CHAPTER

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WINGS

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O 274	Feb 15/2025		O 298.12	Feb 15/2025		O 298.48	Feb 15/2025	
O 275	Feb 15/2025		O 298.13	Feb 15/2025		O 298.49	Feb 15/2025	
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O 280	Feb 15/2025		O 298.18	Feb 15/2025		O 298.54	Feb 15/2025	
R 281	Feb 15/2025		O 298.19	Feb 15/2025		O 298.55	Feb 15/2025	
O 282	Feb 15/2025		R 298.20	Feb 15/2025		O 298.56	Feb 15/2025	
O 283	Feb 15/2025		R 298.21	Feb 15/2025		O 298.57	Feb 15/2025	
O 284	Feb 15/2025		R 298.22	Feb 15/2025		O 298.58	Feb 15/2025	
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O 291	Feb 15/2025		O 298.29	Feb 15/2025		O 298.65	Feb 15/2025	
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O 296	Feb 15/2025		O 298.34	Feb 15/2025		O 298.70	Feb 15/2025	
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O 298.1	Feb 15/2025		O 298.37	Feb 15/2025		O 298.73	Feb 15/2025	
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O 298.4	Feb 15/2025		O 298.40	Feb 15/2025		O 298.76	Feb 15/2025	
O 298.5	Feb 15/2025		O 298.41	Feb 15/2025		O 298.77	Feb 15/2025	
O 298.6	Feb 15/2025		O 298.42	Feb 15/2025		O 298.78	Feb 15/2025	
O 298.7	Feb 15/2025		O 298.43	Feb 15/2025		O 298.79	Feb 15/2025	
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O 298.9	Feb 15/2025		O 298.45	Feb 15/2025		O 298.81	Feb 15/2025	
O 298.10	Feb 15/2025		O 298.46	Feb 15/2025		O 298.82	Feb 15/2025	

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O 298.87	Feb 15/2025	
O 298.88	Feb 15/2025	
O 298.89	Feb 15/2025	
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249	Jun 15/2024		285	Jun 15/2024		298.23	Jun 15/2024	
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R 253	Feb 15/2025		289	Jun 15/2024		298.27	Jun 15/2024	
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R 260	Feb 15/2025		296	Jun 15/2024		298.34	Jun 15/2024	
R 261	Feb 15/2025		297	Jun 15/2024		298.35	Jun 15/2024	
262	Jun 15/2024		298	Jun 15/2024		R 298.36	Feb 15/2025	
263	Jun 15/2024		298.1	Jun 15/2024		O 298.37	Feb 15/2025	
264	Jun 15/2024		298.2	Jun 15/2024		O 298.38	Feb 15/2025	
265	Jun 15/2024		298.3	Jun 15/2024		R 298.39	Feb 15/2025	
R 266	Feb 15/2025		298.4	Jun 15/2024		O 298.40	Feb 15/2025	
R 267	Feb 15/2025		298.5	Jun 15/2024		O 298.41	Feb 15/2025	
R 268	Feb 15/2025		298.6	Jun 15/2024		O 298.42	Feb 15/2025	
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270	Jun 15/2024		298.8	Jun 15/2024		O 298.44	Feb 15/2025	
271	Jun 15/2024		298.9	Jun 15/2024		O 298.45	Feb 15/2025	
272	Jun 15/2024		298.10	Jun 15/2024		O 298.46	Feb 15/2025	
R 273	Feb 15/2025		298.11	Jun 15/2024		O 298.47	Feb 15/2025	
R 274	Feb 15/2025		298.12	Jun 15/2024		O 298.48	Feb 15/2025	
R 275	Feb 15/2025		298.13	Jun 15/2024		O 298.49	Feb 15/2025	
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277	Jun 15/2024		298.15	Jun 15/2024		O 298.51	Feb 15/2025	
278	Jun 15/2024		298.16	Jun 15/2024		O 298.52	Feb 15/2025	
279	Jun 15/2024		298.17	Jun 15/2024		O 298.53	Feb 15/2025	

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57-21-21		
801	Feb 15/2022	
802	Jun 15/2022	
57-21-21 (cont)		
803	Feb 15/2024	
R 804	Feb 15/2025	
805	Feb 15/2022	
806	Feb 15/2022	
807	Oct 15/2021	
808	Oct 15/2021	
809	Oct 15/2021	
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57-21-22		
201	Jun 15/2023	
202	Jun 15/2023	
203	Oct 15/2021	
204	Oct 15/2024	
205	Oct 15/2024	
206	Oct 15/2023	
207	Oct 15/2023	
208	Oct 15/2023	
209	Jun 15/2023	
R 210	Feb 15/2025	
R 211	Feb 15/2025	
R 212	Feb 15/2025	
O 213	Feb 15/2025	
R 214	Feb 15/2025	
R 215	Feb 15/2025	
R 216	Feb 15/2025	
R 217	Feb 15/2025	
R 218	Feb 15/2025	
57-21-22		
601	Jun 15/2023	
602	Jun 15/2023	
603	Jun 15/2023	
604	Oct 15/2021	
605	Oct 15/2021	
606	BLANK	
57-21-22		
801	Oct 15/2023	
802	Oct 15/2023	
57-21-22 (cont)		
803	Jun 15/2022	
804	BLANK	
57-21-23		
401	Feb 15/2024	
402	Oct 15/2024	
403	Feb 15/2024	
404	Feb 15/2024	
405	Feb 15/2024	
406	Oct 15/2024	
407	Oct 15/2024	
408	Feb 15/2024	
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411	Feb 15/2024	
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413	Oct 15/2024	
414	Oct 15/2024	
415	Oct 15/2024	
416	Oct 15/2024	
417	Oct 15/2024	
418	BLANK	
57-21-23		
601	Oct 15/2022	
R 602	Feb 15/2025	
R 603	Feb 15/2025	
604	Oct 15/2022	
R 605	Feb 15/2025	
606	Oct 15/2022	
607	Oct 15/2022	
608	Oct 15/2022	
609	Jun 15/2023	
610	Oct 15/2020	
611	Oct 15/2020	
612	Oct 15/2020	
57-21-23		
801	Oct 15/2014	
802	Oct 15/2014	

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Subject/Page	Date	COC
57-21-23 (cont)		
803	Feb 15/2021	
804	Jun 15/2022	
805	Feb 15/2022	
806	Feb 15/2017	
807	Feb 15/2017	
808	Feb 15/2017	
809	Jun 15/2016	
810	Jun 15/2016	
811	Jun 15/2016	
812	Jun 15/2016	
813	Jun 15/2016	
814	Jun 15/2016	
57-32-00		
R 401	Feb 15/2025	
R 402	Feb 15/2025	
403	Oct 15/2021	
404	Oct 15/2015	
57-41-00		
201	Oct 15/2018	
202	Oct 15/2017	
203	Jun 15/2016	
204	Jun 15/2016	
205	Jun 15/2016	
206	BLANK	
57-41-02		
201	Jun 15/2023	
R 202	Feb 15/2025	
203	Feb 15/2024	
R 204	Feb 15/2025	
O 205	Feb 15/2025	
206	Feb 15/2021	
207	Feb 15/2021	
208	Jun 15/2023	
R 209	Feb 15/2025	
R 210	Feb 15/2025	
R 211	Feb 15/2025	
O 212	Feb 15/2025	
57-41-02 (cont)		
O 213	Feb 15/2025	
214	Feb 15/2019	
215	Jun 15/2023	
216	Jun 15/2016	
217	Jun 15/2016	
218	Feb 15/2016	
219	Feb 15/2016	
220	Jun 15/2016	
221	Jun 15/2022	
222	Jun 15/2023	
223	Jun 15/2022	
224	Jun 15/2022	
57-44-01		
401	Oct 15/2022	
402	Jun 15/2024	
403	Jun 15/2024	
404	Feb 15/2019	
405	Feb 15/2019	
406	Feb 15/2019	
407	Feb 15/2019	
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57-44-02		
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57-44-03		
601	Oct 15/2021	
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57-44-03		
801	Oct 15/2021	
802	Oct 15/2021	
803	Jun 15/2022	
804	Feb 15/2022	
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807	Oct 15/2021	
808	Oct 15/2021	
809	Oct 15/2021	
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57-50-00		
201	Oct 15/2014	
202	Oct 15/2018	
203	Oct 15/2014	
204	Jun 15/2016	
205	Jun 15/2016	
206	Jun 15/2016	
57-50-01		
401	Oct 15/2024	
402	Oct 15/2024	
403	Jun 15/2016	
404	Jun 15/2016	
405	Jun 15/2016	
406	Jun 15/2016	
407	Oct 15/2024	
408	Oct 15/2024	

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Subject/Page	Date	COC
57-50-01 (cont)		
409	Oct 15/2024	
410	BLANK	
57-50-01		
501	Jun 15/2019	
502	Oct 15/2017	
503	Oct 15/2023	
504	Oct 15/2023	
505	Oct 15/2024	
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508	BLANK	
57-50-02		
401	Jun 15/2024	
402	Oct 15/2024	
403	Feb 15/2024	
404	Jun 15/2024	
405	Jun 15/2024	
406	Jun 15/2024	
407	Oct 15/2024	
408	Oct 15/2024	
409	Feb 15/2024	
410	Feb 15/2024	
411	Feb 15/2024	
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413	Jun 15/2024	
414	Jun 15/2024	
415	Oct 15/2024	
416	Jun 15/2024	
417	Jun 15/2024	
418	BLANK	
57-50-02		
501	Feb 15/2024	
502	Feb 15/2024	
503	Feb 15/2024	
504	Feb 15/2024	
505	Feb 15/2024	
506	Feb 15/2024	
57-50-02 (cont)		
507	Feb 15/2024	
508	Feb 15/2024	
509	Feb 15/2024	
510	Feb 15/2024	
57-71-01		
801	Jun 15/2023	
802	Jun 15/2020	
803	Oct 15/2017	
804	Oct 15/2017	

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CHAPTER 57
WINGS

SUBJECT	CHAPTER SECTION SUBJECT	CONF	PAGE	EFFECT
WING SKINS - CORROSION PREVENTION	57-00-00		201	LOM ALL
Wing Skins - Corrosion Prevention TASK 57-00-00-910-801			201	LOM ALL
AILERON - INSPECTION/CHECK	57-00-01		601	LOM ALL
Examine the Composite Flight Controls TASK 57-00-01-200-801			601	LOM ALL
WING FATIGUE INSPECTIONS - MAINTENANCE PRACTICES	57-05-02		201	LOM ALL
INTERNAL - SPECIAL DETAILED: UPPER SIDE OF BODY SPLICE TASK 57-05-02-130-801			201	LOM ALL
INTERNAL - SPECIAL DETAILED: DOUBLE PLUS CHORD AT STRINGER 18A INTERFACE TASK 57-05-02-250-801			202	LOM ALL
INTERNAL - SPECIAL DETAILED: THE DOUBLE PLUS CHORD VERTICAL FLANGE AT THE BODY STRINGER 18A INTERFACE TASK 57-05-02-130-802			203	LOM ALL
INTERNAL - SPECIAL DETAILED: WING CENTER SECTION UPPER SKIN AT FLOOR BEAMS AND SHEAR TIES TASK 57-05-02-130-804			203	LOM ALL
INTERNAL - DETAILED: WING CENTER SECTION LOWER PANEL TYPICAL STRINGERS TASK 57-05-02-211-802			204	LOM ALL
INTERNAL - DETAILED: WING CENTER SECTION LOWER PANEL SKIN TASK 57-05-02-211-803			205	LOM ALL
INTERNAL - DETAILED: WING CENTER SECTION LOWER PANEL TASK 57-05-02-211-804			207	LOM ALL
INTERNAL - GENERAL VISUAL: WING CENTER SECTION LOWER PANEL TASK 57-05-02-210-801			209	LOM ALL
INTERNAL- SPECIAL DETAILED: SIDE OF BODY SPLICE, LOWER SURFACE TASK 57-05-02-250-802			211	LOM ALL

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SUBJECT	CHAPTER SECTION SUBJECT	CONF	PAGE	EFFECT
INTERNAL - SPECIAL DETAILED: SIDE OF BODY SPLICE, LOWER SURFACE TASK 57-05-02-250-803			212	LOM ALL
INTERNAL - SPECIAL DETAILED: WING CENTER SECTION LOWER PANEL TASK 57-05-02-130-805			213	LOM ALL
INTERNAL - SPECIAL DETAILED: WING CENTER SECTION LOWER PANEL TASK 57-05-02-250-806			214	LOM ALL
INTERNAL - SPECIAL DETAILED: WING CENTER SECTION LOWER PANEL TASK 57-05-02-130-806			215	LOM ALL
INTERNAL - SPECIAL DETAILED: WING CENTER SECTION REAR SPAR TYPICAL WEB (CRACK INITIALLY HIDDEN) TASK 57-05-02-250-807			216	LOM ALL
INTERNAL - DETAILED: WING CENTER SECTION REAR SPAR TYPICAL WEB (CRACK INITIALLY HIDDEN) TASK 57-05-02-211-805			217	LOM ALL
INTERNAL - DETAILED: WING CENTER SECTION REAR SPAR TYPICAL WEB (NON-HIDDEN LOCATIONS) TASK 57-05-02-211-806			219	LOM ALL
INTERNAL - SPECIAL DETAILED: WING CENTER SECTION REAR SPAR KEEL BEAM STIFFENERS TASK 57-05-02-250-808			221	LOM ALL
INTERNAL - SPECIAL DETAILED: SIDE OF BODY SPLICE UPPER AND LOWER REAR SPAR TASK 57-05-02-250-809			221	LOM ALL
INTERNAL - SPECIAL DETAILED: SIDE OF BODY SPLICE UPPER AND LOWER FRONT SPAR TASK 57-05-02-250-811			222	LOM ALL
INTERNAL - SPECIAL DETAILED: WING CENTER SECTION FLOOR BEAM UPPER CHORD TASK 57-05-02-250-813			223	LOM ALL

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CHAPTER 57
WINGS

SUBJECT	CHAPTER SECTION SUBJECT	CONF	PAGE	EFFECT
INTERNAL - DETAILED: WING CENTER SECTION FLOOR BEAM - UPPER CHORD TASK 57-05-02-211-807			224	LOM ALL
INTERNAL - SPECIAL DETAILED: WING CENTER SECTION FLOOR BEAM LOWER CHORD OVER PRESSURE DECK TASK 57-05-02-250-814			228	LOM ALL
INTERNAL - SPECIAL DETAILED: WING CENTER SECTION FLOOR BEAMS LOWER CHORD - OVERWING TASK 57-05-02-250-815			228	LOM ALL
INTERNAL - DETAILED: WING CENTER SECTION FLOOR BEAMS LOWER CHORD - OVERWING TASK 57-05-02-211-808			228	LOM ALL
INTERNAL - DETAILED: SIDE OF BODY RIB (DIRECTION 1) TASK 57-05-02-211-809			231	LOM ALL
INTERNAL - DETAILED: SIDE OF BODY RIB (DIRECTION 2) TASK 57-05-02-211-810			233	LOM ALL
INTERNAL - GENERAL VISUAL: LOWER WING PANEL, TYPICAL STRINGERS TASK 57-05-02-210-802			235	LOM ALL
INTERNAL - GENERAL VISUAL: LOWER WING PANEL, TYPICAL STRINGERS TASK 57-05-02-210-804			238	LOM ALL
INTERNAL - SPECIAL DETAILED: LOWER WING PANEL, TYPICAL STRINGERS TASK 57-05-02-250-817			240	LOM ALL
INTERNAL - SPECIAL DETAILED: LOWER WING PANEL SKIN; UNDER THE FLAP TRACK FAIRINGS AND NACELLE FAIRINGS TASK 57-05-02-130-807			240	LOM ALL
EXTERNAL - GENERAL VISUAL: LOWER WING PANEL SKIN TASK 57-05-02-210-806			241	LOM ALL

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SUBJECT	CHAPTER SECTION SUBJECT	CONF	PAGE	EFFECT
EXTERNAL - DETAILED: LOWER WING PANEL SKIN TASK 57-05-02-211-813			243	LOM ALL
EXTERNAL - GENERAL VISUAL: LOWER WING PANEL SKIN TASK 57-05-02-210-808			245	LOM ALL
INTERNAL - DETAILED: LOWER WING PANEL, RAIL STRINGERS TASK 57-05-02-211-815			247	LOM ALL
INTERNAL - SPECIAL DETAILED: LOWER WING PANEL, RAIL STRINGERS TASK 57-05-02-130-809			249	LOM ALL
INTERNAL - GENERAL VISUAL: LOWER WING PANEL, RAIL STRINGERS TASK 57-05-02-210-810			250	LOM ALL
INTERNAL - SPECIAL DETAILED: LOWER WING PANEL, RAIL STRINGER TASK 57-05-02-130-811			253	LOM ALL
INTERNAL - GENERAL VISUAL: LOWER WING PANEL, SPLICE STRINGERS TASK 57-05-02-210-812			254	LOM ALL
EXTERNAL - SPECIAL DETAILED: LOWER WING PANEL, SPLICE STRINGERS TASK 57-05-02-250-819			258	LOM ALL
INTERNAL - SPECIAL DETAILED: LOWER WING PANEL, SPLICE STRINGERS TASK 57-05-02-130-813			258	LOM ALL
EXTERNAL - SPECIAL DETAILED: LOWER WING PANEL, SPLICE STRINGERS TASK 57-05-02-250-821			259	LOM ALL
INTERNAL - DETAILED: WING LOWER PANEL, SPLICE STRINGERS TASK 57-05-02-211-817			260	LOM ALL
EXTERNAL - SPECIAL DETAILED: WING LOWER PANEL, SPLICE STRINGERS TASK 57-05-02-250-825			264	LOM ALL

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SUBJECT	CHAPTER SECTION SUBJECT	CONF	PAGE	EFFECT
INTERNAL - SPECIAL DETAILED: WING LOWER PANEL, SPLICE STRINGER (DIRECTION 3) TASK 57-05-02-250-827			264	LOM ALL
INTERNAL - SPECIAL DETAILED: WING LOWER PANEL, SPLICE STRINGERS (DIRECTION 4) TASK 57-05-02-250-828			266	LOM ALL
INTERNAL - SPECIAL DETAILED: LOWER WING PANEL, SPLICE STRINGERS (DIRECTION 3) TASK 57-05-02-250-831			268	LOM ALL
EXTERNAL - SPECIAL DETAILED: SPLICE STRINGERS AT CHORDWISE SKIN SPLICES (UPPER AND LOWER PANEL) TASK 57-05-02-250-833			270	LOM ALL
INTERNAL - DETAILED: FRONT SPAR LOWER CHORD (SKIN FLANGE INSPECTIONS) TASK 57-05-02-211-819			270	LOM ALL
INTERNAL - SPECIAL DETAILED: FRONT SPAR LOWER CHORD (WEB FLANGE INSPECTIONS) TASK 57-05-02-130-815			273	LOM ALL
EXTERNAL - SPECIAL DETAILED: FRONT SPAR LOWER CHORD (SKIN FLANGE INSPECTIONS) TASK 57-05-02-250-835			276	LOM ALL
INTERNAL - DETAILED: FRONT SPAR LOWER CHORD (WEB FLANGE INSPECTIONS) TASK 57-05-02-211-821			276	LOM ALL
EXTERNAL - SPECIAL DETAILED: FRONT SPAR LOWER CHORD (SKIN FLANGE INSPECTIONS) TASK 57-05-02-250-837			281	LOM ALL
INTERNAL - SPECIAL DETAILED: FRONT SPAR LOWER CHORD (WEB FLANGE INSPECTIONS) TASK 57-05-02-130-817			281	LOM ALL

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SUBJECT	CHAPTER SECTION SUBJECT	CONF	PAGE	EFFECT
INTERNAL - GENERAL VISUAL: FRONT SPAR LOWER CHORD (WEB FLANGE INSPECTIONS) TASK 57-05-02-210-814			282	LOM ALL
INTERNAL - INSPECT (ULTRASONIC) ALL FASTENERS, OUTER LOCATION, COMMON TO THE R7/R8 NACELLE FITTING ATTACHMENT (DIRECTION 1) TASK 57-05-02-130-819			286	LOM ALL
INTERNAL - INSPECT (ULTRASONIC) ALL FASTENERS, INNER LOCATION, COMMON TO THE R7/R8 NACELLE FITTING ATTACHMENT (DIRECTION 3) TASK 57-05-02-130-820			287	LOM ALL
EXTERNAL - SPECIAL DETAILED: FRONT SPAR LOWER CHORD (WEB FLANGE INSPECTIONS) TASK 57-05-02-250-839			288	LOM ALL
INTERNAL - SPECIAL DETAILED: SPAR CHORDS AT CHORDWISE SKIN SPLICES (UPPER AND LOWER PANEL) TASK 57-05-02-130-821			288	LOM ALL
INTERNAL - INSPECT (HIGH FREQUENCY EDDY CURRENT) ALL FASTENERS, OUTER LOCATION, COMMON TO THE R7/R8 NACELLE FITTING ATTACHMENT (DIRECTION 2) TASK 57-05-02-250-841			290	LOM ALL
INTERNAL - INSPECT (HIGH FREQUENCY EDDY CURRENT) ALL FASTENERS, INNER LOCATION, COMMON TO THE R7/R8 NACELLE FITTING ATTACHMENT (DIRECTION 4) TASK 57-05-02-250-842			291	LOM ALL
INTERNAL - GENERAL VISUAL: REAR SPAR LOWER CHORD (SKIN FLANGE INSPECTIONS) TASK 57-05-02-210-816			292	LOM ALL
INTERNAL - GENERAL VISUAL: REAR SPAR LOWER CHORD (WEB FLANGE INSPECTIONS) TASK 57-05-02-210-818			295	LOM ALL

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SUBJECT	CHAPTER SECTION SUBJECT	CONF	PAGE	EFFECT
INTERNAL - SPECIAL DETAILED: REAR SPAR LOWER CHORD (WEB FLANGE INSPECTIONS) TASK 57-05-02-130-823			298.1	LOM ALL
INTERNAL - DETAILED: REAR SPAR LOWER CHORD (SKIN FLANGE INSPECTIONS) TASK 57-05-02-211-823			298.4	LOM ALL
EXTERNAL - SPECIAL DETAILED: REAR SPAR LOWER CHORD (SKIN FLANGE INSPECTIONS) TASK 57-05-02-250-845			298.8	LOM ALL
INTERNAL - SPECIAL DETAILED: DOUBLE PLUS CHORD UPPER HORIZONTAL FLANGE AT STUB BEAMS TASK 57-05-02-250-846			298.8	LOM ALL
INTERNAL - DETAILED: REAR SPAR LOWER CHORD (SKIN FLANGE INSPECTIONS) TASK 57-05-02-211-825			298.9	LOM ALL
INTERNAL - DETAILED: REAR SPAR LOWER CHORD (WEB FLANGE INSPECTIONS) TASK 57-05-02-211-827			298.12	LOM ALL
INTERNAL - SPECIAL DETAILED: LOWER SKIN PANEL AT MAIN LANDING GEAR OUTBOARD SUPPORT FITTINGS TASK 57-05-02-250-847			298.15	LOM ALL
INTERNAL - SPECIAL DETAILED: SKIN AT NACELLE SUPPORT FITTING ATTACHMENTS TASK 57-05-02-250-849			298.15	LOM ALL
INTERNAL - SPECIAL DETAILED: SIDE-OF-BODY SPLICE, LOWER SURFACE SKIN TASK 57-05-02-250-850			298.17	LOM ALL
EXTERNAL - SPECIAL DETAILED: LOWER WING PANEL SKIN AT SHEAR TIED RIB ATTACHMENTS TASK 57-05-02-250-851			298.19	LOM ALL
INTERNAL - SPECIAL DETAILED: SIDE-OF-BODY SPLICE, LOWER SURFACE SKIN TASK 57-05-02-250-852			298.19	LOM ALL

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SUBJECT	CHAPTER SECTION SUBJECT	CONF	PAGE	EFFECT
INTERNAL - SPECIAL DETAILED: LOWER WING PANEL UNDER FLAP TRACK FITTINGS (DIRECTION 1) TASK 57-05-02-250-853			298.20	LOM ALL
INTERNAL - SPECIAL DETAILED: LOWER WING PANEL UNDER FLAP TRACK FITTINGS (DIRECTION 2) TASK 57-05-02-250-854			298.22	LOM ALL
INTERNAL - SPECIAL DETAILED: LOWER WING PANEL UNDER FLAP TRACK FITTINGS (DIRECTION 1) TASK 57-05-02-130-825			298.25	LOM ALL
INTERNAL - SPECIAL DETAILED: LOWER WING PANEL, RAIL STRINGERS TASK 57-05-02-250-855			298.27	LOM ALL
EXTERNAL - DETAILED: UPPER WING PANEL TYPICAL STRINGERS TASK 57-05-02-211-829			298.27	LOM ALL
INTERNAL - DETAILED: REAR SPAR UPPER CHORD SKIN FLANGE INSPECTIONS TASK 57-05-02-211-831			298.29	LOM ALL
EXTERNAL - SPECIAL DETAILED: REAR SPAR UPPER CHORD (SKIN FLANGE INSPECTIONS) TASK 57-05-02-250-857			298.32	LOM ALL
INTERNAL - SPECIAL DETAILED: REAR SPAR UPPER CHORD (WEB FLANGE INSPECTIONS) TASK 57-05-02-250-859			298.32	LOM ALL
INTERNAL - SPECIAL DETAILED: REAR SPAR UPPER CHORD (WEB FLANGE INSPECTIONS) TASK 57-05-02-130-827			298.34	LOM ALL
INTERNAL - SPECIAL DETAILED: WING UPPER SKIN TAB AT R1 NACELLE FITTING TASK 57-05-02-250-861			298.36	LOM ALL
INTERNAL - DETAILED: FRONT SPAR WEB CRACK - TYPICAL DETAILS TASK 57-05-02-211-833			298.36	LOM ALL
EXTERNAL- DETAILED: OUTBOARD WING REAR SPAR WEB TYPICAL DETAILS TASK 57-05-02-211-835			298.39	LOM ALL

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SUBJECT	CHAPTER SECTION SUBJECT	CONF	PAGE	EFFECT
EXTERNAL - DETAILED: OUTBOARD WING REAR SPAR WEB TYPICAL DETAILS TASK 57-05-02-211-837			298.41	LOM ALL
INTERNAL - SPECIAL DETAILED: REAR SPAR WEB AT TRUNNION ATTACHMENT, MLG AND T.E. FITTINGS TASK 57-05-02-130-829			298.41	LOM ALL
INTERNAL - SPECIAL DETAILED: RIB 25 UPPER AND LOWER HORIZONTAL FLANGE TASK 57-05-02-250-863			298.42	LOM ALL
EXTERNAL - SPECIAL DETAILED: RIB 27, UPPER AND LOWER RIB FLANGE TO SKIN ATTACHMENT TASK 57-05-02-250-865			298.43	LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-460, 464-999
INTERNAL - SPECIAL DETAILED: RIB 27, FRONT AND REAR SPAR TENSION FITTINGS TASK 57-05-02-250-867			298.43	LOM ALL
INTERNAL - SPECIAL DETAILED: FRONT SPAR LOWER CHORD (WEB FLANGE INSPECTIONS) TASK 57-05-02-250-868			298.43	LOM ALL
INTERNAL - DETAILED: STRUT TO WING ATTACHMENTS TASK 57-05-02-211-839			298.45	LOM ALL
INTERNAL - SPECIAL DETAILED: IN-SPAR RIB, STATION 0, WINGLET TASK 57-05-02-250-869			298.48	LOM ALL
INTERNAL - SPECIAL DETAILED: IN-SPAR RIB, STA 0 BOLT HOLES TASK 57-05-02-250-871			298.48	LOM ALL
EXTERNAL - SPECIAL DETAILED: FRONT SPAR LOWER CHORD (SKIN AND WEB FLANGE INSPECTIONS) TASK 57-05-02-250-872			298.49	LOM ALL
INTERNAL - DETAILED: INBOARD ACTUATOR SUPPORT FITTINGS TASK 57-05-02-211-841			298.49	LOM ALL

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SUBJECT	CHAPTER SECTION SUBJECT	CONF	PAGE	EFFECT
EXTERNAL - SPECIAL DETAILED: GEAR BEAM INBOARD SUPPORT FITTING TASK 57-05-02-250-873			298.52	LOM ALL
EXTERNAL - SPECIAL DETAILED: REAR SPAR LOWER CHORD (SKIN AND WEB FLANGE INSPECTIONS) TASK 57-05-02-250-874			298.52	LOM ALL
INTERNAL - DETAILED: TRACK #1 & #8 - OUTBOARD MAIN FLAP OUTBOARD TRACK TASK 57-05-02-211-843			298.52	LOM ALL
INTERNAL - SPECIAL DETAILED: UPPER WING PANEL AT SIDE-OF-BODY DOUBLE PLUS CHORD (DIRECTION 2) TASK 57-05-02-250-876			298.55	LOM ALL
INTERNAL - DETAILED: SUPPORT, FORWARD FITTING ASSY FLAP TRACKS 1, 2, 3, (6, 7, & 8) TASK 57-05-02-211-845			298.56	LOM ALL
INTERNAL - DETAILED: TRACK #2 & #7- OUTBOARD MAIN FLAP, INBOARD TRACK TASK 57-05-02-211-847			298.59	LOM ALL
INTERNAL - SPECIAL DETAILED: UPPER WING PANEL AT SIDE-OF-BODY DOUBLE PLUS CHORD (DIRECTION 2) TASK 57-05-02-250-878			298.61	LOM ALL
INTERNAL - DETAILED: TRACK #3 & #6- INBOARD MAIN FLAP, OUTBOARD TRACK TASK 57-05-02-211-849			298.62	LOM ALL
INTERNAL - SPECIAL DETAILED: UPPER WING PANEL AT SIDE-OF-BODY DOUBLE PLUS CHORD (DIRECTION 3) TASK 57-05-02-250-880			298.64	LOM ALL
INTERNAL - SPECIAL DETAILED: No. 4 and No. 5 SUPPORT, AFT LINK PINS TASK 57-05-02-130-831			298.65	LOM ALL
INTERNAL - DETAILED: TRACK #4 & #5- INBOARD MAIN FLAP, INBOARD TRACK TASK 57-05-02-211-851			298.65	LOM ALL

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SUBJECT	CHAPTER SECTION SUBJECT	CONF	PAGE	EFFECT
INTERNAL - SPECIAL DETAILED: UPPER WING PANEL AT SIDE-OF-BODY DOUBLE PLUS CHORD (DIRECTION 3) TASK 57-05-02-250-882			298.68	LOM ALL
INTERNAL - SPECIAL DETAILED: INBOARD MAIN FLAP FITTING ASSEMBLY FWD, INBOARD TRACK TASK 57-05-02-250-883			298.69	LOM ALL
INTERNAL - SPECIAL DETAILED: OUTBOARD WING REAR SPAR WEB TYPICAL DETAILS TASK 57-05-02-250-884			298.70	LOM ALL
INTERNAL - DETAILED: FRONT SPAR UPPER CHORD TASK 57-05-02-211-853			298.70	LOM ALL
INTERNAL - SPECIAL DETAILED: FRONT SPAR UPPER AND LOWER CHORD TASK 57-05-02-250-885			298.73	LOM ALL
INTERNAL - GENERAL VISUAL: FRONT SPAR CUTOUT/ FRONT SPAR FITTING TASK 57-05-02-210-820			298.73	LOM ALL
INTERNAL - GENERAL VISUAL: UPPER WING PANEL SPLICE STRINGER TASK 57-05-02-210-821			298.76	LOM ALL
INTERNAL - DETAILED: REAR SPAR CHORD AT INBD AND OUTBD CUTOUT TASK 57-05-02-211-855			298.78	LOM ALL
INTERNAL - DETAILED: REAR SPAR CHORD AT INBD AND OUTBD PUSHROD CUTOUT TASK 57-05-02-211-857			298.80	LOM ALL
EXTERNAL - DETAILED: REAR SPAR CHORD AT INBOARD AND OUTBOARD PUSHROD CUTOUT TASK 57-05-02-211-858			298.82	LOM ALL
INTERNAL - DETAILED: REAR SPAR UPPER CHORD TASK 57-05-02-211-861			298.84	LOM ALL
INTERNAL - SPECIAL DETAILED: REAR SPAR UPPER CHORD TASK 57-05-02-250-887			298.86	LOM ALL

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SUBJECT	CHAPTER SECTION SUBJECT	CONF	PAGE	EFFECT
EXTERNAL - DETAILED: INBOARD MAIN FLAP - IN-SPAR UPPER SKIN PANELS TASK 57-05-02-211-863			298.86	LOM ALL
INTERNAL - SPECIAL DETAILED: INBOARD MAIN FLAP, INBOARD TORQUE TUBE RIB TASK 57-05-02-250-889			298.89	LOM ALL
INTERNAL - GENERAL VISUAL: INBD MAIN FLAP - TORQUE TUBE TASK 57-05-02-210-822			298.89	LOM ALL
INTERNAL - GENERAL VISUAL: DOUBLE PLUS CHORD UPPER HORIZONTAL FLANGE TASK 57-05-02-210-823			298.92	LOM ALL
INTERNAL - SPECIAL DETAILED: INBD MAIN FLAP, REAR SPAR TASK 57-05-02-250-891			298.94	LOM ALL
INTERNAL - SPECIAL DETAILED: INBD FLAP- No. 3 & No. 6 CARRIAGE ASSY TASK 57-05-02-250-893			298.94	LOM ALL
INTERNAL - SPECIAL DETAILED: INBD FLAP - No. 4 & No. 5 CARRIAGE ASSY TASK 57-05-02-250-895			298.95	LOM ALL
INTERNAL - DETAILED: INBD FLAP - NO.4 & NO.5 CARRIAGE ASSY TASK 57-05-02-211-865			298.97	LOM ALL
INTERNAL - DETAILED: INBOARD MAIN FLAP TASK 57-05-02-211-867			298.100	LOM ALL
INTERNAL - SPECIAL DETAILED: No. 1 & No. 8 CARRIAGE ASSEMBLY TASK 57-05-02-250-897			298.103	LOM ALL
INTERNAL - SPECIAL DETAILED: No. 1 & No. 8 CARRIAGE ASSEMBLY TASK 57-05-02-250-899			298.103	LOM ALL
INTERNAL - SPECIAL DETAILED: No. 2 & No. 7 CARRIAGE ASSEMBLY TASK 57-05-02-250-901			298.104	LOM ALL
INTERNAL - SPECIAL DETAILED: No. 2 & No. 7 CARRIAGE ASSEMBLY TASK 57-05-02-250-903			298.105	LOM ALL

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SUBJECT	CHAPTER SECTION SUBJECT	CONF	PAGE	EFFECT
INTERNAL - SPECIAL DETAILED: FRONT SPAR ASSEMBLY - OUTBD MAIN FLAP TASK 57-05-02-250-905			298.106	LOM ALL
INTERNAL - SPECIAL DETAILED: FRONT SPAR ASSEMBLY - OUTBD MAIN FLAP TASK 57-05-02-250-907			298.107	LOM ALL
INTERNAL - SPECIAL DETAILED: REAR SPAR - OUTBD MAIN FLAP TASK 57-05-02-250-909			298.108	LOM ALL
EXTERNAL - SPECIAL DETAILED: REAR SPAR - OUTBD MAIN FLAP TASK 57-05-02-250-911			298.109	LOM ALL
INTERNAL - SPECIAL DETAILED: REAR SPAR - OUTBD MAIN FLAP TASK 57-05-02-250-913			298.109	LOM ALL
EXTERNAL - SPECIAL DETAILED: LOWER SKIN - OUTBD MAIN FLAP, FRONT SPAR AND REAR SPAR LWR CHORD - LWR SKIN INTERFACE TASK 57-05-02-250-915			298.110	LOM ALL
INTERNAL - SPECIAL DETAILED: FRONT SPAR SPIGOT FITTING - OUTBD MAIN FLAP TASK 57-05-02-240-801			298.110	LOM ALL
INTERNAL - DETAILED: REAR SPAR SPIGOT FITTING - OUTBD MAIN FLAP TASK 57-05-02-211-877			298.111	LOM ALL
INTERNAL - DETAILED: AFT FLAP TRACK SUPPORT RIBS #2 AND #3 TASK 57-05-02-211-871			298.113	LOM ALL
INTERNAL - DETAILED: HINGE/ACTUATOR FITTINGS TASK 57-05-02-211-873			298.114	LOM ALL
INTERNAL - SPECIAL DETAILED: LOWER WING PANEL, RAIL STRINGER TASK 57-05-02-130-833			298.116	LOM ALL
INTERNAL - SPECIAL DETAILED: LOWER WING PANEL, SPLICE STRINGERS (DIRECTION 3) TASK 57-05-02-211-875			298.116	LOM ALL

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SUBJECT	CHAPTER SECTION SUBJECT	CONF	PAGE	EFFECT
INTERNAL - SPECIAL DETAILED: LOWER WING PANEL, SPLICE STRINGERS (DIRECTION 4) TASK 57-05-02-250-917			298.118	LOM ALL
INTERNAL - SPECIAL DETAILED:LEFT LOWER WING PANEL RAIL STRINGER TASK 57-05-02-200-801			298.119	LOM ALL
INTERNAL - SPECIAL DETAILED: RIGHT LOWER WING PANEL RAIL STRINGE TASK 57-05-02-200-802			298.122	LOM ALL
EXTERNAL - SPECIAL DETAILED: LEFT LOWER WING PANEL SPLICE STRINGERS TASK 57-05-02-200-803			298.122	LOM ALL
EXTERNAL - SPECIAL DETAILED: RIGHT LOWER WING PANEL SPLICE STRINGERS TASK 57-05-02-200-804			298.122	LOM ALL
INTERNAL - HIGH FREQUENCY EDDY CURRENT: LEFT LOWER WING PANEL SPLICE STRINGERS TASK 57-05-02-200-805			298.122	LOM ALL
INTERNAL - HIGH FREQUENCY EDDY CURRENT: RIGHT LOWER WING PANEL SPLICE STRINGERS TASK 57-05-02-200-806			298.123	LOM ALL
INTERNAL - SPECIAL DETAILED:LEFT LOWER WING PANEL UNDER NACELLE FITTINGS TASK 57-05-02-200-807			298.123	LOM ALL
INTERNAL - SPECIAL DETAILED: RIGHT LOWER WING PANEL UNDER NACELLE FITTINGS TASK 57-05-02-200-808			298.123	LOM ALL
EXTERNAL - SPECIAL DETAILED: SPAR CHORDS AT CHORDWISE SKIN SPLICES (UPPER AND LOWER PANEL) TASK 57-05-02-250-919			298.123	LOM ALL
INTERNAL - SPECIAL DETAILED: LOWER SKIN PANEL AT MAIN LANDING GEAR OUTBOARD SUPPORT FITTINGS TASK 57-05-02-250-920			298.124	LOM ALL

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SUBJECT	CHAPTER SECTION SUBJECT	CONF	PAGE	EFFECT
INTERNAL - SPECIAL DETAILED: SKIN AT NACELLE SUPPORT FITTING ATTACHMENTS TASK 57-05-02-130-835			298.124	LOM ALL
INTERNAL- GENERAL VISUAL: DOUBLE PLUS CHORD UPPER VERTICAL FLANGE TASK 57-05-02-210-824			298.126	LOM ALL
INTERNAL- SPECIAL DETAILED: DOUBLE PLUS CHORD UPPER VERTICAL FLANGE TASK 57-05-02-250-921			298.128	LOM ALL
INTERNAL - SPECIAL DETAILED: WCS REAR SPAR TYPICAL WEB LOCATIONS (NON-HIDDEN LOCATIONS) TASK 57-05-02-250-922			298.128	LOM ALL
INTERNAL - SPECIAL DETAILED: UPPER WING PANEL AT SIDE-OF-BODY DOUBLE PLUS CHORD TASK 57-05-02-250-923			298.129	LOM ALL
INTERNAL - DETAILED: WING LOWER PANEL, SPLICE STRINGERS TASK 57-05-02-211-878			298.130	LOM ALL
INTERNAL - SPECIAL DETAILED: LOWER WING PANEL, SPLICE STRINGERS (DIRECTION 4) TASK 57-05-02-250-924			298.134	LOM ALL
EXTERNAL - SPECIAL DETAILED: FRONT SPAR LOWER CHORD (WEB FLANGE INSPECTIONS) TASK 57-05-02-250-925			298.135	LOM ALL
INTERNAL - SPECIAL DETAILED: WING CENTER SECTION LOWER PANEL TASK 57-05-02-250-926			298.136	LOM ALL
INTERNAL - SPECIAL DETAILED: REAR SPAR LOWER CHORD (SKIN FLANGE AND WEB FLANGE INSPECTIONS) TASK 57-05-02-250-927			298.136	LOM ALL
INTERNAL - SPECIAL DETAILED: REAR SPAR UPPER CHORD (SKIN FLANGE AND WEB FLANGE INSPECTIONS) TASK 57-05-02-250-928			298.141	LOM ALL

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SUBJECT	CHAPTER SECTION SUBJECT	CONF	PAGE	EFFECT
INTERNAL - DETAILED: WING CENTER SECTION LOWER PANEL SKIN TASK 57-05-02-211-880			298.144	LOM ALL
WINGS - STRUCTURAL INSPECTIONS - MAINTENANCE PRACTICES	57-05-03		201	LOM ALL
INTERNAL - GENERAL VISUAL: WING CENTER SECTION TASK 57-05-03-210-801			201	LOM ALL
INTERNAL - GENERAL VISUAL: WING CENTER SECTION TASK 57-05-03-210-802			205	LOM ALL
EXTERNAL - GENERAL VISUAL: WING CENTER SECTION TASK 57-05-03-210-803			211	LOM ALL
INTERNAL - GENERAL VISUAL: WING CENTER SECTION TASK 57-05-03-210-804			216	LOM ALL
INTERNAL - GENERAL VISUAL: WING CENTER SECTION TASK 57-05-03-210-805			220	LOM ALL
INTERNAL - GENERAL VISUAL: LEFT OUTBOARD WING TASK 57-05-03-210-806			224	LOM ALL
INTERNAL - GENERAL VISUAL: RIGHT OUTBOARD WING TASK 57-05-03-210-807			228	LOM ALL
INTERNAL - GENERAL VISUAL: LEFT OUTBOARD WING TASK 57-05-03-210-808			232	LOM ALL
INTERNAL - GENERAL VISUAL: RIGHT OUTBOARD WING TASK 57-05-03-210-809			235	LOM ALL
INTERNAL - GENERAL VISUAL: WING CENTER SECTION TASK 57-05-03-210-810			238	LOM ALL
INTERNAL - GENERAL VISUAL: LEFT NACELLE SUPPORT FITTINGS TASK 57-05-03-210-811			240	LOM ALL

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SUBJECT	CHAPTER SECTION SUBJECT	CONF	PAGE	EFFECT
INTERNAL - GENERAL VISUAL: RIGHT NACELLE SUPPORT FITTINGS TASK 57-05-03-210-812			243	LOM ALL
INTERNAL - GENERAL VISUAL: LEFT OUTBOARD WING LOWER SURFACE TASK 57-05-03-210-813			246	LOM ALL
INTERNAL - GENERAL VISUAL: RIGHT OUTBOARD WING LOWER SURFACE TASK 57-05-03-210-814			248	LOM ALL
INTERNAL - GENERAL VISUAL: LEFT OUTBOARD WING FRONT SPAR TASK 57-05-03-210-815			250	LOM ALL
INTERNAL - GENERAL VISUAL: RIGHT OUTBOARD WING FRONT SPAR TASK 57-05-03-210-816			258	LOM ALL
INTERNAL - GENERAL VISUAL: LEFT OUTBOARD WING LEADING EDGE STRUCTURE TASK 57-05-03-210-817			266	LOM ALL
INTERNAL - GENERAL VISUAL: RIGHT OUTBOARD WING LEADING EDGE STRUCTURE TASK 57-05-03-210-818			273	LOM ALL
INTERNAL - DETAILED: LEFT WING SLAT TRACKS TASK 57-05-03-211-801			280	LOM ALL
INTERNAL - DETAILED: RIGHT WING SLAT TRACKS TASK 57-05-03-211-802			284	LOM ALL
INTERNAL - GENERAL VISUAL: LEFT OUTBOARD WING ACCESS HOLES TASK 57-05-03-210-819			288	LOM ALL
INTERNAL - GENERAL VISUAL: RIGHT OUTBOARD WING ACCESS HOLES TASK 57-05-03-210-820			293	LOM ALL
INTERNAL - GENERAL VISUAL: LEFT OUTBOARD WING TASK 57-05-03-210-821			298	LOM ALL

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SUBJECT	CHAPTER SECTION SUBJECT	CONF	PAGE	EFFECT
INTERNAL - GENERAL VISUAL: RIGHT OUTBOARD WING TASK 57-05-03-210-822			298.3	LOM ALL
INTERNAL - GENERAL VISUAL: LEFT OUTBOARD WING TASK 57-05-03-210-823			298.6	LOM ALL
INTERNAL - GENERAL VISUAL: RIGHT OUTBOARD WING TASK 57-05-03-210-824			298.12	LOM ALL
INTERNAL - GENERAL VISUAL: LEFT OUTBOARD WING TASK 57-05-03-210-825			298.18	LOM ALL
INTERNAL - GENERAL VISUAL: RIGHT OUTBOARD WING TASK 57-05-03-210-826			298.21	LOM ALL
INTERNAL - GENERAL VISUAL: LEFT FLAP SUPPORT NO. 4 TASK 57-05-03-210-827			298.24	LOM ALL
INTERNAL - GENERAL VISUAL: RIGHT FLAP SUPPORT NO. 5 TASK 57-05-03-210-828			298.26	LOM ALL
INTERNAL - GENERAL VISUAL: LEFT FLAP SUPPORT NO. 3 TASK 57-05-03-210-829			298.28	LOM ALL
INTERNAL - GENERAL VISUAL: RIGHT FLAP SUPPORT NO. 6 TASK 57-05-03-210-830			298.30	LOM ALL
INTERNAL - GENERAL VISUAL: LEFT OUTBOARD WING LOWER SURFACE TASK 57-05-03-210-831			298.32	LOM ALL
INTERNAL - GENERAL VISUAL: RIGHT OUTBOARD WING LOWER SURFACE TASK 57-05-03-210-832			298.34	LOM ALL
INTERNAL - GENERAL VISUAL: FLAP SUPPORTS NO. 1 & 2 TASK 57-05-03-210-833			298.36	LOM ALL

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SUBJECT	CHAPTER SECTION SUBJECT	CONF	PAGE	EFFECT
INTERNAL - GENERAL VISUAL: FLAP SUPPORTS NO. 7 & 8 TASK 57-05-03-210-834			298.39	LOM ALL
INTERNAL - GENERAL VISUAL: LEFT OUTBOARD WING LOWER SURFACE TASK 57-05-03-210-835			298.42	LOM ALL
INTERNAL - GENERAL VISUAL: RIGHT OUTBOARD WING LOWER SURFACE TASK 57-05-03-210-836			298.45	LOM ALL
INTERNAL - GENERAL VISUAL: LEFT MAIN LANDING GEAR SUPPORT STRUCTURE TASK 57-05-03-210-837			298.48	LOM ALL
INTERNAL - GENERAL VISUAL: RIGHT MAIN LANDING GEAR SUPPORT STRUCTURE TASK 57-05-03-210-838			298.52	LOM ALL
INTERNAL - GENERAL VISUAL: LEFT WING OUTBOARD REAR SPAR TASK 57-05-03-210-839			298.56	LOM ALL
INTERNAL - GENERAL VISUAL: RIGHT WING OUTBOARD REAR SPAR TASK 57-05-03-210-840			298.59	LOM ALL
INTERNAL - GENERAL VISUAL: LEFT WING OUTBOARD TRAILING EDGE STRUCTURE TASK 57-05-03-210-841			298.62	LOM ALL
INTERNAL - GENERAL VISUAL: RIGHT WING OUTBOARD TRAILING EDGE STRUCTURE TASK 57-05-03-210-842			298.71	LOM ALL
INTERNAL - GENERAL VISUAL: LEFT INBOARD GROUND SPOILER TASK 57-05-03-210-843			298.80	LOM ALL
INTERNAL - GENERAL VISUAL: RIGHT INBOARD GROUND SPOILER TASK 57-05-03-210-844			298.83	LOM ALL
INTERNAL - GENERAL VISUAL: LEFT INBOARD FLAP TASK 57-05-03-210-845			298.86	LOM ALL

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SUBJECT	CHAPTER SECTION SUBJECT	CONF	PAGE	EFFECT
INTERNAL - GENERAL VISUAL: RIGHT INBOARD FLAP TASK 57-05-03-210-846			298.89	LOM ALL
INTERNAL - GENERAL VISUAL: LEFT OUTBOARD WING REAR SPAR TASK 57-05-03-210-847			298.92	LOM ALL
INTERNAL - GENERAL VISUAL: RIGHT OUTBOARD WING REAR SPAR TASK 57-05-03-210-848			298.96	LOM ALL
INTERNAL - GENERAL VISUAL: LEFT OUTBOARD FLAP TASK 57-05-03-210-849			298.100	LOM ALL
INTERNAL - GENERAL VISUAL: RIGHT OUTBOARD FLAP TASK 57-05-03-210-850			298.105	LOM ALL
INTERNAL - SPECIAL DETAILED: LEFT WINGLET TASK 57-05-03-211-803			298.110	LOM ALL
INTERNAL - SPECIAL DETAILED: RIGHT WINGLET TASK 57-05-03-211-804			298.112	LOM ALL
INTERNAL - DETAILED: LEFT WINGLET TASK 57-05-03-211-805			298.114	LOM ALL
INTERNAL - DETAILED: RIGHT WINGLET TASK 57-05-03-211-806			298.118	LOM ALL
WING CENTER SECTION - CORROSION PREVENTION	57-14-00		201	LOM ALL
Wing Center Section - Corrosion Prevention TASK 57-14-00-910-801			201	LOM ALL
MAIN LANDING GEAR SUPPORT BEAM - CORROSION PREVENTION	57-15-00		201	LOM ALL
Main Landing Gear Support Beam - Corrosion Prevention TASK 57-15-00-910-801			201	LOM ALL

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CHAPTER 57
WINGS

SUBJECT	CHAPTER SECTION SUBJECT	CONF	PAGE	EFFECT
MAIN LANDING GEAR SUPPORT BEAM - REMOVAL/INSTALLATION	57-15-00		401	LOM ALL
Landing Gear Support Beam Removal TASK 57-15-00-000-801			401	LOM ALL
Landing Gear Support Beam Installation TASK 57-15-00-400-801			406	LOM ALL
LANDING GEAR SUPPORT BEAM - INSPECTION/CHECK	57-15-00		601	LOM ALL
Landing Gear Support Beam - Inspection TASK 57-15-00-200-801			601	LOM ALL
Main Landing Gear Beam Hanger Link - Free Play Check TASK 57-15-00-200-802			613	LOM ALL
MAIN LANDING GEAR SUPPORT BEAM HANGER LINKS UPPER AND LOWER PIN - REMOVAL/INSTALLATION	57-15-01		401	LOM ALL
Main Landing Gear Support Beam Hanger Links Upper And Lower Pin Removal TASK 57-15-01-020-801			401	LOM ALL
Main Landing Gear Support Beam Hanger Links Upper And Lower Pin Installation TASK 57-15-01-420-801			407	LOM ALL
MLG FORWARD TRUNNION HOUSING ASSEMBLY - REMOVAL/INSTALLATION	57-16-01		401	LOM ALL
MLG Forward Trunnion Housing Assembly - Removal TASK 57-16-01-000-801			401	LOM ALL
MLG Forward Trunnion Housing Assembly - Installation TASK 57-16-01-400-801			408	LOM ALL
MLG FORWARD TRUNNION BEARING AND SUPPORT - INSPECTION/CHECK	57-16-01		601	LOM ALL
MLG Forward Trunnion Bearing Wear Limits TASK 57-16-01-200-801			601	LOM ALL

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CHAPTER 57
WINGS

SUBJECT	CHAPTER SECTION SUBJECT	CONF	PAGE	EFFECT
MAIN LANDING GEAR (MLG) AFT TRUNNION BEARING ASSEMBLY - REMOVAL/INSTALLATION	57-16-02		401	LOM ALL
MLG Aft Trunnion Bearing Assembly Removal TASK 57-16-02-000-801			401	LOM ALL
MLG Aft Trunnion Bearing Assembly Installation TASK 57-16-02-400-801			406	LOM ALL
MAIN LANDING GEAR REAR SPAR STABLIZER ATTACHMENT FITTING ASSEMBLY - REMOVAL/INSTALLATION	57-16-03		401	LOM ALL
MLG Rear Spar Stabilizer Attachment Fitting Assembly Removal TASK 57-16-03-000-801			401	LOM ALL
MLG Rear Spar Stabilizer Attachment Fitting Assembly Installation TASK 57-16-03-400-801			407	LOM ALL
MAIN LANDING GEAR SUPPORT BEAM OUTBOARD FITTING ASSEMBLY - REMOVAL/INSTALLATION	57-16-04		401	LOM ALL
MLG Support Beam Outboard Fitting Assembly Removal TASK 57-16-04-000-801			401	LOM ALL
MLG Support Beam Outboard Fitting Assembly Installation TASK 57-16-04-400-801			408	LOM ALL
MAIN LANDING GEAR IDLER LINK SUPPORT FITTING ASSEMBLY - REMOVAL/INSTALLATION	57-16-05		401	LOM ALL
Idler Link Support Fitting Assembly Removal TASK 57-16-05-000-801			401	LOM ALL
Idler Link Support Fitting Assembly Installation TASK 57-16-05-400-801			405	LOM ALL
OUTER WING - CORROSION PREVENTION	57-20-00		201	LOM ALL
Outer Wing - Corrosion Prevention TASK 57-20-00-910-801			201	LOM ALL

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CHAPTER 57
WINGS

SUBJECT	CHAPTER SECTION SUBJECT	CONF	PAGE	EFFECT
WINGLET - REMOVAL/INSTALLATION	57-21-21		401	LOM ALL
Winglet Removal TASK 57-21-21-000-801			401	LOM ALL
Winglet Installation TASK 57-21-21-400-801			410	LOM ALL
Blended Winglet Tip Fairing Removal TASK 57-21-21-000-803			431	LOM ALL
Blended Winglet Tip Fairing Installation TASK 57-21-21-400-803			438	LOM ALL
Winglet Bulb Seal Removal TASK 57-21-21-000-805			441	LOM ALL
Winglet Bulb Seal Installation TASK 57-21-21-400-805			444	LOM ALL
WINGLET - PAINTING/CLEANING	57-21-21		701	LOM ALL
Winglet - Painting TASK 57-21-21-300-801			701	LOM ALL
WINGLET SEALS - REPAIRS	57-21-21		801	LOM ALL
Seal Repair Procedure Surface Preparation TASK 57-21-21-100-801			801	LOM ALL
Seal Repair Procedures For Specified Types of Seal Damage TASK 57-21-21-350-801			802	LOM ALL
Seal Repair Procedure (Method A) TASK 57-21-21-350-802			808	LOM ALL
Seal Repair Procedure (Method B) TASK 57-21-21-350-803			808	LOM ALL
Seal Repair Procedure (Method C) TASK 57-21-21-350-804			808	LOM ALL
WINGLET POSITION AND ANTI-COLLISION LIGHTS AND LENS - MAINTENANCE PRACTICES	57-21-22		201	LOM ALL
Aft Position Light Fairing Removal TASK 57-21-22-000-804			201	LOM ALL
Aft Position Light Fairing Installation TASK 57-21-22-400-801			204	LOM ALL

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SUBJECT	CHAPTER SECTION SUBJECT	CONF	PAGE	EFFECT
Forward Position Light and Anti-Collision Light Lens (Dual Forward Lens) Removal TASK 57-21-22-000-803			206	LOM ALL; AIRPLANES WITH DUAL FORWARD LENS CONFIGURATION
Forward Position Light and Anti-Collision Light Lens (Dual Forward Lens) Installation TASK 57-21-22-400-804			210	LOM ALL; AIRPLANES WITH DUAL FORWARD LENS CONFIGURATION
Forward Position Light and Anti-Collision Light Panel (Dual Forward Lens) Removal TASK 57-21-22-000-806			212	LOM ALL; AIRPLANES WITH DUAL FORWARD LENS CONFIGURATION
Forward Position Light and Anti-Collision Light Panel (Dual Forward Lens) Installation TASK 57-21-22-400-806			216	LOM ALL; AIRPLANES WITH DUAL FORWARD LENS CONFIGURATION
WINGLET FORWARD ANTI-COLLISION LIGHT AND POSITION LIGHT LENS - INSPECTION/CHECK	57-21-22		601	LOM ALL
Forward Position Light and Anti-Collision Light Lens (Dual Lens) Inspection TASK 57-21-22-200-802			601	LOM ALL
WINGLET LEADING EDGE LIGHT LENS - REPAIR	57-21-22		801	LOM ALL
Polish the Leading Edge Light Lens TASK 57-21-22-910-801			801	LOM ALL
WING DRY BAY TANK ACCESS DOORS - REMOVAL/INSTALLATION	57-21-23		401	LOM ALL
Dry Bay Access Doors Removal TASK 57-21-23-000-801			401	LOM ALL
Dry Bay Access Doors Installation TASK 57-21-23-400-801			412	LOM ALL
WING DRY BAY TANK VAPOR SEAL - INSPECTION/CHECK	57-21-23		601	LOM ALL
Vapor Seal Leak Check TASK 57-21-23-790-801			601	LOM ALL
WING DRY BAY TANK VAPOR SEAL - REPAIR	57-21-23		801	LOM ALL
Repair of Sealant Leaks in the Wing Dry Bay Tanks TASK 57-21-23-390-801			801	LOM ALL

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CHAPTER 57
WINGS

SUBJECT	CHAPTER SECTION SUBJECT	CONF	PAGE	EFFECT
WING VORTEX GENERATORS - REMOVAL/INSTALLATION	57-32-00		401	LOM ALL
Remove the Wing Vortex Generators TASK 57-32-00-000-801			401	LOM ALL
Install the Wing Vortex Generator TASK 57-32-00-400-801			402	LOM ALL
WING LEADING EDGE - CORROSION PREVENTION	57-41-00		201	LOM ALL
Wing Leading Edge - Corrosion Prevention TASK 57-41-00-910-801			201	LOM ALL
LEADING EDGE ACCESS PANELS - MAINTENANCE PRACTICES	57-41-02		201	LOM ALL
Leading Edge Access Panel Removal TASK 57-41-02-000-801			201	LOM ALL
Leading Edge Access Panel Installation TASK 57-41-02-400-801			208	LOM ALL
OUTBOARD LEADING EDGE SLAT ROLLERS - REMOVAL/INSTALLATION	57-44-01		401	LOM ALL
Outboard Leading Edge Slat Roller - Removal TASK 57-44-01-000-801			401	LOM ALL
Outboard Leading Edge Rollers Installation TASK 57-44-01-400-801			408	LOM ALL
OUTBOARD LEADING EDGE BALLAST - REMOVAL/INSTALLATION	57-44-02		401	LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-434, 437-447, 457
Outboard Leading Edge Ballast Removal TASK 57-44-02-000-801			401	LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-434, 437-447, 457
Outboard Leading Edge Ballast Installation TASK 57-44-02-400-801			407	LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-434, 437-447, 457
OUTBOARD LEADING EDGE SEAL RIB - INSPECTION/CHECK	57-44-03		601	LOM ALL
Check of Sealant at Leading Edge Seal Rib TASK 57-44-03-200-801			601	LOM ALL

ECCN 9E991 BOEING PROPRIETARY - See title page for details

CHAPTER 57
WINGS

SUBJECT	CHAPTER SECTION SUBJECT	CONF	PAGE	EFFECT
OUTBOARD LEADING EDGE SEAL RIB - REPAIR	57-44-03		801	LOM ALL
Repair of Sealant at Leading Edge Seal Rib TASK 57-44-03-390-801			801	LOM ALL
TRAILING EDGE FLAPS - CORROSION PREVENTION	57-50-00		201	LOM ALL
Trailing Edge Flaps - Corrosion Prevention TASK 57-50-00-910-801			202	LOM ALL
FIXED TRAILING EDGE UPPER PANEL - REMOVAL/INSTALLATION	57-50-01		401	LOM ALL
Inboard Fixed Trailing Edge Upper Panel - Removal TASK 57-50-01-000-801			401	LOM ALL
Inboard Fixed Trailing Edge Upper Panel - Installation TASK 57-50-01-400-801			408	LOM ALL
FIXED TRAILING EDGE UPPER PANEL - ADJUSTMENT/TEST	57-50-01		501	LOM ALL
Inboard Fixed Trailing Edge Upper Panel Adjustment TASK 57-50-01-820-801			501	LOM ALL
FIXED TRAILING EDGE LOWER PANEL	57-50-02		401	LOM ALL
Inboard Fixed Trailing Edge Lower Panel - Removal TASK 57-50-02-000-801			401	LOM ALL
Inboard Fixed Trailing Edge Lower Panel - Installation TASK 57-50-02-400-801			413	LOM ALL
FIXED TRAILING EDGE LOWER PANEL - ADJUSTMENT/TEST	57-50-02		501	LOM ALL
Inboard Fixed Trailing Edge Lower Panel Adjustment TASK 57-50-02-820-801			501	LOM ALL
SPOILER SUPPORT FITTINGS - REPAIRS	57-71-01		801	LOM ALL
Spoiler Support Fitting Repair TASK 57-71-01-000-801			801	LOM ALL

ECCN 9E991 BOEING PROPRIETARY - See title page for details

WING SKINS - CORROSION PREVENTION

1. General

A. The exterior surfaces of the upper and lower inspar skins of the wing are susceptible to corrosion at fastener locations. The small gap between the countersunk skin and the head of the flush fastener leaves an unsupported area for the paint system. This area may lead to cracking of the paint system around the fastener head and opening for moisture and contaminants to enter.

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
A50193	Sealant - Pressure And Environmental-Chromate (For Spray Application As A Primer)	BMS5-95 Type I Class F
C00175	Primer - Urethane Compatible, Corrosion Resistant	BMS10-79 Type III
C50262	Coating - Protective Enamel (BAC 900 Clear Color)	BMS10-60 Type II
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23

D. Location Zones

Zone	Area
500	Left Wing
600	Right Wing

ECCN 9E991 BOEING PROPRIETARY - See title page for details

E. Procedure

SUBTASK 57-00-00-370-001

(1) At first opportunity consistent with the scheduled maintenance activity, apply corrosion prevention treatment to the wing in-spar skin.

(a) Apply the primer, C00175 and the coating, C50262 for the wing in-spar upper skin and apply the sealant, A50193 and coating, C50262 for the wing in-spar lower 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.

(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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

LEFT WING
(RIGHT WING IS OPPOSITE)

1 APPLY BMS 10-79 TYPE III AND BMS 10-60 TYPE II FOR WING IN-SPAR UPPER SKIN.
APPLY BMS 5-95 CLASS F AND BMS 10-60 TYPE II FOR WING IN-SPAR LOWER SKIN.

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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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 57-00-01-200-801

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 #: IV9620GL Supplier: 32212

B. Location Zones

Zone	Area
572	Left Wing - Aileron
672	Right Wing - Aileron

C. Procedure

SUBTASK 57-00-01-010-001

(1) Remove the access panels that are necessary.

SUBTASK 57-00-01-290-001

(2) Put a videoscope, COM-117 into an access hole that is 2 in. (5.1 cm) in diameter.

SUBTASK 57-00-01-290-002

(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 57-00-01-290-003

(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 57-00-01-970-001

(5) Make a record of all the unsatisfactory conditions before you move the videoscope, COM-117 to a different area.

SUBTASK 57-00-01-410-001

(6) Install the access panels.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

WING FATIGUE INSPECTIONS - MAINTENANCE PRACTICES

1. **General**

   A. See Document D626A001 for the Supplemental inspection programs.

TASK 57-05-02-130-801

2. **INTERNAL - SPECIAL DETAILED: UPPER SIDE OF BODY SPLICE**

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
195	Above Wing, Wing-To-Body Fairing - Left
196	Above Wing, Wing-To-Body Fairing - Right

B. Access Panels

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

C. Inspection

SUBTASK 57-05-02-010-010

(1) Open this access panel on the Left side:

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

Open this access panel on the Right side:

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

NOTE: Inspection requires removal of wing-to-body fairing.

SUBTASK 57-05-02-130-001

(2) Do an Ultrasonic inspection of the upper side of the body splice at the double plus chord/stub beam interface at STA 639.

See Doc. D626A001 - DTR, DTR check form 57–10–05–1, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 4, Section 57-10-19.

SUBTASK 57-05-02-410-010

(3) Close this access panel on the Left side:

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

Close this access panel on the Right side:

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

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-250-801

3. INTERNAL - SPECIAL DETAILED: DOUBLE PLUS CHORD AT STRINGER 18A INTERFACE

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
195	Above Wing, Wing-To-Body Fairing - Left
196	Above Wing, Wing-To-Body Fairing - Right

B. Access Panels

Number	Name/Location
195BL	Wing To Body Fairing - Left Side
195BR	Wing To Body Fairing - Right Side
195CL	Wing To Body Fairing - Left Side
195CR	Wing To Body Fairings - Right Side

C. Inspection

SUBTASK 57-05-02-010-091

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

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

Open these access panels on the Right side:

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

NOTE: Inspection requires removal of wing-to-body fairing.

