 1 (Sheet 1)

K25102



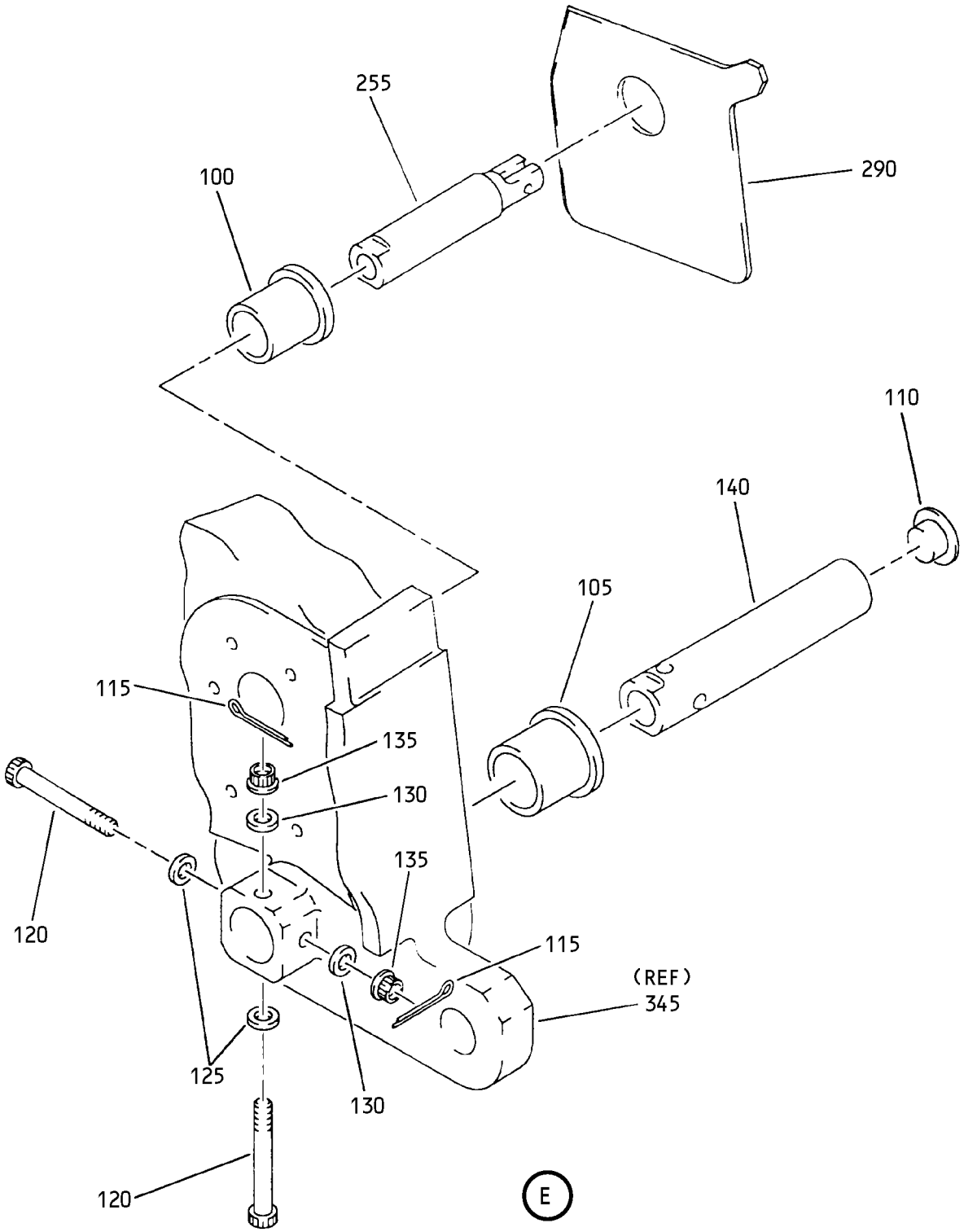
Forward Trunnion Support Machined Assembly
Figure 1 (Sheet 2)

