

 **BOEING**  
COMPONENT  
MAINTENANCE MANUAL

TO: ALL HOLDERS OF THE MACHINED ASSEMBLY - MLG BEAM OUTBOARD SUPPORT,  
WING COMPONENT MAINTENANCE MANUAL 57-54-39.

REVISION NO. 2 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.

The revision dated Oct 01/93 should have been Revision 10.

CHAPTER/SECTION

AND PAGE NO.

DESCRIPTION OF CHANGE

TITLE PAGE

Added assemblies 112T1736-15, -16 with mini-cantilever fittings for a better fit.

1

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TITLE PAGE

Added clarifications and updated callouts.

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MACHINED ASSEMBLY  
MLG BEAM OUTBOARD SUPPORT, WING

PART NUMBERS 112T1736-3,-4,-7,-8,-15,-16

COMPONENT MAINTENANCE MANUAL  
WITH  
ILLUSTRATED PARTS LIST

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K26022



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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.\*[1] Not applicable.

.\*[2] Special instructions are not required. Use standard industry practices.

.\*[3] Also use the procedures in SOPM 20-30-03.

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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 &<br>Service Bulletin Record | 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.

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INTRODUCTION

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## | MAIN LANDING GEAR BEAM OUTBOARD SUPPORT MACHINES ASSEMBLY

DESCRIPTION AND OPERATION1. Description and Operation

| A. The main landing gear beam outboard support machined assembly has two plate assemblies, a mini-cantilever fitting, a panel support fitting assembly and a fitting assembly that houses a spherical bearing. The support fitting assembly is attached to the rear spar of the wing and is a pivot mount for the main landing gear beam.

2. Leading Particulars (Approximate)

A. Length -- 30 inches

B. Width -- 20 inches

C. Height -- 20 inches

| D. Weight -- 274 pounds

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CHECK1. 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) Retainer Dog (270)
  - (b) Antirotation Plate (275)
  - (c) Retaining Nut (285)
  - (d) Washer (290, 490, 495)
  - (e) Fitting (295)
  - (f) Fuse Pin (480, 485)
  - (g) Nut (500, 505)
  - (h) Plate (580)

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- (3) Do a penetrant check (SOPM 20-20-02) of these parts:
- (a) Fitting (180)
  - (b) Mini Cantilever Fitting (510)
  - (c) Aft Plate (585)
  - (d) Forward Plate (590)

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REPAIR – GENERAL

1. General

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

<u>PART NUMBER</u>	<u>NAME</u>	<u>REPAIR</u>
---	REFINISH OF OTHER PARTS	1-1
112T1726	FUSE PIN	2-1
112T1736	MLG BEAM OUTBOARD SUPPORT ASSEMBLY	3-1
112T1742	PLATE ASSEMBLY	4-1, 4-2
113T1992	FITTING ASSEMBLY	5-1, 5-2

2. Dimensioning Symbols

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

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REFINISH OF OTHER PARTS – REPAIR 1-11. General

- A. This procedure has the data 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) C00032 Enamel -- BMS 10-60 (SOPM 20-60-02)
- (2) C00259 Primer -- BMS 10-11, Type 1 (SOPM 20-60-02)

## C. References

- (1) SOPM 20-30-02, Stripping of Protective Finishes
- (2) SOPM 20-30-03, General Cleaning Procedures
- (3) SOPM 20-41-01, Decoding Table for Boeing Finish Codes
- (4) SOPM 20-41-02, Application of Chemical and Solvent Resistant Finishes
- (5) SOPM 20-42-05, Bright Cadmium Plating
- (6) SOPM 20-60-02, Finishing Materials

## D. Procedure

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IPL FIG. & ITEM	MATERIAL	FINISH
<u>IPL Fig. 1</u>		
Retainer Dog (270)	15-5PH CRES 150-170 ksi	Passivate (F-17.25, which replaces F17-09).
Antirotation Plate (275)	15-5PH CRES 150-170 ksi	Passivate (F-17.25, which replaces F-17.09).
Retaining Nut (285)	15-5PH CRES 150-170 ksi	Passivate (F-17.25).
Washer (290)	301 CRES AMS 5901	Passivate (F-17.25).
Washer (490, 495)	15-5PH CRES	Passivate (F-17.25).
Nuts (500, 505)	15-5PH CRES 125-145 ksi	Passivate (F-17.25). Apply BMS 3-8 solid film lubricant (F-19.10) to threads.
Plate (580)	15-5PH CRES 180-200 ksi	Cadmium plate and apply BMS 10-11, Type 1 primer (F-16.01). Apply BMS 10-60 enamel (F-14.9813, which replaces SRF-14.9813).

Refinish Details  
Table 601

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FUSE PIN - REPAIR 2-1

112T1726-1, -2

1. General

- A. This repair gives the data to repair and refinish the fuse pin (480, 485).
- 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: 15-5PH CRES  
140-160 ksi
- (2) Shot Peen: Intensity 0.016A2  
Coverage 2.0

2. Pin Repair

## A. References

- (1) SOPM 20-10-03, Shot Peening
- (2) SOPM 20-10-04, Grinding of Chrome Plated Parts
- (3) SOPM 20-20-01, Magnetic Particle Inspection
- (4) SOPM 20-30-02, Stripping of Protective Finishes
- (5) SOPM 20-30-03, General Cleaning Procedures
- (6) SOPM 20-41-01, Decoding Table for Boeing Finish Codes
- (7) SOPM 20-42-03, Hard Chrome Plating

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| B. Procedure (Fig. 601)

- | (1) Repair is only replacement of the original finish. Do not machine into the base metal.
- | (2) Do a magnetic particle check (SOPM 20-20-01), Class A critical.
- | (3) Shot peen, chrome plate and grind to design dimensions and finish.
- | (4) Wipe the chrome plating with primer (F-19.45).

3. Pin Refinish

A. Consumable Materials

- (1) C00259 Primer -- BMS 10-11, Type 1 (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 20-50-10, Application of Stencils, Insignia, Silk Screen, Part Numbering and Identification Markings
- (5) SOPM 20-60-02, Finishing Materials

C. Procedure (Fig. 601)

- | (1) Chrome plate as shown.
- | (2) Passivate (F-17.25) other surfaces.

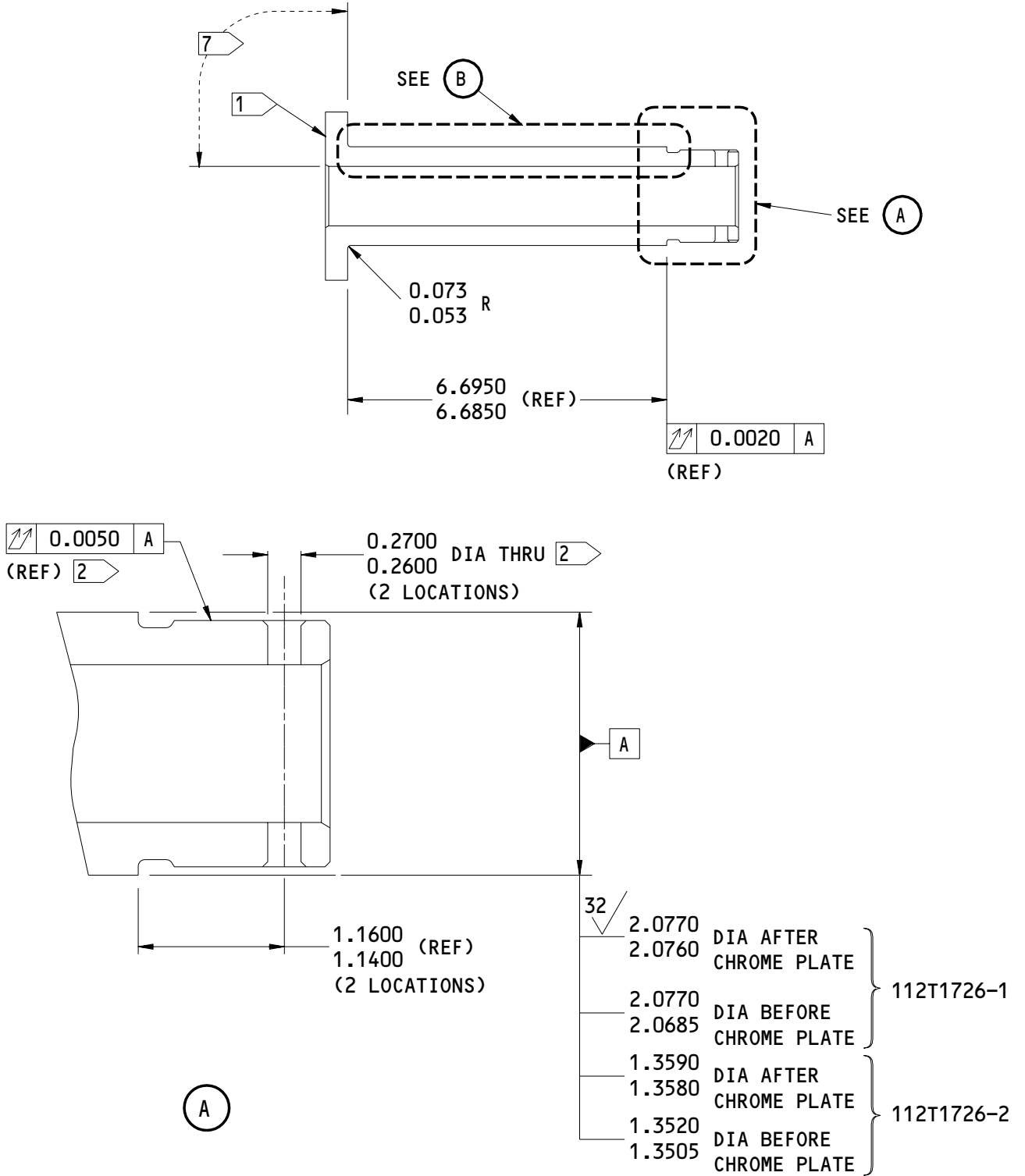
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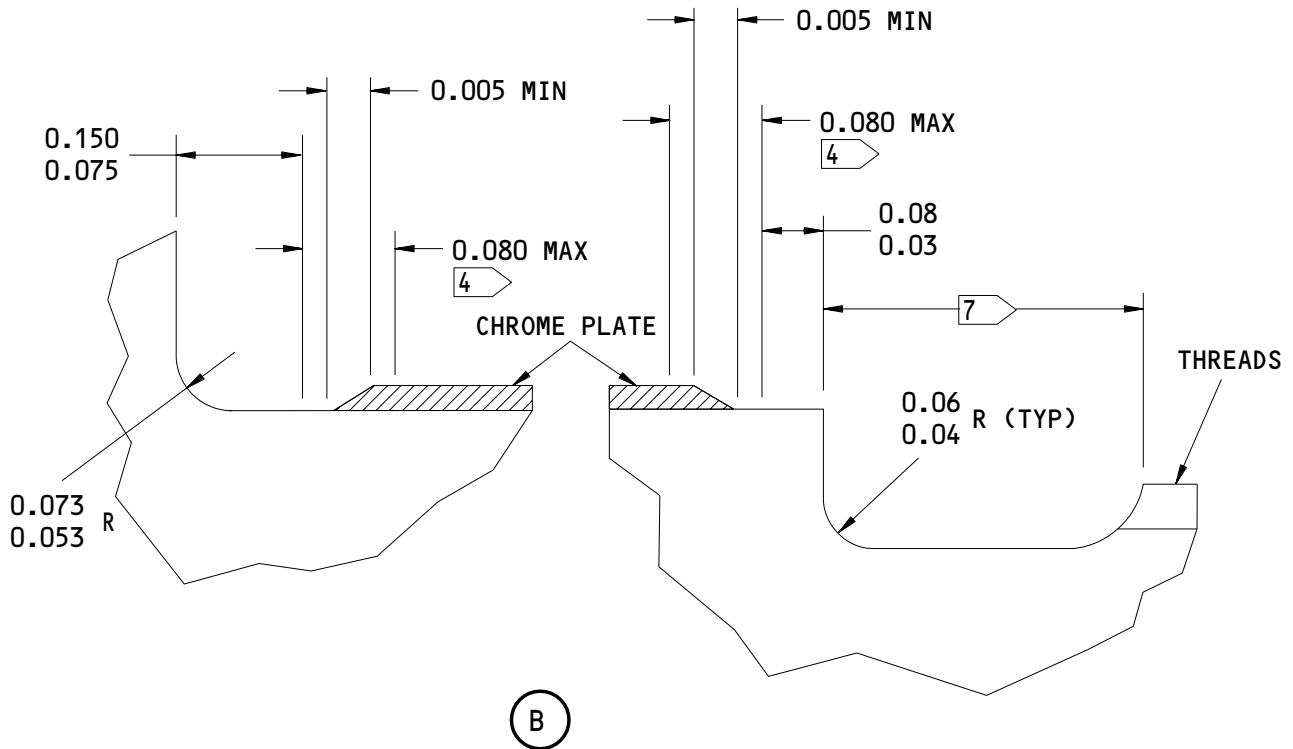


112T1726-1,-2  
 Fuse Pin Refinish  
 Figure 601 (Sheet 1)

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- 1 PART NUMBER AND SERIAL NUMBER LOCATED HERE
- 2 NO SHOT PEEN
- 3 SHOT PEEN
- 4 CHROME PLATE RUNOUT
- 5 CHROME PLATE (F-15.34) 0.003 MINIMUM THICKNESS
- 6 PRIMER (F-19.45)
- 7 SHOT PEEN OVERSPRAY ALLOWED

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

112T1726-1,-2  
 Fuse Pin Refinish  
 Figure 601 (Sheet 2)

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REPAIR 2-1

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MLG BEAM OUTBOARD SUPPORT ASSEMBLY – REPAIR 3-1

112T1736-3, -4, -7, -8, -15, -16

**1. General**

- A. This repair gives the data to replace the bushings (10, 15, 20, 25, 30, 35) in the MLG beam outboard support assembly.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices identified in the repairs.
- C. Refer to IPL Fig. 1 for item numbers.

**2. Bushing Replacement****A. Consumable Materials**

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

**B. References**

- (1) SOPM 20-41-01, Decoding Table for Boeing Finish Codes
- (2) SOPM 20-50-03, Bearing and Bushing Replacement
- (3) SOPM 20-60-04, Miscellaneous Materials

**C. Procedure (Fig. 601)**

- (1) Remove the old bushings (10, 15, 20, 25, 30, 35) from the MLG beam outboard support assembly.
- (2) If you find defects on the hole surfaces, refer to par. 3 for repair instructions.
- (3) Install replacement bushings (10, 15, 20, 25, 30, 35) into the MLG beam outboard support assembly by the shrink-fit method, with BMS 5-95 sealant (SOPM 20-50-03).
- (4) Machine the bushings (10, 15, 20, 25, 30, 35) to design dimensions and finish.

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| (5) Fillet seal around the bushing flanges with BMS 5-95 sealant.

| 3. Holes for Bushings

A. Consumable Materials

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

B. References

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

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

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

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

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

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

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

| C. Procedure (Fig. 601)

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

| (2) Do a penetrant check (SOPM 20-20-02).

| (3) Shot peen the machined area (SOPM 20-10-03).

| (4) Chemical treat and apply primer.

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- (5) Make oversize outer bushings (Fig. 602 and on) as necessary to adjust for the material removed.
- (6) Install the oversize outer bushings and standard inner bushings per par. 2 above.

#### 4. Refinish

##### A. Consumable Materials

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

##### B. References

- (1) SOPM 20-30-02, Stripping of Protective Finishes
- (2) SOPM 20-41-01, Decoding Table for Boeing Finish Codes
- (3) SOPM 20-41-02, Application of Chemical and Solvent Resistant Finishes
- (4) SOPM 20-43-01, Chromic Acid Anodize
- (5) SOPM 20-43-03, Chemical Conversion Coatings for Aluminum
- (6) SOPM 20-60-02, Finishing Materials

##### C. Procedure

- (1) Touch up bare fastener heads and scratched or damaged primer (F-14.9961).
- (2) Apply BMS 10-60 enamel (F-14.9813, which replaces SRF-14.9813) but not on bushing inner diameters. Some surfaces could already have the enamel.

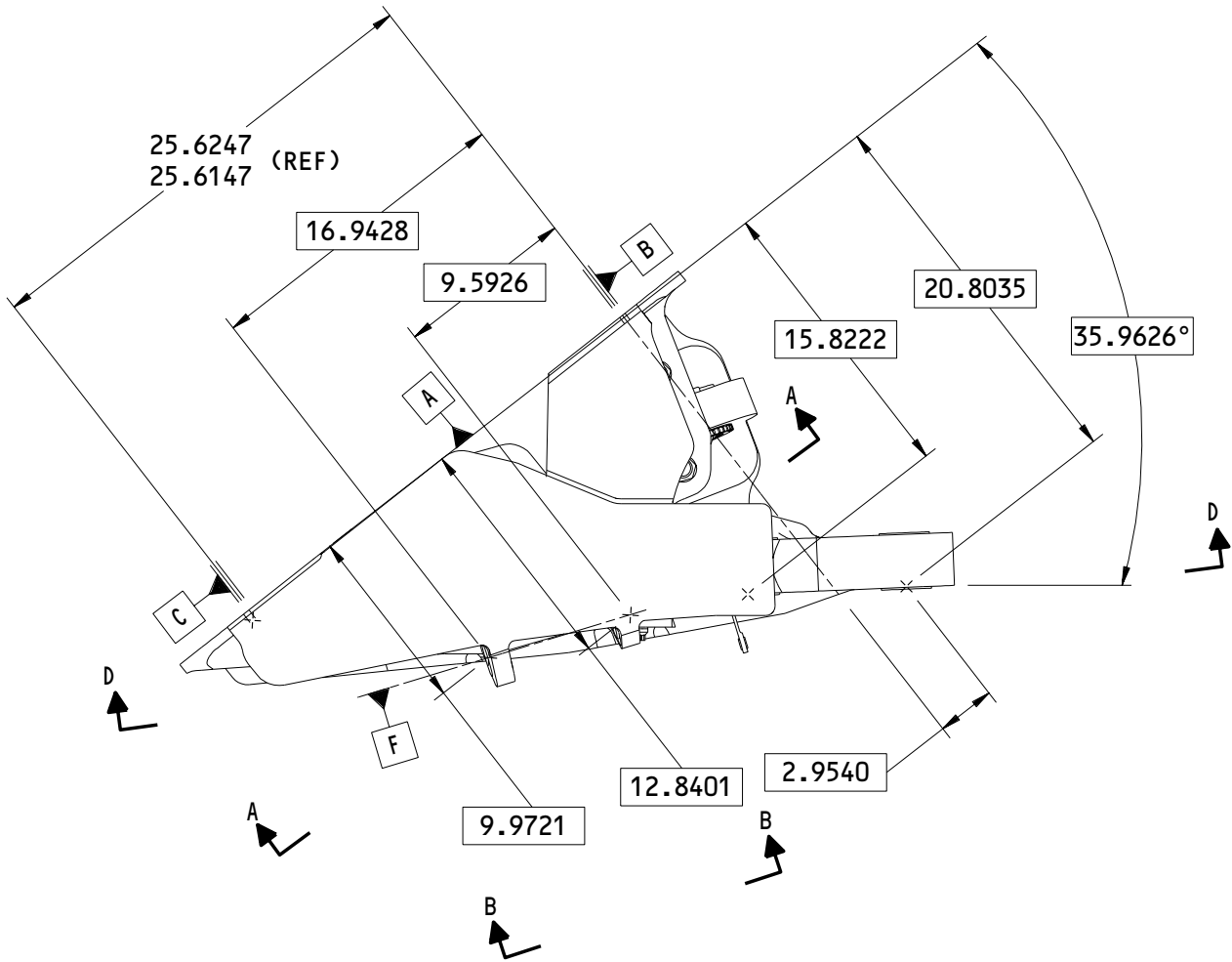
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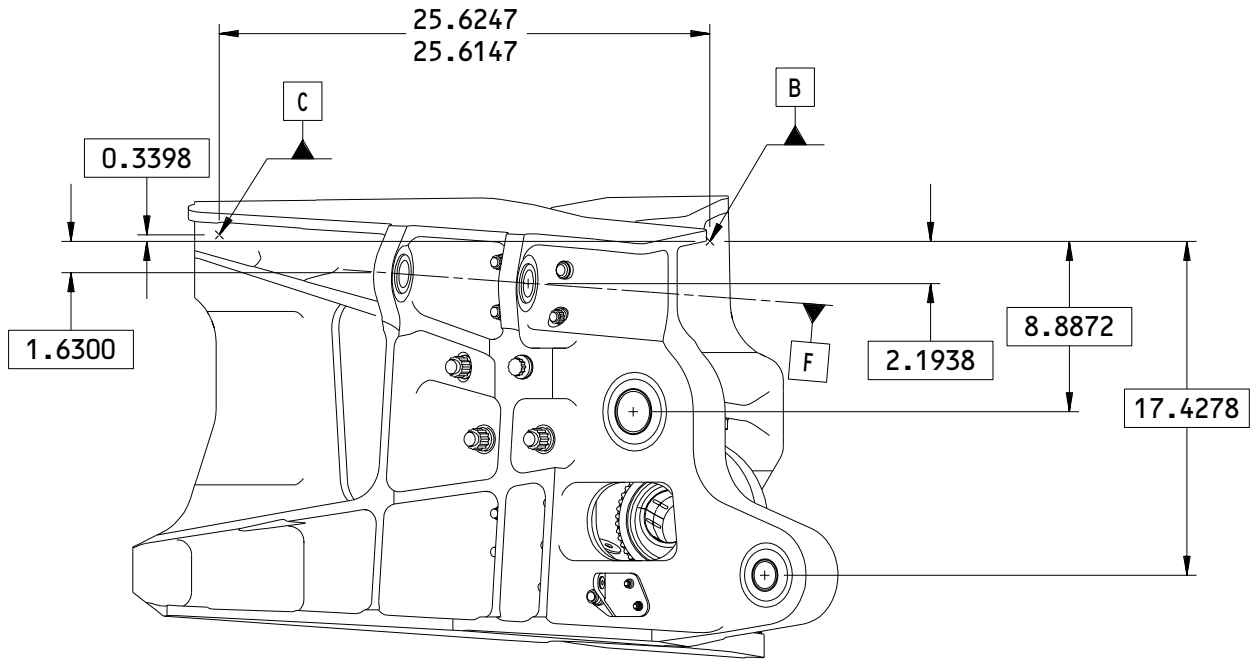