SUBTASK 57-05-02-250-001

(2) Do a High Frequency Eddy Current inspection of the double plus chord at stringer 18-A interface located at aft end of upper vertical flange radius at vertical flange/horizontal flange.

See Doc. D626A001 - DTR, DTR check form 57–10–05–2, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 57-10-84.

SUBTASK 57-05-02-410-091

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

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

Close these access panels on the Right side:

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

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-130-802

4. INTERNAL - SPECIAL DETAILED: THE DOUBLE PLUS CHORD VERTICAL FLANGE AT THE BODY STRINGER 18A INTERFACE

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
195	Above Wing, Wing-To-Body Fairing - Left
196	Above Wing, Wing-To-Body Fairing - Right

B. Access Panels

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

C. Inspection

SUBTASK 57-05-02-010-011

(1) Open this access panel on the Left side:

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

Open this access panel on the Right side:

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

NOTE: Inspection requires removal of wing-to-body fairing.

SUBTASK 57-05-02-130-002

(2) Do an Ultrasonic inspection of the double plus chord vertical flange at body stringer 18A interface, located between STA 639 and STA 663, on top of wing, aft of over-wing exits.

See Doc. D626A001 - DTR, DTR check form 57–10–05–3a, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 4, Section 57-10-19.

SUBTASK 57-05-02-410-011

(3) Close this access panel on the Left side:

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

Close this access panel on the Right side:

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

END OF TASK

TASK 57-05-02-130-804

5. INTERNAL - SPECIAL DETAILED: WING CENTER SECTION UPPER SKIN AT FLOOR BEAMS AND SHEAR TIES

NOTE: This procedure is a scheduled maintenance task.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

A. 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

B. Inspection

NOTE: Floor panel removal is required.

SUBTASK 57-05-02-130-004

(1) Do an Ultrasonic inspection of the wing center section upper skin at floor beams and shear ties located at BL 0, BL 25, BL 45, from front spar to rear spar.

See Doc. D626A001 - DTR, DTR check form 57–10–06, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 4, Subject 57-10-12.

END OF TASK

TASK 57-05-02-211-802

6. INTERNAL - DETAILED: WING CENTER SECTION LOWER PANEL TYPICAL STRINGERS

NOTE: This procedure is a scheduled maintenance task.

A. 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

B. Access Panels

Number	Name/Location
131AB	Center Tank Access

C. Inspection

SUBTASK 57-05-02-010-053

(1) Open this access panel:

Number	Name/Location
131AB	Center Tank Access

SUBTASK 57-05-02-211-002

(2) Do a Detailed inspection of the wing center section lower panel stringers at stringer No.1 through No. 4 and stringer No. 6 through No. 8 from LBL 67.0 to RBL 67.0.

See Doc. D626A001 - DTR, DTR check form 57–10–07–1, for alternative inspection.

SUBTASK 57-05-02-410-053

(3) Close this access panel:

Number	Name/Location
131AB	Center Tank Access

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-211-803

7. INTERNAL - DETAILED: WING CENTER SECTION LOWER PANEL SKIN

Figure 201

NOTE: This procedure is a scheduled maintenance task.

A. 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

B. Access Panels

Number	Name/Location
131AB	Center Tank Access

C. Inspection

SUBTASK 57-05-02-010-054

(1) Open this access panel:

Number	Name/Location
131AB	Center Tank Access

SUBTASK 57-05-02-211-003

(2) Do a Detailed inspection of the wing center section, lower panel skin cracks from the front spar to rear spar and side of body to side of body, except drag angle attachment locations.

See Doc. D626A001 - DTR, DTR check form 57–10–07/08, for alternative inspection.

SUBTASK 57-05-02-410-054

(3) Close this access panel:

Number	Name/Location
131AB	Center Tank Access

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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Wing Center Section Lower Panel Skin
Figure 201/57-05-02-990-845

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-211-804

8. INTERNAL - DETAILED: WING CENTER SECTION LOWER PANEL

Figure 202

NOTE: This procedure is a scheduled maintenance task.

A. 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

B. Access Panels

Number	Name/Location
131AB	Center Tank Access

C. Inspection

SUBTASK 57-05-02-010-055

(1) Open this access panel:

Number	Name/Location
131AB	Center Tank Access

NOTE: Remove any cap or brush sealant that extends beyond .20” around fastener heads and collars. Remove any additional sealant which impairs visibility of the stringer. Fillet seals that touch only the stringer edges do not need to be removed.

SUBTASK 57-05-02-211-004

(2) Do a Detailed inspection of the wing center section lower splice stringer No. 5 and No. 9 from LBL 67.0 to RBL 67.0.

See Doc. D626A001 - DTR, DTR check form 57–10–08, for alternative inspection.

SUBTASK 57-05-02-410-055

(3) Close this access panel:

Number	Name/Location
131AB	Center Tank Access

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

FWD

SPLICE STRINGER
(EXAMPLE)

A-A

WING CENTER SECTION LOWER PANEL
(VIEW IN THE AFT DIRECTION)

A

3038281 S0000807000_V1

Wing Center Section Lower Panel
Figure 202/57-05-02-990-810

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-210-801

9. INTERNAL - GENERAL VISUAL: WING CENTER SECTION LOWER PANEL

Figure 203

NOTE: This procedure is a scheduled maintenance task.

A. 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

B. Access Panels

Number	Name/Location
131AB	Center Tank Access

C. Inspection

SUBTASK 57-05-02-010-040

(1) Open this access panel:

Number	Name/Location
131AB	Center Tank Access

NOTE: Remove any cap or brush sealant that extends beyond 0.20 inches around fastener heads or collars. Remove any additional sealant which impairs visibility of the chord. Fillet seals that touch only chord edge do not need to be removed.

SUBTASK 57-05-02-210-001

(2) Do a General Visual inspection of the wing center section lower panel at the rear spar chord from LBL 67.0 to RBL 67.0.

See Doc. D626A001 - DTR, DTR check form 57–10–09, for alternative inspection.

SUBTASK 57-05-02-410-040

(3) Close this access panel:

Number	Name/Location
131AB	Center Tank Access

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Wing Center Section Lower Panel
Figure 203/57-05-02-990-822

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-250-802

10. INTERNAL- SPECIAL DETAILED: SIDE OF BODY SPLICE, LOWER SURFACE

NOTE: This procedure is a scheduled maintenance task.

A. 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
531	Left Wing - Center Fuel Tank, Rib 1 to Rib 5
631	Right Wing - Center Fuel Tank, Rib 1 to Rib 5

B. 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
192HL	Underwing Bolt Cover - Aft
192HR	Underwing Bolt Cover - Aft

C. Inspection

SUBTASK 57-05-02-010-093

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

Number	Name/Location
192AL	Underwing Bolt Cover - Forward
192BL	ECS Ram Air Inlet Mixing Duct Panel - Forward
192HL	Underwing Bolt Cover - Aft

Open these access panels on the Right side:

Number	Name/Location
192AR	Underwing Bolt Cover - Forward
192BR	ECS Ram Air Inlet Mixing Duct Panel - Forward
192HR	Underwing Bolt Cover - Aft

NOTE: Inspection requires removal of Wing-to-Body fairing.

SUBTASK 57-05-02-250-002

(2) Do a Low Frequency Eddy Current inspection of the side of body splice lower surface at the lower tee chord from the front spar to the rear spar at BBL 70.85. Inspection is on both the inboard and outboard locations at BBL 70.85.

See Doc. D626A001 - DTR, DTR check form 57–10–11–1, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-10-62.

SUBTASK 57-05-02-410-093

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

Number	Name/Location
192AL	Underwing Bolt Cover - Forward

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
192BL	ECS Ram Air Inlet Mixing Duct Panel - Forward
192HL	Underwing Bolt Cover - Aft

Close these access panels on the Right side:

Number	Name/Location
192AR	Underwing Bolt Cover - Forward
192BR	ECS Ram Air Inlet Mixing Duct Panel - Forward
192HR	Underwing Bolt Cover - Aft

——— END OF TASK ———

TASK 57-05-02-250-803

11. INTERNAL - SPECIAL DETAILED: SIDE OF BODY SPLICE, LOWER SURFACE

NOTE: This procedure is a scheduled maintenance task.

A. 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
531	Left Wing - Center Fuel Tank, Rib 1 to Rib 5
631	Right Wing - Center Fuel Tank, Rib 1 to Rib 5

B. Access Panels

Number	Name/Location
131AB	Center Tank Access
531AB	Center Tank Access Door - Wing Station 168
631AB	Center Tank Access Door - Wing Station 168

C. Inspection

SUBTASK 57-05-02-010-007

(1) Open these access panels for the Left side:

Number	Name/Location
131AB	Center Tank Access
531AB	Center Tank Access Door - Wing Station 168

Open these access panels on the Right side:

Number	Name/Location
131AB	Center Tank Access
631AB	Center Tank Access Door - Wing Station 168

SUBTASK 57-05-02-250-003

(2) Do a High Frequency Eddy Current inspection of the left hand side of body splice lower surface at the lower tee chord from the front spar to the rear spar at BBL 70.85.

See Doc. D626A001 - DTR, DTR check form 57-10-11–1, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-10-35.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 57-05-02-250-132

(3) Repeat Step 2 for right hand side.

SUBTASK 57-05-02-410-007

(4) Close these access panels for the Left side:

Number	Name/Location
131AB	Center Tank Access
531AB	Center Tank Access Door - Wing Station 168

Close these access panels on the Right side:

Number	Name/Location
131AB	Center Tank Access
631AB	Center Tank Access Door - Wing Station 168

——— END OF TASK ———

TASK 57-05-02-130-805

12. INTERNAL - SPECIAL DETAILED: WING CENTER SECTION LOWER PANEL

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
06-41-00-010-801	Open Access Panel 192CR (P/B 201)
06-41-00-410-801	Close Access Panel 192CR (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
139	Keel Beam, (Part) Body Station 540.00 to Body Station 727.00
192	Lower Wing-To-Body Fairing - Under Wing Box

C. Access Panels

Number	Name/Location
192CL	ECS Access Door
192CR	ECS Access Door

D. Inspection

SUBTASK 57-05-02-010-014

(1) To open access panel 192CR, refer to: Open Access Panel 192CR, TASK 06-41-00-010-801

Open this access panel on the Left side:

Number	Name/Location
192CL	ECS Access Door

Open this access panel on the Right side:

Number	Name/Location
192CR	ECS Access Door

SUBTASK 57-05-02-130-005

(2) Do an Ultrasonic inspection of the lower panel at attachment to the keel beam from rear spar to the front spar.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

See Doc. D626A001 - DTR, DTR check form 57-10-12, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 4, Subject 57-10-13.

SUBTASK 57-05-02-410-014

(3) To close access panel 192CR, refer to: Close Access Panel 192CR, TASK 06-41-00-410-801

Close this access panel on the Left side:

Number	Name/Location
192CL	ECS Access Door

Close this access panel on the Right side:

Number	Name/Location
192CR	ECS Access Door

——— END OF TASK ———

TASK 57-05-02-250-806

13. INTERNAL - SPECIAL DETAILED: WING CENTER SECTION LOWER PANEL

NOTE: This procedure is a scheduled maintenance task.

A. 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

B. Access Panels

Number	Name/Location
131AB	Center Tank Access

C. Inspection

SUBTASK 57-05-02-010-006

(1) Open this access panel:

Number	Name/Location
131AB	Center Tank Access

SUBTASK 57-05-02-250-006

(2) Do a High Frequency Eddy Current inspection of the lower panel skin at the drain installation between stringer S-7 and stringer S-8 at LBBL 3.5.

See Doc. D626A001 - DTR, DTR check form 57-10-13, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-10-75.

SUBTASK 57-05-02-410-006

(3) Close this access panel:

Number	Name/Location
131AB	Center Tank Access

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-130-806

14. INTERNAL - SPECIAL DETAILED: WING CENTER SECTION LOWER PANEL

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
06-41-00-010-801	Open Access Panel 192CR (P/B 201)
06-41-00-410-801	Close Access Panel 192CR (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
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
192JL	Air Conditioning Panel - Aft
192JR	Air Conditioning Panel - Aft

D. Inspection

SUBTASK 57-05-02-010-015

(1) To open access panel 192CR, refer to: Open Access Panel 192CR, TASK 06-41-00-010-801

Open these access panels on the Left side:

Number	Name/Location
192BL	ECS Ram Air Inlet Mixing Duct Panel - Forward
192CL	ECS Access Door
192JL	Air Conditioning Panel - Aft

Open these access panels on the Right side:

Number	Name/Location
192BR	ECS Ram Air Inlet Mixing Duct Panel - Forward
192CR	ECS Access Door
192JR	Air Conditioning Panel - Aft

SUBTASK 57-05-02-130-006

(2) Do an Ultrasonic inspection of the lower skin at the lower beam attachment from the front spar to the rear spar.

See Doc. D626A001 - DTR, DTR check form 57-10-15, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 4, Subject 57-10-13.

SUBTASK 57-05-02-410-015

(3) To close access panel 192CR; refer to: Close Access Panel 192CR, TASK 06-41-00-410-801

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Close these access panels on the Left side:

Number	Name/Location
192BL	ECS Ram Air Inlet Mixing Duct Panel - Forward
192CL	ECS Access Door
192JL	Air Conditioning Panel - Aft

Close these access panels on the Right side:

Number	Name/Location
192BR	ECS Ram Air Inlet Mixing Duct Panel - Forward
192CR	ECS Access Door
192JR	Air Conditioning Panel - Aft

END OF TASK

TASK 57-05-02-250-807

15. INTERNAL - SPECIAL DETAILED: WING CENTER SECTION REAR SPAR TYPICAL WEB (CRACK INITIALLY HIDDEN)

NOTE: This procedure is a scheduled maintenance task.

A. 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

B. Access Panels

Number	Name/Location
131AB	Center Tank Access

C. Inspection

SUBTASK 57-05-02-010-095

(1) Open this access panel:

Number	Name/Location
131AB	Center Tank Access

SUBTASK 57-05-02-250-007

(2) Do a Low Frequency Eddy Current inspection of the web common to the fuel tank from LBBL 70.85 to RBBL 70.85.

See Doc. D626A001 - DTR, DTR check form 57–10–17–1, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-10-81.

SUBTASK 57-05-02-410-095

(3) Close this access panel:

Number	Name/Location
131AB	Center Tank Access

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-211-805

16. INTERNAL - DETAILED: WING CENTER SECTION REAR SPAR TYPICAL WEB (CRACK INITIALLY HIDDEN)

Figure 204

NOTE: This procedure is a scheduled maintenance task.

A. 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

B. Inspection

SUBTASK 57-05-02-211-005

(1) Do a Detailed inspection of the web common to the fuel tank from LBBL 70.85 to RBBL 70.85. See Doc. D626A001 - DTR, DTR check form 57–10–17–1, for alternative inspection.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

WING CENTER SECTION LBBL 70.85 TO RBBL 70.85
WEB COMMON TO FUEL TANK
(CRACK INITIALLY HIDDEN)

A

FORWARD SIDE OF THE LOWER CHORD OF THE REAR SPAR TYPICAL WEB, LBL 70.00-50.00 ILLUSTRATED. SIMILAR WEB ON REMAINDER OF SPAR

REAR SPAR, TYPICAL WEB

B

REAR SPAR TYPICAL WEB

A-A

3039355 S0000807630_V1

Wing Center Section Rear Spar Typical Web (Crack Initially Hidden)
Figure 204/57-05-02-990-852

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-211-806

17. INTERNAL - DETAILED: WING CENTER SECTION REAR SPAR TYPICAL WEB (NON-HIDDEN LOCATIONS)

Figure 205

NOTE: This procedure is a scheduled maintenance task.

A. 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

B. Inspection

SUBTASK 57-05-02-211-006

(1) Do a Detailed inspection of the web common to the fuel tank from LBBL 70.85 to RBBL 70.85. See Doc. D626A001 - DTR, DTR check form 57–10–17–2, for alternative inspection.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Wing Center Section Rear Spar Typical Web (non-hidden locations)
Figure 205/57-05-02-990-846

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-250-808

18. INTERNAL - SPECIAL DETAILED: WING CENTER SECTION REAR SPAR KEEL BEAM STIFFENERS

NOTE: This procedure is a scheduled maintenance task.

A. 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
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

B. Inspection

SUBTASK 57-05-02-250-008

(1) Do a High Frequency Eddy Current inspection of the rear spar keel beam stiffeners at LBL 6.2 and RBL 6.2.

See Doc. D626A001 - DTR, DTR check form 57–10–18, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 57-10-74.

END OF TASK

TASK 57-05-02-250-809

19. INTERNAL - SPECIAL DETAILED: SIDE OF BODY SPLICE UPPER AND LOWER REAR SPAR

NOTE: This procedure is a scheduled maintenance task.

A. 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
531	Left Wing - Center Fuel Tank, Rib 1 to Rib 5
631	Right Wing - Center Fuel Tank, Rib 1 to Rib 5

B. Access Panels

Number	Name/Location
192HL	Underwing Bolt Cover - Aft
192HR	Underwing Bolt Cover - Aft
195BL	Wing To Body Fairing - Left Side
195BR	Wing To Body Fairing - Right Side
S1303	Upper Side Wing Center Section Inspection

C. Inspection

SUBTASK 57-05-02-010-097

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

Number	Name/Location
192HL	Underwing Bolt Cover - Aft
195BL	Wing To Body Fairing - Left Side
S1303	Upper Side Wing Center Section Inspection

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Open these access panels on the Right side:

Number	Name/Location
192HR	Underwing Bolt Cover - Aft
195BR	Wing To Body Fairing - Right Side
S1303	Upper Side Wing Center Section Inspection

NOTE: Inspection requires removal of external panels.

SUBTASK 57-05-02-250-119

(2) Do an Ultrasonic inspection around the four AFT fasteners along the rear spar that attach the splice plate to the wing lower skin and center section lower skin at BBL 70.85 as well as the upper rear spar through the double plus chord horizontal flange on both sides of the joint.

See Doc. D626A001 - DTR, DTR check form 57–10–20, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 4, Subject 57-10-17.

SUBTASK 57-05-02-410-097

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

Number	Name/Location
192HL	Underwing Bolt Cover - Aft
195BL	Wing To Body Fairing - Left Side
S1303	Upper Side Wing Center Section Inspection

Close these access panels on the Right side:

Number	Name/Location
192HR	Underwing Bolt Cover - Aft
195BR	Wing To Body Fairing - Right Side
S1303	Upper Side Wing Center Section Inspection

——— END OF TASK ———

TASK 57-05-02-250-811

20. INTERNAL - SPECIAL DETAILED: SIDE OF BODY SPLICE UPPER AND LOWER FRONT SPAR

NOTE: This procedure is a scheduled maintenance task.

A. 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
531	Left Wing - Center Fuel Tank, Rib 1 to Rib 5
631	Right Wing - Center Fuel Tank, Rib 1 to Rib 5

B. Access Panels

Number	Name/Location
192AL	Underwing Bolt Cover - Forward
192AR	Underwing Bolt Cover - Forward
195BL	Wing To Body Fairing - Left Side
195BR	Wing To Body Fairing - Right Side
S1303	Upper Side Wing Center Section Inspection

ECCN 9E991 BOEING PROPRIETARY - See title page for details

C. Inspection

NOTE: Inspection requires removal of the external fairings.

SUBTASK 57-05-02-010-244

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

Number	Name/Location
192AL	Underwing Bolt Cover - Forward
195BL	Wing To Body Fairing - Left Side
S1303	Upper Side Wing Center Section Inspection

Open these access panels on the Right side:

Number	Name/Location
192AR	Underwing Bolt Cover - Forward
195BR	Wing To Body Fairing - Right Side
S1303	Upper Side Wing Center Section Inspection

SUBTASK 57-05-02-250-011

(2) Do an Ultrasonic inspection around the four FWD fasteners along the front spar that attach the splice plate to the wing lower skin and center section lower skin at BBL 70.85 as well as the upper front spar through the double plus chord horizontal flange on both sides of the joint.

See Doc. D626A001 - DTR, DTR check form 57–10–21, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 4, Subject 57-10-17.

SUBTASK 57-05-02-410-243

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

Number	Name/Location
192AL	Underwing Bolt Cover - Forward
195BL	Wing To Body Fairing - Left Side
S1303	Upper Side Wing Center Section Inspection

Close these access panels on the Right side:

Number	Name/Location
192AR	Underwing Bolt Cover - Forward
195BR	Wing To Body Fairing - Right Side
S1303	Upper Side Wing Center Section Inspection

——— END OF TASK ———

TASK 57-05-02-250-813

21. INTERNAL - SPECIAL DETAILED: WING CENTER SECTION FLOOR BEAM UPPER CHORD

NOTE: This procedure is a scheduled maintenance task.

A. 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
137	Area Above M.L.G. Wheel Well, Body Station 663.75 to Body Station 727 - Left
138	Area Above M.L.G. Wheel Well, Body Station 663.75 Body Station 727 - Right

ECCN 9E991 BOEING PROPRIETARY - See title page for details

B. Inspection

NOTE: Remove passenger cabin floor panels as required.

SUBTASK 57-05-02-250-013

(1) Do a High Frequency Eddy Current inspection of the BL 0 and BL 25 floor beams from BS 655 to BS 675, and BL 0 floor beam from BS 716 to BS 727B, and BL 45 floor beam from BS 685 to BS 716.

See Doc. D626A001 - DTR, DTR check form 57–10–23–1, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 57-10-83.

——— END OF TASK ———

TASK 57-05-02-211-807

22. INTERNAL - DETAILED: WING CENTER SECTION FLOOR BEAM - UPPER CHORD

Figure 206

NOTE: This procedure is a scheduled maintenance task.

A. 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
137	Area Above M.L.G. Wheel Well, Body Station 663.75 to Body Station 727 - Left
138	Area Above M.L.G. Wheel Well, Body Station 663.75 Body Station 727 - Right

B. Inspection

NOTE: Remove passenger cabin floor panels as required.

SUBTASK 57-05-02-211-007

(1) Do a Detailed inspection of the BL 0, 25, and 45 floor beams from STA 569 to STA 655 and the BL 25 floor beams from STA 685 to STA 727A.

See Doc. D626A001 - DTR, DTR check form 57–10–23–2, for alternative inspection.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

3042075 S0000808130_V1

Wing Center Section Floor Beam - Upper Chord
Figure 206/57-05-02-990-853 (Sheet 1 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

3042076 S0000814302_V1

Wing Center Section Floor Beam - Upper Chord
Figure 206/57-05-02-990-853 (Sheet 2 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

UPPER CHORDS
(UPPER CHORD BL 0 SHOWN, RBL/LBL 45 ARE SIMILAR)

C

WING CENTER SECTION FLOOR BEAM-UPPER CHORDS

A-A

3048034 S0000814303_V1

Wing Center Section Floor Beam - Upper Chord
Figure 206/57-05-02-990-853 (Sheet 3 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-250-814

23. INTERNAL - SPECIAL DETAILED: WING CENTER SECTION FLOOR BEAM LOWER CHORD OVER PRESSURE DECK

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
137	Area Above M.L.G. Wheel Well, Body Station 663.75 to Body Station 727 - Left
138	Area Above M.L.G. Wheel Well, Body Station 663.75 Body Station 727 - Right

B. Inspection

NOTE: Remove passenger cabin floor panels as required.

SUBTASK 57-05-02-250-014

(1) Do a High Frequency Eddy Current inspection of the lower chord along the radius at BL 0, 25, and 45 floor beams from STA 664 to STA 727B.

See Doc. D626A001 - DTR, DTR check form 57–10–23–3, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 57-10-83.

——— END OF TASK ———

TASK 57-05-02-250-815

24. INTERNAL - SPECIAL DETAILED: WING CENTER SECTION FLOOR BEAMS LOWER CHORD - OVERWING

NOTE: This procedure is a scheduled maintenance task.

A. 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

B. Inspection

NOTE: Remove passenger cabin floor panels as required. Sealant present in chord radius must be removed for full inspection credit.

SUBTASK 57-05-02-250-015

(1) Do a High Frequency Eddy Current inspection of the lower chord along the radius at the BL 0, 25, 45 floor beams between STA 574 through STA 664.

See Doc. D626A001 - DTR, DTR check form 57–10–23–4, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 57-10-83.

——— END OF TASK ———

TASK 57-05-02-211-808

25. INTERNAL - DETAILED: WING CENTER SECTION FLOOR BEAMS LOWER CHORD - OVERWING

Figure 207

NOTE: This procedure is a scheduled maintenance task.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

A. 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

B. Inspection

NOTE: Remove passenger cabin floor panels as required. Remove any sealant beyond specifications for full inspection credit.

SUBTASK 57-05-02-211-008

(1) Do a Detailed inspection of the lower chord along the BL 0, 25, and 45 floor beams between STA 540 through STA 574.

See Doc. D626A001 - DTR, DTR check form 57–10–23–5, for alternative inspection.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

NOTE:

LOWER CHORD LBL 45 ILLUSTRATED, ALL OTHER CHORDS ARE THE SAME.

3039398 S0000807624_V1

Wing Center Section Floor Beams, Lower Chord - Overwing
Figure 207/57-05-02-990-823

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-211-809

26. INTERNAL - DETAILED: SIDE OF BODY RIB (DIRECTION 1)

Figure 208

NOTE: This procedure is a scheduled maintenance task.

A. 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
531	Left Wing - Center Fuel Tank, Rib 1 to Rib 5
631	Right Wing - Center Fuel Tank, Rib 1 to Rib 5

B. Inspection

SUBTASK 57-05-02-211-009

(1) Do a Detailed inspection of the typical web to stiffener attach points on the side of body rib. See Doc. D626A001 - DTR, DTR check form 57–10–25, for alternative inspection.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(LEFT SIDE IS SHOWN, RIGHT SIDE IS OPPOSITE)

WEB TO STIFFENER ATTACH POINT (EXAMPLE)

A-A

3040032 S0000808279_V2

Left Side of Body Rib - Direction 1
Figure 208/57-05-02-990-849

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-211-810

27. INTERNAL - DETAILED: SIDE OF BODY RIB (DIRECTION 2)

Figure 209

NOTE: This procedure is a scheduled maintenance task.

A. 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
531	Left Wing - Center Fuel Tank, Rib 1 to Rib 5
631	Right Wing - Center Fuel Tank, Rib 1 to Rib 5

B. Inspection

SUBTASK 57-05-02-211-010

(1) Do a Detailed inspection of the typical web to stiffener attach points on the side of body rib. See Doc. D626A001 - DTR, DTR check form 57–10–25, for alternative inspection.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(LEFT SIDE IS SHOWN, RIGHT SIDE IS OPPOSITE)

WEB TO STIFFENER ATTACH POINT (EXAMPLE)

A-A

3040021 S0000808278_V2

Left Side of Body Rib - Direction 2
Figure 209/57-05-02-990-848

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-210-802

28. INTERNAL - GENERAL VISUAL: LOWER WING PANEL, TYPICAL STRINGERS

Figure 210

NOTE: This procedure is a scheduled maintenance task.

A. 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
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

B. Access Panels

Number	Name/Location
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
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

C. Inspection

SUBTASK 57-05-02-010-041

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

Number	Name/Location
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

Open these access panels on the Right side:

Number	Name/Location
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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 57-05-02-210-002

(2) Do a General Visual inspection of the stringers S-2 through S-4, and S-10 through S-13 from rib 1 to rib 10 at the non-hidden, fairing areas.

See Doc. D626A001 - DTR, DTR check form 57–20–01–1, for alternative inspection.

SUBTASK 57-05-02-410-041

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

Number	Name/Location
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

Close these access panels on the Right side:

Number	Name/Location
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

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

3042720 S0000809711_V1

Lower Wing Panel (Typical Stringers)
Figure 210/57-05-02-990-850

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-210-804

29. INTERNAL - GENERAL VISUAL: LOWER WING PANEL, TYPICAL STRINGERS

Figure 211

NOTE: This procedure is a scheduled maintenance task.

A. 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
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

B. Inspection

SUBTASK 57-05-02-210-004

(1) Do a General Visual inspection of the stringers S-1 through S-4 and S-10 through S-14 from rib 1 to rib 15 adjacent to spar chords at the non hidden areas.

See Doc. D626A001 - DTR, DTR check form 57–20–01–2, for alternative inspection.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

3042705 S0000809717_V1

Lower Wing Panel (Typical Stringers)
Figure 211/57-05-02-990-801

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-250-817

30. INTERNAL - SPECIAL DETAILED: LOWER WING PANEL, TYPICAL STRINGERS

NOTE: This procedure is a scheduled maintenance task.

A. 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
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

B. Inspection

SUBTASK 57-05-02-250-017

(1) Do a low frequency eddy current inspection of the stringers S-2 through S-4, S-10 and S-11 at ribs 5 & 8 at the locations hidden by seal pans & sealant.

See Doc. D626A001 - DTR, DTR check form 57–20–01–3, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-10-79.

END OF TASK

TASK 57-05-02-130-807

31. INTERNAL - SPECIAL DETAILED: LOWER WING PANEL SKIN; UNDER THE FLAP TRACK FAIRINGS AND NACELLE FAIRINGS

NOTE: This procedure is a scheduled maintenance task.

A. 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
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

B. Inspection

SUBTASK 57-05-02-130-007

(1) Do an Ultrasonic inspection of the skin panel at the rub strips from rib 5 to rib 8, rib 9 to rib 11 and rib 13 to rib 15.

See Doc. D626A001 - DTR, DTR check form 57-20-01/02/03/04/05/08-1, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 4, Subject 57-10-15.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-210-806

32. EXTERNAL - GENERAL VISUAL: LOWER WING PANEL SKIN

Figure 212

NOTE: This procedure is a scheduled maintenance task.

A. 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
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

B. Inspection

SUBTASK 57-05-02-210-006

(1) Do a General Visual inspection of rib 1 to rib 14 at the externally visible areas from the front spar to the rear spar.

See Doc. D626A001 - DTR, DTR check form 57-20-01/02/03/04/05/08-2, for alternative inspection.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

3042379 S0000809724_V1

Lower Wing Panel Skin
Figure 212/57-05-02-990-802

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-211-813

33. EXTERNAL - DETAILED: LOWER WING PANEL SKIN

Figure 213

NOTE: This procedure is a scheduled maintenance task.

A. 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
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

B. Inspection

NOTE: Fairing removal is required.

SUBTASK 57-05-02-211-013

(1) Do a Detailed inspection of rib 1 to rib 27 at the skin not covered by rub strips or fittings.

See Doc. D626A001 - DTR, DTR check form 57-20-01/02/03/04/05/08-3, for alternative inspection.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

3042281 S0000809725_V1

Lower Wing Panel Skin
Figure 213/57-05-02-990-803

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-210-808

34. EXTERNAL - GENERAL VISUAL: LOWER WING PANEL SKIN

Figure 214

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
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
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

B. Inspection

SUBTASK 57-05-02-210-008

(1) Do a General Visual inspection of rib 14 to rib 27 at the externally visible areas from the front spar to the rear spar.

See Doc. D626A001 - DTR, DTR check form 57-20-01/02/03/04/05/08-4, for alternative inspection.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

3041645 S0000809280_V1

Lower Wing Panel Skin
Figure 214/57-05-02-990-804

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-211-815

35. INTERNAL - DETAILED: LOWER WING PANEL, RAIL STRINGERS

Figure 215

NOTE: This procedure is a scheduled maintenance task.

A. 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
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

B. Inspection

SUBTASK 57-05-02-211-015

(1) Do a Detailed inspection of stringer S-6 and S-8 from rib 1 to rib 19 at the non hidden, faired and non- faired areas.

See Doc. D626A001 - DTR, DTR check form 57–20–02–1, for alternative inspection

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(THE LEFT WING IS SHOWN, THE RIGHT WING IS OPPOSITE)

A

STRINGER 6 AND 8
(RIB 1 TO 19)

A-A

3041185 S0000808823_V1

Lower Wing Panel, Rail Stringers
Figure 215/57-05-02-990-805

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-130-809

36. INTERNAL - SPECIAL DETAILED: LOWER WING PANEL, RAIL STRINGERS

NOTE: This procedure is a scheduled maintenance task.

A. 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
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

B. Access Panels

Number	Name/Location
531AB	Center Tank Access Door - Wing Station 168
532AB	Main Tank Access Door - Wing Station 216
532BB	Main Tank Access Door - Wing Station 265
532CB	Main Tank Access Door - Wing Station 290
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

C. Inspection

SUBTASK 57-05-02-010-016

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

Number	Name/Location
531AB	Center Tank Access Door - Wing Station 168
532AB	Main Tank Access Door - Wing Station 216
532BB	Main Tank Access Door - Wing Station 265
532CB	Main Tank Access Door - Wing Station 290

Open these access panels on the Right side:

Number	Name/Location
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

SUBTASK 57-05-02-130-009

(2) Do an Ultrasonic inspection of the vertical flange and horizontal attachment flange on stringer S-6 and S-8, ribs 5 and 8, where stringers are hidden under seal pan and sealant.

See Doc. D626A001 - DTR, DTR check form 57–20–02–2, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 4, Subject 57-10-07.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 57-05-02-410-016

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

Number	Name/Location
531AB	Center Tank Access Door - Wing Station 168
532AB	Main Tank Access Door - Wing Station 216
532BB	Main Tank Access Door - Wing Station 265
532CB	Main Tank Access Door - Wing Station 290

Close these access panels on the Right side:

Number	Name/Location
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

——— END OF TASK ———

TASK 57-05-02-210-810

37. INTERNAL - GENERAL VISUAL: LOWER WING PANEL, RAIL STRINGERS

Figure 216

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
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
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

B. Access Panels

Number	Name/Location
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
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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

C. Inspection

SUBTASK 57-05-02-010-043

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

Number	Name/Location
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

SUBTASK 57-05-02-010-234

(2) Open these access panels on the Right side:

Number	Name/Location
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

SUBTASK 57-05-02-210-010

(3) Do a General Visual inspection of the lower wing panel rail stringers, S-6 and S-8, from rib 19 to rib 25 at the non-hidden areas.

(a) See Doc. D626A001 - DTR, DTR check form 57–20–02–4, for alternative inspection.

SUBTASK 57-05-02-410-043

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

Number	Name/Location
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

SUBTASK 57-05-02-410-233

(5) Close these access panels on the Right side:

Number	Name/Location
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

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

3041167 S0000808827_V1

Lower Wing Panel, Rail Stringers, RIB 19 to 25
Figure 216/57-05-02-990-806

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-130-811

38. INTERNAL - SPECIAL DETAILED: LOWER WING PANEL, RAIL STRINGER

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
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
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

B. Access Panels

Number	Name/Location
532AB	Main Tank Access Door - Wing Station 216
532BB	Main Tank Access Door - Wing Station 265
532DB	Main Tank Access Door - Wing Station 313
532EB	Main Tank Access Door - Wing Station 337
532HB	Main Tank Access Door - Wing Station 417
532JB	Main Tank Access Door - Wing Station 443
632AB	Main Tank Access Door - Wing Station 216
632BB	Main Tank Access Door - Wing Station 265
632DB	Main Tank Access Door - Wing Station 313
632EB	Main Tank Access Door - Wing Station 337
632HB	Main Tank Access Door - Wing Station 417
632JB	Main Tank Access Door - Wing Station 443

C. Inspection

SUBTASK 57-05-02-010-141

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

Number	Name/Location
532AB	Main Tank Access Door - Wing Station 216
532BB	Main Tank Access Door - Wing Station 265
532DB	Main Tank Access Door - Wing Station 313
532EB	Main Tank Access Door - Wing Station 337
532HB	Main Tank Access Door - Wing Station 417
532JB	Main Tank Access Door - Wing Station 443

Open these access panels on the Right side:

Number	Name/Location
632AB	Main Tank Access Door - Wing Station 216
632BB	Main Tank Access Door - Wing Station 265
632DB	Main Tank Access Door - Wing Station 313
632EB	Main Tank Access Door - Wing Station 337
632HB	Main Tank Access Door - Wing Station 417
632JB	Main Tank Access Door - Wing Station 443

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 57-05-02-130-011

(2) Do an Ultrasonic inspection of lower wing panel rail stringers, S-6 and S-8, at the areas hidden by the flange of rib 22, shims and sealant.

See Doc. D626A001 - DTR, DTR check form 57-20-02-5, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 4, Subject 57-10-07.

SUBTASK 57-05-02-410-141

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

Number	Name/Location
532AB	Main Tank Access Door - Wing Station 216
532BB	Main Tank Access Door - Wing Station 265
532DB	Main Tank Access Door - Wing Station 313
532EB	Main Tank Access Door - Wing Station 337
532HB	Main Tank Access Door - Wing Station 417
532JB	Main Tank Access Door - Wing Station 443

Close these access panels on the Right side:

Number	Name/Location
632AB	Main Tank Access Door - Wing Station 216
632BB	Main Tank Access Door - Wing Station 265
632DB	Main Tank Access Door - Wing Station 313
632EB	Main Tank Access Door - Wing Station 337
632HB	Main Tank Access Door - Wing Station 417
632JB	Main Tank Access Door - Wing Station 443

——— END OF TASK ———

TASK 57-05-02-210-812

39. INTERNAL - GENERAL VISUAL: LOWER WING PANEL, SPLICE STRINGERS

Figure 217

NOTE: This procedure is a scheduled maintenance task.

A. 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
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

B. 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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
532DB	Main Tank Access Door - Wing Station 313
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

C. Inspection

SUBTASK 57-05-02-010-215

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

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

Open these access panels on the Right side:

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

NOTE: Remove any cap or brush sealant that extends beyond .20” around fastener heads and collars. Remove any additional sealant which impairs visibility of the stringer. Fillet seals that touch only the stringer edges do not need to be removed.

SUBTASK 57-05-02-210-012

(2) Do a General Visual inspection of the lower wing panel splice stringers, S-5 and S-9, from rib 1 to rib 10 at the non-hidden areas without the fairing.

See Doc. D626A001 - DTR, DTR check form 57–20–03–1, for alternative inspection.

SUBTASK 57-05-02-410-215

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

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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Close these access panels on the Right side:

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

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(THE RIGHT WING IS SHOWN, THE LEFT WING IS OPPOSITE)
(VIEW IN THE UP DIRECTION)

A

TYPICAL SPLICE STRINGER
INSPECTION AREA

A-A

3041101 S0000808821_V1

Lower Wing Panel, Splice Stringers
Figure 217/57-05-02-990-807

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-250-819

40. EXTERNAL - SPECIAL DETAILED: LOWER WING PANEL, SPLICE STRINGERS

NOTE: This procedure is a scheduled maintenance task.

A. 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
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

B. Inspection

SUBTASK 57-05-02-250-019

(1) Do a Low Frequency Eddy Current inspection of the lower wing panel splice stringers, S-5 and S-9, from rib 1 to rib 10 at the non-hidden areas without the fairing.

See Doc. D626A001 - DTR, DTR check form 57–20–03–1 for alternative inspections.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-10-55.

——— END OF TASK ———

TASK 57-05-02-130-813

41. INTERNAL - SPECIAL DETAILED: LOWER WING PANEL, SPLICE STRINGERS

NOTE: This procedure is a scheduled maintenance task.

A. 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
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

B. Access Panels

Number	Name/Location
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
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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

C. Inspection

SUBTASK 57-05-02-010-017

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

Number	Name/Location
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

Open these access panels on the Right side:

Number	Name/Location
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

SUBTASK 57-05-02-130-013

(2) Do an Ultrasonic inspection of the lower wing panel splice stringers, S-5 and S-9, at rib 5 and rib 8 at the areas hidden by seal pans and sealant.

See Doc. D626A001 - DTR, DTR check form 57–20–03–3, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 4, Subject 57-10-07.

SUBTASK 57-05-02-410-017

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

Number	Name/Location
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

Close these access panels on the Right side:

Number	Name/Location
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

——— END OF TASK ———

TASK 57-05-02-250-821

42. EXTERNAL - SPECIAL DETAILED: LOWER WING PANEL, SPLICE STRINGERS

NOTE: This procedure is a scheduled maintenance task.

A. 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
631	Right Wing - Center Fuel Tank, Rib 1 to Rib 5

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

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

B. Inspection

SUBTASK 57-05-02-250-021

(1) Do a Low Frequency Eddy Current inspection of the lower wing panel splice stringers, S-5 and S-9, at rib 5 and rib 8 at the areas hidden by seal pans and sealant.

See Doc. D626A001 - DTR, DTR check form 57–20–03–3, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-10-55.

——— END OF TASK ———

TASK 57-05-02-211-817

43. INTERNAL - DETAILED: WING LOWER PANEL, SPLICE STRINGERS

Figure 218

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

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

B. Access Panels

Number	Name/Location
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
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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

C. Inspection

SUBTASK 57-05-02-010-058

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

Number	Name/Location
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

Open these access panels on the Right side:

Number	Name/Location
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

SUBTASK 57-05-02-211-017

(2) Do a Detailed inspection of the web and free flange of the lower wing panel splice stringers, S-5 and S-9, from rib 10 to rib 19 except at areas externally covered by rub strips.

See Doc. D626A001 - DTR, DTR check form 57–20–03–4, for alternative inspection.

SUBTASK 57-05-02-410-058

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

Number	Name/Location
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

Close these access panels on the Right side:

Number	Name/Location
632EB	Main Tank Access Door - Wing Station 337
632FB	Main Tank Access Door - Wing Station 367
632GB	Main Tank Access Door - Wing Station 390

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
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

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(RIGHT WING IS SHOWN, LEFT WING IS OPPOSITE)
(BOTTOM VIEW)

A

TYPICAL SPLICE STRINGER INSPECTION AREA

A-A

3041290 S0000808848_V1

Wing Lower Panel - Splice Stringers
Figure 218/57-05-02-990-808

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-250-825

44. EXTERNAL - SPECIAL DETAILED: WING LOWER PANEL, SPLICE STRINGERS

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

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

B. Inspection

NOTE: Fairing removal required.

SUBTASK 57-05-02-250-025

(1) Do a Low Frequency Eddy Current inspection of the lower wing panel splice stringers, S-5 and S-9, from rib 10 to rib 19, except at areas externally covered by rub strips.

See Doc. D626A001 - DTR, DTR check form 57–20–03–4, for alternative repeat inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-10-55.

——— END OF TASK ———

TASK 57-05-02-250-827

45. INTERNAL - SPECIAL DETAILED: WING LOWER PANEL, SPLICE STRINGER (DIRECTION 3)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

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

B. Access Panels

Number	Name/Location
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
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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
632LB	Main Tank Access Door - Wing Station 496
632MB	Main Tank Access Door - Wing Station 523
632NB	Main Tank Access Door - Wing Station 549

C. Inspection

SUBTASK 57-05-02-010-221

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

Number	Name/Location
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

Open these access panels on the Right side:

Number	Name/Location
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

NOTE: Remove minimal amount of sealant to facilitate direction 3 HFEC in the lower stringer radius.

SUBTASK 57-05-02-250-027

(2) Do a High Frequency Eddy Current inspection of the wing lower panel splice stringers, S-5 and S-9, from rib 10 to rib 19, at the areas externally covered by rub strips.

See. Doc. D626A001 - DTR, DTR check form 57–20–03–5, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-10-33.

SUBTASK 57-05-02-410-105

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

Number	Name/Location
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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
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

Close these access panels on the Right side:

Number	Name/Location
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

END OF TASK

TASK 57-05-02-250-828

46. INTERNAL - SPECIAL DETAILED: WING LOWER PANEL, SPLICE STRINGERS (DIRECTION 4)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

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

B. Access Panels

Number	Name/Location
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
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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
632LB	Main Tank Access Door - Wing Station 496
632MB	Main Tank Access Door - Wing Station 523
632NB	Main Tank Access Door - Wing Station 549

C. Inspection

SUBTASK 57-05-02-010-107

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

Number	Name/Location
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

Open these access panels on the Right side:

Number	Name/Location
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

NOTE: Remove minimal amount of sealant to facilitate direction 4 HFEC at all fasteners.

SUBTASK 57-05-02-250-028

(2) Do a High Frequency Eddy Current inspection of the wing lower panel splice stringers, S-5 and S-9, from rib 10 to rib 19, at the areas externally covered by rub strips.

See Doc. D626A001 - DTR, DTR check form 57–20–03–5, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-10-33.

SUBTASK 57-05-02-410-107

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

Number	Name/Location
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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
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

Close these access panels on the Right side:

Number	Name/Location
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

——— END OF TASK ———

TASK 57-05-02-250-831

47. INTERNAL - SPECIAL DETAILED: LOWER WING PANEL, SPLICE STRINGERS (DIRECTION 3)

NOTE: This procedure is a scheduled maintenance task.

A. 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
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

B. 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
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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

C. Inspection

SUBTASK 57-05-02-010-109

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

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

Open these access panels on the Right side:

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

NOTE: Remove minimal amount of sealant to facilitate direction 3 HFEC in the lower stringer radius.

SUBTASK 57-05-02-250-031

(2) Do a High Frequency Eddy Current inspection of the lower wing panel splice stringers, S-5 and S-9, from rib 1 to rib 10 at the areas externally covered by fairing and rub strips.

See Doc. D626A001 - DTR, DTR check form 57-20-03-6, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-10-33.

SUBTASK 57-05-02-410-109

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

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

Close these access panels on the Right side:

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

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-250-833

48. EXTERNAL - SPECIAL DETAILED: SPLICE STRINGERS AT CHORDWISE SKIN SPLICES (UPPER AND LOWER PANEL)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

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

B. Inspection

SUBTASK 57-05-02-250-033

(1) Do a Low Frequency Eddy Current inspection of the splice stringers at the chordwise skin splices on the lower stringers, S-9 from rib 17 to rib 18; S-5 from rib 18 to rib 19 and upper stringer, S-14 from rib 19 to rib 20.

See Doc. D626A001 - DTR, DTR check form 57–20–03/15, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-10-60.

——— END OF TASK ———

TASK 57-05-02-211-819

49. INTERNAL - DETAILED: FRONT SPAR LOWER CHORD (SKIN FLANGE INSPECTIONS)

Figure 219

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

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

B. Access Panels

Number	Name/Location
532AB	Main Tank Access Door - Wing Station 216
632AB	Main Tank Access Door - Wing Station 216

C. Inspection

SUBTASK 57-05-02-010-060

(1) Open this access panel on the Left side:

Number	Name/Location
532AB	Main Tank Access Door - Wing Station 216

Open this access panel on the Right side:

Number	Name/Location
632AB	Main Tank Access Door - Wing Station 216

ECCN 9E991 BOEING PROPRIETARY - See title page for details

NOTE: Remove any cap or brush sealant that extends beyond .20” around fastener heads and collars. Remove any additional sealant which impairs visibility of the stringer. Fillet seals that touch only the stringer edges do not need to be removed.

SUBTASK 57-05-02-211-019

(2) Do a Detailed inspection of the front spar lower chord at the non-hidden areas from rib 5 to rib 7.

See Doc. D626A001 - DTR, DTR check form 57–20–04–2, for alternative inspection.

SUBTASK 57-05-02-410-060

(3) Close this access panel on the Left side:

Number	Name/Location
532AB	Main Tank Access Door - Wing Station 216

Close this access panel on the Right side:

Number	Name/Location
632AB	Main Tank Access Door - Wing Station 216

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(RIGHT WING IS SHOWN, LEFT WING IS OPPOSITE)
(BOTTOM VIEW)

A

LOWER CHORD OF THE FRONT SPAR
(TYPICAL)

A-A

3041314 S0000808850_V1

Front Spar - Lower Chord (Skin Flange)
Figure 219/57-05-02-990-824

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-130-815

50. INTERNAL - SPECIAL DETAILED: FRONT SPAR LOWER CHORD (WEB FLANGE INSPECTIONS)

NOTE: This procedure is a scheduled maintenance task.

A. 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
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

B. 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
533AB	Surge Tank Access Door - Wing Station 655
533BB	Surge Tank Access Door - Wing Station 679
533CB	Surge Tank Access Door - Wing Station 703
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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
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
633AB	Surge Tank Access Door - Wing Station 655
633BB	Surge Tank Access Door - Wing Station 679
633CB	Surge Tank Access Door - Wing Station 703

C. Inspection

SUBTASK 57-05-02-010-216

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

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
533AB	Surge Tank Access Door - Wing Station 655
533BB	Surge Tank Access Door - Wing Station 679
533CB	Surge Tank Access Door - Wing Station 703

Open these access panels on the Right side:

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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
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
633AB	Surge Tank Access Door - Wing Station 655
633BB	Surge Tank Access Door - Wing Station 679
633CB	Surge Tank Access Door - Wing Station 703

SUBTASK 57-05-02-130-015

(2) Do an Ultrasonic inspection of the front spar lower chord at the areas hidden by stiffeners, rib posts or fittings from ribs 1 to 19 and ribs 22 to 25.

See Doc. D626A001 - DTR, DTR check form 57–20–04–3, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 4, Subject 57-10-09.

SUBTASK 57-05-02-410-216

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

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
533AB	Surge Tank Access Door - Wing Station 655
533BB	Surge Tank Access Door - Wing Station 679
533CB	Surge Tank Access Door - Wing Station 703

Close these access panels on the Right side:

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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
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
633AB	Surge Tank Access Door - Wing Station 655
633BB	Surge Tank Access Door - Wing Station 679
633CB	Surge Tank Access Door - Wing Station 703

——— END OF TASK ———

TASK 57-05-02-250-835

51. EXTERNAL - SPECIAL DETAILED: FRONT SPAR LOWER CHORD (SKIN FLANGE INSPECTIONS)

NOTE: This procedure is a scheduled maintenance task.

A. 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
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

B. Inspection

SUBTASK 57-05-02-250-035

(1) Do a Low Frequency Eddy Current inspection of front spar lower chord at the non-hidden areas from rib 1 to rib 5, and rib 19 to Rib 22, and the hidden areas from rib 1 to rib 6, and from rib 19 to rib 22.

See Doc. D626A001 - DTR, DTR check form 57–20–04–1, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-10-54. Fastener locations that are externally blocked by rub strips or nacelle fittings are examined internally with an Ultrasonic inspection. The inspection procedures are contained in Part 4, Subject 57-10-09.

——— END OF TASK ———

TASK 57-05-02-211-821

52. INTERNAL - DETAILED: FRONT SPAR LOWER CHORD (WEB FLANGE INSPECTIONS)

Figure 220

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

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

B. 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
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

C. Inspection

SUBTASK 57-05-02-010-217

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

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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
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

Open these access panels on the Right side:

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

NOTE: Remove any cap or brush sealant that extends beyond .20” around fastener heads and collars. Remove any additional sealant which impairs visibility of the stringer. Fillet seals that touch only the stringer edges do not need to be removed.

SUBTASK 57-05-02-211-021

(2) Do a Detailed inspection of the front spar lower chord at the non-hidden areas from rib 1 to rib 19.

See Doc. D626A001 - DTR, DTR check form 57-20-04-5, for alternative inspection.

SUBTASK 57-05-02-410-217

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

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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
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

Close these access panels on the Right side:

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

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

LEFT WING
(LEFT WING IS SHOWN, RIGHT WING IS OPPOSITE)

A

FRONT SPAR-LOWER CHORD
(EXAMPLE)

A-A

3041267 S0000808851_V1

Front Spar - Lower Chord (Web Flange)
Figure 220/57-05-02-990-851

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-250-837

53. EXTERNAL - SPECIAL DETAILED: FRONT SPAR LOWER CHORD (SKIN FLANGE INSPECTIONS)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
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
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

B. Inspection

SUBTASK 57-05-02-250-037

(1) Do a Low Frequency Eddy Current inspection of the front spar lower chord at the non-hidden areas from rib 7 to rib 19, and from rib 22 to rib 25, and the hidden areas from rib 6 to rib 19, and from rib 22 to rib 25.

See Doc. D626A001 - DTR, DTR check form 57–20–04–4, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-10-54. Fastener locations that are externally blocked by rub strips or nacelle fittings are examined internally with an Ultrasonic inspection. The inspection procedures are contained in Part 4, Subject 57-10-09.

——— END OF TASK ———

TASK 57-05-02-130-817

54. INTERNAL - SPECIAL DETAILED: FRONT SPAR LOWER CHORD (WEB FLANGE INSPECTIONS)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

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

B. Access Panels

Number	Name/Location
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
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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

C. Inspection

SUBTASK 57-05-02-010-018

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

Number	Name/Location
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

Open these access panels on the Right side:

Number	Name/Location
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

SUBTASK 57-05-02-130-017

(2) Do an Ultrasonic inspection of the front spar lower chord areas hidden by stiffeners, ribs, posts or fittings from rib 19 to rib 22.

See Doc. D626A001 - DTR, DTR check form 57–20–04–7, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 4, Subject 57-10-09.

SUBTASK 57-05-02-410-018

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

Number	Name/Location
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

Close these access panels on the Right side:

Number	Name/Location
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 ———

TASK 57-05-02-210-814

55. INTERNAL - GENERAL VISUAL: FRONT SPAR LOWER CHORD (WEB FLANGE INSPECTIONS)

Figure 221

NOTE: This procedure is a scheduled maintenance task.

A. 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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

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

B. 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
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

C. Inspection

SUBTASK 57-05-02-010-045

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

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

Open these access panels on the Right side:

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

NOTE: Remove any cap or brush sealant that extends beyond .20” around fastener heads and collars. Remove any additional sealant which impairs visibility of the stringer. Fillet seals that touch only the stringer edges do not need to be removed.

SUBTASK 57-05-02-210-014

(2) Do a General Visual inspection of the front spar lower chord at the non-hidden areas from rib 22 to rib 25.

See Doc. D626A001 - DTR, DTR check form 57–20–04–8, for alternative inspection.

SUBTASK 57-05-02-410-045

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

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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Close these access panels on the Right side:

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

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

OUTER WING FRONT SPAR INSPECTION AREAS
(THE LEFT WING IS SHOWN, THE RIGHT WING IS OPPOSITE)

A

RIB 22 THRU 25 INSPECTION AREAS
(EXAMPLE)

A-A

3040402 S0000808543_V1

Front Spar Lower Chord (Web Flange Inspections)
Figure 221/57-05-02-990-825

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-130-819

56. INTERNAL - INSPECT (ULTRASONIC) ALL FASTENERS, OUTER LOCATION, COMMON TO THE R7/R8 NACELLE FITTING ATTACHMENT (DIRECTION 1)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
54-52-06-010-801	Aft Fairing Access Panel Removal (P/B 401)
54-52-06-410-801	Aft Fairing Access Panel Installation (P/B 401)

B. Location Zones

Zone	Area
532	Left Wing - Main Tank, Rib 5 to Rib 22, Wing Station 204.25 to Wing BL 643.50
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
434AL	Aft Strut Fairing, Left Forward Panel, Strut 1
434AR	Aft Strut Fairing, Right Forward Panel, Strut 1
434BL	Aft Strut Fairing, Left Aft Panel, Strut 1
444AL	Aft Strut Fairing, Left Forward Panel, Strut 2
444AR	Aft Strut Fairing, Right Forward Panel, Strut 2
444BR	Aft Strut Fairing, Right Aft Panel, Strut 2

D. Inspection

SUBTASK 57-05-02-010-220

(1) Remove these aft fairing access panels, refer to Aft Fairing Access Panel Removal, TASK 54-52-06-010-801:

NOTE: Nacelle fairing should be removed for inspection.

(a) Remove these access panels on the Left side:

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

(b) Remove these access panels on the Right side:

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

SUBTASK 57-05-02-130-019

(2) Do a special detailed inspection (Ultrasonic) of all fasteners, outer location, common to the R7/R8 nacelle fitting attachment. (Direction 1)

See Doc. D626A001 - DTR, DTR check form 57–20–04–9, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 4, Subject 57-10-05.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 57-05-02-410-220

(3) Install these aft fairing access panels, refer to Aft Fairing Access Panel Installation, TASK 54-52-06-410-801.

(a) Install these access panels on the Left side:

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

(b) Install these access panels on the Right side:

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

——— END OF TASK ———

TASK 57-05-02-130-820

57. INTERNAL - INSPECT (ULTRASONIC) ALL FASTENERS, INNER LOCATION, COMMON TO THE R7/R8 NACELLE FITTING ATTACHMENT (DIRECTION 3)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

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

B. Access Panels

Number	Name/Location
532AB	Main Tank Access Door - Wing Station 216
532AZ	Main Tank Inner Access at Rib 6
632AB	Main Tank Access Door - Wing Station 216
632AZ	Main Tank Inner Access at Rib 6

C. Inspection

SUBTASK 57-05-02-010-019

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

Number	Name/Location
532AB	Main Tank Access Door - Wing Station 216
532AZ	Main Tank Inner Access at Rib 6

Open these access panels on the Right side:

Number	Name/Location
632AB	Main Tank Access Door - Wing Station 216
632AZ	Main Tank Inner Access at Rib 6

NOTE: Nacelle fairing should be removed for inspection.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 57-05-02-130-020

(2) Do an internal special detailed inspection (Ultrasonic) of all fasteners, inner location, common to the R7/R8 nacelle fitting attachment. (Direction 3)

See Doc. D626A001 - DTR, DTR check form 57–20–04–9, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 4, Subject 57-10-05.

SUBTASK 57-05-02-410-019

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

Number	Name/Location
532AB	Main Tank Access Door - Wing Station 216
532AZ	Main Tank Inner Access at Rib 6

Close these access panels on the Right side:

Number	Name/Location
632AB	Main Tank Access Door - Wing Station 216
632AZ	Main Tank Inner Access at Rib 6

——— END OF TASK ———

TASK 57-05-02-250-839

58. EXTERNAL - SPECIAL DETAILED: FRONT SPAR LOWER CHORD (WEB FLANGE INSPECTIONS)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

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

B. Inspection

SUBTASK 57-05-02-250-039

(1) Do a Low Frequency Eddy Current inspection of the front spar lower chord at the non-hidden areas from rib 19 to rib 22.

See Doc. D626A001 - DTR, DTR check form 57-20-04-6, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-10-54.

——— END OF TASK ———

TASK 57-05-02-130-821

59. INTERNAL - SPECIAL DETAILED: SPAR CHORDS AT CHORDWISE SKIN SPLICES (UPPER AND LOWER PANEL)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

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

B. Access Panels

Number	Name/Location
532MB	Main Tank Access Door - Wing Station 523
532NB	Main Tank Access Door - Wing Station 549
532PB	Main Tank Access Door - Wing Station 576
632MB	Main Tank Access Door - Wing Station 523
632NB	Main Tank Access Door - Wing Station 549
632PB	Main Tank Access Door - Wing Station 576

C. Inspection

SUBTASK 57-05-02-010-149

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

Number	Name/Location
532MB	Main Tank Access Door - Wing Station 523
532NB	Main Tank Access Door - Wing Station 549
532PB	Main Tank Access Door - Wing Station 576

Open these access panels on the Right side:

Number	Name/Location
632MB	Main Tank Access Door - Wing Station 523
632NB	Main Tank Access Door - Wing Station 549
632PB	Main Tank Access Door - Wing Station 576

SUBTASK 57-05-02-130-021

(2) Do an Ultrasonic inspection of the front spar lower chord from rib 17 to rib 18, the rear spar lower chord from rib 18 to rib 19, and the front spar upper chord from rib 19 to rib 20.

See Doc. D626A001 - DTR, DTR check form 57-20-04 / 05 / 16, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 4, Subject 57-10-14

SUBTASK 57-05-02-410-149

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

Number	Name/Location
532MB	Main Tank Access Door - Wing Station 523
532NB	Main Tank Access Door - Wing Station 549
532PB	Main Tank Access Door - Wing Station 576

Close these access panels on the Right side:

Number	Name/Location
632MB	Main Tank Access Door - Wing Station 523
632NB	Main Tank Access Door - Wing Station 549
632PB	Main Tank Access Door - Wing Station 576

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-250-841

60. INTERNAL - INSPECT (HIGH FREQUENCY EDDY CURRENT) ALL FASTENERS, OUTER LOCATION, COMMON TO THE R7/R8 NACELLE FITTING ATTACHMENT (DIRECTION 2)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
54-52-06-010-801	Aft Fairing Access Panel Removal (P/B 401)
54-52-06-410-801	Aft Fairing Access Panel Installation (P/B 401)

B. Location Zones

Zone	Area
532	Left Wing - Main Tank, Rib 5 to Rib 22, Wing Station 204.25 to Wing BL 643.50
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
434AL	Aft Strut Fairing, Left Forward Panel, Strut 1
434AR	Aft Strut Fairing, Right Forward Panel, Strut 1
434BL	Aft Strut Fairing, Left Aft Panel, Strut 1
444AL	Aft Strut Fairing, Left Forward Panel, Strut 2
444AR	Aft Strut Fairing, Right Forward Panel, Strut 2
444BR	Aft Strut Fairing, Right Aft Panel, Strut 2

D. Inspection

SUBTASK 57-05-02-010-118

(1) Remove these aft fairing access panels, refer to Aft Fairing Access Panel Removal, TASK 54-52-06-010-801:

NOTE: Nacelle fairing should be removed for inspection.

(a) Remove these access panels on the Left side:

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

(b) Remove these access panels on the Right side:

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

SUBTASK 57-05-02-250-041

(2) Do a special detailed inspection (High Frequency Eddy Current) of all fasteners, outer location, common to the R7/R8 nacelle fitting attachment. (Direction 2)

See Doc. D626A001 - DTR, DTR check form 57–20–04–9, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57–10–51.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 57-05-02-410-118

(3) To install the applicable aft fairing access panels, refer to Aft Fairing Access Panel Installation, TASK 54-52-06-410-801:

(a) Install these access panels on the Left side:

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

(b) Install these access panels on the Right side:

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

——— END OF TASK ———

TASK 57-05-02-250-842

61. INTERNAL - INSPECT (HIGH FREQUENCY EDDY CURRENT) ALL FASTENERS, INNER LOCATION, COMMON TO THE R7/R8 NACELLE FITTING ATTACHMENT (DIRECTION 4)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

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

B. Access Panels

Number	Name/Location
532AB	Main Tank Access Door - Wing Station 216
532AZ	Main Tank Inner Access at Rib 6
632AB	Main Tank Access Door - Wing Station 216
632AZ	Main Tank Inner Access at Rib 6

C. Inspection

SUBTASK 57-05-02-010-120

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

Number	Name/Location
532AB	Main Tank Access Door - Wing Station 216
532AZ	Main Tank Inner Access at Rib 6

Open these access panels on the Right side:

Number	Name/Location
632AB	Main Tank Access Door - Wing Station 216
632AZ	Main Tank Inner Access at Rib 6

NOTE: Nacelle fairing should be removed for inspection.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 57-05-02-250-042

(2) Do an internal special detailed inspection (High Frequency Eddy Current) of all fasteners, inner location, common to the R7/R8 nacelle fitting attachment. (Direction 4)

See Doc. D626A001 - DTR, DTR check form 57-20-04-9, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-10-51.

SUBTASK 57-05-02-410-120

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

Number	Name/Location
532AB	Main Tank Access Door - Wing Station 216
532AZ	Main Tank Inner Access at Rib 6

Close these access panels on the Right side:

Number	Name/Location
632AB	Main Tank Access Door - Wing Station 216
632AZ	Main Tank Inner Access at Rib 6

——— END OF TASK ———

TASK 57-05-02-210-816

62. INTERNAL - GENERAL VISUAL: REAR SPAR LOWER CHORD (SKIN FLANGE INSPECTIONS)

Figure 222

NOTE: This procedure is a scheduled maintenance task.

A. 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
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

B. 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
631AB	Center Tank Access Door - Wing Station 168
631BB	Center Tank Access Door - Wing Station 192
632AB	Main Tank Access Door - Wing Station 216

C. Inspection

SUBTASK 57-05-02-010-047

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

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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
532AB	Main Tank Access Door - Wing Station 216

Open these access panels on the Right side:

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

NOTE: Remove any cap or brush sealant that extends beyond .20” around fastener heads and collars. Remove any additional sealant which impairs visibility of the stringer. Fillet seals that touch only the stringer edges do not need to be removed.

SUBTASK 57-05-02-210-016

(2) Do a General Visual inspection of the rear spar lower chord at the non-hidden areas from rib 1 to rib 7.

See Doc. D626A001 - DTR, DTR check form 57-20-05-1, for alternative inspection.

SUBTASK 57-05-02-410-047

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

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

Close these access panels on the Right side:

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

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(THE LEFT WING IS SHOWN, THE RIGHT WING IS OPPOSITE)

A

REAR SPAR
(THE LEFT SIDE IS SHOWN, THE RIGHT SIDE IS OPPOSITE)
(SKIN FLANGE INSPECTION, NON-HIDDEN)

B

REAR SPAR LOWER CHORD
(EXAMPLE)

A-A

3040378 S0000808545_V1

Rear Spar Lower Chord (Skin Flange Inspections)
Figure 222/57-05-02-990-826

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-210-818

63. INTERNAL - GENERAL VISUAL: REAR SPAR LOWER CHORD (WEB FLANGE INSPECTIONS)

Figure 223

NOTE: This procedure is a scheduled maintenance task.

