



COMPONENT MAINTENANCE MANUAL WITH ILLUSTRATED PARTS LIST

AILERON TAB ROD ASSEMBLY

**PART NUMBER
251A1120-1, -4, -7**

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27-11-34

**COMPONENT MAINTENANCE MANUAL**

Revision No. 11
Jul 01/2009

To: All holders of AILERON TAB ROD ASSEMBLY 27-11-34.

Attached is the current revision to this COMPONENT MAINTENANCE MANUAL

The COMPONENT MAINTENANCE MANUAL is furnished either as a printed manual, on microfilm, or digital products, or any combination of the three. This revision replaces all previous microfilm cartridges or digital products. All microfilm and digital products are reissued with all obsolete data deleted and all updated pages added.

For printed manuals, changes are indicated on the List of Effective Pages (LEP). The pages which are revised will be identified on the LEP by an R (Revised), A (Added), O (Overflow, i.e. changes to the document structure and/or page layout), or D (Deleted). Each page in the LEP is identified by Chapter-Section-Subject number, page number and page date.

Pages replaced or made obsolete by this revision should be removed and destroyed.

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TRANSMITTAL LETTER

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Location of Change

Description of Change

NO HIGHLIGHTS

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HIGHLIGHTS

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2	BLANK	27-11-34 REPAIR - GENERAL			
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A = Added, R = Revised, D = Deleted, O = Overflow

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ASSEMBLY	701
FITS AND CLEARANCES	(Not Applicable)
SPECIAL TOOLS, FIXTURES, AND EQUIPMENT	(Not Applicable)
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**COMPONENT MAINTENANCE MANUAL****TEMPORARY REVISION AND SERVICE BULLETIN RECORD**

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVE	DATE OF INCORPORATION INTO MANUAL
27-1224		PRR 38275-2	JUL 01/02

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TR AND SB RECORD

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Mar 01/2006

All revisions to this manual will be accompanied by transmittal sheet bearing the revision number. Enter the revision number in numerical order, together with the revision date, the date filed and the initials of the person filing.

[illegible]

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When the temporary revision is incorporated or cancelled, and the pages are removed, enter the date the pages are removed and the initials of the person who removed the temporary revision.

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COMPONENT MAINTENANCE MANUAL

INTRODUCTION

1. General

- A. The instructions in this manual supply the data necessary to do the maintenance functions together with the test, fault isolation, repair, and replacement of the defective parts.
- B. This manual is divided into different parts:
 - (1) Title Page
 - (2) Transmittal Letter
 - (3) Highlights
 - (4) List of Effective Pages
 - (5) Table of Contents
 - (6) Temporary Revision & Service Bulletin Record
 - (7) Record of Revisions
 - (8) Record of Temporary Revisions
 - (9) Introduction
 - (10) Procedures & IPL Sections
- C. Components that can be repaired have a different repair number for each specified repair. To find the repair number location of a component, look in the Repair-General procedure at the beginning of the REPAIR section. The Repair-General procedure also has an explanation of the True Position Dimension symbols used.
- D. All dimensions, measures, quantities and weights included are in English units. When metric equivalents are given they will be in the parentheses that follow the English units.
- E. The introduction to the Illustrated Parts List (IPL) shows how the IPL data is used.
- F. Design changes, optional parts, configuration differences and Service Bulletin modifications may cause different part numbers. These part numbers are identified in the IPL with an alphabetical letter which is added to the end of the basic item number. This new item number is referred to as an alpha-variant. Throughout the manual, IPL basic item number references also apply to alpha-variants unless shown differently.
- G. The tool reference numbers found in the individual procedures and in the Special Tools, Fixtures, and Equipment section are used to identify if a tool is a standard tool (STD-XXXX), a commercial tool (COM-XXXX), or a Special Tool (SPL-XXXX). This reference number is also used to distinguish between tools with similar names in the same procedure. These reference numbers are for use in the documentation only. They are not to be used for ordering tools.

