



COMPONENT MAINTENANCE MANUAL WITH ILLUSTRATED PARTS LIST

CFM56-7B TURBINE EXHAUST PRIMARY NOZZLE ASSEMBLY

**PART NUMBER
314A2610-1, -62, -68**

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78-11-37



COMPONENT MAINTENANCE MANUAL

Revision No. 9
Jul 01/2009

To: All holders of CFM56-7B TURBINE EXHAUST PRIMARY NOZZLE ASSEMBLY 78-11-37.

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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**COMPONENT MAINTENANCE MANUAL****Location of Change**

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FRONTMATTER

CHECK

REPAIR 1-1

REPAIR 1-2

ILLUSTRATED PARTS LIST

Description of Change

Changed the part number information on the title page.

Added nontechnical change.

Added new assemblies to procedure.

Added new assemblies to procedure.

Changed the data in the NUMERICAL INDEX list.

Added new Illustrated Parts List.

Updated the IPL.

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HIGHLIGHTS

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2	BLANK	78-11-37 REPAIR 1-1		R 1019	Jul 01/2009
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A = Added, R = Revised, D = Deleted, O = Overflow

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SPECIAL TOOLS, FIXTURES, AND EQUIPMENT	(Not Applicable)
ILLUSTRATED PARTS LIST	1001



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TEMPORARY REVISION AND SERVICE BULLETIN RECORD

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVE	DATE OF INCORPORATION INTO MANUAL
		PRR 38001 PRR 38021 737-SL-78-060-B	JUN 01/97 JUN 01/97 MAR 01/09

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TR AND SB RECORD

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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.

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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

CFM56-7B TURBINE EXHAUST PRIMARY NOZZLE ASSEMBLY - DESCRIPTION AND OPERATION

1. Description

- A. The primary nozzle assembly is made of a welded sleeve assembly to which are fastened a fairing assembly, labyrinth seal assemblies, and sheet metal fences. The inner sleeve, fairing, labyrinth details, and fences are all made of Nickel alloy 625 sheet metal. An attach ring on the front face of the inner sleeve is used to attach the primary nozzle assembly to the engine.

2. Operation

- A. The primary nozzle assembly, together with the primary plug assembly (Refer to CMM 78-11-38), is used to control the expansion of the exhaust from the engine.

3. Leading Particulars (Approximate)

- A. Length – 44 inches
- B. Diameter – 29-38 inches
- C. Weight – 112 pounds

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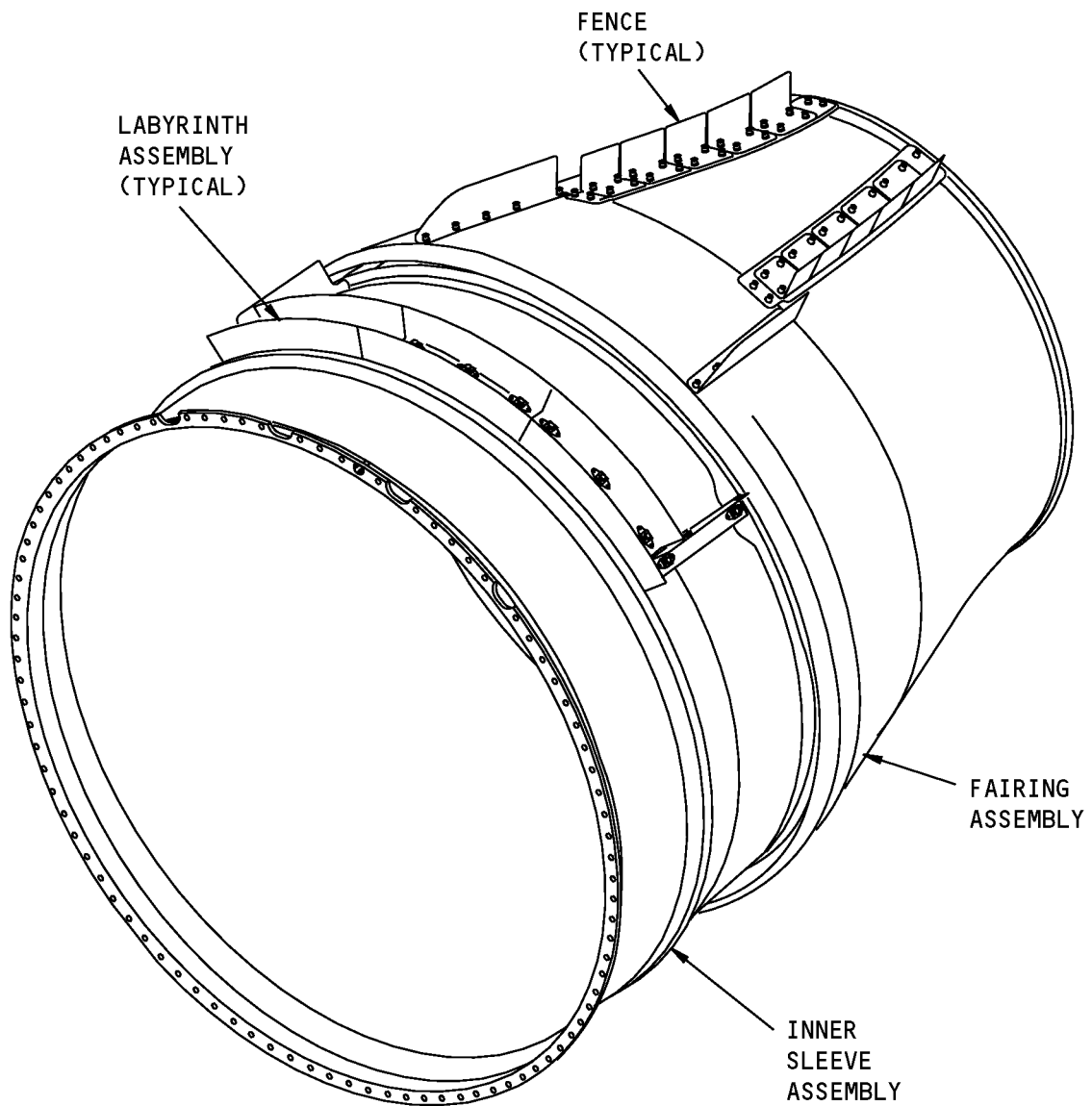
DESCRIPTION AND OPERATION

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Primary Nozzle 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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DISASSEMBLY

1. General

- A. Disassemble this component sufficiently to isolate the defects, do the necessary repairs, and put the component back to a serviceable condition.

2. Disassembly

- A. Procedure

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

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DISASSEMBLY

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CLEANING

(NOT APPLICABLE)

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CLEANING
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CHECK

1. General

- A. This procedure has the data necessary to find defects in the material of the specified parts.
- B. Refer to the 737 Structural Repair Manual (SRM) 54-40-02 to find the applicable limits of permitted damage.
- C. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- D. Refer to IPL Figure 1 for item numbers.

2. Check

A. Procedure

- (1) Use standard industry procedures to do a visual check of all the parts for defects.
- (2) Do a check of the fairing skin (290) and the skin of the inner sleeve assembly (300) for dents, nicks, or pitting.
- (3) If the visual check shows possible damage, or if you suspect possible damage, do a penetrant check (SOPM 20-20-02) of the primary nozzle assembly.
- (4) Make sure that the attach ring at the front of the inner sleeve assembly (300) is flat to within ± 0.010 inch, when it is attached to a surface plate. The hold-down force at each fastener location must not be more than 500 pounds.
- (5) Do a check of the aerodynamic smoothness of the outer contour of the primary nozzle assembly as follows.
 - (a) Make sure that the step from the trailing edge of the fairing assembly (280) to the inner sleeve assembly (300) is 0.040-0.070 inch. Refer to CHECK, Figure 501.

