

 **BOEING**
COMPONENT
MAINTENANCE MANUAL

TO: ALL HOLDERS OF OUTBOARD SPOILER ASSEMBLY COMPONENT MAINTENANCE MANUAL
57-70-51

REVISION NO. 13 DATED NOV 01/00

HIGHLIGHTS

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

CHAPTER/SECTION

AND PAGE NO.

DESCRIPTION OF CHANGE

TITLE PAGE

Incorporated PRR B13100-2, which added top assembly part numbers 113T5102-22SP and -23.

1

REPAIR 4-1

601-602

702

1003-1012,1017-1032,

1037-1051

TR & SB RECORD

Incorporated MC1110MP6141, which added top assembly part number 113T5102-21.

1

REPAIR 4-1

601-602

702-703

1003-1012,1017-1032,

1037-1051

57-70-51

HIGHLIGHTS

01.1

Page 1

Nov 01/00

OUTBOARD SPOILER ASSEMBLY

PART NUMBERS 113T5102-1SP,-9,-10SP,-13,-14,-15,
-17,-18,-19,-21,-22SP,-23
113T5003-5

COMPONENT MAINTENANCE MANUAL
WITH
ILLUSTRATED PARTS LIST

57-70-51

TITLE PAGE

Page 1

Nov 01/00

01.1

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

TEMPORARY REVISION AND SERVICE BULLETIN RECORD

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVE	DATE OF INCORPORATION INTO MANUAL
SB 11-0016 SB 27-0080R1		PRR B11528 PRR B11659 PRR B11528-3 PRR B13100-2 MC 1110MP6141	JUL 10/87 JUL 10/87 JAN 01/88 JUL 01/91 JUL 01/91 NOV 01/00 NOV 01/00

57-70-51

TR & SB RECORD

01.1

Page 1

Nov 01/00



BOEING
COMPONENT
MAINTENANCE MANUAL

PAGE	DATE	CODE	PAGE	DATE	CODE
57-70-51			REPAIR-GENERAL		
TITLE PAGE			601	JUL 01/91	01.1
*1	NOV 01/00	01.1	602	JUL 01/91	01.1
2	BLANK		603	JUL 01/91	01.1
REVISION RECORD			604	BLANK	
1	JUL 01/91	01.1	REPAIR 1-1		
2	BLANK		601	JUL 01/91	01.1
TR & SB RECORD			602	JUL 01/91	01.1
*1	NOV 01/00	01.1	REPAIR 2-1		
2	BLANK		601	JUL 01/91	01.1
LIST OF EFFECTIVE PAGES			602	JUL 01/91	01.1
*1	NOV 01/00	01	REPAIR 3-1		
THRU LAST PAGE			601	JUL 01/91	01.1
CONTENTS			602	BLANK	
1	JUL 01/91	01.1	REPAIR 4-1		
2	BLANK		*601	NOV 01/00	01.1
INTRODUCTION			*602	NOV 01/00	01.1
1	JUL 01/91	01.1	ASSEMBLY		
2	BLANK		701	JUL 01/91	01.1
DESCRIPTION & OPERATION			*702	NOV 01/00	01.1
1	JUL 01/91	01.1	*703	NOV 01/00	01.1
2	BLANK		704	BLANK	
DISASSEMBLY			FITS AND CLEARANCES		
301	JUL 01/91	01.1	801	JUL 01/91	01.1
302	BLANK		802	JUL 01/91	01.1
CLEANING			ILLUSTRATED PARTS LIST		
401	JUL 01/91	01.1	1001	JUL 01/91	01.1
402	BLANK		1002	JUL 01/91	01.1
CHECK			*1003	NOV 01/00	01.1
501	MAR 01/99	01.1	*1004	NOV 01/00	01.1
502	BLANK		*1005	NOV 01/00	01.1
			*1006	NOV 01/00	01.1
			*1007	NOV 01/00	01.1
			*1008	NOV 01/00	01.1
			*1009	NOV 01/00	01.1
			*1010	NOV 01/00	01.1

* = REVISED, ADDED OR DELETED

57-70-51

EFFECTIVE PAGES
CONTINUED Page 1
01 Nov 01/00

PAGE	DATE	CODE	PAGE	DATE	CODE
ILLUSTRATED PARTS LIST		CONT.			
*1011	NOV 01/00	01.1			
*1012	NOV 01/00	01.1			
*1013	NOV 01/00	01.1			
*1014	NOV 01/00	01.1			
*1015	NOV 01/00	01.1			
*1016	NOV 01/00	01.1			
*1017	NOV 01/00	01.1			
*1018	NOV 01/00	01.1			
*1019	NOV 01/00	01.1			
*1020	NOV 01/00	01.1			
*1021	NOV 01/00	01.1			
*1022	NOV 01/00	01.1			
*1023	NOV 01/00	01.1			
*1024	NOV 01/00	01.1			
*1025	NOV 01/00	01.1			
*1026	NOV 01/00	01.1			
*1027	NOV 01/00	01.1			
*1028	NOV 01/00	01.1			
*1029	NOV 01/00	01.1			
*1030	NOV 01/00	01.1			
*1031	NOV 01/00	01.1			
*1032	NOV 01/00	01.1			
*1033	NOV 01/00	01.1			
*1034	NOV 01/00	01.1			
*1035	NOV 01/00	01.1			
*1036	NOV 01/00	01.1			
*1037	NOV 01/00	01.1			
*1038	NOV 01/00	01.1			
*1039	NOV 01/00	01.1			
*1040	NOV 01/00	01.1			
*1041	NOV 01/00	01.1			
*1042	NOV 01/00	01.1			
*1043	NOV 01/00	01.1			
*1044	NOV 01/00	01.1			
*1045	NOV 01/00	01.1			
*1046	NOV 01/00	01.1			
*1047	NOV 01/00	01.1			
*1048	NOV 01/00	01.1			
*1049	NOV 01/00	01.1			
*1050	NOV 01/00	01.1			
*1051	NOV 01/00	01.1			
*1052	BLANK				

* = REVISED, ADDED OR DELETED

57-70-51

EFFECTIVE PAGES
 LAST PAGE Page 2
 01 Nov 01/00

TABLE OF CONTENTS

<u>Paragraph Title</u>	<u>Page</u>
Description and Operation.	1
Testing/Trouble Shooting (Not applicable)	
Disassembly.	301
Cleaning	401
Check.	501
Repair	601
Assembly	701
Fits and Clearances.	801
Special Tools (Not applicable)	
Illustrated Parts List	1001

INTRODUCTION

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

This manual is divided into separate sections:

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

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

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

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

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

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

Verification:

Assembly 10/10/85

57-70-51

INTRODUCTION

01.1

Page 1

Jul 01/91

OUTBOARD SPOILER ASSEMBLY

DESCRIPTION AND OPERATION

1. Description and Operation

A. The outboard spoiler assembly is composed of a graphite/epoxy panel bond assembly, two side hinge fitting assemblies, one center hinge fitting assembly, an actuator hinge fitting assembly, seal, and rub strip. In flight, the outboard spoiler assembly is primarily used to augment lateral control of the airplane. It also serves as an aid to the speed brake spoilers during landing operations.

2. Leading Particulars (Approximate)

Length -- 60 inches
Width -- 28 inches
Height -- 3 inches
Weight -- 96 pounds

57-70-51

DESCRIPTION & OPERATION

01.1

Page 1

Jul 01/91

DISASSEMBLY

1. Use standard industry practices for disassembly of this component and additional procedures in following step.
2. Note thickness and location of shims (40, 55, 70, 155, 210, IPL Fig. 1; 75, 80, 85, 155, 235, IPL Fig. 2) for reference during assembly.
3. Refer to 20-10-08 for instructions on removal of fay surface sealed components.

57-70-51

DISASSEMBLY

01.1

Page 301

Jul 01/91

CLEANING

CAUTION: DO NOT VAPOR DEGREASE GRAPHITE/ARAMID EPOXY STRUCTURES WITH CHLORINATED CLEANING AGENTS SUCH AS METHYLENE CHLORIDE, TRICHLOROETHYLENE, AND TRICHLOROETHANE. CHLORINATED CLEANING AGENTS WILL CAUSE DAMAGE TO GRAPHITE /ARAMID EPOXY STRUCTURES.

1,1,1-TRICHLOROETHANE IS ONE OF THE SOLVENTS ALLOWED FOR CLEANING COMPOSITE COMPONENTS. DO NOT SUBMERGE PARTS IN THE SOLVENT OR ALLOW STANDING SOLVENT ON THE PARTS OR DAMAGE MAY OCCUR. USE 1,1,1-TRICHLOROETHANE ONLY AS A WIPE SOLVENT.

1. Clean all parts in accordance with standard industry practices (Ref 20-30-03) except for graphite/aramid epoxy bonded panel assembly (245, IPL Fig. 1; 250, IPL Fig. 2).

57-70-51

01.1
CLEANING
Page 401
Jul 01/91

CHECK

1. Do a visual check for any obvious damage on all visible parts according to standard industry practices. Do the magnetic particle check or penetrant check if the visual check shows possible damage on the parts.
2. Penetrant check per 20-20-02 -- Fittings (85, 175, 235, IPL Fig. 1; 70, 175, 230, IPL Fig. 2).
3. Check the honeycomb and bonded parts for evidence of delamination, internal water, scratches, and contour defects.
 - A. If you see delamination or impact damage on a visual check, do an ultrasonic inspection or a tap test to find all of the damage.

NOTE: For the tap test, use a solid metal disk and tap the surface area lightly but firmly. Void areas will produce a dull sound as opposed to a sharp ring on a solid bonded area. Refer to 767 Nondestructive Test Manual, Part 1, 51-05-01.
 - B. Examine areas suspected of containing water radiographically or by thermography as shown in the 767 Nondestructive Test Manual, Part 9, 51-00-01.
4. Refer to 767 Structural Repair Manual, 57-70-01 and 57-70-02, for allowable damage and repair instructions.
5. Refer to the FITS AND CLEARANCES section for allowable wear/rework information.
6. Make sure you can read the warning notes. See Assembly, Fig. 702.

57-70-51

CHECK

01.1

Page 501

Mar 01/99

REPAIR – GENERAL

1. Content

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

<u>P/N</u>	<u>NAME</u>	<u>REPAIR</u>
113T5126	HINGE FITTING ASSY	1-1
113T5127	ACTUATOR FITTING ASSY	2-1
113T5128	HINGE FITTING ASSY	3-1
- -	MISCELLANEOUS PARTS	4-1

2. Standard Practices

- A. Refer to the following standard practices, as applicable, for details of procedures in individual repairs.

- 20-10-02 Machining of Alloy Steels
- 20-10-03 Shot Peening
- 20-10-06 Repair of Conductive Coatings
- 20-20-02 Penetrant Methods of Inspection
- 20-30-02 Stripping of Protective Finishes
- 20-30-03 General Cleaning Procedures
- 20-41-01 Decoding Table for Boeing Finish Codes
- 20-41-02 Application of Chemical and Solvent Resistant Finishes
- 20-42-05 Bright Cadmium Plating
- 20-43-01 Chromic Acid Anodizing
- 20-50-03 Bearing Installation and Retention
- 20-60-02 Finishing Materials
- 20-60-04 Miscellaneous Materials

3. Materials

NOTE: Equivalent substitutes may be used.

- A. Conditioner, static -- 28-C-1 (Ref 20-60-04)
- B. Enamel -- BMS 10-60, BAC707 gray gloss (Ref 20-60-02)
- C. Primer (Ref 20-60-02)
 - (1) BMS 10-11 type 1
 - (2) BMS 10-79 type 2
- D. Sealant -- BMS 5-95 (Ref 20-60-04)

- E. Surfacer -- 8-W-5 (Ref 20-60-04)
- F. Surfacer -- Epocast 156 (Ref 20-60-04)

57-70-51

REPAIR-GENERAL

01.1

Page 602

Jul 01/91

4. Dimensioning Symbols

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

—	STRAIGHTNESS	\oplus	THEORETICAL EXACT POSITION OF A FEATURE (TRUE POSITION)
\square	FLATNESS	\varnothing	DIAMETER
\perp	PERPENDICULARITY (OR SQUARENESS)	S \varnothing	SPHERICAL DIAMETER
//	PARALLELISM	R	RADIUS
\bigcirc	ROUNDNESS	SR	SPHERICAL RADIUS
\bigcirc	CYLINDRICITY	()	REFERENCE
\frown	PROFILE OF A LINE	BASIC	A THEORETICALLY EXACT DIMENSION USED TO DESCRIBE SIZE, SHAPE OR LOCATION OF A FEATURE FROM WHICH PERMISSIBLE VARIATIONS ARE ESTABLISHED BY TOLERANCES ON OTHER DIMENSIONS OR NOTES.
\triangle	PROFILE OF A SURFACE	(BSC)	
\odot	CONCENTRICITY	OR	
\equiv	SYMMETRY	DIM	
\sphericalangle	ANGULARITY	-A-	DATUM
\nearrow	RUNOUT	\textcircled{M}	MAXIMUM MATERIAL CONDITION (MMC)
\nearrow	TOTAL RUNOUT	\textcircled{L}	LEAST MATERIAL CONDITION (LMC)
\sqcup	COUNTERBORE OR SPOTFACE	\textcircled{S}	REGARDLESS OF FEATURE SIZE (RFS)
∇	COUNTERSINK	\textcircled{P}	PROJECTED TOLERANCE ZONE
		FIM	FULL INDICATOR MOVEMENT

EXAMPLES

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

True Position Dimensioning Symbols
Figure 601

57-70-51

REPAIR-GENERAL

01.1

Page 603

Jul 01/91

HINGE FITTING ASSEMBLY – REPAIR 1-1

113T5126-1

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

1. Liner Replacement (80, IPL Fig. 1; 65, IPL Fig. 2)

- A. Remove liner.
- B. If liner or fitting is worn beyond allowable limits, refer to paragraph 2.0.
- C. Install liner by press fit per 20-50-03 using wet BMS 5-95 sealant (Fig. 601).

2. Repair

- A. Machine diameter of fitting (85, IPL Fig. 1; 70, IPL Fig. 2), as required, to remove discrepancies per Fig. 601.
- B. Penetrant inspect fitting (85, IPL Fig. 1; 70, IPL Fig. 2) after machining, but prior to shot peening.
- C. Shot peen machined areas using shot number 230-550, intensity 0.008A, coverage 2.0.
- D. Fabricate a replacement liner, if necessary, per Fig. 602.
- E. Install replacement liner per paragraph 1.C, and Fig. 602.

3. Refinish

- A. Fitting (85, IPL Fig. 1; 65, IPL Fig. 2) -- Chromic acid anodize, type 1. Apply one coat BMS 10-11, type 1 primer per 20-41-02 (F-18.13) plus apply BMS 10-60, BAC707 gray gloss enamel (SRF-14.9813) all over, except omit primer and enamel from holes. Material: Aluminum alloy.