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INTRODUCTION

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COMPONENT MAINTENANCE MANUAL

AILERON TAB CONTROL ROD ASSEMBLY - DESCRIPTION AND OPERATION

1. Description

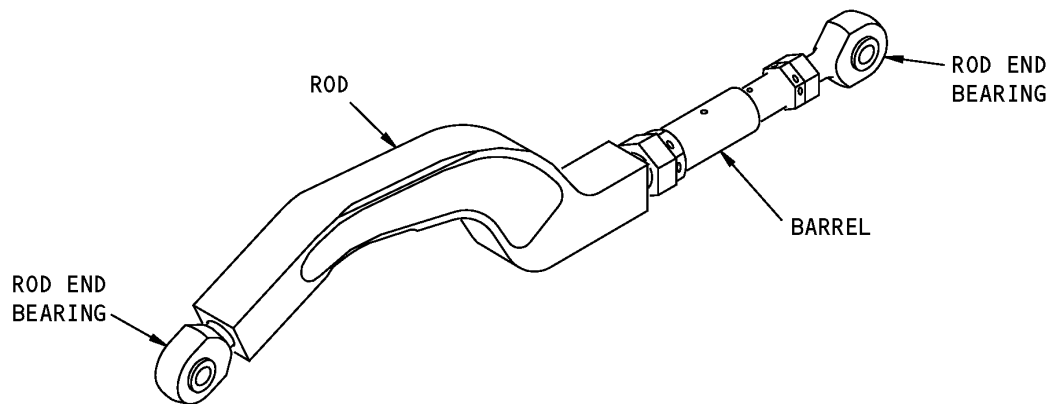
- A. The aileron tab control rod assembly includes an aluminum rod, a plug, barrel, and two rod end bearings.

2. Operation

- A. The aileron tab control rod moves the balance tab relative to aileron motion. Aerodynamic forces on the tab make it easier for the pilot to move the aileron for better lateral control during manual flight.

3. Leading Particulars (Approximate)

- A. Length – 11 inches
B. Width – 0.5 inch
C. Height – 2.25 inches
D. Weight – 0.5 pound



Aileron Tab Control Rod Assembly
Figure 1

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DESCRIPTION AND OPERATION

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TESTING AND FAULT ISOLATION

(NOT APPLICABLE)

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TESTING AND FAULT ISOLATION

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COMPONENT MAINTENANCE MANUAL

DISASSEMBLY

1. General

- A. This procedure has the data necessary to disassemble the aileron tab control rod assembly.
- B. Disassemble this component sufficiently to isolate the defects, do the necessary repairs, and put the component back to a serviceable condition.
- C. Refer to IPL Figure 1 for item numbers.

2. Disassembly

- A. Procedure
 - (1) Use standard industry procedures to disassemble this component.

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DISASSEMBLY

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CLEANING

1. General

- A. This procedure has the data necessary to clean the aileron tab control rod assembly.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 1 for item numbers.

2. Cleaning

A. References

Reference	Title
SOPM 20-30-03	GENERAL CLEANING PROCEDURES

B. Procedure

- (1) Use standard industry procedures and the instructions in SOPM 20-30-03 to clean all parts but the bearings.
- (2) Clean the bearings (10, 35) by the vendor's instructions.

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CLEANING
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CHECK

1. General

- A. This procedure has the data necessary to find defects in the specified parts.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 1 for item numbers.

2. Check

A. References

Reference	Title
SOPM 20-20-01	MAGNETIC PARTICLE INSPECTION
SOPM 20-20-02	PENETRANT METHODS OF INSPECTION

B. Procedure

- (1) Use standard industry procedures to do a visual check of all the parts for defects. Do the penetrant or magnetic particle check if the visual check shows possible damage on the parts listed below:
- (2) Do a magnetic particle check (SOPM 20-20-01) of barrel (20).
- (3) Do a penetrant check (SOPM 20-20-02) of rod (50).

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CHECK
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**COMPONENT MAINTENANCE MANUAL****REPAIR****1. General**

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

Table 601:

PART NUMBER	NAME	REPAIR
—	REFINISH OF OTHER PARTS	1-1
251A1120	ROD ASSEMBLY	2-1, 2-2
69-60084	PLUG	2-3

2. Dimensioning Symbols

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

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REPAIR - GENERAL

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COMPONENT MAINTENANCE MANUAL

REFINISH OF OTHER PARTS - REPAIR 1-1

1. General

- A. This procedure has the data necessary to refinish the parts which are not given in the specified repairs.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 1 for item numbers.

