BOEING

COMPONENT
MAINTENANCE MANUAL

MAIN LANDING GEAR BEAM ASSEMBLY

PART NUMBERS 113T1116-1,-2

COMPONENT MAINTENANCE MANUAL
WITH
ILLUSTRATED PARTS LIST

K21873

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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*[1] Not Applicable.

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

INTRODUCTION

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

This manual is divided into separate sections:

1. Title Page
2. Record of Revisions
3. Temporary 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:

MAIN LANDING GEAR BEAM ASSEMBLY

DESCRIPTION AND OPERATION

1. Description

   A. The main landing gear beam assembly consists of a beam with several bushings in it. There is also several fitting assemblies mounted on the beam.

2. Operation

   A. The main landing gear beam assembly provides structural support for the landing gear and fixed trailing edge structure.

3. Leading Particulars (Approximate)

   A. Length -- 135 inches

   B. Width -- 10 inches

   C. Height -- 20 inches

   D. Weight -- 480 pounds

CHECK

1. General

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

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

   C. Refer to the Standard Overhaul Practices Manual (SOPM) for details of the SOPM chapters identified in this procedure.

   D. Refer to IPL Fig. 1 and 2 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 shows possible damage or if you suspect possible damage on the parts listed below:

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

         (a) Fitting (IPL Fig. 1; 490), (IPL Fig. 2; 135)

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

	ITEM NUMBER	
PART	IPL FIG. 1	IPL FIG. 2
Fittings	225 445 415 705 720 785 335 340 540 750 930 975	220 380 425 275 290 325 70 75 185 250 475 915
Beam	945	815

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
113T1005	FITTING ASSEMBLY	2-1, 2-2
113T1116	MAIN LANDING GEAR BEAM ASSEMBLY	3-1
113T1117	MAIN LANDING GEAR BEAM	3-2
113T1122	FITTING ASSEMBLY	4-1, 4-2
113T1123	FITTING ASSEMBLY	5-1, 5-2
113T1126	FITTING ASSEMBLY	6-1, 6-2
113T1155	FITTING ASSEMBLY	7-1, 7-2
113T1156	FITTING ASSEMBLY	8-1, 8-2
113T1157	FITTING ASSEMBLY	9-1, 9-2
113T1158	FITTING ASSEMBLY	10-1, 10-2
113T1160	FITTING ASSEMBLY	11-1, 11-2

2. Dimensioning Symbols

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

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

EXAMPLES

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

True Position Dimensioning Symbols
Figure 601

K21875

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 chapters identified in this procedure.

   C. Refer to IPL Fig. 1 and 2 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) 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 20-43-01, Chromic Acid Anodize

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

   D. Procedure

IPL FIG. & ITEM	MATERIAL	FINISH
IPL Fig. 1 Support Fitting (IPL Fig. 1; 975) (IPL Fig. 2; 915)	Aluminum alloy	Boric acid sulfuric acid anodize (F-17.31). Apply BMS 10-11, Type 1 primer (F-20.02). No primer in bolt holes.

Refinish Details
Table 601

FITTING ASSEMBLY - REPAIR 2-1

113T1005-7, -8

1. General

   A. This repair gives the data that is necessary to repair the fitting assembly (IPL Fig. 1; 210) and (IPL Fig. 2; 205).

   B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices shown in the repair.

   C. Refer to the REPAIR - GENERAL (57-54-41/601, REPAIR - GENERAL) for the Standard True Position Dimensioning Symbols shown in the repair.

   D. Refer to IPL Fig. 1 and 2 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 Removal, Installation and Retention

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

   C. Procedure

      (1) Replace the bushings in the fitting assemblies.

         (a) Remove the bushings (IPL Fig. 1; 215, 220) from the fitting assembly (IPL Fig. 1; 210).

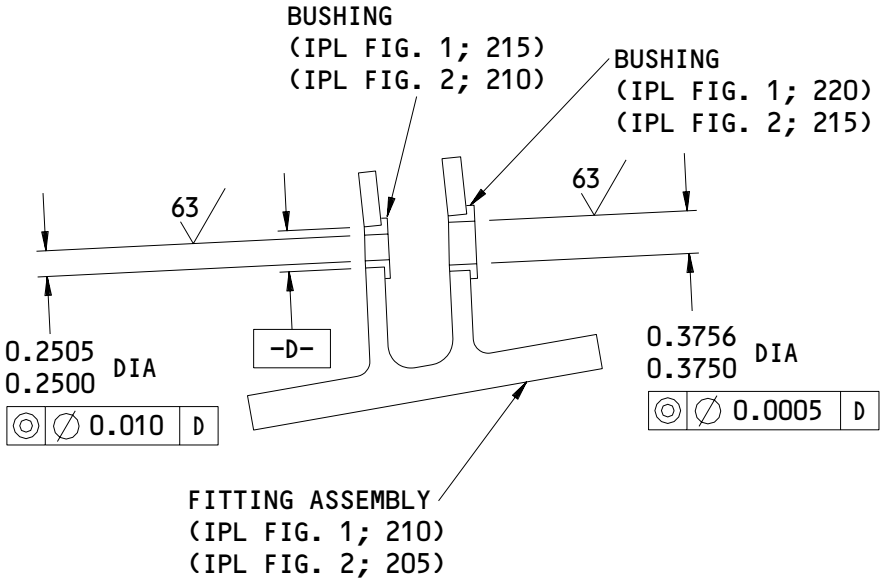
         (b) Remove the bushings (IPL Fig. 2; 210, 215) from the fitting assembly (IPL Fig. 2; 205).

         (c) Install the bushing into the fittings with BMS 5-95 sealant and as shown in the SOPM 20-50-03.

         (d) Machine the bushings inside diameter to the dimensions and finish shown in Fig. 601.

(e) Break all sharp edges to a radius of 0.01-0.02 inch.

(f) Fillet seal around the flanges of the bushings using BMS 5-95 sealant.



125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

113T1005-7,-8
Fitting Assembly Repair
Figure 601

K21885

FITTING - REPAIR 2-2

113T1005-9, -10

1. General

A. This repair gives the data that is necessary to repair and refinish the fitting (IPL Fig. 1; 225), (IPL Fig. 2; 220).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices shown in the repair.

C. Refer to the REPAIR - GENERAL (57-54-41/601, REPAIR - GENERAL) for the Standard True Position Dimensioning Symbols shown in the repair.

D. Refer to IPL Fig. 1 and 2 for item numbers.

E. General repair details:

(1) Material: Aluminum alloy

(2) Shot peen: Intensity 0.010A
Coverage 2.0

2. Bushing Hole Repair

A. References

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

(2) SOPM 20-20-01, Magnetic Particle Inspection

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

(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 the worn or damaged hole for the bushings (IPL Fig. 1; 215, 220), (IPL Fig. 2; 210, 215) as necessary, to remove defects, cracks, and/or corrosion up to the limit shown in Fig. 601.

(2) Break all the sharp edges to a radius of 0.005-0.010 inch.

(3) Do a penetrant check as shown in the SOPM 20-20-02.

(4) Shot peen the machined area as shown in the SOPM 20-10-03.

(5) Machine the hole to the finish shown in Fig. 601.

(6) Oversize bushings

(a) Make the repair bushing for bushing (IPL Fig. 1; 215), (IPL Fig. 2; 210) as shown in Fig. 602 and in the following instructions.

1) Bushing Material: 15-5PH, AMS 5659, 40-43 HRC or 17-4PH, AMS 5643, 40-43 HRC

2) Break all the sharp edges.

3) Do a magnetic particle check as shown in SOPM 20-20-01.

4) Prepare the surface and cadmium plate (F-15.06) as shown in SOPM 20-42-05.

5) Be sure the interference between the bushing O. D. and the oversize hole I. D. is as shown in Fig. 602.

6) Install the oversize repair bushing as shown in REPAIR 2-1.

(b) Make the repair bushing for bushing (IPL Fig. 1; 220), (IPL Fig. 2; 215) as shown in Fig. 603 and in the following instructions.

1) Bushing Material: AL-Ni-Bronze, AMS 4640

2) Break all the sharp edges.

3) Do a penetrant check as shown in SOPM 20-20-02.

4) Prepare the surface and cadmium plate (F-15.06) as shown in SOPM 20-42-05.

5) Be sure the interference between the bushing O. D. and the oversize hole I. D. is as shown in Fig. 603.

6) Install the oversize repair bushing as shown in REPAIR 2-1.

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

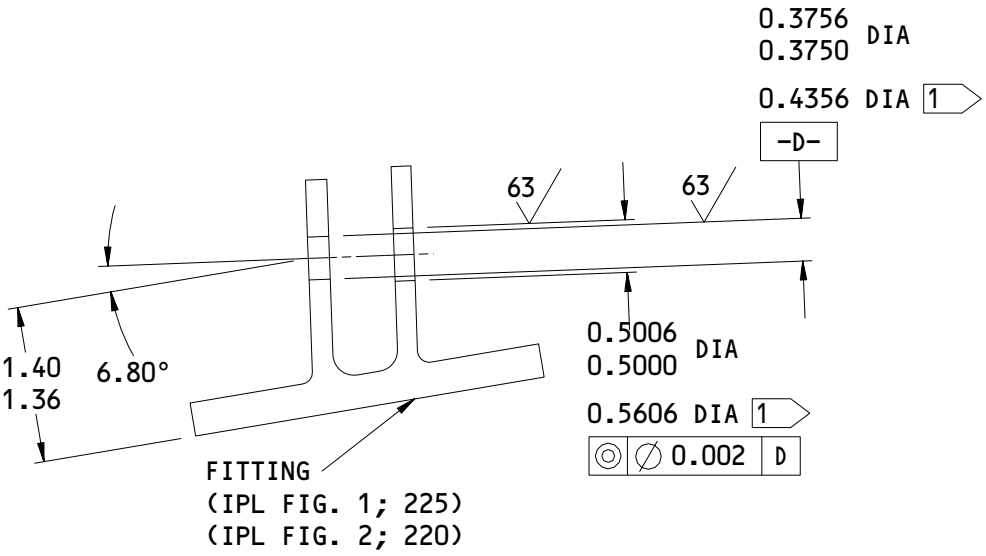
(3) SOPM 20-41-02, Application of Chemical and Solvent Resistant Finishes

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

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

C. Procedure

(1) Chromic acid anodize and apply BMS 10-11, Type 1 primer (F-18.13). No primer in bushing bores.



1 REPAIR LIMIT

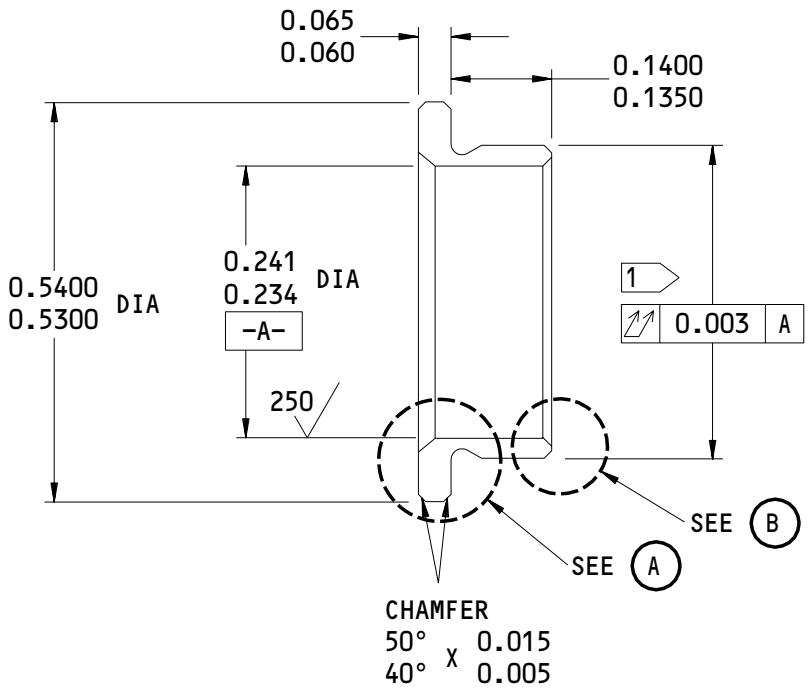
125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

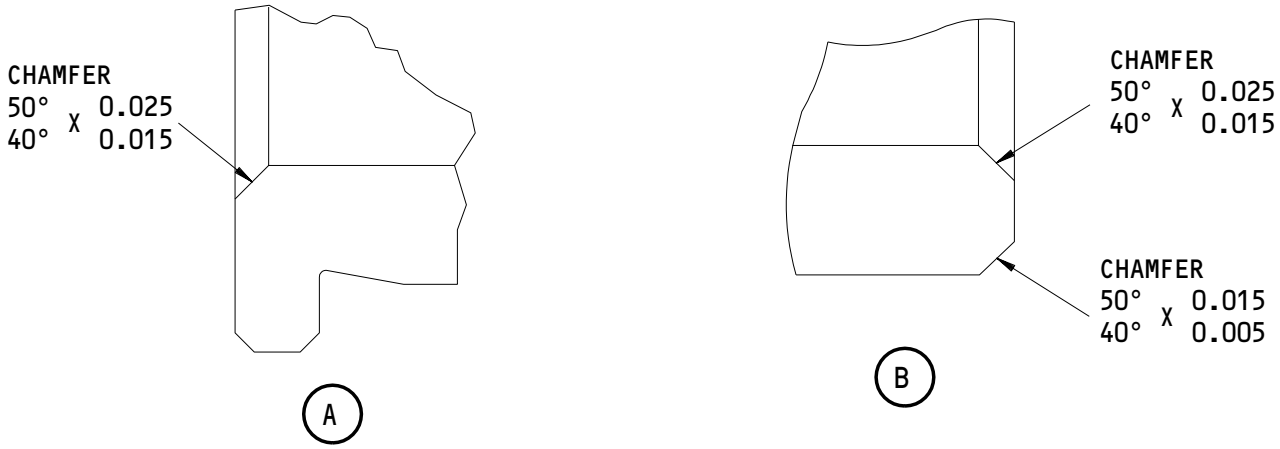
ALL DIMENSIONS ARE IN INCHES

113T1005-9,-10
Fitting Repair
Figure 601

K21929



OVERSIZE REPLACEMENT BUSHING
(IPL FIG. 1; 215)
(IPL FIG. 2; 210)



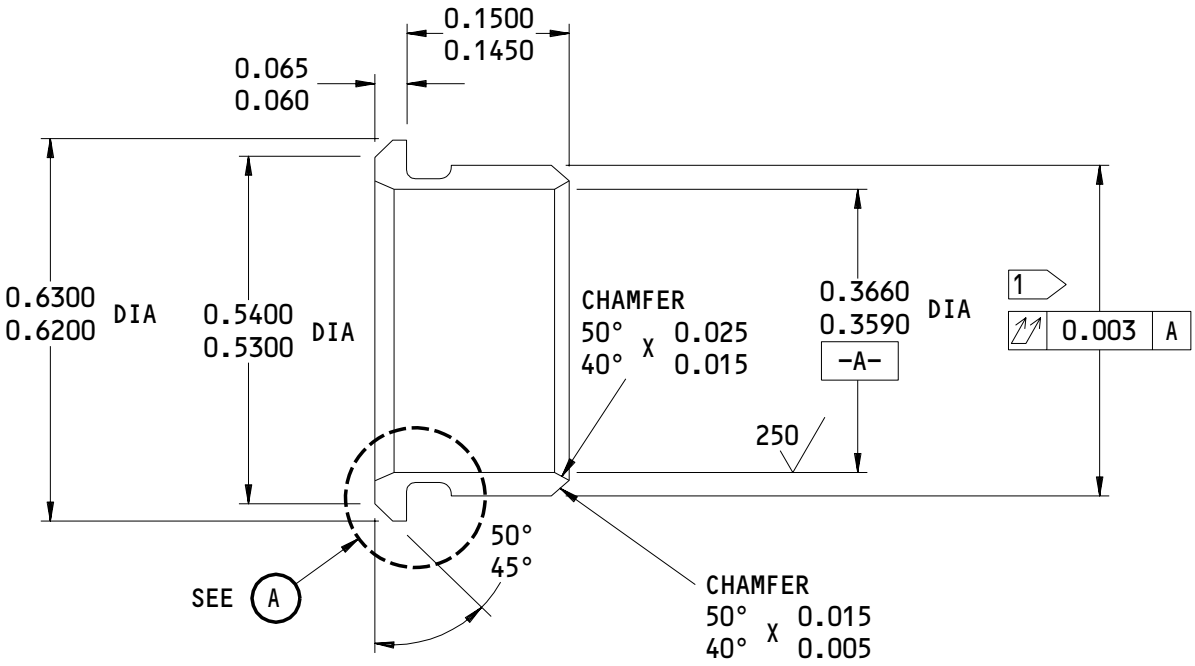
1 THE OUTSIDE DIAMETER OF THE BUSHING IS EQUAL TO THE FITTING HOLE PLUS INTERFERENCE 0.0003-0.0014

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

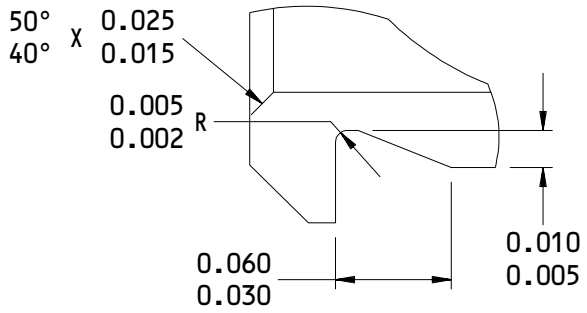
ALL DIMENSIONS ARE IN INCHES

Repair Bushing Details
Figure 602

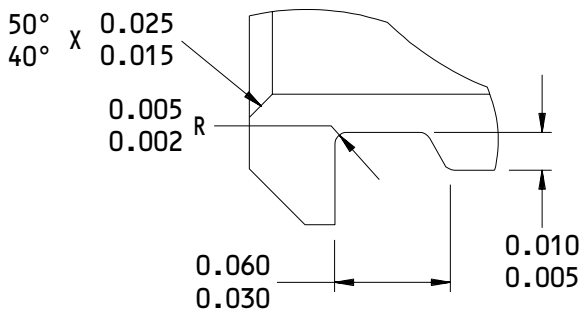
K21949



OVERSIZE REPLACEMENT BUSHING
(IPL FIG. 1; 220)
(IPL FIG. 2; 215)



TYPE 1



TYPE 2

A

1 THE OUTSIDE DIAMETER OF THE BUSHING IS EQUAL TO THE FITTING HOLE PLUS INTERFERENCE 0.0004-0.0016

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

ALL DIMENSIONS ARE IN INCHES

Repair Bushing Details
Figure 603

K21966

MAIN LANDING GEAR BEAM ASSEMBLY - REPAIR 3-1

113T1116-1, -2

1. General

   A. This repair gives the data that is necessary to replace the bushings in the main landing gear beam assembly.

   B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices shown in the repair.

   C. Refer to the REPAIR - GENERAL (57-54-41/601, REPAIR -GENERAL) for the standard true position dimensioning symbols shown in the repair.

   D. Refer to the IPL Fig. 1 and 2 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 of Boeing Finish Codes

      (2) SOPM 20-50-03, Bearing Removal, Installation and Retention

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

   C. Procedure

      (1) Replace the bushings (IPL Fig. 1; 10, 15 , 20, 25, 30, 35, 675, 680), (IPL Fig. 2; 10, 15, 20, 25, 30, 35, 430, 435) in the beam assembly, as shown in Fig. 601.

         (a) Remove the bushings from the beam assembly.

         (b) Install the bushings into the beam assembly by the shrink-fit method, with BMS 5-95 sealent, as shown in The (SOPM 20-50-03) and Fig. 601.

(c) Machine the bushings.

1) For the bushings (IPL Fig. 1; 30), (IPL Fig. 2; 15).

a) Wet hone the bushing inner diameter with oil lubricant to obtain the final dimensions and finish shown in Fig. 601.

2) For the bushings (IPL Fig. 1; 10, 15, 20, 25, 30, 35, 675, 680), (IPL Fig. 2; 10, 20, 25, 30, 35, 430, 435).

a) Machine the inside diameters to the dimensions and finish shown in Fig. 601.

(d) Break all the sharp edges.

(e) Fillet seal around the bushing flanges with BMS 5-95 sealant after all paint applications are completed. Apply BMS 10-60 enamel (SRF-14.9813) over sealant. Bushing bores must be free of enamel.

3. Refinish

A. Consumable Materials

(1) C00032 Enamel -- BMS 10-60 (SOPM 20-60-02)

(2) C00259 Primer -- BMS 10-11 (SOPM 20-60-02)

B. References

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

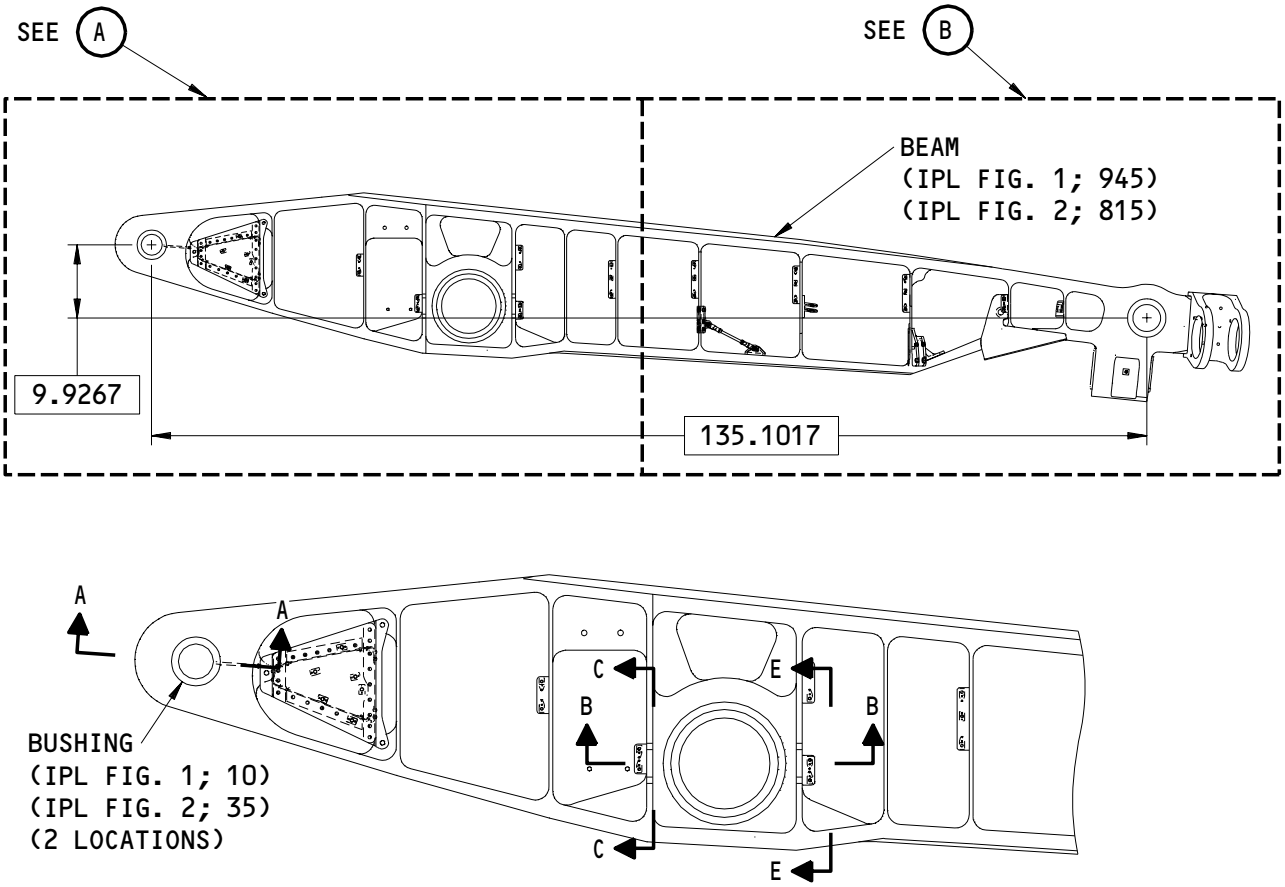
(2) SOPM 20-41-01, Decoding Table of Boeing Finish Codes

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

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

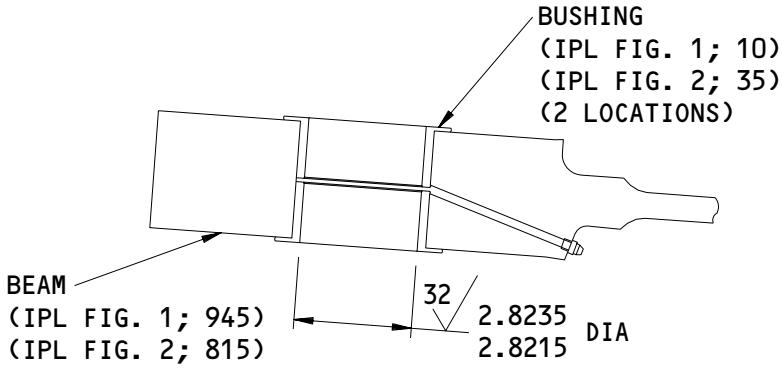
C. Procedure

(1) Apply BMS 10-11, type 1 primer (SRF-14.995) plus BMS 10-60 enamel (SRF-14.9813). Do not apply primer or enamel to bushing inner diameters.

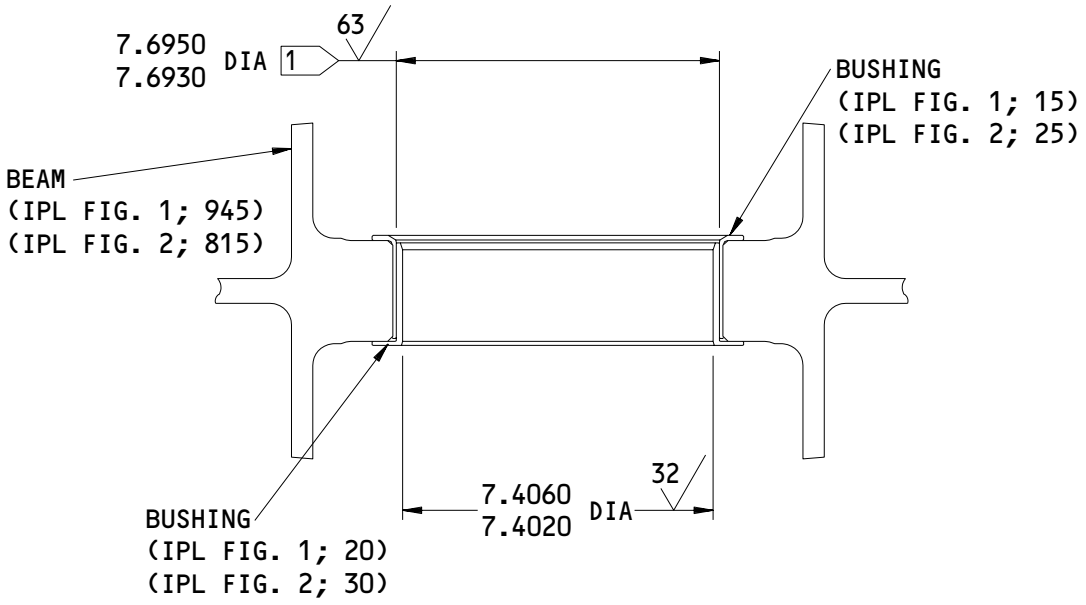


113T1116-1,-2
Main Landing Gear Beam Assembly Repair
Figure 601 (Sheet 1)

K22120



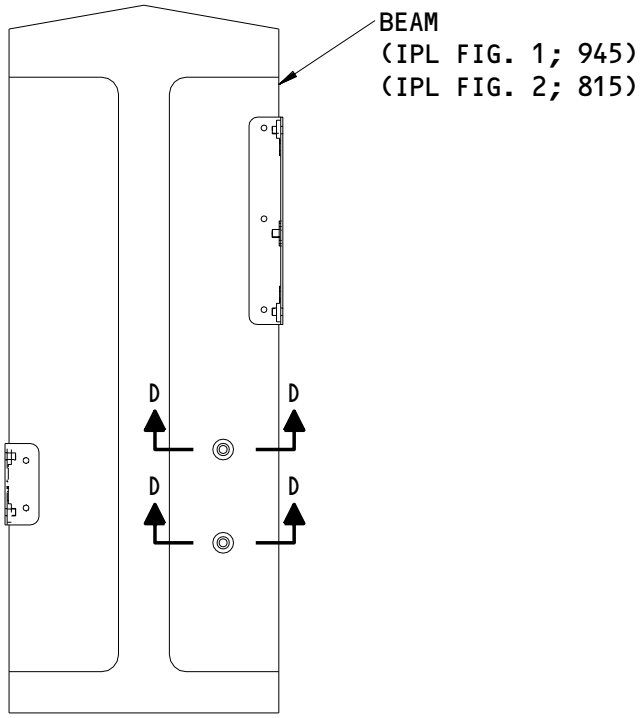
A–A



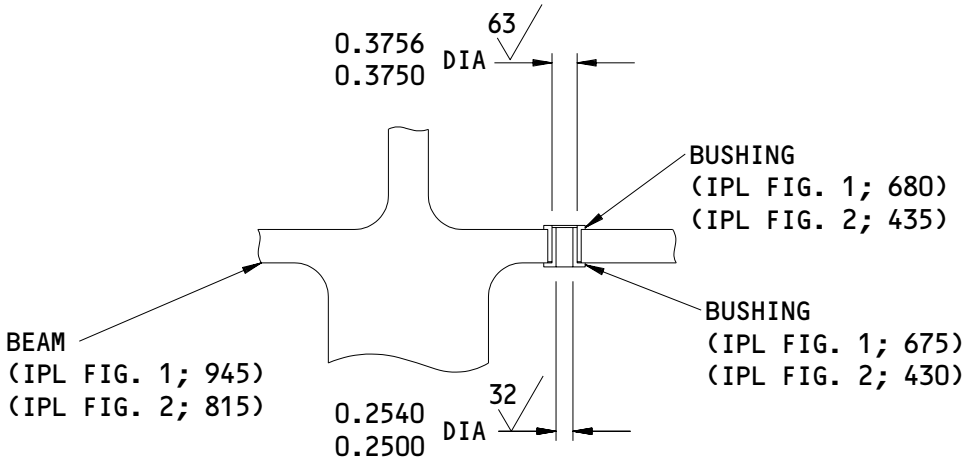
B–B

113T1116-1,-2
Main Landing Gear Beam Assembly Repair
Figure 601 (Sheet 2)

K22142



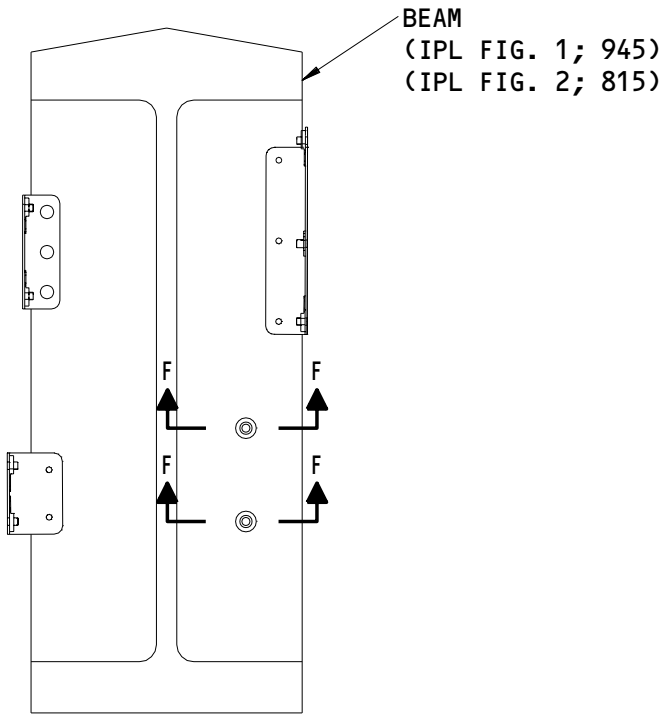
C–C



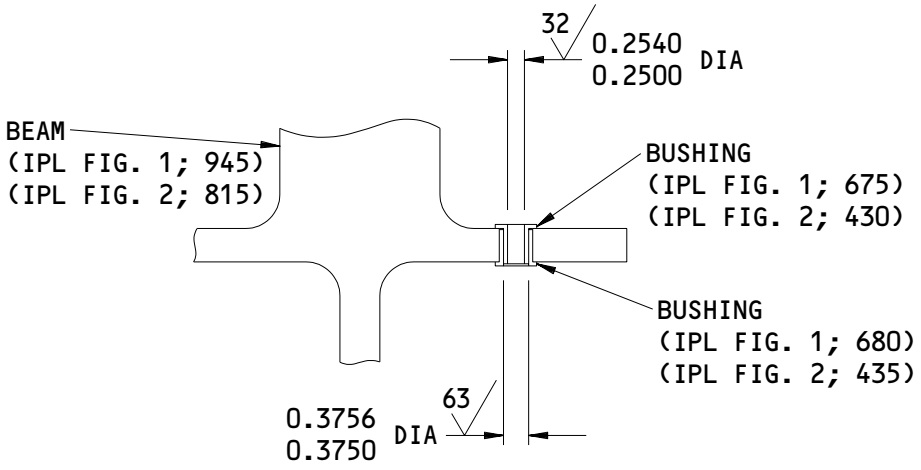
D–D

113T1116-1,-2
Main Landing Gear Beam Assembly Repair
Figure 601 (Sheet 3)

K22153



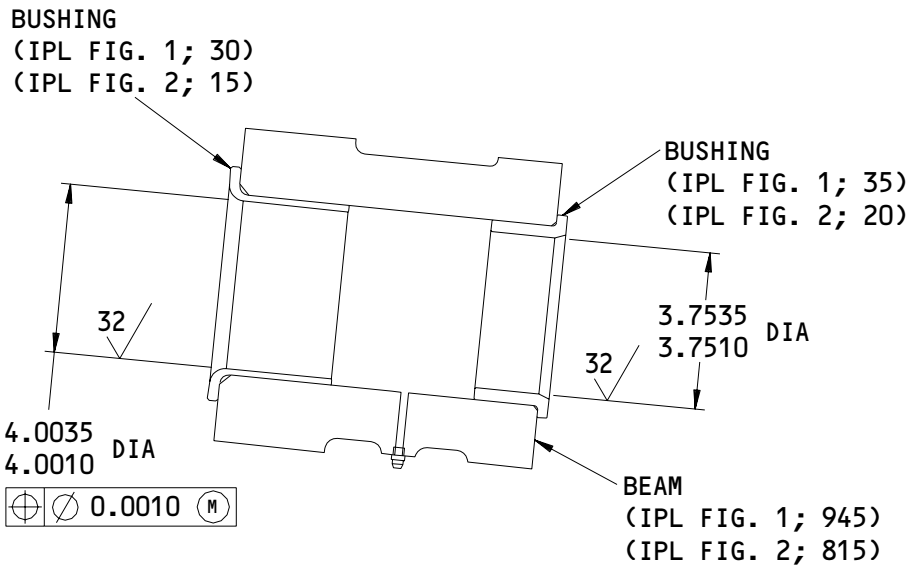
E–E



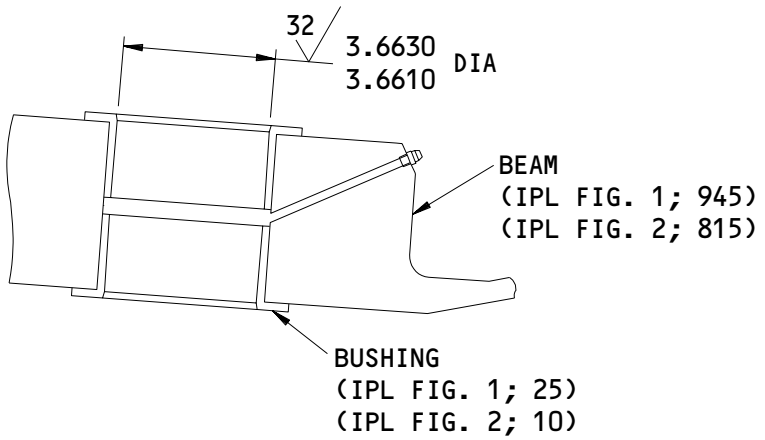
F–F

113T1116-1,-2
Main Landing Gear Beam Assembly Repair
Figure 601 (Sheet 4)

K22158

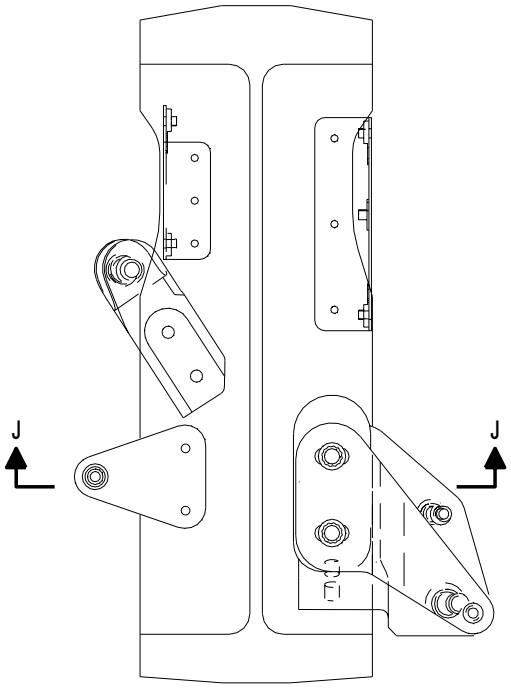


G–G

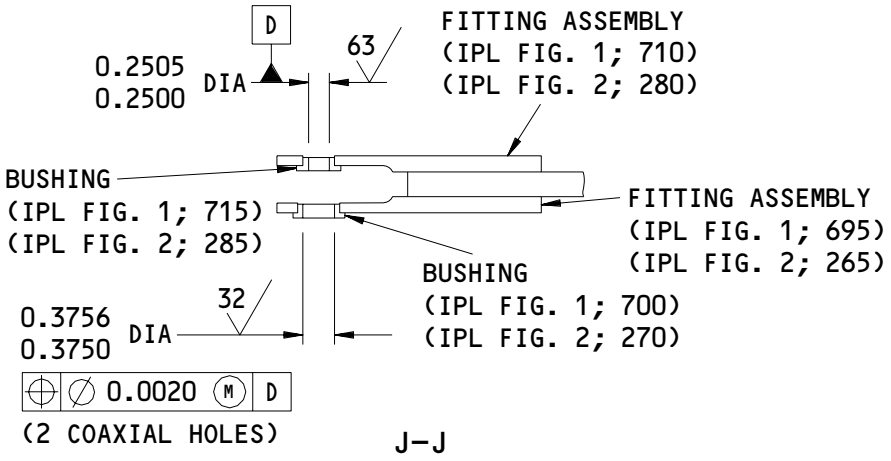


H–H

113T1116-1,-2
Main Landing Gear Beam Assembly Repair
Figure 601 (Sheet 5)



I–I



J–J

ALL DIMENSIONS ARE IN INCHES

113T1116-1,-2
Main Landing Gear Beam Assembly Repair
Figure 601 (Sheet 6)

K27582

MAIN LANDING GEAR BEAM - REPAIR 3-2

113T1117-1, -2

1. General

A. This repair gives the data that is necessary to repair and refinish the main landing gear beam (IPL Fig. 1; 945), (IPL Fig. 2; 815).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices shown in the repair.

C. Refer to the REPAIR - GENERAL (57-54-41/601, REPAIR - GENERAL) for the Standard True Position Dimensioning Symbols shown in the repair.

D. Refer to IPL Fig. 1 and 2 for item numbers.

E. General repair details:

(1) Material: 7050-T7452 Al Alloy

(2) Shot peen: Intensity 0.014A

2. Bushing Hole Repair

A. References

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

(2) SOPM 20-20-01, Magnetic Particle Inspection

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

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

(5) SOPM 20-41-02, Application of Chemical and Solvent Resistant Finish

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

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

B. Procedure (Fig. 601)

(1) Machine the worn or damaged hole for the bushings (IPL Fig. 1; 10, 15, 25, 30, 35, 675), (IPL Fig. 2; 10, 15, 20, 25, 35, 430) as necessary, to remove defects, cracks, and/or corrosion up to the limit shown in Fig. 601.

(2) Break all the sharp edges.

(3) Do a penetrant check as shown in the SOPM 20-20-02.

(4) Shot peen the machined area as shown in the SOPM 20-10-03.

(5) Machine the hole to the finish shown in Fig. 601.

(6) Oversize bushings

(a) Make the repair bushing for bushing (IPL Fig. 1; 10, 25, 35), (IPL Fig. 2; 10, 20, 35) as shown in Fig. 602 , 604, 606 and in the following instructions.

1) Bushing Material: Al-Ni-Bronze, AMS 4640

2) Break all the sharp edges.

3) Do a penetrant check as shown in the SOPM 20-20-02.

4) Finish

a) For bushing (IPL Fig. 1; 10), (IPL Fig. 2; 35) cadmium plate (F-15.06). Do not plate in bushing bore or flange surfaces.

b) For bushing (IPL Fig. 1; 25, 35), (IPL Fig. 2; 10, 20) cadmium plate (F-15.36).

5) Be sure the interference between the bushing O. D. and the oversize hole I. D. is as shown in Fig. 602, 604 and 606.

6) Install the oversize bushing as shown in REPAIR 3-1.

(b) Make the repair bushing for bushing (IPL Fig. 1; 15), (IPL Fig. 2; 25) as shown in Fig. 603 and in the following instructions.

1) Bushing Material: 7075-T7351 Al Alloy

2) Break all the sharp edges.

3) Do a penetrant check as shown in the SOPM 20-20-02.

4) Prepare the surface then hard anodize or sulfuric acid anodize (F-17.31) then apply BMS 10-11, type 1 primer (F-20.02).

5) Be sure the interference between the bushing O. D. and the oversize hole I. D. is as shown in Fig. 603.

6) Install the oversize bushing as shown in REPAIR 3-1.

(c) Make the repair bushing for bushing (IPL Fig. 1; 30), (IPL Fig. 2; 15) as shown in Fig. 605 and in the following instructions.

1) Bushing Material: Copper-Beryllium, AMS 4535

2) Break all the sharp edges.

3) Do a penetrant inspection as shown in the SOPM 20-20-02.

4) Prepare the surface and cadmium plate (F-15.36).

5) Be sure the interference between the bushing O. D. and the oversize hole I. D. is as shown in Fig. 605.

6) Install the oversize bushing as shown in REPAIR 3-1.

(d) Make the repair bushing for bushing (IPL Fig. 1; 680), (IPL Fig. 2; 435) as shown in Fig. 607 and in the following instructions.

1) Bushing Material: Al-Bronze, AMS 4640

2) Break all the sharp edges.

3) Do a penetrant inspection as shown in the SOPM 20-20-02.

4) Prepare the surface and cadmium plate (F-15.06).

5) Be sure the interference between the bushing O. D. and the oversize hole I. D. is as shown in Fig. 607.

6) Install the oversize bushing as shown in REPAIR 3-1.

3. Link-Refinish

A. Consumable Materials

(1) C00259 Primer -- BMS 10-11 (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

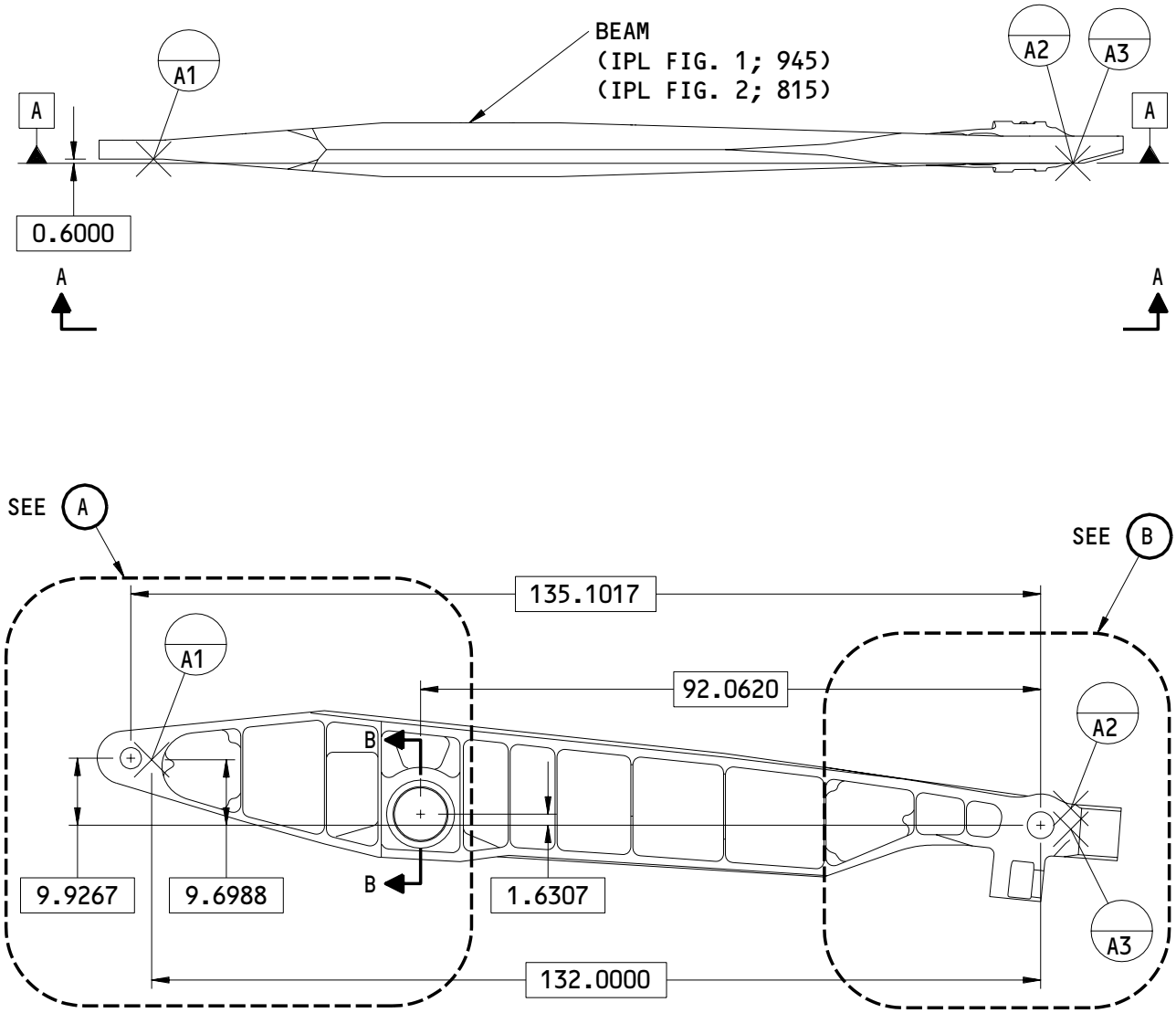
(4) SOPM 20-43-01, Chromic Acid Anodize

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

C. Procedure

(1) Boric Acid-Sulfuric Acid Anodize (F-17.31).

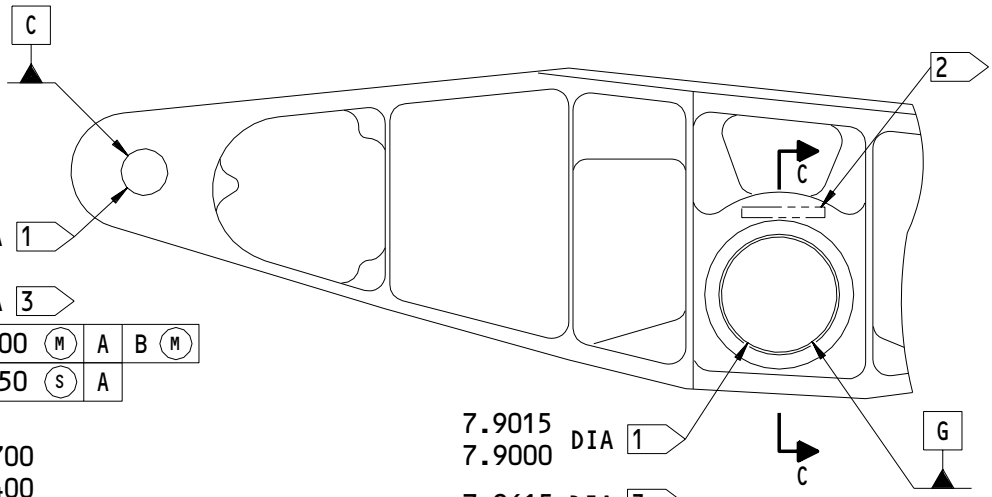
(2) Apply two BMS 10-11, type 1 primer (F-20.03). No primer in bushing bores.