112T1736-3,-4,-7,-8,-15,-16  
MLG Beam Outboard Support Assembly Bushing Replacement  
Figure 601 (Sheet 1)

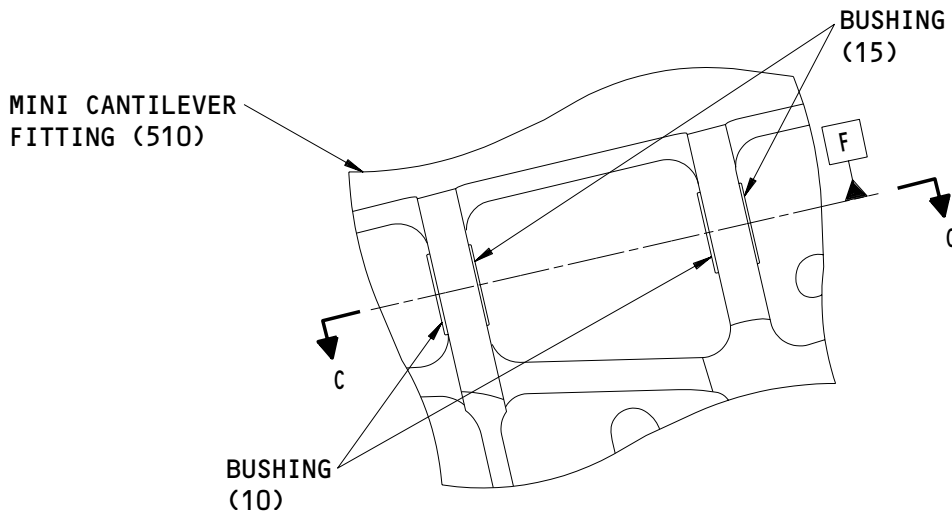
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A-A



B-B

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MLG Beam Outboard Support Assembly Bushing Replacement  
Figure 601 (Sheet 2)

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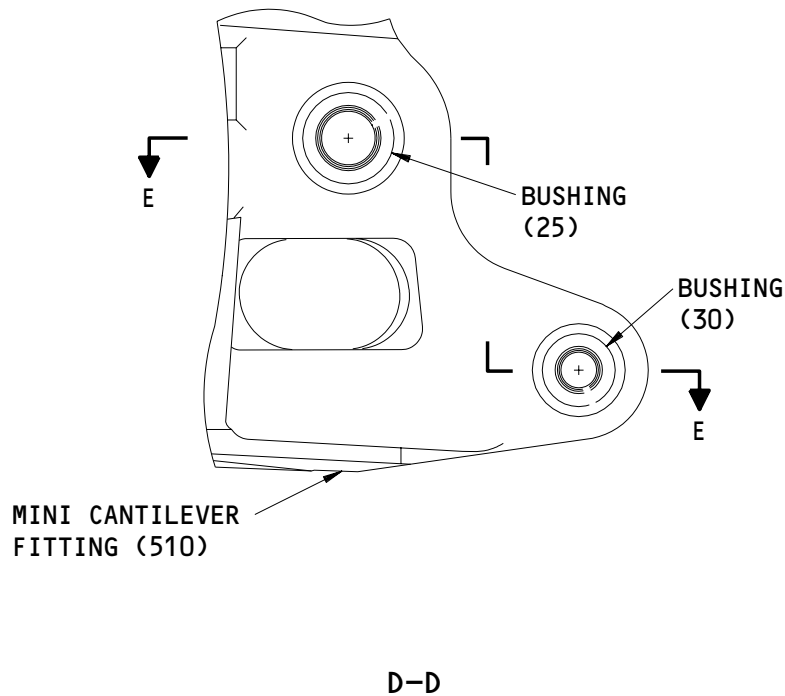
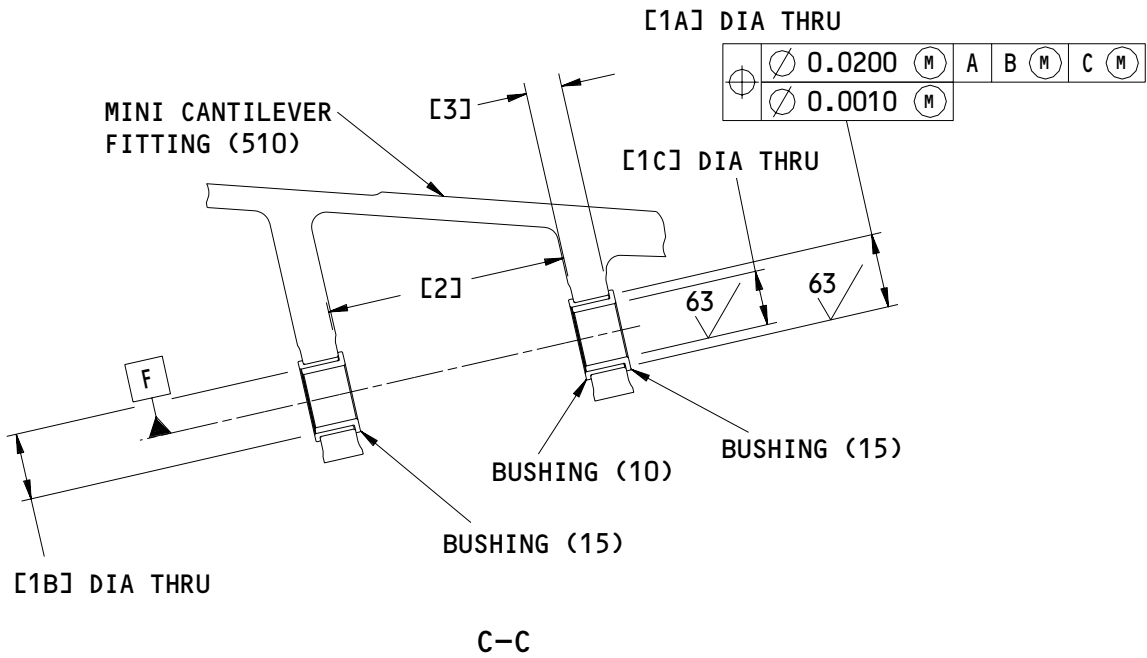
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 MLG Beam Outboard Support Assembly Bushing Replacement  
 Figure 601 (Sheet 3)

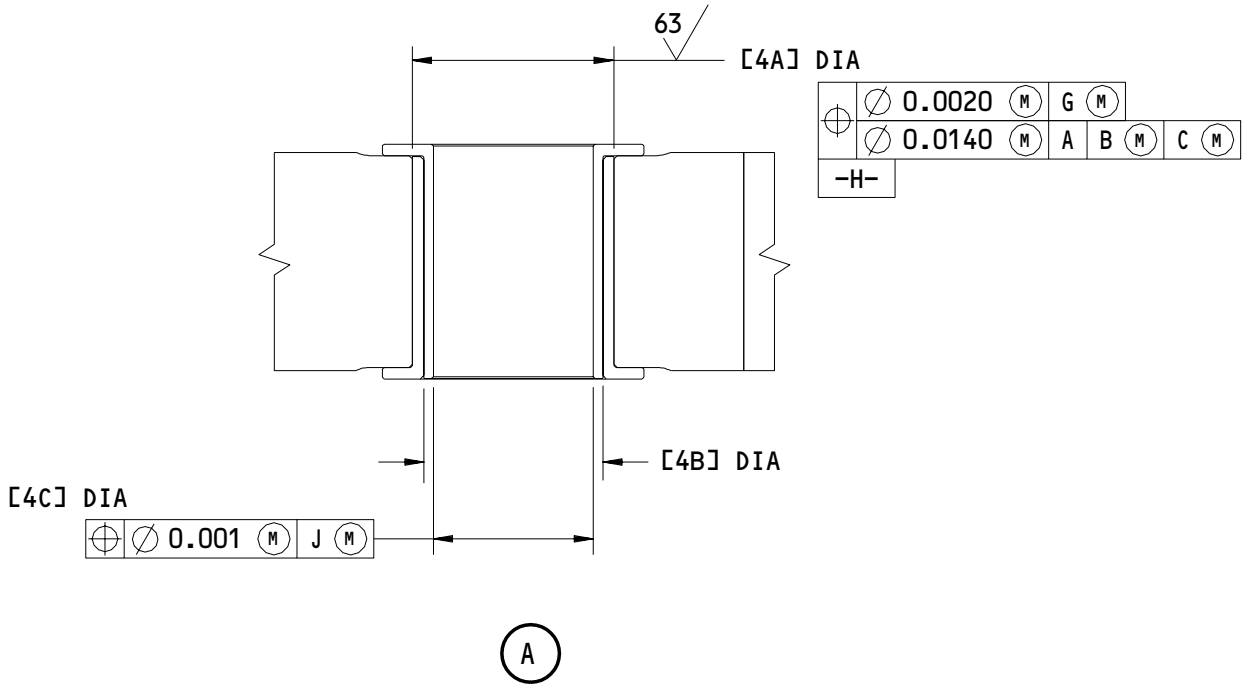
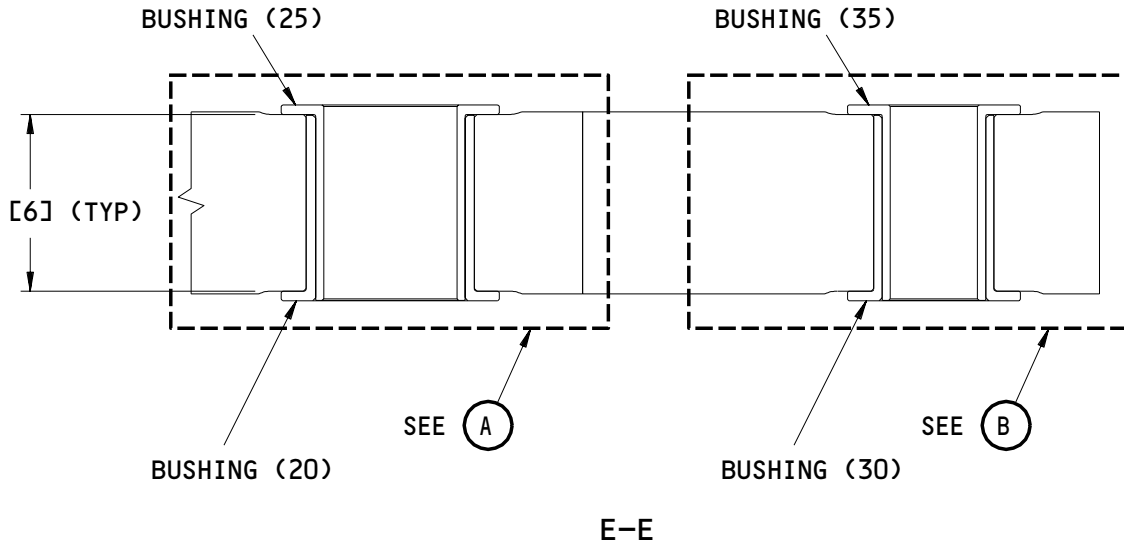
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 MLG Beam Outboard Support Assembly Bushing Replacement  
 Figure 601 (Sheet 4)

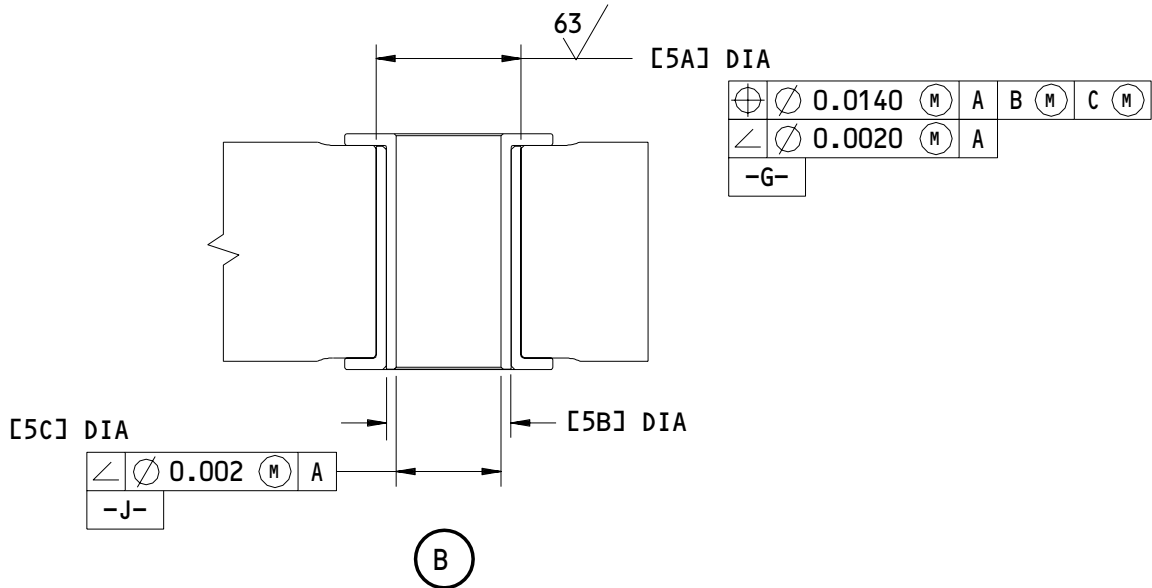
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REPAIR LIMIT	1.9246 1	---	---	---	---	2.7540 1	---	---

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DESIGN DIMENSION	1.8755 1.8745	1.6165 1.6155	1.3610 1.3600	2.7600 2.7550
REPAIR LIMIT	2.0005 1	---	---	---

1 LIMIT FOR INSTALLATION OF OVERSIZE BUSHINGS

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

112T1736-3,-4,-7,-8,-15,-16  
 MLG Beam Outboard Support Assembly Bushing Replacement  
 Figure 601 (Sheet 5)

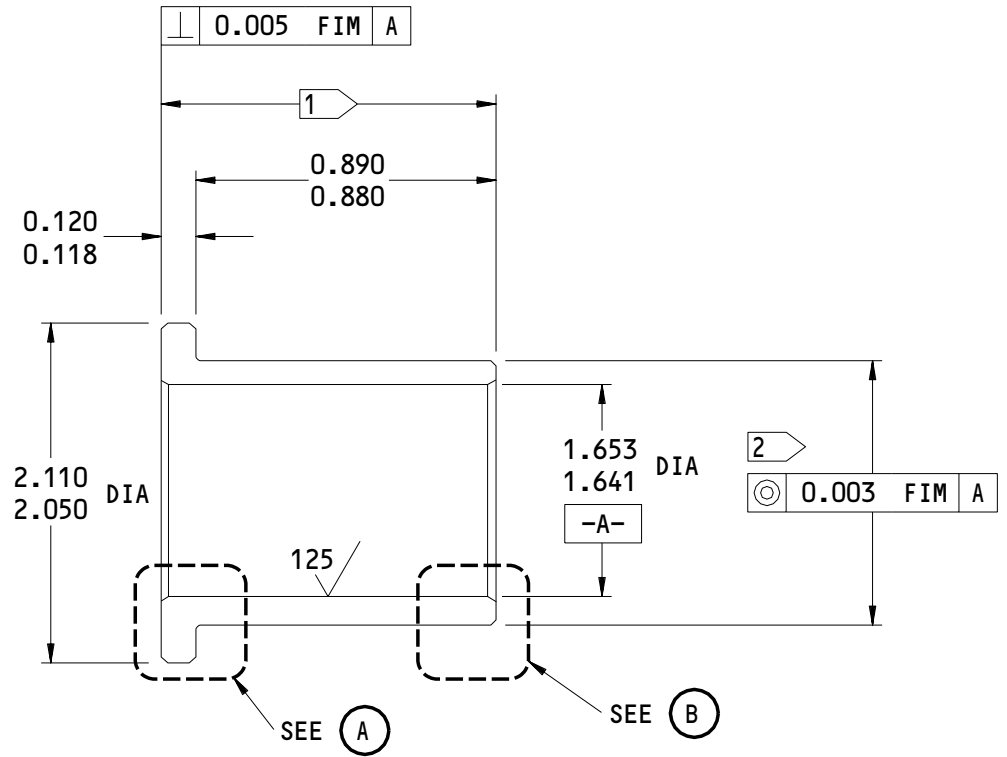
**57-54-39**

REPAIR 3-1

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HOLE LOCATION [1A] FIG. 601 - REPLACES BUSHING (10) 112T1730-3

Oversize Bushing Details  
Figure 602 (Sheet 1)

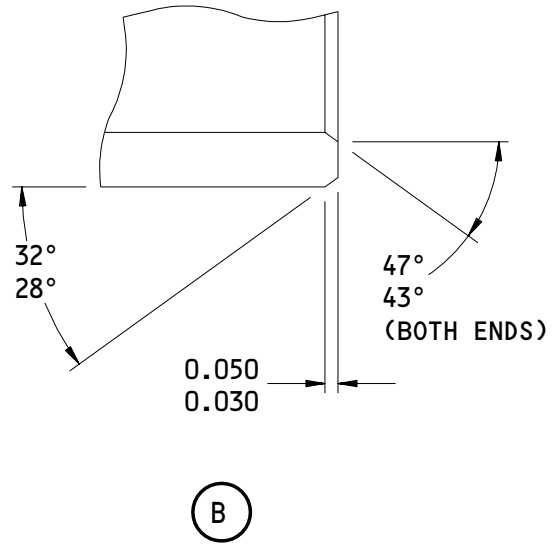
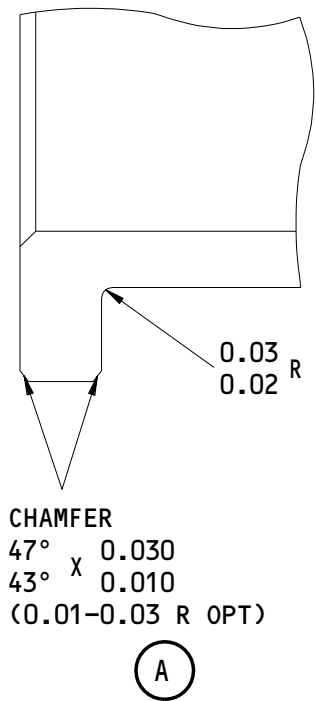
**57-54-39**

REPAIR 3-1

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- 1 CADMIUM PLATE (F-15.02) THIS AREA ONLY
- 2 LUG HOLE REPAIR DIAMETER PLUS 0.0012-0.0029 INTERFERENCE

63 ✓ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES 0.01 R UNLESS SHOWN DIFFERENTLY

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

FINISH: CADMIUM PLATE AS SHOWN BY 1

ITEM NUMBERS REFER TO IPL FIG. 1

DIMENSIONS ARE BEFORE PLATING

ALL DIMENSIONS ARE IN INCHES

HOLE LOCATION [1A] FIG. 601 - REPLACES BUSHING (10) 112T1730-3

Oversize Bushing Details  
 Figure 602 (Sheet 2)