2. Refinish of Other Parts

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I
C00700	Coating - Exterior Protective Enamel, Gray Gloss Enamel	BMS10-60, Type I, BAC 707
C50050	Coating - Exterior Protective Enamel, White Gloss Color (BAC 702)	BMS10-60, Type I

B. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

C. Procedure

NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Instructions for the repair of the parts listed in REPAIR 1-1, Table 601 is for repair of the initial finish.

Table 601: Refinish Details

IPL FIG. & ITEM	MATERIAL	FINISH
Barrel (20)	4340 Steel, 180-200 ksi	Cadmium plate (F-15.02) on all surfaces. Apply primer, C00259 (F-20.02) and enamel coating, C50050 (F-14.9812, which replaces SRF-14.9812) on exterior surfaces only.
Barrel (20A,20B)	4340 Steel, 180-200 ksi	Cadium plate (F-15.02) on all surfaces. Apply primer, C00259 (F-20.02) and enamel coating, C00700 (F-14.9813) on exterior surfaces only.

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REPAIR 1-1

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ROD ASSEMBLY - REPAIR 2-1

251A1120-2, -6

1. General

- A. This procedure has the data necessary to repair and refinish the rod assembly (25).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 1 for item numbers.

2. Rod End Bearing Replacement

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95

- B. References

Reference	Title
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-04	MISCELLANEOUS MATERIALS

- C. Procedure (REPAIR 2-1, Figure 601)

NOTE: For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Remove the rod end bearing (35) from the rod (50) (SOPM 20-50-03).
- (2) Remove the plug (45) from the rod (50).
- (3) If you find defects on the plug, refer to REPAIR 2-3 for repair instructions.
- (4) Apply sealant, A00247 to the shank of the replacement rod end bearing (35) and install it into the rod (50) with new rivets (30A).
- (5) Apply sealant, A00247 to the shank of the replacement plug (45) and install it into the rod (50) with new rivets (40),

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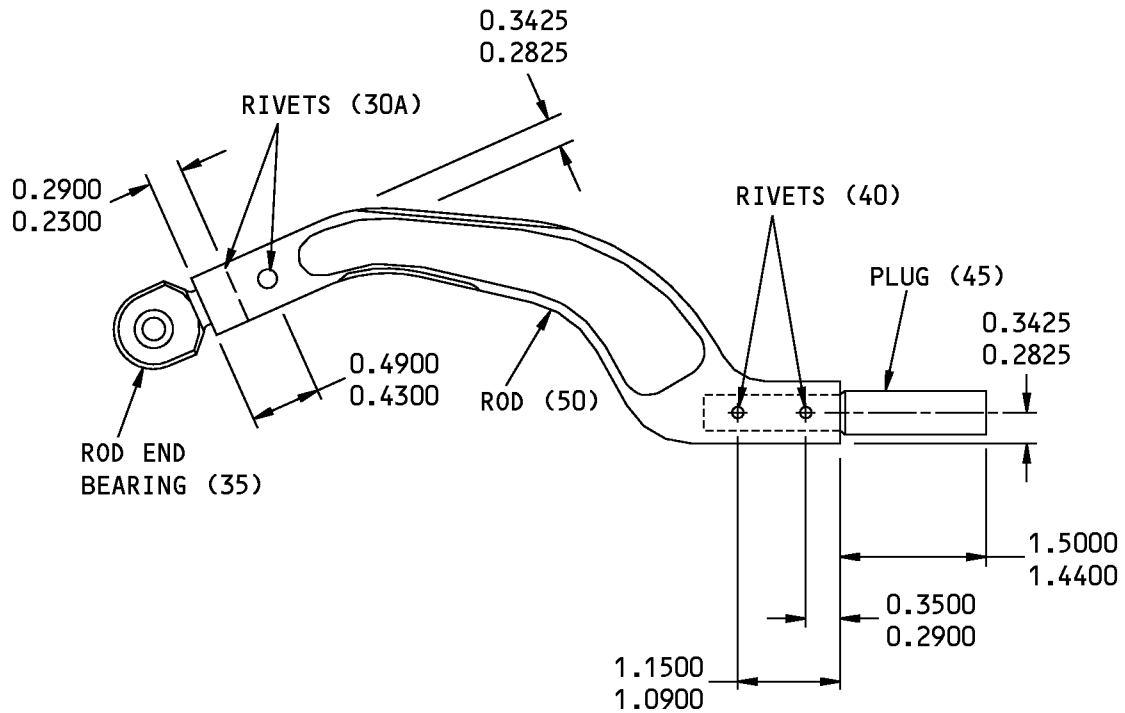
REPAIR 2-1