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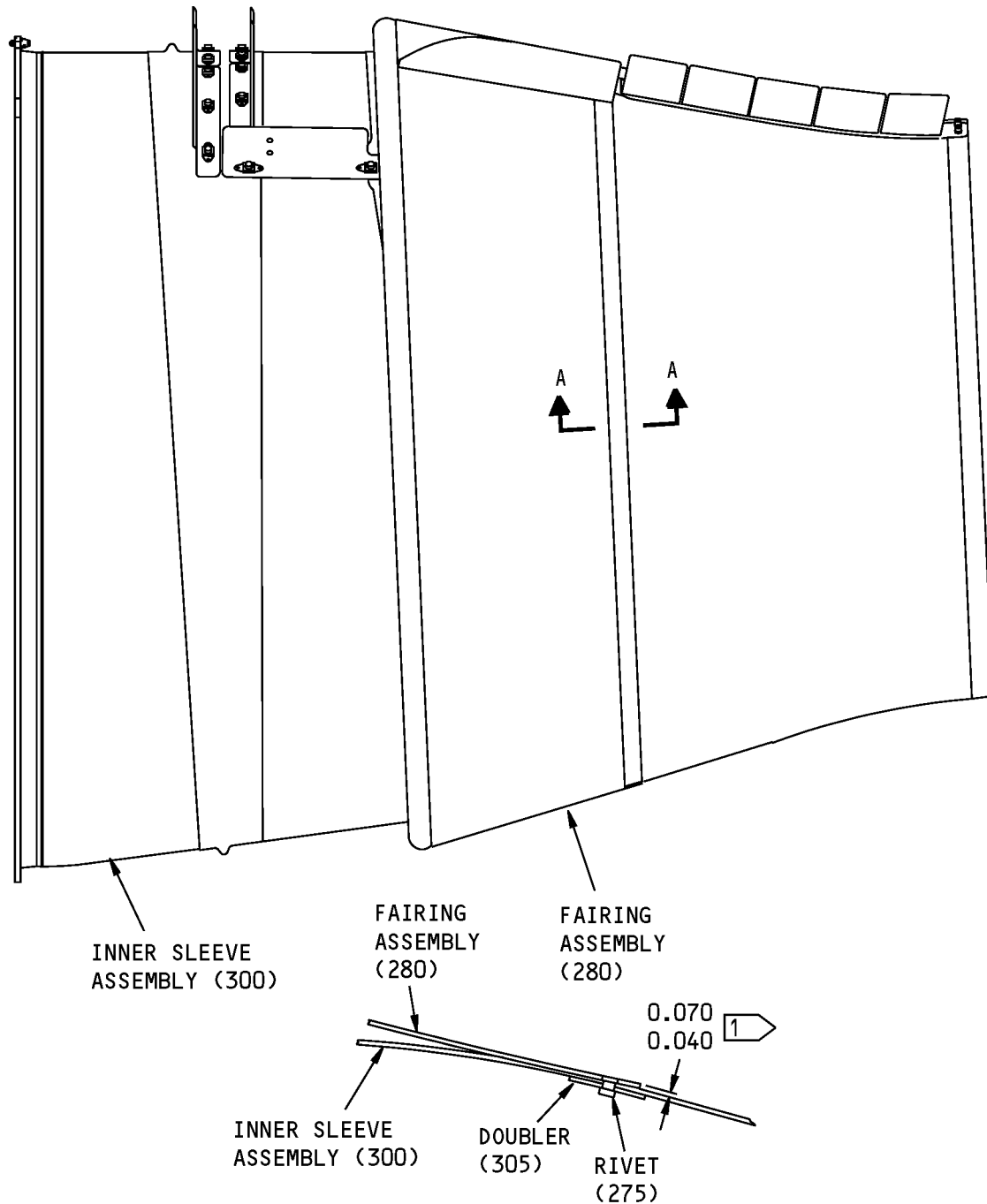
CHECK

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NOZZLE FAIRING TRAILING EDGE

A-A

1 MEASUREMENT OF STEP AT TRAILING
EDGE

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

Check of Aerodynamic Smoothness
Figure 501

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CHECK

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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
314A2610	PRIMARY NOZZLE ASSEMBLY	1-1, 1-2

**COMPONENT MAINTENANCE MANUAL****PRIMARY NOZZLE ASSEMBLY - REPAIR 1-1****314A2610-1, -62, -68****1. General**

- A. This procedure has the data necessary to replace a fence on the primary nozzle assembly.
- B. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 1 for item numbers.

2. Fence Replacement

- A. Make marks on the nozzle skin to show the locations of the damaged fences (215 thru 260) before they are removed.
NOTE: The marks will help you install the new fences in the correct locations.
- B. Remove the damaged fence (215 thru 260) by removing the applicable bolts (190, 195), collars (200).
NOTE: Remove and replace fences (215 thru 260) one at a time. This will help you install the new fences in the correct location and relation to each other.
- C. Put the new fence in the correct position on the nozzle skin or fairing. For the aft fences (215 thru 260), make sure that the vertical parts of the fences are co-planar within ± 0.030 inch. The gap between adjacent fences (215 thru 260) must be 0.050-0.110 inch.
- D. Drill 0.1895-0.1905 inch diameter holes in the new fence. Use the existing holes in the nozzle as a pattern.
- E. Install the bolts (190, 195), collars (200) to attach the fence. Make sure the fence sections stay co-planar within ± 0.030 inch.

3. Fence Replacement

- A. Make marks on the nozzle skin to show the locations of the damaged fences (205, 210) before they are removed.
NOTE: The marks will help you install the new fences in the correct locations.
- B. Remove the damaged fence (205 or 210) by loosening the collars (200) that secure the fence to the nozzle. Lift the fence up to allow a piece of lockwire to be wound around the threads of the forward four (4) bolts (190, 195) to prevent these bolt from falling through the hole into the nozzle fairing cavity. Remove the aft most bolt (193).
NOTE: Failure to properly secure the forward four bolts with lockwire can result in the bolts falling through the hole into the nozzle fairing cavity.
- C. Remove the collars (200) and fence (205, 210), leaving the bolts in their holes in the nozzle fairing.
- D. Match drill fastener holes (0.1895 - 0.1905 inch diameter) in the new fence using the removed fence as a template.
- E. Match drill the one fastener hole (0.1895 - 0.1905 inch diameter) in the new filler (202A, 204A) using the new fence (205B, 210B) as a template.
NOTE: Make sure the curved radius of the filler is seated against the curved section of the fence.
- F. Install and temporarily secure the replacement fence using the existing four (4) bolts (190, 195) with new collars (200).

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- G. Install the new filler (202A, 204A) at the aft (fifth) bolt hole location. Use bolt (193B) and temporarily secure with a new collar (200).
- H. Once the collars are engaged, remove lockwire from the forward four (4) bolts (190, 195) and the aft bolt (193B) and tighten the collars to 25-35 pound-inches to break off the collar end. Make sure the fence sections stay co-planar within ± 0.030 inch with the other fences.

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PRIMARY NOZZLE ASSEMBLY - REPAIR 1-2

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1. General

- A. This procedure has the data necessary to repair cracks, holes, and punctures in the primary nozzle assembly.

NOTE: Cracks, holes, or punctures are not permitted in the attach rings, stiffeners, or doublers.

- B. You can repair the crack, hole, or puncture in the primary nozzle assembly if the maximum dimension of the damaged area is not more than 25 inches.
- C. Refer to 737 SRM 54-40-02 for repair of other types of damage, such as nicks, scratches, gouges, dents, or wrinkles.
- D. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.
- E. Refer to IPL Figure 1 for item numbers.

2. Repair of a Cracked Nozzle Assembly

NOTE: For forming, straightening and fitting metal parts (Boeing process specification), refer to BAC 5300,. For radiologic inspection (Boeing process specification), refer to BAC 5915. For cleaning materials, refer to SOPM 20-60-01. For miscellaneous materials, refer to SOPM 20-60-04.

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
B00148	Solvent - Methyl Ethyl Ketone (MEK)	ASTM D740
E50001	Solvent - Acetone	0-A-51, Grade 1
G50398	Pad - Abrasive	
G50403	Filler - Welding, Nickel Alloy 625, Inconel 625	BMS 7-38, Type 7

- B. References

Reference	Title
BAC 5300,	Forming, Straightening, and Fitting Metal Parts Blanking Sonic Area Edges
BAC 5915	Process Specification for Radiographic Inspection
BAC 5975	Boeing Process Specification for Fusion Welding of Metal
SOPM 20-20-02	PENETRANT METHODS OF INSPECTION
SOPM 20-30-03	GENERAL CLEANING PROCEDURES
SOPM 20-60-01	CLEANING MATERIALS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

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C. Examine the crack in the nozzle assembly.

- (1) Replace the part if the crack is less than 2.0 inches from an edge, fastener, another crack, or other damage, or if the crack divides.
- (2) You can repair a crack that goes at approximately a right angle to a weld line. You can also repair a crack that is parallel to the weld if it is more than 0.5 inch from the weld. If a crack is parallel to the weld but less than 0.5 inch from the weld, replace the part.