K25112



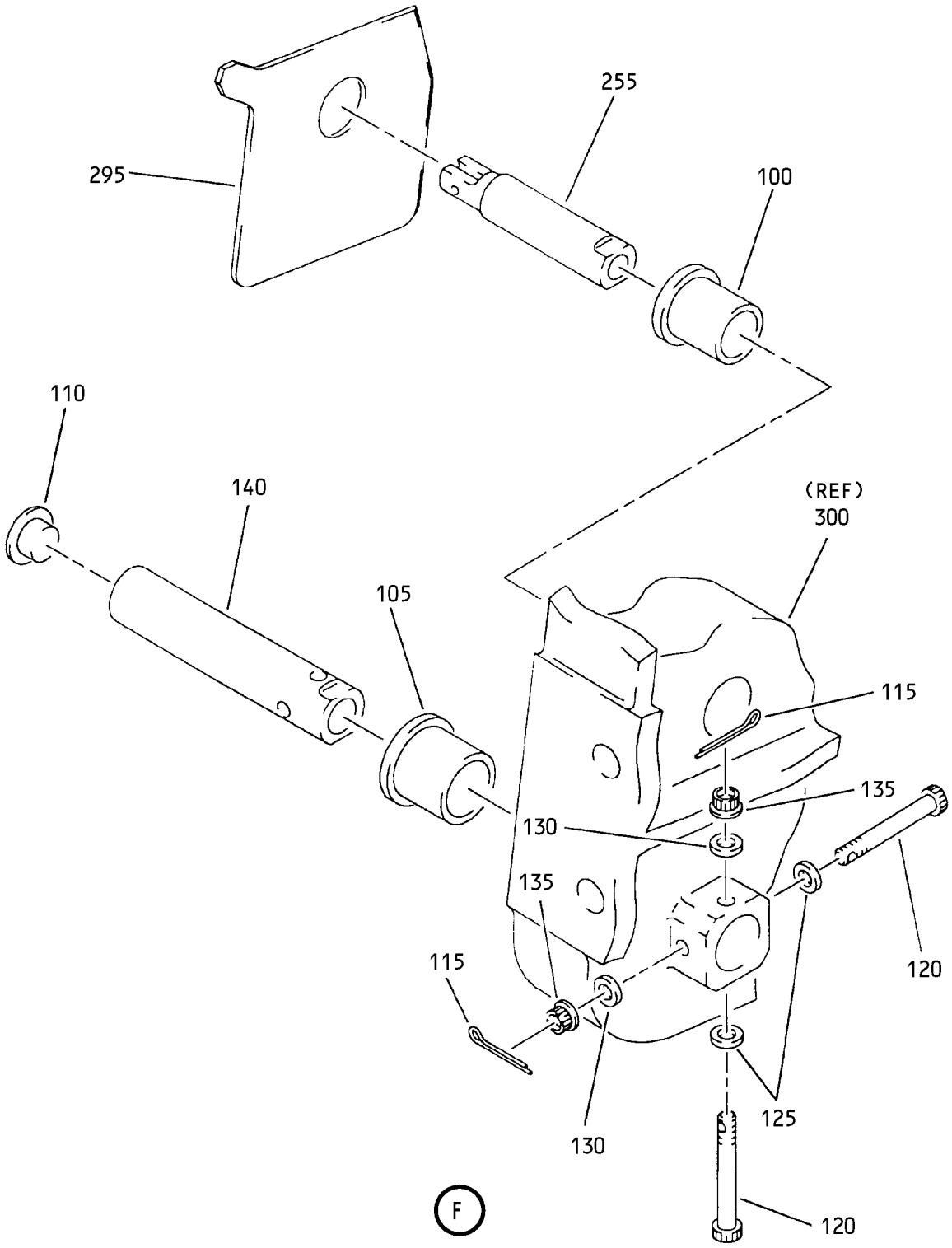
Forward Trunnion Support Machined Assembly
Figure 1 (Sheet 3)

