

CHAPTER

57

WINGS



**737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL**

**CHAPTER 57
WINGS**

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1 thru 7	Sep 15/2023		212	Sep 15/2021		248	Sep 15/2021	
8	BLANK		213	Sep 15/2021		R 249	Sep 15/2023	
57-CONTENTS			214	Sep 15/2021		250	Sep 15/2021	
1	Sep 15/2022		215	Sep 15/2021		251	Sep 15/2021	
2	Sep 15/2022		216	Sep 15/2021		252	Sep 15/2021	
3	May 15/2023		217	Sep 15/2021		253	Sep 15/2021	
4	May 15/2023		218	Sep 15/2021		254	Sep 15/2021	
5	May 15/2023		219	May 15/2023		255	Sep 15/2021	
6	Jan 15/2023		220	May 15/2023		256	Sep 15/2021	
7	Sep 15/2022		221	Sep 15/2021		257	Sep 15/2021	
8	May 15/2023		222	Sep 15/2021		258	Sep 15/2021	
9	Sep 15/2021		223	Jan 15/2023		259	Sep 15/2021	
10	Sep 15/2021		224	Jan 15/2023		260	Sep 15/2021	
11	May 15/2023		225	Sep 15/2021		261	Sep 15/2021	
12	BLANK		226	Sep 15/2021		262	Sep 15/2021	
57-00-00			227	Jan 15/2023		263	Sep 15/2021	
201	Sep 15/2021		228	Jan 15/2023		264	Sep 15/2021	
202	Sep 15/2021		229	Sep 15/2021		265	Sep 15/2021	
203	Sep 15/2021		230	Sep 15/2021		266	Sep 15/2021	
204	Sep 15/2021		231	Jan 15/2023		267	Sep 15/2021	
205	Sep 15/2021		232	Jan 15/2023		268	Sep 15/2021	
206	BLANK		233	Sep 15/2021		269	Sep 15/2021	
57-05-02			234	Sep 15/2021		270	Sep 15/2021	
201	Jan 15/2023		235	Jan 15/2023		271	Sep 15/2021	
202	Sep 15/2022		236	Jan 15/2023		272	Sep 15/2021	
57-05-03			237	Sep 15/2021		273	Sep 15/2021	
201	Jan 15/2023		238	Sep 15/2021		274	Sep 15/2021	
R 202	Sep 15/2023		239	Jan 15/2023		275	Sep 15/2021	
R 203	Sep 15/2023		240	Sep 15/2021		276	Sep 15/2021	
204	Sep 15/2021		R 241	Sep 15/2023		277	Sep 15/2021	
205	Sep 15/2021		R 242	Sep 15/2023		278	Sep 15/2021	
206	Sep 15/2021		243	Sep 15/2021		279	Sep 15/2021	
207	Sep 15/2021		R 244	Sep 15/2023		280	Sep 15/2021	
208	Sep 15/2021		R 245	Sep 15/2023		281	Sep 15/2021	
209	Sep 15/2021		246	Sep 15/2021		282	Sep 15/2021	
210	Sep 15/2021		R 247	Sep 15/2023		283	Sep 15/2021	
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284	Sep 15/2021		298.22	May 15/2023		298.58	May 15/2023	
285	Sep 15/2021		298.23	May 15/2023		298.59	May 15/2023	
286	Sep 15/2021		298.24	May 15/2023		298.60	May 15/2023	
287	Jan 15/2023		298.25	May 15/2023		298.61	May 15/2023	
288	Jan 15/2023		298.26	May 15/2023		298.62	May 15/2023	
289	Jan 15/2023		298.27	May 15/2023		298.63	May 15/2023	
290	Sep 15/2021		298.28	May 15/2023		298.64	May 15/2023	
291	Jan 15/2023		298.29	May 15/2023		298.65	May 15/2023	
292	Jan 15/2023		298.30	May 15/2023		298.66	May 15/2023	
293	Jan 15/2023		298.31	May 15/2023		298.67	May 15/2023	
294	Sep 15/2021		298.32	May 15/2023		298.68	May 15/2023	
295	Sep 15/2021		298.33	May 15/2023		298.69	May 15/2023	
296	Sep 15/2021		298.34	May 15/2023		298.70	May 15/2023	
297	Sep 15/2021		298.35	May 15/2023		298.71	May 15/2023	
298	Sep 15/2021		298.36	May 15/2023		298.72	May 15/2023	
298.1	Sep 15/2021		298.37	May 15/2023		298.73	May 15/2023	
298.2	Sep 15/2021		298.38	May 15/2023		298.74	May 15/2023	
298.3	Sep 15/2021		298.39	May 15/2023		298.75	May 15/2023	
298.4	Sep 15/2021		298.40	May 15/2023		298.76	May 15/2023	
298.5	Sep 15/2021		298.41	May 15/2023		298.77	May 15/2023	
298.6	Sep 15/2021		298.42	May 15/2023		298.78	May 15/2023	
298.7	Sep 15/2021		298.43	May 15/2023		298.79	May 15/2023	
298.8	Sep 15/2021		298.44	May 15/2023		298.80	May 15/2023	
298.9	Sep 15/2021		298.45	May 15/2023		298.81	May 15/2023	
298.10	Sep 15/2021		298.46	May 15/2023		298.82	May 15/2023	
298.11	Sep 15/2021		298.47	May 15/2023		298.83	May 15/2023	
298.12	Sep 15/2021		298.48	May 15/2023		298.84	May 15/2023	
298.13	Sep 15/2021		298.49	May 15/2023		298.85	May 15/2023	
298.14	Sep 15/2021		298.50	May 15/2023		298.86	May 15/2023	
298.15	Jan 15/2023		298.51	May 15/2023		298.87	May 15/2023	
298.16	Jan 15/2023		298.52	May 15/2023		298.88	May 15/2023	
298.17	Jan 15/2023		298.53	May 15/2023		298.89	May 15/2023	
298.18	Jan 15/2023		298.54	May 15/2023		298.90	May 15/2023	
298.19	Jan 15/2023		298.55	May 15/2023		298.91	May 15/2023	
298.20	Jan 15/2023		298.56	May 15/2023		298.92	May 15/2023	
298.21	May 15/2023		298.57	May 15/2023		298.93	May 15/2023	

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298.95	May 15/2023		408	BLANK		402	Sep 15/2021	
298.96	May 15/2023		57-16-01			403	Sep 15/2021	
298.97	May 15/2023		601	Sep 15/2022		404	Sep 15/2021	
298.98	May 15/2023		602	Sep 15/2022		405	Jan 15/2023	
298.99	May 15/2023		603	May 15/2023		406	Jan 15/2023	
298.100	May 15/2023		604	May 15/2023		407	Jan 15/2022	
298.101	May 15/2023		605	May 15/2023		408	BLANK	
298.102	May 15/2023		606	May 15/2023		57-16-06		
298.103	May 15/2023		607	May 15/2023		201	Sep 15/2021	
298.104	May 15/2023		608	BLANK		202	Sep 15/2021	
298.105	May 15/2023		57-16-02			203	Sep 15/2021	
298.106	May 15/2023		401	Sep 15/2021		204	Sep 15/2021	
298.107	May 15/2023		402	Sep 15/2021		57-16-06		
298.108	May 15/2023		403	Sep 15/2021		401	Sep 15/2021	
298.109	May 15/2023		404	Sep 15/2021		402	Sep 15/2021	
298.110	May 15/2023		405	Sep 15/2021		403	Sep 15/2021	
298.111	May 15/2023		406	Sep 15/2021		404	Sep 15/2021	
298.112	May 15/2023		57-16-03			405	Sep 15/2021	
298.113	May 15/2023		401	May 15/2023		406	Sep 15/2021	
298.114	May 15/2023		402	Sep 15/2021		407	Sep 15/2021	
298.115	May 15/2023		403	Sep 15/2021		408	Sep 15/2021	
298.116	May 15/2023		404	Sep 15/2021		409	Sep 15/2021	
298.117	May 15/2023		405	Sep 15/2021		410	Sep 15/2021	
298.118	May 15/2023		406	Sep 15/2021		411	Sep 15/2021	
57-14-00			407	Sep 15/2021		412	Sep 15/2021	
201	Sep 15/2021		408	May 15/2023		413	Sep 15/2021	
202	Sep 15/2021		409	Jan 15/2023		414	May 15/2023	
203	Sep 15/2021		410	Jan 15/2023		415	May 15/2023	
204	Sep 15/2021		411	Sep 15/2022		416	May 15/2023	
57-16-01			412	Sep 15/2022		417	May 15/2023	
R 401	Sep 15/2023		413	Sep 15/2022		418	May 15/2023	
402	May 15/2023		414	Sep 15/2022		419	May 15/2023	
403	Jan 15/2023		415	Sep 15/2021		420	May 15/2023	
404	Jan 15/2023		416	BLANK		421	May 15/2023	
405	Jan 15/2023					422	May 15/2023	
406	Jan 15/2023					423	May 15/2023	

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57-16-06 (cont)			57-20-00 (cont)			57-31-21 (cont)		
424	BLANK		206	Sep 15/2021		408	May 15/2023	
57-16-06			207	Sep 15/2021		409	May 15/2023	
601	Sep 15/2021		208	Sep 15/2021		410	May 15/2023	
602	Sep 15/2021		209	Sep 15/2021		411	May 15/2023	
603	Sep 15/2021		210	Sep 15/2021		412	May 15/2023	
604	Sep 15/2021		211	Sep 15/2021		413	May 15/2023	
605	Sep 15/2021		212	Sep 15/2021		414	May 15/2023	
606	Sep 15/2021		213	Sep 15/2021		415	May 15/2023	
607	Sep 15/2021		214	BLANK		416	May 15/2023	
608	Sep 15/2021		57-22-00			417	May 15/2023	
609	Sep 15/2021		401	May 15/2023		418	May 15/2023	
610	Sep 15/2021		402	Sep 15/2021		419	May 15/2023	
611	Sep 15/2021		403	May 15/2023		420	May 15/2023	
612	Sep 15/2021		404	Sep 15/2021		421	May 15/2023	
613	Sep 15/2021		405	Sep 15/2021		422	May 15/2023	
614	Sep 15/2021		406	BLANK		423	May 15/2023	
615	Sep 15/2021		57-31-21			424	May 15/2023	
616	Sep 15/2021		201	Sep 15/2022		425	May 15/2023	
617	Sep 15/2021		202	May 15/2022		426	May 15/2023	
618	BLANK		203	May 15/2022		427	May 15/2023	
57-16-07			204	May 15/2022		428	May 15/2023	
401	Sep 15/2021		205	May 15/2022		429	May 15/2023	
402	Sep 15/2021		206	May 15/2022		430	May 15/2023	
403	Sep 15/2021		207	May 15/2022		431	May 15/2023	
404	Sep 15/2021		208	May 15/2022		432	May 15/2023	
405	Sep 15/2021		209	May 15/2022		433	May 15/2023	
406	Sep 15/2021		210	May 15/2022		434	May 15/2023	
407	Sep 15/2021		211	May 15/2022		435	May 15/2023	
408	Sep 15/2021		212	BLANK		436	May 15/2023	
409	Sep 15/2021		57-31-21			437	May 15/2023	
410	BLANK		401	May 15/2023		438	May 15/2023	
57-20-00			402	May 15/2023		439	May 15/2023	
201	Sep 15/2021		403	May 15/2023		440	May 15/2023	
202	Sep 15/2021		404	May 15/2023		441	May 15/2023	
203	Sep 15/2021		405	May 15/2023		442	May 15/2023	
204	Sep 15/2021		406	May 15/2023		443	May 15/2023	
205	Sep 15/2021		407	May 15/2023				

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444	May 15/2023		806	BLANK		812	BLANK	
445	May 15/2023		57-31-23			57-31-24		
446	May 15/2023		401	May 15/2023		401	May 15/2023	
447	May 15/2023		402	May 15/2023		R 402	Sep 15/2023	
448	May 15/2023		403	Sep 15/2021		403	May 15/2023	
449	May 15/2023		404	Sep 15/2021		404	May 15/2023	
450	May 15/2023		405	Sep 15/2021		405	Sep 15/2021	
451	May 15/2023		406	Sep 15/2021		406	Sep 15/2021	
452	May 15/2023		407	May 15/2023		407	Sep 15/2021	
453	May 15/2023		408	May 15/2023		408	May 15/2023	
454	May 15/2023		409	May 15/2023		R 409	Sep 15/2023	
455	May 15/2023		410	BLANK		410	May 15/2023	
456	May 15/2023		57-31-23			R 411	Sep 15/2023	
457	May 15/2023		601	Sep 15/2021		412	May 15/2023	
458	May 15/2023		602	May 15/2023		R 413	Sep 15/2023	
459	May 15/2023		603	Sep 15/2022		414	May 15/2023	
460	May 15/2023		604	Sep 15/2022		415	May 15/2023	
461	May 15/2023		605	Sep 15/2022		R 416	Sep 15/2023	
462	May 15/2023		606	Sep 15/2022		417	May 15/2023	
57-31-21			607	Sep 15/2022		418	May 15/2023	
601	Sep 15/2021		608	May 15/2023		419	Sep 15/2021	
602	BLANK		609	Sep 15/2021		420	Sep 15/2021	
57-31-21			610	Sep 15/2021		421	Sep 15/2021	
701	Sep 15/2021		611	Sep 15/2021		422	Sep 15/2021	
702	Sep 15/2021		612	BLANK		423	May 15/2023	
703	Sep 15/2021		57-31-23			R 424	Sep 15/2023	
704	Sep 15/2022		801	Sep 15/2021		425	Sep 15/2021	
705	Sep 15/2022		802	Sep 15/2022		R 426	Sep 15/2023	
706	Jan 15/2022		803	Jan 15/2022		R 427	Sep 15/2023	
707	Jan 15/2022		804	Jan 15/2022		428	May 15/2023	
708	BLANK		805	Jan 15/2022		57-31-24		
57-31-21			806	Jan 15/2022		601	May 15/2022	
801	Sep 15/2021		807	Sep 15/2021		602	BLANK	
802	Sep 15/2021		808	Sep 15/2021		57-31-24		
803	Sep 15/2021		809	Sep 15/2021		801	Sep 15/2021	
804	Sep 15/2021		810	Sep 15/2021		802	BLANK	
805	Sep 15/2021		811	Sep 15/2021				

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402	May 15/2023		57-44-01			402	Jan 15/2023	
403	Sep 15/2021		401	Sep 15/2022		403	Sep 15/2021	
404	Sep 15/2022		402	Sep 15/2022		404	Sep 15/2021	
405	May 15/2023		403	Sep 15/2022		405	Sep 15/2021	
406	Sep 15/2022		404	Sep 15/2021		406	Sep 15/2021	
407	May 15/2023		405	Sep 15/2021		407	Sep 15/2021	
408	BLANK		406	Sep 15/2021		408	Sep 15/2021	
57-41-00			407	Sep 15/2021		409	Sep 15/2021	
201	Sep 15/2021		408	Sep 15/2022		410	Sep 15/2021	
202	Sep 15/2021		409	Sep 15/2022		R 411	Sep 15/2023	
203	Sep 15/2021		410	Sep 15/2022		412	Sep 15/2022	
204	Sep 15/2021		411	Sep 15/2022		413	May 15/2022	
205	Sep 15/2021		412	Sep 15/2022		414	May 15/2023	
206	BLANK		57-44-03			415	May 15/2022	
57-41-02			601	Sep 15/2021		416	BLANK	
201	May 15/2023		602	Sep 15/2021		57-50-01		
202	Sep 15/2021		603	Sep 15/2021		501	May 15/2023	
203	May 15/2023		604	Sep 15/2021		502	May 15/2023	
204	Sep 15/2021		605	Sep 15/2021		503	May 15/2023	
205	Sep 15/2021		606	Sep 15/2021		504	Sep 15/2021	
206	Sep 15/2021		607	Sep 15/2021		505	Sep 15/2021	
207	Sep 15/2021		608	Sep 15/2021		506	Sep 15/2021	
208	Sep 15/2021		57-44-03			57-50-02		
209	Sep 15/2021		801	Jan 15/2022		401	Sep 15/2021	
210	Sep 15/2021		802	Sep 15/2022		402	Sep 15/2021	
211	Sep 15/2021		803	Jan 15/2022		403	Sep 15/2021	
212	Sep 15/2021		804	Jan 15/2022		404	Sep 15/2021	
213	Sep 15/2021		805	Sep 15/2021		405	Sep 15/2021	
214	Sep 15/2021		806	Sep 15/2021		406	Sep 15/2021	
215	Sep 15/2021		807	Sep 15/2021		407	Sep 15/2021	
216	May 15/2023		808	Sep 15/2021		408	May 15/2023	
217	Sep 15/2021		809	Sep 15/2021		409	Sep 15/2021	
218	Sep 15/2021		810	Sep 15/2021		410	Sep 15/2021	
219	Sep 15/2021		811	Sep 15/2021		411	Sep 15/2021	
220	Sep 15/2021		812	BLANK		412	BLANK	
221	Sep 15/2021							

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602	BLANK							
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R 801	Sep 15/2023							
802	May 15/2023							
803	Jan 15/2022							
804	Jan 15/2022							
805	Jan 15/2022							
806	Jan 15/2022							
807	Sep 15/2021							
808	Sep 15/2021							

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<u>WING - MAINTENANCE PRACTICES</u>	57-00-00		201	SIA ALL
Wing Skins - Corrosion Prevention TASK 57-00-00-910-801			201	SIA ALL
Airworthiness Limitation Precautions TASK 57-00-00-910-802			204	SIA ALL
<u>WING FATIGUE INSPECTIONS - MAINTENANCE PRACTICES</u>	57-05-02		201	SIA ALL
INTERNAL - GENERAL VISUAL: SUPPORT, FORWARD FITTING ASSEMBLY FLAP TRACKS 2,3 TASK 57-05-02-210-816			201	SIA ALL
<u>WINGS - STRUCTURAL INSPECTIONS - MAINTENANCE PRACTICES</u>	57-05-03		201	SIA ALL
INTERNAL - GENERAL VISUAL: WING CENTER SECTION TASK 57-05-03-210-801			201	SIA ALL
INTERNAL - GENERAL VISUAL: WING CENTER SECTION TASK 57-05-03-210-802			205	SIA ALL
EXTERNAL - GENERAL VISUAL: WING CENTER SECTION TASK 57-05-03-210-803			211	SIA ALL
INTERNAL - GENERAL VISUAL: WING CENTER SECTION TASK 57-05-03-210-804			216	SIA ALL
INTERNAL - GENERAL VISUAL: WING CENTER SECTION TASK 57-05-03-210-805			219	SIA ALL
INTERNAL - GENERAL VISUAL: LEFT OUTBOARD WING TASK 57-05-03-210-806			223	SIA ALL
INTERNAL - GENERAL VISUAL: RIGHT OUTBOARD WING TASK 57-05-03-210-807			227	SIA ALL
INTERNAL - GENERAL VISUAL: LEFT OUTBOARD WING TASK 57-05-03-210-808			231	SIA ALL

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INTERNAL - GENERAL VISUAL: RIGHT OUTBOARD WING TASK 57-05-03-210-809			235	SIA ALL
INTERNAL - GENERAL VISUAL: WING CENTER SECTION TASK 57-05-03-210-810			239	SIA ALL
INTERNAL - GENERAL VISUAL: LEFT NACELLE SUPPORT FITTINGS TASK 57-05-03-210-811			241	SIA ALL
INTERNAL - GENERAL VISUAL: RIGHT NACELLE SUPPORT FITTINGS TASK 57-05-03-210-812			244	SIA ALL
INTERNAL - GENERAL VISUAL: LEFT OUTBOARD WING LOWER SURFACE TASK 57-05-03-210-813			247	SIA ALL
INTERNAL - GENERAL VISUAL: RIGHT OUTBOARD WING LOWER SURFACE TASK 57-05-03-210-814			249	SIA ALL
INTERNAL - GENERAL VISUAL: LEFT OUTBOARD WING FRONT SPAR TASK 57-05-03-210-815			251	SIA ALL
INTERNAL - GENERAL VISUAL: RIGHT OUTBOARD WING FRONT SPAR TASK 57-05-03-210-816			258	SIA ALL
INTERNAL - GENERAL VISUAL: LEFT OUTBOARD WING LEADING EDGE STRUCTURE TASK 57-05-03-210-817			265	SIA ALL
INTERNAL - GENERAL VISUAL: RIGHT OUTBOARD WING LEADING EDGE STRUCTURE TASK 57-05-03-210-818			272	SIA ALL
INTERNAL - DETAILED: LEFT WING SLAT TRACKS TASK 57-05-03-211-801			279	SIA ALL
INTERNAL - DETAILED: RIGHT WING SLAT TRACKS TASK 57-05-03-211-802			283	SIA ALL

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INTERNAL - GENERAL VISUAL: LEFT OUTBOARD WING ACCESS HOLES TASK 57-05-03-210-819			287	SIA ALL
INTERNAL - GENERAL VISUAL: RIGHT OUTBOARD WING ACCESS HOLES TASK 57-05-03-210-820			291	SIA ALL
INTERNAL - GENERAL VISUAL: LEFT OUTBOARD WING TASK 57-05-03-210-821			295	SIA ALL
INTERNAL - GENERAL VISUAL: RIGHT OUTBOARD WING TASK 57-05-03-210-822			298	SIA ALL
INTERNAL - GENERAL VISUAL: LEFT OUTBOARD WING TASK 57-05-03-210-823			298.3	SIA ALL
INTERNAL - GENERAL VISUAL: RIGHT OUTBOARD WING TASK 57-05-03-210-824			298.9	SIA ALL
INTERNAL - GENERAL VISUAL: LEFT OUTBOARD WING TASK 57-05-03-210-825			298.15	SIA ALL
INTERNAL - GENERAL VISUAL: RIGHT OUTBOARD WING TASK 57-05-03-210-826			298.18	SIA ALL
INTERNAL - GENERAL VISUAL: LEFT FLAP SUPPORT NO. 4 TASK 57-05-03-210-827			298.21	SIA ALL
INTERNAL - GENERAL VISUAL: RIGHT FLAP SUPPORT NO. 5 TASK 57-05-03-210-828			298.23	SIA ALL
INTERNAL - GENERAL VISUAL: LEFT FLAP SUPPORT NO. 3 TASK 57-05-03-210-829			298.25	SIA ALL
INTERNAL - GENERAL VISUAL: RIGHT FLAP SUPPORT NO. 6 TASK 57-05-03-210-830			298.27	SIA ALL

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INTERNAL - GENERAL VISUAL: LEFT OUTBOARD WING LOWER SURFACE TASK 57-05-03-210-831			298.29	SIA ALL
INTERNAL - GENERAL VISUAL: RIGHT OUTBOARD WING LOWER SURFACE TASK 57-05-03-210-832			298.31	SIA ALL
INTERNAL - GENERAL VISUAL: FLAP SUPPORTS NO. 1 & 2 TASK 57-05-03-210-833			298.33	SIA ALL
INTERNAL - GENERAL VISUAL: FLAP SUPPORTS NO. 7 & 8 TASK 57-05-03-210-834			298.36	SIA ALL
INTERNAL - GENERAL VISUAL: LEFT OUTBOARD WING LOWER SURFACE TASK 57-05-03-210-835			298.39	SIA ALL
INTERNAL - GENERAL VISUAL: RIGHT OUTBOARD WING LOWER SURFACE TASK 57-05-03-210-836			298.42	SIA ALL
INTERNAL - GENERAL VISUAL: LEFT MAIN LANDING GEAR SUPPORT STRUCTURE TASK 57-05-03-210-837			298.45	SIA ALL
INTERNAL - GENERAL VISUAL: RIGHT MAIN LANDING GEAR SUPPORT STRUCTURE TASK 57-05-03-210-838			298.48	SIA ALL
INTERNAL - GENERAL VISUAL: LEFT WING OUTBOARD REAR SPAR TASK 57-05-03-210-839			298.51	SIA ALL
INTERNAL - GENERAL VISUAL: RIGHT WING OUTBOARD REAR SPAR TASK 57-05-03-210-840			298.54	SIA ALL
INTERNAL - GENERAL VISUAL: LEFT WING OUTBOARD TRAILING EDGE STRUCTURE TASK 57-05-03-210-841			298.57	SIA ALL
INTERNAL - GENERAL VISUAL: RIGHT WING OUTBOARD TRAILING EDGE STRUCTURE TASK 57-05-03-210-842			298.67	SIA ALL

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INTERNAL - GENERAL VISUAL: LEFT INBOARD GROUND SPOILER TASK 57-05-03-210-843			298.77	SIA ALL
INTERNAL - GENERAL VISUAL: RIGHT INBOARD GROUND SPOILER TASK 57-05-03-210-844			298.80	SIA ALL
INTERNAL - GENERAL VISUAL: LEFT INBOARD FLAP TASK 57-05-03-210-845			298.83	SIA ALL
INTERNAL - GENERAL VISUAL: RIGHT INBOARD FLAP TASK 57-05-03-210-846			298.86	SIA ALL
INTERNAL - GENERAL VISUAL: LEFT OUTBOARD WING REAR SPAR TASK 57-05-03-210-847			298.89	SIA ALL
INTERNAL - GENERAL VISUAL: RIGHT OUTBOARD WING REAR SPAR TASK 57-05-03-210-848			298.93	SIA ALL
INTERNAL - GENERAL VISUAL: LEFT OUTBOARD FLAP TASK 57-05-03-210-849			298.97	SIA ALL
INTERNAL - GENERAL VISUAL: RIGHT OUTBOARD FLAP TASK 57-05-03-210-850			298.102	SIA ALL
INTERNAL - SPECIAL DETAILED: LEFT WINGLET TASK 57-05-03-211-803			298.107	SIA ALL
INTERNAL - SPECIAL DETAILED: RIGHT WINGLET TASK 57-05-03-211-804			298.109	SIA ALL
INTERNAL - DETAILED: LEFT WINGLET TASK 57-05-03-211-805			298.111	SIA ALL
INTERNAL - DETAILED: RIGHT WINGLET TASK 57-05-03-211-806			298.115	SIA ALL
<u>WING CENTER SECTION - CORROSION PREVENTION</u>	57-14-00		201	SIA ALL
Wing Center Section - Corrosion Prevention TASK 57-14-00-910-801			201	SIA ALL

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<u>MLG FORWARD TRUNNION HOUSING ASSEMBLY - REMOVAL/INSTALLATION</u>	57-16-01		401	SIA ALL
MLG Forward Trunnion Housing Assembly Removal TASK 57-16-01-000-801			401	SIA ALL
MLG Forward Trunnion Housing Assembly Installation TASK 57-16-01-400-801			405	SIA ALL
<u>MLG FORWARD TRUNNION HOUSING ASSEMBLY - INSPECTION/CHECK</u>	57-16-01		601	SIA ALL
MLG Forward Trunnion Bearing Wear Limits TASK 57-16-01-200-801			601	SIA ALL
<u>MAIN LANDING GEAR (MLG) AFT TRUNNION BEARING ASSEMBLY - REMOVAL/INSTALLATION</u>	57-16-02		401	SIA ALL
MLG Aft Trunnion Bearing Assembly Removal TASK 57-16-02-000-801			401	SIA ALL
MLG Aft Trunnion Bearing Assembly Installation TASK 57-16-02-400-801			405	SIA ALL
<u>MAIN LANDING GEAR REAR SPAR STABILIZER ATTACHMENT FITTING ASSEMBLY - REMOVAL/INSTALLATION</u>	57-16-03		401	SIA ALL
Main Landing Gear Rear Spar Stabilizer Attachment Fitting Assembly Removal TASK 57-16-03-000-801			401	SIA ALL
Main Landing Gear Rear Spar Stabilizer Attachment Fitting Assembly Installation TASK 57-16-03-400-801			408	SIA ALL
<u>MAIN LANDING GEAR IDLER LINK SUPPORT FITTING ASSEMBLY - REMOVAL/INSTALLATION</u>	57-16-05		401	SIA ALL
Idler Link Support Fitting Assembly Removal TASK 57-16-05-000-801			401	SIA ALL
Idler Link Support Fitting Assembly Installation TASK 57-16-05-400-801			405	SIA ALL

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<u>MAIN LANDING GEAR SUPPORT BEAM - MAINTENANCE PRACTICES</u>	57-16-06		201	SIA ALL
Main Landing Gear Support Beam - Corrosion Prevention TASK 57-16-06-910-801			201	SIA ALL
<u>MAIN LANDING GEAR SUPPORT BEAM - REMOVAL/INSTALLATION</u>	57-16-06		401	SIA ALL
Main Landing Gear Support Beam Removal TASK 57-16-06-000-801			401	SIA ALL
Main Landing Gear Support Beam Installation TASK 57-16-06-400-801			414	SIA ALL
<u>MAIN LANDING GEAR SUPPORT BEAM - INSPECTION/CHECK</u>	57-16-06		601	SIA ALL
Landing Gear Support Beam Inspection TASK 57-16-06-200-801			601	SIA ALL
Main Landing Gear Beam Hanger Link Free Play Check TASK 57-16-06-200-802			612	SIA ALL
<u>MAIN LANDING GEAR SUPPORT BEAM HANGER LINKS UPPER AND LOWER PIN - REMOVAL/INSTALLATION</u>	57-16-07		401	SIA ALL
Main Landing Gear Support Beam Hanger Links Upper And Lower Pin Removal TASK 57-16-07-000-801			401	SIA ALL
Main Landing Gear Support Beam Hanger Links Upper and Lower Pin Installation TASK 57-16-07-400-801			408	SIA ALL
<u>OUTER WING - CORROSION PREVENTION</u>	57-20-00		201	SIA ALL
Outer Wing - Corrosion Prevention TASK 57-20-00-910-801			201	SIA ALL
<u>WING VORTEX GENERATORS - REMOVAL/INSTALLATION</u>	57-22-00		401	SIA ALL
Wing Vortex Generator Removal TASK 57-22-00-000-801			401	SIA ALL
Wing Vortex Generator Installation TASK 57-22-00-400-801			403	SIA ALL

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<u>WINGLET - MAINTENANCE PRACTICES</u>	57-31-21		201	SIA ALL
Winglet Cover Plate Installation TASK 57-31-21-480-801			201	SIA ALL
Winglet Cover Plate Removal TASK 57-31-21-080-801			210	SIA ALL
<u>WINGLET - REMOVAL/INSTALLATION</u>	57-31-21		401	SIA ALL
Winglet Removal TASK 57-31-21-000-801			401	SIA ALL
Winglet Installation TASK 57-31-21-400-801			414	SIA ALL
Winglet Lower Blade Removal TASK 57-31-21-000-802			421	SIA ALL
Winglet Lower Blade Installation TASK 57-31-21-400-802			433	SIA ALL
Winglet Removal (Alternate) TASK 57-31-21-000-803			441	SIA ALL
Winglet Installation (Alternate) TASK 57-31-21-400-803			455	SIA ALL
<u>WINGLET - INSPECTION/CHECK</u>	57-31-21		601	SIA ALL
Winglet Lower Blade Inspection TASK 57-31-21-211-801			601	SIA ALL
<u>WINGLET - CLEANING/PAINTING</u>	57-31-21		701	SIA ALL
Prepare to Paint the Winglet TASK 57-31-21-300-801			701	SIA ALL
Basecoat/Clearcoat Paint System Application TASK 57-31-21-300-802			703	SIA ALL
Basecoat/Clearcoat Paint System Repair TASK 57-31-21-300-803			704	SIA ALL
Basecoat/Clearcoat Paint System Preparation for BMS10-148 Application TASK 57-31-21-300-804			705	SIA ALL
<u>WINGLET AERODYNAMIC SEALANT - REPAIR</u>	57-31-21		801	SIA ALL
Winglet Aerodynamic Sealant Repair TASK 57-31-21-390-801			801	SIA ALL

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<u>WING DRY BAY TANK ACCESS DOORS - REMOVAL/INSTALLATION</u>	57-31-23		401	SIA ALL
Dry Bay Access Doors Removal TASK 57-31-23-000-801			401	SIA ALL
Dry Bay Access Doors Installation TASK 57-31-23-400-801			407	SIA ALL
<u>WING DRY BAY TANK VAPOR SEAL - INSPECTION/CHECK</u>	57-31-23		601	SIA ALL
Vapor Seal Leak Check TASK 57-31-23-790-801			601	SIA ALL
<u>WING DRY BAY TANK VAPOR SEAL - REPAIR</u>	57-31-23		801	SIA ALL
Repair of Sealant Leaks in the Wing Dry Bay Tanks TASK 57-31-23-390-801			801	SIA ALL
<u>WINGLET EROSION PROTECTION - REMOVAL/INSTALLATION</u>	57-31-24		401	SIA ALL
Winglet Erosion Protection Removal TASK 57-31-24-000-801			401	SIA ALL; AIRPLANES WITH FULL-LENGTH EROSION TAPE
Winglet Erosion Protection Installation TASK 57-31-24-400-801			408	SIA ALL; AIRPLANES WITH FULL-LENGTH EROSION TAPE
Winglet Erosion Protection Removal TASK 57-31-24-000-802			415	SIA ALL; AIRPLANES WITH SHORT EROSION TAPE
Winglet Erosion Protection Installation TASK 57-31-24-400-802			423	SIA ALL; AIRPLANES WITH SHORT EROSION TAPE
<u>WINGLET EROSION PROTECTION - INSPECTION/CHECK</u>	57-31-24		601	SIA ALL
Winglet Erosion Protection Inspection TASK 57-31-24-200-801			601	SIA ALL
<u>WINGLET EROSION PROTECTION - REPAIRS</u>	57-31-24		801	SIA ALL
Winglet Erosion Protection Repair TASK 57-31-24-300-801			801	SIA ALL

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<u>WINGLET FAIRINGS - REMOVAL/INSTALLATION</u>	57-31-25		401	SIA ALL
Transition Fairing Removal TASK 57-31-25-010-801			401	SIA ALL
Transition Fairing Installation TASK 57-31-25-410-801			405	SIA ALL
<u>WING LEADING EDGE - CORROSION PREVENTION</u>	57-41-00		201	SIA ALL
Wing Leading Edge - Corrosion Prevention TASK 57-41-00-910-801			201	SIA ALL
<u>LEADING EDGE ACCESS PANELS - MAINTENANCE PRACTICES</u>	57-41-02		201	SIA ALL
Leading Edge Access Panel Removal TASK 57-41-02-000-801			201	SIA ALL
Leading Edge Access Panel Installation TASK 57-41-02-400-801			216	SIA ALL
<u>OUTBOARD LEADING EDGE SLAT ROLLERS - REMOVAL/INSTALLATION</u>	57-44-01		401	SIA ALL
Outboard Leading Edge Slat Roller Removal TASK 57-44-01-000-801			401	SIA ALL
Outboard Leading Edge Rollers Installation TASK 57-44-01-400-801			408	SIA ALL
<u>OUTBOARD LEADING EDGE SEAL RIB - INSPECTION/CHECK</u>	57-44-03		601	SIA ALL
Check of Sealant at Leading Edge Seal Rib TASK 57-44-03-200-801			601	SIA ALL
<u>OUTBOARD LEADING EDGE SEAL RIB - REPAIR</u>	57-44-03		801	SIA ALL
Repair of Sealant at Leading Edge Seal Rib TASK 57-44-03-390-801			801	SIA ALL
<u>FIXED TRAILING EDGE UPPER PANEL - REMOVAL/INSTALLATION</u>	57-50-01		401	SIA ALL
Inboard Fixed Trailing Edge Upper Panel Removal TASK 57-50-01-000-801			401	SIA ALL
Inboard Fixed Trailing Edge Upper Panel Installation TASK 57-50-01-400-801			411	SIA ALL

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<u>FIXED TRAILING EDGE UPPER PANEL - ADJUSTMENT/TEST</u>	57-50-01		501	SIA ALL
Inboard Fixed Trailing Edge Upper Panel - Adjustment TASK 57-50-01-800-801			501	SIA ALL
<u>FIXED TRAILING EDGE LOWER PANEL - REMOVAL/INSTALLATION</u>	57-50-02		401	SIA ALL
Inboard Fixed Trailing Edge Lower Panel Removal TASK 57-50-02-000-801			401	SIA ALL
Inboard Fixed Trailing Edge Lower Panel Installation TASK 57-50-02-400-801			408	SIA ALL
<u>AILERON - INSPECTION/CHECK</u>	57-61-01		601	SIA ALL
Examine the Composite Flight Controls TASK 57-61-01-200-801			601	SIA ALL
<u>SPOILER SUPPORT FITTINGS - REPAIRS</u>	57-71-01		801	SIA ALL
Spoiler Support Fitting Repair TASK 57-71-01-300-801			801	SIA ALL

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WING - MAINTENANCE PRACTICES

1. General

- A. This process has these items:
- (1) Wing Skin - Corrosion Prevention
 - (2) Airworthiness Limitation Precautions

TASK 57-00-00-910-801

2. Wing Skins - Corrosion Prevention

A. General

- (1) Make the regular inspection to prevent or find the start of corrosion. Missing fasteners, white powdery, or other corrosion deposits are signs of corrosion. Initiate the corrosion prevention practices to decrease the occurrence of corrosion.
- (2) Following cleaning of suspected areas PAGEBLOCK 51-21-31/701, a full inspection is effective to ensure that protective finishes provided during manufacture remain intact.
- (3) Where corrosion exists (noticeable bulges of the skin or white deposits of corrosion products at fastener heads or joint edges), refer to Structural Repair Manual for details of corrosion removal.
- (4) For minor corrosion, to minimize the downtime of the airplane, the corrosion products should be cleaned off, followed by the application of a corrosion inhibiting compound into the affected area to decrease the corrosion process. Refer to PAGEBLOCK 51-21-91/701 for details on applying corrosion inhibiting compound. The finish system should be repaired at the next maintenance opportunity.

B. References

Reference	Title
51-21-31 P/B 701	CORROSION REMOVAL AND CONTROL - CLEANING/PAINTING
51-21-91 P/B 701	CORROSION INHIBITING COMPOUND - CLEANING/PAINTING

C. Consumable Materials

Reference	Description	Specification
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23

D. Location Zones

Zone	Area
500	Left Wing
600	Right Wing

E. Procedure

SUBTASK 57-00-00-370-001

- (1) At the next maintenance opportunity, apply corrosion prevention treatment to the wing in-spar skin.

SUBTASK 57-00-00-370-002

- (2) Frequency of Application
 - (a) Periodic inspection is required in areas identified as susceptible to corrosion and should be consistent to the schedules specified in the Maintenance Planning Document. Operators must be aware of reported problems and areas of occurrences.

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- (b) Periodic application of corrosion inhibiting compound, G00009 is necessary to areas identified and should be consistent to the schedule specified in the Maintenance Planning Document.

————— **END OF TASK** —————

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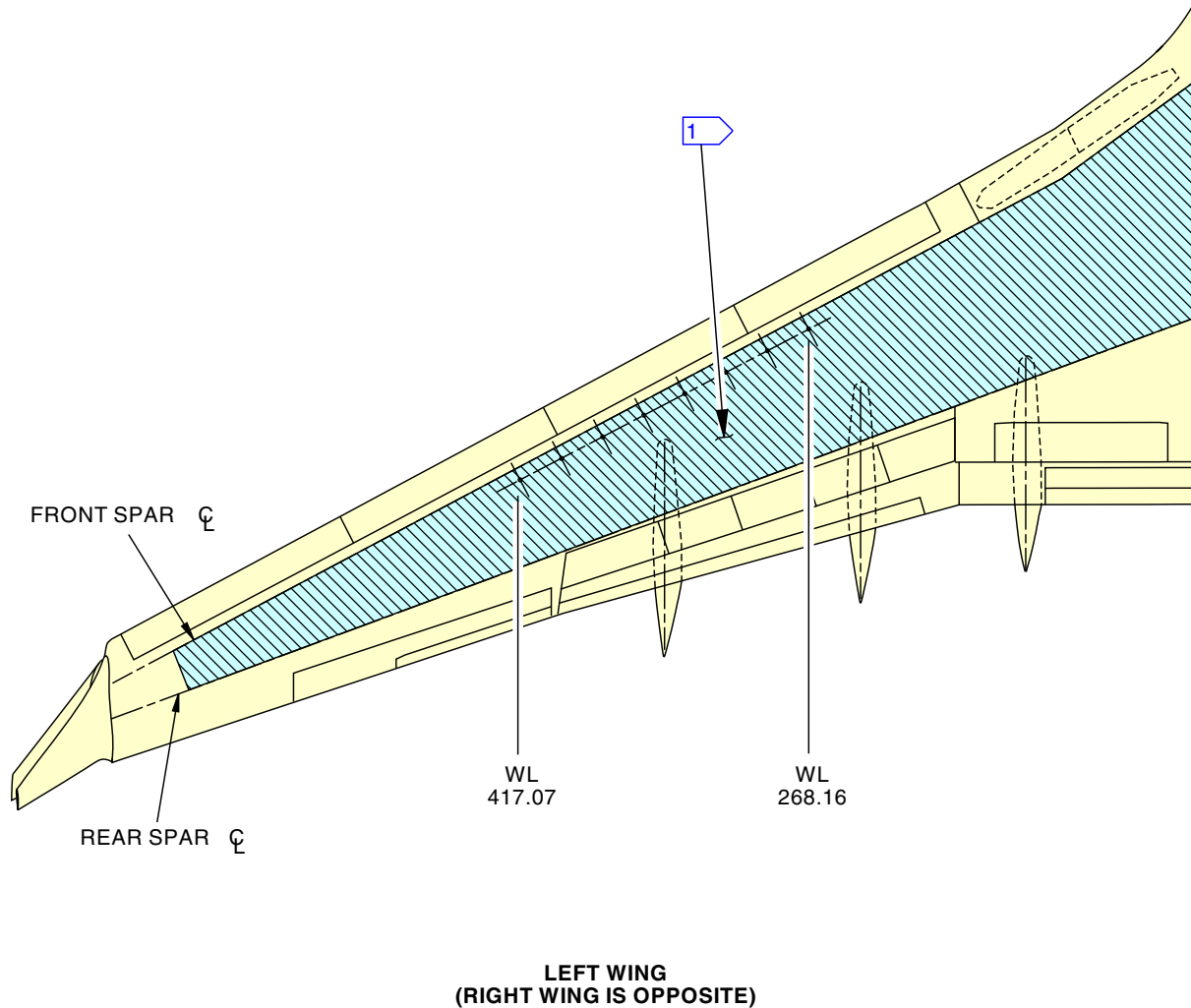
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1 APPLY BMS 10-79 TYPE III PRIMER AND
BMS 10-60 TYPE II GRAY ENAMEL

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**Wing Skins - Corrosion Prevention
Figure 201/57-00-00-990-801**

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TASK 57-00-00-910-802

3. Airworthiness Limitation Precautions

A. General

- (1) Critical Design Configuration Control Limitations (CDCCLs)
 - (a) All occurrences of CDCCLs found in this chapter of the AMM are identified by this note after each applicable CDCCL design feature:
 - 1) NOTE: CDCCL - Refer to the task: Airworthiness Limitation Precautions, TASK 20-00-00-910-801, for important information on Critical Design Configuration Control Limitations (CDCCLs).
 - (b) Design features that are CDCCLs are defined and controlled by Special Federal Aviation Regulation (SFAR) 88, and can be found in Section 9 of the Maintenance Planning Data (MPD) document. CDCCLs are a means of identifying certain design configuration features intended to preclude a fuel tank ignition source for the operational life of the airplane. CDCCLs are mandatory and cannot be changed or deleted without the approval of the FAA office that is responsible for the airplane model Type Certificate, or applicable regulatory agency. A critical fuel tank ignition source prevention feature may exist in the fuel system and its related installation or in systems that, if a failure condition were to develop, could interact with the fuel system in such a way that an unsafe condition would develop without this limitation. Strict adherence to configuration, methods, techniques, and practices as prescribed is required to ensure the CDCCL is complied with. Any use of parts, methods, techniques or practices not contained in the applicable CDCCL must be approved by the FAA office that is responsible for the airplane model Type Certificate, or applicable regulatory agency.
- (2) Airworthiness Limitation Instructions (ALIs)
 - (a) All occurrences of fuel tank system ALIs found in this chapter of the AMM are identified by this note after each applicable ALI inspection feature:
 - 1) NOTE: ALI - Refer to the task: Airworthiness Limitation Precautions, TASK 20-00-00-910-801, for important information on airworthiness limitation instructions (ALIs).
 - (b) Inspection features that are ALIs are defined and controlled by Special Federal Aviation Regulation (SFAR) 88, and can be found in Section 9 of the Maintenance Planning Data (MPD) document. These ALIs identify inspection features related to fuel tank ignition source prevention which must be done to maintain the design level of safety for the operational life of the airplane. These inspection features are mandatory and cannot be changed or deleted without the approval of the FAA office that is responsible for the airplane model Type Certificate, or applicable regulatory agency. Strict adherence to methods, techniques and practices as prescribed is required to ensure the ALI is complied with. Any use of methods, techniques or practices not contained in these ALIs must be approved by the FAA office that is responsible for the airplane model Type Certificate, or applicable regulatory agency.

B. References

Reference	Title
20-00-00-910-801	Airworthiness Limitation Precautions (P/B 201)

C. Location Zones

Zone	Area
100	Lower Half of Fuselage
200	Upper Half of Fuselage

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(Continued)

Zone	Area
500	Left Wing
600	Right Wing

D. Critical Design Configuration Control Limitations (CDCCLs)

SUBTASK 57-00-00-910-001



OBEY THE MANUFACTURER'S PROCEDURES WHEN YOU DO MAINTENANCE THAT HAS AN EFFECT ON A CDCCL. IF YOU DO NOT OBEY THE PROCEDURES, IT CAN INCREASE THE RISK OF A SOURCE OF FUEL TANK IGNITION. INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT CAN OCCUR IF THERE IS A FIRE OR EXPLOSION.

- (1) Make sure you follow the procedures for items identified as CDCCLs.

E. Airworthiness Limitation Instructions (ALIs)

SUBTASK 57-00-00-910-002



OBEY THE MANUFACTURER'S PROCEDURES WHEN YOU DO MAINTENANCE THAT HAS AN EFFECT ON AN ALI. IF YOU DO NOT OBEY THE PROCEDURES, IT CAN INCREASE THE RISK OF A SOURCE OF FUEL TANK IGNITION. INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT CAN OCCUR IF THERE IS A FIRE OR EXPLOSION.

- (1) Make sure you follow the procedures for items identified as ALIs.

————— **END OF TASK** —————

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WING FATIGUE INSPECTIONS - MAINTENANCE PRACTICES

TASK 57-05-02-210-816

1. INTERNAL - GENERAL VISUAL: SUPPORT, FORWARD FITTING ASSEMBLY FLAP TRACKS 2,3

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
542	Left Wing - Fairing Flap Support No. 3
543	Left Wing - Fairing Flap Support No. 2
544	Left Wing - Fairing Flap Support No. 1
642	Right Wing - Fairing Flap Support No. 6
643	Right Wing - Fairing Flap Support No. 7
644	Right Wing - Fairing Flap Support No. 8

B. Access Panels

Number	Name/Location
544AB	Flap Support No. 1 Access Panel, Forward Assembly
544BB	Flap Support No. 1 Access Panel, Aft Assembly
644AB	Flap Support No. 8, Forward Assembly Access Panel
644BB	Flap Support No. 8, Aft Assembly Access Panel

C. Inspection

SUBTASK 57-05-02-010-096

- (1) Open these access panels on the Left side:

<u>Number</u>	<u>Name/Location</u>
544AB	Flap Support No. 1 Access Panel, Forward Assembly
544BB	Flap Support No. 1 Access Panel, Aft Assembly

Open these access panels on the Right side:

<u>Number</u>	<u>Name/Location</u>
644AB	Flap Support No. 8, Forward Assembly Access Panel
644BB	Flap Support No. 8, Aft Assembly Access Panel

NOTE: Remove catcher as required. Access to catcher requires removal of the forward fixed flap support fairing.

SUBTASK 57-05-02-210-016

- (2) Do a General Visual inspection of the catcher attached to the forward fitting assemblies for flap tracks right and left side at WBL 254.0 and 164.0 on the inside bottom surface of the catcher.

See Doc. D626A010-DTR, DTR check form 57-53-02/04/07.

NOTE: Inspect the inside bottom surface of the catcher for signs of contact between the track and the catcher (eg. scratches, paint removal, etc). Any sign of contact indicates failure of the track forward assy. If failure is indicated: disassemble forward joint and replace all failed parts and replace the catcher in order to maintain the required DTR. Unobstructed access to the catcher inside bottom surface requires removal of the forward fixed flap support fairing and removal of the catcher itself unless a validated method using remote visual inspection equipment is used.

EFFECTIVITY
SIA ALL

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SUBTASK 57-05-02-410-096

(3) Close these access panels on the Left side:

<u>Number</u>	<u>Name/Location</u>
544AB	Flap Support No. 1 Access Panel, Forward Assembly
544BB	Flap Support No. 1 Access Panel, Aft Assembly

Close these access panels on the Right side:

<u>Number</u>	<u>Name/Location</u>
644AB	Flap Support No. 8, Forward Assembly Access Panel
644BB	Flap Support No. 8, Aft Assembly Access Panel

———— **END OF TASK** ————

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL

WINGS - STRUCTURAL INSPECTIONS - MAINTENANCE PRACTICES

TASK 57-05-03-210-801

1. INTERNAL - GENERAL VISUAL: WING CENTER SECTION

(Figure 201)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-804	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
125	Air Conditioning Distribution Bay - Left
126	Air Conditioning Distribution Bay - Right
191	Lower Wing-To-Body Fairing - Forward of Wing Box
195	Above Wing, Wing-To-Body Fairing - Left
196	Above Wing, Wing-To-Body Fairing - Right

C. Access Panels

Number	Name/Location
191AL	Forward Wing-To-Body Fairing Panel - Upper
191AR	Forward Wing-To-Body Fairing Panel - Upper
191CL	Forward Wing-To-Body Fairing Panel - Middle
191CR	Forward Wing-To-Body Fairing Panel - Middle
191D	Forward Wing-To-Body Fairing Panel - Lower
191FL	Forward Wing-To-Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
191FR	Forward Wing-To-Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
195AL	Wing-To-Body Fairing - Left Side
195AR	Wing-To-Body Fairing - Right Side
S1006	Forward Side Wing Center Section Inspection

D. Inspection

SUBTASK 57-05-03-010-001

(1) Open these access panels:

Number	Name/Location
191AL	Forward Wing-To-Body Fairing Panel - Upper
191AR	Forward Wing-To-Body Fairing Panel - Upper
191CL	Forward Wing-To-Body Fairing Panel - Middle
191CR	Forward Wing-To-Body Fairing Panel - Middle
191D	Forward Wing-To-Body Fairing Panel - Lower
191FL	Forward Wing-To-Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
191FR	Forward Wing-To-Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
195AL	Wing-To-Body Fairing - Left Side
195AR	Wing-To-Body Fairing - Right Side

EFFECTIVITY
SIA ALL

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Special Access:

<u>Number</u>	<u>Name/Location</u>
S1006	Forward Side Wing Center Section Inspection

NOTE: Remove aft panels in forward cargo compartment.

SUBTASK 57-05-03-210-001

- (2) Do a General Visual inspection of the forward side of wing center section front spar, including the side of body/terminal fitting.

SUBTASK 57-05-03-910-001

- (3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-804.

SUBTASK 57-05-03-410-001

- (4) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
191AL	Forward Wing-To-Body Fairing Panel - Upper
191AR	Forward Wing-To-Body Fairing Panel - Upper
191CL	Forward Wing-To-Body Fairing Panel - Middle
191CR	Forward Wing-To-Body Fairing Panel - Middle
191D	Forward Wing-To-Body Fairing Panel - Lower
191FL	Forward Wing-To-Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
191FR	Forward Wing-To-Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
195AL	Wing-To-Body Fairing - Left Side
195AR	Wing-To-Body Fairing - Right Side

Restore Special Access:

<u>Number</u>	<u>Name/Location</u>
S1006	Forward Side Wing Center Section Inspection

———— **END OF TASK** ————

EFFECTIVITY
SIA ALL

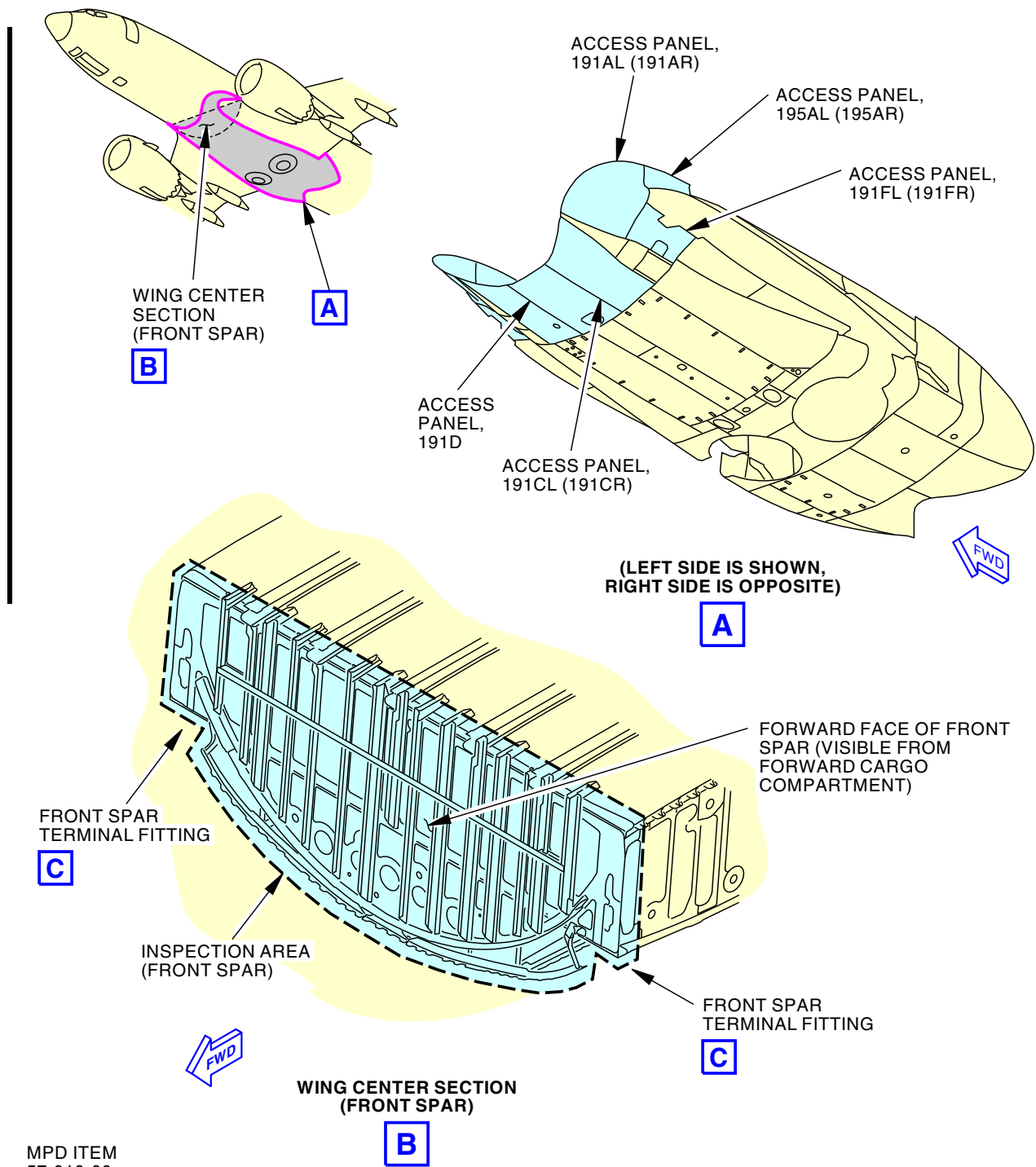
D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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INTERNAL-GENERAL VISUAL: INTERNAL-WING CENTER SECTION
 Figure 201/57-05-03-990-801 (Sheet 1 of 2)

EFFECTIVITY
 SIA ALL

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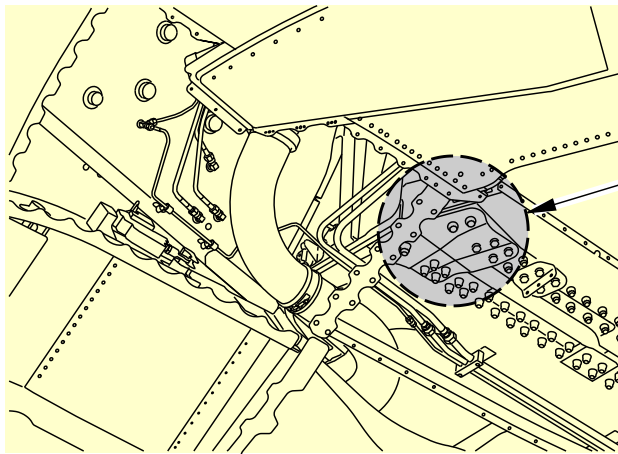
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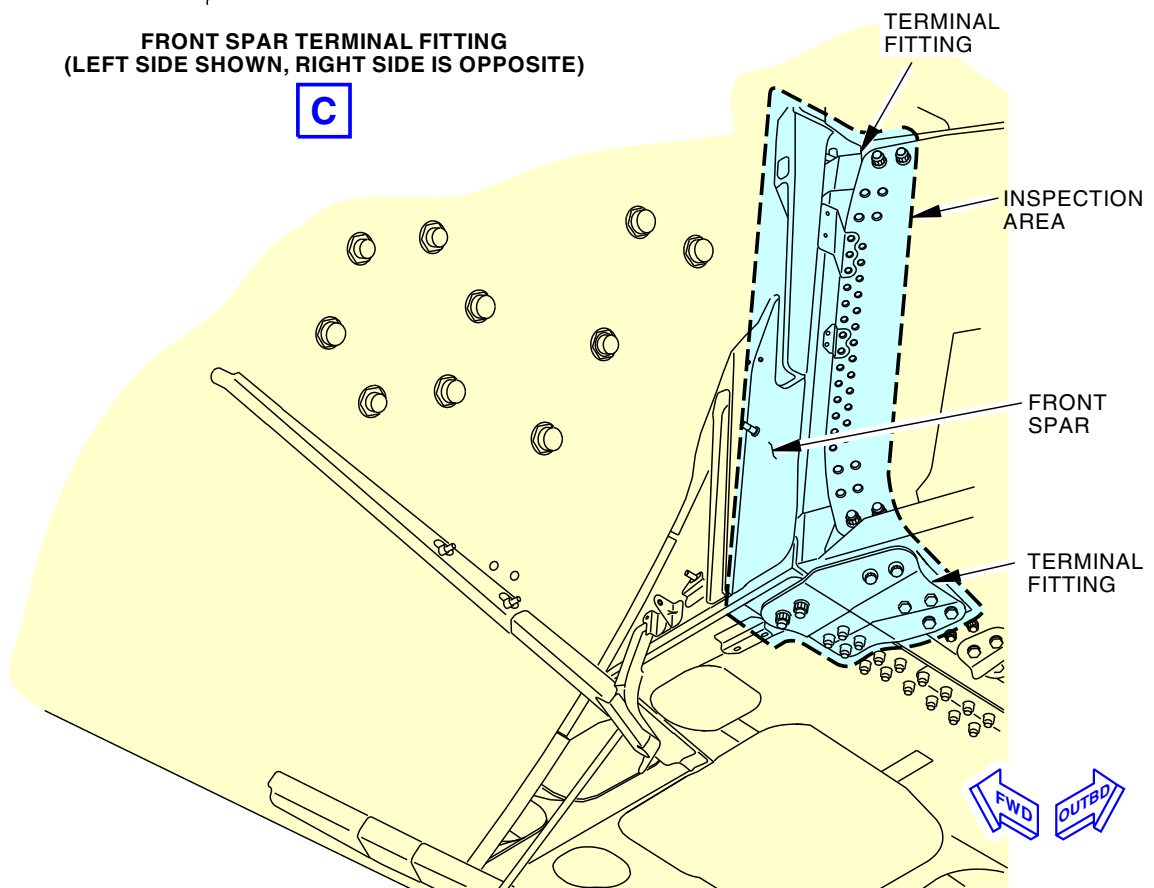


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FRONT SPAR TERMINAL FITTING
(LEFT SIDE SHOWN, RIGHT SIDE IS OPPOSITE)

C



TERMINAL FITTING (EXAMPLE)

D

MPD ITEM
57-010-00

2416487 S00061540928_V1

INTERNAL-GENERAL VISUAL: INTERNAL-WING CENTER SECTION
Figure 201/57-05-03-990-801 (Sheet 2 of 2)

EFFECTIVITY
SIA ALL

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TASK 57-05-03-210-802

2. INTERNAL - GENERAL VISUAL: WING CENTER SECTION

(Figure 202)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
28-11-31-000-801	Center Tank Access Door Removal (P/B 401)
28-11-31-400-801	Center Tank Access Door - Installation (P/B 401)
51-05-01-210-809	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
131	Center Section Wing Box, Body Station 540.00 to Body Station 663.75 - Left
132	Center Section Wing Box, Body Station 540.00 to Body Station 663.75 - Right

C. Access Panels

Number	Name/Location
131AB	Center Tank Access
192CL	ECS Access Door
192CR	ECS Access Door
192E	ECS Under Keel Panel - Forward
192F	ECS Under Keel Panel - Middle
S1303	Upper Side Wing Center Section Inspection

D. Inspection

SUBTASK 57-05-03-010-002

- (1) Open these access panels:

Number	Name/Location
192CL	ECS Access Door
192CR	ECS Access Door
192E	ECS Under Keel Panel - Forward
192F	ECS Under Keel Panel - Middle

Special Access:

Number	Name/Location
S1303	Upper Side Wing Center Section Inspection

- (2) Open this access panel:

Number	Name/Location
131AB	Center Tank Access

To do this, do this task: Center Tank Access Door Removal, TASK 28-11-31-000-801

SUBTASK 57-05-03-210-002

- (3) Do a General Visual inspection of the inside wing center section:

- Upper surface (includes skins, typical and vent stringers, splice stringer, at attachment to floor beams).
- Lower surface (includes skins, typical stringers, splice stringers, at attachment to keel beam, at drain installation, at access hole, at attachment to fuselage drag angle, at attachment to lower beam at BL 41).

EFFECTIVITY
SIA ALL

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**737-7/8/8200/9/10
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- (c) Front and rear spars (includes webs and stiffeners, upper and lower spar chords, attachments to skin).
- (d) Side of body rib (includes webs and stiffeners, upper rib chord, lower tee chord, front and rear spar terminal fittings, splice fittings).
- (e) Spanwise beams.

SUBTASK 57-05-03-910-002

- (4) Do this task: 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-809.

SUBTASK 57-05-03-410-002

- (5) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
131AB	Center Tank Access

To do this, do this task: Center Tank Access Door - Installation, TASK 28-11-31-400-801

- (6) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
192CL	ECS Access Door
192CR	ECS Access Door
192E	ECS Under Keel Panel - Forward
192F	ECS Under Keel Panel - Middle

Restore Special Access:

<u>Number</u>	<u>Name/Location</u>
S1303	Upper Side Wing Center Section Inspection

———— **END OF TASK** ————

EFFECTIVITY
SIA ALL

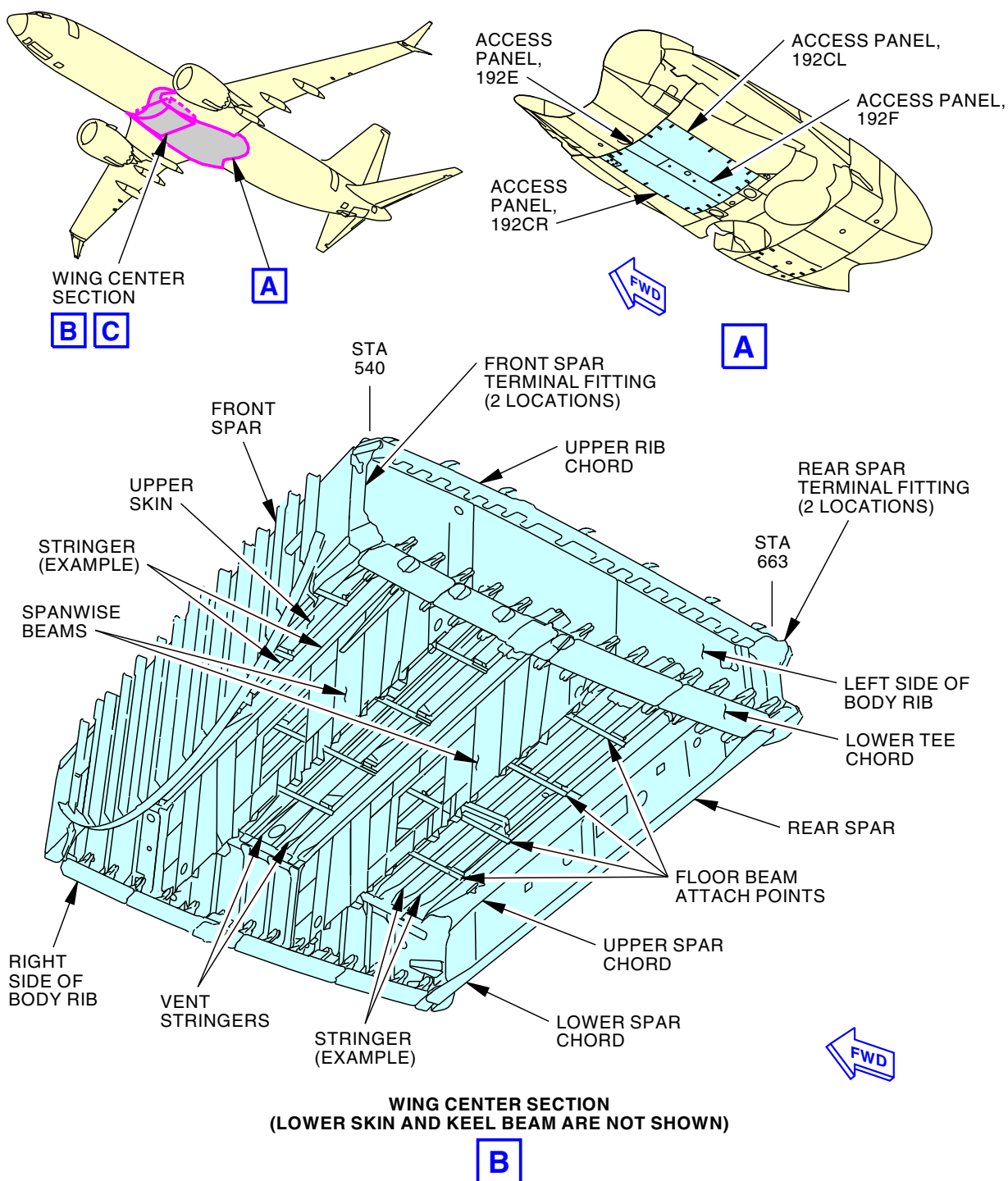
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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2416488 S00061540930_V1

INTERNAL-GENERAL VISUAL: INTERNAL-WING CENTER SECTION
Figure 202/57-05-03-990-802 (Sheet 1 of 4)

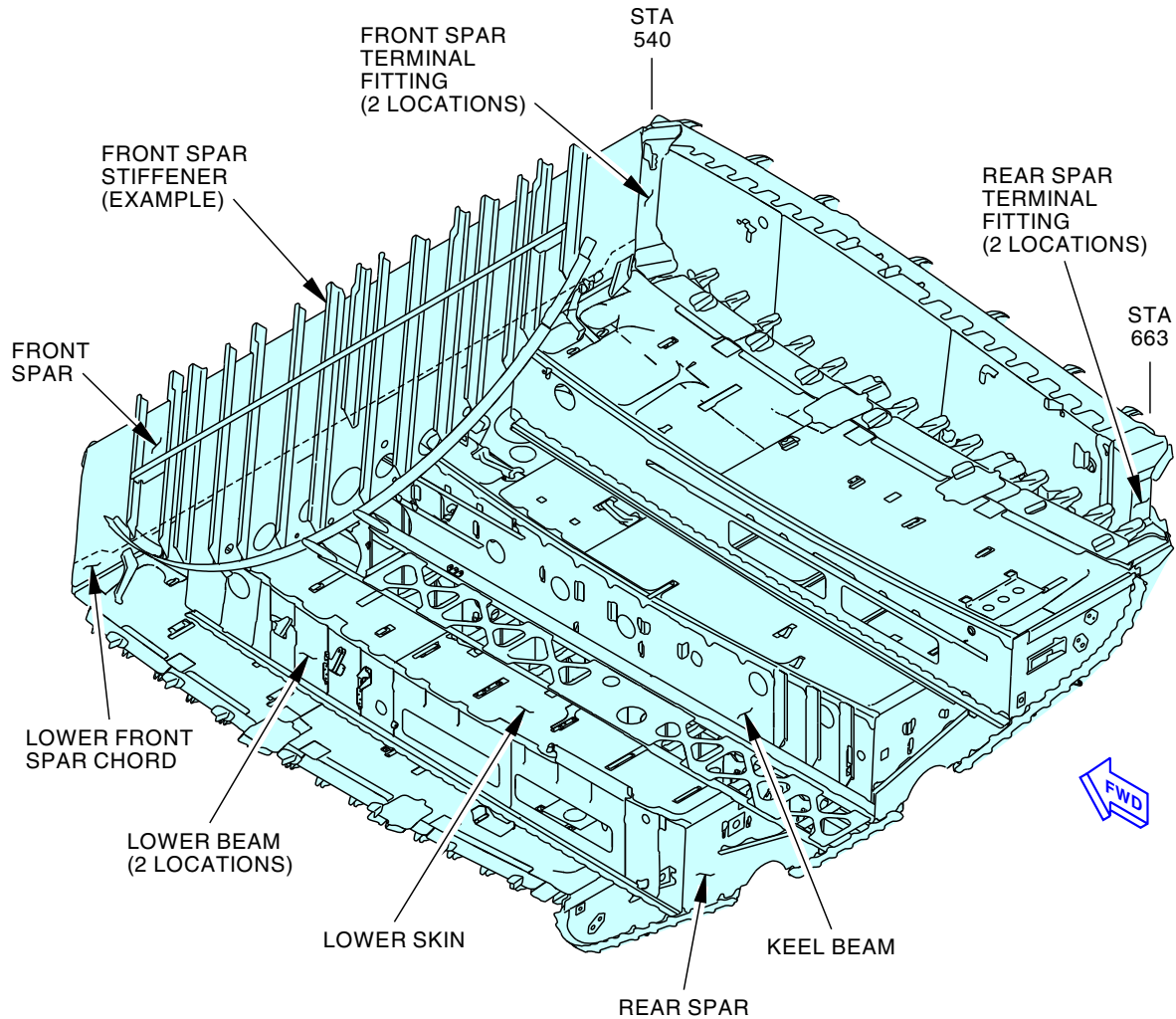
EFFECTIVITY
SIA ALL

57-05-03

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WING CENTER SECTION
(VIEW IN THE UP DIRECTION)



2416489 S00061540931_V1

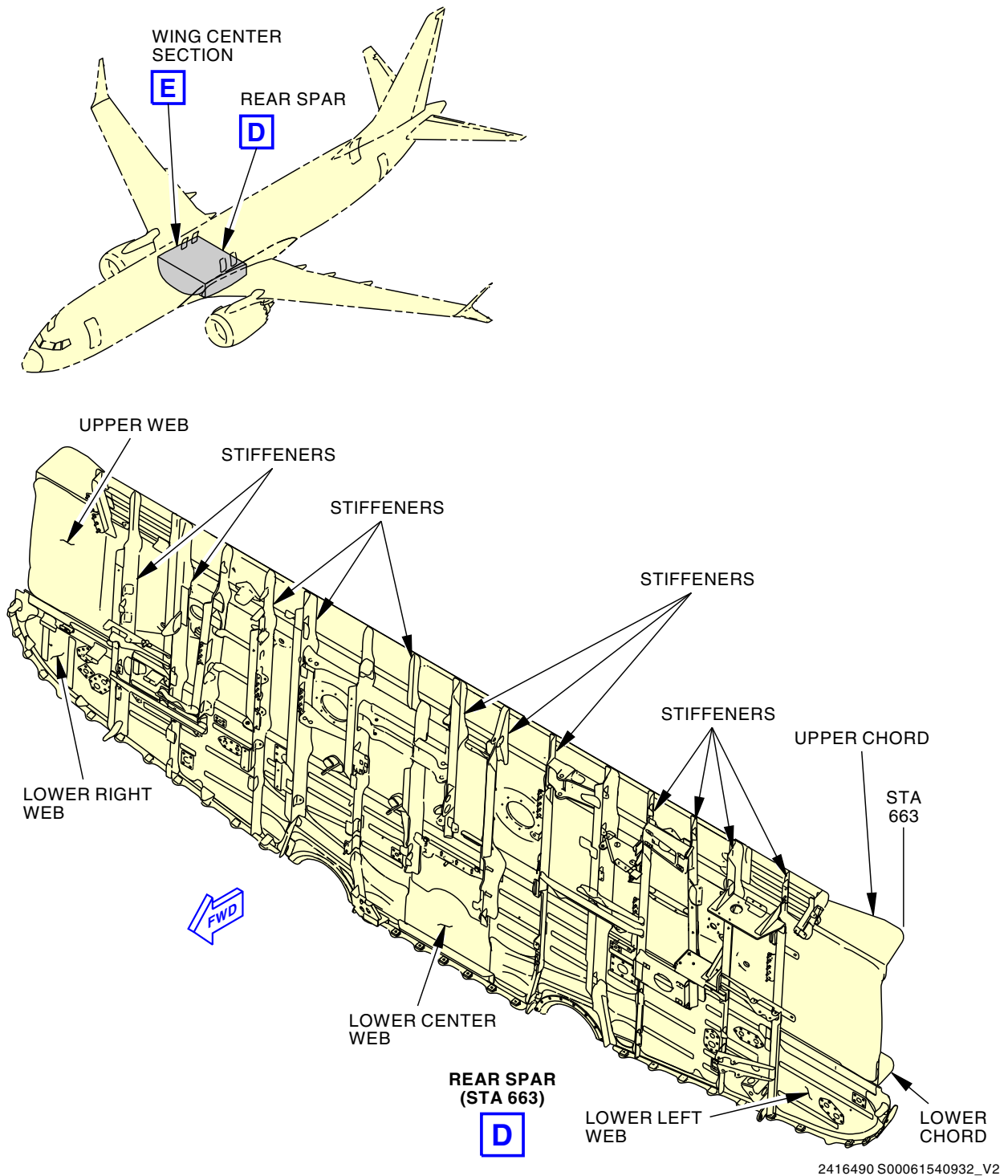
INTERNAL-GENERAL VISUAL: INTERNAL-WING CENTER SECTION
Figure 202/57-05-03-990-802 (Sheet 2 of 4)

EFFECTIVITY
SIA ALL

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INTERNAL-GENERAL VISUAL: INTERNAL-WING CENTER SECTION
Figure 202/57-05-03-990-802 (Sheet 3 of 4)

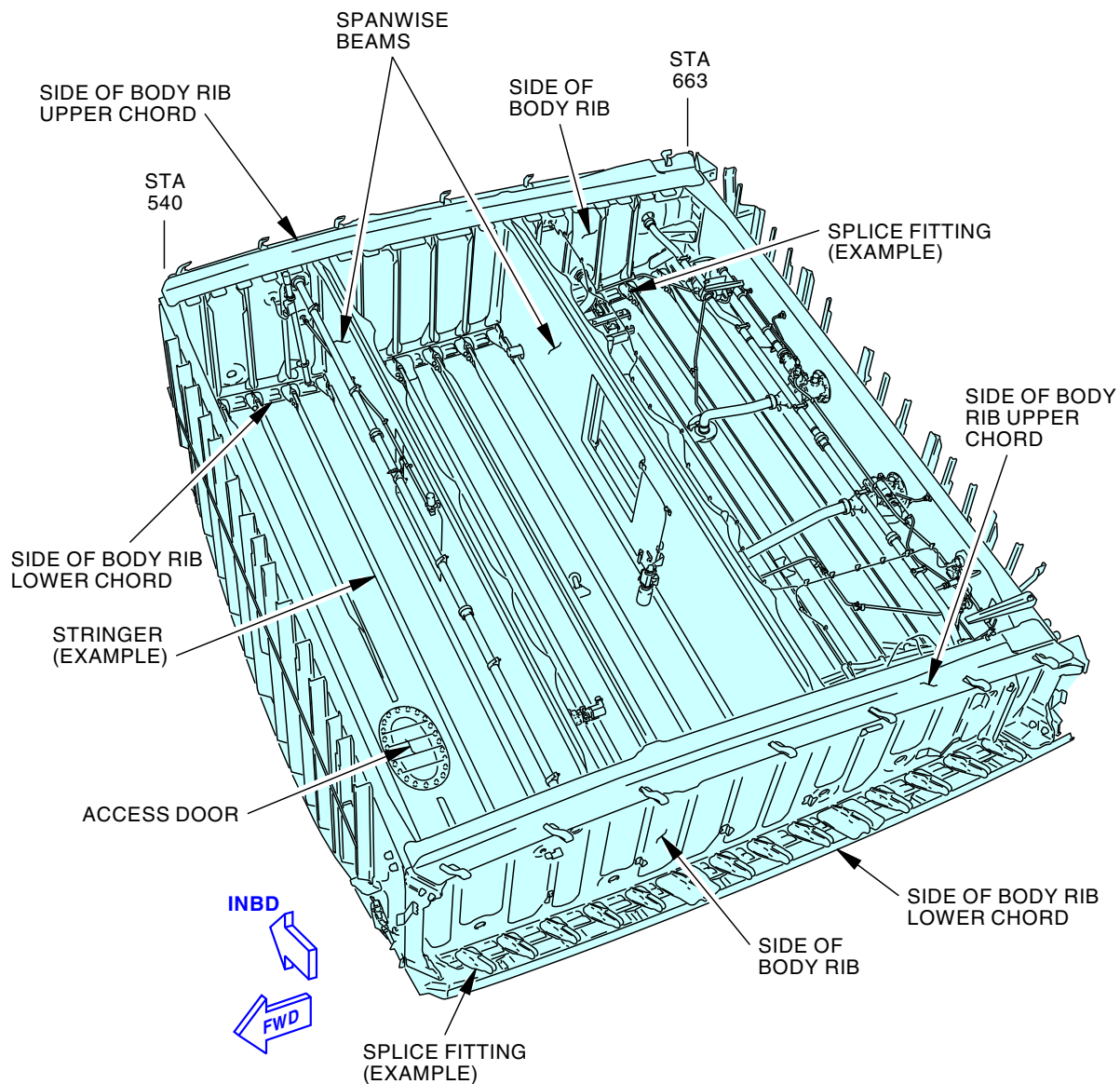
EFFECTIVITY
SIA ALL

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WING CENTER SECTION
(UPPER SKIN IS NOT SHOWN)

E

2416491 S00061540933_V1

INTERNAL-GENERAL VISUAL: INTERNAL-WING CENTER SECTION
Figure 202/57-05-03-990-802 (Sheet 4 of 4)

EFFECTIVITY
SIA ALL

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TASK 57-05-03-210-803

3. EXTERNAL - GENERAL VISUAL: WING CENTER SECTION

(Figure 203, Figure 204, Figure 205)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-806	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
133	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Left
134	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Right
192	Lower Wing-To-Body Fairing - Under Wing Box

C. Access Panels

Number	Name/Location
192BL	ECS Ram Air Inlet Mixing Duct Panel - Forward
192BR	ECS Ram Air Inlet Mixing Duct Panel - Forward
192CL	ECS Access Door
192CR	ECS Access Door
192E	ECS Under Keel Panel - Forward
192F	ECS Under Keel Panel - Middle
S1007	Aft Side Wing Center Section Inspection

D. Inspection

SUBTASK 57-05-03-010-003

- (1) Open these access panels:

<u>Number</u>	<u>Name/Location</u>
192BL	ECS Ram Air Inlet Mixing Duct Panel - Forward
192BR	ECS Ram Air Inlet Mixing Duct Panel - Forward
192CL	ECS Access Door
192CR	ECS Access Door
192E	ECS Under Keel Panel - Forward
192F	ECS Under Keel Panel - Middle

Special Access:

<u>Number</u>	<u>Name/Location</u>
S1007	Aft Side Wing Center Section Inspection

SUBTASK 57-05-03-210-003

- (2) Do a General Visual inspection of the aft side of rear spar (includes keel beam stiffeners at BL 6.2, and side of body rear spar terminal fitting).

SUBTASK 57-05-03-910-003

- (3) Do this task: 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 57-05-03-410-003

- (4) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
192BL	ECS Ram Air Inlet Mixing Duct Panel - Forward

EFFECTIVITY
SIA ALL

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(Continued)

<u>Number</u>	<u>Name/Location</u>
192BR	ECS Ram Air Inlet Mixing Duct Panel - Forward
192CL	ECS Access Door
192CR	ECS Access Door
192E	ECS Under Keel Panel - Forward
192F	ECS Under Keel Panel - Middle

———— **END OF TASK** ————

EFFECTIVITY
SIA ALL

D633AM101-SIA

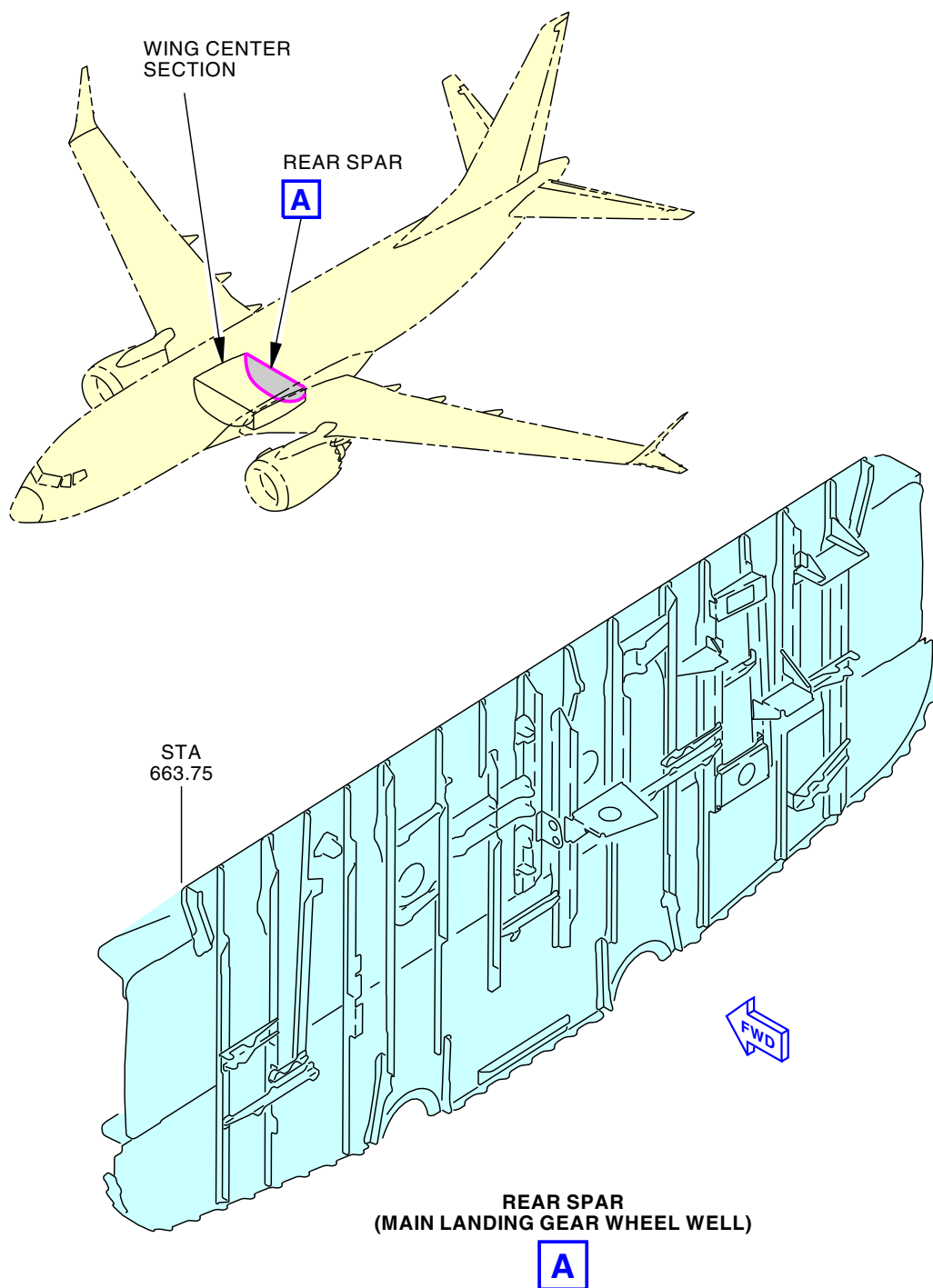
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2416492 S00061540935_V1

EXTERNAL-GENERAL VISUAL: EXTERNAL-WING CENTER SECTION
Figure 203/57-05-03-990-803

EFFECTIVITY
SIA ALL

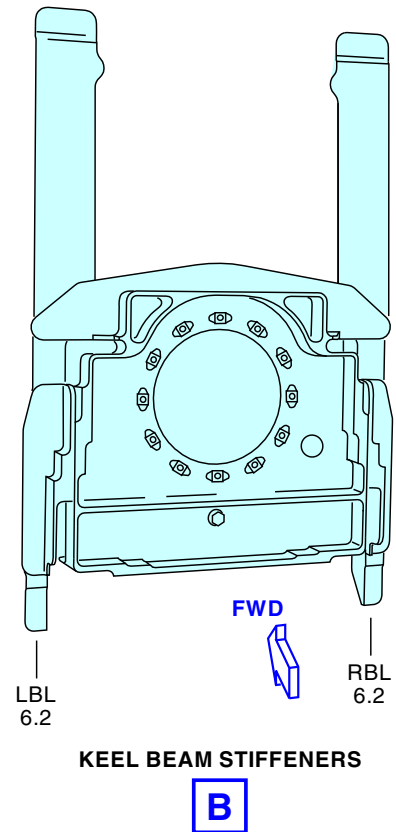
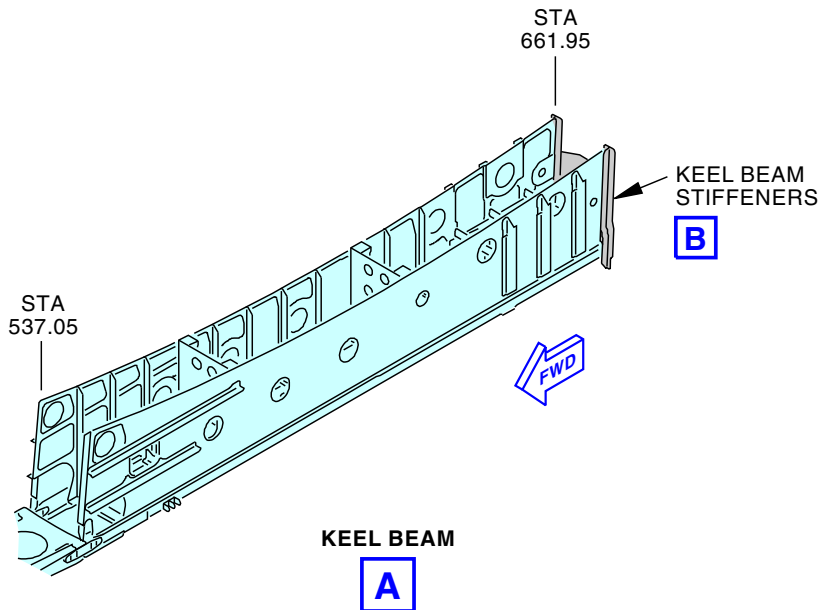
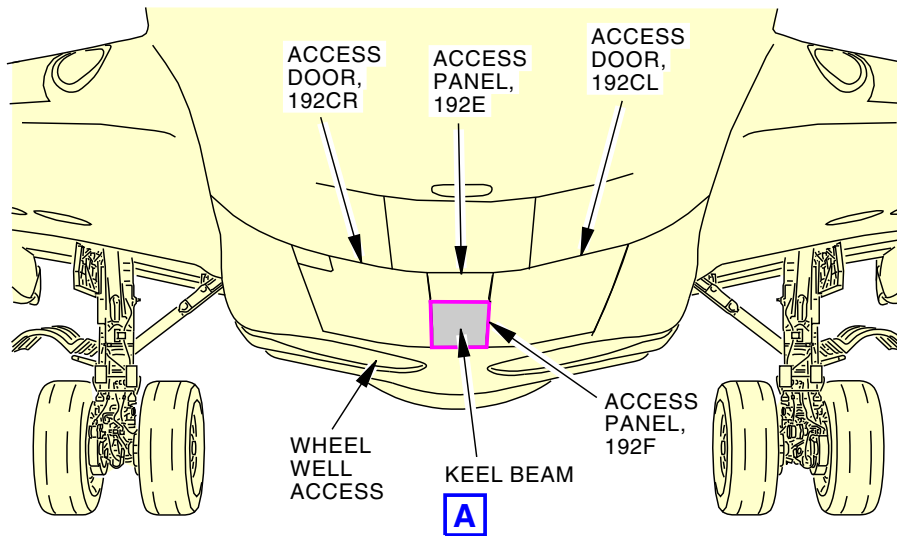
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL**



2416493 S00061540936_V1

EXTERNAL-GENERAL VISUAL: EXTERNAL WING CENTER SECTION
Figure 204/57-05-03-990-804

EFFECTIVITY
SIA ALL

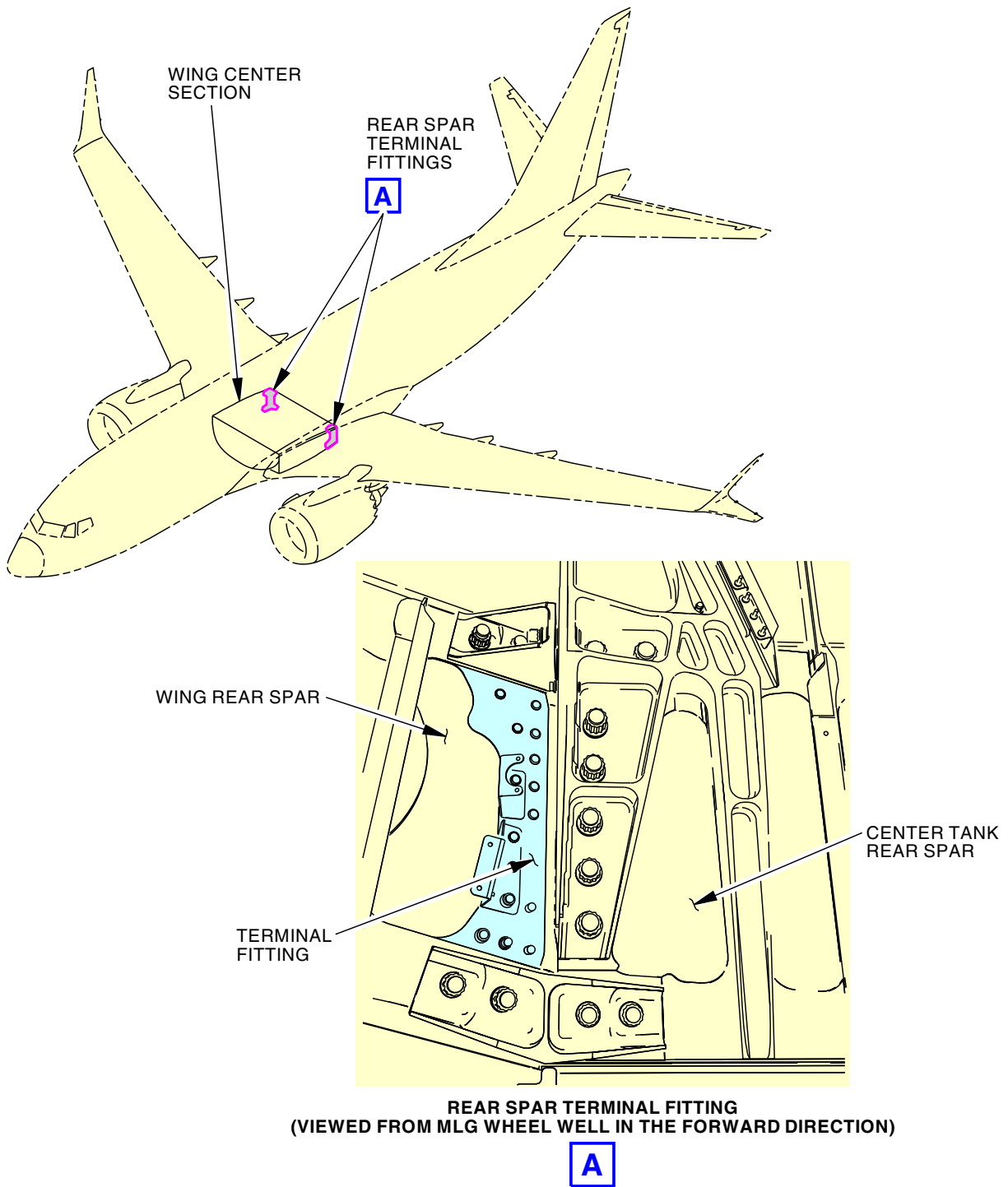
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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**737-7/8/8200/9/10
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2416494 S00061540937_V1

**Rear Spar Terminal Fittings
Figure 205/57-05-03-990-805**

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL

TASK 57-05-03-210-804

4. **INTERNAL - GENERAL VISUAL: WING CENTER SECTION**

(Figure 206)

NOTE: This procedure is a scheduled maintenance task.

A. **References**

Reference	Title
51-05-01-210-804	737-7/8/8200/9 Basic Task Description (P/B 201)
53-51-21-000-804	Center Wing-To-Body Fairing Panel (192AL, 192AR, 192HL, 192HR, 195BL, 195BR) Removal (P/B 401)
53-51-21-400-804	Center Wing-To-Body Fairing Panel (192AL, 192AR, 192HL, 192HR, 195BL, 195BR) - Installation (P/B 401)

B. **Location Zones**

Zone	Area
131	Center Section Wing Box, Body Station 540.00 to Body Station 663.75 - Left
132	Center Section Wing Box, Body Station 540.00 to Body Station 663.75 - Right
192	Lower Wing-To-Body Fairing - Under Wing Box

C. **Access Panels**

Number	Name/Location
192AL	Underwing Bolt Cover - Forward
192AR	Underwing Bolt Cover - Forward
192BL	ECS Ram Air Inlet Mixing Duct Panel - Forward
192BR	ECS Ram Air Inlet Mixing Duct Panel - Forward
192CL	ECS Access Door
192CR	ECS Access Door
192E	ECS Under Keel Panel - Forward
192F	ECS Under Keel Panel - Middle
192HL	Underwing Bolt Cover - Aft
192HR	Underwing Bolt Cover - Aft
S1008	Lower Side Wing Center Section Inspection

D. **Inspection**

SUBTASK 57-05-03-010-060

(1) Open these access panels:

(TASK 53-51-21-000-804)

Number	Name/Location
192AL	Underwing Bolt Cover - Forward
192AR	Underwing Bolt Cover - Forward
192HL	Underwing Bolt Cover - Aft
192HR	Underwing Bolt Cover - Aft

SUBTASK 57-05-03-010-004

(2) Open these access panels:

Number	Name/Location
192BL	ECS Ram Air Inlet Mixing Duct Panel - Forward
192BR	ECS Ram Air Inlet Mixing Duct Panel - Forward

EFFECTIVITY
SIA ALL

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(Continued)

<u>Number</u>	<u>Name/Location</u>
192CL	ECS Access Door
192CR	ECS Access Door
192E	ECS Under Keel Panel - Forward
192F	ECS Under Keel Panel - Middle

Special Access:

<u>Number</u>	<u>Name/Location</u>
S1008	Lower Side Wing Center Section Inspection

NOTE: Remove the ECS heat exchanger access panel.

SUBTASK 57-05-03-210-004

- (3) Do a General Visual inspection of the lower side of lower surface of wing center section:
- (a) Skins, typical stringers, splice stringers, front and rear spar lower chords
 - (b) Side of body lower tee chord and splice plates
 - (c) Lower beams at BL 41
 - (d) At attachments to keel beam, to lower beams at BL 41, to fuselage drag angles; at drain installation and access holes.

SUBTASK 57-05-03-910-004

- (4) Do this task: 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-804.

SUBTASK 57-05-03-410-004

- (5) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
192BL	ECS Ram Air Inlet Mixing Duct Panel - Forward
192BR	ECS Ram Air Inlet Mixing Duct Panel - Forward
192CL	ECS Access Door
192CR	ECS Access Door
192E	ECS Under Keel Panel - Forward
192F	ECS Under Keel Panel - Middle

SUBTASK 57-05-03-410-056

- (6) Close these access panels:

(TASK 53-51-21-400-804)

<u>Number</u>	<u>Name/Location</u>
192AL	Underwing Bolt Cover - Forward
192AR	Underwing Bolt Cover - Forward
192HL	Underwing Bolt Cover - Aft
192HR	Underwing Bolt Cover - Aft

———— **END OF TASK** ————

EFFECTIVITY
SIA ALL

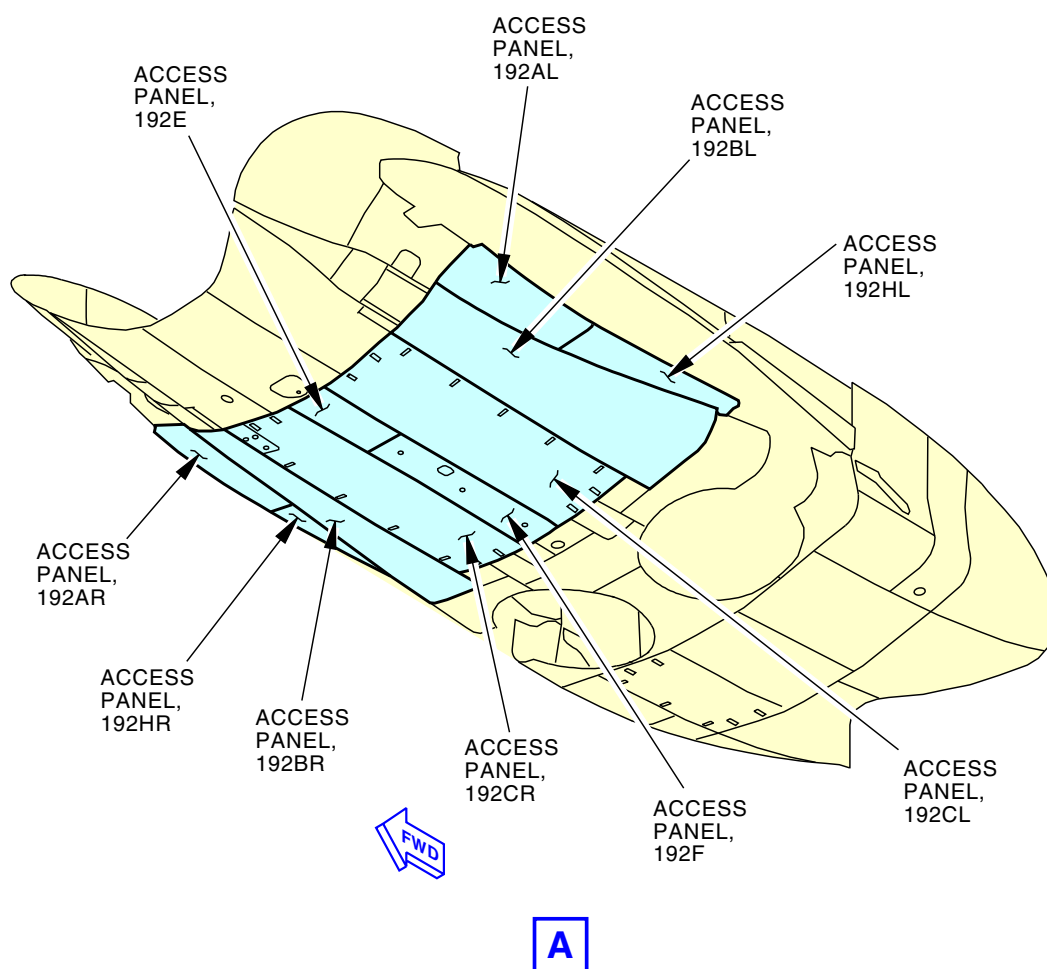
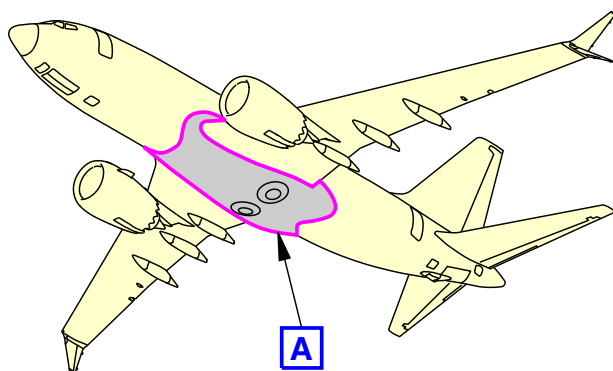
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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2416495 S00061540939_V1

Wing Center Section - General Visual (Internal)
Figure 206/57-05-03-990-806

EFFECTIVITY
SIA ALL

57-05-03

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AIRCRAFT MAINTENANCE MANUAL

TASK 57-05-03-210-805

5. **INTERNAL - GENERAL VISUAL: WING CENTER SECTION**

(Figure 207)

NOTE: This procedure is a scheduled maintenance task.

A. **References**

Reference	Title
51-05-01-210-806	737-7/8/8200/9 Basic Task Description (P/B 201)
53-51-21-000-804	Center Wing-To-Body Fairing Panel (192AL, 192AR, 192HL, 192HR, 195BL, 195BR) Removal (P/B 401)
53-51-21-400-804	Center Wing-To-Body Fairing Panel (192AL, 192AR, 192HL, 192HR, 195BL, 195BR) - Installation (P/B 401)

B. **Location Zones**

Zone	Area
125	Air Conditioning Distribution Bay - Left
126	Air Conditioning Distribution Bay - Right
192	Lower Wing-To-Body Fairing - Under Wing Box

C. **Access Panels**

Number	Name/Location
121EW	Panel Assy - FWD Cargo Compartment Aft Bulkhead
121HW	Panel Assy - FWD Cargo Compartment Aft Bulkhead
122GW	Panel Assy - FWD Cargo Compartment Aft Bulkhead
191FL	Forward Wing-To-Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
191FR	Forward Wing-To-Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
192AL	Underwing Bolt Cover - Forward
192AR	Underwing Bolt Cover - Forward
192BL	ECS Ram Air Inlet Mixing Duct Panel - Forward
192BR	ECS Ram Air Inlet Mixing Duct Panel - Forward
192HL	Underwing Bolt Cover - Aft
192HR	Underwing Bolt Cover - Aft

D. **Inspection**

SUBTASK 57-05-03-010-061

(1) Open these access panels:

(TASK 53-51-21-000-804)

Number	Name/Location
192AL	Underwing Bolt Cover - Forward
192AR	Underwing Bolt Cover - Forward
192HL	Underwing Bolt Cover - Aft
192HR	Underwing Bolt Cover - Aft

SUBTASK 57-05-03-010-005

(2) Open these access panels:

Number	Name/Location
121EW	Panel Assy - FWD Cargo Compartment Aft Bulkhead
121HW	Panel Assy - FWD Cargo Compartment Aft Bulkhead

EFFECTIVITY
SIA ALL

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(Continued)

<u>Number</u>	<u>Name/Location</u>
122GW	Panel Assy - FWD Cargo Compartment Aft Bulkhead
191FL	Forward Wing-To-Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
191FR	Forward Wing-To-Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
192BL	ECS Ram Air Inlet Mixing Duct Panel - Forward
192BR	ECS Ram Air Inlet Mixing Duct Panel - Forward

SUBTASK 57-05-03-210-005

- (3) Do a General Visual inspection of the forward side of front spar (includes the side of body/terminal fitting attachments).

SUBTASK 57-05-03-910-005

- (4) Do this task: 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 57-05-03-410-005

- (5) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
121EW	Panel Assy - FWD Cargo Compartment Aft Bulkhead
121HW	Panel Assy - FWD Cargo Compartment Aft Bulkhead
122GW	Panel Assy - FWD Cargo Compartment Aft Bulkhead
191FL	Forward Wing-To-Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
191FR	Forward Wing-To-Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
192BL	ECS Ram Air Inlet Mixing Duct Panel - Forward
192BR	ECS Ram Air Inlet Mixing Duct Panel - Forward

SUBTASK 57-05-03-410-060

- (6) Close these access panels:

(TASK 53-51-21-400-804)

<u>Number</u>	<u>Name/Location</u>
192AL	Underwing Bolt Cover - Forward
192AR	Underwing Bolt Cover - Forward
192HL	Underwing Bolt Cover - Aft
192HR	Underwing Bolt Cover - Aft

———— **END OF TASK** ————

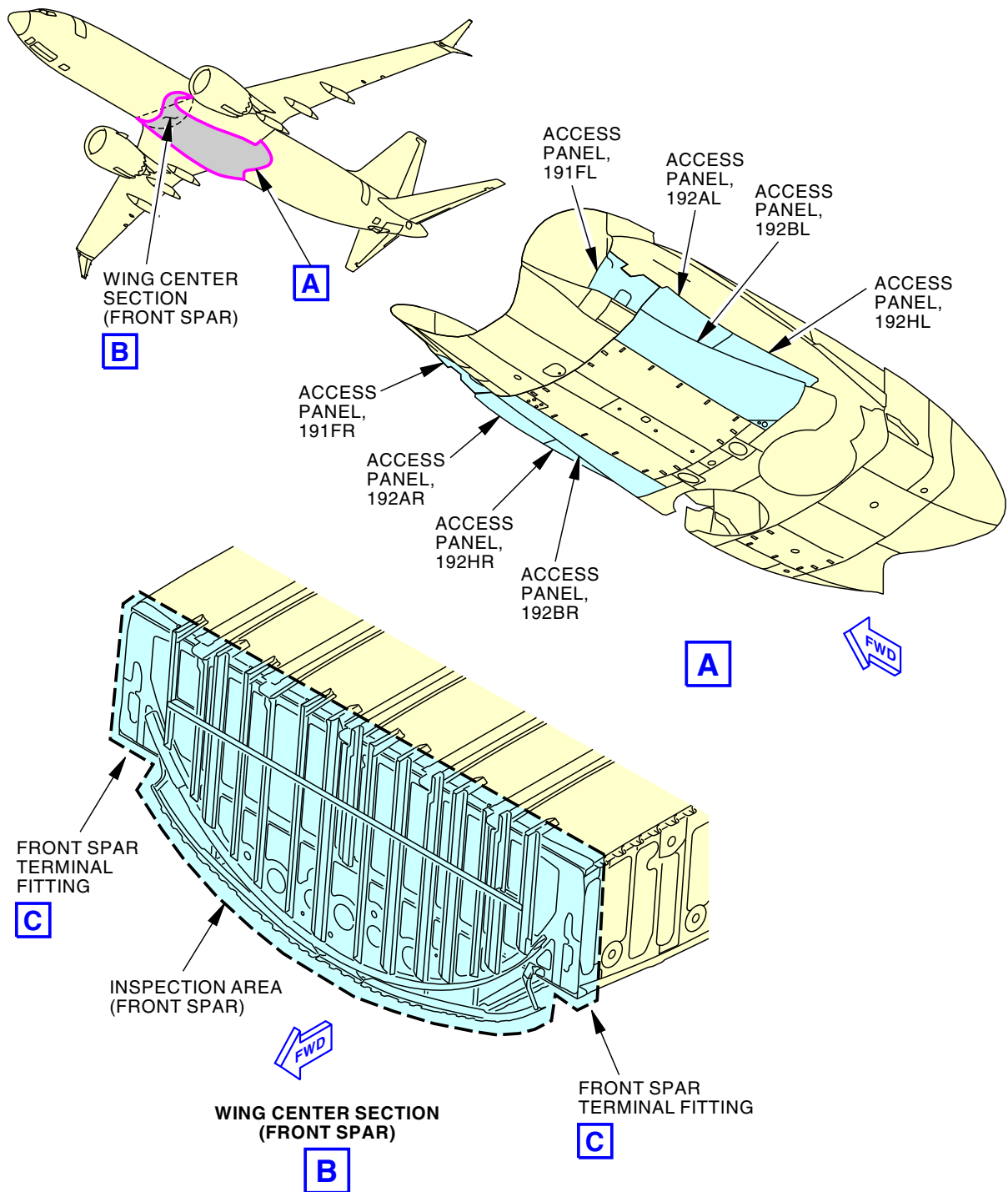
EFFECTIVITY
SIA ALL

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2416496 S00061540941_V1

Wing Center Section
Figure 207/57-05-03-990-807 (Sheet 1 of 2)

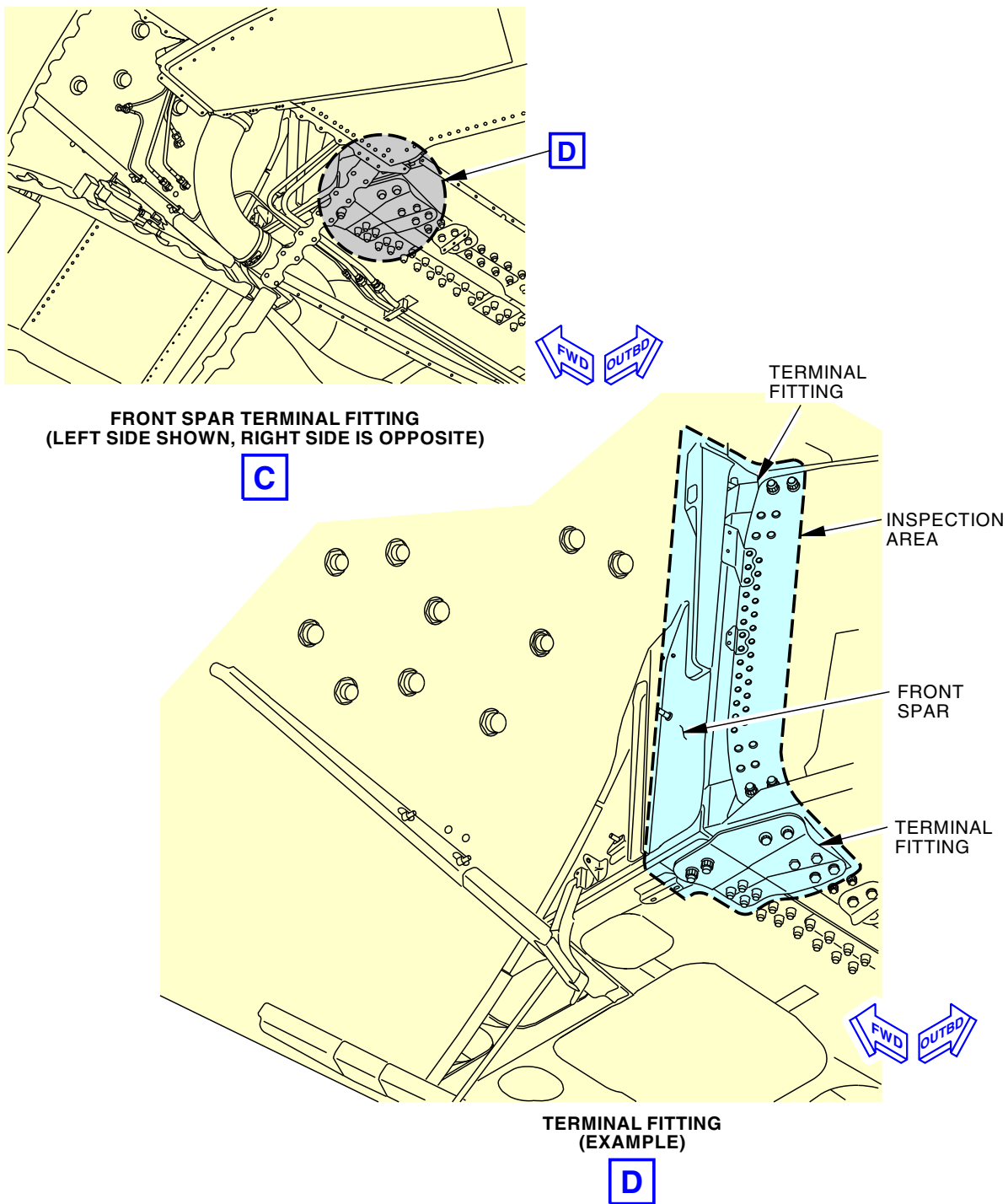
EFFECTIVITY
SIA ALL

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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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2416497 S00061540942_V1

Wing Center Section
Figure 207/57-05-03-990-807 (Sheet 2 of 2)

EFFECTIVITY
SIA ALL

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ECCN 9E991 BOEING PROPRIETARY - See title page for details



737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL

TASK 57-05-03-210-806

6. INTERNAL - GENERAL VISUAL: LEFT OUTBOARD WING

(Figure 208)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-806	737-7/8/8200/9 Basic Task Description (P/B 201)
53-51-21-000-804	Center Wing-To-Body Fairing Panel (192AL, 192AR, 192HL, 192HR, 195BL, 195BR) Removal (P/B 401)
53-51-21-400-804	Center Wing-To-Body Fairing Panel (192AL, 192AR, 192HL, 192HR, 195BL, 195BR) - Installation (P/B 401)

B. Location Zones

Zone	Area
192	Lower Wing-To-Body Fairing - Under Wing Box
511	Left Wing - Leading Edge To Front Spar
531	Left Wing - Center Fuel Tank, Rib 1 to Rib 5
551	Left Wing - Rear Spar To Landing Gear Support Beam

C. Access Panels

Number	Name/Location
191AL	Forward Wing-To-Body Fairing Panel - Upper
191FL	Forward Wing-To-Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
192AL	Underwing Bolt Cover - Forward
192BL	ECS Ram Air Inlet Mixing Duct Panel - Forward
192HL	Underwing Bolt Cover - Aft
193AL	Wheel Well Panel - Forward Outboard
193CL	Wheel Well Panel - Aft Outboard

D. Inspection

SUBTASK 57-05-03-010-062

(1) Open these access panels:

(TASK 53-51-21-000-804)

Number	Name/Location
192AL	Underwing Bolt Cover - Forward
192HL	Underwing Bolt Cover - Aft

SUBTASK 57-05-03-010-006

(2) Open these access panels:

Number	Name/Location
191AL	Forward Wing-To-Body Fairing Panel - Upper
191FL	Forward Wing-To-Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
192BL	ECS Ram Air Inlet Mixing Duct Panel - Forward
193AL	Wheel Well Panel - Forward Outboard
193CL	Wheel Well Panel - Aft Outboard

EFFECTIVITY
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SUBTASK 57-05-03-210-006

- (3) Do a General Visual inspection of the left outboard wing lower surface (under lower side of body fairing), including attachment locations.

SUBTASK 57-05-03-910-006

- (4) Do this task: 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 57-05-03-410-006

- (5) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
191AL	Forward Wing-To-Body Fairing Panel - Upper
191FL	Forward Wing-To-Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
192BL	ECS Ram Air Inlet Mixing Duct Panel - Forward
193AL	Wheel Well Panel - Forward Outboard
193CL	Wheel Well Panel - Aft Outboard

SUBTASK 57-05-03-410-061

- (6) Close these access panels:

(TASK 53-51-21-400-804)

<u>Number</u>	<u>Name/Location</u>
192AL	Underwing Bolt Cover - Forward
192HL	Underwing Bolt Cover - Aft

————— END OF TASK —————

EFFECTIVITY
SIA ALL

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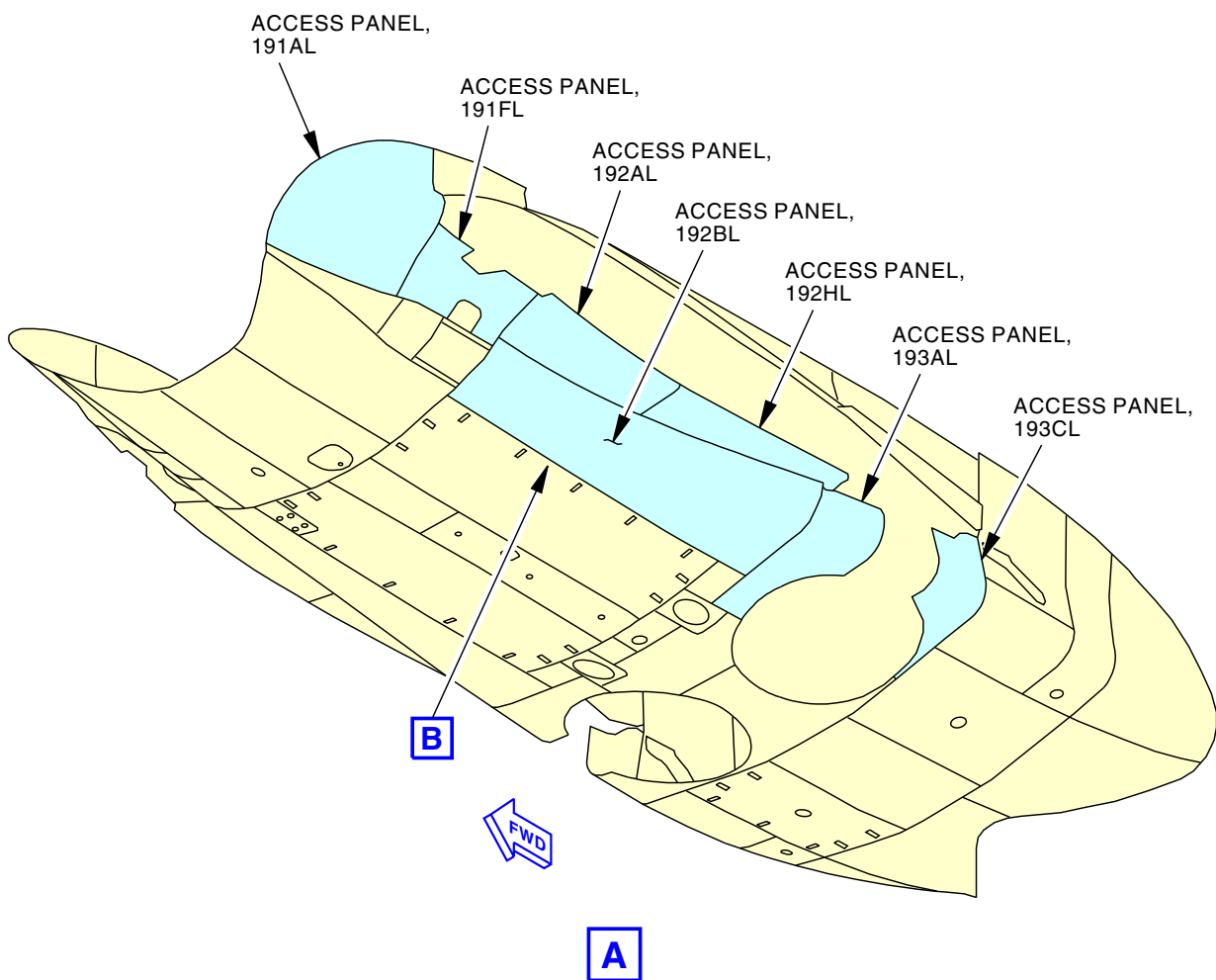
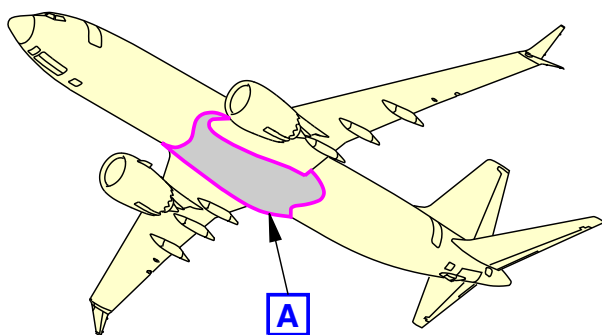
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AIRCRAFT MAINTENANCE MANUAL



2416498 S00061540944_V1

Left Outboard Wing General Visual (Internal)
Figure 208/57-05-03-990-808 (Sheet 1 of 2)

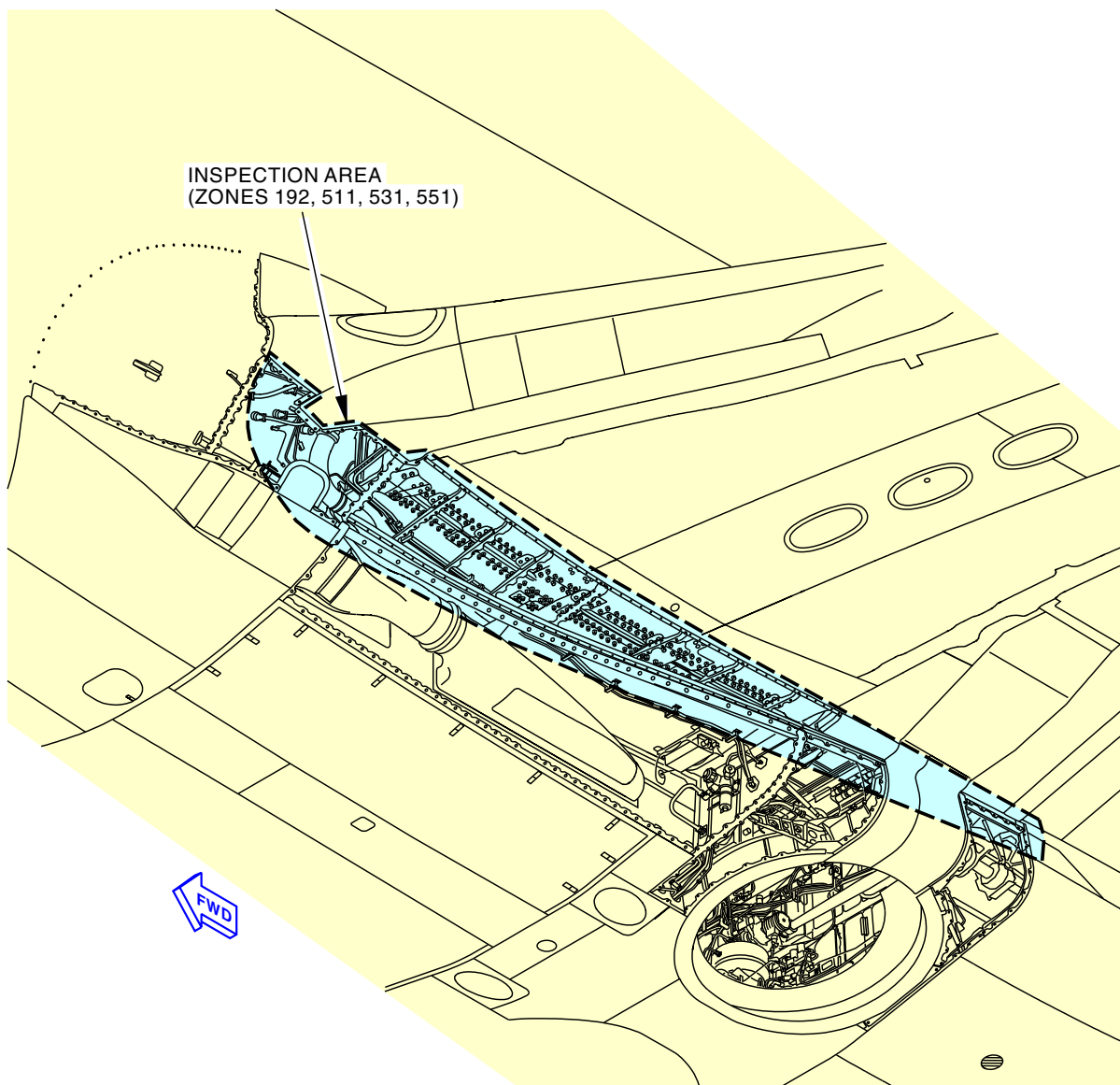
EFFECTIVITY
SIA ALL

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B

2416499 S00061540945_V1

Left Outboard Wing General Visual (Internal)
Figure 208/57-05-03-990-808 (Sheet 2 of 2)

EFFECTIVITY
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AIRCRAFT MAINTENANCE MANUAL

TASK 57-05-03-210-807

7. INTERNAL - GENERAL VISUAL: RIGHT OUTBOARD WING

(Figure 209)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-806	737-7/8/8200/9 Basic Task Description (P/B 201)
53-51-21-000-804	Center Wing-To-Body Fairing Panel (192AL, 192AR, 192HL, 192HR, 195BL, 195BR) Removal (P/B 401)
53-51-21-400-804	Center Wing-To-Body Fairing Panel (192AL, 192AR, 192HL, 192HR, 195BL, 195BR) - Installation (P/B 401)

B. Location Zones

Zone	Area
192	Lower Wing-To-Body Fairing - Under Wing Box
611	Right Wing - Leading Edge to Front Spar
631	Right Wing - Center Fuel Tank, Rib 1 to Rib 5
651	Right Wing - Rear Spar to Landing Gear Support Beam

C. Access Panels

Number	Name/Location
191AR	Forward Wing-To-Body Fairing Panel - Upper
191FR	Forward Wing-To-Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
192AR	Underwing Bolt Cover - Forward
192BR	ECS Ram Air Inlet Mixing Duct Panel - Forward
192HR	Underwing Bolt Cover - Aft
193AR	Wheel Well Panel - Forward Outboard
193CR	Wheel Well Panel - Aft Outboard

D. Inspection

SUBTASK 57-05-03-010-063

(1) Open these access panels:

(TASK 53-51-21-000-804)

Number	Name/Location
192AR	Underwing Bolt Cover - Forward
192HR	Underwing Bolt Cover - Aft

SUBTASK 57-05-03-010-007

(2) Open these access panels:

Number	Name/Location
191AR	Forward Wing-To-Body Fairing Panel - Upper
191FR	Forward Wing-To-Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
192BR	ECS Ram Air Inlet Mixing Duct Panel - Forward
193AR	Wheel Well Panel - Forward Outboard
193CR	Wheel Well Panel - Aft Outboard

EFFECTIVITY
SIA ALL

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SUBTASK 57-05-03-210-007

- (3) Do a General Visual inspection of the right outboard wing lower surface (under the lower side of the body fairing), including attachment locations.

SUBTASK 57-05-03-910-007

- (4) DO this task: 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 57-05-03-410-007

- (5) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
191AR	Forward Wing-To-Body Fairing Panel - Upper
191FR	Forward Wing-To-Body Fairing Panel - Mid Fairing, Above Ram Air Inlet
192BR	ECS Ram Air Inlet Mixing Duct Panel - Forward
193AR	Wheel Well Panel - Forward Outboard
193CR	Wheel Well Panel - Aft Outboard

SUBTASK 57-05-03-410-062

- (6) Close these access panels:

(TASK 53-51-21-400-804)

<u>Number</u>	<u>Name/Location</u>
192AR	Underwing Bolt Cover - Forward
192HR	Underwing Bolt Cover - Aft

————— END OF TASK —————

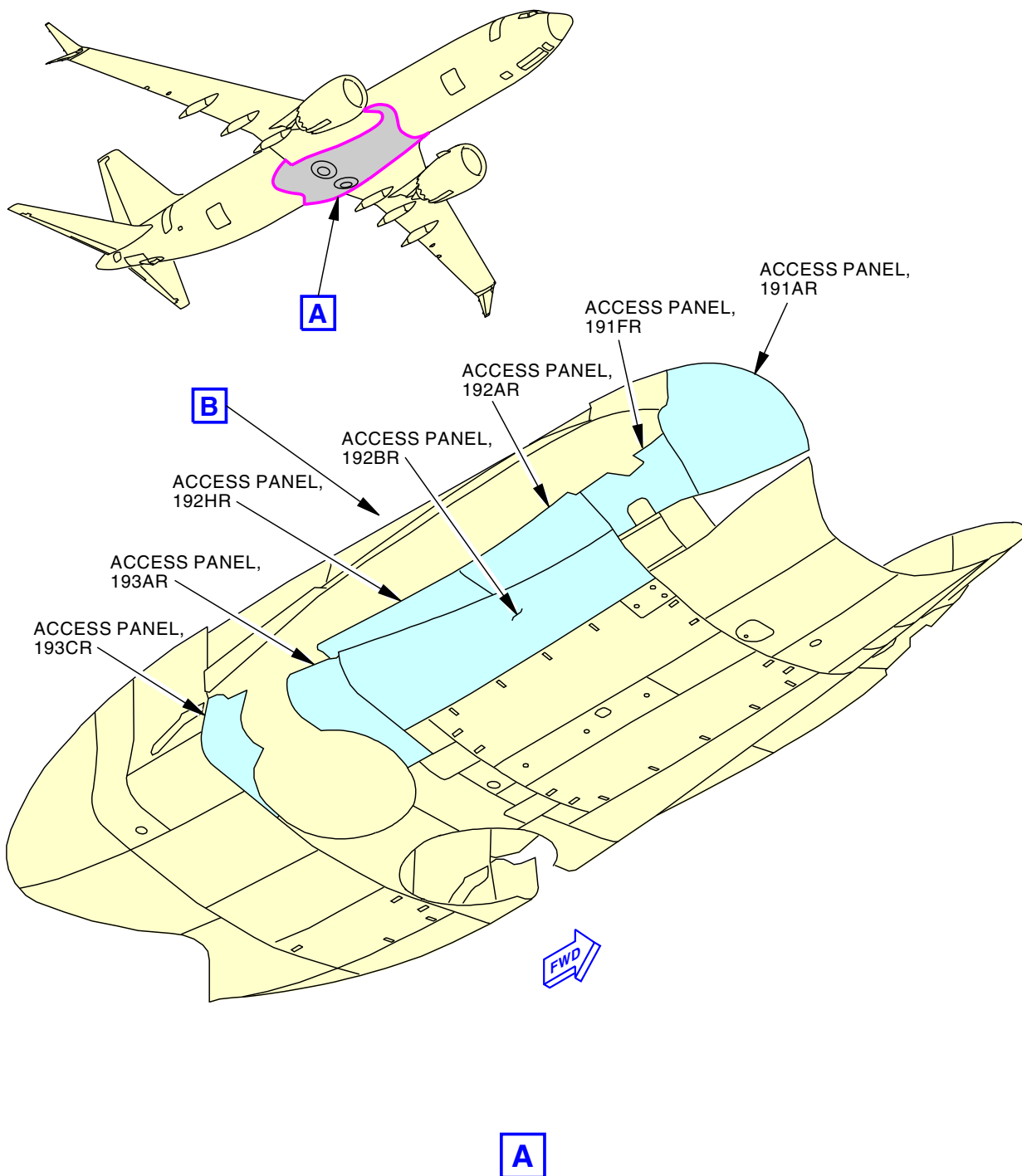
EFFECTIVITY
SIA ALL

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2416500 S00061540947_V1

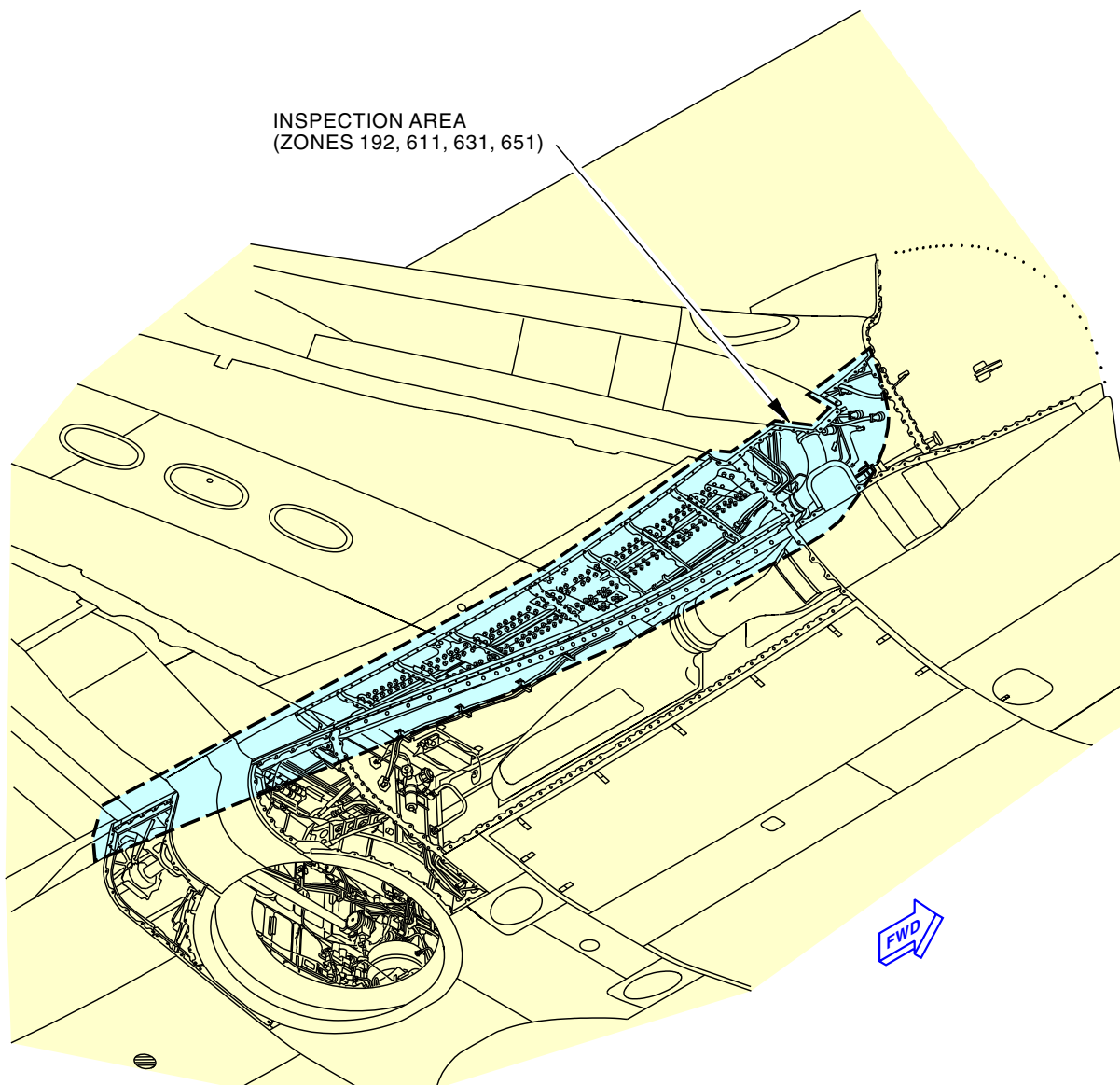
Right Outboard Wing General Visual (Internal)
Figure 209/57-05-03-990-809 (Sheet 1 of 2)

EFFECTIVITY
SIA ALL

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B

2416501 S00061540948_V1

Right Outboard Wing General Visual (Internal)
Figure 209/57-05-03-990-809 (Sheet 2 of 2)

EFFECTIVITY
SIA ALL

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TASK 57-05-03-210-808

8. INTERNAL - GENERAL VISUAL: LEFT OUTBOARD WING

(Figure 210)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-806	737-7/8/8200/9 Basic Task Description (P/B 201)
53-51-21-000-804	Center Wing-To-Body Fairing Panel (192AL, 192AR, 192HL, 192HR, 195BL, 195BR) Removal (P/B 401)
53-51-21-400-804	Center Wing-To-Body Fairing Panel (192AL, 192AR, 192HL, 192HR, 195BL, 195BR) - Installation (P/B 401)

B. Location Zones

Zone	Area
195	Above Wing, Wing-To-Body Fairing - Left
511	Left Wing - Leading Edge To Front Spar
531	Left Wing - Center Fuel Tank, Rib 1 to Rib 5
551	Left Wing - Rear Spar To Landing Gear Support Beam

C. Access Panels

Number	Name/Location
191AL	Forward Wing-To-Body Fairing Panel - Upper
195AL	Wing-To-Body Fairing - Left Side
195BL	Wing-To-Body Fairing - Left Side
195CL	Wing-To-Body Fairing - Left Side

D. Inspection

SUBTASK 57-05-03-010-064

(1) Open this access panel:

(TASK 53-51-21-000-804)

Number	Name/Location
195BL	Wing-To-Body Fairing - Left Side

SUBTASK 57-05-03-010-008

(2) Open these access panels:

Number	Name/Location
191AL	Forward Wing-To-Body Fairing Panel - Upper
195AL	Wing-To-Body Fairing - Left Side
195CL	Wing-To-Body Fairing - Left Side

SUBTASK 57-05-03-210-008

(3) Do a General Visual inspection of the upper side of left outboard wing upper surface (under side-of-body fairing), including:

- (a) Wing upper surface at side-of-body splice, including upper rib chord
- (b) Wing upper surface at attachment locations.

SUBTASK 57-05-03-910-008

(4) Do this task: 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-806..

EFFECTIVITY
SIA ALL

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SUBTASK 57-05-03-410-008

(5) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
191AL	Forward Wing-To-Body Fairing Panel - Upper
195AL	Wing-To-Body Fairing - Left Side
195CL	Wing-To-Body Fairing - Left Side

SUBTASK 57-05-03-410-058

(6) Close this access panel:

(TASK 53-51-21-400-804)

<u>Number</u>	<u>Name/Location</u>
195BL	Wing-To-Body Fairing - Left Side

————— **END OF TASK** —————

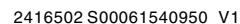
EFFECTIVITY
SIA ALL

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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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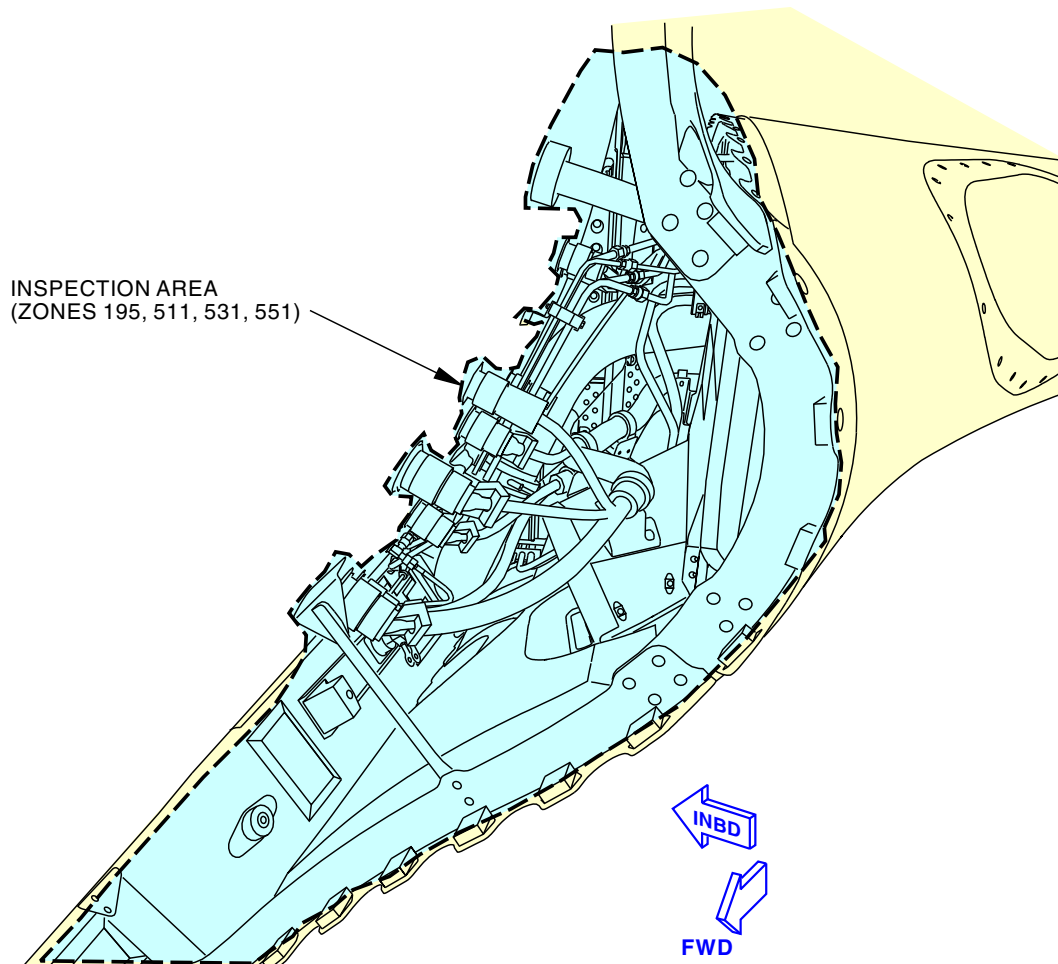
Left Outboard Wing - Wing-to-Body Fairing General Visual (Internal)
Figure 210/57-05-03-990-810 (Sheet 1 of 2)

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(ACCESS PANEL, 191AL IS REMOVED)

B

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Left Outboard Wing - Wing-to-Body Fairing General Visual (Internal)
Figure 210/57-05-03-990-810 (Sheet 2 of 2)

EFFECTIVITY
SIA ALL

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AIRCRAFT MAINTENANCE MANUAL

TASK 57-05-03-210-809

9. **INTERNAL - GENERAL VISUAL: RIGHT OUTBOARD WING**

(Figure 211)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-806	737-7/8/8200/9 Basic Task Description (P/B 201)
53-51-21-000-804	Center Wing-To-Body Fairing Panel (192AL, 192AR, 192HL, 192HR, 195BL, 195BR) Removal (P/B 401)
53-51-21-400-804	Center Wing-To-Body Fairing Panel (192AL, 192AR, 192HL, 192HR, 195BL, 195BR) - Installation (P/B 401)

B. Location Zones

Zone	Area
196	Above Wing, Wing-To-Body Fairing - Right
611	Right Wing - Leading Edge to Front Spar
631	Right Wing - Center Fuel Tank, Rib 1 to Rib 5
651	Right Wing - Rear Spar to Landing Gear Support Beam

C. Access Panels

Number	Name/Location
191AR	Forward Wing-To-Body Fairing Panel - Upper
195AR	Wing-To-Body Fairing - Right Side
195BR	Wing-To-Body Fairing - Right Side
195CR	Wing-To-Body Fairing - Right Side

D. Inspection

SUBTASK 57-05-03-010-065

- (1) Open this access panel:
(TASK 53-51-21-000-804)

Number	Name/Location
195BR	Wing-To-Body Fairing - Right Side

SUBTASK 57-05-03-010-009

- (2) Open these access panels:

Number	Name/Location
191AR	Forward Wing-To-Body Fairing Panel - Upper
195AR	Wing-To-Body Fairing - Right Side
195CR	Wing-To-Body Fairing - Right Side

SUBTASK 57-05-03-210-009

- (3) Do a General Visual inspection of the upper side of right outboard wing upper surface (under side-of-body fairing), including:
- (a) Wing upper surface at side-of-body splice, including upper rib chord
 - (b) Wing upper surface at attachment locations.

SUBTASK 57-05-03-910-009

- (4) Do this task: 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-806..

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SIA ALL

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SUBTASK 57-05-03-410-009

(5) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
191AR	Forward Wing-To-Body Fairing Panel - Upper
195AR	Wing-To-Body Fairing - Right Side
195CR	Wing-To-Body Fairing - Right Side

SUBTASK 57-05-03-410-059

(6) Close this access panel:

(TASK 53-51-21-400-804)

<u>Number</u>	<u>Name/Location</u>
195BR	Wing-To-Body Fairing - Right Side

———— **END OF TASK** ————

EFFECTIVITY
SIA ALL

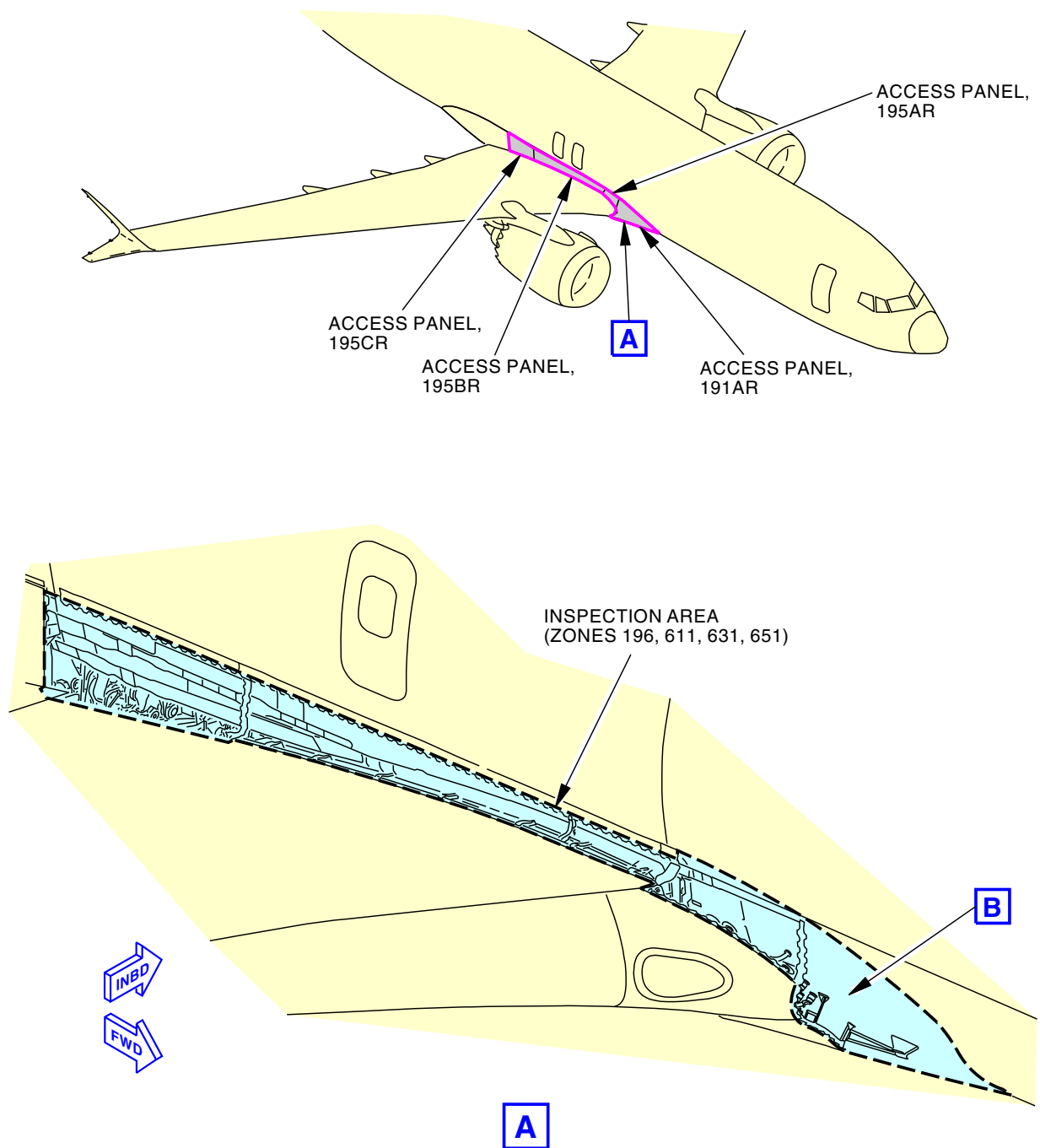
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BOEING
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2416504 S00061540953_V1

Right Outboard Wing - Wing-to-Body Fairing General Visual (Internal)
Figure 211/57-05-03-990-811 (Sheet 1 of 2)

EFFECTIVITY
SIA ALL

D633AM101-SIA

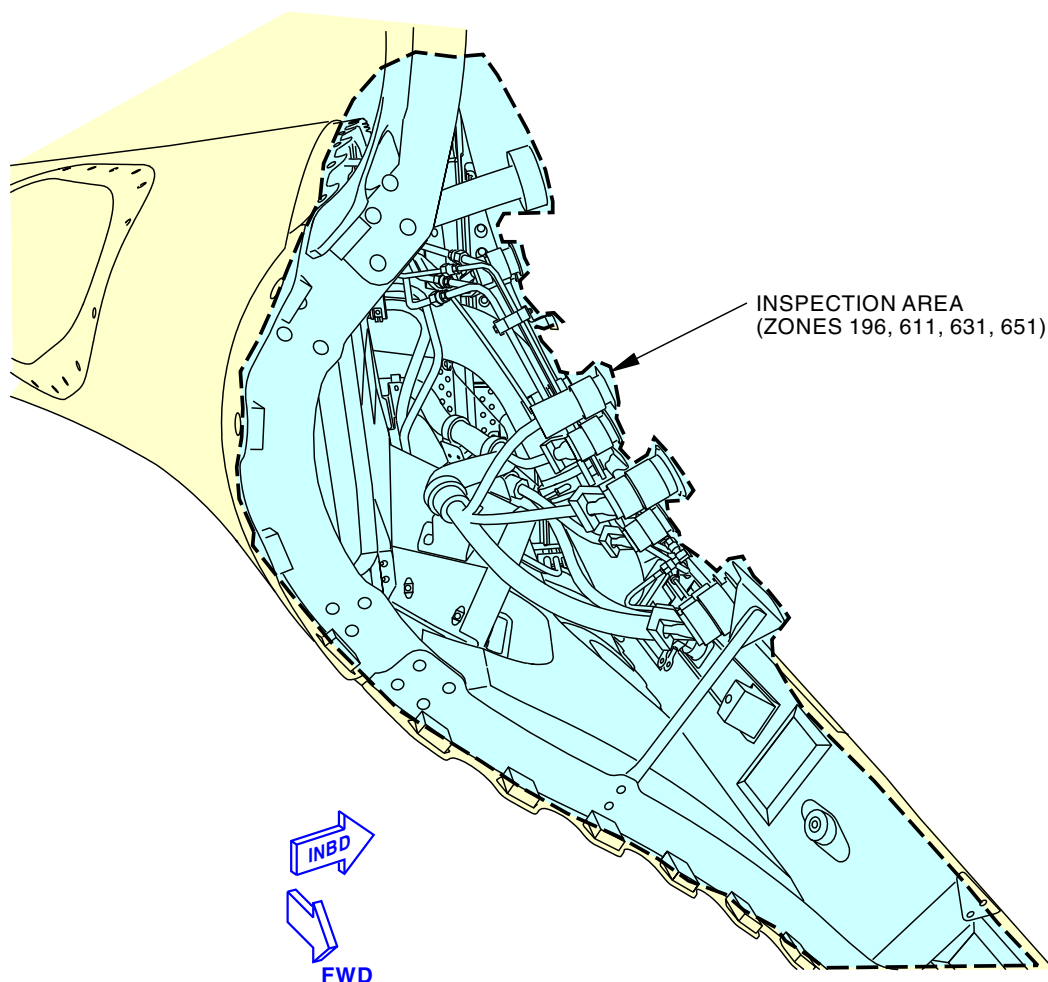
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AIRCRAFT MAINTENANCE MANUAL



(ACCESS PANEL, 191AR IS REMOVED)

B

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Right Outboard Wing - Wing-to-Body Fairing General Visual (Internal)
Figure 211/57-05-03-990-811 (Sheet 2 of 2)

EFFECTIVITY
SIA ALL

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AIRCRAFT MAINTENANCE MANUAL**

TASK 57-05-03-210-810

10. INTERNAL - GENERAL VISUAL: WING CENTER SECTION

(Figure 212)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-808	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
135	Area Above Wing Center Section, Body Station 540 to Body Station 663.75 - Left
136	Area Above Wing Center Section, Body Station 540 to Body Station 663.75 - Right
231	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Left
232	Forward Passenger Compartment - Forward Entry Door to STA 663.75 - Right

C. Inspection

NOTE: Remove the floor panels and insulation as necessary in the passenger compartment for access.

SUBTASK 57-05-03-210-010

- (1) Do a General Visual inspection of the upper side of upper wing surface which includes:
 - (a) Upper panel, including at attachments, front and rear spar upper chords, and side of body upper rib chord
 - (b) Floor beams from Sta 540 to Sta 727B, including at floor beam attachments
 - (c) Condition of secondary vapor barrier.

SUBTASK 57-05-03-910-010

- (2) Do this task: 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-808.

— END OF TASK —

EFFECTIVITY
SIA ALL

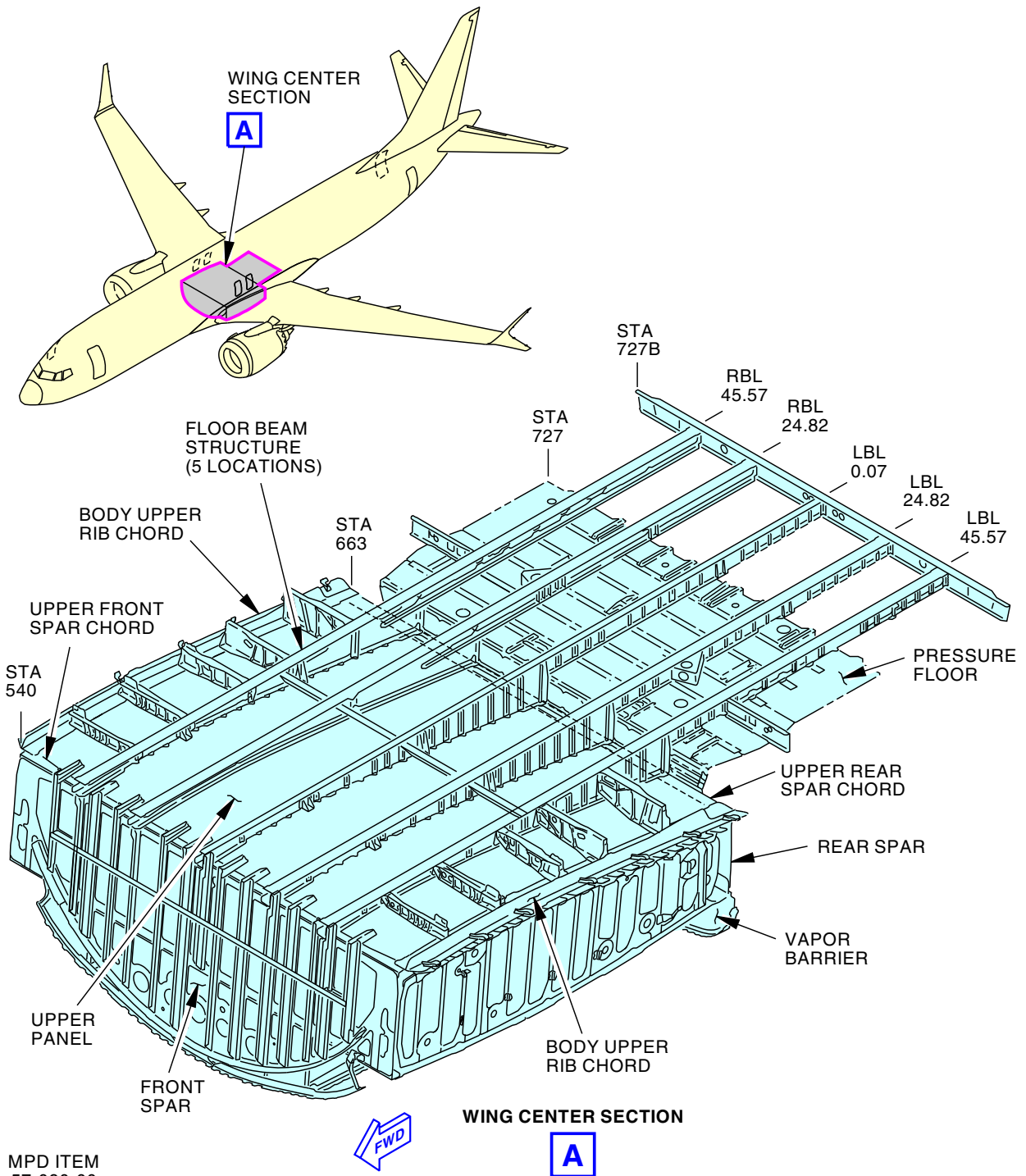
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INTERNAL-GENERAL VISUAL: WING CENTER SECTION
Figure 212/57-05-03-990-812

EFFECTIVITY
SIA ALL

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AIRCRAFT MAINTENANCE MANUAL

TASK 57-05-03-210-811

11. **INTERNAL - GENERAL VISUAL: LEFT NACELLE SUPPORT FITTINGS**

(Figure 213)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-801	737-7/8/8200/9 Basic Task Description (P/B 201)
54-52-06-000-801	Aft Fairing Access Panel Removal (P/B 401)
54-52-06-400-801	Aft Fairing Access Panel Installation (P/B 401)

B. Location Zones

Zone	Area
431	Engine 1 - Forward Strut Fairing
434	Engine 1 - Aft Strut Fairing

C. Access Panels

Number	Name/Location
431CL	Forward Strut Fairing, Left Overwing Fairing, Strut 1
431CR	Forward Strut Fairing, Right Overwing Fairing, Strut 1
434AL	Aft Strut Fairing, Left Panel, Strut 1
434AR	Aft Strut Fairing, Right Panel, Strut 1

D. Inspection

SUBTASK 57-05-03-010-010

- (1) Remove these aft fairing access panels, refer to Aft Fairing Access Panel Removal, TASK 54-52-06-000-801:

- (a) Remove these access panels:

Number	Name/Location
434AL	Aft Strut Fairing, Left Panel, Strut 1
434AR	Aft Strut Fairing, Right Panel, Strut 1

SUBTASK 57-05-03-010-072

- (2) Remove these FWD (Forward) fairing access panels:

- (a) Remove these access panels:

Number	Name/Location
431CL	Forward Strut Fairing, Left Overwing Fairing, Strut 1
431CR	Forward Strut Fairing, Right Overwing Fairing, Strut 1

SUBTASK 57-05-03-210-011

- (3) Do a General Visual inspection of these fittings:

- (a) Front spar pitch load fitting (R1)
- (b) Aft drag load fitting (R2)
- (c) Outboard side load fitting (R3)
- (d) Inboard side load fitting (R4)
- (e) Side brace support fittings (R7 and R8)
- (f) R3 forward backup fitting. Inspect upper wing skin at attachment to nacelle fitting R1.

EFFECTIVITY
SIA ALL

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SUBTASK 57-05-03-910-011

- (4) Do this task: 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-801.

SUBTASK 57-05-03-410-010

- (5) Install these aft fairing access panels, refer to Aft Fairing Access Panel Installation, TASK 54-52-06-400-801:

- (a) Install these access panels:

<u>Number</u>	<u>Name/Location</u>
434AL	Aft Strut Fairing, Left Panel, Strut 1
434AR	Aft Strut Fairing, Right Panel, Strut 1

SUBTASK 57-05-03-410-072

- (6) Install these FWD access panels:

- (a) Install these access panels:

<u>Number</u>	<u>Name/Location</u>
431CL	Forward Strut Fairing, Left Overwing Fairing, Strut 1
431CR	Forward Strut Fairing, Right Overwing Fairing, Strut 1

————— **END OF TASK** —————

EFFECTIVITY
SIA ALL

D633AM101-SIA

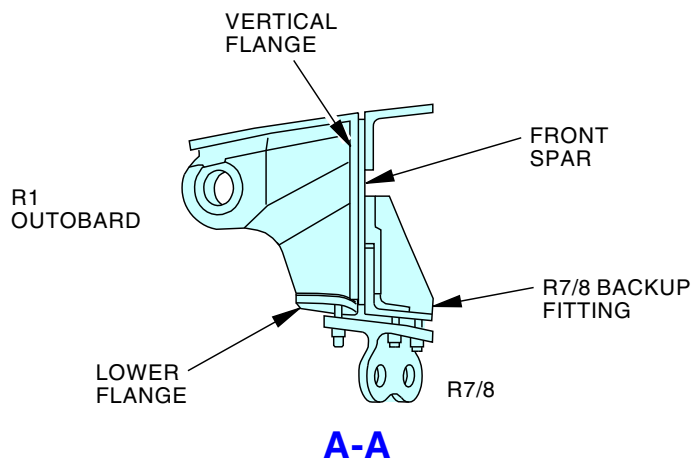
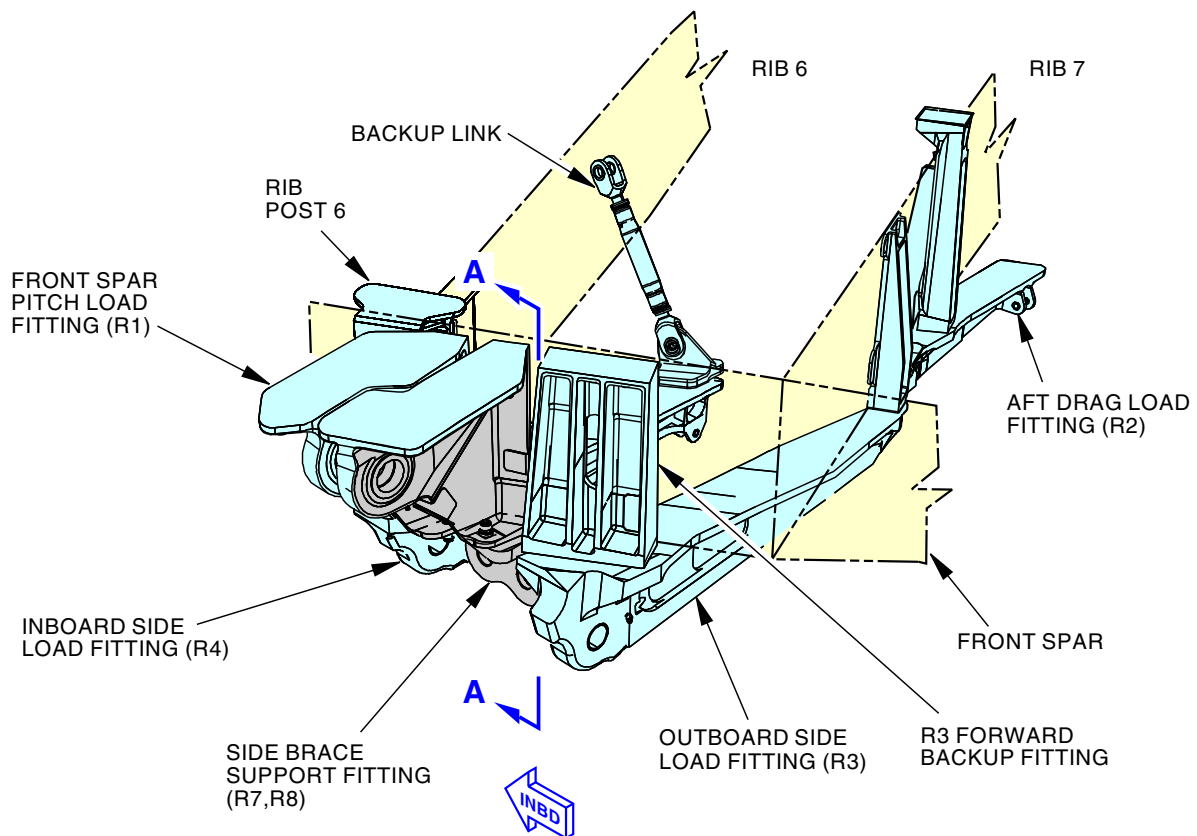
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2416507 S00061540958_V1

Wing - Left Nacelle Support Fittings
Figure 213/57-05-03-990-813

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TASK 57-05-03-210-812

12. **INTERNAL - GENERAL VISUAL: RIGHT NACELLE SUPPORT FITTINGS**

(Figure 214)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-801	737-7/8/8200/9 Basic Task Description (P/B 201)
54-52-06-000-801	Aft Fairing Access Panel Removal (P/B 401)
54-52-06-400-801	Aft Fairing Access Panel Installation (P/B 401)

B. Location Zones

Zone	Area
441	Engine 2 - Forward Strut Fairing
444	Engine 2 - Aft Strut Fairing

C. Access Panels

Number	Name/Location
441CL	Forward Strut Fairing, Left Overwing Fairing, Strut 2
441CR	Forward Strut Fairing, Right Overwing Fairing, Strut 2
444AL	Aft Strut Fairing, Left Panel, Strut 2
444AR	Aft Strut Fairing, Right Panel, Strut 2

D. Inspection

SUBTASK 57-05-03-010-011

- (1) Remove these aft fairing access panels, refer to Aft Fairing Access Panel Removal, TASK 54-52-06-000-801:

- (a) Remove these access panels:

Number	Name/Location
444AL	Aft Strut Fairing, Left Panel, Strut 2
444AR	Aft Strut Fairing, Right Panel, Strut 2

SUBTASK 57-05-03-010-071

- (2) Remove these FWD (Forward) fairing access panels:

- (a) Remove these access panels:

Number	Name/Location
441CL	Forward Strut Fairing, Left Overwing Fairing, Strut 2
441CR	Forward Strut Fairing, Right Overwing Fairing, Strut 2

SUBTASK 57-05-03-210-012

- (3) Do a General Visual inspection of these fittings:

- (a) Front spar pitch load fitting (R1)
- (b) Aft drag load fitting (R2)
- (c) Outboard side load fitting (R3)
- (d) Inboard side load fitting (R4)
- (e) Side brace support fittings (R7 and R8)
- (f) R3 forward backup fitting.
 - 1) Inspect the upper wing skin at attachment to nacelle fitting R1.

EFFECTIVITY
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SUBTASK 57-05-03-910-012

- (4) Do this task: 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-801.

SUBTASK 57-05-03-410-011

- (5) Install these aft fairing access panels, refer to Aft Fairing Access Panel Installation, TASK 54-52-06-400-801:

- (a) Install these access panels:

<u>Number</u>	<u>Name/Location</u>
444AL	Aft Strut Fairing, Left Panel, Strut 2
444AR	Aft Strut Fairing, Right Panel, Strut 2

SUBTASK 57-05-03-410-071

- (6) Install these FWD fairing access panels:

- (a) Install these access panels:

<u>Number</u>	<u>Name/Location</u>
441CL	Forward Strut Fairing, Left Overwing Fairing, Strut 2
441CR	Forward Strut Fairing, Right Overwing Fairing, Strut 2

————— **END OF TASK** —————

EFFECTIVITY
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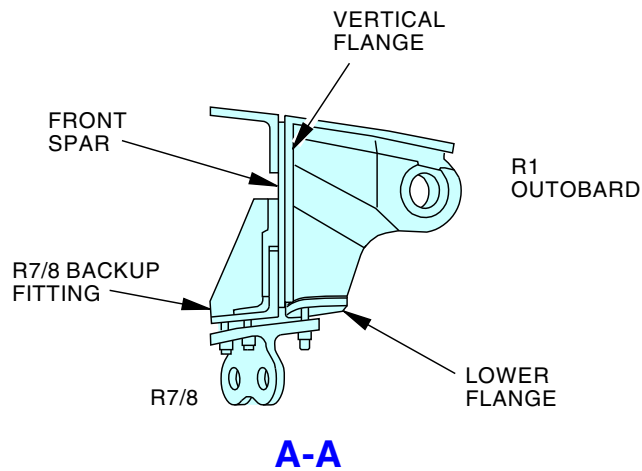
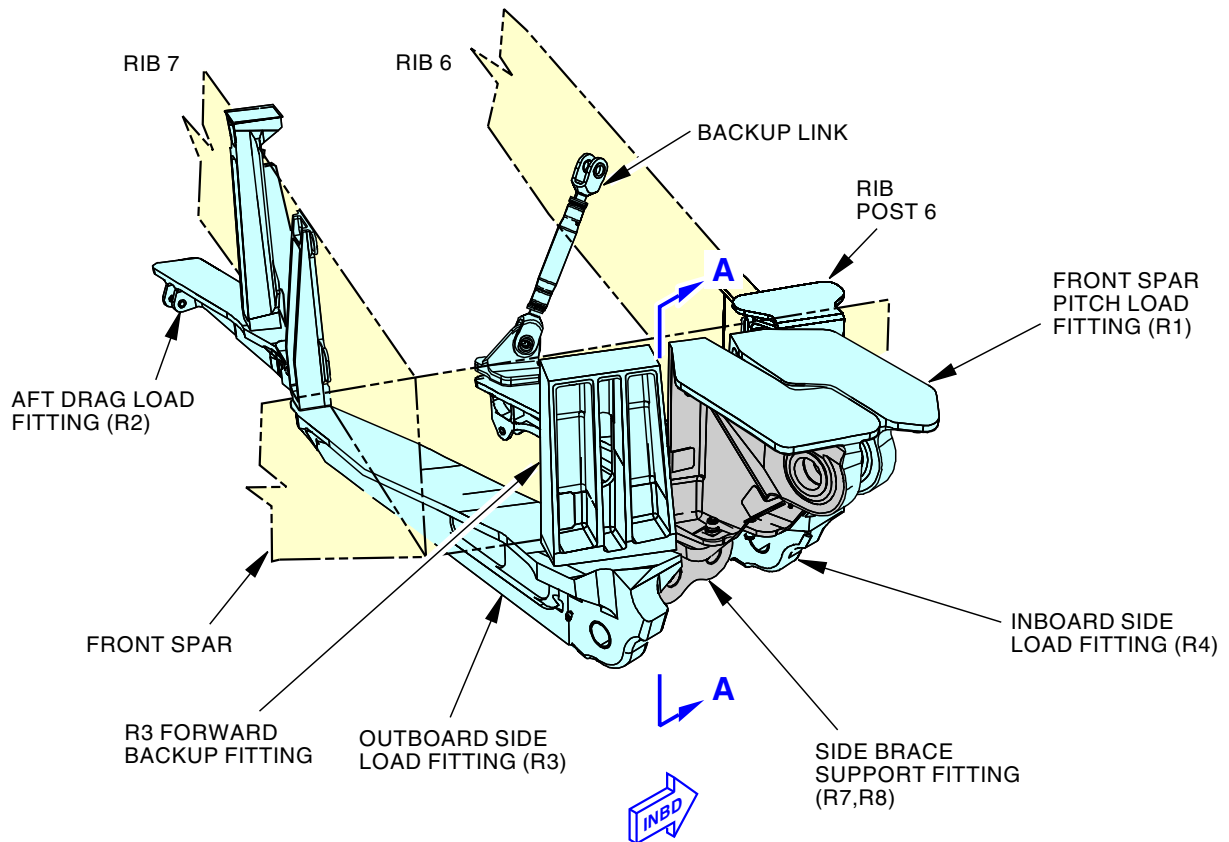
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2416508 S00061540960_V1

Wing - Right Nacelle Support Fittings
Figure 214/57-05-03-990-814

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TASK 57-05-03-210-813

13. **INTERNAL - GENERAL VISUAL: LEFT OUTBOARD WING LOWER SURFACE**

(Figure 215)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-809	737-7/8/8200/9 Basic Task Description (P/B 201)
54-52-06-000-801	Aft Fairing Access Panel Removal (P/B 401)
54-52-06-400-801	Aft Fairing Access Panel Installation (P/B 401)

B. Location Zones

Zone	Area
434	Engine 1 - Aft Strut Fairing
531	Left Wing - Center Fuel Tank, Rib 1 to Rib 5
532	Left Wing - Main Tank, Rib 5 to Rib 22, Wing Station 204.25 to Wing BL 643.50

C. Access Panels

Number	Name/Location
434AL	Aft Strut Fairing, Left Panel, Strut 1
434AR	Aft Strut Fairing, Right Panel, Strut 1

D. Inspection

SUBTASK 57-05-03-010-012

(1) Remove these aft fairing access panels, refer to Aft Fairing Access Panel Removal, TASK 54-52-06-000-801:

(a) Remove these access panels:

Number	Name/Location
434AL	Aft Strut Fairing, Left Panel, Strut 1
434AR	Aft Strut Fairing, Right Panel, Strut 1

SUBTASK 57-05-03-010-013

(2) Do a General Visual inspection of the left wing lower surface under strut fairing, including all attachment locations.

SUBTASK 57-05-03-910-013

(3) Do this task: 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-809..

SUBTASK 57-05-03-410-012

(4) install these aft fairing access panels, refer to Aft Fairing Access Panel Installation, TASK 54-52-06-400-801:

(a) Install these access panels:

Number	Name/Location
434AL	Aft Strut Fairing, Left Panel, Strut 1
434AR	Aft Strut Fairing, Right Panel, Strut 1

— END OF TASK —

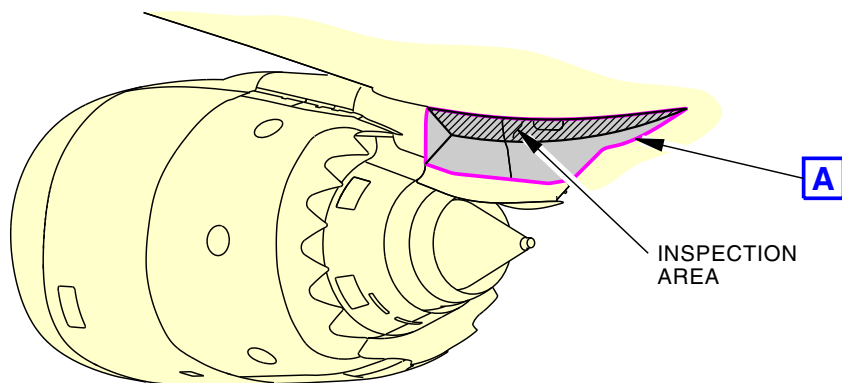
EFFECTIVITY
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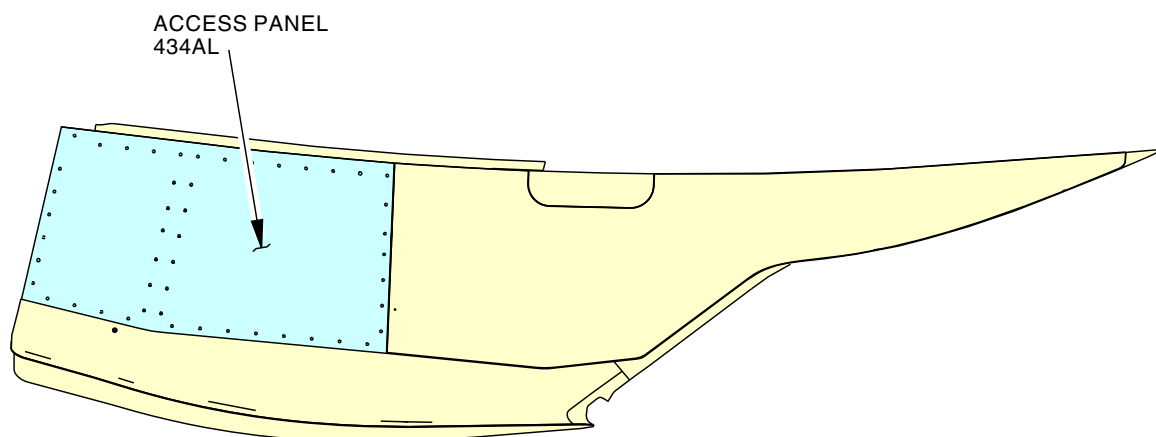
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LEFT STRUT



AFT FAIRING



2416509 S00061540962_V1

Left Aft Fairing Access Panels To Lower Wing Skin
Figure 215/57-05-03-990-815

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TASK 57-05-03-210-814

14. **INTERNAL - GENERAL VISUAL: RIGHT OUTBOARD WING LOWER SURFACE**

(Figure 216)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-809	737-7/8/8200/9 Basic Task Description (P/B 201)
54-52-06-000-801	Aft Fairing Access Panel Removal (P/B 401)
54-52-06-400-801	Aft Fairing Access Panel Installation (P/B 401)

B. Location Zones

Zone	Area
444	Engine 2 - Aft Strut Fairing
631	Right Wing - Center Fuel Tank, Rib 1 to Rib 5
632	Right Wing - Main Tank, Rib 5 to Rib 22, Wing Station 204.25 to Wing Station 643.50

C. Access Panels

Number	Name/Location
444AL	Aft Strut Fairing, Left Panel, Strut 2
444AR	Aft Strut Fairing, Right Panel, Strut 2

D. Inspection

SUBTASK 57-05-03-010-013

- (1) Remove these aft fairing access panels, refer to Aft Fairing Access Panel Removal, TASK 54-52-06-000-801:

- (a) Remove these access panels:

Number	Name/Location
444AL	Aft Strut Fairing, Left Panel, Strut 2
444AR	Aft Strut Fairing, Right Panel, Strut 2

SUBTASK 57-05-03-010-014

- (2) Do a General Visual inspection of the right wing lower surface under strut fairing, including all attachment locations.

SUBTASK 57-05-03-910-014

- (3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-809.

SUBTASK 57-05-03-410-013

- (4) Install these aft fairing access panels, refer to TASK 54-52-06-400-801:

- (a) Install these access panels:

Number	Name/Location
444AL	Aft Strut Fairing, Left Panel, Strut 2
444AR	Aft Strut Fairing, Right Panel, Strut 2

— END OF TASK —

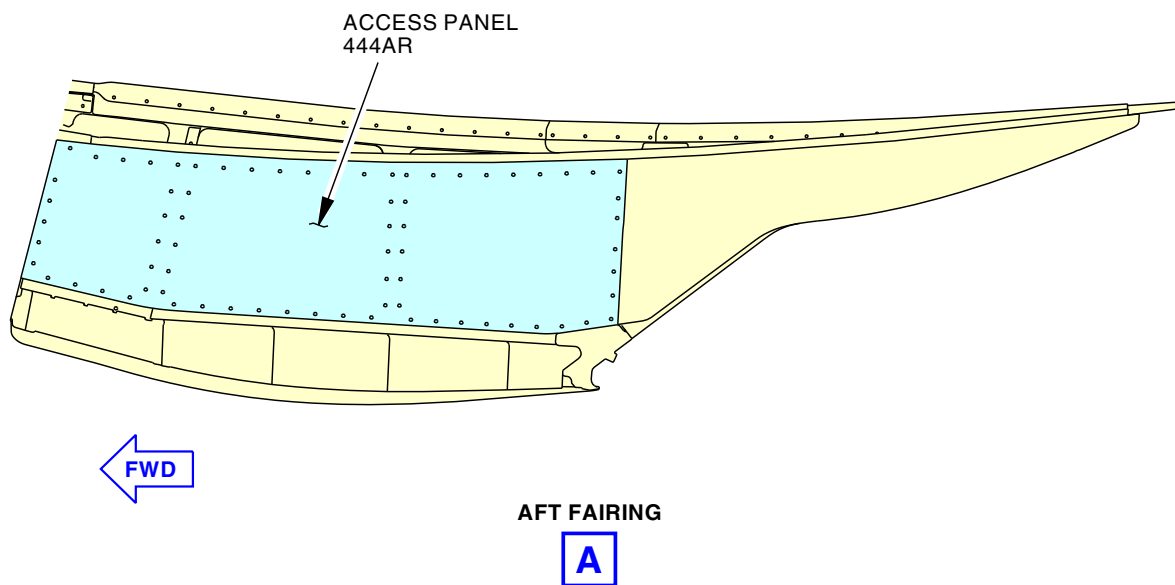
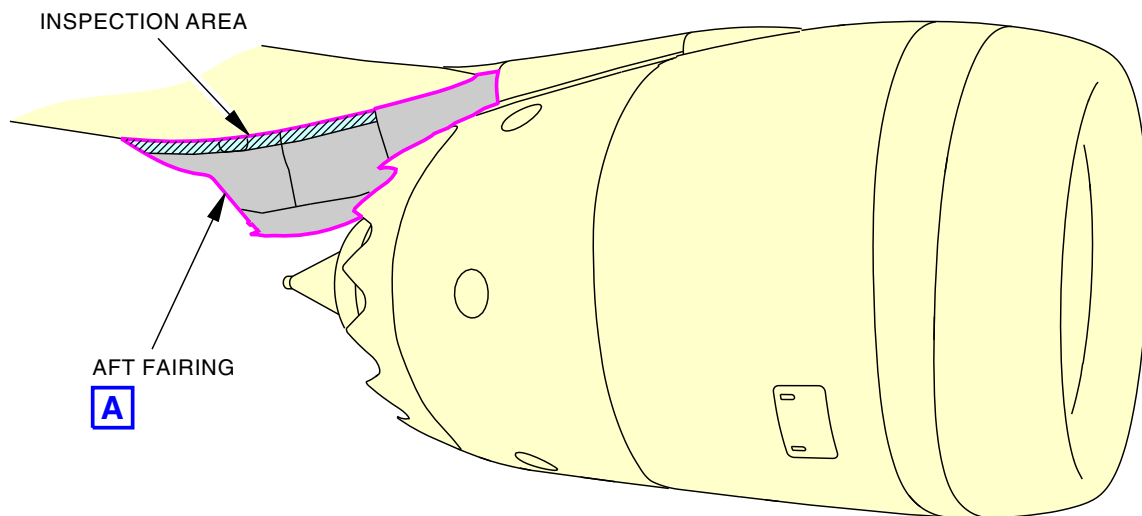
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2416510 S00061540964_V1

Right Aft Fairing Access Panels To Lower Wing Skin
Figure 216/57-05-03-990-816

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TASK 57-05-03-210-815

15. INTERNAL - GENERAL VISUAL: LEFT OUTBOARD WING FRONT SPAR

(Figure 217, Figure 218)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-806	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
511	Left Wing - Leading Edge To Front Spar
521	Left Wing - Leading Edge to Front Spar

C. Access Panels

Number	Name/Location
511AT	Inboard Leading Edge, Strakelet Upper Panel
511BT	Fairing
521AAB	Lower Leading Edge Access Panel - Slat Station 497
521AB	Outboard Leading Edge Blowout Door - Slat Station 20
521ABB	Lower Leading Edge Access Panel-Slat Station 519
521BB	Engine Fuel Valve Shutoff Access Panel - Slat Station 27
521CB	Lower Leading Edge Access Panel - Slat Station 50
521DB	Lower Leading Edge Access Panel - Slat Station 70
521EB	Lower Leading Edge Access Panel - Slat Station 91
521FB	Lower Leading Edge Access Panel - Slat Station 107
521GB	Lower Leading Edge Access Panel - Slat Station 125
521HB	Lower Leading Edge Access Panel - Slat Station 144
521JB	Lower Leading Edge Access Panel - Slat Station 161
521KB	Lower Leading Edge Access Panel - Slat Station 179
521LB	Lower Leading Edge Access Panel - Slat Station 208
521MB	Lower Leading Edge Access Panel - Slat Station 226
521NB	Lower Leading Edge Access Panel - Slat Station 244
521PB	Lower Leading Edge Access Panel - Slat Station 261
521QB	Lower Leading Edge Access Panel - Slat Station 280
521RB	Lower Leading Edge Access Panel - Slat Station 298
521SB	Lower Leading Edge Access Panel - Slat Station 328
521TB	Lower Leading Edge Access Panel - Slat Station 347
521UB	Lower Leading Edge Access Panel - Slat Station 365
521VB	Lower Leading Edge Access Panel - Slat Station 385
521WB	Lower Leading Edge Access Panel - Slat Station 406
521XB	Lower Leading Edge Access Panel - Slat Station 425
521YB	Lower Leading Edge Access Panel - Slat Station 470
521ZB	Lower Leading Edge Access Panel - Slat Station 479

EFFECTIVITY
SIA ALL

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D. Inspection

SUBTASK 57-05-03-010-014

- (1) Open these access panels:

<u>Number</u>	<u>Name/Location</u>
511AT	Inboard Leading Edge, Strakelet Upper Panel
511BT	Fairing
521AAB	Lower Leading Edge Access Panel - Slat Station 497
521AB	Outboard Leading Edge Blowout Door - Slat Station 20
521ABB	Lower Leading Edge Access Panel-Slat Station 519
521BB	Engine Fuel Valve Shutoff Access Panel - Slat Station 27
521CB	Lower Leading Edge Access Panel - Slat Station 50
521DB	Lower Leading Edge Access Panel - Slat Station 70
521EB	Lower Leading Edge Access Panel - Slat Station 91
521FB	Lower Leading Edge Access Panel - Slat Station 107
521GB	Lower Leading Edge Access Panel - Slat Station 125
521HB	Lower Leading Edge Access Panel - Slat Station 144
521JB	Lower Leading Edge Access Panel - Slat Station 161
521KB	Lower Leading Edge Access Panel - Slat Station 179
521LB	Lower Leading Edge Access Panel - Slat Station 208
521MB	Lower Leading Edge Access Panel - Slat Station 226
521NB	Lower Leading Edge Access Panel - Slat Station 244
521PB	Lower Leading Edge Access Panel - Slat Station 261
521QB	Lower Leading Edge Access Panel - Slat Station 280
521RB	Lower Leading Edge Access Panel - Slat Station 298
521SB	Lower Leading Edge Access Panel - Slat Station 328
521TB	Lower Leading Edge Access Panel - Slat Station 347
521UB	Lower Leading Edge Access Panel - Slat Station 365
521VB	Lower Leading Edge Access Panel - Slat Station 385
521WB	Lower Leading Edge Access Panel - Slat Station 406
521XB	Lower Leading Edge Access Panel - Slat Station 425
521YB	Lower Leading Edge Access Panel - Slat Station 470
521ZB	Lower Leading Edge Access Panel - Slat Station 479

NOTE: Deploy the Krueger flaps.

SUBTASK 57-05-03-210-015

- (2) Do a General Visual inspection of the left front spar chords, webs and stiffeners, including at side of body joint and at nacelle fitting attachment.

SUBTASK 57-05-03-910-015

- (3) Do this task: 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 57-05-03-410-014

- (4) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
511AT	Inboard Leading Edge, Strakelet Upper Panel
511BT	Fairing
521AAB	Lower Leading Edge Access Panel - Slat Station 497
521AB	Outboard Leading Edge Blowout Door - Slat Station 20
521ABB	Lower Leading Edge Access Panel-Slat Station 519

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(Continued)

<u>Number</u>	<u>Name/Location</u>
521BB	Engine Fuel Valve Shutoff Access Panel - Slat Station 27
521CB	Lower Leading Edge Access Panel - Slat Station 50
521DB	Lower Leading Edge Access Panel - Slat Station 70
521EB	Lower Leading Edge Access Panel - Slat Station 91
521FB	Lower Leading Edge Access Panel - Slat Station 107
521GB	Lower Leading Edge Access Panel - Slat Station 125
521HB	Lower Leading Edge Access Panel - Slat Station 144
521JB	Lower Leading Edge Access Panel - Slat Station 161
521KB	Lower Leading Edge Access Panel - Slat Station 179
521LB	Lower Leading Edge Access Panel - Slat Station 208
521MB	Lower Leading Edge Access Panel - Slat Station 226
521NB	Lower Leading Edge Access Panel - Slat Station 244
521PB	Lower Leading Edge Access Panel - Slat Station 261
521QB	Lower Leading Edge Access Panel - Slat Station 280
521RB	Lower Leading Edge Access Panel - Slat Station 298
521SB	Lower Leading Edge Access Panel - Slat Station 328
521TB	Lower Leading Edge Access Panel - Slat Station 347
521UB	Lower Leading Edge Access Panel - Slat Station 365
521VB	Lower Leading Edge Access Panel - Slat Station 385
521WB	Lower Leading Edge Access Panel - Slat Station 406
521XB	Lower Leading Edge Access Panel - Slat Station 425
521YB	Lower Leading Edge Access Panel - Slat Station 470
521ZB	Lower Leading Edge Access Panel - Slat Station 479

———— **END OF TASK** ————

EFFECTIVITY
SIA ALL

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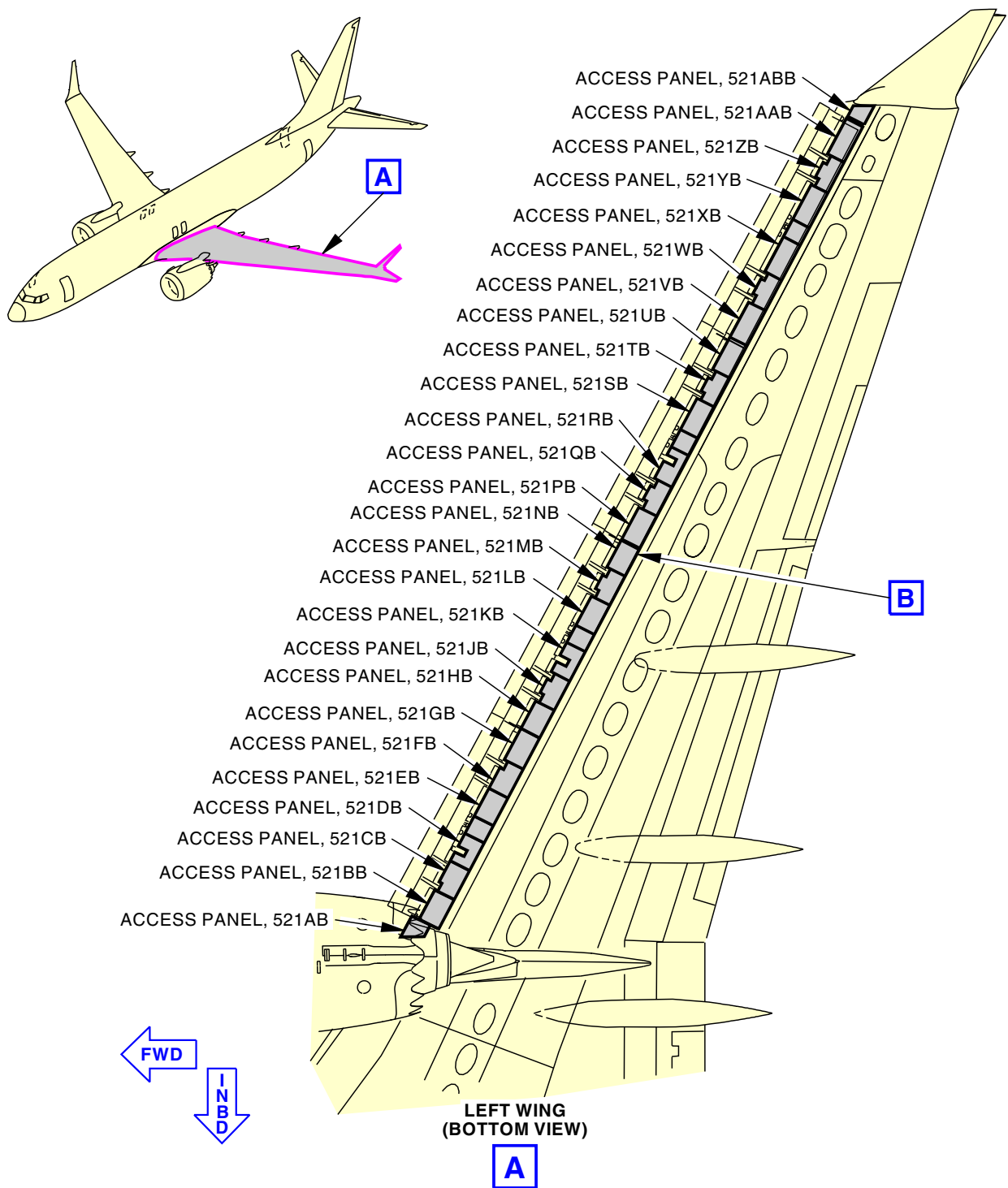
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AIRCRAFT MAINTENANCE MANUAL



2410223 S00061525135_V3

Leading Edge to Front Spar (Outboard of Nacelle Strut) Left Wing - General Visual (Internal)
Figure 217/57-05-03-990-817 (Sheet 1 of 2)

EFFECTIVITY
SIA ALL

D633AM101-SIA

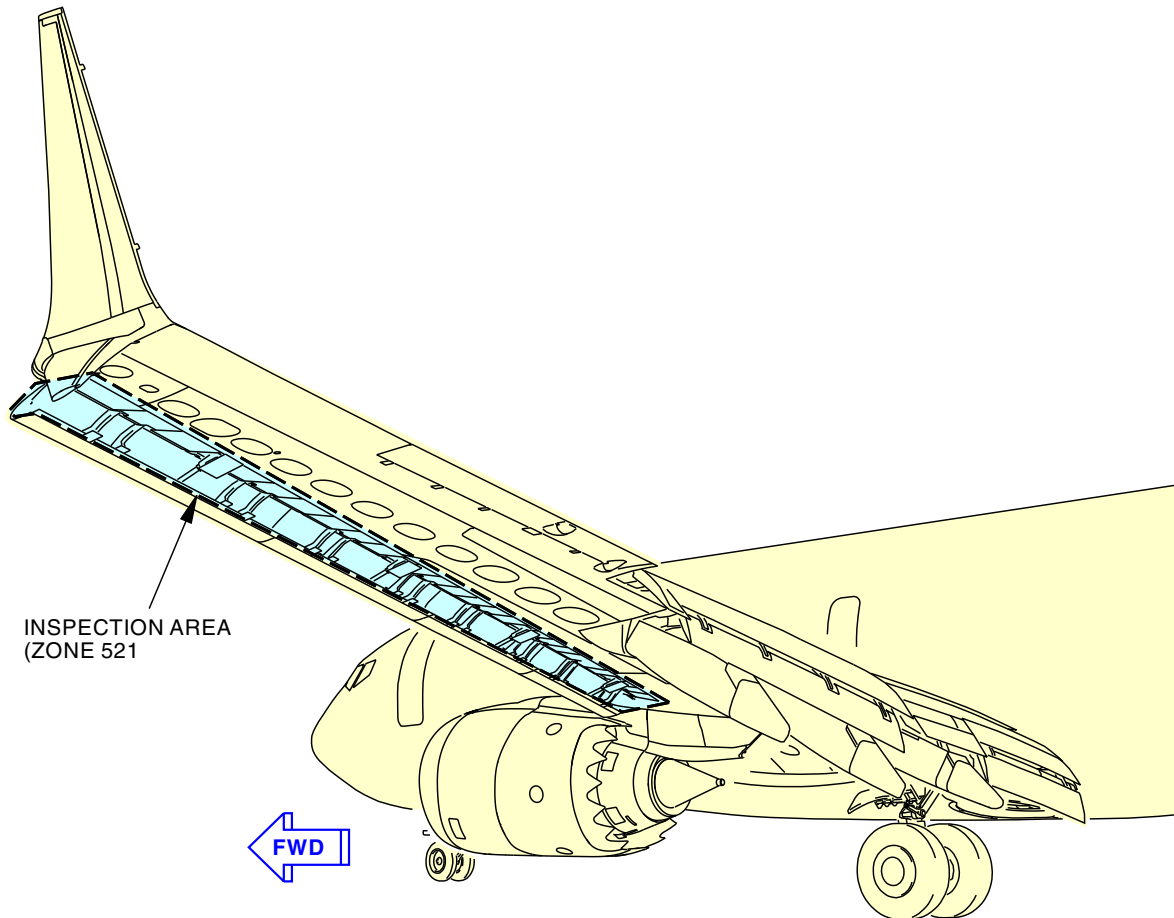
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AIRCRAFT MAINTENANCE MANUAL



(BOTTOM VIEW)

B

2410224 S00061525136_V1

Leading Edge to Front Spar (Outboard of Nacelle Strut) Left Wing - General Visual (Internal)
Figure 217/57-05-03-990-817 (Sheet 2 of 2)

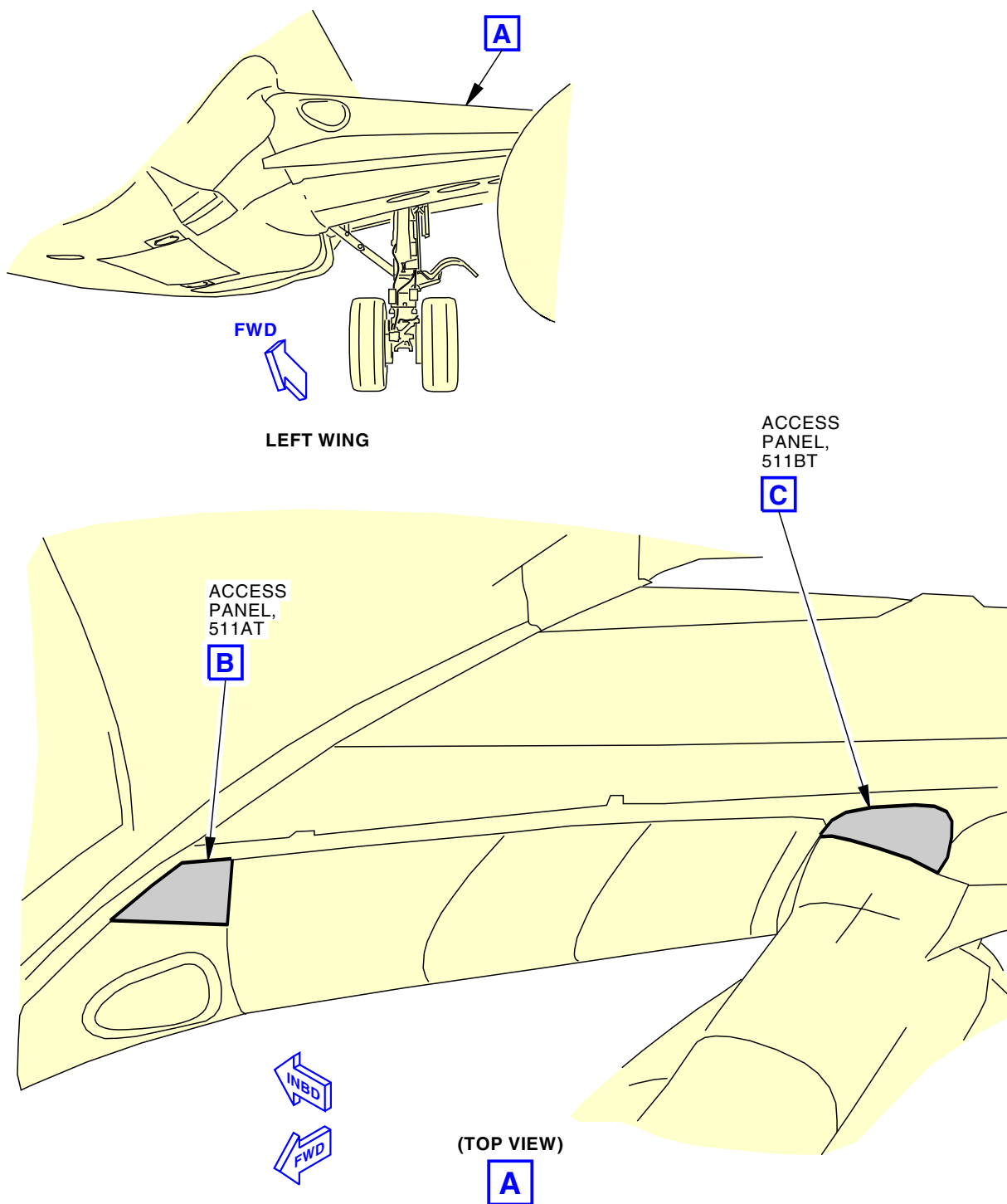
EFFECTIVITY
SIA ALL

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2410217 S00061525125_V1

Leading Edge to Front Spar (Inboard of Nacelle Strut) Left Wing - General Visual (Internal)
Figure 218/57-05-03-990-818 (Sheet 1 of 2)

EFFECTIVITY
SIA ALL

D633AM101-SIA

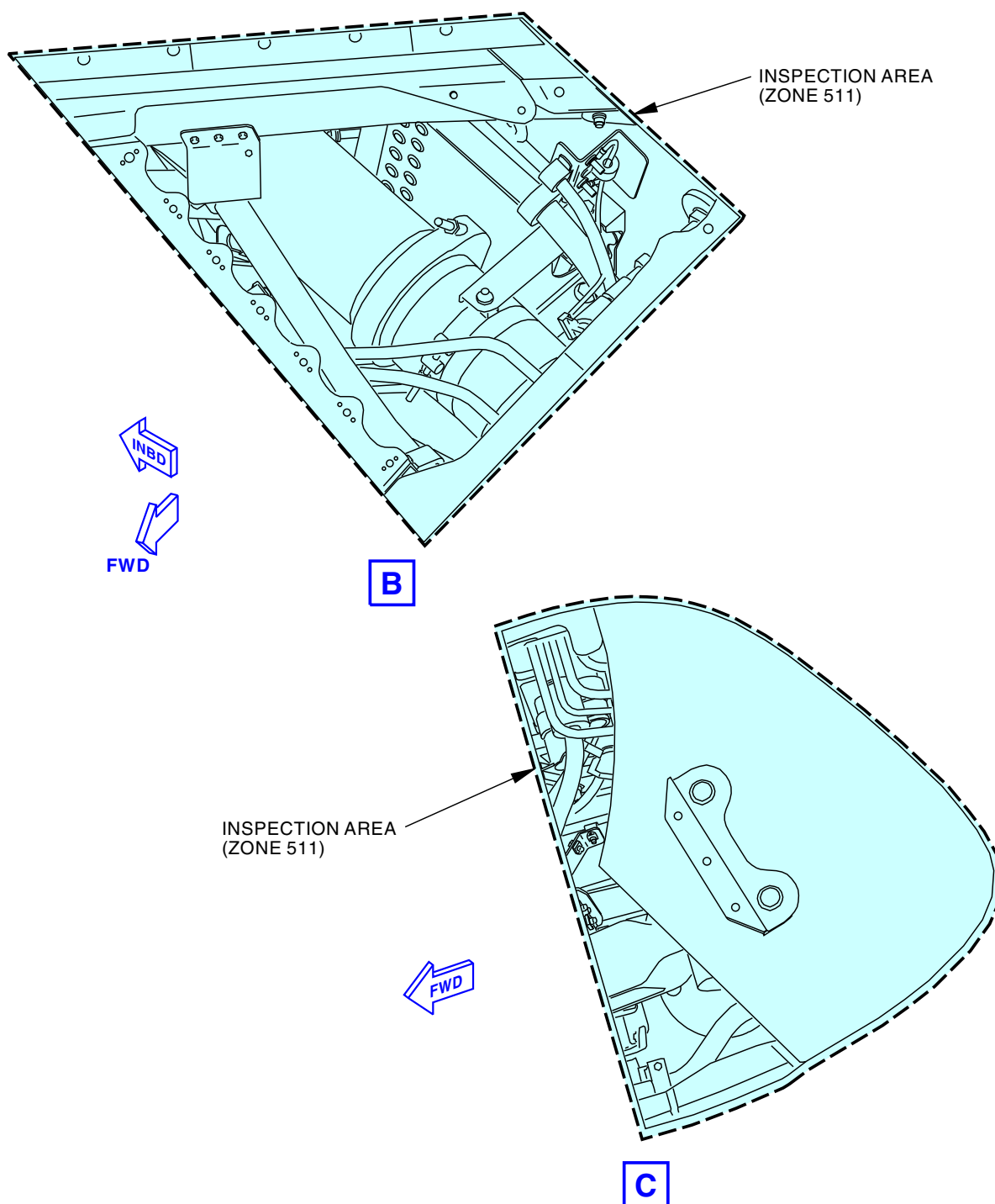
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2410218 S00061525126_V1

Leading Edge to Front Spar (Inboard of Nacelle Strut) Left Wing - General Visual (Internal)
Figure 218/57-05-03-990-818 (Sheet 2 of 2)

EFFECTIVITY
SIA ALL

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TASK 57-05-03-210-816

16. INTERNAL - GENERAL VISUAL: RIGHT OUTBOARD WING FRONT SPAR

(Figure 219, Figure 220)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-806	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
611	Right Wing - Leading Edge to Front Spar
621	Right Wing - Leading Edge to Front Spar

C. Access Panels

Number	Name/Location
611AT	Inboard Leading Edge, Strakelet Upper Access Panel
611BT	Fairing
621AAB	Lower Leading Edge Access Panel - Slat Station 524.31
621AB	Outboard Leading Edge Blowout Door - Slat Station 20
621ABB	Lower Leading Edge Access Panel-Slat Station 519
621BB	Engine Fuel Valve Shutoff Access Panel - Slat Station 27
621CB	Lower Leading Edge Access Panel - Slat Station 50
621DB	Lower Leading Edge Access Panel - Slat Station 70
621EB	Lower Leading Edge Access Panel - Slat Station 91
621FB	Lower Leading Edge Access Panel - Slat Station 107
621GB	Refuel Valve Door - Slat Station 125
621JB	Lower Leading Edge Access Panel - Slat Station 161
621KB	Lower Leading Edge Access Panel - Slat Station 179
621LB	Lower Leading Edge Access Panel - Slat Station 208
621MB	Lower Leading Edge Access Panel - Slat Station 226
621NB	Lower Leading Edge Access Panel - Slat Station 244
621PB	Lower Leading Edge Access Panel - Slat Station 261
621QB	Lower Leading Edge Access Panel - Slat Station 280
621RB	Lower Leading Edge Access Panel - Slat Station 298
621SB	Lower Leading Edge Access Panel - Slat Station 328
621TB	Lower Leading Edge Access Panel - Slat Station 347
621UB	Lower Leading Edge Access Panel - Slat Station 365
621VB	Lower Leading Edge Access Panel - Slat Station 385
621WB	Lower Leading Edge Access Panel - Slat Station 406
621XB	Lower Leading Edge Access Panel - Slat Station 425
621YB	Lower Leading Edge Access Panel - Slat Station 470
621ZB	Lower Leading Edge Access Panel - Slat Station 479

EFFECTIVITY
SIA ALL

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D. Inspection

SUBTASK 57-05-03-010-015

- (1) Open these access panels:

<u>Number</u>	<u>Name/Location</u>
611AT	Inboard Leading Edge, Strakelet Upper Access Panel
611BT	Fairing
621AAB	Lower Leading Edge Access Panel - Slat Station 524.31
621AB	Outboard Leading Edge Blowout Door - Slat Station 20
621ABB	Lower Leading Edge Access Panel-Slat Station 519
621BB	Engine Fuel Valve Shutoff Access Panel - Slat Station 27
621CB	Lower Leading Edge Access Panel - Slat Station 50
621DB	Lower Leading Edge Access Panel - Slat Station 70
621EB	Lower Leading Edge Access Panel - Slat Station 91
621FB	Lower Leading Edge Access Panel - Slat Station 107
621GB	Refuel Valve Door - Slat Station 125
621JB	Lower Leading Edge Access Panel - Slat Station 161
621KB	Lower Leading Edge Access Panel - Slat Station 179
621LB	Lower Leading Edge Access Panel - Slat Station 208
621MB	Lower Leading Edge Access Panel - Slat Station 226
621NB	Lower Leading Edge Access Panel - Slat Station 244
621PB	Lower Leading Edge Access Panel - Slat Station 261
621QB	Lower Leading Edge Access Panel - Slat Station 280
621RB	Lower Leading Edge Access Panel - Slat Station 298
621SB	Lower Leading Edge Access Panel - Slat Station 328
621TB	Lower Leading Edge Access Panel - Slat Station 347
621UB	Lower Leading Edge Access Panel - Slat Station 365
621VB	Lower Leading Edge Access Panel - Slat Station 385
621WB	Lower Leading Edge Access Panel - Slat Station 406
621XB	Lower Leading Edge Access Panel - Slat Station 425
621YB	Lower Leading Edge Access Panel - Slat Station 470
621ZB	Lower Leading Edge Access Panel - Slat Station 479

NOTE: Deploy the Krueger flaps.

SUBTASK 57-05-03-210-016

- (2) Do a General Visual inspection of the right front spar chords, webs and stiffeners, including at side of body joint and at nacelle fitting attachment.