A. 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
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

B. 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
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

C. Inspection

SUBTASK 57-05-02-010-207

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

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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
532FB	Main Tank Access Door - Wing Station 367
532GB	Main Tank Access Door - Wing Station 390
532HB	Main Tank Access Door - Wing Station 417

Open these access panels on the Right side:

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

NOTE: Remove any cap or brush sealant that extends beyond .20” around fastener heads and collars. Remove any additional sealant which impairs visibility of the stringer. Fillet seals that touch only the stringer edges do not need to be removed.

SUBTASK 57-05-02-210-018

(2) Do a General Visual inspection of the rear spar lower chord at the non-hidden areas from rib 1 to rib 14.

See Doc. D626A001 - DTR, DTR check form 57–20–05–2, for alternative inspection.

SUBTASK 57-05-02-410-207

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

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

Close these access panels on the Right side:

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

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(Continued)

Number	Name/Location
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

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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Rear Spar Lower Chord (Web Flange Inspections)
Figure 223/57-05-02-990-827

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-130-823

64. INTERNAL - SPECIAL DETAILED: REAR SPAR LOWER CHORD (WEB FLANGE INSPECTIONS)

NOTE: This procedure is a scheduled maintenance task.

A. 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
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

B. 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
533BB	Surge Tank Access Door - Wing Station 679
533CB	Surge Tank Access Door - Wing Station 703
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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
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

C. Inspection

SUBTASK 57-05-02-010-218

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

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

Open these access panels on the Right side:

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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
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

SUBTASK 57-05-02-130-023

(2) Do an Ultrasonic inspection of the rear spar lower chord at the areas hidden by a stiffener, rib post, or fitting from rib 1 to rib 25.

See Doc. D626A001 - DTR, DTR check form 57-20-05-3, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 4, Subject 57-10-16.

SUBTASK 57-05-02-410-218

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

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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
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

Close these access panels on the Right side:

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

——— END OF TASK ———

TASK 57-05-02-211-823

65. INTERNAL - DETAILED: REAR SPAR LOWER CHORD (SKIN FLANGE INSPECTIONS)

Figure 224

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

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

B. Access Panels

Number	Name/Location
532BB	Main Tank Access Door - Wing Station 265
532CB	Main Tank Access Door - Wing Station 290
532DB	Main Tank Access Door - Wing Station 313

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
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
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

C. Inspection

SUBTASK 57-05-02-010-062

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

Number	Name/Location
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

Open these access panels on the Right side:

Number	Name/Location
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

NOTE: Remove any cap or brush sealant that extends beyond .20” around fastener heads and collars. Remove any additional sealant which impairs visibility of the stringer. Fillet seals that touch only the stringer edges do not need to be removed.

SUBTASK 57-05-02-211-023

(2) Do a Detailed inspection of the rear spar lower chord at the non-hidden areas from rib 7 to rib 14.

See Doc. D626A001 - DTR, DTR check form 57–20–05–4, for alternative inspection.

SUBTASK 57-05-02-410-062

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

Number	Name/Location
532BB	Main Tank Access Door - Wing Station 265

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
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

Close these access panels on the Right side:

Number	Name/Location
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

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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Rear Spar Lower Chord (Skin Flange Inspections)
Figure 224/57-05-02-990-828

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-250-845

66. EXTERNAL - SPECIAL DETAILED: REAR SPAR LOWER CHORD (SKIN FLANGE INSPECTIONS)

NOTE: This procedure is a scheduled maintenance task.

A. 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
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

B. Inspection

SUBTASK 57-05-02-250-045

(1) Do a Low Frequency Eddy Current inspection of the rear spar lower chord areas hidden by a stiffener from rib 1 to rib 22 and the areas hidden by rib post or fitting from rib 1 to rib 25.

See Doc. D626A001 - DTR, DTR check form 57–20–05–5, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-10-58.

END OF TASK

TASK 57-05-02-250-846

67. INTERNAL - SPECIAL DETAILED: DOUBLE PLUS CHORD UPPER HORIZONTAL FLANGE AT STUB BEAMS

NOTE: This procedure is a scheduled maintenance task.

A. 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

B. Inspection

NOTE: Floor panel removal is required.

SUBTASK 57-05-02-250-046

(1) Do a High Frequency Eddy Current inspection of the upper horizontal flange of the chord at the stub beams at STAs 559, 578, 597, 616 and 639.

See Doc. D626A001 - DTR, DTR check form 57-10-05-5, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-10-43.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-211-825

68. INTERNAL - DETAILED: REAR SPAR LOWER CHORD (SKIN FLANGE INSPECTIONS)

Figure 225

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

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

B. Access Panels

Number	Name/Location
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
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

C. Inspection

SUBTASK 57-05-02-010-063

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

Number	Name/Location
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

Open these access panels on the Right side:

Number	Name/Location
632JB	Main Tank Access Door - Wing Station 443
632KB	Main Tank Access Door - Wing Station 470
632LB	Main Tank Access Door - Wing Station 496

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
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

NOTE: Remove any cap or brush sealant that extends beyond .20” around fastener heads and collars. Remove any additional sealant which impairs visibility of the stringer. Fillet seals that touch only the stringer edges do not need to be removed.

SUBTASK 57-05-02-211-025

(2) Do a Detailed inspection of the rear spar lower chord at the non-hidden areas from rib 14 to rib 22.

See Doc. D626A001 - DTR, DTR check form 57–20–05–6, for alternative inspection.

SUBTASK 57-05-02-410-063

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

Number	Name/Location
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

Close these access panels on the Right side:

Number	Name/Location
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

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Rear Spar Lower Chord (Skin Flange Inspections)
Figure 225/57-05-02-990-811

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-211-827

69. INTERNAL - DETAILED: REAR SPAR LOWER CHORD (WEB FLANGE INSPECTIONS)

Figure 226

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

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

B. Access Panels

Number	Name/Location
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
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

C. Inspection

SUBTASK 57-05-02-010-065

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

Number	Name/Location
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

Open these access panels on the Right side:

Number	Name/Location
632JB	Main Tank Access Door - Wing Station 443
632KB	Main Tank Access Door - Wing Station 470
632LB	Main Tank Access Door - Wing Station 496

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
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

NOTE: Remove any cap or brush sealant that extends beyond .20” around fastener heads and collars. Remove any additional sealant which impairs visibility of the stringer. Fillet seals that touch only the stringer edges do not need to be removed.

SUBTASK 57-05-02-211-027

(2) Do a Detailed inspection of the rear spar lower chord at the non-hidden areas from rib 14 to rib 22.

See Doc. D626A001 - DTR, DTR check form 57–20–05–7, for alternative inspection.

SUBTASK 57-05-02-410-065

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

Number	Name/Location
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

Close these access panels on the Right side:

Number	Name/Location
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

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Rear Spar Lower Chord (Web Flange Inspections)
Figure 226/57-05-02-990-812

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-250-847

70. INTERNAL - SPECIAL DETAILED: LOWER SKIN PANEL AT MAIN LANDING GEAR OUTBOARD SUPPORT FITTINGS

NOTE: This procedure is a scheduled maintenance task.

A. 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
550	Subzone - Left Wing: Trailing Edge, Aft of Rear Spar, Inbd of Outboard Trailing Edge Flap
560	Subzone - Left Wing: Trailing Edge , Aft of Rear Spar, Outboard of Inbd Trailing Edge Flap, Inbd of Fixed Trailing Edge
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
650	Subzone - Right Wing: Trailing Edge, Aft of Rear Spar, Inboard of Outboard Trailing Edge Flap
660	Subzone - Right Wing: Trailing Edge, Aft of Rear Spar, Outboard of Inboard Trailing Edge Flap, Inboard of Fixed Trailing Edge

B. Inspection

NOTE: Fairing removal required at WSTA 228.25.

SUBTASK 57-05-02-250-047

(1) Do a High Frequency Eddy Current inspection of all the fasteners common to the skin and fittings at WSTA 228.25, and 253.00 on the gear beam outboard support fittings and at WSTA 180 and WSTA 190 on the forward trunnion support fitting.

See Doc. D626A001 - DTR, DTR check form 57–20–06 / 07–1, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 57-30-11.

——— END OF TASK ———

TASK 57-05-02-250-849

71. INTERNAL - SPECIAL DETAILED: SKIN AT NACELLE SUPPORT FITTING ATTACHMENTS

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
54-52-04 P/B 401	AFT FAIRING - REMOVAL/INSTALLATION
54-52-06-010-801	Aft Fairing Access Panel Removal (P/B 401)
54-52-06-410-801	Aft Fairing Access Panel Installation (P/B 401)

B. Location Zones

Zone	Area
434	Engine 1 - Aft Strut Fairing
444	Engine 2 - Aft Strut Fairing
532	Left Wing - Main Tank, Rib 5 to Rib 22, Wing Station 204.25 to Wing BL 643.50

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

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
431EL	Forward Strut Fairing, Left T.R. Strut Fairing, Strut 1
431ER	Forward Strut Fairing, Right T.R. Strut Fairing, Strut 1
434AL	Aft Strut Fairing, Left Forward Panel, Strut 1
434AR	Aft Strut Fairing, Right Forward Panel, Strut 1
434BL	Aft Strut Fairing, Left Aft Panel, Strut 1
441EL	Forward Strut Fairing, Left T.R. Strut Fairing, Strut 2
441ER	Forward Strut Fairing, Right T.R. Strut Fairing, Strut 2
444AL	Aft Strut Fairing, Left Forward Panel, Strut 2
444AR	Aft Strut Fairing, Right Forward Panel, Strut 2
444BR	Aft Strut Fairing, Right Aft Panel, Strut 2

D. Inspection

SUBTASK 57-05-02-010-126

(1) Remove these aft fairing access panels, refer to Aft Fairing Access Panel Removal, TASK 54-52-06-010-801:

(a) Remove these access panels on the Left side:

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

(b) Remove these access panels on the Right side:

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

SUBTASK 57-05-02-010-236

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

(a) Remove these access panels on the Left side:

Number	Name/Location
431EL	Forward Strut Fairing, Left T.R. Strut Fairing, Strut 1
431ER	Forward Strut Fairing, Right T.R. Strut Fairing, Strut 1

(b) Remove these access panels on the Right side:

Number	Name/Location
441EL	Forward Strut Fairing, Left T.R. Strut Fairing, Strut 2
441ER	Forward Strut Fairing, Right T.R. Strut Fairing, Strut 2

SUBTASK 57-05-02-010-245

(3) Remove aft fairing: AFT FAIRING - REMOVAL/INSTALLATION, PAGEBLOCK 54-52-04/401

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 57-05-02-250-049

(4) Do a High Frequency Eddy Current inspection of the lower wing skin at the R2 and R4 nacelle fitting attachments.

See Doc. D626A001 - DTR, DTR check form 57–20–09, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-30-08.

SUBTASK 57-05-02-410-244

(5) Install aft fairing: AFT FAIRING - REMOVAL/INSTALLATION, PAGEBLOCK 54-52-04/401

SUBTASK 57-05-02-410-126

(6) Install these aft fairing access panels, refer to Aft Fairing Access Panel Installation, TASK 54-52-06-410-801:

(a) Install these access panels on the Left side:

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

(b) Install these access panels on the Right side:

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

SUBTASK 57-05-02-410-235

(7) Install these FWD fairing access panels:

(a) Install these access panels on the Left side:

Number	Name/Location
431EL	Forward Strut Fairing, Left T.R. Strut Fairing, Strut 1
431ER	Forward Strut Fairing, Right T.R. Strut Fairing, Strut 1

(b) Install these access panels on the Right side:

Number	Name/Location
441EL	Forward Strut Fairing, Left T.R. Strut Fairing, Strut 2
441ER	Forward Strut Fairing, Right T.R. Strut Fairing, Strut 2

——— END OF TASK ———

TASK 57-05-02-250-850

72. INTERNAL - SPECIAL DETAILED: SIDE-OF-BODY SPLICE, LOWER SURFACE SKIN

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
192	Lower Wing-To-Body Fairing - Under Wing Box
531	Left Wing - Center Fuel Tank, Rib 1 to Rib 5
631	Right Wing - Center Fuel Tank, Rib 1 to Rib 5

ECCN 9E991 BOEING PROPRIETARY - See title page for details

B. 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
192HL	Underwing Bolt Cover - Aft
192HR	Underwing Bolt Cover - Aft

C. Inspection

SUBTASK 57-05-02-010-138

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

Number	Name/Location
192AL	Underwing Bolt Cover - Forward
192BL	ECS Ram Air Inlet Mixing Duct Panel - Forward
192HL	Underwing Bolt Cover - Aft

Open these access panels on the Right side:

Number	Name/Location
192AR	Underwing Bolt Cover - Forward
192BR	ECS Ram Air Inlet Mixing Duct Panel - Forward
192HR	Underwing Bolt Cover - Aft

NOTE: Inspection requires removal of Wing-to-Body fairing.

SUBTASK 57-05-02-250-050

(2) Do a High Frequency Eddy Current inspection of the side of body splice, lower surface skin in the non hidden areas from the front spar to the rear spar at BBL 70.85.

See Doc. D626A001 - DTR, DTR check form 57-10-11-2, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-10-39.

SUBTASK 57-05-02-410-138

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

Number	Name/Location
192AL	Underwing Bolt Cover - Forward
192BL	ECS Ram Air Inlet Mixing Duct Panel - Forward
192HL	Underwing Bolt Cover - Aft

Close these access panels on the Right side:

Number	Name/Location
192AR	Underwing Bolt Cover - Forward
192BR	ECS Ram Air Inlet Mixing Duct Panel - Forward
192HR	Underwing Bolt Cover - Aft

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-250-851

73. EXTERNAL - SPECIAL DETAILED: LOWER WING PANEL SKIN AT SHEAR TIED RIB ATTACHMENTS

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

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

B. Inspection

SUBTASK 57-05-02-250-051

(1) Do a High Frequency Eddy Current inspection of the lower wing panel skin at the shear tied rib attachments at rib 14.

See Doc. D626A001 - DTR, DTR check form 57-20-10 for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-10-64.

END OF TASK

TASK 57-05-02-250-852

74. INTERNAL - SPECIAL DETAILED: SIDE-OF-BODY SPLICE, LOWER SURFACE SKIN

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
192	Lower Wing-To-Body Fairing - Under Wing Box

B. 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
192HL	Underwing Bolt Cover - Aft
192HR	Underwing Bolt Cover - Aft

C. Inspection

SUBTASK 57-05-02-010-136

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

Number	Name/Location
192AL	Underwing Bolt Cover - Forward
192BL	ECS Ram Air Inlet Mixing Duct Panel - Forward
192HL	Underwing Bolt Cover - Aft

Open these access panels on the Right side:

Number	Name/Location
192AR	Underwing Bolt Cover - Forward

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
192BR	ECS Ram Air Inlet Mixing Duct Panel - Forward
192HR	Underwing Bolt Cover - Aft

NOTE: Inspection requires removal of Wing-to-Body fairing.

SUBTASK 57-05-02-250-052

(2) Do a High Frequency Eddy Current inspection of the side of body splice, lower surface skin in the hidden areas from the front spar to the rear spar at BBL 70.85.

See Doc. D626A001 - DTR, DTR check form 57-10-11-3, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-10-70.

SUBTASK 57-05-02-410-136

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

Number	Name/Location
192AL	Underwing Bolt Cover - Forward
192BL	ECS Ram Air Inlet Mixing Duct Panel - Forward
192HL	Underwing Bolt Cover - Aft

Close these access panels on the Right side:

Number	Name/Location
192AR	Underwing Bolt Cover - Forward
192BR	ECS Ram Air Inlet Mixing Duct Panel - Forward
192HR	Underwing Bolt Cover - Aft

——— END OF TASK ———

TASK 57-05-02-250-853

75. INTERNAL - SPECIAL DETAILED: LOWER WING PANEL UNDER FLAP TRACK FITTINGS (DIRECTION 1)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
532	Left Wing - Main Tank, Rib 5 to Rib 22, Wing Station 204.25 to Wing BL 643.50
543	Left Wing - Fairing Flap Support No. 2
544	Left Wing - Fairing Flap Support No. 1
632	Right Wing - Main Tank, Rib 5 to Rib 22, Wing Station 204.25 to Wing Station 643.50
643	Right Wing - Fairing Flap Support No. 7
644	Right Wing - Fairing Flap Support No. 8

B. Access Panels

Number	Name/Location
543AB	Flap Support No. 2 Access Panel, Forward Assembly
543BB	Flap Support No. 2 Access Panel, Aft Assembly
543CL	Flap Support No. 2 Access Cover
543CR	Flap Support No. 2 Access Cover

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
543DR	Flap Support No. 2 Access Door
544AB	Flap Support No. 1 Access Panel, Forward Assembly
544BB	Flap Support No. 1 Access Panel, Aft Assembly
544CL	Flap Support No. 1 Access Cover
544CR	Flap Support No. 1 Access Cover
544DR	Flap Support No. 1 Access Door
643AB	Flap Support No. 7, Forward Assembly Access Panel
643BB	Flap Support No. 7, Aft Assembly Access Panel
643CL	Flap Support No. 7, Access Cover
643CR	Flap Support No. 7, Access Cover
643DL	Flap Support No. 7, Access Door
644AB	Flap Support No. 8, Forward Assembly Access Panel
644BB	Flap Support No. 8, Aft Assembly Access Panel
644CL	Flap Support No. 8, Access Cover
644CR	Flap Support No. 8, Access Cover
644DL	Flap Support No. 8, Access Door

C. Inspection

SUBTASK 57-05-02-010-130

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

Number	Name/Location
543AB	Flap Support No. 2 Access Panel, Forward Assembly
543BB	Flap Support No. 2 Access Panel, Aft Assembly
543CL	Flap Support No. 2 Access Cover
543CR	Flap Support No. 2 Access Cover
543DR	Flap Support No. 2 Access Door
544AB	Flap Support No. 1 Access Panel, Forward Assembly
544BB	Flap Support No. 1 Access Panel, Aft Assembly
544CL	Flap Support No. 1 Access Cover
544CR	Flap Support No. 1 Access Cover
544DR	Flap Support No. 1 Access Door

Open these access panels on the Right side:

Number	Name/Location
643AB	Flap Support No. 7, Forward Assembly Access Panel
643BB	Flap Support No. 7, Aft Assembly Access Panel
643CL	Flap Support No. 7, Access Cover
643CR	Flap Support No. 7, Access Cover
643DL	Flap Support No. 7, Access Door
644AB	Flap Support No. 8, Forward Assembly Access Panel
644BB	Flap Support No. 8, Aft Assembly Access Panel
644CL	Flap Support No. 8, Access Cover
644CR	Flap Support No. 8, Access Cover
644DL	Flap Support No. 8, Access Door

NOTE: Removal of flap track fairing required.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 57-05-02-250-053

(2) Do a High Frequency Eddy Current inspection of the wing lower skin, area under the flap fairing, between the forward and aft attach fittings at Rib 10 and Rib 14.

See Doc. D626A001 - DTR, DTR check form 57–20–12, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-30-09.

SUBTASK 57-05-02-410-130

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

Number	Name/Location
543AB	Flap Support No. 2 Access Panel, Forward Assembly
543BB	Flap Support No. 2 Access Panel, Aft Assembly
543CL	Flap Support No. 2 Access Cover
543CR	Flap Support No. 2 Access Cover
543DR	Flap Support No. 2 Access Door
544AB	Flap Support No. 1 Access Panel, Forward Assembly
544BB	Flap Support No. 1 Access Panel, Aft Assembly
544CL	Flap Support No. 1 Access Cover
544CR	Flap Support No. 1 Access Cover
544DR	Flap Support No. 1 Access Door

Close these access panels on the Right side:

Number	Name/Location
643AB	Flap Support No. 7, Forward Assembly Access Panel
643BB	Flap Support No. 7, Aft Assembly Access Panel
643CL	Flap Support No. 7, Access Cover
643CR	Flap Support No. 7, Access Cover
643DL	Flap Support No. 7, Access Door
644AB	Flap Support No. 8, Forward Assembly Access Panel
644BB	Flap Support No. 8, Aft Assembly Access Panel
644CL	Flap Support No. 8, Access Cover
644CR	Flap Support No. 8, Access Cover
644DL	Flap Support No. 8, Access Door

END OF TASK

TASK 57-05-02-250-854

76. INTERNAL - SPECIAL DETAILED: LOWER WING PANEL UNDER FLAP TRACK FITTINGS (DIRECTION 2)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
532	Left Wing - Main Tank, Rib 5 to Rib 22, Wing Station 204.25 to Wing BL 643.50
543	Left Wing - Fairing Flap Support No. 2
544	Left Wing - Fairing Flap Support No. 1
632	Right Wing - Main Tank, Rib 5 to Rib 22, Wing Station 204.25 to Wing Station 643.50

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

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

B. Access Panels

Number	Name/Location
543AB	Flap Support No. 2 Access Panel, Forward Assembly
543BB	Flap Support No. 2 Access Panel, Aft Assembly
543CL	Flap Support No. 2 Access Cover
543CR	Flap Support No. 2 Access Cover
543DR	Flap Support No. 2 Access Door
544AB	Flap Support No. 1 Access Panel, Forward Assembly
544BB	Flap Support No. 1 Access Panel, Aft Assembly
544CL	Flap Support No. 1 Access Cover
544CR	Flap Support No. 1 Access Cover
544DR	Flap Support No. 1 Access Door
643AB	Flap Support No. 7, Forward Assembly Access Panel
643BB	Flap Support No. 7, Aft Assembly Access Panel
643CL	Flap Support No. 7, Access Cover
643CR	Flap Support No. 7, Access Cover
643DL	Flap Support No. 7, Access Door
644AB	Flap Support No. 8, Forward Assembly Access Panel
644BB	Flap Support No. 8, Aft Assembly Access Panel
644CL	Flap Support No. 8, Access Cover
644CR	Flap Support No. 8, Access Cover
644DL	Flap Support No. 8, Access Door

C. Inspection

SUBTASK 57-05-02-010-132

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

Number	Name/Location
543AB	Flap Support No. 2 Access Panel, Forward Assembly
543BB	Flap Support No. 2 Access Panel, Aft Assembly
543CL	Flap Support No. 2 Access Cover
543CR	Flap Support No. 2 Access Cover
543DR	Flap Support No. 2 Access Door
544AB	Flap Support No. 1 Access Panel, Forward Assembly
544BB	Flap Support No. 1 Access Panel, Aft Assembly
544CL	Flap Support No. 1 Access Cover
544CR	Flap Support No. 1 Access Cover
544DR	Flap Support No. 1 Access Door

Open these access panels on the Right side:

Number	Name/Location
643AB	Flap Support No. 7, Forward Assembly Access Panel
643BB	Flap Support No. 7, Aft Assembly Access Panel
643CL	Flap Support No. 7, Access Cover

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
643CR	Flap Support No. 7, Access Cover
643DL	Flap Support No. 7, Access Door
644AB	Flap Support No. 8, Forward Assembly Access Panel
644BB	Flap Support No. 8, Aft Assembly Access Panel
644CL	Flap Support No. 8, Access Cover
644CR	Flap Support No. 8, Access Cover
644DL	Flap Support No. 8, Access Door

NOTE: Removal of flap track fairing required.

SUBTASK 57-05-02-250-054

(2) Do a High Frequency Eddy Current inspection of the wing lower skin, area under the flap fairing, forward of the forward flap track fitting and between the fairing rub strips at Rib 10 and Rib 14.

See Doc. D626A001 - DTR, DTR check form 57–20–12, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-30-09.

SUBTASK 57-05-02-410-132

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

Number	Name/Location
543AB	Flap Support No. 2 Access Panel, Forward Assembly
543BB	Flap Support No. 2 Access Panel, Aft Assembly
543CL	Flap Support No. 2 Access Cover
543CR	Flap Support No. 2 Access Cover
543DR	Flap Support No. 2 Access Door
544AB	Flap Support No. 1 Access Panel, Forward Assembly
544BB	Flap Support No. 1 Access Panel, Aft Assembly
544CL	Flap Support No. 1 Access Cover
544CR	Flap Support No. 1 Access Cover
544DR	Flap Support No. 1 Access Door

Close these access panels on the Right side:

Number	Name/Location
643AB	Flap Support No. 7, Forward Assembly Access Panel
643BB	Flap Support No. 7, Aft Assembly Access Panel
643CL	Flap Support No. 7, Access Cover
643CR	Flap Support No. 7, Access Cover
643DL	Flap Support No. 7, Access Door
644AB	Flap Support No. 8, Forward Assembly Access Panel
644BB	Flap Support No. 8, Aft Assembly Access Panel
644CL	Flap Support No. 8, Access Cover
644CR	Flap Support No. 8, Access Cover
644DL	Flap Support No. 8, Access Door

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-130-825

77. INTERNAL - SPECIAL DETAILED: LOWER WING PANEL UNDER FLAP TRACK FITTINGS (DIRECTION 1)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

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

B. Access Panels

Number	Name/Location
543AB	Flap Support No. 2 Access Panel, Forward Assembly
543BB	Flap Support No. 2 Access Panel, Aft Assembly
543CL	Flap Support No. 2 Access Cover
543CR	Flap Support No. 2 Access Cover
543DR	Flap Support No. 2 Access Door
544AB	Flap Support No. 1 Access Panel, Forward Assembly
544BB	Flap Support No. 1 Access Panel, Aft Assembly
544CL	Flap Support No. 1 Access Cover
544CR	Flap Support No. 1 Access Cover
544DR	Flap Support No. 1 Access Door
643AB	Flap Support No. 7, Forward Assembly Access Panel
643BB	Flap Support No. 7, Aft Assembly Access Panel
643CL	Flap Support No. 7, Access Cover
643CR	Flap Support No. 7, Access Cover
643DL	Flap Support No. 7, Access Door
644AB	Flap Support No. 8, Forward Assembly Access Panel
644BB	Flap Support No. 8, Aft Assembly Access Panel
644CL	Flap Support No. 8, Access Cover
644CR	Flap Support No. 8, Access Cover
644DL	Flap Support No. 8, Access Door

C. Inspection

SUBTASK 57-05-02-010-020

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

Number	Name/Location
543AB	Flap Support No. 2 Access Panel, Forward Assembly
543BB	Flap Support No. 2 Access Panel, Aft Assembly
543CL	Flap Support No. 2 Access Cover
543CR	Flap Support No. 2 Access Cover
543DR	Flap Support No. 2 Access Door
544AB	Flap Support No. 1 Access Panel, Forward Assembly
544BB	Flap Support No. 1 Access Panel, Aft Assembly
544CL	Flap Support No. 1 Access Cover
544CR	Flap Support No. 1 Access Cover

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
544DR	Flap Support No. 1 Access Door

Open these access panels on the Right side:

Number	Name/Location
643AB	Flap Support No. 7, Forward Assembly Access Panel
643BB	Flap Support No. 7, Aft Assembly Access Panel
643CL	Flap Support No. 7, Access Cover
643CR	Flap Support No. 7, Access Cover
643DL	Flap Support No. 7, Access Door
644AB	Flap Support No. 8, Forward Assembly Access Panel
644BB	Flap Support No. 8, Aft Assembly Access Panel
644CL	Flap Support No. 8, Access Cover
644CR	Flap Support No. 8, Access Cover
644DL	Flap Support No. 8, Access Door

NOTE: Removal of flap track fairing required.

SUBTASK 57-05-02-130-025

(2) Do an Ultrasonic inspection of the perimeter of the forward flap track fitting and aft flap attachment at Rib 10 and Rib 14.

See Doc. D626A001 - DTR, DTR check form 57–20–12, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 4, Subject 57-10-08.

SUBTASK 57-05-02-410-020

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

Number	Name/Location
543AB	Flap Support No. 2 Access Panel, Forward Assembly
543BB	Flap Support No. 2 Access Panel, Aft Assembly
543CL	Flap Support No. 2 Access Cover
543CR	Flap Support No. 2 Access Cover
543DR	Flap Support No. 2 Access Door
544AB	Flap Support No. 1 Access Panel, Forward Assembly
544BB	Flap Support No. 1 Access Panel, Aft Assembly
544CL	Flap Support No. 1 Access Cover
544CR	Flap Support No. 1 Access Cover
544DR	Flap Support No. 1 Access Door

Close these access panels on the Right side:

Number	Name/Location
643AB	Flap Support No. 7, Forward Assembly Access Panel
643BB	Flap Support No. 7, Aft Assembly Access Panel
643CL	Flap Support No. 7, Access Cover
643CR	Flap Support No. 7, Access Cover
643DL	Flap Support No. 7, Access Door
644AB	Flap Support No. 8, Forward Assembly Access Panel
644BB	Flap Support No. 8, Aft Assembly Access Panel

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
644CL	Flap Support No. 8, Access Cover
644CR	Flap Support No. 8, Access Cover
644DL	Flap Support No. 8, Access Door

END OF TASK

TASK 57-05-02-250-855

78. INTERNAL - SPECIAL DETAILED: LOWER WING PANEL, RAIL STRINGERS

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

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

B. Inspection

SUBTASK 57-05-02-250-055

(1) Do a High Frequency Eddy Current inspection of the lower wing panel rail stringer, S-8, from rib 6 to rib 7 at the areas hidden by the nacelle support strut attachment fitting.

See Doc. D626A001 - DTR, DTR check form 57-20-02-3, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-10-80.

END OF TASK

TASK 57-05-02-211-829

79. EXTERNAL - DETAILED: UPPER WING PANEL TYPICAL STRINGERS

Figure 227

NOTE: This procedure is a scheduled maintenance task.

A. 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
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

B. Inspection

SUBTASK 57-05-02-211-029

(1) Do a Detailed inspection of the typical stringers at rib 5 that are hidden under seal pans and sealant.

See Doc. D626A001 - DTR, DTR check form 57–20–13–1, for alternative inspection.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

PLAN VIEW OF OUTER WING UPPER SURFACE
(LEFT WING IS SHOWN, RIGHT WING IS OPPOSITE)

A

TYPICAL STRINGER
(15 LOCATIONS)

A-A

3042296 S0000809730_V1

Upper Wing Panel Typical Stringers
Figure 227/57-05-02-990-813

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-211-831

80. INTERNAL - DETAILED: REAR SPAR UPPER CHORD SKIN FLANGE INSPECTIONS

Figure 228

NOTE: This procedure is a scheduled maintenance task.

A. 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
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

B. 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
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

C. Inspection

SUBTASK 57-05-02-010-219

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

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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Open these access panels on the Right side:

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

NOTE: Remove any cap or brush sealant that extends beyond .20” around fastener heads or collars. Remove any additional sealant which impairs visibility of the chord. Fillet seals that touch only the chord edge do not need to be removed.

SUBTASK 57-05-02-211-031

(2) Do a Detailed inspection of the rear spar upper chord at the non-hidden areas from rib 1 to rib 13.

See Doc. D626A001 - DTR, DTR check form 57–20–17–1, for alternative inspection.

SUBTASK 57-05-02-410-219

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

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

Close these access panels on the Right side:

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

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(THE LEFT WING IS SHOWN, THE RIGHT WING IS OPPOSITE)

A

REAR SPAR
(THE LEFT SIDE IS SHOWN, THE RIGHT SIDE IS OPPOSITE)

B

3042850 S0000810146_V1

Rear Spar Upper Chord Skin Flange
Figure 228/57-05-02-990-829

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-250-857

81. EXTERNAL - SPECIAL DETAILED: REAR SPAR UPPER CHORD (SKIN FLANGE INSPECTIONS)

NOTE: This procedure is a scheduled maintenance task.

A. 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
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

B. Inspection

SUBTASK 57-05-02-250-057

(1) Do a Low Frequency Eddy Current inspection of the rear spar upper chord at the areas hidden by a stiffener, rib post, or fitting from rib 1 to rib 13.

See Doc. D626A001 - DTR, DTR check form 57–20–17–2, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-10-59.

——— END OF TASK ———

TASK 57-05-02-250-859

82. INTERNAL - SPECIAL DETAILED: REAR SPAR UPPER CHORD (WEB FLANGE INSPECTIONS)

NOTE: This procedure is a scheduled maintenance task.

A. 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
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

B. 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
631AB	Center Tank Access Door - Wing Station 168
631BB	Center Tank Access Door - Wing Station 192
632AB	Main Tank Access Door - Wing Station 216

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
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

C. Inspection

SUBTASK 57-05-02-010-151

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

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

Open these access panels on the Right side:

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

SUBTASK 57-05-02-250-059

(2) Do a High Frequency Eddy Current inspection of the rear spar upper chord at the non-hidden areas from rib 1 to rib 13.

See Doc. D626A001 - DTR, DTR check form 57–20–17–3, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-10-42.

SUBTASK 57-05-02-410-151

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

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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
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

Close these access panels on the Right side:

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

——— END OF TASK ———

TASK 57-05-02-130-827

83. INTERNAL - SPECIAL DETAILED: REAR SPAR UPPER CHORD (WEB FLANGE INSPECTIONS)

NOTE: This procedure is a scheduled maintenance task.

A. 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
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

B. 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
631AB	Center Tank Access Door - Wing Station 168
631BB	Center Tank Access Door - Wing Station 192
632AB	Main Tank Access Door - Wing Station 216

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
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

C. Inspection

SUBTASK 57-05-02-010-173

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

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

Open these access panels on the Right side:

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

SUBTASK 57-05-02-130-027

(2) Do an Ultrasonic inspection of the rear spar upper chord at the areas hidden by stiffener, rib post, or fitting from rib 1 to rib 13.

See Doc. D626A001 - DTR, DTR check form 57–20–17–4, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 4, Subject 57-10-10.

SUBTASK 57-05-02-410-173

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

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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
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

Close these access panels on the Right side:

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

——— END OF TASK ———

TASK 57-05-02-250-861

84. INTERNAL - SPECIAL DETAILED: WING UPPER SKIN TAB AT R1 NACELLE FITTING

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

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

B. Inspection

SUBTASK 57-05-02-250-061

(1) Do a High Frequency Eddy Current inspection of the fasteners common to skin and R1 fitting as well as the fasteners common to the fairing bracket from the adjacent edge.

See Doc. D626A001 - DTR, DTR check form 57–20–19, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 57-30-10.

——— END OF TASK ———

TASK 57-05-02-211-833

85. INTERNAL - DETAILED: FRONT SPAR WEB CRACK - TYPICAL DETAILS

Figure 229

NOTE: This procedure is a scheduled maintenance task.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

A. 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
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

B. Inspection

SUBTASK 57-05-02-211-033

(1) Do a Detailed inspection of the web at the stiffeners or fittings from rib 1 to rib 6 and from rib 7 to rib 27.

See Doc. D626A001 - DTR, DTR check form 57–20–22, for alternative inspection.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(LEFT WING IS SHOWN,
RIGHT WING IS OPPOSITE)

FRONT SPAR WEB
(EXAMPLE)

A-A

3042840 S0000810150_V1

Front Spar Web Crack - Typical Details
Figure 229/57-05-02-990-830

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-211-835

86. EXTERNAL- DETAILED: OUTBOARD WING REAR SPAR WEB TYPICAL DETAILS

Figure 230

NOTE: This procedure is a scheduled maintenance task.

A. 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
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

B. Inspection

SUBTASK 57-05-02-211-035

(1) Do a Detailed inspection of the outboard wing rear spar web at ribs 1 to 27.

See Doc. D626A001 - DTR, DTR check form 57–20–24–1, for alternative inspection.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

3042734 S0000810154_V1

Outboard Wing Rear Spar Web Typical Details
Figure 230/57-05-02-990-831

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-211-837

87. EXTERNAL - DETAILED: OUTBOARD WING REAR SPAR WEB TYPICAL DETAILS

A. Location Zones

Zone	Area
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
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

B. Inspection

SUBTASK 57-05-02-211-037

(1) Do the inspection (Detailed) of ribs 1 to 8, ribs 10 to 11, and ribs 14 to 15 at the 12A1703 fittings.

NOTE: See Doc. D626A001 - DTR, DTR check form 57–20–24–1, for alternative inspection.

——— END OF TASK ———

TASK 57-05-02-130-829

88. INTERNAL - SPECIAL DETAILED: REAR SPAR WEB AT TRUNNION ATTACHMENT, MLG AND T.E. FITTINGS

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
551	Left Wing - Rear Spar To Landing Gear Support Beam
561	Left Wing - Rear Spar to Trailing Edge, Outboard Of Inboard Flap, Inboard of Fixed Trailing Edge
571	Left Wing - Fixed Trailing Edge
651	Right 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
671	Right Wing - Fixed Trailing Edge

B. Access Panels

Number	Name/Location
551AT	Upper Inboard Fixed Trailing Edge Access Panel
551BB	Lower Inboard Fixed Trailing Edge, Gear Adjustment Door
551CT	Upper Inboard Fixed Trailing Edge, Structural Pin Access Panel
651AT	Upper Inboard Fixed Trailing Edge Access Panel
651BT	Upper Inboard Fixed Trailing Edge, MLG Actuator Access Panel
651CT	Upper Inboard Fixed Trailing Edge, Structural Pin Access Panel

ECCN 9E991 BOEING PROPRIETARY - See title page for details

C. Inspection

SUBTASK 57-05-02-010-022

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

Number	Name/Location
551AT	Upper Inboard Fixed Trailing Edge Access Panel
551BB	Lower Inboard Fixed Trailing Edge, Gear Adjustment Door
551CT	Upper Inboard Fixed Trailing Edge, Structural Pin Access Panel

Open these access panels on the Right side:

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

NOTE: Deploy flaps and spoilers to gain access.

SUBTASK 57-05-02-130-029

(2) Do an Ultrasonic inspection of the rear spar web at the trunnion attachment and main landing gear fitting locations from rib 1 to rib 27.

See Doc. D626A001 - DTR, DTR check form 57–20–24/25/26, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 4, Subject 57-10-11.

SUBTASK 57-05-02-410-022

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

Number	Name/Location
551AT	Upper Inboard Fixed Trailing Edge Access Panel
551BB	Lower Inboard Fixed Trailing Edge, Gear Adjustment Door
551CT	Upper Inboard Fixed Trailing Edge, Structural Pin Access Panel

Close these access panels on the Right side:

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

END OF TASK

TASK 57-05-02-250-863

89. INTERNAL - SPECIAL DETAILED: RIB 25 UPPER AND LOWER HORIZONTAL FLANGE

NOTE: This procedure is a scheduled maintenance task.

A. Inspection

SUBTASK 57-05-02-250-063

(1) Do a High Frequency Eddy Current inspection of the entire upper and lower chord horizontal flange from the front spar to the rear spar at WBL 616.75.

See Doc. D626A001 - DTR, DTR check form 57-20-29-1, for alternative inspection.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-10-40.

——— END OF TASK ———

LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-460, 464-999

TASK 57-05-02-250-865

90. EXTERNAL - SPECIAL DETAILED: RIB 27, UPPER AND LOWER RIB FLANGE TO SKIN ATTACHMENT

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
534	Left Wing - Dry Bay
634	Right Wing - Dry Bay

B. Inspection

SUBTASK 57-05-02-250-065

(1) Do a Low Frequency Eddy Current inspection of the entire upper and lower rib flange to skin attachment from the front spar to the rear spar at WBL 658.17.

See Doc. D626A001 - DTR, DTR check form 57–20–29–2, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-10-48.

——— END OF TASK ———

LOM ALL

TASK 57-05-02-250-867

91. INTERNAL - SPECIAL DETAILED: RIB 27, FRONT AND REAR SPAR TENSION FITTINGS

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
534	Left Wing - Dry Bay
634	Right Wing - Dry Bay

B. Inspection

NOTE: Fastener removal required.

SUBTASK 57-05-02-250-067

(1) Do a High Frequency Eddy Current inspection of the fasteners holes on the front and rear spar tension fitting at all eight fastener locations from the outboard side passing through rib 27.

See Doc. D626A001 - DTR, DTR check form 57–20–29–3, for alternative inspection.

——— END OF TASK ———

TASK 57-05-02-250-868

92. INTERNAL - SPECIAL DETAILED: FRONT SPAR LOWER CHORD (WEB FLANGE INSPECTIONS)

NOTE: This procedure is a scheduled maintenance task.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

A. Location Zones

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

B. Access Panels

Number	Name/Location
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
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

C. Inspection

SUBTASK 57-05-02-010-145

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

Number	Name/Location
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

Open these access panels on the Right side:

Number	Name/Location
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

SUBTASK 57-05-02-250-068

(2) Do a High Frequency Eddy Current inspection of the front spar lower chord at the non-hidden areas from rib 19 to rib 22.

See Doc. D626A001 - DTR, DTR check form 57-20-04-6, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-10-44.

SUBTASK 57-05-02-410-145

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

Number	Name/Location
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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Close these access panels on the Right side:

Number	Name/Location
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 ———

TASK 57-05-02-211-839

93. INTERNAL - DETAILED: STRUT TO WING ATTACHMENTS

Figure 231

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
431	Engine 1 - Forward Strut Fairing
434	Engine 1 - Aft Strut Fairing
441	Engine 2 - Forward Strut Fairing
444	Engine 2 - Aft Strut Fairing

B. Access Panels

Number	Name/Location
431CL	Forward Strut Fairing, Left Overwing Fairing, Strut 1
431CR	Forward Strut Fairing, Right Overwing Fairing, Strut 1
434BL	Aft Strut Fairing, Left Aft Panel, Strut 1
441CL	Forward Strut Fairing, Left Overwing Fairing, Strut 2
441CR	Forward Strut Fairing, Right Overwing Fairing, Strut 2

C. Inspection

SUBTASK 57-05-02-010-067

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

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

Open these access panels on the Right side:

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

SUBTASK 57-05-02-211-039

(2) Do a Detailed inspection of the links, fittings including the lugs, clevises, and pins.

See Doc. D626A001 - DTR, DTR check form 57–20–35, 57–20–36, 57–20–37, 57–20–38, 57–20–39, for alternative inspection.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 57-05-02-410-067

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

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

Close these access panels on the Right side:

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

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(LEFT WING IS SHOWN, RIGHT WING IS OPPOSITE)

A

3043533 S0000810611_V1

Strut to Wing Attachments
Figure 231/57-05-02-990-832

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-250-869

94. INTERNAL - SPECIAL DETAILED: IN-SPAR RIB, STATION 0, WINGLET

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
527	Left Winglet
627	Right Winglet

B. Inspection

NOTE: Removal of winglet and tension bolts is required.

SUBTASK 57-05-02-250-069

(1) Do a High Frequency Eddy Current inspection of all eighteen upper and lower tension bolt holes common to the winglet STA 0 Rib.

See Doc. D626A001 - DTR, DTR check form 57–31–02–1, for alternative inspection.

END OF TASK

TASK 57-05-02-250-871

95. INTERNAL - SPECIAL DETAILED: IN-SPAR RIB, STA 0 BOLT HOLES

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
527	Left Winglet
627	Right Winglet

B. Access Panels

Number	Name/Location
527AB	Winglet Access Panel
627AB	Winglet Access Panel

C. Inspection

SUBTASK 57-05-02-010-153

(1) Open this access panel on the Left side:

Number	Name/Location
527AB	Winglet Access Panel

Open this access panel on the Right side:

Number	Name/Location
627AB	Winglet Access Panel

NOTE: Removal of winglet and adjacent access panel is required. Remove 2 fasteners forward of the front spar common to the rib flange.

SUBTASK 57-05-02-250-071

(2) Do a High Frequency Eddy Current inspection of the in-spar lower flange of the winglet STA 0 (root) rib.

See Doc. D626A001 - DTR, DTR check form 57–31–02–2, for alternative inspection.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-10-72.

SUBTASK 57-05-02-410-153

(3) Close this access panel on the Left side:

Number	Name/Location
527AB	Winglet Access Panel

Close this access panel on the Right side:

Number	Name/Location
627AB	Winglet Access Panel

——— END OF TASK ———

TASK 57-05-02-250-872

96. EXTERNAL - SPECIAL DETAILED: FRONT SPAR LOWER CHORD (SKIN AND WEB FLANGE INSPECTIONS)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
534	Left Wing - Dry Bay
634	Right Wing - Dry Bay

B. Inspection

SUBTASK 57-05-02-250-072

(1) Do a Low Frequency Eddy Current inspection of the front spar lower chord from rib 25 to rib 27.

See Doc. D626A001 - DTR, DTR check form 57-20-04-10, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-10-54.

——— END OF TASK ———

TASK 57-05-02-211-841

97. INTERNAL - DETAILED: INBOARD ACTUATOR SUPPORT FITTINGS

Figure 232

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
552	Left Wing - Spoiler No. 6
652	Right Wing - Spoiler No. 7

B. Inspection

NOTE: Access requires deployment of inboard flaps.

SUBTASK 57-05-02-211-041

(1) Do a Detailed inspection of all the lugs of both support fittings on the inboard actuator support fittings on the main landing gear beam.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

See Doc. D626A001 - DTR, DTR check form 57–51–15, for alternative inspection

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

A

LEFT MAIN LANDING GEAR SUPPORT STRUCTURE (RIGHT SIDE IS OPPOSITE)

LEFT WING - INBOARD ACTUATOR SUPPORT FITTINGS

A

3042361 S0000809767_V1

Inboard Actuator Support Fittings
Figure 232/57-05-02-990-833

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-250-873

98. EXTERNAL - SPECIAL DETAILED: GEAR BEAM INBOARD SUPPORT FITTING

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

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

B. Inspection

SUBTASK 57-05-02-250-073

(1) Do a High Frequency Eddy Current inspection of the four main lugs on the inboard support fitting of the main landing gear beam.

See Doc. D626A001 - DTR, DTR check form 57–51–16, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-40-03.

——— **END OF TASK** ———

TASK 57-05-02-250-874

99. EXTERNAL - SPECIAL DETAILED: REAR SPAR LOWER CHORD (SKIN AND WEB FLANGE INSPECTIONS)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
534	Left Wing - Dry Bay
634	Right Wing - Dry Bay

B. Inspection

SUBTASK 57-05-02-250-074

(1) Do a Low Frequency Eddy Current inspection of the rear spar lower chord from rib 25 to rib 27.

See Doc. D626A001 - DTR, DTR check form 57-20-05-10, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-10-58.

——— **END OF TASK** ———

TASK 57-05-02-211-843

100. INTERNAL - DETAILED: TRACK #1 & #8 - OUTBOARD MAIN FLAP OUTBOARD TRACK

Figure 233

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
544	Left Wing - Fairing Flap Support No. 1
644	Right Wing - Fairing Flap Support No. 8

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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 57-05-02-010-069

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

Number	Name/Location
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:

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

SUBTASK 57-05-02-211-043

(2) Do a Detailed inspection of the outboard main flap, outboard track at WBL 357.7.

See Doc. D626A001 - DTR, DTR check form 57–53–01–1a, for alternative inspection.

SUBTASK 57-05-02-410-069

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

Number	Name/Location
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:

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

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Track #1 & #8 - Outboard Main Flap OutBoard Track
Figure 233/57-05-02-990-834

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-250-876

101. INTERNAL - SPECIAL DETAILED: UPPER WING PANEL AT SIDE-OF-BODY DOUBLE PLUS CHORD (DIRECTION 2)

NOTE: This procedure is a scheduled maintenance task.

A. 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
531	Left Wing - Center Fuel Tank, Rib 1 to Rib 5
631	Right Wing - Center Fuel Tank, Rib 1 to Rib 5

B. Access Panels

Number	Name/Location
131AB	Center Tank Access
531AB	Center Tank Access Door - Wing Station 168
631AB	Center Tank Access Door - Wing Station 168

C. Inspection

SUBTASK 57-05-02-010-167

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

Number	Name/Location
131AB	Center Tank Access
531AB	Center Tank Access Door - Wing Station 168

Open these access panels on the Right side:

Number	Name/Location
131AB	Center Tank Access
631AB	Center Tank Access Door - Wing Station 168

SUBTASK 57-05-02-250-076

(2) Do a High Frequency Eddy Current inspection of the forward skin-to-plus chord attachments at splice stringer S-14, BBL 70.85. Inspection is on both the inboard and outboard locations at BBL 70.85.

See Doc. D626A001 - DTR, DTR check form 57-20-13/-14/-15/-16/-17-2, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-10-34.

SUBTASK 57-05-02-410-167

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

Number	Name/Location
131AB	Center Tank Access
531AB	Center Tank Access Door - Wing Station 168

Close these access panels on the Right side:

Number	Name/Location
131AB	Center Tank Access
631AB	Center Tank Access Door - Wing Station 168

ECCN 9E991 BOEING PROPRIETARY - See title page for details

END OF TASK

TASK 57-05-02-211-845

102. INTERNAL - DETAILED: SUPPORT, FORWARD FITTING ASSY FLAP TRACKS 1, 2, 3, (6, 7, & 8)

Figure 234

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
542AB	Flap Support No. 3, Forward Assembly Access Panel
543AB	Flap Support No. 2 Access Panel, Forward Assembly
544AB	Flap Support No. 1 Access Panel, Forward Assembly
642AB	Flap Support No. 6, Forward Assembly Access Panel
643AB	Flap Support No. 7, Forward Assembly Access Panel
644AB	Flap Support No. 8, Forward Assembly Access Panel

C. Inspection

SUBTASK 57-05-02-010-070

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

Number	Name/Location
542AB	Flap Support No. 3, Forward Assembly Access Panel
543AB	Flap Support No. 2 Access Panel, Forward Assembly
544AB	Flap Support No. 1 Access Panel, Forward Assembly

Open these access panels on the Right side:

Number	Name/Location
642AB	Flap Support No. 6, Forward Assembly Access Panel
643AB	Flap Support No. 7, Forward Assembly Access Panel
644AB	Flap Support No. 8, Forward Assembly Access Panel

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

SUBTASK 57-05-02-211-045

(2) Do a Detailed inspection of the catcher attached to the forward fitting assembles for flap tracks right and left side at WBL 357.7, 254.0 and 164.0 on the inside bottom surface of the catcher.

See Doc. D626A001 - DTR, DTR check form 57–53–02, for alternative inspection.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 57-05-02-410-070

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

Number	Name/Location
542AB	Flap Support No. 3, Forward Assembly Access Panel
543AB	Flap Support No. 2 Access Panel, Forward Assembly
544AB	Flap Support No. 1 Access Panel, Forward Assembly

Close these access panels on the Right side:

Number	Name/Location
642AB	Flap Support No. 6, Forward Assembly Access Panel
643AB	Flap Support No. 7, Forward Assembly Access Panel
644AB	Flap Support No. 8, Forward Assembly Access Panel

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

FLAP TRACK 1
(FLAPS 2,3,6,7,8 ARE EQUIVALENT)

A

3042545 S0000809780_V1

Forward Fitting Assy Flap Tracks 1,2,3,4,5,6,7,8
Figure 234/57-05-02-990-835

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-211-847

103. INTERNAL - DETAILED: TRACK #2 & #7- OUTBOARD MAIN FLAP, INBOARD TRACK

Figure 235

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
543	Left Wing - Fairing Flap Support No. 2
643	Right Wing - Fairing Flap Support No. 7

B. Access Panels

Number	Name/Location
543AB	Flap Support No. 2 Access Panel, Forward Assembly
643AB	Flap Support No. 7, Forward Assembly Access Panel

C. Inspection

SUBTASK 57-05-02-010-071

(1) Open this access panel on the Left side:

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

Open this access panel on the Right side:

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

NOTE: For the aft portion of the track the flap must be deployed so the fairing clears the track. For the forward portion of the track the flap support fairing must be removed.

SUBTASK 57-05-02-211-047

(2) Do a Detailed inspection of the outboard main flap, inboard track at WBL 254.0.

See Doc. D626A001 - DTR, DTR check form 57–53–03–1a, for alternative inspection.

SUBTASK 57-05-02-410-071

(3) Close this access panel on the Left side:

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

Close this access panel on the Right side:

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

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

FLAP TRACK
(FLAP TRACK 2 ON THE LEFT WING IS SHOWN,
FLAP TRACK 7 ON THE RIGHT WING IS OPPOSITE)
(VIEW IN THE INBOARD DIRECTION)
(THE OUTBOARD SIDE IS SHOWN, THE INBOARD SIDE IS OPPOSITE)

A

FLAP TRACK
(EXAMPLE)

A-A

3043688 S0000810791_V1

Track #2 & #7 - Outboard Main Flap, Inboard Track
Figure 235/57-05-02-990-836

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-250-878

104. INTERNAL - SPECIAL DETAILED: UPPER WING PANEL AT SIDE-OF-BODY DOUBLE PLUS CHORD (DIRECTION 2)

NOTE: This procedure is a scheduled maintenance task.

A. 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
531	Left Wing - Center Fuel Tank, Rib 1 to Rib 5
631	Right Wing - Center Fuel Tank, Rib 1 to Rib 5

B. Access Panels

Number	Name/Location
131AB	Center Tank Access
531AB	Center Tank Access Door - Wing Station 168
631AB	Center Tank Access Door - Wing Station 168

C. Inspection

SUBTASK 57-05-02-010-169

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

Number	Name/Location
131AB	Center Tank Access
531AB	Center Tank Access Door - Wing Station 168

Open these access panels on the Right side:

Number	Name/Location
131AB	Center Tank Access
631AB	Center Tank Access Door - Wing Station 168

SUBTASK 57-05-02-250-078

(2) Do a High Frequency Eddy Current inspection of the aft skin-to-plus chord attachments at splice stringer S-14, BBL 70.85.

See Doc. D626A001 - DTR, DTR check form 57-20-13/-14/-15/-16/-17-2, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-10-34.

SUBTASK 57-05-02-410-169

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

Number	Name/Location
131AB	Center Tank Access
531AB	Center Tank Access Door - Wing Station 168

Close these access panels on the Right side:

Number	Name/Location
131AB	Center Tank Access
631AB	Center Tank Access Door - Wing Station 168

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-211-849

105. INTERNAL - DETAILED: TRACK #3 & #6- INBOARD MAIN FLAP, OUTBOARD TRACK

Figure 236

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
542	Left Wing - Fairing Flap Support No. 3
642	Right Wing - Fairing Flap Support No. 6

B. Access Panels

Number	Name/Location
542AB	Flap Support No. 3, Forward Assembly Access Panel
542BB	Flap Support No. 3, Aft Assembly Access Panel
642AB	Flap Support No. 6, Forward Assembly Access Panel
642BB	Flap Support No. 6, Aft Assembly Access Panel

C. Inspection

SUBTASK 57-05-02-010-072

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

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

Open these access panels on the Right side:

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

NOTE: For the aft portion of the track the flap must be deployed so the fairing clears the track. For the forward portion of the track the flap support fairing must be removed.

SUBTASK 57-05-02-211-049

(2) Do a Detailed inspection of the inboard main flap, outboard track at WBL 164.0.

See Doc. D626A001 - DTR, DTR check form 57–53–06–1a, for alternative inspection.

SUBTASK 57-05-02-410-072

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

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

Close these access panels on the Right side:

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

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

FLAP TRACK
(VIEW IN THE INBOARD DIRECTION, OUTBOARD SIDE.
INBOARD SIDE IS OPPOSITE)

A

FLAP TRACK
(EXAMPLE)
A-A

3045758 S0000812542_V1

Track 3 & 6 - Inboard Flap Support, Outboard Track
Figure 236/57-05-02-990-837

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-250-880

106. INTERNAL - SPECIAL DETAILED: UPPER WING PANEL AT SIDE-OF-BODY DOUBLE PLUS CHORD (DIRECTION 3)

NOTE: This procedure is a scheduled maintenance task.

A. 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
531	Left Wing - Center Fuel Tank, Rib 1 to Rib 5
631	Right Wing - Center Fuel Tank, Rib 1 to Rib 5

B. Access Panels

Number	Name/Location
131AB	Center Tank Access
531AB	Center Tank Access Door - Wing Station 168
631AB	Center Tank Access Door - Wing Station 168

C. Inspection

SUBTASK 57-05-02-010-209

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

Number	Name/Location
131AB	Center Tank Access
531AB	Center Tank Access Door - Wing Station 168

Open these access panels on the Right side:

Number	Name/Location
131AB	Center Tank Access
631AB	Center Tank Access Door - Wing Station 168

SUBTASK 57-05-02-250-080

(2) Do a Low Frequency Eddy Current inspection of the forward skin-to-plus chord attachments at splice stringer S-14, BBL 70.85.

See Doc. D626A001 - DTR, DTR check form 57-20-13/-14/-15/-16/-17-2, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-10-53.

SUBTASK 57-05-02-410-209

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

Number	Name/Location
131AB	Center Tank Access
531AB	Center Tank Access Door - Wing Station 168

Close these access panels on the Right side:

Number	Name/Location
131AB	Center Tank Access
631AB	Center Tank Access Door - Wing Station 168

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-130-831

107. INTERNAL - SPECIAL DETAILED: No. 4 and No. 5 SUPPORT, AFT LINK PINS

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
541	Left Wing - Fairing Flap Support No. 4
641	Right Wing - Fairing Flap Support No. 5

B. Inspection

NOTE: Inner pin removal required.

SUBTASK 57-05-02-130-031

(1) Do an Ultrasonic inspection of the inboard flap, inboard track aft link pins at WBL 64.0.

See Doc. D626A001 - DTR, DTR check form 57–53–09, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 4, Subject 57-50-05.

——— END OF TASK ———

TASK 57-05-02-211-851

108. INTERNAL - DETAILED: TRACK #4 & #5- INBOARD MAIN FLAP, INBOARD TRACK

Figure 237

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
53-51-21-000-801	Aft Wing-To-Body Fairing Panel Removal (P/B 401)
53-51-21-400-801	Aft Wing-To-Body Fairing Panel Installation (P/B 401)

B. Location Zones

Zone	Area
541	Left Wing - Fairing Flap Support No. 4
641	Right Wing - Fairing Flap Support No. 5

C. Access Panels

Number	Name/Location
194AL	Aft Wing To Body Fairing Panel
194AR	Aft Wing To Body Fairing Panel
194BL	Flap Track Lubrication Panel - Aft
194BR	Flap Track Lubrication Panel - Aft

D. Inspection

SUBTASK 57-05-02-010-073

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

Number	Name/Location
194AL	Aft Wing To Body Fairing Panel
194BL	Flap Track Lubrication Panel - Aft

NOTE: Side of body fairing must be removed to gain access. For HFEC inspections the carriage must be cycled to gain access.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(a) To open access panel 194BL, refer to task:Aft Wing-To-Body Fairing Panel Removal, TASK 53-51-21-000-801.

SUBTASK 57-05-02-010-228

(2) Open these access panels on the Right side:

Number	Name/Location
194AR	Aft Wing To Body Fairing Panel
194BR	Flap Track Lubrication Panel - Aft

NOTE: Side of body fairing must be removed to gain access. For HFEC inspections the carriage must be cycled to gain access.

(a) To open access panel 194BR, refer to task: Aft Wing-To-Body Fairing Panel Removal, TASK 53-51-21-000-801.

SUBTASK 57-05-02-211-051

(3) Do a Detailed inspection of the inboard main flap, inboard track at WBL 64.0.

See Doc. D626A001 - DTR, DTR check form 57–53–10–1a, for alternative inspection.

SUBTASK 57-05-02-410-073

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

Number	Name/Location
194AL	Aft Wing To Body Fairing Panel
194BL	Flap Track Lubrication Panel - Aft

(a) To close access panel 194BL, refer to task:Aft Wing-To-Body Fairing Panel Installation, TASK 53-51-21-400-801.

SUBTASK 57-05-02-410-227

(5) Close these access panels on the Right side:

Number	Name/Location
194AR	Aft Wing To Body Fairing Panel
194BR	Flap Track Lubrication Panel - Aft

(a) To close access panel 194BR, refer to task:Aft Wing-To-Body Fairing Panel Installation, TASK 53-51-21-400-801.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

**(FLAP TRACK 4 (LEFT SIDE) IS SHOWN,
FLAP TRACK 5 (RIGHT SIDE) IS OPPOSITE)**

**INBOARD FLAP TRACK NUMBER 4
(TRACK NUMBER 5 IS OPPOSITE)**

3045806 S0000812544_V1

**Track 4 & 5 - Inboard Flap Support, Inboard Track
Figure 237/57-05-02-990-838**

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-250-882

109. INTERNAL - SPECIAL DETAILED: UPPER WING PANEL AT SIDE-OF-BODY DOUBLE PLUS CHORD (DIRECTION 3)

NOTE: This procedure is a scheduled maintenance task.

A. 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
531	Left Wing - Center Fuel Tank, Rib 1 to Rib 5
631	Right Wing - Center Fuel Tank, Rib 1 to Rib 5

B. Access Panels

Number	Name/Location
131AB	Center Tank Access
531AB	Center Tank Access Door - Wing Station 168
631AB	Center Tank Access Door - Wing Station 168

C. Inspection

SUBTASK 57-05-02-010-171

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

Number	Name/Location
131AB	Center Tank Access
531AB	Center Tank Access Door - Wing Station 168

Open these access panels on the Right side:

Number	Name/Location
131AB	Center Tank Access
631AB	Center Tank Access Door - Wing Station 168

SUBTASK 57-05-02-250-082

(2) Do a Low Frequency Eddy Current inspection of the aft skin-to-plus chord attachments at splice stringer S-14, BBL 70.85.

See Doc. D626A001 - DTR, DTR check form 57-20-13/-14/-15/-16/-17-2, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-10-53.

SUBTASK 57-05-02-410-171

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

Number	Name/Location
131AB	Center Tank Access
531AB	Center Tank Access Door - Wing Station 168

Close these access panels on the Right side:

Number	Name/Location
131AB	Center Tank Access
631AB	Center Tank Access Door - Wing Station 168

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-250-883

110. INTERNAL - SPECIAL DETAILED: INBOARD MAIN FLAP FITTING ASSEMBLY FWD, INBOARD TRACK

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
53-51-21-000-801	Aft Wing-To-Body Fairing Panel Removal (P/B 401)
53-51-21-400-801	Aft Wing-To-Body Fairing Panel Installation (P/B 401)

B. Location Zones

Zone	Area
541	Left Wing - Fairing Flap Support No. 4
641	Right Wing - Fairing Flap Support No. 5

C. Access Panels

Number	Name/Location
194AL	Aft Wing To Body Fairing Panel
194AR	Aft Wing To Body Fairing Panel
194BL	Flap Track Lubrication Panel - Aft
194BR	Flap Track Lubrication Panel - Aft

D. Inspection

SUBTASK 57-05-02-010-162

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

Number	Name/Location
194AL	Aft Wing To Body Fairing Panel
194BL	Flap Track Lubrication Panel - Aft

NOTE: Flap track removal required to perform this inspection.

(a) To open access panel 194BL, refer to task: Aft Wing-To-Body Fairing Panel Removal, TASK 53-51-21-000-801.

SUBTASK 57-05-02-010-230

(2) Open these access panels on the Right side:

Number	Name/Location
194AR	Aft Wing To Body Fairing Panel
194BR	Flap Track Lubrication Panel - Aft

NOTE: Flap track removal required to perform this inspection.

(a) To open access panel 194BR, refer to task: Aft Wing-To-Body Fairing Panel Removal, TASK 53-51-21-000-801.

SUBTASK 57-05-02-250-083

(3) Do a High Frequency Eddy Current inspection of the primary lug of the inboard main flap forward fitting on the inboard track.

See Doc. D626A001 - DTR, DTR check form 57–53–11, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-50-20.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 57-05-02-410-162

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

Number	Name/Location
194AL	Aft Wing To Body Fairing Panel
194BL	Flap Track Lubrication Panel - Aft

(a) To close access panel 194BL, refer to task: Aft Wing-To-Body Fairing Panel Installation, TASK 53-51-21-400-801.

SUBTASK 57-05-02-410-229

(5) Close these access panels on the Right side:

Number	Name/Location
194AR	Aft Wing To Body Fairing Panel
194BR	Flap Track Lubrication Panel - Aft

(a) To close access panel 194BR, refer to task:Aft Wing-To-Body Fairing Panel Installation, TASK 53-51-21-400-801.

——— END OF TASK ———

TASK 57-05-02-250-884

111. INTERNAL - SPECIAL DETAILED: OUTBOARD WING REAR SPAR WEB TYPICAL DETAILS

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
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
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

B. Inspection

SUBTASK 57-05-02-250-084

(1) Do a High Frequency Eddy Current inspection of the outboard wing rear spar at the hidden areas from rib 1 to rib 27, except at locations covered by PSE 57-20-24/25/26.

See Doc. D626A001 - DTR, DTR check form 57-20-24-2, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-10-52.

——— END OF TASK ———

TASK 57-05-02-211-853

112. INTERNAL - DETAILED: FRONT SPAR UPPER CHORD

Figure 238

NOTE: This procedure is a scheduled maintenance task.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

A. Location Zones

Zone	Area
553	Left Wing - Inboard Flap
653	Right Wing - Inboard Flap

B. Access Panels

Number	Name/Location
553BB	Inboard Flap - Lower Skin
653BB	Inboard Flap - Lower Skin

C. Inspection

SUBTASK 57-05-02-010-074

(1) Open this access panel on the Left side:

Number	Name/Location
553BB	Inboard Flap - Lower Skin

Open this access panel on the Right side:

Number	Name/Location
653BB	Inboard Flap - Lower Skin

NOTE: Access requires removal of the inspar skin panel.

SUBTASK 57-05-02-211-053

(2) Do a Detailed inspection of the front spar upper chord trailing edge on the inboard main flap from Inboard Trailing Edge Flap (ITEF) main flap STA 73 to 167, away from the rib.

See Doc. D626A001 - DTR, DTR check form 57–53–12–1, for alternative inspection.