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ITEM NUMBERS REFER TO IPL FIG. 1
ALL DIMENSIONS ARE IN INCHES

G11788 S0004991812_V2

251A1120-2,-6 Rod Assembly Repair
Figure 601

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REPAIR 2-1
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ROD - REPAIR 2-2

251A1120-3, -5

1. General

- A. This procedure has the data necessary to refinish the rod (50).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 1 for item numbers.

2. Rod Refinish

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I
C00304	Coating - Teflon Filled, Non Decorative, Sprayable Material	BMS 10-86 Type I

- B. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

- C. Procedure

NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31) all over.
- (2) Apply primer, C00259 (F-20.03) but not in the holes at each end of the rod.
- (3) For rod (50A), apply abrasion resistant teflon coating, C00304, color BAC707 gray (F14.9625). Apply to indicated surface (Ref. REPAIR 2-2, Figure 601). Overspray allowed on all surfaces except end bores.

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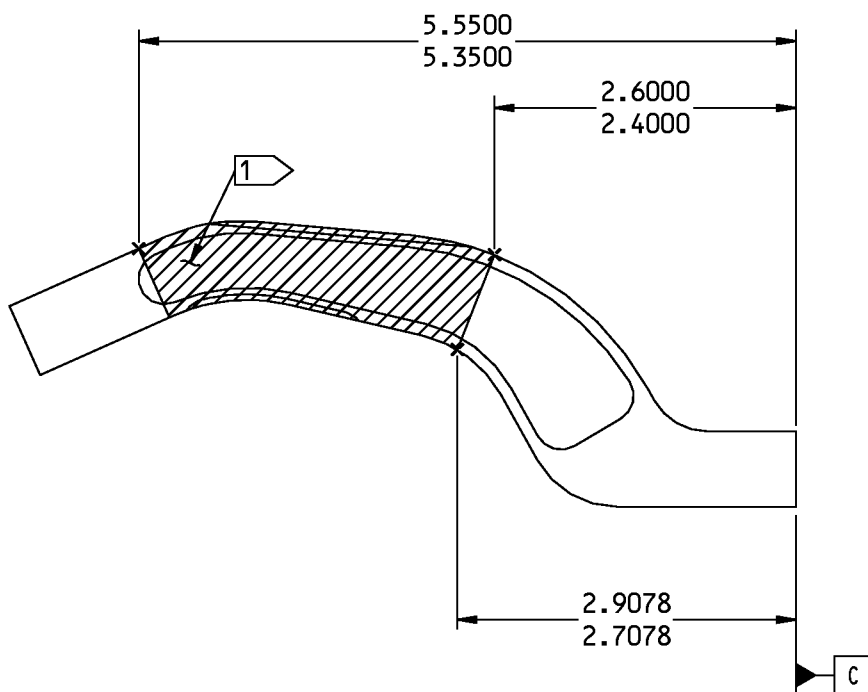
REPAIR 2-2

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COMPONENT MAINTENANCE MANUAL



1 APPLY BMS 10-86, TYPE 1 OR
TYPE 2, ABRASION RESISTANT
TEFLON COATING, COLOR BAC707
GRAY (F-14.9625)

ALL DIMENSIONS ARE IN INCHES

1530586 S0000264561_V1

Rod Refinish 251A1120-5
Figure 601

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REPAIR 2-2
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COMPONENT MAINTENANCE MANUAL

PLUG - REPAIR 2-3

69-60084-1

1. General

- A. This procedure has the data necessary to refinish the plug (45).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 1 for item numbers.