SUBTASK 57-05-03-910-016

- (3) Do this task: 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 57-05-03-410-015

- (4) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
611AT	Inboard Leading Edge, Strakelet Upper Access Panel
611BT	Fairing
621AAB	Lower Leading Edge Access Panel - Slat Station 524.31
621AB	Outboard Leading Edge Blowout Door - Slat Station 20
621ABB	Lower Leading Edge Access Panel-Slat Station 519
621BB	Engine Fuel Valve Shutoff Access Panel - Slat Station 27

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL

(Continued)

<u>Number</u>	<u>Name/Location</u>
621CB	Lower Leading Edge Access Panel - Slat Station 50
621DB	Lower Leading Edge Access Panel - Slat Station 70
621EB	Lower Leading Edge Access Panel - Slat Station 91
621FB	Lower Leading Edge Access Panel - Slat Station 107
621GB	Refuel Valve Door - Slat Station 125
621JB	Lower Leading Edge Access Panel - Slat Station 161
621KB	Lower Leading Edge Access Panel - Slat Station 179
621LB	Lower Leading Edge Access Panel - Slat Station 208
621MB	Lower Leading Edge Access Panel - Slat Station 226
621NB	Lower Leading Edge Access Panel - Slat Station 244
621PB	Lower Leading Edge Access Panel - Slat Station 261
621QB	Lower Leading Edge Access Panel - Slat Station 280
621RB	Lower Leading Edge Access Panel - Slat Station 298
621SB	Lower Leading Edge Access Panel - Slat Station 328
621TB	Lower Leading Edge Access Panel - Slat Station 347
621UB	Lower Leading Edge Access Panel - Slat Station 365
621VB	Lower Leading Edge Access Panel - Slat Station 385
621WB	Lower Leading Edge Access Panel - Slat Station 406
621XB	Lower Leading Edge Access Panel - Slat Station 425
621YB	Lower Leading Edge Access Panel - Slat Station 470
621ZB	Lower Leading Edge Access Panel - Slat Station 479

———— **END OF TASK** ————

EFFECTIVITY
SIA ALL

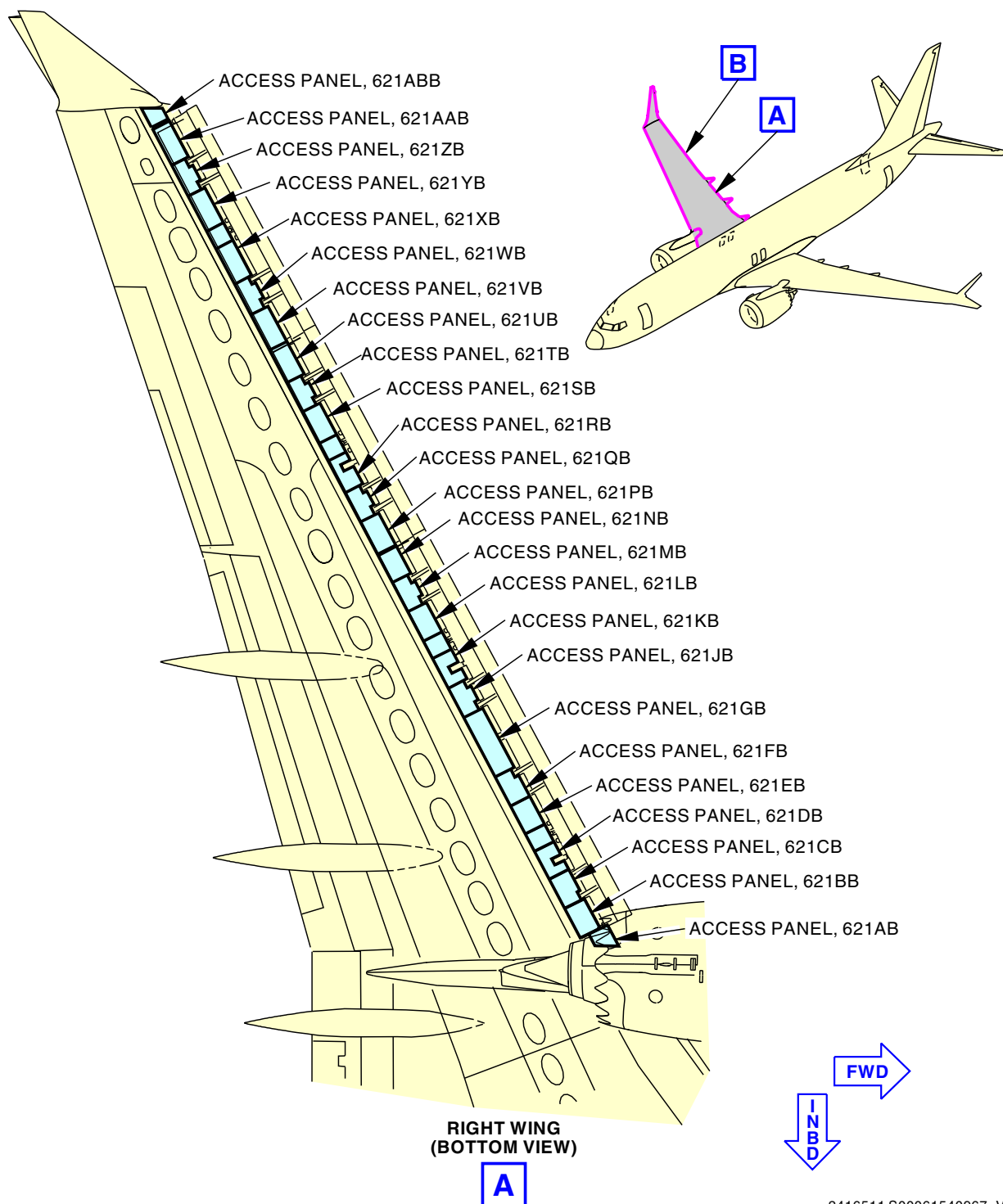
D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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2416511 S00061540967_V4

Leading Edge to Front Spar (Outboard of Nacelle Strut) Right Wing - General Visual (Internal)
Figure 219/57-05-03-990-819 (Sheet 1 of 2)

EFFECTIVITY
SIA ALL

D633AM101-SIA

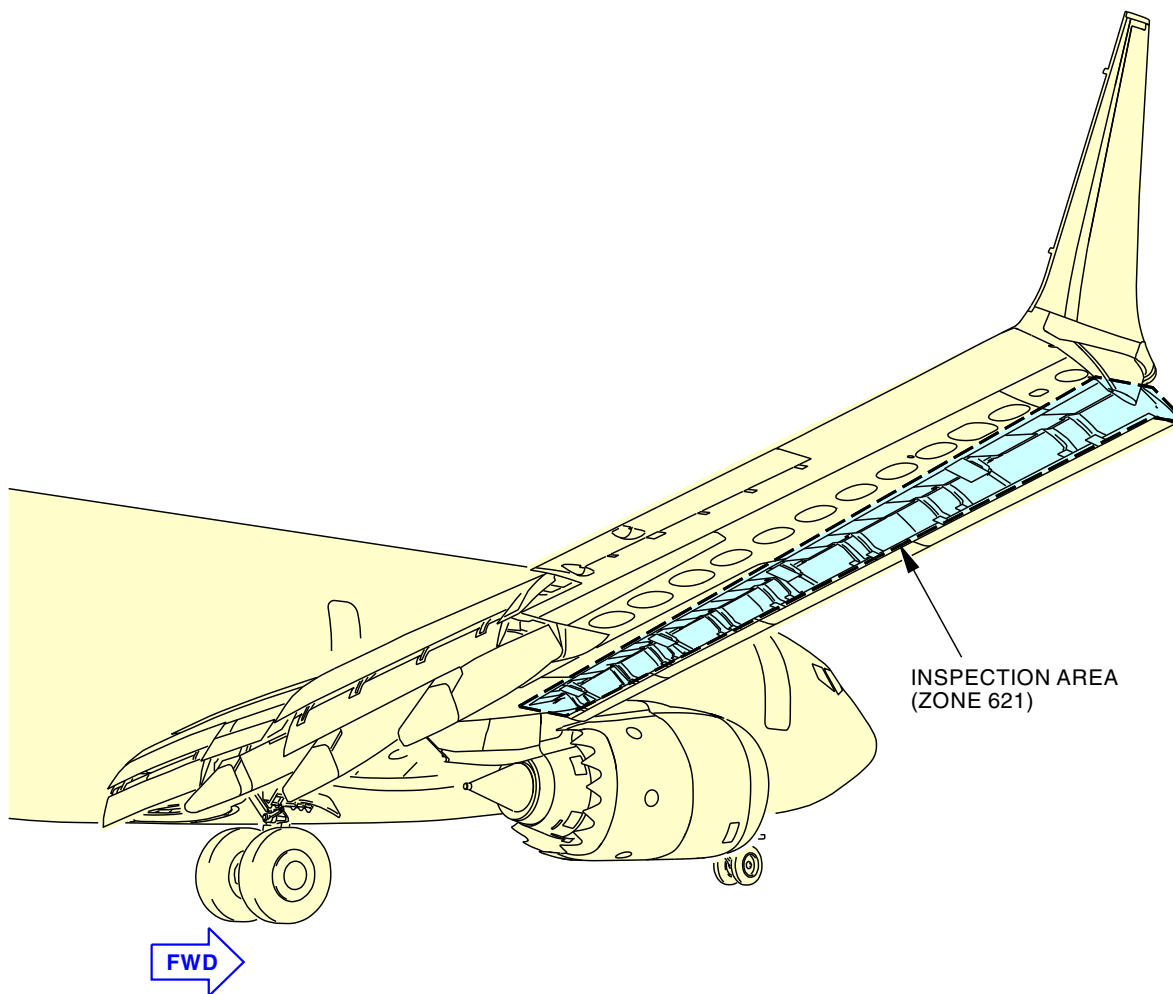
ECCN 9E991 BOEING PROPRIETARY - See title page for details

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737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL



2410267 S00061525217_V1

Leading Edge to Front Spar (Outboard of Nacelle Strut) Right Wing - General Visual (Internal)
Figure 219/57-05-03-990-819 (Sheet 2 of 2)

EFFECTIVITY
SIA ALL

D633AM101-SIA

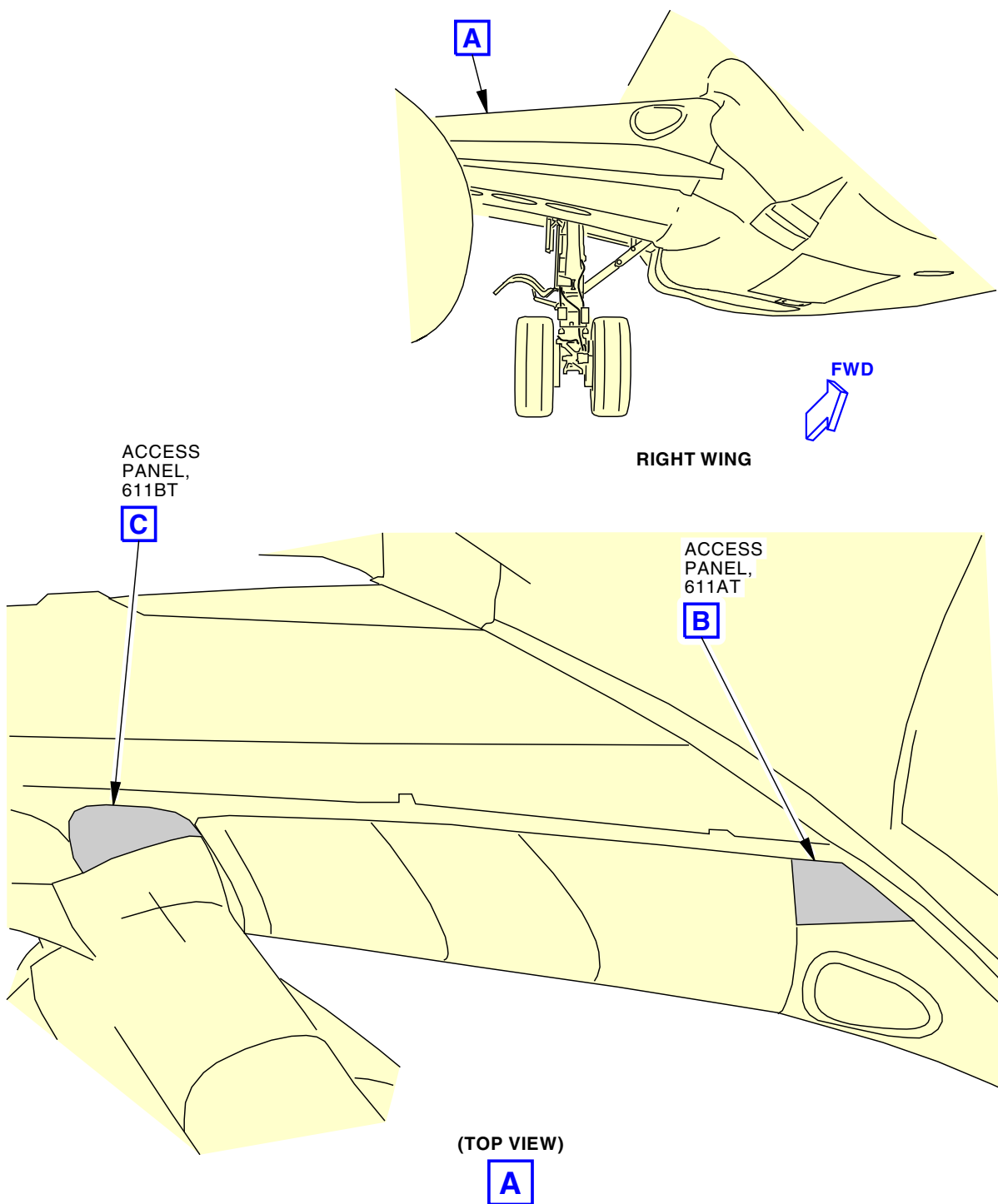
ECCN 9E991 BOEING PROPRIETARY - See title page for details

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737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL



2410260 S00061525206_V2

Leading Edge to Front Spar (Inboard of Nacelle Strut) Right Wing - General Visual (Internal)
Figure 220/57-05-03-990-820 (Sheet 1 of 2)

EFFECTIVITY	
SIA ALL	

D633AM101-SIA

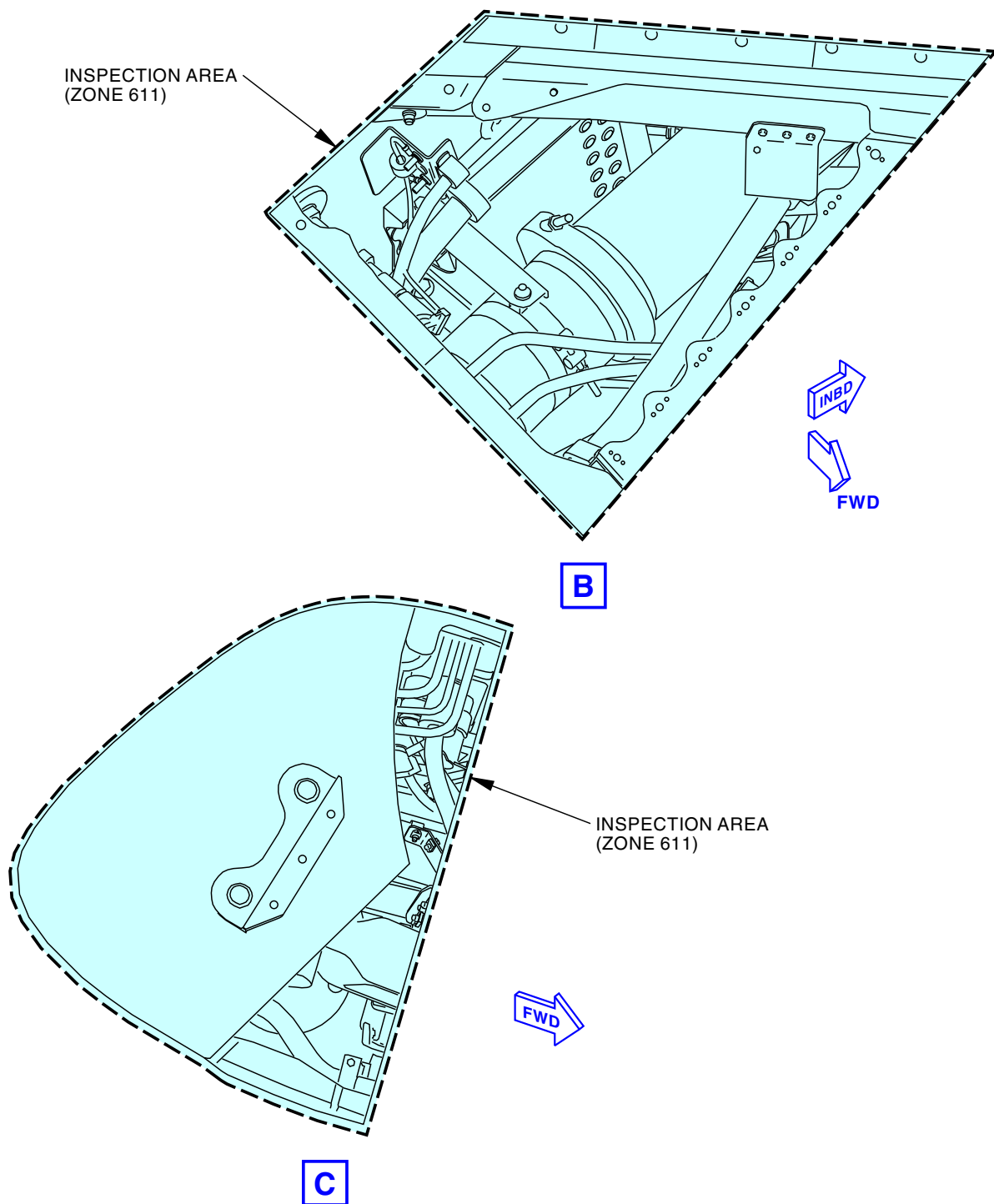
ECCN 9E991 BOEING PROPRIETARY - See title page for details

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737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL



2410261 S00061525207_V1

Leading Edge to Front Spar (Inboard of Nacelle Strut) Right Wing - General Visual (Internal)
Figure 220/57-05-03-990-820 (Sheet 2 of 2)

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL

TASK 57-05-03-210-817

17. INTERNAL - GENERAL VISUAL: LEFT OUTBOARD WING LEADING EDGE STRUCTURE

(Figure 221)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-806	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
511	Left Wing - Leading Edge To Front Spar
512	Left Wing - Krueger Flap No. 2
513	Left Wing - Krueger Flap No. 1
521	Left Wing - Leading Edge to Front Spar
522	Left Wing - Slat No. 4
523	Left Wing - Slat No. 3
524	Left Wing - Slat No. 2
525	Left Wing - Slat No. 1

C. Access Panels

Number	Name/Location
521AAB	Lower Leading Edge Access Panel - Slat Station 497
521AB	Outboard Leading Edge Blowout Door - Slat Station 20
521ABB	Lower Leading Edge Access Panel-Slat Station 519
521BB	Engine Fuel Valve Shutoff Access Panel - Slat Station 27
521CB	Lower Leading Edge Access Panel - Slat Station 50
521DB	Lower Leading Edge Access Panel - Slat Station 70
521EB	Lower Leading Edge Access Panel - Slat Station 91
521FB	Lower Leading Edge Access Panel - Slat Station 107
521GB	Lower Leading Edge Access Panel - Slat Station 125
521HB	Lower Leading Edge Access Panel - Slat Station 144
521JB	Lower Leading Edge Access Panel - Slat Station 161
521KB	Lower Leading Edge Access Panel - Slat Station 179
521LB	Lower Leading Edge Access Panel - Slat Station 208
521MB	Lower Leading Edge Access Panel - Slat Station 226
521NB	Lower Leading Edge Access Panel - Slat Station 244
521PB	Lower Leading Edge Access Panel - Slat Station 261
521QB	Lower Leading Edge Access Panel - Slat Station 280
521RB	Lower Leading Edge Access Panel - Slat Station 298
521SB	Lower Leading Edge Access Panel - Slat Station 328
521TB	Lower Leading Edge Access Panel - Slat Station 347
521UB	Lower Leading Edge Access Panel - Slat Station 365
521VB	Lower Leading Edge Access Panel - Slat Station 385
521WB	Lower Leading Edge Access Panel - Slat Station 406
521XB	Lower Leading Edge Access Panel - Slat Station 425
521YB	Lower Leading Edge Access Panel - Slat Station 470

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL

(Continued)

Number	Name/Location

521ZB	Lower Leading Edge Access Panel - Slat Station 479

D. Inspection

SUBTASK 57-05-03-010-016

(1) Open these access panels:

Number	Name/Location
521AAB	Lower Leading Edge Access Panel - Slat Station 497
521AB	Outboard Leading Edge Blowout Door - Slat Station 20
521ABB	Lower Leading Edge Access Panel-Slat Station 519
521BB	Engine Fuel Valve Shutoff Access Panel - Slat Station 27
521CB	Lower Leading Edge Access Panel - Slat Station 50
521DB	Lower Leading Edge Access Panel - Slat Station 70
521EB	Lower Leading Edge Access Panel - Slat Station 91
521FB	Lower Leading Edge Access Panel - Slat Station 107
521GB	Lower Leading Edge Access Panel - Slat Station 125
521HB	Lower Leading Edge Access Panel - Slat Station 144
521JB	Lower Leading Edge Access Panel - Slat Station 161
521KB	Lower Leading Edge Access Panel - Slat Station 179
521LB	Lower Leading Edge Access Panel - Slat Station 208
521MB	Lower Leading Edge Access Panel - Slat Station 226
521NB	Lower Leading Edge Access Panel - Slat Station 244
521PB	Lower Leading Edge Access Panel - Slat Station 261
521QB	Lower Leading Edge Access Panel - Slat Station 280
521RB	Lower Leading Edge Access Panel - Slat Station 298
521SB	Lower Leading Edge Access Panel - Slat Station 328
521TB	Lower Leading Edge Access Panel - Slat Station 347
521UB	Lower Leading Edge Access Panel - Slat Station 365
521VB	Lower Leading Edge Access Panel - Slat Station 385
521WB	Lower Leading Edge Access Panel - Slat Station 406
521XB	Lower Leading Edge Access Panel - Slat Station 425
521YB	Lower Leading Edge Access Panel - Slat Station 470
521ZB	Lower Leading Edge Access Panel - Slat Station 479

NOTE: Extend Krueger flaps and slats.

SUBTASK 57-05-03-210-017

(2) Do a General Visual inspection of the left wing leading edge cavity, including flaps and slats.

SUBTASK 57-05-03-910-017

(3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 57-05-03-410-016

(4) Close these access panels:

Number	Name/Location
521AAB	Lower Leading Edge Access Panel - Slat Station 497
521AB	Outboard Leading Edge Blowout Door - Slat Station 20
521ABB	Lower Leading Edge Access Panel-Slat Station 519
521BB	Engine Fuel Valve Shutoff Access Panel - Slat Station 27
521CB	Lower Leading Edge Access Panel - Slat Station 50

EFFECTIVITY
SIA ALL

D633AM101-SIA

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737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL

(Continued)

<u>Number</u>	<u>Name/Location</u>
521DB	Lower Leading Edge Access Panel - Slat Station 70
521EB	Lower Leading Edge Access Panel - Slat Station 91
521FB	Lower Leading Edge Access Panel - Slat Station 107
521GB	Lower Leading Edge Access Panel - Slat Station 125
521HB	Lower Leading Edge Access Panel - Slat Station 144
521JB	Lower Leading Edge Access Panel - Slat Station 161
521KB	Lower Leading Edge Access Panel - Slat Station 179
521LB	Lower Leading Edge Access Panel - Slat Station 208
521MB	Lower Leading Edge Access Panel - Slat Station 226
521NB	Lower Leading Edge Access Panel - Slat Station 244
521PB	Lower Leading Edge Access Panel - Slat Station 261
521QB	Lower Leading Edge Access Panel - Slat Station 280
521RB	Lower Leading Edge Access Panel - Slat Station 298
521SB	Lower Leading Edge Access Panel - Slat Station 328
521TB	Lower Leading Edge Access Panel - Slat Station 347
521UB	Lower Leading Edge Access Panel - Slat Station 365
521VB	Lower Leading Edge Access Panel - Slat Station 385
521WB	Lower Leading Edge Access Panel - Slat Station 406
521XB	Lower Leading Edge Access Panel - Slat Station 425
521YB	Lower Leading Edge Access Panel - Slat Station 470
521ZB	Lower Leading Edge Access Panel - Slat Station 479

———— **END OF TASK** ————

EFFECTIVITY
SIA ALL

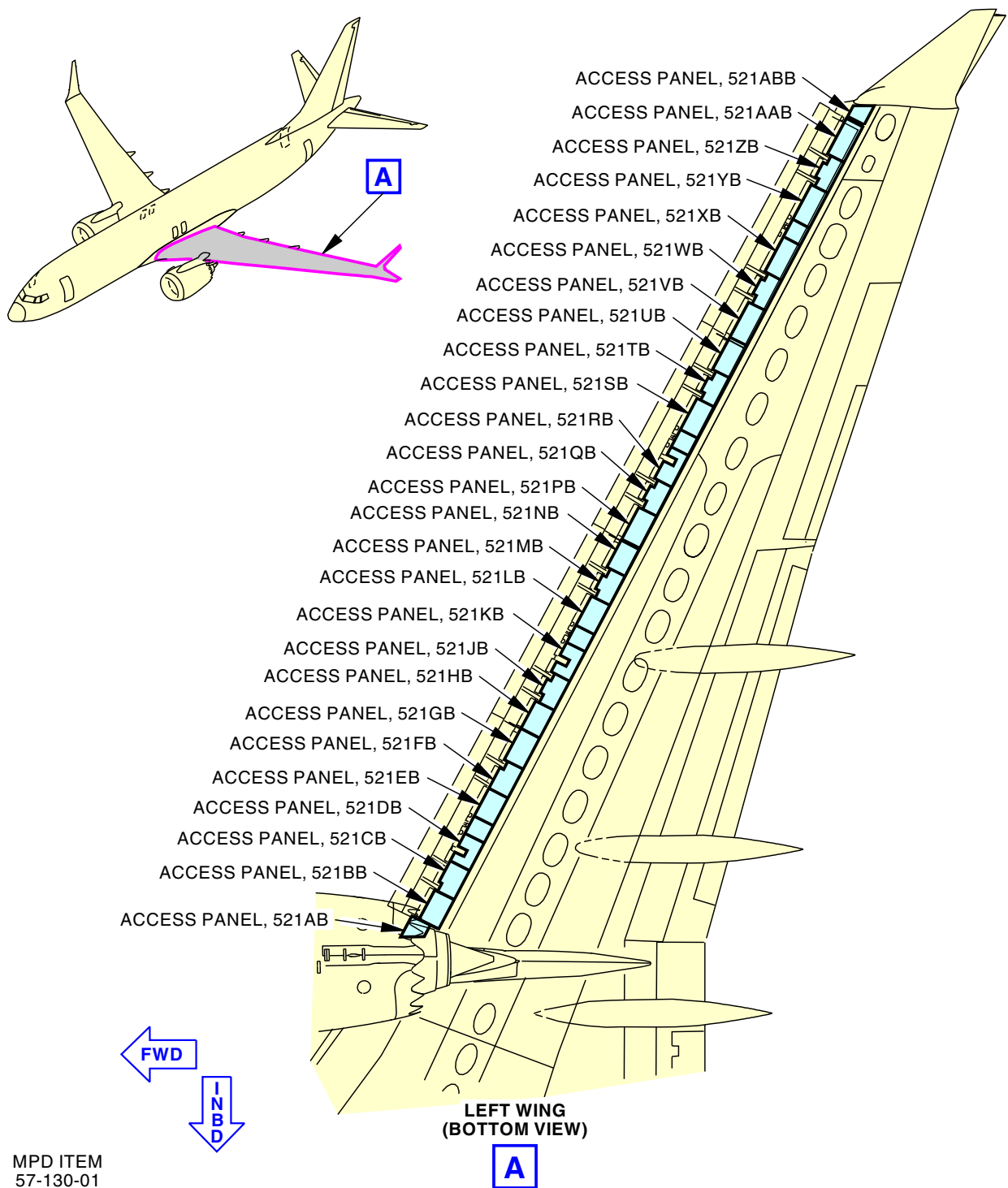
D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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**737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL**



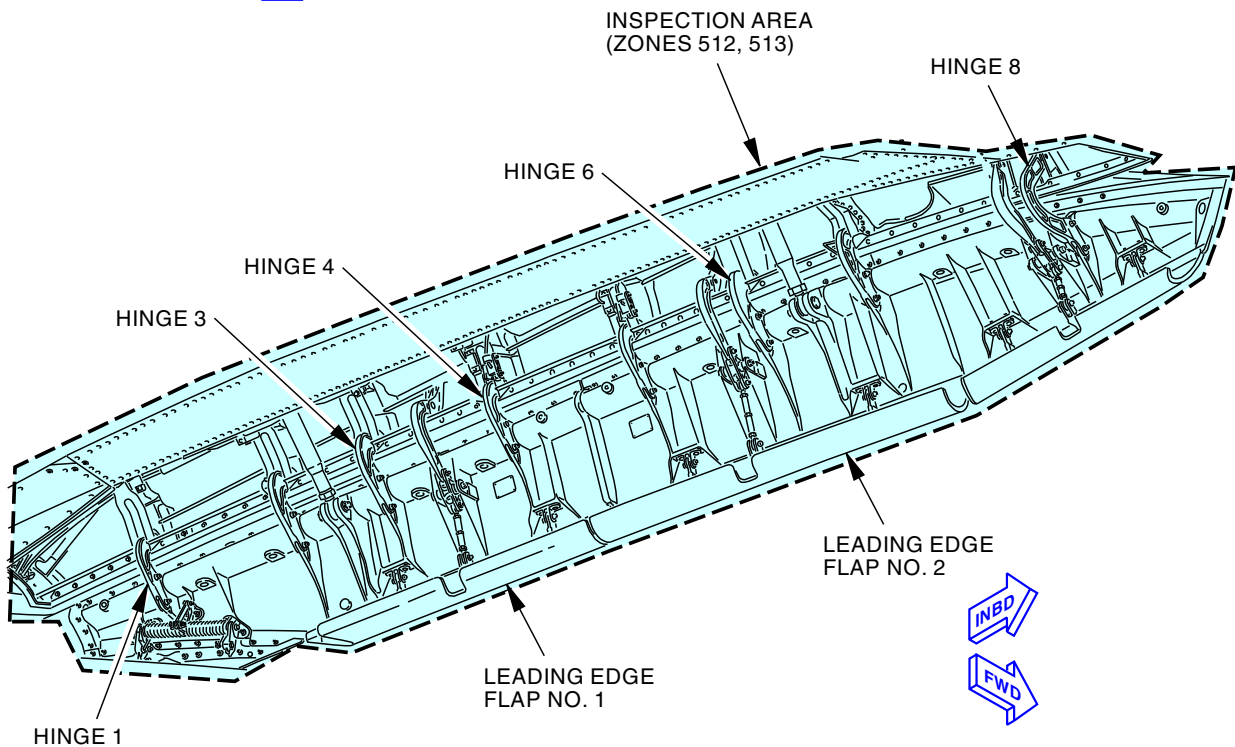
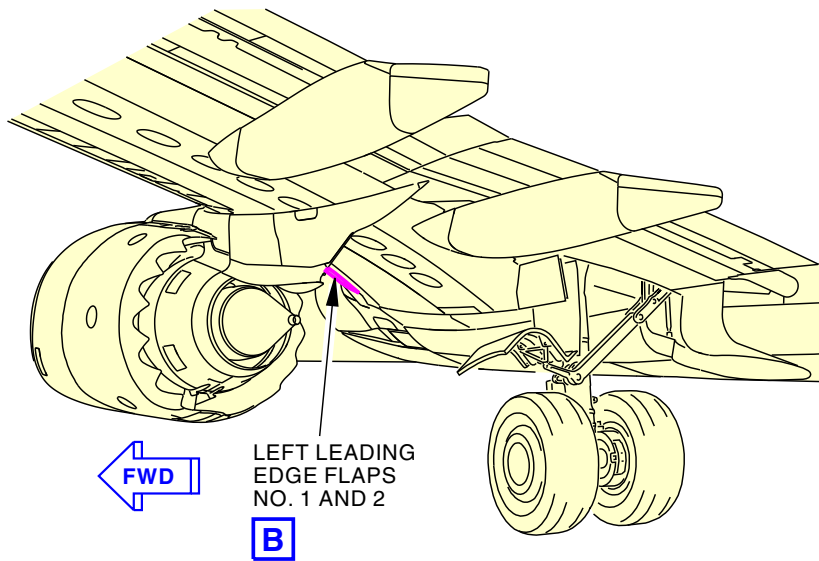
INTERNAL-GENERAL VISUAL: INTERNAL-LEFT OUTBOARD WING LEADING EDGE STRUCTURE
Figure 221/57-05-03-990-821 (Sheet 1 of 4)

EFFECTIVITY
SIA ALL

D633AM101-SIA

57-05-03

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MPD ITEM
57-130-01

2416513 S00061540970_V1

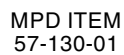
INTERNAL-GENERAL VISUAL: INTERNAL-LEFT OUTBOARD WING LEADING EDGE STRUCTURE
Figure 221/57-05-03-990-821 (Sheet 2 of 4)

EFFECTIVITY
SIA ALL

57-05-03

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details



2416514 S00061540971_V1

INTERNAL-GENERAL VISUAL: INTERNAL-LEFT OUTBOARD WING LEADING EDGE STRUCTURE
Figure 221/57-05-03-990-821 (Sheet 3 of 4)

— EFFECTIVITY
SIA ALL

57-05-03

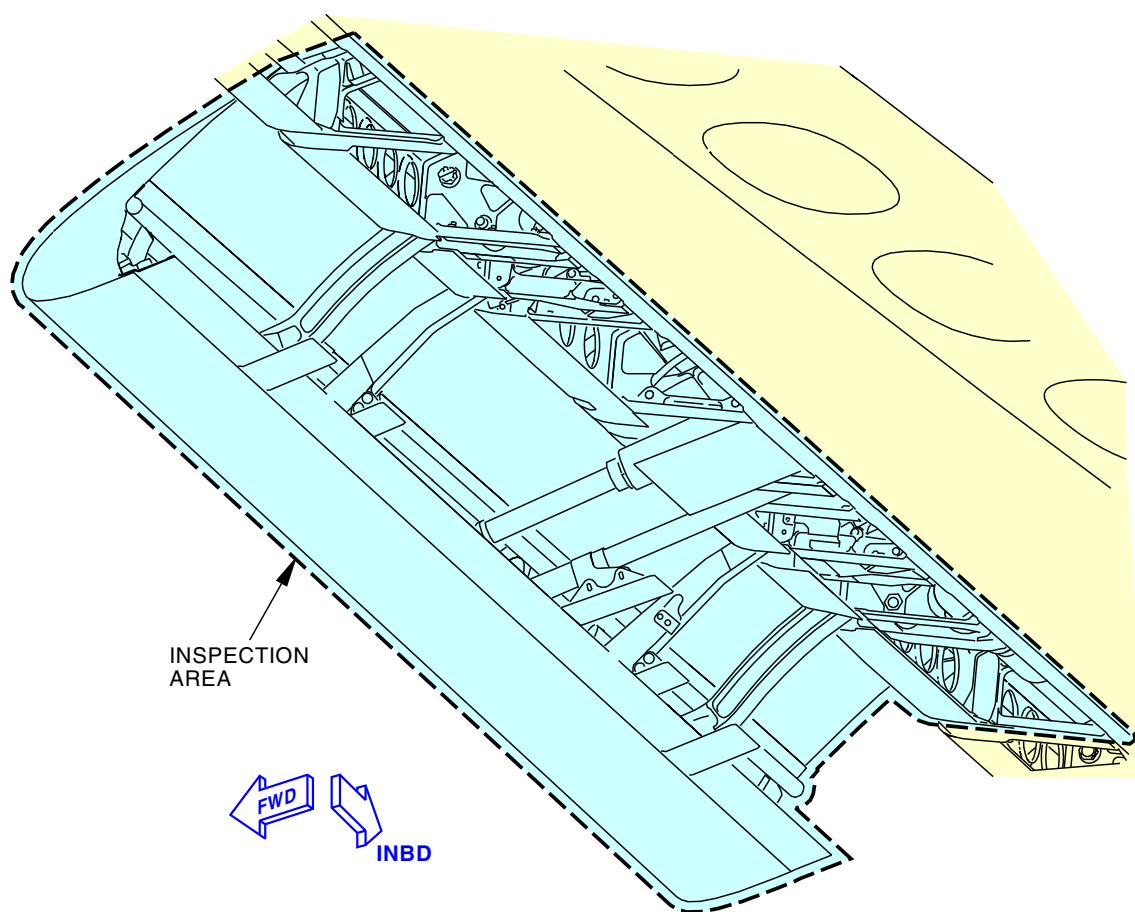
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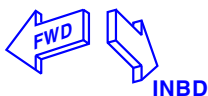
ECCN 9E991 BOEING PROPRIETARY - See title page for details



737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL



INSPECTION
AREA



SLAT 2
(LEFT WING)
(SLATS 3 AND 4 ARE EQUIVALENT)



MPD ITEM
57-130-01

2416515 S00061540972_V1

INTERNAL-GENERAL VISUAL: INTERNAL-LEFT OUTBOARD WING LEADING EDGE STRUCTURE
Figure 221/57-05-03-990-821 (Sheet 4 of 4)

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL

TASK 57-05-03-210-818

18. INTERNAL - GENERAL VISUAL: RIGHT OUTBOARD WING LEADING EDGE STRUCTURE

(Figure 222)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-806	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
611	Right Wing - Leading Edge to Front Spar
612	Right Wing - Krueger Flap No. 3
613	Right Wing - Krueger Flap No. 4
621	Right Wing - Leading Edge to Front Spar
622	Right Wing - Slat No. 5
623	Right Wing - Slat No. 6
624	Right Wing - Slat No. 7
625	Right Wing - Slat No. 8

C. Access Panels

Number	Name/Location
621AAB	Lower Leading Edge Access Panel - Slat Station 524.31
621AB	Outboard Leading Edge Blowout Door - Slat Station 20
621ABB	Lower Leading Edge Access Panel-Slat Station 519
621BB	Engine Fuel Valve Shutoff Access Panel - Slat Station 27
621CB	Lower Leading Edge Access Panel - Slat Station 50
621DB	Lower Leading Edge Access Panel - Slat Station 70
621EB	Lower Leading Edge Access Panel - Slat Station 91
621FB	Lower Leading Edge Access Panel - Slat Station 107
621GB	Refuel Valve Door - Slat Station 125
621JB	Lower Leading Edge Access Panel - Slat Station 161
621KB	Lower Leading Edge Access Panel - Slat Station 179
621LB	Lower Leading Edge Access Panel - Slat Station 208
621MB	Lower Leading Edge Access Panel - Slat Station 226
621NB	Lower Leading Edge Access Panel - Slat Station 244
621PB	Lower Leading Edge Access Panel - Slat Station 261
621QB	Lower Leading Edge Access Panel - Slat Station 280
621RB	Lower Leading Edge Access Panel - Slat Station 298
621SB	Lower Leading Edge Access Panel - Slat Station 328
621TB	Lower Leading Edge Access Panel - Slat Station 347
621UB	Lower Leading Edge Access Panel - Slat Station 365
621VB	Lower Leading Edge Access Panel - Slat Station 385
621WB	Lower Leading Edge Access Panel - Slat Station 406
621XB	Lower Leading Edge Access Panel - Slat Station 425
621YB	Lower Leading Edge Access Panel - Slat Station 470
621ZB	Lower Leading Edge Access Panel - Slat Station 479

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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D. Inspection

SUBTASK 57-05-03-010-017

- (1) Open these access panels:

<u>Number</u>	<u>Name/Location</u>
621AAB	Lower Leading Edge Access Panel - Slat Station 524.31
621AB	Outboard Leading Edge Blowout Door - Slat Station 20
621ABB	Lower Leading Edge Access Panel-Slat Station 519
621BB	Engine Fuel Valve Shutoff Access Panel - Slat Station 27
621CB	Lower Leading Edge Access Panel - Slat Station 50
621DB	Lower Leading Edge Access Panel - Slat Station 70
621EB	Lower Leading Edge Access Panel - Slat Station 91
621FB	Lower Leading Edge Access Panel - Slat Station 107
621GB	Refuel Valve Door - Slat Station 125
621JB	Lower Leading Edge Access Panel - Slat Station 161
621KB	Lower Leading Edge Access Panel - Slat Station 179
621LB	Lower Leading Edge Access Panel - Slat Station 208
621MB	Lower Leading Edge Access Panel - Slat Station 226
621NB	Lower Leading Edge Access Panel - Slat Station 244
621PB	Lower Leading Edge Access Panel - Slat Station 261
621QB	Lower Leading Edge Access Panel - Slat Station 280
621RB	Lower Leading Edge Access Panel - Slat Station 298
621SB	Lower Leading Edge Access Panel - Slat Station 328
621TB	Lower Leading Edge Access Panel - Slat Station 347
621UB	Lower Leading Edge Access Panel - Slat Station 365
621VB	Lower Leading Edge Access Panel - Slat Station 385
621WB	Lower Leading Edge Access Panel - Slat Station 406
621XB	Lower Leading Edge Access Panel - Slat Station 425
621YB	Lower Leading Edge Access Panel - Slat Station 470
621ZB	Lower Leading Edge Access Panel - Slat Station 479

NOTE: Extend Krueger flaps and slats.

SUBTASK 57-05-03-210-018

- (2) Do a General Visual inspection of the right wing leading edge cavity, including flaps and slats.

SUBTASK 57-05-03-910-018

- (3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 57-05-03-410-017

- (4) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
621AAB	Lower Leading Edge Access Panel - Slat Station 524.31
621AB	Outboard Leading Edge Blowout Door - Slat Station 20
621ABB	Lower Leading Edge Access Panel-Slat Station 519
621BB	Engine Fuel Valve Shutoff Access Panel - Slat Station 27
621CB	Lower Leading Edge Access Panel - Slat Station 50
621DB	Lower Leading Edge Access Panel - Slat Station 70
621EB	Lower Leading Edge Access Panel - Slat Station 91
621FB	Lower Leading Edge Access Panel - Slat Station 107
621GB	Refuel Valve Door - Slat Station 125

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL

(Continued)

<u>Number</u>	<u>Name/Location</u>
621JB	Lower Leading Edge Access Panel - Slat Station 161
621KB	Lower Leading Edge Access Panel - Slat Station 179
621LB	Lower Leading Edge Access Panel - Slat Station 208
621MB	Lower Leading Edge Access Panel - Slat Station 226
621NB	Lower Leading Edge Access Panel - Slat Station 244
621PB	Lower Leading Edge Access Panel - Slat Station 261
621QB	Lower Leading Edge Access Panel - Slat Station 280
621RB	Lower Leading Edge Access Panel - Slat Station 298
621SB	Lower Leading Edge Access Panel - Slat Station 328
621TB	Lower Leading Edge Access Panel - Slat Station 347
621UB	Lower Leading Edge Access Panel - Slat Station 365
621VB	Lower Leading Edge Access Panel - Slat Station 385
621WB	Lower Leading Edge Access Panel - Slat Station 406
621XB	Lower Leading Edge Access Panel - Slat Station 425
621YB	Lower Leading Edge Access Panel - Slat Station 470
621ZB	Lower Leading Edge Access Panel - Slat Station 479

———— **END OF TASK** ————

EFFECTIVITY
SIA ALL

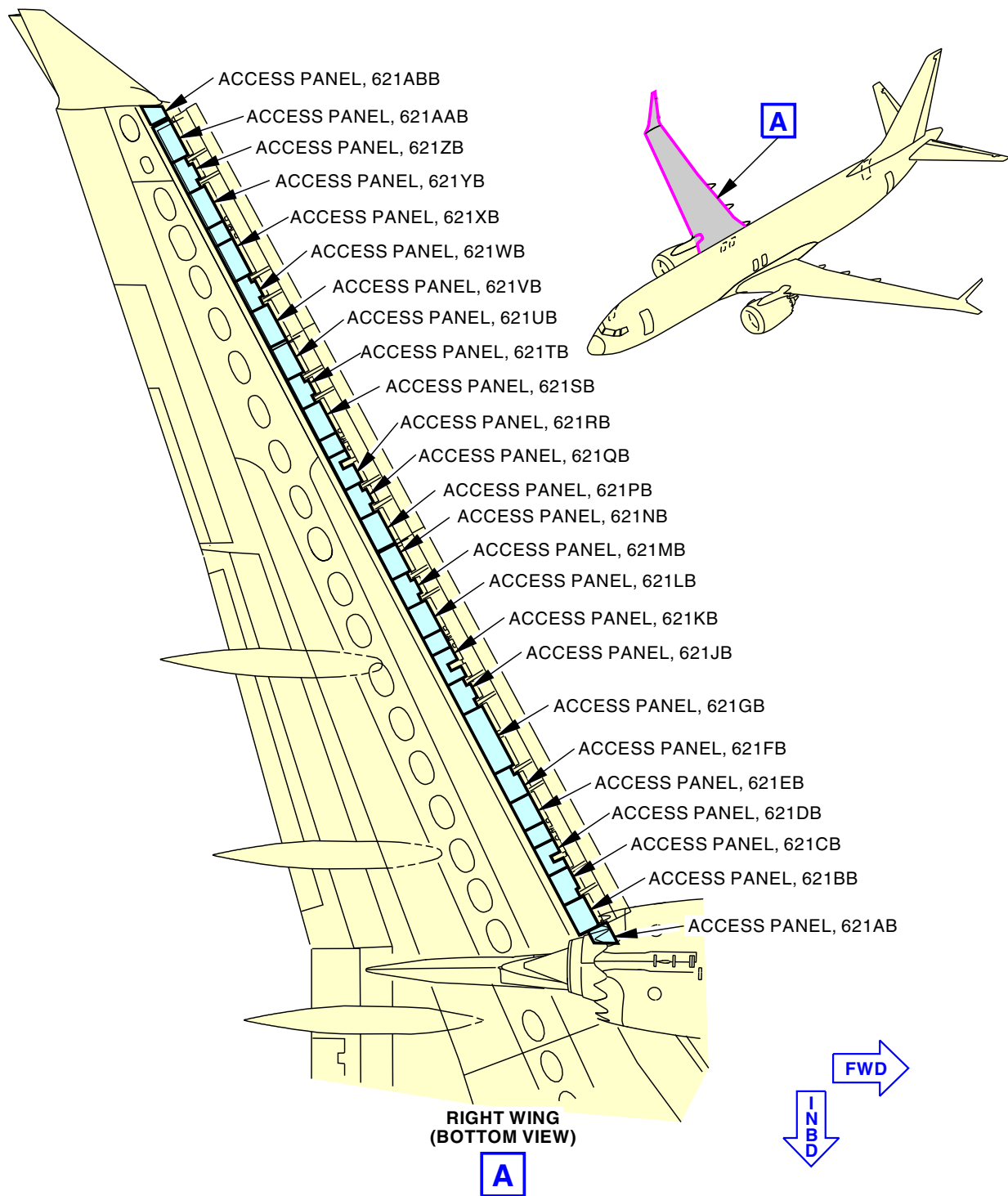
D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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737-7/8/8200/9/10 AIRCRAFT MAINTENANCE MANUAL



2416516 S00061540974_V3

INTERNAL-GENERAL VISUAL: RIGHT OUTBOARD WING LEADING EDGE
Figure 222/57-05-03-990-822 (Sheet 1 of 4)

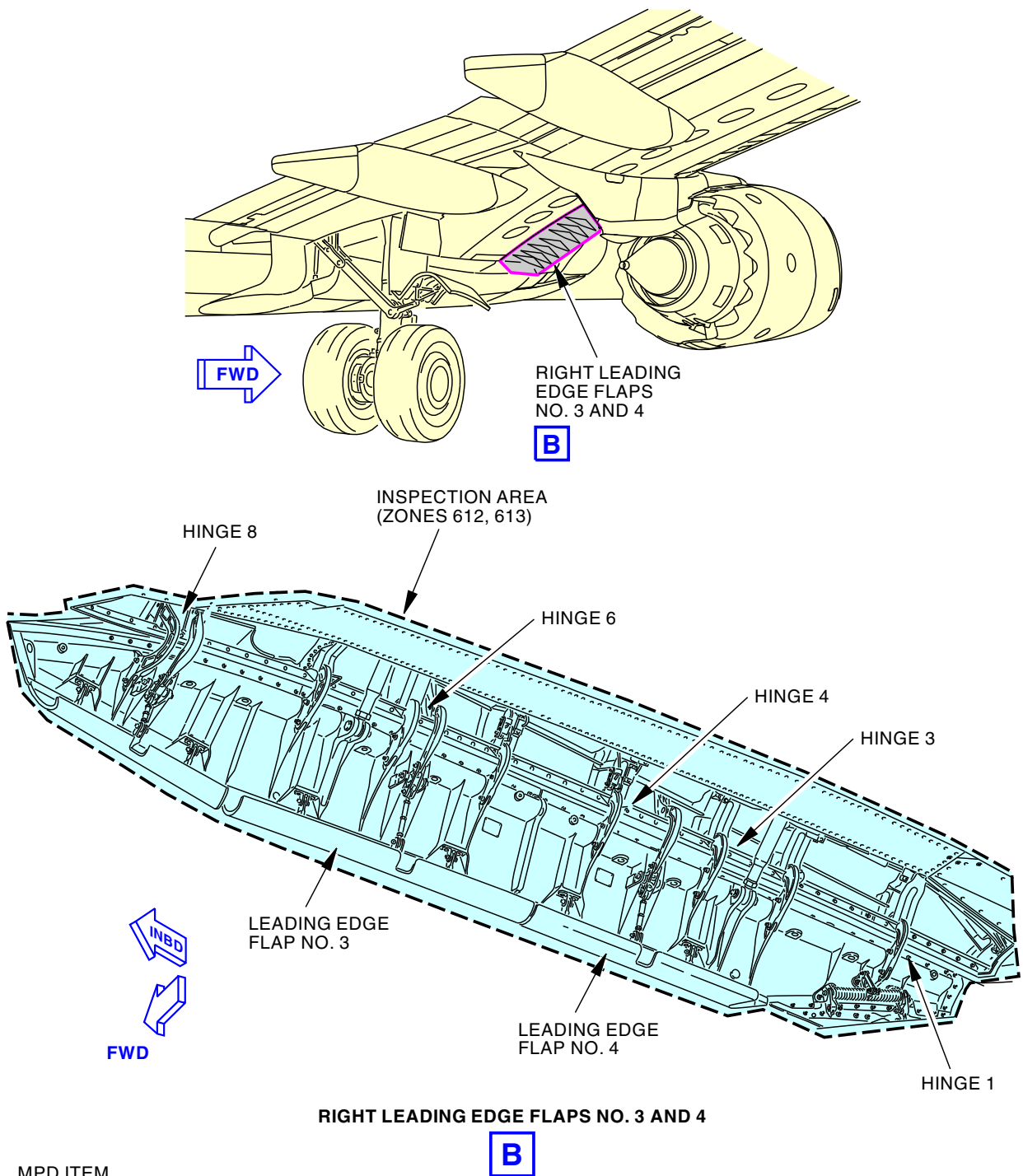
EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

57-05-03

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MPD ITEM
57-130-02

2416517 S00061540975_V1

INTERNAL-GENERAL VISUAL: RIGHT OUTBOARD WING LEADING EDGE
Figure 222/57-05-03-990-822 (Sheet 2 of 4)

EFFECTIVITY
SIA ALL

D633AM101-SIA

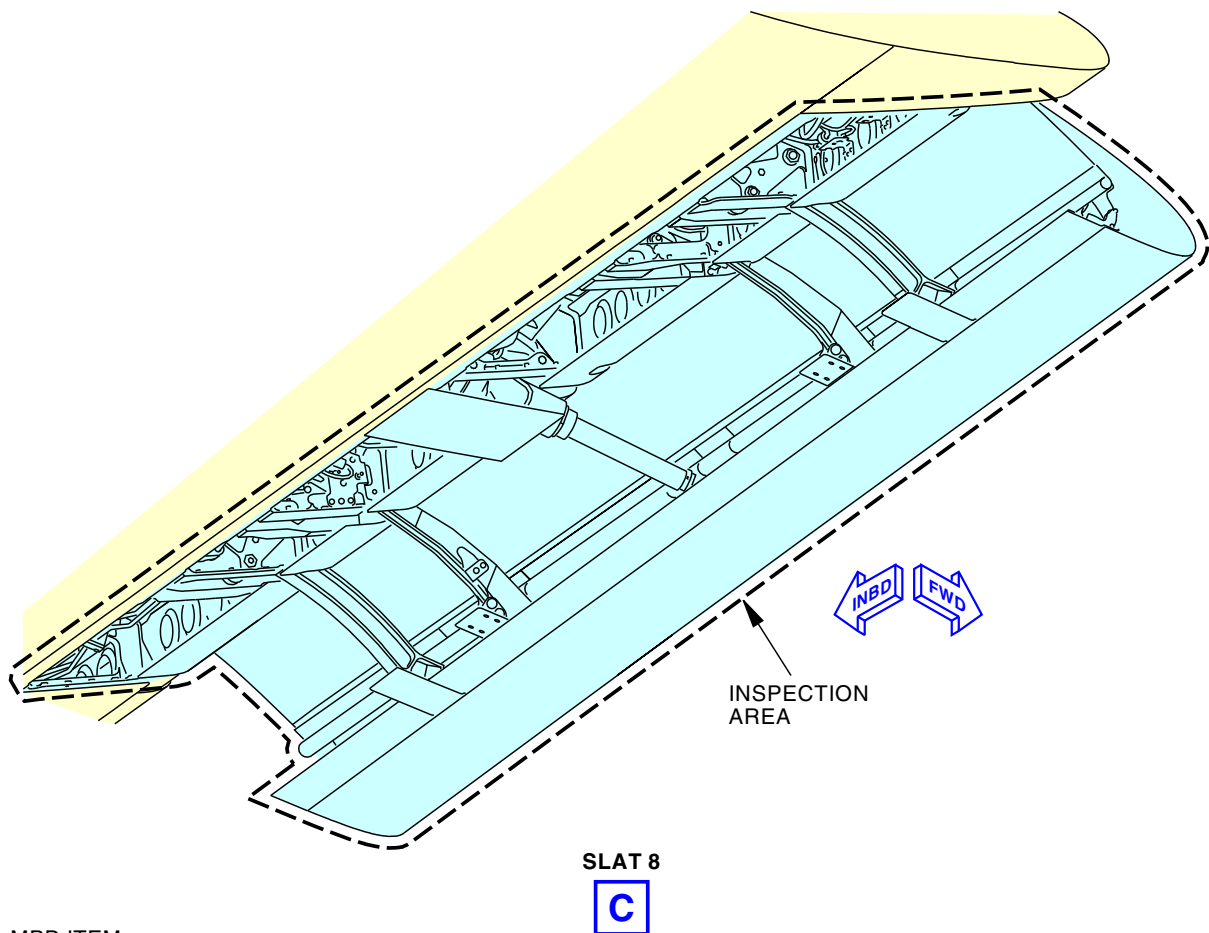
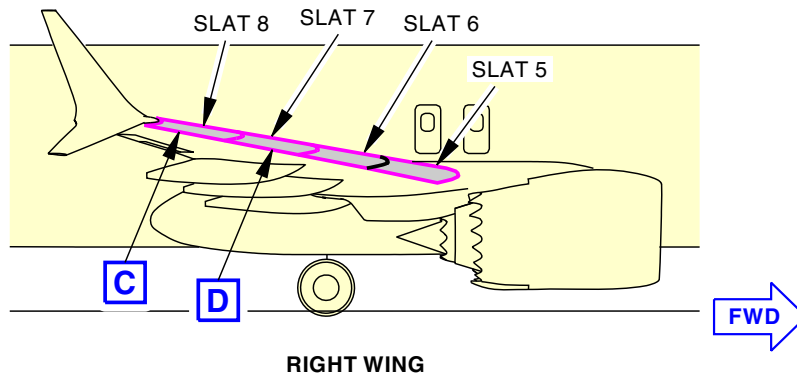
ECCN 9E991 BOEING PROPRIETARY - See title page for details

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737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL



MPD ITEM
57-130-02

2416518 S00061540976_V1

INTERNAL-GENERAL VISUAL: RIGHT OUTBOARD WING LEADING EDGE
Figure 222/57-05-03-990-822 (Sheet 3 of 4)

EFFECTIVITY
SIA ALL

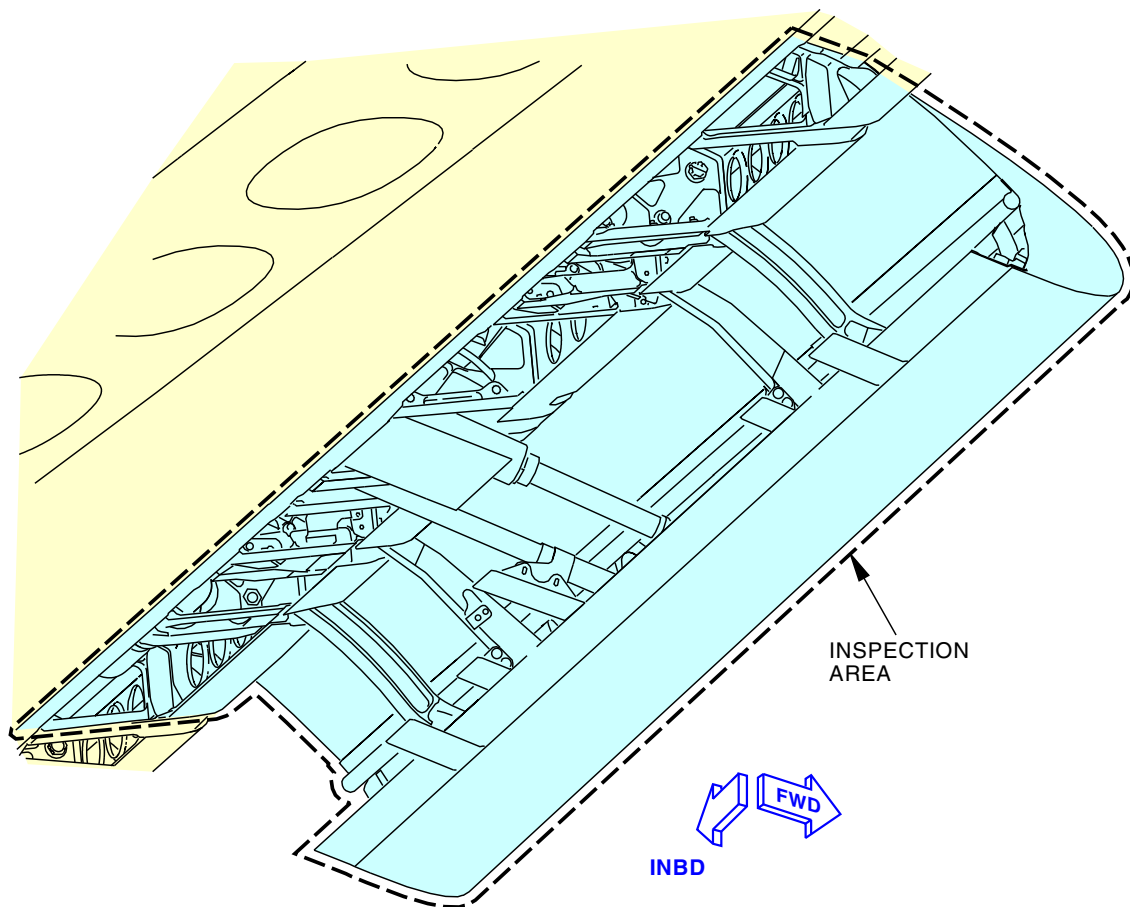
57-05-03

D633AM101-SIA

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737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL



SLAT 7
(SLATS 5 AND 6 ARE EQUIVALENT)



MPD ITEM
57-130-02

2416519 S00061540977_V1

INTERNAL-GENERAL VISUAL: RIGHT OUTBOARD WING LEADING EDGE
Figure 222/57-05-03-990-822 (Sheet 4 of 4)

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

57-05-03

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737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL

TASK 57-05-03-211-801

19. INTERNAL - DETAILED: LEFT WING SLAT TRACKS

(Figure 223)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-809	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
522	Left Wing - Slat No. 4
523	Left Wing - Slat No. 3
524	Left Wing - Slat No. 2
525	Left Wing - Slat No. 1

C. Access Panels

Number	Name/Location
521CB	Lower Leading Edge Access Panel - Slat Station 50
521FB	Lower Leading Edge Access Panel - Slat Station 107
521JB	Lower Leading Edge Access Panel - Slat Station 161
521MB	Lower Leading Edge Access Panel - Slat Station 226
521QB	Lower Leading Edge Access Panel - Slat Station 280
521TB	Lower Leading Edge Access Panel - Slat Station 347
521WB	Lower Leading Edge Access Panel - Slat Station 406
521ZB	Lower Leading Edge Access Panel - Slat Station 479

D. Inspection

SUBTASK 57-05-03-010-018

- (1) Open these access panels:

Number	Name/Location
521CB	Lower Leading Edge Access Panel - Slat Station 50
521FB	Lower Leading Edge Access Panel - Slat Station 107
521JB	Lower Leading Edge Access Panel - Slat Station 161
521MB	Lower Leading Edge Access Panel - Slat Station 226
521QB	Lower Leading Edge Access Panel - Slat Station 280
521TB	Lower Leading Edge Access Panel - Slat Station 347
521WB	Lower Leading Edge Access Panel - Slat Station 406
521ZB	Lower Leading Edge Access Panel - Slat Station 479

NOTE: Extend slats.

SUBTASK 57-05-03-211-001

- (2) Do a Detailed inspection of the left wing slat tracks.

SUBTASK 57-05-03-910-019

- (3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-809.

EFFECTIVITY
SIA ALL

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AIRCRAFT MAINTENANCE MANUAL

SUBTASK 57-05-03-410-018

(4) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
521CB	Lower Leading Edge Access Panel - Slat Station 50
521FB	Lower Leading Edge Access Panel - Slat Station 107
521JB	Lower Leading Edge Access Panel - Slat Station 161
521MB	Lower Leading Edge Access Panel - Slat Station 226
521QB	Lower Leading Edge Access Panel - Slat Station 280
521TB	Lower Leading Edge Access Panel - Slat Station 347
521WB	Lower Leading Edge Access Panel - Slat Station 406
521ZB	Lower Leading Edge Access Panel - Slat Station 479

———— **END OF TASK** ————

EFFECTIVITY
SIA ALL

D633AM101-SIA

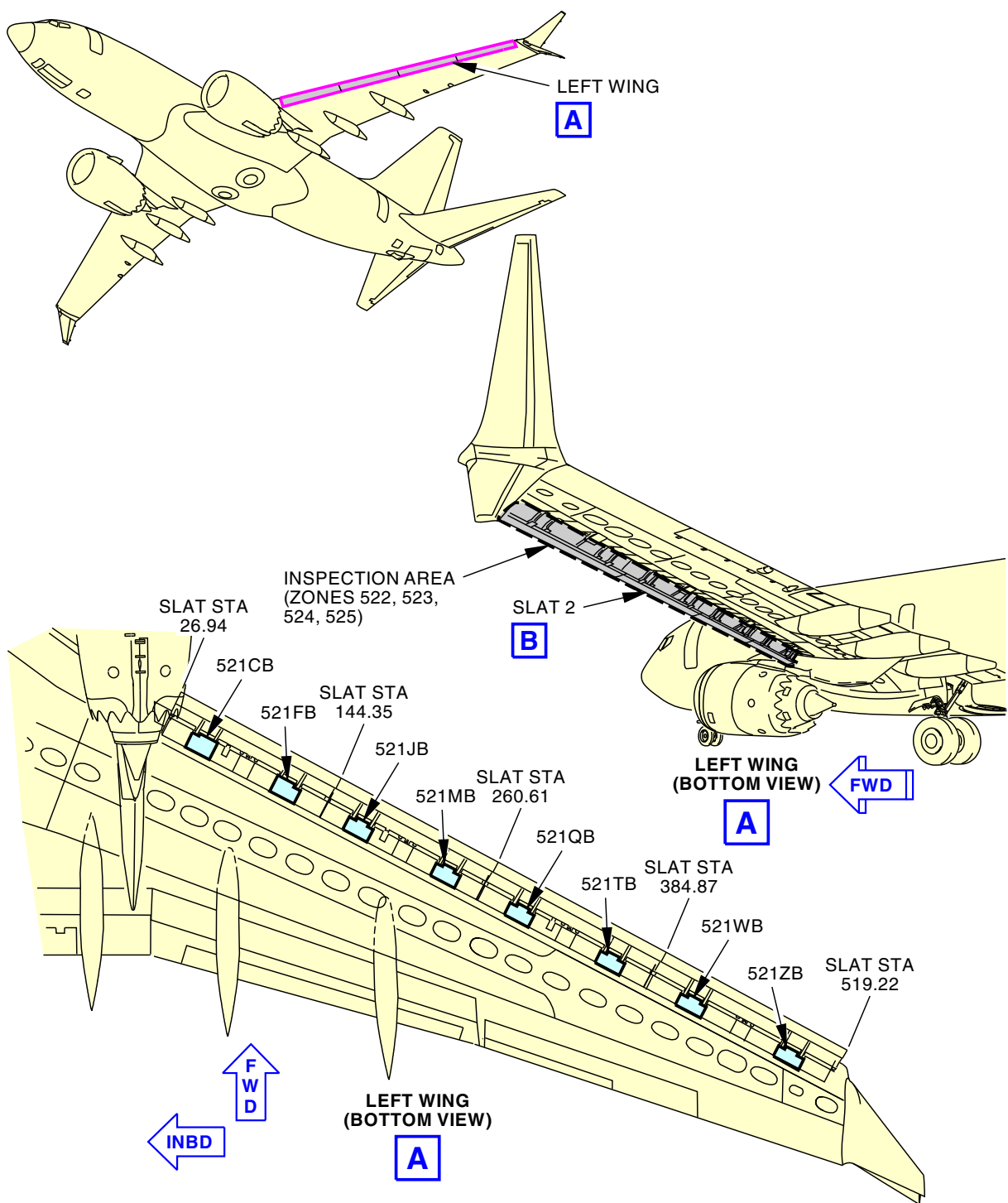
ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL



2416520 S00061540979_V1

Left Wing Leading Edge Slat Tracks
Figure 223/57-05-03-990-823 (Sheet 1 of 2)

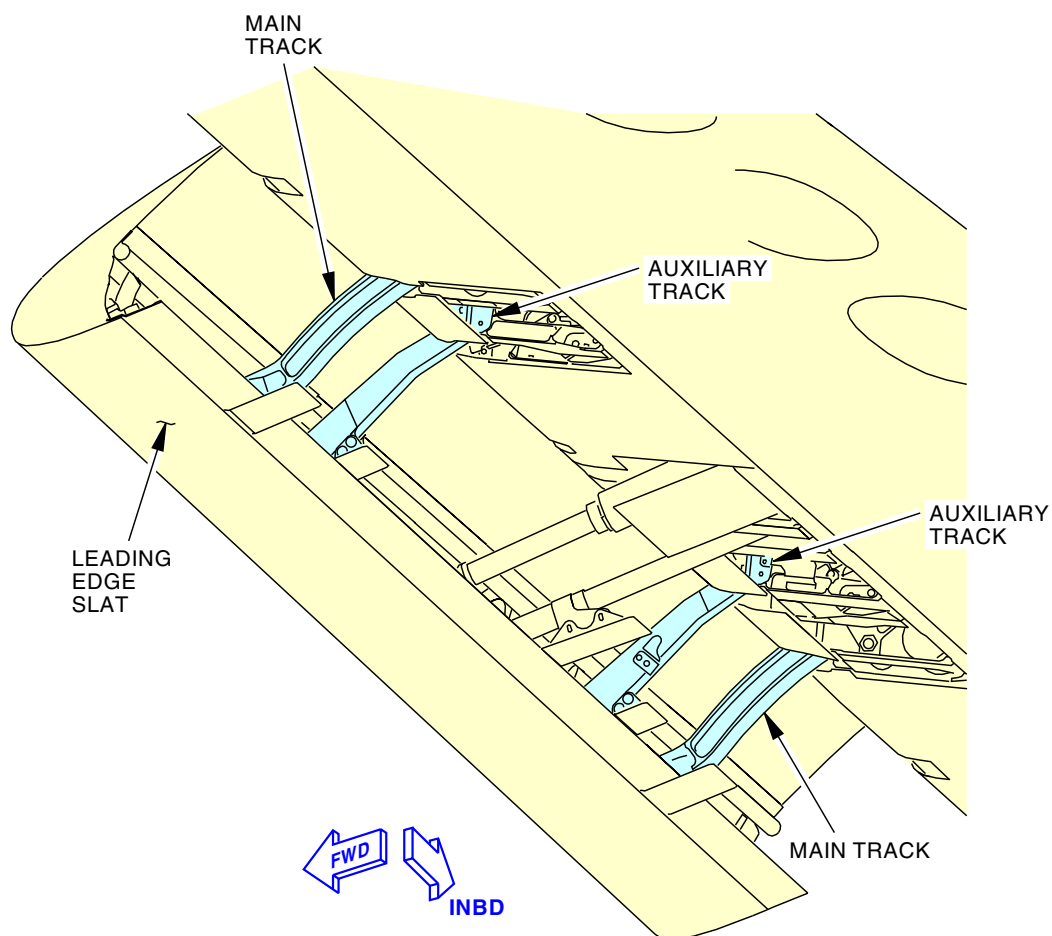
EFFECTIVITY
SIA ALL

D633AM101-SIA

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SLAT 2
(SLATS 1, 3, AND 4 ARE EQUIVALENT)

B

2416521 S00061540980_V1

Left Wing Leading Edge Slat Tracks
Figure 223/57-05-03-990-823 (Sheet 2 of 2)

EFFECTIVITY
SIA ALL

D633AM101-SIA

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AIRCRAFT MAINTENANCE MANUAL

TASK 57-05-03-211-802

20. INTERNAL - DETAILED: RIGHT WING SLAT TRACKS

(Figure 224)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-809	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
622	Right Wing - Slat No. 5
623	Right Wing - Slat No. 6
624	Right Wing - Slat No. 7
625	Right Wing - Slat No. 8

C. Access Panels

Number	Name/Location
621CB	Lower Leading Edge Access Panel - Slat Station 50
621FB	Lower Leading Edge Access Panel - Slat Station 107
621JB	Lower Leading Edge Access Panel - Slat Station 161
621MB	Lower Leading Edge Access Panel - Slat Station 226
621QB	Lower Leading Edge Access Panel - Slat Station 280
621TB	Lower Leading Edge Access Panel - Slat Station 347
621WB	Lower Leading Edge Access Panel - Slat Station 406
621ZB	Lower Leading Edge Access Panel - Slat Station 479

D. Inspection

SUBTASK 57-05-03-010-019

- (1) Open these access panels:

Number	Name/Location
621CB	Lower Leading Edge Access Panel - Slat Station 50
621FB	Lower Leading Edge Access Panel - Slat Station 107
621JB	Lower Leading Edge Access Panel - Slat Station 161
621MB	Lower Leading Edge Access Panel - Slat Station 226
621QB	Lower Leading Edge Access Panel - Slat Station 280
621TB	Lower Leading Edge Access Panel - Slat Station 347
621WB	Lower Leading Edge Access Panel - Slat Station 406
621ZB	Lower Leading Edge Access Panel - Slat Station 479

NOTE: Extend slats.

SUBTASK 57-05-03-211-002

- (2) Do a Detailed inspection of the right wing slat tracks.

SUBTASK 57-05-03-910-020

- (3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-809.

EFFECTIVITY
SIA ALL

D633AM101-SIA

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AIRCRAFT MAINTENANCE MANUAL

SUBTASK 57-05-03-410-019

(4) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
621CB	Lower Leading Edge Access Panel - Slat Station 50
621FB	Lower Leading Edge Access Panel - Slat Station 107
621JB	Lower Leading Edge Access Panel - Slat Station 161
621MB	Lower Leading Edge Access Panel - Slat Station 226
621QB	Lower Leading Edge Access Panel - Slat Station 280
621TB	Lower Leading Edge Access Panel - Slat Station 347
621WB	Lower Leading Edge Access Panel - Slat Station 406
621ZB	Lower Leading Edge Access Panel - Slat Station 479

———— **END OF TASK** ————

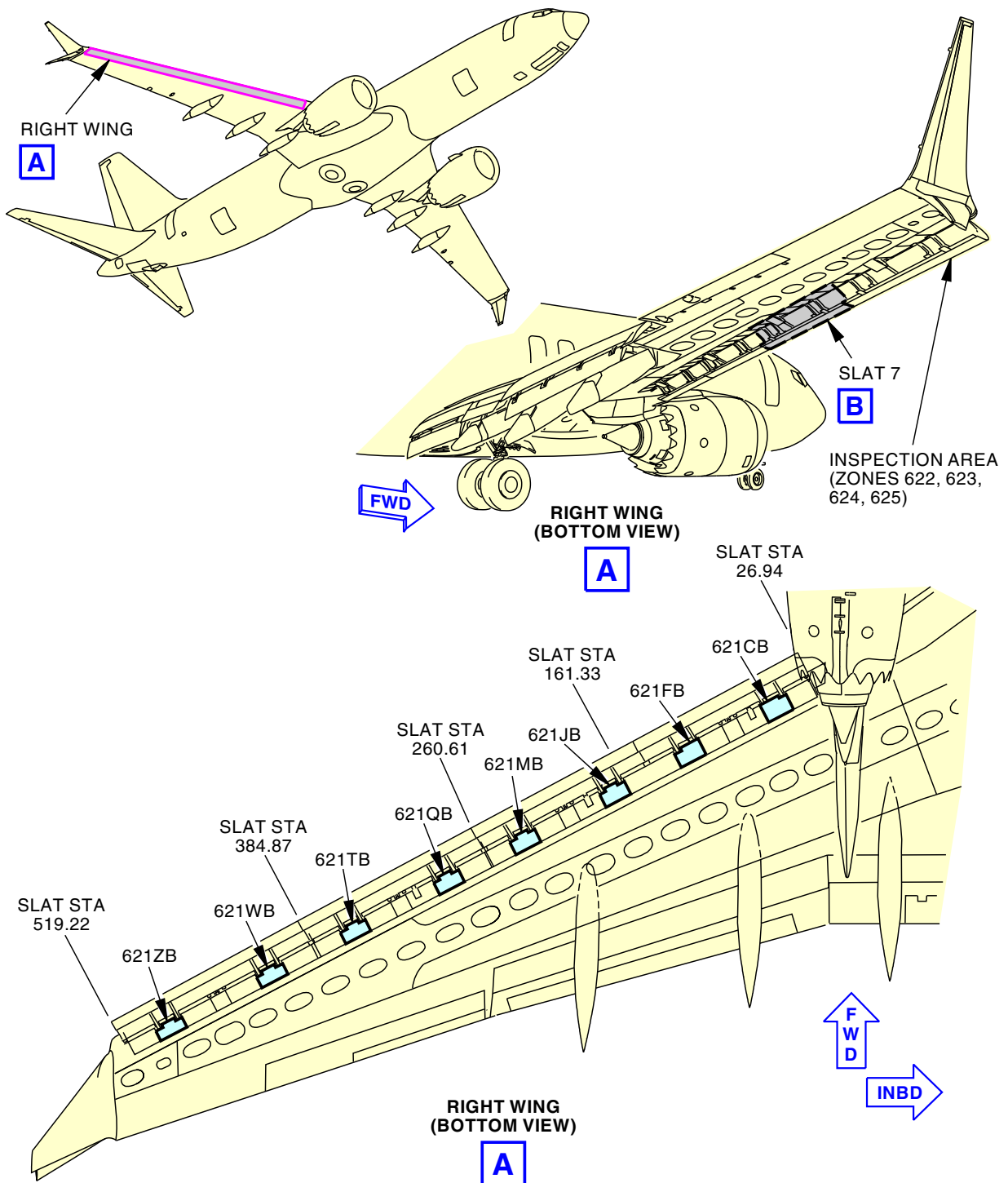
EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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2416522 S00061540982_V2

Right Wing Leading Edge Slat Tracks
Figure 224/57-05-03-990-824 (Sheet 1 of 2)

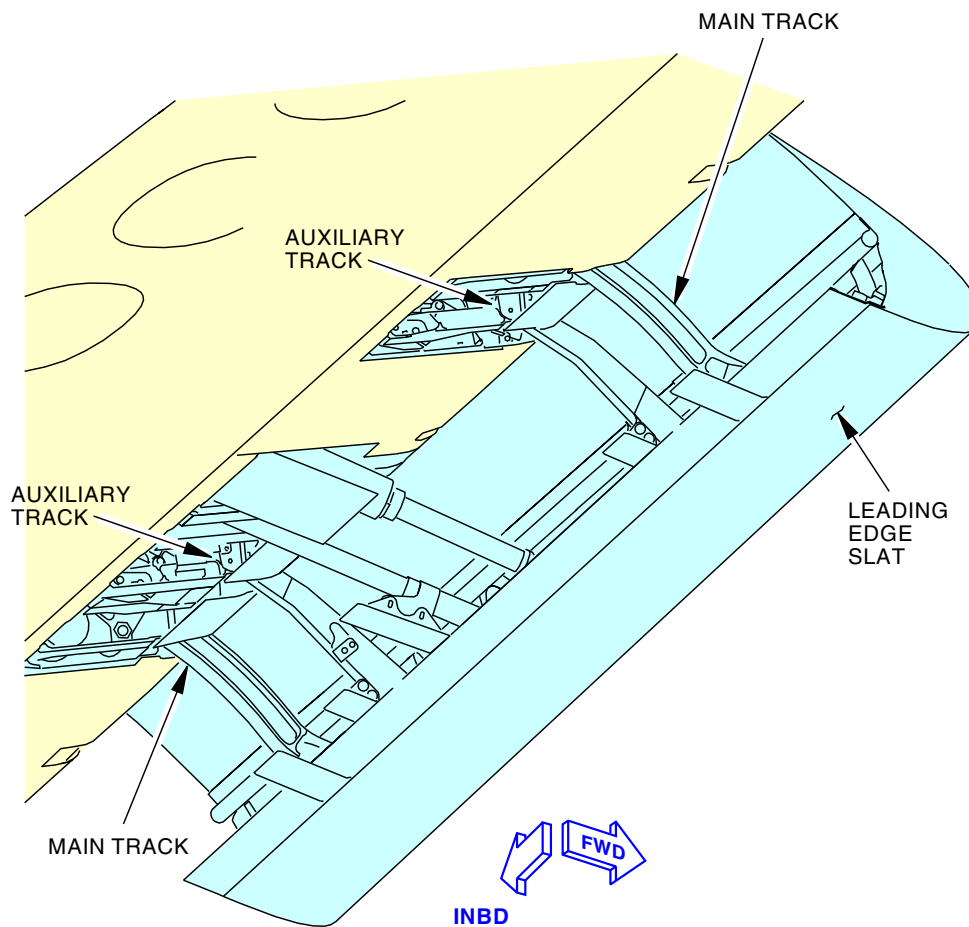
EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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SLAT 7
(SLATS 5, 6, AND 8 ARE EQUIVALENT)

B

2416523 S00061540983_V1

Right Wing Leading Edge Slat Tracks
Figure 224/57-05-03-990-824 (Sheet 2 of 2)

EFFECTIVITY
SIA ALL

D633AM101-SIA

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AIRCRAFT MAINTENANCE MANUAL

TASK 57-05-03-210-819

21. INTERNAL - GENERAL VISUAL: LEFT OUTBOARD WING ACCESS HOLES

(Figure 225)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
28-11-11-000-801	Main Tank Access Door Removal (P/B 401)
28-11-11-000-802	Surge Tank Access Door Removal (P/B 401)
28-11-11-400-801	Main Tank Access Door Installation (P/B 401)
28-11-11-400-802	Surge Tank Access Door (533AB, 533CB, 633AB, 633CB) Installation (P/B 401)
28-11-11-400-803	Surge tank Access Door (533BB, 633BB) Installation (P/B 401)
28-11-31-000-801	Center Tank Access Door Removal (P/B 401)
28-11-31-400-801	Center Tank Access Door - Installation (P/B 401)
51-05-01-210-809	737-7/8/8200/9 Basic Task Description (P/B 201)
57-31-23-000-801	Dry Bay Access Doors Removal (P/B 401)
57-31-23-400-801	Dry Bay Access Doors Installation (P/B 401)

B. Location Zones

Zone	Area
531	Left Wing - Center Fuel Tank, Rib 1 to Rib 5
532	Left Wing - Main Tank, Rib 5 to Rib 22, Wing Station 204.25 to Wing BL 643.50
533	Left Wing - Surge Tank, Rib 22 to Rib 25, Wing Station 643.50 to Wing BL 616.75
534	Left Wing - Dry Bay

C. Access Panels

Number	Name/Location
531AB	Center Tank Access Door - Wing Station 168
531BB	Center Tank Access Door - Wing Station 192
532AB	Main Tank Access Door - Wing Station 216
532BB	Main Tank Access Door - Wing Station 265
532CB	Main Tank Access Door - Wing Station 290
532DB	Main Tank Access Door - Wing Station 313
532EB	Main Tank Access Door - Wing Station 337
532FB	Main Tank Access Door - Wing Station 367
532GB	Main Tank Access Door - Wing Station 390
532HB	Main Tank Access Door - Wing Station 417
532JB	Main Tank Access Door - Wing Station 443
532KB	Main Tank Access Door - Wing Station 470
532LB	Main Tank Access Door - Wing Station 496
532MB	Main Tank Access Door - Wing Station 523
532NB	Main Tank Access Door - Wing Station 549
532PB	Main Tank Access Door - Wing Station 576
532QB	Main Tank Access Door - Wing Station 602
532RB	Main Tank Access Door - Wing Station 629
533AB	Surge Tank Access Door - Wing Station 655

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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**737-7/8/8200/9/10
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(Continued)

Number	Name/Location
533BB	Surge Tank Access Door - Wing Station 679
533CB	Surge Tank Access Door - Wing Station 703
534AB	Dry Bay Tank Access Door - Left Wing Station 727
534BB	Dry Bay Tank Access Door - Left Wing Station 748

D. Inspection of the Left Outboard Wing Access Holes

SUBTASK 57-05-03-010-020

- (1) Open these access panels:

(TASK 28-11-31-000-801, TASK 28-11-11-000-801, TASK 28-11-11-000-802,
TASK 57-31-23-000-801)

Number	Name/Location
531AB	Center Tank Access Door - Wing Station 168
531BB	Center Tank Access Door - Wing Station 192
532AB	Main Tank Access Door - Wing Station 216
532BB	Main Tank Access Door - Wing Station 265
532CB	Main Tank Access Door - Wing Station 290
532DB	Main Tank Access Door - Wing Station 313
532EB	Main Tank Access Door - Wing Station 337
532FB	Main Tank Access Door - Wing Station 367
532GB	Main Tank Access Door - Wing Station 390
532HB	Main Tank Access Door - Wing Station 417
532JB	Main Tank Access Door - Wing Station 443
532KB	Main Tank Access Door - Wing Station 470
532LB	Main Tank Access Door - Wing Station 496
532MB	Main Tank Access Door - Wing Station 523
532NB	Main Tank Access Door - Wing Station 549
532PB	Main Tank Access Door - Wing Station 576
532QB	Main Tank Access Door - Wing Station 602
532RB	Main Tank Access Door - Wing Station 629
533AB	Surge Tank Access Door - Wing Station 655
533BB	Surge Tank Access Door - Wing Station 679
533CB	Surge Tank Access Door - Wing Station 703
534AB	Dry Bay Tank Access Door - Left Wing Station 727
534BB	Dry Bay Tank Access Door - Left Wing Station 748

SUBTASK 57-05-03-210-019

- (2) Do a General Visual inspection of the fuel access holes in left outboard wing lower surface.

NOTE: Tank entry is not required.

SUBTASK 57-05-03-910-021

- (3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-809.

SUBTASK 57-05-03-410-020

- (4) Close these access panels:

(TASK 28-11-31-400-801, TASK 28-11-11-400-801, TASK 28-11-11-400-802,
TASK 28-11-11-400-803, TASK 57-31-23-400-801)

EFFECTIVITY
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AIRCRAFT MAINTENANCE MANUAL

<u>Number</u>	<u>Name/Location</u>
531AB	Center Tank Access Door - Wing Station 168
531BB	Center Tank Access Door - Wing Station 192
532AB	Main Tank Access Door - Wing Station 216
532BB	Main Tank Access Door - Wing Station 265
532CB	Main Tank Access Door - Wing Station 290
532DB	Main Tank Access Door - Wing Station 313
532EB	Main Tank Access Door - Wing Station 337
532FB	Main Tank Access Door - Wing Station 367
532GB	Main Tank Access Door - Wing Station 390
532HB	Main Tank Access Door - Wing Station 417
532JB	Main Tank Access Door - Wing Station 443
532KB	Main Tank Access Door - Wing Station 470
532LB	Main Tank Access Door - Wing Station 496
532MB	Main Tank Access Door - Wing Station 523
532NB	Main Tank Access Door - Wing Station 549
532PB	Main Tank Access Door - Wing Station 576
532QB	Main Tank Access Door - Wing Station 602
532RB	Main Tank Access Door - Wing Station 629
533AB	Surge Tank Access Door - Wing Station 655
533BB	Surge Tank Access Door - Wing Station 679
533CB	Surge Tank Access Door - Wing Station 703
534AB	Dry Bay Tank Access Door - Left Wing Station 727
534BB	Dry Bay Tank Access Door - Left Wing Station 748

———— **END OF TASK** ————

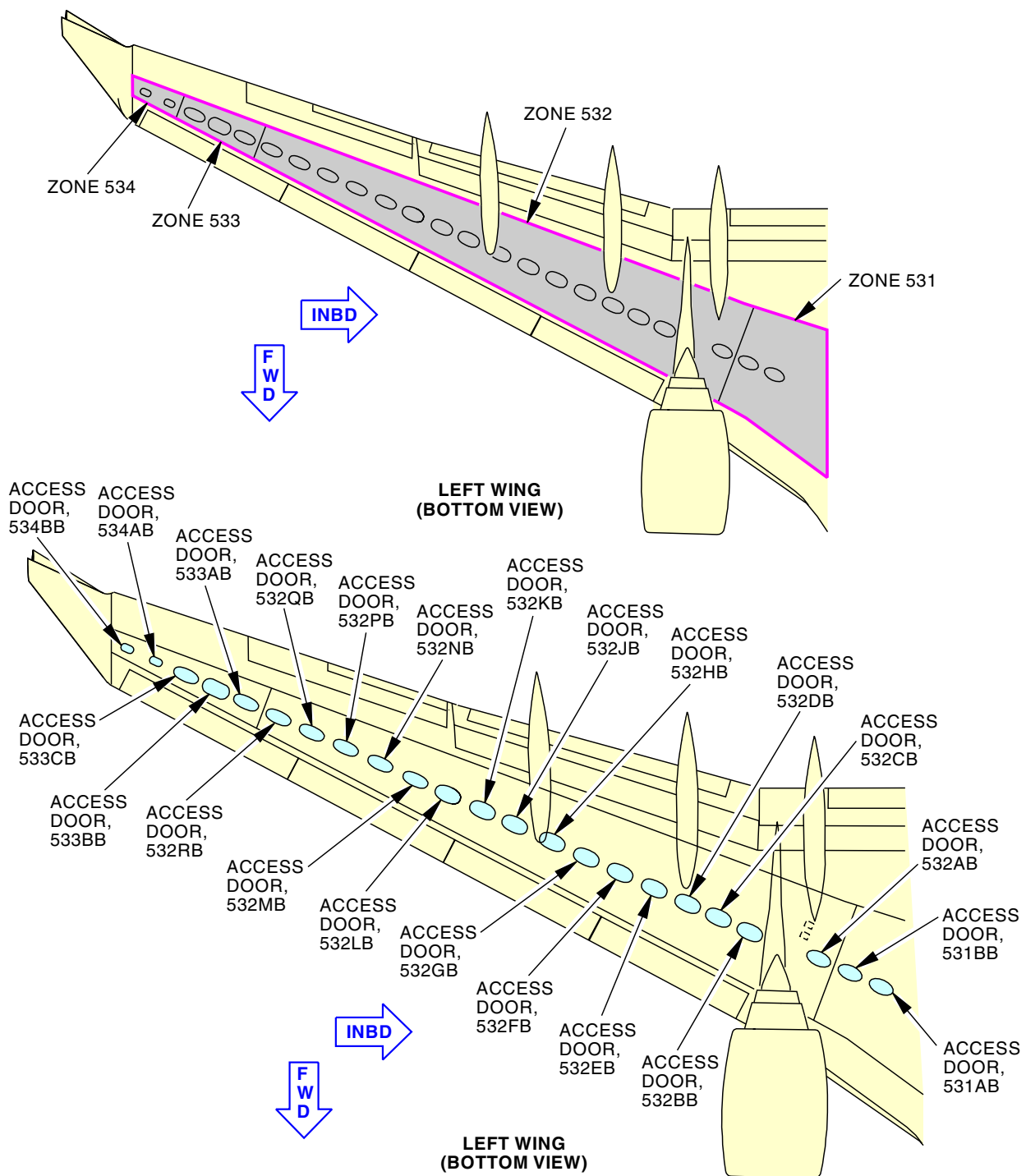
EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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2416524 S00061540985_V2

Left Outboard Wing Access Holes
Figure 225/57-05-03-990-825

EFFECTIVITY
SIA ALL

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AIRCRAFT MAINTENANCE MANUAL

TASK 57-05-03-210-820

22. INTERNAL - GENERAL VISUAL: RIGHT OUTBOARD WING ACCESS HOLES

(Figure 226)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
28-11-11-000-801	Main Tank Access Door Removal (P/B 401)
28-11-11-000-802	Surge Tank Access Door Removal (P/B 401)
28-11-11-400-801	Main Tank Access Door Installation (P/B 401)
28-11-11-400-802	Surge Tank Access Door (533AB, 533CB, 633AB, 633CB) Installation (P/B 401)
28-11-11-400-803	Surge tank Access Door (533BB, 633BB) Installation (P/B 401)
28-11-31-000-801	Center Tank Access Door Removal (P/B 401)
28-11-31-400-801	Center Tank Access Door - Installation (P/B 401)
51-05-01-210-809	737-7/8/8200/9 Basic Task Description (P/B 201)
57-31-23-000-801	Dry Bay Access Doors Removal (P/B 401)
57-31-23-400-801	Dry Bay Access Doors Installation (P/B 401)

B. Location Zones

Zone	Area
631	Right Wing - Center Fuel Tank, Rib 1 to Rib 5
632	Right Wing - Main Tank, Rib 5 to Rib 22, Wing Station 204.25 to Wing Station 643.50
633	Right Wing - Surge Tank, Rib 22 to Rib 25, Wing Station 643.50 to Wing Buttock Line 616.75
634	Right Wing - Dry Bay

C. Access Panels

Number	Name/Location
631AB	Center Tank Access Door - Wing Station 168
631BB	Center Tank Access Door - Wing Station 192
632AB	Main Tank Access Door - Wing Station 216
632BB	Main Tank Access Door - Wing Station 265
632CB	Main Tank Access Door - Wing Station 290
632DB	Main Tank Access Door - Wing Station 313
632EB	Main Tank Access Door - Wing Station 337
632FB	Main Tank Access Door - Wing Station 367
632GB	Main Tank Access Door - Wing Station 390
632HB	Main Tank Access Door - Wing Station 417
632JB	Main Tank Access Door - Wing Station 443
632KB	Main Tank Access Door - Wing Station 470
632LB	Main Tank Access Door - Wing Station 496
632MB	Main Tank Access Door - Wing Station 523
632NB	Main Tank Access Door - Wing Station 549
632PB	Main Tank Access Door - Wing Station 576
632QB	Main Tank Access Door - Wing Station 602

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL

(Continued)

Number	Name/Location
632RB	Main Tank Access Door - Wing Station 629
633AB	Surge Tank Access Door - Wing Station 655
633BB	Surge Tank Access Door - Wing Station 679
633CB	Surge Tank Access Door - Wing Station 703
634AB	Dry Bay Tank Access Door - Right Wing Station 727
634BB	Dry Bay Tank Access Door - Right Wing Station 748

D. Inspection of the Right Outboard Wing Access Holes

SUBTASK 57-05-03-010-021

- (1) Open these access panels:

(TASK 28-11-31-000-801, TASK 28-11-11-000-801, TASK 28-11-11-000-802,
TASK 57-31-23-000-801)

Number	Name/Location
631AB	Center Tank Access Door - Wing Station 168
631BB	Center Tank Access Door - Wing Station 192
632AB	Main Tank Access Door - Wing Station 216
632BB	Main Tank Access Door - Wing Station 265
632CB	Main Tank Access Door - Wing Station 290
632DB	Main Tank Access Door - Wing Station 313
632EB	Main Tank Access Door - Wing Station 337
632FB	Main Tank Access Door - Wing Station 367
632GB	Main Tank Access Door - Wing Station 390
632HB	Main Tank Access Door - Wing Station 417
632JB	Main Tank Access Door - Wing Station 443
632KB	Main Tank Access Door - Wing Station 470
632LB	Main Tank Access Door - Wing Station 496
632MB	Main Tank Access Door - Wing Station 523
632NB	Main Tank Access Door - Wing Station 549
632PB	Main Tank Access Door - Wing Station 576
632QB	Main Tank Access Door - Wing Station 602
632RB	Main Tank Access Door - Wing Station 629
633AB	Surge Tank Access Door - Wing Station 655
633BB	Surge Tank Access Door - Wing Station 679
633CB	Surge Tank Access Door - Wing Station 703
634AB	Dry Bay Tank Access Door - Right Wing Station 727
634BB	Dry Bay Tank Access Door - Right Wing Station 748

SUBTASK 57-05-03-210-020

- (2) Do a General Visual inspection of the fuel access holes in right outboard wing lower surface.

NOTE: Tank entry is not required.

SUBTASK 57-05-03-910-022

- (3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-809.

SUBTASK 57-05-03-410-021

- (4) Close these access panels:

(TASK 28-11-31-400-801, TASK 28-11-11-400-801, TASK 28-11-11-400-802,
TASK 28-11-11-400-803, TASK 57-31-23-400-801)

EFFECTIVITY
SIA ALL

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737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL

<u>Number</u>	<u>Name/Location</u>
631AB	Center Tank Access Door - Wing Station 168
631BB	Center Tank Access Door - Wing Station 192
632AB	Main Tank Access Door - Wing Station 216
632BB	Main Tank Access Door - Wing Station 265
632CB	Main Tank Access Door - Wing Station 290
632DB	Main Tank Access Door - Wing Station 313
632EB	Main Tank Access Door - Wing Station 337
632FB	Main Tank Access Door - Wing Station 367
632GB	Main Tank Access Door - Wing Station 390
632HB	Main Tank Access Door - Wing Station 417
632JB	Main Tank Access Door - Wing Station 443
632KB	Main Tank Access Door - Wing Station 470
632LB	Main Tank Access Door - Wing Station 496
632MB	Main Tank Access Door - Wing Station 523
632NB	Main Tank Access Door - Wing Station 549
632PB	Main Tank Access Door - Wing Station 576
632QB	Main Tank Access Door - Wing Station 602
632RB	Main Tank Access Door - Wing Station 629
633AB	Surge Tank Access Door - Wing Station 655
633BB	Surge Tank Access Door - Wing Station 679
633CB	Surge Tank Access Door - Wing Station 703
634AB	Dry Bay Tank Access Door - Right Wing Station 727
634BB	Dry Bay Tank Access Door - Right Wing Station 748

— **END OF TASK** —

EFFECTIVITY
SIA ALL

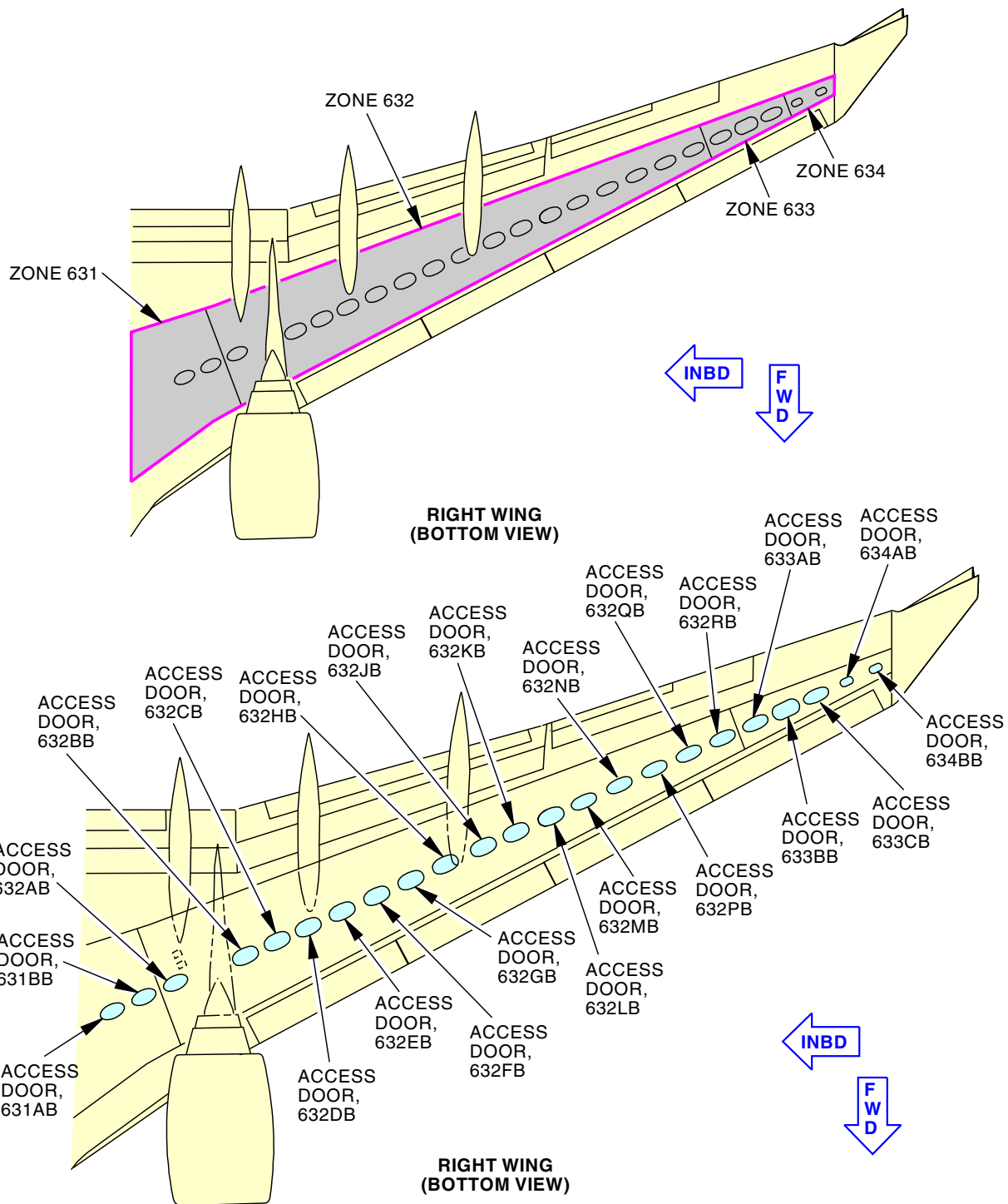
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2416525 S00061540987_V2

Right Outboard Wing Access Holes General Visual (Internal)
Figure 226/57-05-03-990-826

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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TASK 57-05-03-210-821

23. INTERNAL - GENERAL VISUAL: LEFT OUTBOARD WING

(Figure 227)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
28-11-31-000-801	Center Tank Access Door Removal (P/B 401)
28-11-31-400-801	Center Tank Access Door - Installation (P/B 401)
51-05-01-210-809	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
531	Left Wing - Center Fuel Tank, Rib 1 to Rib 5

C. Access Panels

Number	Name/Location
531AB	Center Tank Access Door - Wing Station 168
531BB	Center Tank Access Door - Wing Station 192

D. Inspection

SUBTASK 57-05-03-010-022

- (1) Open these access panels:

Number	Name/Location
531AB	Center Tank Access Door - Wing Station 168
531BB	Center Tank Access Door - Wing Station 192

- (a) Do this task: Center Tank Access Door Removal, TASK 28-11-31-000-801.

SUBTASK 57-05-03-210-021

- (2) Do a General Visual inspection of the inside left outboard wing from side of body Rib to Rib 5.
- (a) Side of body rib (including webs and stiffeners, upper rib chord, lower tee chord, splice fittings, terminal fittings at front and rear spars).
 - (b) Upper and lower surfaces (including skins; typical splice, vent and rail stringers; at drain installations; at attachments to front and rear spars; at attachments to shear tied ribs and support fittings).
 - (c) Front and rear spar chords, webs, stiffeners and rib posts.
 - (d) Shear tied and non-shear tied ribs.

SUBTASK 57-05-03-910-023

- (3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-809.

SUBTASK 57-05-03-410-022

- (4) Close these access panels:

Number	Name/Location
531AB	Center Tank Access Door - Wing Station 168
531BB	Center Tank Access Door - Wing Station 192

- (a) Do this task: Center Tank Access Door - Installation, TASK 28-11-31-400-801.

———— **END OF TASK** ————

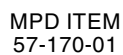
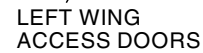
EFFECTIVITY
SIA ALL

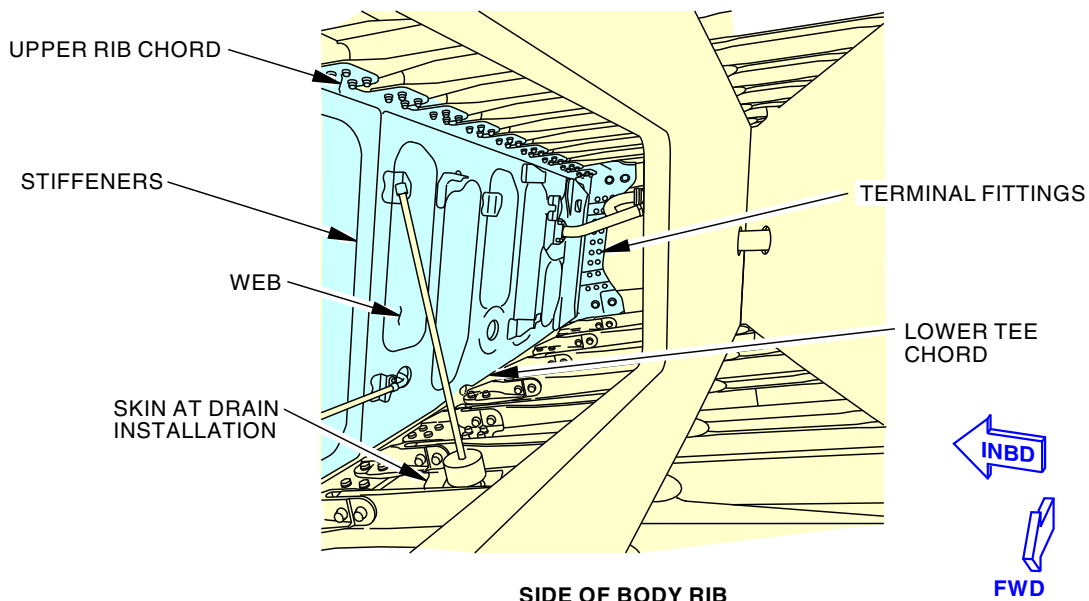
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

57-05-03

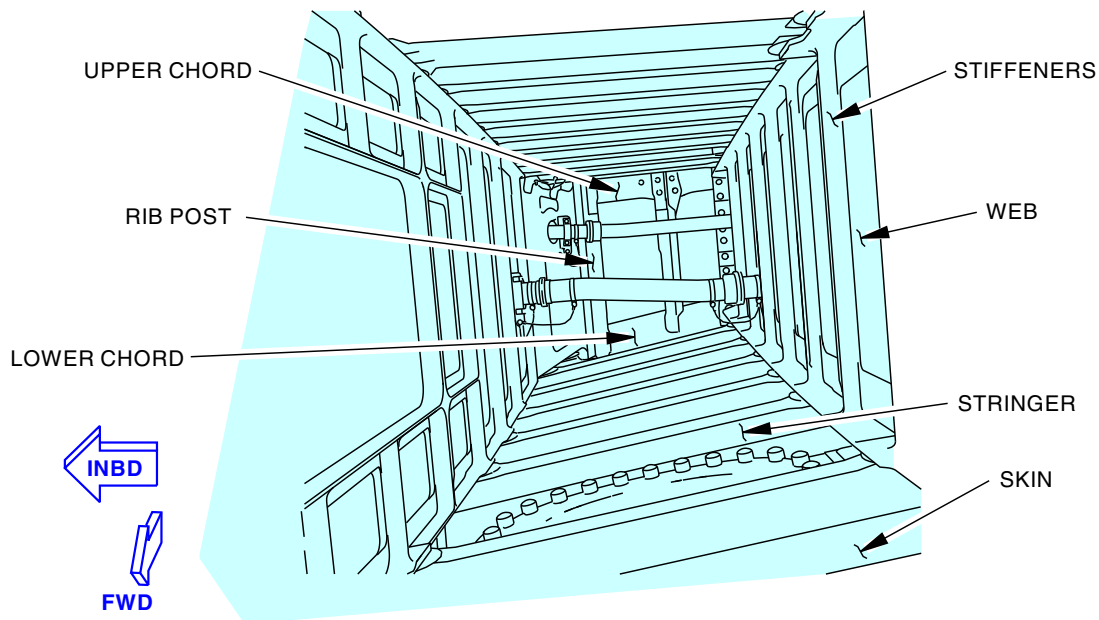
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SIDE OF BODY RIB

C



REAR SPAR

D

MPD ITEM
57-170-01

2416527 S00061540990_V1

INTERNAL-GENERAL VISUAL: INTERNAL LEFT OUTBOARD WING
Figure 227/57-05-03-990-827 (Sheet 2 of 2)

EFFECTIVITY
SIA ALL

57-05-03

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AIRCRAFT MAINTENANCE MANUAL

TASK 57-05-03-210-822

24. INTERNAL - GENERAL VISUAL: RIGHT OUTBOARD WING

(Figure 228)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
28-11-31-000-801	Center Tank Access Door Removal (P/B 401)
28-11-31-400-801	Center Tank Access Door - Installation (P/B 401)
51-05-01-210-809	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
631	Right Wing - Center Fuel Tank, Rib 1 to Rib 5

C. Access Panels

Number	Name/Location
631AB	Center Tank Access Door - Wing Station 168
631BB	Center Tank Access Door - Wing Station 192

D. Inspection

SUBTASK 57-05-03-010-023

- (1) Open these access panels:

Number	Name/Location
631AB	Center Tank Access Door - Wing Station 168
631BB	Center Tank Access Door - Wing Station 192

- (a) Do this task: Center Tank Access Door Removal, TASK 28-11-31-000-801.

SUBTASK 57-05-03-210-022

- (2) Do a General Visual inspection of the inside right outboard wing from side of body Rib to Rib 5.
- (a) Side of body rib (including webs and stiffeners, upper rib chord, lower tee chord, splice fittings, terminal fittings at front and rear spars).
 - (b) Upper and lower surfaces (including skins; typical splice, vent and rail stringers; at drain installations; at attachments to front and rear spars; at attachments to shear tied ribs and support fittings).
 - (c) Front and rear spar chords, webs, stiffeners and rib posts.
 - (d) Shear tied and non-shear tied ribs.

SUBTASK 57-05-03-910-024

- (3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-809.

SUBTASK 57-05-03-410-023

- (4) Close these access panels:

Number	Name/Location
631AB	Center Tank Access Door - Wing Station 168
631BB	Center Tank Access Door - Wing Station 192

- (a) Do this task: Center Tank Access Door - Installation, TASK 28-11-31-400-801.

————— **END OF TASK** —————

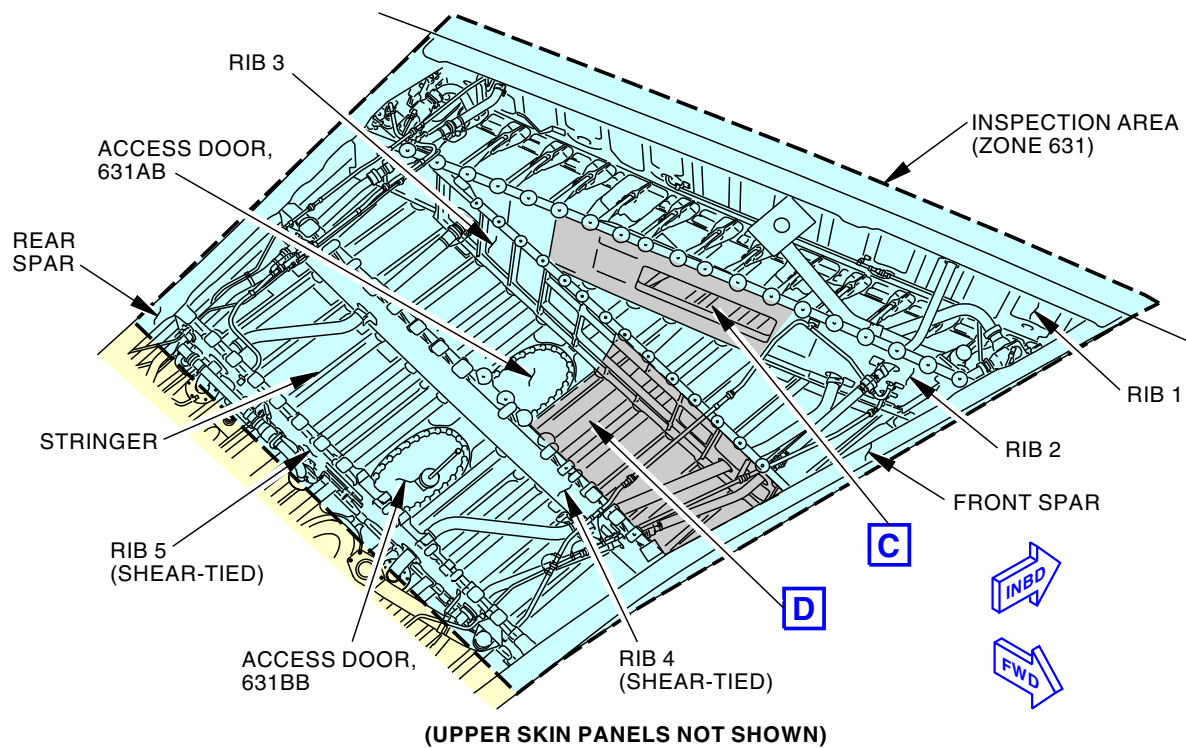
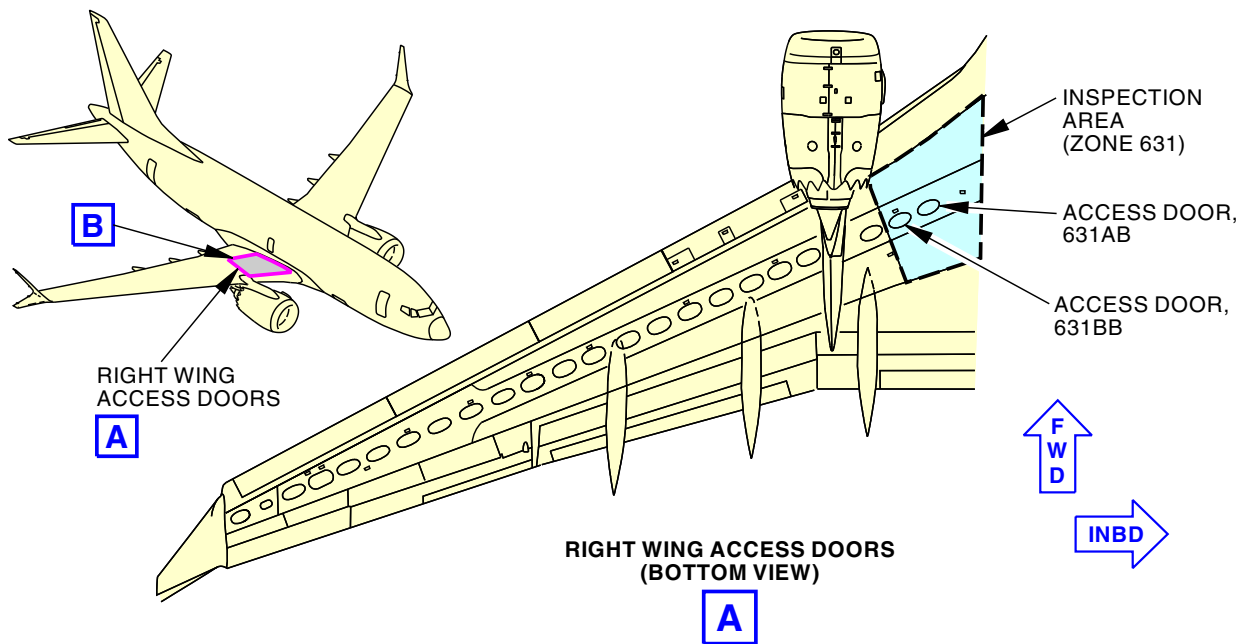
EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

57-05-03

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MPD ITEM
57-170-02

2416528 S00061540992_V2

INTERNAL - GENERAL VISUAL: RIGHT OUTBOARD WING
Figure 228/57-05-03-990-828 (Sheet 1 of 2)

EFFECTIVITY
SIA ALL

D633AM101-SIA

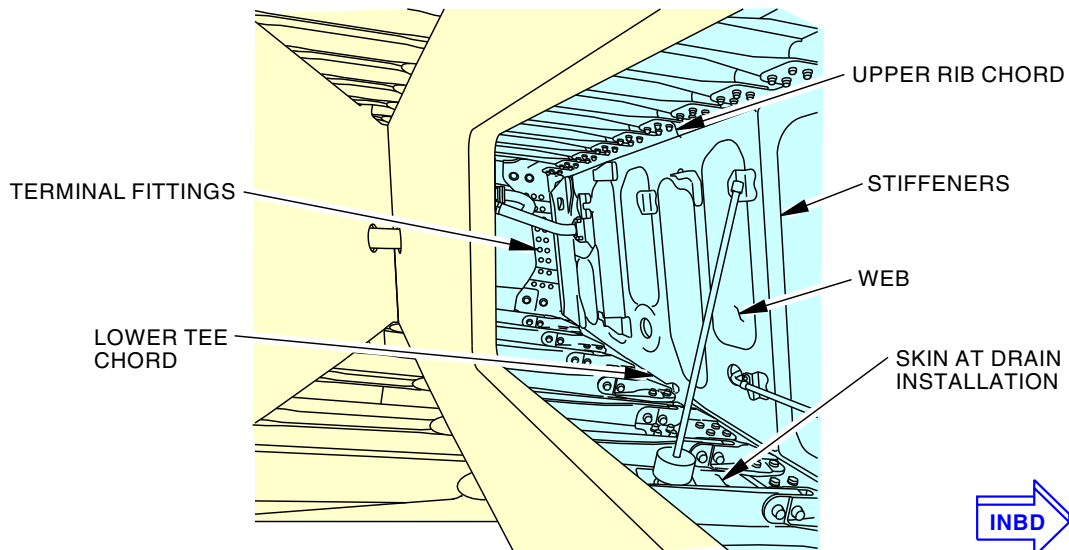
ECCN 9E991 BOEING PROPRIETARY - See title page for details

57-05-03

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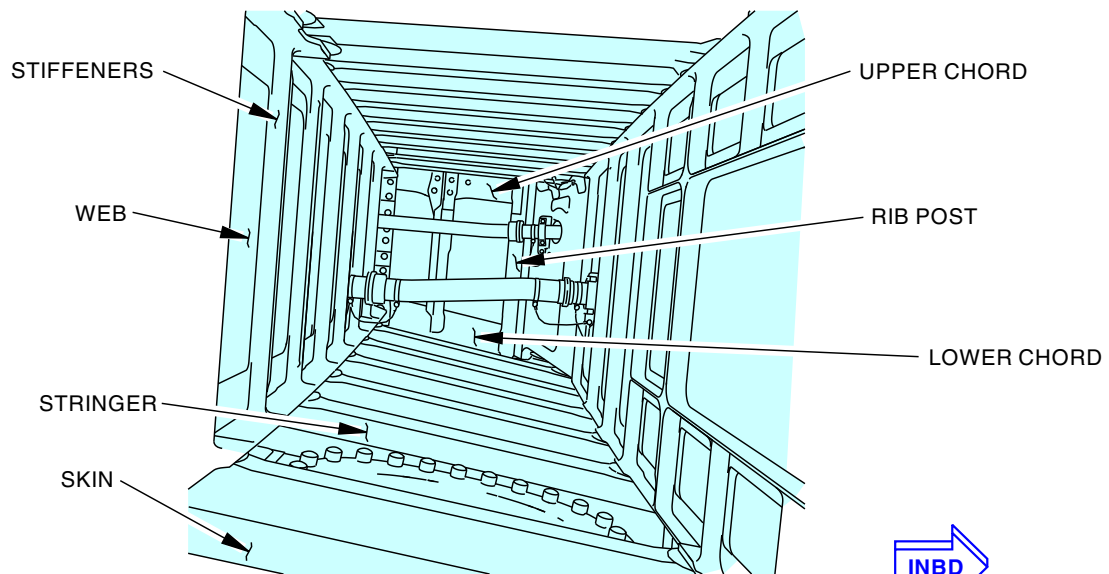


737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL



SIDE OF BODY RIB

C



REAR SPAR

D

MPD ITEM
57-170-02

2416529 S00061540993_V1

INTERNAL - GENERAL VISUAL: RIGHT OUTBOARD WING
Figure 228/57-05-03-990-828 (Sheet 2 of 2)

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL

TASK 57-05-03-210-823

25. **INTERNAL - GENERAL VISUAL: LEFT OUTBOARD WING**

(Figure 229)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-809	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
532	Left Wing - Main Tank, Rib 5 to Rib 22, Wing Station 204.25 to Wing BL 643.50

C. Access Panels

Number	Name/Location
532AB	Main Tank Access Door - Wing Station 216
532AZ	Main Tank Inner Access at Rib 6
532BB	Main Tank Access Door - Wing Station 265
532BZ	Main Tank Inner Access at Rib 6
532CB	Main Tank Access Door - Wing Station 290
532DB	Main Tank Access Door - Wing Station 313
532EB	Main Tank Access Door - Wing Station 337
532FB	Main Tank Access Door - Wing Station 367
532GB	Main Tank Access Door - Wing Station 390
532HB	Main Tank Access Door - Wing Station 417
532JB	Main Tank Access Door - Wing Station 443
532KB	Main Tank Access Door - Wing Station 470
532LB	Main Tank Access Door - Wing Station 496
532MB	Main Tank Access Door - Wing Station 523
532NB	Main Tank Access Door - Wing Station 549
532PB	Main Tank Access Door - Wing Station 576
532QB	Main Tank Access Door - Wing Station 602
532RB	Main Tank Access Door - Wing Station 629
S5321	Left Outboard Internal Wing Inspection

D. Inspection

SUBTASK 57-05-03-010-024

(1) Open these access panels:

Number	Name/Location
532AB	Main Tank Access Door - Wing Station 216
532AZ	Main Tank Inner Access at Rib 6
532BB	Main Tank Access Door - Wing Station 265
532BZ	Main Tank Inner Access at Rib 6
532CB	Main Tank Access Door - Wing Station 290
532DB	Main Tank Access Door - Wing Station 313
532EB	Main Tank Access Door - Wing Station 337
532FB	Main Tank Access Door - Wing Station 367
532GB	Main Tank Access Door - Wing Station 390

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL

(Continued)

<u>Number</u>	<u>Name/Location</u>
532HB	Main Tank Access Door - Wing Station 417
532JB	Main Tank Access Door - Wing Station 443
532KB	Main Tank Access Door - Wing Station 470
532LB	Main Tank Access Door - Wing Station 496
532MB	Main Tank Access Door - Wing Station 523
532NB	Main Tank Access Door - Wing Station 549
532PB	Main Tank Access Door - Wing Station 576
532QB	Main Tank Access Door - Wing Station 602
532RB	Main Tank Access Door - Wing Station 629

Special Access:

<u>Number</u>	<u>Name/Location</u>
S5321	Left Outboard Internal Wing Inspection

NOTE: Do not remove 532AZ and 532BZ access doors at the same time.

SUBTASK 57-05-03-210-023

- (2) Do a General Visual inspection of the left outboard wing from Rib 5 to Rib 22.
- (a) Upper and lower surfaces (including skins; typical splice, vent and rail stringers; at attachments to front and rear spars; at attachments to shear tied ribs and support fittings; at attachment to nacelle fittings; at drain installations).
 - (b) Front spar chords, webs, stiffeners and rib posts, including at nacelle fitting attachments.
 - (c) Rear spar chords, webs, stiffeners and rib posts, flap track support fittings, including rear spar at major fitting attachments.
 - (d) Shear tied and non-shear tied ribs (including Rib 6 structural doors, Ribs 6 and 7 at nacelle support fittings, Ribs 10 and 14 at flap track support fittings).
 - (e) Nacelle support fittings (R2 backup link, R4 back up link, R7/8 backup fitting).

SUBTASK 57-05-03-910-025

- (3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-809.

SUBTASK 57-05-03-410-024

- (4) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
532AB	Main Tank Access Door - Wing Station 216
532AZ	Main Tank Inner Access at Rib 6
532BB	Main Tank Access Door - Wing Station 265
532BZ	Main Tank Inner Access at Rib 6
532CB	Main Tank Access Door - Wing Station 290
532DB	Main Tank Access Door - Wing Station 313
532EB	Main Tank Access Door - Wing Station 337
532FB	Main Tank Access Door - Wing Station 367
532GB	Main Tank Access Door - Wing Station 390
532HB	Main Tank Access Door - Wing Station 417
532JB	Main Tank Access Door - Wing Station 443
532KB	Main Tank Access Door - Wing Station 470
532LB	Main Tank Access Door - Wing Station 496
532MB	Main Tank Access Door - Wing Station 523

EFFECTIVITY
SIA ALL

57-05-03

D633AM101-SIA

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AIRCRAFT MAINTENANCE MANUAL

(Continued)

<u>Number</u>	<u>Name/Location</u>
532NB	Main Tank Access Door - Wing Station 549
532PB	Main Tank Access Door - Wing Station 576
532QB	Main Tank Access Door - Wing Station 602
532RB	Main Tank Access Door - Wing Station 629

———— **END OF TASK** ————

EFFECTIVITY
SIA ALL

D633AM101-SIA

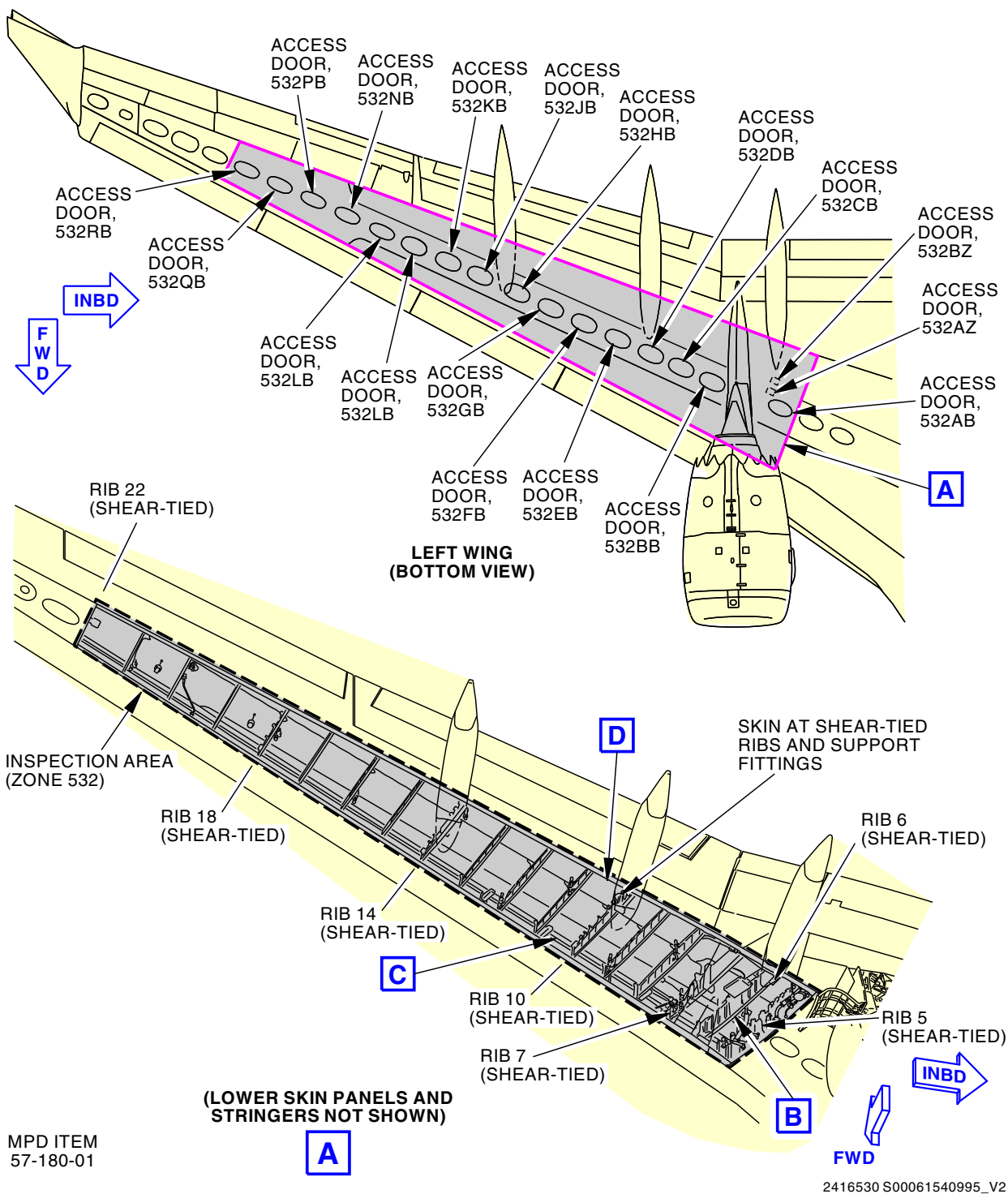
ECCN 9E991 BOEING PROPRIETARY - See title page for details

57-05-03

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AIRCRAFT MAINTENANCE MANUAL



INTERNAL-GENERAL VISUAL: LEFT OUTBOARD WING
Figure 229/57-05-03-990-829 (Sheet 1 of 3)

EFFECTIVITY
SIA ALL

D633AM101-SIA

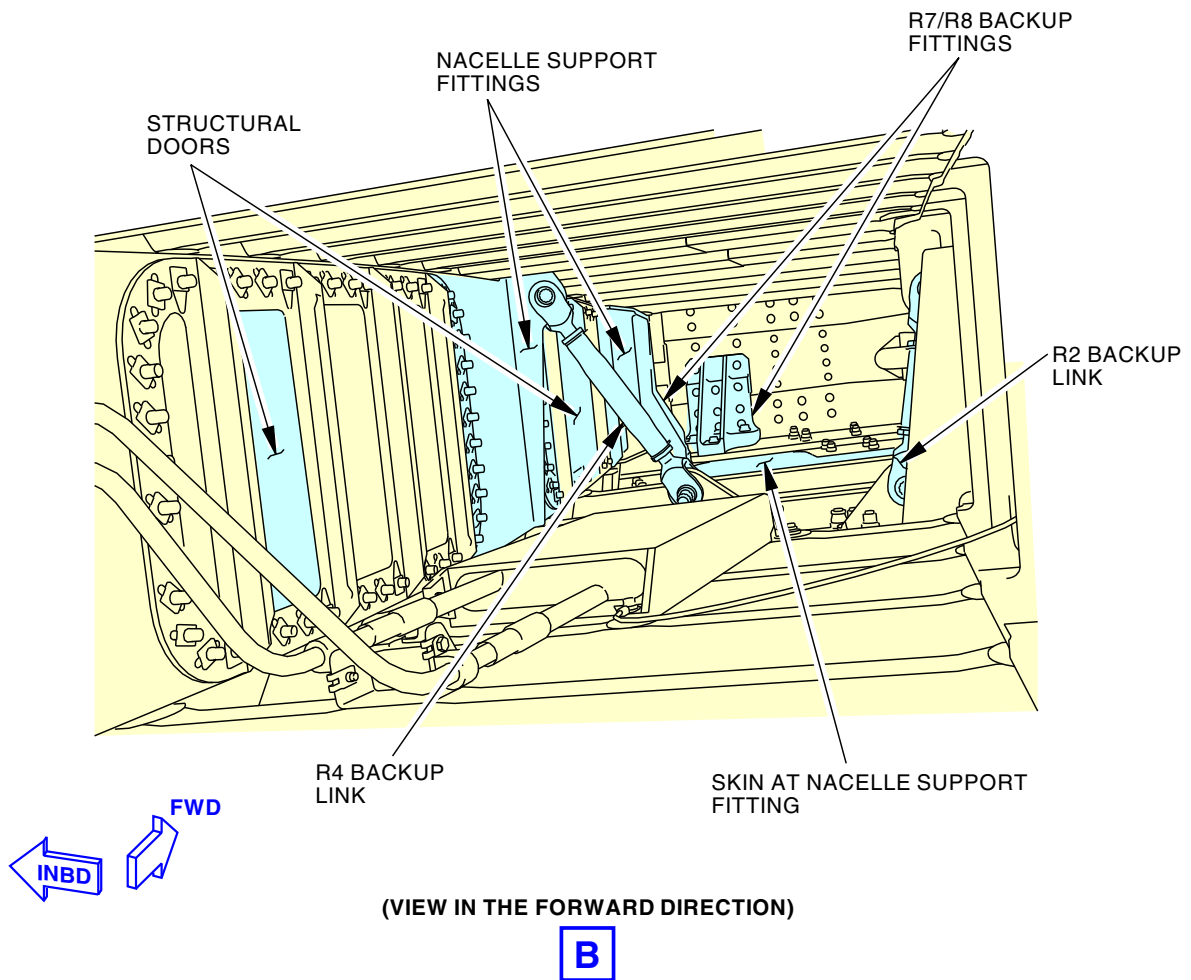
ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL



MPD ITEM
57-180-01

2416531 S00061540996_V1

INTERNAL-GENERAL VISUAL: LEFT OUTBOARD WING
Figure 229/57-05-03-990-829 (Sheet 2 of 3)

EFFECTIVITY
SIA ALL

D633AM101-SIA

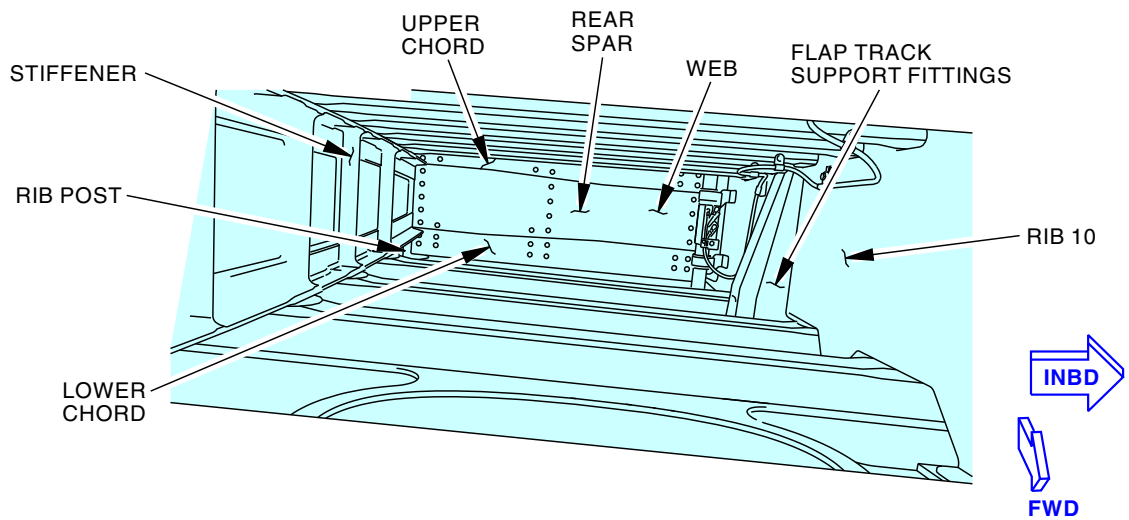
ECCN 9E991 BOEING PROPRIETARY - See title page for details

57-05-03

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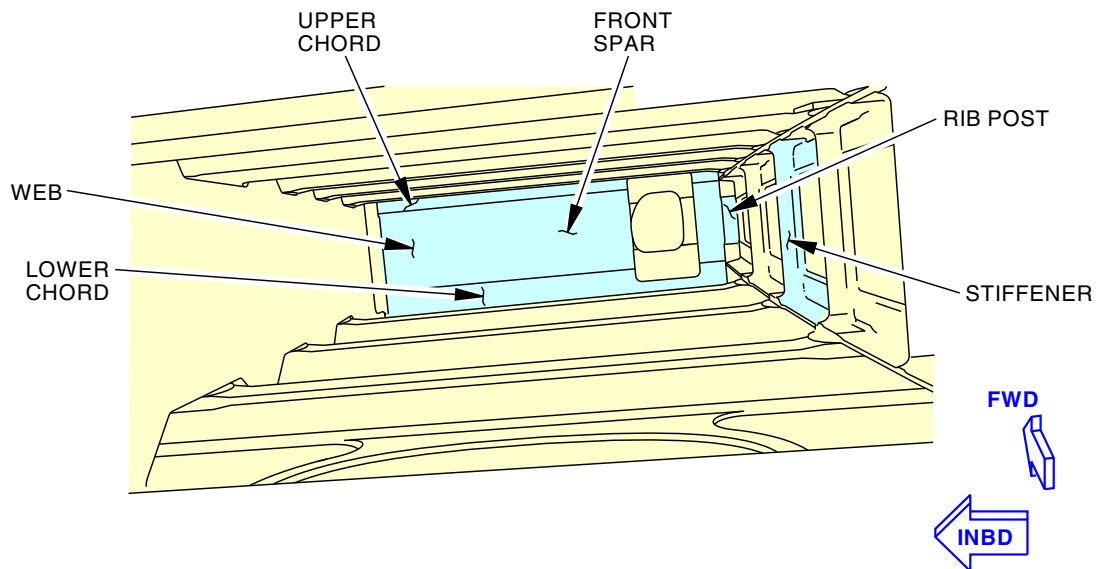


737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL



(RIB 14 IS EQUIVALENT)

C



MPD ITEM
57-180-01

D

2416532 S00061540997_V1

INTERNAL-GENERAL VISUAL: LEFT OUTBOARD WING
Figure 229/57-05-03-990-829 (Sheet 3 of 3)

EFFECTIVITY
SIA ALL

57-05-03

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D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details



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AIRCRAFT MAINTENANCE MANUAL

TASK 57-05-03-210-824

26. **INTERNAL - GENERAL VISUAL: RIGHT OUTBOARD WING**

(Figure 230)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-809	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
632	Right Wing - Main Tank, Rib 5 to Rib 22, Wing Station 204.25 to Wing Station 643.50

C. Access Panels

Number	Name/Location
632AB	Main Tank Access Door - Wing Station 216
632AZ	Main Tank Inner Access at Rib 6
632BB	Main Tank Access Door - Wing Station 265
632BZ	Main Tank Inner Access at Rib 6
632CB	Main Tank Access Door - Wing Station 290
632DB	Main Tank Access Door - Wing Station 313
632EB	Main Tank Access Door - Wing Station 337
632FB	Main Tank Access Door - Wing Station 367
632GB	Main Tank Access Door - Wing Station 390
632HB	Main Tank Access Door - Wing Station 417
632JB	Main Tank Access Door - Wing Station 443
632KB	Main Tank Access Door - Wing Station 470
632LB	Main Tank Access Door - Wing Station 496
632MB	Main Tank Access Door - Wing Station 523
632NB	Main Tank Access Door - Wing Station 549
632PB	Main Tank Access Door - Wing Station 576
632QB	Main Tank Access Door - Wing Station 602
632RB	Main Tank Access Door - Wing Station 629
S6321	Right Outboard Internal Wing Inspection

D. Inspection

SUBTASK 57-05-03-010-025

(1) Open these access panels:

Number	Name/Location
632AB	Main Tank Access Door - Wing Station 216
632AZ	Main Tank Inner Access at Rib 6
632BB	Main Tank Access Door - Wing Station 265
632BZ	Main Tank Inner Access at Rib 6
632CB	Main Tank Access Door - Wing Station 290
632DB	Main Tank Access Door - Wing Station 313
632EB	Main Tank Access Door - Wing Station 337
632FB	Main Tank Access Door - Wing Station 367

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

57-05-03

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AIRCRAFT MAINTENANCE MANUAL

(Continued)

<u>Number</u>	<u>Name/Location</u>
632GB	Main Tank Access Door - Wing Station 390
632HB	Main Tank Access Door - Wing Station 417
632JB	Main Tank Access Door - Wing Station 443
632KB	Main Tank Access Door - Wing Station 470
632LB	Main Tank Access Door - Wing Station 496
632MB	Main Tank Access Door - Wing Station 523
632NB	Main Tank Access Door - Wing Station 549
632PB	Main Tank Access Door - Wing Station 576
632QB	Main Tank Access Door - Wing Station 602
632RB	Main Tank Access Door - Wing Station 629

Special Access:

<u>Number</u>	<u>Name/Location</u>
S6321	Right Outboard Internal Wing Inspection

NOTE: Do not remove the 632AZ and 632BZ access doors at the same time.

SUBTASK 57-05-03-210-024

- (2) Do a General Visual inspection of the inside right outboard wing from Rib 5 to Rib 22.
- (a) Upper and lower surfaces (including skins; typical splice, vent and rail stringers; at attachments to front and rear spars; at attachments to shear tied ribs and support fittings; at attachment to nacelle fittings; at drain installations).
 - (b) Front spar chords, webs, stiffeners and rib posts, including at nacelle fitting attachments.
 - (c) Rear spar chords, webs, stiffeners and rib posts, flap track support fittings, including rear spar at major fitting attachments.
 - (d) Shear tied and non-shear tied ribs (including Rib 6 structural doors, Ribs 6 and 7 at nacelle support fittings, Ribs 10 and 14 at flap track support fittings).
 - (e) Nacelle support fittings (R2 backup link, R4 back up link, R7/8 backup fitting).

SUBTASK 57-05-03-910-026

- (3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-809.

SUBTASK 57-05-03-410-025

- (4) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
632AB	Main Tank Access Door - Wing Station 216
632AZ	Main Tank Inner Access at Rib 6
632BB	Main Tank Access Door - Wing Station 265
632BZ	Main Tank Inner Access at Rib 6
632CB	Main Tank Access Door - Wing Station 290
632DB	Main Tank Access Door - Wing Station 313
632EB	Main Tank Access Door - Wing Station 337
632FB	Main Tank Access Door - Wing Station 367
632GB	Main Tank Access Door - Wing Station 390
632HB	Main Tank Access Door - Wing Station 417
632JB	Main Tank Access Door - Wing Station 443
632KB	Main Tank Access Door - Wing Station 470
632LB	Main Tank Access Door - Wing Station 496

EFFECTIVITY
SIA ALL

D633AM101-SIA

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AIRCRAFT MAINTENANCE MANUAL

(Continued)

<u>Number</u>	<u>Name/Location</u>
632MB	Main Tank Access Door - Wing Station 523
632NB	Main Tank Access Door - Wing Station 549
632PB	Main Tank Access Door - Wing Station 576
632QB	Main Tank Access Door - Wing Station 602
632RB	Main Tank Access Door - Wing Station 629

———— **END OF TASK** ————

EFFECTIVITY
SIA ALL

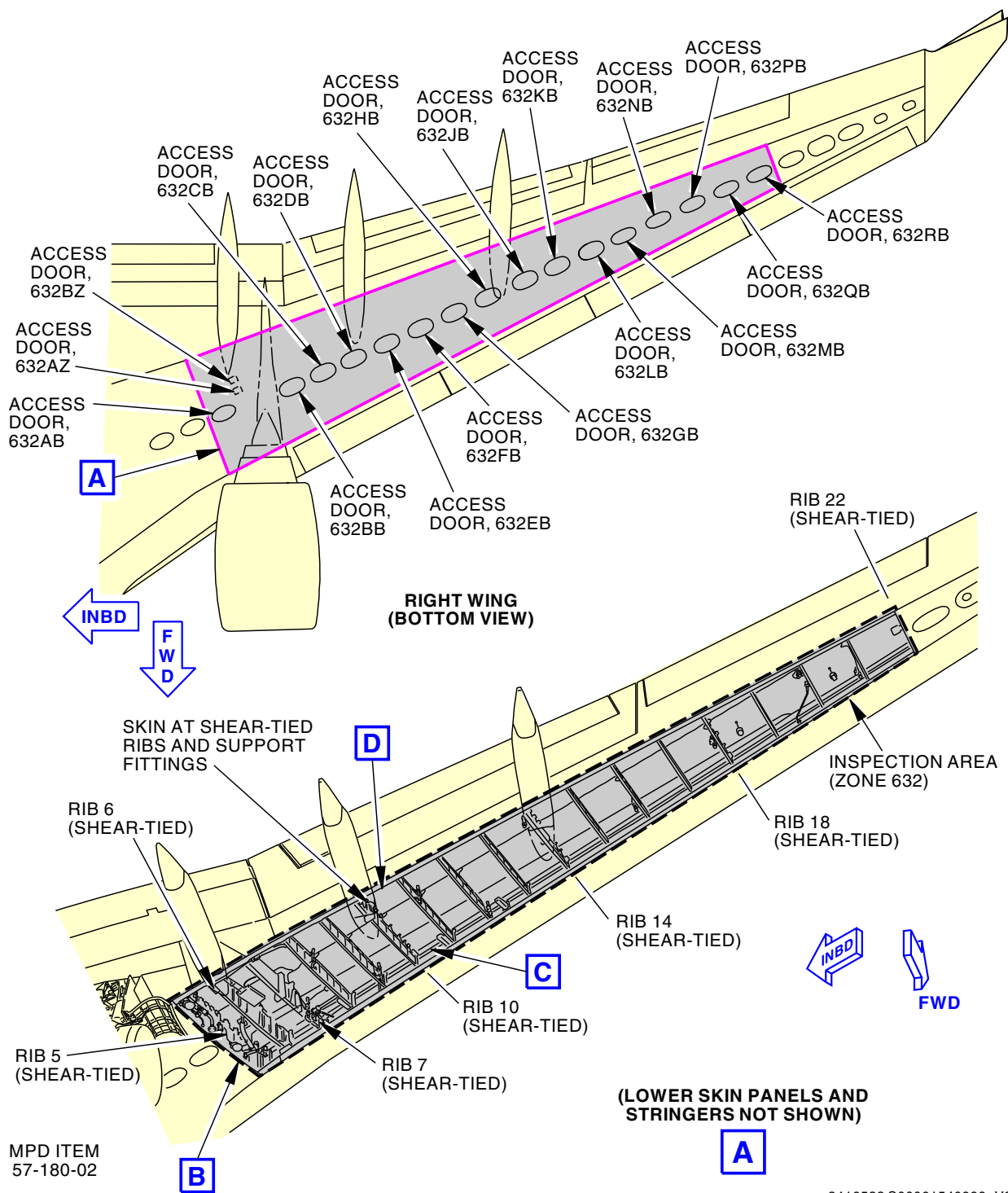
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

57-05-03

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737-7/8/8200/9/10
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2416533 S00061540999_V3

INTERNAL-GENERAL VISUAL: RIGHT OUTBOARD WING
Figure 230/57-05-03-990-830 (Sheet 1 of 3)

EFFECTIVITY
SIA ALL

D633AM101-SIA

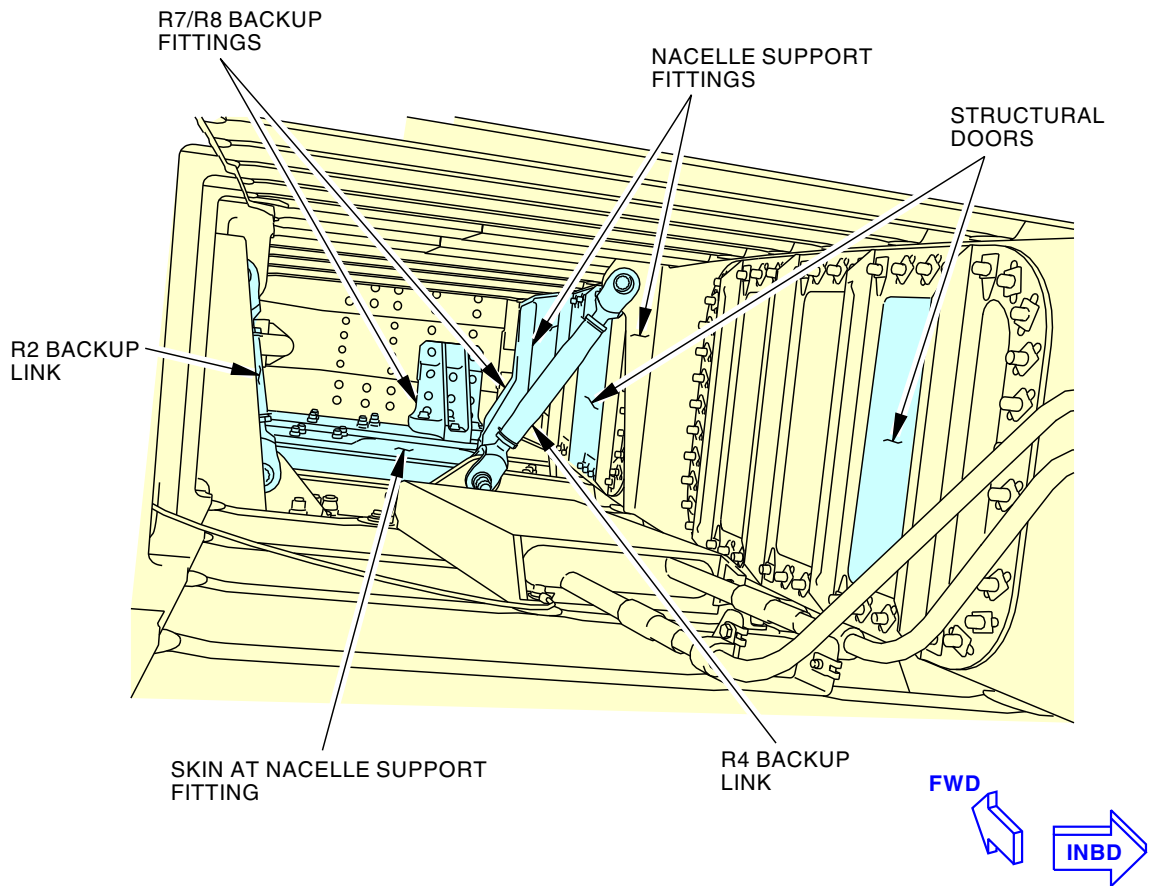
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AIRCRAFT MAINTENANCE MANUAL



(VIEW IN THE FORWARD DIRECTION)

B

MPD ITEM
57-180-02

2416534 S00061541000_V1

INTERNAL-GENERAL VISUAL: RIGHT OUTBOARD WING
Figure 230/57-05-03-990-830 (Sheet 2 of 3)

EFFECTIVITY
SIA ALL

D633AM101-SIA

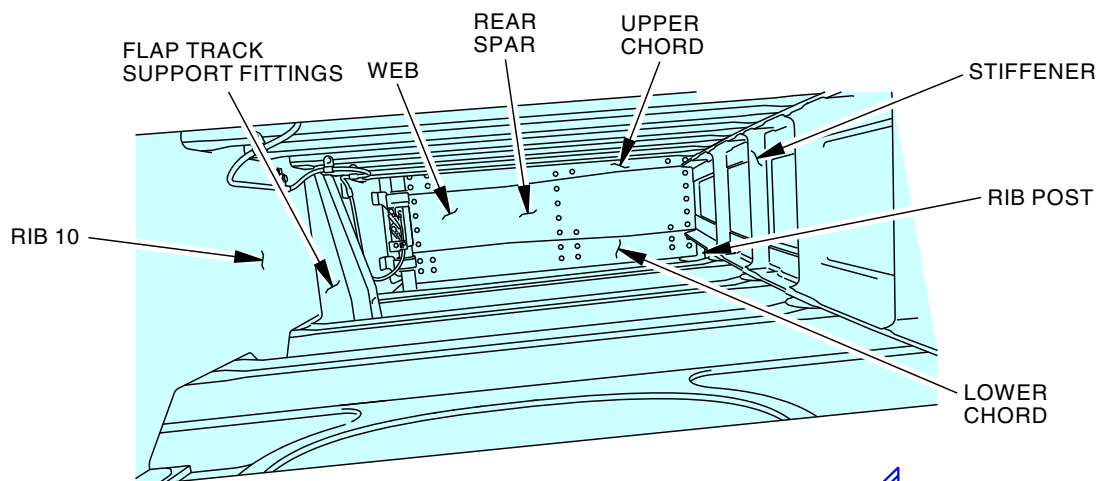
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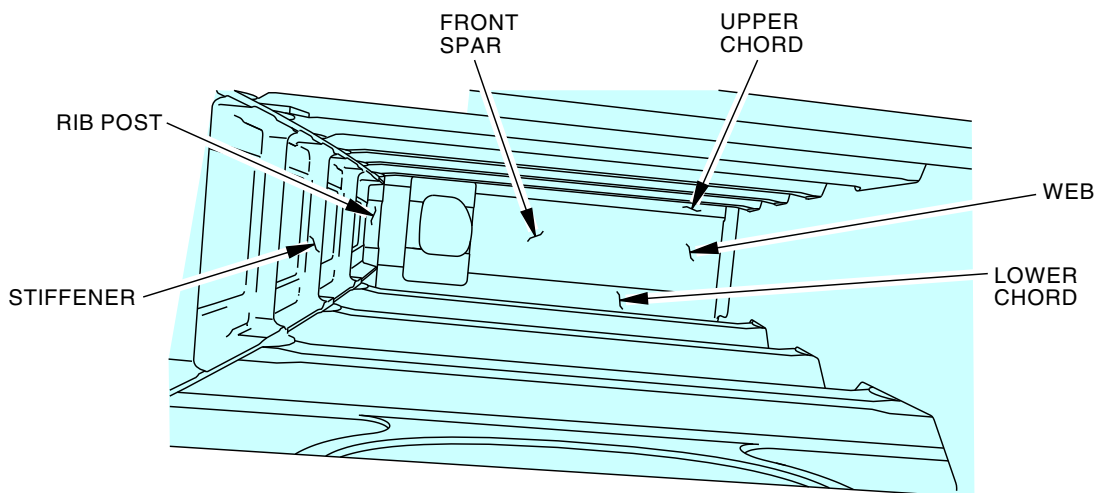


737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL



(RIB 14 IS EQUIVALENT)

C



MPD ITEM
57-180-02

D

2416535 S00061541001_V1

INTERNAL-GENERAL VISUAL: RIGHT OUTBOARD WING
Figure 230/57-05-03-990-830 (Sheet 3 of 3)

EFFECTIVITY
SIA ALL

57-05-03

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL

TASK 57-05-03-210-825

27. INTERNAL - GENERAL VISUAL: LEFT OUTBOARD WING

(Figure 231)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
28-11-11-000-802	Surge Tank Access Door Removal (P/B 401)
28-11-11-400-802	Surge Tank Access Door (533AB, 533CB, 633AB, 633CB) Installation (P/B 401)
28-11-11-400-803	Surge tank Access Door (533BB, 633BB) Installation (P/B 401)
51-05-01-210-806	737-7/8/8200/9 Basic Task Description (P/B 201)
57-31-23-000-801	Dry Bay Access Doors Removal (P/B 401)
57-31-23-400-801	Dry Bay Access Doors Installation (P/B 401)

B. Location Zones

Zone	Area
533	Left Wing - Surge Tank, Rib 22 to Rib 25, Wing Station 643.50 to Wing BL 616.75
534	Left Wing - Dry Bay

C. Access Panels

Number	Name/Location
533AB	Surge Tank Access Door - Wing Station 655
533BB	Surge Tank Access Door - Wing Station 679
533CB	Surge Tank Access Door - Wing Station 703
534AB	Dry Bay Tank Access Door - Left Wing Station 727
534BB	Dry Bay Tank Access Door - Left Wing Station 748

D. Inspection of the Left Outboard Wing

SUBTASK 57-05-03-010-026

- (1) Open these access panels:

(TASK 28-11-11-000-802, TASK 57-31-23-000-801)

Number	Name/Location
533AB	Surge Tank Access Door - Wing Station 655
533BB	Surge Tank Access Door - Wing Station 679
533CB	Surge Tank Access Door - Wing Station 703
534AB	Dry Bay Tank Access Door - Left Wing Station 727
534BB	Dry Bay Tank Access Door - Left Wing Station 748

SUBTASK 57-05-03-210-025

- (2) Do a General Visual inspection of the inside left outboard wing surge tank and dry bay (from Rib 22 to Rib 27), including upper and lower skins, stringers, front and rear spars, rib posts, WBL 656.17 closure rib (if provisioned for winglets, L/N 778 and on), shear tied and non-shear tied ribs, and access holes.

SUBTASK 57-05-03-910-027

- (3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 57-05-03-410-026

- (4) Close these access panels:

(TASK 28-11-11-400-802, TASK 28-11-11-400-803, TASK 57-31-23-400-801)

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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<u>Number</u>	<u>Name/Location</u>
533AB	Surge Tank Access Door - Wing Station 655
533BB	Surge Tank Access Door - Wing Station 679
533CB	Surge Tank Access Door - Wing Station 703
534AB	Dry Bay Tank Access Door - Left Wing Station 727
534BB	Dry Bay Tank Access Door - Left Wing Station 748

———— **END OF TASK** ————

EFFECTIVITY
SIA ALL

D633AM101-SIA

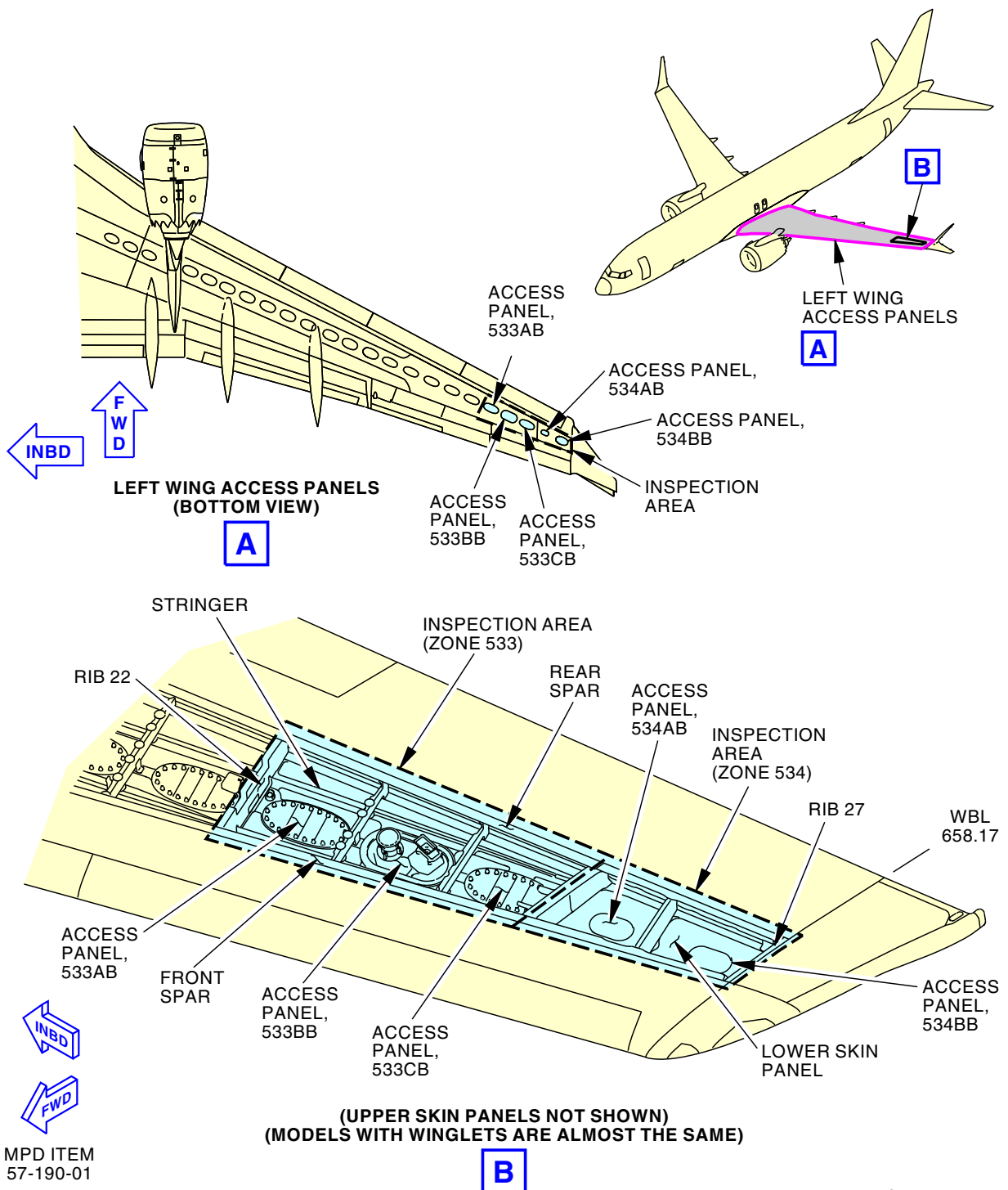
ECCN 9E991 BOEING PROPRIETARY - See title page for details

57-05-03

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737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL



2416536 S00061541003_V1

INTERNAL-GENERAL VISUAL: INTERNAL-LEFT OUTBOARD WING
Figure 231/57-05-03-990-831

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL

TASK 57-05-03-210-826

28. INTERNAL - GENERAL VISUAL: RIGHT OUTBOARD WING

(Figure 232)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
28-11-11-000-802	Surge Tank Access Door Removal (P/B 401)
28-11-11-400-802	Surge Tank Access Door (533AB, 533CB, 633AB, 633CB) Installation (P/B 401)
28-11-11-400-803	Surge tank Access Door (533BB, 633BB) Installation (P/B 401)
51-05-01-210-806	737-7/8/8200/9 Basic Task Description (P/B 201)
57-31-23-000-801	Dry Bay Access Doors Removal (P/B 401)
57-31-23-400-801	Dry Bay Access Doors Installation (P/B 401)

B. Location Zones

Zone	Area
633	Right Wing - Surge Tank, Rib 22 to Rib 25, Wing Station 643.50 to Wing Buttock Line 616.75
634	Right Wing - Dry Bay

C. Access Panels

Number	Name/Location
633AB	Surge Tank Access Door - Wing Station 655
633BB	Surge Tank Access Door - Wing Station 679
633CB	Surge Tank Access Door - Wing Station 703
634AB	Dry Bay Tank Access Door - Right Wing Station 727
634BB	Dry Bay Tank Access Door - Right Wing Station 748

D. Inspection of the Right Outboard Wing

SUBTASK 57-05-03-010-027

- (1) Open these access panels:

(TASK 28-11-11-000-802, TASK 57-31-23-000-801)

Number	Name/Location
633AB	Surge Tank Access Door - Wing Station 655
633BB	Surge Tank Access Door - Wing Station 679
633CB	Surge Tank Access Door - Wing Station 703
634AB	Dry Bay Tank Access Door - Right Wing Station 727
634BB	Dry Bay Tank Access Door - Right Wing Station 748

SUBTASK 57-05-03-210-026

- (2) Do a General Visual inspection of the inside right outboard wing surge tank and dry bay (from Rib 22 to Rib 27), including upper and lower skins, stringers, front and rear spars, rib posts, WBL 656.17 closure rib (if provisioned for winglets, L/N 778 and on), shear tied and non-shear tied ribs, and access holes.

SUBTASK 57-05-03-910-028

- (3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-806.

EFFECTIVITY
SIA ALL

D633AM101-SIA

57-05-03

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737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL

SUBTASK 57-05-03-410-027

(4) Close these access panels:

(TASK 28-11-11-400-802, TASK 28-11-11-400-803, TASK 57-31-23-400-801)

<u>Number</u>	<u>Name/Location</u>
633AB	Surge Tank Access Door - Wing Station 655
633BB	Surge Tank Access Door - Wing Station 679
633CB	Surge Tank Access Door - Wing Station 703
634AB	Dry Bay Tank Access Door - Right Wing Station 727
634BB	Dry Bay Tank Access Door - Right Wing Station 748

———— **END OF TASK** ————

EFFECTIVITY
SIA ALL

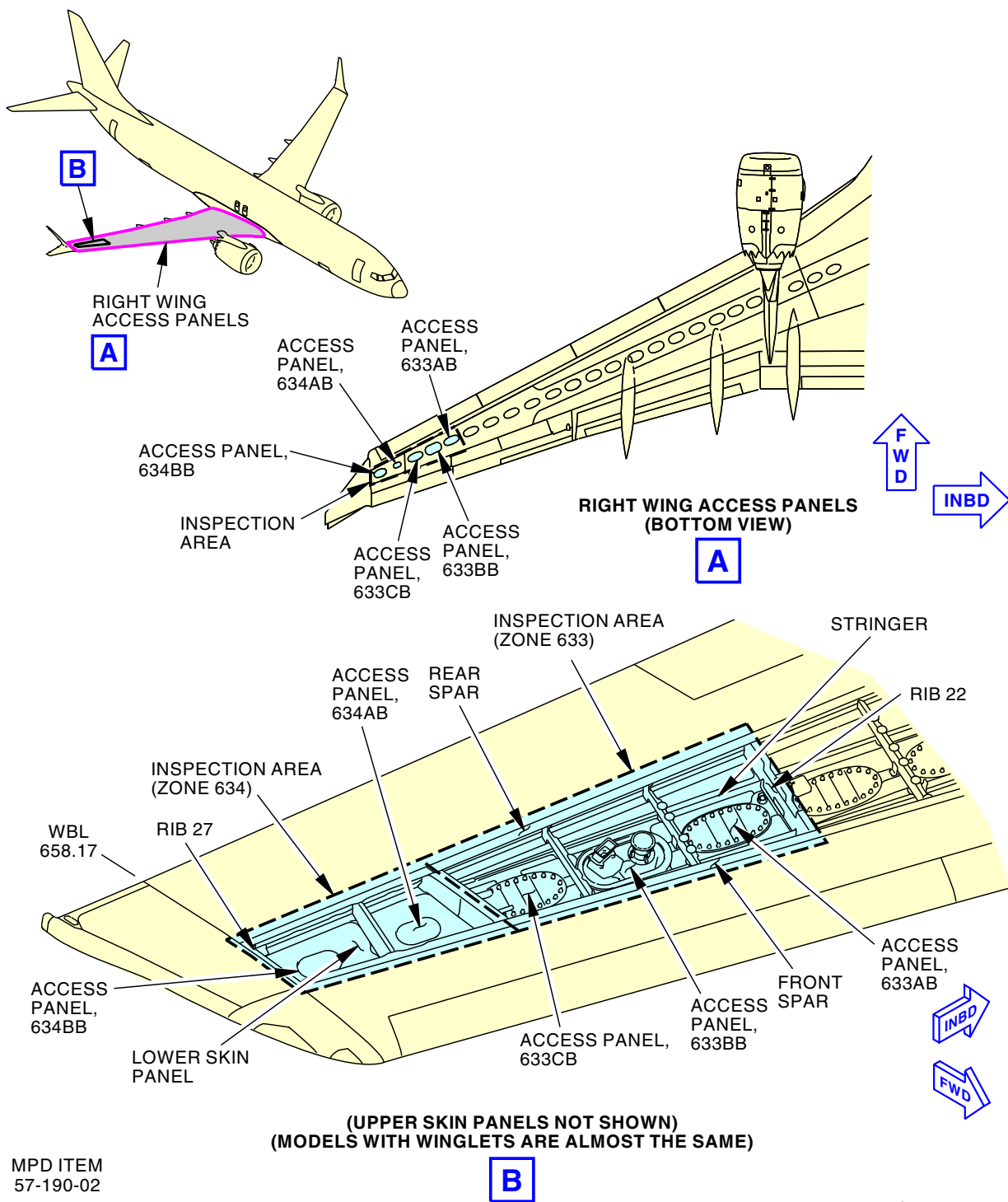
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL



MPD ITEM
57-190-02

2416537 S00061541005_V1

INTERNAL-GENERAL VISUAL: RIGHT OUTBOARD WING
Figure 232/57-05-03-990-832

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL

TASK 57-05-03-210-827

29. **INTERNAL - GENERAL VISUAL: LEFT FLAP SUPPORT NO. 4**

(Figure 233)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-802	737-7/8/8200/9 Basic Task Description (P/B 201)
53-51-21-000-803	Aft Wing-To-Body Fairing Panel Removal (P/B 401)
53-51-21-400-803	Aft Wing-To-Body Fairing Panel - Installation (P/B 401)

B. Location Zones

Zone	Area
541	Left Wing - Fairing Flap Support No. 4

C. Access Panels

Number	Name/Location
194BL	Flap Track Lubrication Panel - Aft

D. Inspection

SUBTASK 57-05-03-010-028

- (1) Open this access panel:

Number	Name/Location
194BL	Flap Track Lubrication Panel - Aft

- (a) To open access panel 194BL, refer to task: Aft Wing-To-Body Fairing Panel Removal, TASK 53-51-21-000-803.

- (2) Remove flap drive lube access door and access door from MLG wheel well.

SUBTASK 57-05-03-910-029

- (3) Do a General Visual inspection of the left inboard flap inboard track assembly, carriage assembly, forward fitting assembly, aft link and aft link pins. Normal overhaul procedures, applied with the flap track assemblies, carriage assemblies and forward fitting assemblies removed, at intervals not exceeding 10 years, are adequate to maintain corrosion at safe levels on these components.

SUBTASK 57-05-03-910-029

- (4) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-802.

SUBTASK 57-05-03-410-028

- (5) Close this access panel:

Number	Name/Location
194BL	Flap Track Lubrication Panel - Aft

- (a) To close access panel 194BL, refer to task: Aft Wing-To-Body Fairing Panel - Installation, TASK 53-51-21-400-803.

————— **END OF TASK** —————

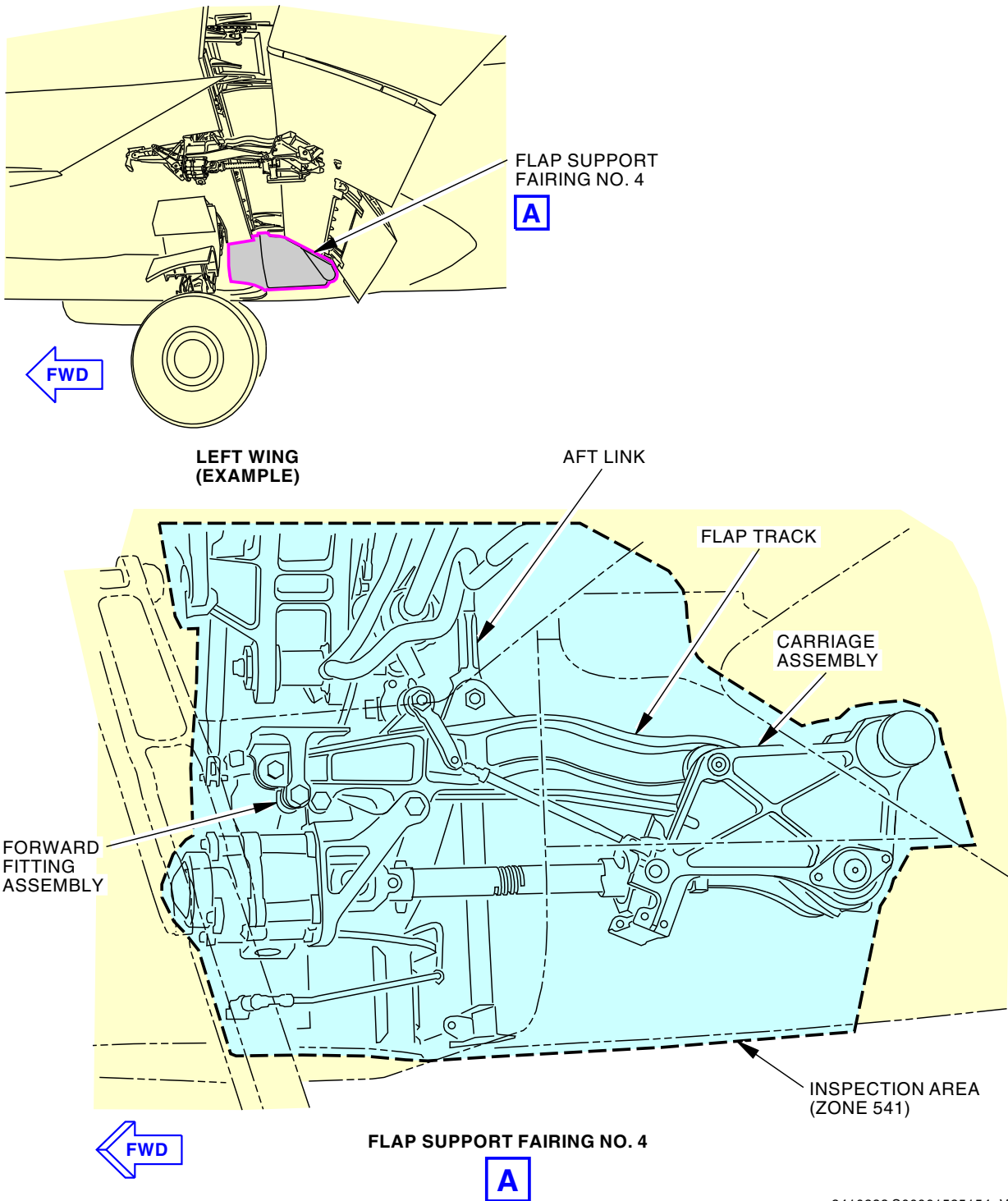
EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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2410233 S00061525154_V3

Flap Support Fairing No. 4 General Visual (Internal)
Figure 233/57-05-03-990-833

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL

TASK 57-05-03-210-828

30. **INTERNAL - GENERAL VISUAL: RIGHT FLAP SUPPORT NO. 5**

(Figure 234)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-802	737-7/8/8200/9 Basic Task Description (P/B 201)
53-51-21-000-803	Aft Wing-To-Body Fairing Panel Removal (P/B 401)
53-51-21-400-803	Aft Wing-To-Body Fairing Panel - Installation (P/B 401)

B. Location Zones

Zone	Area
641	Right Wing - Fairing Flap Support No. 5

C. Access Panels

Number	Name/Location
193CR	Wheel Well Panel - Aft Outboard
194BR	Flap Track Lubrication Panel - Aft
194CR	Aft Wing To Body Fairing Panel

D. Inspection

SUBTASK 57-05-03-010-029

- (1) Open these access panels:

Number	Name/Location
193CR	Wheel Well Panel - Aft Outboard
194BR	Flap Track Lubrication Panel - Aft
194CR	Aft Wing To Body Fairing Panel

- (a) To open access panel 194BR, refer to task:Aft Wing-To-Body Fairing Panel Removal, TASK 53-51-21-000-803.

SUBTASK 57-05-03-210-028

- (2) Do a General Visual inspection of the right inboard flap inboard track assembly, carriage assembly, forward fitting assembly, aft link and aft link pins. Normal overhaul procedures, applied with the flap track assemblies, carriage assemblies and forward fitting assemblies removed, at intervals not exceeding 10 years, are adequate to maintain corrosion at safe levels on these components.

SUBTASK 57-05-03-910-030

- (3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-802.

SUBTASK 57-05-03-410-029

- (4) Close these access panels:

Number	Name/Location
193CR	Wheel Well Panel - Aft Outboard
194BR	Flap Track Lubrication Panel - Aft
194CR	Aft Wing To Body Fairing Panel

- (a) To close access panel 194BR, refer to task:Aft Wing-To-Body Fairing Panel - Installation, TASK 53-51-21-400-803.

————— **END OF TASK** —————

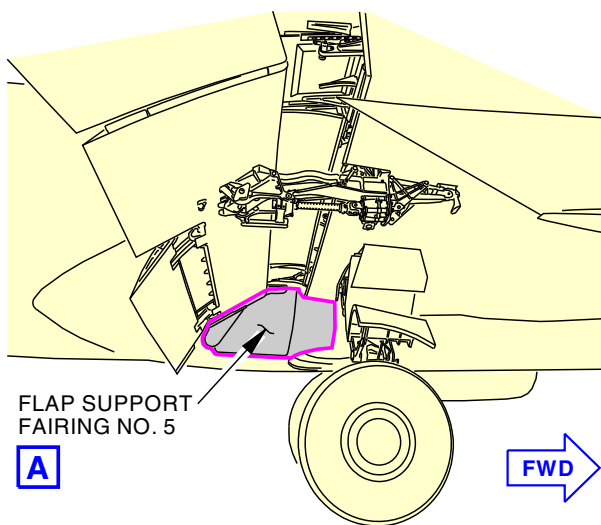
EFFECTIVITY
SIA ALL

D633AM101-SIA

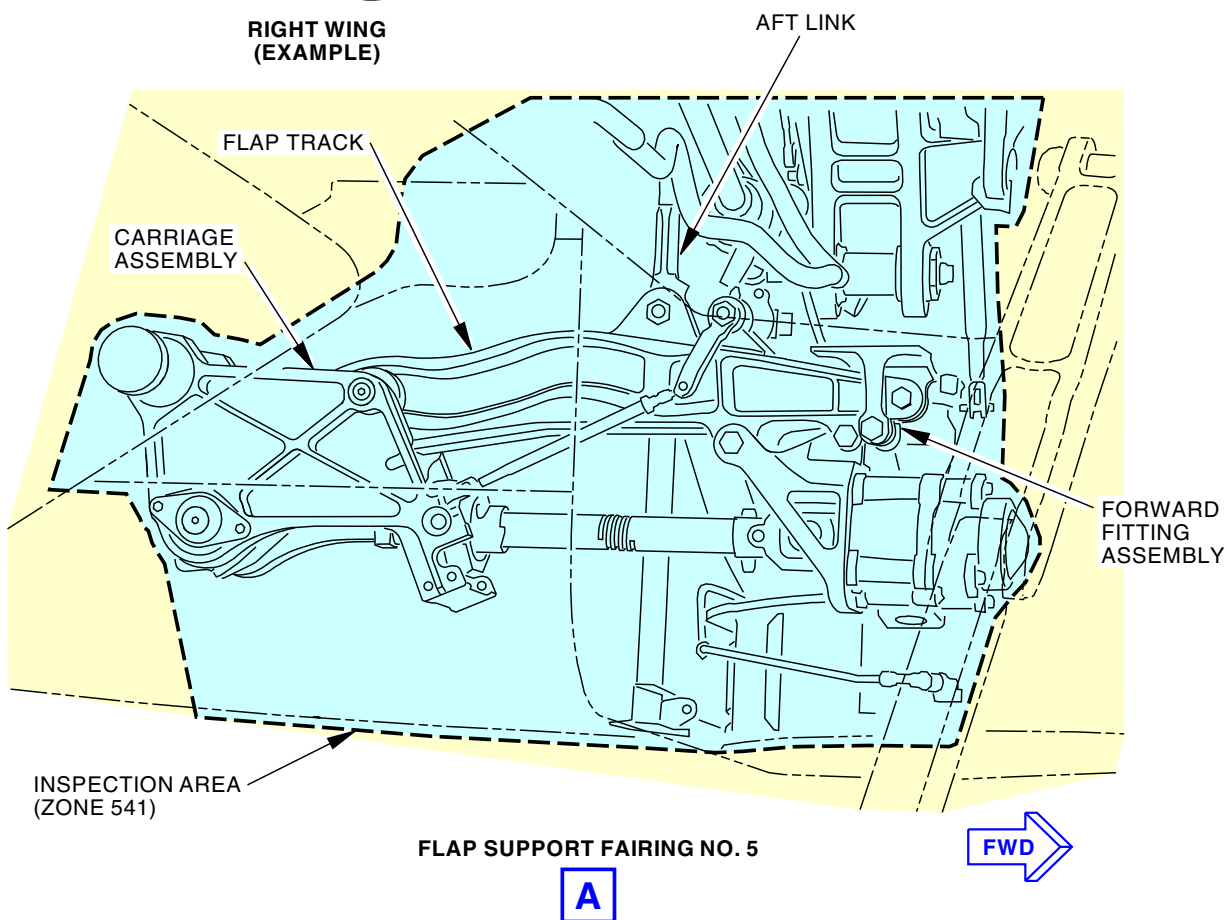
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RIGHT WING
(EXAMPLE)



2410276 S00061525235_V3

Flap Support Fairing No. 5 General Visual (Internal)
Figure 234/57-05-03-990-834

EFFECTIVITY
SIA ALL

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**737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL**

TASK 57-05-03-210-829

31. INTERNAL - GENERAL VISUAL: LEFT FLAP SUPPORT NO. 3

(Figure 235)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-802	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
542	Left Wing - Fairing Flap Support No. 3

C. Access Panels

Number	Name/Location
542AB	Flap Support No. 3, Forward Assembly Access Panel

D. Inspection

SUBTASK 57-05-03-010-030

- (1) Open this access panel:

Number	Name/Location
542AB	Flap Support No. 3, Forward Assembly Access Panel

- (2) Remove flap support forward fairing and deploy flaps.

SUBTASK 57-05-03-210-029

- (3) Do a General Visual inspection of the left inboard flap outboard track assembly, carriage assembly, forward fitting assembly, and aft attach fitting. Normal overhaul procedures, applied with the flap track assemblies, carriage assemblies and forward fitting assemblies removed, at intervals not exceeding 10 years, are adequate to maintain corrosion at safe levels on these components.

SUBTASK 57-05-03-910-031

- (4) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-802.

SUBTASK 57-05-03-410-030

- (5) Close this access panel:

Number	Name/Location
542AB	Flap Support No. 3, Forward Assembly Access Panel

———— **END OF TASK** ————

EFFECTIVITY
SIA ALL

D633AM101-SIA

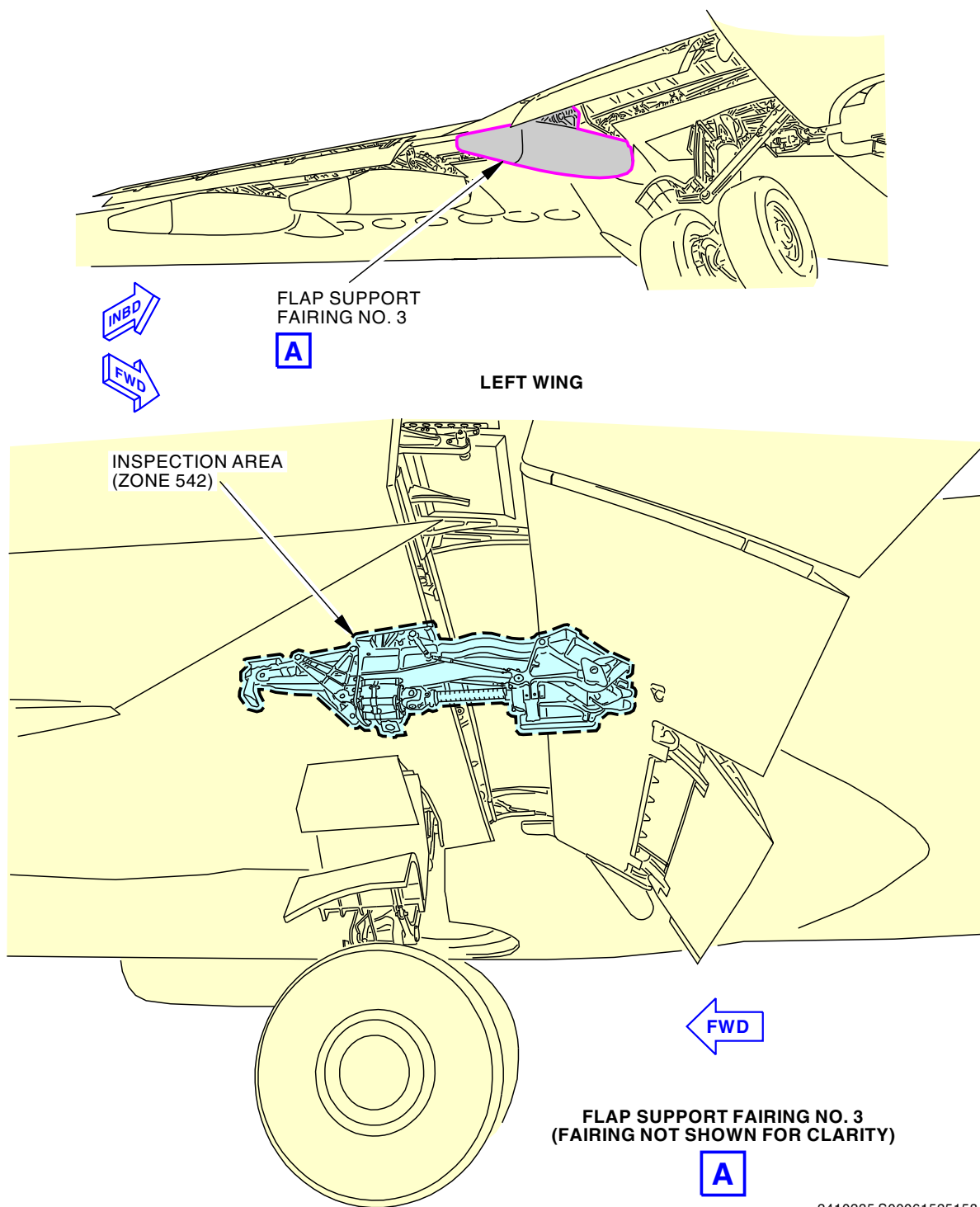
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AIRCRAFT MAINTENANCE MANUAL



2410235 S00061525158_V1

Flap Support Fairing No. 3 General Visual (Internal)
Figure 235/57-05-03-990-835

EFFECTIVITY
SIA ALL

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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL

TASK 57-05-03-210-830

32. INTERNAL - GENERAL VISUAL: RIGHT FLAP SUPPORT NO. 6

(Figure 236)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-802	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
642	Right Wing - Fairing Flap Support No. 6

C. Access Panels

Number	Name/Location
642AB	Flap Support No. 6, Forward Assembly Access Panel

D. Inspection

SUBTASK 57-05-03-010-031

- (1) Open this access panel:

<u>Number</u>	<u>Name/Location</u>
642AB	Flap Support No. 6, Forward Assembly Access Panel

- (2) Remove flap forward fairings and deploy flaps.

SUBTASK 57-05-03-210-030

- (3) Do a General Visual inspection of the right inboard flap outboard track assembly, carriage assembly, forward fitting assembly, and aft attach fitting. Normal overhaul procedures, applied with the flap track assemblies, carriage assemblies and forward fitting assemblies removed, at intervals not exceeding 10 years, are adequate to maintain corrosion at safe levels on these components.

SUBTASK 57-05-03-910-032

- (4) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-802.

SUBTASK 57-05-03-410-031

- (5) Close this access panel:

<u>Number</u>	<u>Name/Location</u>
642AB	Flap Support No. 6, Forward Assembly Access Panel

———— **END OF TASK** ————

EFFECTIVITY
SIA ALL

D633AM101-SIA

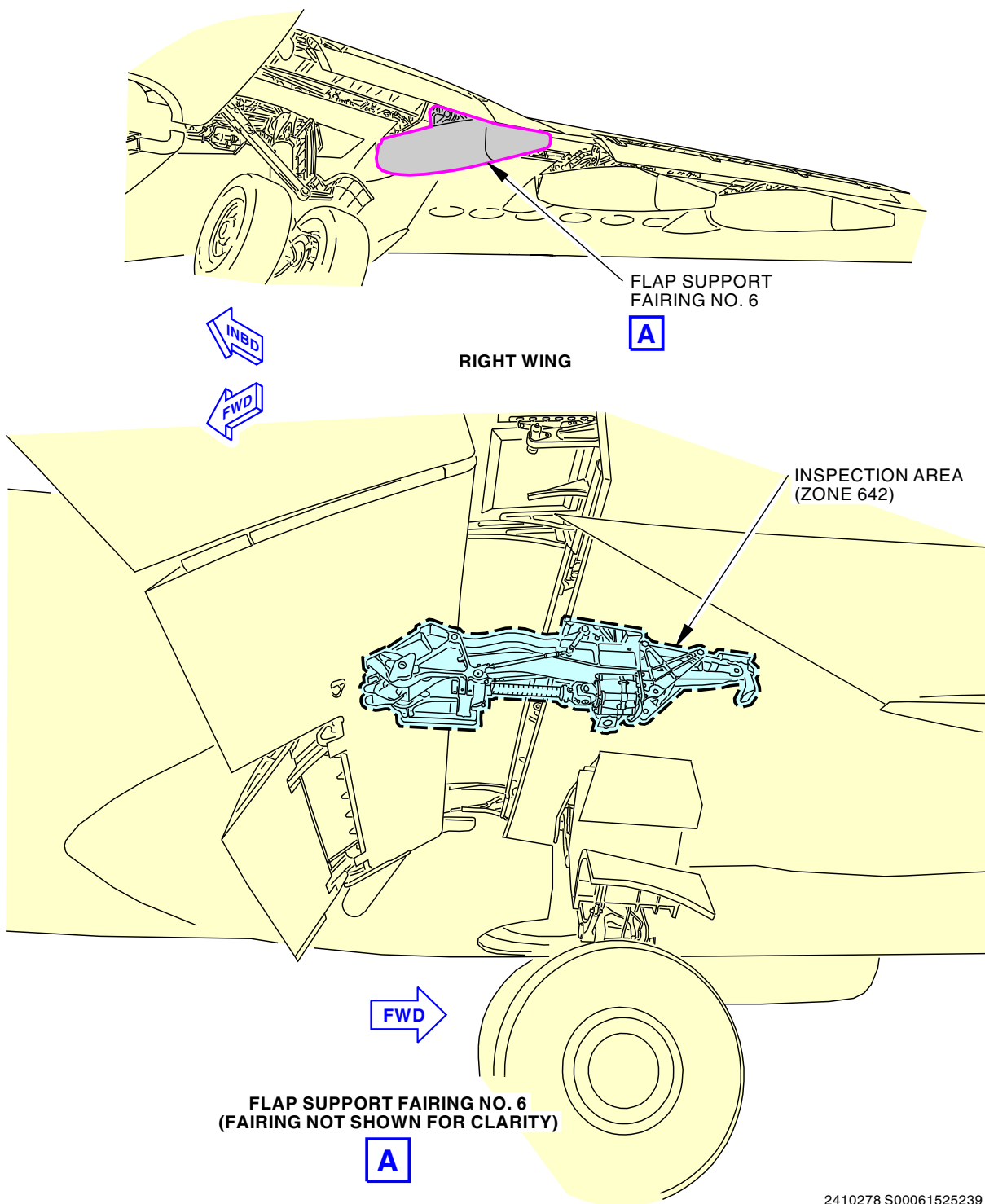
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AIRCRAFT MAINTENANCE MANUAL



2410278 S00061525239_V1

Flap Support Fairing No. 6 General Visual (Internal)
Figure 236/57-05-03-990-836

EFFECTIVITY
SIA ALL

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AIRCRAFT MAINTENANCE MANUAL

TASK 57-05-03-210-831

33. **INTERNAL - GENERAL VISUAL: LEFT OUTBOARD WING LOWER SURFACE**

(Figure 237)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-801	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
542	Left Wing - Fairing Flap Support No. 3

C. Access Panels

Number	Name/Location
542AB	Flap Support No. 3, Forward Assembly Access Panel

D. Inspection

SUBTASK 57-05-03-010-032

- (1) Open this access panel:

Number	Name/Location
542AB	Flap Support No. 3, Forward Assembly Access Panel

SUBTASK 57-05-03-210-031

- (2) Do a General Visual inspection of the lower side of lower surface (under flap support No. 3 fairing), including all attachment locations and access holes.

SUBTASK 57-05-03-910-033

- (3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-801.

SUBTASK 57-05-03-410-032

- (4) Close this access panel:

Number	Name/Location
542AB	Flap Support No. 3, Forward Assembly Access Panel

————— **END OF TASK** —————

EFFECTIVITY
SIA ALL

D633AM101-SIA

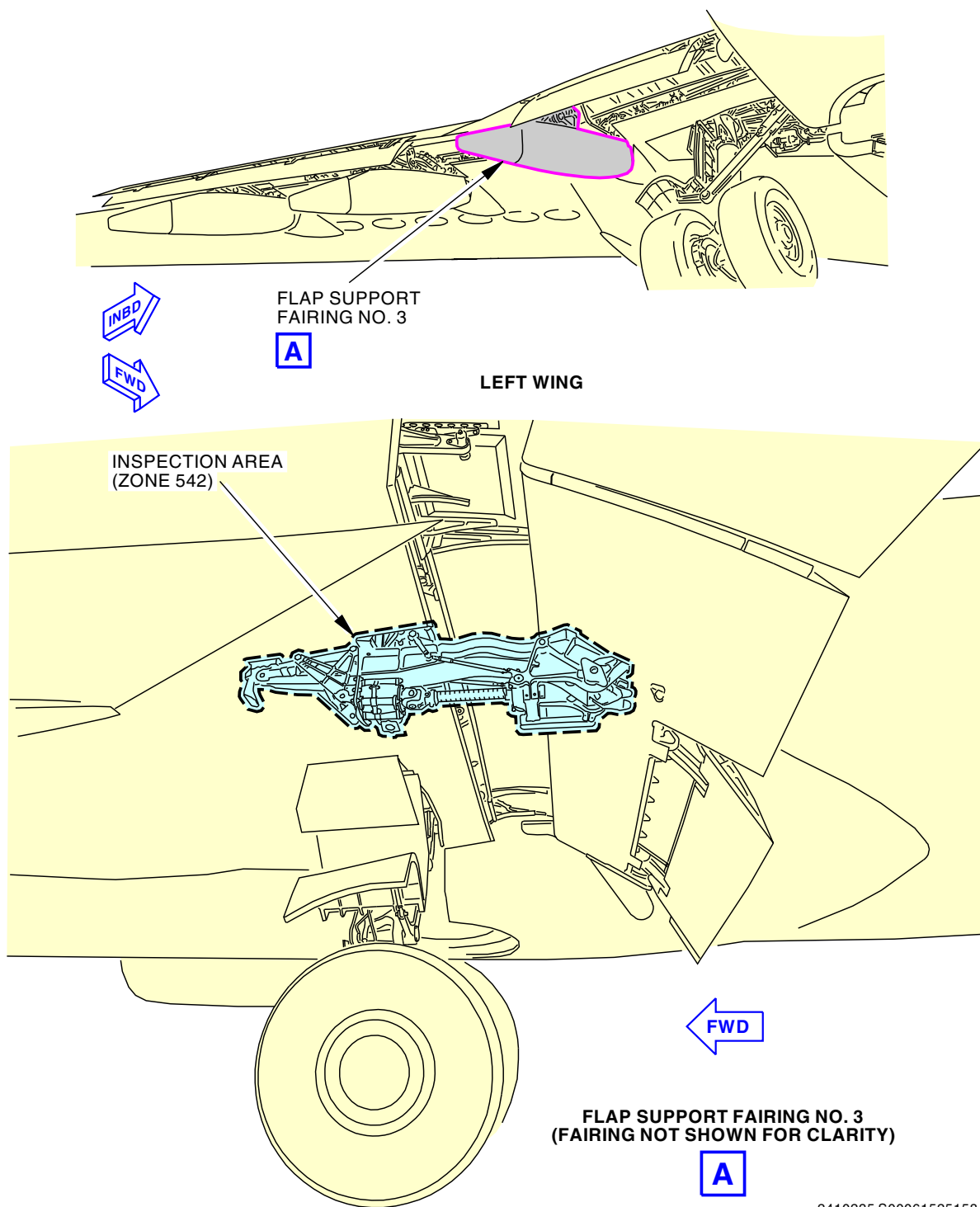
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AIRCRAFT MAINTENANCE MANUAL



2410235 S00061525158_V1

Flap Support Fairing No. 3 General Visual (Internal)
Figure 237/57-05-03-990-837

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL

TASK 57-05-03-210-832

34. **INTERNAL - GENERAL VISUAL: RIGHT OUTBOARD WING LOWER SURFACE**

(Figure 238)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-801	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
642	Right Wing - Fairing Flap Support No. 6

C. Access Panels

Number	Name/Location
642AB	Flap Support No. 6, Forward Assembly Access Panel

D. Inspection

SUBTASK 57-05-03-010-033

(1) Open this access panel:

Number	Name/Location
642AB	Flap Support No. 6, Forward Assembly Access Panel

SUBTASK 57-05-03-210-032

(2) Do a General Visual inspection of the lower side of lower surface (under flap support No. 6 fairing), including all attachment locations and access holes.

SUBTASK 57-05-03-910-034

(3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-801.

SUBTASK 57-05-03-410-033

(4) Close this access panel:

Number	Name/Location
642AB	Flap Support No. 6, Forward Assembly Access Panel

————— **END OF TASK** —————

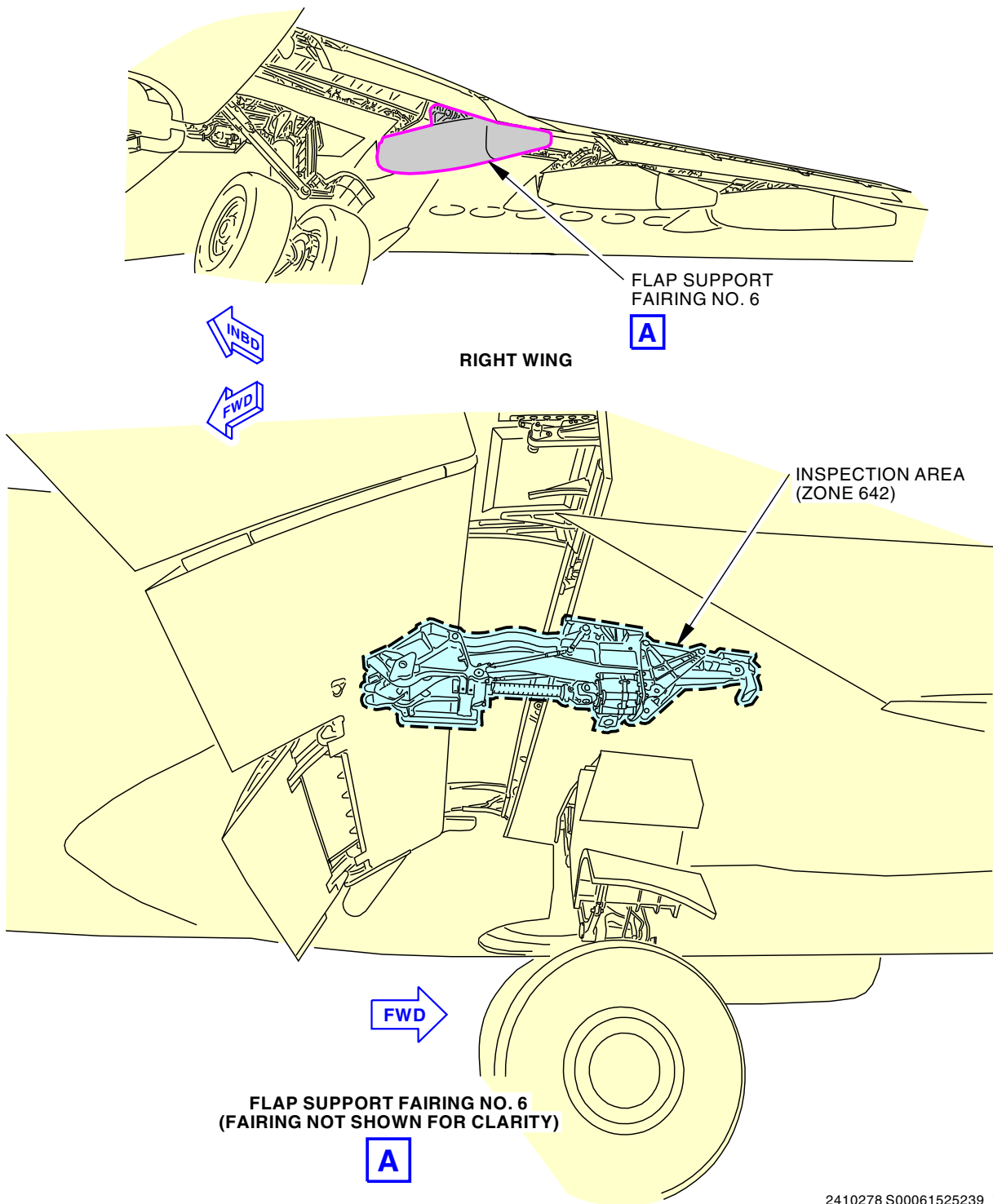
EFFECTIVITY
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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2410278 S00061525239_V1

Flap Support Fairing No. 6 General Visual (Internal)
Figure 238/57-05-03-990-838

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL

TASK 57-05-03-210-833

35. INTERNAL - GENERAL VISUAL: FLAP SUPPORTS NO. 1 & 2

(Figure 239, Figure 240)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-803	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
543	Left Wing - Fairing Flap Support No. 2
544	Left Wing - Fairing Flap Support No. 1

C. Access Panels

Number	Name/Location
543AB	Flap Support No. 2 Access Panel, Forward Assembly
544AB	Flap Support No. 1 Access Panel, Forward Assembly

D. Inspection

SUBTASK 57-05-03-010-034

- (1) Open these access panels:

<u>Number</u>	<u>Name/Location</u>
543AB	Flap Support No. 2 Access Panel, Forward Assembly
544AB	Flap Support No. 1 Access Panel, Forward Assembly

- (2) Remove flap forward fairings and deploy flaps.

SUBTASK 57-05-03-210-033

- (3) Do a General Visual inspection of the left outboard flap inboard and outboard track assemblies, carriage assemblies, forward fitting assemblies, and aft links. Normal overhaul procedures, applied with the flap track assemblies, carriage assemblies and forward fitting assemblies removed, at intervals not exceeding 10 years, are adequate to maintain corrosion at safe levels on these components.

SUBTASK 57-05-03-910-035

- (4) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-803.

SUBTASK 57-05-03-410-034

- (5) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
543AB	Flap Support No. 2 Access Panel, Forward Assembly
544AB	Flap Support No. 1 Access Panel, Forward Assembly

———— **END OF TASK** ————

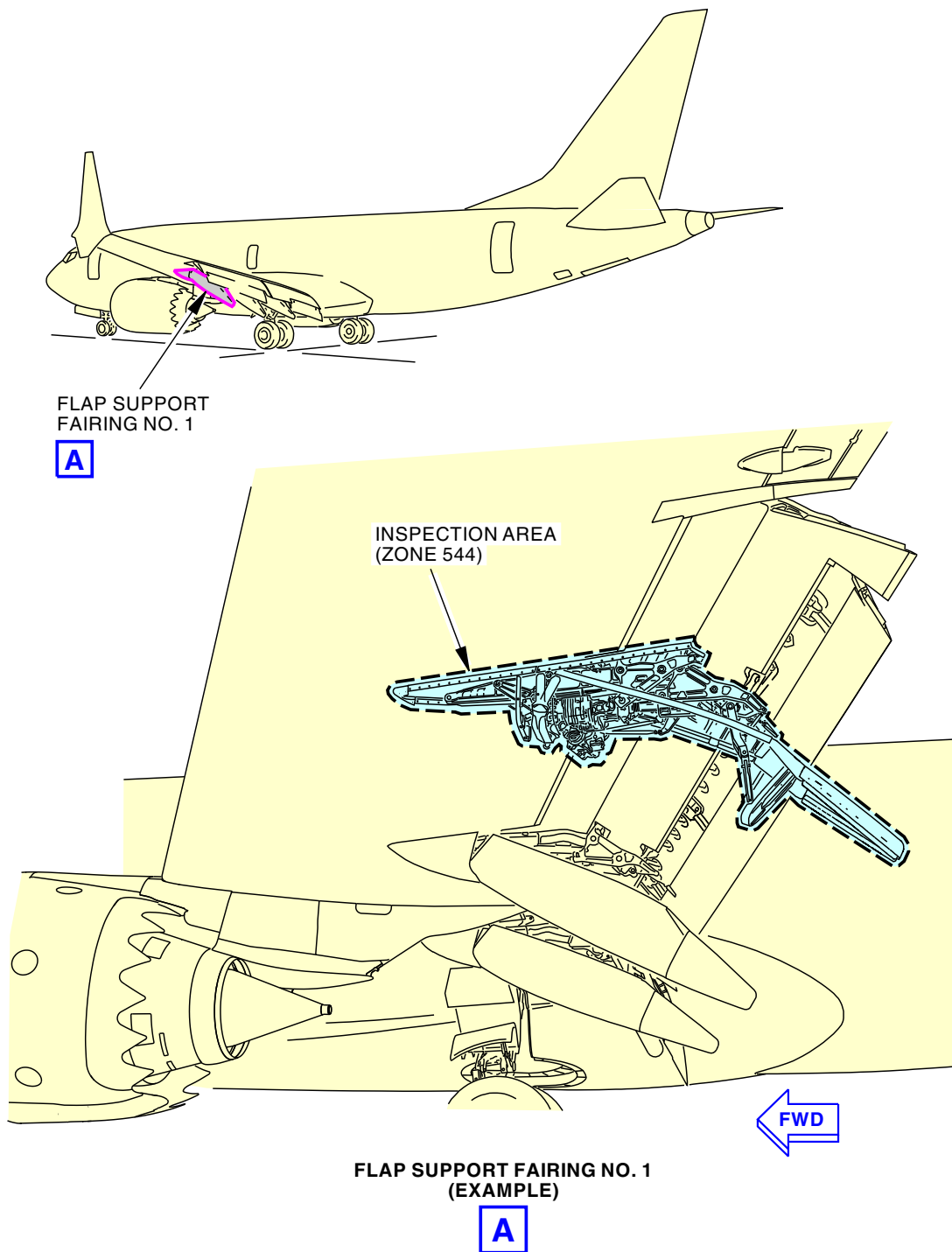
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2410239 S00061525166_V3

Flap Support Fairing No. 1 General Visual (Internal)
Figure 239/57-05-03-990-839

EFFECTIVITY
SIA ALL

D633AM101-SIA

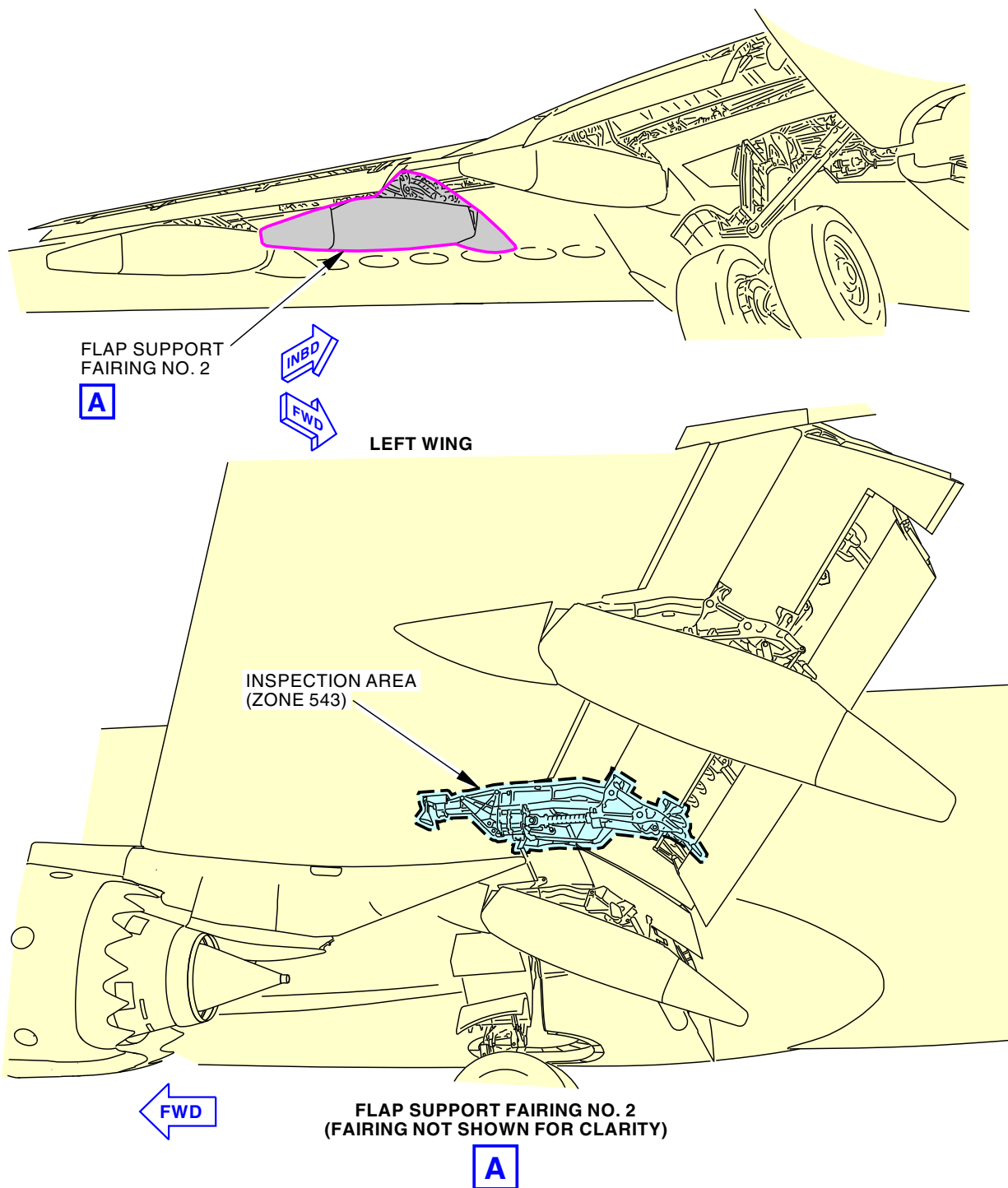
ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL



2410237 S00061525162_V1

Flap Support Fairing No. 2 General Visual (Internal)
Figure 240/57-05-03-990-840

EFFECTIVITY
SIA ALL

D633AM101-SIA

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AIRCRAFT MAINTENANCE MANUAL

TASK 57-05-03-210-834

36. INTERNAL - GENERAL VISUAL: FLAP SUPPORTS NO. 7 & 8

Figure 241

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-803	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
643	Right Wing - Fairing Flap Support No. 7
644	Right Wing - Fairing Flap Support No. 8

C. Access Panels

Number	Name/Location
643AB	Flap Support No. 7, Forward Assembly Access Panel
644AB	Flap Support No. 8, Forward Assembly Access Panel

D. Inspection

SUBTASK 57-05-03-010-035

- (1) Open these access panels:

Number	Name/Location
643AB	Flap Support No. 7, Forward Assembly Access Panel
644AB	Flap Support No. 8, Forward Assembly Access Panel

- (2) Remove flap forward fairings and deploy flaps.

SUBTASK 57-05-03-210-034

- (3) Do a General Visual inspection of the right outboard flap inboard and outboard track assemblies, carriage assemblies, forward fitting assemblies, and aft links. Normal overhaul procedures, applied with the flap track assemblies, carriage assemblies and forward fitting assemblies removed, at intervals not exceeding 10 years, are adequate to maintain corrosion at safe levels on these components.

SUBTASK 57-05-03-910-036

- (4) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-803.

SUBTASK 57-05-03-410-035

- (5) Close these access panels:

Number	Name/Location
643AB	Flap Support No. 7, Forward Assembly Access Panel
644AB	Flap Support No. 8, Forward Assembly Access Panel

———— **END OF TASK** ————

EFFECTIVITY
SIA ALL

D633AM101-SIA

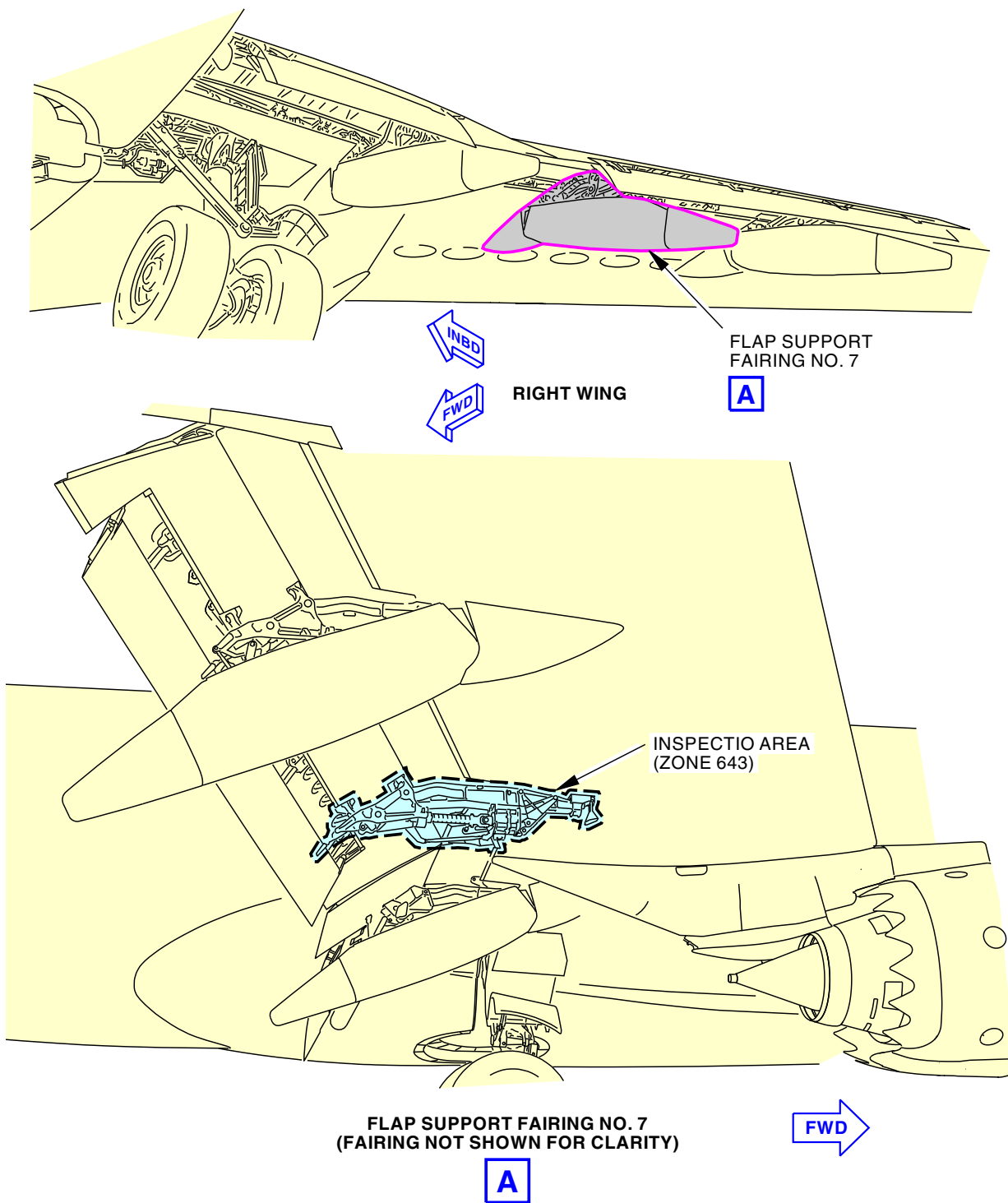
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AIRCRAFT MAINTENANCE MANUAL



2410280 S00061525243_V1

Flap Support Fairing No. 7 General Visual (Internal)
Figure 241/57-05-03-990-841

EFFECTIVITY
SIA ALL

D633AM101-SIA

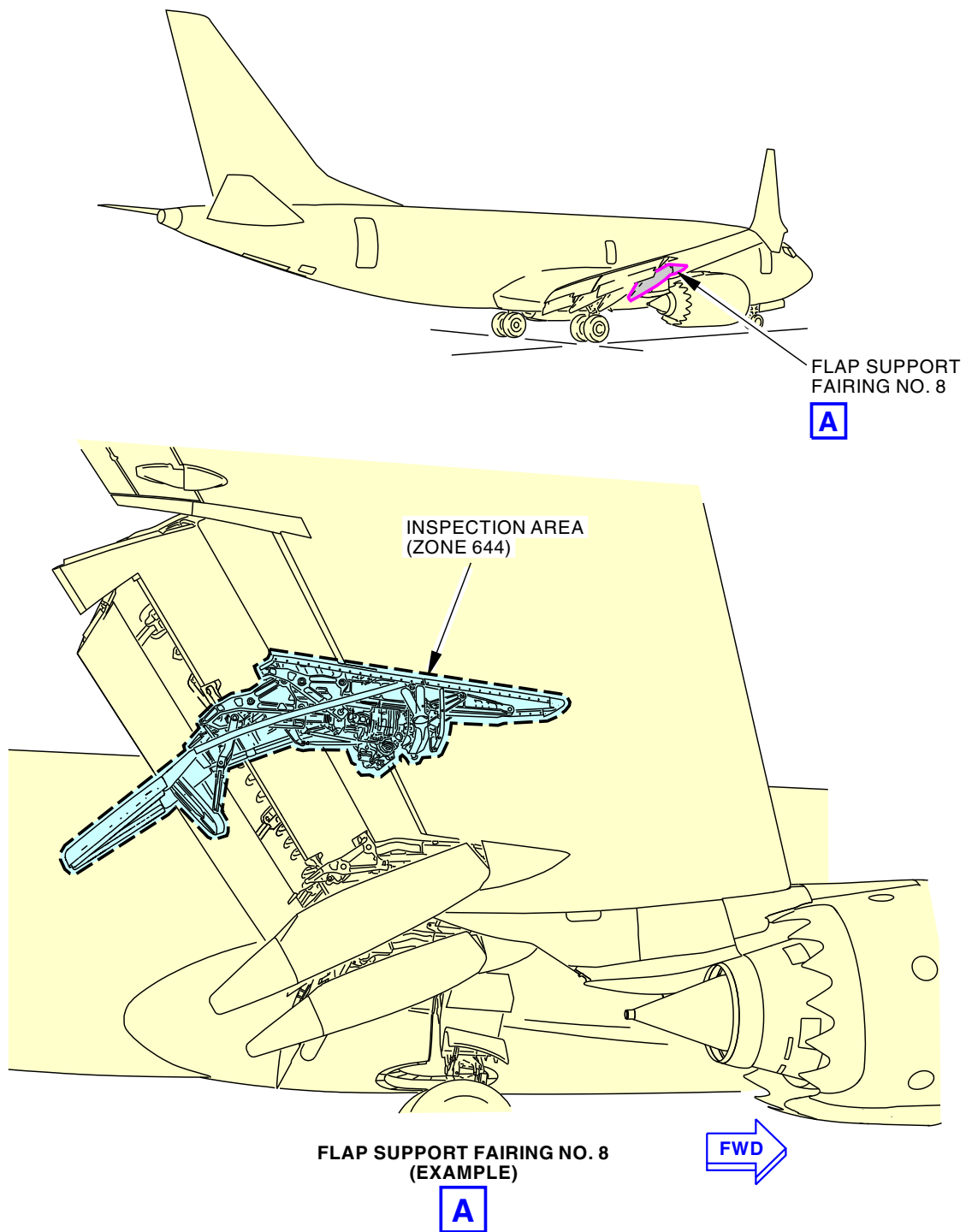
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AIRCRAFT MAINTENANCE MANUAL



2410282 S00061525247_V3

Flap Support Fairing No. 8 General Visual (Internal)
Figure 242/57-05-03-990-842

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL

TASK 57-05-03-210-835

37. **INTERNAL - GENERAL VISUAL: LEFT OUTBOARD WING LOWER SURFACE**

(Figure 243)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-801	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
543	Left Wing - Fairing Flap Support No. 2
544	Left Wing - Fairing Flap Support No. 1

C. Access Panels

Number	Name/Location
543AB	Flap Support No. 2 Access Panel, Forward Assembly
544AB	Flap Support No. 1 Access Panel, Forward Assembly

D. Inspection

SUBTASK 57-05-03-010-036

- (1) Open these access panels:

<u>Number</u>	<u>Name/Location</u>
543AB	Flap Support No. 2 Access Panel, Forward Assembly
544AB	Flap Support No. 1 Access Panel, Forward Assembly

SUBTASK 57-05-03-210-035

- (2) Do a General Visual inspection for the lower side of lower surface (under flap support No. 1 & 2 fairings), including all attachment locations and access holes.

SUBTASK 57-05-03-910-037

- (3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-801.