K25165



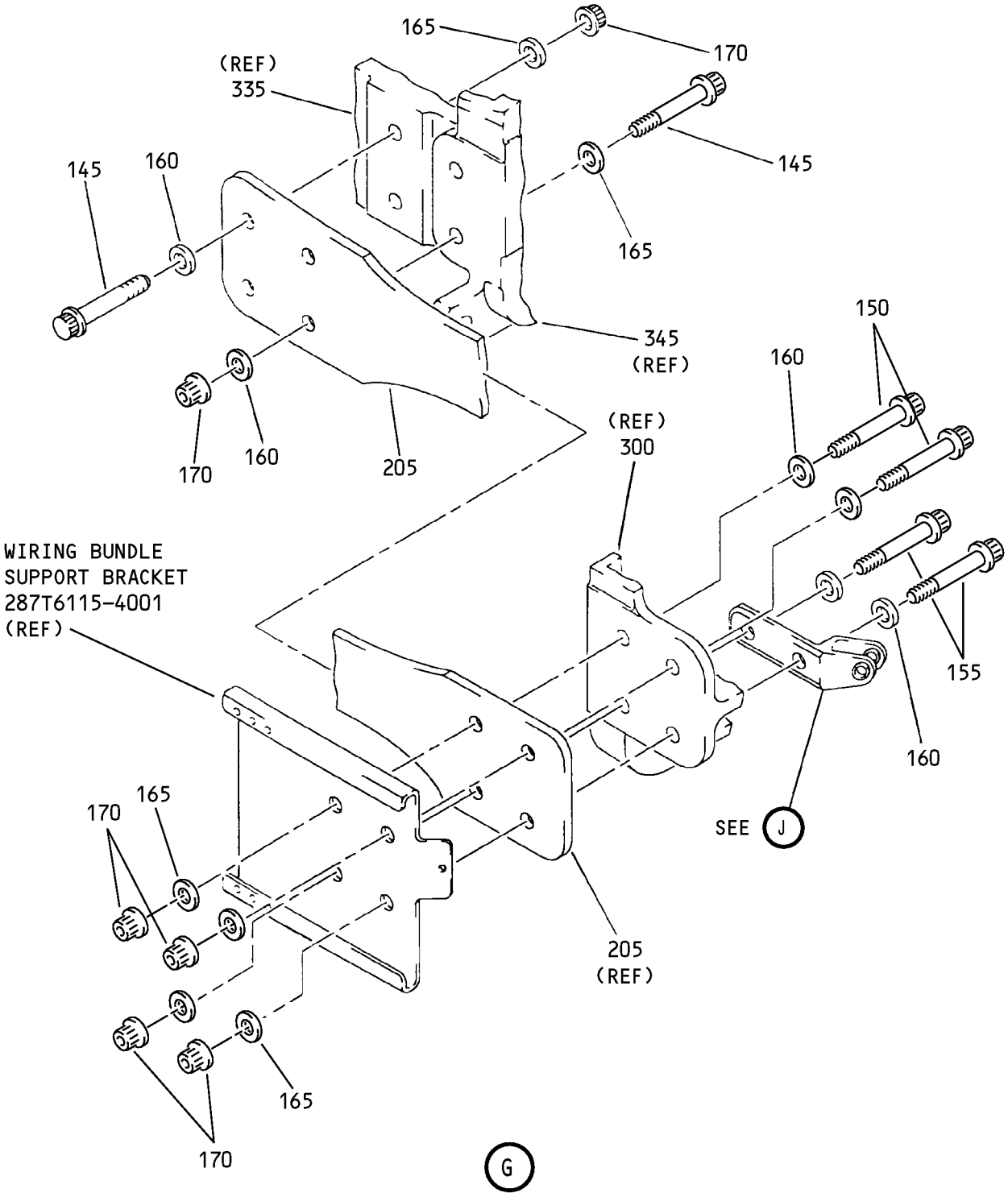
Forward Trunnion Support Machined Assembly
Figure 1 (Sheet 4)

K25134



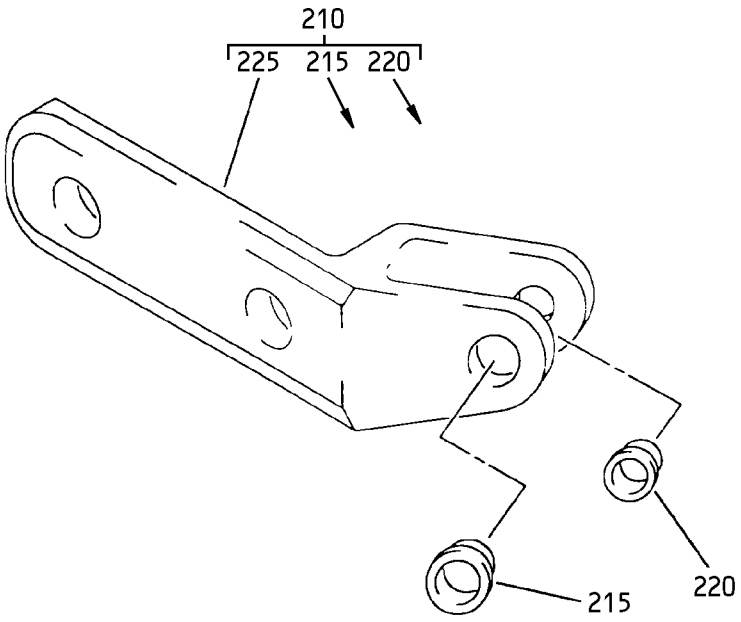
Forward Trunnion Support Machined Assembly
Figure 1 (Sheet 5)