A–A

113T1117-1,-2
Main Landing Gear Beam Repair
Figure 601 (Sheet 1)

K22363



3.2190
3.2178 DIA 1

3.2790 DIA 3

⌖	∅ 0.0400 (M)	A	B (M)
⊥	∅ 0.0050 (S)	A	

CHAMFER
45° X 0.0700 / 0.0400
(BOTH SIDES)

COUNTERBORE
4.1800 / 4.1200 X 0.1300 / 0.1000 FILLET R
(FLAT BOTH SIDES)

//	0.0020	A

7.9015
7.9000 DIA 1

7.9615 DIA 3

⌖	∅ 0.0200 (S)	A	B (M)	C (M)
⊥	∅ 0.0050 (S)	A		

CHAMFER
45° X 0.1200 / 0.1100
(BOTH SIDES)

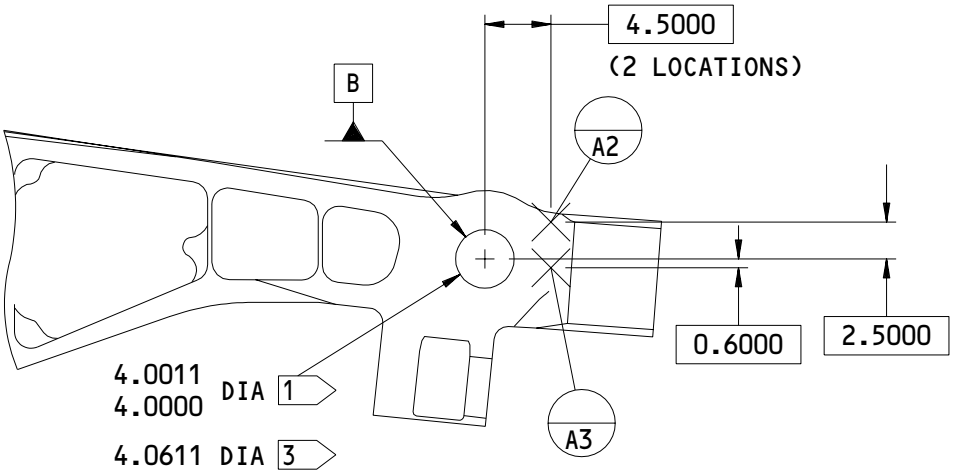
COUNTERBORE
9.8700 / 9.8500 X 0.1300 / 0.1000 FILLET R
(FLAT BOTH SIDES)

⊥	0.0020	G

A

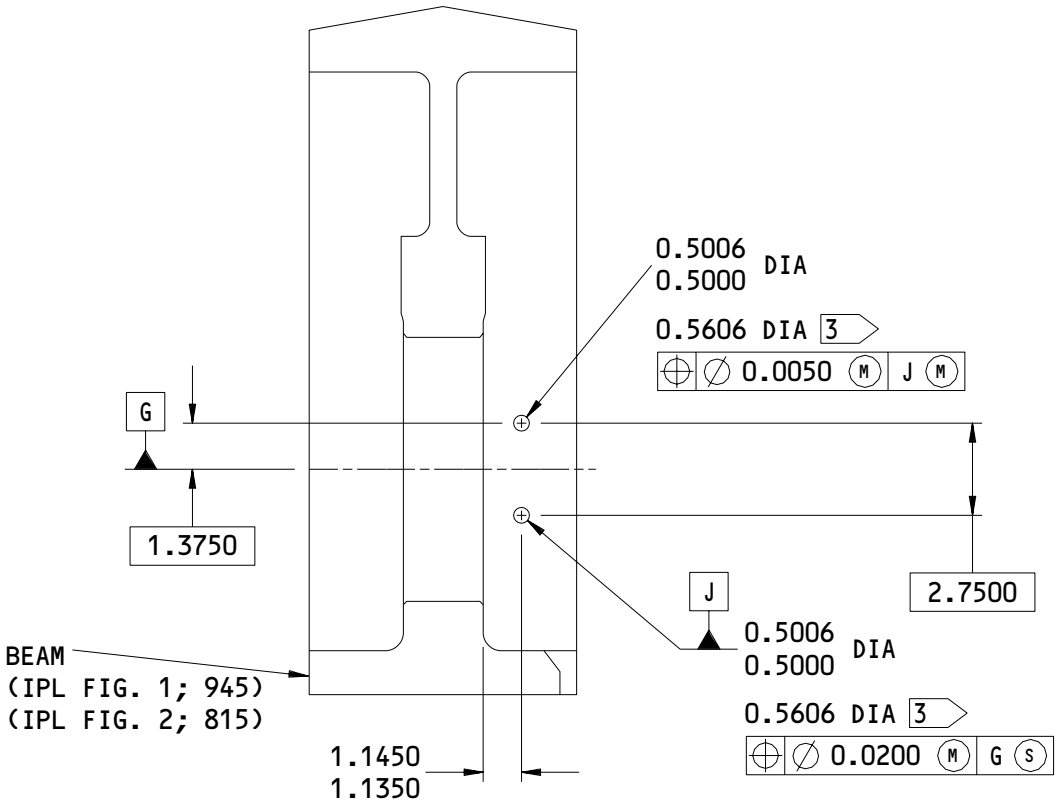
113T1117-1,-2
Main Landing Gear Beam Repair
Figure 601 (Sheet 2)

K22451



113T1117-1,-2
Main Landing Gear Beam Repair
Figure 601 (Sheet 3)

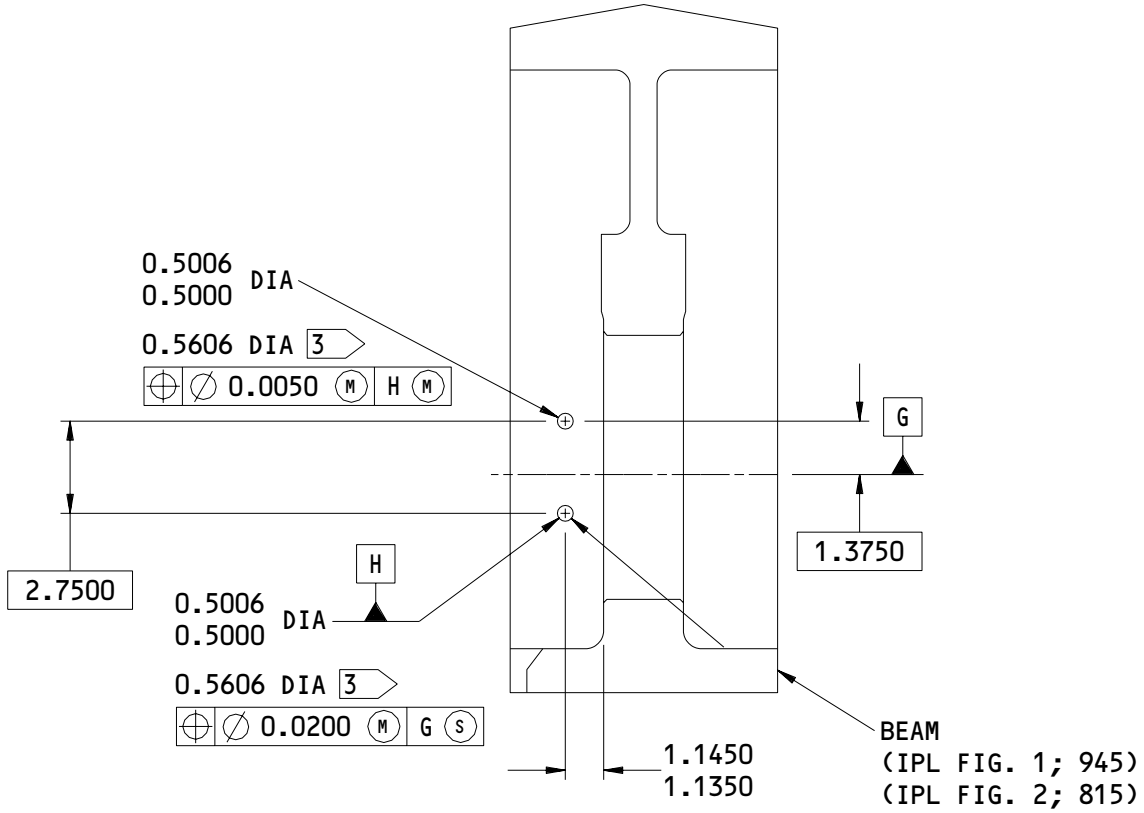
K22521



B–B

113T1117-1,-2
Main Landing Gear Beam Repair
Figure 601 (Sheet 4)

K22576



C–C

1 > F–17.31 ONLY IN BORES

2 > PART NUMBER LOCATED HERE

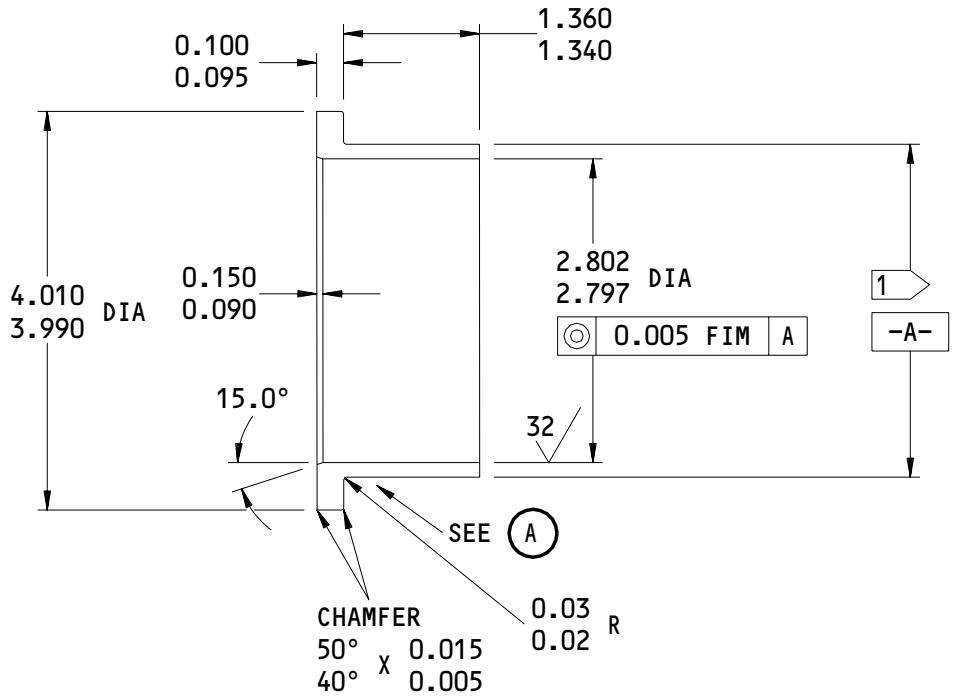
3 > REPAIR LIMIT

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

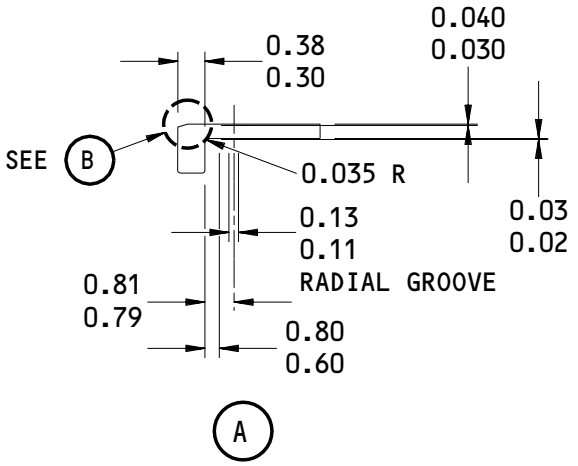
BREAK ALL SHARP EDGES

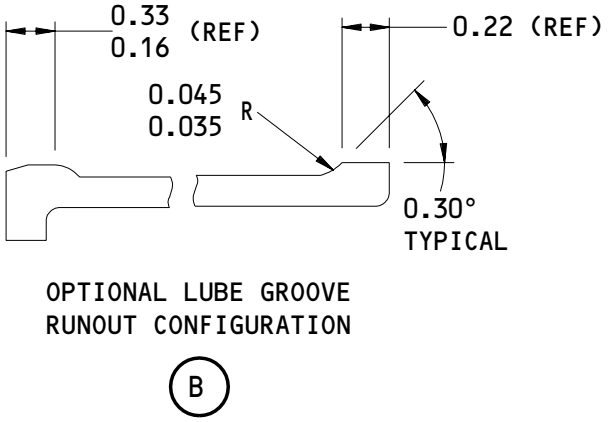
ALL DIMENSIONS ARE IN INCHES

113T1117–1,–2
Main Landing Gear Beam Repair
Figure 601 (Sheet 5)



OVERSIZE REPLACEMENT BUSHING
(IPL FIG. 1; 10)
(IPL FIG. 2; 35)



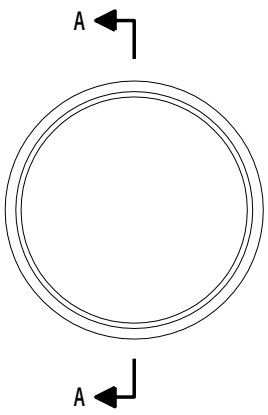


1 THE OUTSIDE DIAMETER OF THE BUSHING IS EQUAL TO THE FITTING HOLE PLUS INTERFERENCE 0.0041-0.0063

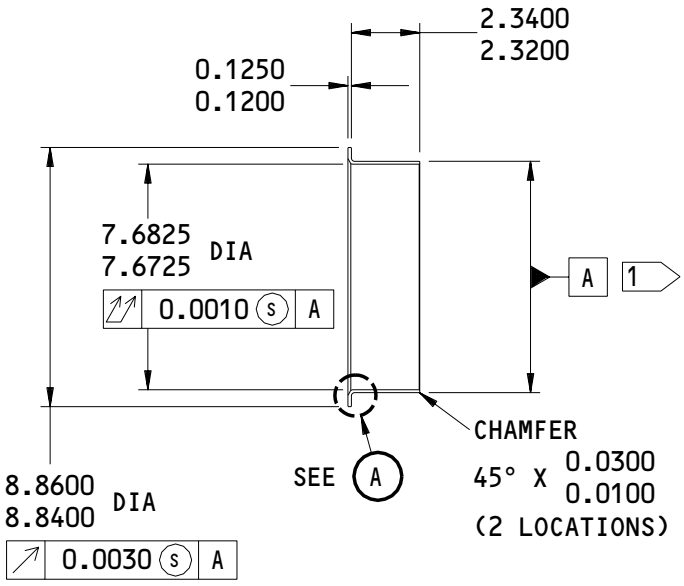
ALL DIMENSIONS ARE IN INCHES

Repair Bushing Details
Figure 602

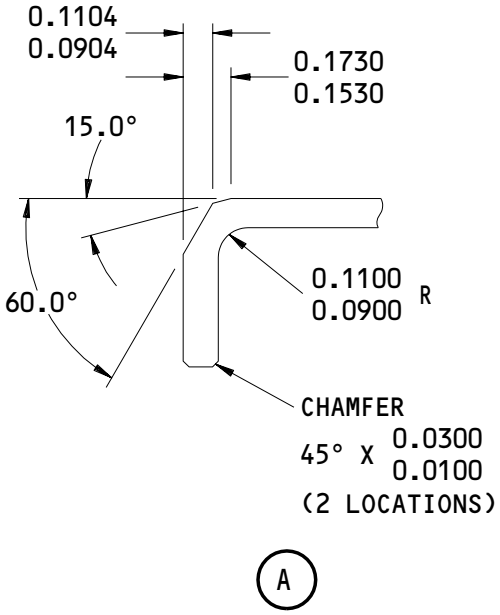
K22740



OVERSIZE REPLACEMENT BUSHING
(IPL FIG. 1; 15)
(IPL FIG. 2; 25)



A–A

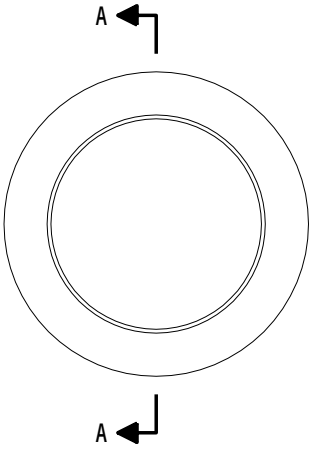


1 THE OUTSIDE DIAMETER OF THE BUSHING AFTER PLATING IS EQUAL TO THE INSIDE DIAMETER OF THE LUG HOLE PLUS THE INTERFERENCE OF 0.0085–0.0140

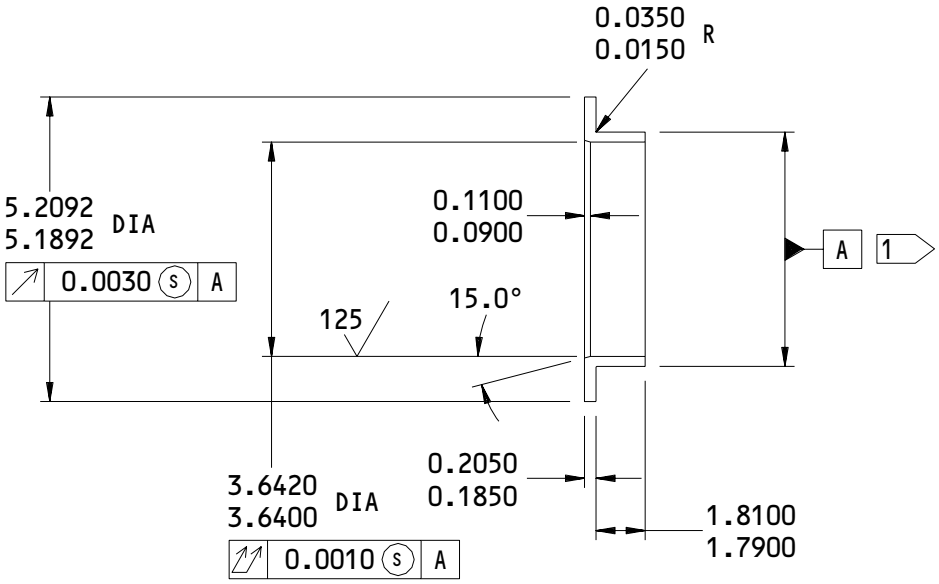
ALL DIMENSIONS ARE IN INCHES

Repair Bushing Details
Figure 603

K22783



OVERSIZE REPLACEMENT BUSHING
(IPL FIG. 1; 25)
(IPL FIG. 2; 10)



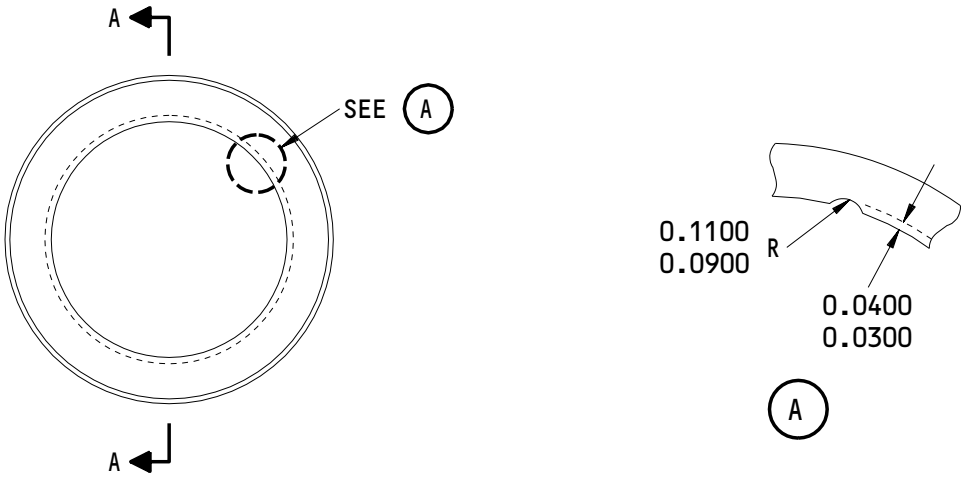
A–A

1 THE OUTSIDE DIAMETER OF THE BUSHING AFTER PLATING IS EQUAL TO THE INSIDE DIAMETER OF THE LUG HOLE PLUS THE INTERFERENCE OF 0.0044–0.0088

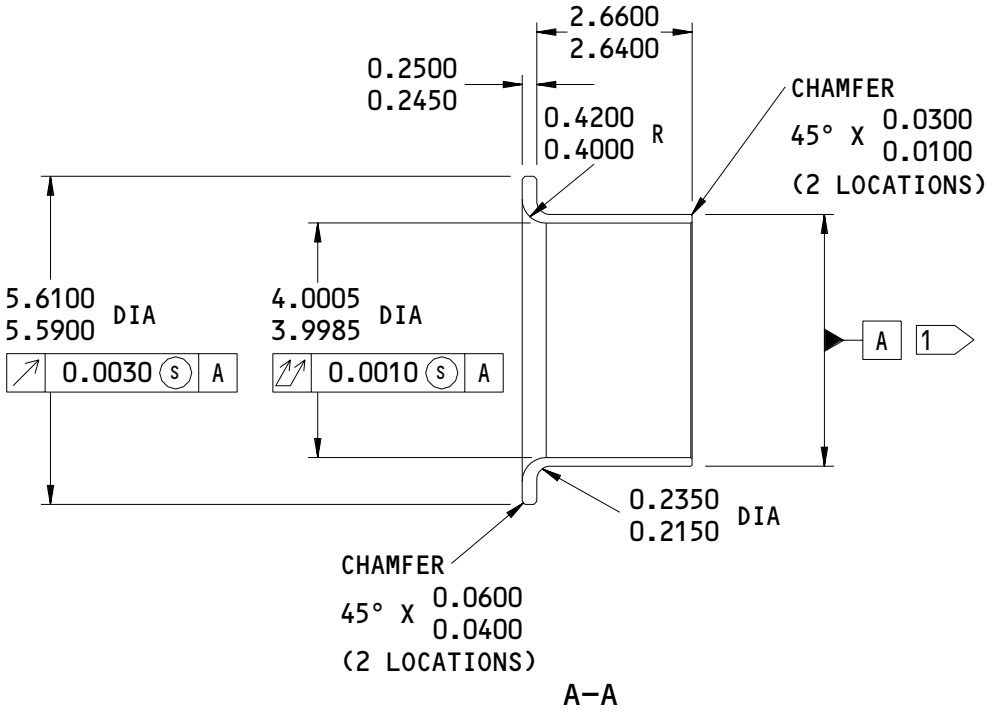
ALL DIMENSIONS ARE IN INCHES

Repair Bushing Details
Figure 604

K22811



OVERSIZE REPLACEMENT BUSHING
(IPL FIG. 1; 30)
(IPL FIG. 2; 15)



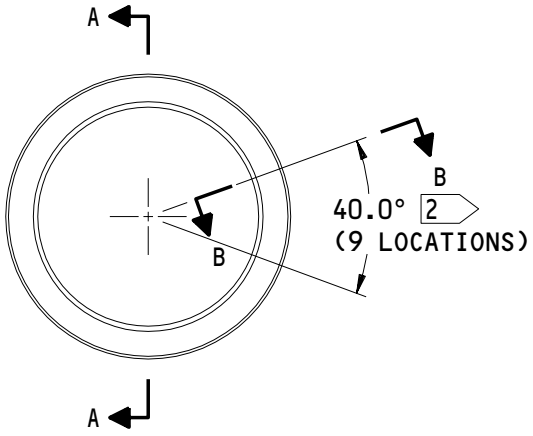
A–A

1 THE OUTSIDE DIAMETER OF THE BUSHING AFTER PLATING IS EQUAL TO THE INSIDE DIAMETER OF THE LUG HOLE PLUS THE INTERFERENCE OF 0.0062–0.0087

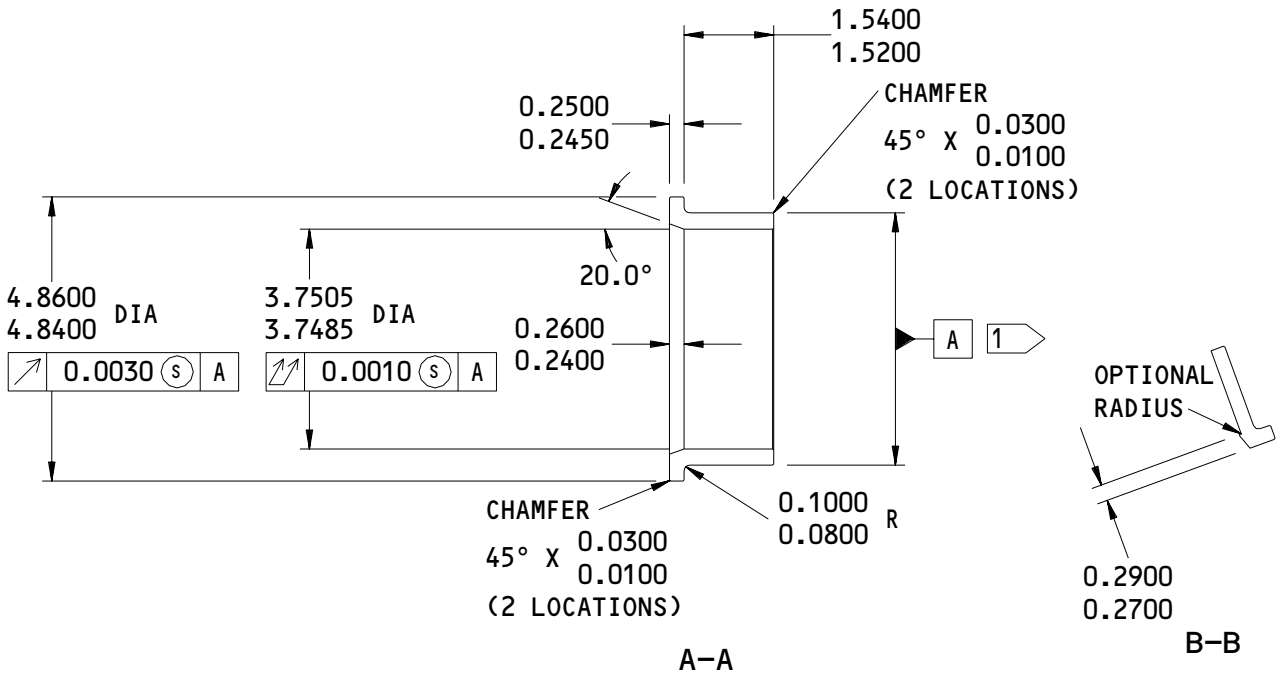
ALL DIMENSIONS ARE IN INCHES

Repair Bushing Details
Figure 605

K22868



OVERSIZE REPLACEMENT BUSHING
(IPL FIG. 1; 35)
(IPL FIG. 2; 20)



1 THE OUTSIDE DIAMETER OF THE BUSHING AFTER PLATING IS EQUAL TO THE INSIDE DIAMETER OF THE LUG HOLE PLUS THE INTERFERENCE OF 0.0062–0.0087

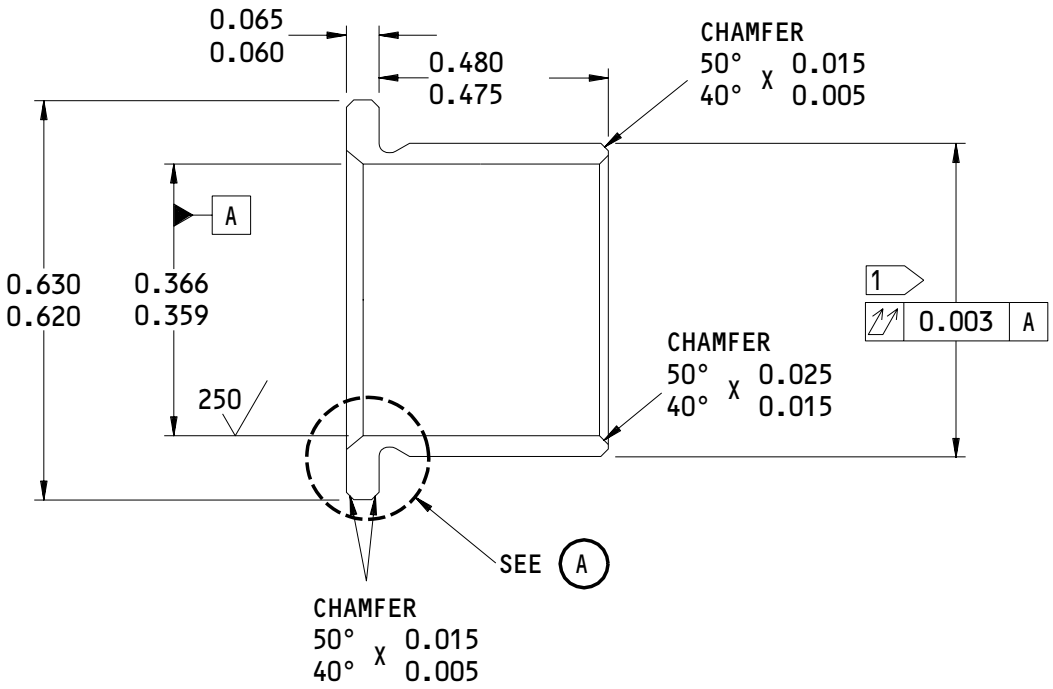
2 OPTIONAL 36° (10 LOCATIONS)

ITEM NUMBERS REFER TO IPL FIG. 1 AND FIG. 2

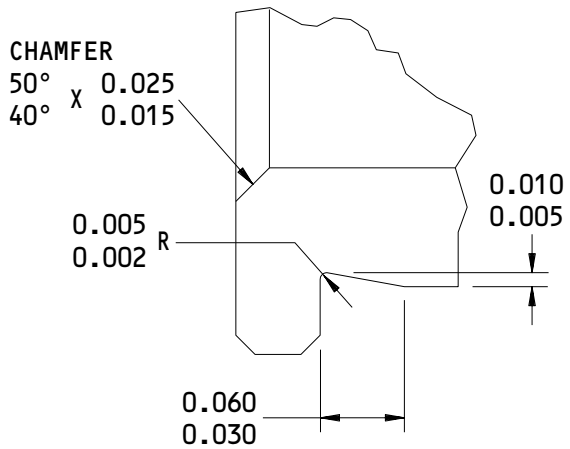
ALL DIMENSIONS ARE IN INCHES

Repair Bushing Details
Figure 606

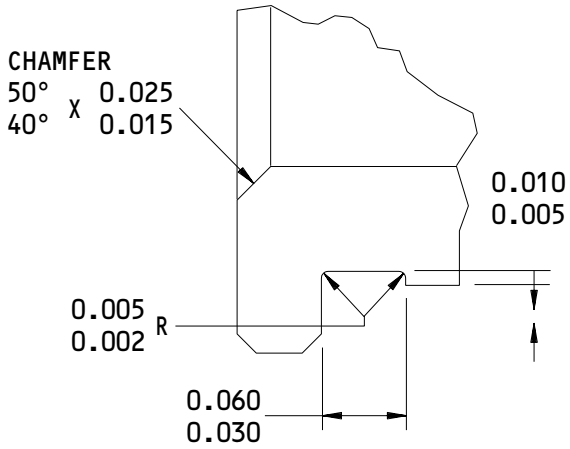
K22929



OVERSIZE REPLACEMENT BUSHING
(IPL FIG. 1; 680)
(IPL FIG. 2; 435)



TYPE 1



TYPE 2

A

1 THE OUTSIDE DIAMETER OF THE BUSHING IS EQUAL TO THE FITTING HOLE PLUS INTERFERENCE 0.0004-0.0015

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

Oversize Bushing Details
Figure 607

K22954

FITTING ASSEMBLY - REPAIR 4-1

113T1122-1

1. General

A. This repair gives the data that is necessary to repair the fitting assembly (IPL Fig. 1; 435) and (IPL Fig. 2; 370).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices shown in the repair.

C. Refer to the REPAIR - GENERAL (57-54-41/601, REPAIR-GENERAL) for the standard true position dimensioning symbols shown in the repair.

D. Refer to IPL Fig. 1 and 2 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 of Boeing Finish Codes

(2) SOPM 20-50-03, Bearing Removal, Installation and Retention

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

C. Procedure

(1) Replace the bushings in the fitting assembly.

(a) Remove the bushings (IPL Fig. 1; 440) from the fitting assembly (IPL Fig. 1; 435).

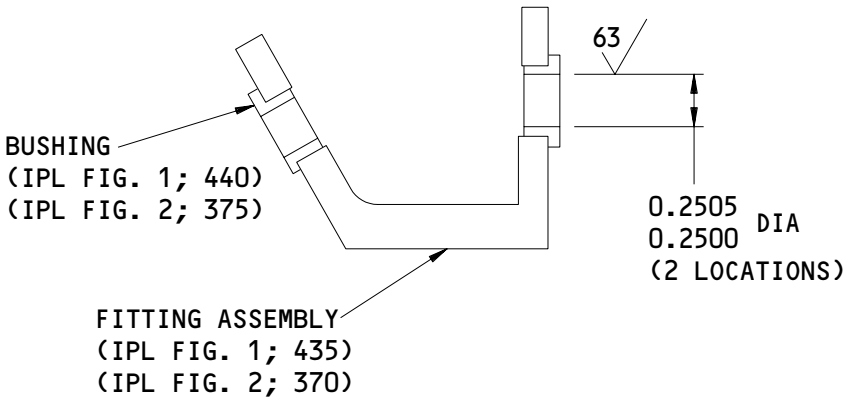
(b) Remove the bushings (IPL Fig. 2; 375) from the fitting assembly (IPL Fig. 2; 370).

(c) Install the bushings into the fittings with BMS 5-95 sealant and as shown in the SOPM 20-50-03.

(d) Machine the bushings inside diameter to the dimensions and finish shown in Fig. 601.

(e) Break all sharp edges to a radius of 0.02-0.03 inch.

(f) Fillet seal around the flanges of the bushings using BMS 5-95 sealant.



125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

113T1122-1
Fitting Assembly Repair
Figure 601

FITTING - REPAIR 4-2

113T1122-2

1. General

A. This repair gives the data that is necessary to repair and refinish the fitting (IPL Fig. 1; 445), (IPL Fig. 2; 380).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices shown in the repair.

C. Refer to the REPAIR - GENERAL (57-54-41/601, REPAIR - GENERAL) for the Standard True Position Dimensioning Symbols shown in the repair.

D. Refer to IPL Fig. 1 and 2 for item numbers.

E. General repair details:

(1) Material: Aluminum alloy

(2) Shot peen: Shot Number 230-460

2. Bushing Hole Repair

A. References

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

(2) SOPM 20-20-01, Magnetic Particle Inspection

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

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

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

B. Procedure

(1) Machine the worn or damaged hole for the bushings (IPL Fig. 1; 440), (IPL Fig. 2; 375) as necessary, to remove defects, cracks, and/or corrosion up to the limit shown in Fig. 601.

(2) Break all the sharp edges to a radius of 0.020-0.030 inch.

(3) Do a penetrant check as shown in the SOPM 20-20-02.

(4) Shot peen the machined area as shown in the SOPM 20-10-03.

(5) Machine the hole to the finish shown in Fig. 601.

(6) Oversize bushings

(a) Make the repair bushing for bushing (IPL Fig. 1; 440), (IPL Fig. 2; 375) as shown in Fig. 602 and in the following instructions.

1) Bushing Material: AL-Ni-Bronze, AMS 4640

2) Break all the sharp edges.

3) Do a penetrant check as shown in SOPM 20-20-02.

4) Prepare the surface and cadmium plate (F-15.06) as shown in SOPM 20-42-05.

5) Be sure the interference between the bushing O. D. and the oversize hole I. D. is as shown in Fig. 602.

6) Install the oversize repair bushing 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

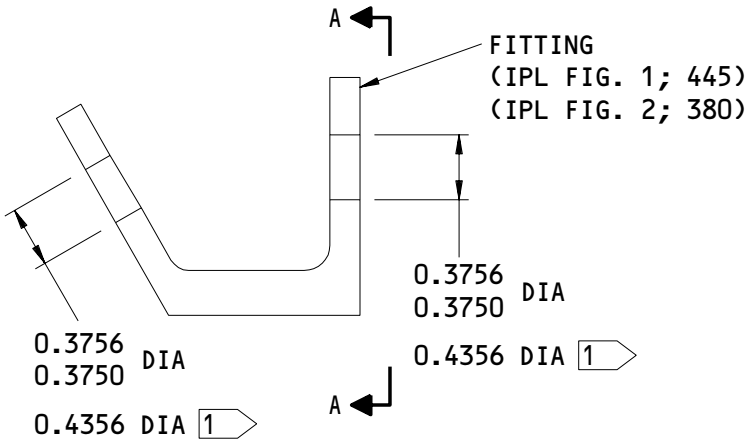
(3) SOPM 20-41-02, Application of Chemical and Solvent Resistant Finishes

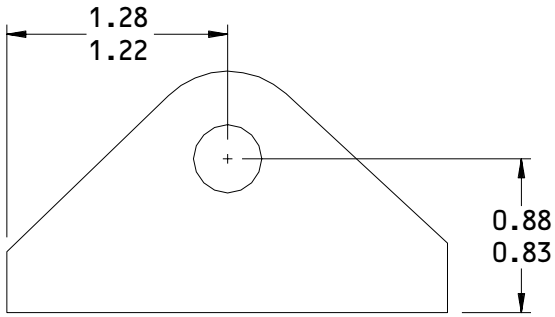
(4) SOPM 20-43-01, Chromic Acid Anodize

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

C. Procedure

(1) Chromic acid anodize and apply BMS 10-11, Type 1 primer (F-18.13). No primer in bushing bores.





A–A

1 REPAIR LIMIT

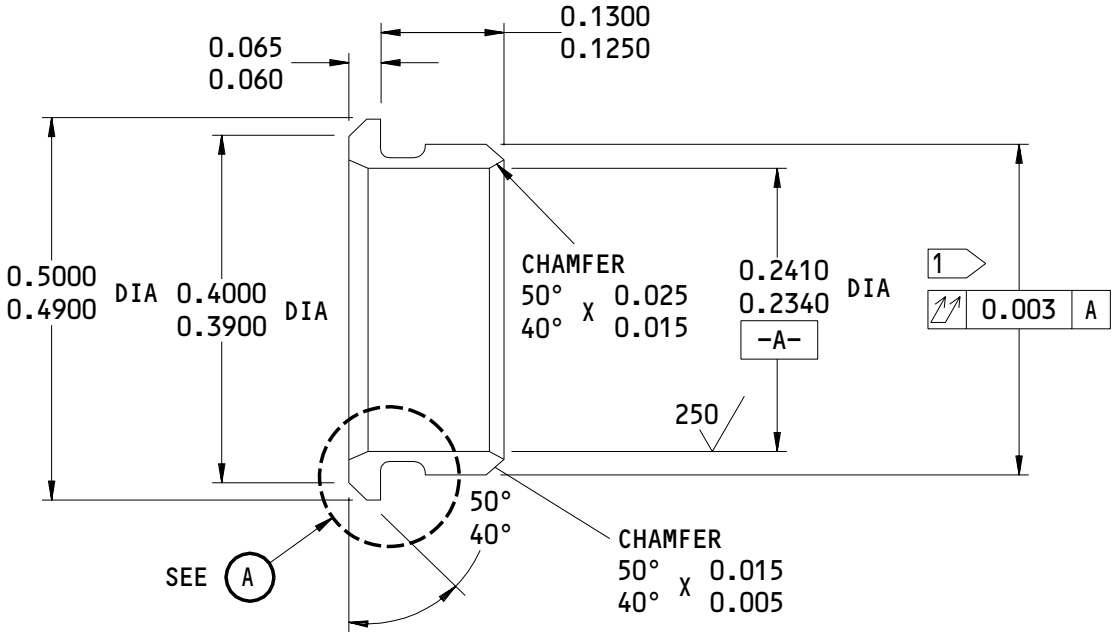
125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

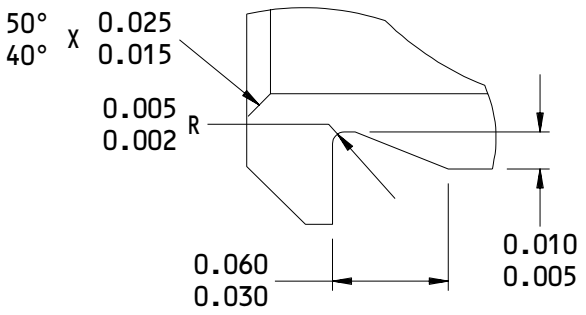
ALL DIMENSIONS ARE IN INCHES

113T1122-2
Fitting Repair
Figure 601

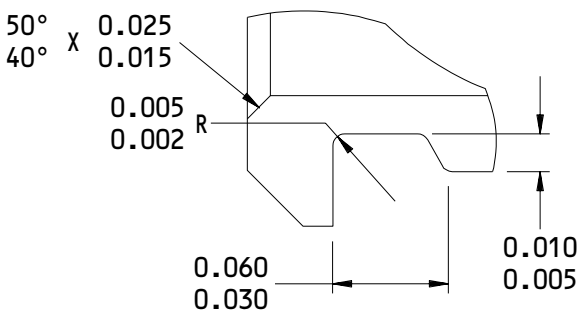
K22998



OVERSIZE REPLACEMENT BUSHING
(IPL FIG. 1; 440)
(IPL FIG. 2; 375)



TYPE 1



TYPE 2

A

1 THE OUTSIDE DIAMETER OF THE BUSHING IS EQUAL TO THE FITTING HOLE PLUS INTERFERENCE 0.0003-0.0015

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

ALL DIMENSIONS ARE IN INCHES

Repair Bushing Details
Figure 602

FITTING ASSEMBLY - REPAIR 5-1

113T1123-5, -6

1. General

A. This repair gives the data that is necessary to repair the fitting assembly (IPL Fig. 1; 385) and (IPL Fig. 2; 395).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices shown in the repair.

C. Refer to the REPAIR - GENERAL (57-54-41/601, REPAIR-GENERAL) for the standard true position dimensioning symbols shown in the repair.

D. Refer to IPL Fig. 1 and 2 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 of Boeing Finish Codes

(2) SOPM 20-50-03, Bearing Removal, Installation and Retention

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

C. Procedure

(1) Replace the bushings in the fitting assembly.

(a) Remove the bushings (IPL Fig. 1; 390, 395, 400, 405, 410) from the fitting assembly (IPL Fig. 1; 385).

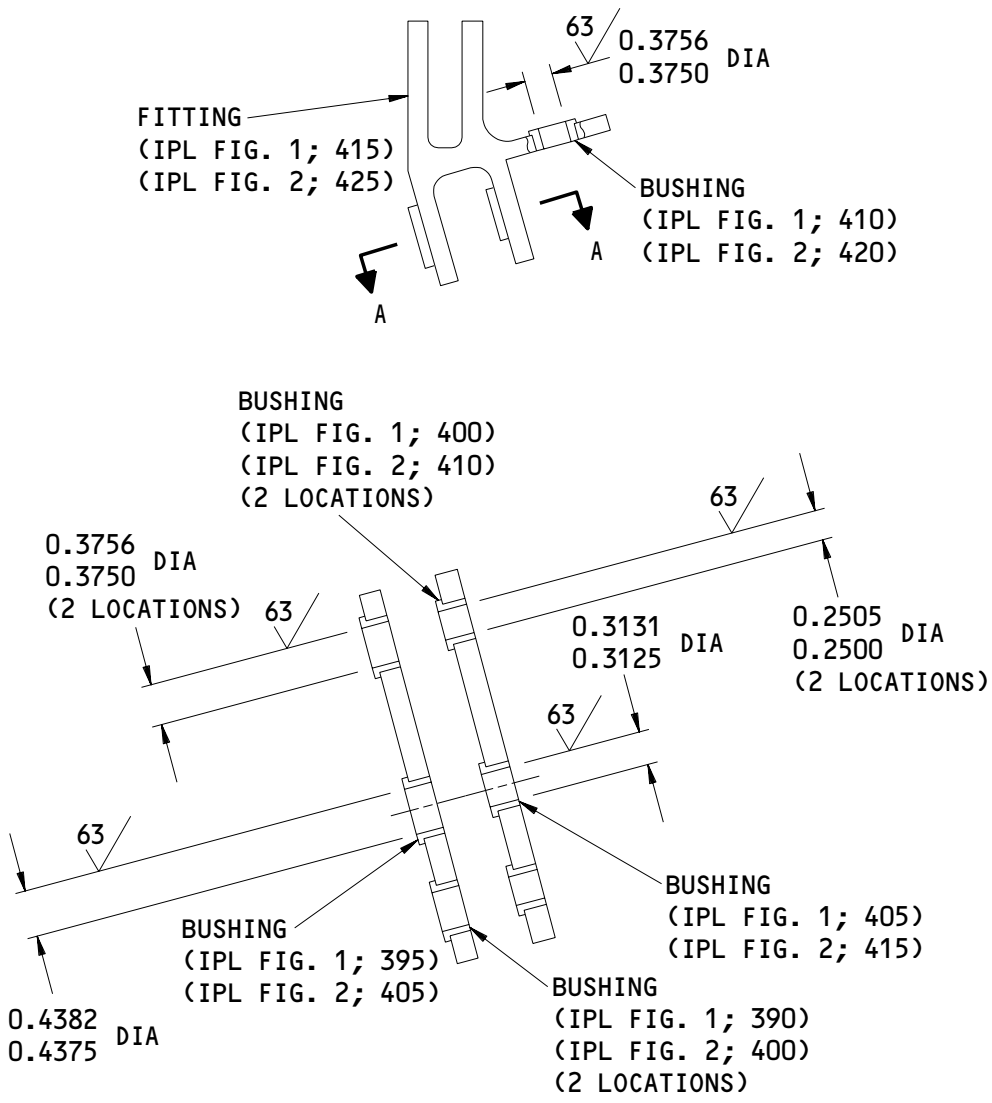
(b) Remove the bushings (IPL Fig. 2; 400, 405, 410, 415, 420) from the fitting assembly (IPL Fig. 2; 395).

(c) Install the bushings into the fittings with BMS 5-95 sealant and as shown in the SOPM 20-50-03.

(d) Machine the bushings inside diameter to the dimensions and finish shown in Fig. 601.

(e) Break all sharp edges to a radius of 0.02-0.03 inch.

(f) Fillet seal around the flanges of the bushings using BMS 5-95 sealant.



A–A

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

113T1123-5,-6
Fitting Assembly Repair
Figure 601

K23391

FITTING - REPAIR 5-2

113T1123-7, -8

1. General

A. This repair gives the data that is necessary to repair and refinish the fitting (IPL Fig. 1; 415), (IPL Fig. 2; 425).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices shown in the repair.

C. Refer to the REPAIR - GENERAL (57-54-41/601, REPAIR - GENERAL) for the Standard True Position Dimensioning Symbols shown in the repair.

D. Refer to IPL Fig. 1 and 2 for item numbers.

E. General repair details:

(1) Material: Aluminum alloy

(2) Shot peen: Shot number 230-460
Coverage 2.0

2. Bushing Hole Repair

A. References

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

(2) SOPM 20-20-01, Magnetic Particle Inspection

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

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

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

B. Procedure

(1) Machine the worn or damaged hole for the bushings (IPL Fig. 1; 390, 395, 400, 405, 410), (IPL Fig. 2; 400, 405, 410, 415, 420) as necessary, to remove defects, cracks, and/or corrosion up to the limit shown in Fig. 601.

(2) Break all the sharp edges to a radius of 0.02-0.03 inch.

(3) Do a penetrant check as shown in the SOPM 20-20-02.

(4) Shot peen the machined area as shown in the SOPM 20-10-03.

(5) Machine the hole to the finish shown in Fig. 601.

(6) Oversize bushings

(a) Make the repair bushing for bushing (IPL Fig. 1; 390, 395, 410), (IPL Fig. 2; 400, 405, 420) as shown in Fig. 602 and in the following instructions.

1) Bushing Material: Al-Ni-Bronze, AMS 4640

2) Break all the sharp edges.

3) Do a penetrant check as shown in SOPM 20-20-02.

4) Prepare the surface and cadmium plate (F-15.06) as shown in SOPM 20-42-05.

5) Be sure the interference between the bushing O. D. and the oversize hole I. D. is as shown in Fig. 602.

6) Install the oversize repair bushing as shown in REPAIR 5-1.

(b) Make the repair bushing for bushing (IPL Fig. 1; 400, 405), (IPL Fig. 2; 410, 415) as shown in Fig. 603 and in the following instructions.

1) Bushing Material: 15-5PH, AMS 5659, 40-43 HRC or
17-4PH, AMS 5643, 40-43 HRC

2) Break all the sharp edges.

3) Do a magnetic particle check as shown in SOPM 20-20-01.

4) Prepare the surface and cadmium plate (F-15.06) as shown in SOPM 20-42-05.

5) Be sure the interference between the bushing O. D. and the oversize hole I. D. is as shown in Fig. 603.

6) Install the oversize repair bushing as shown in REPAIR 5-1.

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

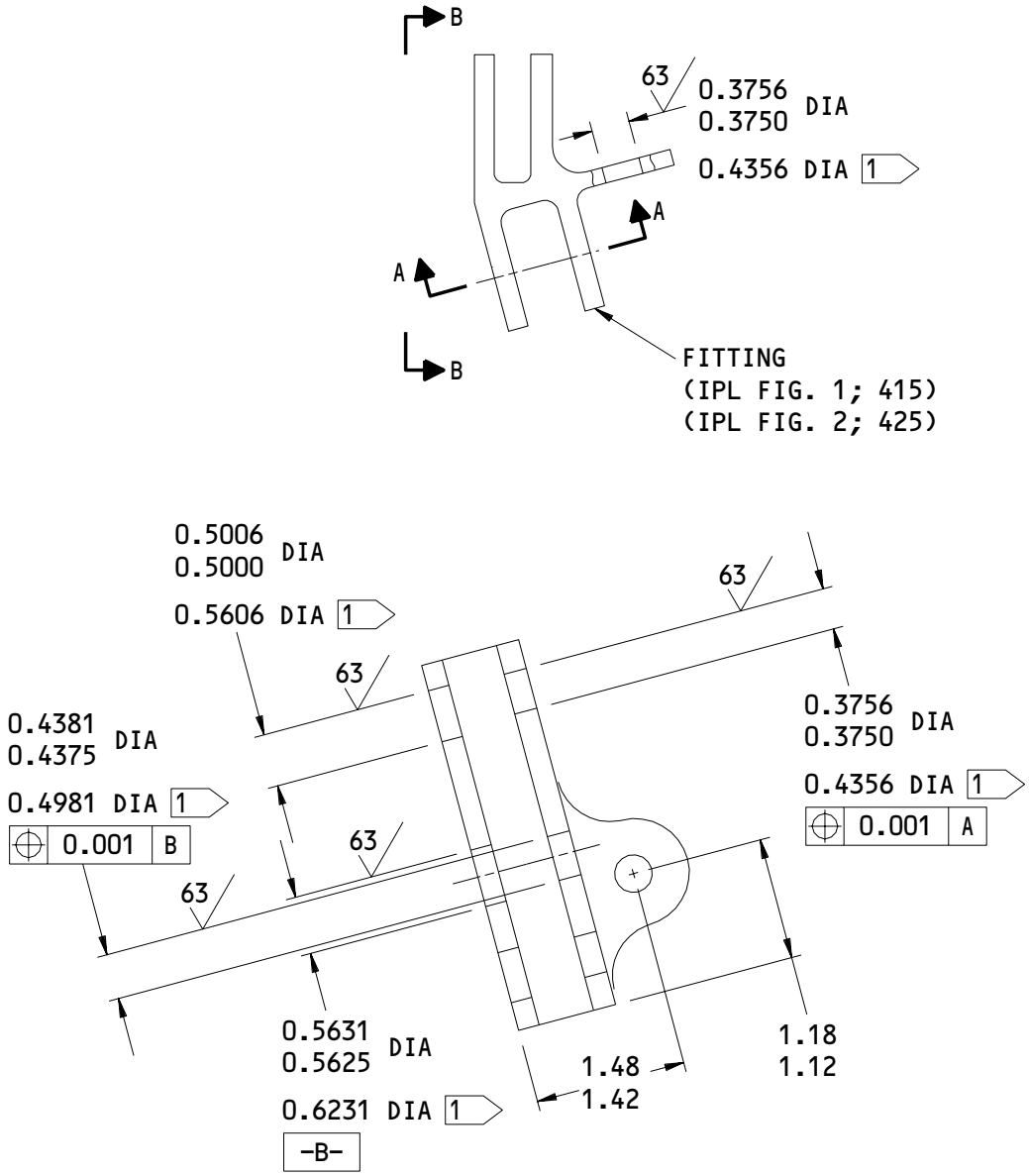
(3) SOPM 20-41-02, Application of Chemical and Solvent Resistant Finishes

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

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

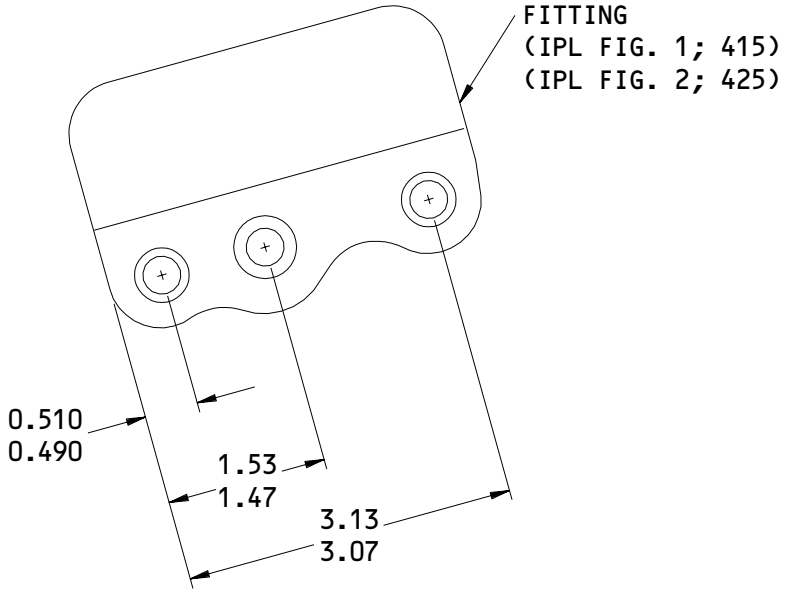
C. Procedure

(1) Chromic acid anodize and apply BMS 10-11, Type 1 primer (F-18.13). No primer in bushing bores.



113T1123-7,-8
Fitting Repair
Figure 601 (Sheet 1)

K23427



B–B

1 REPAIR LIMIT

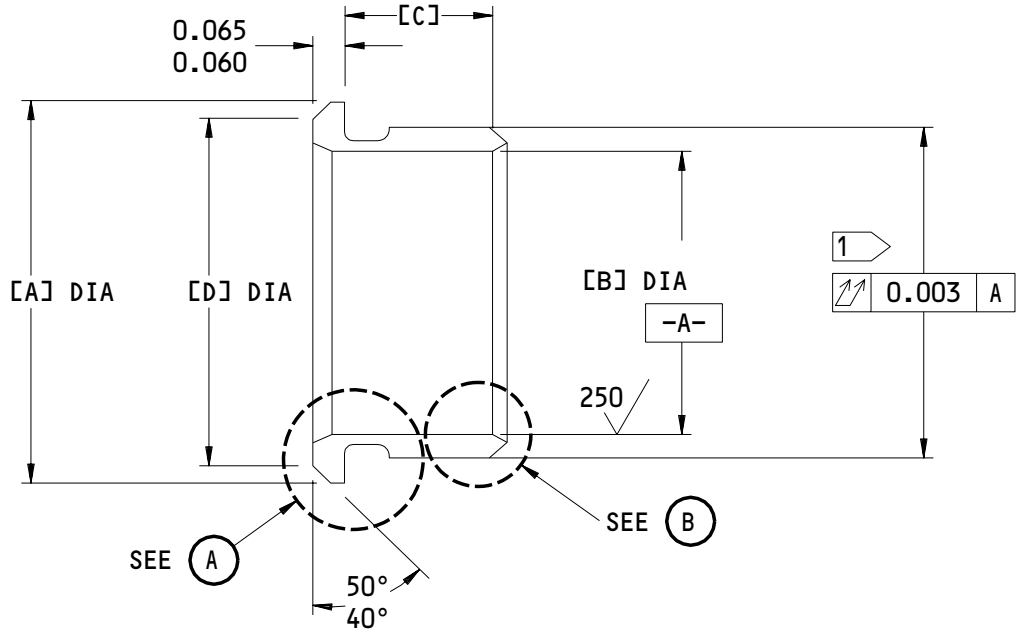
125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

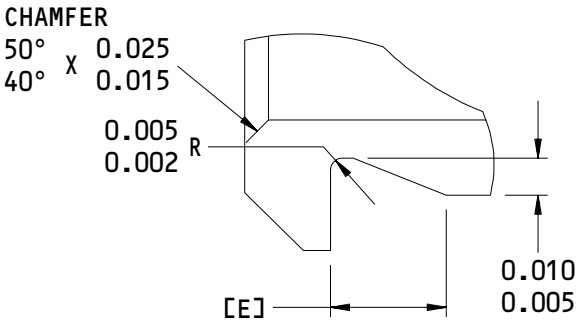
ALL DIMENSIONS ARE IN INCHES

113T1123-7,-8
Fitting Repair
Figure 601 (Sheet 2)

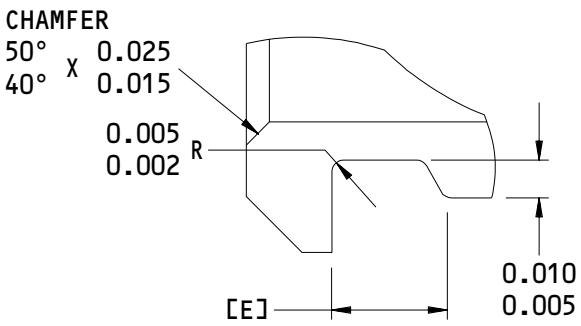
K23430



OVERSIZE REPLACEMENT BUSHING



TYPE 1

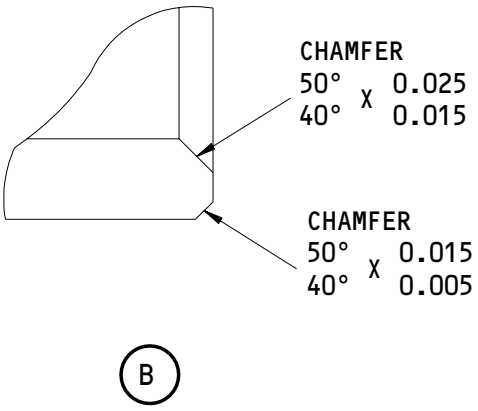


TYPE 2

A

Repair Bushing Details
Figure 602 (Sheet 1)

K23094



BUSHING ITEM NO.	[A]	[B]	[C]	[D]	[E]	INTERFERENCE
FIG. 1; 390 FIG. 2; 400	0.6300 0.6200	0.3660 0.3590	0.1600 0.1550	0.5400 0.5300	0.0300 0.0150	0.0016 0.0004
FIG. 1; 395 FIG. 2; 405	0.6900 0.6800	0.4280 0.4220	0.1600 0.1550	0.5900 0.5800	0.0300 0.0150	0.0017 0.0005
FIG. 1; 410 FIG. 2; 420	0.5000 0.4900	0.2410 0.2340	0.1300 0.1250	0.4000 0.3900		0.0015 0.0003

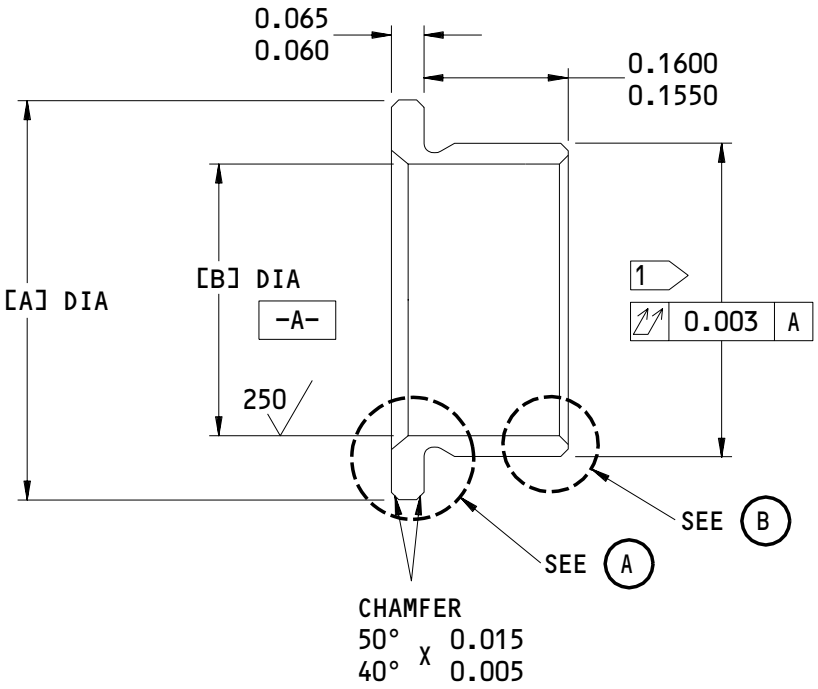
1 THE OUTSIDE DIAMETER OF THE BUSHING IS EQUAL TO THE FITTING HOLE PLUS INTERFERENCE

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

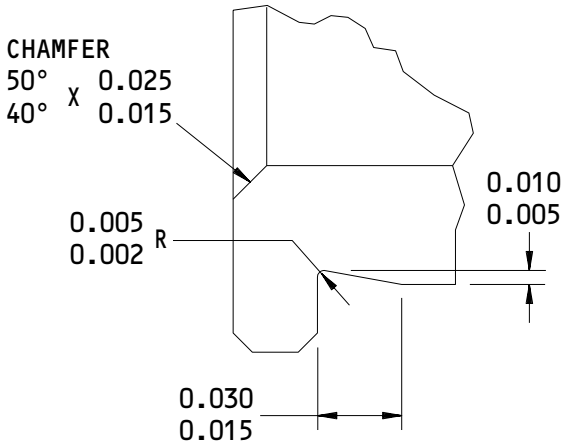
ALL DIMENSIONS ARE IN INCHES

Repair Bushing Details
Figure 602 (Sheet 2)

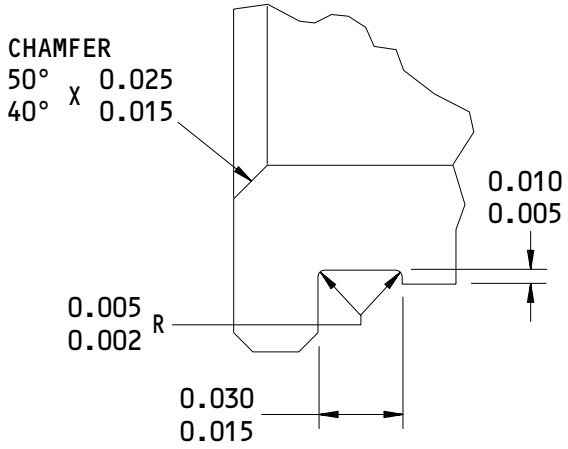
K23105



OVERSIZE REPLACEMENT BUSHING



TYPE 1

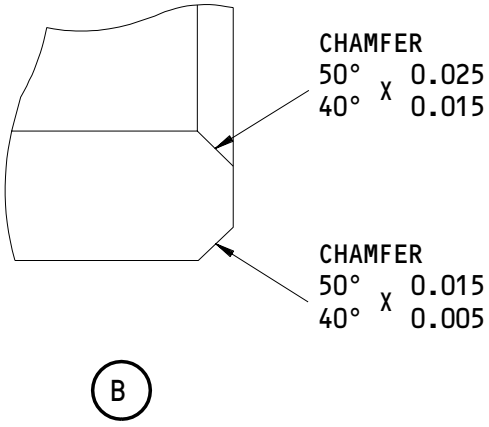


TYPE 2

A

Oversize Bushing Details
Figure 603 (Sheet 1)

K23927



REPLACES BUSHING	[A]	[B]	INTER-FERENCE
FIG. 1; 400 FIG. 2; 410	0.5400 0.5300	0.2410 0.2340	0.0014 0.0003
FIG. 1; 405 FIG. 2; 415	0.6100 0.6000	0.3030 0.2970	0.0014 0.0003

1 THE OUTSIDE DIAMETER OF THE BUSHING IS EQUAL TO THE FITTING HOLE PLUS INTERFERENCE

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

ALL DIMENSIONS ARE IN INCHES

Oversize Bushing Details
Figure 603 (Sheet 2)

K23928

FITTING ASSEMBLY - REPAIR 6-1

113T1126-7, -8, -21, -22

1. General

A. This repair gives the data that is necessary to repair the fitting assembly (IPL Fig. 1; 695, 710, 770) and (IPL Fig. 2; 265, 280, 310).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices shown in the repair.