SUBTASK 57-05-03-410-036

- (4) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
543AB	Flap Support No. 2 Access Panel, Forward Assembly
544AB	Flap Support No. 1 Access Panel, Forward Assembly

————— **END OF TASK** —————

EFFECTIVITY
SIA ALL

D633AM101-SIA

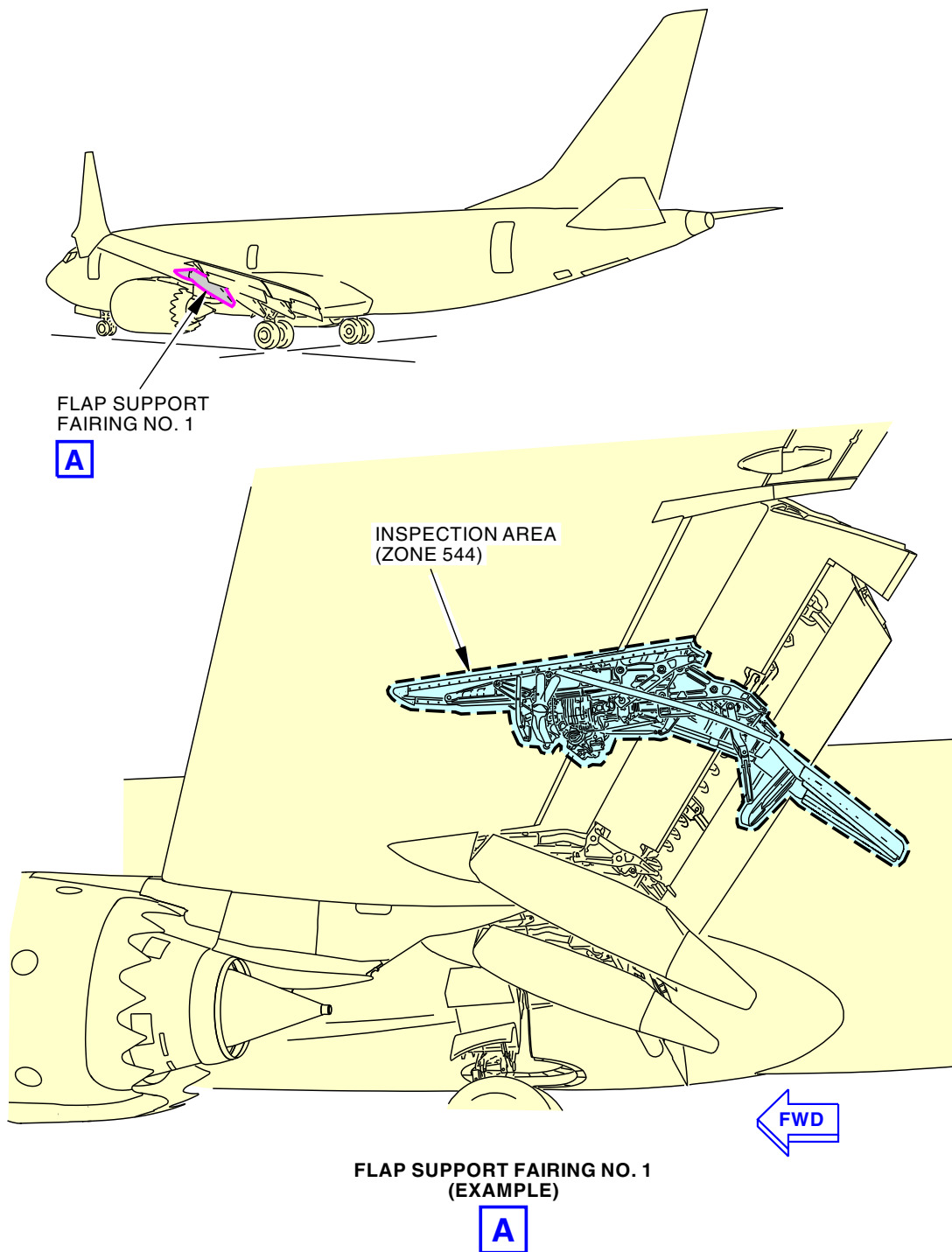
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737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL



2410239 S00061525166_V3

Flap Support Fairing No. 1 General Visual (Internal)
Figure 243/57-05-03-990-843

EFFECTIVITY
SIA ALL

D633AM101-SIA

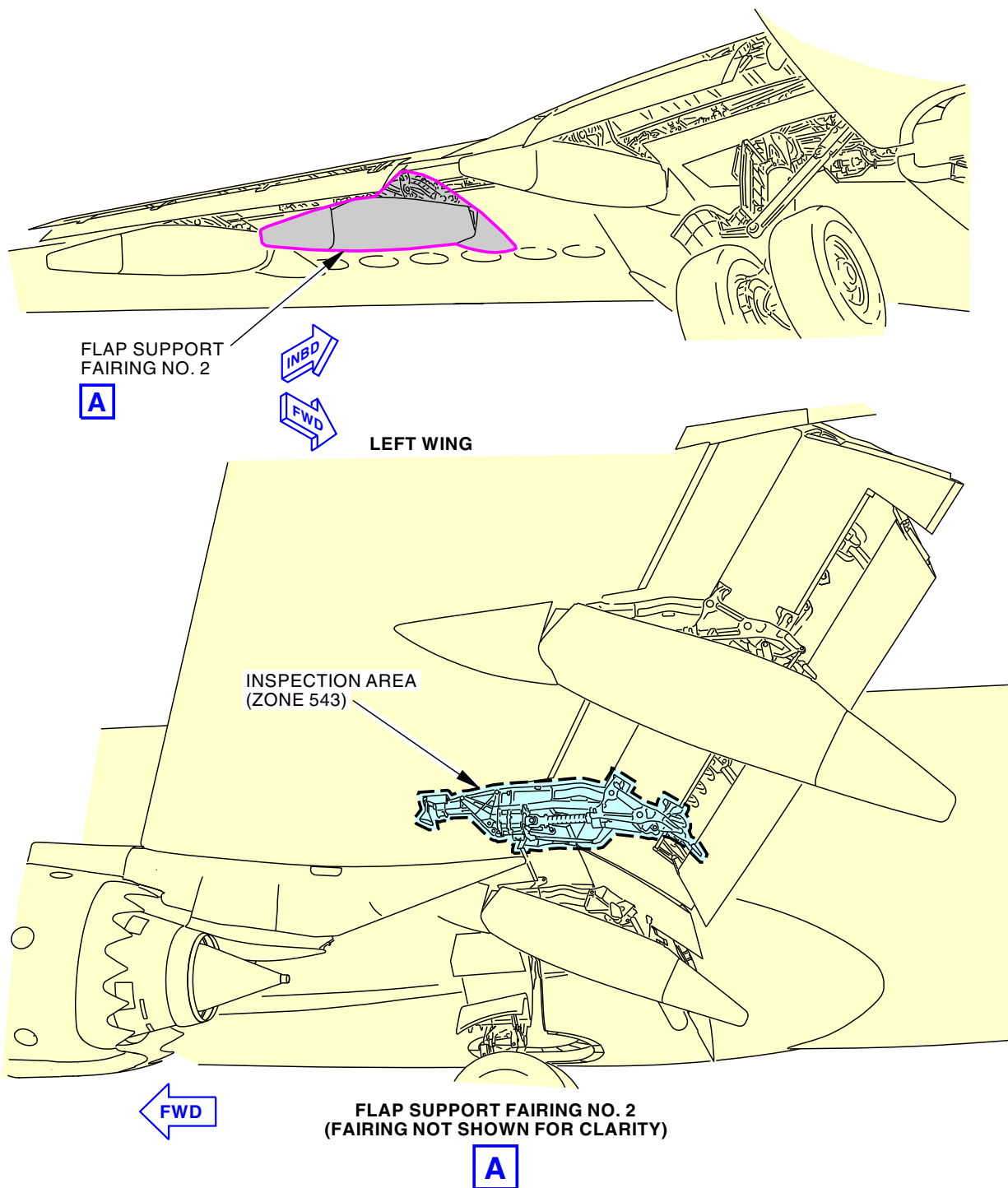
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737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL



2410237 S00061525162_V1

Flap Support Fairing No. 2 General Visual (Internal)
Figure 244/57-05-03-990-844

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL

TASK 57-05-03-210-836

38. **INTERNAL - GENERAL VISUAL: RIGHT OUTBOARD WING LOWER SURFACE**

(Figure 245, Figure 246)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-801	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
643	Right Wing - Fairing Flap Support No. 7
644	Right Wing - Fairing Flap Support No. 8

C. Access Panels

Number	Name/Location
643AB	Flap Support No. 7, Forward Assembly Access Panel
644AB	Flap Support No. 8, Forward Assembly Access Panel

D. Inspection

SUBTASK 57-05-03-010-037

- (1) Open these access panels:

Number	Name/Location
643AB	Flap Support No. 7, Forward Assembly Access Panel
644AB	Flap Support No. 8, Forward Assembly Access Panel

SUBTASK 57-05-03-210-036

- (2) Do a General Visual inspection for the lower side of lower surface (under flap support No. 7 & 8 fairings), including all attachment locations and access holes.

SUBTASK 57-05-03-910-038

- (3) Do this task: 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-801.

SUBTASK 57-05-03-410-037

- (4) Close these access panels:

Number	Name/Location
643AB	Flap Support No. 7, Forward Assembly Access Panel
644AB	Flap Support No. 8, Forward Assembly Access Panel

————— **END OF TASK** —————

EFFECTIVITY
SIA ALL

D633AM101-SIA

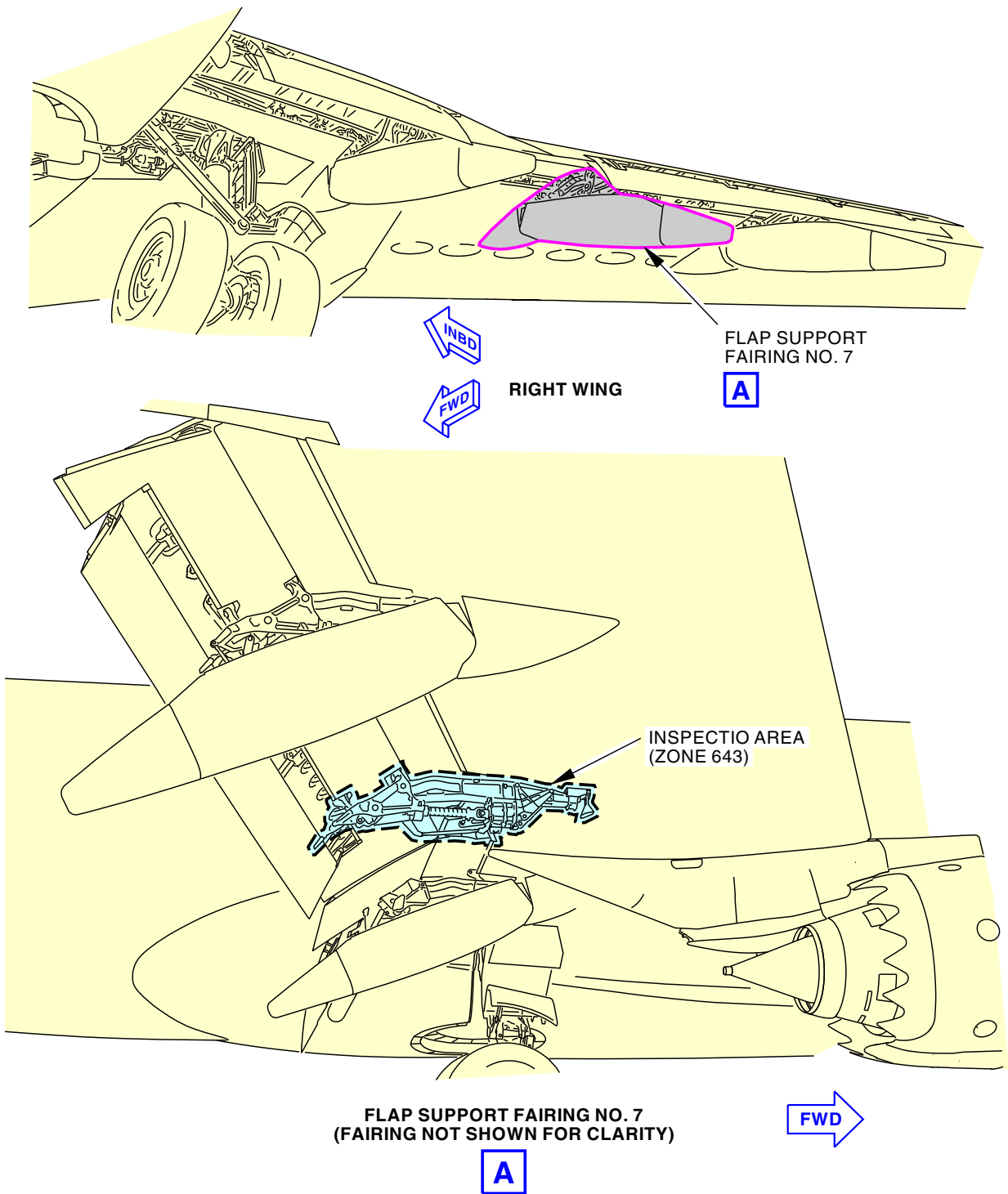
ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL



2410280 S00061525243_V1

Flap Support Fairing No. 7 General Visual (Internal)
Figure 245/57-05-03-990-845

EFFECTIVITY
SIA ALL

D633AM101-SIA

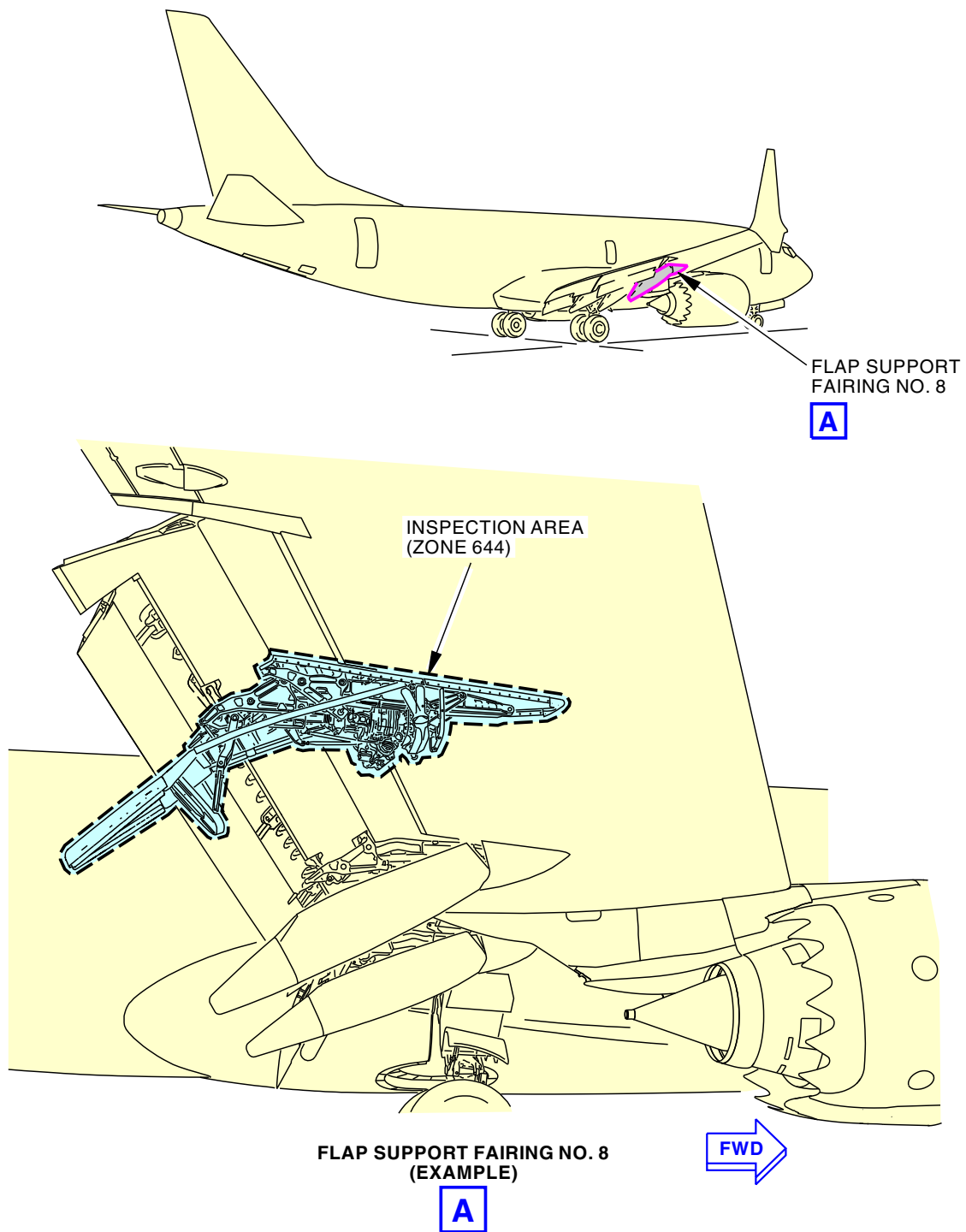
ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL



2410282 S00061525247_V3

Flap Support Fairing No. 8 General Visual (Internal)
Figure 246/57-05-03-990-864

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL

TASK 57-05-03-210-837

39. INTERNAL - GENERAL VISUAL: LEFT MAIN LANDING GEAR SUPPORT STRUCTURE

(Figure 247)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-806	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
551	Left Wing - Rear Spar To Landing Gear Support Beam

C. Access Panels

Number	Name/Location
551DT	Upper Inboard Fixed Trailing Edge, MLG Beam Access Panel
551ET	Upper Inboard Fixed Trailing Edge, MLG Beam Access Panel

D. Inspection

SUBTASK 57-05-03-010-038

(1) Open these access panels:

<u>Number</u>	<u>Name/Location</u>
551DT	Upper Inboard Fixed Trailing Edge, MLG Beam Access Panel
551ET	Upper Inboard Fixed Trailing Edge, MLG Beam Access Panel

SUBTASK 57-05-03-210-037

(2) Do a General Visual inspection of the left main landing gear support structure.

- (a) Main landing gear beam assembly.
- (b) Outboard support (dog house) assembly.
- (c) Inboard support (hanger link) assembly.
- (d) Trunnion support assembly.
- (e) Stabilizer links, including attach fittings and fuse pins.

SUBTASK 57-05-03-910-039

(3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 57-05-03-410-038

(4) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
551DT	Upper Inboard Fixed Trailing Edge, MLG Beam Access Panel
551ET	Upper Inboard Fixed Trailing Edge, MLG Beam Access Panel

———— **END OF TASK** ————

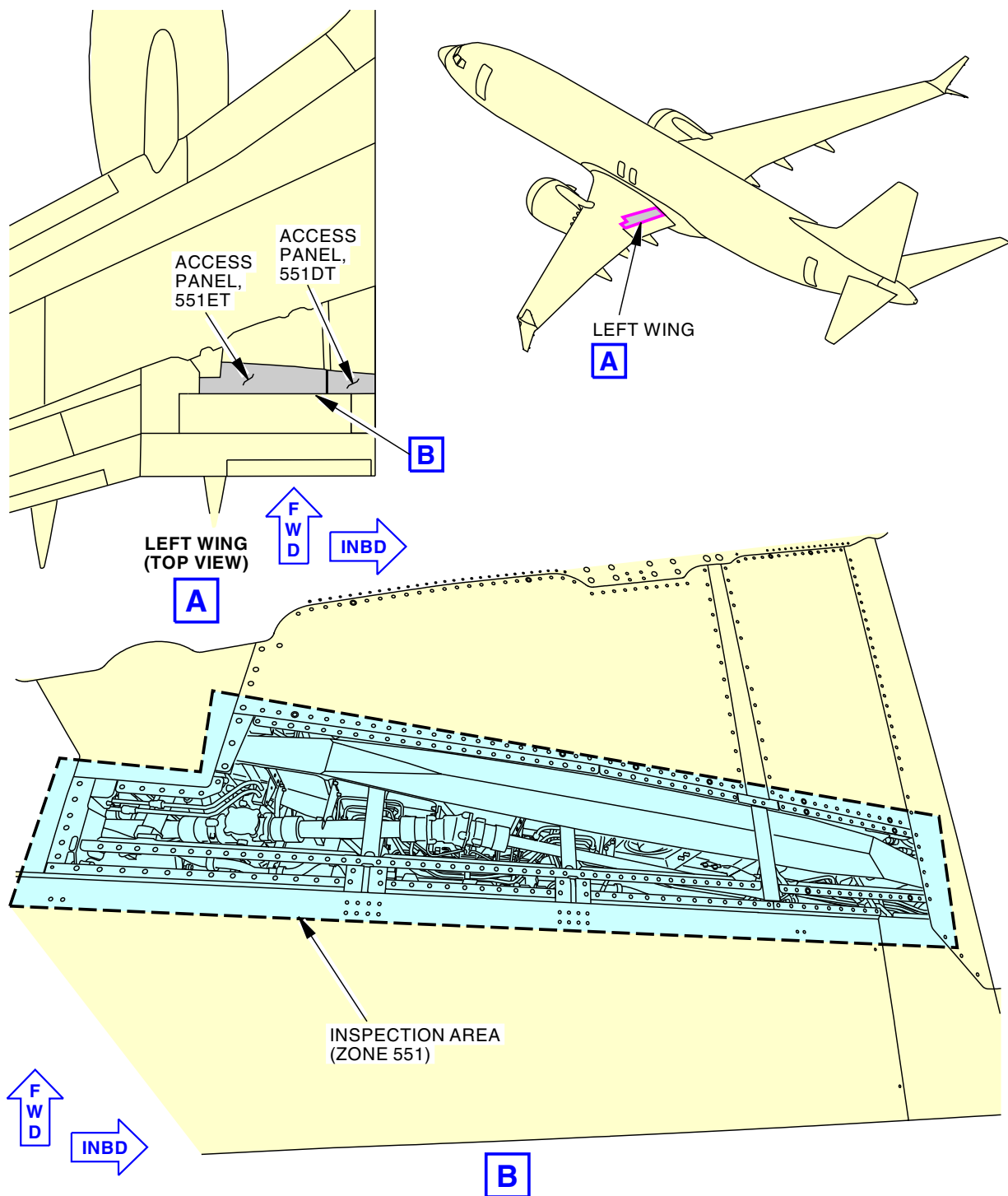
EFFECTIVITY
SIA ALL

57-05-03

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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2416538 S00061541017_V1

Left Main Landing Gear Support Structure
Figure 247/57-05-03-990-846 (Sheet 1 of 2)

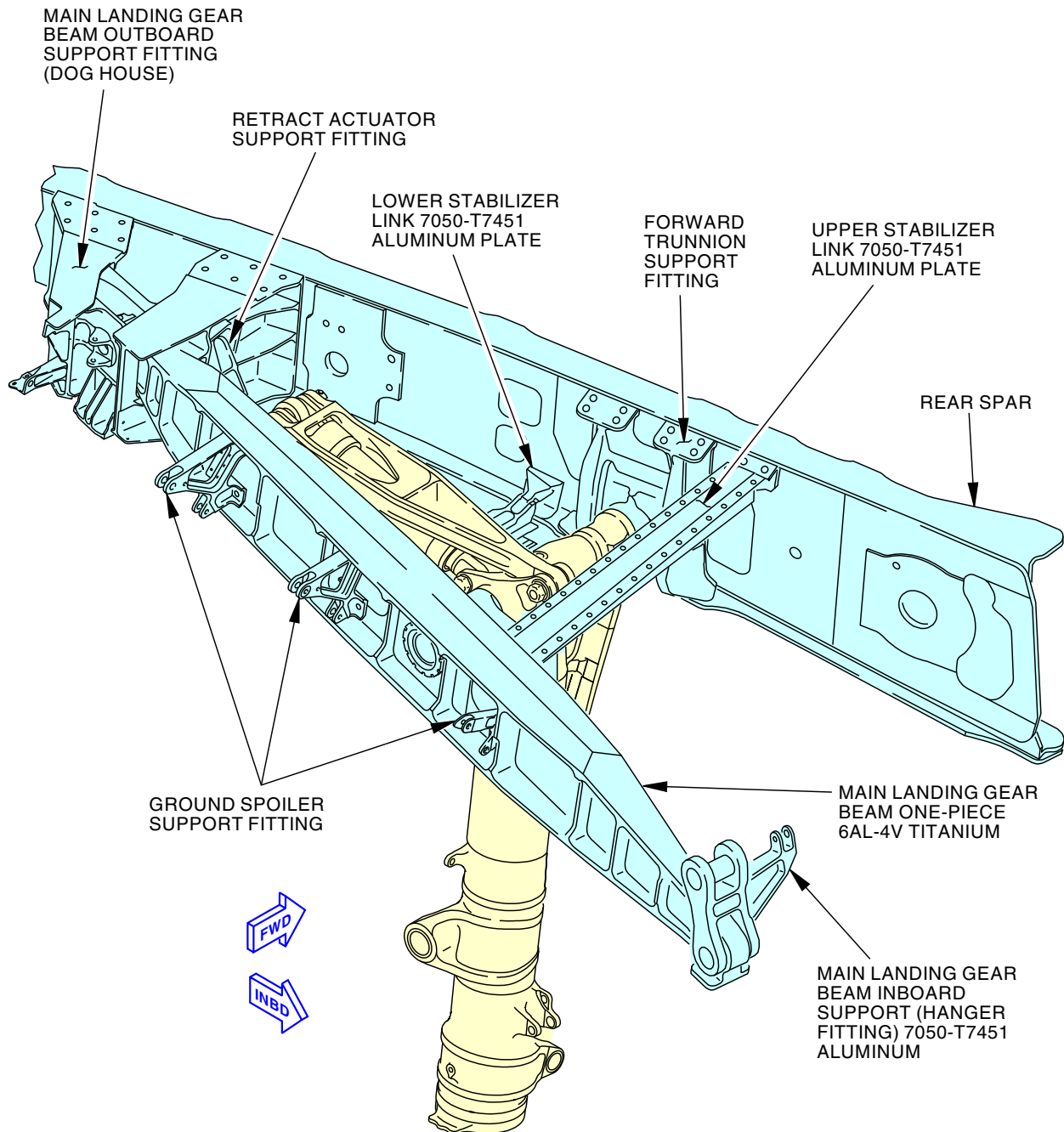
EFFECTIVITY
SIA ALL

57-05-03

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D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details



2416539 S00061541018_V2

Left Main Landing Gear Support Structure
Figure 247/57-05-03-990-846 (Sheet 2 of 2)

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL

TASK 57-05-03-210-838

40. INTERNAL - GENERAL VISUAL: RIGHT MAIN LANDING GEAR SUPPORT STRUCTURE

(Figure 248)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-806	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
651	Right Wing - Rear Spar to Landing Gear Support Beam

C. Access Panels

Number	Name/Location
651DT	Upper Inboard Fixed Trailing Edge, MLG Beam Access Panel
651ET	Upper Inboard Fixed Trailing Edge, MLG Beam Access Panel

D. Inspection

SUBTASK 57-05-03-010-039

- (1) Open these access panels:

<u>Number</u>	<u>Name/Location</u>
651DT	Upper Inboard Fixed Trailing Edge, MLG Beam Access Panel
651ET	Upper Inboard Fixed Trailing Edge, MLG Beam Access Panel

SUBTASK 57-05-03-210-038

- (2) Do a General Visual inspection of the right main landing gear support structure.
- (a) Main landing gear beam assembly.
 - (b) Outboard support (dog house) assembly.
 - (c) Inboard support (hanger link) assembly.
 - (d) Trunnion support assembly.
 - (e) Stabilizer links, including attach fittings and fuse pins.

SUBTASK 57-05-03-910-040

- (3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 57-05-03-410-039

- (4) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
651DT	Upper Inboard Fixed Trailing Edge, MLG Beam Access Panel
651ET	Upper Inboard Fixed Trailing Edge, MLG Beam Access Panel

———— **END OF TASK** ————

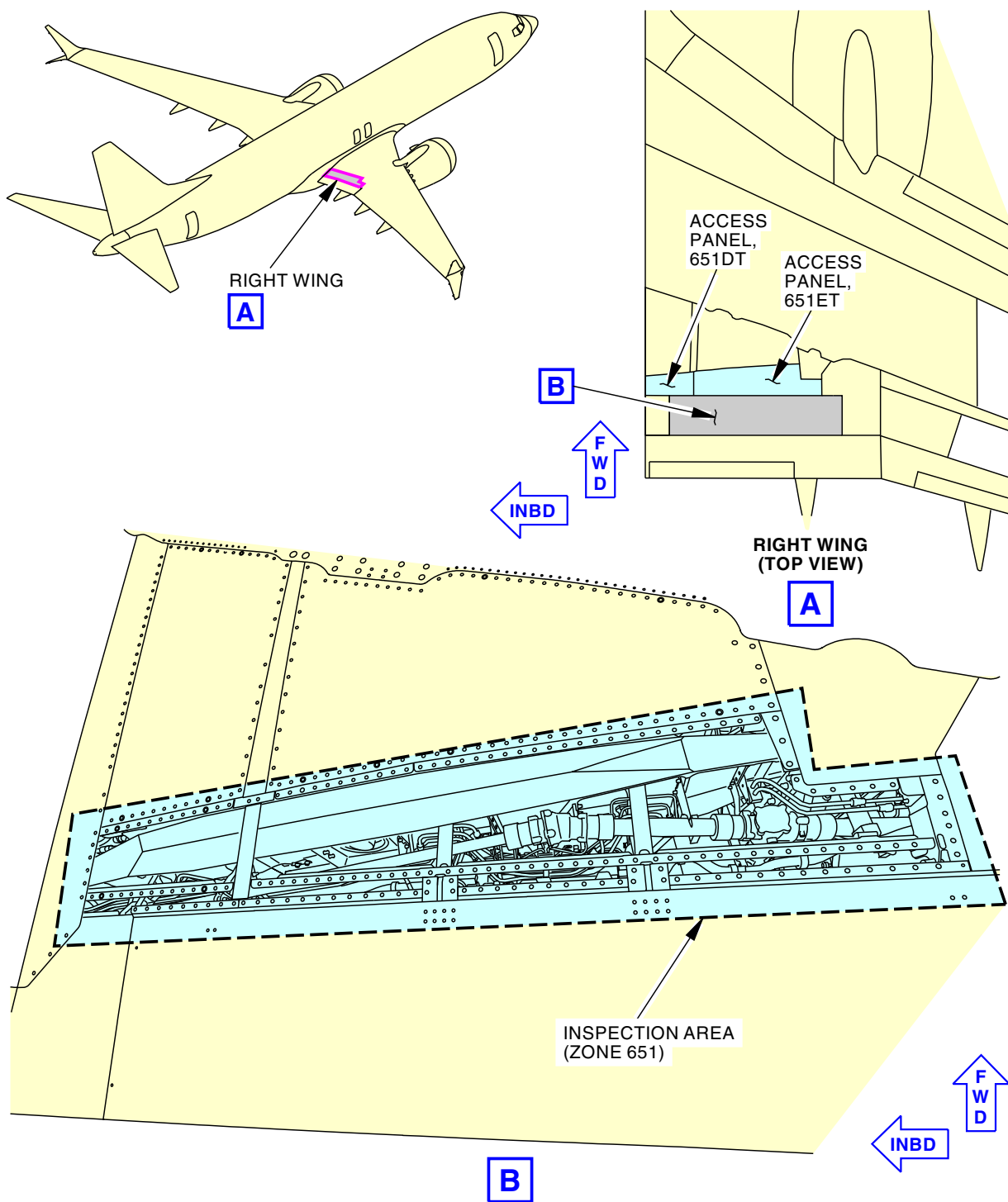
EFFECTIVITY
SIA ALL

57-05-03

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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2416540 S00061541020_V1

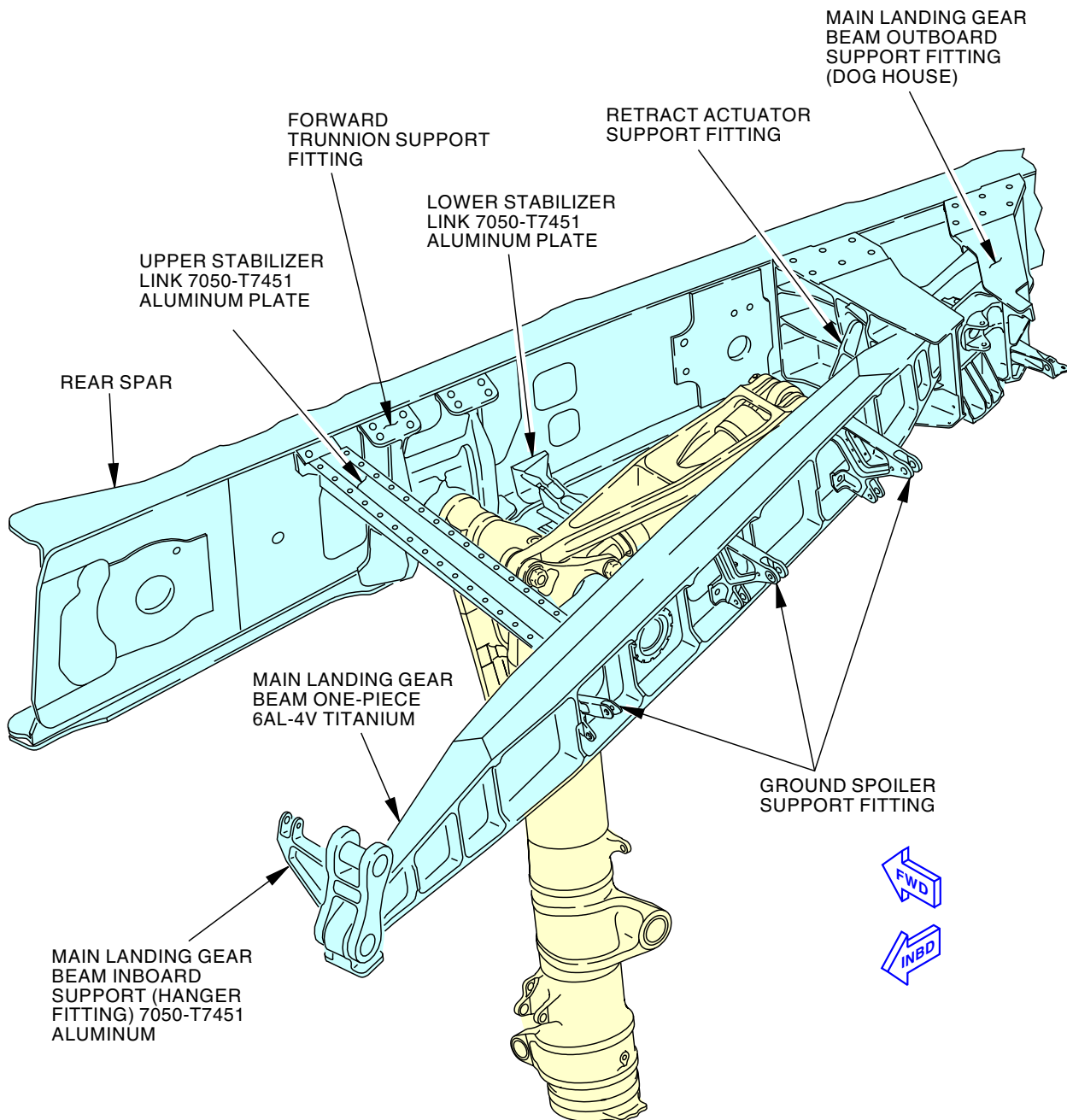
Right Main Landing Gear Support Structure General Visual (Internal)
Figure 248/57-05-03-990-847 (Sheet 1 of 2)

EFFECTIVITY
SIA ALL

57-05-03

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D633AM101-SIA



2416541 S00061541021_V1

Right Main Landing Gear Support Structure General Visual (Internal)
Figure 248/57-05-03-990-847 (Sheet 2 of 2)

EFFECTIVITY
SIA ALL

D633AM101-SIA

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AIRCRAFT MAINTENANCE MANUAL

TASK 57-05-03-210-839

41. INTERNAL - GENERAL VISUAL: LEFT WING OUTBOARD REAR SPAR

(Figure 249)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-806	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
551	Left Wing - Rear Spar To Landing Gear Support Beam

C. Access Panels

Number	Name/Location
551BT	Upper Inboard Fixed Trailing Edge, MLG Actuator Access Panel
551CT	Upper Inboard Fixed Trailing Edge, Structural Pin Access Panel
551EB	Lower Inboard Fixed Trailing Edge, MLG Attach Fitting Access Panel

D. Inspection

SUBTASK 57-05-03-010-040

- (1) Open these access panels:

<u>Number</u>	<u>Name/Location</u>
551BT	Upper Inboard Fixed Trailing Edge, MLG Actuator Access Panel
551CT	Upper Inboard Fixed Trailing Edge, Structural Pin Access Panel
551EB	Lower Inboard Fixed Trailing Edge, MLG Attach Fitting Access Panel

SUBTASK 57-05-03-210-039

- (2) Do a General Visual inspection for the aft side of rear spar (chords, webs and stiffeners), including at main landing gear outboard support attachment, and at trunnion attachment.

SUBTASK 57-05-03-910-041

- (3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 57-05-03-410-040

- (4) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
551BT	Upper Inboard Fixed Trailing Edge, MLG Actuator Access Panel
551CT	Upper Inboard Fixed Trailing Edge, Structural Pin Access Panel
551EB	Lower Inboard Fixed Trailing Edge, MLG Attach Fitting Access Panel

———— **END OF TASK** ————

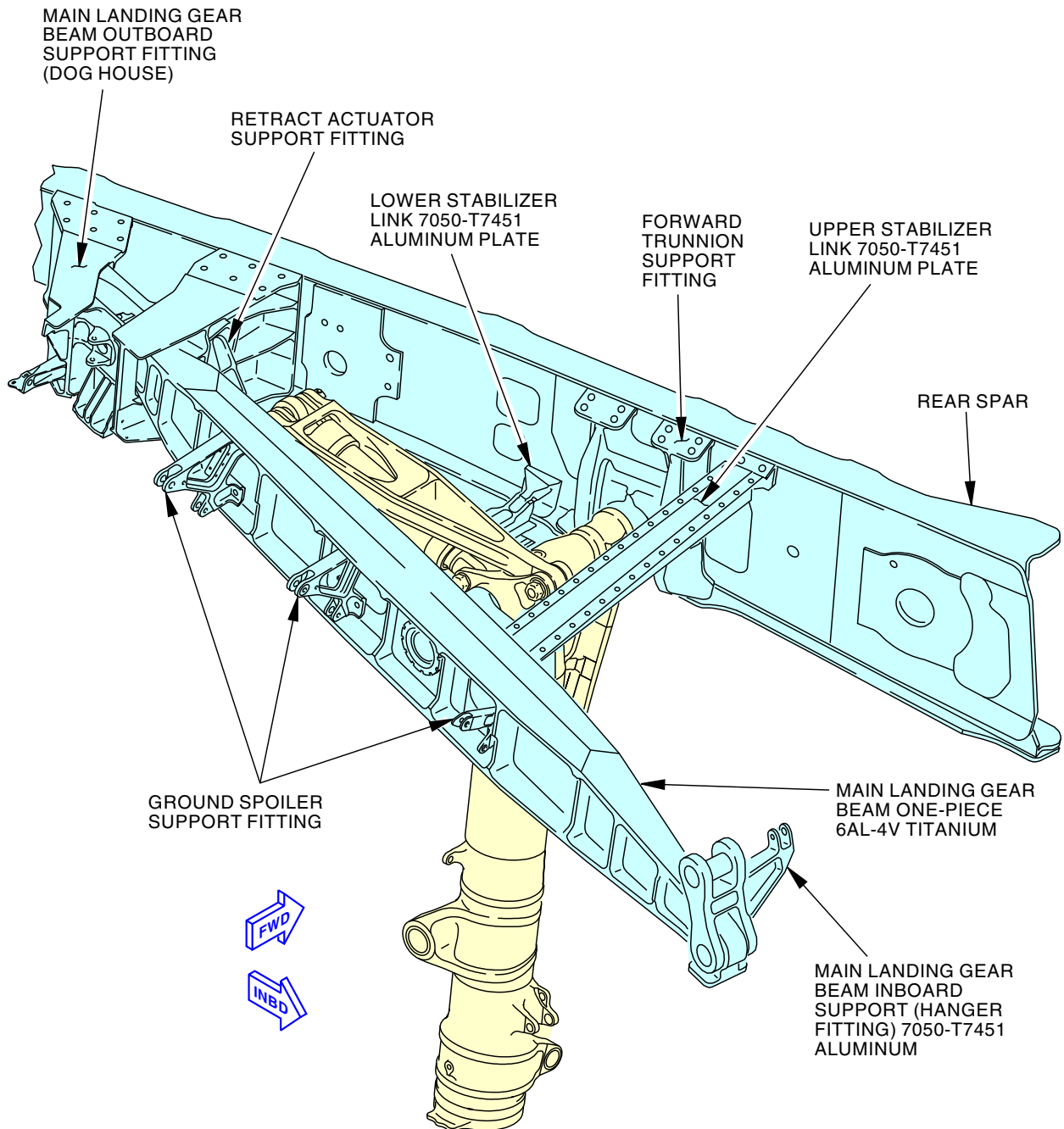
EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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2416539 S00061541018_V2

Aft side of left wing rear spar in zone 551
Figure 249/57-05-03-990-848 (Sheet 1 of 2)

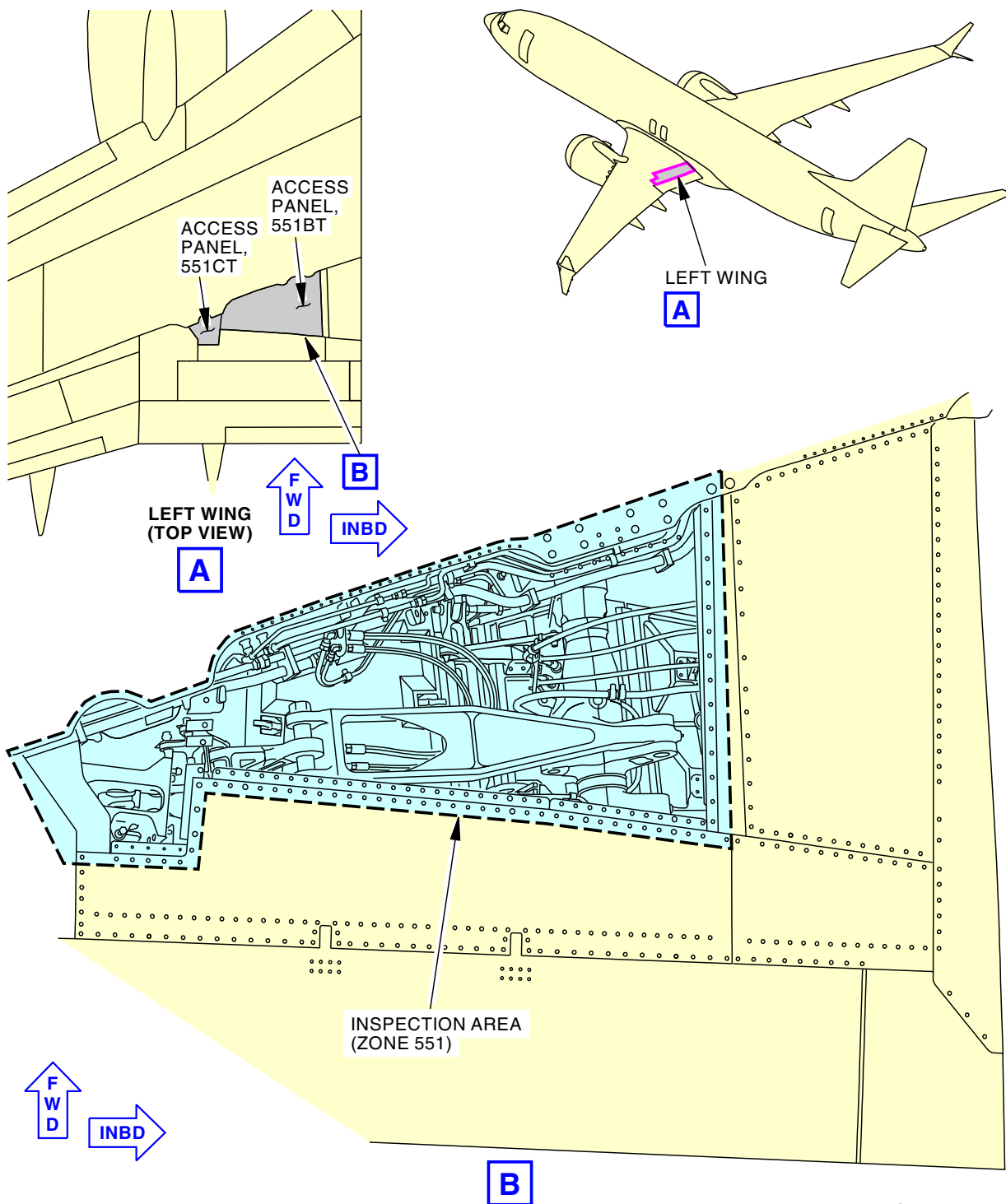
EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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2416542 S00061541023_V1

Aft side of left wing rear spar in zone 551
Figure 249/57-05-03-990-848 (Sheet 2 of 2)

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL

TASK 57-05-03-210-840

42. **INTERNAL - GENERAL VISUAL: RIGHT WING OUTBOARD REAR SPAR**

(Figure 250)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-806	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
651	Right Wing - Rear Spar to Landing Gear Support Beam

C. Access Panels

Number	Name/Location
651BT	Upper Inboard Fixed Trailing Edge, MLG Actuator Access Panel
651CT	Upper Inboard Fixed Trailing Edge, Structural Pin Access Panel
651ET	Upper Inboard Fixed Trailing Edge, MLG Beam Access Panel

D. Inspection

SUBTASK 57-05-03-010-041

- (1) Open these access panels:

Number	Name/Location
651BT	Upper Inboard Fixed Trailing Edge, MLG Actuator Access Panel
651CT	Upper Inboard Fixed Trailing Edge, Structural Pin Access Panel
651ET	Upper Inboard Fixed Trailing Edge, MLG Beam Access Panel

SUBTASK 57-05-03-210-040

- (2) Do a General Visual inspection for the aft side of rear spar (chords, webs and stiffeners), including at main landing gear outboard support attachment, and at trunnion attachment.

SUBTASK 57-05-03-910-042

- (3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 57-05-03-410-041

- (4) Close these access panels:

Number	Name/Location
651BT	Upper Inboard Fixed Trailing Edge, MLG Actuator Access Panel
651CT	Upper Inboard Fixed Trailing Edge, Structural Pin Access Panel
651ET	Upper Inboard Fixed Trailing Edge, MLG Beam Access Panel

————— **END OF TASK** —————

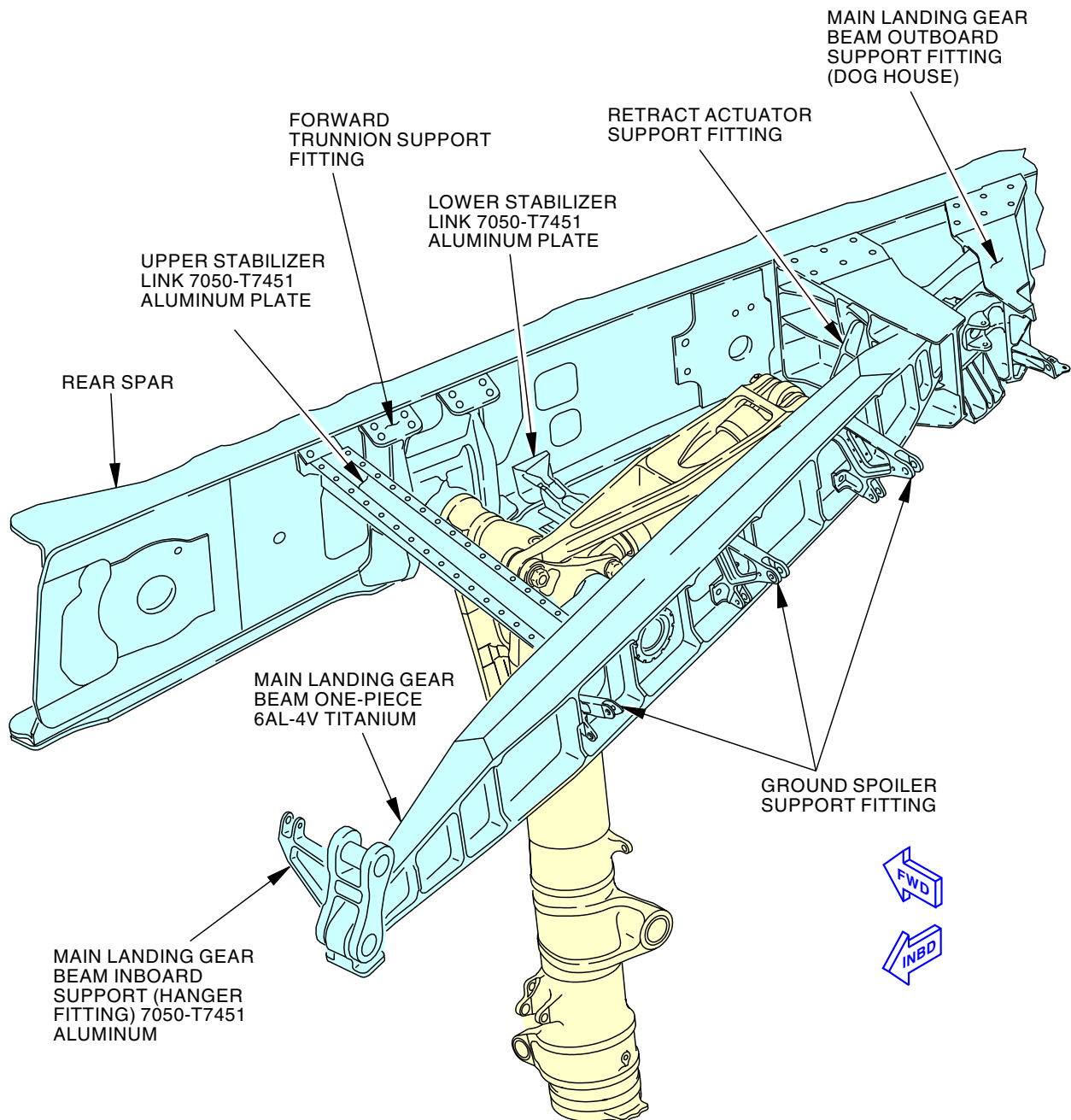
EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

57-05-03

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2416541 S00061541021_V1

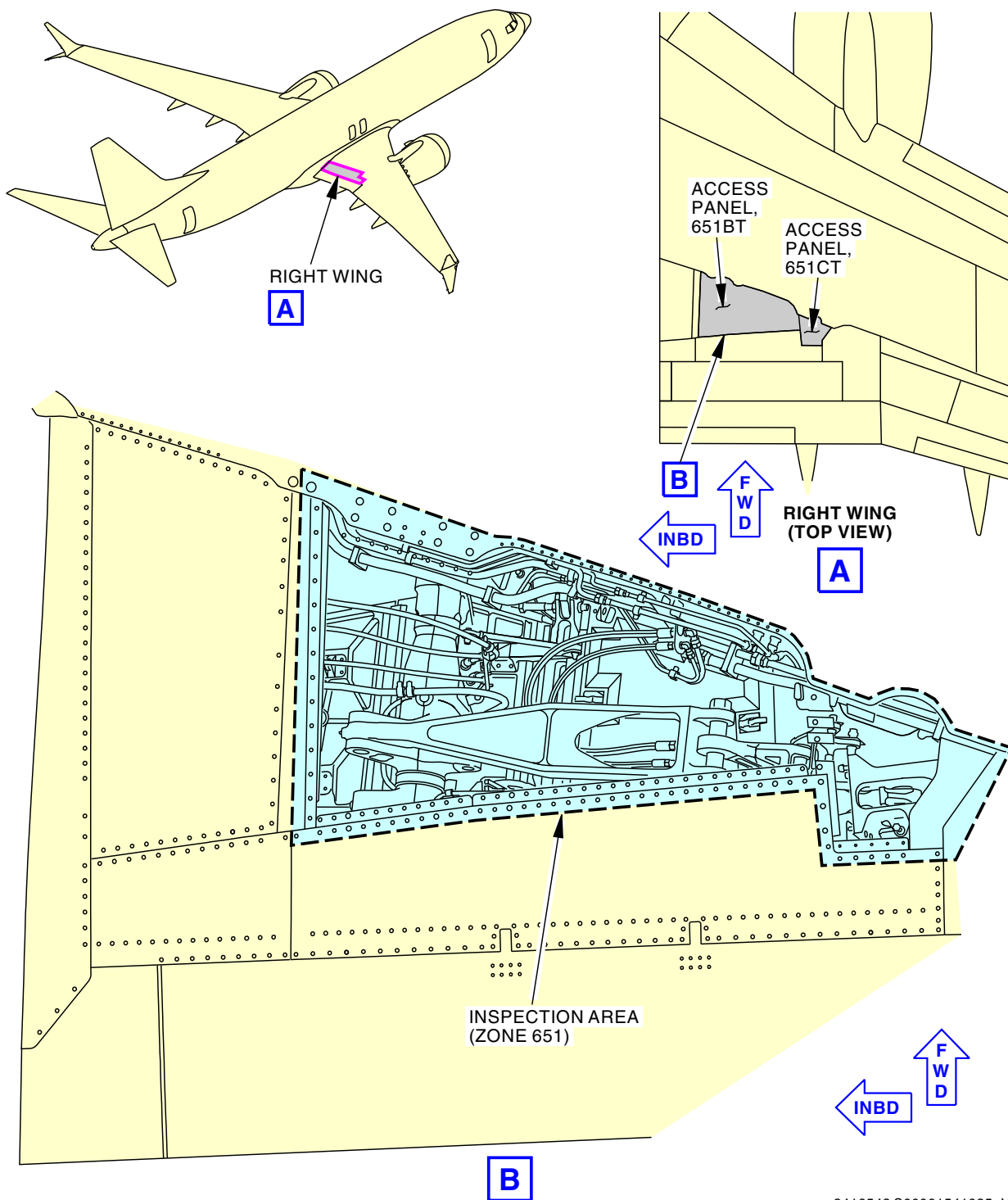
Aft side of right wing rear spar in zone 651
Figure 250/57-05-03-990-849 (Sheet 1 of 2)

EFFECTIVITY
SIA ALL

D633AM101-SIA

57-05-03

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2416543 S00061541025_V1

Aft side of right wing rear spar in zone 651
Figure 250/57-05-03-990-849 (Sheet 2 of 2)

EFFECTIVITY
SIA ALL

D633AM101-SIA

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AIRCRAFT MAINTENANCE MANUAL

TASK 57-05-03-210-841

43. INTERNAL - GENERAL VISUAL: LEFT WING OUTBOARD TRAILING EDGE STRUCTURE

(Figure 251)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
27-51-00-040-801	Trailing Edge Flap System Deactivation (P/B 201)
27-51-00-440-801	Trailing Edge Flap System Reactivation (P/B 201)
27-51-00-860-803	Extend the Trailing Edge Flaps (P/B 201)
27-51-00-860-804	Retract the Trailing Edge Flaps (P/B 201)
51-05-01-210-806	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
551	Left Wing - Rear Spar To Landing Gear Support Beam
552	Left Wing - Spoiler No. 6
553	Left Wing - Inboard Flap
561	Left Wing - Rear Spar to Trailing Edge, Outboard Of Inboard Flap, Inboard of Fixed Trailing Edge
562	Left Wing - Spoiler No. 5
563	Left Wing - Spoiler No. 4
564	Left Wing - Spoiler No. 3
565	Left Wing - Spoiler No. 2
566	Left Wing - Spoiler No. 1
567	Left Wing - Outboard Flap
571	Left Wing - Fixed Trailing Edge
572	Left Wing - Aileron

C. Access Panels

Number	Name/Location
551AB	Lower Inboard Fixed Trailing Edge Access Panel
551BB	Lower Inboard Fixed Trailing Edge, Gear Adjustment Door
551CB	Lower Inboard Fixed Trailing Edge, Gear Access Panel
551DB	Lower Inboard Fixed Trailing Edge, Lube Actuator & MLG Beam Outboard Attach Pin Access Panel
551EB	Lower Inboard Fixed Trailing Edge, MLG Attach Fitting Access Panel
551FB	Lower Inboard Fixed Trailing Edge, Landing Gear Access Panel
551GB	Lower inboard fixed trailing edge
561AB	Midspan Fixed Trailing Edge Access Panel - WBL 224
561BB	Midspan Fixed Trailing Edge Access Panel - WBL 305
561CB	Midspan Fixed Trailing Edge Access Panel - WBL 388
571AB	Lower Outboard Fixed Trailing Edge Access Panel at Deflector Rib
571BB	Lower Outboard Fixed Trailing Edge Access Panel
571CB	Lower Outboard Fixed Trailing Edge Access Panel
571DB	Lower Outboard Fixed Trailing Edge Access Panel
571EB	Lower Outboard Fixed Trailing Edge Wedge Access Panel

EFFECTIVITY
SIA ALL

D633AM101-SIA

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AIRCRAFT MAINTENANCE MANUAL

(Continued)

Number	Name/Location
571FB	Lower Outboard Fixed Trailing Edge Wedge Access Panel
572AB	Lower Aileron, Hinge Cover - WBL 423.00
572BB	Lower Aileron, Actuator Rod Fairing - WBL 472.00
572CB	Lower Aileron, Hinge Cover - WBL 447.00
572DB	Lower Aileron, Hinge Cover - WBL 469.00
572EB	Lower Aileron, Hinge Cover - WBL 481.00
572FB	Lower Aileron, Hinge Cover - WBL 502.00
572GB	Lower Aileron, Hinge Cover - WBL 528.00
572HB	Lower Aileron, Hinge Cover - WBL 553.00
S5001	Left Wing Outboard Trailing Edge Structure Inspection

D. Inspection

SUBTASK 57-05-03-860-001

- (1) Extend the trailing edge flaps to the 40-unit position, do this task: Extend the Trailing Edge Flaps, TASK 27-51-00-860-803.

SUBTASK 57-05-03-040-001

- (2) Do this task: Trailing Edge Flap System Deactivation, TASK 27-51-00-040-801.

SUBTASK 57-05-03-010-042

- (3) Open these access panels:

Number	Name/Location
551AB	Lower Inboard Fixed Trailing Edge Access Panel
551BB	Lower Inboard Fixed Trailing Edge, Gear Adjustment Door
551CB	Lower Inboard Fixed Trailing Edge, Gear Access Panel
551DB	Lower Inboard Fixed Trailing Edge, Lube Actuator & MLG Beam Outboard Attach Pin Access Panel
551EB	Lower Inboard Fixed Trailing Edge, MLG Attach Fitting Access Panel
551FB	Lower Inboard Fixed Trailing Edge, Landing Gear Access Panel
551GB	Lower inboard fixed trailing edge
561AB	Midspan Fixed Trailing Edge Access Panel - WBL 224
561BB	Midspan Fixed Trailing Edge Access Panel - WBL 305
561CB	Midspan Fixed Trailing Edge Access Panel - WBL 388
571AB	Lower Outboard Fixed Trailing Edge Access Panel at Deflector Rib
571BB	Lower Outboard Fixed Trailing Edge Access Panel
571CB	Lower Outboard Fixed Trailing Edge Access Panel
571DB	Lower Outboard Fixed Trailing Edge Access Panel
571EB	Lower Outboard Fixed Trailing Edge Wedge Access Panel
571FB	Lower Outboard Fixed Trailing Edge Wedge Access Panel
572AB	Lower Aileron, Hinge Cover - WBL 423.00
572BB	Lower Aileron, Actuator Rod Fairing - WBL 472.00
572CB	Lower Aileron, Hinge Cover - WBL 447.00
572DB	Lower Aileron, Hinge Cover - WBL 469.00
572EB	Lower Aileron, Hinge Cover - WBL 481.00
572FB	Lower Aileron, Hinge Cover - WBL 502.00
572GB	Lower Aileron, Hinge Cover - WBL 528.00

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL

(Continued)

<u>Number</u>	<u>Name/Location</u>

572HB	Lower Aileron, Hinge Cover - WBL 553.00

Special Access:

<u>Number</u>	<u>Name/Location</u>

S5001	Left Wing Outboard Trailing Edge Structure Inspection

NOTE: Flap extension required for inspection.

SUBTASK 57-05-03-210-041

- (4) Do a General Visual inspection for the interior of left wing trailing edge cavity, including skins, ribs, ailerons, and spoilers.

SUBTASK 57-05-03-910-043

- (5) Do this task: 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 57-05-03-410-042

- (6) Close these access panels:

<u>Number</u>	<u>Name/Location</u>

551AB	Lower Inboard Fixed Trailing Edge Access Panel
551BB	Lower Inboard Fixed Trailing Edge, Gear Adjustment Door
551CB	Lower Inboard Fixed Trailing Edge, Gear Access Panel
551DB	Lower Inboard Fixed Trailing Edge, Lube Actuator & MLG Beam Outboard Attach Pin Access Panel
551EB	Lower Inboard Fixed Trailing Edge, MLG Attach Fitting Access Panel
551FB	Lower Inboard Fixed Trailing Edge, Landing Gear Access Panel
551GB	Lower inboard fixed trailing edge
561AB	Midspan Fixed Trailing Edge Access Panel - WBL 224
561BB	Midspan Fixed Trailing Edge Access Panel - WBL 305
561CB	Midspan Fixed Trailing Edge Access Panel - WBL 388
571AB	Lower Outboard Fixed Trailing Edge Access Panel at Deflector Rib
571BB	Lower Outboard Fixed Trailing Edge Access Panel
571CB	Lower Outboard Fixed Trailing Edge Access Panel
571DB	Lower Outboard Fixed Trailing Edge Access Panel
571EB	Lower Outboard Fixed Trailing Edge Wedge Access Panel
571FB	Lower Outboard Fixed Trailing Edge Wedge Access Panel
572AB	Lower Aileron, Hinge Cover - WBL 423.00
572BB	Lower Aileron, Actuator Rod Fairing - WBL 472.00
572CB	Lower Aileron, Hinge Cover - WBL 447.00
572DB	Lower Aileron, Hinge Cover - WBL 469.00
572EB	Lower Aileron, Hinge Cover - WBL 481.00
572FB	Lower Aileron, Hinge Cover - WBL 502.00
572GB	Lower Aileron, Hinge Cover - WBL 528.00
572HB	Lower Aileron, Hinge Cover - WBL 553.00

SUBTASK 57-05-03-440-001

- (7) Do this task: Trailing Edge Flap System Reactivation, TASK 27-51-00-440-801.

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL

SUBTASK 57-05-03-860-002

- (8) Retract the trailing edge flaps to the UP position, do this task: Retract the Trailing Edge Flaps, TASK 27-51-00-860-804.

————— **END OF TASK** —————

EFFECTIVITY
SIA ALL

D633AM101-SIA

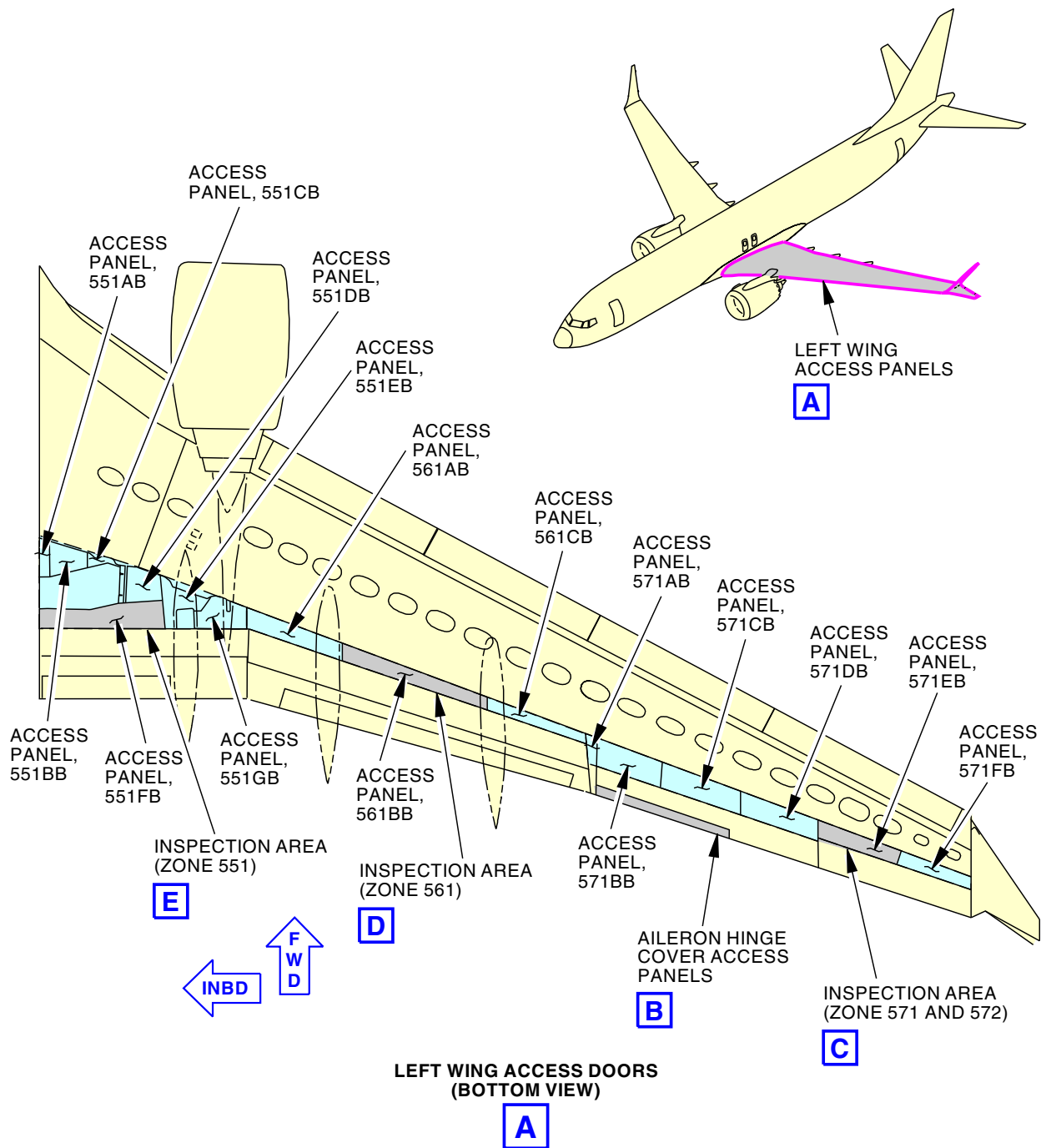
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AIRCRAFT MAINTENANCE MANUAL



MPD ITEM
57-270-01

2416544 S00061541027_V2

INTERNAL-GENERAL VISUAL: LEFT WING OUTBOARD TRAILING EDGE STRUCTURE
Figure 251/57-05-03-990-850 (Sheet 1 of 6)

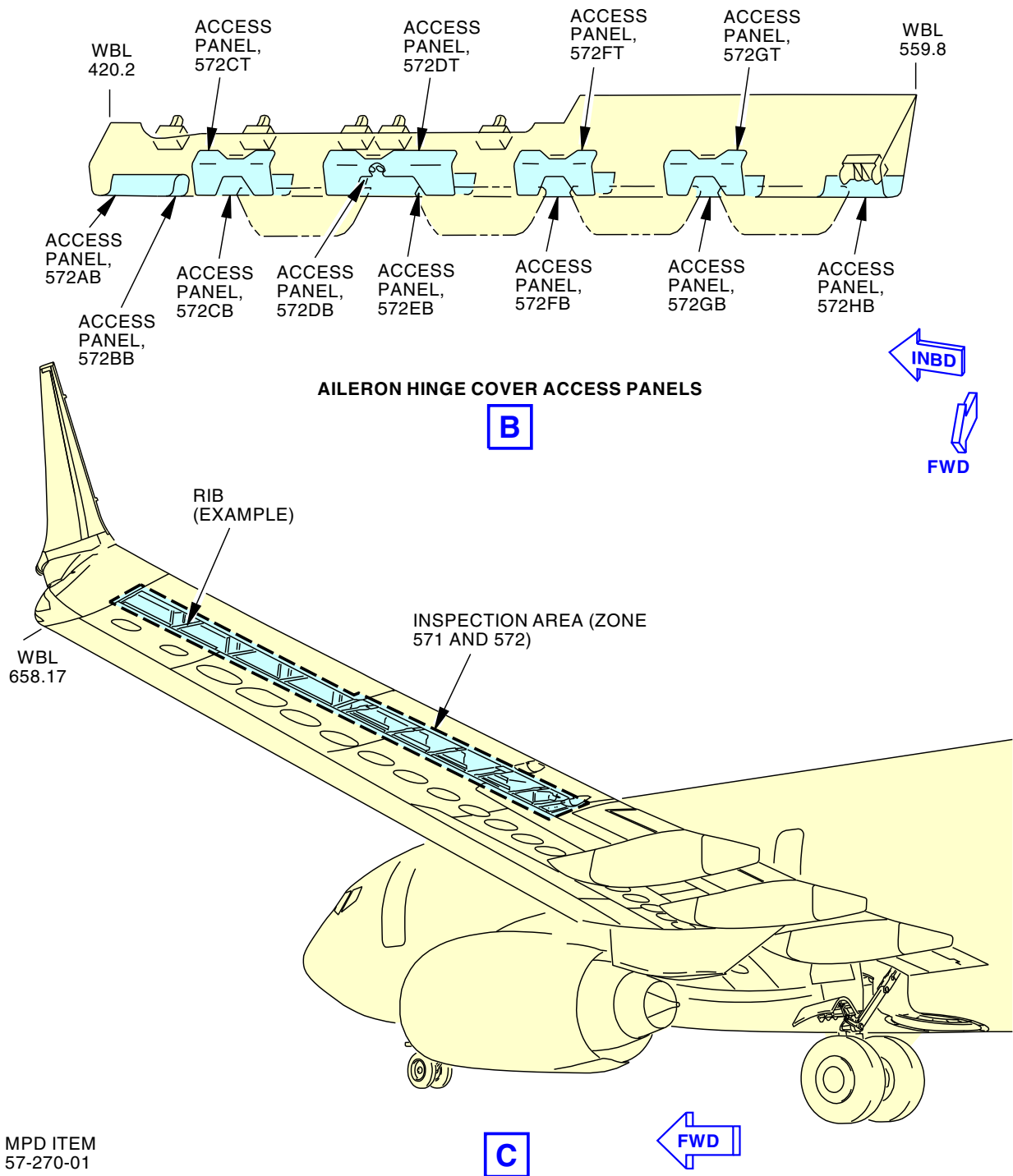
EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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MPD ITEM
57-270-01

2416545 S00061541028_V1

INTERNAL-GENERAL VISUAL: LEFT WING OUTBOARD TRAILING EDGE STRUCTURE
Figure 251/57-05-03-990-850 (Sheet 2 of 6)

EFFECTIVITY
SIA ALL

D633AM101-SIA

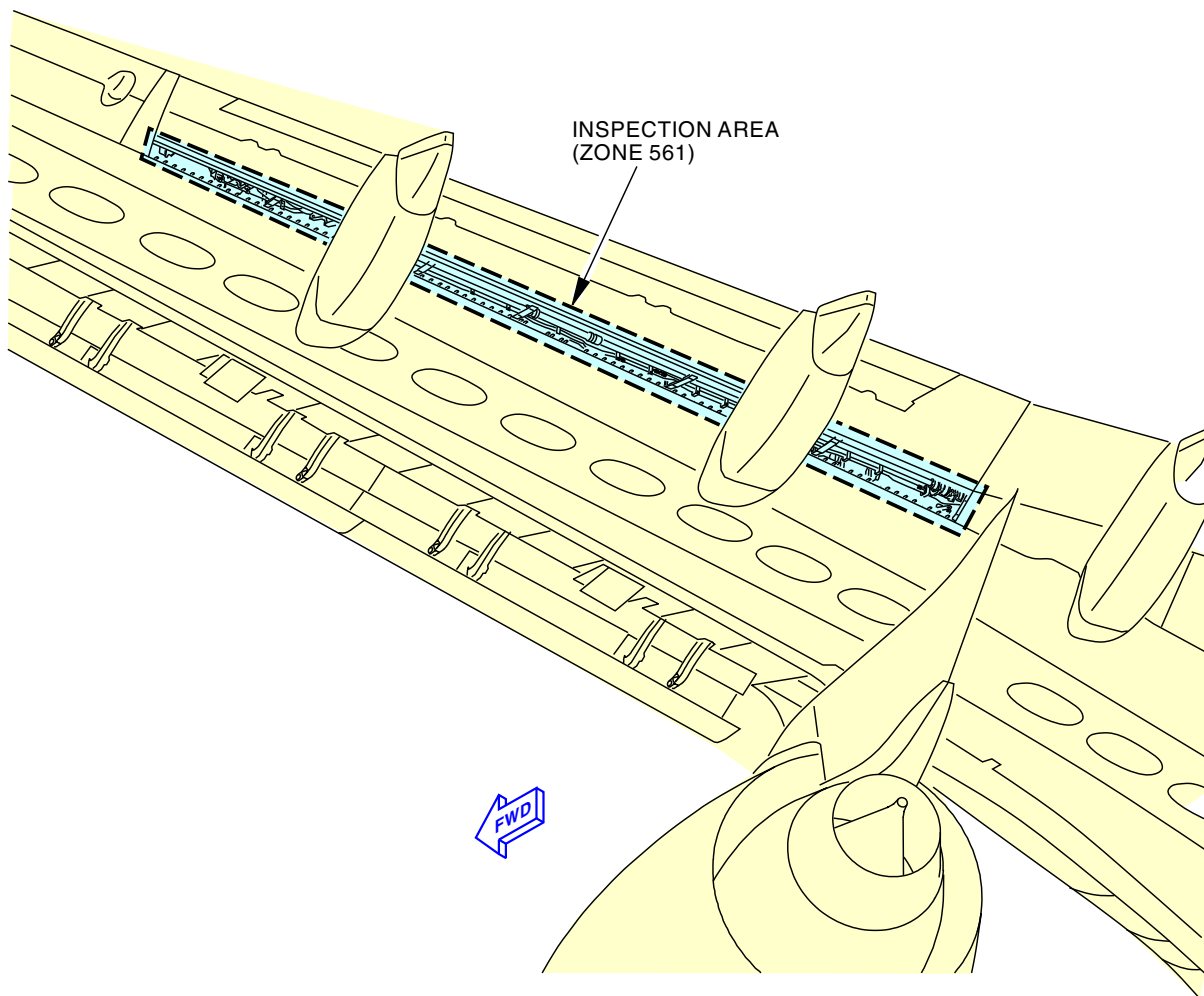
ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL



D

MPD ITEM
57-270-01

2416546 S00061541029_V2

INTERNAL-GENERAL VISUAL: LEFT WING OUTBOARD TRAILING EDGE STRUCTURE
Figure 251/57-05-03-990-850 (Sheet 3 of 6)

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

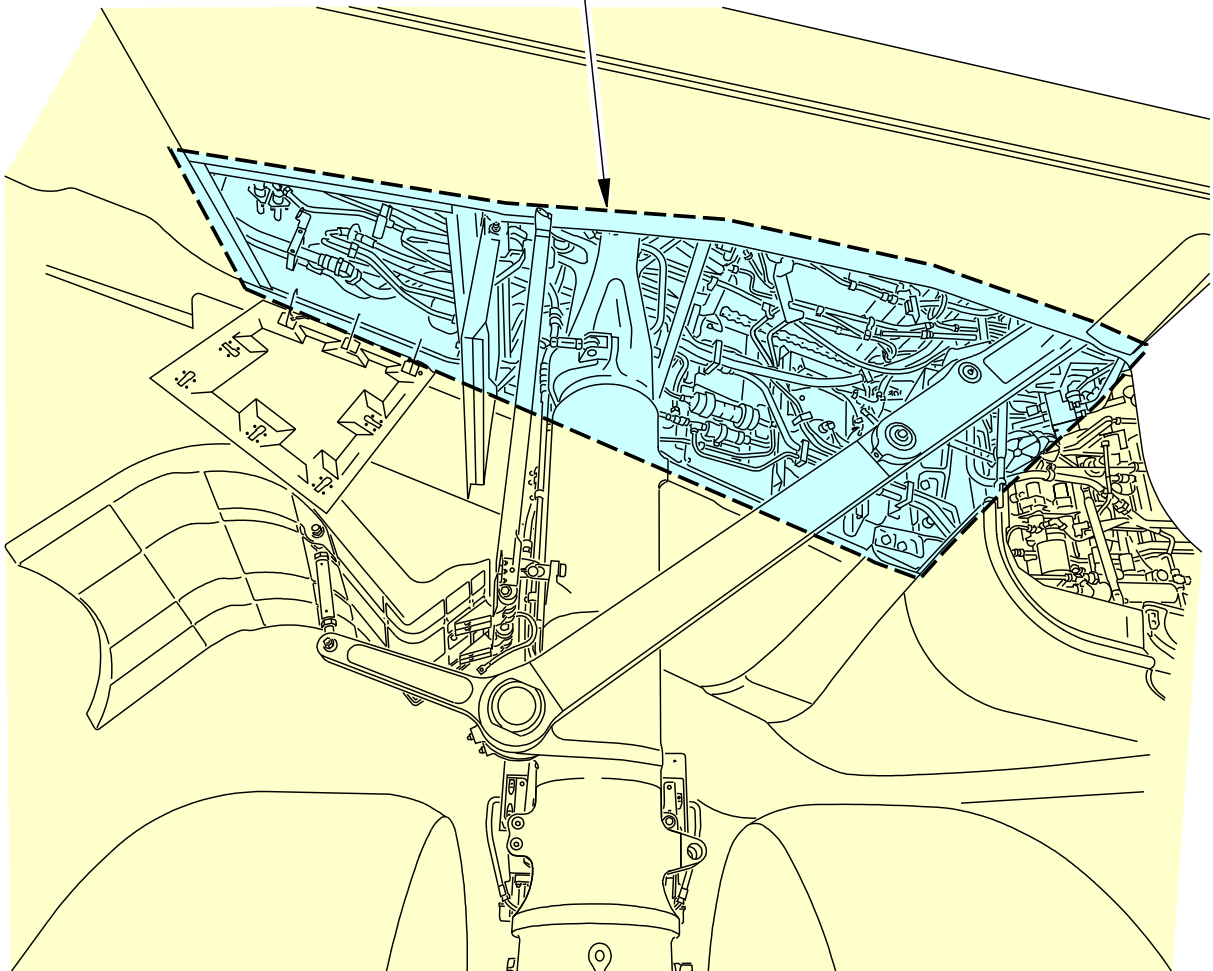
57-05-03

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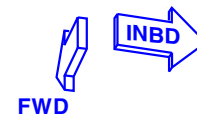


737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL

INSPECTION AREA (SKIN
PANELS ONLY) (ZONE 551)



E



MPD ITEM
57-270-01

2416547 S00061541030_V1

INTERNAL-GENERAL VISUAL: LEFT WING OUTBOARD TRAILING EDGE STRUCTURE
Figure 251/57-05-03-990-850 (Sheet 4 of 6)

EFFECTIVITY
SIA ALL

D633AM101-SIA

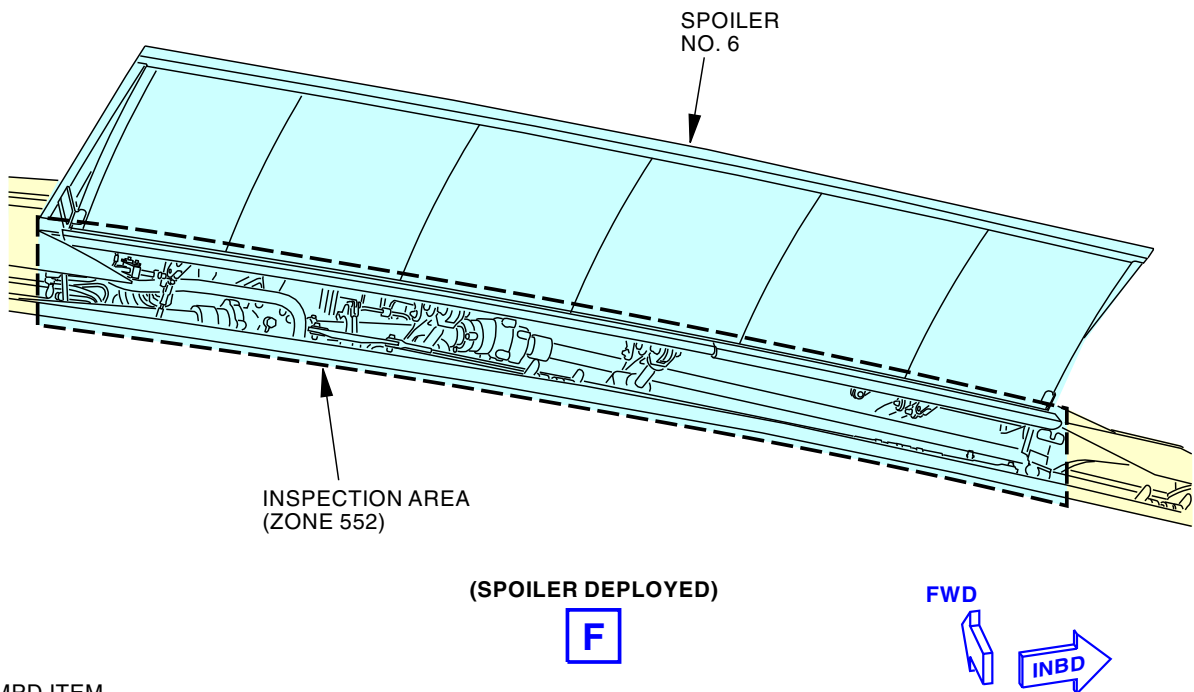
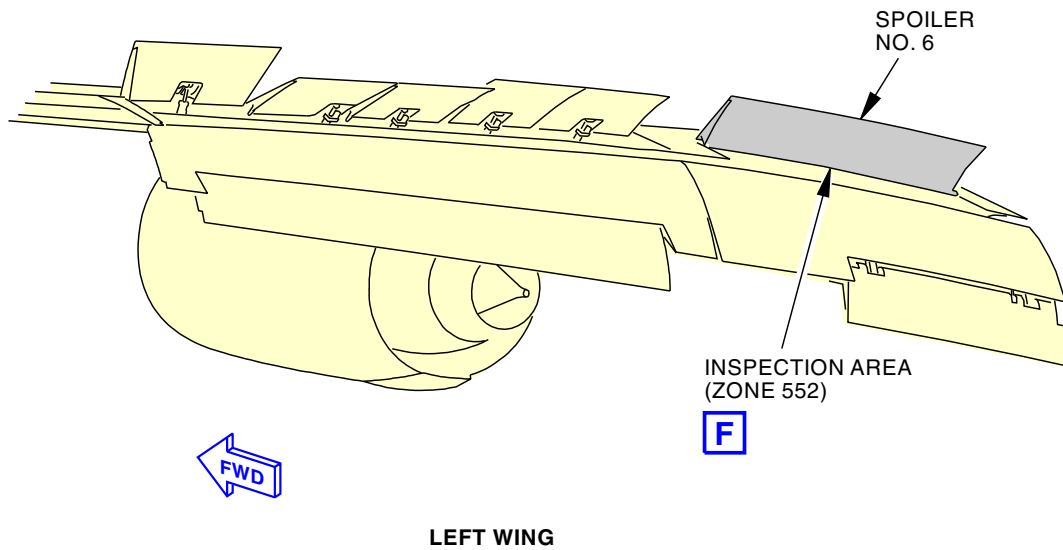
ECCN 9E991 BOEING PROPRIETARY - See title page for details

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737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL



MPD ITEM
57-270-01

2416548 S00061541031_V2

INTERNAL-GENERAL VISUAL: LEFT WING OUTBOARD TRAILING EDGE STRUCTURE
Figure 251/57-05-03-990-850 (Sheet 5 of 6)

EFFECTIVITY
SIA ALL

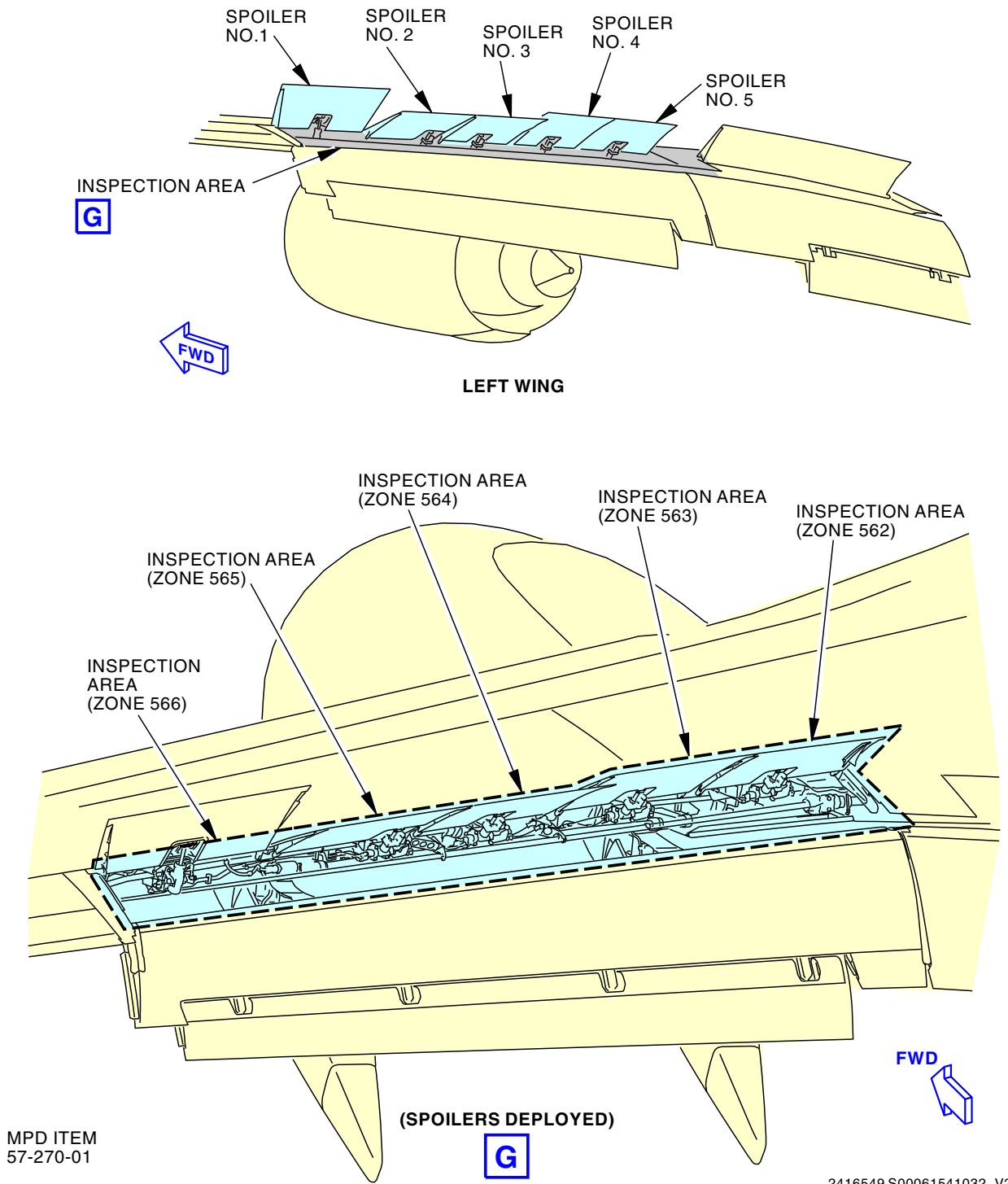
57-05-03

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AIRCRAFT MAINTENANCE MANUAL



INTERNAL-GENERAL VISUAL: LEFT WING OUTBOARD TRAILING EDGE STRUCTURE
Figure 251/57-05-03-990-850 (Sheet 6 of 6)

EFFECTIVITY
SIA ALL

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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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TASK 57-05-03-210-842

44. INTERNAL - GENERAL VISUAL: RIGHT WING OUTBOARD TRAILING EDGE STRUCTURE

(Figure 252)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
27-51-00-040-801	Trailing Edge Flap System Deactivation (P/B 201)
27-51-00-440-801	Trailing Edge Flap System Reactivation (P/B 201)
27-51-00-860-803	Extend the Trailing Edge Flaps (P/B 201)
27-51-00-860-804	Retract the Trailing Edge Flaps (P/B 201)
51-05-01-210-806	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
651	Right Wing - Rear Spar to Landing Gear Support Beam
652	Right Wing - Spoiler No. 7
653	Right Wing - Inboard Flap
661	Right Wing - Rear Spar to Trailing Edge, Outboard of Inboard Flap, Inboard of Fixed Trailing Edge
662	Right Wing - Spoiler No. 8
663	Right Wing - Spoiler No. 9
664	Right Wing - Spoiler No. 10
665	Right Wing - Spoiler No. 11
666	Right Wing - Spoiler No. 12
667	Right Wing - Outboard Flap
671	Right Wing - Fixed Trailing Edge
672	Right Wing - Aileron

C. Access Panels

Number	Name/Location
651AB	Lower Inboard Fixed Trailing Edge Access Panel
651BB	Lower Inboard Fixed Trailing Edge, Gear Adjustment Door
651CB	Lower Inboard Fixed Trailing Edge, Gear Access Panel
651DB	Lower Inboard Fixed Trailing Edge, Lube Actuator & MLG Beam Outboard Attach Pin Access Panel
651EB	Lower Inboard Fixed Trailing Edge, MLG Attach Fitting Access Panel
651FB	Lower Inboard Fixed Trailing Edge, Landing Gear Access Panel
651GB	Lower inboard fixed trailing edge
661AB	Midspan Fixed Trailing Edge Access Panel - WBL 224
661BB	Midspan Fixed Trailing Edge Access Panel - WBL 305
661CB	Midspan Fixed Trailing Edge Access Panel - WBL 388
671AB	Lower Outboard Fixed Trailing Edge Access Panel
671BB	Lower Outboard Fixed Trailing Edge Access Panel
671CB	Lower Outboard Fixed Trailing Edge Access Panel
671DB	Lower Outboard Fixed Trailing Edge Access Panel
671EB	Lower Outboard Fixed Trailing Edge, Wedge Access Panel

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL

(Continued)

Number	Name/Location
671FB	Lower Outboard Fixed Trailing Edge, Wedge Access Panel
672AB	Lower Aileron, Hinge Cover - WBL 423.00
672BB	Lower Aileron, Actuator Rod Fairing - WBL 472.00
672CB	Lower Aileron, Hinge Cover - WBL 447.00
672DB	Lower Aileron, Hinge Cover - WBL 469.00
672EB	Lower Aileron, Hinge Cover - WBL 481.00
672FB	Lower Aileron, Hinge Cover - WBL 502.00
672GB	Lower Aileron, Hinge Cover - WBL 528.00
672HB	Lower Aileron, Hinge Cover - WBL 553.00
S6001	Right Outboard Wing Inspection

D. Inspection

SUBTASK 57-05-03-860-003

- (1) Extend the trailing edge flaps to the 40-unit position, do this task: Extend the Trailing Edge Flaps, TASK 27-51-00-860-803.

SUBTASK 57-05-03-040-002

- (2) Do this task: Trailing Edge Flap System Deactivation, TASK 27-51-00-040-801.

SUBTASK 57-05-03-010-043

- (3) Open these access panels:

Number	Name/Location
651AB	Lower Inboard Fixed Trailing Edge Access Panel
651BB	Lower Inboard Fixed Trailing Edge, Gear Adjustment Door
651CB	Lower Inboard Fixed Trailing Edge, Gear Access Panel
651DB	Lower Inboard Fixed Trailing Edge, Lube Actuator & MLG Beam Outboard Attach Pin Access Panel
651EB	Lower Inboard Fixed Trailing Edge, MLG Attach Fitting Access Panel
651FB	Lower Inboard Fixed Trailing Edge, Landing Gear Access Panel
651GB	Lower inboard fixed trailing edge
661AB	Midspan Fixed Trailing Edge Access Panel - WBL 224
661BB	Midspan Fixed Trailing Edge Access Panel - WBL 305
661CB	Midspan Fixed Trailing Edge Access Panel - WBL 388
671AB	Lower Outboard Fixed Trailing Edge Access Panel
671BB	Lower Outboard Fixed Trailing Edge Access Panel
671CB	Lower Outboard Fixed Trailing Edge Access Panel
671DB	Lower Outboard Fixed Trailing Edge Access Panel
671EB	Lower Outboard Fixed Trailing Edge, Wedge Access Panel
671FB	Lower Outboard Fixed Trailing Edge, Wedge Access Panel
672AB	Lower Aileron, Hinge Cover - WBL 423.00
672BB	Lower Aileron, Actuator Rod Fairing - WBL 472.00
672CB	Lower Aileron, Hinge Cover - WBL 447.00
672DB	Lower Aileron, Hinge Cover - WBL 469.00
672EB	Lower Aileron, Hinge Cover - WBL 481.00
672FB	Lower Aileron, Hinge Cover - WBL 502.00
672GB	Lower Aileron, Hinge Cover - WBL 528.00

EFFECTIVITY
SIA ALL

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AIRCRAFT MAINTENANCE MANUAL

(Continued)

<u>Number</u>	<u>Name/Location</u>
672HB	Lower Aileron, Hinge Cover - WBL 553.00

Special Access:

<u>Number</u>	<u>Name/Location</u>
S6001	Right Outboard Wing Inspection

NOTE: Flap extension required for inspection.

SUBTASK 57-05-03-210-042

- (4) Do a General Visual inspection for the interior of right wing trailing edge cavity, including skins, ribs, ailerons, and spoilers.

SUBTASK 57-05-03-910-044

- (5) Do this task: 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 57-05-03-410-043

- (6) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
651AB	Lower Inboard Fixed Trailing Edge Access Panel
651BB	Lower Inboard Fixed Trailing Edge, Gear Adjustment Door
651CB	Lower Inboard Fixed Trailing Edge, Gear Access Panel
651DB	Lower Inboard Fixed Trailing Edge, Lube Actuator & MLG Beam Outboard Attach Pin Access Panel
651EB	Lower Inboard Fixed Trailing Edge, MLG Attach Fitting Access Panel
651FB	Lower Inboard Fixed Trailing Edge, Landing Gear Access Panel
651GB	Lower inboard fixed trailing edge
661AB	Midspan Fixed Trailing Edge Access Panel - WBL 224
661BB	Midspan Fixed Trailing Edge Access Panel - WBL 305
661CB	Midspan Fixed Trailing Edge Access Panel - WBL 388
671AB	Lower Outboard Fixed Trailing Edge Access Panel
671BB	Lower Outboard Fixed Trailing Edge Access Panel
671CB	Lower Outboard Fixed Trailing Edge Access Panel
671DB	Lower Outboard Fixed Trailing Edge Access Panel
671EB	Lower Outboard Fixed Trailing Edge, Wedge Access Panel
671FB	Lower Outboard Fixed Trailing Edge, Wedge Access Panel
672AB	Lower Aileron, Hinge Cover - WBL 423.00
672BB	Lower Aileron, Actuator Rod Fairing - WBL 472.00
672CB	Lower Aileron, Hinge Cover - WBL 447.00
672DB	Lower Aileron, Hinge Cover - WBL 469.00
672EB	Lower Aileron, Hinge Cover - WBL 481.00
672FB	Lower Aileron, Hinge Cover - WBL 502.00
672GB	Lower Aileron, Hinge Cover - WBL 528.00
672HB	Lower Aileron, Hinge Cover - WBL 553.00

SUBTASK 57-05-03-440-002

- (7) Do this task: Trailing Edge Flap System Reactivation, TASK 27-51-00-440-801.

EFFECTIVITY
SIA ALL

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SUBTASK 57-05-03-860-004

- (8) Retract the trailing edge flaps to the UP position, do this task: Retract the Trailing Edge Flaps, TASK 27-51-00-860-804.

————— **END OF TASK** —————

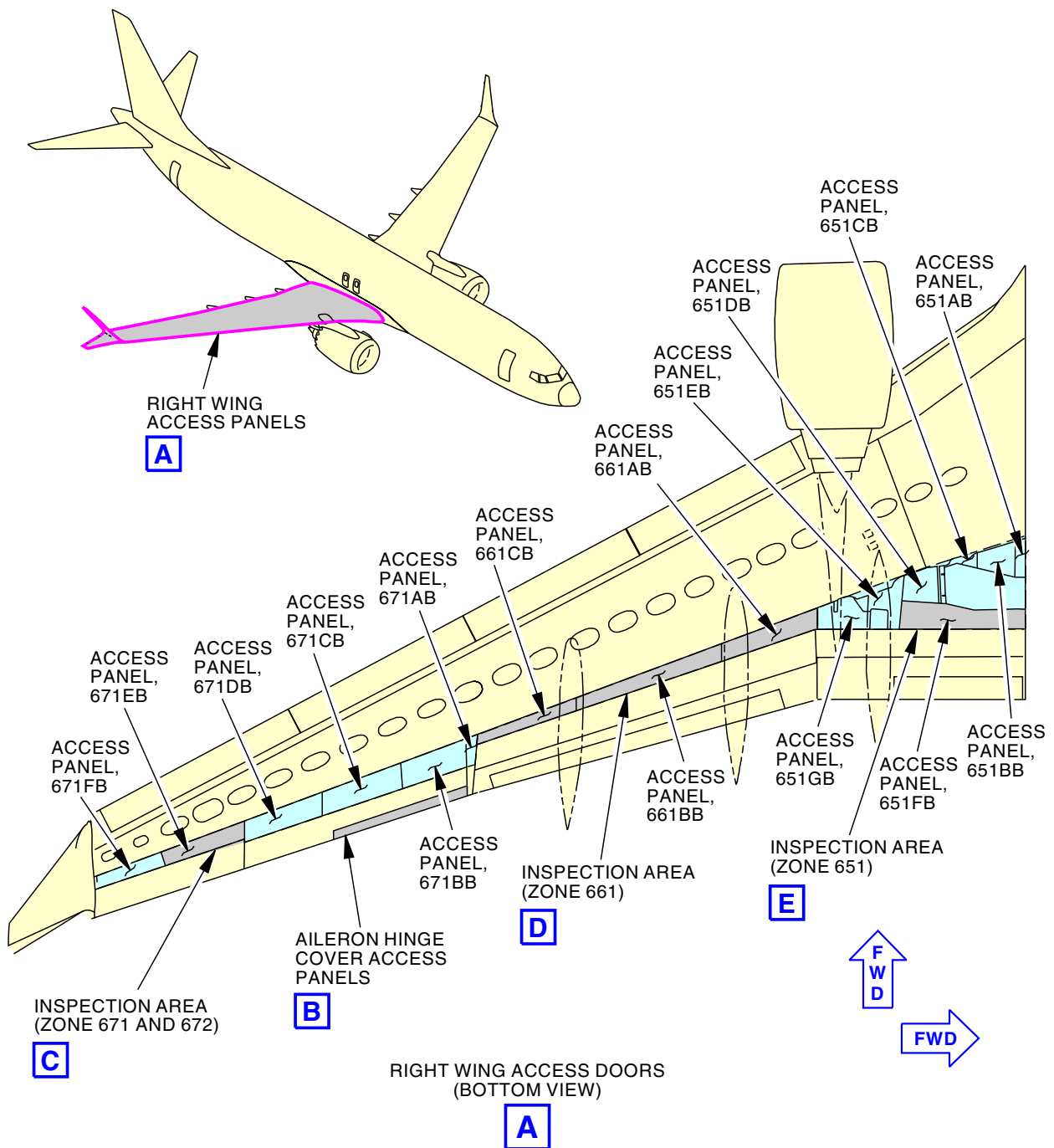
EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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MPD ITEM
57-270-02

2416550 S00061541034_V2

INTERNAL-GENERAL VISUAL: INTERNAL-RIGHT WING OUTBOARD TRAILING EDGE STRUCTURE
Figure 252/57-05-03-990-851 (Sheet 1 of 6)

EFFECTIVITY SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

57-05-03

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Diagram illustrating the inspection area (Zone 671 and 672) on a wing structure. The diagram shows a cross-section of the wing with a dashed line indicating the inspection area. The area is labeled "INSPECTION AREA (ZONE 671 AND 672)". A specific point on the wing is labeled "WBL 658.17". A rib is labeled "RIB (EXAMPLE)".

C

2416551 S00061541035_V1

INTERNAL-GENERAL VISUAL: INTERNAL-RIGHT WING OUTBOARD TRAILING EDGE STRUCTURE
Figure 252/57-05-03-990-851 (Sheet 2 of 6)

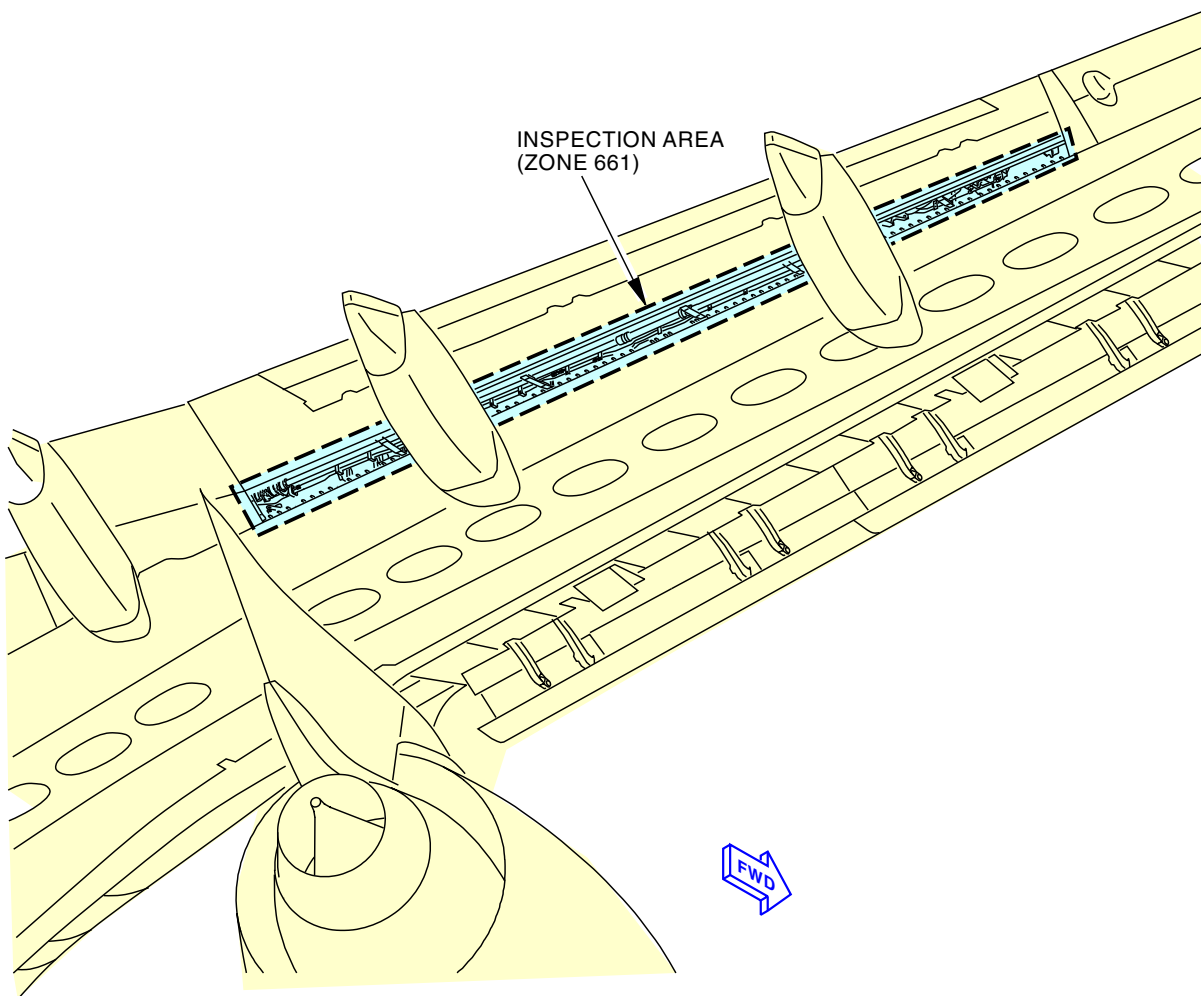
57-05-03

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details



737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL



D

MPD ITEM
57-270-02

2416552 S00061541036_V1

INTERNAL-GENERAL VISUAL: INTERNAL-RIGHT WING OUTBOARD TRAILING EDGE STRUCTURE
Figure 252/57-05-03-990-851 (Sheet 3 of 6)

EFFECTIVITY
SIA ALL

D633AM101-SIA

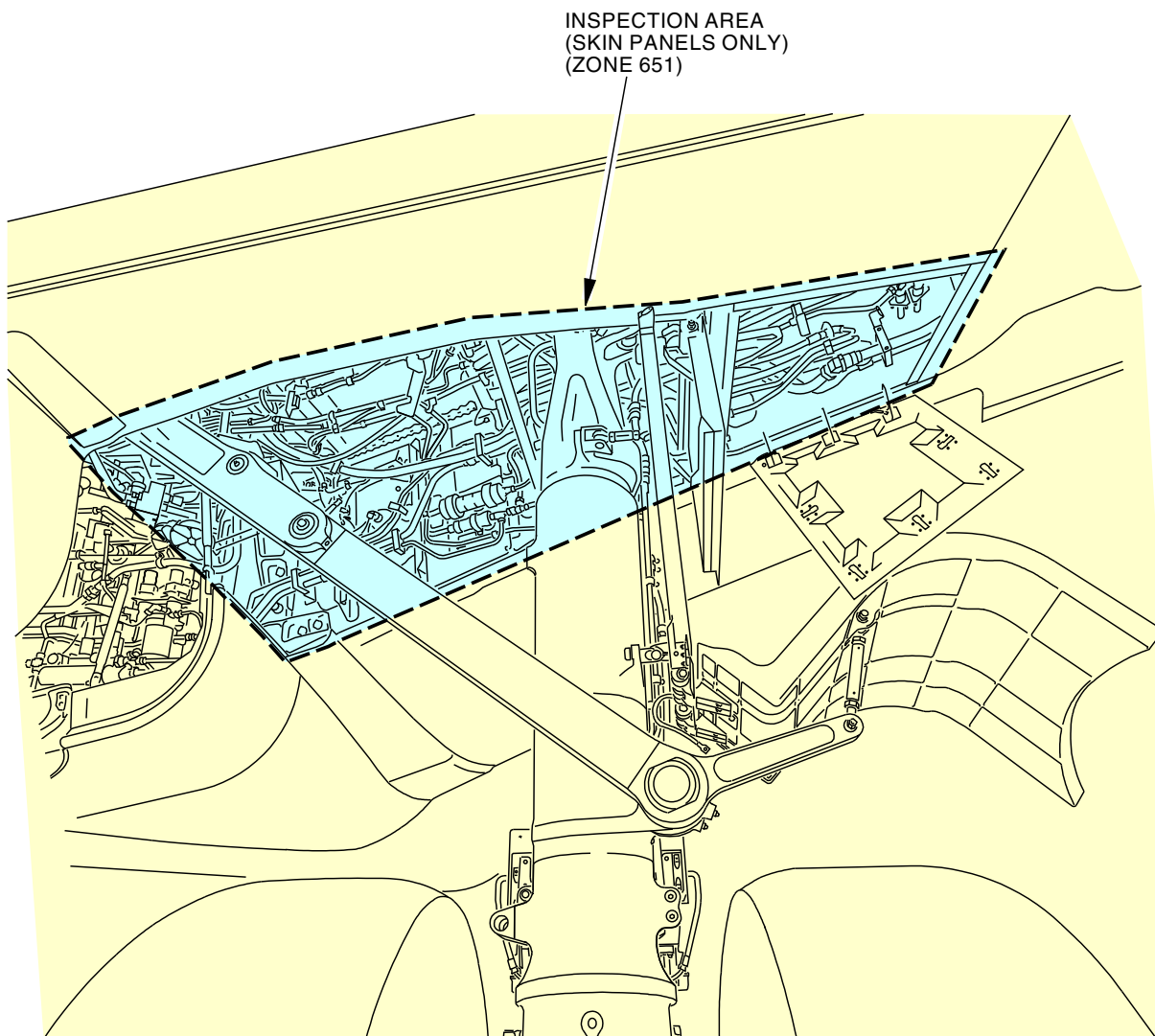
ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL



FWD



MPD ITEM
57-270-02

2416553 S00061541037_V1

INTERNAL-GENERAL VISUAL: INTERNAL-RIGHT WING OUTBOARD TRAILING EDGE STRUCTURE
Figure 252/57-05-03-990-851 (Sheet 4 of 6)

EFFECTIVITY
SIA ALL

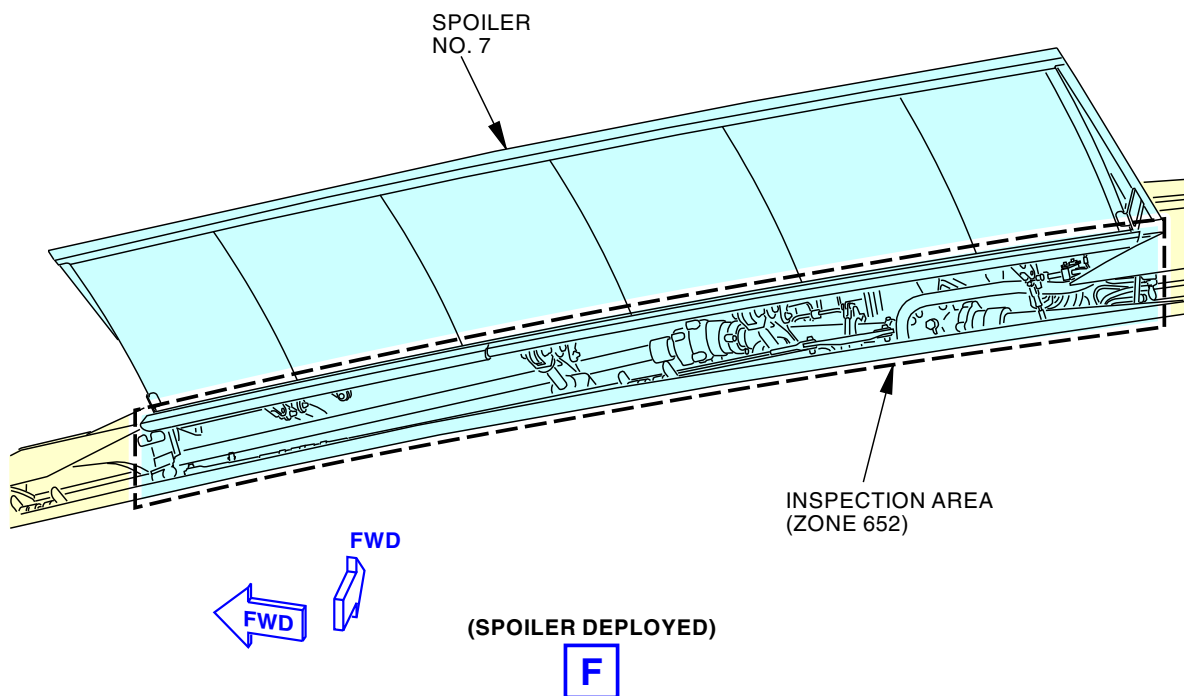
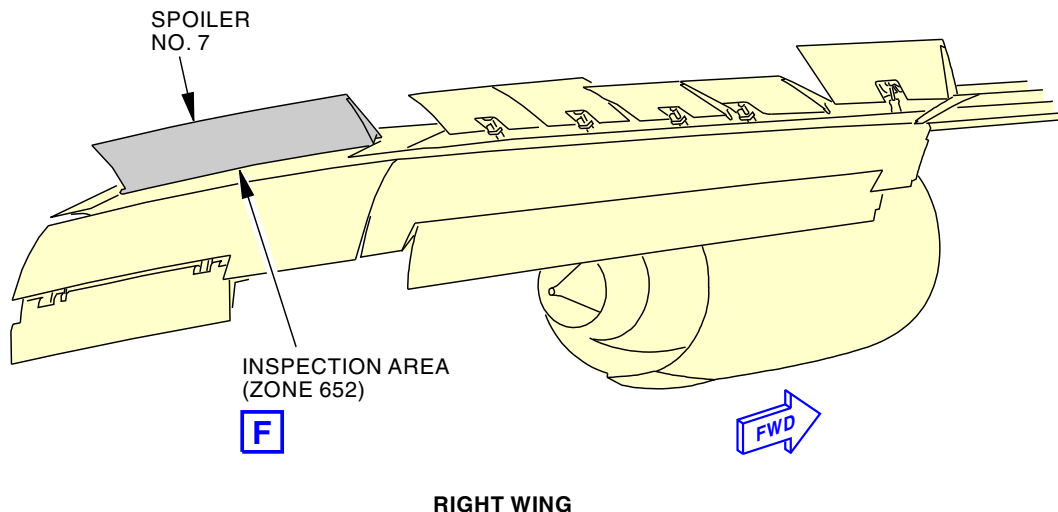
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737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL



MPD ITEM
57-270-02

2416554 S00061541038_V2

INTERNAL-GENERAL VISUAL: INTERNAL-RIGHT WING OUTBOARD TRAILING EDGE STRUCTURE
Figure 252/57-05-03-990-851 (Sheet 5 of 6)

EFFECTIVITY
SIA ALL

D633AM101-SIA

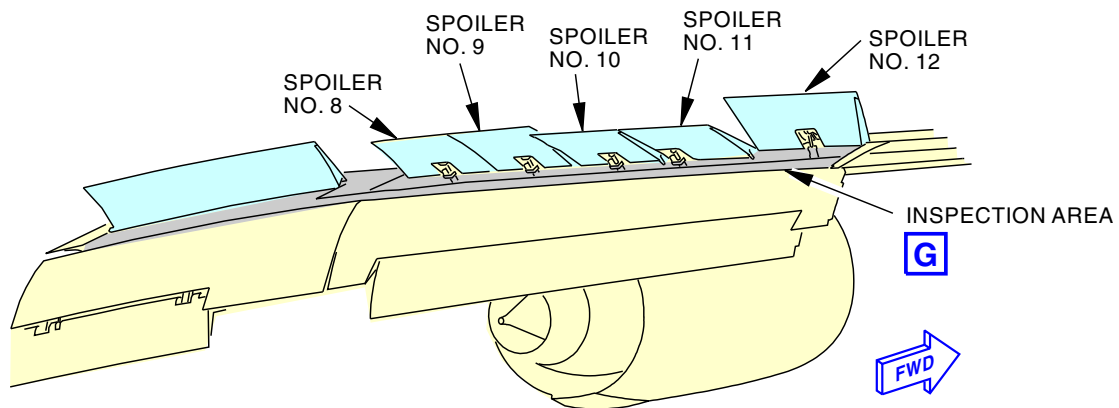
ECCN 9E991 BOEING PROPRIETARY - See title page for details

57-05-03

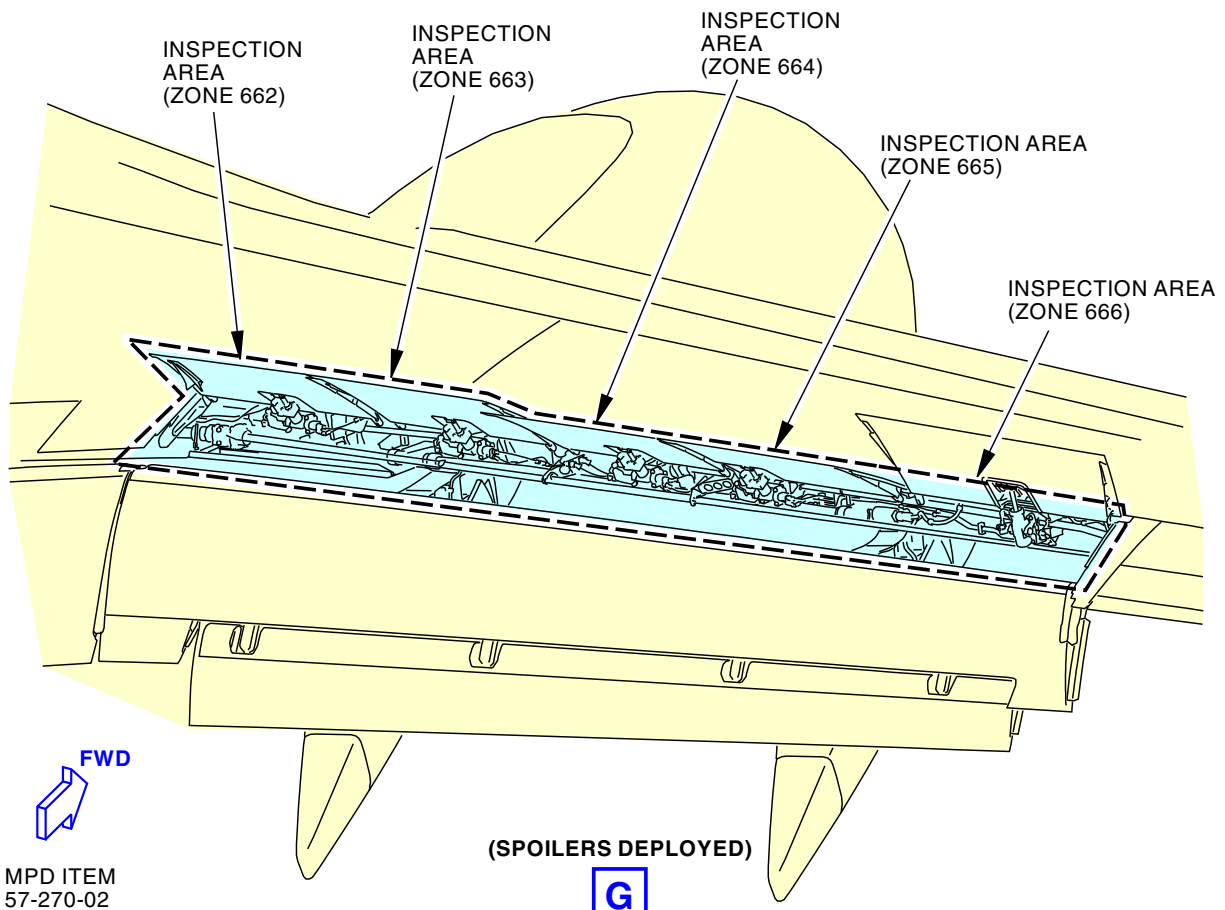
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AIRCRAFT MAINTENANCE MANUAL



RIGHT WING



2416555 S00061541039_V2

INTERNAL-GENERAL VISUAL: INTERNAL-RIGHT WING OUTBOARD TRAILING EDGE STRUCTURE
Figure 252/57-05-03-990-851 (Sheet 6 of 6)

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL

TASK 57-05-03-210-843

45. INTERNAL - GENERAL VISUAL: LEFT INBOARD GROUND SPOILER

(Figure 253)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-801	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
552	Left Wing - Spoiler No. 6

C. Access Panels

Number	Name/Location
S5521	Left Inboard Ground Spoiler Inspection

D. Inspection

SUBTASK 57-05-03-010-044

(1) Special Access:

Number	Name/Location
S5521	Left Inboard Ground Spoiler Inspection

NOTE: Extend flaps and ground spoilers.

SUBTASK 57-05-03-210-043

(2) Do a General Visual inspection of the left inboard ground spoiler actuator fittings.

SUBTASK 57-05-03-910-045

(3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-801.

———— **END OF TASK** ————

EFFECTIVITY
SIA ALL

D633AM101-SIA

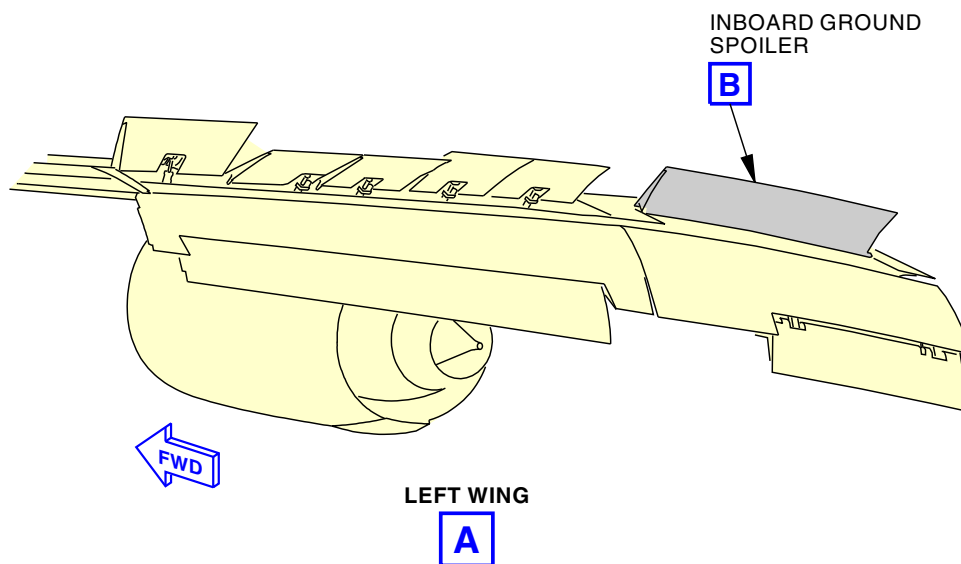
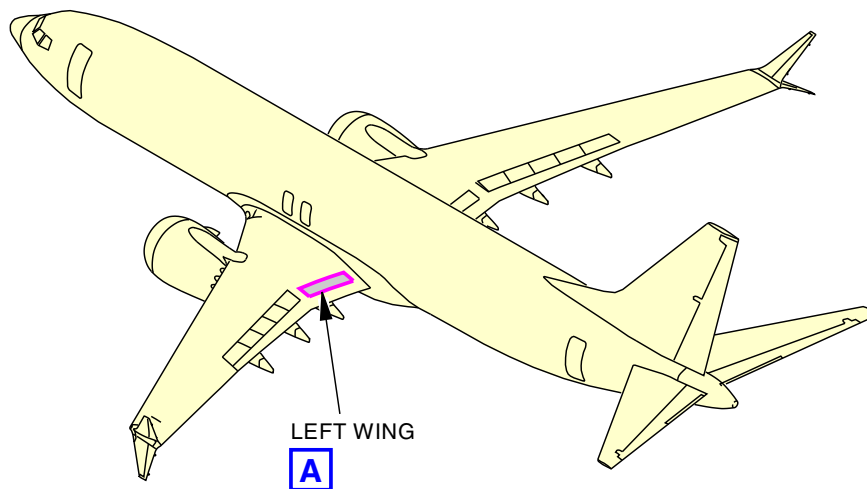
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737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL



2416556 S00061541041_V1

Left Inboard Ground Spoiler General Visual (Internal)
Figure 253/57-05-03-990-852 (Sheet 1 of 2)

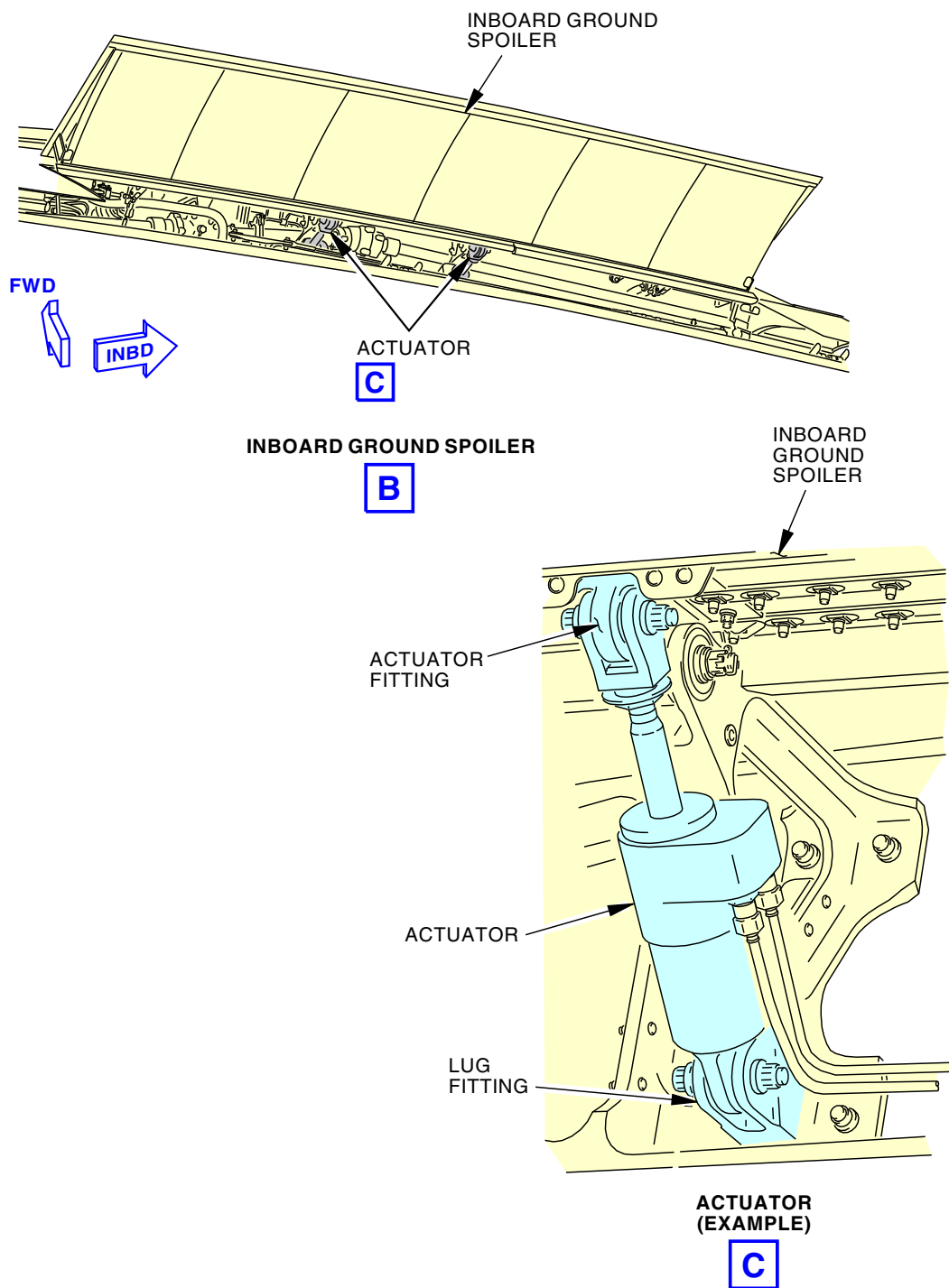
EFFECTIVITY
SIA ALL

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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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2416557 S00061541042_V3

Left Inboard Ground Spoiler General Visual (Internal)
Figure 253/57-05-03-990-852 (Sheet 2 of 2)

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL

TASK 57-05-03-210-844

46. INTERNAL - GENERAL VISUAL: RIGHT INBOARD GROUND SPOILER
(Figure 254)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-801	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
652	Right Wing - Spoiler No. 7

C. Access Panels

Number	Name/Location
S6521	Right Inboard Ground Spoiler Inspection

D. Inspection

SUBTASK 57-05-03-010-045

(1) Special Access:

Number	Name/Location
S6521	Right Inboard Ground Spoiler Inspection

NOTE: Extend flaps and ground spoilers.

SUBTASK 57-05-03-210-044

(2) Do a General Visual inspection of the right inboard ground spoiler actuator fittings.

SUBTASK 57-05-03-910-046

(3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-801.

———— **END OF TASK** ————

EFFECTIVITY
SIA ALL

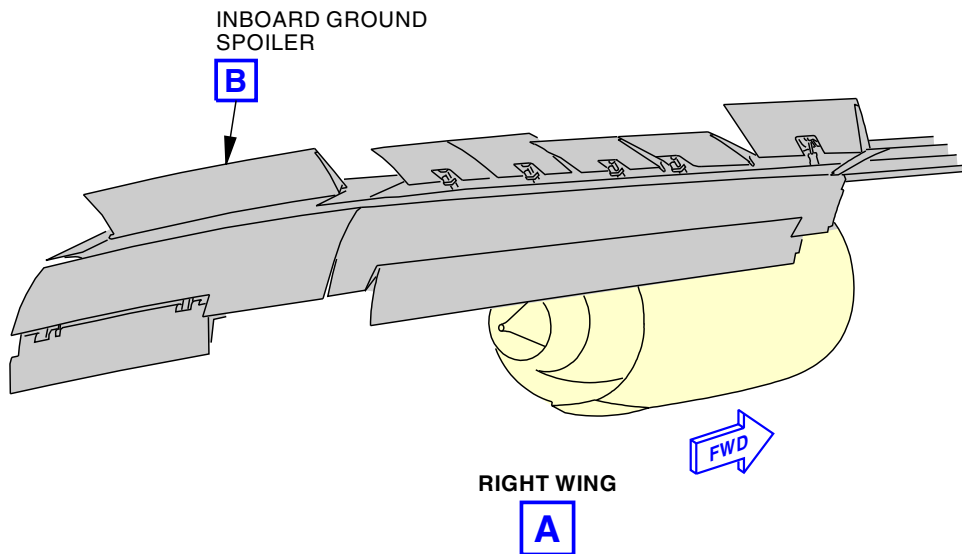
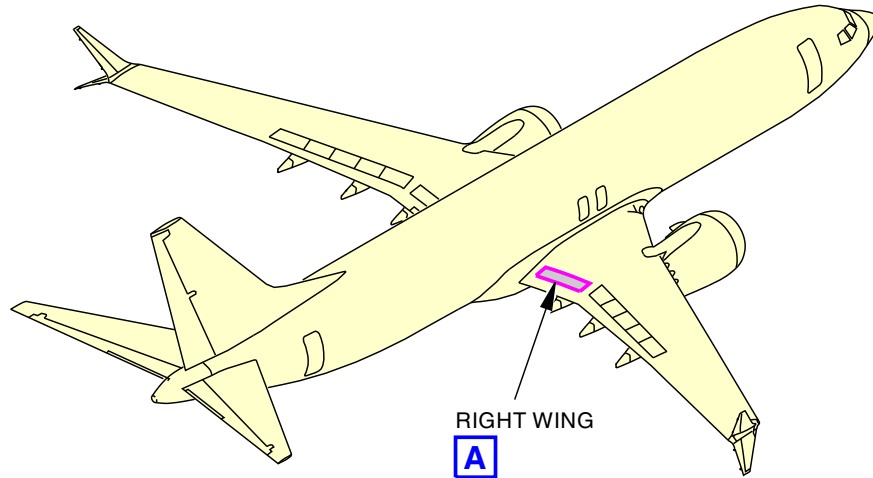
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

57-05-03

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BOEING
737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL



2416558 S00061541044_V1

Right Inboard Ground Spoiler General Visual (Internal)
Figure 254/57-05-03-990-853 (Sheet 1 of 2)

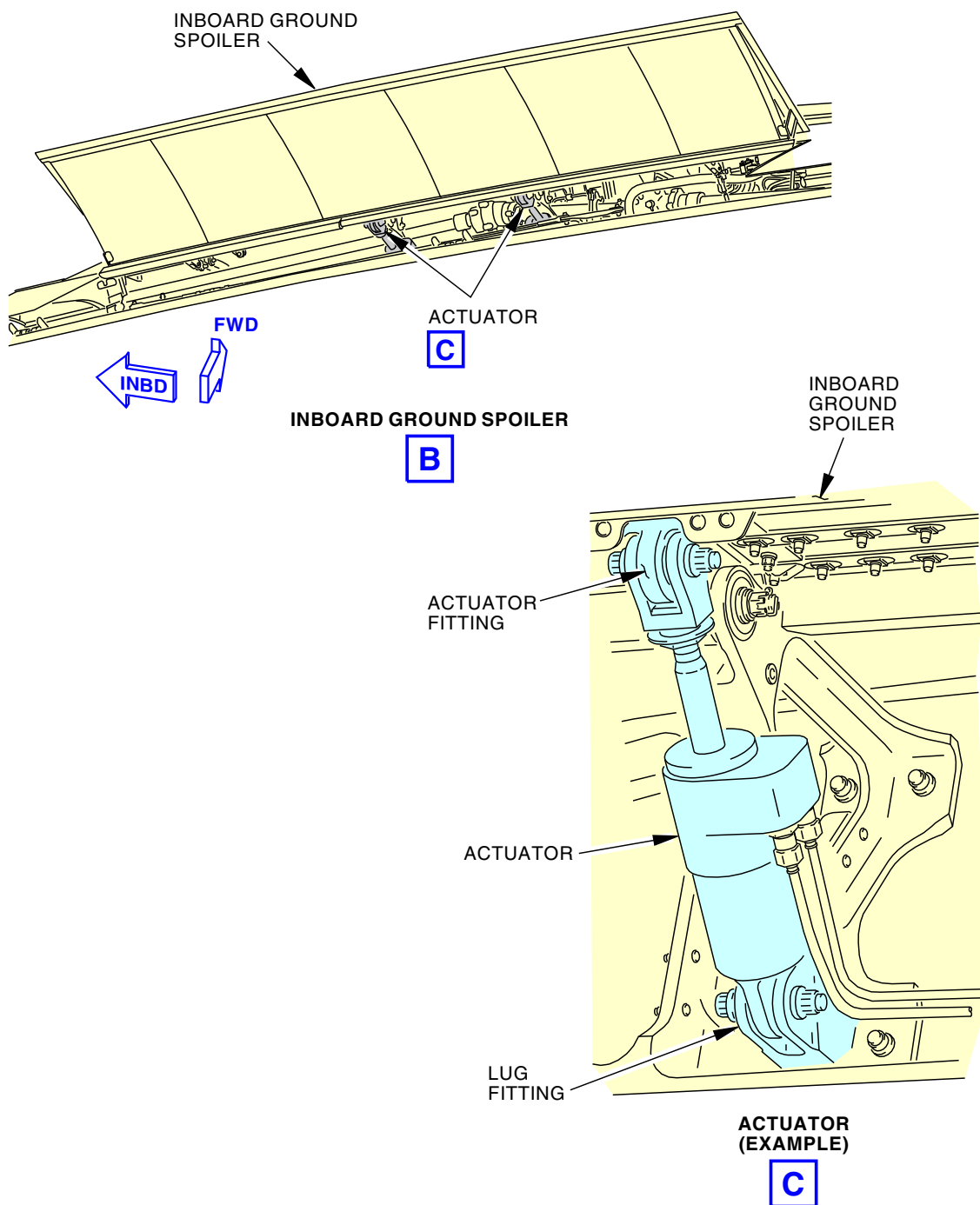
EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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2416559 S00061541045_V3

Right Inboard Ground Spoiler General Visual (Internal)
Figure 254/57-05-03-990-853 (Sheet 2 of 2)

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL

TASK 57-05-03-210-845

47. **INTERNAL - GENERAL VISUAL: LEFT INBOARD FLAP**

(Figure 255)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-806	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
553	Left Wing - Inboard Flap

C. Access Panels

Number	Name/Location
553AT	Inboard Flap - L.E. Skin
553BB	Inboard Flap - Lower Skin
553CT	Inboard Flap - L.E. Skin
553DT	Inboard Flap - Upper Skin
553ET	Inboard Flap - Upper Skin

D. Inspection

SUBTASK 57-05-03-010-046

- (1) Open these access panels:

Number	Name/Location
553AT	Inboard Flap - L.E. Skin
553BB	Inboard Flap - Lower Skin
553CT	Inboard Flap - L.E. Skin
553DT	Inboard Flap - Upper Skin
553ET	Inboard Flap - Upper Skin

SUBTASK 57-05-03-210-045

- (2) Do a General Visual inspection of the left inboard flap internally.
- (a) Front spar (aft side), rear spar (forward side), inspar ribs, torque tube, torque tube ribs;
 - (b) Aft flap track support assembly attachment on main flap rear spar

SUBTASK 57-05-03-910-047

- (3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 57-05-03-410-044

- (4) Close these access panels:

Number	Name/Location
553AT	Inboard Flap - L.E. Skin
553BB	Inboard Flap - Lower Skin
553CT	Inboard Flap - L.E. Skin
553DT	Inboard Flap - Upper Skin
553ET	Inboard Flap - Upper Skin

————— **END OF TASK** —————

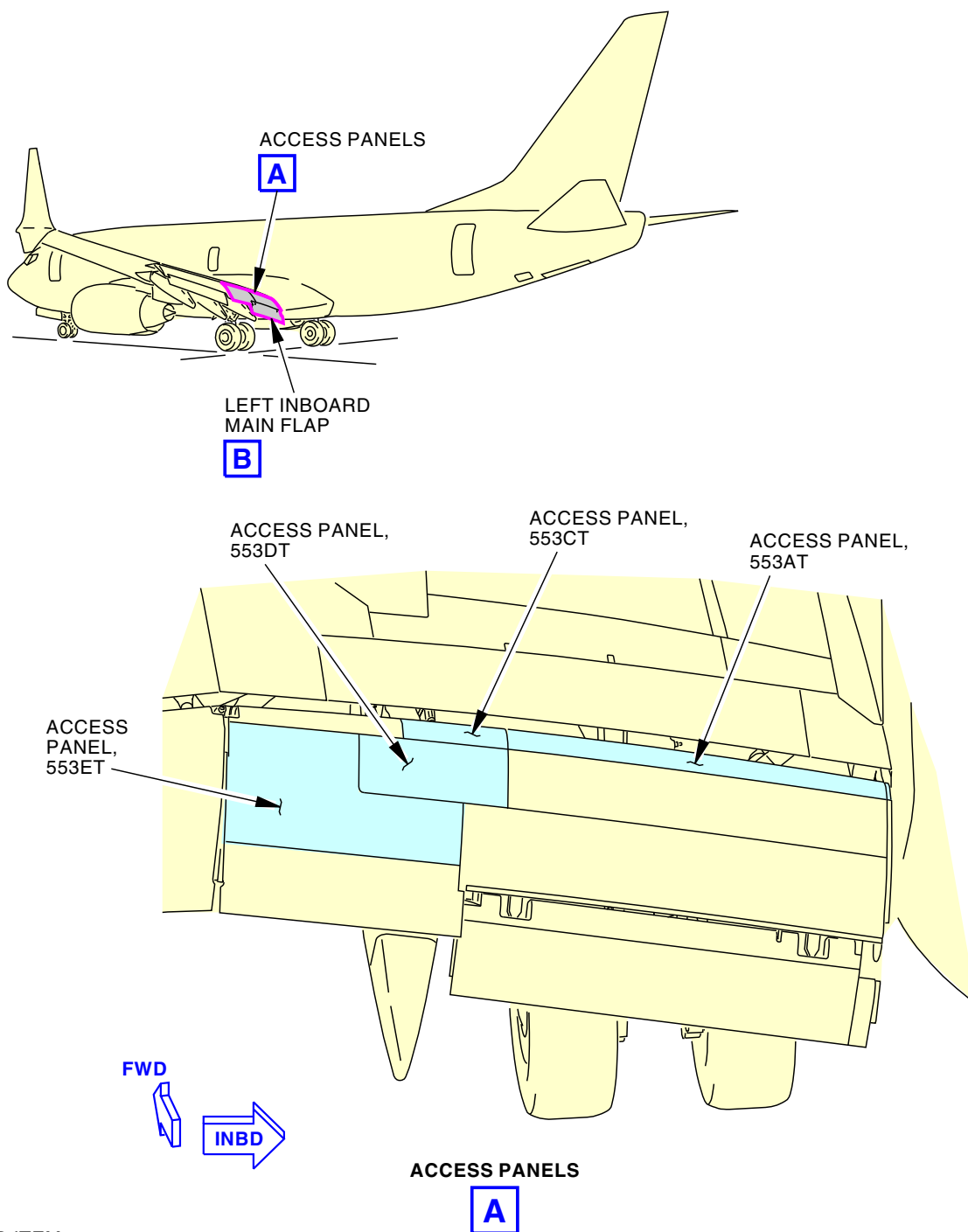
EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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MPD ITEM
57-300-01

2416560 S00061541047_V1

INTERNAL - GENERAL VISUAL: LEFT INBOARD FLAP
Figure 255/57-05-03-990-854 (Sheet 1 of 2)

EFFECTIVITY
SIA ALL

D633AM101-SIA

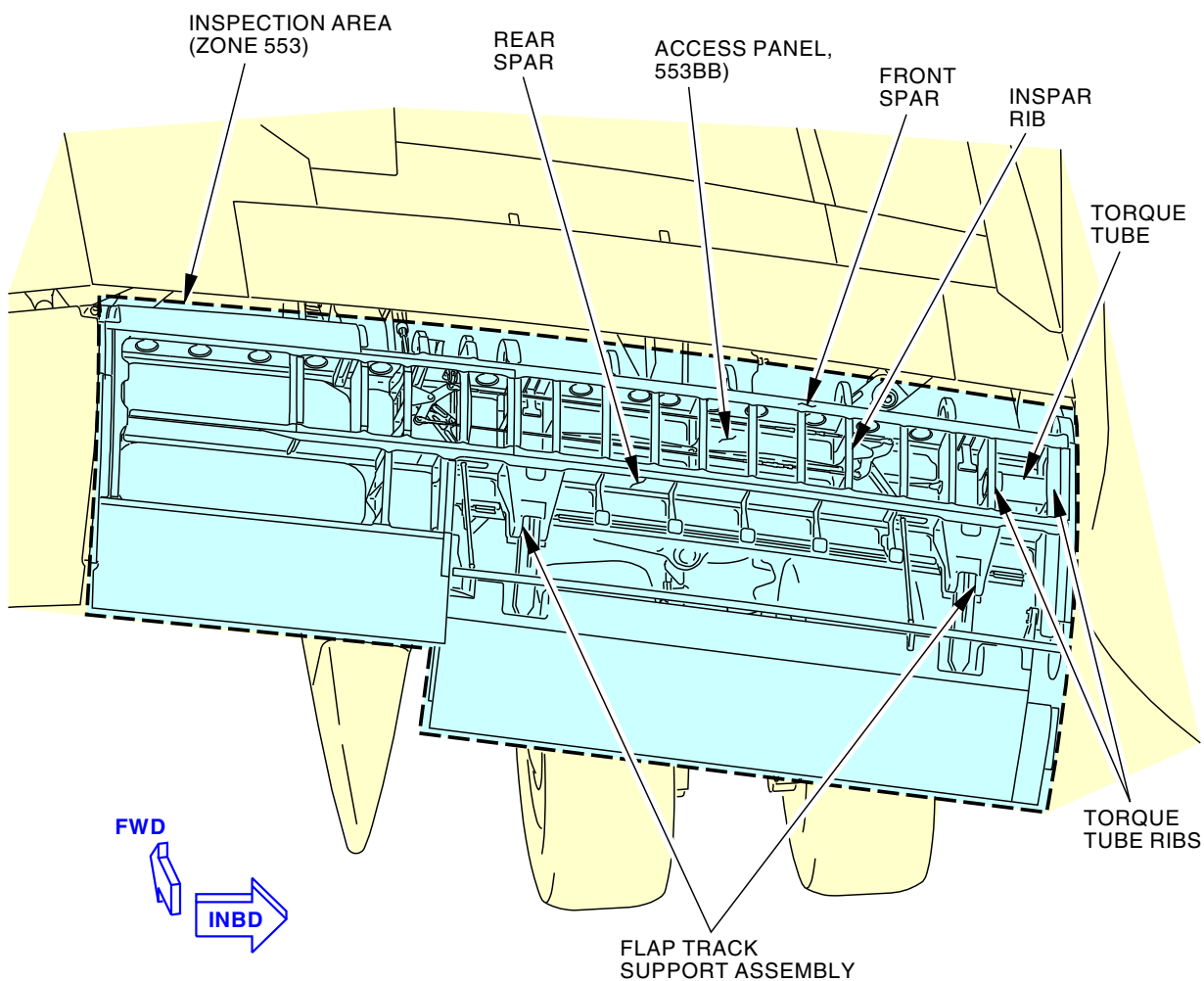
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AIRCRAFT MAINTENANCE MANUAL



LEFT INBOARD MAIN FLAP
(UPPER PANELS NOT SHOWN)

B

MPD ITEM
57-300-01

2416561 S00061541048_V1

INTERNAL - GENERAL VISUAL: LEFT INBOARD FLAP
Figure 255/57-05-03-990-854 (Sheet 2 of 2)

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL

TASK 57-05-03-210-846

48. **INTERNAL - GENERAL VISUAL: RIGHT INBOARD FLAP**

(Figure 256)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-806	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
653	Right Wing - Inboard Flap

C. Access Panels

Number	Name/Location
653AT	Inboard Flap - Leading Edge Skin
653BB	Inboard Flap - Lower Skin
653CT	Inboard Flap - Leading Edge Skin
653DT	Inboard Flap - Upper Skin
653ET	Inboard Flap - Upper Skin

D. Inspection

SUBTASK 57-05-03-010-047

- (1) Open these access panels:

<u>Number</u>	<u>Name/Location</u>
653AT	Inboard Flap - Leading Edge Skin
653BB	Inboard Flap - Lower Skin
653CT	Inboard Flap - Leading Edge Skin
653DT	Inboard Flap - Upper Skin
653ET	Inboard Flap - Upper Skin

SUBTASK 57-05-03-210-046

- (2) Do a General Visual inspection of the right inboard flap internally.
- (a) Front spar (aft side), rear spar (forward side), inspar ribs, torque tube, torque tube ribs.
 - (b) Aft flap track support assembly attachment on main flap rear spar.

SUBTASK 57-05-03-910-048

- (3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 57-05-03-410-045

- (4) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
653AT	Inboard Flap - Leading Edge Skin
653BB	Inboard Flap - Lower Skin
653CT	Inboard Flap - Leading Edge Skin
653DT	Inboard Flap - Upper Skin
653ET	Inboard Flap - Upper Skin

————— **END OF TASK** —————

EFFECTIVITY
SIA ALL

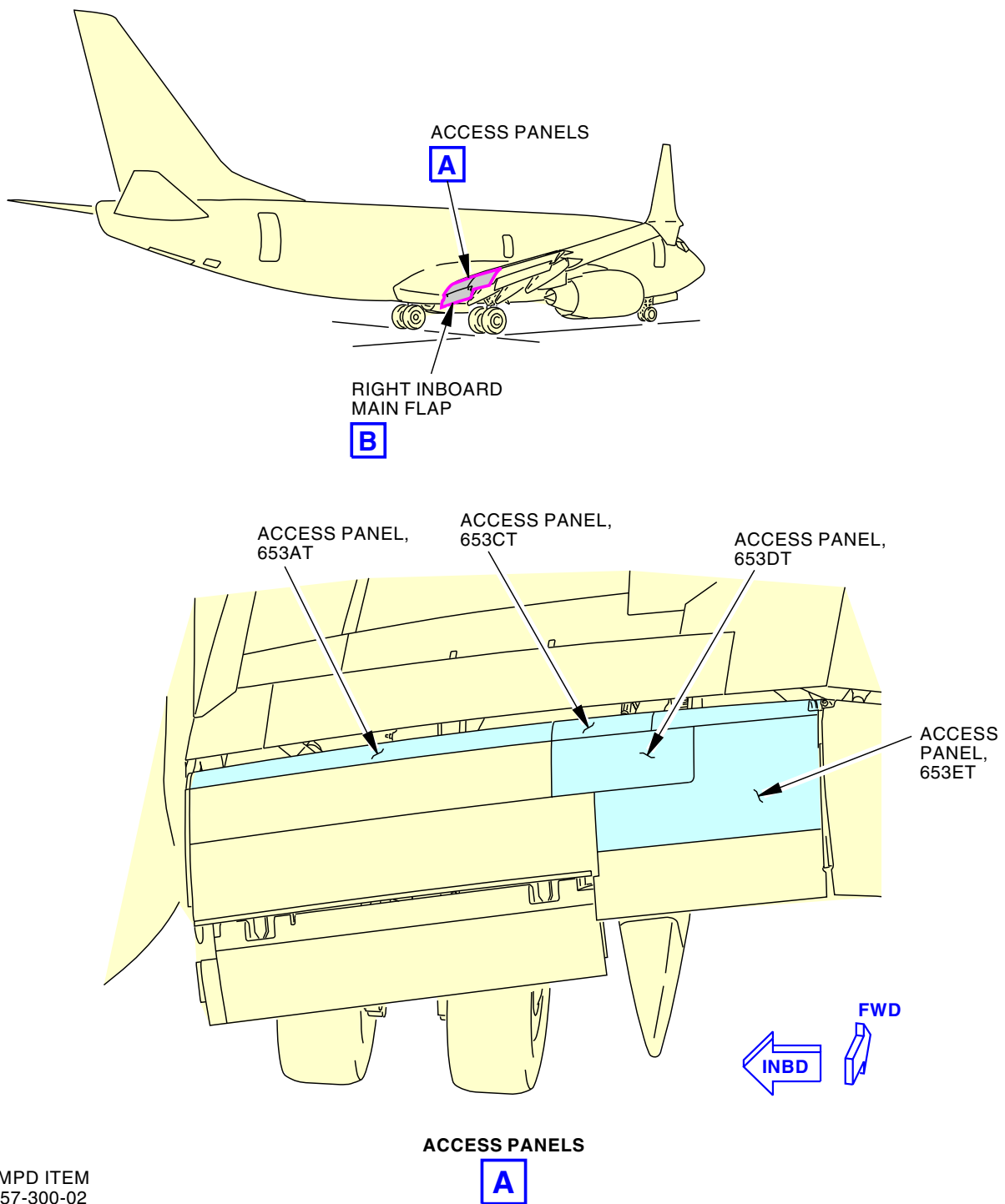
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AIRCRAFT MAINTENANCE MANUAL



MPD ITEM
57-300-02

2416562 S00061541050_V1

INTERNAL - GENERAL VISUAL: RIGHT INBOARD FLAP
Figure 256/57-05-03-990-855 (Sheet 1 of 2)

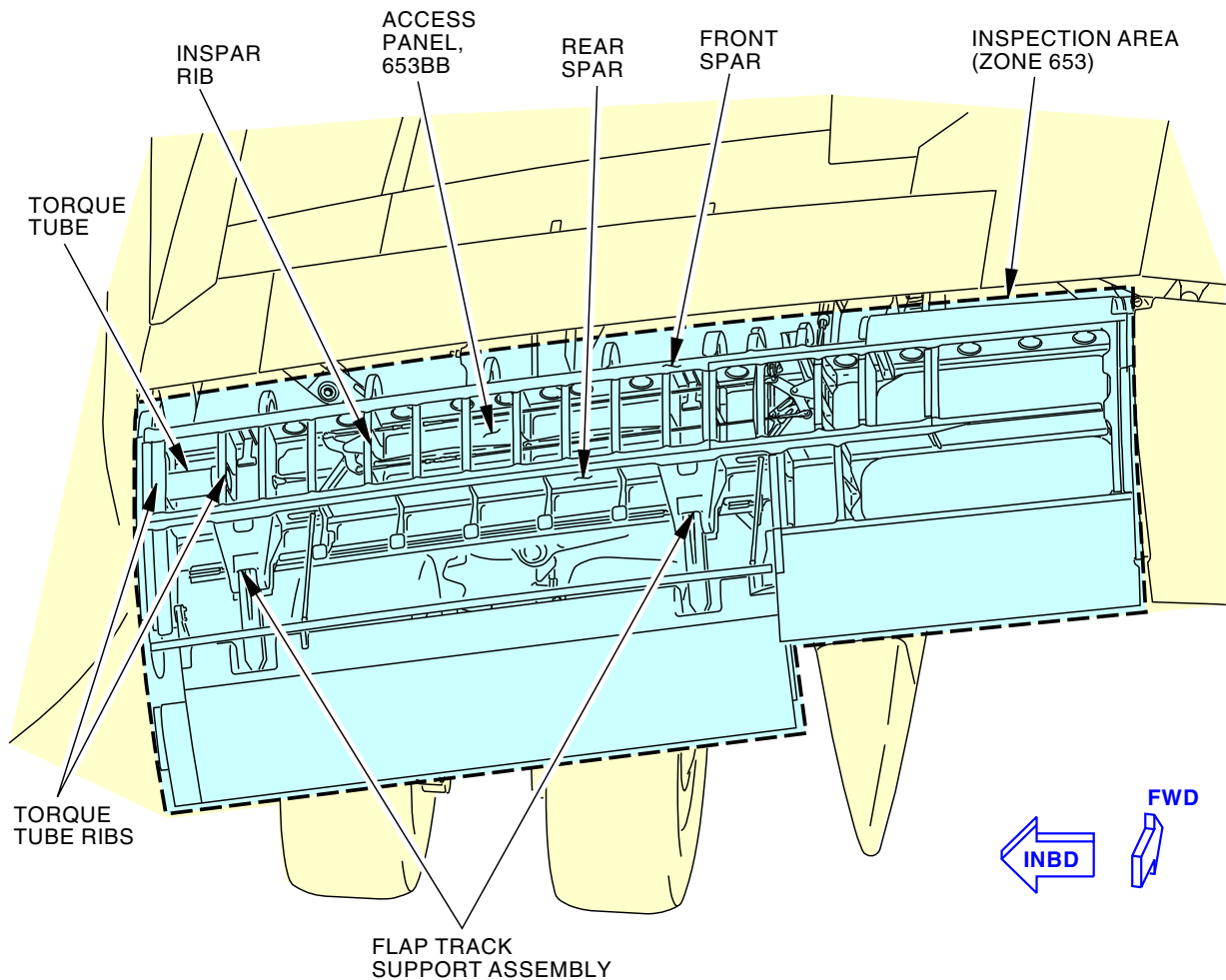
EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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**RIGHT INBOARD MAIN FLAP
(UPPER PANELS NOT SHOWN)**

B

MPD ITEM
57-300-02

2416563 S00061541051_V1

INTERNAL - GENERAL VISUAL: RIGHT INBOARD FLAP
Figure 256/57-05-03-990-855 (Sheet 2 of 2)

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL

TASK 57-05-03-210-847

49. **INTERNAL - GENERAL VISUAL: LEFT OUTBOARD WING REAR SPAR**

(Figure 257)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-806	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
561	Left Wing - Rear Spar to Trailing Edge, Outboard Of Inboard Flap, Inboard of Fixed Trailing Edge
571	Left Wing - Fixed Trailing Edge

C. Access Panels

Number	Name/Location
561AB	Midspan Fixed Trailing Edge Access Panel - WBL 224
561BB	Midspan Fixed Trailing Edge Access Panel - WBL 305
561CB	Midspan Fixed Trailing Edge Access Panel - WBL 388
571CB	Lower Outboard Fixed Trailing Edge Access Panel
571DB	Lower Outboard Fixed Trailing Edge Access Panel

D. Inspection

SUBTASK 57-05-03-010-048

- (1) Open these access panels:

Number	Name/Location
561AB	Midspan Fixed Trailing Edge Access Panel - WBL 224
561BB	Midspan Fixed Trailing Edge Access Panel - WBL 305
561CB	Midspan Fixed Trailing Edge Access Panel - WBL 388
571CB	Lower Outboard Fixed Trailing Edge Access Panel
571DB	Lower Outboard Fixed Trailing Edge Access Panel

SUBTASK 57-05-03-210-047

- (2) Do a General Visual inspection of the aft side of rear spar (chords, webs and stiffeners), including flap track 1 & 2 support fittings.

SUBTASK 57-05-03-910-049

- (3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 57-05-03-410-046

- (4) Close these access panels:

Number	Name/Location
561AB	Midspan Fixed Trailing Edge Access Panel - WBL 224
561BB	Midspan Fixed Trailing Edge Access Panel - WBL 305
561CB	Midspan Fixed Trailing Edge Access Panel - WBL 388
571CB	Lower Outboard Fixed Trailing Edge Access Panel
571DB	Lower Outboard Fixed Trailing Edge Access Panel

————— **END OF TASK** —————

EFFECTIVITY
SIA ALL

D633AM101-SIA

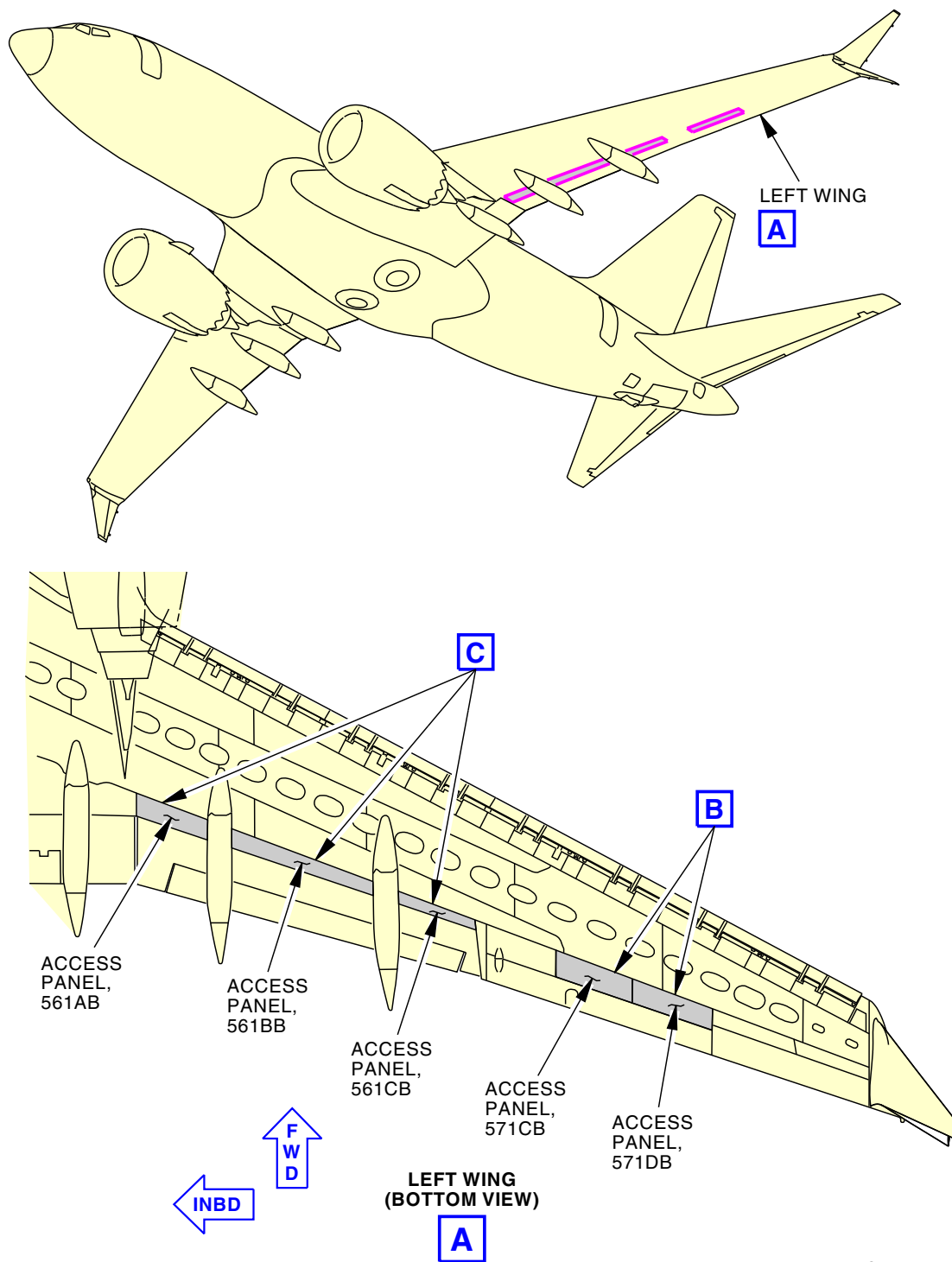
ECCN 9E991 BOEING PROPRIETARY - See title page for details

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737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL



2416564 S00061541053_V1

Left Outboard Wing Rear Spar General Visual (Internal)
Figure 257/57-05-03-990-856 (Sheet 1 of 3)

EFFECTIVITY
SIA ALL

D633AM101-SIA

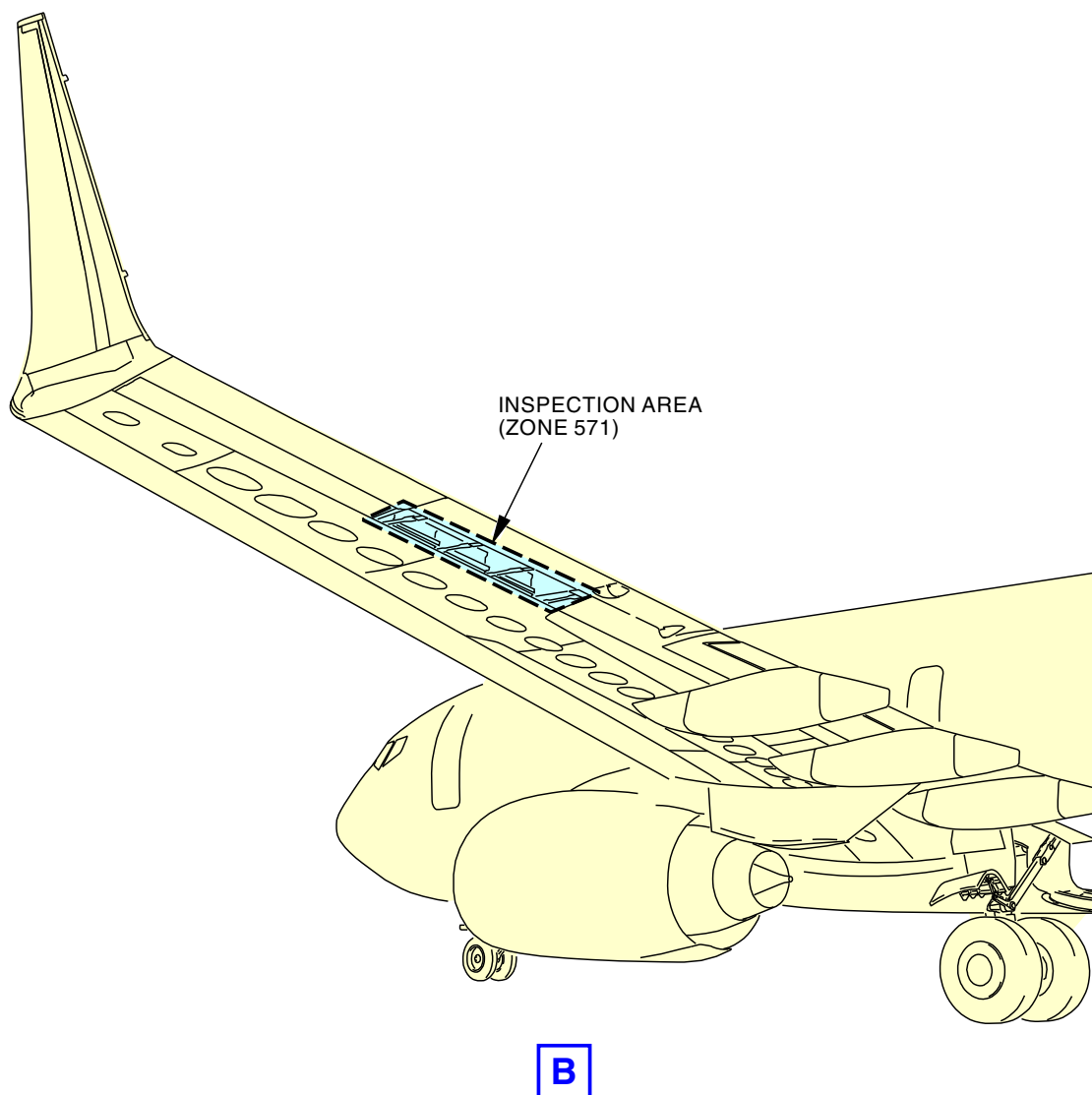
ECCN 9E991 BOEING PROPRIETARY - See title page for details

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737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL



2416565 S00061541054_V1

Left Outboard Wing Rear Spar General Visual (Internal)
Figure 257/57-05-03-990-856 (Sheet 2 of 3)

EFFECTIVITY
SIA ALL

D633AM101-SIA

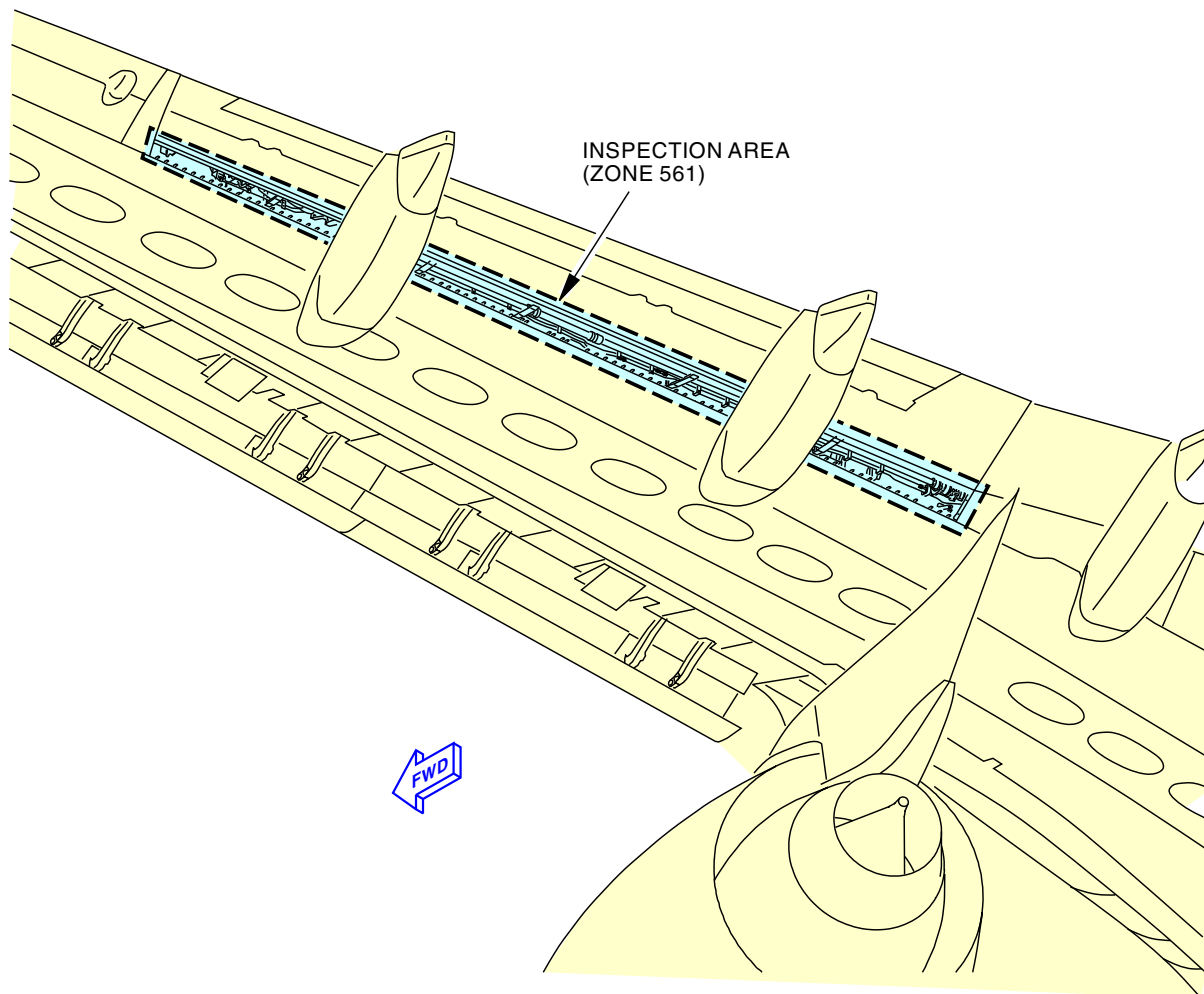
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57-05-03

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737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL



C

2416566 S00061541055_V1

Left Outboard Wing Rear Spar General Visual (Internal)
Figure 257/57-05-03-990-856 (Sheet 3 of 3)

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL

TASK 57-05-03-210-848

50. INTERNAL - GENERAL VISUAL: RIGHT OUTBOARD WING REAR SPAR

(Figure 258)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-806	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
661	Right Wing - Rear Spar to Trailing Edge, Outboard of Inboard Flap, Inboard of Fixed Trailing Edge
671	Right Wing - Fixed Trailing Edge

C. Access Panels

Number	Name/Location
661AB	Midspan Fixed Trailing Edge Access Panel - WBL 224
661BB	Midspan Fixed Trailing Edge Access Panel - WBL 305
661CB	Midspan Fixed Trailing Edge Access Panel - WBL 388
671CB	Lower Outboard Fixed Trailing Edge Access Panel
671DB	Lower Outboard Fixed Trailing Edge Access Panel

D. Inspection

SUBTASK 57-05-03-010-049

- (1) Open these access panels:

Number	Name/Location
661AB	Midspan Fixed Trailing Edge Access Panel - WBL 224
661BB	Midspan Fixed Trailing Edge Access Panel - WBL 305
661CB	Midspan Fixed Trailing Edge Access Panel - WBL 388
671CB	Lower Outboard Fixed Trailing Edge Access Panel
671DB	Lower Outboard Fixed Trailing Edge Access Panel

SUBTASK 57-05-03-210-048

- (2) Do a General Visual inspection of the aft side of rear spar (chords, webs and stiffeners), including flap track 7 & 8 support fittings.

SUBTASK 57-05-03-910-050

- (3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 57-05-03-410-047

- (4) Close these access panels:

Number	Name/Location
661AB	Midspan Fixed Trailing Edge Access Panel - WBL 224
661BB	Midspan Fixed Trailing Edge Access Panel - WBL 305
661CB	Midspan Fixed Trailing Edge Access Panel - WBL 388
671CB	Lower Outboard Fixed Trailing Edge Access Panel
671DB	Lower Outboard Fixed Trailing Edge Access Panel

———— **END OF TASK** ————

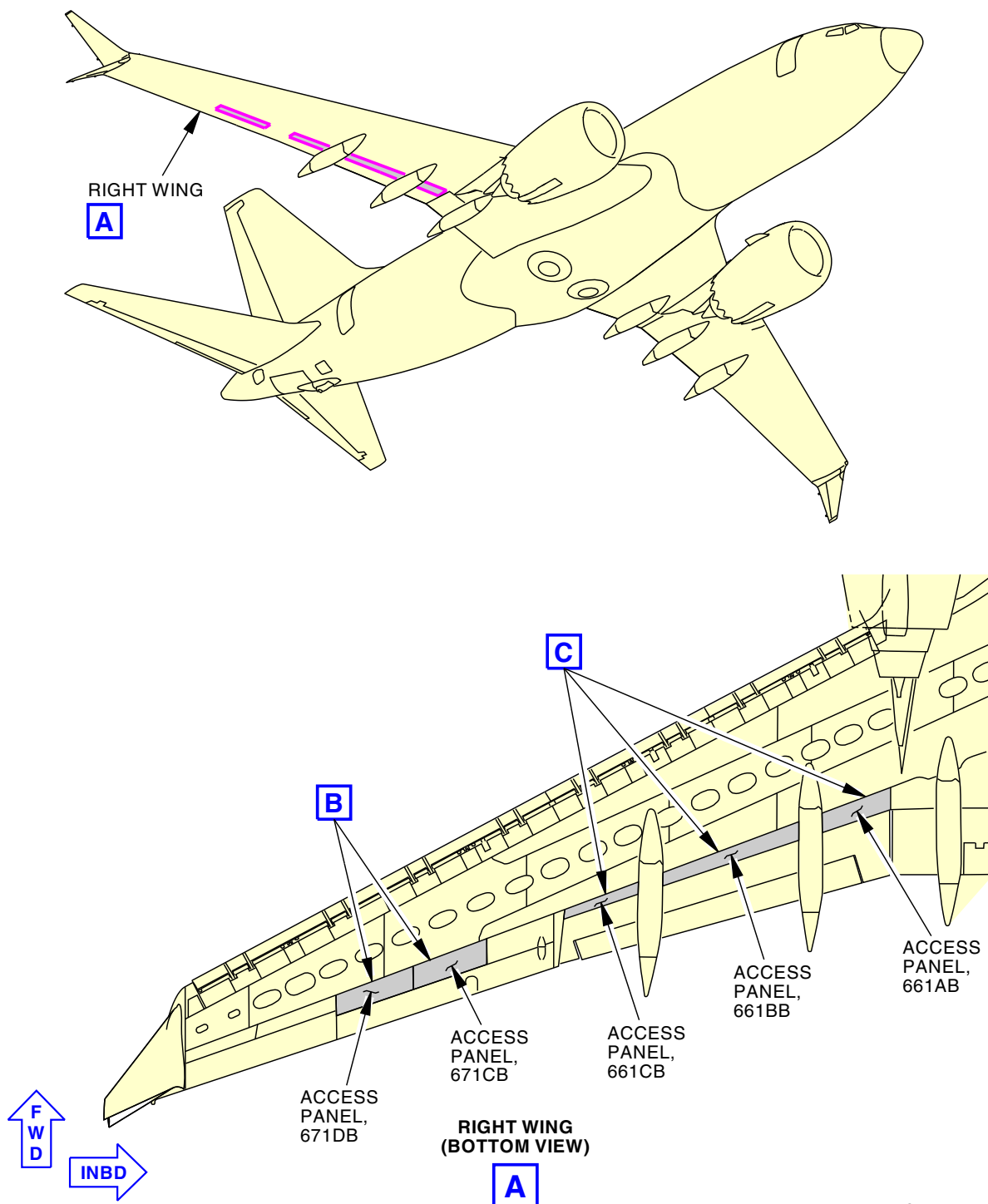
EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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2416567 S00061541057_V1

Right Outboard Wing Rear Spar General Visual (Internal)
Figure 258/57-05-03-990-857 (Sheet 1 of 3)

EFFECTIVITY
SIA ALL

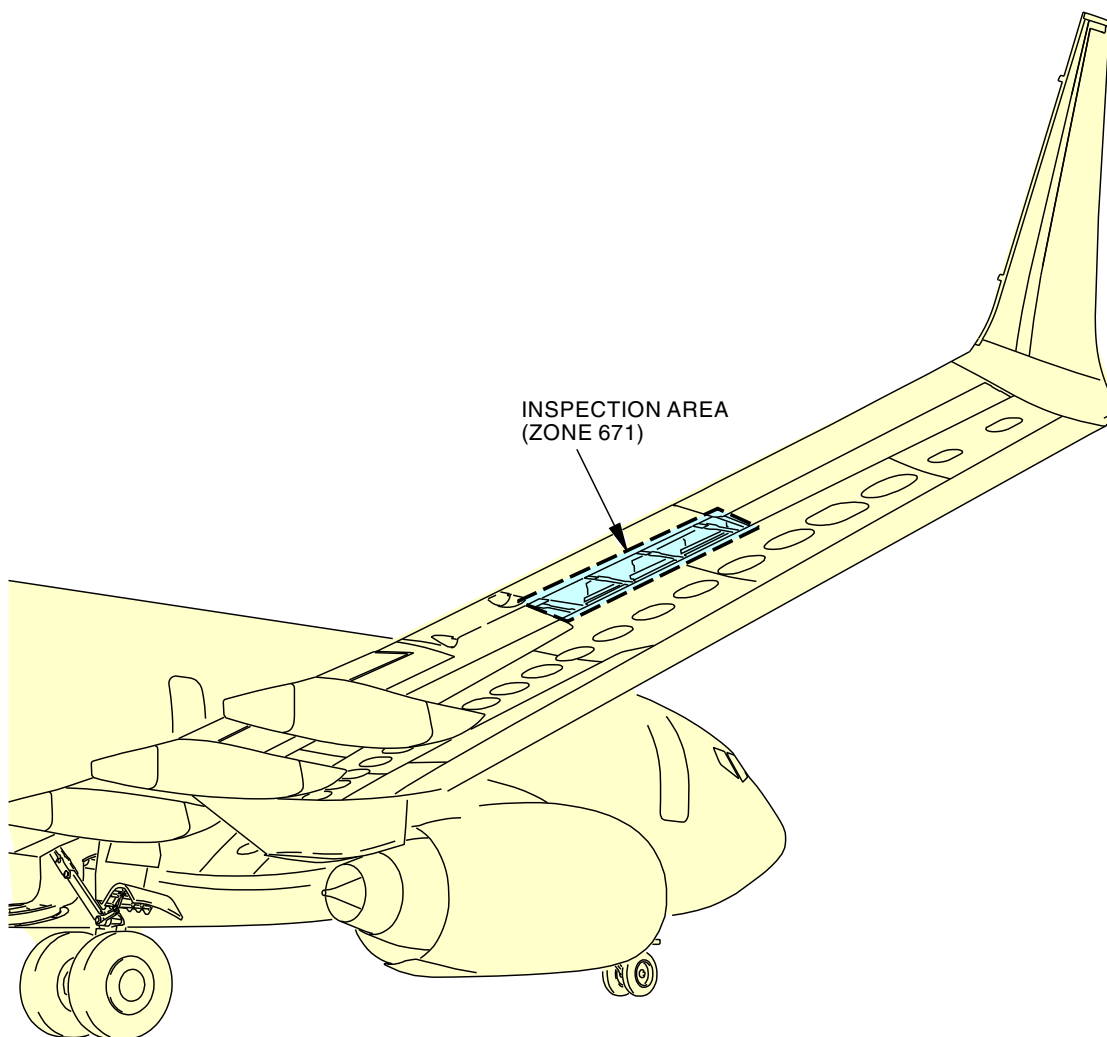
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57-05-03

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AIRCRAFT MAINTENANCE MANUAL



B

2416568 S00061541058_V1

Right Outboard Wing Rear Spar General Visual (Internal)
Figure 258/57-05-03-990-857 (Sheet 2 of 3)

EFFECTIVITY
SIA ALL

D633AM101-SIA

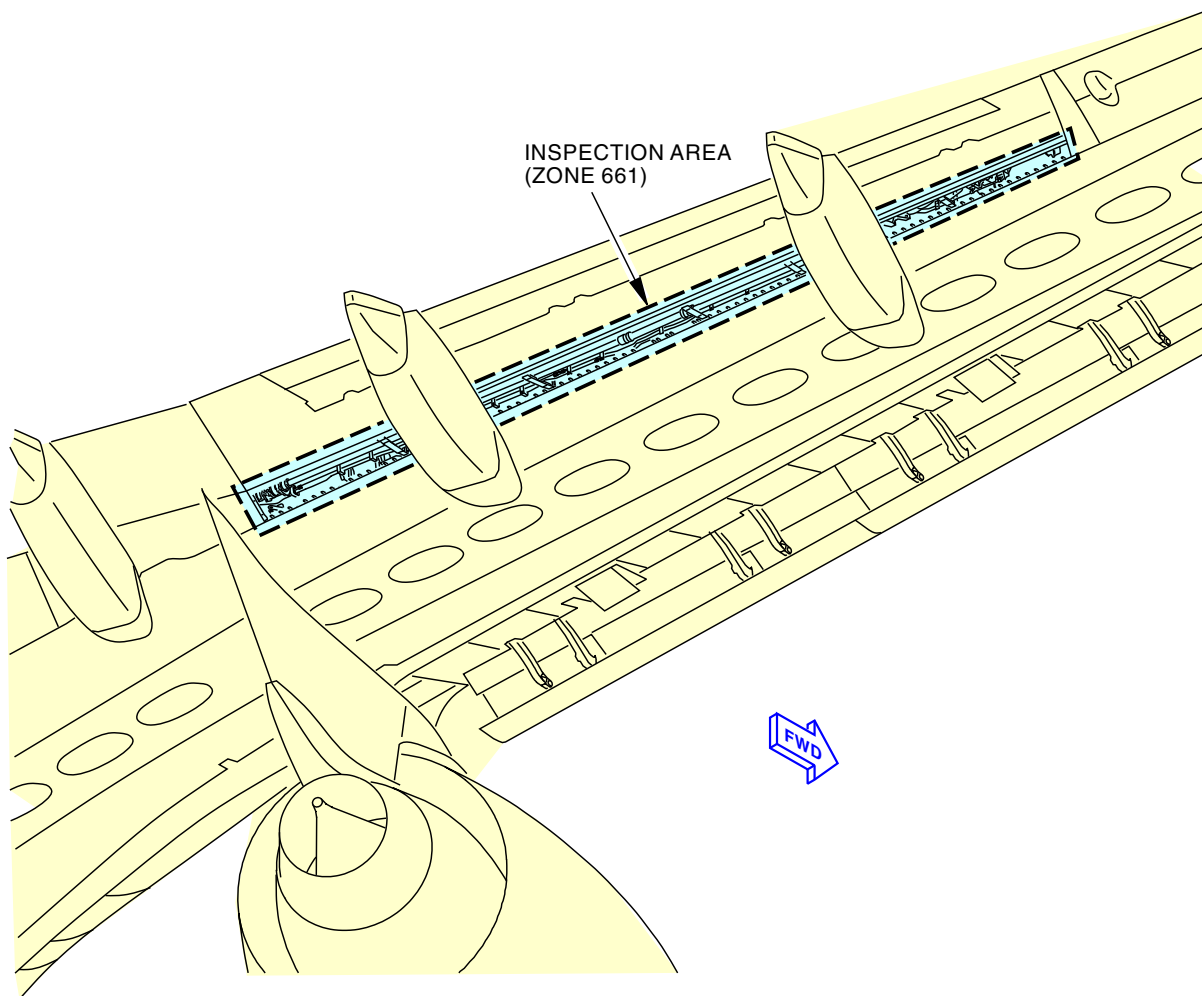
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737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL



C

2416569 S00061541059_V1

Right Outboard Wing Rear Spar General Visual (Internal)
Figure 258/57-05-03-990-857 (Sheet 3 of 3)

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL

TASK 57-05-03-210-849

51. INTERNAL - GENERAL VISUAL: LEFT OUTBOARD FLAP

(Figure 259)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-806	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
C00528	Compound - Corrosion Preventive, Petroleum Hot Application (Soft Film)	MIL-C-11796 Class III

C. Location Zones

Zone	Area
567	Left Wing - Outboard Flap

D. Access Panels

Number	Name/Location
567AT	Outboard Flap - Leading Edge Skin
567BT	Flap, Forward Carriage Bearing And Fitting
567CT	Outboard Flap - Leading Edge Skin
567DT	Outboard Flap - Leading Edge Skin
567ET	Flap, Forward Carriage Bearing And Fitting
567FT	Outboard Flap - Leading Edge Skin
567GT	Outboard Flap - Upper Skin
567HT	Outboard Flap - Upper Skin

E. Inspection

SUBTASK 57-05-03-010-050

- (1) Open these access panels:

Number	Name/Location
567AT	Outboard Flap - Leading Edge Skin
567CT	Outboard Flap - Leading Edge Skin
567DT	Outboard Flap - Leading Edge Skin
567FT	Outboard Flap - Leading Edge Skin
567GT	Outboard Flap - Upper Skin
567HT	Outboard Flap - Upper Skin

- (2) Deploy aft flap so that aft flap tracks do not block view of rear spar lower chord.

SUBTASK 57-05-03-010-056

- (3) Remove the leading edge skin panel [2] from the main flap assembly [1] forward of the inboard carriage [4]:

NOTE: This panel comes very close to the flap track when you engage the inboard carriage.

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

57-05-03

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737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL

- (a) These are the panels:

<u>Number</u>	<u>Name/Location</u>
567BT	Flap, Forward Carriage Bearing And Fitting
567ET	Flap, Forward Carriage Bearing And Fitting

- (b) Remove the boltss [3] that attach the leading edge skin panel [2].
(c) Remove the leading edge skin panel [2] from the main flap assembly [1].

SUBTASK 57-05-03-210-049

- (4) Do a General Visual inspection of the left outboard flap internally.
(a) Front spar (aft side), including support fittings at WBL 254 and 358.
(b) Rear spar (forward side).
(c) Inspar ribs and aft flap track support ribs.

SUBTASK 57-05-03-910-051

- (5) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 57-05-03-410-048

- (6) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
567AT	Outboard Flap - Leading Edge Skin
567CT	Outboard Flap - Leading Edge Skin
567DT	Outboard Flap - Leading Edge Skin
567FT	Outboard Flap - Leading Edge Skin
567GT	Outboard Flap - Upper Skin
567HT	Outboard Flap - Upper Skin

SUBTASK 57-05-03-410-054

- (7) Install the leading edge skin panel [2] on the main flap assembly [1] forward of the inboard carriage [4]:
(a) These are the panels:

<u>Number</u>	<u>Name/Location</u>
567BT	Flap, Forward Carriage Bearing And Fitting
567ET	Flap, Forward Carriage Bearing And Fitting

(b) Put the leading edge skin panel [2] in its location on the leading edge of the main flap assembly [1].
(c) Apply compound, C00528 to the holes for the boltss [3].
(d) Install the bolts to attach the leading edge skin panel [2].
(e) Apply sealant, A00247 to fill all of the clearances around the leading edge skin panel [2] that are more than 0.05 in. (1.27 mm).

———— **END OF TASK** ————

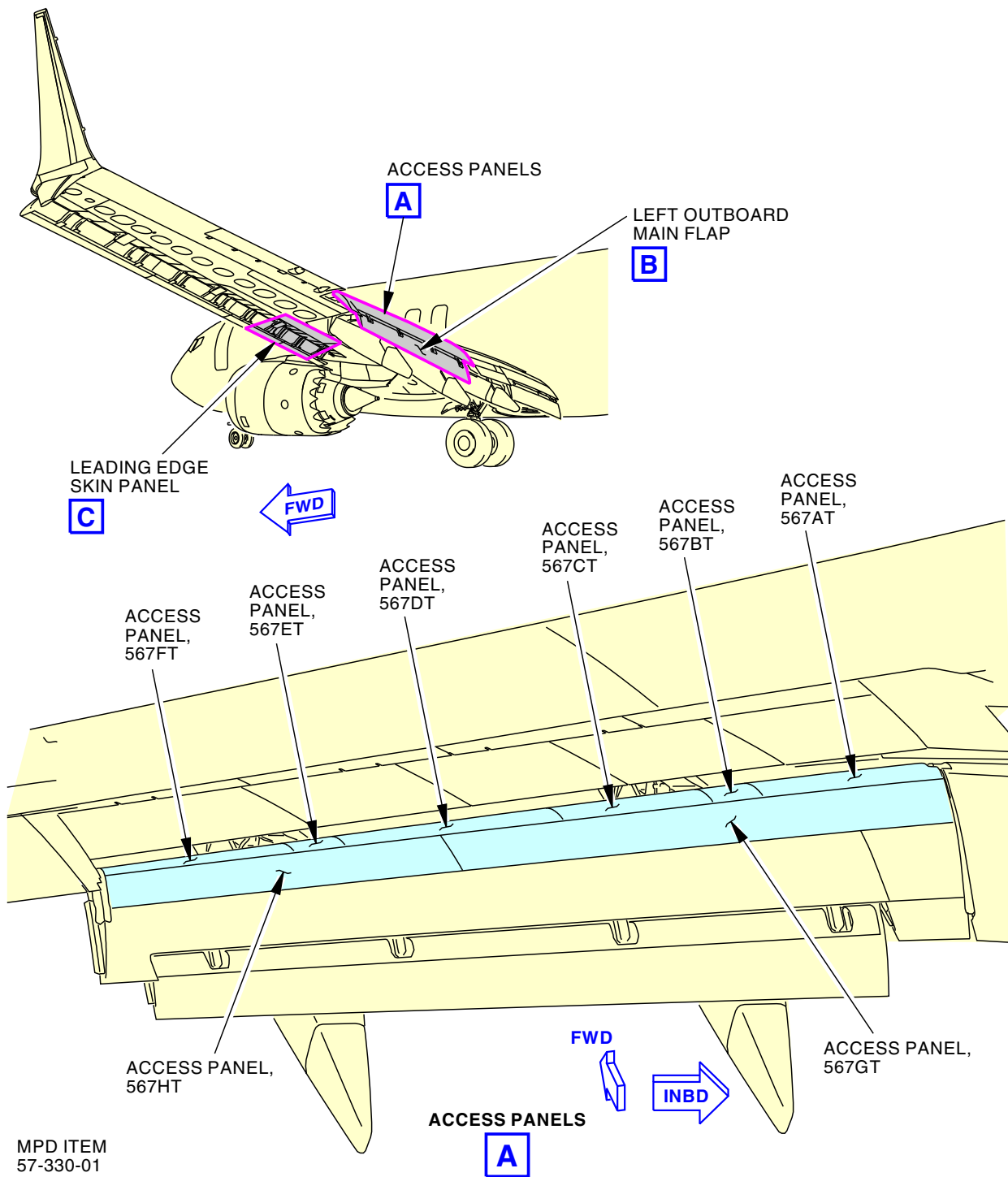
EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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General Visual: Left Outboard Flap
Figure 259/57-05-03-990-858 (Sheet 1 of 3)

EFFECTIVITY
SIA ALL

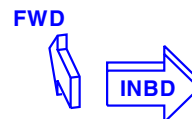
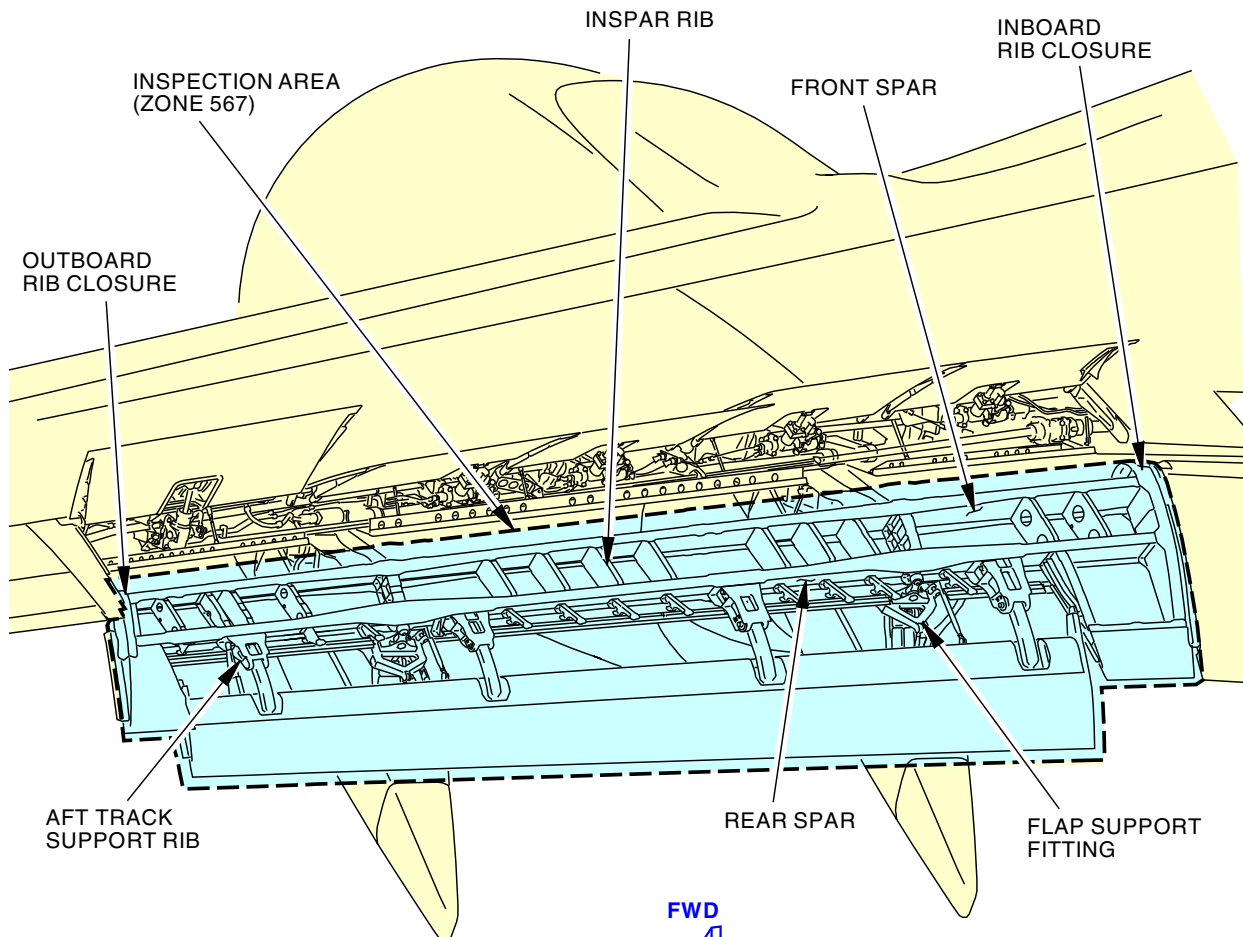
57-05-03

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AIRCRAFT MAINTENANCE MANUAL



LEFT OUTBOARD MAIN FLAP
(UPPER ACCESS PANELS NOT SHOWN)

B

MPD ITEM
57-330-01

2416571 S00061541062_V1

General Visual: Left Outboard Flap
Figure 259/57-05-03-990-858 (Sheet 2 of 3)

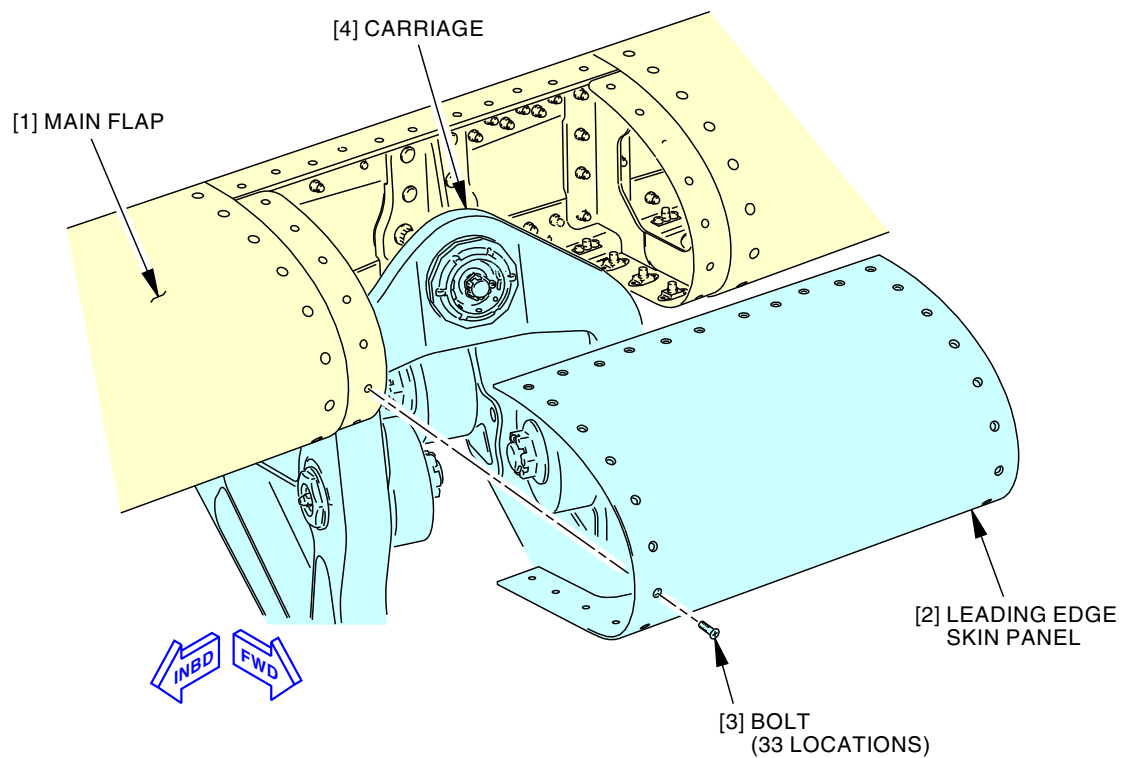
EFFECTIVITY
SIA ALL

57-05-03

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D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details



LEADING EDGE SKIN PANEL
(LEFT SIDE IS SHOWN, RIGHT SIDE IS OPPOSITE)

C

2574953 S0000618977_V1

General Visual: Left Outboard Flap
Figure 259/57-05-03-990-858 (Sheet 3 of 3)

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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**737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL**

TASK 57-05-03-210-850

52. INTERNAL - GENERAL VISUAL: RIGHT OUTBOARD FLAP

(Figure 260)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-806	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
C00528	Compound - Corrosion Preventive, Petroleum Hot Application (Soft Film)	MIL-C-11796 Class III

C. Location Zones

Zone	Area
667	Right Wing - Outboard Flap

D. Access Panels

Number	Name/Location
667AT	Outboard Flap - Leading Edge Skin
667BT	Flap, Forward Carriage Bearing And Fitting
667CT	Outboard Flap - Leading Edge Skin
667DT	Outboard Flap - Leading Edge Skin
667ET	Flap, Forward Carriage Bearing And Fitting
667FT	Outboard Flap - Leading Edge Skin
667GT	Outboard Flap - Upper Skin
667HT	Outboard Flap - Upper Skin

E. Inspection

SUBTASK 57-05-03-010-051

- (1) Open these access panels:

Number	Name/Location
667AT	Outboard Flap - Leading Edge Skin
667CT	Outboard Flap - Leading Edge Skin
667DT	Outboard Flap - Leading Edge Skin
667FT	Outboard Flap - Leading Edge Skin
667GT	Outboard Flap - Upper Skin
667HT	Outboard Flap - Upper Skin

- (2) Deploy aft flap so that aft flap tracks do not block view of rear spar lower chord.

SUBTASK 57-05-03-010-057

- (3) Remove the leading edge skin panel [2] from the main flap assembly [1] forward of the inboard carriage [4]:

NOTE: This panel comes very close to the flap track when you engage the inboard carriage.

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL

- (a) These are the panels:

<u>Number</u>	<u>Name/Location</u>
667BT	Flap, Forward Carriage Bearing And Fitting
667ET	Flap, Forward Carriage Bearing And Fitting

- (b) Remove the boltss [3] that attach the leading edge skin panel [2].
(c) Remove the leading edge skin panel [2] from the main flap assembly [1].

SUBTASK 57-05-03-210-050

- (4) Do a General Visual inspection of the right outboard flap internally.
(a) Front spar (aft side), including support fittings at WBL 254 and 358.
(b) Rear spar (forward side).
(c) Inspar ribs and aft flap track support ribs.

SUBTASK 57-05-03-910-052

- (5) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 57-05-03-410-049

- (6) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
667AT	Outboard Flap - Leading Edge Skin
667CT	Outboard Flap - Leading Edge Skin
667DT	Outboard Flap - Leading Edge Skin
667FT	Outboard Flap - Leading Edge Skin
667GT	Outboard Flap - Upper Skin
667HT	Outboard Flap - Upper Skin

SUBTASK 57-05-03-410-055

- (7) Install the leading edge skin panel [2] on the main flap assembly [1] forward of the inboard carriage [4]:
(a) These are the panels:

<u>Number</u>	<u>Name/Location</u>
667BT	Flap, Forward Carriage Bearing And Fitting
667ET	Flap, Forward Carriage Bearing And Fitting

(b) Put the leading edge skin panel [2] in its location on the leading edge of the main flap assembly [1].
(c) Apply compound, C00528 to the holes for the boltss [3].
(d) Install the bolts to attach the leading edge skin panel [2].
(e) Apply sealant, A00247 to fill all of the clearances around the leading edge skin panel [2] that are more than 0.05 in. (1.27 mm).

————— **END OF TASK** —————

EFFECTIVITY
SIA ALL

D633AM101-SIA

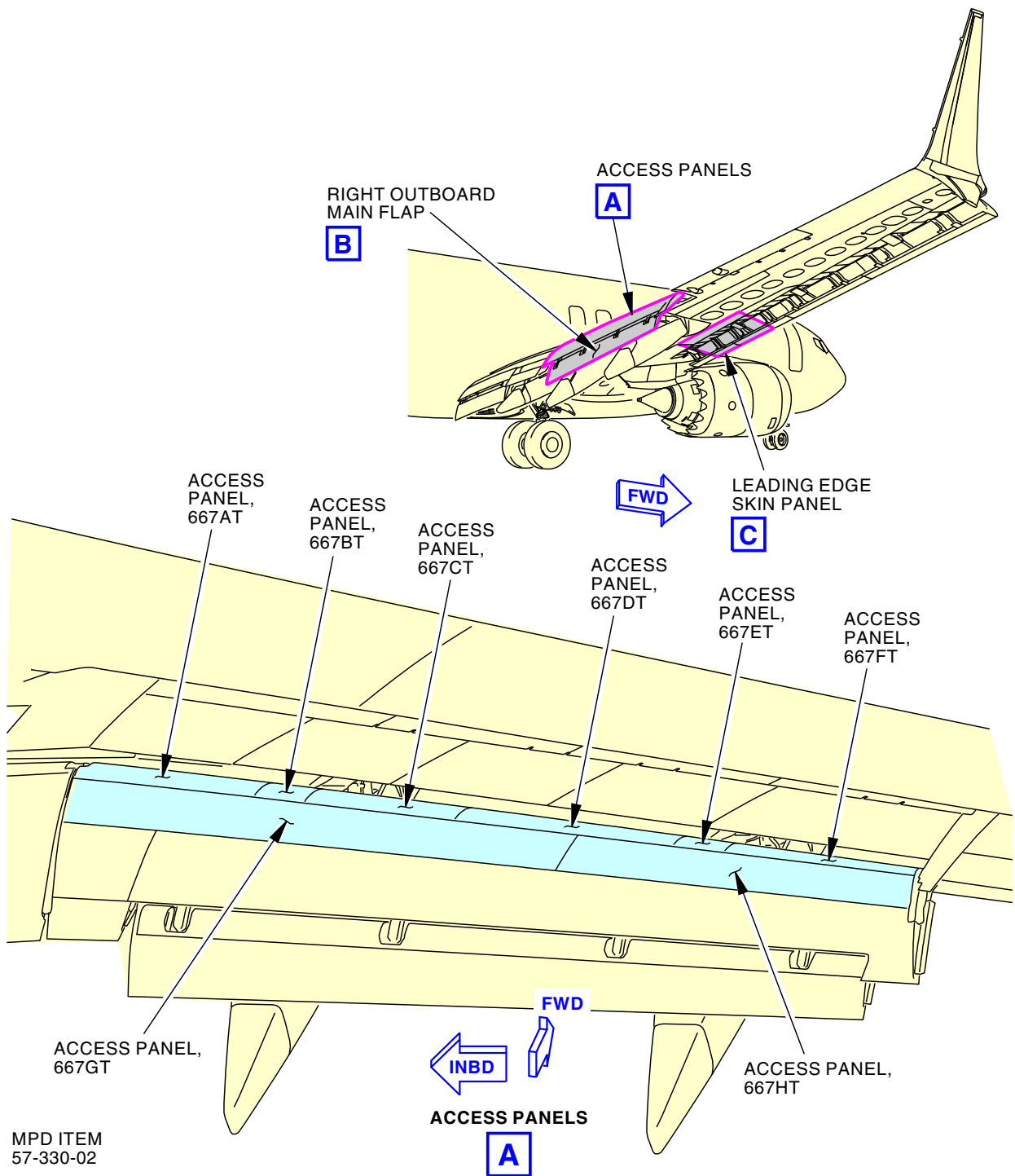
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737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL



2416572 S00061541064_V3

General Visual: Right Outboard Flap
Figure 260/57-05-03-990-859 (Sheet 1 of 3)

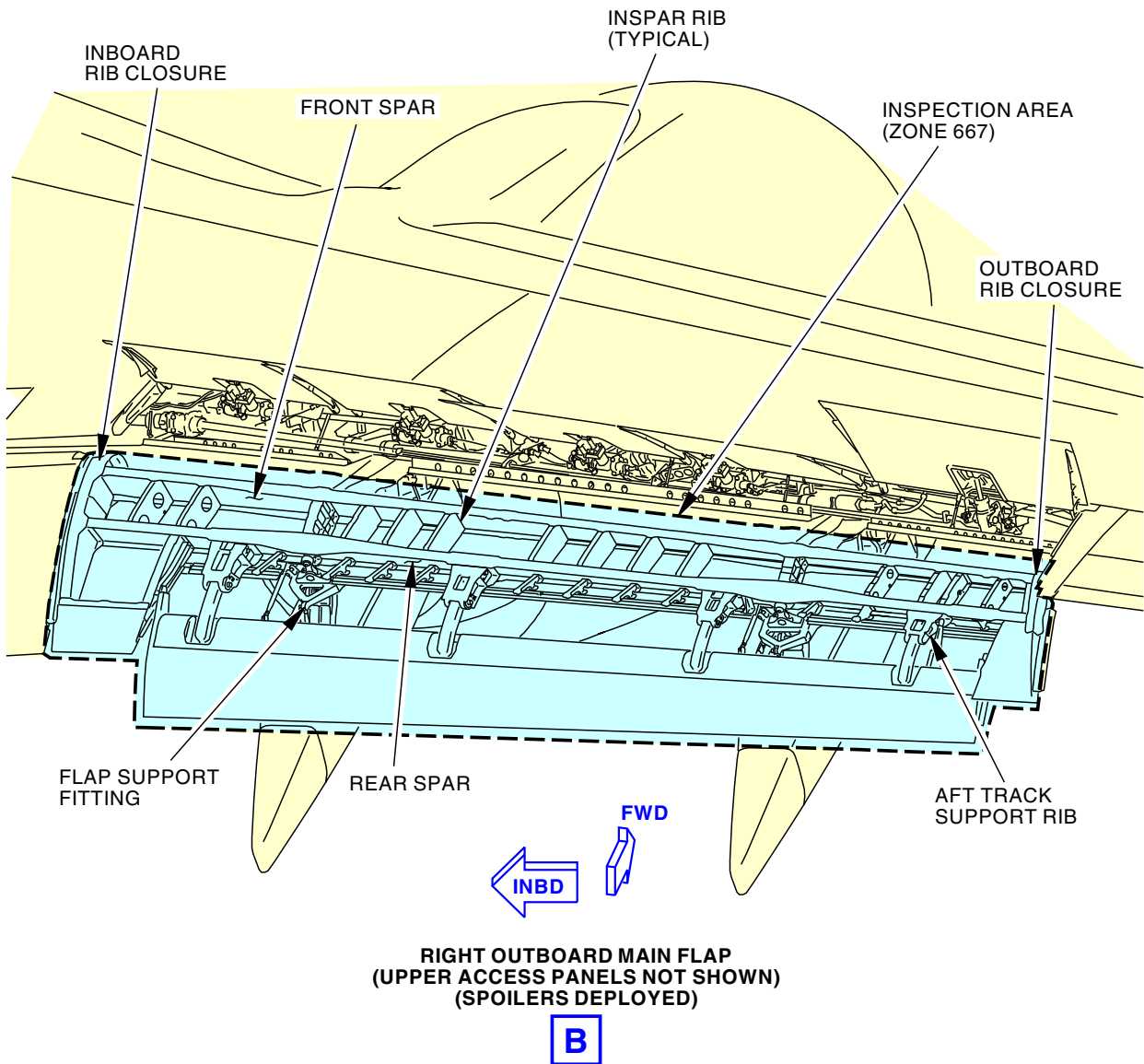
EFFECTIVITY
SIA ALL

57-05-03

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D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details



MPD ITEM
57-330-02

2416573 S00061541065_V1

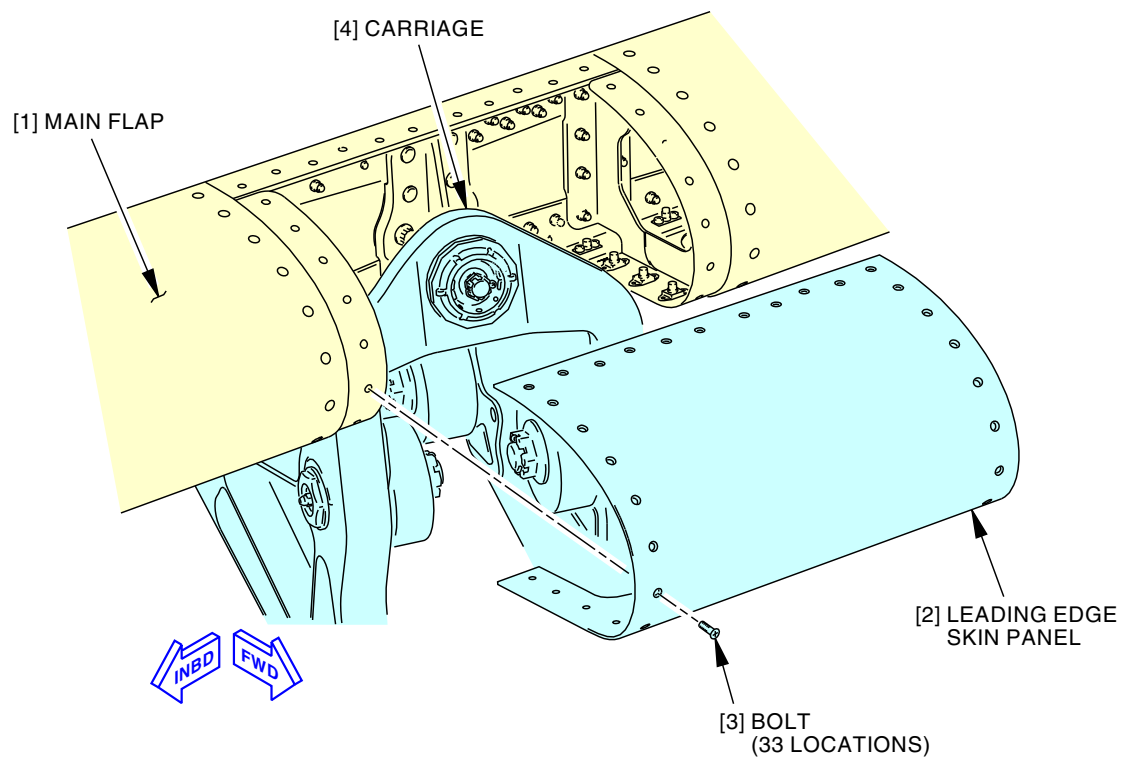
General Visual: Right Outboard Flap
Figure 260/57-05-03-990-859 (Sheet 2 of 3)

EFFECTIVITY
SIA ALL

57-05-03

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D633AM101-SIA



LEADING EDGE SKIN PANEL
(LEFT SIDE IS SHOWN, RIGHT SIDE IS OPPOSITE)

C

2574953 S0000618977_V1

General Visual: Right Outboard Flap
Figure 260/57-05-03-990-859 (Sheet 3 of 3)

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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737-7/8/8200/9/10
AIRCRAFT MAINTENANCE MANUAL

TASK 57-05-03-211-803

53. **INTERNAL - SPECIAL DETAILED: LEFT WINGLET**

(Figure 261)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
527	Left Winglet

B. Access Panels

Number	Name/Location
527AL	ACCESS PANEL - TRANSITION FAIRING, WINGLET
527BB	ACCESS PANEL - CENTER INBOARD LOWER PANEL, WINGLET
527BL	ACCESS PANEL - CENTER OUTBOARD PANEL, WINGLET
527BT	ACCESS PANEL - CENTER INBOARD UPPER PANEL, WINGLET
534BB	Dry Bay Tank Access Door - Left Wing Station 748

C. Inspection

SUBTASK 57-05-03-010-052

- (1) Open these access panels:

Number	Name/Location
527AL	ACCESS PANEL - TRANSITION FAIRING, WINGLET
527BB	ACCESS PANEL - CENTER INBOARD LOWER PANEL, WINGLET
527BL	ACCESS PANEL - CENTER OUTBOARD PANEL, WINGLET
527BT	ACCESS PANEL - CENTER INBOARD UPPER PANEL, WINGLET
534BB	Dry Bay Tank Access Door - Left Wing Station 748

NOTE: Remove winglet assembly, outboard fairing, upper and lower bifurcation fairings.

SUBTASK 57-05-03-211-003

- (2) Do a Special Detailed inspection of the skin to spar transition area (stepdown) for cracking and delamination utilizing a borescope.

