TO: ALL HOLDERS OF CONTROL STAND THRUST LEVER ASSEMBLY COMPONENT MAINTENANCE MANUAL, 76-11-19

REVISION NO. 9 DATED JUL 01/04

HIGHLIGHTS

All of the data that was formerly in manual CMM 76-11-21 is now included in this manual, CMM 76-11-19.

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 the revision number and date on the Record of Revision Sheet.

CHAPTER/SECTION AND PAGE NO.	DESCRIPTION OF CHANGE
1002-1036,1039-1045, 1051-1066,1073-1080B, 1080K-1080X,1082G-1082R, 1084A-1084M	Added new IPL part lists.

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CONTROL STAND THRUST LEVER ASSEMBLY

PART NUMBERS

253T5800-9, -13, -15, -17, -19, -21, -23, -25, -27, -29,-31, -33, -35, -37, -39

015T0094-15, -16

015T0156-2

015T0630-17 THRU -21

COMPONENT MAINTENANCE MANUAL
WITH
ILLUSTRATED PARTS LIST

4229

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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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TEMPORARY REVISION AND SERVICE BULLETIN RECORD

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVE	DATE OF INCORPORATION INTO MANUAL
		PRR B10344	JAN 10/82
		PRR C12010	JAN 10/83
		PRR C12011	JAN 10/83
		PRR C12012	JAN 10/83
		PRR C12013	JAN 10/83
		PRR C12014	JAN 10/83
		PRR C12015	JAN 10/83
		PRR C12016	JAN 10/83
		PRR B10820	JAN 10/83
		PRR B10900	APR 10/83
		PRR B10793-2	JUL 10/83
767-76-8		PRR B11242	JAN 10/86
		PRR C12223	JAN 10/86
767-78-4		PRR B10793 &-1	JAN 10/86
767-76-17		PRR B11554	JAN 01/92
	76-1		JUL 01/90
	76-2		APR 01/92
767-76-31		PRR B12104	APR 01/92
		PRR C12346	APR 01/92
767-76-0031			MAR 01/02

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PAGE	DATE	CODE
76-11-19		
TITLE PAGE		
1	MAR 01/02	01.1
2	BLANK	
REVISION RECORD		
1	MAR 01/02	01.1
2	BLANK	
TR & SB RECORD		
1	MAR 01/02	01.1
2	BLANK	
LIST OF EFFECTIVE PAGES		
*1	JUL 01/04	01
THRU LAST PAGE		
CONTENTS		
1	MAR 01/02	01.1
2	BLANK	
INTRODUCTION		
1	MAR 01/02	01.1
2	BLANK	
DESCRIPTION & OPERATION		
1	MAR 01/02	01.1
2	MAR 01/02	01.1
3	MAR 01/02	01.1
4	MAR 01/02	01.1
TESTING & TROUBLE SHOOTING		
101	MAR 01/02	01.1
102	MAR 01/02	01.1
103	MAR 01/02	01.1
104	MAR 01/02	01.1
105	MAR 01/02	01.1
106	MAR 01/02	01.1
107	MAR 01/02	01.1
108	MAR 01/02	01.1
109	MAR 01/02	01.1

PAGE	DATE	CODE
TESTING & TROUBLE SHOOTING		CONT.
110	BLANK	
DISASSEMBLY		
301	MAR 01/02	01.1
302	MAR 01/02	01.1
303	MAR 01/02	01.1
304	MAR 01/02	01.1
305	MAR 01/02	01.1
306	MAR 01/02	01.1
307	MAR 01/02	01.1
308	MAR 01/02	01.1
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CLEANING		
401	MAR 01/02	01.1
402	MAR 01/02	01.1
CHECK		
501	MAR 01/02	01.1
502	MAR 01/02	01.1
503	MAR 01/02	01.1
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REPAIR-GENERAL		
601	MAR 01/02	01.1
602	MAR 01/02	01.1
603	MAR 01/02	01.1
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REPAIR 1-1		
601	MAR 01/02	01.1
602	MAR 01/02	01.1
603	MAR 01/02	01.1
604	MAR 01/02	01.1
REPAIR 2-1		
601	MAR 01/02	01.1
602	MAR 01/02	01.1
603	MAR 01/02	01.1
604	MAR 01/02	01.1

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PAGE	DATE	CODE
REPAIR 3-1		
601	MAR 01/02	01.1
602	MAR 01/02	01.1
REPAIR 4-1		
601	MAR 01/02	01.1
602	MAR 01/02	01.1
REPAIR 5-1		
601	MAR 01/02	01.1
602	MAR 01/02	01.1
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601	MAR 01/02	01.1
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REPAIR 7-1		
601	MAR 01/02	01.1
602	MAR 01/02	01.1
REPAIR 8-1		
601	MAR 01/02	01.1
602	MAR 01/02	01.1
REPAIR 9-1		
601	MAR 01/02	01.1
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REPAIR 10-1		
601	MAR 01/02	01.1
602	MAR 01/02	01.1
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604	MAR 01/02	01.1
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606	MAR 01/02	01.1
607	MAR 01/02	01.1
608	MAR 01/02	01.1

PAGE	DATE	CODE
REPAIR 10-1		CONT.
609	MAR 01/02	01.1
610	MAR 01/02	01.1
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615	MAR 01/02	01.1
616	MAR 01/02	01.1
617	MAR 01/02	01.1
618	MAR 01/02	01.1
619	MAR 01/02	01.1
620	MAR 01/02	01.1
ASSEMBLY		
701	MAR 01/02	01.1
702	MAR 01/02	01.1
703	MAR 01/02	01.1
704	MAR 01/02	01.1
705	MAR 01/02	01.1
706	MAR 01/02	01.1
707	MAR 01/02	01.1
708	MAR 01/02	01.1
709	MAR 01/02	01.1
710	MAR 01/02	01.1
711	MAR 01/02	01.1
712	MAR 01/02	01.1
713	MAR 01/02	01.1
714	MAR 01/02	01.1
715	MAR 01/02	01.1
716	MAR 01/02	01.1
717	MAR 01/02	01.1
718	MAR 01/02	01.1
719	MAR 01/02	01.1
720	MAR 01/02	01.1
721	MAR 01/02	01.1
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PAGE	DATE	CODE
FITS AND CLEARANCES		
801	MAR 01/02	01.1
802	MAR 01/02	01.1
803	MAR 01/02	01.1
804	MAR 01/02	01.1
805	MAR 01/02	01.1
806	MAR 01/02	01.1
807	MAR 01/02	01.1
808	MAR 01/02	01.1
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810	MAR 01/02	01.1
811	MAR 01/02	01.1
812	MAR 01/02	01.1
813	MAR 01/02	01.1
814	BLANK	
SPECIAL TOOLS		
901	MAR 01/02	01.1
902	BLANK	
ILLUSTRATED PARTS LIST		
1001	MAR 01/02	01.1
*1002	JUL 01/04	01.1
*1003	JUL 01/04	01.1
*1004	JUL 01/04	01.1
*1005	JUL 01/04	01.1
*1006	JUL 01/04	01.1
*1007	JUL 01/04	01.1
*1008	JUL 01/04	01.1
*1009	JUL 01/04	01.1
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*1011	JUL 01/04	01.1
*1012	JUL 01/04	01.1
*1013	JUL 01/04	01.1
*1014	JUL 01/04	01.1
*1015	JUL 01/04	01.1
*1016	JUL 01/04	01.1
*1017	JUL 01/04	01.1
*1018	JUL 01/04	01.1
*1019	JUL 01/04	01.1
*1020	JUL 01/04	01.1
*1021	JUL 01/04	01.1
*1022	JUL 01/04	01.1

PAGE	DATE	CODE
ILLUSTRATED PARTS LIST		CONT.
*1023	JUL 01/04	01.1
*1024	JUL 01/04	01.1
*1025	JUL 01/04	01.1
*1026	JUL 01/04	01.1
*1027	JUL 01/04	01.1
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*1062	JUL 01/04	01.1
*1063	JUL 01/04	01.1
*1064	JUL 01/04	01.1

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PAGE	DATE	CODE
ILLUSTRATED PARTS LIST		CONT.
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*1080W	JUL 01/04	01.1
*1080X	JUL 01/04	01.1
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PAGE	DATE	CODE
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*1084K	JUL 01/04	01.1
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PAGE	DATE	CODE
ILLUSTRATED PARTS LIST		CONT.
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PAGE	DATE	CODE

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COMPONENT
MAINTENANCE MANUAL

TABLE OF CONTENTS

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INTRODUCTION

The instructions that are specified in this manual give the data necessary to do the maintenance functions that range from simple maintenance checks and part replacement to complete shop-type repair procedures.

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. 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:

Testing/TS: AUG 31/87
Disassembly: AUG 31/87
Assembly: AUG 31/87

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CONTROL STAND THRUST LEVER ASSEMBLY

DESCRIPTION AND OPERATION

1. Description

   A. The Control Stand Thrust Lever Assembly is an electromechanical assembly that controls the direction and the amount of engine thrust.

   B. The thrust lever assembly is made up of a left-engine and a right-engine thrust lever assembly, which are both co-located on the control stand inside the flight deck.

   C. Each lever assembly is made from the basic parts that follow:

      (1) A forward thrust select handle

      (2) A reverse thrust select handle

      (3) A number of internally mounted electric control switches

      (4) A wire bundle assembly connector

   D. Each lever assembly is connected to the auto-throttle brake assemblies through an output crank and a control rod assembly.

2. Operation

   A. During normal operation, forward thrust of the engine occurs when the thrust levers are moved to the forward position.

   B. Reverse thrust of the engine occurs when the thrust levers are moved to the aft position, which then operates the deployment of the thrust reverser and controls reverse thrust power.

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C. During forward thrust mode, the reverse thrust levers are mechanically locked in the stowed position in relation to the forward thrust lever, and cannot be moved.

D. When the reverse thrust lever is deployed, the forward thrust lever cannot be moved independently because it is held in the idle position.

3. Leading Particulars (Approximate)

Width -- 5 inches
Length -- 11 inches
Height -- 16 inches
Weight -- 18 pounds

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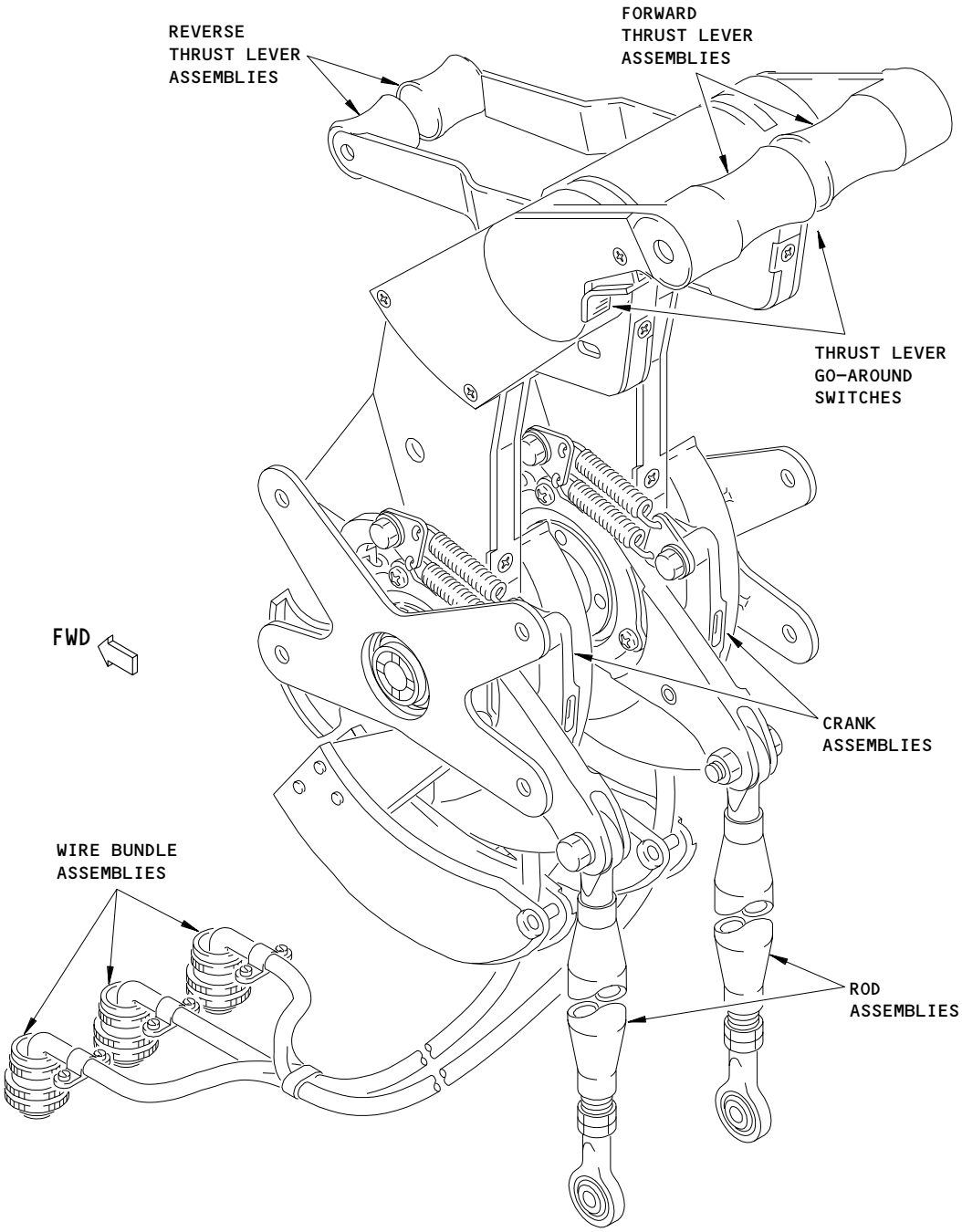

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015T0094-15,-16; 015T0156-2; 015T0630-17 THRU -21

253T5800-9,-13,-15,-17,-19,-21,-23,-25,-27,-29,-31,-33,-35,-37,-39
015T0094-15,-16; 015T0156-2; 015T0630-17 thru -21
Control Stand Thrust Lever Assembly
Figure 1 (Sheet 1)

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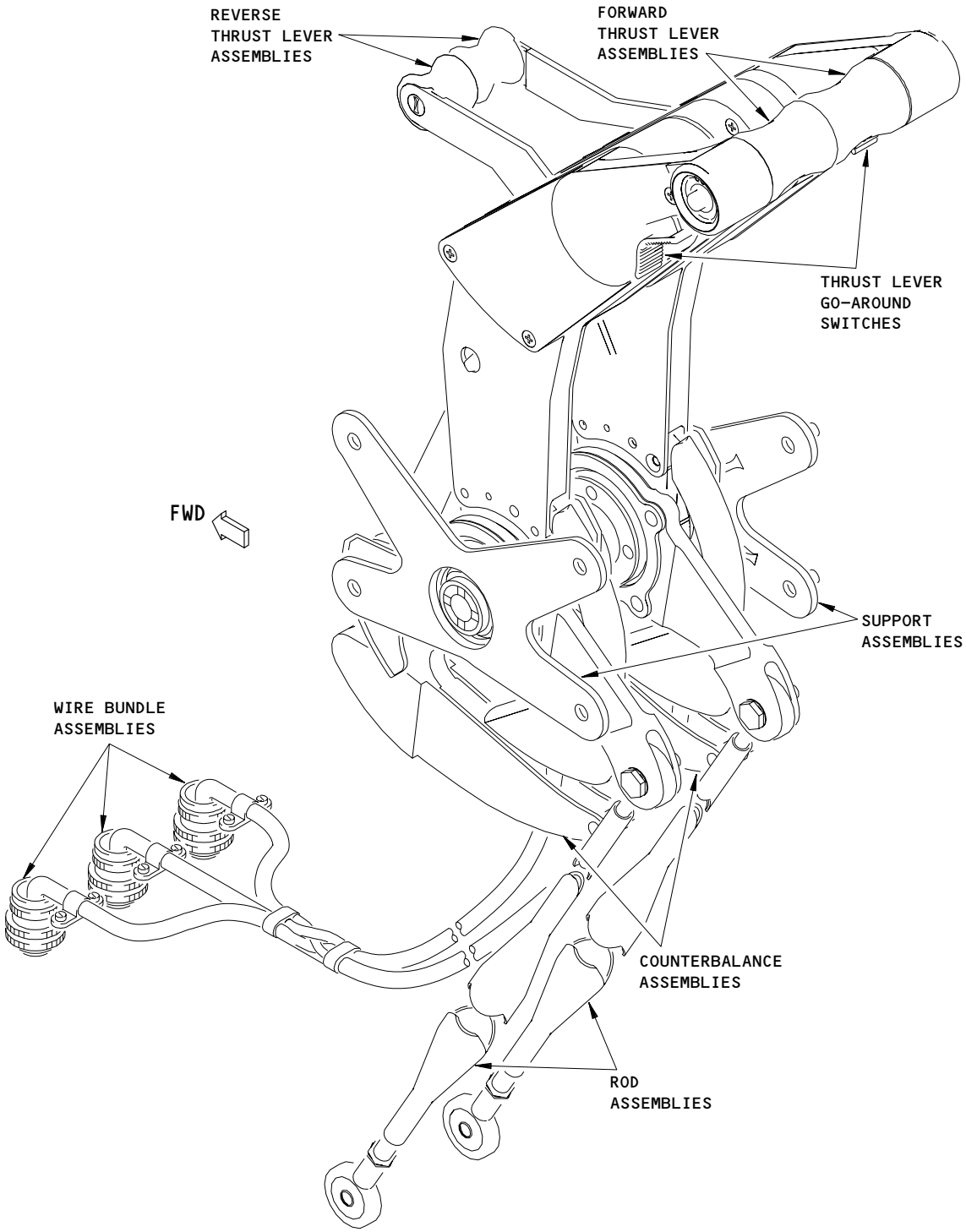

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015T0094-15,-16; 015T0156-2; 015T0630-17 thru -21
Control Stand Thrust Lever Assembly
Figure 1 (Sheet 2)

M46734

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TESTING AND TROUBLE SHOOTING

1. Test Equipment

NOTE: As an alternative, you can use an equivalent substitute.

A. Test fixture: A76001 to mount assembly for test

B. Adapter, cable set: A33003-13, -14, -23

C. Multimeter: Simpson Model 260

D. Breakout Box, Universal: A33003

E. Thrust Reverser Lever Assembly Protractor: G76002-15

F. Protractor Assembly: A27021-30

G. Reverse Thrust Lever Protractor Adapter: A27097-1

2. Test

A. Check mechanical operation.

(1) Lever assembly 253T5810-7, -8, -11 thru -16, 015T0630-5, -6 (Ref IPL Fig. 2 except as noted)

(a) Operate lever assemblies (105D, 110D, IPL Fig. 1) through full travel and check that lever assemblies rotate freely and independently without binding.

(b) Operate trigger (320, 320A) and check that cam rides smoothly on actuators (415) and operates switches (420) without obstruction.

1) Actuator (415) tangs may be bent a maximum of 0.06 inch to accomplish correct switch operation.

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2) Make sure that the trigger returns to initial position after being activated.

(c) Check switch (428) operation.

1) Remove screws (370A, 395), upper cover assembly (365) and lower cover (390) from lever (460, 462, 464, 466, 470, 472, 474).

2) Disconnect connector (425) from switch (428).

3) Make sure that the levers on the reverse thrust lever assembly (350, 355) are in the stowed position.

a) Attach one of the protractor assemblies, either the G76002-15 or the alternative A27021-30, to the reverse thrust lever assembly as shown in Fig. 101.

NOTE: If you use the A27021-30 protractor assembly, then you must also use the A27097-1 adapter to install the protractor assembly. See Fig. 101.

b) Adjust the position of the protractor assembly to prevent any interference with the angled part of the thrust lever.

c) After the protractor assembly has been installed, then set the protractor to zero degrees.

4) Slowly move the reverse thrust lever aft from the stowed off position.

a) Stop the movement of the reverse thrust lever when you hear a click sound from the switch.

b) Measure the angle that the reverse thrust lever moved when you heard the click sound.

c) For pre SB 76-31 configurations the measured angle must be 10-12 degrees.

d) For post SB 76-31 configurations the measured angle must be 10-26 degrees.

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CAUTION: DO NOT MAKE A SHARP BEND AT THE ROLLER SUPPORTS ON THE ACTUATOR ARM. YOU WILL DAMAGE THE SPOT WELDS AT THE SUPPORTS.

DO NOT BEND THE ACTUATOR ARM TOO MUCH AND THEN STRAIGHTEN THE ARM, YOU CAN CAUSE DAMAGE TO THE ACTUATOR ARM.

5) If the angle is not correct, bend the actuator arm of the switch to get the correct switch operation.

NOTE: The collected part tolerances may make it necessary to bend the actuator arm to get the correct angle.

a) Remove screws (410) that hold switch (428) to the reverse thrust lever.

b) Carefully bend the actuator arm down at the area of the roller support arms.

NOTE: Do not make a sharp bend on the actuator arm.

c) Install the switch (428) and actuator (427) with screws (410). Tighten screws.

d) Then do steps 2.A.(1)(c)3)f) thru 2.A.(1)(c)4)c).

e) Do these steps again until the switch operates at the correct angle.

6) After the switches have been found to operate at the correct angles, then remove the protractor assembly and its associated components from the reverse thrust lever.

7) Make sure that the actuator arm roller operates correctly on the center of the cam surface of the reverse thrust lever.

8) Make sure that the follower bearing (145) moves smoothly on the detent cam (225).

9) Install connector (425) to the switch (428).

10) Install lower cover (390) and upper cover assembly (365) to lever (460, 462, 464, 466, 470, 472, 474). Use screws (370A, 395) to install the parts.

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(d) Return reverse thrust lever to stowed position and check that lever latch (340) engages fully.

(2) Lever assembly 254N1131-7 thru -12, 17, 18, 015T0630-11, 012, -15, -16 (IPL Fig. 4 except as noted)

(a) Operate lever assemblies (450, 455) through full travel and check that lever assemblies rotate freely and independently without binding.

(b) Operate trigger (340, 345) and check that cam rides smoothly on actuators (50, IPL Fig. 3) and operates switches (55, IPL Fig. 3) without obstruction.

1) Actuator (50, IPL Fig. 3) tangs may be bent a maximum of 0.06 inch to accomplish switch operation.

2) Make sure trigger returns to original position after being actuated.

(c) Check switch (55, IPL Fig. 3) operation.

1) Remove screw (30, IPL Fig. 3) and cover (35, IPL Fig. 3) from lever (470, 475).

2) Disconnect connector (60, IPL Fig. 3) from switch (55, IPL Fig. 3).

3) Make sure that the reverse thrust lever (395, 400) is in the stowed position.

4) Attach the protractor assembly to the reverse thrust lever protractor adapter, (Fig. 101).

a) Attach the protractor assembly to the reverse thrust lever protractor adapter with two screws.

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b) Loosen the knurled wheel on the J-bolt.

c) Put the reverse thrust lever protractor adapter on the reverse thrust lever.

d) Adjust the position of the adapter to prevent the interference of the J-bolt with the angled part of the lever.

e) Tighten the knurled wheel to hold the adapter to the reverse thrust lever.

f) Set the protractor to zero degrees.

5) Slowly move the reverse thrust lever aft from the stowed off position.

a) Stop the movement of the reverse thrust lever when you hear a click sound from the switch.

b) Measure that angle that the reverse thrust lever moved when you heard the click sound.

c) For pre SB 76-31 configurations the measured angle must be 10-12 degrees.

d) For post SB 76-31 configurations the measured angle must be 10-26 degrees.

CAUTION: DO NOT MAKE A SHARP BEND AT THE ROLLER SUPPORTS ON THE ACTUATOR ARM. YOU WILL DAMAGE THE SPOT WELDS AT THE SUPPORTS.

DO NOT BEND THE ACTUATOR ARM TOO MUCH AND THEN STRAIGHTEN THE ARM, YOU CAN CAUSE DAMAGE TO THE ACTUATOR ARM.

6) If the angle is not correct, bend the actuator arm of the switch to get the correct operation of the switch.

NOTE: The collected part tolerances may make it necessary to bend the actuator arm to get the correct angle.

a) Remove the screws (45, IPL Fig. 3) that hold switch (55, IPL Fig. 3) to the reverse thrust lever.

b) Carefully bend the actuator arm down at the area of the roller support arms.

NOTE: Do not make a sharp bend on the actuator arm.

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c) Install the switch (55, IPL Fig. 3) and actuator (50, IPL Fig. 3) with screws (45, IPL Fig. 3). Tighten screws.

NOTE: Install switch shim (53, IPL Fig. 3) with switch (55, IPL Fig. 3) on the right lever assembly (240D, IPL Fig. 3).

d) Then do steps 2.A.(2)(c)4)f) thru 2.A.(2)(c)5)c).

e) Do these steps again until the switch operates at the correct angle.

7) Remove the protractor assembly and the reverse thrust lever protractor adapter from the reverse thrust lever.

8) Make sure that the actuator arm roller operates correctly on the center of the cam surface of the reverse thrust lever.

9) Install connector (60, IPL Fig. 3) to the switch (55, IPL Fig. 3).

10) Install cover (35, IPL Fig. 3) to lever (470, 475) using screw (30, IPL Fig. 3).

(d) Return reverse thrust lever (395, 400) to stowed position and check that latch (430) fully engages.

B. Lever assembly 253T5810-7, -8, -11 thru -16, 015T0630-5, -6 (IPL Fig. 2), and 254N1131-7 thru -12, -17, -18, 015T0630-11, -12, -15, -16 (IPL Fig. 4).

(1) After installation of the interlock latch (IPL Fig. 2, 240; IPL Fig. 4, 250), make sure that the latch is installed correctly.

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(2) Operate the latch to see if it moves freely without binding.

C. Check electrical continuity.

(1) Use a multimeter to check the switch operation and the circuit continuity between pins of connectors (120A, 125A, 130, IPL Fig. 1), (225, 230, 235, IPL Fig. 3) as shown in Fig. 701.

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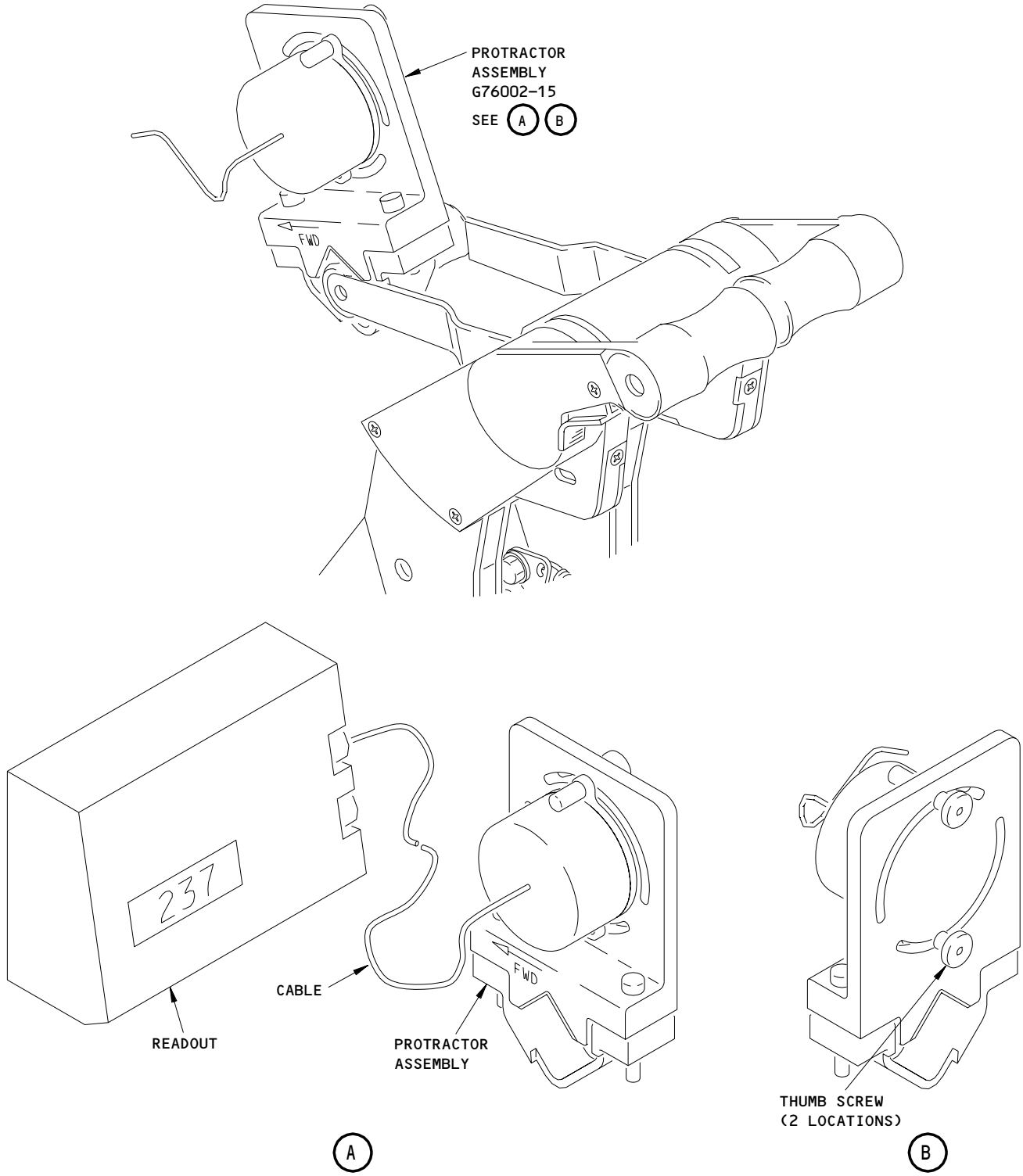

Thrust Reverser Lever Protractor Installation
Figure 101 (Sheet 1)

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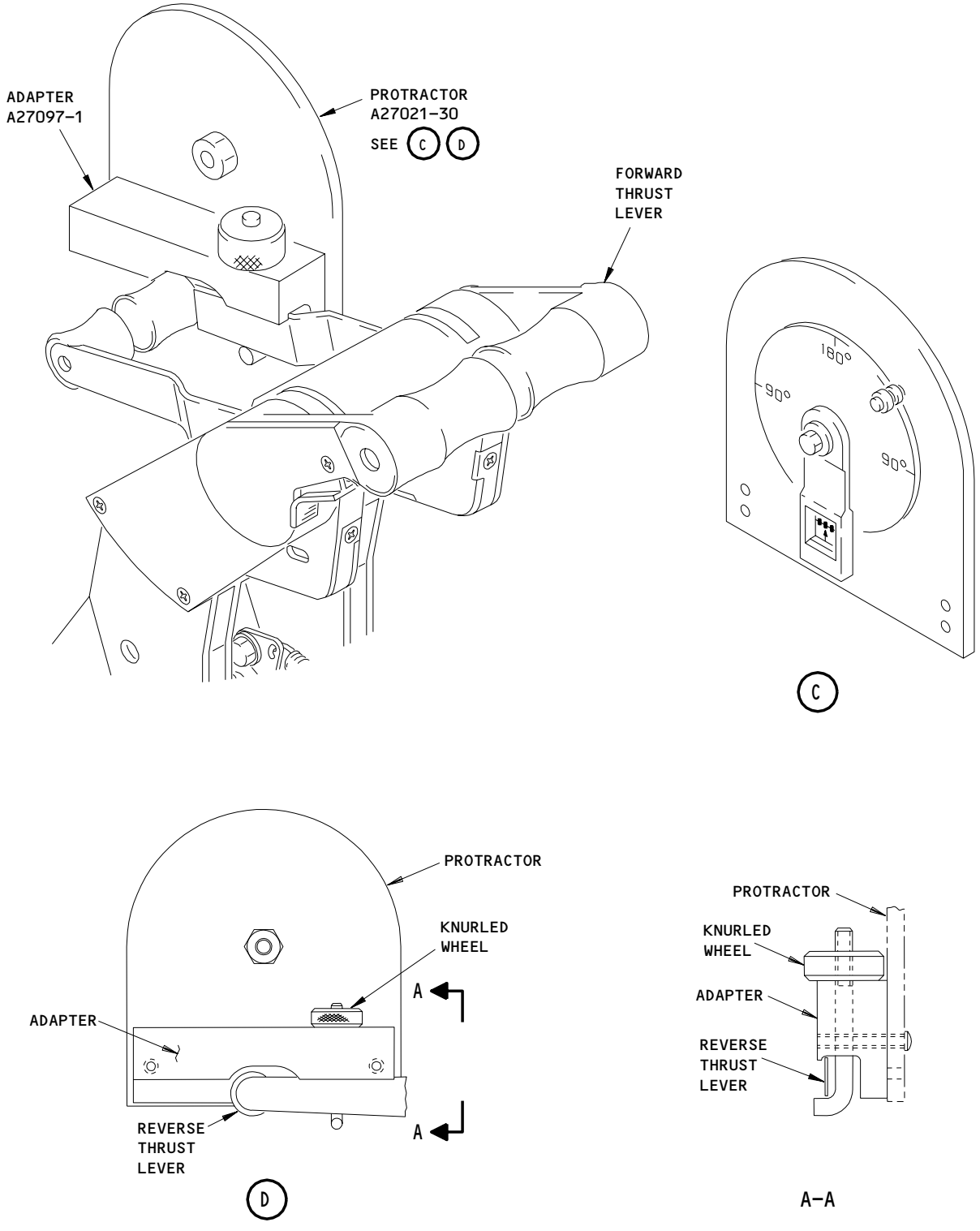

Thrust Reverser Lever Protractor Installation
Figure 101 (Sheet 2)

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DISASSEMBLY

1. Disassembly:

   A. The disassembly procedure that follows contains the data necessary to disassemble the Control Stand Thrust Lever Assembly.

   B. The Boeing Company recommends that you disassemble this lever assembly only when necessary to do the specified procedures that follow:

      (1) To complete any type of fault isolation

      (2) To find out if the parts are in a serviceable condition

      (3) To make any necessary repairs to the assembly unit

      (4) To put the assembly unit back into a serviceable condition.

   C. Where applicable, use standard industry practices to disassemble this assembly unit.

   D. Refer to IPL Fig. 1 thru 6 for the applicable item numbers.

NOTE: Refer to TESTING/TROUBLE SHOOTING to establish condition or probable cause of any malfunction and to determine extent of disassembly or repair.

NOTE: The following parts are recommended for replacement. Unless otherwise specified, actual replacement of parts may be based on in-service experience.

Rivets (40, 135, 317, 330, 360, 505, IPL Fig. 2), (85A, 100, 120, 236, IPL Fig. 3) (120, 350A, 365, 467, IPL Fig. 4), (280, 300, 320, IPL Fig. 5,6) cotter pin (103, IPL Fig. 1), (255, IPL Fig. 2), (70, IPL Fig. 3), (235, IPL Fig. 4), (130, 180, IPL Fig. 5,6) lockstitch, shrinkable tubing.

2. Disassembly of the Control Stand Thrust Lever Assembly

   A. 253T5800-9, -13, -15, -19, o15T0630-17, -18, -19, -20 (IPL Fig. 1)

      (1) Remove bolts (10), washers (15H), nuts (20) and rod assy (25A). Retain installation parts with thrust lever assembly.

      (2) Slide left support assy (65) from shaft assy (90).

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(3) Hold inner shaft (95). Use adapter B76004-1. Remove nut (50) and washer (45A).

NOTE: If inner shaft (95) disengages from outer shaft (100) without nut (50) removal, fill shaft cavity and faying surfaces with BMS 5-92, type 1 or 3 (SOPM 20-50-12) and torque inner shaft to 100-150 pound-inches. Allow to dry. Remove nut (50) and washer (45A).

(4) Slide right support assy (60) and spacer (30) off of shaft assy (90).

NOTE: Do not remove bearing (75B) from support (80) unless repair or replacement is necessary.

(5) Remove right lever assy (110D) from shaft assy (90).

(6) Remove bearing (55B) and spacers (35, 40).

(7) Remove shaft assy (90), bearing (55B) and spacer (35) from left lever assy (105D).

NOTE: Do not remove bearing (75C) from support (85) unless repair or replacement is necessary.

Do not disassemble shaft (90) unless repair is necessary. Shaft (95, 100) are bonded together and are not intended to be disassembled.

B. 253T5800-17, -21, -23, -25, -27, -29, -31, -33, -35, -37, -39, 015T0630-21 (IPL Fig. 3)

(1) Remove bolts (135), washers (140), nuts (145) and rod assy (150). Retain installation parts with thrust lever assembly.

(2) Slide left support assy (170) from shaft assy (155).

(3) Hold inner shaft (156) using adapter B76004-1. Remove nut (165) and washer (160).

NOTE: If inner shaft (156) disengages from outer shaft (157) without nut (165) removal, fill shaft cavity and faying surfaces with BMS 5-92, type 1 or 3 (SOPM 20-50-12) and torque inner shaft to 100-150 pound-inches. Allow to dry. Remove nut (165) and washer (160).

(4) Slide right support assy (185) and spacer (210) off of shaft assy (155).

NOTE: Do not remove bearing (190A) from support (195) unless repair or replacement is necessary.

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(5) Remove right lever assy (245A, 248) from shaft assy (155).

(6) Remove bearing (215) and spacers (200, 205).

(7) Remove shaft assy (155), bearing (215) and spacer (205) from left lever assy (240A, 243).

NOTE: Do not remove bearing (175B) from support (180) unless repair or replacement is necessary.

Do not disassemble shaft (155) unless repair is necessary. Shaft (156, 157) are bonded together and are not intended to be disassembled.

3. Disassemble Lever Assembly

A. 253T5810-7, -8, -11 THRU -16, 015T0630-5, -6 (IPL Fig. 2)

(1) Remove screws (265) and cover (260).

NOTE: Do not remove decals (475) unless replacement is specified.

(2) Remove screw (370A, 395) and remove cover (390, 365).

NOTE: Do not remove rivets (380) and spring (375) from cover (385) unless repair is necessary.

(3) Remove Switches and Wire Assembly.

(a) Remove knob (30). Remove soldered wires from switch (35), then remove switch.

(b) Detach connector (425) from switch (428).

(c) Detach switches (420, 428), shim (429) and actuators (415, 427) by removing screws (400, 405, 410).

NOTE: Do not remove wires from switches (420, 428) or from connector (425) unless repair or replacement is necessary.

Record orientation of switch (428) for use in assembly.

(d) Remove wires from connectors P1 (120A, IPL Fig. 1), P2 (130, IPL Fig. 1) and P3 (125A, IPL Fig. 1).

(e) Cut lockstitch from wire support assy (235) and pull wire bundle (115, IPL Fig. 1) through wire shield (230).

1) Cut one-piece sleeves to separate individual wire bundles.

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(f) Carefully pull wire bundles and attached switches (420) out of lever assembly (437, 447).

1) Pull connector (425, IPL Fig. 1) and attached wiring through rear slot in lever assembly.

B. 253T5800-17, -21, -23, -25, -27, -29, -31, -33, 015T0630-21 (IPL Fig. 3 except as noted)

(1) Remove screws (15) and covers (20, 25).

NOTE: Do not remove decals (310, 315) unless replacement is necessary.

(2) Remove screws (30) and cover (35).

(3) Remove Switches and Wire Assembly.

(a) Remove knob (10). Remove soldered wires from switch (5), then remove switch.

(b) Detach connector (60) from switch (55).

(c) Detach switches (55), shims (53) and actuators (50) by removing screws (45A, 40).

NOTE: Do not remove wires from switches (55) or from connector (60) unless repair or replacement is necessary.

Record orientation of switch (55, ref IPL Fig. 3, view K) for use in assembly.

(d) Remove wires from connectors P1 (230), P2 (235) and P3 (225).

(e) Cut lockstitch from wire shield (230, IPL Fig. 4) and pull wire bundle (220) through wire shield.

1) Cut one-piece sleeves to separate individual wire bundles.

(f) Carefully pull wire bundles and attached switches (55) out of lever assembly.

1) Pull connector (60) and attached wiring through rear slot in lever assembly.

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C. 253T5852-1 THRU -6 (IPL Fig. 5,6 except as noted)

(1) Remove screws (30, 350) and cover (35, 355).

NOTE: Do not remove decals (550, IPL Fig. 5), (560, IPL Fig. 6) unless replacement is required.

(2) Remove Switches and Wire Assembly.

(a) Remove knob (25). Remove ring (5), retainer (10), and packing (15).

1) Remove soldered wires from switch (542, IPL Fig. 5; 552, IPL Fig. 6), then remove switch.

(b) Detach switches (543, IPL Fig. 5; 553, IPL Fig. 6) and actuators (415) by removing screws (405, 410).

NOTE: Do not remove wires from switches (420) unless repair or replacement is necessary.

(c) Remove wires from connectors P1 (217A, IPL Fig. 3), P2 (218A, IPL Fig. 3) and P3 (216,IPL Fig. 3).

(d) Cut lockstitch from guide (195) and pull wire bundle (220, IPL Fig. 3) through guide (195).

1) Cut one-piece sleeves to separate individual wire bundles.

(e) Carefully pull wire bundles and attached switches (543, IPL Fig. 5; 553, IPL Fig. 6) out of lever assembly.

D. 253T5810-7, -8, -11 thru -16, 015T0630-5, -6 (IPL Fig. 2)

(1) With the lever (350) in the stowed position, remove spring (160).

(2) Release spring (270) from trigger (320), then remove screw (275), washers (280), nuts (285), and spring (270).

(3) Remove trigger (320) and link assembly (325) by removing bolt (290), washers (295, 300), rivet (317), stop (318), bushings (310, 315), and nut (305).

(4) Swing link assy (325) to expose screw (165A).

NOTE: Remove screw (165A) and bushing (170A).

(5) Remove springs (80) from plates (85), then remove bolts (90), washers (95, 100), bushings (105), and plates from crank assembly (175A) and follower assembly (125).

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(6) Detach follower assembly by removing bolt (110), washer (115), and bushing (120).

NOTE: Do not disassemble follower assembly unless repair or replacement is necessary.

Do not remove inserts (185, 190, 192) from crank (195) unless repair or replacement is necessary.

(7) Remove rivets (40), retainers (45, 50), and bearing (55).

(8) Remove crank assembly (175A) and attached parts from lever assembly (437, 447).

(9) Remove screws (65), washer (70), cam (60), and bearing (75) from crank assembly (175A).

(10) Detach detent cam (225), shield (230), wire support assembly (235) and counter weight assembly (480) from lever assembly (437, 447) by removing bolts (200, 485B), washers (212, 490A, 493), spacers (495) and nuts (217, 500B).

(11) Remove rivet (330) to separate bushing (335), lever latch (340), and link (345).

NOTE: Do not remove rivet (360) unless repair of link assembly is nececessary.

(12) Remove screw (20A) and knob (10).

(13) Remove cotter pin (255), pin (245), washers (250), and latch (240).

E. 254N1131-7 thru -10, -17, -18, 015T0630-5, -6 (IPL Fig. 4 except as noted)

(1) With reverse thrust lever (395, 400) in the stowed position, detach spring (165).

(a) Remove bolt (145), bushing (160A), washer (150), collar (155) and latch (430) from crank assembly (170).

(2) Remove springs (65).

(3) Remove bolts (70), washers (75, 80), bushings (85) and plates (90) from crank assy (170) and follower assy (110).

(4) Remove bolt (95), washer (100), follower assembly (110) and bushing (105) from crank assembly (170).

NOTE: Do not disassemble follower assembly (110) unless repair or replacement is necessary.

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(5) Remove screws (20A), retainers (25, 30), spacer (55), bearing (35).

(6) Remove crank assembly (170) and attached parts from lever assembly (450, 455).

(7) Remove screws (40), washers (45) cam (50) and bearing (60) from crank assembly (170).

(8) Remove screw (310), nut (325), washers (315) and spacer (320).

(9) Remove bolt (255), nut (305), washers (260 thru 295), bushing (300), springs (330, 335), triggers (340, 345) , rivet (236, IPL Fig. 3), stop (237, 238, IPL Fig. 3) and lever assemblies (375A, 380A) from thrust lever assemblies (450, 455).

(10) Remove bolt (405B), bushing (427), washers (410, 415), latch (430) and collar (420B) from link (445).

(11) Separate lever (395, 400) from arm (390A) by removing rivet (350A). Remove bushing (385).

(12) Remove screw (10) and knob (15).

(13) Remove latch (250) by removing cotter pin (235), washers (245) and pin (240).

(14) Remove wire shield (230), cam (225), counter weight (222) or shim (220) and counter weight (80, IPL Fig. 3) by removing bolts (190, 195), washers (205, 210), nuts (215) and spacers (200).

NOTE: Do not disassemble counter weight (80, IPL Fig. 3) further unless repair or replacement is necessary.

F. 253T5852-1 THRU -6 (IPL Fig. 5,6)

(1) Remove bolt (235A), washer (240A) and collar (245A).

(2) Remove screws (440A, 425A), retainer (445, 430), spacer (447, IPL Fig. 6) and bearing (435).

(3) Remove crank assembly (450) from handle assembly (505).

(4) Remove rivets (455), cam (460), bearing (465), sleeve (470A) and bearing (475) from crank (80).

(5) Remove counter weight (500) and guide (195) by removing bolts (145, 155B, 485A), washers (150A, 165, 170B, 490A), spacer (160) and nuts (175A, 495A).

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(6) Separate bearing support assembly (265) from handle assembly (505) by removing screws (200A,205A), (220A, IPL Fig. 5), bolt (210, 225) and washers (215A, 230A).

(7) Remove bolt (250A), washer (255B), link assembly (315), bearing (275) and cam (260A) from bearing support assembly (265).

(8) Remove spacer (272, IPL Fig. 5) and rivet (282, IPL fig. 5) from support (267).

(9) Remove knob (335) and screw (330).

NOTE: Do not remove rivet (320A) unless repair of lever (340) or link (325) is necessary.

(10) Remove screw (385A), washer (395A) and spacer (390).

CAUTION: RESTRAIN SPRING (400) WHEN REMOVING SCREW (385A). THE SPRING CAN UNCOIL AND CAUSE DAMAGE TO ADJACENT PARTS.

(11) Remove bolt (360A), spring (400), trigger (380), bushing (375), washer (365B) and nut (370A).

(12) Remove stop (345) from handle assembly (505).

(13) Remove spacer (545, IPL Fig. 6) and rivet (540, IPL Fig. 6).

(14) Remove nuts (50A, 55A), spacer (60A) and washer (65A).

(15) Lift plunger (95) out of spring (115A).

(16) Remove screw (40B), washer (45A) and bellcrank assembly (75A) from bearing support assembly (265).

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(17) Separate pin (80), cam roller (85), bellcrank (90) and plunger (95).

(18) Remove screws (100B), washers (105A), nuts (110A) and spring (115A).

NOTE: Do not disassemble bearing support assembly further unless repair is necessary.

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CLEANING

1. Materials

NOTE: If necessary, you can use equivalent substitutes.

A. Solvent -- Aliphatic naphtha, TT-N-95 (SOPM 20-60-01)

B. Solvent -- Isopropyl alcohol, MIL-E-5566 (SOPM 20-60-01)

2. Cleaning

A. The cleaning procedure that follows contains the data necessary to clean the Control Stand Thrust Lever Assembly.

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM chapters specified in this procedure.

C. Where applicable, refer to SOPM 20-30-03 and use standard industry practices to clean this assembly unit.

D. Refer to IPL Fig. 1 thru 6 for the applicable item numbers.

E. Plastic Parts (IPL Fig. 2 unless otherwise noted)

CAUTION: CLEANING FLUIDS (EXCEPT SOAP AND WATER SOLUTION) MUST NOT CONTACT PLASTIC PARTS.

(1) Wash knobs (10, 30, IPL Fig. 2), (10, IPL Fig. 3), (25, 335, IPL Fig. 5,6)), (15, IPL Fig. 4) and shield (230, IPL Fig. 2,4), (195, IPL Fig. 5,6) with mild soap and water solution.

(2) Dry plastic parts with clean, dry compressed air.

F. Electrical Parts

WARNING: MAKE CERTAIN ALL SOURCES OF FLASH OR FIRE ARE ELIMINATED FROM CONTACT WITH COMBUSTIBLE MATERIALS AND VAPORS.

CAUTION: DO NOT APPLY ABRASIVE CLEANING MATERIALS. MAKE CERTAIN SOLVENT BMS 3-2 OR OTHER CLEANING MATERIALS (EXCEPT NAPHTHA AND ALCOHOL) DO NOT CONTACT ELECTRICAL PARTS. CLEANING FLUIDS MUST NOT CONTACT PLASTIC OR RUBBER PARTS.

(1) Remove dust or foreign matter from connectors (120A, 125A, 130, IPL Fig. 1), (425, IPL Fig. 2), (60, 216, 217A, 218A, 225, 230, 235, IPL Fig. 3), switches (420, 428, IPL Fig. 2), (55, IPL Fig. 3), (543, IPL Fig. 5; 553, IPL Fig. 6) and wire bundle (115, IPL Fig. 1). Use mild air suction.

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(2) Clean electrical contacts of connectors with aliphatic naphtha or isopropyl alcohol.

(a) Dry with low pressure air.

(b) For cleaning relating to soldering, refer to SOPM 20-12-01.

(c) Clean terminal lugs and other bonding areas as given in SOPM 20-11-03.

G. Bearings -- Clean sealed bearings (55B, 75B, IPL Fig. 1), (55, 55A, 75, 145, IPL Fig. 2), (175A, 190A, 215, IPL Fig. 3), (35, 60, 130, IPL Fig. 4), (465, 275, 435, IPL Fig. 5,6) and teflon-lined bushing (150A, IPL Fig. 2), (135A, IPL Fig. 4) as given in the manufacturer's specifications.

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CHECK

1. Use standard industry practices to do a visual inspection of all of the component parts for defects or damage.

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

3. Refer to IPL Fig. 1 thru 6 for the applicable item numbers.

4. Do a magnetic particle inspection (SOPM 20-20-01) of the parts that follow:

   A. Figure 1.

      (1) Spacer (30), shaft (95, 100).

   B. Figure 2.

      (1) Cam (60), washer (140), follower (155), detent cam (225, 225A), latch (240), cover (260, 260A), stop (318, 319), trigger (320, 320A), lever latch (340), link (345), lever assembly (350, 355), levers (460, 462, 464, 466, 470, 472, 474, 476).

   C. Figure 3.

      (1) Shaft (156, 157, 157A), spacer (210).

   D. Figure 4.

      (1) Cam (50), follower (140, 140A), counterweight (222), detent cam (225, 225B), latch (250), spring (330, 330A, 330B, 330C, 335, 335A, 335B, 335C), latch (430, 430A).

   E. Figure 5,6.

      (1) Pin (80), cam roller (85), spring (115A), pawl (140A), cam (262), bellcrank support assembly (285), link (325), lever (340), stop (345), spring (400), cam (460).

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5. Do a dye penetrant inspection (SOPM 20-20-02) of the parts that follow:

A. Figure 1.

(1) Spacers (35, 40).

B. Figure 2.

(1) Bushings (170A, 335), crank assembly (175A), wire support assembly (235), support arms (520, 525).

C. Figure 3.

(1) Cover (20, 25), support arm (90), support (180, 195), spacers (200, 205), stop (237, 237A, 238, 238A).

D. Figure 4.

(1) Bushing (160A), crank (185), arm (390A, 390B), lever (395, 395A, 400, 400A, 470, 470A, 470B, 475, 475A, 475B), bushing (427), link (445, 445A).

E. Figure 5,6.

(1) Spring (70), bellcrank (90), support (267) , crank (480), handle (540, IPL Fig. 5), (550, IPL Fig. 6), spacer (447, IPL Fig. 6).

6. Check springs (80, 160, 270, IPL Fig. 2) for load limits per Fig. 501.

ITEM NO. IPL FIG. 2	ITEM NO. IPL FIG. 4	ITEM NO. IPL FIG. 5,6	INITIAL LENGTH (in.) 1	TEST LENGTH (in.)	ALLOWABLE LOAD LIMIT (lb.)
80	65		1.500	2.103-2.237	18.8 TENSION
160	165		1.375	1.947-2.074	7.2 TENSION
270			1.125	1.562-1.659	7.2 TENSION
160A			1.250	1.754-1.866	7.2 TENSION
		70	1.600	1.170-1.350	25.65 ±2.5 COMPRESSION

1 FOR REFERENCE USE ONLY

Spring Load Limits
Figure 501

601

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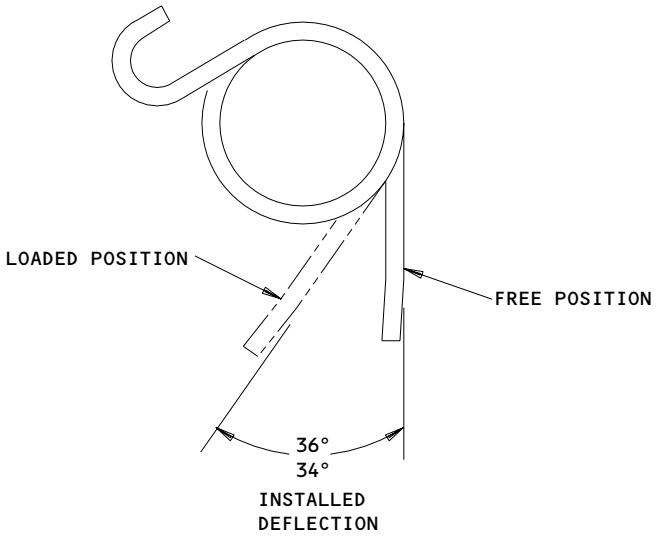

ITEM-FIG.	TEST DEFLECTION (DEGREES) (FROM FREE POSITION)	ALLOWABLE LOAD LIMITS (POUND-INCHES)
330-4 335-4 400-5,6	35	3.6-4.4

Torsion Spring Load Limits
Figure 502

A21718

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REPAIR - GENERAL

1. Content

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

P/N	NAME	REPAIR
253T5814 254N1132 253T5862 015T0630	LEVER ASSEMBLY	1-1
253T5819 254N1176	CRANK ASSEMBLY	2-1
253T5821 254N1173	SPACER	3-1
253T5823	TRIGGER	4-1
253T5827 254N1137	LEVER LATCH	5-1
253T5829 253T5830	SUPPORT ASSEMBLY	6-1
253T5833 254N1205	FOLLOWER ASSEMBLY	7-1
253T5838 253T5842 254N1141	COUNTERWEIGHT ASSEMBLY	8-1
- -	MISCELLANEOUS PARTS	9-1
253T5824 253T5855 254N1134 254N1210 015T0630	LINK ASSEMBLY	10-1

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2. Standard Practices

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

SOPM 20-30-02 Stripping of Protective Finishes
SOPM 20-30-03 General Cleaning Procedures
SOPM 20-41-01 Decoding Table for Boeing Finish Codes
SOPM 20-42-03 Hard Chrome Plating
SOPM 20-42-05 Bright Cadmium Plating
SOPM 20-43-01 Chromic Acid Anodizing
SOPM 20-50-03 Bearing Installation and Retention
SOPM 20-50-08 Application of Dry Lubricant

3. Materials

NOTE: If necessary, you can use equivalent substitutes.

A. Dry Lubricant -- BMS 3-8, Class A (SOPM 20-60-03)

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

C. Coating -- Black Nylon, Type 49, Thermoclad Corp, 14633 Carmenita Ave. Norwalk, CA 90650 (SOPM 20-60-02)

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—	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 WHICH 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 B WITHIN 0.002
// | 0.002 | A	PARALLEL TO 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 PLANE A
⌓ | 0.020 | A	SURFACES MUST LIE WITHIN PARALLEL BOUNDARIES 0.02 INCH APART AND EQUALLY DISPOSED ABOUT TRUE PROFILE
◎ | ∅ 0.0005 | C	CONCENTRIC TO C WITHIN 0.0005 DIAMETER
⌯ | 0.010 | A	SYMMETRICAL WITH A WITHIN 0.010
∠ | 0.005 | A	ANGULAR TOLERANCE 0.005 WITH 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, AND EXTENDING 0.510-INCH ABOVE, DATUM A, MAXIMUM MATERIAL CONDITION
2.000 OR 2.000 BSC	THEORETICALLY EXACT DIMENSION IS 2.000

NOTE: DATUM MAY APPEAR AT EITHER SIDE OF TOLERANCE FRAME

0.020 | A

A | 0.020

True Position Dimensioning Symbols
Figure 601

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LEVER ASSEMBLY - REPAIR 1-1

015T0630-3 THRU -6, -11, -12, -15, -16
253T5814-1, -2, -7, -8, -13, -14, -17, -18, -23, -24
253T5862-1, -2
254N1132-1, -2, -9, -10, -13, -14, -17, -18

NOTE: Refer to REPAIR - GENERAL section for a list of the applicable Chapter 20 standard practices. Also refer to the finish instructions given in Fig. 601, for the repair procedures to put back the initial finish to a specific part.

1. Bushed Hole Repair (253T5814-1, -2, -7, -8, -13, -14, -17, -18, -23, -24)

A. For the Lever Assemblies 253T5814-7, -8, -13, -14, -17 and -18 only, do the steps the follow:

(1) If necessary, you are permitted to remove a defect or damage from the 0.1895-0.1905 or the 0.314-0.315 diameter holes.

(2) Use the repair limits given by flagnote 6 in Fig. 601 to oversize the specified holes.

B. If you oversize the hole in the Lever Assemblies 253T5814-7, -8, -13, -14, -17, -18, then refer to Fig. 602 to manufacture the repair bushing to install in the repaired hole.

C. Use the shrink-fit method (SOPM 20-50-03) to install the repair bushing in the hole.

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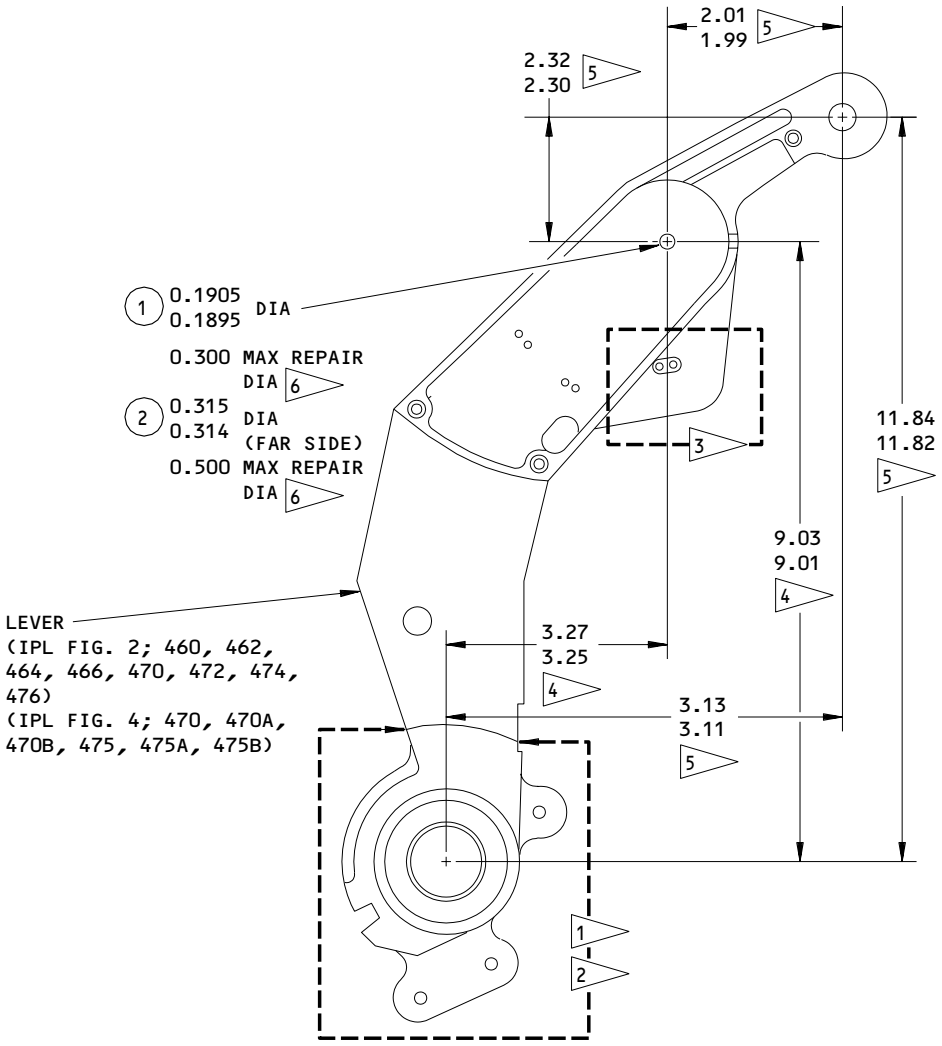

REFINISH

253T5814-3,-4,-9,-10,-15,-16,-19,-20,-25,-26:
PASSIVATE (F-17.09) AND THEN APPLY A LAYER OF CHROME PLATE (F-14.111) TO THE LEVER. DO NOT APPLY CHROME PLATE TO THE THREADED HOLES OR THE AREAS SPECIFIED BY FLAGNOTE 1. IT IS NOT NECESSARY TO CHROME PLATE THE INNER FACES OF THE LEVER.

254N1132-5,-6,-15,-16,-19,-20:
AN ANODIZE FINISH (F-30.015) IS NECESSARY. YOU MUST SEND THE LEVER TO TIODIZE CO. INC, (VENDOR CAGE CODE V34568) TO HAVE THEM APPLY A TYPE 2 TIODIZE FINISH.

LEVER
253T5814-3,-4,-9,-10,-15,-16,-19,-20,-25,-26 (SHOWN)
254N1132-5,-6,-15,-16,-19,-20 (SIMILAR)

015T0630-3 thru -6,-11,-12,-15,-16; 253T5814-1,-2,-7,-8,-13,-14,-17,-18,-23,-24;
253T5862-1,-2; 254N1132-1,-2,-9,-10,-13,-14,-17,-18;
Lever Assembly Repair
Figure 601 (Sheet 1)

4238

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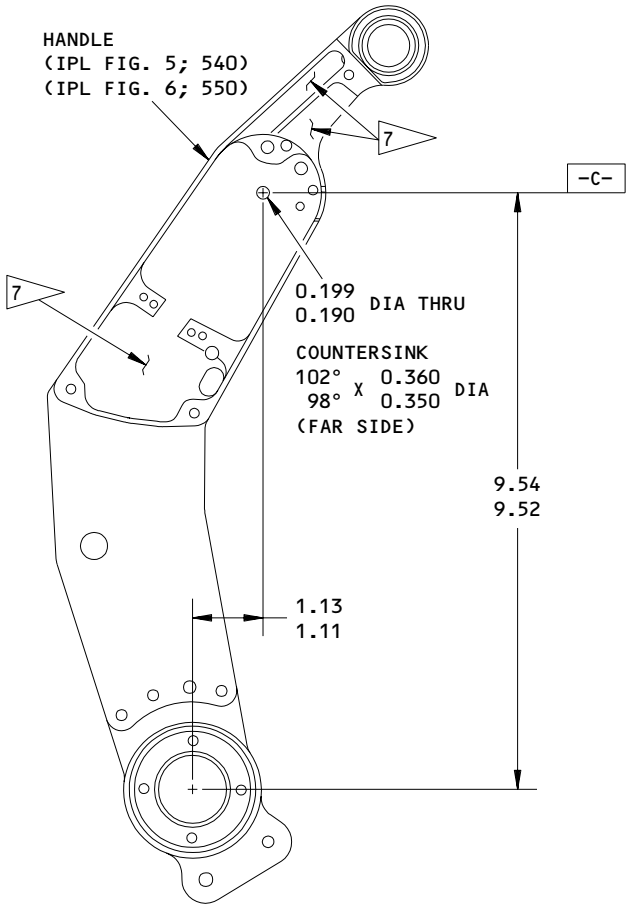

REFINISH

253T5862-3,-4:
SULFURIC ACID ANODIZE (F-14.2977 - 80893) THE LEVER, ALL OVER. IT IS NOT NECESSARY TO ANODIZE THE AREAS SPECIFIED BY FLAGNOTE 7.