SUBTASK 57-05-02-410-074

(3) Close this access panel on the Left side:

Number	Name/Location
553BB	Inboard Flap - Lower Skin

Close this access panel on the Right side:

Number	Name/Location
653BB	Inboard Flap - Lower Skin

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

LEFT WING INBOARD MAIN FLAP
(LEFT WING INBOARD FLAP IS SHOWN,
RIGHT WING INBOARD FLAP IS OPPOSITE)

A

FRONT SPAR - UPPER CHORD

A-A

3045884 S0000812548_V1

Front Spar Upper Chord, Trailing Edge - Inboard Main Flap
Figure 238/57-05-02-990-839

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-250-885

113. INTERNAL - SPECIAL DETAILED: FRONT SPAR UPPER AND LOWER CHORD

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
553	Left Wing - Inboard Flap
653	Right Wing - Inboard Flap

B. Access Panels

Number	Name/Location
553BB	Inboard Flap - Lower Skin
653BB	Inboard Flap - Lower Skin

C. Inspection

SUBTASK 57-05-02-010-163

(1) Open this access panel on the Left side:

Number	Name/Location
553BB	Inboard Flap - Lower Skin

Open this access panel on the Right side:

Number	Name/Location
653BB	Inboard Flap - Lower Skin

SUBTASK 57-05-02-250-085

(2) Do a Low Frequency Eddy Current inspection of the front spar upper and lower chord on the trailing edge and the inboard main flap from Inboard Trailing Edge Flap (ITEF) main flap STA 73 to 168, at the rib location.

See Doc. D626A001 - DTR, DTR check form 57–53–12–2, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-50-32.

SUBTASK 57-05-02-410-163

(3) Close this access panel on the Left side:

Number	Name/Location
553BB	Inboard Flap - Lower Skin

Close this access panel on the Right side:

Number	Name/Location
653BB	Inboard Flap - Lower Skin

END OF TASK

TASK 57-05-02-210-820

114. INTERNAL - GENERAL VISUAL: FRONT SPAR CUTOUT/ FRONT SPAR FITTING

Figure 239

NOTE: This procedure is a scheduled maintenance task.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

A. Location Zones

Zone	Area
553	Left Wing - Inboard Flap
653	Right Wing - Inboard Flap

B. Access Panels

Number	Name/Location
553BB	Inboard Flap - Lower Skin
653BB	Inboard Flap - Lower Skin

C. Inspection

SUBTASK 57-05-02-010-049

(1) Open this access panel on the Left side:

Number	Name/Location
553BB	Inboard Flap - Lower Skin

Open this access panel on the Right side:

Number	Name/Location
653BB	Inboard Flap - Lower Skin

NOTE: Nose skin over the cutout must be removed, and flaps deployed.

SUBTASK 57-05-02-210-020

(2) Do a General Visual inspection of the front spar cutout /front spar fitting on the trailing edge, inboard main flap from Inboard Trailing Edge Flap (ITEF) main flap STA 155.00.

See Doc. D626A001 - DTR, DTR check form 57–53–12–3, for alternative inspection.

SUBTASK 57-05-02-410-049

(3) Close this access panel on the Left side:

Number	Name/Location
553BB	Inboard Flap - Lower Skin

Close this access panel on the Right side:

Number	Name/Location
653BB	Inboard Flap - Lower Skin

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Front Spar Cutout/Front Spar Fitting, Trailing Edge - Inboard Main Flap
Figure 239/57-05-02-990-840

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-210-821

115. INTERNAL - GENERAL VISUAL: UPPER WING PANEL SPLICE STRINGER

Figure 240

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

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

B. Inspection

SUBTASK 57-05-02-210-021

(1) Do a General Visual inspection of the upper wing panel splice stringer, S-14, from rib 12 to rib 21 at locations adjacent to the spar chord.

See Doc. D626A001 - DTR, DTR check form 57-20-15, for alternative inspection.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

PLAN VIEW OF OUTER WING UPPER SURFACE
(LEFT WING IS SHOWN, RIGHT WING IS OPPOSITE)

A

UPPER WING PANEL SPLICE STRINGER
(EXAMPLE)

A-A

3042313 S0000809731_V1

Upper Wing Panel Splice Stringer
Figure 240/57-05-02-990-814

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-211-855

116. INTERNAL - DETAILED: REAR SPAR CHORD AT INBD AND OUTBD CUTOUT

Figure 241

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
553	Left Wing - Inboard Flap
653	Right Wing - Inboard Flap

B. Access Panels

Number	Name/Location
553BB	Inboard Flap - Lower Skin
653BB	Inboard Flap - Lower Skin

C. Inspection

SUBTASK 57-05-02-010-076

(1) Open this access panel on the Left side:

Number	Name/Location
553BB	Inboard Flap - Lower Skin

Open this access panel on the Right side:

Number	Name/Location
653BB	Inboard Flap - Lower Skin

NOTE: Lower inspar skin panel removal is required.

SUBTASK 57-05-02-211-055

(2) Do a Detailed inspection of the upper and lower rear spar chord at the inboard and outboard cutout on the trailing edge inboard main flap at Inboard Trailing Edge Flap (ITEF) and main flap STA 85.225 and 143.3.

See Doc. D626A001 - DTR, DTR check form 57–53–13–1, for alternative inspection.

SUBTASK 57-05-02-410-076

(3) Close this access panel on the Left side:

Number	Name/Location
553BB	Inboard Flap - Lower Skin

Close this access panel on the Right side:

Number	Name/Location
653BB	Inboard Flap - Lower Skin

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

3043552 S0000810622_V1

Rear Spar Chord at Inboard and Outboard Cutout
Figure 241/57-05-02-990-841

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-211-857

117. INTERNAL - DETAILED: REAR SPAR CHORD AT INBD AND OUTBD PUSHROD CUTOUT

Figure 242

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
553	Left Wing - Inboard Flap
653	Right Wing - Inboard Flap

B. Access Panels

Number	Name/Location
553BB	Inboard Flap - Lower Skin
653BB	Inboard Flap - Lower Skin

C. Inspection

SUBTASK 57-05-02-010-078

(1) Open this access panel on the Left side:

Number	Name/Location
553BB	Inboard Flap - Lower Skin

Open this access panel on the Right side:

Number	Name/Location
653BB	Inboard Flap - Lower Skin

NOTE: Skin panel removal is required.

SUBTASK 57-05-02-211-057

(2) Do a Detailed inspection on the horizontal and vertical flanges up to the T-junction of the forward side of the rear spar upper and lower chords at the inboard and outboard pushrod cutout on the trailing edge, inboard main flap at Inboard Trailing Edge Flap (ITEF) main flap STA 91.5 and 149.0.

See Doc. D626A001 - DTR, DTR check form 57–53–13–2, for alternative inspection.

SUBTASK 57-05-02-410-078

(3) Close this access panel on the Left side:

Number	Name/Location
553BB	Inboard Flap - Lower Skin

Close this access panel on the Right side:

Number	Name/Location
653BB	Inboard Flap - Lower Skin

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Rear Spar Chord at Inboard and Outboard Pushrod Cutout
Figure 242/57-05-02-990-842

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-211-858

118. EXTERNAL - DETAILED: REAR SPAR CHORD AT INBOARD AND OUTBOARD PUSHROD CUTOUT

Figure 243

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
553	Left Wing - Inboard Flap
653	Right Wing - Inboard Flap

B. Access Panels

Number	Name/Location
553BB	Inboard Flap - Lower Skin
653BB	Inboard Flap - Lower Skin

C. Inspection

SUBTASK 57-05-02-010-080

(1) Open this access panel on the Left Side:

Number	Name/Location
553BB	Inboard Flap - Lower Skin

Open this access panel on the Right Side:

Number	Name/Location
653BB	Inboard Flap - Lower Skin

NOTE: Flap deployment is required.

SUBTASK 57-05-02-211-058

(2) Do a Detailed inspection on the horizontal and vertical flanges up to the T-junction of the aft side of the rear spar upper and lower chords at the inboard and outboard pushrod cutout on the trailing edge, inboard main flap at Inboard Trailing Edge Flap (ITEF) main flap STA 91.5 and 149.0.

See Doc. D626A001 - DTR, DTR check form 57-53-13-2, for alternative inspection.

SUBTASK 57-05-02-410-080

(3) Close this access panel on the Left Side:

Number	Name/Location
553BB	Inboard Flap - Lower Skin

Close this access panel on the Right Side:

Number	Name/Location
653BB	Inboard Flap - Lower Skin

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Rear Spar Chord at Inboard and Outboard Pushrod Cutout
Figure 243/57-05-02-990-843

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-211-861

119. INTERNAL - DETAILED: REAR SPAR UPPER CHORD

Figure 244

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
553	Left Wing - Inboard Flap
653	Right Wing - Inboard Flap

B. Access Panels

Number	Name/Location
553BB	Inboard Flap - Lower Skin
653BB	Inboard Flap - Lower Skin

C. Inspection

SUBTASK 57-05-02-010-082

(1) Open this access panel on the Left side:

Number	Name/Location
553BB	Inboard Flap - Lower Skin

Open this access panel on the Right side:

Number	Name/Location
653BB	Inboard Flap - Lower Skin

NOTE: Removal of skin panels is required.

SUBTASK 57-05-02-211-061

(2) Do a Detailed inspection of the rear spar upper chord on the trailing edge, inboard main flap from Inboard Trailing Edge Flap (ITEF) and main flap STA 73 to 167, away from the rib.

See Doc. D626A001 - DTR, DTR check form 57–53–13–3, for alternative inspection.

SUBTASK 57-05-02-410-082

(3) Close this access panel on the Left side:

Number	Name/Location
553BB	Inboard Flap - Lower Skin

Close this access panel on the Right side:

Number	Name/Location
653BB	Inboard Flap - Lower Skin

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

3043787 S0000810626_V1

Rear Spar Upper Chord. Trailing Edge - Main Flap
Figure 244/57-05-02-990-847

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-250-887

120. INTERNAL - SPECIAL DETAILED: REAR SPAR UPPER CHORD

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
553	Left Wing - Inboard Flap
653	Right Wing - Inboard Flap

B. Access Panels

Number	Name/Location
553BB	Inboard Flap - Lower Skin
653BB	Inboard Flap - Lower Skin

C. Inspection

SUBTASK 57-05-02-010-165

(1) Open this access panel on the Left side:

Number	Name/Location
553BB	Inboard Flap - Lower Skin

Open this access panel on the Right side:

Number	Name/Location
653BB	Inboard Flap - Lower Skin

SUBTASK 57-05-02-250-087

(2) Do a Low Frequency Eddy Current inspection of the rear spar upper chord on the trailing edge, inboard main flap from Inboard Trailing Edge Flap (ITEF) and main flap STA 73 to 167 at the rib.

See Doc. D626A001 - DTR, DTR check form 57–53–13–4, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-50-31.

SUBTASK 57-05-02-410-165

(3) Close this access panel on the Left side:

Number	Name/Location
553BB	Inboard Flap - Lower Skin

Close this access panel on the Right side:

Number	Name/Location
653BB	Inboard Flap - Lower Skin

——— END OF TASK ———

TASK 57-05-02-211-863

121. EXTERNAL - DETAILED: INBOARD MAIN FLAP - IN-SPAR UPPER SKIN PANELS

Figure 245

NOTE: This procedure is a scheduled maintenance task.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

A. Location Zones

Zone	Area
553	Left Wing - Inboard Flap
653	Right Wing - Inboard Flap

B. Inspection

SUBTASK 57-05-02-211-063

(1) Do a Detailed inspection of the skin at the rear spar chord, inboard main flap from Inboard Trailing Edge Flap (ITEF) and main flap STA 73 to 167.

See Doc. D626A001 - DTR, DTR check form 57–53–14, for alternative inspection.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Inbd Main Flap - Upper Inspar Skin Panels
Figure 245/57-05-02-990-815

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-250-889

122. INTERNAL - SPECIAL DETAILED: INBOARD MAIN FLAP, INBOARD TORQUE TUBE RIB

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
553	Left Wing - Inboard Flap
653	Right Wing - Inboard Flap

B. Access Panels

Number	Name/Location
553BB	Inboard Flap - Lower Skin
653BB	Inboard Flap - Lower Skin

C. Inspection

SUBTASK 57-05-02-010-183

(1) Open this access panel on the Left side:

Number	Name/Location
553BB	Inboard Flap - Lower Skin

Open this access panel on the Right side:

Number	Name/Location
653BB	Inboard Flap - Lower Skin

NOTE: Removal of flap lower skin is required for inspection.

SUBTASK 57-05-02-250-089

(2) Do a High Frequency Eddy Current inspection of the inboard main flap, inboard torque tube rib on the lower chord.

See Doc. D626A001 - DTR, DTR check form 57-53-17, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 57-50-27.

SUBTASK 57-05-02-410-183

(3) Close this access panel on the Left side:

Number	Name/Location
553BB	Inboard Flap - Lower Skin

Close this access panel on the Right side:

Number	Name/Location
653BB	Inboard Flap - Lower Skin

END OF TASK

TASK 57-05-02-210-822

123. INTERNAL - GENERAL VISUAL: INBD MAIN FLAP - TORQUE TUBE

Figure 246

NOTE: This procedure is a scheduled maintenance task.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

A. Location Zones

Zone	Area
553	Left Wing - Inboard Flap
653	Right Wing - Inboard Flap

B. Access Panels

Number	Name/Location
553BB	Inboard Flap - Lower Skin
653BB	Inboard Flap - Lower Skin

C. Inspection

SUBTASK 57-05-02-010-051

(1) Open this access panel on the Left side:

Number	Name/Location
553BB	Inboard Flap - Lower Skin

Open this access panel on the Right side:

Number	Name/Location
653BB	Inboard Flap - Lower Skin

SUBTASK 57-05-02-210-022

(2) Do a General Visual inspection of the inboard main flap torque tube on all of the exposed torque tube surfaces.

See Doc. D626A001 - DTR, DTR check form 57–53–20, for alternative inspection.

SUBTASK 57-05-02-410-051

(3) Close this access panel on the Left side:

Number	Name/Location
553BB	Inboard Flap - Lower Skin

Close this access panel on the Right side:

Number	Name/Location
653BB	Inboard Flap - Lower Skin

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

3043694 S0000810634_V1

Inbd Main Flap - Torque Tube
Figure 246/57-05-02-990-816

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-210-823

124. INTERNAL - GENERAL VISUAL: DOUBLE PLUS CHORD UPPER HORIZONTAL FLANGE

Figure 247

NOTE: This procedure is a scheduled maintenance task.

A. 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
195	Above Wing, Wing-To-Body Fairing - Left
196	Above Wing, Wing-To-Body Fairing - Right

B. Inspection

SUBTASK 57-05-02-210-023

NOTE: Inspection requires removal of the wing-to-body fairing and floor panels.

(1) Do a General Visual inspection of the upper horizontal flange at the double plus chord from the front spar to rear spar. Inspection is on both the inboard and outboard locations at BBL 70.85.

See Doc. D626A001 - DTR, DTR check form 57-10-05-4, for alternative inspection.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

3039990 S0000808196_V1

Double Plus Chord - Upper Horizontal Flange
Figure 247/57-05-02-990-844

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-250-891

125. INTERNAL - SPECIAL DETAILED: INBD MAIN FLAP, REAR SPAR

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
553	Left Wing - Inboard Flap
653	Right Wing - Inboard Flap

B. Access Panels

Number	Name/Location
553BB	Inboard Flap - Lower Skin
653BB	Inboard Flap - Lower Skin

C. Inspection

SUBTASK 57-05-02-010-185

(1) Open this access panel on the Left side:

Number	Name/Location
553BB	Inboard Flap - Lower Skin

Open this access panel on the Right side:

Number	Name/Location
653BB	Inboard Flap - Lower Skin

NOTE: Lower skin panel must be removed and the aft flap track pushrods disconnected to allow the aft flap tracks to extend to their stops.

SUBTASK 57-05-02-250-091

(2) Do a High Frequency Eddy Current inspection of all fitting cutout edge surfaces on the inboard main flap, rear spar aft flap track support assemblies at the Inboard Trailing Edge Flap (ITEF) and main flap STA 85 and 143.

See Doc. D626A001 - DTR, DTR check form 57-53-21, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 57-50-28.

SUBTASK 57-05-02-410-185

(3) Close this access panel on the Left side:

Number	Name/Location
553BB	Inboard Flap - Lower Skin

Close this access panel on the Right side:

Number	Name/Location
653BB	Inboard Flap - Lower Skin

END OF TASK

TASK 57-05-02-250-893

126. INTERNAL - SPECIAL DETAILED: INBD FLAP- No. 3 & No. 6 CARRIAGE ASSY

NOTE: This procedure is a scheduled maintenance task.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

A. Location Zones

Zone	Area
553	Left Wing - Inboard Flap
653	Right Wing - Inboard Flap

B. Access Panels

Number	Name/Location
542BB	Flap Support No. 3, Aft Assembly Access Panel
642BB	Flap Support No. 6, Aft Assembly Access Panel

C. Inspection

SUBTASK 57-05-02-010-187

(1) Open this access panel on the Left side:

Number	Name/Location
542BB	Flap Support No. 3, Aft Assembly Access Panel

Open this access panel on the Right side:

Number	Name/Location
642BB	Flap Support No. 6, Aft Assembly Access Panel

NOTE: The flaps must be deployed to gain inspection access. In addition, the roller assembly must be removed to gain access to the Inbd and Outbd side surface of the roller lug.

SUBTASK 57-05-02-250-093

(2) Do a High Frequency Eddy Current inspection of the forward and aft lug on the carriage assembly, WBL 164.0.

See Doc. D626A001 - DTR, DTR check form 57-53-22, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-50-35.

SUBTASK 57-05-02-410-187

(3) Close this access panel on the Left side:

Number	Name/Location
542BB	Flap Support No. 3, Aft Assembly Access Panel

Close this access panel on the Right side:

Number	Name/Location
642BB	Flap Support No. 6, Aft Assembly Access Panel

END OF TASK

TASK 57-05-02-250-895

127. INTERNAL - SPECIAL DETAILED: INBD FLAP - No. 4 & No. 5 CARRIAGE ASSY

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
53-51-21-000-801	Aft Wing-To-Body Fairing Panel Removal (P/B 401)
53-51-21-400-801	Aft Wing-To-Body Fairing Panel Installation (P/B 401)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

B. Location Zones

Zone	Area
553	Left Wing - Inboard Flap
653	Right Wing - Inboard Flap

C. Access Panels

Number	Name/Location
194AL	Aft Wing To Body Fairing Panel
194AR	Aft Wing To Body Fairing Panel
194BL	Flap Track Lubrication Panel - Aft
194BR	Flap Track Lubrication Panel - Aft

D. Inspection

SUBTASK 57-05-02-010-005

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

Number	Name/Location
194AL	Aft Wing To Body Fairing Panel
194BL	Flap Track Lubrication Panel - Aft

NOTE: The side of body fairing must be removed to gain access. In addition, the aft roller cartridge assembly must be removed to gain access to the inboard and outboard side surfaces of the aft roller lug.

(a) To open access panel 194BL, refer to task: Aft Wing-To-Body Fairing Panel Removal, TASK 53-51-21-000-801.

SUBTASK 57-05-02-010-231

(2) Open these access panels on the Right side:

Number	Name/Location
194AR	Aft Wing To Body Fairing Panel
194BR	Flap Track Lubrication Panel - Aft

NOTE: The side of body fairing must be removed to gain access. In addition, the aft roller cartridge assembly must be removed to gain access to the inboard and outboard side surfaces of the aft roller lug.

(a) To open access panel 194BR, refer to task: Aft Wing-To-Body Fairing Panel Removal, TASK 53-51-21-000-801.

SUBTASK 57-05-02-250-095

(3) Do a High Frequency Eddy Current inspection of the forward and aft lugs on the carriage plates, WBL 64.0.

See Doc. D626A001 - DTR, DTR check form 57-53-23-1, alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-50-36.

SUBTASK 57-05-02-410-005

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

Number	Name/Location
194AL	Aft Wing To Body Fairing Panel
194BL	Flap Track Lubrication Panel - Aft

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(a) To close access panel 194BL, refer to task: Aft Wing-To-Body Fairing Panel Installation, TASK 53-51-21-400-801.

SUBTASK 57-05-02-410-230

(5) Close these access panels on the Right side:

Number	Name/Location
194AR	Aft Wing To Body Fairing Panel
194BR	Flap Track Lubrication Panel - Aft

(a) To close access panel 194BR, refer to task:Aft Wing-To-Body Fairing Panel Installation, TASK 53-51-21-400-801.

END OF TASK

TASK 57-05-02-211-865

128. INTERNAL - DETAILED: INBD FLAP - NO.4 & NO.5 CARRIAGE ASSY

Figure 248

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
53-51-21-000-801	Aft Wing-To-Body Fairing Panel Removal (P/B 401)
53-51-21-400-801	Aft Wing-To-Body Fairing Panel Installation (P/B 401)

B. Location Zones

Zone	Area
553	Left Wing - Inboard Flap
653	Right Wing - Inboard Flap

C. Access Panels

Number	Name/Location
194AL	Aft Wing To Body Fairing Panel
194AR	Aft Wing To Body Fairing Panel
194BL	Flap Track Lubrication Panel - Aft
194BR	Flap Track Lubrication Panel - Aft

D. Inspection

SUBTASK 57-05-02-010-086

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

Number	Name/Location
194AL	Aft Wing To Body Fairing Panel
194BL	Flap Track Lubrication Panel - Aft

(a) To open access panel 194BL, refer to task: Aft Wing-To-Body Fairing Panel Removal, TASK 53-51-21-000-801.

SUBTASK 57-05-02-010-232

(2) Open these access panels on the Right side:

Number	Name/Location
194AR	Aft Wing To Body Fairing Panel
194BR	Flap Track Lubrication Panel - Aft

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(a) To open access panel 194BR, refer to task: Aft Wing-To-Body Fairing Panel Removal, TASK 53-51-21-000-801.

SUBTASK 57-05-02-211-065

(3) Do a Detailed inspection of the torque tube attachment hoop holes on the carriage plate, WBL 64.0.

See Doc. D626A001 - DTR, DTR check form 57–53–23–2, for alternative inspection.

SUBTASK 57-05-02-410-086

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

Number	Name/Location
194AL	Aft Wing To Body Fairing Panel
194BL	Flap Track Lubrication Panel - Aft

(a) To close access panel 194BL, refer to task: Aft Wing-To-Body Fairing Panel Installation, TASK 53-51-21-400-801.

SUBTASK 57-05-02-410-231

(5) Close these access panels on the Right side:

Number	Name/Location
194AR	Aft Wing To Body Fairing Panel
194BR	Flap Track Lubrication Panel - Aft

(a) To close access panel 194BR, refer to task: Aft Wing-To-Body Fairing Panel Installation, TASK 53-51-21-400-801.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

3043762 S0000810408_V1

Carriage Assembly #4 and #5 - Inboard Main Flap, Inboard Carriage
Figure 248/57-05-02-990-817

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-211-867

129. INTERNAL - DETAILED: INBOARD MAIN FLAP

Figure 249

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
53-51-21-000-801	Aft Wing-To-Body Fairing Panel Removal (P/B 401)
53-51-21-400-801	Aft Wing-To-Body Fairing Panel Installation (P/B 401)

B. Location Zones

Zone	Area
553	Left Wing - Inboard Flap
653	Right Wing - Inboard Flap

C. Access Panels

Number	Name/Location
194AL	Aft Wing To Body Fairing Panel
194AR	Aft Wing To Body Fairing Panel
194BL	Flap Track Lubrication Panel - Aft
194BR	Flap Track Lubrication Panel - Aft
544BB	Flap Support No. 1 Access Panel, Aft Assembly
644BB	Flap Support No. 8, Aft Assembly Access Panel

D. Inspection

SUBTASK 57-05-02-010-087

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

Number	Name/Location
194AL	Aft Wing To Body Fairing Panel
194BL	Flap Track Lubrication Panel - Aft
544BB	Flap Support No. 1 Access Panel, Aft Assembly

NOTE: Removal of rub pad attachment fastener is required.

(a) To open access panel 194BL, refer to task: Aft Wing-To-Body Fairing Panel Removal, TASK 53-51-21-000-801.

SUBTASK 57-05-02-010-233

(2) Open these access panels on the Right side:

Number	Name/Location
194AR	Aft Wing To Body Fairing Panel
194BR	Flap Track Lubrication Panel - Aft
644BB	Flap Support No. 8, Aft Assembly Access Panel

NOTE: Removal of rub pad attachment fastener is required

(a) To open access panel 194BRAft Wing-To-Body Fairing Panel Removal, TASK 53-51-21-000-801.

SUBTASK 57-05-02-211-067

(3) Do a Detailed inspection of the aft upper chord, rub pad hole on the inboard carriage.

See Doc. D626A001 - DTR, DTR check form 57–53–23–3, for alternative inspection.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 57-05-02-410-087

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

Number	Name/Location
194AL	Aft Wing To Body Fairing Panel
194BL	Flap Track Lubrication Panel - Aft
544BB	Flap Support No. 1 Access Panel, Aft Assembly

(a) To close access panel 194BL, refer to task:Aft Wing-To-Body Fairing Panel Installation, TASK 53-51-21-400-801.

SUBTASK 57-05-02-410-232

(5) Close these access panels on the Right side:

Number	Name/Location
194AR	Aft Wing To Body Fairing Panel
194BR	Flap Track Lubrication Panel - Aft
644BB	Flap Support No. 8, Aft Assembly Access Panel

(a) To close access panel 194BR, refer to task: Aft Wing-To-Body Fairing Panel Installation, TASK 53-51-21-400-801.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

3043763 S0000810409_V1

Carriage Assembly #4 and #5 - Inboard Main Flap, Inboard Carriage
Figure 249/57-05-02-990-818

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-250-897

130. INTERNAL - SPECIAL DETAILED: No. 1 & No. 8 CARRIAGE ASSEMBLY

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
567	Left Wing - Outboard Flap
667	Right Wing - Outboard Flap

B. Access Panels

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

C. Inspection

SUBTASK 57-05-02-010-004

(1) Open this access panel on the Left side:

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

Open this access panel on the Right side:

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

NOTE: Flaps must be deployed and roller pin assemblies removed.

SUBTASK 57-05-02-250-097

(2) Do a High Frequency Eddy Current inspection of the four outboard carriage roller bosses on the outboard main flap at WBL 357.7.

See Doc. D626A001 - DTR, DTR check form 57-53-24-1, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 57-50-23.

SUBTASK 57-05-02-410-004

(3) Close this access panel on the Left side:

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

Close this access panel on the Right side:

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

END OF TASK

TASK 57-05-02-250-899

131. INTERNAL - SPECIAL DETAILED: No. 1 & No. 8 CARRIAGE ASSEMBLY

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
567	Left Wing - Outboard Flap

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Zone	Area
667	Right Wing - Outboard Flap

B. Access Panels

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

C. Inspection

SUBTASK 57-05-02-010-003

(1) Open this access panel on the Left side:

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

Open this access panel on the Right side:

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

NOTE: The flaps must be deployed and the aft bridge fitting and bolts must be removed for inspection.

SUBTASK 57-05-02-250-099

(2) Do a High Frequency Eddy Current inspection of the holes in the carriage which attach the aft bridge fitting at the outboard carriage aft bridge support on the outboard main flap at WBL 357.7.

See Doc. D626A001 - DTR, DTR check form 57-53-24-2, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 57-50-23.

SUBTASK 57-05-02-410-003

(3) Close this access panel on the Left side:

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

Close this access panel on the Right side:

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

END OF TASK

TASK 57-05-02-250-901

132. INTERNAL - SPECIAL DETAILED: No. 2 & No. 7 CARRIAGE ASSEMBLY

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
567	Left Wing - Outboard Flap
667	Right Wing - Outboard Flap

ECCN 9E991 BOEING PROPRIETARY - See title page for details

B. Access Panels

Number	Name/Location
543BB	Flap Support No. 2 Access Panel, Aft Assembly
643BB	Flap Support No. 7, Aft Assembly Access Panel

C. Inspection

SUBTASK 57-05-02-010-001

(1) Open this access panel on the Left side:

Number	Name/Location
543BB	Flap Support No. 2 Access Panel, Aft Assembly

Open this access panel on the Right side:

Number	Name/Location
643BB	Flap Support No. 7, Aft Assembly Access Panel

NOTE: The flaps must be deployed and roller pin assemblies removed.

SUBTASK 57-05-02-250-101

(2) Do a High Frequency Eddy Current inspection of the four inboard carriage roller bosses on the outboard main flap at WBL 254.0.

See Doc. D626A001 - DTR, DTR check form 57-53-25-1, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 57-50-24.

SUBTASK 57-05-02-410-001

(3) Close this access panel on the Left side:

Number	Name/Location
543BB	Flap Support No. 2 Access Panel, Aft Assembly

Close this access panel on the Right side:

Number	Name/Location
643BB	Flap Support No. 7, Aft Assembly Access Panel

——— END OF TASK ———

TASK 57-05-02-250-903

133. INTERNAL - SPECIAL DETAILED: No. 2 & No. 7 CARRIAGE ASSEMBLY

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
567	Left Wing - Outboard Flap
667	Right Wing - Outboard Flap

B. Access Panels

Number	Name/Location
543BB	Flap Support No. 2 Access Panel, Aft Assembly
643BB	Flap Support No. 7, Aft Assembly Access Panel

ECCN 9E991 BOEING PROPRIETARY - See title page for details

C. Inspection

SUBTASK 57-05-02-010-002

(1) Open this access panel on the Left side:

Number	Name/Location
543BB	Flap Support No. 2 Access Panel, Aft Assembly

Open this access panel on the Right side:

Number	Name/Location
643BB	Flap Support No. 7, Aft Assembly Access Panel

NOTE: The flaps must be deployed and the aft bridge fitting and bolts must be removed for the inspection.

SUBTASK 57-05-02-250-103

(2) Do a High Frequency Eddy Current inspection of the holes in the carriage which attach the aft bridge fitting on the outboard main flap at WBL 254.0.

See Doc. D626A001 - DTR, DTR check form 57-53-25-2, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 57-50-24.

SUBTASK 57-05-02-410-002

(3) Close this access panel on the Left side:

Number	Name/Location
543BB	Flap Support No. 2 Access Panel, Aft Assembly

Close this access panel on the Right side:

Number	Name/Location
643BB	Flap Support No. 7, Aft Assembly Access Panel

END OF TASK

TASK 57-05-02-250-905

134. INTERNAL - SPECIAL DETAILED: FRONT SPAR ASSEMBLY - OUTBD MAIN FLAP

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
567	Left Wing - Outboard Flap
667	Right Wing - Outboard Flap

B. Inspection

NOTE: Deployment of flaps provides access at the carriage support ribs.

SUBTASK 57-05-02-250-105

(1) Do a Low Frequency Eddy Current inspection of the spar upper chord at the ribs from WBL 280 to WBL 327 and the spar lower chord at the ribs from WBL 254 to WBL 358.

See Doc. D626A001 - DTR, DTR check form 57-53-26-1, for alternative inspection.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-250-907

135. INTERNAL - SPECIAL DETAILED: FRONT SPAR ASSEMBLY - OUTBD MAIN FLAP

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
567	Left Wing - Outboard Flap
667	Right Wing - Outboard Flap

B. Access Panels

Number	Name/Location
567GT	Outboard Flap - Upper Skin
567HT	Outboard Flap - Upper Skin
667GT	Outboard Flap - Upper Skin
667HT	Outboard Flap - Upper Skin

C. Inspection

SUBTASK 57-05-02-010-195

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

Number	Name/Location
567GT	Outboard Flap - Upper Skin
567HT	Outboard Flap - Upper Skin

Open these access panels on the Right side:

Number	Name/Location
667GT	Outboard Flap - Upper Skin
667HT	Outboard Flap - Upper Skin

NOTE: Removal of the skin is required.

SUBTASK 57-05-02-250-107

(2) Do a High Frequency Eddy Current inspection of the spar upper chord between the ribs from WBL 280 to WBL 327 and the spar lower chord between the ribs from WBL 254 to WBL 358.

See Doc. D626A001 - DTR, DTR check form 57-53-26-2, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-50-34.

SUBTASK 57-05-02-410-195

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

Number	Name/Location
567GT	Outboard Flap - Upper Skin
567HT	Outboard Flap - Upper Skin

Close these access panels on the Right side:

Number	Name/Location
667GT	Outboard Flap - Upper Skin
667HT	Outboard Flap - Upper Skin

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-250-909

136. INTERNAL - SPECIAL DETAILED: REAR SPAR - OUTBD MAIN FLAP

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
567	Left Wing - Outboard Flap
667	Right Wing - Outboard Flap

B. Access Panels

Number	Name/Location
567GT	Outboard Flap - Upper Skin
567HT	Outboard Flap - Upper Skin
667GT	Outboard Flap - Upper Skin
667HT	Outboard Flap - Upper Skin

C. Inspection

SUBTASK 57-05-02-010-197

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

Number	Name/Location
567GT	Outboard Flap - Upper Skin
567HT	Outboard Flap - Upper Skin

Open these access panels on the Right side:

Number	Name/Location
667GT	Outboard Flap - Upper Skin
667HT	Outboard Flap - Upper Skin

NOTE: Internal access is required. Removal of the flap upper skin is required to gain access. The aft flap track pushrods need to be disconnected to allow the aft flap tracks to extend to their stops.

SUBTASK 57-05-02-250-109

(2) Do a High Frequency Eddy Current inspection of the aft flap track cutouts 2&3 at the rear spar outboard main flap.

See Doc. D626A001 - DTR, DTR check form 57-53-27-1, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-50-21.

SUBTASK 57-05-02-410-197

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

Number	Name/Location
567GT	Outboard Flap - Upper Skin
567HT	Outboard Flap - Upper Skin

Close these access panels on the Right side:

Number	Name/Location
667GT	Outboard Flap - Upper Skin
667HT	Outboard Flap - Upper Skin

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-250-911

137. EXTERNAL - SPECIAL DETAILED: REAR SPAR - OUTBD MAIN FLAP

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
567	Left Wing - Outboard Flap
667	Right Wing - Outboard Flap

B. Inspection

NOTE: Deployment of flaps provides access at the carriage support ribs.

SUBTASK 57-05-02-250-111

(1) Do a Low Frequency Eddy Current inspection of the rear spar upper chord at the ribs from WBL 280 to WBL 327 and the rear spar lower chord at the ribs from WBL 254 to WBL 358.

See Doc. D626A001 - DTR, DTR check form 57-53-27-2, for alternative inspection.

END OF TASK

TASK 57-05-02-250-913

138. INTERNAL - SPECIAL DETAILED: REAR SPAR - OUTBD MAIN FLAP

NOTE: This procedure is a scheduled maintenance task.

A. Access Panels

Number	Name/Location
567GT	Outboard Flap - Upper Skin
567HT	Outboard Flap - Upper Skin
667GT	Outboard Flap - Upper Skin
667HT	Outboard Flap - Upper Skin

B. Inspection

SUBTASK 57-05-02-010-199

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

Number	Name/Location
567GT	Outboard Flap - Upper Skin
567HT	Outboard Flap - Upper Skin

Open these access panels on the Right side:

Number	Name/Location
667GT	Outboard Flap - Upper Skin
667HT	Outboard Flap - Upper Skin

NOTE: Removal of flap upper skin panel is required for access.

SUBTASK 57-05-02-250-113

(2) Do a High Frequency Eddy Current inspection of the rear spar upper chord between the ribs from WBL 280 to WBL 327 and the rear spar lower chord between the ribs from WBL 254 to WBL 358.

See Doc. D626A001 - DTR, DTR check form 57-53-27-3, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-50-34.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 57-05-02-410-199

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

Number	Name/Location
567GT	Outboard Flap - Upper Skin
567HT	Outboard Flap - Upper Skin

Close these access panels on the Right side:

Number	Name/Location
667GT	Outboard Flap - Upper Skin
667HT	Outboard Flap - Upper Skin

END OF TASK

TASK 57-05-02-250-915

139. EXTERNAL - SPECIAL DETAILED: LOWER SKIN - OUTBD MAIN FLAP, FRONT SPAR AND REAR SPAR LWR CHORD - LWR SKIN INTERFACE

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
567	Left Wing - Outboard Flap
667	Right Wing - Outboard Flap

B. Inspection

NOTE: Deployment of flaps provides access at the carriage support ribs.

SUBTASK 57-05-02-250-115

(1) Do a High Frequency Eddy Current inspection of the external surface of the outboard main flap lower skin at the skin-to-chord fastener locations at both the front and rear spar, WBL 254 to WBL 358.

See Doc. D626A001 - DTR, DTR check form 57-53-29, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-50-29.

END OF TASK

TASK 57-05-02-240-801

140. INTERNAL - SPECIAL DETAILED: FRONT SPAR SPIGOT FITTING - OUTBD MAIN FLAP

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
567	Left Wing - Outboard Flap

B. Inspection

NOTE: Access requires removal of the flap from the carriages.

SUBTASK 57-05-02-240-001

(1) Do a Magnetic Particle inspection of the front spar spigot fitting at the surface of the fitting shaft at WBL 254.0 and WBL 358.0.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

See Doc. D626A001 - DTR, DTR check form PSE 57–53–31, for alternative inspection.

END OF TASK

TASK 57-05-02-211-877

141. INTERNAL - DETAILED: REAR SPAR SPIGOT FITTING - OUTBD MAIN FLAP

Figure 250

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
567	Left Wing - Outboard Flap
667	Right Wing - Outboard Flap

B. Inspection

NOTE: Flap deployment is required to gain access.

SUBTASK 57-05-02-211-069

(1) Do a Detailed inspection of the carriage aft link assembly (aft spigot fitting, aft link, aft bridge fitting clevis, aft pin) at WBL 254.0 and 358.0.

See Doc. D626A001-DTR, DTR check form 57-53-32, for alternative inspections.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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Rear Spar Spigot Fitting - Outbd Main Flap
Figure 250/57-05-02-990-819

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-211-871

142. INTERNAL - DETAILED: AFT FLAP TRACK SUPPORT RIBS #2 AND #3

A. Location Zones

Zone	Area
567	Left Wing - Outboard Flap
667	Right Wing - Outboard Flap

B. Access Panels

Number	Name/Location
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
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

C. Inspection

SUBTASK 57-05-02-010-088

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

Number	Name/Location
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

Open these access panels on the Right side:

Number	Name/Location
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

NOTE: Flaps deployed and the lower cove panels removed for access.

SUBTASK 57-05-02-211-071

(2) Do a Detailed inspection of the lower flanges of ribs #2 and #3 on each aft flap track support ribs from WBL 254.0 and 358.0.

See Doc. D626A001 - DTR, DTR check form 57–53–35, for alternative inspection.

SUBTASK 57-05-02-410-088

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

Number	Name/Location
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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Close these access panels on the Right side:

Number	Name/Location
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

——— END OF TASK ———

TASK 57-05-02-211-873

143. INTERNAL - DETAILED: HINGE/ACTUATOR FITTINGS

Figure 251

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
552	Left Wing - Spoiler No. 6
652	Right Wing - Spoiler No. 7

B. Inspection

NOTE: Access requires deployment of inboard flap.

SUBTASK 57-05-02-211-073

(1) Do a Detailed inspection of the lugs on both hinge/actuator fittings on the inboard spoiler. See Doc. D626A001 - DTR, DTR check form 57–70–01, for alternative inspection.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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Hinge/Actuator Fittings
Figure 251/57-05-02-990-820

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-130-833

144. INTERNAL - SPECIAL DETAILED: LOWER WING PANEL, RAIL STRINGER

A. 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
632	Right Wing - Main Tank, Rib 5 to Rib 22, Wing Station 204.25 to Wing Station 643.50

B. Inspection

SUBTASK 57-05-02-130-033

(1) Do the inspection (Ultrasonic) of the stringer S-8 from rib 6 to rib 7 at the areas hidden by the nacelle support strut attachment fitting.

NOTE: See Doc. D626A001 - DTR, DTR check form 57–20–02–3, for alternative inspection.

——— END OF TASK ———

TASK 57-05-02-211-875

145. INTERNAL - SPECIAL DETAILED: LOWER WING PANEL, SPLICE STRINGERS (DIRECTION 3)

NOTE: This procedure is a scheduled maintenance task.

A. 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
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

B. 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
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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

C. Inspection

SUBTASK 57-05-02-010-089

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

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

Open these access panels on the Right side:

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

SUBTASK 57-05-02-211-075

(2) Do a High Frequency Eddy Current inspection of the lower wing panel splice stringers, S-5 and S-9, from rib 1 to rib 10 at the non-hidden areas under the fairing.

See Doc. D626A001 - DTR, DTR check form 57–20–03–2, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-10-33.

SUBTASK 57-05-02-410-089

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

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

Close these access panels on the Right side:

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

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-250-917

146. INTERNAL - SPECIAL DETAILED: LOWER WING PANEL, SPLICE STRINGERS (DIRECTION 4)

NOTE: This procedure is a scheduled maintenance task.

A. 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
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

B. 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
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

C. Inspection

SUBTASK 57-05-02-010-213

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

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

Open these access panels on the Right side:

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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 57-05-02-250-117

(2) Do a High Frequency Eddy Current inspection of the lower wing panel splice stringers, S-5 and S-9, from rib 1 to rib 10 at the non-hidden areas under the fairing.

See Doc. D626A001 - DTR, DTR check form 57-20-03-2, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-10-33.

SUBTASK 57-05-02-410-213

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

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

Close these access panels on the Right side:

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

——— END OF TASK ———

TASK 57-05-02-200-801

147. INTERNAL - SPECIAL DETAILED:LEFT LOWER WING PANEL RAIL STRINGER

A. References

Reference	Title
54-53-01-000-801	Strut Access Panel Removal (P/B 401)
54-53-01-400-801	Strut Access Panel Installation (P/B 401)

B. Location Zones

Zone	Area
342	Right Horizontal Stab - Front Spar to Rear Spar, Stab Sta 57.93 to Stab BL 281.81
343	Right Horizontal Stabilizer - Rear Spar to Trailing Edge
443	Engine 2 - Strut Torque Box
527	Left Winglet
567	Left Wing - Outboard Flap
627	Right Winglet

C. Access Panels

Number	Name/Location
343DB	Horizontal Stabilizer, Access Panel - T.E. Area
343EB	Horizontal Stabilizer, Access Panel - T.E. Area

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
343FB	Horizontal Stabilizer, Access Panel - T.E. Area
441BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 2
441BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 2
441CL	Forward Strut Fairing, Left Overwing Fairing, Strut 2
441CR	Forward Strut Fairing, Right Overwing Fairing, Strut 2
443AT	Strut, Forward Spar Web, Strut 2
443BT	Strut, Forward Spar Web, Strut 2
443CT	Strut, Upper Spar Web, Strut 2
443DT	Strut, Upper Spar Web, Strut 2
527AB	Winglet Access Panel

D. Inspection

SUBTASK 57-05-02-010-034

(1) Open these access panels:

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

SUBTASK 57-05-02-010-237

(2) Open these access panels:

(TASK 54-53-01-000-801)

Number	Name/Location
443AT	Strut, Forward Spar Web, Strut 2
443BT	Strut, Forward Spar Web, Strut 2
443CT	Strut, Upper Spar Web, Strut 2
443DT	Strut, Upper Spar Web, Strut 2

SUBTASK 57-05-02-200-001

(3) Do the inspection (High Frequency Eddy Current) of the upper spar chord between the forward and aft engine mounts at the following locations: Nacelle STA 200.9 - 211.5 on the left hand chords, Nacelle STA 213.6 - 225.2 on the left hand chords, Nacelle STA 226.1 - 233.6 on the left hand chords, and Nacelle STA 236.3 - 241.8 on the left and right hand chords.

NOTE: See Doc. D626A001 - DTR, DTR check form 54–51–17, for alternative inspection.

SUBTASK 57-05-02-410-034

(4) Close these access panels:

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

SUBTASK 57-05-02-410-236

(5) Close these access panels:

(TASK 54-53-01-400-801)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Number	Name/Location
443AT	Strut, Forward Spar Web, Strut 2
443BT	Strut, Forward Spar Web, Strut 2
443CT	Strut, Upper Spar Web, Strut 2
443DT	Strut, Upper Spar Web, Strut 2

SUBTASK 57-05-02-010-035

(6) Open these access panels:

Number	Name/Location
343DB	Horizontal Stabilizer, Access Panel - T.E. Area
343EB	Horizontal Stabilizer, Access Panel - T.E. Area
343FB	Horizontal Stabilizer, Access Panel - T.E. Area

NOTE: Removal of the lower composite skin panel is required.

SUBTASK 57-05-02-130-037

(7) Do the inspection (Low Frequency Eddy Current) around the fasteners that attach the aluminum skin panel to the forward flange at elevator STA 213.32, 250.04, 265.45 and stab. BL 254.66 on the horizontal stabilizer rear spar.

NOTE: See Doc. D626A001 - DTR, DTR check form 55–10–04–3, for alternative inspection.

SUBTASK 57-05-02-410-035

(8) Close these access panels:

Number	Name/Location
343DB	Horizontal Stabilizer, Access Panel - T.E. Area
343EB	Horizontal Stabilizer, Access Panel - T.E. Area
343FB	Horizontal Stabilizer, Access Panel - T.E. Area

SUBTASK 57-05-02-010-036

(9) Open this access panel:

Number	Name/Location
527AB	Winglet Access Panel

NOTE: Winglet and Winglet Barrel Nuts removal is required.

SUBTASK 57-05-02-130-038

(10) Do the inspection (High Frequency Eddy Current) of the barrel nut bores, upper and lower, common to winglet STA 0 rib.

NOTE: See Doc. D626A001 - DTR, DTR check form 57–31–02, for alternative inspection.

SUBTASK 57-05-02-410-036

(11) Close this access panel:

Number	Name/Location
527AB	Winglet Access Panel

SUBTASK 57-05-02-130-039

NOTE: Deployment of flaps required to gain access.

(12) Do the inspection (Detailed) of the #1 Carriage Aft Link (WBL 357.7) for obvious damage. (If failure has occurred, it will be necessary to replace the entire failsafe assembly, consisting of the failsafe spigot, failsafe link, failsafe clevis and the clevis pin, as well as the failed aft link, to maintain DTR.)

NOTE: See Doc. D626A001 - DTR, DTR check form 57–53–33, for alternative inspection.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 57-05-02-130-040

NOTE: Deployment of flaps required to gain access.

(13) Do the inspection (Detailed) of the #1 Carriage Aft Link (WBL 254.0) for obvious damage. (If failure has occurred, it will be necessary to replace the entire failsafe assembly, consisting of the failsafe spigot, failsafe link, failsafe clevis and the clevis pin, as well as the failed aft link, to maintain DTR.)

NOTE: See Doc. D626A001 - DTR, DTR check form 57–53–34, for alternative inspection.

END OF TASK

TASK 57-05-02-200-802

148. INTERNAL - SPECIAL DETAILED: RIGHT LOWER WING PANEL RAIL STRINGE

A. Inspection

SUBTASK 57-05-02-200-002

(1) Do the inspection.

END OF TASK

TASK 57-05-02-200-803

149. EXTERNAL - SPECIAL DETAILED: LEFT LOWER WING PANEL SPLICE STRINGERS

A. Inspection

SUBTASK 57-05-02-200-003

(1) Do the inspection.

END OF TASK

TASK 57-05-02-200-804

150. EXTERNAL - SPECIAL DETAILED: RIGHT LOWER WING PANEL SPLICE STRINGERS

A. Inspection

SUBTASK 57-05-02-200-004

(1) Do the inspection.

END OF TASK

TASK 57-05-02-200-805

151. INTERNAL - HIGH FREQUENCY EDDY CURRENT: LEFT LOWER WING PANEL SPLICE STRINGERS

A. Inspection

SUBTASK 57-05-02-200-005

(1) Do the inspection.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-200-806

152. INTERNAL - HIGH FREQUENCY EDDY CURRENT: RIGHT LOWER WING PANEL SPLICE STRINGERS

A. Inspection

SUBTASK 57-05-02-200-006

(1) Do the inspection.

END OF TASK

TASK 57-05-02-200-807

153. INTERNAL - SPECIAL DETAILED:LEFT LOWER WING PANEL UNDER NACELLE FITTINGS

A. Inspection

SUBTASK 57-05-02-200-007

(1) Do the inspection.

END OF TASK

TASK 57-05-02-200-808

154. INTERNAL - SPECIAL DETAILED: RIGHT LOWER WING PANEL UNDER NACELLE FITTINGS

A. Inspection

SUBTASK 57-05-02-200-008

(1) Do the inspection.

END OF TASK

TASK 57-05-02-250-919

155. EXTERNAL - SPECIAL DETAILED: SPAR CHORDS AT CHORDWISE SKIN SPLICES (UPPER AND LOWER PANEL)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

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

B. Inspection

SUBTASK 57-05-02-250-120

(1) Do a Low Frequency Eddy Current inspection of the front spar lower chord from rib 17 to rib 18, the rear spar lower chord from rib 18 to rib 19, and the front spar upper chord from rib 19 to rib 20.

See Doc. D626A001 - DTR, DTR check form 57-20-04 / 05 / 16, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-10-60.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-250-920

156. INTERNAL - SPECIAL DETAILED: LOWER SKIN PANEL AT MAIN LANDING GEAR OUTBOARD SUPPORT FITTINGS

A. Inspection

SUBTASK 57-05-02-250-121

(1) Do the inspection.

——— END OF TASK ———

TASK 57-05-02-130-835

157. INTERNAL - SPECIAL DETAILED: SKIN AT NACELLE SUPPORT FITTING ATTACHMENTS

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
54-52-04 P/B 401	AFT FAIRING - REMOVAL/INSTALLATION
54-52-06-010-801	Aft Fairing Access Panel Removal (P/B 401)
54-52-06-410-801	Aft Fairing Access Panel Installation (P/B 401)

B. Location Zones

Zone	Area
434	Engine 1 - Aft Strut Fairing
444	Engine 2 - Aft Strut Fairing
532	Left Wing - Main Tank, Rib 5 to Rib 22, Wing Station 204.25 to Wing BL 643.50
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
431EL	Forward Strut Fairing, Left T.R. Strut Fairing, Strut 1
431ER	Forward Strut Fairing, Right T.R. Strut Fairing, Strut 1
434AL	Aft Strut Fairing, Left Forward Panel, Strut 1
434AR	Aft Strut Fairing, Right Forward Panel, Strut 1
434BL	Aft Strut Fairing, Left Aft Panel, Strut 1
441EL	Forward Strut Fairing, Left T.R. Strut Fairing, Strut 2
441ER	Forward Strut Fairing, Right T.R. Strut Fairing, Strut 2
444AL	Aft Strut Fairing, Left Forward Panel, Strut 2
444AR	Aft Strut Fairing, Right Forward Panel, Strut 2
444BR	Aft Strut Fairing, Right Aft Panel, Strut 2

D. Inspection

SUBTASK 57-05-02-010-160

(1) Remove these aft fairing access panels, refer to Aft Fairing Access Panel Removal, TASK 54-52-06-010-801:

(a) Remove these access panels on the Left side:

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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
434BL	Aft Strut Fairing, Left Aft Panel, Strut 1

(b) Remove these access panels on the Right side:

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

SUBTASK 57-05-02-010-235

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

(a) Remove these access panels on the Left side:

Number	Name/Location
431EL	Forward Strut Fairing, Left T.R. Strut Fairing, Strut 1
431ER	Forward Strut Fairing, Right T.R. Strut Fairing, Strut 1

(b) Remove these access panels on the Right side:

Number	Name/Location
441EL	Forward Strut Fairing, Left T.R. Strut Fairing, Strut 2
441ER	Forward Strut Fairing, Right T.R. Strut Fairing, Strut 2

SUBTASK 57-05-02-010-224

(3) Remove aft fairing: AFT FAIRING - REMOVAL/INSTALLATION, PAGEBLOCK 54-52-04/401.

SUBTASK 57-05-02-130-035

(4) Do an Ultrasonic inspection of the lower wing skin at the R2, R3 and R4 nacelle fitting attachments.

See Doc. D626A001 - DTR, DTR check form 57-20-09, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 4, Subject 57-10-06.

SUBTASK 57-05-02-410-223

(5) Install aft fairing: AFT FAIRING - REMOVAL/INSTALLATION, PAGEBLOCK 54-52-04/401.

SUBTASK 57-05-02-410-160

(6) Install these aft fairing access panels, refer to Aft Fairing Access Panel Installation, TASK 54-52-06-410-801:

(a) Install these access panels on the Left side:

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

(b) Install these access panels on the Right side:

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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 57-05-02-410-234

(7) Install these FWD fairing access panels:

(a) Install these access panels on the Left side:

Number	Name/Location
431EL	Forward Strut Fairing, Left T.R. Strut Fairing, Strut 1
431ER	Forward Strut Fairing, Right T.R. Strut Fairing, Strut 1

(b) Install these access panels on the Right side:

Number	Name/Location
441EL	Forward Strut Fairing, Left T.R. Strut Fairing, Strut 2
441ER	Forward Strut Fairing, Right T.R. Strut Fairing, Strut 2

——— END OF TASK ———

TASK 57-05-02-210-824

158. INTERNAL- GENERAL VISUAL: DOUBLE PLUS CHORD UPPER VERTICAL FLANGE

Figure 252

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
195	Above Wing, Wing-To-Body Fairing - Left
196	Above Wing, Wing-To-Body Fairing - Right

B. Inspection

NOTE: Inspection requires removal of wing-to-body fairing.

SUBTASK 57-05-02-210-024

(1) Do a General Visual inspection of the upper vertical flange at the double plus chord forward of STA 639.

See Doc. D626A001 - DTR, DTR check form 57-10-05-6, for alternative inspection.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

DOUBLE PLUS CHORD

A

INSPECTION AREA OF THE DOUBLE PLUS CHORD

A-A

3040400 S0000808435_V1

Double Plus Chord Upper Vertical Flange
Figure 252/57-05-02-990-821

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-250-921

159. INTERNAL- SPECIAL DETAILED: DOUBLE PLUS CHORD UPPER VERTICAL FLANGE

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
195	Above Wing, Wing-To-Body Fairing - Left
196	Above Wing, Wing-To-Body Fairing - Right

B. Inspection

NOTE: Inspection requires removal of wing-to-body fairing.

SUBTASK 57-05-02-250-125

(1) Do a High Frequency Eddy Current inspection of the upper vertical flange at the double plus chord forward of STA 639.

See Doc. D626A001 - DTR, DTR check form 57-10-05-6, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Section 57-10-77.

——— END OF TASK ———

TASK 57-05-02-250-922

160. INTERNAL - SPECIAL DETAILED: WCS REAR SPAR TYPICAL WEB LOCATIONS (NON-HIDDEN LOCATIONS)

NOTE: This procedure is a scheduled maintenance task.

A. 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
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

B. Access Panels

Number	Name/Location
131AB	Center Tank Access

C. Inspection

SUBTASK 57-05-02-250-126

(1) Open this access panel:

Number	Name/Location
131AB	Center Tank Access

(2) Do a Low Frequency Eddy Current inspection of the web common to the fuel tank from LBBL 70.85 to RBBL 70.85.

See Doc. D626A001 - DTR, DTR check form 57–10–17–2, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-10-81.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(3) Close this access panel:

Number	Name/Location
131AB	Center Tank Access

——— END OF TASK ———

TASK 57-05-02-250-923

161. INTERNAL - SPECIAL DETAILED: UPPER WING PANEL AT SIDE-OF-BODY DOUBLE PLUS CHORD

NOTE: This procedure is a scheduled maintenance task.

A. 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
531	Left Wing - Center Fuel Tank, Rib 1 to Rib 5
631	Right Wing - Center Fuel Tank, Rib 1 to Rib 5

B. Access Panels

Number	Name/Location
131AB	Center Tank Access
531AB	Center Tank Access Door - Wing Station 168
531BB	Center Tank Access Door - Wing Station 192
631AB	Center Tank Access Door - Wing Station 168
631BB	Center Tank Access Door - Wing Station 192

C. Inspection

SUBTASK 57-05-02-250-127

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

Number	Name/Location
131AB	Center Tank Access
531AB	Center Tank Access Door - Wing Station 168
531BB	Center Tank Access Door - Wing Station 192

Open these access panels on the Right side:

Number	Name/Location
131AB	Center Tank Access
631AB	Center Tank Access Door - Wing Station 168
631BB	Center Tank Access Door - Wing Station 192

SUBTASK 57-05-02-250-128

(2) Do a High Frequency Eddy Current inspection of the upper skin-to-plus chord attachment at BBL 70.85. Inspection is on both the inboard and outboard locations at BBL 70.85.

See Doc. D626A001 - DTR, DTR check form 57-20-13/-14/-15/-16/-17-1, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-10-34.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 57-05-02-250-129

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

Number	Name/Location
131AB	Center Tank Access
531AB	Center Tank Access Door - Wing Station 168
531BB	Center Tank Access Door - Wing Station 192

Close these access panels on the Right side:

Number	Name/Location
131AB	Center Tank Access
631AB	Center Tank Access Door - Wing Station 168
631BB	Center Tank Access Door - Wing Station 192

——— END OF TASK ———

TASK 57-05-02-211-878

162. INTERNAL - DETAILED: WING LOWER PANEL, SPLICE STRINGERS

Figure 253

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

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

B. Access Panels

Number	Name/Location
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
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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

C. Inspection

SUBTASK 57-05-02-010-222

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

Number	Name/Location
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

Open these access panels on the Right side:

Number	Name/Location
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

SUBTASK 57-05-02-211-078

(2) Do a Detailed inspection of the web and free flange of the wing lower panel splice stringers, S-5 and S-9, from rib 10 to rib 19 at the areas externally covered by rub strips.

See Doc. D626A001 - DTR, DTR check form 57-20-03-5, for alternative inspection.

SUBTASK 57-05-02-410-221

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

Number	Name/Location
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

Close these access panels on the Right side:

Number	Name/Location
632EB	Main Tank Access Door - Wing Station 337
632FB	Main Tank Access Door - Wing Station 367
632GB	Main Tank Access Door - Wing Station 390

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
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

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(RIGHT WING IS SHOWN, LEFT WING IS OPPOSITE)
(BOTTOM VIEW)

A

TYPICAL SPLICE STRINGER INSPECTION AREA
A-A

3041320 S0000808849_V1

Wing Lower Wing Panel - Splice Stringers
Figure 253/57-05-02-990-809

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-250-924

163. INTERNAL - SPECIAL DETAILED: LOWER WING PANEL, SPLICE STRINGERS (DIRECTION 4)

NOTE: This procedure is a scheduled maintenance task.

A. 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
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

B. 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
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

C. Inspection

SUBTASK 57-05-02-010-223

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

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

Open these access panels on the Right side:

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

NOTE: Remove minimal amount of sealant to facilitate direction 4 HFEC at all fasteners.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 57-05-02-250-130

(2) Do a High Frequency Eddy Current inspection of the lower wing panel splice stringers, S-5 and S-9, from rib 1 to rib 10 at the areas externally covered by fairing and rub strips.

See Doc. D626A001 - DTR, DTR check form 57-20-03-6, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-10-33.

SUBTASK 57-05-02-410-222

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

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

Close these access panels on the Right side:

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

END OF TASK

TASK 57-05-02-250-925

164. EXTERNAL - SPECIAL DETAILED: FRONT SPAR LOWER CHORD (WEB FLANGE INSPECTIONS)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

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

B. Inspection

SUBTASK 57-05-02-250-131

(1) Do a Low Frequency Eddy Current inspection of the front spar lower chord areas hidden by stiffeners, ribs, posts or fittings from rib 19 to rib 22.

See Doc. D626A001 - DTR, DTR check form 57-20-04-7, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-10-54.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-250-926

165. INTERNAL - SPECIAL DETAILED: WING CENTER SECTION LOWER PANEL

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)

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

D. Inspection

SUBTASK 57-05-02-010-225

(1) 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 57-05-02-250-133

(2) Do a High Frequency Eddy Current inspection of the wing center section lower splice stringer No. 5 and No. 9 from LBL 67.0 to RBL 67.0.

See Doc. D626A001 - DTR, DTR check form 57-10-08-1, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-11-01.

SUBTASK 57-05-02-410-224

(3) Close this access panel:

Number	Name/Location
131AB	Center Tank Access

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

——— END OF TASK ———

TASK 57-05-02-250-927

166. INTERNAL - SPECIAL DETAILED: REAR SPAR LOWER CHORD (SKIN FLANGE AND WEB FLANGE INSPECTIONS)

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)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Reference	Title
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)

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
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
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
631AB	Center Tank Access Door - Wing Station 168

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
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

D. Inspection

SUBTASK 57-05-02-010-226

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

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

Open these access panels on the Right side:

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

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

(2) Open these access panels on the Left side:

Number	Name/Location
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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
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

Open these access panels on the Right side:

Number	Name/Location
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

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

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

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

Open these access panels on the Right side:

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

To do this, do this task: Surge Tank Access Door Removal, TASK 28-11-11-000-802

SUBTASK 57-05-02-250-134

(4) Do a High Frequency Eddy Current inspection of the rear spar lower chord at the non-hidden and partially hidden areas from rib 1 to rib 25.

See Doc. D626A001 - DTR, DTR check form 57-20-05-11, for alternative inspection.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-11-03.

SUBTASK 57-05-02-410-225

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

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

Close these access panels on the Right side:

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

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

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

Number	Name/Location
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

Close these access panels on the Right side:

Number	Name/Location
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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
632PB	Main Tank Access Door - Wing Station 576
632QB	Main Tank Access Door - Wing Station 602
632RB	Main Tank Access Door - Wing Station 629

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

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

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

Close these access panels on the Right side:

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

To do this, do these tasks: Surge Tank Access Door (533AB, 533CB, 633AB, 633CB) - Installation, TASK 28-11-11-400-802 and Surge Tank Access Door (533BB, 633BB) - Installation, TASK 28-11-11-400-803

END OF TASK

TASK 57-05-02-250-928

167. INTERNAL - SPECIAL DETAILED: REAR SPAR UPPER CHORD (SKIN FLANGE AND WEB FLANGE INSPECTIONS)

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)
28-11-11-400-801	Main Tank Access Door 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)

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
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
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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
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
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

D. Inspection

SUBTASK 57-05-02-010-227

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

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

Open these access panels on the Right side:

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

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

(2) Open these access panels on the Left side:

Number	Name/Location
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

Open these access panels on the Right side:

Number	Name/Location
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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
632GB	Main Tank Access Door - Wing Station 390

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

SUBTASK 57-05-02-250-135

(3) Do a High Frequency Eddy Current inspection of the rear spar upper chord at the non-hidden and partially hidden areas from rib 1 to rib 13.

See Doc. D626A001 - DTR, DTR check form 57–20–17–5, for alternative inspection.

The NDI method(s) necessary to accomplish the intent of this inspection is contained in the 737 Nondestructive Test Manual (D6-37239). The inspection procedures are contained in Part 6, Subject 57-11-02.

SUBTASK 57-05-02-410-226

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

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

Close these access panels on the Right side:

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

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

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

Number	Name/Location
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

Close these access panels on the Right side:

Number	Name/Location
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

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

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-02-211-880

168. INTERNAL - DETAILED: WING CENTER SECTION LOWER PANEL SKIN

NOTE: This procedure is a scheduled maintenance task.

A. 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

B. Access Panels

Number	Name/Location
131AB	Center Tank Access
192CL	ECS Access Door

C. Inspection

SUBTASK 57-05-02-010-243

(1) Open this access panel:

Number	Name/Location
192CL	ECS Access Door

Open this access panel:

Number	Name/Location
131AB	Center Tank Access

SUBTASK 57-05-02-211-080

(2) Do a Detailed inspection of the Wing Center Section, drag angle attachment from the front spar to Wing Center Section S-14, LBL/RBL 50.

See Doc. D626A001 - DTR, DTR check form 57-10-16, for alternative inspection.

SUBTASK 57-05-02-410-242

(3) Close these access panels:

Number	Name/Location
131AB	Center Tank Access
192CL	ECS Access Door

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

WING CENTER SECTION

A

DRAG ANGLE INSPECTION AREA

B

3076904 S0000834556_V2

Wing Center Section Lower Panel Skin
Figure 254/57-05-02-990-854

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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	737-6789 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 57-05-03-010-053

(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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Special Access:

Number	Name/Location
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) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-804.

SUBTASK 57-05-03-410-053

(4) Close 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

Restore Special Access:

Number	Name/Location
S1006	Forward Side Wing Center Section Inspection

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

MPD ITEM
57-010-00

2100673 S0000445864_V3

INTERNAL-GENERAL VISUAL: INTERNAL-WING CENTER SECTION
Figure 201/57-05-03-990-857 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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

C

TERMINAL FITTING (EXAMPLE)

D

MPD ITEM
57-010-00

2101072 S0000445865_V2

INTERNAL-GENERAL VISUAL: INTERNAL-WING CENTER SECTION
Figure 201/57-05-03-990-857 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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	737-6789 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

D. Inspection

SUBTASK 57-05-03-010-052

(1) Open these access panels:

(TASK 28-11-31-000-801)

Number	Name/Location
131AB	Center Tank Access
192CL	ECS Access Door

SUBTASK 57-05-03-210-002

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

(a) Upper surface (including skins, typical and vent stringers, splice stringer, at attachment to floor beams).

(b) Lower surface (including 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).