SUBTASK 57-05-03-410-050

- (3) Close these access panels:

Number	Name/Location
527AL	ACCESS PANEL - TRANSITION FAIRING, WINGLET
527BB	ACCESS PANEL - CENTER INBOARD LOWER PANEL, WINGLET
527BL	ACCESS PANEL - CENTER OUTBOARD PANEL, WINGLET
527BT	ACCESS PANEL - CENTER INBOARD UPPER PANEL, WINGLET
534BB	Dry Bay Tank Access Door - Left Wing Station 748

———— **END OF TASK** ————

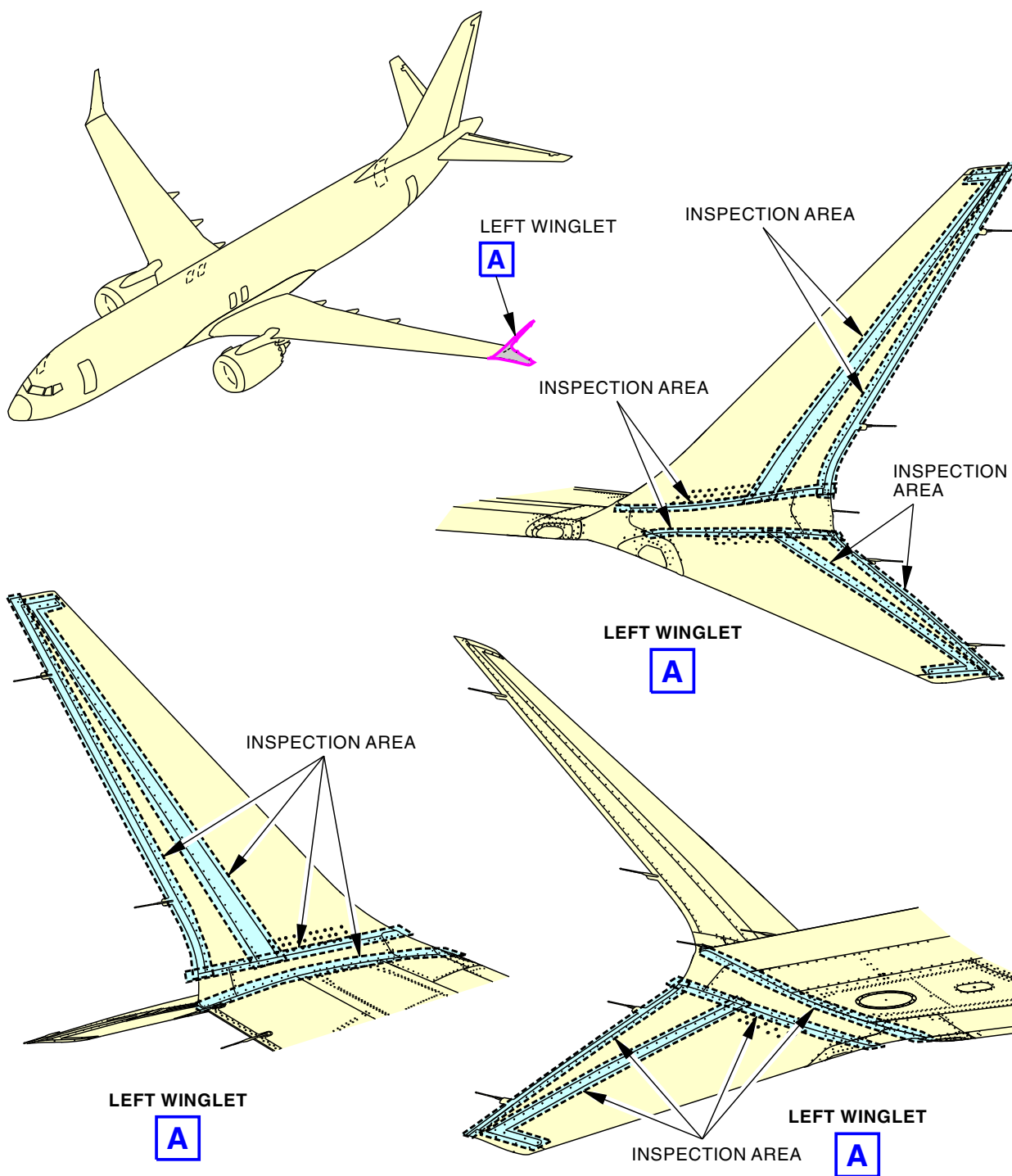
EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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2534260 S0000594278_V1

INTERNAL - SPECIAL DETAILED: LEFT WINGLET
Figure 261/57-05-03-990-860

EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL

TASK 57-05-03-211-804

54. **INTERNAL - SPECIAL DETAILED: RIGHT WINGLET**

(Figure 262)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
627	Right Winglet

B. Access Panels

Number	Name/Location
627AR	ACCESS PANEL - TRANSITION FAIRING, WINGLET
627BB	ACCESS PANEL - CENTER INBOARD LOWER PANEL, WINGLET
627BR	ACCESS PANEL - CENTER OUTBOARD PANEL, WINGLET
627BT	ACCESS PANEL - CENTER INBOARD UPPER PANEL, WINGLET
634BB	Dry Bay Tank Access Door - Right Wing Station 748

C. Inspection

SUBTASK 57-05-03-010-053

- (1) Open these access panels:

Number	Name/Location
627AR	ACCESS PANEL - TRANSITION FAIRING, WINGLET
627BB	ACCESS PANEL - CENTER INBOARD LOWER PANEL, WINGLET
627BR	ACCESS PANEL - CENTER OUTBOARD PANEL, WINGLET
627BT	ACCESS PANEL - CENTER INBOARD UPPER PANEL, WINGLET
634BB	Dry Bay Tank Access Door - Right Wing Station 748

NOTE: Remove winglet assembly, outboard fairing, upper and lower bifurcation fairings.

SUBTASK 57-05-03-211-004

- (2) Do a Special Detailed inspection of the skin to spar transition area (stepdown) for cracking and delamination utilizing a borescope.

SUBTASK 57-05-03-410-051

- (3) Close these access panels:

Number	Name/Location
627AR	ACCESS PANEL - TRANSITION FAIRING, WINGLET
627BB	ACCESS PANEL - CENTER INBOARD LOWER PANEL, WINGLET
627BR	ACCESS PANEL - CENTER OUTBOARD PANEL, WINGLET
627BT	ACCESS PANEL - CENTER INBOARD UPPER PANEL, WINGLET
634BB	Dry Bay Tank Access Door - Right Wing Station 748

———— **END OF TASK** ————

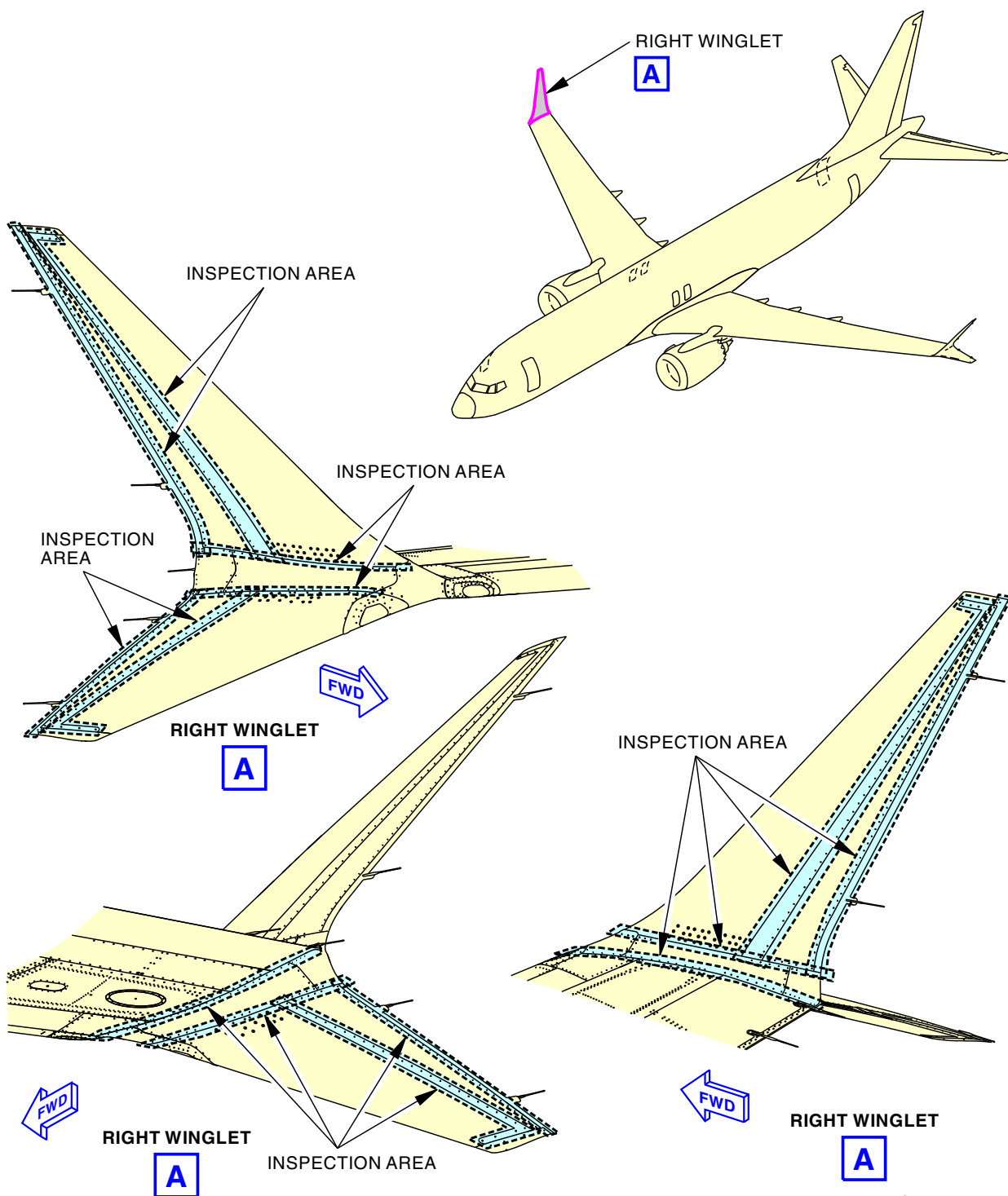
EFFECTIVITY
SIA ALL

D633AM101-SIA

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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2534261 S0000594279_V1

INTERNAL - SPECIAL DETAILED: RIGHT WINGLET
Figure 262/57-05-03-990-861

EFFECTIVITY
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TASK 57-05-03-211-805

55. **INTERNAL - DETAILED: LEFT WINGLET**

(Figure 263)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-804	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
527	Left Winglet

C. Access Panels

Number	Name/Location
527AL	ACCESS PANEL - TRANSITION FAIRING, WINGLET
527BB	ACCESS PANEL - CENTER INBOARD LOWER PANEL, WINGLET
527BL	ACCESS PANEL - CENTER OUTBOARD PANEL, WINGLET
527BT	ACCESS PANEL - CENTER INBOARD UPPER PANEL, WINGLET
534BB	Dry Bay Tank Access Door - Left Wing Station 748

D. Inspection

SUBTASK 57-05-03-010-054

- (1) Open these access panels:

Number	Name/Location
527AL	ACCESS PANEL - TRANSITION FAIRING, WINGLET
527BB	ACCESS PANEL - CENTER INBOARD LOWER PANEL, WINGLET
527BL	ACCESS PANEL - CENTER OUTBOARD PANEL, WINGLET
527BT	ACCESS PANEL - CENTER INBOARD UPPER PANEL, WINGLET
534BB	Dry Bay Tank Access Door - Left Wing Station 748

NOTE: Remove winglet assembly, outboard fairing, upper and lower bifurcation fairings and barrel nuts. Remove barrel nuts to facilitate inspection of recesses.

SUBTASK 57-05-03-211-005

- (2) Do a Detailed inspection of the splice plates, splice channels, lower blade clevis fitting, root fitting and wing Rib 27.

SUBTASK 57-05-03-910-053

- (3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-804

SUBTASK 57-05-03-410-052

- (4) Close these access panels:

Number	Name/Location
527AL	ACCESS PANEL - TRANSITION FAIRING, WINGLET
527BB	ACCESS PANEL - CENTER INBOARD LOWER PANEL, WINGLET
527BL	ACCESS PANEL - CENTER OUTBOARD PANEL, WINGLET
527BT	ACCESS PANEL - CENTER INBOARD UPPER PANEL, WINGLET
534BB	Dry Bay Tank Access Door - Left Wing Station 748

————— **END OF TASK** —————

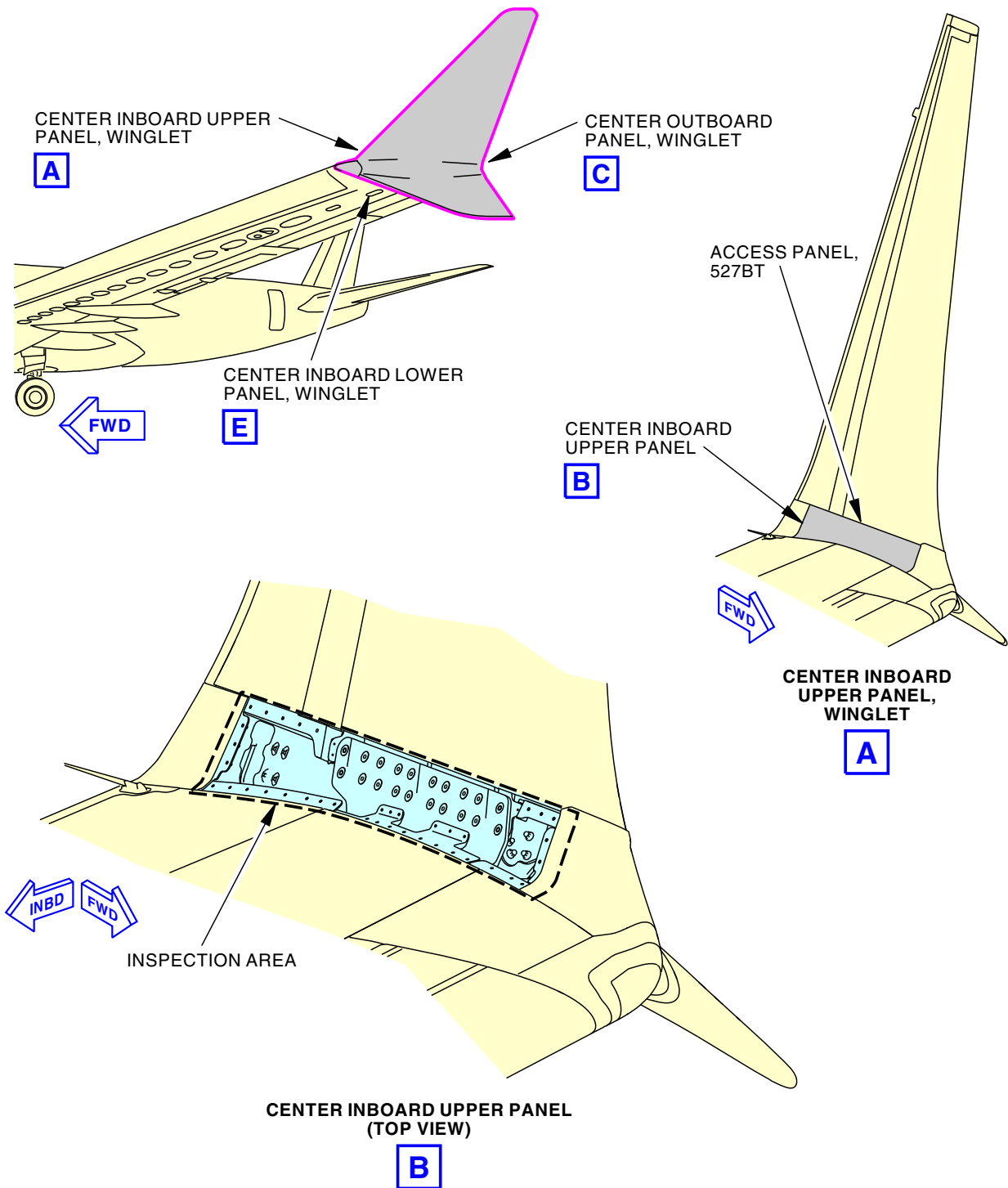
EFFECTIVITY
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2539073 S0000594281_V2

Left Winglet - Detailed (Internal)
Figure 263/57-05-03-990-862 (Sheet 1 of 3)

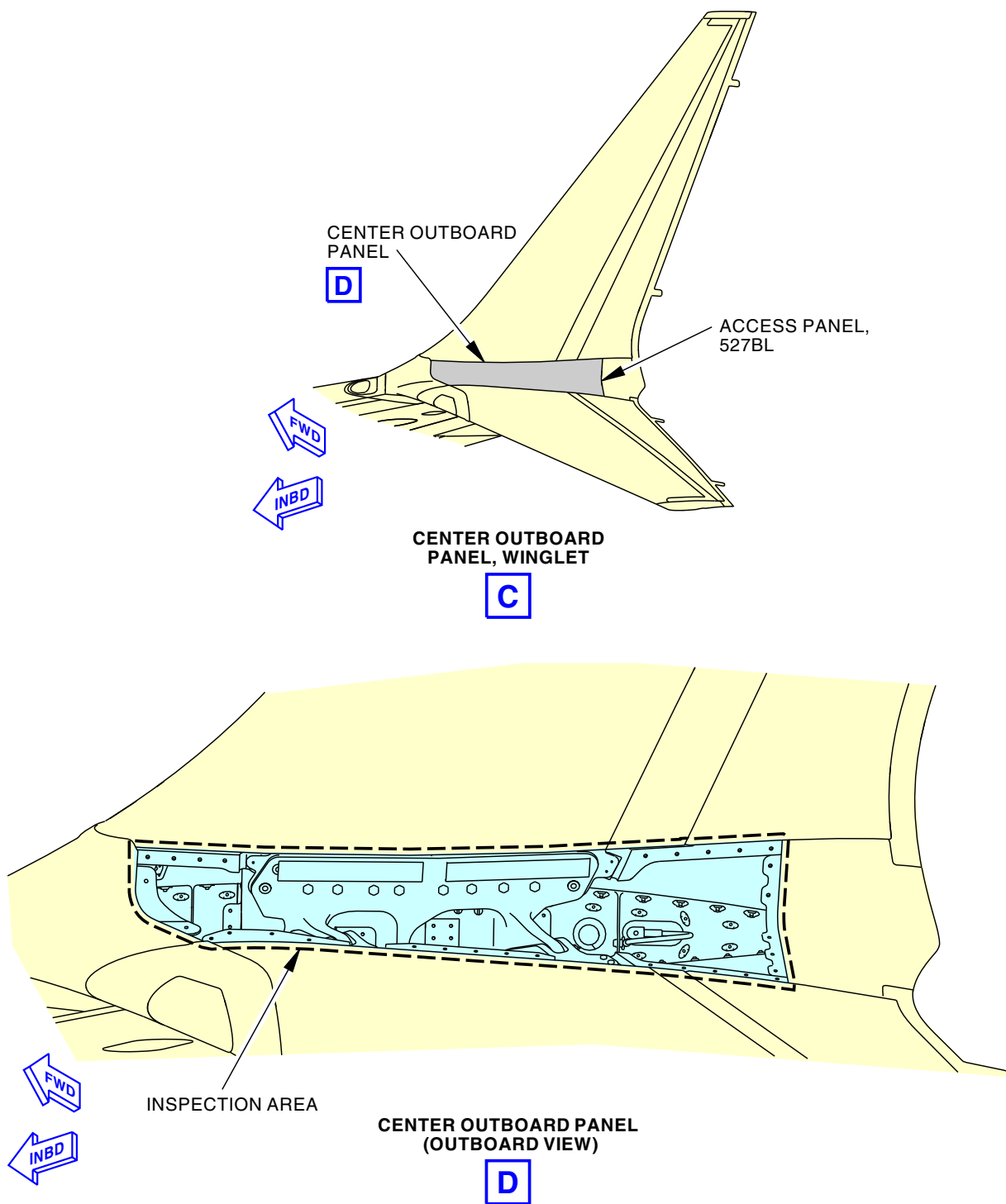
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2539081 S0000603474_V2

Left Winglet - Detailed (Internal)
Figure 263/57-05-03-990-862 (Sheet 2 of 3)

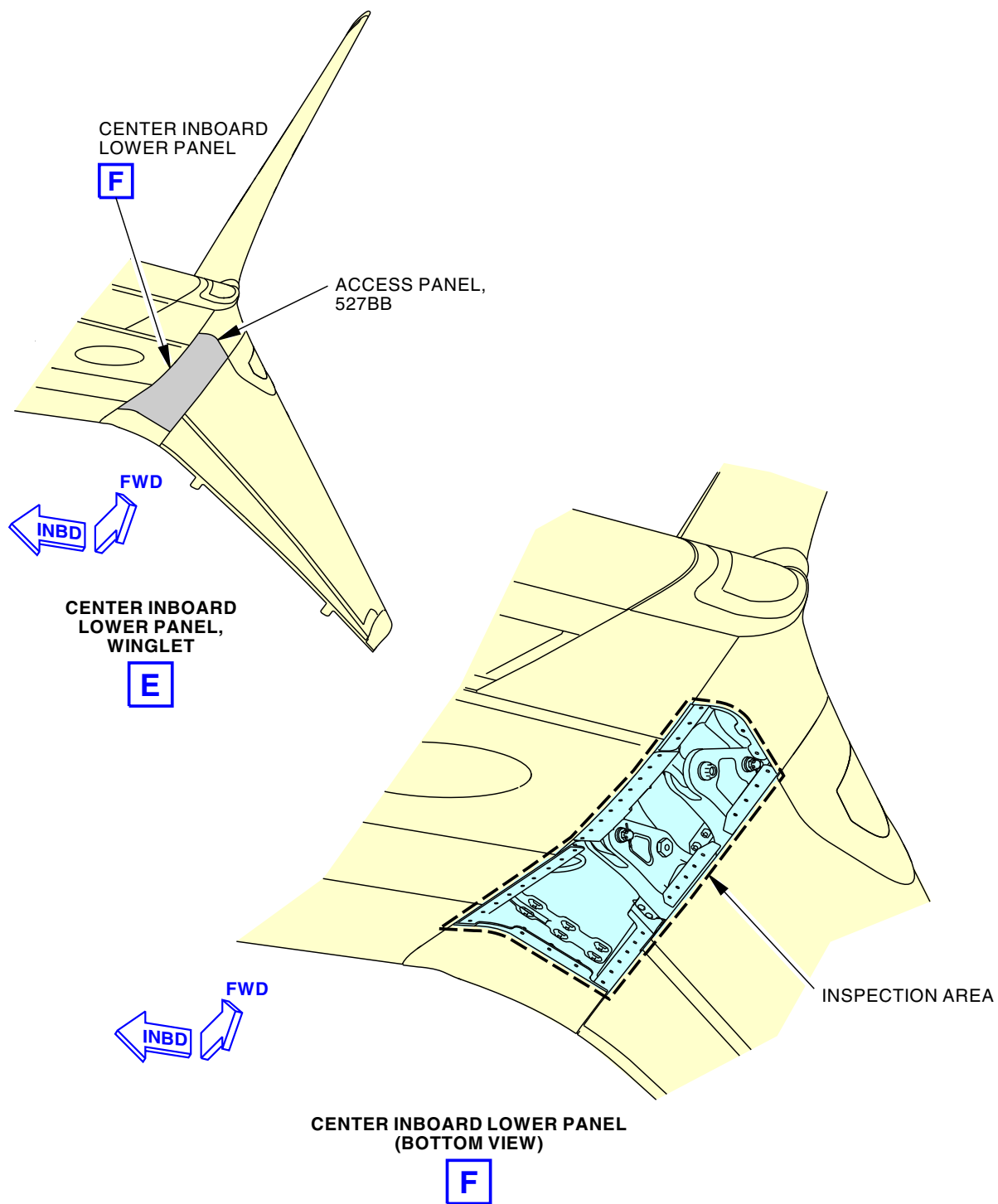
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2539082 S0000603475_V2

Left Winglet - Detailed (Internal)
Figure 263/57-05-03-990-862 (Sheet 3 of 3)

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TASK 57-05-03-211-806

56. **INTERNAL - DETAILED: RIGHT WINGLET**

(Figure 264)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-804	737-7/8/8200/9 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
627	Right Winglet

C. Access Panels

Number	Name/Location
627AR	ACCESS PANEL - TRANSITION FAIRING, WINGLET
627BB	ACCESS PANEL - CENTER INBOARD LOWER PANEL, WINGLET
627BR	ACCESS PANEL - CENTER OUTBOARD PANEL, WINGLET
627BT	ACCESS PANEL - CENTER INBOARD UPPER PANEL, WINGLET
634BB	Dry Bay Tank Access Door - Right Wing Station 748

D. Inspection

SUBTASK 57-05-03-010-055

- (1) Open these access panels:

<u>Number</u>	<u>Name/Location</u>
627AR	ACCESS PANEL - TRANSITION FAIRING, WINGLET
627BB	ACCESS PANEL - CENTER INBOARD LOWER PANEL, WINGLET
627BR	ACCESS PANEL - CENTER OUTBOARD PANEL, WINGLET
627BT	ACCESS PANEL - CENTER INBOARD UPPER PANEL, WINGLET
634BB	Dry Bay Tank Access Door - Right Wing Station 748

NOTE: Remove winglet assembly, outboard fairing, upper and lower bifurcation fairings and barrel nuts. Remove barrel nuts to facilitate inspection of recesses.

SUBTASK 57-05-03-211-006

- (2) Do a Detailed inspection of the splice plates, splice channels, lower blade clevis fitting, root fitting and wing Rib 27.

SUBTASK 57-05-03-910-054

- (3) 737-7/8/8200/9 Basic Task Description, TASK 51-05-01-210-804

SUBTASK 57-05-03-410-053

- (4) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
627AR	ACCESS PANEL - TRANSITION FAIRING, WINGLET
627BB	ACCESS PANEL - CENTER INBOARD LOWER PANEL, WINGLET
627BR	ACCESS PANEL - CENTER OUTBOARD PANEL, WINGLET
627BT	ACCESS PANEL - CENTER INBOARD UPPER PANEL, WINGLET
634BB	Dry Bay Tank Access Door - Right Wing Station 748

———— **END OF TASK** ————

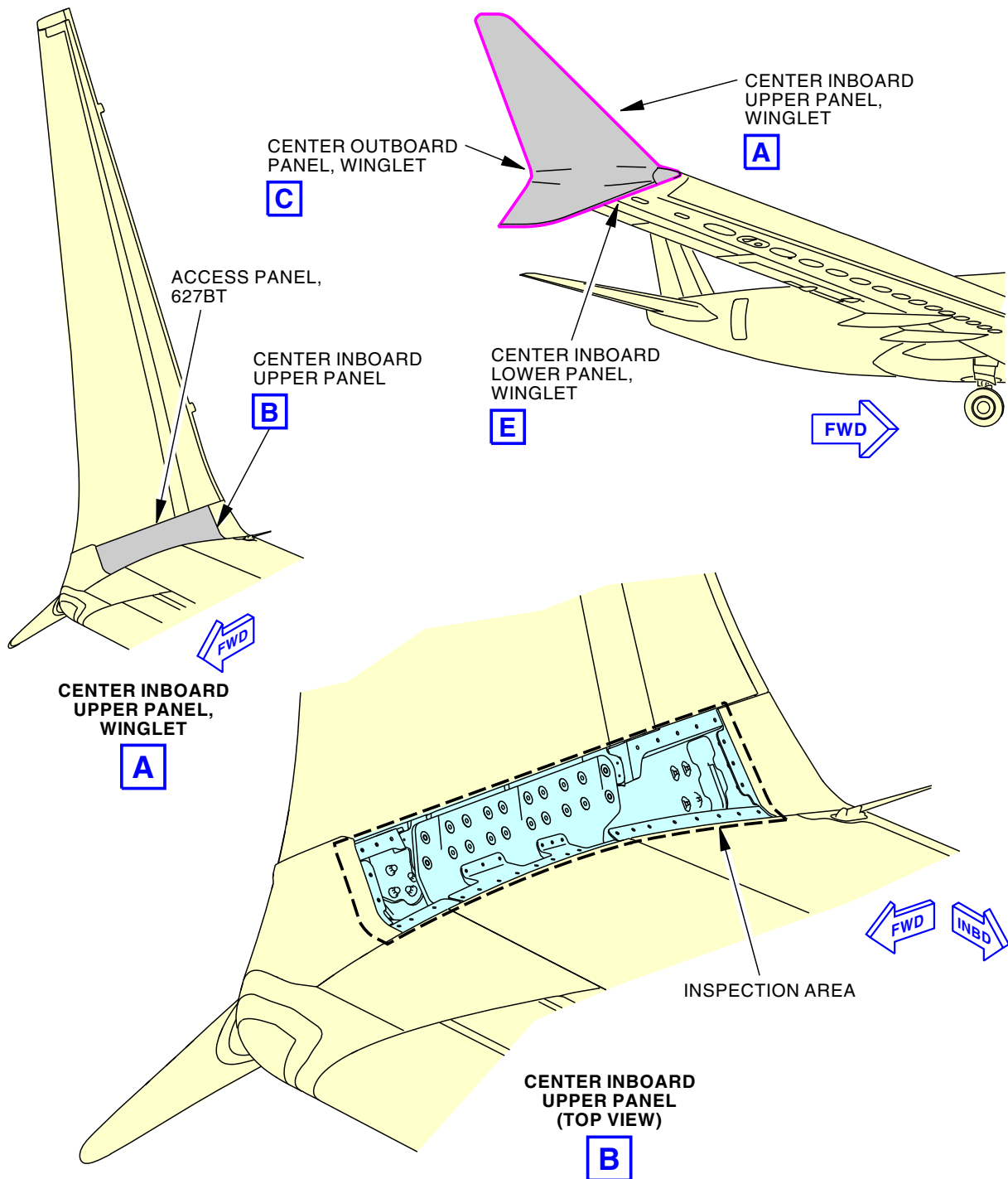
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2539080 S0000594283_V2

Right Winglet
Figure 264/57-05-03-990-863 (Sheet 1 of 3)

EFFECTIVITY
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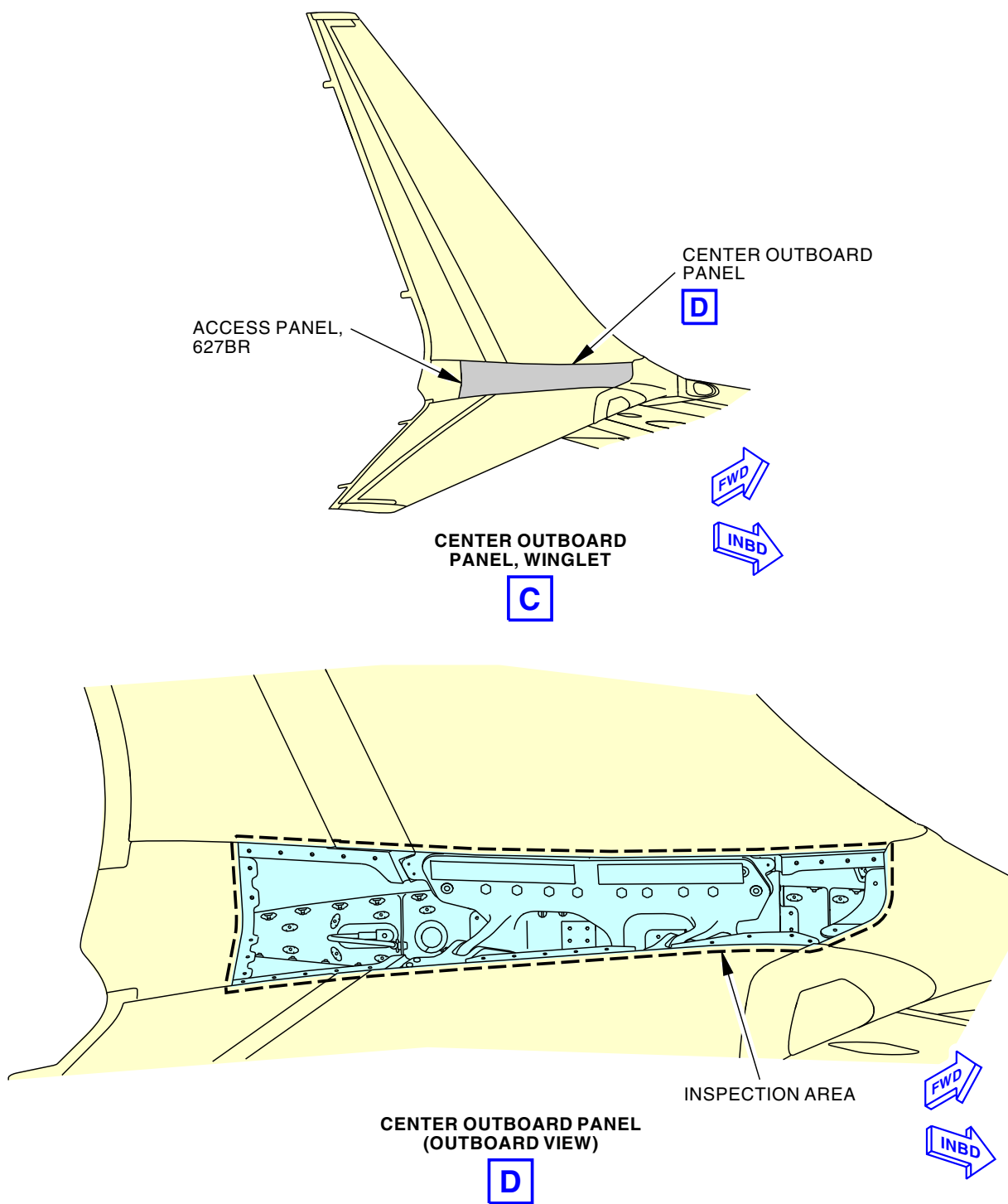
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2539075 S0000603478_V2

Right Winglet
Figure 264/57-05-03-990-863 (Sheet 2 of 3)

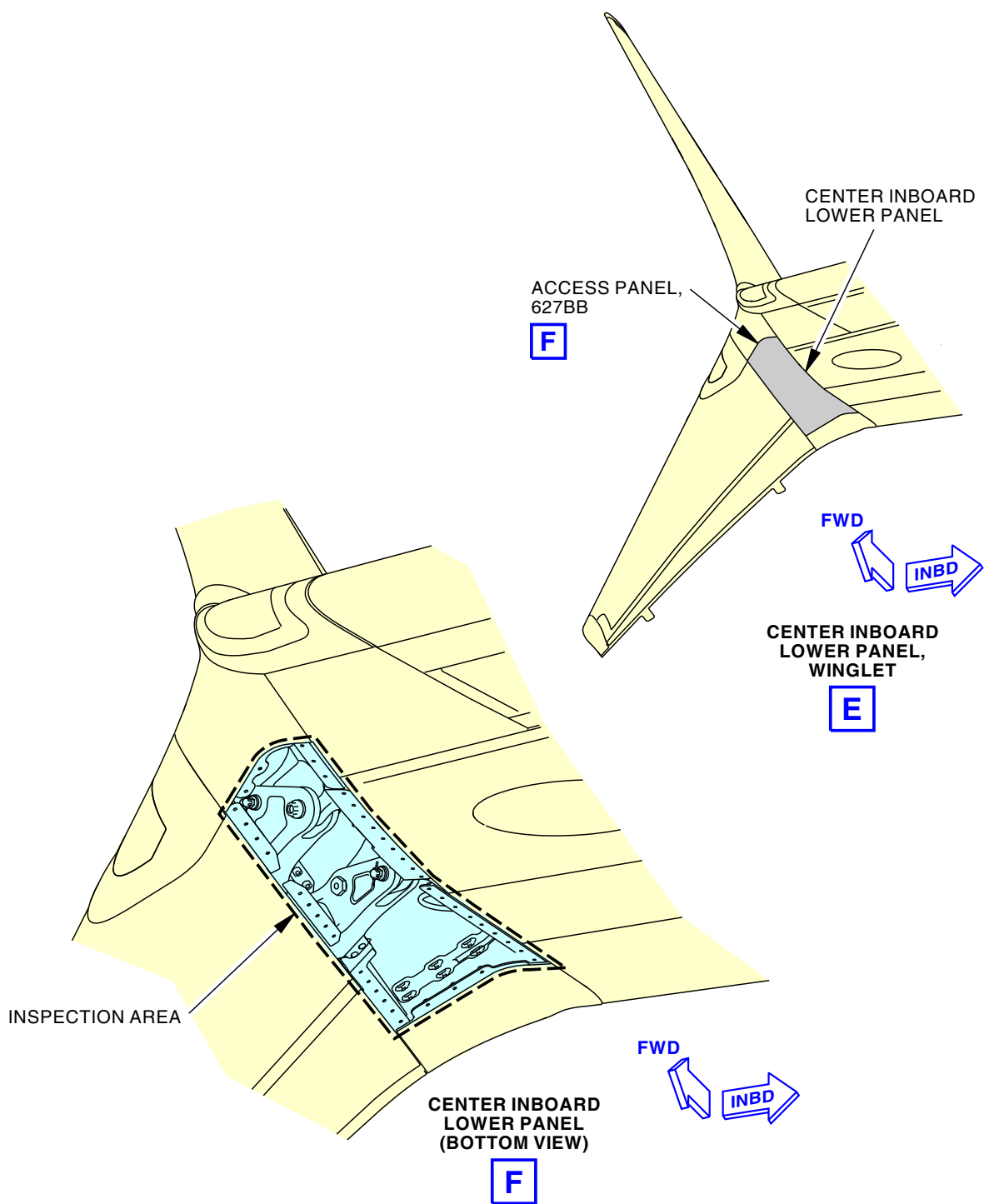
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2539076 S0000603479_V2

Right Winglet
Figure 264/57-05-03-990-863 (Sheet 3 of 3)

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WING CENTER SECTION - CORROSION PREVENTION

1. **General**

- A. Corrosion can occur on the upper and lower external surfaces of the wing center section. This procedure is for the lower skin of the wing center section and lower portion of the front spar. For corrosion prevention on the upper surfaces of the wing center section, refer to Repair of the Secondary Fuel Barrier Sealant, TASK 28-11-00-300-804.
- B. The lower skin is susceptible to corrosion due to moisture accumulation. Corrosion can readily start where protective finishes have been damaged.
- C. Corrosion in the bottom surface of the center wing may cause loss of cross-sectional area of the skin. This can result in a reduction in the load carrying capability of this primary structure and fuel leakage from airplanes which are equipped with integral center wing tanks.

TASK 57-14-00-910-801

2. **Wing Center Section - Corrosion Prevention**

A. **General**

- (1) Make a regular inspection to prevent or find the start of corrosion. Signs of corrosion are missing fasteners, white powdery, or other corrosion deposits. Initiate the corrosion prevention practices to decrease the occurrence of corrosion.
- (2) After you clean the suspected areas (PAGEBLOCK 51-21-31/701), do a full inspection to make sure that protective finishes remain intact.
- (3) Where corrosion exists (noticeable bulges of the skin or white deposits of corrosion products at fastener heads or joint edges), refer to the Structural Repair Manual for details of corrosion removal.
- (4) For minor corrosion, to minimize the downtime of the airplane, the corrosion products should be cleaned off, followed by the application of a corrosion inhibiting compound into the affected area to decrease the corrosion process. Refer to PAGEBLOCK 51-21-91/701 for details on applying corrosion inhibiting compound. The finish system should be repaired at the next maintenance opportunity.

B. **References**

Reference	Title
51-21-31 P/B 701	CORROSION REMOVAL AND CONTROL - CLEANING/PAINTING
51-21-91 P/B 701	CORROSION INHIBITING COMPOUND - CLEANING/PAINTING

C. **Consumable Materials**

Reference	Description	Specification
C00033	Coating - Protective Enamel, Flexibility Use	BMS10-60 Type II
C00175	Primer - Urethane Compatible, Corrosion Resistant	BMS10-79 Type III
C00259	Coating - Chemical And Solvent Resistant Finish, Corrosion Inhibiting Primer	BMS10-11 Type I
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23

D. **Location Zones**

Zone	Area
135	Area Above Wing Center Section, Body Station 540 to Body Station 663.75 - Left

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(Continued)

Zone	Area
136	Area Above Wing Center Section, Body Station 540 to Body Station 663.75 - Right

E. Procedure

SUBTASK 57-14-00-100-001

- (1) Clean the affected area to remove corrosion products.

SUBTASK 57-14-00-370-001

- (2) Apply 2 layers of primer, C00175 or primer, C00259 to areas where the paint is missing.

SUBTASK 57-14-00-390-001

- (3) If you used primer, C00175, coating, C00033 may be applied to the area for additional corrosion protection. Do not apply coating, C00033 if you used primer, C00259.

SUBTASK 57-14-00-370-002

- (4) Frequency of Application

- (a) Periodic inspection is required in areas identified as susceptible to corrosion and should be consistent to the schedules specified in the Maintenance Planning Document. Operators must be aware of reported problems and areas of occurrences.
- (b) Periodic application of corrosion inhibiting compound, G00009 is necessary to areas identified and should be consistent to the schedule specified in the Maintenance Planning Document.

————— **END OF TASK** —————

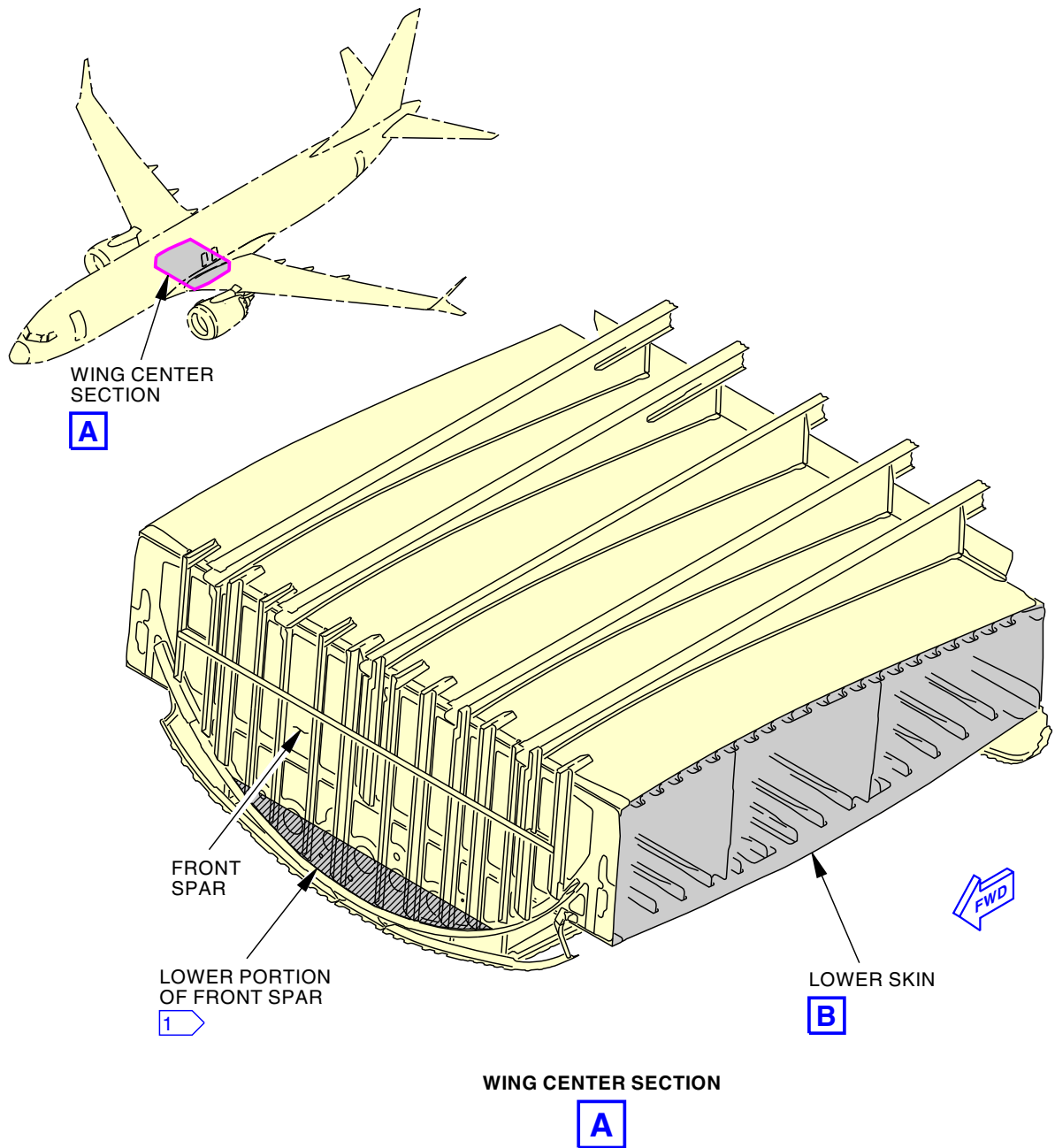
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1 CORROSION PREVENTION ON THE UPPER SKIN OR UPPER PORTION OF THE FRONT SPAR MUST BE DONE PER 28-11-00-300-804

2416580 S00061541080_V1

Wing Center Section - Corrosion Prevention
Figure 201/57-14-00-990-801 (Sheet 1 of 2)

EFFECTIVITY
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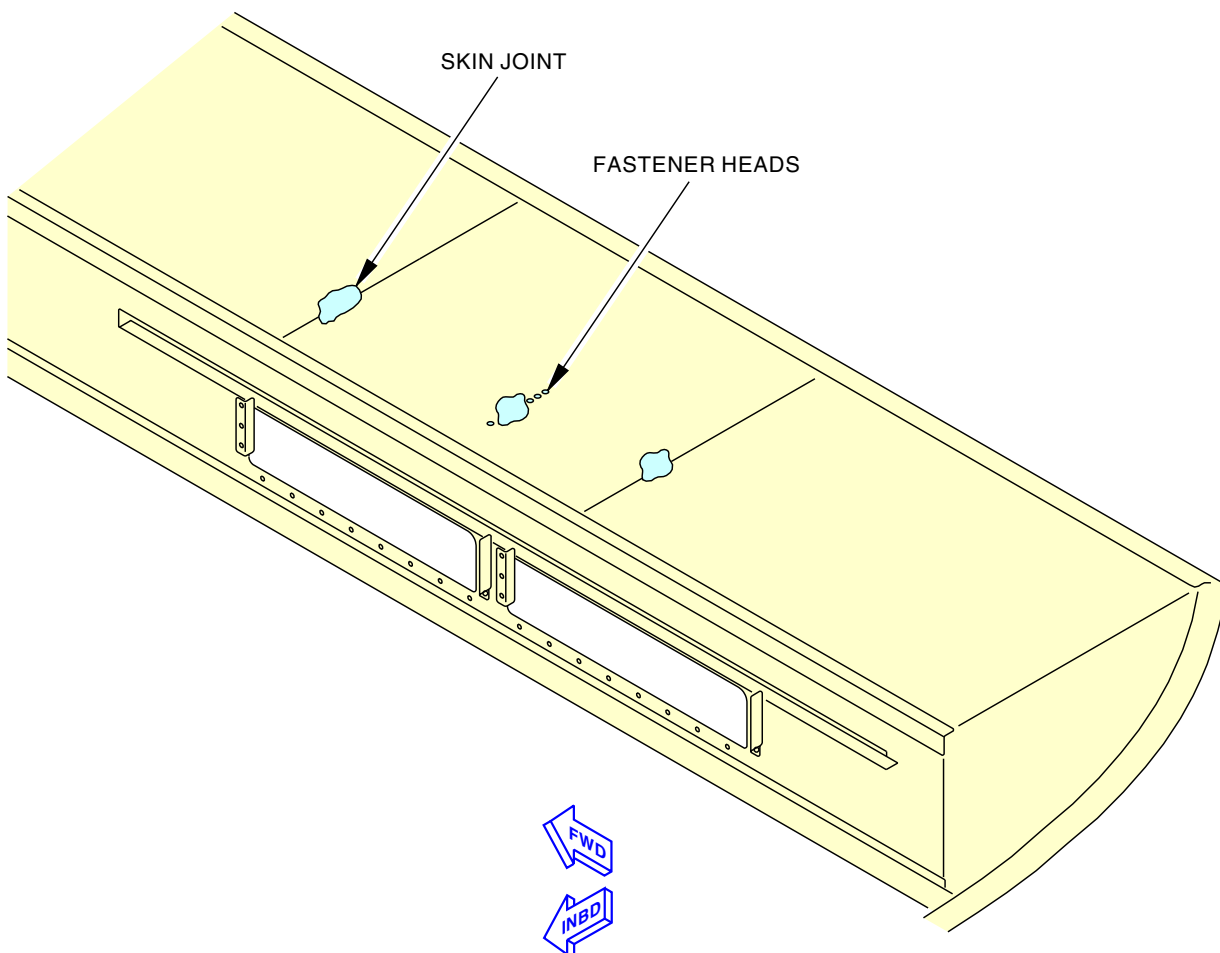
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CENTER WING SECTION LOWER SKIN



2416581 S00061541081_V1

Wing Center Section - Corrosion Prevention
Figure 201/57-14-00-990-801 (Sheet 2 of 2)

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MLG FORWARD TRUNNION HOUSING ASSEMBLY - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

- (1) MLG Forward Trunnion Housing Assembly Removal
- (2) MLG Forward Trunnion Housing Assembly Installation.

TASK 57-16-01-000-801

2. MLG Forward Trunnion Housing Assembly Removal

(Figure 401)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
32-00-01-480-801	Landing Gear Downlock Pins Installation (P/B 201)
32-11-00-000-802	Main Landing Gear Removal (P/B 401)

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-9117	Puller - Fuse Pin, Main Landing Gear Forward Trunnion Support Part #: C32015-34 Supplier: 81205 Opt Part #: C32015-18 Supplier: 81205

C. Location Zones

Zone	Area
551	Left Wing - Rear Spar To Landing Gear Support Beam
651	Right Wing - Rear Spar to Landing Gear Support Beam

D. Prepare for the Removal

SUBTASK 57-16-01-020-005



WARNING

MAKE SURE THAT THE DOWNLOCK PINS ARE INSTALLED ON ALL THE LANDING GEAR. WITHOUT THE DOWNLOCK PINS, THE LANDING GEAR CAN RETRACT. THIS CAN CAUSE INJURIES TO PERSONS, AND DAMAGE TO EQUIPMENT.

- (1) Make sure that the downlock pins are installed on the nose and main landing gear (TASK 32-00-01-480-801).

SUBTASK 57-16-01-020-006

- (2) Do this task: Main Landing Gear Removal, TASK 32-11-00-000-802.

SUBTASK 57-16-01-020-008

- (3) Remove the clamp [10] from the hydraulic flow regulator, do this step:
 - (a) Remove the screws [11] and washers [12].

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E. MLG Forward Trunnion Housing Assembly Removal

SUBTASK 57-16-01-020-001

- (1) Remove the forward trunnion housing assembly [8], do these steps:

NOTE: Remove the lower fuse pin [6] first to prevent the rotating of the housing assembly [8].

- (a) Remove the nuts [2], washers [5], and fuse pin caps [3] on each end of the rods [4].
- (b) Remove the rods [4] from the fuse pins [6].
- (c) Remove the nuts [9] and washers [7] from the fuse pins [6].

SIA 015

NOTE: There are no washers [7] on the right and left trunnion.

SIA ALL

- (d) Use the puller, SPL-9117, to remove the fuse pins [6] that hold the housing assembly [8] to the forward trunnion support.
- (e) Remove the forward trunnion housing assembly [8] along with the bearing assembly [1] from the airplane.

———— **END OF TASK** ————

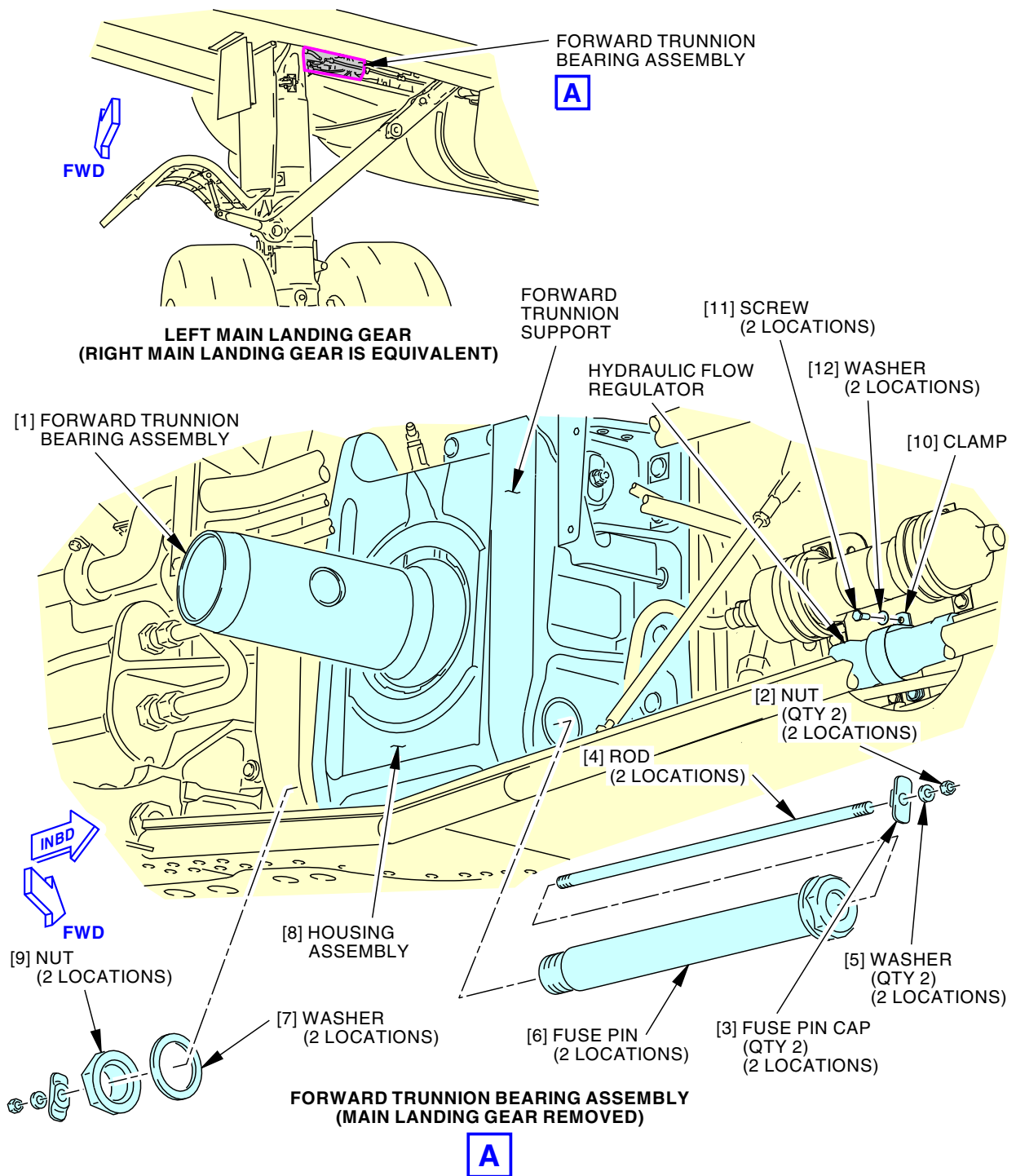
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Forward Trunnion Housing Assembly Installation
Figure 401/57-16-01-990-801 (Sheet 1 of 2)

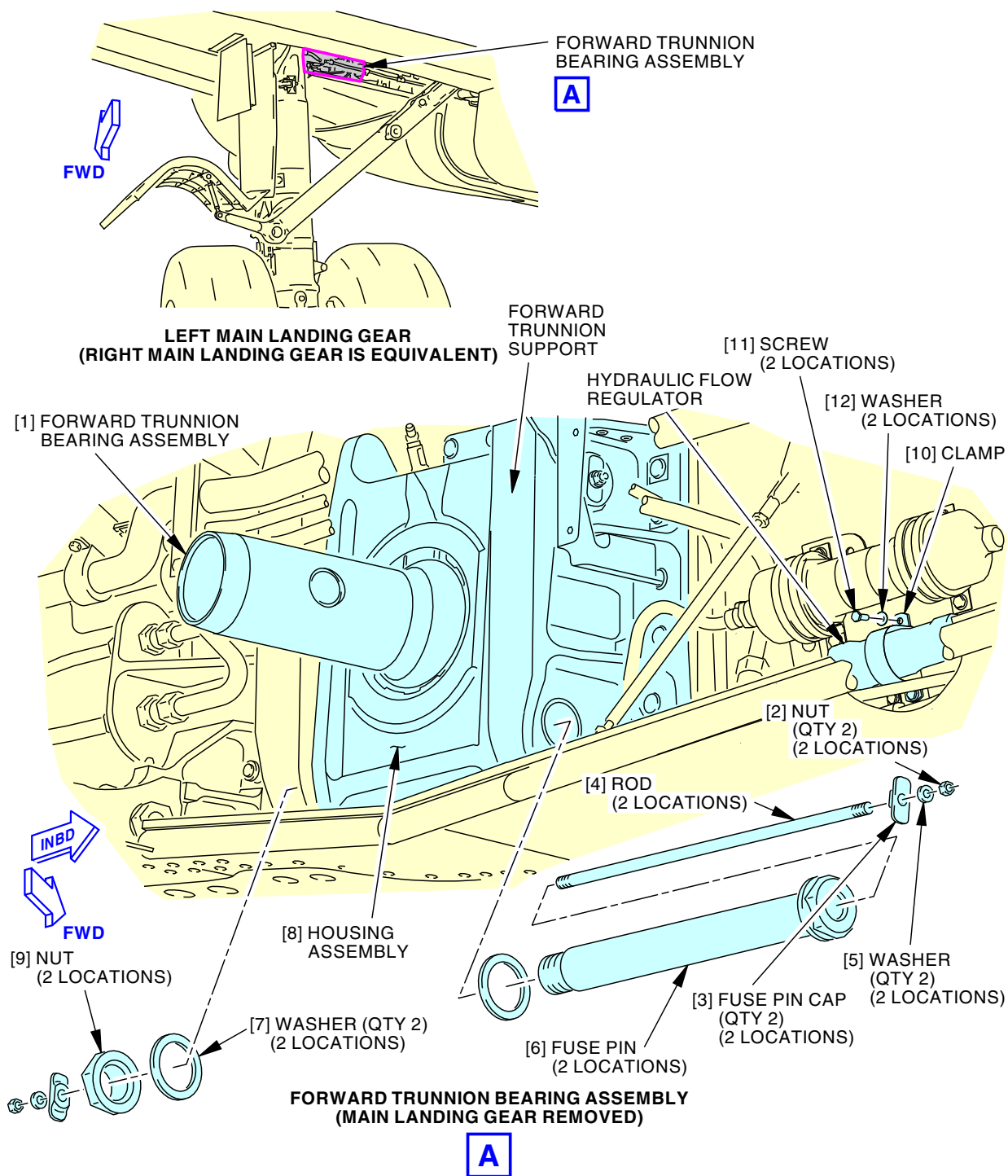
EFFECTIVITY
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2414106 S00061534411_V3

Forward Trunnion Housing Assembly Installation
Figure 401/57-16-01-990-801 (Sheet 2 of 2)

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TASK 57-16-01-400-801

3. **MLG Forward Trunnion Housing Assembly Installation**

(Figure 401)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
12-21-11-640-801	Main Landing Gear Upper End Components Servicing (P/B 301)
32-11-00-400-802	Main Landing Gear Installation (P/B 401)

B. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
A50009	Sealant - Low Density, Non-Chromate Type. (Formerly Chromate - Synthetic Rubber)	BMS5-142 Type II Class B-1 or B-2
D00006	Compound - Antiseize Pure Nickel Special - Never-Seez NSBT	
G01043	Cloth - Lint-free	
G50136	Compound - Corrosion Inhibiting, Non-drying Paste	BMS3-38

C. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
8	Housing assembly	32-11-83-01-095	SIA ALL

D. Location Zones

Zone	Area
551	Left Wing - Rear Spar To Landing Gear Support Beam
651	Right Wing - Rear Spar to Landing Gear Support Beam

E. MLG Forward Trunnion Housing Assembly Installation

SUBTASK 57-16-01-420-001



USE NITRILE GLOVES FOR SKIN PROTECTION AGAINST CORROSION INHIBITOR MATERIAL, G50136. IF CORROSION INHIBITOR MATERIAL, G50136 GETS ON YOUR SKIN, IMMEDIATELY REMOVE IT WITH WATER. IF THIS MATERIAL GETS IN YOUR EYES, IMMEDIATELY FLUSH YOUR EYES WITH WATER AND GET MEDICAL AID. THIS MATERIAL CONTAINS VERY POISONOUS AND FLAMMABLE AGENTS WHICH CAN CAUSE INJURIES TO PERSONNEL.

- (1) Install the forward trunnion housing assembly [8], do these steps:
 - (a) Apply a thin layer of corrosion inhibiting material, G50136, to the outer diameters of the fuse pins [6].
 - (b) Put the housing assembly [8] in its position for the connection to the forward trunnion support.

NOTE: The zerk fitting on the housing assembly will point up and aft.
 - (c) Align the holes in the housing assembly [8] to the holes in the forward trunnion support.

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SIA 001-014

- (d) Install the washers [7] as follows:



DO NOT APPLY SEALANT TO WASHER SURFACES THAT TOUCH WITH THE PIN HEADS OR NUTS. THIS CAN CAUSE DAMAGE TO THE EQUIPMENT.

- 1) Apply corrosion inhibiting material, G50136, to the non-countersunk side of the washers [7].
 - 2) Install the washers [7] on the forward trunnion support.
 - a) For each washer [7], turn the non-countersunk side against the forward trunnion support.
 - b) Visually align the washers [7] with the forward trunnion support bore.
- NOTE: Washers are to stay aligned with the fuse pins during installation of the fuse pins.

SIA 001-014, 016-999

- (e) Put the fuse pins [6] through the washers [7], forward trunnion support, and housing assembly [8].

NOTE: Install the upper fuse pin [6] first to prevent the rotating of the housing assembly [8].

SIA 015

- (f) Put the fuse pins [6] through the forward trunnion support, and housing assembly [8].

NOTE: Install the upper fuse pin [6] first to prevent the rotating of the housing assembly [8].

SIA ALL

- (g) Use a clean lint-free cloth, G01043, to clean unwanted corrosion inhibiting material, G50136, from the threads of the fuse pins [6].
- (h) Apply Never-Seez NSBT compound, D00006, to the inner surfaces of nuts [9] and to the threads of the fuse pins [6].
- (i) Install the nuts [9] on the fuse pins [6].
- (j) Tighten the nuts [9] to 1325 ± 25 in-lb (150 ± 3 N·m).

SIA 001-014, 016-999

- 1) Make sure that the washers [7] stay aligned with the support bore when each nut [9] is tightened.
 - 2) Do a visual inspection that the washers [7] are centered.
- (k) Use a clean lint-free cloth, G01043, to clean unwanted corrosion inhibiting material, G50136, at the outer edges of the washers [7].

SIA 001-014

- (l) Apply a fillet seal to the edge of the washers [7] with sealant, A00247, or sealant, A50009.

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SIA 015

- (m) Apply a fillet seal to the edges of the nuts [9] with sealant, A00247.

SIA ALL

- (n) Put the rods [4] into the fuse pins [6].
- (o) Install the fuse pin caps [3], washers [5], and nuts [2] on the ends of the rods [4].
- (p) Tighten the nuts [2] to 65 ± 15 in-lb (7 ± 2 N·m).

SUBTASK 57-16-01-420-003

- (2) Install the clamp [10], screws [11], and washers [12] on the hydraulic flow regulator.

F. Put the Airplane Back to Its Usual Condition

SUBTASK 57-16-01-420-004

- (1) Do this task: Main Landing Gear Installation, TASK 32-11-00-400-802.

SUBTASK 57-16-01-610-001

- (2) Do this task to lubricate the housing assembly [8]: Main Landing Gear Upper End Components Servicing, TASK 12-21-11-640-801.

———— **END OF TASK** ————

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MLG FORWARD TRUNNION HOUSING ASSEMBLY - INSPECTION/CHECK

1. General

- A. This procedure has one task:
(1) MLG forward trunnion bearing wear limits.

TASK 57-16-01-200-801

2. MLG Forward Trunnion Bearing Wear Limits

(Figure 601)

A. **General**

- (1) This procedure examines the bearings of the Main Landing Gear (MLG) forward trunnion.

B. **References**

Reference	Title
57-16-01-000-801	MLG Forward Trunnion Housing Assembly Removal (P/B 401)
57-16-01-400-801	MLG Forward Trunnion Housing Assembly Installation (P/B 401)

C. **Location Zones**

Zone	Area
551	Left Wing - Rear Spar To Landing Gear Support Beam
651	Right Wing - Rear Spar to Landing Gear Support Beam

D. **Prepare for the Procedure**

SUBTASK 57-16-01-010-002

- (1) Do this task: MLG Forward Trunnion Housing Assembly Removal, TASK 57-16-01-000-801.

E. **Procedure**

SUBTASK 57-16-01-200-001

- (1) Make sure that the dimensions for each part are within tolerance (Figure 601, Table 601).

Table 601/57-16-01-993-801 Forward Trunnion Housing Assembly Wear Limits

INDEX NO.	PART NAME	DIM.	DESIGN LIMITS		WEAR LIMITS	
			DIAMETER		PERMITTED WEAR DIMENSION INCH (mm)	MAXIMUM DIAMETER CLEARANCE INCH (mm)
			MIN INCH (mm)	MAX INCH (mm)		
1	HOUSING	ID	5.1865 in. (131.737 mm)	5.1885 in. (131.788 mm)	---	---
	RACE ASSEMBLY	OD	5.1843 in. (131.681 mm)	5.1853 in. (131.707 mm)	---	---
2	RACE ASSEMBLY	ID	4.6895 in. (119.113 mm)	4.6905 in. (119.139 mm)	---	---
	PIN ASSEMBLY	OD	4.6775 in. (118.809 mm)	4.6805 in. (118.885 mm)	---	---

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Table 601/57-16-01-993-801 Forward Trunnion Housing Assembly Wear Limits (Continued)

INDEX NO.	PART NAME	DIM.	DESIGN LIMITS		WEAR LIMITS	
			DIAMETER		PERMITTED WEAR DIMENSION INCH (mm)	MAXIMUM DIAMETER CLEARANCE INCH (mm)
			MIN INCH (mm)	MAX INCH (mm)		
3	SUPPORT ASSEMBLY	ID	1.6287 in. (41.369 mm)	1.6295 in. (41.389 mm)	---	0
	BUSHING	OD	1.6313 in. (41.435 mm)	1.6325 in. (41.466 mm)	---	0
4	BUSHING	ID	1.3580 in. (34.493 mm)	1.3605 in. (34.557 mm)	---	---
	FUSE PIN	OD	1.3565 in. (34.455 mm)	1.3570 in. (34.468 mm)	---	---

F. Put the Airplane Back to Its Usual Condition

SUBTASK 57-16-01-410-003

(1) Do this task: MLG Forward Trunnion Housing Assembly Installation, TASK 57-16-01-400-801.

————— **END OF TASK** —————

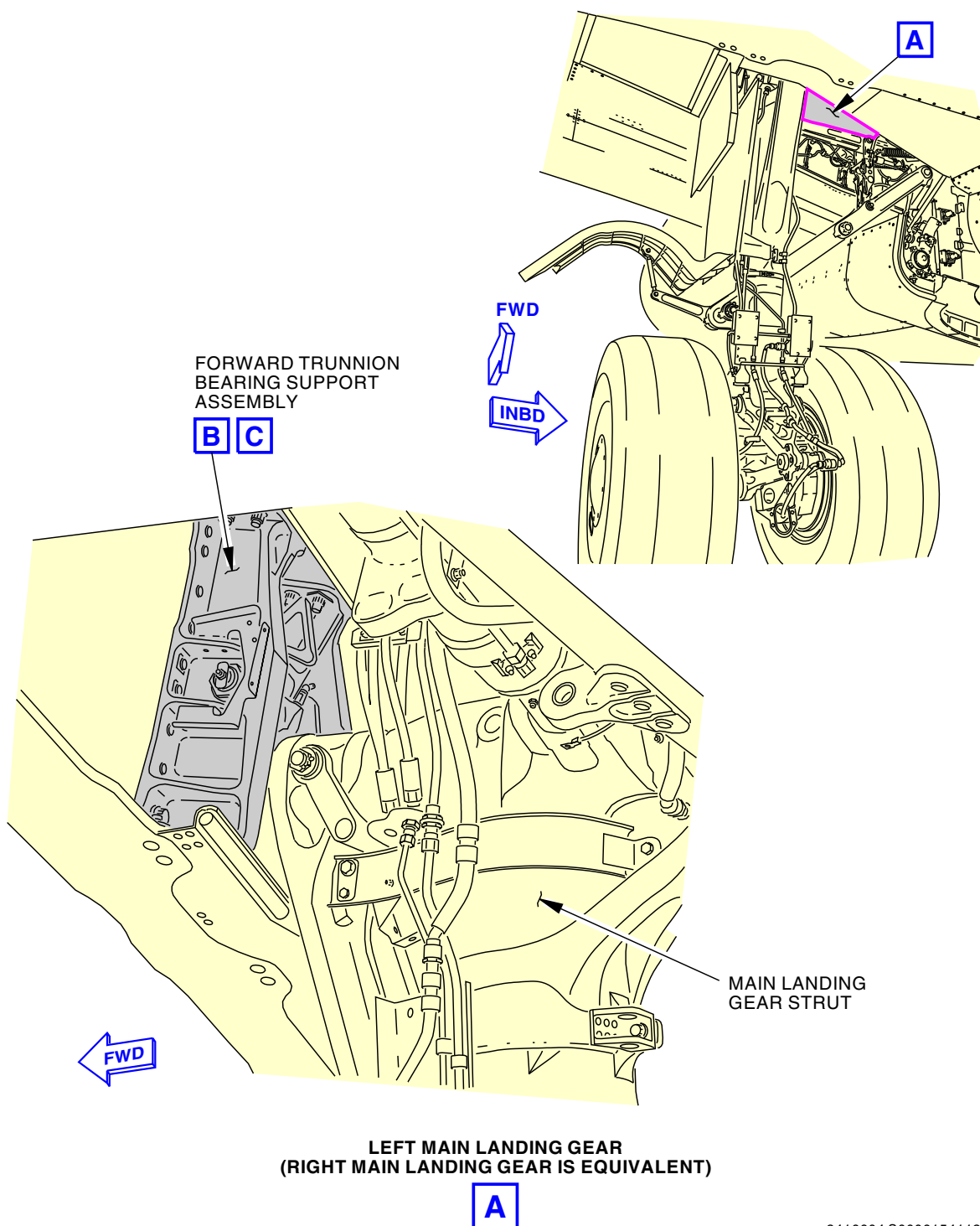
EFFECTIVITY
SIA ALL

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2416604 S00061541121_V1

Forward Trunnion Housing Assembly Inspection
Figure 601/57-16-01-990-802 (Sheet 1 of 5)

EFFECTIVITY
SIA ALL

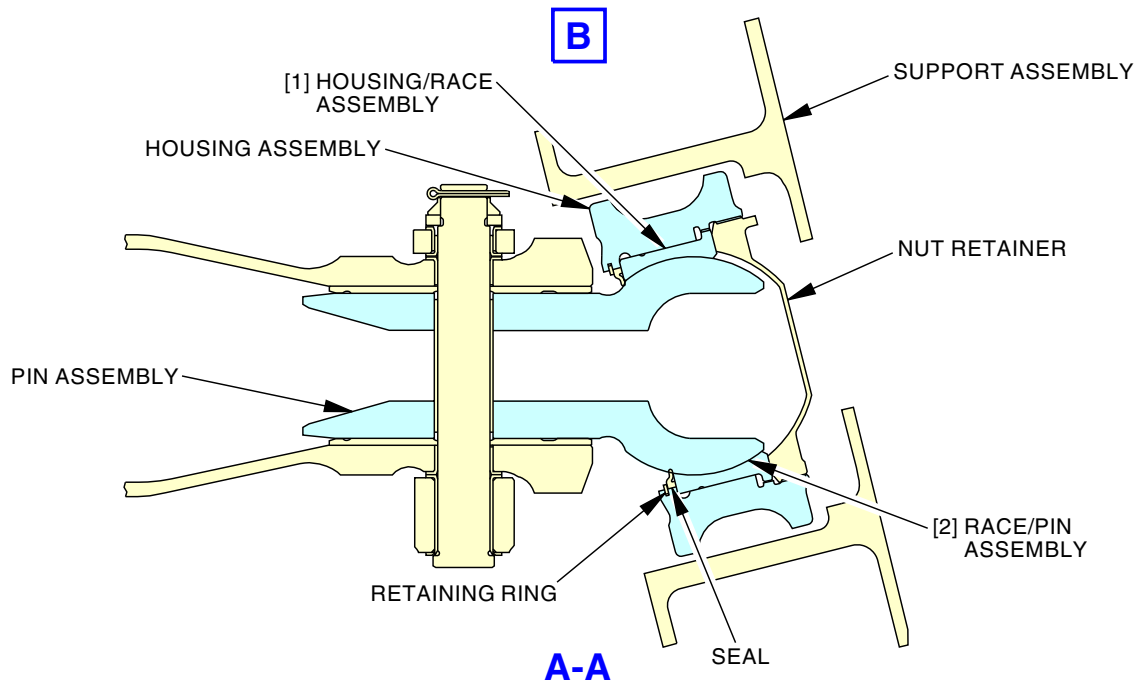
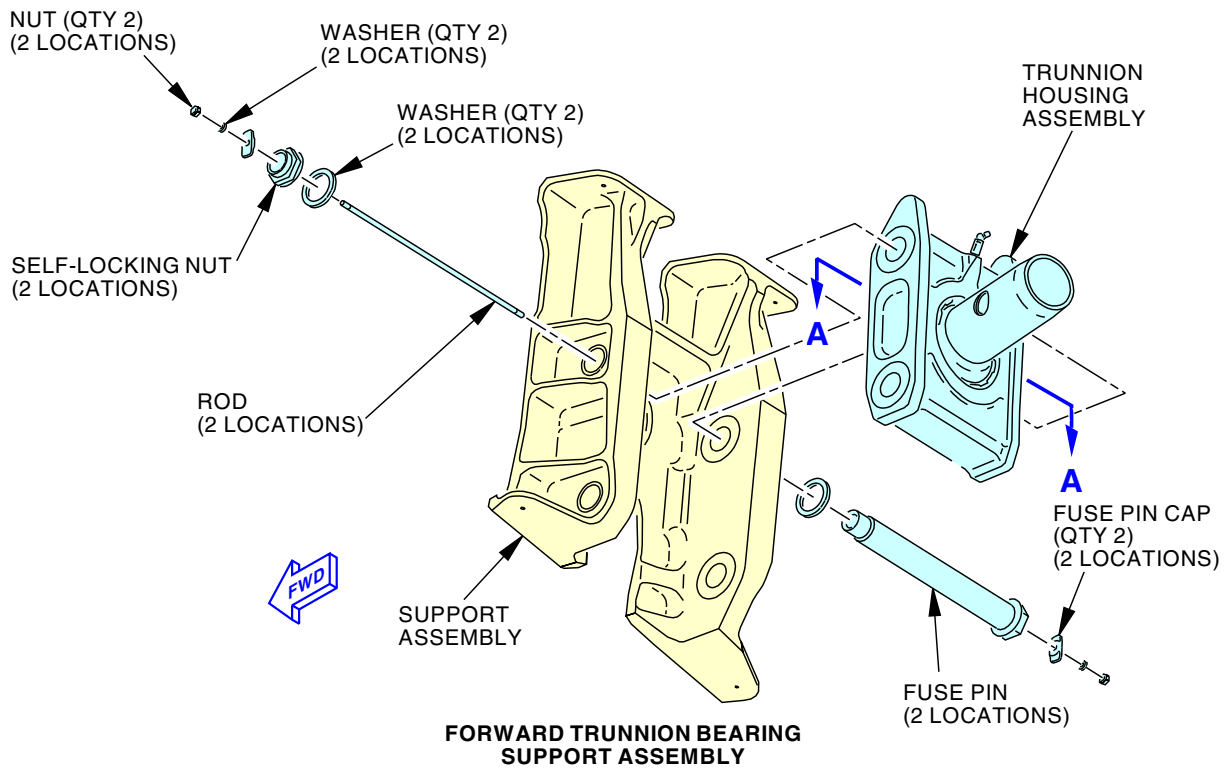
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AIRCRAFT MAINTENANCE MANUAL



2416605 S00061541122_V1

Forward Trunnion Housing Assembly Inspection
Figure 601/57-16-01-990-802 (Sheet 2 of 5)

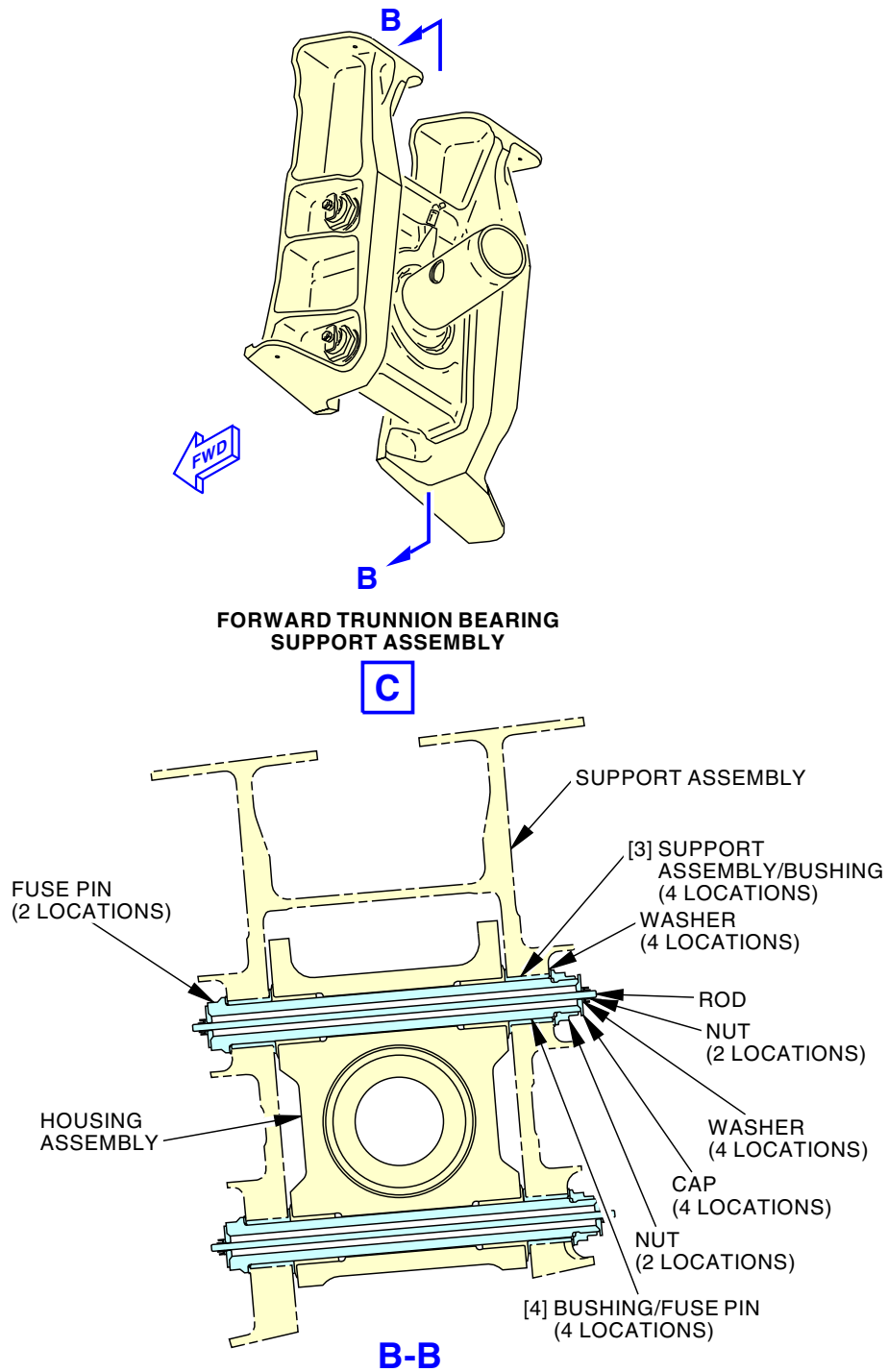
EFFECTIVITY
SIA 001-014, 016-999

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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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2416606 S00061541123_V2

Forward Trunnion Housing Assembly Inspection
Figure 601/57-16-01-990-802 (Sheet 3 of 5)

EFFECTIVITY
SIA 001-014, 016-999

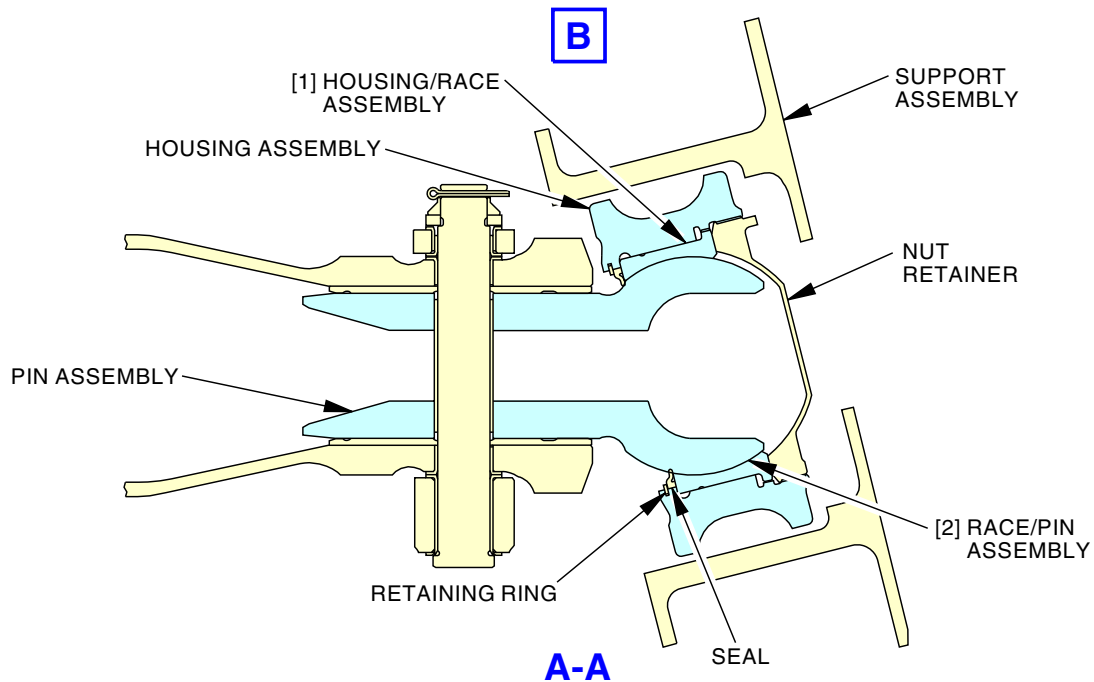
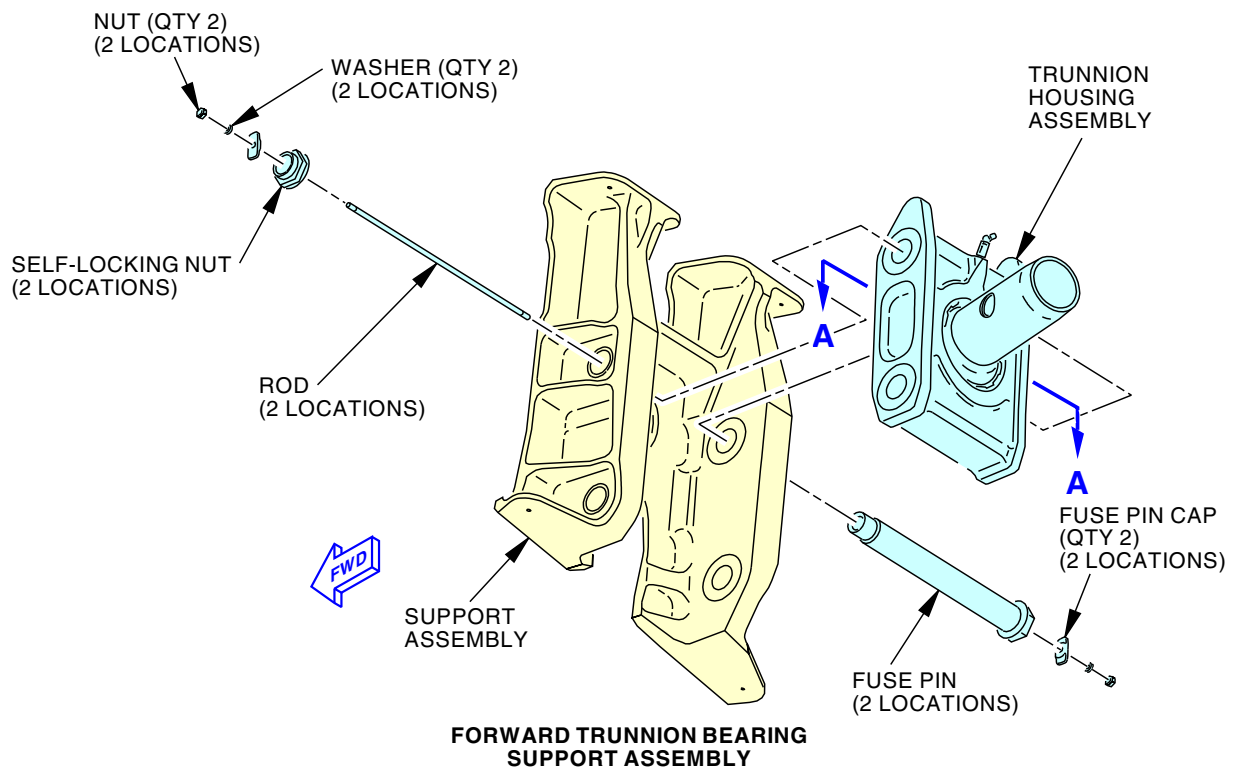
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3019887 S0000792132_V1

Forward Trunnion Housing Assembly Inspection
Figure 601/57-16-01-990-802 (Sheet 4 of 5)

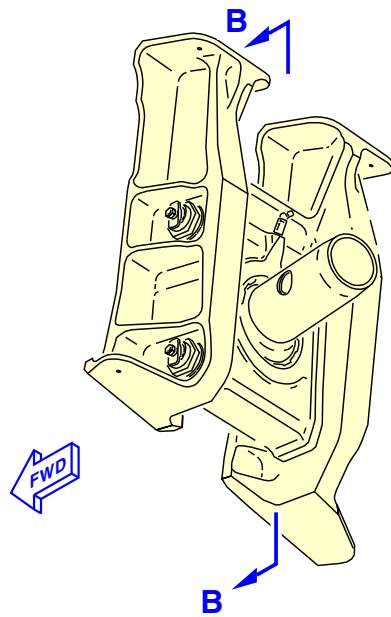
EFFECTIVITY
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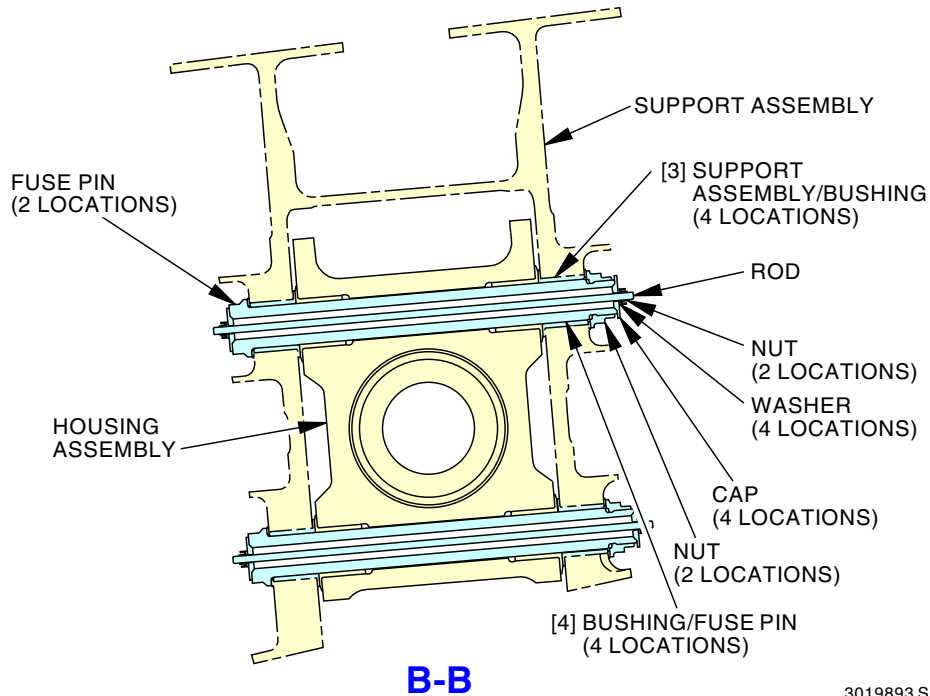
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FORWARD TRUNNION BEARING
SUPPORT ASSEMBLY

C



3019893 S0000792137_V2

Forward Trunnion Housing Assembly Inspection
Figure 601/57-16-01-990-802 (Sheet 5 of 5)

EFFECTIVITY
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MAIN LANDING GEAR (MLG) AFT TRUNNION BEARING ASSEMBLY - REMOVAL/INSTALLATION

1. General

- A. This procedure contains scheduled maintenance task data.
- B. This procedure has two tasks:
 - (1) MLG aft trunnion bearing assembly removal
 - (2) MLG aft trunnion bearing assembly installation.

TASK 57-16-02-000-801

2. MLG Aft Trunnion Bearing Assembly Removal

(Figure 401)

NOTE: This procedure is a scheduled maintenance task.

A. General

- (1) This task has the steps to remove the Main Landing Gear (MLG) aft trunnion bearing assembly.

B. References

Reference	Title
07-10-01-580-801	Lift the Airplane on Jacks (P/B 201)
32-00-01-480-801	Landing Gear Downlock Pins Installation (P/B 201)
32-11-00-000-802	Main Landing Gear Removal (P/B 401)

C. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-11076	Torque Wrench Adaptor Part #: C32013-16 Supplier: 81205 Opt Part #: C32013-9 Supplier: 81205

D. Location Zones

Zone	Area
133	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Left
134	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Right
734	Left Main Landing Gear
744	Right Main Landing Gear

E. Prepare for the Removal

SUBTASK 57-16-02-480-001



WARNING

MAKE SURE THAT THE DOWNLOCK PINS ARE INSTALLED ON ALL THE LANDING GEAR. WITHOUT THE DOWNLOCK PINS, THE LANDING GEAR CAN RETRACT. THIS CAN CAUSE INJURIES TO PERSONS, AND DAMAGE TO EQUIPMENT.

- (1) Make sure that the downlock pins are installed on the nose and main landing gear (TASK 32-00-01-480-801).

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SUBTASK 57-16-02-010-002

- (2) To get access to the aft trunnion bearing assembly:



CAUTION

MAKE SURE THAT YOU RELEASE THE PARKING BRAKE BEFORE YOU LIFT OR LOWER THE AIRPLANE WITH JACKS. IF YOU DO NOT OBEY, DAMAGE TO THE AIRPLANE AND EQUIPMENT CAN OCCUR.



CAUTION

MAKE SURE THAT YOU REMOVE THE WHEEL CHOCKS BEFORE YOU LIFT OR LOWER THE AIRPLANE WITH JACKS. IF YOU DO NOT REMOVE BLOCKAGES AROUND THE MAIN LANDING GEAR, DAMAGE TO THE AIRPLANE AND EQUIPMENT CAN OCCUR.

- (a) Do this task: Lift the Airplane on Jacks, TASK 07-10-01-580-801.
(b) Do this task: Main Landing Gear Removal, TASK 32-11-00-000-802.

- 1) Remove the aft trunnion pin [6] from the aft trunnion bearing assembly.

NOTE: This pin was attached to the aft trunnion with tie wraps within the procedure done before.

F. Procedure

SUBTASK 57-16-02-020-001

- (1) Remove the lock tab [4] from the lock plate.
(a) Remove the lockwire, screws [2] and washers [3].

SUBTASK 57-16-02-020-002

- (2) Remove the retainer nut [1].
(a) Use torque wrench adaptor, SPL-11076 to remove the retainer nut [1].

SUBTASK 57-16-02-020-003

- (3) Remove the split ball assembly [7] and outer race assembly [5].

———— **END OF TASK** ————

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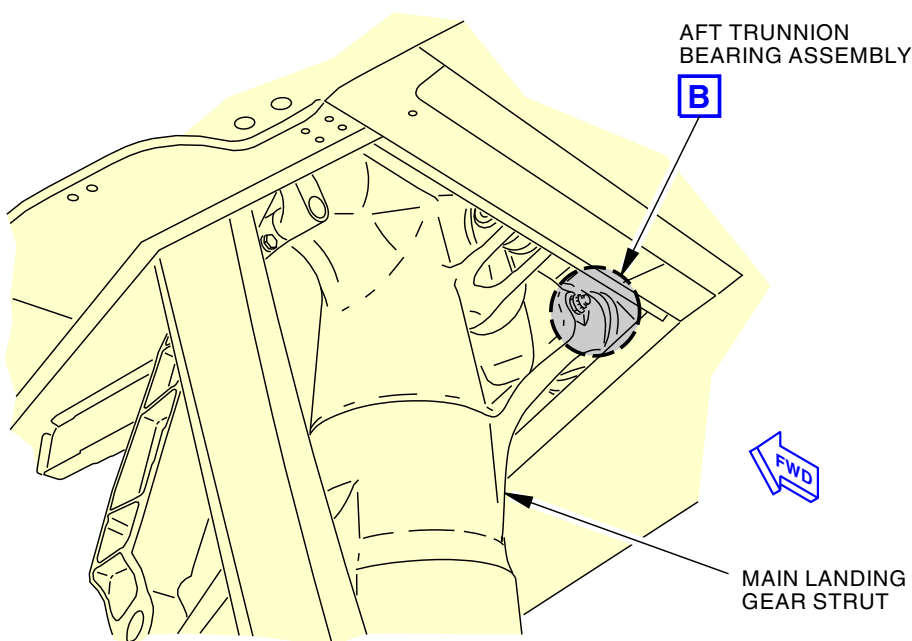
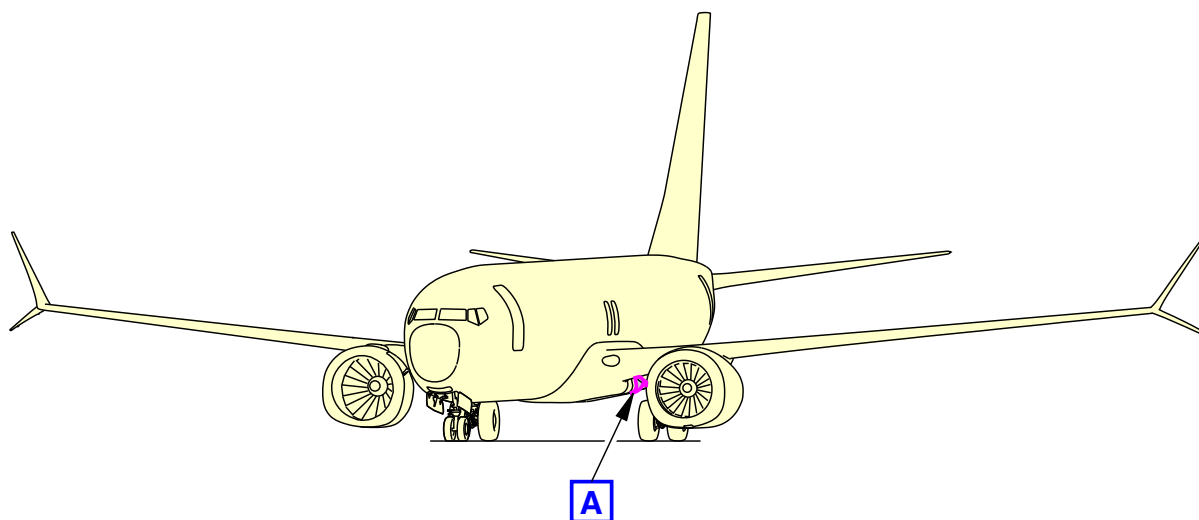
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LEFT MAIN LANDING GEAR
(RIGHT MAIN LANDING GEAR IS EQUIVALENT)

A

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MLG Aft Trunnion Bearing Assembly Installation
Figure 401/57-16-02-990-801 (Sheet 1 of 2)

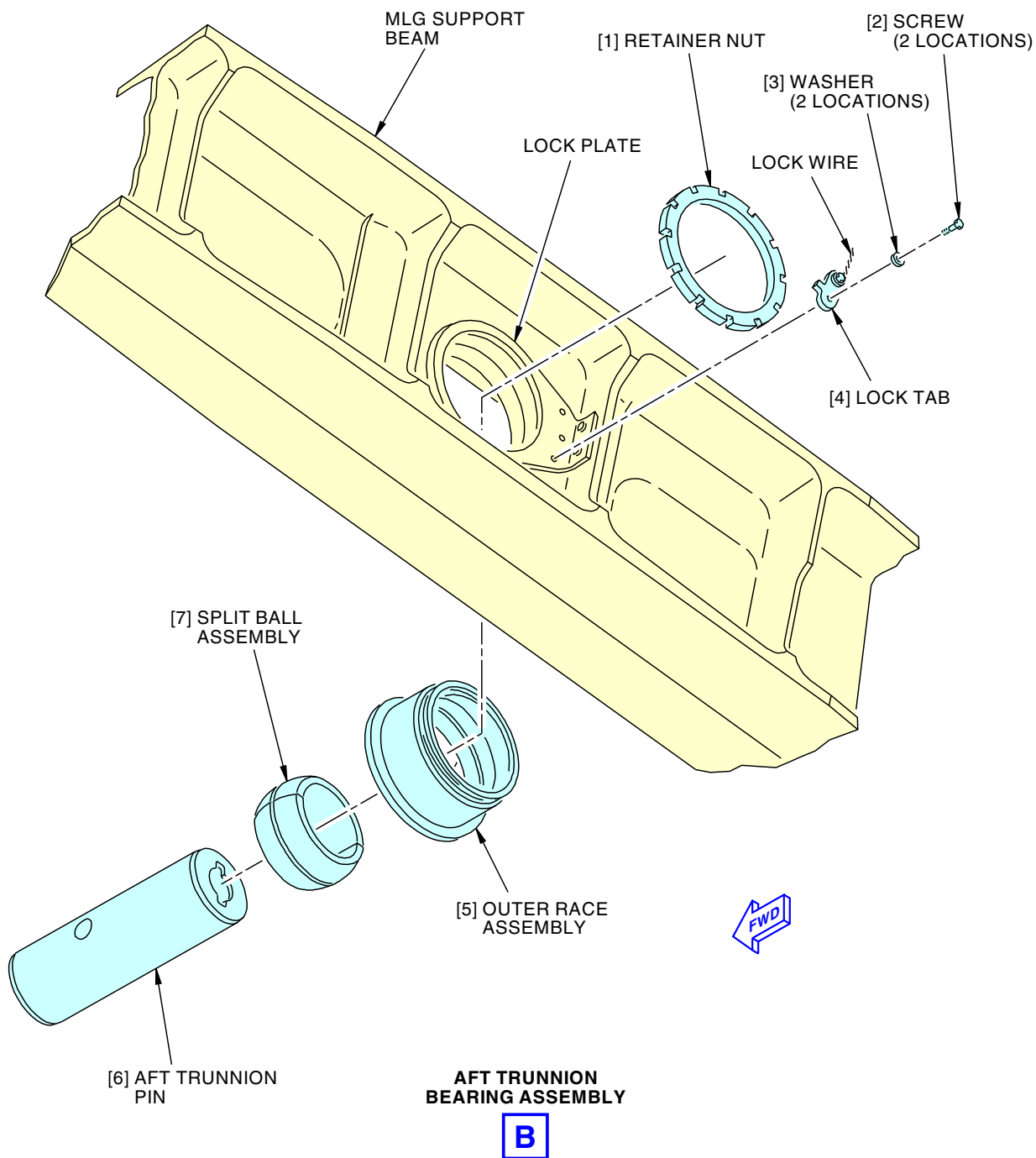
EFFECTIVITY
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2416609 S00061541130_V1

MLG Aft Trunnion Bearing Assembly Installation
Figure 401/57-16-02-990-801 (Sheet 2 of 2)

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TASK 57-16-02-400-801

3. **MLG Aft Trunnion Bearing Assembly Installation**

(Figure 401)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
32-00-01-480-801	Landing Gear Downlock Pins Installation (P/B 201)
32-11-00-400-802	Main Landing Gear Installation (P/B 401)

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt.", which stands for Optional.

Reference	Description
SPL-11076	Torque Wrench Adaptor Part #: C32013-16 Supplier: 81205 Opt Part #: C32013-9 Supplier: 81205

C. Consumable Materials

Reference	Description	Specification
D00633	Grease - Aircraft General Purpose	BMS3-33
G50347	Lockwire - MS20995NC32, Monel - 0.032 Inch (0.8128 mm) Diameter	NASM20995

D. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Retainer nut	57-16-02-01-065	SIA ALL
4	Lock tab	57-16-02-01-045	SIA ALL
5	Outer race assembly	57-16-02-01-085	SIA ALL
7	Split ball assembly	57-16-02-01-070	SIA ALL

E. Location Zones

Zone	Area
133	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Left
134	Main Landing Gear Wheel Well, Body Station 663.75 to Body Station 727.00 - Right
734	Left Main Landing Gear
744	Right Main Landing Gear

F. Procedure

SUBTASK 57-16-02-020-004

- (1) Install the split ball assembly [7] and outer race assembly [5].
 - (a) Apply a thin coat of grease, D00633 to all parts before you install them.

SUBTASK 57-16-02-020-005

- (2) Install the retainer nut [1].
 - (a) Tighten the retainer nut [1] to 10 ft-lb (14 N·m) to 15 ft-lb (20 N·m).
 - 1) Use the torque wrench adaptor, SPL-11076 to tighten the retainer nut [1].

SUBTASK 57-16-02-020-006

- (3) Install the lock tab [4] to the lock plate.

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- (a) If necessary, loosen the retainer nut [1] until the lock tab [4] can engage into the slot of the retainer nut [1].

NOTE: Do not loosen the retainer nut [1] very much.

- 1) To do this, these steps can help:
 - a) The lock tab [4] can be flipped.
 - b) The lock tab [4] can be moved to adjacent threaded holes in the lock plate.
- (b) Install the washers [3], screws [2], and lockwire.
 - 1) Tighten the screws [2] to 50 in-lb (6 N·m) to 80 in-lb (9 N·m).
 - 2) Install the MS20995NC32 lockwire, G50347 by the double-twist procedure.

SUBTASK 57-16-02-020-007

- (4) Lubricate the aft trunnion bearing assembly at the lubrication fitting.
- (a) Move the spherical bearing until it is in a position that lets grease to come into view at the inner diameter of the spherical bearing.

SUBTASK 57-16-02-020-008

- (5) Install the aft trunnion pin [6] into the aft trunnion bearing assembly.

G. Put the Airplane to Back to Its Usual Condition

SUBTASK 57-16-02-010-003

- (1) Do this task: Main Landing Gear Installation, TASK 32-11-00-400-802.

SUBTASK 57-16-02-480-002

 WARNING	MAKE SURE THAT THE DOWNLOCK PINS ARE INSTALLED ON ALL THE LANDING GEAR. WITHOUT THE DOWNLOCK PINS, THE LANDING GEAR CAN RETRACT. THIS CAN CAUSE INJURIES TO PERSONS, AND DAMAGE TO EQUIPMENT.

- (2) Make sure that the downlock pins are installed on the nose and main landing gear (TASK 32-00-01-480-801).

———— **END OF TASK** ————

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**MAIN LANDING GEAR REAR SPAR STABILIZER ATTACHMENT FITTING ASSEMBLY - REMOVAL/
INSTALLATION**

1. General

A. This procedure has these tasks:

- (1) Main Landing Gear Rear Spar Stabilizer Attachment Fitting Assembly Removal
- (2) Main Landing Gear Rear Spar Stabilizer Attachment Fitting Assembly Installation.

TASK 57-16-03-000-801

2. Main Landing Gear Rear Spar Stabilizer Attachment Fitting Assembly Removal

(Figure 401)

A. General

- (1) The main landing gear rear spar stabilizer attachment fitting assembly is referred to as the lower stabilizer fitting or upper stabilizer fitting in this task.

B. References

Reference	Title
20-10-51-000-801	Flareless Tubing Assembly Removal (P/B 401)
29-09-00-860-802	Hydraulic Reservoirs Depressurization (P/B 201)
57-16-06-000-801	Main Landing Gear Support Beam Removal (P/B 401)

C. Tools/Equipment

Reference	Description
STD-12854	Torque Wrench (1500 ft-lb), 1 inch Drive
STD-14686	Fittings - Hydraulic, Caps/Plugs (ref. AMM 20-10-XX)

D. Location Zones

Zone	Area
734	Left Main Landing Gear
744	Right Main Landing Gear

E. Access Panels

Number	Name/Location
551AT	Upper Inboard Fixed Trailing Edge Access Panel
551BT	Upper Inboard Fixed Trailing Edge, MLG Actuator Access Panel
551DB	Lower Inboard Fixed Trailing Edge, Lube Actuator & MLG Beam Outboard Attach Pin Access Panel
551DT	Upper Inboard Fixed Trailing Edge, MLG Beam Access Panel
551EB	Lower Inboard Fixed Trailing Edge, MLG Attach Fitting Access Panel
551ET	Upper Inboard Fixed Trailing Edge, MLG Beam Access Panel
551FB	Lower Inboard Fixed Trailing Edge, Landing Gear Access Panel
651AT	Upper Inboard Fixed Trailing Edge Access Panel
651BT	Upper Inboard Fixed Trailing Edge, MLG Actuator Access Panel
651DB	Lower Inboard Fixed Trailing Edge, Lube Actuator & MLG Beam Outboard Attach Pin Access Panel
651DT	Upper Inboard Fixed Trailing Edge, MLG Beam Access Panel
651EB	Lower Inboard Fixed Trailing Edge, MLG Attach Fitting Access Panel
651ET	Upper Inboard Fixed Trailing Edge, MLG Beam Access Panel

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(Continued)

Number	Name/Location

651FB	Lower Inboard Fixed Trailing Edge, Landing Gear Access Panel

F. Prepare for the Removal

SUBTASK 57-16-03-020-001

- (1) Remove the main landing gear rear spar stabilizer attachment fitting assembly from the airplane.
 - (a) Do this task: Main Landing Gear Support Beam Removal, TASK 57-16-06-000-801.

SUBTASK 57-16-03-010-001

- (2) For the left wing, remove these access panels:

<u>Number</u>	<u>Name/Location</u>
551AT	Upper Inboard Fixed Trailing Edge Access Panel
551BT	Upper Inboard Fixed Trailing Edge, MLG Actuator Access Panel
551DB	Lower Inboard Fixed Trailing Edge, Lube Actuator & MLG Beam Outboard Attach Pin Access Panel
551DT	Upper Inboard Fixed Trailing Edge, MLG Beam Access Panel
551EB	Lower Inboard Fixed Trailing Edge, MLG Attach Fitting Access Panel
551ET	Upper Inboard Fixed Trailing Edge, MLG Beam Access Panel
551FB	Lower Inboard Fixed Trailing Edge, Landing Gear Access Panel

SUBTASK 57-16-03-010-002

- (3) For the right wing, remove these access panels:

<u>Number</u>	<u>Name/Location</u>
651AT	Upper Inboard Fixed Trailing Edge Access Panel
651BT	Upper Inboard Fixed Trailing Edge, MLG Actuator Access Panel
651DB	Lower Inboard Fixed Trailing Edge, Lube Actuator & MLG Beam Outboard Attach Pin Access Panel
651DT	Upper Inboard Fixed Trailing Edge, MLG Beam Access Panel
651EB	Lower Inboard Fixed Trailing Edge, MLG Attach Fitting Access Panel
651ET	Upper Inboard Fixed Trailing Edge, MLG Beam Access Panel
651FB	Lower Inboard Fixed Trailing Edge, Landing Gear Access Panel

SUBTASK 57-16-03-040-001

- (4) Depressurize the hydraulic system (TASK 29-09-00-860-802).

SUBTASK 57-16-03-020-002



WARNING

REMOVE ALL PRESSURE FROM THE SYSTEM BEFORE YOU START THE REMOVAL OF THE FLARELESS TUBING ASSEMBLY. A PRESSURIZED SYSTEM CAN CAUSE INJURY TO PERSONNEL AND DAMAGE TO EQUIPMENT.

- (5) Disconnect the hydraulic and fire extinguisher lines from the assembly as necessary (TASK 20-10-51-000-801).
 - (a) Make a record of the locations of the hydraulic and fire extinguisher lines.
 - (b) Install caps/plugs, STD-14686, on the open hydraulic lines.

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SUBTASK 57-16-03-020-003

- (6) Disconnect the applicable wire bundle assemblies.
 - (a) Make a record of the locations of the wire bundles.

G. Upper Stabilizer Fitting Assembly Removal

SUBTASK 57-16-03-020-004

- (1) Remove the two protruding bolts [10] and collars [5] that attach the upper stabilizer fitting [1] and shim [6] to the rear spar.

SUBTASK 57-16-03-020-005

- (2) Remove the two protruding bolts [9] and collars [5] that attach the upper stabilizer fitting [1] and shim [6] to the rear spar.

SUBTASK 57-16-03-020-006

- (3) Remove the two bolts [4], plain washers [7], and self-locking nuts [8] that attach the upper stabilizer fitting [1] and laminated shim [3] to the wing skin.
 - (a) Use a torque wrench, STD-12854, or equivalent, to remove the self-locking nuts [8].

SUBTASK 57-16-03-020-007

- (4) Remove the upper stabilizer fitting [1], shim [6], and laminated shim [3] from the wing skin and rear spar.
 - (a) Make a record of the location of the shim [6] and laminated shim [3].

H. Lower Stabilizer Fitting Assembly Removal

SUBTASK 57-16-03-020-008

- (1) Remove the four protruding bolts [14] and collars [17] that attach the lower stabilizer fitting [2] and shim [13] to the rear spar.

SUBTASK 57-16-03-020-009

- (2) Remove the two bolts [15], plain washers [12], and self-locking nuts [11] that attach the lower stabilizer fitting [2] and laminated shim [16] to the wing skin.
 - (a) Use a torque wrench, STD-12854, or equivalent, to remove the self-locking nuts [11].

SUBTASK 57-16-03-020-010

- (3) Remove the lower stabilizer fitting [2], shim [13], and laminated shim [16] from the wing skin and rear spar.
 - (a) Make a record of the location of the shim [13] and laminated shim [16].

————— END OF TASK —————

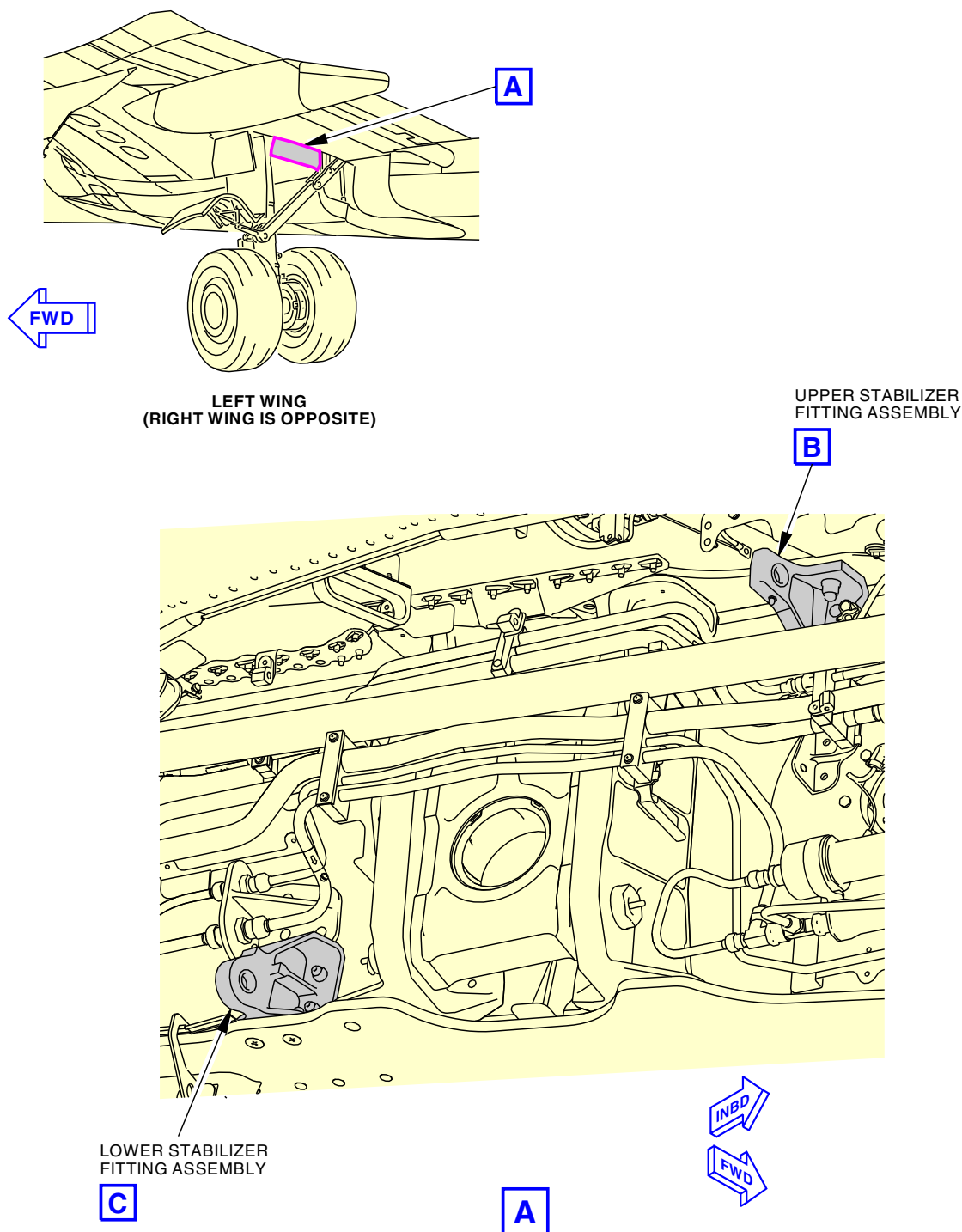
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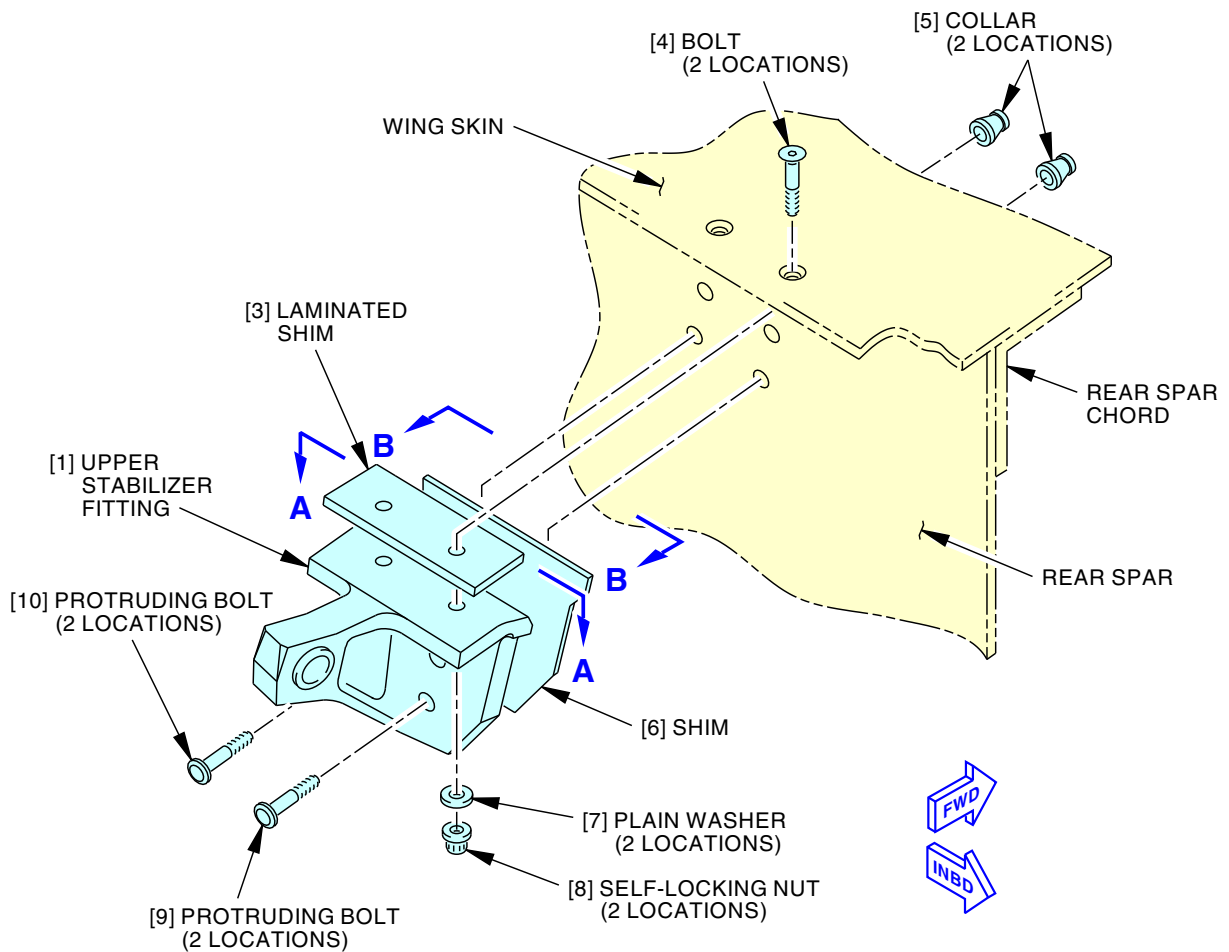
Main Landing Gear Rear Spar Stabilizer Attachment Fitting Assembly Installation
Figure 401/57-16-03-990-801 (Sheet 1 of 3)

EFFECTIVITY
SIA ALL

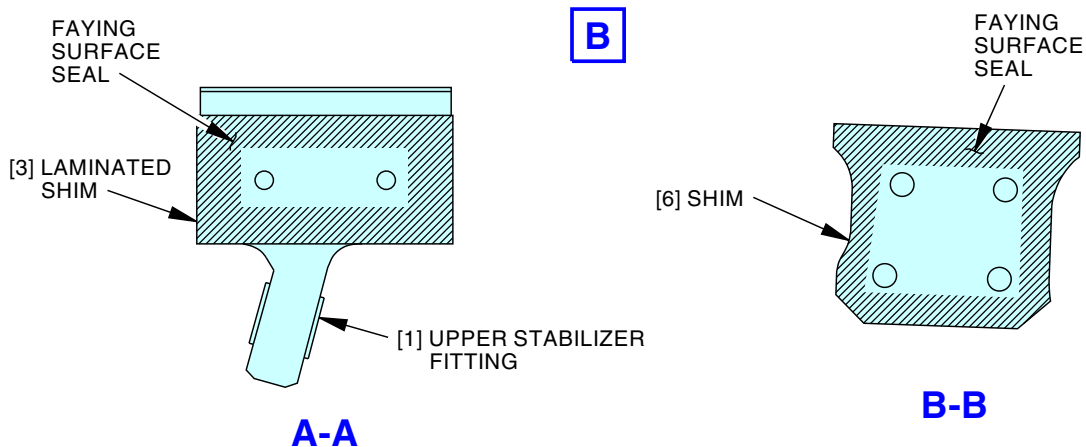
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UPPER STABILIZER FITTING ASSEMBLY



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Main Landing Gear Rear Spar Stabilizer Attachment Fitting Assembly Installation
Figure 401/57-16-03-990-801 (Sheet 2 of 3)

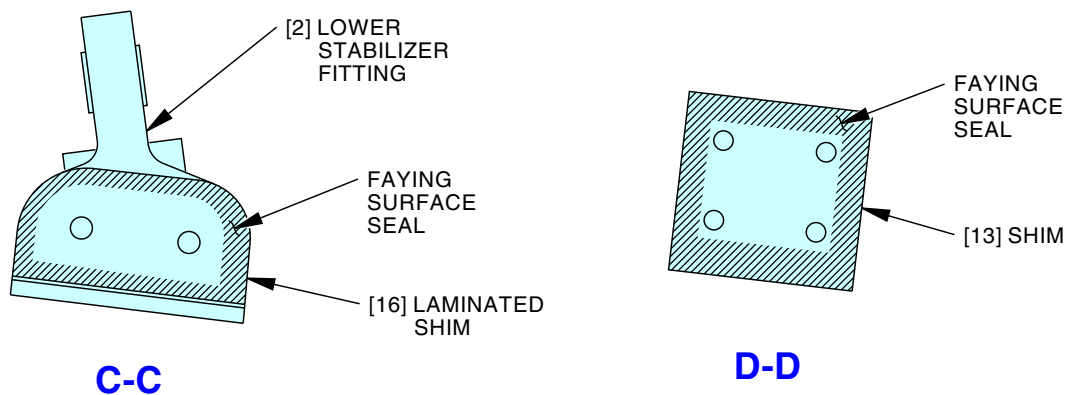
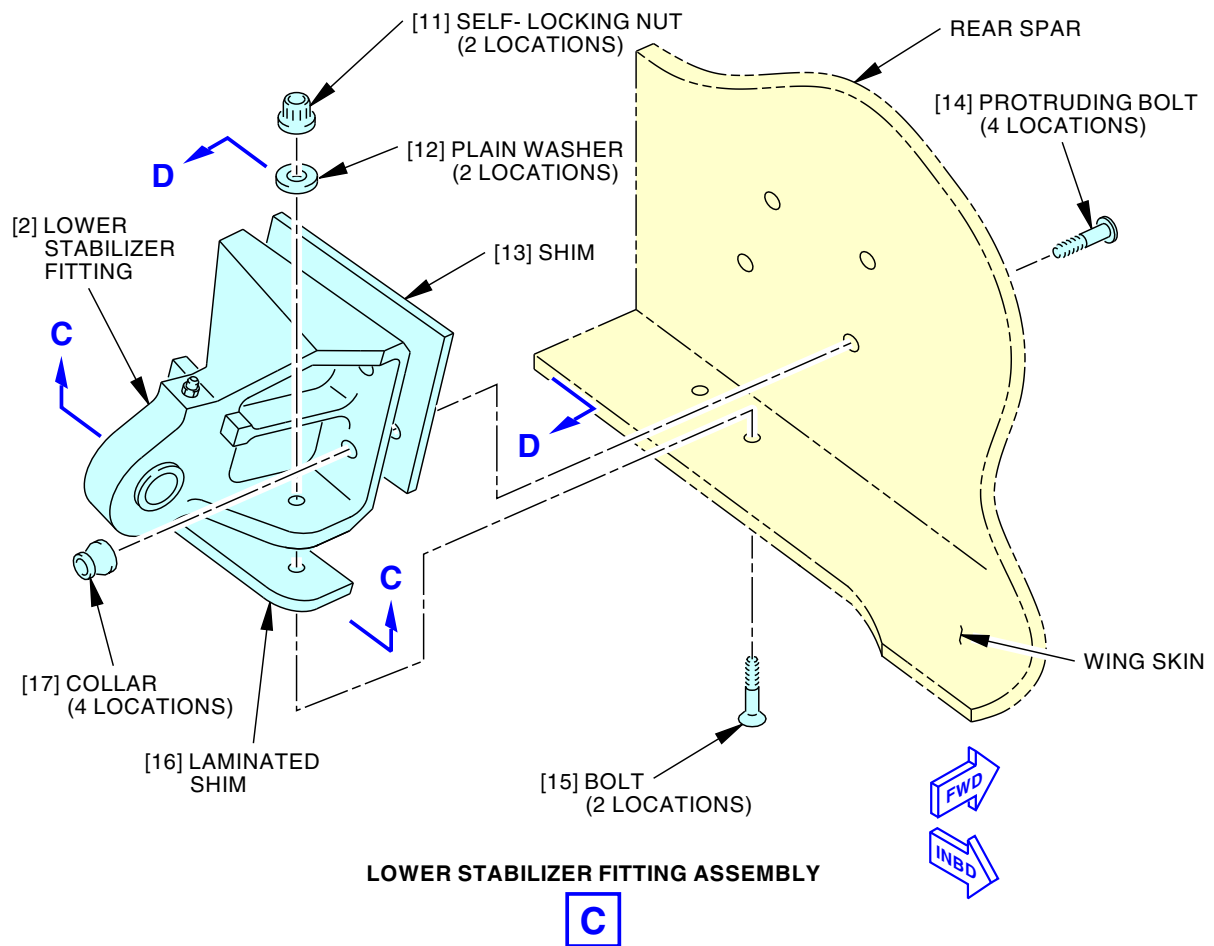
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Main Landing Gear Rear Spar Stabilizer Attachment Fitting Assembly Installation
Figure 401/57-16-03-990-801 (Sheet 3 of 3)

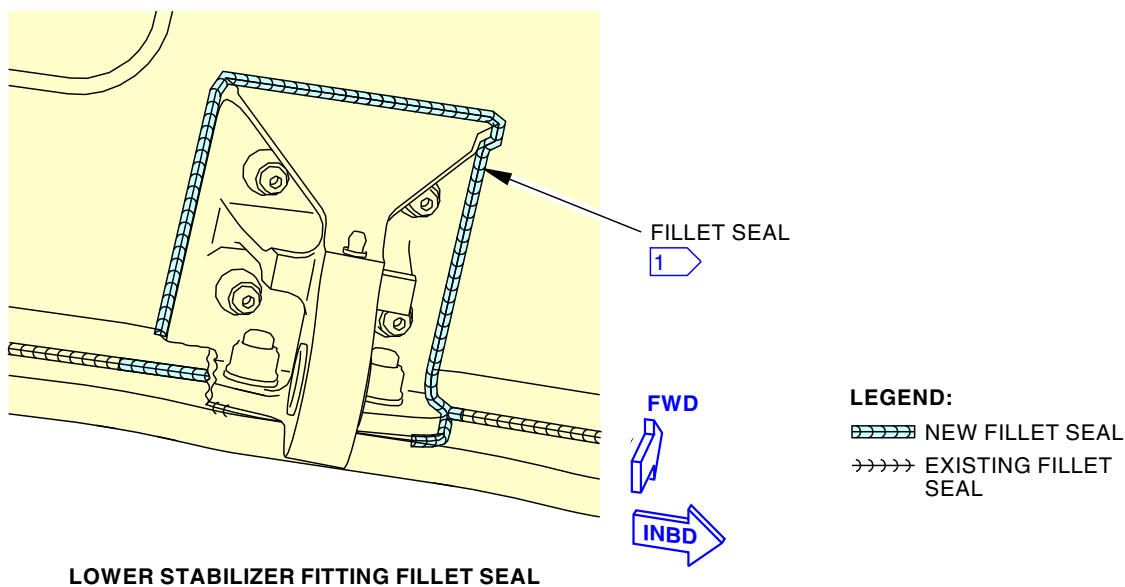
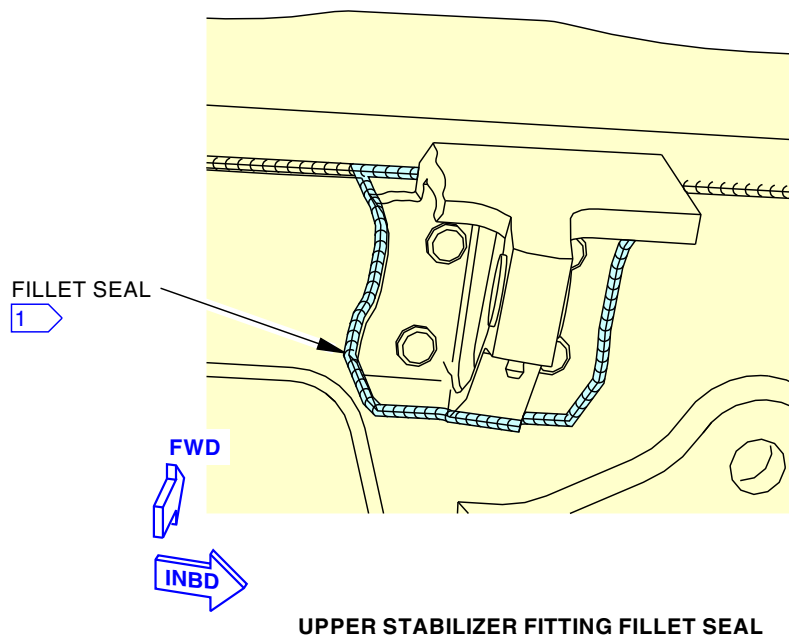
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1 APPLY A CONTINUOUS FILLET SEAL WITH BMS5-142 TYPE II.

2529592 S0000596345_V2

Main Landing Gear Rear Spar Stabilizer Attachment Fitting - Fillet Sealing Location
Figure 402/57-16-03-990-802

EFFECTIVITY
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TASK 57-16-03-400-801

3. Main Landing Gear Rear Spar Stabilizer Attachment Fitting Assembly Installation

(Figure 401)

A. General

- (1) The main landing gear rear spar stabilizer attachment fitting assembly is referred to as the lower stabilizer fitting or upper stabilizer fitting in this task.

B. References

Reference	Title
20-10-51-400-802	Flareless Fittings in Pressurized Areas Installation (P/B 401)
29-09-00-860-801	Hydraulic Reservoirs Pressurization (P/B 201)
51-21-72-370-804	BMS10-11 Primer - Application (P/B 701)
51-22-00-160-801	Prepare For Sealing (P/B 201)
57-16-06-400-801	Main Landing Gear Support Beam Installation (P/B 401)
SWPM 20-20-00	ELECTRICAL BONDING PROCESSES

C. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt.", which stands for Optional.

Reference	Description
COM-1550	Bonding Meter - Approved, Intrinsically Safe (Approved for use in Class I, Divisions I & II hazardous (classified) locations. Outside these hazardous locations, COM-614 can be used in lieu of COM-1550). Part #: 620LK Supplier: 1CRL2 Part #: M1 Supplier: 3AD17 Part #: M1B Supplier: 3AD17 Part #: T477W (C15292) Supplier: 06659
STD-124	Brush - Stiff Bristle, Non-Metallic
STD-12854	Torque Wrench (1500 ft-lb), 1 inch Drive
STD-14686	Fittings - Hydraulic, Caps/Plugs (ref. AMM 20-10-XX)

D. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
A02315	Sealant - Low Density, Synthetic Rubber. 2 Part	BMS5-142 Type II
A50153	Sealant - Fuel Tank - Class A-2	BMS5-45 Class A-2
A50231	Sealant - Pressure And Environmental - Chromate Type	BMS5-95 Class B
A50296	Sealant - Pressure And Environmental - Chromate Type	BMS5-95 Class C
A50337	Sealant - Fuel Tank	BMS5-45 Class B
B00062	Solvent - Acetone (99.5% Grade)	ASTM D 329 (Supersedes O-A-51)
B00184	Solvent - Presealing, Cleaning Solvent	BMS11-7

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Reference	Description	Specification
B00666	Solvent - Methyl Propyl Ketone	BMS11-9
B50226	Solvent - Citra-Safe	
B50269	Solvent - Bonderite C-SO 4460-BK AERO	BAC5681
B50289	Solvent - Corrosion Inhibiting Compound, Biogenic SE377C	BAC5877
C00064	Coating - Aluminum Chemical Conversion	BAC5719 Type II Class A (MIL-DTL-5541 Class 1A)
C00259	Coating - Chemical And Solvent Resistant Finish, Corrosion Inhibiting Primer	BMS10-11 Type I
C50315	Coating - Chemical Conversion - Bonderite M-CR 600 Aero (Formerly Alodine 600)	BAC5719 Class A, C or D, MIL-DTL-81706 Type I Class 1A or 3
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	AMS3819 Class 1 Grade A or B Form 1 (Supersede BMS15-5 CL A)
G50398	Pad - Adbrasive, Scotch-Brite Type S, Abrasive Pad	
G50492	Pad - 3M Scotch Brite 7448 Ultra Fine Pad	MIL-A-9962A Type III Grade AAA
G51293	Cotton Wiper - Knit, Process Cleaning Absorbent Wiper	BMS15-5 Class B

E. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Upper stabilizer fitting	57-16-03-01-060	SIA ALL
		57-16-03-01-065	SIA ALL
2	Lower stabilizer fitting	57-16-03-01-125	SIA ALL
		57-16-03-01-130	SIA ALL

F. Location Zones

Zone	Area
531	Left Wing - Center Fuel Tank, Rib 1 to Rib 5
551	Left Wing - Rear Spar To Landing Gear Support Beam
631	Right Wing - Center Fuel Tank, Rib 1 to Rib 5
651	Right Wing - Rear Spar to Landing Gear Support Beam

G. Access Panels

Number	Name/Location
551AT	Upper Inboard Fixed Trailing Edge Access Panel
551BT	Upper Inboard Fixed Trailing Edge, MLG Actuator Access Panel
551DB	Lower Inboard Fixed Trailing Edge, Lube Actuator & MLG Beam Outboard Attach Pin Access Panel
551DT	Upper Inboard Fixed Trailing Edge, MLG Beam Access Panel
551EB	Lower Inboard Fixed Trailing Edge, MLG Attach Fitting Access Panel
551ET	Upper Inboard Fixed Trailing Edge, MLG Beam Access Panel

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Number	Name/Location
551FB	Lower Inboard Fixed Trailing Edge, Landing Gear Access Panel
651AT	Upper Inboard Fixed Trailing Edge Access Panel
651BT	Upper Inboard Fixed Trailing Edge, MLG Actuator Access Panel
651DB	Lower Inboard Fixed Trailing Edge, Lube Actuator & MLG Beam Outboard Attach Pin Access Panel
651DT	Upper Inboard Fixed Trailing Edge, MLG Beam Access Panel
651EB	Lower Inboard Fixed Trailing Edge, MLG Attach Fitting Access Panel
651ET	Upper Inboard Fixed Trailing Edge, MLG Beam Access Panel
651FB	Lower Inboard Fixed Trailing Edge, Landing Gear Access Panel

H. Upper Stabilizer Fitting Assembly Installation

SUBTASK 57-16-03-100-001

- (1) Do these steps to prepare the upper stabilizer fitting [1], shim [6], laminated shim [3], wing skin, and rear spar for installation:
 - (a) Clean the surfaces of the laminated shim [3], top of the upper stabilizer fitting [1], rear spar, and wing skin that will be sealed (TASK 51-22-00-160-801).
 - (b) Clean the fay surfaces of the aluminum upper stabilizer fitting [1], aluminum shim [6], and aluminum rear spar (SWPM 20-20-00):
 - 1) Use Cleaning Procedure 1 to manually clean the fay surfaces of the upper stabilizer fitting [1], shim [6], and rear spar (dry side).
 - a) Use a Scotch-Brite Type S pad, G50398, or a Scotch-Brite 7448 pad, G50492.
 - b) Move the pad in a circular movement while you push with your thumb.
 - 2) Final clean the fay surfaces of the upper stabilizer fitting [1], shim [6], and rear spar (dry side).
 - a) Use a new cotton wiper, G00034, or knit cotton wiper, G51293, soaked with solvent, B00062 or solvent, B00184.
 - b) Rub dry with a clean dry cotton wiper.
 - c) Continue to clean and dry the surface until the cotton wiper shows clean.
 - 3) Use Cleaning Procedure 5 to clean the two bolts [4].
 - a) Use a new cotton wiper, G00034, soaked with citra-safe solvent, B50226, or Bonderite C-SO 4460-BK AERO, B50269.
 - b) Dry the area with a clean cotton wiper, G00034.
 - 4) Use Cleaning Procedure 1 to clean the rear spar fay surface (wet side).
 - a) Remove the old sealant with a stiff bristle non-metallic brush, STD-124, or cotton wiper, G00034, wet with citra-safe solvent, B50226, or solvent, B50289.
 - b) Clean the fay surface and the area around the fay surface to prevent contamination.
 - c) Rub dry with a clean dry cotton wiper.
 - 5) Final clean the rear spar fay surface (wet side).
 - a) Use a new cotton wiper, G00034, soaked with solvent, B00184, or solvent, B00666.
 - b) Rub dry with a clean dry cotton wiper.

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- c) Continue to clean and dry the surface until the cotton wiper shows clean.

SUBTASK 57-16-03-390-001

- (2) Apply a continuous layer of sealant, A00247, on each side of the laminated shim [3] (Figure 402) (SWPM 20-20-00, Paragraph 14.D).

SUBTASK 57-16-03-390-002

- (3) Apply a continuous layer of sealant, A50231, or sealant, A50296, on each side of the shim [6] (Figure 402) (SWPM 20-20-00, Paragraph 14.D).

SUBTASK 57-16-03-390-003

- (4) Apply a layer of sealant, A00247, on the under-head of the bolts [4].

SUBTASK 57-16-03-420-004

- (5) Install the assembly of the upper stabilizer fitting [1].
- (a) Install the two protruding bolts [9] and collars [5] to attach the upper stabilizer fitting [1] and shim [6] to the rear spar and rear spar chord.
 - (b) Install the two protruding bolts [10] and collars [5] to attach the upper stabilizer fitting [1] and shim [6] to the rear spar and rear spar chord.
 - (c) Install the two bolts [4], plain washers [7], and self-locking nuts [8] to attach the upper stabilizer fitting [1] and laminated shim [3] to the wing skin.

SUBTASK 57-16-03-420-005

- (6) Use a torque wrench, STD-12854, or equivalent, and tighten the self-locking nuts [8] to a tool setpoint of 1070 in-lb (121 N·m).
- (a) Wait 10 minutes.
 - (b) Tighten the self-locking nuts [8] to a tool setpoint of 1070 in-lb (121 N·m) before the squeeze-out life of the sealant expires.
 - (c) Remove the sealant squeeze-out from around the head of the bolts [4] on the wing skin with a clean cotton wiper, G00034.

NOTE: To prevent the removal of sealant below the bolts [4], do not clean too hard.

SUBTASK 57-16-03-420-006



KEEP THE CLEARANCE IN THE LIMITS. IF THE CLEARANCE IS NOT IN THE LIMITS, DAMAGE TO THE AIRPLANE WILL OCCUR.

- (7) Make sure that the gap between the aft face of the upper stabilizer fitting [1] and the rear spar is 0.005 in. (0.127 mm) or less before clamp-up.
- (a) If the gap is more than 0.005 in. (0.127 mm):
 - 1) Disassemble the assembly.
 - 2) Look for unwanted material between the mated parts.
 - 3) Install the assembly and do a check of the gap.

SUBTASK 57-16-03-760-001

- (8) Measure the electrical bonding resistance between the upper stabilizer fitting [1] and the rear spar with an intrinsically safe approved bonding meter, COM-1550 (SWPM 20-20-00).
- (a) Make sure that the electrical bonding resistance is 0.00100 ohm (1.00 milliohm) or less.

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SUBTASK 57-16-03-390-004

- (9) Apply a continuous fillet seal of sealant, A02315, around the perimeter of the upper stabilizer fitting [1].
- (a) Apply the sealant between the rear spar and upper stabilizer fitting [1].

SUBTASK 57-16-03-390-005

- (10) Manually apply primer, C00259, to the abraded surfaces on the rear spar (dry side) (TASK 51-21-72-370-804).

SUBTASK 57-16-03-390-006



DO NOT GET ALODINE IN YOUR MOUTH, EYES, OR ON YOUR SKIN. DO NOT BREATHE THE FUMES FROM ALODINE. PUT ON GOGGLES AND GLOVES WHEN YOU USE ALODINE. KEEP ALODINE AWAY FROM SPARKS, FLAME, AND HEAT. ALODINE IS POISONOUS AND FLAMMABLE, AND CAN CAUSE INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT.

- (11) Manually apply coating, C00064, or Bonderite M-CR 600 Aero coating, C50315, to the abraded surfaces on the rear spar (dry side).

SUBTASK 57-16-03-390-007

- (12) Apply a brushcoat of sealant, A50153, to the collars [5] and the rear spar chord (wet side).

SUBTASK 57-16-03-390-008

- (13) Apply sealant, A50337, to the collars [5], protruding bolts [9], and protruding bolts [10].

I. Lower Stabilizer Fitting Assembly Installation

SUBTASK 57-16-03-100-002

- (1) Do these steps to prepare the lower stabilizer fitting [2], shim [13], laminated shim [16], and rear spar for installation:
- (a) Clean the surfaces of the laminated shim [16], bottom of the lower stabilizer fitting [2], and wing skin that will be sealed (TASK 51-22-00-160-801).
- (b) Clean the fay surfaces of the aluminum lower stabilizer fitting [2], aluminum shim [13], and aluminum rear spar (SWPM 20-20-00):
- 1) Use Cleaning Procedure 1 to manually clean the fay surfaces of the lower stabilizer fitting [2], shim [13], and rear spar (dry side).
 - a) Use a Scotch-Brite Type S pad, G50398, or a Scotch-Brite 7448 pad, G50492.
 - b) Move the pad in a circular movement while you push with your thumb.
 - 2) Final clean the fay surfaces of the lower stabilizer fitting [2], shim [13], and rear spar (dry side).
 - a) Use a new cotton wiper, G00034, or knit cotton wiper, G51293, soaked with solvent, B00062 or solvent, B00184.
 - b) Rub dry with a clean dry cotton wiper.
 - c) Continue to clean and dry the surface until the cotton wiper shows clean.
 - 3) Use Cleaning Procedure 1 to clean the rear spar fay surface (wet side).
 - a) Remove the old sealant with a stiff bristle non-metallic brush, STD-124, or cotton wiper, G00034, wet with citra-safe solvent, B50226, or solvent, B50289.
 - b) Clean the fay surface and the area around the fay surface to prevent contamination.
 - c) Rub dry with a clean dry cotton wiper.

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- 4) Final clean the rear spar fay surface (wet side).
 - a) Use a new cotton wiper, G00034, soaked with solvent, B00184, or solvent, B00666.
 - b) Rub dry with a clean dry cotton wiper.
 - c) Continue to clean and dry the surface until the cotton wiper shows clean.

SUBTASK 57-16-03-390-009

- (2) Apply a continuous layer of sealant, A00247, on each side of the laminated shim [16] (Figure 402) (SWPM 20-20-00, Paragraph 14.D).

SUBTASK 57-16-03-390-010

- (3) Apply a continuous layer of sealant, A50231, or sealant, A50296, on each side of the shim [13] (Figure 402) (SWPM 20-20-00, Paragraph 14.D).

SUBTASK 57-16-03-390-011

- (4) Apply a layer of sealant, A00247, on the under-head of the bolts [4].

SUBTASK 57-16-03-420-007

- (5) Install the assembly of the lower stabilizer fitting [2].
 - (a) Install the four protruding bolts [14] and collars [17] to attach the lower stabilizer fitting [2] and shim [13] to the rear spar.
 - (b) Install the two bolts [15], plain washers [12], and self-locking nuts [11] to attach the lower stabilizer fitting [2] and laminated shim [16] to the wing skin.

SUBTASK 57-16-03-420-008

- (6) Use a torque wrench, STD-12854, or equivalent, and tighten the self-locking nuts [11] to tool setpoint of 690 in-lb (78.0 N·m).
 - (a) Wait 10 minutes
 - (b) Tighten the self-locking nuts [11] to tool setpoint of 690 in-lb (78 N·m) before the squeeze-out life of the sealant expires.
 - (c) Remove the sealant squeeze-out from around the head of the bolts [15] on the wing skin with a clean cotton wiper, G00034.

NOTE: To prevent the removal of sealant below the bolts [15], do not clean too hard.

SUBTASK 57-16-03-400-002



KEEP THE CLEARANCE IN THE LIMITS. IF THE CLEARANCE IS NOT IN THE LIMITS, DAMAGE TO THE AIRPLANE WILL OCCUR.

- (7) Make sure the gap between the aft face of the lower stabilizer fitting [2] and the rear spar is 0.0050 in. (0.1270 mm) or less before clamp-up.
 - (a) If the gap is more than 0.005 in. (0.127 mm):
 - 1) Disassemble the assembly.
 - 2) Look for unwanted material between the mated parts.
 - 3) Install the assembly and check the gap.

SUBTASK 57-16-03-420-009

- (8) Measure the electrical bonding resistance between the lower stabilizer fitting [2] and the rear spar with an intrinsically safe approved bonding meter, COM-1550 (SWPM 20-20-00).
 - (a) Make sure that the electrical bonding resistance is 0.00100 ohm (1.00 milliohm) or less.

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SUBTASK 57-16-03-860-001

- (9) Apply a continuous fillet seal of sealant, A02315, around the perimeter of the lower stabilizer fitting [2].
 - (a) Apply the sealant between the rear spar and lower stabilizer fitting [2].

SUBTASK 57-16-03-390-012

- (10) Manually apply primer, C00259, to the abraded surfaces on the rear spar (dry side) (TASK 51-21-72-370-804).

SUBTASK 57-16-03-390-013



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- (11) Manually apply coating, C00064, or Bonderite M-CR 600 Aero coating, C50315, to the abraded surfaces on the rear spar (dry side).

SUBTASK 57-16-03-390-014

- (12) Apply a brushcoat of sealant, A50153, to the collars [17] and the rear spar (dry side).

SUBTASK 57-16-03-390-015

- (13) Apply sealant, A50337, to the collars [17], protruding bolts [14], and lower stabilizer fitting [2].

J. Put the Airplane Back to Its Usual Condition

SUBTASK 57-16-03-420-001

- (1) Attach all of the electrical wires to the assembly.

SUBTASK 57-16-03-420-002

- (2) Attach all hydraulic and fire extinguisher lines to the assembly.
 - (a) Remove the caps/plugs, STD-14686, from the ends of the hydraulic tubes.
 - (b) Connect the hydraulic and fire extinguisher lines to the assembly (TASK 20-10-51-400-802).

SUBTASK 57-16-03-420-003

- (3) Install the main landing gear support beam (TASK 57-16-06-400-801).

SUBTASK 57-16-03-440-001

- (4) Pressurize the hydraulic systems (TASK 29-09-00-860-801).

SUBTASK 57-16-03-410-001

- (5) For the left wing, install these access panels:

<u>Number</u>	<u>Name/Location</u>
551AT	Upper Inboard Fixed Trailing Edge Access Panel
551BT	Upper Inboard Fixed Trailing Edge, MLG Actuator Access Panel
551DB	Lower Inboard Fixed Trailing Edge, Lube Actuator & MLG Beam Outboard Attach Pin Access Panel
551DT	Upper Inboard Fixed Trailing Edge, MLG Beam Access Panel
551EB	Lower Inboard Fixed Trailing Edge, MLG Attach Fitting Access Panel
551ET	Upper Inboard Fixed Trailing Edge, MLG Beam Access Panel
551FB	Lower Inboard Fixed Trailing Edge, Landing Gear Access Panel

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SUBTASK 57-16-03-410-002

(6) For the right wing, install these access panels:

<u>Number</u>	<u>Name/Location</u>
651AT	Upper Inboard Fixed Trailing Edge Access Panel
651BT	Upper Inboard Fixed Trailing Edge, MLG Actuator Access Panel
651DB	Lower Inboard Fixed Trailing Edge, Lube Actuator & MLG Beam Outboard Attach Pin Access Panel
651DT	Upper Inboard Fixed Trailing Edge, MLG Beam Access Panel
651EB	Lower Inboard Fixed Trailing Edge, MLG Attach Fitting Access Panel
651ET	Upper Inboard Fixed Trailing Edge, MLG Beam Access Panel
651FB	Lower Inboard Fixed Trailing Edge, Landing Gear Access Panel

———— **END OF TASK** ————

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MAIN LANDING GEAR IDLER LINK SUPPORT FITTING ASSEMBLY - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

- (1) Idler Link Support Fitting Assembly Removal
- (2) Idler Link Support Fitting Assembly Installation.

TASK 57-16-05-000-801

2. Idler Link Support Fitting Assembly Removal

(Figure 401)

A. General

- (1) This task includes the steps to remove the idler link support fitting assembly.

B. References

Reference	Title
29-11-00-860-805	Hydraulic System A or B Power Removal (P/B 201)
32-32-93-000-801	Main Gear Beam Hanger Pin Removal (P/B 401)

C. Location Zones

Zone	Area
730	Subzone - Left Main Landing Gear and Landing Gear Doors
740	Subzone - Right Main Landing Gear and Landing Gear Doors

D. Access Panels

Number	Name/Location
551BT	Upper Inboard Fixed Trailing Edge, MLG Actuator Access Panel
551DB	Lower Inboard Fixed Trailing Edge, Lube Actuator & MLG Beam Outboard Attach Pin Access Panel
651BT	Upper Inboard Fixed Trailing Edge, MLG Actuator Access Panel
651DB	Lower Inboard Fixed Trailing Edge, Lube Actuator & MLG Beam Outboard Attach Pin Access Panel

E. Prepare for the Removal

SUBTASK 57-16-05-020-001

- (1) Remove the main gear beam hanger pin (TASK 32-32-93-000-801).

SUBTASK 57-16-05-040-001

- (2) Make sure that the hydraulic system is deactivated (TASK 29-11-00-860-805).

SUBTASK 57-16-05-010-001

- (3) Open the applicable access panels:

Number	Name/Location
551BT	Upper Inboard Fixed Trailing Edge, MLG Actuator Access Panel
551DB	Lower Inboard Fixed Trailing Edge, Lube Actuator & MLG Beam Outboard Attach Pin Access Panel
651BT	Upper Inboard Fixed Trailing Edge, MLG Actuator Access Panel
651DB	Lower Inboard Fixed Trailing Edge, Lube Actuator & MLG Beam Outboard Attach Pin Access Panel

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F. Idler Link Support Fitting Assembly Removal

SUBTASK 57-16-05-420-001

- (1) Remove the two self-locking nuts [3], washers [4], washers [1], and bolts [2] that attach the idler link support fitting [6] to the main landing gear (MLG) support beam outboard fitting assembly.

SUBTASK 57-16-05-420-002

- (2) Remove the two self-locking nuts [11], washers [10], washers [7], and bolts [8] that attach the idler link support fitting [6] to the MLG support beam outboard fitting assembly.

SUBTASK 57-16-05-420-003

- (3) Remove the idler link support fitting [6], two laminated shims [5], and two laminated shims [9] from the MLG support beam outboard fitting assembly.
 - (a) Make a record of the location of the installed shims.

———— **END OF TASK** ————

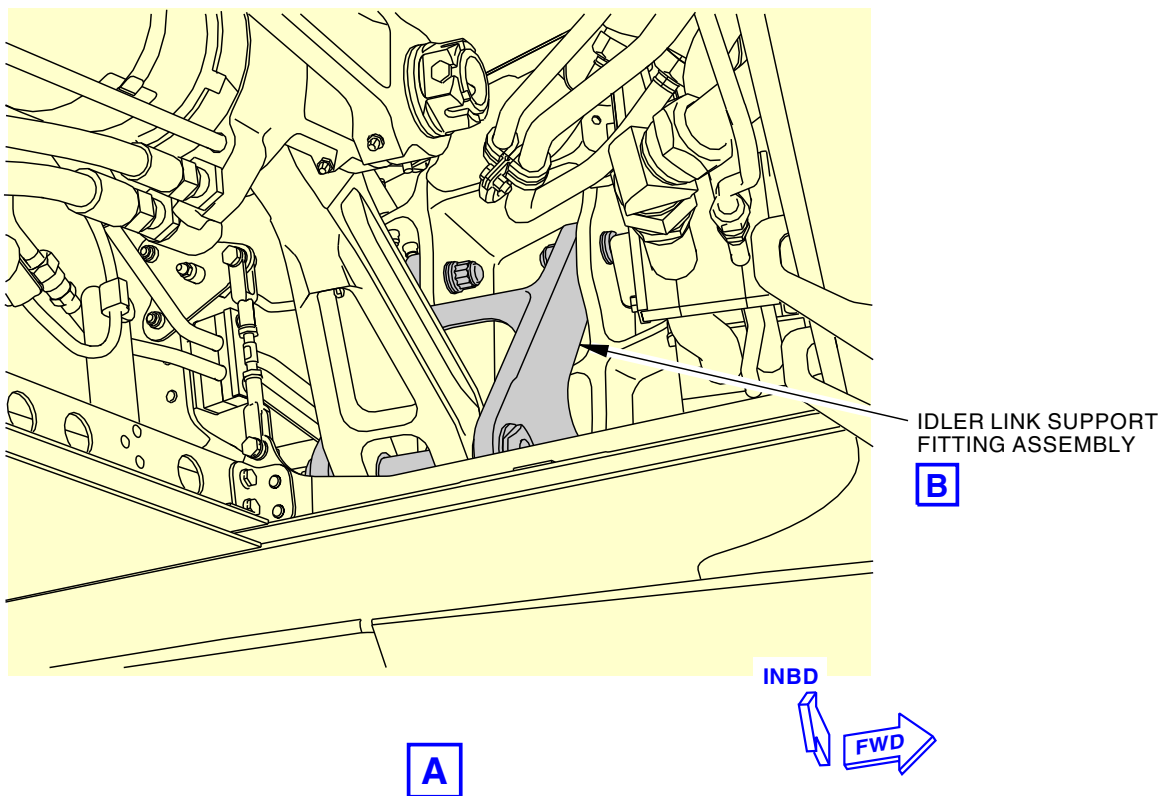
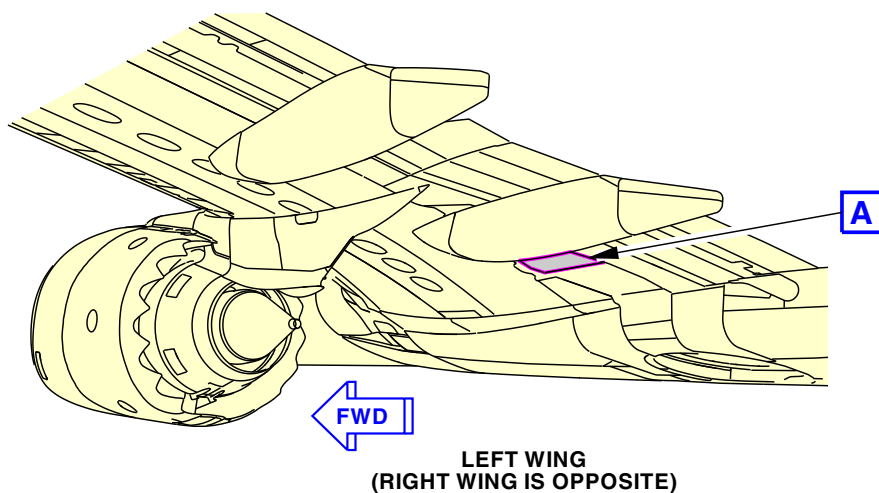
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Idler Link Support Fitting Assembly Installation
Figure 401/57-16-05-990-801 (Sheet 1 of 2)

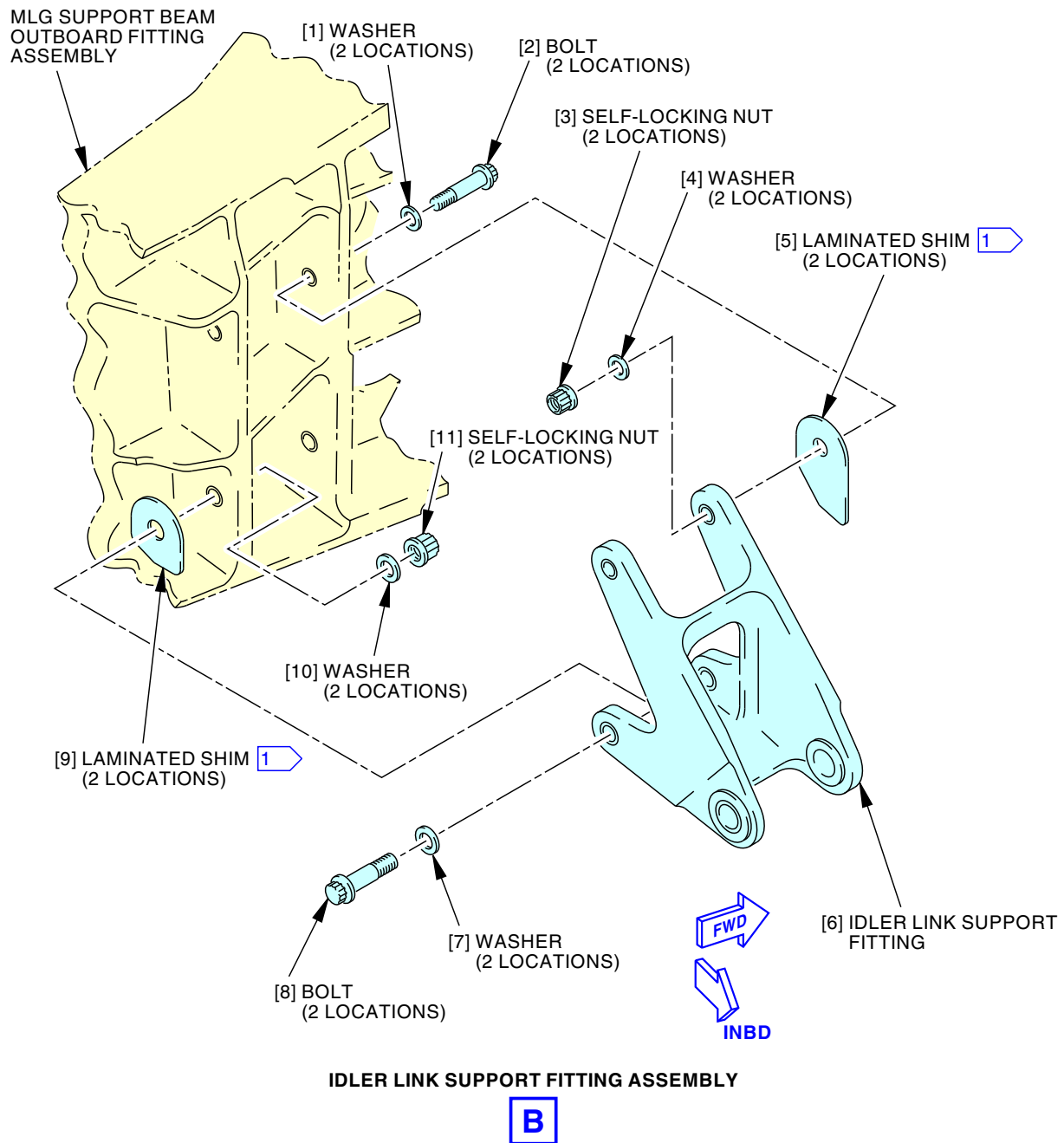
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1 AS REQUIRED

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Idler Link Support Fitting Assembly Installation
Figure 401/57-16-05-990-801 (Sheet 2 of 2)

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TASK 57-16-05-400-801

3. Idler Link Support Fitting Assembly Installation

(Figure 401)

A. General

- (1) This task includes the steps to install the idler link support fitting assembly.
- (2) Shims are only necessary when the gap is more than 0.005 in. (0.127 mm) between the idler link support fitting and MLG support beam outboard fitting assembly.

B. References

Reference	Title
12-40-00-100-801	Clean (Wet Wash) the External Surfaces of the Airplane (P/B 201)
12-40-00-100-802	Clean (Waterless Wash) the External Surfaces of the Airplane (P/B 201)
32-32-93-400-801	Main Gear Beam Hanger Pin Installation (P/B 401)

C. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
B00184	Solvent - Presealing, Cleaning Solvent	BMS11-7
B50226	Solvent - Citra-Safe	
B50269	Solvent - Bonderite C-SO 4460-BK AERO	BAC5681
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	AMS3819 Class 1 Grade A or B Form 1 (Supersede BMS15-5 CLA)

D. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
6	Idler link support fitting	57-16-05-01-040	SIA ALL

E. Location Zones

Zone	Area
730	Subzone - Left Main Landing Gear and Landing Gear Doors
740	Subzone - Right Main Landing Gear and Landing Gear Doors

F. Access Panels

Number	Name/Location
551BT	Upper Inboard Fixed Trailing Edge, MLG Actuator Access Panel
551DB	Lower Inboard Fixed Trailing Edge, Lube Actuator & MLG Beam Outboard Attach Pin Access Panel
651BT	Upper Inboard Fixed Trailing Edge, MLG Actuator Access Panel
651DB	Lower Inboard Fixed Trailing Edge, Lube Actuator & MLG Beam Outboard Attach Pin Access Panel

G. Prepare for the Installation

SUBTASK 57-16-05-160-001

- (1) Clean all the parts before installation (TASK 12-40-00-100-801 or TASK 12-40-00-100-802).

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SUBTASK 57-16-05-220-001

- (2) Measure the gap between the idler link support fitting [6] and MLG support beam outboard fitting assembly:
 - (a) Align the idler link support fitting [6] with the MLG support beam outboard fitting assembly.
 - (b) Loosely install the bolts [2] and self-locking nuts [3].
 - (c) Loosely install the bolts [8] and self-locking nuts [11].
 - (d) Measure the gap between the idler link support fitting [6] and MLG support beam outboard fitting assembly.
 - (e) Make sure that the gap is 0.005 in. (0.13 mm) maximum.
 - (f) If shims are necessary at all four bolt locations, the maximum shim thickness is 0.015 in. (0.38 mm).
 - (g) Install laminated shims [5] or laminated shims [9] if it is necessary.
 - (h) Make a record of all shim locations.

SUBTASK 57-16-05-020-002

- (3) Remove the idler link support fitting [6], two bolts [2], bolts [8], laminated shims [5], and laminated shims [9]

SUBTASK 57-16-05-100-001

- (4) Do these steps to prepare the fasteners, laminated shims [5], laminated shims [9], idler link support fitting [6], and MLG support beam for installation.
 - (a) Clean the bolts [8], bolts [2], washers [7], washers [1], self-locking nuts [3], self-locking nuts [11], surfaces of the aluminum laminated shims [5], laminated shims [9], idler link support fitting [6] and the MLG support beam outboard fitting assembly.

NOTE: Clean the surface far enough beyond the area to be sealed to prevent contamination.

 - 1) Use a new cotton wiper, G00034, made wet with citra-safe solvent, B50226, Bonderite C-SO 4460-BK AERO, B50269, or solvent, B00184.
 - 2) Use a new cotton wiper, G00034, to dry the surfaces.
 - 3) Continue to clean and dry the surface until the cotton wiper, G00034, shows clean.

H. Idler Link Support Fitting Assembly Installation

SUBTASK 57-16-05-390-001

- (1) Apply sealant, A00247, on each side of the laminated shims [5] and laminated shims [9].

SUBTASK 57-16-05-390-002

- (2) Apply sealant, A00247, on the under-side of the head on the bolts [8] and bolts [2].

SUBTASK 57-16-05-820-001

- (3) Align the idler link support fitting [6] and the recorded laminated shims [5] or laminated shims [9] to the MLG support beam outboard fitting assembly.

SUBTASK 57-16-05-420-004

- (4) Install the two self-locking nuts [3], washers [4], laminated shims [5] (if it is necessary), washers [1], and bolts [2] to attach the idler link support fitting [6] to the MLG support beam outboard fitting assembly.

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SUBTASK 57-16-05-420-005

- (5) Install the two self-locking nuts [11], washers [10], laminated shims [9] (if it is necessary), washers [7], and bolts [8] to connect the idler link support fitting [6] to the MLG support beam outboard fitting assembly.

SUBTASK 57-16-05-420-006

- (6) Tighten the two self-locking nuts [3] to 1070 $\pm$ 32 in-lb (121 $\pm$ 4 N·m).

SUBTASK 57-16-05-420-007

- (7) Tighten the two self-locking nuts [11] to 1470 $\pm$ 44 in-lb (166 $\pm$ 5 N·m).

SUBTASK 57-16-05-820-002

- (8) Wait 10 minutes.

SUBTASK 57-16-05-420-009

- (9) Tighten the two self-locking nuts [11] to 1470 $\pm$ 44 in-lb (166 $\pm$ 5 N·m) before the squeeze-out life of the sealant expires.

SUBTASK 57-16-05-420-008

- (10) Tighten the two self-locking nuts [3] to 1070 $\pm$ 32 in-lb (121 $\pm$ 4 N·m) before the squeeze-out life of the sealant expires.

I. Put the Airplane Back to Its Usual Condition

SUBTASK 57-16-05-410-002

- (1) Install the main gear beam hanger pin (TASK 32-32-93-400-801).

SUBTASK 57-16-05-410-001

- (2) Close the applicable access panels:

<u>Number</u>	<u>Name/Location</u>
551BT	Upper Inboard Fixed Trailing Edge, MLG Actuator Access Panel
551DB	Lower Inboard Fixed Trailing Edge, Lube Actuator & MLG Beam Outboard Attach Pin Access Panel
651BT	Upper Inboard Fixed Trailing Edge, MLG Actuator Access Panel
651DB	Lower Inboard Fixed Trailing Edge, Lube Actuator & MLG Beam Outboard Attach Pin Access Panel

————— **END OF TASK** —————

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MAIN LANDING GEAR SUPPORT BEAM - MAINTENANCE PRACTICES

1. **General**

- A. Corrosion and stress corrosion cracks can occur on the Main Landing Gear (MLG) support beam.
- B. Corrosion can occur on the bolts that connect the landing gear beams to the flap track support fitting and hanger link.
- C. Stress corrosion cracks can occur in the forward and aft lugs of the hanger link.
- D. Corrosion frequently occurs in the trunnion fitting bearing hole.
- E. Stress corrosion cracking can occur in and around the inboard lug attach hole of the MLG support beam.
- F. Corrosion can occur on the stabilizer and its attach fitting at the landing gear beam.
- G. Corrosion can occur on the mating surfaces of the stabilizer link assembly of the support beam and on components of the stabilizer link.
- H. The wing wheel well is exposed to atmospheric pollutants and runway splash, and is susceptible to corrosion.
- I. The wing well should be treated for corrosion at the same time as the wing torque box, trunnion and trunnion support fittings

TASK 57-16-06-910-801

2. **Main Landing Gear Support Beam - Corrosion Prevention**

A. General

- (1) Make the regular inspection to prevent or find the start of corrosion. Missing fasteners, white powdery, or other corrosion deposits are signs of corrosion. Initiate the corrosion prevention practices to decrease the occurrence of corrosion.
- (2) Following cleaning of suspected areas (PAGEBLOCK 51-21-31/701), a full inspection is effective to ensure that protective finishes provided during manufacture remain intact.
- (3) Where corrosion exists (noticeable bulges of the skin or white deposits of corrosion products at fastener heads or joint edges), refer to Structural Repair Manual for details of corrosion removal.
- (4) For minor corrosion, to minimize the downtime of the airplane, the corrosion products should be cleaned off, followed by the application of a corrosion inhibiting compound into the affected area to decrease the corrosion process. Refer to PAGEBLOCK 51-21-91/701 for details on applying corrosion inhibiting compound. The finish system should be repaired at the next maintenance opportunity.

B. References

Reference	Title
51-21-31 P/B 701	CORROSION REMOVAL AND CONTROL - CLEANING/PAINTING
51-21-91 P/B 701	CORROSION INHIBITING COMPOUND - CLEANING/PAINTING

C. Consumable Materials

Reference	Description	Specification
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23

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D. Location Zones

Zone	Area
734	Left Main Landing Gear
744	Right Main Landing Gear

E. Procedure

SUBTASK 57-16-06-370-001

- (1) At the next maintenance opportunity, apply corrosion prevention treatment to the Main Landing Gear (MLG) trunnion support structure.

SUBTASK 57-16-06-200-001

- (2) Periodically inspect the MLG beam and the forward trunnion fitting attached to the rear spar for damaged finish and evidence of corrosion.

SUBTASK 57-16-06-370-002

- (3) Apply water displacing corrosion inhibiting compound to landing gear beams.

SUBTASK 57-16-06-910-001

- (4) Remove runway debris and clean the entire wheel well area.

SUBTASK 57-16-06-370-003

- (5) Apply corrosion inhibiting compound, G00009 to all exposed wheel well structure. Pay particular attention to applying the corrosion inhibitor along doubler edges, along edges of structure, forgings, etc., and on fastener heads. Use spray equipment with nozzle directed into faying surfaces.

SUBTASK 57-16-06-370-004

- (6) Apply corrosion inhibiting compound, G00009 to landing gear attachment fittings. Make sure to apply the compound to lugs and lug faces.

SUBTASK 57-16-06-370-005

- (7) Regrease all grease fittings in the treatment area.

SUBTASK 57-16-06-370-006

- (8) After cleaning the wheel well with steam or high pressure water and detergent, apply corrosion inhibiting compound, G00009.

SUBTASK 57-16-06-200-002

- (9) Periodically inspect heavily loaded structural members and wheel well closure walls for deterioration of protective finishes.

SUBTASK 57-16-06-370-007

- (10) Frequency of Application
 - (a) Periodic inspection is required in areas identified as susceptible to corrosion and should be consistent to the schedules specified in the Maintenance Planning Document. Operators must be aware of reported problems and areas of occurrences.
 - (b) Periodic application of corrosion inhibiting compound, G00009 is necessary to areas identified and should be consistent to the schedule specified in the Maintenance Planning Document.

———— **END OF TASK** ————

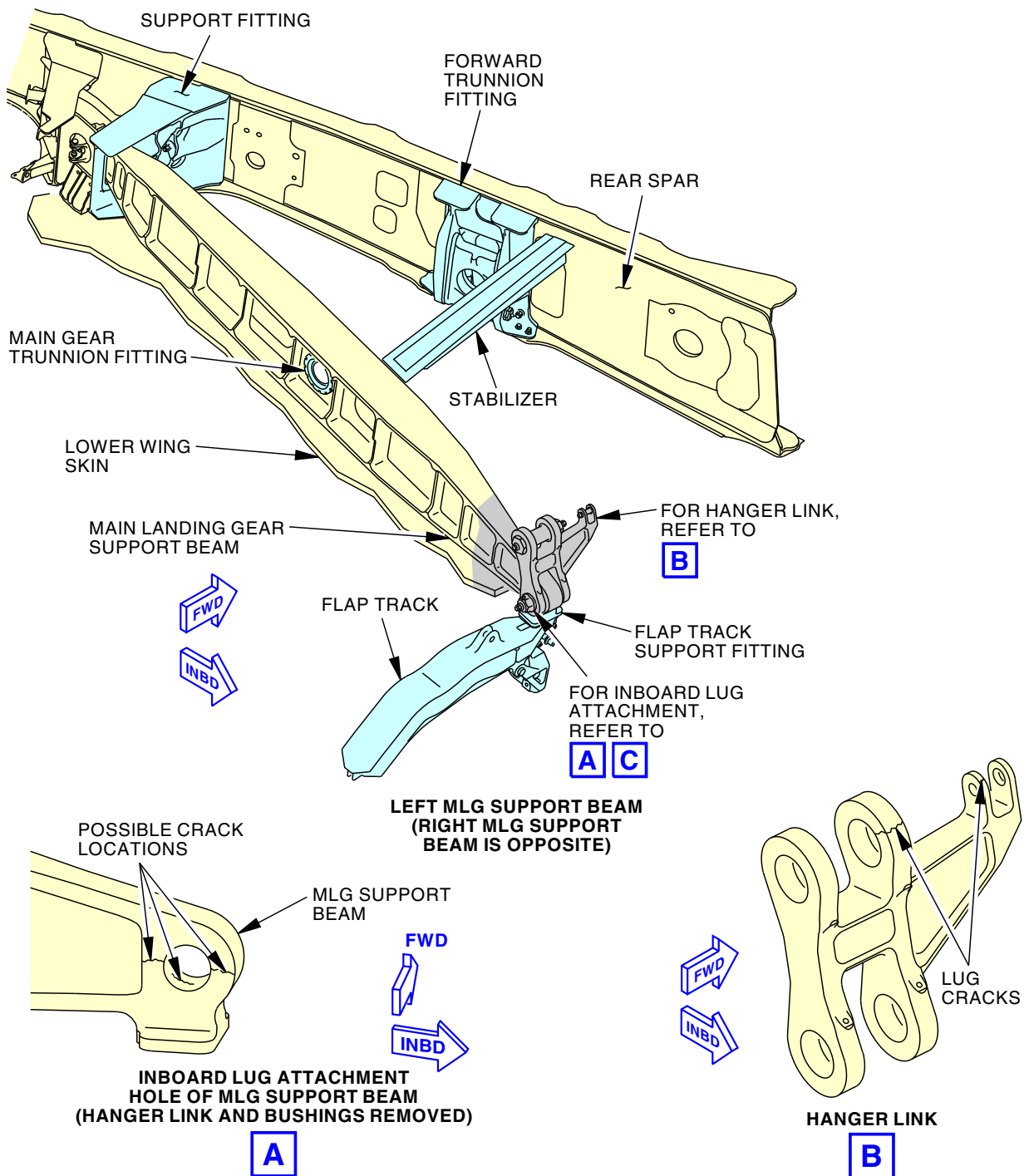
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Main Landing Gear Support Beam - Corrosion Prevention
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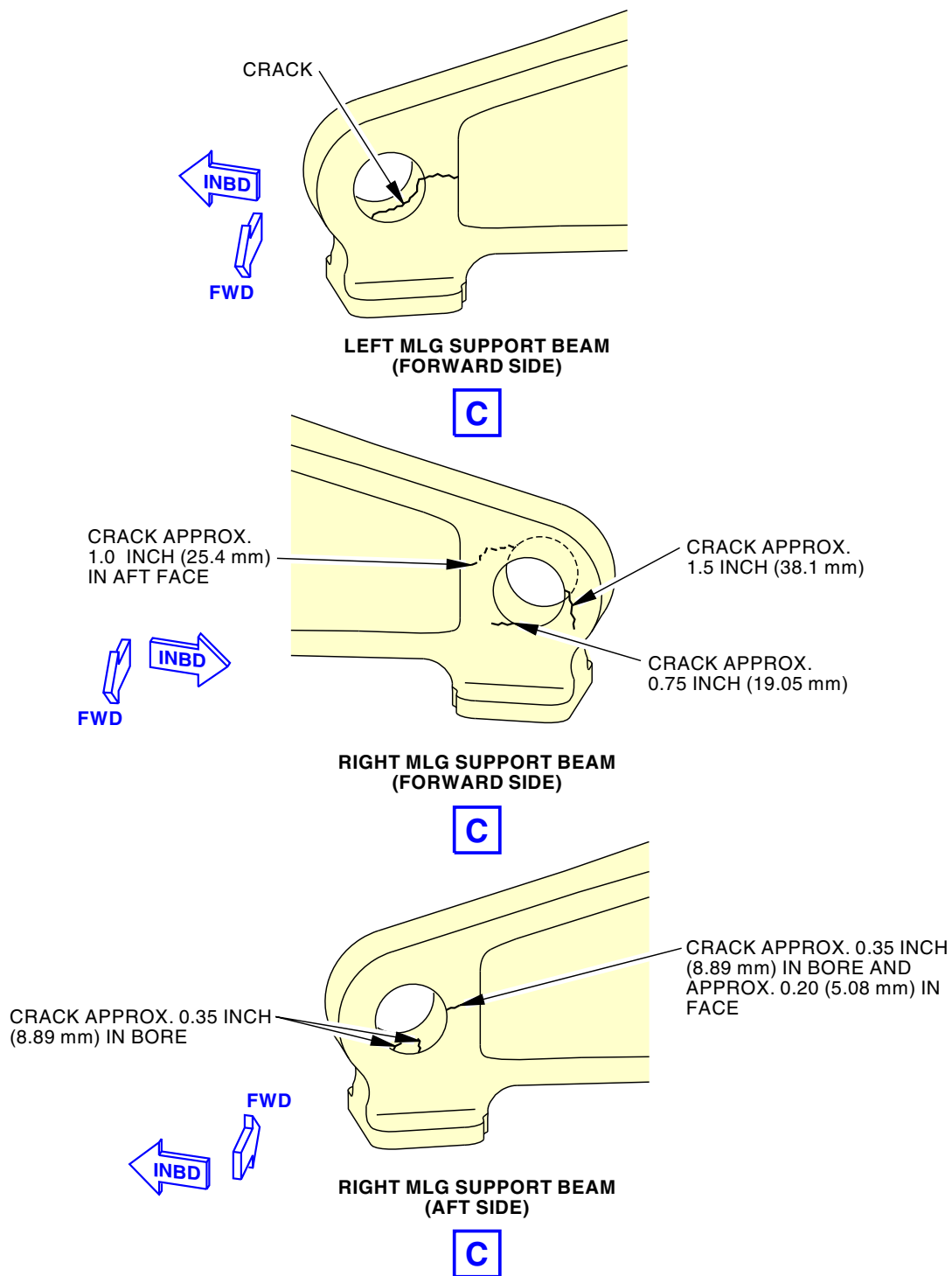
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Main Landing Gear Support Beam - Corrosion Prevention
Figure 201/57-16-06-990-801 (Sheet 2 of 2)

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MAIN LANDING GEAR SUPPORT BEAM - REMOVAL/INSTALLATION

1. General

- A. This procedure has two tasks:
- (1) Main Landing Gear Support Beam Removal
 - (2) Main Landing Gear Support Beam Installation.

TASK 57-16-06-000-801

2. Main Landing Gear Support Beam Removal

A. **General**

- (1) This task has the steps to remove the Main Landing Gear (MLG) support beam.

B. **References**

Reference	Title
27-51-11-000-801	Inboard Trailing Edge Flap Removal (P/B 401)
27-51-15-000-803	Inboard Flap Inboard Track Removal (P/B 401)
27-51-18-000-802	Inboard Flap Support Aft Fairing Removal (P/B 401)
27-51-31-000-802	Inboard Flap Outboard Transmission Removal (P/B 401)
27-51-31-000-803	Inboard Flap Inboard Transmission Removal (P/B 401)
27-51-56-000-801	Main Landing Gear Beam Angle Gearbox Removal (P/B 401)
27-51-58-000-803	Inboard Wing Flap Torque Tube Removal (P/B 401)
27-62-12-000-801	Inboard Ground Spoiler Removal (P/B 401)
27-62-71-000-801	Inboard Ground Spoiler Actuator Removal (P/B 401)
28-26-00-650-801	Fuel Tank Defueling (P/B 201)
32-11-00-000-802	Main Landing Gear Removal (P/B 401)
32-13-21-000-801	Main Landing Gear Wing Door Removal (P/B 401)
32-32-11-000-801	Main Gear Actuator Assembly Removal (P/B 401)

C. **Location Zones**

Zone	Area
734	Left Main Landing Gear
744	Right Main Landing Gear

D. **Access Panels**

Number	Name/Location
551AT	Upper Inboard Fixed Trailing Edge Access Panel
551BT	Upper Inboard Fixed Trailing Edge, MLG Actuator Access Panel
551DB	Lower Inboard Fixed Trailing Edge, Lube Actuator & MLG Beam Outboard Attach Pin Access Panel
551DT	Upper Inboard Fixed Trailing Edge, MLG Beam Access Panel
551EB	Lower Inboard Fixed Trailing Edge, MLG Attach Fitting Access Panel
551ET	Upper Inboard Fixed Trailing Edge, MLG Beam Access Panel
551FB	Lower Inboard Fixed Trailing Edge, Landing Gear Access Panel
651AT	Upper Inboard Fixed Trailing Edge Access Panel
651BT	Upper Inboard Fixed Trailing Edge, MLG Actuator Access Panel
651DB	Lower Inboard Fixed Trailing Edge, Lube Actuator & MLG Beam Outboard Attach Pin Access Panel

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Number	Name/Location
651DT	Upper Inboard Fixed Trailing Edge, MLG Beam Access Panel
651EB	Lower Inboard Fixed Trailing Edge, MLG Attach Fitting Access Panel
651ET	Upper Inboard Fixed Trailing Edge, MLG Beam Access Panel
651FB	Lower Inboard Fixed Trailing Edge, Landing Gear Access Panel

E. Prepare for the Removal

SUBTASK 57-16-06-860-001

- (1) Defuel the wing fuel tanks (TASK 28-26-00-650-801).

SUBTASK 57-16-06-860-002

- (2) Remove the applicable inboard trailing edge flap (TASK 27-51-11-000-801).

SUBTASK 57-16-06-020-001

- (3) Remove the applicable main landing gear (TASK 32-11-00-000-802).

SUBTASK 57-16-06-010-001

- (4) Remove the wing door (TASK 32-13-21-000-801).

SUBTASK 57-16-06-010-002

- (5) Remove the fairing for the inboard flap track (TASK 27-51-18-000-802).

SUBTASK 57-16-06-010-003

- (6) Remove the applicable inboard ground spoiler (TASK 27-62-12-000-801).

SUBTASK 57-16-06-200-003

- (7) At the fitting on the rear spar holding the outboard end of the MLG support beam [1], measure to find if it is necessary to install new bushings.

NOTE: The installation of new bushings will be done after removing the support beam completely.

- (a) Measure the clearance between the bushing face on the FORWARD side of the support beam and the adjacent bushing face in the support fitting.

1) This clearance cannot be more than 0.020 in. (0.508 mm).

- (b) Measure the clearance between the bushing face on the AFT side of the support beam and the adjacent bushing face in the support fitting.

1) This clearance cannot be more than 0.020 in. (0.508 mm).

2) The total clearance, aft side plus the forward side, cannot be more than 0.025 in. (0.635 mm).

- (c) If these clearances are more than the allowed limits, replace defective bushings.

NOTE: Shim washers are not allowed.

NOTE: Defective bushings may be in the support beam and/or the support fitting.

SUBTASK 57-16-06-010-004

- (8) Remove the applicable panels that surround the MLG support beam [1]:

- (a) On the left wing, remove these access panels:

Number	Name/Location
551AT	Upper Inboard Fixed Trailing Edge Access Panel
551BT	Upper Inboard Fixed Trailing Edge, MLG Actuator Access Panel

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<u>Number</u>	<u>Name/Location</u>
551DB	Lower Inboard Fixed Trailing Edge, Lube Actuator & MLG Beam Outboard Attach Pin Access Panel
551DT	Upper Inboard Fixed Trailing Edge, MLG Beam Access Panel
551EB	Lower Inboard Fixed Trailing Edge, MLG Attach Fitting Access Panel
551ET	Upper Inboard Fixed Trailing Edge, MLG Beam Access Panel
551FB	Lower Inboard Fixed Trailing Edge, Landing Gear Access Panel

- (b) On the right wing, remove these access panels:

<u>Number</u>	<u>Name/Location</u>
651AT	Upper Inboard Fixed Trailing Edge Access Panel
651BT	Upper Inboard Fixed Trailing Edge, MLG Actuator Access Panel
651DB	Lower Inboard Fixed Trailing Edge, Lube Actuator & MLG Beam Outboard Attach Pin Access Panel
651DT	Upper Inboard Fixed Trailing Edge, MLG Beam Access Panel
651EB	Lower Inboard Fixed Trailing Edge, MLG Attach Fitting Access Panel
651ET	Upper Inboard Fixed Trailing Edge, MLG Beam Access Panel
651FB	Lower Inboard Fixed Trailing Edge, Landing Gear Access Panel

F. Main Landing Gear Support Beam Removal

SUBTASK 57-16-06-020-002

- (1) Remove the lower stabilizer link [2].
 - (a) If necessary, disconnect the actuator hoses attached to the lower stabilizer link (TASK 32-32-11-000-801).
 - 1) Stow the actuator hoses to the rear spar.
 - 2) Make a note of the locations of the hoses.
 - (b) Disconnect the forward end of the lower stabilizer link [2] from the rear spar (View C, Figure 401).
 - 1) Remove the nut [8], two washers [9], jumper [10], jumper [11] and bolt [12].
 - 2) Remove the cotter pin [7], nut [6], washer [5], washer [4] and fuse pin [3].
 - (c) Disconnect the aft end of the lower stabilizer link [2] from the MLG support beam [1] (View D, Figure 401).
 - 1) Remove the nut [8], two washers [9], jumper [13] and bolt [14].
 - 2) Remove the cotter pin [7], nut [6], washer [5], washer [4] and fuse pin [3].
 - (d) Remove the bolts from the upper and lower stabilizer link attach fittings on the support beam, if necessary.
 - 1) Remove the attach fittings from the support beam.
 - 2) Make a note of the location of the shims.

SUBTASK 57-16-06-020-003

- (2) Remove the upper stabilizer link [15].
 - (a) Disconnect the brake hoses and hydraulic tubes that are attached to the upper stabilizer link fitting.
 - 1) Make a note of the location of the hoses and tubes.

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- (b) Disconnect the electrical connectors and conduits that are attached to the upper stabilizer link fitting.
 - 1) Make a note of the location of the electrical connectors and conduits.
- (c) Disconnect the tray brackets from the upper stabilizer link [15] (View F, Figure 401).
 - 1) Remove the nut [19], two washers [20], jumper [21], washer [22], bolt [23].
 - 2) Remove the four collars [16], two bolts [17] and two bolts [18].
- (d) Disconnect the aft end of the upper stabilizer link [15] from the support fitting on the MLG support beam [1] (View G, Figure 401).
 - 1) Remove the cotter pin [28], nut [27], washer [26], washer [25] and bolt [24].
- (e) Disconnect the forward end of the upper stabilizer link [15] from the rear spar (View H, Figure 401).
 - 1) Remove the nut [19], two washers [20], jumper [29] and bolt [30].
 - 2) Remove the cotter pin [7], nut [6], washer [5], washer [4] and fuse pin [3].

SUBTASK 57-16-06-020-004

- (3) Remove the walking beam hanger fitting, the walking beam, and the actuator (TASK 32-32-11-000-801).

SUBTASK 57-16-06-020-005

- (4) Remove the two ground spoiler actuators from the aft side of the support beam (TASK 27-62-71-000-801).
 - (a) If necessary, remove the two spoiler hinge supports.

SUBTASK 57-16-06-020-006

- (5) Disconnect the necessary hydraulic and fire extinguishing tubes from the support beam.
NOTE: These tubes are on the aft and the forward side of the support beam.
 - (a) Make a note of the locations of the tubes.

SUBTASK 57-16-06-020-007

- (6) Disconnect the electrical wires from the support beam.
 - (a) Make note of the locations of the wires.
 - (b) Make sure that there is no tension in the wires.
NOTE: The wires must be loose for removal of the support beam.

SUBTASK 57-16-06-020-008

- (7) Remove the inboard flap inboard transmission (TASK 27-51-31-000-803).

SUBTASK 57-16-06-020-009

- (8) If necessary, remove the inboard flap outboard transmission (TASK 27-51-31-000-802).

SUBTASK 57-16-06-020-010

- (9) Remove the MLG beam angle gear box from the aft side of the support beam (TASK 27-51-56-000-801).

SUBTASK 57-16-06-010-005

- (10) Remove the inboard torque tube (TASK 27-51-58-000-803).

SUBTASK 57-16-06-010-006

- (11) Remove the inboard flap track (TASK 27-51-15-000-803).

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SUBTASK 57-16-06-020-011



GET SUFFICIENT AID FROM OTHER PERSONNEL AND EQUIPMENT TO HOLD THE COMPONENT DURING THE REMOVAL, AND INSTALLATION. THE COMPONENT IS HEAVY. THIS WILL PREVENT INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

- (12) Remove the MLG support beam [1]:
- Hold the MLG support beam [1] its position.
 - Do these steps to disconnect the hanger link [54] from the MLG support beam [1] (View I, Figure 401).
 - Remove the nut [40], washer [39], two caps [33], washer [32] and bolt [31].
 - Remove the two collars [41], two radius fillers [42] and two bolts [43] that lock the nut [38] in position.
 - Remove the nut [38], washers [35], washers [36], washers [37] and pin [34] from the hanger link [54].
 - Make a note of the locations of the washers.
 - Keep all of the washers.
 - If you will not remove the hanger link [54] from the airplane, do these steps:
 - Swing the hanger link [54] inboard.
 - Hold the lower end of the hanger link [54] inboard by temporarily fastening it.
NOTE: This will allow removal of the support beam.
 - If you will remove the hanger link [54] from the airplane, do these steps (View L, Figure 401):
 - Remove the nut [60], washer [61], bushing [62], washer [63] and bolt [64].
 - Remove the nut [40], washer [39], two caps [33], washer [32] and bolt [31].
 - Remove the two collars [41], two radius fillers [42] and two bolts [43] that lock the nut [38] in position.
 - Remove the nut [38] and pin [34] from the hanger link [54].
 - Remove the hanger link [54].
 - Do these steps to disconnect the MLG support beam [1] from the inboard flap track fitting (View I, Figure 401).
NOTE: The inboard flap track fitting connects the support beam to the inboard flap track. See illustration.
 - Remove the two nuts [45], two washers [46], two washers [47] and two bolts [48] on the forward side of the fitting.
 - Remove the two nuts [49], three washers [50], jumper [51], two washers [52] and two bolts [53] on the aft side of the fitting.
 - Do these steps to remove the fuse pin [59] that connects the MLG support beam [1] to the outboard support fitting (View K, Figure 401).
 - Remove the two bolts [55], two washers [56], two nuts [58] and two bushings [57] that lock the fuse pin [59] in position.
 - Remove the fuse pin [59].
 - Carefully remove the MLG support beam [1].

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- 1) Be careful when you move the MLG support beam [1] because it weighs more than 250 lb (113 kg).
- 2) Move the support beam inboard until it is clear of the outboard support fitting, electrical wire bundles, fire extinguishing tube, and hydraulic tubes.
- 3) Lower the outboard end of the support beam, then move the support beam outboard.
- 4) Remove the MLG support beam [1] from the airplane.

———— **END OF TASK** ————

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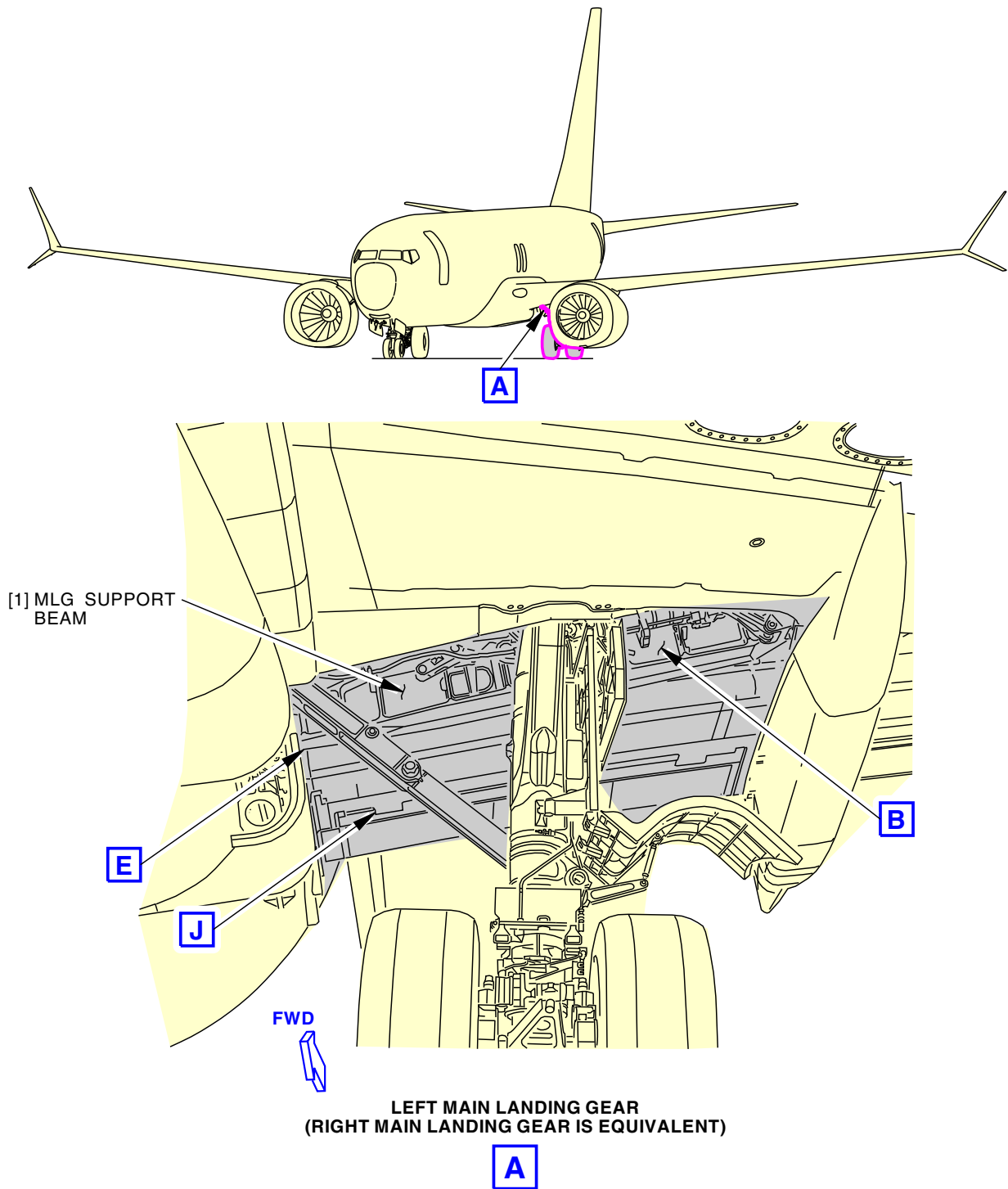
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Main Landing Gear Support Beam Installation
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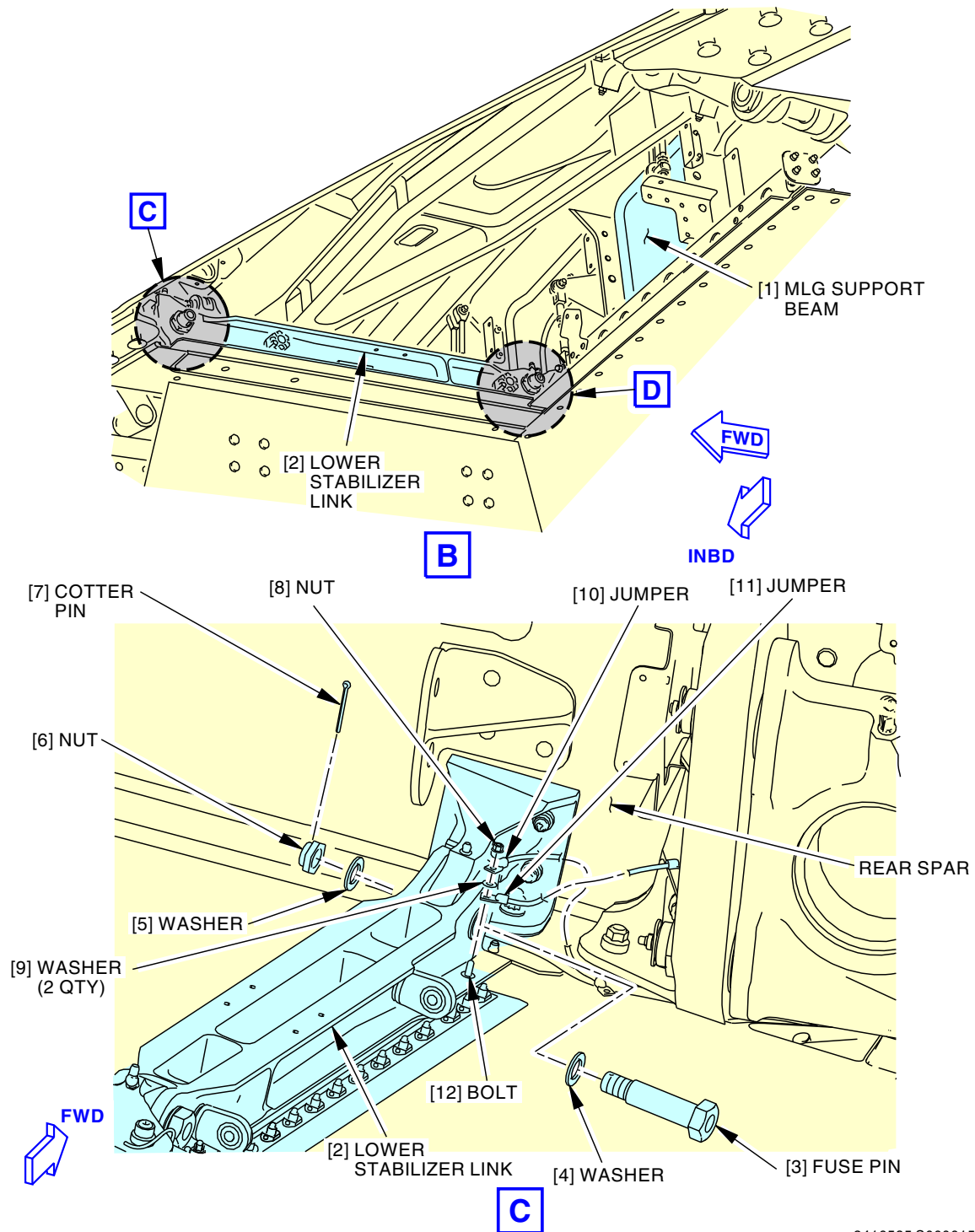
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Main Landing Gear Support Beam Installation
Figure 401/57-16-06-990-802 (Sheet 2 of 7)

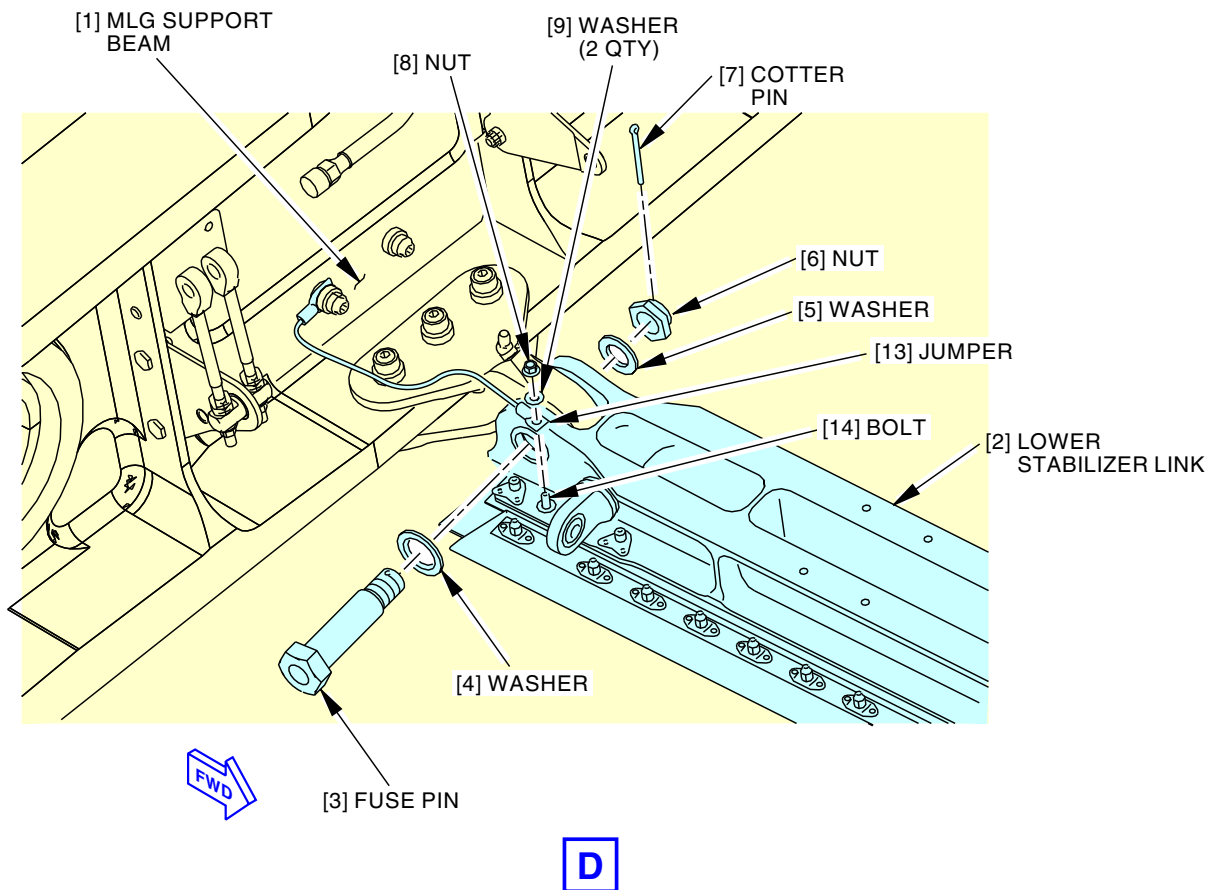
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Main Landing Gear Support Beam Installation
Figure 401/57-16-06-990-802 (Sheet 3 of 7)

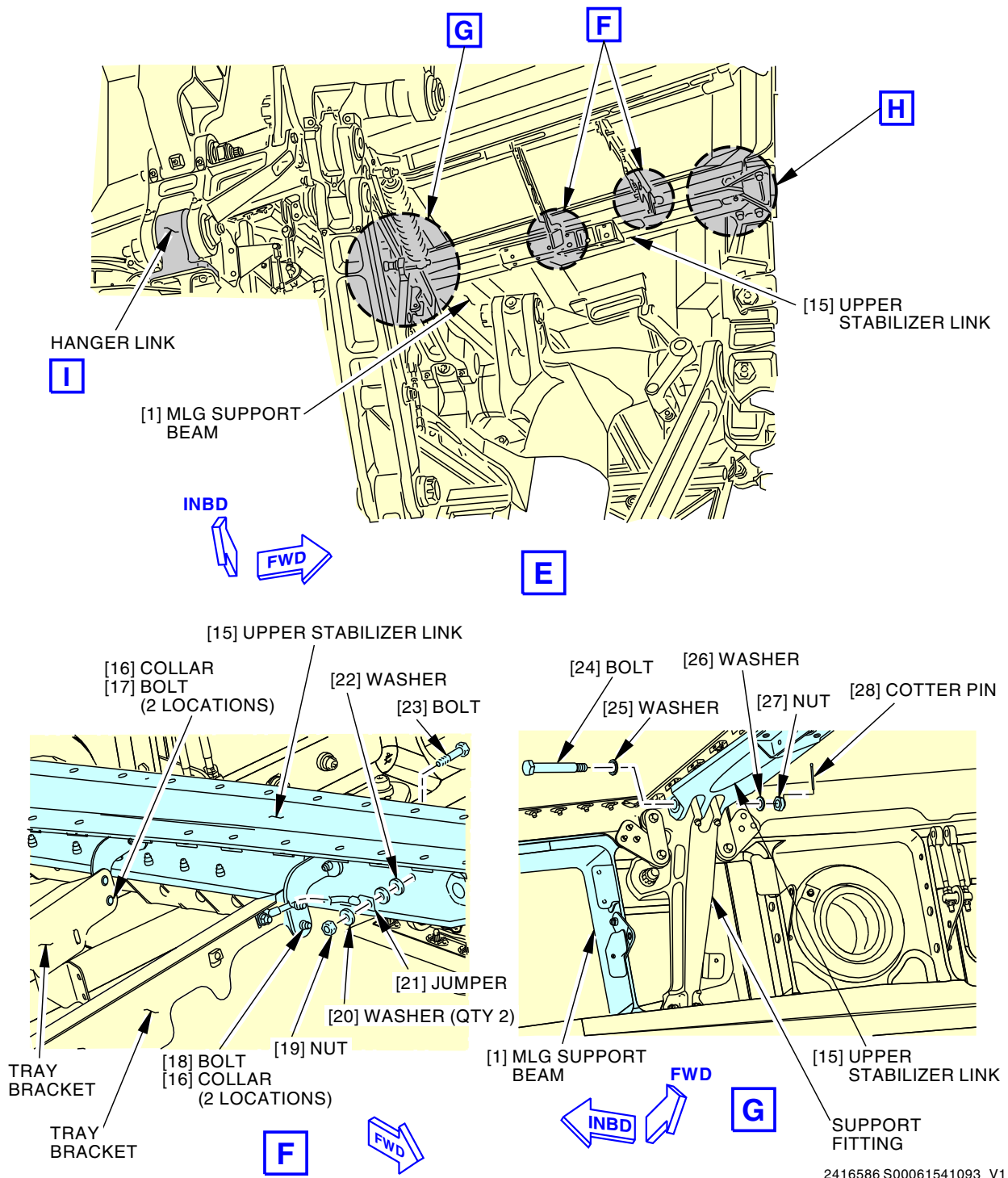
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Main Landing Gear Support Beam Installation
Figure 401/57-16-06-990-802 (Sheet 4 of 7)

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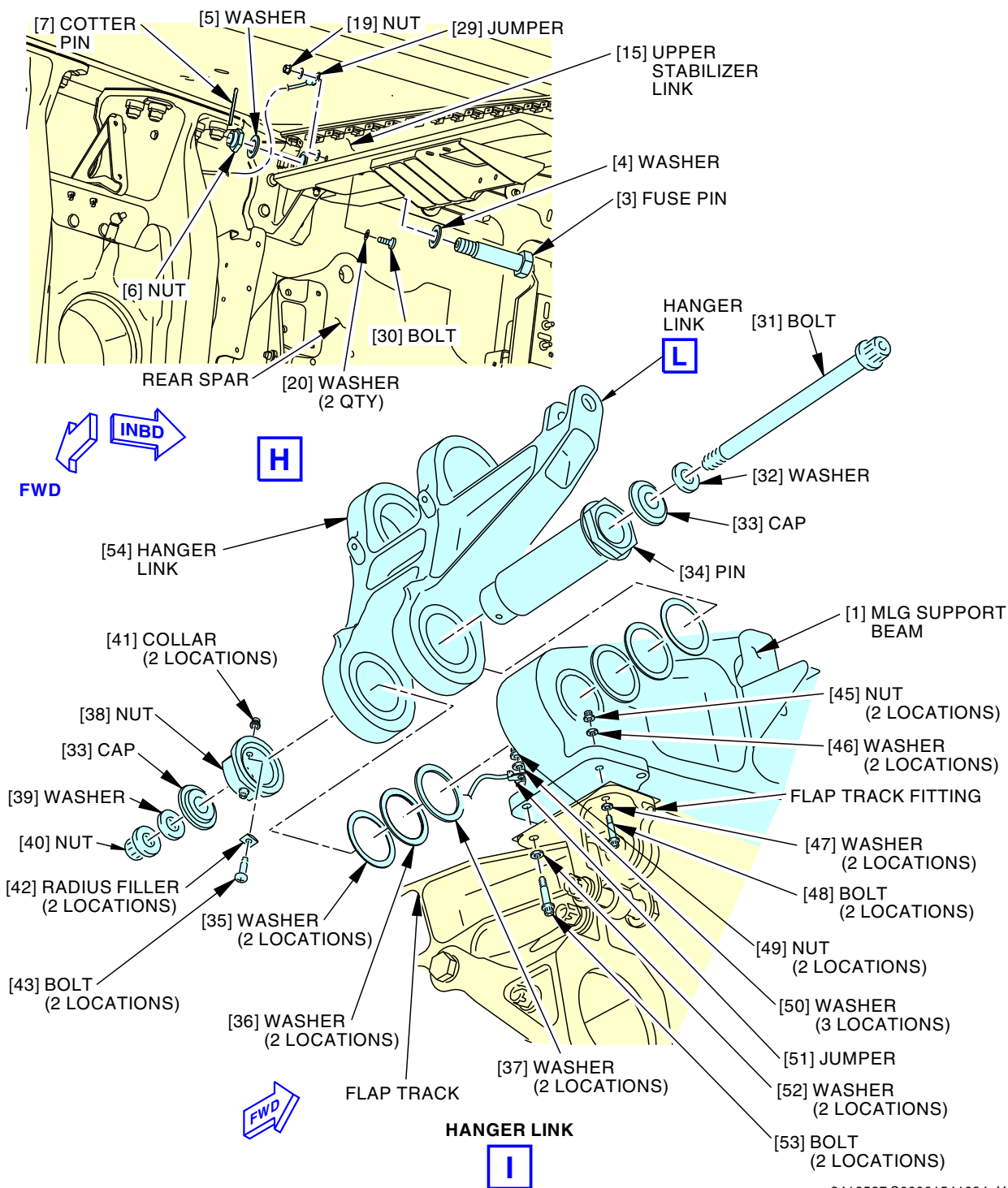
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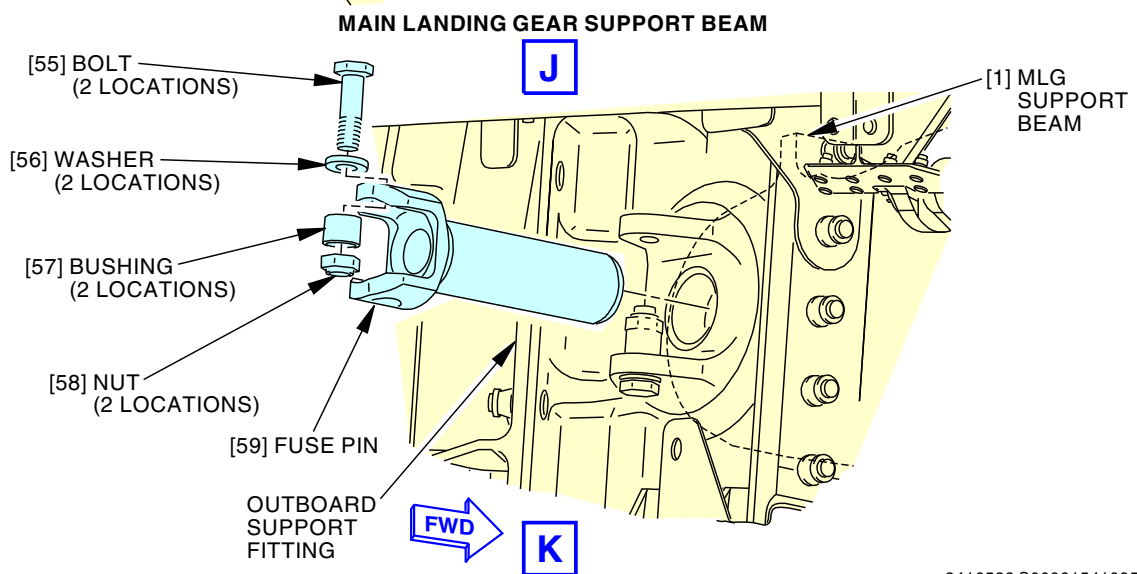
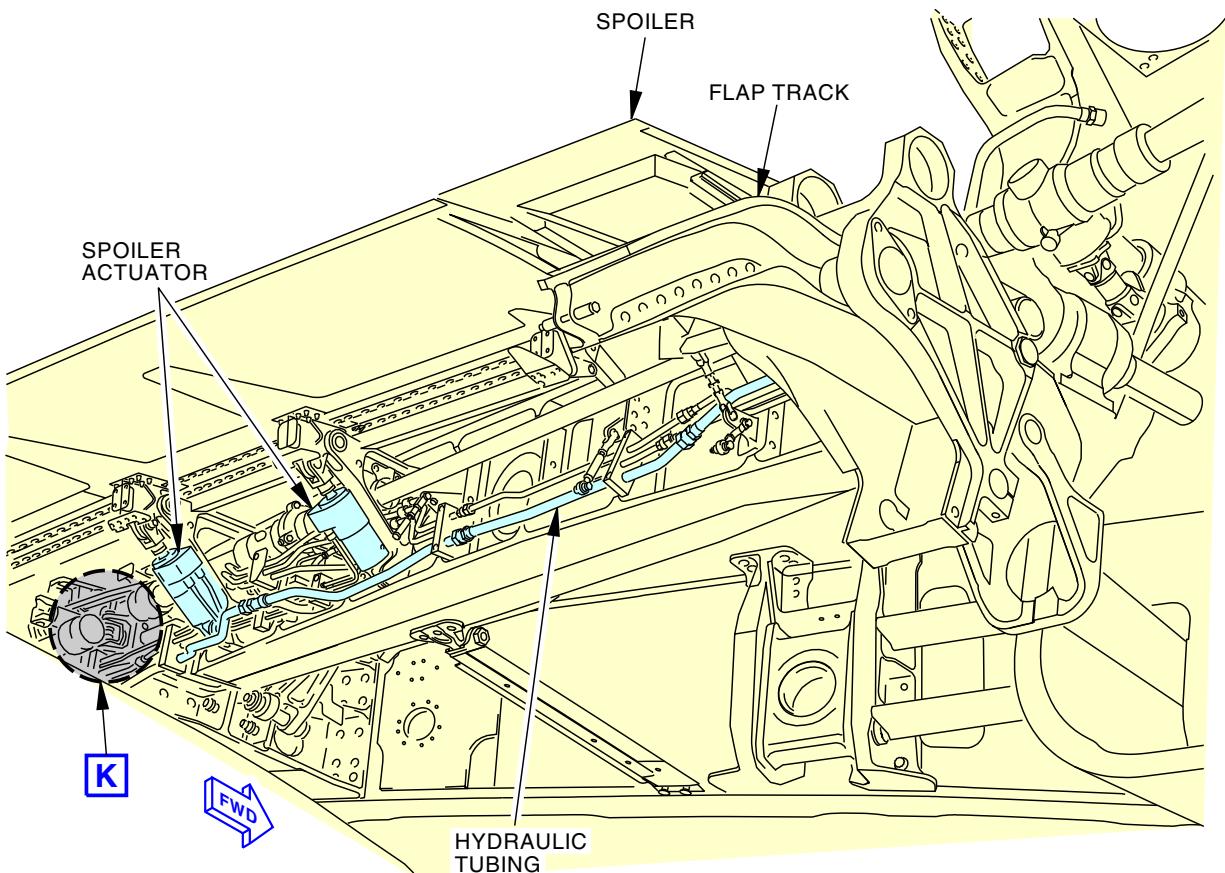
Main Landing Gear Support Beam Installation
Figure 401/57-16-06-990-802 (Sheet 5 of 7)

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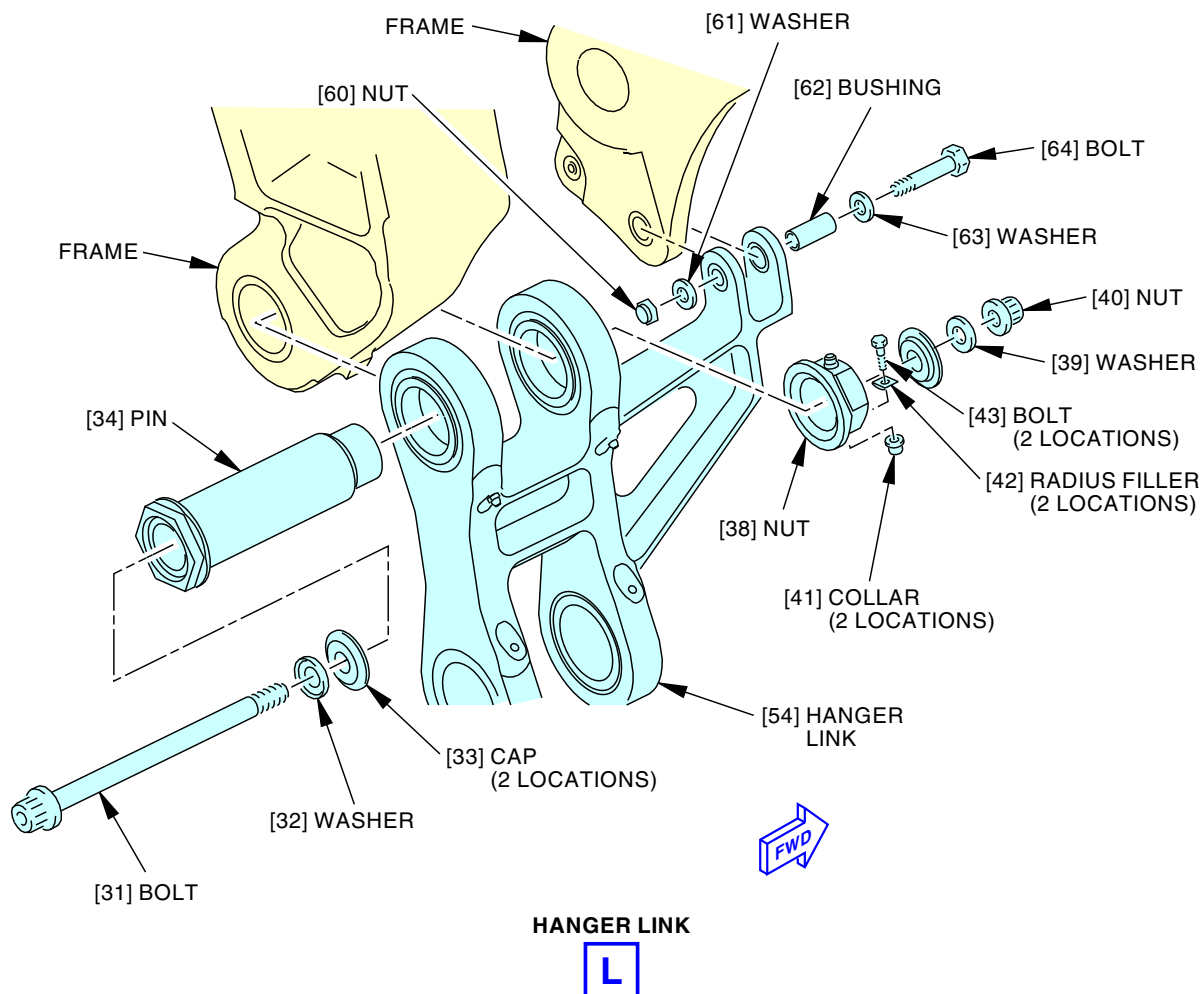
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TASK 57-16-06-400-801

3. Main Landing Gear Support Beam Installation

A. General

(1) This task has the steps to install the Main Landing Gear (MLG) support beam.