C. Refer to the REPAIR - GENERAL (57-54-41/601, REPAIR-GENERAL) for the standard true position dimensioning symbols shown in the repair.

D. Refer to IPL Fig. 1 and 2 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 of Boeing Finish Codes

(2) SOPM 20-50-03, Bearing Removal, Installation and Retention

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

C. Procedure

(1) Replace the bushings in the fitting assemblies.

(a) Remove the bushings (IPL Fig. 1; 700), (IPL Fig. 2; 270) from the fitting assembly (IPL Fig. 1; 695), (IPL Fig. 2; 265).

(b) Remove the bushings (IPL Fig. 1; 715), (IPL Fig. 2; 285) from the fitting assembly (IPL Fig. 1; 710), (IPL Fig. 2; 280).

(c) Remove the bushings (IPL Fig. 1; 775, 780) from the fitting assembly (IPL Fig. 1; 770).

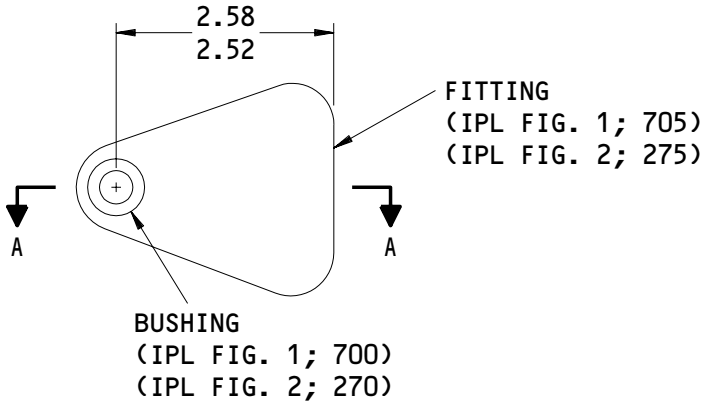
(d) Remove the bushings (IPL Fig. 1; 315, 320) from the fitting assembly (IPL Fig. 2; 310).

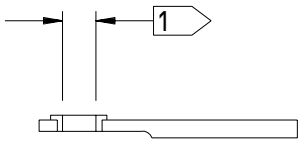
(e) Install the bushings into the fittings with BMS 5-95 sealant and as shown in the SOPM 20-50-03.

(f) Machine the bushings inside diameter to the dimensions and finish shown in Fig. 601, 602 and 603.

(g) Break all sharp edges to a radius of 0.02-0.03 inch.

(h) Fillet seal around the flanges of the bushings using BMS 5-95 sealant.





A–A

1 THE FINAL INNER DIAMETER OF THE BUSHING IS MACHINED ON THE 113T1116. SEE REPAIR 3-1

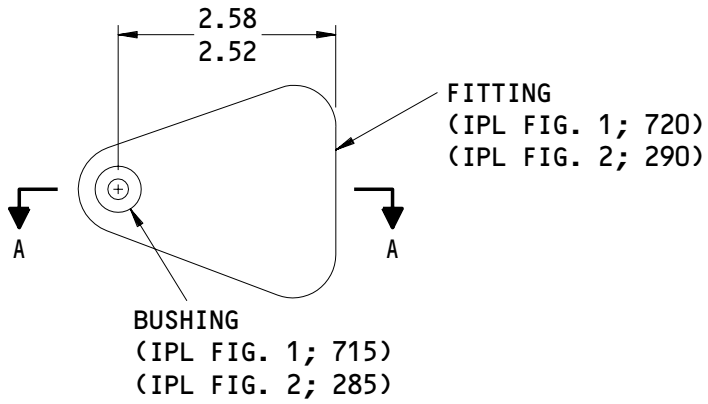
125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

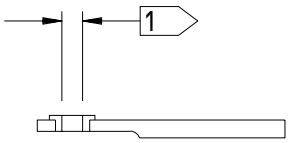
BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

113T1126-7
Fitting Assembly Repair
Figure 601

K23929





A–A

1 THE FINAL INNER DIAMETER OF THE BUSHING IS MACHINED ON THE 113T1116. SEE REPAIR 3-1

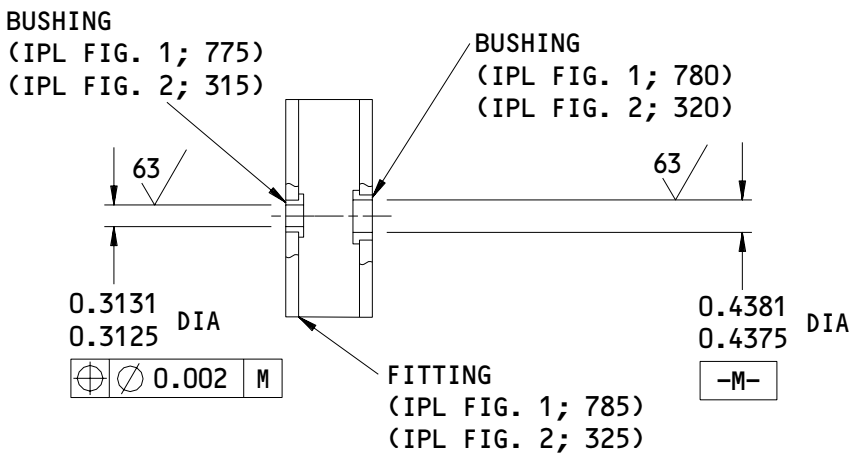
125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

113T1126-8
Fitting Assembly Repair
Figure 602

K23930



125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

113T1126-21,-22
Fitting Assembly Repair
Figure 603

K23931

FITTING - REPAIR 6-2

113T1126-9, -10, -23, -24

1. General

A. This repair gives the data that is necessary to repair and refinish the fitting (IPL Fig. 1; 705, 720, 785), (IPL Fig. 2; 275, 290, 325).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices shown in the repair.

C. Refer to the REPAIR - GENERAL (57-54-41/601, REPAIR - GENERAL) for the Standard True Position Dimensioning Symbols shown in the repair.

D. Refer to IPL Fig. 1 and 2 for item numbers.

E. General repair details:

(1) Material: Aluminum alloy

(2) Shot peen: Shot Number 230-460
Intensity 0.010A
Coverage 2.0

2. Bushing Hole Repair

A. References

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

(2) SOPM 20-20-01, Magnetic Particle Inspection

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

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

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

B. Procedure

(1) Machine the worn or damaged hole for the bushings (IPL Fig. 1; 700, 715, 775, 780), (IPL Fig. 2; 270, 285, 315, 320) as necessary, to remove defects, cracks, and/or corrosion up to the limit shown in Fig. 601.

(2) Break all the sharp edges to a radius of 0.02-0.03 inch.

(3) Do a penetrant check as shown in the SOPM 20-20-02.

(4) Shot peen the machined area as shown in the SOPM 20-10-03.

(5) Machine the hole to the finish shown in Fig. 601, 602 and 603.

(6) Oversize bushings

(a) Make the repair bushing for bushing (IPL Fig. 1; 700, 780), (IPL Fig. 2; 270, 320) as shown in Fig. 604 and in the following instructions.

1) Bushing Material: Al-Ni-Bronze, AMS 4640

2) Break all the sharp edges.

3) Do a penetrant check as shown in SOPM 20-20-02.

4) Prepare the surface and cadmium plate (F-15.06) as shown in SOPM 20-42-05.

5) Be sure the interference between the bushing O. D. and the oversize hole I. D. as shown in Fig. 604.

6) Install the oversize repair bushing as shown in REPAIR 6-1.

(b) Make the repair bushing for bushing (IPL Fig. 1; 715, 775), (IPL Fig. 2; 285, 315) as shown in Fig. 605 and in the following instructions.

1) Bushing Material: 15-5PH, AMS 5659, 40-43 HRC, or
17-4PH, AMS 5643, 40-43 HRC

2) Break all the sharp edges.

3) Do a magnetic particle check as shown in SOPM 20-20-01.

4) Prepare the surface and cadmium plate (F-15.06) as shown in SOPM 20-42-05.

5) Be sure the interference between the bushing O. D. and the oversize hole I. D. is as shown in Fig. 605.

6) Install the oversize repair bushing as shown in REPAIR 6-1.

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

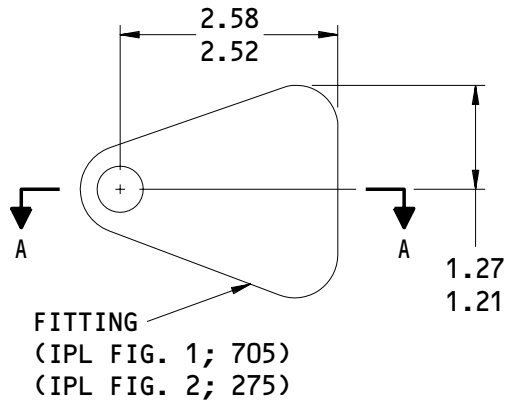
(3) SOPM 20-41-02, Application of Chemical and Solvent Resistant Finishes

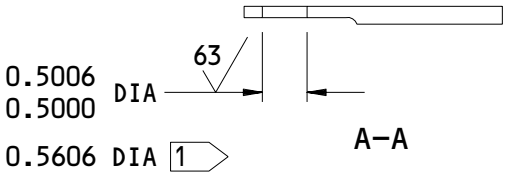
(4) SOPM 20-43-01, Chromic Acid Anodize

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

C. Procedure

(1) Chromic acid anodize and apply BMS 10-11, Type 1 primer (F-18.13). No primer in bushing bores.





1 REPAIR LIMIT

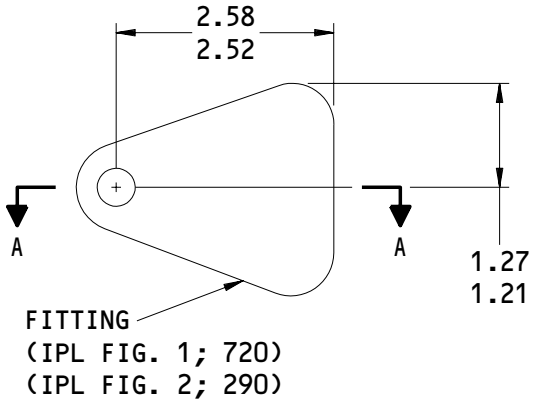
125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

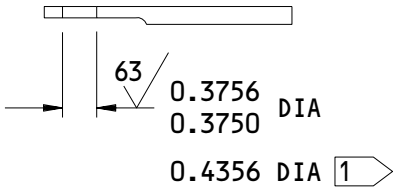
BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

113T1126-9
Fitting Repair
Figure 601

K23932





A–A

1 REPAIR LIMIT

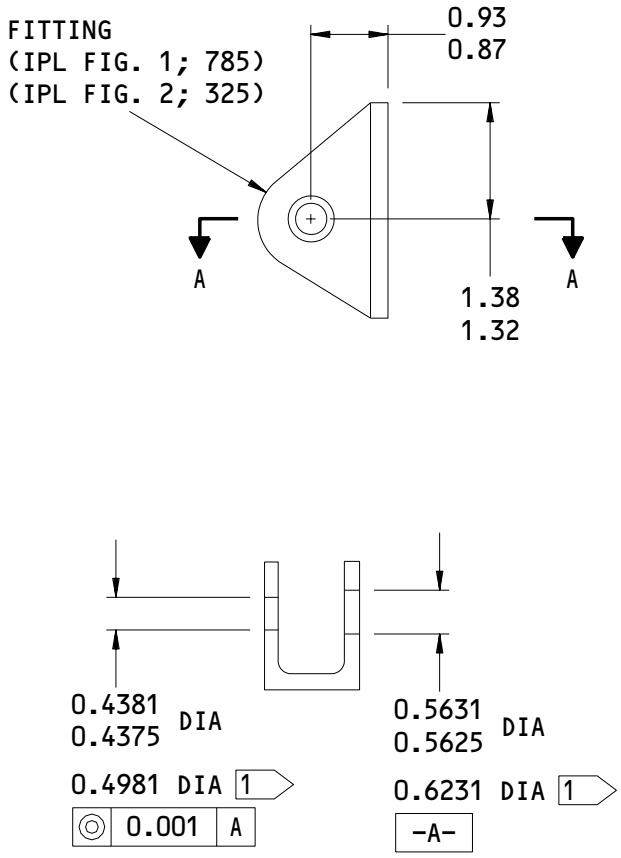
125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

113T1126-10
Fitting Repair
Figure 602

K23933



A–A

1 REPAIR LIMIT

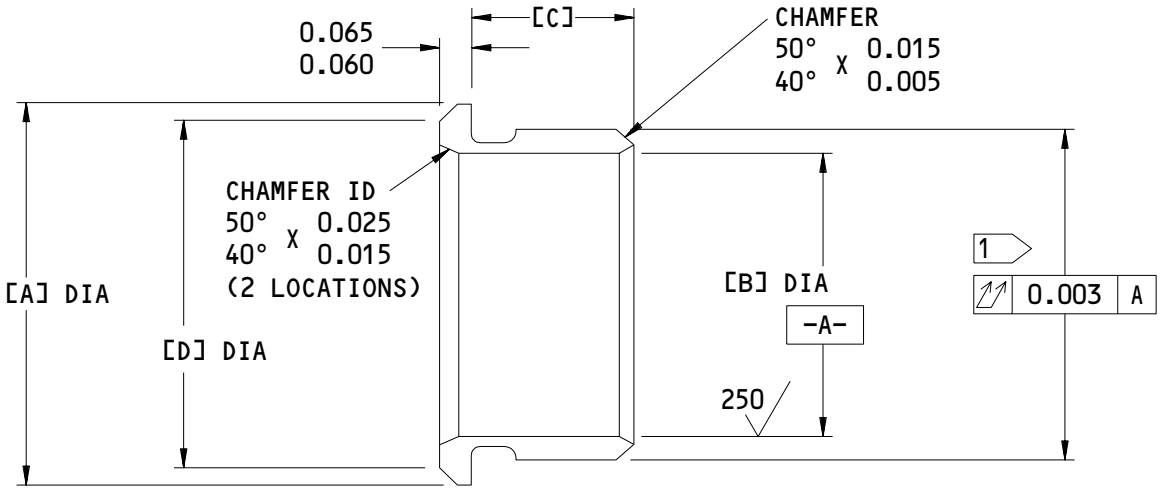
125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

113T1126-23,-24
Fitting Repair
Figure 603

K23934



OVERSIZE REPLACEMENT BUSHING

BUSHING ITEM NO.	[A]	[B]	[C]	[D]	INTERFERENCE
FIG. 1; 700 FIG. 2; 270	0.6300 0.6200	0.3660 0.3590	0.1000 0.0950	0.5400 0.5300	0.0004 0.0016
FIG. 1; 780 FIG. 2; 320	0.6900 0.6800	0.4280 0.4220	0.1400 0.1350	0.5900 0.5800	0.0005 0.0017

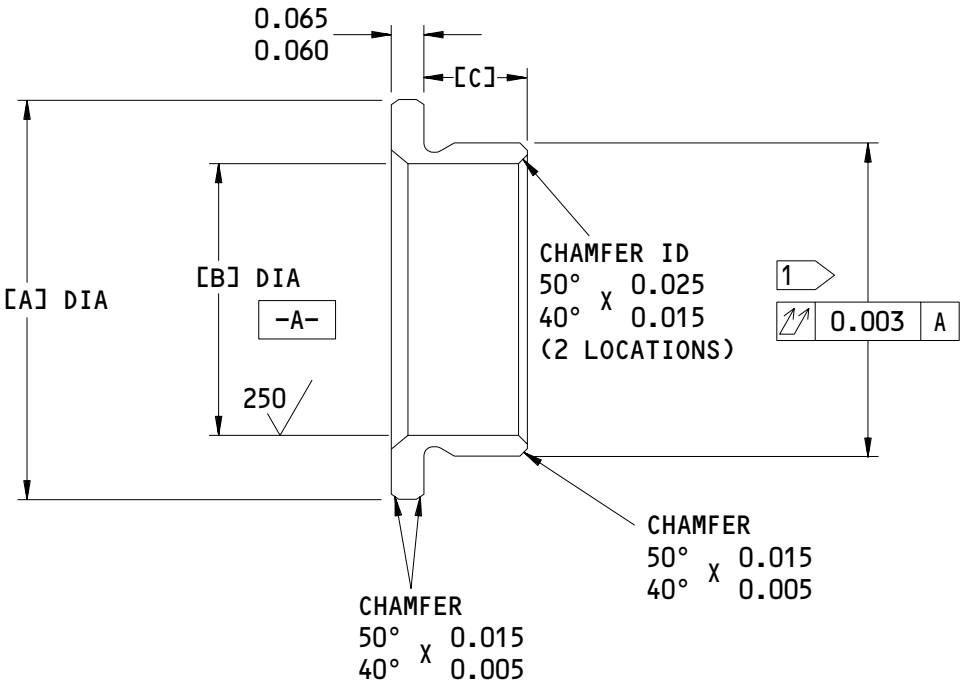
1 THE OUTSIDE DIAMETER OF THE BUSHING IS EQUAL TO THE FITTING HOLE PLUS INTERFERENCE

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

ALL DIMENSIONS ARE IN INCHES

Repair Bushing Details
Figure 604

K23291



OVERSIZE REPLACEMENT BUSHING

BUSHING ITEM NO.	[A]	[B]	[C]	INTERFERENCE
FIG. 1; 715 FIG. 2; 285	0.5400 0.5300	0.2410 0.2340	0.1000 0.0950	0.0014 0.0003
FIG. 1; 775 FIG. 2; 315	0.6100 0.6000	0.3030 0.2970	0.1300 0.1250	0.0014 0.0003

1 THE OUTSIDE DIAMETER OF THE BUSHING IS EQUAL TO THE FITTING HOLE PLUS INTERFERENCE

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

ALL DIMENSIONS ARE IN INCHES

Repair Bushing Details
Figure 605

K23935

FITTING ASSEMBLY - REPAIR 7-1

113T1155-1, -3

1. General

A. This repair gives the data that is necessary to repair the fitting assembly (IPL Fig. 1; 315, 320) and (IPL Fig. 2; 50, 55).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices shown in the repair.

C. Refer to the REPAIR - GENERAL (57-54-41/601, REPAIR-GENERAL) for the standard true position dimensioning symbols shown in the repair.

D. Refer to IPL Fig. 1 and 2 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 of Boeing Finish Codes

(2) SOPM 20-50-03, Bearing Removal, Installation and Retention

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

C. Procedure

(1) Replace the bushings in the fitting assembly.

(a) Remove the bushings (IPL Fig. 1; 325, 330A) from the fitting assembly (IPL Fig. 1; 315, 320).

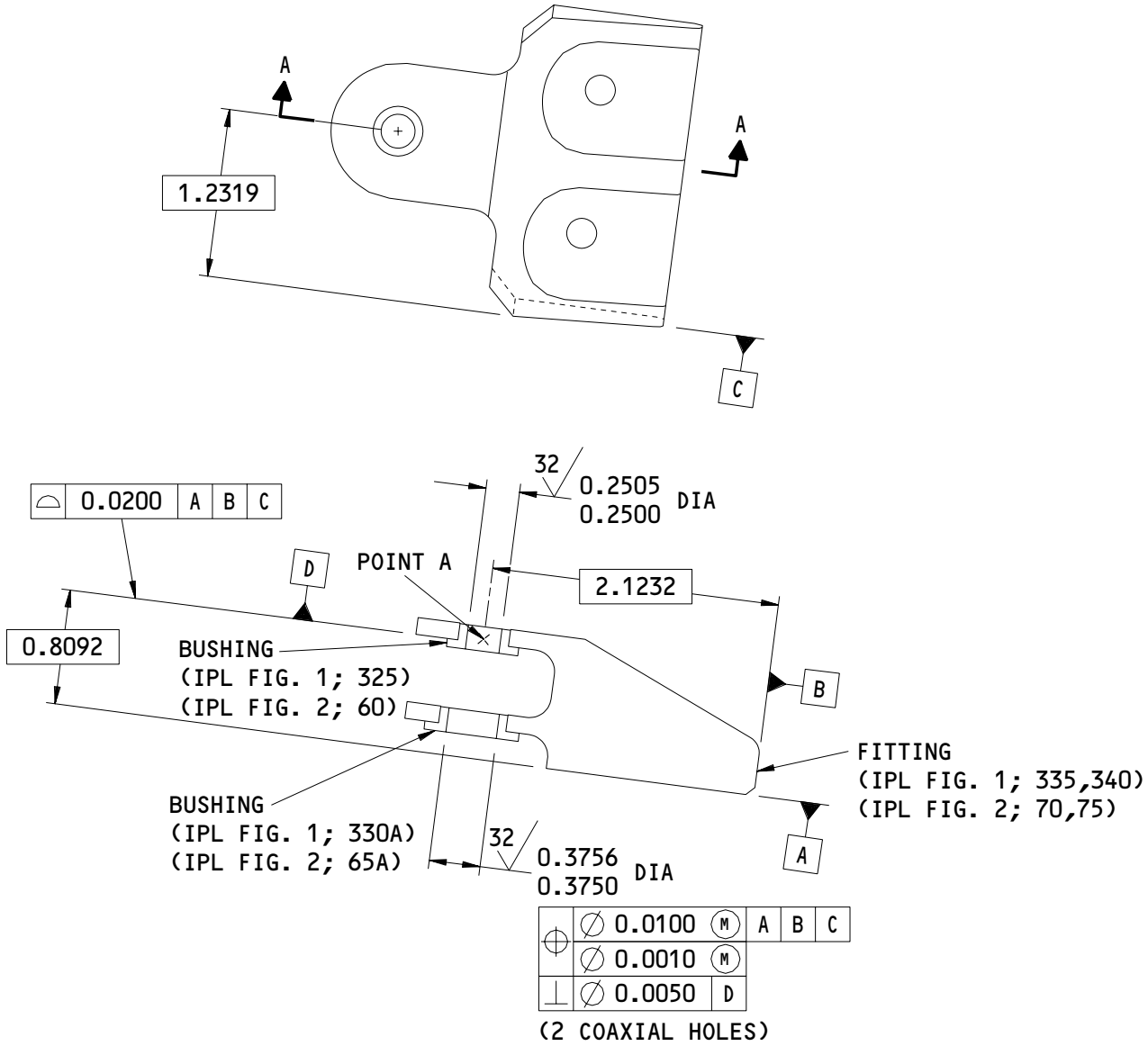
(b) Remove the bushings (IPL Fig. 2; 60, 65A) from the fitting assembly (IPL Fig. 2; 50, 55).

(c) Install the bushings into the fittings with BMS 5-95 sealant and as shown in the SOPM 20-50-03.

(d) Machine the bushings inside diameter to the dimensions and finish shown in Fig. 601.

(e) Break all sharp edges to a radius of 0.02-0.03 inch.

(f) Fillet seal around the flanges of the bushings using BMS 5-95 sealant.



A–A

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

113T1155-1,-3
Fitting Assembly Repair
Figure 601

K23938

FITTING - REPAIR 7-2

113T1155-2, -4

1. General

A. This repair gives the data that is necessary to repair and refinish the fitting (IPL Fig. 1; 335, 340), (IPL Fig. 2; 70, 75).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices shown in the repair.

C. Refer to the REPAIR - GENERAL (57-54-41/601, REPAIR - GENERAL) for the Standard True Position Dimensioning Symbols shown in the repair.

D. Refer to IPL Fig. 1 and 2 for item numbers.

E. General repair details:

(1) Material: Aluminum alloy

(2) Shot peen: Intensity 0.008A
Coverage 2.0

2. Bushing Hole Repair

A. References

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

(2) SOPM 20-20-01, Magnetic Particle Inspection

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

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

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

B. Procedure

(1) Machine the worn or damaged hole for the bushings (IPL Fig. 1; 325, 330A), (IPL Fig. 2; 60, 65A) as necessary, to remove defects, cracks, and/or corrosion up to the limit shown in Fig. 601.

(2) Break all the sharp edges to a radius of 0.02-0.03 inch.

(3) Do a penetrant check as shown in the SOPM 20-20-02.

(4) Shot peen the machined area as shown in the SOPM 20-10-03.

(5) Machine the hole to the finish shown in Fig. 601.

(6) Oversize bushings

(a) Make the repair bushing for bushing (IPL Fig. 1; 325), (IPL Fig. 2; 60) as shown in Fig. 602 and in the following instructions.

1) Bushing Material: 15-5PH, AMS 5659, 40-43 HRC or 17-4PH, AMS 5643, 40-43 HRC

2) Break all the sharp edges.

3) Do a magnetic particle check as shown in SOPM 20-20-01.

4) Prepare the surface and cadmium plate (F-15.06) as shown in SOPM 20-42-05.

5) Be sure the interference between the bushing O. D. and the oversize hole I. D. is as shown in Fig. 602.

6) Install the oversize repair bushing as shown in REPAIR 7-1.

(b) Make the repair bushing for bushing (IPL Fig. 1; 330A), (IPL Fig. 2; 65A) as shown in Fig. 602 and in the following instructions.

1) Bushing Material: AL-Bronze, AMS 4640, HR 50

2) Break all the sharp edges.

3) Do a penetrant check as shown in SOPM 20-20-02.

4) Prepare the surface and cadmium plate (F-15.06) as shown in SOPM 20-42-05.

5) Be sure the interference between the bushing O. D. and the oversize hole I. D. is as shown in Fig. 602.

6) Install the oversize repair bushing as shown in REPAIR 7-1.

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

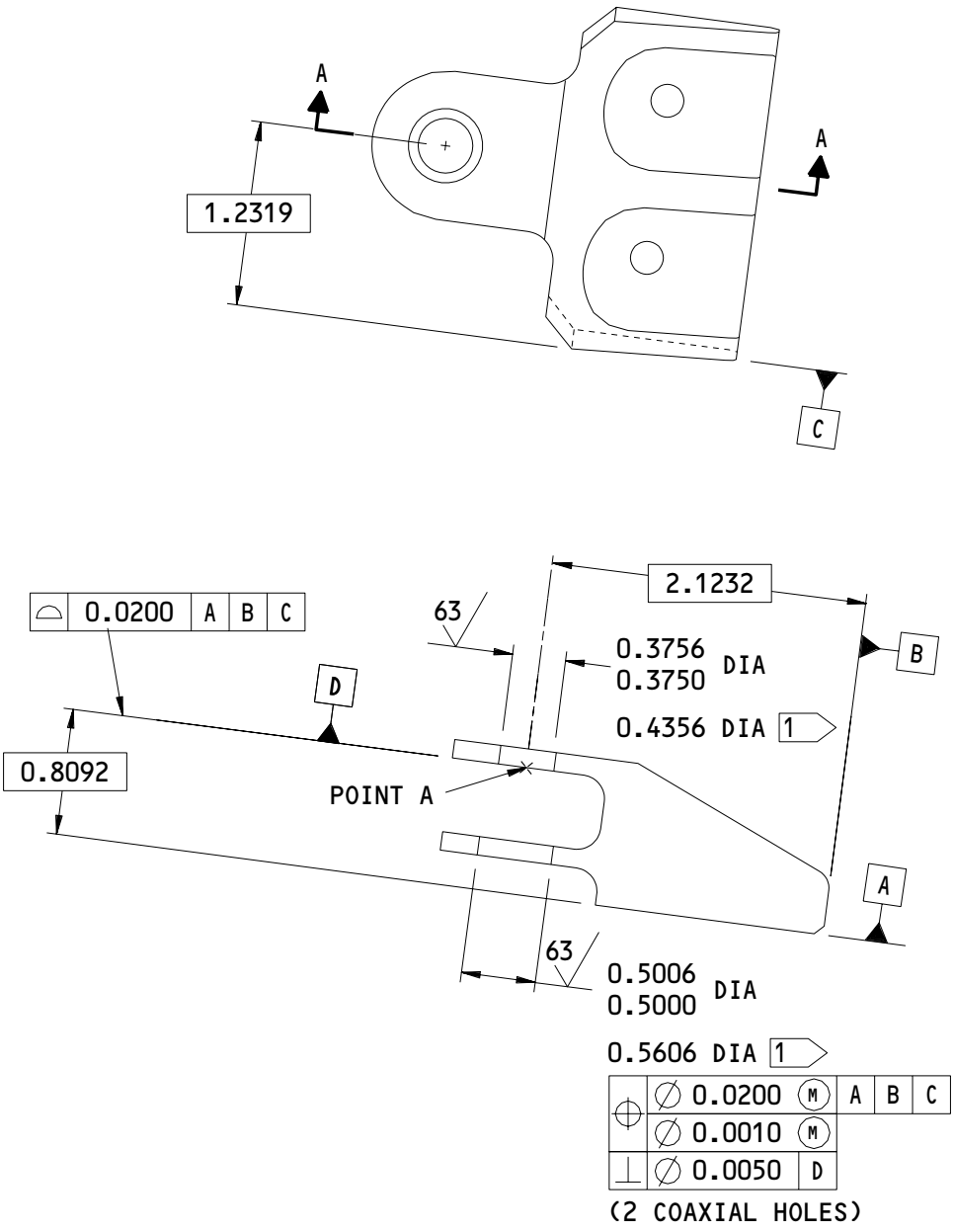
(4) SOPM 20-43-01, Chromic Acid Anodize

(5) 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-20.02). No primer in bushing bores.



A–A

1 REPAIR LIMIT

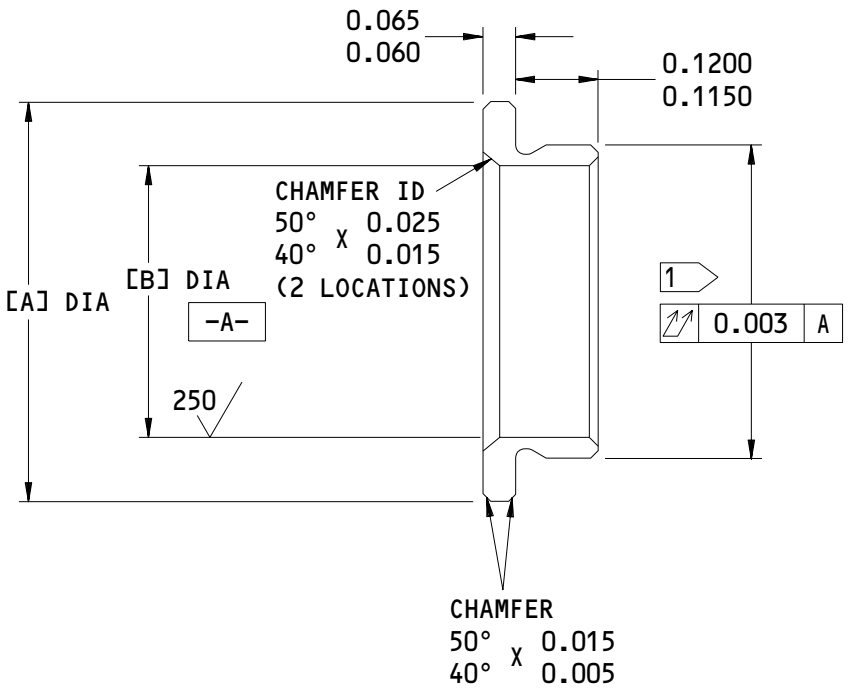
125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

113T1155-2,-4
Fitting Repair
Figure 601

K23939



OVERSIZE REPLACEMENT BUSHING

REPLACES BUSHING	[A]	[B]	INTER-FERENCE
FIG. 1; 325 FIG. 2; 60	0.5400 0.5300	0.2410 0.2340	0.0014 0.0003
FIG. 1; 330A FIG. 2; 65A	0.6300 0.6200	0.3660 0.3590	0.0015 0.0004

1 THE OUTSIDE DIAMETER OF THE BUSHING IS EQUAL TO THE FITTING HOLE PLUS INTERFERENCE

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

Repair Bushing Details
Figure 602

FITTING ASSEMBLY - REPAIR 8-1

113T1156-1, -2

1. General

   A. This repair gives the data that is necessary to repair the fitting assembly (IPL Fig. 1; 515) and (IPL Fig. 2; 160).

   B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices shown in the repair.

   C. Refer to the REPAIR - GENERAL (57-54-41/601, REPAIR-GENERAL) for the standard true position dimensioning symbols shown in the repair.

   D. Refer to IPL Fig. 1 and 2 for item numbers.

2. Bushing Replacement

   A. Consumable Materials

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

   B. References

      (1) SOPM 20-44-01, Decoding of Boeing Finish Codes

      (2) SOPM 20-50-03, Bearing Removal, Installation and Retention

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

   C. Procedure

      (1) Replace the bushings in the fitting assembly.

         (a) Remove the bushings (IPL Fig. 1; 520, 525, 530, 535) from the fitting assembly (IPL Fig. 1; 515).

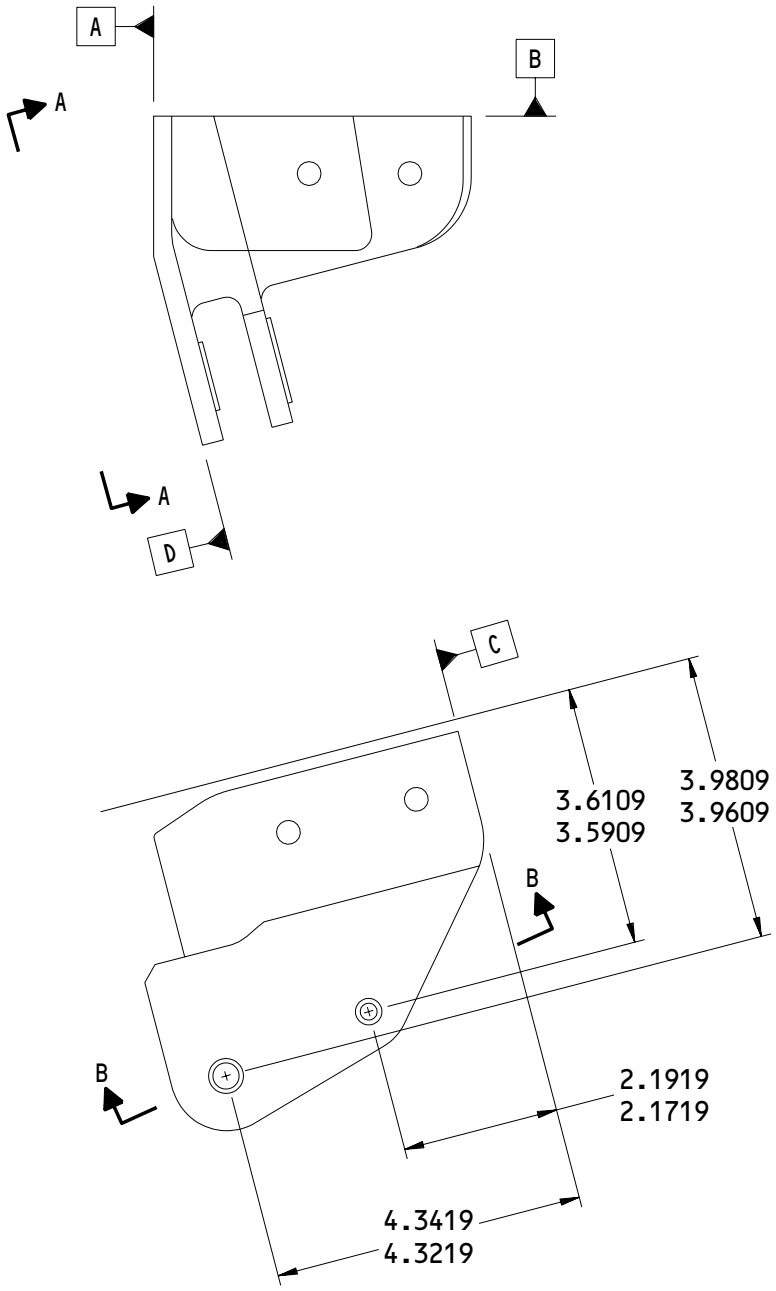
         (b) Remove the bushings (IPL Fig. 2; 165, 170, 175, 180) from the fitting assembly (IPL Fig. 2; 160).

         (c) Install the bushings into the fittings with BMS 5-95 sealant and as shown in the SOPM 20-50-03.

         (d) Machine the bushings inside diameter to the dimensions and finish shown in Fig. 601.

(e) Break all sharp edges to a radius of 0.02-0.03 inch.

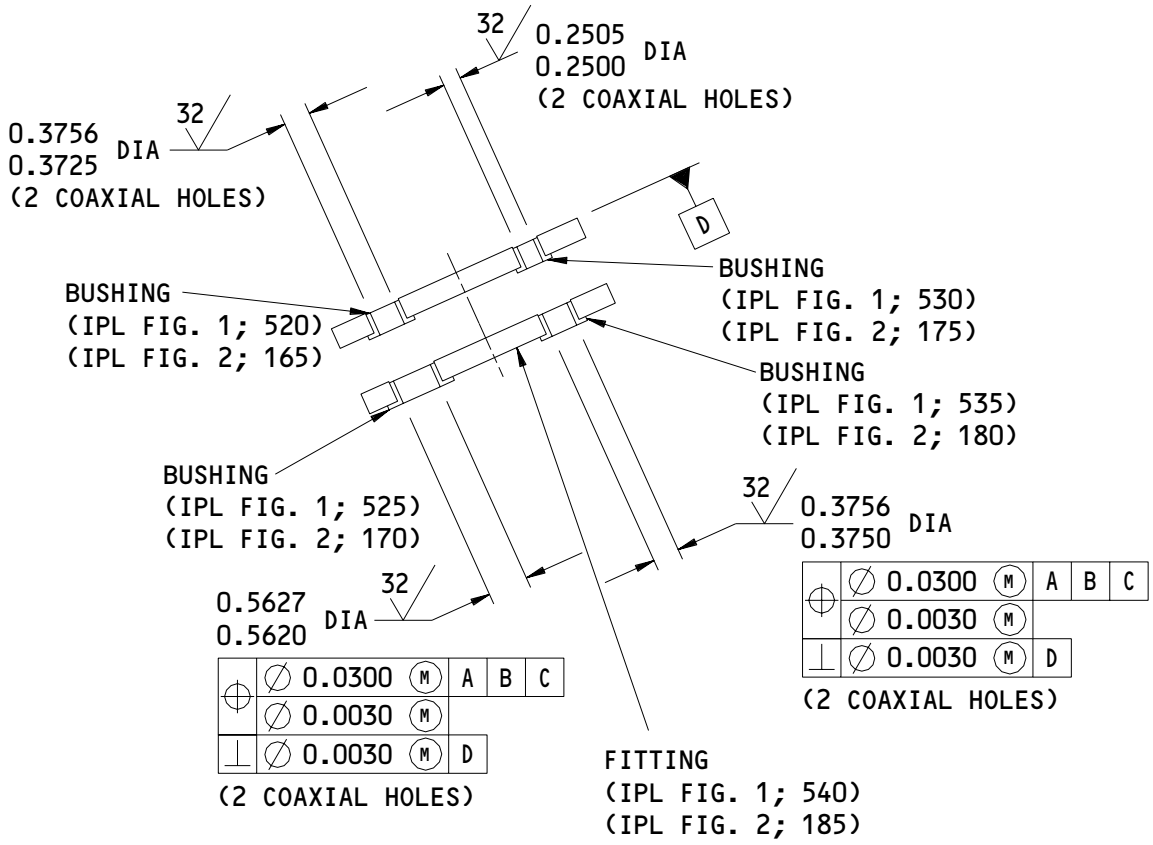
(f) Fillet seal around the flanges of the bushings using BMS 5-95 sealant.



A–A

113T1156-1,-2
Fitting Assembly Repair
Figure 601 (Sheet 1)

K23942



B–B

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

113T1156-1,-2
Fitting Assembly Repair
Figure 601 (Sheet 2)

K23943

FITTING - REPAIR 8-2

113T1156-3, -4

1. General

A. This repair gives the data that is necessary to repair and refinish the fitting (IPL Fig. 1; 540), (IPL Fig. 2; 185).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices shown in the repair.

C. Refer to the REPAIR - GENERAL (57-54-41/601, REPAIR - GENERAL) for the Standard True Position Dimensioning Symbols shown in the repair.

D. Refer to IPL Fig. 1 and 2 for item numbers.

E. General repair details:

(1) Material: Aluminum alloy

(2) Shot peen: Intensity 0.014A
Coverage 2.0

2. Bushing Hole Repair

A. References

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

(2) SOPM 20-20-01, Magnetic Particle Inspection

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

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

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

B. Procedure

(1) Machine the worn or damaged hole for the bushings (IPL FIg. 1; 520, 525, 530, 535), (IPL Fig. 2; 165, 170, 175, 180) as necessary, to remove defects, cracks, and/or corrosion up to the limit shown in Fig. 601.

(2) Break all the sharp edges to a radius of 0.02-0.03 inch.

(3) Do a penetrant check as shown in the SOPM 20-20-02.

(4) Shot peen the machined area as shown in the SOPM 20-10-03.

(5) Machine the hole to the finish shown in Fig. 601.

(6) Oversize bushings

(a) Make the repair bushing for bushing (IPL Fig. 1; 520, 530), (IPL Fig. 2; 165, 175) as shown in Fig. 602 and in the following instructions.

1) Bushing Material: 15-5PH, AMS 5659, 40-43 HRC or 17-4PH, AMS 5643, 40-43 HRC

2) Break all the sharp edges.

3) Do a magnetic particle check as shown in SOPM 20-20-01.

4) Prepare the surface and cadmium plate (F-15.06) as shown in SOPM 20-42-05.

5) Be sure the interference between the bushing O. D. and the oversize hole I. D. is as shown in Fig. 602.

6) Install the oversize repair bushing as shown in REPAIR 8-1.

(b) Make the repair bushing for bushing (IPL Fig. 1; 525, 535), (IPL Fig. 2; 170, 180) as shown in Fig. 602 and in the following instructions.

1) Bushing Material: AL-Bronze, AMS 4640, HR50

2) Break all the sharp edges.

3) Do a penetrant check as shown in SOPM 20-20-02.

4) Prepare the surface and cadmium plate (F-15.06) as shown in SOPM 20-42-05.

5) Be sure the interference between the bushing O. D. and the oversize hole I. D. is as shown in Fig. 602.

6) Install the oversize repair bushing as shown in REPAIR 8-1.

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

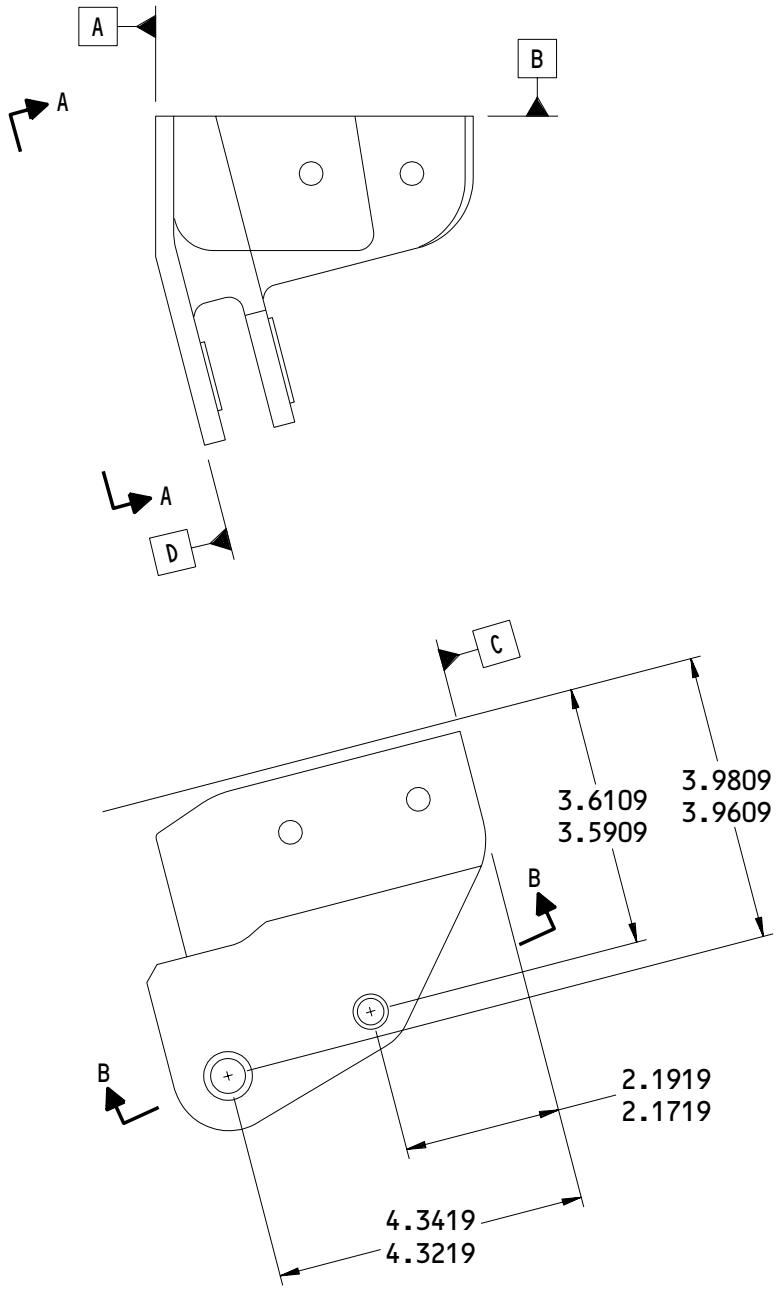
(4) SOPM 20-43-01, Chromic Acid Anodize

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

C. Procedure

(1) Boric acid-sulfuric acid anodize (F-17.31).

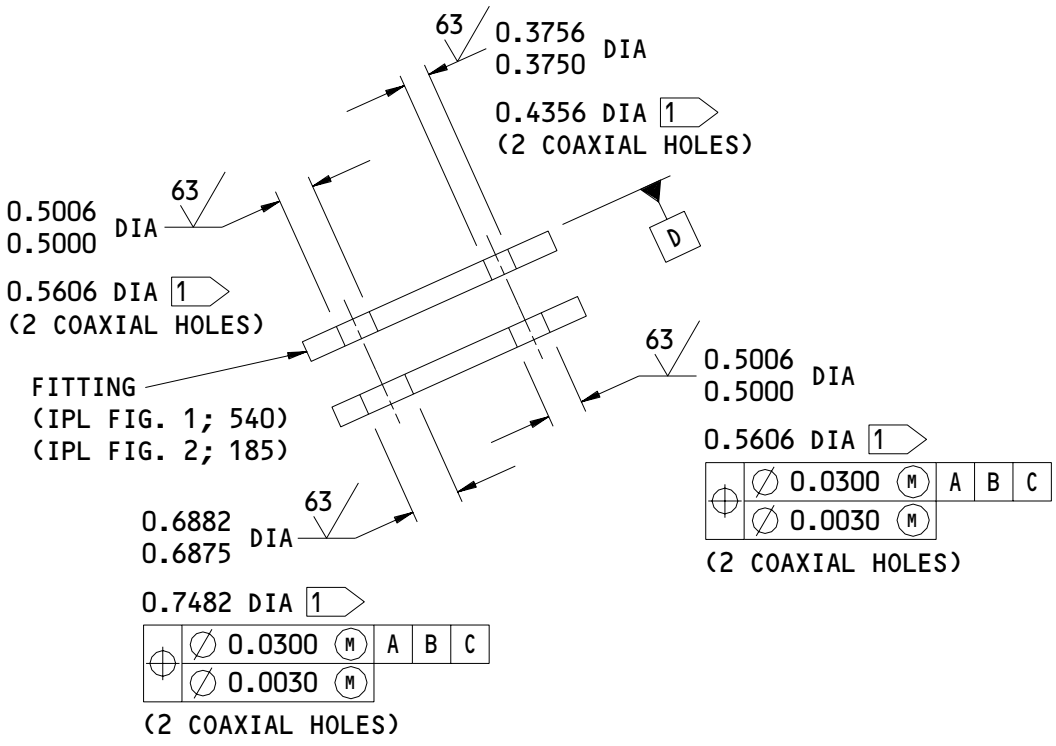
(2) Apply BMS 10-11, Type 1 primer (F-20.02). No primer in bushing bores.