LEVER
253T5862-3,-4

1. FOR LEVERS 253T5814-XX AND 254N1132-XX ONLY:
   ON THESE SPECIFIED AREAS, DO NOT CHROME PLATE THE SURFACES
2. 254N1132-5,-6 ONLY:
   AN ANODIZE FINISH (F-30.015) IS NECESSARY. YOU MUST SEND THE LEVER TO TIODIZE CO. INC, (VENDOR CAGE CODE V34568) TO HAVE THEM APPLY A TYPE 2 TIODIZE FINISH.
3. SEE SB 767-76-0031 FOR MODIFICATION IN THIS AREA
4. 253T5814-9,-10,-15,-16,-19,-20,-25,-26
5. 254N1132-5,-6,-15,-16,-19,-20
6. REPAIR LIMIT FOR INSTALLATION OF BUSHING 253T5814-3,-4,-9,-10,-15,-16,-19,-20,-25,-26 ONLY
7. IT IS NOT NECESSARY TO SULFURIC ACID ANODIZE (F-14.2977 - 80893) THESE AREAS

MATERIAL: 17-4PH CRES

ALL DIMENSIONS ARE IN INCHES

015T0630-3 thru -6,-11,-12,-15,-16; 253T5814-1,-2,-7,-8,-13,-14,-17,-18,-23,-24; 253T5862-1,-2; 254N1132-1,-2,-9,-10,-13,-14,-17,-18;
Lever Assembly Repair
Figure 601 (Sheet 2)

M47555

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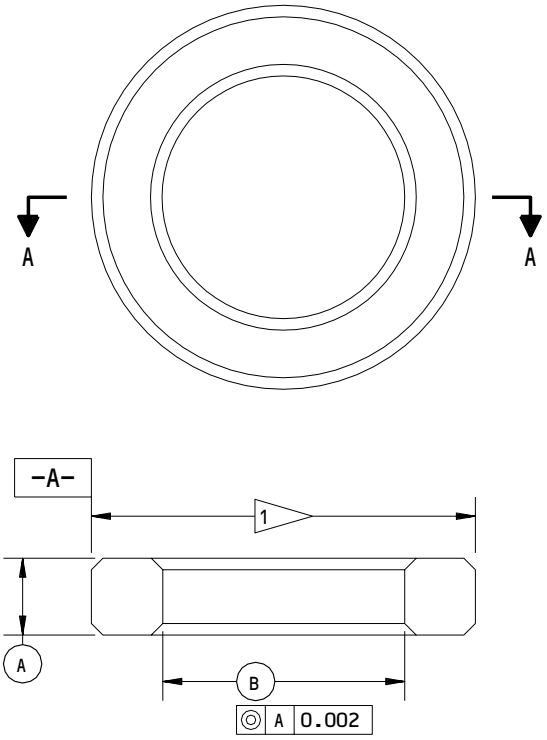

A-A

LOCATION (FIG. 601)	(A)	(B)	INTERFERENCE
(1)	0.11 0.09	0.1905 0.1895	0.0014 0.0009
(2)	0.11 0.09	0.3150 0.3140	0.0016 0.0010

63 ALL MACHINED SURFACES

BREAK SHARP EDGES

PASSIVATE (F-17.09)

MATERIAL: 15-5PH (AMS 5659)
HEAT TREAT TO 180-200 KSI
MAGNETIC PARTICLE INSPECT

ALL DIMENSIONS ARE IN INCHES

1 THE OUTSIDE DIAMETER OF THE BUSHING IS EQUAL TO THE REPAIR DIAMETER OF THE LEVER PLUS THE INTERFERENCE FIT

253T5814-1,-2,-7,-8,-13,-14,-17,-18,-23,-24
Repair Bushing Details
Figure 602

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CRANK ASSEMBLY - REPAIR 2-1

253T5819-3
254N1176-1

NOTE: Refer to REPAIR - GENERAL section for a list of the applicable Chapter 20 standard practices. Also refer to the finish instructions given in Fig. 601 for the repair procedures to put back the initial finish to a specific part.

1. Bushed Hole Repair

   A. Remove defects as required from 0.3750/0.3756 diameter hole in crank assembly (P/N 253T5819-3) to within repair limits as shown in Fig. 601.

   B. Manufacture bushing, Fig. 602, as required to compensate for material removed in step 1.A..

   C. Install the bushing by the shrink-fit method as given in SOPM 20-50-03.

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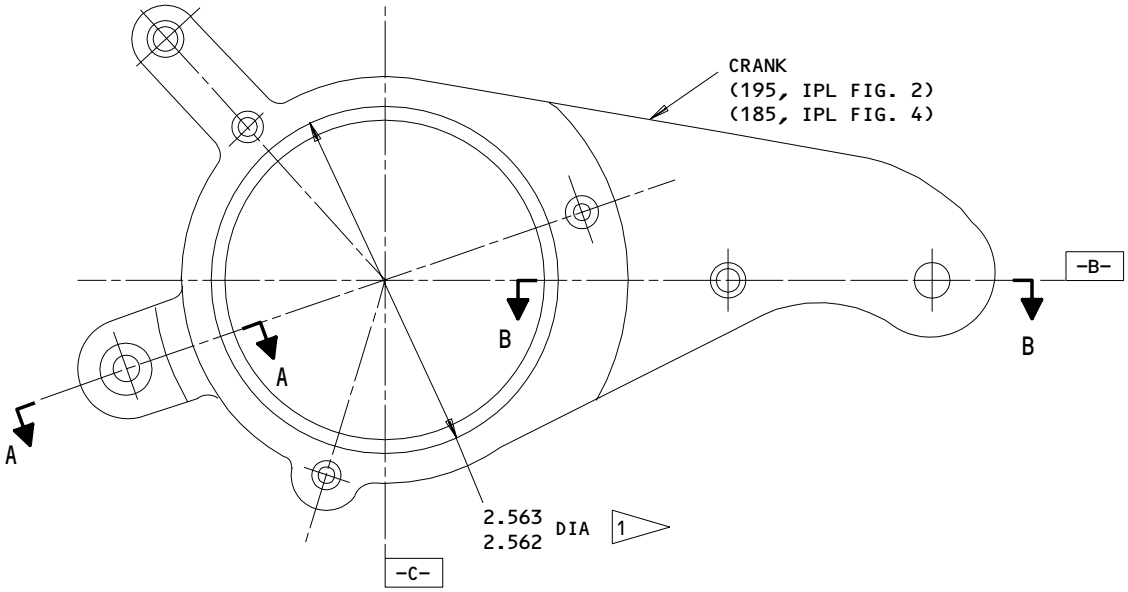
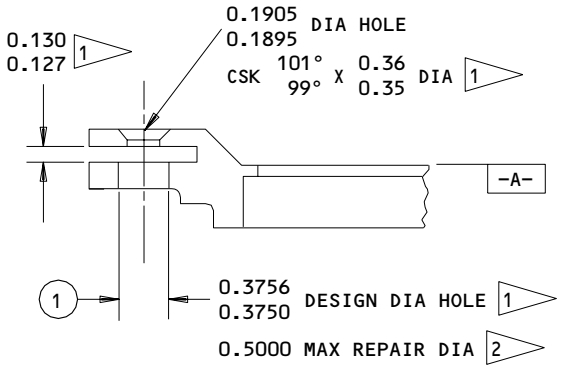
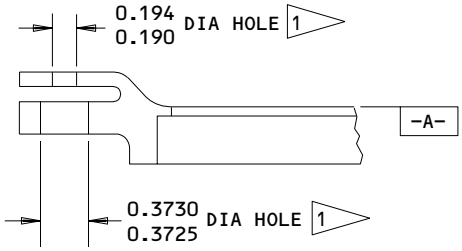


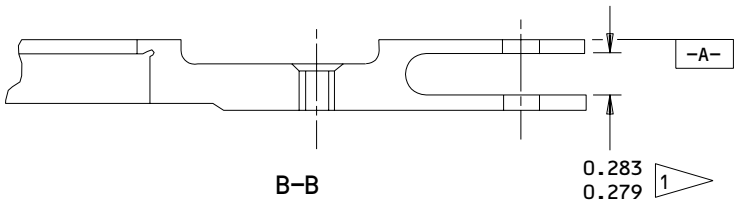
253T5819-3 SHOWN
254N1176-1 EQUIVALENT



253T5819-3
254N1176-1
A-A



254N1176-1
A-A



B-B

253T5819-3
253T5857-1
254N1176-1

Crank Assembly Repair
Figure 601 (Sheet 1)

A21734

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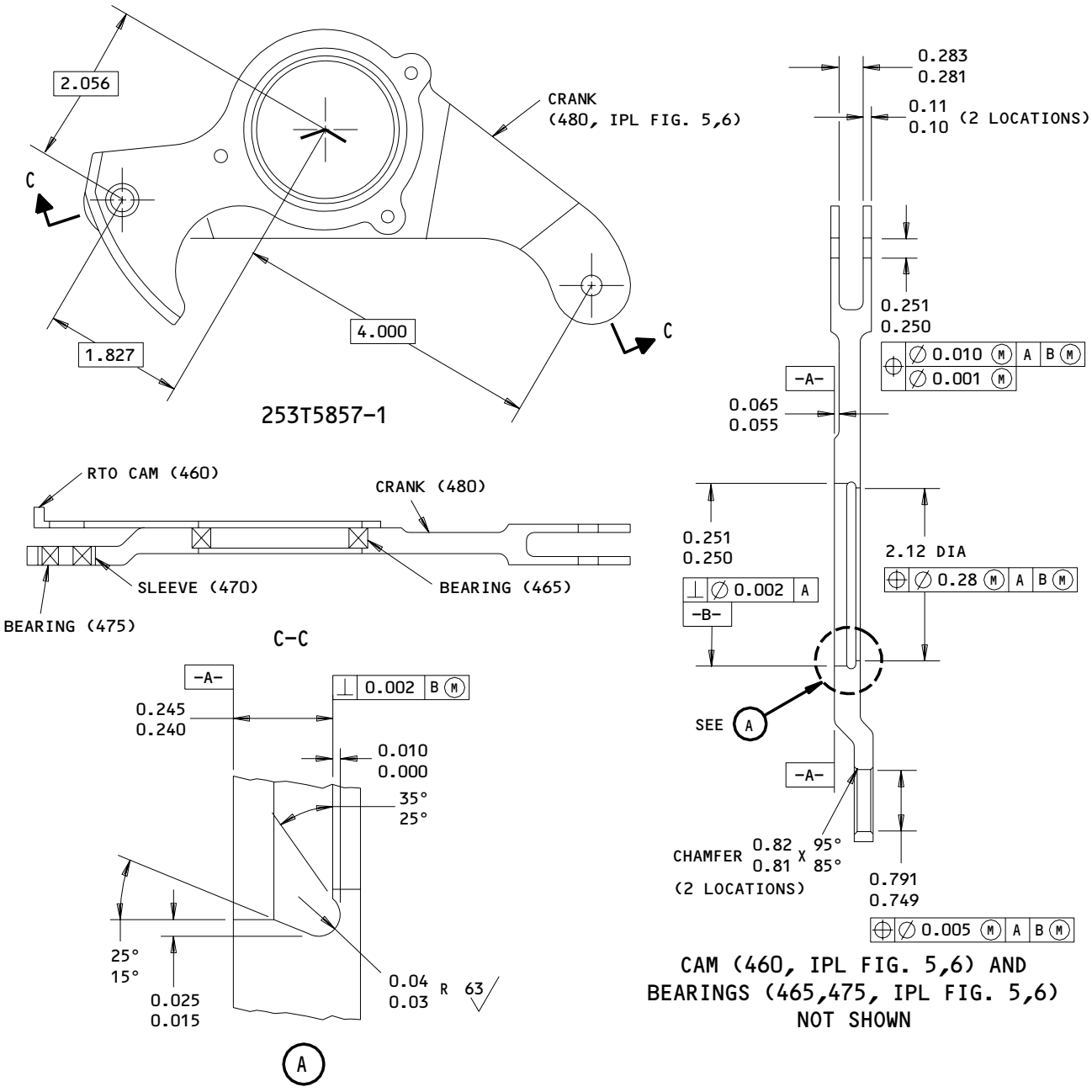

CAM (460, IPL FIG. 5,6) AND
BEARINGS (465,475, IPL FIG. 5,6)
NOT SHOWN

REFINISH

CHROMIC ACID ANODIZE (F-17.04). APPLY TWO COATS PRIMER, BMS 10-11 TYPE 1 (F-20.03) EXCEPT AS NOTED.

1 NO PRIMER THIS SURFACE

2 REPAIR LIMIT FOR INSTALLATION OF BUSHING

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

253T5819-3
253T5857-1
254N1176-1

Crank Assembly Repair
Figure 601 (Sheet 2)

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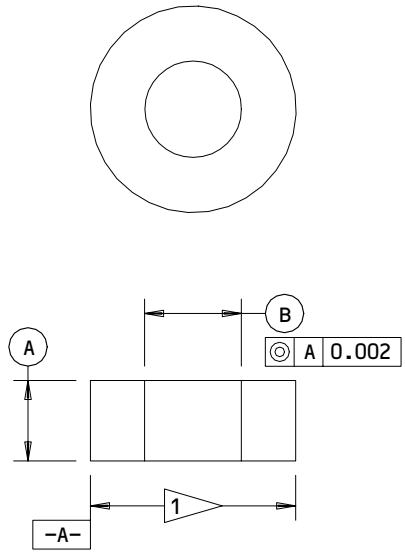

LOCATION (FIG. 601)	(A)	(B)	INTER-FERENCE
(1)	0.214 0.212	0.3756 0.3750	0.0016 0.0010

1 FINAL BUSHING OUTSIDE DIAMETER EQUALS THE REPAIR DIAMETER OF LEVER PLUS INTERFERENCE

63 ALL MACHINED SURFACES

BREAK SHARP EDGES

PASSIVATE (F-17.09)

MATERIAL: 15-5PH PER AMS 5659
HEAT TREAT TO 180-200 KSI
MAGNETIC PARTICLE INSPECT

ALL DIMENSIONS ARE IN INCHES

253T5819-3
Bushing Details
Figure 602

A29570

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SPACER - REPAIR 3-1

253T5821-2
254N1173-1

1. Plating Repair

A. This repair procedure shows how to remove the initial finish and then apply a new finish to the spacer.

B. Refer to the finish instructions given in Fig. 601, for the repair procedures to put back the initial finish to the specified part.

C. Also, refer to the REPAIR - GENERAL section for a list of applicable Chapter 20 standard overhaul practices.

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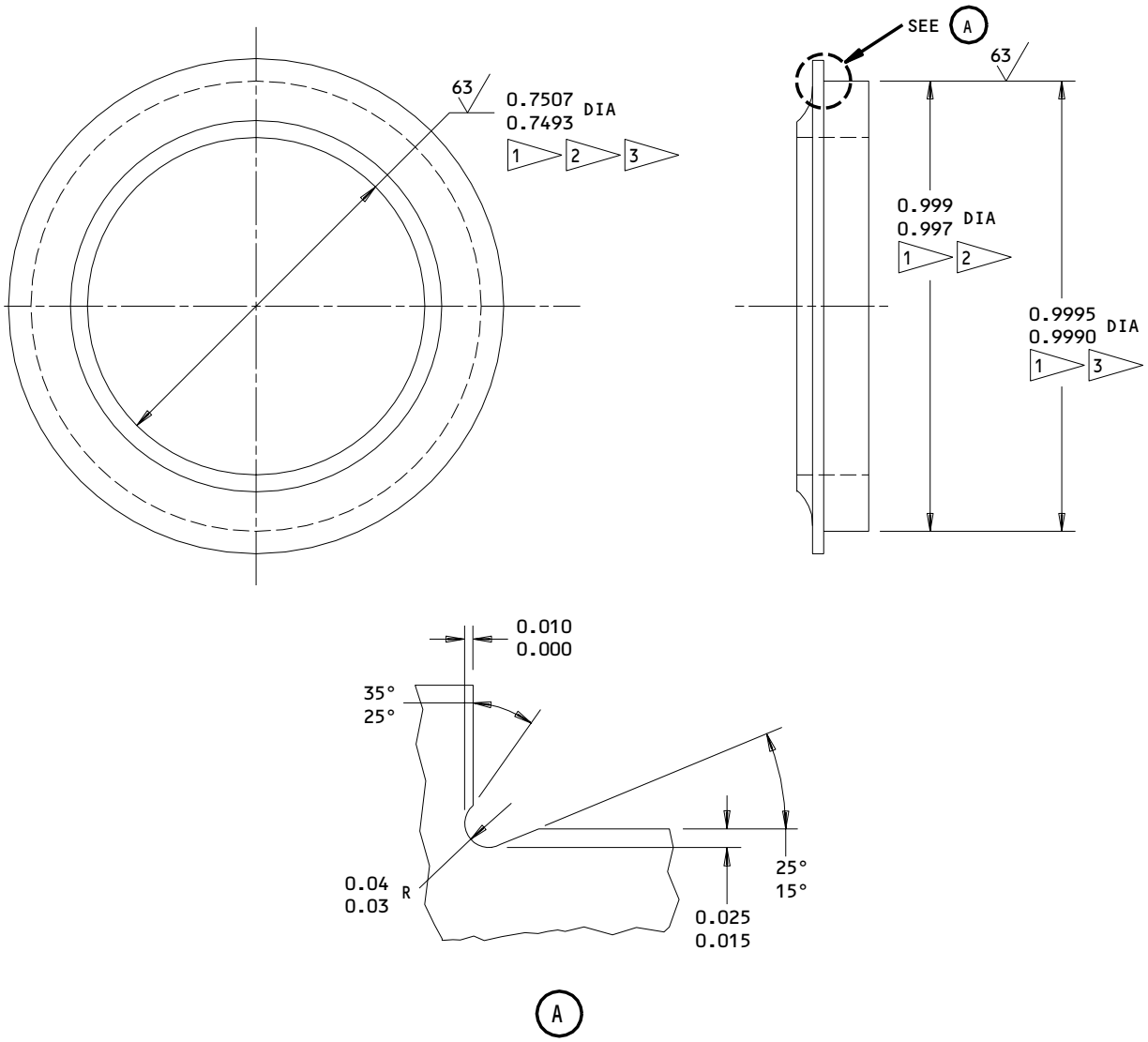

REFINISH

CADMIUM PLATE PER QQ-P-416 TYPE 2, CLASS 2 AND ONE COAT OF BMS 10-11, TYPE 1 PRIMER (F-16.01)

MATERIAL: 4340 STEEL, 180-200 KSI

ALL DIMENSIONS ARE IN INCHES

1 NO PRIMER ON THESE SURFACES
2 253T5821-2
3 254N1173-1

253T5821-2
254N1173-1

Spacer - Refinish
Figure 601

4275

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TRIGGER - REPAIR 4-1

253T5823-1, -2
254N1175-1 THRU -4

1. Plating Repair

A. This repair procedure shows how to remove the initial finish and then apply a new finish to the trigger.

B. Refer to the finish instructions given in Fig. 601, for the repair procedures to put back the initial finish to the specified part.

C. Also, refer to the REPAIR - GENERAL section for a list of the applicable Chapter 20 standard overhaul practices.

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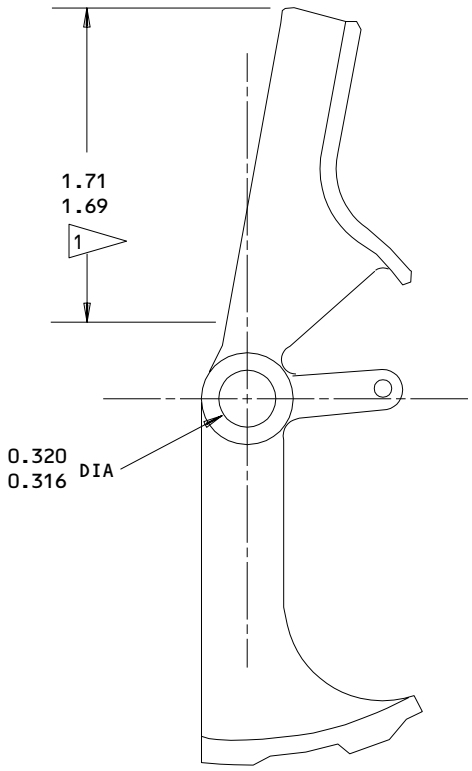
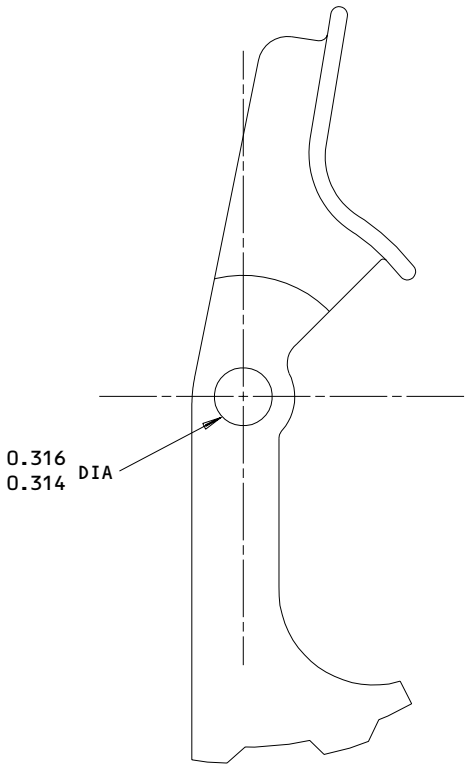


253T5823-1 SHOWN
253T5823-2 OPPOSITE



254N1175-1,-3 SHOWN
254N1175-2,-4 OPPOSITE

REFINISH

253T5823-1,-2
PASSIVATE (F-17.09) ALL OVER
EXCEPT AREA COVERED BY 1

254N1175-1 THRU -4
NO FINISH REQUIRED.

1 MATTE FINISH CHROMIUM PLATE (F-14.111)

MATERIAL: 17-4PH CRES

ALL DIMENSIONS ARE IN INCHES

253T5823-1,-2
254N1175-1 THRU -4
Trigger - Refinish
Figure 601

4276

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LEVER LATCH - REPAIR 5-1

253T5827-1
254N1137-1

NOTE: Refer to REPAIR - GENERAL section for a list of the applicable Chapter 20 standard practices. Also refer to the finish instructions given in Fig. 601, for the repair procedures to put back the initial finish to a specific part.

1. Bushed Hole Repair

   A. If necessary, remove the defects from each of the two 0.3745/0.3755 inch diameter holes in lever latch (P/N 253T5827-1) to the repair limits shown in Fig. 601.

   B. Manufacture a repair bushing, (Fig. 602), to put back the material removed in step 1.A.

   C. Install the repair bushing by the shrink-fit method (SOPM 20-50-03).

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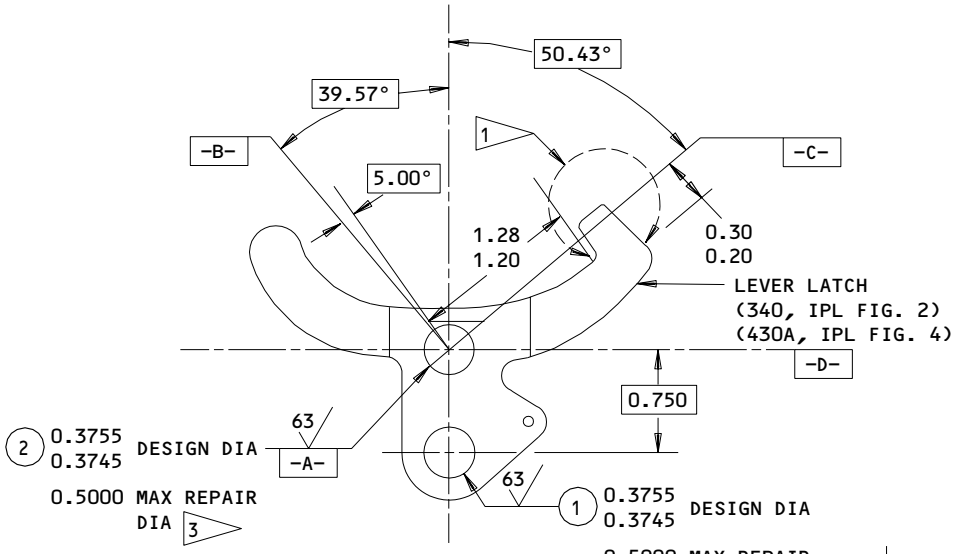
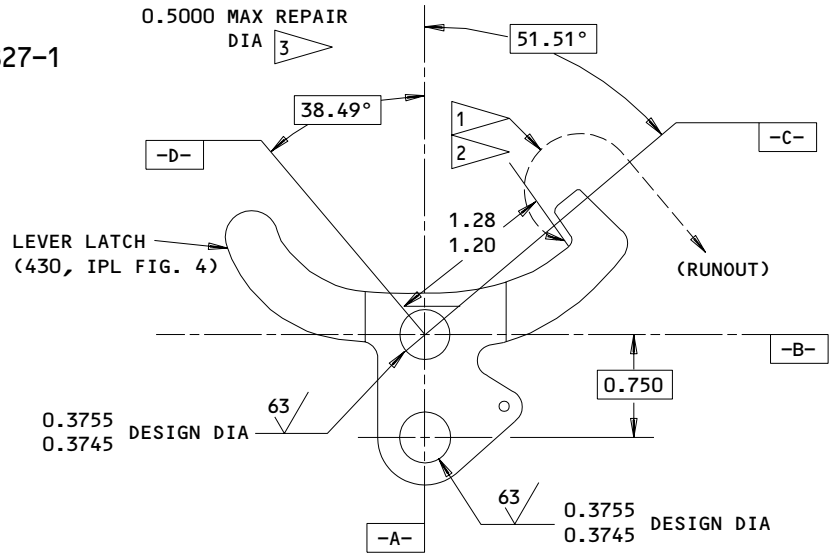


253T5827-1



254N1137-1

REFINISH

PASSIVATE (F-17.09) ALL OVER EXCEPT AREA COVERED BY 1

OPTIONAL FINISH FOR 253T5827-1:
CHROME PLATE (F-15.03) ON ALL SURFACES WITH THICKNESS OF 0.0005-0.001. NO GRINDING ALLOWED. NO FINISH IN 0.3745-0.3755 HOLES.

1 32 SURFACE AND CHROME PLATE (F-15.03) TO 0.0005-0.001 THICKNESS, NO GRINDING ALLOWED

2 APPLY VITRO LUBE 1220 PER 20-11-07 TO THESE SURFACES

3 REPAIR LIMIT FOR INSTALLATION OF BUSHING

REPAIR

REF 1 2 3

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

ALL DIMENSIONS ARE IN INCHES

253T5827-1
254N1137-1
Lever Latch - Repair
Figure 601

199492

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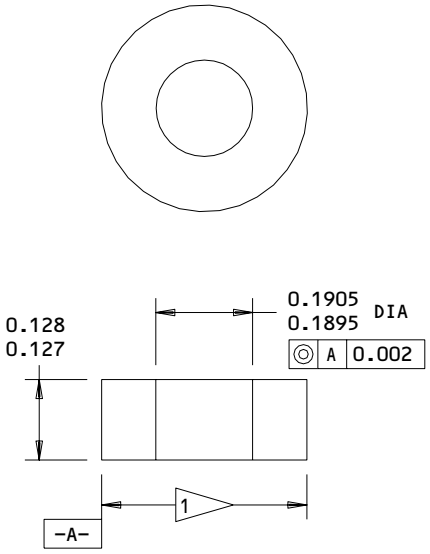

1 FINAL BUSHING OUTSIDE DIAMETER EQUALS THE REPAIR DIAMETER OF LATCH HOLE PLUS 0.0010–0.0016 INTERFERENCE

63 ALL MACHINED SURFACES

BREAK SHARP EDGES

PASSIVATE (F-17.09)

MATERIAL: 15-5PH PER AMS 5659
HEAT TREAT TO 180-200 KSI
MAGNETIC PARTICLE INSPECT

ALL DIMENSIONS ARE IN INCHES

HOLE LOCATIONS (1) AND (2) FIG. 601

253T5827-1
Bushing Details
Figure 602

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SUPPORT ASSEMBLY - REPAIR 6-1

253T5829-1 253T5830-1

NOTE: Refer to REPAIR - GENERAL section for a list of the applicable Chapter 20 standard practices. Also refer to the finish instructions in Fig. 601, for the repair procedures to put back the initial finish to a specific part.

1. Bearing Replacement

   A. Remove bearing.

   B. Apply primer, BMS 10-11, type 1 to cleaned bearing faying surfaces of support and allow to dry.

   C. Install new bearing with wet BMS 10-11, Type 1 primer.

   D. Roller swage bearing in place as given in SOPM 20-50-03.

2. Refinish

   A. Chromic acid anodize and apply one coat of primer, BMS 10-11, type 1 (F-18.13) all over except on surface of support that bearing seats. Material: Aluminum Alloy.

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FOLLOWER ASSEMBLY - REPAIR 7-1

253T5833-1
254N1205-1

NOTE: Refer to REPAIR - GENERAL section for a list of the applicable Chapter 20 standard practices. Also refer to the finish instructions given in Fig. 601 for the repair procedures to put back the initial finish to a specific part.

1. Bushing Replacement

   A. Remove the initial bushing.

   B. Install a new bushing by the shrink-fit method (SOPM 20-50-03).

   C. Install the new bushing wet with BMS 10-11 type 1 primer.

2. Bearing Replacement

   A. Remove washer, rivet and bearing.

   B. Install replacement bearing with new rivet and washer.

   C. Check to make sure bearing turns freely after installation.

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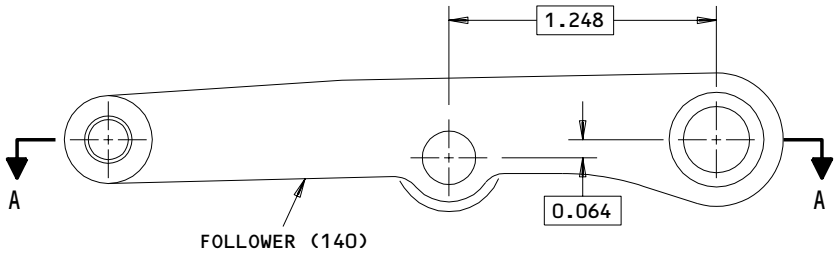

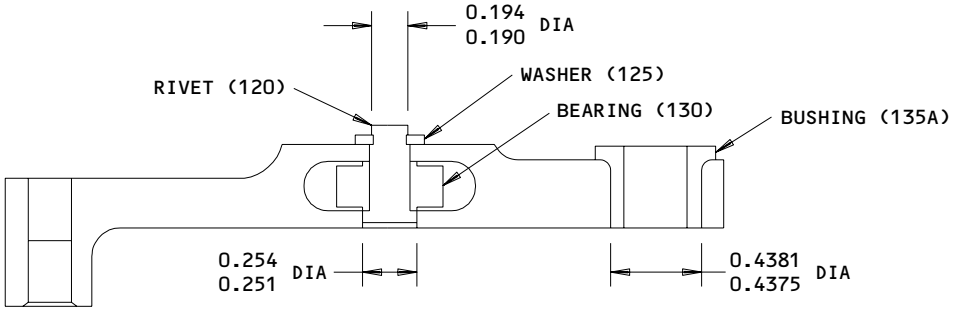

A-A

REFINISH

PASSIVATE (F-17.09) ALL OVER.

MATERIAL: 253T5833-1
15-5PH CRES (180-200 KSI)

254N1205-1
17-4PH CRES PER AMS 5344

ALL ITEM NUMBERS REFER TO FIG. 4

ALL DIMENSIONS ARE IN INCHES

253T5833-1
254N1205-1
Follower Assembly - Refinish
Figure 601

A21837

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COUNTERWEIGHT ASSY - REPAIR 8-1

253T5838-1, -2
253T5842-1
254N1141-1

NOTE: Refer to REPAIR - GENERAL section for a list of the applicable Chapter 20 standard practices. Also refer to the finish instructions given in Fig. 601 for the repair procedures to put back the initial finish to a specific part.

1. Counterweight Replacement (253T5838-1,-2; 253T5842-1)

   A. Drill out rivets.

   B. Apply wet BMS 10-11 Type 1, primer to rivet holes.

   C. Attach counterweight to support arm with rivets.

2. Refinish

   A. Counterweights (510, 515, IPL Fig. 2) -- Apply black nylon coating, Thermoclad Corp. type 49, 0.005 to 0.010 inch thick. Omit nylon coating in holes and countersunk areas. Material: Sintered tungsten.

   B. Counterweight (500, IPL Fig. 5,6) -- See Fig. 601.

   C. Support Arm (520, 525, IPL Fig. 2) (90, IPL Fig. 3) -- Chromic acid anodize and apply one coat BMS 10-11 type 1, primer (F-18.13). Material: Al alloy.

   D. Guide assembly (95, 115, IPL Fig. 3) -- Apply black nylon coating, Thermoclad Corp., type 49, 0.005 to 0.010 inch thick. Material: Sintered tungsten (105, 125, IPL Fig. 3) and Aluminum alloy (110, 130, IPL Fig. 3).

   E. Wireguide (110, 130, IPL Fig. 3) -- Chemical treat (F-17.15). Material: Aluminum alloy.

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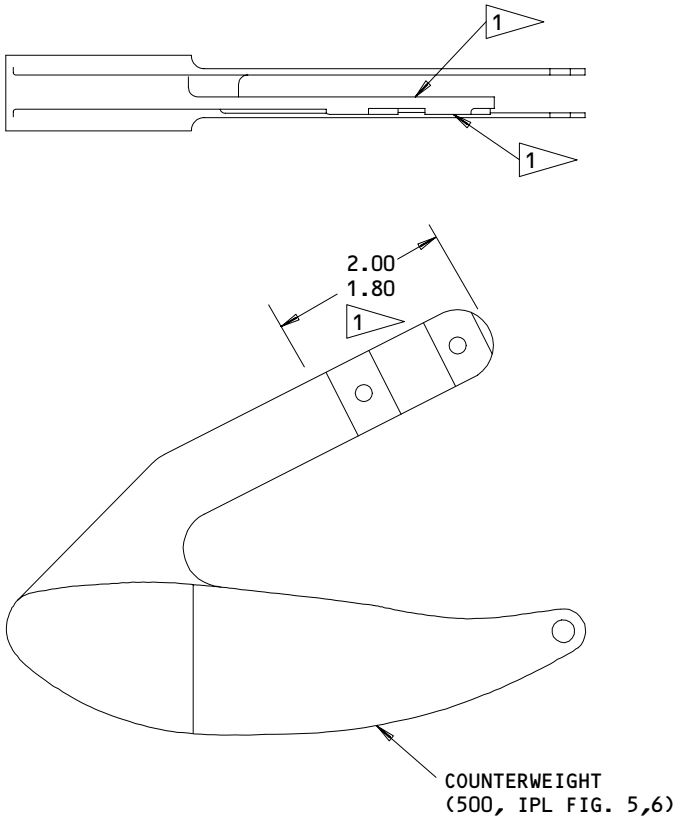

REFINISH

PASSIVATE (F-17.09) AND APPLY BLACK NYLON COATING, THERMOCLAD CORP., TYPE 49, 0.005-0.010 INCH THICK.

1 OPTIONAL - OMIT NYLON COATING IN MOUNTING PAD AREA.

MATERIAL: 17-4PH CRES PER AMS 5343

ALL DIMENSIONS ARE IN INCHES

254N1141-1
Counterweight - Refinish
Figure 601

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MISCELLANEOUS PARTS - REPAIR 9-1

1. This repair procedeure shows how to apply a new finish to the parts listed in Fig. 601.

2. Also, refer to the REPAIR - GENERAL section for a list of the applicable Chapter 20 "Decoding Table for Boeing Finish Codes".

IPL FIG. & ITEM	MATERIAL	FINISH
Fig. 1		
Spacer (35,40)	Al alloy	Chromic acid anodize, plus one coat primer, BMS 10-11, type 1 (F-18.13).
Shaft (95,100)	15-5PH CRES, 180-200 ksi	Passivate (F-17.09).
Fig. 2		
Retainer (45,50)	301 CRES 1/2H	Passivate (F-17.09).
Cam (60)	15-5PH CRES, 180-200 ksi	Passivate (F-17.09).
Plate (85)	301 CRES 1/2H	Passivate (F-17.09).
Washer (140)	15-5PH CRES, 180-200 ksi	Passivate (F-17.09).
Detent cam (225, 225A)	15-5PH CRES, 180-200 ksi	Passivate (F-17.09).
Wire support assy (235)	Al alloy	Chemical treat interior and exterior surfaces plus one coat primer, BMS 10-11, type 1 (F-18.07).
Latch (240)	4340 Steel, 180-200 ksi	Cadmium plate (F-16.04) to thickness of 0.0002-0.0004 plus dry film lube (F-19.10).
Cover (260,260A)	17-4PH CRES, 180 ksi min.	Passivate (F-17.09), plus matte finish chromium plate (F-14.111), except full plating not necessary on interior face.

Refinish Details
Figure 601 (Sheet 1)

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IPL FIG. & ITEM	MATERIAL	FINISH
Fig. 2 (cont.)		
Stop (318, 319)	15-5PH CRES, 150-170 ksi	Matte finish chromium plate (F-14.111), except no chrome in holes.
Cover (385,385A)	304 CRES	Matte finish chromium plate (F-14.111).
Lower cover (390, 390A)	304 CRES	Matte finish chromium plate (F-14.111).
Switch shim (429)	AL alloy	Chemically treat plus one coat BMS 10-11, type 1 primer (F-18.06).
Fig. 3		
Switch shim (53)	AL alloy	Chemically treat plus one coat BMS 10-11, type 1 primer (F-18.06).
Shaft (156)	15-5PH CRES 150-170 ksi	Passivate (F-17.09)
Shaft (157)	15-5PH CRES 180-200 ksi	Cadmium plate (F-15.06).
Spacer (200, 205)	AL alloy	Chromic acid anodize plus one coat BMS 10-11, type 1 primer (F-18.13).
Spacer (210)	4340 steel	Cadmium plate and apply one coat primer, BMS 10-11, type 1 (F-16.01).
Stop (237, 238)	Titanium alloy	Tiodize type II per AMS 2488 to hook end only.

Refinish Details
Figure 601 (Sheet 2)

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IPL FIG. & ITEM	MATERIAL	FINISH
Fig. 4		
Bearing retainer (25, 30)	301 CRES 1/2H	Passivate (F-17.09).
Cam (50,225)	15-5PH CRES, 180-200 ksi	Passivate (F-17.09)
Spacer (55)	AL alloy	Chromic acid anodize plus one coat BMS 10-11, type 1 primer (F-18.13).
Plate (90)	301 CRES 1/2H	Passivate (F-17.09).
Crank (185)	AL alloy	Chromic acid anodize (F-17.04) plus two coats BMS 10-11, type 1 primer (F-20.03).
Cam (225B)	17-4PH CRES	Passivate (F-17.09).
Pin (240)	4130 steel	Cadmium plate (F-15.06).
Latch (250)	4340 steel 180-200 ksi	Cadmium plate (F-16.04) followed by BMS 3-8 solid film lubricant (F-19.10).
Spring (330, 335)	17-7PH CRES	Passivate (F-17.09) plus finish spring hook with one coat BMS 10-11, type 1 primer (F-20.02).

Refinish Details
Figure 601 (Sheet 3)

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IPL FIG. & ITEM	MATERIAL	FINISH
Fig. 5,6		
Retainer (10)	AL alloy	F-21.31 plus F-14.903-705 except omit primer and paint on threads.
Cover (35)	AL alloy	Finish as follows: 1. Apply directional satin finish using Lea compound grade C or equivalent. 2. Sulfuric acid anodize all over and dye to match color BAC 80893 dark bronze. NOTE: Separate color chips are required for each alloy.
Pin (80)	440C	Passivate (F-17.09).
Cam roller (85)	440C	Passivate (F-17.09)
Spring plunger (95)	17-4PH CRES	Passivate (F-17.09).
Spring (115A)	17-4PH CRES	Cadmium plate (F-15.02).
Pin (135)	4037 steel alloy	Cadmium plate (F-15.06).
Pawl (140A)	17-4PH CRES	Cadmium plate (F-15.06).
Cam (262)	440C	Passivate (F-17.09).
LH support (267)	AL alloy	Finish same as cover (35)
Spacer (272, IPL Fig. 5) (545, IPL Fig. 6)	AL-Ni-Br	Cadmium plate (F-15.06).
Bellcrank support (295)	15-5PH CRES	Cadmium plate (F-15.06) to all external surfaces except on 0.38 inch diameter surface which is thin dense chrome plated and dry film lubricated with BMS 3-8.

Refinish Details
Figure 601 (Sheet 4)

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IPL FIG. & ITEM	MATERIAL	FINISH
Fig. 5,6 (cont.)		
Spring guide (305)	AL-Ni-Br per AMS 4640	Cadmium plate and apply one coat BMS 10-11, type 1 primer (F-16.01).
Stop (345)	15-5PH CRES	Cadmium plate and apply one coat BMS 01-11, type 1 primer (F-16.01) plus two coats laquer (F-14.903-8598) as noted.
Spring (400)	17-7PH CRES	Passivate (F-17.09) all over plus apply one coat BMS 10-11, type 1 primer (F-20.02) to spring hook area only.
Bearing retainer (430, 445)	301 CRES 1/2H	Passivate (F-17.09).
Spacer (447, IPL Fig. 6)	AL alloy	Chromic acid anodize and apply one coat BMS 10-11, type 1 primer (F-18.13).

Refinish Details
Figure 601 (Sheet 5)

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LINK ASSY - REPAIR 10-1

015T0630-3, -4, -13, -14
253T5824-1, -2
253T5855-1, -2
254N1134-5, -6
254N1210-1, -2, -5, -6

NOTE: Refer to REPAIR - GENERAL section for a list of the applicable Chapter 20 standard practices. Also refer to the finish instructions given in Fig. 601 for the repair procedures to put back the initial finish to a specific part.

1. Disassembly

A. Link Assembly (IPL Fig. 2; 325, 325A, 355B, 355C)

NOTE: Disassemble Link Assembly (325, 325A, 355B, 355C) only if a repair of the link (345), lever assembly (350, 355), or latch (340) is necessary.

(1) Remove rivet (330) and bushings (335) and separate latch (340) from link (345).

(2) Remove rivet (360) and separate link (345) from lever assembly (350, 355).

B. Link Assembly (IPL Fig. 4; 355A, 360A, 355D, 360D)

NOTE: Disassemble Link Assembly (355A, 360A, 355D, 360D) only if a repair of the link assembly (435), the lever assembly (375A, 380A), or the latch (430) is necessary.

(1) Remove rivet (365) and washer (370), then separate lever assembly (375A, 380A) from link assembly (435).

(2) Remove collar (420B), washers (410, 415), bushing (427) and bolt (405B), then separate latch (430) from link assembly (435).

C. Link Assembly (IPL Fig. 5,6; 315)

NOTE: Disassemble Link Assembly (315) only if a repair of the lever (340) or link (325) is necessary.

(1) Remove rivet (320A) and separate lever (340) and link (325).

(2) Remove screw (330) and knob (335).

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2. Repair

A. Latch (IPL Fig. 2; 430, IPL Fig.4; 340)

(1) Refer to Repair 5-1 for repair of latch.

B. Link (345, IPL Fig. 2)

WARNING: DO NOT USE RIVET (360, IPL FIG. 2) WITH LINK REPAIR FOR P/N 253T5826-1. A NEW RIVET MUST BE USED WITH THE REPAIRED LINK TO PRECLUDE FAILURE TO THE CONTROL STAND THRUST LEVER ASSEMBLY.

(1) Spotface 0.375/0.379 diameter holes as shown in fig. 601.

(2) Bushed Hole Repair for Link - 253T5826-1

(a) If necessary, you are permitted to remove a defect or damage from the 0.375-0.379 diameter holes in the link.

(b) Use the repair limits given in Fig. 601 to oversize the specified holes.

(c) If you oversize the hole, then refer to Fig. 602 to manufacture the repair bushing to install in the repaired hole.

(d) Use the shrink-fit method (SOPM 20-50-03) to install the repair bushing in the hole.

(3) Manufacture new rivet as shown in Fig. 601.

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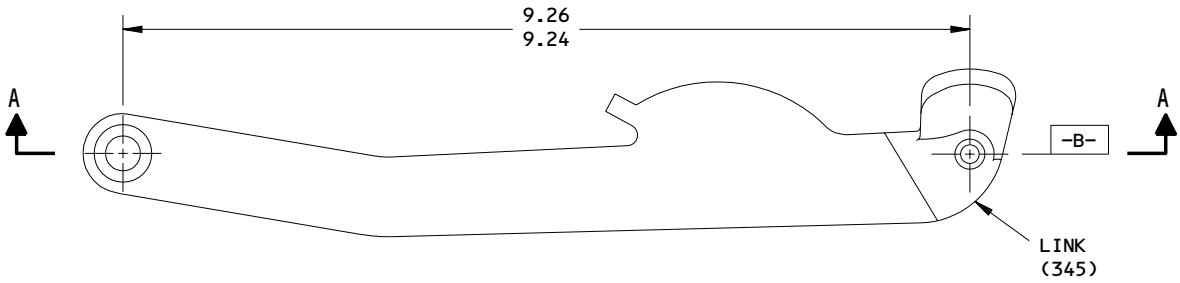
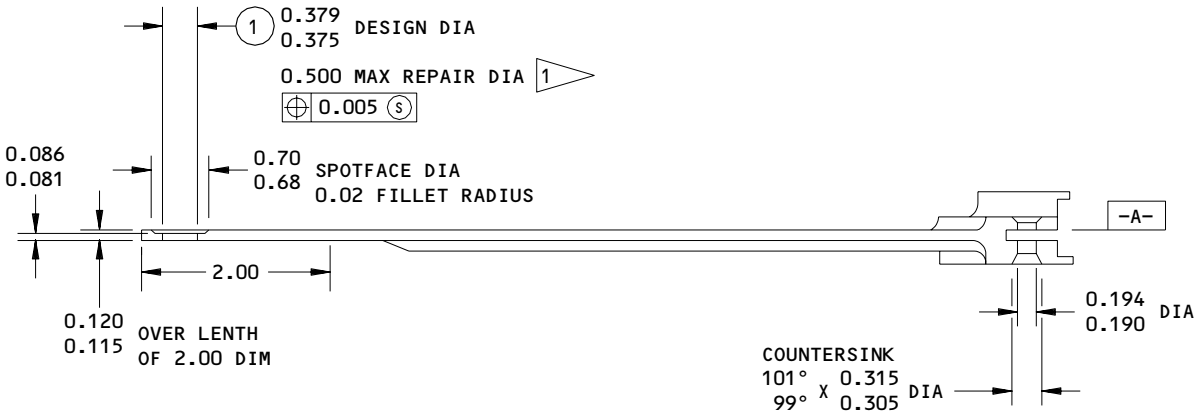


LINK
(253T5826-1)



A-A

REFINISH

PREPARE SURFACE AND THEN PASSIVATE (F-17.09).
APPLY DRY FILM LUBE (F-19.10).

1 REPAIR LIMIT FOR INSTALLATION OF BUSHING

REPAIR

REF 1

MATERIAL: 17-4PH CRES (AMS 5344)

ALL ITEM NUMBERS REFER TO FIG. 2

ALL DIMENSIONS ARE IN INCHES

015T0630-3,-4; 253T5824-1,-2
Link Assembly Repair
Figure 601 (Sheet 1)

A21790

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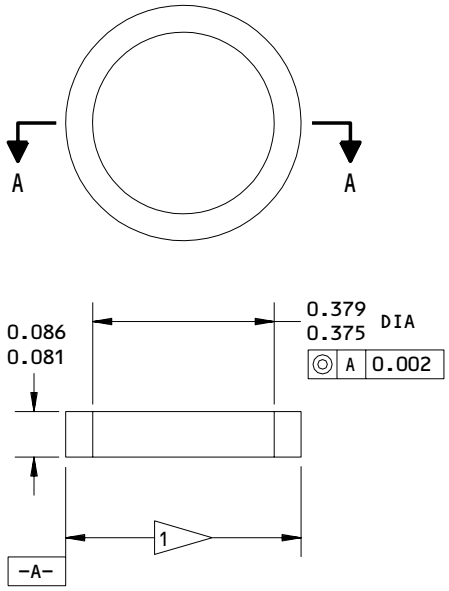

A-A

63 ALL MACHINED SURFACES

BREAK SHARP EDGES

PASSIVATE (F-17.09)

MATERIAL: 15-5PH (AMS 5659)
HEAT TREAT TO 180-200 KSI
MAGNETIC PARTICLE INSPECTION (SOPM 20-20-01)

ALL DIMENSIONS ARE IN INCHES

1 THE FINAL OUTSIDE DIAMETER OF THE BUSHING IS EQUAL TO THE REPAIR DIAMETER OF THE LINK HOLE PLUS 0.0010-0.0016 INCH INTERFERENCE

HOLE LOCATION (1) ON LINK 253T5826-1, FIG. 601 (SHEET 1)

015T0630-3,-4; 253T5824-1,-2
Bushing Details
Figure 601 (Sheet 2)

A29620

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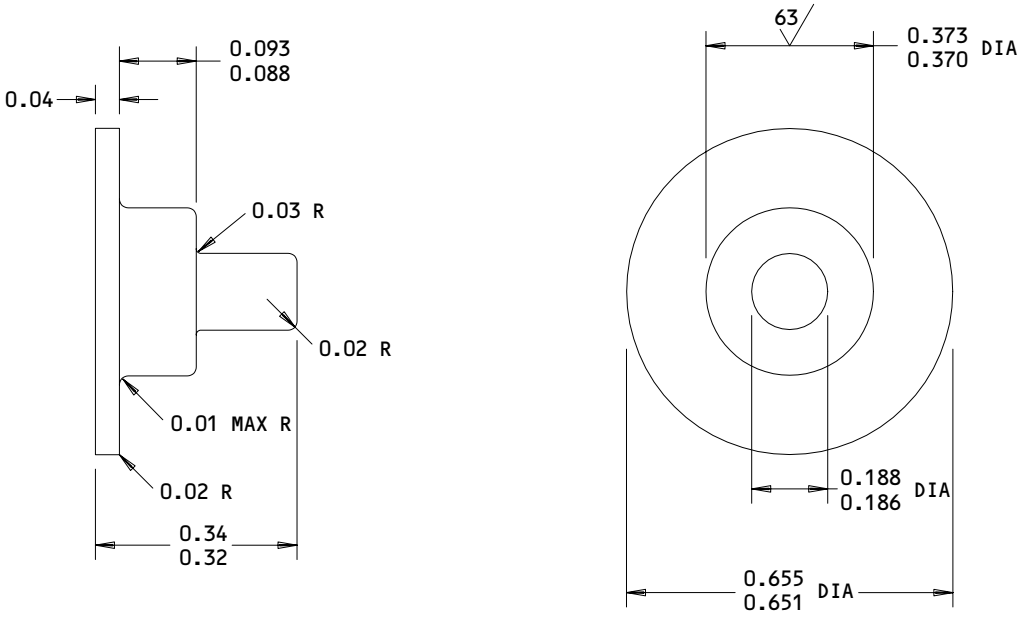

FINISH

DRY FILM LUBE PER (F-19.10)

125 ALL MACHINED SURFACES EXCEPT AS NOTED

BREAK SHARP EDGES

MATERIAL: MONEL (COLD DRAWN BAR)
PER QQ-N-281, CLASS A

ALL DIMENSIONS ARE IN INCHES

REPLACES RIVET (360) 69B81663-2

Rivet Details
Figure 601 (Sheet 3)

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C. Link Assembly (435, IPL Fig. 4)

(1) Make sure the bushing (440) and/or link (445) does not have excessive wear.

NOTE: If necessary, replace the bushing.

CAUTION: USE CAUTION WHEN MACHINING BUSHING TO PRECLUDE DAMAGE TO TIODIZE FINISH ON LINK.

(2) Install bushing (440) as given in SOPM 20-50-03.

(3) Make sure that the bushing is 0.000-0.010 inch below surface of link (445).

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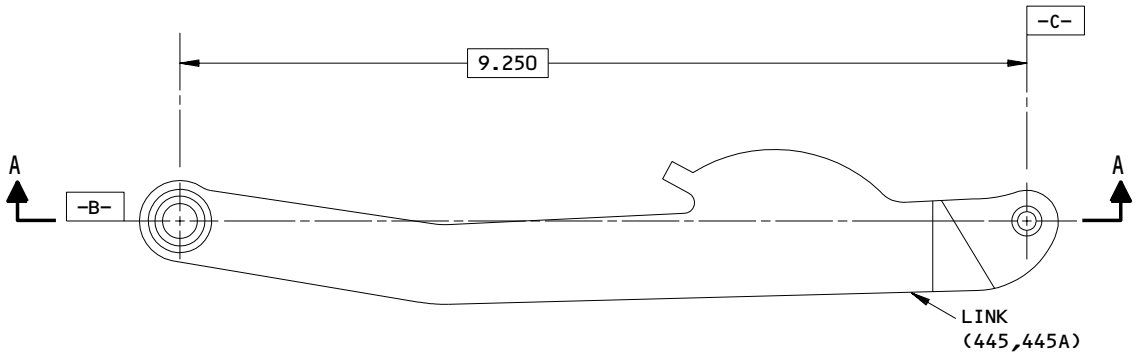
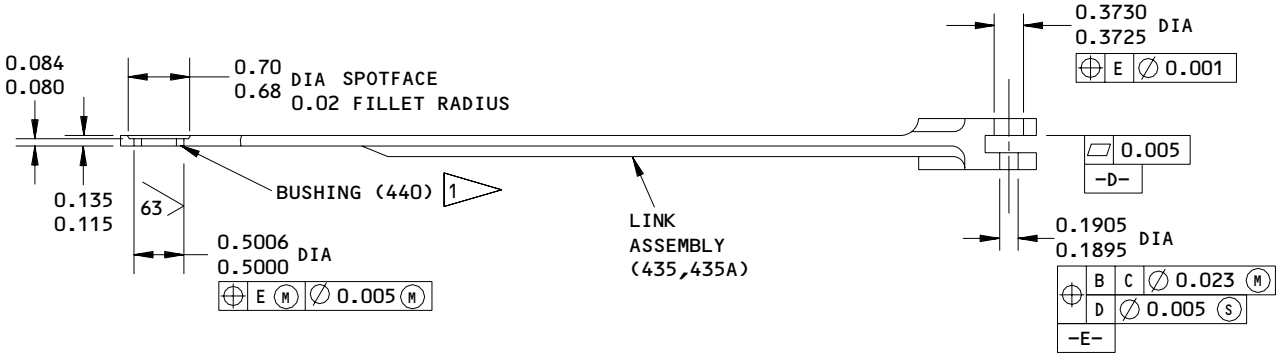


LINK ASSEMBLY
(254N1136-1,-4)



A-A

REFINISH

AN ANODIZE FINISH (F-30.015) IS NECESSARY. YOU MUST SEND THE LINK TO TIODIZE CO. INC, (VENDOR CAGE CODE V34568) TO HAVE THEM APPLY A TYPE 2 TIODIZE FINISH.

1 BUSHING MUST BE 0.000-0.010 INCH BELOW SURFACE

MATERIAL: TITANIUM ALLOY

ALL DIMENSIONS ARE IN INCHES

ALL ITEM NUMBERS REFER TO FIG. 4

015T0630-13,-14; 254N1134-5,-6; 254N1210-1,-2,-5,-6
Link Assembly Repair
Figure 602

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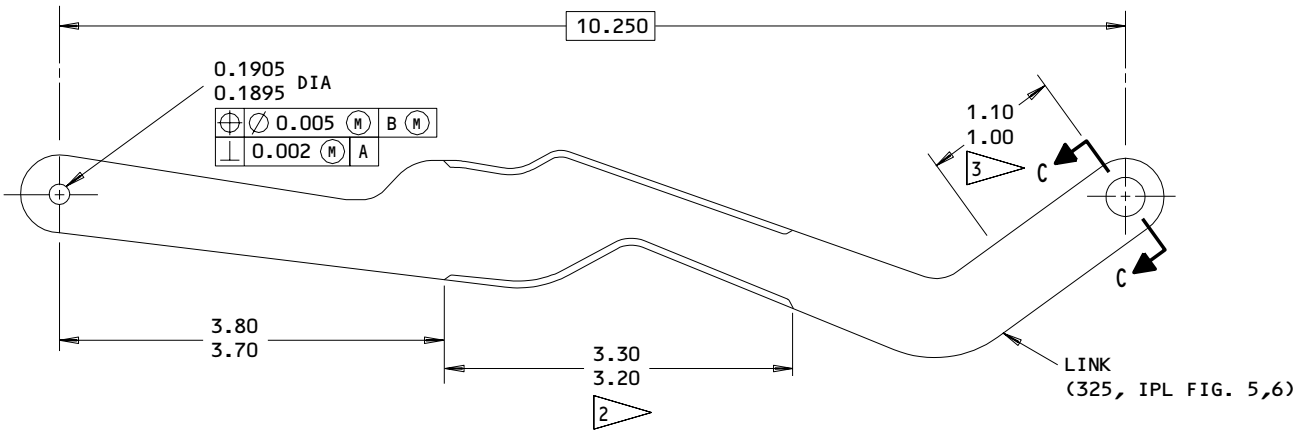
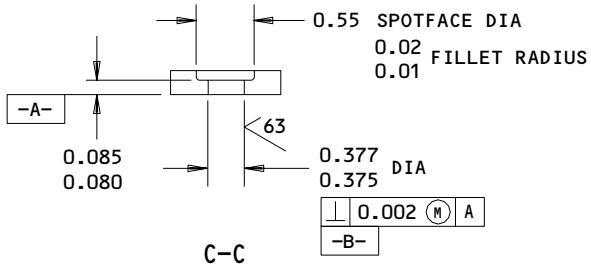
D. Link (325, IPL Fig. 5,6)

(1) Make sure the link (325) does not have excessive wear at the rivet hole.

NOTE: If necessary, replace the link.



253T5866-1
LINK



REFINISH

PREPARE SURFACE AND PASSIVATE (F-17.09) ALL ALL OVER EXCEPT WHERE NOTED.

2 DO NOT PASSIVATE THIS SURFACE. APPLY SOLID FILM LUBRICANT TO THIS AREA

3 OPTIONAL DRY FILM LUBRICANT MAY COVER END OF LINK AREA SHOWN

MATERIAL: 15-5PH CRES

ALL DIMENSIONS ARE IN INCHES

253T5855-1,-2
Link Assembly - Repair
Figure 603

A21795

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E. Lever Assembly (350, 355, IPL Fig. 2)

(1) Bushed Hole Repair

(a) Remove defects as required from 0.315/0.317 diameter hole in lever assembly (P/N 253T5825-1,-2) to within repair limits as shown in Fig. 604.

(b) Manufacture bushing, Fig. 604, as required to compensate for material removed in step 2.E.(1)(a).

(c) Install the bushing by the shrink-fit method as given in SOPM 20-50-03.

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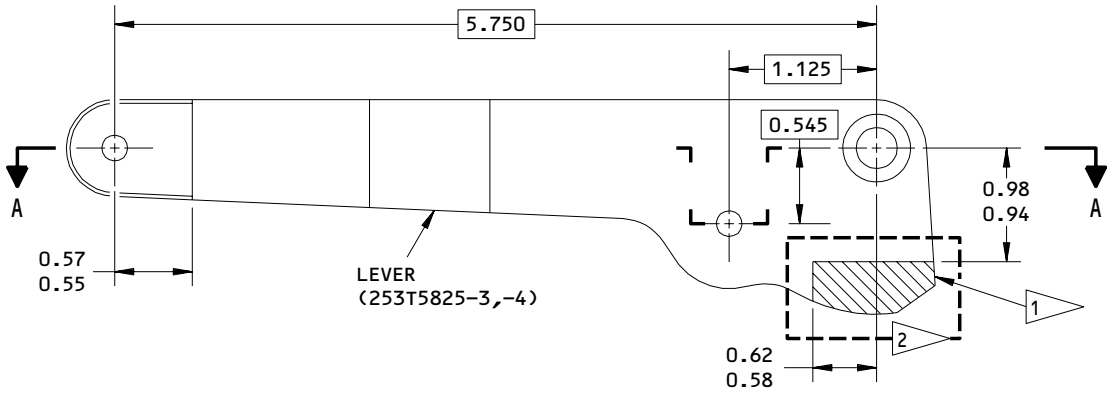
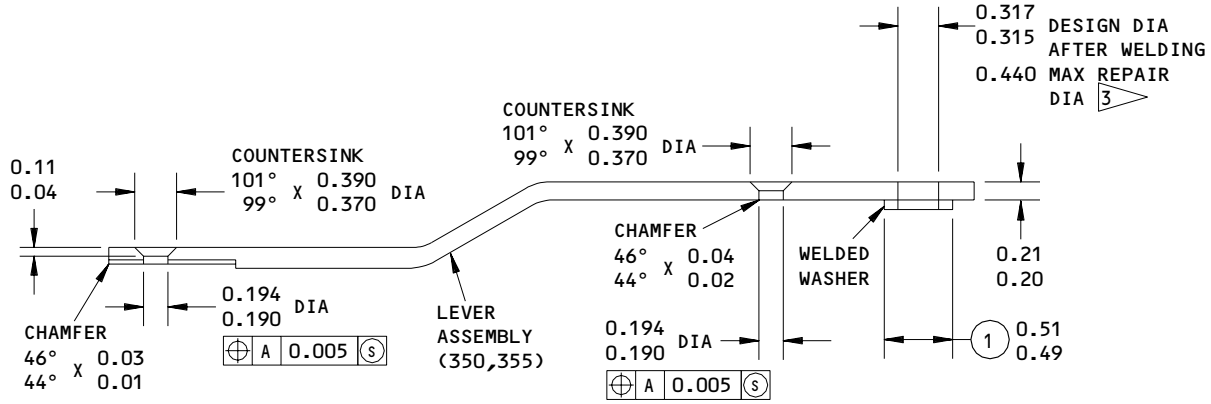


LEVER ASSEMBLY
(253T5825-1,-2)



A-A

REFINISH

CHROME PLATE (F-14.111).

1 63 MICROINCHES ON THIS SURFACE. DO NOT PLATE OR SANDBLAST THE SIDES OR THE EDGE AREA SHOWN

2 SEE SB 767-76-0031 FOR MODIFICATIONS IN THIS AREA

3 REPAIR LIMIT FOR INSTALLATION OF BUSHING

REPAIR

REF 1 2 3

MATERIAL: 15-5PH CRES (BMS 7-240, TYPE 1 ANNEALED)

ALL ITEM NUMBERS REFER TO FIG. 2

ALL DIMENSIONS ARE IN INCHES

015T0630-3,-4; 253T5824-1,-2
Link Assembly Repair
Figure 604 (Sheet 1)

A21799

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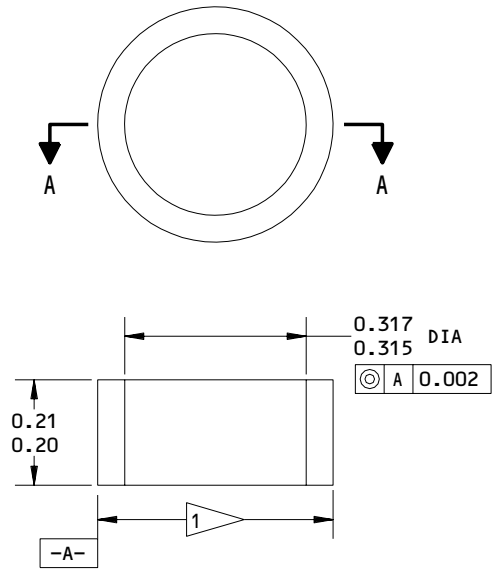

A-A

1 THE FINAL OUTSIDE DIAMETER OF THE BUSHING IS EQUAL TO THE REPAIR DIAMETER OF THE LEVER HOLE PLUS 0.0010-0.0015 INCH INTERFERENCE

63 ALL MACHINED SURFACES

BREAK SHARP EDGES

PASSIVATE (F-17.09)

MATERIAL: 15-5PH (AMS 5659)
HEAT TREAT TO 180-200 KSI
MAGNETIC PARTICLE INSPECTION (SOPM 20-20-01)

ALL DIMENSIONS ARE IN INCHES

HOLE LOCATION (1) ON LEVER 253T5825-1, FIG. 604 (SHEET 1)

015T0630-3,-4; 253T5824-1,-2
Bushing Details
Figure 604 (Sheet 2)

A29650

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F. Lever Assembly (375A, 380A, IPL Fig. 4)

(1) Make sure the bushing (385) and/or arm (390A), or lever (395, 400) does not have excessive wear and replace as necessary.

NOTE: If necessary, replace the bushing, arm or lever.

CAUTION: USE CAUTION WHEN MACHINING BUSHING TO PRECLUDE DAMAGE TO TIODIZE FINISH ON LEVER AND ARM.

(2) Clamp arm (390A) and lever (345, 400) together holding concentricity between 0.4375-0.4381 dia holes to within 0.002 FIM.

(3) Install bushing (385) as given in SOPM 20-50-03.

(a) Make sure that the bushing is 0.000-0.002 inch below surface of lever assy (375A, 380A).