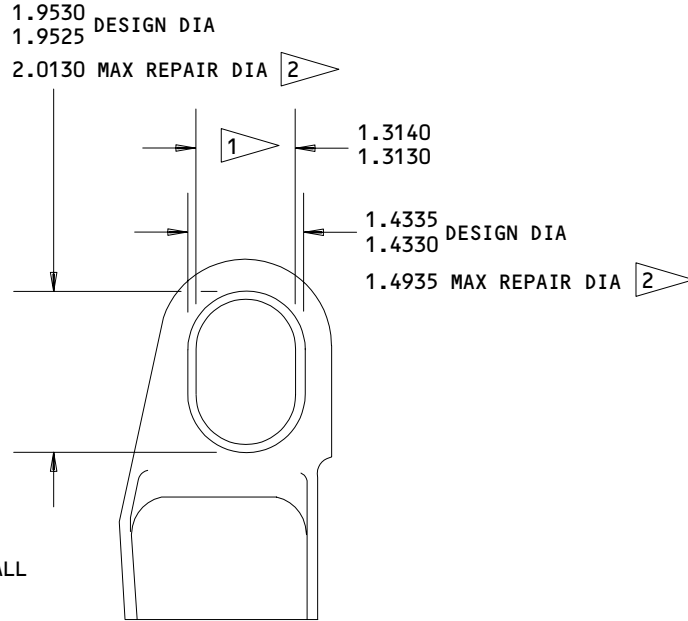
57-70-51

REPAIR 1-1

01.1

Page 601

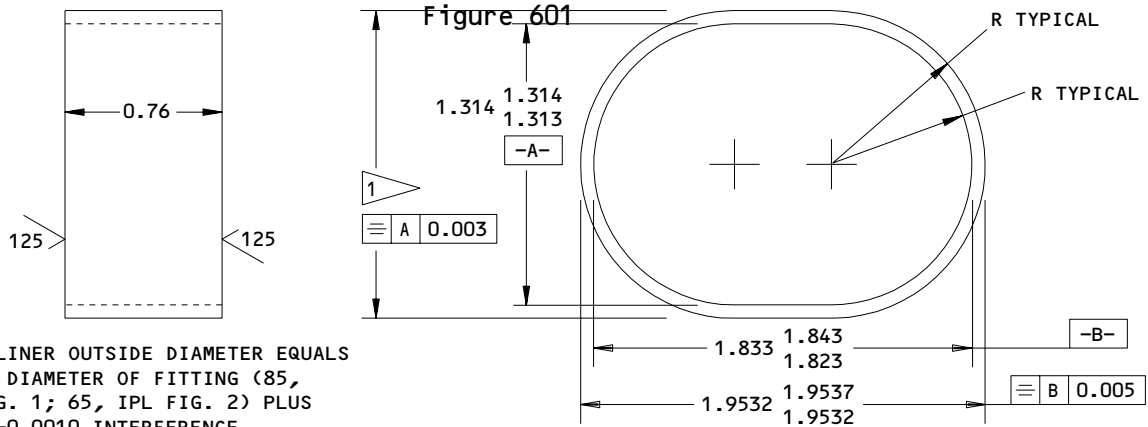
Jul 01/91



1 THIS INSIDE DIAMETER OF LINER (80, IPL FIG. 1; 65, IPL FIG. 2) SHALL BE 1.313 INCH MINIMUM AFTER LINER INSTALLATION

2 COMBINED OVERSIZING IN BOTH DIRECTIONS SHALL NOT EXCEED 0.06 INCH

113T5126-1
 Hinge Fitting Assembly Repair



1 FINAL LINER OUTSIDE DIAMETER EQUALS REPAIR DIAMETER OF FITTING (85, IPL FIG. 1; 65, IPL FIG. 2) PLUS 0.0000-0.0010 INTERFERENCE

32/ ALL MACHINED SURFACES, EXCEPT AS NOTED

MATERIAL: 4130 TUBE, MIL-T-6736, ANNEALED
 OPT: 4340 BAR, MIL-S-5000, NORMALIZED AND
 SUB-CRITICAL ANNEAL TO RC 33 MAX

HEAT TREAT TUBE TO 180-200 KSI AFTER FABRICATION
 MAX ALLOWABLE DECARB DEPTH: 0.003 INCH, ANY
 SURFACE

FINISH: CAD PLATE PER QQ-P-416, TYPE 2,
 CLASS 2 (F-15.06) PER 20-42-05

ALL DIMENSIONS ARE IN INCHES

DIMENSIONS APPLY AFTER PLATING

DECIMAL TOLERANCE, ± 0.010 , EXCEPT AS NOTED

Replacement Liner for Liner (80, IPL Fig. 1; 65, IPL Fig. 2)
 Figure 602

57-70-51

REPAIR 1-1

01.1

Page 602

Jul 01/91

ACTUATOR FITTING ASSEMBLY – REPAIR 2-1

113T5127-1

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

1. Bushing Replacement (225, 230, IPL Fig. 1; 220, 225, IPL Fig. 2)
 - A. Remove bushings.
 - B. Install bushings by press fit per 20-50-03 using wet BMS 5-95 sealant.
 - C. Machine bores of bushings to dimensions shown (Fig. 601).
 - D. Fillet seal around flanges of bushings using BMS 5-95 sealant.
2. Refinish
 - A. Fitting (235, IPL Fig. 1; 230, IPL Fig. 2) -- Chromic acid anodize, type 1. Apply one coat BMS 10-11, type 1 primer per 20-41-02 (F-18.13) plus apply BMS 10-60, BAC707 gray gloss enamel (SRF-14.9813) all over, except omit primer and enamel from holes. Material: Aluminum alloy.
 - B. Fitting assembly (180, IPL Fig. 1; 180, IPL Fig. 2) -- Topcoat sealant around bushing flanges using BMS 10-60, BAC707 gray gloss enamel (SRF-14.9813).

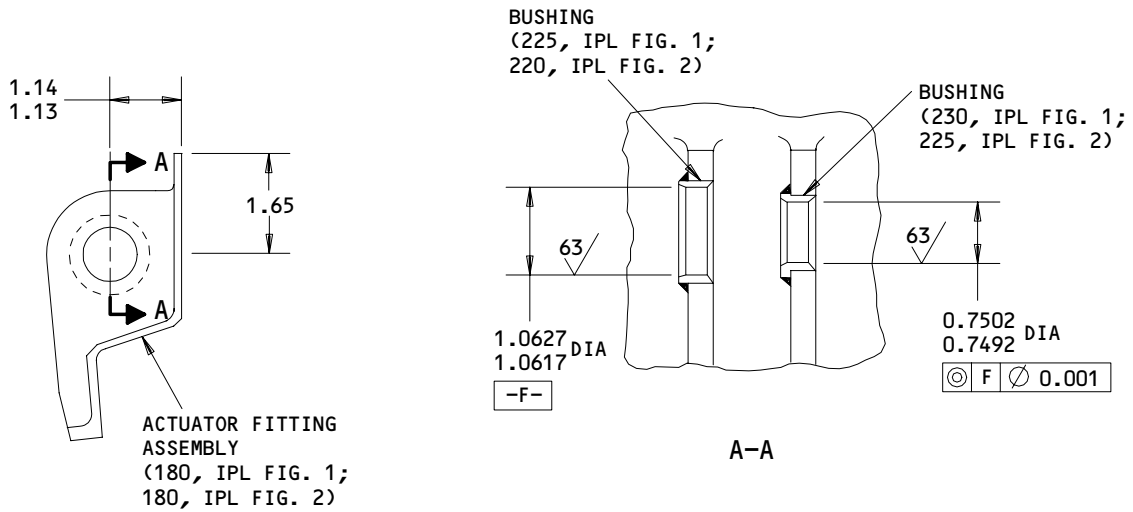
57-70-51

REPAIR 2-1

01.1

Page 601

Jul 01/91



ALL DIMENSIONS ARE IN INCHES

Actuator Fitting Assembly Repair
 Figure 601

3767

57-70-51

REPAIR 2-1

01.1

Page 602

Jul 01/91

HINGE FITTING ASSEMBLY - REPAIR 3-1

113T5128-1, -5

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

1. Bearing Replacement (173, IPL Fig. 1; 170, IPL Fig. 2)

- A. Remove bearing.
- B. Install bearing and roller swage per 20-50-03.

2. Refinish

- A. Fitting (175, IPL Fig. 1; 175, IPL Fig. 2) -- Chromic acid anodize, type 1. Apply one coat BMS 10-11, type 1 primer per 20-41-02 (F-18.13) all over. Apply BMS 10-60, BAC707 gray gloss enamel (SRF-14.9813) all over, except omit primer and enamel from bearing bore. Material: Aluminum alloy.

57-70-51

REPAIR 3-1

01.1

Page 601

Jul 01/91

MISCELLANEOUS PARTS - REPAIR 4-1

1. Repair of parts listed in Fig. 601 consists of restoration of the original finish.

IPL FIG. & ITEM	MATERIAL	FINISH
<u>Fig. 1</u>		
Plate deflector (100)	Al alloy	Chromic acid anodize, type 1. Apply one coat BMS 10-11, type 1 primer per 20-41-02 (F-18.13) plus apply BMS 10-60, BAC707 gray gloss enamel (SRF-14.9813) all over.
Panel bond assembly (245)	Graphite/epoxy	Prepare surface and apply Dexter 28-C-1 static conditioner plus Epocast 156 or Dexter 8-W-5 surfacer per 20-10-06 (SRF-14.672), plus apply one coat BMS 10-79 type 2 primer (F-19.46) all over, except omit all finishes from Tedlar side.
Washer (21)	Al alloy	Brush, swab or spray colored chemical coating (F-17.10). Apply two coats BMS 10-11 type 1 primer per 20-41-02 (F-20.03) all over.
Outboard spoiler assembly (1,1C,1D,1E,1F,1H,1J,1L,1M,1N)		Finish upper surface per operator's standard color scheme (F-19.39-XXXX). Apply BMS 10-60, BAC707 gray gloss enamel (SRF-14.9813) all over rest of assembly, except omit enamel from Tedlar covered areas (lower surface) and from rubber seal surfaces. Apply BMS 3-23 corrosion inhibiting compound to all metallic structure per SRM 51-20-01.
Outboard spoiler assembly (1A, 1B, 1G)		No finish (F-25.01).

Refinish Details
Figure 601 (Sheet 1)

57-70-51

REPAIR 4-1

01.1

Page 601

Nov 01/00

IPL FIG. & ITEM	MATERIAL	FINISH
<u>Fig. 2</u> Plate deflector (100)	Al alloy	Chromic acid anodize, type 1. Apply one coat BMS 10-11, type 1 primer per 20-41-02 (F-18.13) plus apply BMS 10-60, BAC707 gray gloss enamel (SRF-14.9813) all over.
Panel bond assembly (250)	Graphite/epoxy	Prepare surface and apply Dexter 28-C-1 static conditioner plus Epocast 156 or Dexter 8-W-5 surfacer per 20-10-06 (SRF-14.672), plus apply one coat BMS 10-79 type 2 primer (F-19.46) all over, except omit all finishes from Tedlar side.
Washer (7)	Al alloy	Brush, swab or spray colored chemical coating (F-17.10). Apply two coats BMS 10-11, type 1 primer per 20-41-02 (F-20.03) all over.
Outboard spoiler assembly (1,1A,1B, 1D,1E,1F,1G,1H)		Finish upper surface per operator's standard color scheme (F-19.39-XXXX). Apply BMS 10-60, BAC707 gray gloss enamel (SRF-14.9813) all over rest of assembly, except omit enamel from Tedlar covered areas (lower surface) and from rubber seal surfaces. Apply BMS 3-23 corrosion inhibiting compound to all metallic structure per SRM 51-20-01.
Outboard spoiler assembly (1C)		No finish (F-25.01).

Refinish Details
Figure 601 (Sheet 2)

57-70-51

REPAIR 4-1

01.1

Page 602

Nov 01/00

ASSEMBLY

1. Materials

- A. Adhesive -- Type 44 (Ref 20-50-12)
- B. Primer -- BMS 10-11, type 1 (Ref 20-60-02)
- C. Sealant -- BMS 5-95 (Ref 20-60-04)
- D. Enamel -- BMS 10-60 type I, Class A red gloss (Ref 20-60-02)

2. Assembly

- A. Use standard industry practices for assembly of this component and the following additional procedures.
- B. Bond rubstrip (240, IPL Fig. 1; 245, IPL Fig. 2) to panel bond assembly (245, IPL Fig. 1; 250, IPL Fig. 2) per 20-50-12, using type 44 adhesive, prior to any finish application.
- C. Delaminate shims (40, 55, 70, 105, 155, 210, IPL Fig. 1; 75, 80, 85, 155, 235, IPL Fig. 2) by removing 0.003 inch laminations as required per disassembly. Hinge fitting assemblies' (30, 160, IPL Fig. 1; 25, 160, IPL Fig. 2) centerline must be straight within 0.010 inch. Apply two coats BMS 10-11, type 1 primer to entire surface of shim after trimming and delamination.
- D. Prepack cavities indicated in Fig. 701 using BMS 5-95 sealant.
- E. Apply faying surface sealant BMS 5-95 between fittings (160, 180, IPL Fig. 1; 160, 180, IPL Fig. 2) and graphite/epoxy part.
- F. Apply faying surface sealant BMS 5-95 to both sides of aluminum shims (40, 55, 70, 155, 210, IPL Fig. 1; 75, 80, 85, 155, 235, IPL Fig. 2).

NOTE: Gaps between faying parts at all locations, except at rubber seal locations, must not exceed 0.005 inch.

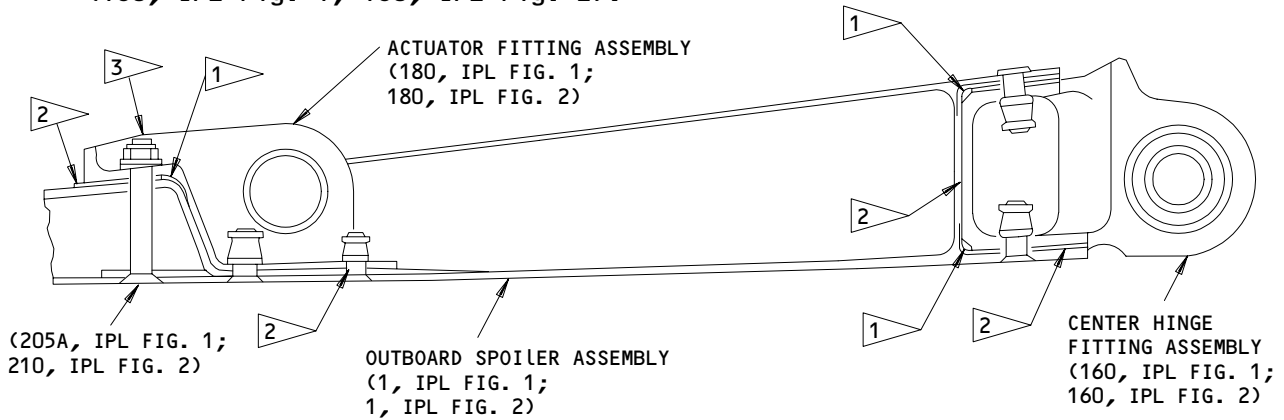
- G. Wet install all fasteners and fillet seal collars using BMS 5-95 sealant, except omit sealant from fasteners attaching the rubber seal.
- H. Install bolts (205A, IPL Fig. 1; 210, IPL Fig. 2) and tighten nuts (220, IPL Fig. 1; 215, IPL Fig. 2) within torque range of 100 to 130 pound-inches. After tightening fasteners, check that bolt ends (205A, IPL Fig. 1; 210, IPL Fig. 2) do not extend beyond the profile of the actuator fitting assembly (160, 180, IPL Fig. 1; 160, 180, IPL Fig. 2). Fill Phillips head recesses with BMS 5-95 sealant, prior to any refinishing.
- I. Fillet seal all fitting edges using BMS 5-95 sealant.

