BOEING

COMPONENT
MAINTENANCE MANUAL

MAIN LANDING GEAR BEAM INSTALLATION COMPONENTS

PART NUMBERS 113T1109-1,-2
113T1134-1,-2
113T1136-1

COMPONENT MAINTENANCE MANUAL
WITH
ILLUSTRATED PARTS LIST

K50307

BOEING
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REVISION RECORD

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

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

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COMPONENT
MAINTENANCE MANUAL

TEMPORARY REVISION AND SERVICE BULLETIN RECORD

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

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* = REVISED, ADDED OR DELETED

COMPONENT
MAINTENANCE MANUAL

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*[1] 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 INSTALLATION COMPONENTS
DESCRIPTION AND OPERATION

1. Description

   A. The main landing gear beam support mainly consists of a wing outboard support, a hanger link assembly, a upper stabilizer brace assembly, and a lower stabilizer brace assembly. The hanger link attaches the inboard end of landing gear beam to the support fitting and aft wheel bulkhead of lower lobe. The outboard end of beam is conntected to the rear spar of wing by upper and lower brace stabilizers.

      This CMM covers the procedures for the hanger link assembly, and upper and lower stabilzer assemblies. The outboard support of main landing gear beam is covered by a separate CMM 57-54-39. Hanger link, and braces of upper and lower stabilizers consist of aluminum alloys.

2. Operation

   A. The basic function of main landing gear beam installation components is to support the main landing gear beam.

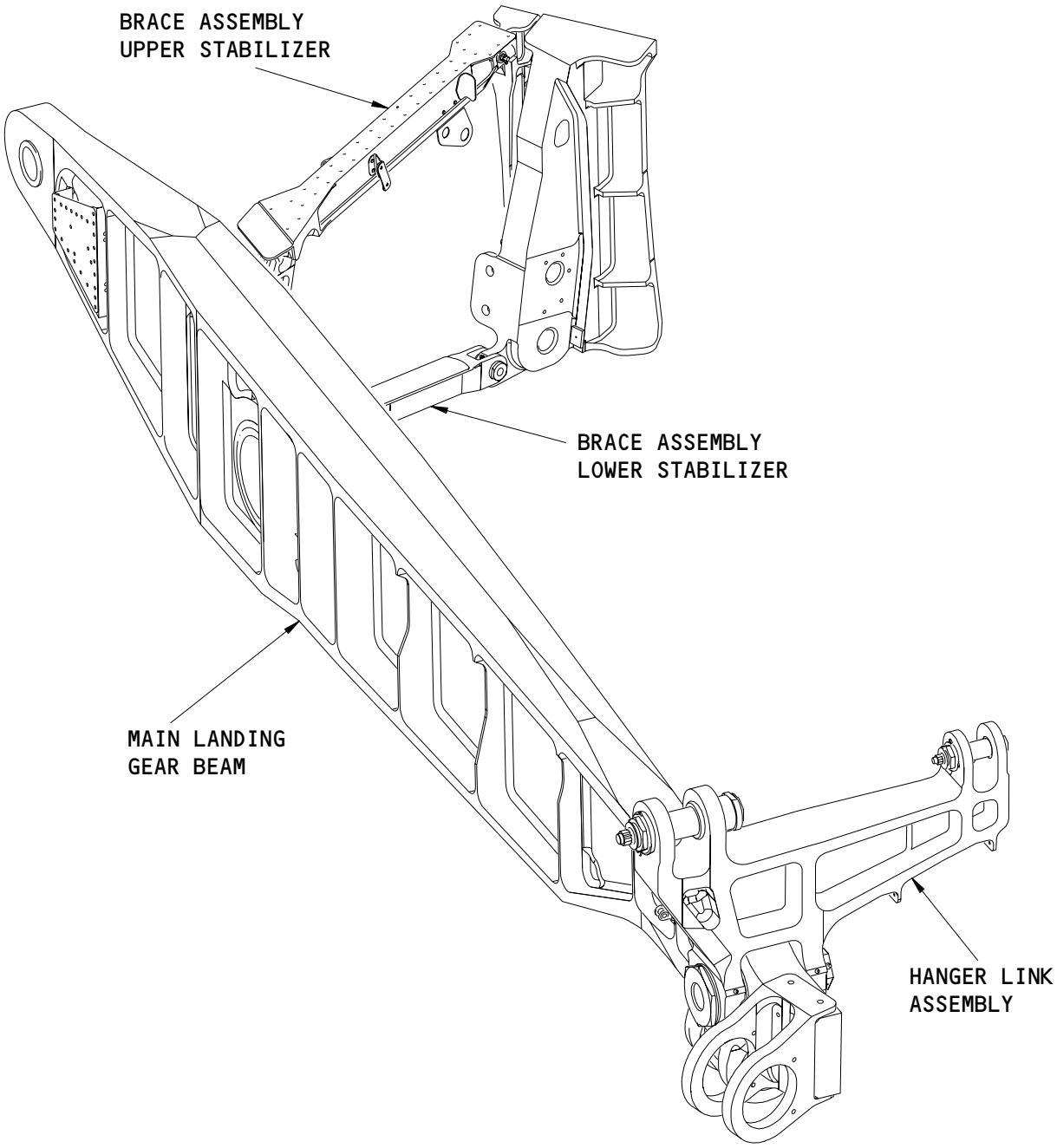
3. Leading Particulars (Approximate)

   A. Length -- X inches

   B. Width -- X inches

   C. Height -- X inches

   D. Weight -- X pounds



Main Landing Gear Beam Installation Components
Figure 1

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
113T1109	HANGER LINK ASSEMBLY	1-1
113T1109	HANGER LINK	1-2
113T1136	LOWER STABILIZER BRACE ASSEMBLY	2-1
113T1136	LOWER STABILIZER BRACE	2-2
113T1134	UPPER STABILIZER BRACE ASSEMBLY	3-1
113T1134	UPPER STABILIZER BRACE	3-2

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

K38893

HANGER LINK ASSEMBLY - REPAIR 1-1

113T1109-1, -2

1. General

   A. This procedure contains the data necessary to repair and refinish the hanger link assembly.

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

   C. Refer to the REPAIR - GENERAL (57-54-42/601, REPAIR - GENERAL) for the Standard True Position Dimensioning Symbols shown in the repair.

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

2. Bushing Replacement

   A. Consumable Materials

      NOTE: Equivalent material can be used.

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

   B. References

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

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

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

      (4) SOPM 20-50-03, Bearing/Bushing Removal, Installation and Retention

   C. Procedure

      (1) Remove bushings (15, 20, 25, 30, 35) from hanger link assembly (1).

      (2) Install Bushings (15, 20, 25, 30, 35) on hanger link assembly (1) by shrink-fit method with BMS 5-95 as shown in (SOPM 20-50-03).

3. Lubrication Fitting Replacement (Fig. 601)

(1) Consumable Materials

NOTE: Equivalent material can be used.

(2) D00633 Grease -- BMS 3-33 (Fig. 1)

A. References

(1) CMM 32-00-08, Landing Gear Parts Lubrication Fitting Replacement

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

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

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

(5) SOPM 20-60-03, Lubricants

(6) Procedure (Fig. 1)

(a) Remove the lubrication fitting (10).

(b) Install lubrication fitting with BMS 3-33 with 25-30 in-lbs torque.

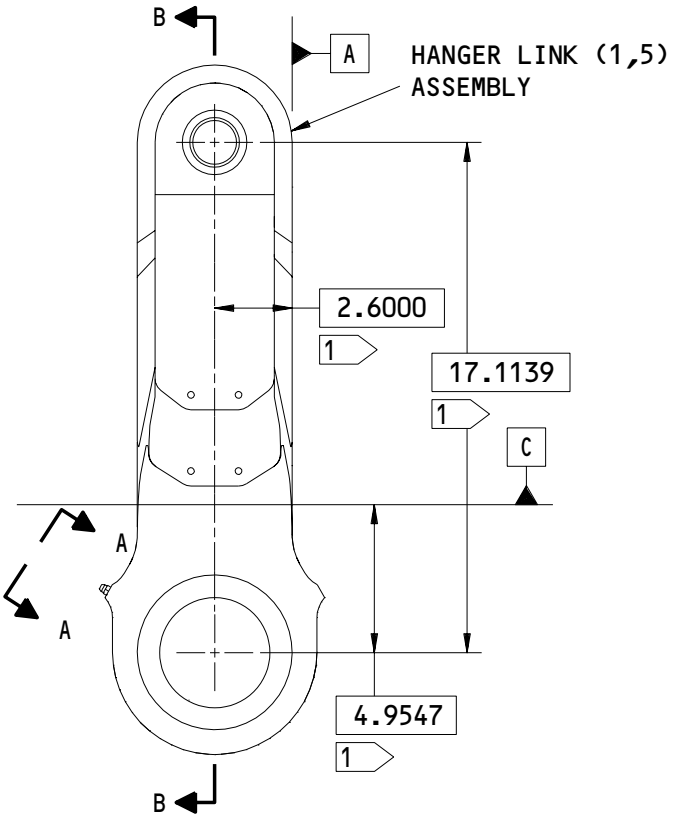
(c) After installation of bushings apply BMS 3-33 until grease appears at the inner diameter of the bushings.

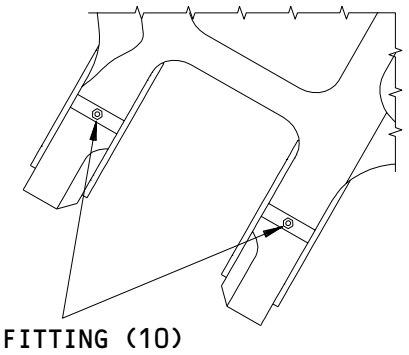
4. Link Assembly Refinish

A. Procedure

(1) Touch up with BMS 10-60 , Type I, Gloss enamel (F-14.9813).

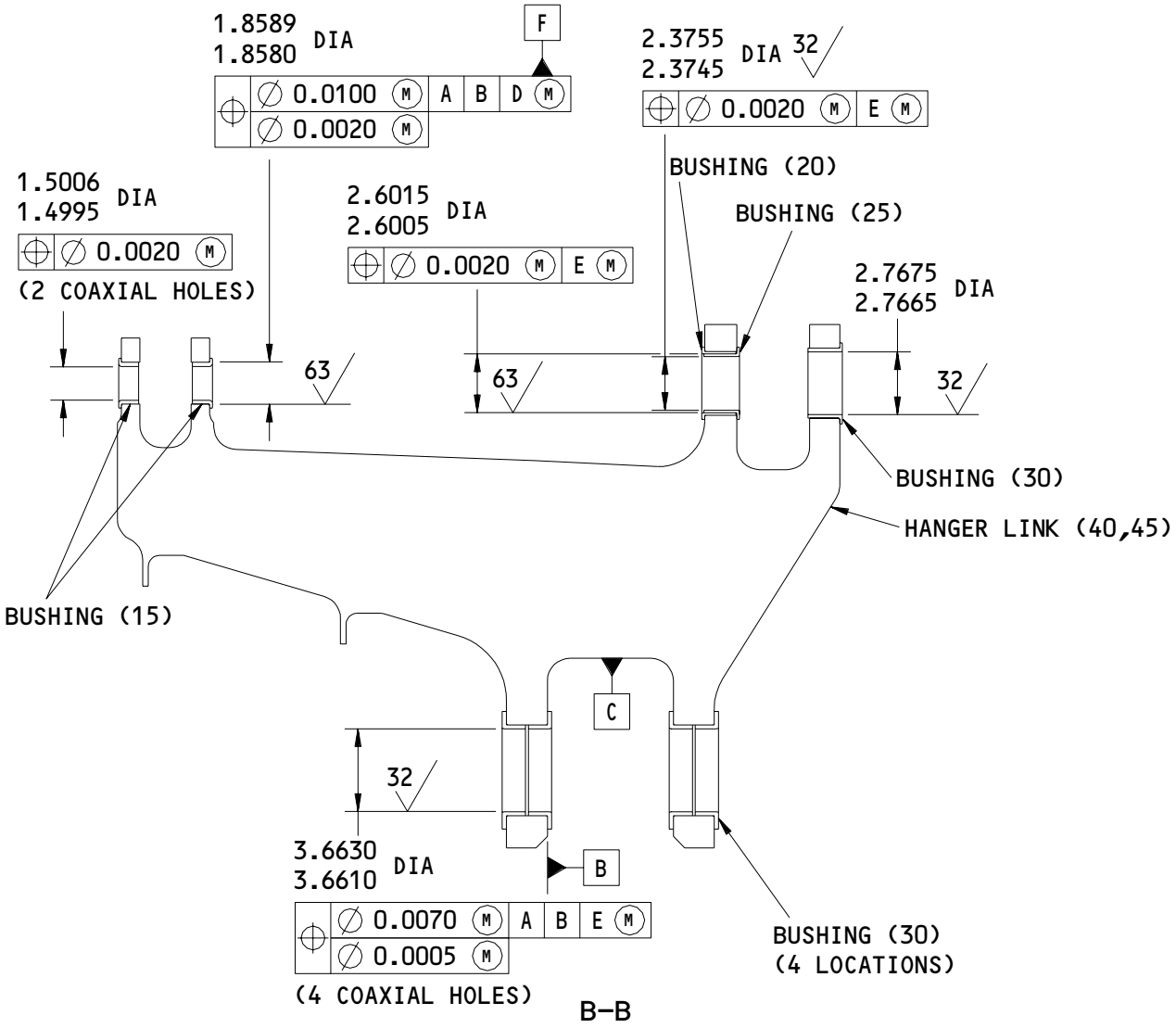
NOTE: Prior to touch up mask bushings, lube fittings and holes.





A-A

113T1109-1,-2
Hanger Link Assembly Bushing Replacement
Figure 601 (Sheet 1)



1 BASIC DIMENSION APPLIES TO BORE LOCATION ONLY

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

113T1109-1,-2
Hanger Link Assembly Bushing Replacement
Figure 601 (Sheet 2)

K39869

HANGER LINK - REPAIR 1-2

113T1109-3, -4

1. General

A. This repair gives the data that is necessary to repair and refinish the hanger link (40, 45).

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

C. Refer to the REPAIR - GENERAL (57-54-42/601, REPAIR -GENERAL) for the standard true position dimensioning symbols shown in the repair.

D. Refer to the IPL Fig. 2 for item numbers.

E. General repair details:

(1) Material: 7050-01 Al Alloy, forged block per BMS 7-214

(2) Shot Peen: All surfaces, Intensity 0.014A

2. Bushing Hole Repair

A. References

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

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

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

B. Procedure

(1) Machine the worn or damaged holes for the bushings (15, 20, 30, 35) 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 0.010-0.020 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 hole to the finish and apply finish (F-17.31) per flag note 2 as shown in Fig. 601.

(6) Oversize bushings.

(a) Make the repair bushings for bushings (15, 20, 30, 35) as shown in Fig. 602 and in the following instructions.

1) Bushing Material: AL-NI-BRONZE bar per AMS 4640 annealed

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).

NOTE: Plating on bushing ID is removed during installation reaming.

5) Obey flag note 1 in the fig 602 and fig 603.

6) Install the oversize repair bushings (15, 20, 30, 35) on hanger link as shown in REPAIR 1-1.

3. Link - Refinish

A. Consumable Materials

(1) C00175 Primer -- BMS 10-79 (SOPM 20-44-04)

B. References

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

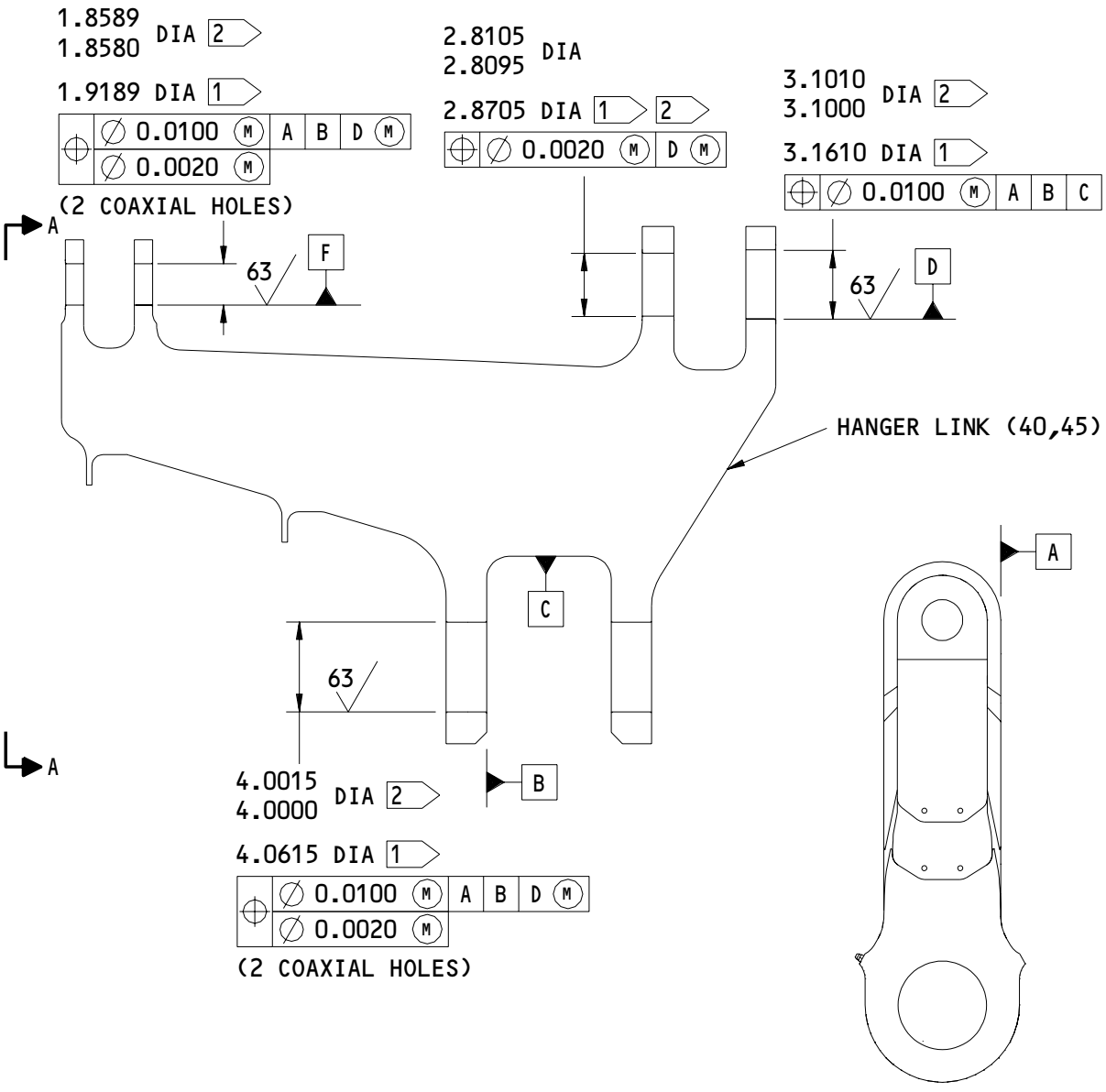
(2) SOPM 20-41-01, Decoding Table of Boeing Finish Codes

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

C. Procedure

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

(2) Apply BMS 10-11, Type I Primer (F-20.02).