2. Plug Refinish

- A. Procedure (REPAIR 2-3, Figure 601)

NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Cadmium plate (F-15.02) except as noted in REPAIR 2-3, Figure 601.
- (2) Apply corrosion preventative compound, C50001 (F-19.03) as shown.

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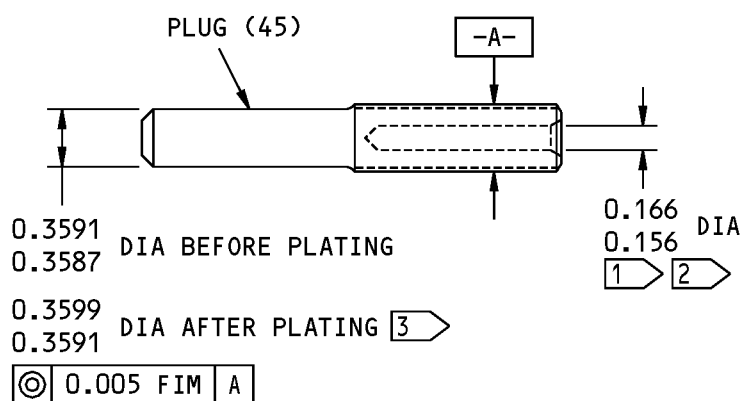
REPAIR 2-3

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- 1 PLATING OPTIONAL IN THIS AREA
- 2 APPLY CORROSION PREVENTIVE COMPOUND (F-19.03) IN THIS AREA
- 3 CADMIUM PLATE (F-15.02)

69-60084-1 Plug Refinish
Figure 601

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REPAIR 2-3

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COMPONENT MAINTENANCE MANUAL

ASSEMBLY

1. General

- A. This procedure has the data necessary to assemble the aileron tab control rod assembly.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 1 for item numbers.

2. Assembly

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
C00913	Compound - Corrosion Inhibiting Material, Nondrying Resin Mix	BMS 3-27
G50136	Paste - Corrosion Inhibiting, Non-drying	BMS 3-38

- B. References

Reference	Title
SOPM 20-60-02	FINISHING MATERIALS

- C. Procedure for 251A1120-1, -4 (ASSEMBLY, Figure 701)

NOTE: For finishing materials, refer to SOPM 20-60-02.

- (1) Install the barrel (20) and the rod end bearing (10) on the plug (45).

WARNING: BMS 3-27 CORROSION PREVENTIVE COMPOUND CONTAINS ASBESTOS, TOLUENE, XYLENE, STRONTIUM CHROMATE AND BARIUM CHROMATE. SPEAK TO THE APPLICABLE SAFETY-STANDARDS PERSONS FOR APPROVED HANDLING PRECAUTIONS.

CAUTION: BMS 3-27 COMPOUND IS USED ONLY IN STATIC JOINTS WHERE GREASE CANNOT BE APPLIED. BMS 3-27 COMPOUND IN DYNAMIC JOINTS WILL NOT LET THEM MOVE FREELY.

- (a) Apply compound, C00913 to the rod end bearing (10) threads. Turn the nut (5) on the rod end bearing (10) threads. Install the rod end bearing (10) in the barrel (20).
- (b) Adjust the length as shown.

- D. Procedure for 251A1120-7

- (1) Install the barrel (20) and the rod end bearing (10) on the plug (45).
- (2) Apply corrosion inhibiting non-drying paste, G50136 to the plug (45) threads. Install the nut (15) and the barrel (20) on the plug).
- (3) Apply corrosion inhibiting non-drying paste, G50136 to the rod end bearing (10) threads. Turn the nut (5) on the rod end bearing (10) threads. Install the rod end bearing (10) in the barrel (20).
- (4) Adjust the length as shown.