57-70-51

ASSEMBLY
Page 701
Jul 01/91

01.1

J. Cold bond identification plate (5, IPL Fig. 1; 255, IPL Fig. 2) to panel bond assembly (245) per 20-50-12, using type 44 adhesive. Center plate in depth of bond assembly, 2.0 inches from flange of fitting assembly (160, IPL Fig. 1; 160, IPL Fig. 2).

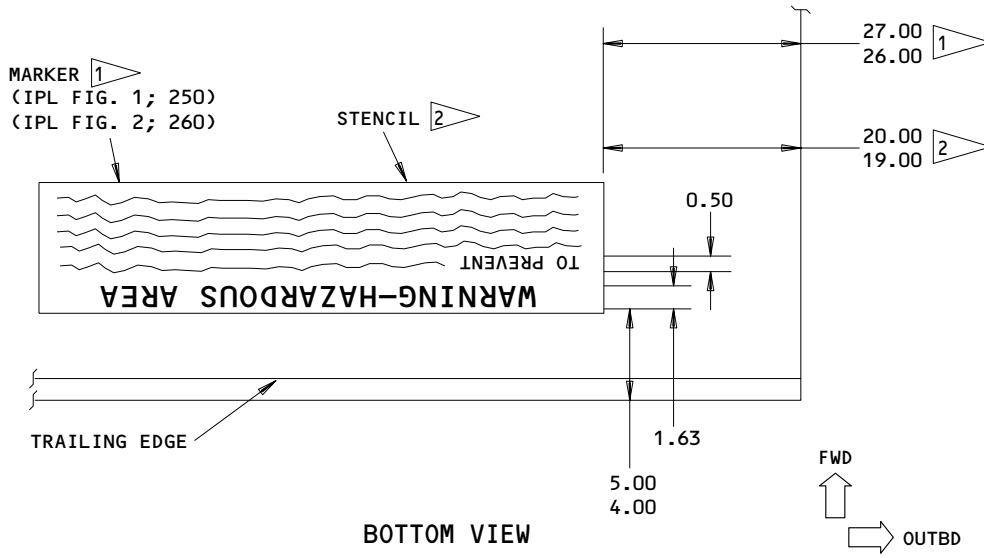


- 1 PREPACK CAVITIES USING BMS 5-95 SEALANT.
- 2 FAY SURFACE SEAL BETWEEN FITTING ASSEMBLIES AND GRAPHITE/EPOXY PARTS USING BMS 5-95 SEALANT
- 3 BOLT (205A,205B) MUST NOT PROTRUDE BEYOND PROFILE OF FITTING ASSEMBLY (180, IPL FIG. 1; 180, IPL FIG. 2)

Hinge Fitting Assembly Instructions
 Figure 701

K. Stencil the following warning message per 20-50-10 in the location shown in Fig. 702 (bottom view) using BMS 10-60 red gloss enamel (SRF-14.9815) or locate marker as shown in Fig. 702.

3769



- 1 113T5102-13,-14,-18,-19,-23SP
- 2 113T5102-1SP,-10SP,-15,-17,-21,-22SP
113T50003-5

ALL DIMENSIONS ARE IN INCHES

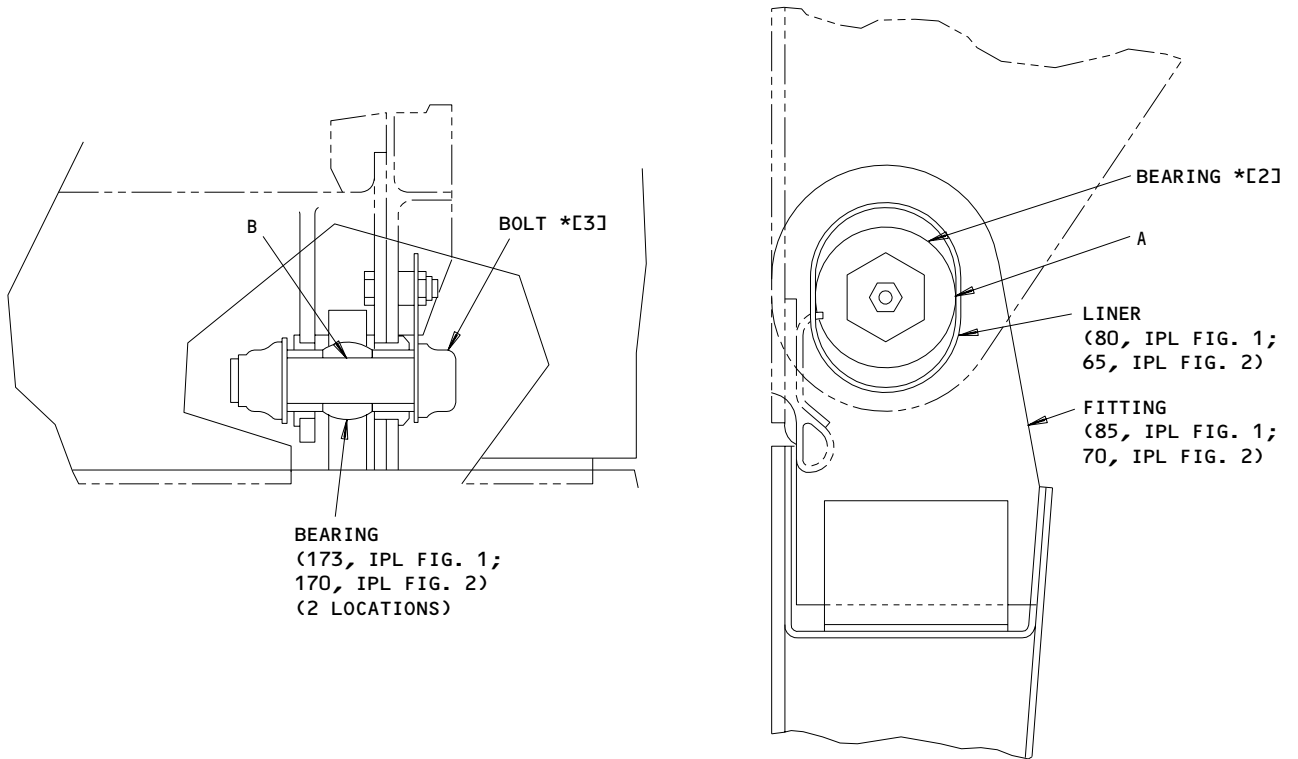
Warning Stencil or Marker
Figure 702

208898

57-70-51

ASSEMBLY
Page 703
Nov 01/00

FITS AND CLEARANCES



Ref Letter Fig.801	Mating Item No.	IPL Fig. No.	Design Dimension				Service Wear Limit			
			Dimension		Assembly Clearance * [1]		Dimension		Maximum Clearance	
			Min	Max	Min	Max	Min	Max		
A	ID 80	1	1.3130	1.3140	-0.0005	0.0025	1.3082	1.3193	0.0058	
	OD * [2]		2	1.3115						1.3135
B	ID 173	1	0.7500	0.7504	0.0010	0.0024	0.7414	0.7580	0.0090	
	OD * [3]		2	0.7480						0.7490

* [1] NEGATIVE VALUES DENOTE INTERFERENCE FIT
 * [2] BEARING (BACB10ET08)
 * [3] BOLT (BACB30LE12-32)

ALL DIMENSIONS ARE IN INCHES

Fits and Clearances
Figure 801

57-70-51

FOR TORQUE VALUES OF STANDARD FASTENERS, REFER TO 20-50-01			
ITEM NO. FIG. 1,2	NAME	TORQUE	
		POUND-INCHES	POUND-FEET
220, 215	NUT	100-130	---

Torque Table
Figure 802

57-70-51

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.

7. Boeing Proprietary Color Coded Parts

Color coded parts are identified with an alpha "SP" suffix. This entry represents consolidation of all color codes applicable for a given usage. Orders for color coded parts should include the registry number of the airplane for which the parts are ordered.

57-70-51

ILLUSTRATED PARTS LIST
01.1 Page 1002
Jul 01/91

VENDORS

S0352 NIPPON MINIATURE BEARING CO LTD
TOKYO, JAPAN

OPTK6 SPS TECHNOLOGIES INC AEROSPACE PRODUCTS DIV
5195 W 4700 SPO BOX 18459
KEARNS, UTAH 84118

02758 NETWORKS ELECTRONIC CORP U S BEARING DIV
9750 DE SOTO AVENUE
CHATSWORTH, CALIFORNIA 91311-4409
FORMERLY U S BEARING DIV NETWORKS ELEC CORP

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

15860 NEW HAMPSHIRE BALL BEARINGS, INCORPORATED ASTRO DIVISION
155 LEXINGTON AVENUE
LACONIA, NEW HAMPSHIRE 03246-2937
FORMERLY ASTRO BEARING CORP, LOS ANGELES, CALIF.

16746 SPECLINE INCORPORATED
2230 MOUTON DR
CARSON CITY, NV 89706
FORMERLY IN SUN VALLEY, CAIFORNIA

57-70-51

ILLUSTRATED PARTS LIST
01.1 Page 1003
Nov 01/00

VENDORS

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

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

56644 AURORA BEARING CO
970 SOUTH LAKE STREET
AURORA, ILLINOIS 60506-5929

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

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

73134 IMO INDUSTRIES INC HEIM BEARINGS DIV
60 ROUND HILL ROAD PO BOX 430
FAIRFIELD, CONNECTICUT 06430
FORMERLY INCOM INTL INC HEIM DIV; FORMERLY HEIM UNIVERSAL
CORP INCOM INTL INC; FORMERLY HEIM DIV INCOM INTL

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

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

57-70-51

ILLUSTRATED PARTS LIST
01.1 Page 1004
Nov 01/00

VENDORS

97613 SARGENT CONTROLS & AEROSPACE/KAHR BEARING DIV
5675 W BURLINGAME RD
TUCSON, ARIZONA 85743
FORMERLY AETNA STEEL PROD KAHR BEARING DIV V96579
FORMERLY SARGENT IND KAHR BEARING DIV, BURBANK, CALIFORNIA

57-70-51

ILLUSTRATED PARTS LIST
01.1 Page 1005
Nov 01/00

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
AG12V32C		1	173	2
		2	170	2
AN960PD516L		1	197	2
		2	200	2
ASBF J12VC		1	173	2
		2	170	2
BACB10F J12GC		1	173	2
		2	170	2
BACB28AM17B027A		1	225	1
		2	220	1
BACB28AP12P027		1	230	1
		2	225	1
BACB30NN3K2		2	12L	11
BACB30NN3K3		1	15	24
		2	5	24
		2	12	11
BACB30NN5K26		1	205B	3
		2	210A	3
BACB30NN5K27		1	205A	3
		2	210	3
BACB30NW8K5		1	53	2
		2	50	2
BACB30NX10K6		1	140	2
		2	140	2
BACB30NX10K7		1	145	2
		2	145	2
BACB30NX6K8		1	35	4
		2	30	4
BACB30NX8K4		1	130A	4
		2	130	4
BACB30NX8K5		1	50	2
		2	40	2
BACB30NZ10K3		1	195C	2
		2	195A	2
BACB30NZ10K4		1	195B	2
		2	195	2
BACB30NZ10K6		1	110	2
		2	110	2
BACB30NZ10K7		1	115	2
		2	115	2
BACB30NZ10K8		1	120	4
		2	120	4

57-70-51

 ILLUSTRATED PARTS LIST
 01.1 Page 1006
 Nov 01/00

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACB30NZ8K5		1	185	3
BACB30NZ8K5		2	185	3
BACB30NZ8K6		1	65	4
		2	55	4
BACB30NZ8K8		1	90	4
		2	90	4
BACC30M10		1	125	8
		2	125	8
BACC30M8		1	63	2
		1	75	4
		1	95	4
		1	190	3
		2	60	6
		2	95	4
		2	190	3
BACC30X10		1	150	4
		2	150	4
BACC30X6S		1	45	4
		2	35	4
BACC30X8		1	60	2
		1	135	4
		2	45	2
		2	135	4
BACF3T01D06-06		1	215	3
		2	240	3
BACN10GW5		1	220	3
		2	215	3
BACN10JC3CM		1	25	24
		2	10	24
		2	13	22
BACN10JC5		1	200A	2
		1	220A	3
		2	205	2
		2	215A	3
BACS40R10D16F		1	40	4
		2	75	4
BACS40R10E45F		1	105	1
		2	105	1
BACS40R11C25F		1	55	2
		2	80	2
BACS40R13C27F		1	155	2
		2	155	2

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACS40R15C25F		1	70	2
		2	85	2
BACW10BP3APU		1	20	24
		2	6	24
BAC27NCT0217		1	250	1
		2	260	1
BWG12A111C		1	173	2
		2	170	2
B30NW8K5		1	53	2
		2	50	2
HL1012AZ10-6		1	140	2
		2	140	2
HL1012AZ10-7		1	145	2
		2	145	2
HL1012AZ6-8		1	35	4
		2	30	4
HL1012AZ8-4		1	130A	4
		2	130	4
HL1012AZ8-5		1	50	2
		2	40	2
HL11VAZ8-5		1	53	2
		2	50	2
HL1187-10		1	150	4
		2	150	4
HL1187-8		1	60	2
		1	135	4
HL1187DU6		2	45	2
		2	135	4
HL12VAZ10-6		1	45	4
		2	35	4
HL12VAZ10-7		1	140	2
		2	140	2
HL12VAZ10-7		1	145	2
		2	145	2
HL12VAZ6-8		1	35	4
		2	30	4

57-70-51

 ILLUSTRATED PARTS LIST
 01.1 Page 1008
 Nov 01/00

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
HL12VAZ8-4		1	130A	4
		2	130	4
HL12VAZ8-5		1	50	2
		2	40	2
HL523AZ10-3		1	195C	2
		2	195A	2
HL523AZ10-4		1	195B	2
		2	195	2
HL523AZ10-6		1	110	2
		2	110	2
HL523AZ10-7		1	115	2
		2	115	2
HL523AZ10-8		1	120	4
		2	120	4
HL523AZ8-5		1	185	3
		2	185	3
HL523AZ8-6		1	65	4
		2	55	4
HL523AZ8-8		1	90	4
		2	90	4
HL79-10		1	125	8
		2	125	8
HL79-8		1	63	2
		1	75	4
		1	95	4
		1	190	3
		2	60	6
		2	95	4
		2	190	3
		1	150	4
HL87-10		2	150	4
HL87-8		1	60	2
		1	135	4
		2	45	2
		2	135	4