(c) Front and rear spars (including webs and stiffeners, upper and lower spar chords, attachments to skin).

(d) Side of body rib (including 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

(3) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-809.

SUBTASK 57-05-03-410-052

(4) Close these access panels:

(TASK 28-11-31-400-801)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Number	Name/Location
131AB	Center Tank Access
192CL	ECS Access Door

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

WING CENTER SECTION
(LOWER SKIN AND KEEL BEAM NOT SHOWN)

B

MPD ITEM
57-020-00

D81411 S0000164997_V5

INTERNAL-GENERAL VISUAL: INTERNAL-WING CENTER SECTION
Figure 202/57-05-03-990-858 (Sheet 1 of 4)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

WING CENTER SECTION
(LOOKING UP)

C

MPD ITEM
57-020-00

D82042 S0000164999_V3

INTERNAL-GENERAL VISUAL: INTERNAL-WING CENTER SECTION
Figure 202/57-05-03-990-858 (Sheet 2 of 4)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

INTERNAL-GENERAL VISUAL: INTERNAL-WING CENTER SECTION
Figure 202/57-05-03-990-858 (Sheet 3 of 4)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

WING CENTER SECTION
(UPPER SKIN NOT SHOWN)

E

MPD ITEM
57-020-00

D82364 S0000167065_V3

INTERNAL-GENERAL VISUAL: INTERNAL-WING CENTER SECTION
Figure 202/57-05-03-990-858 (Sheet 4 of 4)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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
06-41-00-010-801	Open Access Panel 192CR (P/B 201)
06-41-00-410-801	Close Access Panel 192CR (P/B 201)
51-05-01-210-806	737-6789 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 57-05-03-010-051

(1) To open access panel 192CR, refer to: Open Access Panel 192CR, TASK 06-41-00-010-801

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
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
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, including 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: 737-6789 Basic Task Description, TASK 51-05-01-210-806.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 57-05-03-410-051

(4) To close access panel 192CR, refer to: Close Access Panel 192CR, TASK 06-41-00-410-801

Close these 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

Special Access:

Number	Name/Location
S1007	Aft Side Wing Center Section Inspection

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

D81306 S0000164929_V2

EXTERNAL-GENERAL VISUAL: EXTERNAL-WING CENTER SECTION
Figure 203/57-05-03-990-852

ECCN 9E991 BOEING PROPRIETARY - See title page for details

EXTERNAL-GENERAL VISUAL: EXTERNAL WING CENTER SECTION
Figure 204/57-05-03-990-855

ECCN 9E991 BOEING PROPRIETARY - See title page for details

REAR SPAR TERMINAL FITTING
(VIEWED FROM MLG WHEEL WELL IN THE FORWARD DIRECTION)

A

1411869 S0000254637_V2

Rear Spar Terminal Fittings
Figure 205/57-05-03-990-871

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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
06-41-00-010-801	Open Access Panel 192CR (P/B 201)
06-41-00-410-801	Close Access Panel 192CR (P/B 201)
51-05-01-210-804	737-6789 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
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 57-05-03-010-050

(1) To open access panel 192CR, refer to: Open Access Panel 192CR, TASK 06-41-00-010-801

Open these 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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Special Access:

Number	Name/Location
S1008	Lower Side Wing Center Section Inspection

NOTE: Remove ECS heat exchanger access panel.

SUBTASK 57-05-03-210-004

(2) 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

(3) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-804.

SUBTASK 57-05-03-410-050

(4) To close access panel 192CR, refer to: Close Access Panel 192CR, TASK 06-41-00-410-801

Close these 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

Special Access:

Number	Name/Location
S1008	Lower Side Wing Center Section Inspection

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

498740 S0000160213_V5

Wing Center Section - General Visual (Internal)
Figure 206/57-05-03-990-843 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

WING CENTER SECTION
(VIEW IN THE UP DIRECTION)

B

3084907 S0000838979_V1

Wing Center Section - General Visual (Internal)
Figure 206/57-05-03-990-843 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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	737-6789 Basic Task Description (P/B 201)

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 57-05-03-010-049

(1) Open these 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

SUBTASK 57-05-03-210-005

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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 57-05-03-910-005

(3) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 57-05-03-410-049

(4) Close these 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

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Wing Center Section
Figure 207/57-05-03-990-823 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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

C

TERMINAL FITTING (EXAMPLE)

D

403178 S0000133250_V2

Wing Center Section
Figure 207/57-05-03-990-823 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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	737-6789 Basic Task Description (P/B 201)

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 57-05-03-010-048

(1) 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
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

SUBTASK 57-05-03-210-006

(2) 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

(3) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 57-05-03-410-048

(4) Close these access panels:

Number	Name/Location
191AL	Forward Wing To Body Fairing Panel - Upper

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
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

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

417738 S0000137595_V2

Left Outboard Wing General Visual (Internal)
Figure 208/57-05-03-990-838 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

B

419336 S0000137596_V2

Left Outboard Wing General Visual (Internal)
Figure 208/57-05-03-990-838 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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	737-6789 Basic Task Description (P/B 201)

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 57-05-03-010-047

(1) 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
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

SUBTASK 57-05-03-210-007

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

SUBTASK 57-05-03-910-007

(3) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 57-05-03-410-047

(4) Close these access panels:

Number	Name/Location
191AR	Forward Wing To Body Fairing Panel - Upper

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
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

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

A

419445 S0000137598_V2

Right Outboard Wing General Visual (Internal)
Figure 209/57-05-03-990-839 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

B

419337 S0000137599_V2

Right Outboard Wing General Visual (Internal)
Figure 209/57-05-03-990-839 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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	737-6789 Basic Task Description (P/B 201)

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 57-05-03-010-046

(1) Open these 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

SUBTASK 57-05-03-210-008

(2) 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

(3) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 57-05-03-410-046

(4) Close these 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

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Left Outboard Wing - Wing-to-Body Fairing General Visual (Internal)
Figure 210/57-05-03-990-833 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(ACCESS PANEL, 191AL REMOVED)

B

415344 S0000137129_V2

Left Outboard Wing - Wing-to-Body Fairing General Visual (Internal)
Figure 210/57-05-03-990-833 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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	737-6789 Basic Task Description (P/B 201)

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 Fairings - Right Side

D. Inspection

SUBTASK 57-05-03-010-045

(1) Open these 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 Fairings - Right Side

SUBTASK 57-05-03-210-009

(2) 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

(3) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 57-05-03-410-045

(4) Close these 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 Fairings - Right Side

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

415419 S0000137135_V4

Right Outboard Wing - Wing-to-Body Fairing General Visual (Internal)
Figure 211/57-05-03-990-834 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(ACCESS PANEL, 191AR REMOVED)

B

415426 S0000137139_V2

Right Outboard Wing - Wing-to-Body Fairing General Visual (Internal)
Figure 211/57-05-03-990-834 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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	737-6789 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
241	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Left
242	Aft Passenger Compartment - Station 663.75 to Aft Pressure Bulkhead - Right

C. Inspection

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

SUBTASK 57-05-03-210-010

(1) Do a General Visual inspection for the upper side of upper wing surface.

(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 727, including at floor beam attachments.

(c) Inspect for condition of secondary vapor barrier.

SUBTASK 57-05-03-910-010

(2) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-808.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

LEGEND:

CONTINUOUS COATING OF SECONDARY FUEL VAPOR-BARRIER.

WING CENTER SECTION

A

MPD ITEM 57-090-00

D82588 S0000165001_V5

INTERNAL-GENERAL VISUAL: WING CENTER SECTION
Figure 212/57-05-03-990-860

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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	737-6789 Basic Task Description (P/B 201)
54-52-03-010-801	Wing Junction Fairing - Removal (P/B 401)
54-52-03-410-801	Wing Junction Fairing - Installation (P/B 401)
54-52-06-010-801	Aft Fairing Access Panel Removal (P/B 401)
54-52-06-410-801	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 Forward Panel, Strut 1
434AR	Aft Strut Fairing, Right Forward Panel, Strut 1
434BL	Aft Strut Fairing, Left Aft Panel, Strut 1

D. Inspection

SUBTASK 57-05-03-010-044

(1) Remove these access panels:

(TASK 54-52-06-010-801)

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

SUBTASK 57-05-03-010-062

(2) Remove these access panels:

(TASK 54-52-03-010-801)

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 the following 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).

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(e) Side brace support fittings (R7 and R8).

(f) R3 forward backup fitting.

SUBTASK 57-05-03-210-055

(4) Do a General Visual inspection of the upper wing skin at attachment to nacelle fitting R1.

SUBTASK 57-05-03-910-011

(5) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-801.

SUBTASK 57-05-03-410-044

(6) Install these access panels:

(TASK 54-52-06-410-801)

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

SUBTASK 57-05-03-410-062

(7) Install these access panels:

(TASK 54-52-03-410-801)

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

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

A-A

K16539 S0006584748_V2

Wing - Left Nacelle Support Fittings
Figure 213/57-05-03-990-801

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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	737-6789 Basic Task Description (P/B 201)
54-52-03-010-801	Wing Junction Fairing - Removal (P/B 401)
54-52-03-410-801	Wing Junction Fairing - Installation (P/B 401)
54-52-06-010-801	Aft Fairing Access Panel Removal (P/B 401)
54-52-06-410-801	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 Forward Panel, Strut 2
444AR	Aft Strut Fairing, Right Forward Panel, Strut 2
444BR	Aft Strut Fairing, Right Aft Panel, Strut 2

D. Inspection

SUBTASK 57-05-03-010-043

(1) Remove these access panels:

(TASK 54-52-06-010-801)

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

SUBTASK 57-05-03-010-063

(2) Remove these access panels:

(TASK 54-52-03-010-801)

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 the following 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).

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(e) Side brace support fittings (R7 and R8).

(f) R3 forward backup fitting.

SUBTASK 57-05-03-210-054

(4) Do a General Visual inspection of the upper wing skin at attachment to nacelle fitting R1.

SUBTASK 57-05-03-910-012

(5) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-801.

SUBTASK 57-05-03-410-043

(6) Install these access panels:

(TASK 54-52-06-410-801)

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

SUBTASK 57-05-03-410-063

(7) Install these access panels:

(TASK 54-52-03-410-801)

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

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Wing - Right Nacelle Support Fittings
Figure 214/57-05-03-990-802

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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	737-6789 Basic Task Description (P/B 201)
54-52-06-010-801	Aft Fairing Access Panel Removal (P/B 401)
54-52-06-410-801	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 Forward Panel, Strut 1
434AR	Aft Strut Fairing, Right Forward Panel, Strut 1
434BL	Aft Strut Fairing, Left Aft Panel, Strut 1

D. Inspection

SUBTASK 57-05-03-010-042

(1) Remove these access panels:

(TASK 54-52-06-010-801)

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

SUBTASK 57-05-03-210-013

(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: 737-6789 Basic Task Description, TASK 51-05-01-210-809.

SUBTASK 57-05-03-410-042

(4) Install these access panels:

(TASK 54-52-06-410-801)

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

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

LEFT STRUT

AFT FAIRING

A

K56390 S0006584754_V3

Left Aft Fairing Access Panels To Lower Wing Skin
Figure 215/57-05-03-990-803

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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	737-6789 Basic Task Description (P/B 201)
54-52-06-010-801	Aft Fairing Access Panel Removal (P/B 401)
54-52-06-410-801	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 Forward Panel, Strut 2
444AR	Aft Strut Fairing, Right Forward Panel, Strut 2
444BR	Aft Strut Fairing, Right Aft Panel, Strut 2

D. Inspection

SUBTASK 57-05-03-010-041

(1) Remove these access panels:

(TASK 54-52-06-010-801)

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

SUBTASK 57-05-03-210-014

(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) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-809.

SUBTASK 57-05-03-410-041

(4) Install these access panels:

(TASK 54-52-06-410-801)

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

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

RIGHT STRUT

AFT FAIRING

A

K56373 S0006584757_V3

Right Aft Fairing Access Panels To Lower Wing Skin
Figure 216/57-05-03-990-804

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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
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)
51-05-01-210-806	737-6789 Basic Task Description (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)

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 508.31
521AB	Outboard Leading Edge Blowout Door - Slat Station 20.04
521ABB	Lower Leading Edge Access Panel-Slat Station 524.31
521BB	Outboard Lower Fixed Leading Edge Access Panel - Slat Station 36.02
521CB	Lower Leading Edge Access Panel - Slat Station 53.95
521DB	Lower Leading Edge Access Panel - Slat Station 71.38
521EB	Lower Leading Edge Access Panel - Slat Station 98.95
521FB	Lower Leading Edge Access Panel - Slat Station 116.32
521GB	Lower Leading Edge Access Panel - Slat Station 125.27
521HB	Lower Leading Edge Access Panel - Slat Station 152.81
521JB	Lower Leading Edge Access Panel - Slat Station 170.20
521KB	Lower Leading Edge Access Panel - Slat Station 188.12
521LB	Lower Leading Edge Access Panel - Slat Station 216.76
521MB	Lower Leading Edge Access Panel - Slat Station 234.65
521NB	Lower Leading Edge Access Panel - Slat Station 252.04
521PB	Lower Leading Edge Access Panel - Slat Station 270.42
521QB	Lower Leading Edge Access Panel - Slat Station 289.17
521RB	Lower Leading Edge Access Panel - Slat Station 307.75
521SB	Lower Leading Edge Access Panel - Slat Station 337.62
521TB	Lower Leading Edge Access Panel - Slat Station 356.14
521UB	Lower Leading Edge Access Panel - Slat Station 374.95
521VB	Lower Leading Edge Access Panel - Slat Station 395.64
521WB	Lower Leading Edge Access Panel - Slat Station 415.79
521XB	Lower Leading Edge Access Panel - Slat Station 435.91
521YB	Lower Leading Edge Access Panel - Slat Station 467.98

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
521ZB	Lower Leading Edge Access Panel - Slat Station 488.05

D. Inspection

SUBTASK 57-05-03-010-054

(1) Open these access panels:

(TASK 57-41-02-000-801)

Number	Name/Location
511AT	Inboard Leading Edge, Strakelet Upper Panel
511BT	Fairing
521AAB	Lower Leading Edge Access Panel - Slat Station 508.31
521AB	Outboard Leading Edge Blowout Door - Slat Station 20.04
521ABB	Lower Leading Edge Access Panel-Slat Station 524.31
521BB	Outboard Lower Fixed Leading Edge Access Panel - Slat Station 36.02
521CB	Lower Leading Edge Access Panel - Slat Station 53.95
521DB	Lower Leading Edge Access Panel - Slat Station 71.38
521EB	Lower Leading Edge Access Panel - Slat Station 98.95
521FB	Lower Leading Edge Access Panel - Slat Station 116.32
521GB	Lower Leading Edge Access Panel - Slat Station 125.27
521HB	Lower Leading Edge Access Panel - Slat Station 152.81
521JB	Lower Leading Edge Access Panel - Slat Station 170.20
521KB	Lower Leading Edge Access Panel - Slat Station 188.12
521LB	Lower Leading Edge Access Panel - Slat Station 216.76
521MB	Lower Leading Edge Access Panel - Slat Station 234.65
521NB	Lower Leading Edge Access Panel - Slat Station 252.04
521PB	Lower Leading Edge Access Panel - Slat Station 270.42
521QB	Lower Leading Edge Access Panel - Slat Station 289.17
521RB	Lower Leading Edge Access Panel - Slat Station 307.75
521SB	Lower Leading Edge Access Panel - Slat Station 337.62
521TB	Lower Leading Edge Access Panel - Slat Station 356.14
521UB	Lower Leading Edge Access Panel - Slat Station 374.95
521VB	Lower Leading Edge Access Panel - Slat Station 395.64
521WB	Lower Leading Edge Access Panel - Slat Station 415.79
521XB	Lower Leading Edge Access Panel - Slat Station 435.91
521YB	Lower Leading Edge Access Panel - Slat Station 467.98
521ZB	Lower Leading Edge Access Panel - Slat Station 488.05

SUBTASK 57-05-03-980-003

(2) Extend the krueger flaps (TASK 27-81-00-860-803).

SUBTASK 57-05-03-210-015

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

SUBTASK 57-05-03-910-015

(4) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 57-05-03-980-004

(5) Retract the krueger flaps (TASK 27-81-00-860-804).

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 57-05-03-410-054

(6) Close these access panels:

(TASK 57-41-02-400-801)

Number	Name/Location
511AT	Inboard Leading Edge, Strakelet Upper Panel
511BT	Fairing
521AAB	Lower Leading Edge Access Panel - Slat Station 508.31
521AB	Outboard Leading Edge Blowout Door - Slat Station 20.04
521ABB	Lower Leading Edge Access Panel-Slat Station 524.31
521BB	Outboard Lower Fixed Leading Edge Access Panel - Slat Station 36.02
521CB	Lower Leading Edge Access Panel - Slat Station 53.95
521DB	Lower Leading Edge Access Panel - Slat Station 71.38
521EB	Lower Leading Edge Access Panel - Slat Station 98.95
521FB	Lower Leading Edge Access Panel - Slat Station 116.32
521GB	Lower Leading Edge Access Panel - Slat Station 125.27
521HB	Lower Leading Edge Access Panel - Slat Station 152.81
521JB	Lower Leading Edge Access Panel - Slat Station 170.20
521KB	Lower Leading Edge Access Panel - Slat Station 188.12
521LB	Lower Leading Edge Access Panel - Slat Station 216.76
521MB	Lower Leading Edge Access Panel - Slat Station 234.65
521NB	Lower Leading Edge Access Panel - Slat Station 252.04
521PB	Lower Leading Edge Access Panel - Slat Station 270.42
521QB	Lower Leading Edge Access Panel - Slat Station 289.17
521RB	Lower Leading Edge Access Panel - Slat Station 307.75
521SB	Lower Leading Edge Access Panel - Slat Station 337.62
521TB	Lower Leading Edge Access Panel - Slat Station 356.14
521UB	Lower Leading Edge Access Panel - Slat Station 374.95
521VB	Lower Leading Edge Access Panel - Slat Station 395.64
521WB	Lower Leading Edge Access Panel - Slat Station 415.79
521XB	Lower Leading Edge Access Panel - Slat Station 435.91
521YB	Lower Leading Edge Access Panel - Slat Station 467.98
521ZB	Lower Leading Edge Access Panel - Slat Station 488.05

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Leading Edge to Front Spar (Outboard of Nacelle Strut) Left Wing - General Visual (Internal)
Figure 217/57-05-03-990-814 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

L07489 S0006584293_V3

Leading Edge to Front Spar (Outboard of Nacelle Strut) Left Wing - General Visual (Internal)
Figure 217/57-05-03-990-814 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Leading Edge to Front Spar (Inboard of Nacelle Strut) Left Wing - General Visual (Internal)
Figure 218/57-05-03-990-815 (Sheet 1 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

L05036 S0006584284_V3

Leading Edge to Front Spar (Inboard of Nacelle Strut) Left Wing - General Visual (Internal)
Figure 218/57-05-03-990-815 (Sheet 2 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

LEFT LEADING EDGE FLAPS 1 AND 2

A

2573193 S0000617984_V1

Leading Edge to Front Spar (Inboard of Nacelle Strut) Left Wing - General Visual (Internal)
Figure 218/57-05-03-990-815 (Sheet 3 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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
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)
51-05-01-210-806	737-6789 Basic Task Description (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)

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 20.04
621BB	Outboard Lower Fixed Leading Edge Access Panel - Slat Station 36.02
621CB	Lower Leading Edge Access Panel - Slat Station 53.95
621DB	Lower Leading Edge Access Panel - Slat Station 71.38
621EB	Defuel Access Panel - Slat Station 95.15
621FB	Lower Leading Edge Access Panel - Slat Station 112.52
621GB	Refuel Access Panel - Slat Station 143.27
621HB	Lower Leading Edge Access Panel - Slat Station 170.21
621JB	Lower Leading Edge Access Panel - Slat Station 188.14
621KB	Lower Leading Edge Access Panel - Slat Station 216.71
621LB	Lower Leading Edge Access Panel - Slat Station 234.59
621MB	Lower Leading Edge Access Panel - Slat Station 252.04
621NB	Lower Leading Edge Access Panel - Slat Station 270.63
621PB	Lower Leading Edge Access Panel - Slat Station 289.18
621QB	Lower Leading Edge Access Panel - Slat Station 307.75
621RB	Lower Leading Edge Access Panel - Slat Station 337.62
621SB	Lower Leading Edge Access Panel - Slat Station 356.15
621TB	Lower Leading Edge Access Panel - Slat Station 374.95
621UB	Lower Leading Edge Access Panel - Slat Station 395.64
621VB	Lower Leading Edge Access Panel - Slat Station 415.79
621WB	Lower Leading Edge Access Panel - Slat Station 435.91
621XB	Lower Leading Edge Access Panel - Slat Station 467.98
621YB	Lower Leading Edge Access Panel - Slat Station 488.04
621ZB	Lower Leading Edge Access Panel - Slat Station 508.31

ECCN 9E991 BOEING PROPRIETARY - See title page for details

D. Inspection

SUBTASK 57-05-03-010-055

(1) Open these access panels:

(TASK 57-41-02-000-801)

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 20.04
621BB	Outboard Lower Fixed Leading Edge Access Panel - Slat Station 36.02
621CB	Lower Leading Edge Access Panel - Slat Station 53.95
621DB	Lower Leading Edge Access Panel - Slat Station 71.38
621EB	Defuel Access Panel - Slat Station 95.15
621FB	Lower Leading Edge Access Panel - Slat Station 112.52
621GB	Refuel Access Panel - Slat Station 143.27
621HB	Lower Leading Edge Access Panel - Slat Station 170.21
621JB	Lower Leading Edge Access Panel - Slat Station 188.14
621KB	Lower Leading Edge Access Panel - Slat Station 216.71
621LB	Lower Leading Edge Access Panel - Slat Station 234.59
621MB	Lower Leading Edge Access Panel - Slat Station 252.04
621NB	Lower Leading Edge Access Panel - Slat Station 270.63
621PB	Lower Leading Edge Access Panel - Slat Station 289.18
621QB	Lower Leading Edge Access Panel - Slat Station 307.75
621RB	Lower Leading Edge Access Panel - Slat Station 337.62
621SB	Lower Leading Edge Access Panel - Slat Station 356.15
621TB	Lower Leading Edge Access Panel - Slat Station 374.95
621UB	Lower Leading Edge Access Panel - Slat Station 395.64
621VB	Lower Leading Edge Access Panel - Slat Station 415.79
621WB	Lower Leading Edge Access Panel - Slat Station 435.91
621XB	Lower Leading Edge Access Panel - Slat Station 467.98
621YB	Lower Leading Edge Access Panel - Slat Station 488.04
621ZB	Lower Leading Edge Access Panel - Slat Station 508.31

SUBTASK 57-05-03-980-005

(2) Extend the krueger flaps (TASK 27-81-00-860-803).

SUBTASK 57-05-03-210-016

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

SUBTASK 57-05-03-910-016

(4) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 57-05-03-980-006

(5) Retract the krueger flaps (TASK 27-81-00-860-804).

SUBTASK 57-05-03-410-055

(6) Close these access panels:

(TASK 57-41-02-400-801)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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 20.04
621BB	Outboard Lower Fixed Leading Edge Access Panel - Slat Station 36.02
621CB	Lower Leading Edge Access Panel - Slat Station 53.95
621DB	Lower Leading Edge Access Panel - Slat Station 71.38
621EB	Defuel Access Panel - Slat Station 95.15
621FB	Lower Leading Edge Access Panel - Slat Station 112.52
621GB	Refuel Access Panel - Slat Station 143.27
621HB	Lower Leading Edge Access Panel - Slat Station 170.21
621JB	Lower Leading Edge Access Panel - Slat Station 188.14
621KB	Lower Leading Edge Access Panel - Slat Station 216.71
621LB	Lower Leading Edge Access Panel - Slat Station 234.59
621MB	Lower Leading Edge Access Panel - Slat Station 252.04
621NB	Lower Leading Edge Access Panel - Slat Station 270.63
621PB	Lower Leading Edge Access Panel - Slat Station 289.18
621QB	Lower Leading Edge Access Panel - Slat Station 307.75
621RB	Lower Leading Edge Access Panel - Slat Station 337.62
621SB	Lower Leading Edge Access Panel - Slat Station 356.15
621TB	Lower Leading Edge Access Panel - Slat Station 374.95
621UB	Lower Leading Edge Access Panel - Slat Station 395.64
621VB	Lower Leading Edge Access Panel - Slat Station 415.79
621WB	Lower Leading Edge Access Panel - Slat Station 435.91
621XB	Lower Leading Edge Access Panel - Slat Station 467.98
621YB	Lower Leading Edge Access Panel - Slat Station 488.04
621ZB	Lower Leading Edge Access Panel - Slat Station 508.31

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Leading Edge to Front Spar (Outboard of Nacelle Strut) Right Wing - General Visual (Internal)
Figure 219/57-05-03-990-816 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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Leading Edge to Front Spar (Outboard of Nacelle Strut) Right Wing - General Visual (Internal)
Figure 219/57-05-03-990-816 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Leading Edge to Front Spar (Inboard of Nacelle Strut) Right Wing - General Visual (Internal)
Figure 220/57-05-03-990-817 (Sheet 1 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

L05527 S0006584369_V3

Leading Edge to Front Spar (Inboard of Nacelle Strut) Right Wing - General Visual (Internal)
Figure 220/57-05-03-990-817 (Sheet 2 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

RIGHT LEADING EDGE FLAPS 3 AND 4

A

2573205 S0000617990_V1

Leading Edge to Front Spar (Inboard of Nacelle Strut) Right Wing - General Visual (Internal)
Figure 220/57-05-03-990-817 (Sheet 3 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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	737-6789 Basic Task Description (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)

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 508.31
521AB	Outboard Leading Edge Blowout Door - Slat Station 20.04
521ABB	Lower Leading Edge Access Panel-Slat Station 524.31
521BB	Outboard Lower Fixed Leading Edge Access Panel - Slat Station 36.02
521CB	Lower Leading Edge Access Panel - Slat Station 53.95
521DB	Lower Leading Edge Access Panel - Slat Station 71.38
521EB	Lower Leading Edge Access Panel - Slat Station 98.95
521FB	Lower Leading Edge Access Panel - Slat Station 116.32
521GB	Lower Leading Edge Access Panel - Slat Station 125.27
521HB	Lower Leading Edge Access Panel - Slat Station 152.81
521JB	Lower Leading Edge Access Panel - Slat Station 170.20
521KB	Lower Leading Edge Access Panel - Slat Station 188.12
521LB	Lower Leading Edge Access Panel - Slat Station 216.76
521MB	Lower Leading Edge Access Panel - Slat Station 234.65
521NB	Lower Leading Edge Access Panel - Slat Station 252.04
521PB	Lower Leading Edge Access Panel - Slat Station 270.42
521QB	Lower Leading Edge Access Panel - Slat Station 289.17
521RB	Lower Leading Edge Access Panel - Slat Station 307.75
521SB	Lower Leading Edge Access Panel - Slat Station 337.62
521TB	Lower Leading Edge Access Panel - Slat Station 356.14
521UB	Lower Leading Edge Access Panel - Slat Station 374.95
521VB	Lower Leading Edge Access Panel - Slat Station 395.64
521WB	Lower Leading Edge Access Panel - Slat Station 415.79

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
521XB	Lower Leading Edge Access Panel - Slat Station 435.91
521YB	Lower Leading Edge Access Panel - Slat Station 467.98
521ZB	Lower Leading Edge Access Panel - Slat Station 488.05

D. Inspection

SUBTASK 57-05-03-010-040

(1) Open these access panels:

(TASK 57-41-02-000-801)

Number	Name/Location
521AAB	Lower Leading Edge Access Panel - Slat Station 508.31
521AB	Outboard Leading Edge Blowout Door - Slat Station 20.04
521ABB	Lower Leading Edge Access Panel-Slat Station 524.31
521BB	Outboard Lower Fixed Leading Edge Access Panel - Slat Station 36.02
521CB	Lower Leading Edge Access Panel - Slat Station 53.95
521DB	Lower Leading Edge Access Panel - Slat Station 71.38
521EB	Lower Leading Edge Access Panel - Slat Station 98.95
521FB	Lower Leading Edge Access Panel - Slat Station 116.32
521GB	Lower Leading Edge Access Panel - Slat Station 125.27
521HB	Lower Leading Edge Access Panel - Slat Station 152.81
521JB	Lower Leading Edge Access Panel - Slat Station 170.20
521KB	Lower Leading Edge Access Panel - Slat Station 188.12
521LB	Lower Leading Edge Access Panel - Slat Station 216.76
521MB	Lower Leading Edge Access Panel - Slat Station 234.65
521NB	Lower Leading Edge Access Panel - Slat Station 252.04
521PB	Lower Leading Edge Access Panel - Slat Station 270.42
521QB	Lower Leading Edge Access Panel - Slat Station 289.17
521RB	Lower Leading Edge Access Panel - Slat Station 307.75
521SB	Lower Leading Edge Access Panel - Slat Station 337.62
521TB	Lower Leading Edge Access Panel - Slat Station 356.14
521UB	Lower Leading Edge Access Panel - Slat Station 374.95
521VB	Lower Leading Edge Access Panel - Slat Station 395.64
521WB	Lower Leading Edge Access Panel - Slat Station 415.79
521XB	Lower Leading Edge Access Panel - Slat Station 435.91
521YB	Lower Leading Edge Access Panel - Slat Station 467.98
521ZB	Lower Leading Edge Access Panel - Slat Station 488.05

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) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 57-05-03-410-040

(4) Close these access panels:

(TASK 57-41-02-400-801)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Number	Name/Location
521AAB	Lower Leading Edge Access Panel - Slat Station 508.31
521AB	Outboard Leading Edge Blowout Door - Slat Station 20.04
521ABB	Lower Leading Edge Access Panel-Slat Station 524.31
521BB	Outboard Lower Fixed Leading Edge Access Panel - Slat Station 36.02
521CB	Lower Leading Edge Access Panel - Slat Station 53.95
521DB	Lower Leading Edge Access Panel - Slat Station 71.38
521EB	Lower Leading Edge Access Panel - Slat Station 98.95
521FB	Lower Leading Edge Access Panel - Slat Station 116.32
521GB	Lower Leading Edge Access Panel - Slat Station 125.27
521HB	Lower Leading Edge Access Panel - Slat Station 152.81
521JB	Lower Leading Edge Access Panel - Slat Station 170.20
521KB	Lower Leading Edge Access Panel - Slat Station 188.12
521LB	Lower Leading Edge Access Panel - Slat Station 216.76
521MB	Lower Leading Edge Access Panel - Slat Station 234.65
521NB	Lower Leading Edge Access Panel - Slat Station 252.04
521PB	Lower Leading Edge Access Panel - Slat Station 270.42
521QB	Lower Leading Edge Access Panel - Slat Station 289.17
521RB	Lower Leading Edge Access Panel - Slat Station 307.75
521SB	Lower Leading Edge Access Panel - Slat Station 337.62
521TB	Lower Leading Edge Access Panel - Slat Station 356.14
521UB	Lower Leading Edge Access Panel - Slat Station 374.95
521VB	Lower Leading Edge Access Panel - Slat Station 395.64
521WB	Lower Leading Edge Access Panel - Slat Station 415.79
521XB	Lower Leading Edge Access Panel - Slat Station 435.91
521YB	Lower Leading Edge Access Panel - Slat Station 467.98
521ZB	Lower Leading Edge Access Panel - Slat Station 488.05

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(BOTTOM VIEW)

A

1 NOT ON ALL AIRPLANES

MPD ITEM
57-130-01

D74883 S0000164317_V3

INTERNAL-GENERAL VISUAL: INTERNAL-LEFT OUTBOARD WING LEADING EDGE STRUCTURE
Figure 221/57-05-03-990-850 (Sheet 1 of 4)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

LEFT LEADING EDGE FLAPS NO. 1 AND 2

B

MPD ITEM
57-130-01

D74885 S0000164318_V3

INTERNAL-GENERAL VISUAL: INTERNAL-LEFT OUTBOARD WING LEADING EDGE STRUCTURE
Figure 221/57-05-03-990-850 (Sheet 2 of 4)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SLAT 1

C

MPD ITEM
57-130-01

D74893 S0000164319_V3

INTERNAL-GENERAL VISUAL: INTERNAL-LEFT OUTBOARD WING LEADING EDGE STRUCTURE
Figure 221/57-05-03-990-850 (Sheet 3 of 4)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SLAT 2
(SLATS 3 AND 4 ARE EQUIVALENT)

D

MPD ITEM
57-130-01

D74929 S0000164320_V3

INTERNAL-GENERAL VISUAL: INTERNAL-LEFT OUTBOARD WING LEADING EDGE STRUCTURE
Figure 221/57-05-03-990-850 (Sheet 4 of 4)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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	737-6789 Basic Task Description (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)

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 20.04
I 621BB	Outboard Lower Fixed Leading Edge Access Panel - Slat Station 36.02
621CB	Lower Leading Edge Access Panel - Slat Station 53.95
621DB	Lower Leading Edge Access Panel - Slat Station 71.38
621EB	Defuel Access Panel - Slat Station 95.15
621FB	Lower Leading Edge Access Panel - Slat Station 112.52
621GB	Refuel Access Panel - Slat Station 143.27
621HB	Lower Leading Edge Access Panel - Slat Station 170.21
621JB	Lower Leading Edge Access Panel - Slat Station 188.14
621KB	Lower Leading Edge Access Panel - Slat Station 216.71
621LB	Lower Leading Edge Access Panel - Slat Station 234.59
621MB	Lower Leading Edge Access Panel - Slat Station 252.04
621NB	Lower Leading Edge Access Panel - Slat Station 270.63
621PB	Lower Leading Edge Access Panel - Slat Station 289.18
621QB	Lower Leading Edge Access Panel - Slat Station 307.75
621RB	Lower Leading Edge Access Panel - Slat Station 337.62
621SB	Lower Leading Edge Access Panel - Slat Station 356.15
621TB	Lower Leading Edge Access Panel - Slat Station 374.95
621UB	Lower Leading Edge Access Panel - Slat Station 395.64
621VB	Lower Leading Edge Access Panel - Slat Station 415.79
621WB	Lower Leading Edge Access Panel - Slat Station 435.91
621XB	Lower Leading Edge Access Panel - Slat Station 467.98

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
621YB	Lower Leading Edge Access Panel - Slat Station 488.04
621ZB	Lower Leading Edge Access Panel - Slat Station 508.31

D. Inspection

SUBTASK 57-05-03-010-039

(1) Open these access panels:

(TASK 57-41-02-000-801)

Number	Name/Location
621AAB	Lower Leading Edge Access Panel - Slat Station 524.31
621AB	Outboard Leading Edge Blowout Door - Slat Station 20.04
621BB	Outboard Lower Fixed Leading Edge Access Panel - Slat Station 36.02
621CB	Lower Leading Edge Access Panel - Slat Station 53.95
621DB	Lower Leading Edge Access Panel - Slat Station 71.38
621EB	Defuel Access Panel - Slat Station 95.15
621FB	Lower Leading Edge Access Panel - Slat Station 112.52
621GB	Refuel Access Panel - Slat Station 143.27
621HB	Lower Leading Edge Access Panel - Slat Station 170.21
621JB	Lower Leading Edge Access Panel - Slat Station 188.14
621KB	Lower Leading Edge Access Panel - Slat Station 216.71
621LB	Lower Leading Edge Access Panel - Slat Station 234.59
621MB	Lower Leading Edge Access Panel - Slat Station 252.04
621NB	Lower Leading Edge Access Panel - Slat Station 270.63
621PB	Lower Leading Edge Access Panel - Slat Station 289.18
621QB	Lower Leading Edge Access Panel - Slat Station 307.75
621RB	Lower Leading Edge Access Panel - Slat Station 337.62
621SB	Lower Leading Edge Access Panel - Slat Station 356.15
621TB	Lower Leading Edge Access Panel - Slat Station 374.95
621UB	Lower Leading Edge Access Panel - Slat Station 395.64
621VB	Lower Leading Edge Access Panel - Slat Station 415.79
621WB	Lower Leading Edge Access Panel - Slat Station 435.91
621XB	Lower Leading Edge Access Panel - Slat Station 467.98
621YB	Lower Leading Edge Access Panel - Slat Station 488.04
621ZB	Lower Leading Edge Access Panel - Slat Station 508.31

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) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 57-05-03-410-039

(4) Close these access panels:

(TASK 57-41-02-400-801)

Number	Name/Location
621AAB	Lower Leading Edge Access Panel - Slat Station 524.31

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
621AB	Outboard Leading Edge Blowout Door - Slat Station 20.04
621BB	Outboard Lower Fixed Leading Edge Access Panel - Slat Station 36.02
621CB	Lower Leading Edge Access Panel - Slat Station 53.95
621DB	Lower Leading Edge Access Panel - Slat Station 71.38
621EB	Defuel Access Panel - Slat Station 95.15
621FB	Lower Leading Edge Access Panel - Slat Station 112.52
621GB	Refuel Access Panel - Slat Station 143.27
621HB	Lower Leading Edge Access Panel - Slat Station 170.21
621JB	Lower Leading Edge Access Panel - Slat Station 188.14
621KB	Lower Leading Edge Access Panel - Slat Station 216.71
621LB	Lower Leading Edge Access Panel - Slat Station 234.59
621MB	Lower Leading Edge Access Panel - Slat Station 252.04
621NB	Lower Leading Edge Access Panel - Slat Station 270.63
621PB	Lower Leading Edge Access Panel - Slat Station 289.18
621QB	Lower Leading Edge Access Panel - Slat Station 307.75
621RB	Lower Leading Edge Access Panel - Slat Station 337.62
621SB	Lower Leading Edge Access Panel - Slat Station 356.15
621TB	Lower Leading Edge Access Panel - Slat Station 374.95
621UB	Lower Leading Edge Access Panel - Slat Station 395.64
621VB	Lower Leading Edge Access Panel - Slat Station 415.79
621WB	Lower Leading Edge Access Panel - Slat Station 435.91
621XB	Lower Leading Edge Access Panel - Slat Station 467.98
621YB	Lower Leading Edge Access Panel - Slat Station 488.04
621ZB	Lower Leading Edge Access Panel - Slat Station 508.31

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(BOTTOM VIEW)

A

1 NOT ON ALL AIRPLANES

MPD ITEM
57-130-02

D74968 S0000164324_V3

INTERNAL-GENERAL VISUAL: RIGHT OUTBOARD WING LEADING EDGE
Figure 222/57-05-03-990-851 (Sheet 1 of 4)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

RIGHT WING

RIGHT LEADING EDGE FLAPS NO. 3 AND 4

B

MPD ITEM
57-130-02

D75028 S0000164325_V3

INTERNAL-GENERAL VISUAL: RIGHT OUTBOARD WING LEADING EDGE
Figure 222/57-05-03-990-851 (Sheet 2 of 4)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SLAT 8

C

MPD ITEM
57-130-02

D75036 S0000164326_V3

INTERNAL-GENERAL VISUAL: RIGHT OUTBOARD WING LEADING EDGE
Figure 222/57-05-03-990-851 (Sheet 3 of 4)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SLAT 7
(SLATS 5 AND 6 ARE EQUIVALENT)

D

MPD ITEM
57-130-02

D75037 S0000164327_V3

INTERNAL-GENERAL VISUAL: RIGHT OUTBOARD WING LEADING EDGE
Figure 222/57-05-03-990-851 (Sheet 4 of 4)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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	737-6789 Basic Task Description (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)

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 53.95
521FB	Lower Leading Edge Access Panel - Slat Station 116.32
521JB	Lower Leading Edge Access Panel - Slat Station 170.20
521MB	Lower Leading Edge Access Panel - Slat Station 234.65
521QB	Lower Leading Edge Access Panel - Slat Station 289.17
521TB	Lower Leading Edge Access Panel - Slat Station 356.14
521WB	Lower Leading Edge Access Panel - Slat Station 415.79
521ZB	Lower Leading Edge Access Panel - Slat Station 488.05

D. Inspection

SUBTASK 57-05-03-010-006

(1) Open these access panels:

(TASK 57-41-02-000-801)

Number	Name/Location
521CB	Lower Leading Edge Access Panel - Slat Station 53.95
521FB	Lower Leading Edge Access Panel - Slat Station 116.32
521JB	Lower Leading Edge Access Panel - Slat Station 170.20
521MB	Lower Leading Edge Access Panel - Slat Station 234.65
521QB	Lower Leading Edge Access Panel - Slat Station 289.17
521TB	Lower Leading Edge Access Panel - Slat Station 356.14
521WB	Lower Leading Edge Access Panel - Slat Station 415.79
521ZB	Lower Leading Edge Access Panel - Slat Station 488.05

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) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-809.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 57-05-03-410-006

(4) Close these access panels:

(TASK 57-41-02-400-801)

Number	Name/Location
521CB	Lower Leading Edge Access Panel - Slat Station 53.95
521FB	Lower Leading Edge Access Panel - Slat Station 116.32
521JB	Lower Leading Edge Access Panel - Slat Station 170.20
521MB	Lower Leading Edge Access Panel - Slat Station 234.65
521QB	Lower Leading Edge Access Panel - Slat Station 289.17
521TB	Lower Leading Edge Access Panel - Slat Station 356.14
521WB	Lower Leading Edge Access Panel - Slat Station 415.79
521ZB	Lower Leading Edge Access Panel - Slat Station 488.05

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Left Wing Leading Edge Slat Tracks
Figure 223/57-05-03-990-806 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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

B

369592 S0000132826_V3

Left Wing Leading Edge Slat Tracks
Figure 223/57-05-03-990-806 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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	737-6789 Basic Task Description (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)

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 53.95
621FB	Lower Leading Edge Access Panel - Slat Station 112.52
621JB	Lower Leading Edge Access Panel - Slat Station 188.14
621MB	Lower Leading Edge Access Panel - Slat Station 252.04
621QB	Lower Leading Edge Access Panel - Slat Station 307.75
621TB	Lower Leading Edge Access Panel - Slat Station 374.95
621WB	Lower Leading Edge Access Panel - Slat Station 435.91
621ZB	Lower Leading Edge Access Panel - Slat Station 508.31

D. Inspection

SUBTASK 57-05-03-010-005

(1) Open these access panels:

(TASK 57-41-02-000-801)

Number	Name/Location
621CB	Lower Leading Edge Access Panel - Slat Station 53.95
621FB	Lower Leading Edge Access Panel - Slat Station 112.52
621JB	Lower Leading Edge Access Panel - Slat Station 188.14
621MB	Lower Leading Edge Access Panel - Slat Station 252.04
621QB	Lower Leading Edge Access Panel - Slat Station 307.75
621TB	Lower Leading Edge Access Panel - Slat Station 374.95
621WB	Lower Leading Edge Access Panel - Slat Station 435.91
621ZB	Lower Leading Edge Access Panel - Slat Station 508.31

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) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-809.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 57-05-03-410-005

(4) Close these access panels:

(TASK 57-41-02-400-801)

Number	Name/Location
621CB	Lower Leading Edge Access Panel - Slat Station 53.95
621FB	Lower Leading Edge Access Panel - Slat Station 112.52
621JB	Lower Leading Edge Access Panel - Slat Station 188.14
621MB	Lower Leading Edge Access Panel - Slat Station 252.04
621QB	Lower Leading Edge Access Panel - Slat Station 307.75
621TB	Lower Leading Edge Access Panel - Slat Station 374.95
621WB	Lower Leading Edge Access Panel - Slat Station 435.91
621ZB	Lower Leading Edge Access Panel - Slat Station 508.31

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Right Wing Leading Edge Slat Tracks
Figure 224/57-05-03-990-810 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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

B

407152 S0000136337_V2

Right Wing Leading Edge Slat Tracks
Figure 224/57-05-03-990-810 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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	737-6789 Basic Task Description (P/B 201)
57-21-23-000-801	Dry Bay Access Doors Removal (P/B 401)
57-21-23-400-801	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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

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

SUBTASK 57-05-03-010-038

(1) Open these access panels:

(TASK 28-11-31-000-801)

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

(2) Open these access panels:

(TASK 28-11-11-000-801)

Number	Name/Location
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

(3) Open these access panels:

(TASK 28-11-11-000-802)

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

(4) Open these access panels:

(TASK 57-21-23-000-801)

Number	Name/Location
534AB	Dry Bay Tank Access Door - Left Wing Station 727
534BB	Dry Bay Tank Access Door - Left Wing Station 748

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 57-05-03-210-019

(5) Do a General Visual inspection of the fuel access holes in left outboard wing lower surface (tank entry is not required).

SUBTASK 57-05-03-910-021

(6) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-809.

SUBTASK 57-05-03-410-038

(7) Close these access panels:

(TASK 28-11-31-400-801)

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

(8) Close these access panels:

(TASK 28-11-11-400-801)

Number	Name/Location
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

(9) Close these access panels:

(TASK 28-11-11-400-802)

Number	Name/Location
533AB	Surge Tank Access Door - Wing Station 655
533CB	Surge Tank Access Door - Wing Station 703

(10) Close this access panel:

(TASK 28-11-11-400-803)

Number	Name/Location
533BB	Surge Tank Access Door - Wing Station 679

(11) Close these access panels:

(TASK 57-21-23-400-801)

Number	Name/Location
534AB	Dry Bay Tank Access Door - Left Wing Station 727
534BB	Dry Bay Tank Access Door - Left Wing Station 748

ECCN 9E991 BOEING PROPRIETARY - See title page for details

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Left Outboard Wing Access Holes
Figure 225/57-05-03-990-820

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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	737-6789 Basic Task Description (P/B 201)
57-21-23-000-801	Dry Bay Access Doors Removal (P/B 401)
57-21-23-400-801	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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
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

D. Inspection

SUBTASK 57-05-03-010-037

(1) Open these access panels:

(TASK 28-11-31-000-801)

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

(2) Open these access panels:

(TASK 28-11-11-000-801)

Number	Name/Location
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

(3) Open these access panels:

(TASK 28-11-11-000-802)

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

(4) Open these access panels:

(TASK 57-21-23-000-801)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Number	Name/Location
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

(5) Do a General Visual inspection of the fuel access holes in right outboard wing lower surface (tank entry is not required).

SUBTASK 57-05-03-910-022

(6) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-809.

SUBTASK 57-05-03-410-037

(7) Close these access panels:

(TASK 28-11-31-400-801)

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

(8) Close these access panels:

(TASK 28-11-11-400-801)

Number	Name/Location
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

(9) Close these access panels:

(TASK 28-11-11-400-802)

Number	Name/Location
633AB	Surge Tank Access Door - Wing Station 655
633CB	Surge Tank Access Door - Wing Station 703

(10) Close this access panel:

(TASK 28-11-11-400-803)

Number	Name/Location
633BB	Surge Tank Access Door - Wing Station 679

(11) Close these access panels:

(TASK 57-21-23-400-801)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Number	Name/Location
634AB	Dry Bay Tank Access Door - Right Wing Station 727
634BB	Dry Bay Tank Access Door - Right Wing Station 748

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Right Outboard Wing Access Holes General Visual (Internal)
Figure 226/57-05-03-990-811

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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	737-6789 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 57-05-03-010-036

(1) Open these access panels:

(TASK 28-11-31-000-801)

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

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) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-809.

SUBTASK 57-05-03-410-036

(4) Close these access panels:

(TASK 28-11-31-400-801)

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

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

INTERNAL-GENERAL VISUAL: INTERNAL_LEFT OUTBOARD WING
Figure 227/57-05-03-990-854 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

2105989 S0000449143_V2

INTERNAL-GENERAL VISUAL: INTERNAL_LEFT OUTBOARD WING
Figure 227/57-05-03-990-854 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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	737-6789 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 57-05-03-010-035

(1) Open these access panels:

(TASK 28-11-31-000-801)

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

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) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-809.

SUBTASK 57-05-03-410-035

(4) Close these access panels:

(TASK 28-11-31-400-801)

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

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

MPD ITEM
57-170-02

D78777 S0000164694_V3

INTERNAL - GENERAL VISUAL: RIGHT OUTBOARD WING
Figure 228/57-05-03-990-853 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SIDE OF BODY RIB

C

REAR SPAR

D

MPD ITEM
57-170-02

2106030 S0000449157_V2

INTERNAL - GENERAL VISUAL: RIGHT OUTBOARD WING
Figure 228/57-05-03-990-853 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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
28-11-11-000-801	Main Tank Access Door Removal (P/B 401)
28-11-11-400-801	Main Tank Access Door Installation (P/B 401)
51-05-01-210-809	737-6789 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 57-05-03-010-034

> **CAUTION** DO NOT REMOVE THE TWO DOORS 532AZ AND 532BZ AT THE SAME TIME. DURING THE PROCEDURE, ONE OF THE DOORS MUST STAY INSTALLED WITH ALL FASTENERS IN IT. IF YOU DO NOT OBEY, DAMAGE TO THE RIB 6 CAN OCCUR.

(1) Open these access panels:

(TASK 28-11-11-000-801)

Number	Name/Location
532AB	Main Tank Access Door - Wing Station 216

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
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

Special Access:

Number	Name/Location
S5321	Left Outboard Internal Wing Inspection

SUBTASK 57-05-03-210-023

(2) Do a General Visual inspection of the inside 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) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-809.

SUBTASK 57-05-03-410-034

(4) Close these access panels:

(TASK 28-11-11-400-801)

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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
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

Restore Special Access:

Number	Name/Location
S5321	Left Outboard Internal Wing Inspection

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

INTERNAL-GENERAL VISUAL: LEFT OUTBOARD WING
Figure 229/57-05-03-990-863 (Sheet 1 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(VIEW IN THE FORWARD DIRECTION)

B

MPD ITEM
57-180-01

2106687 S0000449501_V2

INTERNAL-GENERAL VISUAL: LEFT OUTBOARD WING
Figure 229/57-05-03-990-863 (Sheet 2 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(RIB 14 IS EQUIVALENT)

C

D

MPD ITEM
57-180-01

2106692 S0000449504_V2

INTERNAL-GENERAL VISUAL: LEFT OUTBOARD WING
Figure 229/57-05-03-990-863 (Sheet 3 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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
28-11-11-000-801	Main Tank Access Door Removal (P/B 401)
28-11-11-400-801	Main Tank Access Door Installation (P/B 401)
51-05-01-210-809	737-6789 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 57-05-03-010-033

CAUTION DO NOT REMOVE THE TWO DOORS 632AZ AND 632BZ AT THE SAME TIME. DURING THE PROCEDURE, ONE OF THE DOORS MUST STAY INSTALLED WITH ALL FASTENERS IN IT. IF YOU DO NOT OBEY, DAMAGE TO THE RIB 6 CAN OCCUR.

(1) Open these access panels:

(TASK 28-11-11-000-801)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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

Special Access:

Number	Name/Location
S6321	Right Outboard Internal Wing Inspection

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) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-809.

SUBTASK 57-05-03-410-033

(4) Close these access panels:

(TASK 28-11-11-400-801)

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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
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

Restore Special Access:

Number	Name/Location
S6321	Right Outboard Internal Wing Inspection

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

INTERNAL-GENERAL VISUAL: RIGHT OUTBOARD WING
Figure 230/57-05-03-990-864 (Sheet 1 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(VIEW IN THE FORWARD DIRECTION)

B

MPD ITEM
57-180-02

2106615 S0000449545_V2

INTERNAL-GENERAL VISUAL: RIGHT OUTBOARD WING
Figure 230/57-05-03-990-864 (Sheet 2 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

MPD ITEM
57-180-02

2106637 S0000449546_V2

INTERNAL-GENERAL VISUAL: RIGHT OUTBOARD WING
Figure 230/57-05-03-990-864 (Sheet 3 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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	737-6789 Basic Task Description (P/B 201)
57-21-23-000-801	Dry Bay Access Doors Removal (P/B 401)
57-21-23-400-801	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

SUBTASK 57-05-03-010-032

(1) Open these access panels:

(TASK 28-11-11-000-802 and TASK 57-21-23-000-801)

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) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-806.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 57-05-03-410-032

(4) Close these access panels:

(TASK 28-11-11-400-802, TASK 28-11-11-400-803, and TASK 57-21-23-400-801)

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

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

INTERNAL-GENERAL VISUAL: INTERNAL-LEFT OUTBOARD WING
Figure 231/57-05-03-990-865

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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	737-6789 Basic Task Description (P/B 201)
57-21-23-000-801	Dry Bay Access Doors Removal (P/B 401)
57-21-23-400-801	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

SUBTASK 57-05-03-010-031

(1) Open these access panels:

(TASK 28-11-11-000-802 and TASK 57-21-23-000-801)

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) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-806.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 57-05-03-410-031

(4) Close these access panels:

(TASK 28-11-11-400-802, TASK 28-11-11-400-803, and TASK 57-21-23-400-801)

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

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

INTERNAL-GENERAL VISUAL: RIGHT OUTBOARD WING
Figure 232/57-05-03-990-866

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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	737-6789 Basic Task Description (P/B 201)
53-51-21-000-801	Aft Wing-To-Body Fairing Panel Removal (P/B 401)
53-51-21-400-801	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 57-05-03-010-030

(1) Open this access panel:

(TASK 53-51-21-000-801)

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

NOTE: Flaps extended.

SUBTASK 57-05-03-210-027

(2) Do a General Visual inspection of the left inboard flap inboard track assembly, carriage assembly, forward fitting assembly, aft link and aft link pins.

SUBTASK 57-05-03-910-029

(3) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-802.

SUBTASK 57-05-03-410-030

(4) Close this access panel:

(TASK 53-51-21-400-801)

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

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Flap Support Fairing No. 4 General Visual (Internal)
Figure 233/57-05-03-990-818

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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	737-6789 Basic Task Description (P/B 201)
53-51-21-000-801	Aft Wing-To-Body Fairing Panel Removal (P/B 401)
53-51-21-400-801	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
194BR	Flap Track Lubrication Panel - Aft

D. Inspection

SUBTASK 57-05-03-010-029

(1) Open this access panel:

(TASK 53-51-21-000-801)

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

NOTE: Flaps extended.

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.

SUBTASK 57-05-03-910-030

(3) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-802.

SUBTASK 57-05-03-410-029

(4) Close this access panel:

(TASK 53-51-21-400-801)

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

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

RIGHT WING

FLAP SUPPORT FAIRING NO. 5

A

L02787 S0006584401_V5

Flap Support Fairing No. 5 General Visual (Internal)
Figure 234/57-05-03-990-819

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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	737-6789 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 57-05-03-010-028

(1) Open this access panel:

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

NOTE: Remove flap support forward fairing and deploy flaps.

SUBTASK 57-05-03-210-029

(2) Do a General Visual inspection of the left inboard flap outboard track assembly, carriage assembly, forward fitting assembly, and aft attach fitting.

SUBTASK 57-05-03-910-031

(3) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-802.

SUBTASK 57-05-03-410-028

(4) Close this access panel:

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

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Flap Support Fairing No. 3General Visual (Internal)
Figure 235/57-05-03-990-831

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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	737-6789 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 57-05-03-010-027

(1) Open this access panel:

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

NOTE: Remove flap forward fairings and deploy flaps.

SUBTASK 57-05-03-210-030

(2) Do a General Visual inspection of the right inboard flap outboard track assembly, carriage assembly, forward fitting assembly, and aft attach fitting.

SUBTASK 57-05-03-910-032

(3) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-802.

SUBTASK 57-05-03-410-027

(4) Close this access panel:

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

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Flap Support Fairing No. 6General Visual (Internal)
Figure 236/57-05-03-990-832

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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	737-6789 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 57-05-03-010-025

(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) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-801.

SUBTASK 57-05-03-410-025

(4) Close this access panel:

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

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Flap Support Fairing No. 3 General Visual (Internal)
Figure 237/57-05-03-990-822

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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	737-6789 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 57-05-03-010-026

(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) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-801.

SUBTASK 57-05-03-410-026

(4) Close this access panel:

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

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Flap Support Fairing No. 6 General Visual (Internal)
Figure 238/57-05-03-990-821

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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
27-51-28-000-801	Outboard Flap Outboard Support Forward Fairing Removal (P/B 401)
27-51-28-000-803	Outboard Flap Inboard Support Forward Fairing Removal (P/B 401)
27-51-28-400-801	Outboard Flap Outboard Support Forward Fairing Installation (P/B 401)
27-51-28-400-803	Outboard Flap Inboard Support Forward Fairing Installation (P/B 401)
51-05-01-210-803	737-6789 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 57-05-03-010-024

(1) Open these access panels:

(TASK 27-51-28-000-803 and TASK 27-51-28-000-801)

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

NOTE: Remove flap forward fairings and deploy flaps.

SUBTASK 57-05-03-210-033

(2) Do a General Visual inspection of the left outboard flap inboard and outboard track assemblies, carriage assemblies, forward fitting assemblies, and aft links.

SUBTASK 57-05-03-910-035

(3) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-803.

SUBTASK 57-05-03-410-024

(4) Close these access panels:

(TASK 27-51-28-400-803 and TASK 27-51-28-400-801)

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

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

FLAP SUPPORT FAIRING NO. 1

A

L07766 S0006584327_V3

Flap Support Fairing No. 1General Visual (Internal)
Figure 239/57-05-03-990-827

ECCN 9E991 BOEING PROPRIETARY - See title page for details

K97552 S0006584323_V3

Flap Support Fairing No. 2General Visual (Internal)
Figure 240/57-05-03-990-828

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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
27-51-28-000-801	Outboard Flap Outboard Support Forward Fairing Removal (P/B 401)
27-51-28-000-803	Outboard Flap Inboard Support Forward Fairing Removal (P/B 401)
27-51-28-400-801	Outboard Flap Outboard Support Forward Fairing Installation (P/B 401)
27-51-28-400-803	Outboard Flap Inboard Support Forward Fairing Installation (P/B 401)
51-05-01-210-803	737-6789 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 57-05-03-010-023

(1) Open these access panels:

(TASK 27-51-28-000-803 and TASK 27-51-28-000-801)

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

NOTE: Remove flap forward fairings and deploy flaps.

SUBTASK 57-05-03-210-034

(2) Do a General Visual inspection of the right outboard flap inboard and outboard track assemblies, carriage assemblies, forward fitting assemblies, and aft links.

SUBTASK 57-05-03-910-036

(3) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-803.

SUBTASK 57-05-03-410-023

(4) Close these access panels:

(TASK 27-51-28-400-803 and TASK 27-51-28-400-801)

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

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

L03078 S0006584409_V3

Flap Support Fairing No. 7General Visual (Internal)
Figure 241/57-05-03-990-830

ECCN 9E991 BOEING PROPRIETARY - See title page for details

L06803 S0006584413_V3

Flap Support Fairing No. 8General Visual (Internal)
Figure 242/57-05-03-990-829

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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	737-6789 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 57-05-03-010-021

(1) Open these access panels:

Number	Name/Location
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) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-801.

SUBTASK 57-05-03-410-021

(4) Close these access panels:

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

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

FLAP SUPPORT FAIRING NO. 1

A

L07766 S0006584327_V3

Flap Support Fairing No. 1 General Visual (Internal)
Figure 243/57-05-03-990-825

ECCN 9E991 BOEING PROPRIETARY - See title page for details

K97552 S0006584323_V3

Flap Support Fairing No. 2 General Visual (Internal)
Figure 244/57-05-03-990-826

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-03-210-836

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

(Figure 245)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-801	737-6789 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 57-05-03-010-020

(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: 737-6789 Basic Task Description, TASK 51-05-01-210-801.

SUBTASK 57-05-03-410-020

(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 ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

L03078 S0006584409_V3

Flap Support Fairing No. 7 General Visual (Internal)
Figure 245/57-05-03-990-807 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

L06803 S0006584413_V3

Flap Support Fairing No. 7 General Visual (Internal)
Figure 245/57-05-03-990-807 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-03-210-837

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

(Figure 246)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
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)
51-05-01-210-806	737-6789 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, Structural MLG Beam Access Panel

D. Inspection

SUBTASK 57-05-03-010-019

(1) Open these access panels:

Number	Name/Location
551DT	Upper Inboard Fixed Trailing Edge, MLG Beam Access Panel
551ET	Upper Inboard Fixed Trailing Edge, Structural 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) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 57-05-03-410-019

> **CAUTION**
> MAKE SURE THAT THE SEALS OF PANEL 551ET AND PANEL 651ET ARE INSTALLED BELOW SPOILER NO.6 AND SPOILER NO.7. IF YOU DO NOT OBEY, DAMAGE TO THE SPOILERS CAN OCCUR.

(4) Close these access panels:

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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(a) If it is difficult to force the seal under the spoiler, remove the spoiler and reinstall it (TASK 27-62-71-000-801 and TASK 27-62-71-400-801).

1) Make sure that the seal is under the spoiler.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Left Main Landing Gear Support Structure
Figure 246/57-05-03-990-842 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Left Main Landing Gear Support Structure
Figure 246/57-05-03-990-842 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-03-210-838

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

(Figure 247)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
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)
51-05-01-210-806	737-6789 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 57-05-03-010-018

(1) Open these 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

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) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 57-05-03-410-018

CAUTION

MAKE SURE THAT THE SEALS OF PANEL 551ET AND PANEL 651ET ARE INSTALLED BELOW SPOILER NO.6 AND SPOILER NO.7. IF YOU DO NOT OBEY, DAMAGE TO THE SPOILERS CAN OCCUR.

(4) Close these 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

(a) If it is difficult to force the seal under the spoiler, remove the spoiler and reinstall it (TASK 27-62-71-000-801 and TASK 27-62-71-400-801).