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ASSEMBLY

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3. Storage

A. References

Reference	Title
SOPM 20-44-02	TEMPORARY PROTECTIVE COATINGS

B. Procedure

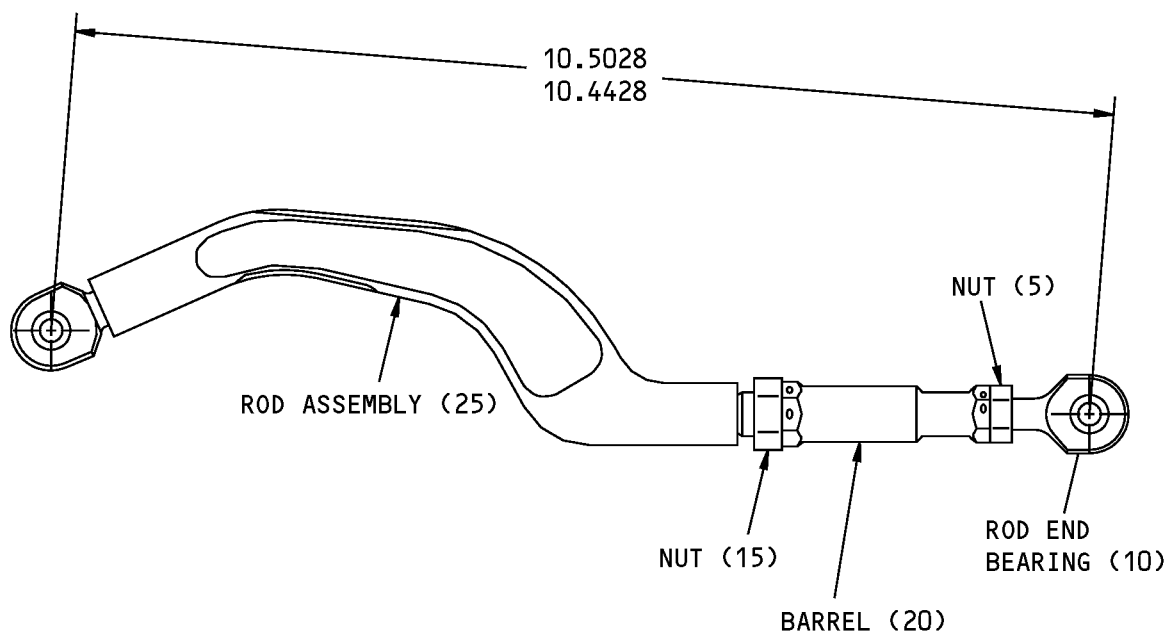
- (1) Attach a tag to the control rod with the following statement:
 - (a) Jamnuts must be tightened to torques specified in AMM installation procedures after the control rod goes through final adjustment on the airplane.
- (2) Use standard industry practices and information in SOPM 20-44-02 to store this component.

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ASSEMBLY
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ITEM NUMBERS REFER TO IPL FIG. 1
ALL DIMENSIONS ARE IN INCHES

Assembly Details
Figure 701

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ASSEMBLY
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FITS AND CLEARANCES

(NOT APPLICABLE)

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FITS AND CLEARANCES

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COMPONENT MAINTENANCE MANUAL

SPECIAL TOOLS, FIXTURES, AND EQUIPMENT

(NOT APPLICABLE)

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SPECIAL TOOLS, FIXTURES, AND EQUIPMENT

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COMPONENT MAINTENANCE MANUAL

ILLUSTRATED PARTS LIST

1. Introduction

- A. The Illustrated Parts List (IPL) contains an illustration and a list of component parts you can repair or replace. The Illustrated Parts Catalog (IPC) shows how to use the Boeing part number system.
- B. This shows how parts are related: The relation of each item to its next higher assembly (NHA) is shown in the NOMENCLATURE column. Use the indenture system that follows:

1	2	3	4	5	6	7
.	Assembly					
.	Attaching parts for assembly					
.	.	Detail parts for assembly				
.	.	Subassembly				
.	.	Attaching parts for subassembly				
.	.	.	Detail parts for subassembly			
.	.	.	Sub-subassembly			
.	.	.	Attaching parts for subassembly			
.	.	.	.	Details parts for sub-subassembly		