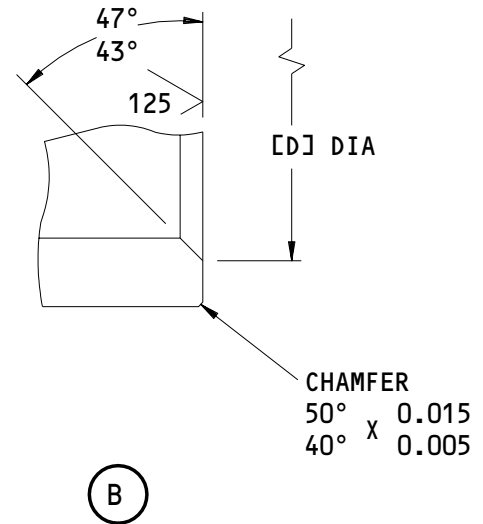
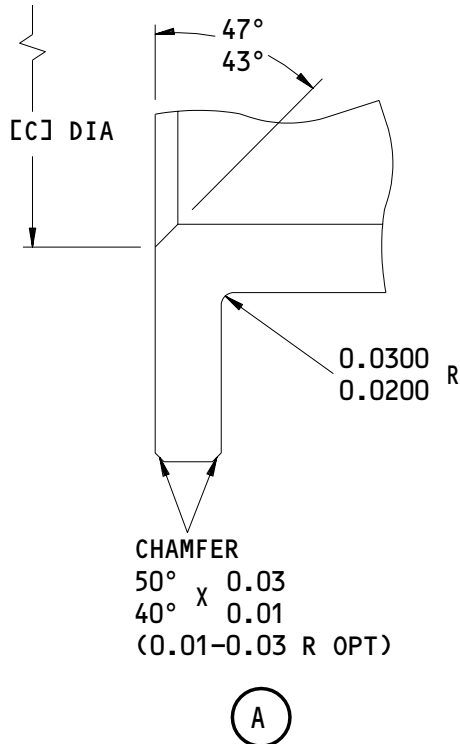
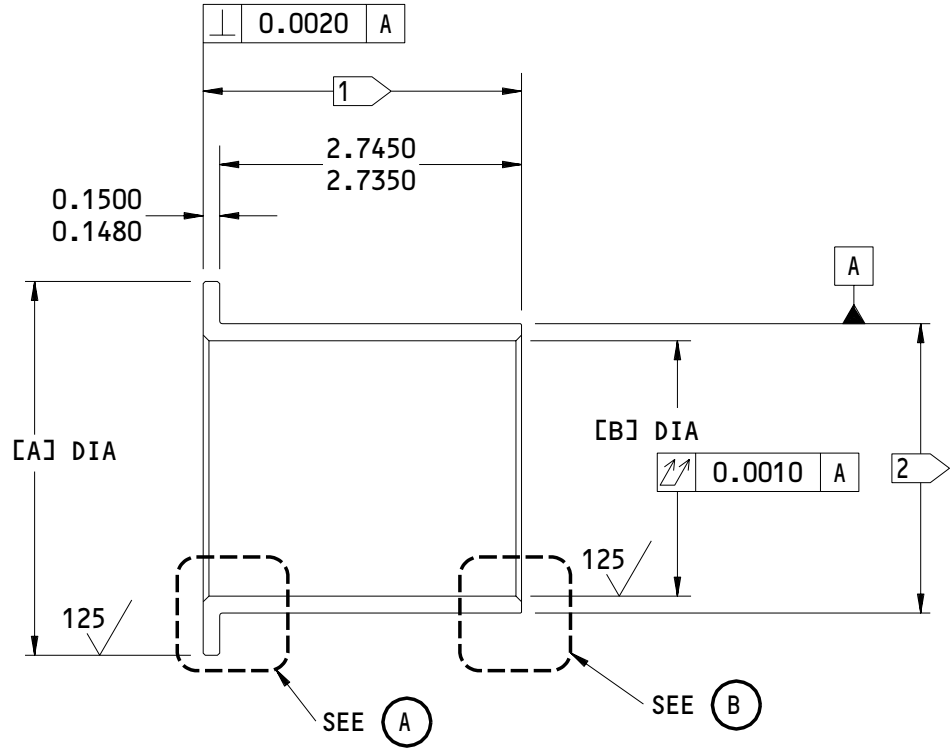
**57-54-39**

REPAIR 3-1

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Oversize Bushing Details  
 Figure 603 (Sheet 1)

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REPAIR 3-1

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HOLE LOCATION (FIG. 601)	REPLACES BUSHING ITEM NO.	[A]	[B]	[C]	[D]	INTERFERENCE
[4A]	20 112T1739-1	3.4300 3.3700	2.6320 2.6310	2.4240 2.4040	2.4240 2.4040	0.0040 0.0020
[5A]	30 112T1739-3	2.7300 2.6700	1.8775 1.8765	1.7090 1.6890	1.7090 1.6890	0.0030 0.0010

- 1 CADMIUM PLATE (F-16.11) THIS AREA ONLY
- 2 REPAIR DIAMETER OF THE LUG HOLE PLUS INTERFERENCE

63/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY  
 BREAK ALL SHARP EDGES  
 MATERIAL: 15-5PH CRES, 180-200 KSI  
 FINISH: CADMIUM PLATE AREAS SHOWN BY 1 . PASSIVATE (F-17.25) OTHER SURFACES  
 ITEM NUMBERS REFER TO IPL FIG. 1  
 DIMENSIONS ARE BEFORE PLATING  
 ALL DIMENSIONS ARE IN INCHES

Oversize Bushing Details  
 Figure 603 (Sheet 2)

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 REPAIR 3-1  
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PLATE ASSEMBLY – REPAIR 4-1

112T1742-1, -2, -3, -4

1. General

- A. This repair gives the data to repair the aft plate assembly (520) and the forward plate assembly (530).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices shown in the repair.
- C. Refer to IPL Fig. 1 for item numbers.

2. Bushing Replacement

A. Consumable Materials

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

B. References

- (1) SOPM 20-41-01, Decoding Table for Boeing Finish Codes
- (2) SOPM 20-50-03, Bearing and Bushing Replacement
- (3) SOPM 20-60-04, Miscellaneous Materials

C. Procedure (Fig. 601, 602)

- (1) Remove the bushings (540, 545, 550, 555, 560, 565) from the plate assemblies.
- (2) If you find defects on the hole surfaces, refer to REPAIR 4-2 for repair instructions.
- (3) Install replacement bushings into the plate (585, 590) by the shrink fit method, with BMS 5-95 sealant (SOPM 20-50-03).
- (4) Machine the bushings to design dimensions and finish.
- (5) Fillet seal around the bushing flanges with BMS 5-95 sealant.

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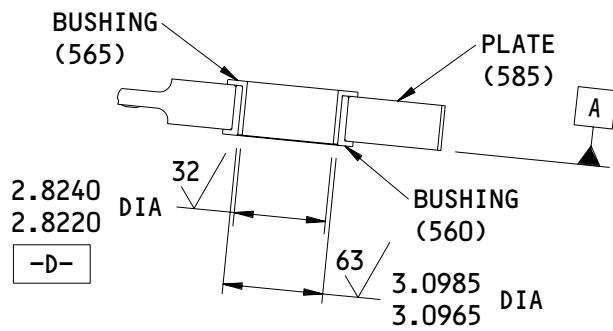
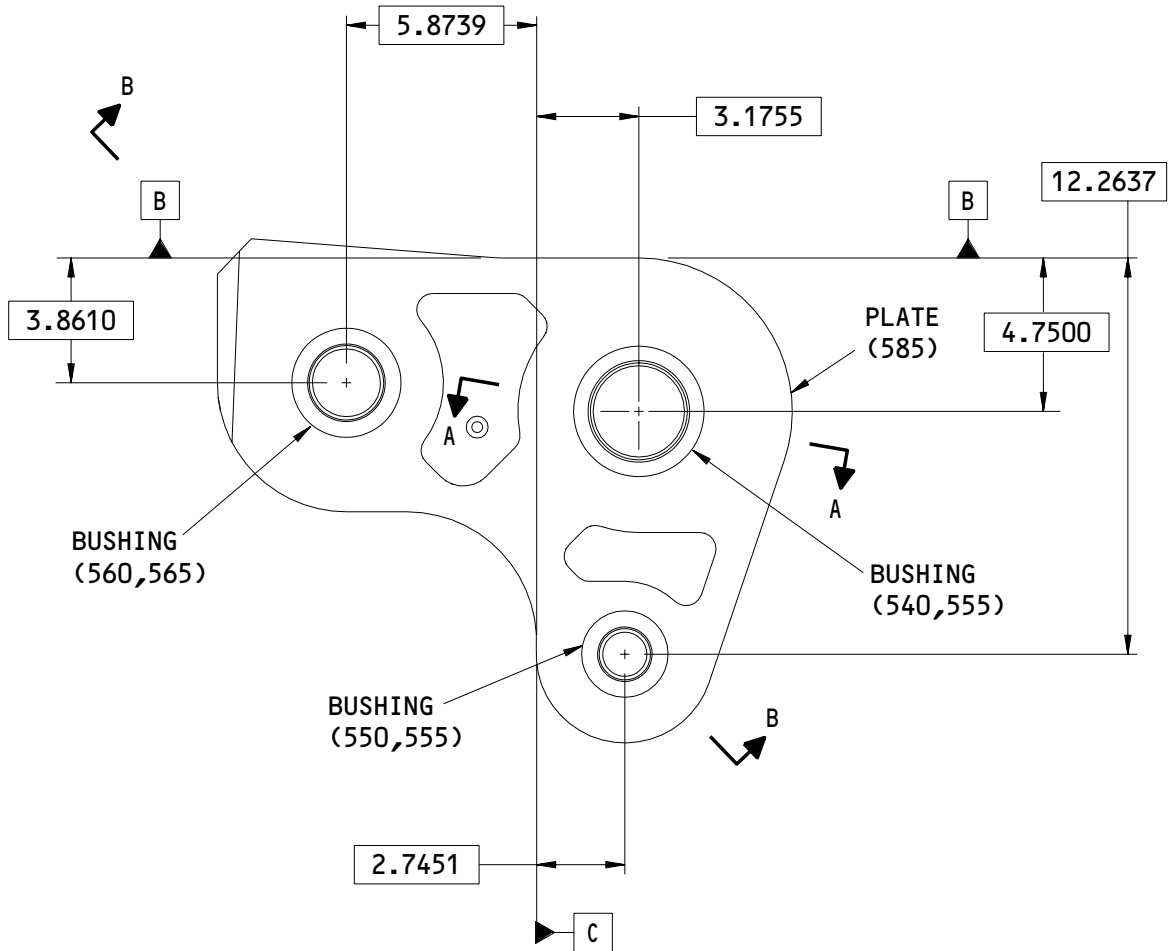
REPAIR 4-1

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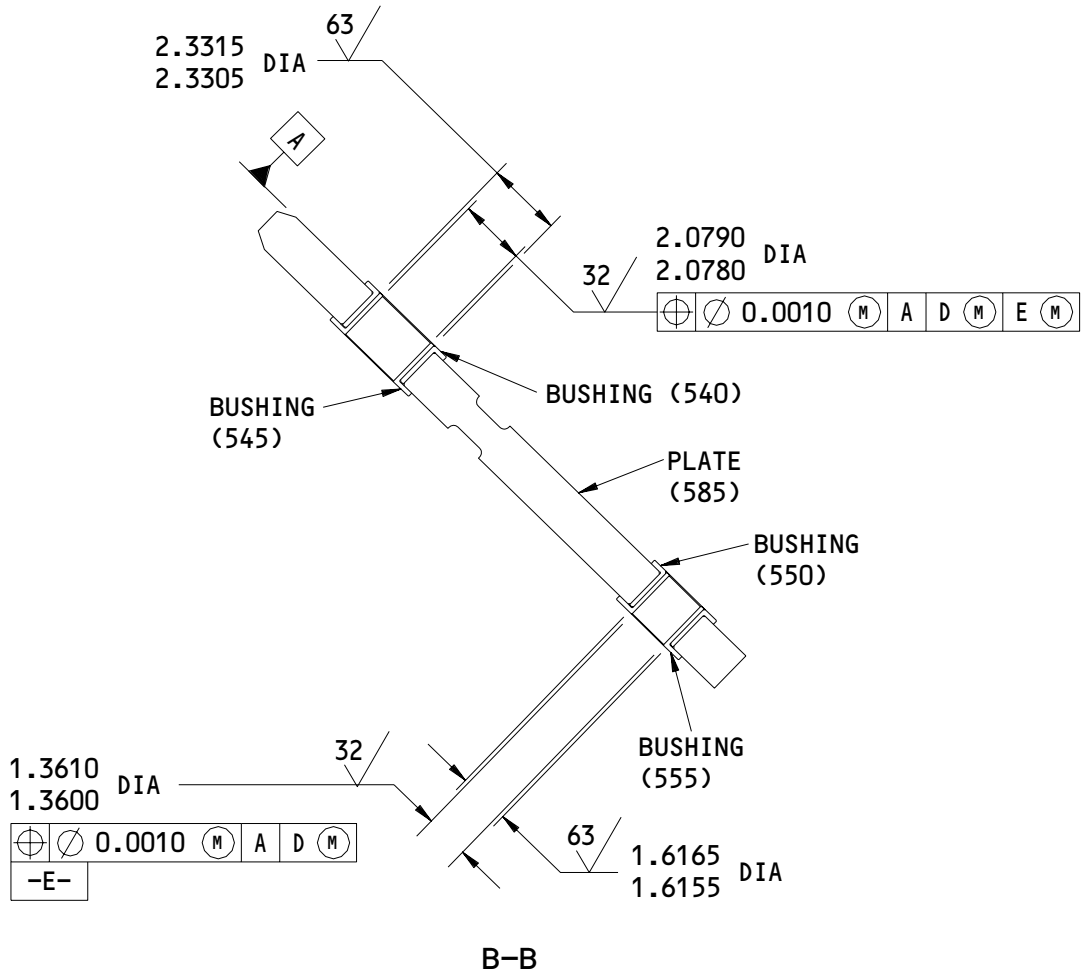
A-A

112T1742-1,-2  
 Aft Plate Assembly Bushing Replacement  
 Figure 601 (Sheet 1)

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REPAIR 4-1  
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125  $\sqrt{\quad}$  ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

112T1742-1,-2  
 Aft Plate Assembly Bushing Replacement  
 Figure 601 (Sheet 2)

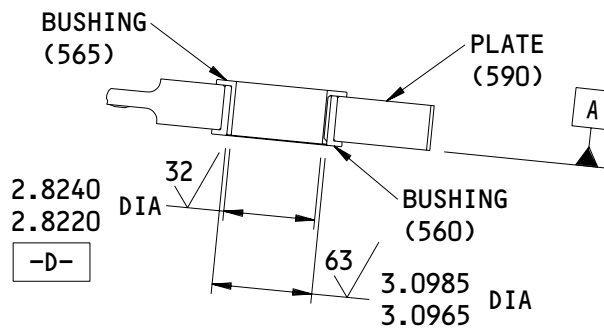
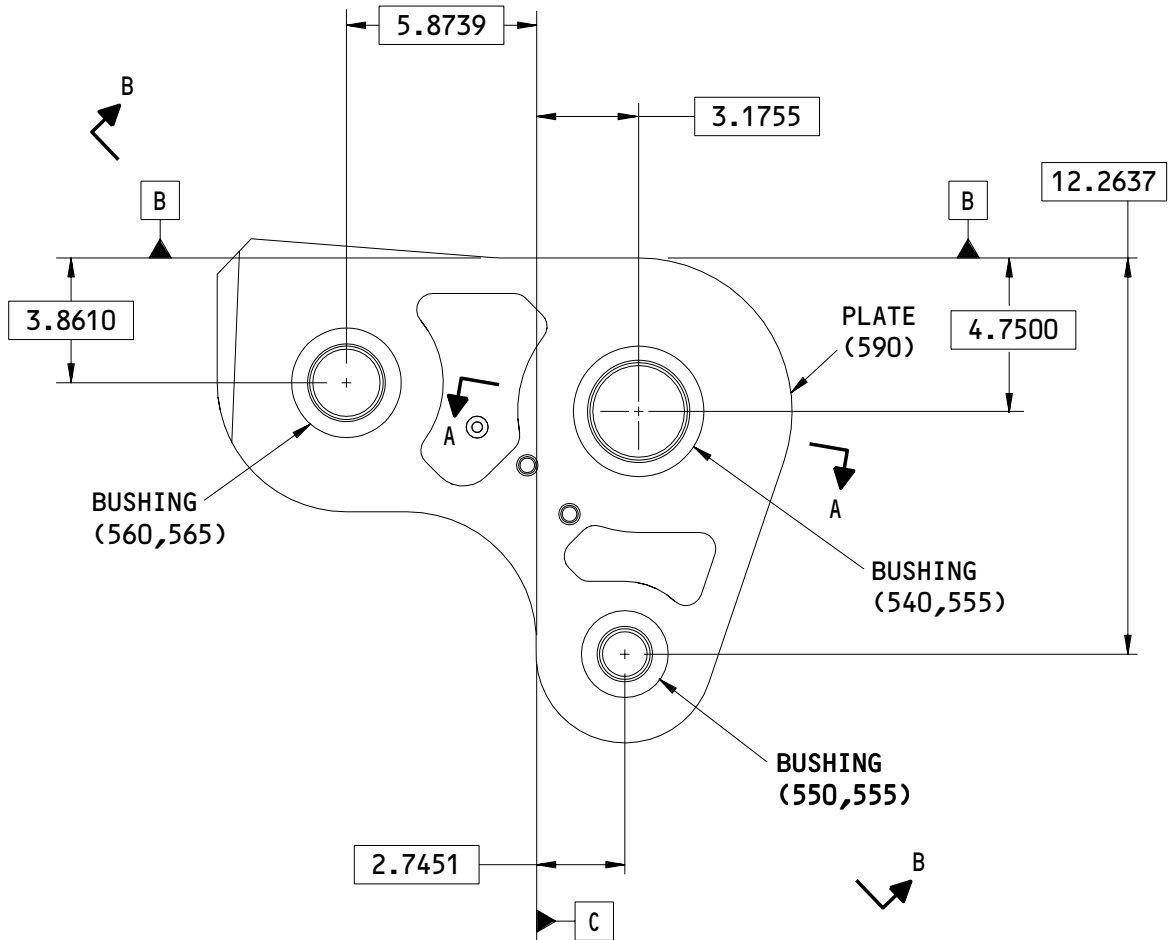
**57-54-39**

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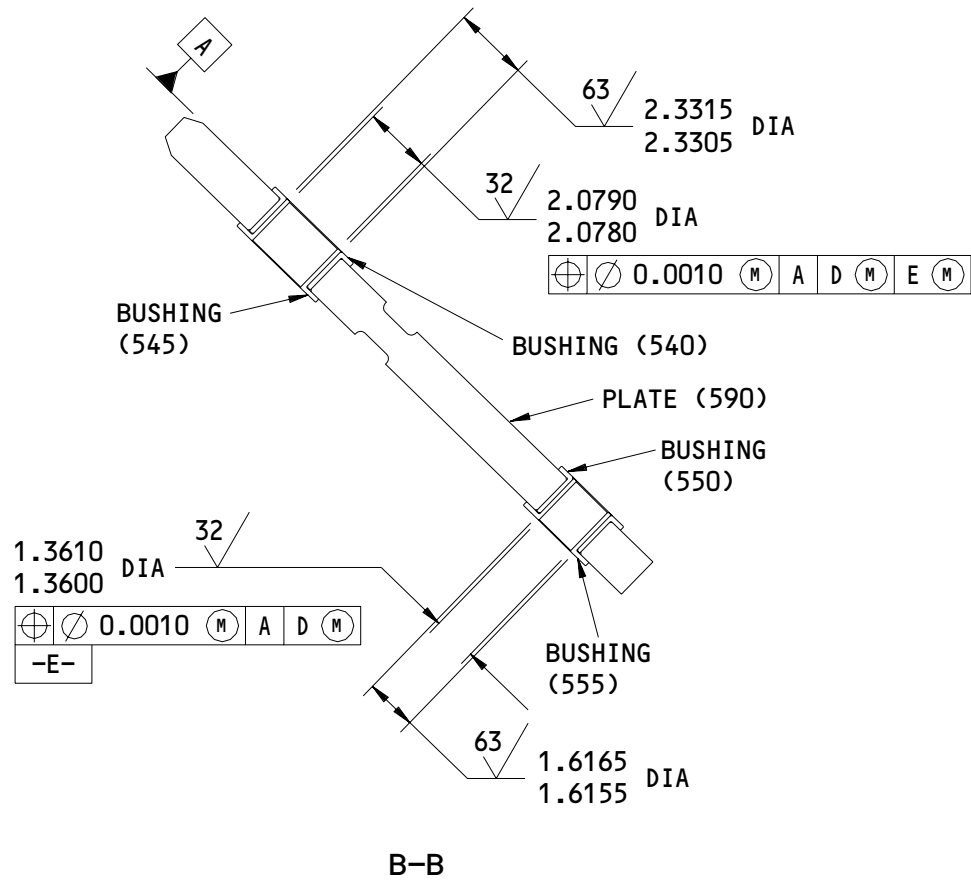
A-A

112T1742-3,-4  
 Forward Plate Assembly Bushing Replacement  
 Figure 602 (Sheet 1)

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REPAIR 4-1  
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125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

112T1742-3,-4  
 Forward Plate Assembly Bushing Replacement  
 Figure 602 (Sheet 2)

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REPAIR 4-1

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PLATE - REPAIR 4-2

112T1742-5, -6, -7, -8

1. General

- | A. This repair gives the data to repair and refinish the plates (585, 590).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices shown in the repair.
- | C. Refer to IPL Fig. 1 for item numbers.
- D. General repair details:
  - (1) Material: Aluminum alloy
  - (2) Shot Peen: Intensity 0.014A  
Coverage 2.0

| 2. Holes for Bushings

- A. References
  - (1) SOPM 20-10-03, Shot Peening
  - (2) SOPM 20-20-02, Penetrant Methods of Inspection
  - (3) SOPM 20-30-03, General Cleaning Procedures
  - (4) SOPM 20-41-01, Decoding Table for Boeing Finish Codes
  - (5) SOPM 20-42-05, Bright Cadmium Plating
- | B. Procedure (Fig. 601)
  - | (1) Machine as necessary, within repair limits, to remove defects.

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REPAIR 4-2

01.1

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- (2) Do a penetrant check (SOPM 20-20-02).
- (3) Shot peen the machined area (SOPM 20-10-03).
- (4) Refinish as indicated.
- (5) Make oversize outer bushings (Fig. 602) as necessary to adjust for the material removed.
- (6) Install the oversize outer bushings and standard inner bushings as shown in REPAIR 4-1.