57-70-51

ILLUSTRATED PARTS LIST
01.1 Page 1009
Nov 01/00

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
HL87DU6		1	45	4
		2	35	4
HU12-210VC		1	173	2
		2	170	2
JC12G3C		1	173	2
		2	170	2
KSB12-61		1	173	2
		2	170	2
LHB12EPGC		1	173	2
		2	170	2
L802-10K6		1	140	2
		2	140	2
L802-10K7		1	145	2
		2	145	2
L802-6K8		1	35	4
		2	30	4
L802-8K4		1	130A	4
		2	130	4
L802-8K5		1	50	2
		2	40	2
L803-8K5		1	53	2
		2	50	2
L804-10K3		1	195C	2
		2	195A	2
L804-10K4		1	195B	2
		2	195	2
L804-10K6		1	110	2
		2	110	2
L804-10K7		1	115	2
		2	115	2
L804-10K8		1	120	4
		2	120	4
L804-8K5		1	185	3
		2	185	3
L804-8K6		1	65	4
		2	55	4

57-70-51

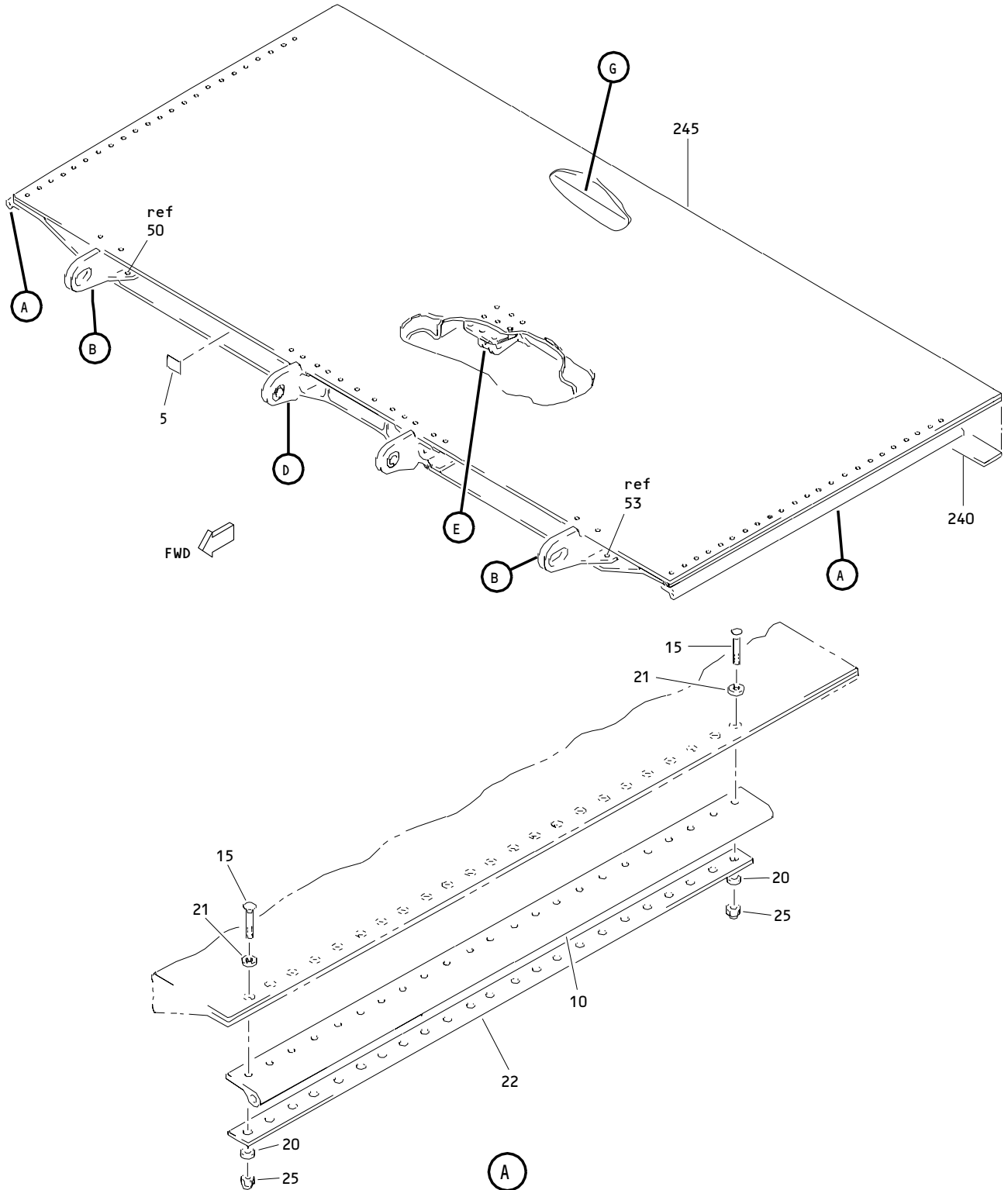
 ILLUSTRATED PARTS LIST
 01.1 Page 1010
 Nov 01/00

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
L804-8K8		1	90	4
		2	90	4
MS15001-1		1	165	2
		2	165	2
MS27253F3		2	255A	1
MS27253P3		1	5	1
		2	255	1
113T5003-5		1	1K	RF
113T5003-6		1	3C	1
113T5102-1SP		1	1	RF
113T5102-10SP		1	1C	RF
		2	1	RF
113T5102-11		2	20	2
113T5102-13		1	1D	RF
113T5102-14		1	1E	RF
		2	1A	RF
113T5102-15		1	1F	RF
		2	1B	RF
113T5102-16		1	3B	1
113T5102-17		1	1G	RF
		2	1C	RF
113T5102-18		1	1H	RF
		2	1D	RF
113T5102-19		1	1J	RF
		2	1E	RF
113T5102-21		1	1L	RF
		2	1F	RF
113T5102-22SP		1	1M	RF
113T5102-22SP		2	1G	RF
113T5102-23		1	1N	RF
		2	1H	RF
113T5102-4		1	10	2
		2	15	2
113T5102-5		1	240	1
		2	245	1
113T5102-5001		1	3	1
113T5102-6		1	210	1
		2	235	1
113T5102-7		1	21	24
		2	7	24
113T5102-8		1	22	2
		2	8	2
113T5102-9		1	1B	RF

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
113T5105-1		1	100	1
		2	100	1
113T5111-1		1	245	1
113T5111-14		2	250	1
113T5111-18		2	250A	1
113T5126-1		1	30	2
		2	25	2
113T5126-2		1	85	2
		2	70	2
113T5127-1		1	180	1
		2	180	1
113T5127-2		1	235	1
		2	230	1
113T5128-1		1	160	1
113T5128-2		1	175	1
113T5128-5		1	160C	1
		2	160	1
113T5128-6		1	175C	1
		2	175	1
66014-10		1	125	8
		2	125	8
66014-8		1	63	2
		1	75	4
		1	95	4
		1	190	3
		2	60	6
		2	95	4
		2	190	3
69B00630-1		1	80	2
69B00630-1		2	65	2

57-70-51

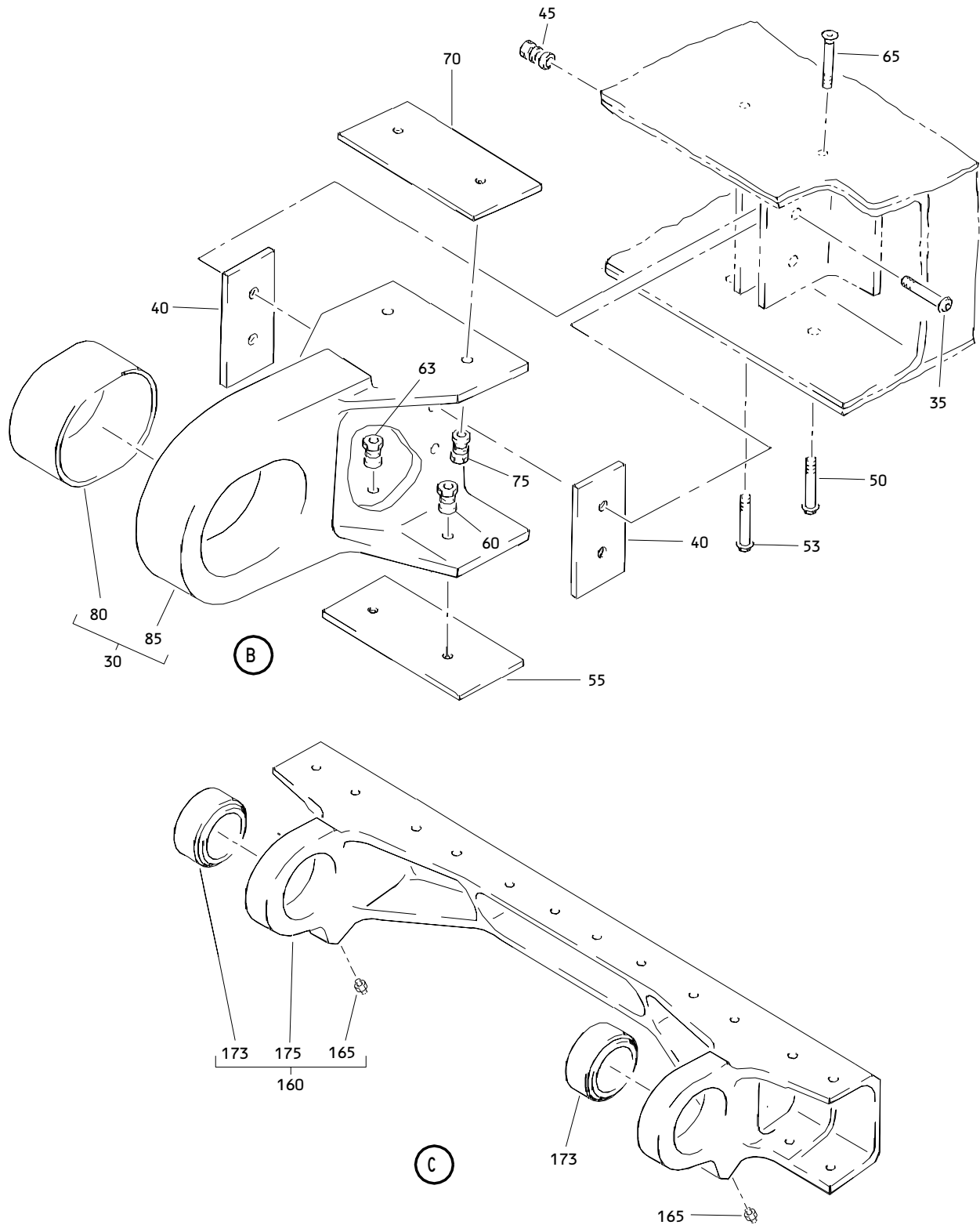
 ILLUSTRATED PARTS LIST
 01.1 Page 1012
 Nov 01/00



Outboard Spoiler Assembly
Figure 1 (Sheet 1)

57-70-51

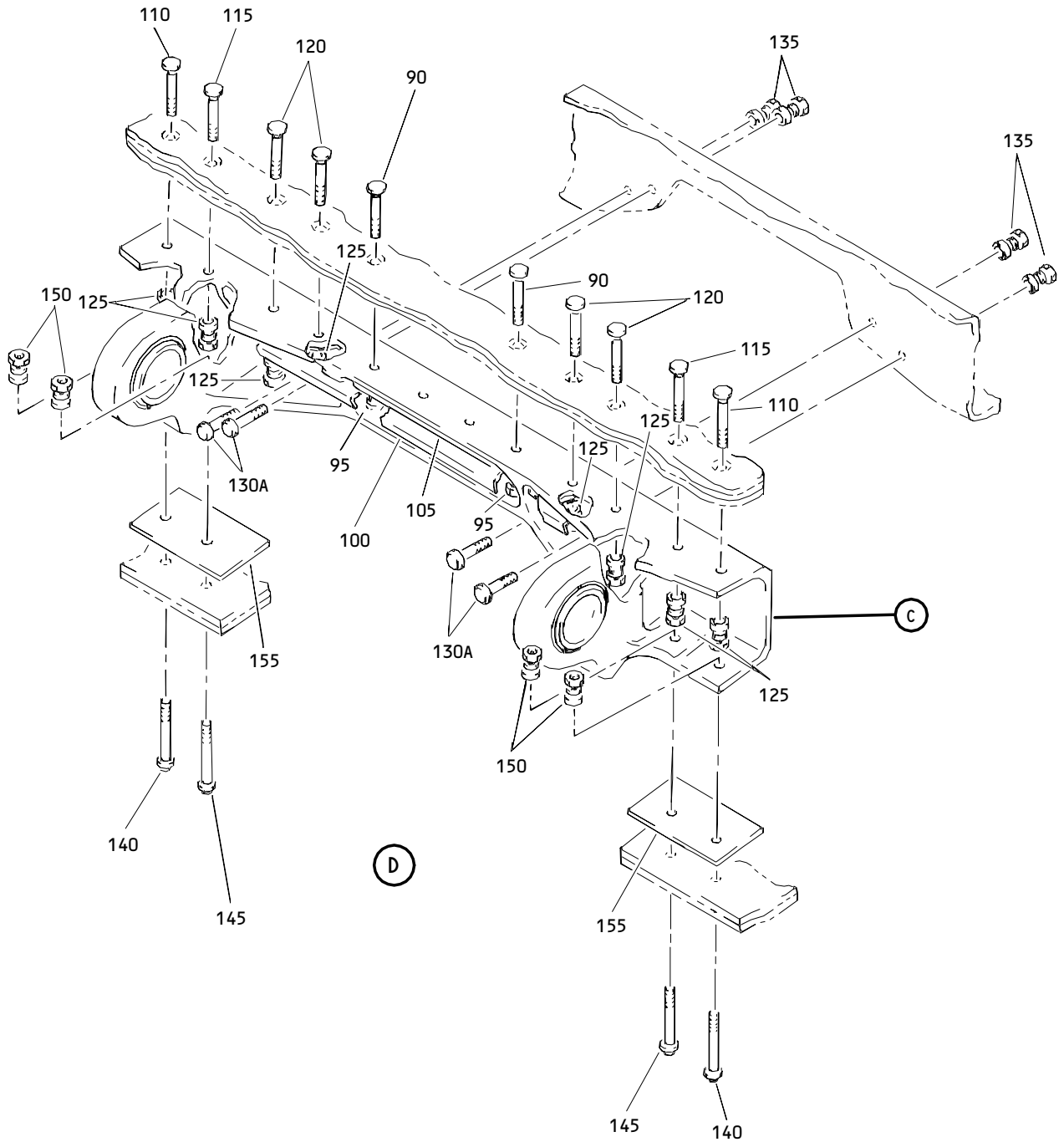
ILLUSTRATED PARTS LIST
01.1 Page 1013
Nov 01/00



Outboard Spoiler Assembly
Figure 1 (Sheet 2)