K25122



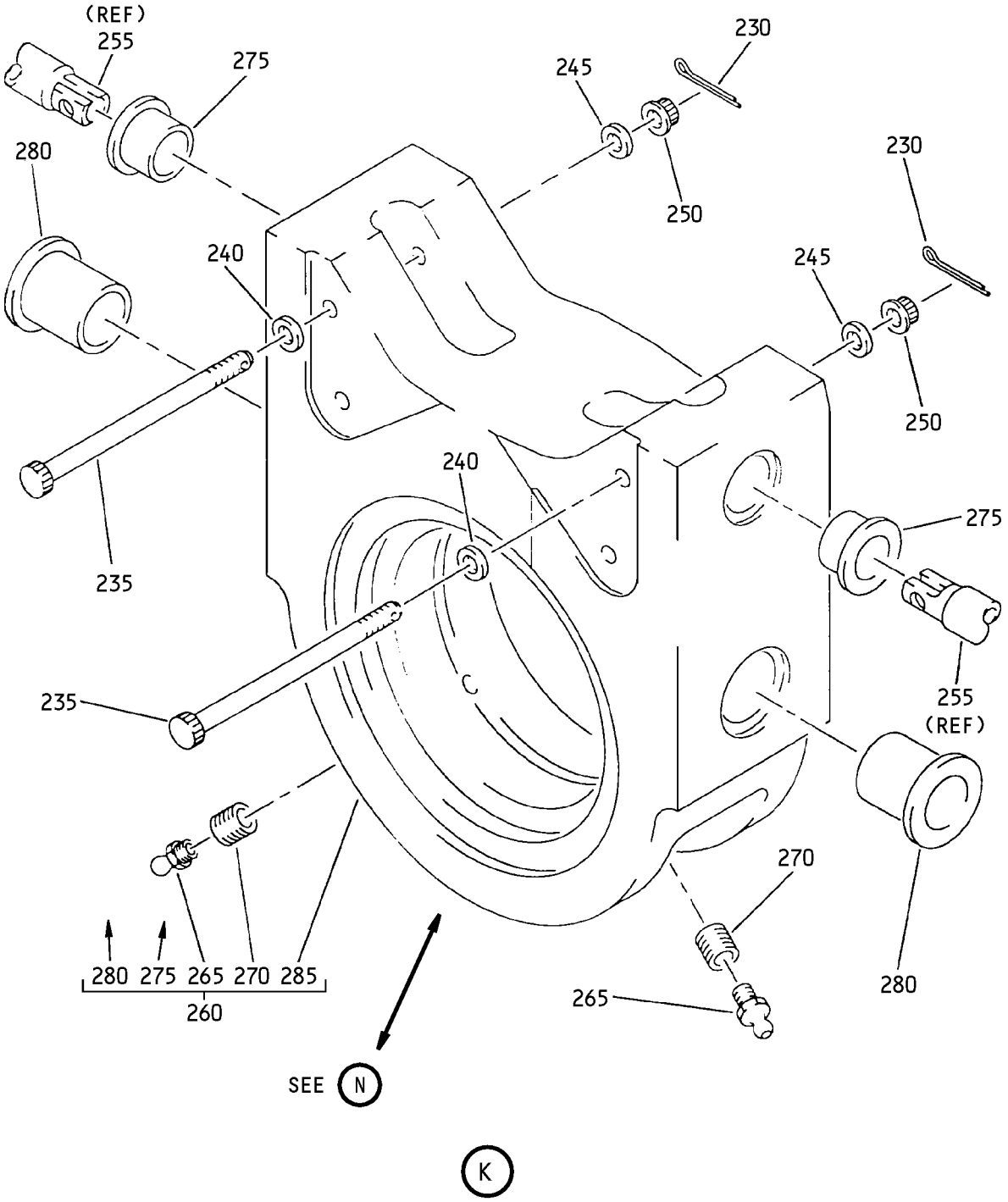
Forward Trunnion Support Machined Assembly
Figure 1 (Sheet 6)