D. Prepare the crack area for the weld repair.

- (1) Clean an area of at least one inch on each side of the crack. Use an approved cleaner which will remove carbon or soot (SOPM 20-30-03).
- (2) Clean the area again with steam.
- (3) Do a penetrant check (SOPM 20-20-02) of the full length of the crack to find the ends of the crack. Do steps REPAIR 1-2, Paragraph 2.D.(1) and REPAIR 1-2, Paragraph 2.D.(2) again, if necessary, to find the ends of the crack.

NOTE: Do not repair the part if the penetrant check shows that the crack divides. The part must be replaced.

(4) Drill the stop holes at the ends of the crack.

- (a) Drill 0.1875-inch diameter stop holes at the ends of the crack.
- (b) Do a penetrant check of the stop holes.
- (c) If the penetrant check shows that the crack does not extend through the holes, increase the hole size to 0.2500-inch diameter. Go to step REPAIR 1-2, Paragraph 2.D.(5).

NOTE: These larger holes are insurance cuts to make sure that the crack is stopped.

- (d) If the crack extends through the first 0.1875-inch diameter stop holes, drill the 0.2500-inch diameter holes as oversize stop holes.

NOTE: If the crack extends through the stop holes, it is possible that the ends of the crack were not identified correctly. Clean the area and do the penetrant check carefully to make sure you can identify the ends of the crack.

- (e) Do a penetrant check of the oversize stop holes to make sure that the crack is stopped.
- (f) Drill 0.3125-inch diameter holes as insurance cuts.
- (5) Use Scotch-Brite Type S, G50398 to remove all colored oxide film from the crack and from an area of at least one inch all around the crack.

NOTE: Do not use a wire brush or a different abrasive cleaner as an alternative for Scotch-Brite Type S, G50398. weld filler, G50403 only polishes the oxide film but does not remove it.

- (6) Wipe the cleaned area or rinse with water to remove all of the remaining oxide.
- (7) Flush the crack and the adjacent area with MEK solvent, B00148 or acetone solvent, E50001. Use a 300-series CRES wire brush to remove the remaining carbon or soot from the crack.

NOTE: If the repair area is not clean, the weld repair may not be satisfactory.

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- (8) Rinse the repair area fully with cold water, and dry the area with clean filtered air or with a clean cloth which has no lint.

NOTE: Parts to be welded must be kept clean and dry. There must be no oil, grease, fingerprints, or other contamination on the cleaned surface. Handle the parts with clean gloves.

E. Do the weld repair.

- (1) Do the gas-tungsten-arc-weld (GTAW) procedure and the steps that follow to repair the crack. Use argon gas or a mixture of argon and helium gases, and Nickel alloy weld filler, G50403. It is not necessary to do a stress relief procedure after the weld repair. Refer to BAC 5975 for more data.
 - (a) Use copper chill blocks to keep warping to a minimum.
 - (b) Keep the weld bead to the minimum size necessary to get a satisfactory repair.
 - (c) Make sure you get a 100% penetration with the weld.
 - (d) Grind the weld until it is smooth to the adjacent skin within 0.000 to +0.010 inch, with a surface finish of 32 microinches or better. Be careful not to grind into the base metal.
 - (e) Use 10-power magnification to do a visual check of the repair.
 - (f) Do a penetrant or radiographic (X-ray) check of the weld zone. Make sure there are no cracks. Porosity and inclusions must not be more than 0.020 inch long, and must not have sharp edges.

3. Repair of Holes and Punctures in the Skins of the Nozzle Assembly

NOTE: All holes and punctures must be repaired before the part can go back into service.

A. Do a check of the condition of the hole or puncture.

- (1) A hole or puncture to be repaired with a rivet filler plug must be a minimum of 1.0 inch from frames, fasteners, edges, or other damage.
- (2) A hole or puncture to be weld repaired must be a minimum of 2.0 inches from frames, fasteners, edges, or other damage.

B. Prepare the hole or puncture for the repair.

- (1) Remove burrs and cracks from the edges of the hole or puncture, then grind the area smooth.
- (2) If the hole is smaller than 0.375 inch in diameter, drill the hole to the next larger standard drill dimension. If the hole is 0.375 inch in diameter or less after the clean-up, fill the hole with an NAS1198 rivet (or equivalent A286 corrosion resistant steel rivet).
- (3) If the hole is larger than 0.375 inch in diameter after the clean-up, do a doubler repair or welded patch repair of the hole. If the hole or puncture is longer than 0.375 inch, but less than 0.19 inch wide, you can repair it with weld filler material as an alternative to the doubler or patch repair procedures.

NOTE: Refer to 737 SRM 54-40-02 for the doubler repair procedure.

C. Do the welded patch repair of the hole or puncture.

- (1) Machine the hole, if necessary, to make the cutout into a smooth, regular shape (approximately a triangle, rectangle, circle, or oval), with corner radii of 0.50 inch or larger. If the largest dimension of the hole is less than 1.0 inch, use the next size standard drill to make a smooth circular cutout.

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- (2) Make a patch of Nickel alloy 625 material of the same thickness as the skin. The contour of the patch must agree with the part to ± 0.050 inch. The patch must also fill the hole without interference, and with no gap larger than 0.050 inch.
- (3) Weld the patch to the skin. Refer to REPAIR 1-2, Paragraph 2..

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REPAIR 1-2

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ASSEMBLY

1. General

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

2. Assembly

A. References

Reference	Title
SOPM 20-44-02	TEMPORARY PROTECTIVE COATINGS

B. Procedure

NOTE: For bolt and nut installation, refer to SOPM 20-44-02.

- (1) Use standard industry procedures and the steps shown below to assemble this component.
- (2) Install the labyrinth assemblies (40, 45, 85 thru 95, 125 thru 135) with bolts (25, 75) and washers (30, 80). Refer to ASSEMBLY, Figure 701.

3. Storage

A. References

Reference	Title
SOPM 20-44-02	TEMPORARY PROTECTIVE COATINGS

B. Procedure

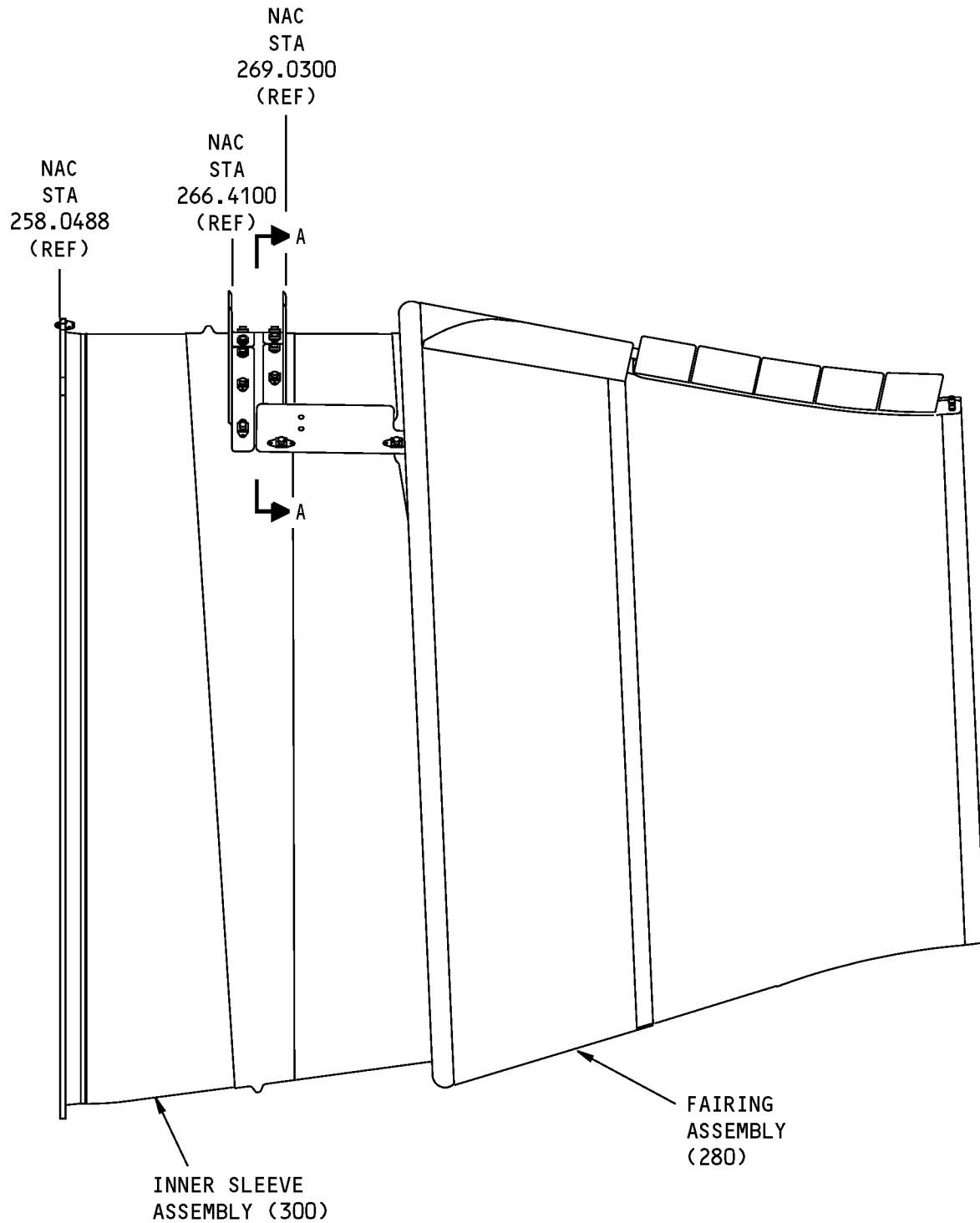
- (1) Use standard industry procedures and the data in SOPM 20-44-02 to store this component.