ECCN 9E991 BOEING PROPRIETARY - See title page for details

1) Make sure that the seal is under the spoiler.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Right Main Landing Gear Support Structure General Visual (Internal)
Figure 247/57-05-03-990-840 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

U72323 S0000214265_V2

Right Main Landing Gear Support Structure General Visual (Internal)
Figure 247/57-05-03-990-840 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-03-210-839

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

(Figure 248)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-806	737-6789 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 57-05-03-010-017

(1) Open these 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

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) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 57-05-03-410-017

(4) Close these 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

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Aft side of left wing rear spar in zone 551
Figure 248/57-05-03-990-867 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Aft side of left wing rear spar in zone 551
Figure 248/57-05-03-990-867 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-03-210-840

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

(Figure 249)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-806	737-6789 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
651EB	Lower Inboard Fixed Trailing Edge, MLG Attach Fitting Access Panel

D. Inspection

SUBTASK 57-05-03-010-016

(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
651EB	Lower Inboard Fixed Trailing Edge, MLG Attach Fitting 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) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 57-05-03-410-016

(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
651EB	Lower Inboard Fixed Trailing Edge, MLG Attach Fitting Access Panel

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Aft side of right wing rear spar in zone 651
Figure 249/57-05-03-990-868 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Aft side of right wing rear spar in zone 651
Figure 249/57-05-03-990-868 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-03-210-841

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

(Figure 250)

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	737-6789 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
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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
572AB	Lower Aileron, Hinge Cover - WBL 423.00
572BB	Lower Aileron, Actuator Rod Fairing - WBL 427.00
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 57-05-03-040-002

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

SUBTASK 57-05-03-010-015

(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
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 427.00
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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Special Access:

Number	Name/Location
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: 737-6789 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 57-05-03-410-015

(6) Close 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
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 427.00
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 57-05-03-440-002

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

SUBTASK 57-05-03-860-005

(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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

LEFT WING ACCESS DOORS (BOTTOM VIEW)

A

MPD ITEM
57-270-01

D80988 S0000165188_V3

INTERNAL-GENERAL VISUAL: LEFT WING OUTBOARD TRAILING EDGE STRUCTURE
Figure 250/57-05-03-990-861 (Sheet 1 of 6)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

AILERON HINGE COVER ACCESS PANELS

B

MPD ITEM
57-270-01

C

D81083 S0000165189_V3

INTERNAL-GENERAL VISUAL: LEFT WING OUTBOARD TRAILING EDGE STRUCTURE
Figure 250/57-05-03-990-861 (Sheet 2 of 6)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

MPD ITEM
57-270-01

D81092 S0000165190_V3

INTERNAL-GENERAL VISUAL: LEFT WING OUTBOARD TRAILING EDGE STRUCTURE
Figure 250/57-05-03-990-861 (Sheet 3 of 6)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

MPD ITEM
57-270-01

D81166 S0000165191_V4

INTERNAL-GENERAL VISUAL: LEFT WING OUTBOARD TRAILING EDGE STRUCTURE
Figure 250/57-05-03-990-861 (Sheet 4 of 6)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

LEFT WING

(SPOILER DEPLOYED)

F

FWD

INBD

MPD ITEM
57-270-01

D85114 S0000167096_V3

INTERNAL-GENERAL VISUAL: LEFT WING OUTBOARD TRAILING EDGE STRUCTURE
Figure 250/57-05-03-990-861 (Sheet 5 of 6)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

LEFT WING

MPD ITEM
57-270-01

D85115 S0000167097_V3

INTERNAL-GENERAL VISUAL: LEFT WING OUTBOARD TRAILING EDGE STRUCTURE
Figure 250/57-05-03-990-861 (Sheet 6 of 6)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-03-210-842

44. INTERNAL - GENERAL VISUAL: RIGHT 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	737-6789 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 Door Adjustment
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
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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
672AB	Lower Aileron, Hinge Cover - WBL 423.00
672BB	Lower Aileron, Actuator Rod Fairing - WBL 427.00
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 57-05-03-040-003

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

SUBTASK 57-05-03-010-014

(3) Open these access panels:

Number	Name/Location
651AB	Lower Inboard Fixed Trailing Edge Access Panel
651BB	Lower Inboard Fixed Trailing Edge, Gear Door Adjustment
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
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 427.00
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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Special Access:

Number	Name/Location
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: 737-6789 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 57-05-03-410-014

(6) Close these access panels:

Number	Name/Location
651AB	Lower Inboard Fixed Trailing Edge Access Panel
651BB	Lower Inboard Fixed Trailing Edge, Gear Door Adjustment
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
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 427.00
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 57-05-03-440-003

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

SUBTASK 57-05-03-860-006

(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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

RIGHT WING ACCESS DOORS
(BOTTOM VIEW)

A

MPD ITEM
57-270-02

D81374 S0000165193_V3

INTERNAL-GENERAL VISUAL: INTERNAL-RIGHT WING OUTBOARD TRAILING EDGE STRUCTURE
Figure 251/57-05-03-990-862 (Sheet 1 of 6)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

AILERON HINGE COVER ACCESS PANELS

B

D81415 S0000165194_V3

INTERNAL-GENERAL VISUAL: INTERNAL-RIGHT WING OUTBOARD TRAILING EDGE STRUCTURE
Figure 251/57-05-03-990-862 (Sheet 2 of 6)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

D

MPD ITEM
57-270-02

D81419 S0000165195_V3

INTERNAL-GENERAL VISUAL: INTERNAL-RIGHT WING OUTBOARD TRAILING EDGE STRUCTURE
Figure 251/57-05-03-990-862 (Sheet 3 of 6)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

MPD ITEM
57-270-02

D81429 S0000165196_V4

INTERNAL-GENERAL VISUAL: INTERNAL-RIGHT WING OUTBOARD TRAILING EDGE STRUCTURE
Figure 251/57-05-03-990-862 (Sheet 4 of 6)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

RIGHT WING

(SPOILER DEPLOYED)

F

MPD ITEM
57-270-02

D84704 S0000167094_V3

INTERNAL-GENERAL VISUAL: INTERNAL-RIGHT WING OUTBOARD TRAILING EDGE STRUCTURE
Figure 251/57-05-03-990-862 (Sheet 5 of 6)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

RIGHT WING

D85111 S0000167095_V3

INTERNAL-GENERAL VISUAL: INTERNAL-RIGHT WING OUTBOARD TRAILING EDGE STRUCTURE
Figure 251/57-05-03-990-862 (Sheet 6 of 6)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-03-210-843

45. INTERNAL - GENERAL VISUAL: LEFT INBOARD GROUND SPOILER

(Figure 252)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-801	737-6789 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 57-05-03-010-013

(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) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-801.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

389895 S0000136332_V2

Left Inboard Ground Spoiler General Visual (Internal)
Figure 252/57-05-03-990-808 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

INBOARD GROUND SPOILER

B

ACTUATOR (EXAMPLE)

C

390046 S0000136333_V2

Left Inboard Ground Spoiler General Visual (Internal)
Figure 252/57-05-03-990-808 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-03-210-844

46. INTERNAL - GENERAL VISUAL: RIGHT INBOARD GROUND SPOILER

(Figure 253)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-801	737-6789 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 57-05-03-010-012

(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) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-801.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

390284 S0000136334_V2

Right Inboard Ground Spoiler General Visual (Internal)
Figure 253/57-05-03-990-809 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

INBOARD GROUND SPOILER

B

ACTUATOR (EXAMPLE)

C

390394 S0000136335_V2

Right Inboard Ground Spoiler General Visual (Internal)
Figure 253/57-05-03-990-809 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-03-210-845

47. INTERNAL - GENERAL VISUAL: LEFT INBOARD FLAP

(Figure 254)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-806	737-6789 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 57-05-03-010-011

(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) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 57-05-03-410-011

(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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

ACCESS PANELS

A

MPD ITEM
57-300-01

D74890 S0000164312_V3

INTERNAL - GENERAL VISUAL: LEFT INBOARD FLAP
Figure 254/57-05-03-990-849 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

LEFT INBOARD MAIN FLAP
(UPPER PANELS NOT SHOWN)

B

MPD ITEM
57-300-01

D75516 S0000164313_V3

INTERNAL - GENERAL VISUAL: LEFT INBOARD FLAP
Figure 254/57-05-03-990-849 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-03-210-846

48. INTERNAL - GENERAL VISUAL: RIGHT INBOARD FLAP

(Figure 255)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-806	737-6789 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 57-05-03-010-010

(1) Open these 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

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) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 57-05-03-410-010

(4) Close these 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

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

MPD ITEM
57-300-02

D75591 S0000164304_V3

INTERNAL - GENERAL VISUAL: RIGHT INBOARD FLAP
Figure 255/57-05-03-990-848 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

RIGHT INBOARD MAIN FLAP
(UPPER PANELS NOT SHOWN)

B

MPD ITEM
57-300-02

D75034 S0000164305_V3

INTERNAL - GENERAL VISUAL: RIGHT INBOARD FLAP
Figure 255/57-05-03-990-848 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-03-210-847

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

(Figure 256)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-806	737-6789 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 57-05-03-010-009

(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) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 57-05-03-410-009

(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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

408750 S0000136577_V2

Left Outboard Wing Rear Spar General Visual (Internal)
Figure 256/57-05-03-990-812 (Sheet 1 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

B

408752 S0000136578_V3

Left Outboard Wing Rear Spar General Visual (Internal)
Figure 256/57-05-03-990-812 (Sheet 2 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

408818 S0000136580_V3

Left Outboard Wing Rear Spar General Visual (Internal)
Figure 256/57-05-03-990-812 (Sheet 3 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-03-210-848

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

(Figure 257)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-806	737-6789 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 57-05-03-010-008

(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) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 57-05-03-410-008

(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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

408797 S0000136581_V2

Right Outboard Wing Rear Spar General Visual (Internal)
Figure 257/57-05-03-990-813 (Sheet 1 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

B

408779 S0000136583_V3

Right Outboard Wing Rear Spar General Visual (Internal)
Figure 257/57-05-03-990-813 (Sheet 2 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

C

408820 S0000136585_V3

Right Outboard Wing Rear Spar General Visual (Internal)
Figure 257/57-05-03-990-813 (Sheet 3 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-03-210-849

51. INTERNAL - GENERAL VISUAL: LEFT OUTBOARD FLAP

(Figure 258)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-806	737-6789 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 57-05-03-010-022

(1) Open these 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

NOTE: Deploy aft flap so that aft flap tracks do not block view of rear spar lower chord.

(a) If it is installed, 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.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

1) These panels are:

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

2) Remove the bolts [3] that attach the leading edge skin panel [2].

3) Remove the leading edge skin panel [2] from the main flap assembly [1].

SUBTASK 57-05-03-210-049

(2) 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

(3) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 57-05-03-410-022

(4) Close these 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

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

1) These panels are:

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

2) Put the leading edge skin panel [2] in its location on the leading edge of the main flap assembly [1].

3) Apply compound, C00528 to the holes for the bolts [3].

4) Install the bolts [3] to attach the leading edge skin panel [2].

5) 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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

General Visual: Left Outboard Flap
Figure 258/57-05-03-990-846 (Sheet 1 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

LEFT OUTBOARD MAIN FLAP
(UPPER ACCESS PANELS NOT SHOWN)

B

MPD ITEM
57-330-01

D76291 S0000164273_V3

General Visual: Left Outboard Flap
Figure 258/57-05-03-990-846 (Sheet 2 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

2485112 S0000584882_V1

General Visual: Left Outboard Flap
Figure 258/57-05-03-990-846 (Sheet 3 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-03-210-850

52. INTERNAL - GENERAL VISUAL: RIGHT OUTBOARD FLAP

(Figure 259)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-806	737-6789 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 57-05-03-010-007

(1) Open these 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

NOTE: Deploy aft flap so that aft flap tracks do not block view of rear spar lower chord.

(a) If it is installed, 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.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

1) These panels are:

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

2) Remove the bolts [3] that attach the leading edge skin panel [2].

3) Remove the leading edge skin panel [2] from the main flap assembly [1].

SUBTASK 57-05-03-210-050

(2) 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

(3) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 57-05-03-410-007

(4) Close these 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

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

1) These panels are:

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

2) Put the leading edge skin panel [2] in its location on the leading edge of the main flap assembly [1].

3) Apply compound, C00528 to the holes for the bolts [3].

4) Install the bolts [3] to attach the leading edge skin panel [2].

5) 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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

General Visual: Right Outboard Flap
Figure 259/57-05-03-990-847 (Sheet 1 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

RIGHT OUTBOARD MAIN FLAP
(UPPER ACCESS PANELS NOT SHOWN)
(SPOILERS DEPLOYED)

B

MPD ITEM
57-330-02

D76478 S0000164296_V3

General Visual: Right Outboard Flap
Figure 259/57-05-03-990-847 (Sheet 2 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

2487050 S0000585411_V1

General Visual: Right Outboard Flap
Figure 259/57-05-03-990-847 (Sheet 3 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-03-211-803

53. INTERNAL - SPECIAL DETAILED: LEFT WINGLET

Figure 260

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-806	737-6789 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
527	Left Winglet

C. Access Panels

Number	Name/Location
527AB	Winglet Access Panel

D. Inspection

SUBTASK 57-05-03-010-004

(1) Open this access panel:

Number	Name/Location
527AB	Winglet Access Panel

NOTE: Access through cover 527AB.

SUBTASK 57-05-03-211-003

(2) Do a Special Detailed inspection of the aluminum rib structure at winglet stations 0, 1, and 4. Use a boroscope to examine the flanges adjacent to skin panels and spars.

SUBTASK 57-05-03-910-053

(3) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 57-05-03-410-004

(4) Close this access panel:

Number	Name/Location
527AB	Winglet Access Panel

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Left Winglet Special Detailed (Internal)
Figure 260/57-05-03-990-873

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-03-211-804

54. INTERNAL - SPECIAL DETAILED: RIGHT WINGLET

Figure 261

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-806	737-6789 Basic Task Description (P/B 201)

B. Location Zones

Zone	Area
627	Right Winglet

C. Access Panels

Number	Name/Location
627AB	Winglet Access Panel

D. Inspection

SUBTASK 57-05-03-010-003

(1) Open this access panel:

Number	Name/Location
627AB	Winglet Access Panel

NOTE: Access through cover 627AB.

SUBTASK 57-05-03-211-004

(2) Do a Special Detailed inspection of the aluminum rib structure at winglet stations 0, 1, and 4. Use a boroscope to examine the flanges adjacent to skin panels and spars.

SUBTASK 57-05-03-910-054

(3) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-806.

SUBTASK 57-05-03-410-003

(4) Close this access panel:

Number	Name/Location
627AB	Winglet Access Panel

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Right Winglet Special Detailed (Internal)
Figure 261/57-05-03-990-875

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-03-211-805

55. INTERNAL - DETAILED: LEFT WINGLET

(Figure 262)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-804	737-6789 Basic Task Description (P/B 201)
57-21-21-000-801	Winglet Removal (P/B 401)
57-21-21-400-801	Winglet Installation (P/B 401)
57-21-23-000-801	Dry Bay Access Doors Removal (P/B 401)
57-21-23-400-801	Dry Bay Access Doors Installation (P/B 401)

B. Location Zones

Zone	Area
527	Left Winglet

C. Access Panels

Number	Name/Location
527AB	Winglet Access Panel
534BB	Dry Bay Tank Access Door - Left Wing Station 748

D. Inspection

SUBTASK 57-05-03-010-002

(1) Open these access panels:

(TASK 57-21-23-000-801)

Number	Name/Location
527AB	Winglet Access Panel
534BB	Dry Bay Tank Access Door - Left Wing Station 748

NOTE: Remove winglet assembly. Remove winglet access panels as noted. Remove barrel nuts to facilitate inspection of recesses.

SUBTASK 57-05-03-010-056

(2) Do this task: Winglet Removal, TASK 57-21-21-000-801.

SUBTASK 57-05-03-211-005

(3) Do a Detailed inspection of the upper and lower flanges and webs, including barrel nut holes, Winglet Rib 0 and Wing Rib 27, WBL 658.17.

SUBTASK 57-05-03-910-055

(4) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-804.

SUBTASK 57-05-03-410-056

(5) Do this task: Winglet Installation, TASK 57-21-21-400-801.

SUBTASK 57-05-03-410-002

(6) Close these access panels:

(TASK 57-21-23-400-801)

Number	Name/Location
527AB	Winglet Access Panel
534BB	Dry Bay Tank Access Door - Left Wing Station 748

ECCN 9E991 BOEING PROPRIETARY - See title page for details

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Left Winglet
Figure 262/57-05-03-990-869 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

B

U71852 S0000211780_V2

Left Winglet
Figure 262/57-05-03-990-869 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-05-03-211-806

56. INTERNAL - DETAILED: RIGHT WINGLET

(Figure 263)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-804	737-6789 Basic Task Description (P/B 201)
57-21-21-000-801	Winglet Removal (P/B 401)
57-21-21-400-801	Winglet Installation (P/B 401)
57-21-23-000-801	Dry Bay Access Doors Removal (P/B 401)
57-21-23-400-801	Dry Bay Access Doors Installation (P/B 401)

B. Location Zones

Zone	Area
627	Right Winglet

C. Access Panels

Number	Name/Location
627AB	Winglet Access Panel
634BB	Dry Bay Tank Access Door - Right Wing Station 748

D. Inspection

SUBTASK 57-05-03-010-001

(1) Open these access panels:

(TASK 57-21-23-000-801)

Number	Name/Location
627AB	Winglet Access Panel
634BB	Dry Bay Tank Access Door - Right Wing Station 748

NOTE: Remove winglet assembly. Remove winglet access panels as noted. Remove barrel nuts to facilitate inspection of recesses.

SUBTASK 57-05-03-010-057

(2) Do this task: Winglet Removal, TASK 57-21-21-000-801.

SUBTASK 57-05-03-211-006

(3) Do a Detailed inspection of the upper and lower flanges and webs, including barrel nut holes, Winglet Rib 0 and Wing Rib 27, WBL 658.17.

SUBTASK 57-05-03-910-056

(4) Do this task: 737-6789 Basic Task Description, TASK 51-05-01-210-804.

SUBTASK 57-05-03-410-057

(5) Do this task: Winglet Installation, TASK 57-21-21-400-801

SUBTASK 57-05-03-410-001

(6) Close these access panels:

(TASK 57-21-23-400-801)

Number	Name/Location
627AB	Winglet Access Panel
634BB	Dry Bay Tank Access Door - Right Wing Station 748

ECCN 9E991 BOEING PROPRIETARY - See title page for details

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

U71871 S0000211785_V3

Right Winglet
Figure 263/57-05-03-990-870 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

B

U71876 S0000211786_V2

Right Winglet
Figure 263/57-05-03-990-870 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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. 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 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 57-14-00-370-005

(2) Apply 2 coats 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 57-14-00-370-004

(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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

WING CENTER SECTION

A

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

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

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CENTER WING SECTION LOWER SKIN

B

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

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MAIN LANDING GEAR SUPPORT BEAM - CORROSION PREVENTION

1. **General**
   A. Corrosion and stress corrosion cracks can occur on the main landing gear support beam.
   B. Corrosion can occur on the bolts that connect the landing gear beams to the flap track support fitting and swing link.
   C. Stress corrosion cracks can occur in the forward and aft lugs of the swing 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. Stress corrosion cracks have been found on four main landing gear beam swing links. On one link, the crack was in the aft lug of the forward clevis at BS 695. On the other three links, the crack was in the forward lug of aft clevis at BS 706. Stress corrosion also broke bolts at the link attachment to the body frame at Sta 706 and at the link-to-beam attachment.
   G. Corrosion can occur on the stabilizer and its attach fitting at the landing gear beam.
   H. Corrosion has been found on the mating surfaces of the stabilizer link assembly of the support beam and on components of the stabilizer link.
   I. The wing wheel well is exposed to atmospheric pollutants and runway splash, and is susceptible to corrosion.
   J. The wing well should be treated for corrosion at the same time as the wing torque box, trunnion and trunnion support fittings

TASK 57-15-00-910-801

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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

C. Consumable Materials

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

D. Location Zones

Zone	Area
734	Left Main Landing Gear
744	Right Main Landing Gear

E. Procedure

SUBTASK 57-15-00-370-001

(1) At first opportunity consistent with the scheduled maintenance activity, apply corrosion prevention treatment to the main landing gear trunnion support structure.

SUBTASK 57-15-00-200-002

(2) Periodically inspect the main landing gear beam and the forward trunnion fitting attached to the rear spar for damaged finish and evidence of corrosion.

SUBTASK 57-15-00-370-002

(3) Apply water displacing corrosion inhibiting compound to landing gear beams.

SUBTASK 57-15-00-910-001

(4) Remove runway debris and clean the entire wheel well area.

SUBTASK 57-15-00-370-003

(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 57-15-00-370-004

(6) Apply corrosion inhibiting compound, G00009 to landing gear attachment fittings. Make sure to apply the compound to lugs and lug faces.

SUBTASK 57-15-00-370-005

(7) Regrease all grease fittings in the treatment area.

SUBTASK 57-15-00-370-006

(8) After cleaning the wheel well with steam or high pressure water and detergent, apply corrosion inhibiting compound, G00009.

SUBTASK 57-15-00-200-003

(9) Periodically inspect heavily loaded structural members and wheel well closure walls for deterioration of protective finishes.

SUBTASK 57-15-00-370-007

(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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Main Landing Gear Support Beam - Corrosion Prevention
Figure 201/57-15-00-990-804 (Sheet 1 of 2)

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Main Landing Gear Support Beam - Corrosion Prevention
Figure 201/57-15-00-990-804 (Sheet 2 of 2)

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MAIN LANDING GEAR SUPPORT BEAM - REMOVAL/INSTALLATION

1. General

A. There are two tasks in this procedure. There is one task for the removal and one task for the installation of a landing gear support beam.

(1) The removal procedure has these parts:

(a) The removal of the fuel from the airplane

(b) The removal of the inboard trailing edge flap

(c) The removal of one main landing gear

(d) The removal of the main gear wing door

(e) The removal of the flap track fairing

(f) The removal of the inboard ground spoiler

(g) The inspection of the rear spar bushings.

(h) The removal of the surrounding panels

(i) The removal of a landing gear support beam.

(2) The installation procedure has these parts:

(a) The installation of the Inboard ground spoiler.

(b) The installation of a landing gear support beam

(c) The installation of the upper and lower stabilizer links

(d) The installation of the surrounding panels

(e) The installation of one main landing gear

(f) The installation of the inboard trailing edge flap

(g) The installation of the main gear wing door

(h) The installation of the fairings for the inboard flap track

(3) The landing gear support beam will be referred to as the support beam.

TASK 57-15-00-000-801

2. Landing Gear Support Beam Removal

(Figure 401)

A. References

Reference	Title
27-51-15-000-802	Inboard Flap Inboard Track Removal (P/B 401)
27-51-18-000-802	Inboard Flap Support Aft Fairing Removal (P/B 401)
27-51-31-000-801	Inboard Flap Outboard Transmission Removal (P/B 401)
27-51-31-000-802	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	Wheel Well 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)
32-11-00-000-801	Main Landing Gear Removal (P/B 401)
32-13-21-000-802	Main Landing Gear Wing Door Removal (P/B 401)

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(Continued)

Reference	Title
32-32-11-000-801	Removal of the Actuator Assembly for the Main Gear (P/B 401)
57-15-00-200-801	Landing Gear Support Beam - Inspection (P/B 601)

B. Location Zones

Zone	Area
734	Left Main Landing Gear
744	Right Main Landing Gear

C. 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, Structural 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
651FB	Lower Inboard Fixed Trailing Edge, Landing Gear Access Panel

D. Prepare to Remove the Support Beam

SUBTASK 57-15-00-860-001

(1) To defuel the wing fuel tanks, do this task: Fuel Tank Defueling, TASK 28-26-00-650-801.

SUBTASK 57-15-00-860-002

(2) To remove the applicable inboard trailing edge flap, do this task: Inboard Flap Inboard Transmission Removal, TASK 27-51-31-000-802.

SUBTASK 57-15-00-860-003

(3) Lower the trailing edge flaps.

SUBTASK 57-15-00-020-002

(4) To remove the applicable main landing gear, do this task: Main Landing Gear Removal, TASK 32-11-00-000-801.

SUBTASK 57-15-00-010-001

(5) To remove the wing door, do this task: Main Landing Gear Wing Door Removal, TASK 32-13-21-000-802.

SUBTASK 57-15-00-010-002

(6) To remove the fairing for the inboard flap track, do this task: Inboard Flap Support Aft Fairing Removal, TASK 27-51-18-000-802.

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SUBTASK 57-15-00-010-003

(7) To remove the applicable inboard ground spoiler, do this task: Inboard Ground Spoiler Removal, TASK 27-62-12-000-801.

SUBTASK 57-15-00-200-001

(8) At the fitting on the rear spar holding the outboard end of the support beam, 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 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 57-15-00-010-004

(9) Remove the applicable panels surrounding the main landing gear support beam:

(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
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, Structural MLG Beam Access Panel
551FB	Lower Inboard Fixed Trailing Edge, Landing Gear Access Panel

(b) On the right wing, remove these access panels:

Number	Name/Location
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

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E. Landing Gear Support Beam Removal

SUBTASK 57-15-00-020-003

(1) Remove the upper and lower stabilizer links (Figure 401).

(a) Remove the cotter pin [8], nut [7], fuse pin [4], washer [5], and washer [6] which connect the forward end of the lower stabilizer link [3] to the attach fitting on the rear spar.

(b) Disconnect the bonding jumper.

(c) Remove the cotter pin [8], nut [7], fuse pin [4], washer [5], and washer [6] which connect the aft end of the lower stabilizer link [3] to the attach fitting on the support beam.

(d) Disconnect the jumper.

(e) Remove the four bolts [9] and four collars [10] which connect the two tray brackets to the upper stabilizer link [14].

(f) Remove the cotter pin [13], nut [12], bolt [15], washer [16], and washer [11] which connect the aft end of the upper stabilizer link [14] to the attach fitting on the support beam.

(g) Remove the cotter pin [8], nut [7], fuse pin [4], washer [5], and washer [6] which connect the forward end of the upper stabilizer link [14] to the attach fitting on the rear spar.

(h) Disconnect the bonding jumper.

(i) If it is necessary, remove the bolts from the upper and lower stabilizer link attach fittings on the support beam,.

1) Remove the attach fittings from the support beam.

2) Make a note of the location of the shims.

SUBTASK 57-15-00-020-004

(2) To remove the walking beam hanger fitting, the walking beam, and the actuator, do this task: Removal of the Actuator Assembly for the Main Gear, TASK 32-32-11-000-801.

SUBTASK 57-15-00-020-005

(3) To remove the two ground spoiler actuators from the aft side of the support beam, do this task: Inboard Ground Spoiler Actuator Removal, TASK 27-62-71-000-801.

(a) Also, remove the two spoiler hinge supports, if necessary.

SUBTASK 57-15-00-020-006

(4) 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 57-15-00-020-007

(5) Disconnect the necessary electrical wires from the support beam.

(a) Make sure that there is no tension in the wires.

NOTE: The wires must be loose for removal of the support beam.

SUBTASK 57-15-00-970-001

(6) Make a note of the location of the wires.

SUBTASK 57-15-00-020-008

(7) To remove the inboard flap inboard transmission, do this task: Inboard Flap Inboard Transmission Removal, TASK 27-51-31-000-802.

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SUBTASK 57-15-00-020-009

(8) To remove the inboard flap outboard transmission if necessary, do this task: Inboard Flap Outboard Transmission Removal, TASK 27-51-31-000-801.

SUBTASK 57-15-00-020-010

(9) To remove the main landing gear beam angle gear box from the aft side of the support beam, do this task: Main Landing Gear Beam Angle Gearbox Removal, TASK 27-51-56-000-801.

SUBTASK 57-15-00-010-005

(10) To remove the inboard torque tube, do this task: Wheel Well Flap Torque Tube Removal, TASK 27-51-58-000-803.

SUBTASK 57-15-00-010-006

(11) To remove the inboard flap track, do this task: Inboard Flap Inboard Track Removal, TASK 27-51-15-000-802.

SUBTASK 57-15-00-020-011

WARNING THE SUPPORT BEAM WEIGHS MORE THAN 250 LB (113.4 KG). WITHOUT CORRECT TOOLS TO SUPPORT THIS WEIGHT, INJURY TO PERSONS AND/OR DAMAGE TO THE EQUIPMENT CAN OCCUR.

(12) Remove the main landing gear support beam [1] or main landing gear support beam [2]:

(a) Hold the support beam in its position.

(b) Disconnect the hanger link [39] from the support beam, do these steps (Figure 401):

1) Remove the pin [20], bolt [17], countersunk washer [18], two caps [19], washer [21], self-locking nut [22], nut [23], collars [24], radius filler [25], bolt [26], washers [27], washers [28], and washers [29] from the hanger link.

NOTE: Make a note of the location of all of the washers.

2) Keep all of the washers.

3) Inspect the hanger link lower bushings [55] for wear (TASK 57-15-00-200-801).

4) If any of these bushings are found outside of the wear limits, remove the hanger link [39].

5) To remove the hanger link [39] from the airplane, do these steps:

a) Remove the pin [43], bolt [40], countersunk washer [41], caps [42], washer [46], self-locking nut [44], nut [45], collar [49], radius filler [48], bolt [47], self-locking nut [50], bolt [54], countersunk washer [53], washer [51], and bushing [52].

b) Remove the hanger link [39].

c) Inspect all the hanger link bushings [55] (TASK 57-15-00-200-801).

d) Replace all bushings that are found to be out of limits.

6) If you will not remove the hanger link [39] from the airplane, do these steps (Figure 401):

a) Swing the hanger link [39] inboard.

b) Hold the lower end of the hanger link [39] inboard by temporarily fastening it.

NOTE: This will allow removal of the support beam.

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> **WARNING** THE SUPPORT BEAM WEIGHS MORE THAN 250 LB (113.4 KG). WITHOUT CORRECT TOOLS TO SUPPORT THIS WEIGHT, INJURY TO PERSONS AND/OR DAMAGE TO THE EQUIPMENT CAN OCCUR.

7) If you will remove the hanger link [39] from the airplane, do these steps:
   a) Remove the pin [43], bolt [40], countersunk washer [41], caps [42], washer [46], self-locking nut [44], nut [45], collar [49], radius filler [48], bolt [47], self-locking nut [50], bolt [54], countersunk washer [53], washer [51], and bushing [52].
   b) Remove the hanger link [39].

(c) Remove the nut [30], washer [31], washer [32], and bolt [33] (4 locations) from the attach fitting at the inboard end of the support beam.

NOTE: This attach fitting connects the support beam to the inboard flap track. See illustration.

(d) Remove the outboard attach the fuse pin [34], two bolts [35], two washers [36], two bushings [37], and two nuts [38].

(e) Carefully remove the support beam.
   1) Move the support beam inboard until it is clear of the fitting at the outboard end, electrical wire bundles, fire extinguishing tube, and hydraulic tubes.
   2) Lower the outboard end of the beam and move the beam outboard.
   3) Remove the support beam from the airplane.

END OF TASK

TASK 57-15-00-400-801

3. Landing Gear Support Beam Installation

(Figure 401)

A. References

Reference	Title
12-25-07-600-801	Lubricate the Support Beam Assembly of the Main Landing Gear (P/B 301)
27-51-11-400-801	Inboard Trailing Edge Flap Installation (P/B 401)
27-51-15-400-802	Inboard Flap Inboard Track Installation (P/B 401)
27-51-18-400-802	Inboard Flap Support Aft Fairing Installation (P/B 401)
27-51-31-400-801	Inboard Flap Outboard Transmission Installation (P/B 401)
27-51-31-400-802	Inboard Flap Inboard Transmission Installation (P/B 401)
27-51-56-400-801	Main Landing Gear Beam Angle Gearbox Installation (P/B 401)
27-51-58-400-802	Inboard Wing Flap Torque Tube Installation (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)
32-11-00-400-801	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	Installation of the Actuator Assembly for the Main Gear (P/B 401)

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B. Consumable Materials

Reference	Description	Specification
D00633	Grease - Aircraft General Purpose	BMS3-33

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, Structural 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
651FB	Lower Inboard Fixed Trailing Edge, Landing Gear Access Panel

E. Landing Gear Support Beam Installation

SUBTASK 57-15-00-420-002

WARNING THE SUPPORT BEAM WEIGHS MORE THAN 250 LB (113.4 KG). WITHOUT CORRECT TOOLS TO SUPPORT THIS WEIGHT, INJURY TO PERSONS AND/OR DAMAGE TO THE EQUIPMENT CAN OCCUR.

(1) Install the outboard end of the main landing gear support beam [1] or main landing gear support beam [2].

(a) Put the support beam 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.

(b) Attach the support beam to the rear spar support fitting.

1) Apply a thin layer of grease, D00633, to the outer diameter and threads of the outboard attach fuse pin [34].

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2) Install the outboard attach fuse pin [34], two bolts [35], two washers [36], two bushings [37], and two nuts [38] to connect the rear spar support fitting and the outboard end of the support beam.

a) Tighten the nuts [38] on the bolts [35] to 250 in-lb (28.2 N·m) - 300 in-lb (33.9 N·m).

SUBTASK 57-15-00-420-003

(2) Reconnect the inboard end of the main landing gear support beam [1] or main landing gear support beam [2] to the airplane as follows:

(a) Install the attach fitting at the inboard end of the support beam.

1) Put the attach fitting into its place.

2) Install the nut [30], nut [30A], washer [31], washer [31A], washer [32], washer [32A], bolt [33], and bolt [33A].

(b) If you removed the hanger link [39] from the airplane, do these steps:

1) Put the hanger link [39] into its position.

a) Before installation the pin [43], apply a light coat of grease, D00633, to its outer diameter and threads.

b) Install the pin [43], bolt [40], countersunk washer [41], caps [42], washer [46], self-locking nut [44], nut [45], collars [49], radius fillers [48], and bolt [47].

c) Tighten the nut [45] to 1000 in-lb (113.0 N·m) - 2000 in-lb (226.0 N·m).

d) Tighten the self-locking nut [44] to 1000 in-lb (113.0 N·m) - 1200 in-lb (135.6 N·m).

2) Install the bolt [54], self-locking nut [50], countersunk washer [53], washer [51], and bushing [52].

a) Before you install the bushing, apply a light coat of grease, grease, D00633, to its outer diameter.

b) Tighten the self-locking nut [50] to 480 in-lb (54.2 N·m) - 790 in-lb (89.3 N·m).

(c) To connect the lower end of the hanger link [39] to the support beam, do these steps:

1) Install the pin [20], two nuts [23], two collars [24], two radius fillers [25], two bolts [26], washer [27], washer [28], and washer [29] on the hanger link [39], (Figure 401).

NOTE: Install the washer [27], washer [28], and washer [29] between the bushing 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.

a) Apply a light coat of grease, D00633 on the outer diameter and threads of the pin [20].

b) Tighten the nut [23] to 1000 in-lb (113.0 N·m) - 2000 in-lb (226.0 N·m).

2) Install the bolt [17], washer [18], two caps [19], washer [21], and self-locking nut [22].

3) Tighten the self-locking nut [22] to 1000 in-lb (113.0 N·m) - 1200 in-lb (135.6 N·m).

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WARNING	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.

(d) Make sure that there is a minimum distance of 0.13 in. (3.302 mm) between the wire bundles and hangar 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.

(e) Apply grease, D00633, through all grease fittings on the hanger link until grease can be seen coming out.

SUBTASK 57-15-00-420-004

(3) To attach the inboard flap inboard track to the support beam, do this task: Inboard Flap Inboard Track Installation, TASK 27-51-15-400-802.

SUBTASK 57-15-00-420-005

(4) To install the inboard flap inboard transmission, do this task: Inboard Flap Inboard Transmission Installation, TASK 27-51-31-400-802.

SUBTASK 57-15-00-420-006

(5) To install the inboard flap outboard transmission, if it is necessary, do this task: Inboard Flap Outboard Transmission Installation, TASK 27-51-31-400-801.

SUBTASK 57-15-00-020-012

(6) To install the main landing gear beam angle gear box on the aft side of the support beam, do this task: Main Landing Gear Beam Angle Gearbox Installation, TASK 27-51-56-400-801.

SUBTASK 57-15-00-410-001

(7) To install the flap torque tubes, do this task: Inboard Wing Flap Torque Tube Installation, TASK 27-51-58-400-802.

SUBTASK 57-15-00-860-004

(8) Remove the support tools from the support beam.

SUBTASK 57-15-00-420-007

(9) To install the ground spoiler actuator, do this task: Inboard Ground Spoiler Actuator Installation, TASK 27-62-71-400-801.

SUBTASK 57-15-00-420-008

(10) Attach all hydraulic tubes to the support beam.

SUBTASK 57-15-00-420-009

(11) Attach all of the electrical wires to the support beam.

SUBTASK 57-15-00-420-010

(12) To install the walking beam hanger fitting, walking beam, and actuator, do this task: Installation of the Actuator Assembly for the Main Gear, TASK 32-32-11-400-801.

SUBTASK 57-15-00-420-011

(13) Install the upper and lower stabilizer links:

(a) If it is necessary, install the attach fittings for the upper and lower stabilizer links to the support beam.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(b) Install the lower stabilizer link [3]:

1) Install the cotter pin [8], nut [7], fuse pin [4], washer [5], and washer [6] which connect the forward end of the lower stabilizer link [3] to the attach fitting on the rear spar.

a) Tighten the nut [7] to 1100 in-lb (124.3 N·m) - 1500 in-lb (169.5 N·m).

b) Apply a light coat of grease, D00633, on the fuse pin [4] outer diameter and threads.

2) Connect the bonding jumper.

3) Connect the cotter pin [8], nut [7], fuse pin [4], washer [5], and washer [6] which connect the aft end of the lower stabilizer link [3] to the attach fitting on the support beam.

a) Tighten the nut [7] to 1100 in-lb (124.3 N·m) - 1500 in-lb (169.5 N·m).

b) Apply a light coat of grease, D00633, on fuse pin [4] outer diameter and threads.

4) Connect the bonding jumper.

(c) Install the upper stabilizer link [14]:

1) Install the cotter pin [13], nut [12], bolt [15], washer [16], and washer [11] which connect the aft end of the upper stabilizer link [14] to the attach fitting on the support beam.

a) Apply a light coat of grease, D00633, on bolt [15] outer diameter and threads.

b) Tighten the nut [12] to 250 in-lb (28.2 N·m) - 350 in-lb (39.5 N·m).

2) Install the cotter pin [8], nut [7], fuse pin [4], washers [5], and washer [6] which connect the forward end of the upper stabilizer link [14] to the attach fitting on the rear spar.

a) Apply a light coat of grease, D00633, on fuse pin [4] outer diameter and threads.

b) Tighten the nut [7] to 1100 in-lb (124.3 N·m) - 1500 in-lb (169.5 N·m).

3) Connect the bonding jumper.

4) Install the four bolts [9] and four collars [10] which connect the two tray brackets to the upper stabilizer link [14].

F. Put the Airplane Back to Its Usual Condition

SUBTASK 57-15-00-010-007

(1) Install the applicable panels surrounding the main landing gear support beam:

> **CAUTION** MAKE SURE THAT THE SEALS OF PANEL 551ET AND PANEL 651ET ARE INSTALLED BELOW SPOILER NO.6 AND SPOILER NO.7. IF YOU DO NOT OBEY, DAMAGE TO THE SPOILERS CAN OCCUR.

(a) On the left wing, install these 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

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(Continued)

Number	Name/Location
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, Structural MLG Beam Access Panel
551FB	Lower Inboard Fixed Trailing Edge, Landing Gear Access Panel

1) If it is difficult to force the seal under the spoiler, remove the spoiler and reinstall it (TASK 27-62-71-000-801 and TASK 27-62-71-400-801).

a) Make sure that the seal is under the spoiler.

CAUTION MAKE SURE THAT THE SEALS OF PANEL 551ET AND PANEL 651ET ARE INSTALLED BELOW SPOILER NO.6 AND SPOILER NO.7. IF YOU DO NOT OBEY, DAMAGE TO THE SPOILERS CAN OCCUR.

(b) On the right wing, install these access panels:

Number	Name/Location
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

1) If it is difficult to force the seal under the spoiler, remove the spoiler and reinstall it (TASK 27-62-71-000-801 and TASK 27-62-71-400-801).

a) Make sure that the seal is under the spoiler.

SUBTASK 57-15-00-420-012

(2) To install the main landing gear, do this task: Main Landing Gear Installation, TASK 32-11-00-400-801.

SUBTASK 57-15-00-420-014

(3) To install the inboard ground spoiler, do this task: Inboard Ground Spoiler Installation, TASK 27-62-12-400-801.

SUBTASK 57-15-00-860-005

(4) To install the applicable inboard trailing edge flap, do this task: Inboard Trailing Edge Flap Installation, TASK 27-51-11-400-801.

SUBTASK 57-15-00-410-002

(5) To install the wing door, do this task: Main Landing Gear Wing Door Installation, TASK 32-13-21-420-801.

SUBTASK 57-15-00-410-003

(6) To install the fairings for the inboard flap track, do this task: Inboard Flap Support Aft Fairing Installation, TASK 27-51-18-400-802.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 57-15-00-640-001

(7) To lubricate the support beam, do this task: Lubricate the Support Beam Assembly of the Main Landing Gear, TASK 12-25-07-600-801.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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Main Landing Gear Support Beam Installation
Figure 401/57-15-00-990-803 (Sheet 1 of 6)

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Main Landing Gear Support Beam Installation
Figure 401/57-15-00-990-803 (Sheet 2 of 6)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Main Landing Gear Support Beam Installation
Figure 401/57-15-00-990-803 (Sheet 3 of 6)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Main Landing Gear Support Beam Installation
Figure 401/57-15-00-990-803 (Sheet 4 of 6)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Main Landing Gear Support Beam Installation
Figure 401/57-15-00-990-803 (Sheet 5 of 6)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

HANGER LINK

L

K31596 S0006581514_V4

Main Landing Gear Support Beam Installation
Figure 401/57-15-00-990-803 (Sheet 6 of 6)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

LANDING GEAR SUPPORT BEAM - INSPECTION/CHECK

1. General

A. This procedure has these tasks:

(1) Landing Gear Support Beam Inspection. 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 57-15-00-200-801

2. Landing Gear Support Beam - Inspection

(Figure 601)

A. References

Reference	Title
57-15-00-000-801	Landing Gear Support Beam Removal (P/B 401)
57-15-00-400-801	Landing Gear Support Beam Installation (P/B 401)
57-15-01-020-801	Main Landing Gear Support Beam Hanger Links Upper And Lower Pin Removal (P/B 401)
57-15-01-420-801	Main Landing Gear Support Beam Hanger Links Upper And Lower Pin 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. Hanger Link Pins and Bushings Inspection

NOTE: This is an alternate procedure for the inspection of hanger link pins and bushings, without the removal of the landing gear support beam. For the inspection of all bolts, pins and bushings which attach the support beam, refer to Inspection Procedure for Support Beam Bolts, Pins and Bushings.

SUBTASK 57-15-00-020-014

(1) To remove the lower pin from the hanger link and support beam, do this task: Main Landing Gear Support Beam Hanger Links Upper And Lower Pin Removal, TASK 57-15-01-020-801.

SUBTASK 57-15-00-210-002

(2) Look for worn areas on the lower pin and bushings of the hanger link, (Figure 601, View A-A).

(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 pins and the bushings.

(b) Compare the measured dimensions with the permitted dimensions shown in (Figure 601).

(c) Replace the parts which are out of the tolerance.

NOTE: If a part is replaced on the hanger link, replace the corresponding part to keep symmetry.

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SUBTASK 57-15-00-420-013

(3) To install the lower pin to the hanger link and support beam, do this task: Main Landing Gear Support Beam Hanger Links Upper And Lower Pin Installation, TASK 57-15-01-420-801.

E. Support Beam Bolts, Pins and Bushings Inspection

SUBTASK 57-15-00-020-001

(1) Do this task: Landing Gear Support Beam Removal, TASK 57-15-00-000-801.

SUBTASK 57-15-00-210-001

(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 measured dimensions with the permitted dimensions shown in (Figure 601).

(c) Replace the parts which are out of the tolerance.

SUBTASK 57-15-00-420-001

(3) Do this task: Landing Gear Support Beam Installation, TASK 57-15-00-400-801.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

MAIN LANDING GEAR
(LEFT SIDE IS SHOWN, RIGHT SIDE IS EQUIVALENT)

A

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Main Landing Gear Beam Inspection
Figure 601/57-15-00-990-801 (Sheet 1 of 10)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUPPORT BEAM
(MAIN GEAR REMOVED)

B

F82357 S0006581518_V2

Main Landing Gear Beam Inspection
Figure 601/57-15-00-990-801 (Sheet 2 of 10)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Main Landing Gear Beam Inspection
Figure 601/57-15-00-990-801 (Sheet 3 of 10)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Main Landing Gear Beam Inspection
Figure 601/57-15-00-990-801 (Sheet 4 of 10)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Main Landing Gear Beam Inspection
Figure 601/57-15-00-990-801 (Sheet 5 of 10)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

G-G

H-H

F82834 S0006581522_V2

Main Landing Gear Beam Inspection
Figure 601/57-15-00-990-801 (Sheet 6 of 10)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

I-I

J-J

H46213 S0006581523_V2

Main Landing Gear Beam Inspection
Figure 601/57-15-00-990-801 (Sheet 7 of 10)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

INDEX NO.	PART NAME	DIM.	DESIGN LIMITS DIAMETER MINIMUM INCHES (mm)	DESIGN LIMITS DIAMETER MAXIMUM INCHES (mm)	WEAR LIMITS PERMITTED WEAR DIMENSION INCHES (mm)	WEAR LIMITS MAXIMUM DIAMETER CLEARANCE INCHES (mm)	REPLACE WORN PART	REPAIR WORN PART	REPAIR INSTR
1	BUSHING	ID	2.1250 (53.975)	2.1262 (54.005)	2.1318 (54.148)	0.0080 (0.203)	X		1
	FUSE PIN	OD	2.1232 (53.929)	2.1238 (53.945)	2.1182 (53.802)			2	
2	BUSHING	ID	2.1250 (53.975)	2.1262 (54.005)	2.1318 (54.148)	0.0080 (0.203)	X		1
	PIN	OD	2.1232 (53.929)	2.1238 (53.945)	2.1182 (53.802)			2	
3	BUSHING	ID	0.6250 (15.875)	0.6256 (15.890)	------	0.0000	X		1
	BUSHING	OD	0.6261 (15.903)	0.6266 (15.916)	------		X		
4	BOLT	OD	0.4985 (12.662)	0.4995 (12.687)	0.4957 (12.591)	0.0050 (0.127)	X		1
	BUSHING	ID	0.5000 (12.700)	0.5007 (12.718)	0.5045 (12.814)		X		
5	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	
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)			2	
7	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	
8	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	

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Main Landing Gear Beam Inspection
Figure 601/57-15-00-990-801 (Sheet 8 of 10)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

INDEX NO.	PART NAME	DIM.	DESIGN LIMITS DIAMETER MINIMUM INCHES (mm)	DESIGN LIMITS DIAMETER MAXIMUM INCHES (mm)	WEAR LIMITS PERMITTED WEAR DIMENSION INCHES (mm)	WEAR LIMITS MAXIMUM DIAMETER CLEARANCE INCHES (mm)	REPLACE WORN PART	REPAIR WORN PART	REPAIR INSTR
9	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	
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	1.4317 (36.365)	1.4330 (36.398)	1.4376 (36.515)	0.0065 (0.165)	X		1
	FUSE PIN	OD	1.4306 (36.337)	1.4311 (36.350)	1.4265 (36.233)		X		1
11 4	BUSHING	ID	1.4817 (37.635)	1.4830 (37.668)	1.4876 (37.785)	0.0065 (0.165)	X		
	FUSE PIN	OD	1.4806 (37.607)	1.4811 (37.620)	1.4765 (37.503)			2	
11 5	BUSHING	ID	1.5817 (40.175)	1.5830 (40.208)	1.5876 (40.325)	0.0065 (0.165)	X		
	BOLT	OD	1.5806 (40.147)	1.5811 (40.160)	1.5765 (40.043)			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 Beam Inspection
Figure 601/57-15-00-990-801 (Sheet 9 of 10)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

INDEX NO.	PART NAME	DIM.	DESIGN LIMITS		WEAR LIMITS		REPLACE WORN PART	REPAIR WORN PART	REPAIR INSTR
			DIAMETER		PERMITTED WEAR DIMENSION INCHES (mm)	MAXIMUM DIAMETER CLEARANCE INCHES (mm)			
			MINIMUM INCHES (mm)	MAXIMUM INCHES (mm)					
15	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		
16	BUSHING	ID	0.3750 (9.525)	0.3756 (9.540)	0.3773 (9.583)	0.0028 (0.071)	X		1
	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		1
	BOLT	OD	0.2485 (6.312)	0.2495 (6.337)	0.2475 (6.287)		X		

1 OVERSIZED BUSHING PERMITTED. REFER TO CMM 57-15-01.
2 REFER TO CMM 57-15-01.
3 737-600 AIRPLANES
4 737-700 AIRPLANES
5 737-800 AND 737-900 AIRPLANES

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Main Landing Gear Beam Inspection
Figure 601/57-15-00-990-801 (Sheet 10 of 10)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-15-00-200-802

3. Main Landing Gear Beam Hanger Link - Free Play Check

(Figure 602)

A. References

Reference	Title
07-11-01 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)
57-15-01-020-801	Main Landing Gear Support Beam Hanger Links Upper And Lower Pin Removal (P/B 401)
57-15-01-420-801	Main Landing Gear Support Beam Hanger Links Upper And Lower Pin Installation (P/B 401)

B. Tools/Equipment

Reference	Description
STD-179	C-clamp
STD-1279	Mount - Device, Mounting, Holds the Dial Indicator
STD-11969	Dial Indicator - 0.001 inch graduations
STD-12479	Locking C-Clamp, 3.25 Inch Jaw Opening
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. Main Landing Gear Beam Hanger Link Free Play Check

SUBTASK 57-15-00-480-003

> **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) 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

SUBTASK 57-15-00-860-006

(2) Put the airplane on jacks (PAGEBLOCK 07-11-01/201).

SUBTASK 57-15-00-010-008

(3) Get access to the main landing gear support beam lower flange.

SUBTASK 57-15-00-480-001

> **WARNING** 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):

ECCN 9E991 BOEING PROPRIETARY - See title page for details

CAUTION 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 Main Landing Gear (MLG) support beam lower flange between the attach bolts.

1) Attach the aluminum plate, STD-12481, with the locking c-clamp, STD-12479, or C-clamp, STD-179.

CAUTION MAKE SURE THAT YOU USE PROTECTION ON THE SURFACE OF THE HANGAR LINK OF THE MLG SUPPORT BEAM. IF YOU DO NOT OBEY, THE MOUNT DEVICE CAN CAUSE DAMAGE TO THE SURFACE OF THE HANGAR LINK.

(c) Attach a dial indicator, STD-11969, to the hangar link at the MLG support beam attach point using the mount, STD-1279.

(d) Put the dial indicator, STD-11969, vertically with the plunger on the aluminum plate, STD-12481.

WARNING MAKE SURE THAT PERSONNEL AND EQUIPMENT ARE CLEAR OF THE MAIN LANDING GEAR. DO THIS WHEN YOU PRESSURIZE THE CENTER HYDRAULIC SYSTEM WITH THE AIRPLANE LIFTED ON THE PRIMARY JACKS. HYDRAULIC PRESSURE WILL TILT THE LANDING GEAR AND THE FAST MOVEMENT CAN CAUSE INJURY TO PERSONNEL OR 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 gear handle down position, set the dial indicator, STD-11969, to zero when the plunger touches the aluminum plate, STD-12481.

SUBTASK 57-15-00-200-004

WARNING MAKE CERTAIN LANDING GEAR DOWNLOCK PINS ARE INSTALLED TO PREVENT INADVERTENT RETRACTION OF LANDING GEAR, AND POSSIBLE INJURY TO PERSONNEL.

WARNING MAKE SURE THAT PERSONNEL AND EQUIPMENT ARE CLEAR OF THE MAIN LANDING GEAR. DO THIS WHEN YOU PRESSURIZE THE CENTER HYDRAULIC SYSTEM WITH THE AIRPLANE LIFTED ON THE PRIMARY JACKS. HYDRAULIC PRESSURE WILL TILT THE LANDING GEAR AND THE FAST MOVEMENT CAN CAUSE INJURY TO PERSONNEL OR DAMAGE TO EQUIPMENT.

(5) In the gear handle up position, read the dial indicator, STD-11969, to find the vertical movement between the hangar link and MLG support beam.

SUBTASK 57-15-00-211-001

(6) Record the free play dimension (Figure 602).

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(a) If the free play is less than 0.050 in. (1.270 mm), no more steps are necessary.

(b) For hydraulic system A, do this task: Hydraulic System A or B Power Removal, TASK 29-11-00-860-805.

NOTE: If the free play check is being performed in conjunction with MPD Item number 32-040-01 or 34-040-02, the disassembly of the Landing Gear Support Beam removal can be deferred until the Landing Gear is completely removed from the aircraft.

(c) If the free play is more than 0.05 in. (1.270 mm), do as follows:

1) Do this task: Main Landing Gear Support Beam Hanger Links Upper And Lower Pin Removal, TASK 57-15-01-020-801.

2) Measure the maximum inner diameter and minimum wall thickness of the hangar link and landing gear bushings.

3) Do a detailed visual inspection of the pin and bushings for wear (TASK 57-15-00-200-801).

NOTE: If damage other than worn bushings is found, contact BOEING for more repair instructions.

a) If it is damaged, replace the bushings.

NOTE: If a bushing is replaced on a part of the hangar link or the landing 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) Do this task: Main Landing Gear Support Beam Hanger Links Upper And Lower Pin Installation, TASK 57-15-01-420-801.

SUBTASK 57-15-00-200-005

(7) Do an inspection of the free play.

(a) Make sure that the free play is not more than 0.05 in. (1.27 mm).

SUBTASK 57-15-00-420-015

CAUTION	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.

(8) If removed, connect the support rod to the wheel well structure.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

MAIN LANDING GEAR
(LEFT SIDE IS SHOWN, RIGHT SIDE IS EQUIVALENT)

A

2016866 S0000398912_V3

Main Landing Gear Beam Hanger Link Free Play Check
Figure 602/57-15-00-990-805 (Sheet 1 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Main Landing Gear Beam Hanger Link Free Play Check
Figure 602/57-15-00-990-805 (Sheet 2 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

2977002 S0000755009_V1

Main Landing Gear Beam Hanger Link Free Play Check
Figure 602/57-15-00-990-805 (Sheet 3 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

MAIN LANDING GEAR SUPPORT BEAM HANGER LINKS UPPER AND LOWER PIN - REMOVAL/ INSTALLATION

1. General

A. There are two tasks in this procedure. There is one task for the removal and one task for the installation of the landing gear beam support hanger links upper and lower pins.

(1) 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.

TASK 57-15-01-020-801

2. Main Landing Gear Support Beam Hanger Links Upper And Lower Pin Removal

(Figure 401)

A. References

Reference	Title
07-11-01 P/B 201	JACK AIRPLANE - MAINTENANCE PRACTICES
32-00-01-480-801	Landing Gear Downlock Pins Installation (P/B 201)
57-15-00 P/B 401	MAIN LANDING GEAR SUPPORT BEAM - REMOVAL/INSTALLATION
57-15-00 P/B 601	LANDING GEAR SUPPORT BEAM - INSPECTION/CHECK

B. Location Zones

Zone	Area
734	Left Main Landing Gear
744	Right Main Landing Gear

C. Prepare for the Removal

SUBTASK 57-15-01-480-001

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) 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.

SUBTASK 57-15-01-580-001

(2) Do this task: JACK AIRPLANE - MAINTENANCE PRACTICES, PAGEBLOCK 07-11-01/201.

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 57-15-01-010-001

(3) Get access to the main landing gear support beam lower flange.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

D. Procedure

SUBTASK 57-15-01-020-001

(1) Disconnect the lower and upper pins from the support beam, do these steps:

> **WARNING** MAKE CERTAIN LANDING GEAR DOWNLOCK PINS ARE INSTALLED TO PREVENT INADVERTENT RETRACTION OF LANDING GEAR, AND POSSIBLE INJURY TO PERSONNEL.

(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.

NOTE: Make a note of the location of all the washers.

(b) Keep all of the washers.

(c) Remove the nut [20], washer [21], bolt [29], countersunk washer [28], caps [27], collars [24], bolts [22], radius fillers [23], nut [25] and upper pin [30].

(d) Do a detailed visual inspection of the bushings [14] for wear, refer to AMM TASK LANDING GEAR SUPPORT BEAM - INSPECTION/CHECK, PAGEBLOCK 57-15-00/601.

1) If necessary, remove the hanger link [26] for repair or replacement, refer to AMM TASK MAIN LANDING GEAR SUPPORT BEAM - REMOVAL/INSTALLATION, PAGEBLOCK 57-15-00/401.

2) If damaged, replace the bushings [14], refer to AMM TASK MAIN LANDING GEAR SUPPORT BEAM - REMOVAL/INSTALLATION, PAGEBLOCK 57-15-00/401.

NOTE: If a bushing is replaced on a part of the hanger link, replace all worn bushings common to that part.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

LEFT MAIN LANDING GEAR
(RIGHT MAIN LANDING GEAR IS EQUIVALENT)

A

2517931 S0000591444_V2

Main Landing Gear Support Beam Hanger Links Upper and Lower Pins Installation
Figure 401/57-15-01-990-801 (Sheet 1 of 4)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

2517934 S0000591528_V1

Main Landing Gear Support Beam Hanger Links Upper and Lower Pins Installation
Figure 401/57-15-01-990-801 (Sheet 2 of 4)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

HANGER LINK

C

2517953 S0000591529_V1

Main Landing Gear Support Beam Hanger Links Upper and Lower Pins Installation
Figure 401/57-15-01-990-801 (Sheet 3 of 4)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

HANGER LINK

D

2517960 S0000591530_V3

Main Landing Gear Support Beam Hanger Links Upper and Lower Pins Installation
Figure 401/57-15-01-990-801 (Sheet 4 of 4)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-15-01-420-801

3. Main Landing Gear Support Beam Hanger Links Upper And Lower Pin Installation

(Figure 401)

A. References

Reference	Title
07-11-01-580-816	Lower the Airplane Off the Jacks (P/B 201)

B. Tools/Equipment

Reference	Description
STD-1022	Wrench - Torque, 1000 to 2000 in-lbs (112.98 to 225.96 N·m)

C. Consumable Materials

Reference	Description	Specification
D00633	Grease - Aircraft General Purpose	BMS3-33

D. Location Zones

Zone	Area
734	Left Main Landing Gear
744	Right Main Landing Gear

E. Procedure

SUBTASK 57-15-01-420-001

(1) Install the upper pin [30] to the hanger link [26].

(a) Before you install the upper pin [30], apply a thin layer of grease, D00633 to its outer diameter and threads.

(b) Install the upper pin [30] and nut [25].

(c) Tighten the nut [25] to 1000 in-lb (113.0 N·m)-2000 in-lb (226.0 N·m) with a torque wrench, STD-1022.

(d) Install the radius fillers [23], bolts [22] and collars [24].

(e) Install the bolt [29], countersunk washer [28], caps [27], washer [21] and nut [20].

(f) Tighten the nut [20] to 1000 in-lb (113.0 N·m)-1200 in-lb (135.6 N·m) with a torque wrench, STD-1022.

SUBTASK 57-15-01-420-003

(2) To connect the lower end of the hanger link [26] to the support beam, do these steps:

(a) Apply a thin layer of grease, D00633 on the outer diameter and threads of the lower pin [4].

(b) Install the washers [5], washers [6], washers [7], lower pin [4] and nut [12] on the hanger link [26].

NOTE: Install the washers [5], washers [6], and washers [7] between the bushing 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.

(c) Tighten the nut [12] to 1000 in-lb (113.0 N·m)-2000 in-lb (226.0 N·m) with a torque wrench, STD-1022.

(d) Install the radius fillers [9], bolts [8] and collars [13].

(e) Install the bolt [1], countersunk washer [2], caps [3], washer [11] and nut [10].

(f) Tighten the nut [10] to 1000 in-lb (113.0 N·m)-1200 in-lb (135.6 N·m) with a torque wrench, STD-1022.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(g) Apply grease, D00633 through all the grease fittings on the hanger link [26] until the grease comes out.

F. Put the Airplane Back to Its Usual Condition

SUBTASK 57-15-01-580-002

(1) Do this task: Lower the Airplane Off the Jacks, TASK 07-11-01-580-816.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

MLG FORWARD TRUNNION HOUSING ASSEMBLY - REMOVAL/INSTALLATION

1. General

A. This procedure has two 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
32-11-83-000-801	Main Landing Gear Forward Trunnion Bearing Assembly 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-4360	Wrench - Trunnion Spherical Bearing, MLG Part #: C32023-12 Supplier: 81205 Opt Part #: C32023-1 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. MLG Forward Trunnion Housing Assembly Removal

SUBTASK 57-16-01-010-001

(1) Remove the housing assembly from the airplane, do this task: Main Landing Gear Forward Trunnion Bearing Assembly Removal, TASK 32-11-83-000-801.

LOM 404, 411, 416, 420, 422, 425 PRE SB 737-32-1448

SUBTASK 57-16-01-020-001

(2) Do the steps that follow to disassemble the housing assembly [5] (Figure 401):

(a) Remove the lockwire [2] from the retainer nut [1].

(b) Remove the retainer nut [1], pin assembly [4], and race assembly [3].

1) Use wrench, SPL-4360, or equivalent, to remove the retainer nut [1].

(c) Remove the retaining ring [8], support ring assembly [7], and seal [6].

LOM 402, 406, 407, 412, 415, 423, 424, 426-434, 437-447, 450-999; LOM 404, 411, 416, 420, 422, 425 POST SB 737-32-1448

SUBTASK 57-16-01-020-005

(3) Do the steps that follow to disassemble the housing assembly [5] (Figure 401):

(a) Remove the lockwire [2] from the retainer nut [1].

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(b) Remove the retainer nut [1], pin assembly [4], and race assembly [3].

1) Use wrench, SPL-4360, or equivalent, to remove the retainer nut [1].

(c) Remove the retaining ring [8] and seal [6].

LOM ALL

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Forward Trunnion Housing Assembly Installation
Figure 401/57-16-01-990-803 (Sheet 1 of 5)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Forward Trunnion Housing Assembly Installation
Figure 401/57-16-01-990-803 (Sheet 2 of 5)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Forward Trunnion Housing Assembly Installation
Figure 401/57-16-01-990-803 (Sheet 3 of 5)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

3013172 S0000786750_V1

Forward Trunnion Housing Assembly Installation
Figure 401/57-16-01-990-803 (Sheet 4 of 5)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

2554049 S0000608759_V1

Forward Trunnion Housing Assembly Installation
Figure 401/57-16-01-990-803 (Sheet 5 of 5)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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
32-11-83-400-801	Main Landing Gear Forward Trunnion Bearing Assembly 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-4360	Wrench - Trunnion Spherical Bearing, MLG Part #: C32023-12 Supplier: 81205 Opt Part #: C32023-1 Supplier: 81205

C. Consumable Materials

Reference	Description	Specification
D00633	Grease - Aircraft General Purpose	BMS3-33
G01912	Lockwire - MS20995NC32, Monel - 0.032 Inch (0.8128 mm) Diameter	NASM20995

D. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
5	Housing assembly	32-11-00-04-095	LOM ALL
8	Retaining ring	32-11-00-02-045	LOM 404, 411, 420
		32-11-00-02-048	LOM 402, 404, 406, 407, 412, 415, 416, 422-434, 437-447, 450-999

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. MLG Forward Trunnion Housing Assembly Installation

SUBTASK 57-16-01-020-002

(1) Install the pin assembly [4] and race assembly [3] into the housing assembly [5].

(a) Apply a coating of grease, D00633, to these parts before assembly.

(b) Make sure that the splines of the race assembly [3] are in full contact with the housing assembly [5] splines before you install the retainer nut [1].

SUBTASK 57-16-01-640-001

(2) Install the retainer nut [1].

(a) Apply grease, D00633, to the retainer nut threads.

(b) Tighten the retainer nut [1] to 50 ft-lb (68 N·m) - 75 ft-lb (102 N·m).

1) Use the wrench, SPL-4360, or equivalent, to tighten the retainer nut [1].

ECCN 9E991 BOEING PROPRIETARY - See title page for details

CAUTION

MAKE SURE THAT THE CLEARANCE BETWEEN THE RACE ASSEMBLY AND THE HOUSING ASSEMBLY IS LESS THAN 0.0050 INCH (0.1270 MM). IF THE CLEARANCE IS MORE THAN 0.0050 INCH (0.1270 MM) DURING THE INSTALLATION OF THE FORWARD TRUNNION BEARINGS, DAMAGE TO THE AIRPLANE CAN OCCUR.

(c) Make sure that the clearance between the aft face of the race assembly [3] and the housing assembly [5] is 0.0050 in. (0.1270 mm) or less (Figure 401 (Sheet 4)).

NOTE: It is not required to continue with the installation until a correct clearance is measured after tightening the nut retainer.

1) If a clearance greater than 0.0050 in. (0.1270 mm) is found, disassemble the retainer nut [1], pin assembly [4], and race assembly [3] to look for unwanted material between the mated parts.

SUBTASK 57-16-01-020-003

(3) Install the lockwire [2] (MS20995NC32 lockwire, G01912), at 2 locations, onto the retainer nut [1], and housing assembly [5].

(a) Install MS20995NC32 lockwire, G01912, with the double twist method.

LOM 404, 411, 416, 420, 422, 425 PRE SB 737-32-1448

SUBTASK 57-16-01-020-004

(4) Install the seal [6], support ring assembly [7], and the retaining ring [8].

NOTE: You can use the removed seal, support ring assembly, and retaining ring if in a serviceable condition.

(a) Apply a coating of grease, D00633, to these parts.

LOM 402, 406, 407, 412, 415, 423, 424, 426-434, 437-447, 450-999; LOM 404, 411, 416, 420, 422, 425 POST SB 737-32-1448

SUBTASK 57-16-01-420-001

CAUTION

DO NOT USE THE EXISTING PARTS (P/N S38624 SEAL AND P/N 161A1194-1 RETAINER) TO REPLACE THE NEW OR CHANGED PARTS (P/N 5649-0615-369 SEAL AND RETAINER P/N 161A1194-3) ON FWD MLG TRUNNION HOUSING ASSY. IF YOU DO NOT OBEY THESE INSTRUCTIONS, DAMAGE TO THE MAIN LANDING GEAR CAN OCCUR.

(5) Install the seal [6] and the retaining ring [8] (Figure 401).

NOTE: You can use the removed seal and retaining ring if in a serviceable condition.

(a) Apply a coating of grease, D00633, to these parts.

(b) Make sure that you install the seal [6] in its correct position.

LOM ALL

SUBTASK 57-16-01-410-001

(6) Put grease, D00633, into the grease fitting on the housing assembly [5] until the grease can be seen at the aft edge of the bearing race.

SUBTASK 57-16-01-410-002

(7) Do this task: Main Landing Gear Forward Trunnion Bearing Assembly Installation, TASK 32-11-83-400-801.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

MLG FORWARD TRUNNION BEARING AND SUPPORT - INSPECTION/CHECK

1. General

A. This procedure examines the bearings of the main landing gear forward trunnion. (Figure 601)

TASK 57-16-01-200-801

2. MLG Forward Trunnion Bearing Wear Limits

A. 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)

B. Location Zones

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

C. 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.

D. Procedure

SUBTASK 57-16-01-200-001

(1) Make sure that the dimensions for each part are within tolerance, (Figure 601).

E. 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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

LEFT MAIN LANDING GEAR
(RIGHT MAIN LANDING GEAR IS EQUIVALENT)

A

K37059 S0006581536_V2

Forward Trunnion Housing Assembly Inspection
Figure 601/57-16-01-990-802 (Sheet 1 of 5)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

K37870 S0006581537_V3

Forward Trunnion Housing Assembly Inspection
Figure 601/57-16-01-990-802 (Sheet 2 of 5)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

2505372 S0000589820_V1

Forward Trunnion Housing Assembly Inspection
Figure 601/57-16-01-990-802 (Sheet 3 of 5)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

FORWARD TRUNNION BEARING
SUPPORT ASSEMBLY

K52785 S0006581538_V2

Forward Trunnion Housing Assembly Inspection
Figure 601/57-16-01-990-802 (Sheet 4 of 5)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

INDEX NO.	PART NAME	DIM.	DESIGN LIMITS		WEAR LIMITS	
			DIAMETER		PERMITTED WEAR DIMENSION INCHES (mm)	MAXIMUM DIAMETER CLEARANCE INCHES (mm)
			MINIMUM INCHES (mm)	MAXIMUM INCHES (mm)		
1	HOUSING	ID	4.9990 (126.975)	5.0010 (127.025)	5.0065 (127.165)	0.0087 (0.221)
	RACE ASSY	OD	4.9968 (126.919)	4.9978 (126.944)	--	0.0087 (0.221)
2	RACE ASSY	ID	4.5020 (114.351)	4.5030 (114.376)	4.5082 (114.508)	0.0082 (0.2083)
	PIN ASSY	OD	4.4990 (114.275)	4.5000 (114.300)	4.4948 (114.168)	0.0082 (0.2083)
3	SUPPORT ASSY	ID	1.5602 (39.629)	1.5610 (39.649)	--	--
	BUSHING	OD	1.5630 (39.700)	1.5638 (39.721)	--	--
4	BUSHING	ID	1.2905 (32.779)	1.2915 (32.804)	1.2973 (32.951)	0.0088 (0.2235)
	FUSE PIN	OD	1.2880 (32.715)	1.2885 (32.728)	1.2827 (32.581)	0.0088 (0.2235)

K53993 S0006581539_V3

Forward Trunnion Housing Assembly Inspection
Figure 601/57-16-01-990-802 (Sheet 5 of 5)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

MAIN LANDING GEAR (MLG) AFT TRUNNION BEARING ASSEMBLY - REMOVAL/INSTALLATION

1. General

A. This procedure has two tasks:

(1) The first task is instructions to remove the aft trunnion bearing assembly.