K25167



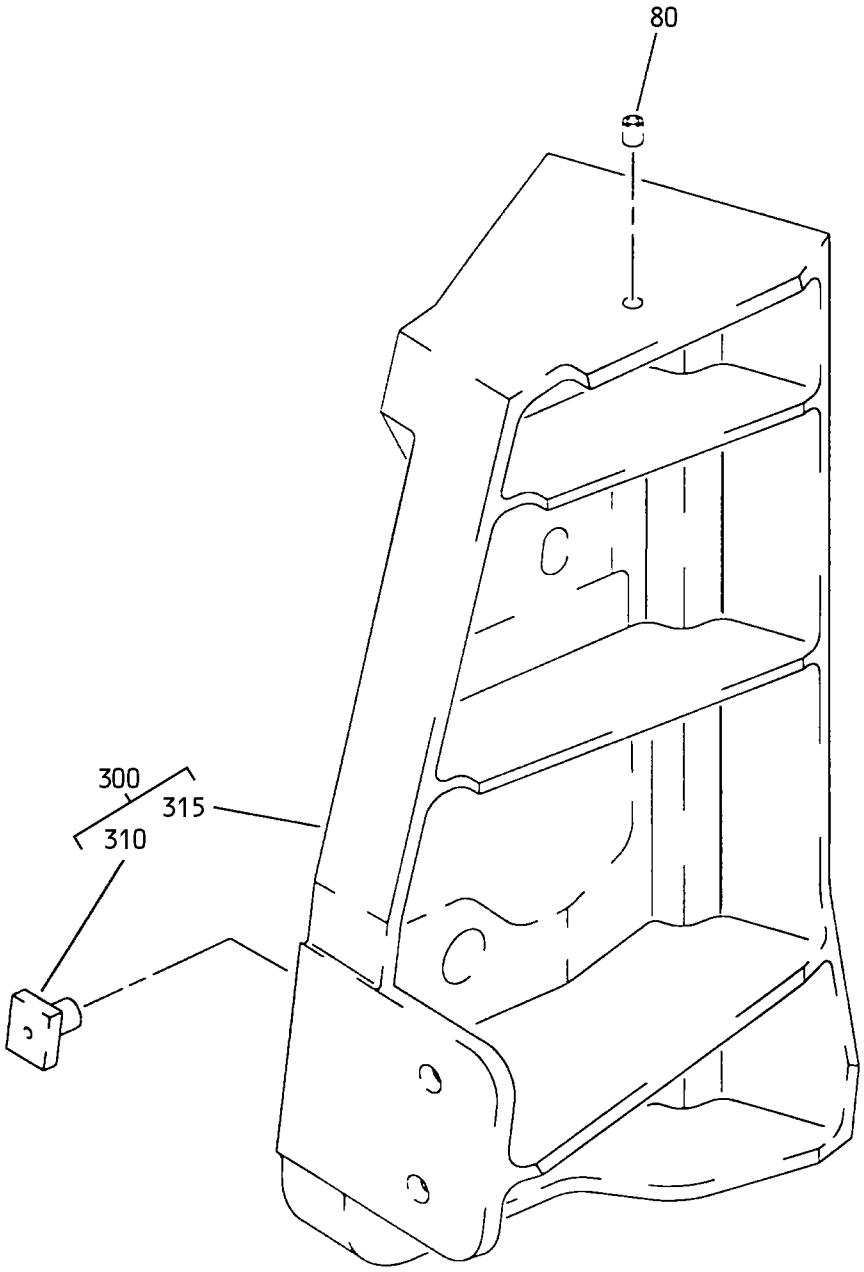
Forward Trunnion Support Machined Assembly
Figure 1 (Sheet 7)

K25169



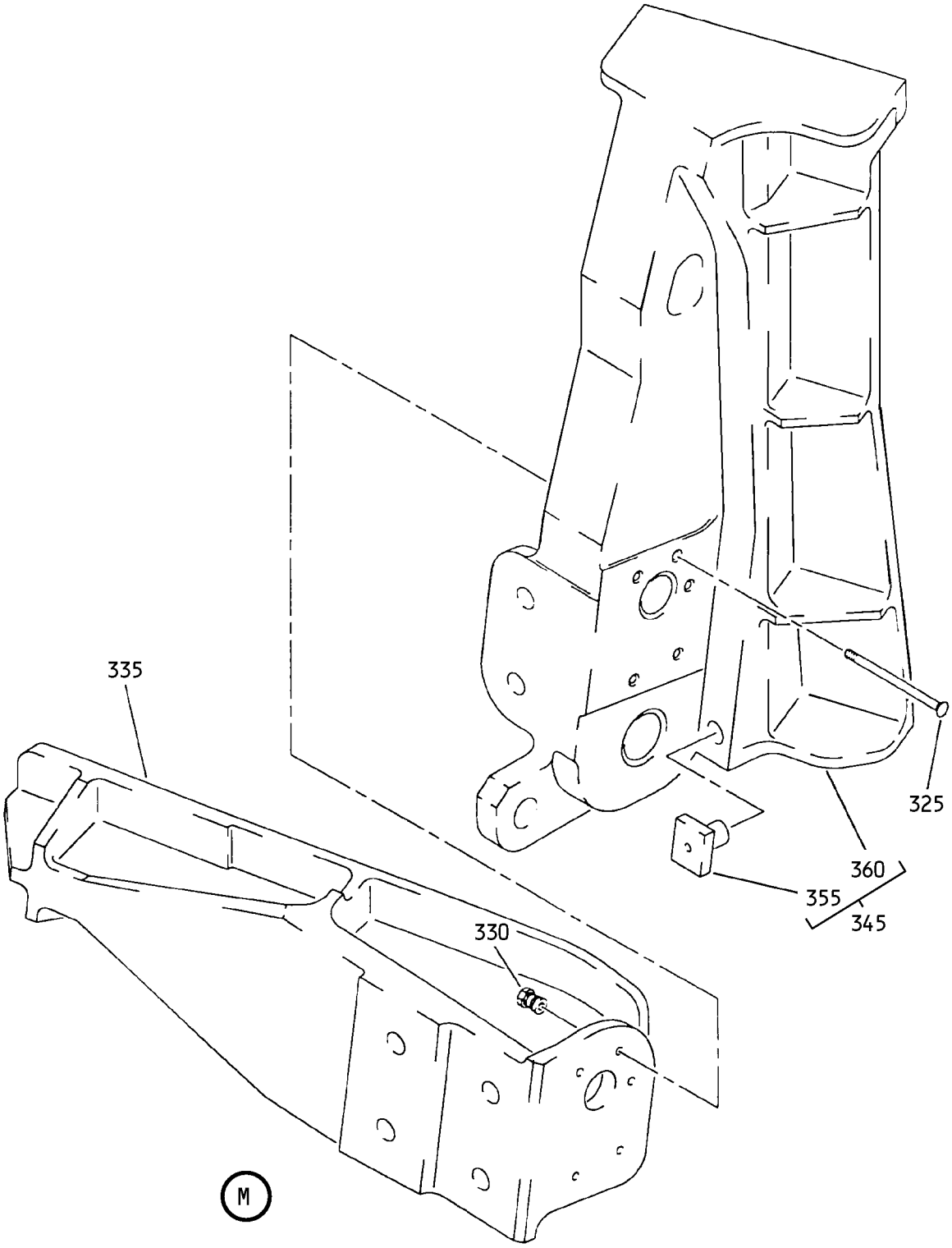
Forward Trunnion Support Machined Assembly
Figure 1 (Sheet 8)