B. References

Reference	Title
12-25-07-600-801	Main Landing Gear Support Beam Lubrication (P/B 301)
27-51-11-400-801	Inboard Trailing Edge Flap Installation (P/B 401)
27-51-15-400-803	Inboard Flap Inboard Track Installation (P/B 401)
27-51-18-400-802	Inboard Flap Support Aft Fairing Installation (P/B 401)
27-51-31-400-802	Inboard Flap Outboard Transmission Installation (P/B 401)
27-51-31-400-803	Inboard Flap Inboard Transmission Installation (P/B 401)
27-51-56-400-801	Main Landing Gear Beam Angle Gearbox Installation (P/B 401)
27-51-58-400-803	Inboard Wing Flap Torque Tube Installation (P/B 401)
27-62-12-400-801	Inboard Ground Spoiler Installation (P/B 401)
27-62-71-400-801	Inboard Ground Spoiler Actuator Installation (P/B 401)
32-11-00-400-802	Main Landing Gear Installation (P/B 401)
32-13-21-420-801	Main Landing Gear Wing Door Installation (P/B 401)
32-32-11-400-801	Main Gear Actuator Assembly Installation (P/B 401)
51-21-72-370-801	BMS10-79 Primer - Application (P/B 701)
51-21-72-370-804	BMS10-11 Primer - Application (P/B 701)
51-21-73-370-802	BMS10-60 Topcoat Application (P/B 701)
SWPM 20-10-11	WIRING ASSEMBLY AND INSTALLATION CONFIGURATION
SWPM 20-20-00	ELECTRICAL BONDING PROCESSES

C. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt.", which stands for Optional.

Reference	Description
COM-1550	Bonding Meter - Approved, Intrinsically Safe (Approved for use in Class I, Divisions I & II hazardous (classified) locations. Outside these hazardous locations, COM-614 can be used in lieu of COM-1550). Part #: 620LK Supplier: 1CRL2 Part #: M1 Supplier: 3AD17 Part #: M1B Supplier: 3AD17 Part #: T477W (C15292) Supplier: 06659

D. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
A50231	Sealant - Pressure And Environmental - Chromate Type	BMS5-95 Class B
B00148	Solvent - Methyl Ethyl Ketone (MEK)	ASTM D740
B00184	Solvent - Presealing, Cleaning Solvent	BMS11-7

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Reference	Description	Specification
C00175	Primer - Urethane Compatible, Corrosion Resistant	BMS10-79 Type III
C00700	Coating - Protective Enamel (BAC 707 Gray Color, Gloss)	BMS10-60 Type I
D00633	Grease - Aircraft General Purpose	BMS3-33
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	AMS3819 Class 1 Grade A or B Form 1 (Supersede BMS15-5 CLA)
G50398	Pad - Adbrasive, Scotch-Brite Type S, Abrasive Pad	
G50492	Pad - 3M Scotch Brite 7448 Ultra Fine Pad	MIL-A-9962A Type III Grade AAA
G50961	Coating - Corrosion Inhibiting Epoxy Primer - (BAC 377 Yellow Color)	BMS10-11 Type I

E. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	MLG support beam	57-16-06-02-765	SIA ALL
		57-16-06-02-768	SIA ALL
2	Lower stabilizer link	57-16-51-02-075	SIA ALL
		57-16-51-02-080	SIA ALL
7	Cotter pin	57-16-51-02-045	SIA ALL
		57-16-51-02-135	SIA ALL
15	Upper stabilizer link	57-16-51-02-185	SIA ALL
		57-16-51-02-190	SIA ALL
28	Cotter pin	57-16-51-02-130	SIA ALL
41	Collar	57-16-51-20-075	SIA ALL

F. Location Zones

Zone	Area
734	Left Main Landing Gear
744	Right Main Landing Gear

G. Access Panels

Number	Name/Location
551AT	Upper Inboard Fixed Trailing Edge Access Panel
551BT	Upper Inboard Fixed Trailing Edge, MLG Actuator Access Panel
551DB	Lower Inboard Fixed Trailing Edge, Lube Actuator & MLG Beam Outboard Attach Pin Access Panel
551DT	Upper Inboard Fixed Trailing Edge, MLG Beam Access Panel
551EB	Lower Inboard Fixed Trailing Edge, MLG Attach Fitting Access Panel
551ET	Upper Inboard Fixed Trailing Edge, MLG Beam Access Panel
551FB	Lower Inboard Fixed Trailing Edge, Landing Gear Access Panel
651AT	Upper Inboard Fixed Trailing Edge Access Panel
651BT	Upper Inboard Fixed Trailing Edge, MLG Actuator Access Panel

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Number	Name/Location
651DB	Lower Inboard Fixed Trailing Edge, Lube Actuator & MLG Beam Outboard Attach Pin Access Panel
651DT	Upper Inboard Fixed Trailing Edge, MLG Beam Access Panel
651EB	Lower Inboard Fixed Trailing Edge, MLG Attach Fitting Access Panel
651ET	Upper Inboard Fixed Trailing Edge, MLG Beam Access Panel
651FB	Lower Inboard Fixed Trailing Edge, Landing Gear Access Panel

H. Main Landing Gear Support Beam Installation

SUBTASK 57-16-06-420-001



GET SUFFICIENT AID FROM OTHER PERSONNEL AND EQUIPMENT TO HOLD THE COMPONENT DURING THE REMOVAL, AND INSTALLATION. THE COMPONENT IS HEAVY. THIS WILL PREVENT INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

- (1) Install the outboard end of the MLG support beam [1].
 - (a) Be careful when you move the MLG support beam [1] because it weighs more than 250 lb (113 kg).
 - (b) Put the MLG support beam [1] into its position.
 - 1) Lift the inboard end of the support beam and move it inboard until it is above any structure.
 - 2) Lift the outboard end of the support beam.
 - 3) Put the outboard end of the support beam in the outboard support fitting.
 - 4) Hold the support beam in its position.
 - (c) Install the fuse pin [59] that connects MLG support beam [1] to the outboard support fitting (View K, Figure 401).
 - 1) Apply a thin layer of grease, D00633 to the outer diameter and threads of the fuse pin [59].
 - 2) Put the fuse pin [59] into its position with the outboard support fitting and the MLG support beam [1].
 - 3) Apply sealant, A00247 on the two bolts [55], the faces of the two washers [56] and the outer diameter of the two bushings [57].
 - 4) Install the two bolts [55], two washers [56], two bushings [57] and two nuts [58] to lock the fuse pin [59] into position.
 - a) Tighten the nut to a torque tool set point of 270 in-lb (31 N·m).

SUBTASK 57-16-06-420-002



GET SUFFICIENT AID FROM OTHER PERSONNEL AND EQUIPMENT TO HOLD THE COMPONENT DURING THE REMOVAL, AND INSTALLATION. THE COMPONENT IS HEAVY. THIS WILL PREVENT INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

- (2) Install the inboard end of the MLG support beam [1].
 - (a) Be careful when you move the MLG support beam [1] because it weighs more than 250 lb (113 kg).
 - (b) Put the MLG support beam [1] on the inboard flap track fitting.

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- (c) Install the inboard end of the MLG support beam [1] to the inboard flap track fitting (View I, Figure 401).
 - 1) Put the MLG support beam [1] on top of the inboard flap track fitting.
 - 2) Install the bolts [48], washers [47], washers [46] and nuts [45] on the forward side of the inboard flap track fitting.
 - 3) Install the bolt [53], washer [52], washer [50] and nut [49] on the outboard side of the inboard flap track fitting.
- (d) Do these steps to prepare the titanium MLG support beam [1], jumper [51], nut [49], washer [50], washer [52] and bolt [53] for installation:
 - 1) Clean the fasteners, jumper [51] and mount hole of the MLG support beam [1]:
 - a) Use Cleaning Procedure 1 to manually clean the MLG support beam [1] at the mount hole (SWPM 20-20-00, Paragraph 2.A.).
 - <1> Prepare approximately 0.6 in. (1.5 cm) diameter of area at the mount hole.
 - <2> Use a very fine Scotch-Brite Type S pad, G50398 or an ultra fine Scotch-Brite 7448 pad, G50492.
 - <3> Move the pad in a circular movement while you press with your thumb.
 - b) Use Cleaning Procedure 5 to clean the MLG support beam [1], jumper [51], nut [49], washer [50], washer [52] and bolt [53] (SWPM 20-20-00, Paragraph 2.E.).
 - <1> Use a new cotton wiper, G00034 soaked with solvent, B00184 or solvent, B00148.
 - <2> Use a new cotton wiper, G00034 to dry the surfaces.
 - <3> Continue to clean and dry the surface until the cotton wiper stays clean.
- (e) Apply sealant, A50231 to the MLG support beam [1] mount hole, jumper [51], bolt [53], washer [52], washers [50] and nut [49].
- (f) Install the bolt [53], washer [52], jumper [51], washers [50] and nut [49].
- (g) Measure the electrical bonding resistance between the jumper [51] and the MLG support beam [1] with an intrinsically safe approved bonding meter, COM-1550.
 - 1) Make sure that the bonding resistance is not more than the maximum value as shown in the SWPM 20-20-00, Section 21-A.
- (h) Refinish the abraded surfaces that you can see.
 - 1) Apply one coat of coating, G50961 (TASK 51-21-72-370-804).
 - 2) Apply coating, C00700 (TASK 51-21-73-370-802).
- (i) If you removed the hanger link [54] from the airplane, do these steps (View L, Figure 401):
 - 1) Install the aft side of the hanger link [54] to the frame.
 - a) Apply a light coat of grease, D00633 to the outer diameter and threads of pin [34].
 - b) Install the pin [34] and nut [38].
 - <1> Tighten the nut [38] to a torque tool set point of 1500 in-lb (169 N·m).
 - c) Install the bolts [43], radius fillers [42] and collars [41] to lock the nut [38] in place.

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- d) Install the bolt [31], washer [32], caps [33], washer [39] and nut [40].
 - <1> Tighten the nut [40] or the head of bolt [31] to a torque tool set point of 1100 in-lb (124 N·m).
- 2) Install the forward side of the hanger link [54] to the frame.
 - a) Apply a light coat of grease, D00633 to the outer diameter of bushing [62].
 - b) Install the bolt [64], washer [63], bushing [62], washer [61] and nut [60].
 - <1> Tighten the nut [60] to a torque tool set point of 400 in-lb (45 N·m).
- (j) Do these steps to connect the hanger link [54] to the MLG support beam [1] (View I, Figure 401):
 - 1) Apply a light coat of grease, D00633 to the outer diameter and threads of pin [34].
 - 2) Install the pin [34], washers [35], washers [36], washers [37] and nut [38].
 - a) Install the washers [35], washers [36] and washers [37] between bushing flanges at each side of the MLG support beam [1] to reduce the gap to 0.005 in. (0.127 mm) minimum per side and 0.025 in. (0.635 mm) maximum total gap for both sides.
 - b) Tighten the nut [38] to a torque tool set point of 1500 in-lb (169 N·m).
 - 3) Install the bolts [43], radius fillers [42] and collars [41] to lock the nut [38] in place.
 - 4) Install the bolt [31], washer [32], caps [33], washer [39] and nut [40].
 - a) Tighten the nut [40] or the head of bolt [31] to a torque tool set point of 1100 in-lb (124 N·m).



MAKE SURE THAT THE SYSTEM-TO-SYSTEM SEPARATIONS ARE CORRECT. SEPARATIONS THAT ARE NOT CORRECT COULD CAUSE UNWANTED CONDITIONS, WHICH COULD INCLUDE CHAFING, FIRE OR ELECTROMAGNETIC INTERFERENCE. THIS CAN CAUSE INJURIES TO PERSONNEL, OR CAN MAKE FLIGHT DANGEROUS, OR CAN CAUSE DAMAGE TO THE SYSTEMS.

- (k) Make sure there is a minimum distance of 0.13 in. (3.30 mm) between the wire bundles and the hanger link.

NOTE: For more detailed information in the wire bundle installation, refer to the Standard Wiring Practices Manual, Wiring Assembly and Installation Configuration, SWPM 20-10-11.

- (l) Apply grease, D00633 through all grease fittings on the hanger link until you can see the grease come out.

SUBTASK 57-16-06-420-003

- (3) Do this task: Inboard Flap Inboard Track Installation, TASK 27-51-15-400-803.

SUBTASK 57-16-06-420-004

- (4) Do this task: Inboard Flap Inboard Transmission Installation, TASK 27-51-31-400-803.

SUBTASK 57-16-06-420-005

- (5) If necessary, do this task: Inboard Flap Outboard Transmission Installation, TASK 27-51-31-400-802.

SUBTASK 57-16-06-020-012

- (6) Do this task: Main Landing Gear Beam Angle Gearbox Installation, TASK 27-51-56-400-801.

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SUBTASK 57-16-06-410-001

(7) Do this task: Inboard Wing Flap Torque Tube Installation, TASK 27-51-58-400-803.

SUBTASK 57-16-06-860-003

(8) Remove the support tools from the support beam.

SUBTASK 57-16-06-420-006

(9) Do this task: Inboard Ground Spoiler Actuator Installation, TASK 27-62-71-400-801.

SUBTASK 57-16-06-420-007

(10) Attach all hydraulic tubes to the support beam.

SUBTASK 57-16-06-420-008

(11) Attach all of the electrical wires to the support beam.

SUBTASK 57-16-06-420-009

(12) Do this task: Main Gear Actuator Assembly Installation, TASK 32-32-11-400-801.

SUBTASK 57-16-06-420-010

(13) Install the upper stabilizer link [15]:

- (a) If removed, install the upper stabilizer link attach fittings to the support beam:
 - 1) Make sure that you install the shims on the same locations from where they were removed.
 - 2) Install the attach fittings to the support beam.
- (b) Connect the aft end of the upper stabilizer link [15] to the support fitting on the MLG support beam [1] (View G, Figure 401):
 - 1) Apply a light coat of grease, D00633 on the outer diameter and threads of bolt [24].
 - 2) Install the bolt [24], washer [25], washer [26] and nut [27].
 - 3) Tighten the nut [27] to a torque tool set point of 270 in-lb (31 N·m).
 - 4) Install a new cotter pin [28].
- (c) Connect the forward end of the upper stabilizer link [15] to the rear spar (View H, Figure 401):
 - 1) Apply a light coat of grease, D00633 on the outer diameter and threads of fuse pin [3].
 - 2) Install the fuse pin [3], washer [4], washer [5] and nut [6].
 - 3) Tighten the nut [6] to a torque tool set point of 820 in-lb (93 N·m).
 - 4) Install a new cotter pin [7].
- (d) Connect the tray brackets to the upper stabilizer link [15] (View F, Figure 401):
 - 1) Install the two bolts [18], two bolts [17] and four collars [16].
- (e) Do these steps to prepare the aluminum upper stabilizer link [15], jumper [21], jumper [29], and fasteners for electrical bonding installation:
 - 1) Clean the fasteners, jumper [21], jumper [29] and mount holes of the upper stabilizer link [15]:
 - a) Use Cleaning Procedure 1 to manually clean the upper stabilizer link [15] at the mount holes (SWPM 20-20-00, Paragraph 2.A.).
 - <1> Prepare approximately 0.6 in. (1.5 cm) diameter of area at the mount holes.

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- <2> Use a very fine Scotch-Brite Type S pad, G50398 or an ultra fine Scotch-Brite 7448 pad, G50492.
- <3> Move the pad in a circular movement while you press with your thumb.
- b) Use Cleaning Procedure 5 to clean the upper stabilizer link [15], bolt [30], jumper [29], washers [20], nuts [19], jumper [21], bolt [23] and washer [22] (SWPM 20-20-00, Paragraph 2.E.).
 - <1> Use a new cotton wiper, G00034 soaked with solvent, B00184 or solvent, B00148.
 - <2> Use a new cotton wiper, G00034 to dry the surfaces.
 - <3> Continue to clean and dry the surfaces until the cotton wiper stays clean.
- (f) Apply sealant, A50231 to the upper stabilizer link [15] mount hole, jumper [29], bolt [30], two washers [20] and nut [19] (View H, Figure 401).
- (g) Install the bolt [30], jumper [29], two washers [20] and nut [19].
- (h) Apply sealant, A50231 to the upper stabilizer link [15], bolt [23], washer [22], jumper [21], two washers [20] and nut [19] (View F, Figure 401).
- (i) Install the bolt [23], washer [22], two washers [20], jumper [21] and nut [19].
- (j) Measure the electrical bonding resistance between the jumper [29] and the upper stabilizer link [15] with an intrinsically safe approved bonding meter, COM-1550.
 - 1) Make sure that the bonding resistance is not more than the maximum value as shown in the SWPM 20-20-00, Section 21-A.
- (k) Measure the electrical bonding resistance between the jumper [21] and the upper stabilizer link [15] with an intrinsically safe approved bonding meter, COM-1550.
 - 1) Make sure that the bonding resistance is not more than the maximum value as shown in the SWPM 20-20-00, Section 21-A.
- (l) Refinish the abraded surfaces that you can see.
 - 1) Apply one coat of primer, C00175 (TASK 51-21-72-370-801).
 - 2) Apply coating, C00700 (TASK 51-21-73-370-802).
- (m) Apply grease, D00633 through all grease fittings on the upper stabilizer link attach fittings until you can see the grease come out.
- (n) Connect the electrical connectors and conduits to the upper stabilizer link fitting.
- (o) Connect the hydraulic tubes to the upper stabilizer link fitting.

SUBTASK 57-16-06-420-011

- (14) Install the lower stabilizer link [2]:
 - (a) If removed, install the lower stabilizer link attach fitting to the support beam:
 - 1) Make sure that you install the shims on the same locations from where they were removed.
 - 2) Install the attach fittings to the support beam.
 - (b) Connect the aft end of the lower stabilizer link [2] from the MLG support beam [1] (View D, Figure 401):
 - 1) Apply a light coat of grease, D00633 on the outer diameter and threads of fuse pin [3].
 - 2) Install the fuse pin [3], washer [4], washer [5] and nut [6].

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- 3) Tighten the nut [6] to a torque tool set point of 820 in-lb (93 N·m).
- 4) Install a new cotter pin [7].
- (c) Connect the forward end of the lower stabilizer link [2] from the rear spar (View C, Figure 401):
 - 1) Apply a light coat of grease, D00633 on the outer diameter and threads of fuse pin [3].
 - 2) Install the fuse pin [3], washer [4], washer [5] and nut [6].
 - 3) Tighten the nut [6] to a torque tool set point of 820 in-lb (93 N·m).
 - 4) Install a new cotter pin [7].
- (d) Do these steps to prepare the aluminum lower stabilizer link [2], jumper [10], jumper [11], jumper [13] and fasteners for electrical bonding installation:
 - 1) Clean the fasteners, jumper [10], jumper [11], jumper [13] and mount holes of the lower stabilizer link [2]:
 - a) Use Cleaning Procedure 1 to manually clean the lower stabilizer link [2] at the mount holes (SWPM 20-20-00, Paragraph 2.A.).
 - <1> Prepare approximately 0.6 in. (1.5 cm) diameter of area at the mount holes.
 - <2> Use a very fine Scotch-Brite Type S pad, G50398 or an ultra fine Scotch-Brite 7448 pad, G50492.
 - <3> Move the pad in a circular movement while you press with your thumb.
 - b) Use Cleaning Procedure 5 to clean the lower stabilizer link [2], jumper [13], jumper [11], jumper [10], bolt [14], washers [9], nuts [8] and bolt [12] (SWPM 20-20-00, Paragraph 2.E.).
 - <1> Use a new cotton wiper, G00034 soaked with solvent, B00184 or solvent, B00148.
 - <2> Use a new cotton wiper, G00034 to dry the surfaces.
 - <3> Continue to clean and dry the surfaces until the cotton wiper stays clean.
- (e) Apply sealant, A50231 to the lower stabilizer link [2] mount hole, jumper [13], bolt [14], washers [9] and nut [8] (View D, Figure 401).
- (f) Install the bolt [14], washers [9], jumper [13] and nut [8].
- (g) Apply sealant, A50231 to the lower stabilizer link [2] mount hole, jumper [11], jumper [10], bolt [12], washers [9] and nut [8] (View C, Figure 401).
- (h) Install the bolt [12], washers [9], jumper [11], jumper [10] and nut [8].
- (i) Measure the electrical bonding resistance between the jumper [13] and the lower stabilizer link [2] with an intrinsically safe approved bonding meter, COM-1550.
 - 1) Make sure that the bonding resistance is not more than the maximum value as shown in the SWPM 20-20-00, Section 21-A.
- (j) Measure the electrical bonding resistance between the jumper [10] and the lower stabilizer link [2] with an intrinsically safe approved bonding meter, COM-1550.
 - 1) Make sure that the bonding resistance is not more than the maximum value as shown in the SWPM 20-20-00, Section 21-A.
- (k) Refinish the abraded surfaces that you can see.

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- 1) Apply one coat of primer, C00175 (TASK 51-21-72-370-801).
- 2) Apply coating, C00700 (TASK 51-21-73-370-802).
- (l) Apply grease, D00633 through all grease fittings on the lower stabilizer link attach fittings until you can see the grease come out.
- (m) Connect the hoses common to the lower stabilizer link (TASK 32-32-11-400-801).
 - 1) Make sure that the hoses go through the guide fitting attached to the lower stabilizer link.

I. Put the Airplane Back to Its Usual Condition

SUBTASK 57-16-06-010-007

- (1) Install the applicable panels surrounding the main landing gear support beam:

- (a) On the left wing, install these access panels:

<u>Number</u>	<u>Name/Location</u>
551AT	Upper Inboard Fixed Trailing Edge Access Panel
551BT	Upper Inboard Fixed Trailing Edge, MLG Actuator Access Panel
551DB	Lower Inboard Fixed Trailing Edge, Lube Actuator & MLG Beam Outboard Attach Pin Access Panel
551DT	Upper Inboard Fixed Trailing Edge, MLG Beam Access Panel
551EB	Lower Inboard Fixed Trailing Edge, MLG Attach Fitting Access Panel
551ET	Upper Inboard Fixed Trailing Edge, MLG Beam Access Panel
551FB	Lower Inboard Fixed Trailing Edge, Landing Gear Access Panel

- (b) On the right wing, install these access panels:

<u>Number</u>	<u>Name/Location</u>
651AT	Upper Inboard Fixed Trailing Edge Access Panel
651BT	Upper Inboard Fixed Trailing Edge, MLG Actuator Access Panel
651DB	Lower Inboard Fixed Trailing Edge, Lube Actuator & MLG Beam Outboard Attach Pin Access Panel
651DT	Upper Inboard Fixed Trailing Edge, MLG Beam Access Panel
651EB	Lower Inboard Fixed Trailing Edge, MLG Attach Fitting Access Panel
651ET	Upper Inboard Fixed Trailing Edge, MLG Beam Access Panel
651FB	Lower Inboard Fixed Trailing Edge, Landing Gear Access Panel

SUBTASK 57-16-06-420-012

- (2) Do this task: Inboard Ground Spoiler Installation, TASK 27-62-12-400-801.

SUBTASK 57-16-06-860-004

- (3) Do this task: Inboard Flap Support Aft Fairing Installation, TASK 27-51-18-400-802.

SUBTASK 57-16-06-410-002

- (4) Do this task: Main Landing Gear Installation, TASK 32-11-00-400-802.

SUBTASK 57-16-06-410-003

- (5) Do this task: Main Landing Gear Wing Door Installation, TASK 32-13-21-420-801.

SUBTASK 57-16-06-410-004

- (6) Do this task: Inboard Trailing Edge Flap Installation, TASK 27-51-11-400-801.

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SUBTASK 57-16-06-640-001

(7) Do this task: Main Landing Gear Support Beam Lubrication, TASK 12-25-07-600-801.

———— **END OF TASK** ————

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MAIN LANDING GEAR SUPPORT BEAM - INSPECTION/CHECK

1. General

A. This procedure has these tasks:

- (1) Landing Gear Support Beam Inspection.
 - (a) To do the inspection, you measure the inner and outer diameters of the bolts and bushings which attach the support beam.
- (2) Main Landing Gear Beam Hanger Link Free Play Check.

TASK 57-16-06-200-801

2. Landing Gear Support Beam Inspection

(Figure 601)

A. **References**

Reference	Title
57-16-06-000-801	Main Landing Gear Support Beam Removal (P/B 401)
57-16-06-400-801	Main Landing Gear Support Beam Installation (P/B 401)

B. **Tools/Equipment**

Reference	Description
STD-1096	Micrometer - Depth, 0-1 inch, Readable to 1/1000 inch
STD-1097	Caliper - Vernier, 0-6 inch, Readable to 1/1000 inch

C. **Location Zones**

Zone	Area
734	Left Main Landing Gear
744	Right Main Landing Gear

D. **Landing Gear Support Beam Inspection**

SUBTASK 57-16-06-020-013

- (1) Do this task: Main Landing Gear Support Beam Removal, TASK 57-16-06-000-801.

SUBTASK 57-16-06-210-001

- (2) Look for worn areas on the bolts and the bushings which attach the support beam (Figure 601).
 - (a) Use a micrometer (0-1 inch, readable to 1/1000 inch), STD-1096, or a vernier caliper (0 - 6 inch, readable to 1/1000 inch), STD-1097, to measure the diameters of the bolts and the bushings.
 - (b) Compare the dimensions you measured, with the permitted dimensions shown in Figure 601.
 - (c) Replace the parts which are out of the tolerance.

SUBTASK 57-16-06-420-013

- (3) Do this task: Main Landing Gear Support Beam Installation, TASK 57-16-06-400-801.

———— **END OF TASK** ————

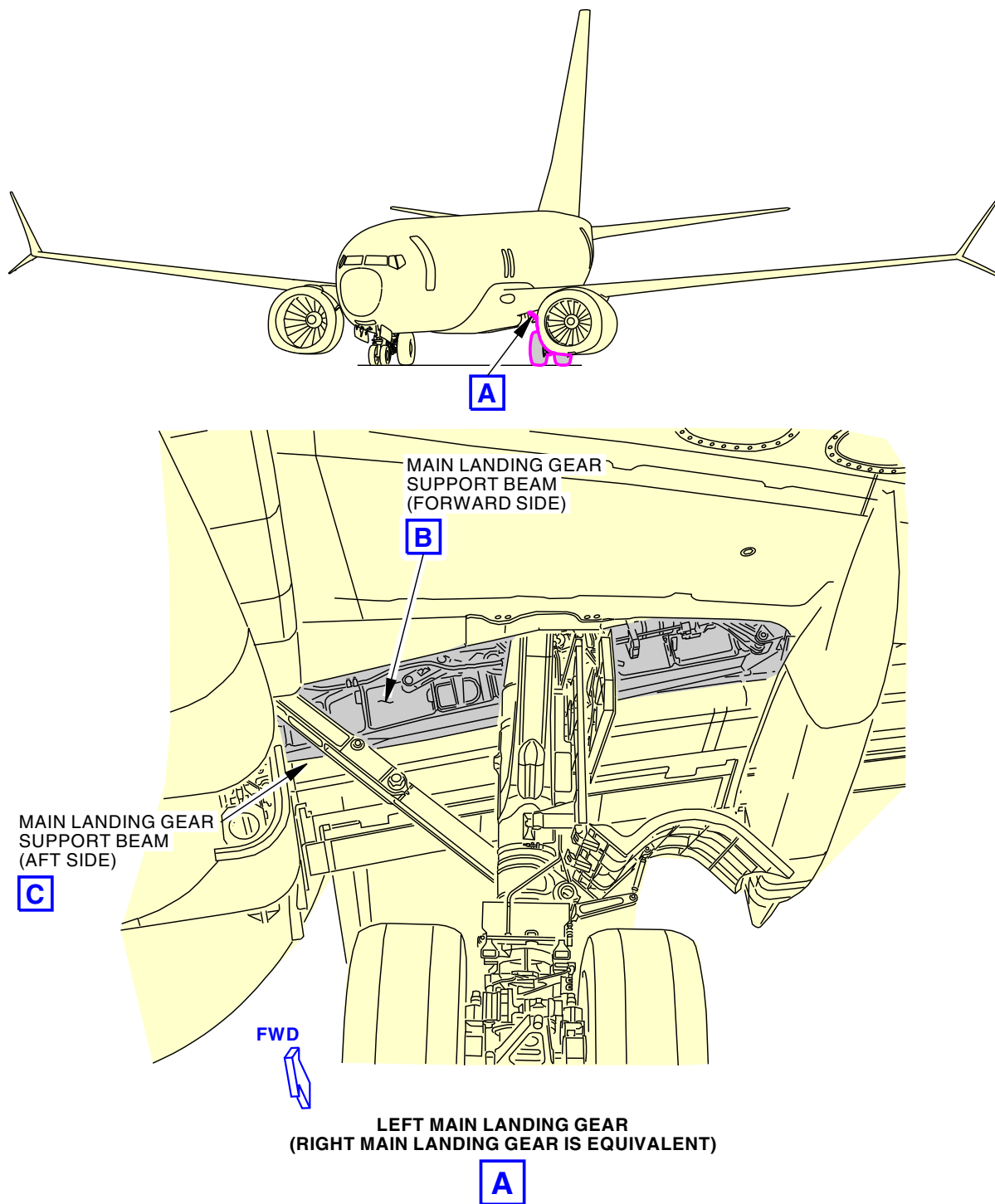
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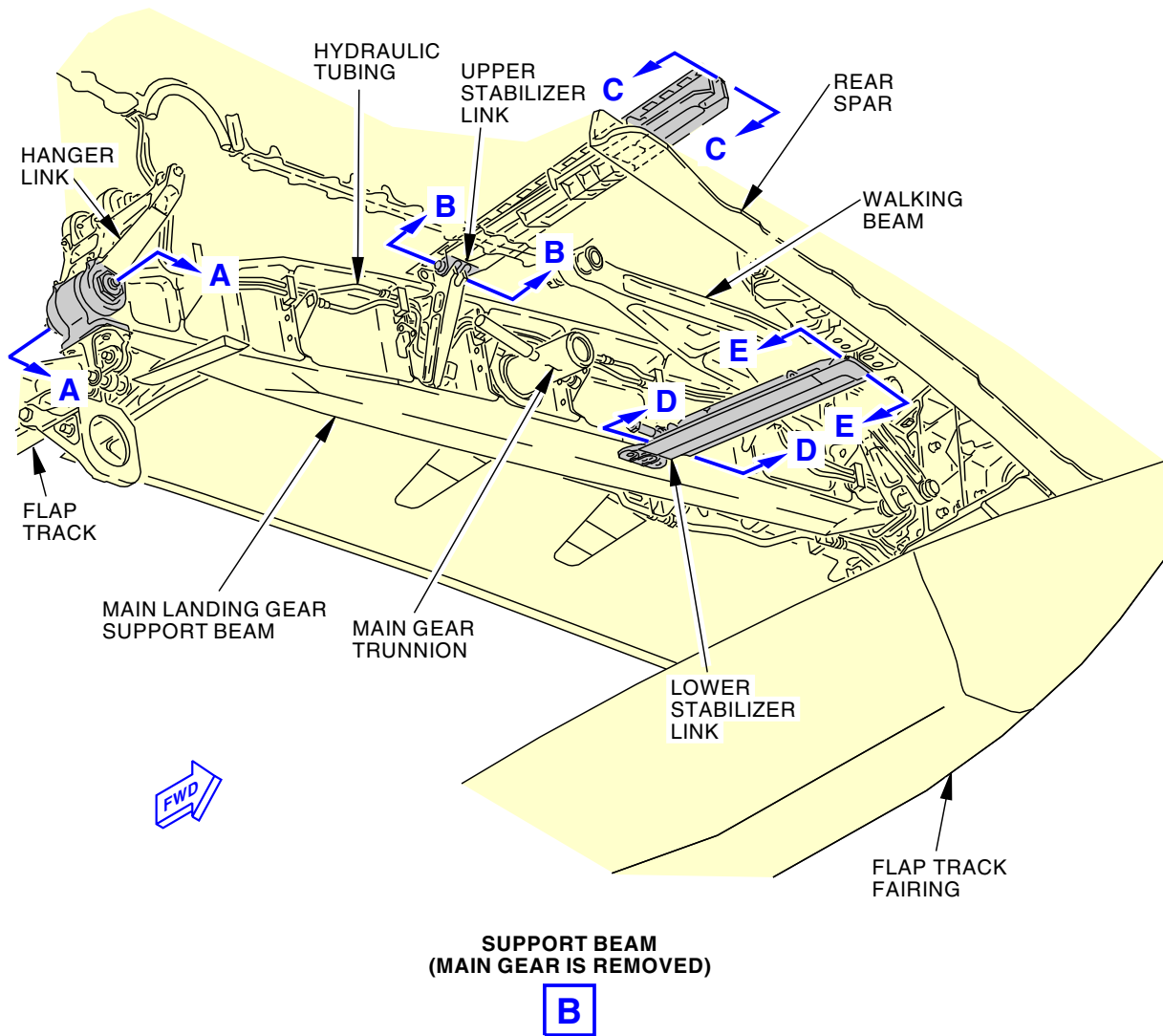
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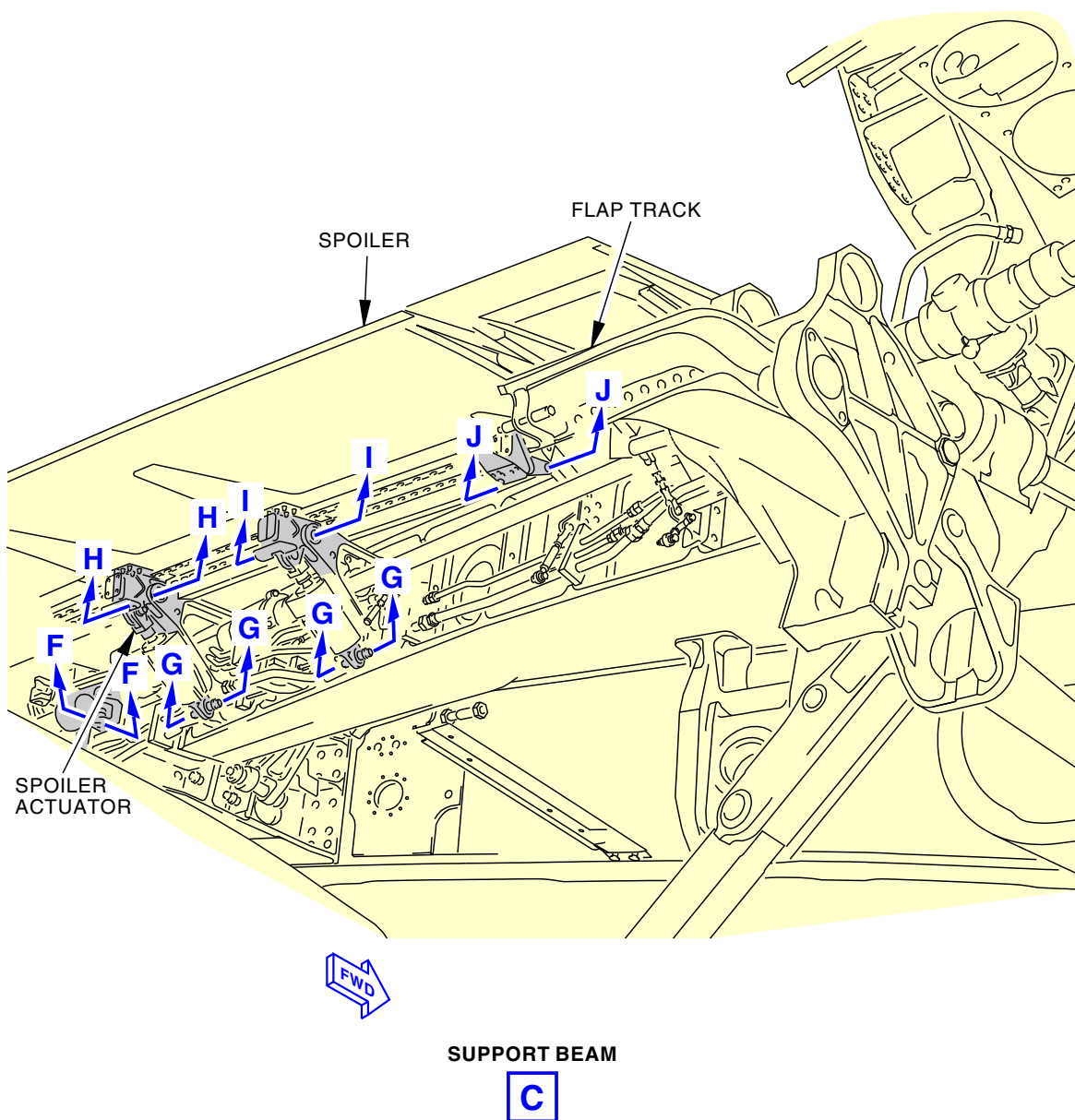
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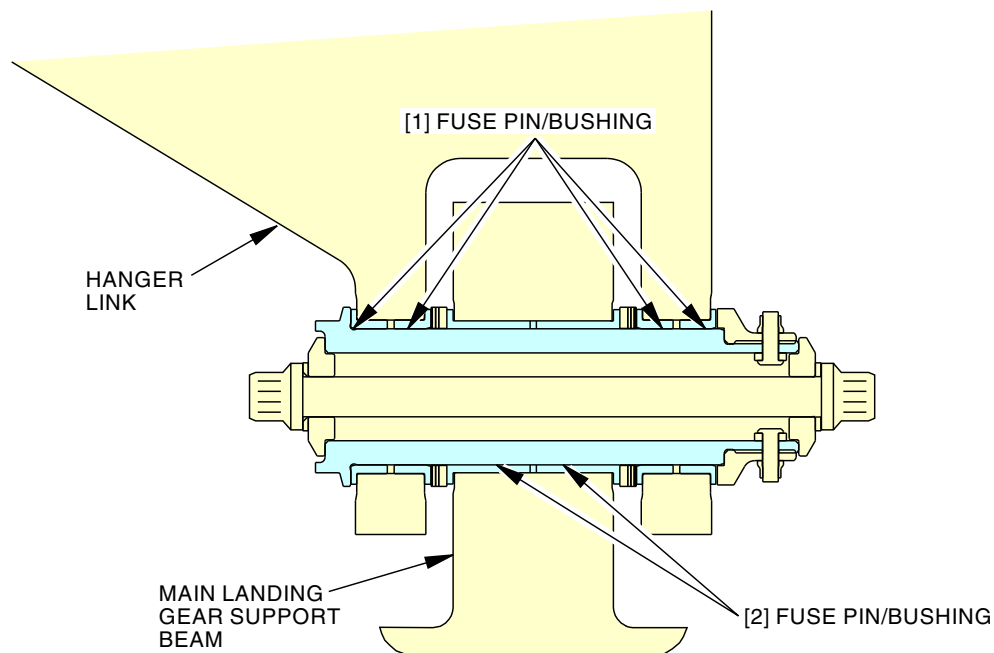
Main Landing Gear Support Beam Inspection
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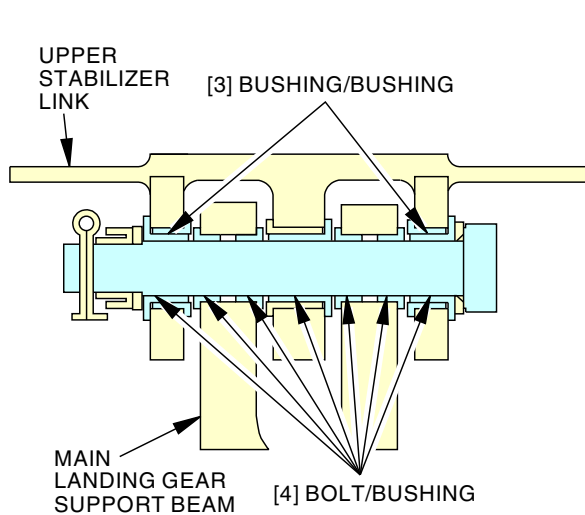
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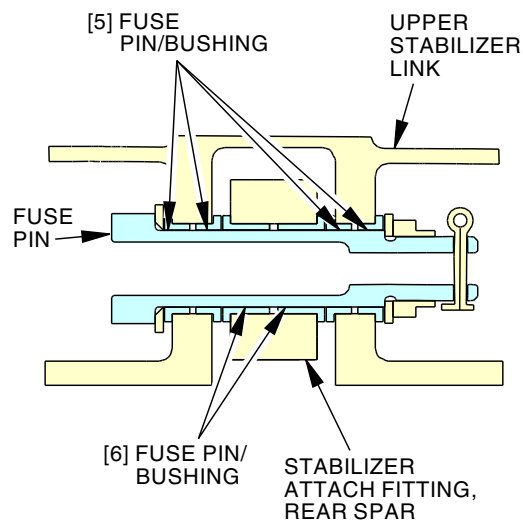
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Main Landing Gear Support Beam Inspection
Figure 601/57-16-06-990-803 (Sheet 4 of 10)

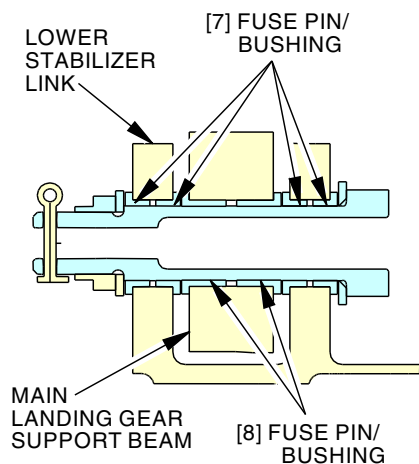
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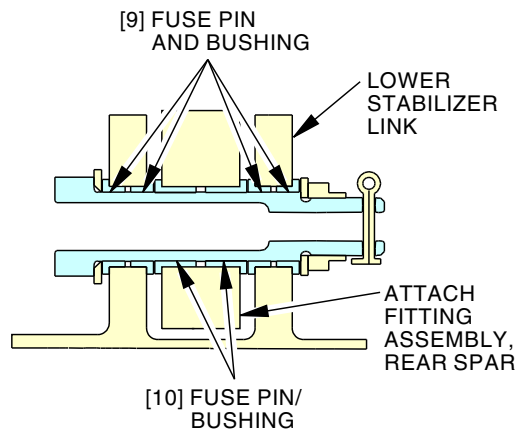
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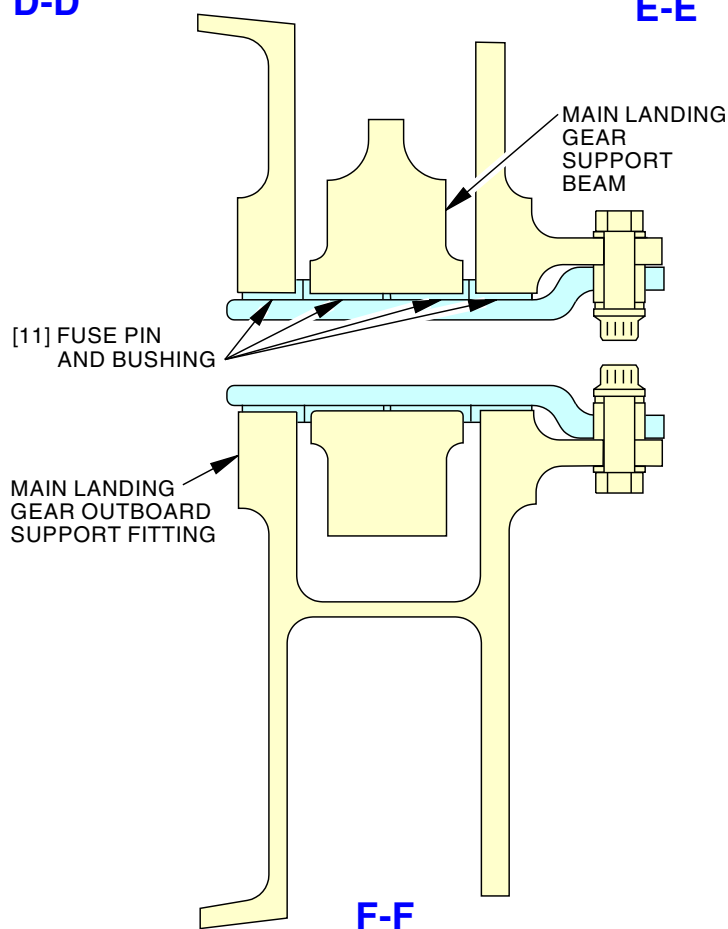
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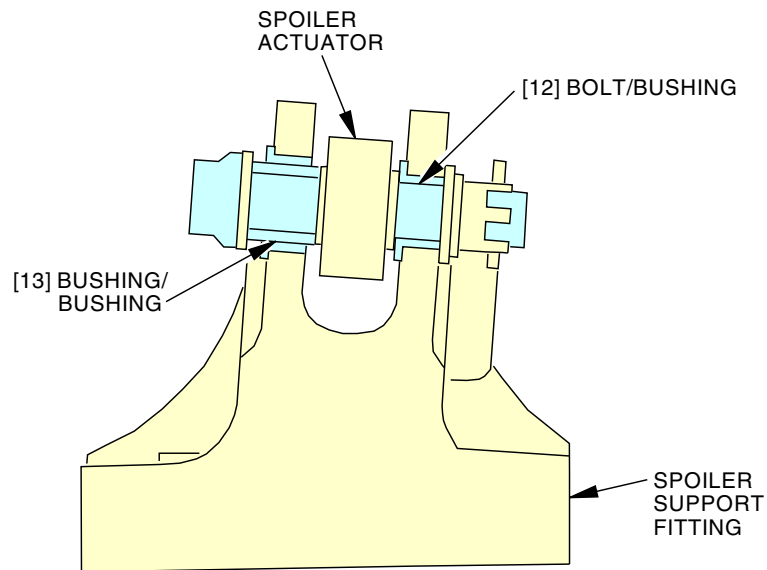
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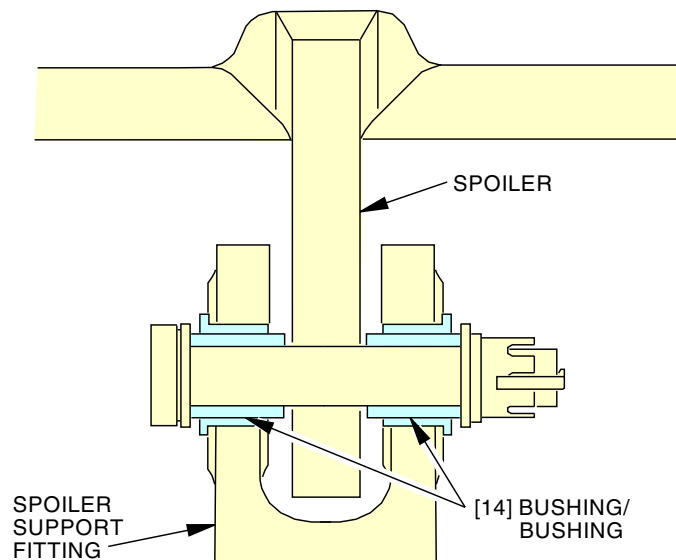
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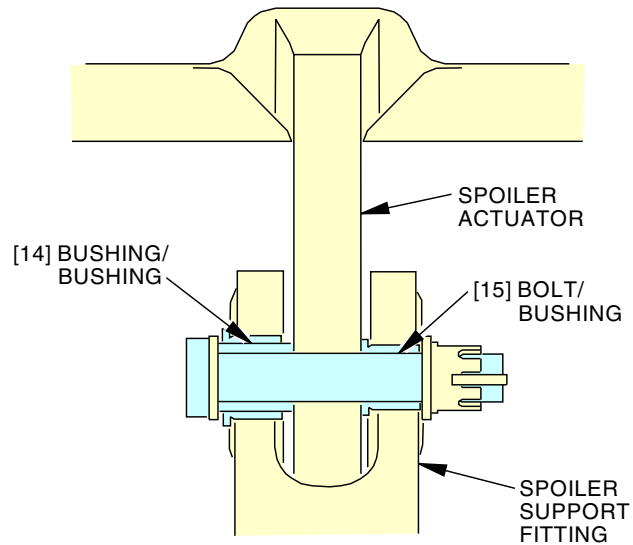
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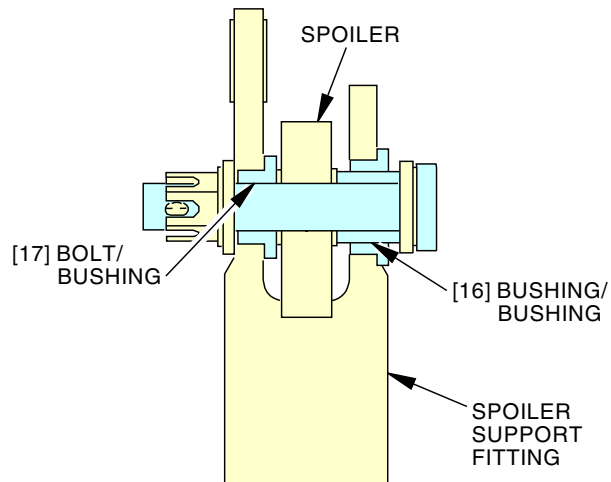
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Main Landing Gear Support Beam Inspection
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INDEX NO.	PART NAME	DIM.	DESIGN LIMITS		WEAR LIMITS		REPLACE WORN PART	REPAIR WORN PART	REPAIR INSTR
			DIAMETER		PERMITTED WEAR DIMENSION INCH (mm)	MAXIMUM DIAMETER CLEARANCE INCH (mm)			
			MINIMUM INCH (mm)	MAXIMUM INCH (mm)					
1	BUSHING	ID	2.1250 (53.975)	2.1262 (54.005)	2.1318 (54.148)	0.0080 (0.203)	X		
	FUSE PIN	OD	2.1232 (53.929)	2.1238 (53.945)	2.1182 (53.802)				
2	BUSHING	ID	2.1250 (53.975)	2.1262 (54.005)	2.1318 (54.148)	0.0080 (0.203)	X		
	FUSE PIN	OD	2.1232 (53.929)	2.1238 (53.945)	2.1182 (53.802)				
3	BUSHING	ID	0.6250 (15.875)	0.6256 (15.890)	-----	0.0000	X		
	BUSHING	OD	0.6261 (15.903)	0.6266 (15.916)	-----		X		
4	BOLT	OD	0.4990 (12.675)	0.4995 (12.687)	0.4962 (12.603)	0.0050 (0.127)	X		
	BUSHING	ID	0.5000 (12.700)	0.5007 (12.718)	0.5045 (12.814)		X		
5	BUSHING	ID	0.7495 (19.037)	0.7505 (19.063)	0.7547 (19.169)	0.0055 (0.140)	X		
	FUSE PIN	OD	0.7472 (18.979)	0.7490 (19.025)	0.7448 (18.918)				
6	BUSHING	ID	0.7495 (19.037)	0.7503 (19.058)	0.7545 (19.164)	0.0055 (0.140)	X		
	FUSE PIN	OD	0.7472 (18.979)	0.7490 (19.025)	0.7448 (18.918)				
7	BUSHING	ID	0.7495 (19.037)	0.7503 (19.058)	0.7545 (19.164)	0.0055 (0.140)	X		
	FUSE PIN	OD	0.7472 (18.979)	0.7490 (19.025)	0.7448 (18.918)				
8	BUSHING	ID	0.7495 (19.037)	0.7503 (19.058)	0.7545 (19.164)	0.0055 (0.140)	X		
	FUSE PIN	OD	0.7472 (18.979)	0.7490 (19.025)	0.7448 (18.918)				

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**Main Landing Gear Support Beam Inspection
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INDEX NO.	PART NAME	DIM.	DESIGN LIMITS		WEAR LIMITS		REPLACE WORN PART	REPAIR WORN PART	REPAIR INSTR
			DIAMETER		PERMITTED WEAR DIMENSION INCH (mm)	MAXIMUM DIAMETER CLEARANCE INCH (mm)			
			MINIMUM INCH (mm)	MAXIMUM INCH (mm)					
9	BUSHING	ID	0.7495 (19.037)	0.7505 (19.063)	0.7545 (19.164)	0.0055 (0.140)	X		1
	FUSE PIN	OD	0.7472 (18.979)	0.7490 (19.025)	0.7448 (18.918)			2	
10	BUSHING	ID	0.7495 (19.037)	0.7503 (19.058)	0.7545 (19.164)	0.0055 (0.140)	X		1
	FUSE PIN	OD	0.7472 (18.979)	0.7490 (19.025)	0.7448 (18.918)			2	
11 3	BUSHING	ID	1.6776 (42.611)	1.6789 (42.644)	-----	-----	X		
	FUSE PIN	OD	1.6765 (42.583)	1.6770 (42.596)	-----			2	
11 4	BUSHING	ID	1.7276 (43.881)	1.7289 (43.914)	-----	-----	X		
	FUSE PIN	OD	1.7265 (43.853)	1.7270 (43.866)	-----			2	
12	BUSHING	ID	0.4375 (11.113)	0.4382 (11.130)	0.4405 (11.189)	0.0035 (0.089)	X		1
	BOLT	OD	0.4360 (11.074)	0.4370 (11.100)	0.4347 (11.041)		X		
13	BUSHING	ID	0.6245 (15.862)	0.6252 (15.880)	0.6275 (15.939)	0.0035 (0.089)	X		1
	BUSHING	OD	0.6235 (15.837)	0.6240 (15.850)	0.6217 (15.791)		X		
14	BUSHING	ID	0.6245 (15.862)	0.6252 (15.880)	0.6273 (15.933)	0.0033 (0.084)	X		1
	BUSHING	OD	0.6235 (15.837)	0.6240 (15.850)	0.6219 (15.796)		X		

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**Main Landing Gear Support Beam Inspection
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INDEX NO.	PART NAME	DIM.	DESIGN LIMITS		WEAR LIMITS		REPLACE WORN PART	REPAIR WORN PART	REPAIR INSTR
			DIAMETER		PERMITTED WEAR DIMENSION INCH (mm)	MAXIMUM DIAMETER CLEARANCE INCH (mm)			
			MINIMUM INCH (mm)	MAXIMUM INCH (mm)					
15	BUSHING	ID	0.4375 (11.113)	0.4382 (11.130)	0.4405 (11.189)	0.0035 (0.089)	X		
	BOLT	OD	0.4360 (11.074)	0.4370 (11.100)	0.4347 (11.041)		X		
16	BUSHING	ID	0.3750 (9.525)	0.3756 (9.540)	0.3773 (9.583)	0.0028 (0.071)	X		
	BUSHING	OD	0.3740 (9.500)	0.3745 (9.512)	0.3728 (9.469)		X		
17	BUSHING	ID	0.2500 (6.350)	0.2505 (6.363)	0.2525 (6.414)	0.0030 (0.0076)	X		
	BOLT	OD	0.2485 (6.312)	0.2495 (6.337)	0.2475 (6.287)		X		

- 1 OVERSIZED BUSHING PERMITTED. SEE APPLICABLE CMM.
- 2 SEE APPLICABLE CMM.
- 3 737-8 AIRPLANES
- 4 737-9 AIRPLANES

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**Main Landing Gear Support Beam Inspection
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TASK 57-16-06-200-802

3. Main Landing Gear Beam Hanger Link Free Play Check

(Figure 602)

A. References

Reference	Title
07-10-01 P/B 201	JACK AIRPLANE - MAINTENANCE PRACTICES
29-11-00-860-801	Hydraulic System A or B Pressurization (P/B 201)
29-11-00-860-805	Hydraulic System A or B Power Removal (P/B 201)
32-00-01-480-801	Landing Gear Downlock Pins Installation (P/B 201)
57-16-06-000-801	Main Landing Gear Support Beam Removal (P/B 401)
57-16-06-400-801	Main Landing Gear Support Beam Installation (P/B 401)

B. Tools/Equipment

Reference	Description
STD-11969	Dial Indicator - 0.001 inch graduations
STD-12481	5.0 inch x 1.1 inch x 0.25 inch aluminum plate

C. Location Zones

Zone	Area
734	Left Main Landing Gear
744	Right Main Landing Gear

D. Prepare for the Check

SUBTASK 57-16-06-480-003



MAKE SURE THAT THE DOWNLOCK PINS ARE INSTALLED ON ALL THE LANDING GEAR. WITHOUT THE DOWNLOCK PINS, THE LANDING GEAR CAN RETRACT. THIS CAN CAUSE INJURIES TO PERSONS, AND DAMAGE TO EQUIPMENT.

- (1) Make sure that the downlock pins are installed on the nose and main landing gear (TASK 32-00-01-480-801).

SUBTASK 57-16-06-860-005

- (2) Put the airplane on jacks (PAGEBLOCK 07-10-01/201).

SUBTASK 57-16-06-010-008

- (3) Get access to the Main Landing Gear (MLG) support beam lower flange.

SUBTASK 57-16-06-480-002



MAKE CERTAIN LANDING GEAR DOWNLOCK PINS ARE INSTALLED TO PREVENT INADVERTENT RETRACTION OF LANDING GEAR, AND POSSIBLE INJURY TO PERSONNEL.

- (4) Do these steps to prepare the measuring equipment (Figure 602).

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MAKE SURE THAT YOU INSTALL THE WHEEL WELL SUPPORT ROD BEFORE THE LANDING GEAR OPERATION. IF YOU DO NOT OBEY, DAMAGE TO THE SUPPORT ROD AND STRUCTURE CAN OCCUR DURING THE LANDING GEAR OPERATION.

- (a) If it is necessary, disconnect the support rod from the wheel well structure to give more space for tool installation.
- (b) Put an aluminum plate, STD-12481, on the top surface of the MLG support beam lower flange between the attach bolts.
 - 1) Attach the aluminum plate, STD-12481, with welding vice grips.
- (c) Attach a dial indicator, STD-11969, to the hangar link at the MLG support beam attach point using lock pliers.
- (d) Put the dial indicator, STD-11969, vertically with the plunger on the aluminum plate, STD-12481.



KEEP PERSONNEL AND EQUIPMENT AWAY FROM THE FLIGHT CONTROL SURFACES, THE THRUST REVERSERS, AND THE LANDING GEAR. THESE COMPONENTS CAN MOVE SUDDENLY WHEN YOU SUPPLY HYDRAULIC POWER. THIS CAN CAUSE INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT.

- (e) For hydraulic system A, do this task: Hydraulic System A or B Pressurization, TASK 29-11-00-860-801.
- (f) In the landing gear lever DN position, set the dial indicator, STD-11969, to zero when the plunger touches the aluminum plate, STD-12481.

E. Main Landing Gear Beam Hanger Link Free Play Check

SUBTASK 57-16-06-200-004



MAKE CERTAIN LANDING GEAR DOWNLOCK PINS ARE INSTALLED TO PREVENT INADVERTENT RETRACTION OF LANDING GEAR, AND POSSIBLE INJURY TO PERSONNEL.

- (1) In the landing gear lever UP position, read the dial indicator, STD-11969, to find the vertical movement between the hangar link and the MLG support beam.

SUBTASK 57-16-06-211-001

- (2) Record the free play dimension (Figure 602).
 - (a) If the free play is less than 0.050 in. (1.270 mm), do an inspection at no more than 10 years or 21,000 cycles which ever occurs first.
 - (b) For hydraulic system A, do this task: Hydraulic System A or B Power Removal, TASK 29-11-00-860-805.
 - (c) If the free play is more than 0.05 in. (1.270 mm), do these steps:
 - 1) Disassemble the joint (TASK 57-16-06-000-801).
 - 2) Measure the maximum inner diameter and the minimum wall thickness of the hangar link and landing gear bushings.

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- 3) Do a detailed visual inspection of the pin and bushings for wear (TASK 57-16-06-200-801).

NOTE: If damage other than worn bushings is found, contact Boeing for more repair instructions.

- a) If they are worn, replace the bushings.

NOTE: If a bushing is replaced on a part of the hanger link or the landing gear beam, replace all worn bushings common to that part.

- b) If it is damaged, replace the pin.

NOTE: A small discoloration because of the material transfer from the bushing to the pin is permitted.

- 4) Make sure that the joint area is clean and free of unwanted material.

- a) Remove all the remaining grease, unwanted material and other contamination.

- 5) Add grease to the joint.

- 6) Assemble the joint (TASK 57-16-06-400-801).

- (3) Do an inspection of the free play.

- (a) Make sure that the free play is 0.05 in. (1.27 mm) or less.

SUBTASK 57-16-06-420-014



MAKE SURE THAT YOU INSTALL THE WHEEL WELL SUPPORT ROD BEFORE THE LANDING GEAR OPERATION. IF YOU DO NOT OBEY, DAMAGE TO THE SUPPORT ROD AND STRUCTURE CAN OCCUR DURING THE LANDING GEAR OPERATION.

- (4) If removed, connect the support rod to the wheel well structure.

———— **END OF TASK** ————

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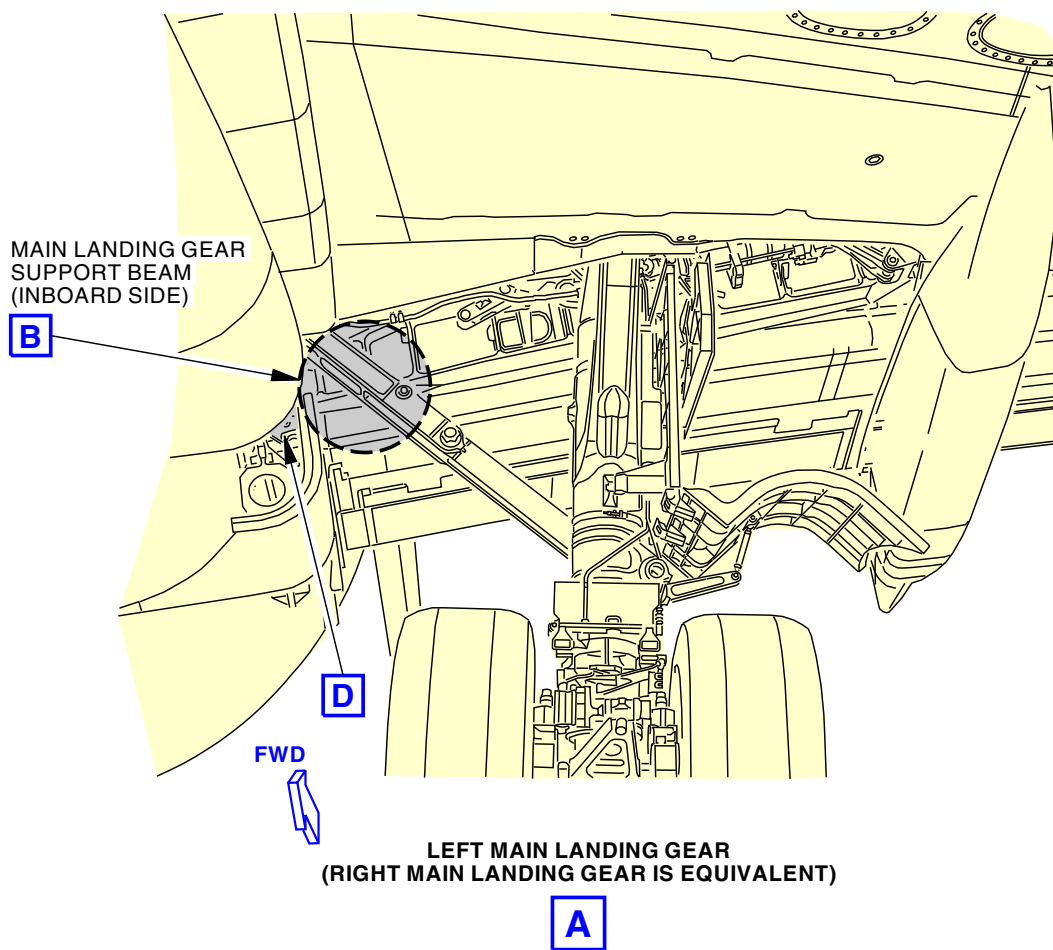
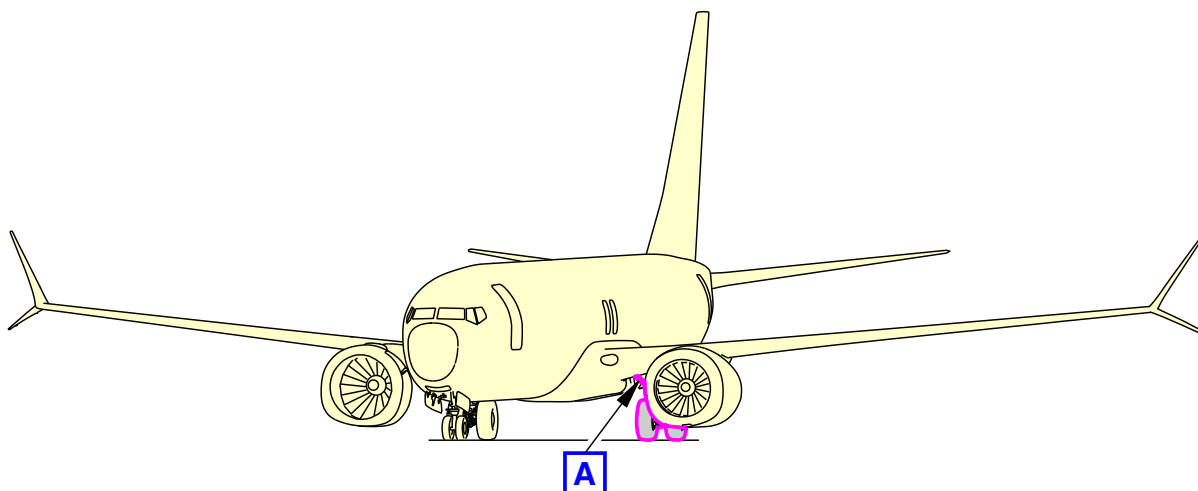
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Main Landing Gear Beam Hanger Link Free Play Check
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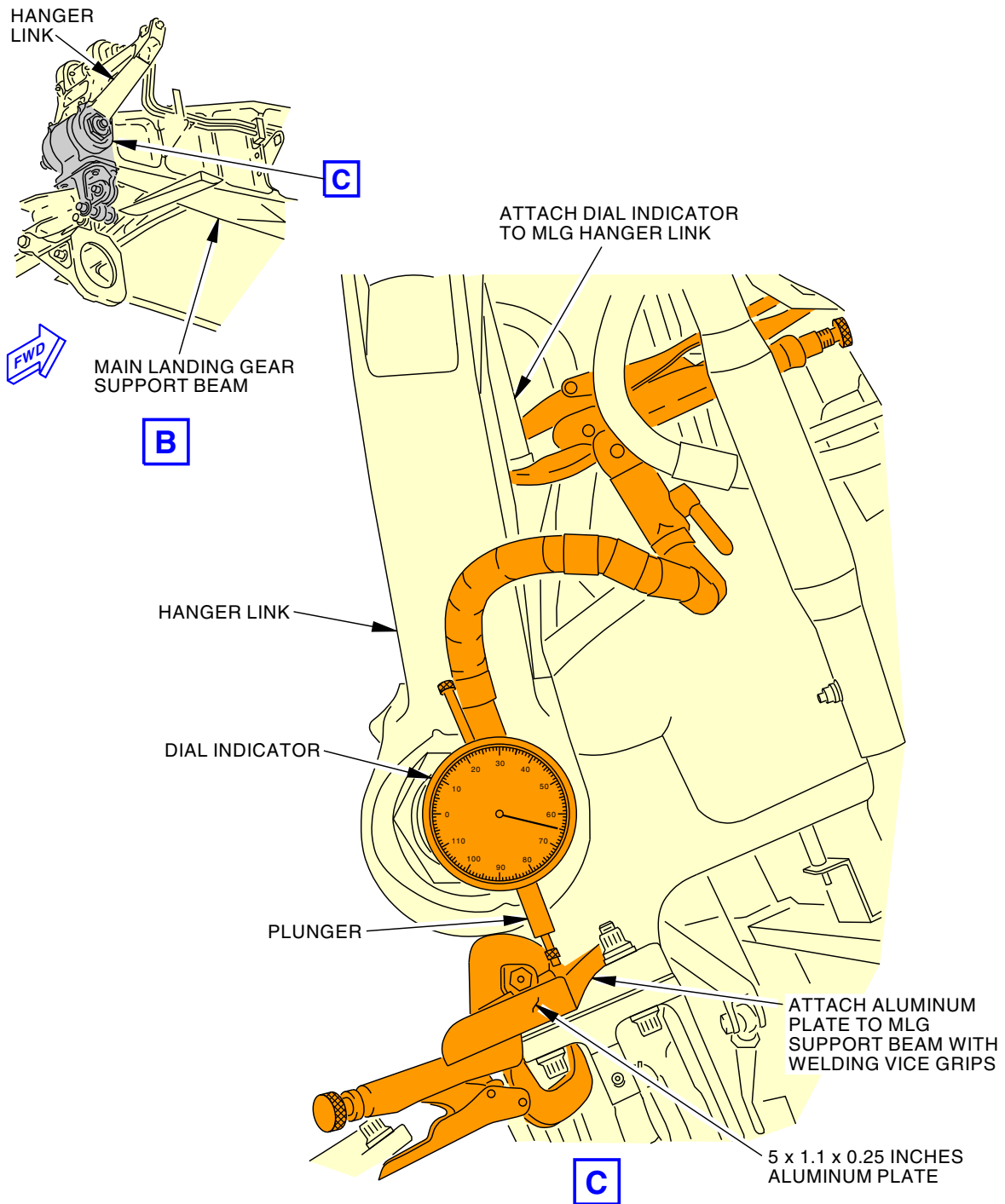
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Main Landing Gear Beam Hanger Link Free Play Check
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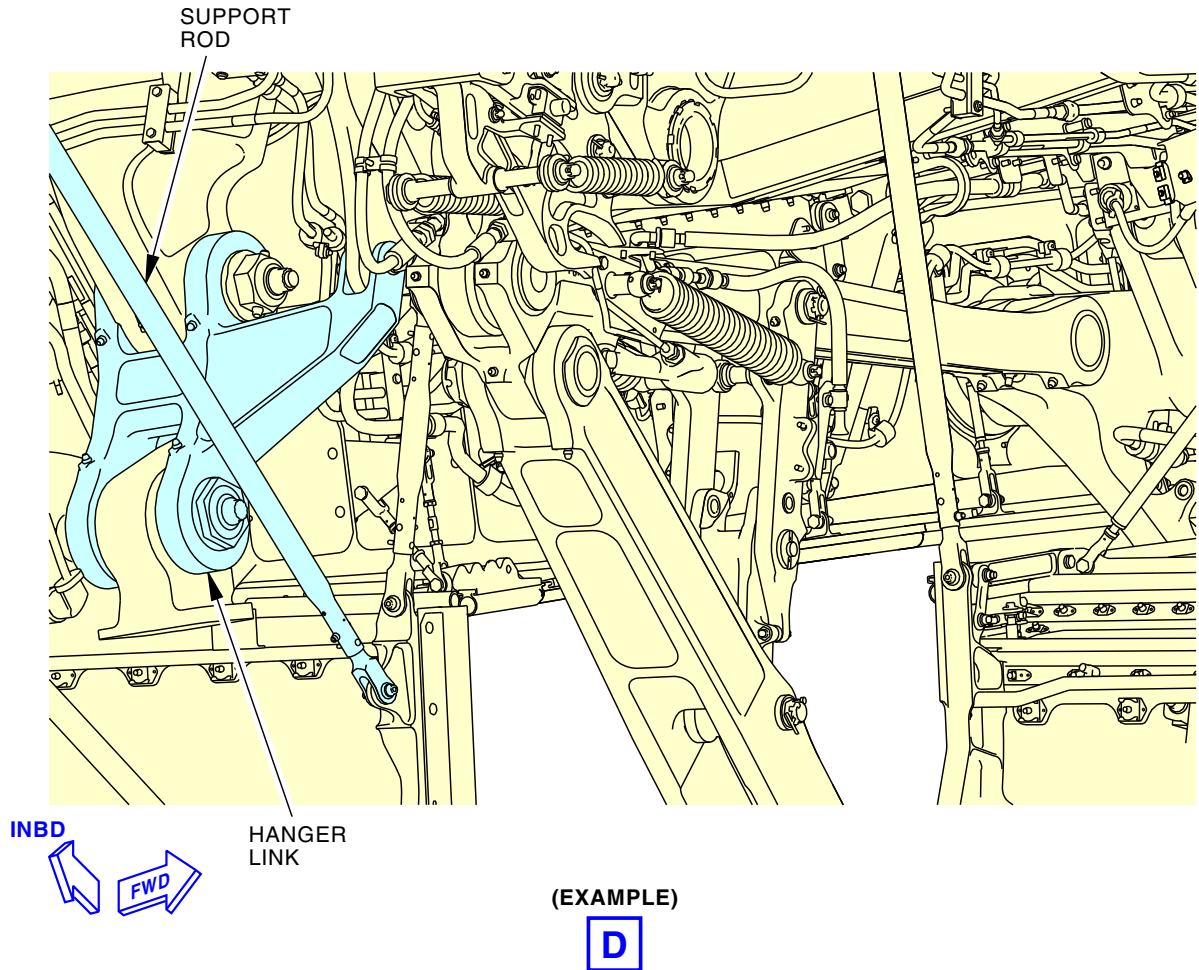
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Main Landing Gear Beam Hanger Link Free Play Check
Figure 602/57-16-06-990-804 (Sheet 3 of 3)

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**MAIN LANDING GEAR SUPPORT BEAM HANGER LINKS UPPER AND LOWER PIN - REMOVAL/
INSTALLATION**

1. General

A. This procedure has these tasks:

- (1) Main Landing Gear Support Beam Hanger Links Upper And Lower Pin Removal.
- (2) Main Landing Gear Support Beam Hanger Links Upper And Lower Pin Installation.

NOTE: The procedure involves placing the aircraft on jacks to support the landing gear beam and getting access to the support beam lower flange to replace the upper and lower pins.

NOTE: It is not necessary to remove the hanger links during the procedure.

TASK 57-16-07-000-801

2. Main Landing Gear Support Beam Hanger Links Upper And Lower Pin Removal

A. References

Reference	Title
07-10-01-580-801	Lift the Airplane on Jacks (P/B 201)
32-00-01-480-801	Landing Gear Downlock Pins Installation (P/B 201)
57-16-06 P/B 601	MAIN LANDING GEAR SUPPORT BEAM - INSPECTION/CHECK
57-16-06-000-801	Main Landing Gear Support Beam Removal (P/B 401)

B. Tools/Equipment

Reference	Description
STD-600	Mirror - Inspection

C. Consumable Materials

Reference	Description	Specification
G50316	Cloth - Clean, Dry, Lint-free, White, Cotton	

D. Location Zones

Zone	Area
734	Left Main Landing Gear
734	Left Main Landing Gear

E. Prepare for the Removal

SUBTASK 57-16-07-420-001



MAKE SURE THAT YOU INSTALL THE DOWNLOCK PINS ON ALL THE LANDING GEAR. WITHOUT THE DOWNLOCK PINS, THE LANDING GEAR CAN RETRACT AND CAUSE INJURIES TO PERSONS AND DAMAGE TO EQUIPMENT.

- (1) If the downlock pins are not installed in the nose and main landing gear, do this task: Landing Gear Downlock Pins Installation, TASK 32-00-01-480-801.

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SUBTASK 57-16-07-580-001



MAKE SURE THAT YOU RELEASE THE PARKING BRAKE BEFORE YOU LIFT OR LOWER THE AIRPLANE WITH JACKS. IF YOU DO NOT OBEY, DAMAGE TO THE AIRPLANE AND EQUIPMENT CAN OCCUR.



MAKE SURE THAT YOU REMOVE THE WHEEL CHOCKS BEFORE YOU LIFT OR LOWER THE AIRPLANE WITH JACKS. IF YOU DO NOT REMOVE BLOCKAGES AROUND THE MAIN LANDING GEAR, DAMAGE TO THE AIRPLANE AND EQUIPMENT CAN OCCUR.

- (2) Do this task: Lift the Airplane on Jacks, TASK 07-10-01-580-801.

NOTE: Do not rest the MLG beam directly against a metal jack pad. Use a wooden block or similar to protect the MLG beam from damage. Support the MLG beam with a jack so that the load against the hanger link can be adjusted to facilitate removal of the hanger link bolts.

NOTE: Do not allow the jack to depressurize or adjust the jacks supporting the airplane while the hanger link pins are removed as this could cause unacceptable preload against interfacing structural and system elements.

SUBTASK 57-16-07-010-001

- (3) Get access to the main landing gear support beam lower flange.

F. Main Landing Gear Support Beam Hanger Links Upper and Lower Pins Removal

SUBTASK 57-16-07-020-001

- (1) Disconnect the lower and upper pins from the support beam, do these steps:



MAKE SURE THAT YOU INSTALL THE DOWNLOCK PINS IN THE MAIN LANDING GEAR. WITHOUT THE DOWNLOCK PINS, THE MAIN LANDING GEAR CAN RETRACT AND CAUSE INJURIES TO PERSONS AND DAMAGE TO EQUIPMENT.

- (a) Remove the nut [10], washer [11], bolt [1], countersunk washer [2], caps [3], collars [13], bolts [8], radius fillers [9], nut [12], lower pin [4], washers [7], washers [6], and washers [5] from the hanger link [26].
- 1) Keep all of the washers.

NOTE: Make a note of the location of all the washers.

- (b) Remove the nut [14], washer [15], bolt [22], countersunk washer [21], caps [20], collars [18], bolts [16], radius fillers [17], nut [19], upper pin [23].

SUBTASK 57-16-07-211-001

- (2) Do a detailed visual inspection of the bushings [24] and bushings [25] inner surfaces, for wear (View D-D, Figure 401).
- (a) Remove the grease and other contamination from the inner surfaces of bushings [24] and bushings [25] with cotton cloth, G50316.
- (b) Use the inspection mirror, STD-600, or any other suitable, for visual inspection of the areas hidden to eyes.
- (c) If they are worn, replace the bushings (PAGEBLOCK 57-16-06/601).

NOTE: If a bushing is replaced on a part of the hanger link, the frame, or the landing gear beam, replace all worn bushings common to that part.

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- (d) If it is necessary to remove the hanger link [26] for repair or replacement, refer to: Main Landing Gear Support Beam Removal, TASK 57-16-06-000-801.

———— **END OF TASK** ————

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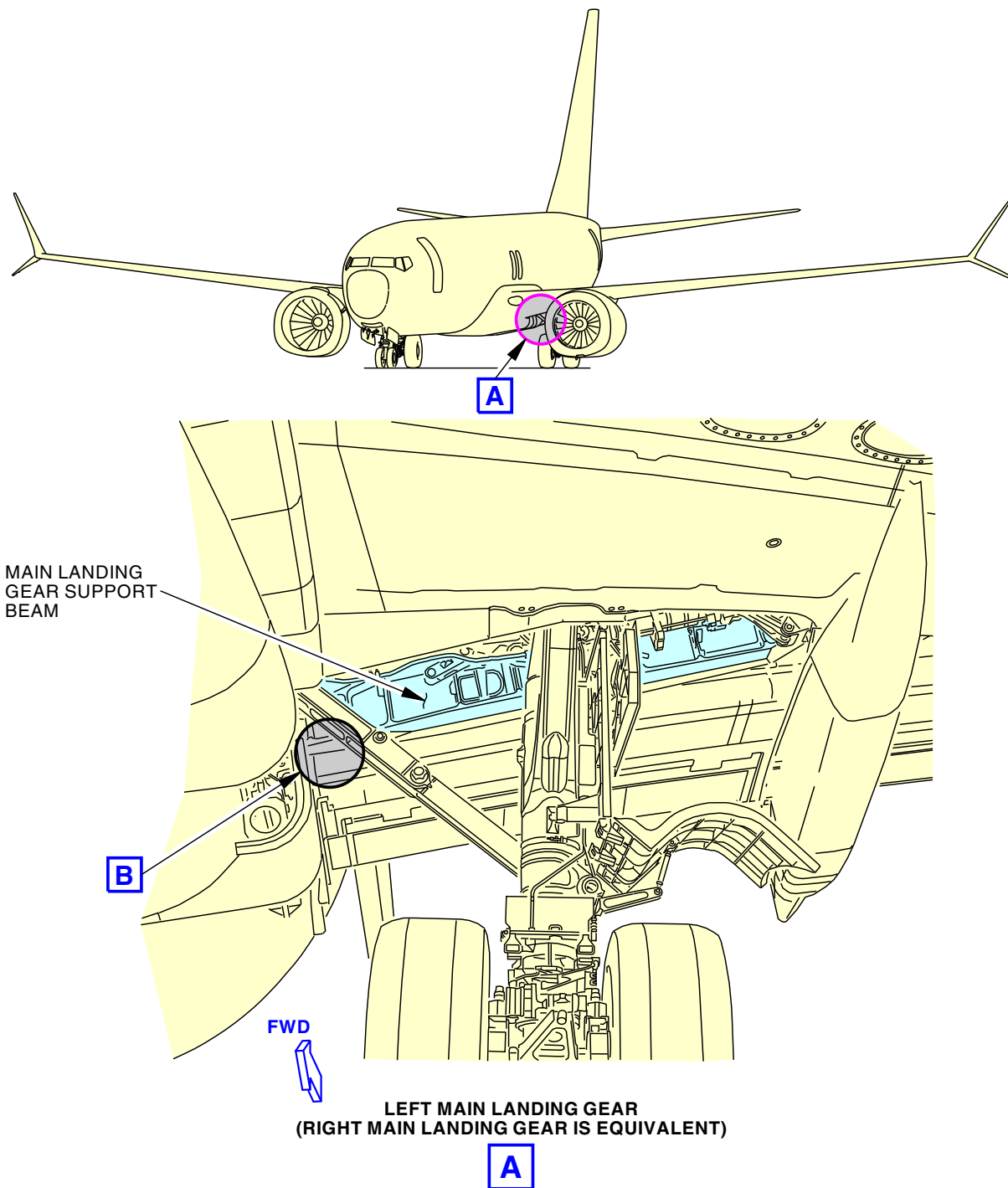
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Main Landing Gear Beam Support Hanger Links Upper and Lower Pins Installation
Figure 401/57-16-07-990-801 (Sheet 1 of 4)

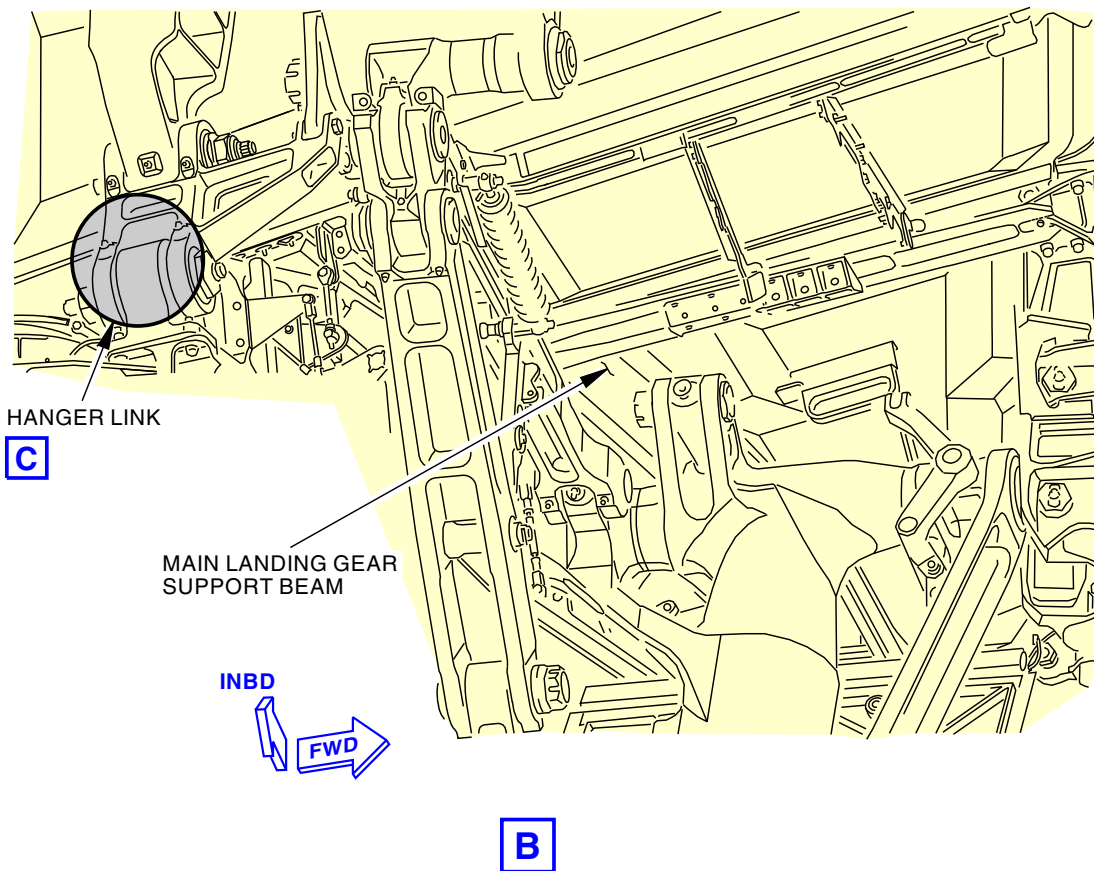
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Main Landing Gear Beam Support Hanger Links Upper and Lower Pins Installation
Figure 401/57-16-07-990-801 (Sheet 2 of 4)

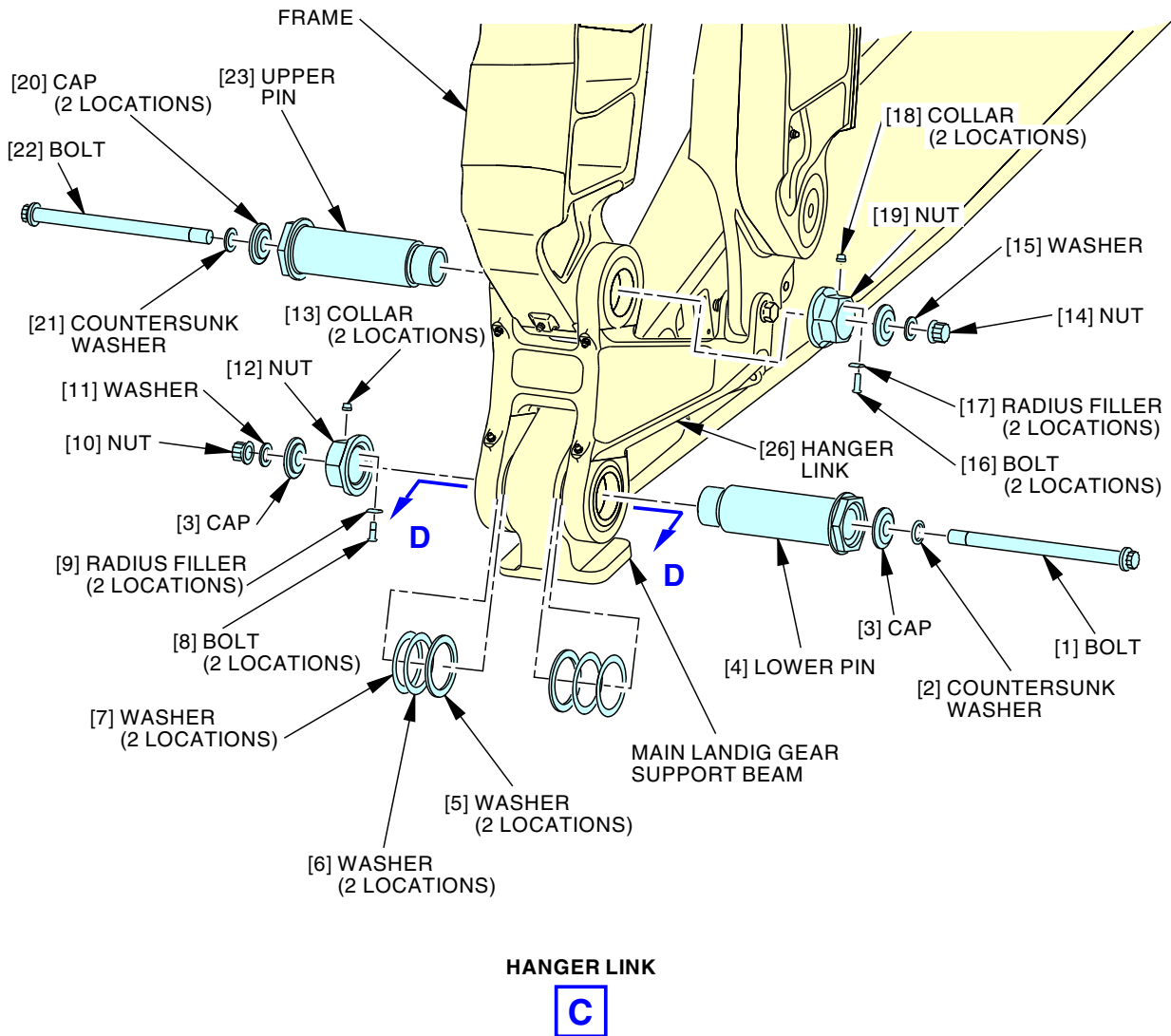
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Main Landing Gear Beam Support Hanger Links Upper and Lower Pins Installation
Figure 401/57-16-07-990-801 (Sheet 3 of 4)

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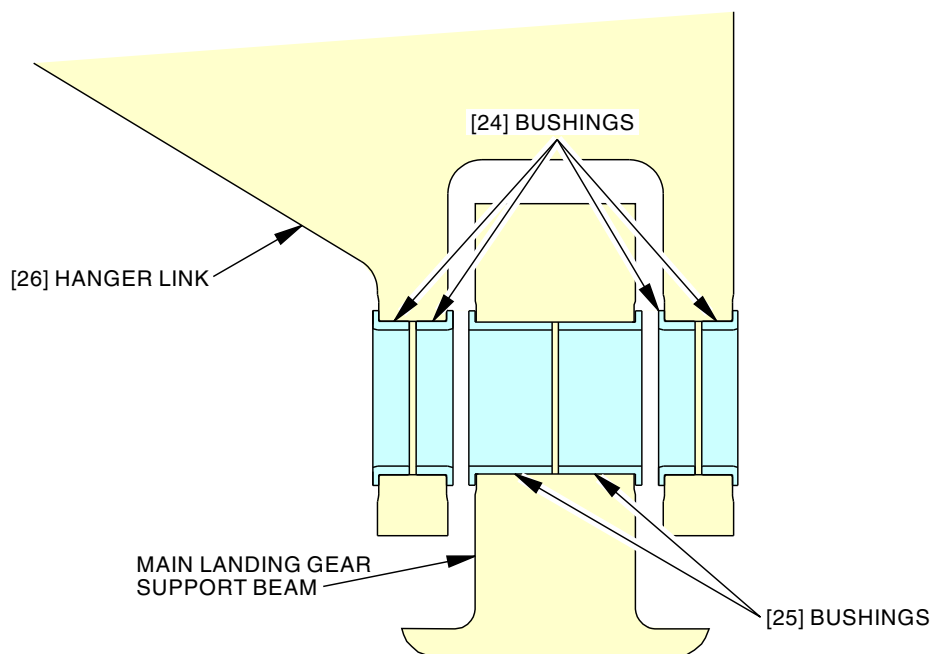
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**HANGER LINK JOINTS
(LOWER PIN JOINT IS SHOWN, UPPER JOINT IS EQUIVALENT)**

D-D

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Main Landing Gear Beam Support Hanger Links Upper and Lower Pins Installation
Figure 401/57-16-07-990-801 (Sheet 4 of 4)

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TASK 57-16-07-400-801

3. Main Landing Gear Support Beam Hanger Links Upper and Lower Pin Installation

A. References

Reference	Title
07-10-01-580-802	Lower the Airplane off Jacks (P/B 201)
57-16-06-200-802	Main Landing Gear Beam Hanger Link Free Play Check (P/B 601)

B. Consumable Materials

Reference	Description	Specification
D00633	Grease - Aircraft General Purpose	BMS3-33

C. Location Zones

Zone	Area
734	Left Main Landing Gear
734	Left Main Landing Gear

D. Procedure

SUBTASK 57-16-07-640-001

- (1) Put the hanger link [26] in its position.
 - (a) Before you install the upper pin [23] and lower pin [4], apply a thin layer of the grease, D00633 to its outer diameters and threads.

SUBTASK 57-16-07-420-002

- (2) Install the upper pin [23].
 - (a) Install the upper pin [23] and nut [19] on the hanger link [26].
 - 1) Tighten the nut [19] to 1500 $\pm$ 45 in-lb (169.5 $\pm$ 5.1 N·m).
 - (b) Install the bolts [16], radius fillers [17] and new collars [18] on the hanger link [26].
 - (c) Install the bolt [22], countersunk washer [21], caps [20], washer [15], and the nut [14].
 - 1) Tighten the nut [14] to 1100 $\pm$ 33 in-lb (124.3 $\pm$ 3.7 N·m).

SUBTASK 57-16-07-420-003

- (3) Install the lower pin [4].
 - (a) Install the washers [5], washers [6], washers [7], lower pin [4] and nut [12] on the hanger link [26].
 - 1) Install the washers [5], washers [6], and washers [7], between the bushings [24] and bushings [25] flanges at each side of the support beam to reduce the gap to a minimum of 0.005 in. (0.127 mm) per side and 0.025 in. (0.635 mm) maximum total for both sides.
 - 2) Tighten the nut [12] to 1500 $\pm$ 45 in-lb (169.5 $\pm$ 5.1 N·m).
 - (b) Install the radius fillers [9], bolts [8], and new collars [13] on the hanger link [26].
 - (c) Install the bolt [1], countersunk washer [2], caps [3], washer [11], and nut [10].
 - 1) Tighten the nut [10] to 1100 $\pm$ 33 in-lb (124.3 $\pm$ 3.7 N·m).

SUBTASK 57-16-07-640-002

- (4) Apply grease, D00633 through all the grease fittings on the hanger link [26] until the grease comes out.

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SUBTASK 57-16-07-200-001

- (5) Do this task: Main Landing Gear Beam Hanger Link Free Play Check,
TASK 57-16-06-200-802.

E. Put the Airplane Back to Its Usual Condition

SUBTASK 57-16-07-580-002



MAKE SURE THAT YOU RELEASE THE PARKING BRAKE BEFORE YOU LIFT OR LOWER THE AIRPLANE WITH JACKS. IF YOU DO NOT OBEY, DAMAGE TO THE AIRPLANE AND EQUIPMENT CAN OCCUR.



MAKE SURE THAT YOU REMOVE THE WHEEL CHOCKS BEFORE YOU LIFT OR LOWER THE AIRPLANE WITH JACKS. IF YOU DO NOT REMOVE BLOCKAGES AROUND THE MAIN LANDING GEAR, DAMAGE TO THE AIRPLANE AND EQUIPMENT CAN OCCUR.

- (1) Do this task: Lower the Airplane off Jacks, TASK 07-10-01-580-802.

———— **END OF TASK** ————

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OUTER WING - CORROSION PREVENTION

1. General

- A. The outer wing consists of the structural units and components and members which support the airplane in flight. These include spars, skins, ribs, stringers, etc., and integral fuel tank structures.
- B. The front and rear spars on the left and right wing boxes are primary structural components of the main wing frame. They extend from the wing root rib to the wingtip. The spars consist of vertical sheet metal webs tapering down in depth towards the wingtips and provided with chords along the upper and lower edges. Vertical stiffeners are attached to the vertical faces of the spar.
 - (1) The deployment of flight control surfaces exposes the spars to the ground air contaminants, thrust reverser soot, runway dirt and debris, and inclement weather elements all of which may cause corrosion.
 - (2) The spar chords are particularly susceptible to corrosion originating most likely at the fasteners common to the chord and web.
 - (3) Stress corrosion cracks can occur on the front and rear spar upper chords.
 - (4) Stress corrosion cracks can occur on the Krueger flap actuator support fittings mounted on the front spars.
 - (5) Stress corrosion cracks can occur in the right outboard trailing edge midflap at WBL 399.85. The cracks can occur in the flap rear spar and were 1.15 in. (29.21 mm) and 3.38 in. (85.85 mm) long, with the shorter crack through the two flap track attach holes
 - (6) Stress corrosion cracks can occur in the aft lug of the engine mount outboard support bracket which attaches to the wing front spar. Corrosion can also occur between the bushing and the lug bore.
 - (7) Exfoliation corrosion can occur on the back side of the front spar upper chord vertical flange at the interface with the spar web surface at approximately FSS 430, and between FSS 150 and 212.
 - (8) Corrosion can occur between RSS 250 and 499 upper rear spar chords.
 - (9) Corrosion can occur around fastener heads in the front and rear spar cavities on airplanes operating in warm moist climatic conditions. Corrosion can occur on aluminum fasteners located in the upper and lower spar chords.
 - (10) Stress corrosion cracks can occur in the lower wing panel stringer-to-rib splice fittings (WBL 70.85) at left wing stringers 5 and 7, and right stringers 5 and 10. These cracks can occur in the fillet between the vertical and horizontal flanges of the fittings.
- C. Corrosion can occur on the interior surfaces of the wing. This corrosion is usually caused by microbial growth which requires the presence of water in the tank
- D. Inter granular corrosion can occur on the wing lower skin in the area of the reserve and main tank access door cutouts. This is caused by exposed aluminum end grain combined with fretting between the access panel and the wing lower skin. Corrosion can occur on the wing lower skin faying surface adjacent to the access door clamp ring. Cracks can start in the machined radius of the wing skin which may extend parallel to the skin surface.

TASK 57-20-00-910-801

2. Outer Wing - Corrosion Prevention

A. General

- (1) Make the regular inspection to prevent or find the start of corrosion. Missing fasteners, white powdery, or other corrosion products are signs of corrosion. Start the corrosion prevention procedures to decrease the occurrence of corrosion.

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- (2) After you clean the suspected areas PAGEBLOCK 51-21-31/701, do a full inspection to make sure that the protective finishes are intact.
- (3) Where corrosion exists (noticeable bulges of the skin or white deposits of corrosion products at fastener heads or joint edges), refer to Structural Repair Manual for instructions to remove corrosion.
- (4) For minor corrosion, to minimize the downtime of the airplane, the corrosion products should be cleaned off, followed by the application of a corrosion inhibiting compound into the affected area to decrease the corrosion process. Refer to PAGEBLOCK 51-21-91/701 for instructions to apply corrosion inhibiting compound. The finish system should be repaired at the next maintenance opportunity.

B. References

Reference	Title
12-20-01-640-801	General Instructions for Lubrication (P/B 301)
51-21-31 P/B 701	CORROSION REMOVAL AND CONTROL - CLEANING/PAINTING
51-21-91 P/B 701	CORROSION INHIBITING COMPOUND - CLEANING/PAINTING

C. Consumable Materials

Reference	Description	Specification
D50050	Grease - Multipurpose, Helicopter Oscillating Bearing Grease with Calcium Soap Thickener - Aeroshell 14	MIL-G-25537
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23
G50237	Compound - Corrosion Inhibiting, Non-drying - Cor-Ban 27L	BMS3-38

D. Location Zones

Zone	Area
500	Left Wing
600	Right Wing

E. Procedure

SUBTASK 57-20-00-370-001

- (1) At the next maintenance opportunity, apply corrosion prevention treatment to the front and rear spars, wing internal structure, and the fuel tank and boost pump access cutout.

SUBTASK 57-20-00-200-001

- (2) Replace damaged or broken finishes.

NOTE: When refinishing the areas around fasteners, inspect around fasteners to ensure that corrosion is not present and apply fillet seal around fasteners prior to paint finishing.

SUBTASK 57-20-00-910-001

- (3) Do these steps to prevent corrosion on front spar and rear spar:
 - (a) Apply corrosion inhibiting compound to the forward surface areas of the front spar. Pay particular attention to spar chord and web joints and faying surfaces of stiffeners, brackets, etc. Use the spray equipment with nozzle directed into faying surfaces, General Instructions for Lubrication, TASK 12-20-01-640-801.

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- (b) Apply corrosion inhibiting compound to the aft surface areas of the rear spar. Pay particular attention to the spar chord and web joints, faying surfaces of stiffeners, brackets, etc., and around high strength boltheads, General Instructions for Lubrication, TASK 12-20-01-640-801.
- (c) Regrease all grease fittings in treatment area, General Instructions for Lubrication, TASK 12-20-01-640-801.

NOTE: The expansion of the corroded material may cause a localized lifting of the free end of the chord flange. This lifting can be detected by checking the chord surface for flatness using a straightedge or scanning with fingers. In some cases, instead of chord flange lifting, the spar web may be depressed. Local depression of the web generally occurs where the spar chord flange is stiffer than the web. These web depressions can be detected visually.

SUBTASK 57-20-00-910-002

- (4) Do these steps to prevent corrosion in wing internal structure:
 - (a) Corrosion prevention includes drainage of water, controlling microbial growth, and making periodic inspection.
 - (b) Inspect the limber holes and drain tubes to make sure the drainage of water, when entering the wing.
 - (c) There are three options for the removal of water or prevention of corrosion:
 - 1) Installing a water scavenge system.
 - 2) Adding sealant to fill areas where water accumulates.
 - 3) Using Strontium chromate canisters to inhibit corrosion.
 - (d) Refer to Structural Repair Manual for instructions to remove corrosion if extensive corrosion exists on the wing inspar skin.
- (5) Restore integral fuel tank finish.

SUBTASK 57-20-00-910-003



USE NITRILE GLOVES FOR SKIN PROTECTION WHEN YOU USE COR-BAN 27L, G50237. IF IT GETS ON YOUR SKIN, IMMEDIATELY REMOVE IT WITH WATER. IF THIS MATERIAL GETS IN YOUR EYES, IMMEDIATELY FLUSH YOUR EYES WITH WATER. GET MEDICAL AID. THIS MATERIAL CONTAINS FLAMMABLE AGENTS WHICH CAN CAUSE INJURIES TO PERSONNEL.

- (6) Do these steps to prevent corrosion in fuel tank and boost pump cutouts:
 - (a) Inspect the mating surfaces of the access door clamp ring and wing skin at regularly scheduled maintenance periods to find corrosion.
 - (b) If there is no corrosion, install the access clamp rings with knitted aluminum gaskets after applying anti-corrosion compound for corrosion protection. Apply 0.010 in. (0.254 mm) - 0.015 in. (0.381 mm) of Cor-Ban 27L Compound, G50237 or Aeroshell 14 helicopter grease, D50050 to wing skin faying surface prior to installing door ring and gasket.
- NOTE:** Aeroshell 14 helicopter grease, D50050 is the recommended anti-corrosion compound for access door gasket installations. Cor-Ban 27L Compound, G50237, can still be used for access door gaskets, but should be replaced with Aeroshell 14 helicopter grease, D50050 as soon as practical.

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- 1) Do not mix the two types of anti-corrosion compounds, Cor-Ban 27L Compound, G50237 and Aeroshell 14 helicopter grease, D50050. When you apply the recommended anti-corrosion compound, Aeroshell 14 helicopter grease, D50050, make sure to remove all Cor-Ban 27L Compound, G50237 from the mesh gasket, clamp ring and the access door structure on the airplane.
- (c) If there is corrosion, refer to Structural Repair Manual for corrosion removal.

SUBTASK 57-20-00-370-002

(7) Frequency of Application

- (a) Periodic inspection is required in areas identified as susceptible to corrosion and should be consistent to the schedules specified in the Maintenance Planning Document. Operators must be aware of reported problems and areas of occurrences.
- (b) Periodic application of corrosion inhibiting compound, G00009 is necessary to areas identified and should be consistent to the schedule specified in the Maintenance Planning Document.

———— **END OF TASK** ————

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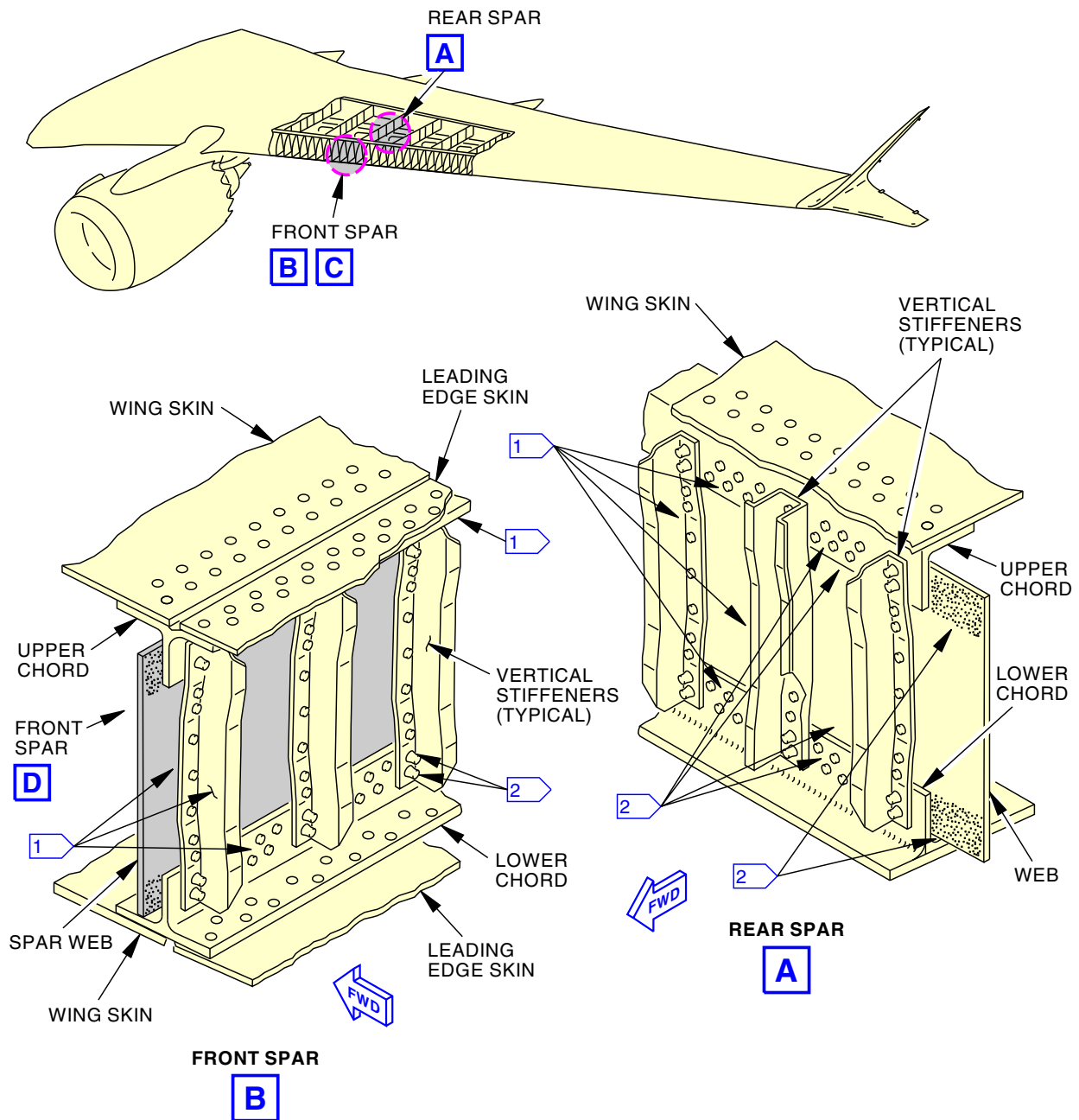
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- 1 APPLY CORROSION INHIBITOR ON ALL EXPOSED STRUCTURE
- 2 POSSIBLE CORROSION AREA

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Outer Wing Front and Rear Spars - Corrosion Prevention
Figure 201/57-20-00-990-801 (Sheet 1 of 6)

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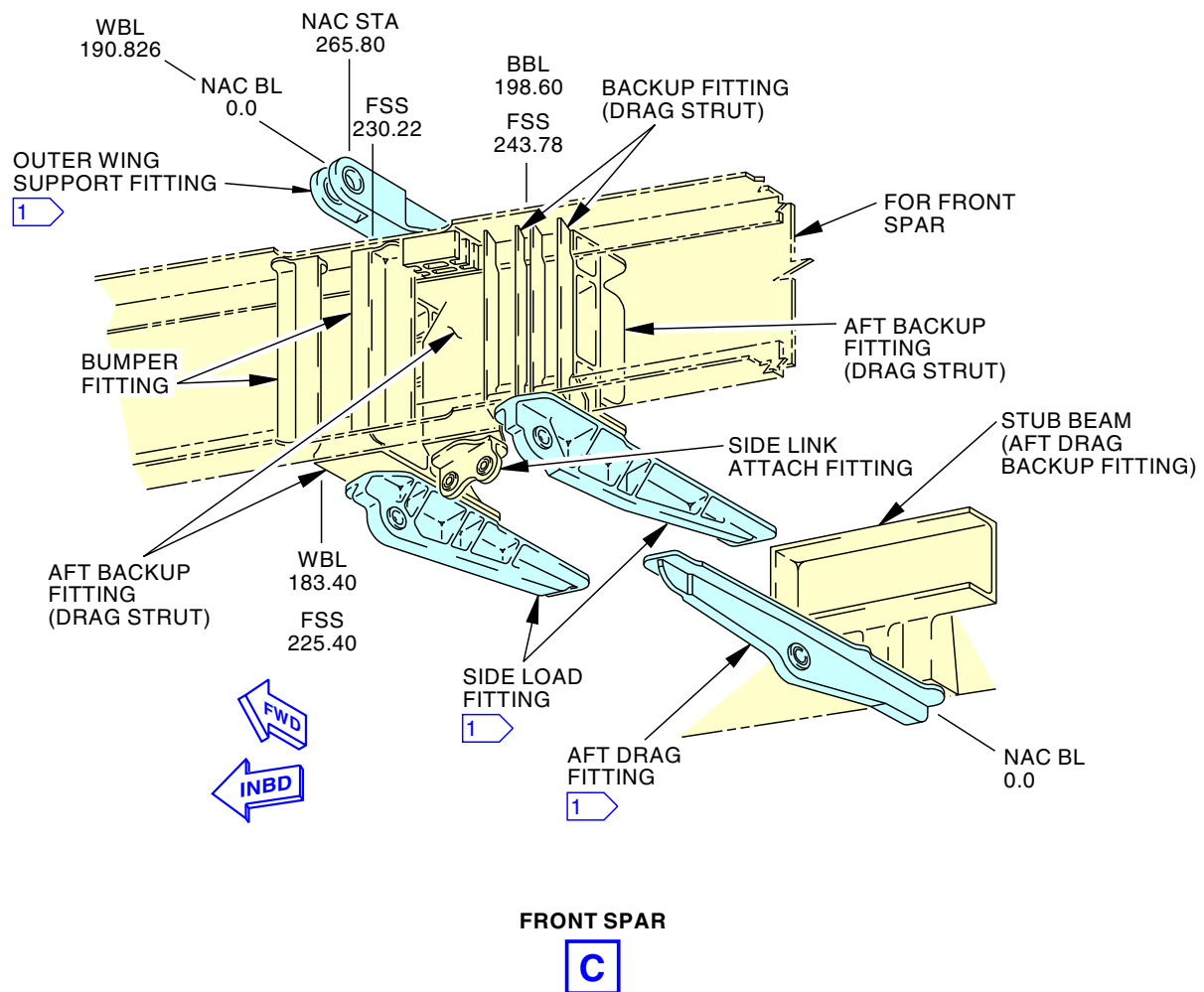
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Outer Wing Front and Rear Spars - Corrosion Prevention
Figure 201/57-20-00-990-801 (Sheet 2 of 6)

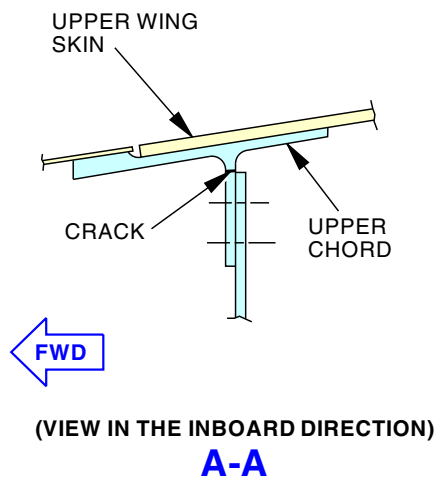
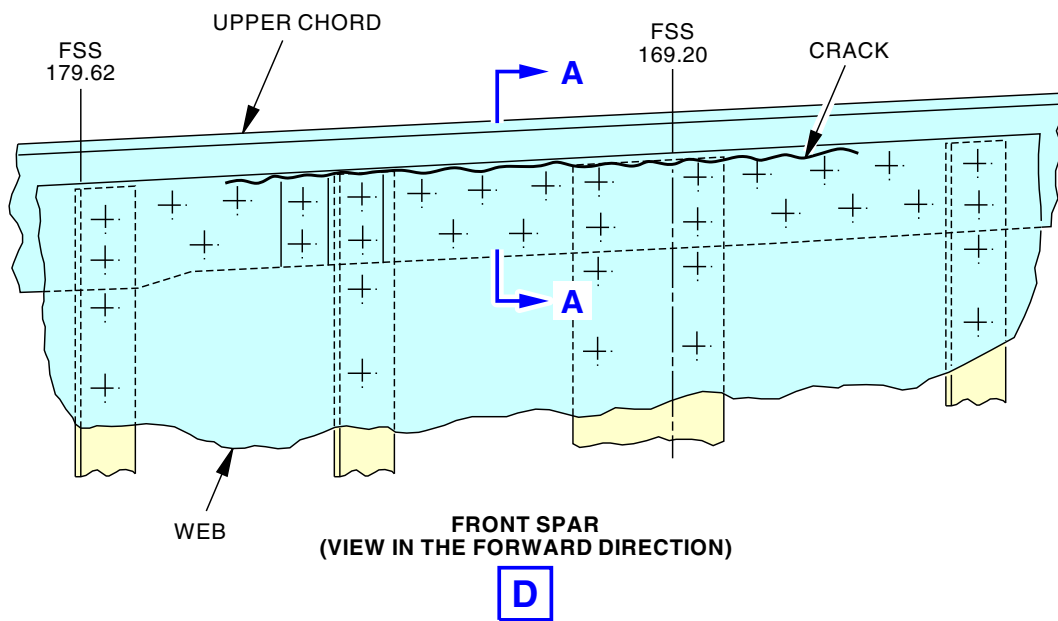
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Outer Wing Front and Rear Spars - Corrosion Prevention
Figure 201/57-20-00-990-801 (Sheet 3 of 6)

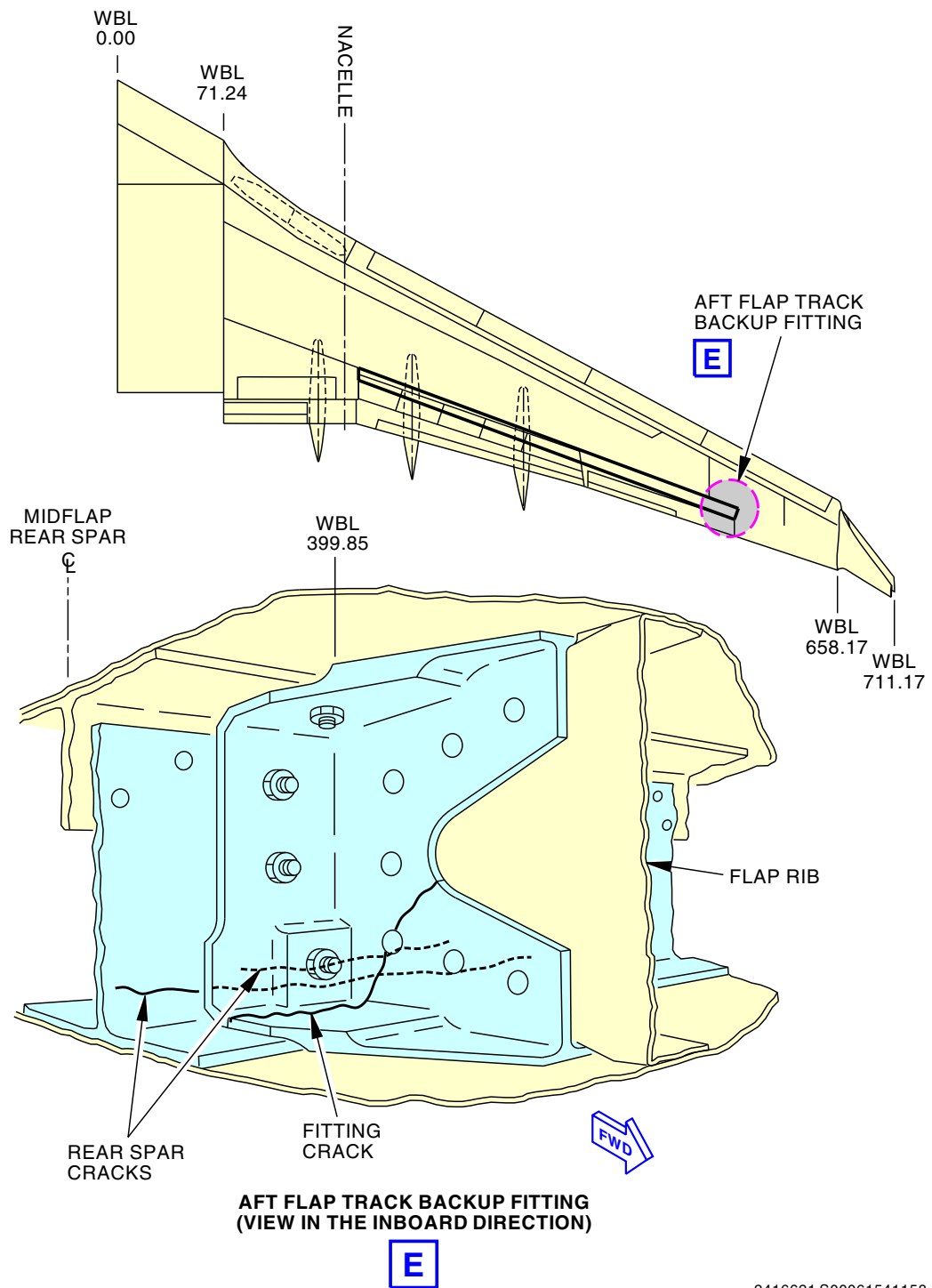
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Outer Wing Front and Rear Spars - Corrosion Prevention
Figure 201/57-20-00-990-801 (Sheet 4 of 6)

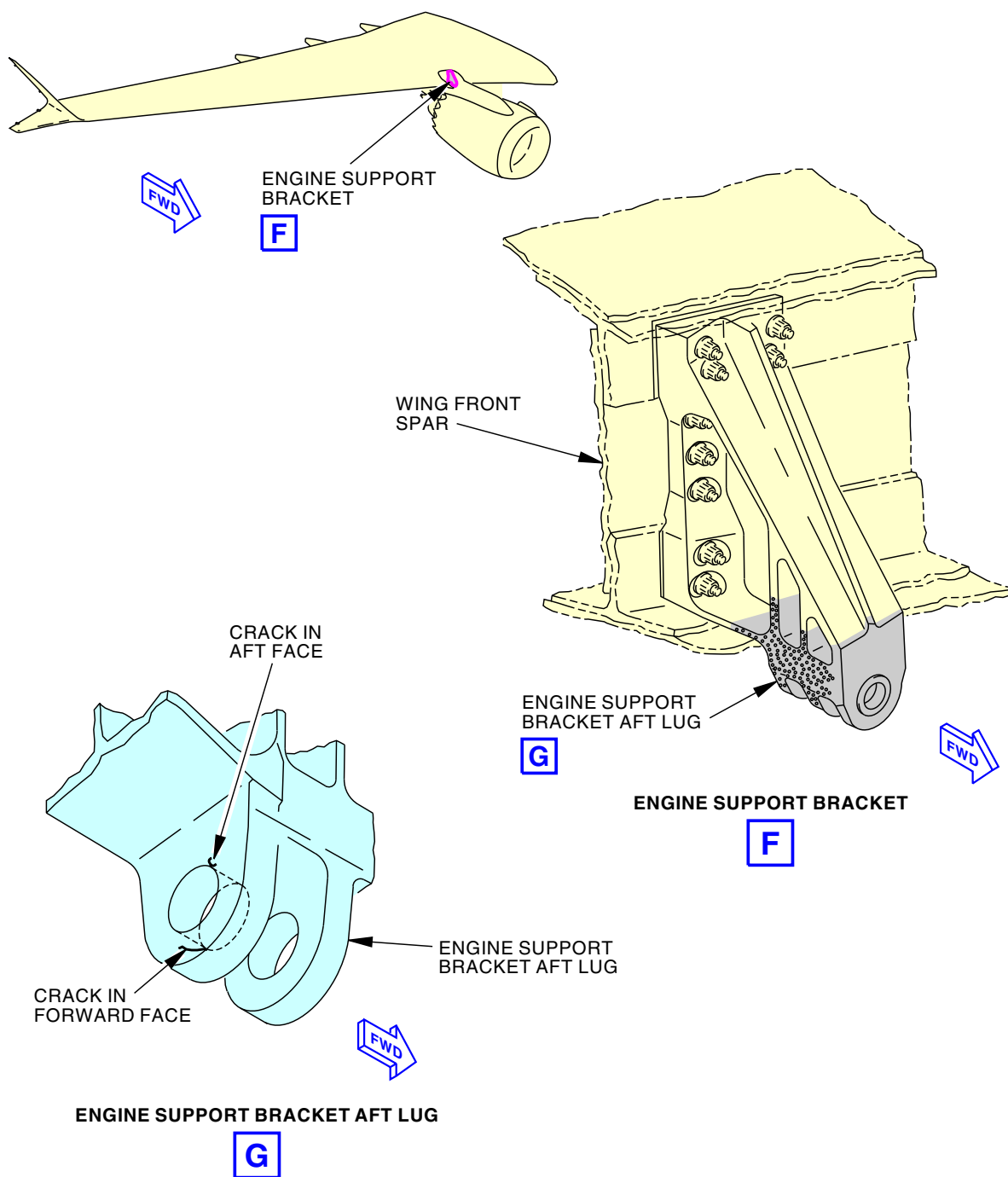
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Outer Wing Front and Rear Spars - Corrosion Prevention
Figure 201/57-20-00-990-801 (Sheet 5 of 6)

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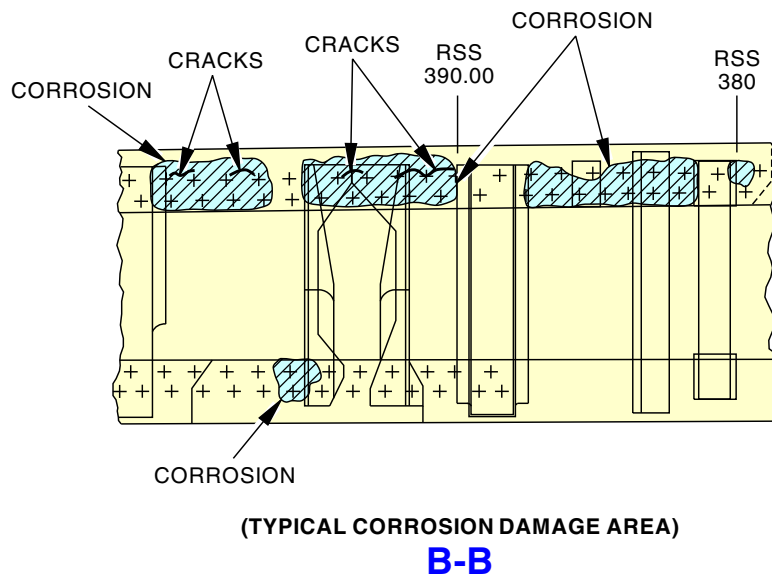
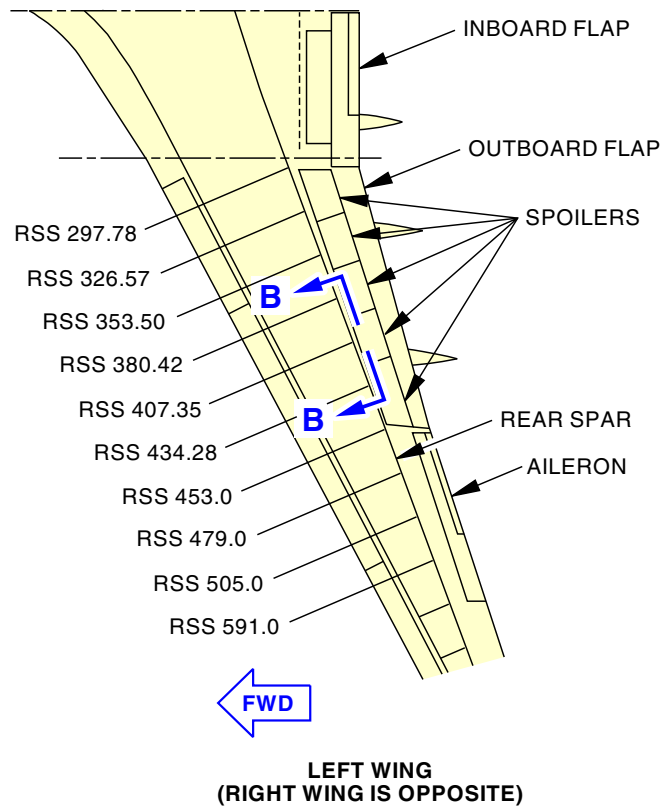
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**Outer Wing Front and Rear Spars - Corrosion Prevention
Figure 201/57-20-00-990-801 (Sheet 6 of 6)**

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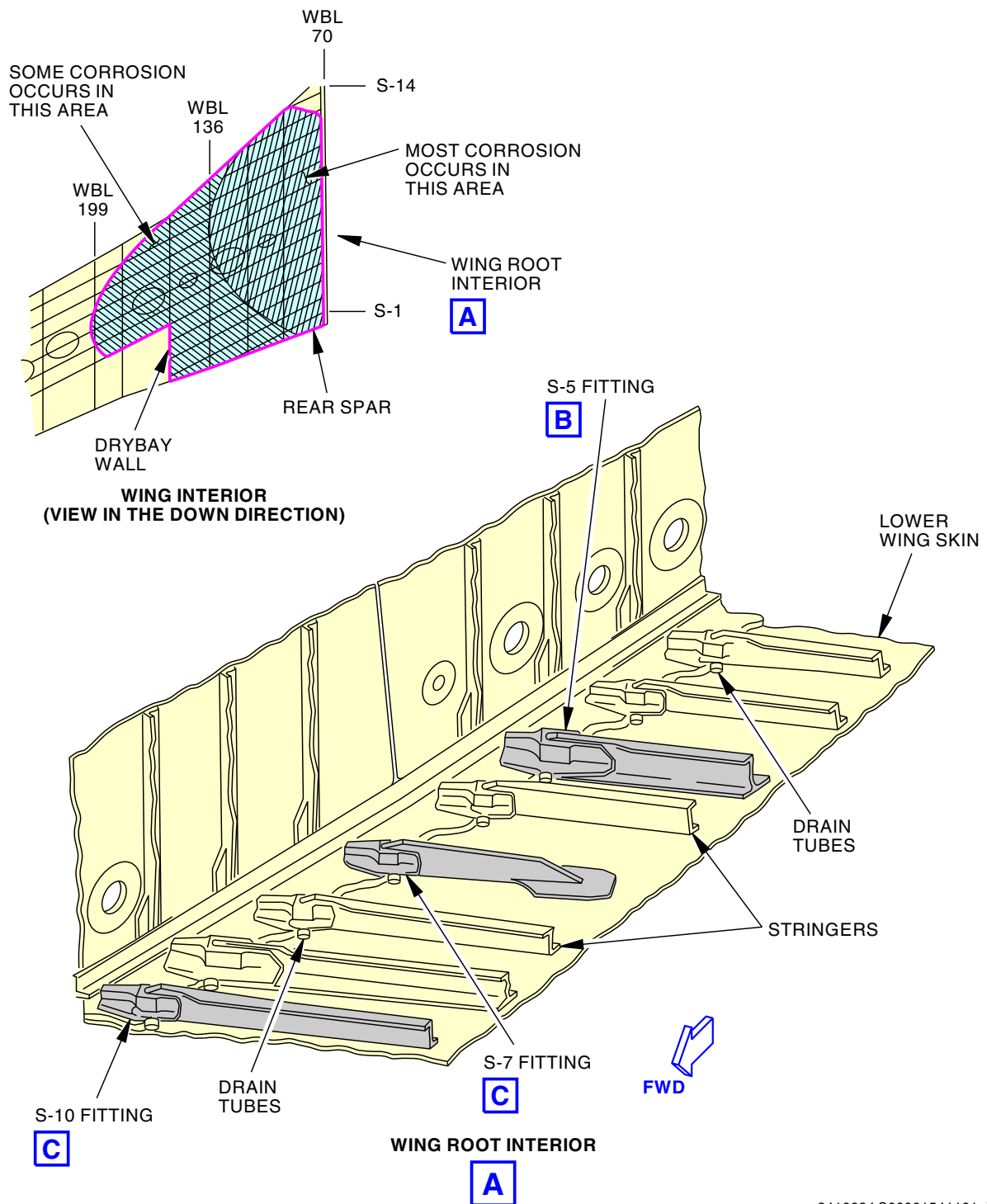
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Outer Wing Internal Structure - Corrosion Prevention
Figure 202/57-20-00-990-802 (Sheet 1 of 2)

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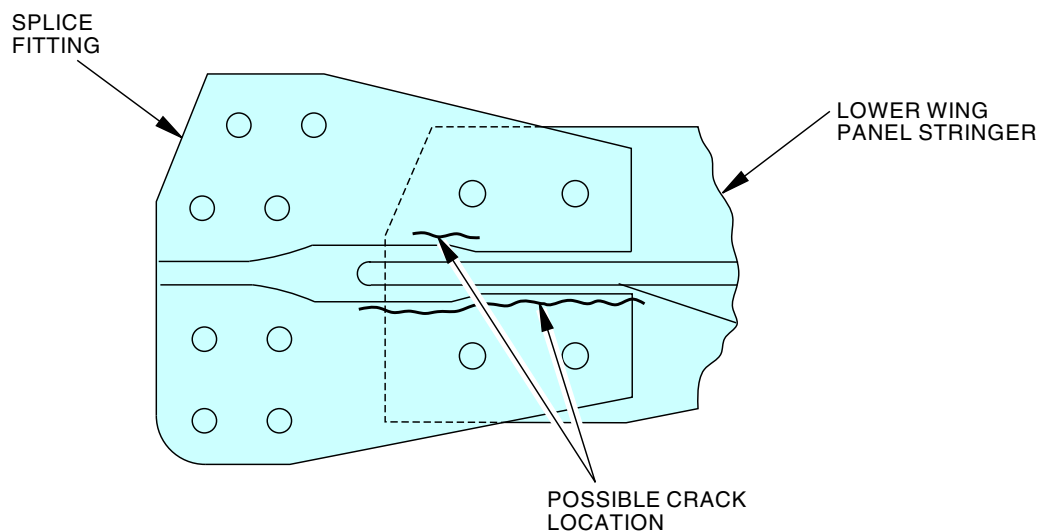
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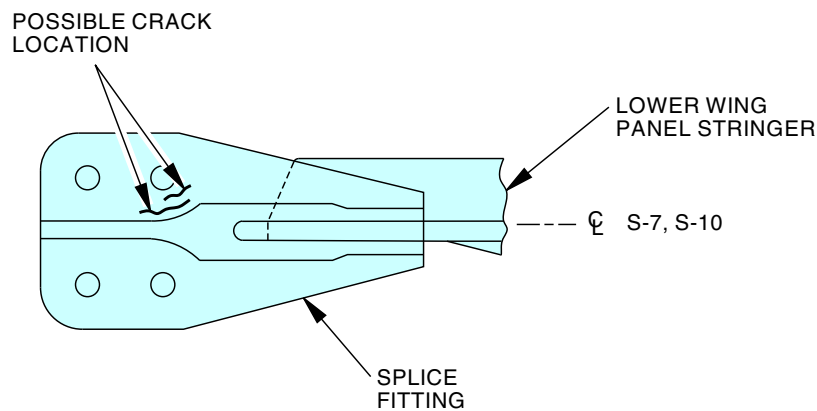
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B



C

2416625 S00061541162_V1

Outer Wing Internal Structure - Corrosion Prevention
Figure 202/57-20-00-990-802 (Sheet 2 of 2)

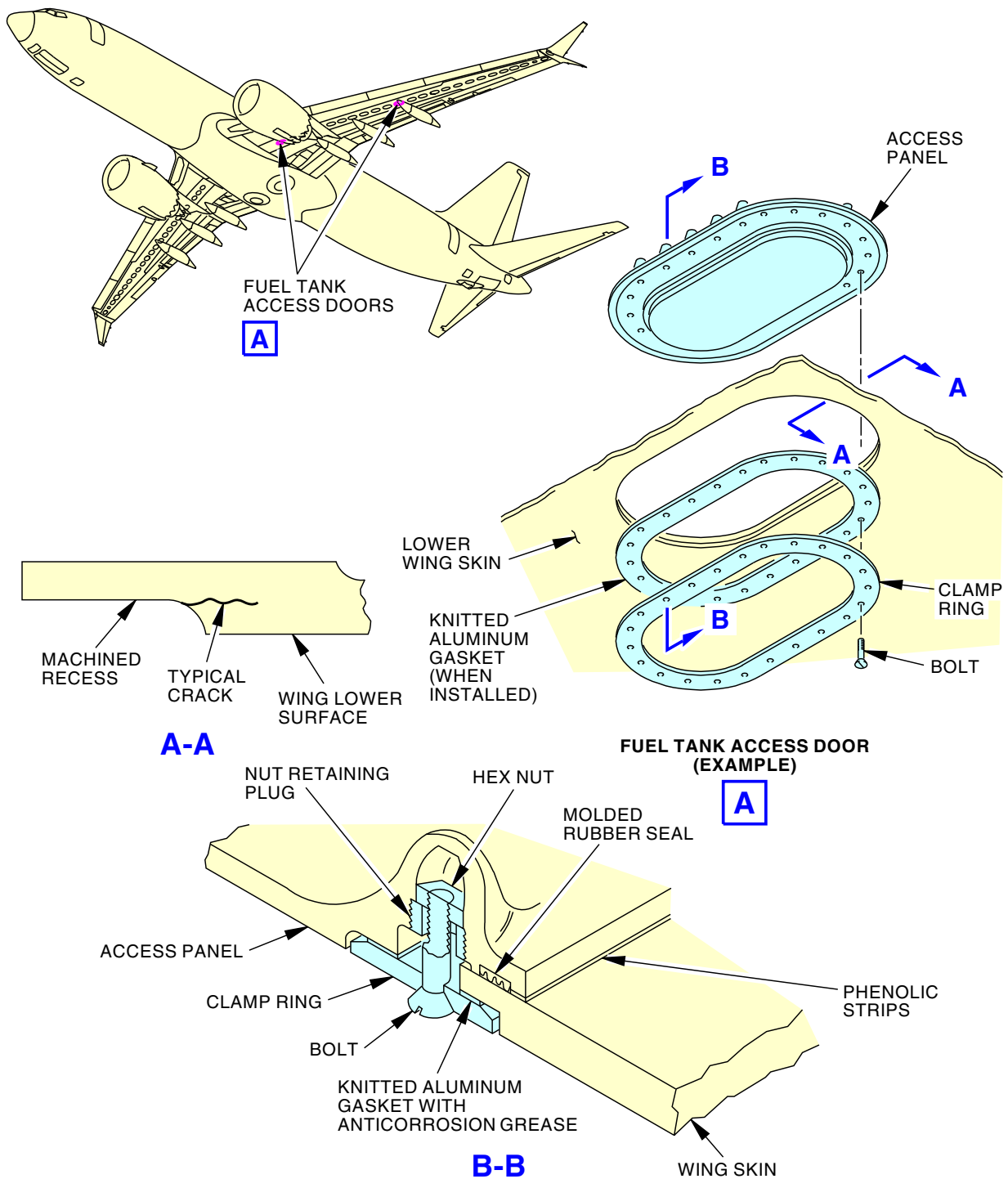
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2416626 S00061541163_V1

Fuel Tank and Boost Pump Access Cutouts - Corrosion Prevention
Figure 203/57-20-00-990-803

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WING VORTEX GENERATORS - REMOVAL/INSTALLATION

1. General

- A. This procedure contains two tasks. The first task is the removal of the wing vortex generator. The second task is the installation of the wing vortex generator.

TASK 57-22-00-000-801

2. Wing Vortex Generator Removal

(Figure 401)

A. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
COM-2481	Sealant Removal Tool (meets BSS7384 requirements) Part #: 1-6390-A Supplier: 63318 Part #: 10810 Supplier: \$0855 Part #: 10811 Supplier: \$0855 Part #: 10812 Supplier: \$0855 Part #: 234350 Supplier: 5HCF1 Part #: 235072 Supplier: 5HCF1 Part #: 235073 Supplier: 5HCF1 Part #: 235074 Supplier: 5HCF1 Part #: 235075 Supplier: 5HCF1 Part #: 235076 Supplier: 5HCF1 Part #: 311/03 Supplier: F6892 Part #: 311/14 Supplier: F6892 Part #: 311/25 Supplier: F6892 Part #: 311/37 Supplier: F6892 Part #: AS1 Supplier: \$1351 Part #: AS2 Supplier: \$1351 Part #: AS3 Supplier: \$1351 Part #: DAD5013 Supplier: 7RKH2 Part #: DFD5019 Supplier: 7RKH2 Part #: JNT411B60 Supplier: 3DN12 Part #: JNT411B90 Supplier: 3DN12 Part #: SCD5019 Supplier: 7RKH2 Part #: ST982LF-9 Supplier: 81205 Part #: TS1275-4 Supplier: 22975

B. Location Zones

Zone	Area
500	Left Wing
600	Right Wing

C. Procedure

SUBTASK 57-22-00-020-001

- (1) Remove the loose vortex generator [1] with a sealant removal tool, COM-2481.

————— **END OF TASK** —————

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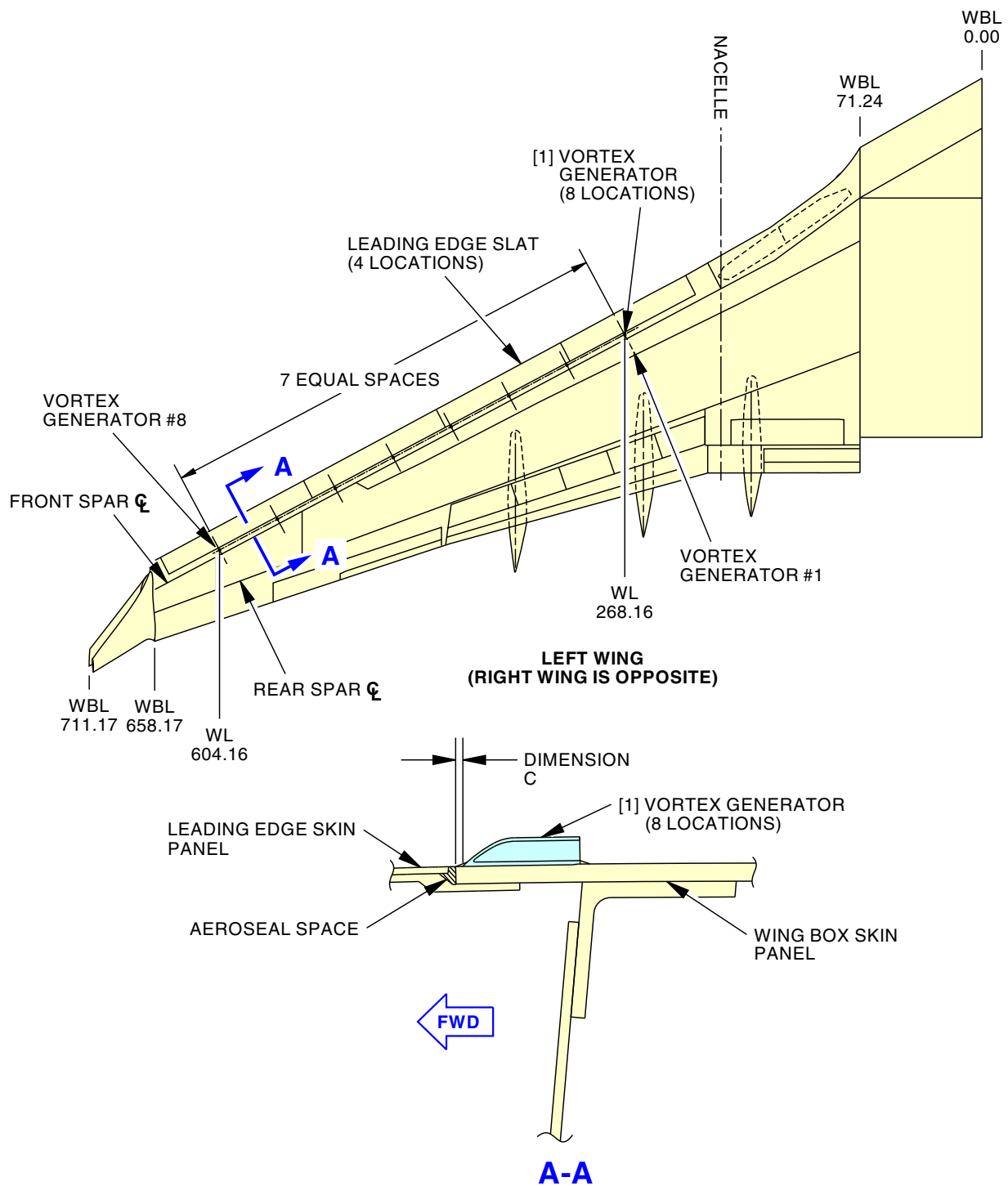
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2416656 S00061541233_V2

Wing Vortex Generator Installation
Figure 401/57-22-00-990-801

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TASK 57-22-00-400-801

3. Wing Vortex Generator Installation

(Figure 401)

A. References

Reference	Title
51-21-00-100-801	Airplane Surface Preparation for Application of Finish (P/B 701)

B. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt.", which stands for Optional.

Reference	Description
COM-2481	Sealant Removal Tool (meets BSS7384 requirements) Part #: 1-6390-A Supplier: 63318 Part #: 10810 Supplier: \$0855 Part #: 10811 Supplier: \$0855 Part #: 10812 Supplier: \$0855 Part #: 234350 Supplier: 5HCF1 Part #: 235072 Supplier: 5HCF1 Part #: 235073 Supplier: 5HCF1 Part #: 235074 Supplier: 5HCF1 Part #: 235075 Supplier: 5HCF1 Part #: 235076 Supplier: 5HCF1 Part #: 311/03 Supplier: F6892 Part #: 311/14 Supplier: F6892 Part #: 311/25 Supplier: F6892 Part #: 311/37 Supplier: F6892 Part #: AS1 Supplier: \$1351 Part #: AS2 Supplier: \$1351 Part #: AS3 Supplier: \$1351 Part #: DAD5013 Supplier: 7RKH2 Part #: DFD5019 Supplier: 7RKH2 Part #: JNT411B60 Supplier: 3DN12 Part #: JNT411B90 Supplier: 3DN12 Part #: SCD5019 Supplier: 7RKH2 Part #: ST982LF-9 Supplier: 81205 Part #: TS1275-4 Supplier: 22975

C. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
A50328	Adhesive - Modified Epoxy For General Purpose Use	BMS5-92 Type V Class 1
B00065	Alcohol - Denatured, Ethyl (Ethanol)	AMS 3002 (Supersedes O-A-396)
G50320 [912-0041]	Cloth - Process Cleaning Absorbent Wiper	

D. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Vortex generator	57-22-51-01-020	SIA ALL

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E. Location Zones

Zone	Area
500	Left Wing
600	Right Wing

F. Procedure

SUBTASK 57-22-00-150-001

- (1) Remove any remaining adhesive from the wing upper surface with a sealant removal tool, COM-2481.
 - (a) If it is necessary, remove any remaining sealant from the wing upper surface with a cloth, G50320 [912-0041] and alcohol, B00065.

SUBTASK 57-22-00-150-002

- (2) Restore any damaged paint prior to installation (TASK 51-21-00-100-801).

SUBTASK 57-22-00-820-001

- (3) Determine the correct position for the vortex generator [1] on the upper surface of the wing:
 - (a) The leading edge of the vortex generator [1] should be Dimension C aft of the leading edge of the wing box skin panel (Table 401).

Table 401/57-22-00-993-802

Vortex Generator Number	Dimension C +/- 0.25 in. (6.35 mm)
Vortex Generator #1	0.140 in. (3.556 mm)
Vortex Generator #2	0.161 in. (4.089 mm)
Vortex Generator #3	0.585 in. (14.859 mm)
Vortex Generator #4	0.990 in. (25.146 mm)
Vortex Generator #5	1.337 in. (33.960 mm)
Vortex Generator #6	1.682 in. (42.723 mm)
Vortex Generator #7	2.032 in. (51.613 mm)
Vortex Generator #8	2.382 in. (60.503 mm)

- (b) Make sure that the long axis of the vortex generator [1] is aligned correctly with the leading edge of the wing.
 - 1) Do not put the vortex generator [1] on top of existing fasteners or over the gap between the skin panels.
 - 2) You can orient the vortex generator [1] $90.0 \pm 2.5^\circ$ arc (1.6 ± 0.1 rad) to the leading edge of the retracted slats.
 - 3) You can orient the vortex generator [1] $89.6 \pm 2.5^\circ$ arc (1.6 ± 0.1 rad) to the leading edge of the wing box skin panel.

SUBTASK 57-22-00-420-001

- (4) Do the steps that follow to bond the vortex generator [1] to the wing upper surface:

NOTE: The vortex generator [1] can be bonded using adhesive, A50328 or sealant, A00247.

- (a) Thoroughly mix the two parts of the adhesive, A50328 or sealant, A00247 per the manufacturers instructions.

NOTE: Refer to the manufacturer's instructions for the details.

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- (b) Apply a thin, consistent layer of the adhesive mixture to the lower surface of the vortex generator [1].
- (c) Put the vortex generator [1] on the upper wing surface immediately with sufficient pressure.
 - 1) Make sure that the surfaces are sealed together completely.
 - 2) Make sure that a continuous bead of extruded adhesive is around the edge of the vortex generator [1].
- (d) Remove the unwanted adhesive around the edges of the vortex generator [1].

SUBTASK 57-22-00-390-001

- (5) Apply a fillet seal of sealant, A00247, around the vortex generator [1].

NOTE: If you used sealant, A00247, to bond the vortex generator, the extruded material can be used for the fillet seal.

———— **END OF TASK** ————

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WINGLET - MAINTENANCE PRACTICES

1. General

- A. This procedure has these tasks:
- (1) Winglet cover plate installation.
 - (2) Winglet cover plate removal.

TASK 57-31-21-480-801

2. Winglet Cover Plate Installation

(Figure 201 and Figure 202)

A. General

- (1) This task is for the installation of the winglet cover plate.
- (2) The cover plate is used to allow dispatch of the airplane without the winglet lower blade.
- (3) The installation of the cover plate will be done after the winglet lower blade was removed.
- (4) The part numbers for the winglet cover plates are as follows:
 - (a) 119A1200-1617, LH lower cover plate
 - (b) 119A1200-1618, RH lower cover plate.

B. References

Reference	Title
20-50-11-910-801	Standard Torque Values (P/B 201)
57-31-21-000-802	Winglet Lower Blade Removal (P/B 401)
SWPM 20-20-00	ELECTRICAL BONDING PROCESSES

C. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
COM-614	Bonding Meters - Non-Intrinsically Safe (For use in outside Class I, Divisions I & II non-hazardous locations. For hazardous locations, use COM-1550). Part #: 247000 Supplier: 00426 Part #: 620LK Supplier: 1CRL2 Part #: BLR-0003-XX Supplier: KC432 Part #: BT51 Supplier: 00426 Part #: M1 Supplier: 3AD17 Part #: M1B Supplier: 3AD17 Part #: T477W (C15292) Supplier: 06659 Opt Part #: 247001 Supplier: 00426

D. Consumable Materials

Reference	Description	Specification
B00184	Solvent - Presealing, Cleaning Solvent	BMS11-7
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	AMS3819 Class 1 Grade A or B Form 1 (Supersede BMS15-5 CLA)

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(Continued)

Reference	Description	Specification
G50228	Tape - 3M 436 Vibration Damping Tape (Formerly 3M Y436)	

E. Location Zones

Zone	Area
527	Left Winglet
627	Right Winglet

F. Winglet Cover Plate Installation

SUBTASK 57-31-21-020-012

(1) Do this task: Winglet Lower Blade Removal, TASK 57-31-21-000-802.

SUBTASK 57-31-21-480-015

- (2) If the LH cover plate assembly [10] will be installed, do these steps:
- (a) Install the LH forward bracket assembly [6] and LH aft bracket assembly [8] on the root fitting assembly with collars [1], shoulder screws [2], washer [5], and locknuts [4].
 - (b) Tighten the locknuts [4] to the standard torque value (TASK 20-50-11-910-801).
 - (c) Connect the bonding jumper [13] as follows:
 - 1) Use cotton wiper, G00034, moist in solvent, B00184, to clean the mating surfaces of the LH cover plate assembly [10], washer [12], bonding jumper [13], washer [14], and nut [15].
 - 2) Install new washer [12] under the forward bonding jumper [13].
 - 3) Install the bonding jumper [13], new washer [14], and new nut [15].
 - 4) Tighten the nut to 180 in-lb (20.3 N·m) - 200 in-lb (22.6 N·m).
 - 5) Measure the electrical bonding resistance between bonding jumper [13] and airplane structure (SWPM 20-20-00).
 - a) Use non-intrinsically safe bonding meter, COM-614.
 - b) Make sure that the electrical bonding resistance is 0.0001 ohm (0.1 milliohm) or less.
 - (d) Put the LH cover plate assembly [10] into position on the fairing assembly.
 - (e) Loosely install the LH cover plate assembly [10] on the bracket assemblies with the eight screws [3].

NOTE: Do not tighten the screws at this time.
 - (f) Prepare the 38 screws from the lower blade as follows:

NOTE: Use the same screws from the lower blade installation to install the cover plate.

 - 1) Remove the sealant that remains on the screws.
 - 2) Examine threads on the screws.
 - 3) Replace the screws that have damage.
 - (g) Install the LH cover plate assembly [10] with the 38 screws from the winglet lower blade.
 - (h) Tighten the 38 screws to 30 in-lb (3 N·m).
 - (i) Tighten the eight screws [3] to the standard torque value (TASK 20-50-11-910-801).
 - (j) Use cotton wiper, G00034, moist in solvent, B00184, to clean the transition fairing and center closeout fairing.

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- 1) Apply strips of 3M 436 Tape, G50228 (vibration damping tape), to seal the perimeter of the transition fairing in the correct sequence and center closeout fairing (Figure 202).

SUBTASK 57-31-21-480-016

- (3) If the RH cover plate assembly [11] will be installed, do these steps:
 - (a) Install the RH forward bracket assembly [7] and RH aft bracket assembly [9] on the root fitting assembly with collars [1], shoulder screws [2], washer [5] and locknuts [4].
 - (b) Tighten the locknuts [4] to the standard torque value (TASK 20-50-11-910-801).
 - (c) Connect the forward bonding jumper [13] as follows:
 - 1) Use cotton wiper, G00034, moist in solvent, B00184, to clean the mating surfaces of the RH cover plate assembly [11], washer [12], bonding jumper [13], washer [14], and nut [15].
 - 2) Install new washer [12] under the forward bonding jumper [13].
 - 3) Install the forward bonding jumper [13], new washer [14], and new nut [15].
 - 4) Tighten the nut to 180 in-lb (20.3 N·m) - 200 in-lb (22.6 N·m).
 - 5) Measure the electrical bonding resistance between bonding jumper [13] and airplane structure (SWPM 20-20-00).
 - a) Use non-intrinsically safe bonding meter, COM-614.
 - b) Make sure that the electrical bonding resistance is 0.0001 ohm (0.1 milliohm) or less.
 - (d) Put the RH cover plate assembly [11] into position on the fairing assembly.
 - (e) Loosely install the RH cover plate assembly [11] on the bracket assemblies with the eight screws [3].

NOTE: Do not tighten the screws at this time.
 - (f) Prepare the 38 screws from the lower blade as follows:

NOTE: Use the same screws from the lower blade installation to install the cover plate.

 - 1) Remove the sealant that remains on the screws.
 - 2) Examine threads on the screws.
 - 3) Replace the screws that have damage.
 - (g) Install the RH cover plate assembly [11] with the 38 screws from the winglet lower blade.
 - (h) Tighten the 38 screws to 30 in-lb (3 N·m).
 - (i) Tighten the eight screws [3] to the standard torque value (TASK 20-50-11-910-801).
 - (j) Use cotton wiper, G00034, moist in solvent, B00184, to clean the transition fairing and center closeout fairing.
 - 1) Apply strips of 3M 436 Tape, G50228 (vibration damping tape), to seal the perimeter of the transition fairing in the correct sequence and center closeout fairing (Figure 202).

————— **END OF TASK** —————

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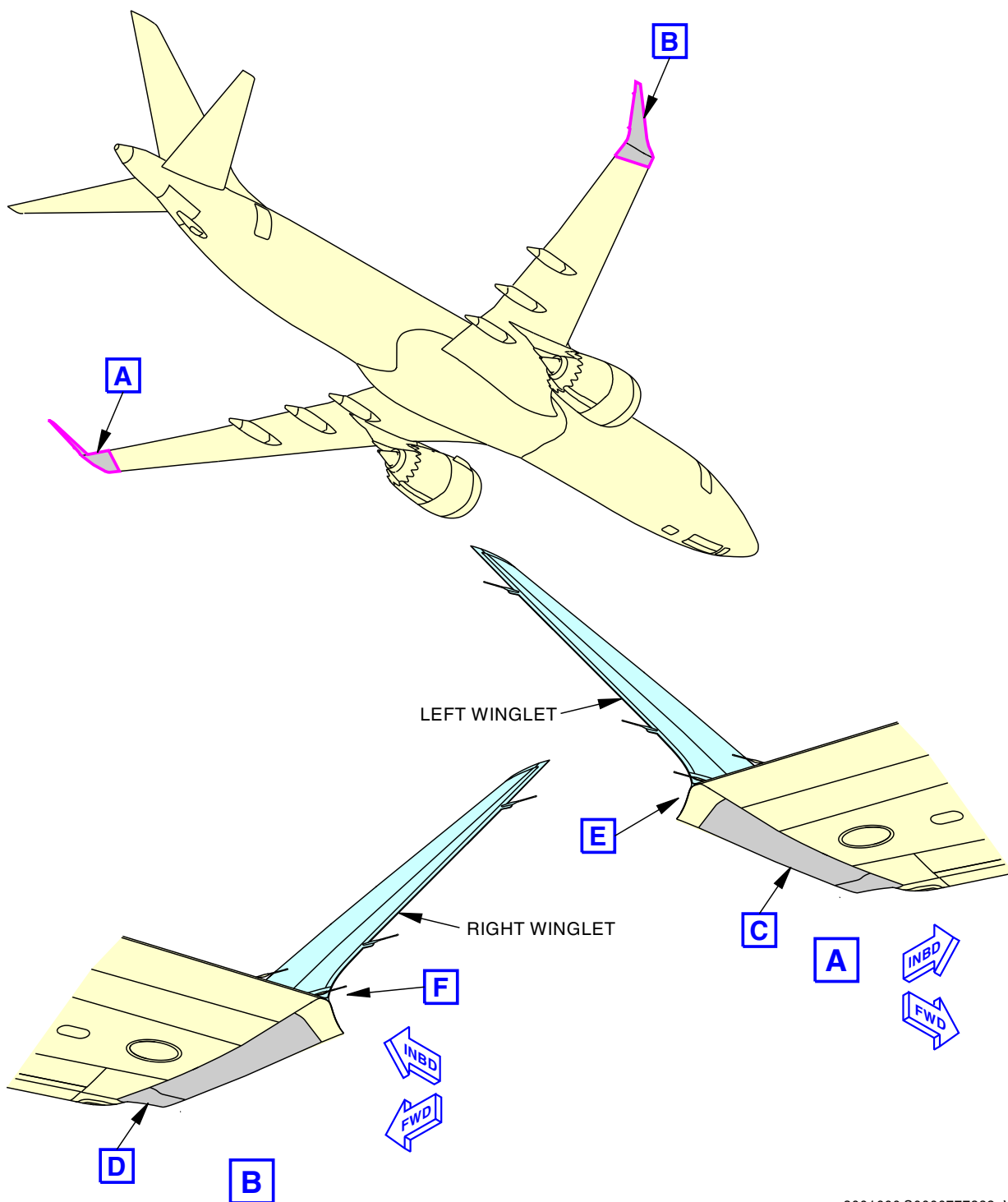
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3001600 S0000777382_V1

Winglet Cover Plate Installation
Figure 201/57-31-21-990-807 (Sheet 1 of 3)

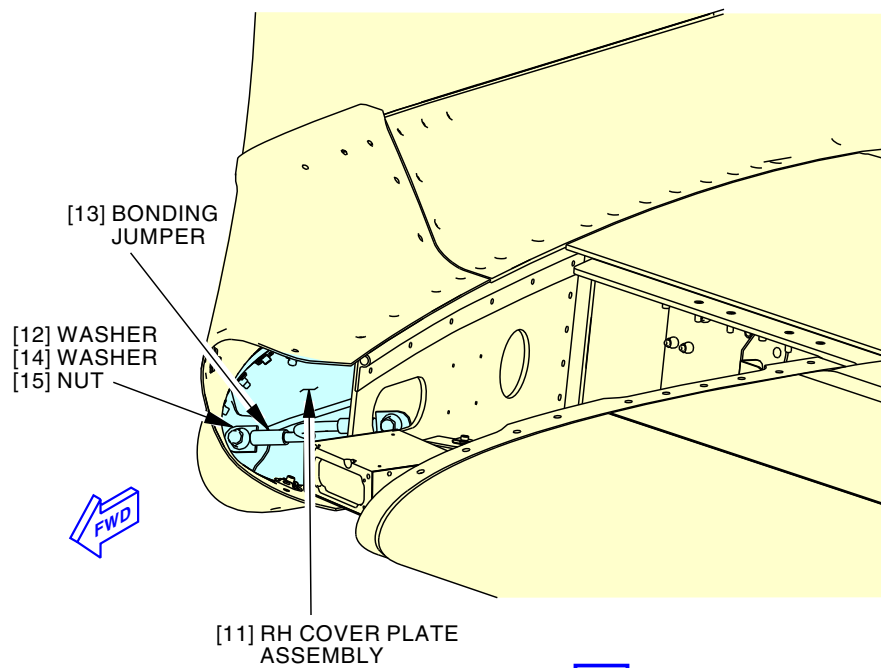
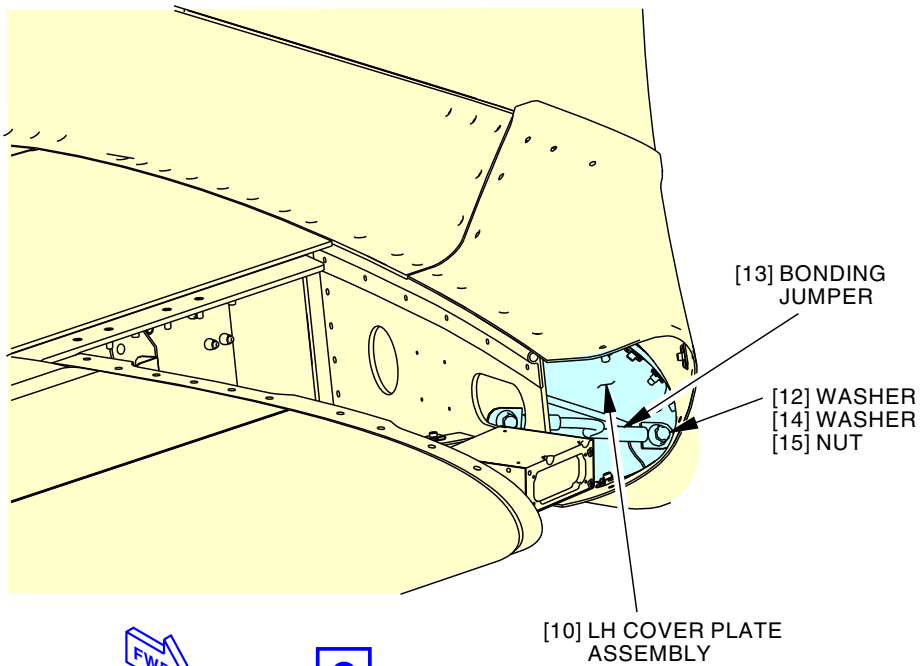
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3001615 S0000777383_V1

Winglet Cover Plate Installation
Figure 201/57-31-21-990-807 (Sheet 2 of 3)

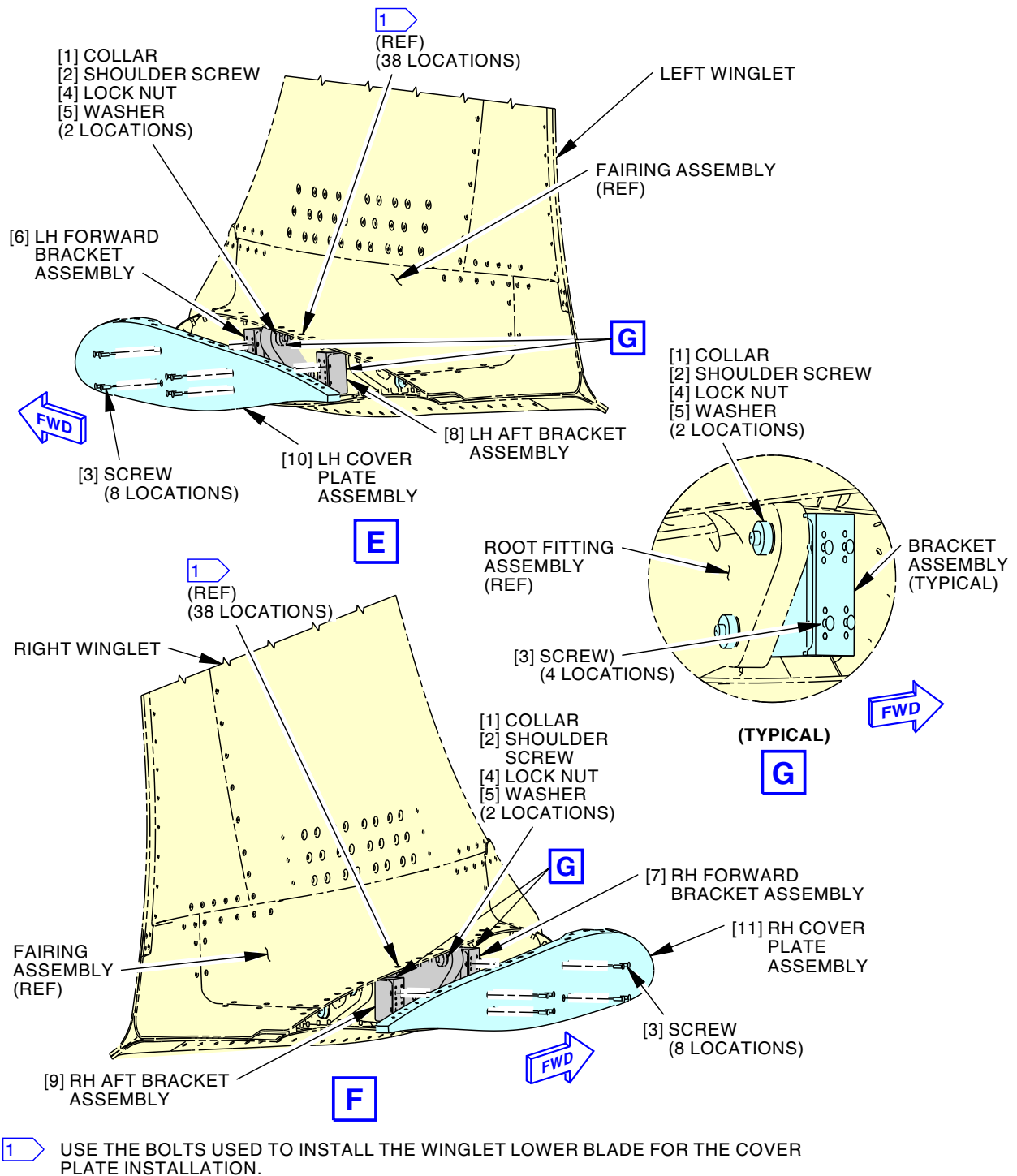
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2822294 S0000652783_V3

Winglet Cover Plate Installation
Figure 201/57-31-21-990-807 (Sheet 3 of 3)

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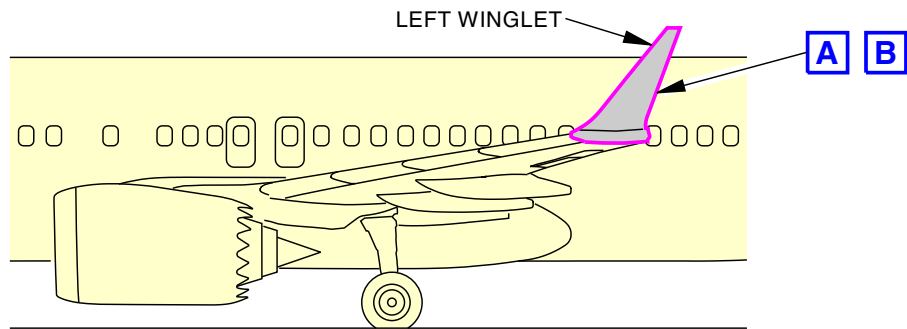
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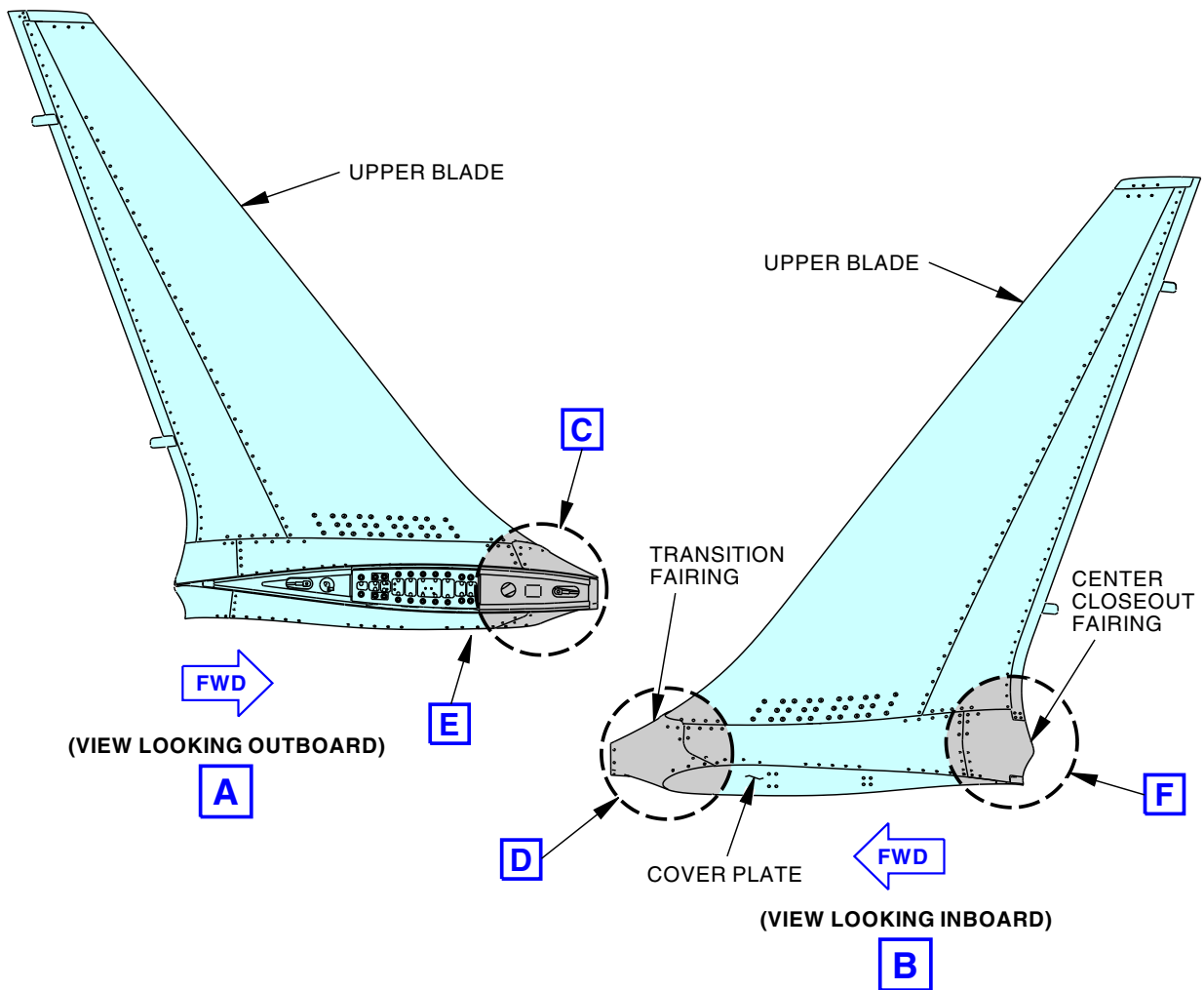
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LEFT WING IS SHOWN, RIGHT WING IS THE SAME
(LOWER BLADE IS REMOVED, WINGLET COVER PLATE IS INSTALLED)



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Vibration Damping Tape Application
Figure 202/57-31-21-990-813 (Sheet 1 of 3)

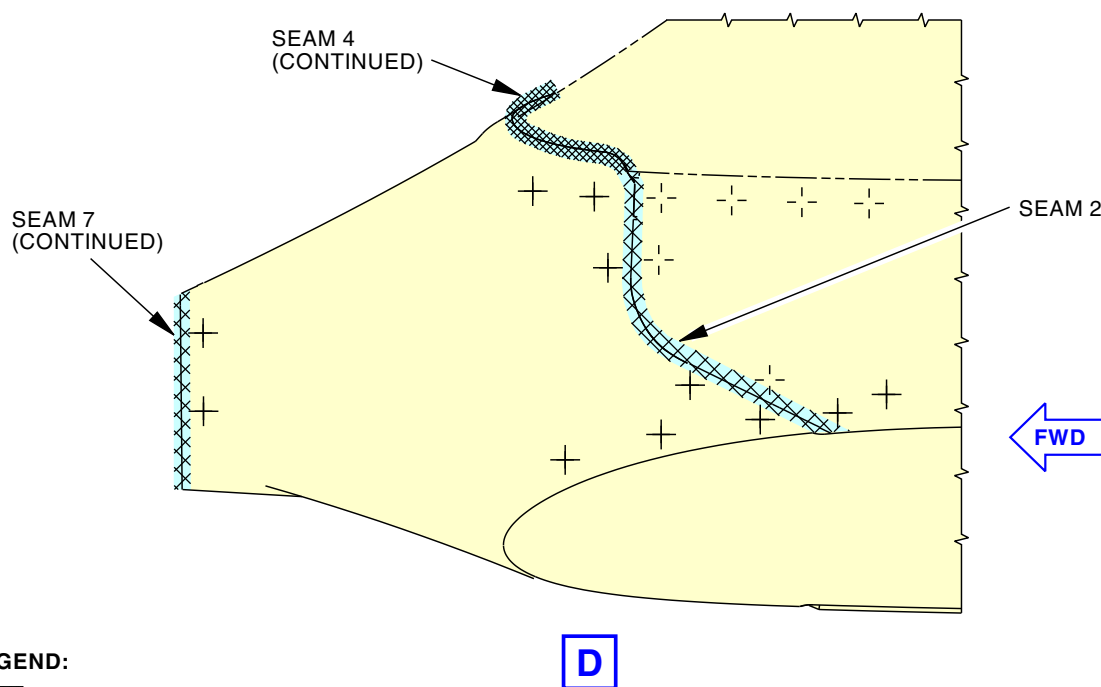
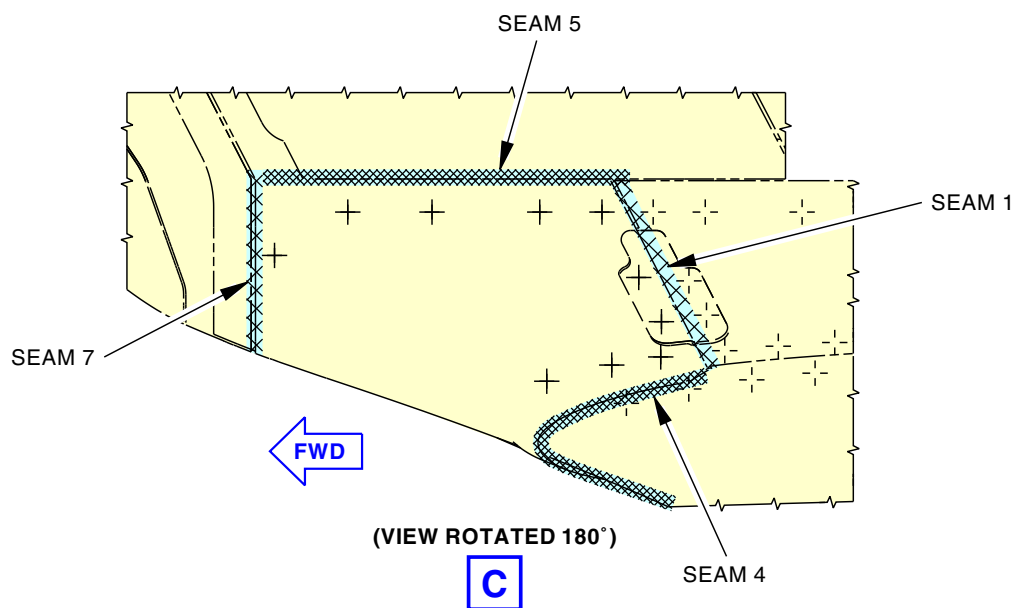
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LEGEND:

-  VIBRATION DAMPING TAPE
-  VIBRATION DAMPING TAPE

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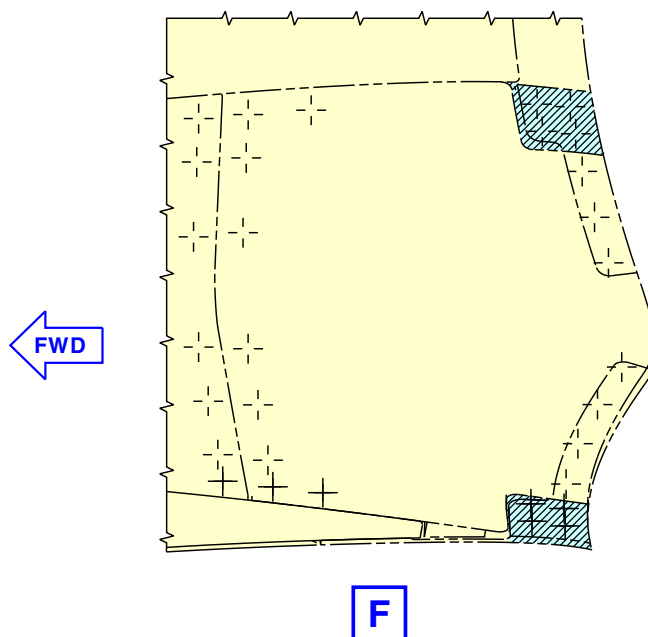
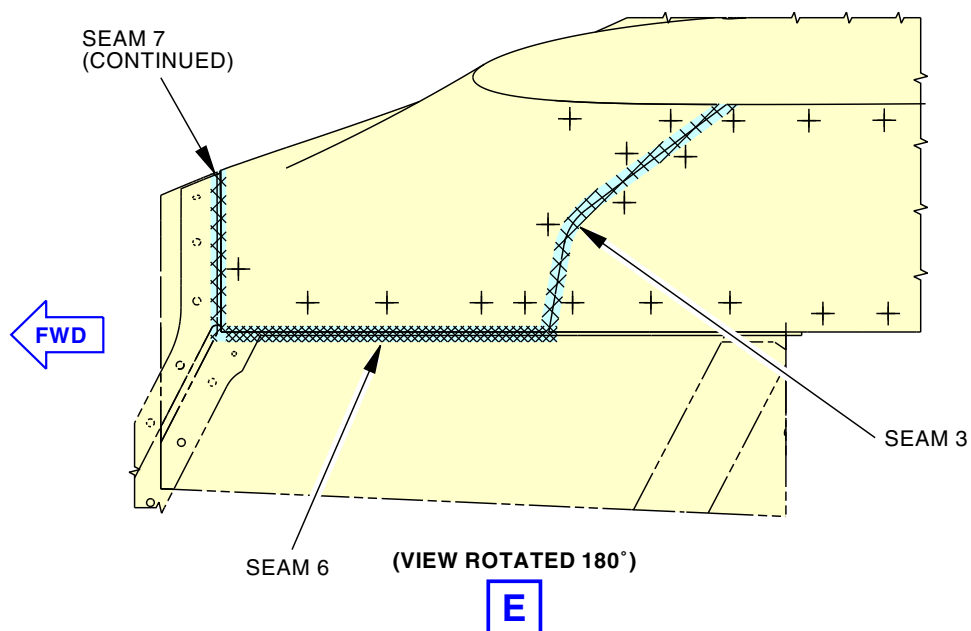
Vibration Damping Tape Application
Figure 202/57-31-21-990-813 (Sheet 2 of 3)

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LEGEND:

-  VIBRATION DAMPING TAPE
-  VIBRATION DAMPING TAPE
-  VIBRATION DAMPING TAPE

2999134 S0000775182_V1

Vibration Damping Tape Application
Figure 202/57-31-21-990-813 (Sheet 3 of 3)

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TASK 57-31-21-080-801

3. **Winglet Cover Plate Removal**

(Figure 201 and Figure 202)

A. General

- (1) This task is for the removal of the winglet cover plate.
- (2) Removal of the winglet coverplate is necessary before installation of the winglet lower blade.

B. References

Reference	Title
57-31-21-400-802	Winglet Lower Blade Installation (P/B 401)

C. Location Zones

Zone	Area
527	Left Winglet
627	Right Winglet

D. Winglet Cover Plate Removal

SUBTASK 57-31-21-080-003

- (1) Remove the LH cover plate assembly [10] as follows:
 - (a) Remove the 3M 436 tape (vibration damping tape).
 - (b) Remove the 38 screws that attach the LH cover plate assembly [10] to the fairing assembly.
 - (c) Keep the screws for the winglet lower blade installation.
 - (d) Hold the LH cover plate assembly [10] in its position.
 - (e) Remove the eight screws [3] that attach the LH cover plate assembly [10] to the bracket assemblies.
 - (f) Remove the nut [15], washer [14], bonding jumper [13], and washer [12].
 - (g) Remove the LH cover plate assembly [10] from the fairing assembly.
 - (h) Remove the two collars [1], shoulder screws [2], locknuts [4], and washers [5] that attach the LH forward bracket assembly [6] to the root fitting.
 - (i) Remove the LH forward bracket assembly [6] from the root fairing.
 - (j) Remove the two collars [1], shoulder screws [2], locknuts [4], and washers [5] that attach the LH aft bracket assembly [8] to the root fitting.
 - (k) Remove the LH aft bracket assembly [8] from the root fairing.

SUBTASK 57-31-21-080-004

- (2) Remove the RH cover plate assembly [11] as follows:
 - (a) Remove the 3M 436 tape (vibration damping tape).
 - (b) Remove the 38 screws that attach the RH cover plate assembly [11] to the fairing assembly.
 - (c) Keep the screws for the winglet lower blade installation.
 - (d) Hold the RH cover plate assembly [11] in its position.
 - (e) Remove the eight screws [3] that attach the RH cover plate assembly [11] to the bracket assemblies.
 - (f) Remove the nut [15], washer [14], bonding jumper [13], and washer [12].

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- (g) Remove the RH cover plate assembly [11] from the fairing assembly.
- (h) Remove the two collars [1], shoulder screws [2], locknuts [4], and washers [5] that attach the RH forward bracket assembly [7] to the root fitting.
- (i) Remove the RH forward bracket assembly [7] from the root fairing.
- (j) Remove the two collars [1], shoulder screws [2], locknuts [4], and washers [5] that attach the RH aft bracket assembly [9] to the root fitting.
- (k) Remove the RH aft bracket assembly [9] from the root fairing.

SUBTASK 57-31-21-420-011

- (3) Do this task: Winglet Lower Blade Installation, TASK 57-31-21-400-802.

———— **END OF TASK** ————

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WINGLET - REMOVAL/INSTALLATION

1. General

- A. The winglet assembly includes an upper blade and a lower blade. The lower blade can be removed separately from the upper blade.
- B. There are six tasks in this procedure.
 - (1) Winglet removal
 - (2) Winglet installation
 - (3) Winglet lower blade removal
 - (4) Winglet lower blade installation
 - (5) Alternate winglet removal
 - (6) Alternate winglet installation.
- C. The winglet procedures will remove and install the winglet in its entirety. The winglet lower blade procedures will only remove and install the lower blade. The alternate winglet procedures will remove the lower blade then the upper blade and install the upper blade then the lower blade.

TASK 57-31-21-000-801

2. Winglet Removal

(Figure 401 and Figure 402)

A. General

- (1) This task gives the instructions to remove the winglet from the left or right wing.
- (2) The winglet consists of the upper blade and lower blade.

B. References

Reference	Title
20-40-11-910-801	Static Grounding (P/B 201)
27-51-00-040-801	Trailing Edge Flap System Deactivation (P/B 201)
27-81-00-040-801	Leading Edge Flaps and Slats - Deactivation (P/B 201)
33-43-10-020-801	Winglet (AFT) Marker and Winglet Anti-Collision Lights - Disconnect the Electrical Connectors (P/B 201)
57-31-21-990-810	Figure: Winglet Seal (P/B 801)
57-31-23-000-801	Dry Bay Access Doors Removal (P/B 401)
57-31-25-010-801	Transition Fairing Removal (P/B 401)

C. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
COM-659	Platform - Maintenance Lift, 3 ft Minimum Height, 12.5 ft Maximum Height Part #: 1135-8000 Supplier: 00994 Opt Part #: 8662-010 Supplier: 00994

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Reference	Description
COM-2480	Platform - Mobile Elevating Work Platform SJ III Series Part #: SJIII 4726 Supplier: 3AF08 Part #: SJIII 4732 Supplier: 3AF08 Opt Part #: SJIII 4620 Supplier: 3AF08 Opt Part #: SJIII 4626 Supplier: 3AF08 Opt Part #: SJIII 4632 Supplier: 3AF08
SPL-2044	Sling - Winglet Part #: C57002-66 Supplier: 81205
SPL-14633	Winglet Holding Fixture Part #: C57006-1 Supplier: 81205
STD-1064	Scraper - Phenolic, Hard Resin
STD-1081	Flashlight - Explosion Proof
STD-1194	Crane - Lift, 250 Lb (113 kg) Capacity, Lift Range 20 to 60 Inches (508-1524 Millimeters)
STD-12395	Load Cell Equipment

D. Consumable Materials

Reference	Description	Specification
G50305	Sheeting - Plastic, Polyethylene	

E. Location Zones

Zone	Area
500	Left Wing
527	Left Winglet
534	Left Wing - Dry Bay
600	Right Wing
627	Right Winglet
634	Right Wing - Dry Bay

F. Access Panels

Number	Name/Location
527BB	ACCESS PANEL - CENTER INBOARD LOWER PANEL, WINGLET
534BB	Dry Bay Tank Access Door - Left Wing Station 748
571FB	Lower Outboard Fixed Trailing Edge Wedge Access Panel
627BB	ACCESS PANEL - CENTER INBOARD LOWER PANEL, WINGLET
634BB	Dry Bay Tank Access Door - Right Wing Station 748
671FB	Lower Outboard Fixed Trailing Edge, Wedge Access Panel

G. Prepare for the Removal

SUBTASK 57-31-21-860-001

- (1) Make sure that the airplane is correctly grounded (TASK 20-40-11-910-801).

SUBTASK 57-31-21-860-004

- (2) Open these circuit breakers and install safety tags:

CAPT Electrical System Panel, P18-3

Row	Col	Number	Name
A	12	C04052	EXTERIOR LIGHTING POSITION RIGHT

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CAPT Electrical System Panel, P18-3

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	13	C04051	EXTERIOR LIGHTING POSITION LEFT

SUBTASK 57-31-21-040-001



DO THE DEACTIVATION PROCEDURE FOR THE TRAILING EDGE FLAP BEFORE YOU DO WORK ON THE FLAP SYSTEM. THE FLAPS MOVE QUICKLY. THEY CAN CAUSE INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

- (3) Do this task: Trailing Edge Flap System Deactivation, TASK 27-51-00-040-801.

SUBTASK 57-31-21-040-002



DO THE DEACTIVATION PROCEDURE FOR THE LEADING EDGE FLAPS. THE ACCIDENTAL MOVEMENT OF THE FLAPS CAN CAUSE INJURY TO PERSONS AND DAMAGE TO EQUIPMENT.

- (4) Do this task: Leading Edge Flaps and Slats - Deactivation, TASK 27-81-00-040-801.

SUBTASK 57-31-21-490-001

- (5) Get a ladder, work platform, COM-2480, or maintenance platform, COM-659.

NOTE: A scissors-type, mobile work platform or scaffold maintenance platform is recommended for two persons, one person to control the movement of the winglet which is suspended from the crane/sling and the other person to remove the winglet bolts and the grounding straps.

SUBTASK 57-31-21-490-002

- (6) Get an overhead, 250 lb (113 kg) capacity crane, STD-1194, for the sling equipment.

NOTE: The complete sling assembly weighs 20 lb (9 kg). The winglet weighs 185 lb (84 kg).

SUBTASK 57-31-21-490-003

- (7) Use the holding fixture, SPL-14633, or prepare a location to store the winglet [1] after it is removed from the airplane.

- (a) If the holding fixture, SPL-14633, is not available, use a support structure covered with plastic sheeting, G50305, for the winglet [1].

SUBTASK 57-31-21-860-002

- (8) Do these steps to prepare metal support equipment such as work platforms, work/maintenance stands, ladders:

NOTE: These steps apply to all metal support equipment within a 50 ft (15 m) radius of an open fuel tank.

- (a) All support equipment must be in place before you begin the procedure.
- (b) Bond the support equipment at an approved airplane bonding location.
- (c) Ground the support equipment to the same earth ground as the airplane.

SUBTASK 57-31-21-020-001

- (9) Remove these dry bay access doors located under the wing, adjacent to the outboard rib 27 (TASK 57-31-23-000-801).

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- (a) Open these access doors.

<u>Number</u>	<u>Name/Location</u>
534BB	Dry Bay Tank Access Door - Left Wing Station 748
634BB	Dry Bay Tank Access Door - Right Wing Station 748

SUBTASK 57-31-21-010-008

- (10) Do this task: Transition Fairing Removal, TASK 57-31-25-010-801.

SUBTASK 57-31-21-010-003



BE CAREFUL IF YOU USE A HARD RESIN PHENOLIC SCRAPER TO REMOVE SEALANTS AND COMPOUNDS TO DISCONNECT THE FAIRINGS BETWEEN THE WING AND THE WINGLET. IF YOU ARE NOT CAREFUL, DAMAGE TO THE EROSION PROTECTION TAPE CAN OCCUR.

- (11) Remove the access panels between the wing and the winglet [1]:

<u>Number</u>	<u>Name/Location</u>
527BB	ACCESS PANEL - CENTER INBOARD LOWER PANEL, WINGLET
571FB	Lower Outboard Fixed Trailing Edge Wedge Access Panel
627BB	ACCESS PANEL - CENTER INBOARD LOWER PANEL, WINGLET
671FB	Lower Outboard Fixed Trailing Edge, Wedge Access Panel

H. Winglet Removal

SUBTASK 57-31-21-000-001

- (1) Do this task: Winglet (AFT) Marker and Winglet Anti-Collision Lights - Disconnect the Electrical Connectors, TASK 33-43-10-020-801.

SUBTASK 57-31-21-020-011

- (2) Disconnect the forward bonding jumper [4] as follows (View C, Figure 401):
- (a) Remove the nut [5] and washer [6] from the outboard rib of the wing.
 - (b) Remove the bonding jumper [4] from the lug on the wing rib.
 - (c) Store the nut [5] and washer [6] in a bag for the installation.

SUBTASK 57-31-21-100-001



BE CAREFUL WHEN YOU USE A HARD RESIN PHENOLIC SCRAPER TO REMOVE SEALANTS AND COMPOUNDS TO DISCONNECT THE WINGLET FROM THE WING. IF YOU ARE NOT CAREFUL, DAMAGE TO THE EROSION PROTECTION TAPE CAN OCCUR.

- (3) Do these steps to remove the corrosion inhibiting material and sealant between the winglet [1] and wing rib:
- (a) Remove corrosion inhibiting material with a hard resin phenolic scraper, STD-1064, around the faying surfaces of rib 27 on the wing and winglet [1] root rib (View A-A, Figure 401).
 - (b) Remove sealant around the external gap on the upper surface of the winglet [1] (View D, Figure 401).

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SUBTASK 57-31-21-100-005



BE CAREFUL WHEN YOU USE A HARD RESIN PHENOLIC SCRAPER TO REMOVE SEALANTS AND COMPOUNDS TO DISCONNECT THE WINGLET FROM THE WING. IF YOU ARE NOT CAREFUL, DAMAGE TO THE EROSION PROTECTION TAPE CAN OCCUR.

- (4) Remove the aerodynamic sealant with a hard resin phenolic scraper, STD-1064, from the necessary areas to disengage the winglet [1] from the wing (Figure 57-31-21-990-810).

SUBTASK 57-31-21-020-002

- (5) Install the sling, SPL-2044, on the winglet [1] (Figure 402).

NOTE: The sling equipment has three attachment fittings, six screws and washers, a sling strap assembly, a load cell, STD-12395.

- (a) Remove the bolts from the winglet [1] where the attachment fittings for the sling, SPL-2044, will be attached to the winglet [1].
- (b) Store the bolts in a bag for the installation procedure.
- (c) Install the bolts and washers to attach the attachment fittings to the winglet [1].

NOTE: The attachment bolts and washers for the sling are stored in the threaded storage holes on the end surfaces of the attachment fittings.

- 1) Tighten the bolts to 50 in-lb (6 N·m) - 80 in-lb (9 N·m).
- (d) Attach the sling strap assembly to the fittings.

SUBTASK 57-31-21-420-001

- (6) Attach the sling, SPL-2044, to the overhead crane.

NOTE: The winglet weighs approximately 185 lb (84 kg).

SUBTASK 57-31-21-800-001



DO NOT LIFT THE WINGLET WITH A FORCE THAT IS MORE THAN 210-LBS. IF YOU USE A FORCE THAT IS MORE THAN 210-LBS, IT CAN CAUSE DAMAGE TO THE AIRPLANE AND INJURY TO PERSONNEL.

- (7) Use the load cell, STD-12395, to make sure that the force used when lifting the winglet [1] is not more than 210 lb (95 kg).

NOTE: The value for the weight of the winglet is 185 lb (84 kg).

SUBTASK 57-31-21-500-001

- (8) Operate the overhead crane to lift the sling equipment until the lines equally support the winglet [1].

NOTE: Operate the overhead crane to a tension that will let you loosen the bolts that attach the winglet without damage to the bolt threads or to the winglet.

SUBTASK 57-31-21-490-004

- (9) Use an explosion proof flashlight, STD-1081, when you look inside the dry bay tank.

SUBTASK 57-31-21-020-003

- (10) Remove the bolts [10] and washers [11] from the center of the winglet [1] in the order sequence (Table 401, View A-A, Figure 401).

- (a) Put the bolts and washers on a foam or cardboard piece.
 - 1) Make sure to set the fasteners on the foam or cardboard piece to align with the removal order sequence.

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- (b) Make sure to label the foam or cardboard piece since the diameters and lengths are different for each attachment location.

Table 401/57-31-21-993-805 Winglet Attachment Bolt Removal

ITEM	BOLT	REMOVAL ORDER	LOCATION
[10]	BACB30US7K13M 0.4375 in. (11.1125 mm) dia.	K	Middle Upper and Lower
[7]	BACB30US8K21M 0.5000 in. (12.7000 mm) dia.	J	Upper Aft (Front)
[9]	BACB30US8K21M 0.5000 in. (12.7000 mm) dia.	I	Lower Forward (Front)
[7]	BACB30US8K21M 0.5000 in. (12.7000 mm) dia.	H	Lower Aft (Front)
[9]	BACB30US8K21M 0.5000 in. (12.7000 mm) dia.	G	Upper Forward (Back)
[7]	BACB30US8K21M 0.5000 in. (12.7000 mm) dia.	F	Upper Aft (Middle)
[9]	BACB30US8K21M 0.5000 in. (12.7000 mm) dia.	E	Lower Forward (Back)
[7]	BACB30US8K21M 0.5000 in. (12.7000 mm) dia.	D	Lower Aft (Middle)
[9]	BACB30US8K21M 0.5000 in. (12.7000 mm) dia.	C	Upper Forward (Front)
[12]	BACB30US8K19M 0.5000 in. (12.7000 mm) dia.	B	Lower Aft (Back)
[12]	BACB30US8K19M 0.5000 in. (12.7000 mm) dia.	A	Upper Aft (Back)

SUBTASK 57-31-21-020-005

- (11) Disconnect the aft bonding jumper [18] (View B, Figure 401).
- (a) Remove the nut [19] and washer [20] from the outboard rib of the wing.
 - (b) Remove the bonding jumper [18] from the lug on the wing rib.
 - (c) Store the nut [19] and washer [20] in a bag for the installation procedure.

SUBTASK 57-31-21-020-004

- (12) Remove the forward and aft bolts [7], bolts [9], bolts [12], and washers [8] in the order sequence (Table 401, View A-A, Figure 401).
- (a) You must control the movement of the sling and the winglet [1] as you remove the attachment fasteners.

NOTE: A second person is recommended to control the movement of the winglet which is suspended from the crane/sling. A gust of wind could cause the winglet to move as you remove the attachment fasteners.
 - (b) Remove the radius filler [13] when you remove the bolts [7] and washers [8].
 - (c) Put the bolts and washers on a foam or cardboard piece.

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- 1) Make sure to set the fasteners on the foam or cardboard piece to align with the removal order sequence.
- (d) Make sure to label the foam or cardboard piece since the diameters and lengths are different for each attachment location.

SUBTASK 57-31-21-900-001

- (13) Use the overhead crane and the sling, SPL-2044, to move the winglet [1] to a holding fixture, SPL-14633, or appropriate storage location.

———— **END OF TASK** ————

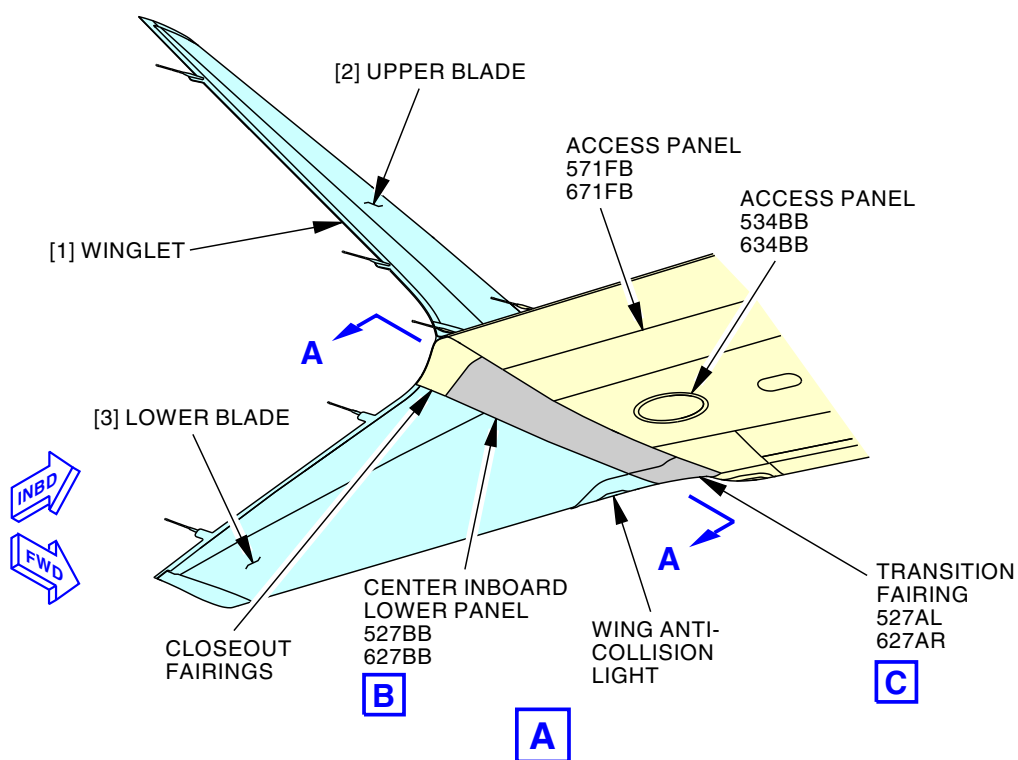
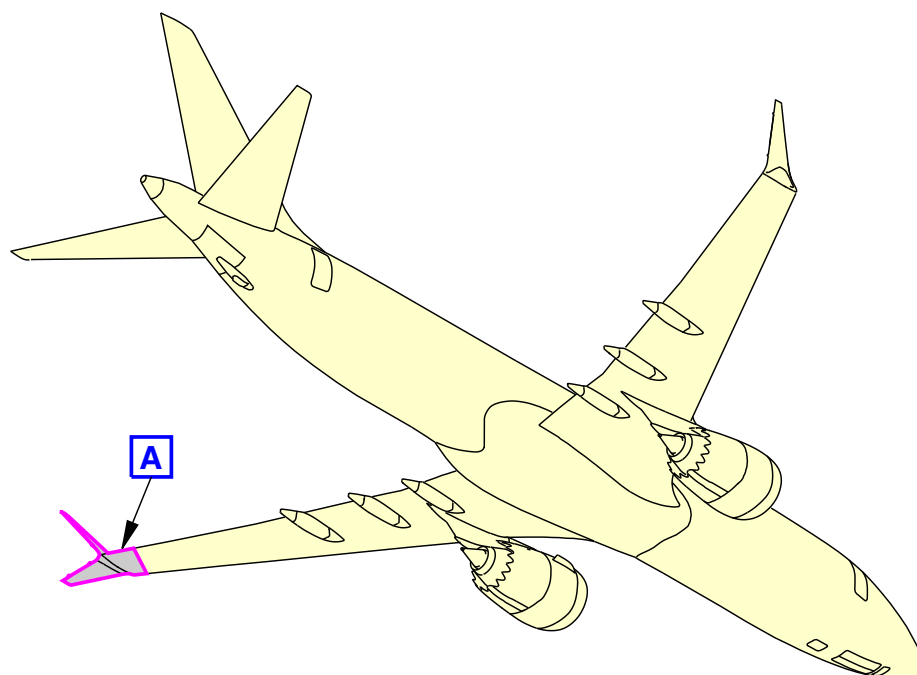
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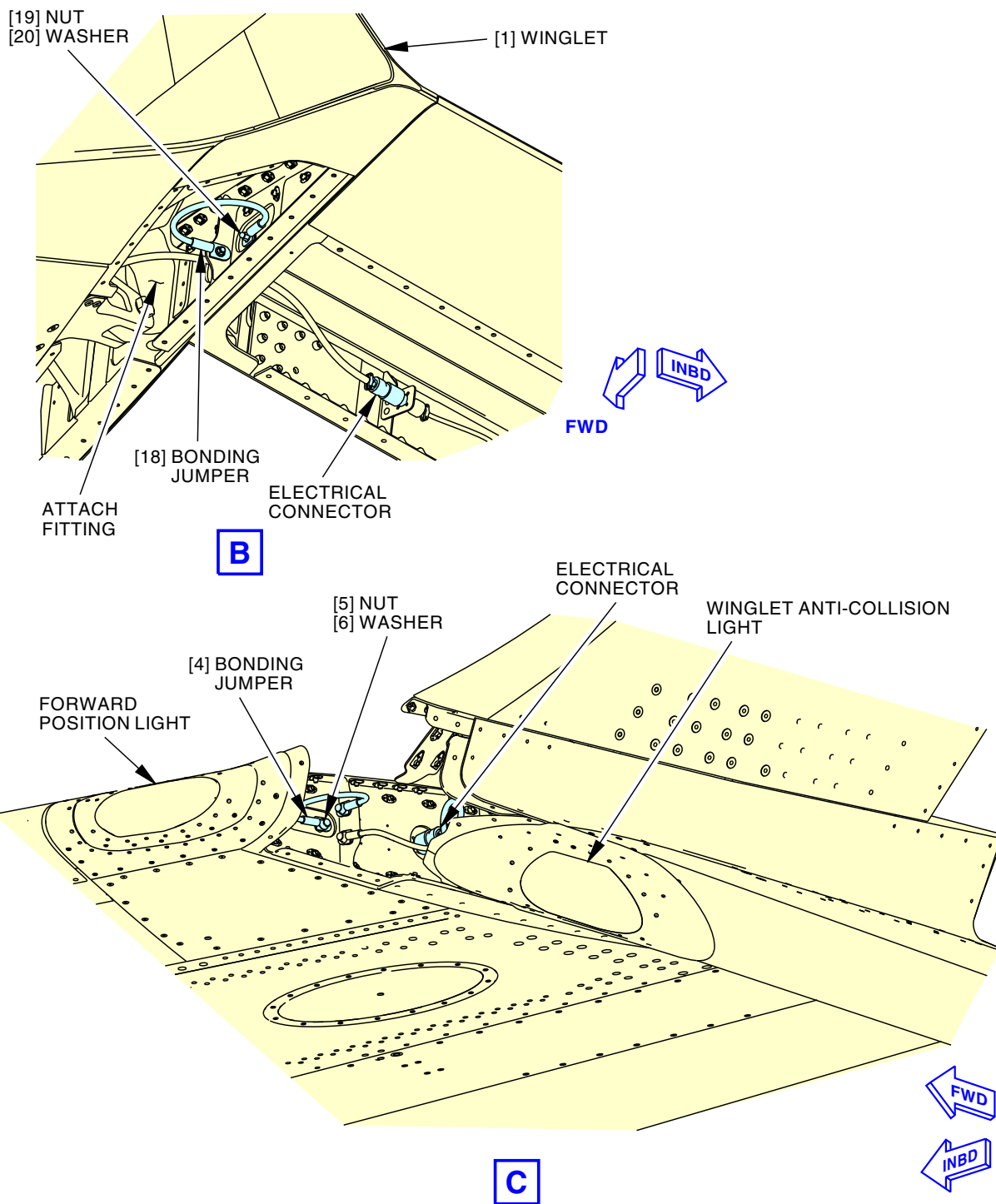
Winglet Installation
Figure 401/57-31-21-990-804 (Sheet 1 of 5)

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Winglet Installation
Figure 401/57-31-21-990-804 (Sheet 2 of 5)

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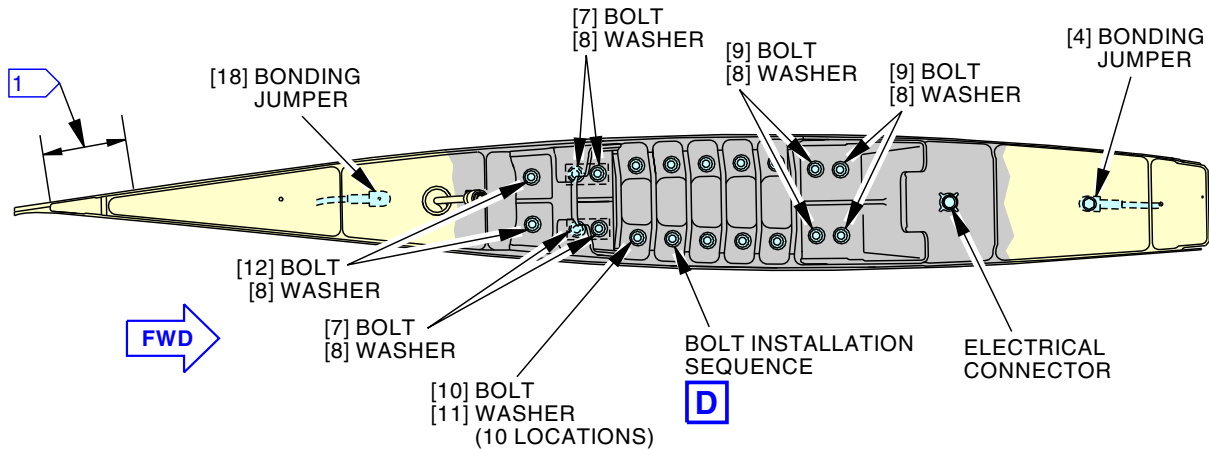
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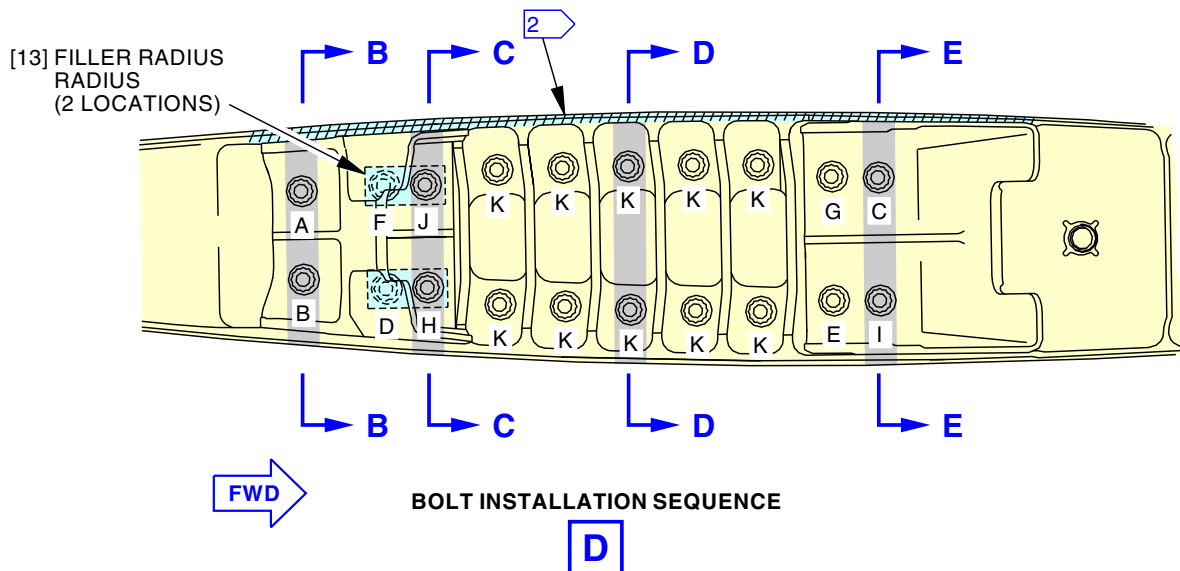
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**RIB 27
(VIEW IN THE OUTBOARD DIRECTION)
A-A**



NOTE: 1. A THRU K ARE THE ORDER OF THE INSTALLATION FOR THE BOLTS.