(2) The second task is instructions to install the aft trunnion bearing assembly.

TASK 57-16-02-000-801

2. MLG Aft Trunnion Bearing Assembly Removal

(Figure 401)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
07-11-01-580-815	Lift the Airplane with the Jacks (P/B 201)
32-00-01-480-801	Landing Gear Downlock Pins Installation (P/B 201)
32-11-00-000-801	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-11076	Wrench Adaptor - Retaining Nut, Aft Bearing Trunion MLG Part #: C32013-15 Supplier: 81205 Opt Part #: C32013-1 Supplier: 81205

C. 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

D. Prepare for the Removal

SUBTASK 57-16-02-010-005

> **WARNING** MAKE SURE THAT THE DOWNLOCK PINS ARE INSTALLED IN ALL OF 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.

SUBTASK 57-16-02-010-002

(2) To get access to the aft trunnion bearing assembly, do these steps:

(a) Do this task: Lift the Airplane with the Jacks, TASK 07-11-01-580-815.

(b) Do this task: Main Landing Gear Removal, TASK 32-11-00-000-801.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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.

E. MLG Aft Trunnion Bearing Assembly Removal

SUBTASK 57-16-02-020-001

(1) Remove the lock tab [4] from the lock plate.

(a) Remove the screws [2], washers [3], and lockwire.

SUBTASK 57-16-02-020-002

(2) Use 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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

LEFT MAIN LANDING GEAR
(RIGHT MAIN LANDING GEAR IS EQUIVALENT)

A

K22407 S0006581544_V2

MLG Aft Trunnion Bearing Assembly Installation
Figure 401/57-16-02-990-802 (Sheet 1 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

K22428 S0006581545_V4

MLG Aft Trunnion Bearing Assembly Installation
Figure 401/57-16-02-990-802 (Sheet 2 of 3)

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A-A

C

1 THE WIDER SPLINES OF THE OUTER RACE ASSEMBLY AND THE LOCK PLATE MUST BE ALIGNED.

2557362 S0000609931_V2

MLG Aft Trunnion Bearing Assembly Installation
Figure 401/57-16-02-990-802 (Sheet 3 of 3)

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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)
32-11-00-400-801	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	Wrench Adaptor - Retaining Nut, Aft Bearing Trunion MLG Part #: C32013-15 Supplier: 81205 Opt Part #: C32013-1 Supplier: 81205

C. Consumable Materials

Reference	Description	Specification
D00013	Grease - Aircraft And Instrument Grease	MIL-PRF-23827 (NATO G-354) (Supersedes MIL-G-23827)
D00633	Grease - Aircraft General Purpose	BMS3-33

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. MLG Aft Trunnion Bearing Assembly Installation

SUBTASK 57-16-02-020-004

(1) Install the split ball assembly [7] and outer race assembly [5].

NOTE: Installation of the race assembly grease fitting should be on the upper inboard side of the trunnion pin when looking forward, approximately 2 o'clock orientation for the left hand side and 11 o'clock orientation for the right hand side.

(a) Apply a thin coat of grease, D00633, or grease, D00013, to all parts before you install them.

NOTE: grease, D00633, is the preferred grease because it offers protection against corrosion and oxidation.

(b) Make sure that the wider splines of the outer race assembly [5] and lock plate are aligned (View C, Figure 401).

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) - 15 ft-lb (20 N·m).

1) Use the wrench adaptor, SPL-11076, to tighten the retainer nut [1].

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2) After the initial torque, allow excess grease on the outer race assembly [5] and split ball assembly [7] to extrude from the bearing housing.

a) Recheck the torque to ensure it is still within the torque limits.

> **CAUTION**
> MAKE SURE THAT THE END OF THE OUTER RACE ASSEMBLY IS FLUSH WITH THE TOP OF THE RETAINER NUT WHILE YOU TIGHTEN THE RETAINER NUT. IF YOU DO NOT OBEY, DAMAGE CAN OCCUR TO THE INCORRECT POSITION OF THE GREASE FITTING TO THE LANDING GEAR.

(b) Make sure that the end of the outer race assembly [5] is flush with the top of the retainer nut [1] while you tighten the retainer nut [1] (View C, Figure 401).

SUBTASK 57-16-02-020-006

(3) Install the lock tab [4] to the lock plate.

(a) Back the retainer nut [1] off until tab can engage slot in nut.

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 screws [2], washers [3], and lockwire.

1) Tighten the screws [2] to 50 in-lb (6 N·m) - 80 in-lb (9 N·m).

2) Install the lockwire by the double-twist procedure.

SUBTASK 57-16-02-020-007

(4) Lubricate the aft trunnion bearing assembly at the lubrication fitting using grease, D00633.

(a) Move the spherical bearing until positioned as shown in View A-A, Figure 401.

NOTE: Grease shall appear at inner diameter of bearing.

SUBTASK 57-16-02-020-008

(5) Install the aft trunnion pin [6] into the aft trunnion bearing assembly.

F. Put the Airplane Back to Its Usual Condition

SUBTASK 57-16-02-010-003

(1) Do this task: Main Landing Gear Installation, TASK 32-11-00-400-801.

SUBTASK 57-16-02-010-006

> **WARNING**
> MAKE SURE THAT THE DOWNLOCK PINS ARE INSTALLED IN ALL OF THE LANDING GEAR. WITHOUT THE DOWNLOCK PINS, THE LANDING GEAR CAN RETRACT AND CAUSE INJURIES TO PERSONS AND DAMAGE TO EQUIPMENT.

(2) 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.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

MAIN LANDING GEAR REAR SPAR STABLIZER ATTACHMENT FITTING ASSEMBLY - REMOVAL/ INSTALLATION

1. General

A. This procedure has these tasks:

(1) Removal of the Main Landing Gear Rear Spar Stabilizer Attachment Fitting Assembly.

(2) Install of the Main Landing Gear Rear Spar Stabilizer Attachment Fitting Assembly.

TASK 57-16-03-000-801

2. MLG Rear Spar Stabilizer Attachment Fitting Assembly Removal

(Figure 401)

A. General

(1) This task includes these steps to remove the Stabilizer Attachment Fitting Assembly on the Rear Spar.

(a) The removal of the upper link attachment fitting assembly.

(b) The removal of the lower link attachment fitting assembly.

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)
57-15-00-000-801	Landing Gear Support Beam 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, Structural 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
651FB	Lower Inboard Fixed Trailing Edge, Landing Gear Access Panel

ECCN 9E991 BOEING PROPRIETARY - See title page for details

E. Prepare for the Removal

SUBTASK 57-16-03-020-001

(1) To remove the MLG Rear Spar Stablizer Attachment Fitting Assembly from the airplane, do this task: Landing Gear Support Beam Removal, TASK 57-15-00-000-801.

SUBTASK 57-16-03-010-001

(2) Make sure that the applicable panels surrounding the assembly have been removed.

(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
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, Structural MLG Beam Access Panel
551FB	Lower Inboard Fixed Trailing Edge, Landing Gear Access Panel

(b) On the right wing, remove these access panels:

Number	Name/Location
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. MLG Rear Spar Stablizer Attachment Fitting Assembly Removal

SUBTASK 57-16-03-040-001

(1) Make sure that the pressure from all the hydraulics has been removed (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.

(2) Disconnect the necessary hydraulic and fire extinguisher lines from the assembly (TASK 20-10-51-000-801).

(a) Make note of the locations of the lines.

(b) Install protective caps on the open hydraulic lines.

SUBTASK 57-16-03-020-003

(3) Disconnect the necessary electrical wires from the assembly.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(a) Make note of the locations of the wires.

SUBTASK 57-16-03-000-001

(4) Do the steps that follow to remove the upper link attachment fitting [1] assembly:

(a) Secure the end of the bonding jumper.

(b) Remove the four bolts [12] and four collars [4] which connect the upper link attachment fitting [1] and shim [9] to the structure.

(c) Remove the two bolts [3], two washers [10], and two nuts [11] which connect the upper link attachment fitting [1] and shim [13] to the upper part of the structure.

(d) Remove the upper link attachment fitting [1] assembly, shim [9], and shim [13] from the structure.

1) Make note of the location of the shims.

SUBTASK 57-16-03-000-002

(5) Do the steps that follow to remove the lower link attachment fitting [2] assembly:

(a) Secure the end of the bonding jumper.

(b) Remove the four bolts [16] and the four collars [24] which connect the lower link attachment fitting [2] and shim [22] to the structure.

(c) Remove the two bolts [21], two washers [15], and two nuts [14] which connect the lower link attachment fitting [2] and shim [23] to the lower part of the structure.

(d) Remove the lower link attachment fitting [2] assembly and shim from the structure.

1) Make note of the location of the shims.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

MLG Rear Spar Stablizer Attachment Fitting Assembly Installation
Figure 401/57-16-03-990-801 (Sheet 1 of 3)

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UPPER LINK ATTACHMENT FITTING ASSEMBLY

B

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MLG Rear Spar Stablizer Attachment Fitting Assembly Installation
Figure 401/57-16-03-990-801 (Sheet 2 of 3)

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LOWER LINK ATTACHMENT FITTING ASSEMBLY

C

2197926 S0000489032_V2

MLG Rear Spar Stablizer Attachment Fitting Assembly Installation
Figure 401/57-16-03-990-801 (Sheet 3 of 3)

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TASK 57-16-03-400-801

3. **MLG Rear Spar Stabilizer Attachment Fitting Assembly Installation**
(Figure 401)

A. **General**

(1) This task includes the following steps to install the Stabilizer Attachment Fitting Assembly on the Rear Spar.

(a) The installation of the upper link attachment fitting [1] assembly.

(b) The installation of the lower link attachment fitting [2] assembly.

B. **References**

Reference	Title
12-40-00-100-801	Clean (Wet Wash) the External Surfaces of the Airplane (P/B 201)
12-40-00-100-803	Clean (Waterless Wash) the External Surfaces of the Airplane (P/B 201)
20-10-51-000-802	Flareless Fittings in Pressurized, Strut, Fuel Tank, and Cargo Areas 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)
57-15-00-000-801	Landing Gear Support Beam Removal (P/B 401)
57-15-00-400-801	Landing Gear Support Beam Installation (P/B 401)

C. **Tools/Equipment**

Reference	Description
STD-12854	Torque Wrench (1500 ft-lb), 1 inch Drive

D. **Consumable Materials**

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95

E. **Expendables/Parts**

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Upper link attachment fitting	57-11-00-23-085	LOM ALL
		57-11-00-23-087	LOM ALL
2	Lower link attachment fitting	57-11-00-23-170	LOM ALL
		57-11-00-23-175	LOM 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

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(Continued)

Number	Name/Location
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, Structural 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
651FB	Lower Inboard Fixed Trailing Edge, Landing Gear Access Panel

H. Prepare for the Installation

SUBTASK 57-16-03-020-004

(1) Make sure that the MLG Support Beam has been removed.

(a) If it is necessary, do this task: Landing Gear Support Beam Removal, TASK 57-15-00-000-801.

SUBTASK 57-16-03-010-002

(2) Make sure that the applicable panels surrounding the main landing gear have been removed:

(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
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, Structural MLG Beam Access Panel
551FB	Lower Inboard Fixed Trailing Edge, Landing Gear Access Panel

(b) On the right wing, remove these access panels:

Number	Name/Location
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

I. MLG Rear Spar Stabilizer Attachment Fitting Assembly Installation

SUBTASK 57-16-03-400-001

(1) Do the steps that follow to install the upper link attachment fitting [1] assembly:

(a) Clean the surfaces of the fitting (TASK 12-40-00-100-801 or TASK 12-40-00-100-803).

1) If it is necessary, replace the parts.

(b) Apply faying surface seal with the sealant, A00247, on both sides of the shim before assembly.

(c) Install the four bolts [12] and four collars [4] which connect the upper link attachment fitting [1] and shim [9] to the structure.

(d) Install the two bolts [3], two washers [10], and two nuts [11] which connect the upper link attachment fitting [1] and shim [13] to the upper part of the structure.

1) Tighten the nuts [11] with the torque wrench, STD-12854, or equivalent, to 440 ft-lb (597 N·m) - 650 ft-lb (881 N·m).

a) Make sure that re-apply installation torque after waiting at least ten minutes before the squeeze-out life of the sealant has expired.

CAUTION

KEEP THE CLEARANCE IN THE LIMITS. IF THE CLEARANCE IS NOT IN THE LIMITS, DAMAGE TO THE AIRPLANE WILL OCCUR.

(e) Make sure that the gap between the aft face of the fitting and rear spar is not greater than 0.0050 in. (0.1270 mm) before clamp up.

1) If a gap greater than 0.0050 in. (0.1270 mm) is found, disassemble the assembly and look for unwanted material between the mated parts.

SUBTASK 57-16-03-400-002

(2) Do the steps that follow to install the lower link attachment fitting [2] assembly:

(a) Apply faying surface seal with the sealant, A00247, on both sides of the shim before assembly.

(b) Install the four bolts [16] and four collars [24] which connect the lower link attachment fitting [2] and shim [22] to the structure.

(c) Install the two bolts [21], two washers [15], and two nuts [14] which connect the lower link attachment fitting [2] and shim [23] to the lower part of the structure.

1) Tighten the nuts [14] with the torque wrench, STD-12854, or equivalent, to 260 ft-lb (353 N·m) - 425 ft-lb (576 N·m).

a) Make sure that re-apply installation torque after waiting at least ten minutes before the squeeze-out life of the sealant has expired.

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> **CAUTION** KEEP THE CLEARANCE IN THE LIMITS. IF THE CLEARANCE IS NOT IN THE LIMITS, DAMAGE TO THE AIRPLANE WILL OCCUR.

(d) Make sure that the gap between the aft face of the fitting and the rear spar is not greater than 0.0050 in. (0.1270 mm) before clamp up.

1) If a gap greater than 0.0050 in. (0.1270 mm) is found, disassemble the assembly and look for unwanted material between the mated parts.

SUBTASK 57-16-03-420-001

(3) Attach all of the electrical wires to the assembly

SUBTASK 57-16-03-420-002

(4) Attach all hydraulic and fire extinguisher lines to the assembly.

(a) Remove the protective caps from the ends of the hydraulic tubes.

(b) Connect the hydraulic and fire extinguisher lines to the assembly (TASK 20-10-51-000-802).

J. Put the Airplane Back to Its Usual Condition

SUBTASK 57-16-03-420-003

(1) To install the main landing gear support beam, do this task:

(a) Landing Gear Support Beam Installation, TASK 57-15-00-400-801

SUBTASK 57-16-03-440-001

(2) Restore the pressure to the hydraulics systems (TASK 29-09-00-860-801).

SUBTASK 57-16-03-410-001

(3) Make sure that the applicable panels surrounding the main landing gear support beam are installed:

> **CAUTION** MAKE SURE THAT THE SEALS OF PANEL 551ET AND PANEL 651ET ARE INSTALLED BELOW SPOILER NO.6 AND SPOILER NO.7. IF YOU DO NOT OBEY, DAMAGE TO THE SPOILERS CAN OCCUR.

(a) On the left wing, install these 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, Structural MLG Beam Access Panel
551FB	Lower Inboard Fixed Trailing Edge, Landing Gear Access Panel

1) If it is difficult to force the seal under the spoiler, remove the spoiler and reinstall it (TASK 27-62-71-000-801 and TASK 27-62-71-400-801).

a) Make sure that the seal is under the spoiler.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

CAUTION MAKE SURE THAT THE SEALS OF PANEL 551ET AND PANEL 651ET ARE INSTALLED BELOW SPOILER NO.6 AND SPOILER NO.7. IF YOU DO NOT OBEY, DAMAGE TO THE SPOILERS CAN OCCUR.

(b) On the right wing, install these access panels:

Number	Name/Location
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

1) If it is difficult to force the seal under the spoiler, remove the spoiler and reinstall it (TASK 27-62-71-000-801 and TASK 27-62-71-400-801).

a) Make sure that the seal is under the spoiler.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

MAIN LANDING GEAR SUPPORT BEAM OUTBOARD FITTING ASSEMBLY - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

(1) Removal of the MLG Support Beam Outboard Fitting Assembly.

(2) Installation of the MLG Support Beam Outboard Fitting Assembly.

TASK 57-16-04-000-801

2. MLG Support Beam Outboard Fitting Assembly Removal

(Figure 401)

A. General

(1) This task includes the steps to remove the 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)
12-40-00-100-803	Clean (Waterless Wash) the External Surfaces of the Airplane (P/B 201)
20-10-51-000-801	Flareless Tubing Assembly Removal (P/B 401)
27-62-12-000-801	Inboard Ground Spoiler Removal (P/B 401)
29-09-00-860-802	Hydraulic Reservoirs Depressurization (P/B 201)
32-32-93-000-801	Main Gear Beam Hanger Pin Removal (P/B 401)
57-15-00-000-801	Landing Gear Support Beam Removal (P/B 401)
57-71-01-000-801	Spoiler Support Fitting Repair (P/B 801)

C. Tools/Equipment

Reference	Description
STD-1098	Hoist - 500 Lb Capacity

D. Location Zones

Zone	Area
730	Subzone - Left Main Landing Gear and Landing Gear Doors
740	Subzone - Right Main Landing Gear and Landing Gear Doors

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, Structural 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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(Continued)

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

F. Prepare for the Removal

SUBTASK 57-16-04-020-003

(1) To remove the MLG Support Beam, do this task: Landing Gear Support Beam Removal, TASK 57-15-00-000-801.

SUBTASK 57-16-04-020-004

(2) To remove the MLG Hanger Link Pin, do this task: Main Gear Beam Hanger Pin Removal, TASK 32-32-93-000-801.

SUBTASK 57-16-04-020-005

(3) Remove the applicable Spoiler Support Fitting, do these tasks:

(a) Remove the applicable inboard ground spoiler (TASK 27-62-12-000-801).

(b) Remove the pressure from all hydraulic systems (TASK 29-09-00-860-802).

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.

(c) Disconnect the applicable hydraulic tubes as necessary (TASK 20-10-51-000-801).

1) Install protective caps on the ends of the hydraulic tubes.

2) Make note of the locations of the tubes.

3) If it is necessary, clean up the hydraulic fluid (TASK 12-40-00-100-801 or TASK 12-40-00-100-803).

(d) Remove the applicable Spoiler Support Fitting (TASK 57-71-01-000-801).

1) Remove the four bolts and the four collars of the support fitting.

2) If it is necessary, repair the Spoiler Support Fitting.

SUBTASK 57-16-04-010-002

(4) Make sure that the applicable panels surrounding the assembly have been removed.

(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
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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
551ET	Upper Inboard Fixed Trailing Edge, Structural MLG Beam Access Panel
551FB	Lower Inboard Fixed Trailing Edge, Landing Gear Access Panel

(b) On the right wing, remove these access panels:

Number	Name/Location
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 57-16-04-480-001

WARNING GET SUFFICIENT AID FROM PERSONS AND EQUIPMENT TO HOLD THE COMPONENT DURING REMOVAL AND INSTALLATION. THIS COMPONENT WEIGHS APPROXIMATELY 250 LBS (113.5 KG). THIS WILL PREVENT INJURY TO PERSONS AND DAMAGE TO EQUIPMENT.

(5) If it is necessary, install the 500 lb capacity hoist, STD-1098, to support the fitting assembly during removal.

G. MLG Support Beam Outboard Fitting Assembly Removal

SUBTASK 57-16-04-040-001

(1) Make sure that the pressure from the hydraulic systems have been removed (TASK 29-09-00-860-802).

SUBTASK 57-16-04-020-006

(2) Disconnect the necessary hydraulic tubes and fire extinguisher lines around the fitting assembly (TASK 20-10-51-000-801).

(a) Install protective caps on the ends of the hydraulic tubes.

(b) Make a note of the location of the lines.

(c) If it is necessary, clean up the hydraulic fluid (TASK 12-40-00-100-801 or TASK 12-40-00-100-803).

SUBTASK 57-16-04-020-007

(3) Disconnect the necessary electrical wires around the assembly.

(a) Make note of the location of the wires.

SUBTASK 57-16-04-000-002

(4) Remove the MLG Support Beam Outboard Fitting Assembly.

(a) On the outboard side of the MLG Support Beam Outboard Fitting Assembly, remove the following:

1) Remove the six bolts [5], six washers [8], and six nuts [9] which connect the upper part of the support fitting [1] assembly to the upper part of the rear spar.

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2) Remove the six bolts [7], six washers [11], and six nuts [10] which connect the lower part of the support fitting [1] assembly to the lower part of the rear spar.

3) Remove the four bolts [13] and four nuts [6] which connect the aft of the support fitting [1] assembly to the rear spar.

4) Remove the 10 bolts [14] and 10 collars [4] which connect the aft of the support fitting [1] assembly to the rear spar.

(b) On the inboard side of the MLG Support Beam Outboard Fitting Assembly, remove the following:

1) Remove the six bolts [17], six washers [27], and six nuts [26] which connect the upper part of the support fitting [1] assembly the upper part of the rear spar.

2) Remove the six bolts [20], six washers [24], and six nuts [25] which connect the lower part of the support fitting [1] assembly to the lower part of the rear spar.

3) Remove the four bolts [22] and four nuts [19] which connect the aft of the support fitting [1] assembly to the rear spar.

4) Remove the remaining bolts [23] and collars [18] which connect the aft of the support fitting [1] assembly to the rear spar.

NOTE: For the left wing fitting assembly, there are ten locations. For the right wing fitting assembly, there are twelve locations.

(c) Remove the support fitting [1] assembly and the shims from the rear spar.

1) Remove the shims from the support fitting assembly.

a) Make note of the location of the shims.

2) Carefully remove the fitting assembly from airplane.

SUBTASK 57-16-04-800-001

(5) For more information on the support fitting assembly refer to:

(a) CMM 57–15–01: Main Landing Gear Beam Installation Components.

——— END OF TASK ———

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LEFT WING
(RIGHT WING IS EQUIVALENT)

2198034 S0000485831_V2

MLG Support Beam Outboard Fitting Assembly Installation
Figure 401/57-16-04-990-802 (Sheet 1 of 3)

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SUPPORT FITTING ASSEMBLY

B

2198299 S0000485832_V2

MLG Support Beam Outboard Fitting Assembly Installation
Figure 401/57-16-04-990-802 (Sheet 2 of 3)

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SUPPORT FITTING ASSEMBLY

C

1 ON THE RIGHT SIDE WING ASSEMBLY THERE ARE 12 LOCATIONS.

2198479 S0000485833_V2

MLG Support Beam Outboard Fitting Assembly Installation
Figure 401/57-16-04-990-802 (Sheet 3 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-16-04-400-801

3. MLG Support Beam Outboard Fitting Assembly Installation

(Figure 401)

A. General

(1) This task includes the steps to install the 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)
12-40-00-100-803	Clean (Waterless Wash) the External Surfaces of the Airplane (P/B 201)
20-10-51-000-802	Flareless Fittings in Pressurized, Strut, Fuel Tank, and Cargo Areas Installation (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)
32-32-93-400-801	Main Gear Beam Hanger Pin Installation (P/B 401)
57-15-00-400-801	Landing Gear Support Beam Installation (P/B 401)

C. Tools/Equipment

Reference	Description
STD-1098	Hoist - 500 Lb Capacity

D. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95

E. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Support fitting	57-15-00-10-362	LOM 402, 404, 406
		57-15-00-10-364	LOM 402, 404, 406
		57-15-00-10-370	LOM 402, 404, 406
		57-15-00-10-375	LOM 402, 404, 406
		57-15-00-10A-430	LOM 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-999
		57-15-00-10A-435	LOM 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-999
		57-15-00-10A-450	LOM 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-999
		57-15-00-10A-455	LOM 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-999

ECCN 9E991 BOEING PROPRIETARY - See title page for details

F. Location Zones

Zone	Area
730	Subzone - Left Main Landing Gear and Landing Gear Doors
740	Subzone - Right Main Landing Gear and Landing Gear Doors

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, Structural 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
651FB	Lower Inboard Fixed Trailing Edge, Landing Gear Access Panel

H. Prepare for the Installation

SUBTASK 57-16-04-010-003

(1) Make sure that the applicable panels surrounding the assembly have been removed.

(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
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, Structural MLG Beam Access Panel
551FB	Lower Inboard Fixed Trailing Edge, Landing Gear Access Panel

(b) On the right wing, remove these access panels:

Number	Name/Location
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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
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 57-16-04-480-002

> **WARNING** GET SUFFICIENT AID FROM PERSONS AND EQUIPMENT TO HOLD THE COMPONENT DURING REMOVAL AND INSTALLATION. THIS COMPONENT WEIGHS APPROXIMATELY 250 LBS (113.5 KG). THIS WILL PREVENT INJURY TO PERSONS AND DAMAGE TO EQUIPMENT.

(2) Install the 500 lb capacity hoist, STD-1098, to support the fitting assembly during installation.

I. MLG Support Beam Outboard Fitting Assembly Installation

SUBTASK 57-16-04-400-002

(1) Install the MLG Support Beam Outboard Fitting Assembly.

(a) Clean the surfaces of the fitting assembly, shims, and rear spar (TASK 12-40-00-100-801 or TASK 12-40-00-100-803).

1) If it is necessary, replace the parts.

(b) Apply a faying surface seal with the sealant, A00247, on both sides of the shims.

(c) Install the support fitting [1] assembly and shim [2], shim [3], shim [12], shim [15], shim [16], shim [21] onto the rear spar.

(d) On the outboard side of the fitting assembly, install the following:

1) Install the six bolts [5], six washers [8], and six nuts [9] which connect the upper part of the support fitting [1] assembly the upper part of the rear spar.

2) Install the six bolts [7], six washers [11], and six nuts [10] which connect the lower part of the support fitting [1] assembly to the lower part of the rear spar.

3) Install the four bolts [13] and four nuts [6] which connect the aft of the support fitting [1] assembly to the rear spar.

4) Install the 10 bolts [14] and 10 collars [4] which connect the aft of the support fitting [1] assembly the rear spar.

(e) On the inboard side of the fitting assembly, install the following:

1) Install the six bolts [17], six washers [27], and six nuts [26] which connect the upper part of the support fitting [1] assembly the upper part of the rear spar.

2) Install the six bolts [20], six washers [24], and six nuts [25] which connect the lower part of the support fitting [1] assembly the lower part of the rear spar.

3) Install the four bolts [22] and four nuts [19] which connect the aft of the support fitting [1] assembly to the rear spar.

4) Install the remaining bolts [23] and collars [18] which connect the aft of the fitting assembly to the rear spar.

NOTE: For the left wing fitting assembly, there are ten locations. For the right wing fitting assembly, there are twelve locations.

SUBTASK 57-16-04-420-002

(2) Connect the necessary electrical wires around the support fitting assembly.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 57-16-04-420-003

(3) Attach all hydraulic and fire extinguisher lines around the fitting assembly.

(a) Remove the protective caps from the ends of the tubes.

(b) Connect the hydraulic tubes and fire extinguisher lines to the fitting assembly (TASK 20-10-51-000-802).

J. Put the Airplane Back to Its Usual Condition

SUBTASK 57-16-04-420-004

(1) To install the applicable spoiler support fitting, do these tasks:

(a) Connect the necessary applicable hydraulic tubes (TASK 20-10-51-000-802).

1) Remove the protective caps from the ends of the hydraulic tubes.

(b) Install the applicable inboard ground spoiler (TASK 27-62-12-400-801).

(c) Install the applicable spoiler support fitting.

1) Install the four bolts and four collars of the support fitting.

SUBTASK 57-16-04-420-005

(2) To install the MLG Hanger Link Pin, do this task: Main Gear Beam Hanger Pin Installation, TASK 32-32-93-400-801.

SUBTASK 57-16-04-420-006

(3) To install the MLG Support Beam, do this task: Landing Gear Support Beam Installation, TASK 57-15-00-400-801.

SUBTASK 57-16-04-440-001

(4) Restore pressure to the hydraulic systems, do this task: Hydraulic Reservoirs Pressurization, TASK 29-09-00-860-801.

SUBTASK 57-16-04-080-001

(5) Remove the 500 lb capacity hoist, STD-1098, from the airplane.

SUBTASK 57-16-04-410-003

CAUTION MAKE SURE THAT THE SEALS OF PANEL 551ET AND PANEL 651ET ARE INSTALLED BELOW SPOILER NO.6 AND SPOILER NO.7. IF YOU DO NOT OBEY, DAMAGE TO THE SPOILERS CAN OCCUR.

(6) Close the applicable 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, Structural 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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

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

(a) If it is difficult to force the seal under the spoiler, remove the spoiler and reinstall it (TASK 27-62-71-000-801 and TASK 27-62-71-400-801).

1) Make sure that the seal is under the spoiler.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

MAIN LANDING GEAR IDLER LINK SUPPORT FITTING ASSEMBLY - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

(1) Removal of the Idler Link Support Fitting Assembly.

(2) Installation of the Idler Link Support Fitting Assembly.

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) To remove the MLG Hanger Link Pin, do this task:

(a) Main Gear Beam Hanger Pin Removal, TASK 32-32-93-000-801

SUBTASK 57-16-05-040-001

(2) To remove the power from the hydraulic systems, do this task:

(a) Hydraulic System A or B Power Removal, 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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
651DB	Lower Inboard Fixed Trailing Edge, Lube Actuator & MLG Beam Outboard Attach Pin Access Panel

F. Idler Link Support Fitting Assembly Removal

SUBTASK 57-16-05-000-001

(1) Remove the Idler Link Support Fitting [1] from the assembly

(a) Remove the four Nuts [10], four Washers [9], four Bushings [8], four Bushings [5], four Washers [7], and four Bolts [6] which connect the Idler Link Support Fitting [1] assembly to the MLG support beam outboard fitting assembly.

(b) Remove the Idler Link Support Fitting [1] and the Shims [2] from the MLG support beam outboard fitting assembly.

1) Make note of the location of the shims.

(c) Remove the two Bushings [3] and the two Bushings [4] from the Idler Link Support Fitting [1].

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

LEFT WING
(RIGHT WING IS OPPOSITE)

2197288 S0000485858_V2

Idler Link Support Fitting Assembly Installation
Figure 401/57-16-05-990-801 (Sheet 1 of 2)

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IDLER LINK SUPPORT FITTING ASSEMBLY

B

2197313 S0000485859_V2

Idler Link Support Fitting Assembly Installation
Figure 401/57-16-05-990-801 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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.

B. References

Reference	Title
12-40-00-100-801	Clean (Wet Wash) the External Surfaces of the Airplane (P/B 201)
12-40-00-100-803	Clean (Waterless Wash) the External Surfaces of the Airplane (P/B 201)
29-11-00-860-801	Hydraulic System A or B Pressurization (P/B 201)
32-32-93-400-801	Main Gear Beam Hanger Pin Installation (P/B 401)

C. Tools/Equipment

Reference	Description
STD-12854	Torque Wrench (1500 ft-lb), 1 inch Drive

D. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95

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 (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 12-40-00-100-803).

(a) If necessary, replace the parts.

H. Idler Link Support Fitting Assembly Installation

SUBTASK 57-16-05-400-001

(1) Install the Idler Link Support Fitting

(a) Apply faying surface seal on both sides of the shim with sealant, A00247.

(b) Install the Idler Link Support Fitting [1] and the Shims [2].

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(c) Apply sealant, A00247 to Bushings [5] and Bushings [8] before installation.

(d) Install the four Bolts [6], four Washers [7], four Bushings [5], four Bushings [8], four Washers [9], and the four Nuts [10] which connect the Idler Link Support Fitting [1] assembly to the MLG support beam outboard fitting assembly.

1) Tighten the Nuts [10] with the torque wrench, STD-12854, or equivalent, to 75 ft-lb (102 N·m) to 130 ft-lb (176 N·m).

NOTE: Complete the reapplication of the torque within the squeeze out life of the sealant.

(e) Install the two Bushings [3] and the two Bushings [4] on to the Idler Link Support Fitting [1].

1) Apply sealant, A00247 to Bushings [3] and Bushings [4] before installation.

I. Put the Airplane Back to Its Usual Condition

SUBTASK 57-16-05-420-001

(1) Do these tasks:

(a) Install the MLG Hanger Link Pin (Main Gear Beam Hanger Pin Installation, TASK 32-32-93-400-801).

(b) Restore pressurization to the hydraulic system (Hydraulic System A or B Pressurization, TASK 29-11-00-860-801).

SUBTASK 57-16-05-410-001

(2) Close 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

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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 spare.

(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 have been found on the front and rear spar upper chords.

(4) Stress corrosion cracks have been found on the Krueger flap actuator support fittings mounted on the front spars.

(5) Stress corrosion cracks have been found in the right outboard trailing edge midflap at WBL 399.85. The cracks were in the flap rear spar and were 1.15 and 3.38 inches long, with the shorter crack through the two flap track attach holes

(6) Stress corrosion cracks have been found in the aft lug of the engine mount outboard support bracket which attaches to the wing front spar. Corrosion was also found between the bushing and the lug bore.

(7) Exfoliation corrosion has been found 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 has been reported between RSS 250 and 499 upper rear spar chords.

(9) Corrosion has been found around fastener heads in the front and rear spar cavities on airplanes operating in warm moist climatic conditions. Affected fasteners were located in the upper and lower spar chords and the fasteners were made of aluminum.

(10) Stress corrosion cracks have been found 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 were located 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 occurs on the wing lower skin faying surface adjacent to the access door clamp ring. Cracks can originate 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 deposits are signs of corrosion. Initiate the corrosion prevention practices to decrease the occurrence of corrosion.

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(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
12-20-00-640-801	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 first opportunity consistent with scheduled maintenance activity, 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 12-20-00-640-801.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(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 12-20-00-640-801.

(c) Regrease all grease fittings in treatment area, General Instructions for Lubrication, TASK 12-20-00-640-801.

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 details on removing corrosion if extensive corrosion exists on the wing inspar skin.

(5) Restore integral fuel tank finish.

SUBTASK 57-20-00-910-003

(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 - 0.015 inches 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.

1) Do not mix the two types of anti-corrosion compounds, Cor-Ban 27L Compound, G50237 and Aeroshell 14 helicopter grease, D50050. When applying 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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

J21464 S0000167743_V2

Outer Wing Front and Rear Spars - Corrosion Prevention
Figure 201/57-20-00-990-801 (Sheet 1 of 6)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

FRONT SPAR

C

J21473 S0000167744_V3

Outer Wing Front and Rear Spars - Corrosion Prevention
Figure 201/57-20-00-990-801 (Sheet 2 of 6)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

J21605 S0000167745_V2

Outer Wing Front and Rear Spars - Corrosion Prevention
Figure 201/57-20-00-990-801 (Sheet 3 of 6)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

AFT FLAP TRACK BACKUP FITTING
(VIEW IN THE INBOARD DIRECTION)

E

J21705 S0000167746_V2

Outer Wing Front and Rear Spars - Corrosion Prevention
Figure 201/57-20-00-990-801 (Sheet 4 of 6)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

J21797 S0000167748_V2

Outer Wing Front and Rear Spars - Corrosion Prevention
Figure 201/57-20-00-990-801 (Sheet 5 of 6)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

LEFT WING
(RIGHT WING IS OPPOSITE)

(TYPICAL CORROSION DAMAGE AREA)

B-B

J21836 S0000167749_V2

Outer Wing Front and Rear Spars - Corrosion Prevention
Figure 201/57-20-00-990-801 (Sheet 6 of 6)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

J22025 S0000167753_V2

Outer Wing Internal Structure - Corrosion Prevention
Figure 202/57-20-00-990-802 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

S-5 FITTING

B

S-7, S-10 FITTINGS

C

J22056 S0000167754_V2

Outer Wing Internal Structure - Corrosion Prevention
Figure 202/57-20-00-990-802 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

J21953 S0000167755_V2

Fuel Tank and Boost Pump Access Cutouts - Corrosion Prevention
Figure 203/57-20-00-990-803

ECCN 9E991 BOEING PROPRIETARY - See title page for details

WINGLET - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

(1) A removal of the winglet

(2) An installation of the winglet

(3) A removal of the blended winglet tip fairing

(4) An installation of the blended winglet tip fairing

(5) A removal of the winglet bulb seal

(6) An installation of the winglet bulb seal.

B. To remove and install the winglet, a second person is needed.

TASK 57-21-21-000-801

2. Winglet Removal

(Figure 401 or Figure 402)

A. General

LOM 461-463

(1) Regulatory requirements refer to the Supplemental Type Certificate (STC) ST00830SE.

NOTE: Supplemental Type Certificate (STC) ST00830SE changes some wing structures for retrofit installation of the Aviation Partners Boeing (APB) Blended Winglets.

LOM ALL

(2) This task gives the procedure to remove the winglet 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	Position Lights - Disconnect the Electrical Connector (P/B 201)
33-44-13-020-801	Anti-Collision Lights - Disconnect the Electrical Connector (P/B 201)
57-21-23-000-801	Dry Bay Access Doors 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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(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
SPL-2044	Sling - Winglet Part #: C57002-70 Supplier: 81205 Part #: HSE 737-0010-7 Supplier: 3F4Z0 Opt Part #: C57002-15 Supplier: 81205 Opt Part #: HSE 737-0010-1 Supplier: 3F4Z0
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
A50001	compound - corrosion inhibiting - ZC-027L	ZC-027L
G50237	Compound - Corrosion Inhibiting, Non-drying - Cor-Ban 27L	BMS3-38

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
534BB	Dry Bay Tank Access Door - Left Wing Station 748
634BB	Dry Bay Tank Access Door - Right Wing Station 748

G. Prepare for Removal

SUBTASK 57-21-21-860-010

(1) Open these circuit breakers and install safety tags:

CAPT Electrical System Panel, P18-3

Row	Col	Number	Name
A	12	C00113	EXTERIOR LIGHTING POSITION RIGHT
A	13	C00114	EXTERIOR LIGHTING POSITION LEFT
B	13	C00115	EXT LIGHTING ANTI COLLISION WHITE

SUBTASK 57-21-21-860-004

(2) Make sure that the airplane is correctly grounded to an approved and identified ground.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(a) Do this task: Static Grounding, TASK 20-40-11-910-801.

SUBTASK 57-21-21-040-003

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

SUBTASK 57-21-21-040-004

(4) Do this task: Leading Edge Flaps and Slats Deactivation, TASK 27-81-00-040-801.

SUBTASK 57-21-21-490-005

(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 57-21-21-490-006

(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 137 lb (62 kg).

SUBTASK 57-21-21-490-007

(7) Prepare a location to store the winglet after the winglet is removed from the airplane.

NOTE: You can use a wood pallet covered with carpet or a layer of sandbags as a temporary storage location.

SUBTASK 57-21-21-860-005

(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 57-21-21-010-002

(9) Remove the dry bay access door under the wing, adjacent to the outboard rib 27.

(a) Open these 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

(b) Do this task: Dry Bay Access Doors Removal, TASK 57-21-23-000-801.

LOM 461-463

H. Removal

SUBTASK 57-21-21-020-017

(1) Install the sling, SPL-2044, on the winglet [10] (Figure 402).

NOTE: The sling equipment has three attachment fittings, six screws and washers, a sling strap assembly, and a load cell, STD-12395.

(a) Remove the 6 bolts from the winglet [10] where the attachment fittings for the sling, SPL-2044, will be attached to the winglet [10].

1) Store the bolts in a bag for the installation procedure.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

LOM 461-463 (Continued)

(b) Install 6 bolts and washers to attach the 3 attachment fittings to the winglet [10].

1) Tighten the bolts to 50 in-lb (6 N·m) to 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.

(c) Attach the sling strap assembly to the three fittings with the short strap attached to the upper, outboard fitting of the winglet [10].

SUBTASK 57-21-21-420-014

(2) Attach the sling, SPL-2044, to the overhead crane (Figure 402).

NOTE: The winglet weighs approximately 137 lbs.

SUBTASK 57-21-21-800-001

WARNING	MAKE SURE THAT THE FORCE WITHOUT THE TOOL WEIGHT IS NO MORE THAN THE SPECIFIED FORCE. A FORCE THAT IS MORE THAN THE SPECIFIED FORCE CAN CAUSE INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT.

(3) Use the load cell, STD-12395, to make sure that the force used when lifting the winglet is not more than 150 lb (68 kg).

NOTE: The value for the weight of the winglet is 140 lb (64 kg).

SUBTASK 57-21-21-500-003

(4) Operate the overhead crane to lift the sling equipment until the 3 lines equally support the winglet [10].

(a) Balance the overhead crane tension, so you can loosen the bolts that hold the winglet [10] to the wing, without damage to the bolt threads or to the winglet [10].

SUBTASK 57-21-21-490-008

(5) Use an explosion proof flashlight, STD-1081, when you look inside the dry bay tank.

SUBTASK 57-21-21-020-018

(6) Remove the 10 bolts [4] and 10 washers [6] from the center of the wing (Figure 402).

(a) Store the bolts and washers in a separate bag for the installation procedure; label the bag as the diameters and lengths are different for each attachment location.

SUBTASK 57-21-21-020-019

(7) Remove the remaining four bolts [1] and four washers [5], two bolts [2] and two washers [5], and two bolts [3] and two washers [5].

(a) Refer to the table: Table 401.

(b) Remove the two bolts [2] and two washers [5].

(c) Store the each set of bolts and washers in a separate bag for the installation procedure; label the bag as the diameters and lengths are different for each attachment location.

SUBTASK 57-21-21-010-003

(8) Carefully move the winglet 2.0 in. (5.1 cm) to 3 in. (8 cm) outboard from the wing.

SUBTASK 57-21-21-000-002

(9) Disconnect the anti-collision and position light connectors from the winglet [10] electrical receptacles [18] (View A-A, Figure 402):

ECCN 9E991 BOEING PROPRIETARY - See title page for details

LOM 461-463 (Continued)

(a) Do the task: Anti-Collision Lights - Disconnect the Electrical Connector, TASK 33-44-13-020-801.

(b) Do the task: Position Lights - Disconnect the Electrical Connector, TASK 33-43-10-020-801.

SUBTASK 57-21-21-020-020

(10) Disconnect the forward grounding strap [12] and aft grounding strap [11] (Figure 402).

(a) You must control movement of the sling and the winglet as you remove the attachment fasteners for the grounding straps.

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 for the grounding straps.

(b) Do not pull the winglet away from the wing, the forward and aft grounding straps are attached between the winglet and the wing outboard rib.

(c) Remove the washer [8] and nut [9] on the wing outboard rib.

(d) Disconnect the lug for the grounding strap from the electrical stud on the wing rib.

(e) Store the washer and nut in a bag for the installation procedure.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

LOM 461-463 (Continued)

Table 401/57-21-21-993-808 Winglet Attachment Bolt Removal

ITEM	BOLT	REMOVAL ORDER	LOCATION
[4]	BACB30US7K12 0.4375 inch (11.1125 mm) dia.	S --- J	Middle Upper and Lower
[3]	BACB30US8K18 0.5000 inch (12.7000 mm) dia.	H	Lower Aft (Front)
[1]	BACB30US8K26 0.5000 inch (12.7000 mm) dia.	G	Upper Forward (Back)
[3]	BACB30US8K18 0.5000 inch (12.7000 mm) dia.	F	Upper Aft (Front)
[1]	BACB30US8K26 0.5000 inch (12.7000 mm) dia.	E	Lower Forward (Front)
[2]	BACB30US8K18 0.5000 inch (12.7000 mm) dia.	D	Upper Aft (Back)
[1]	BACB30US8K26 0.5000 inch (12.7000 mm) dia.	C	Lower Forward (Back)
[2]	BACB30US8K18 0.5000 inch (12.7000 mm) dia.	B	Lower Aft (Back)
[1]	BACB30US8K26 0.5000 inch (12.7000 mm) dia.	A	Upper Forward (Front)

SUBTASK 57-21-21-100-002

(11) Remove the excess corrosion inhibitiing compound - ZC-027L, A50001, or Cor-Ban 27L Compound, G50237, with a hard resin phenolic scraper, STD-1064.

SUBTASK 57-21-21-900-002

(12) Use the overhead crane and the sling, SPL-2044, to move the winglet to a storage location.

LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-460, 464-999

I. Removal

SUBTASK 57-21-21-020-003

(1) Install the sling, SPL-2044, on the winglet [10] (Figure 401).

NOTE: The sling equipment has three attachment fittings, six screws and washers, a sling strap assembly, a load cell, STD-12395.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(a) Remove the 6 bolts from the winglet [10] where the attachment fittings for the sling, SPL-2044, will be attached to the winglet [10].

1) Store the bolts in a bag for the installation procedure.

(b) Install 6 bolts and washers to attach the 3 attachment fittings to the winglet [10].

1) Tighten the bolts to 50 in-lb (6 N·m) to 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.

(c) Attach the sling strap assembly to the three fittings with the short strap attached to the upper, outboard fitting of the winglet [10].

SUBTASK 57-21-21-420-002

(2) Attach the sling, SPL-2044, to the overhead crane (Figure 401).

NOTE: The winglet weighs approximately 137 lb (62 kg).

SUBTASK 57-21-21-800-003

WARNING MAKE SURE THAT THE FORCE WITHOUT THE TOOL WEIGHT IS NO MORE THAN THE SPECIFIED FORCE. A FORCE THAT IS MORE THAN THE SPECIFIED FORCE CAN CAUSE INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT.

(3) Use the load cell, STD-12395, to make sure that the force used when lifting the winglet [10] is not more than 150 lb (68 kg).

NOTE: The value for the weight of the winglet is 140 lb (64 kg).

SUBTASK 57-21-21-500-001

(4) Operate the overhead crane to lift the sling equipment until the 3 lines equally support the winglet [10].

(a) Balance the overhead crane tension, so you can loosen the bolts that hold the winglet [10] to the wing, without damage to the bolt threads or to the winglet [10].

SUBTASK 57-21-21-490-004

(5) Use an explosion proof flashlight, STD-1081, when you look inside the dry bay tank.

SUBTASK 57-21-21-020-004

(6) Remove the 10 bolts [4] and 10 washers [6] from the center of the wing (Figure 401).

(a) Store the bolts and washers in a separate bag for the installation procedure; label the bag as the diameters and lengths are different for each attachment location.

SUBTASK 57-21-21-020-014

(7) Remove the remaining four bolts [1] and four washers [5], two bolts [2] and two washers [5], and two bolts [3] and two washers [5].

(a) Refer to the table: Table 402.

(b) Remove the radius filler [7] when you remove the two bolts [2] and two washers [5].

(c) Store the each set of bolts and washers in a separate bag for the installation procedure; label the bag as the diameters and lengths are different for each attachment location.

SUBTASK 57-21-21-000-001

(8) Disconnect the anti-collision and position light connectors from the winglet [10] electrical receptacles [18] (View A-A, Figure 401):

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(a) Do this task: Anti-Collision Lights - Disconnect the Electrical Connector, TASK 33-44-13-020-801.

(b) Do this task: Position Lights - Disconnect the Electrical Connector, TASK 33-43-10-020-801.

SUBTASK 57-21-21-020-005

(9) Disconnect the forward grounding strap [12] and aft grounding strap [11] (Figure 401).

(a) You must control movement of the sling and the winglet as you remove the attachment fasteners for the grounding straps.

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 for the grounding straps.

(b) Do not pull the winglet [10] away from the wing, the forward and aft grounding straps are attached between the winglet and the wing outboard rib.

(c) Remove the washer [8] and nut [9] from the outboard rib of the wing.

(d) Disconnect the lug for the grounding strap from the electrical stud on the wing rib.

(e) Store the washer and nut in a bag for the installation procedure.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Table 402/57-21-21-993-809

ITEM	BOLT	REMOVAL ORDER	LOCATION
[4]	BACB30US7K12M 0.4375 inch (11.1125 mm) dia.	J	Middle Upper and Lower
[3]	BACB30US8K18M 0.5000 inch (12.7000 mm) dia.	H	Upper Aft (Front)
[1]	BACB30US8K27M 0.5000 inch (12.7000 mm) dia.	G	Lower Forward (Front)
[3]	BACB30US8K18M 0.5000 inch (12.7000 mm) dia.	F	Lower Aft (Front)
[1]	BACB30US8K27M 0.5000 inch (12.7000 mm) dia.	E	Upper Forward (Back)
[2]	BACB30US8K20M 0.5000 inch (12.7000 mm) dia.	D	Upper Aft (Back)
[1]	BACB30US8K27M 0.5000 inch (12.7000 mm) dia.	C	Lower Forward (Back)
[2]	BACB30US8K20M 0.5000 inch (12.7000 mm) dia.	B	Lower Aft (Back)
[1]	BACB30US8K27M 0.5000 inch (12.7000 mm) dia.	A	Upper Forward (Front)

SUBTASK 57-21-21-100-001

(10) Remove the excess corrosion inhibitiing compound - ZC-027L, A50001, or Cor-Ban 27L Compound, G50237, with a hard resin phenolic scraper, STD-1064.

SUBTASK 57-21-21-900-001

(11) Use the overhead crane and the sling, SPL-2044, to move the winglet to a storage location.

LOM ALL

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-21-21-400-801

3. Winglet Installation

(Figure 401 or Figure 402)

A. General

LOM 461-463

(1) Regulatory requirements refer to the Supplemental Type Certificate (STC) ST00830SE.

NOTE: Supplemental Type Certificate (STC) ST00830SE changes some wing structures for retrofit installation of the Aviation Partners Boeing (APB) Blended Winglets.

LOM ALL

(2) This task gives the procedure to install the winglet on 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)
33-43-10-420-801	Position Lights - Connect the Electrical Connector (P/B 201)
33-43-10-710-801	Position Lights - Operational Test (P/B 201)
33-44-00-710-801	Anti-Collision Lights - Operational Test (P/B 501)
33-44-13-420-801	Anti-Collision Lights - Connect the Electrical Connector (P/B 201)
51-21-11-150-801	Paint Stripping (P/B 701)
51-31-00-390-806	Aerodynamic Smoother Application (P/B 201)
57-21-21-300-801	Winglet - Painting (P/B 701)
57-21-23-400-801	Dry Bay Access Doors Installation (P/B 401)
57-21-23-790-801	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
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-1587	Wrench - Torque, 30 in-lbs (4 N-m) Part #: 5718A42 Supplier: 3A054 Opt 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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Reference	Description
SPL-2044	Sling - Winglet Part #: C57002-70 Supplier: 81205 Part #: HSE 737-0010-7 Supplier: 3F4Z0 Opt Part #: C57002-15 Supplier: 81205 Opt Part #: HSE 737-0010-1 Supplier: 3F4Z0
STD-247	Crane - Lift, 250 lb Capacity, Lift Range 20 to 60 in
STD-12395	Load Cell Equipment

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
A50001	compound - corrosion inhibiting - ZC-027L	ZC-027L
C00528	Compound - Corrosion Preventive, Petroleum Hot Application (Soft Film)	MIL-C-11796 Class III
G50237	Compound - Corrosion Inhibiting, Non-drying - Cor-Ban 27L	BMS3-38

E. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
10	Winglet	57-21-21-02-051	LOM 406
		57-21-21-02A-045	LOM 406
		57-21-21-02B-050	LOM 406
		57-21-21-02C-045	LOM 406
		57-21-21-02D-045	LOM 406
		57-21-21-02E-045	LOM 406
		57-21-21-06-100	LOM 461-463
		57-21-21-06-101	LOM 461-463
		57-30-51-01-055	LOM 402, 404, 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-460, 464-999
		57-30-51-01-060	LOM 402, 404, 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-460, 464-999

F. Location Zones

Zone	Area
500	Left Wing
527	Left Winglet
534	Left Wing - Dry Bay
600	Right Wing
627	Right Winglet

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Zone	Area
634	Right Wing - Dry Bay

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

LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-460, 464-999

H. Installation

SUBTASK 57-21-21-390-001

(1) Prepare to install the winglet [10].

(a) To install the winglet [10], a second person is needed.

SUBTASK 57-21-21-370-001

(2) Touch-up the paint on the winglet [10] as required.

NOTE: The winglet weight and center of gravity (CG) is critical. You must strip the paint on the winglet, as given in the procedure referenced, before the repaint procedure can start. Whenever possible, you must prevent application of excess paint, such as logo color masking. The requirement is a zero net increase in winglet weight after the repaint procedure is completed.

(a) Do this task: Paint Stripping, TASK 51-21-11-150-801.

SUBTASK 57-21-21-390-002

(3) Apply a thin coat of corrosion inhibitiing compound - ZC-027L, A50001, or Cor-Ban 27L Compound, G50237, to the entire faying surface of rib 27 on the wing, and the entire faying surface of the winglet [10] root rib before the installation.

(a) Make sure that the chamfered drainage passages on the winglet [10] wing root, below the barrel nut openings, are not closed with corrosion inhibiting compound.

SUBTASK 57-21-21-200-001

(4) Do a check the locking feature of the barrel nuts in the winglet [10] as follows (Figure 401):

(a) Refer to the table: Winglet Attachment Bolt Installation Order/Table 403.

(b) Apply a thin coat of corrosion inhibitiing compound - ZC-027L, A50001, or Cor-Ban 27L Compound, G50237, to all surfaces of the bolt threads.

(c) Install the four bolts [1] and four washers [5], two bolts [2] and two washers [5], two bolts [3] and two washers [5], one at a time, in number order, until seated in the correct hole.

(d) Install the 10 bolts [4] and 10 washers [6], one at a time, until seated in the correct holes.

(e) Tighten each of the four bolts [1], two bolts [2] and two bolts [3] in proper number order.

1) Use a torque wrench (30 in-lbs), COM-1587, set to 18 in-lb (2 N·m).

NOTE: These bolts are 0.5000 in. (12.7000 mm) diameter.

2) Apply force with the torque wrench in a clockwise direction.

3) If the bolts can be tightened until the threads protrude, then the barrel nuts must be replaced.

(f) Tighten each of the 10 bolts [4].

ECCN 9E991 BOEING PROPRIETARY - See title page for details

1) Use a torque wrench (30 in-lbs), COM-1587, to 14.0 in-lb (1.6 N·m).

NOTE: These bolts are 0.4375 in. (11.1125 mm) diameter.

2) Apply force with the torque wrench in a clockwise direction.

3) If the bolts can be torqued until the threads protrude, then the barrel nuts in the winglet [10] must be replaced.

SUBTASK 57-21-21-960-001

(5) To replace the barrel nuts in the winglet [10], do these steps:

(a) Remove the retainer and barrel nut through the access holes in the wing root of the winglet [10].

(b) Replace the barrel nut [14] for bolt [1], bolt [2] and bolt [3].

(c) Replace the barrel nut [16] for bolt [4].

(d) Install the barrel nut [14] with retainer [13] through the access holes in the wing root of the winglet [10].

(e) Install the barrel nut [16] with retainer [15] through the access holes in the wing root of the winglet [10].

SUBTASK 57-21-21-420-003

(6) Install the sling, SPL-2044, on the winglet [10] (Figure 401).

NOTE: The sling equipment has three attachment fittings, six screws and washers, a sling strap assembly, and a load cell, STD-12395.

(a) Remove the 6 bolts from the replacement winglet [10] where the attachment fittings for the sling, SPL-2044, will be attached to the winglet [10].

1) Store the 6 screws in a bag.

(b) Attach the 3 attachment fittings to the winglet with 6 screws and washers.

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 6 bolts to 50 in-lb (6 N·m) to 80 in-lb (9 N·m).

(c) Attach the sling straps to the 3 attachment fittings with the short line attached to the upper leading edge of the winglet [10].

SUBTASK 57-21-21-420-005

(7) Attach the sling, SPL-2044, to the overhead, 250 lb capacity lift crane, STD-247 (Figure 401).

NOTE: The winglet weighs approximately 137 lbs.

SUBTASK 57-21-21-800-002

WARNING MAKE SURE THAT THE FORCE WITHOUT THE TOOL WEIGHT IS NO MORE THAN THE SPECIFIED FORCE. A FORCE THAT IS MORE THAN THE SPECIFIED FORCE CAN CAUSE INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT.

(8) Use the load cell, STD-12395, to make sure that the force used when lifting the winglet [10] is not more than 150 lb (68 kg).

NOTE: The value for the weight of the winglet is 140 lb (64 kg).

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 57-21-21-500-002

(9) Operate the overhead crane to lift the sling until the 3 lines are equally supporting the winglet [10].

(a) Balance the overhead crane tension, so you can tighten the bolts that hold the winglet [10] to the wing, without damage to the bolt threads or to the winglet [10].

SUBTASK 57-21-21-400-001

(10) Connect the forward grounding strap [12] and aft grounding strap [11] (Figure 401).

(a) You must control movement of the sling and the winglet [10] as you install the attachment fasteners for the grounding straps.

NOTE: A second person is recommended to control the movement of the winglet which is suspended from the crane and sling. A gust of wind could cause the winglet to move as you install the attachment fasteners for the grounding straps.

(b) Do not pull the winglet [10] away from the wing, the forward and aft grounding straps are attached between the winglet [10] and the wing outboard rib.

(c) Install the lug of the grounding strap on the electrical stud on the wing rib.

(d) Install a washer [8] and nut [9] and tighten.

SUBTASK 57-21-21-420-021

(11) Connect the anti-collision and position light connectors to the winglet [10] electrical receptacles [18] (View A-A, Figure 401):

(a) Do this task: Anti-Collision Lights - Connect the Electrical Connector, TASK 33-44-13-420-801.

(b) Do this task: Position Lights - Connect the Electrical Connector, TASK 33-43-10-420-801.

SUBTASK 57-21-21-420-007

(12) Install the winglet [10] (Figure 401).

(a) Refer to the table: Winglet Attachment Bolt Installation Order/Table 403.

(b) If you did not keep the bolts in separate bags or you replace the bolt, make sure the bolt grip length is correct for the installation location.

(c) Apply a thin coat of corrosion inhibitiing compound - ZC-027L, A50001, or Cor-Ban 27L Compound, G50237, to all surfaces of the bolt threads, shanks, and under the bolt head prior to installation.

(d) Install the four bolts [1], two bolts [2] and two bolts [3] with the order sequence in the table.

1) Refer to the table: Winglet Attachment Bolt Installation Order/Table 403.

2) Do not tighten the bolts to the final torque value at this time.

a) Install of the bolt [1] and washer [5] one at a time in number order until seated in the correct hole.

b) Install of the bolt [2] and washer [5] one at a time in number order until seated in the correct hole.

<1> Apply sealant, A00247, to the faying surface between the radius filler [7] and rib 27.

<2> Position the radius filler [7] before you install the bolt [2] and washer [5].

ECCN 9E991 BOEING PROPRIETARY - See title page for details

c) Install of the bolt [3] and washer [5] one at a time in number order until seated in the correct hole.

(e) Install the 10 bolts [4] and washers [6], one at a time, until seated; do not tighten the bolts to the final torque value at this time.

Table 403/57-21-21-993-804 Winglet Attachment Bolt Installation Order

ITEM	BOLT	INSTALLATION ORDER	LOCATION	TORQUE
[1]	BACB30US8K27M 0.5000 inch (12.7000 mm) dia.	A	Upper Forward (Front)	600 in-lb (67.8 N·m) - 700 in-lb (79.09 N·m)
[2]	BACB30US8K20M 0.5000 inch (12.7000 mm) dia.	B	Lower Aft (Back)	600 in-lb (67.8 N·m) - 700 in-lb (79.09 N·m)
[1]	BACB30US8K27M 0.5000 inch (12.7000 mm) dia.	C	Lower Forward (Back)	600 in-lb (67.8 N·m) - 700 in-lb (79.09 N·m)
[2]	BACB30US8K20M 0.5000 inch (12.7000 mm) dia.	D	Upper Aft (Back)	600 in-lb (67.8 N·m) - 700 in-lb (79.09 N·m)
[1]	BACB30US8K27M 0.5000 inch (12.7000 mm) dia.	E	Upper Forward (Back)	600 in-lb (67.8 N·m) - 700 in-lb (79.09 N·m)
[3]	BACB30US8K18M 0.5000 inch (12.7000 mm) dia.	F	Lower Aft (Front)	600 in-lb (67.8 N·m) - 700 in-lb (79.09 N·m)
[1]	BACB30US8K27M 0.5000 inch (12.7000 mm) dia.	G	Lower Forward (Front)	600 in-lb (67.8 N·m) - 700 in-lb (79.09 N·m)
[3]	BACB30US8K18M 0.5000 inch (12.7000 mm) dia.	H	Upper Aft (Front)	600 in-lb (67.8 N·m) - 700 in-lb (79.09 N·m)
[4]	BACB30US7K12M 0.4375 inch (11.1125 mm) dia.	J	Middle Upper and Lower	400 in-lb (45.2 N·m) - 450 in-lb (50.84 N·m)

(f) Tighten the four bolts [1], two bolts [2] and two bolts [3] in the order sequence in the table.

1) Refer to the table for the bolt torque values: Winglet Attachment Bolt Installation Order/Table 403.

2) Apply force with the torque wrench in a clockwise direction.

(g) Tighten each of the 10 bolts [4].

1) Refer to the table for the bolt torque value: Winglet Attachment Bolt Installation Order/Table 403.

2) Apply force with the torque wrench in a clockwise direction.

SUBTASK 57-21-21-420-019

(13) Make sure that the misfair is in the requirements in Figure 401.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-460, 464-999 (Continued)

SUBTASK 57-21-21-020-006

(14) Remove the sling, SPL-2044, from the winglet [10].

(a) Remove the six bolts and washers from the 3 attachment fittings.

(b) Install the six bolts and washers in the threaded storage holes in the ends of the attachment fittings.

(c) Apply compound, C00528, to the six holes in the winglet [10] and immediately install the bolts.

(d) Install the 6 bolts.

(e) Tighten the bolts to 30 in-lb (3 N·m) to 40 in-lb (5 N·m).

SUBTASK 57-21-21-390-003

(15) Apply a seal to the external gap on the upper surface of the winglet [10] between point A and B with sealant, A00247 (Figure 401).

NOTE: It is optional to use sealant, A02315.

(a) To apply the sealant, refer to this task: Aerodynamic Smoother Application, TASK 51-31-00-390-806.

SUBTASK 57-21-21-790-001

(16) If the Absolute Vapor Seal has been moved or changed, do the vapor seal leak check of the dry bay.

(a) Do this task: Vapor Seal Leak Check, TASK 57-21-23-790-801.

LOM 461-463

I. Installation

SUBTASK 57-21-21-390-007

(1) Prepare to install the winglet [10].

(a) To install the winglet [10], a second person is needed.

SUBTASK 57-21-21-370-004

WARNING DO NOT APPLY TOO MUCH PAINT TO THE WINGLET. TOO MUCH PAINT ON THE WINGLET CAN MOVE THE CENTER OF GRAVITY OF THE WINGLET. DAMAGE TO EQUIPMENT, AND INJURIES TO PERSONNEL CAN OCCUR.

(2) Touch-up the paint on the winglet if required.

NOTE: The winglet weight and center of gravity (CG) is critical. You must strip the paint on the winglet, as given in the procedure referenced, before the repaint procedure can start. Whenever possible, you must prevent application of excess paint, such as logo color masking. The requirement is a zero net increase in winglet weight after the repaint procedure is completed.

(a) Do this task: (Paint Stripping, TASK 51-21-11-150-801).

(b) Do the task : (Winglet - Painting, TASK 57-21-21-300-801).

SUBTASK 57-21-21-390-008

(3) Apply a thin coat of corrosion inhibitiing compound - ZC-027L, A50001, or Cor-Ban 27L Compound, G50237, to the entire faying surface of rib 27 on the wing, and the entire faying surface of the winglet [10] root rib before the installation.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

LOM 461-463 (Continued)

(a) Make sure that the chamfered drainage passages on the winglet [10] wing root, below the barrel nut openings, are not closed with corrosion inhibiting compound.

SUBTASK 57-21-21-200-003

(4) Do a check the locking feature of the barrel nuts in the winglet [10] as follows (Figure 402):

(a) Refer to the table: Table 404.

(b) Apply a thin coat of corrosion inhibitiing compound - ZC-027L, A50001, or Cor-Ban 27L Compound, G50237, to all surfaces of the bolt threads.

(c) Install the four bolts [1] and four washers [5], two bolts [2] and two washers [5], two bolts [3] and two washers [5], one at a time, in number order, until seated in the correct hole.

(d) Install the 10 bolts [4], one at a time, until seated in the correct holes.