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Installation of Labyrinth Assemblies
Figure 701 (Sheet 1 of 2)

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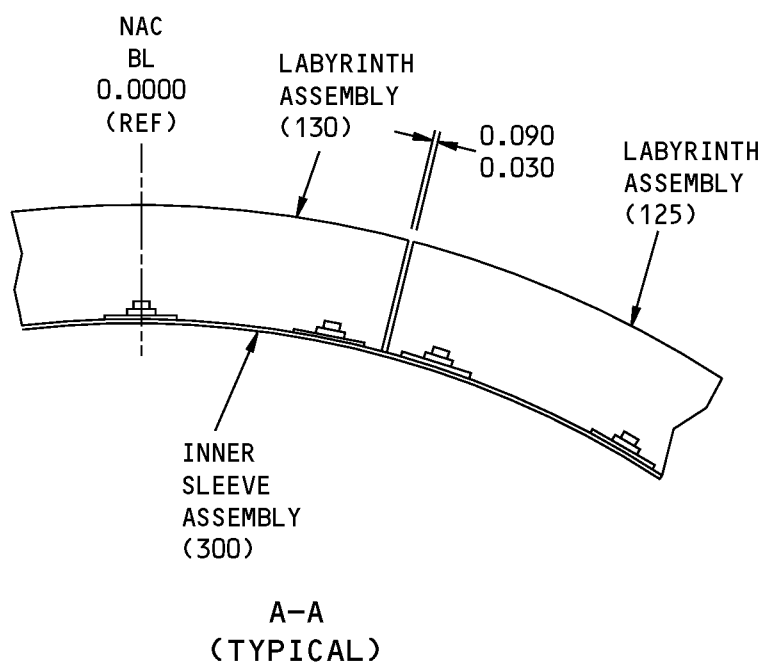
ASSEMBLY

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ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

Installation of Labyrinth Assemblies
Figure 701 (Sheet 2 of 2)

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FITS AND CLEARANCES

(NOT APPLICABLE)

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FITS AND CLEARANCES

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SPECIAL TOOLS, FIXTURES, AND EQUIPMENT

(NOT APPLICABLE)

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SPECIAL TOOLS, FIXTURES, AND EQUIPMENT

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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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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
06710	LAMSON AND SESSIONS CO THE VALLEY-TODECO 12975 BRADLEY AVENUE SYLMAR, CALIFORNIA 91342-3830 FORMERLY VALLEY BOLT CORP VB0097 IN NORTH HOLLYWOOD, CA
06725	AIR INDUSTRIES CORPORATION 12570 KNOTT STREET GARDEN GROVE, CALIFORNIA 92641-3932 FORMERLY AIR INDUSTRIES OF CALIF IN GARDENA, CALIF.
08524	Replaced: [V08524] DEUTSCH FASTENER CORP SEE CODE V97928 Replaced: [V97928] SEE V17446 HUCK INTL by Code: Name and Address below 17446: HUCK INTL INC AEROSPACE FASTENER DIV 900 WATSON CENTER ROAD CARSON, CALIFORNIA 90745-4201 FORMERLY V32134 REXNORD INC; FORMERLY V97928 HUCK INTL Referenced in FORMERLY line below [17419] DEUTSCH COMPANY THE WELLS FARGO BANK BLDG 2444 WILSHIRE BLVD #600 SANTA MONICA, CALIFORNIA 90403 FORMERLY DEUTSCH FASTENER CORP V08524 FORMERLY IN LOS ANGELES
08529	
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

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Code	Name
15653	ALCOA GLOBAL FASTENERS INC DIV KAYNAR PRODUCTS 800 S STATE COLLEGE BLVD FULLERTON, CALIFORNIA 92831-3001 FORMERLY VK6405 MICRODOT AEROSP LTD; FORMERLY KAYNAR TECH FORMERLY FAIRCHILD FASTENERS KAYNAR DIV
27238	BRISTOL INDUSTRIES 630 EAST LAMBERT ROAD PO BOX 630 BREA, CALIFORNIA 92621-4119
52828	REPUBLIC FASTENER MFG CORP 1300 RANCHO CONEJO BLVD NEWBURY PARK, CALIFORNIA 91320-1405 FORMERLY IN SYLMAR, CALIFORNIA
56878	SPS TECHNOLOGIES INC AEROSPACE AND INDUSTRIAL PRODUCTS DIV 301 HIGHLAND AVE JENKINTOWN, PENNSYLVANIA 19046 FORMERLY STANDARD PRESSED STEEL FORMERLY IN SALT LAKE, UTAH
62554	SIMMONDS MECAERO FASTENERS INC 1734 SEQUOIA AVENUE ORANGE, CALIFORNIA 92668
72962	HARVARD INDUSTRIES INC 3 WERNER WAY SUITE 210 LEBANON, NEW JERSEY 08833 FORMERLY ESNA V7A079 FORMERLY ELASTIC STOP NUT IN UNION, NJ
73197	HI-SHEAR TECHNOLOGY CORP 2600 SKYPARK DRIVE TORRANCE, CALIFORNIA 90509
80539	SPS TECHNOLOGIES INC DIV AERPSOACE - SANTA ANA 2701 SOUTH HARBOR BOULEVARD SANTA ANA, CALIFORNIA 92704-5803 FORMERLY NUTT-SHEL DIV OF SPC WESTERN CO V80539 AND STANDARD PRESSED STEEL WESTERN DIV V17279

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Code	Name
92215	FAIRCHILD IND INC FAIRCHILD AEROSPACE FASTENER DIV 3010 W LOMITA BLVD TORRANCE, CALIFORNIA 90505-5102 FORMERLY VOI-SHAN IN CULVER CITY, CALIF
97928	Replaced: [V97928] SEE V17446 HUCK INTL by Code: Name and Address below 17446: HUCK INTL INC AEROSPACE FASTENER DIV 900 WATSON CENTER ROAD CARSON, CALIFORNIA 90745-4201 FORMERLY V32134 REXNORD INC; FORMERLY V97928 HUCK INTL