2. K THRU A IS THE REVERSE ORDER FOR REMOVAL OF THE BOLTS.

1 6.000 ±0.500 INCH (152.4 ±12.7 mm), ONLY UPPER SURFACE, MAXIMUM ALLOWED MISFAIR 0.1200 INCH (3.048 mm)

2 AERODYNAMIC SEAL WITH BMS 5-95 OR BMS 5-142 TYPE II, ///

2416628 S00061541170_V3

**Winglet Installation
Figure 401/57-31-21-990-804 (Sheet 3 of 5)**

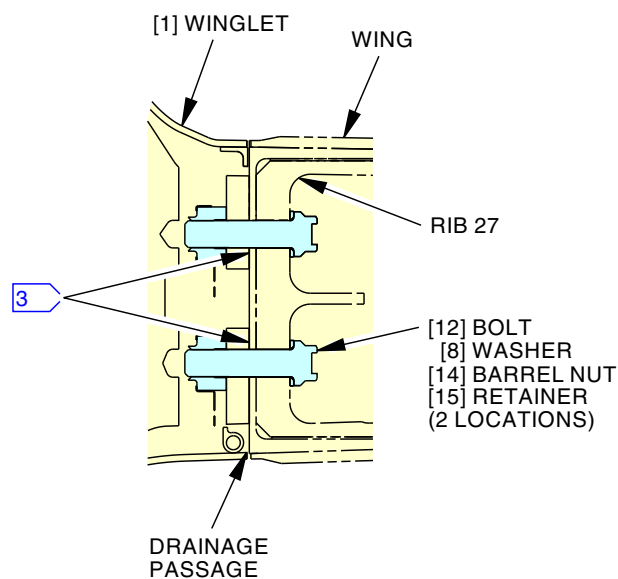
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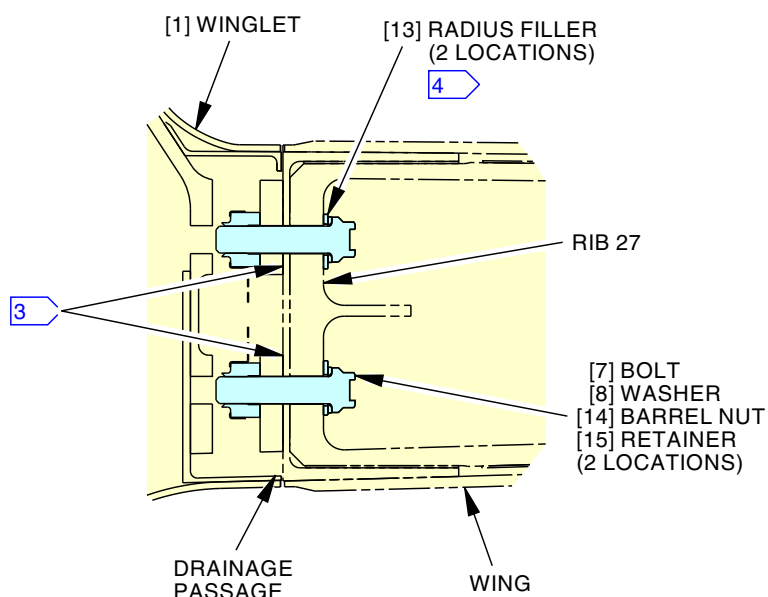
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B-B



C-C

- [3] APPLY CORROSION INHIBITING COMPOUND
- [4] ONLY BOLT [7] INSTALLATION

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Winglet Installation
Figure 401/57-31-21-990-804 (Sheet 4 of 5)

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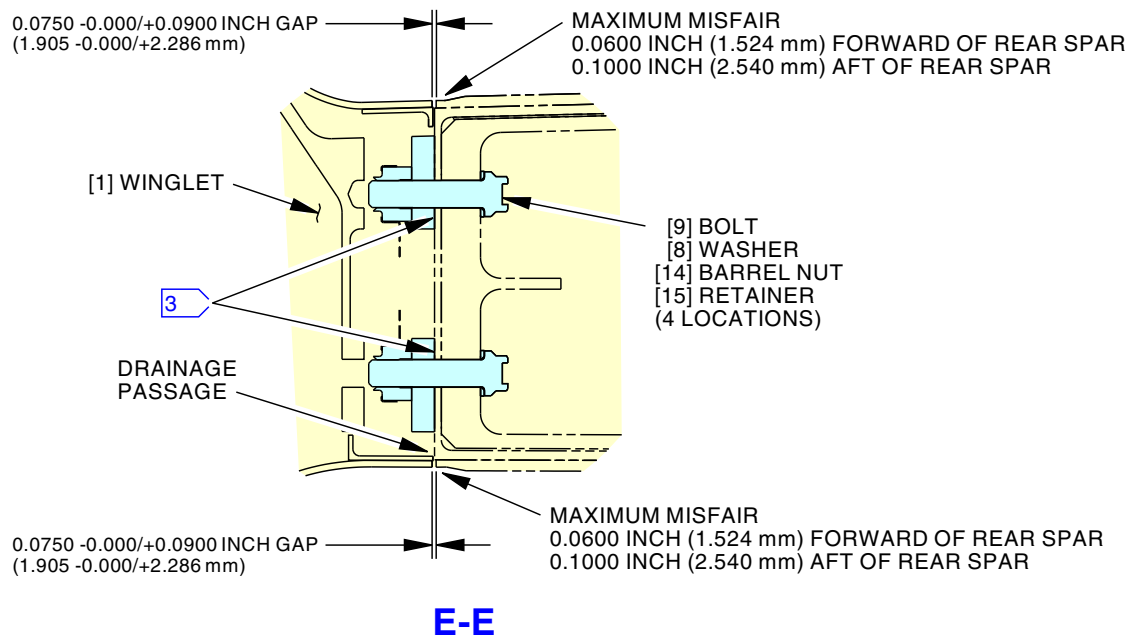
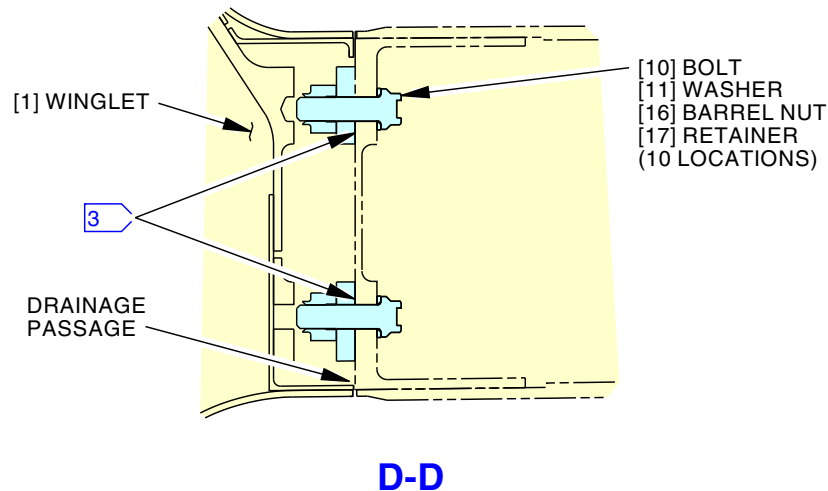
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**Winglet Installation
Figure 401/57-31-21-990-804 (Sheet 5 of 5)**

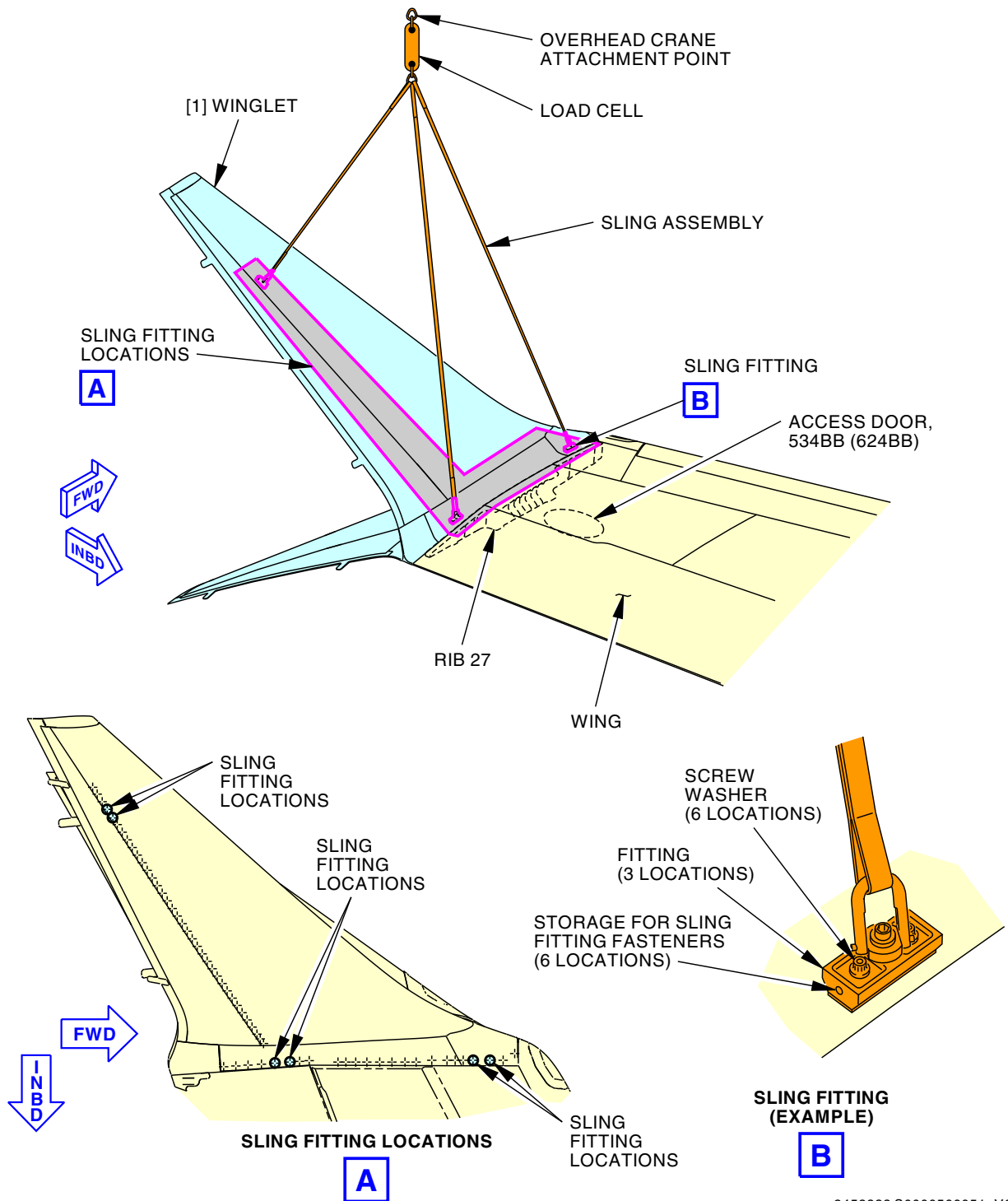
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Winglet Sling Installation
Figure 402/57-31-21-990-805

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TASK 57-31-21-400-801

3. **Winglet Installation**

(Figure 401 and Figure 402)

A. General

- (1) This task gives the instructions to install the winglet on the left or right wing. The winglet assembly consists of the upper blade and lower blade.
- (2) To install the winglet, a second person is needed.

B. References

Reference	Title
27-51-00-040-801	Trailing Edge Flap System Deactivation (P/B 201)
27-51-00-440-801	Trailing Edge Flap System Reactivation (P/B 201)
27-81-00-040-801	Leading Edge Flaps and Slats - Deactivation (P/B 201)
27-81-00-440-801	Leading Edge Flaps and Slats - Activation (P/B 201)
33-43-10-420-801	Winglet (AFT) Marker and Winglet Anti-Collision Lights - Connect the Electrical Connectors (P/B 201)
57-31-21-390-801	Winglet Aerodynamic Sealant Repair (P/B 801)
57-31-23-400-801	Dry Bay Access Doors Installation (P/B 401)
57-31-23-790-801	Vapor Seal Leak Check (P/B 601)
57-31-24-200-801	Winglet Erosion Protection Inspection (P/B 601)
57-31-25-410-801	Transition Fairing Installation (P/B 401)
SWPM 20-20-00	ELECTRICAL BONDING PROCESSES

C. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt.", which stands for Optional.

Reference	Description
COM-659	Platform - Maintenance Lift, 3 ft Minimum Height, 12.5 ft Maximum Height Part #: 1135-8000 Supplier: 00994 Opt Part #: 8662-010 Supplier: 00994
COM-1550	Bonding Meter - Approved, Intrinsically Safe (Approved for use in Class I, Divisions I & II hazardous (classified) locations. Outside these hazardous locations, COM-614 can be used in lieu of COM-1550). Part #: 620LK Supplier: 1CRL2 Part #: M1 Supplier: 3AD17 Part #: M1B Supplier: 3AD17 Part #: T477W (C15292) Supplier: 06659
COM-1587	Wrench - Torque, 30 in-lbs (4 N-m) Part #: TE3FUA Supplier: 55719
COM-2480	Platform - Mobile Elevating Work Platform SJ III Series Part #: SJIII 4726 Supplier: 3AF08 Part #: SJIII 4732 Supplier: 3AF08 Opt Part #: SJIII 4620 Supplier: 3AF08 Opt Part #: SJIII 4626 Supplier: 3AF08 Opt Part #: SJIII 4632 Supplier: 3AF08

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Reference	Description
SPL-2044	Sling - Winglet Part #: C57002-66 Supplier: 81205
SPL-19986	Torque Adapter, Ratcheting Part #: ST2580-550A Supplier: 81205
STD-247	Crane - Lift, 250 lb Capacity, Lift Range 20 to 60 in
STD-1081	Flashlight - Explosion Proof
STD-13964	Wrench - Torque, 200 to 1000 in-lb

D. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
A02315	Sealant - Low Density, Synthetic Rubber. 2 Part	BMS5-142 Type II
C00528	Compound - Corrosion Preventive, Petroleum Hot Application (Soft Film)	MIL-C-11796 Class III
G50136	Compound - Corrosion Inhibiting, Non-drying Paste	BMS3-38

E. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Winglet	57-31-00-01-115	SIA 001-014
		57-31-21-01-110	SIA ALL
		57-31-21-01-115	SIA ALL
		57-31-21-01-800	SIA ALL
		57-31-21-01-805	SIA ALL

F. Location Zones

Zone	Area
500	Left Wing
527	Left Winglet
534	Left Wing - Dry Bay
600	Right Wing
627	Right Winglet
634	Right Wing - Dry Bay

G. Access Panels

Number	Name/Location
527BB	ACCESS PANEL - CENTER INBOARD LOWER PANEL, WINGLET
534BB	Dry Bay Tank Access Door - Left Wing Station 748
571FB	Lower Outboard Fixed Trailing Edge Wedge Access Panel
627BB	ACCESS PANEL - CENTER INBOARD LOWER PANEL, WINGLET
634BB	Dry Bay Tank Access Door - Right Wing Station 748
671FB	Lower Outboard Fixed Trailing Edge, Wedge Access Panel

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H. Winglet Installation

SUBTASK 57-31-21-370-001

- (1) Make sure that the erosion protection tape is in serviceable condition (TASK 57-31-24-200-801).

SUBTASK 57-31-21-860-006

- (2) Make sure that these circuit breakers are open and have safety tags:

CAPT Electrical System Panel, P18-3

Row	Col	Number	Name
A	12	C04052	EXTERIOR LIGHTING POSITION RIGHT
A	13	C04051	EXTERIOR LIGHTING POSITION LEFT

SUBTASK 57-31-21-040-010



DO THE TRAILING EDGE FLAP DEACTIVATION PROCEDURE BEFORE YOU DO WORK ON THE FLAP SYSTEM. WITH THE FLAPS ACTIVATED, THE FLAPS CAN MOVE AND CAUSE INJURY TO PERSONS OR DAMAGE TO EQUIPMENT.

- (3) If the trailing edge flap system has not been deactivated, do this task: Trailing Edge Flap System Deactivation, TASK 27-51-00-040-801.

SUBTASK 57-31-21-040-011



DO THE DEACTIVATION PROCEDURE FOR THE LEADING EDGE FLAPS. THE ACCIDENTAL MOVEMENT OF THE FLAPS CAN CAUSE INJURY TO PERSONS AND DAMAGE TO EQUIPMENT.

- (4) If the leading edge flaps and slats have not been deactivated, do this task: Leading Edge Flaps and Slats - Deactivation, TASK 27-81-00-040-801.

SUBTASK 57-31-21-420-002

- (5) Install the sling, SPL-2044, on the winglet [1] (Figure 402).

NOTE: The sling equipment has three attachment fittings, six screws and washers, a sling strap assembly.

- (a) Remove the bolts from the winglet [1] where the attachment fittings for the sling, SPL-2044, will be attached to the winglet [1].
- (b) Store the bolts in a bag.
- (c) Attach the attachment fittings to the winglet [1] with the screws and washers.

NOTE: The attachment screws and washers for the sling are stored in the threaded storage holes on the end surfaces of the attachment fittings.

- 1) Tighten the screws to 50 in-lb (6 N·m) - 80 in-lb (9 N·m).
- (d) Attach the sling strap assembly to the fittings.

SUBTASK 57-31-21-420-003

- (6) Attach the sling, SPL-2044, to the overhead, 250 lb capacity lift crane, STD-247 (Figure 402).

NOTE: The winglet weight approximately 185 lb (84 kg).

SUBTASK 57-31-21-390-001

- (7) Apply a thin coat of corrosion inhibiting material, G50136, to these surfaces before the installation:
 - (a) Apply to the entire faying surface of rib 27 on the wing.

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- (b) Apply to the entire faying surface of the winglet [1] root rib.
- (c) Make sure that the drainage passages on the winglet wing root below the barrel nut openings are clear of the corrosion inhibiting compound.

SUBTASK 57-31-21-500-002

- (8) Operate the overhead crane to lift the sling, SPL-2044, until the lines equally support the winglet [1].
 - (a) Balance the overhead crane tension, so the bolts that hold the winglet [1] to the wing can be tightened, without damage to the bolt threads or to the winglet [1].

SUBTASK 57-31-21-480-030

- (9) Use an explosion proof flashlight, STD-1081, when the dry bay tank inside is looked.

SUBTASK 57-31-21-200-001

- (10) Do a check of the locking feature of the barrel nuts [14] and barrel nuts [16] in the winglet [1] as follows (View A-A, Figure 401):
 - (a) Apply a thin coat of corrosion inhibiting material, G50136, to all surfaces of the threads of the bolts [7], bolts [9], and bolts [12].
 - (b) Install the bolts [7], bolts [9], and bolts [12], one at a time, into the correct hole.
 - 1) Use a torque wrench (30 in-lbs), COM-1587, set to 18 in-lb (2 N·m).
 - 2) If the bolts [7], bolts [9], and bolts [12] can be tightened until the threads protrude, the barrel nuts [14] must be replaced.
NOTE: Only replace the discrepant barrel nut.
 - 3) Remove the bolts [7], bolts [9], and bolts [12] from the holes.
 - (c) Apply a thin coat of corrosion inhibiting material, G50136, to the threads of the bolts [10].
 - (d) Install the bolts [10] into the correct holes.
 - 1) Use a torque wrench (30 in-lbs), COM-1587, set to 14 in-lb (2 N·m).
 - 2) If the bolts [10] can be tightened until the threads protrude, the barrel nuts [16] must be replaced.
NOTE: Only replace the discrepant barrel nut.
 - 3) Remove the bolts [10] from the holes.

SUBTASK 57-31-21-960-001

- (11) If it is necessary, replace the barrel nut [14] and barrel nut [16] in the winglet [1].
NOTE: Only replace the discrepant barrel nut.
 - (a) Remove the barrel nut [14] with retainer [15] and barrel nut [16] with retainer [17] through the access holes in the wing root of the winglet [1].
 - (b) Install the new barrel nut [14] with retainer [15] through the access holes in the wing root of the winglet [1].
 - (c) Install the new barrel nut [16] with retainer [17] through the access holes in the wing root of the winglet [1].

SUBTASK 57-31-21-420-005

- (12) Install the winglet [1] (View A-A, Figure 401).
 - (a) If the bolts were not kept on a foam or cardboard piece or the bolts were replaced, make sure that the bolt grip length is correct for the installation location.
 - (b) Apply a thin layer of corrosion inhibiting material, G50136, to all surfaces of the bolt threads, shanks, and under the bolt head prior to installation.

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- (c) Loose install the bolts [12], bolts [9], and bolts [7] in the order sequence (Table 402).

NOTE: Do not tighten the bolts to the final torque value at this time.

NOTE: 6-inch extensions and low profile swivel head sockets can tighten the bolts to approximately 300 in-lb (33.9 N·m). This is an initial torque to seat the bolts.

- 1) Loose install the bolts [12] and washers [8], one at a time, in the sequence shown until seated in the correct holes.
- 2) Loose install the bolts [9] and washers [8], one at a time, in the sequence shown until seated in the correct holes.
- 3) Apply corrosion inhibiting material, G50136, to the faying surface between the radius fillers [13] and rib 27.
- 4) Put the radius fillers [13] into their position.
- 5) Loose install the bolts [7] and washers [6], one at a time, in sequence shown until seated in the correct hole.

- (d) Install the bolts [10] and washers [11], one at a time, until seated.

NOTE: Do not tighten the bolts to the final torque value at this time.

NOTE: 6-inch extensions and low profile swivel head sockets can tighten the bolts to approximately 300 in-lb (33.9 N·m). This is an initial torque to seat the bolts.

Table 402/57-31-21-993-803 Winglet Attachment Bolt Installation Order

ITEM	BOLT	INSTALLATION ORDER	LOCATION	TORQUE
[12]	BACB30US8K19M 0.5000 in. (12.7000 mm) dia.	A	Upper Aft (Back)	630 in-lb (71 N·m) - 670 in-lb (76 N·m)
[12]	BACB30US8K19M 0.5000 in. (12.7000 mm) dia.	B	Lower Aft (Back)	630 in-lb (71 N·m) - 670 in-lb (76 N·m)
[9]	BACB30US8K21M 0.5000 in. (12.7000 mm) dia.	C	Upper Forward (Front)	630 in-lb (71 N·m) - 670 in-lb (76 N·m)
[7]	BACB30US8K21M 0.5000 in. (12.7000 mm) dia.	D	Lower Aft (Middle)	630 in-lb (71 N·m) - 670 in-lb (76 N·m)
[9]	BACB30US8K21M 0.5000 in. (12.7000 mm) dia.	E	Lower Forward (Back)	630 in-lb (71 N·m) - 670 in-lb (76 N·m)
[7]	BACB30US8K21M 0.5000 in. (12.7000 mm) dia.	F	Upper Aft (Middle)	630 in-lb (71 N·m) - 670 in-lb (76 N·m)
[9]	BACB30US8K21M 0.5000 in. (12.7000 mm) dia.	G	Upper Forward (Back)	630 in-lb (71 N·m) - 670 in-lb (76 N·m)
[7]	BACB30US8K21M 0.5000 in. (12.7000 mm) dia.	H	Lower Aft (Front)	630 in-lb (71 N·m) - 670 in-lb (76 N·m)
[9]	BACB30US8K21M 0.5000 in. (12.7000 mm) dia.	I	Lower Forward (Front)	630 in-lb (71 N·m) - 670 in-lb (76 N·m)
[7]	BACB30US8K21M 0.5000 in. (12.7000 mm) dia.	J	Upper Aft (Front)	630 in-lb (71 N·m) - 670 in-lb (76 N·m)
[10]	BACB30US7K13M 0.4375 in. (11.1125 mm) dia.	K	Middle Upper and Lower	427 in-lb (48 N·m) - 453 in-lb (51 N·m)

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- (e) Tighten the bolts [12], bolts [9], and bolts [7] in the order sequence (Table 402).
 - 1) Use the torque wrench, STD-13964, to tighten the bolts [12], bolts [9], and bolts [7].

NOTE: A combination of 6-inch extensions and low profile swivel head sockets can tighten bolts [12] and bolts [9] to the final toque.

NOTE: A combination of 6-inch extensions and low profile swivel head sockets with the torque adapter, SPL-19986, can tighten bolts [7] to the final toque.
- (f) Tighten each of the bolts [10] (Table 402).
 - 1) Use the torque wrench, STD-13964, to tighten the bolts [10].

NOTE: A combination of 6-inch extensions and low profile swivel head sockets can tighten bolts [10] to the final toque.

SUBTASK 57-31-21-400-001

- (13) Connect the aft bonding jumper [18] (View B, Figure 401).
 - (a) Install the bonding jumper [18] on the electrical stud on the wing rib.
 - (b) Install the washer [20] and nut [19] to attach the bonding jumper [18].
 - (c) Measure the electrical bonding resistance between terminal of the bonding jumper [18] and structure (SWPM 20-20-00).
 - 1) Use an intrinsically safe approved bonding meter, COM-1550.
 - 2) Make sure that the electrical bonding resistance is 0.001 ohm (1.0 milliohm) or less.

SUBTASK 57-31-21-420-010

- (14) Connect the forward bonding jumper [4] (View C, Figure 401).
 - (a) Install the bonding jumper [4] on the electrical stud on the wing rib.
 - (b) Install the washer [6] and nut [5] to attach the bonding jumper [4].
 - (c) Measure the electrical bonding resistance between terminal of the bonding jumper [4] and structure (SWPM 20-20-00).
 - 1) Use an intrinsically safe approved bonding meter, COM-1550.
 - 2) Make sure that the electrical bonding resistance is 0.001 ohm (1.0 milliohm) or less.

SUBTASK 57-31-21-420-004

- (15) Do this task: Winglet (AFT) Marker and Winglet Anti-Collision Lights - Connect the Electrical Connectors, TASK 33-43-10-420-801.

SUBTASK 57-31-21-420-006

- (16) Make sure that the misfair is in the limits (View A-A, Figure 401):
 - (a) Make sure that the aft 6.0 ± 0.5 in. (152.4 ± 12.7 mm) of the winglet [1] is aligns with the upper wing surface to within 0.1200 in. (3.0480 mm).
 - (b) Make sure that the winglet [1] aligns with the upper and lower wing surface forward of the rear spar to within 0.06 in. (1.524 mm).
 - (c) Make sure that the winglet [1] aligns with the upper and lower wing surface aft of the rear spar to within 0.10 in. (2.54 mm).
 - (d) Make sure that the space between the winglet [1] and the upper and lower wing skin is in the limit of $0.075 +0.090 / -0.000$ in. ($1.905 +2.286 / -0.000$ mm).

SUBTASK 57-31-21-020-006

- (17) Remove the sling, SPL-2044, from the winglet [1].
 - (a) Remove the screws and washers from the attachment fittings.

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- (b) Install the screws and washers in the threaded storage holes in the ends of the attachment fittings.
- (c) Apply compound, C00528, to the holes in the winglet [1] and immediately install the bolts.
- (d) Tighten the bolts to 30 in-lb (3 N·m) - 40 in-lb (5 N·m).

SUBTASK 57-31-21-410-011

- (18) Install the access panels between the wing and winglet:

<u>Number</u>	<u>Name/Location</u>
527BB	ACCESS PANEL - CENTER INBOARD LOWER PANEL, WINGLET
627BB	ACCESS PANEL - CENTER INBOARD LOWER PANEL, WINGLET

- (a) Tighten the fasteners for the lower fairing to a torque tool setpoint of 30 in-lb (3 N·m).

SUBTASK 57-31-21-410-012

- (19) Install the access panels between the wing and winglet:

<u>Number</u>	<u>Name/Location</u>
571FB	Lower Outboard Fixed Trailing Edge Wedge Access Panel
671FB	Lower Outboard Fixed Trailing Edge, Wedge Access Panel

- (a) Tighten the fasteners for the access panel to a torque tool setpoint of 70 in-lb (8 N·m).

SUBTASK 57-31-21-410-004

- (20) Do this task: Transition Fairing Installation, TASK 57-31-25-410-801.

SUBTASK 57-31-21-390-002

- (21) Apply a seal to the external gap on the upper surface of the winglet [1] between point A and B with sealant, A00247 (View D, Figure 401).

NOTE: It is optional to use sealant, A02315.

SUBTASK 57-31-21-790-001

- (22) If the absolute vapor seal has been moved or changed, do the vapor seal leak check of the dry bay (TASK 57-31-23-790-801).

I. Put the Airplane Back to Its Usual Condition

SUBTASK 57-31-21-410-001

- (1) Install these access doors on the left or right wing (TASK 57-31-23-400-801).
- (a) Close these access doors.

<u>Number</u>	<u>Name/Location</u>
534BB	Dry Bay Tank Access Door - Left Wing Station 748
634BB	Dry Bay Tank Access Door - Right Wing Station 748

SUBTASK 57-31-21-390-007

- (2) Do this task: Winglet Aerodynamic Sealant Repair, TASK 57-31-21-390-801.

SUBTASK 57-31-21-090-001

- (3) Remove the ladders, work platform, COM-2480, or maintenance platform, COM-659, from the work area.

SUBTASK 57-31-21-860-005

- (4) Remove the safety tags and close these circuit breakers:

CAPT Electrical System Panel, P18-3

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	12	C04052	EXTERIOR LIGHTING POSITION RIGHT

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CAPT Electrical System Panel, P18-3

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	13	C04051	EXTERIOR LIGHTING POSITION LEFT

SUBTASK 57-31-21-440-001

(5) Do this task: Trailing Edge Flap System Reactivation, TASK 27-51-00-440-801.

SUBTASK 57-31-21-440-002

(6) Do this task: Leading Edge Flaps and Slats - Activation, TASK 27-81-00-440-801.

————— **END OF TASK** —————

TASK 57-31-21-000-802

4. Winglet Lower Blade Removal

(Figure 403 and Figure 404)

A. General

(1) This task gives instructions for the removal of the winglet lower blade.

B. References

Reference	Title
20-40-11-910-801	Static Grounding (P/B 201)
27-51-00-040-801	Trailing Edge Flap System Deactivation (P/B 201)
27-51-00-440-801	Trailing Edge Flap System Reactivation (P/B 201)
27-81-00-040-801	Leading Edge Flaps and Slats - Deactivation (P/B 201)
27-81-00-440-801	Leading Edge Flaps and Slats - Activation (P/B 201)
33-43-10-020-801	Winglet (AFT) Marker and Winglet Anti-Collision Lights - Disconnect the Electrical Connectors (P/B 201)
33-44-13-000-801	Winglet Anti-Collision Light Removal (P/B 201)
57-31-21-390-801	Winglet Aerodynamic Sealant Repair (P/B 801)
57-31-21-480-801	Winglet Cover Plate Installation (P/B 201)
57-31-25-010-801	Transition Fairing Removal (P/B 401)
57-31-25-410-801	Transition Fairing Installation (P/B 401)
SRM 51-40-02-0G-0	Fastener Installation and Removal

C. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
COM-659	Platform - Maintenance Lift, 3 ft Minimum Height, 12.5 ft Maximum Height Part #: 1135-8000 Supplier: 00994 Opt Part #: 8662-010 Supplier: 00994
COM-2480	Platform - Mobile Elevating Work Platform SJ III Series Part #: SJIII 4726 Supplier: 3AF08 Part #: SJIII 4732 Supplier: 3AF08 Opt Part #: SJIII 4620 Supplier: 3AF08 Opt Part #: SJIII 4626 Supplier: 3AF08 Opt Part #: SJIII 4632 Supplier: 3AF08

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Reference	Description
SPL-1556	Hoist - Boom, General, 400 Pound Maximum Capacity Part #: A20001-185 Supplier: 81205 Opt Part #: A20001-152 Supplier: 81205 Opt Part #: A20001-82 Supplier: 81205
SPL-2044	Sling - Winglet Part #: C57002-66 Supplier: 81205
SPL-6658	Long Hoist Arm Assembly Part #: A20001-65 Supplier: 81205
SPL-14633	Winglet Holding Fixture Part #: C57006-1 Supplier: 81205
STD-1064	Scraper - Phenolic, Hard Resin
STD-20668	Bumper - Foam Cushion

D. Consumable Materials

Reference	Description	Specification
G01912	Lockwire - MS20995NC32, Monel - 0.032 Inch (0.8128 mm) Diameter	NASM20995
G50305	Sheeting - Plastic, Polyethylene	
G51674	Kit - Safety Cable, 321 CRES - 0.032 Inch (0.81 mm) Diameter, (Contains both Cable and Ferrule), 12 Inches Long	BACC13AT3K12

E. Location Zones

Zone	Area
118	Electrical and Electronics Compartment - Right
500	Left Wing
527	Left Winglet
534	Left Wing - Dry Bay
600	Right Wing
627	Right Winglet
634	Right Wing - Dry Bay

F. Access Panels

Number	Name/Location
527BB	ACCESS PANEL - CENTER INBOARD LOWER PANEL, WINGLET
527BL	ACCESS PANEL - CENTER OUTBOARD PANEL, WINGLET
571FB	Lower Outboard Fixed Trailing Edge Wedge Access Panel
627BB	ACCESS PANEL - CENTER INBOARD LOWER PANEL, WINGLET
627BR	ACCESS PANEL - CENTER OUTBOARD PANEL, WINGLET
671FB	Lower Outboard Fixed Trailing Edge, Wedge Access Panel

G. Prepare for the Removal

SUBTASK 57-31-21-860-003

- (1) Make sure that the airplane is properly grounded (TASK 20-40-11-910-801).

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SUBTASK 57-31-21-860-009

- (2) Open these circuit breakers and install safety tags:

CAPT Electrical System Panel, P18-3

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	12	C04052	EXTERIOR LIGHTING POSITION RIGHT
A	13	C04051	EXTERIOR LIGHTING POSITION LEFT

SUBTASK 57-31-21-040-003



DO THE DEACTIVATION PROCEDURE FOR THE TRAILING EDGE FLAP BEFORE YOU DO WORK ON THE FLAP SYSTEM. THE FLAPS MOVE QUICKLY. THEY CAN CAUSE INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

- (3) Do this task: Trailing Edge Flap System Deactivation, TASK 27-51-00-040-801.

SUBTASK 57-31-21-040-004



DO THE DEACTIVATION PROCEDURE FOR THE LEADING EDGE FLAPS. THE ACCIDENTAL MOVEMENT OF THE FLAPS CAN CAUSE INJURY TO PERSONS AND DAMAGE TO EQUIPMENT.

- (4) Do this task: Leading Edge Flaps and Slats - Deactivation, TASK 27-81-00-040-801.

SUBTASK 57-31-21-480-001

- (5) Get a ladder, work platform, COM-2480, or maintenance platform, COM-659.

NOTE: A scissors-type, mobile work platform or scaffold maintenance platform is recommended for two persons, one person to control the movement of the winglet that is suspended from the boom hoist/sling and other person to remove the winglet bolts and grounding straps.

SUBTASK 57-31-21-480-002

- (6) Use a boom hoist, SPL-1556, with a long hoist arm, SPL-6658, for the sling equipment.

NOTE: The complete sling assembly weighs 20 lb (9 kg). The winglet lower blade weighs 48 lb (22 kg).



MAKE SURE TO ATTACH BUMPERS TO THE BOOM HOIST AND THE LONG HOIST ARM. IF YOU DO NOT ATTACH THE BUMPERS, DAMAGE TO THE WINGLET LOWER BLADE AND UPPER BLADE CAN OCCUR.

- (a) Attach the bumpers, STD-20668, around the necessary areas of the boom hoist and long hoist arm attachment.

SUBTASK 57-31-21-480-003

- (7) Use the holding fixture, SPL-14633, or prepare a location to store the lower blade [3].

NOTE: If the holding fixture, SPL-14633, is not available, a support structure covered with plastic sheeting, G50305, can be used for the lower blade.

SUBTASK 57-31-21-480-004

- (8) Do these steps to prepare metal support equipment such as work platforms, work/maintenance stands, ladders:

NOTE: These steps apply to all metal support equipment within a 50 ft (15 m) radius of an open fuel tank.

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- (a) All support equipment must be in place before the procedure is begun.
- (b) Bond the support equipment at an approved airplane bonding location.
- (c) Ground the support equipment to the same earth ground as the airplane.

SUBTASK 57-31-21-010-009

- (9) Do this task: Transition Fairing Removal, TASK 57-31-25-010-801.

SUBTASK 57-31-21-010-007



BE CAREFUL IF YOU USE A HARD RESIN PHENOLIC SCRAPER TO REMOVE SEALANTS AND COMPOUNDS TO DISCONNECT THE FAIRINGS BETWEEN THE WING AND THE WINGLET. IF YOU ARE NOT CAREFUL, DAMAGE TO THE EROSION PROTECTION TAPE CAN OCCUR.

- (10) Remove the access panels between the wing and the winglet:

<u>Number</u>	<u>Name/Location</u>
527BB	ACCESS PANEL - CENTER INBOARD LOWER PANEL, WINGLET
527BL	ACCESS PANEL - CENTER OUTBOARD PANEL, WINGLET
571FB	Lower Outboard Fixed Trailing Edge Wedge Access Panel
627BB	ACCESS PANEL - CENTER INBOARD LOWER PANEL, WINGLET
627BR	ACCESS PANEL - CENTER OUTBOARD PANEL, WINGLET
671FB	Lower Outboard Fixed Trailing Edge, Wedge Access Panel

SUBTASK 57-31-21-020-008

- (11) Disconnect the electrical connectors for the aft marker light and winglet anti-collision light:
 - (a) Do this task: Winglet (AFT) Marker and Winglet Anti-Collision Lights - Disconnect the Electrical Connectors, TASK 33-43-10-020-801.

SUBTASK 57-31-21-020-009

- (12) Disconnect the forward bonding jumper [51] from the winglet anti-collision light (View C, Figure 403).
 - (a) Remove the sealant from the nut [52] and washer [53].
 - (b) Remove the nut [52] and washer [53].
 - (c) Remove the bonding jumper [51] from the lug on the winglet anti-collision light.
 - (d) Store the nut [52] and washer [53] in a bag for the installation procedure.

SUBTASK 57-31-21-020-007

- (13) If it is necessary, remove the anti-collision light from the winglet [1] (TASK 33-44-13-000-801).

NOTE: The removal of the anti-collision light is only necessary if there is a new lower blade replacement.

H. Winglet Lower Blade Removal

SUBTASK 57-31-21-010-004

- (1) Do these steps to remove the rivets [40] and bolts [42] that attach the center closeout fairing [45] to the winglet [1] (View D, Figure 403):
 - (a) Remove the four rivets [40] (SRM PROCEDURE 51-40-02-0G-0).
 - (b) Remove the bolts [42].

SUBTASK 57-31-21-010-006

- (2) Do this step to remove the bolts [42] that attach the lower closeout fairing [44] to the winglet [1] (View E, Figure 403):

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- (a) Remove the bolts [42].

SUBTASK 57-31-21-100-003



CAUTION

BE CAREFUL WHEN YOU USE A HARD RESIN PHENOLIC SCRAPER TO REMOVE SEALANTS AND COMPOUNDS TO DISCONNECT THE UPPER OR LOWER BLADE FROM THE WINGLET. IF YOU ARE NOT CAREFUL, DAMAGE TO THE EROSION PROTECTION TAPE CAN OCCUR.

- (3) Do these steps to remove the corrosion inhibiting material and sealant between the lower blade [3] and closeout fairings:
- (a) Remove the corrosion inhibiting material with a hard resin phenolic scraper, STD-1064, around the rivet area of the lower blade [3] (View D, Figure 403).
- (b) Remove the sealant with a hard resin phenolic scraper, STD-1064, around fay seal area of the lower closeout fairing [44] (View E, Figure 403).

SUBTASK 57-31-21-100-004



CAUTION

BE CAREFUL WHEN YOU USE A HARD RESIN PHENOLIC SCRAPER TO REMOVE SEALANTS AND COMPOUNDS TO DISCONNECT THE UPPER OR LOWER BLADE FROM THE WINGLET. IF YOU ARE NOT CAREFUL, DAMAGE TO THE EROSION PROTECTION TAPE CAN OCCUR.

- (4) Remove the aerodynamic sealant with a hard resin phenolic scraper, STD-1064, from the necessary areas to disengage the lower blade [3] from the winglet [1] (TASK 57-31-21-390-801).

SUBTASK 57-31-21-480-005

- (5) Install the sling, SPL-2044, on the lower blade [3] (Figure 404).

NOTE: The sling equipment has three attachment fittings, six screws and washers, and a sling strap assembly.

- (a) Remove the six bolts from the lower blade [3] where the attachment fittings are installed for the sling, SPL-2044, to the lower blade [3].
- (b) Store the six bolts in a bag for the installation procedure.
- (c) Install six screws and washers from the sling kit to attach the three attachment fittings to the lower blade [3].
- 1) Tighten the screws to 50 in-lb (6 N·m) - 80 in-lb (9 N·m).

NOTE: The attachment screws and washers for the sling are stored in the threaded storage holes on the end surfaces of the attachment fittings.

- (d) Attach the sling strap assembly to the three fittings.

SUBTASK 57-31-21-480-006



WARNING

DO NOT LIFT THE LOWER BLADE WITH A FORCE THAT IS MORE THAN 60-LBS. IF YOU USE A FORCE THAT IS MORE THAN 60-LBS, IT CAN CAUSE DAMAGE TO THE AIRPLANE AND INJURY TO PERSONNEL.

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(WARNING PRECEDES)



CAUTION

MAKE SURE THAT YOU APPLY MINIMUM TENSION ON THE SLING WHEN YOU REMOVE THE LOWER BLADE. IF YOU DO NOT APPLY MINIMUM TENSION, DAMAGE TO THE AIRPLANE CAN OCCUR.

- (6) Attach the sling, SPL-2044, to the boom hoist (Figure 404).

NOTE: The lower blade weighs approximately 48 lb (22 kg).

SUBTASK 57-31-21-480-008

- (7) Operate the boom hoist to lift the sling equipment until the 3 lines equally support the lower blade [3].
- (a) Balance the boom hoist tension, so the bolts that hold the lower blade [3] to the winglet [1] can be loosened, without damage to the bolt threads or to the lower blade [3].

SUBTASK 57-31-21-020-010

- (8) Remove the lower blade [3] (View B, Figure 403):



CAUTION

BE CAREFUL WHEN YOU REMOVE THE BUSHING FROM THE LOWER PART OF THE FORWARD FITTING ON THE LOWER BLADE. THE BUSHING CAN BECOME VERY LOOSE AND CAN FALL OUT. IF YOU DO NOT OBEY, DAMAGE TO EQUIPMENT CAN OCCUR.

- (a) Remove the cotter pin [32], nut [33], washers [34], bushing [35], and bolt [36] from the lower part of the forward fitting.
- (b) Remove the cotter pin [37], nut [38], washer [39], and bolt [31] from the upper part of the forward fitting.
- (c) Remove the cotter pins [37], nuts [38], washers [39], and bolts [31] from the upper and lower part of the fitting.

SUBTASK 57-31-21-480-009



CAUTION

BE CAREFUL WHEN YOU MANUALLY LOOSEN THE LOWER BLADE TO PREPARE IT FROM WHEN YOU DISCONNECT IT FROM THE WINGLET WITH A BOOM HOIST. IF YOU ARE NOT CAREFUL, DAMAGE TO THE RIVET AREA OF THE LOWER BLADE CAN OCCUR.



CAUTION

BE CAREFUL WHEN YOU USE A BOOM HOIST TO DISCONNECT THE LOWER BLADE FROM THE WINGLET. IF YOU ARE NOT CAREFUL, DAMAGE TO THE RIVET AREA OF THE LOWER BLADE CAN OCCUR.

- (9) Use the boom hoist and sling, SPL-2044, to move the lower blade [3] straight down from the upper blade [2] and to a holding fixture, SPL-14633, or appropriate storage location.

SUBTASK 57-31-21-480-017

- (10) If the airplane will be dispatched without the lower blade [3], do these steps:
- (a) Cap and stow the wirings for the inoperative aft marker light and winglet anti-collision light of the lower blade [3].
- (b) Install these access panels:

<u>Number</u>	<u>Name/Location</u>
527BB	ACCESS PANEL - CENTER INBOARD LOWER PANEL, WINGLET
527BL	ACCESS PANEL - CENTER OUTBOARD PANEL, WINGLET

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(Continued)

<u>Number</u>	<u>Name/Location</u>
571FB	Lower Outboard Fixed Trailing Edge Wedge Access Panel
627BB	ACCESS PANEL - CENTER INBOARD LOWER PANEL, WINGLET
627BR	ACCESS PANEL - CENTER OUTBOARD PANEL, WINGLET
671FB	Lower Outboard Fixed Trailing Edge, Wedge Access Panel

- (c) Install the transition fairing (TASK 57-31-25-410-801).
- (d) Do this task: Winglet Cover Plate Installation, TASK 57-31-21-480-801.
- (e) Set the ALTERNATE VMO/MMO switch (S1127), on the Electronic Equipment (EE) bay service panel, to the ALTN position.
 - 1) Cut the safety cable or lockwire in the switch guard.
 - 2) Lift the switch guard and move the switch to the ALTN position.
 - 3) Move the guard down and lockwire the switch guard using safety cable kit, G51674 (preferred), or MS20995NC32 lockwire, G01912 (alternate), and double twist method.
 - 4) Make sure that the ADR label 270 bit 23 is set to "1".
- (f) Remove the safety tags and close these circuit breakers:

CAPT Electrical System Panel, P18-3

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	12	C04052	EXTERIOR LIGHTING POSITION RIGHT
A	13	C04051	EXTERIOR LIGHTING POSITION LEFT

- (g) Remove the ladder, work platform, COM-2480, or maintenance platform, COM-659, from the work area.
- (h) Do this task: Trailing Edge Flap System Reactivation, TASK 27-51-00-440-801.
- (i) Do this task: Leading Edge Flaps and Slats - Activation, TASK 27-81-00-440-801.

———— **END OF TASK** ————

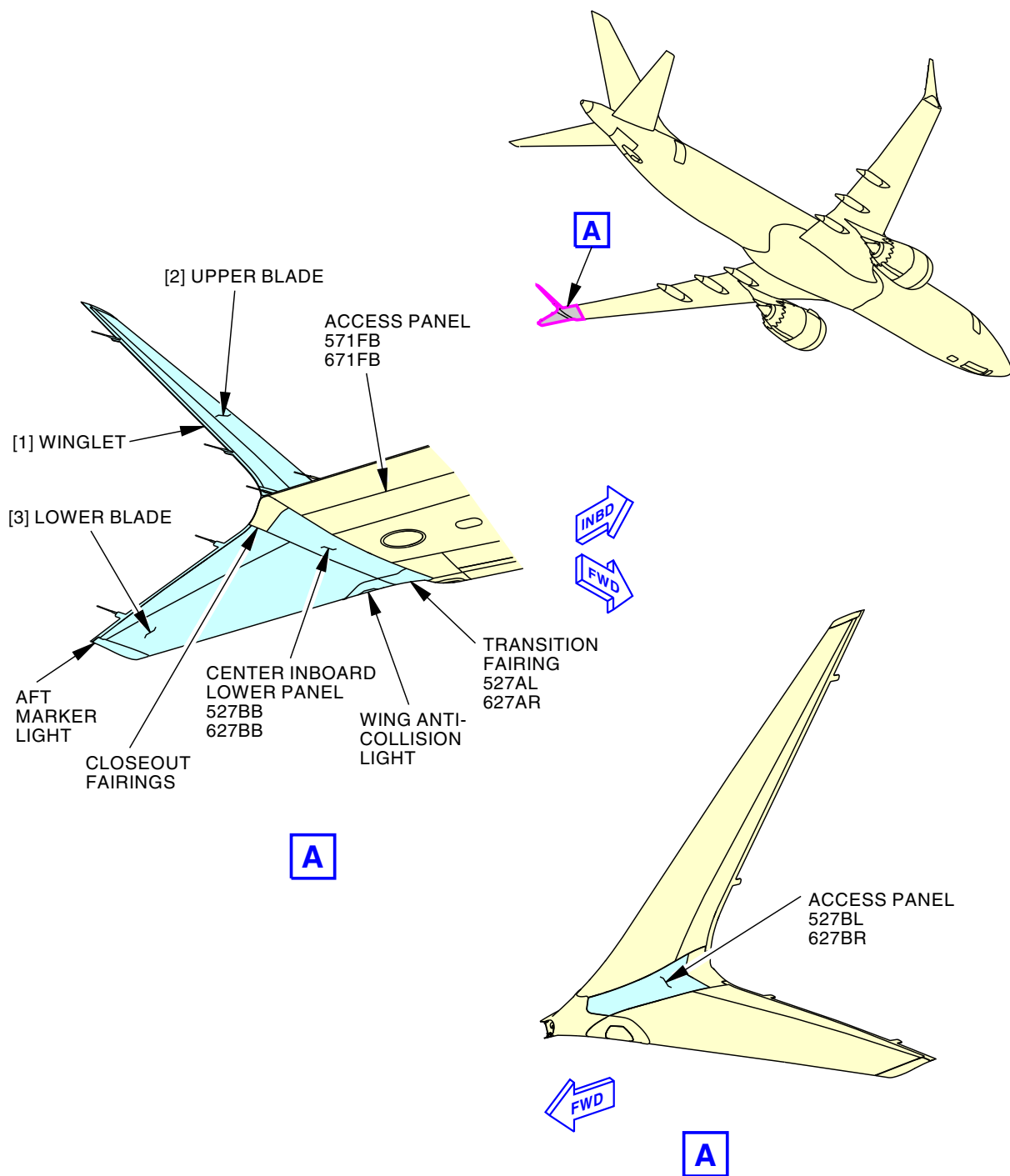
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2458495 S0000566296_V5

Winglet Lower Blade Installation
Figure 403/57-31-21-990-803 (Sheet 1 of 4)

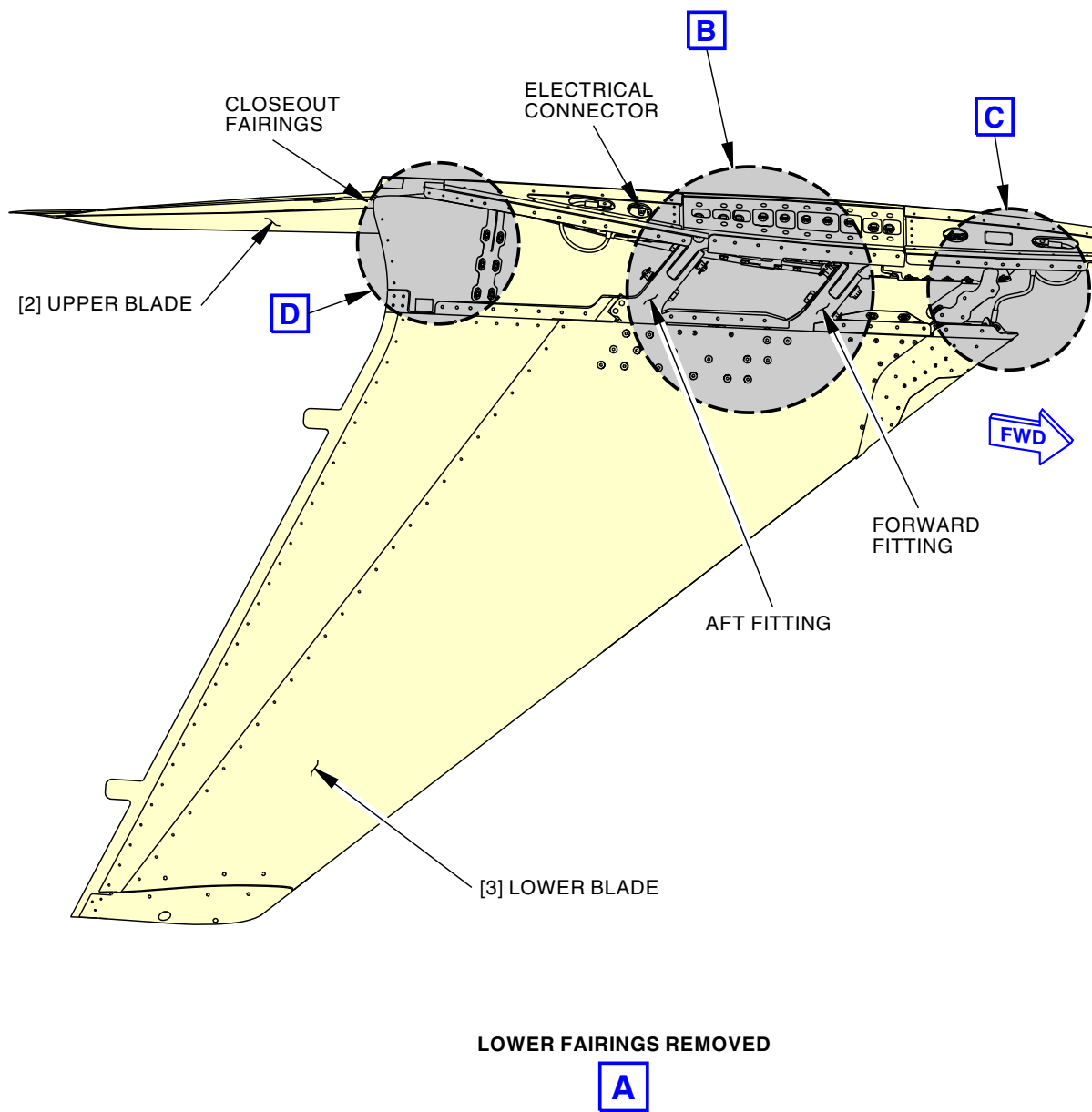
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2458500 S0000572555_V4

Winglet Lower Blade Installation
Figure 403/57-31-21-990-803 (Sheet 2 of 4)

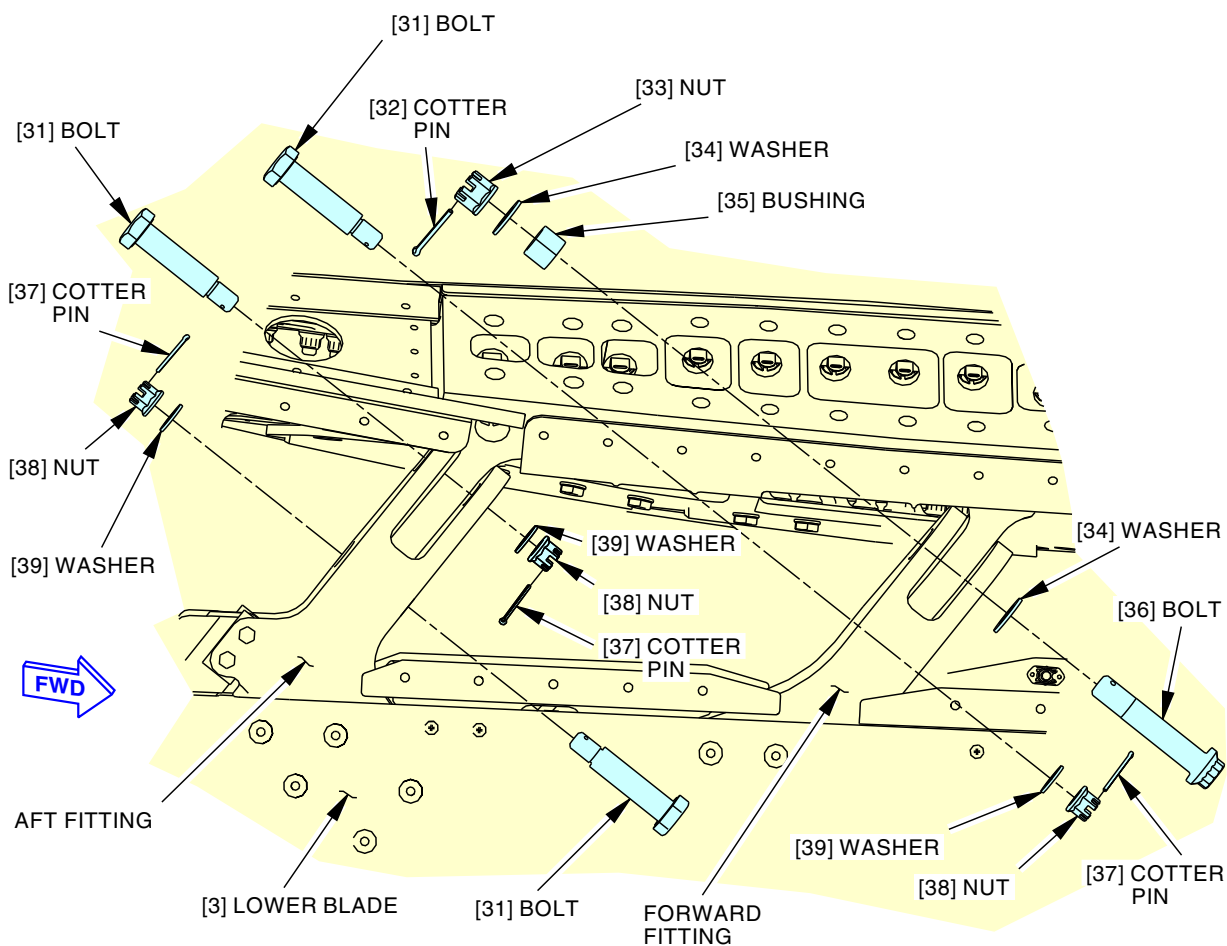
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WINGLET LOWER BLADE INSTALLATION

B

2458727 S0000572557_V2

Winglet Lower Blade Installation
Figure 403/57-31-21-990-803 (Sheet 3 of 4)

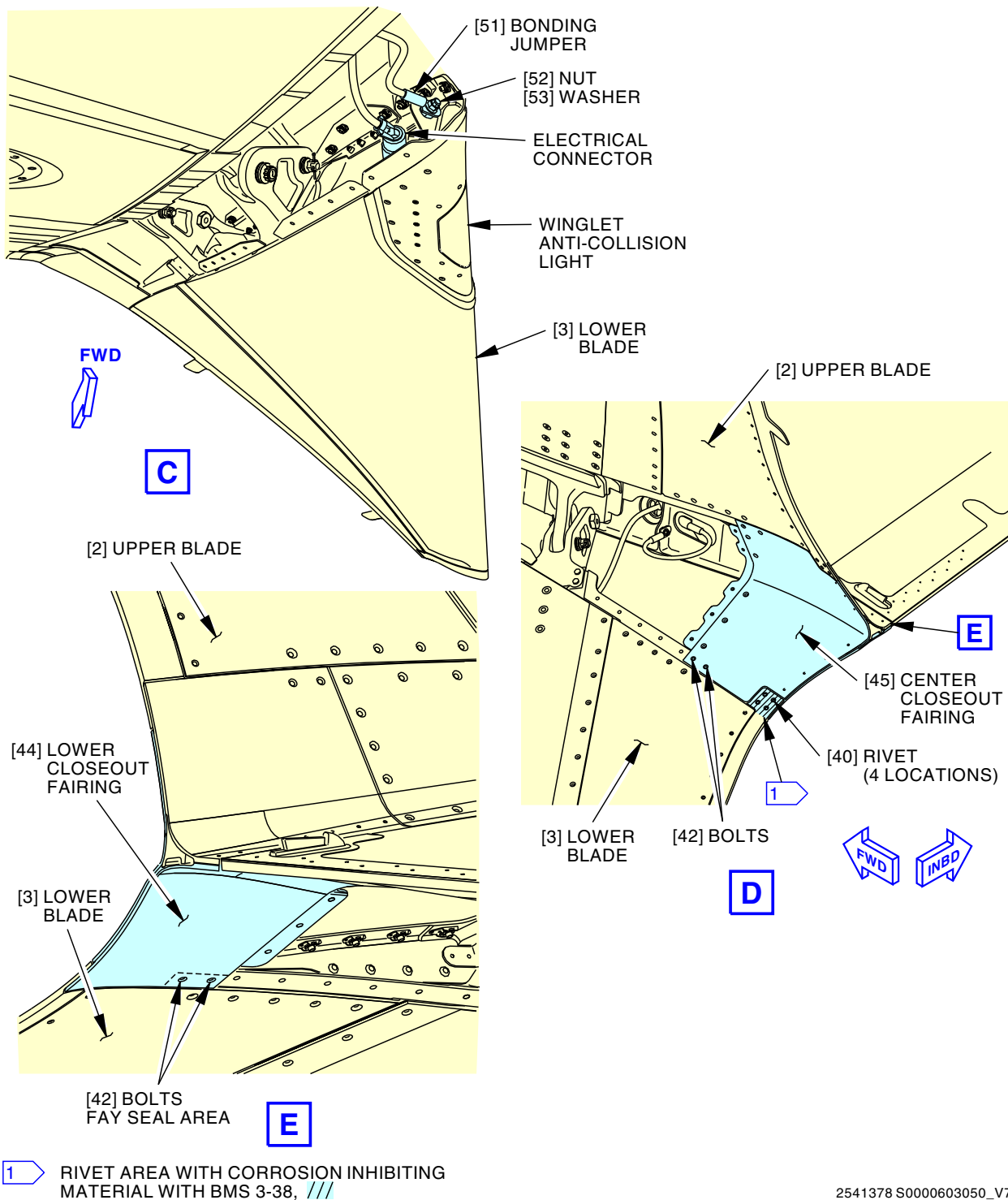
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2541378 S0000603050_V7

Winglet Lower Blade Installation
Figure 403/57-31-21-990-803 (Sheet 4 of 4)

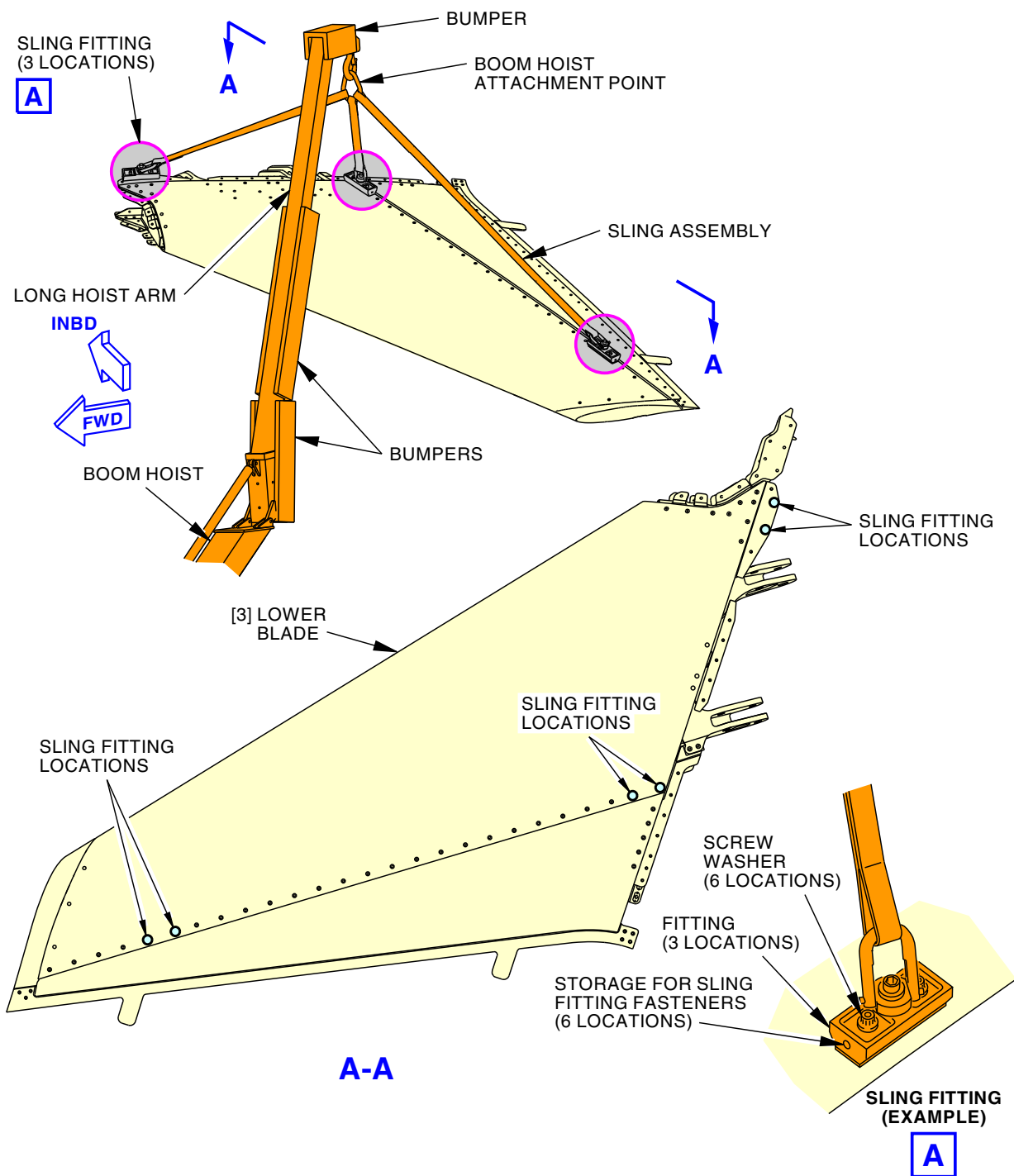
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2540457 S0000603051_V5

Winglet Lower Blade Sling Installation
Figure 404/57-31-21-990-811

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TASK 57-31-21-400-802

5. Winglet Lower Blade Installation

(Figure 403 and Figure 404)

A. General

- (1) The winglet assembly consists of upper blade and lower blade. This task gives instructions to install the lower blade to the winglet assembly.
- (2) A second person is required to do this task.

B. References

Reference	Title
20-40-11-910-801	Static Grounding (P/B 201)
27-51-00-040-801	Trailing Edge Flap System Deactivation (P/B 201)
27-51-00-440-801	Trailing Edge Flap System Reactivation (P/B 201)
27-81-00-040-801	Leading Edge Flaps and Slats - Deactivation (P/B 201)
27-81-00-440-801	Leading Edge Flaps and Slats - Activation (P/B 201)
33-43-10-420-801	Winglet (AFT) Marker and Winglet Anti-Collision Lights - Connect the Electrical Connectors (P/B 201)
33-44-13-400-801	Winglet Anti-Collision Light Installation (P/B 201)
51-21-71-370-802	Apply BMS 10-21 Type III Conductive Coating to Specified External Surfaces (P/B 701)
51-22-00-390-801	Non-Removable Faying (Mated) Surface Seal Application (P/B 201)
51-22-00-390-808	Fastener Seal Application (P/B 201)
57-31-21-080-801	Winglet Cover Plate Removal (P/B 201)
57-31-21-390-801	Winglet Aerodynamic Sealant Repair (P/B 801)
57-31-24-200-801	Winglet Erosion Protection Inspection (P/B 601)
57-31-25-010-801	Transition Fairing Removal (P/B 401)
57-31-25-410-801	Transition Fairing Installation (P/B 401)
SRM 51-40-02-0G-0	Fastener Installation and Removal
SWPM 20-20-00	ELECTRICAL BONDING PROCESSES
SWPM 20-20-00 Paragraph 21	MAXIMUM PERMITTED RESISTANCE OF ELECTRICAL BONDS

C. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt.", which stands for Optional.

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Reference	Description
COM-614	Bonding Meters - Non-Intrinsically Safe (For use in outside Class I, Divisions I & II non-hazardous locations. For hazardous locations, use COM-1550). Part #: 247000 Supplier: 00426 Part #: 620LK Supplier: 1CRL2 Part #: BLR-0003-XX Supplier: KC432 Part #: BT51 Supplier: 00426 Part #: M1 Supplier: 3AD17 Part #: M1B Supplier: 3AD17 Part #: T477W (C15292) Supplier: 06659 Opt Part #: 247001 Supplier: 00426
COM-659	Platform - Maintenance Lift, 3 ft Minimum Height, 12.5 ft Maximum Height Part #: 1135-8000 Supplier: 00994 Opt Part #: 8662-010 Supplier: 00994
COM-2480	Platform - Mobile Elevating Work Platform SJ III Series Part #: SJIII 4726 Supplier: 3AF08 Part #: SJIII 4732 Supplier: 3AF08 Opt Part #: SJIII 4620 Supplier: 3AF08 Opt Part #: SJIII 4626 Supplier: 3AF08 Opt Part #: SJIII 4632 Supplier: 3AF08
SPL-1556	Hoist - Boom, General, 400 Pound Maximum Capacity Part #: A20001-185 Supplier: 81205 Opt Part #: A20001-152 Supplier: 81205 Opt Part #: A20001-82 Supplier: 81205
SPL-2044	Sling - Winglet Part #: C57002-66 Supplier: 81205
SPL-6658	Long Hoist Arm Assembly Part #: A20001-65 Supplier: 81205
STD-20668	Bumper - Foam Cushion

D. Consumable Materials

Reference	Description	Specification
A50110	Sealant - Fuel Tank	BMS5-45 Class B-2
A50231	Sealant - Pressure And Environmental - Chromate Type	BMS5-95 Class B
C00528	Compound - Corrosion Preventive, Petroleum Hot Application (Soft Film)	MIL-C-11796 Class III
C00767	Coating - Anti-Static Coating	BMS10-21 Type III
D00633	Grease - Aircraft General Purpose	BMS3-33
G01912	Lockwire - MS20995NC32, Monel - 0.032 Inch (0.8128 mm) Diameter	NASM20995
G50136	Compound - Corrosion Inhibiting, Non-drying Paste	BMS3-38
G51674	Kit - Safety Cable, 321 CRES - 0.032 Inch (0.81 mm) Diameter, (Contains both Cable and Ferrule), 12 Inches Long	BACC13AT3K12

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E. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
3	Lower blade	57-31-21-01-745	SIA ALL
		57-31-21-01-750	SIA ALL
		57-31-21-05-310	SIA ALL
		57-31-21-05-315	SIA ALL
		57-31-22-05-010	SIA ALL
		57-31-22-05-015	SIA ALL
32	Cotter pin	57-31-00-01-130	SIA 001-014
		57-31-21-01-130	SIA ALL
		57-31-21-05-035	SIA ALL
37	Cotter pin	57-31-00-01-125	SIA 001-014
		57-31-21-01-125	SIA ALL
		57-31-21-05-030	SIA ALL
40	Rivet	57-31-21-01-205	SIA ALL
		57-31-21-05-065	SIA ALL
		57-31-21-10-741	SIA ALL

F. Location Zones

Zone	Area
118	Electrical and Electronics Compartment - Right
500	Left Wing
527	Left Winglet
534	Left Wing - Dry Bay
600	Right Wing
627	Right Winglet
634	Right Wing - Dry Bay

G. Access Panels

Number	Name/Location
527BB	ACCESS PANEL - CENTER INBOARD LOWER PANEL, WINGLET
527BL	ACCESS PANEL - CENTER OUTBOARD PANEL, WINGLET
534BB	Dry Bay Tank Access Door - Left Wing Station 748
571FB	Lower Outboard Fixed Trailing Edge Wedge Access Panel
627BB	ACCESS PANEL - CENTER INBOARD LOWER PANEL, WINGLET
627BR	ACCESS PANEL - CENTER OUTBOARD PANEL, WINGLET
634BB	Dry Bay Tank Access Door - Right Wing Station 748
671FB	Lower Outboard Fixed Trailing Edge, Wedge Access Panel

H. Prepare for the Installation

SUBTASK 57-31-21-860-014

- (1) Make sure that the airplane is properly grounded (TASK 20-40-11-910-801).

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SUBTASK 57-31-21-860-015

- (2) Get a ladder, work platform, COM-2480, or maintenance platform, COM-659.

NOTE: A scissors-type, mobile work platform or scaffold maintenance platform is recommended for two persons, one person to control the movement of the winglet that is suspended from the boom hoist/sling and other person to remove the winglet bolts and grounding straps.

I. Winglet Lower Blade Installation

SUBTASK 57-31-21-080-005

- (1) If the winglet cover plate was installed, then do these steps:

- (a) Open these circuit breakers and install safety tags:

CAPT Electrical System Panel, P18-3

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	12	C04052	EXTERIOR LIGHTING POSITION RIGHT
A	13	C04051	EXTERIOR LIGHTING POSITION LEFT



DO THE TRAILING EDGE FLAP DEACTIVATION PROCEDURE BEFORE YOU DO WORK ON THE FLAP SYSTEM. WITH THE FLAPS ACTIVATED, THE FLAPS CAN MOVE AND CAUSE INJURY TO PERSONS OR DAMAGE TO EQUIPMENT.

- (b) Do this task: Trailing Edge Flap System Deactivation, TASK 27-51-00-040-801.



DO THE DEACTIVATION PROCEDURE FOR THE LEADING EDGE FLAPS. THE ACCIDENTAL MOVEMENT OF THE FLAPS CAN CAUSE INJURY TO PERSONS AND DAMAGE TO EQUIPMENT.

- (c) Do this task: Leading Edge Flaps and Slats - Deactivation, TASK 27-81-00-040-801.

- (d) Do this task: Winglet Cover Plate Removal, TASK 57-31-21-080-801.

- (e) Remove the transition fairing (TASK 57-31-25-010-801).

- (f) Open these access panels:

<u>Number</u>	<u>Name/Location</u>
527BB	ACCESS PANEL - CENTER INBOARD LOWER PANEL, WINGLET
527BL	ACCESS PANEL - CENTER OUTBOARD PANEL, WINGLET
534BB	Dry Bay Tank Access Door - Left Wing Station 748
571FB	Lower Outboard Fixed Trailing Edge Wedge Access Panel
627BB	ACCESS PANEL - CENTER INBOARD LOWER PANEL, WINGLET
627BR	ACCESS PANEL - CENTER OUTBOARD PANEL, WINGLET
634BB	Dry Bay Tank Access Door - Right Wing Station 748
671FB	Lower Outboard Fixed Trailing Edge, Wedge Access Panel

- (g) Remove cap from the wirings for the inoperative aft marker light and winglet anti-collision light of the lower blade [3].

- 1) Carefully pull the wirings.

- (h) Set the ALTERNATE VMO/MMO switch (S1127), on the Electronic Equipment (EE) bay service panel, to the NORM position.

- 1) Cut the safety cable or lockwire in the switch guard.

- 2) Lift the switch guard and move the switch to the NORM position.

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- 3) Move the guard down and lockwire the switch guard using safety cable kit, G51674 (preferred), or MS20995NC32 lockwire, G01912 (alternate), and double twist method.
- 4) Make sure that the ADR label 270 bit 23 is set to "0".

SUBTASK 57-31-21-480-010

- (2) Make sure that the erosion protection tape is in serviceable condition (TASK 57-31-24-200-801).

SUBTASK 57-31-21-860-008

- (3) Make sure that these circuit breakers are open and have safety tags:

CAPT Electrical System Panel, P18-3

Row	Col	Number	Name
A	12	C04052	EXTERIOR LIGHTING POSITION RIGHT
A	13	C04051	EXTERIOR LIGHTING POSITION LEFT

SUBTASK 57-31-21-040-006



DO THE TRAILING EDGE FLAP DEACTIVATION PROCEDURE BEFORE YOU DO WORK ON THE FLAP SYSTEM. WITH THE FLAPS ACTIVATED, THE FLAPS CAN MOVE AND CAUSE INJURY TO PERSONS OR DAMAGE TO EQUIPMENT.

- (4) Make sure that the trailing edge flap system is deactivated (TASK 27-51-00-040-801).

SUBTASK 57-31-21-040-007



DO THE DEACTIVATION PROCEDURE FOR THE LEADING EDGE FLAPS. THE ACCIDENTAL MOVEMENT OF THE FLAPS CAN CAUSE INJURY TO PERSONS AND DAMAGE TO EQUIPMENT.

- (5) Make sure that the leading edge flap and slats are deactivated (TASK 27-81-00-040-801).

SUBTASK 57-31-21-480-011

- (6) Install the sling, SPL-2044, on the lower blade [3] (Figure 404).

NOTE: The sling equipment has three attachment fittings, six screws and washers, and a sling strap assembly.

- (a) Remove the six bolts from the lower blade [3] where the attachment fittings for the sling, SPL-2044, will be attached to the lower blade [3].
- (b) Store the bolts in a bag for the installation procedure.
- (c) Install six screws and washers to attach the three attachment fittings to the lower blade [3].

NOTE: The attachment screws and washers for the sling are stored in the threaded storage holes on the end surfaces of the attachment fittings.

- (d) Tighten the screws to 50 in-lb (6 N·m) - 80 in-lb (9 N·m).
- (e) Attach the sling strap assembly to the three fittings.

SUBTASK 57-31-21-480-012

- (7) Attach the sling, SPL-2044, to the boom hoist, SPL-1556, with a long hoist arm, SPL-6658 (Figure 404).

NOTE: The lower blade weighs approximately 48 lb (22 kg).

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CAUTION

MAKE SURE TO ATTACH BUMPERS TO THE BOOM HOIST AND THE LONG HOIST ARM. IF YOU DO NOT ATTACH THE BUMPERS, DAMAGE TO THE WINGLET LOWER BLADE AND UPPER BLADE CAN OCCUR.

- (a) Make sure that the bumpers, STD-20668, are still on the necessary areas of the boom hoist and long hoist arm attachment.

SUBTASK 57-31-21-480-014



CAUTION

BE CAREFUL WHEN YOU MANUALLY ADJUST THE LOWER BLADE TO PREPARE IT FROM WHEN YOU CONNECT IT TO THE WINGLET WITH A BOOM HOIST. IF YOU ARE NOT CAREFUL, DAMAGE TO THE RIVET AREA OF THE LOWER BLADE CAN OCCUR.



CAUTION

BE CAREFUL WHEN YOU USE A BOOM HOIST TO CONNECT THE LOWER BLADE TO THE WINGLET. IF YOU ARE NOT CAREFUL, DAMAGE TO THE RIVET AREA OF THE LOWER BLADE CAN OCCUR.

- (8) Operate the boom hoist, SPL-1556, to lift the sling, SPL-2044, until the three lines equally support the lower blade [3].

NOTE: Operate the boom hoist, SPL-1556, to a tension that will tighten the screws that hold the lower blade to the winglet without damage to the screw threads or to the attach fittings.

SUBTASK 57-31-21-420-007

- (9) Install the lower blade [3] (View B, Figure 403):

- (a) Apply a thin coat of grease, D00633, to the shank and threads of the three bolts [31] and bolt [36].
- (b) Install the bolts [31], washers [39], and nuts [38] to attach the lower blade [3] to the aft fitting.
- (c) Install the bolt [36], washers [34], bushing [35], and nut [33] on the lower part of the forward fitting.
- (d) Install the bolt [31], washer [39], and nut [38] on the upper part of the forward fitting.
- (e) Tighten the nuts [38] on the aft fitting to 220 in-lb (25 N·m) - 440 in-lb (50 N·m).
- (f) Tighten the upper nut [38] on the forward fitting to 220 in-lb (25 N·m) - 440 in-lb (50 N·m).
- (g) Tighten the lower nut [33] on the forward fitting to 320 in-lb (36 N·m) - 520 in-lb (59 N·m).
- (h) Install the three new cotter pins [37] on the nuts [38].
- (i) Install the new cotter pin [32] on the nut [33].

SUBTASK 57-31-21-080-001

- (10) Remove the sling, SPL-2044, from the lower blade [3] (Figure 404):

- (a) Remove the six screws and washers from the three attachment fittings.
- (b) Install the six screws and washers in the threaded storage holes in the ends of the attachment fittings.
- (c) Apply compound, C00528, to the four holes in the winglet [1] and immediately install the bolts.
- (d) Install the bolts.
- (e) Tighten the bolts to 30 in-lb (3 N·m) - 40 in-lb (5 N·m).

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SUBTASK 57-31-21-410-006

- (11) Do these steps to install the rivets [40] and bolts [42] that attach the center closeout fairing [45] to the winglet [1] (View D, Figure 403):
- (a) Apply coating, C00767, to the mating surface of the bolts [42] (TASK 51-21-71-370-802).
 - (b) Install the bolts [42].
 - 1) Tighten the bolts [42] to a torque tool setpoint of 30 in-lb (3 N·m).
 - (c) Measure the electrical bonding resistance between the head of bolt [42] and center closeout fairing [45] (TASK 51-21-71-370-802).
 - 1) Use a non-intrinsically safe bonding meter, COM-614.
 - 2) Make sure that the electrical bonding resistance is 300,000 ohms or less.
 - (d) Apply corrosion inhibiting material, G50136, to the faying surfaces of the rivets [40].
 - (e) Install the rivets [40] (SRM PROCEDURE 51-40-02-0G-0, SWPM 20-20-00).
 - (f) Measure the electrical bonding resistance between the center closeout fairing [45] and upper blade [2] (SWPM 20-20-00 Paragraph 21).
 - 1) Use a non-intrinsically safe bonding meter, COM-614.
 - 2) Make sure that the electrical bonding resistance is 0.0005 ohms (5.0 milliohm) or less.
 - (g) Measure the electrical bonding resistance between the center closeout fairing [45] and lower blade [3] (SWPM 20-20-00 Paragraph 21).
 - 1) Use a non-intrinsically safe bonding meter, COM-614.
 - 2) Make sure that the electrical bonding resistance is 0.0005 ohms (5.0 milliohm) or less.

SUBTASK 57-31-21-420-012

- (12) Do these steps to install the bolts [42] that attach the lower closeout fairing [44] to the winglet [1] (View E, Figure 403):
- (a) Apply sealant, A50110, to the faying surface of the bolts [42] (TASK 51-22-00-390-801).
 - (b) Install the bolts [42] with sealant, A50110 (TASK 51-22-00-390-808).
 - 1) Tighten the bolts [42] to a torque tool setpoint of 30 in-lb (3 N·m).

SUBTASK 57-31-21-420-008

- (13) Connect the forward bonding jumper [51] as follows (View C, Figure 403):
- (a) Install the bonding jumper [51] on the electrical stud on the winglet [1].
 - (b) Install the nut [52] and washer [53] to attach the bonding jumper [51].
 - (c) Measure the electrical bonding resistance between bonding jumper [51] and airplane structure (SWPM 20-20-00).
 - 1) Use non-intrinsically safe bonding meter, COM-614.
 - 2) Make sure that the resistance 0.0001 ohm (1.0 milliohm) or less.
 - (d) Apply sealant, A50110, or sealant, A50231, on the nut [52] and washer [53].

SUBTASK 57-31-21-420-009

- (14) Do this task: Winglet (AFT) Marker and Winglet Anti-Collision Lights - Connect the Electrical Connectors, TASK 33-43-10-420-801.

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SUBTASK 57-31-21-410-008

- (15) Install the access panels between the wing and the winglet:

<u>Number</u>	<u>Name/Location</u>
527BB	ACCESS PANEL - CENTER INBOARD LOWER PANEL, WINGLET
627BB	ACCESS PANEL - CENTER INBOARD LOWER PANEL, WINGLET

- (a) Tighten the fasteners for the lower fairing to a torque tool setpoint of 30 in-lb (3 N·m).

SUBTASK 57-31-21-410-009

- (16) Install the access panels between the wing and the winglet:

<u>Number</u>	<u>Name/Location</u>
527BL	ACCESS PANEL - CENTER OUTBOARD PANEL, WINGLET
627BR	ACCESS PANEL - CENTER OUTBOARD PANEL, WINGLET

- (a) Tighten the fasteners for the outboard fairing to a torque tool setpoint of 30 in-lb (3 N·m).

SUBTASK 57-31-21-410-010

- (17) Install the access panels between the wing and the winglet:

<u>Number</u>	<u>Name/Location</u>
571FB	Lower Outboard Fixed Trailing Edge Wedge Access Panel
671FB	Lower Outboard Fixed Trailing Edge, Wedge Access Panel

- (a) Tighten the fasteners for the access panel to a torque tool setpoint of 70 in-lb (8 N·m).

SUBTASK 57-31-21-410-002

- (18) Do this task: Transition Fairing Installation, TASK 57-31-25-410-801.

SUBTASK 57-31-21-410-005

- (19) If it is necessary, install the anti-collision light on the winglet [1]:

NOTE: The installation of the anti-collision light is only necessary if there is a new lower blade replacement.

- (a) Do this task: Winglet Anti-Collision Light Installation, TASK 33-44-13-400-801.

J. Put the Airplane Back to Its Usual Condition

SUBTASK 57-31-21-390-008

- (1) Do this task: Winglet Aerodynamic Sealant Repair, TASK 57-31-21-390-801.

SUBTASK 57-31-21-080-002

- (2) Remove the ladders, work platform, COM-2480, or maintenance platform, COM-659.

SUBTASK 57-31-21-860-007

- (3) Remove the safety tags and close these circuit breakers:

CAPT Electrical System Panel, P18-3

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
A	12	C04052	EXTERIOR LIGHTING POSITION RIGHT
A	13	C04051	EXTERIOR LIGHTING POSITION LEFT

SUBTASK 57-31-21-440-003

- (4) Do this task: Trailing Edge Flap System Reactivation, TASK 27-51-00-440-801.

SUBTASK 57-31-21-440-004

- (5) Do this task: Leading Edge Flaps and Slats - Activation, TASK 27-81-00-440-801.

————— END OF TASK —————

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TASK 57-31-21-000-803

6. Winglet Removal (Alternate)

(Figure 405 and Figure 406)

A. General

- (1) This task gives instructions for the removal of the winglet lower blade and winglet upper blade from the left or right wing.

B. References

Reference	Title
20-40-11-910-801	Static Grounding (P/B 201)
27-51-00-040-801	Trailing Edge Flap System Deactivation (P/B 201)
27-81-00-040-801	Leading Edge Flaps and Slats - Deactivation (P/B 201)
33-43-10-020-801	Winglet (AFT) Marker and Winglet Anti-Collision Lights - Disconnect the Electrical Connectors (P/B 201)
57-31-21-990-810	Figure: Winglet Seal (P/B 801)
57-31-23-000-801	Dry Bay Access Doors Removal (P/B 401)
57-31-25-010-801	Transition Fairing Removal (P/B 401)
SRM 51-40-02-0G-0	Fastener Installation and Removal

C. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
COM-659	Platform - Maintenance Lift, 3 ft Minimum Height, 12.5 ft Maximum Height Part #: 1135-8000 Supplier: 00994 Opt Part #: 8662-010 Supplier: 00994
COM-2480	Platform - Mobile Elevating Work Platform SJ III Series Part #: SJIII 4726 Supplier: 3AF08 Part #: SJIII 4732 Supplier: 3AF08 Opt Part #: SJIII 4620 Supplier: 3AF08 Opt Part #: SJIII 4626 Supplier: 3AF08 Opt Part #: SJIII 4632 Supplier: 3AF08
SPL-2044	Sling - Winglet Part #: C57002-66 Supplier: 81205
SPL-14633	Winglet Holding Fixture Part #: C57006-1 Supplier: 81205
STD-1064	Scraper - Phenolic, Hard Resin
STD-1081	Flashlight - Explosion Proof
STD-1194	Crane - Lift, 250 Lb (113 kg) Capacity, Lift Range 20 to 60 Inches (508-1524 Millimeters)
STD-12395	Load Cell Equipment

D. Consumable Materials

Reference	Description	Specification
G50305	Sheeting - Plastic, Polyethylene	

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E. Location Zones

Zone	Area
500	Left Wing
527	Left Winglet
534	Left Wing - Dry Bay
600	Right Wing
627	Right Winglet
634	Right Wing - Dry Bay

F. Access Panels

Number	Name/Location
527BB	ACCESS PANEL - CENTER INBOARD LOWER PANEL, WINGLET
534BB	Dry Bay Tank Access Door - Left Wing Station 748
571FB	Lower Outboard Fixed Trailing Edge Wedge Access Panel
627BB	ACCESS PANEL - CENTER INBOARD LOWER PANEL, WINGLET
634BB	Dry Bay Tank Access Door - Right Wing Station 748
671FB	Lower Outboard Fixed Trailing Edge, Wedge Access Panel

G. Prepare for the Removal

SUBTASK 57-31-21-860-011

- (1) Make sure that the airplane is correctly grounded (TASK 20-40-11-910-801).

SUBTASK 57-31-21-860-012

- (2) Open these circuit breakers and install safety tags:

CAPT Electrical System Panel, P18-3

Row	Col	Number	Name
A	12	C04052	EXTERIOR LIGHTING POSITION RIGHT
A	13	C04051	EXTERIOR LIGHTING POSITION LEFT

SUBTASK 57-31-21-040-012



WARNING

DO THE DEACTIVATION PROCEDURE FOR THE TRAILING EDGE FLAP BEFORE YOU DO WORK ON THE FLAP SYSTEM. THE FLAPS MOVE QUICKLY. THEY CAN CAUSE INJURIES TO PERSONNEL, AND DAMAGE TO EQUIPMENT.

- (3) Do this task: Trailing Edge Flap System Deactivation, TASK 27-51-00-040-801.

SUBTASK 57-31-21-040-013



WARNING

DO THE DEACTIVATION PROCEDURE FOR THE LEADING EDGE FLAPS. THE ACCIDENTAL MOVEMENT OF THE FLAPS CAN CAUSE INJURY TO PERSONS AND DAMAGE TO EQUIPMENT.

- (4) Do this task: Leading Edge Flaps and Slats - Deactivation, TASK 27-81-00-040-801.

SUBTASK 57-31-21-480-032

- (5) Get a ladder, work platform, COM-2480, or maintenance platform, COM-659.

NOTE: A scissors-type, mobile work platform or scaffold maintenance platform is recommended for two persons, one person to control the movement of the winglet which is suspended from the crane/sling and the other person to remove the winglet bolts and the grounding straps.

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SUBTASK 57-31-21-480-028

- (6) Make sure that an overhead 250 lb (113 kg) capacity crane, STD-1194, is available for the sling equipment.

NOTE: The complete sling assembly weighs 20 lb (9 kg). The winglet upper blade weighs 137 lb (62 kg).

SUBTASK 57-31-21-480-029

- (7) Make sure that a holding fixture, SPL-14633, is available for use or prepare a location to store the upper blade [2].

NOTE: If the holding fixture, SPL-14633, is not available, use a support structure covered with plastic sheeting, G50305, for the upper blade.

SUBTASK 57-31-21-860-013

- (8) Do these steps to prepare metal support equipment such as work platforms, work/maintenance stands, ladders:

NOTE: These steps apply to all metal support equipment within a 50 ft (15 m) radius of an open fuel tank.

- (a) All support equipment must be in place before you begin the procedure.
- (b) Bond the support equipment at an approved airplane bonding location.
- (c) Ground the support equipment to the same earth ground as the airplane.

SUBTASK 57-31-21-020-023

- (9) Remove these dry bay access doors located under the wing, adjacent to the outboard rib 27 (TASK 57-31-23-000-801).

- (a) Open these access doors.

<u>Number</u>	<u>Name/Location</u>
534BB	Dry Bay Tank Access Door - Left Wing Station 748
634BB	Dry Bay Tank Access Door - Right Wing Station 748

SUBTASK 57-31-21-010-010

- (10) Do this task: Transition Fairing Removal, TASK 57-31-25-010-801.

SUBTASK 57-31-21-010-011

 CAUTION	BE CAREFUL IF YOU USE A HARD RESIN PHENOLIC SCRAPER TO REMOVE SEALANTS AND COMPOUNDS TO DISCONNECT THE FAIRINGS BETWEEN THE WING AND THE WINGLET. IF YOU ARE NOT CAREFUL, DAMAGE TO THE EROSION PROTECTION TAPE CAN OCCUR.

- (11) Remove the access panels between the wing and the winglet [1]:

<u>Number</u>	<u>Name/Location</u>
527BB	ACCESS PANEL - CENTER INBOARD LOWER PANEL, WINGLET
571FB	Lower Outboard Fixed Trailing Edge Wedge Access Panel
627BB	ACCESS PANEL - CENTER INBOARD LOWER PANEL, WINGLET
671FB	Lower Outboard Fixed Trailing Edge, Wedge Access Panel



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H. Alternate Winglet Removal

SUBTASK 57-31-21-100-006



BE CAREFUL WHEN YOU USE A HARD RESIN PHENOLIC SCRAPER TO REMOVE SEALANTS AND COMPOUNDS TO DISCONNECT THE UPPER OR LOWER BLADE FROM THE WINGLET. IF YOU ARE NOT CAREFUL, DAMAGE TO THE EROSION PROTECTION TAPE CAN OCCUR.

- (1) Do this step to remove the sealant between the lower blade [3] and lower closeout fairing [44]:
 - (a) Remove the sealant with a hard resin phenolic scraper, STD-1064, around the fay seal area of the fasteners on the lower closeout fairing [44] (View E, Figure 405).

SUBTASK 57-31-21-020-013

- (2) Do this task: Winglet Lower Blade Removal, TASK 57-31-21-000-802.

SUBTASK 57-31-21-020-014

- (3) Do these steps to remove the lower closeout fairing [44] from the winglet [1] (View E, Figure 405):
 - (a) Make sure that the bolts [42] have been removed.
 - (b) Remove the bolts [50], washers [47], and nuts [48].

SUBTASK 57-31-21-020-015

- (4) Do these steps to remove the center closeout fairing [45] from the winglet [1] (View D, Figure 405):
 - (a) Remove the remaining rivets [40] (SRM PROCEDURE 51-40-02-0G-0).
 - (b) Make sure that the bolts [42] have been removed.
 - (c) Remove the bolts [41].

SUBTASK 57-31-21-020-017

- (5) Remove the drain plug [49] from the necessary aft closeout fairings (View E, Figure 405).

SUBTASK 57-31-21-020-016

- (6) Do this step to remove the rivets [40] that attach the upper closeout fairing [46] to the lower closeout fairing [44] (View E, Figure 405):
 - (a) Remove the rivets [40] (SRM PROCEDURE 51-40-02-0G-0).

SUBTASK 57-31-21-100-002



BE CAREFUL WHEN YOU USE A HARD RESIN PHENOLIC SCRAPER TO REMOVE SEALANTS AND COMPOUNDS TO DISCONNECT THE UPPER OR LOWER BLADE FROM THE WINGLET. IF YOU ARE NOT CAREFUL, DAMAGE TO THE EROSION PROTECTION TAPE CAN OCCUR.

- (7) Do these steps to remove the corrosion inhibiting material and sealant between the upper blade [2] and aft closeout fairings:
 - (a) Remove the corrosion inhibiting material with a hard resin phenolic scraper, STD-1064, between the rivet area of the upper blade [2] and center closeout fairing [45] (View D, Figure 405).
 - (b) Remove the sealant with a hard resin phenolic scraper, STD-1064, around the rivets fay seal area of the upper closeout fairing [46] (View E, Figure 405).

SUBTASK 57-31-21-020-021

- (8) Make sure that the electrical connectors for the lights have been disconnected (TASK 33-43-10-020-801).

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SUBTASK 57-31-21-020-022

- (9) Disconnect the forward bonding jumper [4] as follows (View C, Figure 405):
- Remove the nut [5] and washer [6] from the outboard rib of the wing.
 - Remove the bonding jumper [4] from the lug on the wing rib.
 - Store the nut [5] and washer [6] in a bag for the installation procedure.

SUBTASK 57-31-21-100-007



BE CAREFUL WHEN YOU USE A HARD RESIN PHENOLIC SCRAPER TO REMOVE SEALANTS AND COMPOUNDS TO DISCONNECT THE WINGLET FROM THE WING. IF YOU ARE NOT CAREFUL, DAMAGE TO THE EROSION PROTECTION TAPE CAN OCCUR.

- (10) Do these steps to remove the corrosion inhibiting material and sealant between the upper blade [2] and wing rib:
- Remove the corrosion inhibiting material with a hard resin phenolic scraper, STD-1064, around the faying surfaces of rib 27 on the wing and winglet [1] root rib (View A-A, Figure 405).
 - Remove sealant around the external gap on the upper surface of the winglet [1] (View F, Figure 405).

SUBTASK 57-31-21-100-008



BE CAREFUL WHEN YOU USE A HARD RESIN PHENOLIC SCRAPER TO REMOVE SEALANTS AND COMPOUNDS TO DISCONNECT THE WINGLET FROM THE WING. IF YOU ARE NOT CAREFUL, DAMAGE TO THE EROSION PROTECTION TAPE CAN OCCUR.

- (11) Remove the aerodynamic sealant with a hard resin phenolic scraper, STD-1064, from the necessary areas to disengage the upper blade [2] from the winglet [1] (Figure 57-31-21-990-810).

SUBTASK 57-31-21-480-018

- (12) Install the sling, SPL-2044, on the upper blade [2].

NOTE: The sling equipment has three attachment fittings, six screws and washers, a sling strap assembly, a load cell, STD-12395.

- Remove the bolts from the upper blade [2] where you install the attachment fittings for the sling, SPL-2044, to the upper blade [2].
- Store the bolts in a bag for the installation procedure.
- Install the bolts and washers from the sling kit to attach the attachment fittings to the upper blade [2].
 - Tighten the bolts to 50 in-lb (6 N·m) - 80 in-lb (9 N·m).

NOTE: The attachment bolts and washers for the sling are stored in the threaded storage holes on the end surfaces of the attachment fittings.

- Attach the sling strap assembly to the fittings.

SUBTASK 57-31-21-480-019

- (13) Attach the sling, SPL-2044, to the overhead crane.

NOTE: The upper blade weighs approximately 137 lb (62 kg).

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SUBTASK 57-31-21-480-020



WARNING

DO NOT LIFT THE UPPER BLADE WITH A FORCE THAT IS MORE THAN 152-LBS. IF YOU USE A FORCE THAT IS MORE THAN 152-LBS, IT CAN CAUSE DAMAGE TO THE AIRPLANE AND INJURY TO PERSONNEL.

- (14) Use the load cell, STD-12395, to make sure that the force used when lifting the upper blade [2] is not more than 152 lb (69 kg).

NOTE: The value for the weight of the upper blade is approximately 137 lb (62 kg).

SUBTASK 57-31-21-480-021

- (15) Operate the overhead crane to lift the sling equipment until the lines equally support the upper blade [2].
- (a) Balance the overhead crane tension, so you can loosen the bolts that hold the upper blade [2] to the winglet [1], without damage to the bolt threads or to the upper blade [2].

SUBTASK 57-31-21-210-004

- (16) Use an explosion proof flashlight, STD-1081, when you look inside the dry bay tank.

SUBTASK 57-31-21-020-018

- (17) Remove the bolts [10] and washers [11] from the center of the upper blade [2] (Table 403, View A-A, Figure 405).
- (a) Put the bolts and washers on a foam or cardboard piece.
- 1) Make sure to set the fasteners on the foam or cardboard piece to align with the removal order sequence.
- (b) Make sure to label the foam or cardboard piece since the diameters and lengths are different for each attachment location.

Table 403/57-31-21-993-806 Winglet Attachment Bolt Removal

ITEM	BOLT	REMOVAL ORDER	LOCATION
[10]	BACB30US7K13M 0.4375 in. (11.1125 mm) dia.	K	Middle Upper and Lower
[7]	BACB30US8K21M 0.5000 in. (12.7000 mm) dia.	J	Upper Aft (Front)
[9]	BACB30US8K21M 0.5000 in. (12.7000 mm) dia.	I	Lower Forward (Front)
[7]	BACB30US8K21M 0.5000 in. (12.7000 mm) dia.	H	Lower Aft (Front)
[9]	BACB30US8K21M 0.5000 in. (12.7000 mm) dia.	G	Upper Forward (Back)
[7]	BACB30US8K21M 0.5000 in. (12.7000 mm) dia.	F	Upper Aft (Middle)
[9]	BACB30US8K21M 0.5000 in. (12.7000 mm) dia.	E	Lower Forward (Back)
[7]	BACB30US8K21M 0.5000 in. (12.7000 mm) dia.	D	Lower Aft (Middle)

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Table 403/57-31-21-993-806 Winglet Attachment Bolt Removal (Continued)

ITEM	BOLT	REMOVAL ORDER	LOCATION
[9]	BACB30US8K21M 0.5000 in. (12.7000 mm) dia.	C	Upper Forward (Front)
[12]	BACB30US8K19M 0.5000 in. (12.7000 mm) dia.	B	Lower Aft (Back)
[12]	BACB30US8K19M 0.5000 in. (12.7000 mm) dia.	A	Upper Aft (Back)

SUBTASK 57-31-21-020-020

- (18) Disconnect the aft bonding jumper [18] (View B, Figure 405).
- (a) Remove the nut [19] and washer [20] from the outboard rib of the wing.
 - (b) Remove the bonding jumper [18] from the lug on the wing rib.
 - (c) Store the nut [19] and washer [20] in a bag for the installation procedure.

SUBTASK 57-31-21-020-019

- (19) Remove the forward and aft bolts [7], bolts [9], bolts [12], and washers [8] (Table 403, View A-A, Figure 405).

NOTE: Remove the bolts in the necessary sequence.

- (a) You must control movement of the sling and the upper blade [2] as you remove the attachment fasteners.

NOTE: A second person is recommended to control the movement of the upper blade which is suspended from the crane/sling. A gust of wind could cause the upper blade to move as you remove the attachment fasteners.

- (b) Remove the radius filler [13] when you remove the bolts [7] and washers [8].
- (c) Put the bolts and washers on a foam or cardboard piece.
- 1) Make sure to set the fasteners on the foam or cardboard piece to align with the removal order sequence.
- (d) Make sure to label the foam or cardboard piece since the diameters and lengths are different for each attachment location.

SUBTASK 57-31-21-480-022



CAUTION

BE CAREFUL WHEN YOU MANUALLY LOOSEN THE UPPER BLADE TO PREPARE IT FROM WHEN YOU DISCONNECT IT FROM THE WINGLET WITH A OVERHEAD CRANE. IF YOU ARE NOT CAREFUL, DAMAGE TO THE RIVET AREA OF THE UPPER BLADE CAN OCCUR.



CAUTION

BE CAREFUL WHEN YOU USE THE OVERHEAD CRANE TO DISCONNECT THE UPPER BLADE FROM THE WINGLET. IF YOU ARE NOT CAREFUL, DAMAGE TO THE RIVET AREA OF THE UPPER BLADE CAN OCCUR.

- (20) Use the overhead crane and the sling, SPL-2044, to move the upper blade [2] to a holding fixture, SPL-14633, or appropriate storage location.

————— **END OF TASK** —————

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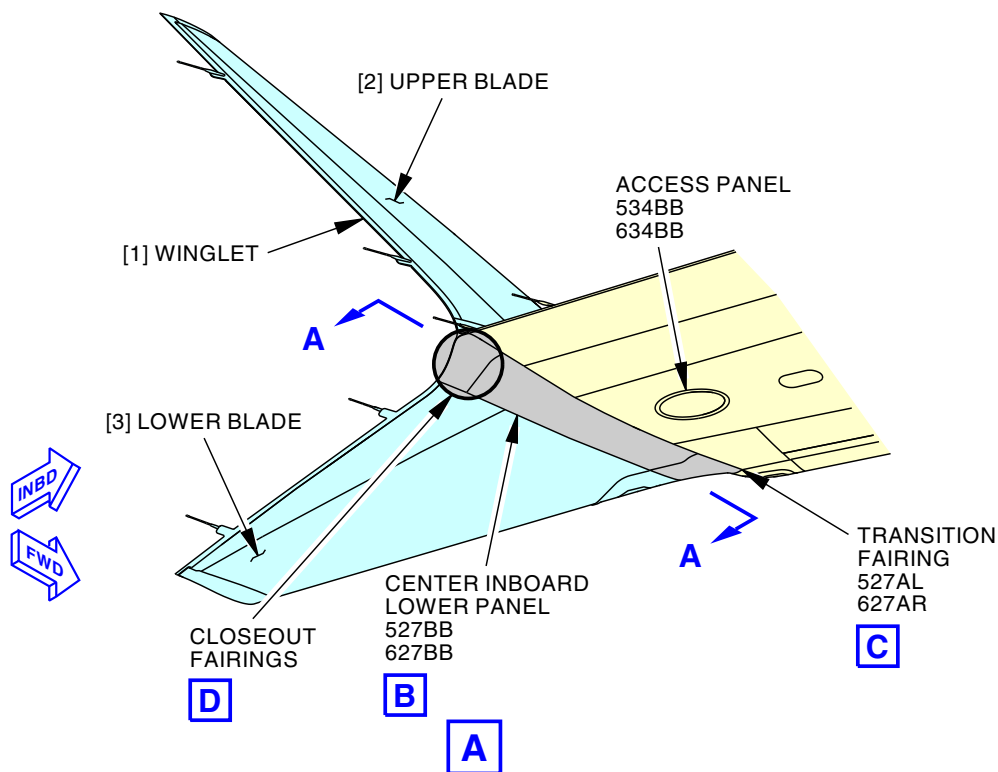
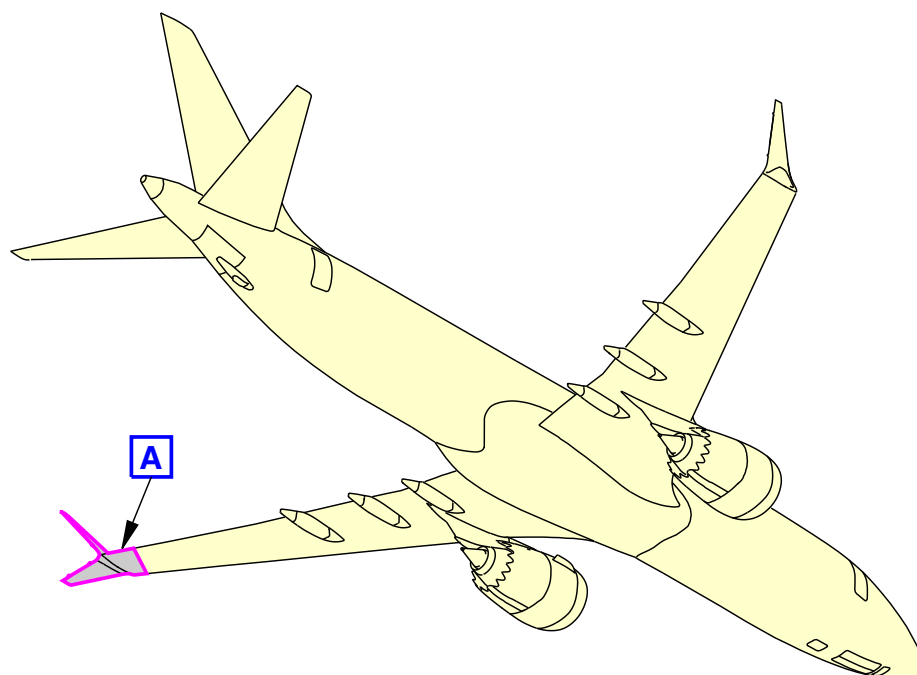
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2921632 S0000703905_V3

Winglet Installation (Alternate)
Figure 405/57-31-21-990-808 (Sheet 1 of 6)

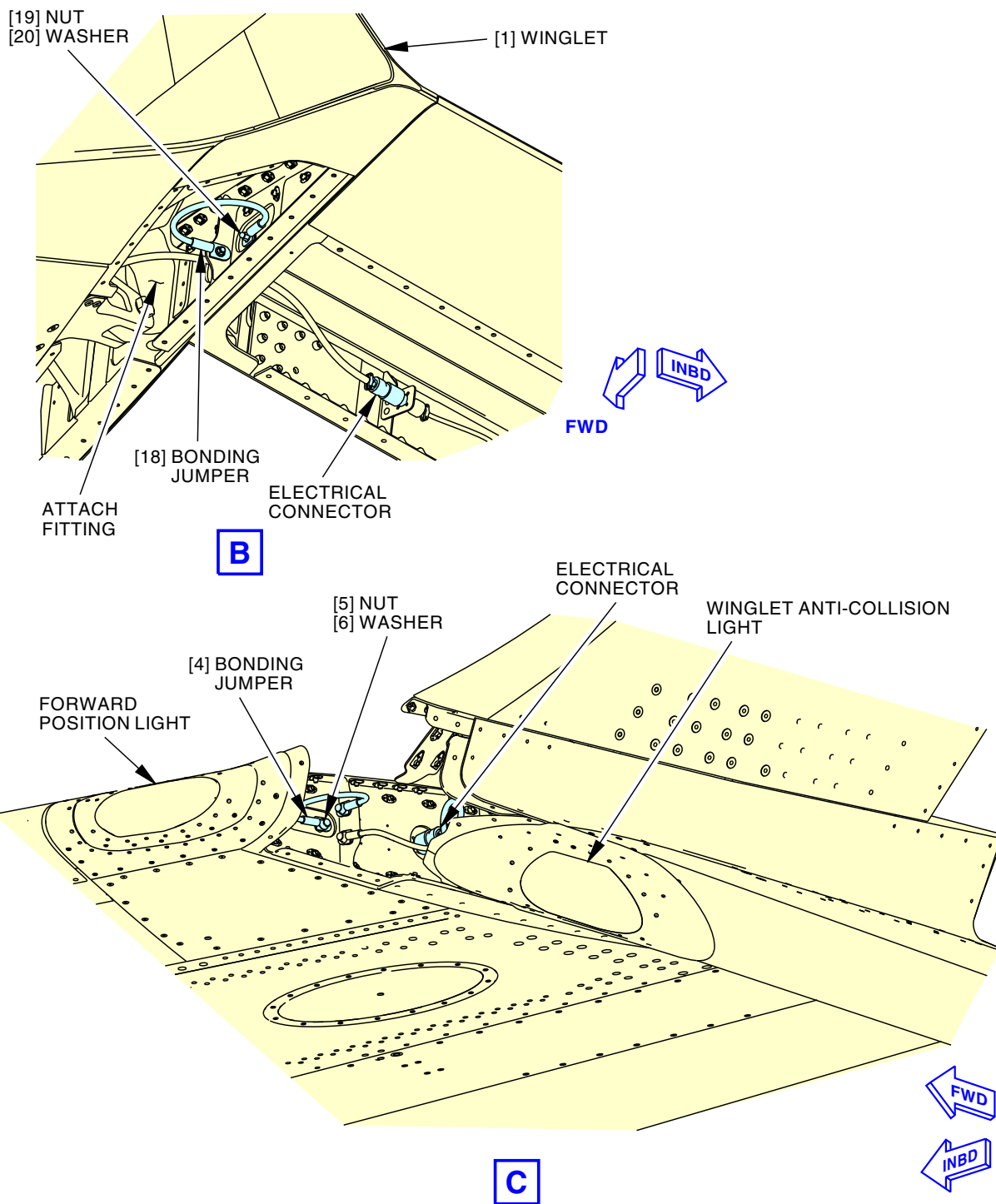
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2452776 S0000569913_V3

Winglet Installation (Alternate)
Figure 405/57-31-21-990-808 (Sheet 2 of 6)

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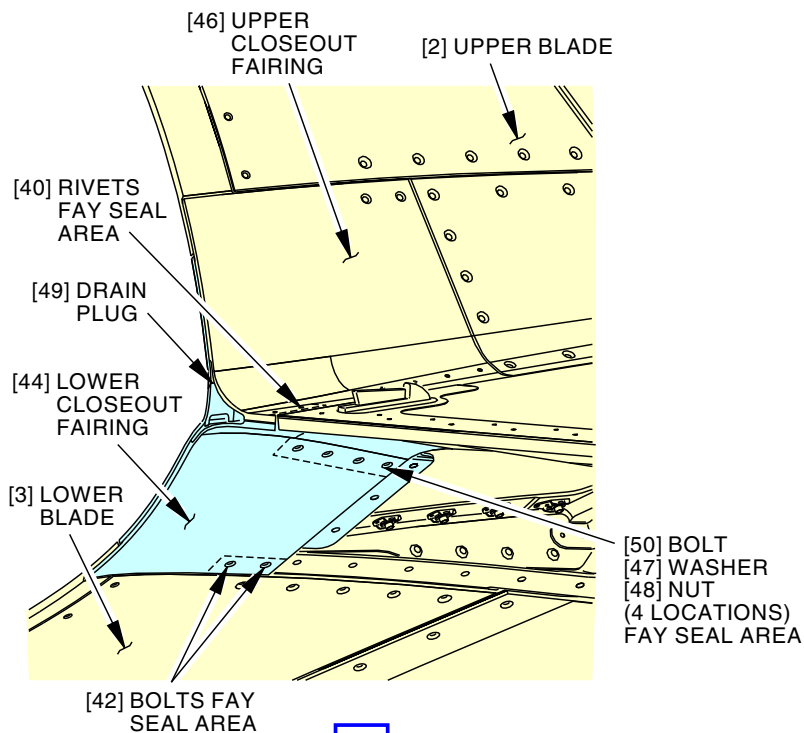
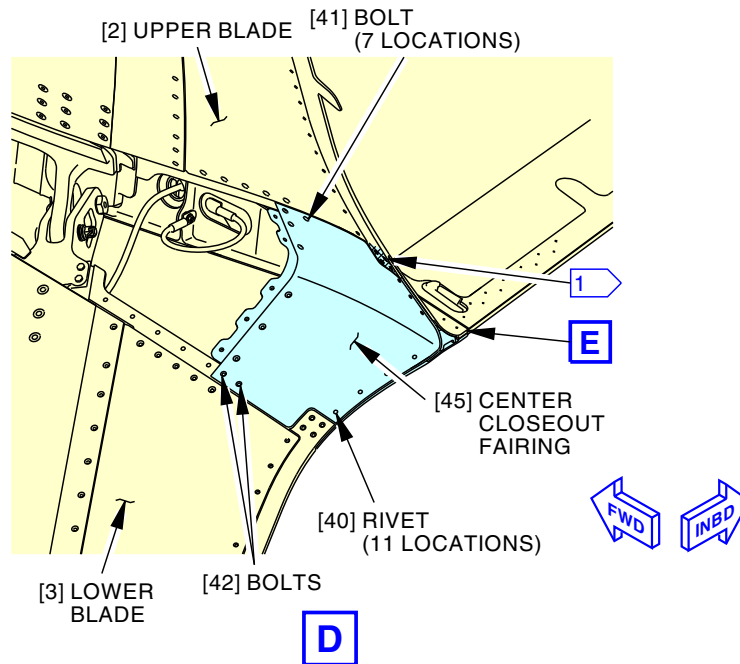
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1 RIVET AREA WITH CORROSION INHIBITING MATERIAL WITH BMS 3-38, 

2921633 S0000703906_V4

Winglet Installation (Alternate)
Figure 405/57-31-21-990-808 (Sheet 3 of 6)

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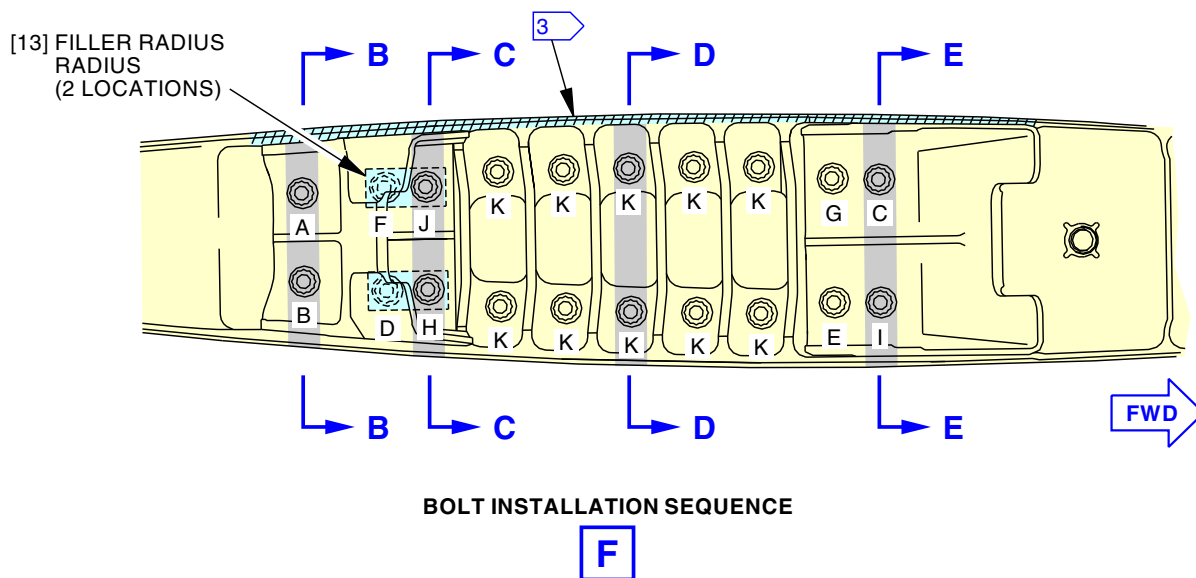
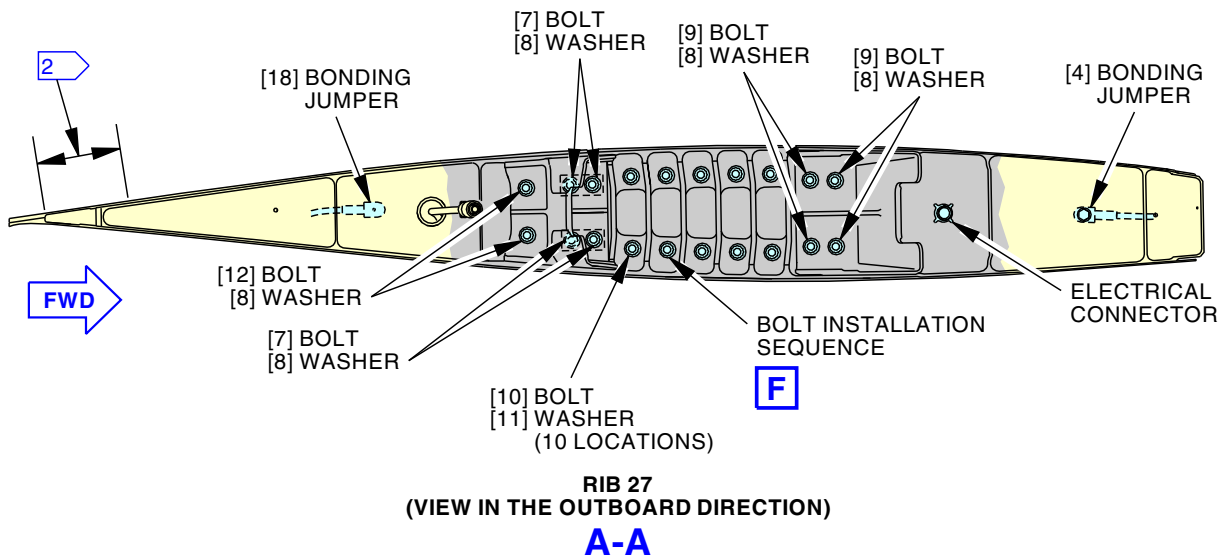
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NOTE:

1. A THRU K ARE THE ORDER OF THE INSTALLATION FOR THE BOLTS.
2. K THRU A IS THE REVERSE ORDER FOR REMOVAL OF THE BOLTS.

2 6.000 ±0.500 INCH (152.4 ±12.7 mm), ONLY UPPER SURFACE, MAXIMUM ALLOWED MISFAIR 0.1200 INCH (3.048 mm)

3 AERODYNAMIC SEAL WITH BMS 5-95 OR BMS 5-142 TYPE II, ///

2921634 S0000703907_V2

Winglet Installation (Alternate)
Figure 405/57-31-21-990-808 (Sheet 4 of 6)

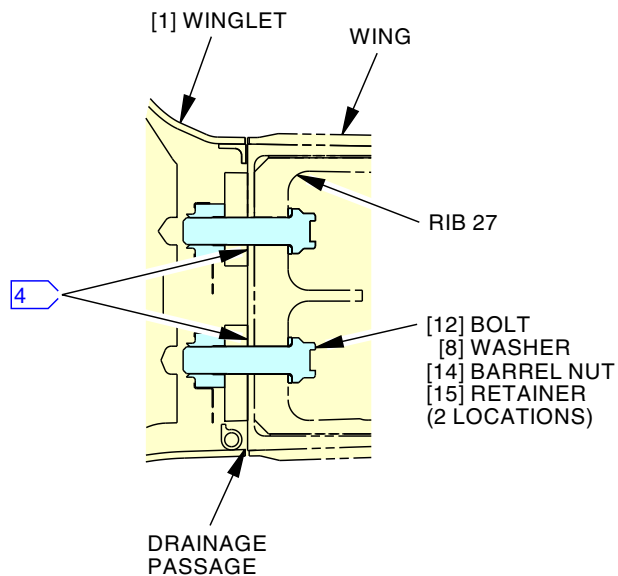
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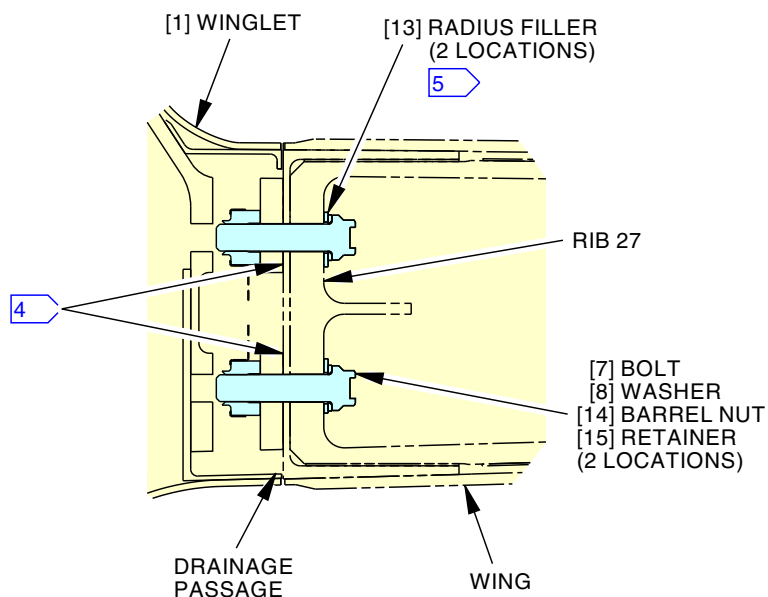
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B-B



C-C

- 4 APPLY CORROSION INHIBITING COMPOUND
- 5 ONLY BOLT [7] INSTALLATION

2962024 S0000739953_V1

Winglet Installation (Alternate)
Figure 405/57-31-21-990-808 (Sheet 5 of 6)

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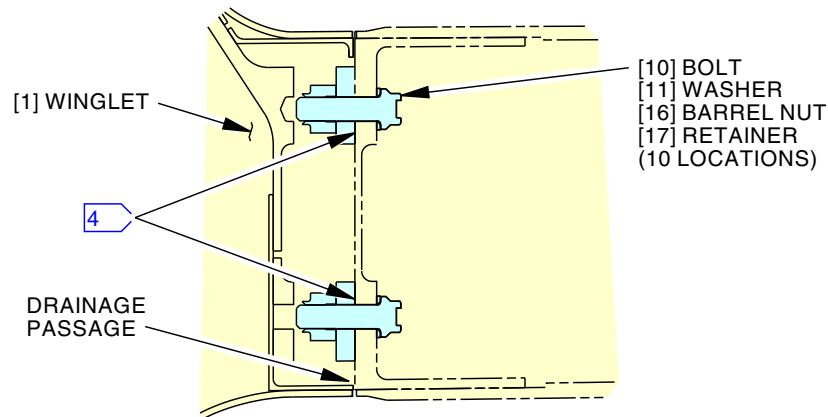
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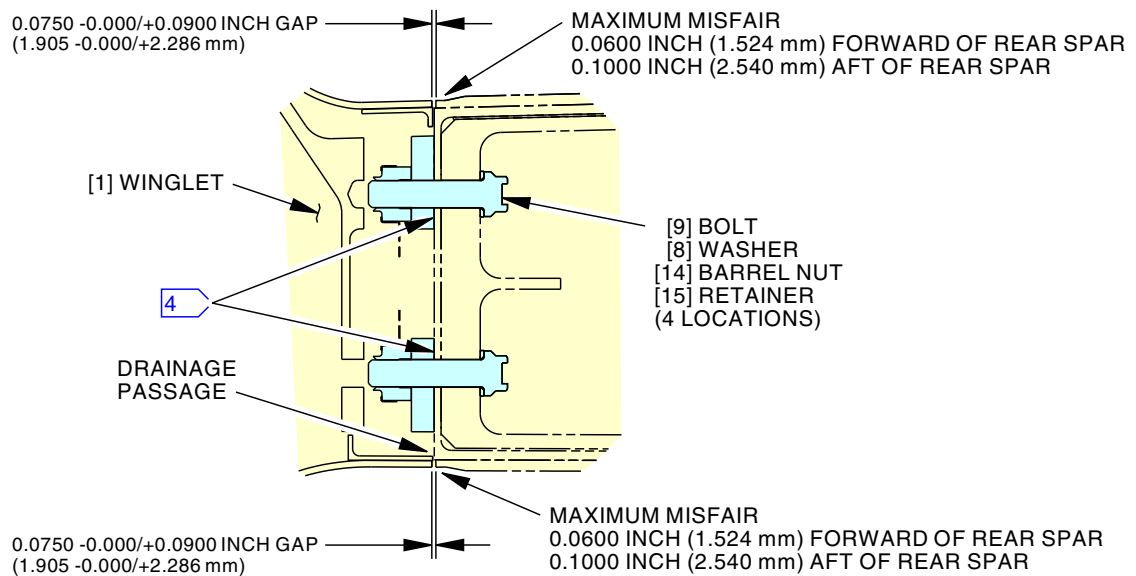
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E-E

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Winglet Installation (Alternate)
Figure 405/57-31-21-990-808 (Sheet 6 of 6)

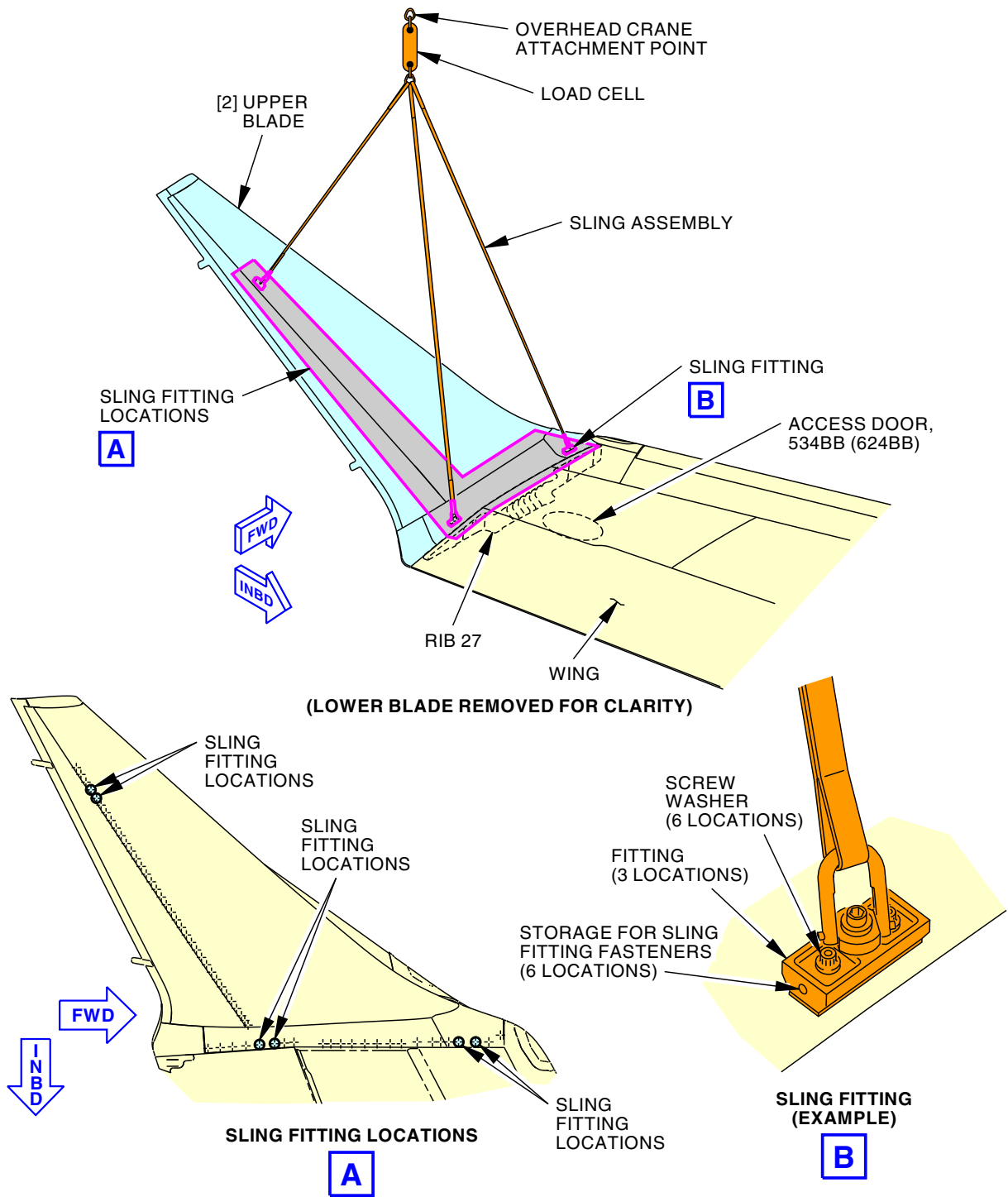
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Winglet Sling Installation (Alternate)
Figure 406/57-31-21-990-809

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TASK 57-31-21-400-803

7. **Winglet Installation (Alternate)**

(Figure 405 and Figure 406)

A. General

- (1) This task gives instructions for the installation of the winglet upper blade and winglet lower blade.
- (2) A second person is required to do this task.

B. References

Reference	Title
27-51-00-040-801	Trailing Edge Flap System Deactivation (P/B 201)
27-81-00-040-801	Leading Edge Flaps and Slats - Deactivation (P/B 201)
51-21-72-370-804	BMS10-11 Primer - Application (P/B 701)
51-22-00-390-801	Non-Removable Faying (Mated) Surface Seal Application (P/B 201)
51-22-00-390-808	Fastener Seal Application (P/B 201)
57-31-21-080-801	Winglet Cover Plate Removal (P/B 201)
57-31-23-400-801	Dry Bay Access Doors Installation (P/B 401)
57-31-23-790-801	Vapor Seal Leak Check (P/B 601)
57-31-24-200-801	Winglet Erosion Protection Inspection (P/B 601)
SRM 51-40-02-0G-0	Fastener Installation and Removal
SWPM 20-20-00	ELECTRICAL BONDING PROCESSES
SWPM 20-20-00 Paragraph 21	MAXIMUM PERMITTED RESISTANCE OF ELECTRICAL BONDS

C. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
COM-1550	Bonding Meter - Approved, Intrinsically Safe (Approved for use in Class I, Divisions I & II hazardous (classified) locations. Outside these hazardous locations, COM-614 can be used in lieu of COM-1550). Part #: 620LK Supplier: 1CRL2 Part #: M1 Supplier: 3AD17 Part #: M1B Supplier: 3AD17 Part #: T477W (C15292) Supplier: 06659
COM-1587	Wrench - Torque, 30 in-lbs (4 N-m) Part #: TE3FUA Supplier: 55719
SPL-2044	Sling - Winglet Part #: C57002-66 Supplier: 81205
SPL-19986	Torque Adapter, Ratcheting Part #: ST2580-550A Supplier: 81205
STD-247	Crane - Lift, 250 lb Capacity, Lift Range 20 to 60 in
STD-1081	Flashlight - Explosion Proof
STD-13964	Wrench - Torque, 200 to 1000 in-lb

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D. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
A02315	Sealant - Low Density, Synthetic Rubber. 2 Part	BMS5-142 Type II
A50110	Sealant - Fuel Tank	BMS5-45 Class B-2
C00259	Coating - Chemical And Solvent Resistant Finish, Corrosion Inhibiting Primer	BMS10-11 Type I
C00528	Compound - Corrosion Preventive, Petroleum Hot Application (Soft Film)	MIL-C-11796 Class III
G50136	Compound - Corrosion Inhibiting, Non-drying Paste	BMS3-38

E. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Winglet	57-31-00-01-115	SIA 001-014
		57-31-21-01-110	SIA ALL
		57-31-21-01-115	SIA ALL
		57-31-21-01-800	SIA ALL
		57-31-21-01-805	SIA ALL
2	Upper blade	57-31-21-01-755	SIA ALL
		57-31-21-01-760	SIA ALL
		57-31-21-05-300	SIA ALL
		57-31-21-05-305	SIA ALL
		57-31-21-01-745	SIA ALL
3	Lower blade	57-31-21-01-750	SIA ALL
		57-31-21-05-310	SIA ALL
		57-31-21-05-315	SIA ALL
		57-31-22-05-010	SIA ALL
		57-31-22-05-015	SIA ALL
40	Rivet	57-31-21-01-205	SIA ALL
		57-31-21-05-065	SIA ALL
		57-31-21-10-741	SIA ALL

F. Location Zones

Zone	Area
500	Left Wing
527	Left Winglet
534	Left Wing - Dry Bay
600	Right Wing
627	Right Winglet
634	Right Wing - Dry Bay

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G. Access Panels

Number	Name/Location
534BB	Dry Bay Tank Access Door - Left Wing Station 748
634BB	Dry Bay Tank Access Door - Right Wing Station 748

H. Winglet Installation (Alternate)

SUBTASK 57-31-21-080-006

- (1) If it is necessary, do this task: Winglet Cover Plate Removal, TASK 57-31-21-080-801.

SUBTASK 57-31-21-480-023

- (2) Make sure that the erosion protection tape is in serviceable condition (TASK 57-31-24-200-801).

SUBTASK 57-31-21-860-010

- (3) Make sure that these circuit breakers are open and have safety tags:

CAPT Electrical System Panel, P18-3

Row	Col	Number	Name
A	12	C04052	EXTERIOR LIGHTING POSITION RIGHT
A	13	C04051	EXTERIOR LIGHTING POSITION LEFT

SUBTASK 57-31-21-040-008



DO THE TRAILING EDGE FLAP DEACTIVATION PROCEDURE BEFORE YOU DO WORK ON THE FLAP SYSTEM. WITH THE FLAPS ACTIVATED, THE FLAPS CAN MOVE AND CAUSE INJURY TO PERSONS OR DAMAGE TO EQUIPMENT.

- (4) If the trailing edge flap system has not been deactivated, do this task: Trailing Edge Flap System Deactivation, TASK 27-51-00-040-801.

SUBTASK 57-31-21-040-009



DO THE DEACTIVATION PROCEDURE FOR THE LEADING EDGE FLAPS. THE ACCIDENTAL MOVEMENT OF THE FLAPS CAN CAUSE INJURY TO PERSONS AND DAMAGE TO EQUIPMENT.

- (5) If the leading edge flaps and slats have not been deactivated, do this task: Leading Edge Flaps and Slats - Deactivation, TASK 27-81-00-040-801.

SUBTASK 57-31-21-480-026

- (6) Install the sling, SPL-2044, on the upper blade [2] (Figure 406).

NOTE: The sling equipment has three attachment fittings, six screws and washers, a sling strap assembly.

- (a) Remove the bolts from the upper blade [2] where the attachment fittings for the sling, SPL-2044, will be attached to the upper blade [2].
- (b) Store the bolts in a bag for the installation procedure.
- (c) Install the screws and washers to attach the attachment fittings to the upper blade [2].

NOTE: The attachment screws and washers for the sling are stored in the threaded storage holes on the end surfaces of the attachment fittings.

- (d) Tighten the screws to 50 in-lb (6 N·m) - 80 in-lb (9 N·m).
- (e) Attach the sling strap assembly to the fittings.

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SUBTASK 57-31-21-480-027

- (7) Attach the sling, SPL-2044, to the overhead, 250 lb capacity lift crane, STD-247 (Figure 406).

NOTE: The upper blade weighs approximately 137 lb (62 kg).

SUBTASK 57-31-21-390-003

- (8) Apply a thin coat of corrosion inhibiting material, G50136, to these surfaces before the installation:
- (a) Apply to the entire faying surface of rib 27 on the wing.
 - (b) Apply to the entire faying surface of the winglet [1] root rib.
 - (c) Make sure that the drainage passages on the winglet wing root below the barrel nut openings are clear of the corrosion inhibiting compound.

SUBTASK 57-31-21-480-025



BE CAREFUL WHEN YOU MANUALLY ADJUST THE UPPER BLADE TO PREPARE IT FROM WHEN YOU CONNECT IT TO THE WINGLET WITH A OVERHEAD CRANE. IF YOU ARE NOT CAREFUL, DAMAGE TO THE RIVET AREA OF THE UPPER BLADE CAN OCCUR.



BE CAREFUL WHEN YOU USE A OVERHEAD CRANE TO CONNECT THE UPPER BLADE TO THE WINGLET. IF YOU ARE NOT CAREFUL, DAMAGE TO THE RIVET AREA OF THE UPPER BLADE CAN OCCUR.

- (9) Operate the overhead crane to lift the sling, SPL-2044, until the lines equally support the upper blade [2].

NOTE: Operate the overhead crane to a tension that will let tighten the bolts that hold the upper blade to the winglet without damage to the bolt threads or to the attach fittings.

SUBTASK 57-31-21-480-031

- (10) Use an explosion proof flashlight, STD-1081, when the dry bay tank inside is looked.

SUBTASK 57-31-21-200-002

- (11) Do a check of the locking feature of the barrel nuts [14] and barrel nuts [16] in the upper blade [2] as follows (View A-A, Figure 405):
- (a) Apply a thin coat of corrosion inhibiting material, G50136, to all surfaces of the threads of the bolts [7], bolts [9], and bolts [12].
 - (b) Install the bolts [7], bolts [9], and bolts [12], one at a time, into the correct hole.
 - 1) Use a torque wrench (30 in-lbs), COM-1587, set to 18 in-lb (2 N·m).
 - 2) If the bolts [7], bolts [9], and bolts [12] can be tightened until the threads protrude, the barrel nuts [14] must be replaced.
 - (c) Apply a thin coat of corrosion inhibiting material, G50136, to the threads of the bolts [10].
 - (d) Install the bolts [10] into the correct holes.
 - 1) Use a torque wrench (30 in-lbs), COM-1587, set to 14 in-lb (2 N·m).
 - 2) If the bolts [10] can be tightened until the threads protrude, the barrel nuts [16] must be replaced.

NOTE: Only replace the discrepant barrel nut.

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- 3) Remove the bolts [10] from the holes.

SUBTASK 57-31-21-960-002

- (12) If it is necessary, replace the barrel nut [14] and barrel nut [16] in the upper blade [2].

NOTE: Only replace the discrepant barrel nut.

- (a) Remove the barrel nut [14] with retainer [15] and barrel nut [16] with retainer [17] through the access holes in the wing root of the upper blade [2].
- (b) Install the new barrel nut [14] with retainer [15] through the access holes in the wing root of the upper blade [2].
- (c) Install the new barrel nut [16] with retainer [17] through the access holes in the wing root of the upper blade [2].

SUBTASK 57-31-21-420-013

- (13) Do these steps to install the upper blade [2] (View A-A, Figure 405):

- (a) If the bolts were not kept on a foam or cardboard piece or the bolts were replaced, make sure that the bolt grip length is correct for the installation location.
- (b) Apply a thin layer of corrosion inhibiting material, G50136, to all surfaces of the bolt threads, shanks, and under the bolt head prior to installation.
- (c) Loose install the bolts [12], bolts [9], and bolts [7] in the order sequence (Table 404).

NOTE: Do not tighten the bolts to the final torque value at this time.

NOTE: 6-inch extensions and low profile swivel head sockets can tighten the bolts to approximately 300 in-lb (33.9 N·m). This is an initial torque to seat the bolts.

- 1) Loose install the bolts [12] and washers [8], one at a time, in sequence until seated in the correct holes.
- 2) Loose install the bolts [9] and washers [8], one at a time, in sequence until seated in the correct holes.
- 3) Apply corrosion inhibiting material, G50136, to the faying surface between the radius fillers [13] and rib 27.
- 4) Put the radius fillers [13] into their position.
- 5) Loose install the bolts [7] and washers [6], one at a time, in sequence until seated in the correct hole.
- (d) Install the bolts [10] and washers [11], one at a time, until seated.

NOTE: Do not tighten the bolts to the final torque value at this time.

NOTE: 6-inch extensions and low profile swivel head sockets can tighten the bolts to approximately 300 in-lb (33.9 N·m). This is an initial torque to seat the bolts.

Table 404/57-31-21-993-804 Winglet Attachment Bolt Installation Order

ITEM	BOLT	INSTALLATION ORDER	LOCATION	TORQUE
[12]	BACB30US8K19M 0.5000 in. (12.7000 mm) dia.	A	Upper Aft (Back)	630 in-lb (71 N·m) - 670 in-lb (76 N·m)
[12]	BACB30US8K19M 0.5000 in. (12.7000 mm) dia.	B	Lower Aft (Back)	630 in-lb (71 N·m) - 670 in-lb (76 N·m)
[9]	BACB30US8K21M 0.5000 in. (12.7000 mm) dia.	C	Upper Forward (Front)	630 in-lb (71 N·m) - 670 in-lb (76 N·m)

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Table 404/57-31-21-993-804 Winglet Attachment Bolt Installation Order (Continued)

ITEM	BOLT	INSTALLATION ORDER	LOCATION	TORQUE
[7]	BACB30US8K21M 0.5000 in. (12.7000 mm) dia.	D	Lower Aft (Middle)	630 in-lb (71 N·m) - 670 in-lb (76 N·m)
[9]	BACB30US8K21M 0.5000 in. (12.7000 mm) dia.	E	Lower Forward (Back)	630 in-lb (71 N·m) - 670 in-lb (76 N·m)
[7]	BACB30US8K21M 0.5000 in. (12.7000 mm) dia.	F	Upper Aft (Middle)	630 in-lb (71 N·m) - 670 in-lb (76 N·m)
[9]	BACB30US8K21M 0.5000 in. (12.7000 mm) dia.	G	Upper Forward (Back)	630 in-lb (71 N·m) - 670 in-lb (76 N·m)
[7]	BACB30US8K21M 0.5000 in. (12.7000 mm) dia.	H	Lower Aft (Front)	630 in-lb (71 N·m) - 670 in-lb (76 N·m)
[9]	BACB30US8K21M 0.5000 in. (12.7000 mm) dia.	I	Lower Forward (Front)	630 in-lb (71 N·m) - 670 in-lb (76 N·m)
[7]	BACB30US8K21M 0.5000 in. (12.7000 mm) dia.	J	Upper Aft (Front)	630 in-lb (71 N·m) - 670 in-lb (76 N·m)
[10]	BACB30US7K13M 0.4375 in. (11.1125 mm) dia.	K	Middle Upper and Lower	427 in-lb (48 N·m) - 453 in-lb (51 N·m)

(e) Tighten the bolts [12], bolts [9], and bolts [7] in the order sequence (Table 404).

1) Use the torque wrench, STD-13964, to tighten the bolts [12], bolts [9], and bolts [7].

NOTE: A combination of 6-inch extensions and low profile swivel head sockets can tighten bolts [12] and bolts [9] to the final torque.

NOTE: A combination of 6-inch extensions and low profile swivel head sockets with the torque adapter, SPL-19986, can tighten bolts [7] to the final torque.

(f) Tighten each of the bolts [10] (Table 404).

1) Use the torque wrench, STD-13964, to tighten the bolts [10].

NOTE: A combination of 6-inch extensions and low profile swivel head sockets can tighten bolts [10] to the final torque.

SUBTASK 57-31-21-420-018

(14) Connect the aft bonding jumper [18] (View B, Figure 405).

(a) Install the bonding jumper [18] on the electrical stud on the wing rib.

(b) Install the washer [20] and nut [19] to attach the bonding jumper [18].

(c) Measure the electrical bonding resistance between terminal of the bonding jumper [18] and structure (SWPM 20-20-00).

1) Use an intrinsically safe approved bonding meter, COM-1550.

2) Make sure that the electrical bonding resistance is 0.001 ohm (1.0 milliohm) or less.

SUBTASK 57-31-21-420-019

(15) Connect the forward bonding jumper [4] (View C, Figure 405).

(a) Install the bonding jumper [4] on the electrical stud on the wing rib.

(b) Install the washer [6] and nut [5] to attach the bonding jumper [4].

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- (c) Measure the electrical bonding resistance between terminal of the bonding jumper [4] and structure (SWPM 20-20-00).
 - 1) Use an intrinsically safe approved bonding meter, COM-1550.
 - 2) Make sure that the electrical bonding resistance is 0.001 ohm (1.0 milliohm) or less.

SUBTASK 57-31-21-220-001

- (16) Make sure that the misfair is in the limits (View A-A, Figure 405):
 - (a) Make sure that the aft 6.0 ± 0.5 in. (152.4 ± 12.7 mm) of the upper blade [2] aligns with the upper wing surface to within 0.1200 in. (3.0480 mm).
 - (b) Make sure that the upper blade [2] aligns with the upper and lower wing surface forward of the rear spar to within 0.06 in. (1.524 mm).
 - (c) Make sure that the upper blade [2] aligns with the upper and lower wing surface aft of the rear spar to within 0.10 in. (2.54 mm).
 - (d) Make sure that the space between the upper blade [2] and the upper and lower wing skin is in the limit of $0.075 + 0.090 / - 0.000$ in. ($1.905 + 2.286 / - 0.000$ mm).

SUBTASK 57-31-21-080-007

- (17) Remove the sling, SPL-2044, from the upper blade [2].
 - (a) Remove the screws and washers from the attachment fittings.
 - (b) Install the screws and washers in the threaded storage holes in the ends of the attachment fittings.
 - (c) Apply compound, C00528, to the holes in the upper blade [2] and immediately install the bolts.
 - (d) Tighten the bolts to 30 in-lb (3 N·m) - 40 in-lb (5 N·m).

SUBTASK 57-31-21-390-004

- (18) Apply a seal to the external gap on the upper surface of the upper blade [2] between point A and B with sealant, A00247 (View F, Figure 405).

NOTE: It is optional to use sealant, A02315.

SUBTASK 57-31-21-790-002

- (19) If the absolute vapor seal has been moved or changed, do the vapor seal leak check of the dry bay (TASK 57-31-23-790-801).

SUBTASK 57-31-21-420-014

- (20) Do these steps to install the rivets [40] that attach the upper closeout fairing [46] to the winglet [1] (View E, Figure 405):
 - (a) Apply sealant, A50110, to the faying surface of the rivets [40] (TASK 51-22-00-390-801).
 - (b) Install the rivets [40] (SRM PROCEDURE 51-40-02-0G-0, SWPM 20-20-00).

SUBTASK 57-31-21-420-015

- (21) Do these steps to install the drain plug [49] (View E, Figure 405):
 - (a) Apply sealant, A50110, to the faying surface of the drain plug [49] and aft closeout fairings (TASK 51-22-00-390-801).
 - (b) Attach the drain plug [49] to the necessary aft closeout fairings.
 - 1) Make sure that the drain path remains free of sealant and adhesive.

SUBTASK 57-31-21-420-016

- (22) Do these steps to install the center closeout fairing [45] to the winglet [1] (View D, Figure 405):

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- (a) Apply corrosion inhibiting material, G50136, to the hole where the bolts [41] will be installed.
- (b) Immediately install the bolts [41].
 - 1) Tighten the bolts [41] to a torque tool setpoint of 30 in-lb (3 N·m).
- (c) Apply corrosion inhibiting material, G50136, to the indicated surface of the rivets [40].
- (d) Install the rivets [40] (SRM PROCEDURE 51-40-02-0G-0, SWPM 20-20-00).
- (e) Measure the electrical bonding resistance between the center closeout fairing [45] and upper blade [2] (SWPM 20-20-00 Paragraph 21).
 - 1) Use an intrinsically safe approved bonding meter, COM-1550.
 - 2) Make sure that the electrical bonding resistance is 0.0005 ohm (0.5 milliohm) or less.
- (f) Measure the electrical bonding resistance between the center closeout fairing [45] and lower blade [3] (SWPM 20-20-00 Paragraph 21).
 - 1) Use an intrinsically safe approved bonding meter, COM-1550.
 - 2) Make sure that the electrical bonding resistance is 0.0005 ohm (0.5 milliohm) or less.

SUBTASK 57-31-21-420-017

- (23) Do these steps to install the lower closeout fairing [44] to the winglet [1] (View E, Figure 405):
 - (a) Apply sealant, A50110, to the faying surface of the fasteners (TASK 51-22-00-390-801).
 - (b) Install the bolts [50], washers [47], and nuts [48] with sealant, A50110 (TASK 51-22-00-390-808).
 - 1) Tighten the fasteners to a torque tool setpoint of 30 in-lb (3 N·m).
 - (c) Measure the electrical bonding resistance between the head of bolt [42] and lower closeout fairing [44] (SWPM 20-20-00 Paragraph 21).
 - 1) Use an intrinsically safe approved bonding meter, COM-1550.
 - 2) Make sure that the electrical bonding resistance is 0.0005 ohm (0.5 milliohm) or less.
 - (d) Apply primer, C00259, as necessary (TASK 51-21-72-370-804).

SUBTASK 57-31-21-410-013

- (24) Install these access doors on the left or right wing (TASK 57-31-23-400-801).
 - (a) Close these access doors.

<u>Number</u>	<u>Name/Location</u>
534BB	Dry Bay Tank Access Door - Left Wing Station 748
634BB	Dry Bay Tank Access Door - Right Wing Station 748

SUBTASK 57-31-21-400-004

- (25) Do this task: Winglet Lower Blade Installation, TASK 57-31-21-400-802.

———— **END OF TASK** ————

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WINGLET - INSPECTION/CHECK

1. **General**

- A. This procedure has this task:
(1) Winglet Lower Blade Inspection.

TASK 57-31-21-211-801

2. **Winglet Lower Blade Inspection**

A. References

Reference	Title
05-51-36-210-801	Winglet Strike Inspection Phase I (P/B 201)
57-31-21-000-802	Winglet Lower Blade Removal (P/B 401)
57-31-21-400-802	Winglet Lower Blade Installation (P/B 401)

B. Location Zones

Zone	Area
500	Left Wing
527	Left Winglet
600	Right Wing
627	Right Winglet

C. Prepare for the Inspection

SUBTASK 57-31-21-210-003

- (1) If there was a winglet lower blade strike condition, do this task: TASK 05-51-36-210-801.

SUBTASK 57-31-21-010-005

- (2) Do this task: Winglet Lower Blade Removal, TASK 57-31-21-000-802.

D. Winglet Lower Blade Inspection

SUBTASK 57-31-21-211-001

- (1) Do a detailed visual inspection of the winglet lower blade to winglet upper blade attachment.

SUBTASK 57-31-21-211-002

- (2) Do a detailed visual inspection of the exposed attach fittings of the winglet blade ribs for evidence of cracks, buckling, elongated holes, or other damage.

NOTE: Use 10x magnification around the winglet attach fastener holes.

SUBTASK 57-31-21-211-003

- (3) Do a detailed visual inspection of the winglet upper blade to wing surface.
(a) Inspect the aero-sealed and unsealed portions for evidence of binding, interference, or other damage.

SUBTASK 57-31-21-300-001

- (4) If any damage is found to the winglets or wing structure, refer to the applicable SRM procedure.

E. Put the Airplane Back to Its Usual Condition

SUBTASK 57-31-21-410-007

- (1) Do this task: Winglet Lower Blade Installation, TASK 57-31-21-400-802.

————— **END OF TASK** —————

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WINGLET - CLEANING/PAINTING

1. General

A. This procedure has these tasks:

- (1) Prepare to Paint the Winglet
- (2) Basecoat/Clearcoat Paint System Application
- (3) Basecoat/Clearcoat Paint System Repair
- (4) Basecoat/Clearcoat Paint System Preparation for BMS10-148 Application.

TASK 57-31-21-300-801

2. Prepare to Paint the Winglet

A. **General**

- (1) This task has the masking requirements before you paint the winglet.

B. **Location Zones**

Zone	Area
527	Left Winglet
627	Right Winglet

C. **Masking Requirements**

SUBTASK 57-31-21-950-001

- (1) Mask the surfaces and items that follow:
 - (a) The Ground Support Equipment (GSE) attach locations.
NOTE: This helps identify the correct fastener locations for the GSE.
 - 1) Mask the head of the fasteners common to the GSE fittings.
 - (b) Inboard surfaces at winglet station zero.
 - 1) Overspray is allowed onto inboard upper and lower skin edges.
 - 2) Overspray is not allowed on the bulb seal.
 - 3) Refer to Figure 701 for overspray allowance and masking requirements.
 - (c) The lower blade marker light glass lens.
 - (d) The anti-collision light glass lens.

———— **END OF TASK** ————

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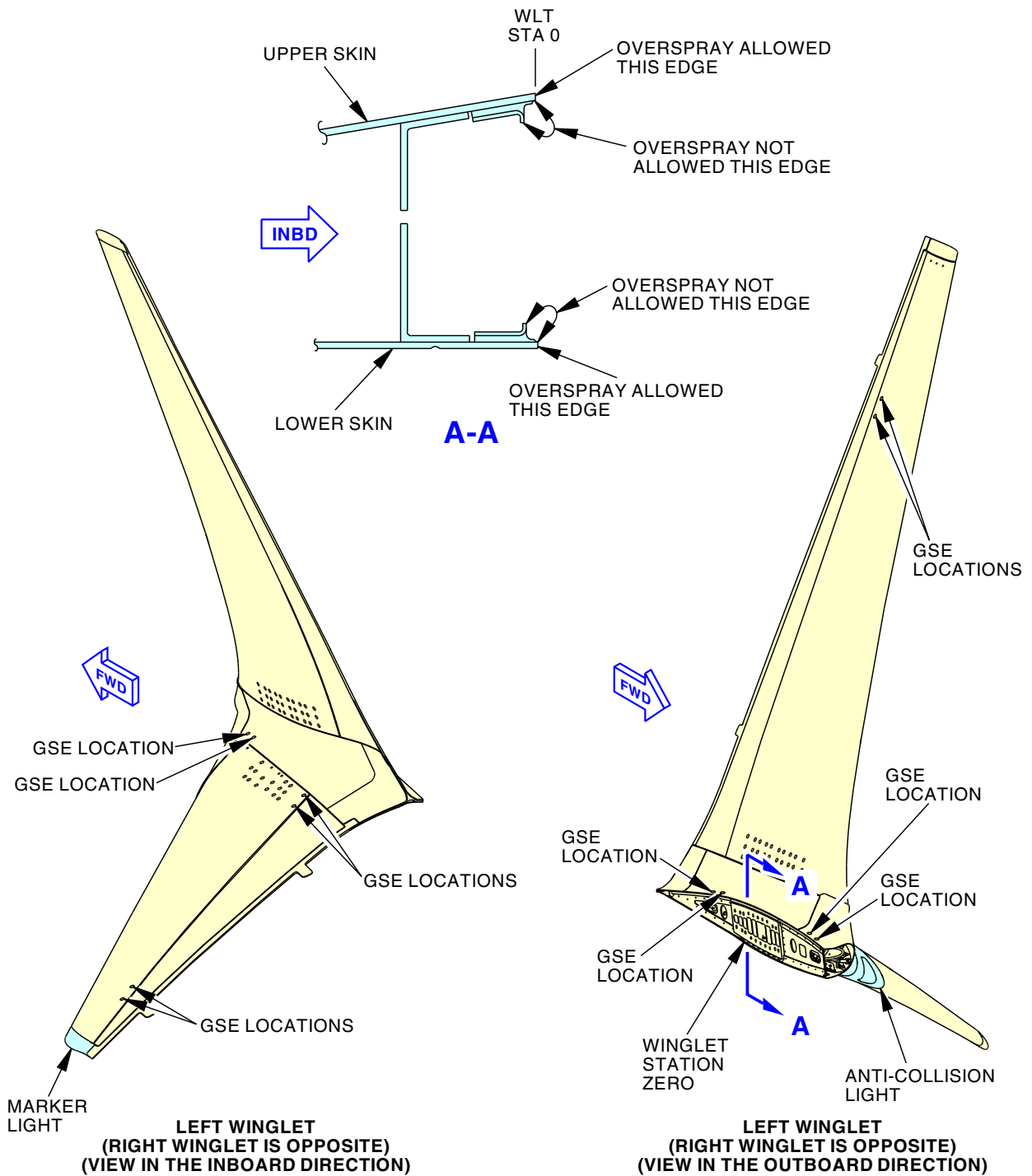
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**Winglet Masking Requirements
Figure 701/57-31-21-990-806**

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TASK 57-31-21-300-802

3. Basecoat/Clearcoat Paint System Application

A. General

- (1) This task has the steps to paint the winglet.
- (2) Do not get paint or primer on these items:
 - Decoupled static dischargers or retainers on the wing and empennage,
 - Polished aluminum surfaces,
 - Winglet Erosion Tape (BMS10-148, Type I),
 - Rubber seals,
 - Exterior light lens covers.
- (3) Paint should meet the requirements and be listed on the approved products list (QPL) of BMS10-125, Type IV. In addition to this procedure, Boeing specification BAC5075 provides procedures for Basecoat/Clearcoat paint system application.

B. References

Reference	Title
51-21-21-100-801	Clean the Surface to be Painted (P/B 701)
51-21-21-370-801	Prepare the Surface to be Painted (P/B 701)

C. Prepare to Apply the Paint System

SUBTASK 57-31-21-500-003

- (1) Put covers on the following components:
 - (a) Decoupled static dischargers or retainers on the wing and empennage,
 - (b) Polished aluminum surfaces,
 - (c) Winglet Erosion Tape (BMS10-148, Type I),
 - (d) Rubber seals,
 - (e) Exterior light lenses.

SUBTASK 57-31-21-100-009

- (2) Do this task: Clean the Surface to be Painted, TASK 51-21-21-100-801.

SUBTASK 57-31-21-840-001

- (3) Do this task: Prepare the Surface to be Painted, TASK 51-21-21-370-801.

SUBTASK 57-31-21-370-002

- (4) Apply the decorative exterior paint system as specified by the applicable customer livery, livery drawings, paint manufacturer's specifications and with Table 701.

Table 701/57-31-21-993-807 Decorative Exterior Paint System Application Specifications

Description	Coating Specification	Application Specification	Applied On
Nonchromated Primer for Composites	BMS 10-103, Type I	BAC5325	Rivets
Exterior Decorative Paint	BMS 10-125, Type IV	BAC5075	Entire assembly, per customer livery
Urethane Compatible Primer	BMS 10-79	BAC5882	Detail Aluminum

- (a) Paint mixing, straining, application and cure per BAC5075.
- (b) Aerodur 3001G Basecoat Application per BAC5075.

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- (c) Aerodur 3002G Clearcoat Application per BAC5075.
- (d) Aerodur 3001E Special Effects Basecoat application, if necessary by customer livery, per BAC5075.
- (e) Drying and Cure the paint system per BAC5075.

———— **END OF TASK** ————

TASK 57-31-21-300-803

4. Basecoat/Clearcoat Paint System Repair

A. Consumable Materials

Reference	Description	Specification
B00102	Abrasive - Aluminum Oxide Coated Cloth	
B00130	Alcohol - Isopropyl	TT-I-735
B00184	Solvent - Presealing, Cleaning Solvent	BMS11-7
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	AMS3819 Class 1 Grade A or B Form 1 (Supersede BMS15-5 CL A)

B. Procedure

SUBTASK 57-31-21-300-002

- (1) Repair areas with minor damage (no bare metal) as follows:
 - (a) Rub the surface smooth with a 240 grit (minimum) wet or dry abrasive cloth, B00102 paper.
 - (b) Remove the remaining particles with a clean cotton wiper, G00034, that is moist with solvent, B00184, or alcohol, B00130.
 - (c) Dry the surface with a clean cotton wiper, G00034.
 - (d) Apply the applicable primer and top coats again, if necessary (TASK 57-31-21-300-802).
 - (e) Make sure that you get a smooth continuous surface.

SUBTASK 57-31-21-300-003

- (2) Repair areas with defective paint layers as follows:
 - (a) Rub the surface smooth with a 240 grit (minimum) wet paper or dry abrasive cloth, B00102 to remove defects.
 - (b) Feather the edges into the adjacent areas.
 - (c) Remove the remaining particles with a clean cotton wiper, G00034 that is moist with solvent, B00184 or alcohol, B00130.
 - (d) Dry the surface with a clean cotton wiper, G00034.
 - (e) Apply the applicable primer and top coats per manufacturer's specification and Table 701.
 - (f) Feather the edges to get a smooth continuous surface.

———— **END OF TASK** ————

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TASK 57-31-21-300-804

5. Basecoat/Clearcoat Paint System Preparation for BMS10-148 Application

A. General

- (1) This task prepares the Basecoat/Clearcoat paint system for application of the BMS10-148 Erosion tape. Do not complete this task on surfaces that will not receive the BMS10-148 Erosion tape.
- (2) Paint lines and edges are to be abraded to ensure smooth transitions for the BMS10-148 Erosion tape. Paint line and edge transitions will be visible under the BMS10-148 Erosion tape if not properly abraded and prepared.
- (3) The surface must be free from inclusions and debris after perpetration. Inclusions or debris will be visible in the form of air bubbles under the BMS10-148 Erosion tape if not properly prepared.

B. References

Reference	Title
57-31-24-400-801	Winglet Erosion Protection Installation (P/B 401)
57-31-24-400-802	Winglet Erosion Protection Installation (P/B 401)

C. Tools/Equipment

Reference	Description
STD-1207	Sander/Polisher - Orbital, Air Driven

D. Consumable Materials

Reference	Description	Specification
A50424	Tape - Masking, No. 7288, Heat Resistant Washi.	JIS Z-0237
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	AMS3819 Class 1 Grade A or B Form 1 (Supersede BMS15-5 CL A)
G02219	Tape - Yellow Vinyl Adhesive, Scotch Brand No.471, 1.5 Inches (38.1 mm) Wide	
G50123	Rag - Epoxy Coated Tack Rag - C-60	
G50509	Tape - Masking (3M Scotch Fine Line Tape 218)	AMS-T-21595
G51224	Pad - Abrasive, Scotch-Brite, Very Fine, Maroon 7447	A-A-58054 Type I Grade A
G51313	Abrasive - Sanding Disc, Foam Backing, 443SA Pattern, A5 or P3000	Commercially Available
G51315	Abrasive - Hand Pad, Super Fine, P400	Commercially Available
G51319	Abrasive - Aluminum Oxide, Very Fine, Grade A, Maroon, Non-Woven, Resin Bonded, Scotch-Brite Clean and Finish	
G51488	Tape - Masking, Pressure Sensitive - PG777	

E. Prepare for the Procedure

SUBTASK 57-31-21-300-004

- (1) Make sure that the Aerodur 3002 Clearcoat surface has been cured for a minimum of 4 hours at 120°F (49°C) set point.

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SUBTASK 57-31-21-950-002

- (2) Mask the surfaces that will not be abraded with Tape - Masking, G50509, Scotch Brand No.471 tape, G02219, masking tape, A50424, or PG777 tape, G51488. Protect substrate edges and surfaces from damage during sanding.

SUBTASK 57-31-21-120-001

- (3) Abrade only the Aerodur 3002 Clearcoat Surface that will have BMS10-148 Erosion tape installed.

F. Procedure

SUBTASK 57-31-21-120-002

- (1) Use hand sanding procedure with P400 aero-contouring abrasive, G51315 on the surface paint lines within 0.25 in. (6.35 mm) of part or sharp edges.

- (a) Do not damage the substrate surfaces while sanding.
- (b) Do not sand through to the basecoat.

NOTE: The Aerodur 3002 Clearcoat prevents the basecoat or nonmetallic special visual effect coat from smearing and degrading in appearance.

SUBTASK 57-31-21-120-003

- (2) Smooth the paint line edges with P400 aero-contouring abrasive, G51315 on a 1.25 in. (31.75 mm) random orbital sander/polisher, STD-1207 with 3/16 in. (5 mm) orbit at maximum rotational speed of 6500 rpm.

- (a) Alternatively, use a 3 in. (7.6 cm) x 4 in. (10.2 cm) random orbital sander with 3/16 in. (5 mm) orbit at maximum rotational speed of 6500 rpm. Do not use a larger diameter sander on paint line edges.
- (b) Make sure that the sander is near flush with the paint surface and centered on the paint line edge. Abrade using a slight pressure in a back and forth motion along the paint line edge.
- (c) Abrade the paint line edge until the gloss is removed from the higher (thicker) paint surface.

NOTE: A 1/32 in. (0.8 mm) to 1/16 in. (1.6 mm) wide glossy line should appear on the lower (thinner) paint surface along the paint line edge.

- (d) Continue to abrade the paint line until the paint line is almost or fully smoothed.

SUBTASK 57-31-21-300-005

- (3) When Aerodur 3001 basecoat design color transfers to the field color, wipe color transfer with IPA.
 - (a) If color transfer cannot be removed by wiping, then wet abrade with a A5 or P3000 abrasive, G51313 pad on a 1.25 in. (31.8 mm) random orbital sander/polisher, STD-1207. Apply light pressure.
 - 1) Alternatively, use a 3 in. (7.6 cm) x 4 in. (10.2 cm) random orbital sander.

SUBTASK 57-31-21-120-004

- (4) Remove all visually noticeable surface inclusions with a P400 aero-contouring abrasive, G51315 pad on a 1.25 in. (31.8 mm) random orbital sander/polisher, STD-1207 with a 3/16 in. (4.8 mm) orbit. Apply light pressure.
 - (a) Alternatively, use a 3 in. (7.6 cm) x 4 in. (10.2 cm) random orbital sander with 3/16 in. (5 mm) orbit.

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SUBTASK 57-31-21-120-005

- (5) Polish the surface with a Scotch-Brite 7447 pad, G51224 or abrasive pad, G51319 on a jitterbug/orbital action sander.
 - (a) Remove loose dust with compressed air.
 - (b) Do not use large orbital sander near the abraded paint lines. This may result in burn through.

SUBTASK 57-31-21-300-006

- (6) Visually inspect surfaces to make sure that all aerodynamic surfaces and paint line edges that will be covered by BMS10-148 erosion tape are smooth.
 - (a) Verify smoothness by feeling the edge with a clean fingertip or use clean gloves.

SUBTASK 57-31-21-100-010

- (7) Wipe with a clean cotton wiper, G00034 damp with water. Wipe dry with a new cotton wiper, G00034.

SUBTASK 57-31-21-100-011

- (8) Make sure that the surface is thoroughly dry. Remove dust from the sanding with a tack rag, G50123.

SUBTASK 57-31-21-100-012

- (9) Clean the surface using compressed air and wipe with a new tack rag, G50123.

SUBTASK 57-31-21-400-005

- (10) Do this task: Winglet Erosion Protection Installation, TASK 57-31-24-400-801 or Winglet Erosion Protection Installation, TASK 57-31-24-400-802.

———— **END OF TASK** ————

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WINGLET AERODYNAMIC SEALANT - REPAIR

1. General

- A. This procedure has this task:
(1) Winglet Aerodynamic Sealant Repair.

TASK 57-31-21-390-801

2. Winglet Aerodynamic Sealant Repair

(Figure 801)

A. **General**

- (1) This task gives the procedure to apply sealant to the winglet.

B. **Consumable Materials**

Reference	Description	Specification
A02315	Sealant - Low Density, Synthetic Rubber. 2 Part	BMS5-142 Type II
A50110	Sealant - Fuel Tank	BMS5-45 Class B-2
A50528	Sealant - Fast Cure	BMS5-184

C. **Location Zones**

Zone	Area
500	Left Wing
527	Left Winglet
534	Left Wing - Dry Bay
600	Right Wing
627	Right Winglet
634	Right Wing - Dry Bay

D. **Winglet Seal**

SUBTASK 57-31-21-390-005

- (1) Apply sealant, A02315 or sealant, A50528 to the necessary areas (Figure 801).

SUBTASK 57-31-21-390-006

- (2) Apply sealant, A50110 to the necessary areas (Figure 801).

————— **END OF TASK** —————

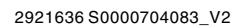
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Winglet Seal
Figure 801/57-31-21-990-810 (Sheet 1 of 4)

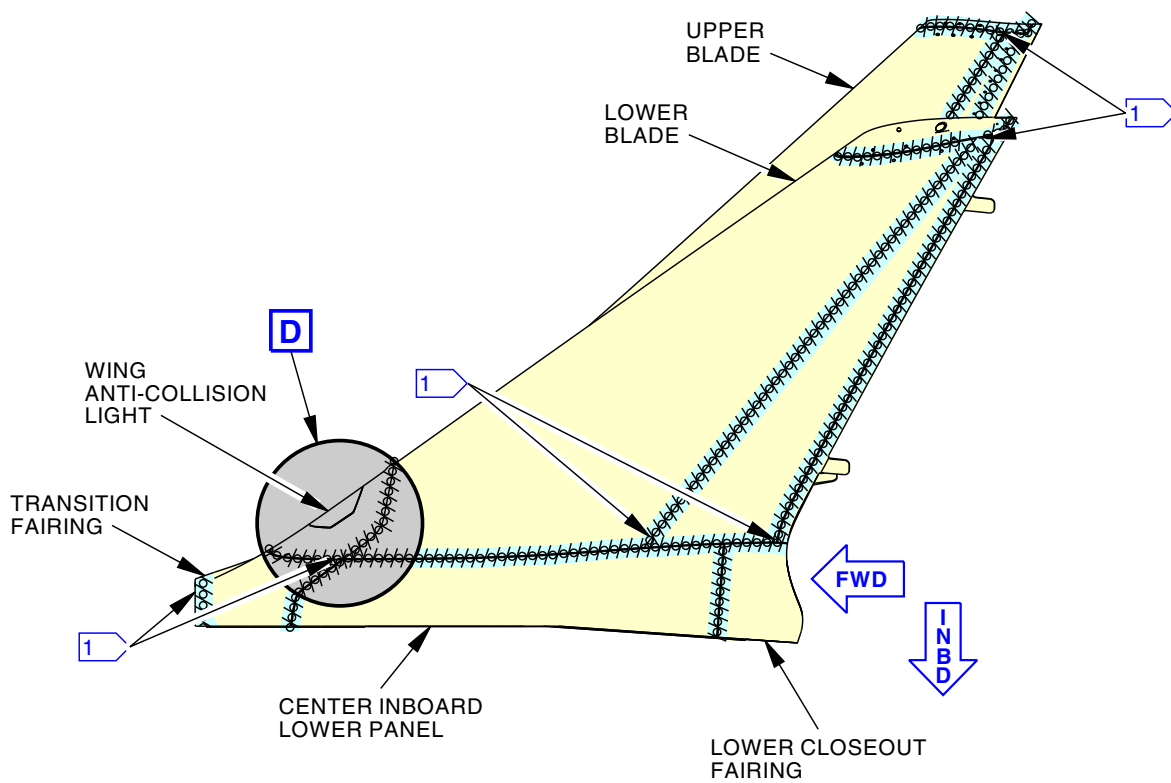
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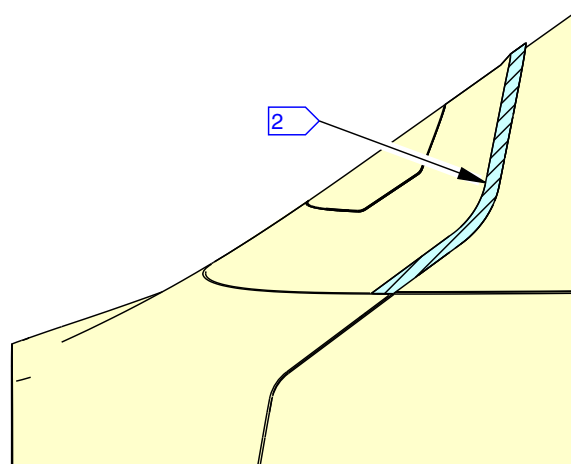
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(BOTTOM VIEW)

C



D

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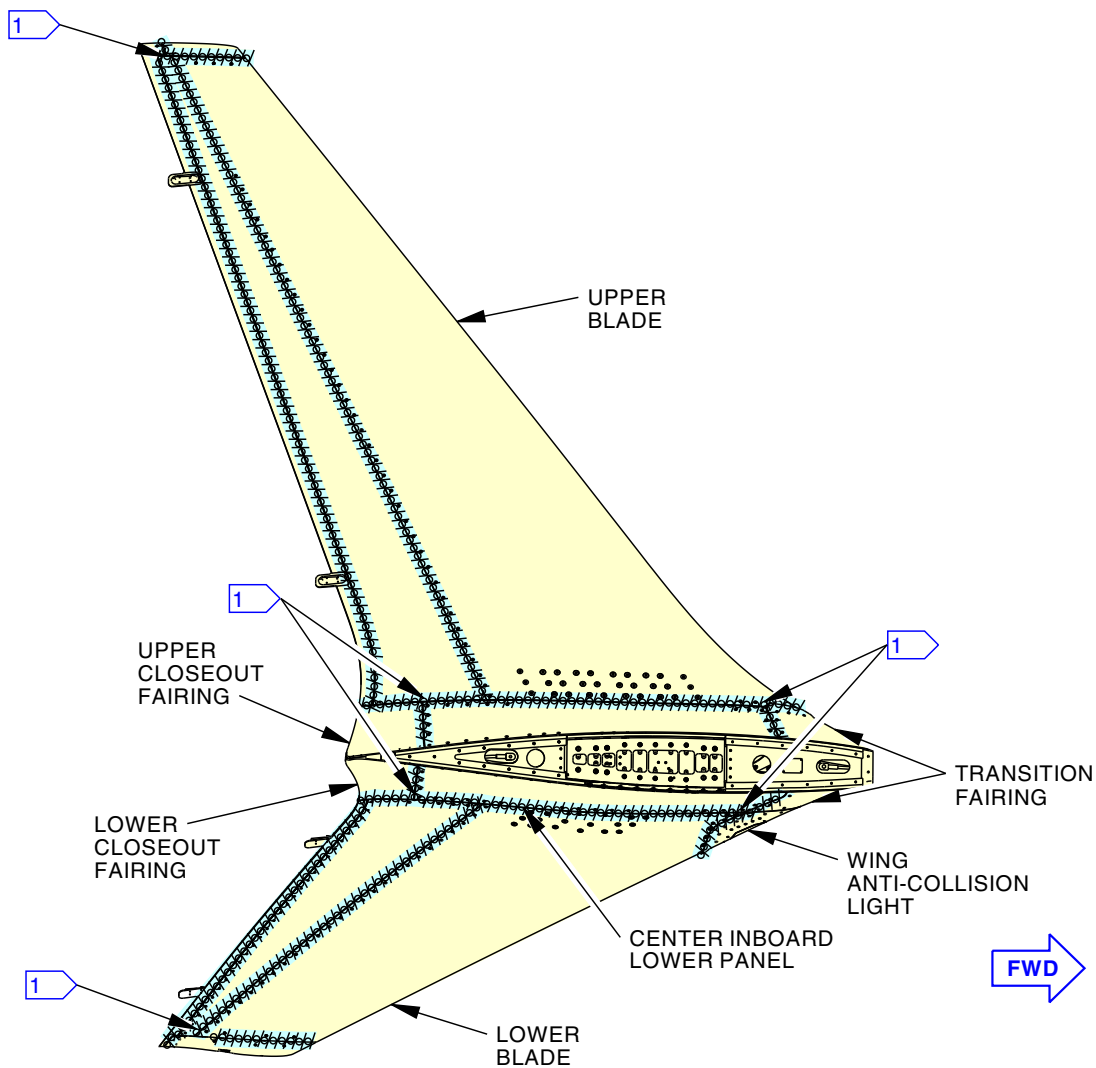
Winglet Seal
Figure 801/57-31-21-990-810 (Sheet 2 of 4)

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(VIEW IN THE OUTBOARD DIRECTION)

E

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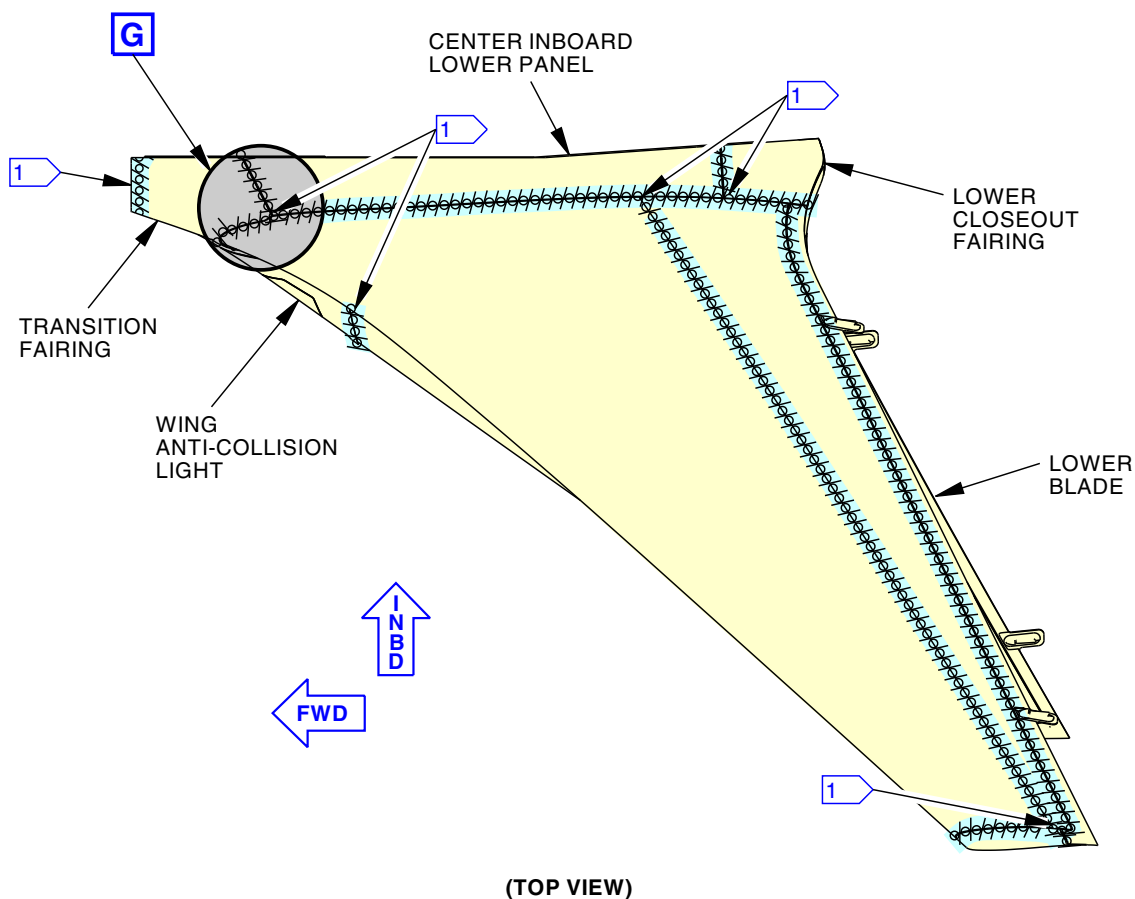
Winglet Seal
Figure 801/57-31-21-990-810 (Sheet 3 of 4)

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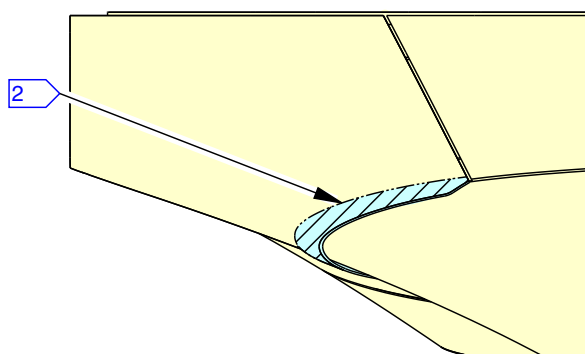
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(TOP VIEW)

F



G

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Winglet Seal
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WING DRY BAY TANK ACCESS DOORS - REMOVAL/INSTALLATION

1. **General**

A. This procedure has these tasks:

- (1) Dry bay access doors removal
- (2) Dry bay access doors installation.

B. There are two dry bay tanks that are outboard of the surge fuel tank which is a wet bay. The dry bay tanks are between the outboard wing rib 27, the middle rib 26 and the outboard rib 25 of the surge fuel tank.

TASK 57-31-23-000-801

2. **Dry Bay Access Doors Removal**

(Figure 401)

A. **General**

- (1) This task gives the procedure to remove the two access doors for the inboard or outboard wing dry bay tanks in the left or right wing.

B. **References**

Reference	Title
20-40-11-910-801	Static Grounding (P/B 201)
24-22-00-860-802	Remove Electrical Power (P/B 201)
27-51-00-040-801	Trailing Edge Flap System Deactivation (P/B 201)
27-81-00-040-801	Leading Edge Flaps and Slats - Deactivation (P/B 201)

C. **Tools/Equipment**

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
COM-659	Platform - Maintenance Lift, 3 ft Minimum Height, 12.5 ft Maximum Height Part #: 1135-8000 Supplier: 00994 Opt Part #: 8662-010 Supplier: 00994
COM-2480	Platform - Mobile Elevating Work Platform SJ III Series Part #: SJIII 4726 Supplier: 3AF08 Part #: SJIII 4732 Supplier: 3AF08 Opt Part #: SJIII 4620 Supplier: 3AF08 Opt Part #: SJIII 4626 Supplier: 3AF08 Opt Part #: SJIII 4632 Supplier: 3AF08

D. **Location Zones**

Zone	Area
500	Left Wing
534	Left Wing - Dry Bay
600	Right Wing
634	Right Wing - Dry Bay

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E. Access Panels

Number	Name/Location
534AB	Dry Bay Tank Access Door - Left Wing Station 727
534BB	Dry Bay Tank Access Door - Left Wing Station 748
634AB	Dry Bay Tank Access Door - Right Wing Station 727
634BB	Dry Bay Tank Access Door - Right Wing Station 748

F. Remove the Access Doors

SUBTASK 57-31-23-760-001

- (1) Make sure that the airplane is correctly grounded to an approved and identified ground.
 - (a) Do this task: Static Grounding, TASK 20-40-11-910-801.

SUBTASK 57-31-23-040-001

- (2) Do this task: Trailing Edge Flap System Deactivation, TASK 27-51-00-040-801.

SUBTASK 57-31-23-040-002

- (3) Do this task: Leading Edge Flaps and Slats - Deactivation, TASK 27-81-00-040-801.

SUBTASK 57-31-23-490-001

- (4) Make sure that one of these portable fire extinguishers is available:
 - (a) one - 150 pound dry chemical wheeled extinguisher.
 - (b) one - 150 pound CO2 wheeled extinguisher.
 - (c) one - 150 pound Halon wheeled extinguisher.

SUBTASK 57-31-23-490-002

- (5) Get a ladder, work platform, COM-2480 or maintenance platform, COM-659.

SUBTASK 57-31-23-765-001

- (6) Do these steps to prepare metal support equipment such as work platforms, work/maintenance stands, ladders.

NOTE: These steps apply to all metal support equipment within a 50 ft (15 m) radius of an open fuel tank.

- (a) All support equipment must be in place before you begin the procedure.
- (b) Bond the support equipment at an approved airplane bonding location.
- (c) Ground the support equipment to the same earth ground as the airplane.

SUBTASK 57-31-23-862-001

- (7) Remove the electrical power from the airplane before you remove the tank access doors.
 - (a) Install a "Do Not Apply Electrical Power" tag on the external power source receptacle and on the cockpit left control stick.
 - (b) Do this task: Remove Electrical Power, TASK 24-22-00-860-802.
 - (c) Do not supply electrical power again until you have completed this procedure.

SUBTASK 57-31-23-020-001

- (8) If it is necessary, open the inboard dry bay tank access door [1] on the left or right wing.
 - (a) Open these access doors.

<u>Number</u>	<u>Name/Location</u>
534AB	Dry Bay Tank Access Door - Left Wing Station 727
634AB	Dry Bay Tank Access Door - Right Wing Station 727

- (b) Remove the 16 bolts [2] and store the bolts in a bag for the installation.

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- (c) Remove the access door [1].

SUBTASK 57-31-23-020-002

- (9) If it is necessary, open the outboard dry bay tank access door [3] on the left or right wing.

- (a) Open these access doors.

<u>Number</u>	<u>Name/Location</u>
534BB	Dry Bay Tank Access Door - Left Wing Station 748
634BB	Dry Bay Tank Access Door - Right Wing Station 748

- (b) Remove the 16 bolts [5] and store the bolts in a bag for the installation.

- (c) Remove the gasket [4], the clamp ring [6] and the access door [3].

NOTE: It is not recommended, but if it is necessary, you may be able to re-use the gasket [4].

———— **END OF TASK** ————

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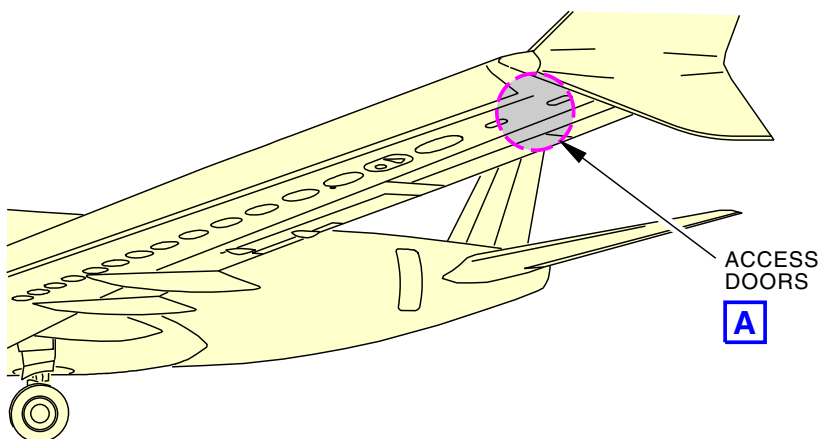
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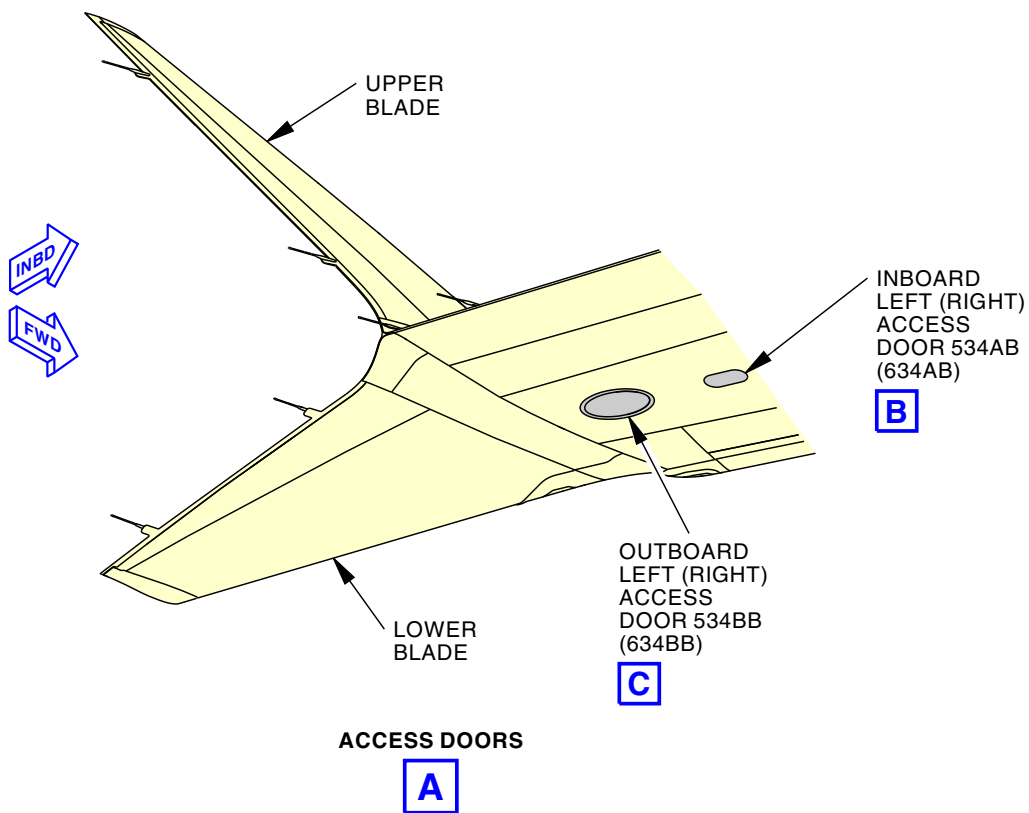
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LEFT WING
(RIGHT WING IS OPPOSITE)



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Dry Bay Access Doors Installation
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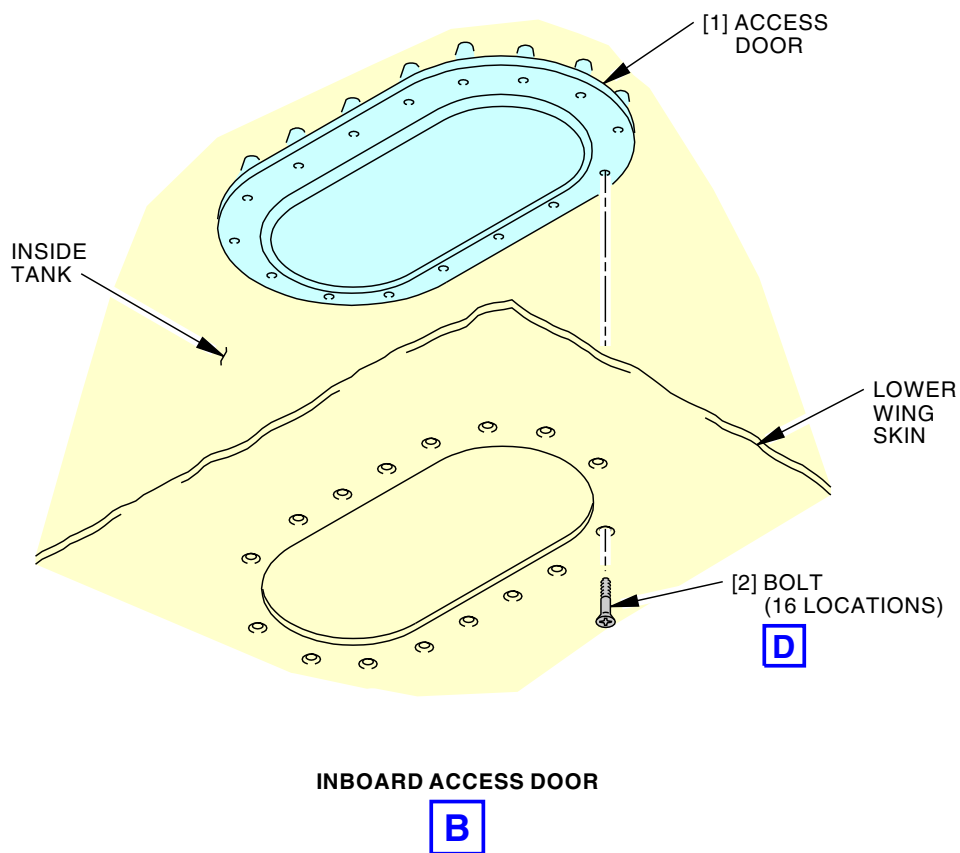
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Dry Bay Access Doors Installation
Figure 401/57-31-23-990-801 (Sheet 2 of 3)

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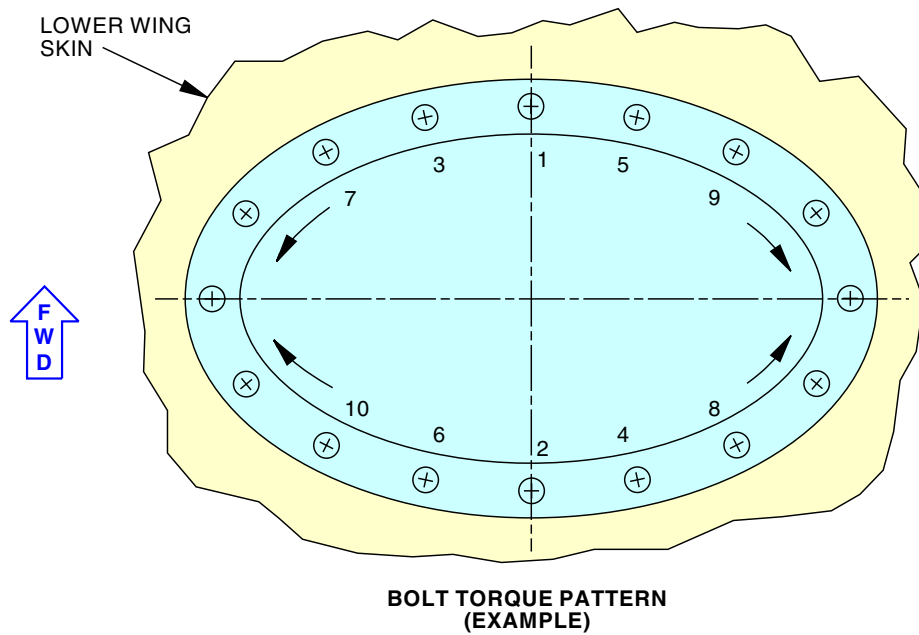
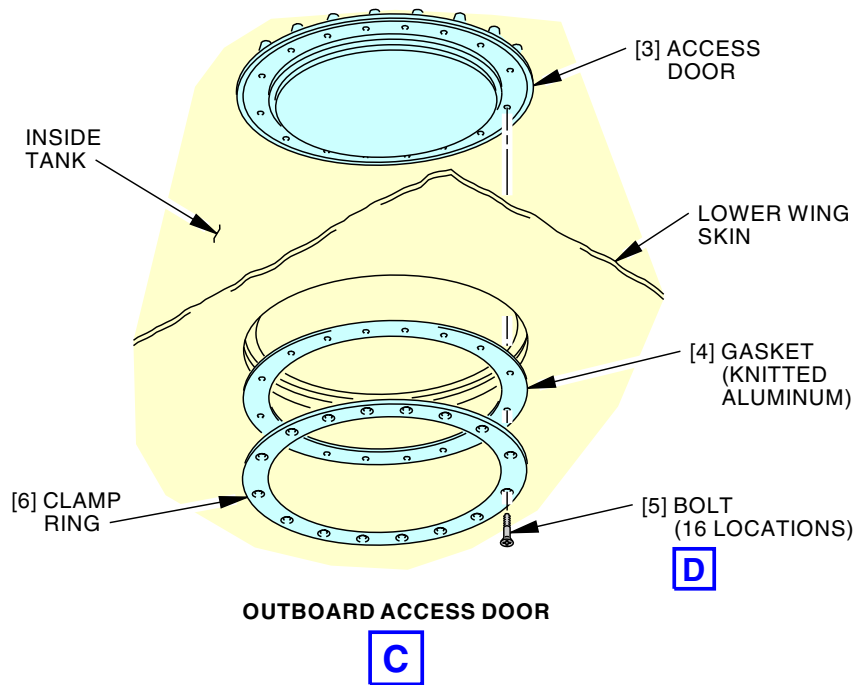
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NOTE:
TORQUE THE MOUNT BOLTS IN THE SEQUENCE SHOWN BY THE NUMBERS.

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Dry Bay Access Doors Installation
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TASK 57-31-23-400-801

3. **Dry Bay Access Doors Installation**

(Figure 401)

A. General

- (1) This task gives the procedure to install the two access doors for the inboard or outboard wing dry bay tanks in the left or right wing.

B. References

Reference	Title
27-51-00-440-801	Trailing Edge Flap System Reactivation (P/B 201)
27-81-00-440-801	Leading Edge Flaps and Slats - Activation (P/B 201)

C. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
COM-659	Platform - Maintenance Lift, 3 ft Minimum Height, 12.5 ft Maximum Height Part #: 1135-8000 Supplier: 00994 Opt Part #: 8662-010 Supplier: 00994
COM-1550	Bonding Meter - Approved, Intrinsically Safe (Approved for use in Class I, Divisions I & II hazardous (classified) locations. Outside these hazardous locations, COM-614 can be used in lieu of COM-1550). Part #: 620LK Supplier: 1CRL2 Part #: M1 Supplier: 3AD17 Part #: M1B Supplier: 3AD17 Part #: T477W (C15292) Supplier: 06659
COM-2480	Platform - Mobile Elevating Work Platform SJ III Series Part #: SJIII 4726 Supplier: 3AF08 Part #: SJIII 4732 Supplier: 3AF08 Opt Part #: SJIII 4620 Supplier: 3AF08 Opt Part #: SJIII 4626 Supplier: 3AF08 Opt Part #: SJIII 4632 Supplier: 3AF08

D. Consumable Materials

Reference	Description	Specification
B00130	Alcohol - Isopropyl	TT-I-735
B00148	Solvent - Methyl Ethyl Ketone (MEK)	ASTM D740
B00634	Solvent - Stabilized Limonene Cleaner	BMS11-10 Type 1, 2, or 3
G00834	Cloth - Lint-free Cotton	
G50136	Compound - Corrosion Inhibiting, Non-drying Paste	BMS3-38

E. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Access door	57-21-23-01-100	SIA ALL
3	Access door	57-21-23-01-065	SIA ALL

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AMM Item	Description	AIPC Reference	AIPC Effectivity
4	Gasket	57-21-23-01-030	SIA ALL

F. Location Zones

Zone	Area
500	Left Wing
534	Left Wing - Dry Bay
600	Right Wing
634	Right Wing - Dry Bay

G. Access Panels

Number	Name/Location
534AB	Dry Bay Tank Access Door - Left Wing Station 727
534BB	Dry Bay Tank Access Door - Left Wing Station 748
634AB	Dry Bay Tank Access Door - Right Wing Station 727
634BB	Dry Bay Tank Access Door - Right Wing Station 748

H. Access Doors Installation

SUBTASK 57-31-23-160-001

- (1) Use a clean, lint-free cloth, G00834 that is moist with Limonene solvent, B00634, or solvent, B00148, or alcohol, B00130 to remove all grease, corrosion resistant compound, dirt and unwanted material.
 - (a) You must clean the surface around the wing panel access hole faying surface.
 - (b) You must clean the access door and the clamp ring faying surfaces.
 - (c) Clean the surfaces with a new, dry, clean cloth before the solvent is dry.
 - 1) Do not let the solvent become dry on the surfaces.

SUBTASK 57-31-23-942-001

- (2) Do a check of the tanks to make sure that you removed all unwanted materials, tools, and equipment.

SUBTASK 57-31-23-420-001

- (3) Close the outboard dry bay tank access door [3] for the dry bay tanks on the left or right wing:
 - (a) Close these access doors.

<u>Number</u>	<u>Name/Location</u>

534BB	Dry Bay Tank Access Door - Left Wing Station 748
634BB	Dry Bay Tank Access Door - Right Wing Station 748

- 1) Install the access door [3] in the wing access hole.
- 2) Install a new gasket [4] between the clamp ring [6] and the bottom surface of the wing skin.
- 3) Apply a thin layer of corrosion inhibiting material, G50136 to the surfaces of the clamp ring [6], gasket [4] and the fastener holes.
 - a) Apply a thin layer to the countersink.
 - b) Apply a thin layer to the counterbore.
- 4) Immediately install the 16 bolts [5] after you apply the corrosion inhibiting compound.

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- a) Tighten the bolts to 19 ± 1 in-lb (2 ± 0 N·m).

NOTE: Use the bolt torque pattern shown.

- (b) Measure the electrical resistance of the door to the adjacent wing skin with an intrinsically safe approved bonding meter, COM-1550.
- 1) The maximum resistance must not be more than 100 milliohms.
 - 2) If it is necessary, remove the paint from the lower skin countersinks to get the electrical resistance.

SUBTASK 57-31-23-420-002

- (4) Close the inboard dry bay tank access door [1] on the left or right wing.

- (a) Close these access doors.

Number	Name/Location
534AB	Dry Bay Tank Access Door - Left Wing Station 727
634AB	Dry Bay Tank Access Door - Right Wing Station 727

- (b) If it is necessary, remove the paint from fastener hole countersinks of a new panel to get the electrical continuity.
- (c) Apply a thin layer of corrosion inhibiting material, G50136 to the surfaces of the fastener holes for the access door [1].
- 1) Apply a thin layer to the countersink.
 - 2) Apply a thin layer to the counterbore.
- (d) Install the access door [1] in the wing access hole.
- (e) Install 16 bolts [2] to install this access door.
- 1) Tighten the bolts to 30 ± 1 in-lb (3 ± 1 N·m).
- NOTE: Use the bolt torque pattern shown.
- (f) Measure the electrical resistance of the door to the adjacent wing skin with a intrinsically safe approved bonding meter, COM-1550.
- 1) The maximum resistance must not be more than 100 milliohms.

SUBTASK 57-31-23-090-001

- (5) Remove the ladder, work platform, COM-2480 or maintenance platform, COM-659.

SUBTASK 57-31-23-440-001

- (6) Do this task: Trailing Edge Flap System Reactivation, TASK 27-51-00-440-801.

SUBTASK 57-31-23-440-002

- (7) Do this task: Leading Edge Flaps and Slats - Activation, TASK 27-81-00-440-801.

———— **END OF TASK** ————

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WING DRY BAY TANK VAPOR SEAL - INSPECTION/CHECK

1. General

- A. This task gives the procedure to do a check of the vapor seal of the wing dry bay tanks between wing rib 25 and 26.
- (1) There are two dry bay tanks that are outboard of the surge fuel tank which is a wet bay. The dry bay tanks are between the outboard wing rib 27, the middle rib 26 and the rib 25 of the surge fuel tank.
 - (2) Rib 25 is the outboard rib for the surge fuel tank. The seams between rib 25, the forward and aft spars, and the upper and lower skin panels are filled with sealant to prevent fuel leakage into the dry bay tank.
 - (3) Rib 26 is the common rib between the two dry bays. The seams between rib 26, the forward and aft spars, and the upper and lower skin panels are filled with sealant to prevent fuel leakage or fuel vapor movement from the inboard dry bay to the outboard dry bay tank.
 - (4) Because the anti-collision and position lights on the end of the wing are not explosion-proof, the vapor seal must be intact to separate a potential ignition source from any fuel vapor.

TASK 57-31-23-790-801

2. Vapor Seal Leak Check

(Figure 601)

A. General

- (1) This task gives the procedure to do a check of the vapor seal of the inboard dry bay tank between rib 25 and rib 26.
- (2) The check requires pressurization of the dry bay tank for 10 minutes with a minimum pressure loss.
- (3) It is difficult to find the vapor leaks on the outside surface of the wing; the tank can be pressurized and a bubble solution applied to the wing. The bubbles will show the external leak points.
- (4) The pressure test equipment must be able to supply positive pressure, 2.5 $\pm$ 0.6 psig (17.2 $\pm$ 4.2 kPa). The maximum pressure to the structure is 3.0 psig (20.7 kPa) positive pressure and 2.0 psig (13.8 kPa) vacuum. A safety device which limits internal pressure to 72 in/H₂O (2.6 psig) and -20 in/H₂O (-0.7 psig) is required.
 - (a) The water manometer, SPL-1774 does not have a mark for 72 in/H₂O (2.6 psig). It is recommended to put a temporary mark at the height of 31.25 inches 31.25 in. (79.38 cm) measured from the top of the cross tube. Then the manometer tube could be filled to that height to provide 2.6 psig (72.0 in/H₂O) safety relief manometer setting.
- (5) All plugs are installed from inside the dry bay tank (the pressure side) to prevent blowout of the plug.
- (6) The leading edge slats must be fully extended to install the block off plug in the forward spar.
- (7) To prevent damage to the wing, all repairs to the wing structure must be completed before the tank is pressurized.
- (8) Only pressurize one tank at a time. No two adjacent tanks can be pressurized at the same time when you do a check for leakage from one tank to the adjacent tank.
- (9) All areas where the sealant was changed by damage or rework must be tested again to make sure the seal is good.
- (10) All leak repairs must be tested again with this procedure.

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B. References

Reference	Title
20-40-11-910-801	Static Grounding (P/B 201)
24-22-00-860-802	Remove Electrical Power (P/B 201)
27-51-00-040-801	Trailing Edge Flap System Deactivation (P/B 201)
27-51-00-440-801	Trailing Edge Flap System Reactivation (P/B 201)
27-81-00-040-801	Leading Edge Flaps and Slats - Deactivation (P/B 201)
27-81-00-440-801	Leading Edge Flaps and Slats - Activation (P/B 201)
27-81-00-860-803	Leading Edge Flaps and Slats Extension (P/B 201)
27-81-00-860-804	Leading Edge Flaps and Slats Retraction (P/B 201)
57-31-23-000-801	Dry Bay Access Doors Removal (P/B 401)
57-31-23-390-801	Repair of Sealant Leaks in the Wing Dry Bay Tanks (P/B 801)
57-31-23-400-801	Dry Bay Access Doors Installation (P/B 401)
57-41-02-000-801	Leading Edge Access Panel Removal (P/B 201)
57-41-02-400-801	Leading Edge Access Panel Installation (P/B 201)
SRM 57-00-00	WINGS - GENERAL

C. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
COM-659	Platform - Maintenance Lift, 3 ft Minimum Height, 12.5 ft Maximum Height Part #: 1135-8000 Supplier: 00994 Opt Part #: 8662-010 Supplier: 00994
COM-2480	Platform - Mobile Elevating Work Platform SJ III Series Part #: SJIII 4726 Supplier: 3AF08 Part #: SJIII 4732 Supplier: 3AF08 Opt Part #: SJIII 4620 Supplier: 3AF08 Opt Part #: SJIII 4626 Supplier: 3AF08 Opt Part #: SJIII 4632 Supplier: 3AF08
SPL-1774	Manometer - Water, Test Equipment Part #: F72951-1 Supplier: 81205
SPL-6214	Console - Shop Air Supply Part #: J28010-154 Supplier: 81205 Opt Part #: J28010-135 Supplier: 81205 Opt Part #: J28010-139 Supplier: 81205 Opt Part #: J28010-26 Supplier: 81205
SPL-11086	Expand Vent Plug Assembly, C57003-2 (included in C57003 Test Equipment) Part #: C57003-49 Supplier: 81205 Opt Part #: C57003-1 Supplier: 81205
SPL-11088	Pressure Test Door Assembly - Airplanes With Production Winglets, C57003-3 (included in C57003 Test Equipment) Part #: C57003-49 Supplier: 81205 Opt Part #: C57003-1 Supplier: 81205

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Reference	Description
SPL-19125	Test Equipment - Wing Dry Bay Vapor Seal Part #: C57003-49 Supplier: 81205 Opt Part #: C57003-1 Supplier: 81205
STD-600	Mirror - Inspection
STD-1081	Flashlight - Explosion Proof
STD-1083	Source - Air, Regulated, Dry Filtered, 0-10 PSIG
STD-11392	Fire Extinguisher - 150lb Portable, Carbon Dioxide, Dry Chemical, Halon, or Aqueous Film Forming Foam (AFFF)
STD-13561	Stopper - Solid Rubber (Local Fabrication)

D. Consumable Materials

Reference	Description	Specification
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	AMS3819 Class 1 Grade A or B Form 1 (Supersede BMS15-5 CLA)
G00091	Compound - Oxygen System Leak Detection - Snoop Leak Detector	MIL-PRF-25567
G02061	Marker - Permanent, Felt Tip Pen	
G50135	Leak Detector - Liquid, Non-Corrosive Soap Compound	MIL-PRF-25567
G50219	Marking Pen	
G50256	Water, Regular	

E. Location Zones

Zone	Area
500	Left Wing
521	Left Wing - Leading Edge to Front Spar
534	Left Wing - Dry Bay
571	Left Wing - Fixed Trailing Edge
600	Right Wing
621	Right Wing - Leading Edge to Front Spar
634	Right Wing - Dry Bay
671	Right Wing - Fixed Trailing Edge

F. Access Panels

Number	Name/Location
521ZB	Lower Leading Edge Access Panel - Slat Station 479
534AB	Dry Bay Tank Access Door - Left Wing Station 727
534BB	Dry Bay Tank Access Door - Left Wing Station 748
571FB	Lower Outboard Fixed Trailing Edge Wedge Access Panel
621ZB	Lower Leading Edge Access Panel - Slat Station 479
634AB	Dry Bay Tank Access Door - Right Wing Station 727
634BB	Dry Bay Tank Access Door - Right Wing Station 748
671FB	Lower Outboard Fixed Trailing Edge, Wedge Access Panel

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G. Prepare for the Leak Check

SUBTASK 57-31-23-760-002

- (1) Make sure that the airplane is correctly grounded to an approved and identified ground.
 - (a) Do this task: Static Grounding, TASK 20-40-11-910-801.

SUBTASK 57-31-23-981-001

- (2) Do this task: Leading Edge Flaps and Slats Extension, TASK 27-81-00-860-803.
 - (a) Move the slats to the full extended position.

SUBTASK 57-31-23-040-003

- (3) Do this task: Trailing Edge Flap System Deactivation, TASK 27-51-00-040-801.

SUBTASK 57-31-23-040-004

- (4) Do this task: Leading Edge Flaps and Slats - Deactivation, TASK 27-81-00-040-801.

SUBTASK 57-31-23-490-003

- (5) Make sure that one of these portable fire extinguishers, STD-11392 is available:
 - (a) one - 150 pound dry chemical wheeled extinguisher.
 - (b) one - 150 pound CO2 wheeled extinguisher.
 - (c) one - 150 pound Halon wheeled extinguisher.

SUBTASK 57-31-23-862-002

- (6) Remove the electrical power from the airplane before you remove the tank access doors.
 - (a) Do this task: Remove Electrical Power, TASK 24-22-00-860-802.
 - (b) Do not supply electrical power again until you have completed this procedure.

SUBTASK 57-31-23-010-001

- (7) Remove the access door for the inboard, wing dry bay tank on the applicable wing (TASK 57-31-23-000-801).
 - (a) Open these access doors.

<u>Number</u>	<u>Name/Location</u>
534AB	Dry Bay Tank Access Door - Left Wing Station 727
634AB	Dry Bay Tank Access Door - Right Wing Station 727

SUBTASK 57-31-23-490-004

- (8) Install the pressure test equipment, SPL-19125 (Figure 601).
 - (a) Install the drain plug (plug assembly, C57003-2, SPL-11086) into the drain hole in the lower skin panel at the inboard, forward corner of the dry bay tank.
 - 1) Install the plug from the inside of the tank.
 - 2) If necessary, use a tapered stopper (solid rubber stopper, STD-13561). The drain hole in the lower skin panel is 0.375 in. (9.525 mm) diameter.
 - (b) Install the block off plug assembly, C57003-2, SPL-11086, from the inside of the tank.
 - 1) Put the plug into position in the slat track hole in the forward spar.
 - 2) Turn the handle to tighten the press plate.

NOTE: When the press plate is tightened, the press plate will compress the plug. This will cause a clamp force between the plug and the slat track hole in the forward spar.
 - (c) Install the pressure test door assembly, C57003-3, SPL-11088.
 - 1) Put the pressure test door into position in the hole for the access door.

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- 2) Turn the T-handle (above the cross-handle) to turn the clamp plate 90 degrees on the pressure test door.
NOTE: The clamp plate turned 90 degrees will hold the pressure test door in position.
- 3) Turn the cross-handle to tighten the pressure test door against the outside surface of the lower skin panel.
- 4) Make sure that the pressure test door has a good seal over the hole for the tank access door.
- (d) Connect the air supply hose from the pressure test equipment to the pressure test door connector.
 - 1) The pressure test equipment must be able to supply positive pressure in the range of 2.0 psig (13.8 kPa) to 3.0 psig (20.7 kPa) with a the variation of not more than ± 0.1 psig (± 0.7 kPa).
NOTE: The test uses a pressure of 2.2 psig (15.2 kPa) - 2.4 psig (16.5 kPa).
 - 2) The maximum pressure to the structure is 3.0 psig (20.7 kPa) positive pressure and 2.0 psig (13.8 kPa) vacuum.
 - 3) A safety device which limits internal pressure to 72 in/H₂O (2.6 psig) or 72 in/H₂O (17.9 kPa) and -20 in/H₂O (-0.72 psig) or -20 in/H₂O (-5.0 kPa) is required.
- (e) Connect the long hose from the water manometer, SPL-1774, to the 2.0 in. (50.8 mm) diameter adapter on the pressure test door (Figure 602).
- (f) Connect a 0-10 psig dry filtered regulated air source, STD-1083, or shop air supply console, SPL-6214, to the pressure test equipment.

H. Pressure Check

SUBTASK 57-31-23-790-001

- (1) Do the pressure check.

NOTE: This task is extremely sensitive to the surrounding temperature changes.

- (a) Avoid any unnecessary activities that might cause a change in temperature.
- (b) Supply 2.2 psig (15.2 kPa) - 2.4 psig (16.5 kPa) air pressure to test equipment.
- (c) Open the shut off valve on the pressure test door.

NOTE: The dry bay tank is now pressurized.

- (d) Wait 2 minutes minimum for the pressure in the tank to become stable before you start the check.
- (e) Close the shut off valve on the pressure test door.
- (f) Record the start time of the check and the inches of water at the beginning of the check.
- (g) Wait 10 minutes.

NOTE: The tank must hold the pressure for this time.

- (h) After 10 minutes, make a record of the inches of water on the manometer.
- (i) Calculate the pressure drop.
 - 1) Subtract the value for the inches of water at the start of the check from the inches of water at the end of the check.
 - 2) If the pressure drop is less than 0.11 in/H₂O (0.004 psig) or 0.11 in/H₂O (0.03 kPa), the vapor seal is good.
 - a) Decrease the pressure in the tank to zero.

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- b) Put the airplane back to the usual condition.
- 3) If the pressure drop is more than 0.11 in/H₂O (0.004 psig) or 0.11 in/H₂O (0.03 kPa), there is vapor movement through the vapor seal.
 - a) Examine the pressure test door for leakage.
 - <1> Apply a non-corrosive soap solution, leak detector, G50135, or Snoop Leak Detector compound, G00091, to the pressure test door.
 - <2> If you find leakage, decrease the pressure in the tank to zero.
 - <a> Repair the leak.
 - Do the Pressure Check Procedure again.
 - <3> If you find no leakage, continue to the next step.
 - b) Decrease the pressure in the tank to zero.
 - c) Continue with the procedure to find the location of the vapor leak.

I. Vapor Leak Location Check

SUBTASK 57-31-23-010-002

- (1) Open the applicable lower leading edge access panel on the left or right wing (TASK 57-41-02-000-801).
 - (a) Open these access panels:

<u>Number</u>	<u>Name/Location</u>
521ZB	Lower Leading Edge Access Panel - Slat Station 479
621ZB	Lower Leading Edge Access Panel - Slat Station 479

SUBTASK 57-31-23-010-003

- (2) Open the applicable lower trailing edge access panel on the left or right wing.
 - (a) Open these access panels:

<u>Number</u>	<u>Name/Location</u>
571FB	Lower Outboard Fixed Trailing Edge Wedge Access Panel
671FB	Lower Outboard Fixed Trailing Edge, Wedge Access Panel

SUBTASK 57-31-23-010-004

- (3) Open the access door for the outboard, dry bay tank on the applicable wing (TASK 57-31-23-000-801).
 - (a) Open these access doors:

<u>Number</u>	<u>Name/Location</u>
534BB	Dry Bay Tank Access Door - Left Wing Station 748
634BB	Dry Bay Tank Access Door - Right Wing Station 748

SUBTASK 57-31-23-790-002

- (4) Find the vapor leak in the dry bay tank.
 - (a) Apply a non-corrosive soap solution, leak detector, G50135, or Snoop Leak Detector compound, G00091, to all the seal areas on the outside of the dry bay tank.

NOTE: All seal areas on the outside of the dry bay tank includes the forward spar, the aft spar and the outboard side of rib 26.
 - (b) Supply 2.2 psig (15.2 kPa) - 2.4 psig (16.5 kPa) air pressure to test equipment.
 - (c) Open the shut off valve on the pressure test door.

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- (d) Monitor these areas for air bubbles.

NOTE: The size of the leak can cause the bubbles to form very slowly.

- 1) Constantly monitor the seals to find the leak.
- (e) Make a mark at the locations where you see bubbles with a marking pen, G50219, marker, G02061, or equivalent.
- (f) Close the shut off valve on the pressure test door.
- (g) Decrease the pressure in the wing tank to zero.

SUBTASK 57-31-23-080-001

- (5) Remove the pressure test equipment.
 - (a) Disconnect the hose from the water manometer, SPL-1774, from the adapter on the pressure test door.
 - (b) Disconnect the 0-10 psig dry filtered regulated air source, STD-1083, or shop air supply console, SPL-6214, from the pressure test equipment.
 - (c) Disconnect the air supply hose from the pressure test door.
 - (d) Remove the pressure test door.
 - 1) Turn the cross-handle to remove the clamp force from the clamp plate.
 - 2) Turn the T-handle to turn the clamp plate 90 degrees on the pressure test door.
 - 3) Remove the pressure test door from the hole for the access door.
 - (e) Remove the block off plug from the inside of the tank.
 - 1) Turn the handle to loosen the press plate which will remove the clamp force from the plug.
 - (f) Remove the drain plug on the lower skin panel, from the inside of the tank.