1 REPAIR LIMIT

2 F-17.31 TO INDICATED SURFACE

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

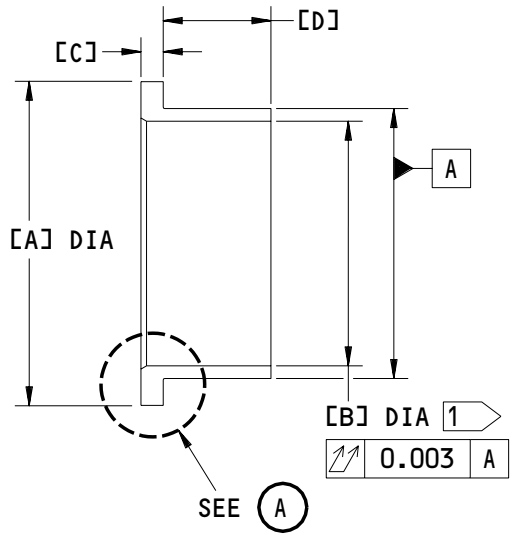
BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 2

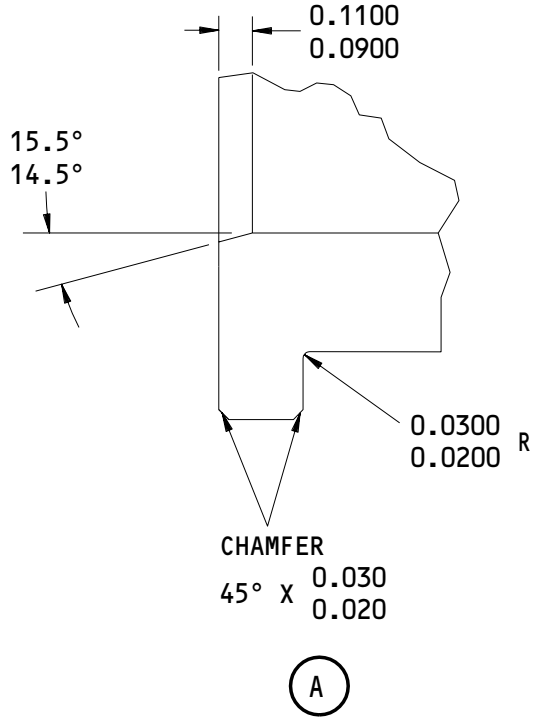
ALL DIMENSIONS ARE IN INCHES

113T1109-3,-4
Hanger Link Repair
Figure 601

K40459



OVERSIZE REPLACEMENT FOR BUSHING (15,20,30)



Oversize Bushing Details
Figure 602 (Sheet 1)

BUSHING ITEM NO.	[A]	[B]	[C]	[D]	INTERFERENCE
15	2.2100 2.1900	1.4750 1.4700	0.1200 0.1150	0.7700 0.7500	0.001-0.003
20	3.2100 3.1900	2.5800 2.5750	0.1200 0.1150	1.3900 1.3800	0.001-0.003
30	3.6100 3.5900	2.7470 2.7420	0.1200 0.1150	1.4075 1.4025	0.001-0.003

NOTE: WHEN YOU MAKE THIS PART, DO NOT USE LASER CUTTING, ELECTRICAL DISCHARGE MACHINING, THERMAL CUTTING, AND ALL OTHER NON-CONVENTIONAL MACHINING PROCEDURES.

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

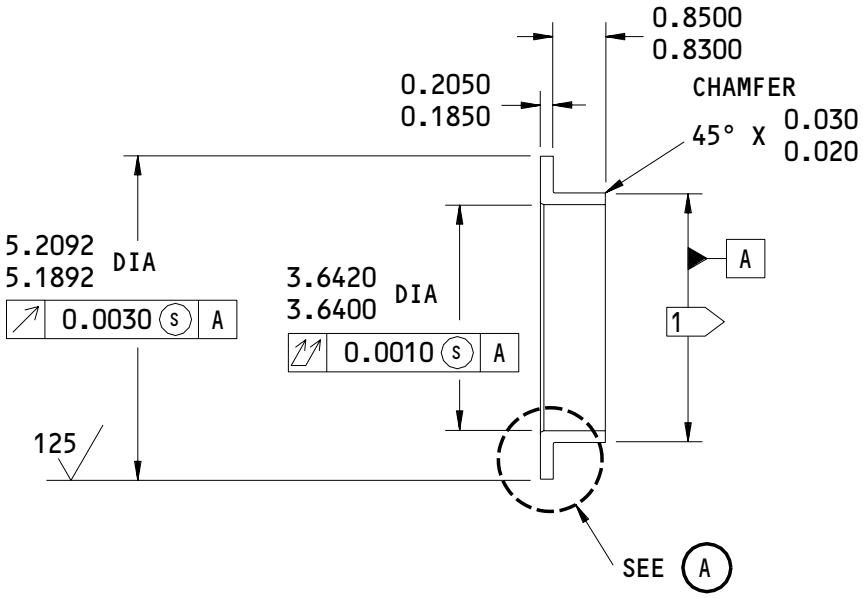
64 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

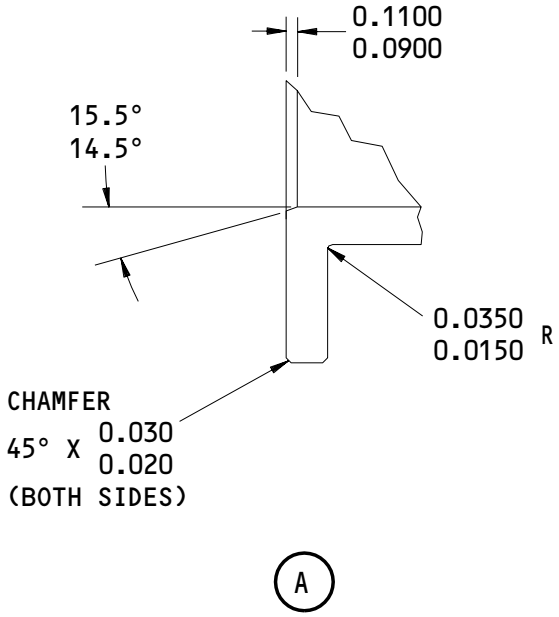
ITEM NUMBER REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

Oversize Bushing Details
Figure 602 (Sheet 2)



OVERSIZE REPLACEMENT FOR BUSHING (35)



Oversize Bushing Details
Figure 603 (Sheet 1)

NOTE: WHEN YOU MAKE THIS PART, DO NOT USE LASER CUTTING, ELECTRICAL DISCHARGE MACHINING, THERMAL CUTTING, AND ALL OTHER NON-CONVENTIONAL MACHINING PROCEDURES. ALL CONNECTING PLANE AND CURVED SURFACES TO BLEND SMOOTHLY. MAXIMUM MISMATCH 0.005.

1 THE OUTSIDE DIAMETER OF THE BUSHING AFTER PLATING IS EQUAL TO THE INSIDE DIAMETER OF THE LUG HOLE PLUS A 0.0040 THRU 0.008 INTERFERENCE

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBER REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

Oversize Bushing Details
Figure 603 (Sheet 2)

LOWER STABILIZER BRACE ASSEMBLY - REPAIR 2-1

113T1136-1

1. General

A. This procedure contains the data necessary to repair and refinish the hanger link assembly.

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

C. Refer to the REPAIR - GENERAL (57-54-42/601, REPAIR - GENERAL) for the Standard True Position Dimensioning Symbols shown in the repair.

D. Refer to IPL Fig. 3 for item numbers.

2. Bushing Replacement

A. Consumable Materials

NOTE: Equivalent material can be used.

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

B. References

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

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

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

(4) SOPM 20-50-03, Bearing/Bushing Removal, Installation and Retention

C. Procedure

(1) Remove the bushings (10, 15, 20) from lower stabilizer brace assembly (1).

(2) Install Bushings (10, 15, 20) on lower stabilizer brace assembly by shrink-fit method with BMS 5-95 as shown in (SOPM 20-50-03).

3. Lubrication Fitting Replacement (Fig. 601)

(1) Consumable Materials

NOTE: Equivalent material can be used.

(2) D00633 Grease -- BMS 3-33 (Fig. 1)

A. References

(1) CMM 32-00-08, Landing Gear Parts Lubrication Fitting Replacement

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

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

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

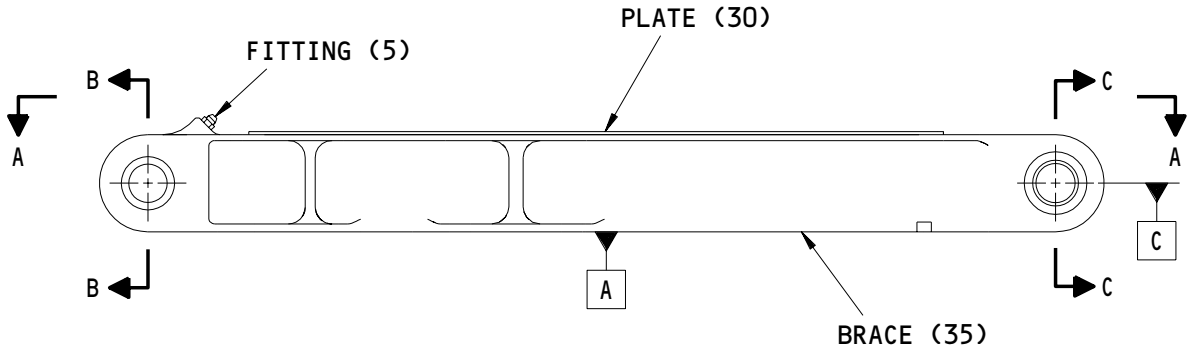
(5) SOPM 20-60-03, Lubricants

B. Procedure (Fig. 1)

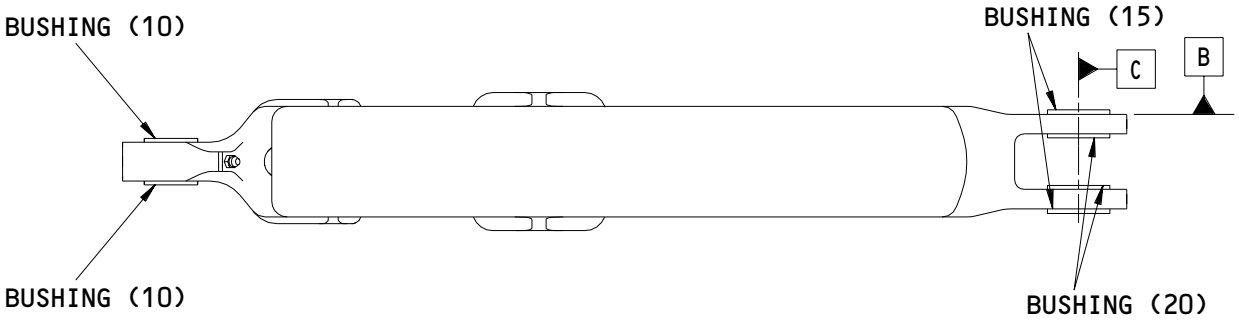
(1) Remove the lubrication fitting (5).

(2) Install lubrication fitting with BMS 3-33 with 25-30 in-lbs torque.

(3) After installation of bushings apply BMS 3-33 until grease appears at the inner diameter of the bushings.



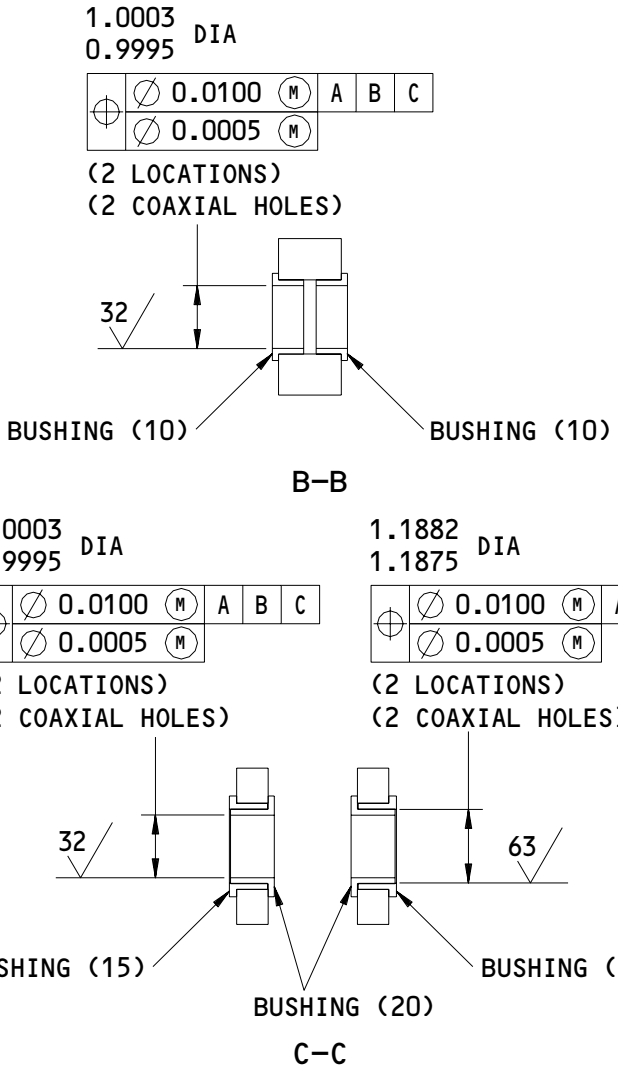
113T1136-1 SHOWN
113T1136-2 OPPOSITE



A-A

113T1136-1,-2
Brace Assembly Lower Stabilizer Bushing Replacement
Figure 601 (Sheet 1)

K39327



125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

ITEM NUMBERS REFER TO IPL FIG. 3

ALL DIMENSIONS ARE IN INCHES

113T1136-1,-2
Brace Assembly Lower Stabilizer Bushing Replacement
Figure 601 (Sheet 2)

LOWER STABILIZER BRACE - REPAIR 2-2

113T1136-3

1. General

A. This procedure contains the data necessary to repair and refinish the Lower stabilizer brace assembly.

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

C. Refer to the REPAIR - GENERAL (57-54-42/601, REPAIR - GENERAL) for the Standard True Position Dimensioning Symbols shown in the repair.

D. Refer to IPL Fig. 3 for item numbers.

E. General repair details:

(1) Material: Aluminum alloy (7050-T7451 PER BMS 7-323 TYPE I)

(2) Shot Peen: All surfaces, Intensity 0.008A

2. Bushing Hole Repair

A. References

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

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

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

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

B. Procedure

(1) Machine the worn or damaged hole for the bushings (10, 15) 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 0.010-0.020 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 hole to the finish and apply finish (F-17.31) per flag note 2 as shown in Fig. 601.

(6) Oversize bushings.

(a) Make the repair bushing for bushing (325A) as shown in Fig. 602 and in the following instructions.

1) Bushing Material: AL-BRONZE bar per AMS 4640

2) Break all the sharp edges.

3) Prepare the surface and cadmium plate (F-15.02) as shown in (SOPM 20-42-05).

4) Obey flag note 1 in the fig 602 and fig 603.

5) Install the oversize repair bushings (10, 15) on lower stabilizer brace (35) as shown in REPAIR 2-1.

3. Brace Refinish

A. Consumable Materials

NOTE: Equivalent material can be used.

(1) C00432 Primer -- BMS 10-11, Type 1 (SOPM 20-60-02)

B. References

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

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

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

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

C. Procedure (Fig. 601)

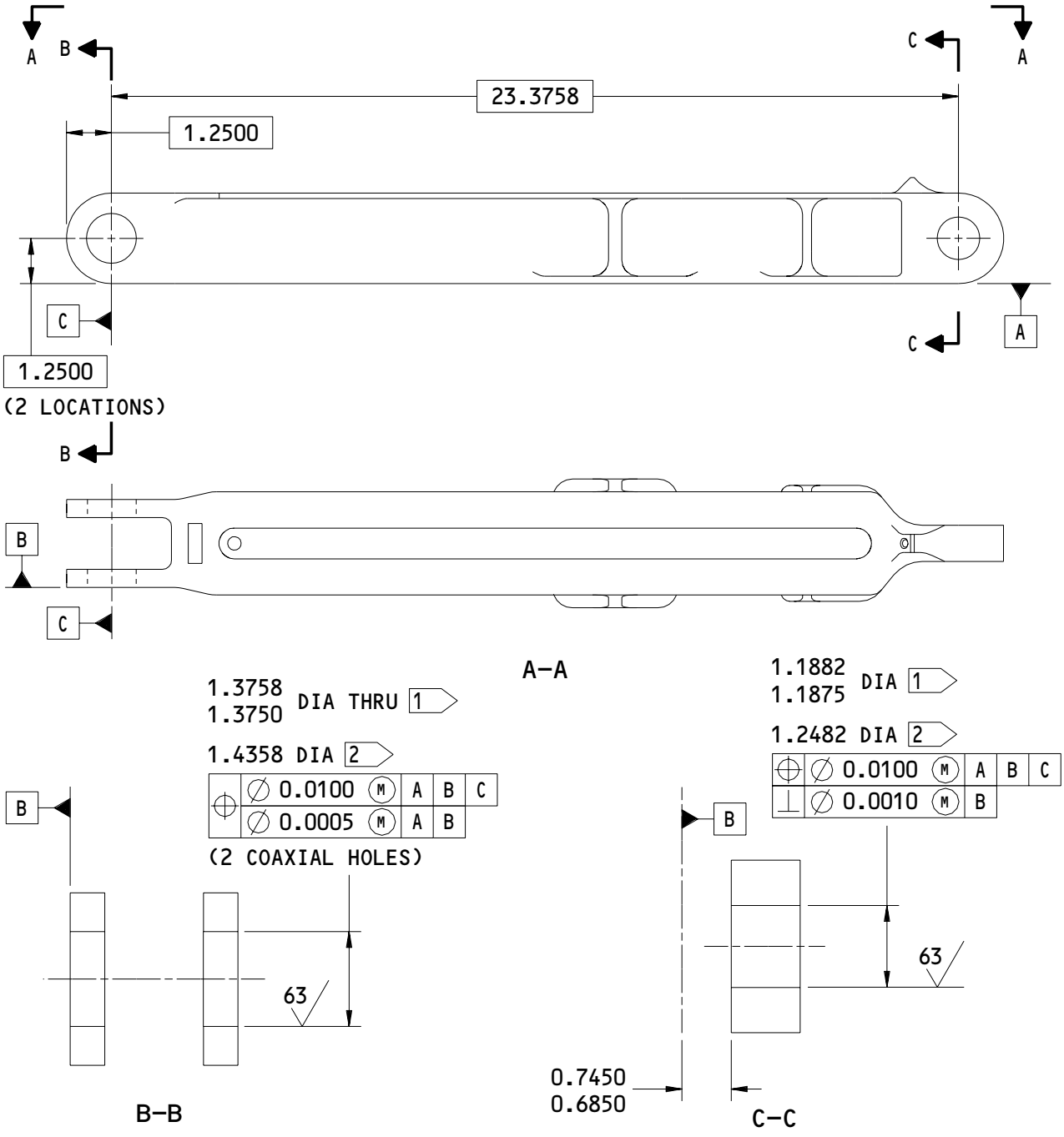
(1) Appply a finish on the brace (35).