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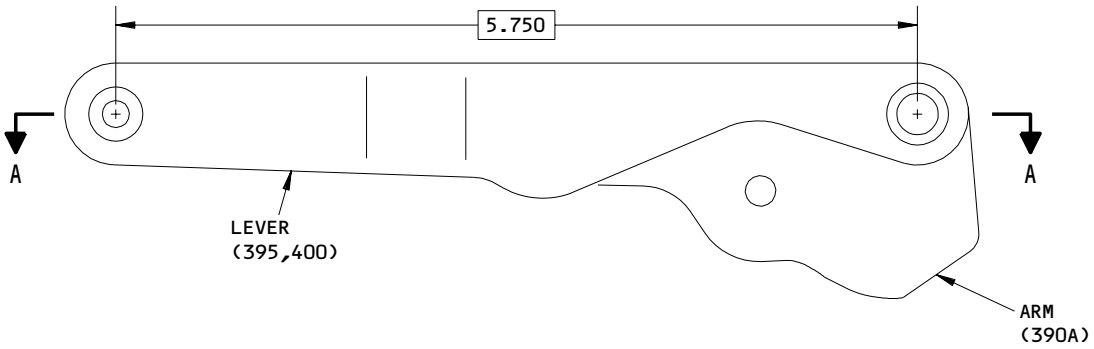
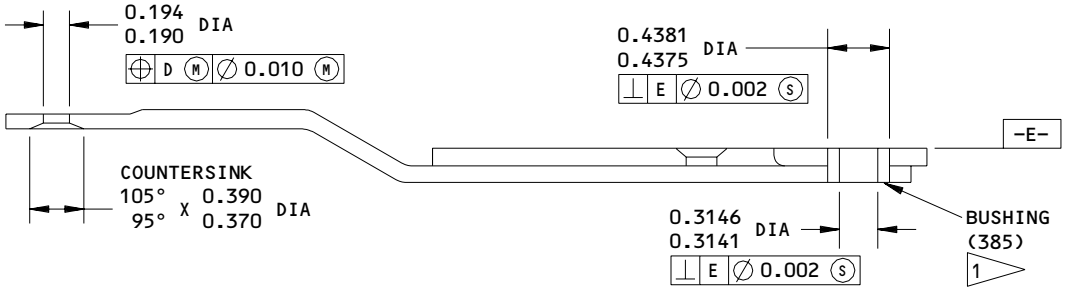


LEVER ASSEMBLY
(254N1174-1,-7,-13, SHOWN; 254N1174-2,-8,-14 SIMILAR)



A-A

REFINISH

AN ANODIZE FINISH (F-30.015) IS NECESSARY. YOU MUST SEND THE LEVER TO TIODIZE CO. INC, (VENDOR CAGE CODE V34568) TO HAVE THEM APPLY A TYPE 2 TIODIZE FINISH.

1 BUSHING MUST BE 0.000-0.002 INCH BELOW SURFACE

MATERIAL: TITANIUM ALLOY

ALL DIMENSIONS ARE IN INCHES

ALL ITEM NUMBERS REFER TO FIG. 4

015T0630-13,-14; 254N1134-5,-6; 254N1210-1,-2,-5,-6
Link Assembly Repair
Figure 605

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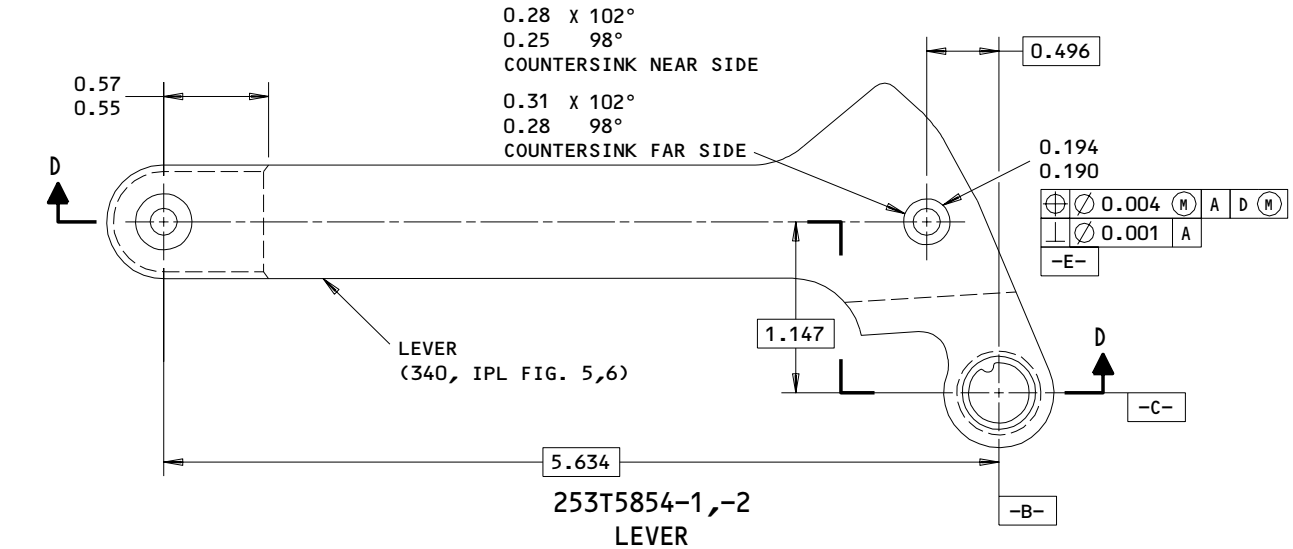
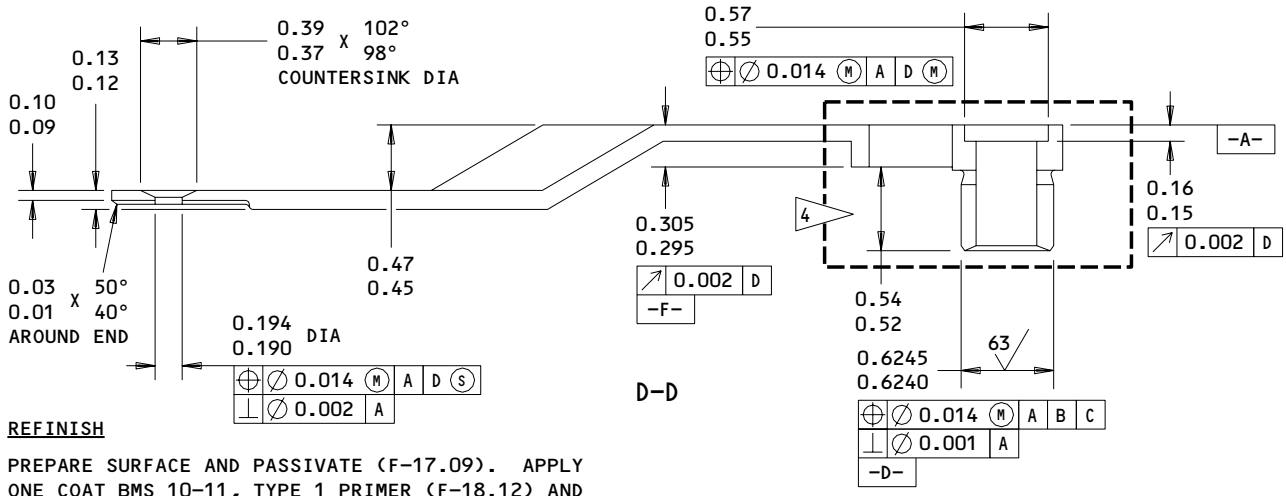
G. Lever (340, IPL Fig. 5,6)

(1) Make sure the lever (340) does not have excessive wear at rivet hole.

NOTE: If necessary, replace the lever.



253T5854-1,-2
LEVER



REFINISH

PREPARE SURFACE AND PASSIVATE (F-17.09). APPLY ONE COAT BMS 10-11, TYPE 1 PRIMER (F-18.12) AND TWO COATS OF HI-SPEED LACQUER, FLAT (F-14.902-8598) ALL OVER, EXCEPT ON DRIVEN HEAD OF RIVET.

4 OMIT PRIMER AND PAINT FROM THIS AREA.

MATERIAL: 15-5PH CRES

ALL DIMENSIONS ARE IN INCHES

253T5855-1,-2

Link Assembly - Repair
Figure 606

A21803

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3. Assembly

A. Link Assembly (325, IPL Fig. 2)

WARNING: DO NOT USE RIVET (360, IPL FIG. 2) WITH REPAIRED LINK (345). A NEW RIVET (REPAIR 10-1, FIG. 601) MUST BE USED WITH REPAIRED LINK TO PRECLUDE FAILURE TO THE CONTROL STAND THRUST LEVER ASSEMBLY.

(1) Align lever assy (350, 355) and link (345) and install rivet (360). Shave rivet head to 0.000-0.005 above the lever assy surface to avoid interference with thrust lever assy (1A, 5A).

NOTE: Lever assy and link shall rotate freely after installation of rivet.

(2) Insert latch (340) and bushings (335) into slot in link (345) and install rivet (330).

NOTE: Latch (340) and link (345) must rotate freely after installation of rivet.

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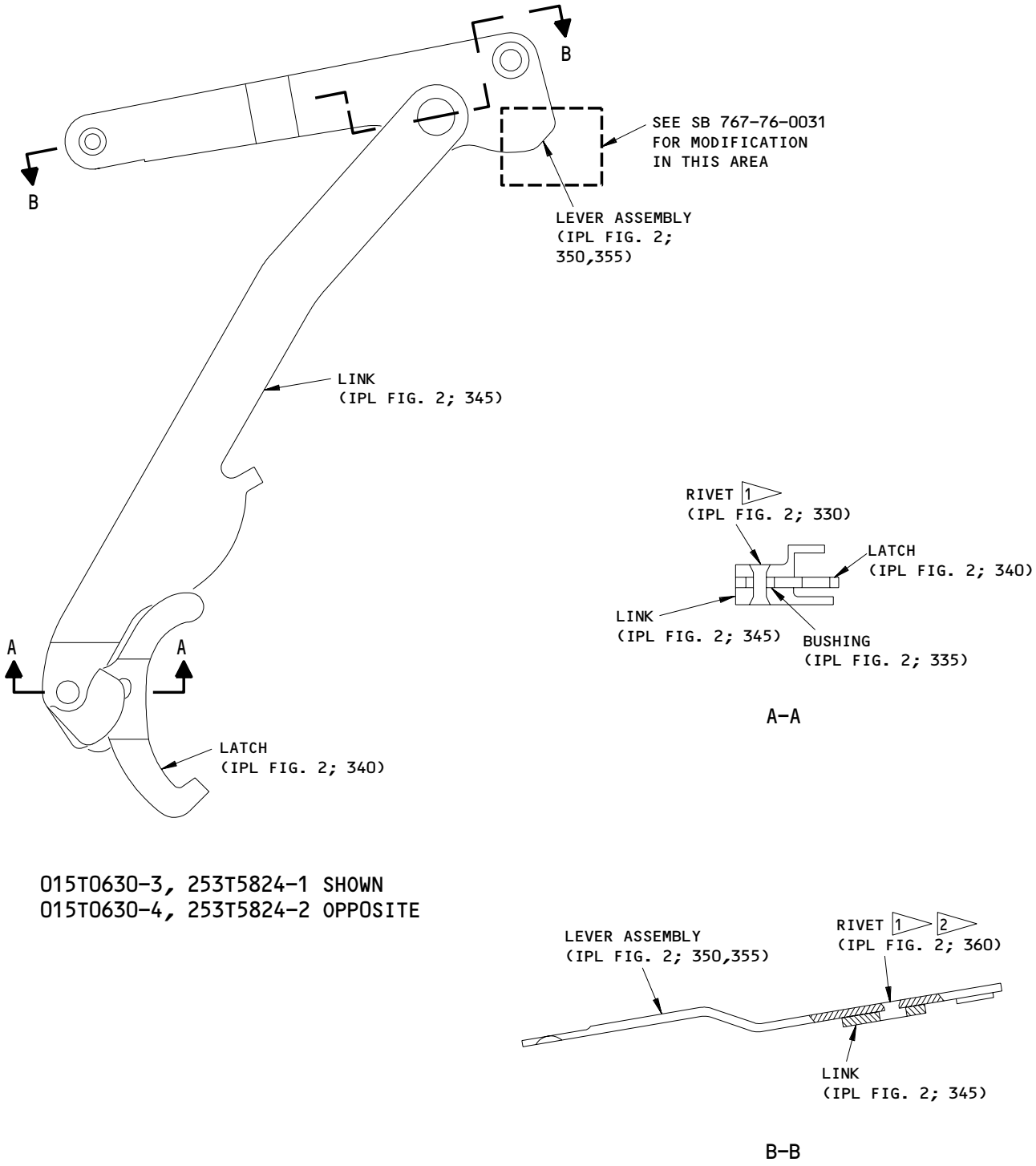

015T0630-3, 253T5824-1 SHOWN
015T0630-4, 253T5824-2 OPPOSITE

015T0630-3,-4,-13,-14; 253T5824-1,-2; 254N1134-5,-6; 254N1210-1,-2,-5,-6
Link Assembly Details
Figure 607 (Sheet 1)

A21812

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B. Link Assembly (435, IPL Fig. 4)

(1) Insert latch (430) and washers (415) into slot in link assy (435) and install bushing (427), bolt (405B), washer (410), and collar (420B).

NOTE: Latch and link assy shall rotate freely after installation of bolt.

CAUTION: USE CAUTION WHEN SHAVING RIVET HEAD TO PRECLUDE DAMAGE TO TIODIZE FINISH.

(2) Align lever assy (375A, 380A), washer (370), and link assy (435) and install rivet (365).

NOTE: Make sure that the driven head of the rivet is 0.25 minimum.

(a) Apply 0.003-inch thick protective tape to Tiodize-coated area around rivet head.

(b) Shave rivet head to 0.003 or less above the lever assy surface to avoid interference with thrust lever assy (1B, 5B).

(c) Lever assy and link assy shall rotate freely after installation of rivet.

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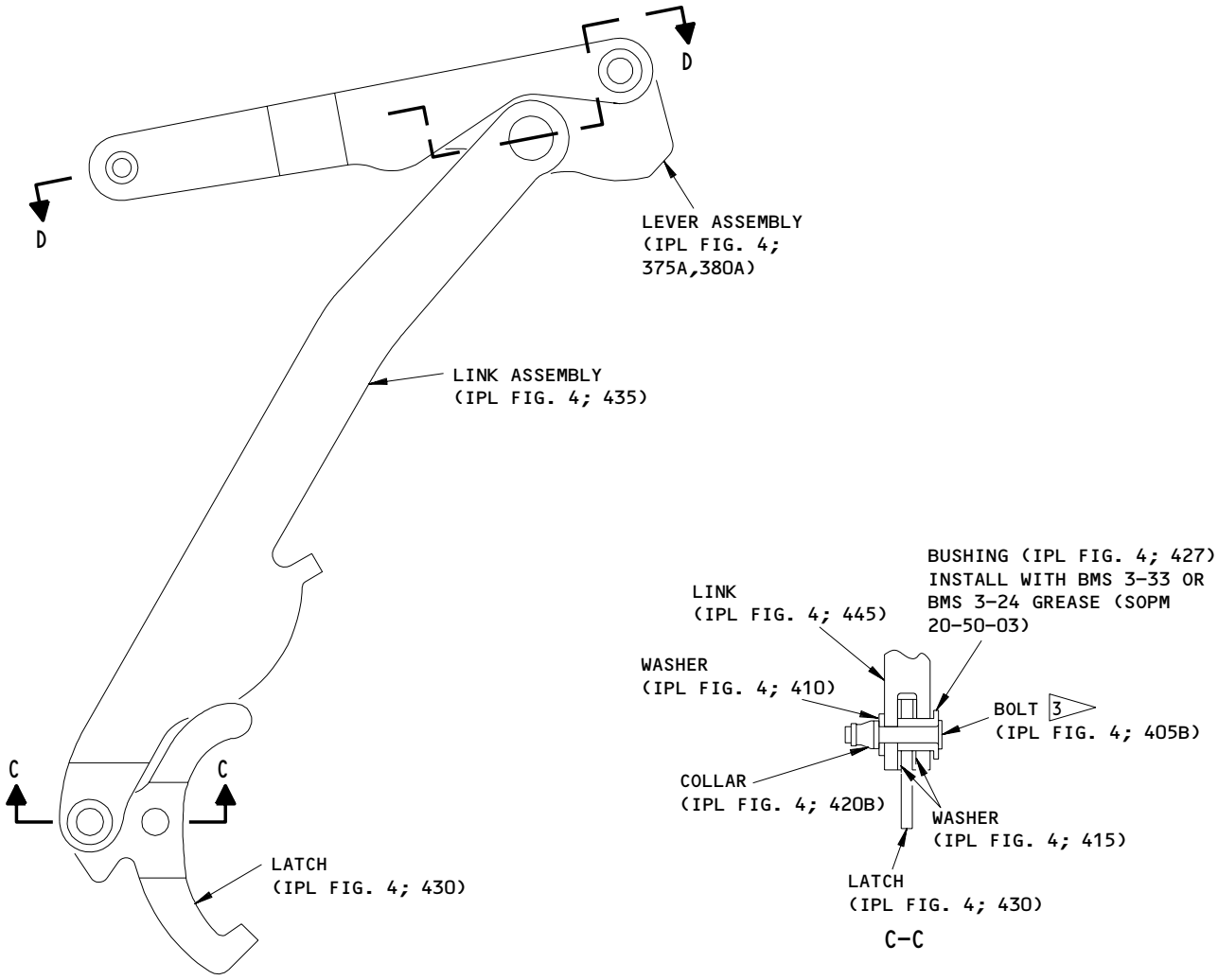


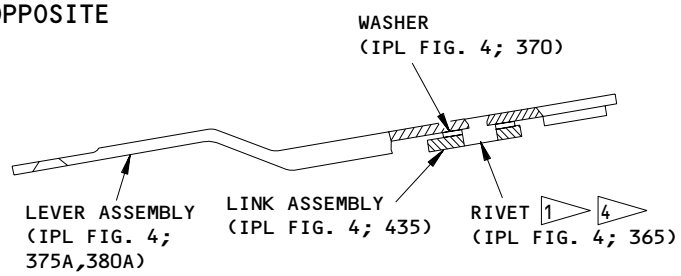
015T0630-13, 254N1134-5, 254N1210-1,-5 SHOWN
015T0630-14, 254N1134-6, 254N1210-2,-6 OPPOSITE

1 AFTER RIVET INSTALLATION, REVERSE THRUST LEVER AND LATCH SHALL ROTATE FREELY ON LINK

2 AFTER RIVET INSTALLATION, SHAVE RIVET HEAD TO 0.000-0.005 INCH ABOVE LEVER ASSEMBLY SURFACE

3 AFTER BOLT INSTALLATION, REVERSE THRUST LEVER AND LATCH SHALL ROTATE FREELY ON LINK

4 AFTER RIVET INSTALLATION, PROTECT LEVER ASSEMBLY AND SHAVE RIVET HEAD TO 0.000-0.005 INCH ABOVE LEVER ASSEMBLY SURFACE. DO NOT DAMAGE TIODIZE FINISH



ALL DIMENSIONS ARE IN INCHES

015T0630-3,-4,-13,-14; 253T5824-1,-2; 254N1134-5,-6; 254N1210-1,-2,-5,-6
Link Assembly Details
Figure 607 (Sheet 2)

A21815

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C. Link Assembly (315, IPL Fig. 5,6)

(1) Align lever (340) and link (325) and install rivet (320A).

(a) Formed head of rivet shall be 0.000-0.020 inch below surface of lever.

(b) Lever and link shall rotate freely after installation of rivet.

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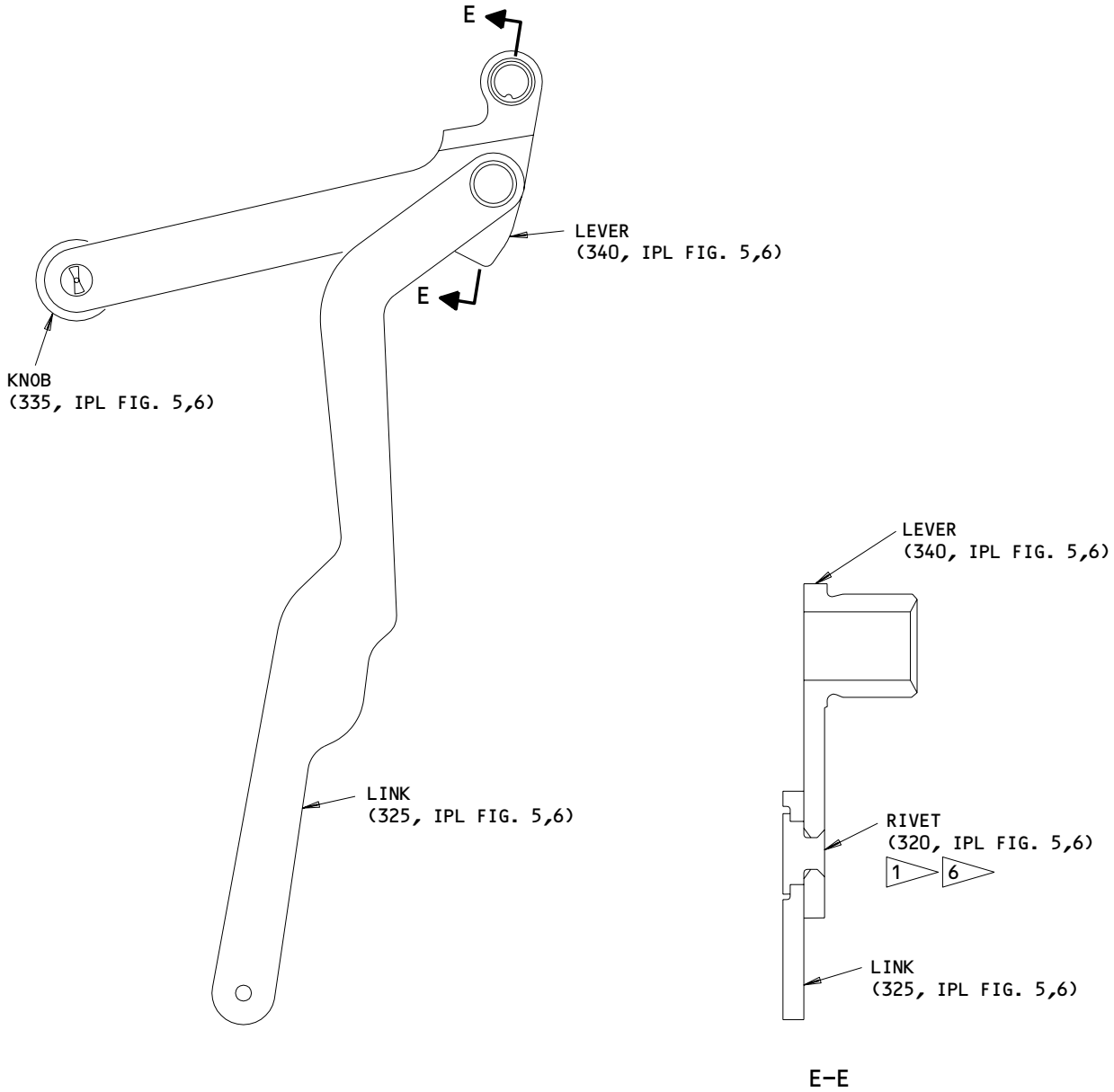

1 REVERSE THRUST LEVER AND LATCH SHALL ROTATE FREELY ON LINK AFTER RIVETING.

4 AFTER INSTALLATION OF RIVET (320, IPL FIG. 5,6), PROTECT LEVER AND SHAVE RIVET HEAD TO 0.000-0.020 INCH BELOW LEVER SURFACE.

ALL DIMENSIONS ARE IN INCHES

253T5855-1,-2
Link Assembly - Assembly Details
Figure 607 (Sheet 3)

A21817

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ASSEMBLY

1. The assembly procedure that follows contains the data necessary to assemble the Control Stand Thrust Lever Assembly.

2. Where applicable, use standard industry practices to assemble this Control Stand Thrust Lever Assembly.

3. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM chapters specified in this procedure.

4. Refer to IPL Fig. 1 thru 6 for the applicable item numbers.

5. Materials

   NOTE: If necessary, you can use equivalent substitutes.

   A. Primer -- BMS 10-11, type 1 (SOPM 20-60-02)

   B. Lockstitch -- 417X, EON Corp., 2425 San Fernando Road, Los Angeles, CA 90065 (SOPM 20-60-04)

   C. Heat-Shrink Tubing -- RT876, color yellow, Raychem Corp., Menlo Park, CA (SOPM 20-60-04)

   D. Varglass Sleeving -- Varflex Corp, 512 W. Court St., Rome, NY 13440 (SOPM 20-60-04)

   E. Teflon Tubing -- 5/16 dia. TFE-4X, Chemplast Inc., 150 Dey Road, Wayne, NJ 07470

   F. Adhesive -- Type 70 (SOPM 20-50-12)

   G. Sealant -- BMS 5-95 (SOPM 20-60-04)

   H. Lubricant -- C5-A anti-seize, Fel-Pro Inc, Skokie, Illinois (SOPM 20-60-03)

6. Equipment

   NOTE: If necessary, you can use equivalent substitutes.

   A. Adatper, Thrust Control Inner Shaft -- B76004-1

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7. Assembly

A. Install wiring and switches (253T5810-7, -8, -11 thru -16, 015T0630-5, -6 IPL Fig. 2).

(1) Assemble wire bundles A-F as shown in Fig. 701

NOTE: Install RT876 heat-shrink tubing as shown.

(2) Attach wiring to switches (35, 420) and connector (425) according to Fig. 701.

NOTE: Install heat-shrink tubing to cover all connections as shown.

(3) Attach switches (420, 428), actuators (415, 427) and shim (429) to lever assemblies (437, 447) with screws (400, 405, 410). See Fig. 701 for correct switch orientation.

NOTE: Screws must be flush or under-flush by one thread maximum.

(4) Install switch (35) in handle of lever assembly.

NOTE: Feed 4-wire bundle (B, E, Fig. 701) through channel in handle.

(5) Attach connector (425) to switch (428) (Ref IPL Fig. 2, view K).

(6) Collect wire bundles A-C and D-F and install heat-shrink tubing to make one-piece sleeve as shown in Fig. 701.

NOTE: Route wire bundle down through lever assembly as shown in the figure.

B. Install wiring and switches (253T5800 -17, -21, -23, -25, -27, -29, -31, -33, 015T0630-21 IPL Fig. 3).

(1) Assemble wire bundles A-F per Fig. 701 and install RT876 heat-shrink tubing as shown.

(2) Attach wiring to switches (5, 55) and connector (60) according to Fig. 701.

NOTE: Install heat-shrink tubing to cover all connections as shown.

(3) Attach switches (55), actuators (50) and shim (53) to lever assemblies (240A, 245A) with screws (40, 45). See Fig. 701 for correct switch orientation.

NOTE: Screws must be flush or under-flush by one thread maximum.

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(4) Install switch (5) in handle of lever assembly.

NOTE: Feed 4-wire bundle (B, E, Fig. 701) through channel in handle.

(5) Attach connector (60) to switch (55) (Ref IPL Fig. 3, view K).

(6) Collect wire bundles A-C and D-F and install heat-shrink tubing to make one-piece sleeve as shown in Fig. 701.

NOTE: Route wire bundle down through lever assembly as shown in the figure.

C. Install wiring and switches (253T5852-1 thru -6, IPL Fig. 5,6).

(1) Assemble wire bundles A-F per Fig. 701 and install RT876 heat-shrink tubing as shown.

(2) Attach wiring to switches (542, 543 IPL Fig. 5; 552, 553 IPL Fig. 6) according to Fig. 701.

NOTE: Install heat-shrink tubing to cover all connections as shown.

(3) Attach switches (543, IPL Fig. 5; 553, IPL Fig. 6) and actuators (415) to handle assembly (505) with screws (405, 410).

NOTE: Screws must be flush or under-flush by one thread maximum.

(4) Attach switch (543, IPL Fig. 5; 553, IPL Fig. 6) to bearing support assembly (265) using screws (120).

(5) Install switch (542, IPL Fig. 5; 552, IPL Fig. 6) in handle of lever assembly.

NOTE: Feed 4-wire bundle (B, E, Fig. 701) through channel in handle.

(6) Collect wire bundles A-C and D-F and install heat-shrink tubing to make one-piece sleeve as shown in Fig. 701.

NOTE: Route wire bundle down through lever assembly as shown in the figure.

D. Assemble crank and follower (253T5810-7, -8, -11 thru -16, 015T0630-5, -6 IPL Fig. 2).

(1) Install bearing (75) in crank assembly (175A) with wet primer, then attach cam (60) to crank with screws (65) and washers (70).

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(2) Install follower assembly (125) on crank assembly (175A) with bolt (110), washer (115), and bushing (120).

NOTE: Follower assembly must pivot freely after installation.

(3) Attach plates (85) to crank assembly (175A) and follower assembly (125) with bolts (90), washers (95, 100) and bushings (105).

NOTE: Plates must pivot freely on bushings after installation.

E. Assemble crank and follower (254N1131-7 thru -10, -17, -18, 015T0630-11, -12, -15, -16 IPL Fig. 4).

(1) Install bearing (60) in crank assembly (170) with wet primer, then attach cam (50) to crank with screws (40) and washers (45).

(2) Install follower assembly (110) on crank assembly (170) with bolt (95), washer (100), and bushing (105).

NOTE: Follower assembly must pivot freely after installation.

(3) Attach plates (90) to crank assembly (170) and follower assembly (110) with bolts (70), washers (75, 80) and bushings (85).

NOTE: Plates must pivot freely on bushings after installation.

F. Install lever assembly components (253T5810-7, -8, -11 thru -16, 015T0630-5, -6 IPL Fig. 2).

(1) Install counterweight assembly (480), detent cam (225) and shield (230) on to lever assembly (437, 447) using bolts (485B), spacers (495), washers (490A, 493), and nuts (500B).

(2) Feed wire bundle through wire support assembly (235) and shield (230), then attach wire support assembly to lever assembly (437, 447) using bolts (200), washers (212), and nuts (217).

NOTE: Tie wire bundle to wire support with lockstitch as shown in Fig. 701.

(3) Install bearing (75) in crank assy (175A).

(4) Install cam (60) using bolts (65) and washers (70).

(5) Apply wet primer to bearing contact surface of lever assembly, then immediately slide crank assembly (175A) and attached parts onto lever.

NOTE: Check that crank rotates smoothly without binding.

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(6) Install plates (85) using bolts (90), washers (95, 100) and spacers (105).

(7) Install springs (80) between plates (85).

NOTE: Check that follower bearing (145) rides smoothly on detent cam (225).

(8) Apply wet primer to bearing housing in lever assembly then immediately install bearing (55).

(9) Install retainers (45, 50) with rivets (40).

(10) Apply Fel-Pro C5-A anti-seize lubricant on lever latch catch (340) and inside bushing (335).

(a) Attach lever latch (340) to link (345) using rivet (330) and bushing (335).

(b) Attach reverse thrust lever assembly (350, 355) with rivet (360).

(c) Check that all parts pivot freely.

(11) Attach latch lever (340) to crank assembly (175A) using screw (165A) and bushing (170A).

(a) Install spring (160).

(b) Apply Fel-Pro C5-A anti-seize lubricant to mating surfaces at the point where the latch engages.

(12) Install trigger (320), link assembly (325) and stop (318, 319) on lever assembly using bolt (290), washers (295, 300), bushings (310, 315) and nut (305).

(a) Secure stop (318, 319) with rivet (317).

(b) Trigger and link assemblies must pivot freely on bushings.

(c) Check that trigger and reverse thrust lever (350, 355) ride on actuators (415, 427) freely and actuate switches without obstruction.

NOTE: Verify that the actuator arm roller is centered on the link assembly cam surface.

(13) Install spring (270) using screw (275), washers (280), and nuts (285), then attach spring to trigger.

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(14) Install latch (240) on lever assembly. For installation, use pin (245), washers (250), and cotter pin (255).

NOTE: Refer to IPL Fig. 2, Sheet 3, for the correct configuration to install the latch (240). After the latch is installed, refer to the Testing and Trouble Shooting section to do an operational test on the latch.

(15) Install cover (260), upper cover assembly (365) and lower cover (390) using screws (265, 370A, 395).

(16) Install knob (30).

NOTE: Attach knobs (10) with screws (20A).

G. Install lever assembly components (254N1131-7 thru -10, -17, -18, 015T0630-11, -12, -15, -16 IPL Fig. 4 except as noted).

(1) Install counterweight (222), (80, IPL Fig. 3) or shim (220), detent cam (225), and wire shield (230) on lever assembly (450, 455). Use bolts (190, 195), washers (205, 210), spacers (200) and nuts (215).

(2) Feed wire bundle through wire shield (230) and tie wire bundle to wire shield with lockstitch as shown in fig. 701.

(3) Install bearing (35) in lever assembly (450, 455) using wet primer.

(4) Install bearing (60) in crank assy (170).

(5) Install cam (50) using bolts (40) and washers (45).

(6) Install crank assembly (170) on lever assemblies (450, 455) using wet primer.

NOTE: Check that crank assembly rotates freely.

(7) Install retainers (25, 30) and spacer (55) with screws (20A).

(8) Install plates (90) using washers (75, 80), bushings (85) and bolts (70).

(9) Install springs (65) to plates (90) and check that follower bearing (130) rides freely on detent cam (225).

(10) Attach lever latch (430) to link (445) using bolt (405B), bushing (427), washers (410, 415) and collar (420B).

(11) Insert bushing (385) into levers (395, 400) and arm (390A). Install rivet (350A).

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(12) Install reverse thrust lever assemblies (375A, 380A) to link (445) with rivet (365), bushing (440) and washer (370).

(13) Install triggers (340, 345), springs (330, 335), stop (233, 238, IPL Fig. 3), rivet (236, IPL Fig. 3) and lever assemblies (375A, 380A) to thrust lever assemblies (450, 455) with bolt (255), nut (305), washers (260 thru 295) and bushing (300).

NOTE: Verify that the actuator arm roller is centered on the lever assembly cam surface. Also, trigger and link assembly must pivot freely on bushings.

(14) Install screw (310), spacer (320), washer (315) and nut (325). Attach spring (330, 335) to spacer (320).

(15) Insert bushing (160A) into crank assembly (170).

(a) Attach lever latch (430) to crank assembly (170) with bolt (145), washer (150) and collar (155).

(b) Connect spring (165).

(c) Apply Fel-Pro C5-A anti-seize lubricant to mating surfaces at point where latch engages.

(16) Install latch (250) on lever assembly (450, 455). Use pin (240), washers (245) and cotter pin (235).

NOTE: Refer to IPL Fig. 4, Sheet 4, for the correct configuration to install the latch (250). After the latch is installed, refer to the Testing and Trouble Shooting section to do an operational test on the latch.

(17) Install knob (15) with screw (10).

(18) Install knob (10, IPL Fig. 3).

(19) Install cover (20, 25, 35, IPL Fig. 3) on lever assembly using screws (15, 30, IPL Fig. 3)

H. Install lever assembly components (253T5852-1 thru -6, IPL Fig. 5,6).

(1) Install counterweight assembly (500), guide (195) on handle assembly (505) using bolts (145, 155B, 485A), spacer (160), washers (150A, 165, 170B, 490A) and nuts (175A, 495A).

(2) Feed wire bundle through guide (195).

NOTE: Tie wire bundle to guide with lockstitch as shown in Fig. 701.

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(3) Install bearing (465, 470A, 475) in crank (480) with wet primer, then attach cam (460) to crank with rivets (455).

(4) Apply wet primer to bearing contact surface of handle assembly, then immediately slide crank assembly (450) on to handle assembly.

NOTE: Check that crank rotates smoothly without binding.

(5) Apply wet primer to bearing housing in handle assembly then immediately install bearing (435).

(6) Install retainers (445, 430), spacer (447, IPL Fig. 6) with screws (440A, 425A).

(7) Apply Fel-Pro C5-A anti-seize lubricant to link (325) pivot points. Attach reverse thrust lever (340) and link (325) with rivet (320A).

NOTE: Check that parts pivot freely.

(8) Install bearing (85) and plunger (95) on bellcrank (90). Use pins (80) to install bearing and plunger.

(9) Install springs (70, 115A) and spacer (60) on plunger (95). Use washer (65A) and nut (50A, 55B) to install springs and spacer.

NOTE: Do not thread nuts (50A, 55B) onto plunger (95) more than necessary.

(10) Lift spring (70) to clear guide (305), then install bellcrank assembly (75A) and attached parts. Use screws (40B, 100B), washers (45A, 105A) and nuts (110) to install the parts.

(11) Install bearing (275) in bearing support housing (265).

(12) Install spacer (272, IPL Fig. 5) with rivet (282, IPL Fig. 5) on support (267).

(13) Attach link assembly (315) to bearing support housing using bolt (250A), washer (255A) and reverse thrust cam (260).

(a) Tighten bolt (250) within range of 22-25 pound-inches.

(b) Check link assembly actuates freely.

(14) Install trigger (380) and spring (400) on handle assembly (505) using bolt (360A), spacer (375), washer (365B) and nut (370A).

NOTE: Check trigger actuates freely.

(15) Install spacer (545, IPL Fig. 6) with rivet (540, IPL Fig. 6).

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(16) Install screw (385A), washer (395A) and spacer (390). Attach spring (400) to spacer (390).

(17) Align bearing support assembly (265) with handle assembly (505), then insert stop (345) and attach together with screws (200A, 205A, 210, 220A, 225) and washers (215A, 230A).

(18) Install pawl (140A) on lever assembly using pin (135) and cotter pin (130).

(19) Install covers (35, 355) using screws (30, 350).

(20) Install knob (25). Attach knob (335) with screw (330).

(21) Install packing (15), retainer (10) and ring (5).

I. Assemble control stand thrust lever assembly (253T5800-9, -13, -15, -19, 015T0630-17 thru -20 IPL Fig. 1).

(1) Install inner shaft (95) in outer shaft (100) with type 70 adhesive (SOPM 20-50-12) and adapter B76004-1.

(a) Tighten within torque range of 100-150 pound-inches.

(2) Slide bearing (55B) and spacer (35) onto shaft assembly (90), then install shaft in left thrust lever assembly (105D).

NOTE: Check that shaft rotates freely in lever assembly.

(3) Slide spacer (40), bearing (55B), and spacer (35) onto shaft assembly (90), then install right lever assembly (110D).

NOTE: Check that shaft rotates freely.

(4) Install spacer (30) and right support assembly (60), then secure with washer (45A) and nut (50).

(a) Tighten within torque range of 250-300 pound-inches.

(5) Slide left support assembly (65) onto shaft assembly (90).

(6) Check that supports (60, 65) and lever assemblies (105D, 110D) can rotate smoothly and independently on shaft assembly.

(7) Install shrinkable Teflon tubing on wire bundle (115) and tie with lockstitch as shown in Fig. 701.

(8) Install connectors P1 (120A), P2 (130), and P3 (125A) as shown in wiring diagram of Fig. 701.

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(9) Attach rod assemblies (25A) with bolts (10), washers (15H) and nuts (20).

NOTE: Direction of bolt installation is optional.

(10) Install pins (102) and cotter pins (103).

J. Assemble control stand thrust lever assembly (253T5800 -17, -21, -23, -25, -27, -29, -31, -33, -35, -37, -39, 015T0630-21 IPL Fig. 3).

(1) Install inner shaft (156) in outer shaft (157) with type 70 adhesive (SOPM 20-50-12) and adapter B76004-1.

(a) Tighten within torque range of 100-150 pound-inches.

(2) Slide bearing (215) and spacer (205) onto shaft assembly (155), then install shaft in left thrust lever assembly (240A, 243).

NOTE: Check that shaft rotates freely in lever assembly.

(3) Slide spacer (200), bearing (215), and spacer (205) onto shaft assembly (155), then install right lever assembly (245A, 248).

NOTE: Check that shaft rotates freely.

(4) Install spacer (210) and right support assembly (185), then secure with washer (160) and nut (165).

(a) Tighten within torque range of 250-300 pound-inches.

(5) Slide left support assembly (170) onto shaft assembly (155).

(6) Check that supports (170, 185) and lever assemblies (240A, 243, 245A, 248) can rotate smoothly and independently on shaft assembly.

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(7) Install shrinkable Teflon tubing on wire bundle (220) and tie with lockstitch as shown in Fig. 701.

(8) Install connectors P1 (217A, 230), P2 (218A, 235), and P3 (216, 225) as shown in wiring diagram of Fig. 701.

(9) Attach rod assemblies (150) with bolts (135), washers (140) and nuts (145).

(10) Install pins (65), spacer (75A) and cotter pins (103).

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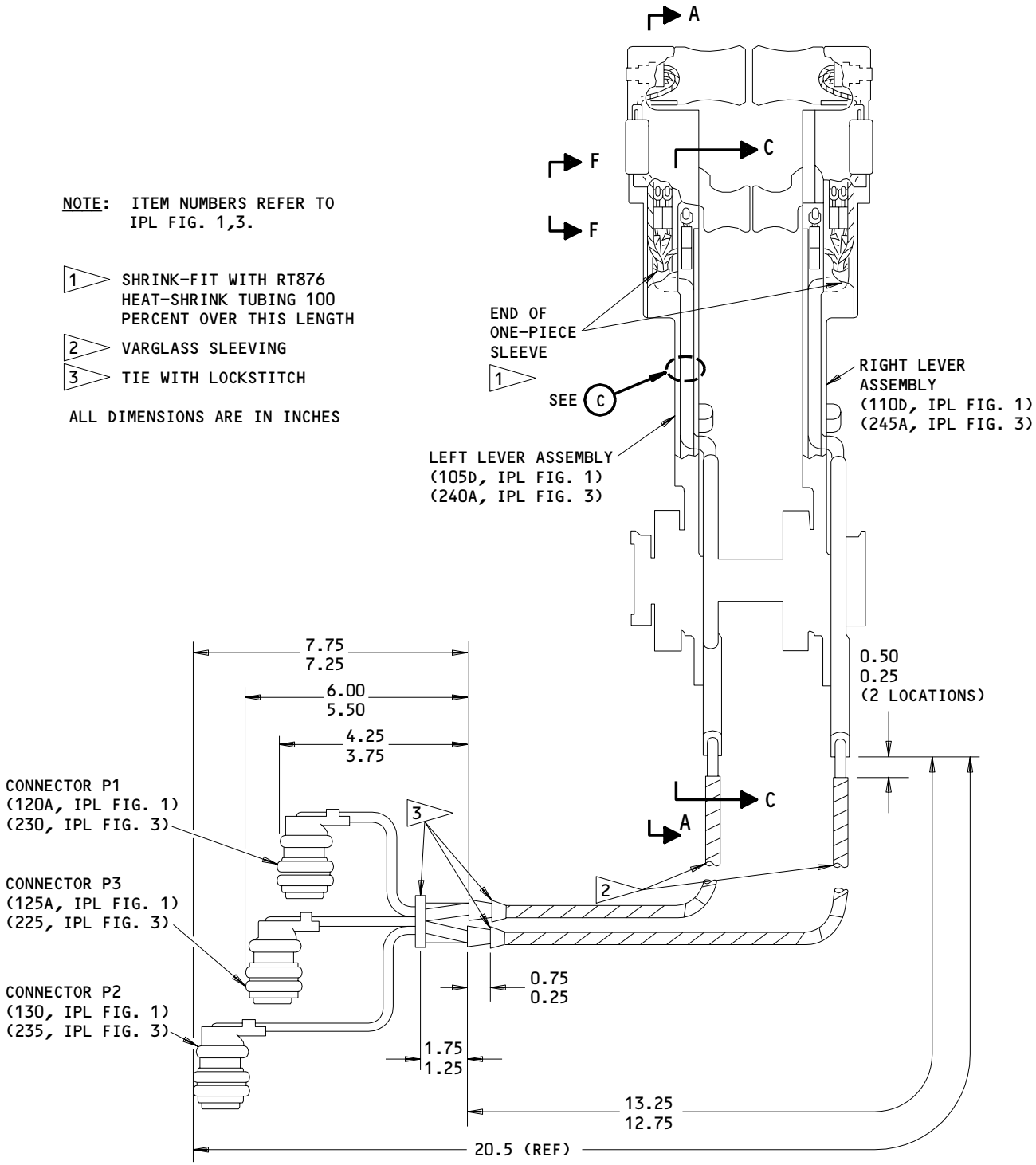

253T5800-9,-13,-15,-17,-19,-21,-23,-25,-27,-29,-31,-33
Switch and Wire Bundle Details
Figure 701 (Sheet 1)

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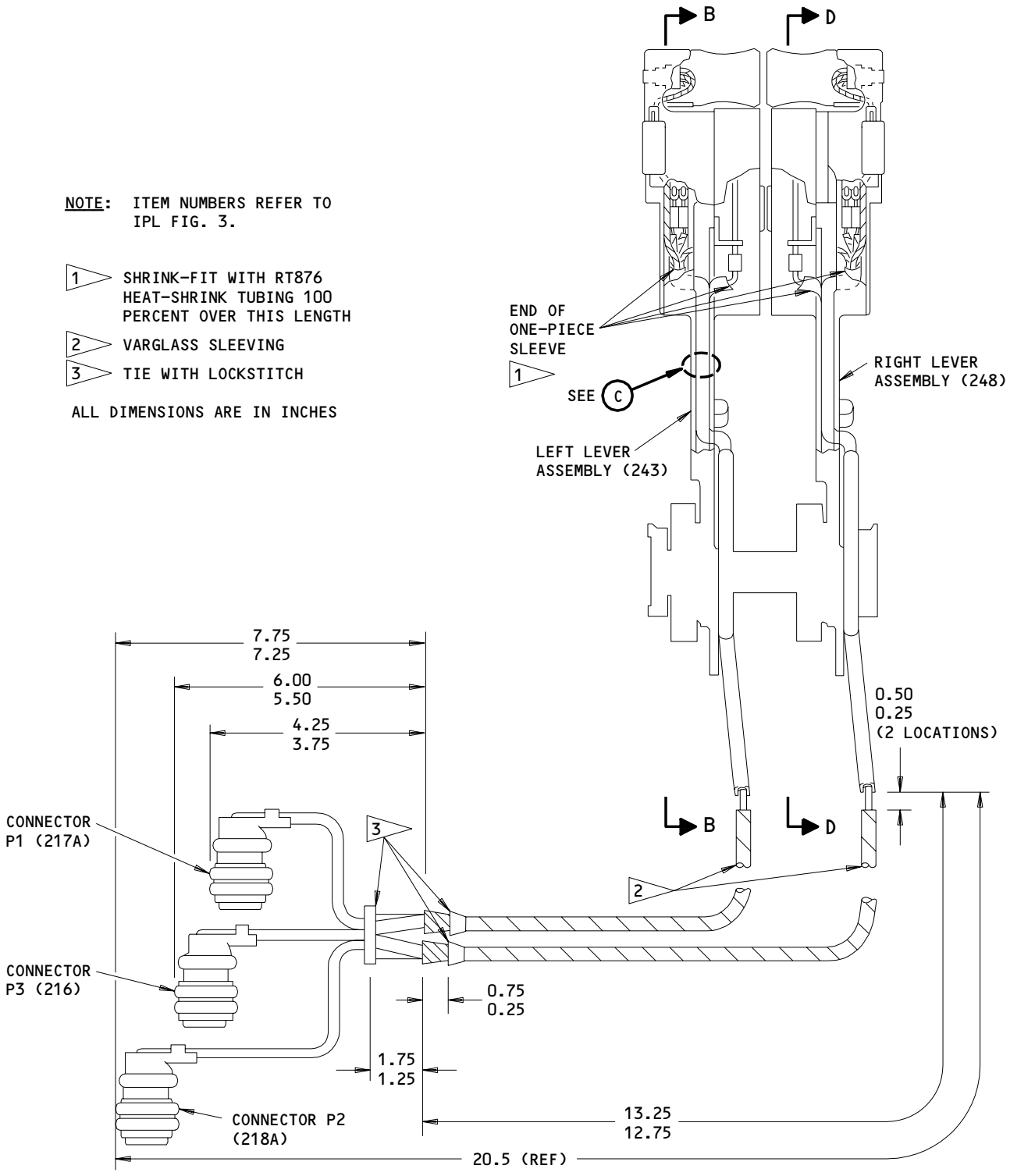

253T5800-35,-37,-39
Switch and Wire Bundle Details
Figure 701 (Sheet 2)

A21402

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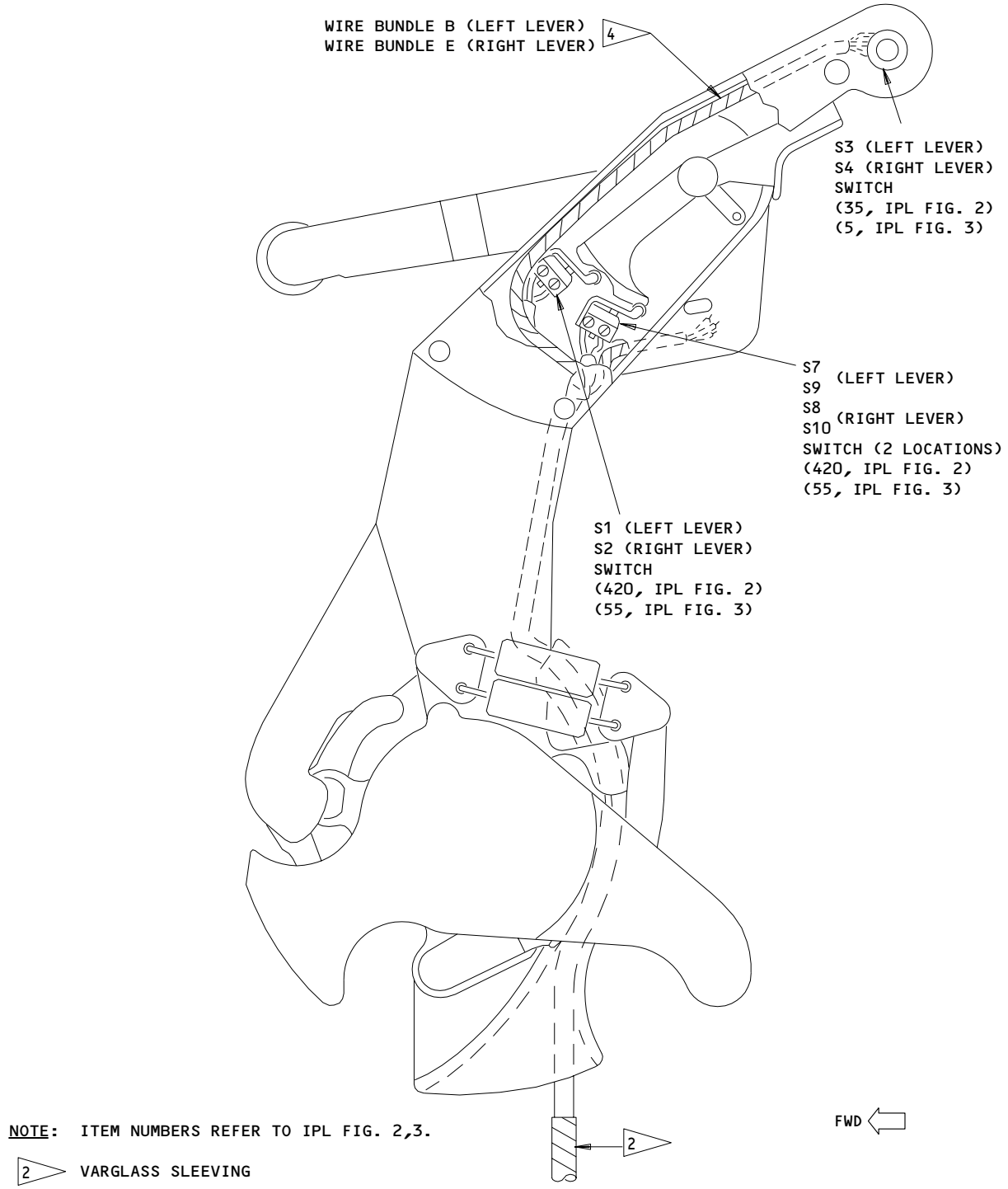

NOTE: ITEM NUMBERS REFER TO IPL FIG. 2,3.

2 VARGLASS SLEEVING

4 ROUTE WIRE BUNDLE TIGHT AGAINST FORWARD SURFACE OF THRUST LEVER

Switch and Wire Bundle Details
Figure 701 (Sheet 3)

4279

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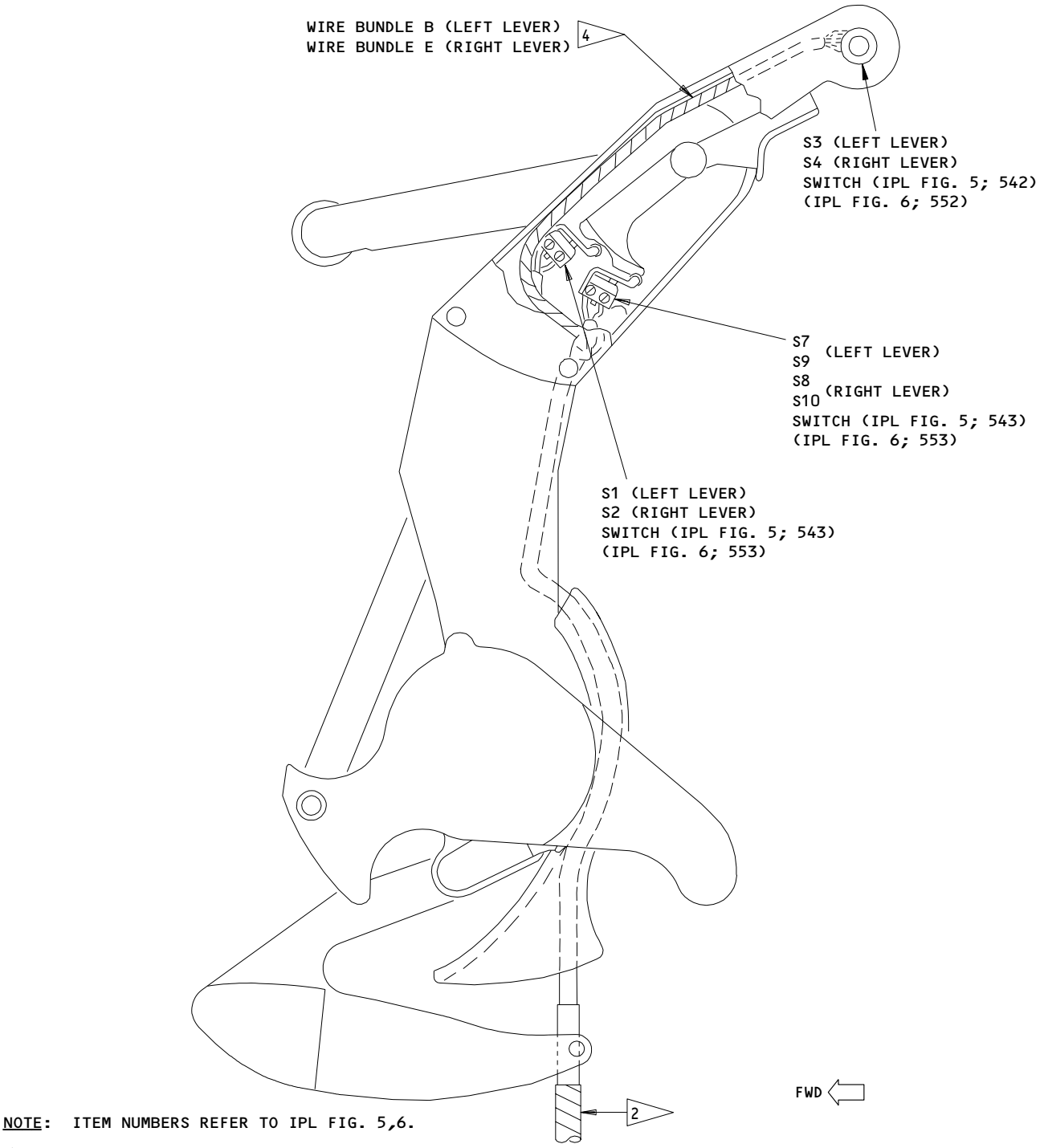

NOTE: ITEM NUMBERS REFER TO IPL FIG. 5,6.

2 VARGLASS SLEEVING

4 ROUTE WIRE BUNDLE TIGHT AGAINST FORWARD SURFACE OF THRUST LEVER

Switch and Wire Bundle Details
Figure 701 (Sheet 4)

A21436

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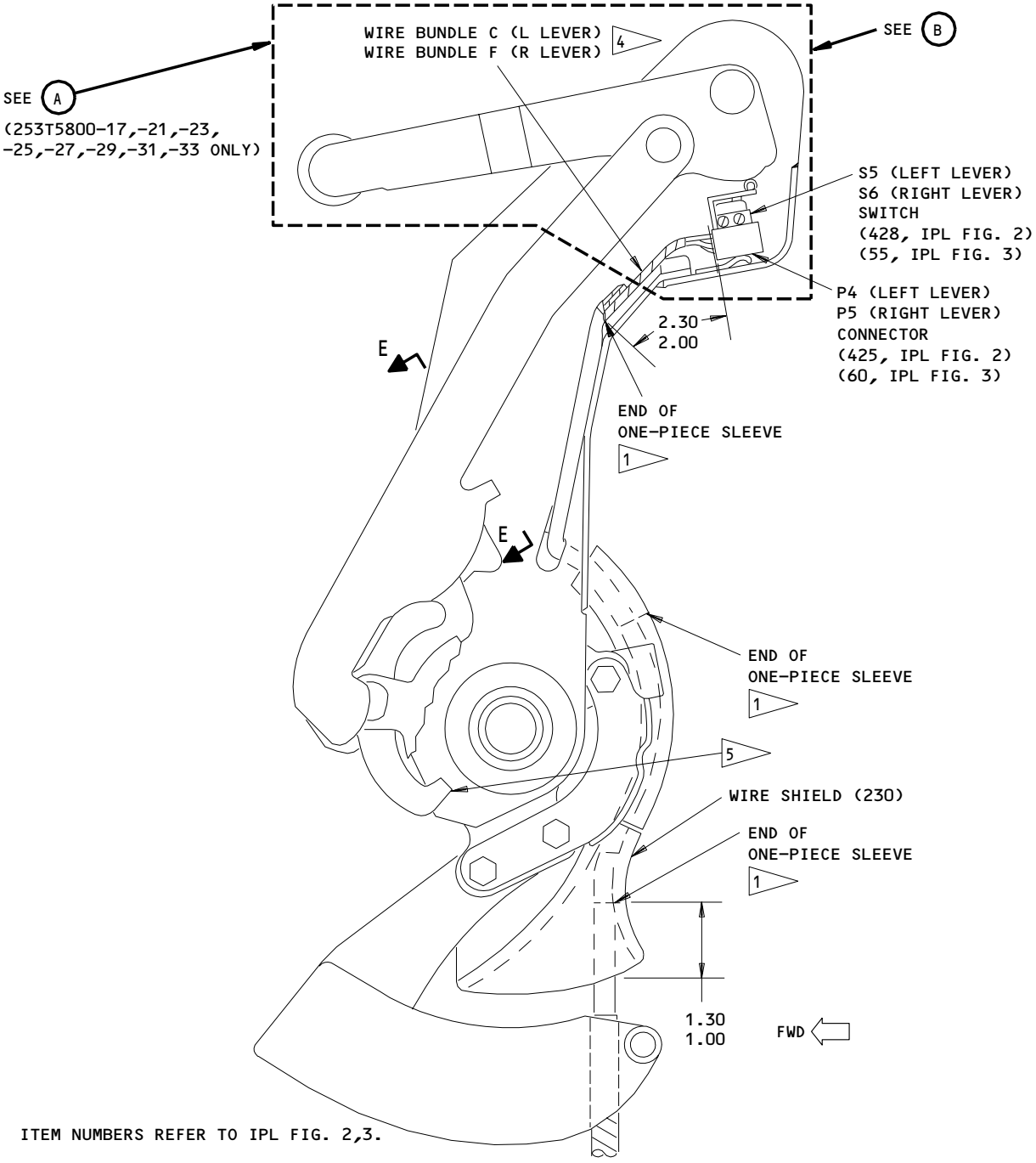

NOTE: ITEM NUMBERS REFER TO IPL FIG. 2,3.