SUBTASK 57-31-23-211-001

- (6) Visually examine the area for damage.
 - (a) Examine the area you think contains a leak for seal defects such as cracked or loose fillets, pinholes, or loose fasteners.
 - 1) Use an explosion proof flashlight, STD-1081, when you look inside the dry bay tank.
 - 2) If it is necessary, use an inspection mirror, STD-600, to examine seals which are difficult to see.
 - (b) Do a check of the fillet seals that you think have a bad bond.
 - (c) Look at the tank structure for cracks or distortion.
 - (d) If you find tank damage, cracks, distortion or loose fasteners, refer to the structural repair manual (SRM SUBJECT 57-00-00).

SUBTASK 57-31-23-360-001

- (7) Repair or replace the sealant if necessary.
 - (a) Do this task: Repair of Sealant Leaks in the Wing Dry Bay Tanks, TASK 57-31-23-390-801.

J. Put the Airplane Back to Its Usual Condition

SUBTASK 57-31-23-080-002

- (1) Make sure that the drain holes are free from unwanted material or objects.

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SUBTASK 57-31-23-090-002

- (2) Do an check of the tanks to make sure you removed all unwanted materials, tools and equipment.

SUBTASK 57-31-23-160-002

- (3) Use water, G50256, and a moist, clean cotton wiper, G00034, to remove the bubble solution from the external surface of the fuel tank.

SUBTASK 57-31-23-410-001

- (4) Close these access doors and panels on the left or right wing, if opened to find the vapor leak (TASK 57-31-23-400-801).

- (a) Close these access doors:

<u>Number</u>	<u>Name/Location</u>
534BB	Dry Bay Tank Access Door - Left Wing Station 748
634BB	Dry Bay Tank Access Door - Right Wing Station 748

SUBTASK 57-31-23-410-002

- (5) Close the applicable lower leading edge access panel on the left or right wing (TASK 57-41-02-400-801).

- (a) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
521ZB	Lower Leading Edge Access Panel - Slat Station 479
621ZB	Lower Leading Edge Access Panel - Slat Station 479

SUBTASK 57-31-23-410-005

- (6) Close the applicable lower trailing edge access panel on the left or right wing.

- (a) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
571FB	Lower Outboard Fixed Trailing Edge Wedge Access Panel
671FB	Lower Outboard Fixed Trailing Edge, Wedge Access Panel

SUBTASK 57-31-23-410-003

- (7) Close the access door for the inboard, dry bay tank on the left or right wing (TASK 57-31-23-400-801).

- (a) Close these access doors.

<u>Number</u>	<u>Name/Location</u>
534AB	Dry Bay Tank Access Door - Left Wing Station 727
634AB	Dry Bay Tank Access Door - Right Wing Station 727

SUBTASK 57-31-23-360-002

- (8) Remove the work platform, COM-2480, or maintenance platform, COM-659.

SUBTASK 57-31-23-440-003

- (9) Do this task: Trailing Edge Flap System Reactivation, TASK 27-51-00-440-801.

SUBTASK 57-31-23-440-004

- (10) Do this task: Leading Edge Flaps and Slats - Activation, TASK 27-81-00-440-801.

SUBTASK 57-31-23-981-002

- (11) Do this task: Leading Edge Flaps and Slats Retraction, TASK 27-81-00-860-804.

————— **END OF TASK** —————

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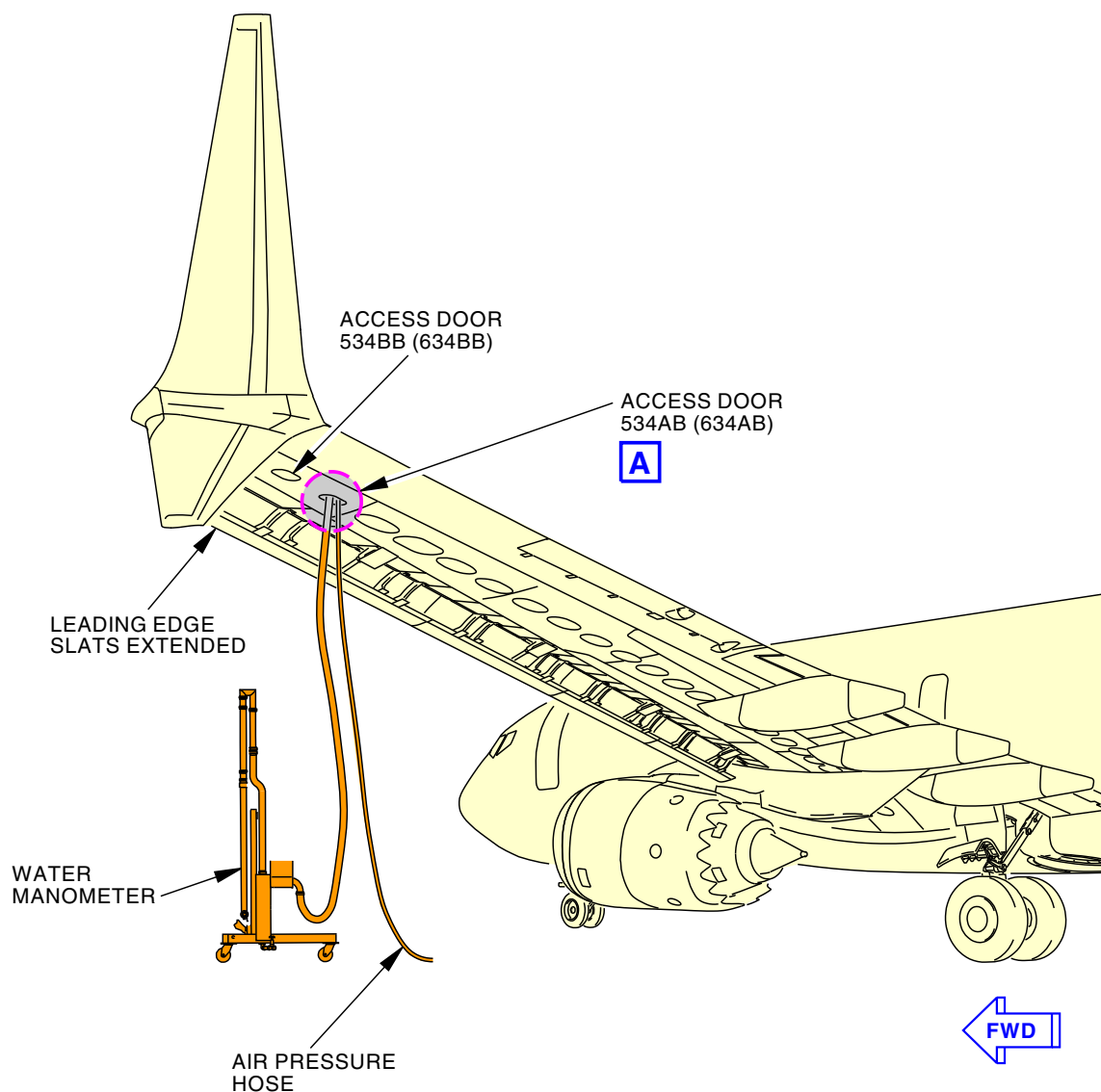
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Dry Bay Tank Pressure Check
Figure 601/57-31-23-990-802 (Sheet 1 of 2)

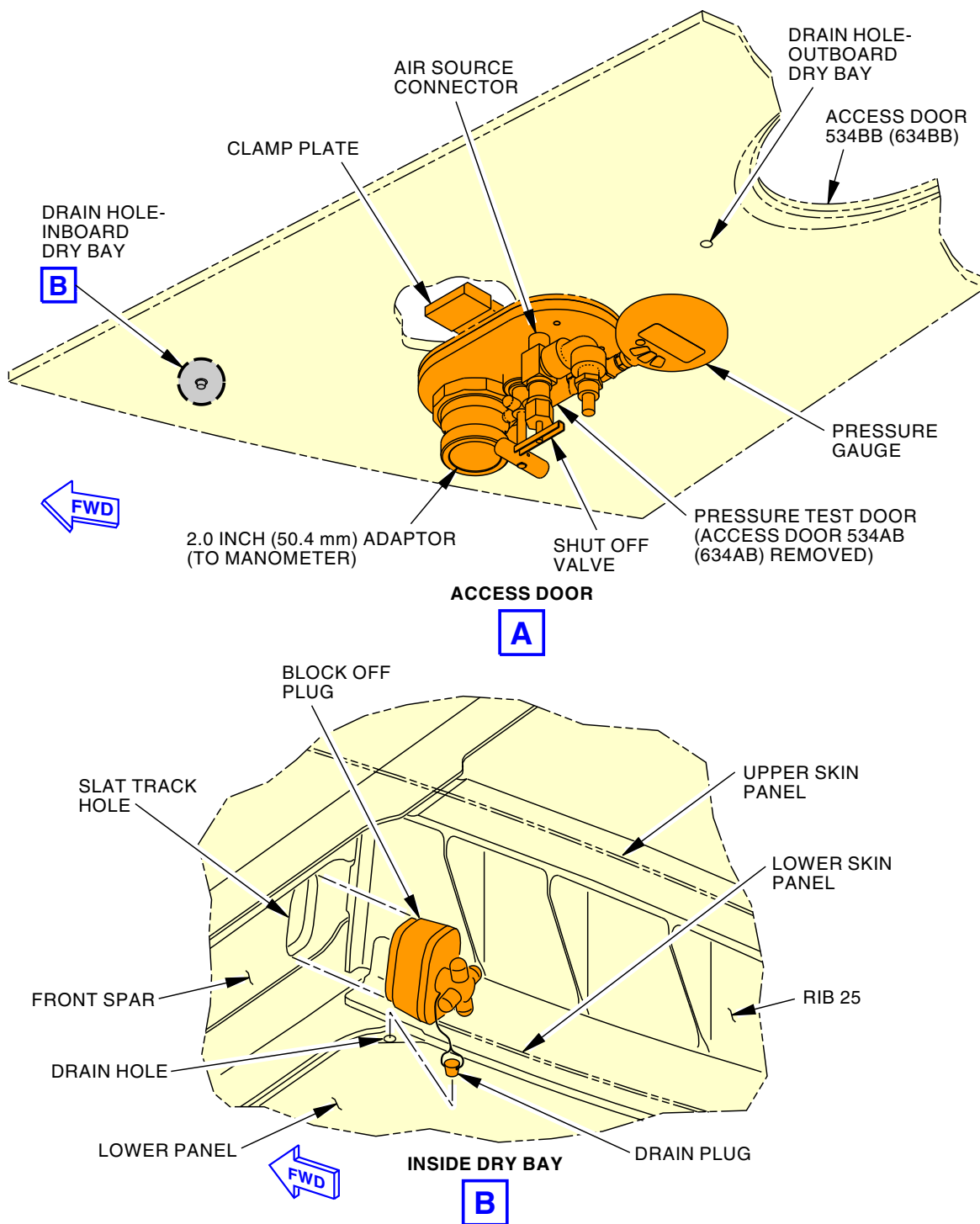
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Dry Bay Tank Pressure Check
Figure 601/57-31-23-990-802 (Sheet 2 of 2)

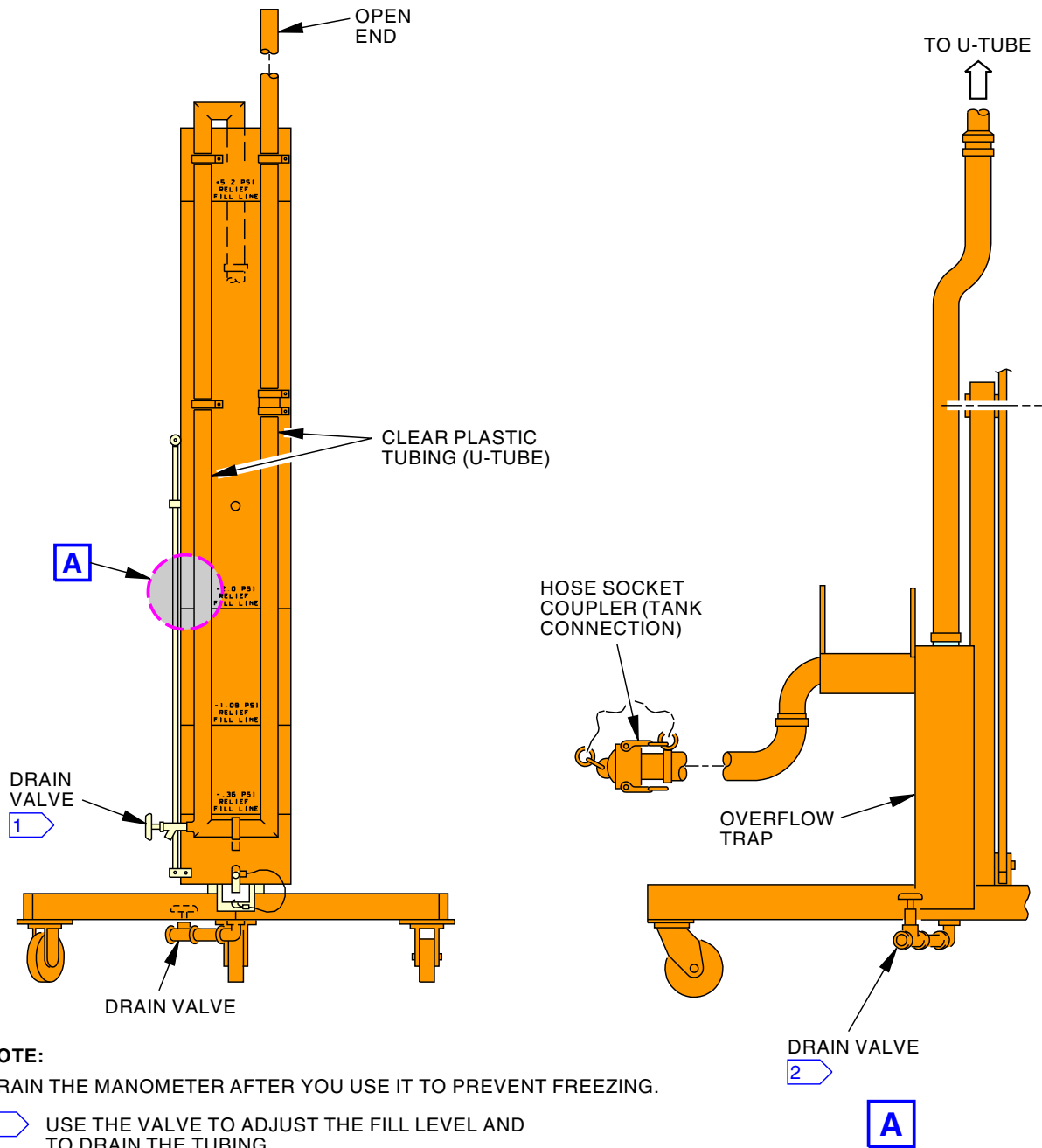
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Water Manometer Assembly
Figure 602/57-31-23-990-803

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WING DRY BAY TANK VAPOR SEAL - REPAIR

1. General

- A. This procedure has this task:
- (1) A task to repair the sealant in the wing dry bay tanks.
- B. A related task is to repair the sealant at the wing leading edge seal ribs.
- C. It is necessary to use materials that are poisonous and flammable when you repair the sealant. You must have a good flow of air in the area. You must obey all fire safety precautions.
- D. Before you repair a leak, make an analysis of the source and cause of the leak with the Vapor Seal Leak Check procedure.
- E. If the cause of the leak is a result of structural damage, do the structural repair. Refer to the Structural Repair Manual before you apply sealant.

TASK 57-31-23-390-801

2. Repair of Sealant Leaks in the Wing Dry Bay Tanks

(Figure 801)

A. General

- (1) This task gives the procedure to apply sealant to the vapor leaks of the dry bay tank between rib 25 and rib 26, and rib 27 and rib 26.

B. References

Reference	Title
28-11-00-300-803	Repair of Sealant Leaks in the Fuel Tank Structure (P/B 801)
28-11-00-600-801	Apply the Corrosion Resistant Finish (Topcoat) (P/B 701)
51-22-00-390-804	Injection Seal Application (P/B 201)
51-22-00-390-806	Fillet Seal Application (P/B 201)
51-22-00-390-808	Fastener Seal Application (P/B 201)
57-31-23-000-801	Dry Bay Access Doors Removal (P/B 401)
57-31-23-400-801	Dry Bay Access Doors Installation (P/B 401)
57-31-23-790-801	Vapor Seal Leak Check (P/B 601)

C. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-768	Sealant Removal Tool, Non-Metallic Part #: ST982L-9 Supplier: 81205 Part #: ST982LF-9 Supplier: 81205 Part #: ST982LH-A-1 Supplier: 81205
STD-185	Cleaners - Pipe
STD-449	Gun - Sealant
STD-600	Mirror - Inspection
STD-1081	Flashlight - Explosion Proof
STD-1280	Source - Air, Regulated, Dry Filtered, 0-30 PSIG

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D. Consumable Materials

Reference	Description	Specification
A02315	Sealant - Low Density, Synthetic Rubber. 2 Part	BMS5-142 Type II
B00062	Solvent - Acetone (99.5% Grade)	ASTM D 329 (Supersedes O-A-51)
B00083	Solvent - VM&P Naphthas	TT-N-95 Type II, ASTM D-3735 Type III
B00130	Alcohol - Isopropyl	TT-I-735
B00148	Solvent - Methyl Ethyl Ketone (MEK)	ASTM D740
B00184	Solvent - Presealing, Cleaning Solvent	BMS11-7
C00012	Coating - Akzo Nobel Clear Polyurethane Topcoat, 683-3-2 Base with X-310A Catalyst (Akzo Nobel Aerospace Coatings)	
C00064	Coating - Aluminum Chemical Conversion	BAC5719 Type II Class A (MIL-DTL-5541 Class 1A)
C50238	Coating - Akzo Nobel Clear Polyurethane Topcoat, 683-3-20 Base with X-310A Catalyst (Akzo Nobel Aerospace Coatings)	
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	AMS3819 Class 1 Grade A or B Form 1 (Supersede BMS15-5 CLA)
G00268	Brush - Soft Bristle, Paint	
G00834	Cloth - Lint-free Cotton	
G01061	Water - Distilled	
G50222	Brush - Tampico Fiber, Non-Metallic	

E. Location Zones

Zone	Area
500	Left Wing
521	Left Wing - Leading Edge to Front Spar
534	Left Wing - Dry Bay
571	Left Wing - Fixed Trailing Edge
600	Right Wing
621	Right Wing - Leading Edge to Front Spar
634	Right Wing - Dry Bay
671	Right Wing - Fixed Trailing Edge

F. Prepare for the Repair

SUBTASK 57-31-23-010-005

(1) Do this task: Dry Bay Access Doors Removal, TASK 57-31-23-000-801.

SUBTASK 57-31-23-212-001

(2) Examine the area you think contains a leak (TASK 57-31-23-790-801).

- (a) Look for seal defects such as cracked or loose fillets, pinholes or loose fasteners.
- (b) Use an explosion proof flashlight, STD-1081 when you look into the dry bay tank.

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- (c) If necessary, use an inspection mirror, STD-600 to examine seals which you cannot easily see.
- (d) You can increase the seal plane to isolate a bad seal.
NOTE: Because you add a large quantity of sealant when you increase the seal plane above the initial seal plane, it is better to replace the bad seal.
 - 1) Examine the structure around the bad seal to find where to increase the seal plane.
 - 2) Apply a new fillet seal around the structure with the applicable seals and fasteners to increase the seal plane.
- (e) You can remove the sealant to replace the bad seal.

SUBTASK 57-31-23-360-003

- (3) Use the sealant removal tool, SPL-768 to remove the bad sealant in the fillet seal.
 - (a) Cut the ends of the bad sealant at a slope such that the new sealant makes an overlap with the remaining sealant.
 - 1) Make sure that you cut the sealant smoothly.
 - (b) If the fillet seal bond is good, it is not necessary to cut the sealant to the metal.
 - 1) Make sure that you remove all sealant that is loose.
 - (c) If the bad sealant includes fasteners with fillet seals, do the steps that follow:
 - 1) Cut around the bottom of the fastener with a sealant cutting tool.
 - 2) Use pliers to pull the sealant from the fastener.
 - a) It is not necessary to remove small quantities of the sealant that bond to the fastener.
 - (d) If the fillet seal is to be applied to cured structural adhesives, remove all adhesive material that has not adhered to the metal or primed surface.
 - 1) Scrape the adhesive with an abrasive-free hardwood or plastic tool to remove the loose adhesive.
 - a) It is not necessary to remove adhesive that remains bonded to the metal or primed surface after you scrape the loose adhesive.

SUBTASK 57-31-23-360-004

- (4) If there is a bad injection or prepack seal at rib 25, refer to TASK 28-11-00-300-803 to repair the seal for the surge fuel tank.

SUBTASK 57-31-23-360-005

- (5) If there is a bad injection seal at rib 26 and rib 27 and the upper and lower skin panels, do the steps that follow:
 - (a) Remove all loose sealant.
NOTE: You can repair bad injection seals if you raise the new seal plane above the old seal plane. When the hole for the injection seal is covered with a fillet seal, it is not necessary to inject sealant in the entire depth of the channel.
 - 1) It is not necessary to remove the sealant inside short injection channels that have a good sealant bond.
 - (b) If the injection channel does not have any sealant for the length of the channel, do these steps:
 - 1) Remove the any loose sealant with pipe cleaners, STD-185 and small sealant removal tool, SPL-768.

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- a) Be careful not to cause damage to the tank structure.



DO NOT GET SOLVENTS IN YOUR MOUTH, YOUR EYES, OR ON YOUR SKIN. DO NOT BREATHE THE FUMES FROM SOLVENTS. SOLVENTS ARE DANGEROUS MATERIALS. SOLVENTS CAN BE FLAMMABLE OR CAUSE DAMAGE TO THE ENVIRONMENT. REFER TO THE MATERIAL SAFETY DATA SHEETS (MSDS) AND THE LOCAL SAFETY PRECAUTIONS.

- 2) For channels that are too small for pipe cleaners, apply solvent, B00184 or solvent, B00148 to the channel with a brush.
- 3) Clean the channel of unwanted sealant debris or make the channel dry to evaporate the solvent with a clean, oil-free, 0-30 psig dry filtered regulated air source, STD-1280.
- 4) Continue the procedure to do an injection seal at one end of the channel.

SUBTASK 57-31-23-160-003

- (6) For tank surfaces covered with corrosion inhibiting compound, G00009, clean the tank surface around the repair area as follows:
- (a) Wipe off excess corrosion inhibiting compound, G00009 with a clean, lint-free cloth, G00834.
 - (b) Clean the area approximately 1.0 in. (25.4 mm) larger than the area to be sealed to prevent contamination from the corrosion inhibiting compound, G00009.
 - 1) Make the surface clean with a new, clean cotton wiper, G00034 moist with solvent, B00062 or solvent, B00184.
 - 2) Wipe the surface with a new, clean, dry cloth to remove excess solvent.
 - a) Do not let the solvent become dry on the surface.
 - 3) Replace the cloth when the cloth becomes dirty.
 - 4) Continue to clean and dry the surfaces until the clean, dry cloth remains clean.
 - 5) Do not touch the cleaned area with your fingers or allow the surface to become contaminated.

SUBTASK 57-31-23-160-004

- (7) If there is topcoat on the surface of the sealant, remove all the topcoat from the sealant repair area.
- (a) Use abrasive paper and remove the used topcoat until the sealant is shown and is in good condition.
 - (b) Use clean, cotton wiper, G00034 soaked with solvent, B00083 or solvent, B00184 to clean all surfaces and sealant from which you removed the topcoat.
 - (c) Wipe the surface with a clean, dry cloth to remove excess solvent.
 - 1) Do not let the solvent become dry on the surface.
 - (d) Continue to clean and dry the surfaces until the clean, dry cloth remains clean.
 - (e) Do not touch the cleaned area with your fingers or allow the surface to become contaminated.

SUBTASK 57-31-23-350-001

- (8) If the alodine metal surface treatment is worn or damaged, you must apply an alodine coating, C00064, to the metal surface before you apply the new sealant or finish material.

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- (a) Apply alodine to the surfaces that are worn, damaged or where the metal is shown (TASK 28-11-00-600-801).

SUBTASK 57-31-23-160-005

- (9) Immediately before you apply the sealant, clean the surface with a clean cotton wiper, G00034 moist with solvent, B00083 or solvent, B00184.

NOTE: Do not use an aqueous cleaner to clean the repair area. Use of this kind of material requires a flush and rinse with water. The dry bay tanks are a small enclosed structure where water can collect and become entrapped.

- (a) Wipe the surface with a clean dry cloth to remove excess solvent.
 - 1) Do not let the solvent become dry on the surface.
- (b) Do not touch the cleaned area with your fingers or allow the surface to become contaminated.

G. Wing Dry Bay Tank Repair - Injection Seals

SUBTASK 57-31-23-390-001

- (1) To apply a new injection seal of sealant, A02315, do the steps that follow (TASK 51-22-00-390-804):
 - (a) Examine the seal area to make sure that you have the correct selection of tools for the job.
 - 1) Use an explosion proof flashlight, STD-1081 when you look inside the dry bay tank.
 - 2) If it is necessary, use an inspection mirror, STD-600 to examine seals which are difficult to see.
 - (b) Apply the injection seal of sealant, A02315 with the sealant gun, STD-449.

H. Wing Dry Bay Tank Repair - Fillet Seals

SUBTASK 57-31-23-390-002

- (1) To apply a new fillet seal of sealant, A02315, do the steps that follow (TASK 51-22-00-390-806):
 - (a) Examine the seal area to make sure that you have the correct selection of tools for the job.
 - 1) Use an explosion proof flashlight, STD-1081 when you look inside the dry bay tank.
 - 2) If it is necessary, use an inspection mirror, STD-600 to examine seals which are difficult to see.
 - (b) Apply a small fillet seal of sealant with the sealant gun, STD-449.
 - (c) Use a sealant fairing tool and push the fillet seals tightly into position.
 - 1) Make sure that all sealant fairing tools are clean.
 - a) Use a clean cotton wiper, G00034.
 - b) Use a solution of alcohol, B00130 and distilled water, G01061, mixed to a ratio of 1:5 or 1:6 by volume to wet the tool surface to prevent sticking of the sealant to the fairing tools.
 - (d) If the first fillet seal is hard, but is not clean, then it must be cleaned before you apply the second fillet seal.
 - (e) Apply sealant a second time to make a full bodied fillet seal.
 - 1) If you do not use an extruded nozzle, use a sealant fairing tool to make a full bodied fillet seal.

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- 2) Remove all air bubbles and re-entrant fillet seal edges.
- (f) Apply a corrosion resistant finish (topcoat).

I. Fastener Sealant Application

SUBTASK 57-31-23-390-003

- (1) Repair of the fastener fillet seals (TASK 51-22-00-390-808).
 - (a) Apply sealant, A02315 to the fastener and the area 0.50 in. (12.70 mm) in width in all directions from the fastener.
 - 1) Use a stiff bristled tampico fiber brush, G50222 to apply the sealant on the surfaces and into crevices.
 - (b) Let the sealant become dry until it is not tacky.
 - (c) Use a sealing gun or spatula and apply sealant, A02315 around and on the fastener.
 - (d) Move the sealant with a sealant fairing tool until you get the dimensions shown for the fillet seal.
 - (e) Examine the sealant for holes, bubbles, or spaces.
 - 1) If there are holes, bubbles or spaces, do the procedure again.

J. Apply a Corrosion Resistant Finish (Topcoat)

SUBTASK 57-31-23-390-004

- (1) Apply a corrosion resistant finish (topcoat) to all exposed sealant.

NOTE: The new sealant must become dry and tack free before the corrosion resistant finish (topcoat) can be applied.

 - (a) Prepare a two-part Akzo Nobel 683-3-2 coating, C00012 or Akzo Nobel 683-3-20 coating, C50238 for a topcoat per manufacturer's instructions.
 - (b) Use clean, cotton wiper, G00034 soaked with solvent, B00184 or solvent, B00148 to clean all surfaces and sealant.
 - 1) Wipe the surface with a clean, dry cloth to remove excess solvent.
 - a) Do not let the solvent become dry on the surface.
 - 2) Continue to clean and dry the surfaces until the clean, dry cloth remains clean.
 - 3) Do not touch the cleaned area with your fingers or allow the surface to become dirty.
 - (c) Apply the finish coating with a brush, G00268.

SUBTASK 57-31-23-390-005

- (2) Apply corrosion inhibiting compound, G00009 to the area of repair of the dry bay tank.

K. Put the Airplane Back to Its Usual Condition

SUBTASK 57-31-23-410-004

- (1) Do this task: Dry Bay Access Doors Installation, TASK 57-31-23-400-801.

———— **END OF TASK** ————

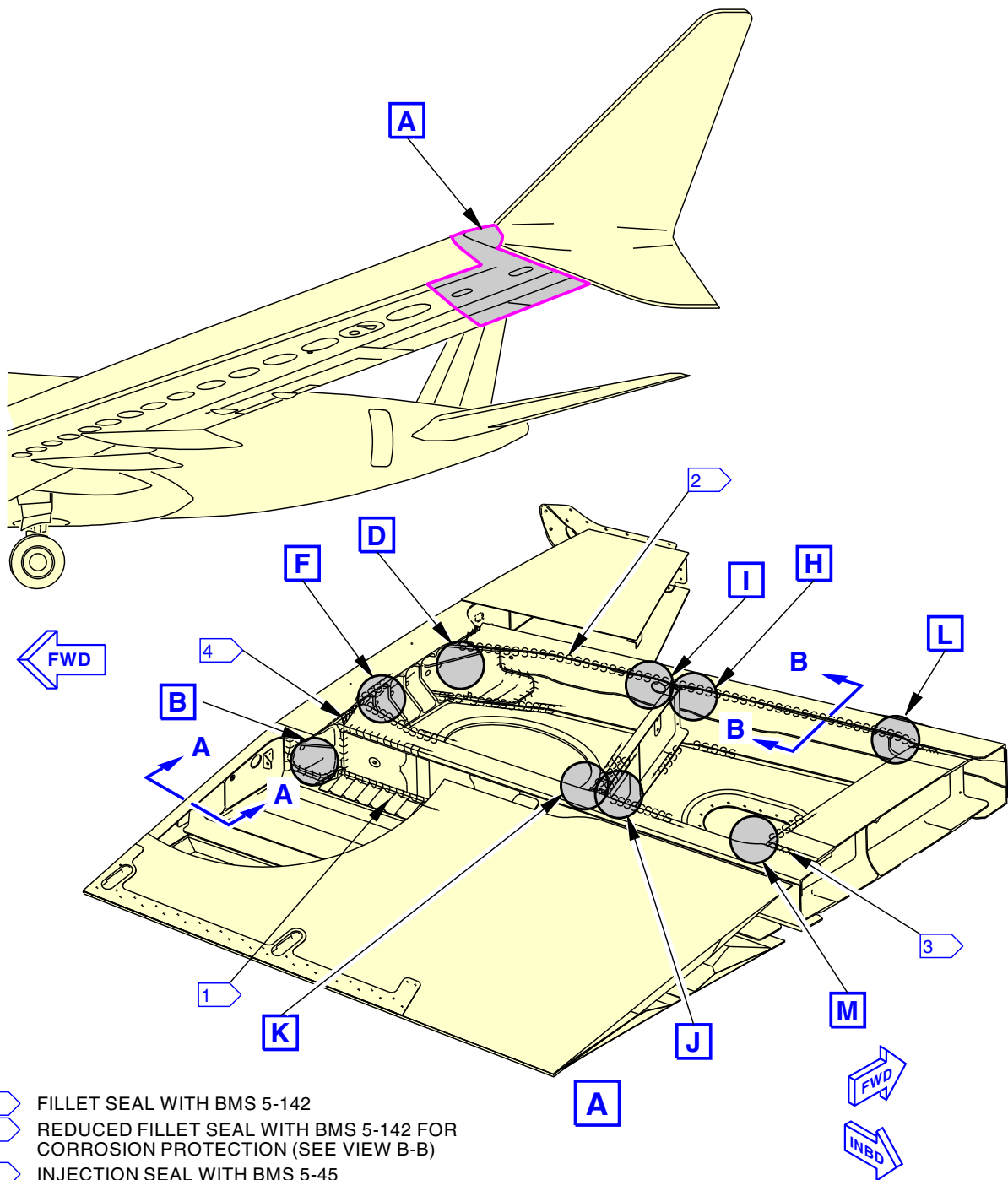
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- 1 FILLET SEAL WITH BMS 5-142
- 2 REDUCED FILLET SEAL WITH BMS 5-142 FOR CORROSION PROTECTION (SEE VIEW B-B)
- 3 INJECTION SEAL WITH BMS 5-45
- 4 INJECTION SEAL WITH BMS 5-142
- 5 DRAINAGE PATH. KEEP GAP OPEN.

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Dry Bay Tank Seals
Figure 801/57-31-23-990-804 (Sheet 1 of 5)

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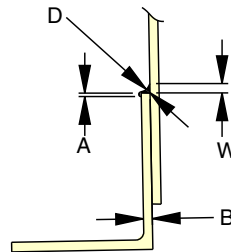
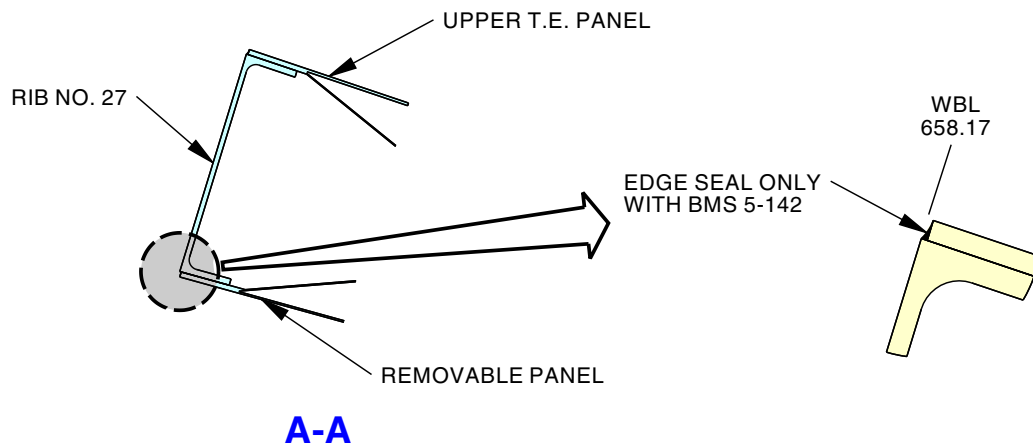
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REDUCED DIMENSION FILLETS FOR FUEL CONTAINMENT

B-B

LEGEND:

D = .06 INCH (1.52 mm) MIN
W = .06 INCH (1.52 mm) - .25 IN (6.35 mm)
A+B = W EXCEPT
A = 0 WHEN B = .06 INCH (1.52 mm) OR MORE

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Dry Bay Tank Seals
Figure 801/57-31-23-990-804 (Sheet 2 of 5)

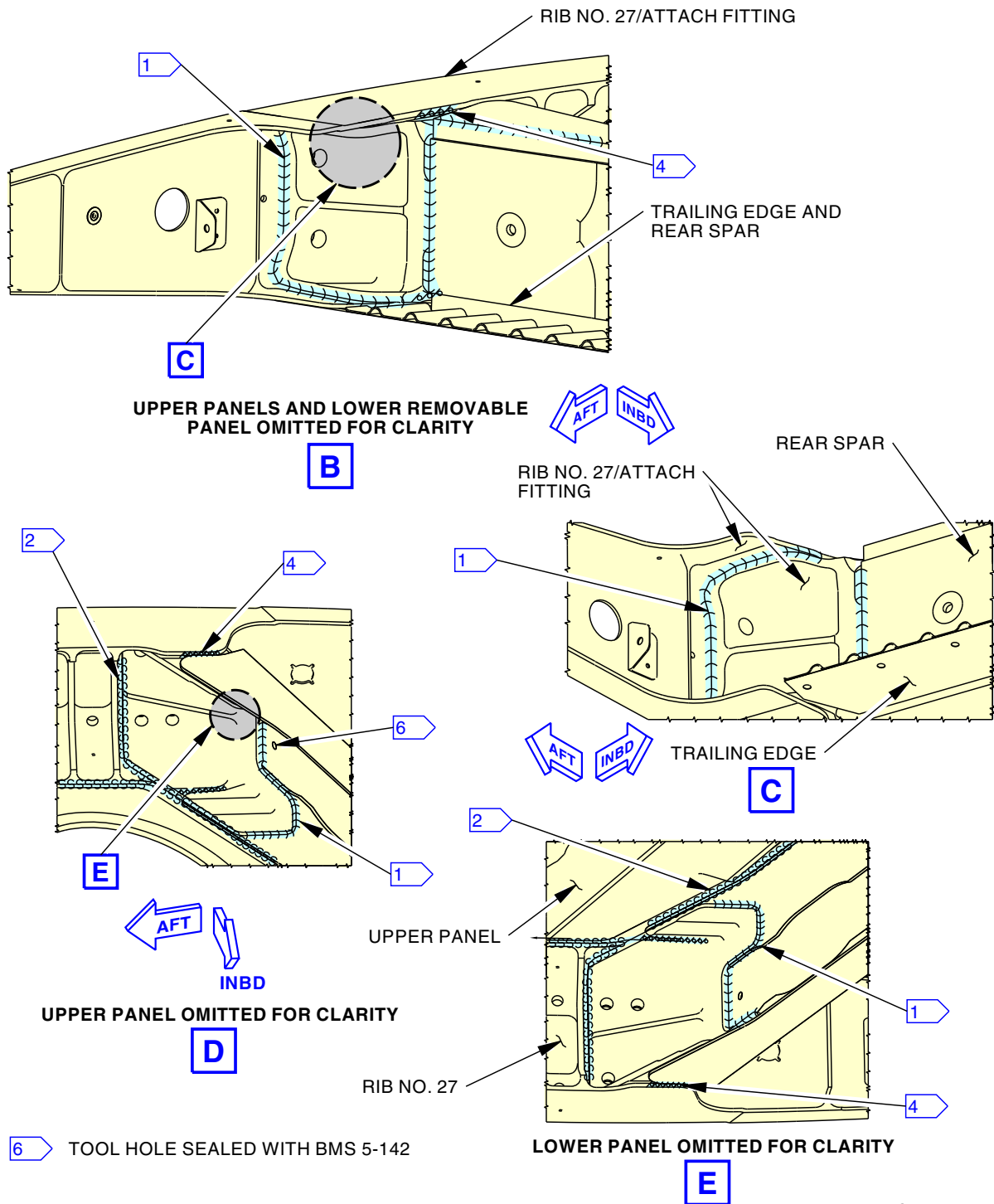
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Dry Bay Tank Seals
Figure 801/57-31-23-990-804 (Sheet 3 of 5)

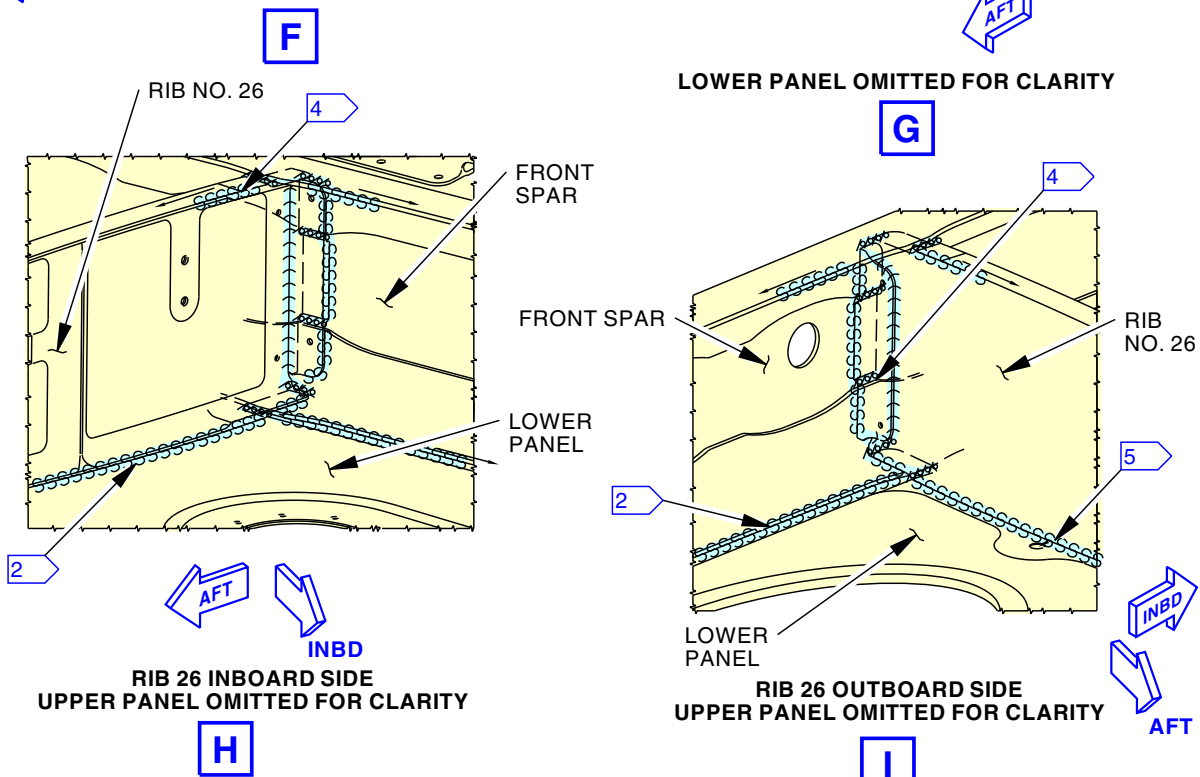
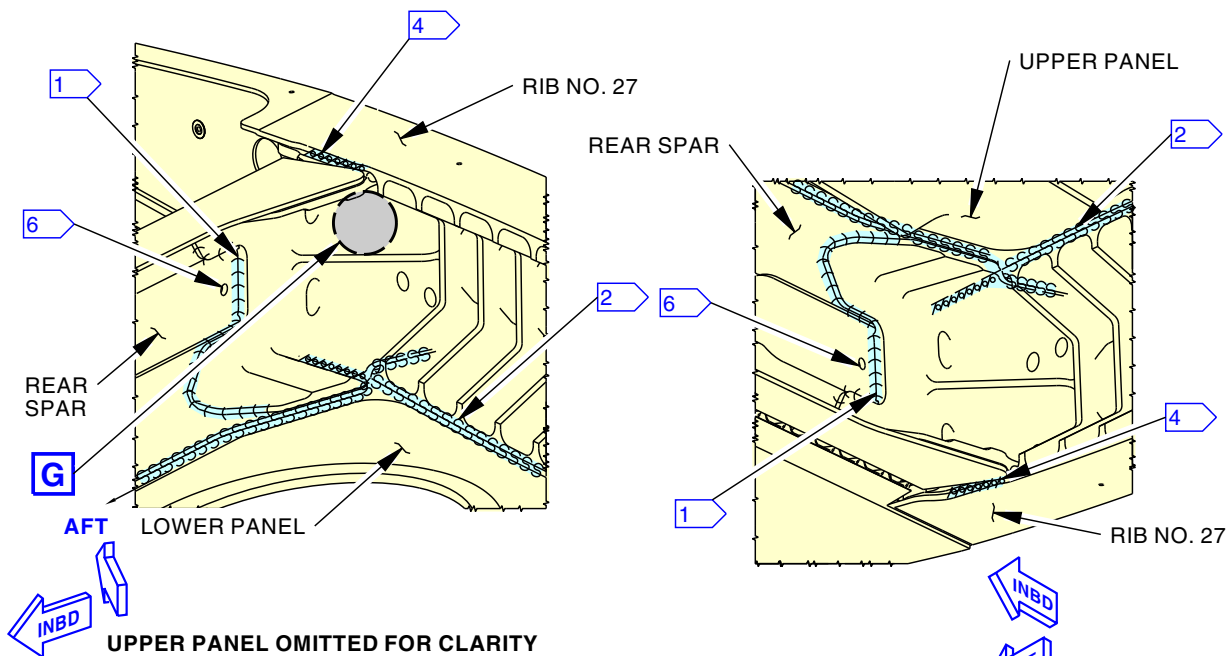
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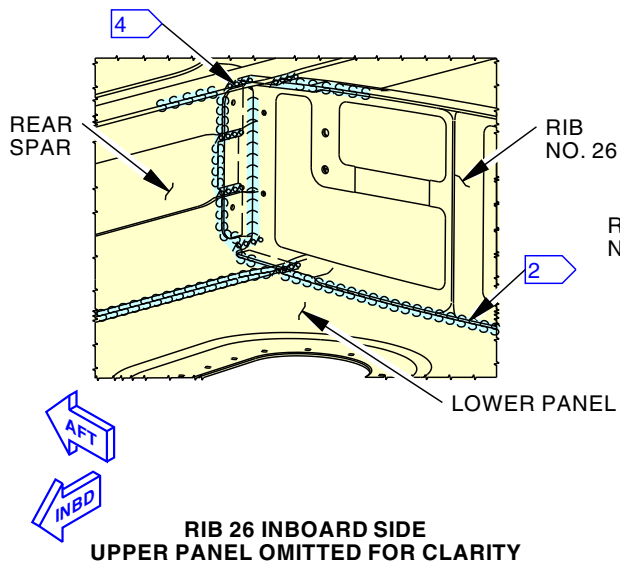
Dry Bay Tank Seals
Figure 801/57-31-23-990-804 (Sheet 4 of 5)

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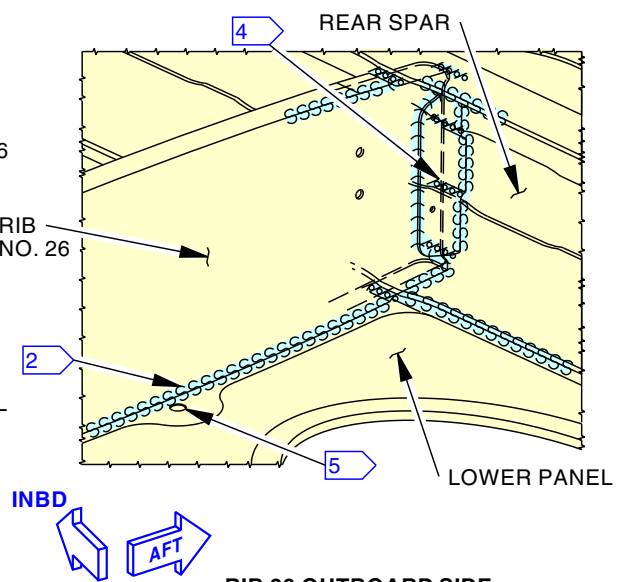
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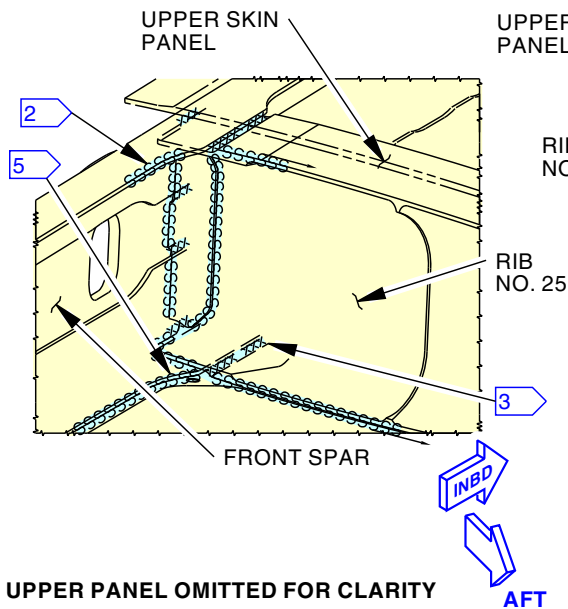
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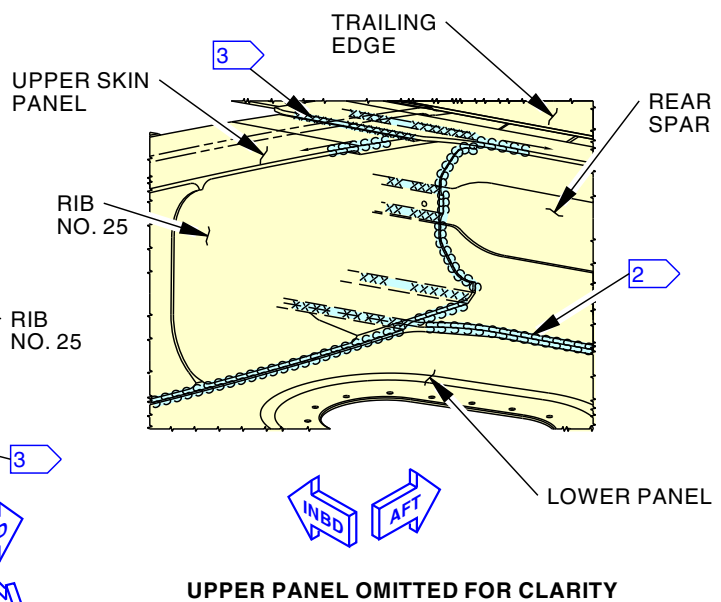
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Dry Bay Tank Seals
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WINGLET EROSION PROTECTION - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

- (1) Winglet erosion protection removal
- (2) Winglet erosion protection installation.

B. The winglet blades have erosion protection tape on part of their surface area.

NOTE: BMS10-148 is the specification for the erosion protection tape. In this procedure, the erosion protection tape will be referred to as protective tape.

SIA ALL; AIRPLANES WITH FULL-LENGTH EROSION TAPE

TASK 57-31-24-000-801

2. Winglet Erosion Protection Removal

(Figure 401)

A. General

- (1) This task gives the steps to remove the erosion protection tape from the winglet blades.

B. References

Reference	Title
20-40-11-910-801	Static Grounding (P/B 201)
33-44-13-000-801	Winglet Anti-Collision Light Removal (P/B 201)
57-31-25-010-801	Transition Fairing Removal (P/B 401)

C. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt.", which stands for Optional.

Reference	Description
COM-659	Platform - Maintenance Lift, 3 ft Minimum Height, 12.5 ft Maximum Height Part #: 1135-8000 Supplier: 00994 Opt Part #: 8662-010 Supplier: 00994
COM-2480	Platform - Mobile Elevating Work Platform SJ III Series Part #: SJIII 4726 Supplier: 3AF08 Part #: SJIII 4732 Supplier: 3AF08 Opt Part #: SJIII 4620 Supplier: 3AF08 Opt Part #: SJIII 4626 Supplier: 3AF08 Opt Part #: SJIII 4632 Supplier: 3AF08

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SIA ALL; AIRPLANES WITH FULL-LENGTH EROSION TAPE (Continued)

(Continued)

Reference	Description
COM-2481	Sealant Removal Tool (meets BSS7384 requirements) Part #: 1-6390-A Supplier: 63318 Part #: 10810 Supplier: \$0855 Part #: 10811 Supplier: \$0855 Part #: 10812 Supplier: \$0855 Part #: 234350 Supplier: 5HCF1 Part #: 235072 Supplier: 5HCF1 Part #: 235073 Supplier: 5HCF1 Part #: 235074 Supplier: 5HCF1 Part #: 235075 Supplier: 5HCF1 Part #: 235076 Supplier: 5HCF1 Part #: 311/03 Supplier: F6892 Part #: 311/14 Supplier: F6892 Part #: 311/25 Supplier: F6892 Part #: 311/37 Supplier: F6892 Part #: AS1 Supplier: \$1351 Part #: AS2 Supplier: \$1351 Part #: AS3 Supplier: \$1351 Part #: DAD5013 Supplier: 7RKH2 Part #: DFD5019 Supplier: 7RKH2 Part #: JNT411B60 Supplier: 3DN12 Part #: JNT411B90 Supplier: 3DN12 Part #: SCD5019 Supplier: 7RKH2 Part #: ST982LF-9 Supplier: 81205 Part #: TS1275-4 Supplier: 22975
STD-6435	Respirator - Particulate (Meets NIOSH 42 CFR 84 Class N95, EN149 Class FFP2, or Better)
STD-6437	Goggles - Safety, Non Vented

D. Consumable Materials

Reference	Description	Specification
B00148	Solvent - Methyl Ethyl Ketone (MEK)	ASTM D740
B50262	Alcohol - Isopropyl, grade A (water content 0.1 percent max.)	TT-I-735
G50140	Gloves - Protective, Latex or Nitrile	
G51677	Cloth - 100% Synthetic or Blended Synthetic, Cotton or Cellulose Material	AMS3819 Class 1, 2, or 4, Grade A or B, Form 1

E. Location Zones

Zone	Area
500	Left Wing
527	Left Winglet
600	Right Wing
627	Right Winglet

F. Prepare for the Removal

SUBTASK 57-31-24-860-001

- (1) Make sure that the work area is safe.
 - (a) Make sure that the airplane is correctly grounded to an approved and identified ground.

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SIA ALL; AIRPLANES WITH FULL-LENGTH EROSION TAPE (Continued)

- 1) Do this task: Static Grounding, TASK 20-40-11-910-801.
- (b) Get a ladder, work platform, COM-2480, or maintenance platform, COM-659.
NOTE: A scissors-type, mobile work platform, or scaffold maintenance platform is recommended for two persons.
- (c) Do these steps to prepare metal support equipment such as work platforms, work/maintenance stands, ladders.
NOTE: These steps apply to all metal support equipment within a 50 ft (15 m) radius of an open fuel tank.
 - 1) All support equipment must be in place before you begin the procedure.
 - 2) Bond the support equipment at an approved airplane bonding location.
 - 3) Ground the support equipment to the same earth ground as the airplane.

SUBTASK 57-31-24-020-003

- (2) If the lower blade erosion tape [2] will be removed, do this task: Winglet Anti-Collision Light Removal, TASK 33-44-13-000-801.
 - (a) Make sure to remove all sealant from leading edge of the winglet lower blade and anti-collision light.

SUBTASK 57-31-24-010-001

- (3) If the upper blade erosion tape [1] will be removed, do this task: Transition Fairing Removal, TASK 57-31-25-010-801.

G. Winglet Erosion Protection Tape Removal



ONLY USE APPROVED SCRAPERS ON THE AIRPLANE SKIN. SCRAPERS THAT ARE NOT APPROVED CAN MAKE SCRATCHES ON THE SKIN, AND CAUSE FATIGUE CRACKS.

SUBTASK 57-31-24-020-001

- (1) Remove the upper blade erosion tape [1].
 - (a) Cut the upper blade erosion tape [1] in narrow strips less than 4 in. (102 mm) wide.



BE CAREFUL WHEN YOU REMOVE THE EROSION PROTECTION TAPE. PULL THE TAPE WITH A SLOW AND STABLE, CONTINUOUS FORCE. IF YOU ARE NOT CAREFUL, THEN DAMAGE TO THE PAINT AND STRUCTURE CAN OCCUR.

- (b) Lift the edge of the strip from the upper blade erosion tape [1] from the surface of the winglet.
- (c) If it is necessary, use a sealant removal tool, COM-2481, to remove the upper blade erosion tape [1] from the surface.

SUBTASK 57-31-24-020-002

- (2) Remove the lower blade erosion tape [2].
 - (a) Cut the lower blade erosion tape [2] in narrow strips less than 4 in. (102 mm) wide.

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BE CAREFUL WHEN YOU REMOVE THE EROSION PROTECTION TAPE. PULL THE TAPE WITH A SLOW AND STABLE, CONTINUOUS FORCE. IF YOU ARE NOT CAREFUL, THEN DAMAGE TO THE PAINT AND STRUCTURE CAN OCCUR.

- (b) Lift the edge of the lower blade erosion tape [2] from the surface of the winglet.
- (c) If it is necessary, use a sealant removal tool, COM-2481, to remove the lower blade erosion tape [2] from the surface.

SUBTASK 57-31-24-160-001

- (3) Clean the remaining adhesive from the winglet.



METHYL ETHYL KETONE IS POISONOUS. USE PERSONAL-PROTECTION EQUIPMENT. MAKE SURE THAT THERE IS GOOD AIRFLOW OR INJURY CAN OCCUR.

- (a) Use cloth, G51677, soaked in alcohol, B50262, or solvent, B00148, and a sealant removal tool, COM-2481, to remove the adhesive.
 - 1) Put on the personal protective equipment listed below if solvent, B00148, is used:
 - safety goggles, STD-6437
 - protective gloves, G50140
 - particulate respirator, STD-6435.

————— END OF TASK —————

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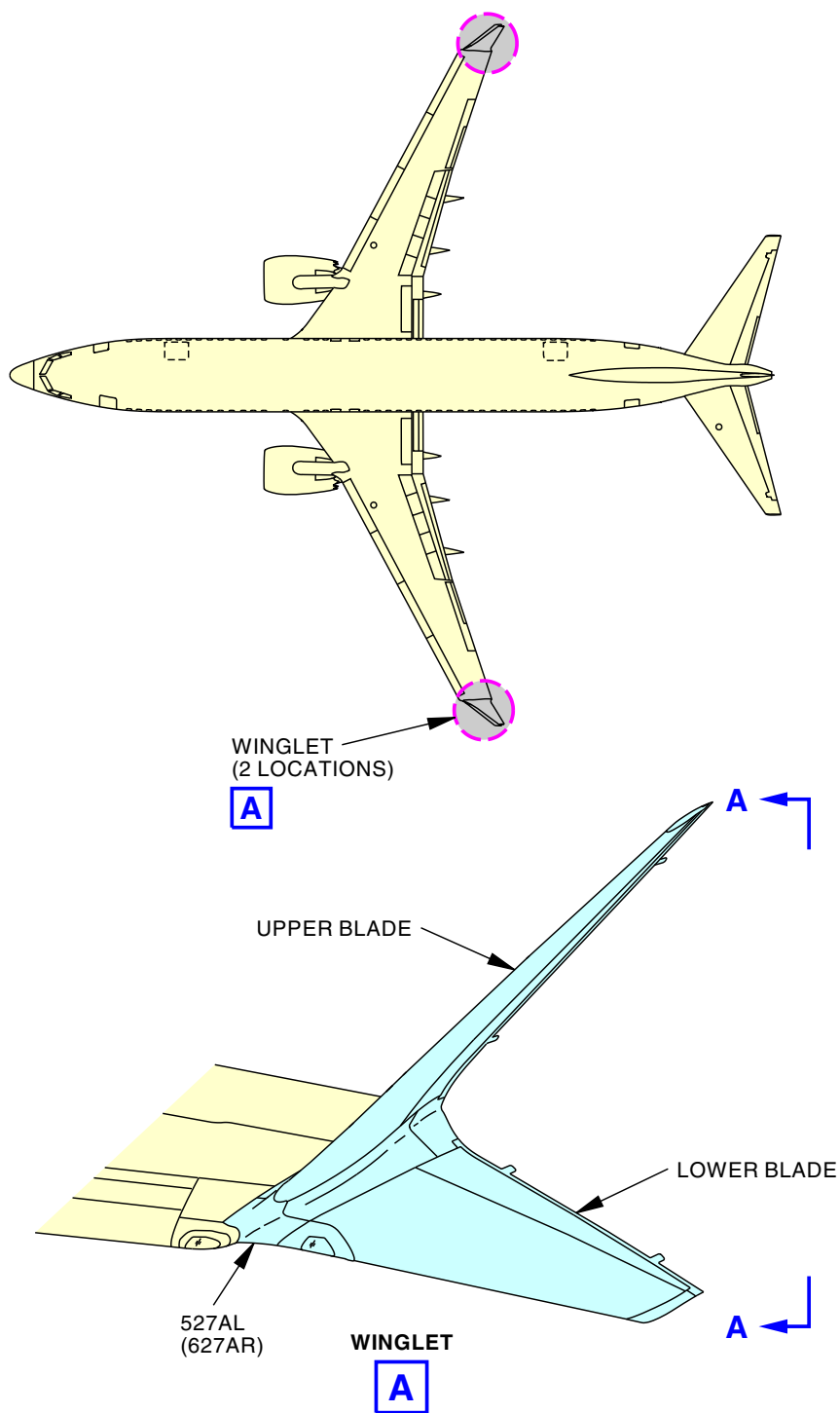
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2471210 S0000578277_V2

Winglet Erosion Protection Installation
Figure 401/57-31-24-990-802 (Sheet 1 of 3)

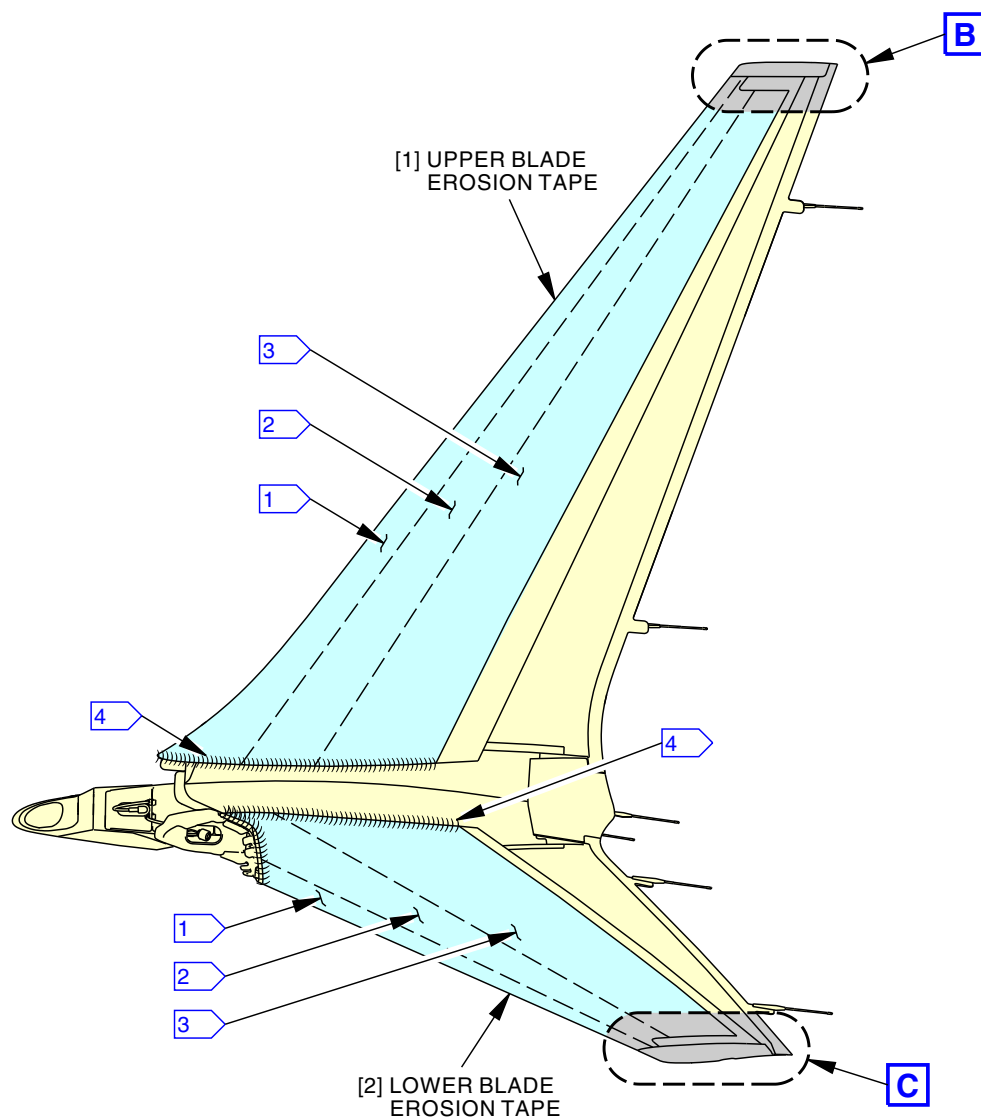
EFFECTIVITY
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WINGLET - UPPER AND LOWER BLADES

A-A

- 1 ZONE 1
- 2 ZONE 2
- 3 ZONE 3
- 4 TRIM LINE))))

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Winglet Erosion Protection Installation
Figure 401/57-31-24-990-802 (Sheet 2 of 3)

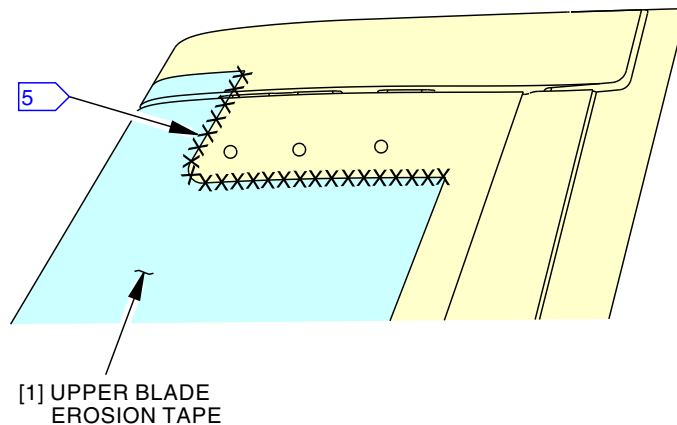
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SIA ALL; AIRPLANES WITH FULL-LENGTH
EROSION TAPE

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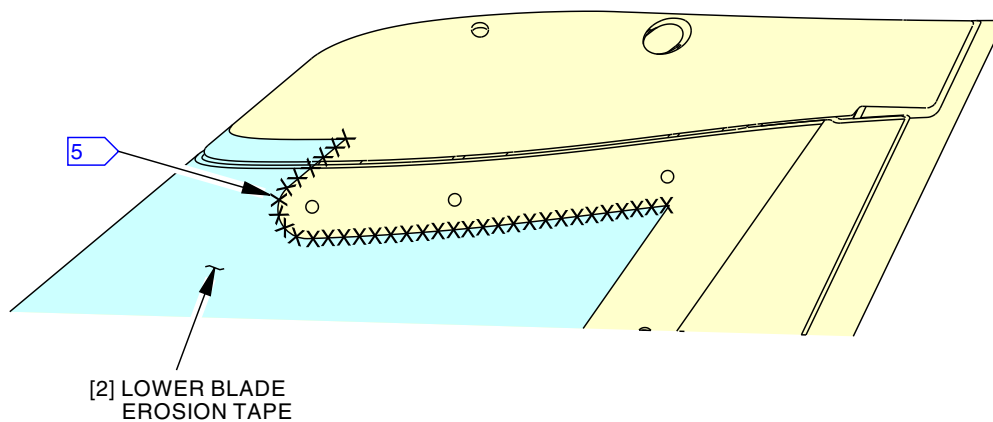
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UPPER BLADE

B



LOWER BLADE

C

5 EDGE SEAL THIS AREA XXX

2471317 S0000578279_V2

Winglet Erosion Protection Installation
Figure 401/57-31-24-990-802 (Sheet 3 of 3)

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TASK 57-31-24-400-801

3. Winglet Erosion Protection Installation

(Figure 401)

A. General

- (1) This task gives instructions to install the erosion protection tape on the winglet blades.
- (2) To install the erosion protection tape on the winglet blades, three persons are needed.
- (3) It is recommended that the airplane be moved to a clean enclosed environment to install the erosion protection tape.
- (4) The erosion tape has one liner that is slit into two primary sections. The liner is removed to apply the erosion tape to the winglet blade surface.
 - (a) The inboard section includes the leading edge and inboard side of the winglet blades.
 - (b) The outboard section includes the outboard side of the winglet blades.
- (5) Protrusions are bubbles, wrinkles, inclusions, or other situations that raise an area on the erosion protection tape surface.
 - (a) Protrusions must be kept to a minimum or averted fully, if it is possible.
- (6) Maintenance must not have sharp items that can penetrate the erosion protection tape or wear clothing that will release lint that can bond to the tape.
- (7) The surface of the winglet blade that will have the erosion protection tape installed must have the clearcoat abraded (TASK 57-31-21-300-804).
 - (a) If the surface that will receive the erosion protection tape is already abraded, then no additional change is necessary.
- (8) The surface of the winglet blade that will not receive erosion protection tape must have sufficient clearcoat to cover the livery (TASK 57-31-21-300-802).

B. References

Reference	Title
33-44-13-400-801	Winglet Anti-Collision Light Installation (P/B 201)
57-31-21-300-802	Basecoat/Clearcoat Paint System Application (P/B 701)
57-31-21-300-804	Basecoat/Clearcoat Paint System Preparation for BMS10-148 Application (P/B 701)
57-31-25-410-801	Transition Fairing Installation (P/B 401)

C. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
COM-659	Platform - Maintenance Lift, 3 ft Minimum Height, 12.5 ft Maximum Height Part #: 1135-8000 Supplier: 00994 Opt Part #: 8662-010 Supplier: 00994

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Reference	Description
COM-2480	Platform - Mobile Elevating Work Platform SJ III Series Part #: SJIII 4726 Supplier: 3AF08 Part #: SJIII 4732 Supplier: 3AF08 Opt Part #: SJIII 4620 Supplier: 3AF08 Opt Part #: SJIII 4626 Supplier: 3AF08 Opt Part #: SJIII 4632 Supplier: 3AF08
COM-20546	Squeegee - Protective Tape and Film Applicator Part #: 4INSES Supplier: \$1345 Part #: CPA-1 Supplier: 17325 Part #: MSES4IN Supplier: \$1345
STD-3949	Scalpel - X-ACTO Knife
STD-4048	Bottle - Hand Spray
STD-6435	Respirator - Particulate (Meets NIOSH 42 CFR 84 Class N95, EN149 Class FFP2, or Better)
STD-6437	Goggles - Safety, Non Vented
STD-6444	Straightedge - Steel, 4 ft

D. Consumable Materials

Reference	Description	Specification
A50454	Tape - Masking, General Purpose, Scotch 234	
A50565	Adhesive - Modified Epoxy For General Purpose Use	BMS5-92 Type IV Class 3
B00148	Solvent - Methyl Ethyl Ketone (MEK)	ASTM D740
B00541	Cleaner - General Purpose Household Detergent	
B50262	Alcohol - Isopropyl, grade A (water content 0.1 percent max.)	TT-I-735
B50384	Solution - Protective Tape Application - 3M UPC #048011-56800-3	BAC5095
C50328	Sealer - Two-Part, Polyurethane, Edge Sealer, Erosion Resistant (ES2000)	
G02418	Water - De-ionized	
G50140	Gloves - Protective, Latex or Nitrile	
G50554	Tape - Polyethylene - 3M No. 5421	
G51128	Tape - 3M Vinyl Tape 471 Red, 3.0 Inches (76.2 mm) Wide	
G51677	Cloth - 100% Synthetic or Blended Synthetic, Cotton or Cellulose Material	AMS3819 Class 1, 2, or 4, Grade A or B, Form 1

E. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Upper blade erosion tape	57-31-24-01-020	SIA ALL
		57-31-24-01-025	SIA ALL
		57-31-24-05-020	SIA ALL
		57-31-24-05-025	SIA ALL

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SIA ALL; AIRPLANES WITH FULL-LENGTH EROSION TAPE (Continued)

(Continued)

AMM Item	Description	AIPC Reference	AIPC Effectivity
1 (cont.)		57-31-24-05-030	SIA ALL
		57-31-24-05-035	SIA ALL
2	Lower blade erosion tape	57-31-24-01-030	SIA ALL
		57-31-24-01-035	SIA ALL
		57-31-24-05-120	SIA ALL
		57-31-24-05-125	SIA ALL
		57-31-24-05-130	SIA ALL
		57-31-24-05-135	SIA ALL

F. Location Zones

Zone	Area
500	Left Wing
527	Left Winglet
600	Right Wing
627	Right Winglet

G. Prepare for the Installation

SUBTASK 57-31-24-160-002

- (1) Prepare the surfaces of the applicable upper or lower blade of the winglet.
 - (a) Repair any paint chips or other defects on the surface of the winglet blade.



METHYL ETHYL KETONE IS POISONOUS. USE PERSONAL-PROTECTION EQUIPMENT. MAKE SURE THAT THERE IS GOOD AIRFLOW OR INJURY CAN OCCUR.

- (b) Use cloth, G51677, soaked in alcohol, B50262, or solvent, B00148, to clean the surface of the winglet blade.
 - 1) Put on the personal protective equipment listed below if solvent, B00148, is used:
 - safety goggles, STD-6437
 - protective gloves, G50140
 - particulate respirator, STD-6435.
- (c) Make sure that there is no old adhesive on the surface of the winglet blade.
- (d) Make sure that there is no remaining sealant on the leading edge of the winglet blades.
- (e) Make sure that the surface of the winglet blade is smooth and dry.

SUBTASK 57-31-24-420-001

- (2) Apply a line of 3M Vinyl 471 Red tape, G51128, around the area where the erosion protection tape will be applied to the surface of the winglet blade.

SUBTASK 57-31-24-420-004

- (3) If it is necessary, apply a layer of 3M No. 5421 tape, G50554, to the edge of the squeegee, COM-20546.
 - (a) Trim the excess 3M No. 5421 tape, G50554, from the sides of the squeegee, COM-20546.

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SUBTASK 57-31-24-940-001

- (4) Do one of the following options:
- (a) Use wetting solution, B50384, or
 - (b) Prepare wetting solution in one or more hand spray bottles, STD-4048, with the following mixing ratio:
 - 75% de-ionized water, G02418
 - 25% alcohol, B50262
 - 4 to 5 drops of general purpose household detergent cleaner, B00541.

SUBTASK 57-31-24-160-005

- (5) Use cloth, G51677, soaked in alcohol, B50262, to clean the non-adhesive surface of the erosion tape.

H. Winglet Upper Blade Erosion Protection Tape Installation

SUBTASK 57-31-24-420-002

- (1) Install the upper blade erosion tape [1].
- (a) Align the centerline marking strip on the upper blade erosion tape [1] with the leading edge of the winglet blade.
 - 1) Make sure that the upper blade erosion tape [1] is aligned at the apex and the root of the winglet blade.
 - (b) Use multiple strips of Scotch General Purpose Masking Tape 234, A50454, to loosely attach the upper blade erosion tape [1] to the winglet blade.
 - (c) Install the upper blade erosion tape [1] to the leading edge of the winglet blade.

NOTE: Attaching the upper blade erosion tape at the leading edge first will help keep it aligned and fixed during installation of the adjacent sides.

- 1) Remove the inboard liner in small increments from the tip to the root along the center of the upper blade erosion tape [1].
 - a) Remove masking tape where necessary for access.
 - 2) Apply liberal amounts of wetting solution to the upper blade erosion tape [1] and winglet surface.
 - 3) Use finger pressure to attach the exposed section of the upper blade erosion tape [1] to the winglet blade.
 - 4) Make sure that the centerline marking strip is in the limit of 0.00 ± 0.25 in. (0.00 ± 6.35 mm) of the leading edge.
 - 5) Smooth the upper blade erosion tape [1] with a squeegee, COM-20546.
 - a) Start from the leading edge and move aft.
 - 6) Make sure that the number of protrusions on the upper blade erosion tape [1] are kept to a minimum along the leading edge of the winglet blade.
 - a) If it is necessary, lift and stretch the upper blade erosion tape [1] at small increments to remove the protrusion and smooth with the squeegee, COM-20546.
- (d) Install the inboard side of the upper blade erosion tape [1] to the winglet blade.
- 1) Remove the remainder of the inboard liner in small increments from the tip to the root of the upper blade erosion tape [1].

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- a) Remove masking tape where necessary for access.
- 2) Apply liberal amounts of wetting solution to the exposed adhesive of the upper blade erosion tape [1] and winglet surface.
- 3) Use finger pressure to attach the exposed section of the upper blade erosion tape [1] to the winglet blade.
- 4) Smooth the upper blade erosion tape [1] with a squeegee, COM-20546.
 - a) Start from the leading edge and move aft.
- 5) Make sure that the number of protrusions on the upper blade erosion tape [1] are kept to a minimum along the sides of the winglet blade.
 - a) If it is necessary, lift and stretch the upper blade erosion tape [1] at small increments to remove the protrusion and smooth with the squeegee, COM-20546.
- (e) Install the outboard side of the upper blade erosion tape [1] to the winglet blade.
 - 1) Remove the outboard liner in small increments from the tip to the root of the upper blade erosion tape [1].
 - a) Remove masking tape where necessary for access.
 - 2) Apply liberal amounts of wetting solution to the exposed adhesive of the upper blade erosion tape [1] and winglet surface.
 - 3) Use finger pressure to attach the exposed section of the upper blade erosion tape [1] to the winglet blade.
 - 4) Smooth the upper blade erosion tape [1] with a squeegee, COM-20546.
 - a) Start from the leading edge and move aft.
 - 5) Make sure that the number of protrusions on the upper blade erosion tape [1] are kept to a minimum along the sides of the winglet blade.
 - a) If it is necessary, lift and stretch the upper blade erosion tape [1] at small increments to remove the protrusion and smooth with the squeegee, COM-20546.
- (f) If it is necessary, use cloth, G51677, to remove excess wetting solution on the winglet blade
- (g) Remove the centerline marking strip from the upper blade erosion tape [1].

SUBTASK 57-31-24-420-003

- (2) Trim the upper blade erosion tape [1] at the edge.
 - (a) Lift the edge of the upper blade erosion tape [1] from the surface and peel it back to the trim line.
 - (b) Put a straightedge, STD-6444, on the adhesive side of the upper blade erosion tape [1], aligned with the trim line.
 - (c) If it is necessary, use a X-ACTO knife scalpel, STD-3949, to carefully cut along the edge of the straight line.
 - (d) Use the squeegee, COM-20546, to reapply the upper blade erosion tape [1].

SUBTASK 57-31-24-390-001

- (3) Apply an edge seal to the inboard and outboard ends of the upper blade erosion tape [1].

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- (a) Apply a strip of Scotch General Purpose Masking Tape 234, A50454, perpendicular to the edges of the upper blade erosion tape [1], in the area to be sealed.
- (b) Use one of the following for the edge seal:
 - sealer, C50328 (preferred)
 - adhesive, A50565 (alternative).
- (c) Apply the sealer along the edge of the upper blade erosion tape [1] between the areas of tape.
- (d) Use the squeegee, COM-20546, to smooth the sealer to a constant thickness.
- (e) Repeat the above step until the sealer is smooth and continuous with no visible gaps.

I. Winglet Lower Blade Erosion Protection Tape Installation

SUBTASK 57-31-24-420-005

- (1) Install the lower blade erosion tape [2].
 - (a) Align the centerline marking strip on the lower blade erosion tape [2] with the leading edge of the winglet blade.
 - 1) Make sure that the lower blade erosion tape [2] is aligned at the apex and the root of the winglet blade.
 - (b) Use multiple strips of Scotch General Purpose Masking Tape 234, A50454, to loosely attach the lower blade erosion tape [2] to the winglet blade.
 - (c) Install the lower blade erosion tape [2] to the leading edge of the winglet blade.

NOTE: Attaching the lower blade erosion tape at the leading edge first will help keep it aligned and fixed during installation of the adjacent sides.

 - 1) Remove the inboard liner in small increments from the tip to the root along the center of the lower blade erosion tape [2].
 - a) Remove masking tape where necessary for access.
 - 2) Apply liberal amounts of wetting solution to the lower blade erosion tape [2] and winglet surface.
 - 3) Use finger pressure to attach the exposed section of the lower blade erosion tape [2] to the winglet blade.
 - 4) Make sure that the centerline marking strip is in the limit of 0.00 ±0.25 in. (0.00 ±6.35 mm) of the leading edge.
 - 5) Smooth the lower blade erosion tape [2] with a squeegee, COM-20546.
 - a) Start from the leading edge and move aft.
 - 6) Make sure that the number of protrusions on the lower blade erosion tape [2] are kept to a minimum along the leading edge of the winglet blade.
 - a) If it is necessary, lift and stretch the lower blade erosion tape [2] at small increments to remove the protrusion and smooth with the squeegee, COM-20546.
 - (d) Install the outboard side of the lower blade erosion tape [2] to the winglet blade.
 - 1) Remove the outboard liner in small increments from the tip to the root of the lower blade erosion tape [2].
 - a) Remove masking tape where necessary for access.

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- 2) Apply liberal amounts of wetting solution to the exposed adhesive of the lower blade erosion tape [2] and winglet surface.
 - 3) Use finger pressure to attach the exposed section of the lower blade erosion tape [2] to the winglet blade.
 - 4) Smooth the lower blade erosion tape [2] with a squeegee, COM-20546.
 - a) Start from the leading edge and move aft.
 - 5) Make sure that the number of protrusions on the lower blade erosion tape [2] are kept to a minimum along the sides of the winglet blade.
 - a) If it is necessary, lift and stretch the lower blade erosion tape [2] at small increments to remove the protrusion and smooth with the squeegee, COM-20546.
- (e) Install the inboard side of the lower blade erosion tape [2] to the winglet blade.
- 1) Remove the remainder of the inboard liner in small increments from the tip to the root of the lower blade erosion tape [2].
 - a) Remove masking tape where necessary for access.
 - 2) Apply liberal amounts of wetting solution to the exposed adhesive of the lower blade erosion tape [2] and winglet surface.
 - 3) Use finger pressure to attach the exposed section of the lower blade erosion tape [2] to the winglet blade.
 - 4) Smooth the lower blade erosion tape [2] with a squeegee, COM-20546. Start from the leading edge and move aft.
 - a) Start from the leading edge and move aft.
 - 5) Make sure that the number of protrusions on the lower blade erosion tape [2] are kept to a minimum along the sides of the winglet blade.
 - a) If it is necessary, lift and stretch the lower blade erosion tape [2] at small increments to remove the protrusion and smooth with the squeegee, COM-20546.
- (f) If it is necessary, use a cloth, G51677, to remove excess wetting solution on the winglet blade
- (g) Remove the centerline marking strip from the lower blade erosion tape [2].

SUBTASK 57-31-24-420-006

- (2) Trim the lower blade erosion tape [2] at the edge.
- (a) Lift the edge of the lower blade erosion tape [2] from the surface and peel it back to the trim line.
 - (b) Put a straightedge, STD-6444, on the adhesive side of the lower blade erosion tape [2], aligned with the trim line.
 - (c) If it is necessary, use a X-ACTO knife scalpel, STD-3949, to carefully cut along the edge of the straight line.
 - (d) Use the squeegee, COM-20546, to reapply the lower blade erosion tape [2].

SUBTASK 57-31-24-390-004

- (3) Apply an edge seal to the inboard and outboard ends of the lower blade erosion tape [2].

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- (a) Apply a strip of Scotch General Purpose Masking Tape 234, A50454, perpendicular to the edges of the lower blade erosion tape [2], in the area to be sealed.
- (b) Use one of the following for the edge seal:
 - sealer, C50328 (preferred)
 - adhesive, A50565 (alternative).
- (c) Apply the sealer along the edge of the lower blade erosion tape [2] between the areas of tape.
- (d) Use the squeegee, COM-20546, to smooth the sealer to a constant thickness.
- (e) Repeat the above step until the sealer is smooth and continuous with no visible gaps.

J. Put the Airplane Back to Its Usual Condition

SUBTASK 57-31-24-840-001

- (1) Remove the ladders, work platform, COM-2480, or maintenance platform, COM-659.

SUBTASK 57-31-24-400-001

- (2) If the upper blade erosion tape [1] was installed, do this task: Transition Fairing Installation, TASK 57-31-25-410-801.

SUBTASK 57-31-24-400-002

- (3) If the lower blade erosion tape [2] was installed, do this task: Winglet Anti-Collision Light Installation, TASK 33-44-13-400-801.

————— END OF TASK —————

SIA ALL; AIRPLANES WITH SHORT EROSION TAPE

TASK 57-31-24-000-802

4. Winglet Erosion Protection Removal

(Figure 402)

A. General

- (1) This task gives instructions to remove the erosion protection tape from the winglet blades.

B. References

Reference	Title
20-40-11-910-801	Static Grounding (P/B 201)
33-44-13-000-801	Winglet Anti-Collision Light Removal (P/B 201)
57-31-25-010-801	Transition Fairing Removal (P/B 401)

C. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
COM-659	Platform - Maintenance Lift, 3 ft Minimum Height, 12.5 ft Maximum Height Part #: 1135-8000 Supplier: 00994 Opt Part #: 8662-010 Supplier: 00994

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SIA ALL; AIRPLANES WITH SHORT EROSION TAPE (Continued)

(Continued)

Reference	Description
COM-2480	Platform - Mobile Elevating Work Platform SJ III Series Part #: SJIII 4726 Supplier: 3AF08 Part #: SJIII 4732 Supplier: 3AF08 Opt Part #: SJIII 4620 Supplier: 3AF08 Opt Part #: SJIII 4626 Supplier: 3AF08 Opt Part #: SJIII 4632 Supplier: 3AF08
COM-2481	Sealant Removal Tool (meets BSS7384 requirements) Part #: 1-6390-A Supplier: 63318 Part #: 10810 Supplier: \$0855 Part #: 10811 Supplier: \$0855 Part #: 10812 Supplier: \$0855 Part #: 234350 Supplier: 5HCF1 Part #: 235072 Supplier: 5HCF1 Part #: 235073 Supplier: 5HCF1 Part #: 235074 Supplier: 5HCF1 Part #: 235075 Supplier: 5HCF1 Part #: 235076 Supplier: 5HCF1 Part #: 311/03 Supplier: F6892 Part #: 311/14 Supplier: F6892 Part #: 311/25 Supplier: F6892 Part #: 311/37 Supplier: F6892 Part #: AS1 Supplier: \$1351 Part #: AS2 Supplier: \$1351 Part #: AS3 Supplier: \$1351 Part #: DAD5013 Supplier: 7RKH2 Part #: DFD5019 Supplier: 7RKH2 Part #: JNT411B60 Supplier: 3DN12 Part #: JNT411B90 Supplier: 3DN12 Part #: SCD5019 Supplier: 7RKH2 Part #: ST982LF-9 Supplier: 81205 Part #: TS1275-4 Supplier: 22975
STD-6435	Respirator - Particulate (Meets NIOSH 42 CFR 84 Class N95, EN149 Class FFP2, or Better)
STD-6437	Goggles - Safety, Non Vented

D. Consumable Materials

Reference	Description	Specification
B00148	Solvent - Methyl Ethyl Ketone (MEK)	ASTM D740
B50262	Alcohol - Isopropyl, grade A (water content 0.1 percent max.)	TT-I-735
G50140	Gloves - Protective, Latex or Nitrile	
G51677	Cloth - 100% Synthetic or Blended Synthetic, Cotton or Cellulose Material	AMS3819 Class 1, 2, or 4, Grade A or B, Form 1

E. Location Zones

Zone	Area
500	Left Wing
527	Left Winglet
600	Right Wing

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(Continued)

Zone	Area
627	Right Winglet

F. Prepare for the Removal

SUBTASK 57-31-24-860-002

- (1) Make sure that the work area is safe.
 - (a) Make sure that the airplane is correctly grounded to an approved and identified ground.
 - 1) Do this task: Static Grounding, TASK 20-40-11-910-801.
 - (b) Get a ladder, work platform, COM-2480, or maintenance platform, COM-659.

NOTE: A scissors-type, mobile work platform, or scaffold maintenance platform is recommended for two persons.
 - (c) Do these steps to prepare metal support equipment such as work platforms, work/maintenance stands, ladders.

NOTE: These steps apply to all metal support equipment within a 50 ft (15 m) radius of an open fuel tank.

 - 1) All support equipment must be in place before you begin the procedure.
 - 2) Bond the support equipment at an approved airplane bonding location.
 - 3) Ground the support equipment to the same earth ground as the airplane.

SUBTASK 57-31-24-020-004

- (2) If the lower blade erosion tape [2] will be removed, do this task: Winglet Anti-Collision Light Removal, TASK 33-44-13-000-801.
 - (a) Make sure to remove all sealant from the leading edge of the winglet lower blade and the anti-collision light.

SUBTASK 57-31-24-010-002

- (3) If the upper blade erosion tape [1] will be removed, do this task: Transition Fairing Removal, TASK 57-31-25-010-801.

G. Winglet Erosion Protection Tape Removal



ONLY USE APPROVED SCRAPERS ON THE AIRPLANE SKIN. SCRAPERS THAT ARE NOT APPROVED CAN MAKE SCRATCHES ON THE SKIN, AND CAUSE FATIGUE CRACKS.

SUBTASK 57-31-24-020-005

- (1) Remove the upper blade erosion tape [1].
 - (a) Cut the upper blade erosion tape [1] in narrow strips less than 4 in. (102 mm) wide.



BE CAREFUL WHEN YOU REMOVE THE EROSION PROTECTION TAPE. PULL THE TAPE WITH A SLOW AND STABLE, CONTINUOUS FORCE. IF YOU ARE NOT CAREFUL, THEN DAMAGE TO THE PAINT AND STRUCTURE CAN OCCUR.

- (b) Lift the edge of the strip from the upper blade erosion tape [1] from the surface of the winglet.

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SIA ALL; AIRPLANES WITH SHORT EROSION TAPE (Continued)

- (c) If it is necessary, use sealant removal tool, COM-2481, to remove the upper blade erosion tape [1] from the surface.

SUBTASK 57-31-24-020-006

- (2) Remove the lower blade erosion tape [2].
(a) Cut the lower blade erosion tape [2] in narrow strips less than 4 in. (102 mm) wide.



CAUTION

BE CAREFUL WHEN YOU REMOVE THE EROSION PROTECTION TAPE. PULL THE TAPE WITH A SLOW AND STABLE, CONTINUOUS FORCE. IF YOU ARE NOT CAREFUL, THEN DAMAGE TO THE PAINT AND STRUCTURE CAN OCCUR.

- (b) Lift the edge of the lower blade erosion tape [2] from the surface of the winglet.
(c) If it is necessary, use sealant removal tool, COM-2481, to remove the lower blade erosion tape [2] from the surface.

SUBTASK 57-31-24-160-003

- (3) Clean the remaining adhesive from the winglet.



WARNING

METHYL ETHYL KETONE IS POISONOUS. USE PERSONAL-PROTECTION EQUIPMENT. MAKE SURE THAT THERE IS GOOD AIRFLOW OR INJURY CAN OCCUR.

- (a) Use cloth, G51677, soaked in alcohol, B50262, or solvent, B00148, and a sealant removal tool, COM-2481, to remove the adhesive.
1) Put on the personal protective equipment listed below if solvent, B00148, is used:
- safety goggles, STD-6437
 - protective gloves, G50140
 - particulate respirator, STD-6435.

————— **END OF TASK** —————

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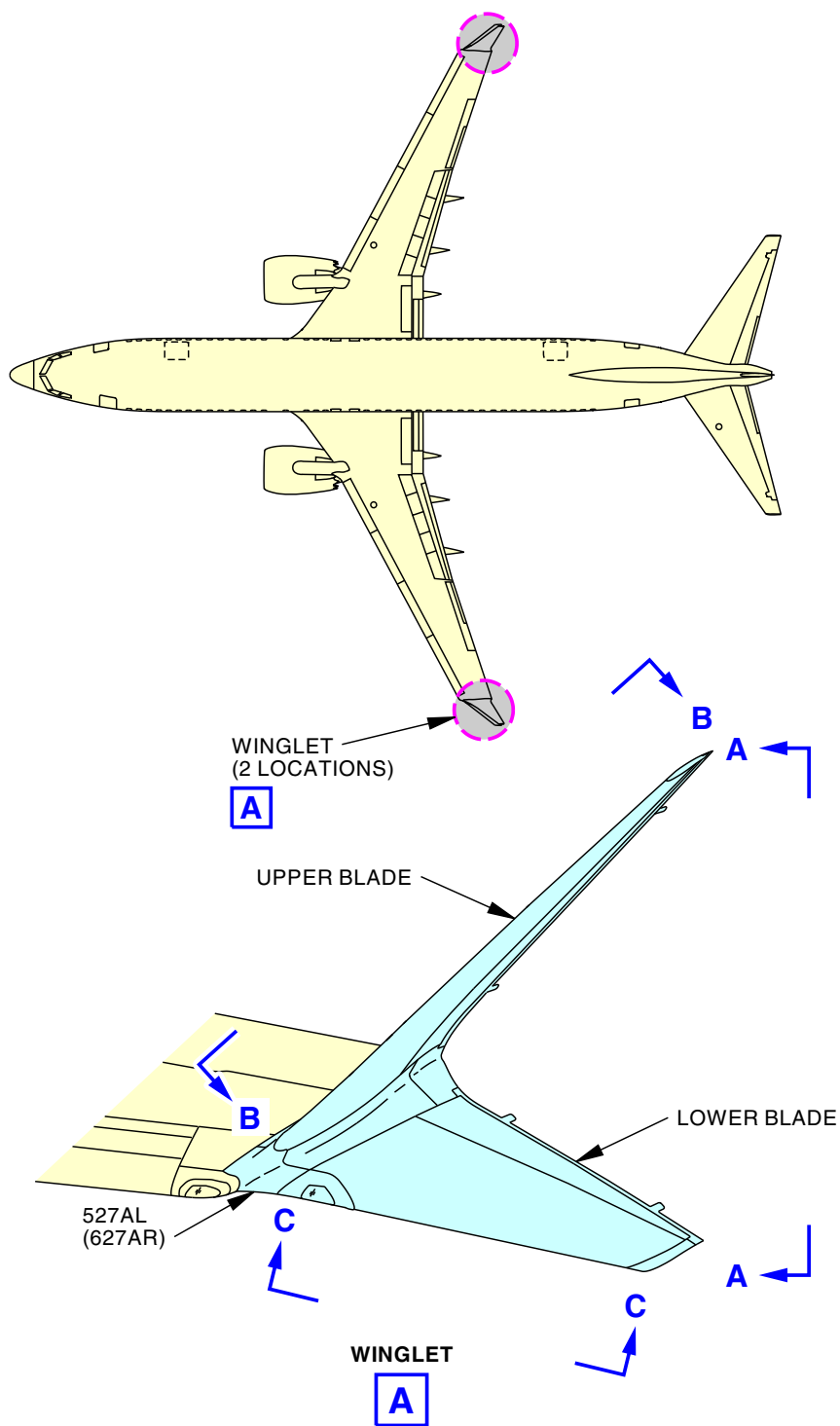
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2962674 S0000740897_V1

Winglet Erosion Protection Installation
Figure 402/57-31-24-990-803 (Sheet 1 of 4)

EFFECTIVITY
SIA ALL; AIRPLANES WITH SHORT EROSION TAPE

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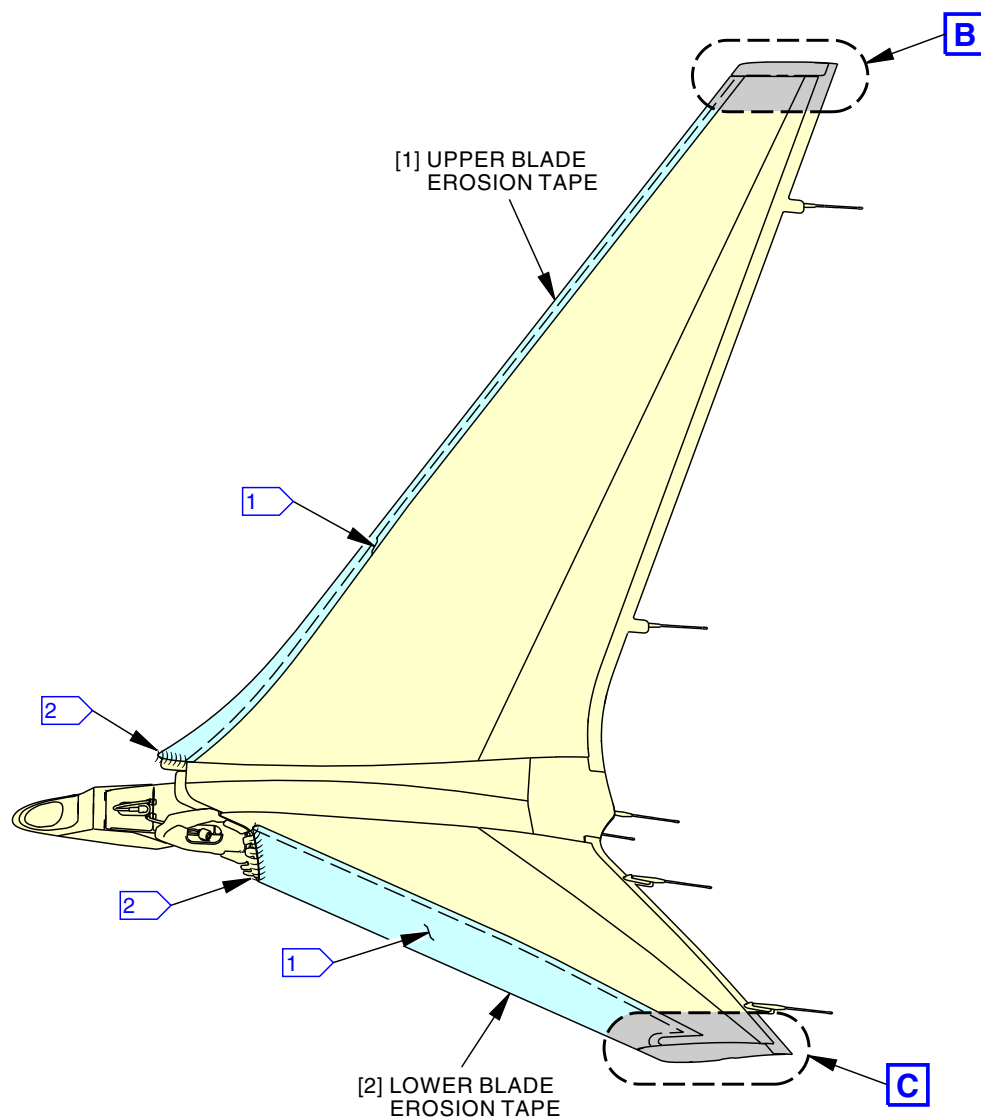
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WINGLET - UPPER AND LOWER BLADES

A-A

- 1 ZONE 1
- 2 TRIM LINE))))

2962779 S0000740898_V1

Winglet Erosion Protection Installation
Figure 402/57-31-24-990-803 (Sheet 2 of 4)

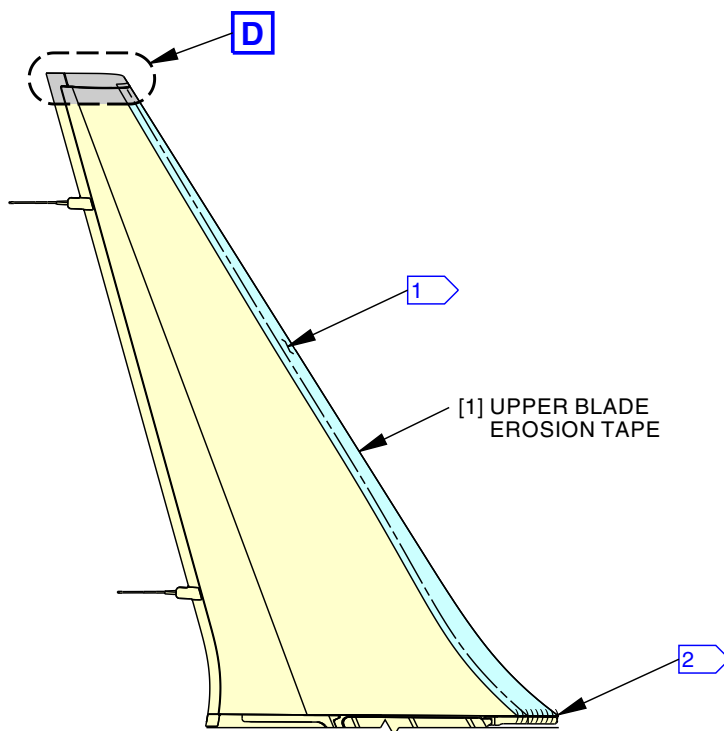
EFFECTIVITY
SIA ALL; AIRPLANES WITH SHORT EROSION TAPE

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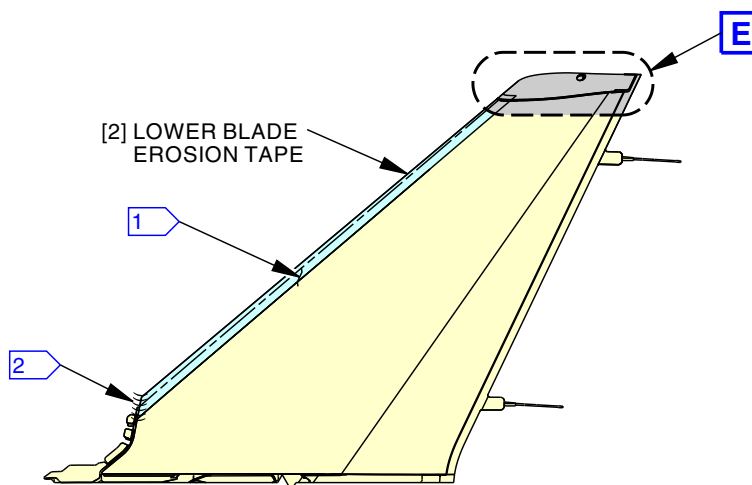
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WINGLET - UPPER BLADE
B-B



WINGLET - LOWER BLADE
C-C

1 ZONE 1
2 TRIM LINE))))

2963372 S0000741618_V1

Winglet Erosion Protection Installation
Figure 402/57-31-24-990-803 (Sheet 3 of 4)

EFFECTIVITY
SIA ALL; AIRPLANES WITH SHORT EROSION TAPE

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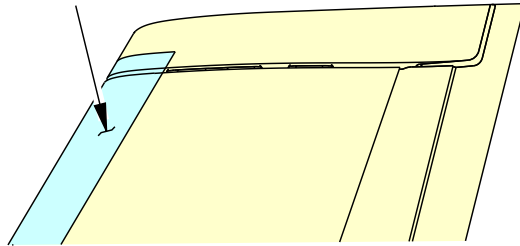
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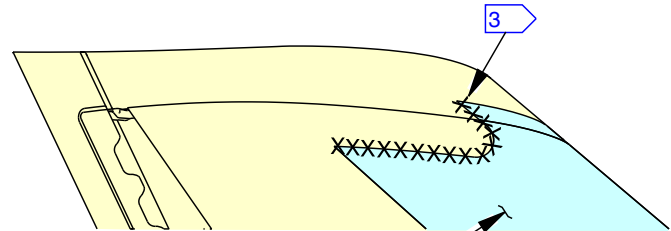
BOEING
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[1] UPPER BLADE
EROSION TAPE



UPPER BLADE

B



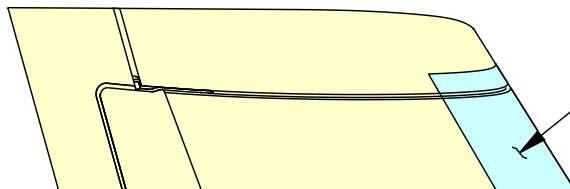
3

[2] LOWER BLADE
EROSION TAPE



LOWER BLADE

C

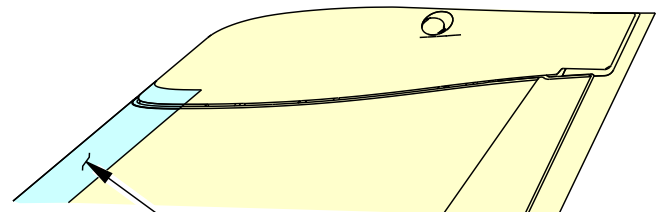


[1] UPPER BLADE
EROSION TAPE



UPPER BLADE

D



[2] LOWER BLADE
EROSION TAPE



LOWER BLADE

E

3 EDGE SEAL THIS AREA XXX

2962937 S0000740899_V1

Winglet Erosion Protection Installation
Figure 402/57-31-24-990-803 (Sheet 4 of 4)

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TASK 57-31-24-400-802

5. Winglet Erosion Protection Installation

(Figure 402)

A. General

- (1) This task gives instructions to install the erosion protection tape on the winglet blades.
- (2) To install the erosion protection tape on the winglet blades, three persons are needed.
- (3) It is recommended that the airplane be moved to a clean enclosed environment to install the erosion protection tape.
- (4) The erosion tape has one liner that is removed to apply it to the winglet blade surface.
- (5) Protrusions are bubbles, wrinkles, inclusions, or other situations that raise an area on the erosion protection tape surface.
 - (a) Protrusions must be kept to a minimum or averted fully, if it is possible.
- (6) Maintenance must not have sharp items that can penetrate the erosion protection tape or wear clothing that will release lint that can bond to the tape.
- (7) The surface of the winglet blade that will have the erosion protection tape installed must have the clearcoat abraded (TASK 57-31-21-300-804).
 - (a) If the surface that will receive the erosion protection tape is already abraded, then no additional change is necessary.
- (8) The surface of the winglet blade that will not receive erosion protection tape must have sufficient clearcoat to cover the livery (TASK 57-31-21-300-802).

B. References

Reference	Title
33-44-13-400-801	Winglet Anti-Collision Light Installation (P/B 201)
57-31-21-300-802	Basecoat/Clearcoat Paint System Application (P/B 701)
57-31-21-300-804	Basecoat/Clearcoat Paint System Preparation for BMS10-148 Application (P/B 701)
57-31-25-410-801	Transition Fairing Installation (P/B 401)

C. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
COM-659	Platform - Maintenance Lift, 3 ft Minimum Height, 12.5 ft Maximum Height Part #: 1135-8000 Supplier: 00994 Opt Part #: 8662-010 Supplier: 00994
COM-2480	Platform - Mobile Elevating Work Platform SJ III Series Part #: SJIII 4726 Supplier: 3AF08 Part #: SJIII 4732 Supplier: 3AF08 Opt Part #: SJIII 4620 Supplier: 3AF08 Opt Part #: SJIII 4626 Supplier: 3AF08 Opt Part #: SJIII 4632 Supplier: 3AF08

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(Continued)

Reference	Description
COM-20546	Squeegee - Protective Tape and Film Applicator Part #: 4INSES Supplier: \$1345 Part #: CPA-1 Supplier: 17325 Part #: MSES4IN Supplier: \$1345
STD-3949	Scalpel - X-ACTO Knife
STD-4048	Bottle - Hand Spray
STD-6435	Respirator - Particulate (Meets NIOSH 42 CFR 84 Class N95, EN149 Class FFP2, or Better)
STD-6437	Goggles - Safety, Non Vented
STD-6444	Straightedge - Steel, 4 ft

D. Consumable Materials

Reference	Description	Specification
A50454	Tape - Masking, General Purpose, Scotch 234	
A50565	Adhesive - Modified Epoxy For General Purpose Use	BMS5-92 Type IV Class 3
B00148	Solvent - Methyl Ethyl Ketone (MEK)	ASTM D740
B00541	Cleaner - General Purpose Household Detergent	
B50262	Alcohol - Isopropyl, grade A (water content 0.1 percent max.)	TT-I-735
B50384	Solution - Protective Tape Application - 3M UPC #048011-56800-3	BAC5095
C50328	Sealer - Two-Part, Polyurethane, Edge Sealer, Erosion Resistant (ES2000)	
G02418	Water - De-ionized	
G50140	Gloves - Protective, Latex or Nitrile	
G50554	Tape - Polyethylene - 3M No. 5421	
G51128	Tape - 3M Vinyl Tape 471 Red, 3.0 Inches (76.2 mm) Wide	
G51677	Cloth - 100% Synthetic or Blended Synthetic, Cotton or Cellulose Material	AMS3819 Class 1, 2, or 4, Grade A or B, Form 1

E. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Upper blade erosion tape	57-31-24-01-020	SIA ALL
		57-31-24-01-025	SIA ALL
		57-31-24-05-020	SIA ALL
		57-31-24-05-025	SIA ALL
		57-31-24-05-030	SIA ALL
		57-31-24-05-035	SIA ALL
2	Lower blade erosion tape	57-31-24-01-030	SIA ALL
		57-31-24-01-035	SIA ALL
		57-31-24-05-120	SIA ALL

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SIA ALL; AIRPLANES WITH SHORT EROSION TAPE (Continued)

(Continued)

AMM Item	Description	AIPC Reference	AIPC Effectivity
2 (cont.)		57-31-24-05-125	SIA ALL
		57-31-24-05-130	SIA ALL
		57-31-24-05-135	SIA ALL

F. Location Zones

Zone	Area
500	Left Wing
527	Left Winglet
600	Right Wing
627	Right Winglet

G. Prepare for the Installation

SUBTASK 57-31-24-160-004

- (1) Prepare the surfaces of the applicable upper or lower blade of the winglet.
 - (a) Repair any paint chips or other defects on the surface of the winglet blade.



WARNING

METHYL ETHYL KETONE IS POISONOUS. USE PERSONAL-PROTECTION EQUIPMENT. MAKE SURE THAT THERE IS GOOD AIRFLOW OR INJURY CAN OCCUR.

- (b) Use a cloth, G51677, soaked in alcohol, B50262, or solvent, B00148, to clean the surface of the winglet blade.
 - 1) Put on the personal protective equipment listed below if solvent, B00148, is used:
 - safety goggles, STD-6437
 - protective gloves, G50140
 - particulate respirator, STD-6435.
- (c) Make sure that there is no old adhesive on the surface of the winglet blade.
- (d) Make sure that there is no remaining sealant on the leading edge of the winglet blades.
- (e) Make sure that the surface of the winglet blade is smooth and dry.

SUBTASK 57-31-24-420-009

- (2) Apply a line of 3M Vinyl 471 Red tape, G51128, around the area where the erosion protection tape will be applied to the surface of the winglet blade.

SUBTASK 57-31-24-420-010

- (3) If it is necessary, apply a layer of 3M No. 5421 tape, G50554, to the edge of the squeegee, COM-20546.
 - (a) Trim the excess 3M No. 5421 tape, G50554, from the sides of the squeegee, COM-20546.

SUBTASK 57-31-24-940-002

- (4) Do one of the following options:
 - (a) Use wetting solution, B50384, or
 - (b) Prepare wetting solution in one or more hand spray bottles, STD-4048, with the following mixing ratio:

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- 75% de-ionized water, G02418
- 25% alcohol, B50262
- 4 to 5 drops of general purpose household detergent cleaner, B00541.

SUBTASK 57-31-24-160-006

- (5) Use a cloth, G51677, soaked in alcohol, B50262, to clean the non-adhesive surface of the erosion tape.

H. Winglet Upper Blade Erosion Protection Tape Installation

SUBTASK 57-31-24-420-011

- (1) Install the upper blade erosion tape [1].
- Align the centerline marking strip on the upper blade erosion tape [1] with the leading edge of the winglet blade.
 - Make sure that the upper blade erosion tape [1] is aligned at the apex and the root of the winglet blade.
 - Use multiple strips of Scotch General Purpose Masking Tape 234, A50454, to loosely attach the upper blade erosion tape [1] to the winglet blade.
 - Remove the liner in small increments from the tip to the root along the upper blade erosion tape [1].
 - Remove masking tape where necessary for access.
 - Apply liberal amounts of wetting solution to the exposed adhesive of the upper blade erosion tape [1] and winglet surface.
 - Use finger pressure to attach the exposed section of the upper blade erosion tape [1] to the winglet blade.
 - Make sure that the centerline marking strip is in the limit of 0.00 ± 0.25 in. (0.00 ± 6.35 mm) of the leading edge.
 - Smooth the upper blade erosion tape [1] with a squeegee, COM-20546.
 - Start from the leading edge and move aft.
 - Make sure that the number of protrusions on the upper blade erosion tape [1] are kept to a minimum along the leading edge of the winglet blade.
 - If it is necessary, lift and stretch the upper blade erosion tape [1] at small increments to remove the protrusion and smooth with the squeegee, COM-20546.
 - Use cloth, G51677, to remove any remaining wetting solution on the winglet blade.
 - Remove the centerline marking strip from the upper blade erosion tape [1].

SUBTASK 57-31-24-420-012

- (2) Trim the upper blade erosion tape [1] at the edge.
- Lift the edge of the upper blade erosion tape [1] from the surface and peel it back to the trim line.
 - Put a straightedge, STD-6444, on the adhesive side of the upper blade erosion tape [1], aligned with the trim line.
 - If it is necessary, use a X-ACTO knife scalpel, STD-3949, to carefully cut along the edge of the straight line.
 - Use the squeegee, COM-20546, to reapply the upper blade erosion tape [1].

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SIA ALL; AIRPLANES WITH SHORT EROSION TAPE (Continued)

I. Winglet Lower Blade Erosion Protection Tape Installation

SUBTASK 57-31-24-420-013

- (1) Install the new lower blade erosion tape [2].
 - (a) Align the centerline marking strip on the lower blade erosion tape [2] with the leading edge of the winglet blade.
 - 1) Make sure that the lower blade erosion tape [2] is aligned at the apex and the root of the winglet blade.
 - (b) Use multiple strips of Scotch General Purpose Masking Tape 234, A50454, to loosely attach the lower blade erosion tape [2] to the winglet blade.
 - (c) Remove the liner in small increments from the tip to the root along the lower blade erosion tape [2].
 - 1) Remove masking tape where necessary for access.
 - (d) Apply liberal amounts of wetting solution to the exposed adhesive of the lower blade erosion tape [2] and winglet surface.
 - (e) Use finger pressure to attach the exposed section of the lower blade erosion tape [2] to the winglet blade.
 - (f) Make sure that the centerline marking strip is in the limit of 0.00 ±0.25 in. (0.00 ±6.35 mm) of the leading edge.
 - (g) Smooth the lower blade erosion tape [2] with a squeegee, COM-20546.
 - 1) Start from the leading edge and move aft.
 - (h) Make sure that the number of protrusions on the lower blade erosion tape [2] are kept to a minimum along the leading edge of the winglet blade.
 - 1) If it is necessary, lift and stretch the lower blade erosion tape [2] at small increments to remove the protrusion and smooth with the squeegee, COM-20546.
 - (i) Use cloth, G51677, to remove any remaining wetting solution on the winglet blade.
 - (j) Remove the centerline marking strip from the lower blade erosion tape [2].

SUBTASK 57-31-24-420-014

- (2) Trim the lower blade erosion tape [2] at the edge.
 - (a) Lift the edge of the lower blade erosion tape [2] from the surface and peel it back to the trim line.
 - (b) Put a straightedge, STD-6444, on the adhesive side of the lower blade erosion tape [2], aligned with the trim line.
 - (c) If it is necessary, use a X-ACTO knife scalpel, STD-3949, to carefully cut along the edge of the straight line.
 - (d) Use the squeegee, COM-20546, to reapply the lower blade erosion tape [2].

SUBTASK 57-31-24-390-005

- (3) Apply an edge seal to the outboard ends of the lower blade erosion tape [2].
 - (a) Apply a strip of Scotch General Purpose Masking Tape 234, A50454, perpendicular to the edges of the lower blade erosion tape [2], in the area to be sealed.
 - (b) Use one of the following for the edge seal:
 - sealer, C50328 (preferred)

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- adhesive, A50565 (alternative).
- (c) Apply the sealer along the edge of the lower blade erosion tape [2] between the areas of tape.
- (d) Use the squeegee, COM-20546, to smooth the sealer to a constant thickness.
- (e) Repeat the above step until the sealer is smooth and continuous with no visible gaps.

J. Put the Airplane Back to Its Usual Condition

SUBTASK 57-31-24-840-002

- (1) Remove the ladders, work platform, COM-2480, or maintenance platform, COM-659.

SUBTASK 57-31-24-400-003

- (2) If the upper blade erosion tape [1] was installed, do this task: Transition Fairing Installation, TASK 57-31-25-410-801.

SUBTASK 57-31-24-400-004

- (3) If the lower blade erosion tape [2] was installed, do this task: Winglet Anti-Collision Light Installation, TASK 33-44-13-400-801.

———— **END OF TASK** ————

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WINGLET EROSION PROTECTION - INSPECTION/CHECK

1. General

- A. This procedure has the following task:
(1) Winglet Erosion Protection Inspection.

TASK 57-31-24-200-801

2. Winglet Erosion Protection Inspection

A. References

Reference	Title
57-31-24-300-801	Winglet Erosion Protection Repair (P/B 801)

B. Location Zones

Zone	Area
527	Left Winglet
627	Right Winglet

C. **Winglet Erosion Protection Inspection**

SUBTASK 57-31-24-210-003

- (1) Do a general visual inspection of the winglet erosion protection for these conditions:
(a) Installed on the all painted surfaces
(b) Edges are smooth
(c) Repairs are not noticeable from 10 ft (3 m) away.

SUBTASK 57-31-24-350-001

- (2) If necessary, do this task: Winglet Erosion Protection Repair, TASK 57-31-24-300-801.

———— **END OF TASK** ————

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WINGLET EROSION PROTECTION - REPAIRS

TASK 57-31-24-300-801

1. Winglet Erosion Protection Repair

A. References

Reference	Title
SRM 57-30-01-2R-6	Winglet Rain Erosion and Impact Protection Tape Repair

B. Procedure

SUBTASK 57-31-24-350-002

- (1) For repairs on the winglet erosion protection tape, go to this procedure: Winglet Rain Erosion and Impact Protection Tape Repair/SRM PROCEDURE 57-30-01-2R-6.

———— **END OF TASK** ————

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WINGLET FAIRINGS - REMOVAL/INSTALLATION

1. **General**

- A. This procedure has these tasks:
- (1) A removal of the transition fairing
 - (2) An installation of the transition fairing.

TASK 57-31-25-010-801

2. **Transition Fairing Removal**

(Figure 401)

A. **General**

- (1) This task gives instructions to remove the transition fairing from the left or right winglet.

B. **References**

Reference	Title
20-40-11-910-801	Static Grounding (P/B 201)
27-81-00-040-801	Leading Edge Flaps and Slats - Deactivation (P/B 201)

C. **Tools/Equipment**

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
COM-659	Platform - Maintenance Lift, 3 ft Minimum Height, 12.5 ft Maximum Height Part #: 1135-8000 Supplier: 00994 Opt Part #: 8662-010 Supplier: 00994
COM-2480	Platform - Mobile Elevating Work Platform SJ III Series Part #: SJIII 4726 Supplier: 3AF08 Part #: SJIII 4732 Supplier: 3AF08 Opt Part #: SJIII 4620 Supplier: 3AF08 Opt Part #: SJIII 4626 Supplier: 3AF08 Opt Part #: SJIII 4632 Supplier: 3AF08
STD-1064	Scraper - Phenolic, Hard Resin

D. **Location Zones**

Zone	Area
527	Left Winglet
627	Right Winglet

E. **Access Panels**

Number	Name/Location
527AL	ACCESS PANEL - TRANSITION FAIRING, WINGLET
627AR	ACCESS PANEL - TRANSITION FAIRING, WINGLET

F. **Prepare for the Removal**

SUBTASK 57-31-25-860-001

- (1) Make sure that the airplane is correctly grounded (TASK 20-40-11-910-801).

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SUBTASK 57-31-25-040-001



WARNING

DO THE DEACTIVATION PROCEDURE FOR THE LEADING EDGE FLAPS. THE ACCIDENTAL MOVEMENT OF THE FLAPS CAN CAUSE INJURY TO PERSONS AND DAMAGE TO EQUIPMENT.

- (2) Do this task: Leading Edge Flaps and Slats - Deactivation, TASK 27-81-00-040-801.

SUBTASK 57-31-25-940-001

- (3) Get a ladder, work platform, COM-2480, or maintenance platform, COM-659.

SUBTASK 57-31-25-940-002

- (4) Do these steps to prepare metal support equipment such as work platforms, work/maintenance stands, ladders:

NOTE: These steps apply to all metal support equipment within a 50 ft (15 m) radius of an open fuel tank.

- (a) All support equipment must be in place before you begin the procedure.
- (b) Bond the support equipment at an approved airplane bonding location.
- (c) Ground the support equipment to the same earth ground as the airplane.

G. Transition Fairing Removal

SUBTASK 57-31-25-020-001

- (1) Remove the applicable fairings:

<u>Number</u>	<u>Name/Location</u>
527AL	ACCESS PANEL - TRANSITION FAIRING, WINGLET
627AR	ACCESS PANEL - TRANSITION FAIRING, WINGLET

- (a) Remove the bolts [2], bolts [3], and bolts [4] from the transition fairing [1].
- 1) Store the bolts in a bag for the installation procedure.



CAUTION

BE CAREFUL IF YOU USE A HARD RESIN PHENOLIC SCRAPER TO REMOVE SEALANTS AND COMPOUNDS TO DISCONNECT THE FAIRINGS BETWEEN THE WING AND THE WINGLET. IF YOU ARE NOT CAREFUL, DAMAGE TO THE EROSION PROTECTION TAPE CAN OCCUR.

- (b) Remove the sealant around the transition fairing [1] with a hard resin phenolic scraper, STD-1064.
- (c) Remove the transition fairing [1] from the winglet.

————— **END OF TASK** —————

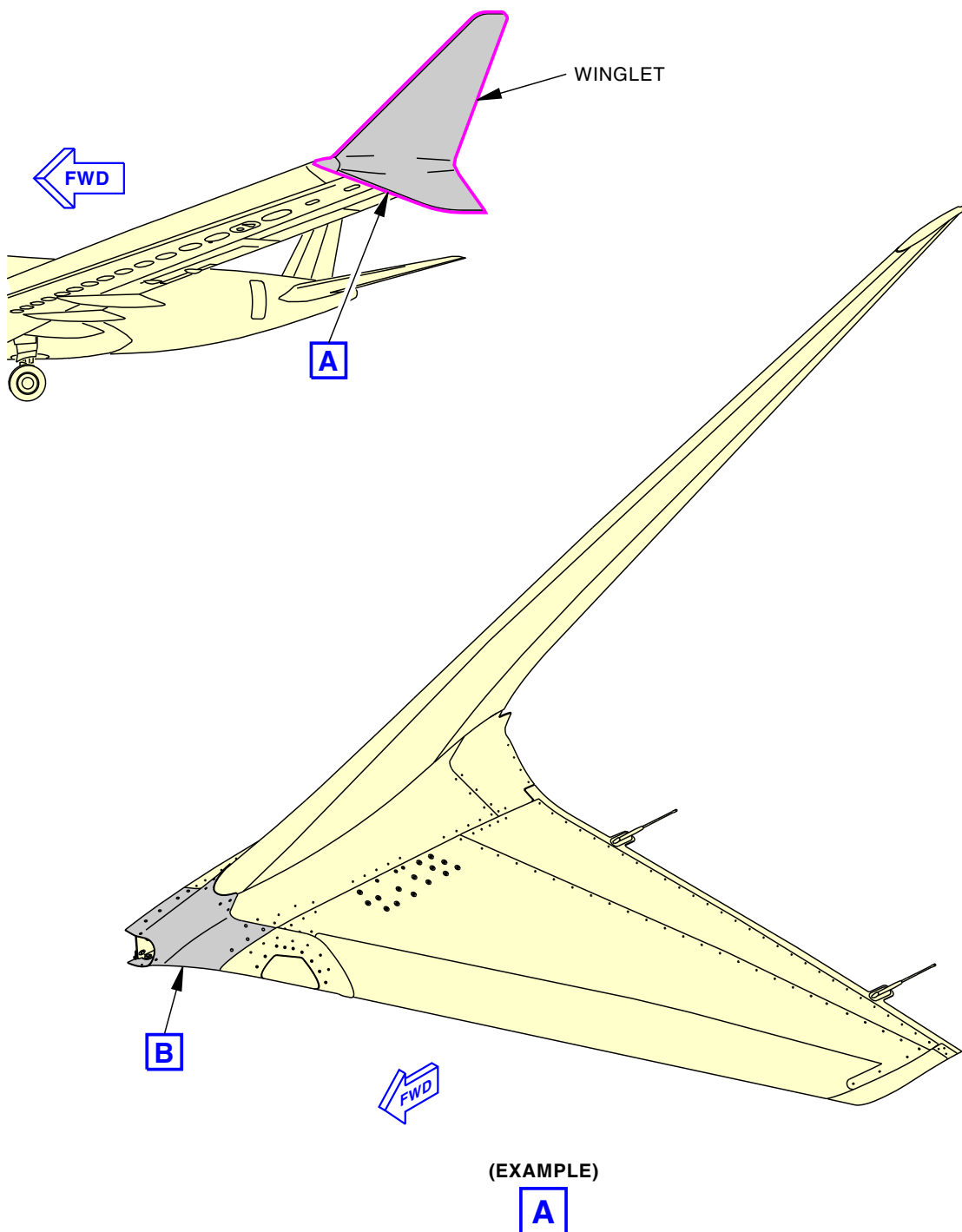
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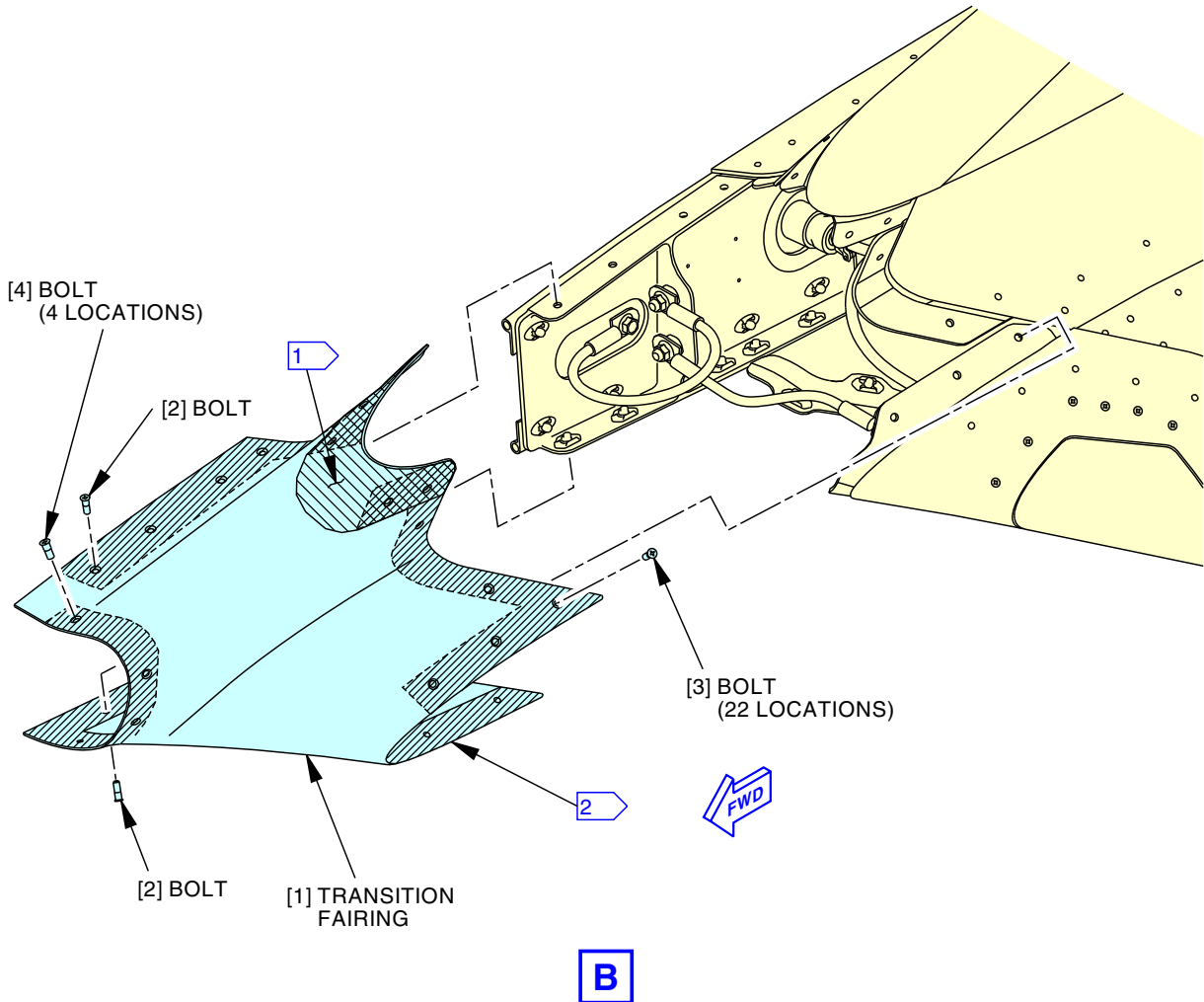
Transition Fairing Installation
Figure 401/57-31-25-990-801 (Sheet 1 of 2)

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- [1] OPTIONAL. APPLY PARTING AGENT, 
- [2] APPLY CORROSION INHIBITING COMPOUND, 

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Transition Fairing Installation
Figure 401/57-31-25-990-801 (Sheet 2 of 2)

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TASK 57-31-25-410-801

3. Transition Fairing Installation

(Figure 401)

A. General

(1) This task gives instructions to install the transition fairing to the left or right winglet.

B. References

Reference	Title
20-50-11-910-801	Standard Torque Values (P/B 201)
27-81-00-040-801	Leading Edge Flaps and Slats - Deactivation (P/B 201)
27-81-00-440-801	Leading Edge Flaps and Slats - Activation (P/B 201)
57-31-21-390-801	Winglet Aerodynamic Sealant Repair (P/B 801)
57-31-24-200-801	Winglet Erosion Protection Inspection (P/B 601)
SWPM 20-20-00	ELECTRICAL BONDING PROCESSES

C. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
COM-614	Bonding Meters - Non-Intrinsically Safe (For use in outside Class I, Divisions I & II non-hazardous locations. For hazardous locations, use COM-1550). Part #: 247000 Supplier: 00426 Part #: 620LK Supplier: 1CRL2 Part #: BLR-0003-XX Supplier: KC432 Part #: BT51 Supplier: 00426 Part #: M1 Supplier: 3AD17 Part #: M1B Supplier: 3AD17 Part #: T477W (C15292) Supplier: 06659 Opt Part #: 247001 Supplier: 00426
COM-659	Platform - Maintenance Lift, 3 ft Minimum Height, 12.5 ft Maximum Height Part #: 1135-8000 Supplier: 00994 Opt Part #: 8662-010 Supplier: 00994
COM-2480	Platform - Mobile Elevating Work Platform SJ III Series Part #: SJIII 4726 Supplier: 3AF08 Part #: SJIII 4732 Supplier: 3AF08 Opt Part #: SJIII 4620 Supplier: 3AF08 Opt Part #: SJIII 4626 Supplier: 3AF08 Opt Part #: SJIII 4632 Supplier: 3AF08

D. Consumable Materials

Reference	Description	Specification
A02315	Sealant - Low Density, Synthetic Rubber. 2 Part	BMS5-142 Type II
A50110	Sealant - Fuel Tank	BMS5-45 Class B-2
A50528	Sealant - Fast Cure	BMS5-184
G50136	Compound - Corrosion Inhibiting, Non-drying Paste	BMS3-38

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Reference	Description	Specification
G50337	Shim - Laminated Polyimide, Square And Rectangular	BACS40V
G50367	Agent - Peelable Parting (Aztec Chemical AZ 634-2)	MIL-PRF-6799, BAC5000
G50368	Agent - Peelable Parting (Rexco Chemical Company - Partall Coverall Film)	BAC5000

E. Location Zones

Zone	Area
527	Left Winglet
627	Right Winglet

F. Access Panels

Number	Name/Location
527AL	ACCESS PANEL - TRANSITION FAIRING, WINGLET
627AR	ACCESS PANEL - TRANSITION FAIRING, WINGLET

G. Prepare for the Installation

SUBTASK 57-31-25-040-002



WARNING

DO THE DEACTIVATION PROCEDURE FOR THE LEADING EDGE FLAPS. THE ACCIDENTAL MOVEMENT OF THE FLAPS CAN CAUSE INJURY TO PERSONS AND DAMAGE TO EQUIPMENT.

- (1) If the leading edge flaps and slats have not been deactivated, do this task: Leading Edge Flaps and Slats - Deactivation, TASK 27-81-00-040-801.

SUBTASK 57-31-25-210-001

- (2) Make sure that the erosion protective film is in serviceable condition (TASK 57-31-24-200-801).

H. Transition Fairing Installation

SUBTASK 57-31-25-420-001

- (1) Install the applicable fairings:

Number	Name/Location
527AL	ACCESS PANEL - TRANSITION FAIRING, WINGLET
627AR	ACCESS PANEL - TRANSITION FAIRING, WINGLET

- (a) If it is necessary, apply AZ 634-2 peelable parting agent, G50367, or Rexco Partall Coverall Film peelable parting agent, G50368, to the transition fairing [1] surfaces that are common to the upper blade structure of the winglet.

NOTE: The application of the parting agent is optional.

- (b) Apply corrosion inhibiting material, G50136, inside of the transition fairing [1] to all areas of the holes.
- (c) Apply sealant, A50110, to the necessary areas of the transition fairing [1] (TASK 57-31-21-390-801).
- (d) Make sure that there is a clearance of 0.020 in. (0.508 mm) or less between the transition fairing [1] and substructure.
- 1) Install shims, G50337, if the clearance is greater than 0.020 in. (0.508 mm).

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- a) Apply corrosion inhibiting material, G50136, to both sides of the shim, G50337.
- b) Keep a 1.5D minimum edge margin.
- c) Attach shim, G50337, with at least two fasteners.
- (e) Install the bolts [2], bolts [3], and bolts [4] to the transition fairing [1].
- (f) Tighten the bolts [4] to 30 in-lb (3.4 N·m) (TASK 20-50-11-910-801).
- (g) Tighten the bolts [3] to 10 in-lb (1 N·m) - 15 in-lb (2 N·m) (TASK 20-50-11-910-801).
- (h) Tighten the bolts [2] to 10 in-lb (1 N·m) - 15 in-lb (2 N·m) (TASK 20-50-11-910-801).
- (i) Measure the electrical bonding resistance between bolt [2] head and structure (SWPM 20-20-00).
 - 1) Use a non-intrinsically safe bonding meter, COM-614.
 - 2) Make sure that the electrical bonding resistance is 0.001 ohm (1.0 milliohms) or less.
- (j) Apply sealant, A02315, or sealant, A50528, to the necessary areas of the transition fairing [1] (TASK 57-31-21-390-801).

I. Put the Airplane Back to Its Usual Condition

SUBTASK 57-31-25-860-004

- (1) Remove the ladders, work platform, COM-2480, or maintenance platform, COM-659.

SUBTASK 57-31-25-440-001

- (2) Do this task: Leading Edge Flaps and Slats - Activation, TASK 27-81-00-440-801.

———— **END OF TASK** ————

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WING LEADING EDGE - CORROSION PREVENTION

1. **General**

- A. Stress corrosion cracking can occur in the hinge support ribs of the inboard leading edge flaps. Most of the cracks can occur along the fastener line through the inboard and outboard flanges of the ribs, and also at the flange radius. The rib webs are considered susceptible to stress corrosion cracks.
- B. Severe exfoliation corrosion can occur on the leading edge slat ribs. Ribs at main track attach point were corroded through the web. The rib at actuator attach point was also severely corroded.
- C. Stress corrosion cracks can occur in the flanges of the slat track roller support ribs attached to the leading edge of the wing front spar.
- D. Stress corrosion cracking can occur on the slat actuator support fittings.

TASK 57-41-00-910-801

2. **Wing Leading Edge - Corrosion Prevention**

A. **General**

- (1) Make the regular inspection to prevent or find the start of corrosion. Missing fasteners, white powdery, or other corrosion deposits are signs of corrosion. Initiate the corrosion prevention practices to decrease the occurrence of corrosion.
- (2) Following cleaning of suspected areas PAGEBLOCK 51-21-31/701, a full inspection is effective to ensure that protective finishes provided during manufacture remain intact.
- (3) Where corrosion exists (noticeable bulges of the skin or white deposits of corrosion products at fastener heads or joint edges), refer to Structural Repair Manual for details of corrosion removal.
- (4) For minor corrosion, to minimize the downtime of the airplane, the corrosion products should be cleaned off, followed by the application of a corrosion inhibiting compound into the affected area to decrease the corrosion process. Refer to PAGEBLOCK 51-21-91/701 for details on applying corrosion inhibiting compound. The finish system should be repaired at the next maintenance opportunity.

B. **References**

Reference	Title
51-21-31 P/B 701	CORROSION REMOVAL AND CONTROL - CLEANING/PAINTING
51-21-91 P/B 701	CORROSION INHIBITING COMPOUND - CLEANING/PAINTING

C. **Consumable Materials**

Reference	Description	Specification
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23

D. **Location Zones**

Zone	Area
511	Left Wing - Leading Edge To Front Spar
521	Left Wing - Leading Edge to Front Spar
611	Right Wing - Leading Edge to Front Spar
621	Right Wing - Leading Edge to Front Spar

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E. Procedure

SUBTASK 57-41-00-370-001

- (1) At the next maintenance opportunity, apply corrosion prevention treatment to the wing leading edge.

SUBTASK 57-41-00-200-001

- (2) Periodically inspect the leading edge slat rib webs and flanges for evidence of corrosion.

SUBTASK 57-41-00-370-002



DO NOT APPLY CORROSION INHIBITING COMPOUND ON GREASED JOINTS OR SEALED BEARINGS. THESE COMPOUNDS DISSOLVE GREASE AND OTHER LUBRICANTS. THEY ARE PENETRATING COMPOUNDS AND CAN GET AROUND THE SEALS AND INTO THE BEARINGS.

- (3) Apply corrosion inhibiting compound, G00009 to slat ribs, hinge support ribs, and seat track roller support ribs.

SUBTASK 57-41-00-370-003

(4) Frequency of Application

- (a) Periodic inspection is required in areas identified as susceptible to corrosion and should be consistent to the schedules specified in the Maintenance Planning Document. Operators must be aware of reported problems and areas of occurrences.
- (b) Periodic application of corrosion inhibiting compound, G00009 is necessary to areas identified and should be consistent to the schedule specified in the Maintenance Planning Document.

———— **END OF TASK** ————

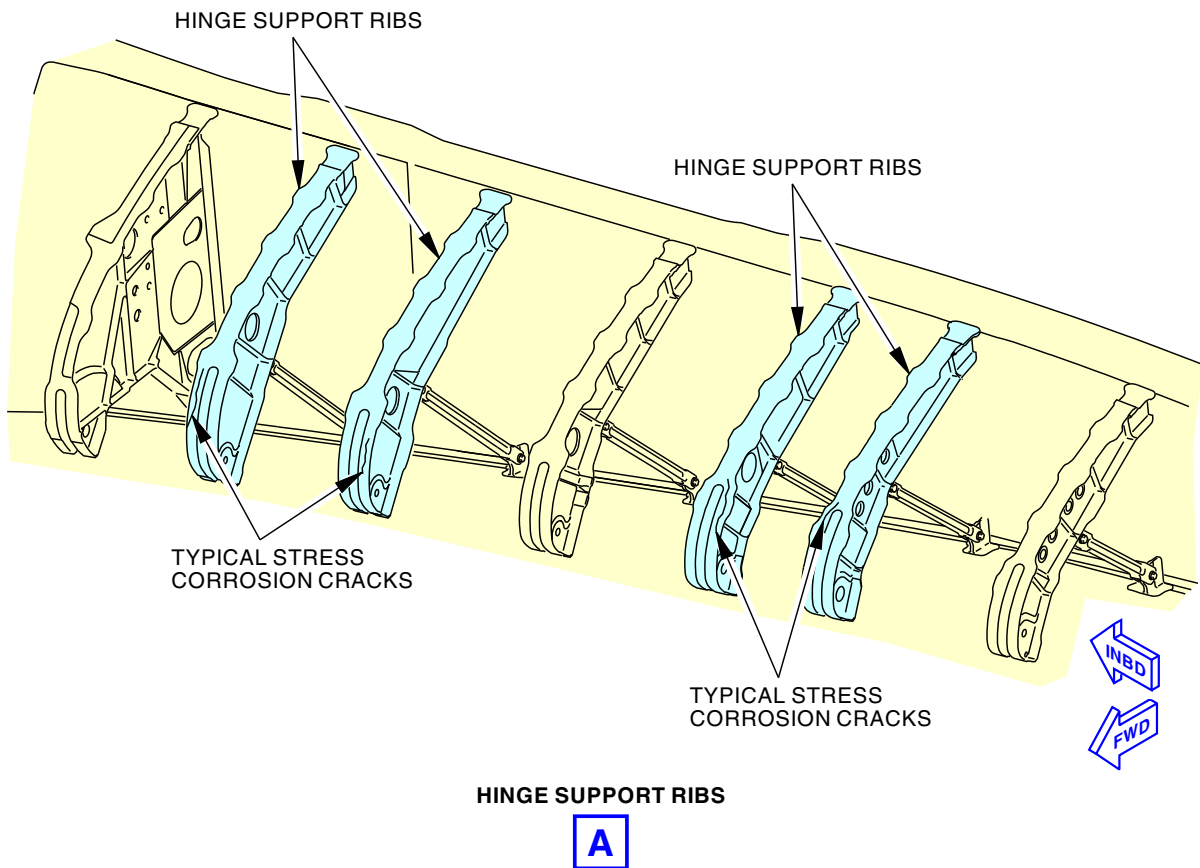
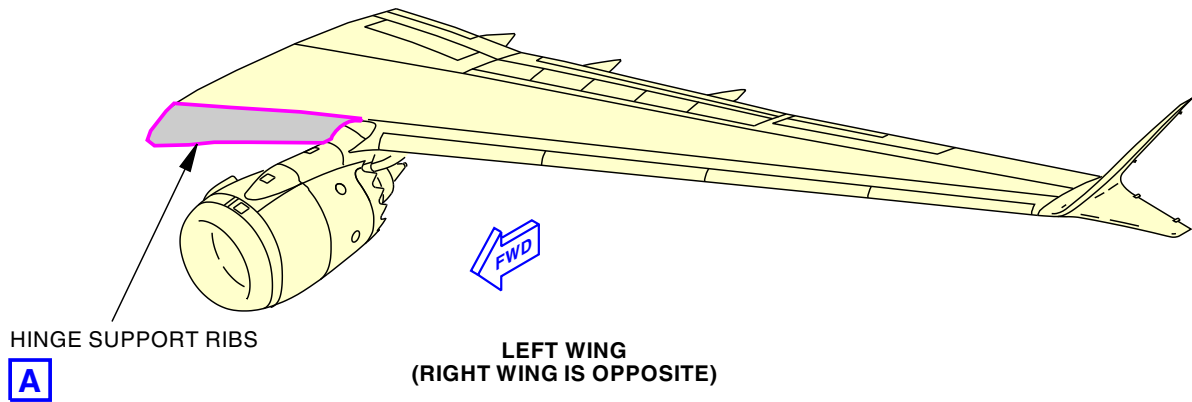
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Wing Leading Edge - Corrosion Prevention
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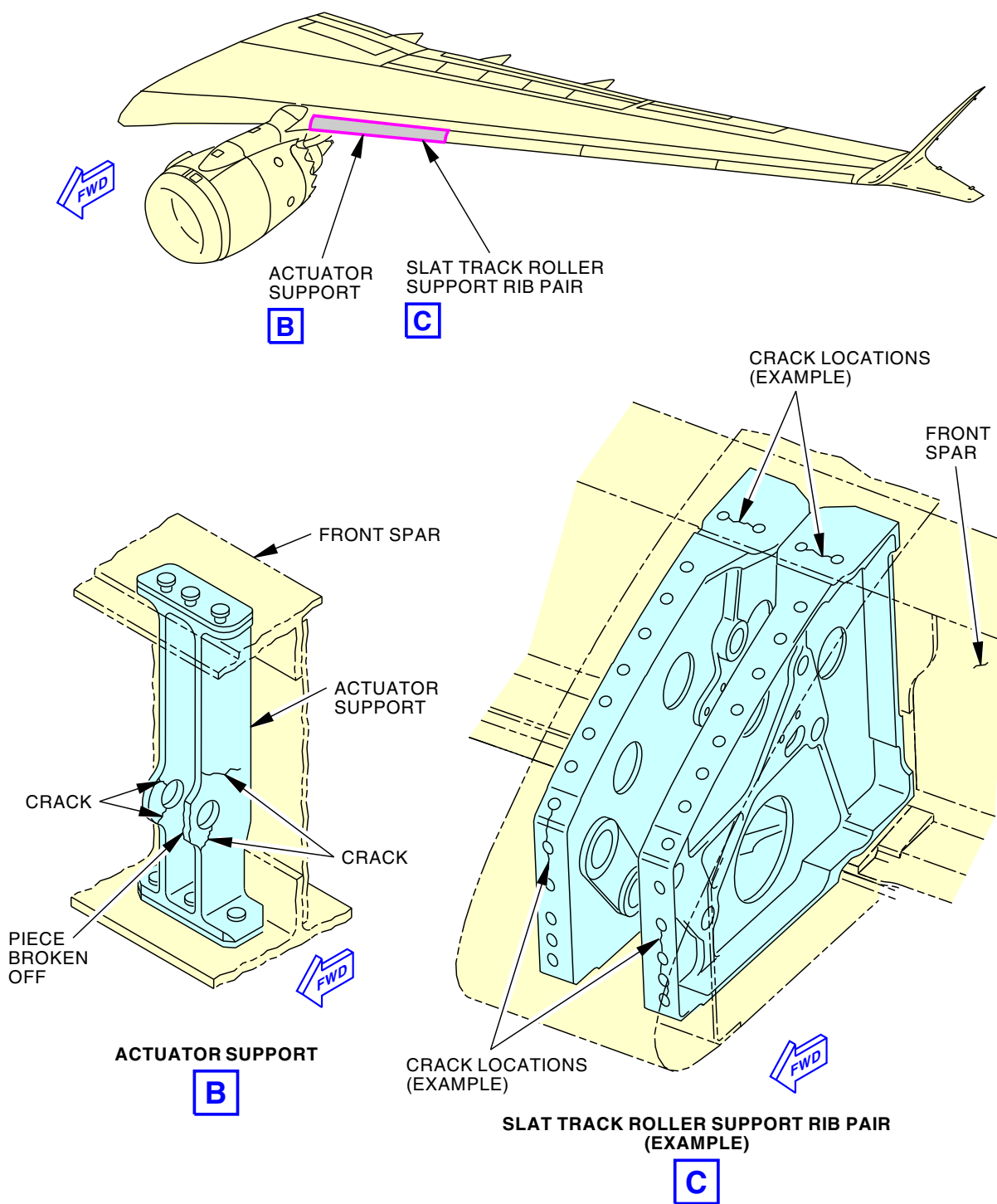
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Wing Leading Edge - Corrosion Prevention
Figure 201/57-41-00-990-801 (Sheet 2 of 3)

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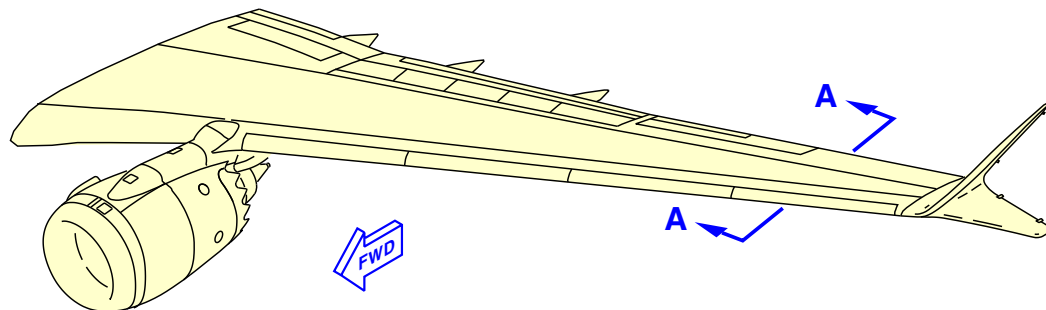
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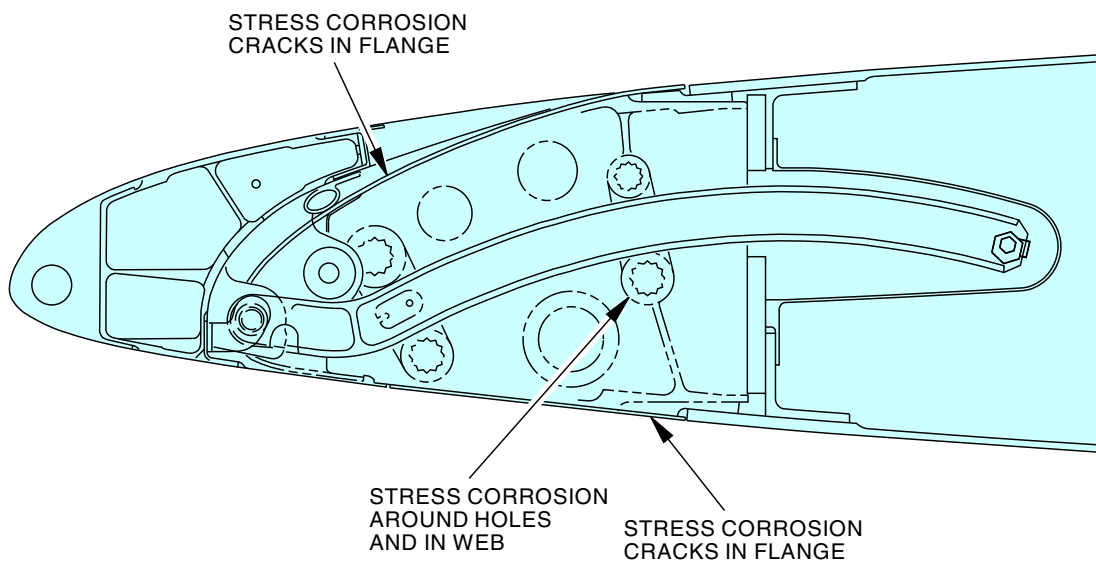
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LEFT WING
(RIGHT WING IS OPPOSITE)



LEADING EDGE SLAT TRACK
ROLLER SUPPORT RIB
(EXAMPLE)

A-A

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Wing Leading Edge - Corrosion Prevention
Figure 201/57-41-00-990-801 (Sheet 3 of 3)

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LEADING EDGE ACCESS PANELS - MAINTENANCE PRACTICES

1. General

- A. This procedure has these tasks:
- (1) Leading edge access panel removal
 - (2) Leading edge access panel installation
- B. There are access panels aft of the leading edge which gives access to the wing forward spar.

TASK 57-41-02-000-801

2. Leading Edge Access Panel Removal

A. **General**

- (1) This procedure gives the task for the removal of the access panels on the lower and upper surfaces of the wing leading edge.
- (2) This task has one or more steps which are a means to satisfy Critical Design Configuration Control Limitation (CDCCL) requirements. A CDCCL note will follow the step to which it applies. Any step or sub-step that precedes or follows a CDCCL identified step is not subject to the CDCCL requirement.
 - (a) For important information on CDCCL requirements, refer to this task: Airworthiness Limitation Precautions, TASK 57-00-00-910-802.

NOTE: This is applicable to Airworthiness Limitation 28-AWL-02.

B. **References**

Reference	Title
06-44-00-800-801	Finding an Access Door or Panel on the Wings (P/B 201)
27-51-00-040-801	Trailing Edge Flap System Deactivation (P/B 201)
27-81-00-040-801	Leading Edge Flaps and Slats - Deactivation (P/B 201)
28-11-00-211-802	External Wires Mounted Near the Forward Wing Spar Inspection (P/B 601)
57-00-00-910-802	Airworthiness Limitation Precautions (P/B 201)

C. **Tools/Equipment**

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
COM-659	Platform - Maintenance Lift, 3 ft Minimum Height, 12.5 ft Maximum Height Part #: 1135-8000 Supplier: 00994 Opt Part #: 8662-010 Supplier: 00994
COM-2480	Platform - Mobile Elevating Work Platform SJ III Series Part #: SJIII 4726 Supplier: 3AF08 Part #: SJIII 4732 Supplier: 3AF08 Opt Part #: SJIII 4620 Supplier: 3AF08 Opt Part #: SJIII 4626 Supplier: 3AF08 Opt Part #: SJIII 4632 Supplier: 3AF08

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Reference	Description
SPL-1558	Adapter - Access Panel, Leverage Part #: 3008-550 Supplier: 55856 Part #: B20004-42 Supplier: 81205 Opt Part #: B20004-21 Supplier: 81205
STD-1265	Screwdriver - #3 Phillips ACR

D. Location Zones

Zone	Area
500	Left Wing
511	Left Wing - Leading Edge To Front Spar
521	Left Wing - Leading Edge to Front Spar
600	Right Wing
611	Right Wing - Leading Edge to Front Spar
621	Right Wing - Leading Edge to Front Spar

E. Access Panels

Number	Name/Location
511AB	Inboard Leading Edge, Lower Removable Panel
521AAB	Lower Leading Edge Access Panel - Slat Station 497
521AB	Outboard Leading Edge Blowout Door - Slat Station 20
521ABB	Lower Leading Edge Access Panel-Slat Station 519
521AT	Outbd Leading Edge - Gap Cover Access
521BB	Engine Fuel Valve Shutoff Access Panel - Slat Station 27
521BT	ACCESS PANEL- UPPER LEADING EDGE PANEL
521CB	Lower Leading Edge Access Panel - Slat Station 50
521DB	Lower Leading Edge Access Panel - Slat Station 70
521EB	Lower Leading Edge Access Panel - Slat Station 91
521FB	Lower Leading Edge Access Panel - Slat Station 107
521GB	Lower Leading Edge Access Panel - Slat Station 125
521HB	Lower Leading Edge Access Panel - Slat Station 144
521JB	Lower Leading Edge Access Panel - Slat Station 161
521KB	Lower Leading Edge Access Panel - Slat Station 179
521LB	Lower Leading Edge Access Panel - Slat Station 208
521MB	Lower Leading Edge Access Panel - Slat Station 226
521NB	Lower Leading Edge Access Panel - Slat Station 244
521PB	Lower Leading Edge Access Panel - Slat Station 261
521QB	Lower Leading Edge Access Panel - Slat Station 280
521RB	Lower Leading Edge Access Panel - Slat Station 298
521SB	Lower Leading Edge Access Panel - Slat Station 328
521TB	Lower Leading Edge Access Panel - Slat Station 347
521UB	Lower Leading Edge Access Panel - Slat Station 365
521VB	Lower Leading Edge Access Panel - Slat Station 385
521WB	Lower Leading Edge Access Panel - Slat Station 406
521XB	Lower Leading Edge Access Panel - Slat Station 425
521YB	Lower Leading Edge Access Panel - Slat Station 470

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Number	Name/Location
521ZB	Lower Leading Edge Access Panel - Slat Station 479
611AB	Inboard Leading Edge, Lower Removable Access Panel
621AAB	Lower Leading Edge Access Panel - Slat Station 524.31
621AB	Outboard Leading Edge Blowout Door - Slat Station 20
621ABB	Lower Leading Edge Access Panel-Slat Station 519
621AT	Outbd Leading Edge - Gap Cover Access
621BB	Engine Fuel Valve Shutoff Access Panel - Slat Station 27
621BT	UPPER LEADING EDGE ACCESS PANEL
621CB	Lower Leading Edge Access Panel - Slat Station 50
621DB	Lower Leading Edge Access Panel - Slat Station 70
621EB	Lower Leading Edge Access Panel - Slat Station 91
621FB	Lower Leading Edge Access Panel - Slat Station 107
621GB	Refuel Valve Door - Slat Station 125
621JB	Lower Leading Edge Access Panel - Slat Station 161
621KB	Lower Leading Edge Access Panel - Slat Station 179
621LB	Lower Leading Edge Access Panel - Slat Station 208
621MB	Lower Leading Edge Access Panel - Slat Station 226
621NB	Lower Leading Edge Access Panel - Slat Station 244
621PB	Lower Leading Edge Access Panel - Slat Station 261
621QB	Lower Leading Edge Access Panel - Slat Station 280
621RB	Lower Leading Edge Access Panel - Slat Station 298
621SB	Lower Leading Edge Access Panel - Slat Station 328
621TB	Lower Leading Edge Access Panel - Slat Station 347
621UB	Lower Leading Edge Access Panel - Slat Station 365
621VB	Lower Leading Edge Access Panel - Slat Station 385
621WB	Lower Leading Edge Access Panel - Slat Station 406
621XB	Lower Leading Edge Access Panel - Slat Station 425
621YB	Lower Leading Edge Access Panel - Slat Station 470
621ZB	Lower Leading Edge Access Panel - Slat Station 479

F. Prepare for the Removal

SUBTASK 57-41-02-040-001

- (1) Do this task: Trailing Edge Flap System Deactivation, TASK 27-51-00-040-801.

SUBTASK 57-41-02-040-002

- (2) Do this task: Leading Edge Flaps and Slats - Deactivation, TASK 27-81-00-040-801.

SUBTASK 57-41-02-490-001

- (3) Get a ladder, work platform, COM-2480 or maintenance platform, COM-659.

SUBTASK 57-41-02-490-002

- (4) Do these steps to prepare metal support equipment such as work platforms, work/maintenance stands, ladders.

NOTE: These steps apply to all metal support equipment within a 50-foot radius of an open fuel tank.

- (a) All support equipment must be in place before you begin the procedure.

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- (b) Bond the support equipment at an approved airplane bonding location.
- (c) Ground the support equipment to the same earth ground as the airplane.

SUBTASK 57-41-02-860-001

- (5) To help you find the applicable leading edge panel, refer to Finding an Access Door or Panel on the Wings, TASK 06-44-00-800-801.

SUBTASK 57-41-02-490-003

- (6) Get these tools to remove the bolts from the access panels:

NOTE: These tools are for corroded fasteners that are difficult to remove.

- (a) A leverage access panel adapter, SPL-1558 with a customer furnished, removal anti cam-out ribbed (ACR) bit and socket.
- (b) A phillips screwdriver, STD-1265 with a removal anti cam-out ribbed (ACR) bit (customer furnished).

NOTE: The ACR bit should have a hardness of 56-58 RC. A combination removal/installation ACR bit is not recommended.

- (c) Apply a fastener removal compound on the driver bit if a fastener is difficult to remove.

G. Leading Edge Access Panel Removal

SUBTASK 57-41-02-020-001

- (1) Remove the access panel (Figure 201).
 - (a) For the left wing, remove these access panels.

<u>Number</u>	<u>Name/Location</u>
511AB	Inboard Leading Edge, Lower Removable Panel
521AAB	Lower Leading Edge Access Panel - Slat Station 497
521AB	Outboard Leading Edge Blowout Door - Slat Station 20
521ABB	Lower Leading Edge Access Panel-Slat Station 519
521AT	Outbd Leading Edge - Gap Cover Access
521BB	Engine Fuel Valve Shutoff Access Panel - Slat Station 27
521BT	ACCESS PANEL- UPPER LEADING EDGE PANEL
521CB	Lower Leading Edge Access Panel - Slat Station 50
521DB	Lower Leading Edge Access Panel - Slat Station 70
521EB	Lower Leading Edge Access Panel - Slat Station 91
521FB	Lower Leading Edge Access Panel - Slat Station 107
521GB	Lower Leading Edge Access Panel - Slat Station 125
521HB	Lower Leading Edge Access Panel - Slat Station 144
521JB	Lower Leading Edge Access Panel - Slat Station 161
521KB	Lower Leading Edge Access Panel - Slat Station 179
521LB	Lower Leading Edge Access Panel - Slat Station 208
521MB	Lower Leading Edge Access Panel - Slat Station 226
521NB	Lower Leading Edge Access Panel - Slat Station 244
521PB	Lower Leading Edge Access Panel - Slat Station 261
521QB	Lower Leading Edge Access Panel - Slat Station 280
521RB	Lower Leading Edge Access Panel - Slat Station 298
521SB	Lower Leading Edge Access Panel - Slat Station 328
521TB	Lower Leading Edge Access Panel - Slat Station 347
521UB	Lower Leading Edge Access Panel - Slat Station 365
521VB	Lower Leading Edge Access Panel - Slat Station 385

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<u>Number</u>	<u>Name/Location</u>
521WB	Lower Leading Edge Access Panel - Slat Station 406
521XB	Lower Leading Edge Access Panel - Slat Station 425
521YB	Lower Leading Edge Access Panel - Slat Station 470
521ZB	Lower Leading Edge Access Panel - Slat Station 479

- (b) For the right wing, remove these access panels.

<u>Number</u>	<u>Name/Location</u>
611AB	Inboard Leading Edge, Lower Removable Access Panel
621AAB	Lower Leading Edge Access Panel - Slat Station 524.31
621AB	Outboard Leading Edge Blowout Door - Slat Station 20
621ABB	Lower Leading Edge Access Panel-Slat Station 519
621AT	Outbd Leading Edge - Gap Cover Access
621BB	Engine Fuel Valve Shutoff Access Panel - Slat Station 27
621BT	UPPER LEADING EDGE ACCESS PANEL
621CB	Lower Leading Edge Access Panel - Slat Station 50
621DB	Lower Leading Edge Access Panel - Slat Station 70
621EB	Lower Leading Edge Access Panel - Slat Station 91
621FB	Lower Leading Edge Access Panel - Slat Station 107
621GB	Refuel Valve Door - Slat Station 125
621JB	Lower Leading Edge Access Panel - Slat Station 161
621KB	Lower Leading Edge Access Panel - Slat Station 179
621LB	Lower Leading Edge Access Panel - Slat Station 208
621MB	Lower Leading Edge Access Panel - Slat Station 226
621NB	Lower Leading Edge Access Panel - Slat Station 244
621PB	Lower Leading Edge Access Panel - Slat Station 261
621QB	Lower Leading Edge Access Panel - Slat Station 280
621RB	Lower Leading Edge Access Panel - Slat Station 298
621SB	Lower Leading Edge Access Panel - Slat Station 328
621TB	Lower Leading Edge Access Panel - Slat Station 347
621UB	Lower Leading Edge Access Panel - Slat Station 365
621VB	Lower Leading Edge Access Panel - Slat Station 385
621WB	Lower Leading Edge Access Panel - Slat Station 406
621XB	Lower Leading Edge Access Panel - Slat Station 425
621YB	Lower Leading Edge Access Panel - Slat Station 470
621ZB	Lower Leading Edge Access Panel - Slat Station 479



DO NOT LET OBJECTS GET IN THE HOUSING ASSEMBLY OF THE SLAT TRACK. THIS WILL HELP PREVENT A PUNCTURE OF THE HOUSING ASSEMBLY THAT COULD CAUSE A FUEL LEAK. THE FUEL LEAK COULD CAUSE A FIRE AND POSSIBLE DEATH OR INJURY TO PERSONNEL.

- (c) Remove the bolt to remove the panel.

- 1) Identify and tag the bolts as you remove them from the holes with the hole location in the panel.

NOTE: The access panels have bolts with different grip lengths at different hole locations in the panel.

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- (d) Examine the area to make sure objects have not been left in the slat track housing assembly.

SUBTASK 57-41-02-010-001

 28-AWL-02: CDCCL

- (2) If you removed the panels to do maintenance, preventative maintenance, or alteration in any area within 12 in. (305 mm) from the fuel tanks (front spar), do these steps:

NOTE: CDCCL - Refer to the task: Airworthiness Limitation Precautions, TASK 57-00-00-910-802, for important information on Critical Design Configuration Control Limitations (CDCCLs).

NOTE: This is applicable to Airworthiness Limitation 28-AWL-02.

 28-AWL-02: CDCCL

- (a) Make sure you do not change the routing and clamping of the wires near the front spar.

NOTE: CDCCL - Refer to the task: Airworthiness Limitation Precautions, TASK 57-00-00-910-802, for important information on Critical Design Configuration Control Limitations (CDCCLs).

NOTE: This is applicable to Airworthiness Limitation 28-AWL-02.

 28-AWL-02: CDCCL

- (b) Before you install the panels, do this task only for the areas where you removed the panels and maintenance was performed: External Wires Mounted Near the Forward Wing Spar Inspection, TASK 28-11-00-211-802.

NOTE: CDCCL - Refer to the task: Airworthiness Limitation Precautions, TASK 57-00-00-910-802, for important information on Critical Design Configuration Control Limitations (CDCCLs).

NOTE: This is applicable to Airworthiness Limitation 28-AWL-02.

———— **END OF TASK** ————

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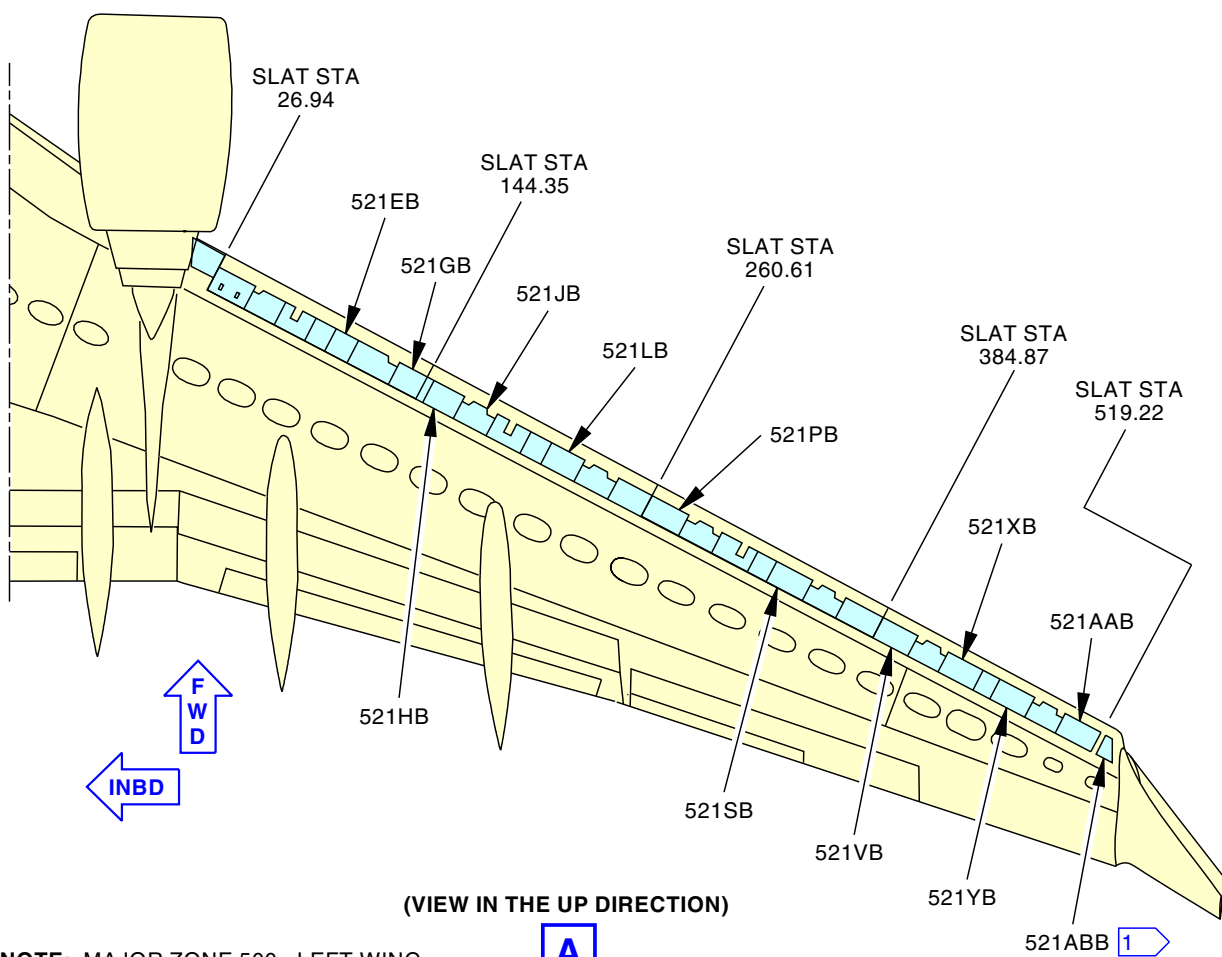
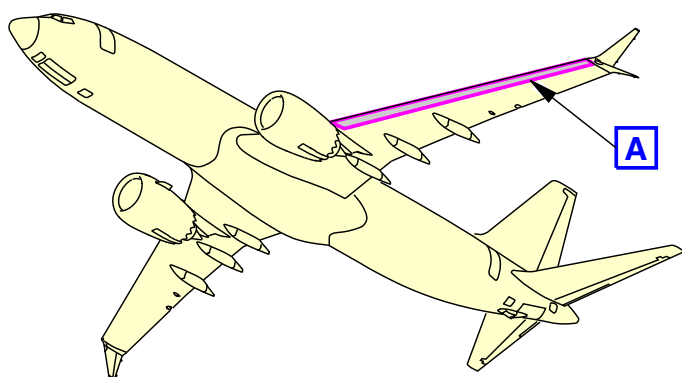
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NOTE: MAJOR ZONE 500 - LEFT WING.
MAJOR ZONE 600 - RIGHT WING.

1 THIS PANEL IS METALLIC

2416660 S00061541244_V3

Bonded Panels - Removal/Installation
Figure 201/57-41-02-990-801 (Sheet 1 of 4)

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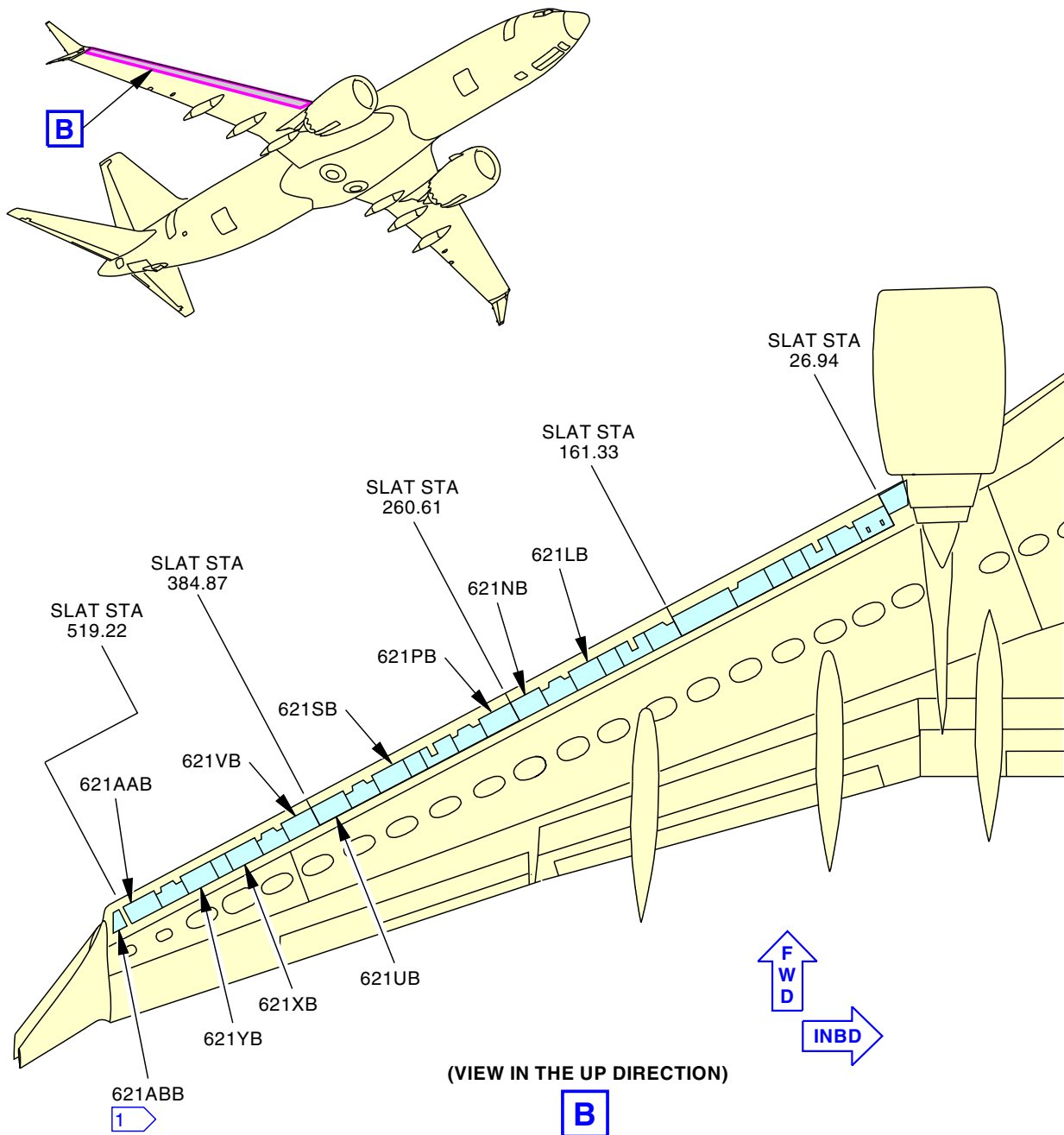
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NOTE:

MAJOR ZONE 500 - LEFT WING.
MAJOR ZONE 600 - RIGHT WING.

1 THIS PANEL IS METALLIC

2416661 S00061541245_V3

Bonded Panels - Removal/Installation
Figure 201/57-41-02-990-801 (Sheet 2 of 4)

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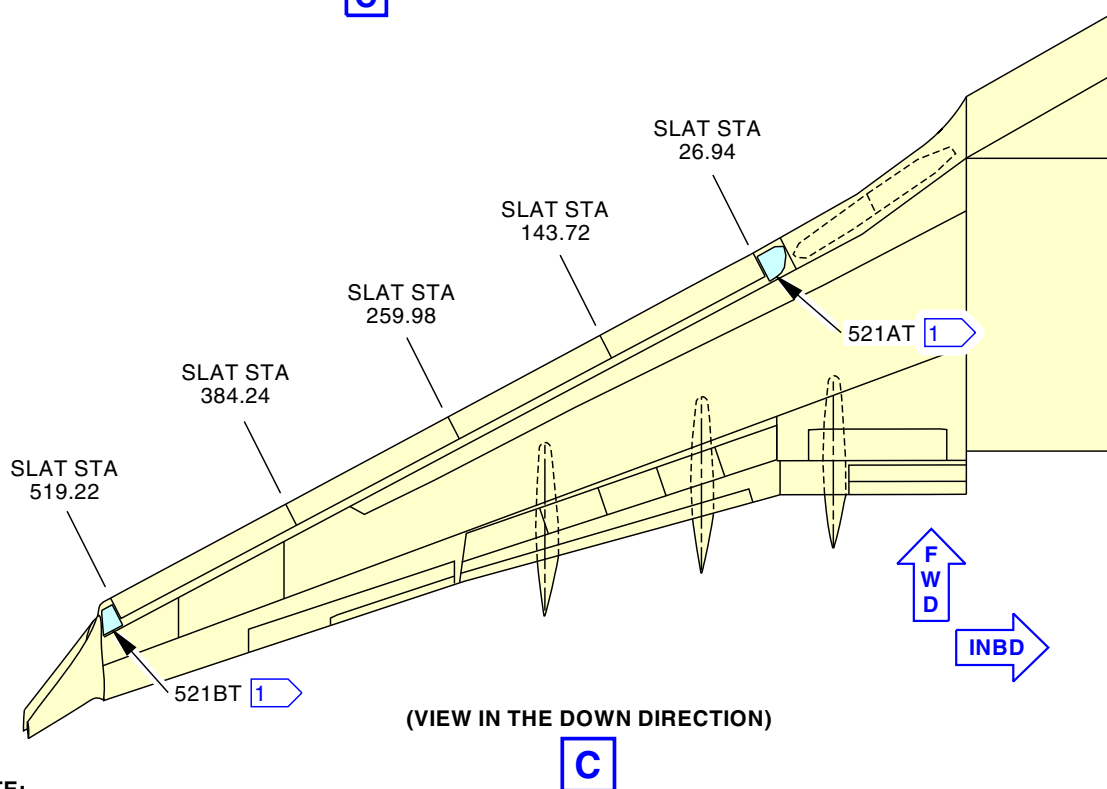
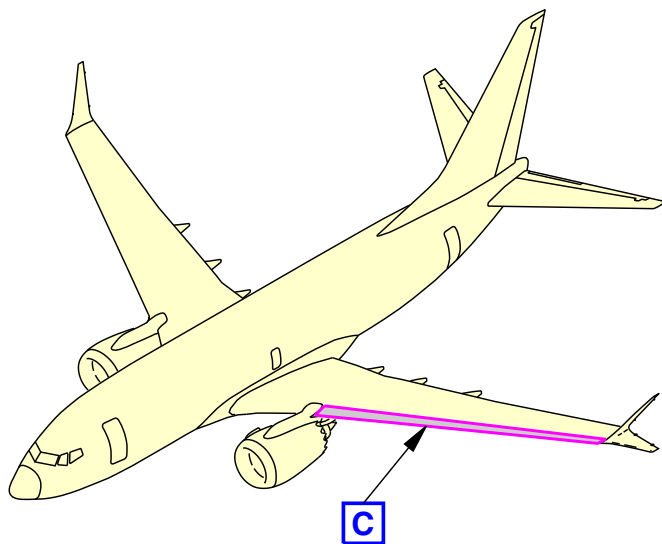
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NOTE:

MAJOR ZONE 500 - LEFT WING.
MAJOR ZONE 600 - RIGHT WING.

1 THIS PANEL IS METALLIC.

2465794 S0000575029_V1

Bonded Panels - Removal/Installation
Figure 201/57-41-02-990-801 (Sheet 3 of 4)

EFFECTIVITY
SIA ALL

D633AM101-SIA

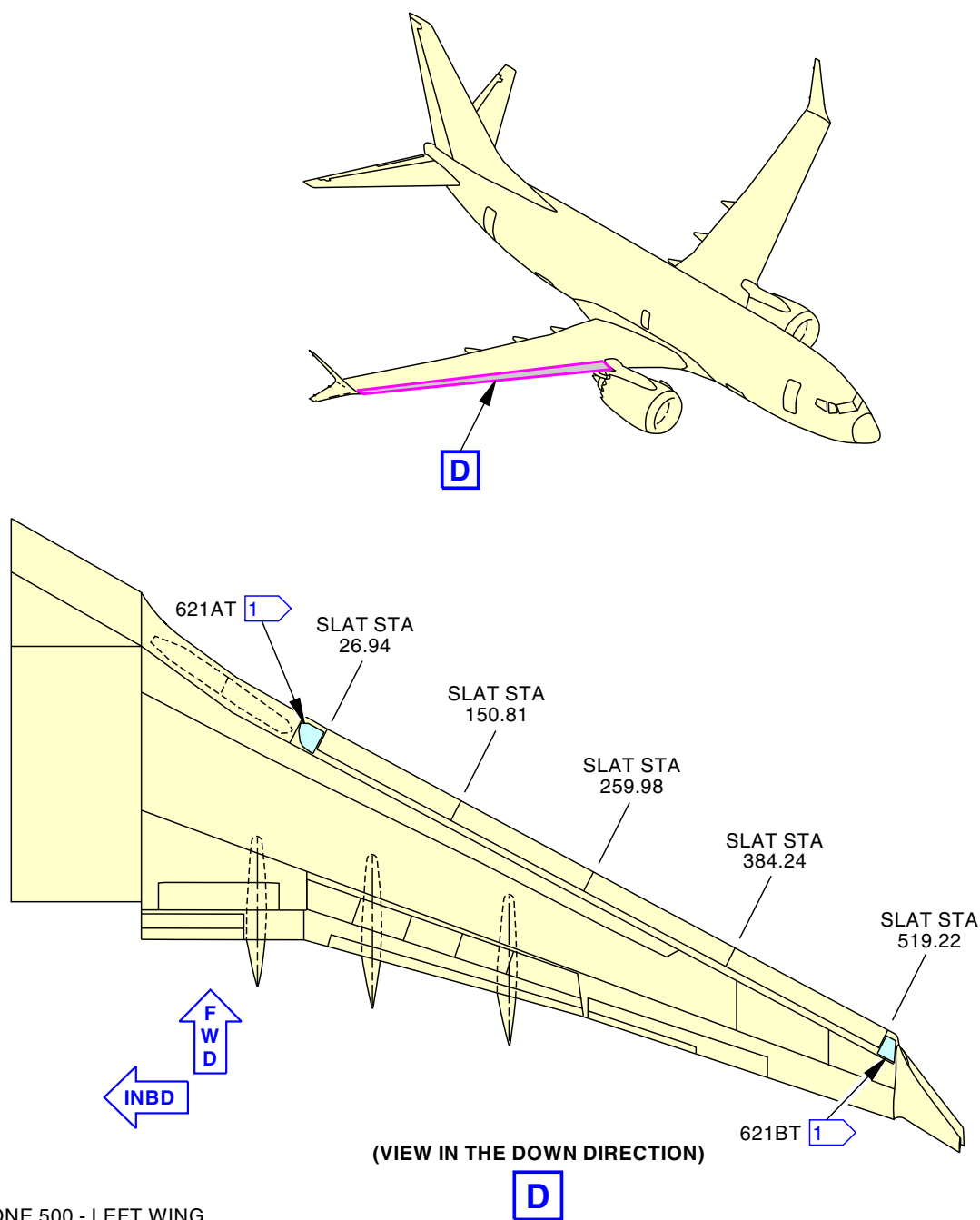
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NOTE:

MAJOR ZONE 500 - LEFT WING.
MAJOR ZONE 600 - RIGHT WING.

1 THIS PANEL IS METALLIC.

2465796 S0000575031_V1

Bonded Panels - Removal/Installation
Figure 201/57-41-02-990-801 (Sheet 4 of 4)

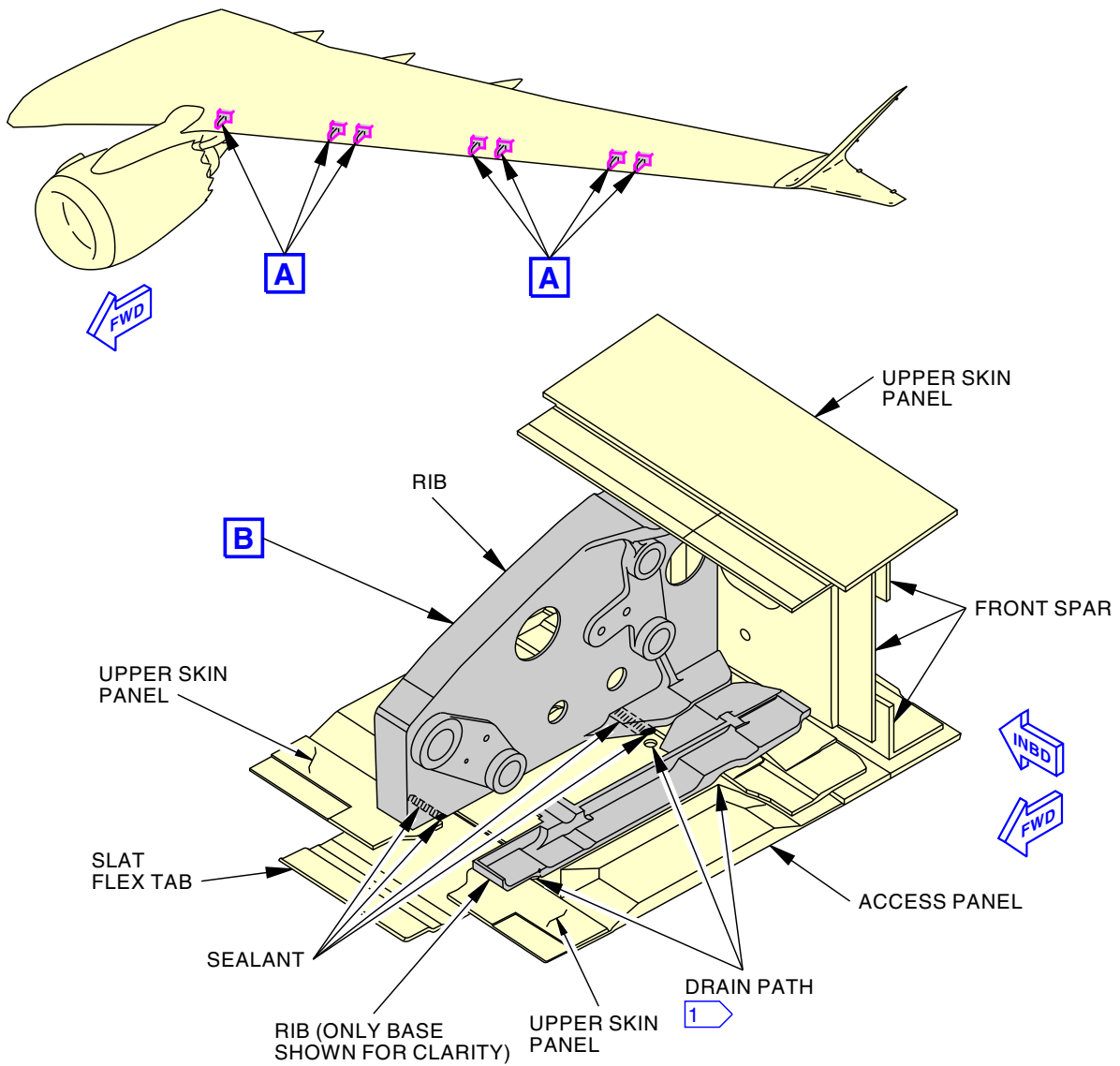
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MAIN SLAT TRACK PAIR
(STATIONS 47.69, 122.69, 163.95, 240.95, 282.91, 362.51 AND 409.09)

A

- 1 KEEP DRAIN PATH CLEAR OF SEALANT AND DEBIS
- 2 NO SEALANT IN THIS AREA FLUSH WITH EDGE OF PANEL

2416662 S00061541247_V1

Leading Edge Slat Track Ribs - Sealant Location
Figure 202/57-41-02-990-802 (Sheet 1 of 2)

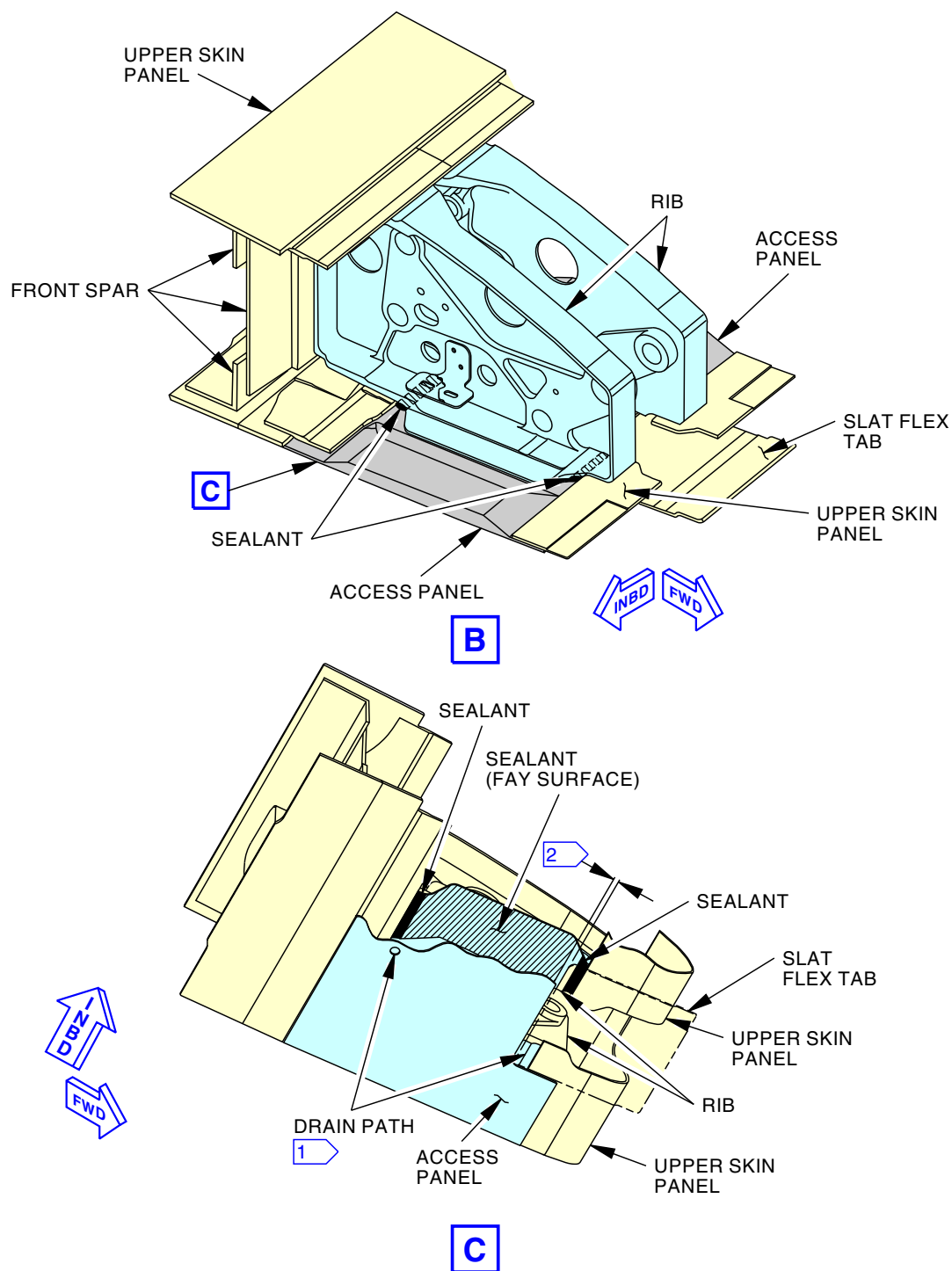
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2416663 S00061541248_V1

Leading Edge Slat Track Ribs - Sealant Location
Figure 202/57-41-02-990-802 (Sheet 2 of 2)

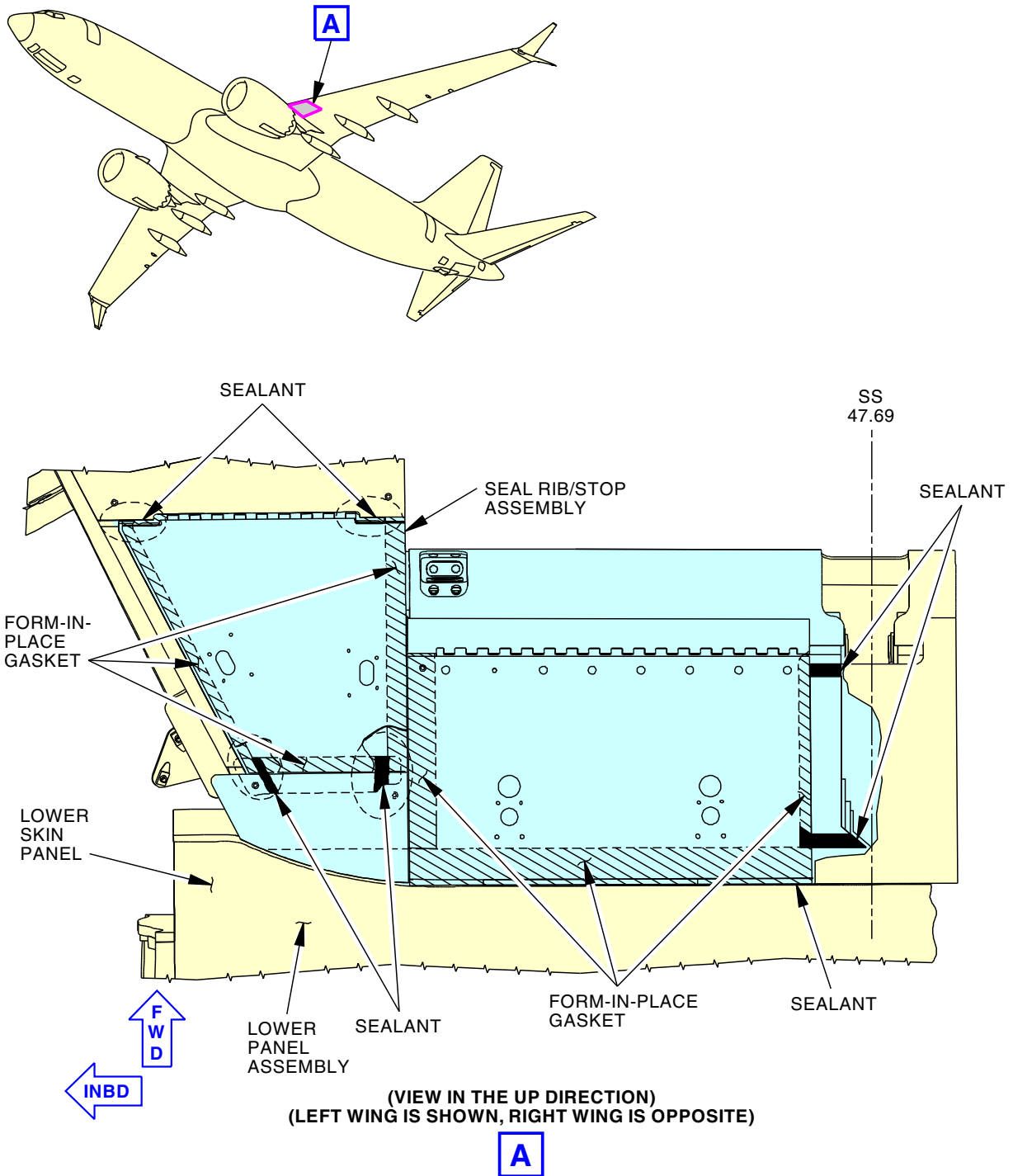
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2416664 S00061541249_V1

Blowout Door and Fuel Shutoff Access Door - Sealant Location
Figure 203/57-41-02-990-803

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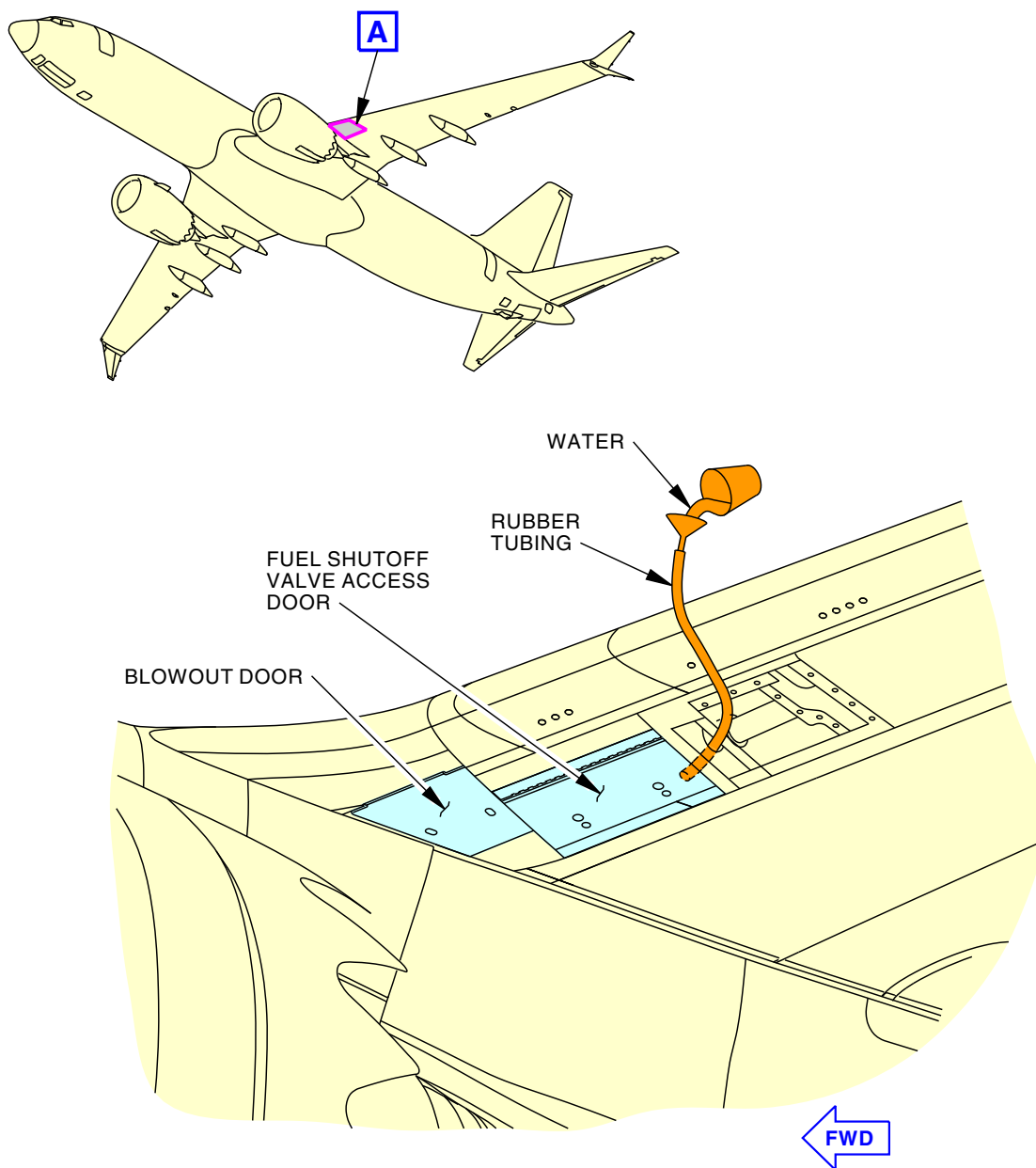
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(VIEW IN THE UP DIRECTION)
(LEFT WING IS SHOWN, RIGHT WING IS OPPOSITE)

A

2416665 S00061541250_V1

Blowout Door and Fuel Shutoff Access Door - Leak Test
Figure 204/57-41-02-990-804

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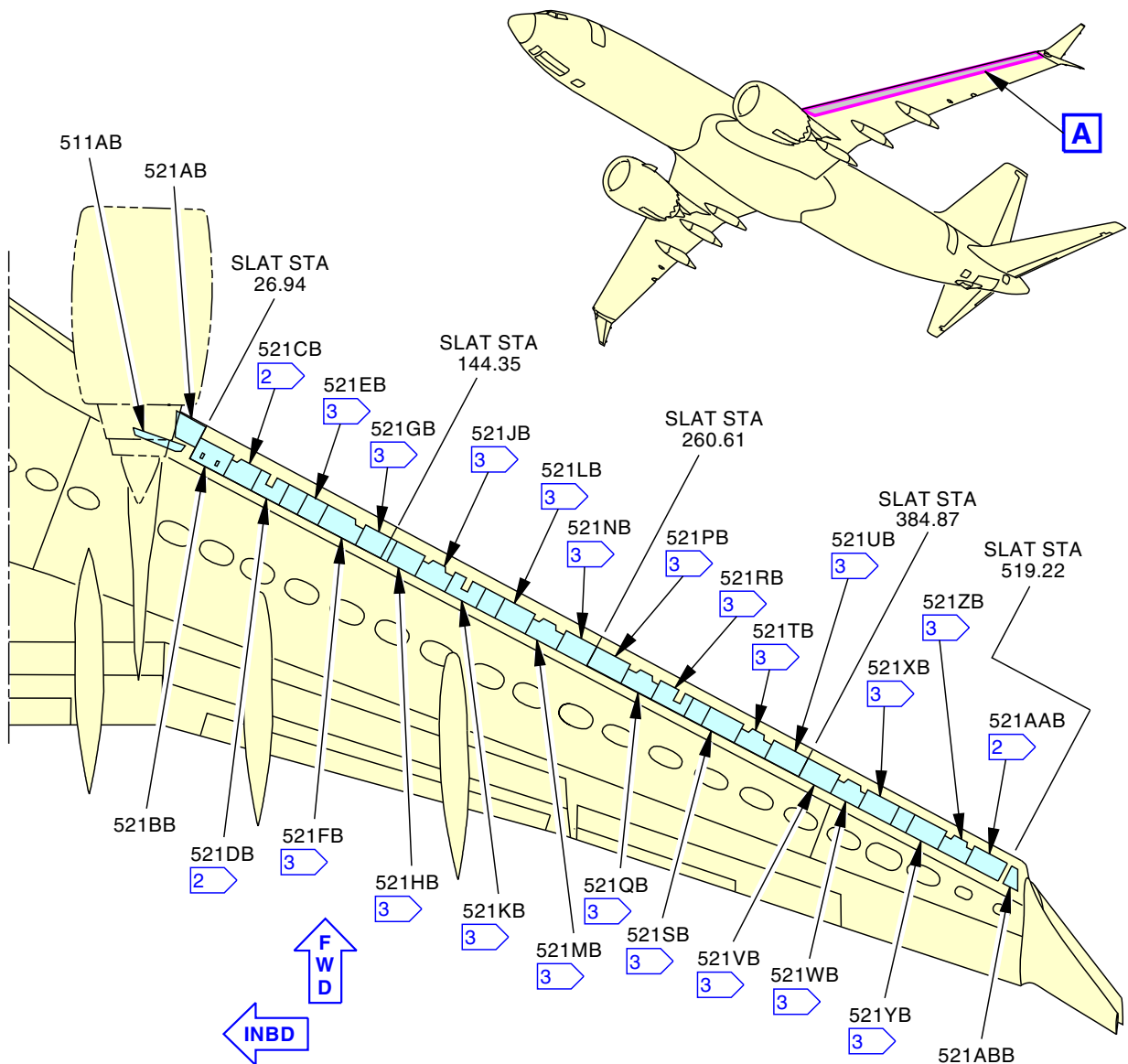
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(VIEW IN THE UP DIRECTION)
(LEFT WING IS SHOWN, RIGHT WING IS OPPOSITE)

A

- (2) 10 OHMS MAXIMUM
- (3) 300,000 OHMS MAXIMUM

2416666 S00061541251_V2

Removable Leading Edge Panel Bonding Resistance
Figure 205/57-41-02-990-805

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TASK 57-41-02-400-801

3. Leading Edge Access Panel Installation

A. General

- (1) This procedure gives the task for the installation of the access panels on the lower and upper surfaces of the wing leading edge.

B. References

Reference	Title
06-44-00-800-801	Finding an Access Door or Panel on the Wings (P/B 201)
20-50-11-910-801	Standard Torque Values (P/B 201)
27-51-00-440-801	Trailing Edge Flap System Reactivation (P/B 201)
27-81-00-440-801	Leading Edge Flaps and Slats - Activation (P/B 201)
SOPM 20-50-19	General Sealing

C. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
COM-659	Platform - Maintenance Lift, 3 ft Minimum Height, 12.5 ft Maximum Height Part #: 1135-8000 Supplier: 00994 Opt Part #: 8662-010 Supplier: 00994
COM-1793	Multimeter - Digital/Analog (or equivalent meter meets task requirements) Part #: 117 Supplier: 89536 Part #: 260-8XPI Supplier: 55026 Part #: 287 Supplier: 89536 Part #: 289 Supplier: 89536 Part #: 87V Supplier: 89536 Part #: FLUKE 27 II Supplier: 89536 Part #: FLUKE-77-4 Supplier: 89536 Opt Part #: 187 Supplier: 89536 Opt Part #: 189 Supplier: 89536 Opt Part #: 21 Supplier: 89536 Opt Part #: 27 Supplier: 89536 Opt Part #: 77 SERIES III Supplier: 89536 Opt Part #: 87 Supplier: 89536 Opt Part #: FLUKE 27 Supplier: 89536 Opt Part #: MODEL 27 Supplier: 89536
COM-2480	Platform - Mobile Elevating Work Platform SJ III Series Part #: SJIII 4726 Supplier: 3AF08 Part #: SJIII 4732 Supplier: 3AF08 Opt Part #: SJIII 4620 Supplier: 3AF08 Opt Part #: SJIII 4626 Supplier: 3AF08 Opt Part #: SJIII 4632 Supplier: 3AF08
SPL-1558	Adapter - Access Panel, Leverage Part #: 3008-550 Supplier: 55856 Part #: B20004-42 Supplier: 81205 Opt Part #: B20004-21 Supplier: 81205

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Reference	Description
STD-1265	Screwdriver - #3 Phillips ACR

D. Consumable Materials

Reference	Description	Specification
A50142	Sealant - Fuel Tank	BMS5-45 Class B-1/2
B00148	Solvent - Methyl Ethyl Ketone (MEK)	ASTM D740
C00528	Compound - Corrosion Preventive, Petroleum Hot Application (Soft Film)	MIL-C-11796 Class III
D00504	Grease - Petrolatum	VV-P-236
D50063	Grease - Perfluoropolyether, fuel and oxygen resistant - Krytox 240AC	MIL-PRF- 27617 Type III
G50313	Agent - Non-Peelable Parting (Henkel Loctite - Frekote 710-NC Mold Release)	BAC5000

E. Location Zones

Zone	Area
500	Left Wing
511	Left Wing - Leading Edge To Front Spar
521	Left Wing - Leading Edge to Front Spar
600	Right Wing
611	Right Wing - Leading Edge to Front Spar
621	Right Wing - Leading Edge to Front Spar

F. Access Panels

Number	Name/Location
511AB	Inboard Leading Edge, Lower Removable Panel
521AAB	Lower Leading Edge Access Panel - Slat Station 497
521AB	Outboard Leading Edge Blowout Door - Slat Station 20
521ABB	Lower Leading Edge Access Panel-Slat Station 519
521AT	Outbd Leading Edge - Gap Cover Access
521BB	Engine Fuel Valve Shutoff Access Panel - Slat Station 27
521BT	ACCESS PANEL- UPPER LEADING EDGE PANEL
521CB	Lower Leading Edge Access Panel - Slat Station 50
521DB	Lower Leading Edge Access Panel - Slat Station 70
521EB	Lower Leading Edge Access Panel - Slat Station 91
521FB	Lower Leading Edge Access Panel - Slat Station 107
521GB	Lower Leading Edge Access Panel - Slat Station 125
521HB	Lower Leading Edge Access Panel - Slat Station 144
521JB	Lower Leading Edge Access Panel - Slat Station 161
521KB	Lower Leading Edge Access Panel - Slat Station 179
521LB	Lower Leading Edge Access Panel - Slat Station 208
521MB	Lower Leading Edge Access Panel - Slat Station 226
521NB	Lower Leading Edge Access Panel - Slat Station 244
521PB	Lower Leading Edge Access Panel - Slat Station 261
521QB	Lower Leading Edge Access Panel - Slat Station 280
521RB	Lower Leading Edge Access Panel - Slat Station 298

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Number	Name/Location
521SB	Lower Leading Edge Access Panel - Slat Station 328
521TB	Lower Leading Edge Access Panel - Slat Station 347
521UB	Lower Leading Edge Access Panel - Slat Station 365
521VB	Lower Leading Edge Access Panel - Slat Station 385
521WB	Lower Leading Edge Access Panel - Slat Station 406
521XB	Lower Leading Edge Access Panel - Slat Station 425
521YB	Lower Leading Edge Access Panel - Slat Station 470
521ZB	Lower Leading Edge Access Panel - Slat Station 479
611AB	Inboard Leading Edge, Lower Removable Access Panel
621AAB	Lower Leading Edge Access Panel - Slat Station 524.31
621AB	Outboard Leading Edge Blowout Door - Slat Station 20
621ABB	Lower Leading Edge Access Panel-Slat Station 519
621AT	Outbd Leading Edge - Gap Cover Access
621BB	Engine Fuel Valve Shutoff Access Panel - Slat Station 27
621BT	UPPER LEADING EDGE ACCESS PANEL
621CB	Lower Leading Edge Access Panel - Slat Station 50
621DB	Lower Leading Edge Access Panel - Slat Station 70
621EB	Lower Leading Edge Access Panel - Slat Station 91
621FB	Lower Leading Edge Access Panel - Slat Station 107
621GB	Refuel Valve Door - Slat Station 125
621JB	Lower Leading Edge Access Panel - Slat Station 161
621KB	Lower Leading Edge Access Panel - Slat Station 179
621LB	Lower Leading Edge Access Panel - Slat Station 208
621MB	Lower Leading Edge Access Panel - Slat Station 226
621NB	Lower Leading Edge Access Panel - Slat Station 244
621PB	Lower Leading Edge Access Panel - Slat Station 261
621QB	Lower Leading Edge Access Panel - Slat Station 280
621RB	Lower Leading Edge Access Panel - Slat Station 298
621SB	Lower Leading Edge Access Panel - Slat Station 328
621TB	Lower Leading Edge Access Panel - Slat Station 347
621UB	Lower Leading Edge Access Panel - Slat Station 365
621VB	Lower Leading Edge Access Panel - Slat Station 385
621WB	Lower Leading Edge Access Panel - Slat Station 406
621XB	Lower Leading Edge Access Panel - Slat Station 425
621YB	Lower Leading Edge Access Panel - Slat Station 470
621ZB	Lower Leading Edge Access Panel - Slat Station 479

G. Leading Edge Access Panel Installation

SUBTASK 57-41-02-860-002

- (1) To help you find the applicable leading edge panel, refer to Finding an Access Door or Panel on the Wings, TASK 06-44-00-800-801.

SUBTASK 57-41-02-420-001

- (2) Install the applicable access panel on the wing (Figure 201).

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- (a) For the left wing, install the applicable access panels.

<u>Number</u>	<u>Name/Location</u>
511AB	Inboard Leading Edge, Lower Removable Panel
521AAB	Lower Leading Edge Access Panel - Slat Station 497
521AB	Outboard Leading Edge Blowout Door - Slat Station 20
521ABB	Lower Leading Edge Access Panel-Slat Station 519
521AT	Outbd Leading Edge - Gap Cover Access
521BB	Engine Fuel Valve Shutoff Access Panel - Slat Station 27
521BT	ACCESS PANEL- UPPER LEADING EDGE PANEL
521CB	Lower Leading Edge Access Panel - Slat Station 50
521DB	Lower Leading Edge Access Panel - Slat Station 70
521EB	Lower Leading Edge Access Panel - Slat Station 91
521FB	Lower Leading Edge Access Panel - Slat Station 107
521GB	Lower Leading Edge Access Panel - Slat Station 125
521HB	Lower Leading Edge Access Panel - Slat Station 144
521JB	Lower Leading Edge Access Panel - Slat Station 161
521KB	Lower Leading Edge Access Panel - Slat Station 179
521LB	Lower Leading Edge Access Panel - Slat Station 208
521MB	Lower Leading Edge Access Panel - Slat Station 226
521NB	Lower Leading Edge Access Panel - Slat Station 244
521PB	Lower Leading Edge Access Panel - Slat Station 261
521QB	Lower Leading Edge Access Panel - Slat Station 280
521RB	Lower Leading Edge Access Panel - Slat Station 298
521SB	Lower Leading Edge Access Panel - Slat Station 328
521TB	Lower Leading Edge Access Panel - Slat Station 347
521UB	Lower Leading Edge Access Panel - Slat Station 365
521VB	Lower Leading Edge Access Panel - Slat Station 385
521WB	Lower Leading Edge Access Panel - Slat Station 406
521XB	Lower Leading Edge Access Panel - Slat Station 425
521YB	Lower Leading Edge Access Panel - Slat Station 470
521ZB	Lower Leading Edge Access Panel - Slat Station 479

- (b) For the right wing, install the applicable access panels.

<u>Number</u>	<u>Name/Location</u>
611AB	Inboard Leading Edge, Lower Removable Access Panel
621AAB	Lower Leading Edge Access Panel - Slat Station 524.31
621AB	Outboard Leading Edge Blowout Door - Slat Station 20
621ABB	Lower Leading Edge Access Panel-Slat Station 519
621AT	Outbd Leading Edge - Gap Cover Access
621BB	Engine Fuel Valve Shutoff Access Panel - Slat Station 27
621BT	UPPER LEADING EDGE ACCESS PANEL
621CB	Lower Leading Edge Access Panel - Slat Station 50
621DB	Lower Leading Edge Access Panel - Slat Station 70
621EB	Lower Leading Edge Access Panel - Slat Station 91
621FB	Lower Leading Edge Access Panel - Slat Station 107
621GB	Refuel Valve Door - Slat Station 125
621JB	Lower Leading Edge Access Panel - Slat Station 161
621KB	Lower Leading Edge Access Panel - Slat Station 179

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<u>Number</u>	<u>Name/Location</u>
621LB	Lower Leading Edge Access Panel - Slat Station 208
621MB	Lower Leading Edge Access Panel - Slat Station 226
621NB	Lower Leading Edge Access Panel - Slat Station 244
621PB	Lower Leading Edge Access Panel - Slat Station 261
621QB	Lower Leading Edge Access Panel - Slat Station 280
621RB	Lower Leading Edge Access Panel - Slat Station 298
621SB	Lower Leading Edge Access Panel - Slat Station 328
621TB	Lower Leading Edge Access Panel - Slat Station 347
621UB	Lower Leading Edge Access Panel - Slat Station 365
621VB	Lower Leading Edge Access Panel - Slat Station 385
621WB	Lower Leading Edge Access Panel - Slat Station 406
621XB	Lower Leading Edge Access Panel - Slat Station 425
621YB	Lower Leading Edge Access Panel - Slat Station 470
621ZB	Lower Leading Edge Access Panel - Slat Station 479

- (c) For access panels that touch the slat track ribs at SS 47.69, 122.69, 163.95, 240.95, 282.91, 362.51 and 409.09, do these steps:
- 1) Make sure that there is no damage to the sealant in the machined gaps of the ribs (Figure 202).
 - 2) Make sure that there is no damage to the fay surface sealant on the bottom flanges of the ribs (Figure 202).
 - 3) If there are signs of damage to the sealants, do the steps that follow:
 - a) Remove damaged sealant with a plastic scraper.
 - b) Clean the surface.
 - c) Apply the parting agent only to the door surface in contact with the ribs.
NOTE: This will allow the sealant to release from the door.
 - d) Apply sealant at the fay surface of the door and rib flange with sealant, A50142 per (SOPM 20-50-19).