A–A

113T1156-3,-4
Fitting Repair
Figure 601 (Sheet 1)

K23944



B–B

1 REPAIR LIMIT

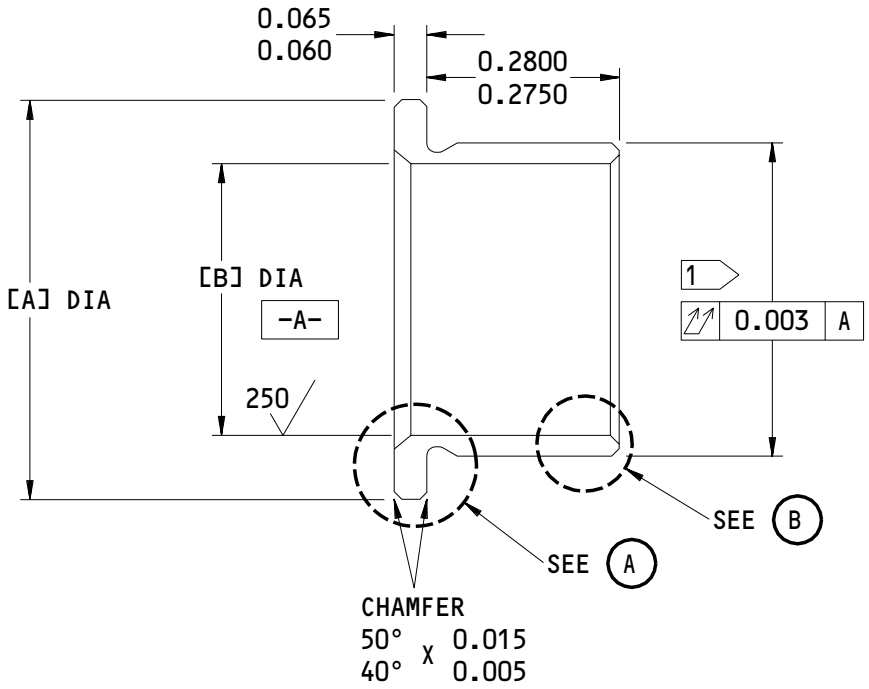
125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

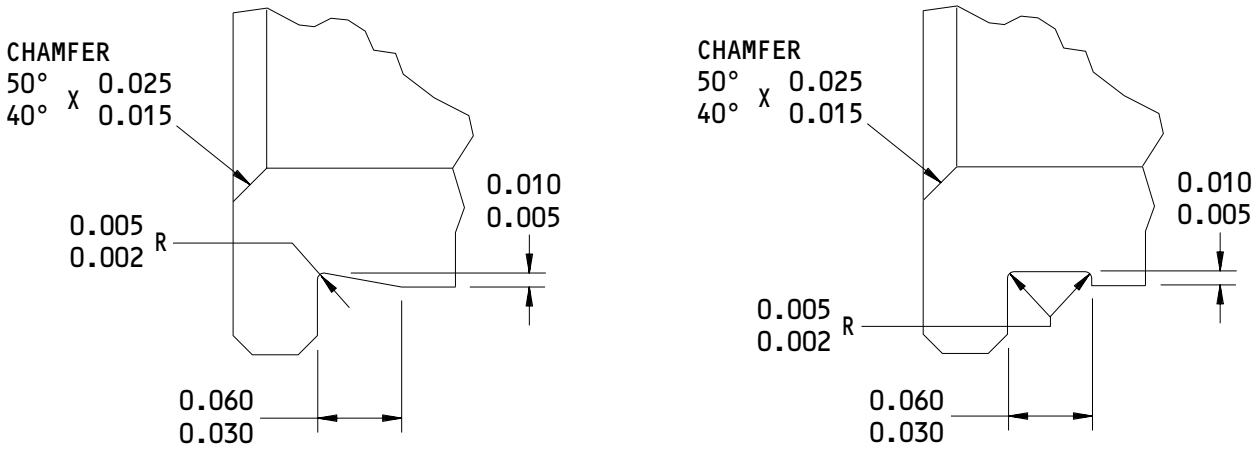
ALL DIMENSIONS ARE IN INCHES

113T1156-3,-4
Fitting Repair
Figure 601 (Sheet 2)

K23946



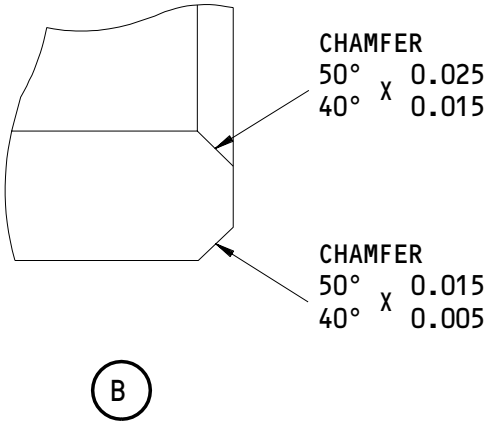
OVERSIZE REPLACEMENT BUSHING



A

Repair Bushing Details
Figure 602 (Sheet 1)

K23947



REPLACES BUSHING	[A]	[B]	INTER-FERENCE
FIG. 1; 520 FIG. 2; 165	0.7100 0.7000	0.3660 0.3590	0.0015 0.0004
FIG. 1; 525 FIG. 2; 170	0.8100 0.8000	0.5530 0.5470	0.0018 0.0006
FIG. 1; 530 FIG. 2; 175	0.5400 0.5300	0.2410 0.2340	0.0014 0.0003
FIG. 1; 535 FIG. 2; 180	0.6300 0.6200	0.3660 0.3590	0.0015 0.0004

1 THE OUTSIDE DIAMETER OF THE BUSHING IS EQUAL TO THE FITTING HOLE PLUS INTERFERENCE

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

Repair Bushing Details
Figure 602 (Sheet 2)

K23948

FITTING ASSEMBLY - REPAIR 9-1

113T1157-1, -2

1. General

   A. This repair gives the data that is necessary to repair the fitting assembly (IPL Fig. 1; 735) and (IPL Fig. 2; 235).

   B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices shown in the repair.

   C. Refer to the REPAIR - GENERAL (57-54-41/601, REPAIR-GENERAL) for the standard true position dimensioning symbols shown in the repair.

   D. Refer to IPL Fig. 1 and 2 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 of Boeing Finish Codes

      (2) SOPM 20-50-03, Bearing Removal, Installation and Retention

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

   C. Procedure

      (1) Replace the bushings in the fitting assembly.

         (a) Remove the bushings (IPL Fig. 1; 740, 745) from the fitting assembly (IPL Fig. 1; 735).

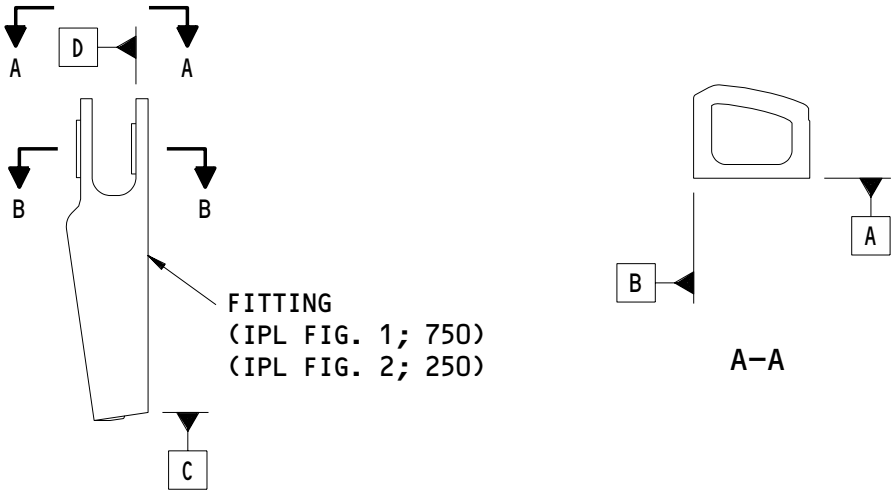
         (b) Remove the bushings (IPL Fig. 2; 240, 245) from the fitting assembly (IPL Fig. 2; 235).

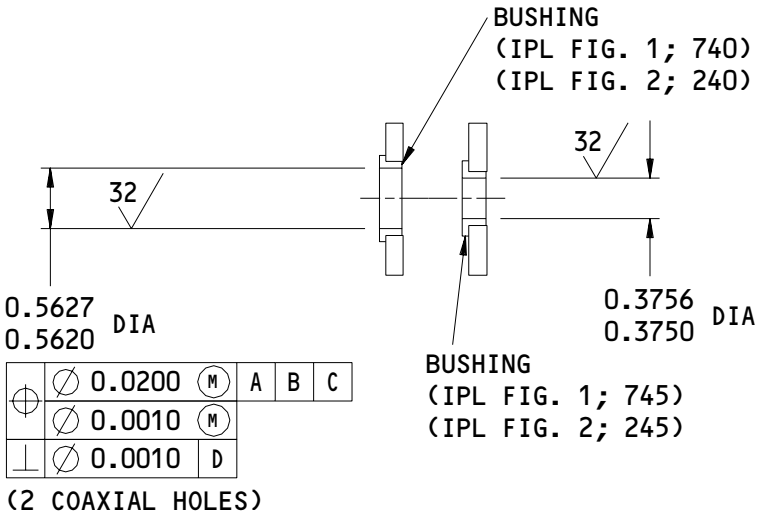
         (c) Install the bushings into the fittings with BMS 5-95 sealant and as shown in the SOPM 20-50-03.

         (d) Machine the bushings inside diameter to the dimensions and finish shown in Fig. 601.

(e) Break all sharp edges to a radius of 0.02-0.03 inch.

(f) Fillet seal around the flanges of the bushings using BMS 5-95 sealant.





125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

113T1157-2
Fitting Assembly Repair
Figure 601

K23949

FITTING - REPAIR 9-2

113T1157-3, -4

1. General

A. This repair gives the data that is necessary to repair and refinish the fitting (IPL Fig. 1; 750), (IPL Fig. 2; 235).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices shown in the repair.

C. Refer to the REPAIR - GENERAL (57-54-41/601, REPAIR - GENERAL) for the Standard True Position Dimensioning Symbols shown in the repair.

D. Refer to IPL Fig. 1 and 2 for item numbers.

E. General repair details:

(1) Material: Aluminum alloy

(2) Shot peen: Intensity 0.010A
Coverage 2.0

2. Bushing Hole Repair

A. References

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

(2) SOPM 20-20-01, Magnetic Particle Inspection

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

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

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

B. Procedure

(1) Machine the worn or damaged hole for the bushings (IPL Fig. 1; 740, 745), (IPL Fig. 2; 240, 245) as necessary, to remove defects, cracks, and/or corrosion up to the limit shown in Fig. 601.

(2) Break all the sharp edges to a radius of 0.02-0.03 inch.

(3) Do a penetrant check as shown in the SOPM 20-20-02.

(4) Shot peen the machined area as shown in the SOPM 20-10-03.

(5) Machine the hole to the finish shown in Fig. 601.

(6) Oversize bushings

(a) Make the repair bushing for bushing (IPL Fig. 1; 745), (IPL Fig. 2; 245) as shown in Fig. 602 and in the following instructions.

1) Bushing Material: 15-5PH, AMS 5659, 40-43 HRC or 17-4PH, AMS 5643, 40-43 HRC

2) Break all the sharp edges.

3) Do a magnetic particle check as shown in SOPM 20-20-01.

4) Prepare the surface and cadmium plate (F-15.06) as shown in SOPM 20-42-05.

5) Be sure the interference between the bushing O. D. and the oversize hole I. D. is as shown in Fig. 602.

6) Install the oversize repair bushing as shown in REPAIR 9-1.

(b) Make the repair bushing for bushing (IPL Fig. 1; 740), (IPL Fig. 2; 240) as shown in Fig. 602 and in the following instructions.

1) Bushing Material: AL-Bronze, AMS 4640, HR 50

2) Break all the sharp edges.

3) Do a penetrant check as shown in SOPM 20-20-02.

4) Prepare the surface and cadmium plate (F-15.06) as shown in SOPM 20-42-05.

5) Be sure the interference between the bushing O. D. and the oversize hole I. D. is as shown in Fig. 602.

6) Install the oversize repair bushing as shown in REPAIR 9-1.

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

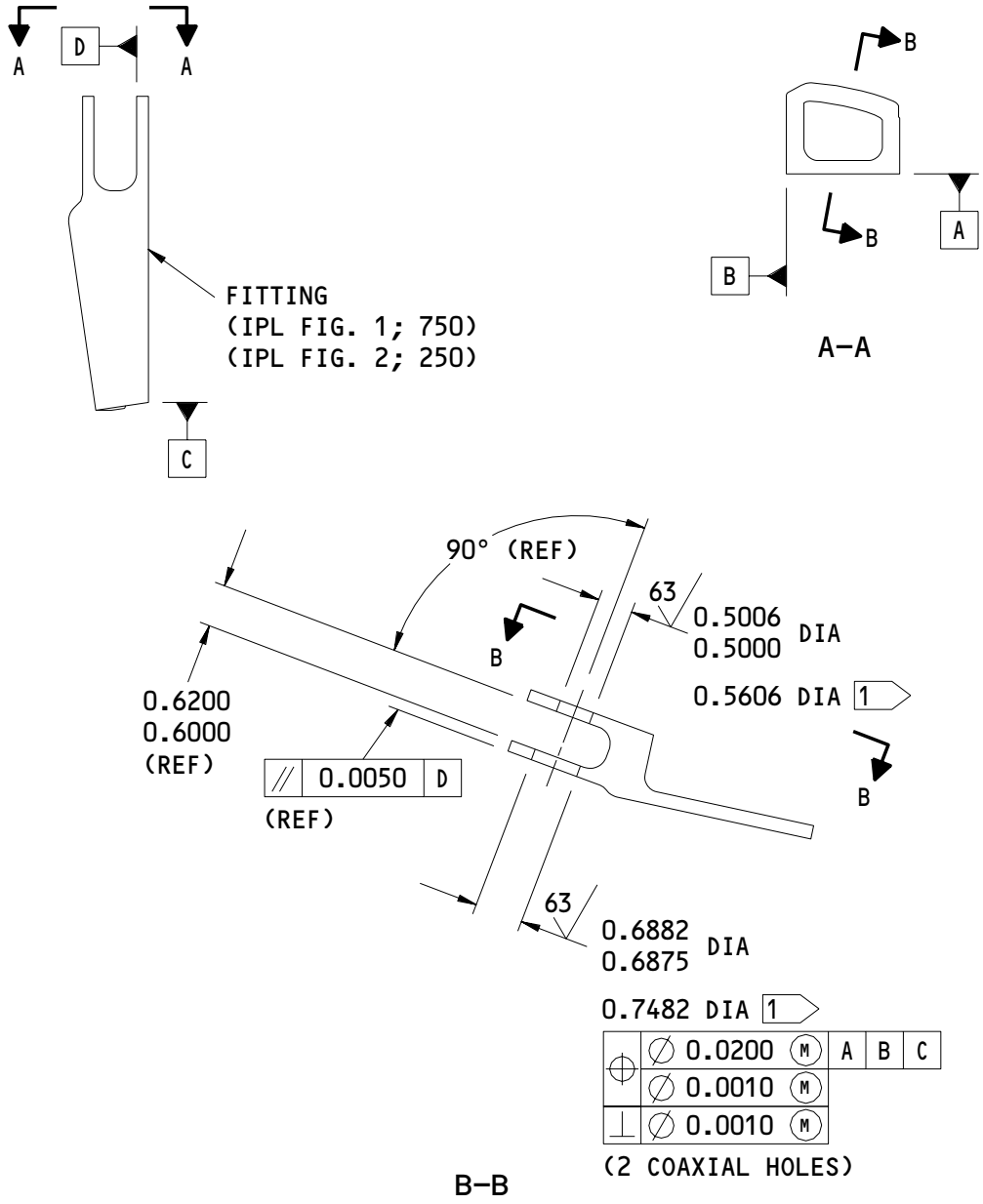
(4) SOPM 20-43-01, Chromic Acid Anodize

(5) 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-20.02). No primer in bushing bores.



1 REPAIR LIMIT

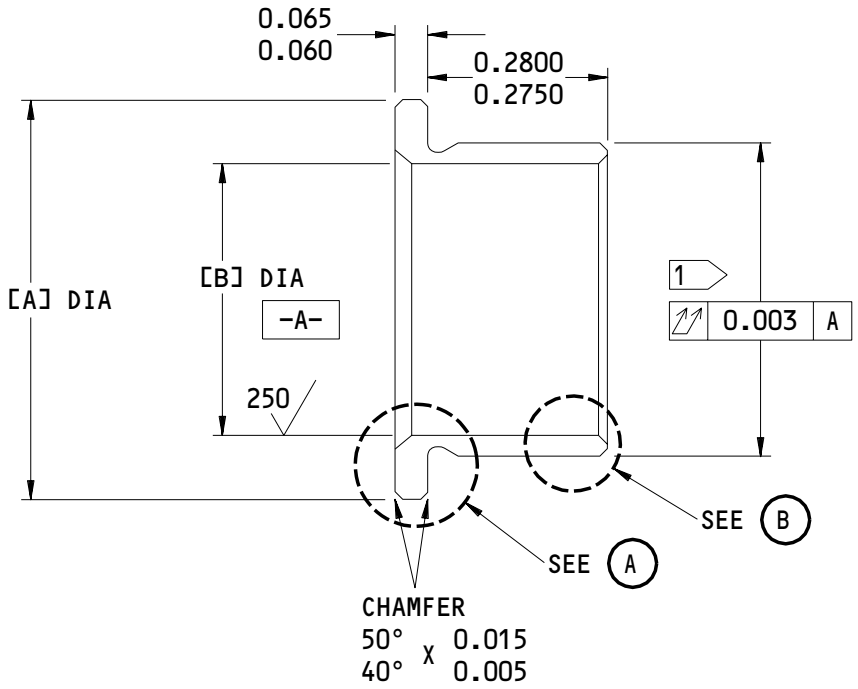
125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

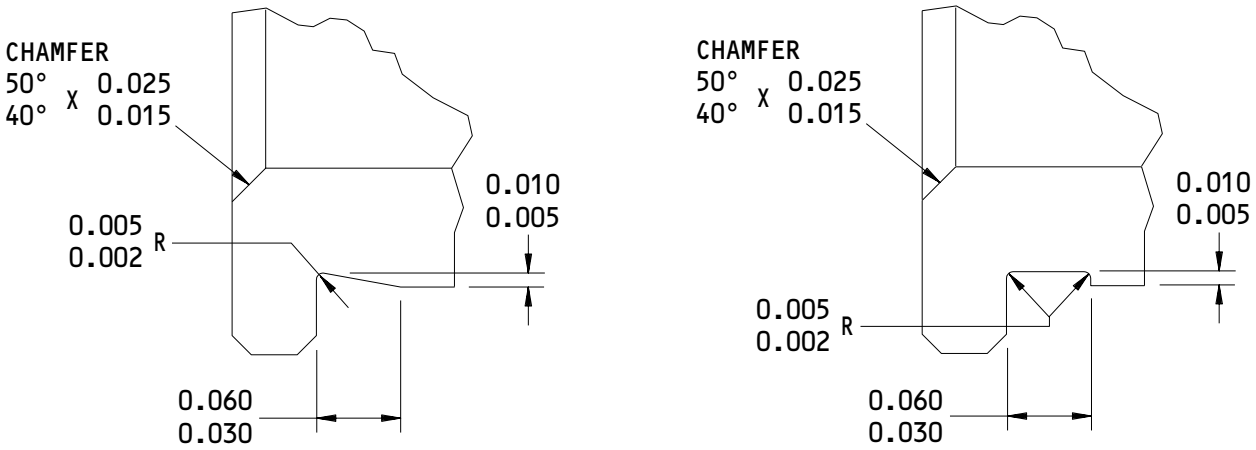
ALL DIMENSIONS ARE IN INCHES

113T1157-4
Fitting Repair
Figure 601

K23950



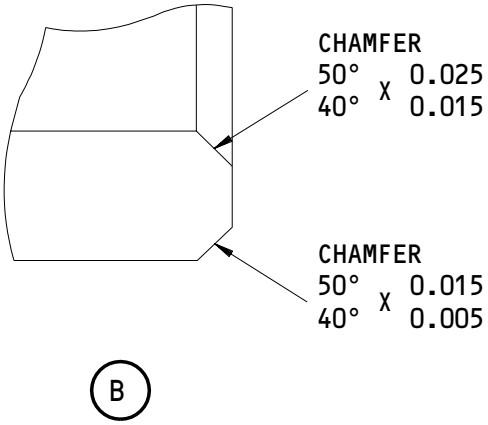
OVERSIZE REPLACEMENT BUSHING



A

Repair Bushing Details
Figure 602 (Sheet 1)

K23951



REPLACES BUSHING	[A]	[B]	INTER-FERENCE
FIG. 1; 745 FIG. 2; 245	0.7100 0.7000	0.3660 0.3590	0.0015 0.0004
FIG. 1; 740 FIG. 2; 240	0.8100 0.8000	0.5530 0.5470	0.0018 0.0006

1 THE OUTSIDE DIAMETER OF THE BUSHING IS EQUAL TO THE FITTING HOLE PLUS INTERFERENCE

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

Repair Bushing Details
Figure 602 (Sheet 2)

K23952

FITTING ASSEMBLY - REPAIR 10-1

113T1158-1, -2

1. General

A. This repair gives the data that is necessary to repair the fitting assembly (IPL Fig. 1; 480) and (IPL Fig. 2; 125).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices shown in the repair.

C. Refer to the REPAIR - GENERAL (57-54-41/601, REPAIR-GENERAL) for the standard true position dimensioning symbols shown in the repair.

D. Refer to IPL Fig. 1 and 2 for item numbers.

2. Bushing Replacement

A. References

(1) SOPM 20-50-03, Bearing Removal, Installation and Retention

B. Procedure

(1) Replace the bushings in the fitting assembly.

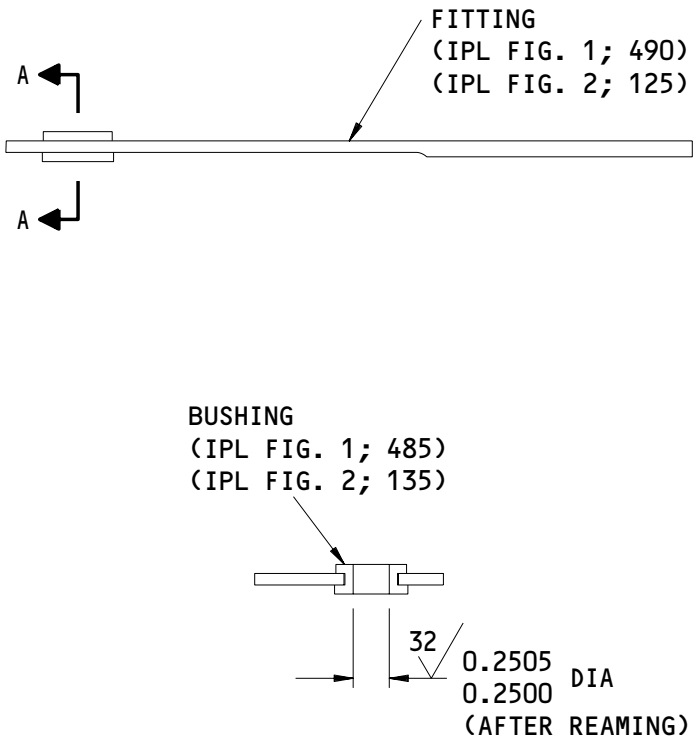
(a) Remove the bushings (IPL Fig. 1; 485) from the fitting assembly (IPL Fig. 1; 480).

(b) Remove the bushings (IPL Fig. 2; 130) from the fitting assembly (IPL Fig. 2; 125).

(c) Install the bushings into the fittings as shown in the SOPM 20-50-03.

(d) Machine the bushings inside diameter to the dimensions and finish shown in Fig. 601.

(e) Break all sharp edges.



A–A

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

113T1158-1,-2
Fitting Assembly Repair
Figure 601

K23964

FITTING - REPAIR 10-2

113T1158-3, -4

1. General

A. This repair gives the data that is necessary to repair and refinish the fitting (IPL Fig. 1; 490), (IPL Fig. 2; 135).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices shown in the repair.

C. Refer to the REPAIR - GENERAL (57-54-41/601, REPAIR - GENERAL) for the Standard True Position Dimensioning Symbols shown in the repair.

D. Refer to IPL Fig. 1 and 2 for item numbers.

E. General repair details:

(1) Material: 15-5PH Cres
150-170 KSI

2. Bushing Hole Repair

A. References

(1) SOPM 20-20-01, Magnetic Particle Inspection

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

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

B. Procedure

(1) Machine the worn or damaged hole for the bushings (IPL Fig. 1; 485), (IPL Fig. 2; 130) as necessary, to remove defects, cracks, and/or corrosion up to the limit shown in Fig. 601.

(2) Break all the sharp edges.

(3) Do a magnetic particle check as shown in the SOPM 20-20-01.

(4) Oversize bushings

(a) Make the repair bushing for bushing (IPL Fig. 1; 485), (IPL Fig. 2; 130) as shown in Fig. 602 and in the following instructions.

1) Bushing Material: 302 Cres, AMS 5639
HT 302 Cres-Condition A (Annealed)

2) Break all the sharp edges.

3) Do a magnetic particle check as shown in SOPM 20-20-01.

4) Prepare the surface and cadmium plate (F-15.06) as shown in SOPM 20-42-05.

5) The bushing (IPL Fig. 1; 485), (IPL Fig. 2; 130) is not an interference fit bushing; however, make sure that the clearance between the inner diameter of the fitting and the outer diameter of the bushing is 0.0100-0.0160 inch.

6) Install the oversize repair bushing as shown in REPAIR 10-1.

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

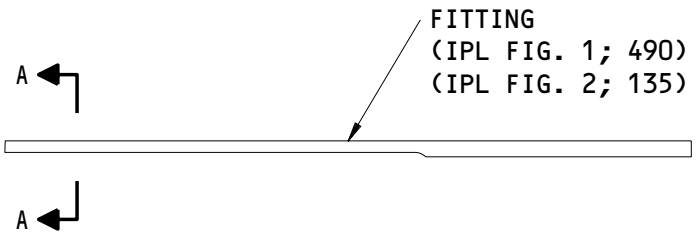
(3) SOPM 20-41-02, Application of Chemical and Solvent Resistant Finishes

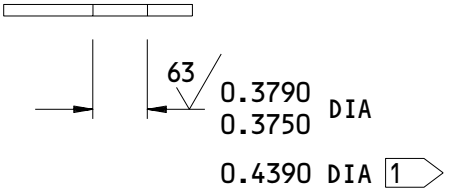
(4) SOPM 20-42-05, Bright Cadmium Plating

C. Procedure

(1) Cadmium plate (F-15.06).

(2) Apply BMS 10-11, Type 1 primer (F-20.02).





A–A

1 REPAIR LIMIT

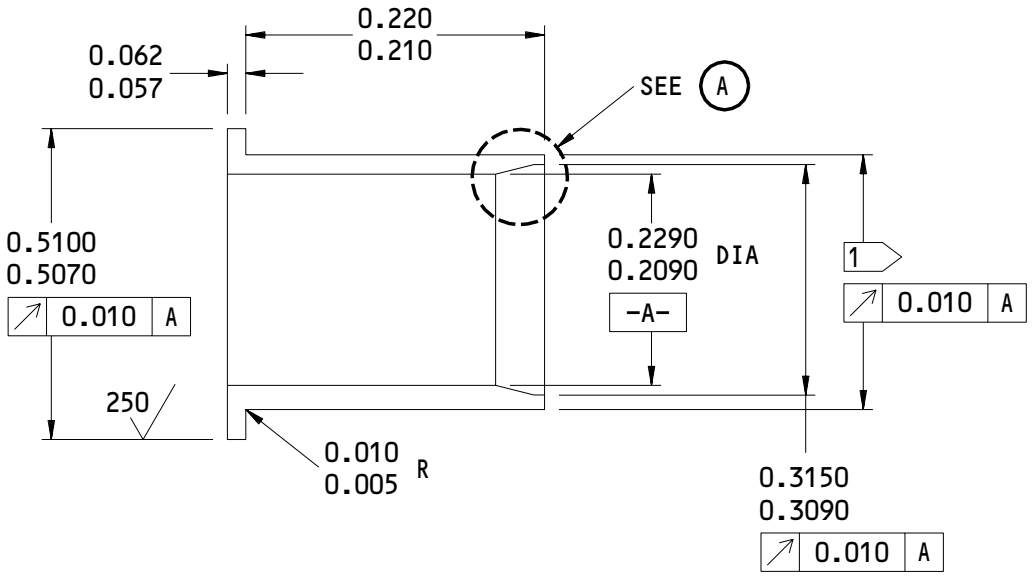
125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

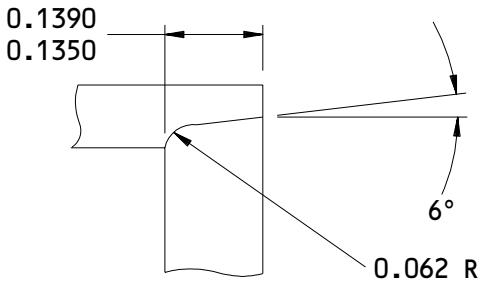
ALL DIMENSIONS ARE IN INCHES

113T1158-3,-4
Fitting Repair
Figure 601

K23969



OVERSIZE REPLACEMENT BUSHING
(IPL FIG. 1; 485)
(IPL FIG. 2; 130)



A

1 THE OUTSIDE DIAMETER OF THE BUSHING IS EQUAL TO THE FITTING HOLE PLUS INTERFERENCE 0.0100-0.0160

250 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

Repair Bushing Details
Figure 602

K23985

FITTING ASSEMBLY - REPAIR 11-1

113T1160-1, -2

1. General

A. This repair gives the data that is necessary to repair the fitting assembly (IPL Fig. 1; 915) and (IPL Fig. 2; 460).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices shown in the repair.

C. Refer to the REPAIR - GENERAL (57-54-41/601, REPAIR-GENERAL) for the standard true position dimensioning symbols shown in the repair.

D. Refer to IPL Fig. 1 and 2 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 of Boeing Finish Codes

(2) SOPM 20-50-03, Bearing Removal, Installation and Retention

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

C. Procedure

(1) Replace the bushings in the fitting assembly.

(a) Remove the bushings (IPL Fig. 1; 925) from the fitting assembly (IPL Fig. 1; 915).

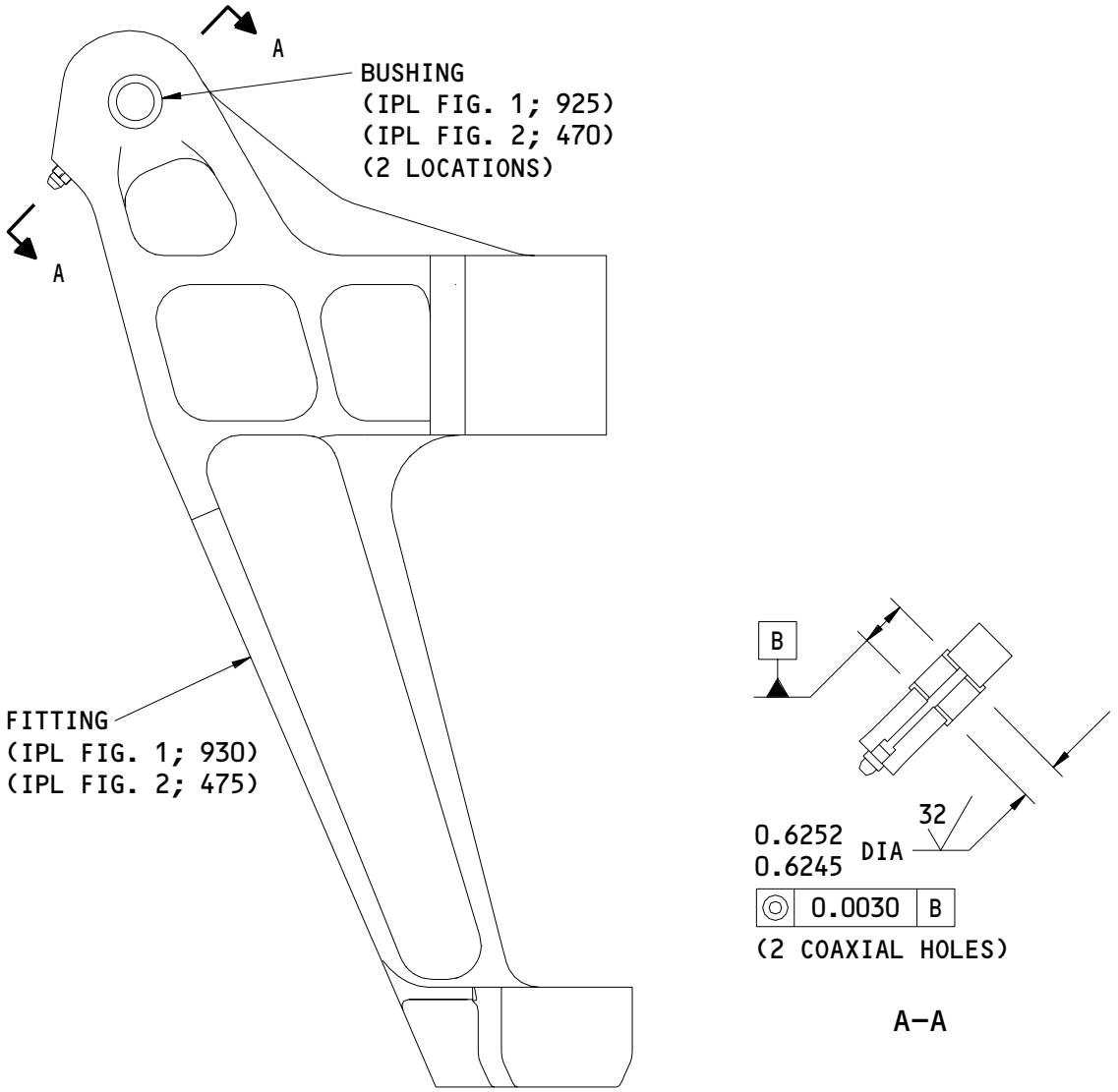
(b) Remove the bushings (IPL Fig. 2; 470) from the fitting assembly (IPL Fig. 2; 460).

(c) Install the bushings into the fittings with BMS 5-95 sealant and as shown in the SOPM 20-50-03.

(d) Machine the bushings inside diameter to the dimensions and finish shown in Fig. 601.

(e) Break all sharp edges to a radius of 0.02-0.03 inch.

(f) Fillet seal around the flanges of the bushings using BMS 5-95 sealant.



125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

113T1160-1,-2
Fitting Assembly Repair
Figure 601

K24001

FITTING - REPAIR 11-2

113T1160-3, -4

1. General

A. This repair gives the data that is necessary to repair and refinish the fitting (IPL Fig. 1; 930), (IPL Fig. 2; 475).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices shown in the repair.

C. Refer to the REPAIR - GENERAL (57-54-41/601, REPAIR - GENERAL) for the Standard True Position Dimensioning Symbols shown in the repair.

D. Refer to IPL Fig. 1 and 2 for item numbers.

E. General repair details:

(1) Material: Aluminum alloy

(2) Shot peen: Intensity 0.012A
Coverage 2.0

2. Bushing Hole Repair

A. References

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

(2) SOPM 20-20-01, Magnetic Particle Inspection

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

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

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

B. Procedure

(1) Machine the worn or damaged hole for the bushings (IPL Fig. 1; 925), (IPL Fig. 2; 470) as necessary, to remove defects, cracks, and/or corrosion up to the limit shown in Fig. 601.

(2) Break all the sharp edges to a radius of 0.02-0.03 inch.

(3) Do a penetrant check as shown in the SOPM 20-20-02.

(4) Shot peen the machined area as shown in the SOPM 20-10-03.

(5) Machine the hole to the finish shown in Fig. 601.

(6) Oversize bushings

(a) Make the repair bushing for bushing (IPL Fig. 1; 925), (IPL Fig. 2; 470) as shown in Fig. 602 and in the following instructions.

1) Bushing Material: AL-Bronze, AMS 4640, HR 50

2) Break all the sharp edges.

3) Do a penetrant check as shown in SOPM 20-20-02.

4) Prepare the surface and cadmium plate (F-15.06) as shown in SOPM 20-42-05.

5) Be sure the interference between the bushing O. D. and the oversize hole I. D. is as shown in Fig. 602.

6) Install the oversize repair bushing as shown in REPAIR 11-2.

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

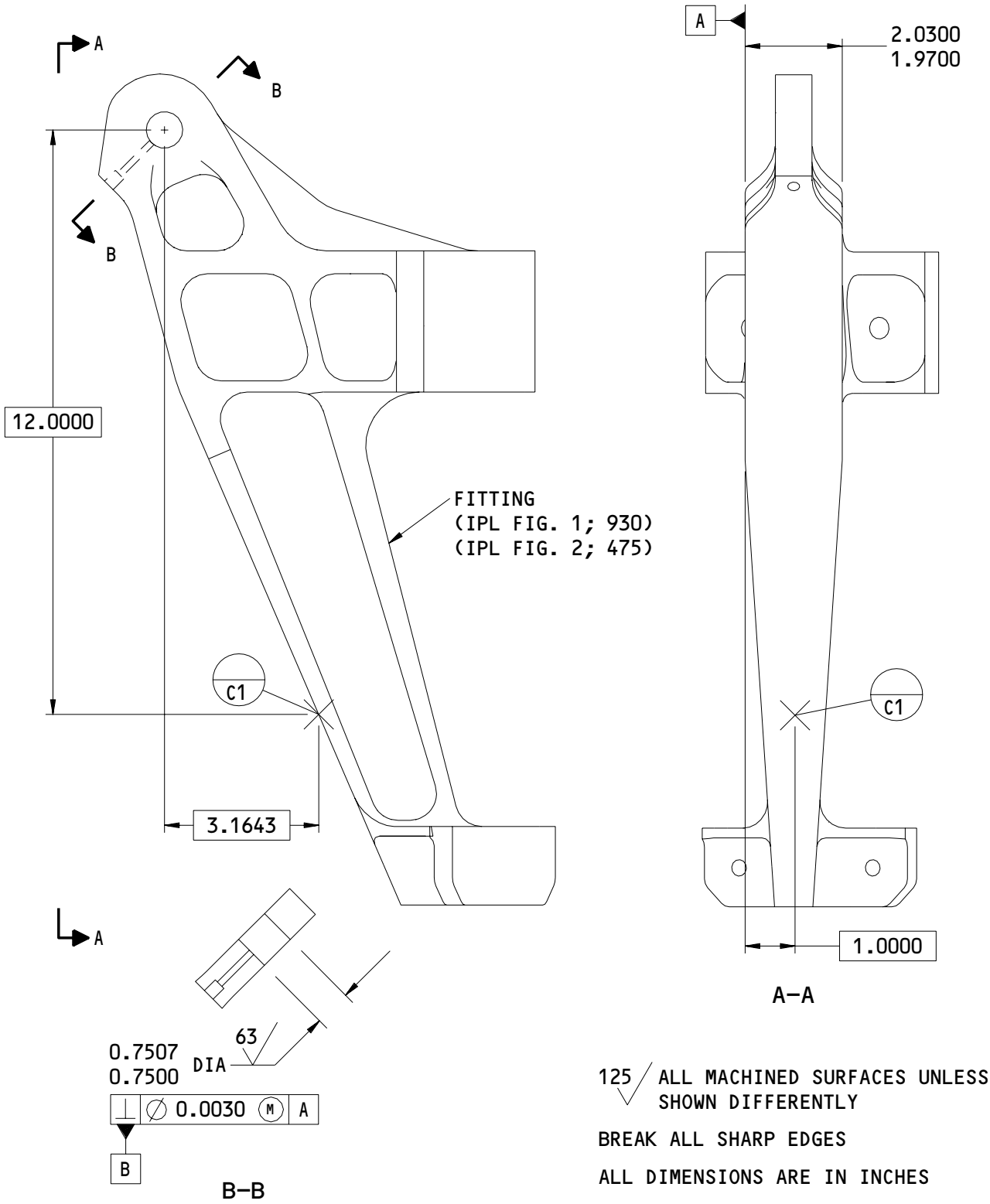
(4) SOPM 20-43-01, Chromic Acid Anodize

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

C. Procedure

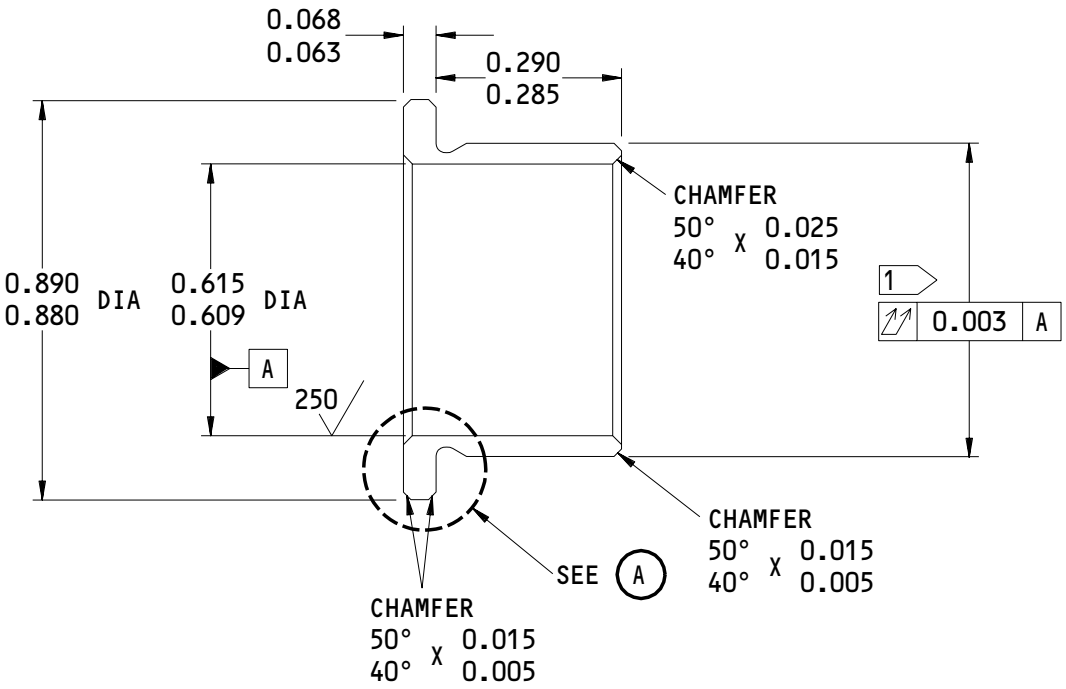
(1) Boric acid-sulfuric acid anodize (F-17.31).

(2) Apply BMS 10-11, Type 1 primer (F-20.02). No primer in bushing bores.

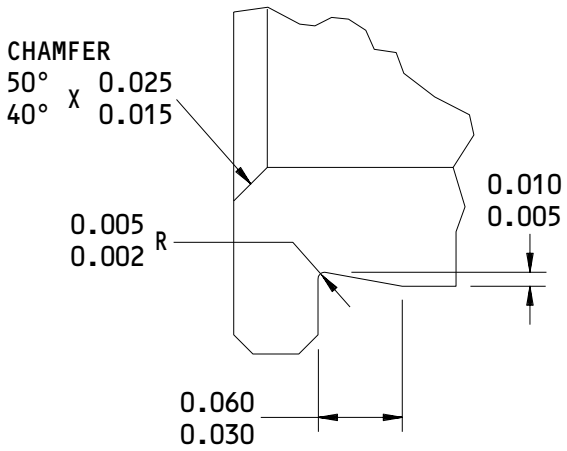


113T1160-3,-4
Fitting Assembly Repair
Figure 601

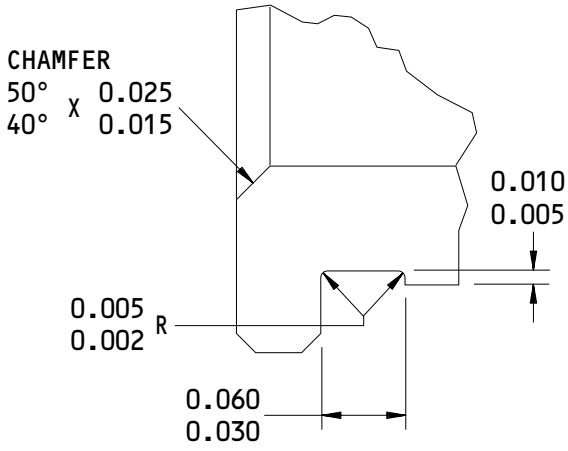
K24020



OVERSIZE REPLACEMENT BUSHING
(IPL FIG. 1; 925)
(IPL FIG. 2; 470)



TYPE 1



TYPE 2

A

1 THE OUTSIDE DIAMETER OF THE BUSHING IS EQUAL TO THE FITTING HOLE PLUS INTERFERENCE OF 0.0007-0.0019

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

Repair Bushing Details
Figure 602

K24034

ASSEMBLY

1. General

   A. This procedure has the data necessary to assemble the WXYZ 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. XYZ for item numbers.

2. Assembly

   A. Consumable Materials

      NOTE: Equivalent material can be used.

      (1) A00359 Sealant -- BMS 5-95 (SOPM 20-60-04)

   B. References

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

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

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

   C. Procedure

      (1) Use standard industry procedures to assemble this component.

      (2) Use standard industry procedures and the steps shown below to assemble this component.

      (3) Install the support fitting (IPL Fig. 1; 990) (IPL Fig. 2; 930) onto the beam assembly.

         (a) Fay surface seal between the main landing gear beam and all the support fitting surfaces with BMS 5-95 sealant.

(b) Position the support fitting onto the beam assembly and install the bolts (IPL Fig. 1; 960), (IPL Fig. 2; 900), washers (IPL Fig. 1; 965), (IPL Fig. 2; 905) and the nuts (IPL Fig. 1; 970), (IPL Fig. 2; 910) with BMS 5-95 as shown in the SOPM 20-50-19 method 2. Tighten the nuts in the fay seal areas as follows.

1) Complete the initial installation so that the BMS 5-95 sealant has at least 60 minutes of squeeze-out life remaining.

NOTE: Consult SOPM 20-50-19 for the definition of squeeze-out life.

2) Retighten all fasteners in the fay surface seal areas to -10% of the maximum end of the specified torque range.

3) Complete reapplication of torque within the squeeze-out life of the sealant. One hundred percent of the torque must be applied at this time.

(c) Install the bolts (IPL Fig. 1; 980), (IPL Fig. 2; 920) and the collars (IPL Fig. 1; 985), (IPL Fig. 2; 925) with BMS 5-95 sealant per F-19.27. Tighten the nuts to the specified torque range.

(d) Install the shim (IPL Fig. 1; 995), (IPL Fig. 2; 935).

1) Install the shim and make sure that the maximum gap is no more than 0.005 inch.

2) Remove the shim then fay surface seal both sides of the shim with BMS 5-95 sealant.

3) Install the shim.

(e) Install the bolts (IPL Fig. 1; 975), (IPL Fig. 2; 915) and the collars (IPL Fig. 1; 985), (IPL Fig. 2; 925) with BMS 5-95 sealant per F-19.27. Tighten the nuts to the specified torque range.