(a) Boric acid-sulphuric acid anodize Class 1 or class 5 Or chromic acid anodize at 22 Volt class 3 or class 5 (F-17.31).

(b) Apply one coat of BMS 10-11, Type I primer (F-20.02).

1) Do not apply primer to the bushing holes.

(c) Obey the flag note in Fig. 601



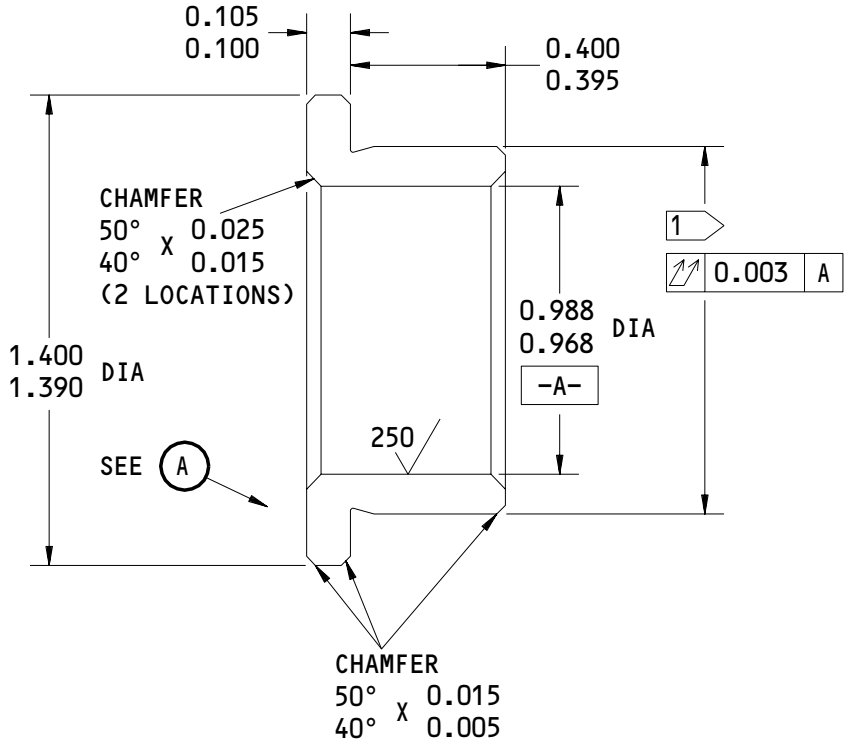
1 BORIC ACID-SULFURIC ACID ANODIZE (F-17.31) TO INDICATED SURFACE

2 REPAIR LIMIT

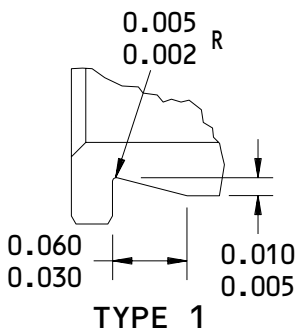
125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

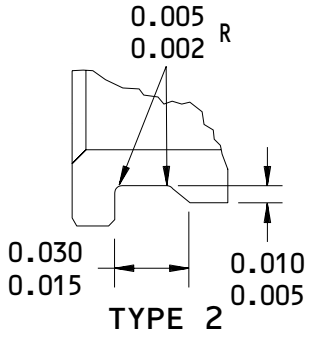
ALL DIMENSIONS ARE IN INCHES

113T1136-3
Lower Stabilizer Brace Repair
Figure 601



OVERSIZE REPLACEMENT FOR BUSHING (10)





A

1 THE OUTSIDE DIAMETER OF THE BUSHING AFTER PLATING IS EQUAL TO THE INSIDE DIAMETER OF THE LUG HOLE PLUS A -0.0015 THRU -0.0025 INTERFERENCE

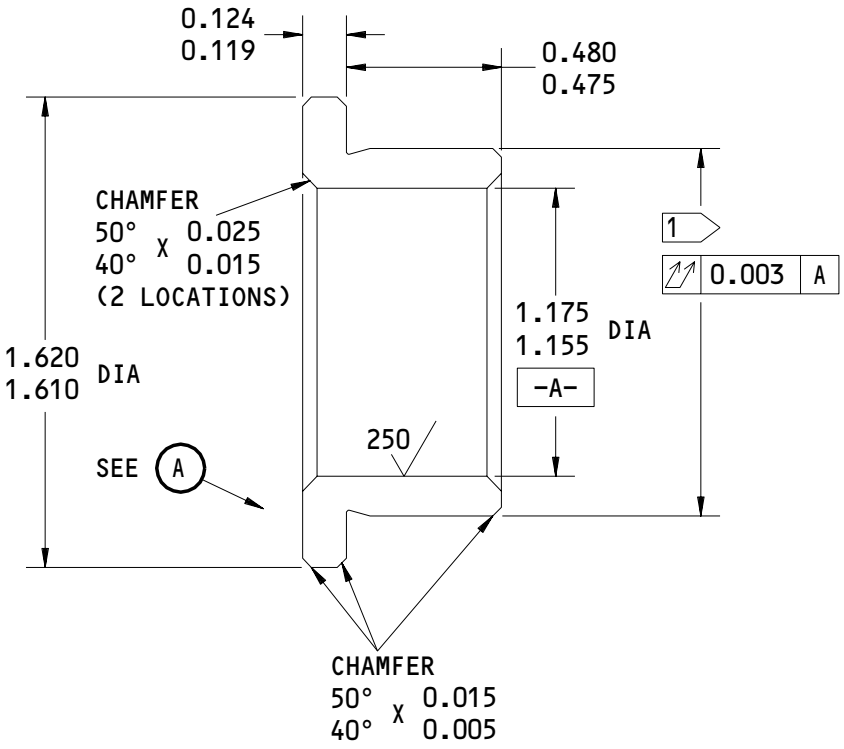
63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

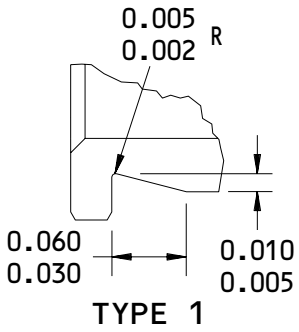
ITEM NUMBERS REFER TO IPL FIG. 1

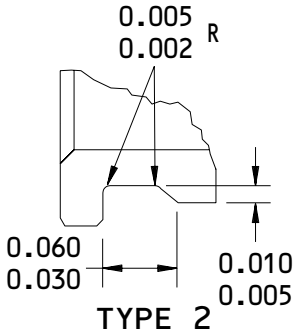
ALL DIMENSIONS ARE IN INCHES

Oversize Bushing Details
Figure 602



OVERSIZE REPLACEMENT FOR BUSHING (20)





A

1 THE OUTSIDE DIAMETER OF THE BUSHING AFTER PLATING IS EQUAL TO THE INSIDE DIAMETER OF THE LUG HOLE PLUS A -0.0015 THRU -0.0030 INTERFERENCE

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

Oversize Bushing Details
Figure 603

UPPER STABILIZER BRACE ASSEMBLY - REPAIR 3-1

113T1134-1,-2

1. General

   A. This procedure contains the data necessary to repair and refinish the hanger link assembly.

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

   C. Refer to the REPAIR - GENERAL (57-54-42/601, REPAIR - GENERAL) for the Standard True Position Dimensioning Symbols shown in the repair.

   D. Refer to IPL Fig. 4

2. Bushing Replacement

   A. Consumable Materials

      NOTE: Equivalent material can be used.

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

   B. References

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

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

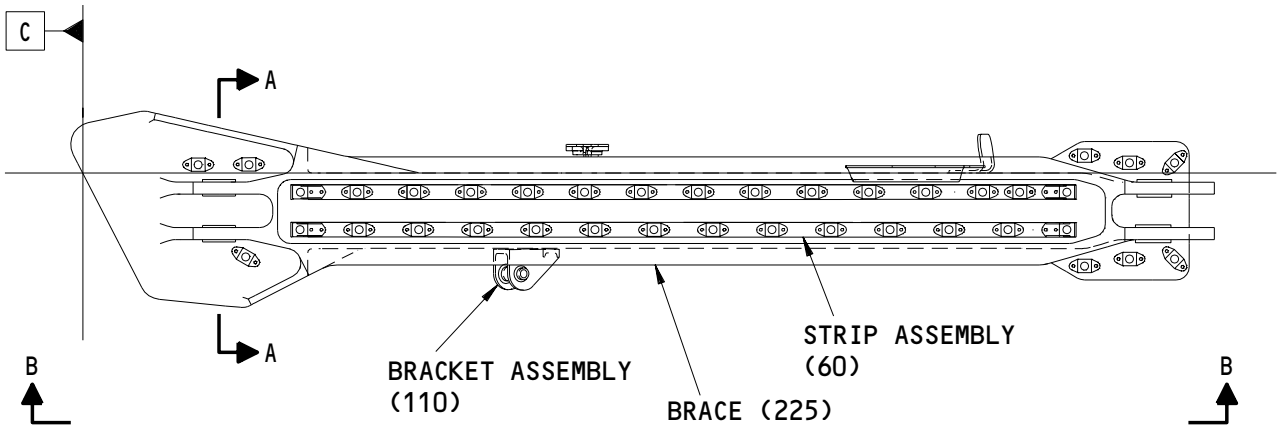
      (3) SOPM 20-41-01, Decoding Table for Boeing Finish Codes

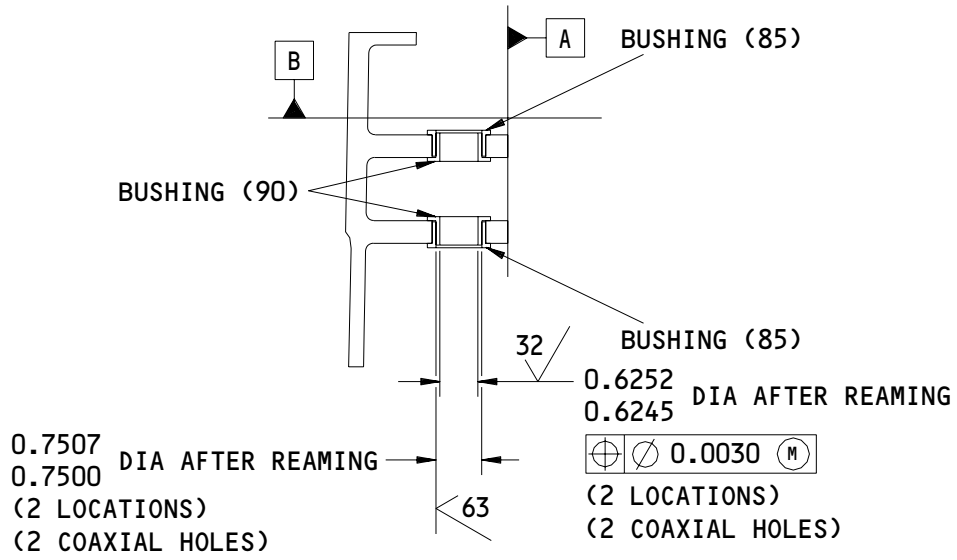
      (4) SOPM 20-50-03, Bearing / Bushing Removal, Installation and Retention

   C. Procedure

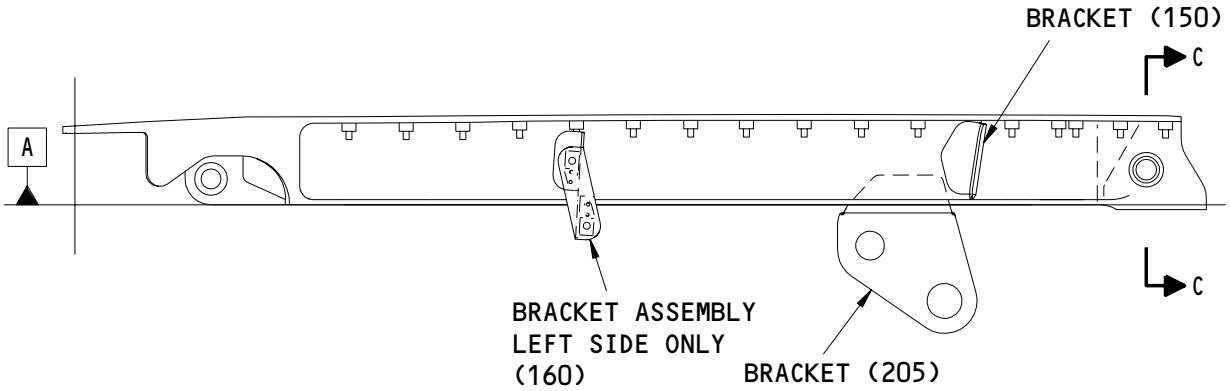
      (1) Remove the bushings (fig. 1, 785,790), (fig. 4, 85, 90).

      (2) Install bushings (85 ,90, 785, 790) by shrink-fit method with BMS [5-95 as shown in (SOPM 20-50-03).



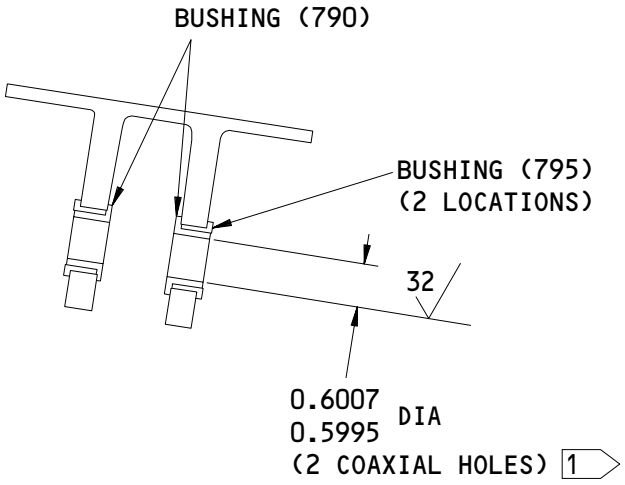


A-A



B-B

113T1134-1,-2
Upper Stabilizer Brace Assembly
Figure 601 (Sheet 1)



C-C

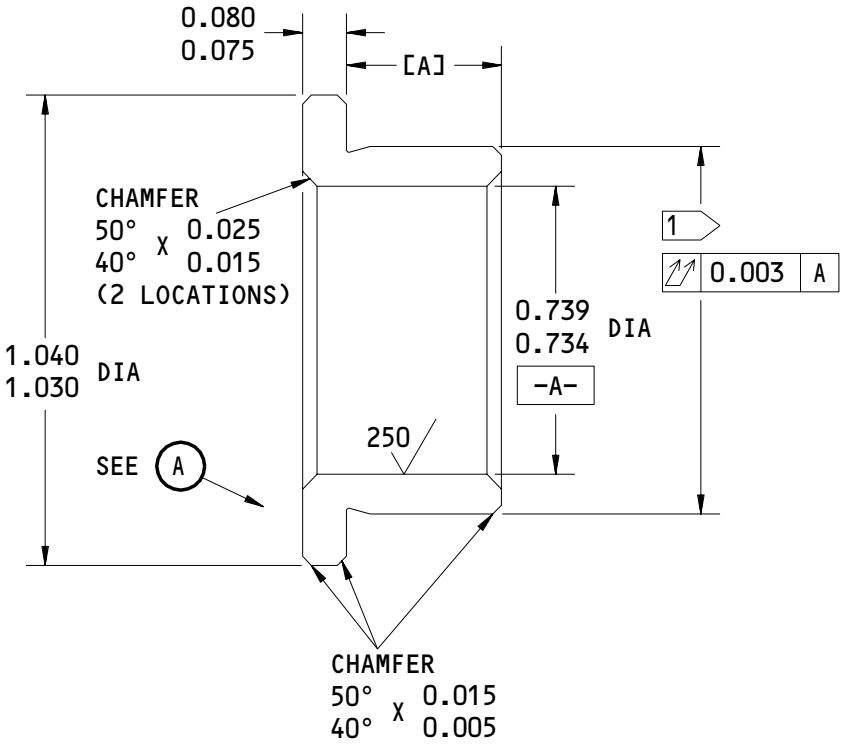
1 DURING THE INSTALLATION, LOCATE BORE IN 113T1134 STABILIZER BRACE TO MATCH THE 113T1124 REAR SPAR FITTING BORE WHILE MAINTAINING NOTED OFFSET (0.1000 ± 0.0100) FROM THE WING UPPER SKIN OML (TO ACCOMODATE 113T1605 AND 113T1606 FIXED PANELS). AFTER BORING, BREAK SHARP EDGES 0.010-0.030 PER BAC 5300

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

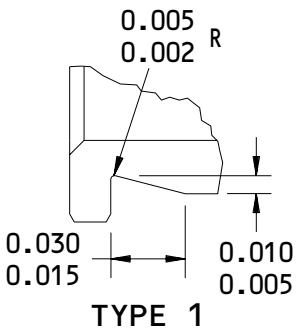
ITEM NUMBERS REFER TO IPL FIG. 4

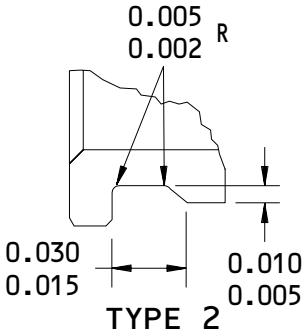
ALL DIMENSIONS ARE IN INCHES

113T1134-1,-2
Upper Stabilizer Brace Assembly
Figure 601 (Sheet 2)



OVERSIZE REPLACEMENT FOR BUSHINGS
(85,785)





BUSHING REPLACES ITEM NO.	[A]
85	0.350 0.345
785	0.340 0.335

A

1 THE OUTSIDE DIAMETER OF THE BUSHING AFTER PLATING IS EQUAL TO THE INSIDE DIAMETER OF THE LUG HOLE PLUS A -0.0008 THRU -0.0020 INTERFERENCE

63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

Oversize Bushing Details
Figure 602

UPPER STABILIZER BRACE - REPAIR 3-2

113T1134-3,-4

1. General

A. This procedure contains the data necessary to repair and refinish the Lower stabilizer brace assembly.

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

C. Refer to the REPAIR - GENERAL (57-54-42/601, REPAIR - GENERAL) for the Standard True Position Dimensioning Symbols shown in the repair.