### 3. Link - Refinish

#### A. Consumable Materials

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

#### B. References

- (1) SOPM 20-30-02, Stripping of Protective Finishes
- (2) SOPM 20-41-01, Decoding Table for Boeing Finish Codes
- (3) SOPM 20-43-01, Chromic Acid Anodize
- (4) SOPM 20-60-02, Finishing Materials

#### C. Procedure

- (1) Boric acid-sulfuric acid anodize (F-17.31).
- (2) Apply BMS 10-11, Type 1 primer (F-20.03). No primer in holes for bushings.

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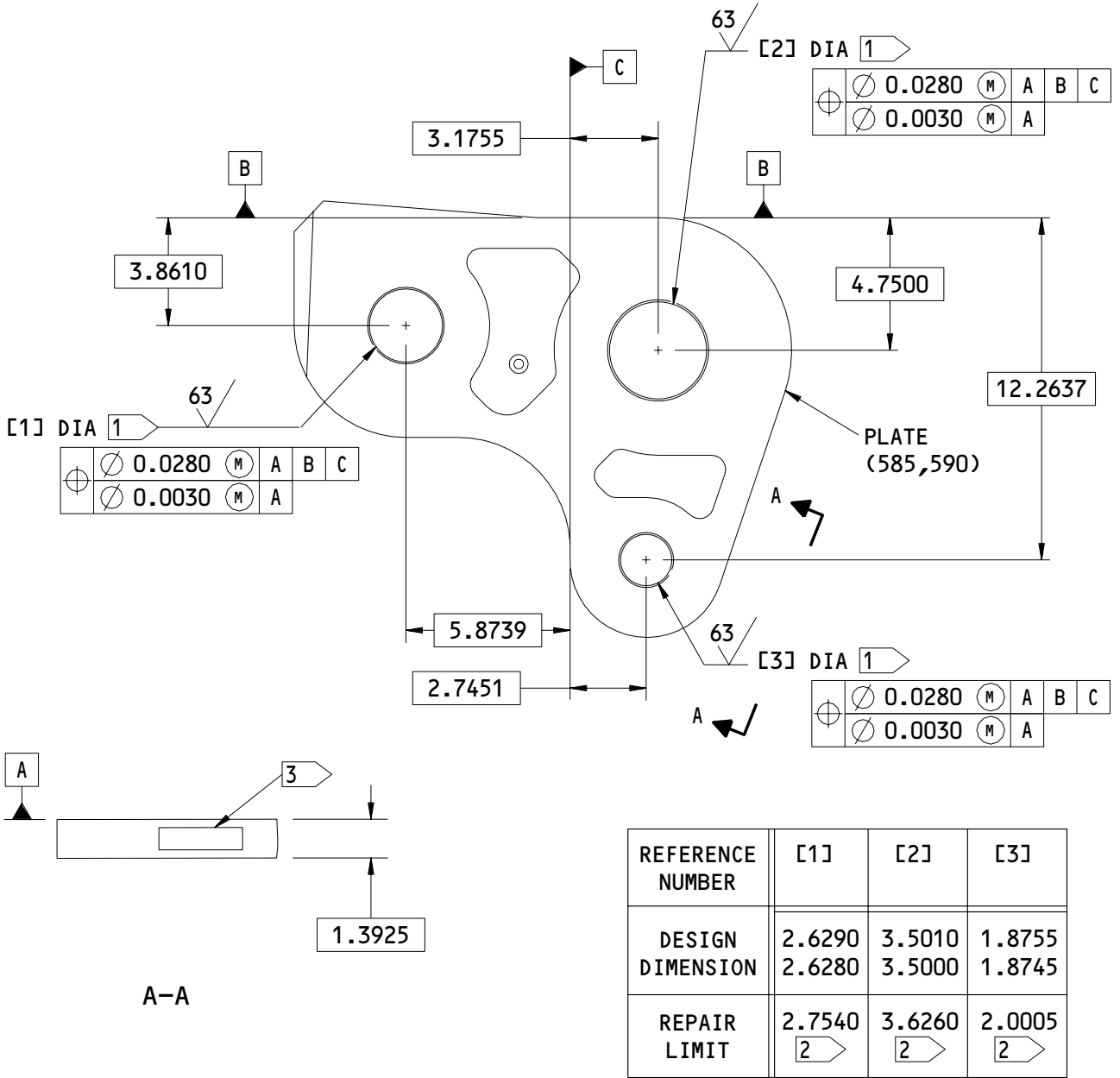
REPAIR 4-2

01.1

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**BOEING**  
 COMPONENT  
 MAINTENANCE MANUAL

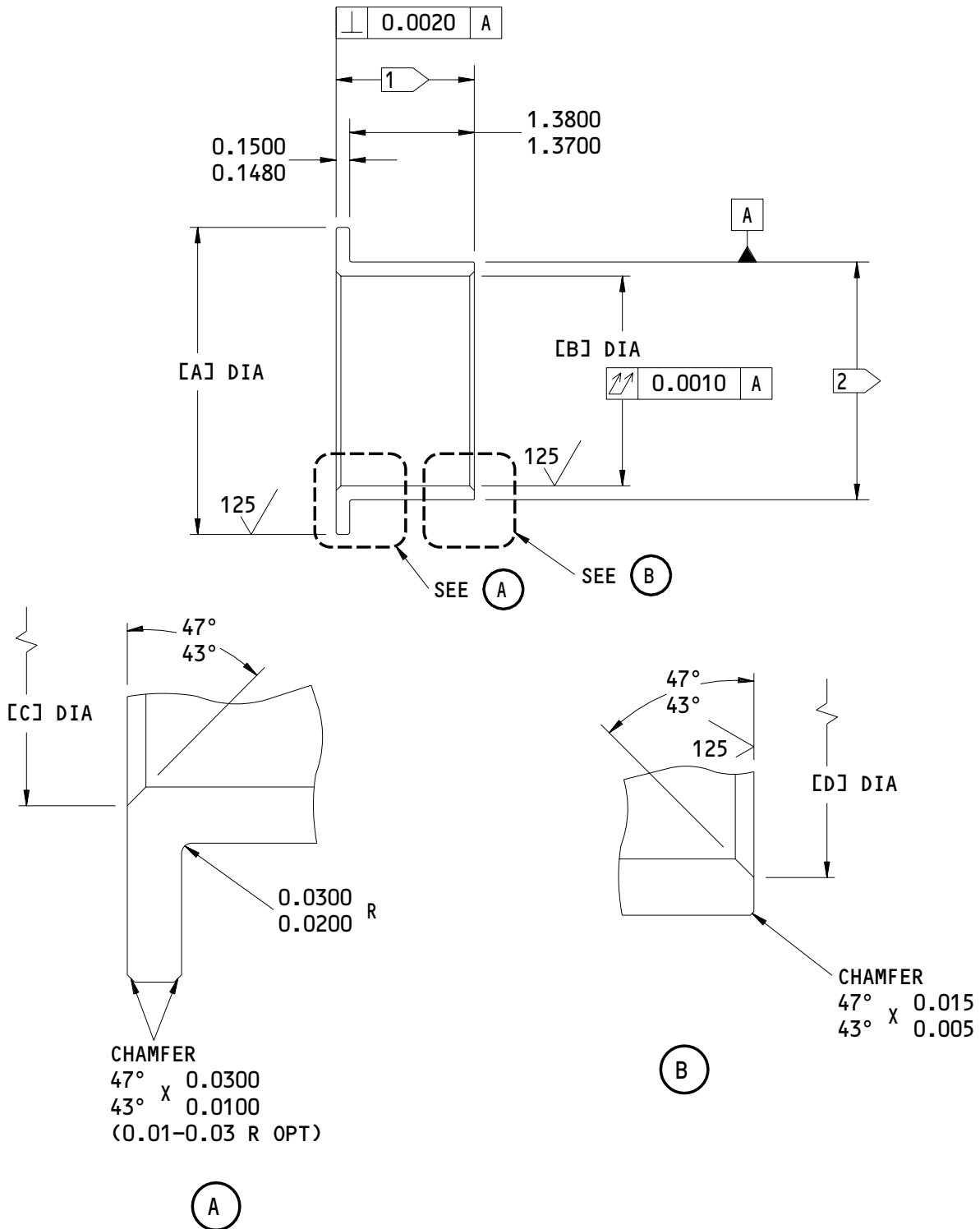


- 1 BORIC ACID-SULFURIC ACID ANODIZE (F-17.31) ONLY - NO PRIMER
- 2 LIMIT FOR INSTALLATION OF OVERSIZE BUSHINGS
- 3 PART NUMBER AND SERIAL NUMBER LOCATION

- 125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY
- BREAK ALL SHARP EDGES
- ITEM NUMBERS REFER TO IPL FIG. 1
- ALL DIMENSIONS ARE IN INCHES

112T1742-5,-6,-7,-8  
 Plate Repair and Refinish  
 Figure 601

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 REPAIR 4-2  
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Oversize Bushing Details  
 Figure 602 (Sheet 1)

**57-54-39**

REPAIR 4-2  
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HOLE LOCATION (FIG. 601)	REPLACES BUSHING ITEM NO.	[A]	[B]	[C]	[D]	INTERFERENCE
[2]	540 112T1743-1	3.4300 3.3700	2.6320 2.6310	2.4240 2.4040	2.4240 2.4040	0.0040 0.0020
[3]	550 112T1743-3	2.7300 2.6700	1.8775 1.8765	1.7090 1.6890	1.7090 1.6890	0.0030 0.0010

- 1 > CADMIUM PLATE (F-16.11) THIS AREA ONLY
- 2 > REPAIR DIAMETER OF LUG HOLE PLUS INTERFERENCE

63 ✓ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

MATERIAL: 15-5PH CRES, 180-200 KSI

FINISH: CADMIUM PLATE AREAS SHOWN BY 1 >. PASSIVATE (F-17.25) OTHER AREAS

ITEM NUMBERS REFER TO IPL FIG. 1

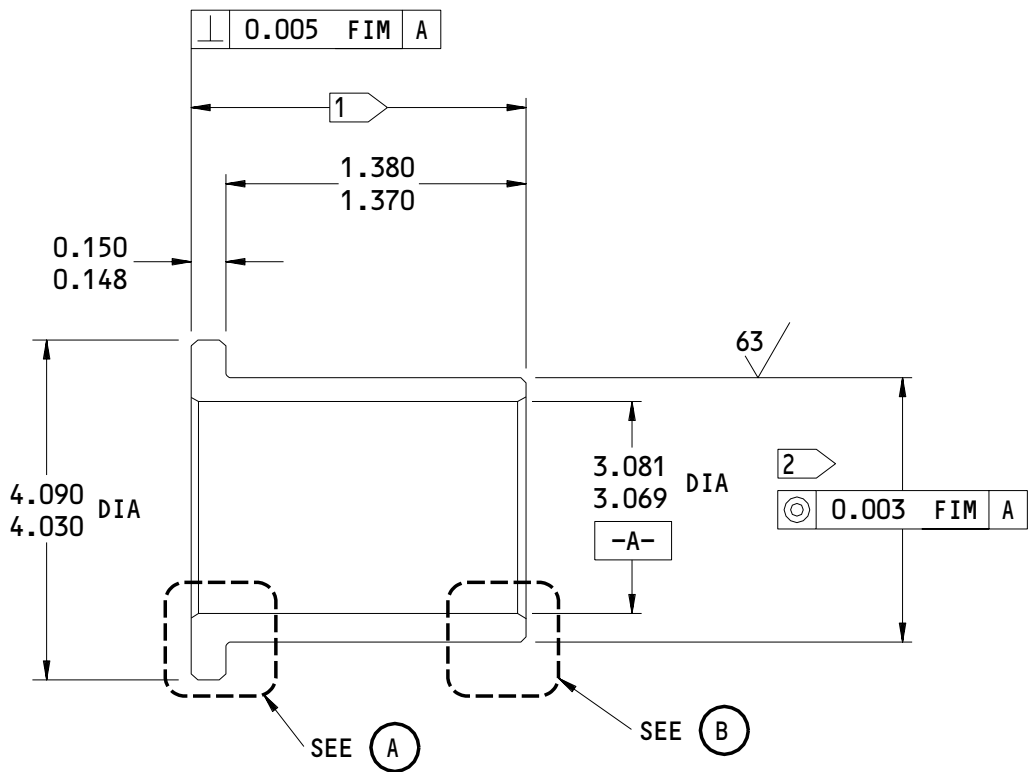
DIMENSIONS ARE BEFORE PLATING

ALL DIMENSIONS ARE IN INCHES

Oversize Bushing Details  
Figure 602 (Sheet 2)

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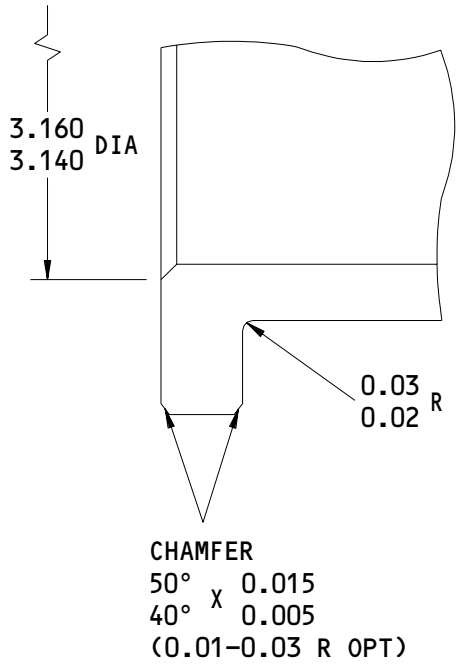
HOLE LOCATION [1] FIG. 601 - REPLACES BUSHING (560) 112T1730-101

Oversize Bushing Details  
 Figure 603 (Sheet 1)

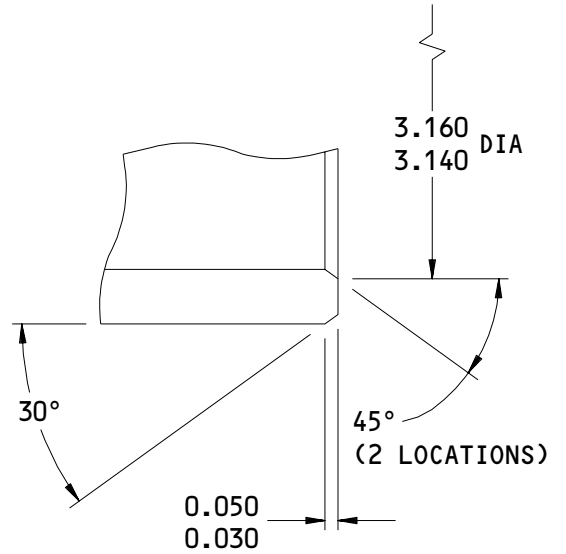
**57-54-39**

REPAIR 4-2  
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(A)



(B)

- 1 CADMIUM PLATE (F-15.02) THIS AREA ONLY
- 2 REPAIR DIAMETER OF THE LUG HOLE PLUS 0.0023-0.0043 INTERFERENCE

63 ✓ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES 0.01 R UNLESS SHOWN DIFFERENTLY

MATERIAL: 15-5PH CRES, 180-200 KSI

FINISH: CADMIUM PLATE AS SHOWN BY 1

ITEM NUMBERS REFER TO IPL FIG. 1

DIMENSIONS ARE BEFORE PLATING

ALL DIMENSIONS ARE IN INCHES

HOLE LOCATION [1] FIG. 601 - REPLACES BUSHING (560) 112T1730-101

Oversize Bushing Details  
 Figure 603 (Sheet 2)

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REPAIR 4-2

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FITTING ASSEMBLY – REPAIR 5-1

113T1992-29, -30

1. General

- A. This repair gives the data to repair the fitting assembly (160).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices shown in the repair.
- C. Refer to IPL Fig. 1 for item numbers.

2. Bushing Replacement

## A. Consumable Materials

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

## B. References

- (1) SOPM 20-41-01, Decoding Table for Boeing Finish Codes
- (2) SOPM 20-50-03, Bearing and Bushing Replacement
- (3) SOPM 20-60-04, Miscellaneous Materials

## C. Procedure (Fig. 601)

- (1) Remove the old bushings (170, 175) from the fitting assembly (160).
- (2) If you find defects on the fitting surfaces, refer to REPAIR 5-2 for repair instructions.
- (3) Install replacement bushings into the fitting (180) by the shrink fit method with BMS 5-95 sealant (SOPM 20-50-03).
- (4) Machine the bushings inside diameter to the dimensions and finish shown in Fig. 601.
- (5) Fillet seal around the bushing flanges of the bushings with BMS 5-95 sealant.

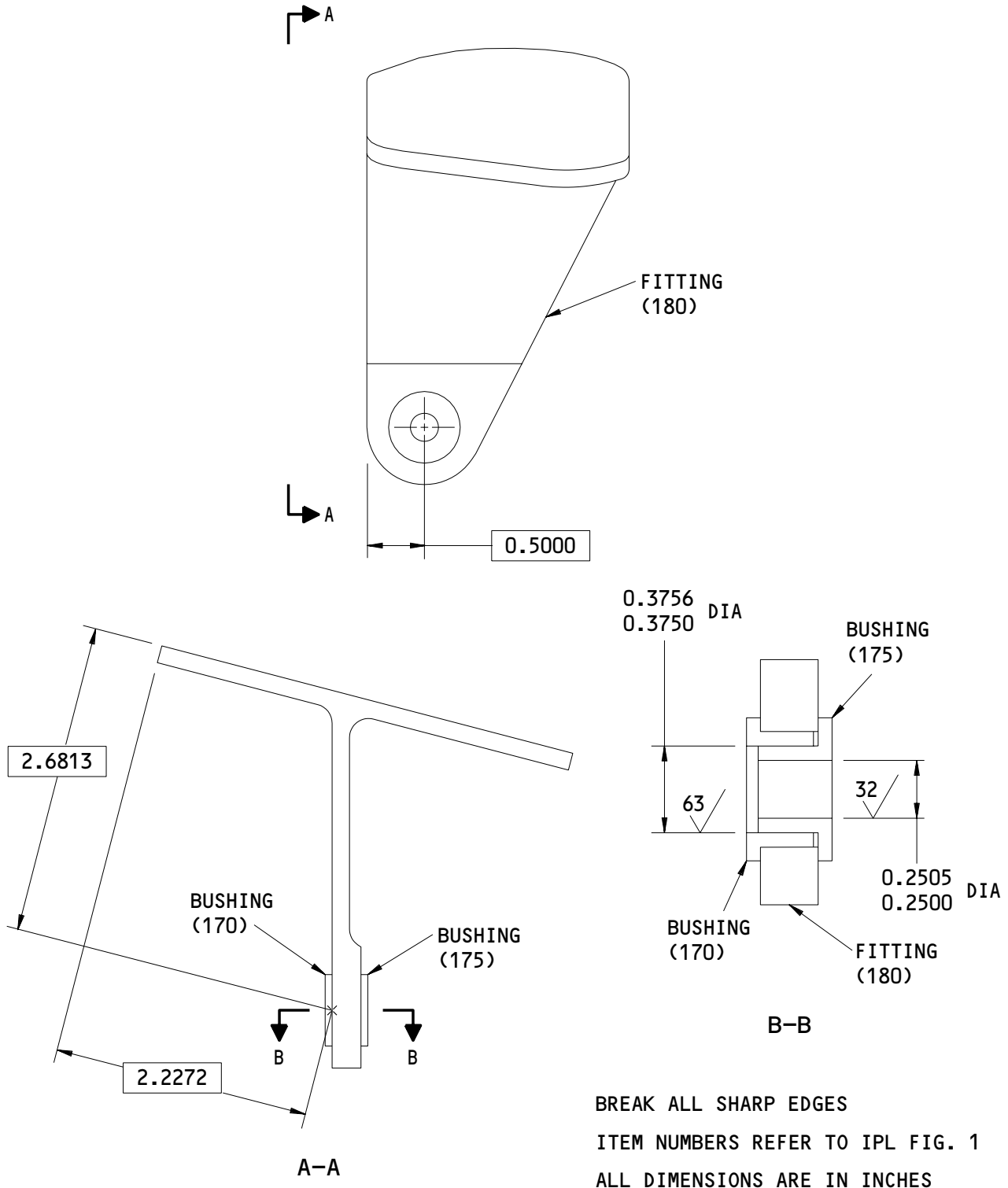
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REPAIR 5-1

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113T1992-29,-30  
 Fitting Assembly Bushing Replacement  
 Figure 601

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REPAIR 5-1

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FITTING - REPAIR 5-2

113T1992-31, -32

1. General

- | A. This repair gives the data to repair and refinish the fitting (180).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices shown in the repair.
- | C. Refer to IPL Fig. 1 for item numbers.
- D. General repair details:
  - (1) Material: Aluminum alloy
  - (2) Shot Peen: Intensity 0.010A  
Coverage 2.0

| 2. Holes for Bushings

- A. References
  - (1) SOPM 20-10-03, Shot Peening
  - (2) SOPM 20-20-02, Penetrant Methods of Inspection
  - (3) SOPM 20-41-01, Decoding Table for Boeing Finish Codes
  - (4) SOPM 20-42-05, Bright Cadmium Plating
- | B. Procedure (Fig. 601)
  - | (1) Machine as necessary, within repair limits, to remove defects.