<1> Make sure to keep the drain paths clear of sealant as noted in Figure 202.
- (d) For the Blow Out Door and the Fuel Shut Off Access Door (521AB, 521BB, 621AB, 621BB), make sure that there is no damage to the form-in-place gasket and sealant around the door structure (Figure 203).
- 1) If there are signs of damage to the form-in-place gasket or sealant, do the steps that follow:
 - a) Remove damaged sealant with a plastic scraper.
 - b) Clean the surface of the door.
 - c) Apply the parting agent only to the door surface in contact with the seal.
NOTE: This will allow the sealant to release from the door during operation.
Do not apply the parting agent to the doorway surround structure.
 - d) Apply seal at the fay surface of the door surround with sealant, A50142 per (SOPM 20-50-19).
 - e) Make sure that the sealant is attached on the door structure and not on the door.

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- f) To reduce the adhesion of the door panels to form in place gaskets, apply a thin coat of Frekote 710-NC non-peelable parting agent, G50313 or Krytox 240AC perfluoropolyether grease, D50063 to the doors surfaces that contact the gasket. You can use grease, D00504 as a substitute for the preferred grease on subsequent re-applications, but only with the additional process requirements that the door surface be wiped clean with a lint free cloth after application, removing all but a residue of petrolatum.

NOTE: Surface that is to be painted should be wiped clean of grease with solvent, B00148 prior to surface preparation for painting.

- (e) Make sure that the bolt have correct grip length, undamaged threads and undamaged recesses.

NOTE: If any fasteners need to be replaced, it is recommended that aluminum pigmented coated, titanium bolts, BACB30XD()K(), BACB30XD()K()G, BACB30ZE4-()G, NAS8704-5 are used where applicable. No grip length substitution allowed. On the panel, use cadmium plated, corrosion resistant steel (CRES) nut-plates where applicable.

- (f) Remove any excess paint or debris on bolt hole recesses.
(g) Apply corrosion preventative compound, C00528 to all areas of the hole, the countersink, counterbore or other recess and immediately install the bolt.



WARNING

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- (h) Examine the area to make sure objects are not left in the slat track housing assembly.

- (i) Install the bolt.

- 1) The use of a phillips screwdriver, STD-1265, and an installation anti cam-out (ACR) driver bit (customer furnished) or a leverage access panel adapter, SPL-1558, is recommended.

NOTE: The ACR bit should have a hardness of 56-58 RC. A combination removal/installation ACR bit is not recommended.

- 2) For the applicable torques; refer to Standard Torque Values, TASK 20-50-11-910-801.
3) Make sure the bolt is installed flush with the panel surface, 0.000 +0.002 / -0.010 in. (0.000 +0.051 / -0.254 mm).
4) Install the applicable electrical bonding fastener (BACB30ZE4-()G or NAS8704-5) and measure the electrical resistance between the anti-static coating or expanded aluminum foil on the access panel and the fastener with a digital/analog multimeter, COM-1793 (Figure 205).

H. Blowout door and Fuel Shutoff Access Door Leak Check

SUBTASK 57-41-02-790-001

- (1) Insert a rubber tube attached to a funnel through the gap between the thermal anti-icing duct and the hole in the rib (Figure 204).

- (a) There should be approximately 2 feet of tubing from the rib up to the funnel.

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SUBTASK 57-41-02-790-002

- (2) Pour 16 ounces of water slowly through the funnel onto the Fuel Shutoff Valve Access Door.
 - (a) If water drains through the strut drain tube and no water drips onto the engine nozzle within two minutes, then the check is successful.
 - (b) If water does not drain through the strut drain tube, then clean the drain path and repeat the leak check.
 - (c) If water drips onto the engine nozzle within two minutes, then reapply sealant as required until the leak check is successful.

I. Put the Airplane Back to the Usual Condition

SUBTASK 57-41-02-090-001

- (1) Remove the ladder, work platform, COM-2480 or maintenance platform, COM-659.

SUBTASK 57-41-02-440-001

- (2) Do this task: Trailing Edge Flap System Reactivation, TASK 27-51-00-440-801.

SUBTASK 57-41-02-440-002

- (3) Do this task: Leading Edge Flaps and Slats - Activation, TASK 27-81-00-440-801.

———— **END OF TASK** ————

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OUTBOARD LEADING EDGE SLAT ROLLERS - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) A removal of the outboard leading edge slat rollers
 - (2) An installation of the outboard leading edge slat rollers.
- B. There are four slats on each wing. This procedure is applicable for the leading edge slats no. 1 thru 8.
- C. You can do this procedure with the airplane on jacks or off jacks, but the wing should not be supported outboard of the engines.

TASK 57-44-01-000-801

2. Outboard Leading Edge Slat Roller Removal

(Figure 401)

A. **References**

Reference	Title
27-81-00-040-801	Leading Edge Flaps and Slats - Deactivation (P/B 201)
27-81-21-000-801	Leading Edge Slat Removal (P/B 401)
57-41-02-000-801	Leading Edge Access Panel Removal (P/B 201)

B. **Location Zones**

Zone	Area
521	Left Wing - Leading Edge to Front Spar
522	Left Wing - Slat No. 4
523	Left Wing - Slat No. 3
524	Left Wing - Slat No. 2
525	Left Wing - Slat No. 1
621	Right Wing - Leading Edge to Front Spar
622	Right Wing - Slat No. 5
623	Right Wing - Slat No. 6
624	Right Wing - Slat No. 7
625	Right Wing - Slat No. 8

C. **Access Panels**

Number	Name/Location
521CB	Lower Leading Edge Access Panel - Slat Station 50
521FB	Lower Leading Edge Access Panel - Slat Station 107
521HB	Lower Leading Edge Access Panel - Slat Station 144
521LB	Lower Leading Edge Access Panel - Slat Station 208
521PB	Lower Leading Edge Access Panel - Slat Station 261
521SB	Lower Leading Edge Access Panel - Slat Station 328
521VB	Lower Leading Edge Access Panel - Slat Station 385
521YB	Lower Leading Edge Access Panel - Slat Station 470
621CB	Lower Leading Edge Access Panel - Slat Station 50
621FB	Lower Leading Edge Access Panel - Slat Station 107
621LB	Lower Leading Edge Access Panel - Slat Station 208

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(Continued)

Number	Name/Location

621PB	Lower Leading Edge Access Panel - Slat Station 261
621SB	Lower Leading Edge Access Panel - Slat Station 328
621VB	Lower Leading Edge Access Panel - Slat Station 385
621YB	Lower Leading Edge Access Panel - Slat Station 470

D. Outboard Leading Edge Slat Roller Removal

SUBTASK 57-44-01-040-001

- (1) Do this task: Leading Edge Flaps and Slats - Deactivation, TASK 27-81-00-040-801.

SUBTASK 57-44-01-020-001

- (2) To remove the upper rollers, do this task: Leading Edge Slat Removal, TASK 27-81-21-000-801.

SUBTASK 57-44-01-010-001

- (3) Open the applicable access panels from the lower leading edge (TASK 57-41-02-000-801):

- (a) For the left wing, open these access panels:

Number	Name/Location

521CB	Lower Leading Edge Access Panel - Slat Station 50
521FB	Lower Leading Edge Access Panel - Slat Station 107
521HB	Lower Leading Edge Access Panel - Slat Station 144
521LB	Lower Leading Edge Access Panel - Slat Station 208
521PB	Lower Leading Edge Access Panel - Slat Station 261
521SB	Lower Leading Edge Access Panel - Slat Station 328
521VB	Lower Leading Edge Access Panel - Slat Station 385
521YB	Lower Leading Edge Access Panel - Slat Station 470

For the right wing, open these access panels:

Number	Name/Location

621CB	Lower Leading Edge Access Panel - Slat Station 50
621FB	Lower Leading Edge Access Panel - Slat Station 107
621LB	Lower Leading Edge Access Panel - Slat Station 208
621PB	Lower Leading Edge Access Panel - Slat Station 261
621SB	Lower Leading Edge Access Panel - Slat Station 328
621VB	Lower Leading Edge Access Panel - Slat Station 385
621YB	Lower Leading Edge Access Panel - Slat Station 470

SUBTASK 57-44-01-020-002

- (4) Remove the upper and lower aft bearings [3]:

- (a) Remove the cotter pins [7] from the nut [6] and nut [9], and discard them.
(b) Remove the nut [6], washers [4], and bushing [5] from the upper aft bearings [3].
(c) Remove the nut [9], washers [8], and bushing [10] from the lower aft bearing [3]



DO NOT LET OBJECTS GET IN THE HOUSING ASSEMBLY OF THE SLAT TRACK. THIS WILL HELP PREVENT A PUNCTURE OF THE HOUSING ASSEMBLY THAT COULD CAUSE A FUEL LEAK. THE FUEL LEAK COULD CAUSE A FIRE AND POSSIBLE DEATH OR INJURY TO PERSONNEL.

- (d) Remove the bolts [1] and bearings [3].

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- (e) Remove the washers [2], washers [4], and washers [8].

NOTE: The quantities for the washers [4] and washers [8] can vary because of adjustments. See the information in the installation procedure for the minimum and maximum quantities.

SUBTASK 57-44-01-210-001

- (5) Examine the area to make sure that objects are not left in the slat track housing assembly.

SUBTASK 57-44-01-930-001

- (6) Label the bolts [1], bearings [3], washers [2], washers [4], washers [8], bushing [5], bushing [10], nut [6], and nut [9].

SUBTASK 57-44-01-020-003

- (7) Remove the upper and lower forward bearings [3]:
- (a) Remove the cotter pins [7] from the nut [13] and nut [15], and discard them.
 - (b) Remove the nut [13], washers [11], and bushing [12] from the upper forward bearing [3].
 - (c) Remove the nut [15], washers [14], and bushing [16] from the lower forward bearing [3].



DO NOT LET OBJECTS GET IN THE HOUSING ASSEMBLY OF THE SLAT TRACK. THIS WILL HELP PREVENT A PUNCTURE OF THE HOUSING ASSEMBLY THAT COULD CAUSE A FUEL LEAK. THE FUEL LEAK COULD CAUSE A FIRE AND POSSIBLE DEATH OR INJURY TO PERSONNEL.

- (d) Remove the bolts [1] and bearings [3].
- (e) Remove the washers [2], washers [11], and washers [14].

NOTE: The quantities for the washers [11] and washers [14] can vary because of adjustments. See the cautions in the installation procedure for the minimum and maximum quantities.

SUBTASK 57-44-01-930-002

- (8) Label the bolts [1], bearings [3], washers [2], washers [11], washers [14], bushing [10], bushing [12], nut [13], and nut [15].

———— **END OF TASK** ————

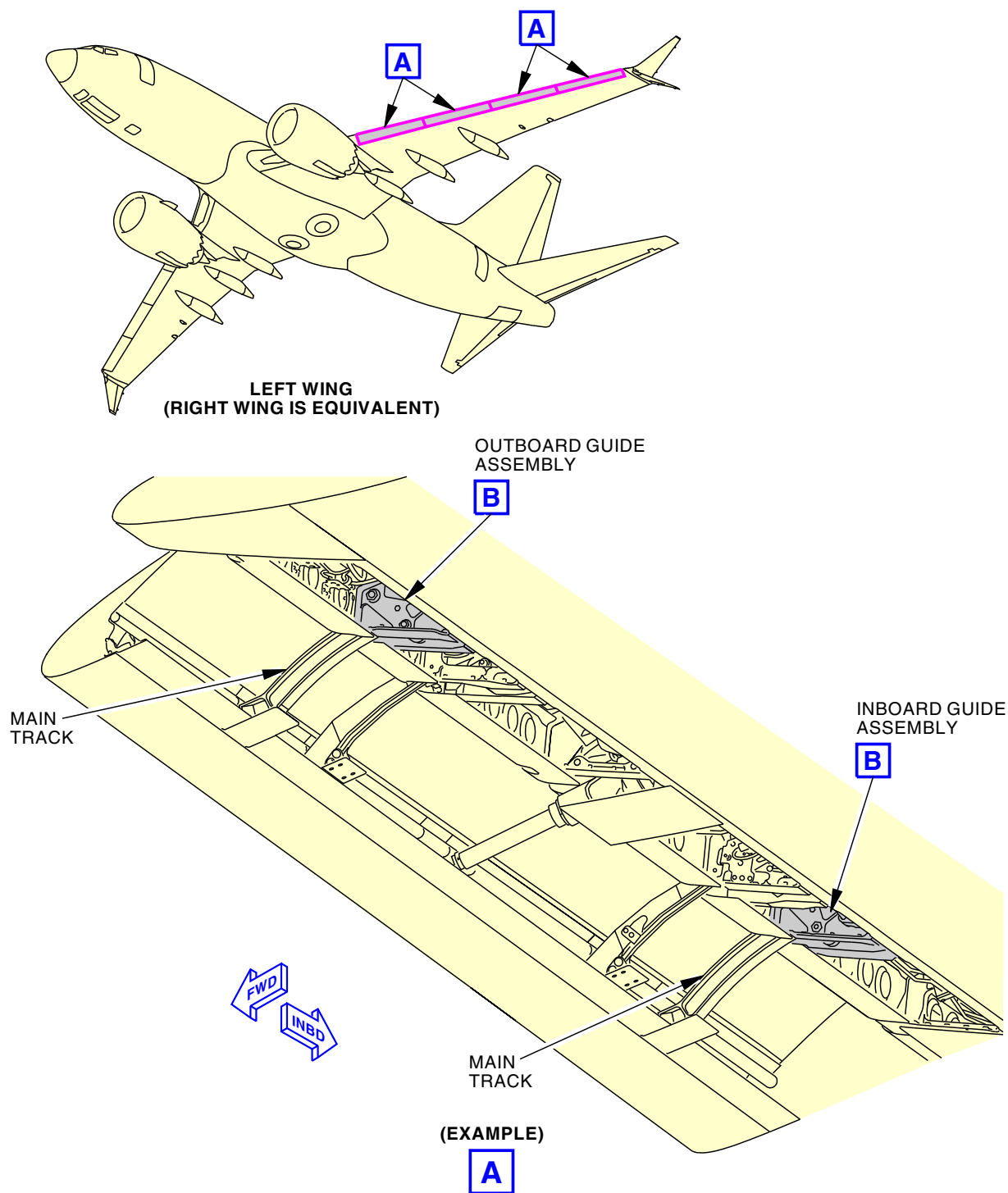
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2416667 S00061541258_V1

Outboard Fixed Leading Edge Slat Rollers Installation
Figure 401/57-44-01-990-801 (Sheet 1 of 4)

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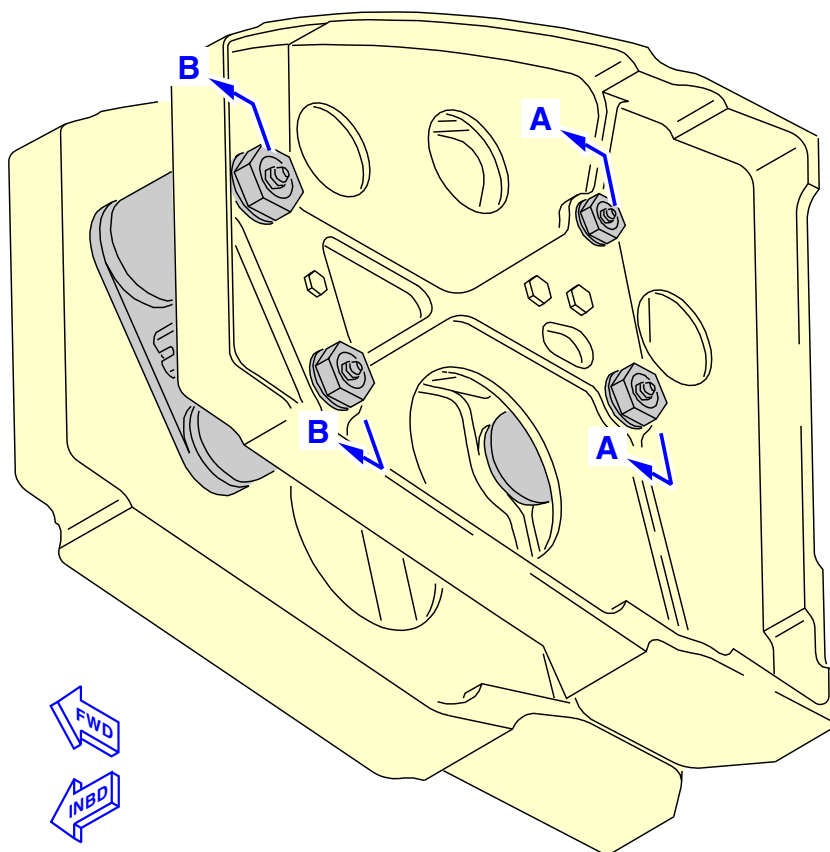
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INBOARD GUIDE ASSEMBLY
(OUTBOARD GUIDE ASSEMBLY IS OPPOSITE)

B

2416668 S00061541259_V1

Outboard Fixed Leading Edge Slat Rollers Installation
Figure 401/57-44-01-990-801 (Sheet 2 of 4)

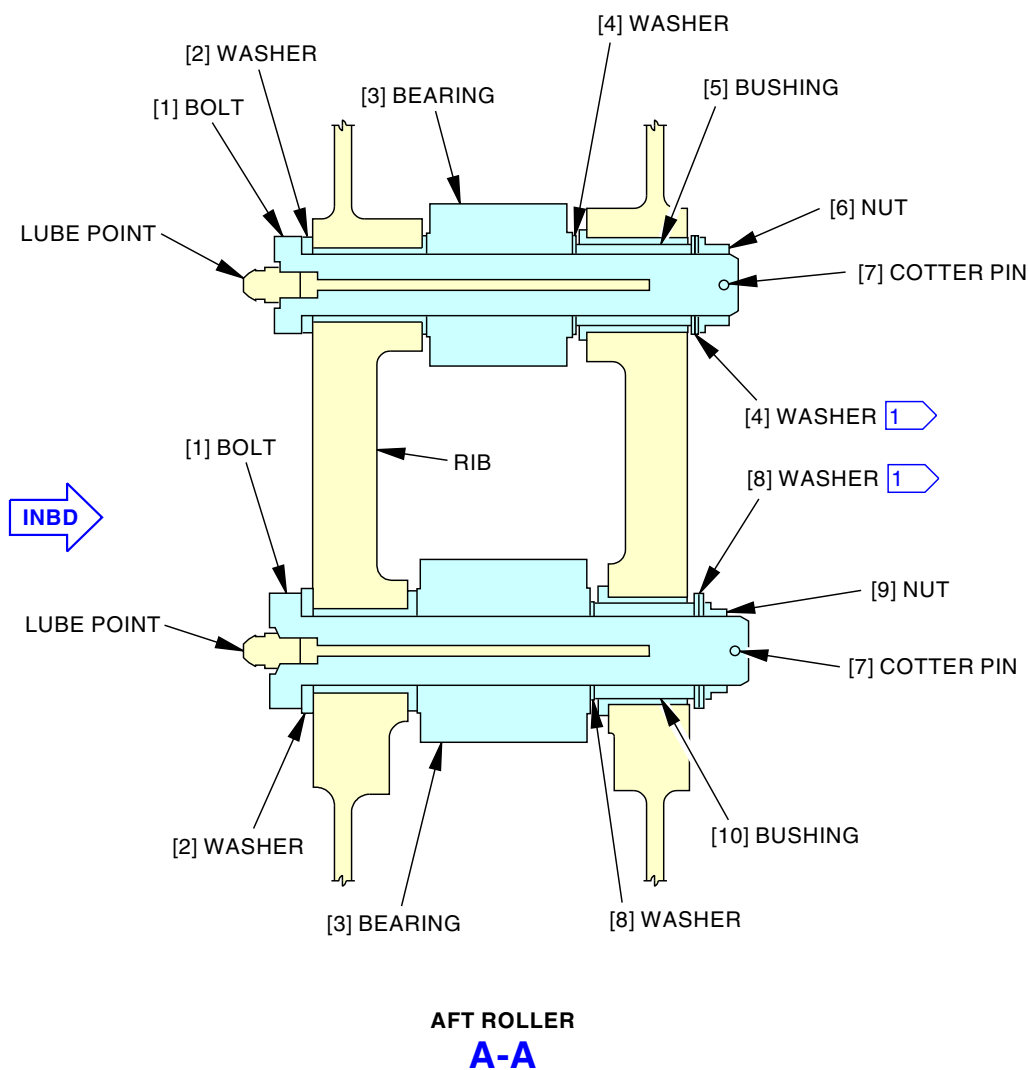
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1 USE A MINIMUM OF 1 WASHER
AND A MAXIMUM OF 4 WASHERS

2416669 S00061541260_V1

Outboard Fixed Leading Edge Slat Rollers Installation
Figure 401/57-44-01-990-801 (Sheet 3 of 4)

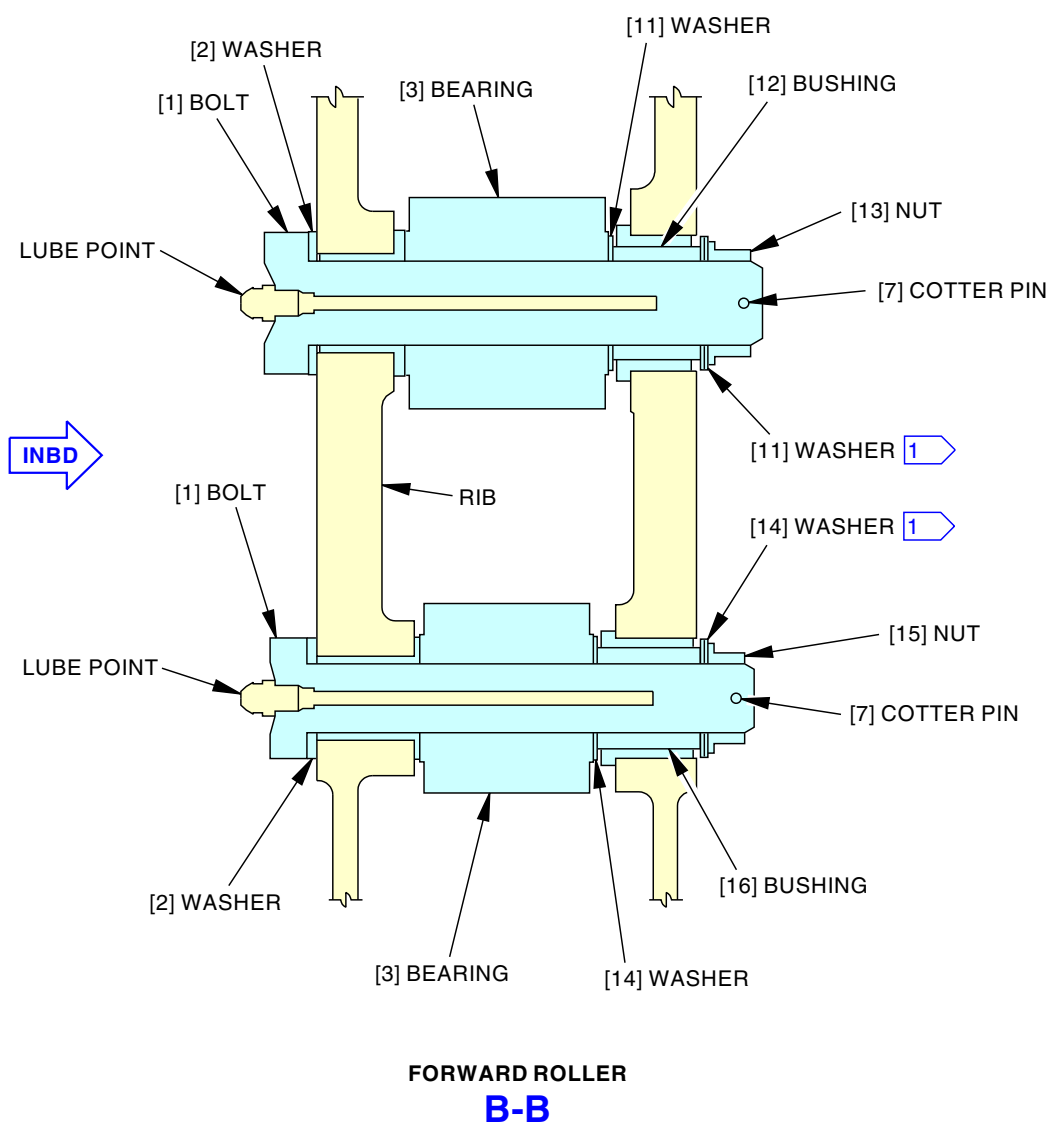
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2416670 S00061541261_V1

Outboard Fixed Leading Edge Slat Rollers Installation
Figure 401/57-44-01-990-801 (Sheet 4 of 4)

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TASK 57-44-01-400-801

3. Outboard Leading Edge Rollers Installation

(Figure 401)

A. References

Reference	Title
27-81-00-440-801	Leading Edge Flaps and Slats - Activation (P/B 201)
27-81-21-400-801	Leading Edge Slat Installation (P/B 401)
57-41-02-400-801	Leading Edge Access Panel Installation (P/B 201)

B. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
3	Bearing	57-44-01-01-135	SIA ALL
		57-44-01-01-175	SIA ALL
		57-44-01-01-215	SIA ALL
7	Cotter pin	57-44-01-01-095	SIA ALL
		57-44-01-01-100	SIA ALL

C. Location Zones

Zone	Area
521	Left Wing - Leading Edge to Front Spar
522	Left Wing - Slat No. 4
523	Left Wing - Slat No. 3
524	Left Wing - Slat No. 2
525	Left Wing - Slat No. 1
621	Right Wing - Leading Edge to Front Spar
622	Right Wing - Slat No. 5
623	Right Wing - Slat No. 6
624	Right Wing - Slat No. 7
625	Right Wing - Slat No. 8

D. Access Panels

Number	Name/Location
521CB	Lower Leading Edge Access Panel - Slat Station 50
521FB	Lower Leading Edge Access Panel - Slat Station 107
521HB	Lower Leading Edge Access Panel - Slat Station 144
521LB	Lower Leading Edge Access Panel - Slat Station 208
521PB	Lower Leading Edge Access Panel - Slat Station 261
521SB	Lower Leading Edge Access Panel - Slat Station 328
521VB	Lower Leading Edge Access Panel - Slat Station 385
521YB	Lower Leading Edge Access Panel - Slat Station 470
621CB	Lower Leading Edge Access Panel - Slat Station 50
621FB	Lower Leading Edge Access Panel - Slat Station 107
621LB	Lower Leading Edge Access Panel - Slat Station 208
621PB	Lower Leading Edge Access Panel - Slat Station 261
621SB	Lower Leading Edge Access Panel - Slat Station 328
621VB	Lower Leading Edge Access Panel - Slat Station 385
621YB	Lower Leading Edge Access Panel - Slat Station 470

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E. Outboard Leading Edge Rollers Installation

SUBTASK 57-44-01-000-001

- (1) Remove the labels from the bolts [1], bearings [3], washers [2], washers [11], washers [14], bushing [16], bushing [12], nut [13], and nut [15] for the forward rollers.

SUBTASK 57-44-01-210-002



WARNING

DO NOT LET OBJECTS GET IN THE HOUSING ASSEMBLY OF THE SLAT TRACK. THIS WILL HELP PREVENT A PUNCTURE OF THE HOUSING ASSEMBLY THAT COULD CAUSE A FUEL LEAK. THE FUEL LEAK COULD CAUSE A FIRE AND POSSIBLE DEATH OR INJURY TO PERSONNEL.

- (2) Examine the area to make sure that objects are not left in the slat track housing assembly.

SUBTASK 57-44-01-420-001

- (3) Install the upper and lower forward bearings [3]:

- (a) Loosely install the bolts [1], washers [2], and bearings [3]

NOTE: On the inboard side of the slat, install the bolts [1] with the heads outboard. On the outboard side of the slat, install the bolts [1] with the heads inboard.

- (b) Install the washer [11], washer [14], bushing [12], and bushing [16].

NOTE: The quantities for the washers [11] and washers [14] can vary because of adjustments. Use a minimum of 1 washer and a maximum of 4 washers.

- (c) Install the nut [13] and nut [15] as follows:



CAUTION

DO NOT APPLY MORE THAN 1500 IN-LB (169 N·M) TORQUE. TOO MUCH TORQUE WILL CAUSE DAMAGE TO EQUIPMENT.

- 1) For slats 2 to 7, tighten the upper nut [13] to a minimum of 1200 in-lb (136 N·m).
2) Rotate the nut [13] a maximum of one additional castellation to align the cotter pin hole.



CAUTION

DO NOT APPLY MORE THAN 700 IN-LB (79 N·M) TORQUE. TOO MUCH TORQUE WILL CAUSE DAMAGE TO EQUIPMENT.

- 3) For slats 1 and 8, tighten the upper nut [13] to a minimum of 400 in-lb (45 N·m).
4) Rotate the nut [13] a maximum of one additional castellation to align the cotter pin hole.
5) Install the new cotter pin [7].
6) For slats 2 to 7, make sure that the bolt assembly cannot rotate by applying a minimum torque of 600 in-lb (68 N·m) to the bolts [1] or nut [13].
7) For slats 1 and 8, make sure that the bolt assembly cannot rotate by applying a minimum torque of 200 in-lb (23 N·m) to the bolts [1] or nut [13].



CAUTION

DO NOT APPLY MORE THAN 700 IN-LB (79 N·M) TORQUE. TOO MUCH TORQUE WILL CAUSE DAMAGE TO EQUIPMENT.

- 8) For slats 2 to 7, tighten the lower nut [15] to a minimum of 400 in-lb (45 N·m).

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DO NOT APPLY MORE THAN 350 IN-LB (40 N·M) TORQUE. TOO MUCH TORQUE WILL CAUSE DAMAGE TO EQUIPMENT.

- 9) For slats 1 and 8, tighten the lower nut [15] to a minimum of 200 in-lb (23 N·m).
- 10) Rotate the nut [15] a maximum of one additional castellation to align the cotter pin hole.
- 11) Install the new cotter pin [7].
- 12) For slats 2 to 7, make sure that the bolt assembly cannot rotate by applying a minimum torque of 200 in-lb (23 N·m) to the bolt [1] or nut [15].
- 13) For slats 1 and 8, make sure that the bolt assembly cannot rotate by applying a minimum torque of 70 in-lb (8 N·m) to the bolt [1] or nut [15].

SUBTASK 57-44-01-000-002

- (4) Remove the labels from the bolts [1], bearings [3], washers [2], washers [4], washers [8], bushing [5], bushing [10], nut [6], and nut [9] for the aft rollers.

SUBTASK 57-44-01-210-003



DO NOT LET OBJECTS GET IN THE HOUSING ASSEMBLY OF THE SLAT TRACK. THIS WILL HELP PREVENT A PUNCTURE OF THE HOUSING ASSEMBLY THAT COULD CAUSE A FUEL LEAK. THE FUEL LEAK COULD CAUSE A FIRE AND POSSIBLE DEATH OR INJURY TO PERSONNEL.

- (5) Examine the area to make sure that objects are not left in the slat track housing assembly.

SUBTASK 57-44-01-420-002

- (6) Install the upper and lower aft bearings [3]:
 - (a) Loosely install the bolts [1], washers [2], and bearings [3].

NOTE: On the inboard side of the slat, install the bolts [1] with the heads outboard. On the outboard side of the slat, install the bolts [1] with the heads inboard.
 - (b) Install the washers [4], washers [8], bushing [5], and bushing [10].

NOTE: The quantities for the washers [4] and washers [8] can vary because of adjustments. Use a minimum of 1 washer and a maximum of 4 washers.
 - (c) Install the nut [6] and nut [9] as follows:



DO NOT APPLY MORE THAN 350 IN-LB (40 N·M) TORQUE. TOO MUCH TORQUE WILL CAUSE DAMAGE TO EQUIPMENT.

- 1) Tighten the upper nut [6] to a minimum of 200 in-lb (23 N·m).
- 2) Rotate the nut [6] a maximum of one additional castellation to align the cotter pin hole.
- 3) Install the new cotter pin [7].
- 4) Make sure that the bolt assembly cannot rotate by applying a minimum torque of 70 in-lb (8 N·m) to the bolt [1] and nut [6].

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DO NOT APPLY MORE THAN 700 IN-LB (79 N·M) TORQUE. TOO MUCH TORQUE WILL CAUSE DAMAGE TO EQUIPMENT.

- 5) For slats 2 to 7, tighten the lower nut [9] to a minimum of 400 in-lb (45 N·m).
- 6) Rotate the nut [9] a maximum of one additional castellation to align the cotter pin hole.



DO NOT APPLY MORE THAN 350 IN-LB (40 N·M) TORQUE. TOO MUCH TORQUE WILL CAUSE DAMAGE TO EQUIPMENT.

- 7) For slats 1 and 8, torque the lower nut [9] to a minimum of 200 in-lb (23 N·m).
- 8) Rotate the nut [9] a maximum of one additional castellation to align the cotter pin hole.
- 9) Install the new cotter pins [7].
- 10) For slats 2 to 7, make sure that the bolt assembly cannot rotate by applying a minimum torque of 200 in-lb (23 N·m) to the bolt [1] or nut [9].
- 11) For slats 1 and 8, make sure that the bolt assembly cannot rotate by applying a minimum torque of 70 in-lb (8 N·m) to the bolt [1] or nut [9].

SUBTASK 57-44-01-410-001

- (7) If the outboard leading edge slat was removed, do this task: Leading Edge Slat Installation, TASK 27-81-21-400-801.

SUBTASK 57-44-01-410-002

- (8) Close the applicable access panels on the lower leading edge (TASK 57-41-02-400-801):
 - (a) For the left wing, close these access panels:

<u>Number</u>	<u>Name/Location</u>
521CB	Lower Leading Edge Access Panel - Slat Station 50
521FB	Lower Leading Edge Access Panel - Slat Station 107
521HB	Lower Leading Edge Access Panel - Slat Station 144
521LB	Lower Leading Edge Access Panel - Slat Station 208
521PB	Lower Leading Edge Access Panel - Slat Station 261
521SB	Lower Leading Edge Access Panel - Slat Station 328
521VB	Lower Leading Edge Access Panel - Slat Station 385
521YB	Lower Leading Edge Access Panel - Slat Station 470

For the right wing, close these access panels:

<u>Number</u>	<u>Name/Location</u>
621CB	Lower Leading Edge Access Panel - Slat Station 50
621FB	Lower Leading Edge Access Panel - Slat Station 107
621LB	Lower Leading Edge Access Panel - Slat Station 208
621PB	Lower Leading Edge Access Panel - Slat Station 261
621SB	Lower Leading Edge Access Panel - Slat Station 328
621VB	Lower Leading Edge Access Panel - Slat Station 385
621YB	Lower Leading Edge Access Panel - Slat Station 470

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SUBTASK 57-44-01-440-001

(9) Do this task: Leading Edge Flaps and Slats - Activation, TASK 27-81-00-440-801.

———— **END OF TASK** ————

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OUTBOARD LEADING EDGE SEAL RIB - INSPECTION/CHECK

1. General

A. This procedure has one task:

- (1) Check of sealant at leading edge seal rib.

TASK 57-44-03-200-801

2. Check of Sealant at Leading Edge Seal Rib

A. **General**

- (1) This task gives the procedure to do a visual check of the sealant applied to the forward spar and the leading edge seal rib.
- (2) A visual inspection for condition of the fillet seals of the seal rib, the forward spar, and rib 27 is necessary because these seals must have absolute seals to form a vapor barrier. These fillet seals can not be tested by pressurization. If the fillet seal is damaged, it is necessary to repair the fillet seal or replace the fillet seal.

B. **References**

Reference	Title
57-41-02-000-801	Leading Edge Access Panel Removal (P/B 201)
57-41-02-400-801	Leading Edge Access Panel Installation (P/B 201)
57-44-03-390-801	Repair of Sealant at Leading Edge Seal Rib (P/B 801)

C. **Tools/Equipment**

Reference	Description
STD-600	Mirror - Inspection
STD-1081	Flashlight - Explosion Proof

D. **Location Zones**

Zone	Area
500	Left Wing
521	Left Wing - Leading Edge to Front Spar
600	Right Wing
621	Right Wing - Leading Edge to Front Spar

E. **Prepare for the Procedure**

SUBTASK 57-44-03-010-001

- (1) Do this task: Leading Edge Access Panel Removal, TASK 57-41-02-000-801.

F. **Visual Check**

SUBTASK 57-44-03-212-001

- (1) Examine the area you think contains a leak.
 - (a) Look for seal defects such as cracked or loose fillets, pinholes, or loose fasteners.
 - (b) Refer to Leading Edge Seal Rib Fillet Seals/Figure 601.
 - (c) Use an explosion proof flashlight, STD-1081 when you look inside the leading edge area.
 - (d) If necessary, use an inspection mirror, STD-600 to examine seals which are difficult to see.

SUBTASK 57-44-03-212-002

- (2) If you find seal defects, repair or replace the fillet seal:

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- (a) Do this task: Repair of Sealant at Leading Edge Seal Rib, TASK 57-44-03-390-801.
- 1) You can remove and replace the bad sealant.
 - a) Examine the structure around the bad seal to find where to increase the seal plane.
 - b) Remove the length of bad sealant.
 - c) Apply a new fillet seal around the structure with the applicable seals and fasteners.
 - 2) You can increase the seal plane to isolate a bad seal.

NOTE: Because you add a large quantity of sealant when you increase the seal plane above the initial seal plane, it is better to replace the bad seal.

 - a) Examine the structure around the bad seal to find where to increase the seal plane.
 - b) Apply a new fillet seal around the structure with the applicable seals and fasteners to increase the seal plane.

G. Put the Airplane Back to the Usual Condition

SUBTASK 57-44-03-410-001

- (1) Do this task: Leading Edge Access Panel Installation, TASK 57-41-02-400-801.

———— **END OF TASK** ————

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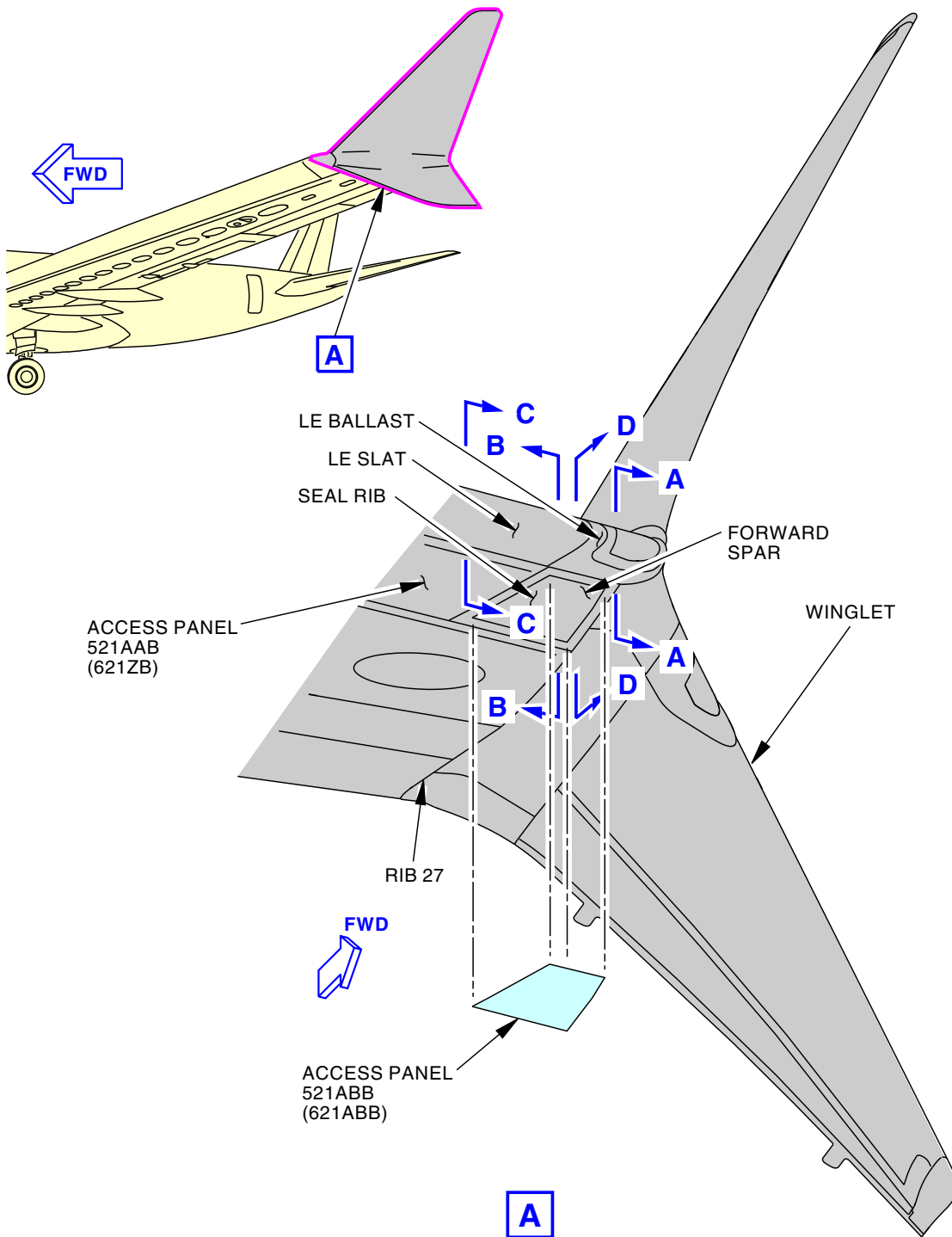
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Leading Edge Seal Rib Fillet Seals
Figure 601/57-44-03-990-801 (Sheet 1 of 6)

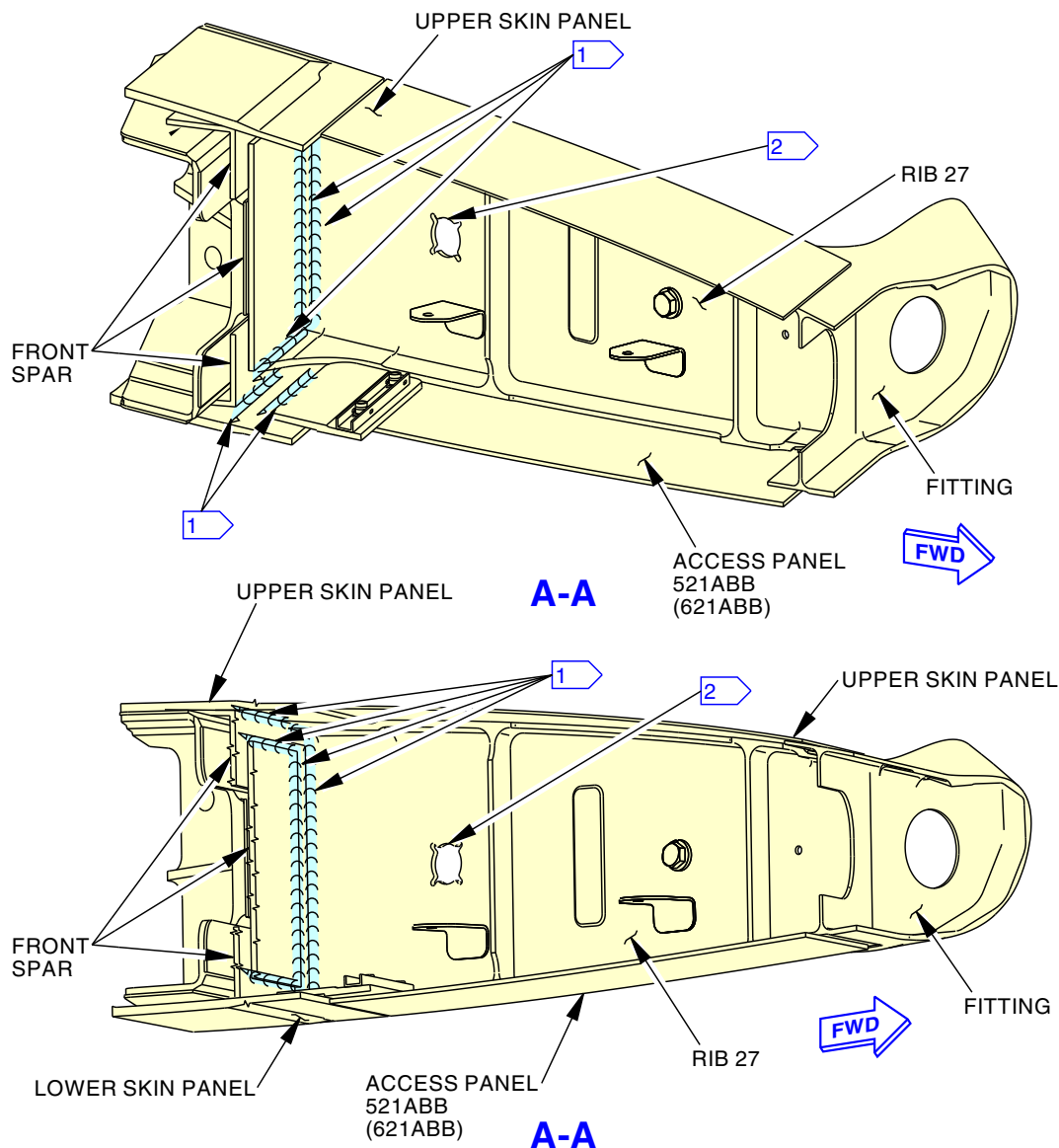
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- 1 FILLET SEAL BMS 5-142, >>> OR >>>
- 2 TOOL HOLE SEAL BMS 5-142
- 3 DO NOT FILL WITH SEALANT, KEEP OPEN, DRAINAGE PATH]
- 4 INJECTION SEAL BMS 5-142 XXX
- 5 PANEL GAPS SEAL BMS 5-95 —
- 6 SEALANT STOP
- 7 APPLY PARTING AGENT TO REMOVABLE LOWER PANEL COMMON TO SEAL RIB
- 8 AERO SEAL GAPS SEAL BMS 5-142, FLUSH WITH SKIN

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Leading Edge Seal Rib Fillet Seals
Figure 601/57-44-03-990-801 (Sheet 2 of 6)

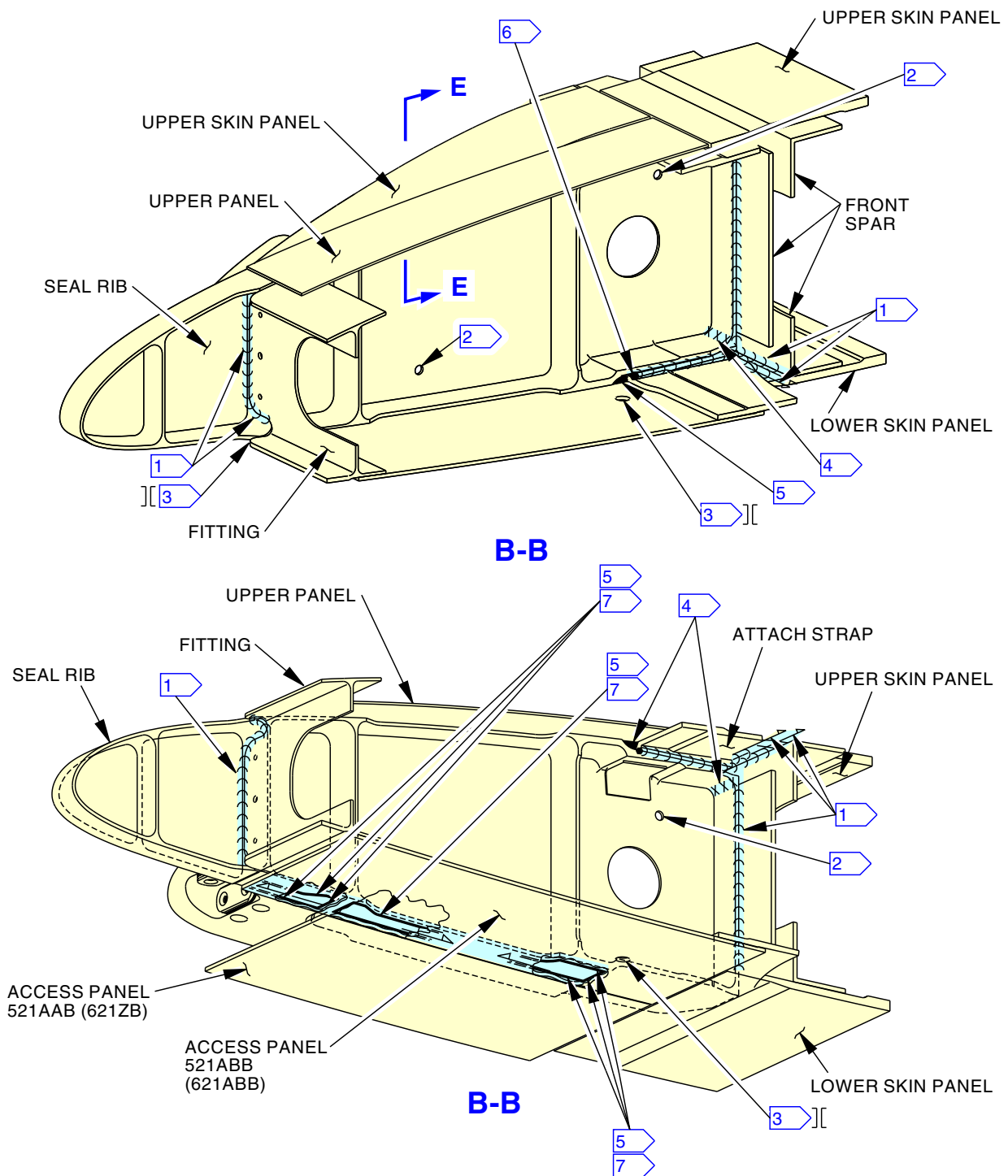
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Leading Edge Seal Rib Fillet Seals
Figure 601/57-44-03-990-801 (Sheet 3 of 6)

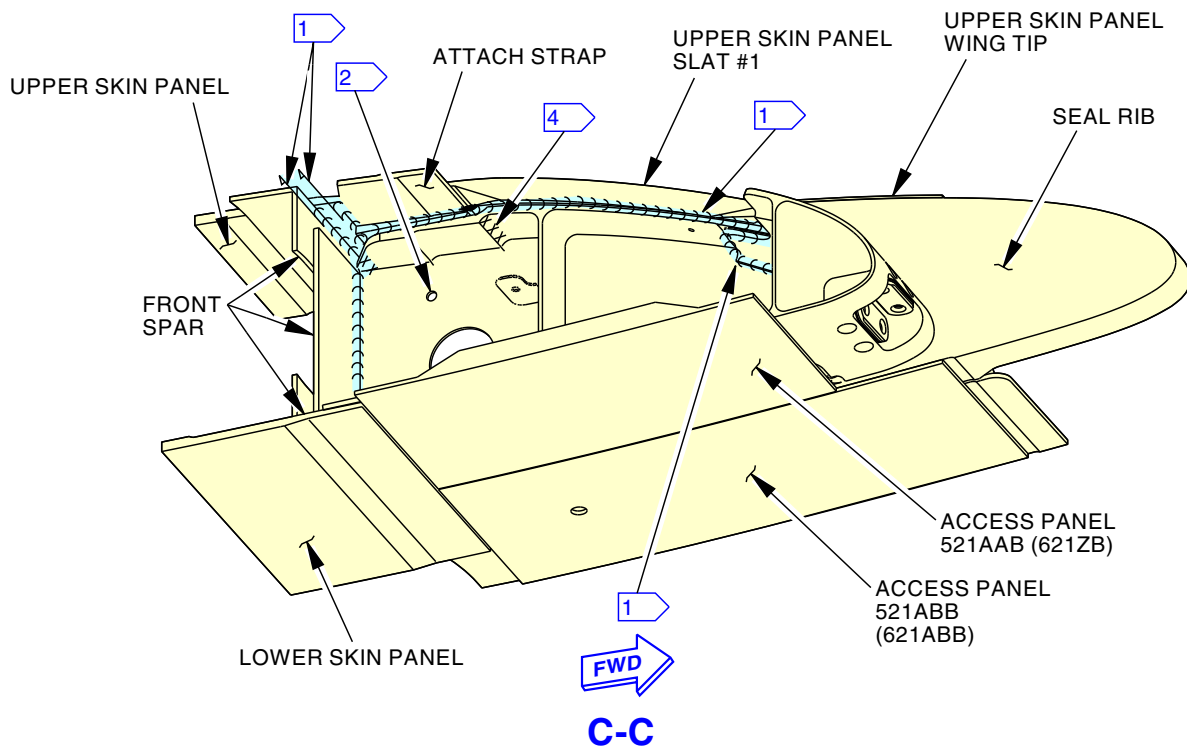
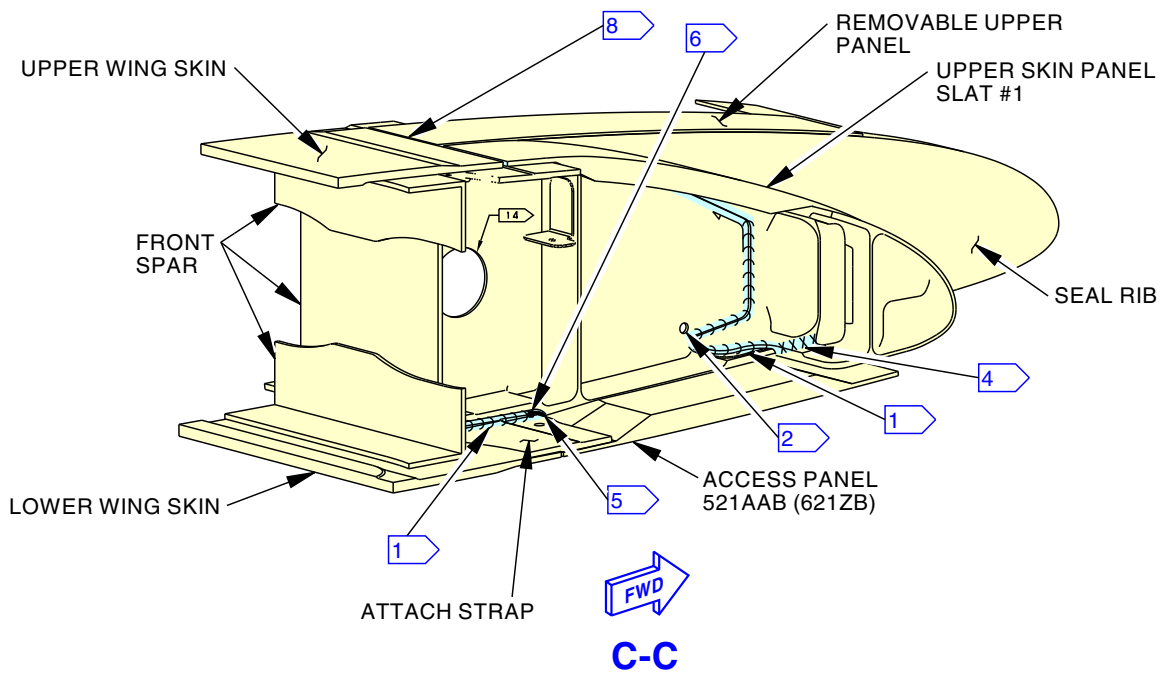
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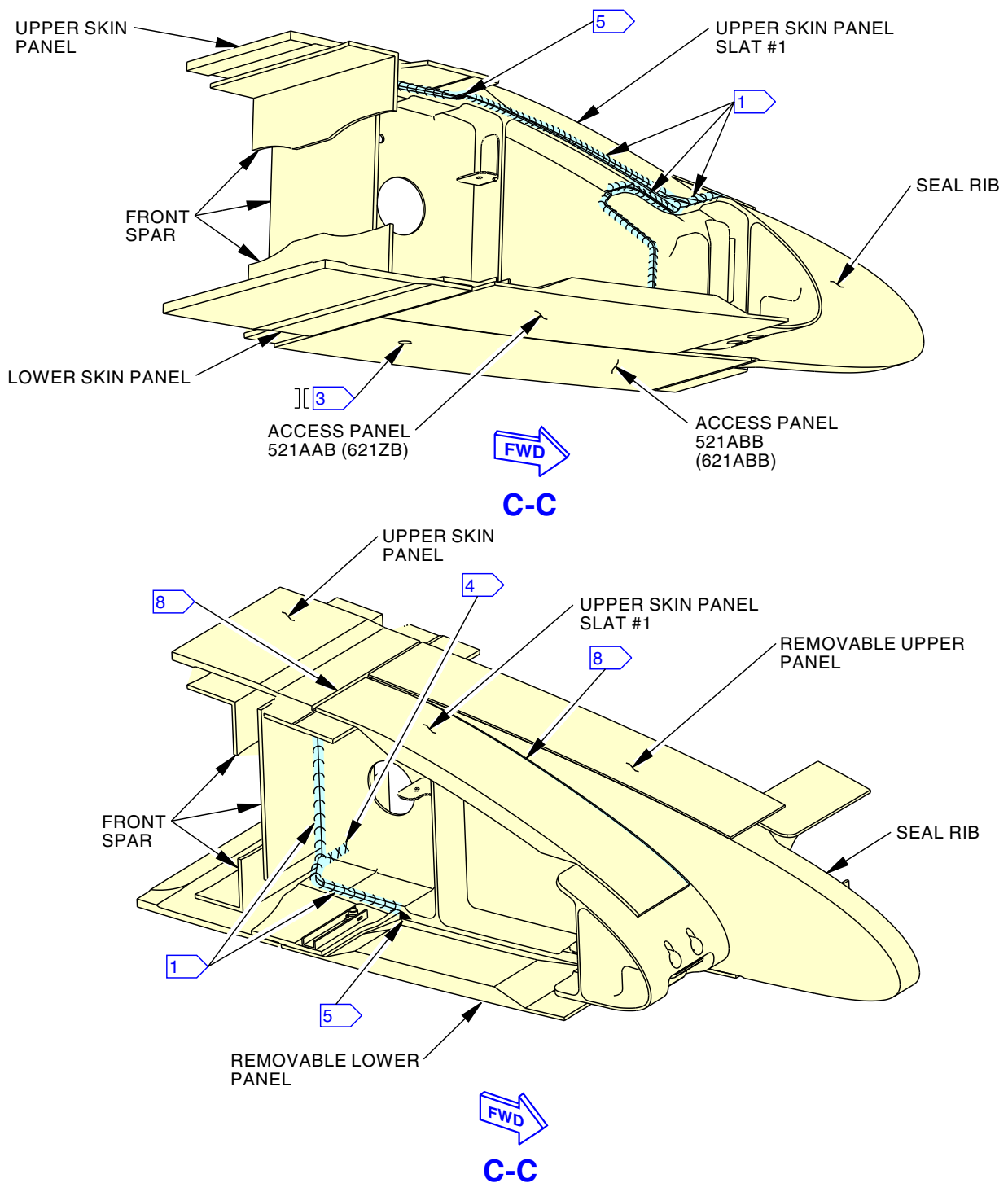
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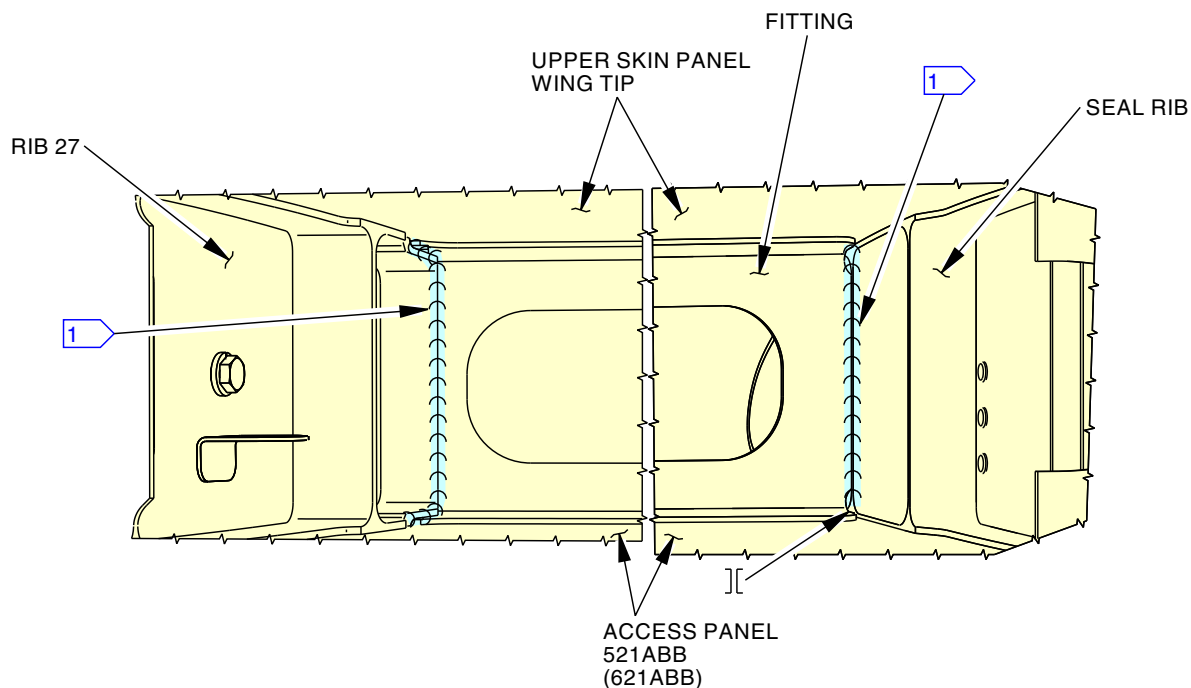
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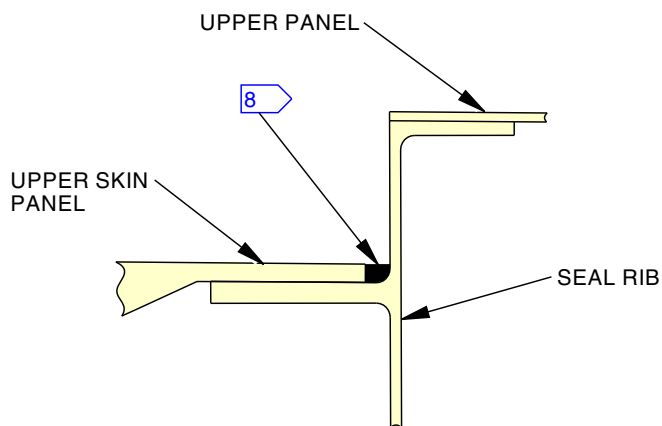
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OUTBOARD LEADING EDGE SEAL RIB - REPAIR

1. General

- A. This procedure has the task to repair the fillet seals on the seal rib that is adjacent to the leading edge slats.

TASK 57-44-03-390-801

2. Repair of Sealant at Leading Edge Seal Rib

A. **General**

- (1) This task gives the procedure to apply sealant to seal the forward spar and the leading edge seal rib for vapor leaks.

B. **References**

Reference	Title
51-22-00-390-806	Fillet Seal Application (P/B 201)
57-41-02-000-801	Leading Edge Access Panel Removal (P/B 201)
57-41-02-400-801	Leading Edge Access Panel Installation (P/B 201)

C. **Tools/Equipment**

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-768	Sealant Removal Tool, Non-Metallic Part #: ST982L-9 Supplier: 81205 Part #: ST982LF-9 Supplier: 81205 Part #: ST982LH-A-1 Supplier: 81205
STD-449	Gun - Sealant
STD-600	Mirror - Inspection
STD-1081	Flashlight - Explosion Proof

D. **Consumable Materials**

Reference	Description	Specification
A02315	Sealant - Low Density, Synthetic Rubber. 2 Part	BMS5-142 Type II
B00083	Solvent - VM&P Naphthas	TT-N-95 Type II, ASTM D-3735 Type III
B00130	Alcohol - Isopropyl	TT-I-735
B00184	Solvent - Presealing, Cleaning Solvent	BMS11-7
B00666	Solvent - Methyl Propyl Ketone	BMS11-9
C00012	Coating - Akzo Nobel Clear Polyurethane Topcoat, 683-3-2 Base with X-310A Catalyst (Akzo Nobel Aerospace Coatings)	
C50238	Coating - Akzo Nobel Clear Polyurethane Topcoat, 683-3-20 Base with X-310A Catalyst (Akzo Nobel Aerospace Coatings)	
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23

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Reference	Description	Specification
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	AMS3819 Class 1 Grade A or B Form 1 (Supersede BMS15-5 CLA)
G00268	Brush - Soft Bristle, Paint	
G00834	Cloth - Lint-free Cotton	
G01061	Water - Distilled	

E. Location Zones

Zone	Area
500	Left Wing
521	Left Wing - Leading Edge to Front Spar
600	Right Wing
621	Right Wing - Leading Edge to Front Spar

F. Prepare for the Procedure

SUBTASK 57-44-03-010-002

- (1) Do the task: Leading Edge Access Panel Removal, TASK 57-41-02-000-801.

SUBTASK 57-44-03-212-003

- (2) Examine the area you think contains a leak.
- (a) Look for seal defects such as cracked or loose fillets, pinholes, or loose fasteners.
 - (b) Refer to Leading Edge Seal Rib Fillet Seals/Figure 801 to examine the attach fitting for the leading edge ballast, the seal rib and rib 27.
 - (c) Use an explosion proof flashlight, STD-1081 when you look inside the leading edge area.
 - (d) If it is necessary, use an inspection mirror, STD-600 to examine seals which are difficult to see.
 - (e) You can increase the seal plane to isolate a bad seal.
NOTE: Because you add a large quantity of sealant when you increase the seal plane above the initial seal plane, it is better to replace the bad seal.
 - 1) Examine the structure around the bad seal to find where to increase the seal plane.
 - 2) Apply a new fillet seal around the structure with the applicable seals and fasteners to increase the seal plane.
 - (f) You can remove the sealant to replace the bad seal.

SUBTASK 57-44-03-140-001

- (3) Use the sealant removal tool, SPL-768 to remove the bad sealant in the fillet seal.
- (a) Cut the ends of the bad sealant at a slope such that the new sealant makes an overlap with the remaining sealant.
 - 1) Make sure that you cut the sealant smoothly.
 - (b) If the fillet seal bond is good, it is not necessary to cut the sealant to the metal.
 - 1) Make sure that you remove all sealant that is loose.
 - (c) If the bad sealant includes fasteners with fillet seals, do the steps that follow:
 - 1) Cut around the bottom of the fastener with a sealant cutting tool.
 - 2) Use a pliers and pull the sealant from the fastener.

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- a) It is not necessary to remove small quantities of the sealant that bond to the fastener.
- (d) If the fillet seal is to be applied to cured structural adhesives, remove all adhesive material that has not adhered to the metal or primed surface.
 - 1) Scrape the adhesive with a abrasive-free hardwood or plastic tool to remove the loose adhesive.
 - a) It is not necessary to remove adhesive that remains bonded to the metal or primed surface after you scrape the loose adhesive.

SUBTASK 57-44-03-160-001

- (4) For surfaces covered with corrosion inhibiting compound, G00009 (BMS 3-23), clean the surface around the repair area as follows:
 - (a) Wipe off excess corrosion inhibiting compound, G00009 with a clean, lint-free cloth, G00834.
 - (b) Clean the area approximately 1.0 in. (25.4 mm) larger than the area to be sealed to prevent contamination from the corrosion inhibiting compound, G00009.
 - 1) Make that the surface is clean with a new, clean cotton wiper, G00034 moist with solvent, B00083 or solvent, B00666.
 - 2) Wipe the surface with a new, clean, dry cloth to remove excess solvent.
 - a) Do not let the solvent become dry on the surface.
 - 3) Replace the cloth as the cloth becomes soiled.
 - 4) Continue to clean and dry the surfaces until the a clean, dry cloth remains clean.
 - 5) Do not touch the cleaned area with your fingers or allow the surface to become contaminated.

SUBTASK 57-44-03-160-002

- (5) If there is topcoat on the surface of the sealant, remove all the topcoat from the sealant repair area.
 - (a) Use abrasive paper and remove the used topcoat until the sealant is shown and is in good condition.
 - (b) Use clean, cotton wiper, G00034 soaked with solvent, B00083 or solvent, B00666 to clean all surfaces and sealant from which you removed the topcoat.
 - (c) Wipe the surface with a clean, dry cloth to remove excess solvent; do not let the solvent become dry on the surface.
 - (d) Continue to clean and dry the surfaces until the a clean, dry cloth remains clean.
 - (e) Do not touch the cleaned area with your fingers or allow the surface to become contaminated.

SUBTASK 57-44-03-160-003

- (6) Immediately before you apply the sealant, clean the surface with a clean cotton wiper, G00034 moist with solvent, B00083 or solvent, B00666.
 - (a) Wipe the surface with a clean dry cloth to remove excess solvent.
 - 1) Do not let the solvent become dry on the surface.
 - (b) Do not touch the cleaned area with your fingers or allow the surface to become contaminated.

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G. Wing Leading Edge Seal Ribs and Forward Spar Repair - Fillet Seals

SUBTASK 57-44-03-390-001

- (1) To apply a new fillet seal of sealant, A02315, do the steps that follow:
 - (a) Refer to this task for the method and examples to apply a fillet seal: Fillet Seal Application, TASK 51-22-00-390-806.
 - (b) Examine the seal area to make sure you have the correct selection of tools for the job.
 - 1) Use an explosion proof flashlight, STD-1081 when you look inside the leading edge area.
 - 2) If it is necessary, use an inspection mirror, STD-600 to examine seals which are difficult to see.
 - (c) Apply a small fillet seal of sealant with the sealant gun, STD-449.
 - (d) Use a sealant fairing tool and push the fillet seals tightly into position.
 - 1) Make sure all sealant fairing tools are clean.
 - a) Use a clean cotton wiper, G00034.
 - b) Use a solution of alcohol, B00130 and distilled water, G01061, mixed to a ratio of 1:5 or 1:6 by volume to wet the tool surface to prevent sticking of the sealant to the fairing tools.
 - (e) If the first fillet seal is hard, but is not clean, then it must be cleaned before you apply the second fillet seal.
 - (f) Apply sealant a second time to make a full bodied fillet seal.
 - 1) If you do not use an extruded nozzle, use a sealant fairing tool to make a full bodied fillet seal.
 - 2) Remove all air bubbles and re-entrant fillet seal edges.

H. Apply a Corrosion Resistant Finish (Topcoat)

SUBTASK 57-44-03-390-002

- (1) If there is topcoat on the surface of the old sealant, apply a corrosion resistant finish (topcoat) to all exposed new sealant.

NOTE: The new sealant must become dry and tack free before the corrosion resistant finish (topcoat) can be applied.

 - (a) Prepare a two-part Akzo Nobel 683-3-2 coating, C00012 or Akzo Nobel 683-3-20 coating, C50238 for a topcoat per manufacturer's instructions.
 - (b) Use clean, cotton wiper, G00034 soaked with solvent, B00184 or solvent, B00666 to clean all surfaces and sealant before you apply the topcoat.
 - 1) Wipe the surface with a clean, dry cloth to remove excess solvent.
 - a) Do not let the solvent become dry on the surface.
 - 2) Continue to clean and dry the surfaces until the a clean, dry cloth remains clean.
 - 3) Do not touch the cleaned area with your fingers or allow the surface to become contaminated.
 - (c) Apply the finish coating with a brush, G00268.

SUBTASK 57-44-03-390-003

- (2) If there is corrosion inhibiting compound on the surface of the old sealant, apply corrosion inhibiting compound, G00009 (BMS 3-23) to the area of repair after all sealant and corrosion resistant finish (topcoat) application is completed.

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I. Put the Airplane Back to the Usual Condition

SUBTASK 57-44-03-410-002

(1) Do this task: Leading Edge Access Panel Installation, TASK 57-41-02-400-801.

———— **END OF TASK** ————

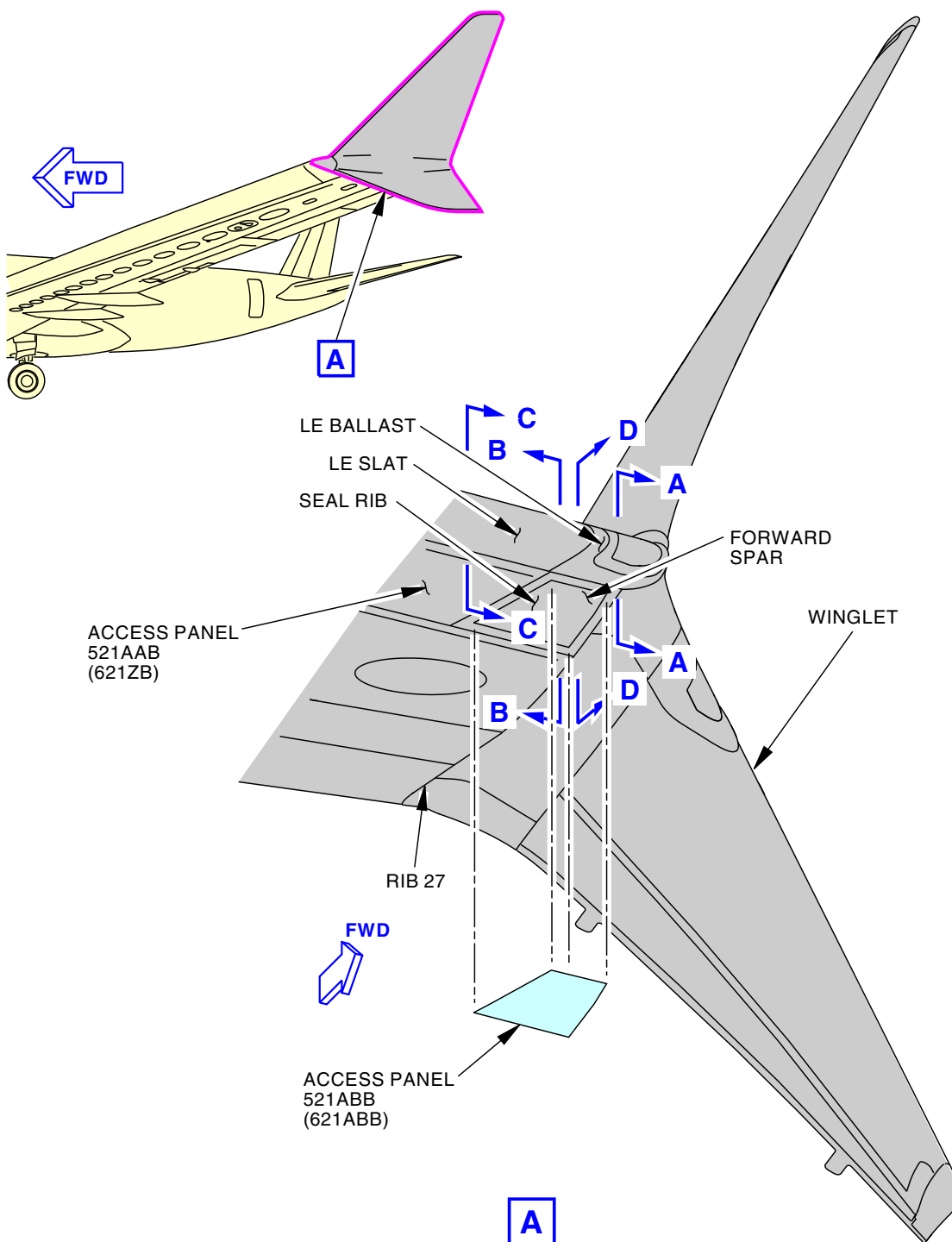
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Leading Edge Seal Rib Fillet Seals
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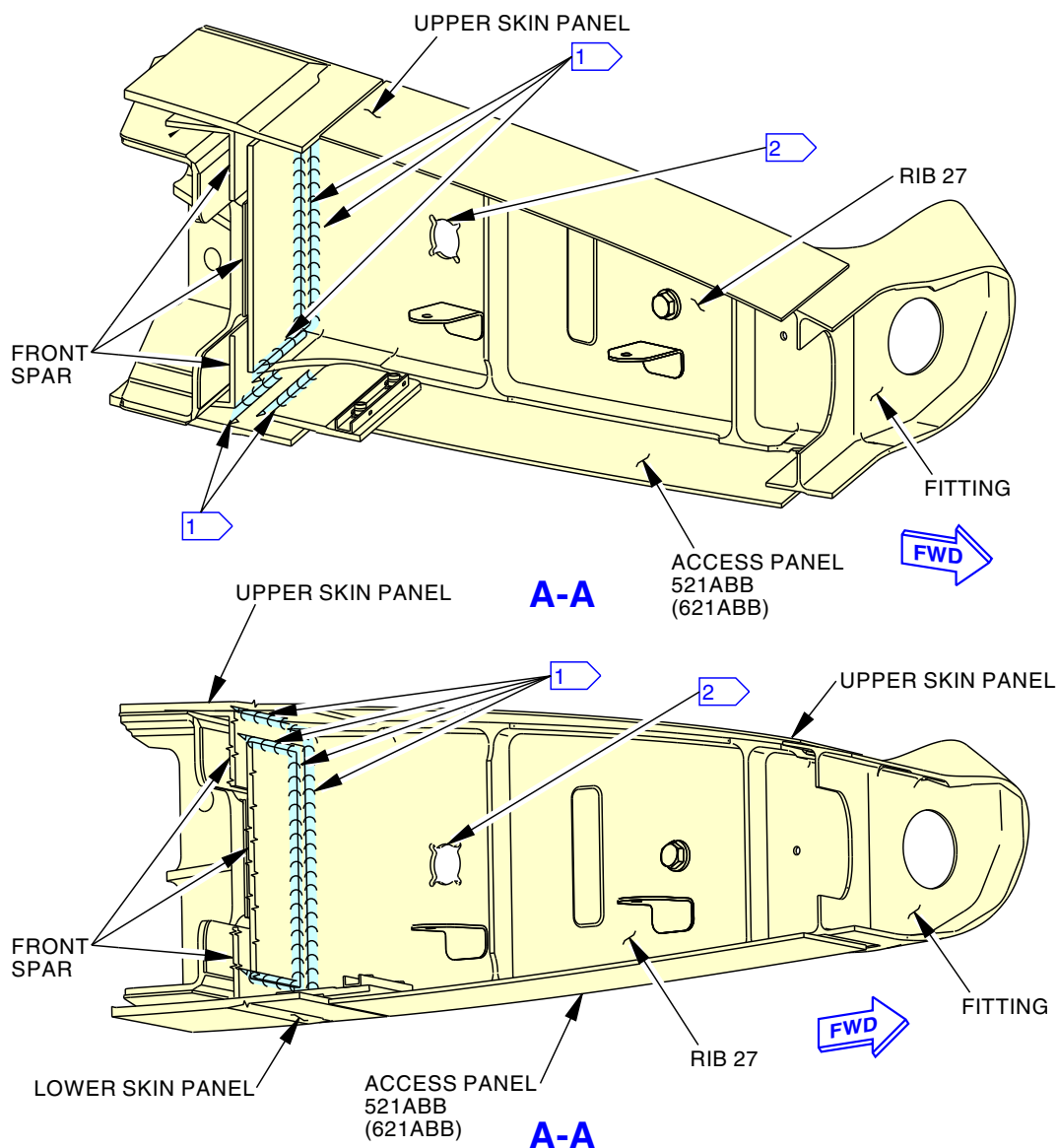
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- 1 FILLET SEAL BMS 5-142,  OR 
- 2 TOOL HOLE SEAL BMS 5-142
- 3 DO NOT FILL WITH SEALANT, KEEP OPEN, DRAINAGE PATH 
- 4 INJECTION SEAL BMS 5-142 
- 5 PANEL GAPS SEAL BMS 5-95 
- 6 SEALANT STOP
- 7 APPLY PARTING AGENT TO REMOVABLE LOWER PANEL COMMON TO SEAL RIB
- 8 AERO SEAL GAPS SEAL BMS 5-142, FLUSH WITH SKIN

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Leading Edge Seal Rib Fillet Seals
Figure 801/57-44-03-990-802 (Sheet 2 of 6)

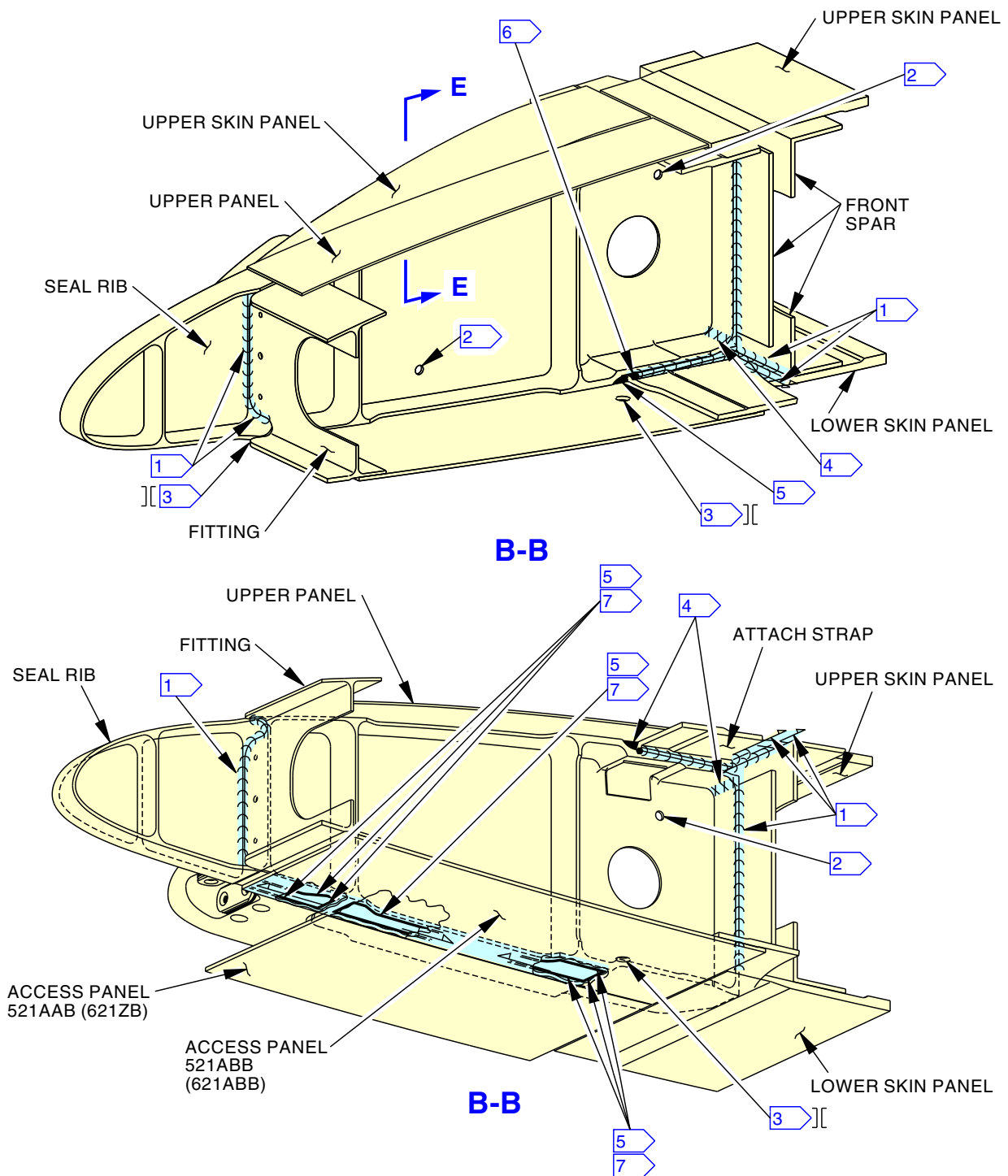
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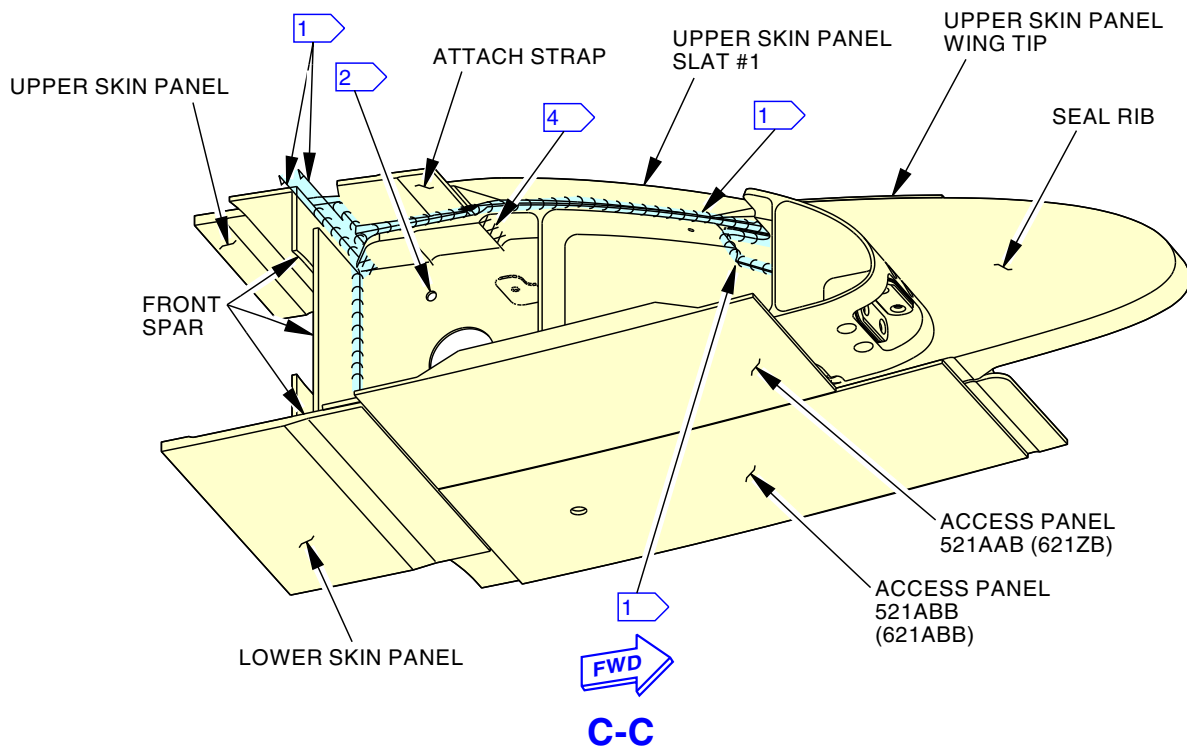
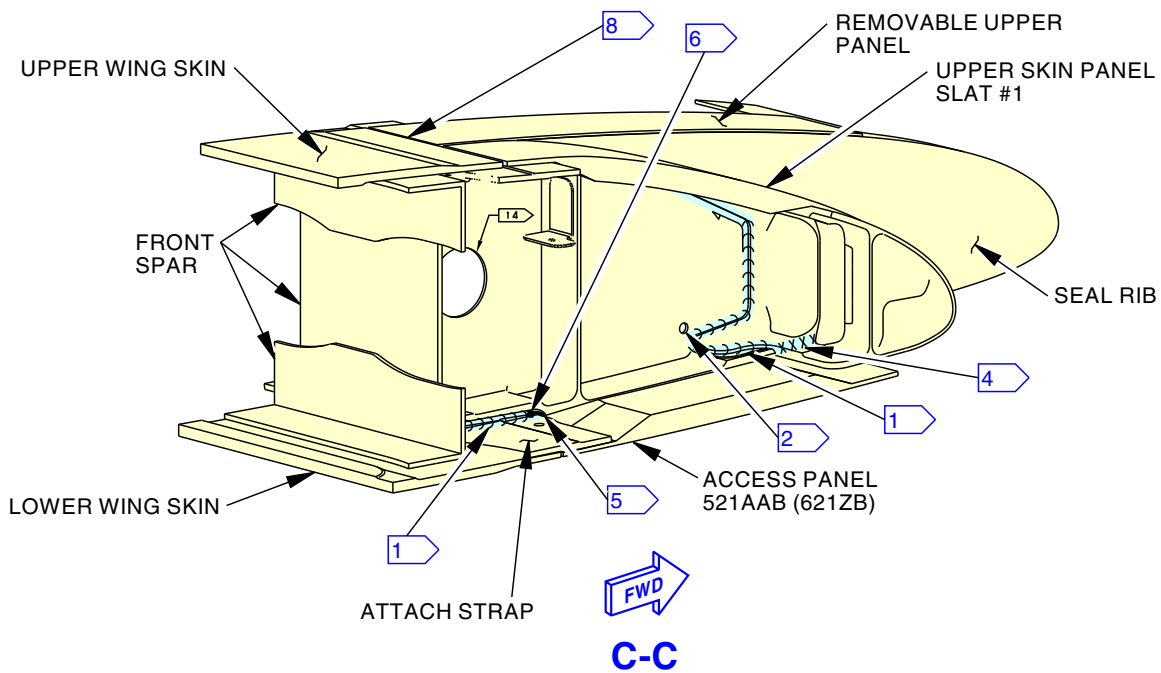
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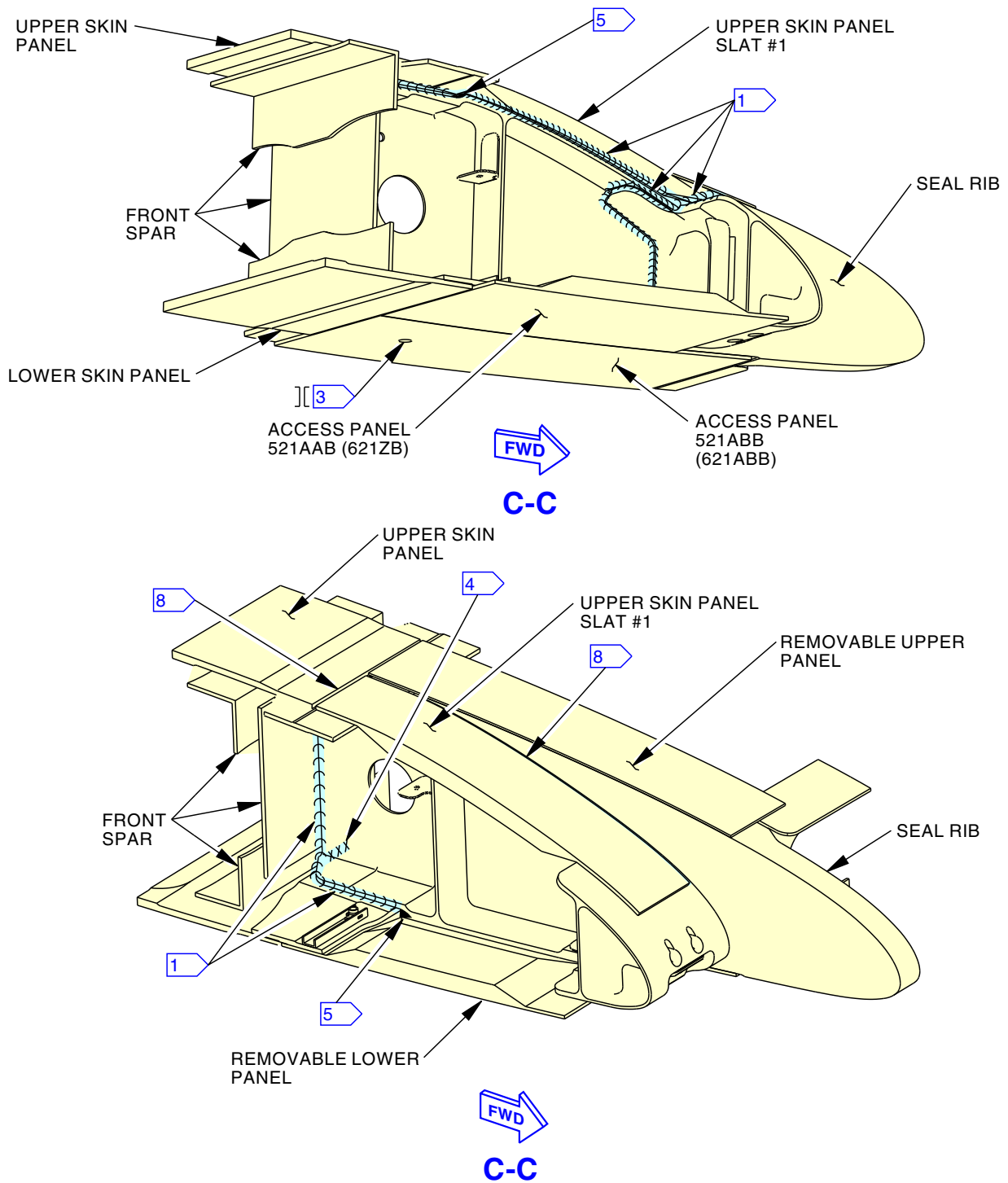
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Leading Edge Seal Rib Fillet Seals
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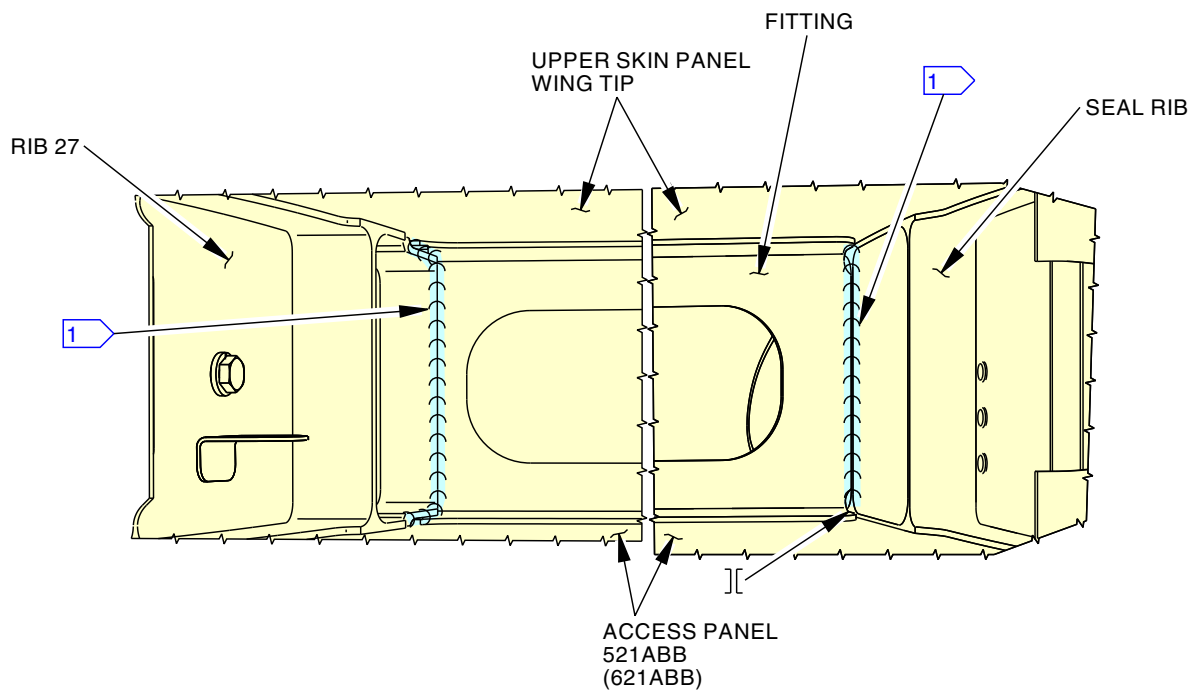
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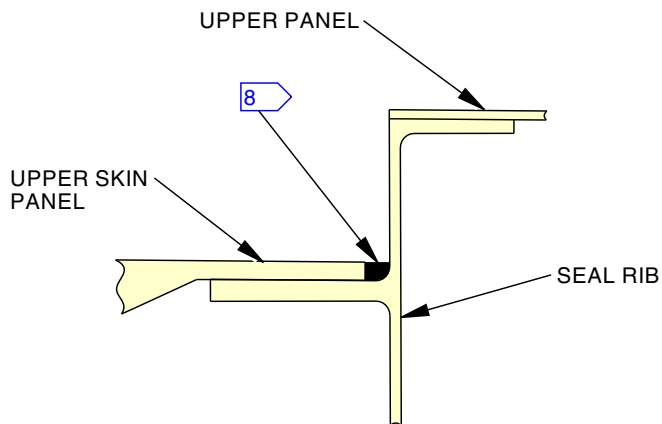
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Leading Edge Seal Rib Fillet Seals
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FIXED TRAILING EDGE UPPER PANEL - REMOVAL/INSTALLATION

1. General

A. This procedure contains these task:

- (1) Inboard fixed trailing edge upper panel removal
- (2) Inboard fixed trailing edge upper panel installation.

TASK 57-50-01-000-801

2. Inboard Fixed Trailing Edge Upper Panel Removal

A. **General**

- (1) This task has the steps to remove the inboard fixed trailing edge upper panels.
- (2) This task has one or more steps which are a means to satisfy Critical Design Configuration Control Limitation (CDCCL) requirements. A CDCCL note will follow the step to which it applies. Any step or sub-step that precedes or follows a CDCCL identified step is not subject to the CDCCL requirement.
 - (a) For important information on CDCCL requirements, refer to this task: Airworthiness Limitation Precautions, TASK 57-00-00-910-802.

NOTE: This is applicable to Airworthiness Limitation 28-AWL-02.

B. **References**

Reference	Title
27-51-00-040-801	Trailing Edge Flap System Deactivation (P/B 201)
27-51-00-860-803	Extend the Trailing Edge Flaps (P/B 201)
27-61-00-800-802	Depressurization of the Spoiler Hydraulic Systems A and B (P/B 201)
28-11-00-211-803	External Wires Mounted Near the Rear Spar Inspection (P/B 601)
32-00-01-480-801	Landing Gear Downlock Pins Installation (P/B 201)
57-00-00-910-802	Airworthiness Limitation Precautions (P/B 201)
SRM 51-40-02	FASTENER INSTALLATION AND REMOVAL

C. **Tools/Equipment**

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
SPL-1744	Set - Lock, Inboard Ground Spoiler Actuator (Contains 4 Lock Assemblies) Part #: C27046-13 Supplier: 81205 Opt Part #: C27046-1 Supplier: 81205

D. **Location Zones**

Zone	Area
561	Left Wing - Rear Spar to Trailing Edge, Outboard Of Inboard Flap, Inboard of Fixed Trailing Edge
661	Right Wing - Rear Spar to Trailing Edge, Outboard of Inboard Flap, Inboard of Fixed Trailing Edge

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E. Prepare for the Removal

SUBTASK 57-50-01-480-001



MAKE SURE THAT THE DOWNLOCK PINS ARE INSTALLED ON ALL THE LANDING GEAR. WITHOUT THE DOWNLOCK PINS, THE LANDING GEAR CAN RETRACT. THIS CAN CAUSE INJURIES TO PERSONS, AND DAMAGE TO EQUIPMENT.

- (1) Make sure that the downlock pins are installed on the nose and main landing gear (TASK 32-00-01-480-801).

SUBTASK 57-50-01-860-001

- (2) Extend the trailing edge flaps (TASK 27-51-00-860-803).

SUBTASK 57-50-01-860-002

- (3) Deploy spoilers to get access to the fixed upper panels.

SUBTASK 57-50-01-040-001

- (4) Do this task: Trailing Edge Flap System Deactivation, TASK 27-51-00-040-801.

SUBTASK 57-50-01-430-001

- (5) Install the lock-set, SPL-1744 on the actuator for the applicable ground spoiler.

SUBTASK 57-50-01-040-002

- (6) Do the deactivation procedure for the spoilers (TASK 27-61-00-800-802).

F. Inboard Fixed Trailing Edge Upper Panel Removal

SUBTASK 57-50-01-010-001

- (1) Remove the fixed upper panel [1].
 - (a) Disconnect the electrical connectors [37] from the support bracket (View H, Figure 401).
 - (b) Remove the clamps [40] and screws [41] supporting the wire harness.
 - (c) Move the wire harness away from the fixed upper panel [1].
 - (d) Remove the screws [38] and washers [39] from the support bracket.
 - (e) Remove the bolts [42] and washers [43] from the clamp block.
 - (f) Remove the sealant from the upper surface of the panel to expose the two bolts [19], four bolts [20] and seven bolts [21] that attach the ribs to the fixed upper panel [1] (View E, Figure 401).
 - (g) Remove the rivets [34] from the fixed upper panel [1] (SRM SUBJECT 51-40-02).
 - (h) Remove the hex drive bolts [35] and collars [36] from the fixed upper panel [1] (SRM SUBJECT 51-40-02).
 - (i) Remove the two bolts [19], four bolts [20] and seven bolts [21].
 - (j) Disconnect the upper links of the turnbuckle [3], turnbuckle [4], and turnbuckle [5] from the fixed upper panel [1] (View A, Figure 401).
 - 1) Remove the bolts [7], washers [8], washers [9], washers [10] and nuts [11] (View B, Figure 401).
 - (k) Remove the bolt [12], washer [13], bushings [14], washer [15] and nut [16] (View C, Figure 401).
 - (l) Remove the bolt [17], washer [13], bushings [18], washer [15] and nut [16] (View D, Figure 401).
 - (m) Remove the fixed upper panel [1].

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SUBTASK 57-50-01-010-002

- (2) Remove the fixed upper panel [2].
 - (a) Remove the nut [30], washer [31] and jumper [32] from the fixed upper panel [2] (View G, Figure 401).
 - (b) Remove the sealant from the upper surface of the panel to expose the bolts [33] that attach the wing to body fairing to the fixed upper panel [2] (View F, Figure 401).
 - (c) Remove the bolts [33].
 - (d) Disconnect the upper links of the two turnbuckles [6] from the fixed upper panel [2].
 - 1) Remove the bolts [26], washers [27], washers [28] and nuts [29].
 - (e) Remove the bolts [22], washers [23], washers [24] and nuts [25].
 - (f) Remove the fixed upper panel [2].

SUBTASK 57-50-01-210-001

28-AWL-02: CDCCL

- (3) If you remove the panels to do maintenance, preventative maintenance, or alteration in any area within 12 in. (305 mm) from the fuel tanks (rear spar), do these steps:

NOTE: CDCCL - Refer to the task: Airworthiness Limitation Precautions, TASK 57-00-00-910-802, for important information on Critical Design Configuration Control Limitations (CDCCLs).

NOTE: This is applicable to Airworthiness Limitation 28-AWL-02

28-AWL-02: CDCCL

- (a) Make sure that you do not change the routing and clamping of the wires near the rear spar.

NOTE: CDCCL - Refer to the task: Airworthiness Limitation Precautions, TASK 57-00-00-910-802, for important information on Critical Design Configuration Control Limitations (CDCCLs).

NOTE: This is applicable to Airworthiness Limitation 28-AWL-02

28-AWL-02: CDCCL

- (b) Before you install the panels, do this task only in the areas where you removed the panels and maintenance was performed: External Wires Mounted Near the Rear Spar Inspection, TASK 28-11-00-211-803.

NOTE: CDCCL - Refer to the task: Airworthiness Limitation Precautions, TASK 57-00-00-910-802, for important information on Critical Design Configuration Control Limitations (CDCCLs).

NOTE: This is applicable to Airworthiness Limitation 28-AWL-02

———— **END OF TASK** ————

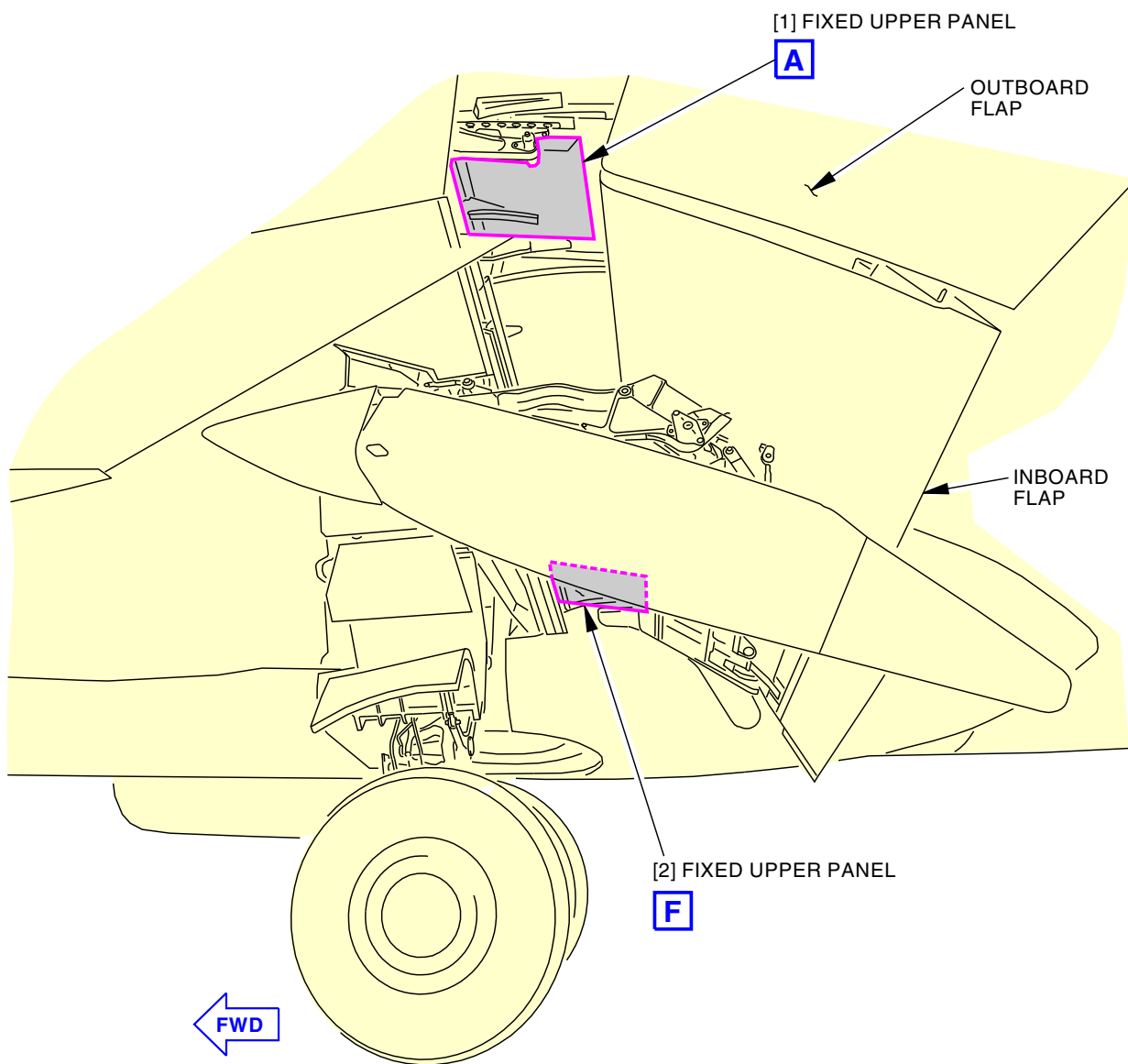
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2416679 S00061541282_V2

Inboard Fixed Trailing Edge Upper Panel Installation
Figure 401/57-50-01-990-801 (Sheet 1 of 7)

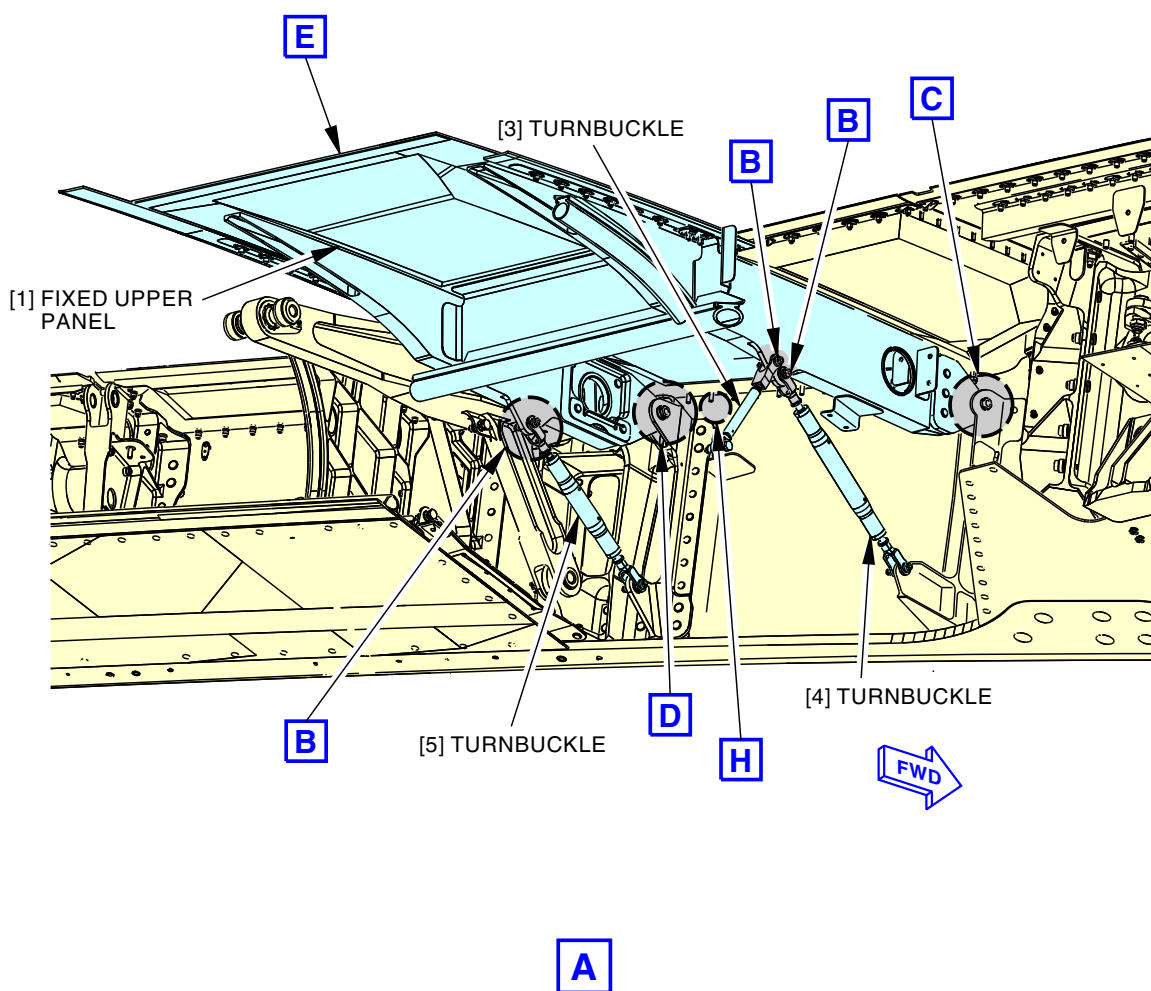
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2416680 S00061541283_V3

Inboard Fixed Trailing Edge Upper Panel Installation
Figure 401/57-50-01-990-801 (Sheet 2 of 7)

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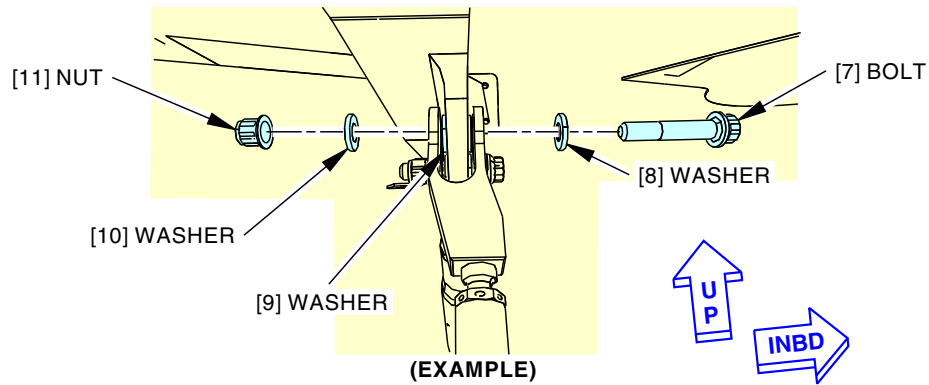
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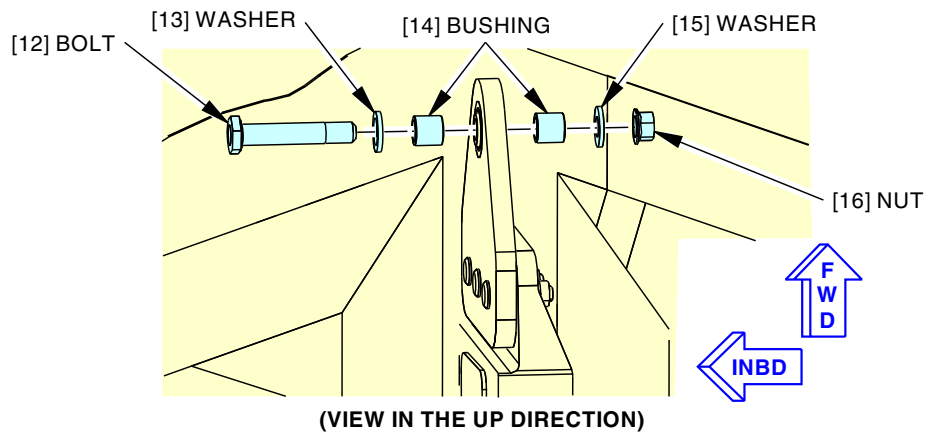
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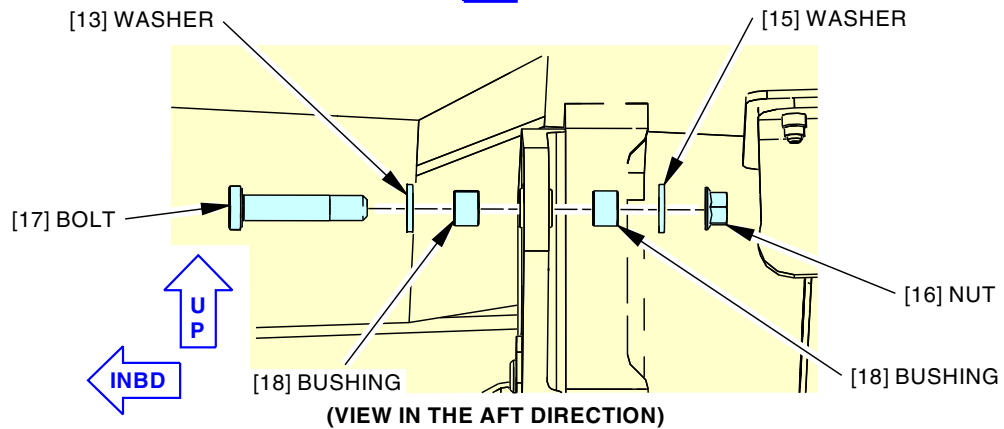
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B



C



D

2465422 S0000575058_V1

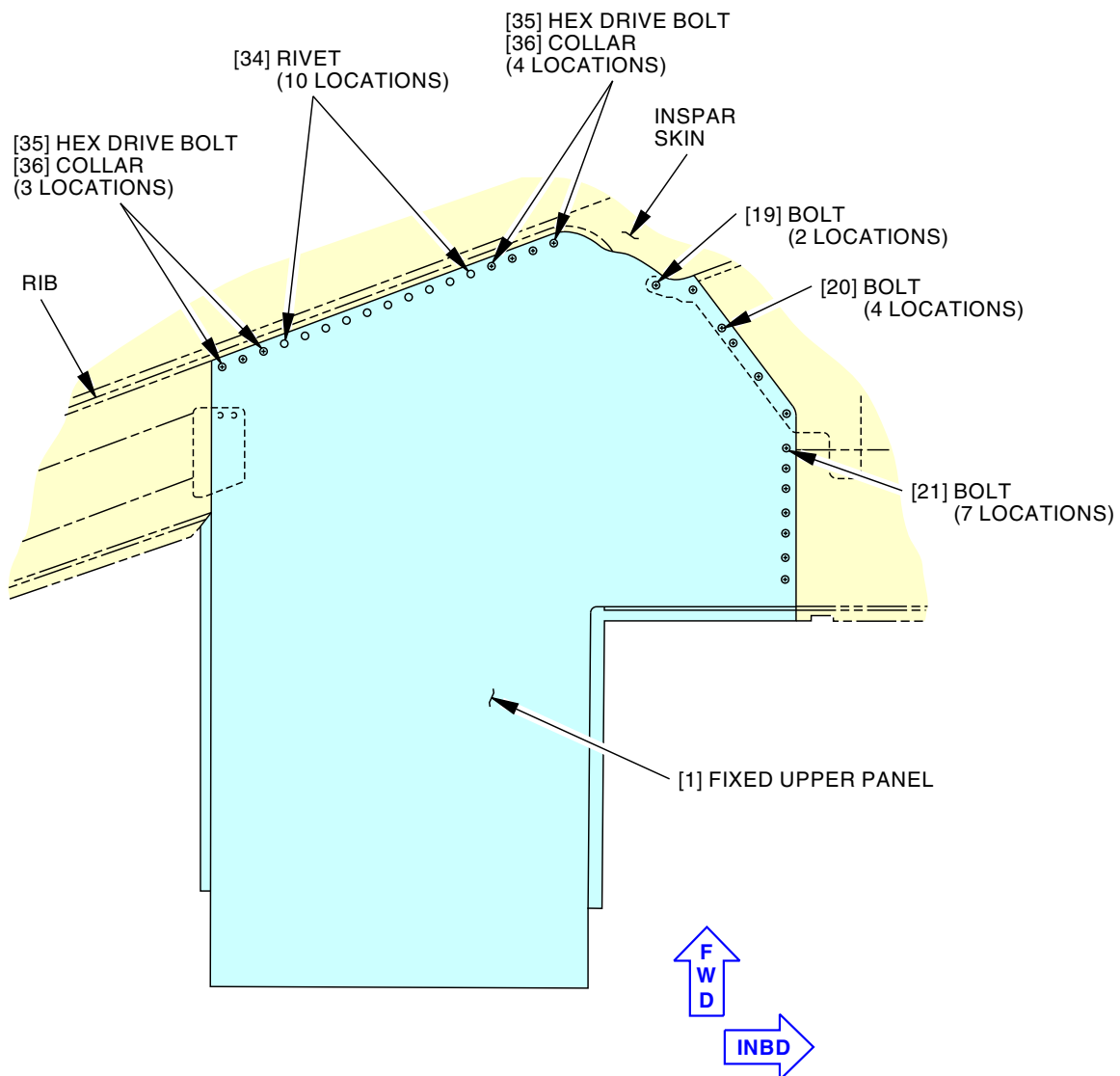
Inboard Fixed Trailing Edge Upper Panel Installation
Figure 401/57-50-01-990-801 (Sheet 3 of 7)

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E

(VIEW IN THE DOWN DIRECTION)

2416681 S00061541284_V3

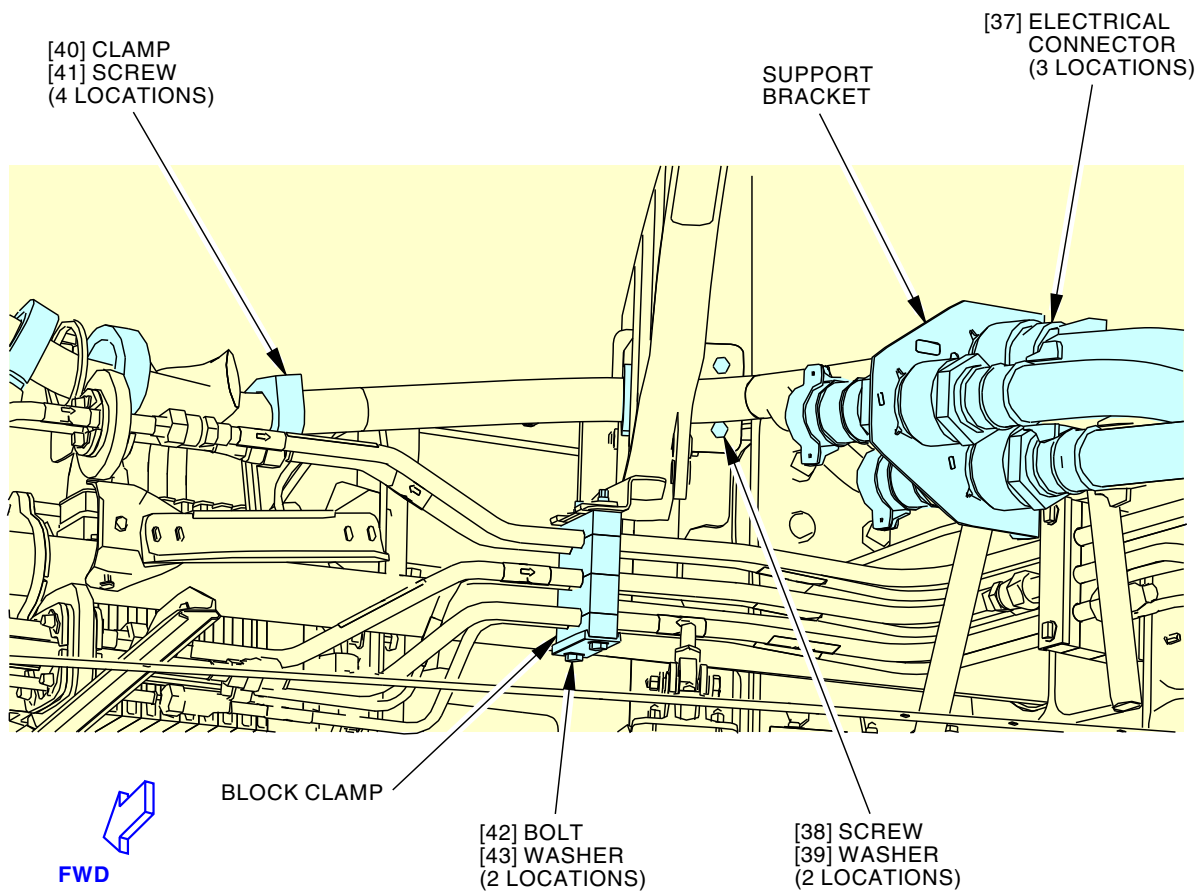
Inboard Fixed Trailing Edge Upper Panel Installation
Figure 401/57-50-01-990-801 (Sheet 4 of 7)

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2548060 S0000606074_V1

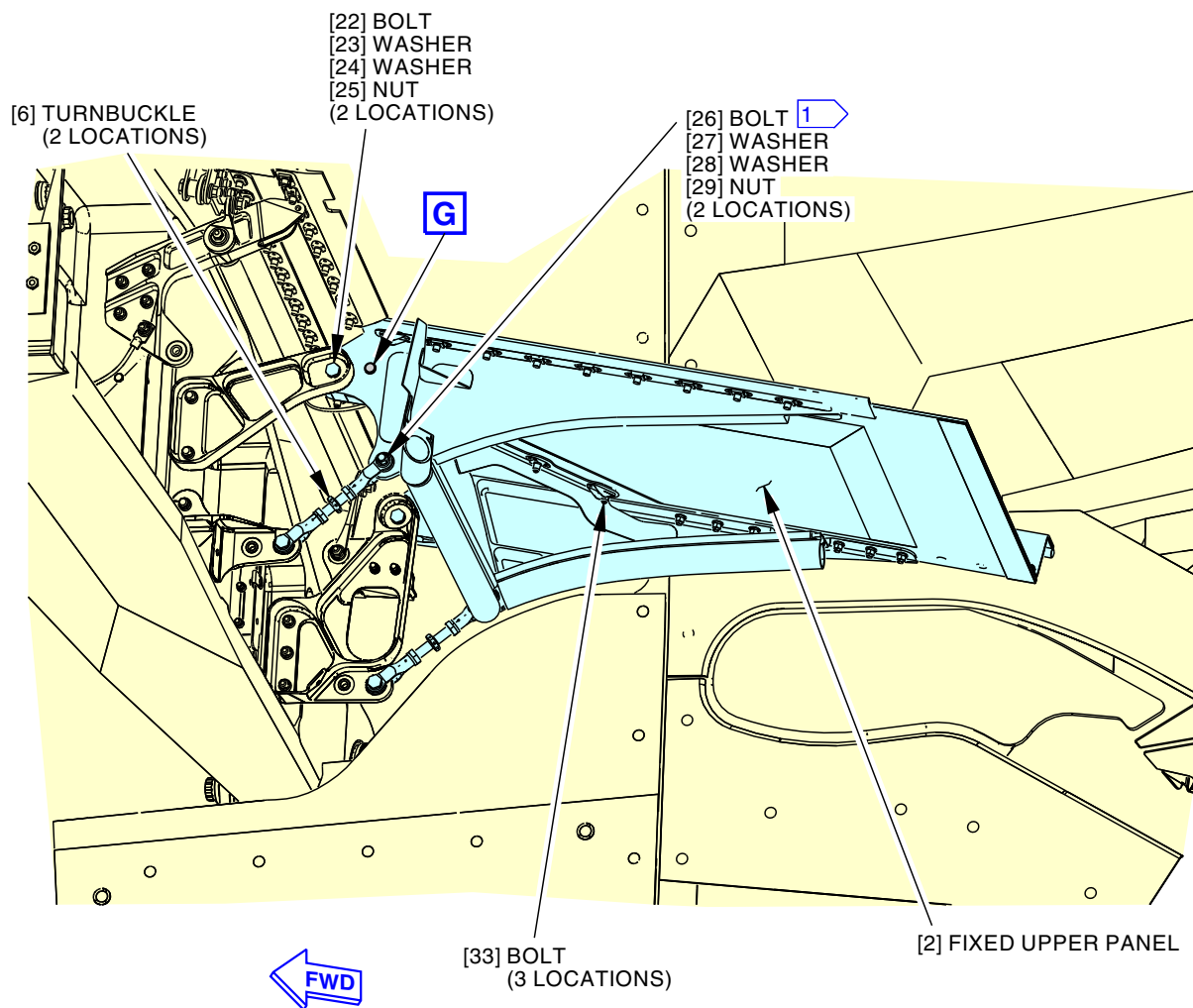
Inboard Fixed Trailing Edge Upper Panel Installation
Figure 401/57-50-01-990-801 (Sheet 5 of 7)

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1 BOLT HEAD IS INBOARD

(VIEW IN THE UP DIRECTION)

F

2416682 S00061541285_V3

Inboard Fixed Trailing Edge Upper Panel Installation
Figure 401/57-50-01-990-801 (Sheet 6 of 7)

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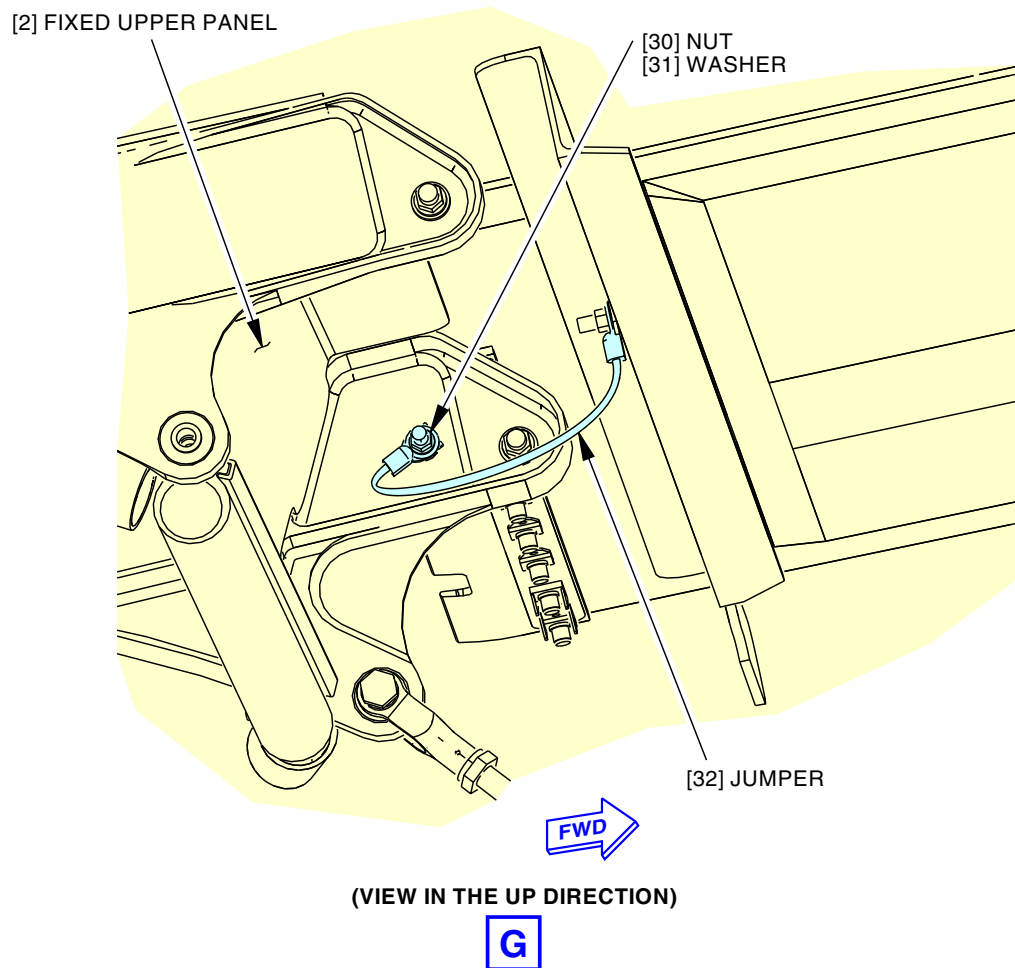
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Inboard Fixed Trailing Edge Upper Panel Installation
Figure 401/57-50-01-990-801 (Sheet 7 of 7)

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TASK 57-50-01-400-801

3. Inboard Fixed Trailing Edge Upper Panel Installation

A. General

(1) This task has the steps to install the inboard fixed trailing edge upper panels.

B. References

Reference	Title
27-51-00-040-801	Trailing Edge Flap System Deactivation (P/B 201)
27-51-00-440-801	Trailing Edge Flap System Reactivation (P/B 201)
27-51-00-860-804	Retract the Trailing Edge Flaps (P/B 201)
27-61-00-800-802	Depressurization of the Spoiler Hydraulic Systems A and B (P/B 201)
27-61-00-840-802	Pressurization of the Spoiler Hydraulic Systems A and B to its Usual Condition (P/B 201)
27-62-41-720-801	Ground Spoiler Control Module Functional Test (P/B 401)
51-21-72-370-804	BMS10-11 Primer - Application (P/B 701)
57-50-01-800-801	Inboard Fixed Trailing Edge Upper Panel - Adjustment (P/B 501)
SRM 51-40-02	FASTENER INSTALLATION AND REMOVAL
SWPM 20-20-10	Replacement of Ground Studs and Bonding Jumper Installation

C. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
COM-1550	Bonding Meter - Approved, Intrinsically Safe (Approved for use in Class I, Divisions I & II hazardous (classified) locations. Outside these hazardous locations, COM-614 can be used in lieu of COM-1550). Part #: 620LK Supplier: 1CRL2 Part #: M1 Supplier: 3AD17 Part #: M1B Supplier: 3AD17 Part #: T477W (C15292) Supplier: 06659
SPL-1744	Set - Lock, Inboard Ground Spoiler Actuator (Contains 4 Lock Assemblies) Part #: C27046-13 Supplier: 81205 Opt Part #: C27046-1 Supplier: 81205

D. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
B00062	Solvent - Acetone (99.5% Grade)	ASTM D 329 (Supersedes O-A-51)
B00184	Solvent - Presealing, Cleaning Solvent	BMS11-7
C00259	Coating - Chemical And Solvent Resistant Finish, Corrosion Inhibiting Primer	BMS10-11 Type I

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Reference	Description	Specification
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	AMS3819 Class 1 Grade A or B Form 1 (Supersede BMS15-5 CL A)
G50237	Compound - Corrosion Inhibiting, Non-drying - Cor-Ban 27L	BMS3-38

E. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Fixed upper panel	57-50-00-36-330 57-50-00-36-335	SIA ALL SIA ALL
2	Fixed upper panel	57-50-01-01-495 57-50-01-01-500	SIA ALL SIA ALL

F. Location Zones

Zone	Area
561	Left Wing - Rear Spar to Trailing Edge, Outboard Of Inboard Flap, Inboard of Fixed Trailing Edge
661	Right Wing - Rear Spar to Trailing Edge, Outboard of Inboard Flap, Inboard of Fixed Trailing Edge

G. Inboard Fixed Trailing Edge Upper Panel Installation

SUBTASK 57-50-01-860-003

 WARNING	DO NOT OPERATE THE SPOILER AND AILERON CONTROLS UNTIL SYSTEM MAINTENANCE IS COMPLETE. INJURY TO PERSONS AND DAMAGE TO EQUIPMENT CAN OCCUR.

- (1) Make sure that the ailerons, flaps, and spoilers do not operate (TASK 27-51-00-040-801, TASK 27-61-00-800-802).

SUBTASK 57-50-01-400-001

- (2) Install the fixed upper panel [2].
- (a) Put the fixed upper panel [2] in place.
 - (b) Apply sealant, A00247 to the shank and threads of the bolts [22] and to the faces of the washers [23] and washers [24].
 - (c) Install the bolts [22], washers [23], washers [24] and nuts [25] to the wing fittings and the fixed upper panel [2].
 - (d) Connect the upper links of the turnbuckles [6] to the fixed upper panel [2] (View F, Figure 401).
 - 1) On the outboard turnbuckle [6], install the bolt [26], washer [27], washer [28] and nut [29].
 - 2) For the inboard turnbuckle [6], apply sealant, A00247 to the shank and threads of the bolt [26], washer [27], washer [28] and nut [29].
 - 3) Install the bolt [26], washer [27], washer [28] and nut [29] to the inboard turnbuckle [6] and fixed upper panel [2].

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- (e) Do the steps that follow to install the bolts [33] to the wing to body fairing (View F, Figure 401).
 - 1) Apply primer, C00259 to all the areas of the fastener holes at the upper side of the fixed upper panel [2] and let dry.
 - 2) Apply Cor-Ban 27L Compound, G50237 to all the areas of the fastener holes at the upper side of the fixed upper panel [2].
 - 3) Immediately install the bolts [33].
- (f) Clean the fasteners, the jumper [32], and the faying surface of the aluminum fixed upper panel [2].
 - 1) Use a clean cotton wiper, G00034 soaked with solvent, B00062 or solvent, B00184.
 - 2) Rub dry with a clean dry cotton wiper, G00034.
 - 3) Continue to clean and dry the surface until the cotton wiper stays clean.
- (g) Install the jumper [32], washer [31] and nut [30] to the fixed upper panel [2] (View G, Figure 401).
- (h) Measure the resistance between the fixed upper panel [2] and the wing fitting with an intrinsically safe approved bonding meter, COM-1550 (SWPM 20-20-10).
 - 1) Make sure that the measured resistance is below the maximum bonding resistance as specified in SWPM 20-20-10.

SUBTASK 57-50-01-400-002

- (3) Install the fixed upper panel [1].
 - (a) Put the fixed upper panel [1] in place.
 - (b) Install the bolt [12], washer [13], bushings [14], washer [15] and nut [16].
 - (c) Install the bolt [17], washer [13], bushings [18], washer [15] and nut [16].
 - (d) Install the upper links of the turnbuckle [3], turnbuckle [4], turnbuckle [5] to the fixed upper panel [1] (View A, Figure 401).
 - 1) Install the bolts [7], washers [8], washers [9], washers [10] and nuts [11].

NOTE: Use shim washers (NAS1149D0416J, NAS1149D0432J or NAS1149D0463J) between the clevis and lug to get a maximum gap of 0.030 in. (0.762 mm) before clamp-up. A minimum of one washer for each side.



WARNING

USE NITRILE GLOVES FOR SKIN PROTECTION WHEN YOU USE COR-BAN 27L, G50237. IF IT GETS ON YOUR SKIN, IMMEDIATELY REMOVE IT WITH WATER. IF THIS MATERIAL GETS IN YOUR EYES, IMMEDIATELY FLUSH YOUR EYES WITH WATER. GET MEDICAL AID. THIS MATERIAL CONTAINS FLAMMABLE AGENTS WHICH CAN CAUSE INJURIES TO PERSONNEL.

- (e) Do the steps that follow to install the two bolts [19], four bolts [20] and seven bolts [21] to the fixed upper panel [1] (View E, Figure 401).
 - 1) Apply primer, C00259 to all the areas of the fastener holes at the upper side of the fixed upper panel [1] and let dry.
 - 2) Apply Cor-Ban 27L Compound, G50237 to all the areas of the fastener holes at the upper side of the fixed upper panel [1].
 - 3) Immediately install the two bolts [19], four bolts [20] and seven bolts [21].

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- (f) Apply sealant, A00247 to the shank and threads of the hex drive bolts [35].
- (g) Install the hex drive bolts [35] and collars [36] to the fixed upper panel [1] (SRM SUBJECT 51-40-02).
- (h) Install the rivets [34] to the fixed upper panel [1] (SRM SUBJECT 51-40-02).
- (i) Install the bolts [42] and washers [43] on the block clamp.
- (j) Do these steps to install the screws [38] and washers [39] to the support bracket (View H, Figure 401).
 - 1) Clean the fay surfaces of the fixed upper panel [1] and the support bracket (SWPM 20-20-10).
 - 2) Apply sealant, A00247 to the shank and threads of the screws [38] and to the faces of the washers [39] (SWPM 20-20-10).
 - 3) Install the screws [38] and washers [39] on the support bracket and the fixed upper panel [1].
- (k) Measure the electrical bonding resistance between the support bracket and the fixed upper panel [1] with an intrinsically safe approved bonding meter, COM-1550.
 - 1) Make sure that the measured resistance is below the maximum bonding resistance as specified in SWPM 20-20-10.
- (l) Apply a fillet seal of sealant sealant, A00247, around the perimeter of the support bracket.
- (m) Apply primer, C00259, as necessary to the fixed upper panel [1] and support bracket (TASK 51-21-72-370-804).
- (n) Install the wire harness on the fixed upper panel [1].
- (o) Install the clamps [40] and screws [41] that support the wire harness.
- (p) Connect the electrical connectors [37] on the support bracket.

H. Inboard Fixed Trailing Edge Upper Panel Installation Test

SUBTASK 57-50-01-820-001

- (1) Do this task: Inboard Fixed Trailing Edge Upper Panel - Adjustment, TASK 57-50-01-800-801.

I. Put the Airplane Back to its Usual Condition

SUBTASK 57-50-01-020-001

- (1) Remove the lock-set, SPL-1744 on the actuator for the applicable ground spoiler.

SUBTASK 57-50-01-720-001

- (2) Do this task to unlatch the SPOILER ACTUATOR status message: Ground Spoiler Control Module Functional Test, TASK 27-62-41-720-801.

NOTE: The SPOILER ACTUATOR status message can be latched when the spoilers are locked in the up position.

SUBTASK 57-50-01-440-001



KEEP PERSONS AND EQUIPMENT AWAY FROM THE FLIGHT CONTROL SURFACES. THE AILERONS, ELEVATORS, RUDDER, FLAPS, SLATS, SPOILERS, STABILIZER AND NOSE GEAR CAN MOVE SUDDENLY WHEN YOU SUPPLY HYDRAULIC POWER. THIS CAN CAUSE INJURY TO PERSONS AND DAMAGE TO EQUIPMENT.

- (3) Do the activation procedure for the spoilers (TASK 27-61-00-840-802).

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SUBTASK 57-50-01-440-002

(4) Do this task: Trailing Edge Flap System Reactivation, TASK 27-51-00-440-801.

SUBTASK 57-50-01-860-004

(5) Retract the inboard trailing edge flaps (TASK 27-51-00-860-804).

SUBTASK 57-50-01-860-005

(6) Retract the inboard spoilers.

————— **END OF TASK** —————

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FIXED TRAILING EDGE UPPER PANEL - ADJUSTMENT/TEST

1. General

- A. This procedure has one task:
- (1) Inboard fixed trailing edge upper panel adjustment.

TASK 57-50-01-800-801

2. Inboard Fixed Trailing Edge Upper Panel - Adjustment

(Figure 501)

A. **References**

Reference	Title
27-51-00-040-801	Trailing Edge Flap System Deactivation (P/B 201)
27-51-00-440-801	Trailing Edge Flap System Reactivation (P/B 201)
27-51-00-860-803	Extend the Trailing Edge Flaps (P/B 201)
27-51-00-860-804	Retract the Trailing Edge Flaps (P/B 201)
32-00-01-480-801	Landing Gear Downlock Pins Installation (P/B 201)

B. **Consumable Materials**

Reference	Description	Specification
G50375	Kit - Safety Cable, 321 CRES - 0.032 Inch (0.81 mm) Diameter, (Contains both Cable and Ferrule)	BACC13AT3K, AMS 5689

C. **Location Zones**

Zone	Area
561	Left Wing - Rear Spar to Trailing Edge, Outboard Of Inboard Flap, Inboard of Fixed Trailing Edge
661	Right Wing - Rear Spar to Trailing Edge, Outboard of Inboard Flap, Inboard of Fixed Trailing Edge

D. **Prepare for the Adjustment**

SUBTASK 57-50-01-480-002



WARNING

MAKE SURE THAT THE DOWNLOCK PINS ARE INSTALLED ON ALL THE LANDING GEAR. WITHOUT THE DOWNLOCK PINS, THE LANDING GEAR CAN RETRACT. THIS CAN CAUSE INJURIES TO PERSONS, AND DAMAGE TO EQUIPMENT.

- (1) Make sure that the downlock pins are installed on the nose and main landing gear (TASK 32-00-01-480-801).

SUBTASK 57-50-01-040-003

- (2) Do this task: Trailing Edge Flap System Deactivation, TASK 27-51-00-040-801.

E. **Inboard Fixed Trailing Edge Upper Panel Adjustment**

SUBTASK 57-50-01-860-006

- (1) Make sure that the inboard trailing edge flap is in the retracted position.

SUBTASK 57-50-01-220-001

- (2) Measure the mismatch between the fixed upper panel [1] and the upper surface of the inboard trailing edge flap assembly.

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SUBTASK 57-50-01-820-002

- (3) Measure the mismatch between the fixed upper panel [2] and the upper surface of the inboard trailing edge flap assembly.

SUBTASK 57-50-01-820-004

- (4) If the mismatch is in the limits of 0.0050 in. (0.127 mm) - 0.1000 in. (2.540 mm), no more adjustment is necessary. Make sure that the safety device wires are installed.
 - (a) Install safety cable kit, G50375, on both ends of the turnbuckle [3] and turnbuckle [4].
 - (b) Install safety cable kit, G50375, on one end of the turnbuckle [5].

SUBTASK 57-50-01-820-003

- (5) If the mismatch is not in the limits of 0.0050 in. (0.127 mm) - 0.1000 in. (2.540 mm), adjust the applicable fixed upper panel:
 - (a) Do this task: Trailing Edge Flap System Reactivation, TASK 27-51-00-440-801.
 - (b) Extend the inboard trailing edge flaps to get access to the turnbuckle [3], turnbuckle [4], turnbuckle [5] and turnbuckles [6] for the fixed upper panels (TASK 27-51-00-860-803).
 - (c) Do this task: Trailing Edge Flap System Deactivation, TASK 27-51-00-040-801.
 - (d) To adjust the fixed upper panel [1], do these steps:
 - 1) Loosen the six nuts [7] at each end of the turnbuckle [3], turnbuckle [4] and turnbuckle [5].
 - a) Remove the existing safety device wire.
 - 2) Loosen the jam nuts [8] on the turnbuckle [4] and turnbuckle [5].
 - a) Remove the existing safety device wire.
 - 3) Loosen the jam nuts [9] on the turnbuckle [3].
 - 4) Adjust the turnbuckle [3], turnbuckle [4] and turnbuckle [5] to set the gap between the fixed upper panel [1] and the trailing edge flap upper surface to within the limit.
 - a) Make sure that the threads are visible through the turnbuckle inspection holes.
 - 5) Tighten the jam nuts [8] and jam nuts [9].
 - a) Install safety cable kit, G50375 on both ends of the turnbuckle [3] and turnbuckle [4].
 - b) Install safety cable kit, G50375 on one end of the turnbuckle [5].
 - 6) Tighten the six nuts [7].
 - (e) To adjust the fixed upper panel [2], do these steps:
 - 1) Loosen the four nuts [10] at each end of the turnbuckles [6].
 - 2) Loosen the four jam nuts [11] on the turnbuckles [6].
 - 3) Adjust the turnbuckles [6] to set the gap between the fixed upper panel [2] and the flap upper surface to within the limit.
 - 4) Tighten the jam nuts [11].
 - a) Make sure that the threads are visible through the turnbuckle inspection holes.
 - 5) Tighten the four nuts [10].

F. Put the Airplane Back to Its Usual Condition

SUBTASK 57-50-01-410-001

- (1) Do this task: Trailing Edge Flap System Reactivation, TASK 27-51-00-440-801.

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SUBTASK 57-50-01-860-007

(2) Retract the trailing edge flaps to the retracted position (TASK 27-51-00-860-804).

———— **END OF TASK** ————

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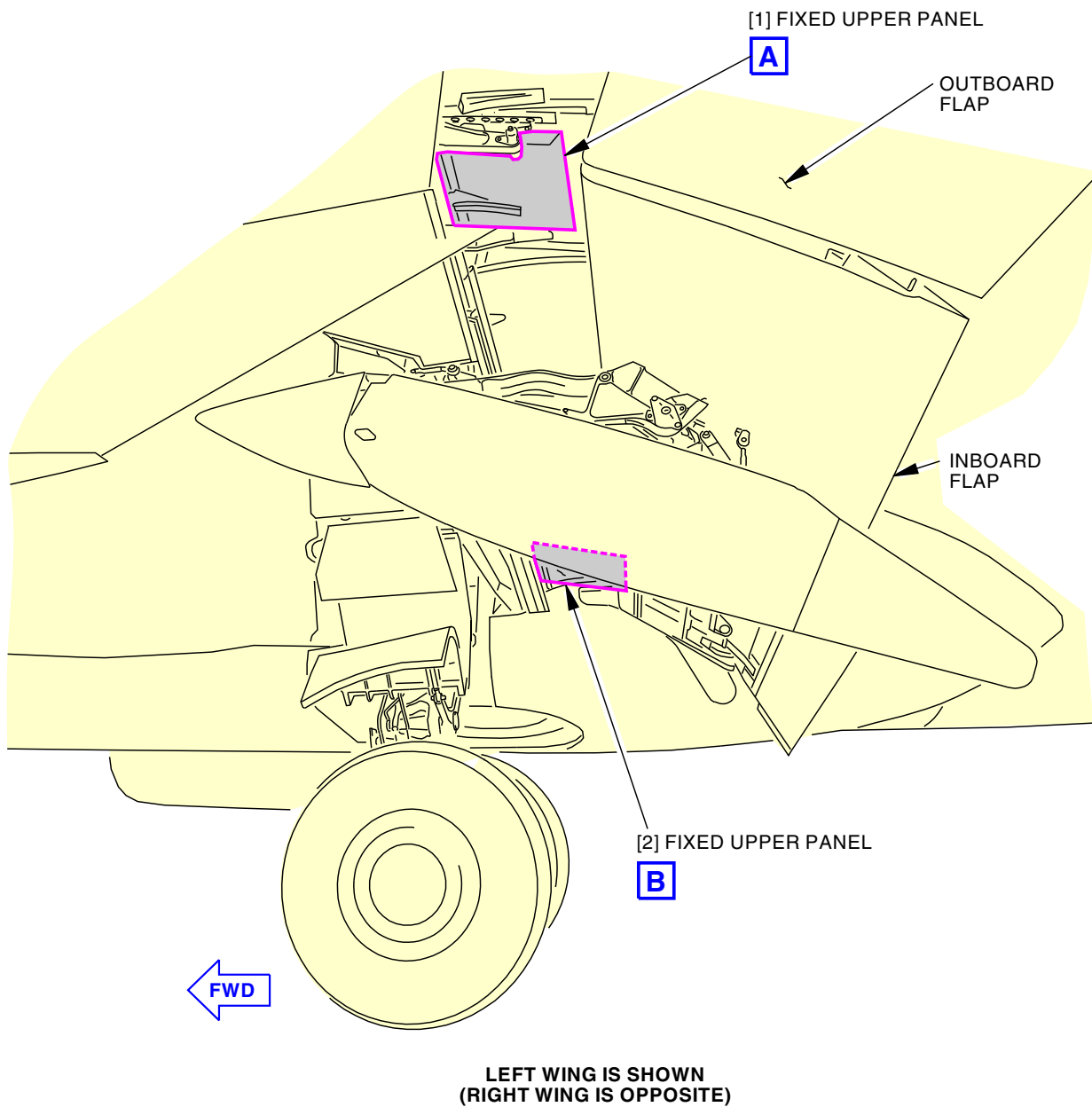
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2416684 S00061541290_V2

Inboard Fixed Upper Panel Adjustment
Figure 501/57-50-01-990-802 (Sheet 1 of 3)

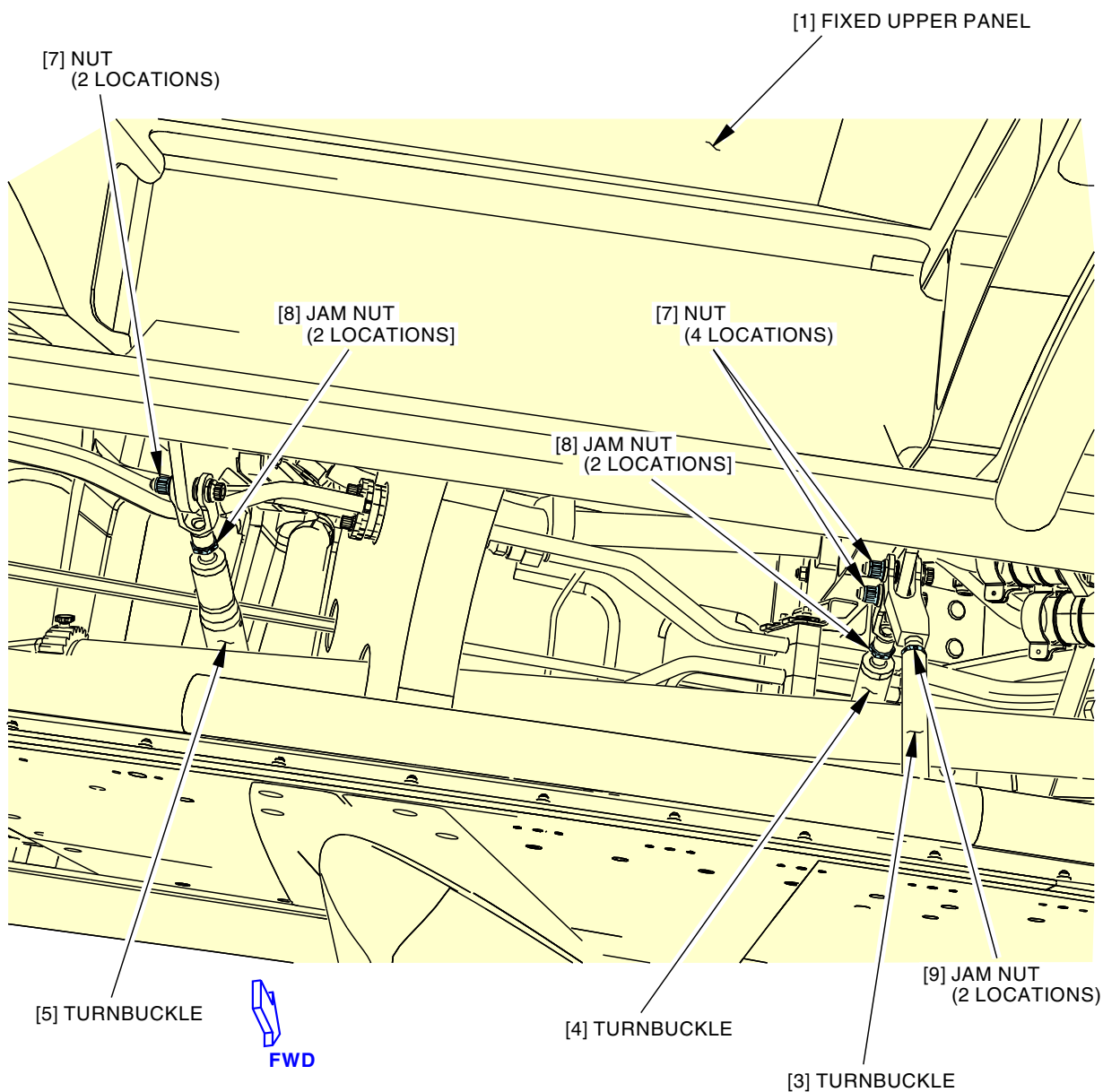
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2416685 S00061541291_V1

Inboard Fixed Upper Panel Adjustment
Figure 501/57-50-01-990-802 (Sheet 2 of 3)

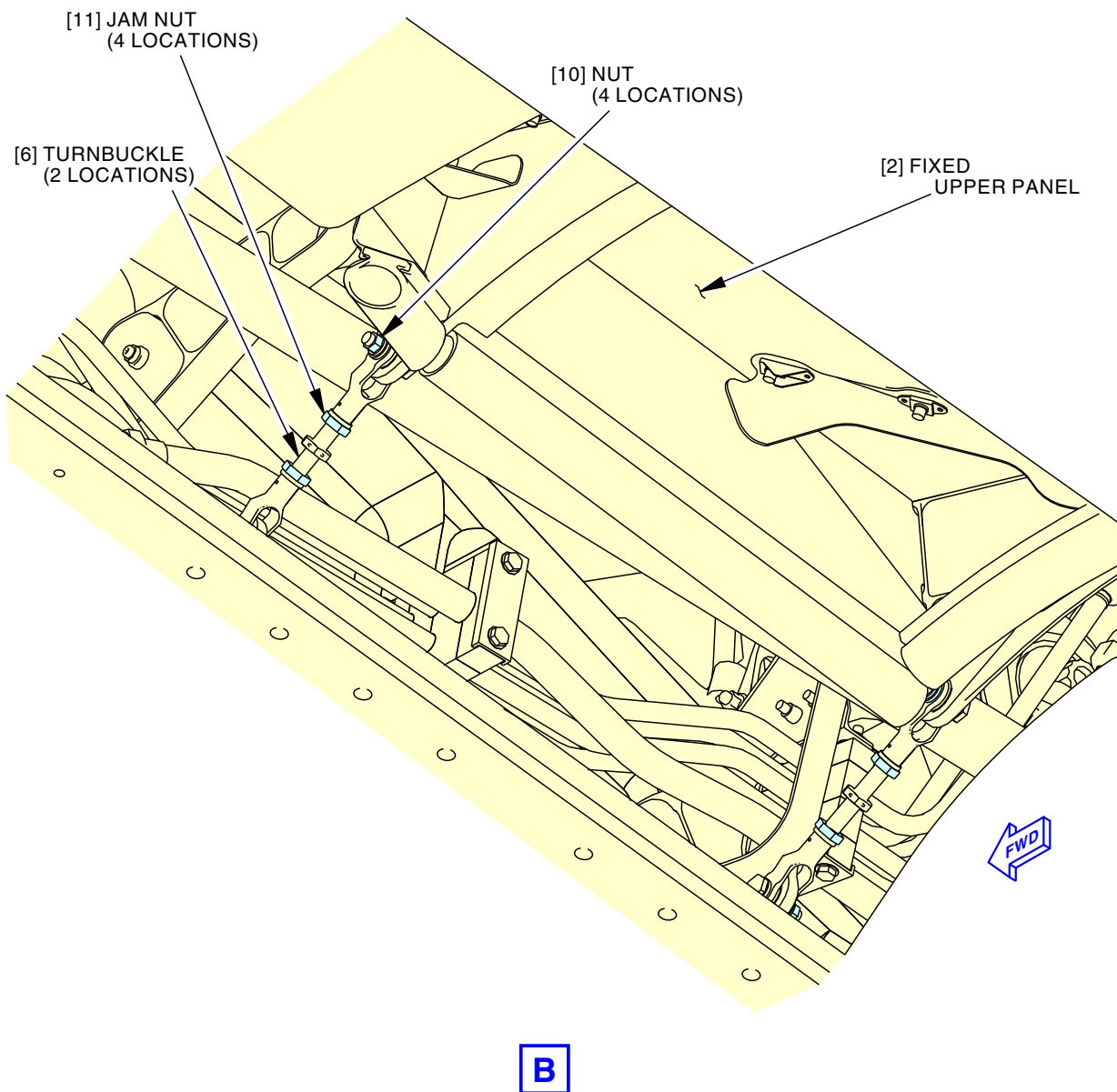
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Inboard Fixed Upper Panel Adjustment
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FIXED TRAILING EDGE LOWER PANEL - REMOVAL/INSTALLATION

1. **General**

A. This procedure contains these task:

- (1) Inboard fixed trailing edge lower panel removal
- (2) Inboard fixed trailing edge lower panel installation.

TASK 57-50-02-000-801

2. **Inboard Fixed Trailing Edge Lower Panel Removal**

(Figure 401)

A. **General**

- (1) This task has the steps to remove the inboard fixed trailing edge lower panel.
- (2) This task has one or more steps which are a means to satisfy Critical Design Configuration Control Limitation (CDCCL) requirements. A CDCCL note will follow the step to which it applies. Any step or sub-step that precedes or follows a CDCCL identified step is not subject to the CDCCL requirement.
 - (a) For important information on CDCCL requirements, refer to this task: Airworthiness Limitation Precautions, TASK 57-00-00-910-802.

NOTE: This is applicable to Airworthiness Limitation 28-AWL-02.

B. **References**

Reference	Title
27-51-00-040-801	Trailing Edge Flap System Deactivation (P/B 201)
28-11-00-211-803	External Wires Mounted Near the Rear Spar Inspection (P/B 601)
32-00-01-480-801	Landing Gear Downlock Pins Installation (P/B 201)
57-00-00-910-802	Airworthiness Limitation Precautions (P/B 201)

C. **Location Zones**

Zone	Area
551	Left Wing - Rear Spar To Landing Gear Support Beam
661	Right Wing - Rear Spar to Trailing Edge, Outboard of Inboard Flap, Inboard of Fixed Trailing Edge

D. **Prepare for the Removal**

SUBTASK 57-50-02-420-001



WARNING

MAKE SURE THAT THE DOWNLOCK PINS ARE INSTALLED ON ALL THE LANDING GEAR. WITHOUT THE DOWNLOCK PINS, THE LANDING GEAR CAN RETRACT. THIS CAN CAUSE INJURIES TO PERSONS, AND DAMAGE TO EQUIPMENT.

- (1) Make sure that the downlock pins are installed on the nose and main landing gear (TASK 32-00-01-480-801).

SUBTASK 57-50-02-860-001

- (2) Extend the inboard main flaps.

SUBTASK 57-50-02-040-001

- (3) Do this task: Trailing Edge Flap System Deactivation, TASK 27-51-00-040-801.

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E. Inboard Fixed Trailing Edge Lower Panel Removal

SUBTASK 57-50-02-480-001

- (1) Put a rubber pad or rag on top of the door's top edge to prevent damage to the main landing gear wing door.

SUBTASK 57-50-02-020-001

- (2) Disconnect wire bundle on the aft end of the inboard fixed trailing edge lower panel [1] from the brackets.

SUBTASK 57-50-02-020-002

- (3) Remove the bolts [6], bolts [2] and washers [3].

SUBTASK 57-50-02-020-003

- (4) Remove the two bolts [4] and two washers [5] on the inboard fixed trailing edge lower panel [1].

SUBTASK 57-50-02-020-004

- (5) Disconnect the top links of the turnbuckles from the Main Landing Gear (MLG) beam.

NOTE: Make a note of the location of all the washers.

- (a) Remove the nuts [7], washers [8], washers [9] and bolts [10].
 - 1) Disconnect the upper link of the turnbuckles [11].
- (b) Remove the nuts [12], washers [13], washers [14] and bolts [15].
 - 1) Disconnect the upper link of the turnbuckles [16].
- (c) Remove the bolts [17], washers [18], washers [19] and nuts [20].
 - 1) Disconnect the upper link of the turnbuckles [21].
- (d) Remove the bolts [22], washers [23], washers [24] and nuts [25].
 - 1) Disconnect the upper link of the turnbuckles [26].
- (e) Remove the bolts [27], washers [28], washers [29] and nuts [30].
 - 1) Disconnect the upper link of the turnbuckles [31].

SUBTASK 57-50-02-020-005

- (6) Remove the inboard fixed trailing edge lower panel [1].

SUBTASK 57-50-02-010-001

28-AWL-02: CDCCL

- (7) If you remove the panels to do maintenance, preventative maintenance, or alteration in any area within 12 in. (305 mm) from the fuel tanks (rear spar), do these steps:

NOTE: CDCCL - Refer to the task: Airworthiness Limitation Precautions, TASK 57-00-00-910-802, for important information on Critical Design Configuration Control Limitations (CDCCLs).

NOTE: This is applicable to Airworthiness Limitation 28-AWL-02

28-AWL-02: CDCCL

- (a) Make sure that you do not change the routing and clamping of the wires near the rear spar.

NOTE: CDCCL - Refer to the task: Airworthiness Limitation Precautions, TASK 57-00-00-910-802, for important information on Critical Design Configuration Control Limitations (CDCCLs).

NOTE: This is applicable to Airworthiness Limitation 28-AWL-02

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 28-AWL-02: CDCCL

- (b) Before you install the panels, do this task only in the areas where you removed the panels and maintenance was performed: External Wires Mounted Near the Rear Spar Inspection, TASK 28-11-00-211-803.

NOTE: CDCCL - Refer to the task: Airworthiness Limitation Precautions, TASK 57-00-00-910-802, for important information on Critical Design Configuration Control Limitations (CDCCLs).

NOTE: This is applicable to Airworthiness Limitation 28-AWL-02

———— **END OF TASK** ————

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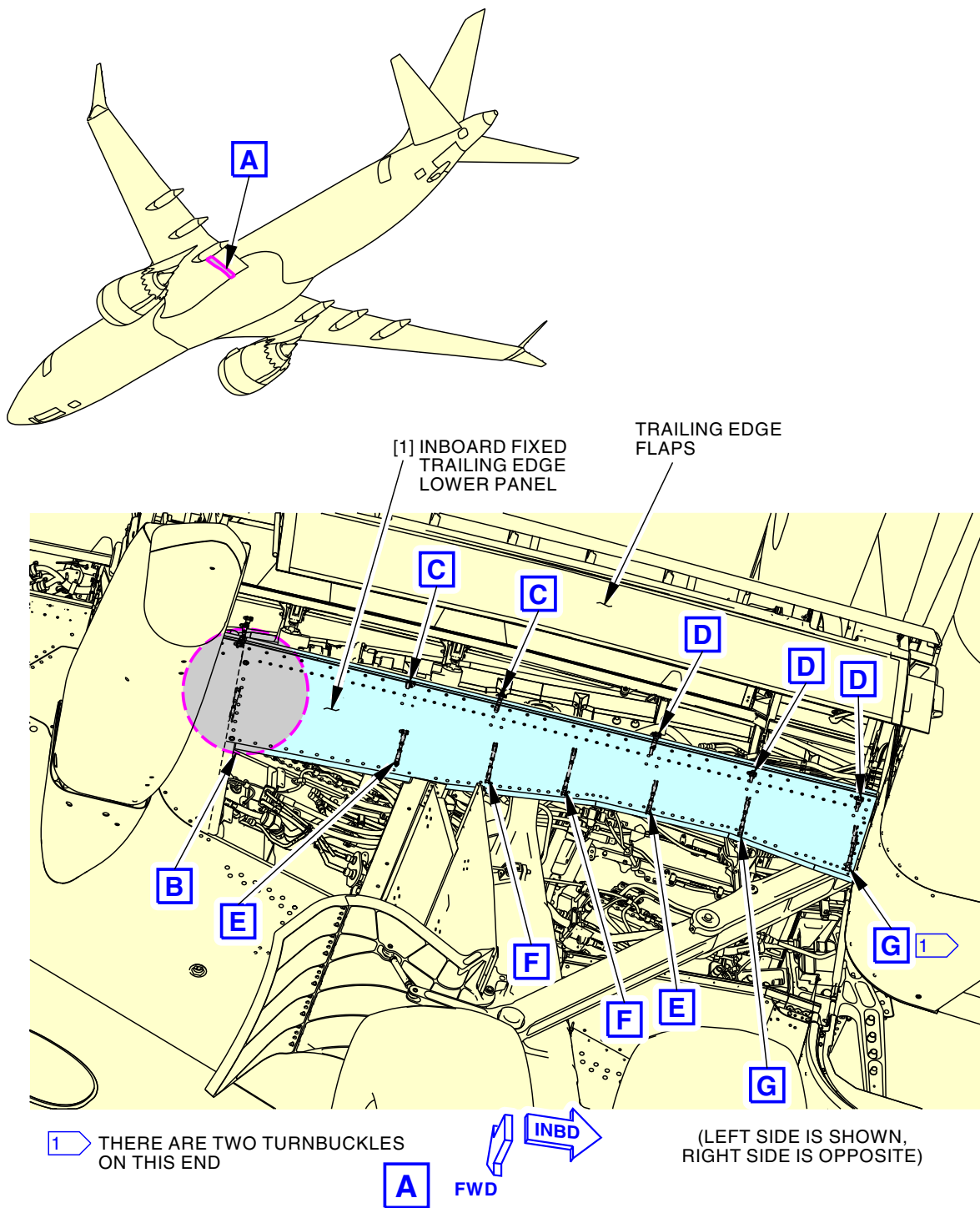
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2416688 S00061541297_V3

Inboard Fixed Trailing Edge Lower Panel Installation
Figure 401/57-50-02-990-801 (Sheet 1 of 4)

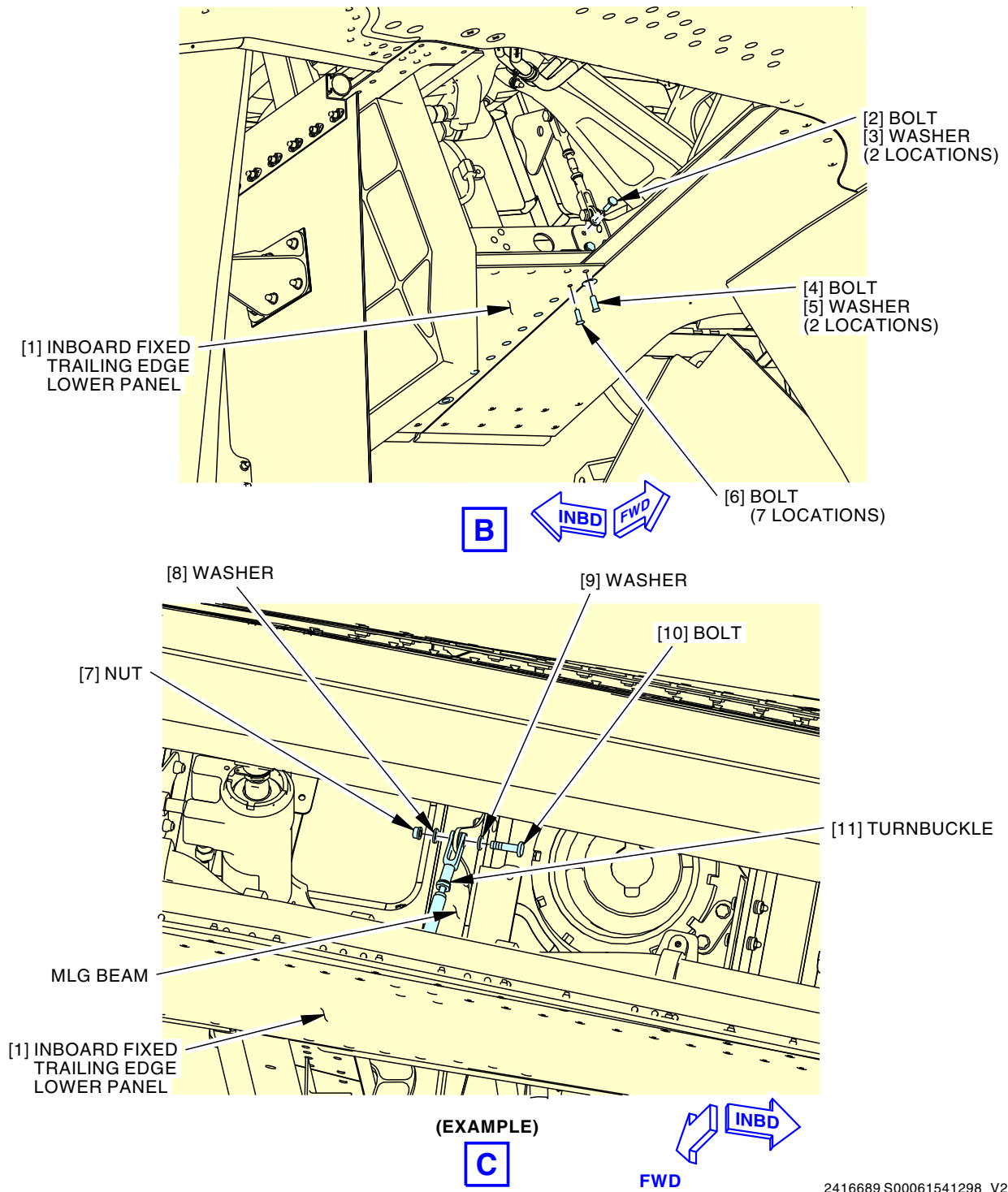
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Inboard Fixed Trailing Edge Lower Panel Installation
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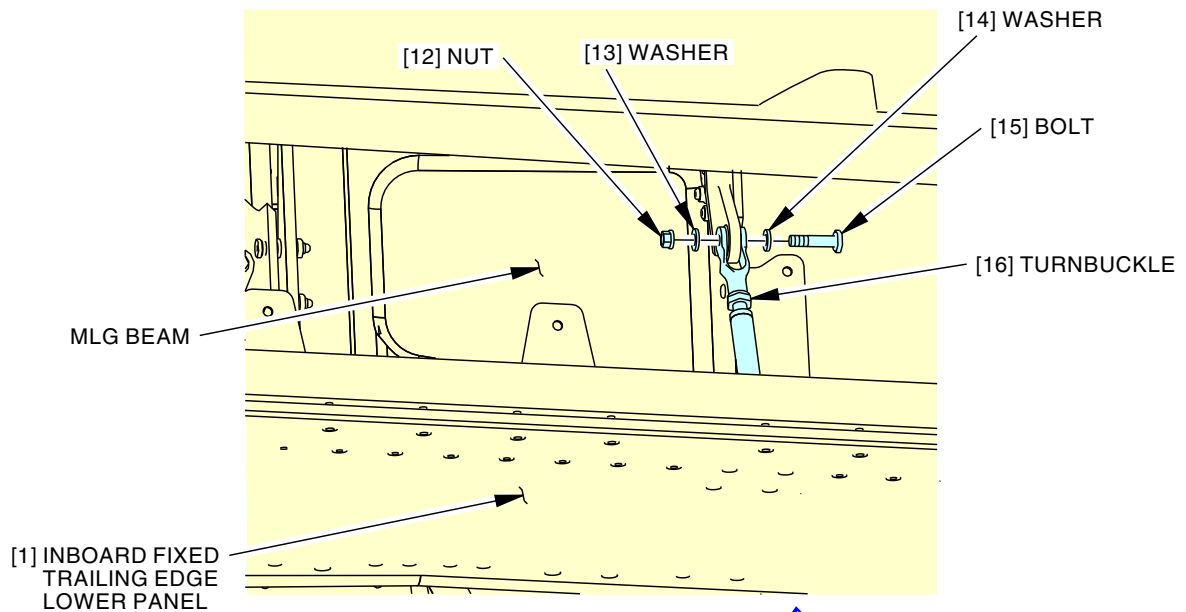
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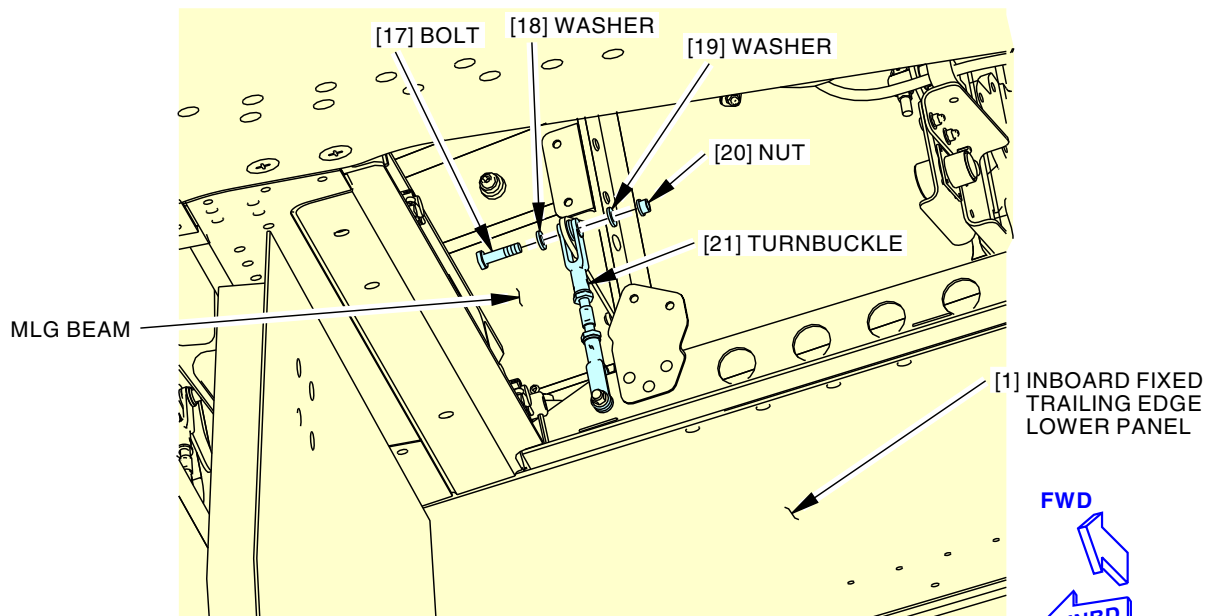
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(EXAMPLE)

D

FWD



(EXAMPLE)

E

FWD



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Inboard Fixed Trailing Edge Lower Panel Installation
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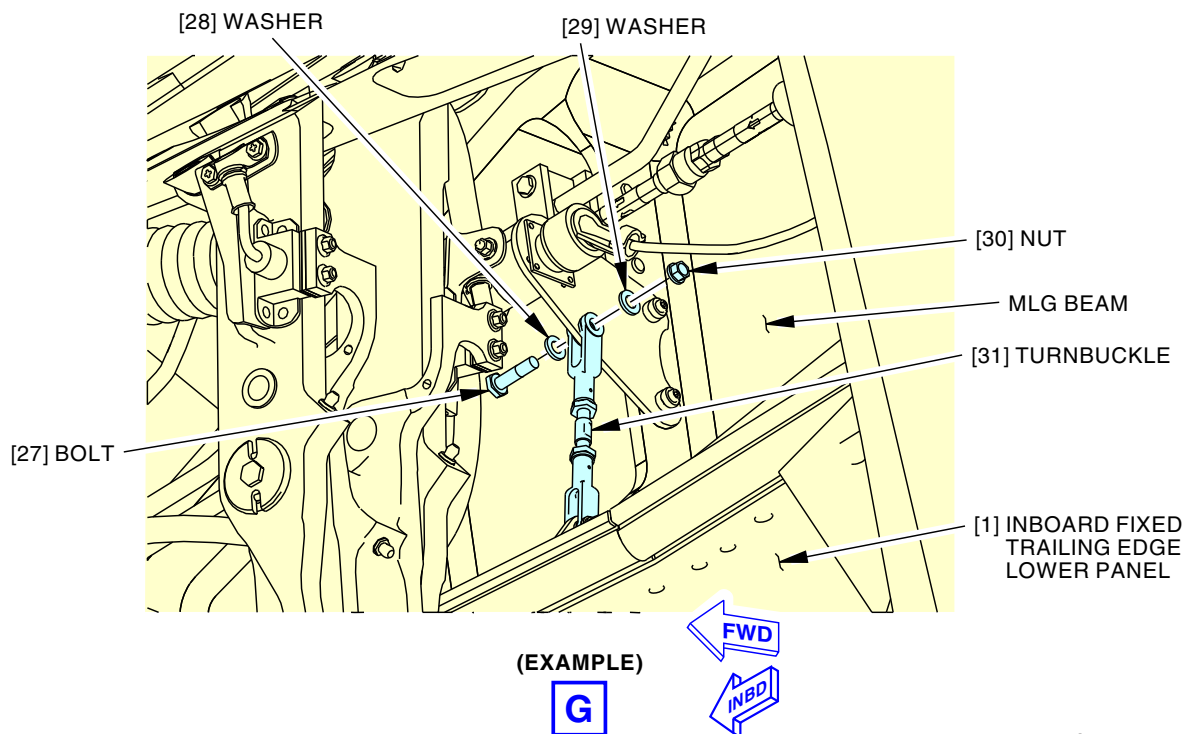
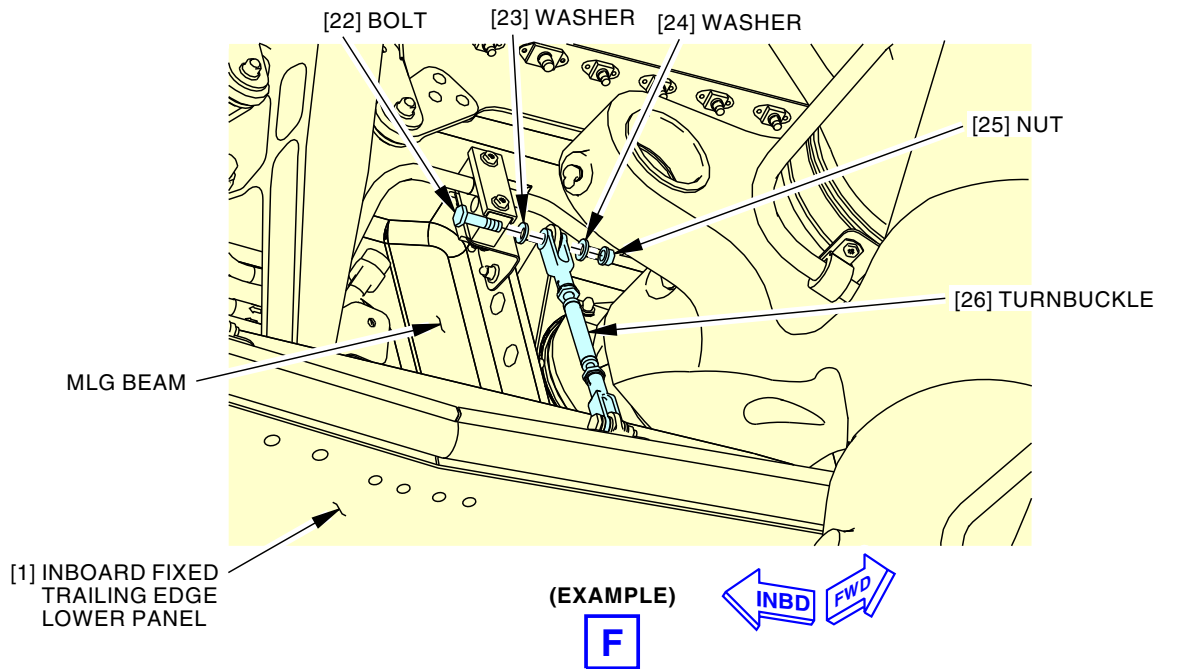
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2483642 S0000583058_V2

Inboard Fixed Trailing Edge Lower Panel Installation
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TASK 57-50-02-400-801

3. Inboard Fixed Trailing Edge Lower Panel Installation

(Figure 401)

A. General

(1) This task has the steps to install the inboard fixed trailing edge lower panel.

B. References

Reference	Title
27-51-00-040-801	Trailing Edge Flap System Deactivation (P/B 201)
27-51-00-440-801	Trailing Edge Flap System Reactivation (P/B 201)
27-61-00-800-802	Depressurization of the Spoiler Hydraulic Systems A and B (P/B 201)
SWPM 20-20-00	ELECTRICAL BONDING PROCESSES
SWPM 20-20-00, Paragraph 2.A.	Cleaning Procedure 1
SWPM 20-20-00, Paragraph 2.E.	Standard Wiring Practices Manual

C. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
COM-1550	Bonding Meter - Approved, Intrinsically Safe (Approved for use in Class I, Divisions I & II hazardous (classified) locations. Outside these hazardous locations, COM-614 can be used in lieu of COM-1550). Part #: 620LK Supplier: 1CRL2 Part #: M1 Supplier: 3AD17 Part #: M1B Supplier: 3AD17 Part #: T477W (C15292) Supplier: 06659

D. Consumable Materials

Reference	Description	Specification
B00062	Solvent - Acetone (99.5% Grade)	ASTM D 329 (Supersedes O-A-51)
B00184	Solvent - Presealing, Cleaning Solvent	BMS11-7
C00259	Coating - Chemical And Solvent Resistant Finish, Corrosion Inhibiting Primer	BMS10-11 Type I
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	AMS3819 Class 1 Grade A or B Form 1 (Supersede BMS15-5 CL A)
G50237	Compound - Corrosion Inhibiting, Non-drying - Cor-Ban 27L	BMS3-38
G51193	Pad - General Purpose, Abrasive Hand Pad, Maroon, Very Fine Grade. (Norton Bear-Tex 747)	

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E. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Inboard fixed trailing edge lower panel	57-50-51-10-475	SIA ALL
		57-50-51-10-480	SIA ALL

F. Location Zones

Zone	Area
551	Left Wing - Rear Spar To Landing Gear Support Beam
661	Right Wing - Rear Spar to Trailing Edge, Outboard of Inboard Flap, Inboard of Fixed Trailing Edge

G. Inboard Fixed Trailing Edge Lower Panel Installation

SUBTASK 57-50-02-860-002



WARNING

DO NOT OPERATE THE SPOILER AND AILERON CONTROLS UNTIL SYSTEM MAINTENANCE IS COMPLETE. INJURY TO PERSONS AND DAMAGE TO EQUIPMENT CAN OCCUR.

- (1) Make sure that the ailerons, flaps, and spoilers do not operate (TASK 27-51-00-040-801, TASK 27-61-00-800-802).

SUBTASK 57-50-02-420-002

- (2) Put a rubber pad or rag on top of the door's top edge to prevent damage to the main landing gear wing door.

SUBTASK 57-50-02-420-003

- (3) Put the inboard fixed trailing edge lower panel [1] in its position.

SUBTASK 57-50-02-420-004

- (4) Connect the top links of the turnbuckles to the Main Landing Gear (MLG) beam.
- (a) Connect the top links of turnbuckles [31].
- 1) Install bolts [27], washers [28], washers [29] and nuts [30].
- a) Use combination of washers NAS1149E0416P, NAS1149E0432P and NAS1149E0463P between each side of the lug and clevis. Decrease the total gap to 0.030 in. (0.762 mm) maximum before you tighten the fasteners. Use a minimum of one washer for each side. Install the washers equally. Put the lug in the center of the clevis unless it is necessary to align the top and lower joints. Keep a minimum of one washer for each side.
- (b) Connect the top links of turnbuckles [26].
- 1) Install bolts [22], washers [23], washers [24] and nuts [25].
- a) Use combination of washers NAS1149E0416R, NAS1149E0432R and NAS1149E0463R between each side of the lug and clevis. Decrease the total gap to 0.030 in. (0.762 mm) maximum before you tighten the fasteners. Use a minimum of one washer for each side. Install the washers equally. Put the lug in the center of the clevis unless it is necessary to align the top and lower joints. Keep a minimum of one washer for each side.
- (c) Connect the top links of turnbuckles [21].
- 1) Install bolts [17], washers [18], washers [19] and nuts [20].

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- a) Use combination of washers NAS1149D0416J, NAS1149D0432J and NAS1149D0463J between each side of the lug and clevis. Decrease the total gap to 0.030 in. (0.762 mm) maximum before you tighten the fasteners. Use a minimum of one washer for each side. Install the washers equally. Put the lug in the center of the clevis unless it is necessary to align the top and lower joints. Keep a minimum of one washer for each side.
- (d) Connect the top links of turnbuckles [16].
 - 1) Install the bolts [15], washers [14], washers [13] and nuts [12].
 - a) Use combination of washers NAS1149D0416J, NAS1149D0432J and NAS1149D0463J between each side of the lug and clevis. Decrease the total gap to 0.030 in. (0.762 mm) maximum before you tighten the fasteners. Use a minimum of one washer for each side. Install the washers equally. Put the lug in the center of the clevis unless it is necessary to align the top and lower joints. Keep a minimum of one washer for each side.
- (e) Connect the top links of turnbuckles [11].
 - 1) Install the bolts [10], washers [9], washers [8] and nuts [7].
 - a) Use combination of washers NAS1149D0416J, NAS1149D0432J and NAS1149D0463J between each side of the lug and clevis. Decrease the total gap to 0.030 in. (0.762 mm) maximum before you tighten the fasteners. Use a minimum of one washer for each side. Install the washers equally. Put the lug in the center of the clevis unless it is necessary to align the top and lower joints. Keep a minimum of one washer for each side.

SUBTASK 57-50-02-420-005



USE NITRILE GLOVES FOR SKIN PROTECTION WHEN YOU USE COR-BAN 27L, G50237. IF IT GETS ON YOUR SKIN, IMMEDIATELY REMOVE IT WITH WATER. IF THIS MATERIAL GETS IN YOUR EYES, IMMEDIATELY FLUSH YOUR EYES WITH WATER. GET MEDICAL AID. THIS MATERIAL CONTAINS FLAMMABLE AGENTS WHICH CAN CAUSE INJURIES TO PERSONNEL.

- (5) Do these steps to install the bolts [6], bolts [2] and washers [3].
 - (a) Apply primer, C00259, to the fastener holes on the outboard side of the inboard fixed trailing edge lower panel [1] for bolts [6], bolts [2].
 - (b) Make sure that the primer is dry.
 - (c) Apply Cor-Ban 27L Compound, G50237, to the fastener holes on the outboard side of the inboard fixed trailing edge lower panel [1] for bolts [6], bolts [2].
 - (d) Immediately install the bolts [6], bolts [2] and washers [3].

SUBTASK 57-50-02-120-001

- (6) Do these steps to prepare the inboard fixed trailing edge lower panel [1] and the support beam for the electrical bond installation:
 - (a) Clean the bolts [4], washers [5] and the fay surfaces of the expanded aluminum inboard fixed trailing edge lower panel [1] and the aluminum support beam.
 - 1) Use Cleaning Procedure 1 to abrasively clean the fay surfaces of the lower panel and the support beam (SWPM 20-20-00, Paragraph 2.A.).
 - a) Use a very fine abrasive hand pad, G51193.
 - b) Twist the pad with a circular movement while pressing with your thumb.

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- 2) Use Cleaning Procedure 5 to clean the fay surfaces of the inboard fixed trailing edge lower panel [1], bolts [4] and washers [5] (SWPM 20-20-00, Paragraph 2.E.).
 - a) Use a new cotton wiper, G00034, made moist with solvent, B00062 or solvent, B00184.
 - b) Use a new cotton wiper, G00034, to dry the surfaces.
 - c) Make sure that you remove the remaining corrosion inhibiting compound on the lower panel.

SUBTASK 57-50-02-420-006



USE NITRILE GLOVES FOR SKIN PROTECTION WHEN YOU USE COR-BAN 27L, G50237. IF IT GETS ON YOUR SKIN, IMMEDIATELY REMOVE IT WITH WATER. IF THIS MATERIAL GETS IN YOUR EYES, IMMEDIATELY FLUSH YOUR EYES WITH WATER. GET MEDICAL AID. THIS MATERIAL CONTAINS FLAMMABLE AGENTS WHICH CAN CAUSE INJURIES TO PERSONNEL.

- (7) Do these steps to install the two bolts [4] and two washers [5] on the inboard fixed trailing edge lower panel [1]:
 - (a) Apply Cor-Ban 27L Compound, G50237, to all the areas of the fastener holes.
 - (b) Immediately install the two bolts [4] and two washers [5].

SUBTASK 57-50-02-760-001

- (8) Measure the resistance between the inboard fixed trailing edge lower panel [1] and the bolts [4] with an intrinsically safe approved bonding meter, COM-1550 (SWPM 20-20-00).
 - (a) Make sure that the resistance is not more than the maximum resistance value as specified in SWPM 20-20-00.

SUBTASK 57-50-02-420-007

- (9) Attach the wire bundle on the aft end of inboard fixed trailing edge lower panel [1] to the brackets.

SUBTASK 57-50-02-080-001

- (10) Remove the rubber pad or rag that was put on top of the door's top edge to prevent damage to the main landing gear wing door.

H. Put the Airplane Back to Its Usual Condition

SUBTASK 57-50-02-440-001



KEEP PERSONNEL AND EQUIPMENT AWAY FROM THE FLIGHT CONTROL SURFACES, THE THRUST REVERSERS, AND THE LANDING GEAR. THESE COMPONENTS CAN MOVE SUDDENLY WHEN YOU SUPPLY HYDRAULIC POWER. THIS CAN CAUSE INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT.

- (1) Do this task: Trailing Edge Flap System Reactivation, TASK 27-51-00-440-801.

SUBTASK 57-50-02-860-003

- (2) Retract the inboard trailing edge flaps.

————— **END OF TASK** —————

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AILERON - INSPECTION/CHECK

1. General

- A. This procedure has one task. The task gives instructions to do a visual inspection of the internal area of the ailerons.

TASK 57-61-01-200-801

2. Examine the Composite Flight Controls

A. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt:", which stands for Optional.

Reference	Description
COM-117	Videoscope - Borescope Inspection Part #: IV9000N Supplier: 32212 Part #: IV9620GL Supplier: 32212

B. Location Zones

Zone	Area
572	Left Wing - Aileron
672	Right Wing - Aileron

C. Examine the Composite Flight Controls

SUBTASK 57-61-01-010-001

- (1) Remove the access panels that are necessary.

SUBTASK 57-61-01-290-001

- (2) Put a videoscope, COM-117, into an access hole that is 2 in. (5.1 cm) in diameter.

SUBTASK 57-61-01-290-002

- (3) Move the videoscope, COM-117, until you can see an area where an inspection is necessary.

NOTE: If you cannot move the optical tip into the correct areas, use a guide tube.

SUBTASK 57-61-01-290-003

- (4) Examine the area for these unsatisfactory conditions:

NOTE: Do not move the videoscope, COM-117, while you examine an area.

- (a) Signs of deterioration.
- (b) Bulges and cracks on the skins and the ribs.
- (c) Corrosion on the fasteners.
- (d) Other signs of the stress.

SUBTASK 57-61-01-970-001

- (5) Make a record of all the unsatisfactory conditions before you move the videoscope, COM-117, to a different area.

SUBTASK 57-61-01-410-001

- (6) Install the access panels.

————— **END OF TASK** —————

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SPOILER SUPPORT FITTINGS - REPAIRS

1. General

- A. This procedure includes a repair of the inboard ground spoiler support fittings. This procedure repairs spoiler support fittings by replacing damaged fittings with new, replacement fittings. Only one spoiler support may be repaired at a time for a single inboard ground spoiler.
- B. This procedure may only be done if the two other spoiler support fittings are correctly located for the inboard ground spoiler.
- C. The spoiler support fittings repaired in this procedure provide support to the inboard ground spoiler and their actuators. (The other spoiler support fittings that do not support an actuator are not repaired in this procedure). They are attached to the main landing gear support beam.

TASK 57-71-01-300-801

2. Spoiler Support Fitting Repair

(Figure 801)

A. General

- (1) This task has the steps to repair the inboard ground spoiler support fittings on the Main Landing Gear (MLG) support beam.

B. References

Reference	Title
12-40-00-100-801	Clean (Wet Wash) the External Surfaces of the Airplane (P/B 201)
12-40-00-100-802	Clean (Waterless Wash) the External Surfaces of the Airplane (P/B 201)
20-10-51-000-801	Flareless Tubing Assembly Removal (P/B 401)
20-10-51-400-802	Flareless Fittings in Pressurized Areas Installation (P/B 401)
27-51-58-000-801	Flap Torque Tube Removal (Selection) (P/B 401)
27-51-58-400-801	Flap Torque Tube Installation (Selection) (P/B 401)
27-62-12-000-801	Inboard Ground Spoiler Removal (P/B 401)
27-62-12-400-801	Inboard Ground Spoiler Installation (P/B 401)
27-62-71-000-801	Inboard Ground Spoiler Actuator Removal (P/B 401)
27-62-71-400-801	Inboard Ground Spoiler Actuator Installation (P/B 401)
29-09-00-860-801	Hydraulic Reservoirs Pressurization (P/B 201)
29-09-00-860-802	Hydraulic Reservoirs Depressurization (P/B 201)
SWPM 20-20-10	Replacement of Ground Studs and Bonding Jumper Installation

C. Tools/Equipment

NOTE: When more than one tool part number is listed under the same "Reference" number, the tools shown are alternates to each other within the same airplane series. Tool part numbers that are replaced or non-procurable are preceded by "Opt.", which stands for Optional.

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Reference	Description
COM-1550	Bonding Meter - Approved, Intrinsically Safe (Approved for use in Class I, Divisions I & II hazardous (classified) locations. Outside these hazardous locations, COM-614 can be used in lieu of COM-1550). Part #: 620LK Supplier: 1CRL2 Part #: M1 Supplier: 3AD17 Part #: M1B Supplier: 3AD17 Part #: T477W (C15292) Supplier: 06659

D. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
A50110	Sealant - Fuel Tank	BMS5-45 Class B-2
B00062	Solvent - Acetone (99.5% Grade)	ASTM D 329 (Supersedes O-A-51)
B00184	Solvent - Presealing, Cleaning Solvent	BMS11-7
C00259	Coating - Chemical And Solvent Resistant Finish, Corrosion Inhibiting Primer	BMS10-11 Type I
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	AMS3819 Class 1 Grade A or B Form 1 (Supersede BMS15-5 CLA)
G50398	Pad - Adbrasive, Scotch-Brite Type S, Abrasive Pad	
G50492	Pad - 3M Scotch Brite 7448 Ultra Fine Pad	MIL-A-9962A Type III Grade AAA

E. Location Zones

Zone	Area
551	Left Wing - Rear Spar To Landing Gear Support Beam
651	Right Wing - Rear Spar to Landing Gear Support Beam

F. Access Panels

Number	Name/Location
551DB	Lower Inboard Fixed Trailing Edge, Lube Actuator & MLG Beam Outboard Attach Pin Access Panel
651DB	Lower Inboard Fixed Trailing Edge, Lube Actuator & MLG Beam Outboard Attach Pin Access Panel

G. Prepare for the Spoiler Support Fitting Repair

SUBTASK 57-71-01-010-001

- (1) Remove the applicable access panels:

Number	Name/Location
551DB	Lower Inboard Fixed Trailing Edge, Lube Actuator & MLG Beam Outboard Attach Pin Access Panel
651DB	Lower Inboard Fixed Trailing Edge, Lube Actuator & MLG Beam Outboard Attach Pin Access Panel

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SUBTASK 57-71-01-010-002

- (2) To remove the applicable inboard ground spoiler, do this task: Inboard Ground Spoiler Removal, TASK 27-62-12-000-801.

SUBTASK 57-71-01-010-003

- (3) To remove the pressure from all hydraulic systems, do this task: Hydraulic Reservoirs Depressurization, TASK 29-09-00-860-802.

SUBTASK 57-71-01-020-005



REMOVE ALL PRESSURE FROM THE SYSTEM BEFORE YOU START THE REMOVAL OF THE FLARELESS TUBING ASSEMBLY. A PRESSURIZED SYSTEM CAN CAUSE INJURY TO PERSONNEL AND DAMAGE TO EQUIPMENT.

- (4) To disconnect the hydraulic tubes from the support beam as necessary, do this task: Flareless Tubing Assembly Removal, TASK 20-10-51-000-801.



PUT AN IDENTIFIER ON THE TUBES ON EACH SIDE OF THE CONNECTION BEFORE YOU DISCONNECT. IF YOU CONNECT THEM AT AN INCORRECT LOCATION, DAMAGE TO THE COMPONENTS WILL OCCUR.

- (a) Put caps on the ends of the hydraulic tubes to prevent contamination.
- (b) Make a note of the location of each piece of hydraulic tubing that is removed.
- (c) To clean up the hydraulic fluid, do this task: Clean (Wet Wash) the External Surfaces of the Airplane, TASK 12-40-00-100-801 or Clean (Waterless Wash) the External Surfaces of the Airplane, TASK 12-40-00-100-802.

SUBTASK 57-71-01-010-005

- (5) Remove the applicable ground spoiler actuator to the spoiler and support fitting (Inboard Ground Spoiler Actuator Removal, TASK 27-62-71-000-801).

SUBTASK 57-71-01-010-006

- (6) Remove applicable trailing edge flap torque tube, do this Task Flap Torque Tube Removal (Selection), TASK 27-51-58-000-801

H. Spoiler Support Fitting Repair

SUBTASK 57-71-01-960-001



DO NOT REMOVE AND INSTALL MORE THAN ONE SPOILER FITTING FOR EACH SPOILER AT A TIME. THE OTHER SUPPORT FITTINGS SHOW THE NEW SUPPORT FITTING'S CORRECT HOLE LOCATIONS. IF YOU DO NOT ENGAGE THE NEW SUPPORT FITTING HOLES CORRECTLY, DAMAGE TO THE AIRPLANE CAN OCCUR.



DO NOT USE THIS PROCEDURE IF THERE ARE TWO OR MORE DAMAGED SPOILER SUPPORT FITTINGS FOR EACH SPOILER. THE SPOILER'S HINGE POINTS MUST CORRECTLY ENGAGE THE HOLES FOR THE NEW SUPPORT FITTING. IF YOU DO NOT ENGAGE THE NEW SUPPORT FITTING HOLES CORRECTLY, DAMAGE TO THE AIRPLANE CAN OCCUR.

- (1) If you will repair the spoiler support fitting [1], do these steps:

NOTE: There are two spoiler support fittings on each main landing gear support beam that may be replaced. Only one may be replaced at a time.

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- (a) Remove the four collars [4] and four bolts [3] from the damaged spoiler support fitting [1].
- (b) Remove the nut [8], two washers [9], and bolt [10] from the damaged spoiler support fitting [1].
- (c) Remove the damaged spoiler support fitting [1] from the MLG support beam.
- (d) Install the inboard ground spoiler (Inboard Ground Spoiler Installation, TASK 27-62-12-400-801).
 - 1) Do not attach the new support fitting to the MLG support beam while installing the spoiler.
- (e) Attach the new spoiler support fitting [1] to the spoiler hinge.
- (f) Attach the spoiler support fitting [1] to the MLG support beam.
 - 1) Apply sealant, A00247 to the mating surfaces of the spoiler support fitting [1] and the MLG support beam.
 - 2) Apply sealant, A00247 to the bolts [3] shanks and threads.
 - 3) Install the four bolts [3] and four collars [4].
 - a) Make sure that the bolt heads are on the spoiler support fitting [1].
 - 4) Remove excess sealant.
 - 5) Install bolt [10], washers [9], and nut [8]

SUBTASK 57-71-01-960-002



CAUTION

DO NOT REMOVE AND INSTALL MORE THAN ONE SPOILER FITTING FOR EACH SPOILER AT A TIME. THE OTHER SUPPORT FITTINGS SHOW THE NEW SUPPORT FITTING'S CORRECT HOLE LOCATIONS. IF YOU DO NOT ENGAGE THE NEW SUPPORT FITTING HOLES CORRECTLY, DAMAGE TO THE AIRPLANE CAN OCCUR.



CAUTION

DO NOT USE THIS PROCEDURE IF THERE ARE TWO OR MORE DAMAGED SPOILER SUPPORT FITTINGS FOR EACH SPOILER. THE SPOILER'S HINGE POINTS MUST CORRECTLY ENGAGE THE HOLES FOR THE NEW SUPPORT FITTING. IF YOU DO NOT ENGAGE THE NEW SUPPORT FITTING HOLES CORRECTLY, DAMAGE TO THE AIRPLANE CAN OCCUR.

- (2) If you will repair the spoiler support fitting [2], do these steps:

NOTE: There are two spoiler support fittings on each main landing gear support beam that may be replaced. Only one may be replaced at a time.

 - (a) Remove the collar [4], washers [6], jumper [7] and bolt [5] from the damaged spoiler support fitting [2].
 - (b) Remove the three collars [4] and three bolts [3].
 - (c) Remove the nut [8], two washers [9], and bolt [10] from the damaged spoiler support fitting [2].
 - (d) Remove the damaged spoiler support fitting [2] from the MLG support beam.
 - (e) Install the inboard ground spoiler (Inboard Ground Spoiler Installation, TASK 27-62-12-400-801).
 - 1) Do not attach the new support fitting to the MLG support beam while installing the spoiler.
 - (f) Attach the new spoiler support fitting [2] to the spoiler hinge.

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- (g) Attach the spoiler support fitting [2] to the MLG support beam.
 - 1) Apply sealant, A00247 to the mating surfaces of the spoiler support fitting [2] and the MLG support beam.
 - 2) Apply sealant, A00247 to the bolts [3] shanks and threads.
 - 3) Install the three bolts [3] and three collars [4].
 - a) Make sure that the bolt heads are on the spoiler support fitting [2].
 - 4) Install bolt [10], washers [9], and nut [8]
- (h) Do these steps to install the jumper [7] to the MLG support beam:
 - 1) Clean the fasteners and the fay surfaces of the titanium MLG support beam and the jumper [7].
 - a) Use Cleaning Method CM1 to manually clean the MLG support beam at the mount hole.
 - <1> Prepare approximately 0.6 in. (1.5 cm) diameter area of fay surface of the MLG support beam at the mount hole.
 - <2> Use a very fine Scotch-Brite Type S pad, G50398 or an ultra fine Scotch-Brite 7448 pad, G50492.
 - <3> Move the pad in a circular movement while you press with your thumb.
 - b) Use Cleaning Method CM3 to clean the MLG support beam and the fasteners.
 - <1> Use a clean cotton wiper, G00034 soaked with solvent, B00062 or solvent, B00184.
 - <2> Use a new cotton wiper, G00034 to dry the surfaces.
 - <3> Continue to clean and dry the surface until the cotton wiper stays clean.
 - 2) Apply sealant, A50110 to the jumper [7] and the fasteners (SWPM 20-20-10).
 - a) Apply sealant, A50110 to the shank and threads of the bolt [5].
 - b) Apply a continuous bead of sealant, A50110 between each mating surface of the washers and jumper [7].
 - 3) Install the bolt [5], washers [6], jumper [7] and collar [4].
 - 4) Measure the resistance between the MLG support beam and jumper [7] with an intrinsically safe approved bonding meter, COM-1550 (SWPM 20-20-10).
 - a) Make sure that the measured resistance is not more than the maximum value as specified in SWPM 20-20-10.
- (i) Apply one coat of primer, C00259 to the abraded surfaces that you can see.

I. Put the Airplane Back to Its Usual Condition

SUBTASK 57-71-01-020-002

- (1) Connect the hydraulic tubes to the support beam (TASK 20-10-51-400-802).
 - (a) Remove the caps from the ends of the hydraulic tubes.
 - (b) Remove the tags and connect the hydraulic connectors to the correct installation locations as identified by the tag.

SUBTASK 57-71-01-400-001

- (2) Install applicable trailing edge flap torque tube, do this task Flap Torque Tube Installation (Selection), TASK 27-51-58-400-801

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SUBTASK 57-71-01-020-003

- (3) Install the applicable ground spoiler actuator to the spoiler and the spoiler support fitting (Inboard Ground Spoiler Actuator Installation, TASK 27-62-71-400-801).
- (a) Make sure that the hydraulic tubing that you removed does not have a leak after you pressurize the hydraulic systems.

SUBTASK 57-71-01-400-002

- (4) Apply pressure to all hydraulic systems, do this task: Hydraulic Reservoirs Pressurization, TASK 29-09-00-860-801.

SUBTASK 57-71-01-010-004

- (5) Install the applicable access panels:

<u>Number</u>	<u>Name/Location</u>
551DB	Lower Inboard Fixed Trailing Edge, Lube Actuator & MLG Beam Outboard Attach Pin Access Panel
651DB	Lower Inboard Fixed Trailing Edge, Lube Actuator & MLG Beam Outboard Attach Pin Access Panel

———— **END OF TASK** ————

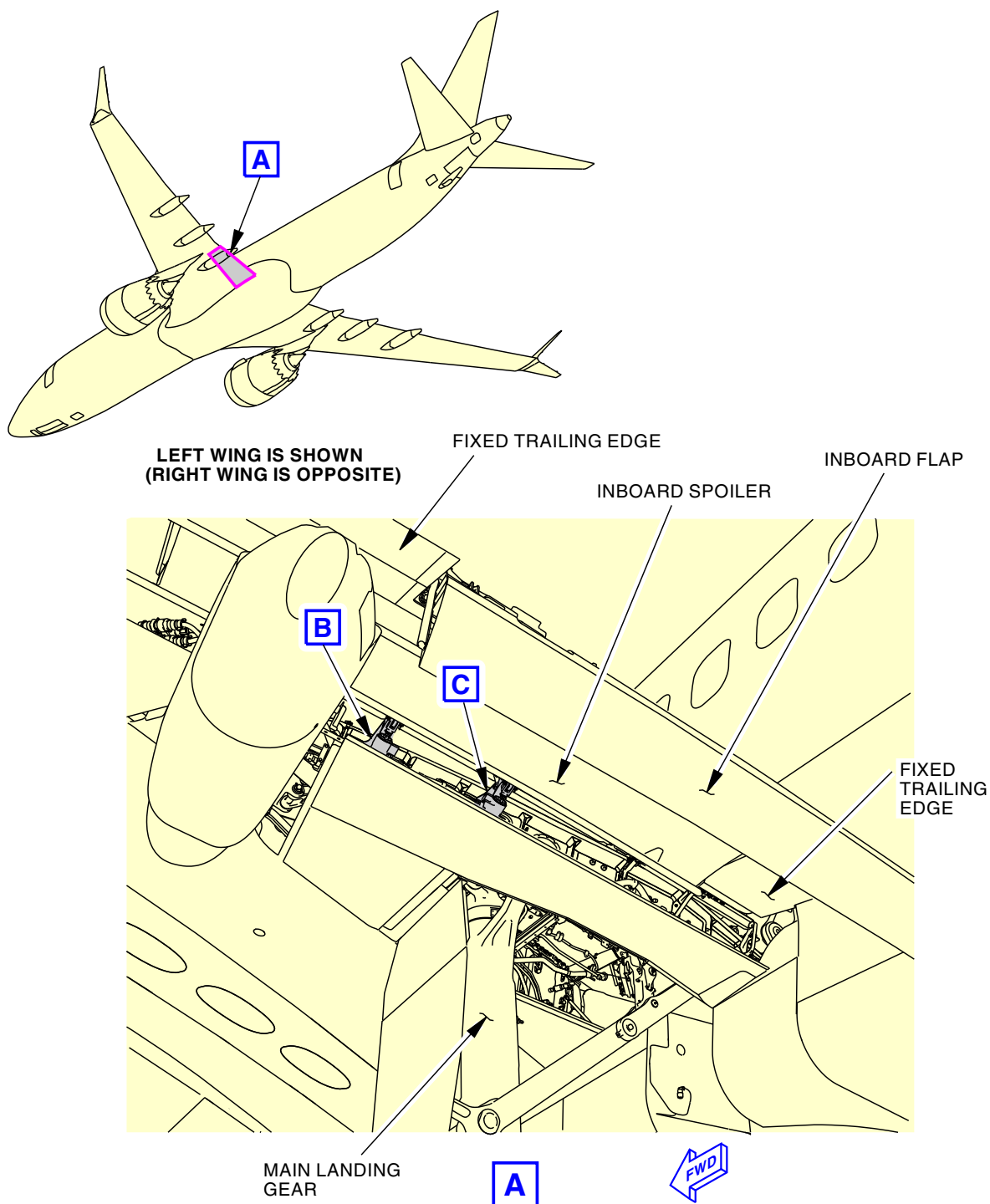
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Spoiler Support Fitting Repair
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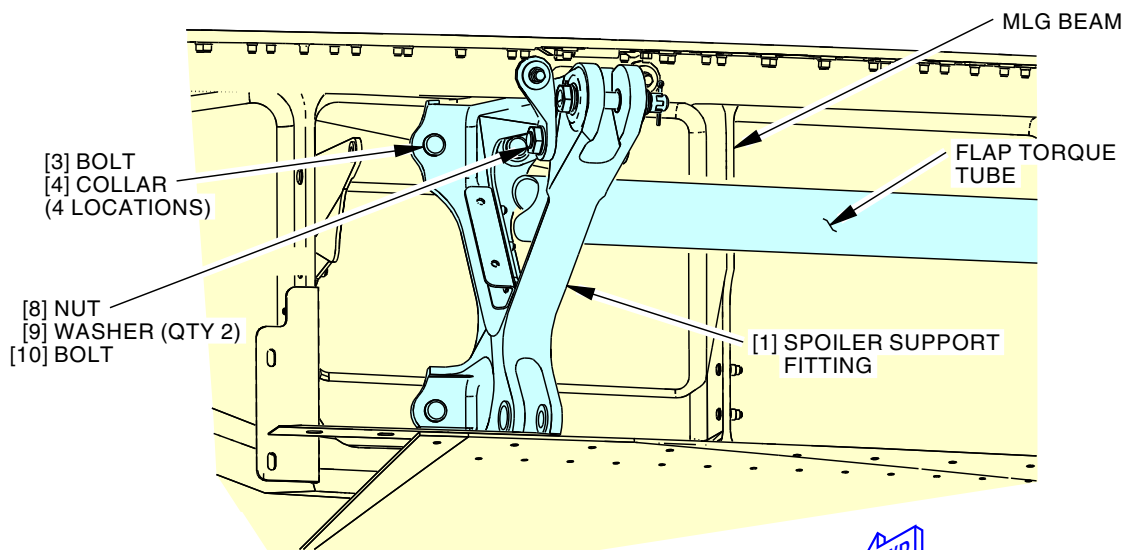
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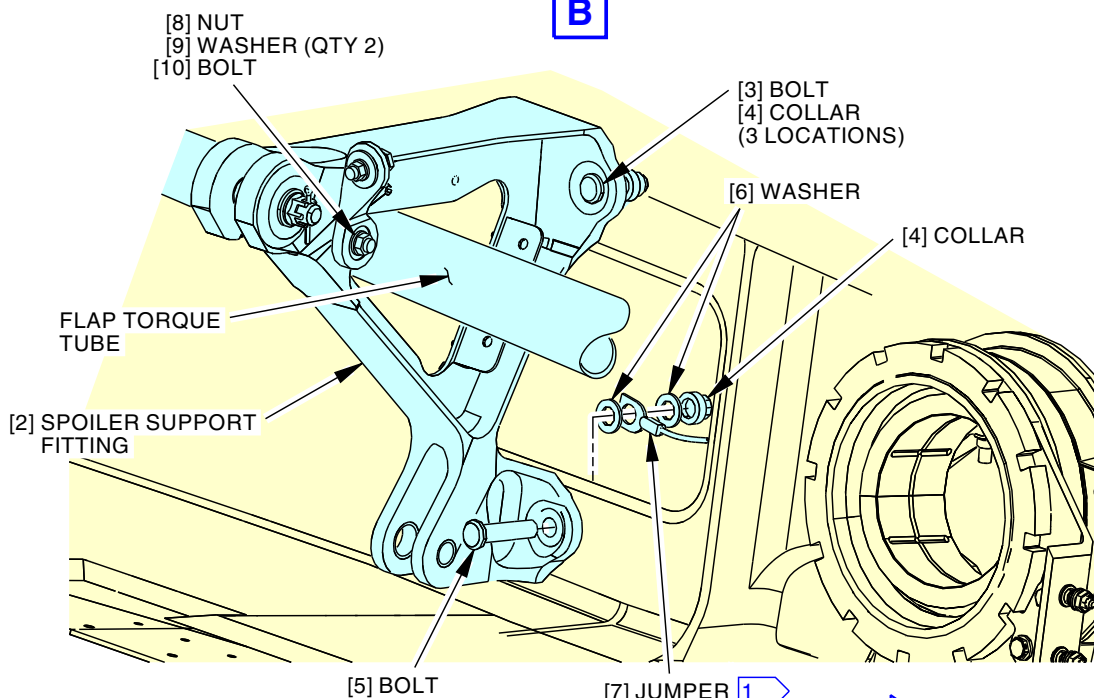
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SPOILER SUPPORT FITTING REPAIR

B



SPOILER SUPPORT FITTING REPAIR

C

1 INSTALL JUMPER AS SHOWN

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Spoiler Support Fitting Repair
Figure 801/57-71-01-990-801 (Sheet 2 of 2)

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