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
06725	AIR INDUSTRIES CORPORATION 12570 KNOTT STREET GARDEN GROVE, CALIFORNIA 92641-3932
11815	CHERRY AEROSPACE FASTENERS DIV OF TEXTRON 1224 EAST WARNER AVENUE PO BOX 2157 SANTA ANA, CALIFORNIA 92707-0157
15653	KAYNAR TECHNOLOGY KAYNAR DIV 800 SOUTH STATE COLLEGE BLVD PO BOX 3001 FULLERTON, CALIFORNIA 92634-3001
5M902	FAIRCHILD IND INC FAIRCHILD AEROSPACE FASTENER DIV 3016 W LOMITA BLVD TORRANCE, CALIFORNIA 90505-5103
52828	REPUBLIC FASTENER MFG CORP 1300 RANCHO CONEJO BLVD NEWBURY PARK, CALIFORNIA 91320-1405
56878	SPS TECHNOLOGIES INC AEROSPACE AND INDUSTRIAL PRODUCTS DIV HIGHLAND AVENUE JENKINTOWN, PENNSYLVANIA 19046
60516	WEST COAST AEROSPACE INC 812 MIRAFLORES STREET SAN PEDRO, CALIFORNIA 90731-1439
72962	HARVARD INDUSTRIES INC 3 WERNER WAY SUITE 210 LEBANON, NEW JERSEY 08833
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

VENDORS

9N513 VOI SHAN/CHATSWORTH DIV OF VSI CORP SUB OF FAIRCHILD IND
CHATSWORTH, CALIFORNIA 91311-5013
COMPANY NO LONGER WISHES TO BE CONSIDERED FOR FED CONTRCTG

92215 FAIRCHILD IND INC FAIRCHILD AEROSPACE FASTENER DIV
3010 W LOMITA BLVD
TORRANCE, CALIFORNIA 90505-5102

97928 DEUTSCH FASTENER CORP
3969 PARAMONT BOULEVARD
LAKEWOOD, CALIFORNIA 90712-4193

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACB28AM04B013A		1	410	1
		1	440	2
		2	375	2
		2	420	1
BACB28AM06B010A		1	700	4
		2	270	4
BACB28AM06B015A		1	220	1
		2	215	1
BACB28AM06B016A		1	390	2
		2	400	2
BACB28AM07B014A		1	780	1
		2	320	1
BACB28AM07B016A		1	395	1
		2	405	1
BACB28AP04P010		1	715	4
		2	285	4
BACB28AP04P012		1	325	2
		2	60	2
BACB28AP04P014		1	215	1
		2	210	1
BACB28AP04P016		1	400	2
		2	410	2
BACB28AP04P028		1	530	1
		2	175	1
BACB28AP05P013		1	775	1
		2	315	1
BACB28AP05P016		1	405	1
		2	415	1
BACB28AP06P016		1	745	1
		2	245	1
BACB28AP06P028		1	520	1
		2	165	1
BACB28AT06B028C		1	535	1
		2	180	1
BACB28AT06B048C		1	680	4
		2	435	4
BACB28AT06P012C		1	330	2
		2	65	2
BACB28AT09B015C		1	740	1
		2	240	1
BACB28AT09B028C		1	525	1
		2	170	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACB28AT10BO29C		1	925	2
		2	470	2
BACB28AX04CO53		1	675	4
BACB28AX04CO53		2	430	4
BACB28B4-215		1	485	1
		2	130	1
BACB30MR6K15		1	450	1
		2	95	1
BACB30MR6K16		1	455	1
		2	100	1
BACB30NX12K17		1	905	2
		2	450	2
BACB30NX12K21		1	40	3
		2	480	3
BACB30NX16K32		1	895	2
		2	440	2
BACB30NZ10K24		1	425	2
		2	360	2
BACB30NZ12K24		1	505	1
		2	150	1
BACB30NZ12K25		1	500	1
		2	145	1
BACB30NZ8K24		1	760	1
		2	300	1
BACB30NZ8K26		1	755	1
		2	295	1
BACB30VT10K10		1	200	1
		2	195	2
BACB30VT10K11		1	195	1
BACB30VT10K8		1	725	2
		2	225	2
BACB30VT6K6		1	115	2
		1	230	11
		1	550	6
		1	585	6
		1	790	12
		2	555	15
		2	590	3
		2	625	6
		2	675	3
		2	710	12

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACB30VT6K7		1	270	1
		2	80	3
BACB30VT6K8		1	265	2
		1	865	3
		2	620	3
BACB30VT6K9		1	145	7
		1	625	6
BACB30VT6K9		2	560	3
		2	715	3
		2	780	3
BACB30VT8K11		1	685	8
		2	255	8
BACB30VT8K12		1	375	3
		2	385	3
BACB30VT8K8		1	305	4
		2	40	4
BACC30AB10C		1	430	2
		2	365	2
BACC30AB8C		1	765	2
		2	305	2
BACC30BH12		1	45	3
		1	910	2
		2	455	2
		2	485	3
BACC30BL10		1	205	2
		1	730	2
		2	200	2
		2	230	2
BACC30BL6		1	120	2
		1	150	7
		1	235	11
		1	275	3
		1	555	6
		1	590	6
		1	630	6
		1	795	12
		1	870	3
		2	85	3
		2	565	18
		2	595	3
		2	630	9
		2	680	3
		2	720	15
		2	785	3

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACC30BL8		1	310	4
		1	380	3
		1	690	8
		2	45	4
		2	260	8
		2	390	3
BACC30BU12PW		1	510	2
		2	155	2
BACC30X16		1	900	2
		2	445	2
BACN10JC3		1	660	1
		2	805	1
BACN10JC4CD		1	355	2
		2	340	2
BACN10JC5CD		1	360	2
		2	345	2
BACN10JN3		1	850	2
		2	580	12
		2	700	1
BACN10JN3CD		1	255	4
		1	575	2
		1	655	1
		2	755	5
BACN10JN4		1	60	6
		2	500	6
BACN10KB3CF		1	295	2
BACN10KB3F		1	135	2
		1	175	6
		1	250	8
		1	570	4
		1	610	4
		1	650	4
		1	815	4
		1	845	4
		1	885	2
		2	610	2
		2	655	6
		2	695	2
		2	750	10
		2	800	2

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACR15BA3AD		1	55	12
		1	130	4
		1	170	12
		1	245	24
		1	290	4
		1	565	12
		1	605	8
		1	645	12
		1	810	8
		1	840	12
		1	880	4
		2	495	12
		2	575	24
BACR15BA3AD		2	605	4
		2	650	12
		2	690	6
		2	745	30
		2	795	6
BACR15BA5AD		1	65	22
		2	505	22
BACR15BA8AD7C		1	475	2
		2	120	2
BACR15BB5AD		1	70	14
		2	510	14
BACS4OR010C036		1	420	1
		2	427	1
BACS4OR016C031F		1	545	1
		2	190	1
BACS4OR017C047F		1	940	1
		2	478	1
BACS4OR029C051F		1	935	1
		2	477	1
BACW10BP6CD		1	460	2
		2	105	2
BACW10BP6DP		1	465	2
		2	110	2
BRFM20A3		1	850	2
		2	580	12
		2	700	1
BRFM20A4		1	60	6
		2	500	6

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BRFM20C3D		1	255	4
		1	575	2
		1	655	1
		2	755	5
BRF100A3		1	135	2
		1	175	6
		1	250	8
		1	570	4
		1	610	4
		1	650	4
		1	815	4
		1	845	4
		1	885	2
		2	610	2
		2	655	6
		2	695	2
		2	750	10
BRF100A3		2	800	2
BRF100C3		1	295	2
BRH10A3		1	660	1
		2	805	1
F2000-3		1	135	2
		1	175	6
		1	250	8
		1	570	4
		1	610	4
		1	650	4
		1	815	4
		1	845	4
		1	885	2
		2	610	2
		2	655	6
		2	695	2
		2	750	10
		2	800	2
F2031-3		1	295	2
HL1087-12		1	45	3
		1	910	2
		2	455	2
		2	485	3

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
HL1187-16		1	900	2
		2	445	2
HL12-32		1	895	2
		2	440	2
HL12VAZ12-17		1	905	2
		2	450	2
HL12VAZ12-21		1	40	3
		2	480	3
HL12VAZ16-32		1	895	2
		2	440	2
HL523AZ8-24		1	760	1
		2	300	1
HL523AZ8-26		1	755	1
		2	295	1
HL87-16		1	900	2
		2	445	2
HL97KG10		1	430	2
		2	365	2
HL97KG8		1	765	2
		2	305	2
HL97PB10		1	430	2
		2	365	2
HL97PB8		1	765	2
		2	305	2
HST10AG10-10		1	200	1
		2	195	2
HST10AG10-11		1	195	1
HST10AG10-8		1	725	2
		2	225	2
HST10AG6-6		1	115	2
		1	230	11
		1	550	6
		1	585	6
		1	790	12
		2	555	15
		2	590	3
		2	625	6
		2	675	3
		2	710	12

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
HST10AG6-7		1	270	1
		2	80	3
HST10AG6-8		1	265	2
		1	865	3
		2	620	3
HST10AG6-9		1	145	7
		1	625	6
HST10AG6-9		2	560	3
		2	715	3
		2	780	3
HST10AG8-11		1	685	8
		2	255	8
HST10AG8-12		1	375	3
		2	385	3
HST10AG8-8		1	305	4
		2	40	4
HST79-10		1	205	2
		1	730	2
		2	200	2
		2	230	2
HST79-6		1	120	2
		1	150	7
		1	235	11
		1	275	3
		1	555	6
HST79-6		1	590	6
		1	630	6
		1	795	12
		1	870	3
		2	85	3
		2	565	18
		2	595	3
		2	630	9
		2	680	3
		2	720	15
		2	785	3
HST79-8		1	310	4
		1	380	3
		1	690	8
		2	45	4
		2	260	8
		2	390	3

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
HST79CY10		1	205	2
		1	730	2
		2	200	2
		2	230	2
HST79CY6		1	120	2
		1	150	7
		1	235	11
		1	275	3
		1	555	6
		1	590	6
		1	630	6
		1	795	12
		1	870	3
		2	85	3
		2	565	18
		2	595	3
		2	630	9
		2	680	3
		2	720	15
		2	785	3
HST79CY8		1	310	4
		1	380	3
		1	690	8
		2	45	4
		2	260	8
		2	390	3
H10-3BAC		1	660	1
		2	805	1
L802-12K17		1	905	2
		2	450	2
L802-12K21		1	40	3
		2	480	3
L802-16K32		1	895	2
		2	440	2
L804-8K24		1	760	1
		2	300	1
L804-8K26		1	755	1
		2	295	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
MF1000-3BAC		1	850	2
		2	580	12
		2	700	1
MF1000-4BAC		1	60	6
		2	500	6
MF51637-3		1	255	4
		1	575	2
		1	655	1
		2	755	5
MF53049-3		1	850	2
		2	580	12
		2	700	1
MF53049-4		1	60	6
		2	500	6
MF53050-3CD		1	255	4
		1	575	2
		1	655	1
		2	755	5
MS15001-1		1	5	3
		1	920	1
		2	5	3
		2	465	1
NAS1149E0432P		1	350	4
		2	335	4
NAS170-1		1	365	2
		2	350	2
NAS1805-6L		1	470	2
		2	115	2
NAS354-5-475		1	370	1
		2	355	1
NAS6704-9		1	345	2
		2	330	2
NS103185-02		1	135	2
		1	175	6
		1	250	8
		1	570	4
		1	610	4
		1	650	4
		1	815	4
		1	845	4
		1	885	2
		2	610	2
		2	655	6
		2	695	2
		2	750	10
		2	800	2

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
NS103185S02		1	295	2
NS103218-02		1	850	2
		2	580	12
		2	700	1
NS103218-048		1	60	6
		2	500	6
NS202101-02		1	660	1
		2	805	1
NS202487-02		1	255	4
		1	575	2
		1	655	1
		2	755	5
RMF9201M3		1	850	2
		2	580	12
		2	700	1
RMF9201M4		1	60	6
		2	500	6
RMF9207-3		1	135	2
		1	175	6
		1	250	8
		1	570	4
		1	610	4
		1	650	4
		1	815	4
		1	845	4
		1	885	2
		2	610	2
RMF9207-3		2	655	6
		2	695	2
		2	750	10
		2	800	2
RMLH9075-3W		1	660	1
		2	805	1

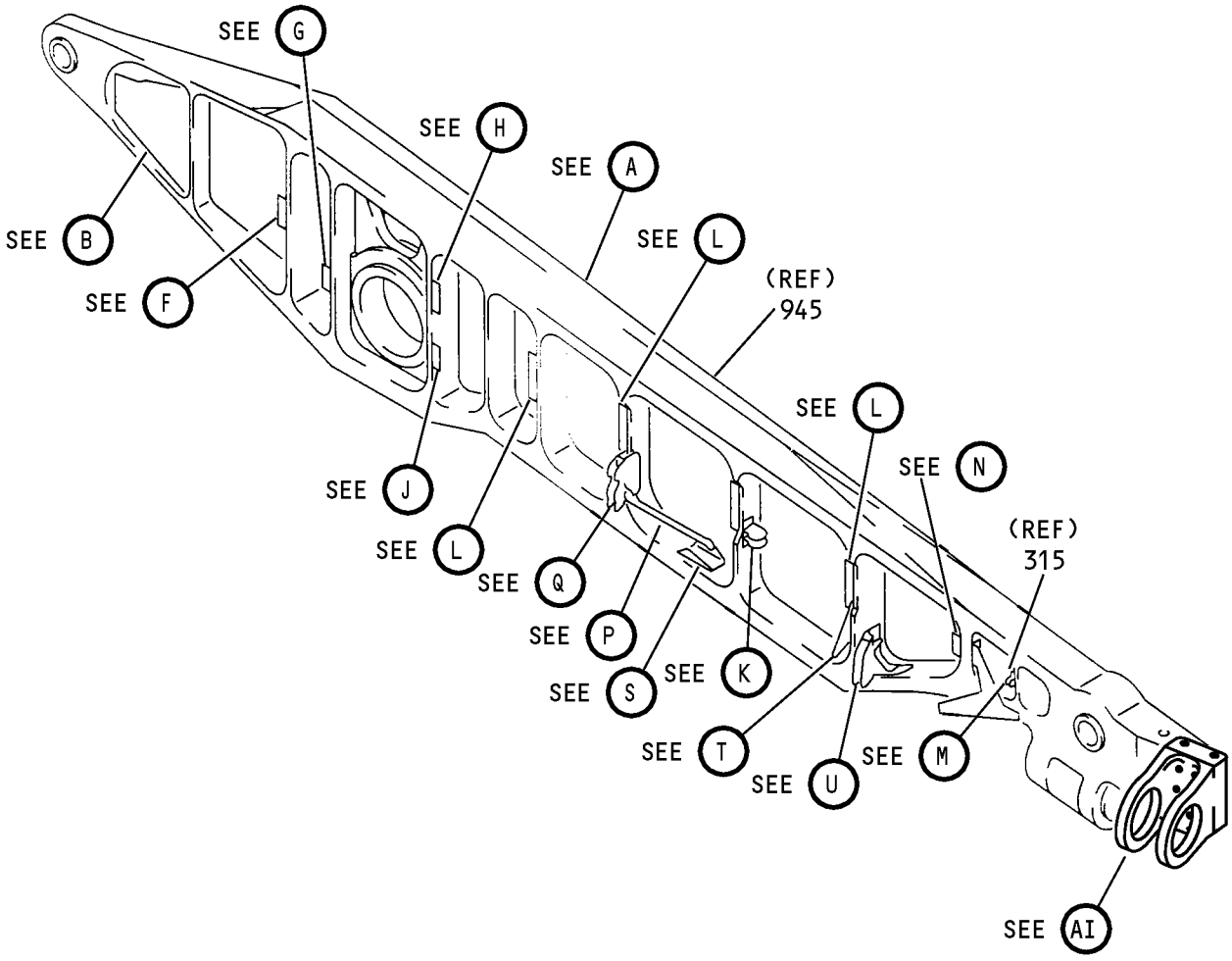
PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
T6S1032J		1	660	1
		2	805	1
T8112C1032C		1	295	2
T8114S1032S		1	135	2
		1	175	6
		1	250	8
		1	570	4
		1	610	4
		1	650	4
		1	815	4
		1	845	4
		1	885	2
		2	610	2
		2	655	6
		2	695	2
		2	750	10
		2	800	2
T8124S3S		1	850	2
		2	580	12
		2	700	1
T8124S4S		1	60	6
		2	500	6
VN151A1-02		1	135	2
		1	175	6
		1	250	8
		1	570	4
		1	610	4
		1	650	4
		1	815	4
		1	845	4
		1	885	2
		2	610	2
		2	655	6
		2	695	2
		2	750	10
		2	800	2
VN151B1-02		1	295	2
VN252A02		1	850	2
		2	580	12
VN252A02		2	700	1
VN252A048		1	60	6
		2	500	6

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
VN303A02		1	660	1
		2	805	1
101F9207-3		1	295	2
102F9201M3		1	255	4
		1	575	2
		1	655	1
		2	755	5
113T1005-10		2	220	1
113T1005-7		1	210	1
113T1005-8		2	205	1
113T1005-9		1	225	1
113T1108-20		1	10	2
		2	35	2
113T1116-1		1	1A	RF
		2	1A	RF
113T1117-1		1	945	1
113T1117-2		2	815	1
113T1122-1		1	435	1
		2	370	1
113T1122-2		1	445	1
		2	380	1
113T1123-5		1	385	1
113T1123-6		2	395	1
113T1123-7		1	415	1
113T1123-8		2	425	1
113T1126-10		1	720	4
		2	290	4
113T1126-21		1	770	1
113T1126-22		2	310	1
113T1126-23		1	785	1
113T1126-24		2	325	1
113T1126-7		1	695	4
		2	265	4
113T1126-8		1	710	4
		2	280	4
113T1126-9		1	705	4
		2	275	4
113T1147-1		1	25	2
		2	10	2
113T1147-3		1	15	1
		2	25	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
113T1147-4		1	20	1
		2	30	1
113T1147-5		1	35	1
		2	20	1
113T1147-6		1	30	1
		2	15	1
113T1155-1		1	315	1
		2	50	1
113T1155-2		1	335	1
		2	70	1
113T1155-3		1	320	1
		2	55	1
113T1155-4		1	340	1
		2	75	1
113T1156-1		1	515	1
113T1156-2		2	160	1
113T1156-3		1	540	1
113T1156-4		2	185	1
113T1157-1		1	735	1
113T1157-2		2	235	1
113T1157-3		1	750	1
113T1157-4		2	250	1
113T1158-1		1	480	1
113T1158-2		2	125	1
113T1158-3		1	490	1
113T1158-4		2	135	1
113T1158-5		1	495	1
		2	140	1
113T1160-1		1	915	1
113T1160-2		2	460	1
113T1160-3		1	930	1
113T1160-4		2	475	1
272T1448-1		2	90	1
272T1448-2		2	585	6
272T1448-3		2	570	6
272T1448-4		2	615	1
272T1448-5		2	600	1
272T1449-1		1	190	1

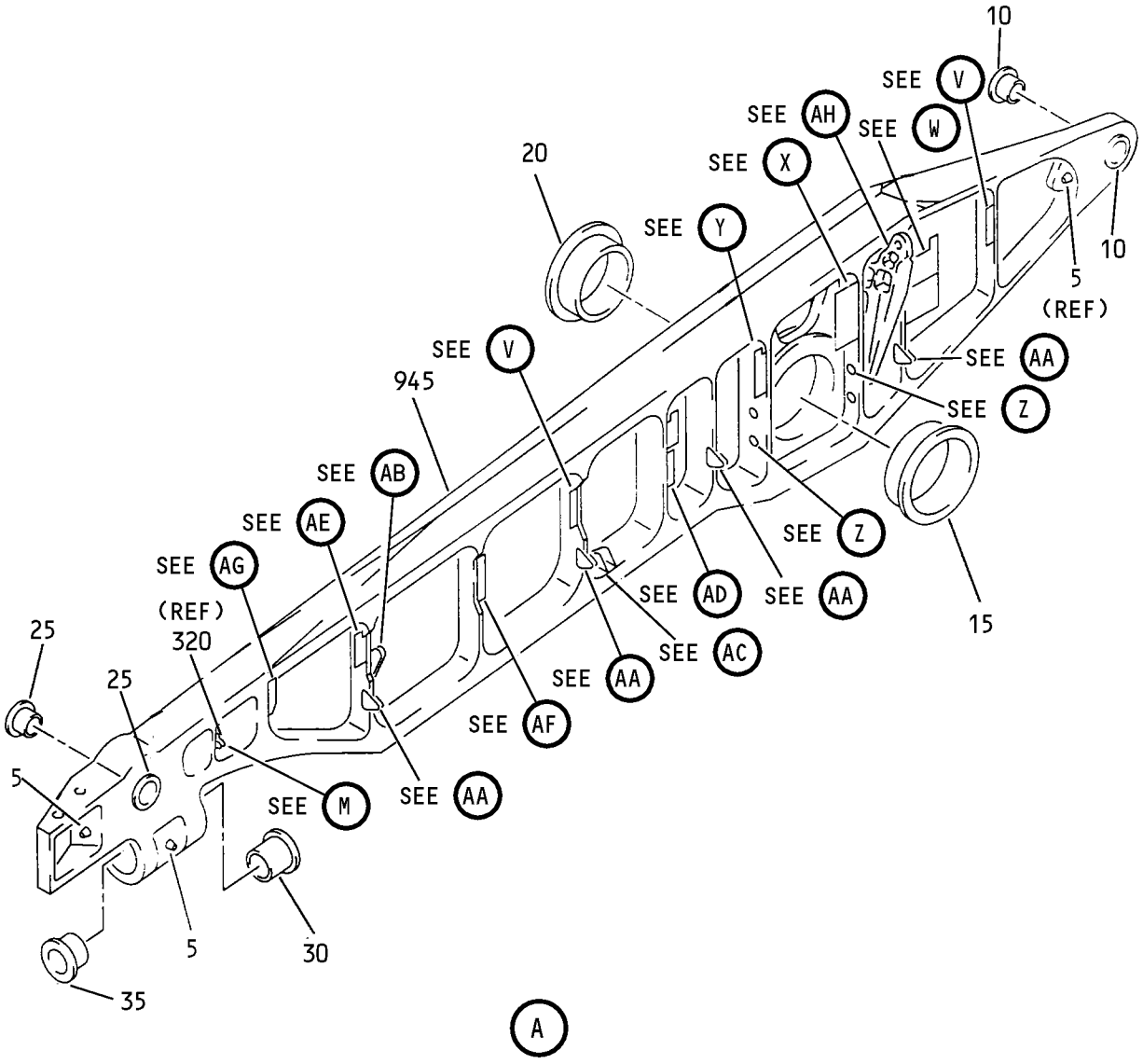
PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
272T1449-10		1	240	4
272T1449-11		1	300	1
272T1449-12		1	285	1
272T1449-14		1	280	1
272T1449-2		1	165	1
272T1449-3		1	180	1
272T1449-4		1	155	1
272T1449-5		1	140	1
272T1449-6		1	125	1
272T1449-7		1	185	1
272T1449-8		1	160	1
272T1449-9		1	260	4
272T1450-1		1	580	2
272T1450-10		2	670	1
272T1450-11		1	800	1
272T1450-12		2	645	1
272T1450-13		1	855	1
272T1450-15		1	830	1
272T1450-2		2	760	2
272T1450-21		1	860	1
272T1450-22		2	705	1
272T1450-23		1	835	1
272T1450-24		2	685	1
272T1450-25		1	825	1
272T1450-26		2	665	1
272T1450-27		1	805	1
272T1450-28		2	640	1
272T1450-29		1	890	1
272T1450-3		1	560	2
272T1450-30		2	660	1
272T1450-31		1	875	1
272T1450-32		2	635	1
272T1450-37		2	775	1
272T1450-38		2	740	1
272T1450-39		2	770	1
272T1450-4		2	725	2
272T1450-40		2	735	1
272T1450-47		2	765	1
272T1450-48		2	730	1
272T1450-5		1	670	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
272T1450-6		2	810	1
272T1450-7		1	640	1
272T1450-8		2	790	1
272T1450-9		1	820	1
272T1451-1		1	615	1
272T1451-2		1	595	1
272T1451-3		1	620	1
272T1451-4		1	600	1
272T1451-5		1	665	1
272T1451-6		1	635	1
273T1559-1		1	50	1
273T1559-10		2	540	1
273T1559-11		1	105	1
273T1559-12		2	545	1
273T1559-13		1	110	1
273T1559-14		2	550	1
273T1559-2		2	490	1
273T1559-3		1	75	1
		2	515	1
273T1559-4		1	80	1
		2	520	1
273T1559-5		1	85	1
		2	525	1
273T1559-6		1	90	1
		2	530	1
273T1559-7		1	95	1
273T1559-8		2	535	1
273T1559-9		1	100	1
96-02		1	660	1
		2	805	1



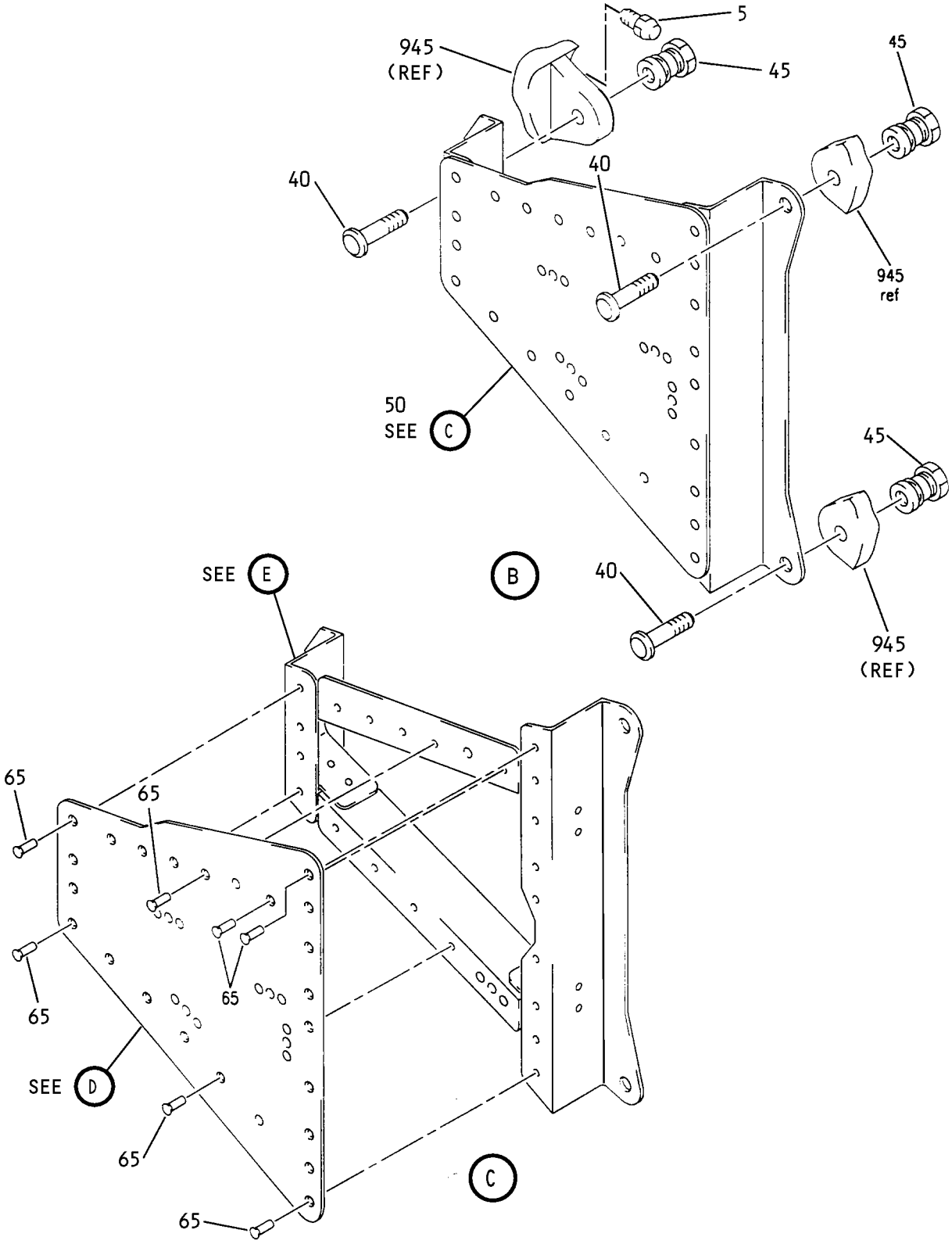
Main Landing Gear Beam Assembly
Figure 1 (Sheet 1)

K24506



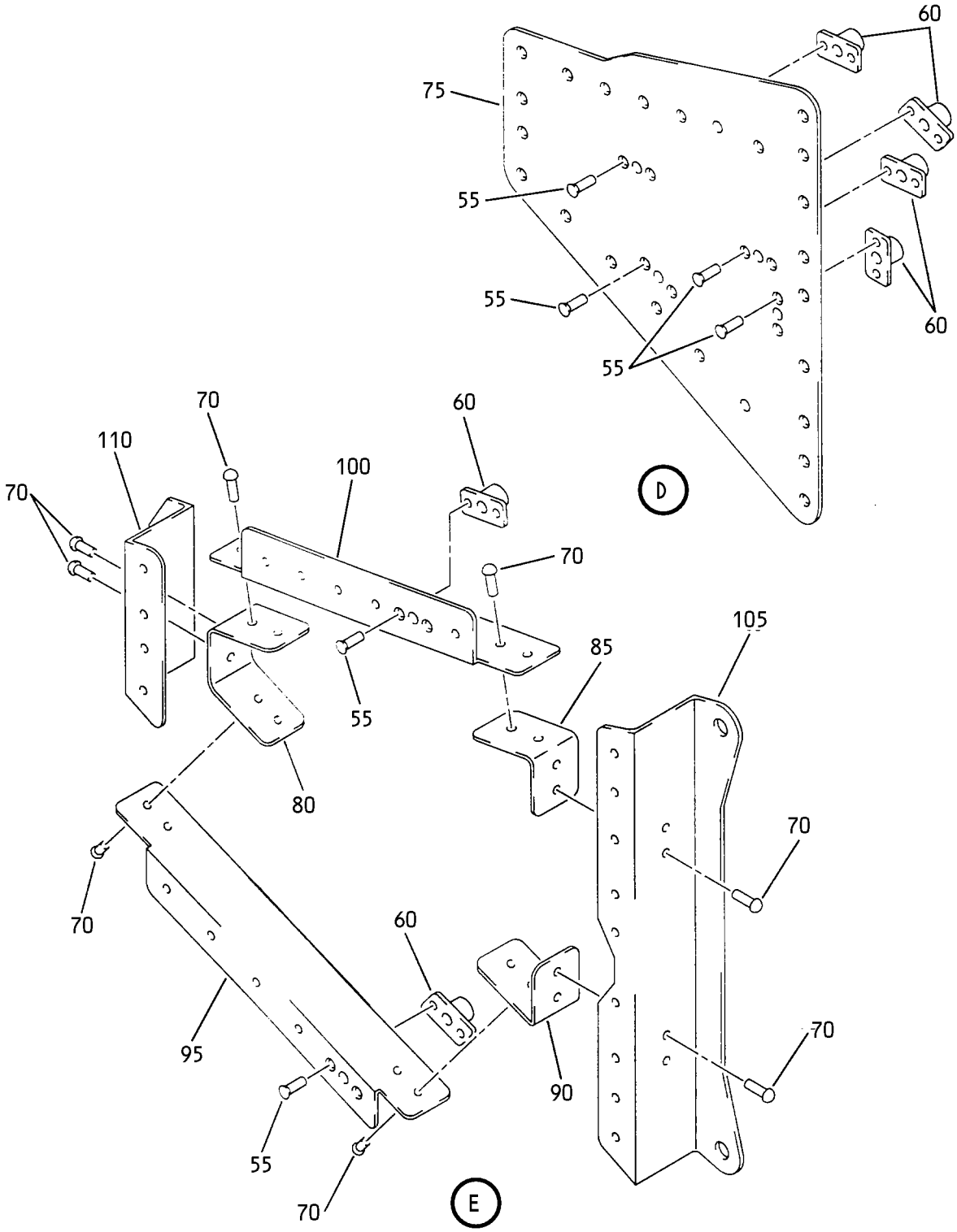
Main Landing Gear Beam Assembly
Figure 1 (Sheet 2)

K24496



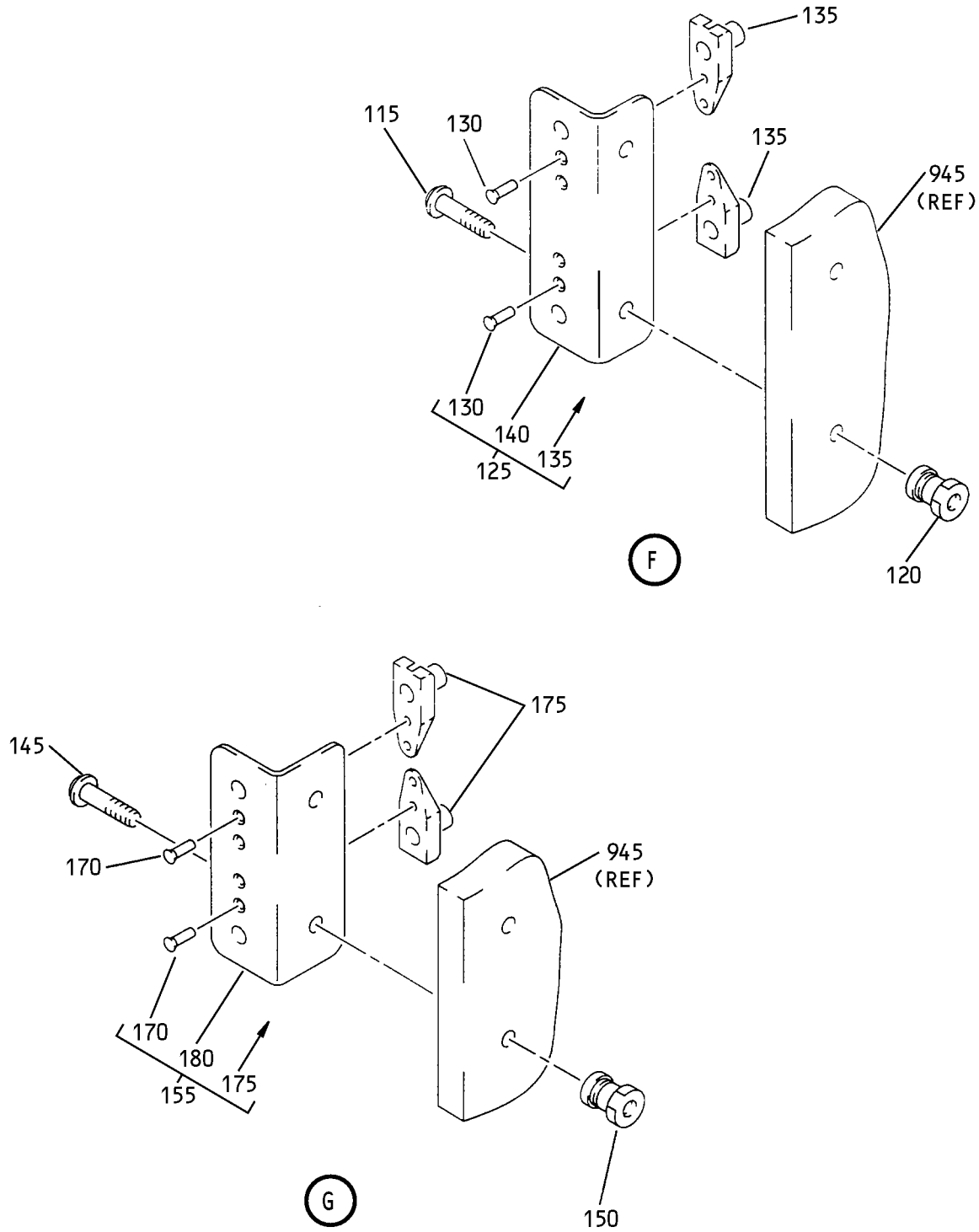
Main Landing Gear Beam Assembly
Figure 1 (Sheet 3)

K24093



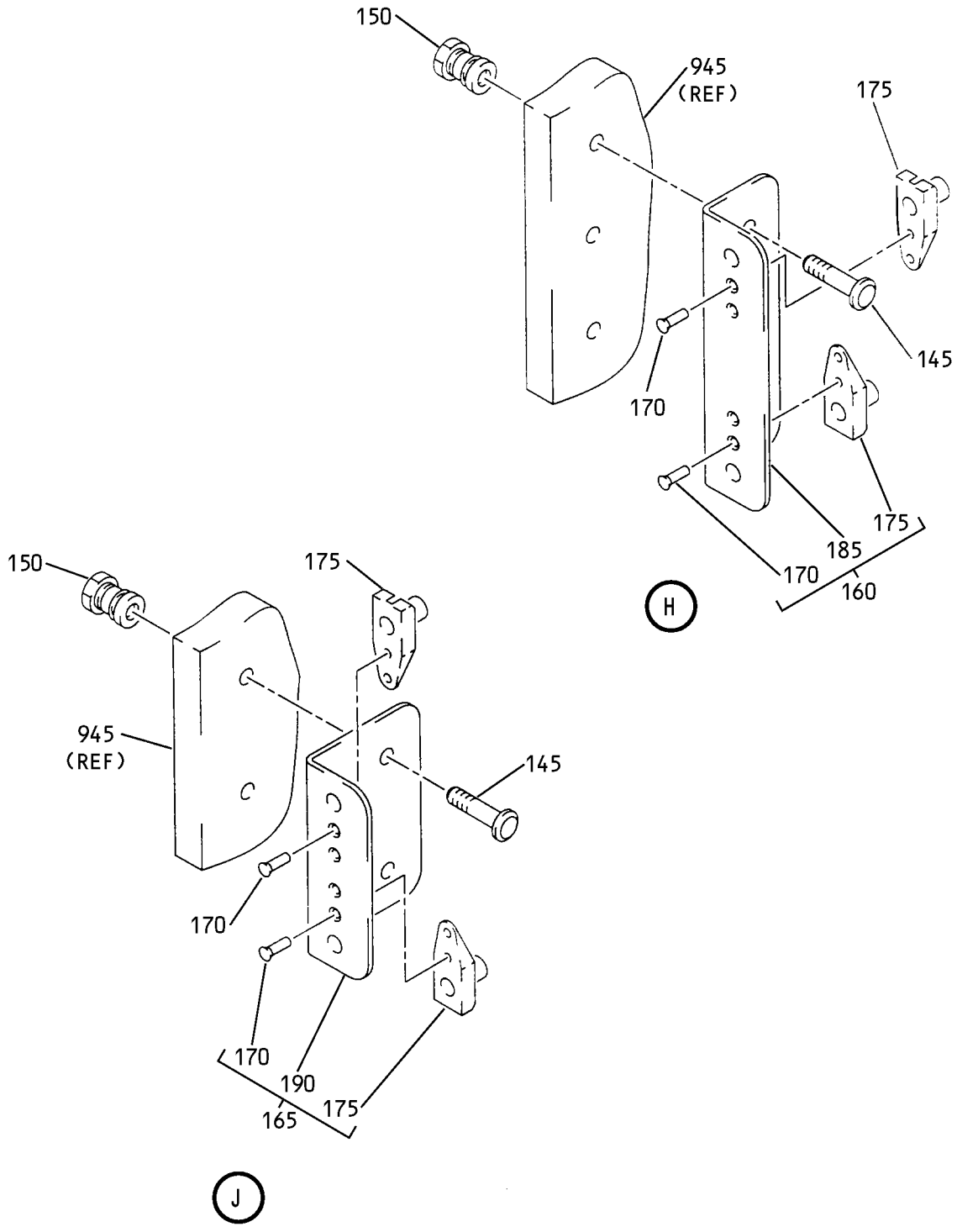
Main Landing Gear Beam Assembly
Figure 1 (Sheet 4)

K24095



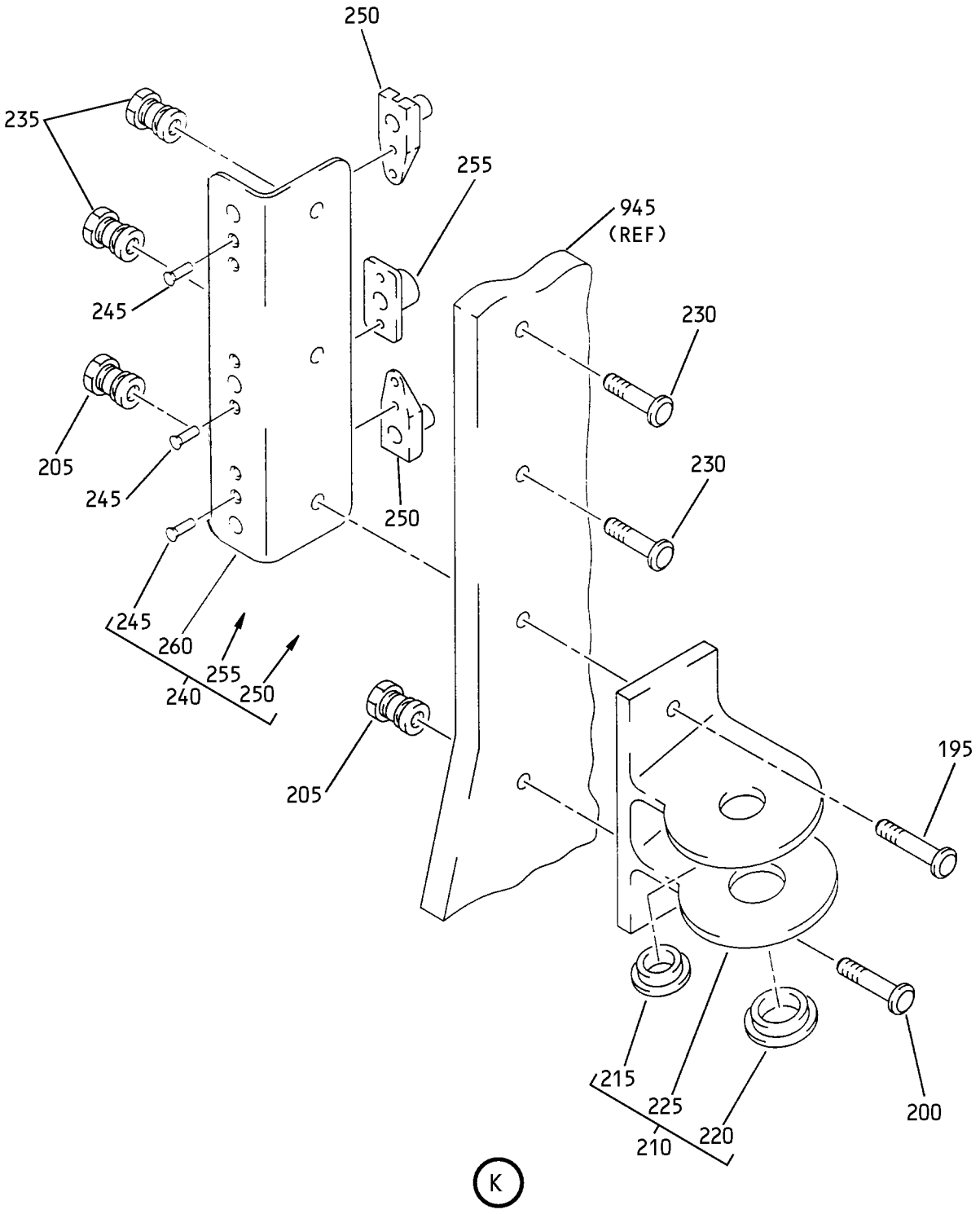
Main Landing Gear Beam Assembly
Figure 1 (Sheet 5)

K24109



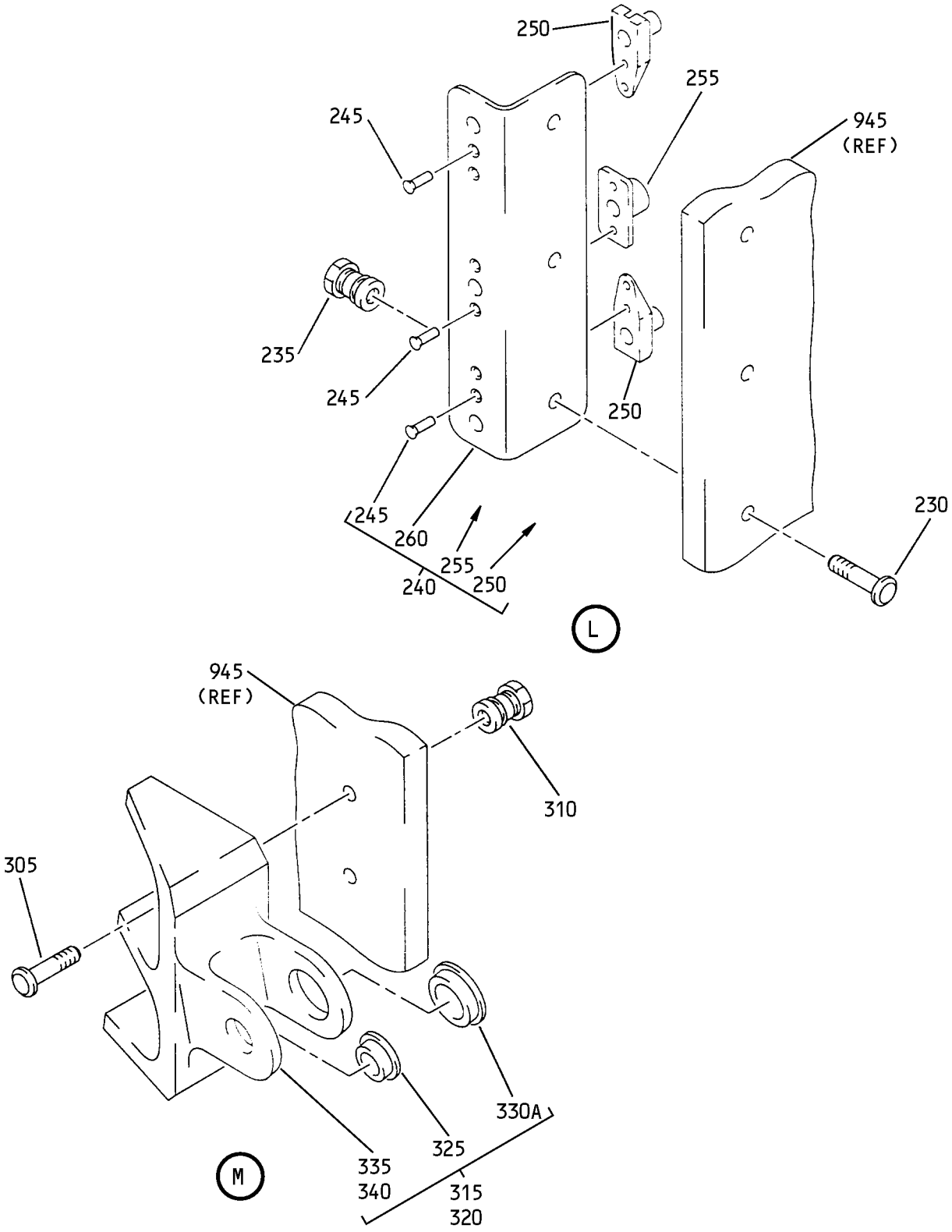
Main Landing Gear Beam Assembly
Figure 1 (Sheet 6)

K24116



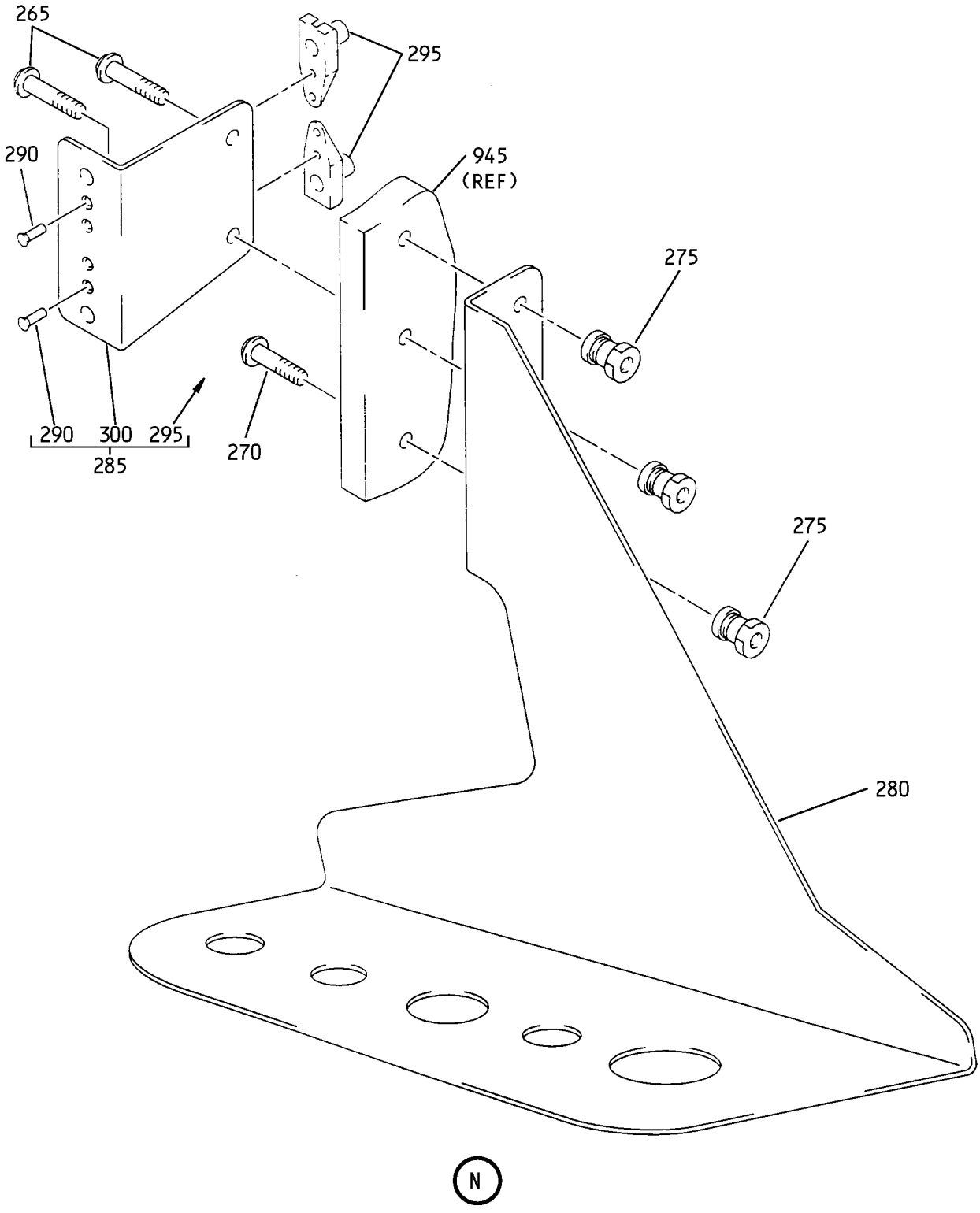
Main Landing Gear Beam Assembly
Figure 1 (Sheet 7)

K24257



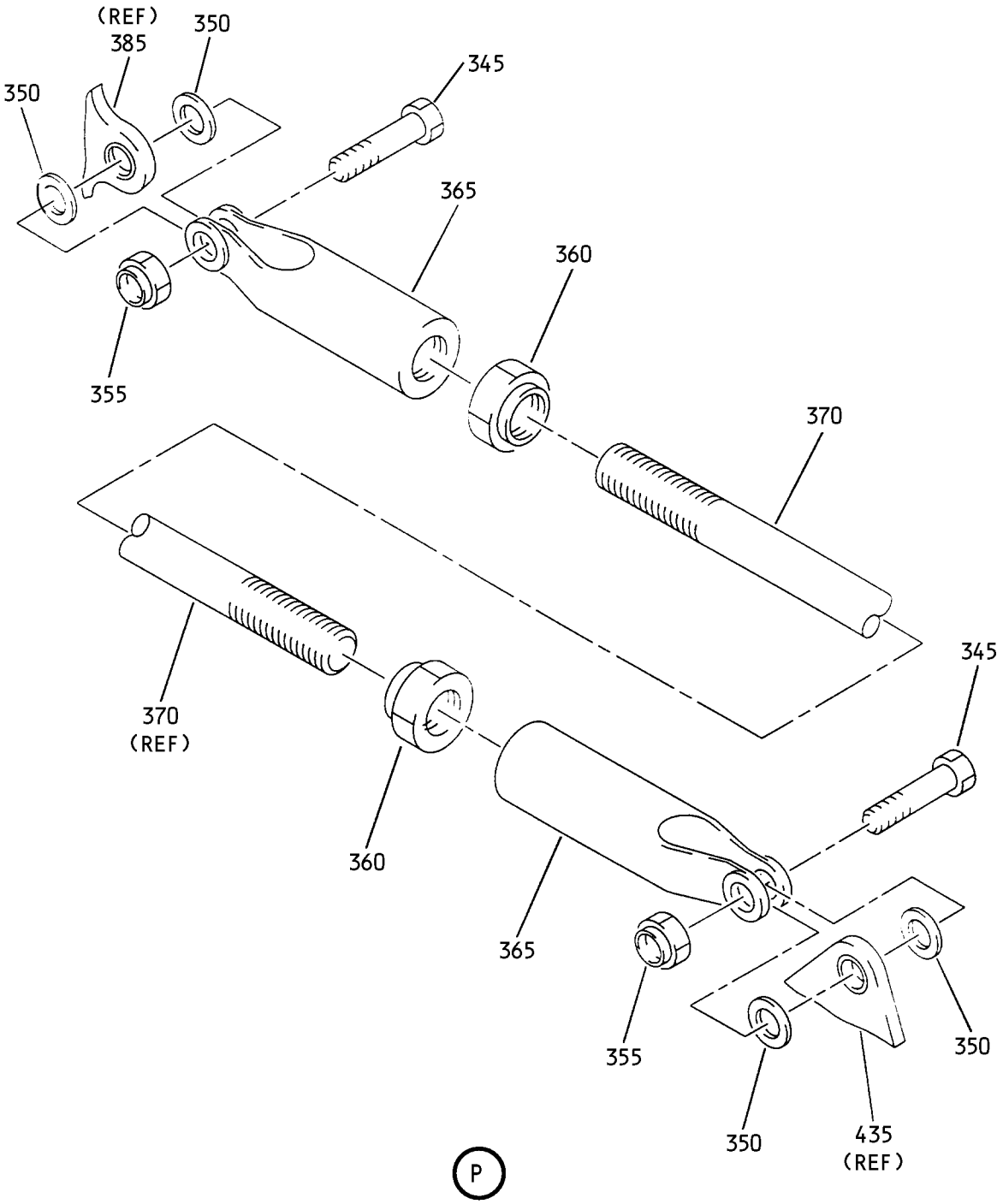
Main Landing Gear Beam Assembly
Figure 1 (Sheet 8)

K24280



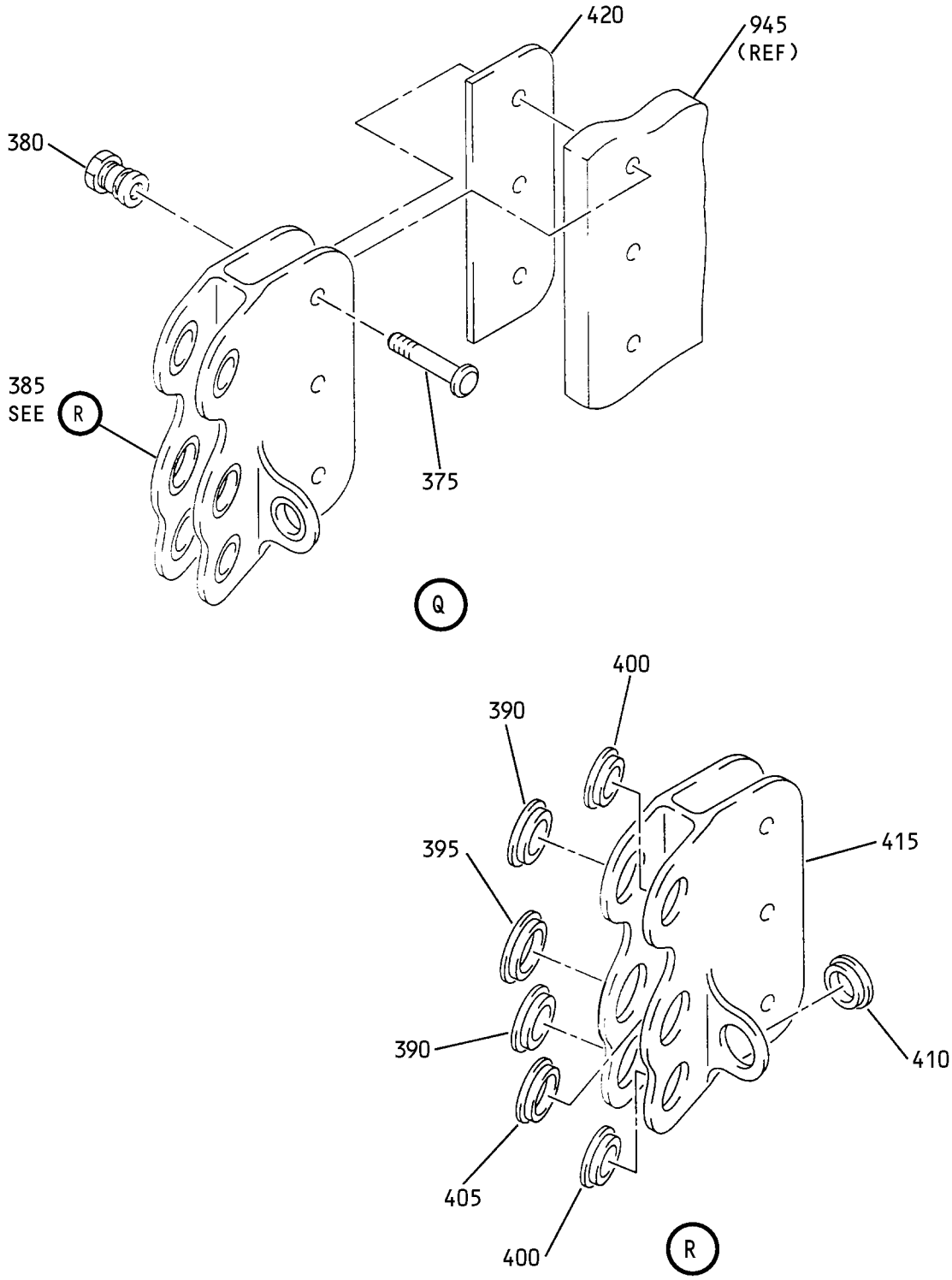
Main Landing Gear Beam Assembly
Figure 1 (Sheet 9)

K24289



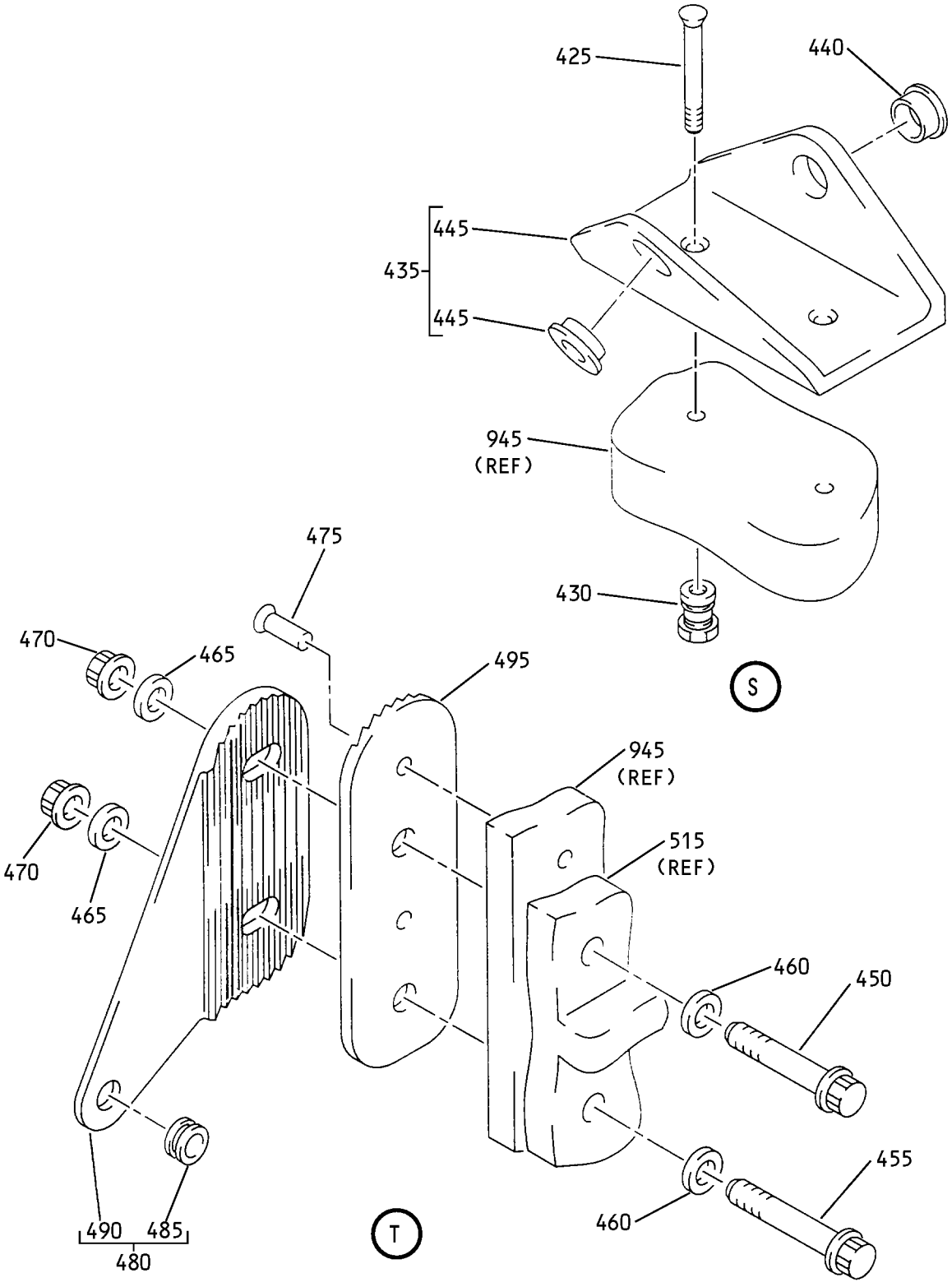
Main Landing Gear Beam Assembly
Figure 1 (Sheet 10)