D. Refer to IPL Fig. 4 for item numbers.

E. General repair details:

(1) Material: Aluminum alloy (7050-T7451 PER BMS 7-323, TYPE I)

(2) Shot Peen: All surfaces, Intensity 0.006A

F. Stab brace general repair details:

2. Bushing Hole Repair

A. References

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

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

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

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

B. Procedure

(1) Machine the worn or damaged hole for the bushings (fig.1 785, fig.4 85), 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 0.010-0.020 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 hole to the finish and apply finish (F-17.31) per flag note 2 as shown in Fig 602.

(6) Oversize bushings.

(a) Make the repair bushing for bushings (85, 785) as shown in Fig. 602 and in the following instructions.

1) Bushing Material: AL-BRONZE bar per AMS 4640

2) Break all the sharp edges.

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

4) Obey flag note 1 in the Fig 603.

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

3. Brace Refinish

A. Consumable Materials

NOTE: Equivalent material can be used.

(1) C00432 Primer -- BMS 10-11, Type 1 (SOPM 20-60-02)

B. References

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

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

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

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

C. Procedure (Fig. 601)

(1) Appply a finish on the brace (35).

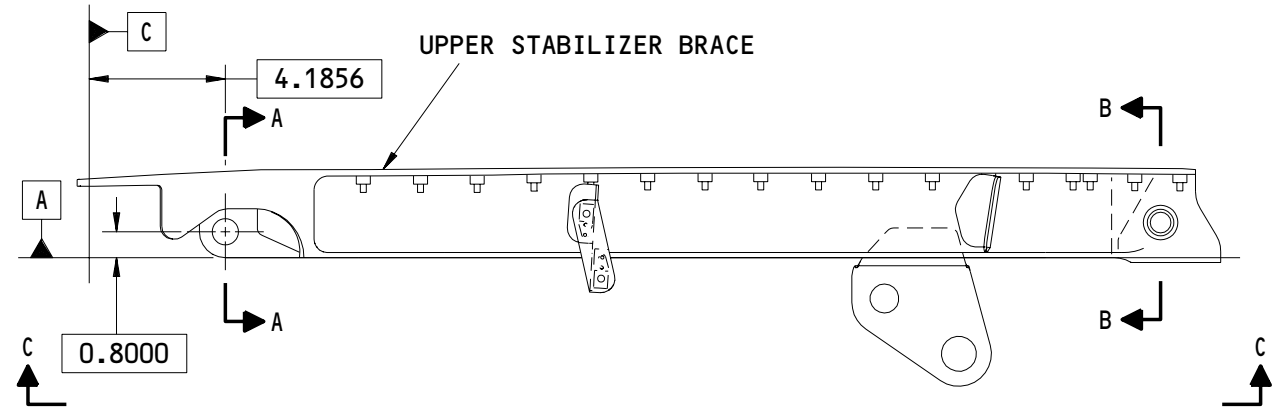
(a) Boric acid-sulphuric acid anodize Class 1 or class 5 or chromic acid anodize at 22 Volt class 3 or class 5 (F-17.31).

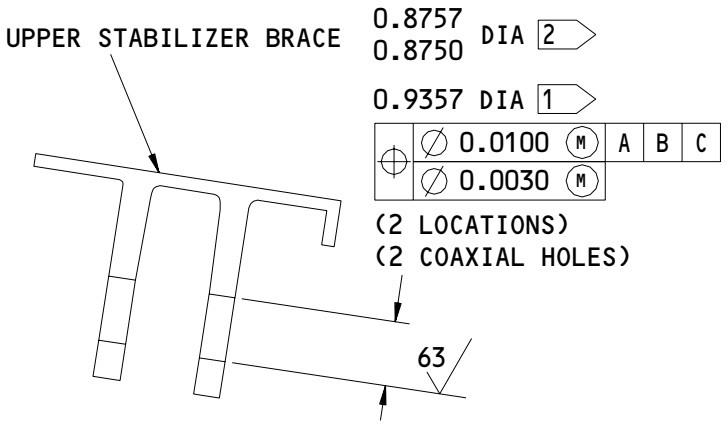
(b) Apply one coat of BMS 10-11, Type I primer (F-20.02).

(c) Apply one coat of BMS 10-11, Type I primer (F-20.02).

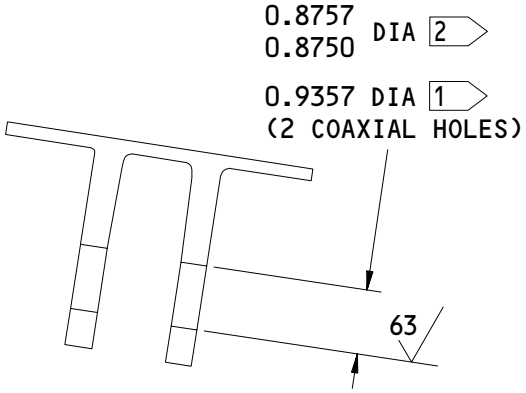
NOTE: Do not apply primer to the bushing holes.

1) Do not apply primer to the bushing holes.

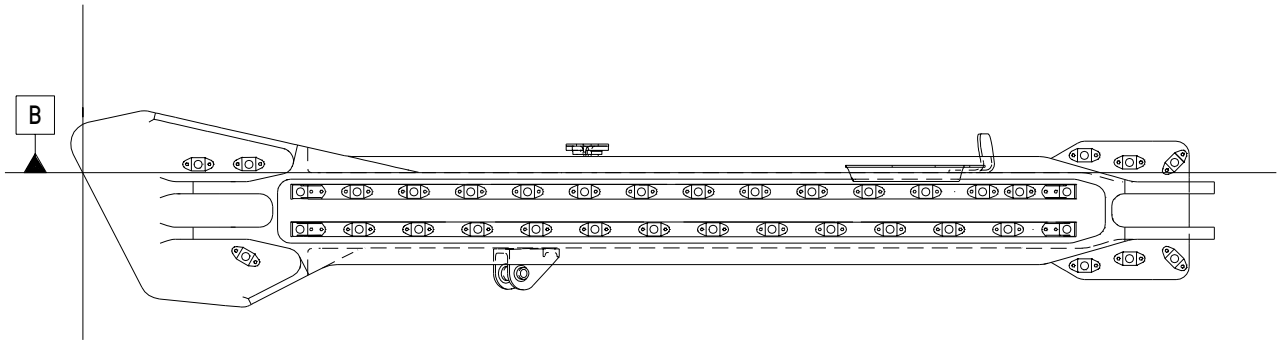




A-A



B-B



C-C

1 REPAIR LIMITS

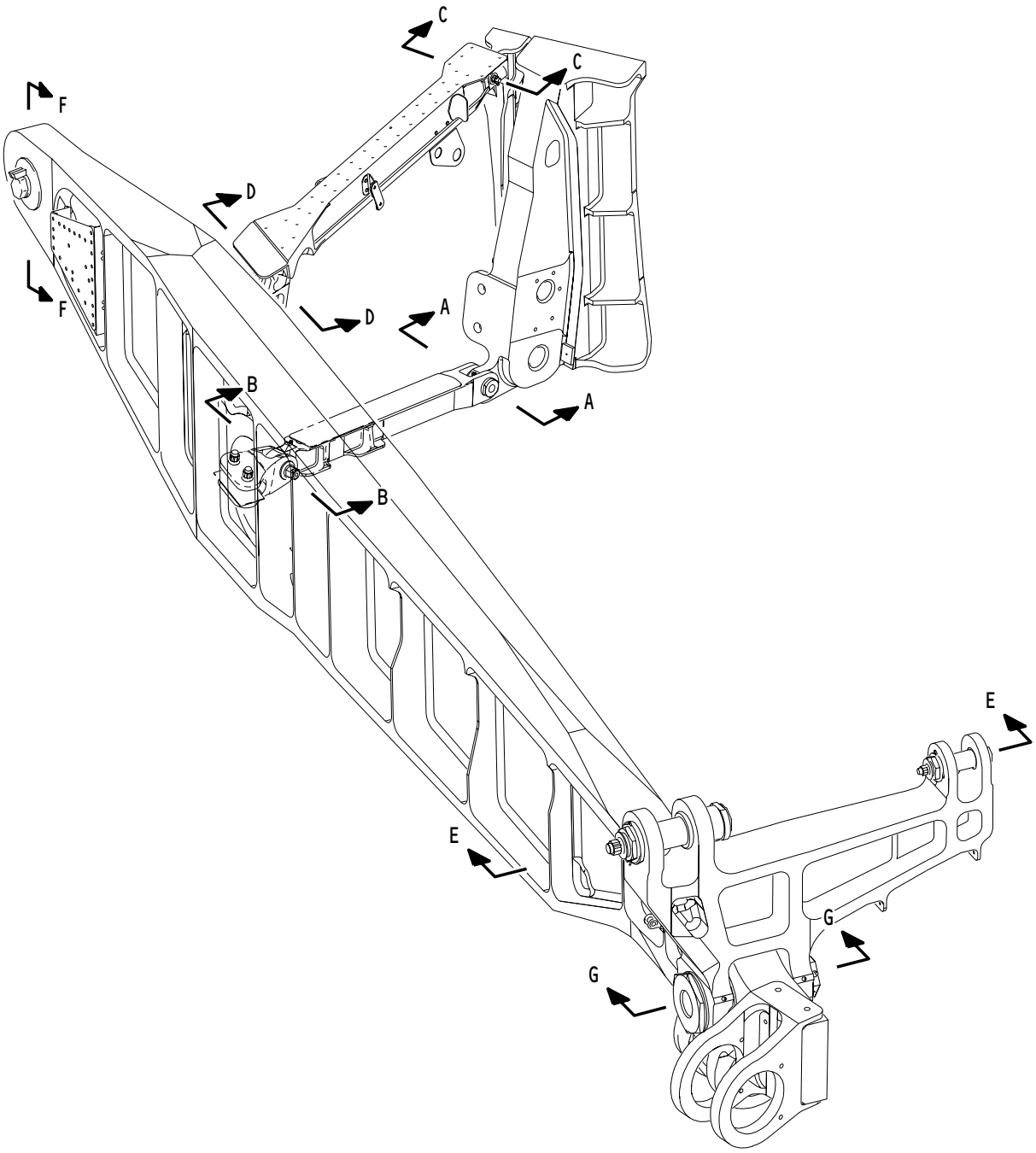
2 F-17.31 TO INDICATED SURFACE

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

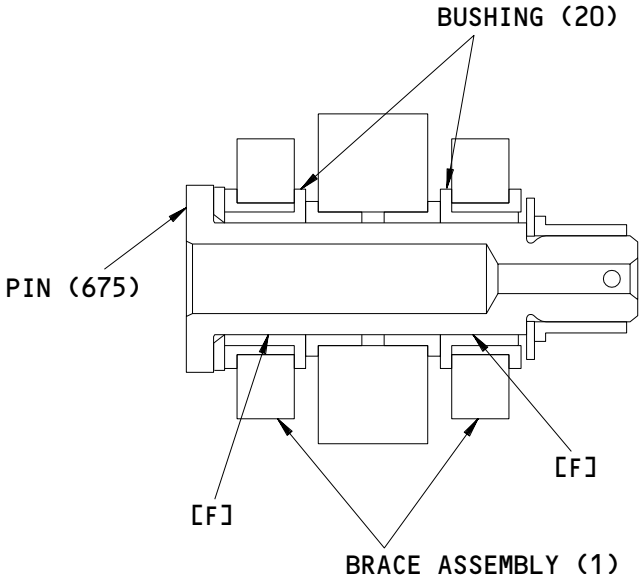
113T1133-3,-4
Upper Stabilizer Brace
Figure 601

K40792

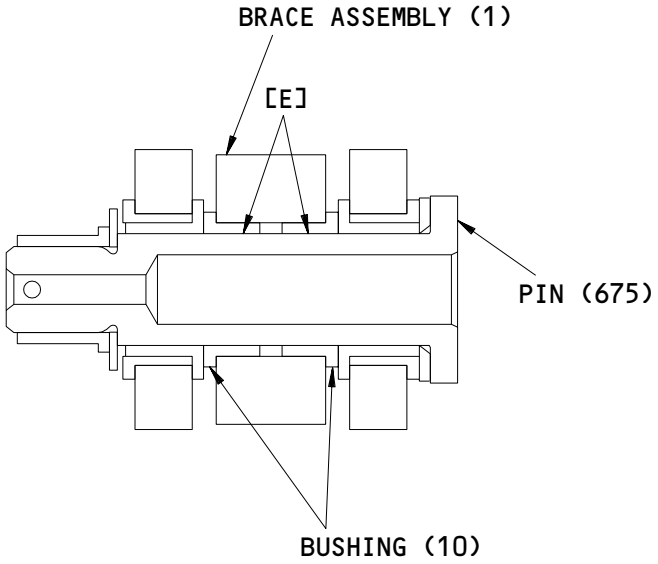


Fits and Clearances
Figure 801 (Sheet 1)

K42410



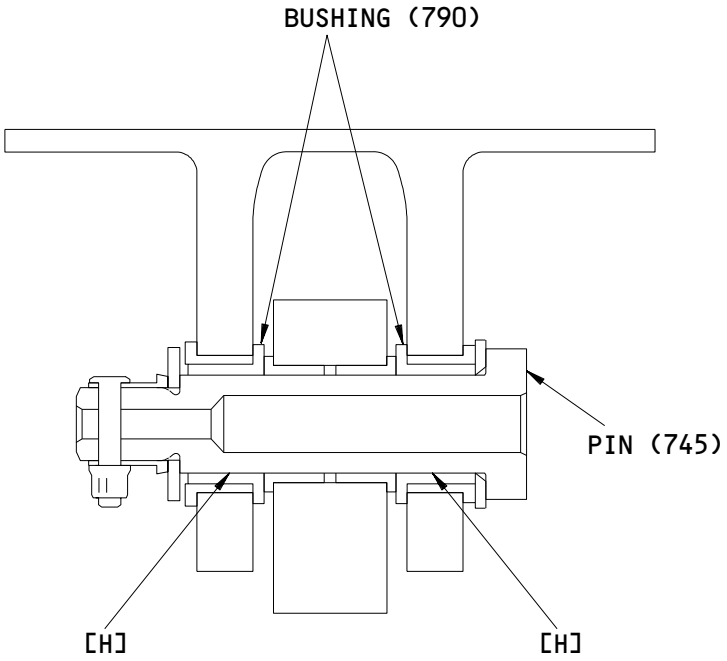
A-A



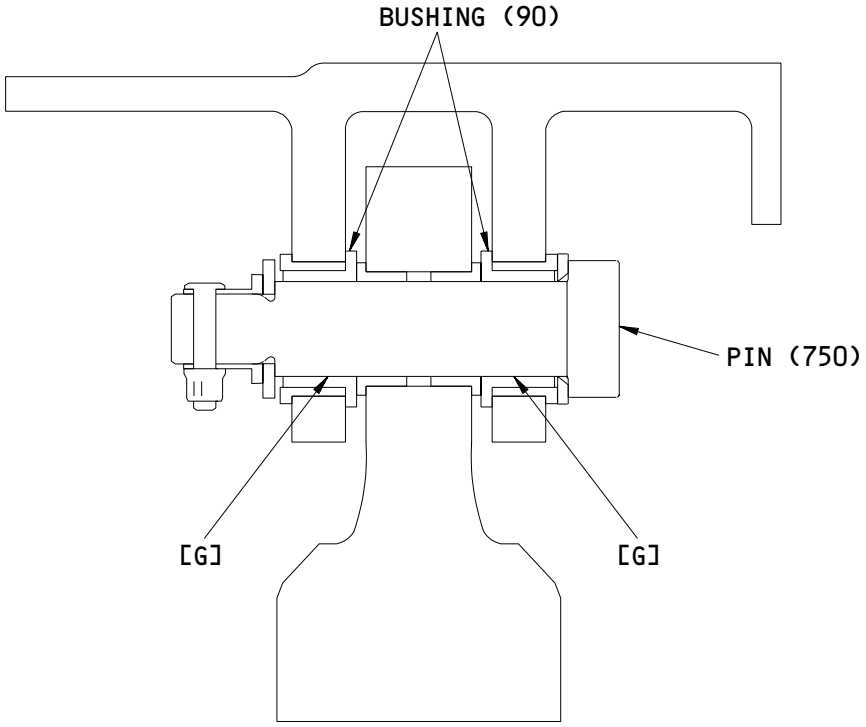
B-B

Fits and Clearances
Figure 801 (Sheet 2)