57-70-51

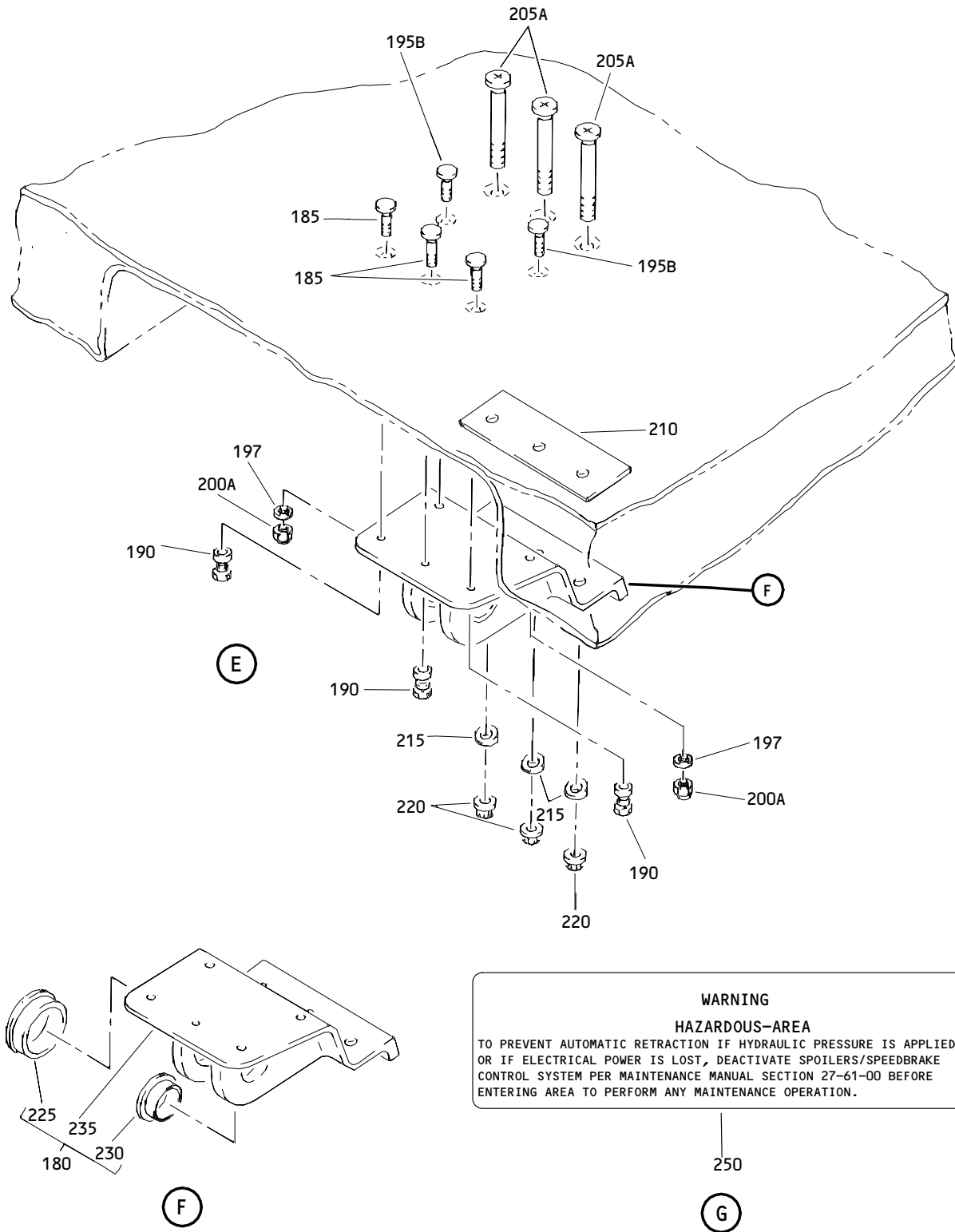
ILLUSTRATED PARTS LIST
 01.1 Page 1014
 Nov 01/00



Outboard Spoiler Assembly
Figure 1 (Sheet 3)

57-70-51

ILLUSTRATED PARTS LIST
01.1 Page 1015
Nov 01/00



WARNING
HAZARDOUS-AREA
 TO PREVENT AUTOMATIC RETRACTION IF HYDRAULIC PRESSURE IS APPLIED OR IF ELECTRICAL POWER IS LOST, DEACTIVATE SPOILERS/SPEEDBRAKE CONTROL SYSTEM PER MAINTENANCE MANUAL SECTION 27-61-00 BEFORE ENTERING AREA TO PERFORM ANY MAINTENANCE OPERATION.

Outboard Spoiler Assembly
Figure 1 (Sheet 4)

57-70-51

ILLUSTRATED PARTS LIST
 01.1 Page 1016
 Nov 01/00

 **BOEING**
COMPONENT
MAINTENANCE MANUAL

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01- -1	113T5102-1SP		SPOILER ASSY-OUTBD SPOILER (PRE 767-27-0080)	A	RF
-1A	113T5102-3		DELETED		
-1B	113T5102-9		SPOILER ASSY-OUTBD SPOILER (VARIABLE)	B	RF
-1C	113T5102-10SP		SPOILER ASSY-OUTBD SPOILER (POST 767-27-0080) (FOR DETAILS SEE FIG. 2)	C	RF
-1D	113T5102-13		SPOILER ASSY-OUTBD SPOILER (VARIABLE)	D	RF
-1E	113T5102-14		SPOILER ASSY-OUTBD SPOILER (VARIABLE) (FOR DETAILS SEE FIG. 2)	E	RF
-1F	113T5102-15		SPOILER ASSY-OUTBD SPOILER (VARIABLE) (PRE 767-27-0080) (FOR DETAILS SEE FIG. 2)	F	RF
-1G	113T5102-17		SPOILER ASSY-OUTBD SPOILER (VARIABLE) (FOR DETAILS SEE FIG. 2)	G	RF
-1H	113T5102-18		SPOILER ASSY-OUTBD SPOILER (VARIABLE) (FOR DETAILS SEE FIG. 2)	H	RF
-1J	113T5102-19		SPOILER ASSY-OUTBD SPOILER (VARIABLE) (FOR DETAILS SEE FIG. 2)	J	RF
R -1K	113T5003-5		SPOILER ASSY-SPOILER NO. 1 (POST 767-27-0080)	K	RF
R -1L	113T5102-21		SPOILER ASSY-OUTBD SPOILER (VARIABLE) (FOR DETAILS SEE FIG. 2)	L	RF
R -1M	113T5102-22SP		SPOILER ASSY-OUTBD SPOILER (FOR DETAILS SEE FIG. 2)	M	RF
R -1N	113T5102-23		SPOILER ASSY-OUTBD SPOILER (FOR DETAILS SEE FIG. 2)	N	RF
-3	113T5102-5001		.SPOILER ASSY- (REPLD BY ITEM 3A)	A,B	1
-3A	113T5102-5002		.SPOILER ASSY- (REPLS ITEM 3)	A,B	1
-3B	113T5102-16		.SPOILER ASSY-(VARIABLE) (PRE 767-27-0080)	D	1
R -3C	113T5003-6		.SPOILER ASSY- (POST 767-27-0080)	D	1
5	MS27253P3		..PLATE	A,B,D	1

57-70-51

ILLUSTRATED PARTS LIST
01.1 Page 1017
Nov 01/00

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-10	113T5102-4		..SEAL- (MFD FROM EXTRUSION RUBBER 10-60754-83 23.00 IN.) ATTACHING PARTS	A,B,D	2
15-20	BACB30NN3K3 BACW10BP3APU		..BOLT ..WASHER- (ITEM 20 PLUS ITEM 21 OPT TO ITEM 22)	A,B,D A,B,D	24 24
21	113T5102-7		..WASHER- (ITEM 20 PLUS ITEM 21 OPT TO ITEM 22)	A,B,D	24
22	113T5102-8		..RETAINER- (ITEM 20 PLUS ITEM 21 OPT TO ITEM 22)	A,B,D	2
25	BACN10JC3CM		..NUT -----*-----	A,B,D	24
30-30A	113T5126-1 113T5126-3		..FITTING ASSY-SIDE HINGE DELETED	A,B,D	2

57-70-51

 ILLUSTRATED PARTS LIST
 01.1 Page 1018
 Nov 01/00

 **BOEING**
COMPONENT
MAINTENANCE MANUAL

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 01-35	HL1012AZ6-8		ATTACHING PARTS ..BOLT- (V97928) (SPEC BACB30NX6K8) (OPT HL12VAZ6-8 (V73197)) (OPT HL12VAZ6-8 (V92215)) (OPT HL12VAZ6-8 (V97928)) (OPT L802-6K8 (V06725)) (OPT HL12VAZ6-8 (V56878)) (OPT HL1012AZ6-8 (V0PTK6)) (OPT HL1012AZ6-8 (V06725)) (OPT HL1012AZ6-8 (V06950)) (OPT HL1012AZ6-8 (V17446)) (OPT HL1012AZ6-8 (V56878)) (OPT HL1012AZ6-8 (V60516)) (OPT HL1012AZ6-8 (V73197))	A,B,D	4
40	BACS40R10D16F		..SHIM	A,B,D	4
45	HL1187DU6		..COLLAR- (V73197) (SPEC BACC30X6S) (OPT HL87DU6 (V73197)) (OPT HL87DU6 (V92215)) (OPT HL1187DU6 (V56878)) (OPT HL1187DU6 (V92215)) (OPT HL87DU6 (V56878)) (OPT HL1187DU6 (V5M902))	A,B,D	4

57-70-51

ILLUSTRATED PARTS LIST
01.1 Page 1019
Nov 01/00

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 01-50	HL1012AZ8-5		..BOLT- (VOPTK6) (SPEC BACB30NX8K5) (OPT HL12VAZ8-5 (V73197)) (OPT HL12VAZ8-5 (V92215)) (OPT HL12VAZ8-5 (V97928)) (OPT L802-8K5 (V06725)) (OPT HL12VAZ8-5 (V56878)) (OPT HL1012AZ8-5 (V06725)) (OPT HL1012AZ8-5 (V06950)) (OPT HL1012AZ8-5 (V17446)) (OPT HL1012AZ8-5 (V56878)) (OPT HL1012AZ8-5 (V60516)) (OPT HL1012AZ8-5 (V73197)) (OPT HL1012AZ8-5 (V97928))	A,B,D	2
53	HL11VAZ8-5		..BOLT- (V56878) (SPEC BACB30NW8K5) (OPT B30NW8K5 (V97928)) (OPT HL11VAZ8-5 (V73197)) (OPT HL11VAZ8-5 (V92215)) (OPT HL11VAZ8-5 (V97928)) (OPT L803-8K5 (V06725)) (OPT HL11VAZ8-5 (VOPTK6)) (OPT HL11VAZ8-5 (V60516))	A,B,D	2

57-70-51

 ILLUSTRATED PARTS LIST
 01.1 Page 1020
 Nov 01/00

BOEING
COMPONENT
MAINTENANCE MANUAL

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-55	BACS40R11C25F		..SHIM	A,B,D	2
60	HL1187-8		..COLLAR- (V73197) (SPEC BACC30X8) (OPT HL87-8 (V73197)) (OPT HL87-8 (V92215)) (OPT HL1187-8 (V56878)) (OPT HL1187-8 (V92215)) (OPT HL87-8 (V56878)) (OPT HL1187-8 (V5M902))	A,B,D	2
63	HL79-8		..COLLAR- (V56878) (SPEC BACC30M8) (OPT HL79-8 (V73197)) (OPT HL79-8 (V92215)) (OPT 66014-8 (V56878)) (OPT HL79-8 (V5M902))	A,B,D	2
65	HL523AZ8-6		..BOLT- (V73197) (SPEC BACB30NZ8K6) (OPT L804-8K6 (V06725)) (OPT HL523AZ8-6 (V56878)) (OPT HL523AZ8-6 (V92215)) (OPT HL523AZ8-6 (V97928)) (OPT HL523AZ8-6 (V0PTK6)) (OPT HL523AZ8-6 (V60516)) (OPT HL523AZ8-6 (V06725))	A,B,D	4

57-70-51

ILLUSTRATED PARTS LIST
01.1 Page 1021
Nov 01/00

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01- 70 75	BACS40R15C25F HL79-8		..SHIM ..COLLAR- (V56878) (SPEC BACC30M8) (OPT HL79-8 (V73197)) (OPT HL79-8 (V92215)) (OPT 66014-8 (V56878)) (OPT HL79-8 (V5M902)) -----*	A,B,D A,B,D	2 4
80	69B00630-1		...LINER	A,B,D	1
85	113T5126-2		...FITTING-	A,B,D	1
-85A	113T5126-4		DELETED		
90	HL523AZ8-8		..BOLT- (V73197) (SPEC BACB30NZ8K8) (OPT L804-8K8 (V06725)) (OPT HL523AZ8-8 (V56878)) (OPT HL523AZ8-8 (V92215)) (OPT HL523AZ8-8 (V97928)) (OPT HL523AZ8-8 (V0PTK6)) (OPT HL523AZ8-8 (V60516)) (OPT HL523AZ8-8 (V06725))	A,B,D	4

57-70-51

 ILLUSTRATED PARTS LIST
 01.1 Page 1022
 Nov 01/00

 **BOEING**
COMPONENT
MAINTENANCE MANUAL

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-95	HL79-8		..COLLAR- (V56878) (SPEC BACC30M8) (OPT HL79-8 (V73197)) (OPT HL79-8 (V92215)) (OPT 66014-8 (V56878)) (OPT HL79-8 (V5M902))	A,B,D	4
100	113T5105-1		..DEFLECTOR-PLATE	A,B,D	1
105	BACS40R10E45F		..SHIM	A,B,D	1
110	HL523AZ10-6		..BOLT- (V06725) (SPEC BACB30NZ10K6) (OPT L804-10K6 (V06725)) (OPT HL523AZ10-6 (V56878)) (OPT HL523AZ10-6 (V73197)) (OPT HL523AZ10-6 (V92215)) (OPT HL523AZ10-6 (V97928)) (OPT HL523AZ10-6 (V0PTK6)) (OPT HL523AZ10-6 (V60516))	A,B,D	2

57-70-51

ILLUSTRATED PARTS LIST
01.1 Page 1023
Nov 01/00

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-115	HL523AZ10-7		..BOLT- (V06725) (SPEC BACB30NZ10K7) (OPT L804-10K7 (V06725)) (OPT HL523AZ10-7 (V56878)) (OPT HL523AZ10-7 (V73197)) (OPT HL523AZ10-7 (V92215)) (OPT HL523AZ10-7 (V97928)) (OPT HL523AZ10-7 (V0PTK6)) (OPT HL523AZ10-7 (V60516))	A,B,D	2
120	HL523AZ10-8		..BOLT- (V56878) (SPEC BACB30NZ10K8) (OPT L804-10K8 (V06725)) (OPT HL523AZ10-8 (V92215)) (OPT HL523AZ10-8 (V73197)) (OPT HL523AZ10-8 (V06725)) (OPT HL523AZ10-8 (V97928)) (OPT HL523AZ10-8 (V0PTK6)) (OPT HL523AZ10-8 (V60516))	A,B,D	4

57-70-51

 ILLUSTRATED PARTS LIST
 01.1 Page 1024
 Nov 01/00

 **BOEING**
COMPONENT
MAINTENANCE MANUAL

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-125	HL79-10		..COLLAR- (V56878) (SPEC BACC30M10) (OPT HL79-10 (V73197)) (OPT HL79-10 (V92215)) (OPT 66014-10 (V56878)) (OPT HL79-10 (V5M902))	A,B,D	8
R 130 130A	HL12VAZ8-5 HL1012AZ8-4		DELETED ..BOLT- (V0PTK6) (SPEC BACB30NX8K4) (OPT HL12VAZ8-4 (V73197)) (OPT HL12VAZ8-4 (V92215)) (OPT HL12VAZ8-4 (V97928)) (OPT L802-8K4 (V06725)) (OPT HL12VAZ8-4 (V56878)) (OPT HL1012AZ8-4 (V06725)) (OPT HL1012AZ8-4 (V06950)) (OPT HL1012AZ8-4 (V17446)) (OPT HL1012AZ8-4 (V56878)) (OPT HL1012AZ8-4 (V60516)) (OPT HL1012AZ8-4 (V73197)) (OPT HL1012AZ8-4 (V97928))	A,B,D	4