K24299



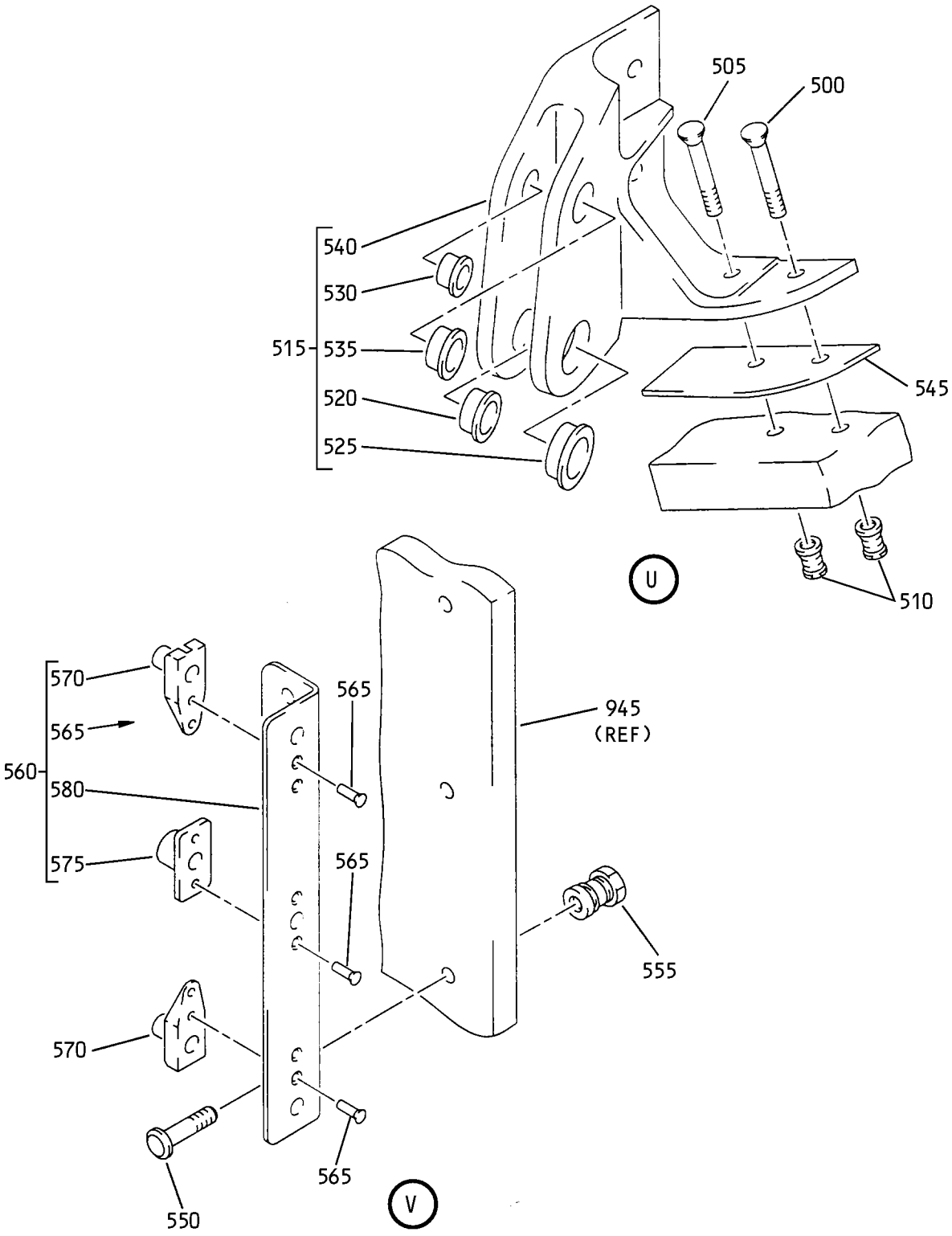
Main Landing Gear Beam Assembly
Figure 1 (Sheet 11)

K24313



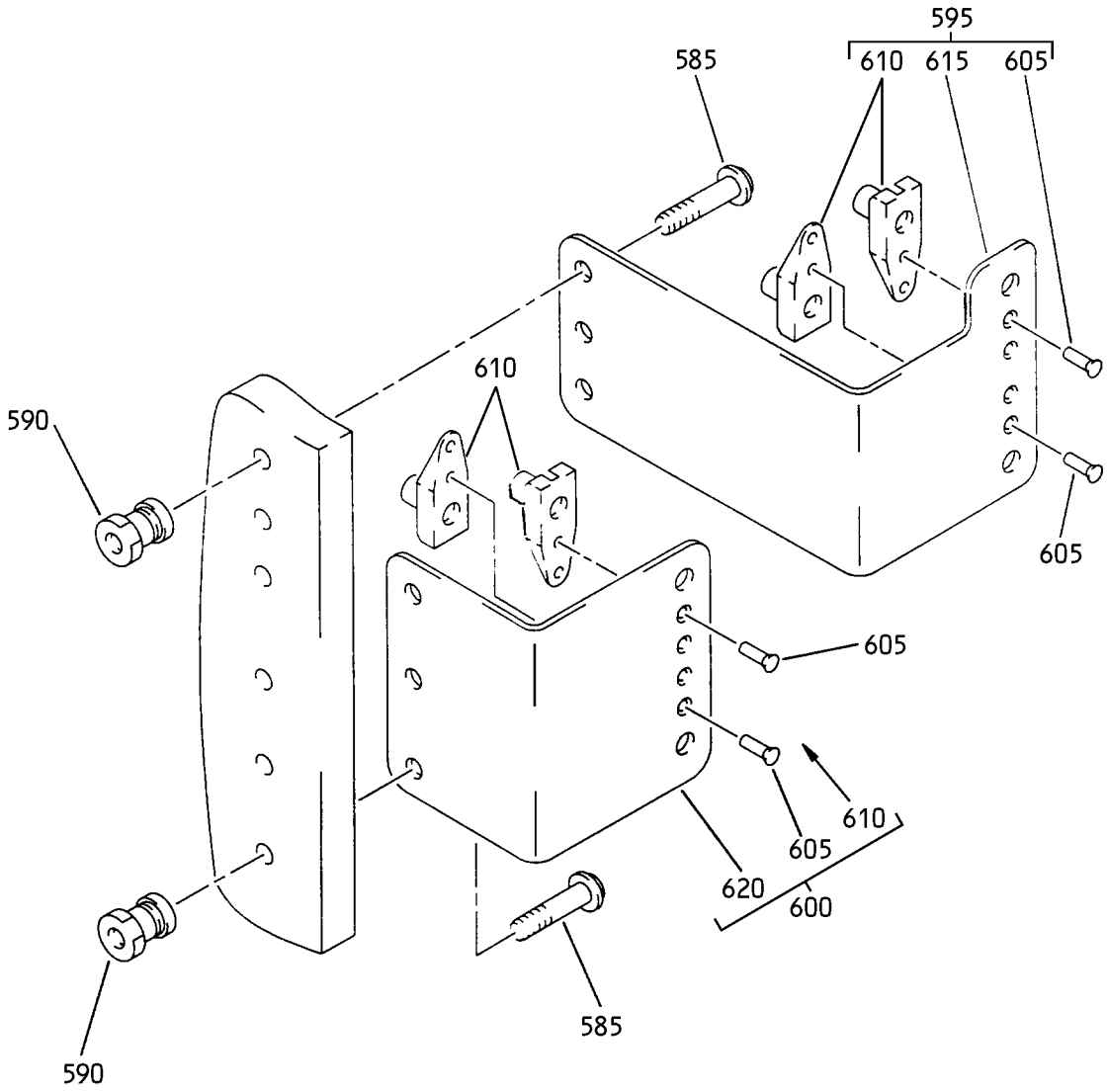
Main Landing Gear Beam Assembly
Figure 1 (Sheet 12)

K24329



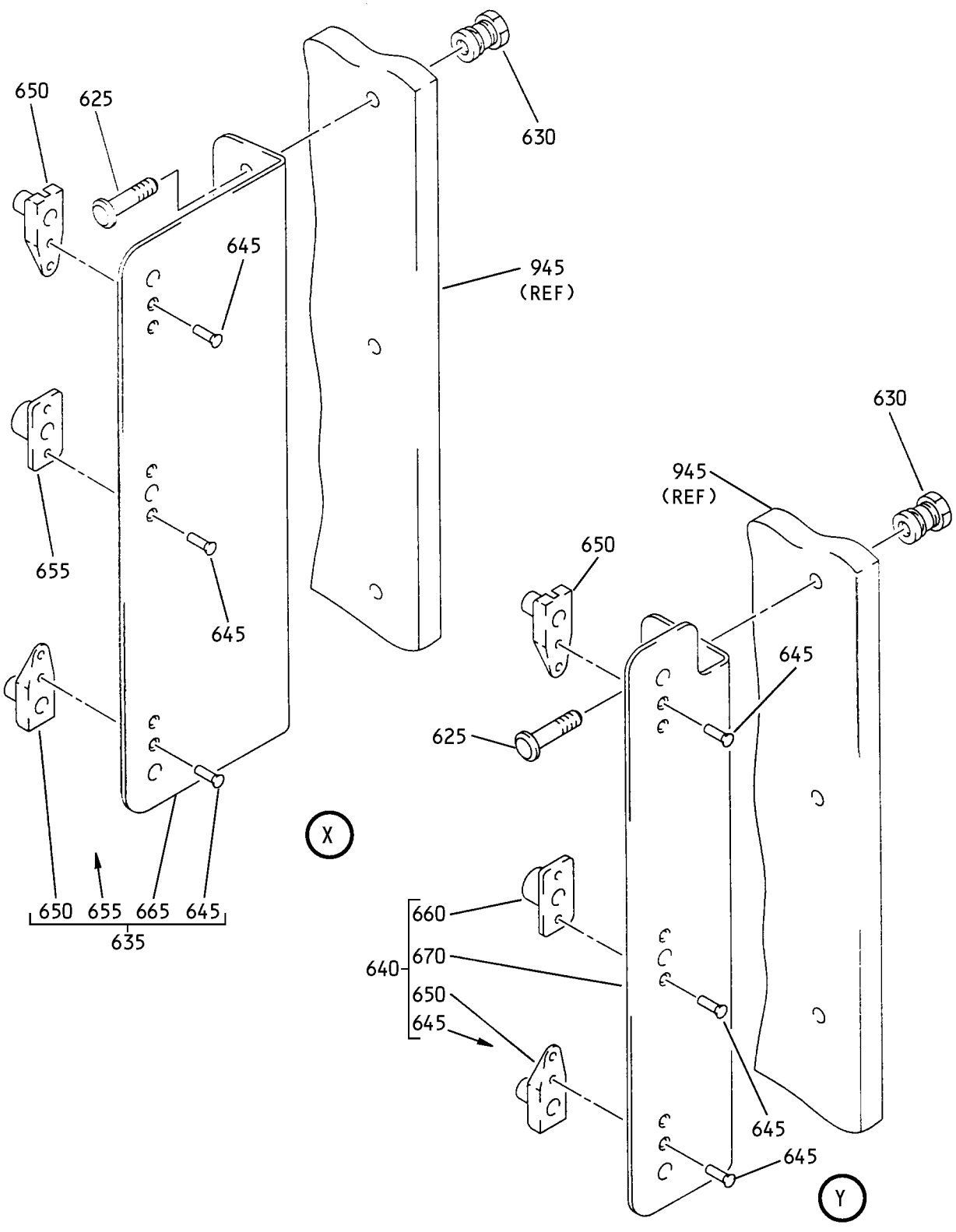
Main Landing Gear Beam Assembly
Figure 1 (Sheet 13)

K24347



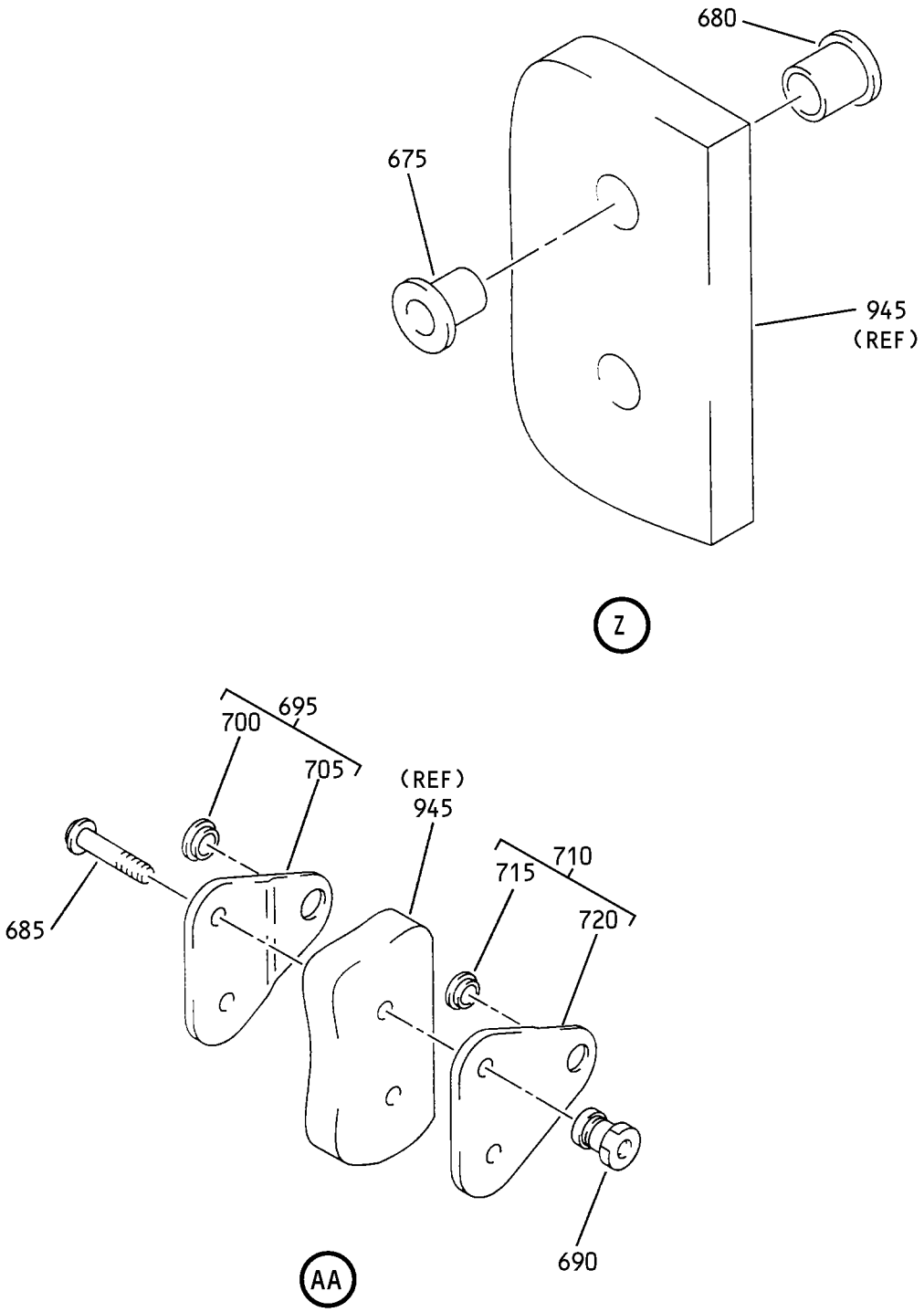
Main Landing Gear Beam Assembly
Figure 1 (Sheet 14)

K24371



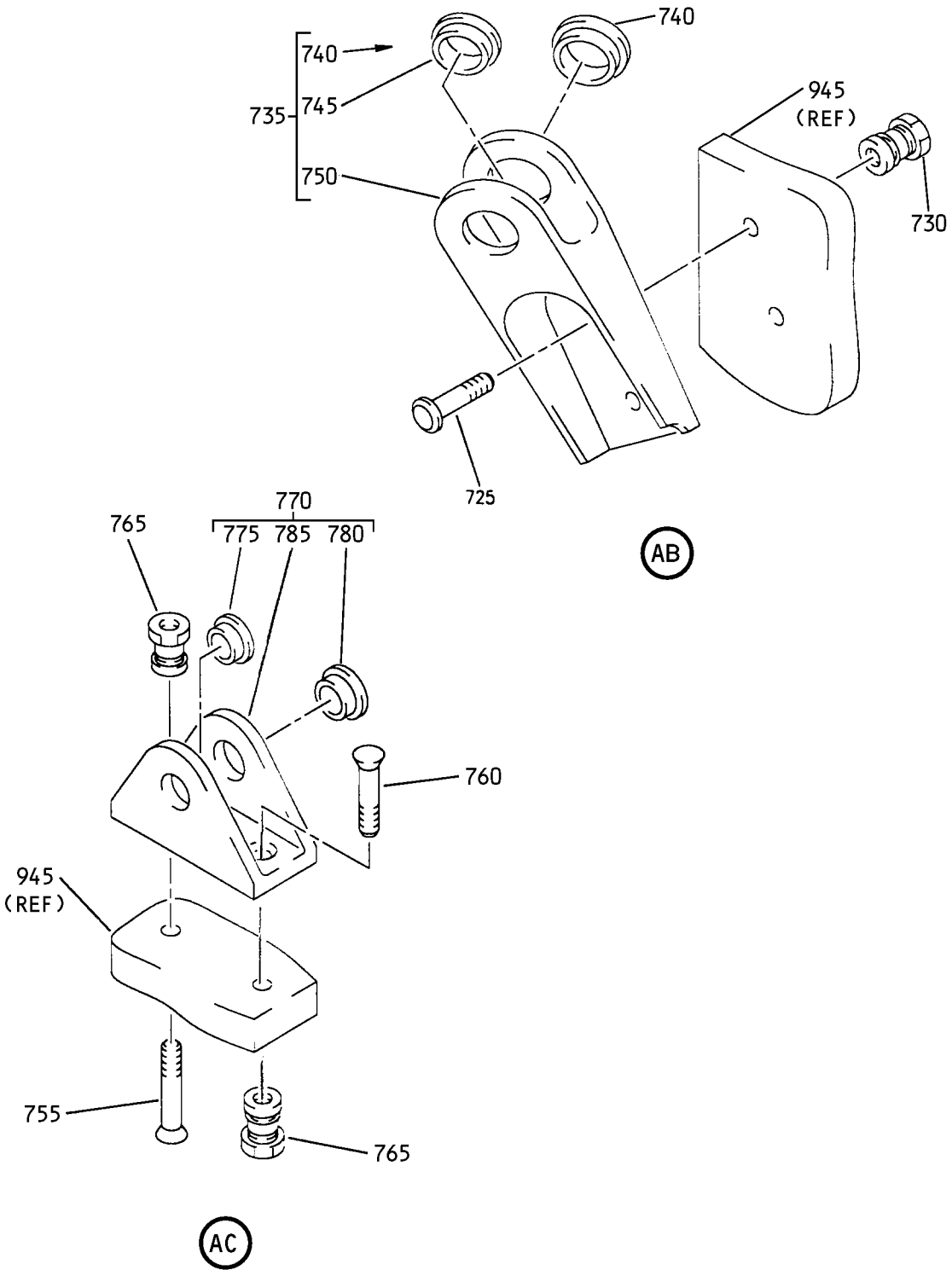
Main Landing Gear Beam Assembly
Figure 1 (Sheet 15)

K24383



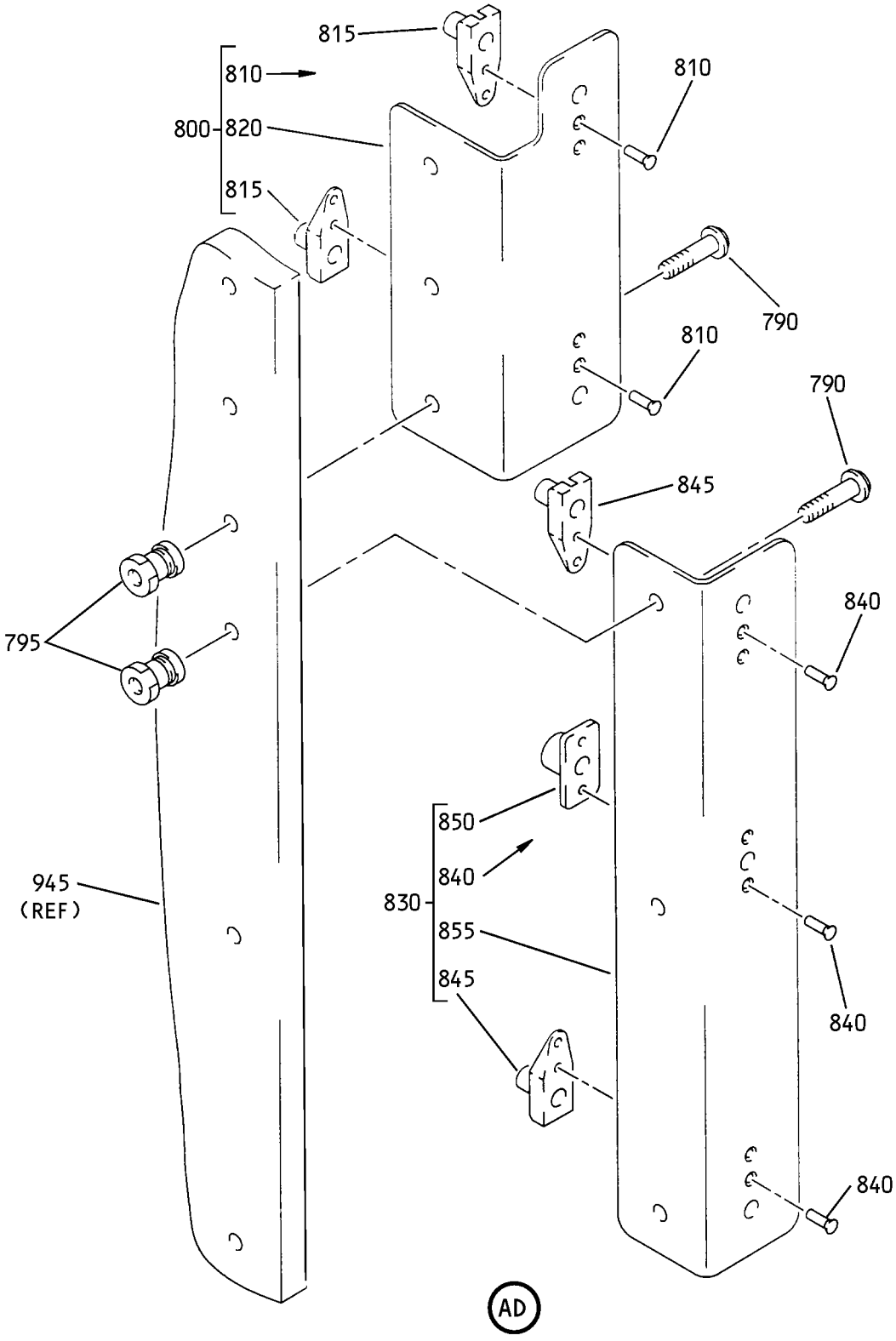
Main Landing Gear Beam Assembly
Figure 1 (Sheet 16)

K24392



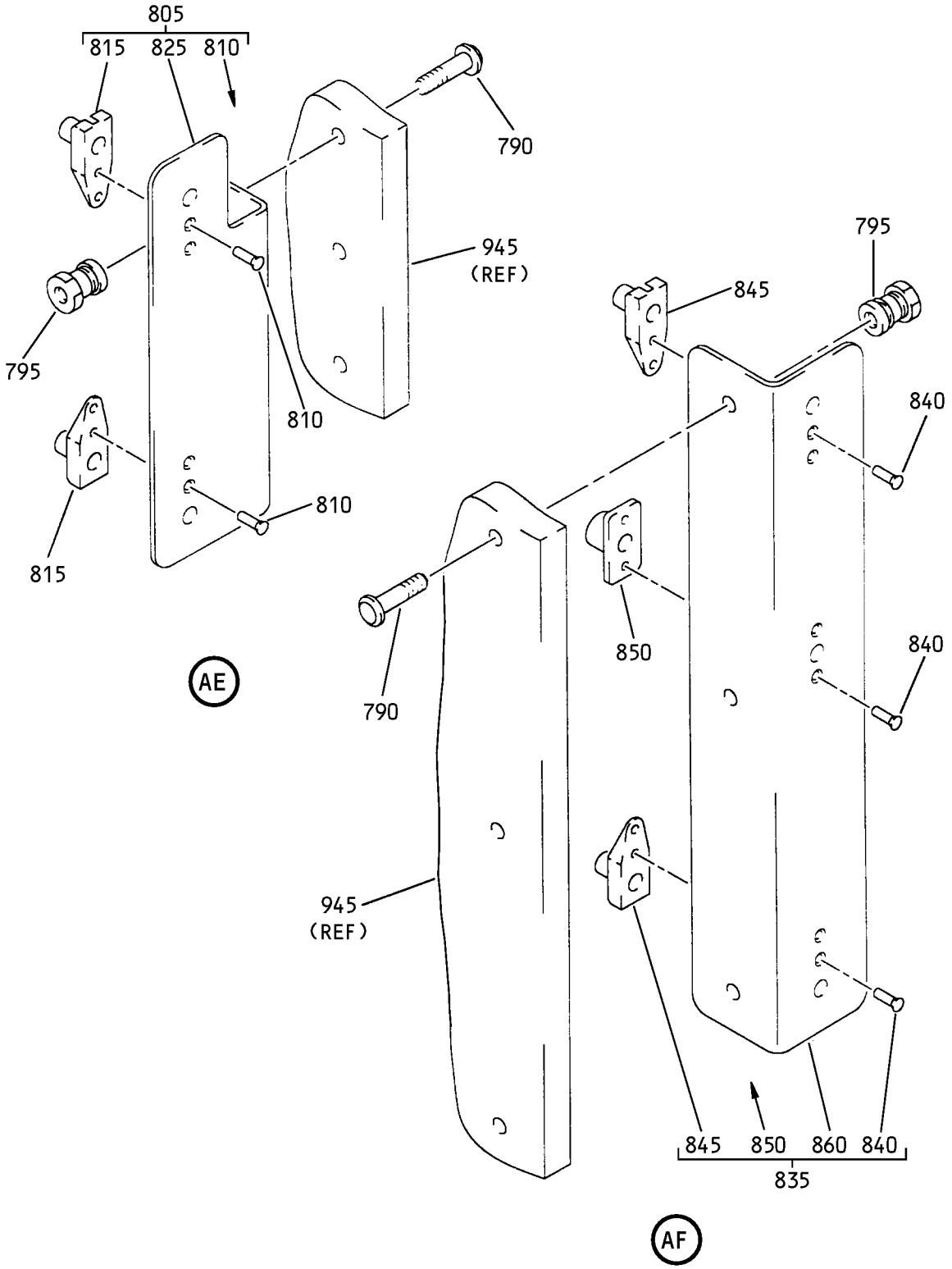
Main Landing Gear Beam Assembly
Figure 1 (Sheet 17)

K24407



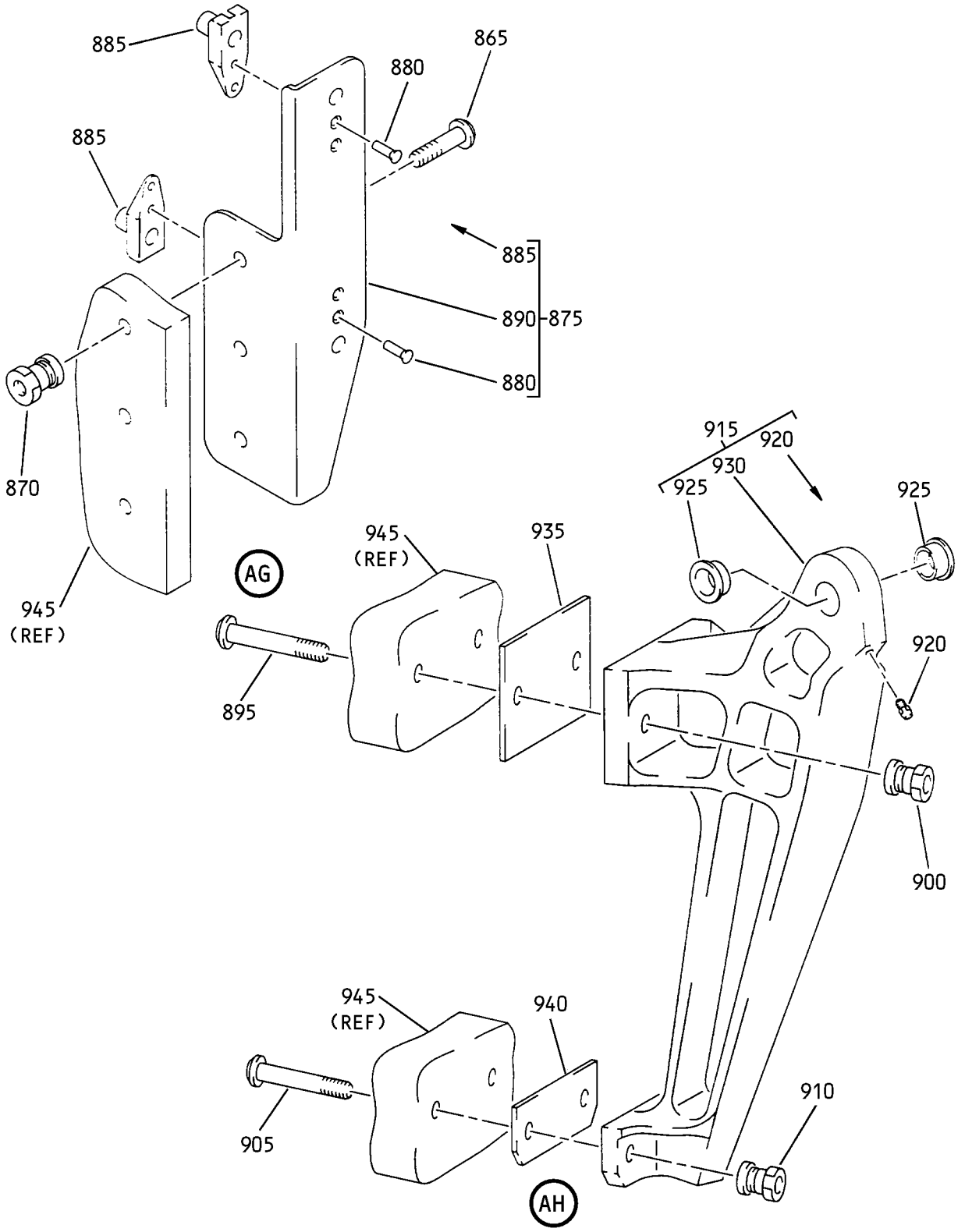
Main Landing Gear Beam Assembly
Figure 1 (Sheet 18)

K24418



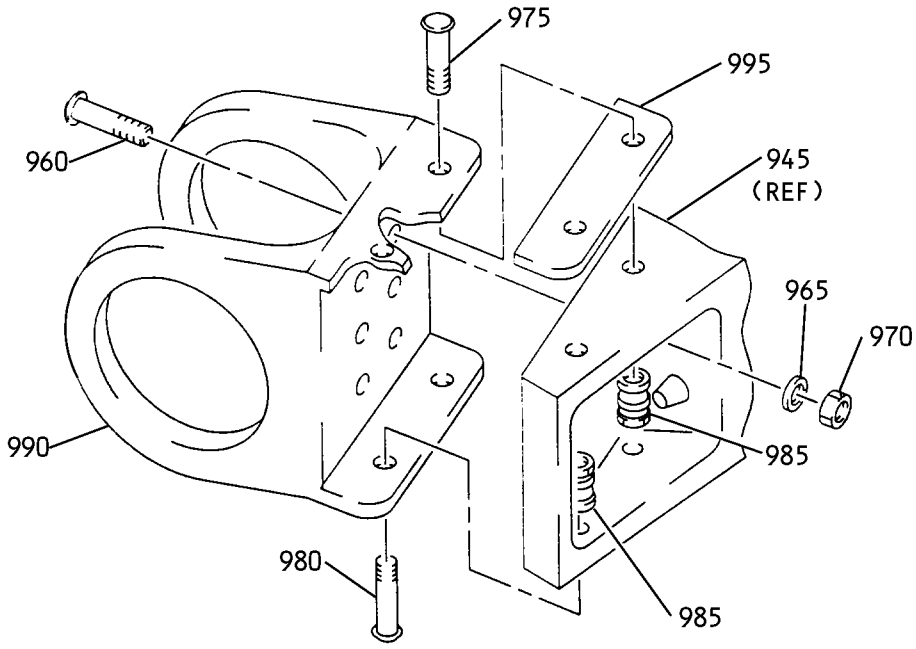
Main Landing Gear Beam Assembly
Figure 1 (Sheet 19)

K24440



Main Landing Gear Beam Assembly
Figure 1 (Sheet 20)

K24448



AI

Main Landing Gear Beam Assembly
Figure 1 (Sheet 21)

K24603

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-1A	113T1116-1		BEAM ASSY-MLG	A	RF
-1B	113T1116-2		BEAM ASSY-MLG (FOR DETAILS SEE FIG. 2)	B	RF
5	MS15001-1		.FITTING	A	3
10	113T1108-20		.BUSHING	A	2
15	113T1147-3		.BUSHING	A	1
20	113T1147-4		.BUSHING	A	1
25	113T1147-1		.BUSHING	A	2
30	113T1147-6		.BUSHING	A	1
35	113T1147-5		.BUSHING	A	1
40	HL12VAZ12-21		.BOLT- (V56878) (SPEC BACB30NX12K21) (OPT HL12VAZ12-21 (V73197)) (OPT HL12VAZ12-21 (V92215)) (OPT HL12VAZ12-21 (V97928)) (OPT L802-12K21 (V06725)) (OPT HL12VAZ12-21 (V0PTK6)) (OPT HL12VAZ12-21 (V60516))	A	3
45	HL1087-12		.COLLAR- (V56878) (SPEC BACC30BH12) (OPT HL1087-12 (V92215)) (OPT HL1087-12 (V73197)) (OPT HL1087-12 (V9N513))	A	3
50	273T1559-1		.BRACKET ASSY-TRUCK POSITIONER	A	1
55	BACR15BA3AD		..RIVET- (SIZE DETERMINE ON INST)	A	12

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
60	BRFM20A4		..NUTPLATE- (V52828) (SPEC BACN10JN4) (OPT MF53049-4 (V15653)) (OPT MF1000-4BAC (V15653)) (OPT NS103218-048 (V80539)) (OPT RMF9201M4 (V72962)) (OPT VN252A048 (V92215)) (OPT T8124S4S (V11815))	A	6
65	BACR15BA5AD		..RIVET- (SIZE DETERMINE ON INST)	A	22
70	BACR15BB5AD		..RIVET- (SIZE DETERMINE ON INST)	A	14
75	273T1559-3		..BRACKET	A	1
80	273T1559-4		..BRACKET	A	1
85	273T1559-5		..BRACKET	A	1
90	273T1559-6		..BRACKET	A	1
95	273T1559-7		..BRACKET	A	1
100	273T1559-9		..BRACKET	A	1
105	273T1559-11		..BRACKET	A	1
110	273T1559-13		..BRACKET	A	1
115	HST10AG6-6		.BOLT- (VOPTK6) (SPEC BACB30VT6K6) (OPT HST10AG6-6 (V06725)) (OPT HST10AG6-6 (V56878)) (OPT HST10AG6-6 (V73197))	A	2

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
120	HST79CY6		.COLLAR-	A	2
			(V73197)		
			(SPEC BACC30BL6)		
			(OPT HST79-6		
			(V92215))		
			(OPT HST79CY6		
			(V56878))		
			(OPT HST79CY6		
			(V5M902))		
125	272T1449-6		.BRACKET ASSY-SPRT	A	1
130	BACR15BA3AD		..RIVET-	A	4
			(SIZE DETERMINE ON INST)		
135	BRF100A3		..NUTPLATE-	A	2
			(V52828)		
			(SPEC BACN10KB3F)		
			(OPT NS103185-02		
			(V80539))		
			(OPT RMF9207-3		
			(V72962))		
			(OPT T8114S1032S		
			(V11815))		
			(OPT VN151A1-02		
			(V92215))		
			(OPT F2000-3		
			(V15653))		
140	272T1449-5		..BRACKET	A	1
145	HST10AG6-9		.BOLT-	A	7
			(VOPTK6)		
			(SPEC BACB30VT6K9)		
			(OPT HST10AG6-9		
			(V06725))		
			(OPT HST10AG6-9		
			(V56878))		
			(OPT HST10AG6-9		
			(V73197))		

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
150	HST79CY6		.COLLAR- (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V92215)) (OPT HST79CY6 (V56878)) (OPT HST79CY6 (V5M902))	A	7
155	272T1449-4		.BRACKET ASSY-SPRT	A	1
160	272T1449-8		.BRACKET ASSY-SPRT	A	1
165	272T1449-2		.BRACKET ASSY-SPRT	A	1
170	BACR15BA3AD		..RIVET- (SIZE DETERMINE ON INST)	A	4
175	BRF100A3		..NUTPLATE- (V52828) (SPEC BACN10KB3F) (OPT NS103185-02 (V80539)) (OPT RMF9207-3 (V72962)) (OPT T8114S1032S (V11815)) (OPT VN151A1-02 (V92215)) (OPT F2000-3 (V15653))	A	2
180	272T1449-3		..BRACKET- (USED ON ITEM 155)	A	1
185	272T1449-7		..BRACKET- (USED ON ITEM 160)	A	1
190	272T1449-1		..BRACKET- (USED ON ITEM 165)	A	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
195	HST10AG10-11		.BOLT- (V0PTK6) (SPEC BACB30VT10K11) (OPT HST10AG10-11 (V06725)) (OPT HST10AG10-11 (V56878)) (OPT HST10AG10-11 (V73197))	A	1
200	HST10AG10-10		.BOLT- (V0PTK6) (SPEC BACB30VT10K10) (OPT HST10AG10-10 (V06725)) (OPT HST10AG10-10 (V56878)) (OPT HST10AG10-10 (V73197))	A	1
205	HST79CY10		.COLLAR- (V73197) (SPEC BACC30BL10) (OPT HST79-10 (V92215)) (OPT HST79CY10 (V56878)) (OPT HST79CY10 (V5M902))	A	2
210	113T1005-7		.FITTING ASSY-SIDE BRACE	A	1
215	BACB28AP04P014		..BUSHING	A	1
220	BACB28AM06B015A		..BUSHING	A	1
225	113T1005-9		..FITTING	A	1
230	HST10AG6-6		.BOLT- (V0PTK6) (SPEC BACB30VT6K6) (OPT HST10AG6-6 (V06725)) (OPT HST10AG6-6 (V56878)) (OPT HST10AG6-6 (V73197))	A	11

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
235	HST79CY6		.COLLAR- (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V92215)) (OPT HST79CY6 (V56878)) (OPT HST79CY6 (V5M902))	A	11
240	272T1449-10		.BRACKET ASSY-SPRT	A	4
245	BACR15BA3AD		..RIVET- (SIZE DETERMINE ON INST)	A	6
250	BRF100A3		..NUTPLATE- (V52828) (SPEC BACN10KB3F) (OPT NS103185-02 (V80539)) (OPT RMF9207-3 (V72962)) (OPT T8114S1032S (V11815)) (OPT VN151A1-02 (V92215)) (OPT F2000-3 (V15653))	A	2
255	BRFM20C3D		..NUTPLATE- (V52828) (SPEC BACN10JN3CD) (OPT 102F9201M3 (V72962)) (OPT NS202487-02 (V80539)) (OPT MF51637-3 (V15653)) (OPT MF53050-3CD (V15653))	A	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
260	272T1449-9		..BRACKET	A	1
265	HST10AG6-8		.BOLT- (V0PTK6) (SPEC BACB30VT6K8) (OPT HST10AG6-8 (V06725)) (OPT HST10AG6-8 (V56878)) (OPT HST10AG6-8 (V73197))	A	2
270	HST10AG6-7		.BOLT- (V0PTK6) (SPEC BACB30VT6K7) (OPT HST10AG6-7 (V06725)) (OPT HST10AG6-7 (V56878)) (OPT HST10AG6-7 (V73197))	A	1
275	HST79CY6		.COLLAR- (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V92215)) (OPT HST79CY6 (V56878)) (OPT HST79CY6 (V5M902))	A	3
280	272T1449-14		.BRACKET	A	1
285	272T1449-12		.BRACKET ASSY-SPRT	A	1
290	BACR15BA3AD		..RIVET- (SIZE DETERMINE ON INST)	A	4
295	BRF100C3		..NUTPLATE- (V52828) (SPEC BACN10KB3CF) (OPT NS103185S02 (V80539)) (OPT T8112C1032C (V11815)) (OPT VN151B1-02 (V92215)) (OPT 101F9207-3 (V72962)) (OPT F2031-3 (V15653))	A	2

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
300	272T1449-11		..BRACKET	A	1
305	HST10AG8-8		.BOLT-	A	4
			(VOPTK6)		
			(SPEC BACB30VT8K8)		
			(OPT HST10AG8-8		
			(V06725))		
			(OPT HST10AG8-8		
			(V56878))		
			(OPT HST10AG8-8		
			(V73197))		
310	HST79CY8		.COLLAR-	A	4
			(V73197)		
			(SPEC BACC30BL8)		
			(OPT HST79-8		
			(V92215))		
			(OPT HST79CY8		
			(V56878))		
			(OPT HST79CY8		
			(V5M902))		
315	113T1155-1		.FITTING ASSY-TE PNL SPRT	A	1
320	113T1155-3		.FITTING ASSY-TE PNL SPRT	A	1
325	BACB28AP04P012		..BUSHING	A	1
330	BACB28AT06P012C		DELETED		
330A	BACB28AT06B012C		..BUSHING	A	1
335	113T1155-2		..FITTING-	A	1
			(USED ON ITEM 315)		
340	113T1155-4		..FITTING-	A	1
			(USED ON ITEM 320)		
345	NAS6704-9		.BOLT	A	2
350	NAS1149E0432P		.WASHER	A	4
355	BACN10JC4CD		.NUT	A	2

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
360	BACN10JC5CD		.NUT	A	2
365	NAS170-1		.ROD END	A	2
370	NAS354-5-475		.TIE ROD	A	1
375	HST10AG8-12		.BOLT- (VOPTK6) (SPEC BACB30VT8K12) (OPT HST10AG8-12 (V06725)) (OPT HST10AG8-12 (V56878)) (OPT HST10AG8-12 (V73197))	A	3
380	HST79CY8		.COLLAR- (V73197) (SPEC BACC30BL8) (OPT HST79-8 (V92215)) (OPT HST79CY8 (V56878)) (OPT HST79CY8 (V5M902))	A	3
385	113T1123-5		.FITTING ASSY	A	1
390	BACB28AM06B016A		..BUSHING	A	2
395	BACB28AM07B016A		..BUSHING	A	1
400	BACB28AP04P016		..BUSHING	A	2
405	BACB28AP05P016		..BUSHING	A	1
410	BACB28AM04B013A		..BUSHING	A	1
415	113T1123-7		..FITTING	A	1
420	BACS40R010C036		.SHIM	A	1
425	BACB30NZ10K24		.BOLT	A	2

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
430	HL97KG10		.COLLAR- (V5M902) (SPEC BACC30AB10C) (OPT HL97PB10 (V5M902)) (OPT HL97PB10 (V56878)) (OPT HL97KG10 (V73197)) (OPT HL97KG10 (V56878)) (OPT HL97PB10 (V73197))	A	2
435	113T1122-1		.FITTING ASSY	A	1
440	BACB28AM04B013A		..BUSHING	A	2
445	113T1122-2		..FITTING	A	1
450	BACB30MR6K15		.BOLT	A	1
455	BACB30MR6K16		.BOLT	A	1
460	BACW10BP6CD		.WASHER	A	2
465	BACW10BP6DP		.WASHER	A	2
470	NAS1805-6L		.NUT	A	2
475	BACR15BA8AD7C		.RIVET	A	2
480	113T1158-1		.FITTING ASSY-TE PNL SPRT	A	1
485	BACB28B4-215		..BUSHING	A	1
490	113T1158-3		..FITTING	A	1
495	113T1158-5		.PLATE-SERRATED	A	1
500	BACB30NZ12K25		.BOLT	A	1
505	BACB30NZ12K24		.BOLT	A	1
510	BACC30BU12PW		.COLLAR	A	2
515	113T1156-1		.FITTING ASSY-TE PNL SPRT	A	1
520	BACB28AP06P028		..BUSHING	A	1
525	BACB28AT09B028C		..BUSHING	A	1
530	BACB28AP04P028		..BUSHING	A	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
535	BACB28AT06B028C		..BUSHING	A	1
540	113T1156-3		..FITTING	A	1
545	BACS40R016C031F		.SHIM	A	1
550	HST10AG6-6		.BOLT- (VOPTK6) (SPEC BACB30VT6K6) (OPT HST10AG6-6 (V06725)) (OPT HST10AG6-6 (V56878)) (OPT HST10AG6-6 (V73197))	A	6
555	HST79CY6		.COLLAR- (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V92215)) (OPT HST79CY6 (V56878)) (OPT HST79CY6 (V5M902))	A	6
560	272T1450-3		.BRACKET ASSY-SPRT	A	2
565	BACR15BA3AD		..RIVET- (SIZE DETERMINE ON INST)	A	6
570	BRF100A3		..NUTPLATE- (V52828) (SPEC BACN10KB3F) (OPT NS103185-02 (V80539)) (OPT RMF9207-3 (V72962)) (OPT T8114S1032S (V11815)) (OPT VN151A1-02 (V92215)) (OPT F2000-3 (V15653))	A	2

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
575	BRFM20C3D		..NUTPLATE- (V52828) (SPEC BACN10JN3CD) (OPT 102F9201M3 (V72962)) (OPT NS202487-02 (V80539)) (OPT MF51637-3 (V15653)) (OPT MF53050-3CD (V15653))	A	1
580	272T1450-1		..BRACKET	A	1
585	HST10AG6-6		.BOLT- (VOPTK6) (SPEC BACB30VT6K6) (OPT HST10AG6-6 (V06725)) (OPT HST10AG6-6 (V56878)) (OPT HST10AG6-6 (V73197))	A	6
590	HST79CY6		.COLLAR- (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V92215)) (OPT HST79CY6 (V56878)) (OPT HST79CY6 (V5M902))	A	6

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
595	272T1451-2		.BRACKET ASSY-SPRT	A	1
600	272T1451-4		.BRACKET ASSY-SPRT	A	1
605	BACR15BA3AD		..RIVET- (SIZE DETERMINE ON INST)	A	4
610	BRF100A3		..NUTPLATE- (V52828) (SPEC BACN10KB3F) (OPT NS103185-02 (V80539)) (OPT RMF9207-3 (V72962)) (OPT T8114S1032S (V11815)) (OPT VN151A1-02 (V92215)) (OPT F2000-3 (V15653))	A	2
615	272T1451-1		..BRACKET- (USED ON ITEM 595)	A	1
620	272T1451-3		..BRACKET- (USED ON ITEM 600)	A	1
625	HST10AG6-9		.BOLT- (VOPTK6) (SPEC BACB30VT6K9) (OPT HST10AG6-9 (V06725)) (OPT HST10AG6-9 (V56878)) (OPT HST10AG6-9 (V73197))	A	6
630	HST79CY6		.COLLAR- (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V92215)) (OPT HST79CY6 (V56878)) (OPT HST79CY6 (V5M902))	A	6

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
635	272T1451-6		.BRACKET ASSY-SPRT	A	1
640	272T1450-7		.BRACKET ASSY-SPRT	A	1
645	BACR15BA3AD		..RIVET- (SIZE DETERMINE ON INST)	A	6
650	BRF100A3		..NUTPLATE- (V52828) (SPEC BACN10KB3F) (OPT NS103185-02 (V80539)) (OPT RMF9207-3 (V72962)) (OPT T8114S1032S (V11815)) (OPT VN151A1-02 (V92215)) (OPT F2000-3 (V15653))	A	2
655	BRFM20C3D		..NUTPLATE- (V52828) (SPEC BACN10JN3CD) (OPT 102F9201M3 (V72962)) (OPT NS202487-02 (V80539)) (OPT MF51637-3 (V15653)) (OPT MF53050-3CD (V15653)) (USED ON ITEM 635)	A	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
660	H10-3BAC		..NUT-	A	1
			(V15653)		
			(SPEC BACN10JC3)		
			(OPT NS202101-02		
			(V80539))		
			(OPT RMLH9075-3W		
			(V72962))		
			(OPT VN303A02		
			(V92215))		
			(OPT 96-02		
			(V80539))		
			(OPT BRH10A3		
			(V52828))		
			(OPT T6S1032J		
			(V11815))		
			(USED ON ITEM 640)		
665	272T1451-5		..BRACKET-	A	1
			(USED ON ITEM 635)		
670	272T1450-5		..BRACKET-	A	1
			(USED ON ITEM 640)		
675	BACB28AX04C053		.BUSHING	A	4
680	BACB28AT06B048C		.BUSHING	A	4
685	HST10AG8-11		.BOLT-	A	8
			(V0PTK6)		
			(SPEC BACB30VT8K11)		
			(OPT HST10AG8-11		
			(V06725))		
			(OPT HST10AG8-11		
			(V56878))		
			(OPT HST10AG8-11		
			(V73197))		
690	HST79CY8		.COLLAR-	A	8
			(V73197)		
			(SPEC BACC30BL8)		
			(OPT HST79-8		
			(V92215))		
			(OPT HST79CY8		
			(V56878))		
			(OPT HST79CY8		
			(V5M902))		

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
695	113T1126-7		.FITTING ASSY	A	4
700	BACB28AM06B010A		..BUSHING	A	1
705	113T1126-9		..FITTING	A	1
710	113T1126-8		.FITTING ASSY	A	4
715	BACB28AP04P010		..BUSHING	A	1
720	113T1126-10		..FITTING	A	1
725	HST10AG10-8		.BOLT- (VOPTK6) (SPEC BACB30VT10K8) (OPT HST10AG10-8 (V06725)) (OPT HST10AG10-8 (V56878)) (OPT HST10AG10-8 (V73197))	A	2
730	HST79CY10		.COLLAR- (V73197) (SPEC BACC30BL10) (OPT HST79-10 (V92215)) (OPT HST79CY10 (V56878)) (OPT HST79CY10 (V5M902))	A	2
735	113T1157-1		.FITTING ASSY-TE PNL SPRT	A	1
740	BACB28AT09B015C		..BUSHING	A	1
745	BACB28AP06P016		..BUSHING	A	1
750	113T1157-3		..FITTING	A	1
755	L804-8K26		.BOLT- (V06725) (SPEC BACB30NZ8K26) (OPT HL523AZ8-26 (V56878)) (OPT HL523AZ8-26 (V73197)) (OPT HL523AZ8-26 (V92215)) (OPT HL523AZ8-26 (V97928)) (OPT HL523AZ8-26 (VOPTK6)) (OPT HL523AZ8-26 (V60516)) (OPT HL523AZ8-26 (V06725))	A	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-760	HL523AZ8-24		.BOLT- (V73197) (SPEC BACB30NZ8K24) (OPT L804-8K24 (V06725)) (OPT HL523AZ8-24 (V56878)) (OPT HL523AZ8-24 (V92215)) (OPT HL523AZ8-24 (V97928)) (OPT HL523AZ8-24 (VOPTK6)) (OPT HL523AZ8-24 (V60516)) (OPT HL523AZ8-24 (V06725))	A	1
765	HL97KG8		.COLLAR- (V5M902) (SPEC BACC30AB8C) (OPT HL97PB8 (V5M902)) (OPT HL97PB8 (V56878)) (OPT HL97KG8 (V73197)) (OPT HL97KG8 (V56878)) (OPT HL97PB8 (V73197))	A	2

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
770	113T1126-21		.FITTING ASSY	A	1
775	BACB28AP05P013		..BUSHING	A	1
780	BACB28AM07B014A		..BUSHING	A	1
785	113T1126-23		..FITTING	A	1
790	HST10AG6-6		.BOLT- (VOPTK6) (SPEC BACB30VT6K6) (OPT HST10AG6-6 (V06725)) (OPT HST10AG6-6 (V56878)) (OPT HST10AG6-6 (V73197))	A	12
795	HST79CY6		.COLLAR- (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V92215)) (OPT HST79CY6 (V56878)) (OPT HST79CY6 (V5M902))	A	12
800	272T1450-11		.BRACKET ASSY-SPRT	A	1
805	272T1450-27		.BRACKET ASSY-SPRT	A	1
810	BACR15BA3AD		..RIVET- (SIZE DETERMINE ON INST)	A	4
815	BRF100A3		..NUTPLATE- (V52828) (SPEC BACN10KB3F) (OPT NS103185-02 (V80539)) (OPT RMF9207-3 (V72962)) (OPT T8114S1032S (V11815)) (OPT VN151A1-02 (V92215)) (OPT F2000-3 (V15653))	A	2

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
820	272T1450-9		..BRACKET- (USED ON ITEM 800)	A	1
825	272T1450-25		..BRACKET- (USED ON ITEM 805)	A	1
830	272T1450-15		.BRACKET ASSY-SPRT	A	1
835	272T1450-23		.BRACKET ASSY-SPRT	A	1
840	BACR15BA3AD		..RIVET- (SIZE DETERMINE ON INST)	A	6
845	BRF100A3		..NUTPLATE- (V52828) (SPEC BACN10KB3F) (OPT NS103185-02 (V80539)) (OPT RMF9207-3 (V72962)) (OPT T8114S1032S (V11815)) (OPT VN151A1-02 (V92215)) (OPT F2000-3 (V15653))	A	2
850	BRFM20A3		..NUTPLATE- (V52828) (SPEC BACN10JN3) (OPT MF1000-3BAC (V15653)) (OPT NS103218-02 (V80539)) (OPT RMF9201M3 (V72962)) (OPT VN252A02 (V92215)) (OPT MF53049-3 (V15653)) (OPT T8124S3S (V11815))	A	1