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REPAIR 5-2

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- | (2) Do a penetrant check (SOPM 20-20-02).
- | (3) Shot peen the machined area (SOPM 20-10-03).
- | (4) Refinish as indicated.
- | (5) Make an oversize bushing (Fig. 602) as necessary to adjust for the material removed.
- | (6) Install the oversize repair bushing and a standard inner bushing as shown in REPAIR 5-1.

### | 3. Fitting - Refinish

#### A. Consumable Materials

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

#### B. References

- (1) SOPM 20-30-02, Stripping of Protective Finishes
- (2) SOPM 20-41-01, Decoding Table for Boeing Finish Codes
- (3) SOPM 20-41-02, Application of Chemical and Solvent Resistant Finishes
- | (4) SOPM 20-43-01, Chromic Acid Anodizing

#### | C. Procedure (Fig. 601)

- (1) Boric acid-sulfuric acid anodize (F-17.31).
- | (2) Apply BMS 10-11, Type 1 primer (F-20.02), but not in the hole for the bushings.

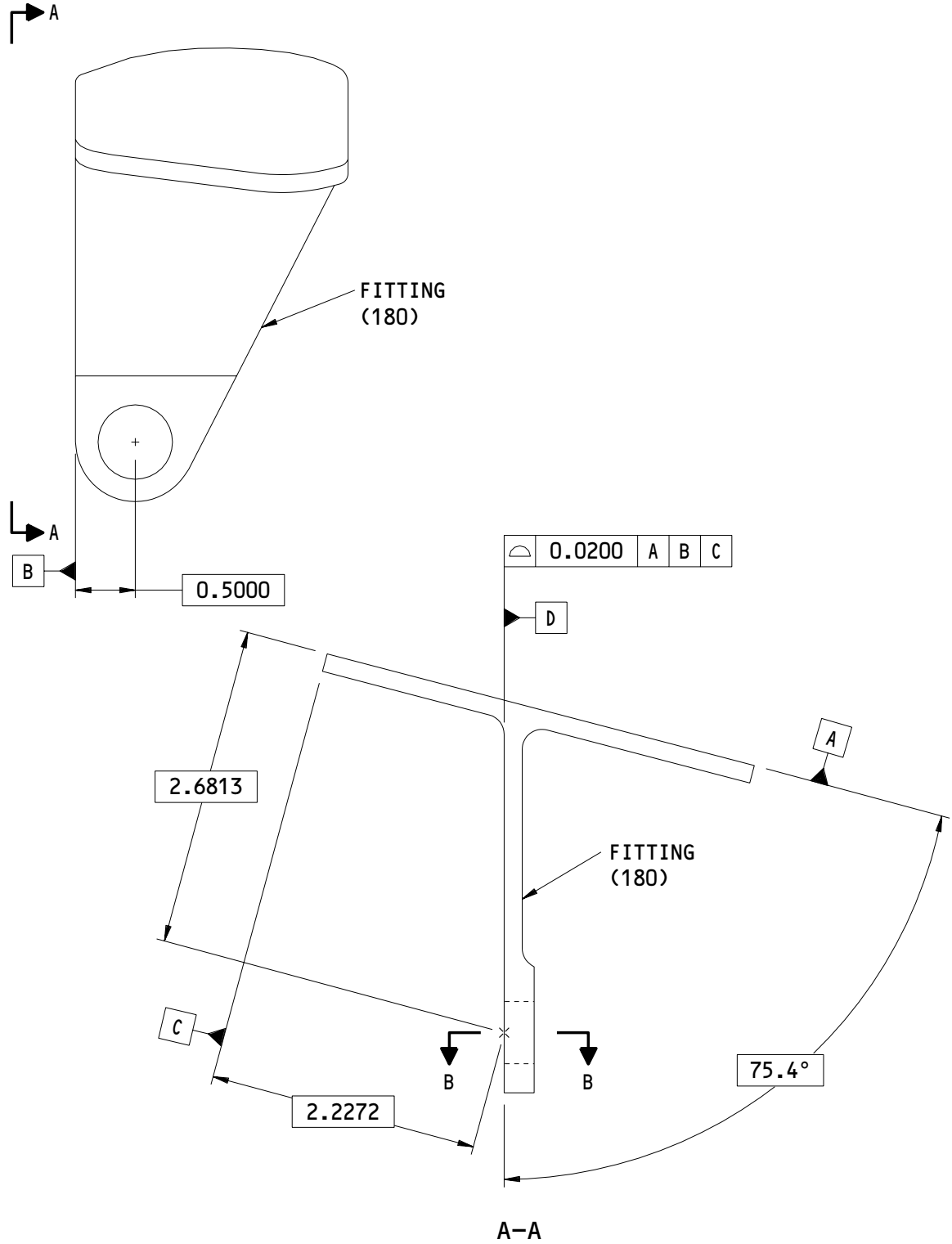
**57-54-39**

REPAIR 5-2

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113T1992-31,-32  
Fitting Repair and Refinish  
Figure 601 (Sheet 1)

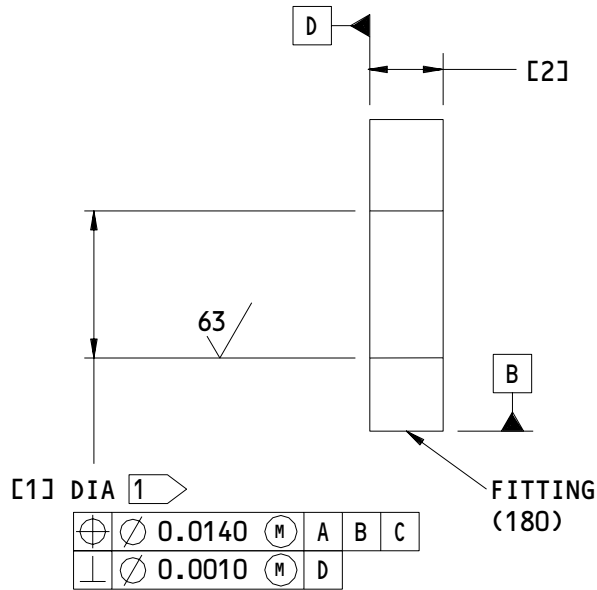
**57-54-39**

REPAIR 5-2  
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B-B

REFERENCE NUMBER	[1]	[2]
DESIGN DIMENSION	0.5006 0.5000	0.2600 0.2400
REPAIR LIMIT	0.5606 2	---

1 BORIC ACID-SULFURIC ACID ANODIZE (F-17.31) ONLY

2 LIMIT FOR INSTALLATION OF OVERSIZE BUSHING

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

113T1992-31,-32  
 Fitting Repair and Refinish  
 Figure 601 (Sheet 2)

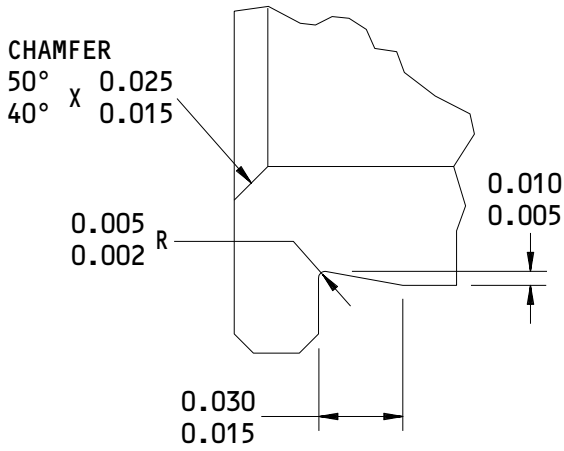
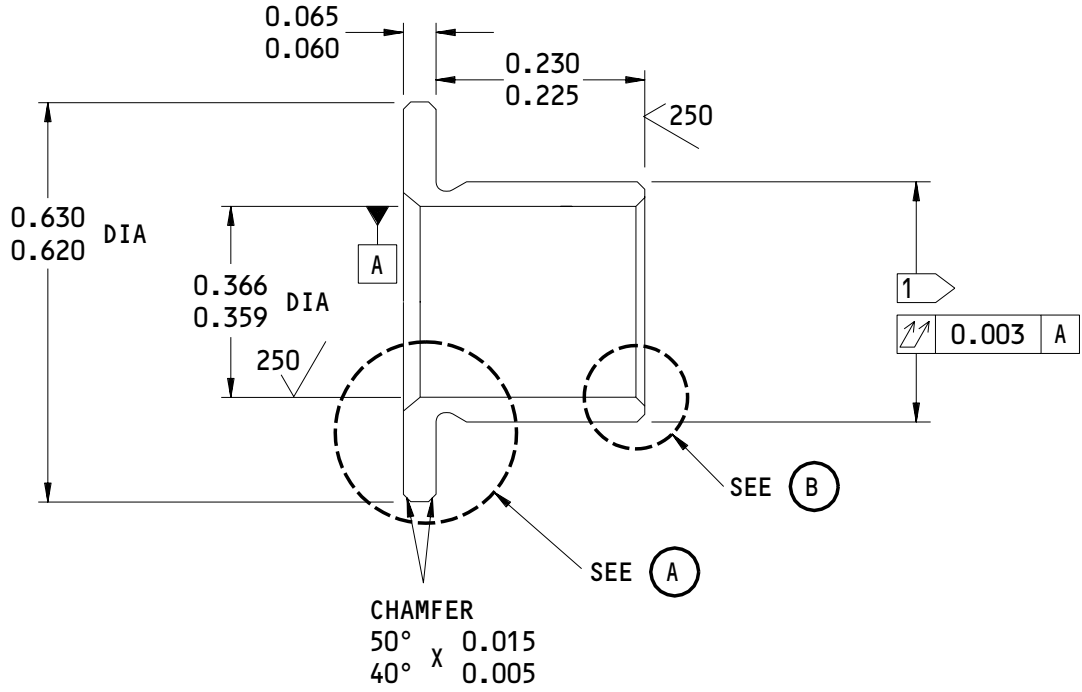
**57-54-39**

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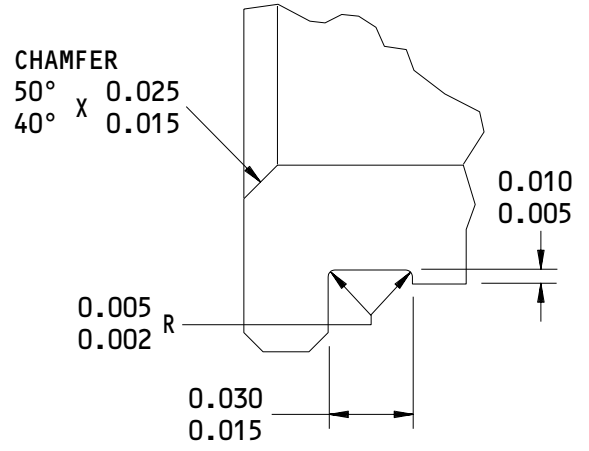
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TYPE 1

(A)



TYPE 2

(A)

OR

HOLE LOCATION [1] FIG. 601 - REPLACES BUSHING (170)  
BACB28AT06D023

Oversize Bushing Details  
Figure 602 (Sheet 1)

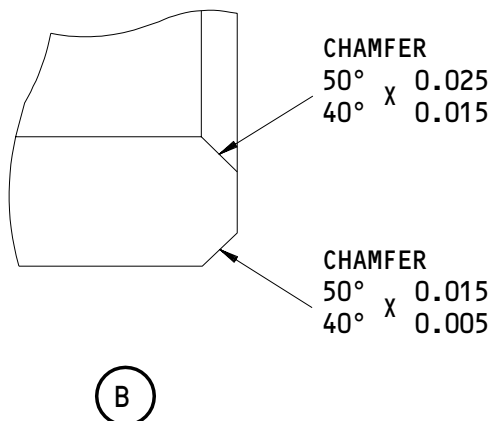
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REPAIR 5-2

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1 REPAIR DIAMETER OF LUG HOLE PLUS  
0.0004-0.0015 INTERFERENCE

63 ALL MACHINED SURFACES UNLESS  
SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

MATERIAL: 15-5PH OR 17-4PH CRES,  
R<sub>c</sub> 32-37

FINISH: CADMIUM PLATE (F-15.06)  
OR ZINC-NICKEL PLATE  
(F-15.40). PLATING CAN  
RUN OUT IN BORE

ITEM NUMBERS REFER TO IPL FIG. 1

DIMENSIONS ARE AFTER PLATING

ALL DIMENSIONS ARE IN INCHES

HOLE LOCATION [1] FIG. 601 - REPLACES BUSHING (170)  
BACB28AT06D023C

Oversize Bushing Details  
Figure 602 (Sheet 2)

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REPAIR 5-2

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ASSEMBLY1. General

- A. This procedure has the data to assemble the support assembly.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for details of the SOPM chapters identified in this procedure.
- C. Refer to IPL Fig. 1 for item numbers.

2. Assembly

## A. Special Tools

NOTE: Equivalent tools can be used.

- (1) A57005-1 Retention Nut Socket Assembly

## B. Consumable Materials

NOTE: Equivalent material can be used.

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

## C. References

- (1) SOPM 20-50-01, Bolt and Nut Installation
- (2) SOPM 20-50-02, Installation of Safetying Devices
- (3) SOPM 20-60-03, Lubricants

## D. Procedure

- (1) Use standard industry procedures and these steps,
- (2) Install spherical bearing (280) into retract actuator fitting assembly (225).
  - (a) Install the spherical bearing (280), the washer (290), the retainer nut (285), the antirotation plate (275), the retainer dog (270), the bolts (245, 250), the washers (255, 260) and the nuts (265) onto the fitting (295).
    - 1) Be sure that the teeth on the spherical bearing (280) fully engage the teeth on the antirotation plate (275).

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- 2) Tighten the retaining nut (285) 75-100 pound-feet.
  - 3) Be sure that the teeth on the retaining nut (285) fully engage the teeth on the retainer dog (270).
- (b) Install the fuse pins (480, 485), the washers (490, 495), the nuts (500, 505), the cross bolts (465, 470), the lock nuts (475) and the cotter pins (460).
- 1) Lubricate the fuse pins (480, 485) all over with BMS 3-33 grease before you install them through the plates (520, 530) and the mini-cantilever fitting (510).
  - 2) Install the fuse pins (480, 485), the washers (490, 495).
  - 3) Install the fuse pin nuts (500, 505) finger tight with no gap between the head of the fuse pin, washer and bushing flanges. If necessary, back off the nuts to the nearest castellation, then install the cross bolts (465, 470), the lock nuts (475) and the cotter pins (460).

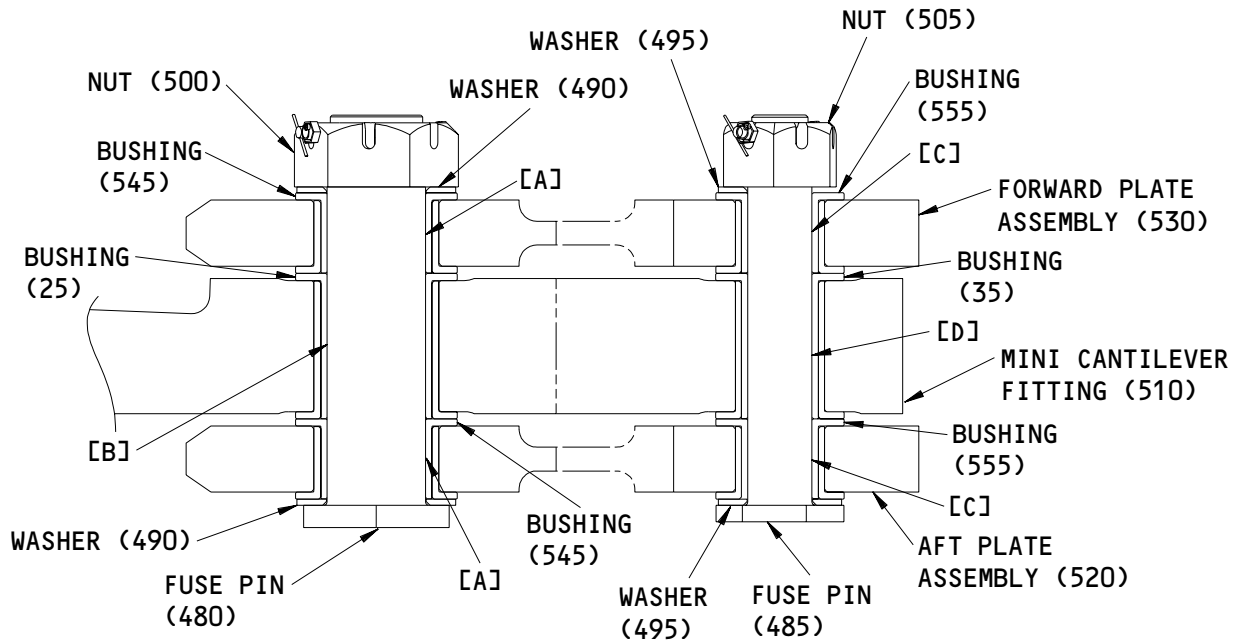
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ASSEMBLY  
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**BOEING**  
 COMPONENT  
 MAINTENANCE MANUAL

FITS AND CLEARANCES



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 545	2.0780	2.0790	0.0010	0.0030	1	2.0830	0.0060
	OD 480	2.0760	2.0770					
[B]	ID 25	2.0780	2.0790	0.0010	0.0030	1	2.0830	0.0060
	OD 480	2.0760	2.0770					
[C]	ID 555	1.3600	1.3610	0.0010	0.0030	1	1.3650	0.0060
	OD 485	1.3580	1.3590					
[D]	ID 35	1.3600	1.3610	0.0010	0.0030	1	1.3650	0.0060
	OD 485	1.3580	1.3590					

\* ALL DIMENSIONS ARE IN INCHES

1 CHROME PLATE MUST NOT BE WORN THROUGH TO THE BASE MATERIAL

Fits and Clearances  
 Figure 801

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FITS AND CLEARANCES  
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REF IPL		NAME	TORQUE*	
FIG. NO.	ITEM NO.		POUND-INCHES	POUND-FEET
1	285	Retaining Nut		75 - 100

\* REFER TO SOPM 20-50-01 FOR TORQUE VALUES OF STANDARD FASTENERS.

Torque Table  
 Figure 802

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FITS AND CLEARANCES  
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SPECIAL TOOLS, FIXTURES AND EQUIPMENT

NOTE: Equivalent substitutes may be used.

1. Retention Nut Socket Assembly -- A57005-1

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SPECIAL TOOLS

01.1

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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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ILLUSTRATED PARTS LIST

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VENDORS

OPTK6 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.