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NUMERICAL INDEX

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
101F177-4		1	60	1
101F9201-3		1	165	2
101F9201-4		1	55	1
		1	105	3
		1	145	3
101LH9031-4		1	15	1
101LH90314		1	15	1
314A2610-1		1	1A	RF
314A2610-13		1	155	1
314A2610-14		1	170	1
314A2610-2		1	300	1
314A2610-22		1	90	1
314A2610-23		1	85	1
314A2610-24		1	95	1
314A2610-25		1	125	1
314A2610-26		1	135	1
314A2610-27		1	130	1
314A2610-28		1	305	1
314A2610-29		1	40	1
314A2610-30		1	45	1
314A2610-35		1	290	1
314A2610-36		1	295	1
314A2610-38		1	115	1
314A2610-39		1	110	1
314A2610-4		1	280	1
314A2610-40		1	120	1
314A2610-41		1	175	1
314A2610-42		1	185	1
314A2610-43		1	65	1
314A2610-44		1	70	1
314A2610-45		1	180	1
314A2610-47		1	205	1
314A2610-48		1	210	1
314A2610-49		1	215	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
314A2610-50		1	220	1
314A2610-51		1	225	1
314A2610-52		1	230	1
314A2610-53		1	235	1
314A2610-54		1	240	1
314A2610-55		1	245	1
314A2610-56		1	250	1
314A2610-57		1	255	1
314A2610-58		1	260	1
314A2610-59		1	265	1
314A2610-60		1	270	1
314A2610-62		1	1B	RF
314A2610-63		1	205A	1
		1	205B	1
314A2610-64		1	210A	1
		1	210B	1
314A2610-65		1	202	1
		1	202A	1
314A2610-66		1	204	1
		1	204A	1
314A2610-68		1	1C	RF
314A2610-69		1	205C	1
314A2610-70		1	210C	1
333A2010-1		1	5	1
43710-048		1	60	1
67832A4		1	15	1
		1	15	1
67832A428		1	15	1
BACB30FM6A2SU		1	195	6
BACB30FM6A3SU		1	190	50
		1	193	2
BACB30FM6A4SU		1	193A	2
		1	193B	2
BACB30LK3U1		1	20	4
BACB30LK4U2		1	25	4

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	75	18
BACC30AB6S		1	200	58
BACN10HR4C		1	15	1
BACN10JA4C		1	60	1
BACN10JR3CF		1	165	2
BACN10JR4CF		1	55	1
		1	105	3
		1	145	3
BH00304-4		1	15	1
		1	15	1
BMN10HRC4		1	15	1
BMN5024C4		1	15	1
BRF110C4		1	60	1
BRF170CR		1	60	1
BRF200C3		1	165	2
CR59074		1	15	1
F2431-4		1	60	1
F5031-3BAC		1	165	2
F5031-4BAC		1	55	1
		1	55	1
		1	105	3
		1	105	3
		1	145	3
		1	145	3
H97-4		1	15	1
H974		1	15	1
HL40DU6-2		1	195	6
		1	195	6
		1	195	6
		1	195	6
		1	195	6
		1	195	6
HL40DU6-3		1	190	50
		1	190	50
		1	190	50

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HL40DU6-4		1	190	50
		1	190	50
		1	190	50
		1	193	2
		1	193	2
		1	193	2
		1	193	2
		1	193	2
		1	193	2
		1	193A	2
		1	193A	2
		1	193A	2
		1	193A	2
		1	193A	2
		1	193B	2
		1	193B	2
HL97DU6		1	193B	2
		1	200	58
		1	200	58
L8056A4SU		1	200	58
NAS1149E0316R		1	193A	2
NAS1149E0416R		1	35	4
NAS1198-5		1	10	1
		1	30	4
		1	80	18
NAS1200-3		1	150	2
NAS1200-5		1	50	4
		1	100	6
		1	140	6
		1	160	4
		1	275	93
		1	285	111

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
NS103203S02		1	165	2
NS103203S048		1	55	1
		1	105	3
		1	145	3
SL70604		1	15	1
SL7060C428		1	15	1
T8093C1032		1	165	2
T8093C428		1	55	1
		1	105	3
		1	145	3
VAL280024		1	15	1
VN152B1-02		1	165	2
VN152B1-048		1	55	1
		1	105	3
		1	145	3

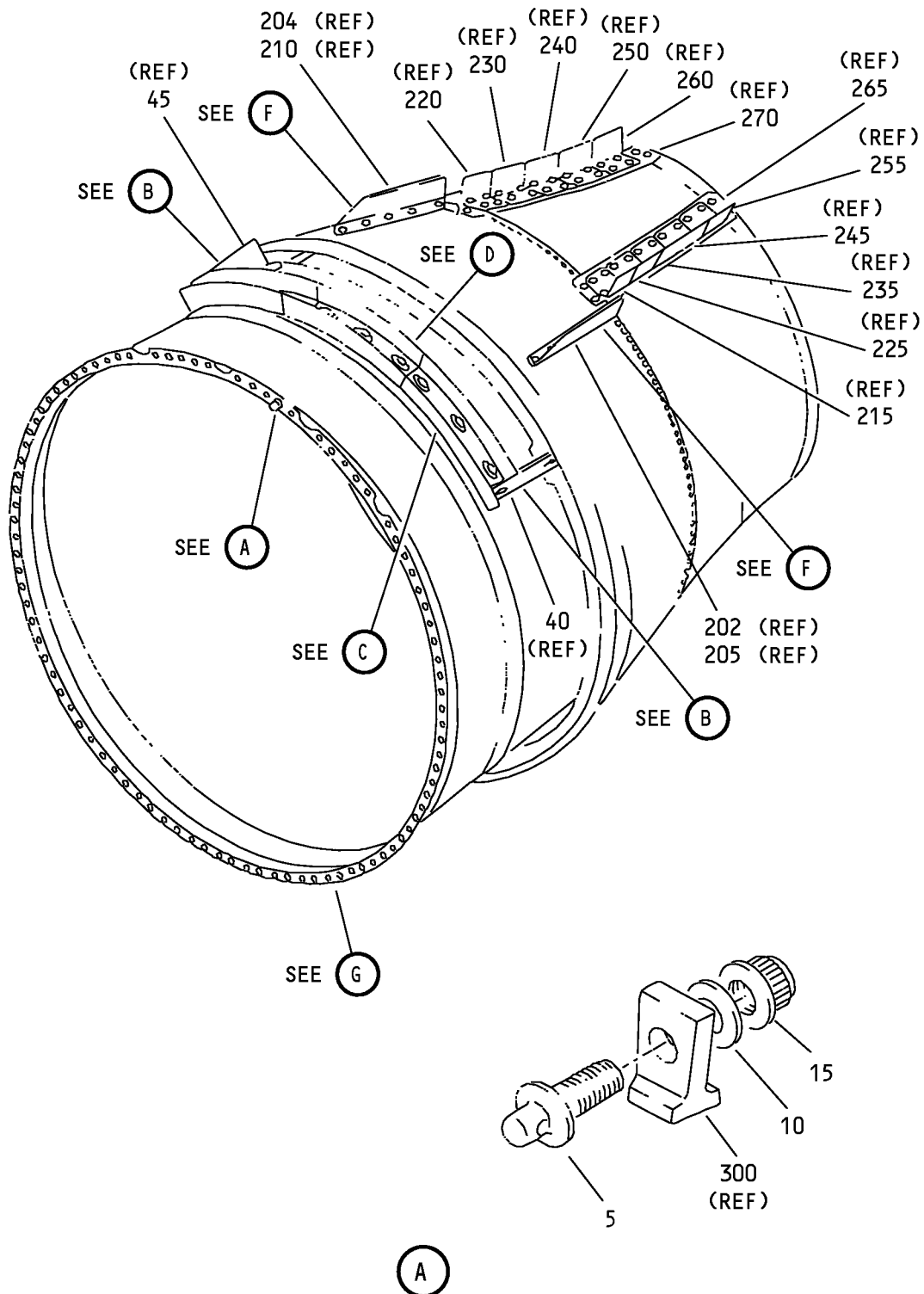
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G42132 S00041008983_V2

CFM56-7B Turbine Exhaust Primary Nozzle Assembly
IPL Figure 1 (Sheet 1 of 5)