K25172



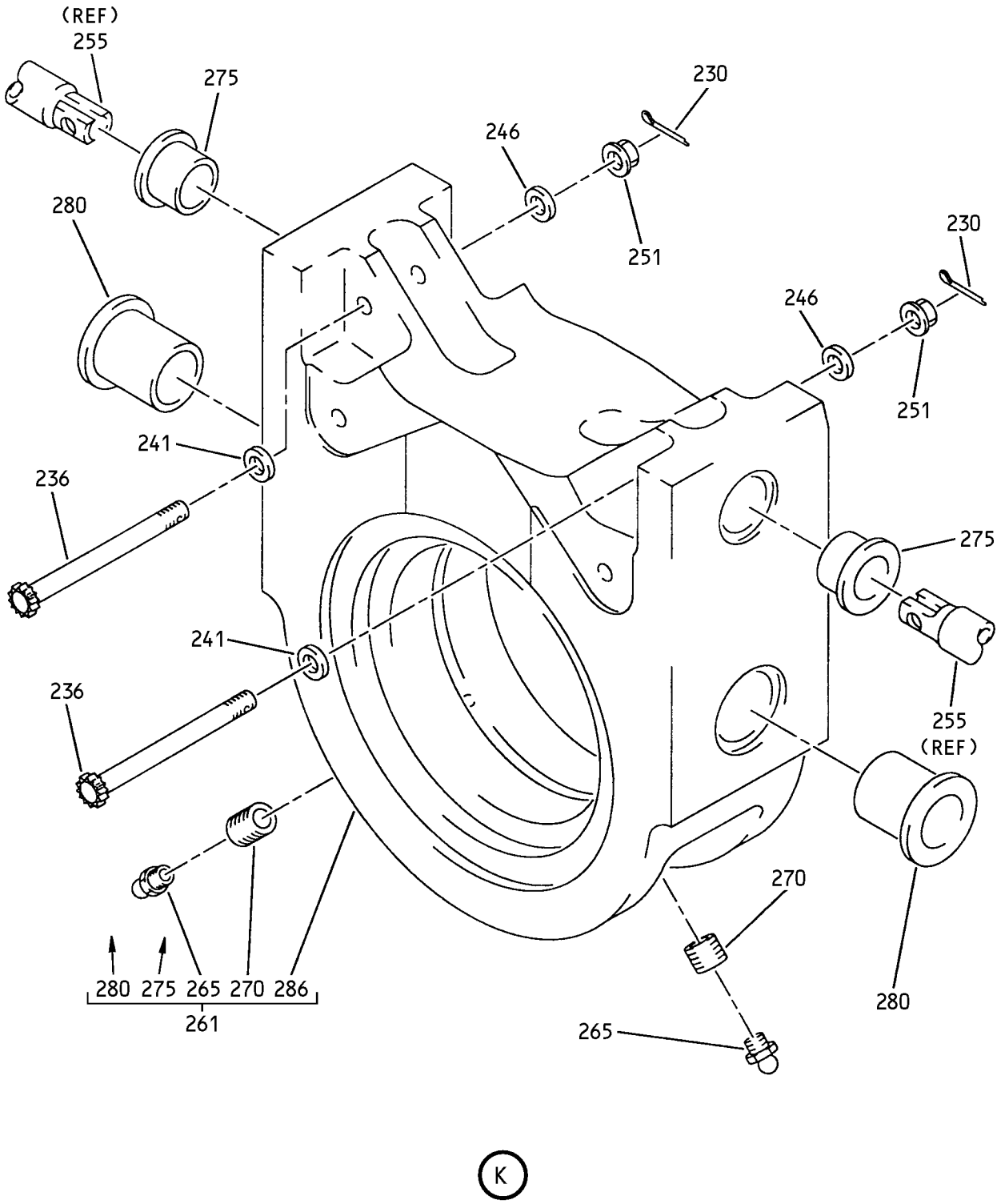
Forward Trunnion Support Machined Assembly
Figure 1 (Sheet 9)