1 SHRINK-FIT WITH RT876 HEAT-SHRINK TUBING 100 PERCENT OVER THIS LENGTH

4 ROUTE WIRE BUNDLE TIGHT AGAINST FORWARD SURFACE OF THRUST LEVER

5 LATCH MUST CLEAR BOTTOM OF NOTCH BY 0.003 MIN

C-C

ALL DIMENSIONS ARE IN INCHES

Switch and Wire Bundle Details
Figure 701 (Sheet 5)

4280

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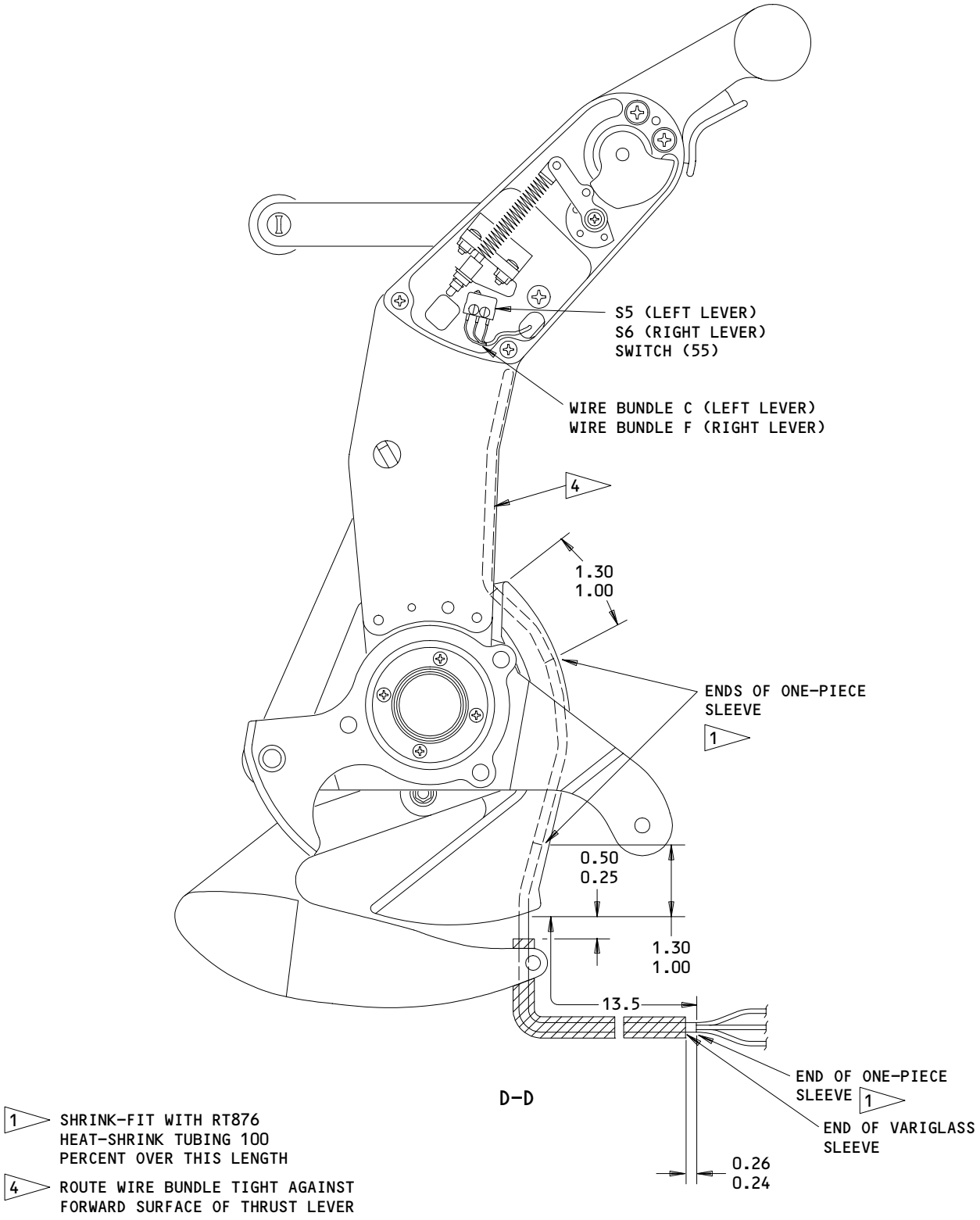

Switch and Wire Bundle Details
Figure 701 (Sheet 6)

A21467

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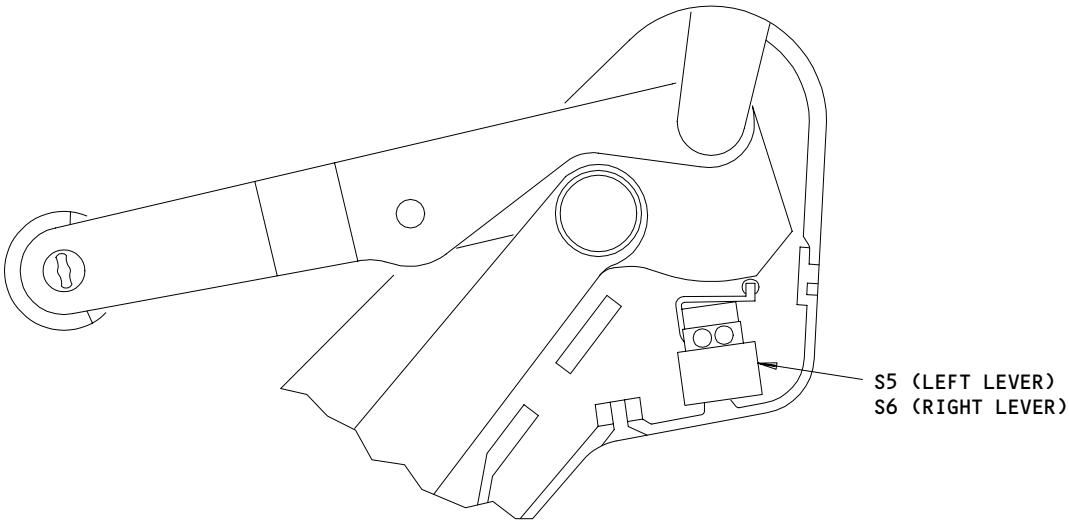
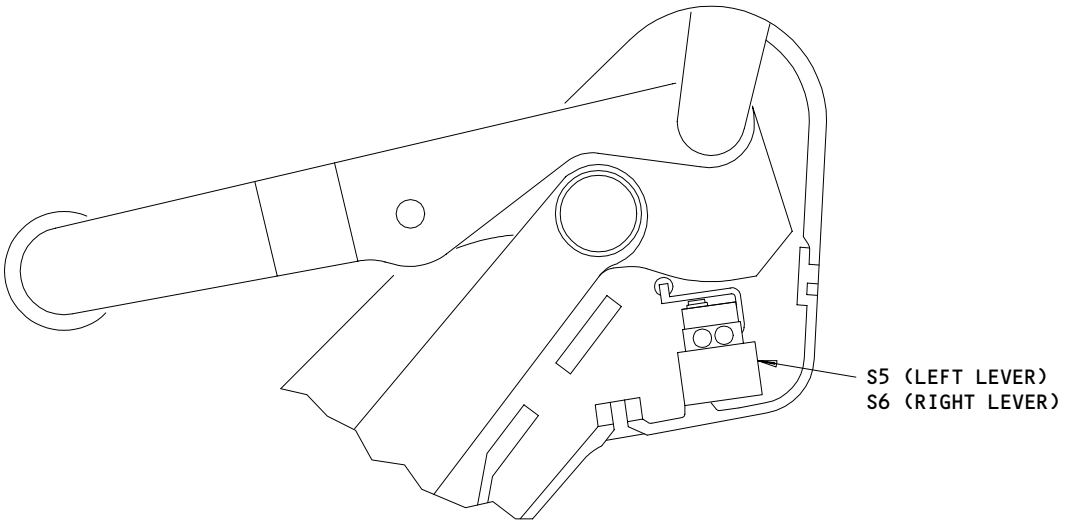


253T5800-17,-21,-23,-25,-27

A



253T5800-29,-31,-33

A

Switch and Wire Bundle Details
Figure 701 (Sheet 7)

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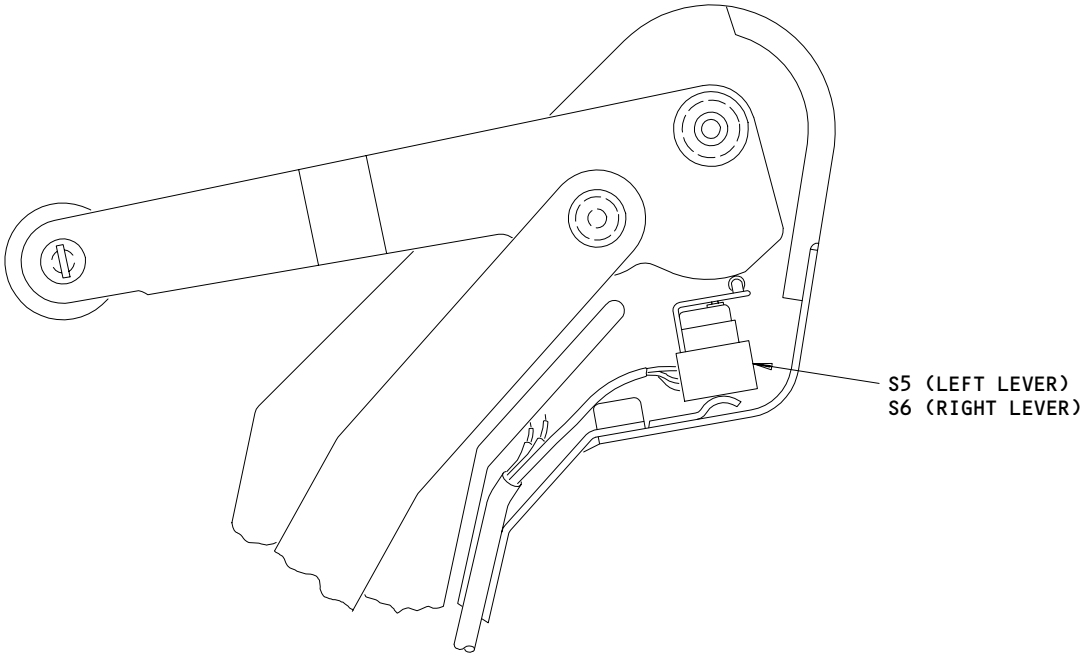
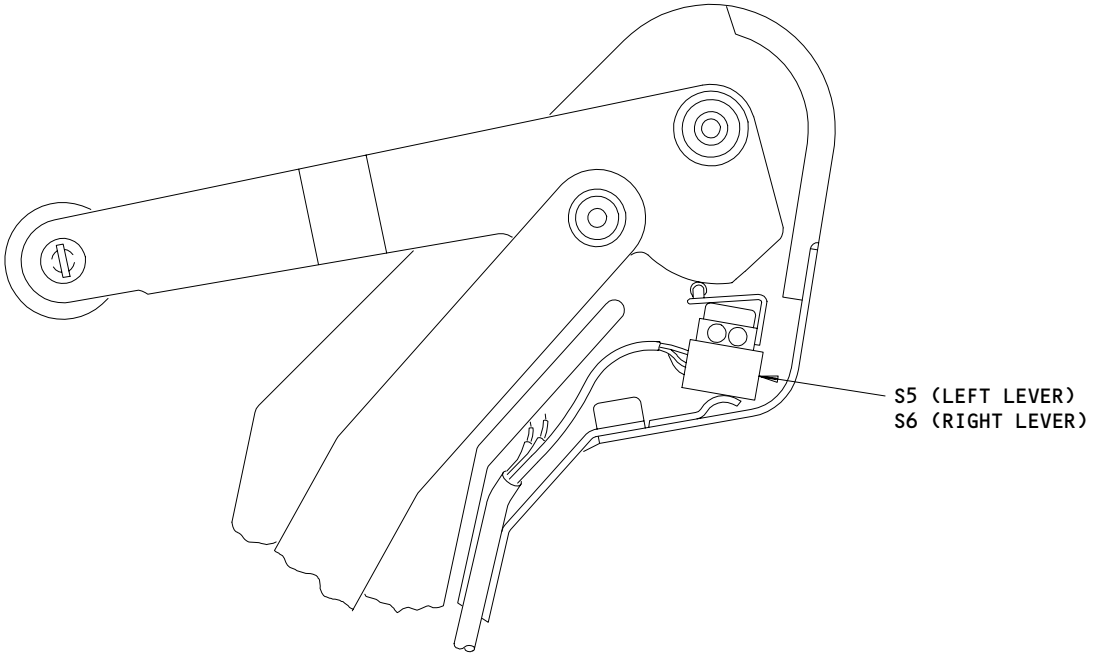


PRE SB 76-31

(B)



POST SB 76-31

(B)

Switch and Wire Bundle Details
Figure 701 (Sheet 8)

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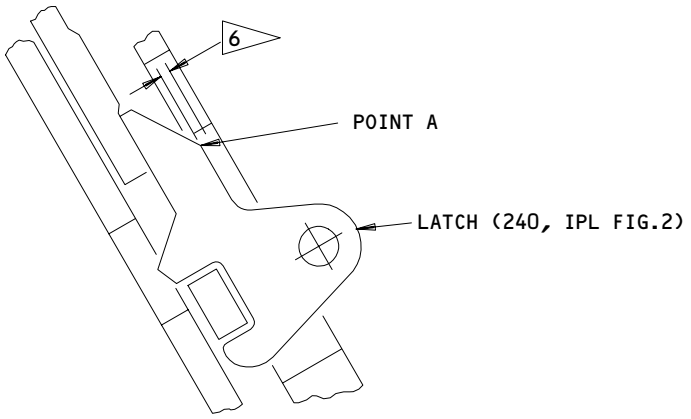
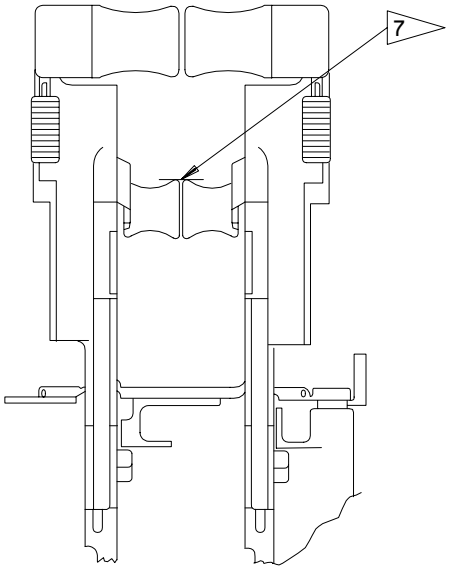


LATCH FREE TRAVEL
E-E



ALL DIMENSIONS ARE IN INCHES

6 ENSURE 0.001 MINIMUM FREE TRAVEL AT POINT A WITH REVERSE THRUST LEVER IN STOWED POSITION (NO LOAD CONDITION)

7 ENSURE REVERSE THRUST LEVER KNOB MISALIGNMENT DOES NOT EXCEED 0.15 WHEN FORWARD THRUST LEVER KNOBS ARE ALIGNED (REVERSE THRUST LEVERS IN STOWED POSITION)

Switch and Wire Bundle Details
Figure 701 (Sheet 9)

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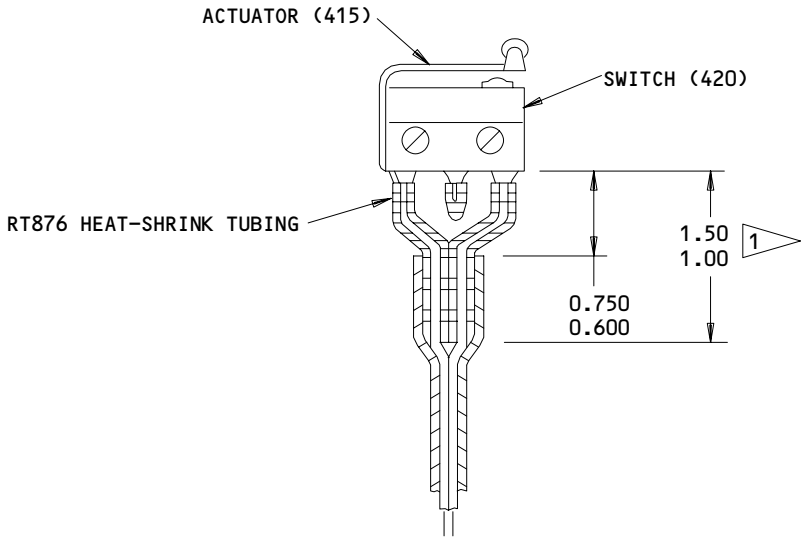


NOTES: INSTALLATION TYPICAL FOR ALL SWITCHES.

SLEEVING TO COVER CONNECTIONS ON ALL SWITCHES.

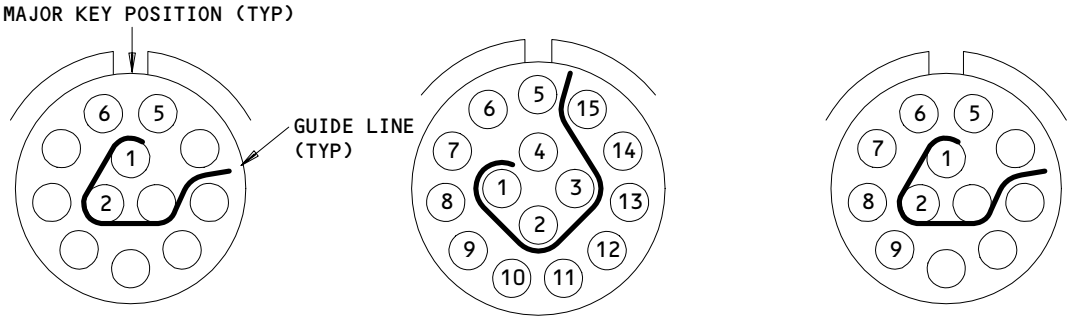
RT876 HEAT-SHRINK TUBING (YELLOW).

ITEM NUMBERS REFER TO IPL FIG. 2.

ALL DIMENSIONS ARE IN INCHES.

1 SHRINK-FIT WITH RT876 HEAT-SHRINK TUBING 100 PERCENT OVER THIS LENGTH

(SLEEVING INSTALLATION)
F-F



RECEPTACLE MAP FOR P2 RECEPTACLE MAP FOR P3 RECEPTACLE MAP FOR P1

RECEPTACLE MAPS
(WIRING SIDE)

Switch and Wire Bundle Details
Figure 701 (Sheet 10)

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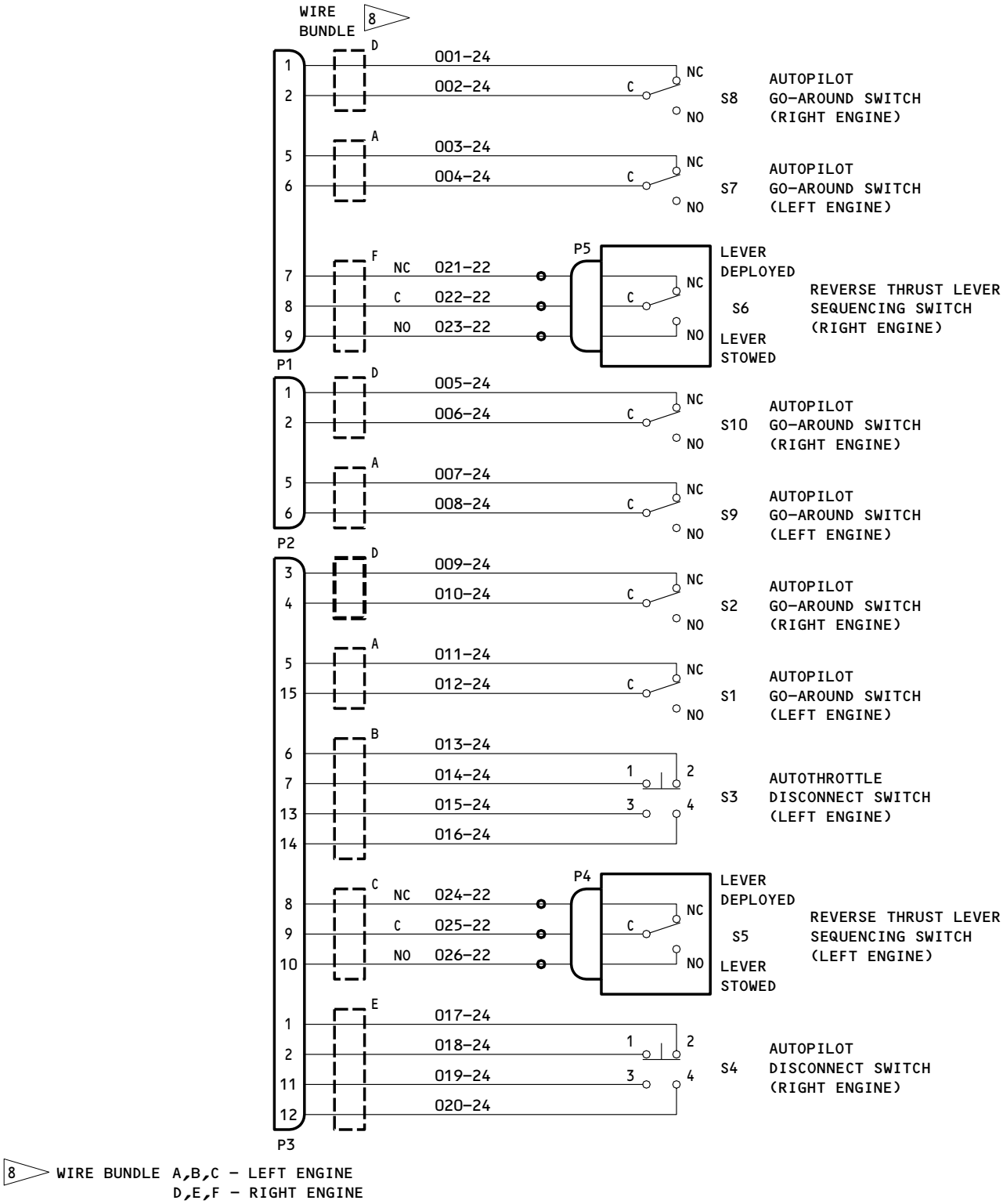

Switch and Wire Bundle Details
Figure 701 (Sheet 11)

4283

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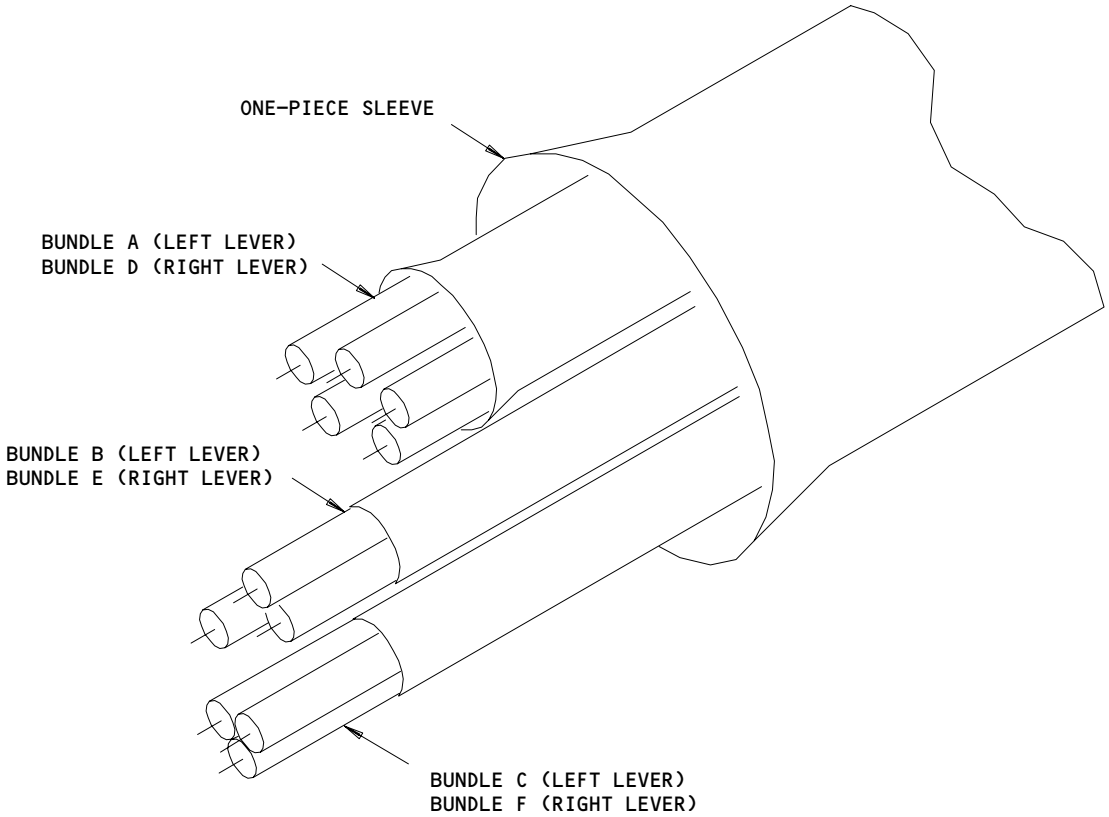

C

Switch and Wire Bundle Details
Figure 701 (Sheet 12)

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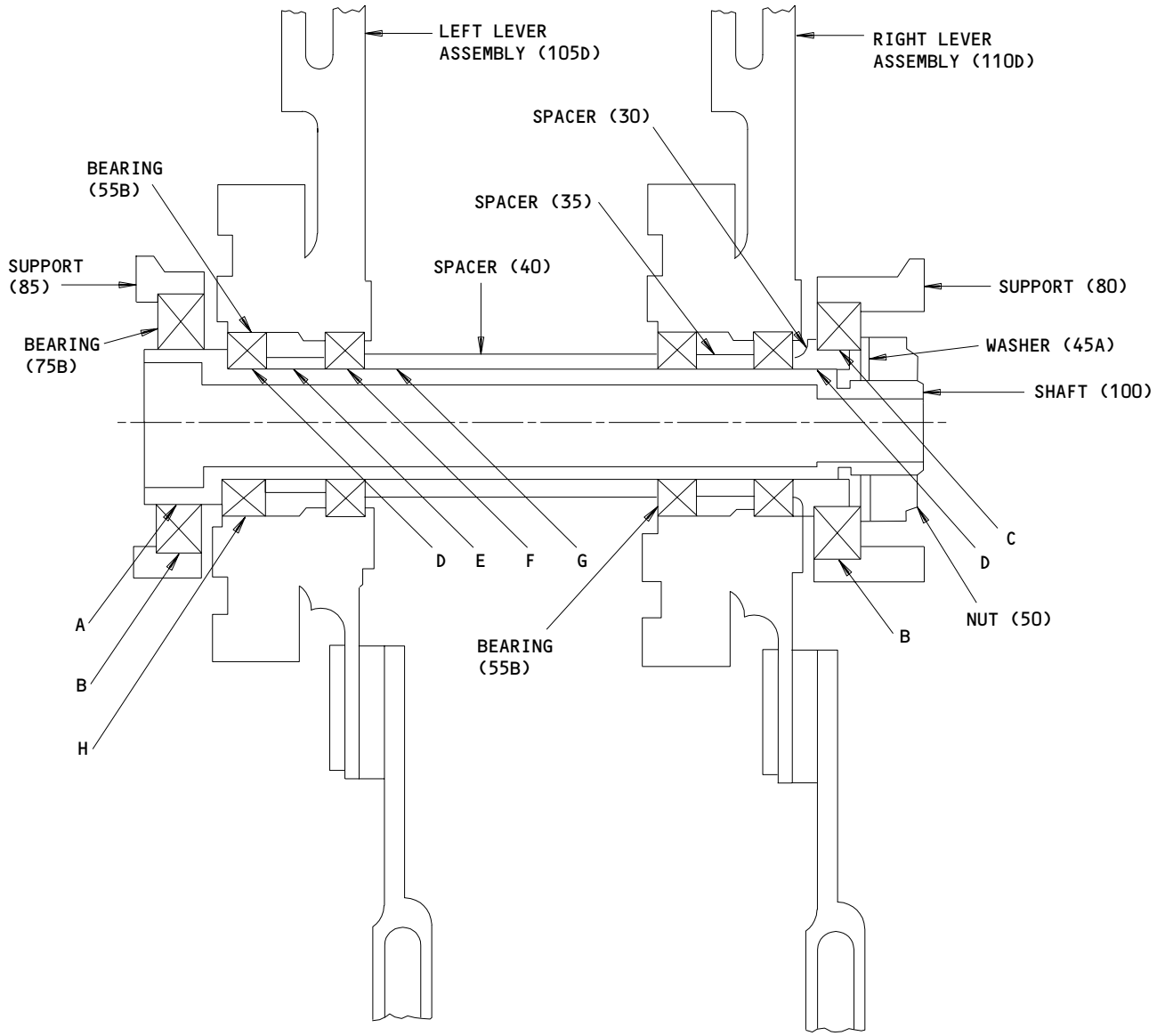
FITS AND CLEARANCES



REAR VIEW

ITEM NUMBERS REFER TO IPL FIG. 1

253T5800-9,-13,-15,-19
Fits and Clearances
Figure 801 (Sheet 1)

4284

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Ref Letter Fig.801	Mating Item No. IPL Fig.1	Design Dimension				Service Wear Limit		
		Dimension		Assembly Clearance		Dimension		Maximum Clearance
		Min	Max	Min	Max	Min	Max	
A	ID 75B OD 100	0.9995 0.9990	1.0000 0.9995	0.0000	0.0010			
B	ID 80,85 OD 75B	1.5995 1.5995	1.6000 1.6000	-0.0005 [1]	0.0005			
C	ID 75B OD 30	0.9995 0.997	1.0000 0.999	0.0005	0.0030			
D	ID 30,55B OD 100	0.7493 0.7483	0.7507 0.7493	0.0000	0.0024			
E	ID 35 OD 100	0.752 0.7483	0.757 0.7493	0.0027	0.0087			
F	ID 55 [2] OD 100	0.7493 0.7483	0.7507 0.7493	0.0000	0.0024			
G	ID 40 OD 100	0.752 0.69	0.757 0.71	0.042	0.067			
H	ID 437, 447 [2] OD 55B	1.1875 1.1865	1.1885 1.1875	0.0000	0.0020			

[1] INTERFERENCE FIT

[2] IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

Fits and Clearances
Figure 801 (Sheet 2)

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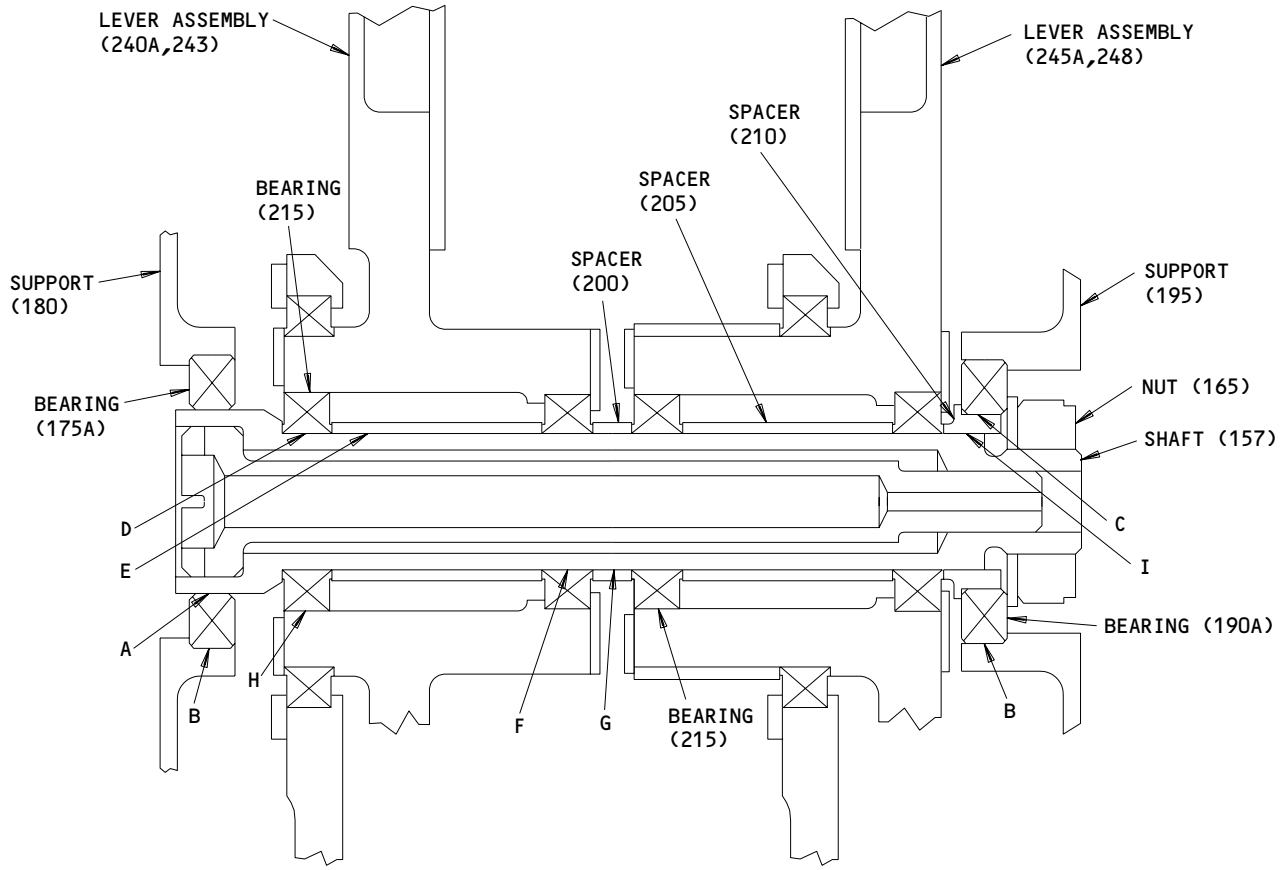

REAR VIEW

ITEM NUMBERS REFER TO IPL FIG. 3

253T5800-17,-21,-23,-25,-27,-29,-31,-33,-35,-37,-39
Fits and Clearances
Figure 802 (Sheet 1)

A16981

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Ref Letter Fig.802	Mating Item No. IPL Fig.3	Design Dimension				Service Wear Limit		
		Dimension		Assembly Clearance		Dimension		Maximum Clearance
		Min	Max	Min	Max	Min	Max	
A	ID 175A	0.9995	1.0000	0.000 [1]	0.001 [1]			
	OD 157	0.9990 [1]	0.9995 [1]	0.0005 [2]	0.002 [2]			
		0.9980 [2]	0.9990 [2]					
B	ID 180,195	1.5995	1.6000	−0.0005 [6]	0.0005			
	OD 175A,190A	1.5995	1.6000					
C	ID 190A	0.9995	1.0000	0.0000	0.001			
	OD 210	0.9990	0.9995					
D	ID 215	0.7495	0.7500	0.000 [1]	0.0015 [1]			
	OD 157	0.7485 [1]	0.7495 [1]	0.0005 [2]	0.002 [2]			
		0.7480 [2]	0.7490 [2]					
E	ID 205	0.752	0.757	0.0025 [1]	0.0085 [1]			
	OD 157	0.7485 [1]	0.7495 [1]	0.003 [2]	0.009 [2]			
		0.7480 [2]	0.7490 [2]					
F	ID 35 [3] 435 [4] 435 [5]	0.7495	0.7500	0.0000 [1]	0.0015 [1]			
	OD 157	0.7485 [1]	0.7495 [1]	0.0005 [2]	0.002 [2]			
		0.7480 [2]	0.7490 [2]					
G	ID 200	0.752	0.757	0.0025 [1]	0.0085 [1]			
	OD 157	0.7485 [1]	0.7495 [1]	0.003 [2]	0.009 [2]			
		0.7480 [2]	0.7490 [2]					
H	ID 240A,243, 245A,248	1.1875	1.1885	0.0000	0.0015			
	OD 215	1.1870	1.1875					
I	ID 210	0.7493	0.7507	−0.0002 [1]	0.0022 [1]			
	OD 157	0.7485 [1]	0.7495 [1]	−0.0025 [2] [6]	0.0027 [2]			
		0.7480 [2]	0.7490 [2]					

[1] 254N1153-1 IN USE
[2] 254N1153-2 IN USE
[3] IPL FIG. 4
[4] IPL FIG. 5
[5] IPL FIG. 6
[6] INTERFERENCE FIT DENOTED WITH NEGATIVE NUMBERS

Fits and Clearances
Figure 802 (Sheet 2)

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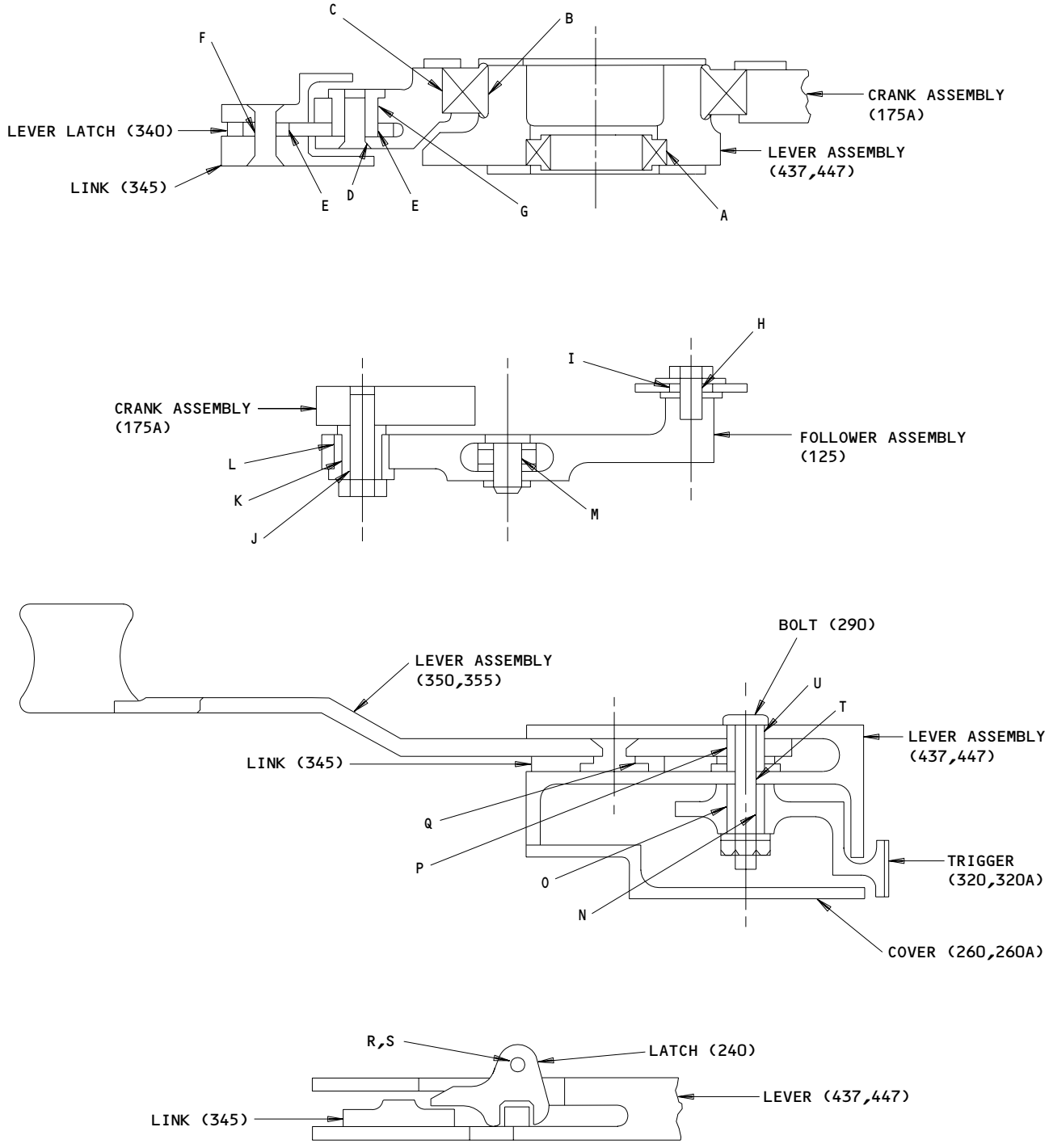

Fits and Clearances
Figure 803 (Sheet 1)

4285

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Ref Letter Fig.803	Mating Item No. IPL Fig.2	Design Dimension				Service Wear Limit		
		Dimension		Assembly Clearance		Dimension		Maximum Clearance
		Min	Max	Min	Max	Min	Max	
A	ID 437,447	1.1875	1.1885	0.0000	0.0020			
	OD 55	1.1865	1.1875					
B	ID 75	1.8120	1.8125	0.0000	0.0010			
	OD 437,447	1.8115	1.8120					
C	ID 175A	2.562	2.563	-0.0005 (1)	0.0015			
	OD 75	2.5615	2.5625					
D	ID 175A	0.1895	0.1905	0.0000	0.0015		0.1920	
	OD 165A	0.1890	0.1895			0.1875		0.0030
E	ID 340	0.3745	0.3755	0.0002	0.0017		0.3772	
	OD 170A	0.3738	0.3743			0.3721		0.0034
	ID 340	0.3745	0.3755	0.0020	0.0035		0.3795	
	OD 335	0.3720	0.3725			0.3675		0.007
F	ID 335	0.1895	0.1905	0.0000	0.0020			
	OD 330	0.1885	0.1895					
G	ID 175A	0.3750	0.3756	0.0007	0.0018		0.3773	
	OD 170A	0.3738	0.3743			0.3721		0.0035
H	ID 105	0.1900	0.1915	0.0005	0.0030			
	OD 90	0.1885	0.1895					
I	ID 85	0.322	0.326	0.0084	0.0129			
	OD 105	0.3131	0.3136					
J	ID 120	0.1800	0.2000	-0.0095 (1)	0.0115			
	OD 110	0.1885	0.1895					

ALL DIMENSIONS ARE IN INCHES

Fits and Clearances
Figure 803 (Sheet 2)

A16960

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Ref Letter Fig.803	Mating Item No. IPL Fig.2	Design Dimension				Service Wear Limit		
		Dimension		Assembly Clearance		Dimension		Maximum Clearance
		Min	Max	Min	Max	Min	Max	
K	ID 150 OD 120	0.3140 0.3131	0.3150 0.3136	0.0004	0.0019			
L	ID 155 OD 150	0.4375 0.4381	0.4381 0.4386	−0.0011 1	0.0000			
M	ID 145 OD 135	0.1895 0.1865	0.1900 0.1895	0.0000	0.0035			
N	ID 310,315 OD 290	0.1900 0.1885	0.1915 0.1895	0.0005	0.0030	0.1865	0.1935	0.0050
O	ID 320 OD 315	0.3160 0.3131	0.3200 0.3136	0.0024	0.0069	0.3022	0.3274	0.0138
P	ID 350,355 OD 310	0.3150 0.3131	0.3170 0.3136	0.0014	0.0039	0.3112	0.3189	0.0058
Q	ID 345 OD 360	0.375 0.370	0.379 0.373	0.002	0.009	0.360	0.388	0.015
R	ID 437,447 OD 245	0.125 0.122	0.127 0.124	0.001	0.005			
S	ID 240 OD 245	0.1245 0.1220	0.1270 0.1240	0.0005	0.0050			
T	ID 437,447 OD 290	0.1895 0.1885	0.1905 0.1895	0.0000	0.0020	0.1865	0.1925	0.0040
U	ID 437,447 OD 310	0.3140 0.3131	0.3150 0.3136	0.0004	0.0019	0.3112	0.3169	0.0038

1 INTERFERENCE FIT

ALL DIMENSIONS ARE IN INCHES

Fits and Clearances
Figure 803 (Sheet 3)

A16962

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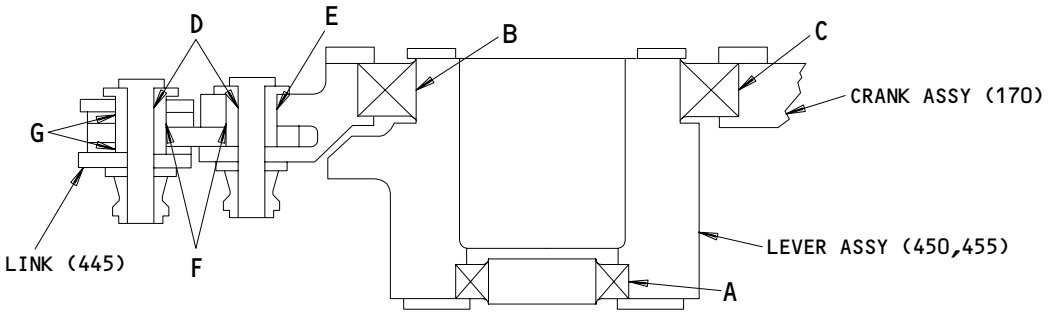

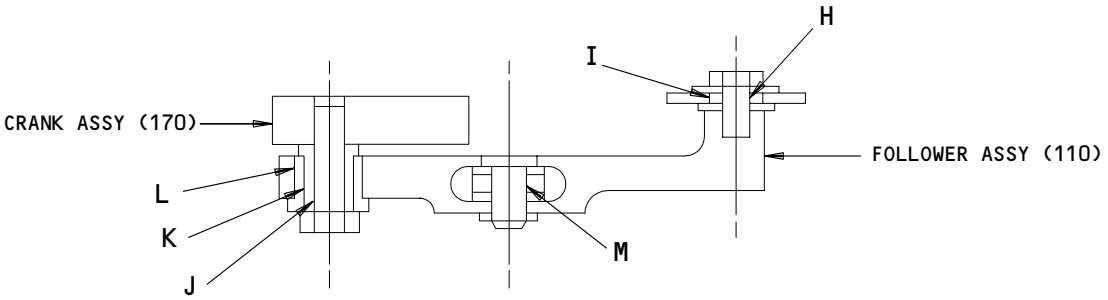

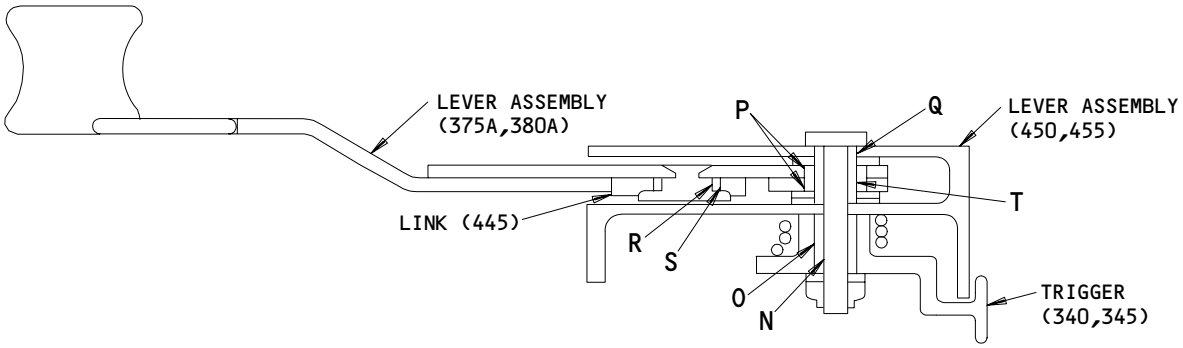

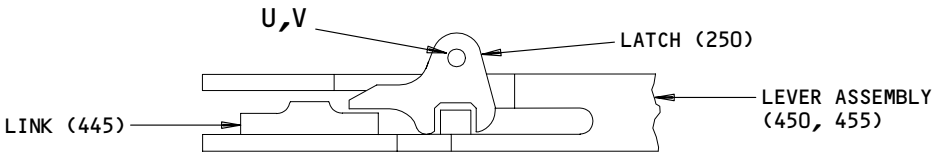

ITEM NUMBERS REFER TO IPL FIG. 3

Fits and Clearances
Figure 804 (Sheet 1)

199493

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Ref Letter Fig.804	Mating Item No. IPL Fig.4	Design Dimension				Service Wear Limit		
		Dimension		Assembly Clearance		Dimension		Maximum Clearance
		Min	Max	Min	Max	Min	Max	
A	ID 450,455 OD 35	1.1875 1.1870	1.1885 1.1875	0.0000	0.0015			
B	ID 60 OD 450,455	1.8120 1.8115	1.8125 1.8120	0.0000	0.0010			
C	ID 185 OD 60	2.5620 2.5615	2.5630 2.5625	-0.0005 1	0.0015			
D	ID 160A,425 OD 145,405B	0.1895 0.1890	0.1905 0.1895	0.0000	0.0015			
E	ID 185 OD 160	0.3725 0.3720	0.3730 0.3725	0.0000	0.0010			
F	ID 430 OD 160,425	0.3745 0.3720	0.3755 0.3725	0.0020	0.0035			
G	ID 415 OD 425	0.3800 0.3720	0.3900 0.3725	0.0075	0.0180			
H	ID 85 OD 70	0.1900 0.1885	0.1915 0.1895	0.0005	0.0030			
I	ID 90 OD 85	0.3220 0.3131	0.3260 0.3136	0.0084	0.0129			
J	ID 105 OD 95	0.1900 0.1885	0.1915 0.1895	0.0005	0.0030			
K	ID 135 OD 105	0.3140 0.3131	0.3150 0.3136	0.0004	0.0019			

1 INTERFERENCE FIT

ALL DIMENSIONS ARE IN INCHES

Fits and Clearances
Figure 804 (Sheet 2)

199495

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Ref Letter Fig.804	Mating Item No. IPL Fig.4	Design Dimension				Service Wear Limit		
		Dimension		Assembly Clearance		Dimension		Maximum Clearance
		Min	Max	Min	Max	Min	Max	
L	ID 140 OD 135	0.4375 0.4381	0.4381 0.4386	-0.0011 [1]	0.0000			
M	ID 130 OD 120	0.1895 0.1865	0.1900 0.1895	0.0000	0.0035			
N	ID 300 OD 255	0.1900 0.1890	0.1915 0.1895	0.0005	0.0025			
O	ID 340,345 OD 300	0.3140 0.3131	0.3160 0.3136	0.0004	0.0029			
P	ID 390,395, 400 OD 385	0.4375 0.4381	0.4381 0.4386	-0.0011 [1]	0.0000			
Q	ID 450,455 OD 300	0.3140 0.3131	0.3150 0.3136	0.0004	0.0019			
R	ID 440 OD 365	0.3750 0.3730	0.3765 0.3740	0.0010	0.0035			
S	ID 445 OD 440	0.5000 0.5006	0.5006 0.5013	-0.0013 [1]	0.0000			
T	ID 385 OD 300	0.3141 0.3131	0.3146 0.3136	0.0005	0.0015			
U	ID 450,455 OD 240	0.1250 0.1220	0.1270 0.1240	0.0010	0.0050			
V	ID 250 OD 240	0.1245 0.1220	0.1270 0.1240	0.0005	0.0050			

[1] INTERFERENCE FIT
[2] IPL FIG. 3

ALL DIMENSIONS ARE IN INCHES

Fits and Clearances
Figure 804 (Sheet 3)

199497

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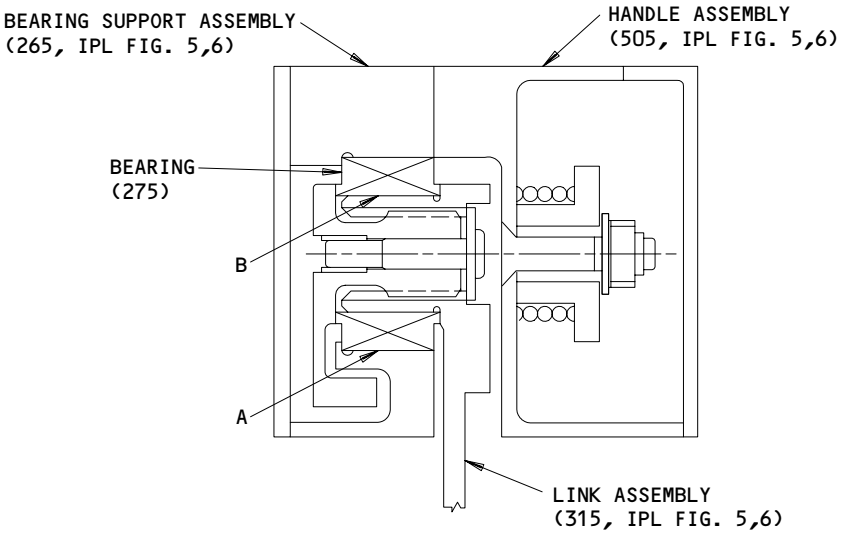
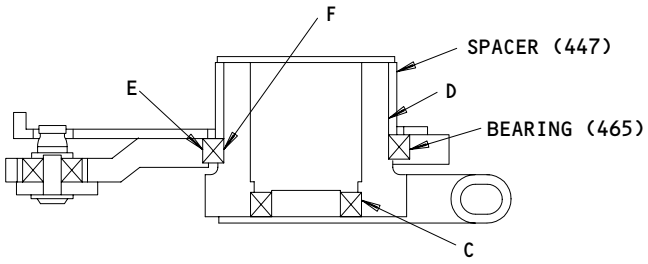
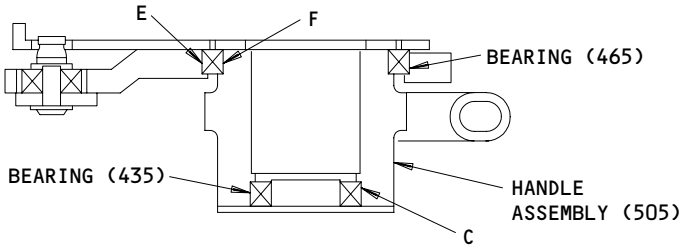




253T5852-2,-4,-6



253T5852-1,-3,-5

Fits and Clearances
Figure 805 (Sheet 1)

A17117

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Ref Letter Fig.805	Mating Item No. IPL Fig. 5,6	Design Dimension				Service Wear Limit		
		Dimension		Assembly Clearance		Dimension		Maximum Clearance
		Min	Max	Min	Max	Min	Max	
A	ID 265 OD 275	1.0625 1.0615	1.0635 1.0625	0.0000	0.0020			
B	ID 275 OD 340	0.6243 0.6240	0.6257 0.6245	-0.0002	0.0017			
C	ID 505 OD 435	1.1875 1.1870	1.1885 1.1875	-0.0000	0.0015			
D	ID 447 OD 505	1.8250 1.8105	1.8300 1.8115	0.0135	0.0195			
E	ID 480 OD 465	2.2500 2.2493	2.2510 2.2500	0.0000	0.0017			
F	ID 465 OD 505	1.8117 1.8105	1.8125 1.8115	0.0002	0.0020			

Fits and Clearances
Figure 805 (Sheet 2)

A17083

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FOR TORQUE VALUES OF STANDARD FASTENERS, REFER TO 20-50-01			
ITEM NO.	NAME	TORQUE	
		POUND-INCHES	POUND-FEET
95 IPL FIG. 1	SHAFT	100-150	
156 IPL FIG. 3	SHAFT	100-150	
50 IPL FIG. 1	NUT	250-300	
250 IPL FIG. 5 & 6	BOLT	22-25	

Torque Table
Figure 806

2101

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SPECIAL TOOLS, FIXTURES, AND EQUIPMENT

NOTE: Equivalent substitutions may be used.

1. A76001-1 -- Fixture, Control Stand Thrust Lever Assy Test

2. A33003 -- Breakout Box, Universal

3. A33003-13, -14, -23 -- Adapter, Control Stand Thrust Lever Assy Cable Set

4. A27097-1 -- Adapter, Reverse Thrust Lever Protractor

5. A27021-30 -- Protractor Assembly

6. B76004-1 -- Adatper, Thrust Control Inner Shaft

7. G76002-15 -- Thrust Reverser Lever Protractor Assembly

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ILLUSTRATED PARTS LIST

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

2. Indentures show parts relationships as follows:

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

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

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

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

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

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

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

6. Parts Interchangeability

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

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VENDORS

K8455 RHP BEARINGS PLC RHP AEROSPACE
OLDENDS LANE
STONEHOUSE GL10 3RM UK

S0352 NIPPON MINIATURE BEARING CO LTD
TOKYO, JAPAN

0LYY8 AOI INC
115 GAME FARM ROAD NORTH
MAPLE PLAIN, MINNESOTA 55359
FORMERLY DLV IND IN GOLDEN VALLEY, MINNESOTA AND V0827B

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

02660 AMPHENOL CORP INDUSTRIAL TECHNOLOGY DIV
358 HALL AVENUE PO BOX 384
WALLINGFORD, CONNECTICUT 06492
FORMERLY BUNKER RAMO CORP, ELTRA CORP AMPHENOL AND
AMPHENOL CORP COMM AND IND DIV

06144 INDUSTRIAL TECTONICS BEARING CORP
18301 SOUTH SANTA FE AVENUE
RANCHO DOMINGUEZ, CALIFORNIA 90221
FORMERLY IN COMPTON, CALIFORNIA

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

0827B SEE AOI INC V0LYY8

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VENDORS

08524 DEUTSCH FASTENER CORP SEE CODE V97928

09455 RBC TRANSPORT DYNAMICS CORP
3131 W SEGERSTROM AVE
SANTA ANA, CALIFORNIA 92704-5872
FORMERLY TRANSPORT DYNAMICS AEROSPACE DIV; FABROID DIV
TRANSPORT DYNAMICS V17571 & LEAR SEIGLER INC TRANSPORT DIV
V98076; FORMERLY BFM TRANSPORT DYNAMICS

10630 ANILLO INDUSTRIES, INCORPORATED
2090 NORTH GLASSELL
ORANGE, CALIFORNIA 92667
FORMERLY WESTERN WASHER DIV OF SENG CO V87487

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

13556 LABINAL COMPONENTS AND SYS CINCH MILITARY AEROSPACE DIV
8821 SCIENCE CENTER DRIVE
MINNEAPOLIS, MINNESOTA 55428-3619
FORMERLY TRW CINCH MFG CO, FORMERLY IN NEW HOPE, MINNESOTA
FORMERLY CINCH CYLINDRICAL DIV OF LABINAL COMP & SYS

15653 FAIRCHILD FASTENERS KAYNAR PRODUCTS DIV
800 S STATE COLLEGE BLVD
FULLERTON, CALIFORNIA 92831-3001
FORMERLY VK6405 MICRODOT AEROSP LTD; FORMERLY KAYNAR TECH
KAYNAR DIV

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

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VENDORS

21335 TORRINGTON CO FAFNIR BEARING DIV
59 FIELD STREET
TORRINGTON, CONNECTICUT 06790-1008
FORMERLY FAFNIR BRG AND TEXTRON INC FAFNIR DIV IN
NEW BRITAIN, CONNECTICUT

21649 OTTO CONTROLS DIV OF OTTO ENGRG INC
2 EAST MAIN STREET
CARPENTERSVILLE, ILLINOIS 60110

21760 SCHATZ MANUFACTURING CO
FAIRVIEW AVENUE PO BOX 1191
POUGHKEEPSIE, NEW YORK 12601
FORMERLY FEDERAL BRG CO AND SCHATZ MFG CO V53268
FORMERLY SCHATZ MFG CO

30163 VALENTEC DAYRON INC
333 MAGUIRE BLVD PO BOX 140394
ORLANDO, FLORIDA 32814-0394

38443 MRC BEARINGS
402 CHANDLER STREET
JAMESTOWN, NEW YORK 14701-3802
FORMERLY MARLIN-ROCKWELL CORP DIV TRW AND TRW INC

40920 MPB MINIATURE PRECISION BEARING DIV
PRECISION PARK PO BOX 547
KEENE, NEW HAMPSHIRE 03431
FORMERLY MPB CORP AND MINIATURE BRG DIV MPB CORP

41118 RMS COMPANY
8600 EVERGREEN BLVD
COON RAPIDS, MINNESOTA 55433-6036

43991 FAG BEARING INCORPORATED
118 HAMILTON AVENUE
STAMFORD, CONNECTICUT 06904
FORMERLY NORMA-HOFFMAN BEARING CORPORATION
FORMERLY NORMA FAG BEARINGS CORPORATION

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

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VENDORS

50632 KAMATICS CORP SUB OF KAMAN CORP
1335 BLUE HILLS ROAD
BLOOMFIELD, CONNECTICUT 06002-1304

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

53551 ALLFAST FASTENING SYSTEMS INC
15200 EAST DON JULIAN ROAD PO BOX 3166
CITY OF INDUSTRY, CALIFORNIA 91745-1001
FORMERLY V0736B
FORMERLY ALLFAST INC V5K545

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

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

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

71087 BOOTS ACFT NUT DIV TOWNSEND CO SEE TEXTRON INC CHERRY
FASTENER TOWNSEND DIV V11815

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

73134 ROLLER BEARING COMPANYOF AMER DBA HEIM BEARINGS DIV
60 ROUND HILL RD
FAIRFIELD, CONNECTICUT 06430-0000
FORMERLY INCOM INTL HEIM DIV; HEIM UNIVERSAL CORP INCOM;
FORMERLY HEIM DIV INCOM INTL; IMO IND HEIM BEARINGS DIV

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

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VENDORS

77896 REXNORD INC BEARING OPERATION
2400 CURTIS STREET
DOWNERS GROVE, ILLINOIS 60515-4005
FORMERLY SHAEFER BEARING DIV REX CHAINBELT
FORMERLY REX CHAINBELT INC BEARING DIV.