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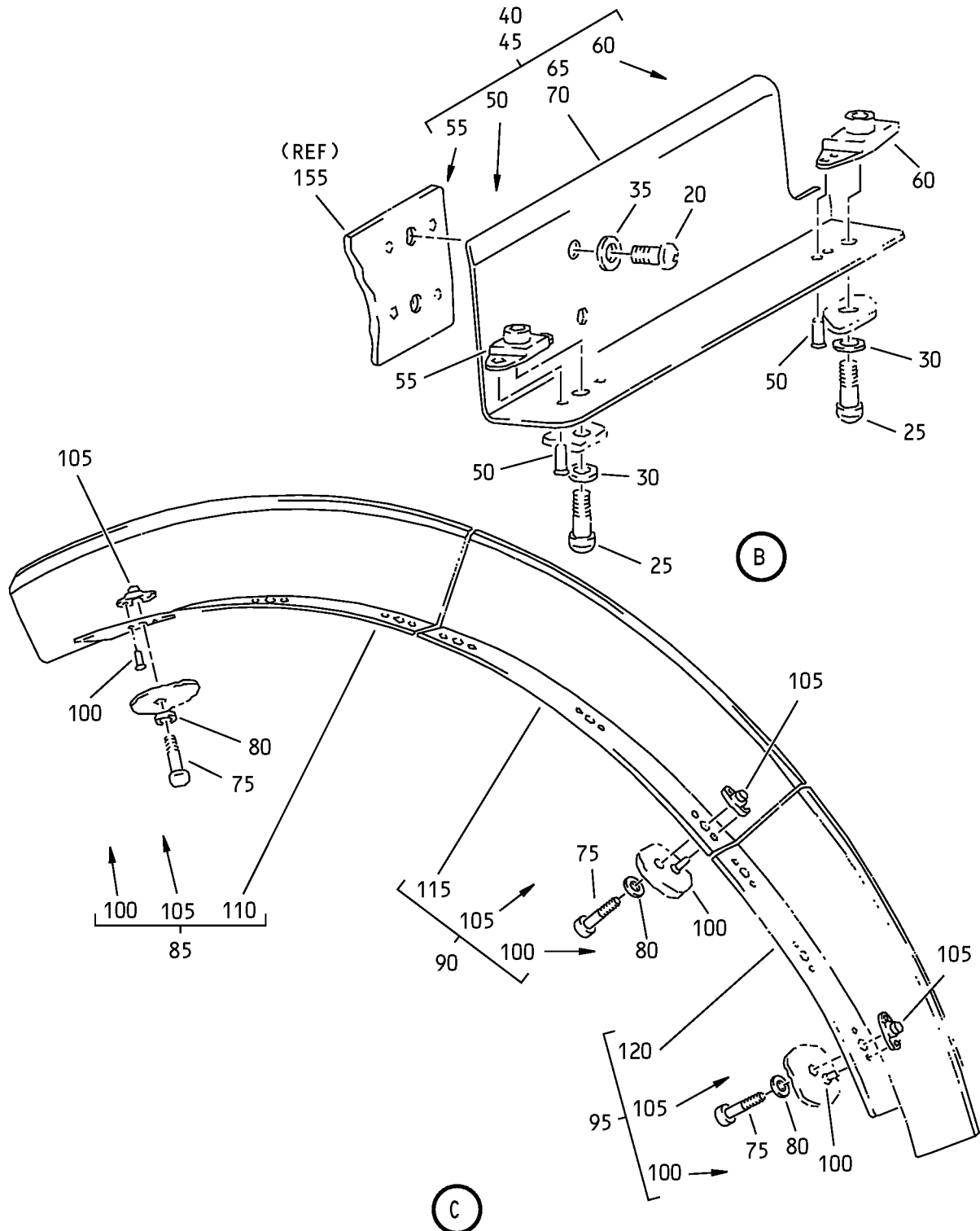
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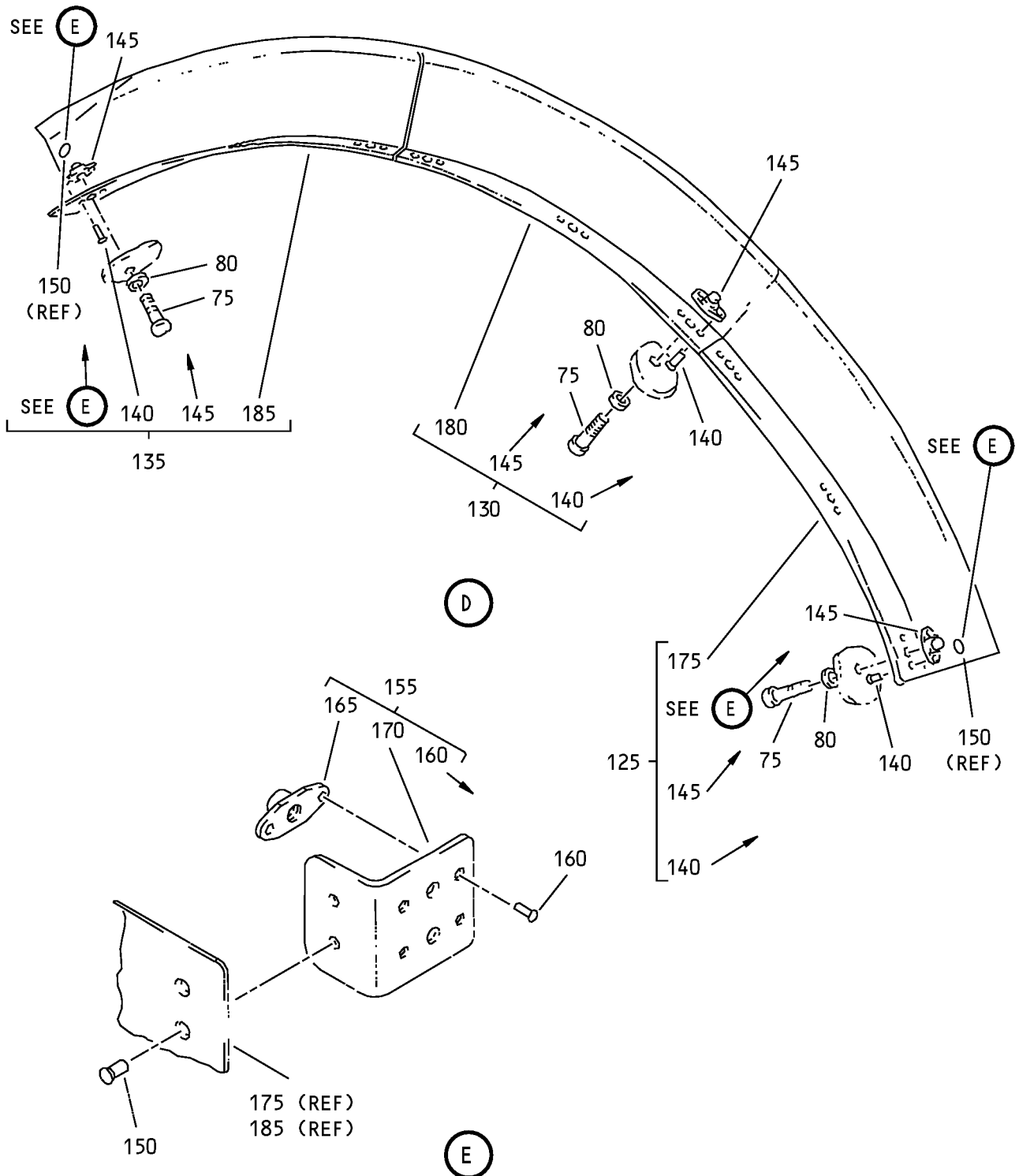
CFM56-7B Turbine Exhaust Primary Nozzle Assembly
IPL Figure 1 (Sheet 2 of 5)