K25234



Forward Trunnion Support Machined Assembly
Figure 1 (Sheet 10)

K25237



Forward Trunnion Support Machined Assembly
Figure 1 (Sheet 11)

M62221

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	-1A	112T1600-3		DELETED		
R	-1B	112T1600-7		MACHINED ASSY-FWD TRUN SPRT	C	RF
R	-1C	112T1600-11		MACHINED ASSY-FWD TRUN SPRT	D	RF
R	-1D	112T1600-15		MACHINED ASSY-FWD TRUN SPRT	E	RF
R	-1E	112T1600-19		MACHINED ASSY-FWD TRUN SPRT	F	RF
	-5	112T1600-4		DELETED		
R	-5A	112T1600-8		MACHINED ASSY-FWD TRUN SPRT	G	RF
R	-5B	112T1600-12		MACHINED ASSY-FWD TRUN SPRT	H	RF
R	-5C	112T1600-16		MACHINED ASSY-FWD TRUN SPRT	J	RF
R	-5D	112T1600-20		MACHINED ASSY-FWD TRUN SPRT	K	RF
	10	HST10AG6-16		DELETED		
R	10A	HST10AG6-12		.BOLT- (V0PTK6) (SPEC BACB30VT6K12) (OPT HST10AG6-12 (V06725)) (OPT HST10AG6-12 (V56878)) (OPT HST10AG6-12 (V73197))		6
	15	HST79CY6		.COLLAR- (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V92215)) (OPT HST79CY6 (V56878)) (OPT HST79CY6 (V5M902))		6
	20	113T1648-5		.BRACKET ASSY-PNL SPRT		1
	25	BACR15BA3AD		..RIVET- (SIZE DETERMINE ON INST)		2
	30	NS202493-02-5		..NUTPLATE- (V80539) (SPEC BACN10KE3B5CD) (OPT F51747-3-5CD (V15653)) (OPT 102A9213-5-3 (V72962)) (OPT BRFR220C3-5D (V52828))		1
	35	113T1648-6		..BRACKET		1
	40	272T1455-1		DELETED		
R	40A	272T1455-8		.BRACKET ASSY-HYDR TUBING SPRT	C-F	2

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
R	45	BACR15BA3AD		..RIVET- (SIZE DETERMINE ON INST)	C-F	4
R	50	BRF100A3		..NUTPLATE- (V52828) (SPEC BACN10KB3F) (OPT NS103185-02 (V80539)) (OPT RMF9207-3 (V72962)) (OPT T8114S1032S (V11815)) (OPT VN151A1-02 (V92215)) (OPT F2000-3 (V15653))	C-F	2
	55	272T1455-2		DELETED		
R	55A	272T1455-9		..BRACKET	C-F	1
	60	272T1454-1		.BRACKET ASSY-HYDR TUBING SPRT	G-K	2
	65	BACR15BA3AD		..RIVET- (SIZE DETERMINE ON INST)	G-K	4
	70	BRF100A3		..NUTPLATE- (V52828) (SPEC BACN10KB3F) (OPT NS103185-02 (V80539)) (OPT RMF9207-3 (V72962)) (OPT T8114S1032S (V11815)) (OPT VN151A1-02 (V92215)) (OPT F2000-3 (V15653))	G-K	2
	75	272T1454-2		..BRACKET	G-K	1
	80	BACB28Y3M055		.BUSHING		1
	85	MS15001-1		.FITTING		1
	90	161W7010-1		.INSERT		1
	95	BACB28AT16B040C		.BUSHING		2
	100	112T1609-1		.BUSHING		2
	105	112T1609-2		.BUSHING		2
	110	WW12		.INSERT-PLASTIC (V95760)		2
	115	BACP18BC02A06P		.PIN-COTTER		4
	120	BACB30UU4K44DH		.BOLT		4