57-70-51

ILLUSTRATED PARTS LIST
01.1 Page 1025
Nov 01/00

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE	EFF CODE	QTY PER ASSY
01-135	HL1187-8		1234567 ..COLLAR- (V73197) (SPEC BACC30X8) (OPT HL87-8 (V73197)) (OPT HL87-8 (V92215)) (OPT HL1187-8 (V56878)) (OPT HL1187-8 (V92215)) (OPT HL87-8 (V56878)) (OPT HL1187-8 (V5M902))	A,B,D	4
R 140	HL1012AZ10-6		..BOLT- (VOPTK6) (SPEC BACB30NX10K6) (OPT HL12VAZ10-6 (V73197)) (OPT HL12VAZ10-6 (V92215)) (OPT HL12VAZ10-6 (V97928)) (OPT L802-10K6 (V06725)) (OPT HL12VAZ10-6 (V56878)) (OPT HL1012AZ10-6 (V06725)) (OPT HL1012AZ10-6 (V06950)) (OPT HL1012AZ10-6 (V17446)) (OPT HL1012AZ10-6 (V56878)) (OPT HL1012AZ10-6 (V60516)) (OPT HL1012AZ10-6 (V73197)) (OPT HL1012AZ10-6 (V97928))	A,B,D	2

57-70-51

 ILLUSTRATED PARTS LIST
 01.1 Page 1026
 Nov 01/00

 **BOEING**
COMPONENT
MAINTENANCE MANUAL

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 01-145	HL1012AZ10-7		..BOLT- (V0PTK6) (SPEC BACB30NX10K7) (OPT HL12VAZ10-7 (V73197)) (OPT HL12VAZ10-7 (V92215)) (OPT HL12VAZ10-7 (V97928)) (OPT L802-10K7 (V06725)) (OPT HL12VAZ10-7 (V56878)) (OPT HL1012AZ10-7 (V06725)) (OPT HL1012AZ10-7 (V06950)) (OPT HL1012AZ10-7 (V17446)) (OPT HL1012AZ10-7 (V56878)) (OPT HL1012AZ10-7 (V60516)) (OPT HL1012AZ10-7 (V73197)) (OPT HL1012AZ10-7 (V97928))	A,B,D	2
150	HL1187-10		..COLLAR- (V73197) (SPEC BACC30X10) (OPT HL87-10 (V73197)) (OPT HL87-10 (V92215)) (OPT HL1187-10 (V56878)) (OPT HL1187-10 (V92215)) (OPT HL87-10 (V56878)) (OPT HL1187-10 (V5M902))	A,B,D	4
155	BACS40R13C27F		..SHIM	A,B,D	2
160	113T5128-1		..FITTING ASSY-CTR HINGE (USED ON ITEM 3)	A,B	1

57-70-51

ILLUSTRATED PARTS LIST
01.1 Page 1027
Nov 01/00

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-160A	113T5128-3		DELETED		
-160B	113T5128-3		DELETED		
-160C	113T5128-5		...FITTING ASSY-CTR HINGE (USED ON ITEM 3A)	A,B,D	1
165	MS15001-1		...FITTING	A,B,D	2
170	AG12V28C		DELETED		
173	AG12V32C		...BEARING- (V15860) (SPEC BACB10FJ12GC) (OPT ASBFJ12VC (VS0352)) (OPT ASBFJ12VC (VS0352)) (OPT BWG12A111C (V16746)) (OPT HU12-210VC (V02758)) (OPT JC12G3C (V56644)) (OPT KSB12-61 (V97613)) (OPT LHB12EPGC (V73134))	A,B,D	2
175	113T5128-2		...FITTING- (USED ON ITEM 160)	A,B	1
-175A	113T5128-4		DELETED		
-175B	113T5128-4		DELETED		
-175C	113T5128-6		...FITTING- (USED ON ITEM 160C)	A,B,D	1

57-70-51

 ILLUSTRATED PARTS LIST
 01.1 Page 1028
 Nov 01/00

 **BOEING**
COMPONENT
MAINTENANCE MANUAL

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01- 180 -180A -180B	113T5127-1 113T5127-3 113T5127-3		..FITTING ASSY-ACTR DELETED DELETED	A,B,D	1
185	HL523AZ8-5		ATTACHING PARTS ..BOLT- (V56878) (SPEC BACB30NZ8K5) (OPT L804-8K5 (V06725)) (OPT HL523AZ8-5 (V92215)) (OPT HL523AZ8-5 (V73197)) (OPT HL523AZ8-5 (V0PTK6)) (OPT HL523AZ8-5 (V08524)) (OPT HL523AZ8-5 (V60516)) (OPT HL523AZ8-5 (V06725))	A,B,D	3
190	HL79-8		..COLLAR- (V56878) (SPEC BACC30M8) (OPT HL79-8 (V73197)) (OPT HL79-8 (V92215)) (OPT 66014-8 (V56878)) (OPT HL79-8 (V5M902))	A,B,D	3

57-70-51

ILLUSTRATED PARTS LIST
01.1 Page 1029
Nov 01/00

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01- 195 195A 195B	HL523VAZ10-5 HL523VAZ10-3 HL523AZ10-4		DELETED DELETED ..BOLT- (VOPTK6) (SPEC BACB30NZ10K4) (OPT L804-10K4 (V06725)) (OPT HL523AZ10-4 (V56878)) (OPT HL523AZ10-4 (V73197)) (OPT HL523AZ10-4 (V92215)) (OPT HL523AZ10-4 (V97928)) (OPT HL523AZ10-4 (V60516)) (OPT HL523AZ10-4 (V06725)) (OPT ITEM 195C)	A,B,D	2
-195C	HL523AZ10-3		..BOLT- (V06725) (SPEC BACB30NZ10K3) (OPT L804-10K3 (V06725)) (OPT HL523AZ10-3 (V56878)) (OPT HL523AZ10-3 (V73197)) (OPT HL523AZ10-3 (V92215)) (OPT HL523AZ10-3 (V97928)) (OPT HL523AZ10-3 (VOPTK6)) (OPT HL523AZ10-3 (V60516)) (OPT ITEM 195B)	A,B,D	2

57-70-51

 ILLUSTRATED PARTS LIST
 01.1 Page 1030
 Nov 01/00

 **BOEING**
COMPONENT
MAINTENANCE MANUAL

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
197	AN960PD516L		..WASHER	A,B,D	2
200	HL79-10		DELETED		
200A	BACN10JC5		..NUT	A,B,D	2
205	BACB30NN5K28		DELETED		
205A	BACB30NN5K27		..BOLT-	A,B,D	3
			(OPT ITEM 205B)		
-205B	BACB30NN5K26		..BOLT-	A,B,D	3
			(OPT ITEM 205A)		
210	113T5102-6		..SHIM	A,B,D	1
215	BACF3T01D06-06		..FILLER	A,B,D	3
220	BACN10GW5		..NUT-	A,B,D	3
			(OPT ITEM 220A)		
-220A	BACN10JC5		..NUT-	A,B,D	3
			(OPT ITEM 220)		
			-----*		
225	BACB28AM17B027A		...BUSHING	A,B,D	1
230	BACB28AP12P027		...BUSHING	A,B,D	1
235	113T5127-2		...FITTING-	A,B,D	1
-235A	113T5127-4		DELETED		
-235B	113T5127-4		DELETED		
240	113T5102-5		..STRIP-RUB	A,B,D	1
245	113T5111-1		..BOND ASSY-PNL	A,B,D	1
250	BAC27NCT0217		..MARKER-ALUMINUM FOIL	D	1

- Item Not Illustrated

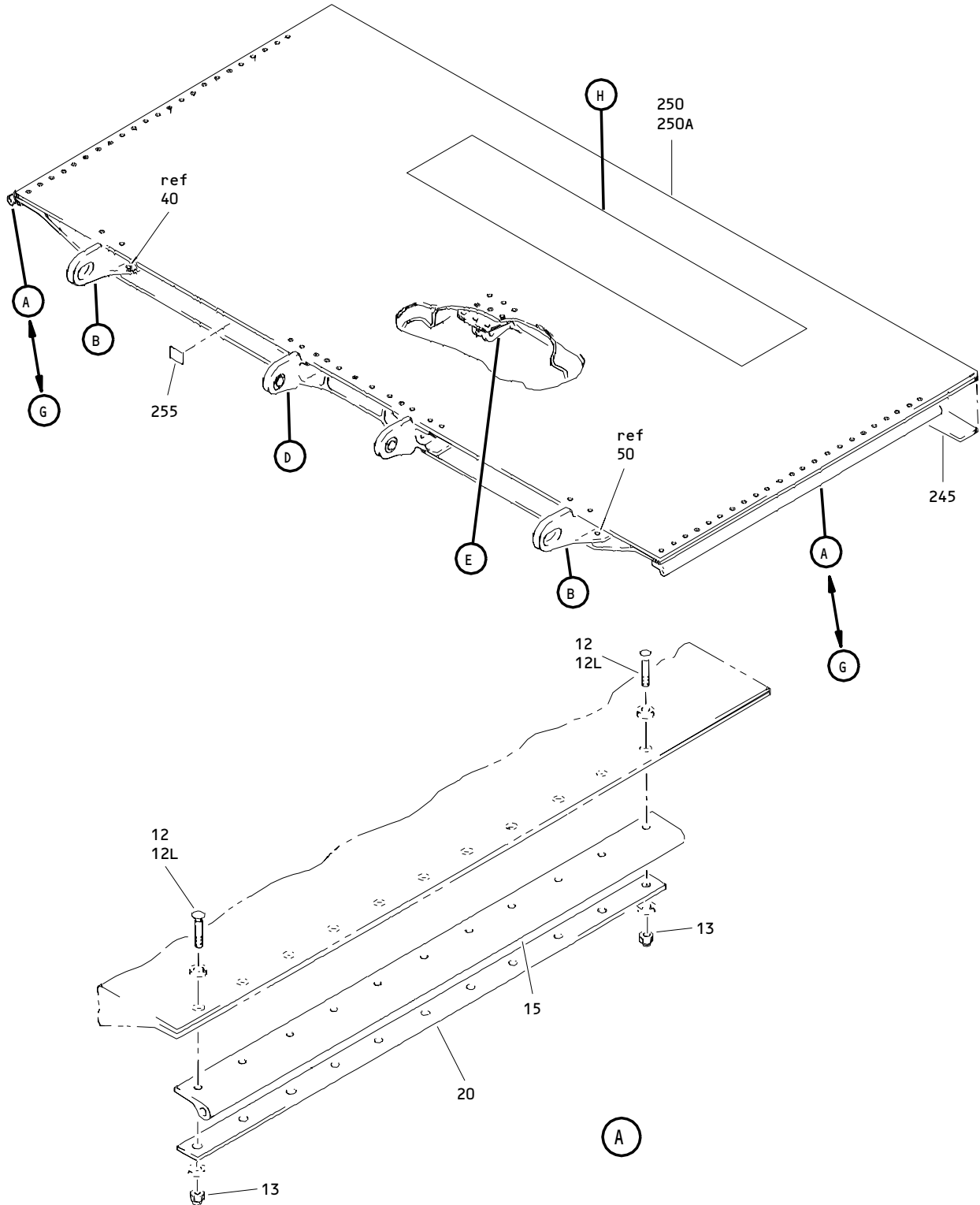
57-70-51

ILLUSTRATED PARTS LIST

01.1

Page 1031

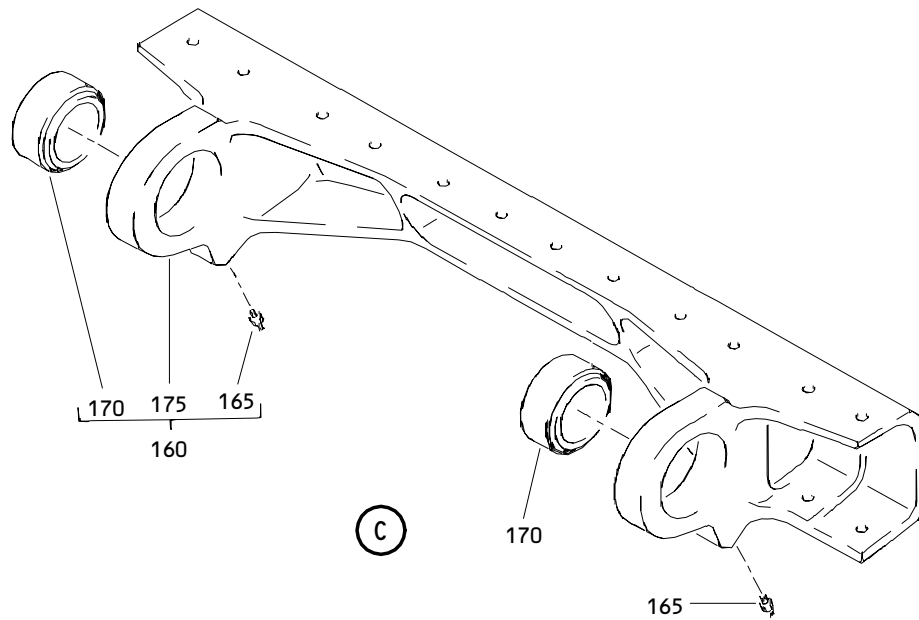
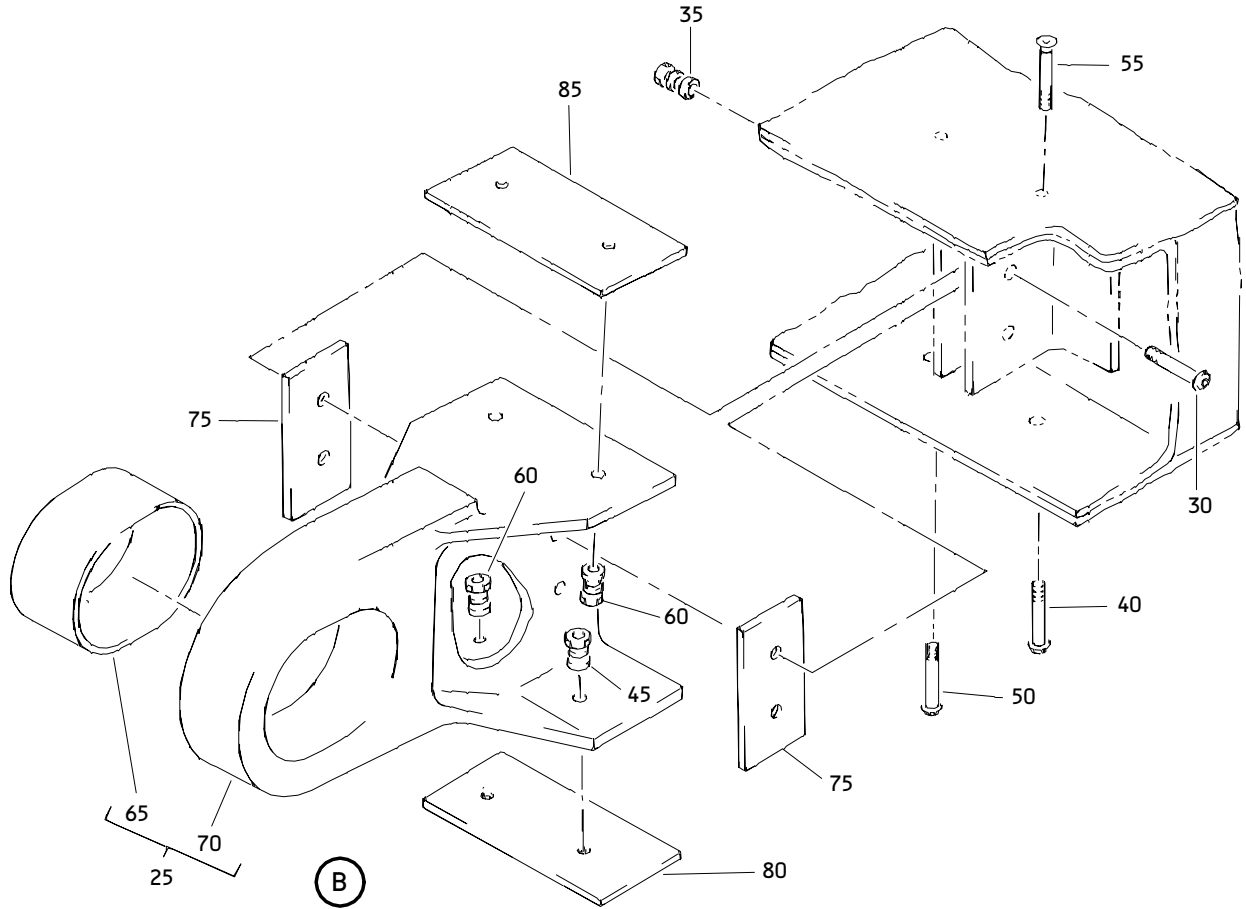
Nov 01/00