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

81376 SMITH ACQUISITION COMPANY
2240 BUENA VISTA
BALDWIN PARK, CALIFORNIA 91706

81640 EATON CORP AEROSPACE AND COMMERCIAL CONTROLS DIV
2250 WHITFIELD AVENUE EAST
SARASOTA, FLORIDA 34243-9703
FORMERLY SINGER CO CONTROLS DIV AND CONTROLS CO OF AMERICA
AND CONTROL SWITCH A CUTLER-HAMMER CO AND EATON CORP
CUTLER-HAMMER GROUP V97198, V81641 IN FOLCROFT, PENNSYLVANIA

83086 NEW HAMPSHIRE BALL BEARING, INC HITECH DIVISION
172 JAFFREY ROAD
PETERBOROUGH, NEW HAMPSHIRE 03458

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

91929 HONEYWELL INC MICRO SWITCH DIV
11 WEST SPRING STREET
FREEPORT, ILLINOIS 61032
FORMERLY MICRO SWITCH A DIV OF HONEYWELL
FORMERLY V74059 AND V40228

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

97393 SHUR-LOK CORPORATION
2541 WHITE ROAD PO BOX 19584
IRVINE, CALIFORNIA 92713
FORMERLY SHUR LOK CORP VB0060
FORMERLY IN SANTA ANA, CALIFORNIA 92714

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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
97928	SEE V17446 HUCK INTL HUCK INTL SEE V17446 HUCK INTL SEE V17446 HUCK INTL

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REFERENCE DESIGNATOR INDEX (SEE SCHEMATIC DIAGRAM)		
REFERENCE DESIGNATOR	PART NUMBER	FIG-ITEM
P1	C0909A12B12PN	1-120A
P1	C0909A12B12PN	3-230
P2	C0909A12B12P9	1-130
P2	C0909A12B12P9	3-218A
P2	C0909A12B12P9	235
P3	BACC45FT14B15P	1-125A
P3	BACC45FT14B15P	3-216
P3	BACC45FT14B15P	225
S1	MS24547-1	55
S1	MS24547-1	5-543
S2	MS24547-1	3-55
S3	C2006	5
S3	C2006	5-542
S4	C2006	3-5
S4	C2006	6-552
S5	MS24547-1	5-543
S5-S10	MS24547-1	3-55
S6	MS24547-1	6-553
S7	MS24547-1	5-543
S9	MS24547-1	543

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
AJF05A109		2	150A	2
		4	135A	2
AN960C10L		2	100	4
		2	115	2
		2	212	4
		2	493	4
		4	80	4
		4	100	2
		4	150	2
		4	205	8
		4	410	2
AN960C4L		2	280	6
		4	315	4
AN960C516L		2	95	4
		2	295	4
		4	75	4
AN960D10L		2	300	2
		4	260	2
AN960D1016		3	160	1
AN960D416L		3	140	4
AN960D6L		2	70	6
		4	45	6
AN960JD1016L		1	45A	1
AN960JD416L		1	15H	4
BACB10AP3		5	475	1
		6	475	1
BACB10AS12		2	55A	2
		3	215	2
		4	35	2
		5	435	1
		6	435	1

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACB10AS29		5	465	1
		6	465	1
BACB10AU29		2	75	2
		4	60	2
BACB10BG1M		2	145	2
		4	130	2
BACB10CF12PP		1	55B	2
		2	55	2
BACB28U5E022		4	385	2
BACB28X3M040		2	120	2
		4	105	2
BACB28Y3C010		2	105	4
		4	85	4
BACB28Y3C042		2	310	2
BACB28Y3C046		2	315	2
BACB28Y3F046		4	300	4
		5	375	1
		6	375	1
BACB28Y6E009		4	440	2
BACB30FM5A8U		5	250A	1
		6	250A	1
BACB30FM6-15		2	290	2
BACB30FM6A15U		4	255	2
BACB30FM6A8		4	145	2
BACB30LR3U3		2	165A	2
BACB30MB6A10SU		4	405B	2
BACB30NM3K4		5	485A	1
		6	485A	1
BACB30NM4K16		6	170	1
BACB30NR4K8		1	10	2
		3	135	2
BACB30NZ6K8		5	360A	1
		6	360A	1

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACB30VT6K8		5	235A	1
		6	235A	1
BACC30BL6		5	245A	1
		6	245A	1
BACC30M6		4	155	2
BACC30X6S		4	420B	2
BACC45FT14B15P		1	125A	1
		3	216	1
		3	225	1
BACC63BN12B12P		1	120A	1
		3	217A	1
		3	230	1
BACC63BN12B12P9		1	130	1
		3	218A	1
		3	235	1
BACN10JC04		2	285	4
		4	325	2
BACN10JC04CD		5	110A	2
		6	110A	2
BACN10JC3		2	217	2
		2	305	2
		2	500B	2
		4	215	6
		4	305	2
BACN10JC4		1	20	2
		3	145	2
BACN10RF10		1	50	1
		3	165	1
BACN10YR04CM		5	50A	1
		6	50A	1
BACN10YR3CD		5	175A	1
		5	495A	1
		6	175A	1
		6	495A	1
BACN10YR3CM		5	370A	1
		6	370A	1
BACR15BA3AD		5	280	3
		5	300	3
		6	280	3
		6	300	3
BACR15BA5AD		5	282	1
		6	540	1
BACR15BB6B		3	85A	6
BACR15CE6KE		2	505	3
		3	100	6
		3	120	6
BACR15DY6M10		2	330	2

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACS12BE02A5		5	405A	2
		6	405A	2
BACS12BE02A6		5	120A	2
BACS12BE02A9		5	410	2
		6	410	2
BACS12BG02AP6		2	400B	2
		2	410B	2
		3	40	4
BACS12BG02AP9		2	405B	2
		3	45A	8
BACS12BG02CP6		2	400A	2
		2	410A	2
BACS12BG02CP9		2	405A	2
BACS12BP06-5		3	30	2
BACS12BP08P5		2	370A	4
BACS12BP3-8		4	10	2
BACS12BP3P8		2	20A	2
		5	330	1
		6	330	1
BACS12ER04K5		5	425A	4
		5	440A	4
		6	425A	4
		6	440A	4
BACS12GX06-4		5	30A	3
		5	350A	3
		6	30A	3
		6	350A	3
BACW10P24C		2	295A	4
BACW10P5C		2	490A	2
		4	210	4
		5	165	1
		5	493	1
		6	165	1
		6	493	2
BAC27TCT0012		1	135	1
		3	250	1
		5	565	1
BAC27TCT0013		1	140	1
		3	255	1
		6	575	1
BAC27TCT0014		1	145	1
		3	260	1
		5	555	1
BAC27TCT0015		1	150	1
		3	265	1
		6	565	1

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BAC27TCT0016		1	155	1
		3	270	1
		5	545	1
BAC27TCT0017		1	160	1
		3	275	1
		6	555	1
BAC27TCT0031		1	165	1
		3	280	1
		5	570	1
BAC27TCT0032		1	170	1
		3	285	1
		6	580	1
BAC27TCT0033		1	175	1
		3	290	1
		5	560	1
BAC27TCT0034		1	180	1
		3	295	1
		6	570	1
BAC27TCT0149		1	185	1
		3	300	1
BAC27TCT0150		1	190	1
BAC27TCT0150		3	305	1
BAC27TCT0156		2	530	1
		3	310	1
		5	550	1
BAC27TCT0157		2	535	1
		3	315	1
		6	560	1
BRH10-3		2	500B	2
BRH10A04		2	285	4
		4	325	2
BRH10A3		2	217	2
		2	305	2
		4	215	6
		4	305	2
BRH10A4		1	20	2
		3	145	2
BRH10C04D		5	110A	2
		6	110A	2
BR9080-10		1	50	1
		3	165	1
B539-2TS		1	55B	2
		2	55	2

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
B539DD		1	55B	2
		2	55	2
B539DDFS101		1	55B	2
		2	55	2
B539DDFS428		1	55B	2
		2	55	2
B539DDNJC		1	55B	2
		2	55	2
B539DDP		1	55B	2
		2	55	2
B539FS101		1	55B	2
		2	55	2
B539SSG27		1	55B	2
		2	55	2
B5538WZZFS428		5	275	1
		6	275	1
CS203AE		2	145	2
		4	130	2
C0909A12-12P9		1	130	1
		3	218A	1
		3	235	1
C0909A12B12PN		1	120A	1
		3	217A	1
C0909A12B12PN		3	230	1
C0909A12B12P9		1	130	1
		3	218A	1
		3	235	1
C2006		2	35	2
		3	5	2
		5	542	2
		6	552	2

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
DBAF5-184		2	150A	2
		4	135A	2
DLV2002		3	60B	2
DLV2004		2	425	1
		3	60	2
D2002		3	60A	2
FBR05A11BA		2	150A	2
		4	135A	2
HL1187DU6		4	420B	2
HL18-5A8U		5	250A	1
		6	250A	1
HL18PB6-15		2	290	2
HL40-5-8		5	250A	1
		6	250A	1
HL40-6-15		4	255	2
HL440UC6-8		4	145	2
HL441UC6-8		4	145	2
HL448DU6-10		4	405B	2
HL48DU6-10		4	405B	2
HL523AZ6-8		5	360A	1
		6	360A	1
HL79-6		4	155	2
HL87DU6		4	420B	2
HST10AG6-8		5	235A	1
HST10AG6-8		6	235A	1
HST79-6		5	245A	1
		6	245A	1
HST79CY6		5	245A	1
		6	245A	1
H10-04BAC		2	285	4
		4	325	2
H10-3BAC		2	217	2
		2	305	2
		4	215	6
		4	305	2

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
H10-4BAC		1	20	2
		3	145	2
H51650-04BAC		5	110A	2
		6	110A	2
H52732-04CM		5	50A	1
		6	50A	1
H52732-3CD		5	175A	1
		5	495A	1
		6	175A	1
		6	495A	1
H52732-3CM		5	370A	1
		6	370A	1
JX45		2	415	3
		2	427	1
		3	50	8
		5	415	3
		6	415	3
KJB60516-327		2	150A	2
		4	135A	2
KJN5-22		2	150A	2
		4	135A	2
KP3AL		2	145	2
		4	130	2
KP3ALE		2	145	2
		4	130	2
KP3ALE6531		2	145	2
		4	130	2
KP3ALFS428		2	145	2
		4	130	2
KP3ALG20		2	145	2
		4	130	2
KP3ALP		2	145	2
		4	130	2
KP3ALSD610		2	145	2
		4	130	2

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
KP3ALTT		2	145	2
		4	130	2
KP3ALT1C1-01		2	145	2
		4	130	2
LLKP16BS1		1	75D	2
		3	175C	1
		3	190C	1
LLKP3AL		2	145	2
		4	130	2
LLMB539		2	55A	2
		3	215	2
		4	35	2
		5	435	1
		6	435	1
LLMB544		5	465	1
		6	465	1
LLMKP29B1		2	75	2
		4	60	2
LLMKP3A		5	475	1
		6	475	1
L804-6K8		5	360A	1
		6	360A	1
L8055A8U		5	250A	1
		6	250A	1
L8056-15		2	290	2
L8056A8		4	145	2
MB539-2TS		2	55A	2
		3	215	2
		4	35	2
		5	435	1
		6	435	1
MB539DD		2	55A	2
		3	215	2
		4	35	2
		5	435	1
		6	435	1
MB539DDFS428		2	55A	2
MB539DDFS428		3	215	2
		4	35	2
		5	435	1
		6	435	1
MB539DDG20		2	55A	2
		3	215	2
		4	35	2
		5	435	1
		6	435	1

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
MB539DDLY196		2	55A	2
		3	215	2
		4	35	2
		5	435	1
		6	435	1
MB539DDNJC		2	55A	2
		3	215	2
		4	35	2
		5	435	1
		6	435	1
MB539TT		2	55A	2
		3	215	2
		4	35	2
		5	435	1
		6	435	1
MB544-2TS		5	465	1
		6	465	1
MB544DD		5	465	1
		6	465	1
MB544DDFS428		5	465	1
		6	465	1
MB544DDG20		5	465	1
		6	465	1
MB544DDLY196		5	465	1
		6	465	1
MB544DDNJC		5	465	1
		6	465	1
MB544DDSD610		5	465	1
		6	465	1
MB544TT		5	465	1
		6	465	1
MCS23E		5	475	1
		6	475	1

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
MKP16BE9273-29		2	75	2
		4	60	2
MKP16BS2E9881		1	75D	2
MKP16BS2E9881		3	175C	1
		3	190C	1
MKP16BS2SD750		1	75D	2
		3	175C	1
		3	190C	1
MKP29B		2	75	2
		4	60	2
MKP29BFS428		2	75	2
		4	60	2
MKP29BLY196		2	75	2
		4	60	2
MKP29BNJC		2	75	2
		4	60	2
MKP29BSD610		2	75	2
		4	60	2
MKP29BTT		2	75	2
		4	60	2
MKP29B1G20		2	75	2
		4	60	2
MKP29B2TS		2	75	2
		4	60	2
MKP3A		5	475	1
		6	475	1
MKP3AFS428		5	475	1
		6	475	1
MKP3AG20		5	475	1
		6	475	1
MKP3ALY196		5	475	1
		6	475	1
MKP3ANJC		5	475	1
		6	475	1

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
MKP3ASD610		5	475	1
		6	475	1
MKP3ATT		5	475	1
		6	475	1
MKP3A2TS		5	475	1
		6	475	1
MKP3E6531		5	475	1
		6	475	1
MS16625-4086		5	5	1
		6	5	1
MS20392-1C15		2	245	2
		4	240	2
MS20392-2C17		1	102	2
		3	65	2
MS20392-2C19		5	190	1
		6	190	1
MS20427M2		2	380	4
MS20427M4-19		2	40	8
MS20427M4-5		4	350A	2
MS20427M5		4	467	6
MS206155M		4	467B	6
MS206155MP		5	455	3
		6	455	3
MS212009C0615P		5	270	3
		6	270	3
MS21209C0210P		5	520	4
		6	520	4
MS21209C0220P		5	310	2
		6	310	2
MS21209C0410		5	290	1
		6	290	1
MS21209C0415		4	460	16
MS21209C0415P		5	515	9
		6	515	9
MS21209C0610		2	185	6
		4	180	6
		4	465	8
MS21209C0610P		5	510	3
		6	510	3

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
MS21209C0810		2	450	5
MS21209C0815		5	262	1
		6	262	1
MS21209C0820P		5	535	2
		6	535	2
MS21209F1-10		2	190	2
		4	175	2
MS21209F1-15		2	130	2
		2	192	2
		4	115	2
		4	177	2
MS21209F1-15P		5	530	4
		6	530	4
MS24547-1		2	420	3
		2	428	1
		3	55	8
		5	543	4
		6	553	4
MS24586-698		2	80	4
MS24586-698		4	65	4
MS24586C60		2	270	2
MS24586C61		2	160A	2
		4	165	2
MS24586C62		2	160	2
MS24665-151		1	103	2
		2	255	2
		3	70	2
		4	235	2
		5	130	1
		5	180	1
		6	130	1
		6	180	1
MS28775-114		5	15	1
		6	15	1
MS35214-4		2	410	2
MS35214-5		2	400	2
MS35214-8		2	405	2
MS35649-244		5	55B	1
		6	55B	1
MT339E		2	55A	2
		3	215	2
		4	35	2
		5	435	1
		6	435	1

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
MT344E		5	465	1
		6	465	1
NAS1056C6-009		2	495	2
NAS1056C6-011		4	200	4
		5	160	1
		6	160	1
NAS1057T0-010		4	320	2
		5	390	1
		6	390	1
NAS1149CN416R		5	45A	1
		5	65A	1
		5	105A	2
		5	395A	2
		6	45A	1
		6	65A	1
		6	105A	2
		6	395A	2
NAS1149CN949R		5	255B	1
		6	255B	1
NAS1149C0332R		5	240A	1
NAS1149C0332R		5	365B	1
		6	240A	1
		6	365A	1
NAS1149DN832J		5	230A	1
		6	230A	2
NAS1149D0332J		5	150A	1
		5	170B	1
		5	215A	1
		5	247A	1
		5	490A	1
		6	150A	1
		6	170B	1
		6	215A	1
		6	247A	1
		6	490A	2

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
NAS1801-04-6		5	40C	1
		5	100C	2
		6	40C	1
		6	100C	2
NAS43DD1-12FC		5	45B	1
		5	65B	1
		5	105B	1
		5	395B	1
		6	45B	1
		6	65B	1
		6	105B	1
		6	395B	1
NAS43DD3-24		3	75A	2
NAS43DD3-24FC		5	185A	1
		6	185A	1
NAS514P1032-18P		5	205A	1
		6	205A	1
NAS514P1032-24P		5	200A	1
		6	200A	1
NAS514P440-5		4	20A	16
NAS514P440-6		4	310	2
NAS514P440-8		2	275	2
NAS514P632-4		3	15	6
NAS514P832-4		2	265	6
NAS514P832-7P		5	220A	1
		6	220A	1
NAS601-4		2	65	6
		4	40	6
NAS602-5P		2	395	2
NAS602-7P		5	225	1
NAS602-7P		6	225	2
NAS603-7P		5	210	1
		6	210	1

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
NAS607-3-4P		5	525	2
		6	525	2
NAS620-416		2	495B	2
NAS620C5L		2	250	4
		4	245	4
NAS623-3-3		5	145	1
		6	145	1
NAS623-3-6		5	155B	1
		6	155B	1
NAS6603-1		2	90	4
		4	70	4
NAS6603-3		2	200	2
NAS6603-4		4	190	2
NAS6603-6		2	110	2
		2	485B	2
		4	95	2
NAS6603-7		4	195	4
NAS8200A5		5	40B	1
		5	100B	2
		6	40B	1
		6	100B	2
NAS8200A8		5	385A	1
		6	385A	1
NB539DDSD610		2	55A	2
		3	215	2
		4	35	2
		5	435	1
		6	435	1
NHF05-203A		2	150A	2
		4	135A	2
NS202101-02		2	217	2
		2	305	2
		4	215	6
		4	305	2
NS202101-048		1	20	2
		3	145	2
NS202101-40		2	285	4
		4	325	2
NS202486-40		5	110A	2
		6	110A	2

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
PLH504CM		5	50A	1
PLH504CM		6	50A	1
PLH53CD		5	175A	1
		5	495A	1
		6	175A	1
		6	495A	1
PLH53CM		5	370A	1
		6	370A	1
P8-4000003		5	542A	2
		6	552A	2
RMLH9075-3W		2	217	2
		2	305	2
		4	215	6
		4	305	2
RMLH9075-4W		1	20	2
		3	145	2
RMLH9075-40W		2	285	4
		4	325	2
RO71212B12P		1	120A	1
		3	217A	1
		3	230	1
SL2822-10		1	50	1
		3	165	1
T339E		1	55B	2
		2	55	2
T6C440CD		5	110A	2
		6	110A	2
T6C440JCD		5	110A	2
		6	110A	2
T6S1032J		2	217	2
		2	305	2
		4	215	6
		4	305	2
T6S428J		1	20	2
		3	145	2
T6S440J		2	285	4
		4	325	2
VN303A02		2	217	2
		2	305	2
		4	215	6
		4	305	2
VN303A048		1	20	2
		3	145	2
VN303A40		2	285	4
		4	325	2
WC130-6-8		4	145	2

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
WC22-6-15		2	290	2
WC36-6-15		4	255	2
YTS754		2	150A	2
		4	135A	2
Y010		1	75D	2
		3	175C	1
		3	190C	1
Y164		1	75D	2
		3	175C	1
		3	190C	1
015T0094-15		1	1T	RF
015T0156-3		1	105K	1
		2	1J	RF
015T0156-4		1	110L	1
		2	5J	RF
015T0630-11		3	240E	1
		4	1F	RF
015T0630-12		3	245E	1
		4	5F	RF
015T0630-13		4	355D	1
015T0630-14		4	360D	1
015T0630-15		3	240F	1
		4	1G	RF
015T0630-16		3	245F	1
		4	5G	RF
015T0630-17		1	1W	RF
015T0630-21		1	2	RF
		3	1L	RF
015T0630-3		2	325B	1
015T0630-5		1	105J	1
		2	1H	RF
015T0630-6		1	110K	1
		2	5H	RF
10-60516-327		2	150A	2
		4	135A	2
102LH9075-40W		5	110A	2
		6	110A	2
10633		1	75D	2
		3	175C	1
10633		3	190C	1
251T0100-140		1	25A	2
		3	150	2
253T4006-1		3	200	1
253T4006-11		3	205	2
253T4006-12		4	55	1
		6	447	1
253T4006-8		1	35	2

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
253T4006-9		1	40	1
253T5800-13		1	1D	RF
253T5800-15		1	1E	RF
253T5800-17		1	1F	RF
		3	1	RF
253T5800-19		1	1G	RF
		3	1A	RF
253T5800-23		1	1J	RF
		3	1B	RF
253T5800-25		1	1K	RF
		3	1C	RF
253T5800-27		1	1L	RF
		3	1D	RF
253T5800-29		1	1M	RF
		3	1E	RF
253T5800-31		1	1N	RF
		3	1F	RF
253T5800-33		1	1P	RF
		3	1G	RF
253T5800-35		1	1Q	RF
		3	1H	RF
253T5800-37		1	1R	RF
		3	1J	RF
253T5800-39		1	1S	RF
		3	1K	RF
253T5800-6		1	115	1
		3	220	1
253T5800-9		1	1B	RF
253T5810-11		1	105F	1
		2	1E	RF
253T5810-12		1	110G	1
		2	5E	RF
253T5810-13		1	105G	1
		2	1F	RF
253T5810-14		1	110H	1
		2	5F	RF
253T5810-15		1	105H	1
		2	1G	RF
253T5810-16		1	110J	1
		2	5G	RF
253T5810-7		1	105D	1
		2	1C	RF
253T5810-8		1	110D	1
		2	5C	RF
253T5811-1		2	30	2
		3	10	2

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
253T5812-1		2	45	2
253T5812-2		2	50	2
253T5812-3		4	25	2
		5	430	1
		6	430	1
253T5812-4		4	30	2
		5	445	1
		6	445	1
253T5813-1		1	90	1
253T5814-10		2	470	1
253T5814-13		2	437	1
253T5814-14		2	447	1
253T5814-15		2	462	1
253T5814-16		2	472	1
253T5814-17		2	437B	1
253T5814-18		2	447B	1
253T5814-19		2	464	1
253T5814-20		2	474	1
253T5814-23		2	437C	1
253T5814-24		2	447C	1
253T5814-25		2	466	1
253T5814-26		2	476	1
253T5814-8		2	447A	1
253T5814-9		2	460	1
253T5815-1		2	235	2
253T5816-1		1	95	1
		3	156	1
253T5817-1		2	390	1
253T5817-10		2	385A	1
253T5817-2		2	390A	1
253T5817-3		2	365	1
253T5817-4		2	365A	1
253T5817-7		2	375	2
253T5817-9		2	385	1
253T5819-2		2	195	2

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
253T5819-3		2	175A	2
253T5820-1		1	100	1
253T5821-2		1	30	1
253T5822-1		4	220	2
253T5823-1		2	320	1
253T5823-2		2	320A	1
253T5824-1		2	325	1
253T5824-2		2	325A	1
253T5825-1		2	350	1
253T5825-2		2	355	1
253T5826-1		2	345	2
253T5827-1		2	340	2
		4	430A	2
253T5828-10		2	260A	1
253T5829-1		1	60	1
		3	185	1
253T5829-2		1	80	1
		3	195	1
253T5830-1		1	65	1
		3	170	1
253T5830-2		1	85	1
		3	180	1
253T5831-1		2	135	2
		4	120	2
253T5832-1		2	85	4
		4	90	4
253T5833-1		2	125	2
		4	110	2
253T5833-2		2	155	2
		4	140	2
253T5834-1		2	225	2
		4	225	2
253T5834-2		2	225A	2

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
253T5835-1		2	60	2
		4	50	2
253T5836-1		2	429	1
		3	53	2
		5	68	3
		6	112	3
253T5837-1		2	510	1
253T5837-2		2	515	1
253T5838-1		2	480	1
253T5838-2		2	480A	1
253T5839-1		2	520	1
		3	90	2
253T5839-2		2	525	1
253T5840-1		2	318	1
253T5840-2		2	319	1
253T5840-3		2	318A	1
253T5840-4		2	319A	1
253T5840-5		3	237	1
253T5840-6		3	238	1
253T5840-7		3	237A	1
253T5840-8		3	238A	1
253T5841-1		2	317	2
		3	236	2
253T5842-1		3	80	2
253T5842-3		3	95	2
253T5842-4		3	115	2
253T5844-1		3	105	2
253T5844-2		3	125	2
253T5845-1		3	110	2
		3	130	2
253T5852-1		3	243	1
		5	1	RF
253T5852-2		3	248	1
		6	1	RF

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
253T5852-3		3	243A	1
		5	1A	RF
253T5852-4		3	248A	1
		6	1A	RF
253T5852-5		3	243B	1
		5	1B	RF
253T5852-6		3	248B	1
		6	1B	RF
253T5852-8		6	551	1
253T5853-1		5	35	1
253T5853-2		6	35	1
253T5854-1		5	340	1
253T5854-2		6	340	1
253T5855-1		5	315	1
253T5855-2		6	315	1
253T5856-2		5	115A	1
		6	115A	1
253T5857-1		5	450	1
		6	450	1
253T5858-1		5	480	1
		6	480	1
253T5859-5		5	260A	1
253T5859-6		6	260A	1
253T5860-1		5	305	1
253T5860-2		6	305A	1
253T5861-1		5	265	1
253T5861-2		6	265	1
253T5861-3		5	267	1
253T5861-4		6	267	1
253T5862-1		5	505	1
253T5862-2		6	505	1
253T5862-3		5	540	1
253T5862-4		6	550	1
253T5863-2		5	75A	1
		6	75A	1
253T5864-1		5	90	1
		6	90	1
253T5866-1		5	325	1
		6	325	1
253T5867-1		5	70	1
		6	70	1
253T5868-1		5	345	1
253T5868-2		6	345	1
253T5868-3		5	345A	1
253T5868-4		6	345A	1
253T5868-5		5	345B	1
253T5868-6		6	345B	1

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
253T5869-1		6	140A	1
253T5869-2		6	140B	1
253U5810-2		5	320A	1
		6	320A	1
253U5813-1		5	272	1
		6	545	1
253U5828-2		5	85	1
		6	85	1
253U5838-1		5	285	1
		6	285	1
253U5838-2		5	295	1
		6	295	1
254N1131-10		3	245B	1
		4	5C	RF
254N1131-11		3	240C	1
254N1131-11		4	1D	RF
254N1131-12		3	245C	1
		4	5D	RF
254N1131-17		3	240D	1
		4	1E	RF
254N1131-18		3	245D	1
		4	5E	RF
254N1131-7		3	240A	1
		4	1B	RF
254N1131-8		3	245A	1
		4	5B	RF
254N1131-9		3	240B	1
		4	1C	RF
254N1132-1		4	450	1
254N1132-14		4	455A	1
254N1132-15		4	470A	1
254N1132-16		4	475A	1
254N1132-17		4	450B	1
254N1132-18		4	455B	1
254N1132-19		4	470B	1
254N1132-2		4	455	1
254N1132-20		4	475B	1
254N1132-5		4	470	1
254N1132-6		4	475	1
254N1134-5		4	355A	1
254N1134-6		4	360A	1
254N1136-1		4	435	2
254N1136-2		4	445	2
254N1136-4		4	435A	2

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
254N1136-5		4	445A	2
254N1137-1		4	430	2
254N1138-1		3	20	1
254N1138-2		3	25	1
254N1138-7		5	355	1
254N1138-8		6	355	1
254N1140-1		3	35	2
254N1141-1		4	222	2
		5	500	1
		6	500	1
254N1144-1		4	370	2
254N1144-11		4	415	4
254N1144-2		4	265	2
254N1144-3		4	270	2
254N1144-5		4	275	2
254N1144-6		4	280	2
254N1144-7		4	285	2
254N1144-8		4	290	2
254N1144-9		4	295	2
254N1153-1		3	157	1
254N1153-2		3	157A	1
254N1171-1		4	365	2
254N1172-1		3	155	1
254N1173-1		3	210	1
254N1174-10		4	400A	1
254N1174-13		4	375B	1
254N1174-14		4	380B	1
254N1174-3		4	395	1
254N1174-4		4	400	1
254N1174-7		4	375A	1
254N1174-8		4	380A	1
254N1174-9		4	395A	1
254N1175-1		4	340	1
254N1175-2		4	345	1
254N1175-3		5	380	1

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
254N1175-4		6	380	1
254N1175-5		5	380A	1
254N1175-6		6	380A	1
254N1176-1		4	170	2
254N1176-2		4	185	2
254N1177-2		4	160A	2
		4	427	2
254N1179-1		4	330	1
254N1179-2		4	335	1
254N1179-3		4	330A	1
		5	400	1
254N1179-4		4	335A	1
		6	400	1
254N1180-1		4	230	2
254N1181-2		4	390A	2
254N1181-4		4	390B	2
254N1205-1		4	110B	2
254N1205-2		4	140A	2
254N1210-1		4	355B	1
254N1210-2		4	360B	1
254N1210-5		4	355C	1
254N1210-6		4	360C	1
254N1212-1		4	225B	2
254N1703-1		4	240A	2
		5	135	1
		6	135	1
254N1721-1		4	469	2
254N1731-1		5	460	1
		6	460	1
254N1739-1		5	195	1
		6	195	1

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
254N5869-1		5	140A	1
256T5852-7		5	541	1
48-63N12B12P		1	120A	1
		3	217A	1
		3	230	1
48-63N12B12P9		1	130	1
		3	218A	1
		3	235	1
60B00179-100		1	75D	2
		3	175C	1
		3	190C	1
62550-6-15		2	290	2
65C14183-46		2	10	2
		4	15	2
		5	335	1
		6	335	1
66-25941-1		5	80	2
		6	80	2
66014-6		4	155	2
67067-5A8U		5	250A	1
		6	250A	1
67067-6A15U		4	255	2
67067-6A8		4	145	2
69-35353-3		5	10	1
		6	10	1
69-38919-23		5	470A	1
69-38919-52		6	470A	1
69-73206-1		5	95	1
		6	95	1
69-73369-1		5	60	1
		6	60	1
69B14373-3		2	140	2
		4	125	2
69B81324-1		2	335	2
69B81663-2		2	360	2
69B81942-2		2	240	2
		4	250	2

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
69B82645-1		2	230	2
69B84020-1		2	170A	2
82631-1018		1	50	1
		3	165	1
90792		2	150A	2
		4	135A	2
96-02		2	217	2
		2	305	2
		4	215	6
		4	305	2
96-048		1	20	2
		3	145	2
96-40		2	285	4
		4	325	2

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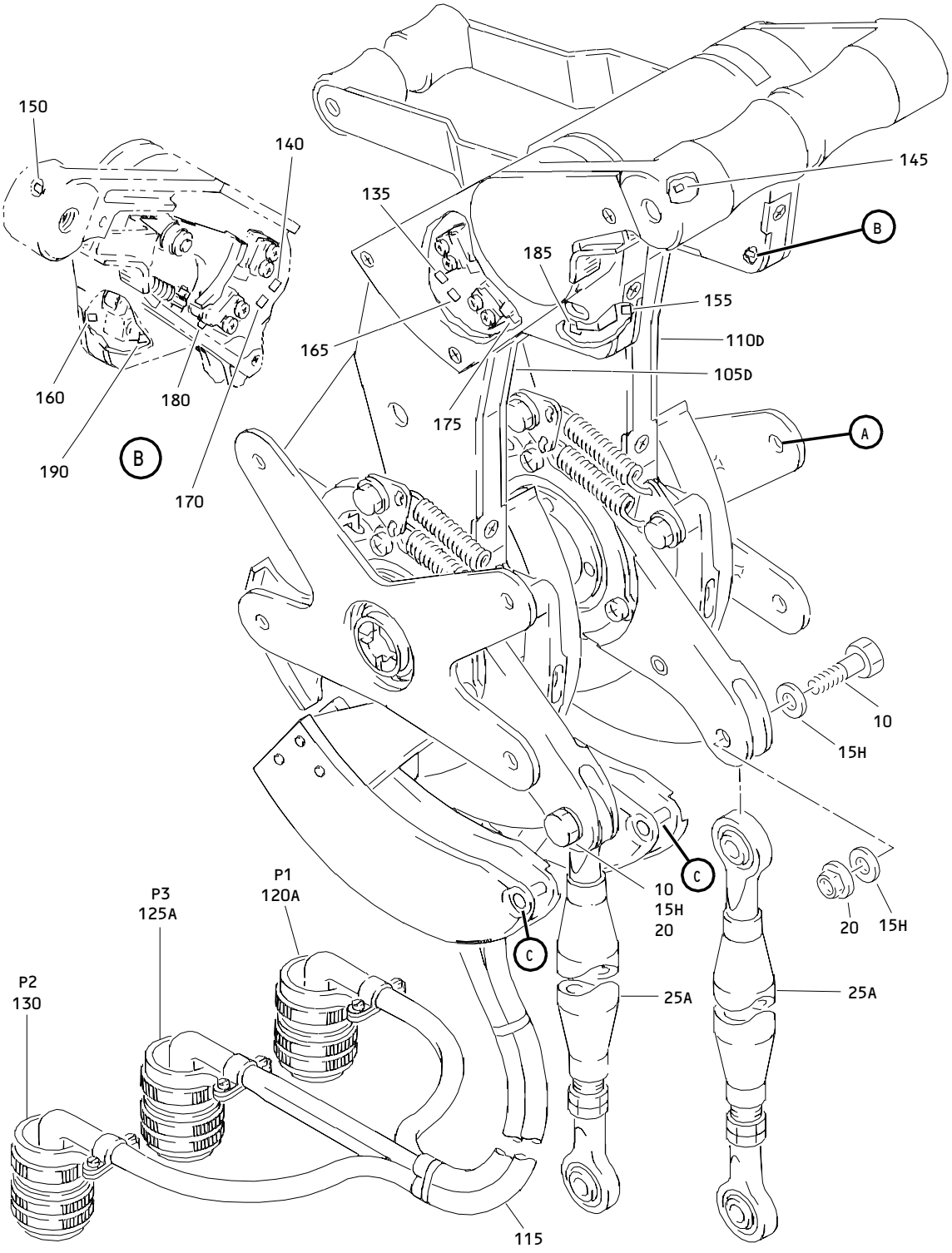

Control Stand Thrust Lever Assembly
Figure 1 (Sheet 1)

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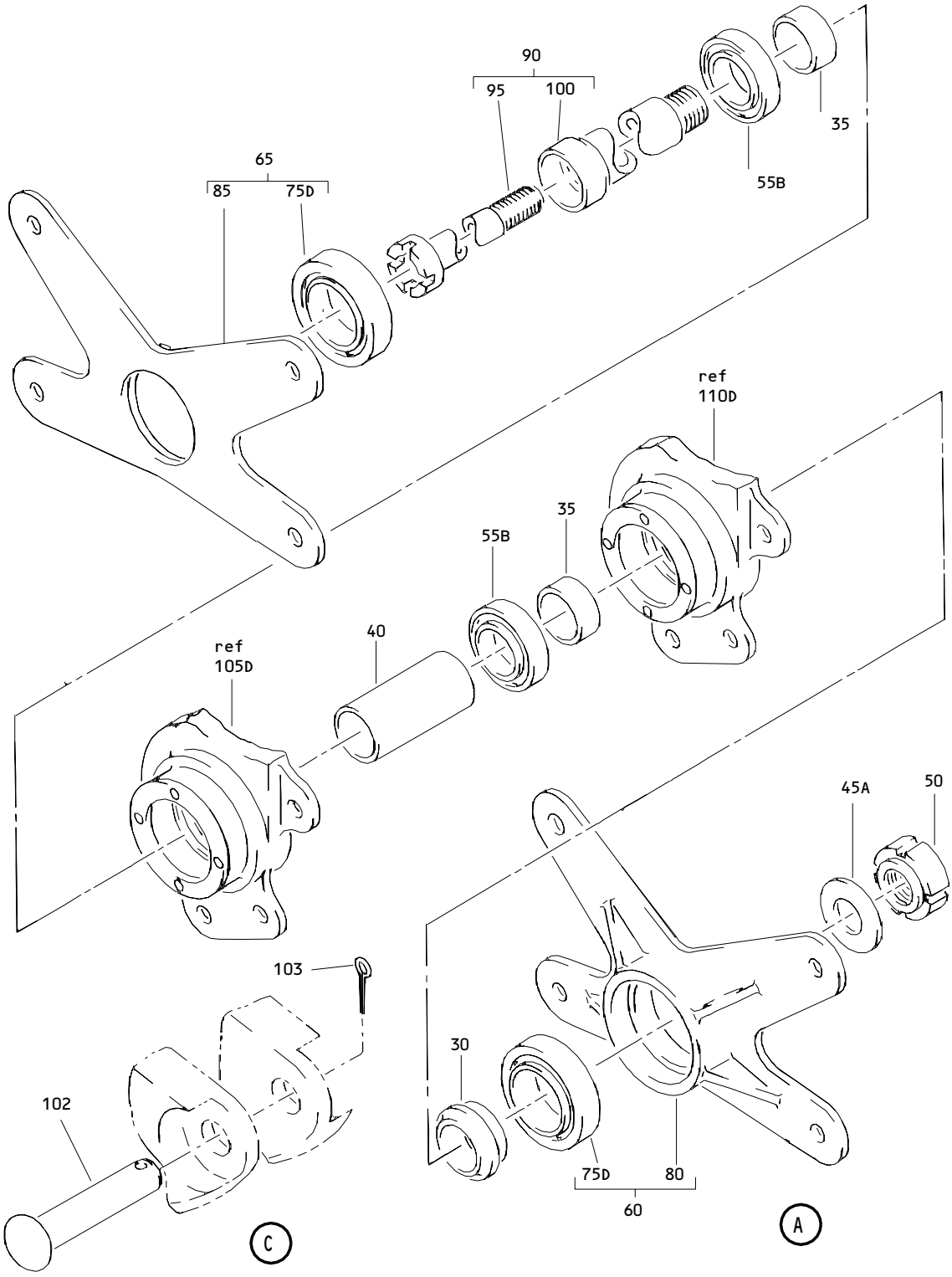

Control Stand Thrust Lever Assembly
Figure 1 (Sheet 2)

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-1B	253T5800-9		LEVER ASSY-CONT STAND THRUST (PRE SB 767-76-0008) (PRE SB 767-76-0031)	B	RF
-1D	253T5800-13		LEVER ASSY-CONT STAND THRUST (PRE SB 767-76-0008) (PRE SB 767-76-0031)	D	RF
-1E	253T5800-15		LEVER ASSY-CONT STAND THRUST (PRE SB 767-76-0031)	C	RF
-1F	253T5800-17		LEVER ASSY-CONT STAND THRUST (PRE SB 767-76-0017) (FOR DETAILS SEE FIG. 3)	E	RF
-1G	253T5800-19		LEVER ASSY-CONT STAND THRUST (PRE SB 767-76-0008) (PRE SB 767-76-0031)	F	RF
-1H	253T5800-21		LEVER ASSY-CONT STAND THRUST (PRE SB 767-76-0017) (PRE SB 767-76-0031) (FOR DETAILS SEE FIG. 3)	G	RF
-1J	253T5800-23		LEVER ASSY-CONT STAND THRUST (POST SB 767-76-0017) (PRE SB 767-76-0031) (FOR DETAILS SEE FIG. 3)	H	RF
-1K	253T5800-25		LEVER ASSY-CONT STAND THRUST (POST SB 767-76-0017) (PRE SB 767-76-0031) (FOR DETAILS SEE FIG. 3)	J	RF
-1L	253T5800-27		LEVER ASSY-CONT STAND THRUST (PRE SB 767-76-0031) (FOR DETAILS SEE FIG. 3)	K	RF
-1M	253T5800-29		LEVER ASSY-CONT STAND THRUST (POST SB 767-76-0031) (FOR DETAILS SEE FIG. 3)	L	RF

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-1N	253T5800-31		LEVER ASSY-CONT STAND THRUST (POST SB 767-76-0031) (FOR DETAILS SEE FIG. 3)	M	RF
-1P	253T5800-33		LEVER ASSY-CONT STAND THRUST (POST SB 767-76-0031) (FOR DETAILS SEE FIG. 3)	N	RF
-1Q	253T5800-35		LEVER ASSY-CONT STAND THRUST (FOR DETAILS SEE FIG. 3)	P	RF
-1R	253T5800-37		LEVER ASSY-CONT STAND THRUST (FOR DETAILS SEE FIG. 3)	Q	RF
-1S	253T5800-39		LEVER ASSY-CONT STAND THRUST (FOR DETAILS SEE FIG. 3)	R	RF
-1T	015T0094-15		LEVER ASSY-THRUST (REWORK) (PRE SB 767-76-0008)	S	RF
-1U	015T0094-16		LEVER ASSY-THRUST (REWORK) (PRE SB 767-76-0008)	T	RF
-1V	015T0156-2		LEVER ASSY-THRUST (REWORK) (POST SB 767-76-0008)	U	RF
-1W	015T0630-17		LEVER ASSY-THRUST (REWORK) (POST SB 767-76-0031)	V	RF
-1X	015T0630-18		LEVER ASSY-THRUST (REWORK) (POST SB 767-76-0031)	W	RF
-1Y	015T0630-19		LEVER ASSY-THRUST (REWORK) (POST SB 767-76-0031)	X	RF
-1Z	015T0630-20		LEVER ASSY-THRUST (REWORK) (POST SB 767-76-0031)	Y	RF
-2	015T0630-21		LEVER ASSY-THRUST (REWORK) (POST SB 767-76-0031) (FOR DETAILS SEE FIG. 3)	Z	RF
10	BACB30NR4K8		.BOLT	B-D,F,V-Y	2
15G	AN960PD1016L		DELETED		

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
15H	AN960JD416L		.WASHER	B-D,F ,V-Y	4
20	BRH10A4		.NUT- (V52828) (SPEC BACN10JC4) (OPT T6S428J (V11815)) (OPT 96-048 (V80539)) (OPT VN303A048 (V92215)) (OPT RMLH9075-4W (V72962)) (OPT NS202101-048 (V80539)) (OPT H10-4BAC (V15653))	B-D,F ,V-Y	2
25A	251T0100-140		.ROD ASSY- (REF CCM 27-00-11)	B-D,F ,V-Y	2
30	253T5821-2		.SPACER	B-D,F ,V-Y	1
35	253T4006-8		.SPACER	B-D,F ,V-Y	2
40	253T4006-9		.SPACER	B-D,F ,V-Y	1
45	AN960D1016		DELETED		
45A	AN960JD1016L		.WASHER	B-D,F ,V-Y	1
50	SL2822-10		.NUT- (V97393) (SPEC BACN10RF10) (OPT 82631-1018 (V56878)) (OPT BR9080-10 (V72962))	B-D,F ,V-Y	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
55B	B539DDNJC		.BEARING- (V06144) (SPEC BACB10CF12PP) (OPT B539DDFS101 (V06144)) (OPT T339E (VK8455)) (OPT B539SSG27 (V30163)) (OPT B539DDFS428 (V21335)) (OPT B539DD (V38443)) (OPT B539-2TS (V43991)) (OPT B539FS101 (V06144)) (OPT B539DDP (V21760))	B-D,F ,V-Y	2
60	253T5829-1		.SUPPORT ASSY	B-D,F ,V-Y	1
65	253T5830-1		.SUPPORT ASSY	B-D,F ,V-Y	1
75A	MKP16BS2E9881		DELETED		
75B	LLKP16BS1		DELETED		
75C	MKP16BS2SD750		DELETED		
75D	Y010		..BEARING- (V40920) (SPEC 60B00179-100) (OPT 10633 (V06144)) (OPT MKP16BS2E9881 (V21335)) (OPT LLKP16BS1 (V38443)) (OPT MKP16BS2SD750 (V83086)) (OPT Y164 (V40920))	B-D,F ,V-Y	1
80	253T5829-2		..SUPPORT- (USED ON ITEM 60)	B-D,F ,V-Y	1
85	253T5830-2		..SUPPORT- (USED ON ITEM 65)	B-D,F ,V-Y	1
90	253T5813-1		.SHAFT ASSY	B-D,F ,V-Y	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-95	253T5816-1		..SHAFT	B-D,F,V-Y	1
100	253T5820-1		..SHAFT	B-D,F,V-Y	1
102	MS20392-2C17		.PIN-DRILLED SHANK	B-D,F,V-Y	2
103	MS24665-151		.PIN-COTTER	B-D,F,V-Y	2
105D	253T5810-7		.LEVER ASSY- (FOR DETAILS SEE FIG. 2) (PRE SB 767-76-0031) (PRE SB 767-76-0008)	B	1
-105F	253T5810-11		.LEVER ASSY- (FOR DETAILS SEE FIG. 2) (PRE SB 767-76-0031) (PRE SB 767-76-0008)	D	1
-105G	253T5810-13		.LEVER ASSY- (FOR DETAILS SEE FIG. 2) (PRE SB 767-76-0031) (PRE SB 767-76-0008)	C	1
-105H	253T5810-15		.LEVER ASSY- (FOR DETAILS SEE FIG. 2) (PRE SB 767-76-0031) (POST SB 767-76-0008)	F	1
-105J	015T0630-5		.LEVER ASSY- (REWORK) (POST SB 767-76-0031) (FOR DETAILS SEE FIG. 2)	V-Y	1
-105K	015T0156-3		.LEVER ASSY- (REWORK) (POST SB 767-76-0008) (FOR DETAILS SEE FIG. 2)	D,U	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
110D	253T5810-8		.LEVER ASSY- (PRE SB 767-76-0031) (PRE SB 767-76-0008) (FOR DETAILS SEE FIG. 2)	B	1
-110G	253T5810-12		.LEVER ASSY- (PRE SB 767-76-0031) (PRE SB 767-76-0008) (FOR DETAILS SEE FIG. 2)	D	1
-110H	253T5810-14		.LEVER ASSY- (PRE SB 767-76-0031) (PRE SB 767-76-0008) (FOR DETAILS SEE FIG. 2)	C	1
-110J	253T5810-16		.LEVER ASSY- (PRE SB 767-76-0031) (POST SB 767-76-0008) (FOR DETAILS SEE FIG. 2)	F	1
-110K	015T0630-6		.LEVER ASSY- (REWORK) (POST SB 767-76-0031) (FOR DETAILS SEE FIG. 2)	V-Y	1
-110L	015T0156-4		.LEVER ASSY- (REWORK) (POST SB 767-76-0008) (FOR DETAILS SEE FIG. 2)	D,U	1
115	253T5800-6		.WIRE BUNDLE ASSY	B-D,F,V-Y	1
120A	C0909A12B12PN		..CONNECTOR- (V13556) (SPEC BACC63BN12B12P) (OPT 48-63N12B12P (V02660)) (OPT R071212B12P (V41118)) (P1)	B-D,F,V-Y	1

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	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	125A	BACC45FT14B15P		..CONNECTOR- (P3)	B-D,F ,V-Y	1
	130	C0909A12B12P9		..CONNECTOR- (V13556) (SPEC BACC63BN12B12P9) (OPT C0909A12-12P9 (V13556)) (OPT 48-63N12B12P9 (V02660)) (P2)	B-D,F ,V-Y	1
	135	BAC27TCT0012		.MARKER-S1	B-D,F ,V-Y	1
	140	BAC27TCT0013		.MARKER-S2	B-D,F ,V-Y	1
	145	BAC27TCT0014		.MARKER-S3	B-D,F ,V-Y	1
	150	BAC27TCT0015		.MARKER-S4	B-D,F ,V-Y	1
	155	BAC27TCT0016		.MARKER-S5	B-D,F ,V-Y	1
	160	BAC27TCT0017		.MARKER-S6	B-D,F ,V-Y	1
	165	BAC27TCT0031		.MARKER-S7	B-D,F ,V-Y	1
	170	BAC27TCT0032		.MARKER-S8	B-D,F ,V-Y	1
	175	BAC27TCT0033		.MARKER-S9	B-D,F ,V-Y	1
	180	BAC27TCT0034		.MARKER-S10	B-D,F ,V-Y	1
	185	BAC27TCT0149		.DECAL-P4	B-D,F ,V-Y	1
	190	BAC27TCT0150		.DECAL-P5	B-D,F ,V-Y	1
R						

- Item Not Illustrated

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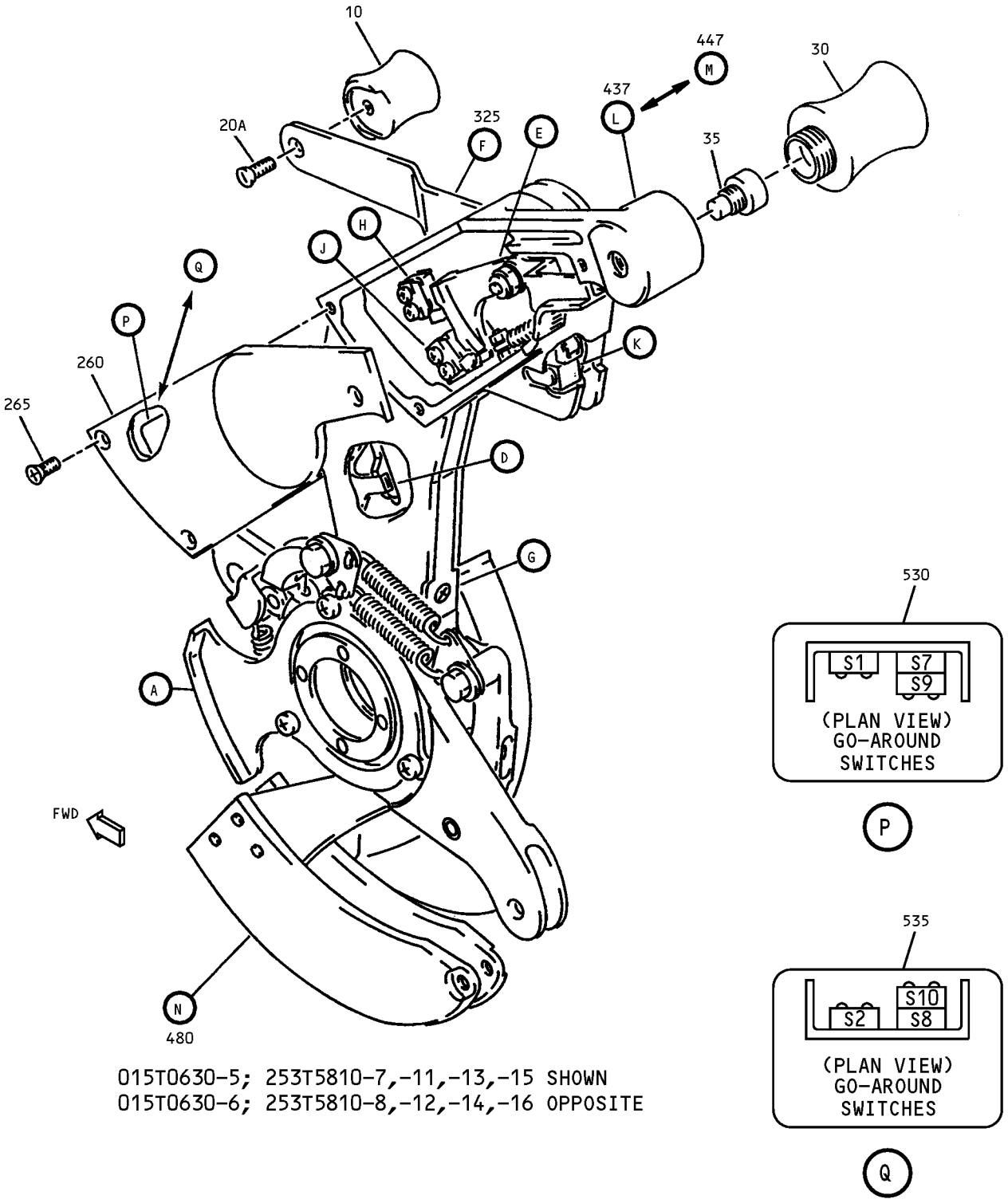

015T0630-5; 253T5810-7,-11,-13,-15 SHOWN
015T0630-6; 253T5810-8,-12,-14,-16 OPPOSITE

Control Stand Thrust Lever Assembly
Figure 2 (Sheet 1)

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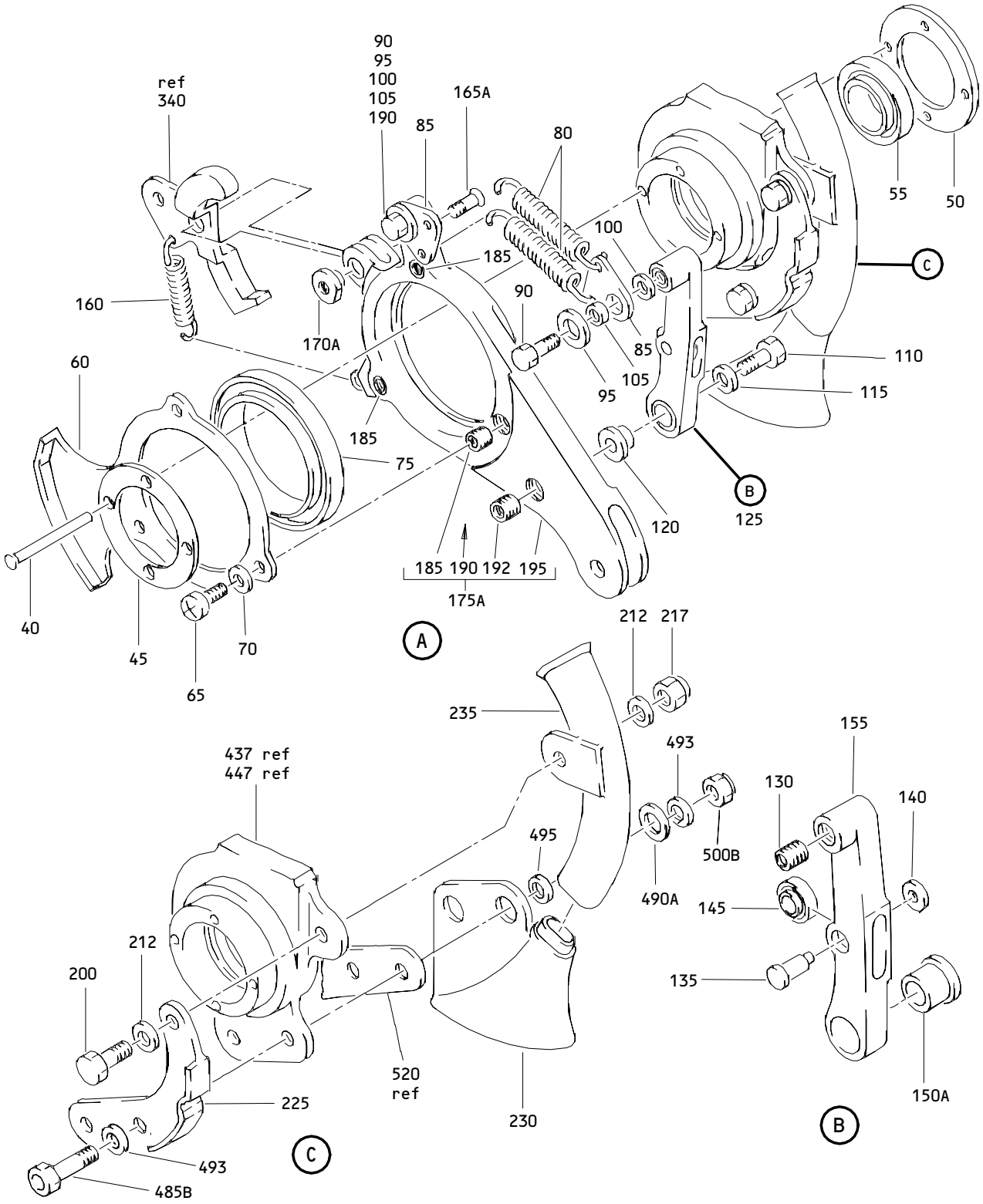

Control Stand Thrust Lever Assembly
Figure 2 (Sheet 2)

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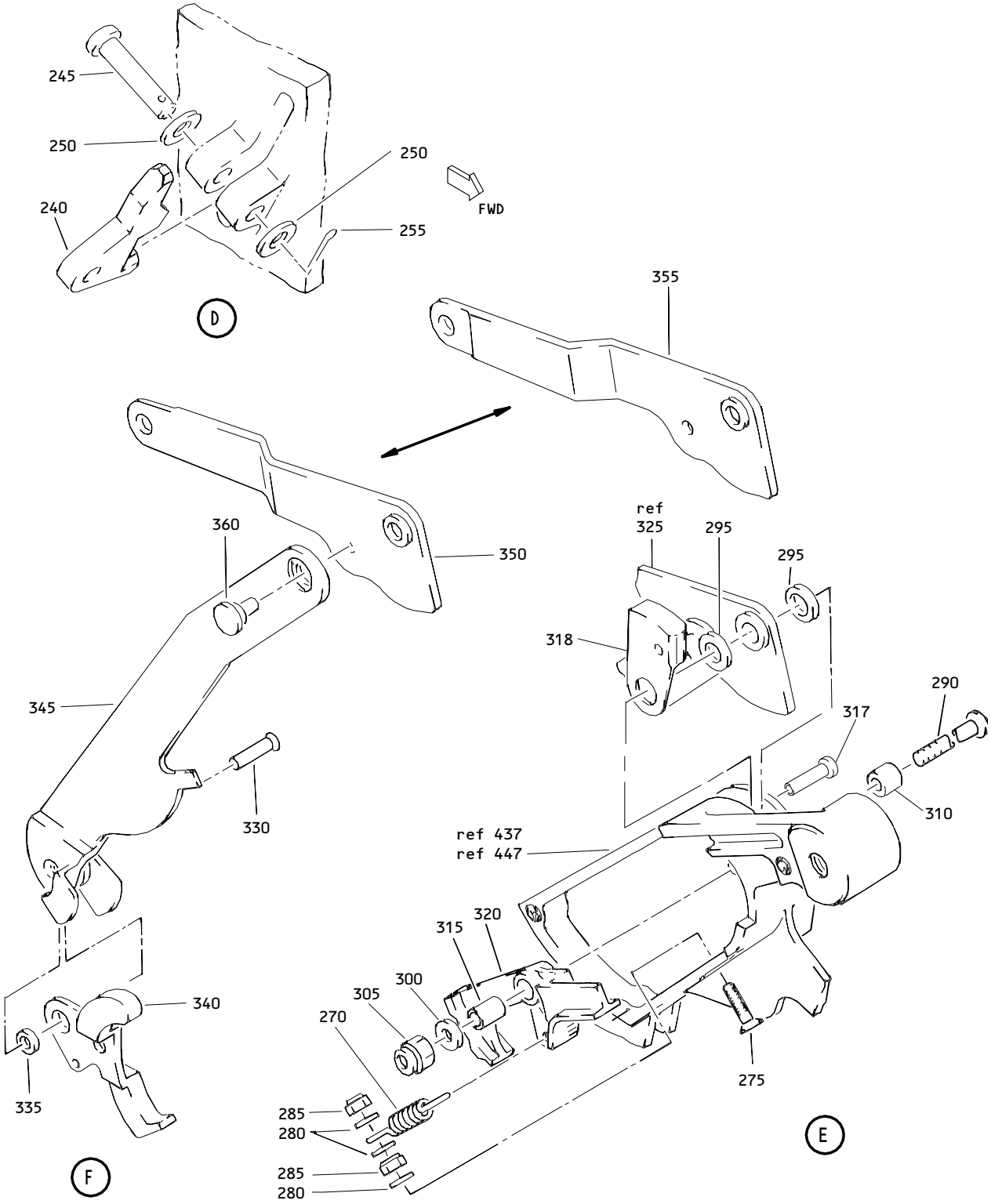

Control Stand Thrust Lever Assembly
Figure 2 (Sheet 3)

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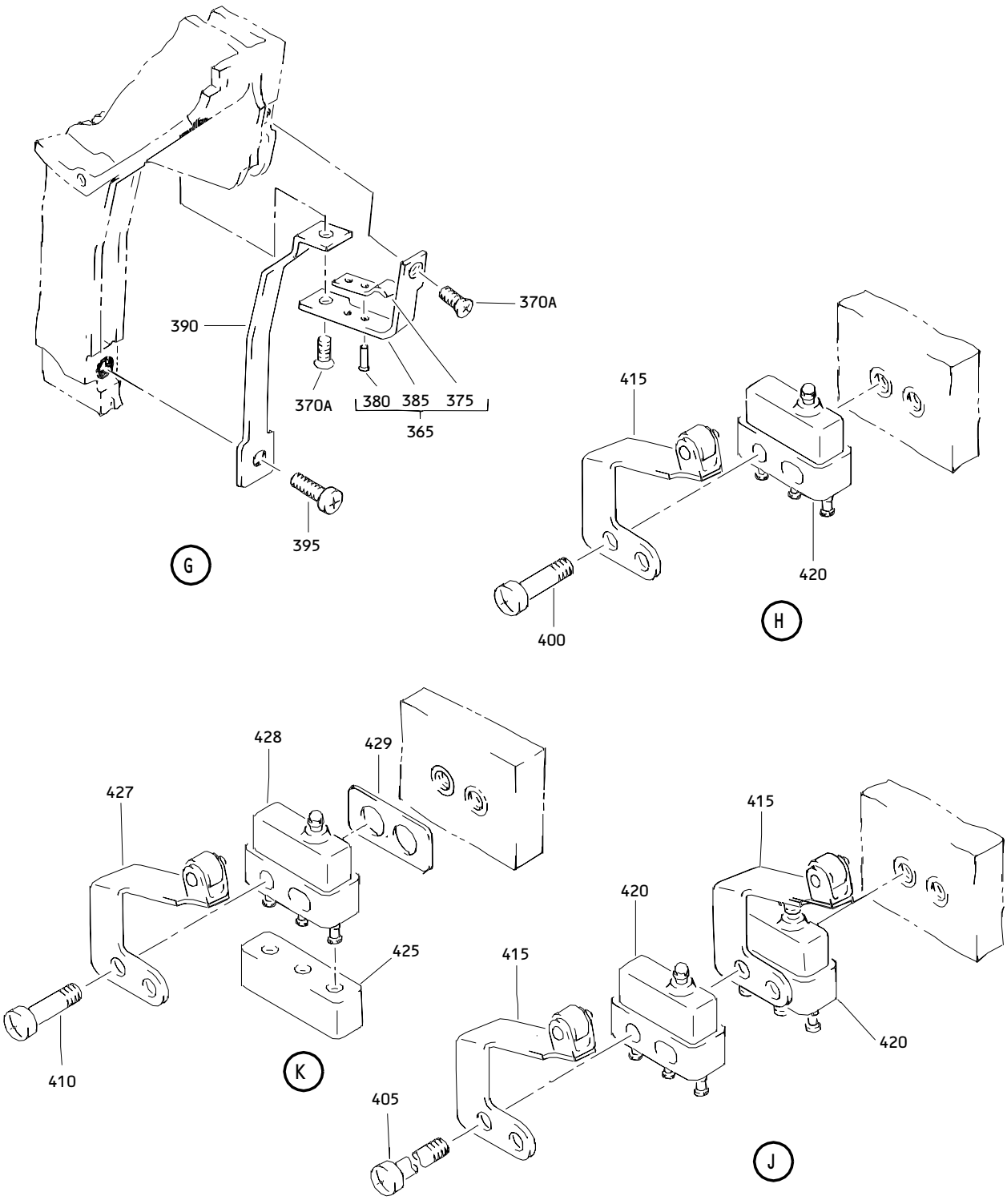

Control Stand Thrust Lever Assembly
Figure 2 (Sheet 4)

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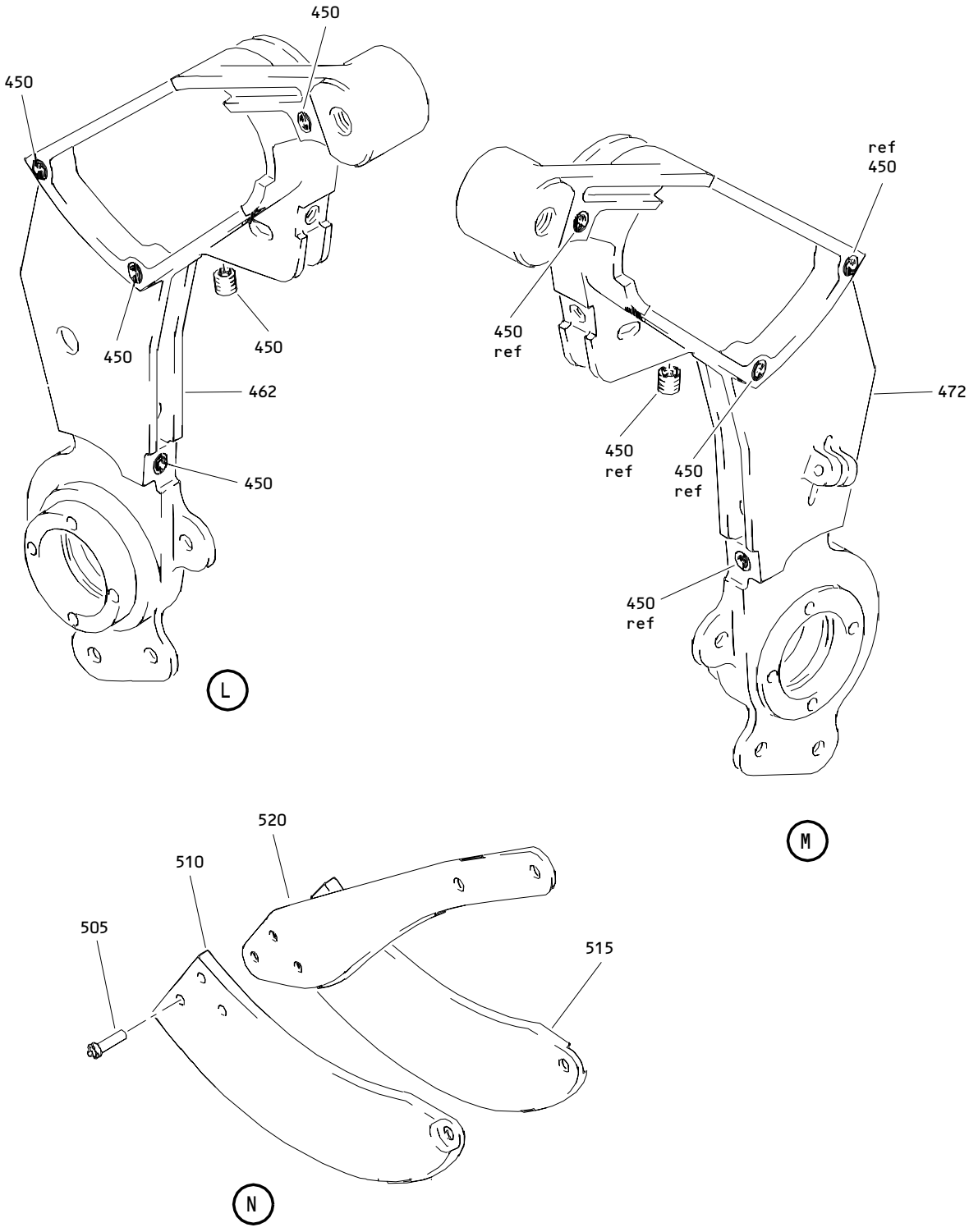

Control Stand Thrust Lever Assembly
Figure 2 (Sheet 5)

T58440

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-					
-1C	253T5810-7		LEVER ASSY-CONT STAND THRUST (PRE SB 767-76-0031) (PRE SB 767-76-0008)	B	RF
-1E	253T5810-11		LEVER ASSY-CONT STAND THRUST (PRE SB 767-76-0031) (PRE SB 767-76-0008)	D	RF
-1F	253T5810-13		LEVER ASSY-CONT STAND THRUST (PRE SB 767-76-0031) (PRE SB 767-76-0008)	C	RF
-1G	253T5810-15		LEVER ASSY-CONT STAND THRUST (PRE SB 767-76-0031) (POST SB 767-76-0008)	F	RF
-1H	015T0630-5		LEVER ASSY-THRUST (REWORK) (POST SB 767-76-0031)	V-Y	RF
-1J	015T0156-3		LEVER ASSY-THRUST (REWORK) (POST SB 767-76-0008)	D,U	RF
-5C	253T5810-8		LEVER ASSY-CONT STAND THRUST (PRE SB 767-76-0031) (PRE SB 767-76-0008)	B	RF
-5E	253T5810-12		LEVER ASSY-CONT STAND THRUST (PRE SB 767-76-0031) (PRE AB 767-76-0008)	D	RF
-5F	253T5810-14		LEVER ASSY-CONT STAND THRUST (PRE SB 767-76-0031) (PRE SB 767-76-0008)	C	RF
-5G	253T5810-16		LEVER ASSY-CONT STAND THRUST (POST SB 767-76-0008) (PRE SB 767-76-0031)	F	RF
-5H	015T0630-6		LEVER ASSY-THRUST (REWORK) (POST SB 767-76-0031)	V-Y	RF
-5J	015T0156-4		LEVER ASSY-THRUST (REWORK) (POST SB 767-76-0008)	D,U	RF

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-					
10	65C14183-46		.KNOB	B-D,F,V-Y	1
20A	BACS12BP3P8		.SCREW	B-D,F,V-Y	1
30	253T5811-1		.KNOB	B-D,F,V-Y	1
35	C2006		.SWITCH- (V81640)	B-D,F,V-Y	1
-35A	P8-4000003		DELETED		
40	MS20427M4-19		.RIVET	B-D,F,V-Y	4
45	253T5812-1		.RETAINER	B-D,F,V-Y	1
50	253T5812-2		.RETAINER	B-D,F,V-Y	1
55	B539DDNJC		.BEARING- (V06144) (SPEC BACB10CF12PP) (OPT B539DDFS101 (V06144)) (OPT T339E (VK8455)) (OPT B539SSG27 (V30163)) (OPT B539DDFS428 (V21335)) (OPT B539DD (V38443)) (OPT B539-2TS (V43991)) (OPT B539FS101 (V06144)) (OPT B539DDP (V21760)) (OPT ITEM 55A)	B-D,F,V-Y	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02- -55A	MB539DDNJC		.BEARING- (V06144) (SPEC BACB10AS12) (OPT LLMB539 (V38443)) (OPT MB539-2TS (V43991)) (OPT MB539DDFS428 (V21335)) (OPT MB539TT (V43991)) (OPT MB539DDG20 (V38443)) (OPT MT339E (VK8455)) (OPT MB539DDLY196 (V40920)) (OPT MB539DD (V06144)) (OPT NB539DDSD610 (V83086)) (OPT ITEM 55)	B-D,F ,V-Y	1
60	253T5835-1		.CAM	B-D,F ,V-Y	1
65	NAS601-4		.SCREW	B-D,F ,V-Y	3
70	AN960D6L		.WASHER	B-D,F ,V-Y	3