K42436

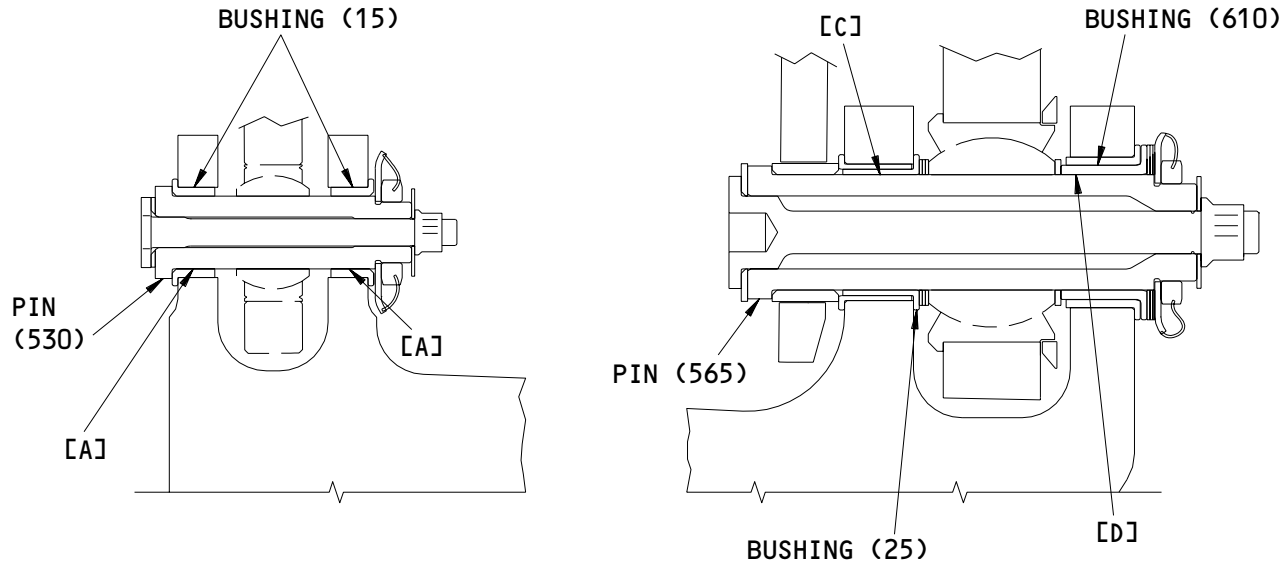


C-C

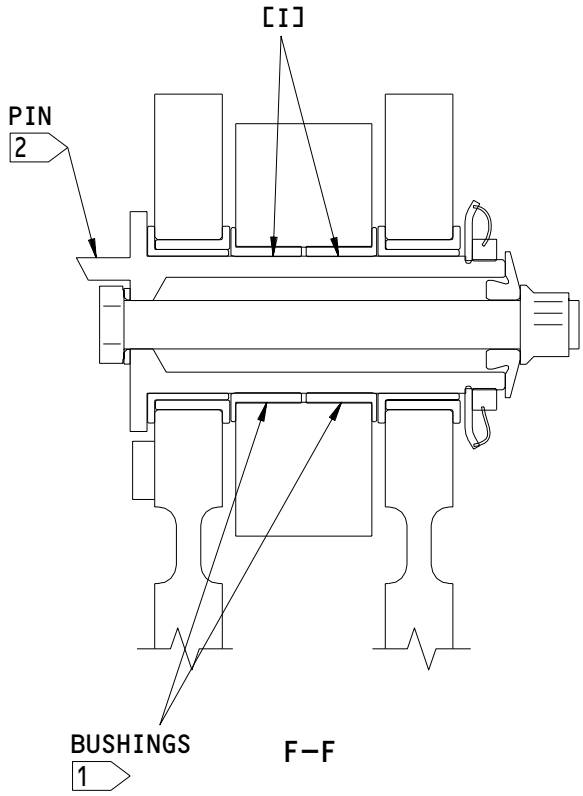


D-D

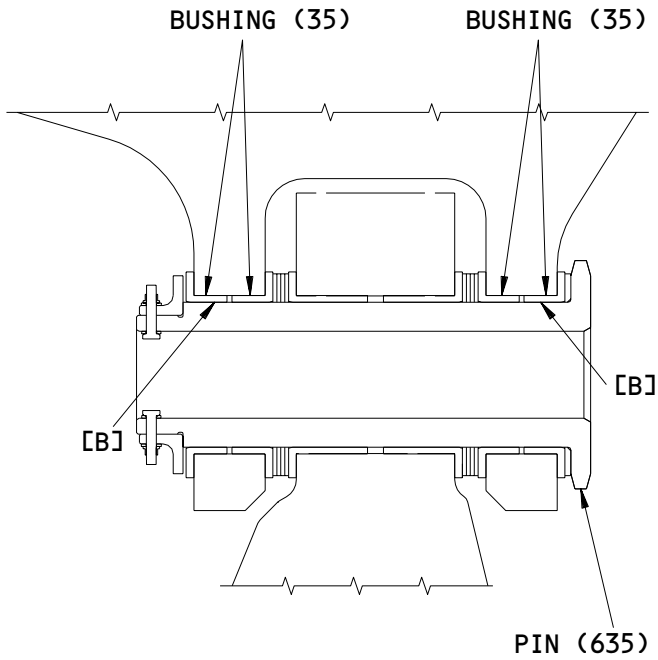
Fits and Clearances
Figure 801 (Sheet 3)



E-E



F-F



G-G

Fits and Clearances
Figure 801 (Sheet 4)

K42674

REF LETTER	REF IPL FIG. 1, MATING ITEM NO.	DESIGN DIMENSION*				SERVICE WEAR LIMIT*		
		DIMENSION		ASSEMBLY CLEARANCE		DIMENSION		MAXIMUM CLEARANCE
		MIN	MAX	MIN	MAX	MIN	MAX	
[A]	ID 15	1.4995	1.5006	0.0010	0.0029		1.5072	0.0095
	OD 507	1.4977	1.4985			1.4911		
[B]	ID 35	3.6610	3.6630	0.0005	0.0030		3.6750	0.0150
	OD 635	3.6600	3.6605			3.6480		
[C]	ID 25	2.3745	2.3755	0.0005	0.0023		2.3682	0.0130
	OD 565	2.3732	2.3740			2.3635		
[D]	ID 610	2.3745	2.3755	0.0005	0.0023		2.3682	0.0130
	OD 565	2.3732	2.3740			2.3625		
[E]	ID 10	0.9995	1.0003	0.0005	0.0018		1.0053	0.0068
	OD 675	0.9985	0.9990			0.9935		
[F]	ID 20	0.9995	1.0003	0.0005	0.0018		1.0053	0.0068
	OD 675	0.9985	0.9990			0.9935		
[G]	ID 790	0.5995	0.6002	0.0005	0.0017		0.6035	0.0050
	OD 750	0.5985	0.5990			0.5962		
[H]	ID 90	0.6245	0.6252	0.0005	0.0022		0.628	0.0050
	OD 745	0.6230	0.6240			0.6202		
[I]	ID 1	2.8215	2.8235	0.0005	0.0035		2.8350	0.0145
	OD 2	2.8200	2.8210			2.8090		

* ALL DIMENSIONS ARE IN INCHES

1 INSTALLATION BUSHING 113T1117-1

2 INSTALLATION PIN 113T1145-8

Fits and Clearances
Figure 801 (Sheet 5)

K43701

ILLUSTRATED PARTS LIST

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

2. Indentures show parts relationships as follows:

    Assembly
      Detail Parts for Assembly
      Subassembly
      Attaching Parts for Subassembly
        Detail Parts for Subassembly

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

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

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

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

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

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

6. Parts Interchangeability

Optional (OPT)	The parts are optional to and interchangeable with other parts having the same item number.
Supersedes, Superseded By (SUPSDS, SUPSD BY)	The part supersedes and is not interchangeable with the original part.
Replaces, Replaced By (REPLS, REPLD BY)	The part replaces and is interchangeable with, or is an alternate to, the original part.

VENDORS

0PTK6 SPS TECHNOLOGIES INC AEROSPACE PRODUCTS DIV
5195 W 4700 SPO BOX 18459
KEARNS, UTAH 84118

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

06725 AIR INDUSTRIES CORPORATION
12570 KNOTT STREET
GARDEN GROVE, CALIFORNIA 92641-3932
FORMERLY AIR INDUSTRIES OF CALIF IN GARDENA, CALIF.

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

08524 DEUTSCH FASTENER CORP SEE CODE V97928

11815 CHERRY AEROSPACE FASTENERS DIV OF TEXTRON
1224 EAST WARNER AVENUE PO BOX 2157
SANTA ANA, CALIFORNIA 92707-0157
FORMERLY IN LOS ANGELES, CALIF , FORMERLY CHERRY FASTENERS
TOWNSEND DIV OF TEXTRON INC V71087

15653 KAYNAR TECHNOLOGY KAYNAR DIV
800 SOUTH STATE COLLEGE BLVD PO BOX 3001
FULLERTON, CALIFORNIA 92634-3001
FORMERLY KAYNAR MICRODOT AEROSPACE FASTENING SYSTEM
FORMERLY MICRODOT INC AEROSP FASTENING SYS KAYNAR MFG DIV

27238 BRISTOL INDUSTRIES
630 EAST LAMBERT ROAD PO BOX 630
BREA, CALIFORNIA 92621-4119

5M902 FAIRCHILD IND INC FAIRCHILD AEROSPACE FASTENER DIV
3016 W LOMITA BLVD
TORRANCE, CALIFORNIA 90505-5103
FMLY IN REDONDO BEACH, CALIF

VENDORS

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

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

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

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

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

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

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
FORMERLY VOI-SHAN IN CULVER CITY, CALIF

VENDORS

97928 DEUTSCH FASTENER CORP
3969 PARAMONT BOULEVARD
LAKEWOOD, CALIFORNIA 90712-4193
FORMERLY DUMONT AVIATION ASSOC IN LONG BEACH, CALIFORNIA
FORMERLY LITTON FASTENING SYSTEMS DIV OF LITTON SYSTEMS INC
FORMERLY DUMONT AVIATION & SUPPLY CO, LONG BEACH, CA V85254

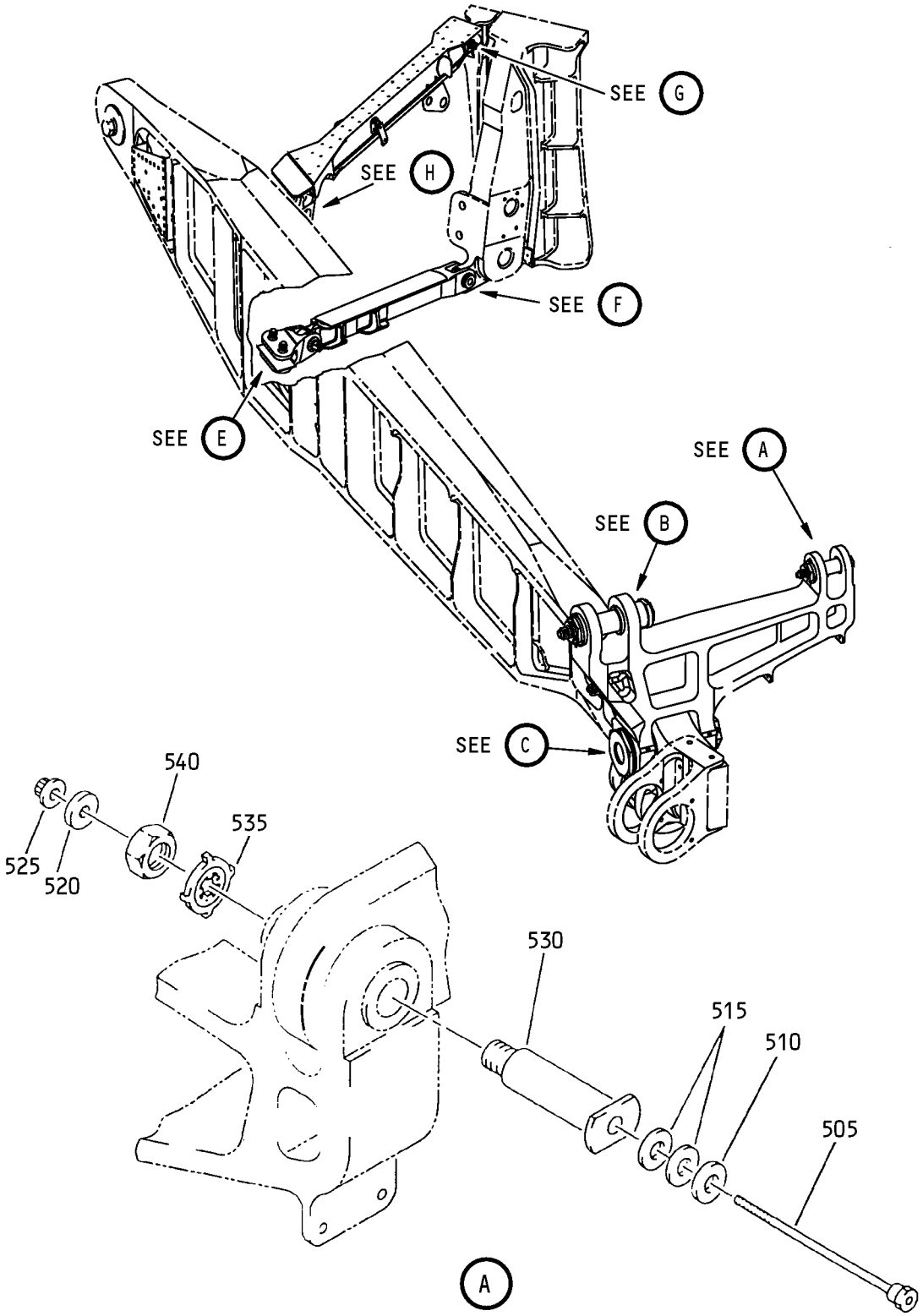
PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACB28AT12DO34C		1	785	2
BACB28AT12DO35C		4	85	2
BACB28AT16BO40C		3	10	2
BACB28AT19DO48C		3	15	2
BACB28AU10BO40C		4	90	2
BACB28AU16BO60C		3	20	2
BACB28W4CO12		4	125	1
BACB28W6CO12		4	120	1
BACB28X4CO12		4	125A	1
BACB30LE9K41		1	700	2
BACB30NX8K6		4	95	1
BACB30VT5HK14		1	665	2
BACB30VT5HK9		1	735	2
BACB30VT6K5		4	140	5
		4	195	2
		4	210	2
BACC30BH8		4	100	1
BACC30BL5		1	670	2
BACC30BL6		4	145	5
		4	200	2
		4	215	2
BACC30BS5S		1	740	2
BACN10HR9CD		1	715	2
BACN10KB3F		4	175	2
BACN10KE3B2CD		4	20	1
BACN10KE3B3CD		4	15	2
		4	75	12
BACN10KE3B4CD		4	25	6
BACN10KE3B5CD		4	50	13
BACN10KE3E3CD		4	70	2
BACN10KE3E5CD		4	45	2
BACN10YR4CD		1	630	4
BACR15BA3AD		4	10	18
		4	40	30
		4	65	28
		4	170	4
BACR15BA5AD		4	30	6

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACR15FT6KE4C		3	25	32
BACR15GF5D		4	105	1
BACS40R025E045		1	730	1
BACW10BN12UC		1	510	1
BACW10BN12UP		1	515	2
		1	685	2
BACW10BN24UC		1	550	1
BACW10BN4AC		1	620	4
BACW10BN8SP		1	770	1
BACW10BP10CD		1	765	1
BACW10BP16ACU		1	680	2
BACW10BP9CD		1	705	2
BACW10BP9DP		1	710	2
BH00303CM9		1	715	2
BMN10HRCWD3-9		1	715	2
BMN5024CWD3-9		1	715	2
BMN5024CWD39		1	715	2
BRFR120C3-3D		4	70	2
BRFR120C3-5D		4	45	2
BRFR220C3-2D		4	20	1
BRFR220C3-3D		4	15	2
		4	75	12
BRFR220C3-4D		4	25	6
BRFR220C3-5D		4	50	13
BRF100A3		4	175	2
CR60309		1	715	2
F2000-3		4	175	2
F51747-3-2CD		4	20	1
F51747-3-3CD		4	15	2
		4	75	12
F51747-3-4CD		4	25	6
F51747-3-5CD		4	50	13
F51751-3-3CD		4	70	2
F51751-3-5CD		4	45	2
HL1087-8		4	100	1
HL12VAZ8-6		4	95	1
HST10AG6-5		4	140	5
		4	195	2
		4	210	2

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
HST1094DU5		1	740	2
HST79-5		1	670	2
HST79-6		4	145	5
		4	200	2
		4	215	2
HST79CY5		1	670	2
HST79CY6		4	145	5
		4	200	2
		4	215	2
H51560		1	715	2
H52732-4CD		1	630	4
L802-8K6		4	95	1
MS15001-1		2	10	2
		3	5	1
NAS1149D0463J		1	625	4
NAS1149E1216R		1	690	2
NAS1805-14		1	560	1
NAS1805-9		1	525	1
NAS6704U13		1	615	4
NS103185-02		4	175	2
NS202493-02-2		4	20	1
NS202493-02-3		4	15	2
		4	75	12
NS202493-02-4		4	25	6
NS202493-02-5		4	50	13
NS202494-02-3		4	70	2
NS202494-02-5		4	45	2
PLH54CD		1	630	4
RMF9207-3		4	175	2
SL7108C9		1	715	2
T8114S1032S		4	175	2
VCU0005D9		1	715	2
VL310AG5-9		1	735	2
VN151A1-02		4	175	2
102A9213-2-3		4	20	1
102A9213-3-3		4	15	2
		4	75	12
102A9213-4-3		4	25	6
102A9213-5-3		4	50	13
102F9216-3-3		4	70	2