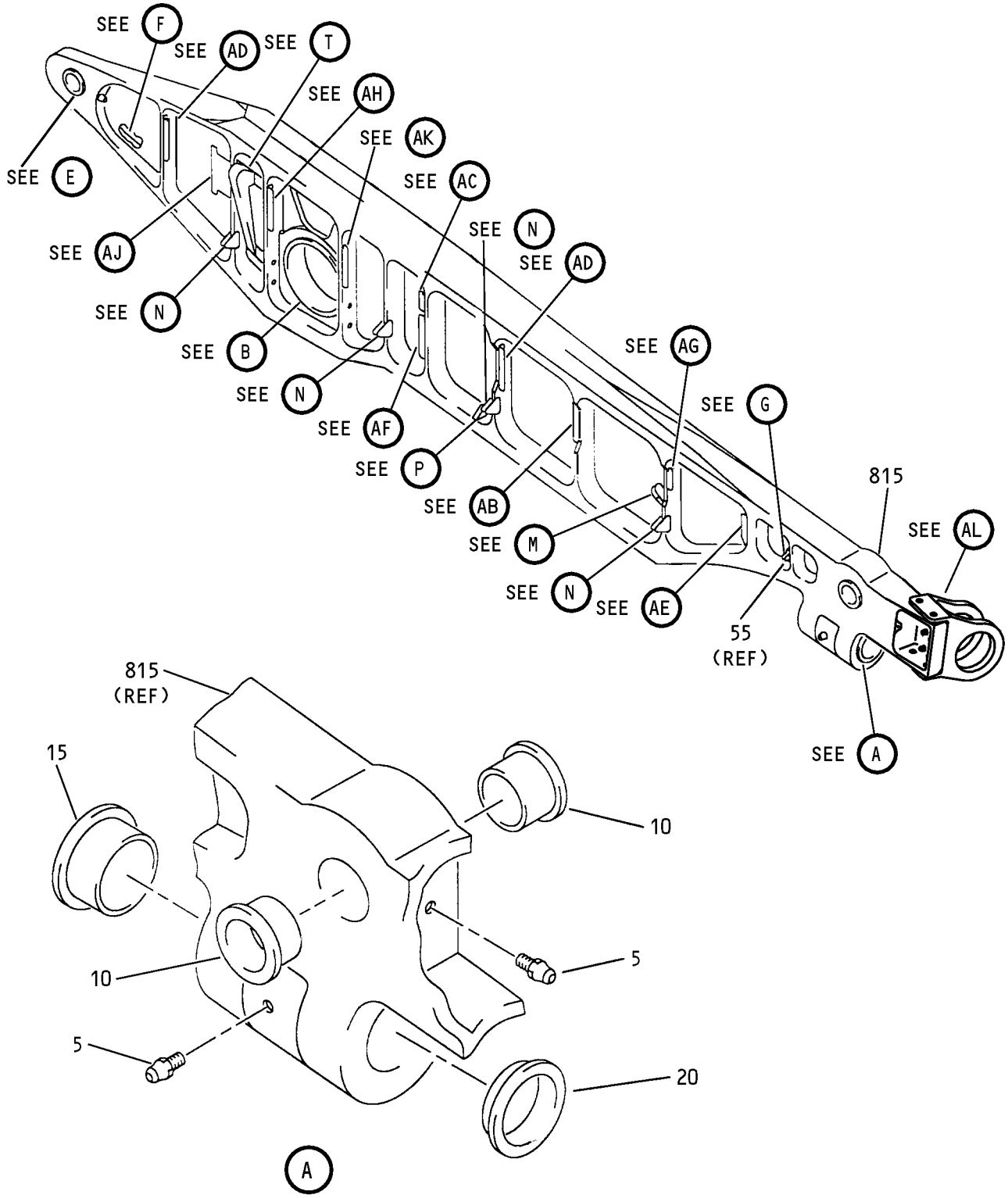
FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
855	272T1450-13		..BRACKET-	A	1
			(USED ON ITEM 830)		
860	272T1450-21		..BRACKET-	A	1
			(USED ON ITEM 835)		
865	HST10AG6-8		.BOLT-	A	3
			(VOPTK6)		
			(SPEC BACB30VT6K8)		
			(OPT HST10AG6-8		
			(V06725))		
			(OPT HST10AG6-8		
			(V56878))		
			(OPT HST10AG6-8		
			(V73197))		
870	HST79CY6		.COLLAR-	A	3
			(V73197)		
			(SPEC BACC30BL6)		
			(OPT HST79-6		
			(V92215))		
			(OPT HST79CY6		
			(V56878))		
			(OPT HST79CY6		
			(V5M902))		
875	272T1450-31		.BRACKET ASSY-SPRT	A	1
880	BACR15BA3AD		..RIVET-	A	4
			(SIZE DETERMINE ON INST)		
885	BRF100A3		..NUTPLATE-	A	2
			(V52828)		
			(SPEC BACN10KB3F)		
			(OPT NS103185-02		
			(V80539))		
			(OPT RMF9207-3		
			(V72962))		
			(OPT T8114S1032S		
			(V11815))		
			(OPT VN151A1-02		
			(V92215))		
			(OPT F2000-3		
			(V15653))		

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
890	272T1450-29		..BRACKET	A	1
895	HL12VAZ16-32		.BOLT- (V56878) (SPEC BACB30NX16K32) (OPT HL12VAZ16-32 (V73197)) (OPT HL12VAZ16-32 (V92215)) (OPT HL12VAZ16-32 (V97928)) (OPT L802-16K32 (V06725)) (OPT HL12-32 (V06725)) (OPT HL12VAZ16-32 (V97928))	A	2
900	HL1187-16		.COLLAR- (V73197) (SPEC BACC30X16) (OPT HL87-16 (V92215)) (OPT HL87-16 (V73197)) (OPT HL1187-16 (V56878)) (OPT HL1187-16 (V92215)) (OPT HL87-16 (V56878)) (OPT HL1187-16 (V5M902))	A	2

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
905	HL12VAZ12-17		.BOLT- (V56878) (SPEC BACB30NX12K17) (OPT HL12VAZ12-17 (V73197)) (OPT HL12VAZ12-17 (V92215)) (OPT HL12VAZ12-17 (V97928)) (OPT L802-12K17 (V06725)) (OPT HL12VAZ12-17 (VOPTK6)) (OPT HL12VAZ12-17 (V60516))	A	2
910	HL1087-12		.COLLAR- (V56878) (SPEC BACC30BH12) (OPT HL1087-12 (V92215)) (OPT HL1087-12 (V73197)) (OPT HL1087-12 (V9N513))	A	2
915	113T1160-1		.FITTING ASSY-ATTACH	A	1
920	MS15001-1		..FITTING	A	1
925	BACB28AT10B029C		..BUSHING	A	2
930	113T1160-3		..FITTING	A	1
935	BACS40R029C051F		.SHIM	A	1
940	BACS40R017C047F		.SHIM	A	1
945	113T1117-1		.BEAM	A	1
			INSTALLATION PARTS		
960	BACB30NX12K17		BOLT	A	6
965	BACW10BP12DP		WASHER	A	6
970	NAS1805-12		NUT	A	6
975	BACB30MY16K17		BOLT	A	2

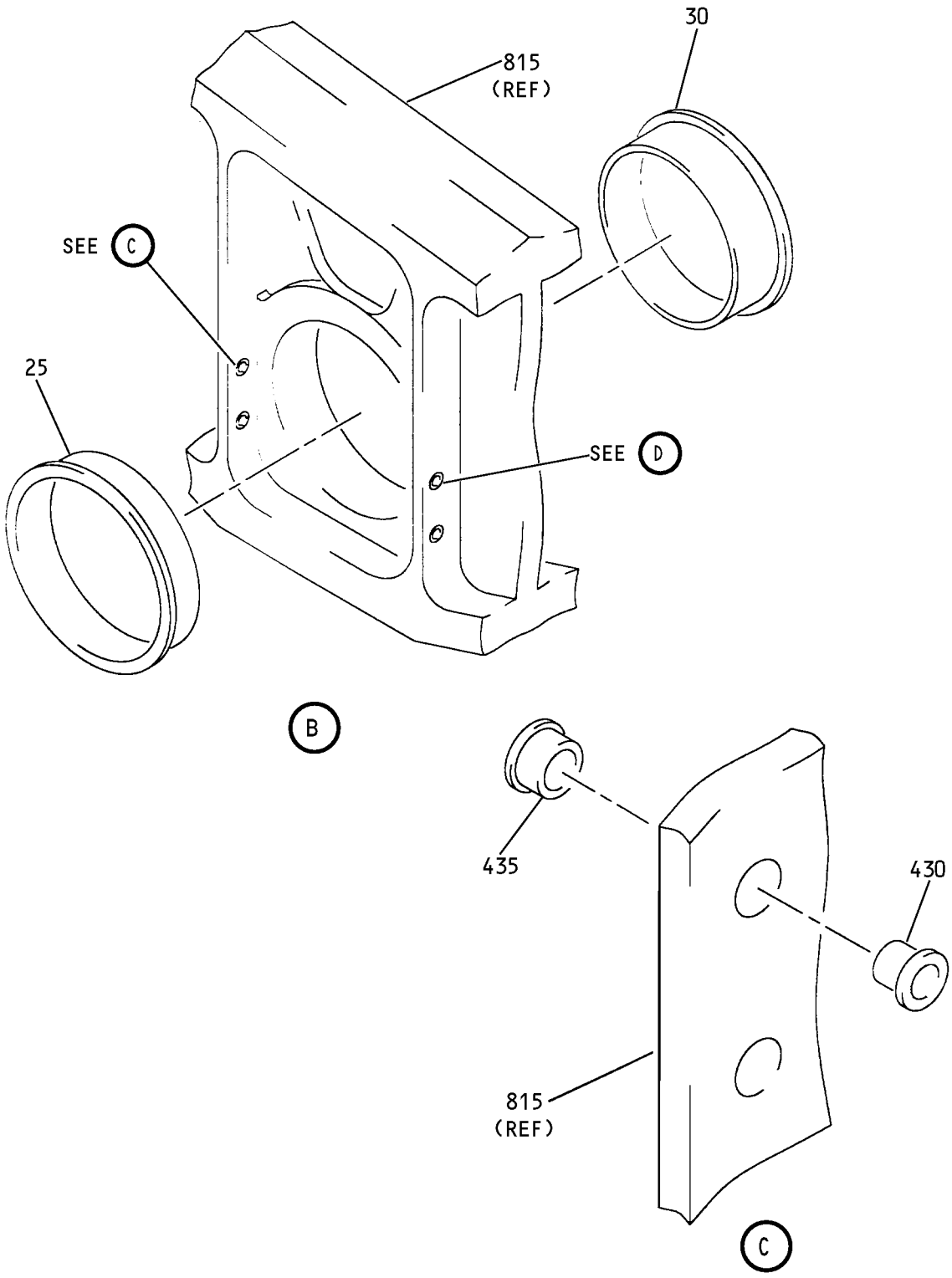
FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
980	BACB30MY16K21		BOLT	A	2
985	BACC30AB16C		COLLAR	A	4
990	113T1138-1		SUPPORT FITTING	A	1
995	BACS40RO22C063F		SHIM	A	1

- Item Not Illustrated



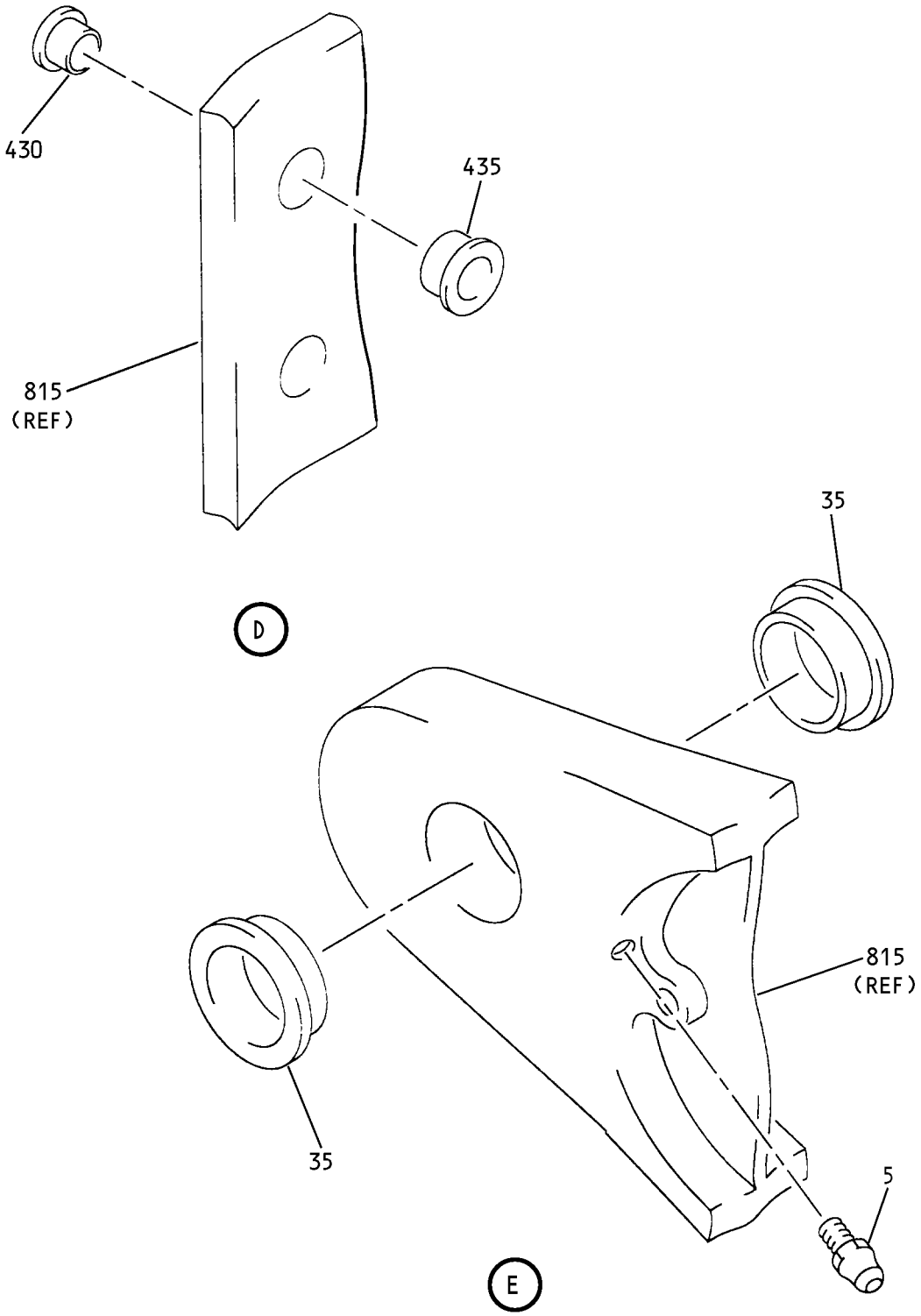
Main Landing Gear Beam Assembly
Figure 2 (Sheet 1)

K24658



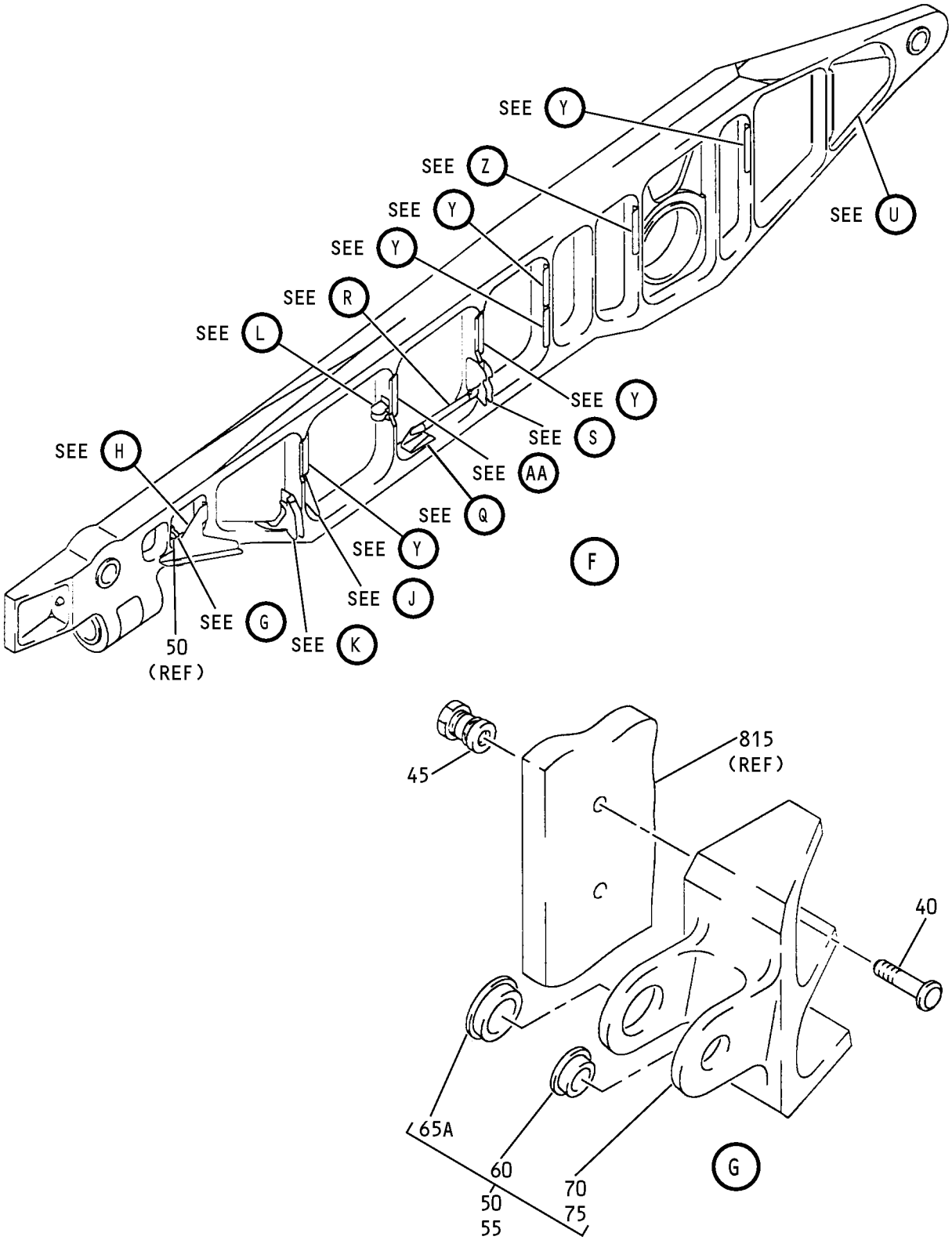
Main Landing Gear Beam Assembly
Figure 2 (Sheet 2)

K24663



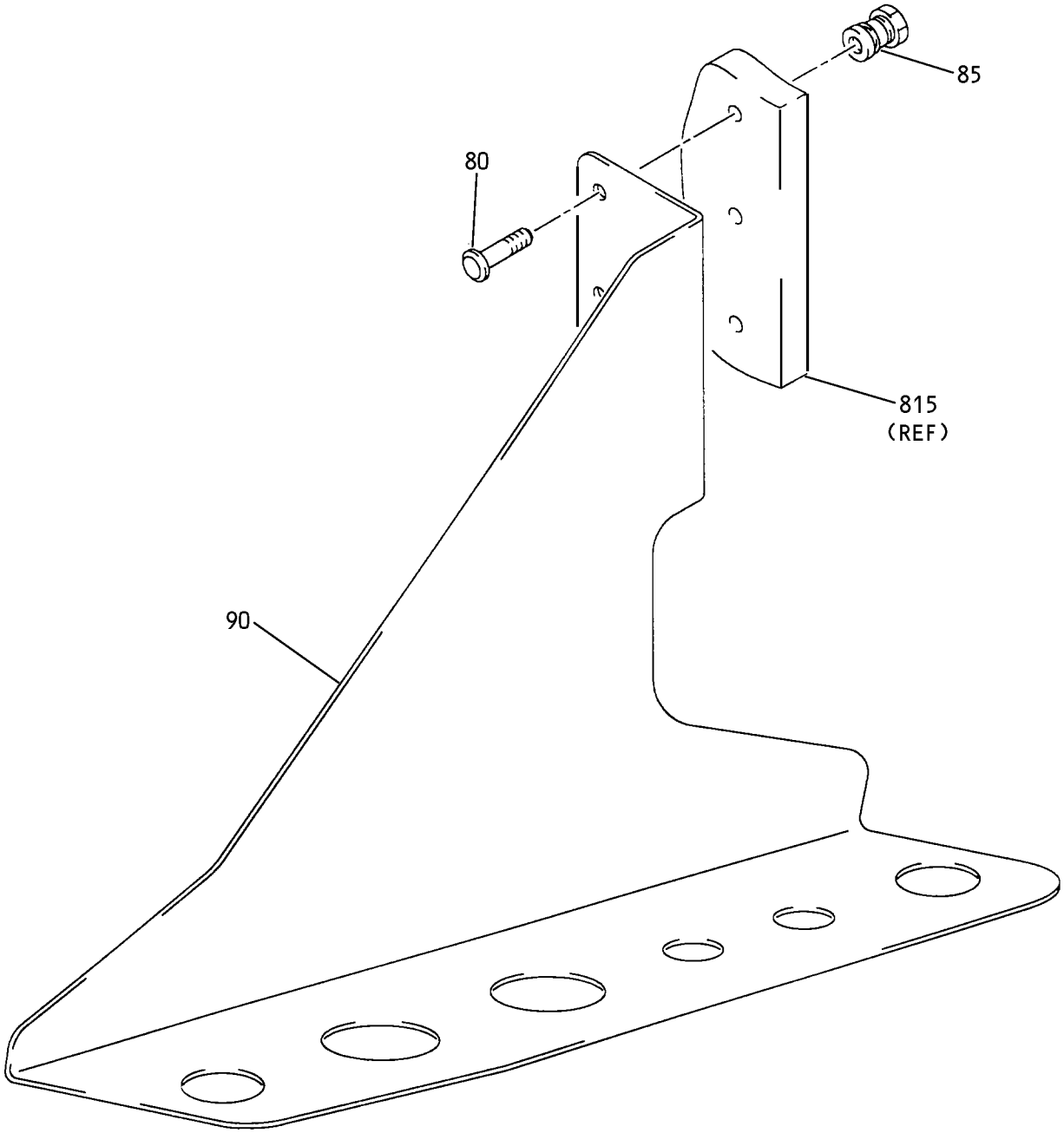
Main Landing Gear Beam Assembly
Figure 2 (Sheet 3)

K24668



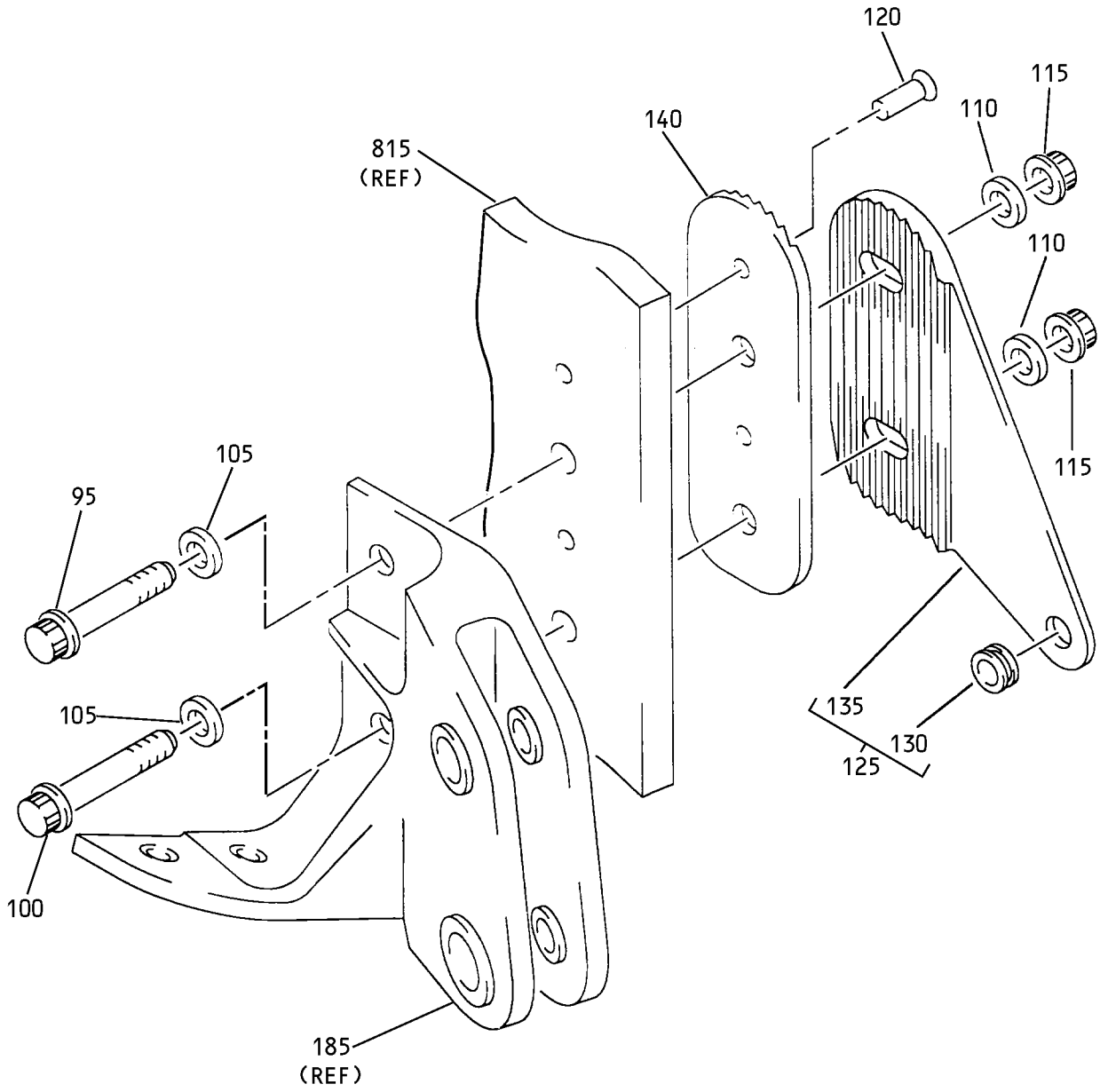
Main Landing Gear Beam Assembly
Figure 2 (Sheet 4)

K24683



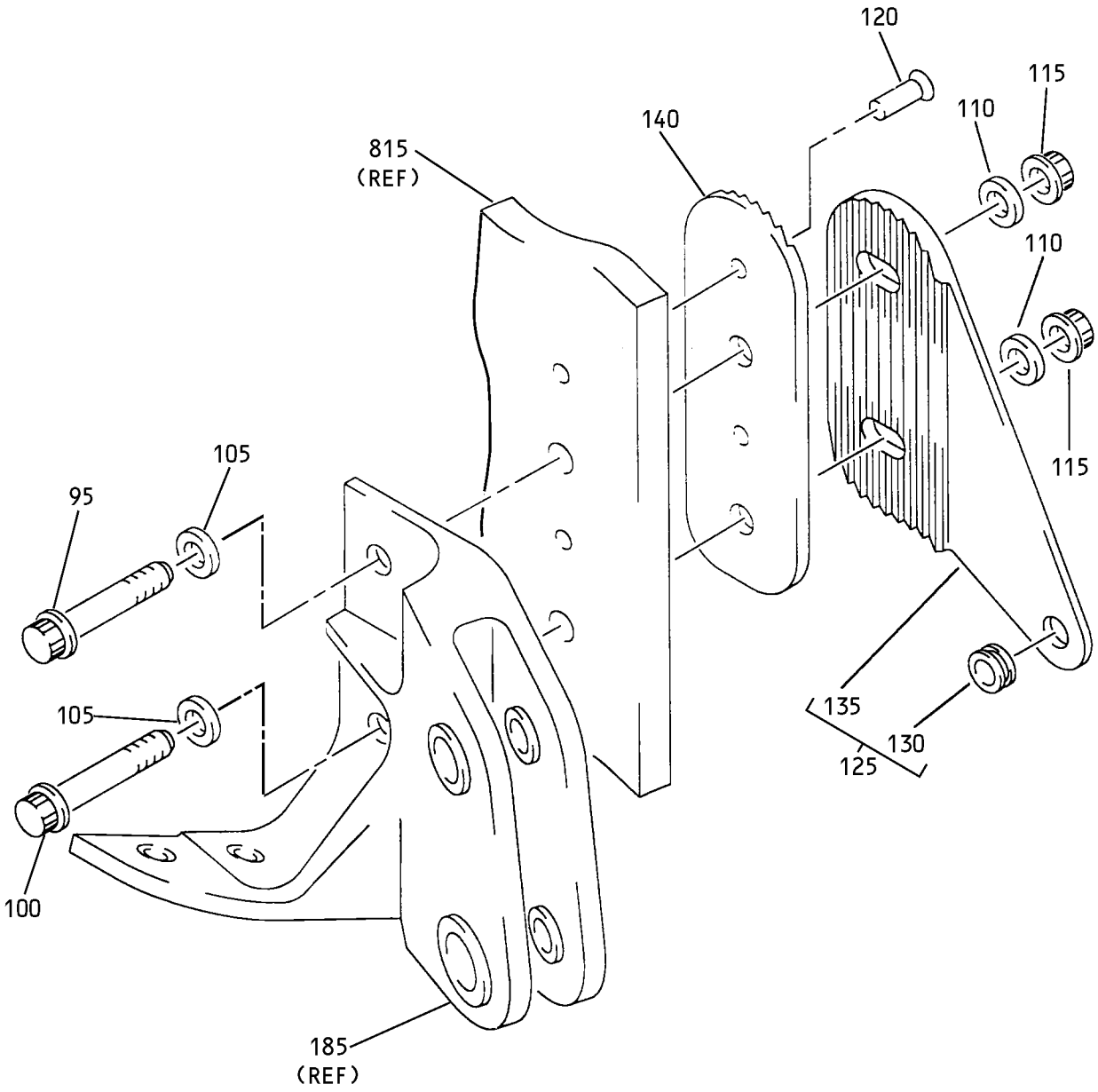
Main Landing Gear Beam Assembly
Figure 2 (Sheet 5)

K24693



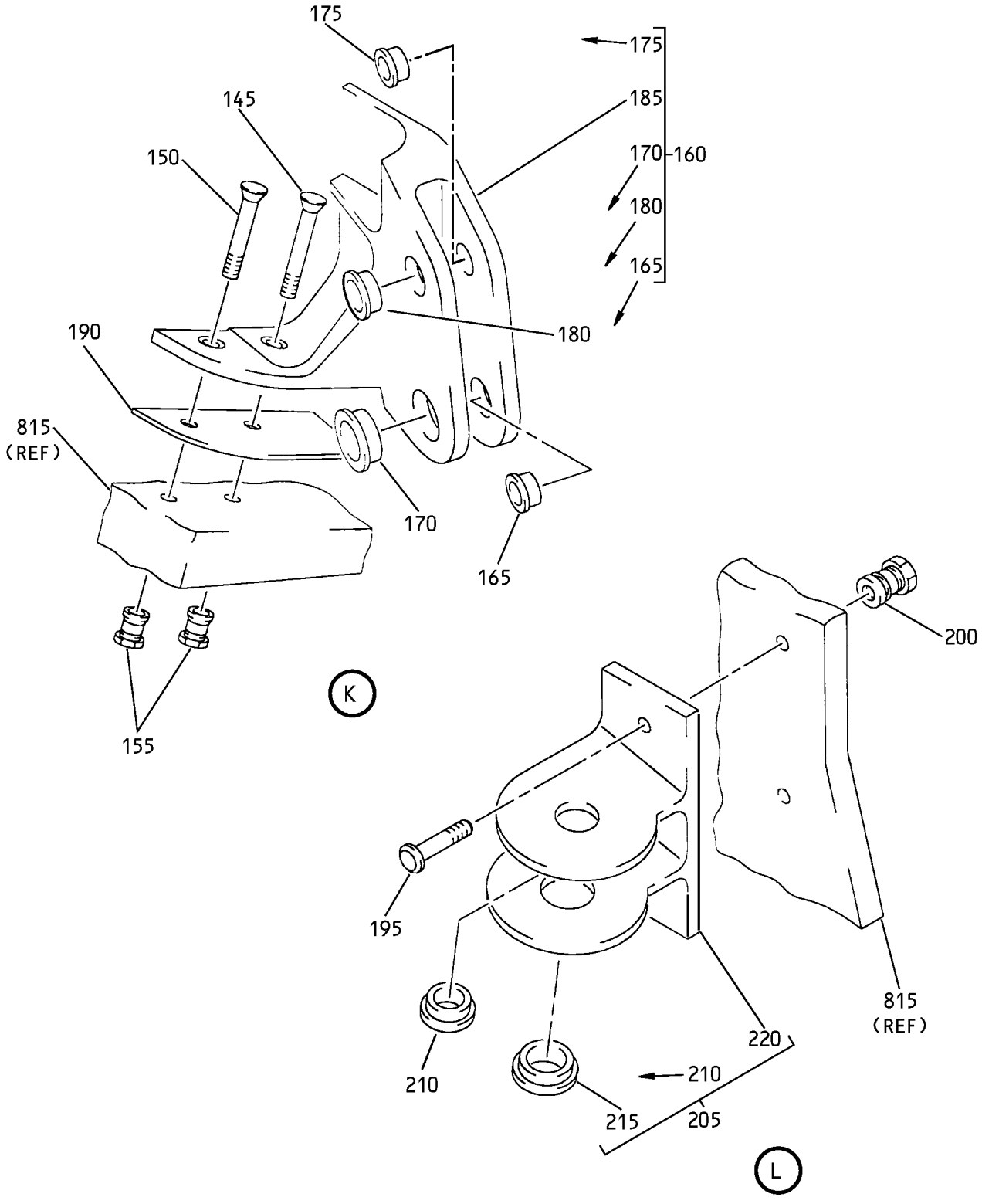
Main Landing Gear Beam Assembly
Figure 2 (Sheet 6)

K24702



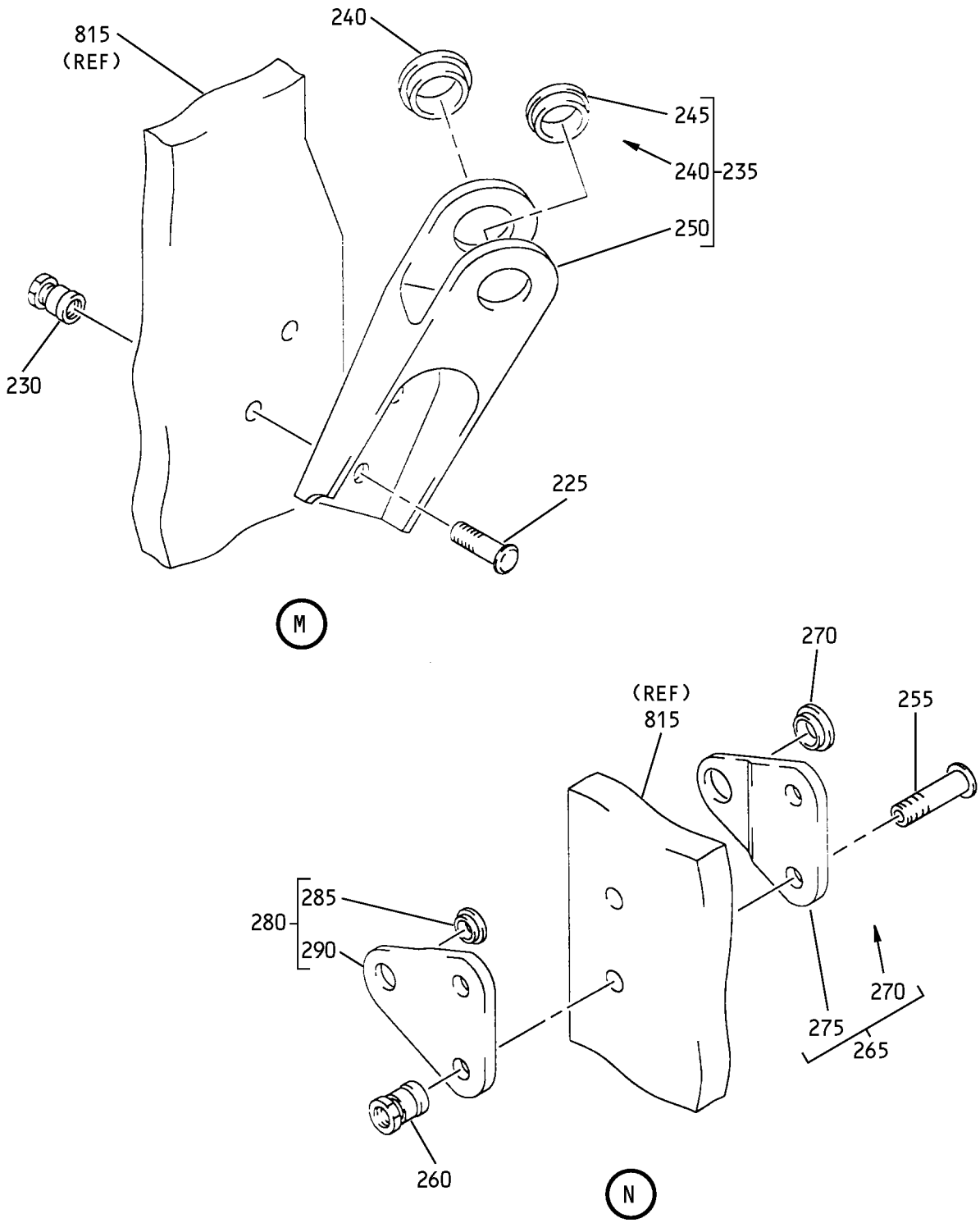
Main Landing Gear Beam Assembly
Figure 2 (Sheet 6)

K24702



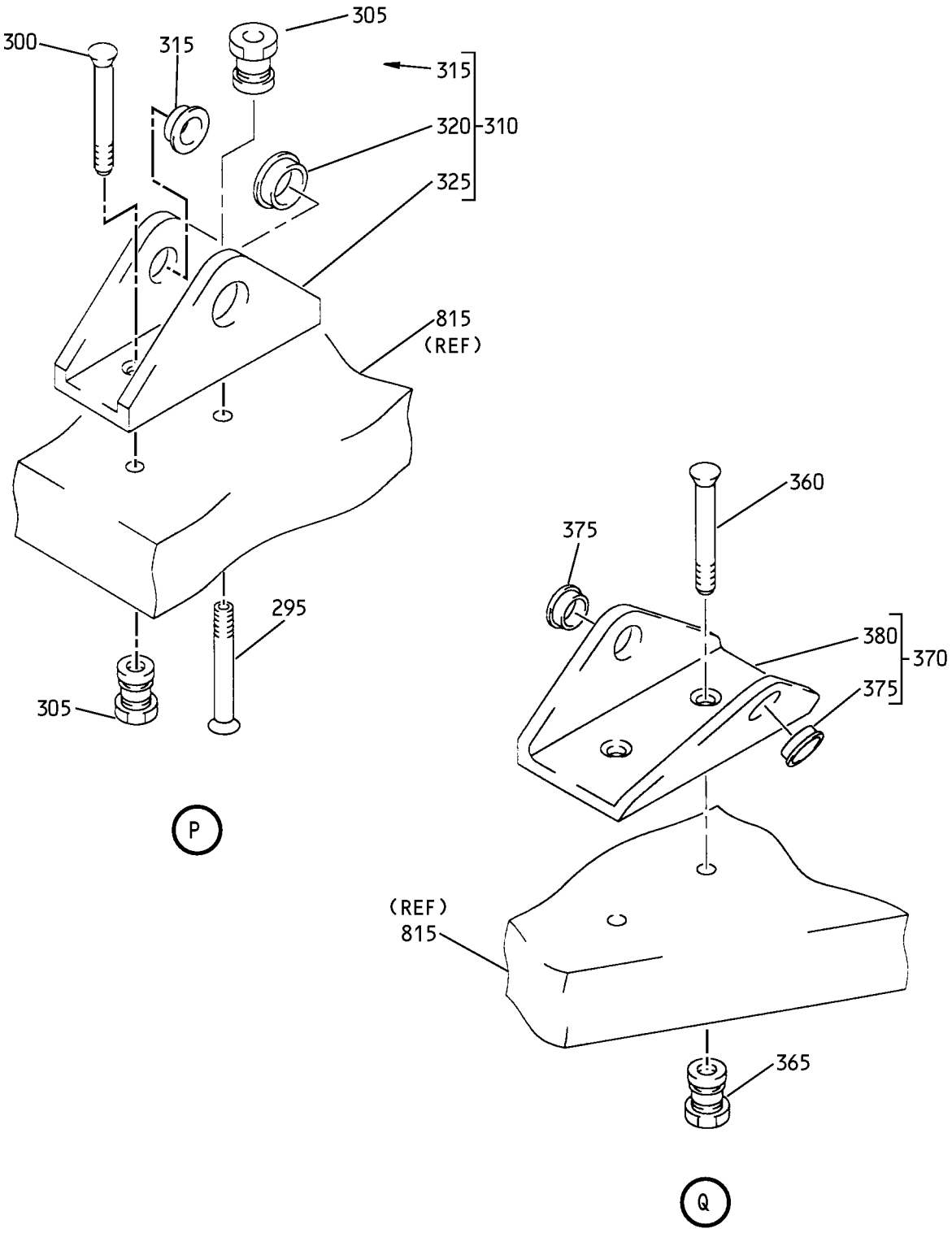
Main Landing Gear Beam Assembly
Figure 2 (Sheet 7)

K24708



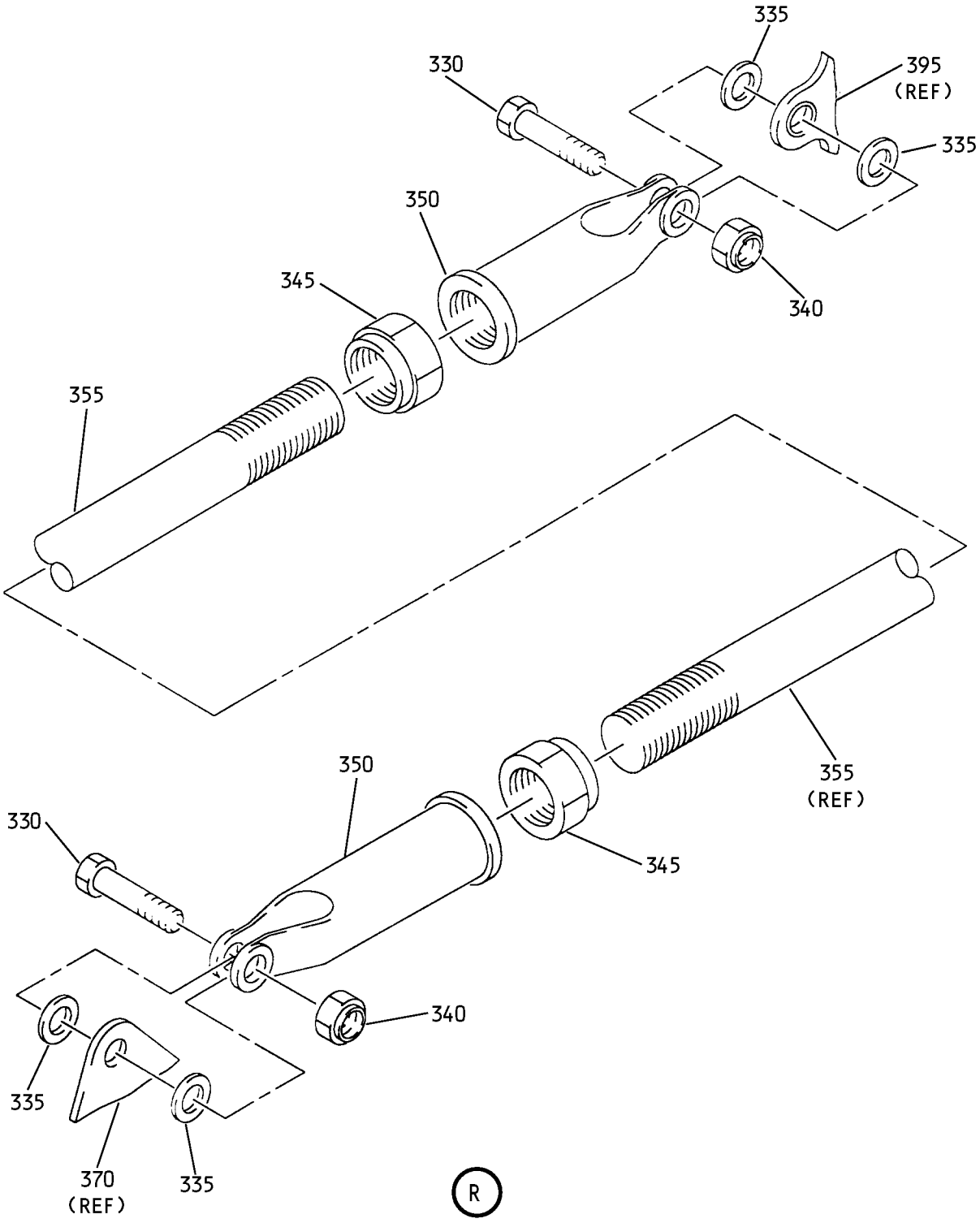
Main Landing Gear Beam Assembly
Figure 2 (Sheet 8)

K24720



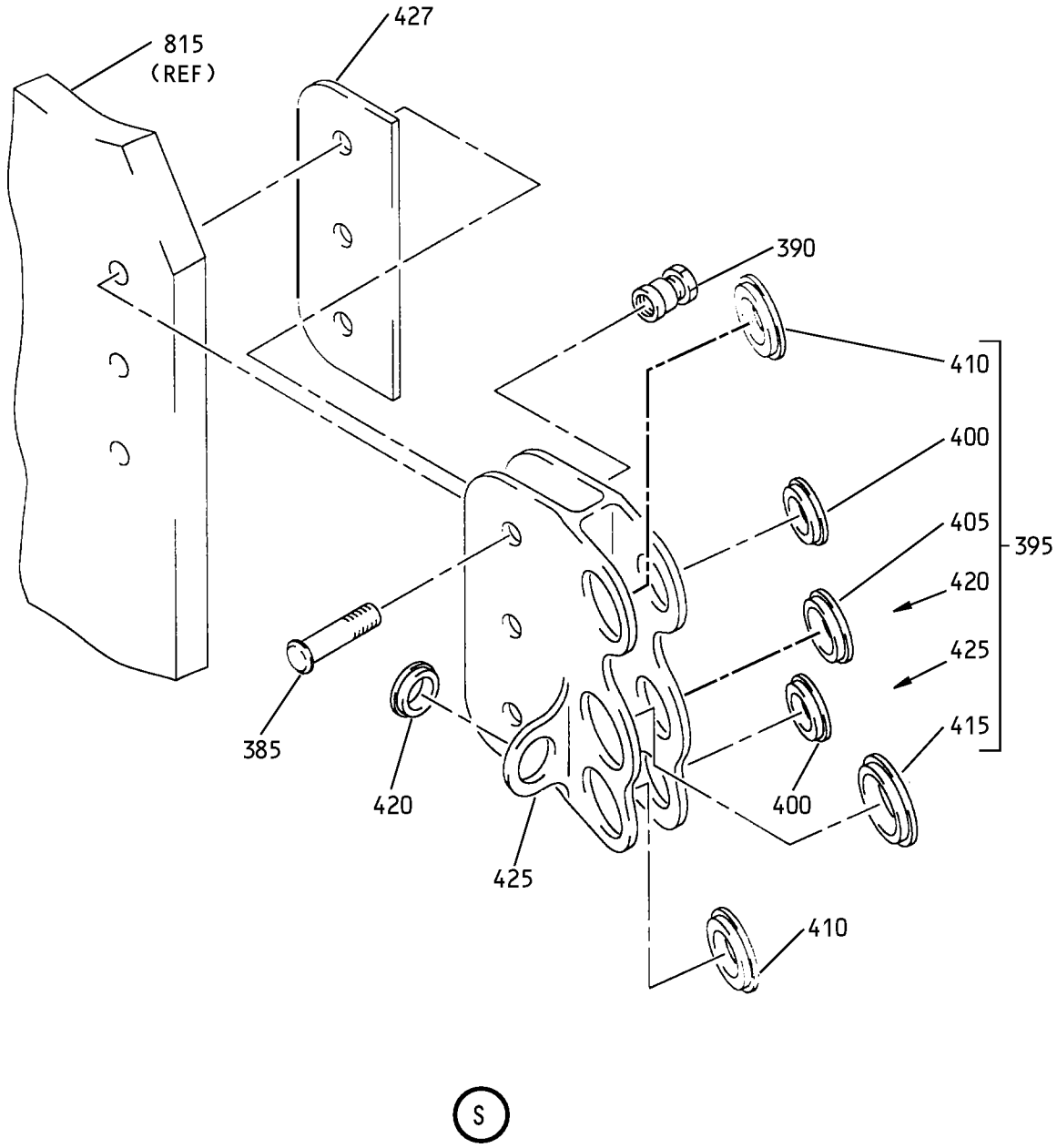
Main Landing Gear Beam Assembly
Figure 2 (Sheet 9)

K24726



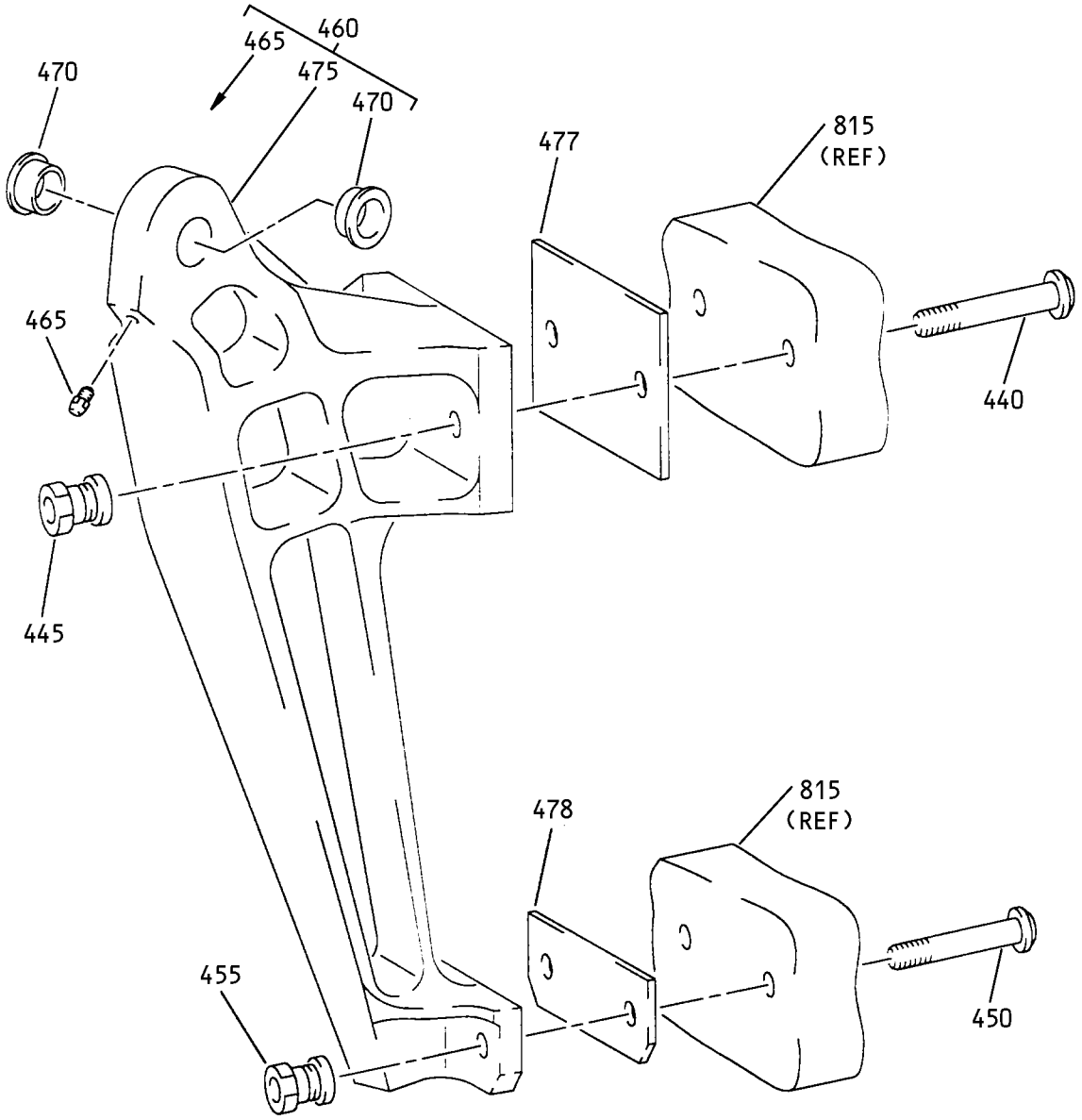
Main Landing Gear Beam Assembly
Figure 2 (Sheet 10)