06950 SCREWCORP VSI AEROSPACE PRODUCTS DIV FAIRCHILD IND DIV  
13001 EAST TEMPLE AVENUE PO BOX 730  
CITY OF INDUSTRY, CALIFORNIA 91746-1417  
FORMERLY VB0096 AND VSI CORP SCREWCORP DIV  
FORMERLY IN CULVER CITY, CALIFORNIA

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

17446 HUCK MFG CO GOV CONTRACTS LOS ANGELES DIV SUB OF FED-MOGUL  
900 WATSON CENTER ROAD  
CARSON, CALIFORNIA 90745

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

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**BOEING**  
 COMPONENT  
 MAINTENANCE MANUAL
VENDORS

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

60119 MONADNOCK CO THE  
 18301 ARENTH AVENUE PO BOX 1222  
 CITY OF INDUSTRY, CALIFORNIA 91749  
 FORMERLY UNITED CARR FASTENER CORP VB0051 VB0056 VB0076  
 FORMERLY TRW ELECTRONIC COMPONENTS CINCH-MONADNOCK DIV  
 FORMERLY CINCH-MONADNOCK DIV OF TRW INC V76530

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

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

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

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

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

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

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

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 ILLUSTRATED PARTS LIST  
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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACB28AT06D023C		1	170	1
BACB28AU04B026C		1	175	1
BACB30MY14K17		1	215	8
BACB30MY14K26		1	570	2
BACB30MY16K18		1	355	5
BACB30MY16K43		1	140	1
BACB30NM7K19		1	216	8
BACB30NR4DK36		1	470	1
BACB30NR4DK48		1	465	1
BACB30NX16K18		1	320	2
BACB30NX16K28		1	330	1
BACB30NX16K31		1	325A	1
BACB30US12K26		1	340	1
BACB30US12K48		1	350	1
BACB30US12K54		1	335	1
BACB30US12K97		1	345	1
BACB30UU14K27		1	190	2
		1	195A	2
BACB30UU14K30		1	195	2
BACB30UU6K38		1	245A	1
BACB30UU6K39		1	245	1
BACB30UU6K40		1	250A	2
BACB30UU6K41		1	250	2
BACB30VT5K14		1	40	5
BACB30VT6K12		1	100	2
BACB30VT8K34		1	150	2
BACB30YP8K10		1	415	2
BACC30AG16		1	145	1
BACC30BL5		1	45	5
BACC30BL6		1	105	2
BACC30BL8		1	420	2
BACC30BQ8		1	155	2
BACC30M14		1	220	8
		1	575	2
BACN10HR12CD		1	395	4
BACN10JC14CD		1	210	4
BACN10JC4CM		1	475	2
BACN10JC8CD		1	400	5
BACN10JN3CD		1	90	2
BACN10JP3B		1	125	2
BACN10JR3CFD		1	65	2
BACN10YR6CM		1	265	3
BACP18BC02A06P		1	460	2
BACR15BA3AD		1	60	4
		1	85	4

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**BOEING**  
 COMPONENT  
 MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACR15BA3AD		1	120	4
BACW10BP12CD		1	375	4
BACW10BP12DP		1	380	4
BACW10BP14ACU		1	200	4
BACW10BP14DP		1	205	4
BACW10BP6ACU		1	255	3
BACW10BP6APU		1	260	3
BACW10BP7ACU		1	217	8
BACW10CA8CC		1	365	1
BACW10CA8CV		1	370	1
BMN10HRCWD3-12		1	395	4
BMN4122CPD8-14		1	210	4
BMN4122CPD8-8		1	400	5
BRFM20C3D		1	90	2
BRF200C3D		1	65	2
BRM100A3		1	125	2
B30MY14K17		1	215	8
B30MY14K26		1	570	2
CR603012		1	395	4
HL10VAZ14-17		1	215	8
HL10VAZ14-26		1	570	2
HL10VAZ16-18		1	355	5
HL10VAZ16-43		1	140	1
HL1012AZ16-18		1	320	2
HL1012AZ16-28		1	330	1
HL1012AZ16-31		1	325A	1
HL12VAZ16-18		1	320	2
HL12VAZ16-28		1	330	1
HL12VAZ16-31		1	325A	1
HL79-14		1	220	8
		1	575	2
HL82-16APBW		1	145	1
HST10AG5-14		1	40	5
HST10AG6-12		1	100	2
HST10AG8-34		1	150	2
HST79-5		1	45	5
HST79-6		1	105	2
HST79-8		1	420	2
HST79CY5		1	45	5
HST79CY6		1	105	2
HST79CY8		1	420	2
HST82CY8APBW		1	155	2
HST828AW		1	155	2
H51560-12		1	395	4
H51650-14BAC		1	210	4
H51650-8BAC		1	400	5

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
H52732-6CM		1	265	3
K29646-8		1	370	1
K29913-8		1	365	1
K51602-3BAC		1	65	2
L802-16K18		1	320	2
L802-16K28		1	330	1
L802-16K31		1	325A	1
MF51637-3		1	90	2
MF53050-3CD		1	90	2
MK2000-3BAC		1	125	2
MS51023-138		1	235	1
NAS1149D0863J		1	385	5
NAS1149E0763P		1	218	8
NAS1149E0863P		1	360	4
NAS1805-7L		1	222	8
NAS1805-8L		1	390	4
NS103198-02		1	125	2
NS202476-02		1	65	2
NS202487-02		1	90	2
PLH56CM		1	265	3
RMA9207-3		1	125	2
SL7108C12		1	395	4
S113W102-400		1	280	1
T8077S1032		1	125	2
T8092C1032CD		1	65	2
VCU0005D12		1	395	4
VN201A1-02		1	125	2
VTB13230		1	280	1
WC331K8-10		1	415	2
102F9201-3		1	65	2
102F9201M3		1	90	2
102LH903112		1	395	4
102LH9074-14		1	210	4
102LH9074-8		1	400	5
112T1718-1		1	445	1
112T1718-2		1	455	1
112T1718-21		1	445B	1
112T1718-22		1	455B	1
112T1718-3		1	305	1
112T1718-4		1	310	1
112T1718-5		1	315	1
112T1718-6		1	450	1
112T1720-1		1	275	1
112T1721-2		1	270	1
112T1725-1		1	580	1

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**BOEING**  
 COMPONENT  
 MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
112T1726-1		1	480	1
112T1726-2		1	485	1
112T1727-1		1	490	2
112T1727-2		1	495	2
112T1728-1		1	500	1
112T1728-2		1	505	1
112T1730-101		1	560	2
112T1730-102		1	565	2
112T1730-3		1	10	2
112T1730-4		1	15	2
112T1736-15		1	1C	RF
112T1736-16		1	5B	RF
112T1736-3		1	1A	RF
112T1736-4		1	5	RF
112T1736-7		1	1B	RF
112T1736-8		1	5A	RF
112T1737-1		1	510	1
112T1737-2		1	515	1
112T1737-3		1	510A	1
112T1737-4		1	515A	1
112T1737-5		1	510B	1
112T1737-6		1	515B	1
112T1739-1		1	20	1
112T1739-2		1	25	1
112T1739-3		1	30	1
112T1739-4		1	35	1
112T1740-1		1	405	1
112T1740-2		1	410	1
112T1740-3		1	435	1
112T1740-4		1	440	1
112T1740-5		1	405A	1
112T1740-6		1	410A	1
112T1740-7		1	435A	1
112T1740-8		1	440A	1
112T1742-1		1	520	1
112T1742-2		1	525	1
112T1742-3		1	530	1
112T1742-4		1	535	1
112T1742-5		1	585	1
112T1742-6		1	587	1
112T1742-7		1	590	1
112T1742-8		1	592	1
112T1743-1		1	540	2
112T1743-2		1	545	2
112T1743-3		1	550	2

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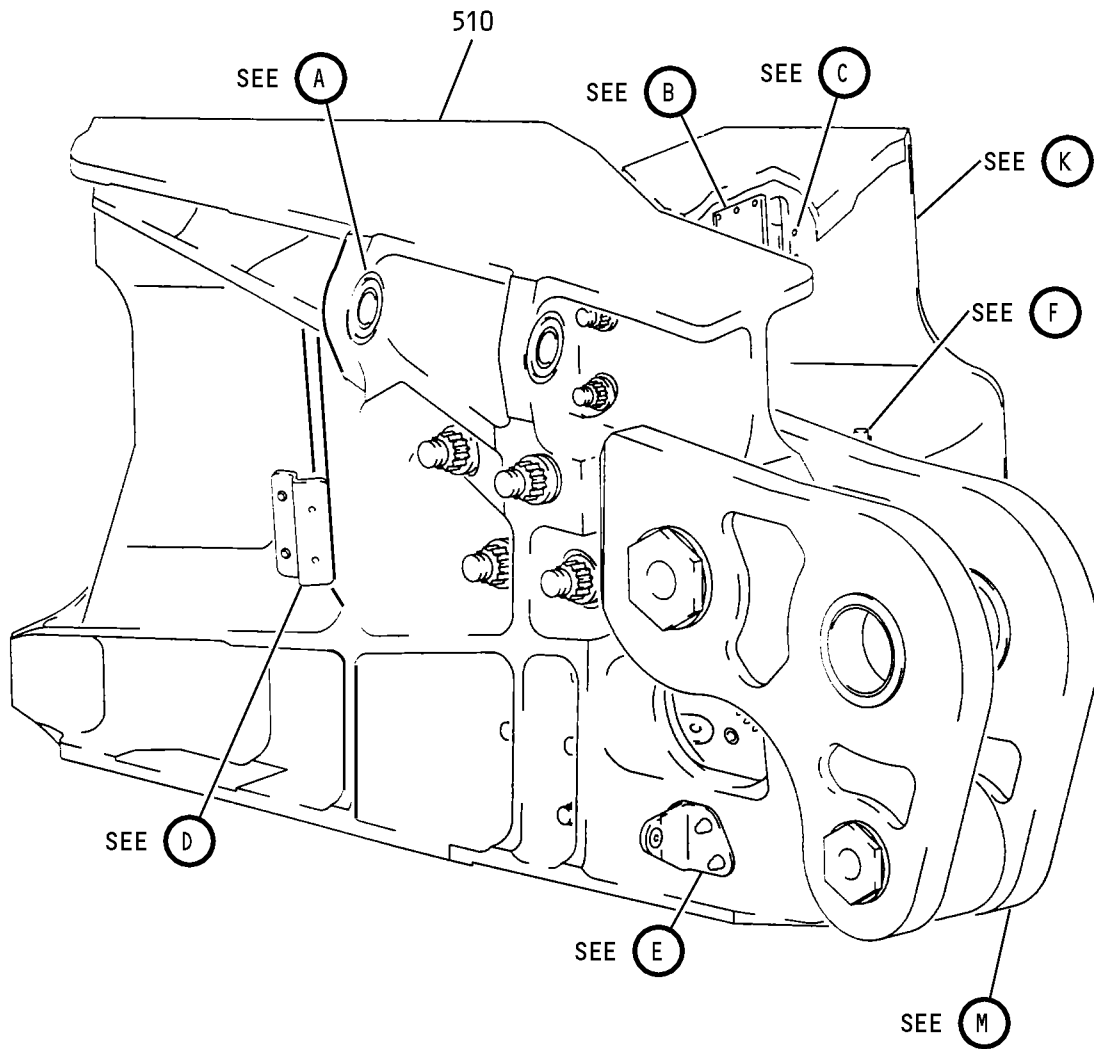
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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
112T1743-4		1	555	2
112T1745-1		1	225	1
112T1745-2		1	230	1
112T1745-3		1	295	1
112T1745-4		1	300	1
112T1745-5		1	225A	1
112T1745-6		1	230A	1
112T1745-7		1	295A	1
112T1745-8		1	300A	1
112T1748-1		1	285	1
112T1749-1		1	290	1
112T1760-1		1	425	1
112T1760-2		1	430	1
113T1992-29		1	160	1
113T1992-30		1	165	1
113T1992-31		1	180	1
113T1992-32		1	185	1
161W7010-1		1	240	1
255T1329-19		1	50	1
255T1329-20		1	55	1
255T1329-21		1	70	1
255T1329-22		1	75	1
272T1455-4		1	80	1
272T1455-5		1	95	1
287T5010-58		1	110	1
287T5010-59		1	115	1
287T5010-60		1	130	1
287T5010-61		1	135	1
66014-14		1	220	8
		1	575	2
67832CD1216		1	395	4
69235-1414CD		1	210	4
69235-820CD		1	400	5
70188-8		1	370	1
70191-8		1	365	1
922007-8		1	370	1
922008-8		1	365	1
942007-8		1	370	1
942008-8		1	365	1

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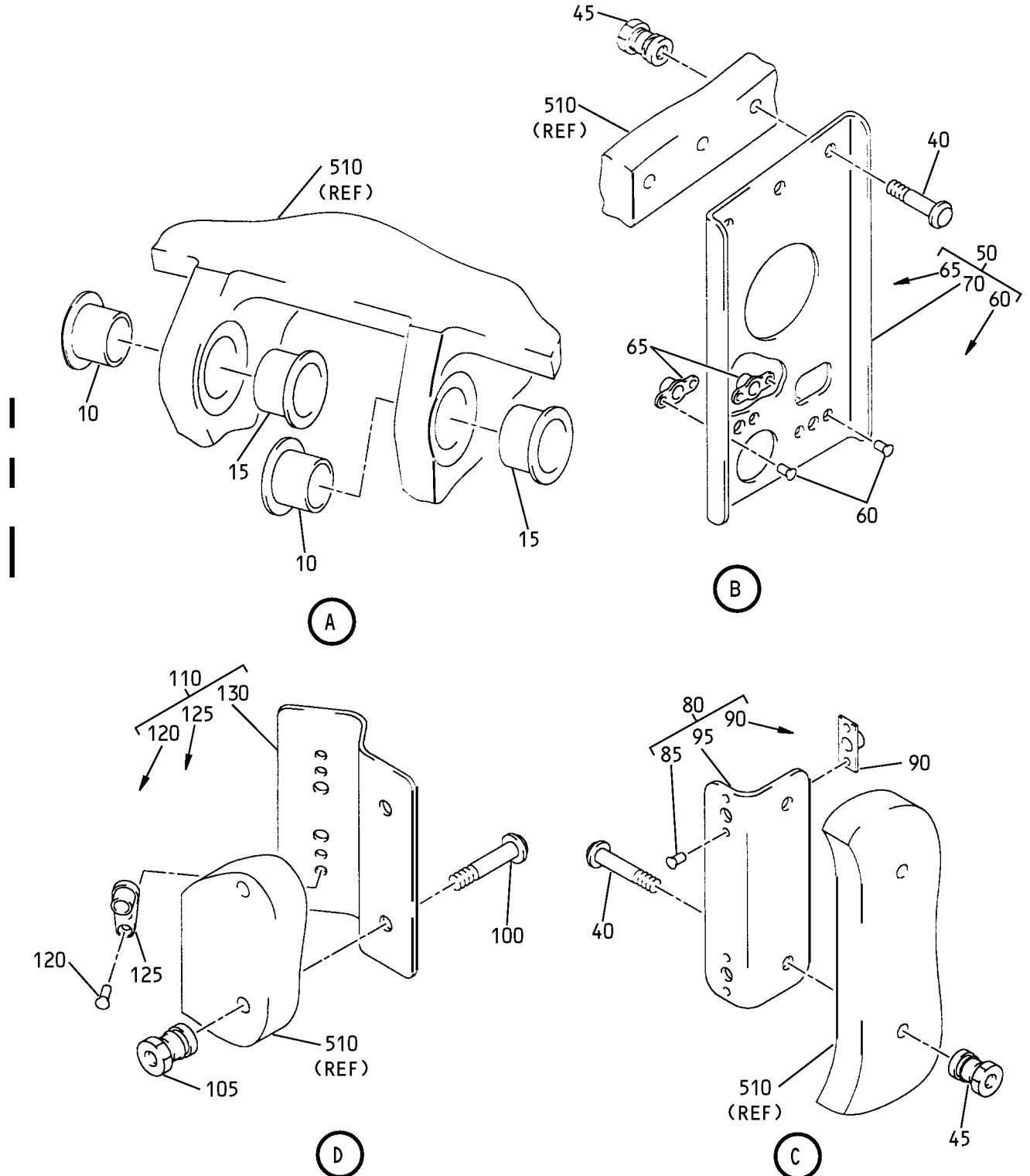




Machined Assembly – MLG Outboard Support  
Figure 1 (Sheet 1)

**57-54-39**

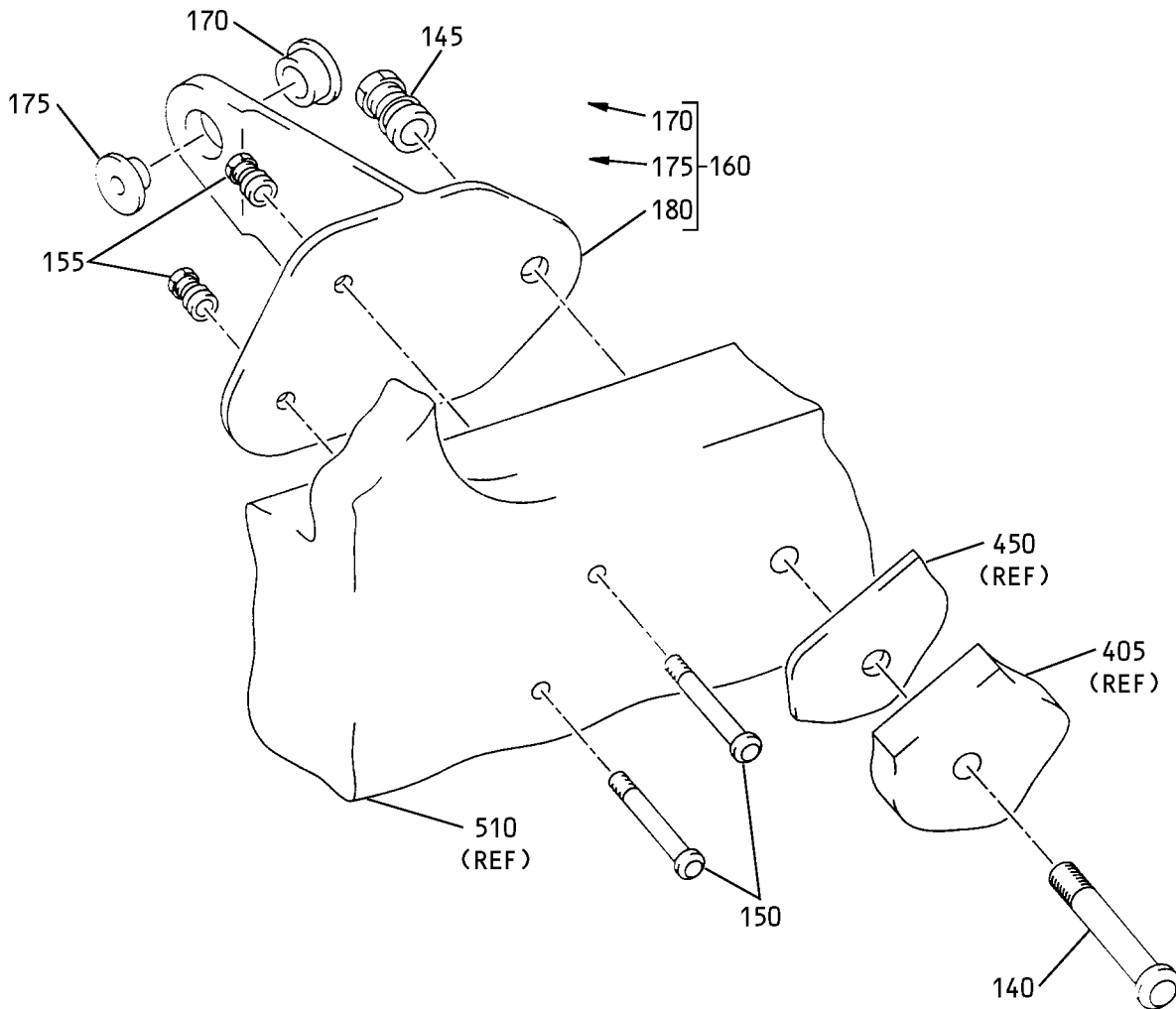
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Machined Assembly - MLG Outboard Support  
 Figure 1 (Sheet 2)

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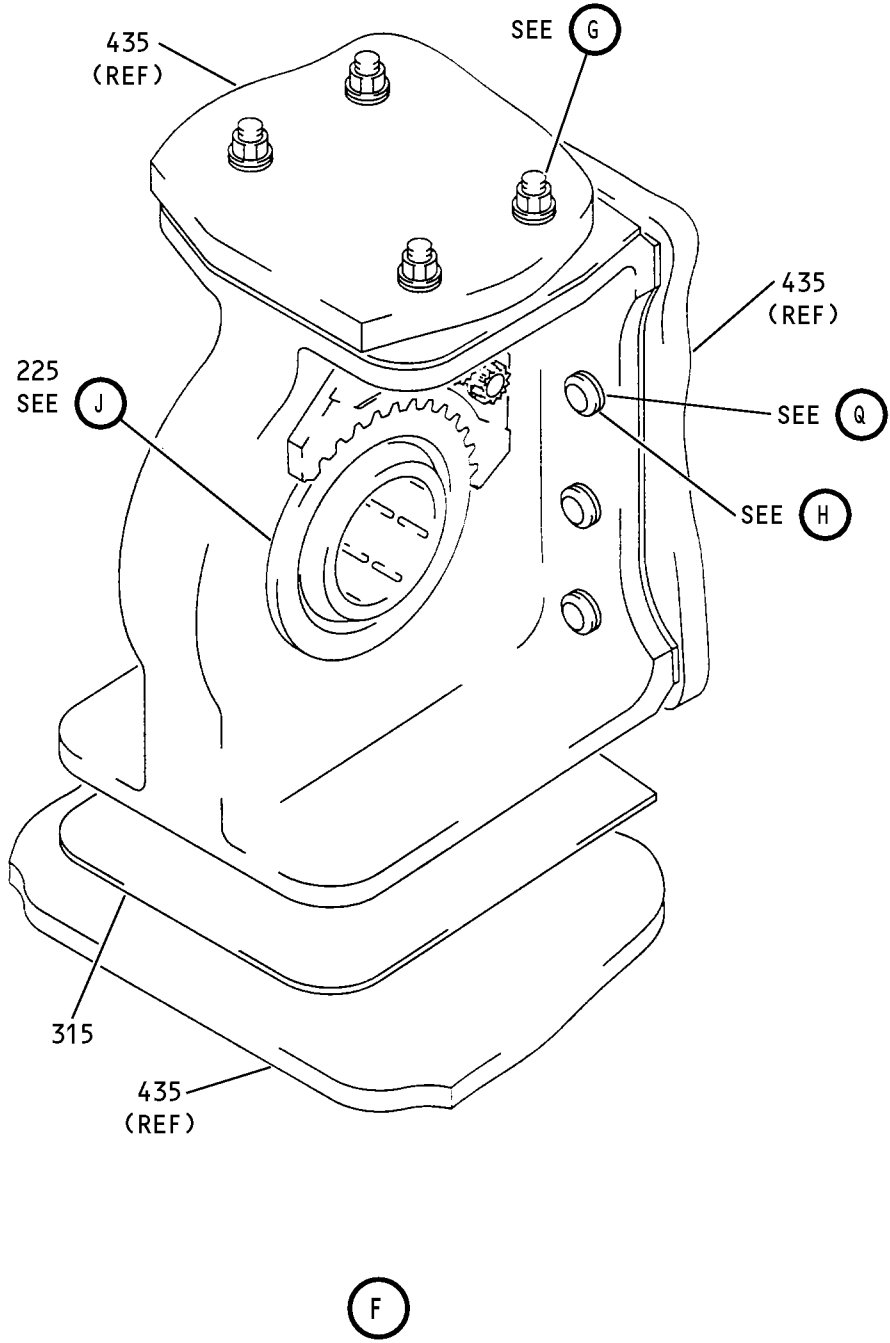
(E)