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-75	MKP29BNJC		.BEARING- (V06144) (SPEC BACB10AU29) (OPT MKP29BSD610 (V83086)) (OPT MKP29BTT (V43991)) (OPT MKP29B2TS (V43991)) (OPT MKP16BE9273-29 (V21335)) (OPT LLMKP29B1 (V38443)) (OPT MKP29BFS428 (V21335)) (OPT MKP29B1G20 (V38443)) (OPT MKP29BLY196 (V40920)) (OPT MKP29B (V06144))	B-D,F,V-Y	1
80	MS24586-698		.SPRING	B-D,F,V-Y	2
85	253T5832-1		.PLATE	B-D,F,V-Y	2
90	NAS6603-1		.BOLT	B-D,F,V-Y	2
95	AN960C516L		.WASHER	B-D,F,V-Y	2
100	AN960C10L		.WASHER	B-D,F,V-Y	2
105	BACB28Y3C010		.BUSHING	B-D,F,V-Y	2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-					
110	NAS6603-6		.BOLT	B-D,F,V-Y	1
115	AN960C10L		.WASHER	B-D,F,V-Y	1
120	BACB28X3M040		.BUSHING	B-D,F,V-Y	1
125	253T5833-1		.FOLLOWER ASSY	B-D,F,V-Y	1
130	MS21209F1-15		..INSERT	B-D,F,V-Y	1
135	253T5831-1		..RIVET	B-D,F,V-Y	1
140	69B14373-3		..WASHER	B-D,F,V-Y	1
145	KP3ALP		..BEARING- (V21760) (SPEC BACB10BG1M) (OPT KP3ALE6531 (V21335)) (OPT KP3ALFS428 (V21335)) (OPT KP3ALTT (V43991)) (OPT KP3ALT1C1-01 (V21760)) (OPT LLKP3AL (V38443)) (OPT KP3ALG20 (V38443)) (OPT CS203AE (VK8455)) (OPT KP3ALSD610 (V83086)) (OPT KP3ALE (V21760)) (OPT KP3AL (V38443))	B-D,F,V-Y	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-					
150	DBAF5-184		DELETED		
150A	KJB60516-327		..BUSHING- (V50632) (SPEC 10-60516-327) (OPT 90792 (V09455)) (OPT AJF05A109 (VS0352)) (OPT FBR05A11BA (V73134)) (OPT KJN5-22 (V97613)) (OPT NHF05-203A (V15860)) (OPT YTS754 (V77896)) (OPT DBAF5-184 (V81376))	B-D,F,V-Y	1
155	253T5833-2		..FOLLOWER	B-D,F,V-Y	1
160	MS24586C62		.SPRING- (OPT ITEM 160A)	B-D,F,V-Y	1
-160A	MS24586C61		.SPRING- (OPT ITEM 160)	B-D,F,V-Y	1
165A	BACB30LR3U3		.BOLT	B-D,F,V-Y	1
170A	69B84020-1		.BUSHING	B-D,F,V-Y	1
175A	253T5819-3		.CRANK ASSY	B-D,F,V-Y	1
185	MS21209C0610		..INSERT	B-D,F,V-Y	3
190	MS21209F1-10		..INSERT	B-D,F,V-Y	1
192	MS21209F1-15		..INSERT	B-D,F,V-Y	1
195	253T5819-2		..CRANK	B-D,F,V-Y	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-					
200	NAS6603-3		.BOLT	B-D,F ,V-Y	1
212	AN960C10L		.WASHER	B-D,F ,V-Y	2
217	H10-3BAC		.NUT- (V15653) (SPEC BACN10JC3) (OPT NS202101-02 (V80539)) (OPT RMLH9075-3W (V72962)) (OPT T6S1032J (V71087)) (OPT VN303A02 (V92215)) (OPT 96-02 (V80539)) (OPT BRH10A3 (V52828))	B-D,F ,V-Y	1
225	253T5834-1		.CAM-DETENT	B,C,F ,V-Y	1
-225A	253T5834-2		.CAM-DETENT	D,V-Y	1
230	69B82645-1		.SHIELD	B-D,F ,V-Y	1
235	253T5815-1		.SUPPORT ASSY-WIRE	B-D,F ,V-Y	1
240	69B81942-2		.LATCH	B-D,F ,V-Y	1
245	MS20392-1C15		.PIN-DRILLED SHANK	B-D,F ,V-Y	1
250	NAS620C5L		.WASHER	B-D,F ,V-Y	2
255	MS24665-151		.PIN-COTTER	B-D,F ,V-Y	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-					
260	253T5828-9		.COVER- (OPT ITEM 260B) (USED ON ITEMS 1C, 1E, 1F, 1G, 1H)	B-D,F,V-Y	1
-260A	253T5828-10		.COVER- (OPT ITEM 260C) (USED ON ITEMS 5C, 5E, 5F, 5G, 5H)	B-D,F,V-Y	1
-260B	253T5828-11		.COVER- (OPT ITEM 260) (USED ON ITEMS 1C, 1E, 1F, 1G, 1H)	B-D,F,V-Y	1
-260C	253T5828-12		.COVER- (OPT ITEM 260A) (USED ON ITEMS 5C, 5E, 5F, 5G, 5H)	B-D,F,V-Y	1
265	NAS514P832-4		.SCREW	B-D,F,V-Y	3
270	MS24586C60		.SPRING	B-D,F,V-Y	1
275	NAS514P440-8		.SCREW	B-D,F,V-Y	1
280	AN960C4L		.WASHER	B-D,F,V-Y	3
285	H10-04BAC		.NUT- (V15653) (SPEC BACN10JC04) (OPT NS202101-40 (V80539)) (OPT RMLH9075-40W (V72962)) (OPT T6S440J (V11815)) (OPT VN303A40 (V92215)) (OPT 96-40 (V80539)) (OPT BRH10A04 (V52828))	B-D,F,V-Y	2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-290	HL18PB6-15		.BOLT- (V06725) (SPEC BACB30FM6-15) (OPT HL18PB6-15 (V73197)) (OPT HL18PB6-15 (V92215)) (OPT HL18PB6-15 (V97928)) (OPT HL18PB6-15 (V80539)) (OPT WC22-6-15 (V60516)) (OPT 62550-6-15 (V56878)) (OPT L8056-15 (V06725)) (OPT HL18PB6-15 (V56878))	B-D,F,V-Y	1
295	AN960C516L		.WASHER-*(1)	B-D,F,V-Y	AR
-295A	BACW10P24C		.WASHER-*(1)	B-D,F,V-Y	AR
300	AN960D10L		.WASHER	B-D,F,V-Y	1
305	H10-3BAC		.NUT- (V15653) (SPEC BACN10JC3) (OPT NS202101-02 (V80539)) (OPT RMLH9075-3W (V72962)) (OPT T6S1032J (V71087)) (OPT VN303A02 (V92215)) (OPT 96-02 (V80539)) (OPT BRH10A3 (V52828))	B-D,F,V-Y	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-					
310	BACB28Y3C042		.BUSHING	B-D,F ,V-Y	1
315	BACB28Y3C046		.BUSHING	B-D,F ,V-Y	1
317	253T5841-1		.RIVET- (PRE SB 767-78-0004) (POST SB 767-76-0008)	C,D,F ,V-Y	1
318	253T5840-1		.STOP- (USED ON ITEMS 1E, 1F) (PRE SB 767-78-0004)	C,D, V-Y	1
-318A	253T5840-3		.STOP- (USED ON ITEM 1G) (POST SB 767-76-0008)	F,V-Y	1
-319	253T5840-2		.STOP- (USED ON ITEMS 5E, 5F) (PRE SB 767-78-0004)	C,D, V-Y	1
-319A	253T5840-4		.STOP- (USED ON ITEM 5G) (POST SB 767-76-0008)	F,V-Y	1
320	253T5823-1		.TRIGGER- (USED ON ITEMS 1C, 1E, 1F, 1G, 1H)	B-D,F ,V-Y	1
-320A	253T5823-2		.TRIGGER- (USED ON ITEMS 5C, 5E, 5F, 5G, 5H)	B-D,F ,V-Y	1
325	253T5824-1		.LINK ASSY- (USED ON ITEMS 1C, 1E, 1F, 1G) (PRE SB 767-76-0031)	B-D,F	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-					
-325A	253T5824-2		.LINK ASSY- (USED ON ITEMS 5C, 5E, 5F, 5G) (PRE SB 767-76-0031)	B-D,F	1
-325B	015T0630-3		.LINK ASSY- (REWORK) (USED ON ITEM 1H) (POST SB 767-76-0031)	V-Y	1
-325C	015T0630-4		.LINK ASSY- (REWORK) (USED ON ITEM 5H) (POST SB 767-76-0031)	V-Y	1
330	BACR15DY6M10		..RIVET- (V53551) (SPEC BACR15DY6M10)	B-D,F ,V-Y	1
335	69B81324-1		..BUSHING	B-D,F ,V-Y	1
340	253T5827-1		..LATCH-LEVER	B-D,F ,V-Y	1
345	253T5826-1		..LINK	B-D,F ,V-Y	1
350	253T5825-1		..LEVER ASSY- (USED ON ITEMS 325, 325B)	B-D,F ,V-Y	1
355	253T5825-2		..LEVER ASSY- (USED ON ITEMS 325A, 325C)	B-D,F ,V-Y	1
360	69B81663-2		..RIVET-CONT LINK	B-D,F ,V-Y	1
365	253T5817-3		.COVER ASSY-UPR (USED ON ITEMS 1C, 1E, 1F, 1G, 1H)	B-D,F ,V-Y	1
-365A	253T5817-4		.COVER ASSY-UPR (USED ON ITEMS 5C, 5E, 5F, 5G, 5H)	B-D,F ,V-Y	1
370A	BACS12BP08P5		.SCREW	B-D,F ,V-Y	2
375	253T5817-7		..SPRING	B-D,F ,V-Y	1
380	MS20427M2		..RIVET	B-D,F ,V-Y	2
385	253T5817-9		..COVER- (USED ON ITEM 365)	B-D,F ,V-Y	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-					
-385A	253T5817-10		..COVER- (USED ON ITEM 365A)	B-D,F ,V-Y	1
390	253T5817-1		.COVER-LWR (USED ON ITEMS 1C, 1E, 1F, 1G, 1H)	B-D,F ,V-Y	1
-390A	253T5817-2		.COVER-LWR (USED ON ITEMS 5C, 5E, 5F, 5G, 5H)	B-D,F ,V-Y	1
395	NAS602-5P		.SCREW	B-D,F ,V-Y	1
400	MS35214-5		.SCREW- (OPT ITEMS 400A, 400B)	B-D,F ,V-Y	2
-400A	BACS12BG02CP6		.SCREW- (OPT ITEMS 400, 400B)	C,D,F ,V-Y	2
-400B	BACS12BG02AP6		.SCREW- (OPT ITEMS 400, 400A)	B-D,F ,V-Y	2
405	MS35214-8		.SCREW- (OPT ITEMS 405A, 405B)	B-D,F ,V-Y	2
-405A	BACS12BG02CP9		.SCREW- (OPT ITEMS 405, 405B)	C,D,F ,V-Y	2
-405B	BACS12BG02AP9		.SCREW- (OPT ITEMS 405, 405A)	B-D,F ,V-Y	2
410	MS35214-4		.SCREW- (OPT ITEMS 410A, 410B)	B-D,F ,V-Y	2
-410A	BACS12BG02CP6		.SCREW- (OPT ITEMS 410, 410B)	C,D,F ,V-Y	2
-410B	BACS12BG02AP6		.SCREW- (OPT ITEMS 410, 410A)	B-D,F ,V-Y	2
415	JX45		.ACTUATOR- (V91929)	B-D,F ,V-Y	3
420	MS24547-1		.SWITCH	B-D,F ,V-Y	3
425	DLV2004		.CONNECTOR- (VOLYY8)	B-D,F ,V-Y	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-					
427	JX45		.ACTUATOR- (V91929)	B-D,F ,V-Y	1
428	MS24547-1		.SWITCH	B-D,F ,V-Y	1
429	253T5836-1		.SHIM-SWITCH (USED ON ITEMS 5C, 5E 5F, 5G, 5H)	B-D,F ,V-Y	1
437	253T5814-13		.LEVER ASSY- (USED ON ITEMS 1C, 1E, 1F, 1G, 1H) (ITEM 437 OR 437B (EITHER PART REWKD BY ADDING REVERSE THRUST STOP ATTACH HOLE) IS OPT TO ITEM 437C)	B-D,F ,V-Y	1
-437A	253T5814-7		DELETED		
-437B	253T5814-17		.LEVER ASSY- (USED ON ITEMS 1C, 1E, 1F, 1G, 1H) (ITEM 437 OR 437B (EITHER PART REWKD BY ADDING REVERSE THRUST STOP ATTACH HOLE) IS OPT TO ITEM 437C)	B-D,F ,V-Y	1
-437C	253T5814-23		.LEVER ASSY- (USED ON ITEMS 1E, 1F, 1G, 1H) (ITEM 437 OR 437B (EITHER PART REWKD BY ADDING REVERSE THRUST STOP ATTACH HOLE) IS OPT TO ITEM 437C)	C,D,F ,V-Y	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-					
447	253T5814-14		.LEVER ASSY- (USED ON ITEMS 5C, 5E, 5F, 5G, 5H) (OPT ITEM 447A USED WITH ITEM 480A) (OPT ITEM 447B USED WITH ITEM 480) (USED WITH ITEM 480)	B-D,F ,V-Y	1
-447A	253T5814-8		.LEVER ASSY- (USED ON ITEMS 5C, 5E, 5F, 5G, 5H) (OPT ITEM 447 USED WITH ITEM 480) (OPT ITEM 447B USED WITH ITEM 480) (USED WITH ITEM 480)	B-D,F ,V-Y	1
-447B	253T5814-18		.LEVER ASSY- (USED ON ITEMS 5C, 5E, 5F, 5G, 5H) (OPT ITEM 447 USED WITH ITEM 480) (OPT ITEM 447A USED WITH ITEM 480A) (USED WITH ITEM 480)	B-D,F ,V-Y	1
-447C	253T5814-24		.LEVER ASSY- (USED ON ITEMS 5E, 5F 5G, 5H) (USED WITH ITEM 480)	C,D,F ,V-Y	1
450	MS21209C0810		..INSERT	B-D,F ,V-Y	5
-460	253T5814-9		..LEVER- (USED ON ITEM 437A)	B-D,F ,V-Y	1
462	253T5814-15		..LEVER- (USED ON ITEM 437)	B-D,F ,V-Y	1
-464	253T5814-19		..LEVER- (USED ON ITEM 437B)	B-D,F ,V-Y	1
-466	253T5814-25		..LEVER- (USED ON ITEM 437C)	B-D,F ,V-Y	1
-470	253T5814-10		..LEVER- (USED ON ITEM 447A)	B-D,F ,V-Y	1
472	253T5814-16		..LEVER- (USED ON ITEM 447)	B-D,F ,V-Y	1
-474	253T5814-20		..LEVER- (USED ON ITEM 447B)	B-D,F ,V-Y	1
475	BAC27TCT0156		DELETED		

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-					
-475A	BAC27TCT0157		DELETED		
476	253T5814-26		..LEVER	B-D,F,V-Y	1
480	253T5838-1		.COUNTERWEIGHT ASSY- (OPT ITEM 480A USED WITH ITEMS 437A, 447A) (USED WITH ITEMS 437, 437B, 437C, 447, 447B, 447C) (USED ON ITEMS 5C, 5E, 5F, 5G, 5H)	B-D,F,V-Y	1
-480A	253T5838-2		.COUNTERWEIGHT ASSY- (OPT ITEM 480 USED WITH ITEMS 437, 437B, 447, 447B) (USED ON ITEMS 5C, 5E, 5F, 5G, 5H) (USED WITH ITEMS 437A, 447A)	B-D,F,V-Y	1
			ATTACHING PARTS		
485B	NAS6603-6		.BOLT	B-D,F,V-Y	2
490A	BACW10P5C		.WASHER- (V10630) (SPEC BACW10P5C)	B-D,F,V-Y	2
493	AN960C10L		.WASHER	B-D,F,V-Y	4
-495	NAS1056C6-009		.SPACER- (OPT ITEMS 495B, 495C)	B-D,F,V-Y	2
-495B	NAS620-416		.WASHER- (OPT ITEM 495)	B-D,F,V-Y	2
-495C	NAS620-416L		.WASHER- (OPT ITEM 495)	B-D,F,V-Y	2
500B	BRH10-3		.NUT- (V52828) (SPEC BACN10JC3)	B-D,F,V-Y	2
			-------*-------		
505	BACR15CE6KE		..RIVET- (SIZE DETERMINE ON INST)	B-D,F,V-Y	3
510	253T5837-1		..COUNTERWEIGHT	B-D,F,V-Y	1
515	253T5837-2		..COUNTERWEIGHT	B-D,F,V-Y	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-					
520	253T5839-1		..ARM-SPRT (USED ON ITEM 480)	B-D,F ,V-Y	1
-525	253T5839-2		..ARM-SPRT (USED ON ITEM 480A)	B-D,F ,V-Y	1
530	BAC27TCT0156		.MARKER-VINYL (USED ON ITEMS 1C, 1E, 1F, 1G, 1H)	B-D,F ,V-Y	1
535	BAC27TCT0157		.MARKER-VINYL (USED ON ITEMS 5C, 5E, 5F, 5G, 5H)	B-D,F ,V-Y	1

- Item Not Illustrated

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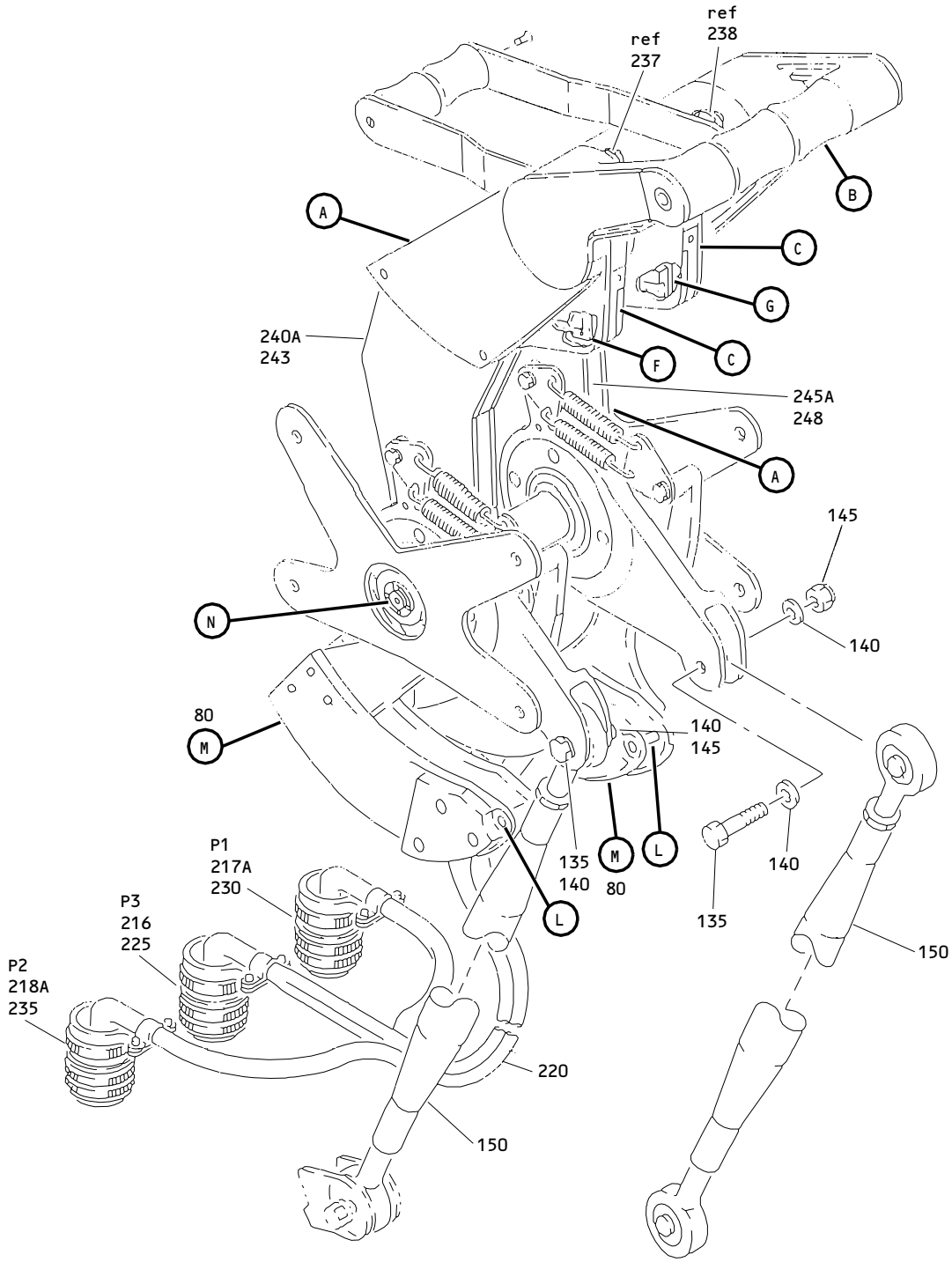

Control Stand Thrust Control Lever Assembly
Figure 3 (Sheet 1)

A15968

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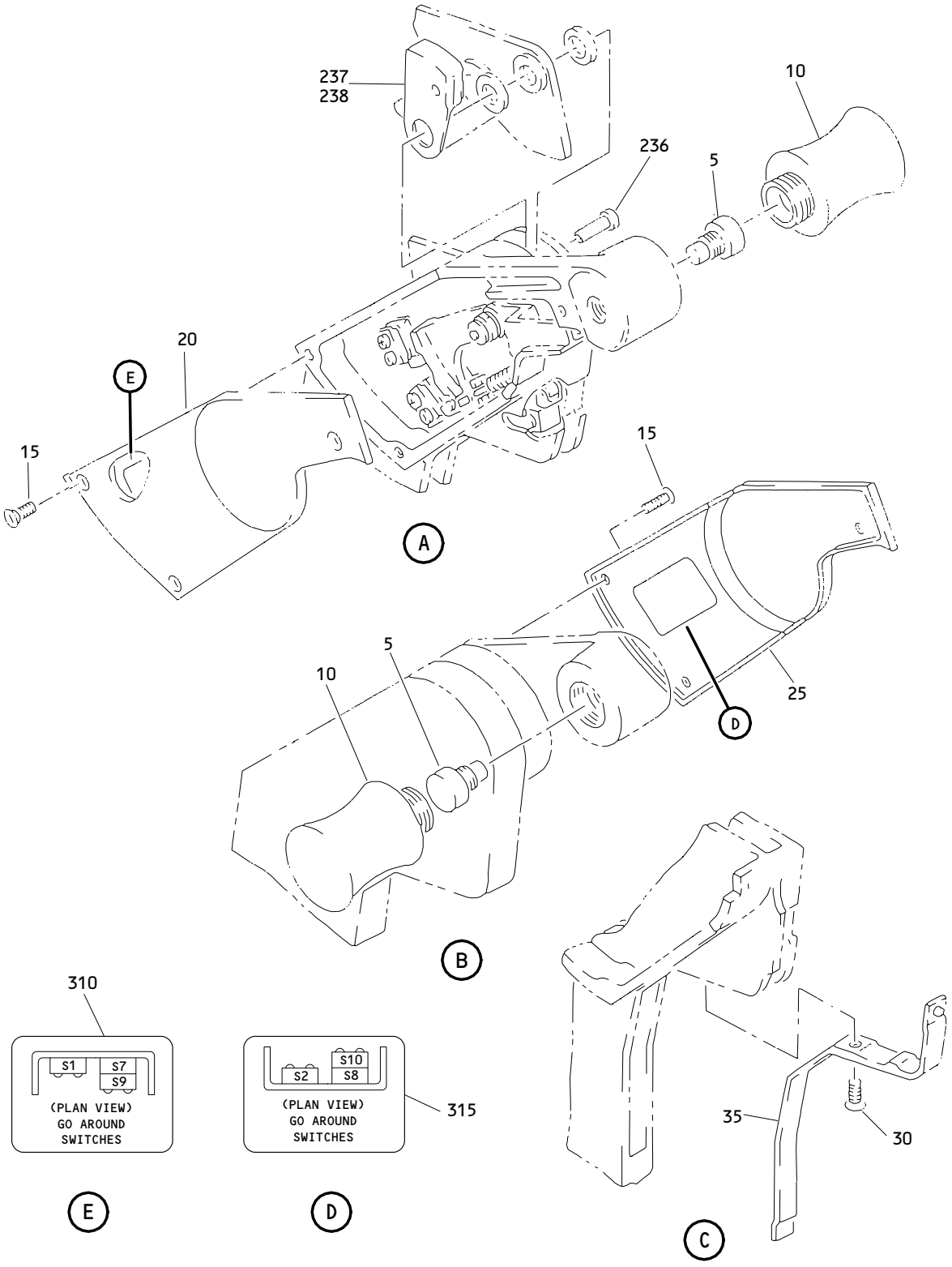

Control Stand Thrust Control Lever Assembly
Figure 3 (Sheet 2)

A15969

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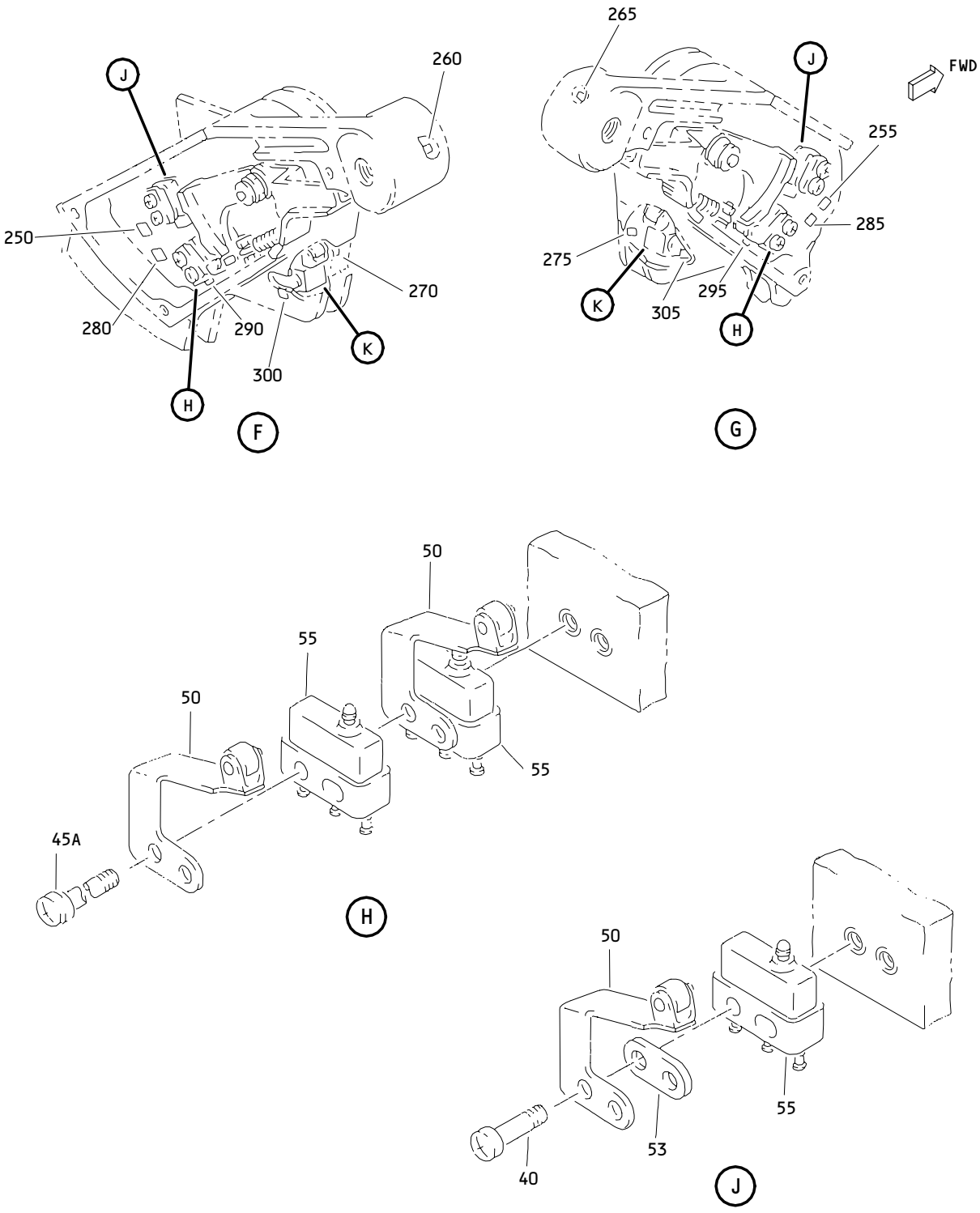

Control Stand Thrust Control Lever Assembly
Figure 3 (Sheet 3)

A15970

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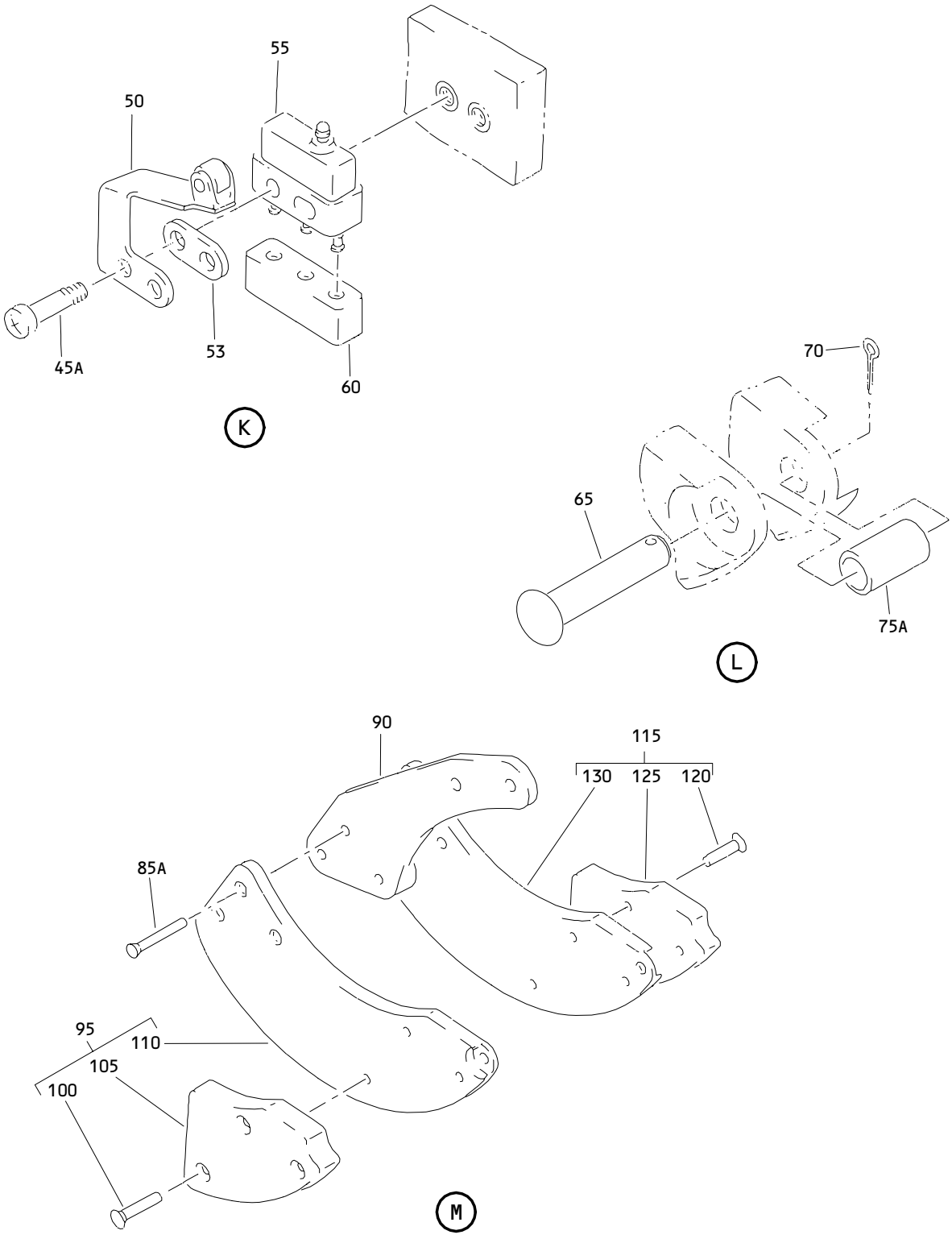

Control Stand Thrust Control Lever Assembly
Figure 3 (Sheet 4)

A15971

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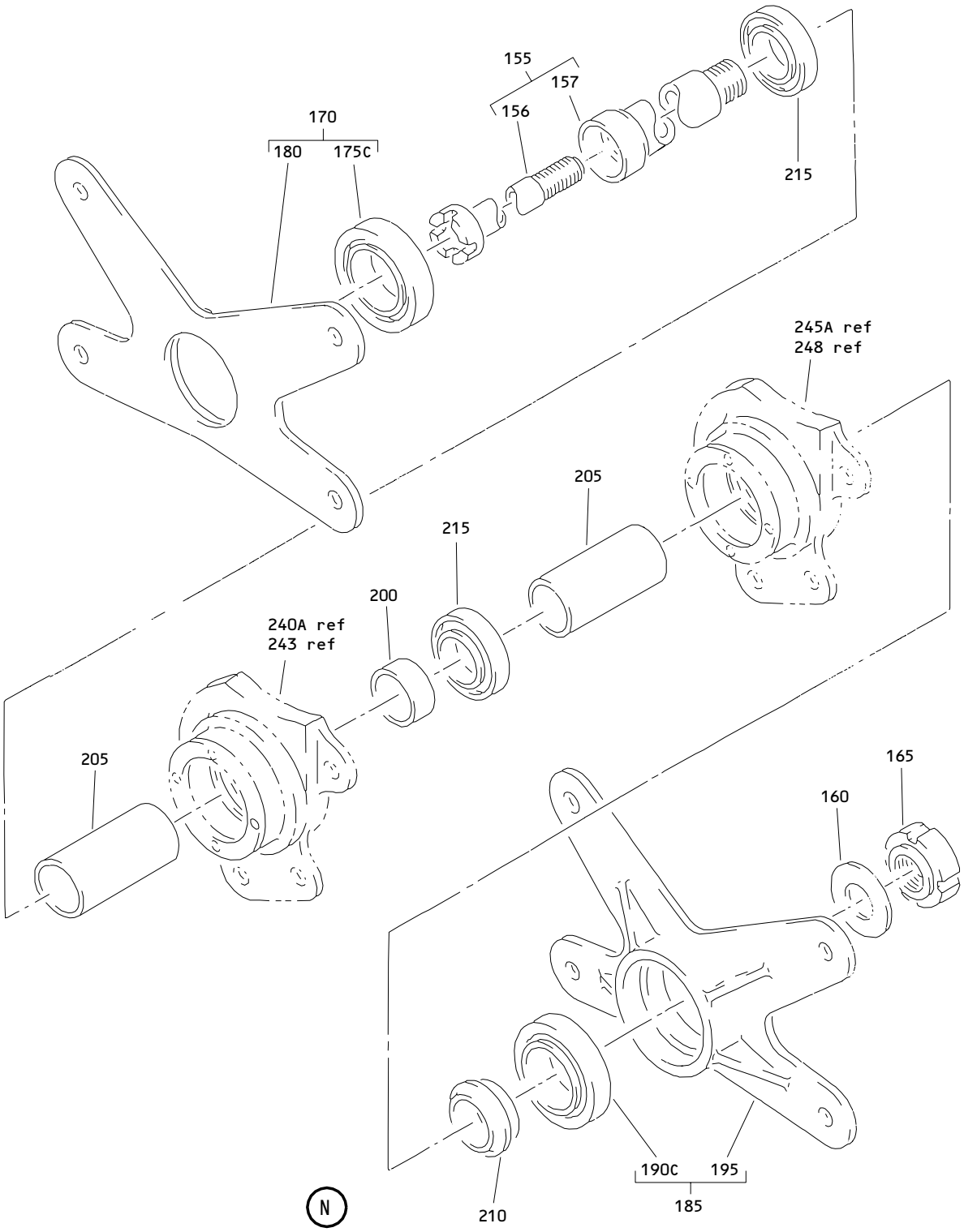

Control Stand Thrust Control Lever Assembly
Figure 3 (Sheet 5)

A15972

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
03-					
-1	253T5800-17		LEVER ASSY-CONT STAND THRUST (PRE SB 767-76-0017) (PRE SB 767-76-0031)	E	RF
-1A	253T5800-21		LEVER ASSY-CONT STAND THRUST (PRE SB 767-76-0017) (PRE SB 767-76-0031)	G	RF
-1B	253T5800-23		LEVER ASSY-CONT STAND THRUST (POST SB 767-76-0017) (PRE SB 767-76-0031)	H	RF
-1C	253T5800-25		LEVER ASSY-CONT STAND THRUST (POST SB 767-76-0017) (PRE SB 767-76-0031)	J	RF
-1D	253T5800-27		LEVER ASSY-CONT STAND THRUST (PRE SB 767-76-0031)	K	RF
-1E	253T5800-29		LEVER ASSY-CONT STAND THRUST (POST SB 767-76-0031)	L	RF
-1F	253T5800-31		LEVER ASSY-CONT STAND THRUST (POST SB 767-76-0031)	M	RF
-1G	253T5800-33		LEVER ASSY-CONT STAND THRUST (POST SB 767-76-0031)	N	RF
-1H	253T5800-35		LEVER ASSY-CONT STAND THRUST	P	RF
-1J	253T5800-37		LEVER ASSY-CONT STAND THRUST	Q	RF
-1K	253T5800-39		LEVER ASSY-CONT STAND THRUST	R	RF
-1L	015T0630-21		LEVER ASSY-CONT STAND THRUST (REWORK) (POST SB 767-76-0031)	Z	RF
5	C2006		.SWITCH- (V81640) (S3, S4)	E,G-N,Z	2
10	253T5811-1		.KNOB	E,G-N,Z	2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
03-					
15	NAS514P632-4		.SCREW	E,G-N ,Z	6
20	254N1138-1		.COVER	E,G-N ,Z	1
25	254N1138-2		.COVER	E,G-N ,Z	1
30	BACS12BP06-5		.SCREW	E,G-N ,Z	2
35	254N1140-1		.COVER	E,G-N ,Z	2
40	BACS12BG02AP6		.SCREW	E,G-N ,Z	4
45	BACS12BG02A9		DELETED		
45A	BACS12BG02AP9		.SCREW	E,G-N ,Z	8
50	JX45		.ACTUATOR-SWITCH (V91929)	E,G-N ,Z	8
53	253T5836-1		.SHIM	E,G-N ,Z	2
55	MS24547-1		.SWITCH- (S1, S2, S5-S10)	E,G-N ,Z	8
60	DLV2004		.CONNECTOR- (VOLYY8)	E,G-K ,Z	2
-60A	D2002		.CONNECTOR- (V0827B) (OPT ITEM 60B)	L-N	2
-60B	DLV2002		.CONNECTOR- (VOLYY8) (OPT ITEM 60A)	L-N	2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
03-					
65	MS20392-2C17		.PIN-DRILLED SHANK	E,G-N,Z	2
70	MS24665-151		.PIN-COTTER	E,G-N,Z	2
75A	NAS43DD3-24		.SPACER	E,G-N,Z	2
80	253T5842-1		.COUNTER WEIGHT ASSY- (ITEM 240A ASSEMBLED WITH ITEM 80 IS OPT TO ITEM 240B AND ITEM 245A ASSEMBLED WITH ITEM 80 IS OPT TO ITEM 245B)	E,G	2
-80A	253T5842-1		.COUNTER WEIGHT ASSY	Z	2
85A	BACR15BB6B		..RIVET- (SIZE DETERMINE ON INST)	E,G,Z	3
90	253T5839-1		..ARM-SPRT	E,G,Z	1
95	253T5842-3		..GUIDE ASSY-L	E,G,Z	1
100	BACR15CE6KE		...RIVET- (SIZE DETERMINE ON INST)	E,G,Z	3
105	253T5844-1		...SLUG	E,G,Z	1
110	253T5845-1		...WIREGUIDE	E,G,Z	1
115	253T5842-4		..GUIDE ASSY-R	E,G,Z	1
120	BACR15CE6KE		...RIVET- (SIZE DETERMINE ON INST)	E,G,Z	3
125	253T5844-2		...SLUG	E,G,Z	1
130	253T5845-1		...WIREGUIDE	E,G,Z	1
135	BACB30NR4K8		.BOLT	E,G-N,Z	2
140	AN960D416L		.WASHER	E,G-N,Z	4

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
03-					
145	BRH10A4		.NUT- (V52828) (SPEC BACN10JC4) (OPT T6S428J (V11815)) (OPT 96-048 (V80539)) (OPT VN303A048 (V92215)) (OPT RMLH9075-4W (V72962)) (OPT NS202101-048 (V80539)) (OPT H10-4BAC (V15653))	E,G-R ,Z	2
150	251T0100-140		.ROD ASSY- (REF CMM 27-00-11)	E,G-N ,Z	2
155	254N1172-1		.SHAFT ASSY	E,G-R ,Z	1
156	253T5816-1		..SHAFT-INNNER	E,G-R ,Z	1
157	254N1153-1		..SHAFT-OUTER (OPT ITEM 157A)	E,G-R ,Z	1
-157A	254N1153-2		..SHAFT-OUTER (OPT ITEM 157)	E,G-R ,Z	1
160	AN960D1016		.WASHER	E,G-R ,Z	1
165	SL2822-10		.NUT- (V97393) (SPEC BACN10RF10) (OPT 82631-1018 (V56878)) (OPT BR9080-10 (V72962))	E,G-R ,Z	1
170	253T5830-1		.SUPPORT ASSY	E,G-R ,Z	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
03-					
175	MKP16BS2E9881		DELETED		
175A	LLKP16BS1		DELETED		
175B	MKP16BS2SD750		DELETED		
175C	Y010		..BEARING- (V40920) (SPEC 60B00179-100) (OPT 10633 (V06144)) (OPT MKP16BS2E9881 (V21335)) (OPT LLKP16BS1 (V38443)) (OPT MKP16BS2SD750 (V83086)) (OPT Y164 (V40920))	E,G-R ,Z	1
180	253T5830-2		..SUPPORT	E,G-R ,Z	1
185	253T5829-1		.SUPPORT ASSY	E,G-R ,Z	1
190	MKP16BS2E9881		DELETED		
190A	LLKP16BS1		DELETED		
190B	MKP16BS2SD750		DELETED		
190C	Y010		..BEARING- (V40920) (SPEC 60B00179-100) (OPT 10633 (V06144)) (OPT MKP16BS2E9881 (V21335)) (OPT LLKP16BS1 (V38443)) (OPT MKP16BS2SD750 (V83086)) (OPT Y164 (V40920))	E,G-R ,Z	1
195	253T5829-2		..SUPPORT	E,G-R ,Z	1
200	253T4006-1		.SPACER	E,G-R ,Z	1
205	253T4006-11		.SPACER	E,G-R ,Z	2
210	254N1173-1		.SPACER	E,G-R ,Z	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
03-					
215	MB539DDNJC		.BEARING- (V06144) (SPEC BACB10AS12) (OPT LLMB539 (V38443)) (OPT MB539-2TS (V43991)) (OPT MB539DDFS428 (V21335)) (OPT MB539TT (V43991)) (OPT MB539DDG20 (V38443)) (OPT MT339E (VK8455)) (OPT MB539DDLY196 (V40920)) (OPT MB539DD (V06144)) (OPT NB539DDSD610 (V83086))	E,G-R ,Z	2
216	BACC45FT14B15P		.CONNECTOR- (P3)	P-R	1
217	BACC45FT14B12P		DELETED		
217A	C0909A12B12PN		.CONNECTOR- (V13556) (SPEC BACC63BN12B12P) (OPT 48-63N12B12P (V02660)) (OPT R071212B12P (V41118)) (P1)	P-R	1
218	BACC45FT14B12P		DELETED		
218A	C0909A12B12P9		.CONNECTOR- (V13556) (SPEC BACC63BN12B12P9) (OPT C0909A12-12P9 (V13556)) (OPT 48-63N12B12P9 (V02660)) (P2)	P-R	1
220	253T5800-6		.WIRE BUNDLE ASSY	E,G-N ,Z	1
225	BACC45FT14B15P		..CONNECTOR- (P3)	E,G-N ,Z	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
03-					
230	C0909A12B12PN		..CONNECTOR- (V13556) (SPEC BACC63BN12B12P) (OPT 48-63N12B12P (V02660)) (OPT R071212B12P (V41118)) (P1)	E,G-N ,Z	1
235	C0909A12B12P9		..CONNECTOR- (V13556) (SPEC BACC63BN12B12P9) (OPT C0909A12-12P9 (V13556)) (OPT 48-63N12B12P9 (V02660)) (P2)	E,G-N ,Z	1
236	253T5841-1		.RIVET	G,J,K ,M,N, Z	2
237	253T5840-5		.STOP	G,J,M ,Z	1
-237A	253T5840-7		.STOP	K,N	1
238	253T5840-6		.STOP	G,J,M ,Z	1
-238A	253T5840-8		.STOP	K,N	1
240A	254N1131-7		.LEVER ASSY- (ITEM 240A ASSEMBLED WITH ITEM 80 IS OPT TO ITEM 240B AND ITEM 245A ASSEMBLED WITH ITEM 80 IS OPT TO ITEM 245B) (FOR DETAILS SEE FIG. 4) (PRE SB 767-76-0031)	E,G	1
-240B	254N1131-9		.LEVER ASSY- (ITEM 240A ASSEMBLED WITH ITEM 80 IS OPT TO ITEM 240B AND ITEM 245A ASSEMBLED WITH ITEM 80 IS OPT TO ITEM 245B) (FOR DETAILS SEE FIG. 4) (PRE SB 767-76-0031)	E,G	1
-240C	254N1131-11		.LEVER ASSY- (FOR DETAILS SEE FIG. 4) (PRE SB 767-76-0031)	H-K	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
03-					
-240D	254N1131-17		.LEVER ASSY- (FOR DETAILS SEE FIG. 4) (POST SB 767-76-0031)	L-N	1
-240E	015T0630-11		.LEVER ASSY- (OPT ITEM 240F) (FOR DETAILS SEE FIG. 4) (POST SB 767-76-0031)	Z	1
-240F	015T0630-15		.LEVER ASSY- (OPT ITEM 240E) (FOR DETAILS SEE FIG. 4) (POST SB 767-76-0031)	Z	1
243	253T5852-1		.LEVER ASSY- (FOR DETAILS SEE FIG. 5)	P	1
-243A	253T5852-3		.LEVER ASSY- (FOR DETAILS SEE FIG. 5)	Q	1
-243B	253T5852-5		.LEVER ASSY- (FOR DETAILS SEE FIG. 5)	R	1
245A	254N1131-8		.LEVER ASSY- (ITEM 240A ASSEMBLED WITH ITEM 80 IS OPT TO ITEM 240B AND ITEM 245A ASSEMBLED WITH ITEM 80 IS OPT TO ITEM 245B) (FOR DETAILS SEE FIG. 4) (PRE SB 767-76-0031)	E,G	1
-245B	254N1131-10		.LEVER ASSY- (ITEM 240A ASSEMBLED WITH ITEM 80 IS OPT TO ITEM 240B AND ITEM 245A ASSEMBLED WITH ITEM 80 IS OPT TO ITEM 245B) (FOR DETAILS SEE FIG. 4) (PRE SB 767-76-0031)	E,G	1
-245C	254N1131-12		.LEVER ASSY- (FOR DETAILS SEE FIG. 4) (PRE SB 767-76-0031)	H-K	1
-245D	254N1131-18		.LEVER ASSY- (FOR DETAILS SEE FIG. 4) (POST SB 767-76-0031)	L-N	1
-245E	015T0630-12		.LEVER ASSY- (OPT ITEM 245F) (FOR DETAILS SEE FIG. 4) (POST SB 767-76-0031)	Z	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
03-					
-245F	015T0630-16		.LEVER ASSY- (OPT ITEM 245E) (FOR DETAILS SEE FIG. 4) (POST SB 767-76-0031)	Z	1
248	253T5852-2		.LEVER ASSY- (FOR DETAILS SEE FIG. 6)	P	1
-248A	253T5852-4		.LEVER ASSY- (FOR DETAILS SEE FIG. 6)	Q	1
-248B	253T5852-6		.LEVER ASSY- (FOR DETAILS SEE FIG. 6)	R	1
250	BAC27TCT0012		.MARKER-VINYL, S1	E,G-N,Z	1
255	BAC27TCT0013		.MARKER-VINYL, S2	E,G-N,Z	1
260	BAC27TCT0014		.MARKER-VINYL, S3	E,G-N,Z	1
265	BAC27TCT0015		.MARKER-VINYL, S4	E,G-N,Z	1
270	BAC27TCT0016		.MARKER-VINYL, S5	E,G-N,Z	1
275	BAC27TCT0017		.MARKER-VINYL, S6	E,G-N,Z	1
280	BAC27TCT0031		.MARKER-VINYL, S7	E,G-N,Z	1
285	BAC27TCT0032		.MARKER-VINYL, S8	E,G-N,Z	1
290	BAC27TCT0033		.MARKER-VINYL, S9	E,G-N,Z	1
295	BAC27TCT0034		.MARKER-VINYL, S10	E,G-N,Z	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
03-					
300	BAC27TCT0149		.DECAL-VINYL, P4	E,G-N ,Z	1
305	BAC27TCT0150		.DECAL-VINYL, P5	E,G-N ,Z	1
310	BAC27TCT0156		.MARKER-VINYL	E,G-N ,Z	1
315	BAC27TCT0157		.MARKER-VINYL	E,G-N ,Z	1

- Item Not Illustrated

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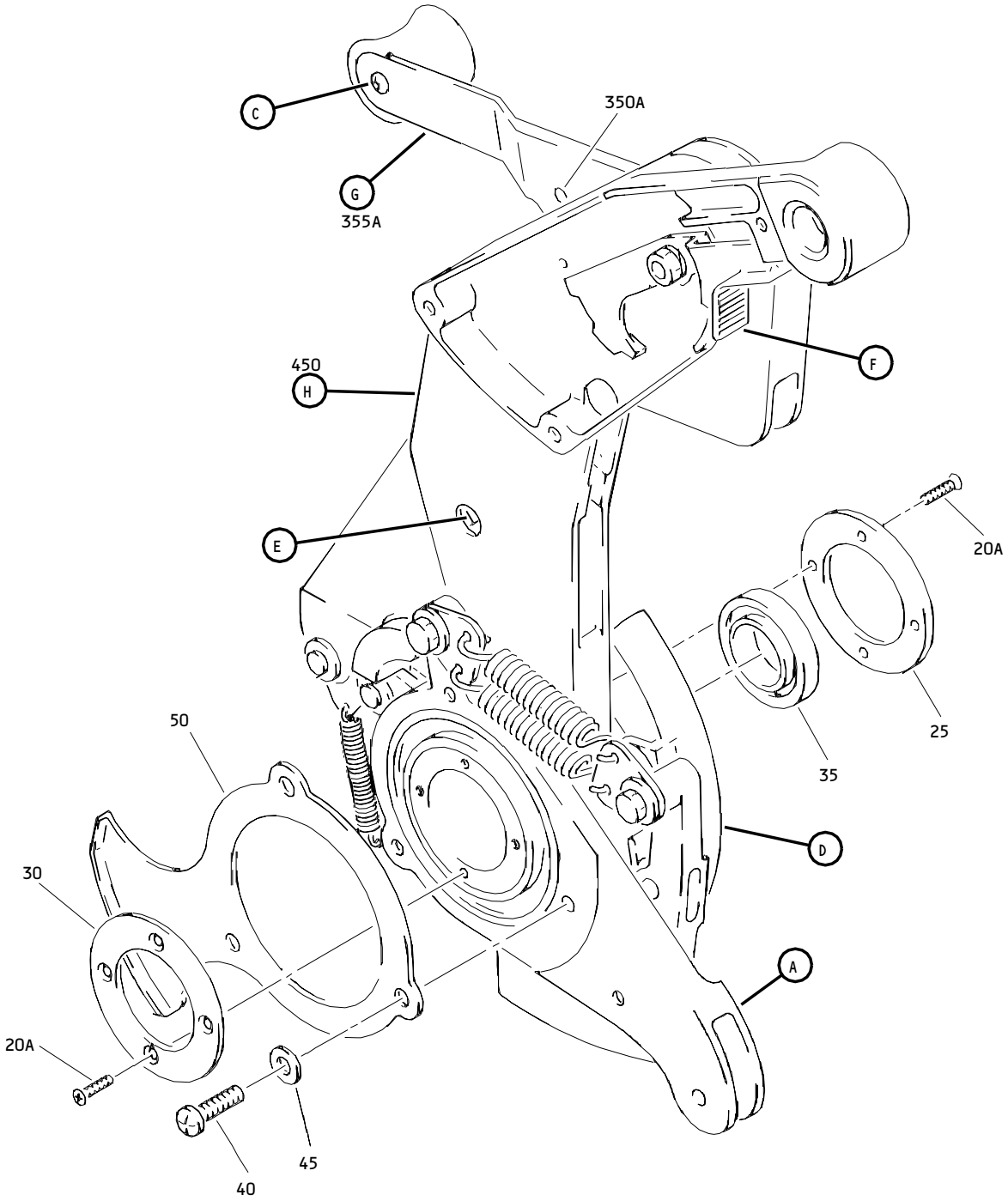

Control Stand Thrust Control Lever Assembly
Figure 4 (Sheet 1)

U6432

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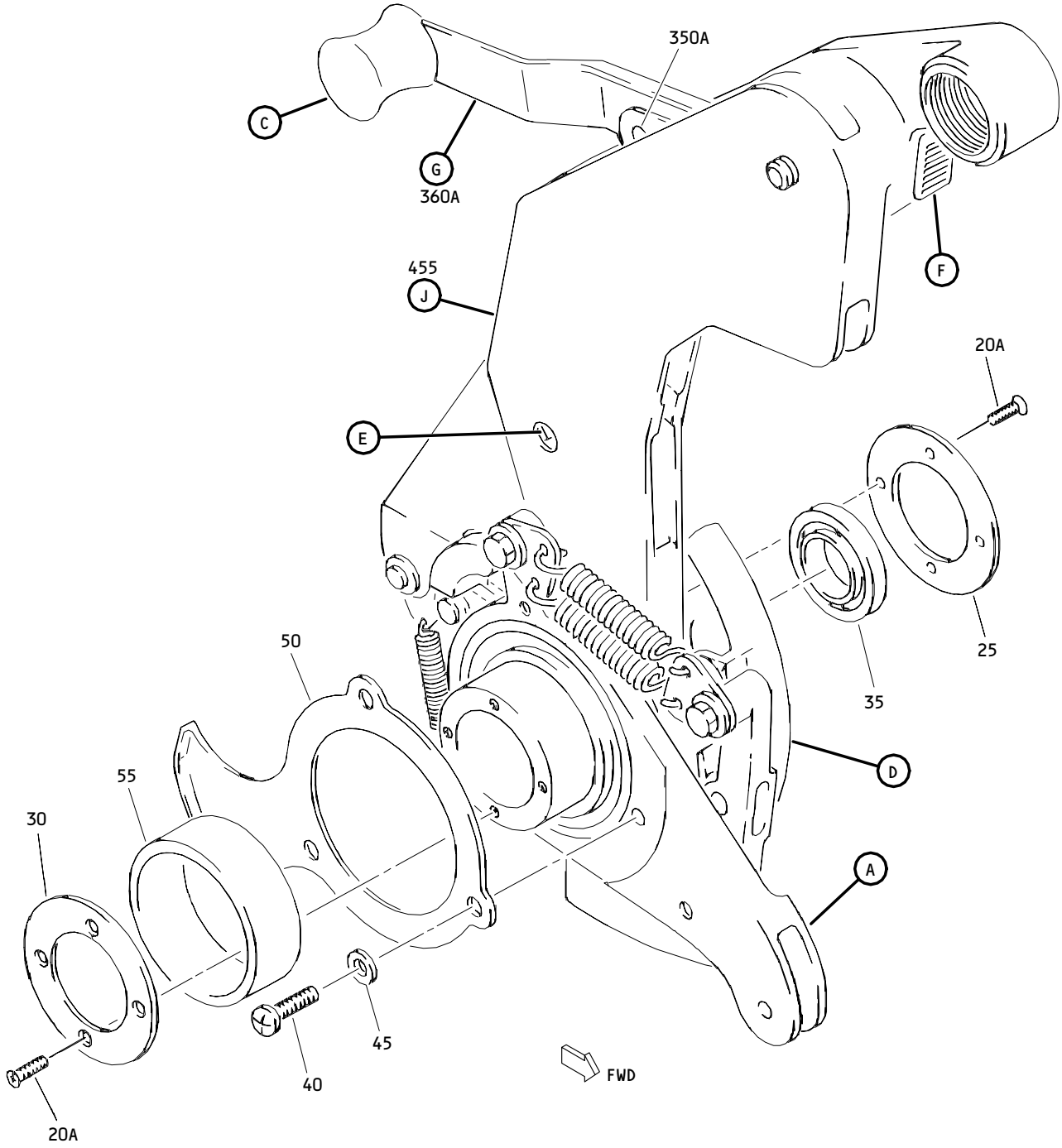

Control Stand Thrust Control Lever Assembly
Figure 4 (Sheet 2)

U6433

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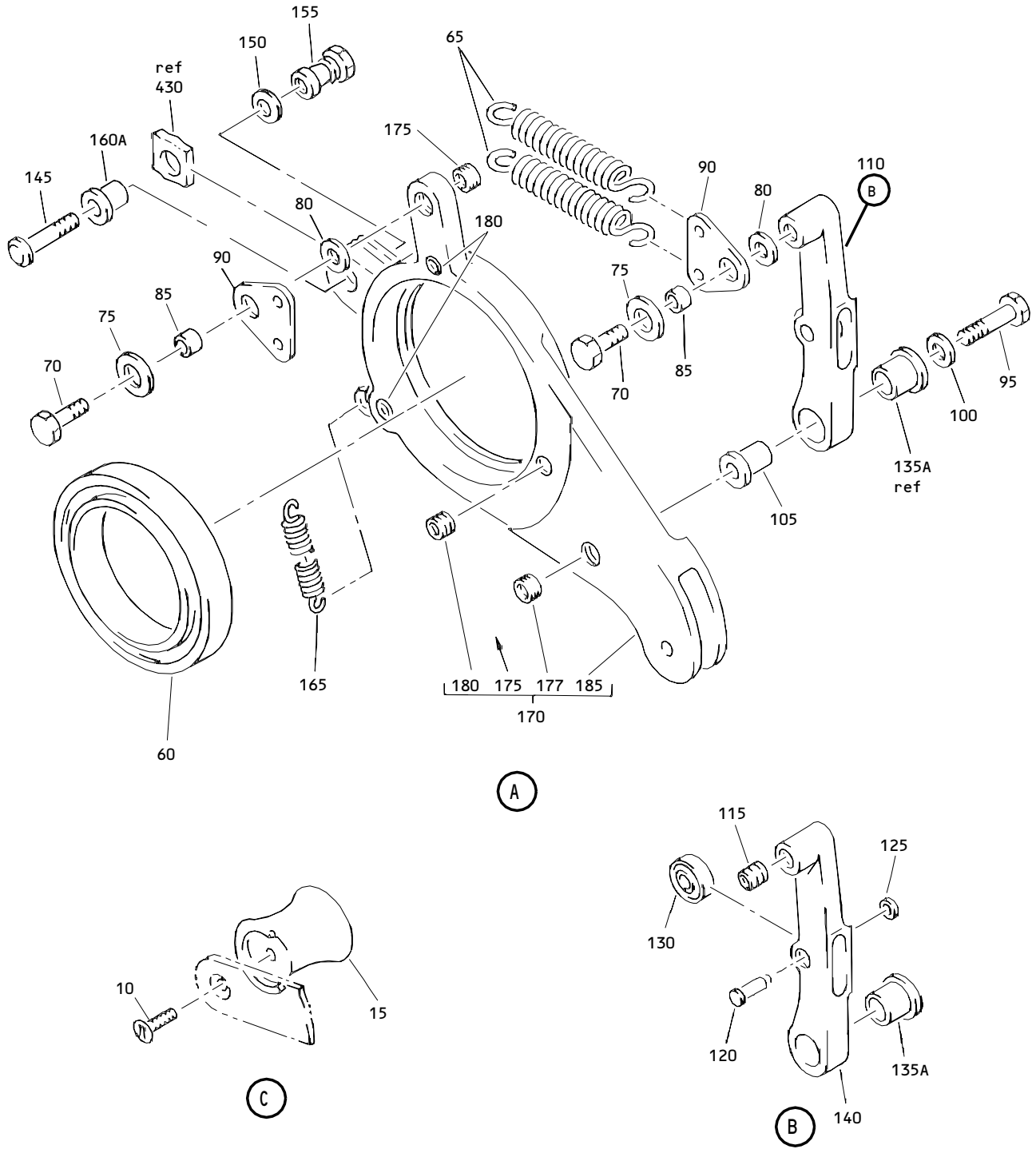

Control Stand Thrust Control Lever Assembly
Figure 4 (Sheet 3)

U6434

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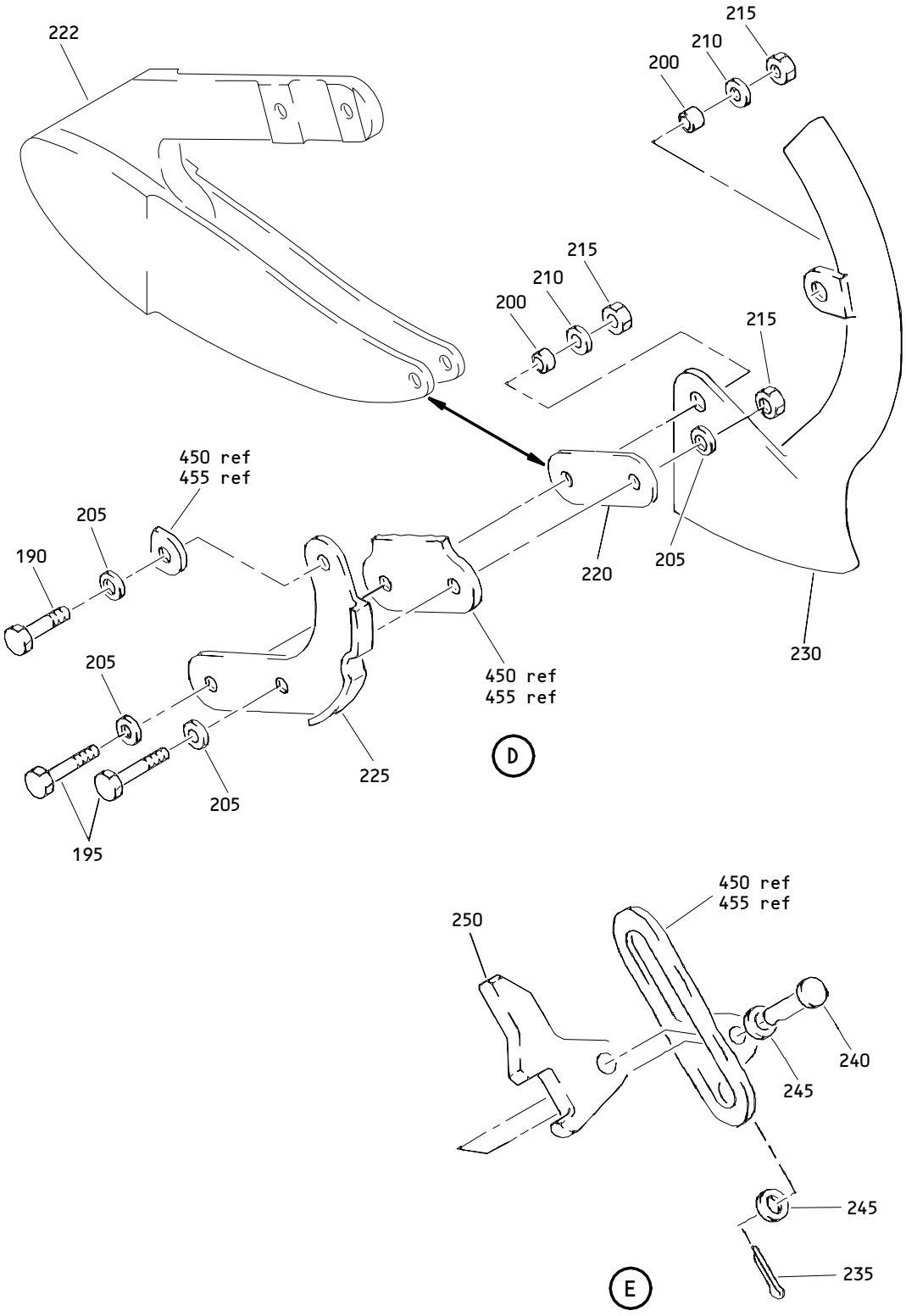

Control Stand Thrust Control Lever Assembly
Figure 4 (Sheet 4)

U6435

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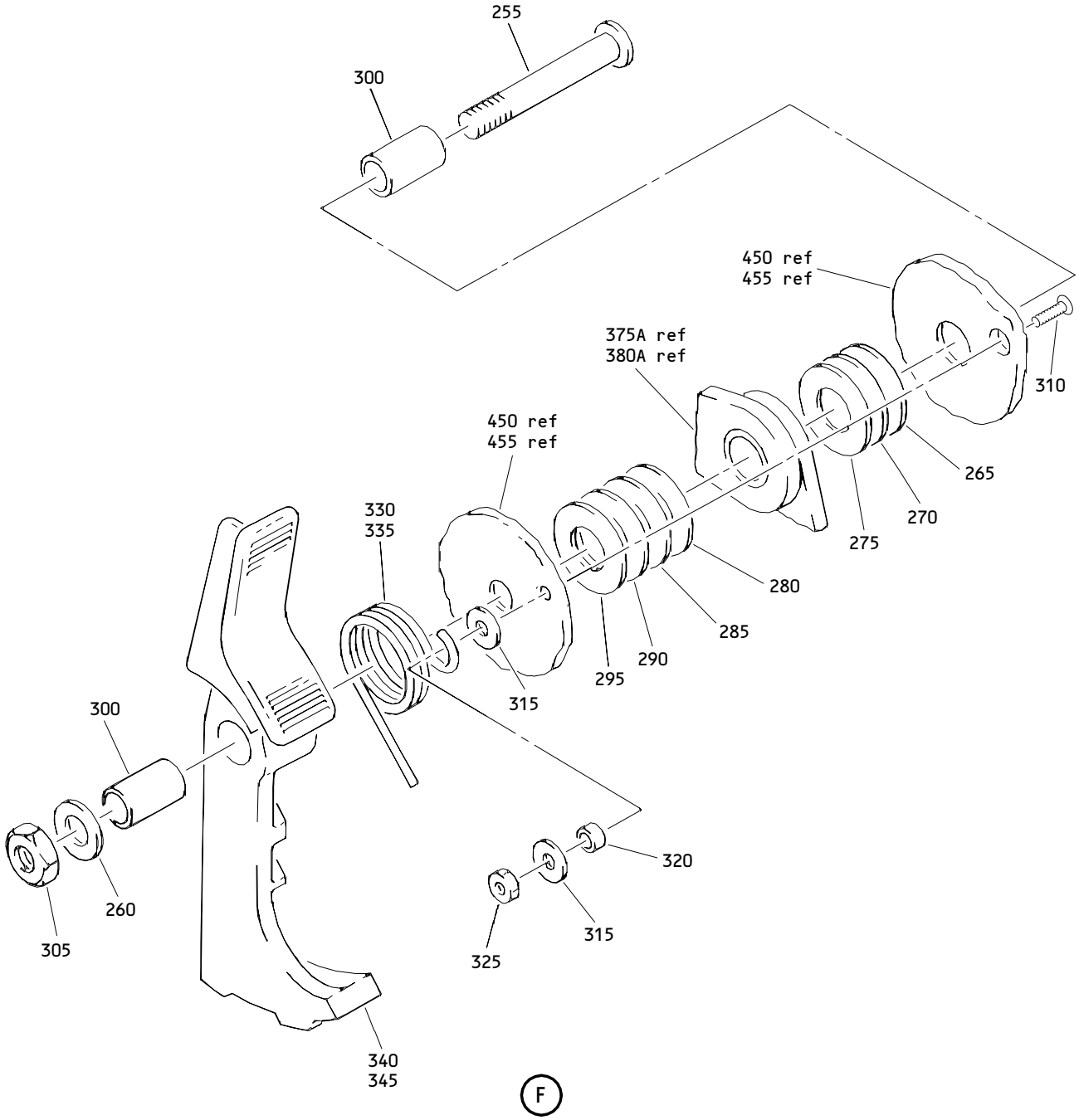