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
125	BACW10BP4CD		.WASHER		4
130	BACW10BP4DP		.WASHER		4
135	H52732-4CD		.NUT-		4
			(V15653)		
			(SPEC BACN10YR4CD)		
			(OPT PLH54CD		
			(V62554))		
140	112T1611-2		.PIN-FUSE		2
145	BACB30US14K35		.BOLT		4
150	BACB30US14K24		.BOLT		2
155	BACB30US14K28		.BOLT		2
160	BACW10BP14ACU		.WASHER		8
165	BACW10BP14DP		.WASHER		8
170	H51560-14		.NUT-		8
			(V15653)		
			(SPEC BACN10HR14CD)		
			(OPT 102CH9031-14		
			(V72962))		
			(OPT 67832CD1414		
			(V56878))		
			(OPT BMN5024CWD314		
			(V97928))		
			(OPT CR603014		
			(V62554))		
			(OPT SL7108C14		
			(V11815))		
			(OPT VCU0005D14		
			(V06710))		
			(OPT 102LH903114		
			(V72962))		
			(OPT 67832CD14		
			(V56878))		
175	287T6115-4001		DELETED		
-180	287T6115-4002		DELETED		
185	BACR15BA3AD		DELETED		
190	BRFM20C3D		DELETED		
190A	BRFM20C3M		DELETED		
195	287T6115-4003		DELETED		
-200	287T6115-4004		DELETED		
205	112T1606-1		.STRAP-TNSN		1
210	113T1992-11		.FITTING ASSY-PNL SPRT		1
215	BACB28AT06B012C		..BUSHING		1
220	BACB28AP04P012		..BUSHING		1
225	113T1992-13		..FITTING		1
230	BACP18BC02A06P		.PIN-COTTER	C,G	2

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	235	BACB30UU4K81DH		.BOLT	C,G	2
R	236	BACB30UU4K44DH		.BOLT	D-F, H-K	2
	240	BACW10BP4ACU		.WASHER	C,G	2
R	241	BACW10BP4ACU		.WASHER	D-F, H-K	2
	245	BACW10BP4APU		.WASHER	C,G	2
R	246	BACW10BP4APU		.WASHER	D-F, H-K	2
	250	H52732-4CM		.NUT- (V15653) (SPEC BACN10YR4CM) (OPT PLH54CM (V62554))	C,G	2
R	251	H52732-4CM		.NUT- (V15653) (SPEC BACN10YR4CM) (OPT PLH54CM (V62554))	D-F, H-K	2
	255	112T1611-1		.PIN-FUSE		2
	260	112T1612-1		.HOUSING ASSY	C,G	1
R	261	112T1612-5		.HOUSING ASSY	D-F, H-K	1
	265	MS15004-1		..FITTING		2
	270	161W7010-1		..INSERT		2
	275	112T1614-1		..BUSHING		2
	280	112T1614-2		..BUSHING		2
	285	112T1612-3		..HOUSING	C,G	1
R	286	112T1612-7		..HOUSING	D-F, H-K	1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	290	112T1610-1		.PLATE-BRG		1
	295	112T1610-2		.PLATE-BRG		1
	300	112T1602-1		.FITTING ASSY-INBD VERT.	C-F	1
	-305	112T1602-2		.FITTING ASSY-INBD VERT.	G-K	1
	310	112T1605-1		..BUTTON-BRG		1
	315	112T1602-3		..FITTING	C-F	1
	-320	112T1602-4		..FITTING	G-K	1
	325	WC331K10-40		.BOLT- (V60516) (SPEC BACB30YP10K40)		5
	330	HST79CY10		.COLLAR- (V73197) (SPEC BACC30BL10) (OPT HST79-10 (V92215)) (OPT HST79CY10 (V56878)) (OPT HST79CY10 (V5M902))		5
	335	112T1607-1		.FITTING-SIDE LOAD	C-F	1
	-340	112T1607-2		.FITTING-SIDE LOAD	G-K	1
	345	112T1601-1		.FITTING ASSY-OUTBD VERT.	C-E	1
R	-345A	112T1601-5		.FITTING ASSY-OUTBD VERT.	F	1
	-350	112T1601-2		.FITTING ASSY-OUTBD VERT.	G-J	1
R	-350A	112T1601-6		.FITTING ASSY-OUTBD VERT.	K	1
	355	112T1605-1		..BUTTON-BRG		1
	360	112T1601-3		..FITTING	C-E	1
R	-360A	112T1601-7		..FITTING	F	1
	-365	112T1601-4		..FITTING	G-J	1
R	-365A	112T1601-8		..FITTING	K	1

- Item Not Illustrated