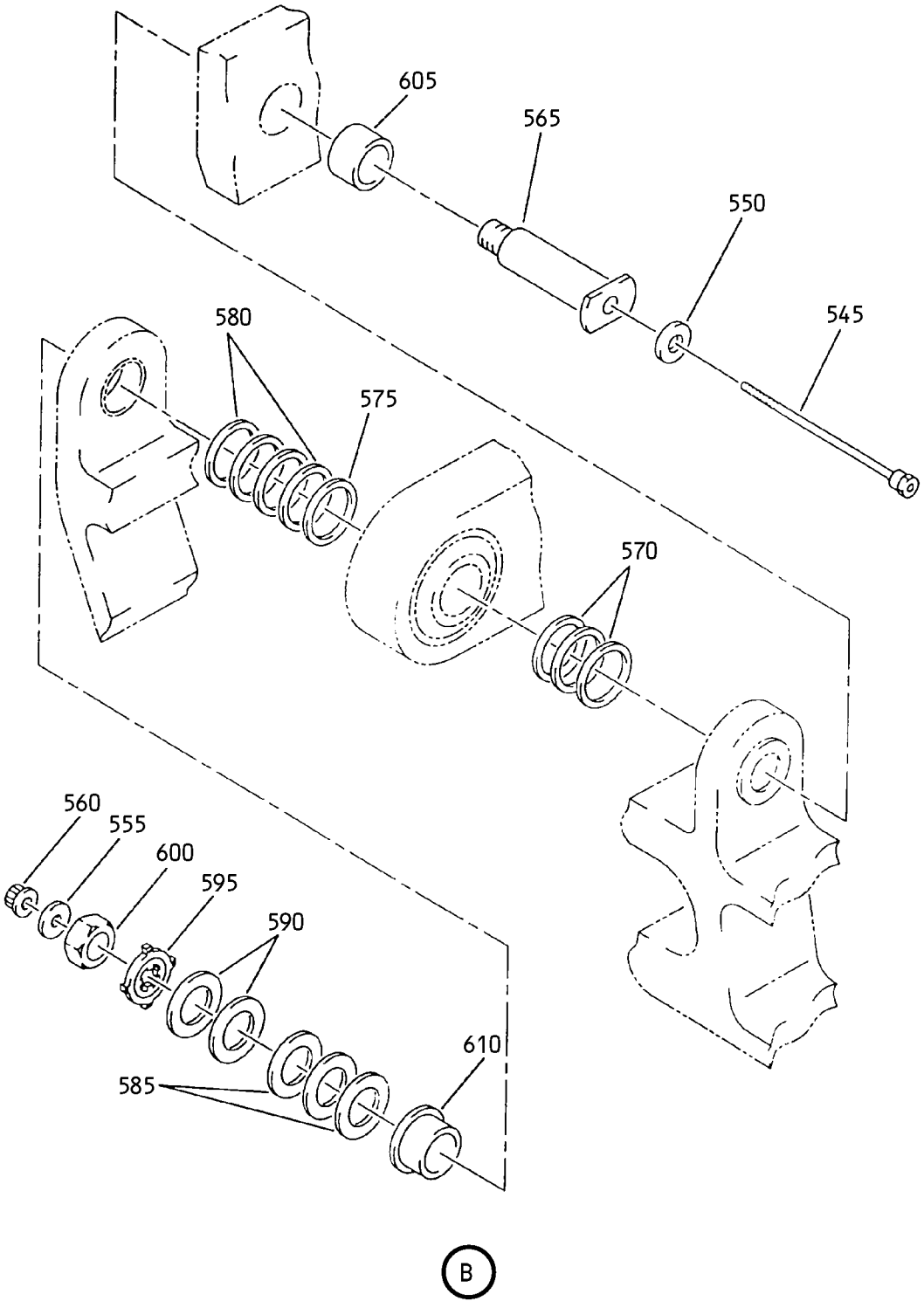
PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
102F9216-5-3		4	45	2
102LH9031-9		1	715	2
102LH90319		1	715	2
113T1105-17		1	570	3
		1	575	1
113T1105-18		1	580	4
113T1105-19		1	585	3
113T1105-20		1	590	2
113T1108-14		1	605	1
113T1108-15		1	610	1
113T1108-19		2	20	1
113T1108-30		2	15	2
113T1108-6		2	25	1
113T1108-7		2	30	1
113T1109-1		1	1A	RF
		2	1A	RF
113T1109-2		1	5	RF
		2	5	RF
113T1109-3		2	40	1
113T1109-4		2	45	1
113T1134-1		1	12	RF
		4	1A	RF
113T1134-2		1	14	RF
		4	5	RF
113T1134-3		4	225	1
113T1134-4		4	230	1
113T1134-5		4	60	1
113T1134-7		4	35	1
113T1134-9		4	55	1
		4	80	1
113T1136-1		1	10	RF
		3	1A	RF
113T1136-3		3	35	1
113T1136-5		3	30	1
113T1137-1		1	720	1
113T1137-2		1	725	1
113T1139-1		1	755	1
113T1139-2		1	760	1
113T1139-3		1	640	1
113T1139-4		1	645	8
113T1139-5		1	650	4
113T1139-6		1	655	4

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
113T1140-1		1	635	1
113T1140-2		1	675	2
113T1140-3		1	745	1
113T1140-4		1	750	1
113T1143-5		1	505	1
113T1143-6		1	545	1
113T1143-7		1	530	1
113T1143-8		1	565	1
113T1146-1		1	660	1
113T1146-2		1	775	1
113T1146-3		1	780	1
113T1146-4		1	695	2
113T1147-2		2	35	4
113T1147-7		1	790	2
113T1254-3		1	535	1
113T1254-36		1	520	1
113T1254-38		1	555	1
113T1254-7		1	595	1
113T1262-3		1	540	1
113T1262-5		1	600	1
113T1988-10		4	155	1
113T1988-9		4	150	1
272T1450-46		4	220	1
272T1451-7		4	205	1
272T1456-1		4	160	1
272T1456-2		4	165	1
272T1456-3		4	185	1
272T1456-4		4	190	1
272T1456-5		4	180	2
274T1104-20		4	130	1
274T1104-28		4	115	1
274T1104-30		4	135	1
274T1104-7		4	110	1
67832CD9		1	715	2
67832CD918		1	715	2



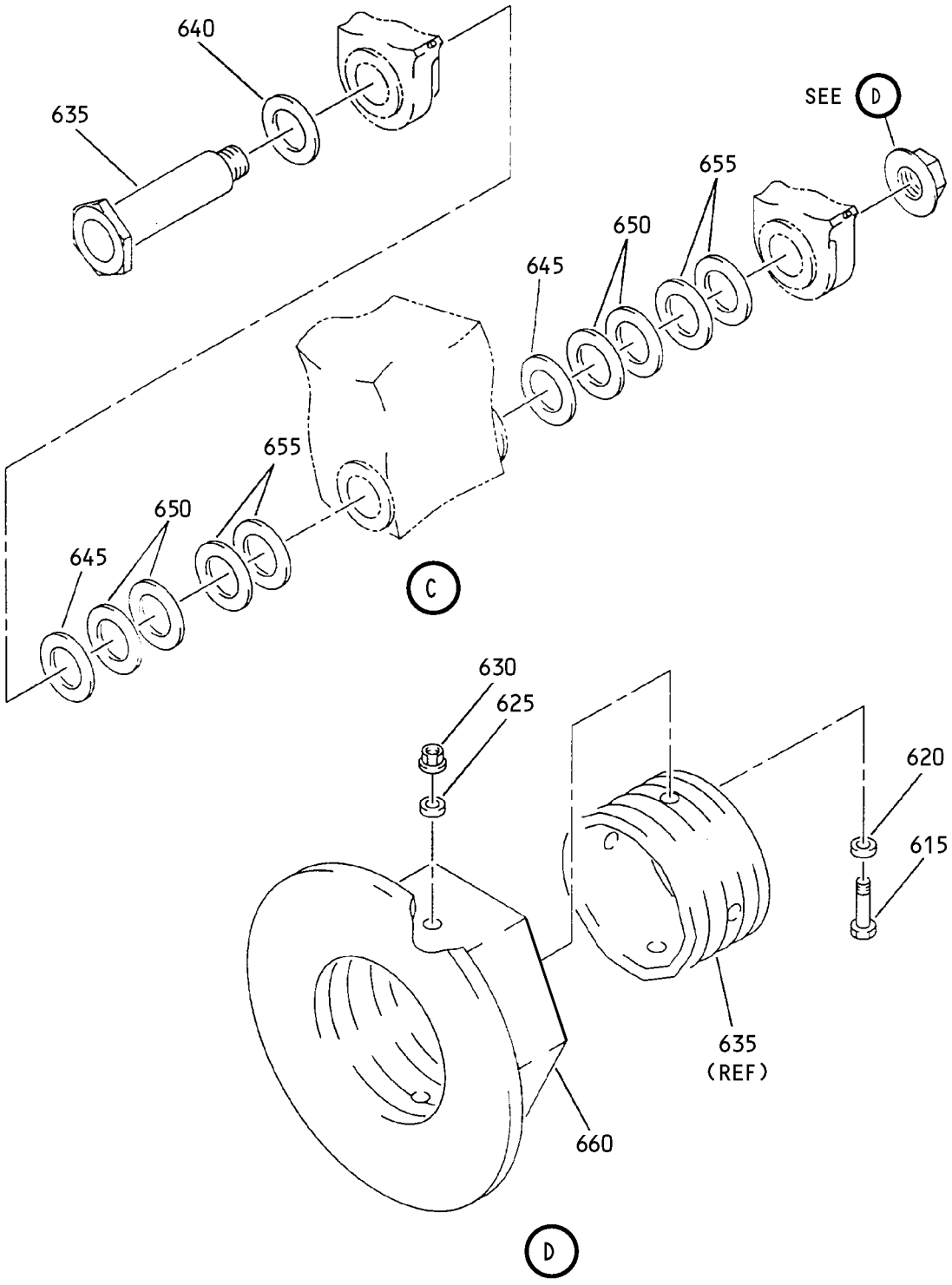
Main Landing Gear Beam - Installation Components
Figure 1 (Sheet 1)

K40048



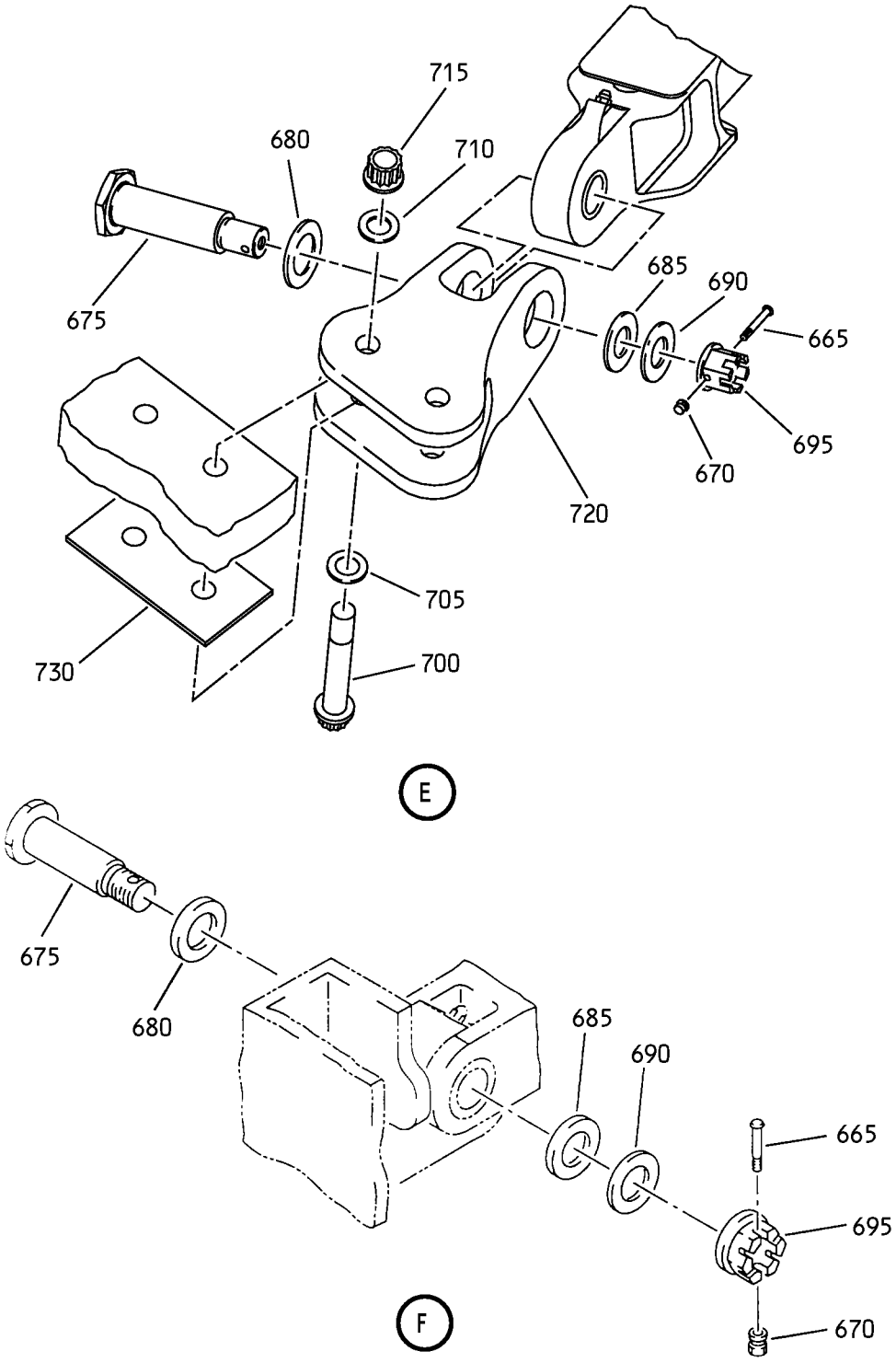
Main Landing Gear Beam - Installation Components
Figure 1 (Sheet 2)

K40058



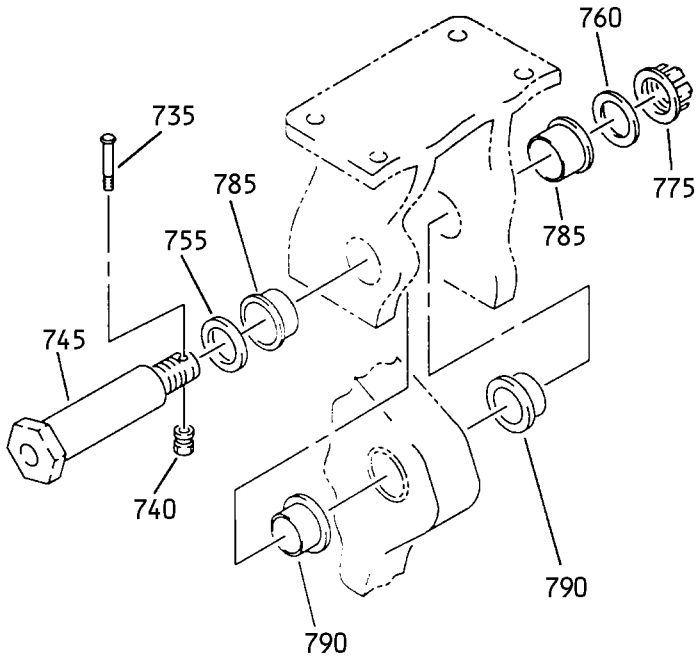
Main Landing Gear Beam - Installation Components
Figure 1 (Sheet 3)

K40080

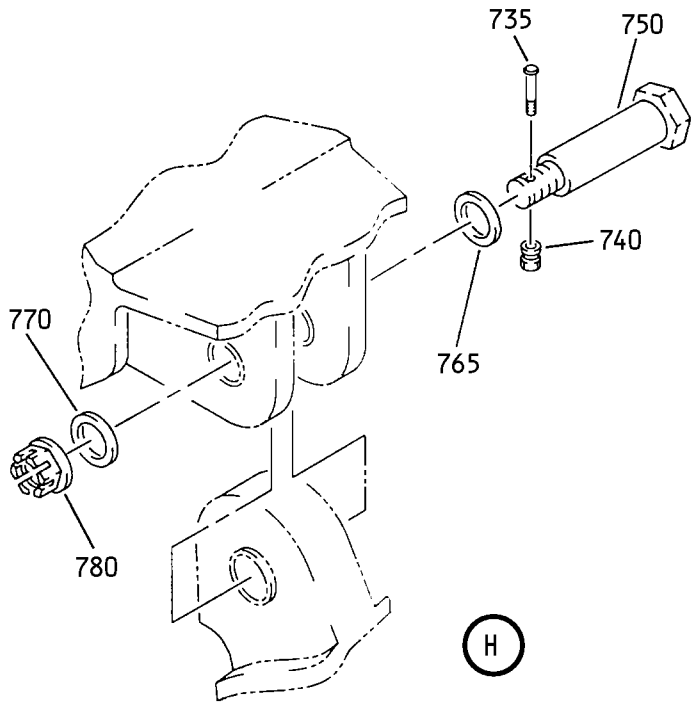


Main Landing Gear Beam - Installation Components
Figure 1 (Sheet 4)

K40096



G



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Main Landing Gear Beam - Installation Components
Figure 1 (Sheet 5)