Control Stand Thrust Control Lever Assembly
Figure 4 (Sheet 5)

U6436

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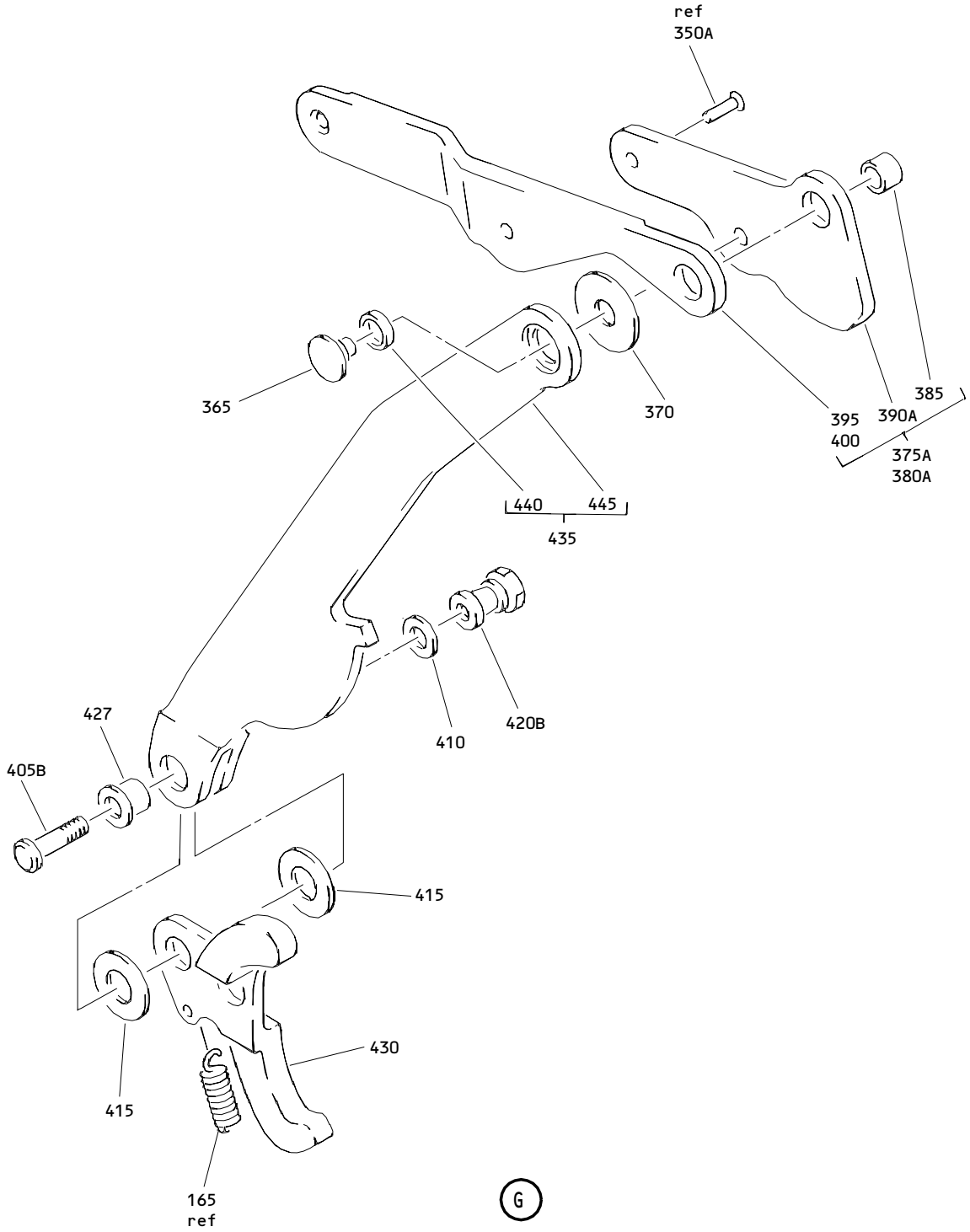

Control Stand Thrust Control Lever Assembly
Figure 4 (Sheet 6)

U6437

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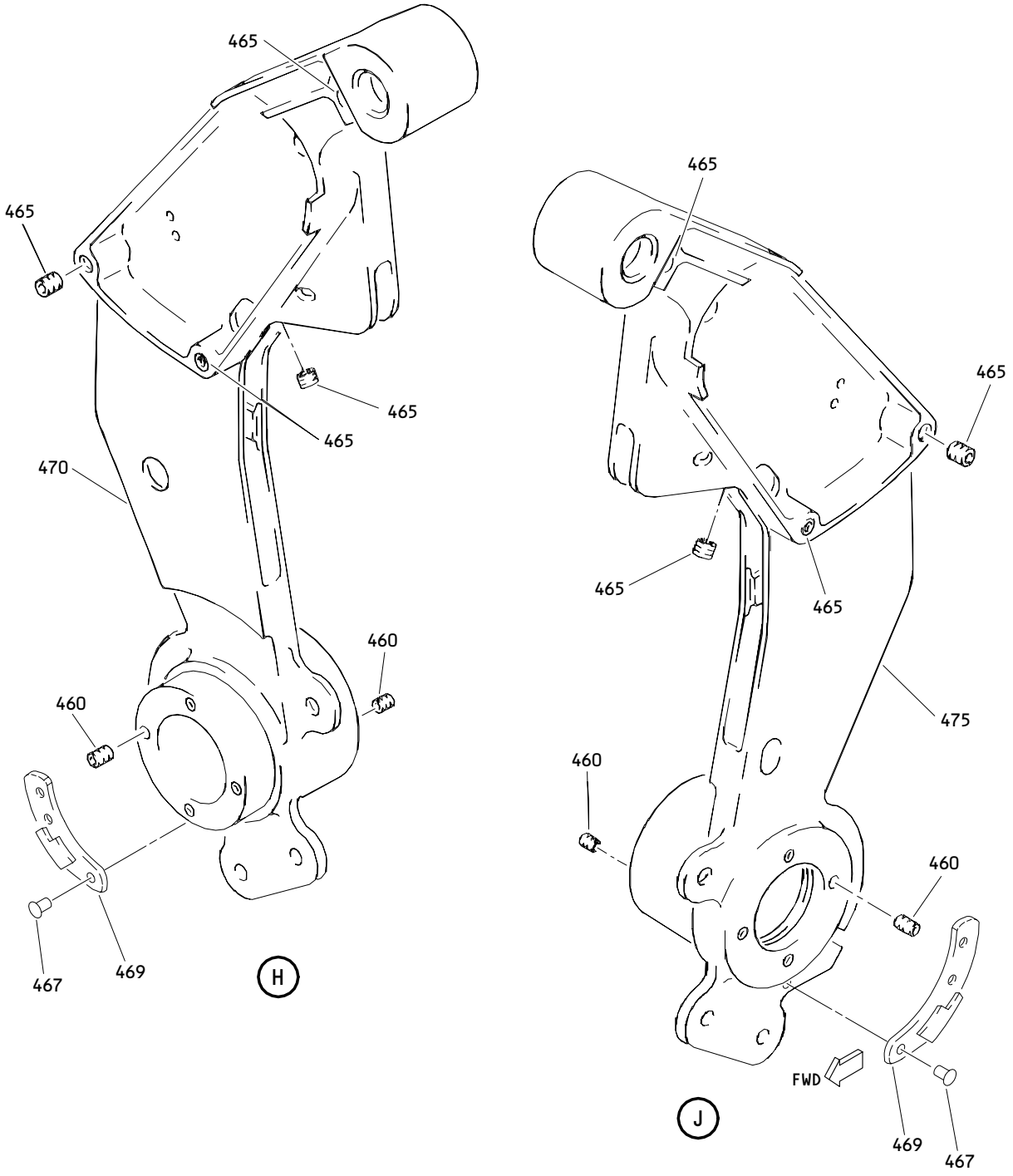

Control Stand Thrust Control Lever Assembly
Figure 4 (Sheet 7)

U6438

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
04-					
-1B	254N1131-7		LEVER ASSY-CONT STAND THRUST CONT (PRE SB 767-76-0031)	E,G	RF
-1C	254N1131-9		LEVER ASSY-CONT STAND THRUST CONT (PRE SB 767-76-0031)	E,G	RF
-1D	254N1131-11		LEVER ASSY-CONT STAND THRUST CONT (PRE SB 767-76-0031)	H-K	RF
-1E	254N1131-17		LEVER ASSY-CONT STAND THRUST CONT (POST SB 767-76-0031)	L-N	RF
-1F	015T0630-11		LEVER ASSY-CONT STAND THRUST CONT (REWORK) (POST SB 767-76-0031)	Z	RF
-1G	015T0630-15		LEVER ASSY-CONT STAND THRUST CONT (REWORK) (POST SB 767-76-0031)	Z	RF
-5B	254N1131-8		LEVER ASSY-CONT STAND THRUST CONT (PRE SB 767-76-0031)	E,G	RF
-5C	254N1131-10		LEVER ASSY-CONT STAND THRUST CONT (PRE SB 767-76-0031)	E,G	RF
-5D	254N1131-12		LEVER ASSY-CONT STAND THRUST CONT (PRE SB 767-76-0031)	H-K	RF
-5E	254N1131-18		LEVER ASSY-CONT STAND THRUST CONT (POST SB 767-76-0031)	L-N	RF
-5F	015T0630-12		LEVER ASSY-CONT STAND THRUST CONT (POST SB 767-76-0031)	Z	RF
-5G	015T0630-16		LEVER ASSY-CONT STAND THRUST CONT (REWORK) (POST SB 767-76-0031)	Z	RF

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
04-					
10	BACS12BP3-8		.SCREW	E,G-N ,Z	1
15	65C14183-46		.KNOB	E,G-N ,Z	1
20A	NAS514P440-5		.SCREW	E,G-N ,Z	8
25	253T5812-3		.RETAINER-BRG	E,G-N ,Z	1
30	253T5812-4		.RETAINER-BRG	E,G-N ,Z	1
35	MB539DDNJC		.BEARING- (V06144) (SPEC BACB10AS12) (OPT LLMB539 (V38443)) (OPT MB539-2TS (V43991)) (OPT MB539DDFS428 (V21335)) (OPT MB539TT (V43991)) (OPT MB539DDG20 (V38443)) (OPT MT339E (VK8455)) (OPT MB539DDLY196 (V40920)) (OPT MB539DD (V06144)) (OPT NB539DDSD610 (V83086))	E,G-N ,Z	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
04-					
40	NAS601-4		.SCREW	E,G-N ,Z	3
45	AN960D6L		.WASHER	E,G-N ,Z	3
50	253T5835-1		.CAM	E,G-N ,Z	1
55	253T4006-12		.SPACER- (USED ON ITEMS 5B, 5C, 5D, 5F, 5G)	E,G-N ,Z	1
60	MKP29BNJC		.BEARING- (V06144) (SPEC BACB10AU29) (OPT MKP29BSD610 (V83086)) (OPT MKP29BTT (V43991)) (OPT MKP29B2TS (V43991)) (OPT MKP16BE9273-29 (V21335)) (OPT LLMKP29B1 (V38443)) (OPT MKP29BFS428 (V21335)) (OPT MKP29B1G20 (V38443)) (OPT MKP29BLY196 (V40920)) (OPT MKP29B (V06144))	E,G-N ,Z	1
65	MS24586-698		.SPRING	E,G-N ,Z	2
70	NAS6603-1		.BOLT	E,G-N ,Z	2
75	AN960C516L		.WASHER	E,G-N ,Z	2
80	AN960C10L		.WASHER	E,G-N ,Z	2
85	BACB28Y3C010		.BUSHING	E,G-N ,Z	2
90	253T5832-1		.PLATE	E,G-N ,Z	2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
04-					
95	NAS6603-6		.BOLT	E,G-N ,Z	1
100	AN960C10L		.WASHER	E,G-N ,Z	1
105	BACB28X3M040		.BUSHING	E,G-N ,Z	1
110	253T5833-1		.FOLLOWER ASSY	E,G,Z	1
-110A	253T5833-1		.FOLLOWER ASSY- (OPT ITEM 110B)	H-N	1
-110B	254N1205-1		.FOLLOWER ASSY- (OPT ITEM 110A)	H-N	1
115	MS21209F1-15		..INSERT	E,G-N ,Z	1
120	253T5831-1		..RIVET	E,G-N ,Z	1
125	69B14373-3		..WASHER	E,G-N ,Z	1
130	KP3ALP		..BEARING- (V21760) (SPEC BACB10BG1M) (OPT KP3ALE6531 (V21335)) (OPT KP3ALFS428 (V21335)) (OPT KP3ALTT (V43991)) (OPT KP3ALT1C1-01 (V21760)) (OPT LLKP3AL (V38443)) (OPT KP3ALG20 (V38443)) (OPT CS203AE (VK8455)) (OPT KP3ALSD610 (V83086)) (OPT KP3ALE (V21760)) (OPT KP3AL (V38443))	E,G-N ,Z	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
04-					
135	DBAF5-184		DELETED		
135A	KJB60516-327		..BUSHING- (V50632) (SPEC 10-60516-327) (OPT 90792 (V09455)) (OPT AJF05A109 (VS0352)) (OPT FBR05A11BA (V73134)) (OPT KJN5-22 (V97613)) (OPT NHF05-203A (V15860)) (OPT YTS754 (V77896)) (OPT DBAF5-184 (V81376))	E,G-N ,Z	1
140	253T5833-2		..FOLLOWER- (USED ON ITEMS 110,110A)	E,G-N ,Z	1
-140A	254N1205-2		..FOLLOWER- (USED ON ITEM 110B)	H-N	1
145	HL441UC6-8		.BOLT- (V60516) (SPEC BACB30FM6A8) (OPT HL440UC6-8 (V73197)) (OPT HL440UC6-8 (V92215)) (OPT HL440UC6-8 (V97928)) (OPT HL440UC6-8 (V80539)) (OPT WC130-6-8 (V60516)) (OPT 67067-6A8 (V56878)) (OPT L8056A8 (V06725)) (OPT HL440UC6-8 (V56878))	E,G-N ,Z	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
04-					
150	AN960C10L		.WASHER	E,G-N,Z	1
155	HL79-6		.COLLAR- (V5M902) (SPEC BACC30M6) (OPT HL79-6 (V73197)) (OPT HL79-6 (V92215)) (OPT 66014-6 (V56878)) (OPT HL79-6 (V56878))	E,G-N,Z	1
160A	254N1177-2		.BUSHING	E,G-N,Z	1
165	MS24586C61		.SPRING	E,G-N,Z	1
170	254N1176-1		.CRANK ASSY	E,G-N,Z	1
175	MS21209F1-10		..INSERT	E,G-N,Z	1
177	MS21209F1-15		..INSERT	E,G-N,Z	1
180	MS21209C0610		..INSERT	E,G-N,Z	3
185	254N1176-2		..CRANK	E,G-N,Z	1
190	NAS6603-4		.BOLT	E,G-N,Z	1
195	NAS6603-7		.BOLT	E,G-N,Z	2
200	NAS1056C6-011		.SPACER	E,G-N,Z	2
205	AN960C10L		.WASHER	E,G-N,Z	4

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
04-					
210	BACW10P5C		.WASHER	E,G-N,Z	2
215	H10-3BAC		.NUT- (V15653) (SPEC BACN10JC3) (OPT NS202101-02 (V80539)) (OPT RMLH9075-3W (V72962)) (OPT T6S1032J (V71087)) (OPT VN303A02 (V92215)) (OPT 96-02 (V80539)) (OPT BRH10A3 (V52828))	E,G-N,Z	3
220	253T5822-1		.SHIM- (USED ON ITEMS 1B, 5B, 1F, 5F)	E,G,Z	1
222	254N1141-1		.COUNTERWEIGHT- (USED ON ITEMS 1C, 1D, 1E, 1G, 5C, 5D, 5E, 5G)	E,G-N,Z	1
225	253T5834-1		.CAM-DETENT	E,G,Z	1
-225A	253T5834-1		.CAM-DETENT (OPT ITEM 225B)	H-N	1
-225B	254N1212-1		.CAM-DETENT (OPT ITEM 225A)	H-N	1
230	254N1180-1		.SHIELD-WIRE	E,G-N,Z	1
235	MS24665-151		.PIN-COTTER	E,G-K,Z	1
240	MS20392-1C15		.PIN-DRILLED SHANK	E,G-K,Z	1
-240A	254N1703-1		.PIN-DRILLED SHANK	L-N	1
245	NAS620C5L		.WASHER	E,G-K,Z	2
250	69B81942-2		.LATCH	E,G-N,Z	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
04- 255	HL40-6-15		.BOLT- (V97928) (SPEC BACB30FM6A15U) (OPT 67067-6A15U (V56878)) (OPT HL40-6-15 (V56878)) (OPT HL40-6-15 (V73197)) (OPT HL40-6-15 (V80539)) (OPT HL40-6-15 (V92215)) (OPT WC36-6-15 (V60516)) (OPT HL40-6-15 (V60516))	E,G-N ,Z	1
260	AN960D10L		.WASHER	E,G-N ,Z	1
265	254N1144-2		.WASHER	E,G-N ,Z	AR
270	254N1144-3		.WASHER	E,G-N ,Z	AR
275	254N1144-5		.WASHER	E,G-N ,Z	AR
280	254N1144-6		.WASHER	E,G-N ,Z	AR
285	254N1144-7		.WASHER	E,G-N ,Z	AR
290	254N1144-8		.WASHER	E,G-N ,Z	AR
295	254N1144-9		.WASHER	E,G-N ,Z	AR
300	BACB28Y3F046		.BUSHING	E,G-N ,Z	2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
04-					
305	H10-3BAC		.NUT- (V15653) (SPEC BACN10JC3) (OPT NS202101-02 (V80539)) (OPT RMLH9075-3W (V72962)) (OPT T6S1032J (V71087)) (OPT VN303A02 (V92215)) (OPT 96-02 (V80539)) (OPT BRH10A3 (V52828))	E,G-N ,Z	1
310	NAS514P440-6		.SCREW	E,G-N ,Z	1
315	AN960C4L		.WASHER	E,G-N ,Z	2
320	NAS1057T0-010		.SPACER	E,G-N ,Z	1
325	H10-04BAC		.NUT- (V15653) (SPEC BACN10JC04) (OPT NS202101-40 (V80539)) (OPT RMLH9075-40W (V72962)) (OPT T6S440J (V11815)) (OPT VN303A40 (V92215)) (OPT 96-40 (V80539)) (OPT BRH10A04 (V52828))	E,G-N ,Z	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
04-					
330	254N1179-1		.SPRING- (USED ON ITEMS 1B, 1C, 1F, 1G)	E,G,Z	1
-330A	254N1179-3		.SPRING- (USED ON ITEMS 1E)	L-N	1
-330B	254N1179-1		.SPRING- (OPT ITEM 330C) (USED ON ITEM 1D)	H-K	1
-330C	254N1179-3		.SPRING- (OPT ITEM 330B) (USED ON ITEM 1D)	H-K	1
335	254N1179-2		.SPRING- (USED ON ITEMS 5B, 5C, 5F, 5G)	E,G,Z	1
-335A	254N1179-4		.SPRING- (USED ON ITEMS 5E)	L-N	1
-335B	254N1179-2		.SPRING- (OPT ITEM 335C) (USED ON ITEM 5D)	H-K	1
-335C	254N1179-4		.SPRING- (OPT ITEM 335B) (USED ON ITEM 5D)	H-K	1
340	254N1175-1		.TRIGGER- (USED ON ITEMS 1B, 1C, 1D, 1E, 1F, 1G)	E,G-N,Z	1
345	254N1175-2		.TRIGGER- (USED ON ITEMS 5B, 5C, 5D, 5E, 5F, 5G)	E,G-N,Z	1
350A	MS20427M4-5		.RIVET	E,G-N,Z	1
355A	254N1134-5		.LINK ASSY- (USED ON ITEMS 1B, 1C) (PRE SB 767-76-0031)	E,G,Z	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
04-					
-355B	254N1210-1		.LINK ASSY- (USED ON ITEM 1D) (PRE SB 767-76-0031)	H-K	1
-355C	254N1210-5		.LINK ASSY- (USED ON ITEM 1E) (POST SB 767-76-0031)	L-N	1
-355D	015T0630-13		.LINK ASSY- (USED ON ITEMS 1F, 1G) (POST SB 767-76-0031)	Z	1
360A	254N1134-6		.LEVER- (USED ON ITEMS 5B, 5C) (PRE SB 767-76-0031)	E,G	1
-360B	254N1210-2		.LINK ASSY- (USED ON ITEM 5D) (PRE SB 767-76-0031)	H-K	1
-360C	254N1210-6		.LINK ASSY- (USED ON ITEM 5E) (POST SB 767-76-0031)	L-N	1
-360D	015T0630-14		.LEVER- (USED ON ITEMS 5F, 5G) (POST SB 767-76-0031)	Z	1
365	254N1171-1		..RIVET	E,G-N	1
370	254N1144-1		..WASHER	E,G-N	1
375A	254N1174-7		..LEVER ASSY- (USED ON ITEMS 355A, 355B)	E,G-K	1
-375B	254N1174-13		..LEVER ASSY- (USED ON ITEMS 355C)	L-N	1
380A	254N1174-8		..LEVER ASSY- (USED ON ITEMS 360A, 360B)	E,G-K	1
-380B	254N1174-14		..LEVER ASSY- (USED ON ITEMS 360C)	L-N	1
385	BACB28U5E022		...BUSHING	E,G-N	1
390A	254N1181-2		...ARM	E,G-K	1
-390B	254N1181-4		...ARM	L-N	1
395	254N1174-3		...LEVER- (USED ON ITEM 375A)	E,G-K	1
-395A	254N1174-9		...LEVER- (USED ON ITEM 375B)	L-N	1
400	254N1174-4		...LEVER- (USED ON ITEM 380A)	E,G-K	1
-400A	254N1174-10		...LEVER- (USED ON ITEM 380B)	L-N	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
04-					
405B	HL448DU6-10		..BOLT- (V60516) (SPEC BACB30MB6A10SU) (OPT HL48DU6-10 (V73197)) (OPT HL48DU6-10 (V92215)) (OPT HL48DU6-10 (V97928)) (OPT HL48DU6-10 (V80539)) (OPT HL48DU6-10 (V08524)) (OPT HL48DU6-10 (V9N513)) (OPT HL48DU6-10 (V56878)) (OPT HL448DU6-10 (V56878)) (OPT HL448DU6-10 (V73197)) (OPT HL448DU6-10 (V80539)) (OPT HL448DU6-10 (V9N513)) (OPT HL448DU6-10 (V97928))	E,G-N	1
410	AN960C10L		..WASHER	E,G-N	1
415	254N1144-11		..WASHER	E,G-N	2
420B	HL1187DU6		..COLLAR- (V5M902) (SPEC BACC30X6S) (OPT HL87DU6 (V73197)) (OPT HL87DU6 (V92215)) (OPT HL1187DU6 (V56878)) (OPT HL1187DU6 (V92215)) (OPT HL87DU6 (V56878)) (OPT HL1187DU6 (V73197))	E,G-N	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
04-					
427	254N1177-2		..BUSHING- (USED ON ITEMS 355A, 360A, 355C, 360C)	E,G-N	1
430	254N1137-1		..LATCH	E,G	1
-430A	253T5827-1		..LATCH	H-N	1
435	254N1136-1		..LINK ASSY	E,G-K	1
-435A	254N1136-4		..LINK ASSY	L-N	1
440	BACB28Y6E009		...BUSHING	E,G-N	1
445	254N1136-2		...LINK	E,G-K	1
-445A	254N1136-5		...LINK	L-N	1
450	254N1132-1		.LEVER ASSY- (USED ON ITEMS 1B, 1C, 1F, 1G)	E,G,Z	1
-450A	254N1132-13		.LEVER ASSY- (USED ON ITEM 1D)	H-K	1
-450B	254N1132-17		.LEVER ASSY- (USED ON ITEM 1E)	L-N	1
455	254N1132-2		.LEVER ASSY- (USED ON ITEMS 5B, 5C, 5F, 5G)	E,G,Z	1
-455A	254N1132-14		.LEVER ASSY- (USED ON ITEM 5D)	H-K	1
-455B	254N1132-18		.LEVER ASSY- (USED ON ITEM 5E)	L-N	1
460	MS21209C0415		..INSERT	E,G-N,Z	8
465	MS21209C0610		..INSERT	E,G-N,Z	4
467	MS20427M5		..RIVET	H-K	3

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
04-					
-467A	MS20427M5		..RIVET- (OPT ITEM 467B) (SIZE DETERMINE ON INST) (NHA 254N1132)	L-N	3
-467B	MS206155M		..RIVET- (OPT ITEM 467A) (SIZE DETERMINE ON INST) (NHA 254N1132)	L-N	3
469	254N1721-1		..INSERT- (OPT ITEM 469A)	H-N	1
-469A	254N1721-2		..INSERT- (OPT ITEM 469)	H-N	1
470	254N1132-5		..LEVER- (USED ON ITEM 450)	E,G	1
-470A	254N1132-15		..LEVER- (USED ON ITEM 450A)	H-K	1
-470B	254N1132-19		..LEVER- (USED ON ITEM 450B)	L-N	1
475	254N1132-6		..LEVER- (USED ON ITEM 455)	E,G	1
-475A	254N1132-16		..LEVER- (USED ON ITEM 455A)	H-K	1
-475B	254N1132-20		..LEVER- (USED ON ITEM 455B)	L-N	1

- Item Not Illustrated

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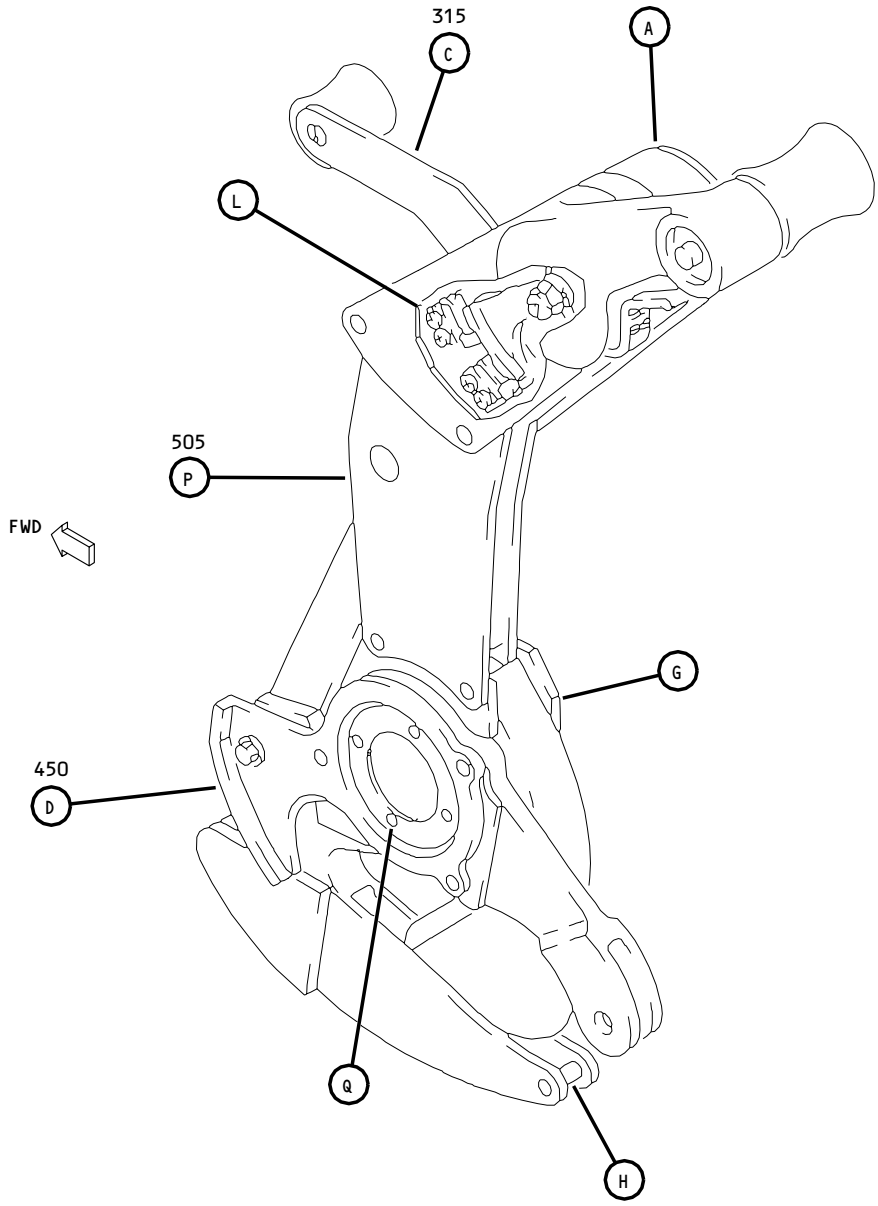

Control Stand Thrust Lever Assembly
Figure 5 (Sheet 1)

A15973

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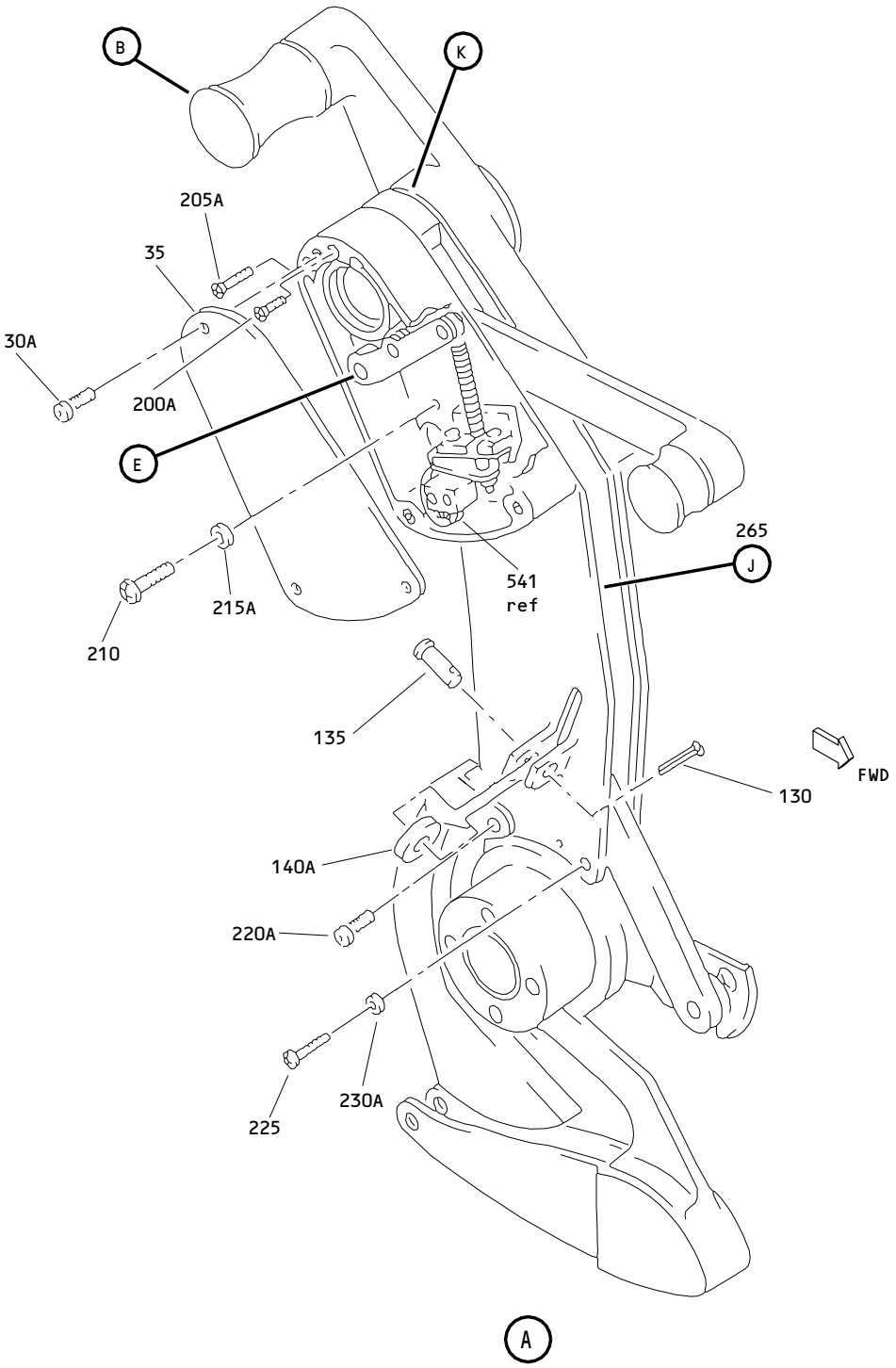

Control Stand Thrust Lever Assembly
Figure 5 (Sheet 2)

A15974

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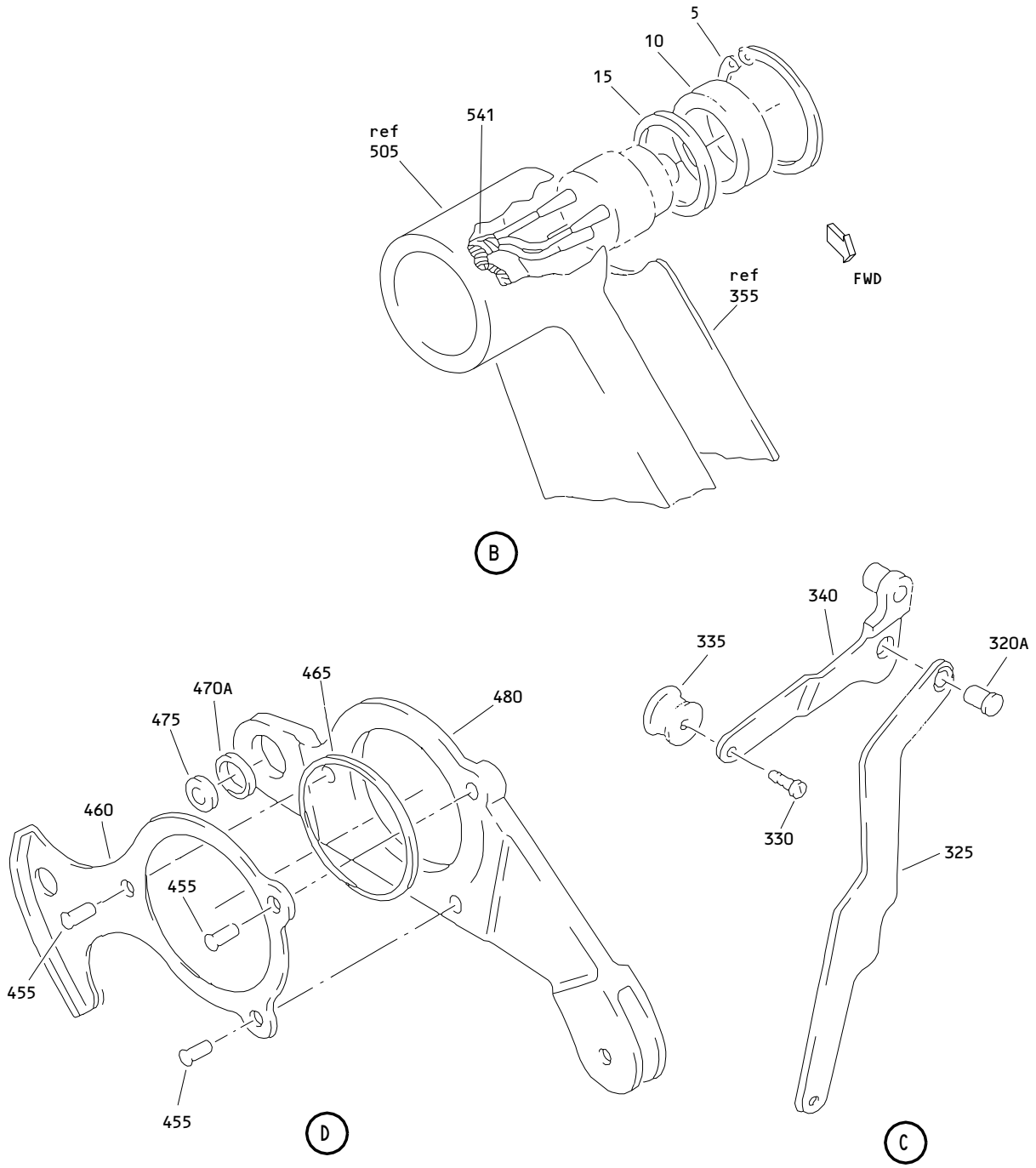

Control Stand Thrust Lever Assembly
Figure 5 (Sheet 3)

A15975

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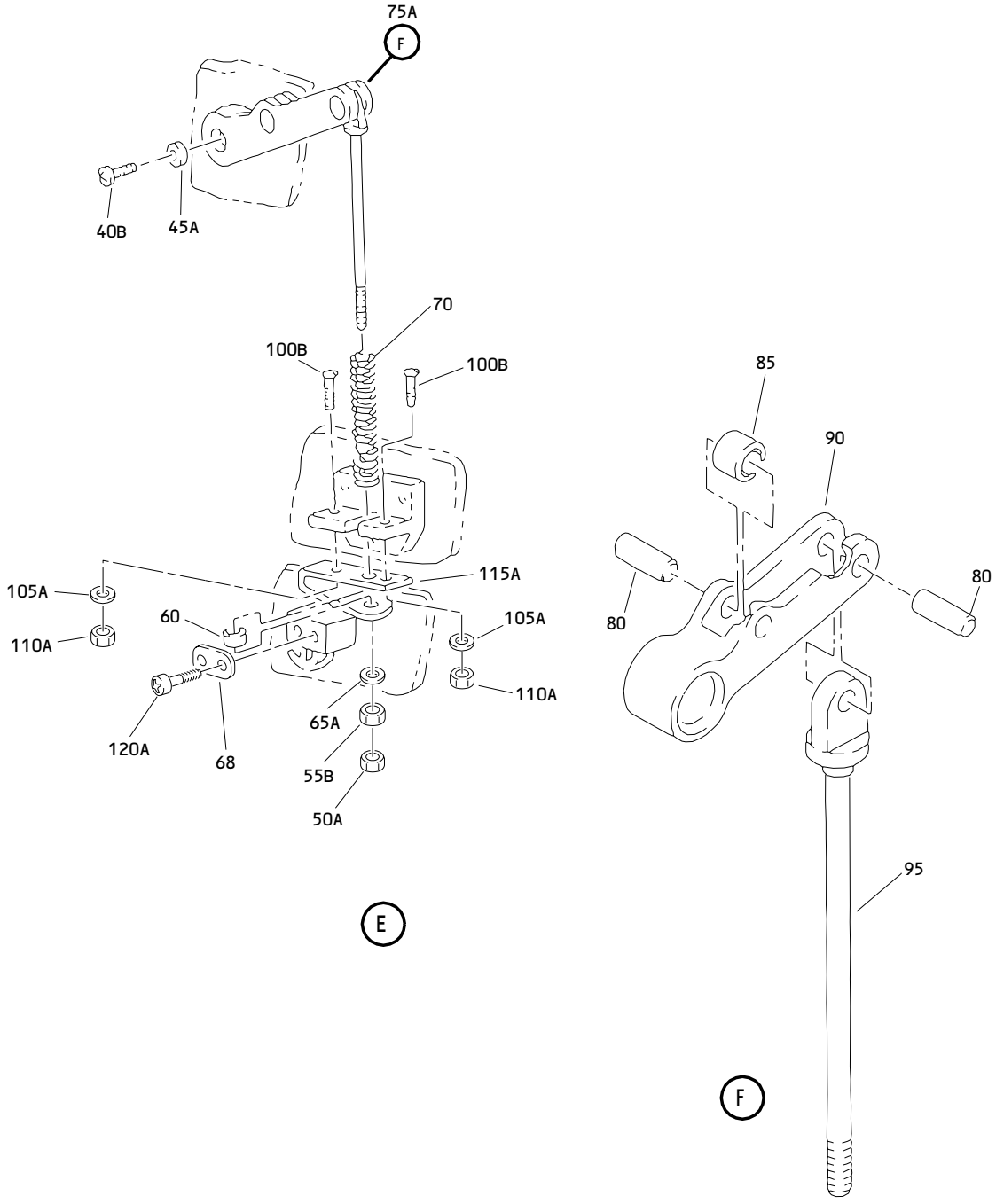

Control Stand Thrust Lever Assembly
Figure 5 (Sheet 4)

A15976

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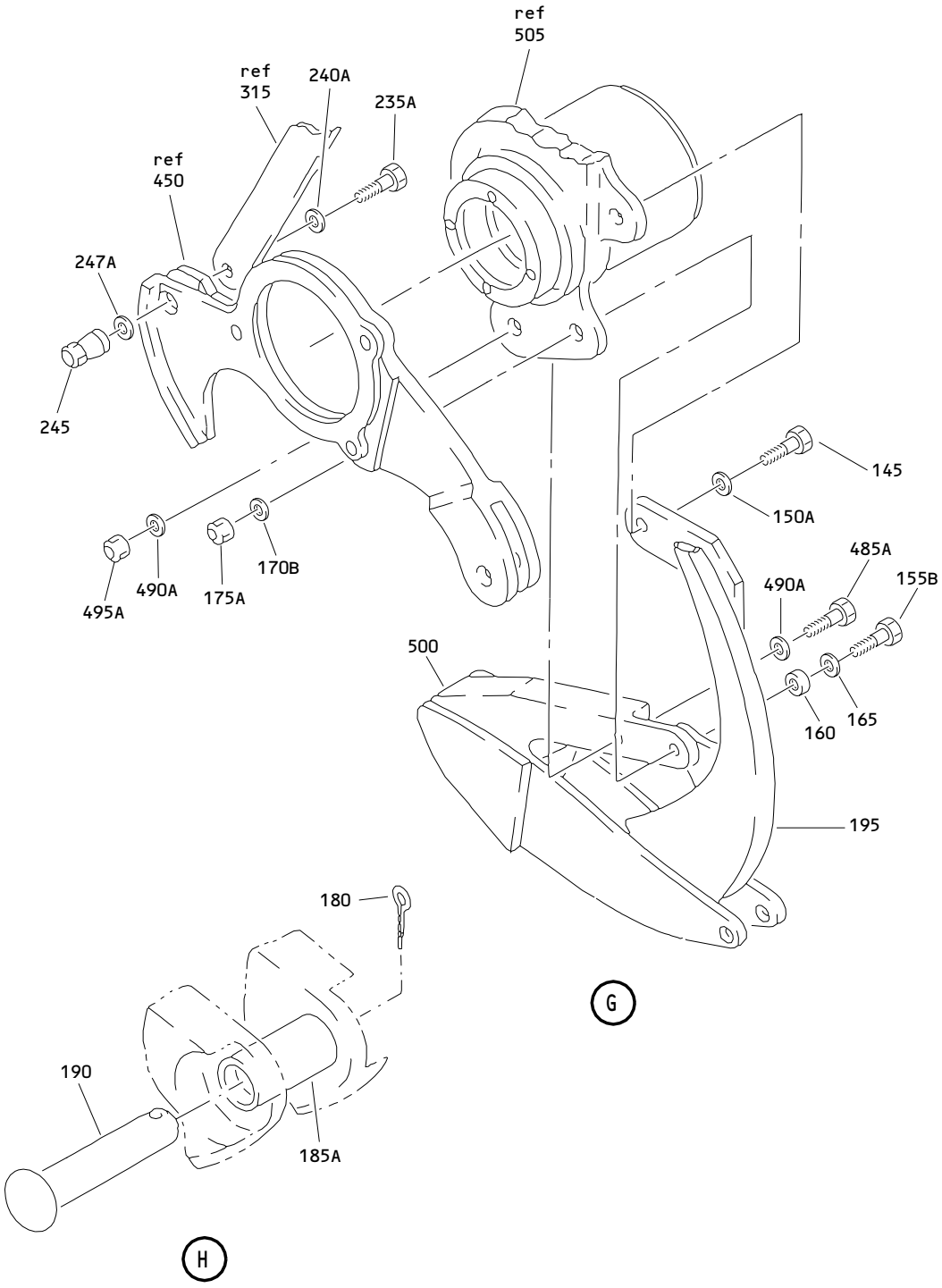

Control Stand Thrust Lever Assembly
Figure 5 (Sheet 5)

A16066

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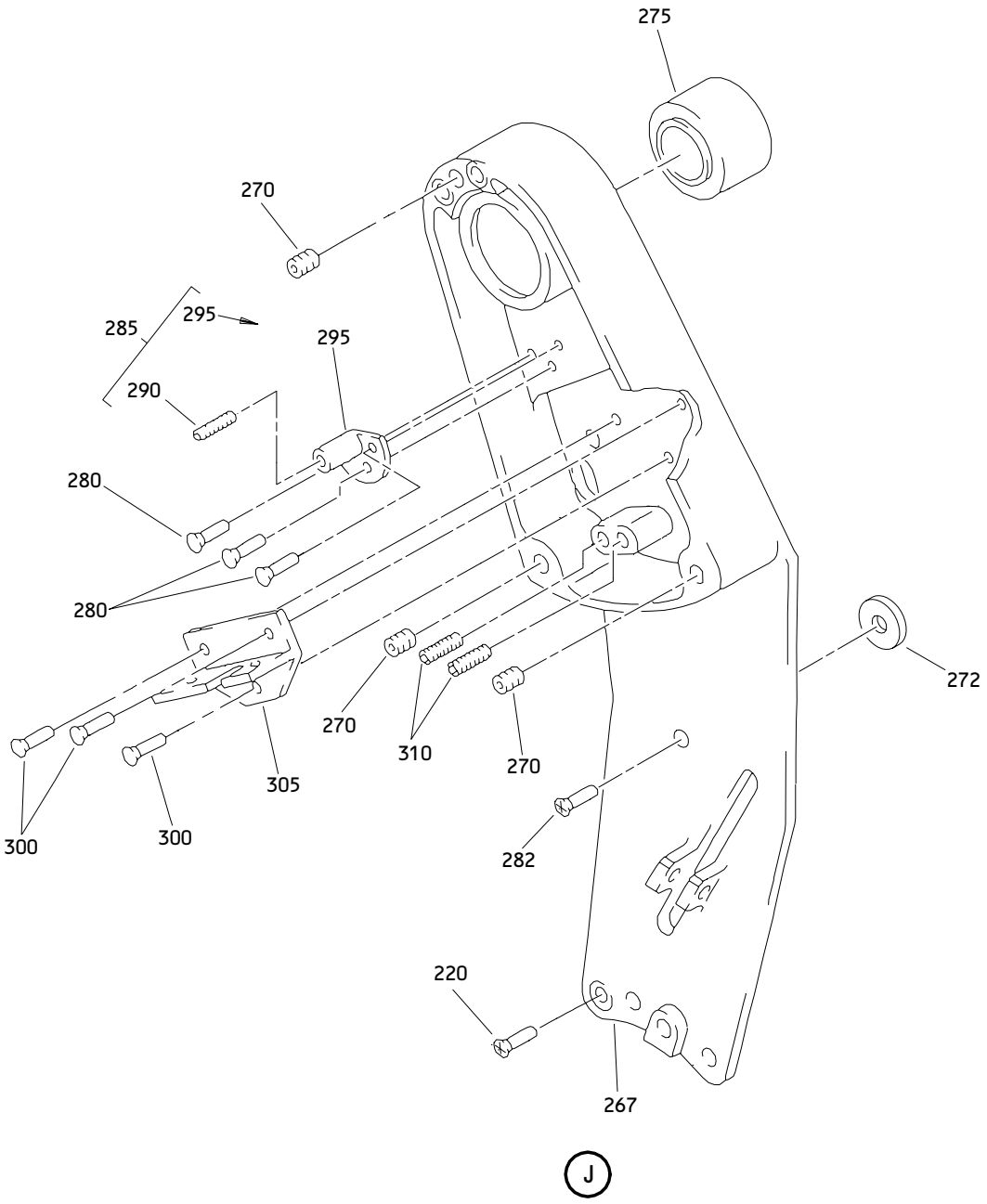

Control Stand Thrust Lever Assembly
Figure 5 (Sheet 6)

A15978

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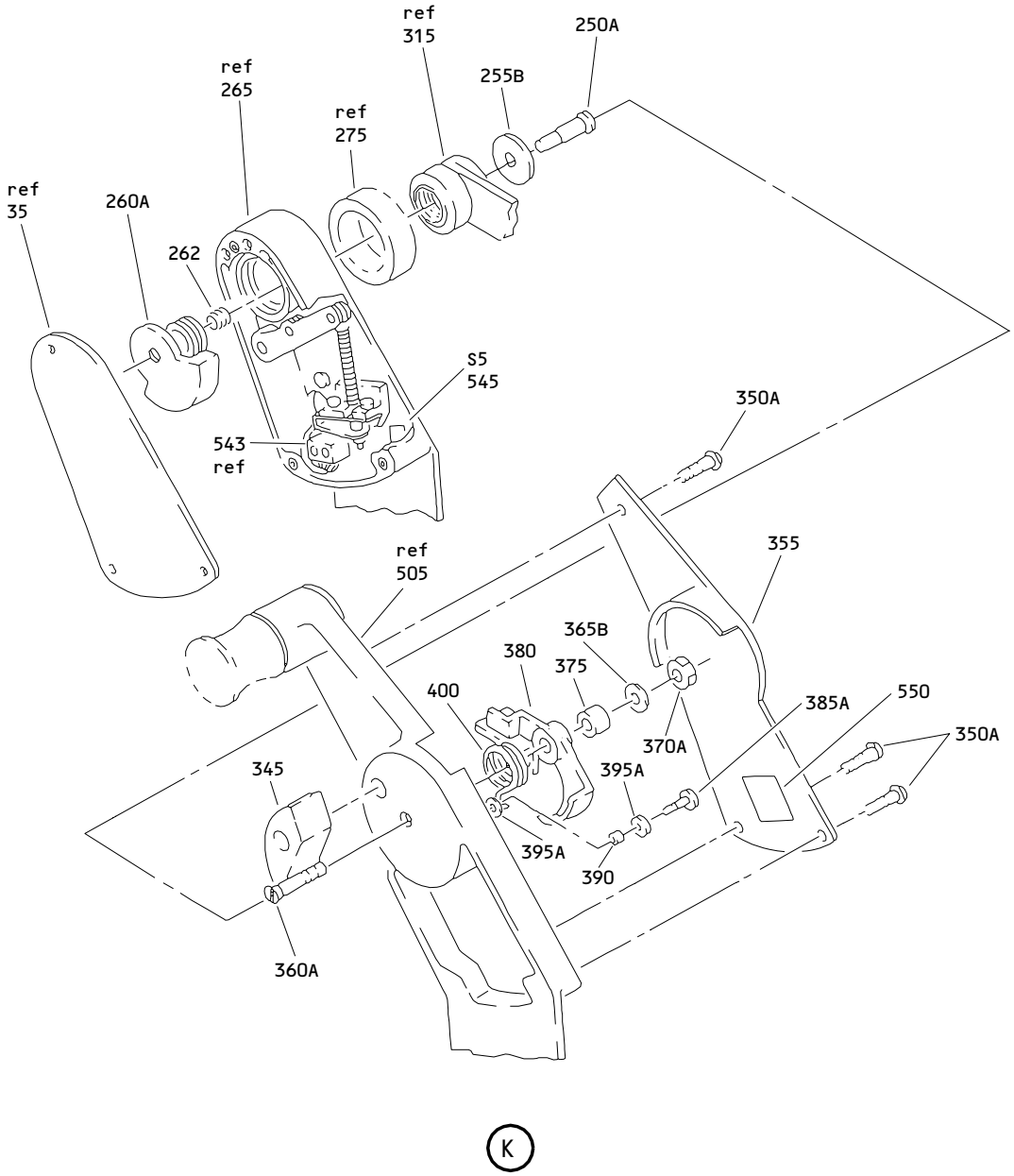

Control Stand Thrust Lever Assembly
Figure 5 (Sheet 7)

A16067

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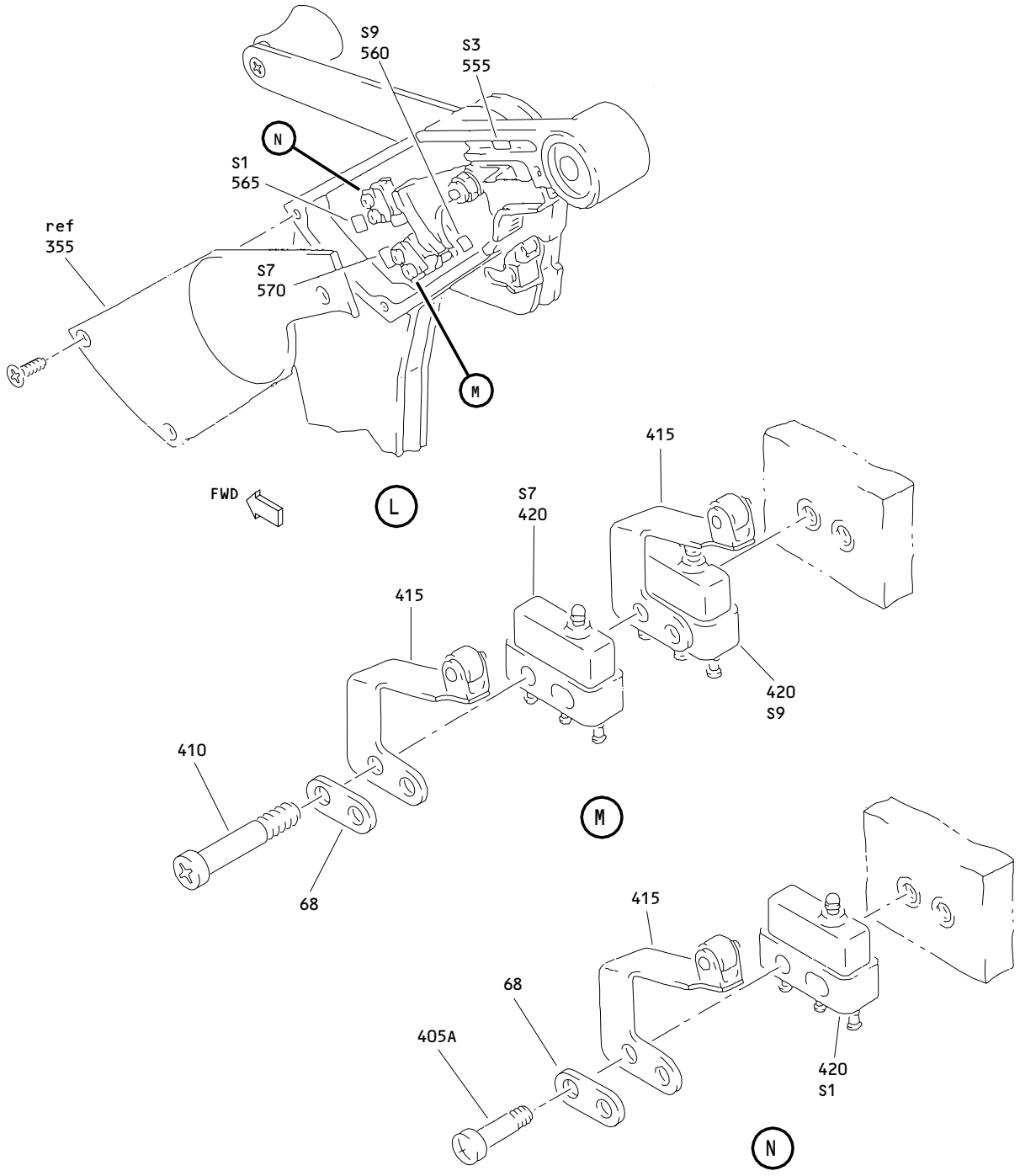

Control Stand Thrust Lever Assembly
Figure 5 (Sheet 8)

A16069

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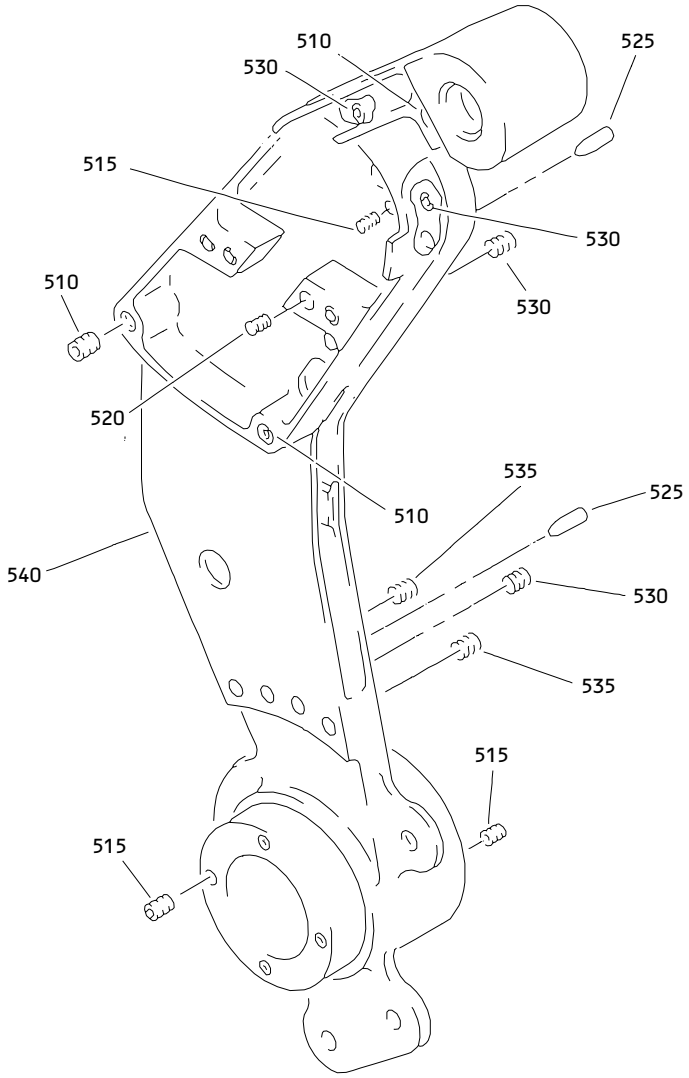

P

Control Stand Thrust Lever Assembly
Figure 5 (Sheet 9)

A15979

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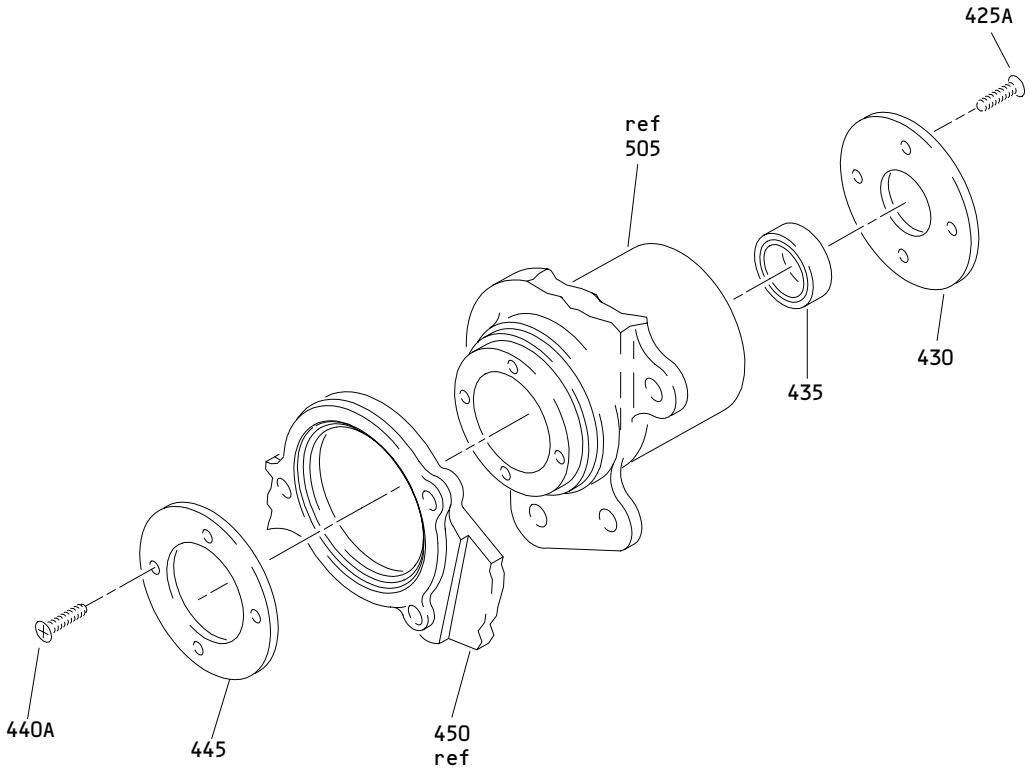

Control Stand Thrust Lever Assembly
Figure 5 (Sheet 10)

A15937

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
05-					
-1	253T5852-1		LEVER ASSY-CONT STAND THRUST	P	RF
-1A	253T5852-3		LEVER ASSY-CONT STAND THRUST	Q	RF
-1B	253T5852-5		LEVER ASSY-CONT STAND THRUST	R	RF
5	MS16625-4086		.RING	P-R	1
10	69-35353-3		.RETAINER	P-R	1
15	MS28775-114		.PACKING	P-R	1
20	C2006		DELETED		
25	253T5811-3		DELETED		
30	NAS514P632-6B		DELETED		
30A	BACS12GX06-4		.SCREW	P-R	3
35	253T5853-1		.COVER	P-R	1
40	NAS600-6P		DELETED		
40A	NAS8200A6		DELETED		
40B	NAS8200A5		.SCREW- (OPT ITEM 40C)	P-R	1
-40C	NAS1801-04-6		.SCREW- (OPT ITEM 40B)	P-R	1
45	AN960C4L		DELETED		
45A	NAS1149CN416R		.WASHER- (USE MINIMUM 1 (QTY) AND UP TO MAXIMUM 8 (QTY) WASHERS TO ADJUST SWITCH ACTUATION POINT. OPT USE 1 (QTY) NAS43DD1-12FC SPACER IN CONJUNCTION WITH UP TO 4 (QTY) WASHERS MAXIMUM)	P-R	1
-45B	NAS43DD1-12FC		.WASHER- (USE MINIMUM 1 (QTY) AND UP TO MAXIMUM 8 (QTY) WASHERS TO ADJUST SWITCH ACTUATION POINT. OPT USE 1 (QTY) NAS43DD1-12FC SPACER IN CONJUNCTION WITH UP TO 4 (QTY) WASHERS MAXIMUM)	P-R	1
50	MS21042L04		DELETED		
50A	H52732-04CM		.NUT- (V15653) (SPEC BACN10YR04CM) (OPT PLH504CM (V62554))	P-R	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
05-					
55	H10-04BAC		DELETED		
55A	BRH111OC04M		DELETED		
55B	MS35649-244		.NUT	P-R	1
60	69-73369-1		.SPACER	P-R	1
65	AN960C4L		DELETED		
65A	NAS1149CN416R		.WASHER- (USE MINIMUM 1 (QTY) AND UP TO MAXIMUM 8 (QTY) WASHERS TO ADJUST SWITCH ACTUATION POINT. OPT USE 1 (QTY) NAS43DD1-12FC SPACER IN CONJUNCTION WITH UP TO 4 (QTY) WASHERS MAXIMUM)	P-R	1
-65B	NAS43DD1-12FC		.WASHER- (USE MINIMUM 1 (QTY) AND UP TO MAXIMUM 8 (QTY) WASHERS TO ADJUST SWITCH ACTUATION POINT. OPT USE 1 (QTY) NAS43DD1-12FC SPACER IN CONJUNCTION WITH UP TO 4 (QTY) WASHERS MAXIMUM)	P-R	1
68	253T5836-1		.SHIM	P-R	3
70	253T5867-1		.SPRING	P-R	1
75	253T5863-1		DELETED		
75A	253T5863-2		.BELLCRANK ASSY- (OPT ITEM 75)	P-R	1
80	66-25941-1		..PIN	P-R	2
85	253U5828-2		..ROLLER-CAM	P-R	1
90	253T5864-1		..BELLCRANK	P-R	1
95	69-73206-1		..PLUNGER-SPRING	P-R	1
100	NAS600-6P		DELETED		