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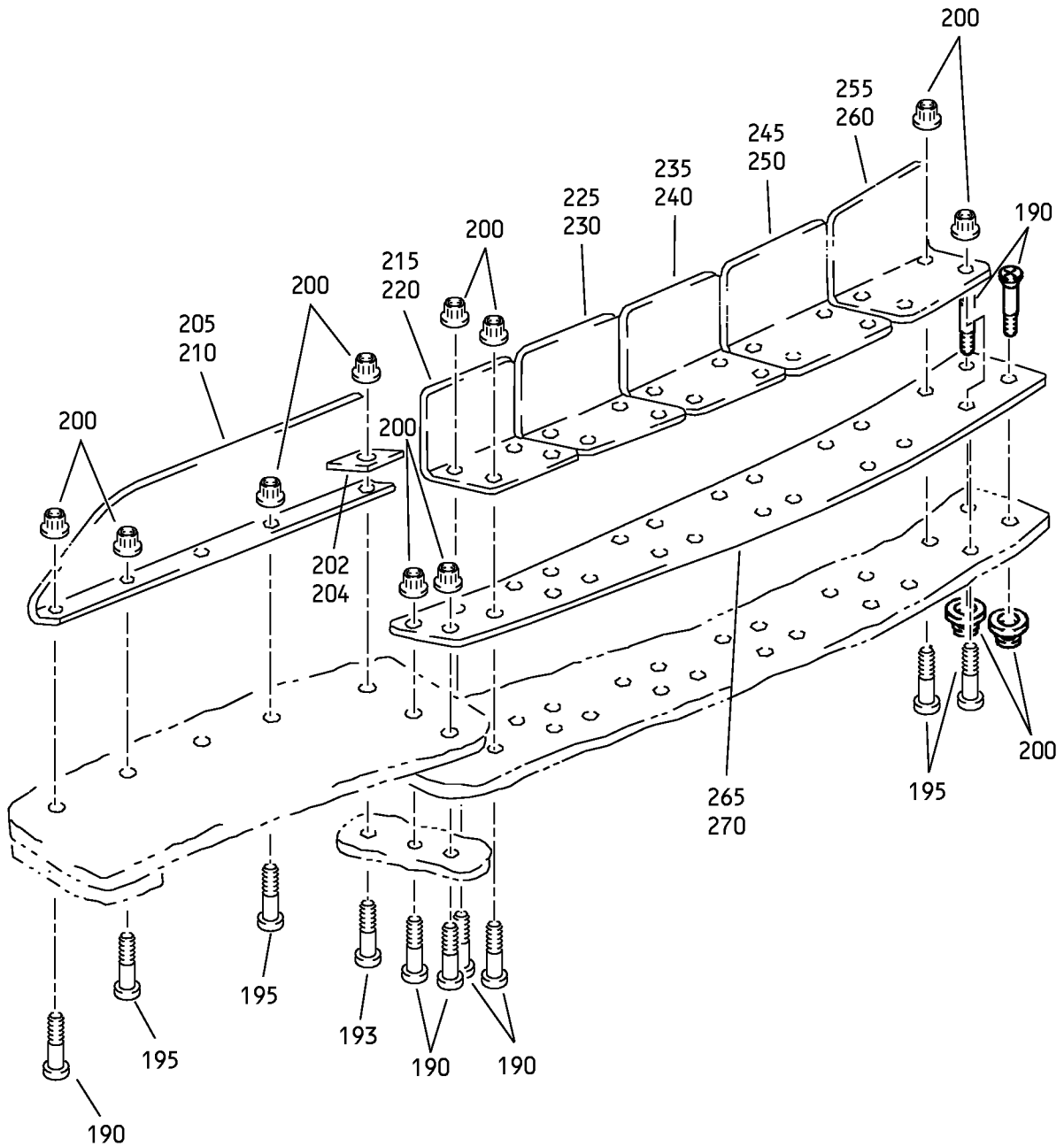
CFM56-7B Turbine Exhaust Primary Nozzle Assembly
IPL Figure 1 (Sheet 3 of 5)

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F

G42497 S00041008986_V2

CFM56-7B Turbine Exhaust Primary Nozzle Assembly
IPL Figure 1 (Sheet 4 of 5)

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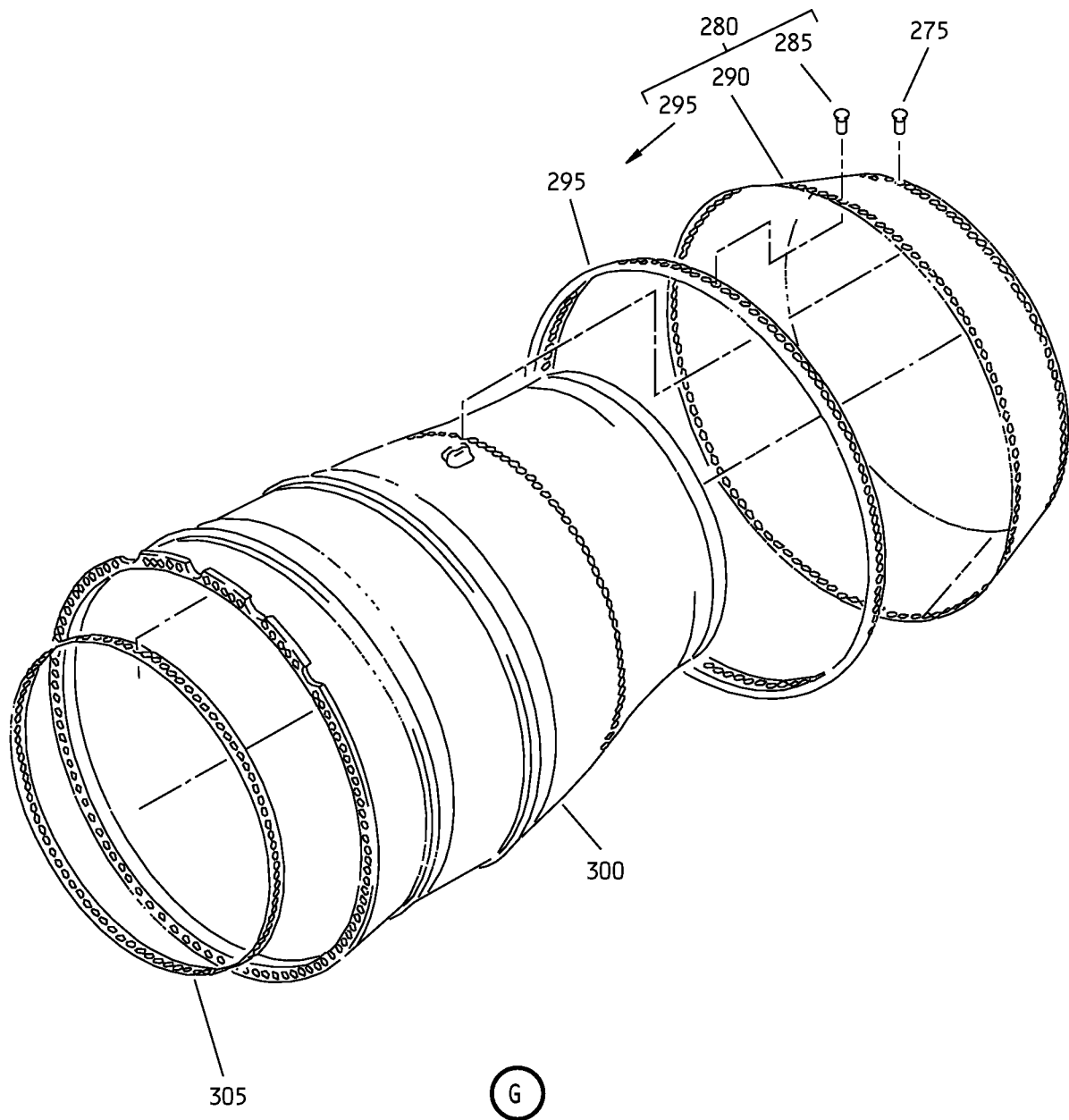
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CFM56-7B Turbine Exhaust Primary Nozzle Assembly
IPL Figure 1 (Sheet 5 of 5)

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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	314A2610-1		NOZZLE ASSY-PRIMARY	A	RF
—1B	314A2610-62		NOZZLE ASSY-PRIMARY	B	RF
—1C	314A2610-68		NOZZLE ASSY-PRIMARY	C	RF
5	333A2010-1		. PIN-ALIGN.		1
10	NAS1149E0416R		. WASHER		1
15	H97-4		. NUT (V15653) (SPEC BACN10HR4C) (OPT 101LH9031-4 (V72962)) (OPT 67832A428 (V56878)) (OPT BMN5024C4 (V97928)) (OPT BH00304-4 (V27238)) (OPT SL7060C428 (V11815)) (OPT BH00304-4 (V27238)) (OPT CR59074 (V62554)) (OPT H974 (V15653)) (OPT SL70604 (V11815)) (OPT VAL280024 (V06710)) (OPT 101LH90314 (V72962)) (OPT 67832A4 (V56878)) (OPT BMN10HRC4 (V97928)) (OPT 67832A4 (V56878))		1
20	BACB30LK3U1		. BOLT		4
25	BACB30LK4U2		. BOLT		4
30	NAS1149E0416R		. WASHER		4
35	NAS1149E0316R		. WASHER		4
40	314A2610-29		. LABYRINTH ASSY-SIDE, L		1
45	314A2610-30		. LABYRINTH ASSY-SIDE, R		1
50	NAS1200-3		. . RIVET (SIZE DETERMINED ON INST)		4
55	F5031-4BAC		. . NUTPLATE (V15653) (SPEC BACN10JR4CF) (OPT NS103203S048 (V80539)) (OPT VN152B1-048 (V92215)) (OPT 101F9201-4 (V72962)) (OPT T8093C428 (V11815)) (OPT F5031-4BAC (V15653))		1