K40152

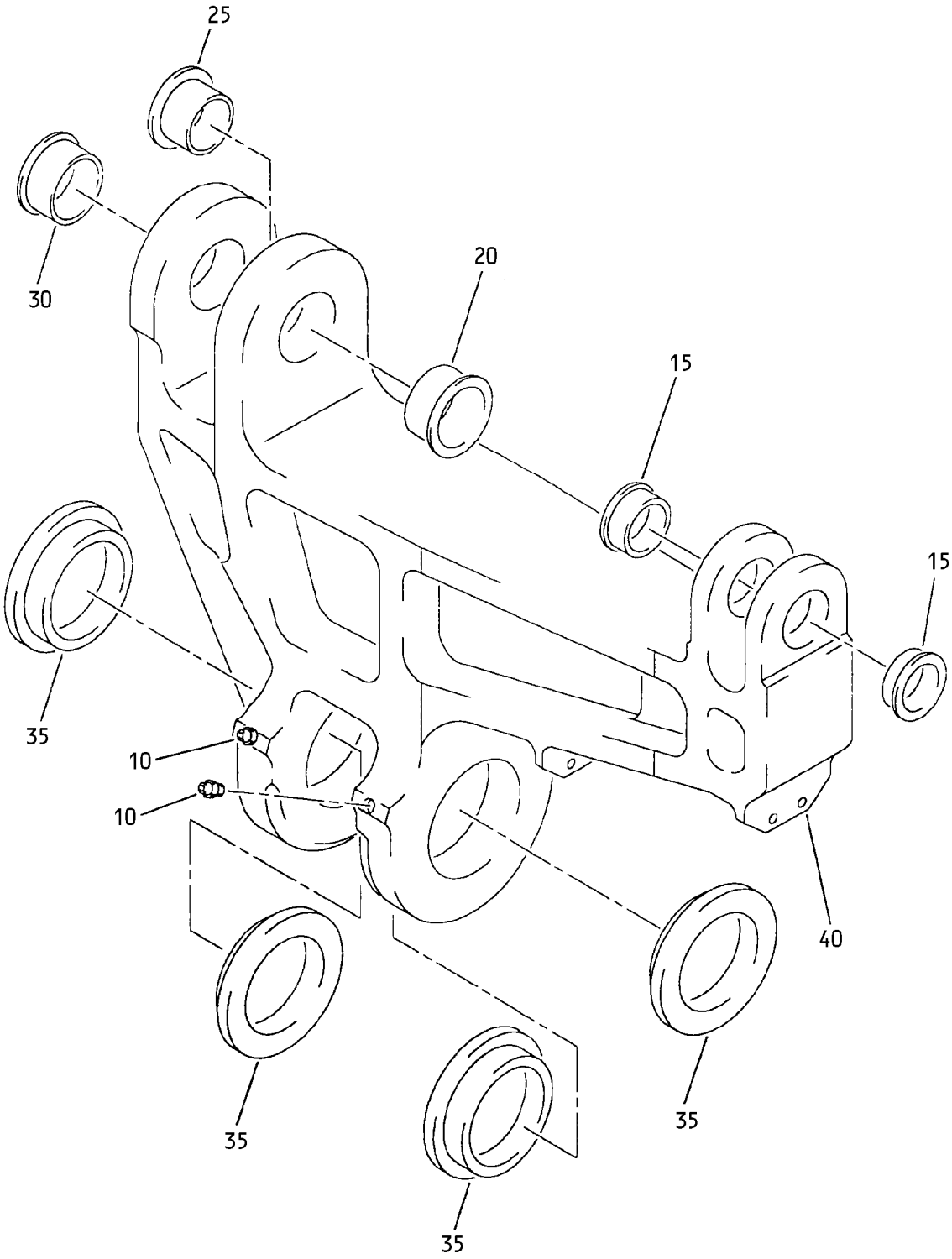
FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
			MAIN LANDING GEAR BEAM INSTALLATION COMPONENTS		
-1A	113T1109-1		LINK ASSY-HANGER (FOR DETAILS SEE FIG. 2)	A	RF
-5	113T1109-2		LINK ASSY-HANGER (FOR DETAILS SEE FIG. 2)	B	RF
-10	113T1136-1		BRACE ASSY-LWR STAB. (FOR DETAILS SEE FIG. 3)	C	RF
-12	113T1134-1		BRACE ASSY-UPR STAB. (FOR DETAILS SEE FIG. 4)	D	RF
-14	113T1134-2		BRACE ASSY-UPR STAB. (FOR DETAILS SEE FIG. 4)	E	RF
			INSTALLATION PARTS		
505	113T1143-5		PIN-INNER	A,B	1
510	BACW10BN12UC		WASHER	A,B	1
515	BACW10BN12UP		WASHER	A,B	AR
520	113T1254-36		WASHER	A,B	1
525	NAS1805-9		NUT	A,B	1
530	113T1143-7		PIN-OUTER	A,B	1
535	113T1254-3		WASHER	A,B	1
540	113T1262-3		NUT	A,B	1
545	113T1143-6		PIN-INNER	A,B	1
550	BACW10BN24UC		WASHER	A,B	1
555	113T1254-38		WASHER	A,B	1
560	NAS1805-14		NUT	A,B	1
565	113T1143-8		PIN-OUTER	A,B	1
570	113T1105-17		WASHER	A,B	3
575	113T1105-17		WASHER	A,B	AR
580	113T1105-18		WASHER	A,B	AR
585	113T1105-19		WASHER	A,B	AR
590	113T1105-20		WASHER	A,B	AR
595	113T1254-7		WASHER	A,B	1
600	113T1262-5		NUT	A,B	1
605	113T1108-14		BUSHING	A,B	1
610	113T1108-15		BUSHING	A,B	1
615	NAS6704U13		BOLT	A,B	4
620	BACW10BN4AC		WASHER	A,B	4

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
625	NAS1149D0463J		WASHER	A,B	4
630	H52732-4CD		NUT-	A,B	4
			(V15653)		
			(SPEC BACN10YR4CD)		
			(OPT PLH54CD		
			(V62554))		
635	113T1140-1		PIN	A,B	1
640	113T1139-3		WASHER	A,B	1
645	113T1139-4		WASHER	A,B	AR
650	113T1139-5		WASHER	A,B	AR
655	113T1139-6		WASHER	A,B	AR
660	113T1146-1		NUT	A,B	1
665	BACB30VT5HK14		BOLT	C	2
670	HST79CY5		COLLAR-	C	2
			(V73197)		
			(SPEC BACC30BL5)		
			(OPT HST79-5		
			(V92215))		
			(OPT HST79CY5		
			(V56878))		
			(OPT HST79CY5		
			(V5M902))		
675	113T1140-2		PIN	C	2
680	BACW10BP16ACU		WASHER	C	2
685	BACW10BN12UP		WASHER	C	2
690	NAS1149E1216R		WASHER	C	2
695	113T1146-4		NUT	C	2

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
700	BACB30LE9K41		BOLT	C	2
705	BACW10BP9CD		WASHER	C	2
710	BACW10BP9DP		WASHER	C	2
715	H51560-9		NUT-	C	2
			(V15653)		
			(SPEC BACN10HR9CD)		
			(OPT 67832CD918		
			(V56878))		
			(OPT BMN5024CWD3-9		
			(V97928))		
			(OPT 102LH9031-9		
			(V72962))		
			(OPT BH00303CM9		
			(V27238))		
			(OPT BMN10HRCWD3-9		
			(V97928))		
			(OPT BMN5024CWD39		
			(V97928))		
			(OPT CR60309		
			(V62554))		
			(OPT H51560		
			(V15653))		
			(OPT SL7108C9		
			(V11815))		
			(OPT VCU0005D9		
			(V06710))		
			(OPT 102LH90319		
			(V72962))		
			(OPT 67832CD9		
			(V56878))		
720	113T1137-1		FITTING-ATTACH	C	1
-725	113T1137-2		FITTING-ATTACH	C	1
730	BACS40R025E045		SHIM	C	1
735	VL310AG5-9		BOLT-	D,E	2
			(V97928)		
			(SPEC BACB30VT5HK9)		
			(OPT VL310AG5-9		
			(V9N513))		
			(OPT VL310AG5-9		
			(V06950))		

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
740	HST1094DU5		COLLAR- (V73197) (SPEC BACC30BS5S)	D,E	2
745	113T1140-3		PIN	D,E	1
750	113T1140-4		PIN	D,E	1
755	113T1139-1		WASHER	D,E	1
760	113T1139-2		WASHER	D,E	1
765	BACW10BP10CD		WASHER	D,E	1
770	BACW10BN8SP		WASHER	D,E	1
775	113T1146-2		NUT	D,E	1
780	113T1146-3		NUT	D,E	1
785	BACB28AT12D034C		BUSHING	D,E	2
790	113T1147-7		BUSHING	D,E	2

- Item Not Illustrated

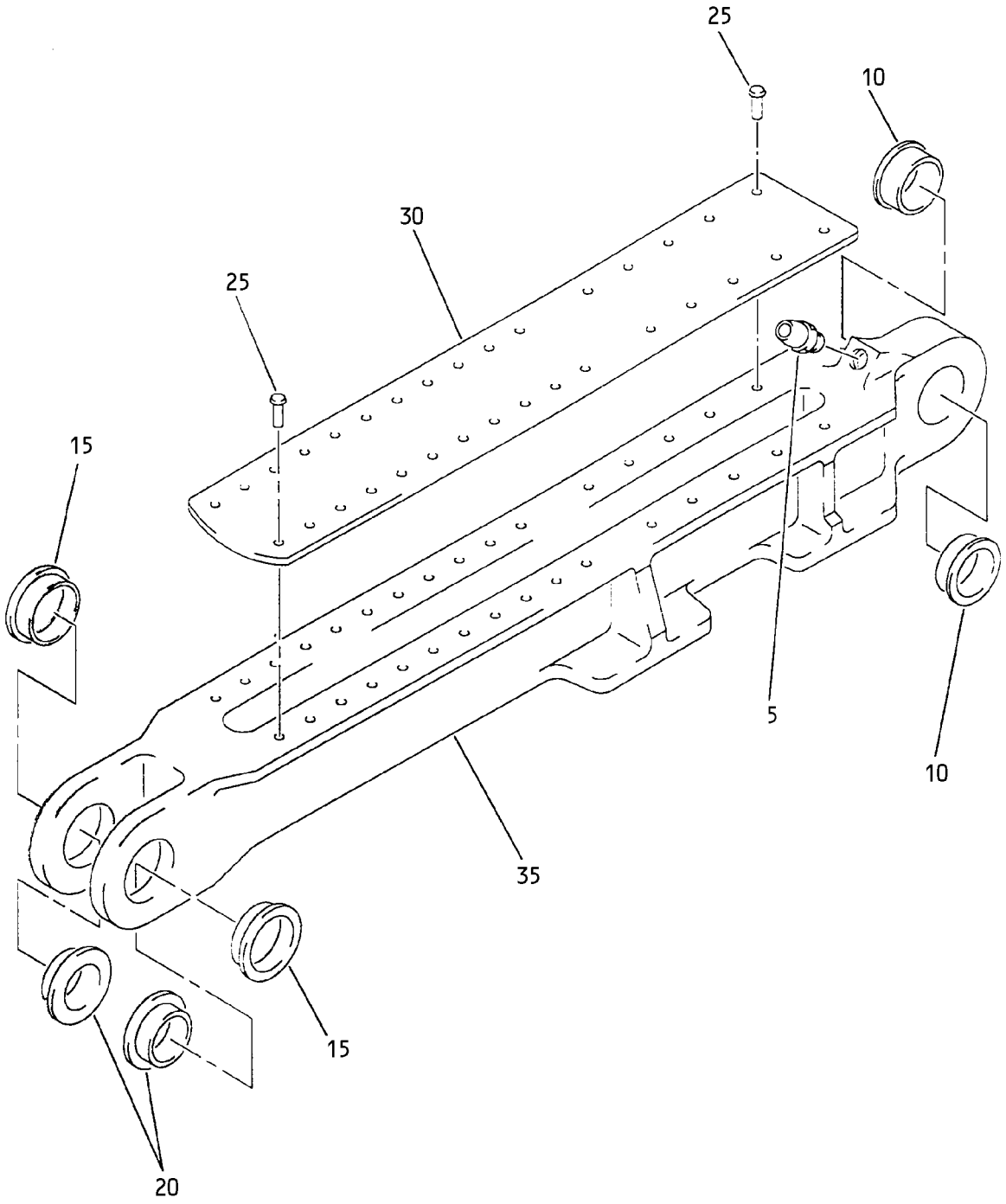


Main Landing Gear Beam - Lower Stabilizer Brace Assembly
Figure 2

K40169

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-					
-1A	113T1109-1		LINK ASSY-HANGER	A	RF
-5	113T1109-2		LINK ASSY-HANGER	B	RF
10	MS15001-1		.FITTING	A,B	2
15	113T1108-30		.BUSHING	A,B	2
20	113T1108-19		.BUSHING	A,B	1
25	113T1108-6		.BUSHING	A,B	1
30	113T1108-7		.BUSHING	A,B	1
35	113T1147-2		.BUSHING	A,B	4
40	113T1109-3		.LINK	A	1
-45	113T1109-4		.LINK	B	1

- Item Not Illustrated

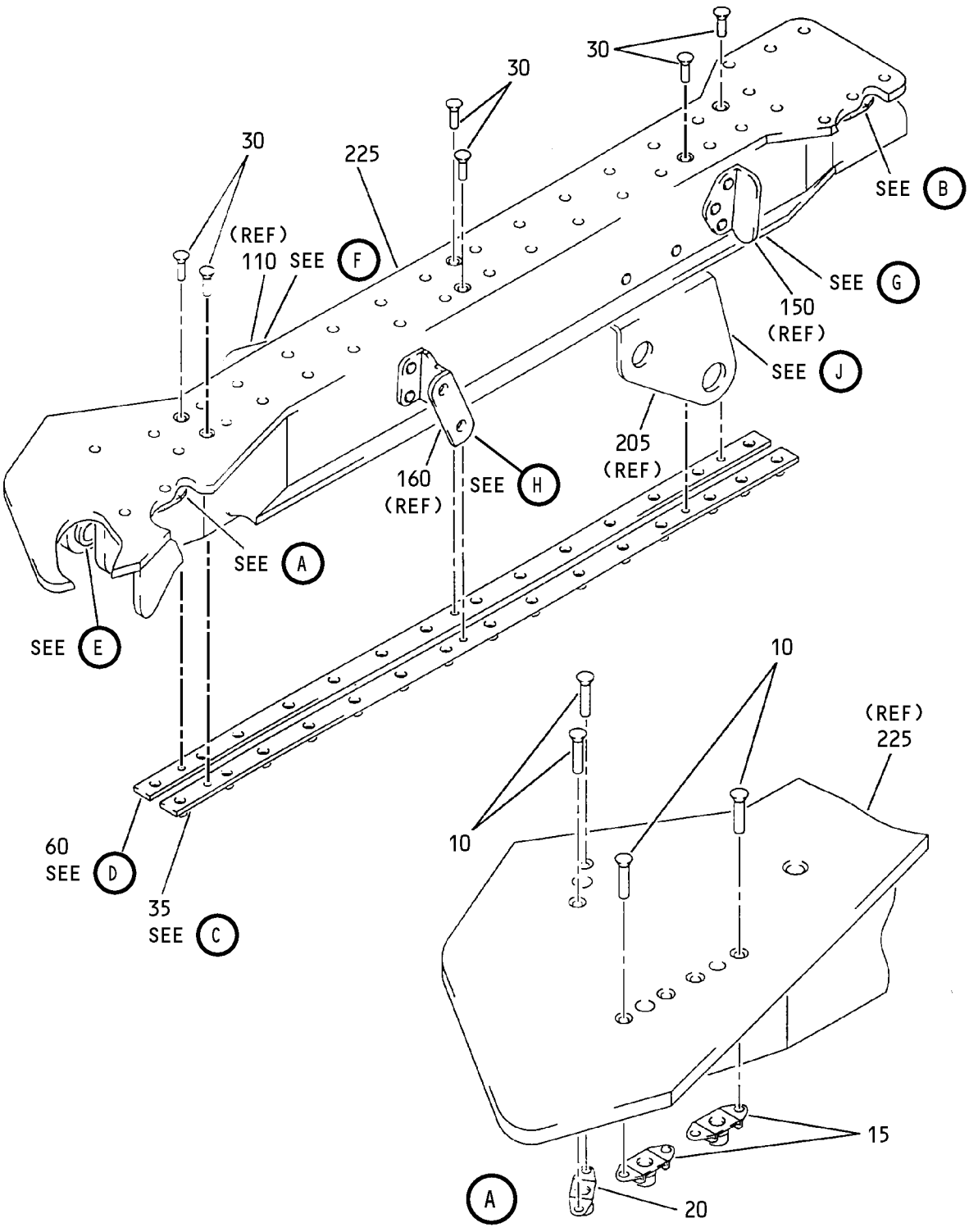


Main Landing Gear Beam - Lower Stabilizer Brace Assembly
Figure 3

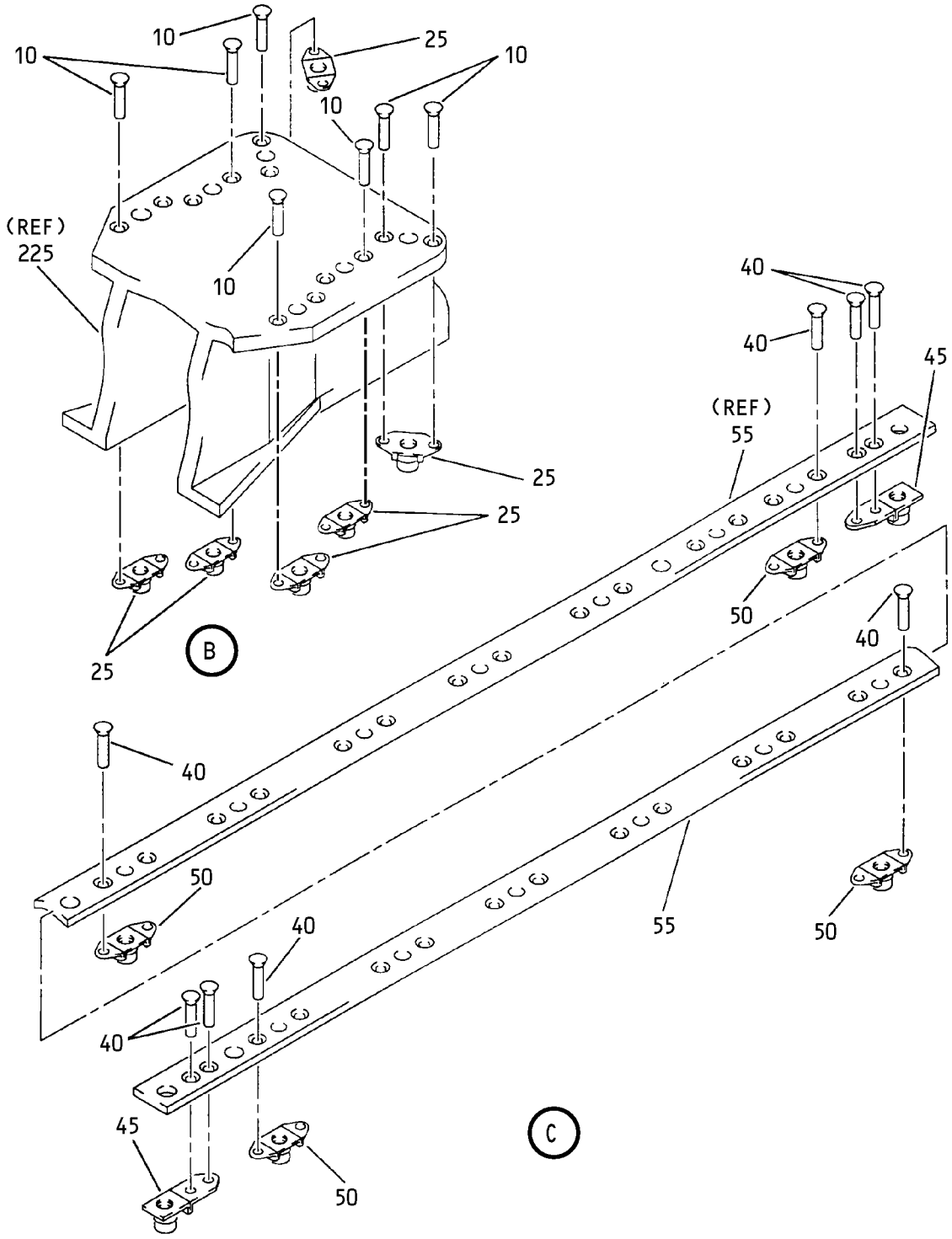
K40184

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
03-					
-1A	113T1136-1		BRACE ASSY	C	RF
5	MS15001-1		.FITTING	C	1
10	BACB28AT16B040C		.BUSHING	C	2
15	BACB28AT19D048C		.BUSHING	C	2
20	BACB28AU16B060C		.BUSHING	C	2
25	BACR15FT6KE4C		.RIVET	C	32
30	113T1136-5		.PLATE	C	1
35	113T1136-3		.BRACE	C	1