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
05-					
100A	NAS8200A6		DELETED		
100B	NAS8200A5		.SCREW- (OPT ITEM 100C)	P-R	2
-100C	NAS1801-04-6		.SCREW- (OPT ITEM 100B)	P-R	2
105	AN960C4L		DELETED		
105A	NAS1149CN416R		.WASHER- (USE MINIMUM 1 (QTY) AND UP TO MAXIMUM 8 (QTY) WASHERS TO ADJUST SWITCH ACTUATION POINT. OPT USE 1 (QTY) NAS43DD1-12FC SPACER IN CONJUNCTION WITH UP TO 4 (QTY) WASHERS MAXIMUM)	P-R	2
-105B	NAS43DD1-12FC		.WASHER- (USE MINIMUM 1 (QTY) AND UP TO MAXIMUM 8 (QTY) WASHERS TO ADJUST SWITCH ACTUATION POINT. OPT USE 1 (QTY) NAS43DD1-12FC SPACER IN CONJUNCTION WITH UP TO 4 (QTY) WASHERS MAXIMUM)	P-R	1
110	H10-04BAC		DELETED		
110A	BRH10C04D		.NUT- (V52828) (SPEC BACN10JC04CD) (OPT H51650-04BAC (V15653)) (OPT 102LH9075-40W (V72962)) (OPT NS202486-40 (V80539)) (OPT T6C440CD (V11815)) (OPT T6C440JCD (V11815))	P-R	2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
05-					
115	253T5856-1		DELETED		
115A	253T5856-2		.SPRING	P-R	1
120	BACS12BE02A8		DELETED		
120A	BACS12BE02A6		.SCREW	P-R	2
125	MS24547-1		DELETED		
130	MS24665-151		.PIN-COTTER	P-R	1
135	254N1703-1		.PIN-DRILLED SHANK	P-R	1
140	254N1732-1		DELETED		
140A	254N5869-1		.PAWL- (OPT ITEM 140B)	P-R	1
-140B	254N5869-2		.PAWL- (OPT ITEM 140A)	P-R	1
145	NAS623-3-3		.SCREW	P-R	1
150	AN960JD10L		DELETED		
150A	NAS1149D0332J		.WASHER	P-R	1
155	NAS6603-6		DELETED		
155A	BACB30NM3K6		DELETED		
155B	NAS623-3-6		.SCREW	P-R	1
160	NAS1056C6-011		.SPACER	P-R	1
165	BACW10P5C		.WASHER	P-R	1
170	BACB30NM4K16		DELETED		
170A	AN960JD10L		DELETED		
170B	NAS1149D0332J		.WASHER	P-R	1
175	MS21042L3		DELETED		
175A	H52732-3CD		.NUT- (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))	P-R	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
05-					
180	MS24665-151		.PIN-COTTER	P-R	1
185	NAS43DD3-24		DELETED		
185A	NAS43DD3-24FC		.SPACER	P-R	1
190	MS20392-2C19		.PIN-DRILLED SHANK	P-R	1
195	254N1739-1		.GUIDE	P-R	1
200	NAS514P1032-24		DELETED		
200A	NAS514P1032-24P		.SCREW	P-R	1
205	NAS514P1032-18		DELETED		
205A	NAS514P1032-18P		.SCREW	P-R	1
210	NAS603-7P		.SCREW	P-R	1
215	AN960JD10L		DELETED		
215A	NAS1149D0332J		.WASHER	P-R	1
220	NAS514P832-7		DELETED		
220A	NAS514P832-7P		.SCREW	P-R	1
225	NAS602-7P		.SCREW	P-R	1
230	AN960JD8		DELETED		
230A	NAS1149DN832J		.WASHER	P-R	1
235	HL18PB6-8		DELETED		
235A	HST10AG6-8		.BOLT- (VOPTK6) (SPEC BACB30VT6K8) (OPT HST10AG6-8 (V06725)) (OPT HST10AG6-8 (V56878)) (OPT HST10AG6-8 (V73197))	P-R	1
240	AN960C10L		DELETED		
240A	NAS1149C0332R		.WASHER	P-R	1
245	HL79-6		DELETED		
245A	HST79CY6		.COLLAR- (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V56878)) (OPT HST79-6 (V92215)) (OPT HST79-6 (V5M902))	P-R	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
05-					
247	AN960JD10L		DELETED		
247A	NAS1149D0332J		.WASHER	P-R	1
250	HL440UC5-8		DELETED		
250A	HL40-5-8		.BOLT- (V97928) (SPEC BACB30FM5A8U) (OPT HL40-5-8 (V73197)) (OPT HL40-5-8 (V80539)) (OPT HL40-5-8 (V92215)) (OPT L8055A8U (V06725)) (OPT HL18-5A8U (V06725)) (OPT HL40-5-8 (V08524)) (OPT 67067-5A8U (V56878)) (OPT HL40-5-8 (V56878))	P-R	1
255	AN960XC9		DELETED		
255A	AN960C9		DELETED		
255B	NAS1149CN949R		.WASHER	P-R	1
260	253T5859-1		DELETED		
260A	253T5859-5		.CAM ASSY-THRUSTER REVERSE	P-R	1
262	MS21209C0815		..INSERT	P-R	1
265	253T5861-1		.SUPPORT ASSY-BEARING	P-R	1
267	253T5861-3		..SUPPORT	P-R	1
270	MS21209C0615P		..INSERT	P-R	3
272	253U5813-1		..SPACER	P-R	1
275	B5538WZZFS428		..BEARING- (V21335)	P-R	1
280	BACR15BA3AD		..RIVET- (SIZE DETERMINE ON INST)	P-R	3
282	BACR15BA5AD		..RIVET	P-R	1
285	253U5838-1		..SUPPORT ASSY-BELLCRANK	P-R	1
290	MS21209C0410		...INSERT	P-R	1
295	253U5838-2		...SUPPORT	P-R	1
300	BACR15BA3AD		..RIVET- (SIZE DETERMINE ON INST)	P-R	3
305	253T5860-1		..GUIDE-SPRING	P-R	1
310	MS21209C0220P		..INSERT	P-R	2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
05-					
315	253T5855-1		.LINK ASSY	P-R	1
320	253U5810-1		DELETED		
320A	253U5810-2		..RIVET-PIVOT	P-R	1
325	253T5866-1		..LINK	P-R	1
330	BACS12BP3P8		..SCREW	P-R	1
335	65C14183-46		..KNOB	P-R	1
340	253T5854-1		..LEVER-THRUSTER REVERSE	P-R	1
345	253T5868-1		.STOP	P	1
-345A	253T5868-3		.STOP	Q	1
-345B	253T5868-5		.STOP	R	1
350	NAS514P632-5B		DELETED		
350A	BACS12GX06-4		.SCREW	P-R	3
355	254N1138-7		.COVER	P-R	1
360	HL445-6-8		DELETED		
360A	HL523AZ6-8		.BOLT- (V73197) (SPEC BACB30NZ6K8) (OPT L804-6K8 (V06725)) (OPT HL523AZ6-8 (V56878)) (OPT HL523AZ6-8 (V92215)) (OPT HL523AZ6-8 (V97928)) (OPT HL523AZ6-8 (V0PTK6)) (OPT HL523AZ6-8 (V60516)) (OPT HL523AZ6-8 (V06725))	P-R	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
05-					
365	AN96010L		DELETED		
365A	AN960C10L		DELETED		
365B	NAS1149C0332R		.WASHER	P-R	1
370	MS21042L3		DELETED		
370A	H52732-3CM		.NUT- (V15653) (SPEC BACN10YR3CM) (OPT PLH53CM (V62554))	P-R	1
375	BACB28Y3F046		.BUSHING	P-R	1
380	254N1175-3		.TRIGGER- (OPT ITEM 380A)	P-R	1
-380A	254N1175-5		.TRIGGER- (OPT ITEM 380)	P-R	1
385	NAS600-8		DELETED		
385A	NAS8200A8		.SCREW	P-R	1
390	NAS1057T0-010		.SPACER	P-R	1
395	AN960C4L		DELETED		
395A	NAS1149CN416R		.WASHER- (USE MINIMUM 1 (QTY) AND UP TO MAXIMUM 8 (QTY) WASHERS TO ADJUST SWITCH ACTUATION POINT. OPT USE 1 (QTY) NAS43DD1-12FC SPACER IN CONJUNCTION WITH UP TO 4 (QTY) WASHERS MAXIMUM)	P-R	2
-395B	NAS43DD1-12FC		.WASHER- (USE MINIMUM 1 (QTY) AND UP TO MAXIMUM 8 (QTY) WASHERS TO ADJUST SWITCH ACTUATION POINT. OPT USE 1 (QTY) NAS43DD1-12FC SPACER IN CONJUNCTION WITH UP TO 4 (QTY) WASHERS MAXIMUM)	P-R	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
05-					
400	254N1179-3		.SPRING	P-R	1
405	BACS12BE02A6		DELETED		
405A	BACS12BE02A5		.SCREW	P-R	2
410	BACS12BE02A9		.SCREW	P-R	2
415	JX45		.ACTUATOR-SWITCH (V91929)	P-R	3
420	MS24547-1		DELETED		
425	NAS514P440-5		DELETED		
425A	BACS12ER04K5		.SCREW	P-R	4
430	253T5812-3		.RETAINER-BRG	P-R	1
435	MB539DDNJC		.BEARING- (V06144) (SPEC BACB10AS12) (OPT LLMB539 (V38443)) (OPT MB539-2TS (V43991)) (OPT MB539DDFS428 (V21335)) (OPT MB539TT (V43991)) (OPT MB539DDG20 (V38443)) (OPT MT339E (VK8455)) (OPT MB539DDLY196 (V40920)) (OPT MB539DD (V06144)) (OPT NB539DDSD610 (V83086))	P-R	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
05-					
440	NAS514P440-5		DELETED		
440A	BACS12ER04K5		.SCREW	P-R	4
445	253T5812-4		.RETAINER-BRG	P-R	1
450	253T5857-1		.CRANK ASSY	P-R	1
455	MS20615SMP		..RIVET- (SIZE DETERMINE ON INST)	P-R	3
460	254N1731-1		..CAM-RTO	P-R	1
465	MB544DDNJC		..BEARING- (V06144) (SPEC BACB10AS29) (OPT LLMB544 (V38443)) (OPT MB544-2TS (V43991)) (OPT MB544DDFS428 (V21335)) (OPT MB544TT (V43991)) (OPT MB544DDG20 (V38443)) (OPT MT344E (VK8455)) (OPT MB544DDLY196 (V40920)) (OPT MB544DD (V06144)) (OPT MB544DDSD610 (V83086))	P-R	1
470	69-38919-52		DELETED		
470A	69-38919-23		..SLEEVE- (MFD FROM 6061-0 SH PER QQ-A-250/11 OR 6061-0 TUBING PER WW-T-700/6 OPTL. MATRL. 6061-T6 ROD PER QQ-A-225/8 ANNEAL TO 6061-0 AFTER MACHINING)	P-R	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
05-					
475	MKP3ANJC		..BEARING- (V06144) (SPEC BACB10AP3) (OPT MKP3ASD610 (V83086)) (OPT LLMKP3A (V38443)) (OPT MKP3AFS428 (V21335)) (OPT MKP3ATT (V43991)) (OPT MKP3A2TS (V43991)) (OPT MKP3E6531 (V21335)) (OPT MKP3AG20 (V38443)) (OPT MKP3ALY196 (V40920)) (OPT MKP3A (V38443)) (OPT MCS23E (VK8455))	P-R	1
480	253T5858-1		..CRANK	P-R	1
485	NAS6603-4		DELETED		
485A	BACB30NM3K4		.BOLT	P-R	1
490	AN960JD10L		DELETED		
490A	NAS1149D0332J		.WASHER	P-R	1
493	BACW10P5C		.WASHER	P-R	1
495	MS21042L3		DELETED		
495A	H52732-3CD		.NUT- (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))	P-R	1
500	254N1141-1		.COUNTERWEIGHT	P-R	1
505	253T5862-1		.HANDLE ASSY	P-R	1
510	MS21209C0610P		..INSERT	P-R	3
515	MS21209C0415P		..INSERT	P-R	9
520	MS21209C0210P		..INSERT	P-R	4

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
05-					
525	NAS607-3-4P		..PIN-DOWEL	P-R	2
530	MS21209F1-15P		..INSERT	P-R	4
535	MS21209C0820P		..INSERT	P-R	2
536	253T5811-3		DELETED		
540	253T5862-3		..HANDLE	P-R	1
541	256T5852-7		.WIRE BUNDLE ASSY	P-R	1
-542	C2006		..SWITCH- (V81640) (S3) (OPT ITEM 542A)	P-R	2
-542A	P8-4000003		..SWITCH- (V21649) (OPT ITEM 542)	P-R	2
-543	MS24547-1		..SWITCH- (S1, S5, S7, S9)	P-R	4
545	BAC27TCT0016		.DECAL-S5	P-R	1
550	BAC27TCT0156		.DECAL	P-R	1
555	BAC27TCT0014		.DECAL-S3	P-R	1
560	BAC27TCT0033		.DECAL-S9	P-R	1
565	BAC27TCT0012		.DECAL-S1	P-R	1
570	BAC27TCT0031		.DECAL-S7	P-R	1

- Item Not Illustrated

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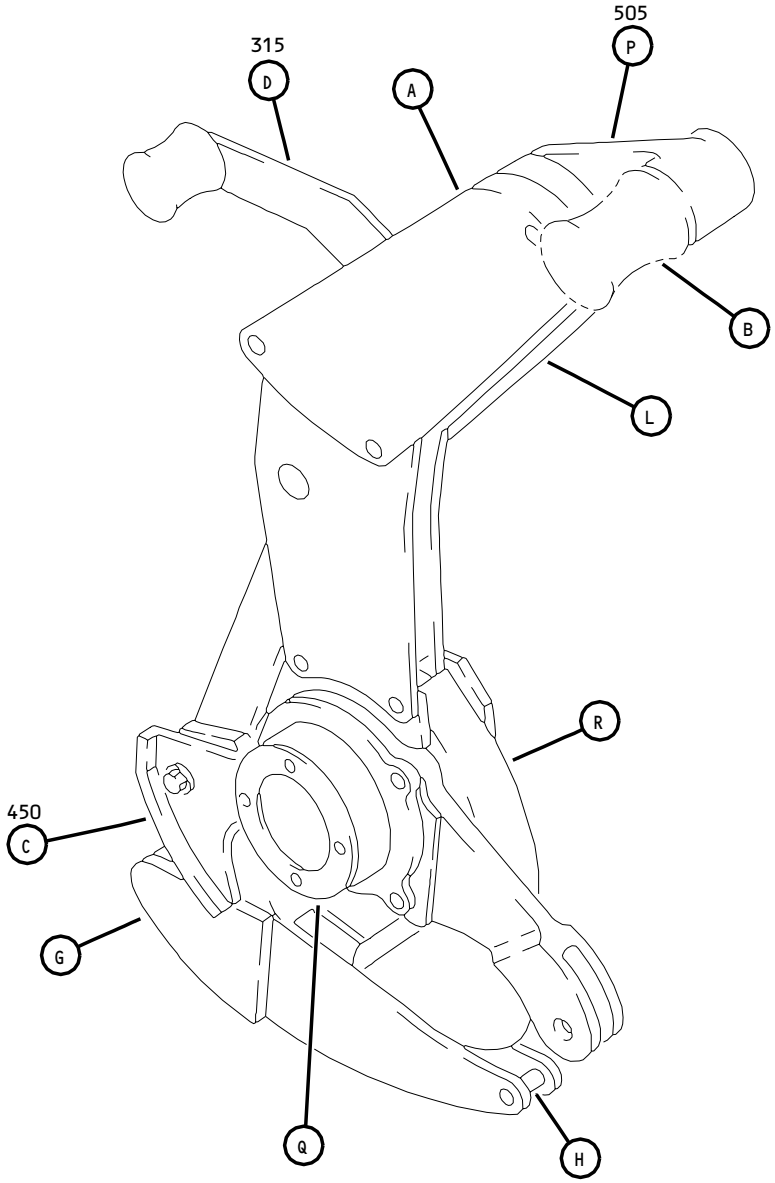

Control Stand Thrust Lever Assembly
Figure 6 (Sheet 1)

A15980

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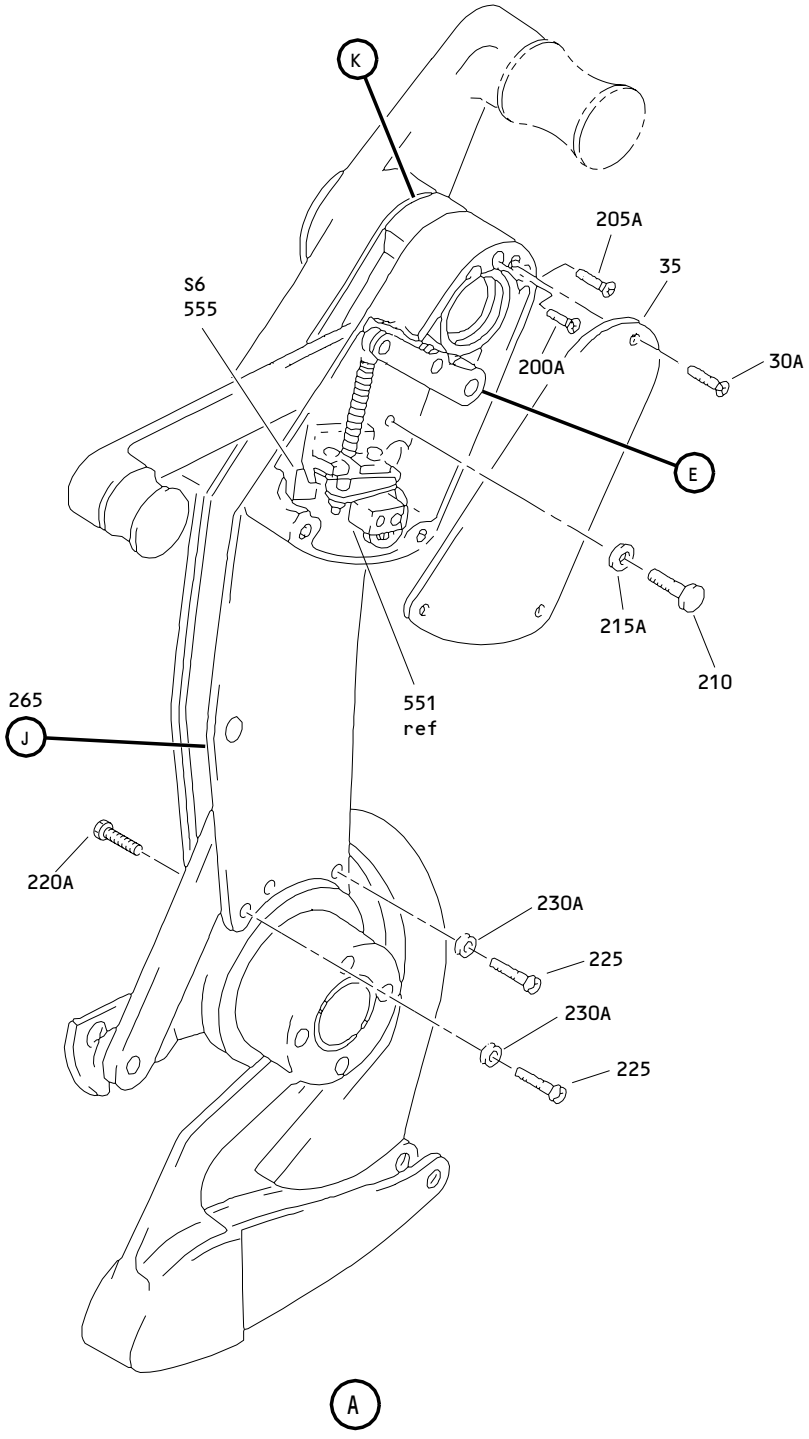

Control Stand Thrust Lever Assembly
Figure 6 (Sheet 2)

A16070

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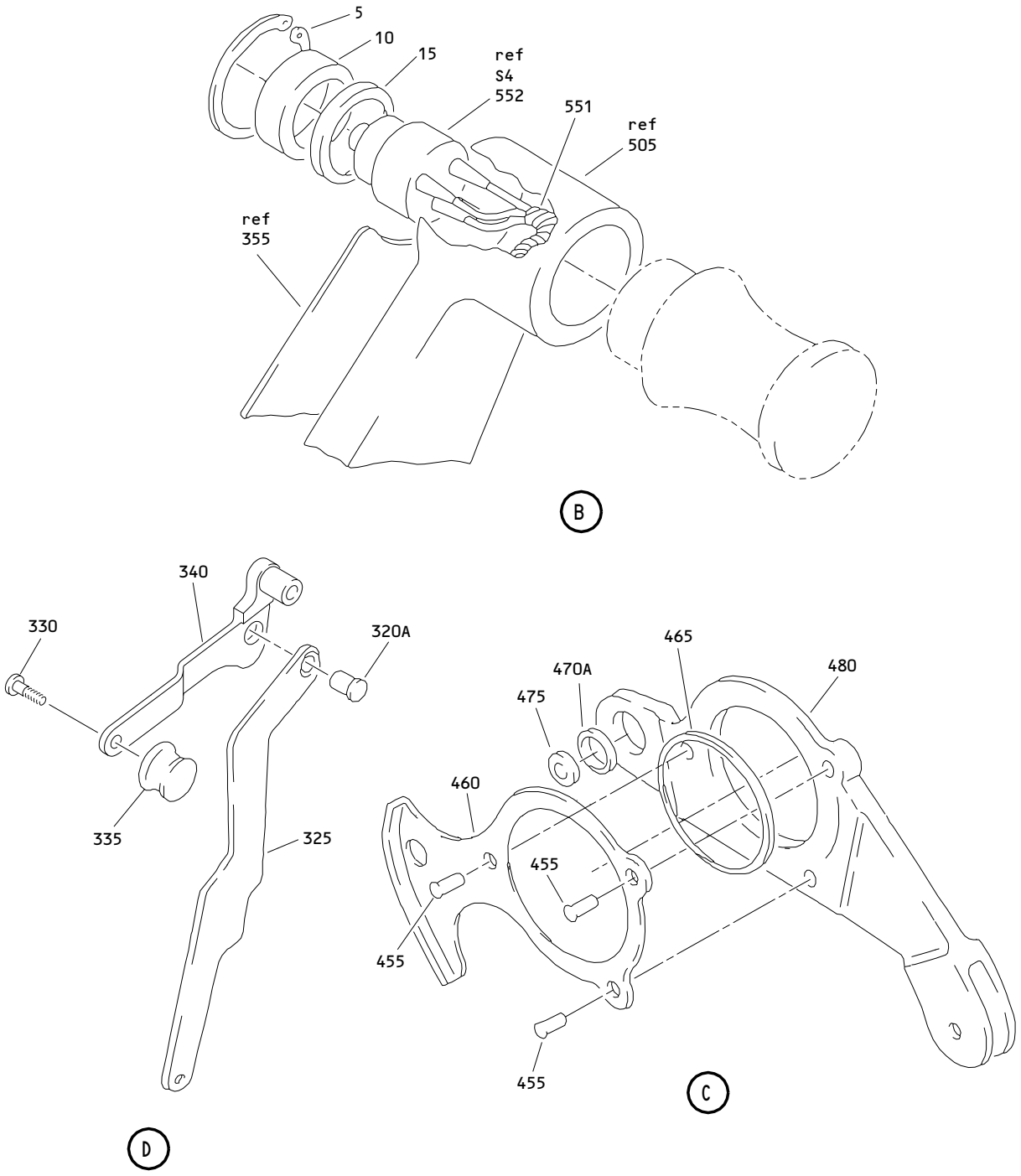

Control Stand Thrust Lever Assembly
Figure 6 (Sheet 3)

A16071

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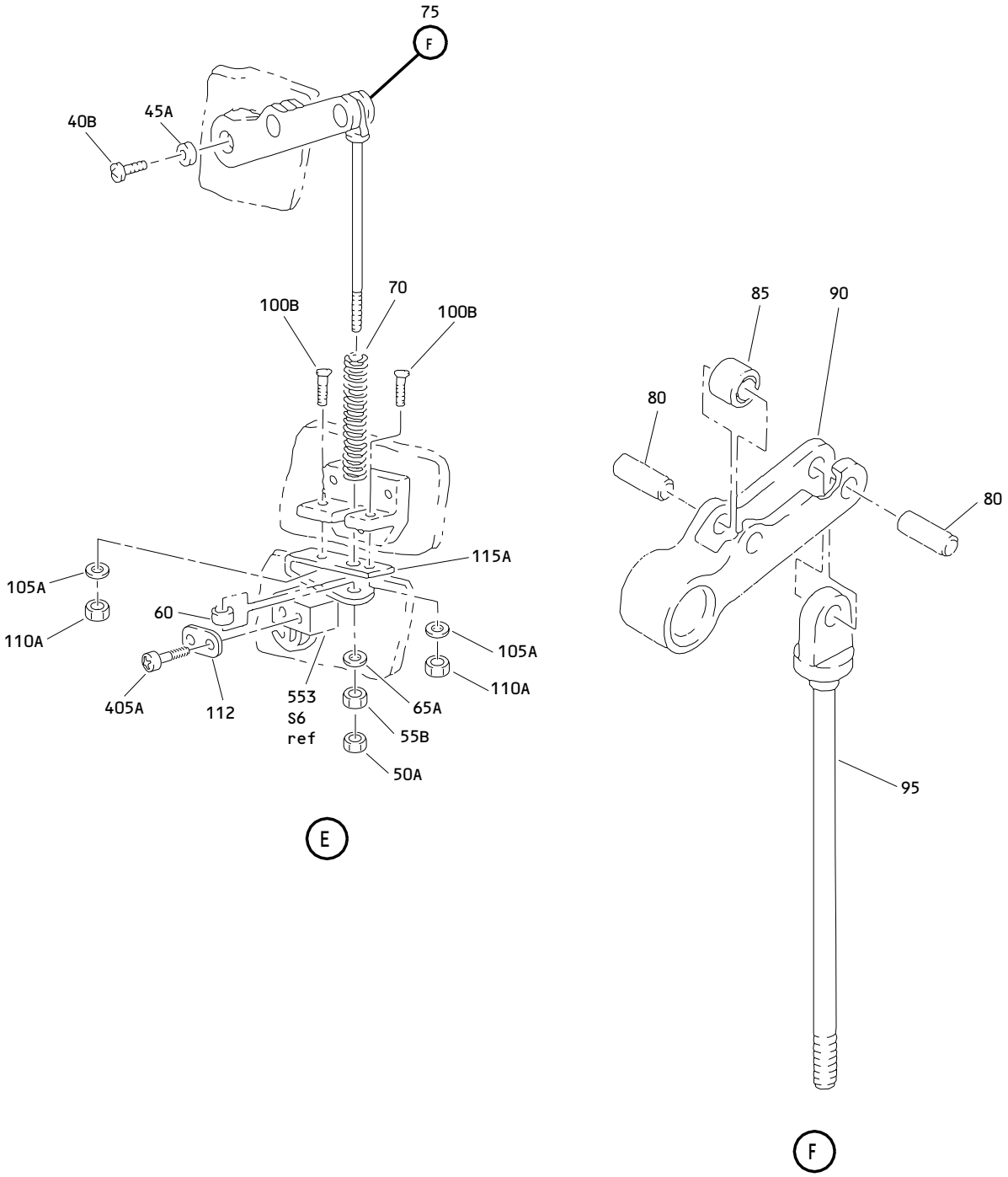

Control Stand Thrust Lever Assembly
Figure 6 (Sheet 4)

A16072

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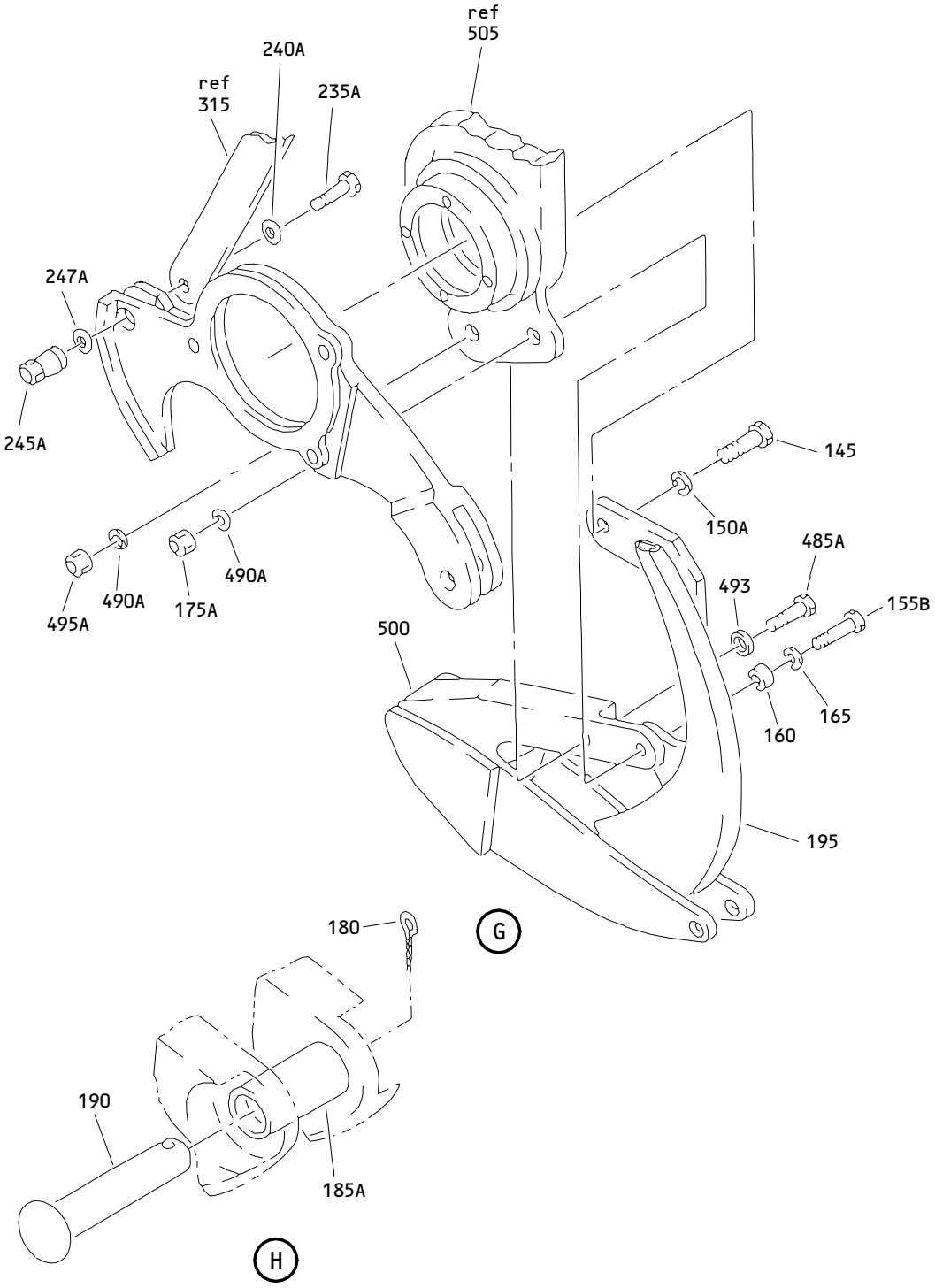

Control Stand Thrust Lever Assembly
Figure 6 (Sheet 5)

A16115

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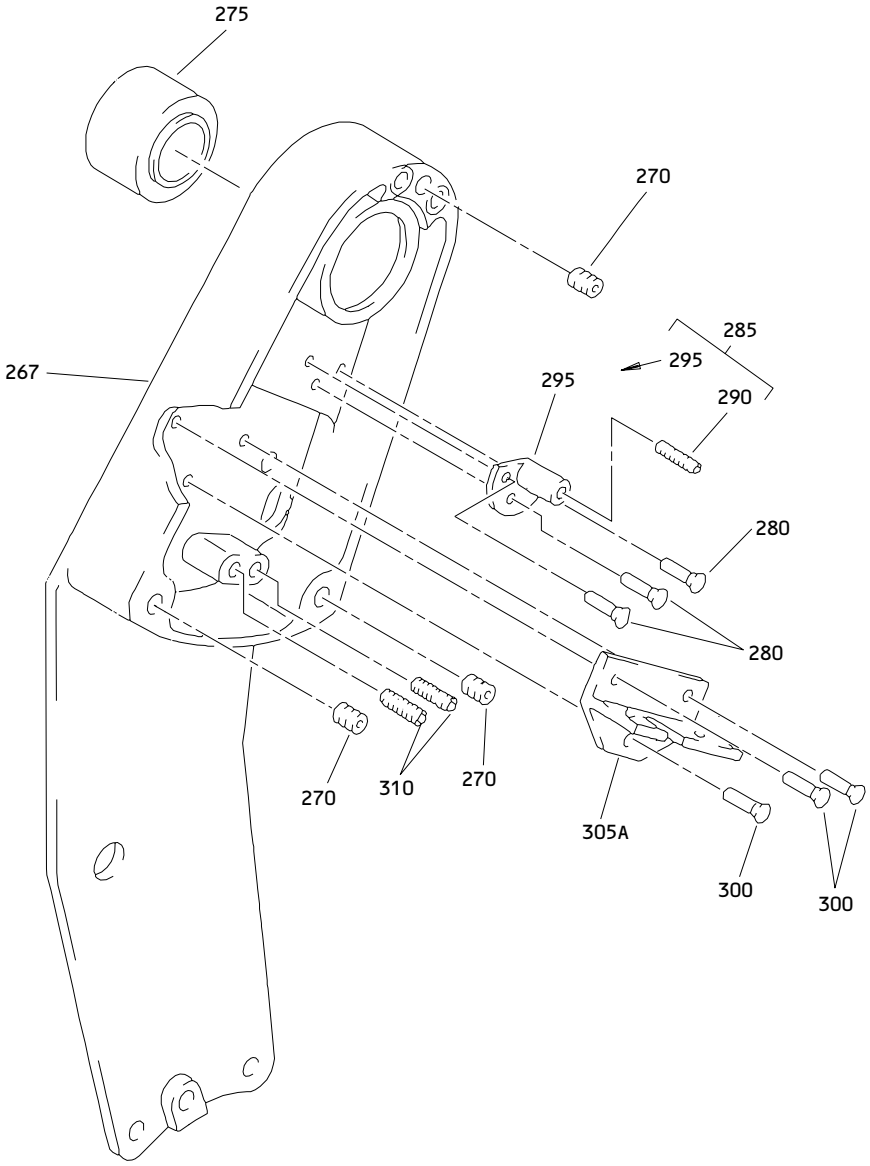

Control Stand Thrust Lever Assembly
Figure 6 (Sheet 6)

A16116

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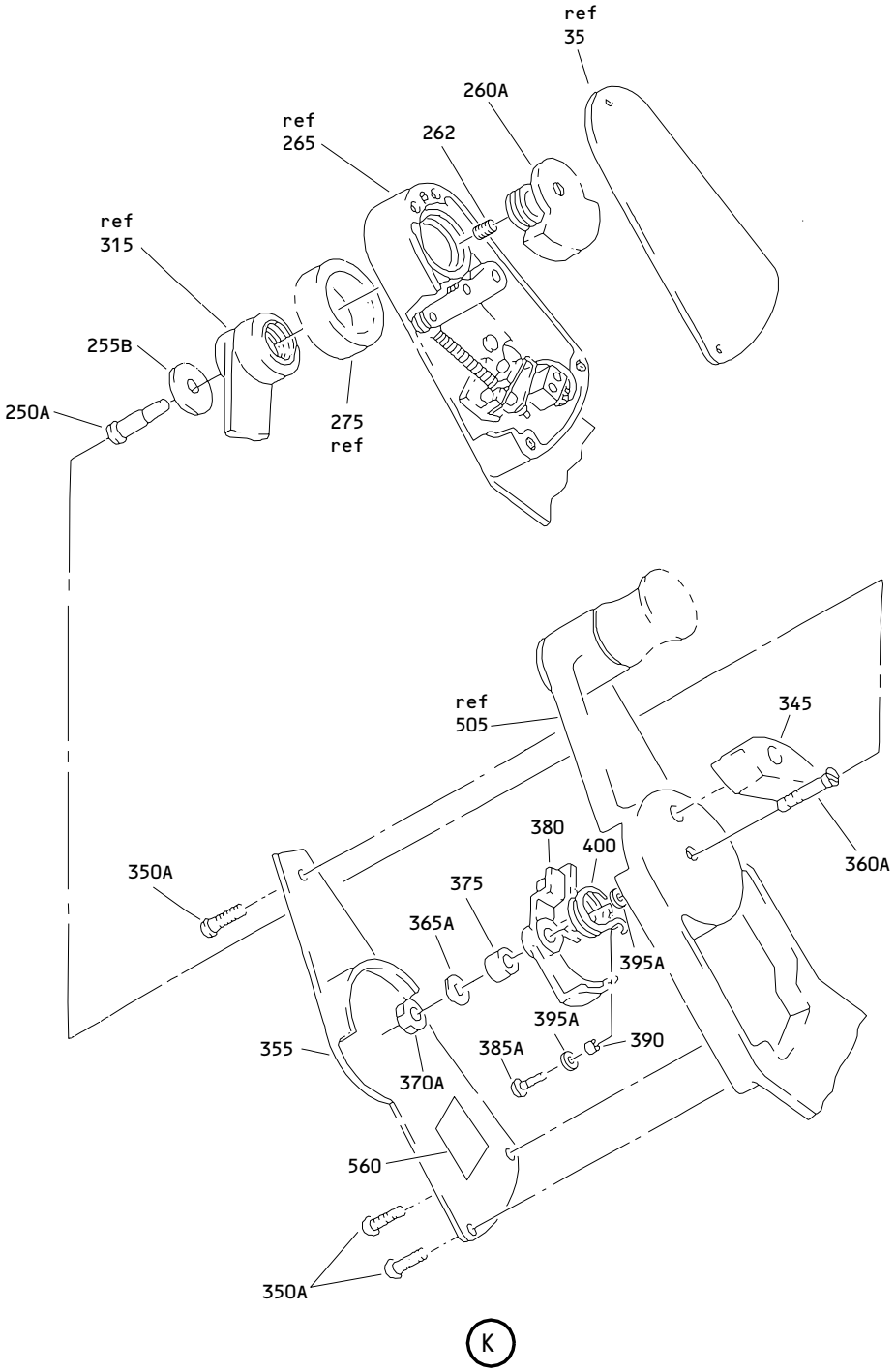

Control Stand Thrust Lever Assembly
Figure 6 (Sheet 7)

A16117

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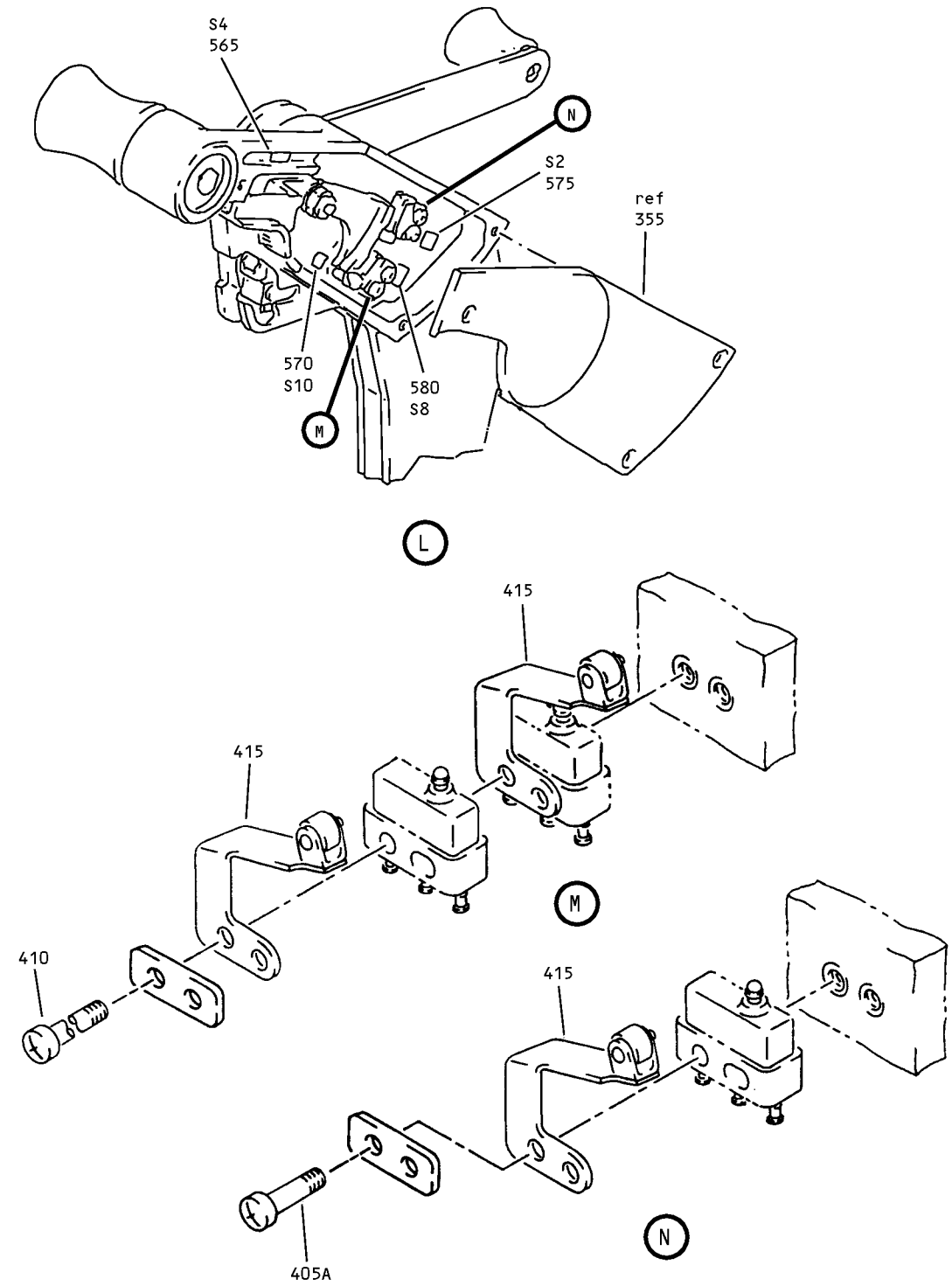

Control Stand Thrust Lever Assembly
Figure 6 (Sheet 8)

A16118

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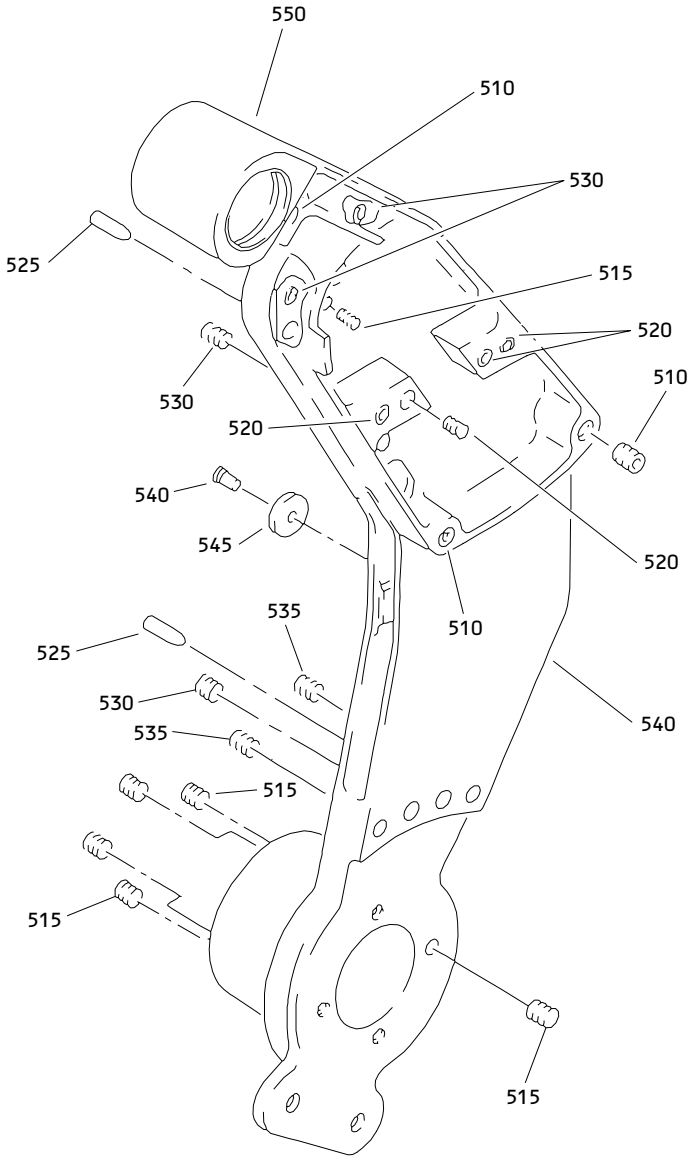

Control Stand Thrust Lever Assembly
Figure 6 (Sheet 9)

A16119

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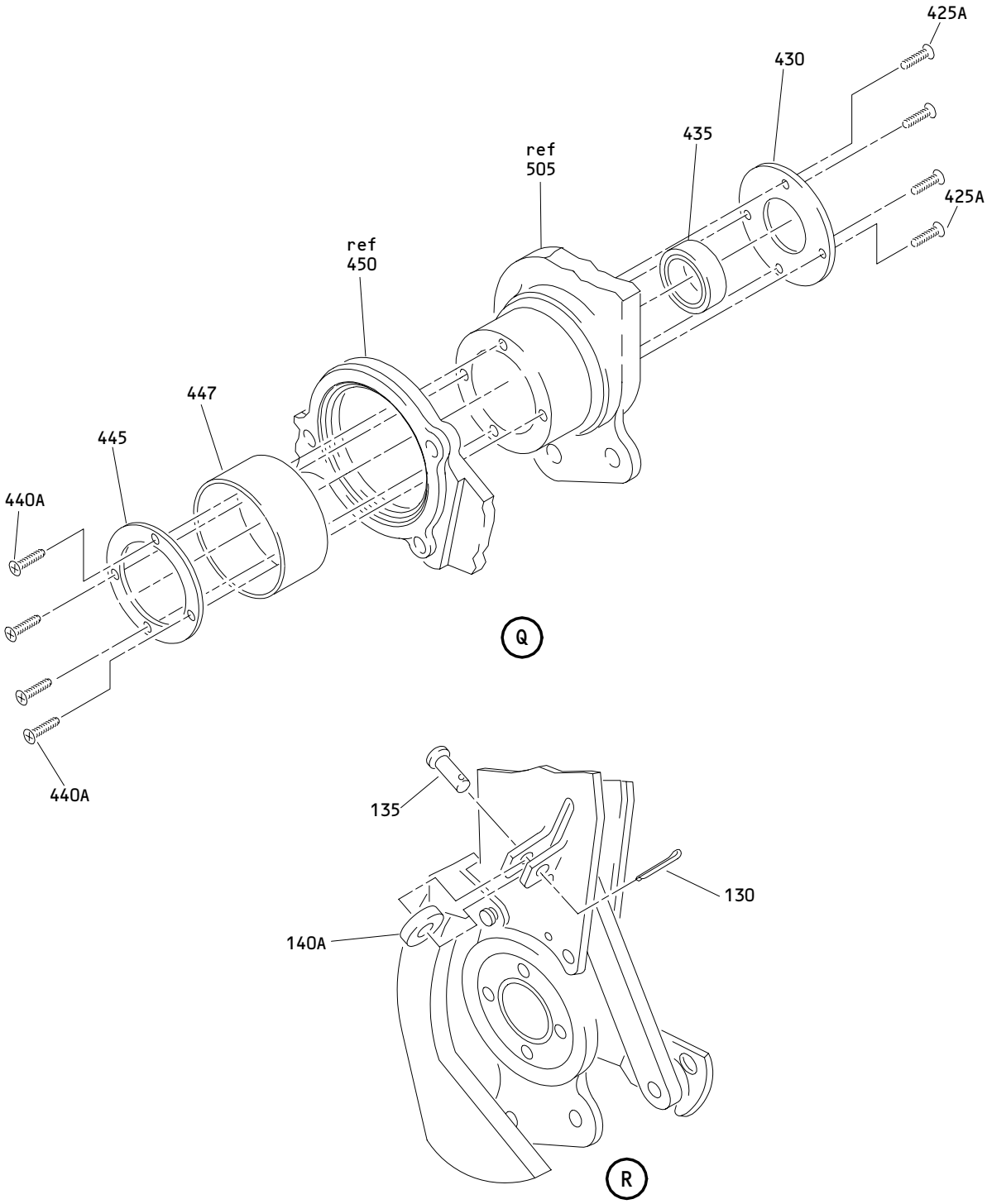

Control Stand Thrust Lever Assembly
Figure 6 (Sheet 10)

A15946

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
06-					
-1	253T5852-2		LEVER ASSY-CONT STAND THRUST	P	RF
-1A	253T5852-4		LEVER ASSY-CONT STAND THRUST	Q	RF
-1B	253T5852-6		LEVER ASSY-CONT STAND THRUST	R	RF
5	MS16625-4086		.RING	P-R	1
10	69-35353-3		.RETAINER	P-R	1
15	MS28775-114		.PACKING	P-R	1
20	C2006		DELETED		
25	253T5811-3		DELETED		
30	NAS514P632-6B		DELETED		
30A	BACS12GX06-4		.SCREW	P-R	3
35	253T5853-2		.COVER	P-R	1
40	NAS600-6P		DELETED		
40A	NAS8200A6		DELETED		
40B	NAS8200A5		.SCREW- (OPT ITEM 40C)	P-R	1
-40C	NAS1801-04-6		.SCREW- (OPT ITEM 40B)	P-R	1
45	AN960C4L		DELETED		
45A	NAS1149CN416R		.WASHER- (USE MINIMUM 1 (QTY) AND UP TO MAXIMUM 8 (QTY) WASHERS TO ADJUST SWITCH ACTUATION POINT. OPT USE 1 (QTY) NAS43DD1-12FC SPACER IN CONJUNCTION WITH UP TO 4 (QTY) WASHERS MAXIMUM)	P-R	1
-45B	NAS43DD1-12FC		.WASHER- (USE MINIMUM 1 (QTY) AND UP TO MAXIMUM 8 (QTY) WASHERS TO ADJUST SWITCH ACTUATION POINT. OPT USE 1 (QTY) NAS43DD1-12FC SPACER IN CONJUNCTION WITH UP TO 4 (QTY) WASHERS MAXIMUM)	P-R	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
06-					
50	MS21042L04		DELETED		
50A	H52732-04CM		.NUT- (V15653) (SPEC BACN10YR04CM) (OPT PLH504CM (V62554))	P-R	1
55	H10-04BAC		DELETED		
55A	BRH1110C04M		DELETED		
55B	MS35649-244		.NUT	P-R	1
60	69-73369-1		.SPACER	P-R	1
65	AN960C4L		DELETED		
65A	NAS1149CN416R		.WASHER- (USE MINIMUM 1 (QTY) AND UP TO MAXIMUM 8 (QTY) WASHERS TO ADJUST SWITCH ACTUATION POINT. OPT USE 1 (QTY) NAS43DD1-12FC SPACER IN CONJUNCTION WITH UP TO 4 (QTY) WASHERS MAXIMUM)	P-R	1
-65B	NAS43DD1-12FC		.WASHER- (USE MINIMUM 1 (QTY) AND UP TO MAXIMUM 8 (QTY) WASHERS TO ADJUST SWITCH ACTUATION POINT. OPT USE 1 (QTY) NAS43DD1-12FC SPACER IN CONJUNCTION WITH UP TO 4 (QTY) WASHERS MAXIMUM)	P-R	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
06-					
70	253T5867-1		.SPRING	P-R	1
75	253T5863-1		DELETED		
75A	253T5863-2		.BELLCRANK ASSY- (OPT ITEM 75)	P-R	1
80	66-25941-1		..PIN	P-R	2
85	253U5828-2		..ROLLER-CAM	P-R	1
90	253T5864-1		..BELLCRANK	P-R	1
95	69-73206-1		..PLUNGER-SPRING	P-R	1
100	NAS600-6P		DELETED		
100A	NAS8200A6		DELETED		
100B	NAS8200A5		..SCREW- (OPT ITEM 100C)	P-R	2
-100C	NAS1801-04-6		..SCREW- (OPT ITEM 100B)	P-R	2
105	AN960C4L		DELETED		
105A	NAS1149CN416R		..WASHER- (USE MINIMUM 1 (QTY) AND UP TO MAXIMUM 8 (QTY) WASHERS TO ADJUST SWITCH ACTUATION POINT. OPT USE 1 (QTY) NAS43DD1-12FC SPACER IN CONJUNCTION WITH UP TO 4 (QTY) WASHERS MAXIMUM)	P-R	2
-105B	NAS43DD1-12FC		..WASHER- (USE MINIMUM 1 (QTY) AND UP TO MAXIMUM 8 (QTY) WASHERS TO ADJUST SWITCH ACTUATION POINT. OPT USE 1 (QTY) NAS43DD1-12FC SPACER IN CONJUNCTION WITH UP TO 4 (QTY) WASHERS MAXIMUM)	P-R	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
06-					
110	H10-04BAC		DELETED		
110A	BRH10C04D		..NUT-	P-R	2
			(V52828)		
			(SPEC BACN10JC04CD)		
			(OPT H51650-04BAC		
			(V15653))		
			(OPT 102LH9075-40W		
			(V72962))		
			(OPT NS202486-40		
			(V80539))		
			(OPT T6C440CD		
			(V11815))		
			(OPT T6C440JCD		
			(V11815))		
112	253T5836-1		..SHIM	P-R	3
115	253T5856-1		DELETED		
115A	253T5856-2		.SPRING	P-R	1
120	BACS12BE02A8		DELETED		
120A	BACS12BE02A6		DELETED		
125	MS24547-1		DELETED		
130	MS24665-151		.PIN-COTTER	P-R	1
135	254N1703-1		.PIN-DRILLED SHANK	P-R	1
140	254N1732-1		DELETED		
140A	253T5869-1		.PAWL-	P-R	1
			(OPT ITEM 140B)		
-140B	253T5869-2		.PAWL-	P-R	1
			(OPT ITEM 140A)		
145	NAS623-3-3		.SCREW	P-R	1
150	AN960JD10L		DELETED		
150A	NAS1149D0332J		.WASHER	P-R	1
155	NAS6603-6		DELETED		
155A	BACB30NM3K6		DELETED		

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
06-					
155B	NAS623-3-6		.SCREW	P-R	1
160	NAS1056C6-011		.SPACER	P-R	1
165	BACW10P5C		.WASHER	P-R	1
170	BACB30NM4K16		.BOLT	P-R	1
-170A	AN960JD10L		DELETED		
-170B	NAS1149D0332J		.WASHER	P-R	1
175	MS21042L3		DELETED		
175A	H52732-3CD		.NUT- (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))	P-R	1
180	MS24665-151		.PIN-COTTER	P-R	1
185	NAS43DD3-24		DELETED		
185A	NAS43DD3-24FC		.SPACER	P-R	1
190	MS20392-2C19		.PIN-DRILLED SHANK	P-R	1
195	254N1739-1		.GUIDE	P-R	1
200	NAS514P1032-24		DELETED		
200A	NAS514P1032-24P		.SCREW	P-R	1
205	NAS514P1032-18		DELETED		
205A	NAS514P1032-18P		.SCREW	P-R	1
210	NAS603-7P		.SCREW	P-R	1
215	AN960JD10L		DELETED		
215A	NAS1149D0332J		.WASHER	P-R	1
220	NAS514P832-7		DELETED		
220A	NAS514P832-7P		.SCREW	P-R	1
225	NAS602-7P		.SCREW	P-R	2
230	AN960JD8		DELETED		
230A	NAS1149DN832J		.WASHER	P-R	2
235	HL18PB6-8		DELETED		
235A	HST10AG6-8		.BOLT- (V0PTK6) (SPEC BACB30VT6K8) (OPT HST10AG6-8 (V06725)) (OPT HST10AG6-8 (V56878)) (OPT HST10AG6-8 (V73197))	P-R	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
06-					
240	AN960C10L		DELETED		
240A	NAS1149C0332R		.WASHER	P-R	1
245	HL79-6		DELETED		
245A	HST79CY6		.COLLAR- (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V56878)) (OPT HST79-6 (V92215)) (OPT HST79-6 (V5M902))	P-R	1
247	AN960JD10L		DELETED		
247A	NAS1149D0332J		.WASHER	P-R	1
250	HL440UC5-8		DELETED		
250A	HL40-5-8		.BOLT- (V97928) (SPEC BACB30FM5A8U) (OPT HL40-5-8 (V73197)) (OPT HL40-5-8 (V80539)) (OPT HL40-5-8 (V92215)) (OPT L8055A8U (V06725)) (OPT HL18-5A8U (V06725)) (OPT HL40-5-8 (V08524)) (OPT 67067-5A8U (V56878)) (OPT HL40-5-8 (V56878))	P-R	1
255	AN960XC9		DELETED		
255A	AN960C9		DELETED		
255B	NAS1149CN949R		.WASHER	P-R	1
260	253T5859-2		DELETED		
260A	253T5859-6		.CAM ASSY-THRUSTER REVERSE	P-R	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
06-					
262	MS21209C0815		..INSERT	P-R	1
265	253T5861-2		.SUPPORT ASSY-BEARING	P-R	1
267	253T5861-4		..SUPPORT	P-R	1
270	MS21209C0615P		..INSERT	P-R	3
275	B5538WZZFS428		..BEARING- (V21335)	P-R	1
280	BACR15BA3AD		..RIVET- (SIZE DETERMINE ON INST)	P-R	3
285	253U5838-1		..SUPPORT ASSY-BELLCRANK	P-R	1
290	MS21209C0410		...INSERT	P-R	1
295	253U5838-2		...SUPPORT	P-R	1
300	BACR15BA3AD		..RIVET- (SIZE DETERMINE ON INST)	P-R	3
305	253T5860-1		DELETED		
305A	253T5860-2		..GUIDE-SPRING	P-R	1
310	MS21209C022OP		..INSERT	P-R	2
315	253T5855-2		.LINK ASSY	P-R	1
320	253U5810-1		DELETED		
320A	253U5810-2		..RIVET-PIVOT	P-R	1
325	253T5866-1		..LINK	P-R	1
330	BACS12BP3P8		..SCREW	P-R	1
335	65C14183-46		..KNOB	P-R	1
340	253T5854-2		..LEVER-THRUSTER REVERSE	P-R	1
345	253T5868-2		.STOP	P	1
-345A	253T5868-4		.STOP	Q	1
-345B	253T5868-6		.STOP	R	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
06-					
350	NAS514P632-5B		DELETED		
350A	BACS12GX06-4		.SCREW	P-R	3
355	254N1138-8		.COVER	P-R	1
360	HL445-6-8		DELETED		
360A	HL523AZ6-8		.BOLT- (V73197) (SPEC BACB30NZ6K8) (OPT L804-6K8 (V06725)) (OPT HL523AZ6-8 (V56878)) (OPT HL523AZ6-8 (V92215)) (OPT HL523AZ6-8 (V97928)) (OPT HL523AZ6-8 (V0PTK6)) (OPT HL523AZ6-8 (V60516)) (OPT HL523AZ6-8 (V06725))	P-R	1
365	AN96010L		DELETED		
365A	NAS1149C0332R		.WASHER	P-R	1
370	MS21042L3		DELETED		
370A	H52732-3CM		.NUT- (V15653) (SPEC BACN10YR3CM) (OPT PLH53CM (V62554))	P-R	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
06-					
375	BACB28Y3F046		.BUSHING	P-R	1
380	254N1175-4		.TRIGGER- (OPT ITEM 380A)	P-R	1
-380A	254N1175-6		.TRIGGER- (OPT ITEM 380)	P-R	1
385	NAS600-8		DELETED		
385A	NAS8200A8		.SCREW	P-R	1
390	NAS1057T0-010		.SPACER	P-R	1
395	AN960C4L		DELETED		
395A	NAS1149CN416R		.WASHER- (USE MINIMUM 1 (QTY) AND UP TO MAXIMUM 8 (QTY) WASHERS TO ADJUST SWITCH ACTUATION POINT. OPT USE 1 (QTY) NAS43DD1-12FC SPACER IN CONJUNCTION WITH UP TO 4 (QTY) WASHERS MAXIMUM)	P-R	2
-395B	NAS43DD1-12FC		.WASHER- (USE MINIMUM 1 (QTY) AND UP TO MAXIMUM 8 (QTY) WASHERS TO ADJUST SWITCH ACTUATION POINT. OPT USE 1 (QTY) NAS43DD1-12FC SPACER IN CONJUNCTION WITH UP TO 4 (QTY) WASHERS MAXIMUM)	P-R	1
400	254N1179-4		.SPRING	P-R	1
405	BACS12BE02A6		DELETED		
405A	BACS12BE02A5		.SCREW	P-R	2
410	BACS12BE02A9		.SCREW	P-R	2
415	JX45		.ACTUATOR-SWITCH (V91929)	P-R	3
420	MS24547-1		DELETED		
425	NAS514P440-5		DELETED		
425A	BACS12ER04K5		.SCREW	P-R	4
430	253T5812-3		.RETAINER-BRG	P-R	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
06-					
435	MB539DDNJC		.BEARING- (V06144) (SPEC BACB10AS12) (OPT LLMB539 (V38443)) (OPT MB539-2TS (V43991)) (OPT MB539DDFS428 (V21335)) (OPT MB539TT (V43991)) (OPT MB539DDG20 (V38443)) (OPT MT339E (VK8455)) (OPT MB539DDLY196 (V40920)) (OPT MB539DD (V06144)) (OPT NB539DDSD610 (V83086))	P-R	1
440	NAS514P440-5		DELETED		
440A	BACS12ER04K5		.SCREW	P-R	4
445	253T5812-4		.RETAINER-BRG	P-R	1
447	253T4006-12		.SPACER	P-R	1
450	253T5857-1		.CRANK ASSY	P-R	1
455	MS206155MP		..RIVET- (SIZE DETERMINE ON INST)	P-R	3
460	254N1731-1		..CAM-RTO	P-R	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
06-465	MB544DDNJC		..BEARING- (V06144) (SPEC BACB10AS29) (OPT LLMB544 (V38443)) (OPT MB544-2TS (V43991)) (OPT MB544DDFS428 (V21335)) (OPT MB544TT (V43991)) (OPT MB544DDG20 (V38443)) (OPT MT344E (VK8455)) (OPT MB544DDLY196 (V40920)) (OPT MB544DD (V06144)) (OPT MB544DDSD610 (V83086))	P-R	1
470	MB544DDG20		DELETED		
470A	69-38919-52		..SLEEVE	P-R	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
06-					
475	MKP3ANJC		..BEARING- (V06144) (SPEC BACB10AP3) (OPT MKP3ASD610 (V83086)) (OPT LLMKP3A (V38443)) (OPT MKP3AFS428 (V21335)) (OPT MKP3ATT (V43991)) (OPT MKP3A2TS (V43991)) (OPT MKP3E6531 (V21335)) (OPT MKP3AG20 (V38443)) (OPT MKP3ALY196 (V40920)) (OPT MKP3A (V38443)) (OPT MCS23E (VK8455))	P-R	1
480	253T5858-1		..CRANK	P-R	1
485	NAS6603-4		DELETED		
485A	BACB30NM3K4		.BOLT	P-R	1
490	AN960JD10L		DELETED		
490A	NAS1149D0332J		.WASHER	P-R	2
493	BACW10P5C		.WASHER	P-R	2
495	MS21042L3		DELETED		
495A	H52732-3CD		.NUT- (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))	P-R	1
500	254N1141-1		.COUNTERWEIGHT	P-R	1
505	253T5862-2		.HANDLE ASSY	P-R	1
510	MS21209C0610P		..INSERT	P-R	3
515	MS21209C0415P		..INSERT	P-R	9
520	MS21209C0210P		..INSERT	P-R	4
525	NAS607-3-4P		..PIN-DOWEL	P-R	2
530	MS21209F1-15P		..INSERT	P-R	4
535	MS21209C0820P		..INSERT	P-R	2
540	BACR15BA5AD		..RIVET- (SIZE DETERMINE ON INST)	P-R	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
06-					
545	253U5813-1		..SPACER	P-R	1
546	253T5811-3		DELETED		
550	253T5862-4		..HANDLE	P-R	1
551	253T5852-8		.WIRE BUNDLE ASSY	P-R	1
-552	C2006		..SWITCH- (V81640) (S4) (OPT ITEM 552A)	P-R	2
-552A	P8-4000003		..SWITCH- (V21649) (OPT ITEM 552)	P-R	2
-553	MS24547-1		..SWITCH- (S6)	P-R	4
555	BAC27TCT0017		.DECAL-S6	P-R	1
560	BAC27TCT0157		.DECAL	P-R	1
565	BAC27TCT0015		.DECAL-S4	P-R	1
570	BAC27TCT0034		.DECAL-S10	P-R	1
575	BAC27TCT0013		.DECAL-S2	P-R	1
580	BAC27TCT0032		.DECAL-S8	P-R	1

- Item Not Illustrated

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