Machined Assembly - MLG Outboard Support  
 Figure 1 (Sheet 3)

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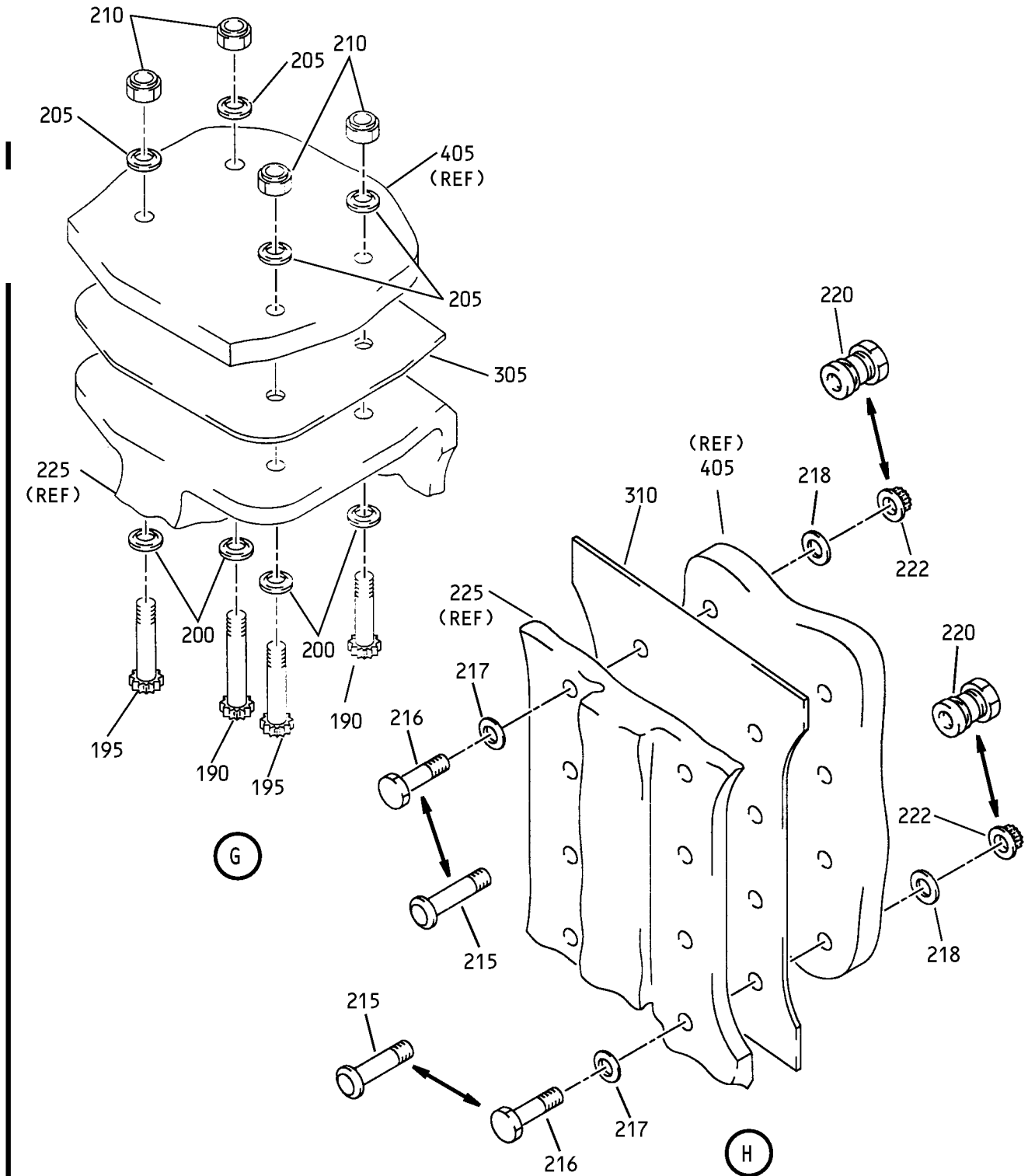
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Machined Assembly - MLG Outboard Support  
Figure 1 (Sheet 4)

**57-54-39**

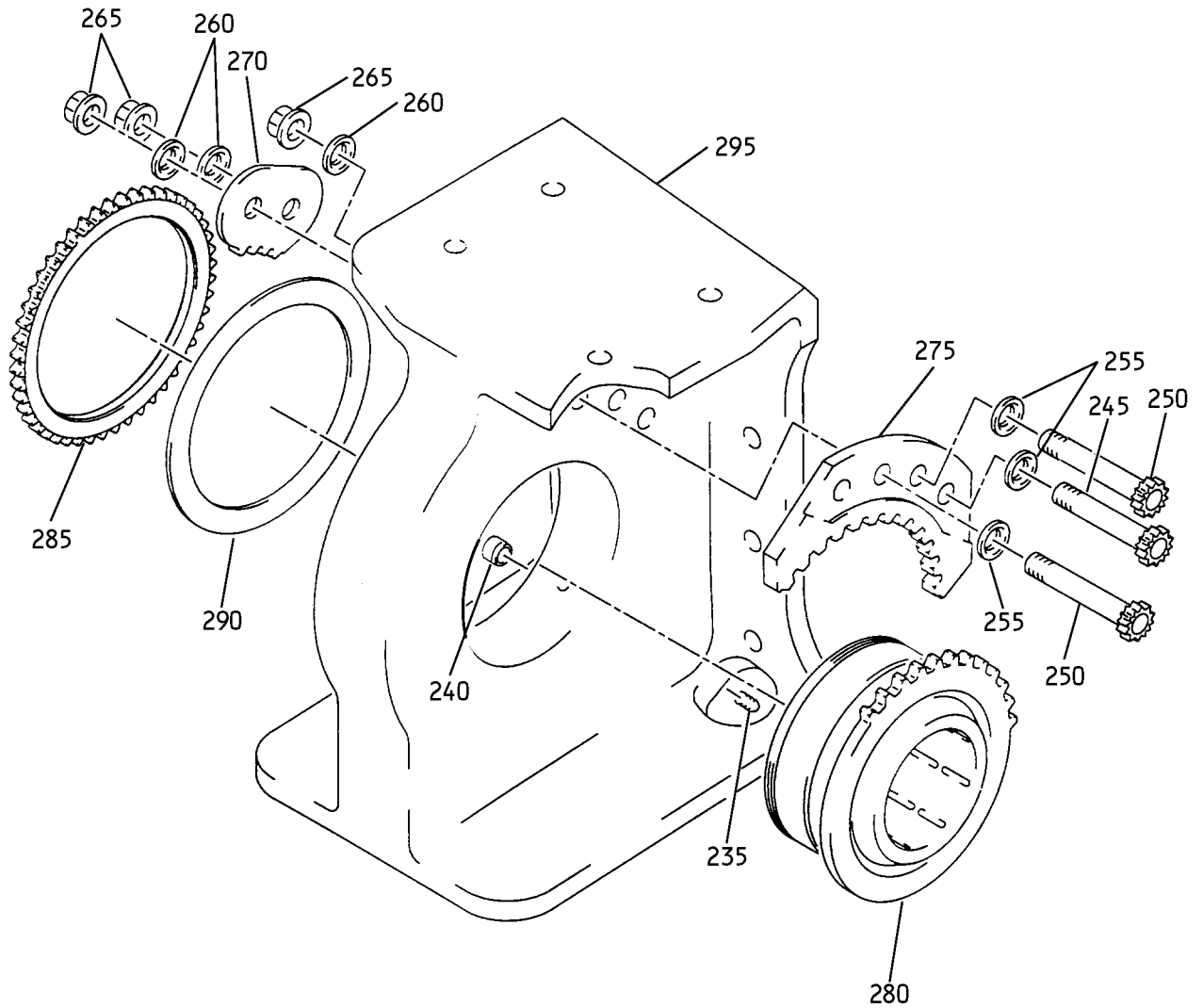
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Machined Assembly - MLG Outboard Support  
 Figure 1 (Sheet 5)

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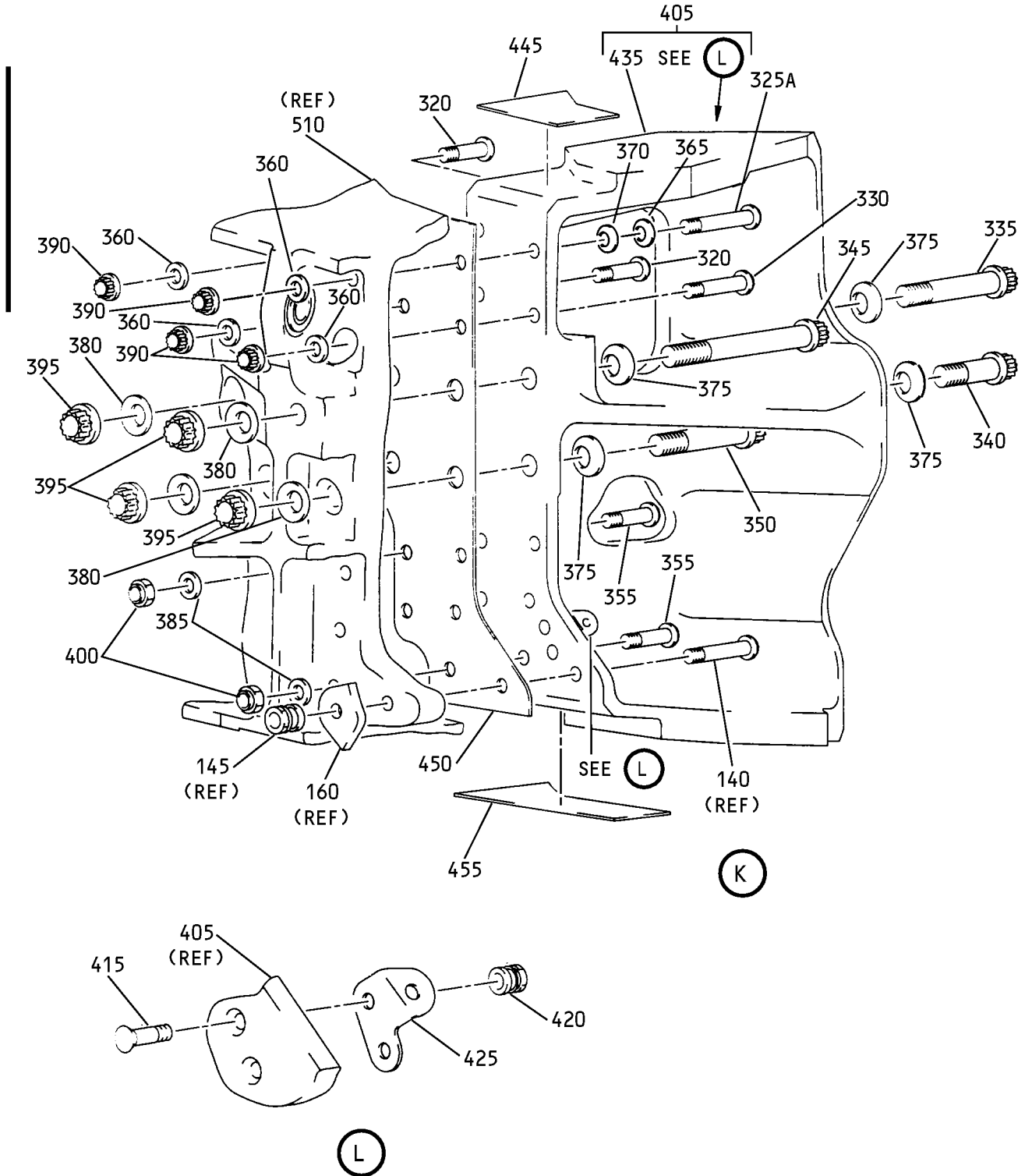


J

Machined Assembly - MLG Outboard Support  
Figure 1 (Sheet 6)

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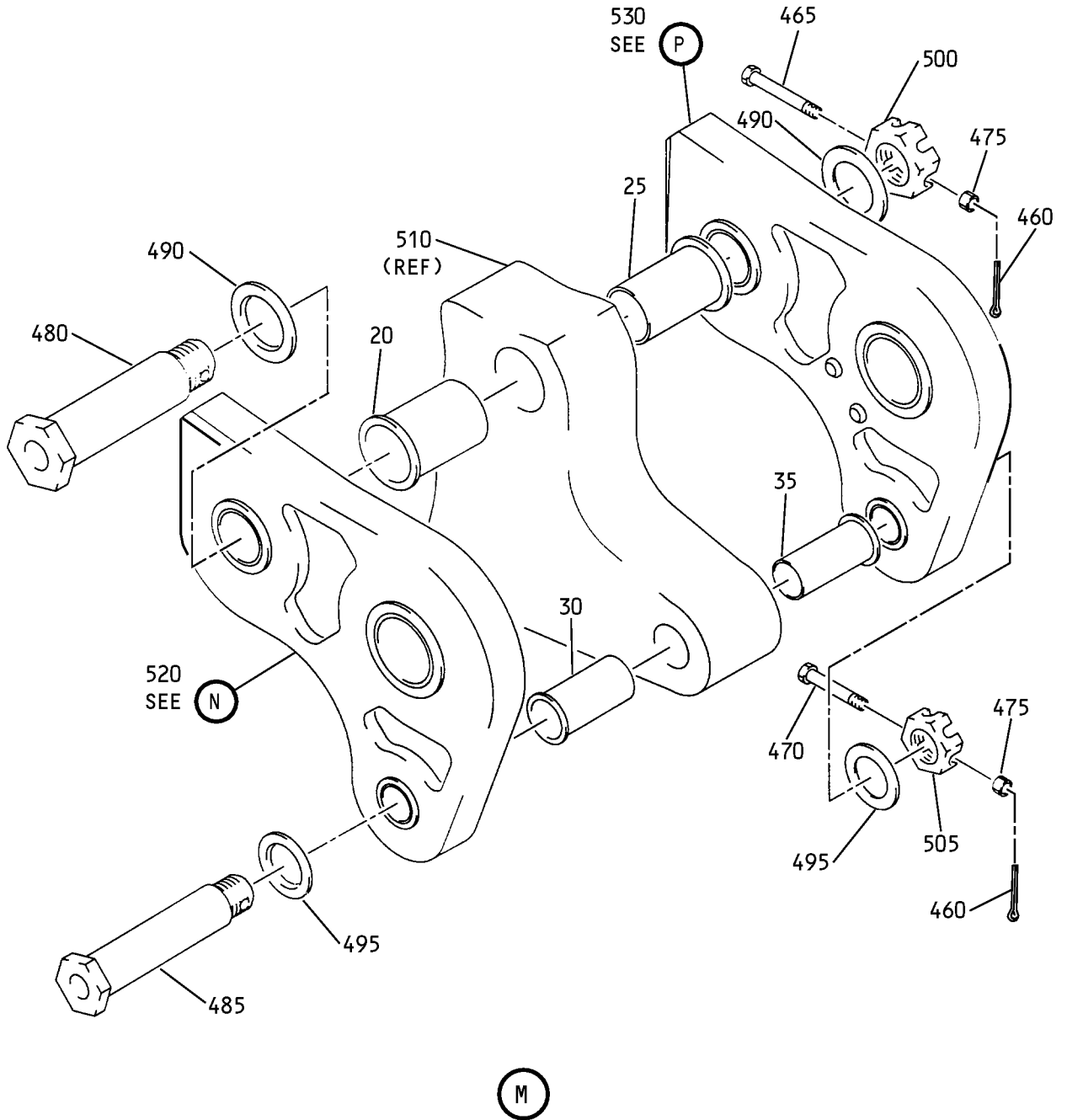
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Machined Assembly - MLG Outboard Support  
Figure 1 (Sheet 7)

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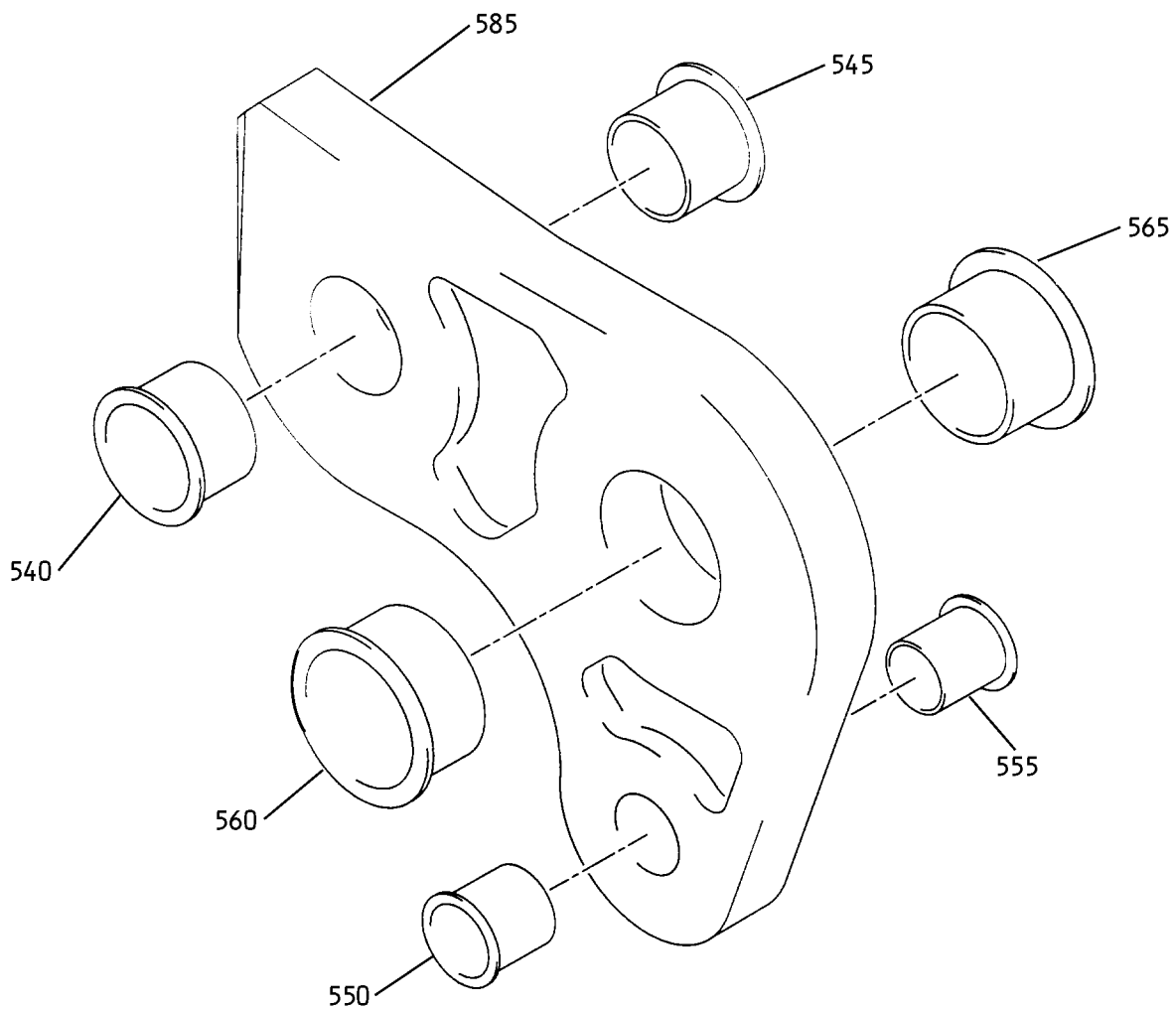


Machined Assembly - MLG Outboard Support  
 Figure 1 (Sheet 8)