Outboard Spoiler Assembly
 Figure 2 (Sheet 1)

57-70-51

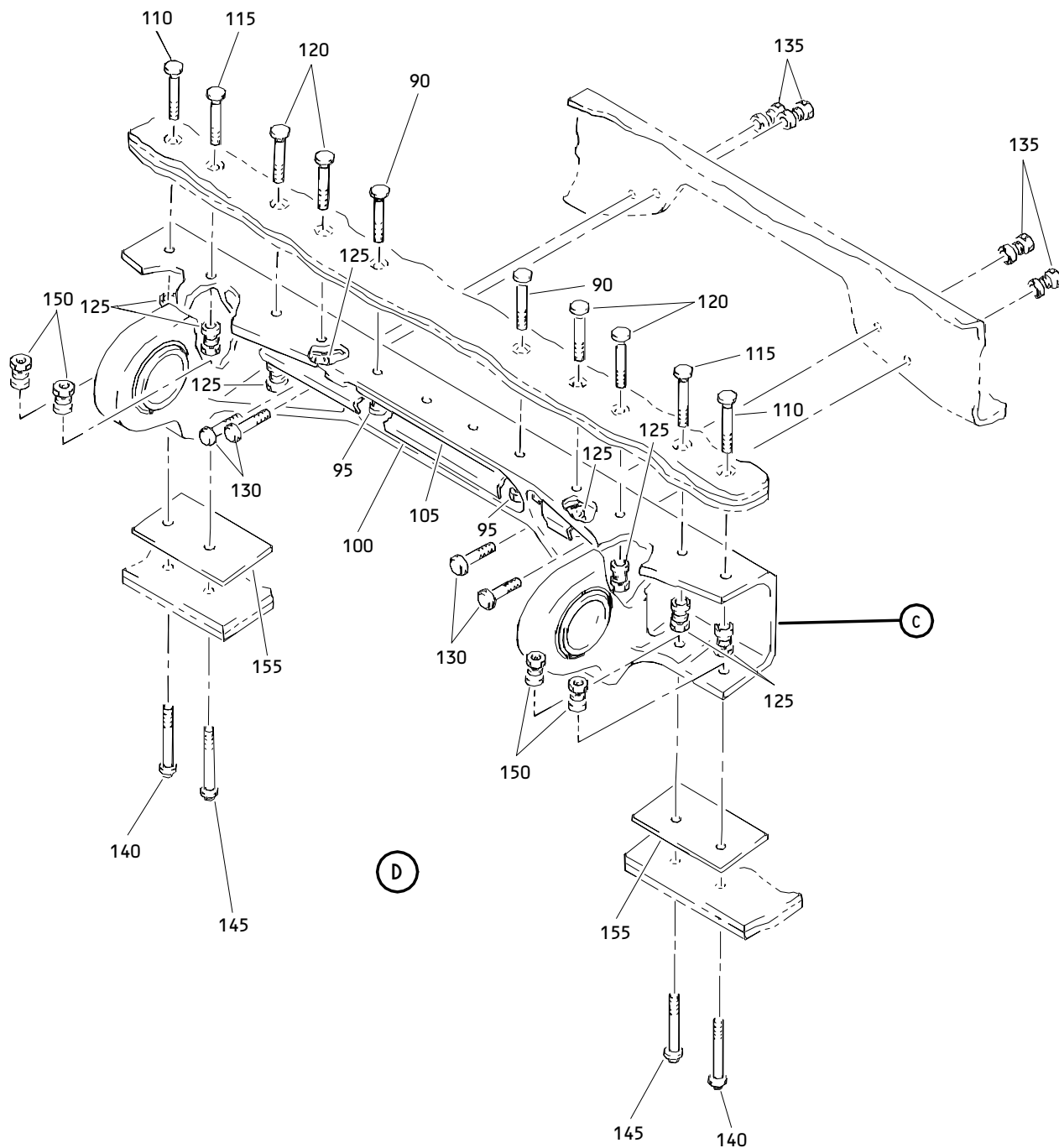
ILLUSTRATED PARTS LIST
 01.1 Page 1032
 Nov 01/00



Outboard Spoiler Assembly
Figure 2 (Sheet 2)

57-70-51

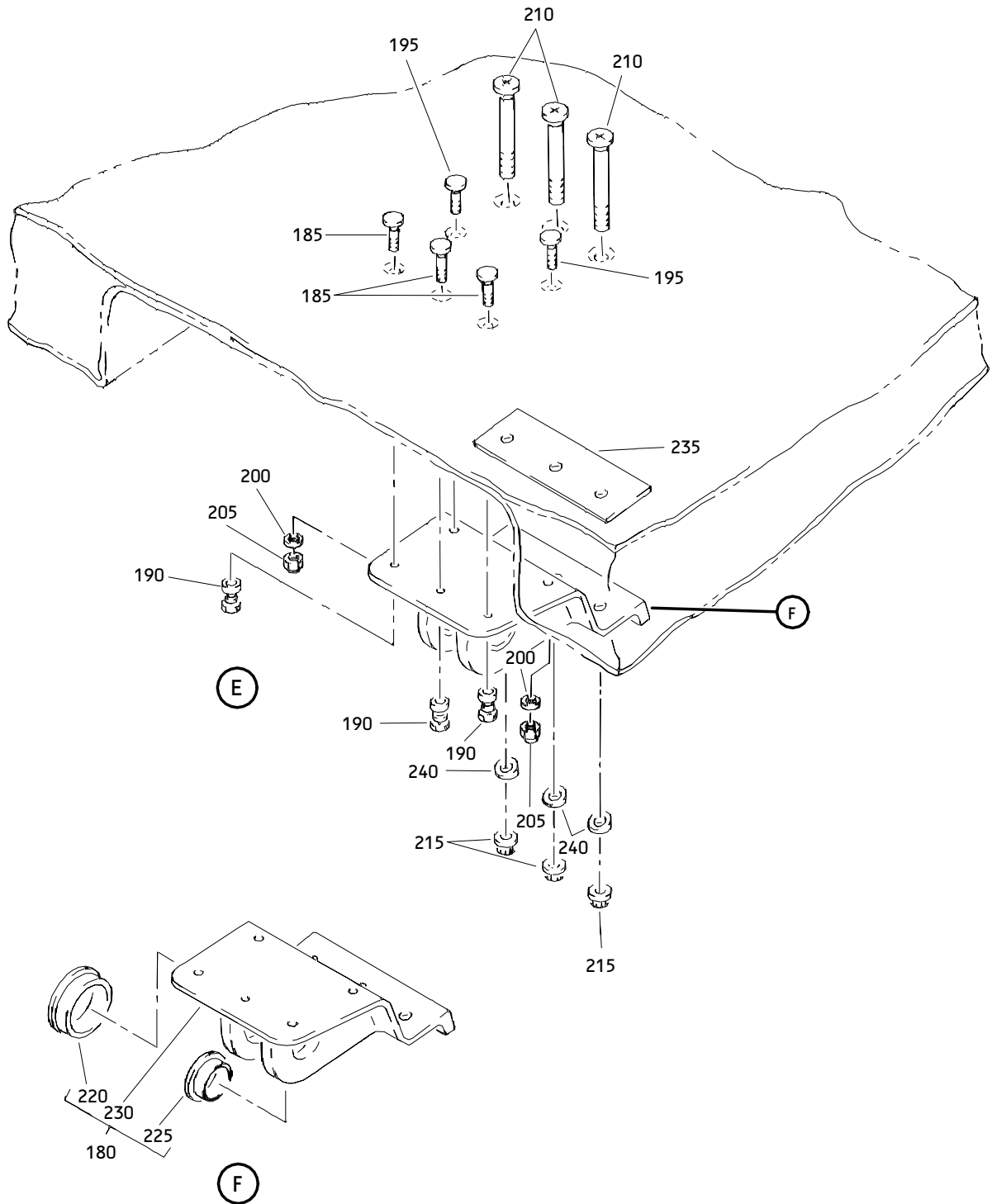
ILLUSTRATED PARTS LIST
01.1 Page 1033
Nov 01/00



Outboard Spoiler Assembly
Figure 2 (Sheet 3)

57-70-51

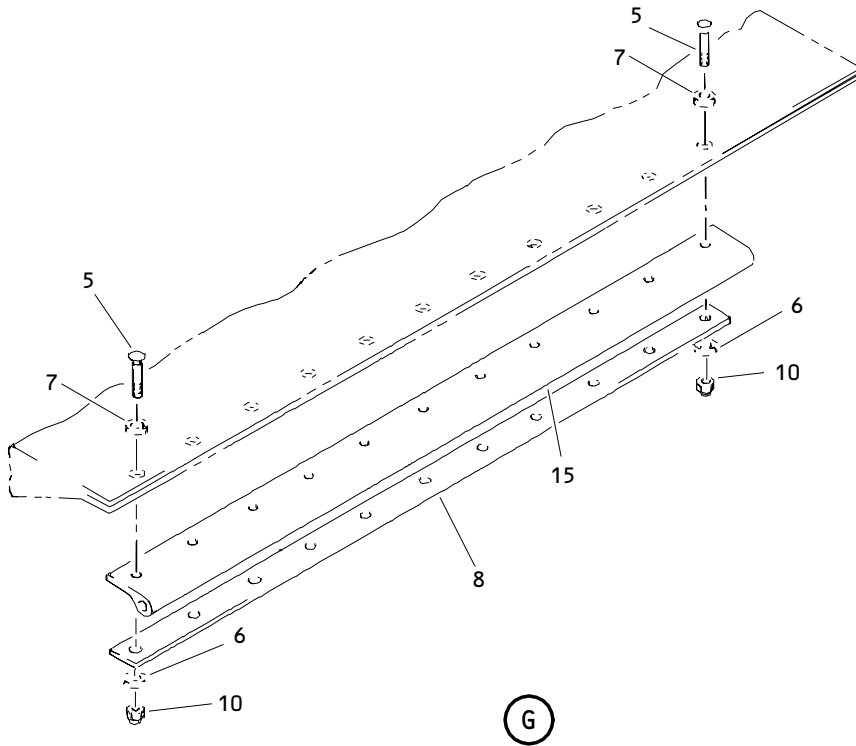
ILLUSTRATED PARTS LIST
01.1 Page 1034
Nov 01/00



Outboard Spoiler Assembly
Figure 2 (Sheet 4)

57-70-51

ILLUSTRATED PARTS LIST
01.1 Page 1035
Nov 01/00



WARNING
HAZARDOUS-AREA
 TO PREVENT AUTOMATIC RETRACTION IF HYDRAULIC PRESSURE IS APPLIED
 OR IF ELECTRICAL POWER IS LOST, DEACTIVATE SPOILERS/SPEEDBRAKE
 CONTROL SYSTEM PER MAINTENANCE MANUAL SECTION 27-61-00 BEFORE
 ENTERING AREA TO PERFORM ANY MAINTENANCE OPERATION.

260

(H)

Outboard Spoiler Assembly
 Figure 2 (Sheet 5)

57-70-51

ILLUSTRATED PARTS LIST
 01.1 Page 1036
 Nov 01/00

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02- -1	113T5102-10SP		SPOILER ASSY-OUTBD SPOILER (POST 767-27-0080)	C	RF
-1A	113T5102-14		SPOILER ASSY-OUTBD SPOILER (VARIABLE)	E	RF
-1B	113T5102-15		SPOILER ASSY-OUTBD SPOILER (VARIABLE) (PRE 767-27-0080)	F	RF
-1C	113T5102-17		SPOILER ASSY-OUTBD SPOILER (VARIABLE)	G	RF
-1D	113T5102-18		SPOILER ASSY-OUTBD SPOILER (VARIABLE)	H	RF
-1E	113T5102-19		SPOILER ASSY-OUTBD SPOILER (VARIABLE)	J	RF
R -1F	113T5102-21		SPOILER ASSY-OUTBD SPOILER (VARIABLE)	L	RF
R -1G	113T5102-22SP		SPOILER ASSY-OUTBD SPOILER	M	RF
R -1H	113T5102-23		SPOILER ASSY-OUTBD SPOILER	N	RF
5	BACB30NN3K3		.BOLT	E,F	24
6	BACW10BP3APU		.WASHER- (ITEM 6 PLUS ITEM 7 OPT TO ITEM 8)	E,F	24
R 7	113T5102-7		.WASHER- (ITEM 6 PLUS ITEM 7 OPT TO ITEM 8)	E,F	24
R 8	113T5102-8		.RETAINER- (ITEM 6 PLUS ITEM 7 OPT TO ITEM 8)	E,F	2
10	BACN10JC3CM		.NUT	E,F	24
R 12	BACB30NN3K3		.BOLT	C,G-J L-N	11

57-70-51

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 02-12L	BACB30NN3K2		.BOLT	C,G-J L-N	11
13	BACN10JC3CM		.NUT	C,G-J L-N	22
15	113T5102-4		.SEAL- (MFD FROM EXTRUSION RUBBER 10-60754-83 23.00 IN.)	C,G-J L-N	2
20	113T5102-11		.RETAINER- (OPT ITEM 20A)	C,G-J L-N	2
-20A	113T5102-12		.RETAINER- (OPT ITEM 20)	C,G-J L-N	2
25	113T5126-1		.FITTING ASSY-SIDE HINGE	C,E-J L-N	2
R 30	HL1012AZ6-8		ATTACHING PARTS .BOLT- (V97928) (SPEC BACB30NX6K8) (OPT HL12VAZ6-8 (V73197)) (OPT HL12VAZ6-8 (V92215)) (OPT HL12VAZ6-8 (V97928)) (OPT L802-6K8 (V06725)) (OPT HL12VAZ6-8 (V56878)) (OPT HL1012AZ6-8 (V0PTK6)) (OPT HL1012AZ6-8 (V06725)) (OPT HL1012AZ6-8 (V06950)) (OPT HL1012AZ6-8 (V17446)) (OPT HL1012AZ6-8 (V56878)) (OPT HL1012AZ6-8 (V60516)) (OPT HL1012AZ6-8 (V73197))	C,E-J L-N	4