- Item Not Illustrated

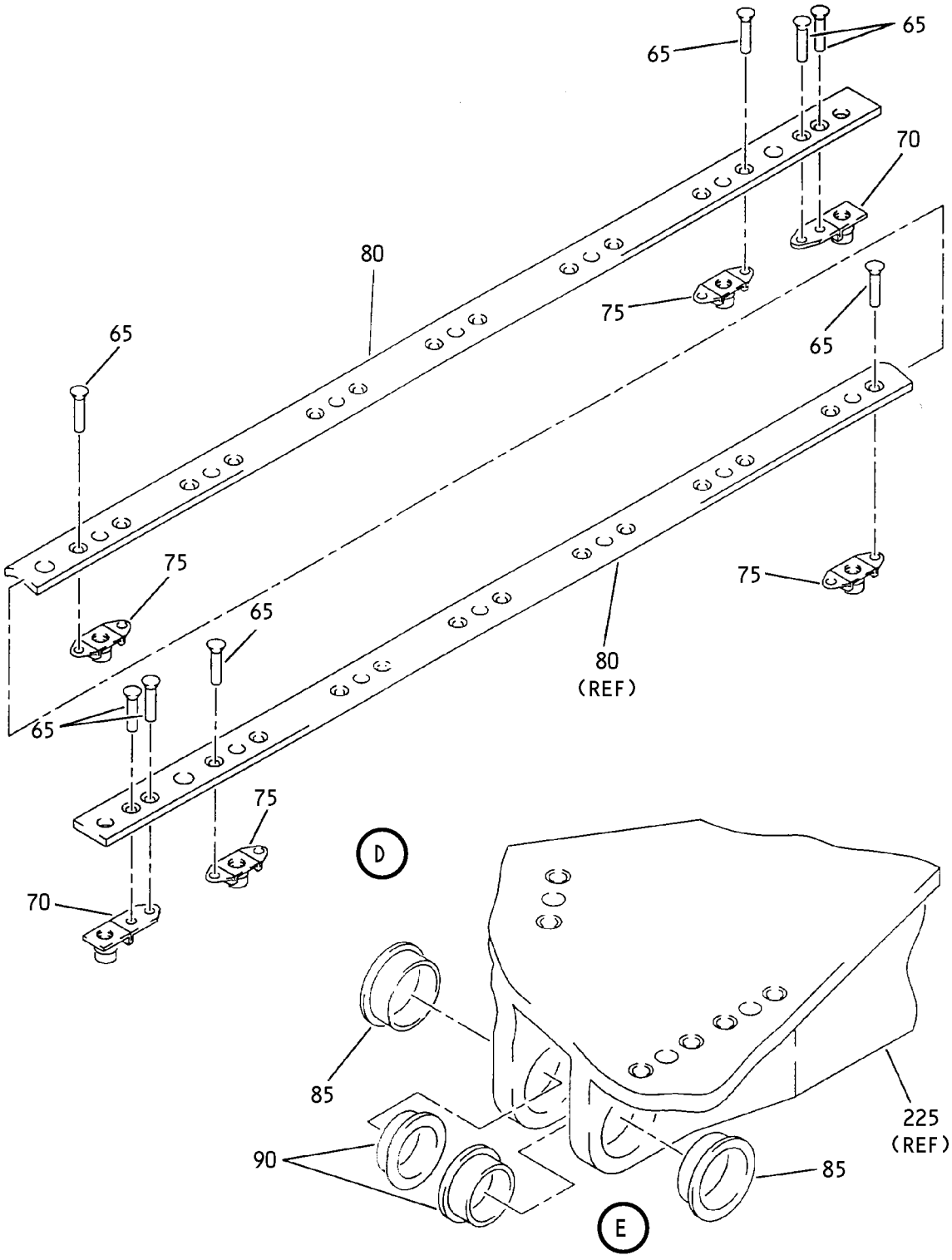


Main Landing Gear Beam - Upper Stabilizer Brace Assembly
Figure 4 (Sheet 1)



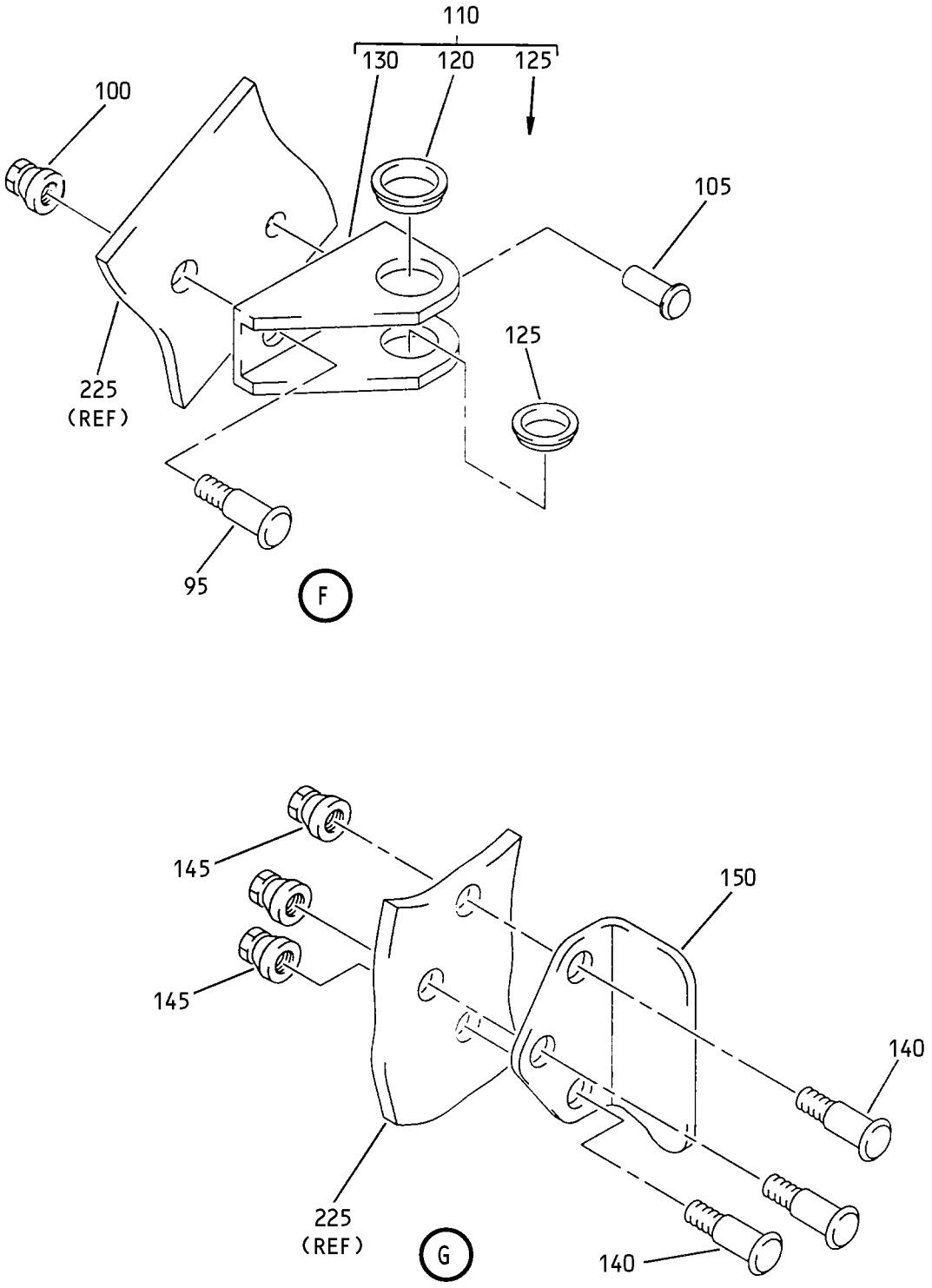
Main Landing Gear Beam - Upper Stabilizer Brace Assembly
Figure 4 (Sheet 2)

K40243



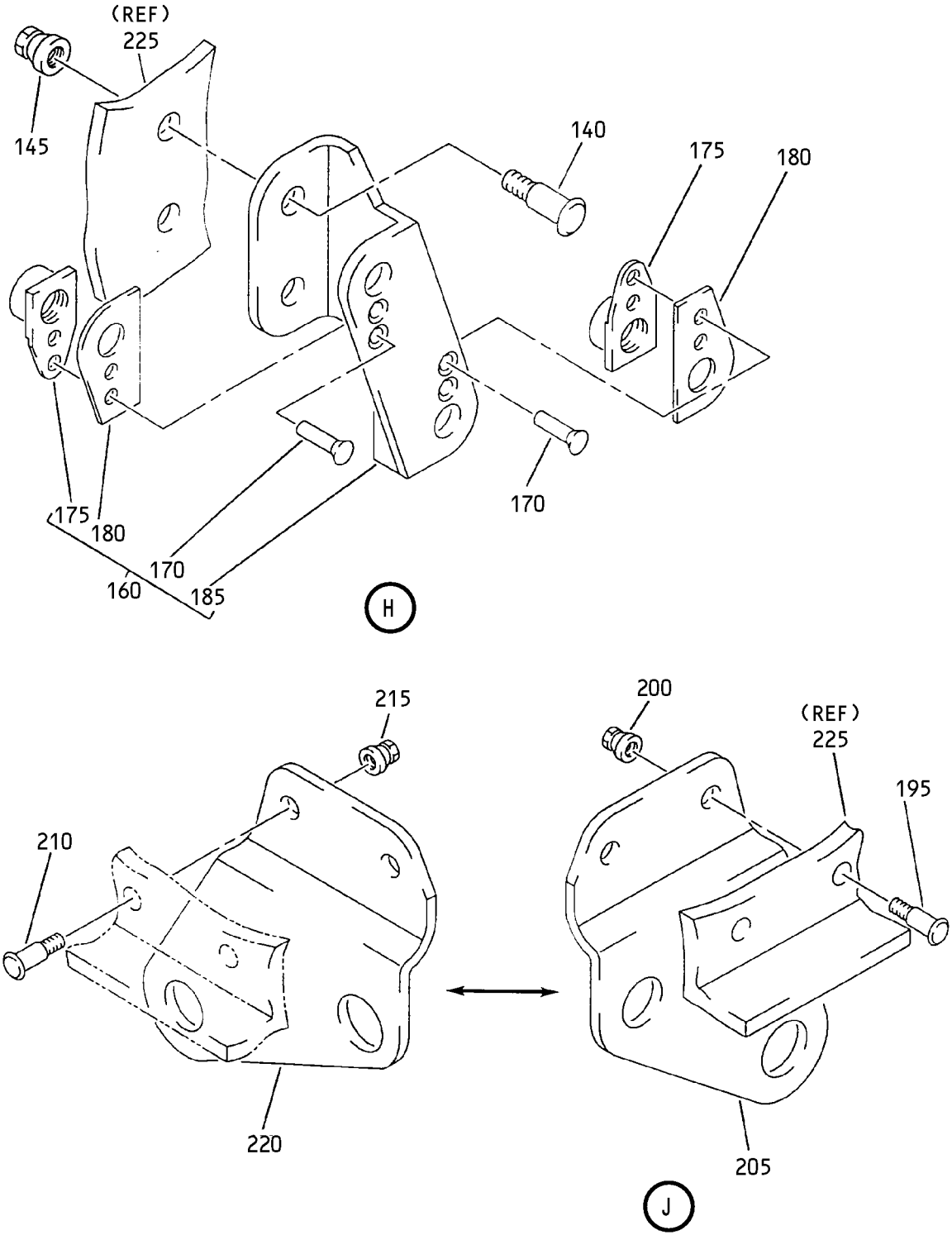
Main Landing Gear Beam - Upper Stabilizer Brace Assembly
Figure 4 (Sheet 3)

K40370



Main Landing Gear Beam - Upper Stabilizer Brace Assembly
Figure 4 (Sheet 4)

K40381



Main Landing Gear Beam - Upper Stabilizer Brace Assembly
Figure 4 (Sheet 5)

K40390

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
04-					
-1A	113T1134-1		BRACE ASSY-UPR STAB.	D	RF
-5	113T1134-2		BRACE ASSY-UPR STAB.	E	RF
10	BACR15BA3AD		.RIVET- (SIZE DETERMINE ON INST)	D,E	18
15	NS202493-02-3		.NUTPLATE- (V80539) (SPEC BACN10KE3B3CD) (OPT F51747-3-3CD (V15653)) (OPT 102A9213-3-3 (V72962)) (OPT BRFR220C3-3D (V52828))	D,E	2
20	NS202493-02-2		.NUTPLATE- (V80539) (SPEC BACN10KE3B2CD) (OPT F51747-3-2CD (V15653)) (OPT 102A9213-2-3 (V72962)) (OPT BRFR220C3-2D (V52828))	D,E	1
25	NS202493-02-4		.NUTPLATE- (V80539) (SPEC BACN10KE3B4CD) (OPT F51747-3-4CD (V15653)) (OPT 102A9213-4-3 (V72962)) (OPT BRFR220C3-4D (V52828))	D,E	6
30	BACR15BA5AD		.RIVET- (SIZE DETERMINE ON INST)	D,E	6
35	113T1134-7		.STRIP ASSY	D,E	1
40	BACR15BA3AD		..RIVET- (SIZE DETERMINE ON INST)	D,E	30

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
04-					
45	NS202494-02-5		..NUTPLATE- (V80539) (SPEC BACN10KE3E5CD) (OPT 102F9216-5-3 (V72962)) (OPT F51751-3-5CD (V15653)) (OPT BRFR120C3-5D (V52828))	D,E	2
50	NS202493-02-5		..NUTPLATE- (V80539) (SPEC BACN10KE3B5CD) (OPT F51747-3-5CD (V15653)) (OPT 102A9213-5-3 (V72962)) (OPT BRFR220C3-5D (V52828))	D,E	13
55	113T1134-9		..STRIP	D,E	1
60	113T1134-5		.STRIP ASSY	D,E	1
65	BACR15BA3AD		..RIVET- (SIZE DETERMINE ON INST)	D,E	28
70	F51751-3-3CD		..NUTPLATE- (V15653) (SPEC BACN10KE3E3CD) (OPT 102F9216-3-3 (V72960)) (OPT BRFR120C3-3D (V52828)) (OPT NS202494-02-3 (V80539))	D,E	2
75	NS202493-02-3		..NUTPLATE- (V80539) (SPEC BACN10KE3B3CD) (OPT F51747-3-3CD (V15653)) (OPT 102A9213-3-3 (V72962)) (OPT BRFR220C3-3D (V52828))	D,E	12

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
04-					
80	113T1134-9		..STRIP	D,E	1
85	BACB28AT12D035C		.BUSHING	D,E	2
90	BACB28AU10B040C		.BUSHING	D,E	2
95	HL12VAZ8-6		.BOLT- (V56878) (SPEC BACB30NX8K6) (OPT HL12VAZ8-6 (V73197)) (OPT HL12VAZ8-6 (V92215)) (OPT HL12VAZ8-6 (V97928)) (OPT L802-8K6 (V06725)) (OPT HL12VAZ8-6 (V08524))	D,E	1
100	HL1087-8		.COLLAR- (V56878) (SPEC BACC30BH8) (OPT HL1087-8 (V92215)) (OPT HL1087-8 (V73197)) (OPT HL1087-8 (V9N513))	D,E	1
105	BACR15GF5D		.RIVET- (SIZE DETERMINE ON INST)	D,E	1
110	274T1104-7		.BRACKET ASSY	D	1
-115	274T1104-28		.BRACKET ASSY	E	1
120	BACB28W6C012		..BUSHING	D,E	1
125	BACB28W4C012		..BUSHING- (OPT ITEM 125A)	D,E	1
-125A	BACB28X4C012		..BUSHING- (OPT ITEM 125)	D,E	1
130	274T1104-20		..BRACKET	D	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
04-					
-135	274T1104-30		..BRACKET	E	1
140	HST10AG6-5		.BOLT-	D,E	5
			(V0PTK6)		
			(SPEC BACB30VT6K5)		
			(OPT HST10AG6-5		
			(V06725))		
			(OPT HST10AG6-5		
			(V56878))		
			(OPT HST10AG6-5		
			(V73197))		
145	HST79CY6		.COLLAR-	D,E	5
			(V73197)		
			(SPEC BACC30BL6)		
			(OPT HST79-6		
			(V92215))		
			(OPT HST79CY6		
			(V56878))		
			(OPT HST79CY6		
			(V5M902))		
150	113T1988-9		.BRACKET	D	1
-155	113T1988-10		.BRACKET	E	1
160	272T1456-1		.BRACKET ASSY	D	1
-165	272T1456-2		.BRACKET ASSY	E	1
170	BACR15BA3AD		..RIVET-	D,E	4
			(SIZE DETERMINE ON INST)		
175	BRF100A3		..NUTPLATE-	D,E	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
04-					
180	272T1456-5		..FILLER	D,E	2
185	272T1456-3		..BRACKET	D	1
-190	272T1456-4		..BRACKET	E	1
195	HST10AG6-5		.BOLT- (V0PTK6) (SPEC BACB30VT6K5) (OPT HST10AG6-5 (V06725)) (OPT HST10AG6-5 (V56878)) (OPT HST10AG6-5 (V73197))	D	2
200	HST79CY6		.COLLAR- (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V92215)) (OPT HST79CY6 (V56878)) (OPT HST79CY6 (V5M902))	D	2
205	272T1451-7		.BRACKET	D	1
210	HST10AG6-5		.BOLT- (V0PTK6) (SPEC BACB30VT6K5) (OPT HST10AG6-5 (V06725)) (OPT HST10AG6-5 (V56878)) (OPT HST10AG6-5 (V73197))	E	2
215	HST79CY6		.COLLAR- (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V92215)) (OPT HST79CY6 (V56878)) (OPT HST79CY6 (V5M902))	E	2

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
04-					
220	272T1450-46		.BRACKET	E	1
225	113T1134-3		.BRACE	D	1
-230	113T1134-4		.BRACE	E	1

- Item Not Illustrated