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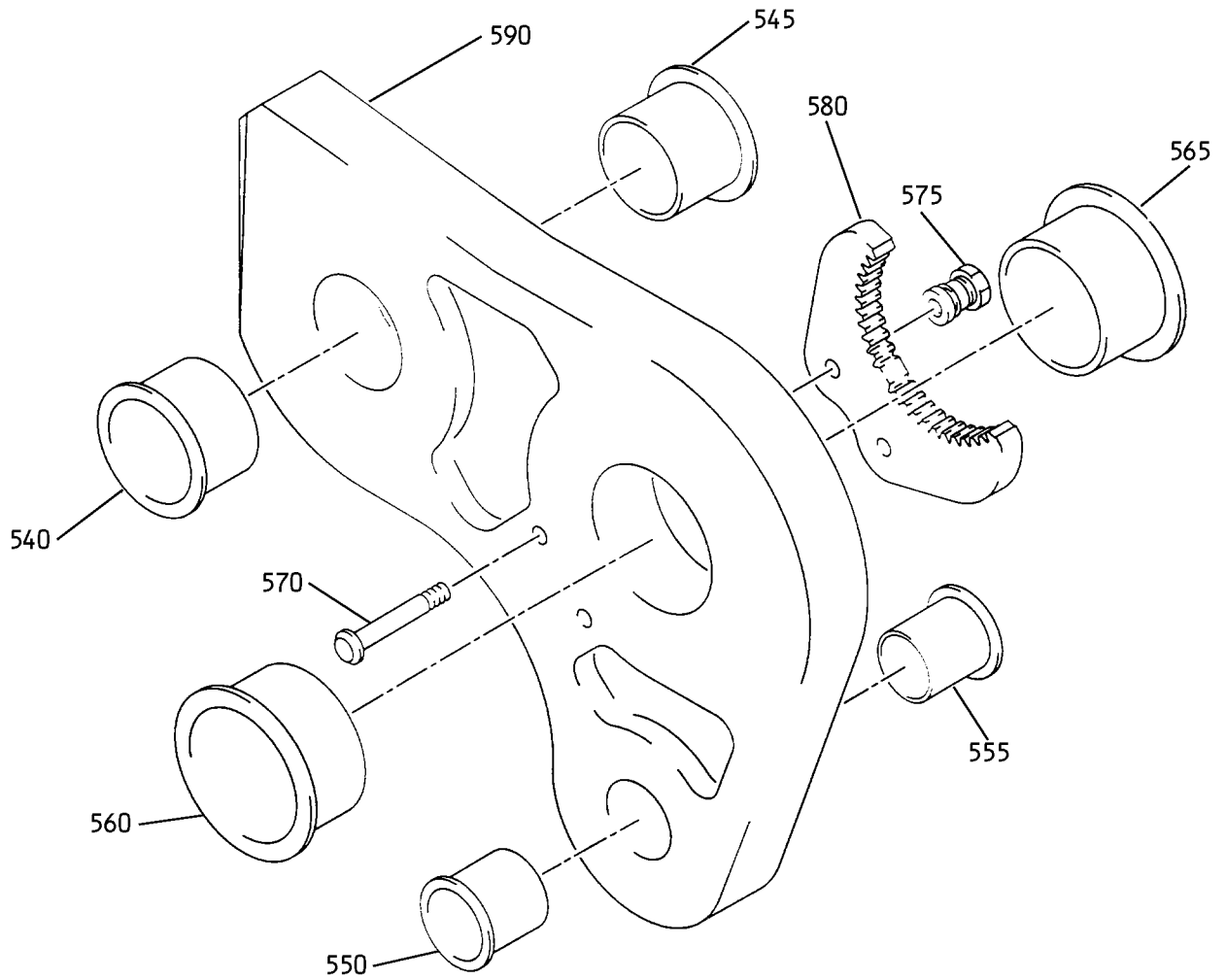


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Machined Assembly – MLG Outboard Support  
Figure 1 (Sheet 9)

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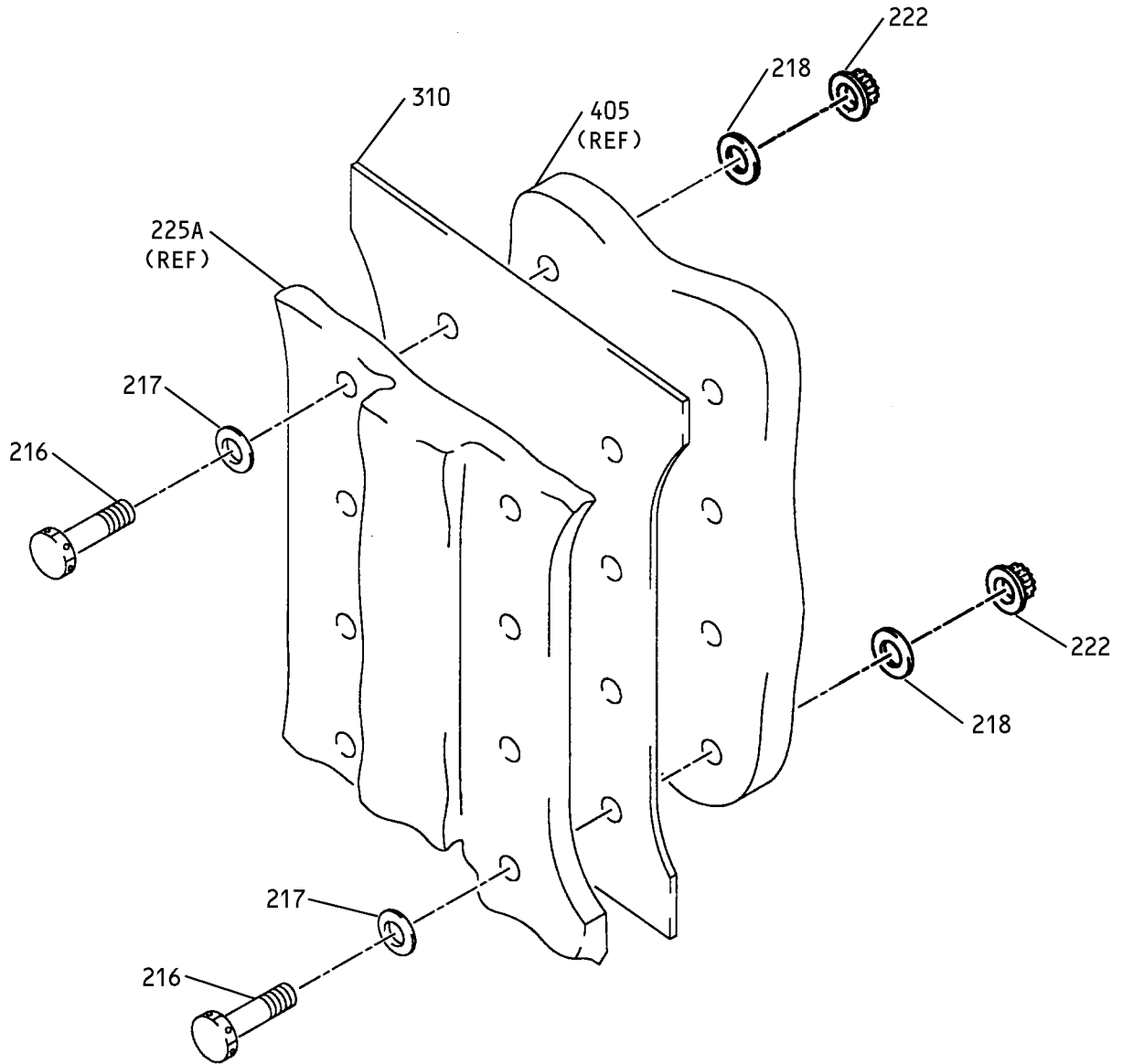


P

Machined Assembly - MLG Outboard Support  
Figure 1 (Sheet 10)

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Q

Machined Assembly - MLG Outboard Support  
Figure 1 (Sheet 11)

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**BOEING**  
 COMPONENT  
 MAINTENANCE MANUAL

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01- -1A	112T1736-3		MACHINED ASSY-MLG OUTBD SPRT	A	RF
-1B	112T1736-7		MACHINED ASSY-MLG OUTBD SPRT	C	RF
R -1C	112T1736-15		MACHINED ASSY-MLG OUTBD SPRT	E	RF
-5	112T1736-4		MACHINED ASSY-MLG OUTBD SPRT	B	RF
-5A	112T1736-8		MACHINED ASSY-MLG OUTBD SPRT	D	RF
R -5B	112T1736-16		MACHINED ASSY-MLG OUTBD SPRT	F	RF
10	112T1730-3		.BUSHING-OUTER		2
15	112T1730-4		.BUSHING-INNER		2
20	112T1739-1		.BUSHING-OUTER		1
25	112T1739-2		.BUSHING-INNER		1
30	112T1739-3		.BUSHING-OUTER		1
35	112T1739-4		.BUSHING-INNER		1
40	HST10AG5-14		.BOLT- (VOPTK6) (SPEC BACB30VT5K14) (OPT HST10AG5-14 (V06725)) (OPT HST10AG5-14 (V56878)) (OPT HST10AG5-14 (V73197))		5
45	HST79CY5		.COLLAR- (V73197) (SPEC BACC30BL5) (OPT HST79-5 (V92215)) (OPT HST79CY5 (V56878)) (OPT HST79CY5 (V5M902))		5
50	255T1329-19		.BRACKET ASSY-FAIRLEAD AIL.	A,C,E	1
-55	255T1329-20		.BRACKET ASSY-FAIRLEAD AIL.	B,D,F	1
60	BACR15BA3AD		..RIVET- (SIZE DETERMINE ON INST)		4

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-65	BRF200C3D		..NUTPLATE- (V52828) (SPEC BACN10JR3CFD) (OPT K51602-3BAC (V15653)) (OPT NS202476-02 (V80539)) (OPT 102F9201-3 (V72962)) (OPT T8092C1032CD (V11815))		2
70	255T1329-21		..BRACKET	A,C,E	1
-75	255T1329-22		..BRACKET	B,D,F	1
80	272T1455-4		.BRACKET ASSY-HYDR SPRT		1
85	BACR15BA3AD		..RIVET- (SIZE DETERMINE ON INST)		4
90	BRFM20C3D		..NUTPLATE- (V52828) (SPEC BACN10JN3CD) (OPT 102F9201M3 (V72962)) (OPT NS202487-02 (V80539)) (OPT MF51637-3 (V15653)) (OPT MF53050-3CD (V15653))		2
95	272T1455-5		..BRACKET		1
100	HST10AG6-12		.BOLT- (VOPTK6) (SPEC BACB30VT6K12) (OPT HST10AG6-12 (V06725)) (OPT HST10AG6-12 (V56878)) (OPT HST10AG6-12 (V73197))		2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-105	HST79CY6		.COLLAR- (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V92215)) (OPT HST79CY6 (V56878)) (OPT HST79CY6 (V5M902))		2
110	287T5010-58		.BRACKET ASSY-WIRING BUNDLE SPRT	A,C,E	1
-115	287T5010-59		.BRACKET ASSY-WIRING BUNDLE SPRT	B,D,F	1
120	BACR15BA3AD		..RIVET- (SIZE DETERMINE ON INST)		4
125	BRM100A3		..NUTPLATE- (V52828) (SPEC BACN10JP3B) (OPT MK2000-3BAC (V15653)) (OPT NS103198-02 (V80539)) (OPT RMA9207-3 (V72962)) (OPT VN201A1-02 (V92215)) (OPT T8077S1032 (V11815))		2
130	287T5010-60		..BRACKET	A,C,E	1
-135	287T5010-61		..BRACKET	B,D,F	1
140	HL10VAZ16-43		.BOLT- (VOPTK6) (SPEC BACB30MY16K43) (OPT HL10VAZ16-43 (V60516))		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-145	HL82-16APBW		.COLLAR- (V73197) (SPEC BACC30AG16) (OPT HL82-16APBW (V56878))		1
150	HST10AG8-34		.BOLT- (VOPTK6) (SPEC BACB30VT8K34) (OPT HST10AG8-34 (V06725)) (OPT HST10AG8-34 (V56878)) (OPT HST10AG8-34 (V73197))		2
155	HST828AW		.COLLAR- (V5M902) (SPEC BACC30BQ8) (OPT HST828AW (V56878)) (OPT HST828AW (V73197)) (OPT HST82CY8APBW (V73197)) (OPT HST82CY8APBW (V56878))		2
160	113T1992-29		.FITTING ASSY-PNL SPRT	A,C,E	1
-165	113T1992-30		.FITTING ASSY-PNL SPRT	B,D,F	1
170	BACB28AT06D023C		..BUSHING		1
175	BACB28AU04B026C		..BUSHING		1
180	113T1992-31		..FITTING	A,C,E	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-185	113T1992-32		.. FITTING	B,D,F	1
190	BACB30UU14K27		. BOLT		2
195	BACB30UU14K30		. BOLT	A,B	2
-195A	BACB30UU14K27		. BOLT	C-F	2
200	BACW10BP14ACU		. WASHER		4
205	BACW10BP14DP		. WASHER		4
210	H51650-14BAC		. NUT- (V15653) (SPEC BACN10JC14CD) (OPT 102LH9074-14 (V72962)) (OPT 69235-1414CD (V92215)) (OPT BMN4122CPD8-14 (V97928))		4
215	HL10VAZ14-17		. BOLT- (V60516) (SPEC BACB30MY14K17) (OPT B30MY14K17 (V97928))	A,B	8
216	BACB30NM7K19		. BOLT	C-F	8
217	BACW10BP7ACU		. WASHER	C-F	8
218	NAS1149E0763P		. WASHER	C-F	8
220	HL79-14		. COLLAR- (V56878) (SPEC BACC30M14) (OPT HL79-14 (V73197)) (OPT HL79-14 (V92215)) (OPT 66014-14 (V56878)) (OPT HL79-14 (V5M902))	A,B	8
222	NAS1805-7L		. NUT	C-F	8
225	112T1745-1		. FITTING ASSY-RETRACT ACTR SPRT	A	1
-225A	112T1745-5		. FITTING ASSY-RETRACT ACTR SPRT	C,E	1
-230	112T1745-2		. FITTING ASSY-RETRACT ACTR SPRT	B	1
-230A	112T1745-6		. FITTING ASSY-RETRACT ACTR SPRT	D,F	1
235	MS51023-138		.. SETSCREW		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
240	161W7010-1		..INSERT		1
245	BACB30UU6K39		..BOLT	A,B	1
-245A	BACB30UU6K38		..BOLT	C-F	1
250	BACB30UU6K41		..BOLT	A,B	2
-250A	BACB30UU6K40		..BOLT	A,B	2
255	BACW10BP6ACU		..WASHER		3
260	BACW10BP6APU		..WASHER		3
265	H52732-6CM		..NUT- (V15653) (SPEC BACN10YR6CM) (OPT PLH56CM (V62554))		3
270	112T1721-2		..RETAINER-DOG		1
275	112T1720-1		..PLATE-ANTIROTATION		1
280	VTB13230		..BEARING-SPHER (V06710) (SPEC S113W102-400)		1
285	112T1748-1		..NUT-RETAINING		1
290	112T1749-1		..WASHER		1
295	112T1745-3		..FITTING	A	1
-295A	112T1745-7		..FITTING	C,E	1
-300	112T1745-4		..FITTING	B	1
-300A	112T1745-8		..FITTING	D,F	1
305	112T1718-3		.SHIM		1
310	112T1718-4		.SHIM		1
315	112T1718-5		.SHIM		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE	EFF CODE	QTY PER ASSY
			1234567		
01-320	HL1012AZ16-18		.BOLT- (VOPTK6) (SPEC BACB30NX16K18) (OPT HL12VAZ16-18 (V73197)) (OPT HL12VAZ16-18 (V92215)) (OPT HL12VAZ16-18 (V97928)) (OPT L802-16K18 (V06725)) (OPT HL12VAZ16-18 (V56878)) (OPT HL1012AZ16-18 (V06725)) (OPT HL1012AZ16-18 (V06950)) (OPT HL1012AZ16-18 (V17446)) (OPT HL1012AZ16-18 (V56878)) (OPT HL1012AZ16-18 (V60516)) (OPT HL1012AZ16-18 (V73197)) (OPT HL1012AZ16-18 (V97928))		2
325	HL12VAZ16-30		DELETED		

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-325A	HL1012AZ16-31		.BOLT- (VOPTK6) (SPEC BACB30NX16K31) (OPT HL12VAZ16-31 (V60516)) (OPT HL12VAZ16-31 (VOPTK6)) (OPT HL12VAZ16-31 (V97928)) (OPT L802-16K31 (V06725)) (OPT HL12VAZ16-31 (V92215)) (OPT HL12VAZ16-31 (V73197)) (OPT HL12VAZ16-31 (V56878)) (OPT HL1012AZ16-31 (V56878)) (OPT HL1012AZ16-31 (V60516)) (OPT HL1012AZ16-31 (V73197)) (OPT HL1012AZ16-31 (V97928)) (OPT HL1012AZ16-31 (V06950))		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-330	HL1012AZ16-28		.BOLT- (V0PTK6) (SPEC BACB30NX16K28) (OPT HL12VAZ16-28 (V73197)) (OPT HL12VAZ16-28 (V92215)) (OPT L802-16K28 (V06725)) (OPT HL12VAZ16-28 (V97928)) (OPT HL12VAZ16-28 (V56878)) (OPT HL1012AZ16-28 (V06950)) (OPT HL1012AZ16-28 (V17446)) (OPT HL1012AZ16-28 (V56878)) (OPT HL1012AZ16-28 (V60516)) (OPT HL1012AZ16-28 (V73197)) (OPT HL1012AZ16-28 (V97928)) (OPT HL1012AZ16-28 (V06725))		1
335	BACB30US12K54		.BOLT		1
340	BACB30US12K26		.BOLT		1
345	BACB30US12K97		.BOLT		1
350	BACB30US12K48		.BOLT		1
355	HL10VAZ16-18		.BOLT- (V60516) (SPEC BACB30MY16K18) (OPT HL10VAZ16-18 (V73197))		5
360	NAS1149E0863P		.WASHER		4

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-365	K29913-8		.WASHER- (V15653) (SPEC BACW10CA8CC) (OPT 70191-8 (V56878)) (OPT 922008-8 (V60119)) (OPT 942008-8 (V60119))		1
370	K29646-8		.WASHER- (V15653) (SPEC BACW10CA8CV) (OPT 70188-8 (V56878)) (OPT 922007-8 (V60119)) (OPT 942007-8 (V60119))		1
375	BACW10BP12CD		.WASHER		4
380	BACW10BP12DP		.WASHER		4
385	NAS1149D0863J		.WASHER		5
390	NAS1805-8L		.NUT		4
395	CR603012		.NUT- (V62554) (SPEC BACN10HR12CD) (OPT H51560-12 (V15653)) (OPT 67832CD1216 (V56878)) (OPT BMN10HRCWD3-12 (V97928)) (OPT SL7108C12 (V11815)) (OPT VCU0005D12 (V06710)) (OPT 102LH903112 (V72962))		4

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-400	H51650-8BAC		.NUT- (V15653) (SPEC BACN10JC8CD) (OPT 102LH9074-8 (V72962)) (OPT 69235-820CD (V92215)) (OPT BMN4122CPD8-8 (V97928))		5
405	112T1740-1		.FITTING ASSY-BRIDGE	A	1
-405A	112T1740-5		.FITTING ASSY-BRIDGE	C,E	1
-410	112T1740-2		.FITTING ASSY-BRIDGE	B	1
-410A	112T1740-6		.FITTING ASSY-BRIDGE	D,F	1
415	WC331K8-10		..BOLT- (V60516) (SPEC BACB30YP8K10)		2
420	HST79CY8		..COLLAR- (V73197) (SPEC BACC30BL8) (OPT HST79-8 (V92215)) (OPT HST79CY8 (V56878)) (OPT HST79CY8 (V5M902))		2
425	112T1760-1		..CLIP	A,C,E	1
-430	112T1760-2		..CLIP	B,D,F	1
435	112T1740-3		..FITTING	A	1
-435A	112T1740-7		..FITTING	C,E	1
-440	112T1740-4		..FITTING	B	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-440A	112T1740-8		..FITTING	D,F	1
445	112T1718-1		.SHIM	A,B	1
-445A	112T1718-1		.SHIM-	C-F	1
			(OPT ITEM 445B)		
-445B	112T1718-21		.SHIM-	C-F	1
			(OPT ITEM 445A)		
450	112T1718-6		.SHIM		AR
455	112T1718-2		.SHIM	A,B	1
-455A	112T1718-2		.SHIM-	C-F	1
			(OPT ITEM 455B)		
-455B	112T1718-22		.SHIM-	C-F	1
			(OPT ITEM 455A)		
460	BACP18BC02A06P		.PIN-COTTER		2
465	BACB30NR4DK48		.BOLT		1
470	BACB30NR4DK36		.BOLT		1
475	BACN10JC4CM		.NUT		2
480	112T1726-1		.PIN-FUSE		1
485	112T1726-2		.PIN-FUSE		1
490	112T1727-1		.WASHER		2
495	112T1727-2		.WASHER		2
500	112T1728-1		.NUT-FUSE PIN		1
505	112T1728-2		.NUT-FUSE PIN		1
510	112T1737-1		.FITTING-MINI, CANTILEVER	A	1
-510A	112T1737-3		.FITTING-MINI, CANTILEVER	C	1
R -510B	112T1737-5		.FITTING-MINI, CANTILEVER	E	1
-515	112T1737-2		.FITTING-MINI, CANTILEVER	B	1
-515A	112T1737-4		.FITTING-MINI, CANTILEVER	D	1
R -515B	112T1737-6		.FITTING-MINI, CANTILEVER	F	1
520	112T1742-1		.PLATE ASSY-AFT	A,C,E	1
-525	112T1742-2		.PLATE ASSY-AFT	B,D,F	1
530	112T1742-3		.PLATE ASSY-FWD	A,C,E	1
-535	112T1742-4		.PLATE ASSY-FWD	B,D,F	1
540	112T1743-1		..BUSHING		1
545	112T1743-2		..BUSHING		1
550	112T1743-3		..BUSHING		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
555	112T1743-4		..BUSHING		1
560	112T1730-101		..BUSHING		1
565	112T1730-102		..BUSHING		1
570	HL10VAZ14-26		..BOLT- (V60516) (SPEC BACB30MY14K26) (OPT B30MY14K26 (V97928)) (USED ON ITEMS 530, 535)		2
575	HL79-14		..COLLAR- (V56878) (SPEC BACC30M14) (OPT HL79-14 (V73197)) (OPT HL79-14 (V92215)) (OPT 66014-14 (V56878)) (OPT HL79-14 (V5M902)) (USED ON ITEMS 530, 535)		2
580	112T1725-1		..PLATE- (USED ON ITEMS 530, 535)		1
585	112T1742-5		..PLATE- (USED ON ITEM 520)	A,C,E	1
-587	112T1742-6		..PLATE- (USED ON ITEM 525)	B,D,F	1
590	112T1742-7		..PLATE- (USED ON ITEM 530)	A,C,E	1
-592	112T1742-8		..PLATE- (USED ON ITEM 535)	B,D,F	1

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