57-70-51

 ILLUSTRATED PARTS LIST
 01.1 Page 1038
 Nov 01/00

 **BOEING**
COMPONENT
MAINTENANCE MANUAL

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-35	HL1187DU6		.COLLAR- (V73197) (SPEC BACC30X6S) (OPT HL87DU6 (V73197)) (OPT HL87DU6 (V92215)) (OPT HL1187DU6 (V56878)) (OPT HL1187DU6 (V92215)) (OPT HL87DU6 (V56878)) (OPT HL1187DU6 (V5M902))	C,E-J ,L-N	4
R 40	HL1012AZ8-5		.BOLT- (V0PTK6) (SPEC BACB30NX8K5) (OPT HL12VAZ8-5 (V73197)) (OPT HL12VAZ8-5 (V92215)) (OPT HL12VAZ8-5 (V97928)) (OPT L802-8K5 (V06725)) (OPT HL12VAZ8-5 (V56878)) (OPT HL1012AZ8-5 (V06725)) (OPT HL1012AZ8-5 (V06950)) (OPT HL1012AZ8-5 (V17446)) (OPT HL1012AZ8-5 (V56878)) (OPT HL1012AZ8-5 (V60516)) (OPT HL1012AZ8-5 (V73197)) (OPT HL1012AZ8-5 (V97928))	C,E-J ,L-N	2

57-70-51

ILLUSTRATED PARTS LIST
01.1 Page 1039
Nov 01/00

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-45	HL1187-8		.COLLAR- (V73197) (SPEC BACC30X8) (OPT HL87-8 (V73197)) (OPT HL87-8 (V92215)) (OPT HL1187-8 (V56878)) (OPT HL1187-8 (V92215)) (OPT HL87-8 (V56878)) (OPT HL1187-8 (V5M902))	C,E-J ,L-N	2
50	HL11VAZ8-5		.BOLT- (V56878) (SPEC BACB30NW8K5) (OPT B30NW8K5 (V97928)) (OPT HL11VAZ8-5 (V73197)) (OPT HL11VAZ8-5 (V92215)) (OPT HL11VAZ8-5 (V97928)) (OPT L803-8K5 (V06725)) (OPT HL11VAZ8-5 (V0PTK6)) (OPT HL11VAZ8-5 (V60516))	C,E-J ,L-N	2

57-70-51

 ILLUSTRATED PARTS LIST
 01.1 Page 1040
 Nov 01/00

 **BOEING**
COMPONENT
MAINTENANCE MANUAL

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-55	HL523AZ8-6		.BOLT- (V73197) (SPEC BACB30NZ8K6) (OPT L804-8K6 (V06725)) (OPT HL523AZ8-6 (V56878)) (OPT HL523AZ8-6 (V92215)) (OPT HL523AZ8-6 (V97928)) (OPT HL523AZ8-6 (V0PTK6)) (OPT HL523AZ8-6 (V60516)) (OPT HL523AZ8-6 (V06725))	C,E-J ,L-N	4
60	HL79-8		.COLLAR- (V56878) (SPEC BACC30M8) (OPT HL79-8 (V73197)) (OPT HL79-8 (V92215)) (OPT 66014-8 (V56878)) (OPT HL79-8 (V5M902)) -----*	C,E-J ,L-N	6

57-70-51

ILLUSTRATED PARTS LIST
01.1 Page 1041
Nov 01/00

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-65	69B00630-1		..LINER	C,E-J L-N	1
70	113T5126-2		..FITTING	C,E-J L-N	1
75	BACS40R10D16F		.SHIM	C,E-J L-N	4
80	BACS40R11C25F		.SHIM	C,E-J L-N	2
85	BACS40R15C25F		.SHIM	C,E-J L-N	2
90	HL523AZ8-8		.BOLT- (V73197) (SPEC BACB30NZ8K8) (OPT L804-8K8 (V06725)) (OPT HL523AZ8-8 (V56878)) (OPT HL523AZ8-8 (V92215)) (OPT HL523AZ8-8 (V97928)) (OPT HL523AZ8-8 (V0PTK6)) (OPT HL523AZ8-8 (V60516)) (OPT HL523AZ8-8 (V06725))	C,E-J L-N	4
95	HL79-8		.COLLAR- (V56878) (SPEC BACC30M8) (OPT HL79-8 (V73197)) (OPT HL79-8 (V92215)) (OPT 66014-8 (V56878)) (OPT HL79-8 (V5M902))	C,E-J L-N	4

57-70-51

 ILLUSTRATED PARTS LIST
 01.1 Page 1042
 Nov 01/00

 **BOEING**
COMPONENT
MAINTENANCE MANUAL

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-100	113T5105-1		.DEFLECTOR-PLATE	C,E-J L-N	1
105	BACS40R10E45F		.SHIM	C,E-J L-N	1
110	HL523AZ10-6		.BOLT- (V06725) (SPEC BACB30NZ10K6) (OPT L804-10K6 (V06725)) (OPT HL523AZ10-6 (V56878)) (OPT HL523AZ10-6 (V73197)) (OPT HL523AZ10-6 (V92215)) (OPT HL523AZ10-6 (V97928)) (OPT HL523AZ10-6 (V0PTK6)) (OPT HL523AZ10-6 (V60516))	C,E-J L-N	2
115	HL523AZ10-7		.BOLT- (V06725) (SPEC BACB30NZ10K7) (OPT L804-10K7 (V06725)) (OPT HL523AZ10-7 (V56878)) (OPT HL523AZ10-7 (V73197)) (OPT HL523AZ10-7 (V92215)) (OPT HL523AZ10-7 (V97928)) (OPT HL523AZ10-7 (V0PTK6)) (OPT HL523AZ10-7 (V60516))	C,E-J L-N	2

57-70-51

ILLUSTRATED PARTS LIST
01.1 Page 1043
Nov 01/00

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-120	HL523AZ10-8		.BOLT- (V56878) (SPEC BACB30NZ10K8) (OPT L804-10K8 (V06725)) (OPT HL523AZ10-8 (V92215)) (OPT HL523AZ10-8 (V73197)) (OPT HL523AZ10-8 (V06725)) (OPT HL523AZ10-8 (V97928)) (OPT HL523AZ10-8 (V0PTK6)) (OPT HL523AZ10-8 (V60516))	C,E-J ,L-N	4
125	HL79-10		.COLLAR- (V56878) (SPEC BACC30M10) (OPT HL79-10 (V73197)) (OPT HL79-10 (V92215)) (OPT 66014-10 (V56878)) (OPT HL79-10 (V5M902))	C,E-J ,L-N	8

57-70-51

 ILLUSTRATED PARTS LIST
 01.1 Page 1044
 Nov 01/00

 **BOEING**
COMPONENT
MAINTENANCE MANUAL

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 02-130	HL1012AZ8-4		.BOLT- (V0PTK6) (SPEC BACB30NX8K4) (OPT HL12VAZ8-4 (V73197)) (OPT HL12VAZ8-4 (V92215)) (OPT HL12VAZ8-4 (V97928)) (OPT L802-8K4 (V06725)) (OPT HL12VAZ8-4 (V56878)) (OPT HL1012AZ8-4 (V06725)) (OPT HL1012AZ8-4 (V06950)) (OPT HL1012AZ8-4 (V17446)) (OPT HL1012AZ8-4 (V56878)) (OPT HL1012AZ8-4 (V60516)) (OPT HL1012AZ8-4 (V73197)) (OPT HL1012AZ8-4 (V97928))	C,E-J L-N	4
135	HL1187-8		.COLLAR- (V73197) (SPEC BACC30X8) (OPT HL87-8 (V73197)) (OPT HL87-8 (V92215)) (OPT HL1187-8 (V56878)) (OPT HL1187-8 (V92215)) (OPT HL87-8 (V56878)) (OPT HL1187-8 (V5M902))	C,E-J L-N	4

57-70-51

ILLUSTRATED PARTS LIST
01.1 Page 1045
Nov 01/00

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE	EFF CODE	QTY PER ASSY
R 02-140	HL1012AZ10-6		1234567 .BOLT- (VOPTK6) (SPEC BACB30NX10K6) (OPT HL12VAZ10-6 (V73197)) (OPT HL12VAZ10-6 (V92215)) (OPT HL12VAZ10-6 (V97928)) (OPT L802-10K6 (V06725)) (OPT HL12VAZ10-6 (V56878)) (OPT HL1012AZ10-6 (V06725)) (OPT HL1012AZ10-6 (V06950)) (OPT HL1012AZ10-6 (V17446)) (OPT HL1012AZ10-6 (V56878)) (OPT HL1012AZ10-6 (V60516)) (OPT HL1012AZ10-6 (V73197)) (OPT HL1012AZ10-6 (V97928))	C, E-J , L-N	2

57-70-51

 ILLUSTRATED PARTS LIST
 01.1 Page 1046
 Nov 01/00

 **BOEING**
COMPONENT
MAINTENANCE MANUAL

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE	EFF CODE	QTY PER ASSY
R 02-145	HL1012AZ10-7		1234567 .BOLT- (V0PTK6) (SPEC BACB30NX10K7) (OPT HL12VAZ10-7 (V73197)) (OPT HL12VAZ10-7 (V92215)) (OPT HL12VAZ10-7 (V97928)) (OPT L802-10K7 (V06725)) (OPT HL12VAZ10-7 (V56878)) (OPT HL1012AZ10-7 (V06725)) (OPT HL1012AZ10-7 (V06950)) (OPT HL1012AZ10-7 (V17446)) (OPT HL1012AZ10-7 (V56878)) (OPT HL1012AZ10-7 (V60516)) (OPT HL1012AZ10-7 (V73197)) (OPT HL1012AZ10-7 (V97928))	C,E-J L-N	2
150	HL1187-10		.COLLAR- (V73197) (SPEC BACC30X10) (OPT HL87-10 (V73197)) (OPT HL87-10 (V92215)) (OPT HL1187-10 (V56878)) (OPT HL1187-10 (V92215)) (OPT HL87-10 (V56878)) (OPT HL1187-10 (V5M902))	C,E-J L-N	4

57-70-51

ILLUSTRATED PARTS LIST
01.1 Page 1047
Nov 01/00

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-155	BACS40R13C27F		.SHIM	C,E-J L-N	2
160	113T5128-5		.FITTING ASSY-CTR HINGE	C,E-J L-N	1
165	MS15001-1		..FITTING	C,E-J L-N	2
170	AG12V32C		..BEARING- (V15860) (SPEC BACB10FJ12GC) (OPT ASBFJ12VC (VS0352)) (OPT ASBFJ12VC (VS0352)) (OPT BWG12A111C (V16746)) (OPT HU12-210VC (V02758)) (OPT JC12G3C (V56644)) (OPT KSB12-61 (V97613)) (OPT LHB12EPGC (V73134))	C,E-J L-N	2
175	113T5128-6		..FITTING	C,E-J L-N	1
180	113T5127-1		.FITTING ASSY-ACTR	C,E-J L-N	1
185	HL523AZ8-5		ATTACHING PARTS .BOLT- (V56878) (SPEC BACB30NZ8K5) (OPT L804-8K5 (V06725)) (OPT HL523AZ8-5 (V92215)) (OPT HL523AZ8-5 (V73197)) (OPT HL523AZ8-5 (V0PTK6)) (OPT HL523AZ8-5 (V08524)) (OPT HL523AZ8-5 (V60516)) (OPT HL523AZ8-5 (V06725))	C,E-J L-N	3

57-70-51

 ILLUSTRATED PARTS LIST
 01.1 Page 1048
 Nov 01/00

 **BOEING**
COMPONENT
MAINTENANCE MANUAL

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE	EFF CODE	QTY PER ASSY
02-190	HL79-8		1234567 COLLAR- (V56878) (SPEC BACC30M8) (OPT HL79-8 (V73197)) (OPT HL79-8 (V92215)) (OPT 66014-8 (V56878)) (OPT HL79-8 (V5M902))	C,E-J L-N	3
195	HL523AZ10-4		BOLT- (V0PTK6) (SPEC BACB30NZ10K4) (OPT L804-10K4 (V06725)) (OPT HL523AZ10-4 (V56878)) (OPT HL523AZ10-4 (V73197)) (OPT HL523AZ10-4 (V92215)) (OPT HL523AZ10-4 (V97928)) (OPT HL523AZ10-4 (V60516)) (OPT HL523AZ10-4 (V06725)) (OPT ITEM 195A)	C,E-J L-N	2

57-70-51

ILLUSTRATED PARTS LIST
01.1 Page 1049
Nov 01/00

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02- -195A	HL523AZ10-3		.BOLT- (V06725) (SPEC BACB30NZ10K3) (OPT L804-10K3 (V06725)) (OPT HL523AZ10-3 (V56878)) (OPT HL523AZ10-3 (V73197)) (OPT HL523AZ10-3 (V92215)) (OPT HL523AZ10-3 (V97928)) (OPT HL523AZ10-3 (V0PTK6)) (OPT HL523AZ10-3 (V60516)) (OPT ITEM 195)	C,E-J ,L-N	2
200	AN960PD516L		.WASHER	C,E-J ,L-N	2
205	BACN10JC5		.NUT	C,E-J ,L-N	2
210	BACB30NN5K27		.BOLT- (OPT ITEM 210A)	C,E-J ,L-N	3
-210A	BACB30NN5K26		.BOLT- (OPT ITEM 205A)	C,E-J ,L-N	3
215	BACN10GW5		.NUT- (OPT ITEM 215A)	C,E-J ,L-N	3
-215A	BACN10JC5		.NUT- (OPT ITEM 215) -----*-----	C,E-J ,L-N	3

57-70-51

 ILLUSTRATED PARTS LIST
 01.1 Page 1050
 Nov 01/00

BOEING
COMPONENT
MAINTENANCE MANUAL

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-220	BACB28AM17B027A		..BUSHING	C,E-J L-N	1
225	BACB28AP12P027		..BUSHING	C,E-J L-N	1
230	113T5127-2		..FITTING	C,E-J L-N	1
235	113T5102-6		.SHIM	C,E-J L-N	1
240	BACF3T01D06-06		.FILLER	C,E-J L-N	3
245	113T5102-5		.STRIP-RUB	C,E-J L-N	1
250	113T5111-14		.BOND ASSY-PNL	C,G-J L-N	1
250A	113T5111-18		.BOND ASSY-PNL	E,F	1
255	MS27253P3		.PLATE- (OPT ITEM 255A)	C,F,G J L-N	1
R-255A	MS27253F3		.PLATE-IDENT (OPT ITEM 255)	C,F,G J L-N	1
260	BAC27NCT0217		.MARKER-ALUMINUM FOIL	E,H,J N	1

- Item Not Illustrated

57-70-51

ILLUSTRATED PARTS LIST
01.1 Page 1051
Nov 01/00