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

- C. Each top assembly is given one use code letter (A, B, C, etc.) in the USAGE CODE column. All subsequent component parts in the list can have one or more of the use code letters to show effectivity to top assemblies. A component part without a use code applies to all top assemblies.
- D. An alphabetical letter is added after the item number for optional parts, parts changed by a Service Bulletin, configuration differences (except left-handed and right-handed parts), last engineering releases, and parts added between item numbers in a sequence. The alphabetical letter will not be shown on the illustration for equivalent parts of the same part number.
- E. Color-coded parts are identified with a single digit alpha following the dash number or with "SP" suffix. If the "SP" suffix is used, it represents consolidation of all color codes applicable for a given usage which are not separately listed. Orders for color-coded parts should include the registry number of the airplane for which the parts are ordered.
- F. If a part number is 15 characters long but will not fit in the part number column, the part number will be displayed with a "~" at the end of the line and will be continued on the next line. The "~" denotes that the part number continues on the next line.
- G. Parts changed by a Service Bulletin are shown by PRE SB XXXX and POST SB XXXX added to the NOMENCLATURE column.
- (1) When a new top assembly is added by a Service Bulletin, PRE SB XXXX and POST SB XXXX will be added at the top assembly level only. The configuration differences at the detail part level are shown by use code letters.
- (2) When the top assembly part number is not changed by the Service Bulletin, PRE SB XXXX and POST SB XXXX will be added at the detail level.
- H. Interchangeable Parts

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ILLUSTRATED PARTS LIST

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Optional (OPT)	The part is optional to and interchangeable with other parts that have the same item number.
Replaces, Replaced by and not interchangeable with (REPLACES, REPLACED BY AND NOT INTCHG/W)	The part replaces and is not interchangeable with the initial part.
Replaces, Replaced by (REPLACES, REPLACED BY)	The part replaces and is interchangeable with, or is an alternative to, the initial part.

VENDOR CODES

Code	Name
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.

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COMPONENT MAINTENANCE MANUAL

NUMERICAL INDEX

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
251A1120-1		1	1A	RF
251A1120-2		1	25	1
251A1120-3		1	50	1
251A1120-4		1	1B	RF
251A1120-5		1	50A	1
251A1120-6		1	25A	1
251A1120-7		1	1C	RF
69-60083-1		1	20	1
69-60083-2		1	20B	1
69-60083-3		1	20A	1
69-60084-1		1	45	1
BACR15BA5AD13C		1	30A	2
BACR15FT5AD		1	40	2
BACR15FT5AD13C		1	40A	2
NAS509-5		1	5	1
NAS509-7		1	15	1
SM4-5E1-503		1	10	1
SPH4-6A1-503		1	35	1