—Item not Illustrated

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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– 60	101F177-4		. . NUTPLATE (V72962) (SPEC BACN10JA4C) (OPT BRF170CR (V52828)) (OPT 43710-048 (V80539)) (OPT BRF110C4 (V52828)) (OPT F2431-4 (V15653))		1
65	314A2610-43		. . LABYRINTH (USED ON ITEM 40)		1
70	314A2610-44		. . LABYRINTH (USED ON ITEM 45)		1
75	BACB30LK4U2		. BOLT		18
80	NAS1149E0416R		. WASHER		18
85	314A2610-23		. LABYRINTH ASSY-FWD, L		1
90	314A2610-22		. LABYRINTH ASSY-FWD, CTR		1
95	314A2610-24		. LABYRINTH ASSY-FWD, R		1
100	NAS1200-3		. . RIVET (SIZE DETERMINED ON INST)		6
105	F5031-4BAC		. . NUTPLATE (V15653) (SPEC BACN10JR4CF) (OPT NS103203S048 (V80539)) (OPT VN152B1-048 (V92215)) (OPT 101F9201-4 (V72962)) (OPT T8093C428 (V11815)) (OPT F5031-4BAC (V15653))		3
110	314A2610-39		. . LABYRINTH (USED ON ITEM 85)		1
115	314A2610-38		. . LABYRINTH (USED ON ITEM 90)		1
120	314A2610-40		. . LABYRINTH (USED ON ITEM 95)		1
125	314A2610-25		. LABYRINTH ASSY-AFT, L		1
130	314A2610-27		. LABYRINTH ASSY-AFT, CTR		1
135	314A2610-26		. LABYRINTH ASSY-AFT, R		1
140	NAS1200-3		. . RIVET (SIZE DETERMINED ON INST)		6

–Item not Illustrated

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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– 145	F5031-4BAC		. . NUTPLATE (V15653) (SPEC BACN10JR4CF) (OPT NS103203S048 (V80539)) (OPT VN152B1-048 (V92215)) (OPT 101F9201-4 (V72962)) (OPT T8093C428 (V11815)) (OPT F5031-4BAC (V15653))		3
150	NAS1198-5		. . RIVET (SIZE DETERMINED ON INST) (USED ON ITEMS 125, 135)		2
155	314A2610-13		. . CLIP ASSY (USED ON ITEMS 125, 135)		1
160	NAS1200-3		. . . RIVET (SIZE DETERMINED ON INST)		4
165	BRF200C3		. . . NUTPLATE (V52828) (SPEC BACN10JR3CF) (OPT F5031-3BAC (V15653)) (OPT NS103203S02 (V80539)) (OPT T8093C1032 (V11815)) (OPT VN152B1-02 (V92215)) (OPT 101F9201-3 (V72962))		2
170	314A2610-14		. . . CLIP		1
175	314A2610-41		. . LABYRINTH (USED ON ITEM 125)		1
180	314A2610-45		. . LABYRINTH (USED ON ITEM 130)		1
185	314A2610-42		. . LABYRINTH (USED ON ITEM 135)		1
190	HL40DU6-3		. BOLT (V97928) (SPEC BACB30FM6A3SU) (OPT HL40DU6-3 (V08529)) (OPT HL40DU6-3 (V80539)) (OPT HL40DU6-3 (V92215)) (OPT HL40DU6-3 (V73197)) (OPT HL40DU6-3 (V56878))		50

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1– 193	HL40DU6-3		. BOLT (V97928) (SPEC BACB30FM6A3SU) (OPT HL40DU6-3 (V08529)) (OPT HL40DU6-3 (V80539)) (OPT HL40DU6-3 (V92215)) (OPT HL40DU6-3 (V73197)) (OPT HL40DU6-3 (V56878)) (ITEM 205B USED WITH ITEM 202A AND ITEM 193B CAN REPLACE ITEM 205 USED WITH ITEM 193) (ITEM 210B USED WITH 204A AND ITEM 193B CAN REPLACE ITEM 210 USED WITH ITEM 193) (REWORKED BY SL-78-060-B)							A	2
–193A	HL40DU6-4		. BOLT (V97928) (SPEC BACB30FM6A4SU) (OPT HL40DU6-4 (V73197)) (OPT HL40DU6-4 (V92215)) (OPT HL40DU6-4 (V80539)) (OPT HL40DU6-4 (V08524)) (OPT L8056A4SU (V06725))							B, C	2
–193B	HL40DU6-4		. BOLT (V97928) (SPEC BACB30FM6A4SU) (OPT HL40DU6-4 (V73197)) (OPT HL40DU6-4 (V92215)) (OPT HL40DU6-4 (V80539)) (OPT HL40DU6-4 (V08524)) (OPT HL40DU6-4 (V56878)) (ITEM 205B USED WITH ITEM 202A AND ITEM 193B CAN REPLACE ITEM 205 USED WITH ITEM 193) (ITEM 210B USED WITH ITEM 204A AND ITEM 193B CAN REPLACE ITEM 210 USED WITH ITEM 193) (REWORKED BY SL-78-060-B)							A	2
195	HL40DU6-2		. BOLT (V97928) (SPEC BACB30FM6A2SU) (OPT HL40DU6-2 (V08524)) (OPT HL40DU6-2 (V80539)) (OPT HL40DU6-2 (V92215)) (OPT HL40DU6-2 (V73197)) (OPT HL40DU6-2 (V56878))								6

–Item not Illustrated

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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– 200	HL97DU6		. COLLAR (V73197) (SPEC BACC30AB6S) (OPT HL97DU6 (V92215)) (OPT HL97DU6 (V56878))		58
202	314A2610-65		. FILLER	B, C	1
–202A	314A2610-65		. FILLER (ITEM 205B USED WITH ITEM 202A AND ITEM 193B CAN REPLACE ITEM 205 USED WITH ITEM 193) (REWORKED BY SL 78-060-B)	A	1
204	314A2610-66		. FILLER	B, C	1
–204A	314A2610-66		. FILLER (ITEM 210B USED WITH ITEM 204A AND ITEM 193B CAN REPLACE ITEM 210 USED WITH ITEM 193) (REWORKED BY SL-78-060-B)	A	1
205	314A2610-47		. FENCE (ITEM 205B USED WITH ITEM 202A AND ITEM 193B CAN REPLACE ITEM 205 USED WITH ITEM 193) (REWORKED BY SL-78-060-B)	A	1
–205A	314A2610-63		. FENCE	B	1
–205B	314A2610-63		. FENCE (ITEM 205B USED WITH 202A AND ITEM 193B CAN REPLACE ITEM 205 USED WITH ITEM 193) (REWORKED BY SL-78-060-B)	A	1
–205C	314A2610-69		. FENCE	C	1
210	314A2610-48		. FENCE (ITEM 210B USED WITH ITEM 204A AND ITEM 193B CAN REPLACE ITEM 210 USED WITH ITEM 193) (REWORKED BY SL-78-060-B)	A	1
–210A	314A2610-64		. FENCE	B	1
–210B	314A2610-64		. FENCE (ITEM 210B USED WITH ITEM 204A AND ITEM 193B CAN REPLACE ITEM 210 USED WITH ITEM 193) (REWORKED BY SL-78-060-B)	A	1
–210C	314A2610-70		. FENCE	C	1

–Item not Illustrated

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1–											
215	314A2610-49		.	FENCE							1
220	314A2610-50		.	FENCE							1
225	314A2610-51		.	FENCE							1
230	314A2610-52		.	FENCE							1
235	314A2610-53		.	FENCE							1
240	314A2610-54		.	FENCE							1
245	314A2610-55		.	FENCE							1
250	314A2610-56		.	FENCE							1
255	314A2610-57		.	FENCE							1
260	314A2610-58		.	FENCE							1
265	314A2610-59		.	DOUBLER							1
270	314A2610-60		.	DOUBLER							1
275	NAS1200-5		.	RIVET							93
				(SIZE DETERMINED ON INST)							
280	314A2610-4		.	FAIRING ASSY							1
285	NAS1200-5		.	RIVET							111
				(SIZE DETERMINED ON INST)							
290	314A2610-35		.	SKIN-FAIRING							1
295	314A2610-36		.	STIFFENER-FAIRING LE							1
300	314A2610-2		.	SLEEVE ASSY-INNER							1
305	314A2610-28		.	DOUBLER-FWD							1

–Item not Illustrated

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