K24730



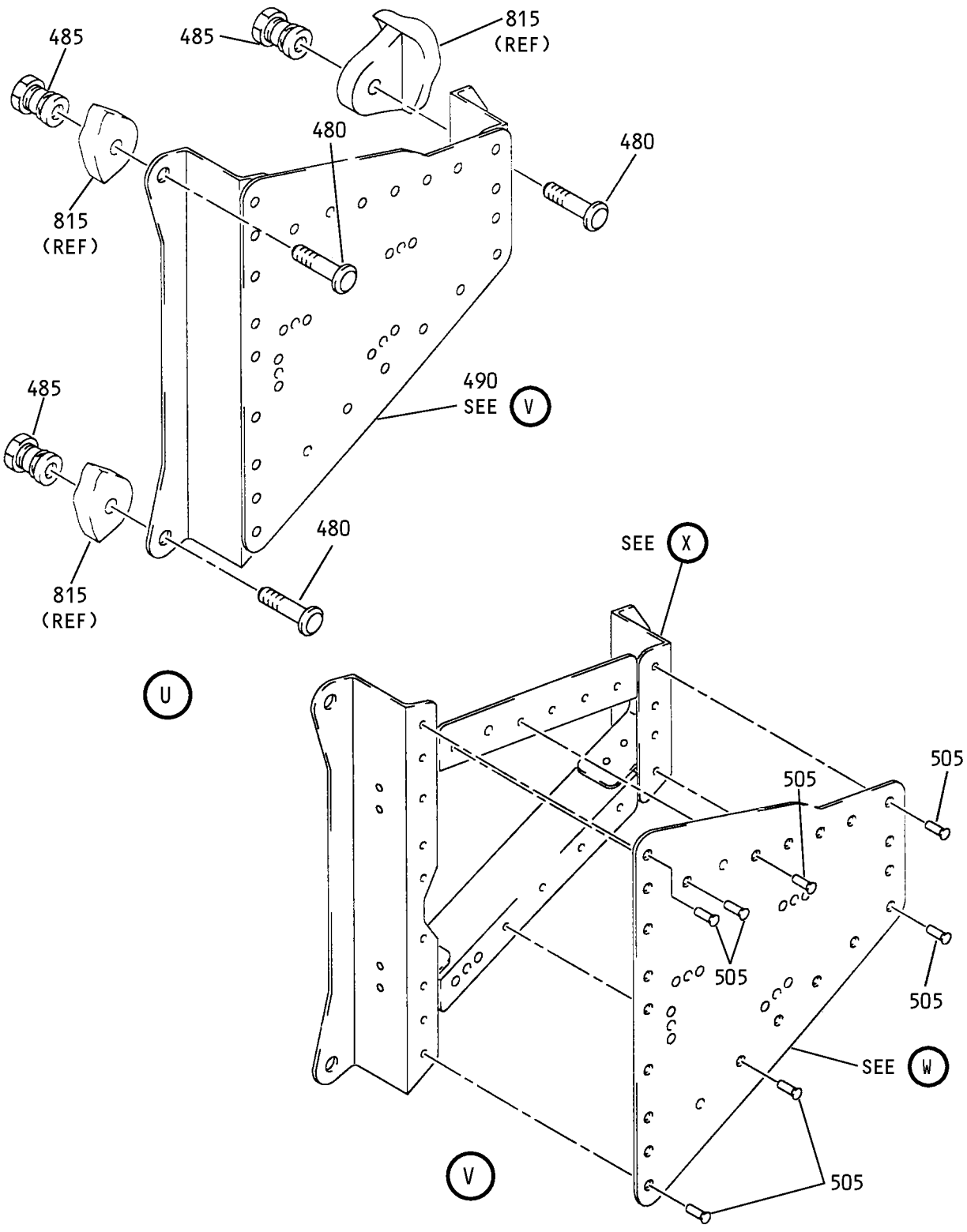
Main Landing Gear Beam Assembly
Figure 2 (Sheet 11)

K24733



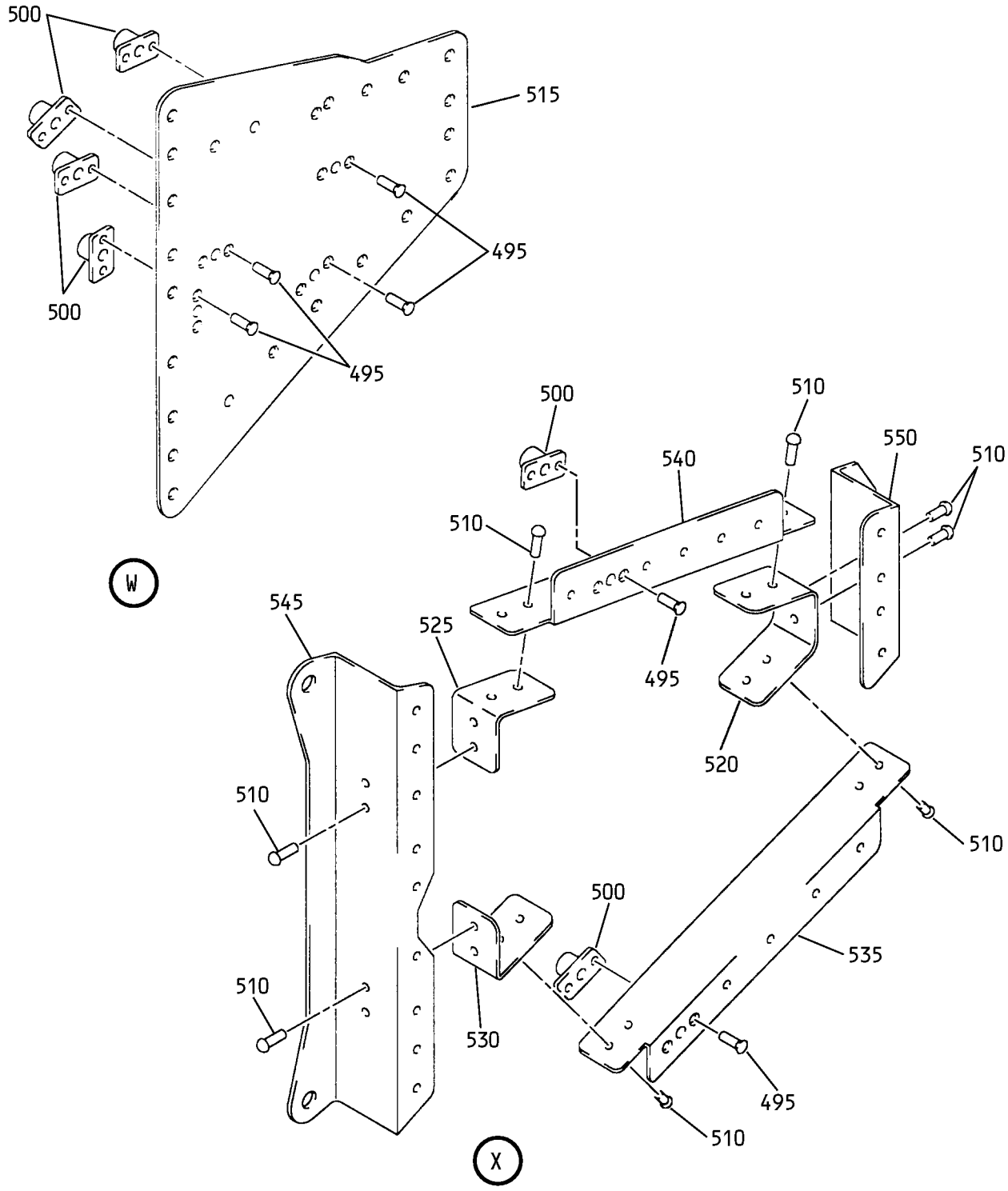
Main Landing Gear Beam Assembly
Figure 2 (Sheet 12)

K24739



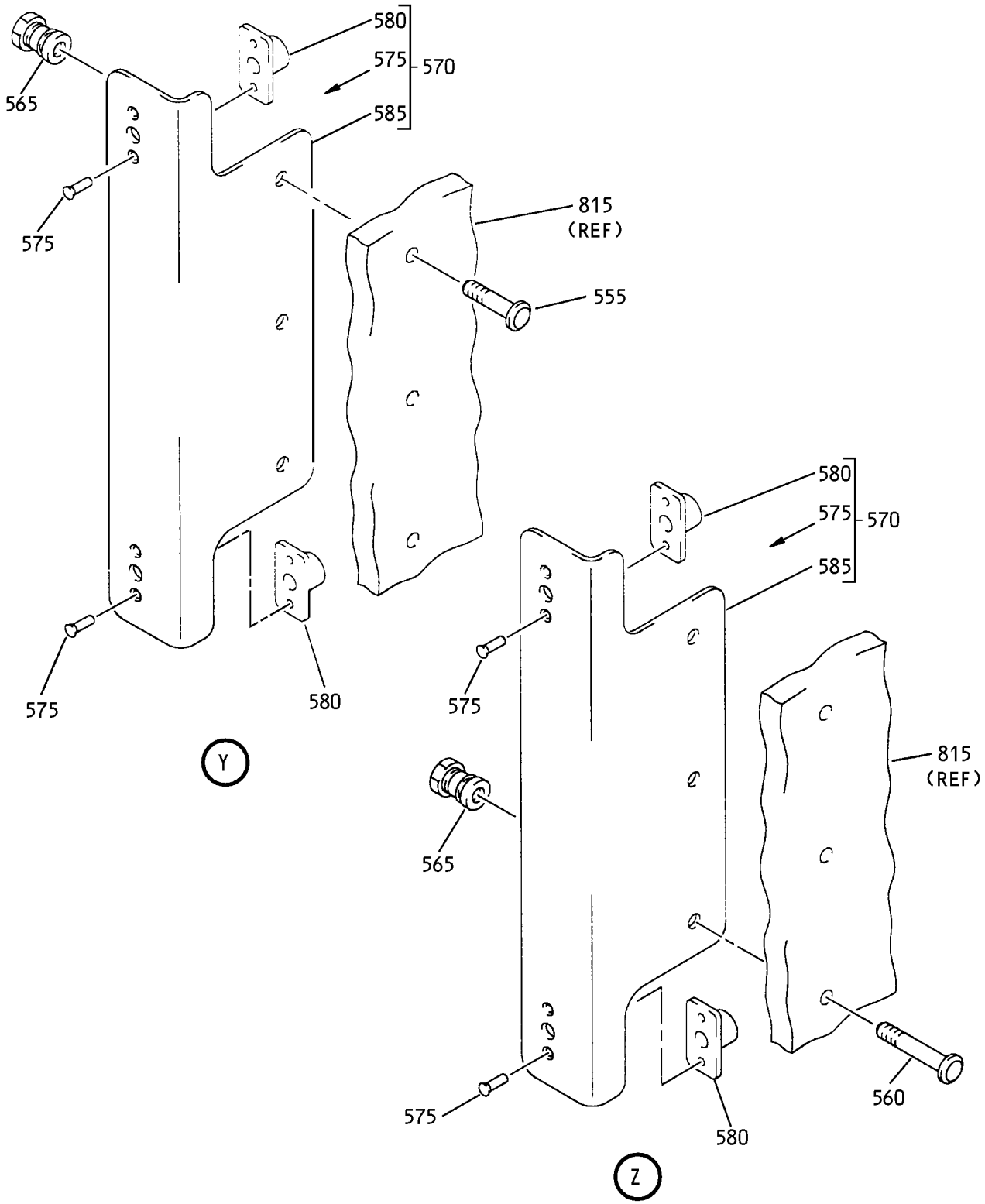
Main Landing Gear Beam Assembly
Figure 2 (Sheet 13)

K24740



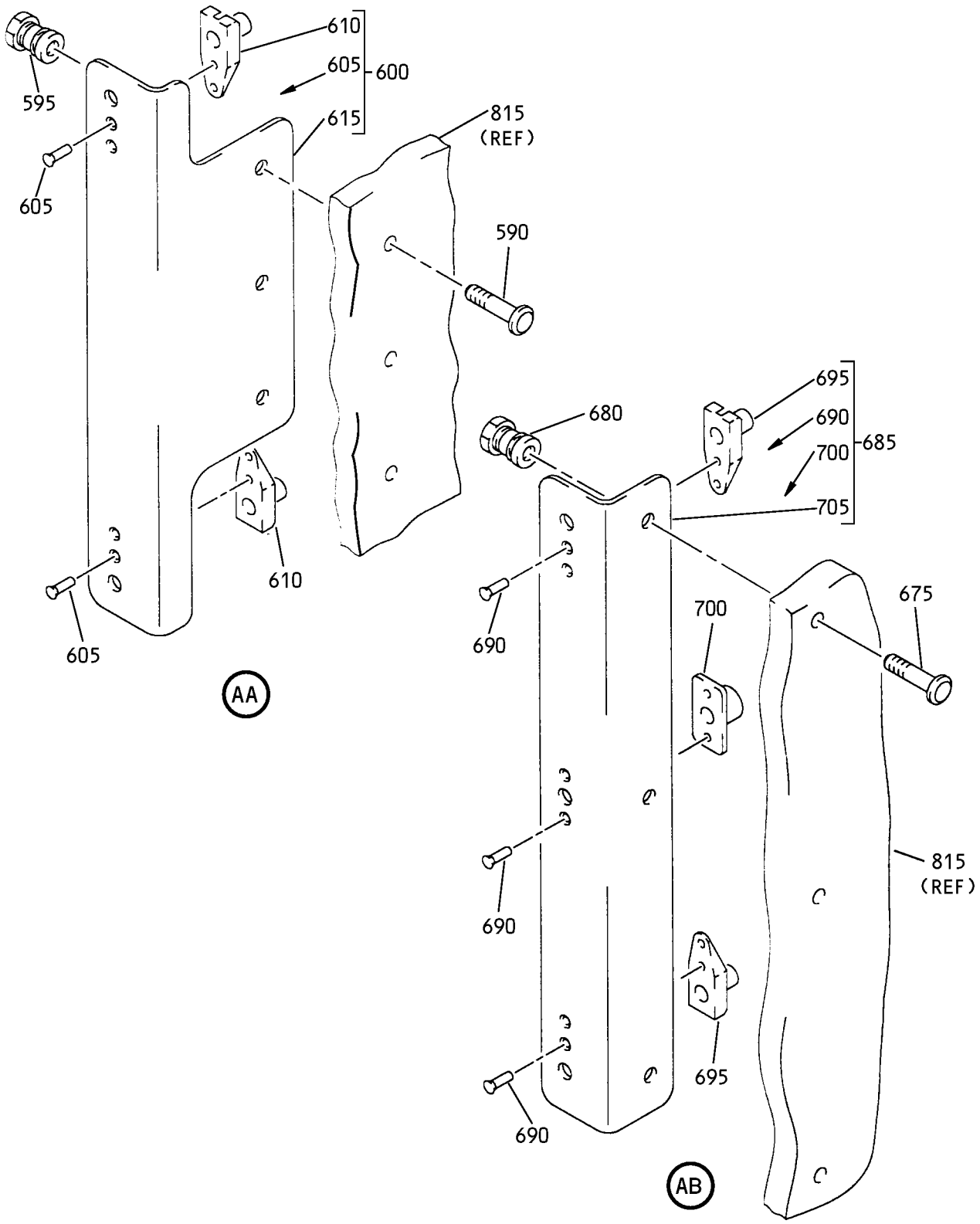
Main Landing Gear Beam Assembly
Figure 2 (Sheet 14)

K24798



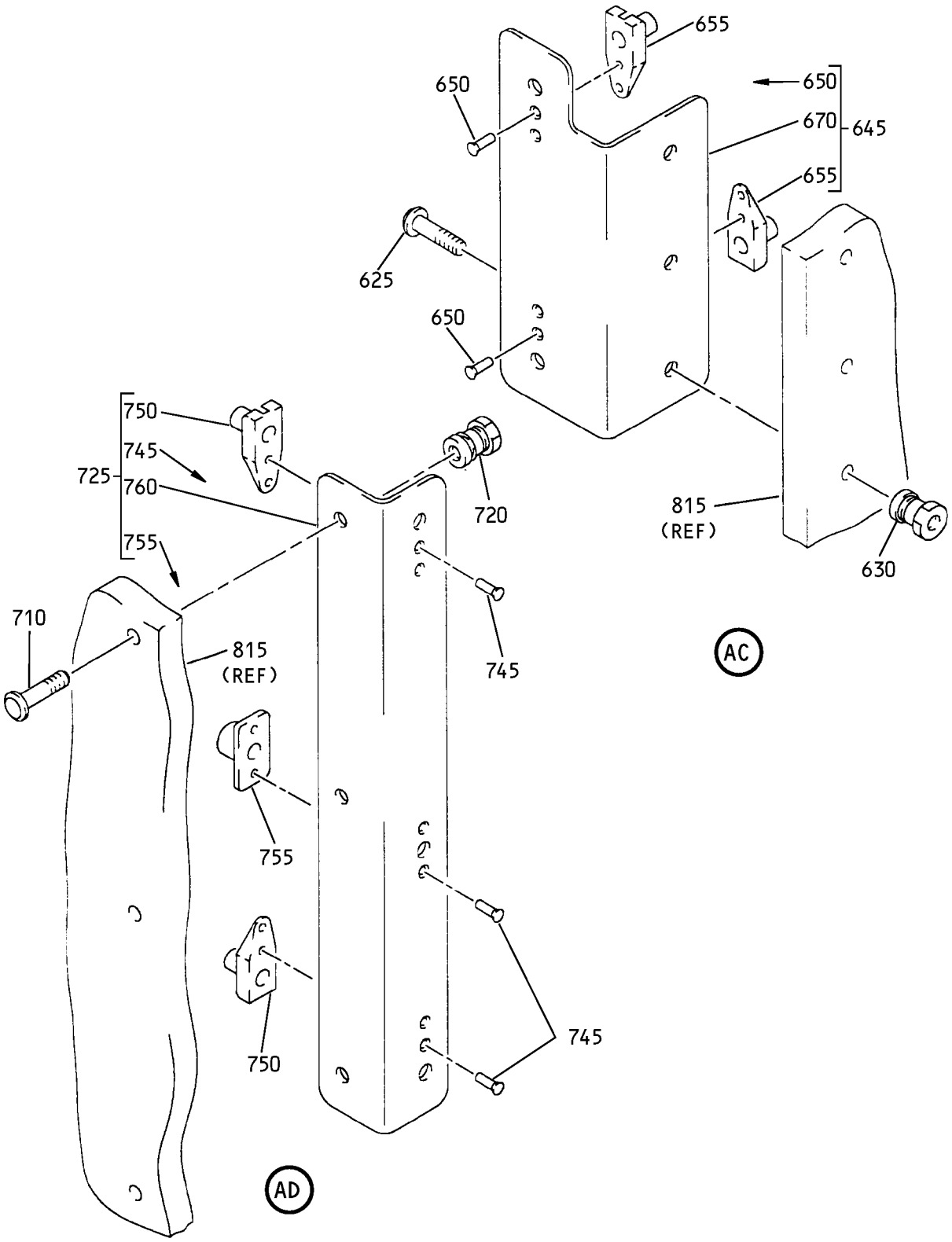
Main Landing Gear Beam Assembly
Figure 2 (Sheet 15)

K24806



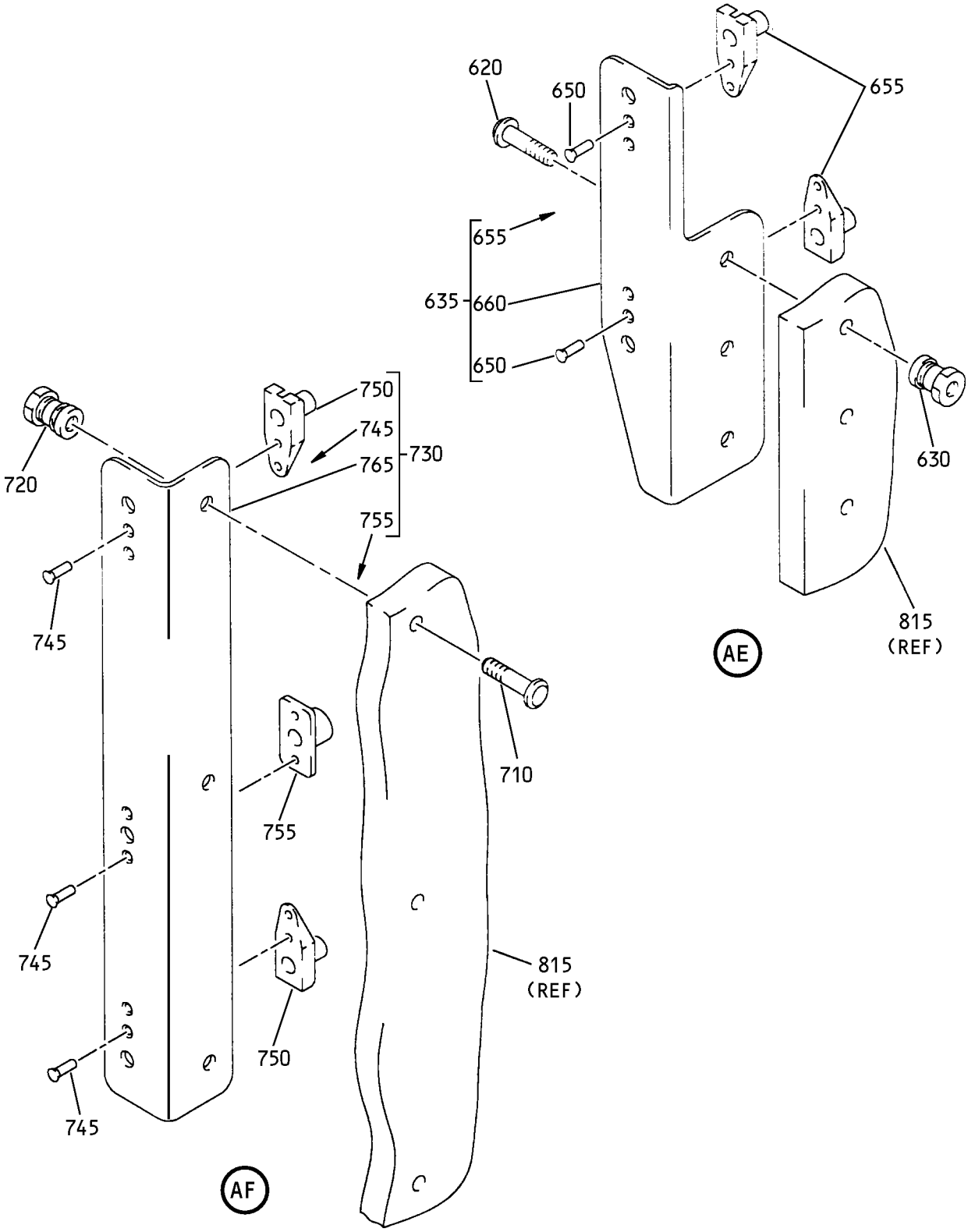
Main Landing Gear Beam Assembly
Figure 2 (Sheet 16)

K24830



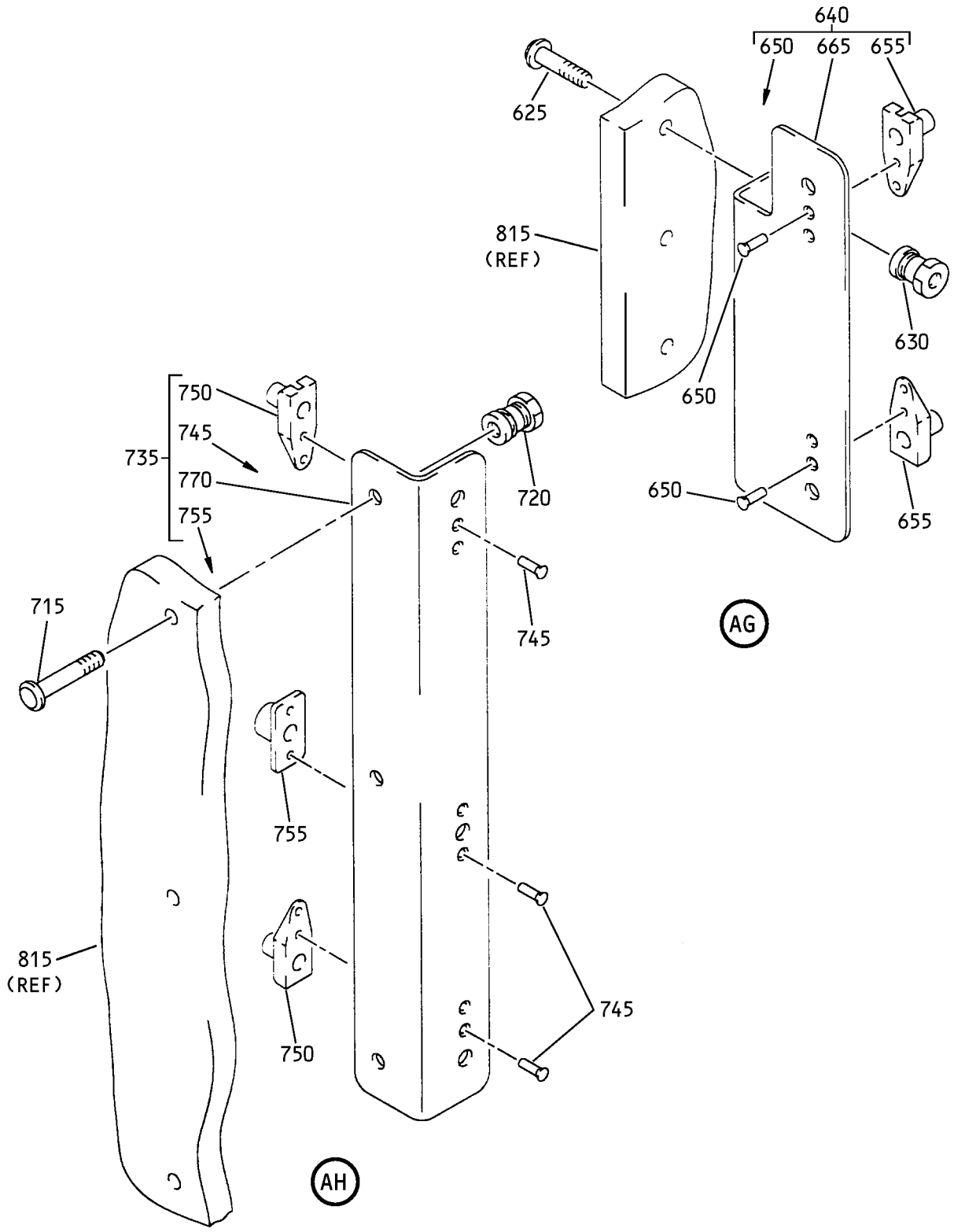
Main Landing Gear Beam Assembly
Figure 2 (Sheet 17)

K24837



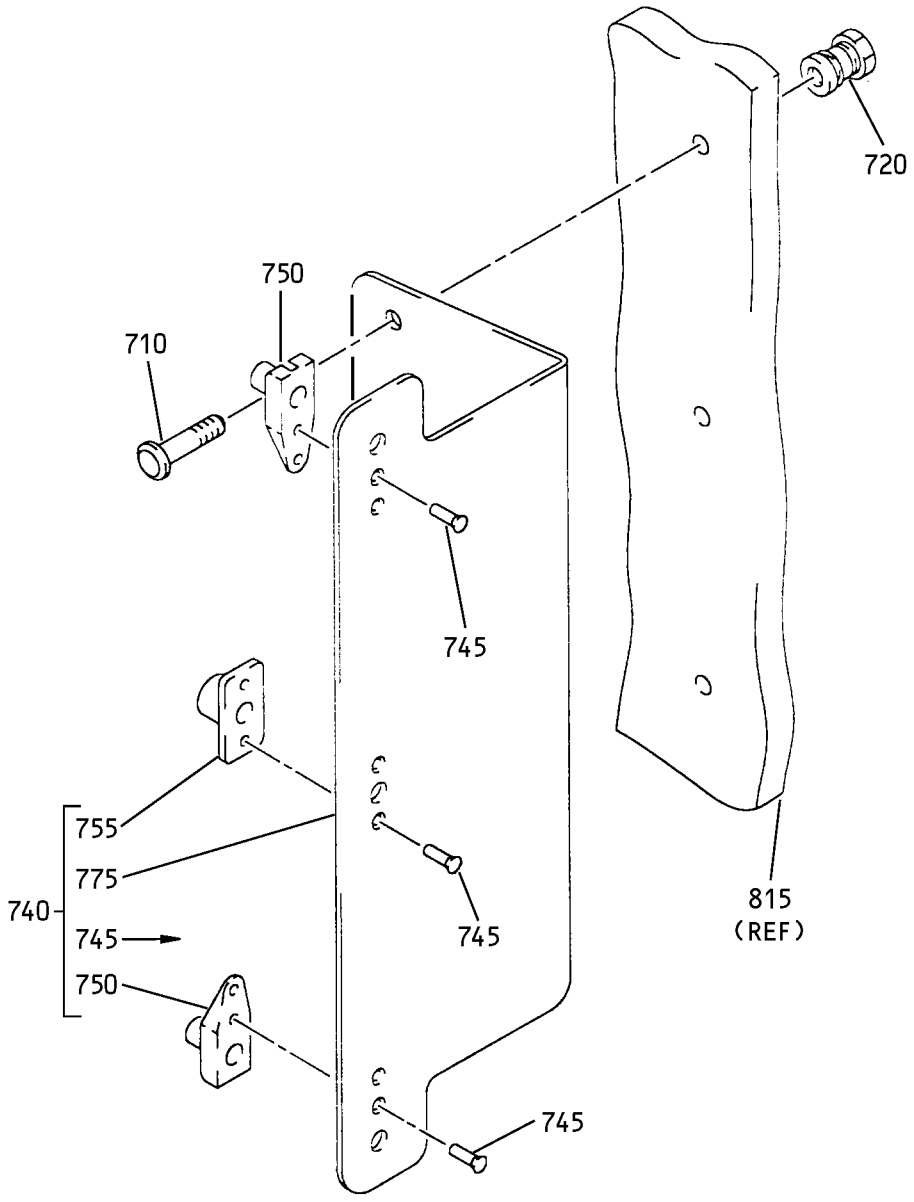
Main Landing Gear Beam Assembly
Figure 2 (Sheet 18)

K24846



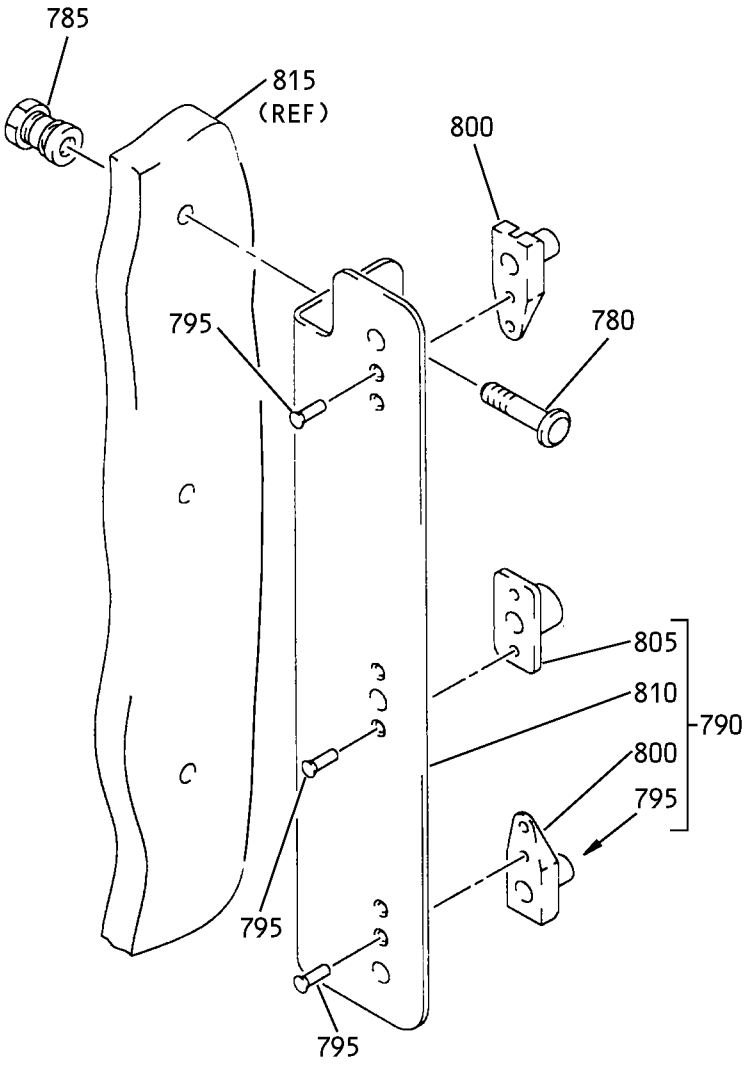
Main Landing Gear Beam Assembly
Figure 2 (Sheet 19)

K24857



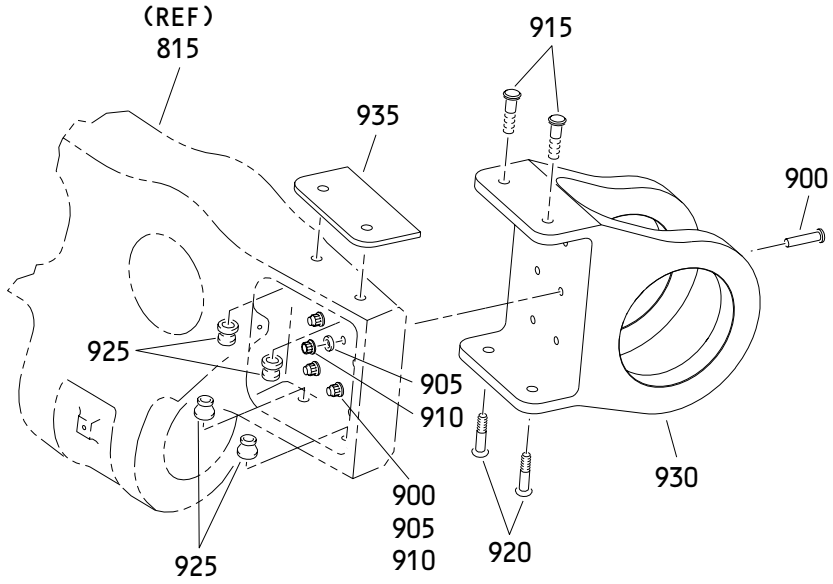
Main Landing Gear Beam Assembly
Figure 2 (Sheet 20)

K24863



Main Landing Gear Beam Assembly
Figure 2 (Sheet 21)

K24868



Main Landing Gear Beam Assembly
Figure 2 (Sheet 22)

K25578

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-					
-1A	113T1116-2		BEAM ASSY-MLG	B	RF
5	MS15001-1		.FITTING	B	3
10	113T1147-1		.BUSHING	B	2
15	113T1147-6		.BUSHING	B	1
20	113T1147-5		.BUSHING	B	1
25	113T1147-3		.BUSHING	B	1
30	113T1147-4		.BUSHING	B	1
35	113T1108-20		.BUSHING	B	2
40	HST10AG8-8		.BOLT- (VOPTK6) (SPEC BACB30VT8K8) (OPT HST10AG8-8 (V06725)) (OPT HST10AG8-8 (V56878)) (OPT HST10AG8-8 (V73197))	B	4
45	HST79CY8		.COLLAR- (V73197) (SPEC BACC30BL8) (OPT HST79-8 (V92215)) (OPT HST79CY8 (V56878)) (OPT HST79CY8 (V5M902))	B	4
50	113T1155-1		.FITTING ASSY-TE PNL SPRT	B	1
55	113T1155-3		.FITTING ASSY-TE PNL SPRT	B	1
60	BACB28AP04P012		..BUSHING	B	1
65	BACB28AT06P012C		DELETED		
65A	BACB28AT06B012C		..BUSHING	B	1
70	113T1155-2		..FITTING- (USED ON ITEM 50)	B	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-					
75	113T1155-4		..FITTING- (USED ON ITEM 55)	B	1
80	HST10AG6-7		.BOLT- (V0PTK6) (SPEC BACB30VT6K7) (OPT HST10AG6-7 (V06725)) (OPT HST10AG6-7 (V56878)) (OPT HST10AG6-7 (V73197))	B	3
85	HST79CY6		.COLLAR- (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V92215)) (OPT HST79CY6 (V56878)) (OPT HST79CY6 (V5M902))	B	3
90	272T1448-1		.BRACKET	B	1
95	BACB30MR6K15		.BOLT	B	1
100	BACB30MR6K16		.BOLT	B	1
105	BACW10BP6CD		.WASHER	B	2
110	BACW10BP6DP		.WASHER	B	2
115	NAS1805-6L		.NUT	B	2
120	BACR15BA8AD7C		.RIVET	B	2
125	113T1158-2		.FITTING ASSY-TE PNL SPRT	B	1
130	BACB28B4-215		..BUSHING	B	1
135	113T1158-4		..FITTING	B	1
140	113T1158-5		.PLATE-SERRATED	B	1
145	BACB30NZ12K25		.BOLT	B	1
150	BACB30NZ12K24		.BOLT	B	1
155	BACC30BU12PW		.COLLAR	B	2
160	113T1156-2		.FITTING ASSY-TE PNL SPRT	B	1
165	BACB28AP06P028		..BUSHING	B	1
170	BACB28AT09B028C		..BUSHING	B	1
175	BACB28AP04P028		..BUSHING	B	1
180	BACB28AT06B028C		..BUSHING	B	1
185	113T1156-4		..FITTING	B	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-					
190	BACS40R016C031F		.SHIM	B	1
195	HST10AG10-10		.BOLT- (V0PTK6) (SPEC BACB30VT10K10) (OPT HST10AG10-10 (V06725)) (OPT HST10AG10-10 (V56878)) (OPT HST10AG10-10 (V73197))	B	2
200	HST79CY10		.COLLAR- (V73197) (SPEC BACC30BL10) (OPT HST79-10 (V92215)) (OPT HST79CY10 (V56878)) (OPT HST79CY10 (V5M902))	B	2
205	113T1005-8		.FITTING ASSY-SIDE BRACE	B	1
210	BACB28AP04P014		..BUSHING	B	1
215	BACB28AM06B015A		..BUSHING	B	1
220	113T1005-10		..FITTING	B	1
225	HST10AG10-8		.BOLT- (V0PTK6) (SPEC BACB30VT10K8) (OPT HST10AG10-8 (V06725)) (OPT HST10AG10-8 (V56878)) (OPT HST10AG10-8 (V73197))	B	2

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-					
230	HST79CY10		.COLLAR- (V73197) (SPEC BACC30BL10) (OPT HST79-10 (V92215)) (OPT HST79CY10 (V56878)) (OPT HST79CY10 (V5M902))	B	2
235	113T1157-2		.FITTING ASSY-TE PNL SPRT	B	1
240	BACB28AT09B015C		..BUSHING	B	1
245	BACB28AP06P016		..BUSHING	B	1
250	113T1157-4		..FITTING	B	1
255	HST10AG8-11		.BOLT- (V0PTK6) (SPEC BACB30VT8K11) (OPT HST10AG8-11 (V06725)) (OPT HST10AG8-11 (V56878)) (OPT HST10AG8-11 (V73197))	B	8
260	HST79CY8		.COLLAR- (V73197) (SPEC BACC30BL8) (OPT HST79-8 (V92215)) (OPT HST79CY8 (V56878)) (OPT HST79CY8 (V5M902))	B	8
265	113T1126-7		.FITTING ASSY	B	4
270	BACB28AM06B010A		..BUSHING	B	1
275	113T1126-9		..FITTING	B	1
280	113T1126-8		.FITTING ASSY	B	4
285	BACB28AP04P010		..BUSHING	B	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-					
290	113T1126-10		..FITTING	B	1
295	L804-8K26		.BOLT- (V06725) (SPEC BACB30NZ8K26) (OPT HL523AZ8-26 (V56878)) (OPT HL523AZ8-26 (V73197)) (OPT HL523AZ8-26 (V92215)) (OPT HL523AZ8-26 (V97928)) (OPT HL523AZ8-26 (VOPTK6)) (OPT HL523AZ8-26 (V60516)) (OPT HL523AZ8-26 (V06725))	B	1
300	HL523AZ8-24		.BOLT- (V73197) (SPEC BACB30NZ8K24) (OPT L804-8K24 (V06725)) (OPT HL523AZ8-24 (V56878)) (OPT HL523AZ8-24 (V92215)) (OPT HL523AZ8-24 (V97928)) (OPT HL523AZ8-24 (VOPTK6)) (OPT HL523AZ8-24 (V60516)) (OPT HL523AZ8-24 (V06725))	B	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-					
305	HL97KG8		.COLLAR- (V5M902) (SPEC BACC30AB8C) (OPT HL97PB8 (V5M902)) (OPT HL97PB8 (V56878)) (OPT HL97KG8 (V73197)) (OPT HL97KG8 (V56878)) (OPT HL97PB8 (V73197))	B	2
310	113T1126-22		.FITTING ASSY	B	1
315	BACB28AP05P013		..BUSHING	B	1
320	BACB28AM07B014A		..BUSHING	B	1
325	113T1126-24		..FITTING	B	1
330	NAS6704-9		.BOLT	B	2
335	NAS1149E0432P		.WASHER	B	4
340	BACN10JC4CD		.NUT	B	2
345	BACN10JC5CD		.NUT	B	2
350	NAS170-1		.ROD END	B	2
355	NAS354-5-475		.TIE ROD	B	1
360	BACB30NZ10K24		.BOLT	B	2
365	HL97KG10		.COLLAR- (V5M902) (SPEC BACC30AB10C) (OPT HL97PB10 (V5M902)) (OPT HL97PB10 (V56878)) (OPT HL97KG10 (V73197)) (OPT HL97KG10 (V56878)) (OPT HL97PB10 (V73197))	B	2

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-					
370	113T1122-1		.FITTING ASSY	B	1
375	BACB28AM04B013A		..BUSHING	B	2
380	113T1122-2		..FITTING	B	1
385	HST10AG8-12		.BOLT- (VOPTK6) (SPEC BACB30VT8K12) (OPT HST10AG8-12 (V06725)) (OPT HST10AG8-12 (V56878)) (OPT HST10AG8-12 (V73197))	B	3
390	HST79CY8		.COLLAR- (V73197) (SPEC BACC30BL8) (OPT HST79-8 (V92215)) (OPT HST79CY8 (V56878)) (OPT HST79CY8 (V5M902))	B	3
395	113T1123-6		.FITTING ASSY	B	1
400	BACB28AM06B016A		..BUSHING	B	2
405	BACB28AM07B016A		..BUSHING	B	1
410	BACB28AP04P016		..BUSHING	B	2
415	BACB28AP05P016		..BUSHING	B	1
420	BACB28AM04B013A		..BUSHING	B	1
425	113T1123-8		..FITTING	B	1
427	BACS40R010C036		.SHIM	B	1
430	BACB28AX04C053		.BUSHING	B	4
435	BACB28AT06B048C		.BUSHING	B	4

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02- 440	HL12VAZ16-32		.BOLT- (V56878) (SPEC BACB30NX16K32) (OPT HL12VAZ16-32 (V73197)) (OPT HL12VAZ16-32 (V92215)) (OPT HL12VAZ16-32 (V97928)) (OPT L802-16K32 (V06725)) (OPT HL12-32 (V06725)) (OPT HL12VAZ16-32 (V97928))	B	2
445	HL1187-16		.COLLAR- (V73197) (SPEC BACC30X16) (OPT HL87-16 (V92215)) (OPT HL87-16 (V73197)) (OPT HL1187-16 (V56878)) (OPT HL1187-16 (V92215)) (OPT HL87-16 (V56878)) (OPT HL1187-16 (V5M902))	B	2

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-					
450	HL12VAZ12-17		.BOLT- (V56878) (SPEC BACB30NX12K17) (OPT HL12VAZ12-17 (V73197)) (OPT HL12VAZ12-17 (V92215)) (OPT HL12VAZ12-17 (V97928)) (OPT L802-12K17 (V06725)) (OPT HL12VAZ12-17 (VOPTK6)) (OPT HL12VAZ12-17 (V60516))	B	2
455	HL1087-12		.COLLAR- (V56878) (SPEC BACC30BH12) (OPT HL1087-12 (V92215)) (OPT HL1087-12 (V73197)) (OPT HL1087-12 (V9N513))	B	2
460	113T1160-2		.FITTING ASSY-ATTACH	B	1
465	MS15001-1		..FITTING	B	1
470	BACB28AT10B029C		..BUSHING	B	2
475	113T1160-4		..FITTING	B	1
477	BACS40R029C051F		.SHIM	B	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-					
478	BACS40R017C047F		.SHIM	B	1
480	HL12VAZ12-21		.BOLT-	B	3
			(V56878)		
			(SPEC BACB30NX12K21)		
			(OPT HL12VAZ12-21 (V73197))		
			(OPT HL12VAZ12-21 (V92215))		
			(OPT HL12VAZ12-21 (V97928))		
			(OPT L802-12K21 (V06725))		
			(OPT HL12VAZ12-21 (V0PTK6))		
			(OPT HL12VAZ12-21 (V60516))		
485	HL1087-12		.COLLAR-	B	3
			(V56878)		
			(SPEC BACC30BH12)		
			(OPT HL1087-12 (V92215))		
			(OPT HL1087-12 (V73197))		
			(OPT HL1087-12 (V9N513))		
490	273T1559-2		.BRACKET ASSY-FUSE	B	1
495	BACR15BA3AD		..RIVET-	B	12
			(SIZE DETERMINE ON INST)		
500	BRFM20A4		..NUTPLATE-	B	6
			(V52828)		
			(SPEC BACN10JN4)		
			(OPT MF53049-4 (V15653))		
			(OPT MF1000-4BAC (V15653))		
			(OPT NS103218-048 (V80539))		
			(OPT RMF9201M4 (V72962))		
			(OPT VN252A048 (V92215))		
			(OPT T8124S4S (V11815))		

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-					
505	BACR15BA5AD		..RIVET- (SIZE DETERMINE ON INST)	B	22
510	BACR15BB5AD		..RIVET- (SIZE DETERMINE ON INST)	B	14
515	273T1559-3		..BRACKET	B	1
520	273T1559-4		..BRACKET	B	1
525	273T1559-5		..BRACKET	B	1
530	273T1559-6		..BRACKET	B	1
535	273T1559-8		..BRACKET	B	1
540	273T1559-10		..BRACKET	B	1
545	273T1559-12		..BRACKET	B	1
550	273T1559-14		..BRACKET	B	1
555	HST10AG6-6		.BOLT- (VOPTK6) (SPEC BACB30VT6K6) (OPT HST10AG6-6 (V06725)) (OPT HST10AG6-6 (V56878)) (OPT HST10AG6-6 (V73197))	B	15
560	HST10AG6-9		.BOLT- (VOPTK6) (SPEC BACB30VT6K9) (OPT HST10AG6-9 (V06725)) (OPT HST10AG6-9 (V56878)) (OPT HST10AG6-9 (V73197))	B	3
565	HST79CY6		.COLLAR- (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V92215)) (OPT HST79CY6 (V56878)) (OPT HST79CY6 (V5M902))	B	18

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-					
570	272T1448-3		.BRACKET ASSY-SPRT	B	6
575	BACR15BA3AD		..RIVET-	B	4
			(SIZE DETERMINE ON INST)		
580	BRFM20A3		..NUTPLATE-	B	2
			(V52828)		
			(SPEC BACN10JN3)		
			(OPT MF1000-3BAC (V15653))		
			(OPT NS103218-02 (V80539))		
			(OPT RMF9201M3 (V72962))		
			(OPT VN252A02 (V92215))		
			(OPT MF53049-3 (V15653))		
			(OPT T8124S3S (V11815))		
585	272T1448-2		..BRACKET	B	1
590	HST10AG6-6		.BOLT-	B	3
			(VOPTK6)		
			(SPEC BACB30VT6K6)		
			(OPT HST10AG6-6 (V06725))		
			(OPT HST10AG6-6 (V56878))		
			(OPT HST10AG6-6 (V73197))		
595	HST79CY6		.COLLAR-	B	3
			(V73197)		
			(SPEC BACC30BL6)		
			(OPT HST79-6 (V92215))		
			(OPT HST79CY6 (V56878))		
			(OPT HST79CY6 (V5M902))		

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-					
600	272T1448-5		.BRACKET ASSY-SPRT	B	1
605	BACR15BA3AD		..RIVET- (SIZE DETERMINE ON INST)	B	4
610	BRF100A3		..NUTPLATE- (V52828) (SPEC BACN10KB3F) (OPT NS103185-02 (V80539)) (OPT RMF9207-3 (V72962)) (OPT T8114S1032S (V11815)) (OPT VN151A1-02 (V92215)) (OPT F2000-3 (V15653))	B	2
615	272T1448-4		..BRACKET	B	1
620	HST10AG6-8		.BOLT- (VOPTK6) (SPEC BACB30VT6K8) (OPT HST10AG6-8 (V06725)) (OPT HST10AG6-8 (V56878)) (OPT HST10AG6-8 (V73197))	B	3
625	HST10AG6-6		.BOLT- (VOPTK6) (SPEC BACB30VT6K6) (OPT HST10AG6-6 (V06725)) (OPT HST10AG6-6 (V56878)) (OPT HST10AG6-6 (V73197))	B	6

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-					
630	HST79CY6		.COLLAR- (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V92215)) (OPT HST79CY6 (V56878)) (OPT HST79CY6 (V5M902))	B	9
635	272T1450-32		.BRACKET ASSY-SPRT	B	1
640	272T1450-28		.BRACKET ASSY-SPRT	B	1
645	272T1450-12		.BRACKET ASSY-SPRT	B	1
650	BACR15BA3AD		..RIVET- (SIZE DETERMINE ON INST)	B	4
655	BRF100A3		..NUTPLATE- (V52828) (SPEC BACN10KB3F) (OPT NS103185-02 (V80539)) (OPT RMF9207-3 (V72962)) (OPT T8114S1032S (V11815)) (OPT VN151A1-02 (V92215)) (OPT F2000-3 (V15653))	B	2
660	272T1450-30		..BRACKET- (USED ON ITEM 635)	B	1
665	272T1450-26		..BRACKET- (USED ON ITEM 640)	B	1
670	272T1450-10		..BRACKET- (USED ON ITEM 645)	B	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-					
675	HST10AG6-6		.BOLT- (V0PTK6) (SPEC BACB30VT6K6) (OPT HST10AG6-6 (V06725)) (OPT HST10AG6-6 (V56878)) (OPT HST10AG6-6 (V73197))	B	3
680	HST79CY6		.COLLAR- (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V92215)) (OPT HST79CY6 (V56878)) (OPT HST79CY6 (V5M902))	B	3
685	272T1450-24		.BRACKET ASSY-SPRT	B	1
690	BACR15BA3AD		..RIVET- (SIZE DETERMINE ON INST)	B	6
695	BRF100A3		..NUTPLATE- (V52828) (SPEC BACN10KB3F) (OPT NS103185-02 (V80539)) (OPT RMF9207-3 (V72962)) (OPT T8114S1032S (V11815)) (OPT VN151A1-02 (V92215)) (OPT F2000-3 (V15653))	B	2

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-					
700	BRFM20A3		..NUTPLATE- (V52828) (SPEC BACN10JN3) (OPT MF1000-3BAC (V15653)) (OPT NS103218-02 (V80539)) (OPT RMF9201M3 (V72962)) (OPT VN252A02 (V92215)) (OPT MF53049-3 (V15653)) (OPT T8124S3S (V11815))	B	1
705	272T1450-22		..BRACKET	B	1
710	HST10AG6-6		.BOLT- (VOPTK6) (SPEC BACB30VT6K6) (OPT HST10AG6-6 (V06725)) (OPT HST10AG6-6 (V56878)) (OPT HST10AG6-6 (V73197))	B	12
715	HST10AG6-9		.BOLT- (VOPTK6) (SPEC BACB30VT6K9) (OPT HST10AG6-9 (V06725)) (OPT HST10AG6-9 (V56878)) (OPT HST10AG6-9 (V73197))	B	3

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-					
720	HST79CY6		.COLLAR- (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V92215)) (OPT HST79CY6 (V56878)) (OPT HST79CY6 (V5M902))	B	15
725	272T1450-4		.BRACKET ASSY-SPRT	B	2
730	272T1450-48		.BRACKET ASSY-SPRT	B	1
735	272T1450-40		.BRACKET ASSY-SPRT	B	1
740	272T1450-38		.BRACKET ASSY-SPRT	B	1
745	BACR15BA3AD		..RIVET- (SIZE DETERMINE ON INST)	B	6
750	BRF100A3		..NUTPLATE- (V52828) (SPEC BACN10KB3F) (OPT NS103185-02 (V80539)) (OPT RMF9207-3 (V72962)) (OPT T8114S1032S (V11815)) (OPT VN151A1-02 (V92215)) (OPT F2000-3 (V15653))	B	2
755	BRFM20C3D		..NUTPLATE- (V52828) (SPEC BACN10JN3CD) (OPT 102F9201M3 (V72962)) (OPT NS202487-02 (V80539)) (OPT MF51637-3 (V15653)) (OPT MF53050-3CD (V15653))	B	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-					
760	272T1450-2		..BRACKET- (USED ON ITEM 725)	B	1
765	272T1450-47		..BRACKET- (USED ON ITEM 730)	B	1
770	272T1450-39		..BRACKET- (USED ON ITEM 735)	B	1
775	272T1450-37		..BRACKET- (USED ON ITEM 740)	B	1
780	HST10AG6-9		.BOLT- (VOPTK6) (SPEC BACB30VT6K9) (OPT HST10AG6-9 (V06725)) (OPT HST10AG6-9 (V56878)) (OPT HST10AG6-9 (V73197))	B	3
785	HST79CY6		.COLLAR- (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V92215)) (OPT HST79CY6 (V56878)) (OPT HST79CY6 (V5M902))	B	3
790	272T1450-8		.BRACKET ASSY-SPRT	B	1
795	BACR15BA3AD		..RIVET- (SIZE DETERMINE ON INST)	B	6
800	BRF100A3		..NUTPLATE- (V52828) (SPEC BACN10KB3F) (OPT NS103185-02 (V80539)) (OPT RMF9207-3 (V72962)) (OPT T8114S1032S (V11815)) (OPT VN151A1-02 (V92215)) (OPT F2000-3 (V15653))	B	2

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-					
805	H10-3BAC		..NUT-	B	1
			(V15653)		
			(SPEC BACN10JC3)		
			(OPT NS202101-02		
			(V80539))		
			(OPT RMLH9075-3W		
			(V72962))		
			(OPT VN303A02		
			(V92215))		
			(OPT 96-02		
			(V80539))		
			(OPT BRH10A3		
			(V52828))		
			(OPT T6S1032J		
			(V11815))		
810	272T1450-6		..BRACKET	B	1
815	113T1117-2		.BEAM	B	1
			INSTALLATION PARTS		
900	BACB30NX12K17		BOLT	B	6
905	BACW10BP12DP		WASHER	B	6
910	NAS1805-12		NUT	B	6
915	BACB30MY16K17		BOLT	B	2
920	BACB30MY16K21		BOLT	B	2
925	BACC30AB16C		COLLAR	B	4
930	113T1138-1		SUPPORT FITTING	B	1
935	BACS40RO22C063F		SHIM	B	1

- Item Not Illustrated