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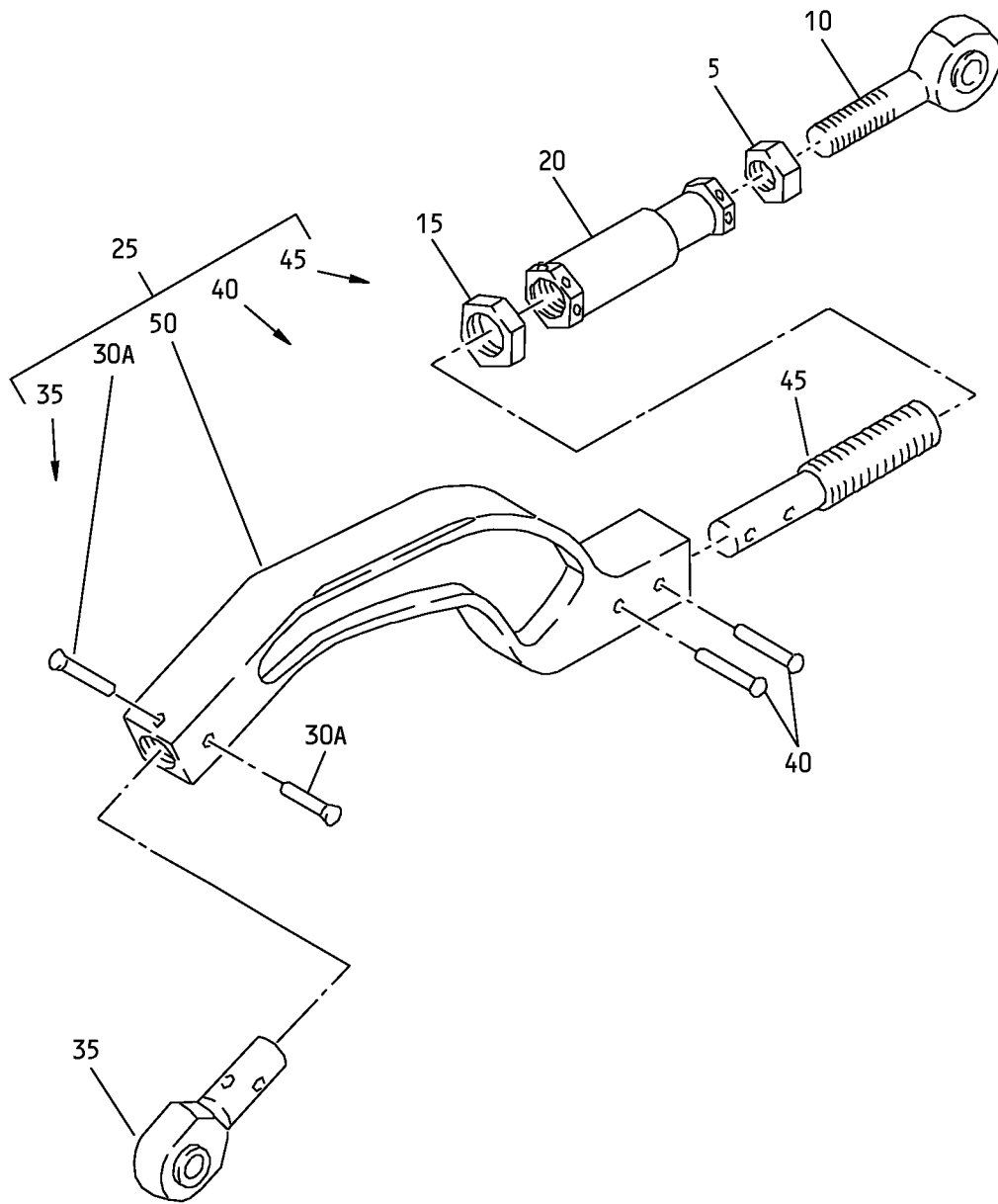
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COMPONENT MAINTENANCE MANUAL



G11794 S0004991820_V2

Aileron Tab Control Rod Assembly
IPL Figure 1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1—					
—1A	251A1120-1		ROD ASSY-AILEVON TAB	A	RF
—1B	251A1120-4		ROD ASSY-AILEVON TAB	B	RF
—1C	251A1120-7		ROD ASSY-AILEVON TAB	C	RF
5	NAS509-5		. NUT		1
10	SM4-5E1-503		. BEARING-ROD END (V77896)		1
15	NAS509-7		. NUT		1
20	69-60083-1		. BARREL (PRE SB 737-27-1224)	A	1
—20A	69-60083-3		. BARREL (OPT ITEM 20B) (POST SB 737-27-1224)	B, C	1
—20B	69-60083-2		. BARREL (OPT ITEM 20A) (POST SB 737-27-1224)	B, C	1
25	251A1120-2		. ROD ASSY	A, B	1
—25A	251A1120-6		. ROD ASSY	C	1
30	BACR15BA5AD		DELETED		
30A	BACR15BA5AD13C		. . RIVET		2
35	SPH4-6A1-503		. . BEARING-ROD END (V77896)		1
40	BACR15FT5AD		. . RIVET (SIZE DETERMINED ON INST)	A, B	2
40A	BACR15FT5AD13C		. . RIVET	C	2
45	69-60084-1		. . PLUG		1
50	251A1120-3		. . ROD	A, B	1
—50A	251A1120-5		. . ROD	C	1

—Item not Illustrated

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