(e) Tighten each of the four bolts [1], two bolts [2] and two bolts [3] in proper number order.

1) Use a torque wrench (30 in-lbs), COM-1587, set to 18 in-lb (2 N·m).

NOTE: These bolts are 0.5000 in. (12.7000 mm) diameter.

2) Apply force with the torque wrench in a clockwise direction.

3) If the bolts can be tightened until the threads protrude, then the barrel nuts must be replaced.

(f) Tighten each of the 10 bolts [4].

1) Use a torque wrench (30 in-lbs), COM-1587, to 14 in-lb (2 N·m).

NOTE: These bolts are 0.4375 in. (11.1125 mm) diameter.

2) Apply force with the torque wrench in a clockwise direction.

3) If the bolts can be torqued until the threads protrude, then the barrel nuts in the winglet [10] must be replaced.

SUBTASK 57-21-21-960-002

(5) To replace the barrel nuts in the winglet, do these steps:

(a) Remove the retainer and barrel nut through the access holes in the wing root of the winglet [10].

(b) Replace the barrel nut [14] for bolt [1], bolt [2] and bolt [3].

(c) Replace the barrel nut [16] for bolt [4].

(d) Install the barrel nut [14] with retainer [13] through the access holes in the wing root of the winglet [10].

(e) Install the barrel nut [16] with retainer [15] through the access holes in the wing root of the winglet [10].

SUBTASK 57-21-21-420-015

(6) Install the sling, SPL-2044, on the winglet (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 6 bolts from the replacement winglet [10] where the attachment fittings for the sling, SPL-2044, will be attached to the winglet [10].

1) Store the 6 screws in a bag.

(b) Attach the 3 attachment fittings to the winglet [10] with 6 screws and washers.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

1) Tighten the bolts to 50 in-lb (6 N·m) to 80 in-lb (9 N·m).

(c) Attach the sling straps to the 3 attachment fittings with the short line attached to the upper leading edge of the winglet [10].

SUBTASK 57-21-21-420-016

(7) Attach the sling, SPL-2044, to the overhead, 250 lb capacity lift crane, STD-247 (Figure 402).

NOTE: The winglet weighs approximately 137 lb (62 kg).

SUBTASK 57-21-21-800-004

WARNING	MAKE SURE THAT THE FORCE WITHOUT THE TOOL WEIGHT IS NO MORE THAN THE SPECIFIED FORCE. A FORCE THAT IS MORE THAN THE SPECIFIED FORCE CAN CAUSE INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT.

(8) Use the load cell, STD-12395, to make sure that the force used when lifting the winglet [10] is not more than 150 lb (68 kg).

NOTE: The value for the weight of the winglet is 140 lb (64 kg).

SUBTASK 57-21-21-500-004

(9) Operate the overhead crane to lift the sling until the 3 lines are equally supporting the winglet [10].

(a) Balance the overhead crane tension, so you can tighten the bolts that hold the winglet [10] to the wing, without damage to the bolt threads or to the winglet [10].

SUBTASK 57-21-21-410-004

(10) Connect the forward grounding strap [12] and aft grounding strap [11] (Figure 402).

(a) You must control movement of the sling and the winglet [10] as you install the attachment fasteners for the grounding straps.

NOTE: A second person is recommended to control the movement of the winglet which is suspended from the crane and sling. A gust of wind could cause the winglet to move as you install the attachment fasteners for the grounding straps.

(b) Do not pull the winglet [10] away from the wing, the forward and aft grounding straps are attached between the winglet [10] and the wing outboard rib.

(c) Install the lug of the grounding strap on the electrical stud on the wing rib.

(d) Install a washer [8] and nut [9] and tighten.

SUBTASK 57-21-21-420-022

(11) Connect the anti-collision and position light connectors to the winglet [10] electrical receptacles [18] (View A-A, Figure 402):

(a) Do this task: Anti-Collision Lights - Connect the Electrical Connector, TASK 33-44-13-420-801.

(b) Do this task: Position Lights - Connect the Electrical Connector, TASK 33-43-10-420-801.

SUBTASK 57-21-21-420-018

(12) Install the winglet [10] (Figure 402).

(a) Refer to the table: Table 404.

(b) If you did not keep the bolts in separate bags or you replace the bolt, make sure the bolt grip length is correct for the installation location.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

LOM 461-463 (Continued)

(c) Apply a thin coat of corrosion inhibitiing compound - ZC-027L, A50001, or Cor-Ban 27L Compound, G50237, to all surfaces of the bolt threads, shanks, and under the bolt head prior to installation.

(d) Install the four bolts [1], two bolts [2] and two bolts [3] with the order sequence in the table.

1) Refer to the table: Table 404.

2) Do not tighten the bolts to the final torque value at this time.

a) Install the bolt [1] and washer [5] one at a time in number order until seated in the correct hole.

b) Install the two bolts [2] and washers [5] one at a time in number order until seated in the correct hole.

c) Install the two bolts [3] and washers [5] one at a time in number order until seated in the correct hole.

(e) Install the 10 bolts [4] and washers [6], one at a time, until seated; do not tighten the bolts to the final torque value at this time.

Table 404/57-21-21-993-805 Winglet Attachment Bolt Installation Order

ITEM	BOLT	INSTALLATION ORDER	LOCATION	TORQUE
[1]	BACB30US8K26 0.5000 inch (12.7000 mm) dia.	A	Upper Forward (Front)	600 in-lb (67.8 N·m) - 700 in-lb (79.1 N·m)
[2]	BACB30US8K18 0.5000 inch (12.7000 mm) dia.	B	Lower Aft (Back)	600 in-lb (67.8 N·m) - 700 in-lb (79.1 N·m)
[1]	BACB30US8K26 0.5000 inch (12.7000 mm) dia.	C	Lower Forward (Back)	600 in-lb (67.8 N·m) - 700 in-lb (79.1 N·m)
[2]	BACB30US8K18 0.5000 inch (12.7000 mm) dia.	D	Upper Aft (Back)	600 in-lb (67.8 N·m) - 700 in-lb (79.1 N·m)
[1]	BACB30US8K26 0.5000 inch (12.7000 mm) dia.	E	Lower Forward (Front)	600 in-lb (67.8 N·m) - 700 in-lb (79.1 N·m)
[3]	BACB30US8K18 0.5000 inch (12.7000 mm) dia.	F	Upper Aft (Front)	600 in-lb (67.8 N·m) - 700 in-lb (79.1 N·m)
[1]	BACB30US8K26 0.5000 inch (12.7000 mm) dia.	G	Upper Forward (Back)	600 in-lb (67.8 N·m) - 700 in-lb (79.1 N·m)
[3]	BACB30US8K18 0.5000 inch (12.7000 mm) dia.	H	Lower Aft (Front)	600 in-lb (67.8 N·m) - 700 in-lb (79.1 N·m)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

LOM 461-463 (Continued)

Table 404/57-21-21-993-805 Winglet Attachment Bolt Installation Order (Continued)

ITEM	BOLT	INSTALLATION ORDER	LOCATION	TORQUE
[4]	BACB30US7K12 0.4375 inch (11.1125 mm) dia.	J — S	Middle Upper and Lower	400 in-lb (45.2 N·m) - 450 in-lb (50.8 N·m)

(f) Tighten the four bolts [1], two bolts [2] and two bolts [3] in the order sequence in the table.

1) Refer to the table for the bolt torque values: Table 404.

2) Apply force with the torque wrench in a clockwise direction.

(g) Tighten each of the 10 bolts [4] in the order sequence in the table.

1) Refer to the table for the bolt torque value: Table 404.

2) Apply force with the torque wrench in a clockwise direction.

SUBTASK 57-21-21-420-020

(13) Make sure that the misfair is in the requirements in (Figure 402).

SUBTASK 57-21-21-020-021

(14) Remove the sling, SPL-2044, from the winglet [10].

(a) Remove the six bolts and washers from the 3 attachment fittings.

(b) Install the six bolts and washers in the threaded storage holes in the ends of the attachment fittings.

(c) Apply compound, C00528, to the six holes in the winglet [10] and immediately install the bolts.

(d) Install the 6 bolts.

(e) Tighten the bolts to 30 in-lb (3 N·m)-40 in-lb (5 N·m).

SUBTASK 57-21-21-390-009

(15) Apply a seal to the external gap on the upper surface of the winglet [10] between point A and B with sealant, A00247 (Figure 402).

NOTE: It is optional to use sealant, A02315.

(a) To apply the sealant, refer to this task: Aerodynamic Smoother Application, TASK 51-31-00-390-806.

SUBTASK 57-21-21-790-002

(16) If the Absolute Vapor Seal has been moved or changed, do the vapor seal leak check of the dry bay.

(a) Do this task: Vapor Seal Leak Check, TASK 57-21-23-790-801.

LOM ALL

J. Put the Airplane Back to the Usual Condition

SUBTASK 57-21-21-410-002

(1) Install these access doors on the left or right wing.

(a) Close these access doors.

Number	Name/Location
534BB	Dry Bay Tank Access Door - Left Wing Station 748
634BB	Dry Bay Tank Access Door - Right Wing Station 748

ECCN 9E991 BOEING PROPRIETARY - See title page for details

1) Do this task: Dry Bay Access Doors Installation, TASK 57-21-23-400-801.

SUBTASK 57-21-21-090-001

(2) Remove the ladders, work platform, COM-2480, or maintenance platform, COM-659.

SUBTASK 57-21-21-440-001

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

SUBTASK 57-21-21-440-002

(4) Do this task: Leading Edge Flaps and Slats - Activation, TASK 27-81-00-440-801.

SUBTASK 57-21-21-860-009

(5) Remove the safety tags and close these circuit breakers:

Remove the safety tags and close these circuit breakers:

CAPT Electrical System Panel, P18-3

Row	Col	Number	Name
A	12	C00113	EXTERIOR LIGHTING POSITION RIGHT
A	13	C00114	EXTERIOR LIGHTING POSITION LEFT
B	13	C00115	EXT LIGHTING ANTI COLLISION WHITE

SUBTASK 57-21-21-710-001

(6) Do this task: Position Lights - Operational Test, TASK 33-43-10-710-801.

SUBTASK 57-21-21-710-002

(7) Do this task: Anti-Collision Lights - Operational Test, TASK 33-44-00-710-801.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

L88839 S0006581562_V5

Boeing Winglet Installation
Figure 401/57-21-21-990-801 (Sheet 1 of 4)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

RIB 27
(VIEW IN THE OUTBOARD DIRECTION)

A-A

BOLT INSTALLATION SEQUENCE

B

NOTE:

1. A THRU H ARE THE ORDER OF THE INSTALLATION FOR THE BOLTS.
2. H 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)

L99537 S0006581563_V5

Boeing Winglet Installation
Figure 401/57-21-21-990-801 (Sheet 2 of 4)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

2 ONLY BOLT [2] INSTALLATION

3 APPLY CORROSION INHIBITING COMPOUND

462319 S0000142206_V2

Boeing Winglet Installation
Figure 401/57-21-21-990-801 (Sheet 3 of 4)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

466937 S0000142754_V2

Boeing Winglet Installation
Figure 401/57-21-21-990-801 (Sheet 4 of 4)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

L88839 S0006581562_V5

APB Winglet Installation
Figure 402/57-21-21-990-810 (Sheet 1 of 5)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

2274540 S0000512701_V2

APB Winglet Installation
Figure 402/57-21-21-990-810 (Sheet 2 of 5)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

RIB 27
(VIEW IN THE OUTBOARD DIRECTION)

A-A

BOLT INSTALLATION SEQUENCE

B

NOTE:

1. A THRU H ARE THE ORDER OF THE INSTALLATION FOR THE BOLTS.
2. H 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)

1413322 S0000254810_V4

APB Winglet Installation
Figure 402/57-21-21-990-810 (Sheet 3 of 5)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

APB Winglet Installation
Figure 402/57-21-21-990-810 (Sheet 4 of 5)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

E-E

F-F

1413777 S0000254831_V4

APB Winglet Installation
Figure 402/57-21-21-990-810 (Sheet 5 of 5)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-21-21-000-803

4. Blended Winglet Tip Fairing Removal

(Figure 403)

A. General

(1) This task gives the procedure to remove the blended winglet tip fairing from the left or right winglet.

B. References

Reference	Title
20-40-11-910-801	Static Grounding (P/B 201)
SRM 51-40-02	Structural Repair 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-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. Prepare for the Removal

SUBTASK 57-21-21-860-012

(1) Make sure the airplane is correctly grounded to an approved and identified ground.

(a) Do this task: Static Grounding, TASK 20-40-11-910-801.

SUBTASK 57-21-21-480-002

(2) Get a ladder or work platform, COM-2480, or maintenance platform, COM-659.

SUBTASK 57-21-21-480-003

(3) 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.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

F. Blended Winglet Tip Fairing Removal

SUBTASK 57-21-21-020-026

(1) Remove the rivets [27]. Refer to SRM 51-40-02.

SUBTASK 57-21-21-020-027

(2) Remove the bolts [26].

SUBTASK 57-21-21-020-028

(3) Remove and retain the shim [29] and the filler [28] if they are not damaged.

SUBTASK 57-21-21-100-004

(4) If necessary, remove sealant with a hard resin phenolic scraper, STD-1064.

SUBTASK 57-21-21-020-029

(5) Remove the fairing [25].

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(LEFT SIDE IS SHOWN, RIGHT SIDE IS OPPOSITE)

NOTES:

1. PREPACK THIS AREA WITH BMS 5-95 SEALANT AS GIVEN IN SOPM 20-50-19.
2. CUT TIP FAIRING EDGE TO A MAXIMUM OF 0.3 INCH (7.62 mm), IF NECESSARY TO GET THE GAP IN TOLERANCE. APPLY A CHEMICAL CONVERSION COATING TO THE BARE SURFACES. REFER TO 51-20-01. APPLY ONE COAT OF BMS 10-79, TYPE III PRIMER TO THE BARE SURFACES. REFER TO SOPM 20-44-04.
3. FAY SURFACE ELECTRICAL BOND THIS AREA AS GIVEN IN SOPM 20-11-03, CATEGORY ONE.
4. CUT ARROWHEAD EDGE TO GET THE MISMATCH IN TOLERANCE. APPLY A CHEMICAL CONVERSION COATING TO THE BARE SURFACES. REFER TO 51-20-01. APPLY ONE COAT OF BMS 10-79, TYPE III PRIMER TO THE BARE SURFACES. REFER TO SOPM 20-44-04.

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Blended Winglet Tip Fairing Installation
Figure 403/57-21-21-990-813 (Sheet 1 of 5)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Blended Winglet Tip Fairing Installation
Figure 403/57-21-21-990-813 (Sheet 2 of 5)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

B-B

C-C

2814767 S0000649047_V1

Blended Winglet Tip Fairing Installation
Figure 403/57-21-21-990-813 (Sheet 3 of 5)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Blended Winglet Tip Fairing Installation
Figure 403/57-21-21-990-813 (Sheet 4 of 5)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(VIEW IS ROTATED CLOCKWISE)

D-D

2814791 S0000649049_V1

Blended Winglet Tip Fairing Installation
Figure 403/57-21-21-990-813 (Sheet 5 of 5)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-21-21-400-803

5. Blended Winglet Tip Fairing Installation

(Figure 403)

A. General

(1) This task gives the procedure to install the blended winglet tip fairing on the left or right winglet.

B. References

Reference	Title
SOPM 20-11-03	Repair of Electrical Terminations and Electrical Bonding Areas
SOPM 20-44-04	Application of Urethane Compatible Primer
SOPM 20-50-11	Standard Overhaul Practices Manual
SOPM 20-50-19	General Sealing
SOPM 20-50-20	How to Make and Install Resin Bond Laminated Shims and Solid Fillers
SRM 51-10-02	Structural Repair Manual
SRM 51-20-01	Structural Repair Manual
SRM 51-40-02	Structural Repair 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-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
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
C00175	Primer - Urethane Compatible, Corrosion Resistant	BMS10-79 Type III
G51401	Filler - Flat, Rectangular, Aluminum Alloy	BACF3F

E. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
25	Fairing	57-21-21-12-600	LOM 402, 404, 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-460, 464-999

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

AMM Item	Description	AIPC Reference	AIPC Effectivity
25 (cont.)		57-21-21-12-605	LOM 402, 404, 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-460, 464-999
		57-21-21-12A-610	LOM 402, 404, 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-460, 464-999
		57-21-21-12A-615	LOM 402, 404, 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-460, 464-999
		57-21-21-16-640	LOM 406
		57-21-21-16-645	LOM 406
		57-21-21-17-610	LOM 406
		57-21-21-17-615	LOM 406
		57-21-21-18-515	LOM 406
		57-21-21-18-520	LOM 406
		57-21-21-19-515	LOM 406
		57-21-21-19-520	LOM 406
		57-21-21-21-515	LOM 406
		57-21-21-21-520	LOM 406
		57-21-21-22-515	LOM 406
		57-21-21-22-520	LOM 406
		57-21-21-23-515	LOM 406
		57-21-21-23-520	LOM 406
		57-21-21-24-515	LOM 406
		57-21-21-24-520	LOM 406
		57-21-21-25-515	LOM 406
		57-21-21-25-520	LOM 406
		57-21-21-26-515	LOM 406
		57-21-21-26-520	LOM 406
		57-21-21-27-515	LOM 406
		57-21-21-27-520	LOM 406

F. Location Zones

Zone	Area
527	Left Winglet
627	Right Winglet

G. Prepare for the Installation

SUBTASK 57-21-21-210-001

(1) Inspect the attachment holes on the upper and lower surfaces. Refer to SRM 51-10-02.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 57-21-21-210-002

(2) Make sure that the holes are within the hole tolerances shown in Figure 403.

H. Blended Winglet Tip Fairing Installation

SUBTASK 57-21-21-420-025

(1) Put the fairing [25] in position and make sure all gaps and mismatches are within the tolerances shown in Figure 403.

SUBTASK 57-21-21-390-014

(2) If necessary, apply a protective coating to the bare surfaces of the aluminum parts as given in the flag notes of Figure 403. Refer to SRM 51-20-01 and SOPM 20-44-04.

SUBTASK 57-21-21-390-015

(3) Apply prepack sealant, A00247 as shown in Figure 403.

SUBTASK 57-21-21-390-016

(4) Apply fay surface seal to all part-to-part and part-to-shim interfaces with sealant, A00247 as shown in Figure 403 per SOPM 20-50-19.

NOTE: Do not apply sealant to the electrical bonding path as shown in Figure 403.

SUBTASK 57-21-21-420-024

(5) Install the fasteners to secure the fairing [25] to the winglet as follows:

(a) Tip fairing to leading edge skin:

1) Install two bolts [26] wet with sealant, A00247 per SOPM 20-50-19.

2) Install bolts [26] flush to flushness tolerance of -0.007 in. (-0.018 cm) to 0.000 in. (0.000 cm).

(b) Tip fairing to skin panels:

1) Apply one coat primer, C00175 on all hole surfaces. Refer to SOPM 20-44-04.

2) Install rivets [27] as given in SRM 51-40-02.

3) Install rivets [27] wet with sealant, A00247 per SOPM 20-50-19, Method 2..

4) Install rivets [27] flush to a flushness tolerance of -0.008 in. (-0.020 cm) to 0.000 in. (0.000 cm).

NOTE: Shaving of spindle and head is permitted.

(c) Tip fairing to the trailing edge arrowhead:

1) Install filler [28] between the tip fairing and arrowhead.

a) If mismatch is not within tolerance, make a new filler from filler, G51401. Refer to Figure 403.

b) Adjust the mismatch by selection of the correct thickness or by machining or sanding. Refer to SOPM 20-50-20.

c) Install shim [29] between tip fairing and arrowhead as necessary. Refer to SOPM 20-50-20.

d) Install rivets [27] double-flush and microshave rivets to a flushness tolerance of 0.003 in. (0.008 cm) to 0.000 in. (0.000 cm).

SUBTASK 57-21-21-390-017

(6) Apply aerodynamic sealant to all peripheral external tip fairing gaps with sealant, A00247 as given in SOPM 20-50-11.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 57-21-21-390-018

(7) Fay surface electrical bond tip fairing to the leading edge skin and trailing edge arrowhead in the hatched areas shown in Figure 403. Refer to SOPM 20-11-03, Category One.

I. Put the Airplane Back to Its Usual Condition

SUBTASK 57-21-21-080-001

(1) Remove the ladder or work platform, COM-2480 or maintenance platform, COM-659.

——— END OF TASK ———

TASK 57-21-21-000-805

6. Winglet Bulb Seal Removal

(Figure 404)

A. General

(1) This task includes the steps to remove the right or left winglet bulb seal.

B. Location Zones

Zone	Area
527	Left Winglet
627	Right Winglet

C. Prepare for the Removal

SUBTASK 57-21-21-010-005

(1) Do this task: Winglet Removal, TASK 57-21-21-000-801.

D. Bulb Seal Removal

SUBTASK 57-21-21-020-043

(1) Remove the forward seal [58] as follows:

(a) Remove the 11 bolts [43], 11 washers [44], and 11 nuts [45] that attach the forward seal [58].

(b) Keep and tag the removed fasteners for installation.

(c) Carefully remove the forward seal [58].

SUBTASK 57-21-21-020-044

(2) Remove the forward upper seal [59] as follows:

(a) Remove the eight bolts [46], eight washers [47] and eight nuts [48] that attach the forward upper seal [59].

(b) Keep and tag the removed fasteners for installation.

(c) Carefully remove the forward upper seal [59].

SUBTASK 57-21-21-020-045

(3) Remove the aft upper seal [61] as follows:

(a) Remove the 13 bolts [49], 13 washers [50] and 13 nuts [51] that attach the aft upper seal [61].

(b) Keep and tag the removed fasteners for installation.

(c) Carefully remove the aft upper seal [61].

SUBTASK 57-21-21-020-046

(4) Remove the forward lower seal [60] as follows:

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(a) Remove the 10 bolts [52], nine washers [53] and nine nuts [54] that attach the forward lower seal [60].

(b) Keep and tag the removed fasteners for installation.

(c) Carefully remove the forward lower seal [60].

SUBTASK 57-21-21-020-047

(5) Remove the aft lower seal [62] as follows:

(a) Remove the 12 bolts [55], 12 washers [56] and 12 nuts [57] that attach the aft lower seal [62].

(b) Keep and tag the removed fasteners for installation.

(c) Carefully remove the aft lower seal [62].

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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Winglet Bulb Seal Installation
Figure 404/57-21-21-990-816

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-21-21-400-805

7. Winglet Bulb Seal Installation

(Figure 404)

A. General

(1) This task includes the steps to install the right or left winglet bulb seal.

B. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
58	Forward seal	57-21-21-12-190	LOM 402, 404, 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-460, 464-999
		57-21-21-12A-140	LOM 402, 404, 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-460, 464-999
		57-21-21-16-140	LOM 406
		57-21-21-17-140	LOM 406
		57-21-21-18-140	LOM 406
		57-21-21-19-140	LOM 406
		57-21-21-21-140	LOM 406
		57-21-21-22-140	LOM 406
		57-21-21-23-140	LOM 406
		57-21-21-24-140	LOM 406
		57-21-21-25-140	LOM 406
		57-21-21-26-140	LOM 406
		57-21-21-27-140	LOM 406
		57-21-21-33-160	LOM 461-463
59	Forward upper seal	57-21-21-12-190	LOM 402, 404, 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-460, 464-999
		57-21-21-12A-160	LOM 402, 404, 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-460, 464-999
		57-21-21-16-160	LOM 406
		57-21-21-17-160	LOM 406
		57-21-21-18-160	LOM 406
		57-21-21-19-160	LOM 406
		57-21-21-21-160	LOM 406
		57-21-21-22-160	LOM 406
		57-21-21-23-160	LOM 406
		57-21-21-24-160	LOM 406
		57-21-21-25-160	LOM 406

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(Continued)

AMM Item	Description	AIPC Reference	AIPC Effectivity
59 (cont.)		57-21-21-26-160	LOM 406
		57-21-21-27-160	LOM 406
		57-21-21-33-180	LOM 461-463
60	Forward lower seal	57-21-21-12-210	LOM 402, 404, 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-460, 464-999
		57-21-21-12A-180	LOM 402, 404, 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-460, 464-999
		57-21-21-16-180	LOM 406
		57-21-21-17-180	LOM 406
		57-21-21-18-180	LOM 406
		57-21-21-19-180	LOM 406
		57-21-21-21-180	LOM 406
		57-21-21-22-180	LOM 406
		57-21-21-23-180	LOM 406
		57-21-21-24-180	LOM 406
		57-21-21-25-180	LOM 406
		57-21-21-26-180	LOM 406
		57-21-21-27-180	LOM 406
		57-21-21-33-200	LOM 461-463
61	Aft upper seal	57-21-21-12-230	LOM 402, 404, 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-460, 464-999
		57-21-21-12A-200	LOM 402, 404, 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-460, 464-999
		57-21-21-16-200	LOM 406
		57-21-21-17-200	LOM 406
		57-21-21-18-200	LOM 406
		57-21-21-19-200	LOM 406
		57-21-21-21-200	LOM 406
		57-21-21-22-200	LOM 406
		57-21-21-23-200	LOM 406
		57-21-21-24-200	LOM 406
		57-21-21-25-200	LOM 406
		57-21-21-26-200	LOM 406
		57-21-21-27-200	LOM 406

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

AMM Item	Description	AIPC Reference	AIPC Effectivity
61 (cont.)		57-21-21-33-220	LOM 461-463
62	Aft lower seal	57-21-21-12-250	LOM 402, 404, 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-460, 464-999
		57-21-21-12A-220	LOM 402, 404, 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-460, 464-999
		57-21-21-16-220	LOM 406
		57-21-21-17-220	LOM 406
		57-21-21-18-220	LOM 406
		57-21-21-19-220	LOM 406
		57-21-21-21-220	LOM 406
		57-21-21-22-220	LOM 406
		57-21-21-23-220	LOM 406
		57-21-21-24-220	LOM 406
		57-21-21-25-220	LOM 406
		57-21-21-26-220	LOM 406
		57-21-21-27-220	LOM 406
		57-21-21-33-240	LOM 461-463

C. Location Zones

Zone	Area
527	Left Winglet
627	Right Winglet

D. Winglet Bulb Seal Permitted Damage Limits

SUBTASK 57-21-21-210-003

(1) Permitted damage limits to the bulb seal at the wing to the winglet connection are as follows:

(a) Cuts or tears fully through the silicone rubber membrane of the bulb seal are permitted, if the length of the cut or tear is 0.50 in. (12.70 mm) maximum. Multiple cuts or tears on a single seal are permitted only if the distance between the damage locations is 2.0 in. minimum.

(b) Nicks or scratches in the silicone material that do not fully into the silicone rubber membrane of the bulb seal are permitted.

(c) Cuts, tears, wearing, and fraying of the Dacron fabric material exposing the silicone rubber material are permitted.

(d) Permanent setting/deformation of the bulb portion of the seal because of compression is permitted, if the protrusion dimension from the root of the winglet to the maximum protruding point of the seal is 0.140 in. (3.56 mm) minimum.

E. Winglet Bulb Seal Installation

SUBTASK 57-21-21-210-004

(1) Make sure that the winglet bulb seals are in the permitted damage limits.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 57-21-21-420-039

(2) Install the forward seal [58] as follows:

(a) Align the forward seal [58] and retainer with the attachment holes.

(b) Install the forward seal [58] with the 11 bolts [43], 11 washers [44], and 11 nuts [45].

(c) Torque the bolts [43] to 13 in-lb (1.5 N·m) - 18 in-lb (2.0 N·m).

SUBTASK 57-21-21-420-040

(3) Install the forward upper seal [59] as follows:

(a) Align the forward upper seal [59] and retainer with the attachment holes.

(b) Install the forward upper seal [59] with the eight bolts [46], eight washers [47] and eight nuts [48].

(c) Torque the bolts [46] to 13 in-lb (1.5 N·m) - 18 in-lb (2.0 N·m).

SUBTASK 57-21-21-420-041

(4) Install the aft upper seal [61] as follows:

(a) Align the aft upper seal [61] and retainer with the attachment holes.

(b) Install the aft upper seal [61] with the 13 bolts [49], 13 washers [50] and 13 nuts [51].

(c) Torque the bolts [49] to 13 in-lb (1.5 N·m) - 18 in-lb (2.0 N·m).

SUBTASK 57-21-21-420-042

(5) Install the forward lower seal [60] as follows:

(a) Align the forward lower seal [60] and retainer with the attachment holes.

(b) Install the forward lower seal [60] with the 10 bolts [52], nine washers [53] and nine nuts [54].

(c) Torque the bolts [52] to 13 in-lb (1.5 N·m) - 18 in-lb (2.0 N·m).

SUBTASK 57-21-21-420-043

(6) Install the aft lower seal [62] as follows:

(a) Align the aft lower seal [62] and retainer with the attachment holes.

(b) Install the aft lower seal [62] with the 12 bolts [55], 12 washers [56] and 12 nuts [57].

(c) Torque the bolts [55] to 13 in-lb (1.5 N·m) - 18 in-lb (2.0 N·m).

F. Put the Airplane Back to Its Usual Condition

SUBTASK 57-21-21-410-005

(1) Do this task: Winglet Installation, TASK 57-21-21-400-801.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

WINGLET - PAINTING/CLEANING

1. General

A. This procedure contains one task.

(1) This task is to prepare the winglet for painting.

TASK 57-21-21-300-801

2. Winglet - Painting

(Figure 701)

A. References

Reference	Title
51-21-11	PAINT STRIPPING

B. General

SUBTASK 57-21-21-370-003

(1) Significant weight addition to the winglet may cause a condition dangerous to flight safety. For this reason, painting over existing finishes is not permitted unless specifically approved by Aviation Partners Boeing. Application of a new finish equivalent to the initial finish is permissible only if the original finish is stripped using this procedure: PAINT STRIPPING, SUBJECT 51-21-11.

NOTE: Most of the exterior of the winglet is of composite construction, which may only be stripped abrasively.

(2) The total top coat dry film thickness shall not exceed an average of 4.8 mils (0.12 mm).

C. Masking Requirements

SUBTASK 57-21-21-950-001

(1) The three polished leading edge skins from the winglet root up to, but not including the wingtip fairing. This includes the navigation lens assembly mounted in the inboard leading edge skin.

SUBTASK 57-21-21-950-003

(2) The Drawing Identified Ground Support Equipment (GSE) attach locations that are not in use with exposed threads.

NOTE: If a fastener is an installed at the GSE location, then masking is not required.

SUBTASK 57-21-21-950-004

(3) Inboard surfaces at winglet station zero. Overspray is allowed onto inboard upper and lower skin edges. Overspray is not allowed on bulb seal. Refer to Figure 701 for overspray allowance and masking requirements.

SUBTASK 57-21-21-950-005

(4) The exposed portion of the aft position light glass lens.

SUBTASK 57-21-21-950-006

(5) If installed, the exposed portion of the anti-collision light glass lens.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

LEFT WINGLET
(RIGHT WINGLET IS OPPOSITE)
(VIEW IN THE INBOARD DIRECTION)

LEFT WINGLET
(RIGHT WINGLET IS OPPOSITE)
(VIEW IN THE OUTBOARD DIRECTION)

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Winglet Masking Requirements
Figure 701/57-21-21-990-807

ECCN 9E991 BOEING PROPRIETARY - See title page for details

WINGLET SEALS - REPAIRS

1. General

A. This procedure has tasks to repair the winglet seals.

B. The silicone bulb seals used in these areas are subject to two different types of failure or damage as follows:

(1) Cuts, nicks, splits or tears in the seal section are primarily a result of lack of care in handling and installation.

(2) Splice failure occurs on those continuous seals formed by splicing the ends of the extruded bulb section. Flexing of the seal causes separation of the bond between this material and the ends of the extruded section.

C. Seal repair procedures for the silicone rubber bulb seals are divided into three general methods:

(1) Method A is a procedure for repairs in which the cut and the separated surfaces are rejoined by adhesive only.

(2) Method B is a procedure for repairs with an adhesive reinforced with fabric. The fabric is embedded in the adhesive on the seal surface.

(3) Method C repair procedure is for the replacement of a section of seal with adhesive, and when necessary, fabric.

D. Adhesives used for repairs are in three category types as follows:

(1) Type I is a two-part, air-cured adhesive.

(a) Use type I adhesives only on those parts of the seal where it is not necessary to have a flexible bond.

(2) Type II is a one-part, air-cured adhesive. It is flexible at low temperatures.

(a) Use type II adhesives for repairs to the bulb on the bulb seals where it is necessary that the adhesive is flexible to make an air-tight seal.

(3) Type III is a quick repair air-cured adhesive (two-part kit). It is very flexible.

(a) Use type III adhesives for fast repairs. You can use it in all locations on the seal.

TASK 57-21-21-100-801

2. Seal Repair Procedure Surface Preparation

A. General

(1) Make all of the seal repairs with the seal in a position for easy access and when the load on the seal is as small as possible. For seals that are installed, it can be necessary to remove parts of the seal retainer to do work on the damaged area.

(2) Replace the seal if the damage is extensive.

B. Consumable Materials

Reference	Description	Specification
B00068	Alcohol - Denatured, Ethyl (Ethanol)	AMS 3002, MIL-E-51454 Type II
B00130	Alcohol - Isopropyl	TT-I-735
B00137	Abrasive - Garnet Coated Paper	
B00148	Solvent - Methyl Ethyl Ketone (MEK)	ASTM D740

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(Continued)

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)

C. Procedure

SUBTASK 57-21-21-010-004

(1) Make sure that there is access to the seal.

(a) If it is necessary, remove one or more sections of the seal retainer to get access to a damaged section of the seal.

SUBTASK 57-21-21-100-003

(2) Clean the area of the seals with the seal in a position for easy access, do the steps that follow:

(a) Rub the area and approximately 2 in. (51 mm) or more on all sides of the area with a clean cotton wiper, G00034 that is wet with one of the solvents that follow:

1) solvent, B00148

2) alcohol, B00068

3) alcohol, B00130.

(b) Lightly rub the surface to be repaired with the abrasive, B00137 (180 grit minimum).

(c) Wipe dry with a cotton wiper, G00034 before solvent evaporates.

1) If necessary repeat steps to fully remove dirt, oil, paint, and other soils.

NOTE: Clean surfaces are necessary to make a good bond.

END OF TASK

TASK 57-21-21-350-801

3. Seal Repair Procedures For Specified Types of Seal Damage

(Figure 801)

A. General

(1) Make all of the seal repairs with the seal in a position for easy access and when the load on the seal is as small as possible. For seals that are installed, it can be necessary to remove parts of the seal retainer to do work on the damaged area.

(2) Determine the type of repair that is necessary and the procedure to be used.

(a) Use fabric when a stronger bond is necessary.

(b) Replace the seal if the damage is extensive.

(c) Replace the repaired seal as quickly as possible.

(3) Adhesives used in this procedure as follows:

Table 801/57-21-21-993-810 Table Of Type I Adhesives

Bulk code	Description	Catalyst	Cure Time*[1]	BAC Process	Specification
RTV430 rubber base, A50025	Condensation Cure, Mouldmaking Rubber	Beta 5 catalyst, A50234*[2] Beta 11 catalyst, A50235*[3]	24 Hours for both catalysts	BAC 5010 Type 68	---

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*[1] Refer to manufacturer's instructions for specific cure times based on local conditions of where the product is used.
*[2] Mixing ratio is 10 parts RTV430 base to 1 part Beta 5 catalyst.
*[3] Mixing ratio is 10 parts RTV430 base to 1 part Beta 11 catalyst.

Table 802/57-21-21-993-811 Table Of Type II Adhesives

Bulk code	Description	Tack Free Time	Cure Time*[1]	BAC Process	Specification
Dow Corning 732 multi-purpose sealant, A50031	General purpose silicone adhesive/sealant	20 Minutes	24 Hours	BAC 5010 Type 60	MIL-A-46106
RTV 102 adhesive, A50067	One-Component Acetoxy Adhesive Sealants	20 Minutes	3 days at 77°F (25°C) and 50% relative humidity	BAC 5010 Type 60	MIL-A-46106
RTV 108 adhesive, A00635	One-Component Acetoxy Adhesive Sealants	20 Minutes	3 days at 77°F (25°C) and 50% relative humidity	BAC 5010 Type 60	MIL-A-46106

*[1] Refer to manufacturer's instructions for specific cure times based on local conditions of where the product is used.

Table 803/57-21-21-993-812 Table Of Type III Adhesives

Bulk code	Description	Primer*[1]	Cure Time*[2]	BAC Process	Specification
Dow Corning 93-076-1/2 RF sealant and catalyst kit, A50094	Two part, thixotripic silicone elastomer	Dow Corning PR-1204 prime coat, C50242 or PR 1204 primer, A50126	4 Hours at 185°F (85°C) or 2 Hours at 203°F (95°C)	BAC 5010 Type 68	---
Dow Corning 93-076-2 RF sealant and catalyst kit, A50233	Two part, thixotripic silicone elastomer	Dow Corning PR-1204 prime coat, C50242 or PR 1204 primer, A50126	4 Hours at 185°F (85°C) or 2 Hours at 203°F (95°C)	BAC 5010 Type 68	---

*[1] This product enhances bonding but is not mandatory for the sealant to fully cure.
*[2] Refer to manufacturer's instructions for specific cure times based on local conditions of where the product is used.

B. Consumable Materials

Reference	Description	Specification
A00635	Adhesive - RTV 108 Translucent Silicone Rubber RTV Paste, One-part	BAC5010 Type 60 Class A Grade 2 / MIL-A-46106 Type 1
A50025	Adhesive - Condensation Cure, Mouldmaking Rubber, Momentive Performance Materials RTV430 Base (Formerly GE Silicones)	
A50031	Sealant - Dow Corning 732 Multi-Purpose Sealant	MIL-A-46106
A50067	Adhesive - Silicone Rubber - RTV 102 (White)	MIL-A-46106 Group 1 Type 1, BAC5010 Type 60 Class A Grade 1

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Reference	Description	Specification
A50094	Sealant - Kit (Sealant & Catalyst), Dow Corning 93-076-1/2 RF (Formerly 93-076-1/2. Use until Stock depleted)	
A50126	Primer - Adhesive Bonding (Formerly Dow Corning 1204 Clear)	
A50233	Sealant - Kit (Sealant & Catalyst), Dow Corning 93-076-2 RF (Formerly 93-076-2. Use until Stock depleted)	
A50234	Catalyst - Momentive Performance Materials Beta 5 Catalyst	BAC5010 Type 68 Class C
A50235	Catalyst - Momentive Performance Materials Beta 11 Catalyst	BAC5010 Type 68 Class C
C50242	Primer - Dow Corning PR-1204 RTV Prime Coat	
G50228	Tape - 3M 436 Vibration Damping Tape (Formerly 3M Y436)	

C. Location Zones

Zone	Area
527	Left Winglet
627	Right Winglet

D. Repair Procedures for Specified Types of Seal Damage

SUBTASK 57-21-21-390-013

(1) Repair the damaged seal as follows (temporary repair):

(a) Hold the surfaces together.

(b) Apply 3M 436 Tape, G50228 or the equivalent on the damaged area.

(c) This repair is permitted until 90 days.

1) After 90 days, continue with the applicable repair procedure.

SUBTASK 57-21-21-390-010

(2) Repair a cut or split in the bulb section of a seal as follows:

(a) If the damage is a small cut or split (0.20 in. (5.08 mm) maximum length), do these steps:

1) Do the Seal Repair Procedure (Method A), TASK 57-21-21-350-802 to bond the damaged seal with one of the adhesives in the tables that follow:

a) Table Of Type I Adhesives/Table 801

b) Table Of Type II Adhesives/Table 802

c) Table Of Type III Adhesives/Table 803.

2) Push the surfaces tightly together to make sure that the adhesive fully touches the repair area.

3) Make sure that the adhesive cures the minimum time necessary.

4) Apply 3M 436 Tape, G50228 or the equivalent on the repaired area.

(b) If the damage is a large cut or split (1.00 in. (25.40 mm) maximum length), do these steps:

1) Push on the seal to open the cut.

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2) Carefully drill a hole in each end of the cut.

NOTE: A sharpened metal tube can be used as a drill bit to cut the holes.

3) Make the holes smooth and miter the edges.

4) Do the Seal Repair Procedure (Method A), TASK 57-21-21-350-802 to bond the damaged seal with one of the adhesives in the tables that follow:

a) Table Of Type II Adhesives/Table 802

b) Table Of Type III Adhesives/Table 803.

5) Push the surfaces tightly together to make sure that the adhesive fully touches the repair area.

6) Make sure that the adhesive cures the minimum time necessary.

7) Apply 3M 436 Tape, G50228 or the equivalent on the repaired area.

(c) If the damage to the seal is a large split (2.00 in. (50.80 mm) maximum length), do these steps:

1) Push on the seal to open the cut.

2) Carefully drill a hole in each end of the cut.

NOTE: A sharpened metal tube can be used as a drill bit to cut the holes.

3) Make the holes smooth and miter the edges.

4) Do the Seal Repair Procedure (Method B), TASK 57-21-21-350-803 to bond the damaged seal with one of the adhesives in the tables that follow:

a) Table Of Type I Adhesives/Table 801

b) Table Of Type II Adhesives/Table 802

c) Table Of Type III Adhesives/Table 803.

5) Cut the fabric to make an overlap of 0.50 in. (12.70 mm) on the sides and ends of the split.

6) Push the surfaces tightly together to make sure that the adhesive fully touches the repair area.

7) Make sure that the adhesive cures the minimum time necessary.

8) Apply 3M 436 Tape, G50228 or the equivalent on the repaired area.

SUBTASK 57-21-21-390-011

(3) Repair a damaged seal flange (3.00 in. (76.20 mm) maximum patch length) as follows:

(a) If it is not necessary to replace the flange, do these steps:

1) Do the Seal Repair Procedure (Method B), TASK 57-21-21-350-803 to bond the damaged seal with one of the adhesives in the tables that follow:

a) Table Of Type II Adhesives/Table 802

b) Table Of Type III Adhesives/Table 803.

2) Cut the fabric to make an overlap of 0.50 in. (12.70 mm) on the sides and ends of the split.

3) Push the surfaces tightly together to make sure that the adhesive fully touches the repair area.

4) Make sure that the adhesive cures the minimum time necessary.

5) Apply 3M 436 Tape, G50228 or the equivalent on the repaired area.

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(b) If a part of the flange is missing, do these steps:

1) Trim the seal edge adjacent to the missing part of the flange.

2) Cut a piece of replacement flange that is a correct fit for the missing part.

3) Do the Seal Repair Procedure (Method C), TASK 57-21-21-350-804 to bond the replacement seal patch to the seal with one of the adhesives in the tables that follow:

a) Table Of Type II Adhesives/Table 802

b) Table Of Type III Adhesives/Table 803.

4) Cut the fabric to make an overlap of 0.50 in. (12.70 mm) on the sides and ends of the split.

5) Push the surfaces tightly together to make sure that the adhesive fully touches the repair area.

6) Make sure that the adhesive cures the minimum time necessary.

7) Apply 3M 436 Tape, G50228 or the equivalent on the repaired area.

SUBTASK 57-21-21-390-012

(4) Repair large damage to seal parts as follows:

(a) Find the seal splices in the straight parts of the seal.

(b) Remove the full damaged area.

(c) Replace the damaged area with a piece of replacement seal that has the same dimensions.

(d) Make mitered cuts on the seal surfaces that touch.

(e) Fill them with adhesive from the tables that follow:

1) Table Of Type II Adhesives/Table 802

2) Table Of Type III Adhesives/Table 803.

(f) Do the Seal Repair Procedure (Method B), TASK 57-21-21-350-803 and the Seal Repair Procedure (Method C), TASK 57-21-21-350-804 to bond the seal splices.

(g) Push the surfaces tightly together to make sure that the adhesive fully touches the repair area.

(h) Make sure that the adhesive cures the minimum time necessary.

(i) Apply 3M 436 Tape, G50228 or the equivalent on the repaired area.

END OF TASK

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BULB SEAL

A-A

2567901 S0000614874_V1

Winglet Seals - Repairs
Figure 801/57-21-21-990-812

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TASK 57-21-21-350-802

4. Seal Repair Procedure (Method A)

A. General

(1) This procedure is for repairs that uses only adhesive.

B. Procedure

SUBTASK 57-21-21-300-001

(1) Do the steps that follow to repair the seal with only adhesive:

(a) Apply the adhesive to all of the areas to be bonded.

(b) Put a load on the seal to make sure that the seal fully touches the adhesive.

(c) Let the adhesive cure the minimum time necessary before you put a load on it.

END OF TASK

TASK 57-21-21-350-803

5. Seal Repair Procedure (Method B)

A. General

(1) This procedure is for repairs with an adhesive reinforced with fabric. The fabric is embedded in the adhesive on the seal surface.

B. Consumable Materials

Reference	Description	Specification
G00028	Fabric - Dacron, 70/34 Mesh (Mohawk Dacron Fabrics - D117 Fabric)	
G51094	Fabric - Dacron, 100/34 Solid (Mohawk Dacron Fabrics - D1000 Fabric)	

C. Procedure

SUBTASK 57-21-21-300-002

(1) Do the steps that follow to repair the seal with adhesive and fabric:

(a) Cut the fabric to have the correct fit for the patch area. Use the fabrics that follow:

1) D1000 Dacron Fabric, G51094 for external covering.

2) D117 Dacron Fabric, G00028 for internal reinforcement (optional).

(b) Apply the adhesive to the repair area on the seal.

(c) Push the fabric patch into the wet adhesive and apply more adhesive on top of the patch.

(d) Make the surface smooth of unwanted adhesive and put a load on to make sure that the seal fully touches the adhesive.

(e) Apply pressure to make sure that the parts are fully bonded.

(f) Let the adhesive cure the minimum time necessary before you put a load on it.

END OF TASK

TASK 57-21-21-350-804

6. Seal Repair Procedure (Method C)

A. General

(1) This procedure replaces the damaged seal part with an equivalent piece of replacement seal.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

B. Consumable Materials

Reference	Description	Specification
G00028	Fabric - Dacron, 70/34 Mesh (Mohawk Dacron Fabrics - D117 Fabric)	
G51094	Fabric - Dacron, 100/34 Solid (Mohawk Dacron Fabrics - D1000 Fabric)	

C. Procedure

SUBTASK 57-21-21-300-003

(1) Do the steps that follow to repair the seal with an equivalent piece of replacement seal:

(a) Cut a piece of replacement seal that will have the correct fit for the repair area.

(b) Miter the seal and the replacement piece of seal to the correct fit.

(c) Do one of the procedures that follow:

1) To repair the seal with only adhesive:

a) Apply the adhesive to all of the areas to be bonded.

b) Put a load on the seal to make sure that the seal fully touches the adhesive.

c) Let the adhesive cure the minimum time necessary before you put a load on it.

2) To repair the seal with adhesive and fabric:

a) Cut the fabric to have the correct fit for the patch area. Use one of the fabrics that follow:

<1> D1000 Dacron Fabric, G51094 for external covering.

<2> D117 Dacron Fabric, G00028 for internal reinforcement (optional).

b) Apply the adhesive to the repair area on the seal.

c) Push the fabric patch into the wet adhesive and apply more adhesive on top of the patch.

d) Make the surface smooth of unwanted adhesive and put a load on to make sure that the seal fully touches the adhesive.

e) Apply pressure to make sure that the parts are fully bonded.

f) Let the adhesive cure the minimum time necessary before you put a load on it.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

WINGLET POSITION AND ANTI-COLLISION LIGHTS AND LENS - MAINTENANCE PRACTICES

1. General

A. This procedure gives these tasks:

(1) The removal of the aft position light fairing on the winglet.

(2) The installation of the aft position light fairing on the winglet.

(3) The removal of the forward position and anti-collision light panel (Dual Forward Lens) on the winglet.

(4) The installation of the forward position and anti-collision light panel (Dual Forward Lens) on the winglet.

TASK 57-21-22-000-804

2. Aft Position Light Fairing Removal

(Figure 201)

A. General

(1) This procedure gives the task to remove the canoe fairing for the aft position light under the winglet.

B. References

Reference	Title
33-43-12-960-801	Aft Position Light - Lamp Replacement (P/B 201)
33-43-12-960-802	Aft Position Light - Light Assembly Replacement (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-2209	Pliers - Electrical Connector Part #: TG69 Supplier: 06324
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
500	Left Wing
527	Left Winglet
600	Right Wing
627	Right Winglet

ECCN 9E991 BOEING PROPRIETARY - See title page for details

E. Prepare for the Removal

SUBTASK 57-21-22-865-005

(1) Open these circuit breakers and install safety tags:

CAPT Electrical System Panel, P18-3

Row	Col	Number	Name
A	12	C00113	EXTERIOR LIGHTING POSITION RIGHT
A	13	C00114	EXTERIOR LIGHTING POSITION LEFT

SUBTASK 57-21-22-490-003

(2) Get a ladder, work platform, COM-2480, or maintenance platform, COM-659.

SUBTASK 57-21-22-430-004

(3) 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 the procedure beginning.

(b) Bond the support equipment at an approved airplane bonding location.

(c) Ground the support equipment to the same earth ground as the airplane.

F. Aft Position Light Fairing Removal

SUBTASK 57-21-22-020-004

(1) Remove the lower canoe fairing [63] for the aft position light.

(a) Remove the screws [61] and screws [62] from the lower canoe fairing [63] that is forward of the aft collision light on the lower surface of the winglet.

1) Store the screws [61] and screws [62] in a separate bag for the installation procedure.

a) Tag the screws [61] and screws [62] as the lengths are different for the attachment location.

(b) Use a hard resin phenolic scraper, STD-1064, to remove the sealant around the lower canoe fairing [63].

(c) Remove the lower canoe fairing [63].

SUBTASK 57-21-22-020-009

(2) If it is necessary, remove the aft position light assembly.

(a) Use a pair of connector pliers, COM-2209, to disconnect the electrical connector [64].

(b) Do this task: Aft Position Light - Light Assembly Replacement, TASK 33-43-12-960-802.

(c) Store the four bolts, screw, and washer in a bag for the installation procedure.

SUBTASK 57-21-22-020-010

(3) If it is necessary, remove the aft position light lens (TASK 33-43-12-960-801).

(a) Store the fasteners in a separate bag for the installation procedure.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

WINGLET

AFT POSITION LIGHT
(EXAMPLE)

A

(LOWER CANOE FAIRING REMOVED)

A-A

1 APPLY SEALANT TO SEAM AROUND FAIRING.

M04691 S0006581579_V3

Winglet Aft Position Light Fairing Installation
Figure 201/57-21-22-990-812

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-21-22-400-801

3. Aft Position Light Fairing Installation

(Figure 201)

A. General

(1) This procedure gives the task to install the canoe fairing for the aft position light under the winglet.

B. References

Reference	Title
33-43-12-960-801	Aft Position Light - Lamp Replacement (P/B 201)
33-43-12-960-802	Aft Position Light - Light Assembly Replacement (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-2209	Pliers - Electrical Connector Part #: TG69 Supplier: 06324
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-810	Spatula - Fillet Smoothing, Hardwood or Plastic

D. 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

E. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
63	Lower canoe fairing	33-43-12-02-135	LOM 402, 404, 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-460, 464-999
		33-43-12-02C-135	LOM 402, 404, 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-460, 464-999

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

AMM Item	Description	AIPC Reference	AIPC Effectivity
63 (cont.)		33-43-12-02D-105	LOM 402, 404, 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-460, 464-999
		33-43-12-05-135	LOM 406
		33-43-12-06-135	LOM 406
		33-43-12-07-135	LOM 406
		33-43-12-08-135	LOM 406
		33-43-12-09-135	LOM 406
		33-43-12-10-135	LOM 406
		33-43-12-11-135	LOM 406
		33-43-12-12-135	LOM 406
		33-43-12-13-135	LOM 406
		33-43-12-14-135	LOM 406
		33-43-12-15-135	LOM 406
		33-43-12-20-070	LOM 461-463

F. Location Zones

Zone	Area
500	Left Wing
527	Left Winglet
600	Right Wing
627	Right Winglet

G. Aft Position Light Fairing Installation

SUBTASK 57-21-22-420-008

(1) If it is necessary, install the aft position light lens (TASK 33-43-12-960-801).

SUBTASK 57-21-22-420-009

(2) If it is necessary, install the aft position light assembly (TASK 33-43-12-960-802).

(a) Use the connector pliers, COM-2209, to connect the electrical connector [64].

SUBTASK 57-21-22-390-001

(3) Install the aft position light lower canoe fairing [63].

(a) Remove the tags from the screws [61] and screws [62] for the lower canoe fairing [63].

(b) Put the lower canoe fairing [63] in the position.

(c) Install the screws [61] and screws [62] that hold the lower canoe fairing [63] to the lower surface of the winglet.

1) Tighten the screws [61] and screws [62] to 15 in-lb (1.69 N·m) - 17 in-lb (1.92 N·m).

(d) Apply sealant, A00247, or sealant, A50009, at the gap between the upper fairing and lower canoe fairing [63] as needed.

1) Make the sealant smooth and flush with the adjacent surfaces with a hardwood or plastic fillet smoothing spatula, STD-810.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

H. Put the Airplane Back to Its Usual Condition

SUBTASK 57-21-22-090-003

(1) Remove the ladder, work platform, COM-2480, or maintenance platform, COM-659.

SUBTASK 57-21-22-865-006

(2) Remove the safety tags and close these circuit breakers:

CAPT Electrical System Panel, P18-3

Row	Col	Number	Name
A	12	C00113	EXTERIOR LIGHTING POSITION RIGHT
A	13	C00114	EXTERIOR LIGHTING POSITION LEFT

END OF TASK

LOM ALL; AIRPLANES WITH DUAL FORWARD LENS CONFIGURATION

TASK 57-21-22-000-803

4. Forward Position Light and Anti-Collision Light Lens (Dual Forward Lens) Removal

(Figure 202)

A. General

(1) This procedure gives the task to remove the dual forward lens in the leading edge panel.

B. References

Reference	Title
27-81-00-040-801	Leading Edge Flaps and Slats Deactivation (P/B 201)
57-21-22-200-802	Forward Position Light and Anti-Collision Light Lens (Dual Lens) Inspection (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
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-768	Sealant Removal Tool, Non-Metallic Part #: ST982L-9 Supplier: 81205 Part #: ST982LF-9 Supplier: 81205 Part #: ST982LH-A-1 Supplier: 81205

D. Location Zones

Zone	Area
500	Left Wing

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(Continued)

Zone	Area
534	Left Wing - Dry Bay
600	Right Wing
634	Right Wing - Dry Bay

E. Prepare for the Procedure

SUBTASK 57-21-22-865-003

> **WARNING** DO NOT TOUCH THE ANTI-COLLISION LIGHT FOR 10 MINUTES AFTER YOU REMOVE ELECTRICAL POWER. AN ELECTRICAL SHOCK CAN CAUSE INJURIES TO PERSONNEL OR DAMAGE TO EQUIPMENT.

(1) Open these circuit breakers and install safety tags:

CAPT Electrical System Panel, P18-3

Row	Col	Number	Name
A	12	C00113	EXTERIOR LIGHTING POSITION RIGHT
A	13	C00114	EXTERIOR LIGHTING POSITION LEFT
B	13	C00115	EXT LIGHTING ANTI COLLISION WHITE

SUBTASK 57-21-22-040-002

(2) Do this task: Leading Edge Flaps and Slats Deactivation, TASK 27-81-00-040-801.

SUBTASK 57-21-22-490-001

(3) Get a ladder, work platform, COM-2480 or maintenance platform, COM-659.

SUBTASK 57-21-22-430-002

(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 (15.24 meter) 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.

F. Lens Assembly Removal

SUBTASK 57-21-22-020-005

(1) Remove the forward position light lens assembly [85] from the outboard leading edge skin.

(a) Remove 14 screws [81] from the lens retainer.

(b) Remove the screw [83] and nut [84] to disconnect the electrical bonding jumper [87] from the lens assembly.

(c) Remove old sealant from the faying surfaces of the skin with a sealant removal tool, SPL-768.

NOTE: The fay seal in no longer used at this location.

SUBTASK 57-21-22-020-006

(2) Remove the anti-collision light lens assembly [88] from the outboard leading edge skin.

(a) Remove 12 screws [82] from the lens retainer.

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(b) Remove the screw [83] and nut [84] to disconnect the electrical bonding jumper [87] from the lens assembly.

(c) Remove old sealant from the faying surfaces of the skin with a sealant removal tool, SPL-768.

NOTE: The fay seal in no longer used at this location.

SUBTASK 57-21-22-212-003

(3) Inspect the lens for damage.

(a) Do this task: Forward Position Light and Anti-Collision Light Lens (Dual Lens) Inspection, TASK 57-21-22-200-802.

——— END OF TASK ———

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Forward Dual Lens Installation
Figure 202/57-21-22-990-807

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-21-22-400-804

5. **Forward Position Light and Anti-Collision Light Lens (Dual Forward Lens) Installation**
(Figure 202)

A. **General**

(1) This procedure gives the task to install the dual forward lens in the leading edge panel.

B. **References**

Reference	Title
20-30-11-910-802	Sealant Cure Time (P/B 201)
27-81-00-440-801	Leading Edge Flaps and Slats - Activation (P/B 201)
33-43-10-710-801	Position Lights - Operational Test (P/B 201)
33-44-00-710-801	Anti-Collision Lights - Operational Test (P/B 501)
SOPM 20-50-11	Standard Overhaul Practices Manual
SOPM 20-50-19	General Sealing
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-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
A00160	Sealant - Firewall - Hydraulic Fluid Resistant	BMS5-63
A50231	Sealant - Pressure And Environmental - Chromate Type	BMS5-95 Class B
A50343	Sealant - PPG Aerospace PR-1772 Class B Low Weight Fuselage Sealant	BMS5-142 Type II Class B

ECCN 9E991 BOEING PROPRIETARY - See title page for details

LOM ALL; AIRPLANES WITH DUAL FORWARD LENS CONFIGURATION (Continued)

(Continued)

Reference	Description	Specification
C00528	Compound - Corrosion Preventive, Petroleum Hot Application (Soft Film)	MIL-C-11796 Class III
D50119	Lubricant - Fluorocarbon PTFE Release Agent - Miller-Stephenson MS-122DF	
D50326	Lubricant - PTFE Release Agent - Miller-Stephenson MS-122XD (Replaces MS-122DF and MS-122V Lubricants)	
G00291	Tape - Aluminum Foil, 3M 425	AMS-T-23397 / L-T-80

E. Location Zones

Zone	Area
500	Left Wing
527	Left Winglet
600	Right Wing
627	Right Winglet

F. Lens Assembly Installation

SUBTASK 57-21-22-420-005

(1) Attach the forward position light lens assembly [85] to the leading edge.

(a) Attach the bonding jumper [87] to the lens assembly [85].

1) Position the jumper lug and install the screw [83] and nut [84].

(b) Measure the electrical resistance between the lens assembly and light assembly (SWPM 20-20-00).

1) Use theintrinsically safe approved bonding meter, COM-1550.

2) Make sure that the resistance is 0.0025 ohms (2.5 milliohm) or less.

(c) Install the lens assembly [85].

NOTE: Fay seal is no longer used at this location.

(d) Install the screws [81] with compound, C00528, and tighten to 10.00 in-lb (1.13 N·m) - 18.00 in-lb (2.03 N·m).

(e) Apply an aerodynamic seal with sealant, A00160, sealant, A50231, or PR-1772 Class B Sealant, A50343, to the external gap around the lens (SOPM 20-50-19, SOPM 20-50-11).

1) If you must send the airplane before the sealant is fully cured, install 3M 425 Aluminum Foil Tape, G00291, on the top of the sealant.

a) Before each flight visually examine the 3M 425 Aluminum Foil Tape, G00291.

b) Remove the 3M 425 Aluminum Foil Tape, G00291, when the sealant is fully cured (TASK 20-30-11-910-802).

SUBTASK 57-21-22-420-006

(2) Attach the anti-collision light lens assembly [88] to the leading edge.

(a) Attach the bonding jumper [87] to the lens assembly [88].

1) Position the jumper lug and install the screw [83] and nut [84].

(b) Measure the electrical resistance between the lens assembly and light assembly (SWPM 20-20-00).

ECCN 9E991 BOEING PROPRIETARY - See title page for details

1) Use the intrinsically safe approved bonding meter, COM-1550.
2) Make sure that the resistance is 0.0025 ohms (2.5 milliohm) or less.

(c) Apply MS-122DF lubricant, D50119, or MS-122XD lubricant, D50326, to the faying surfaces of the anti-collision light lens assembly [88], except at electrical bonding locations.
1) Let the anti-collision light lens assembly [88] to dry.

(d) Install the anti-collision light lens assembly [88].

(e) Install the screws [82] with compound, C00528, and tighten to 10.00 in-lb (1.13 N·m) - 18.00 in-lb (2.03 N·m).

(f) Apply an aerodynamic seal with sealant, A00160, sealant, A50231, or PR-1772 Class B Sealant, A50343, to the external gap around the lens (SOPM 20-50-19, SOPM 20-50-11).
1) If you must send the airplane before the sealant is fully cured, install 3M 425 Aluminum Foil Tape, G00291, on the top of the sealant.
a) Before each flight visually examine the 3M 425 Aluminum Foil Tape, G00291.
b) Remove the 3M 425 Aluminum Foil Tape, G00291, when the sealant is fully cured (TASK 20-30-11-910-802).

SUBTASK 57-21-22-865-004

(3) Remove the safety tags and close these circuit breakers:

CAPT Electrical System Panel, P18-3

Row	Col	Number	Name
A	12	C00113	EXTERIOR LIGHTING POSITION RIGHT
A	13	C00114	EXTERIOR LIGHTING POSITION LEFT
B	13	C00115	EXT LIGHTING ANTI COLLISION WHITE

SUBTASK 57-21-22-710-003

(4) Do this task: Position Lights - Operational Test, TASK 33-43-10-710-801.

SUBTASK 57-21-22-710-004

(5) Do this task: Anti-Collision Lights - Operational Test, TASK 33-44-00-710-801.

G. Put the Airplane Back to Its Usual Condition

SUBTASK 57-21-22-090-002

(1) Remove the ladder, work platform, COM-2480, or maintenance platform, COM-659.

SUBTASK 57-21-22-440-004

(2) Do this task: Leading Edge Flaps and Slats - Activation, TASK 27-81-00-440-801.

——— END OF TASK ———

TASK 57-21-22-000-806

6. Forward Position Light and Anti-Collision Light Panel (Dual Forward Lens) Removal
(Figure 203)

A. General

(1) This task has the steps to remove the leading edge panel from the winglet.

(2) The removal of the leading edge panel gives access to the anti-collision light attentuator in the winglet.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

LOM ALL; AIRPLANES WITH DUAL FORWARD LENS CONFIGURATION (Continued)

B. References

Reference	Title
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
SPL-768	Sealant Removal Tool, Non-Metallic Part #: ST982L-9 Supplier: 81205 Part #: ST982LF-9 Supplier: 81205 Part #: ST982LH-A-1 Supplier: 81205

D. Location Zones

Zone	Area
500	Left Wing
527	Left Winglet
600	Right Wing
627	Right Winglet

E. Prepare for the Removal

SUBTASK 57-21-22-865-007

WARNING DO NOT TOUCH THE ANTI-COLLISION LIGHT FOR 10 MINUTES AFTER YOU REMOVE ELECTRICAL POWER. AN ELECTRICAL SHOCK CAN CAUSE INJURIES TO PERSONNEL OR DAMAGE TO EQUIPMENT.

(1) Open these circuit breakers and install safety tags:

CAPT Electrical System Panel, P18-3

Row	Col	Number	Name
A	12	C00113	EXTERIOR LIGHTING POSITION RIGHT
A	13	C00114	EXTERIOR LIGHTING POSITION LEFT
B	13	C00115	EXT LIGHTING ANTI COLLISION WHITE

SUBTASK 57-21-22-040-008

(2) Do this task: Leading Edge Flaps and Slats Deactivation, TASK 27-81-00-040-801.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

LOM ALL; AIRPLANES WITH DUAL FORWARD LENS CONFIGURATION (Continued)

SUBTASK 57-21-22-490-004

(3) Get a ladder, work platform, COM-2480, or maintenance platform, COM-659.

SUBTASK 57-21-22-430-005

(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.

(b) Bond the support equipment at an approved airplane bonding location.

(c) Ground the support equipment to the same earth ground as the airplane.

F. Forward Position Light and Anti-Collision Light Panel (Dual Forward Lens) Removal

SUBTASK 57-21-22-020-008

(1) Remove the leading edge panel [91] for the forward position and anti-collision lights (Figure 203).

(a) Remove the bolts [92], bolts [93], and bolts [94] on the leading edge panel.

1) Do not remove the screws on the inboard side of the leading edge skin.

NOTE: The screws hold a bulb seal to the leading edge skin.

(b) Remove the leading edge panel [91].

NOTE: The panel that contains the light lens and lights.

(c) Tag all the bolts [92], bolts [93], and bolts [94].

1) Keep the bolts [92], bolts [93], and bolts [94] for the installation procedure.

SUBTASK 57-21-22-160-006

(2) Remove all sealant from the gap between the leading edge panel [91] and outboard leading edge panel and the upper skin panel and lower skin panel with a sealant removal tool, SPL-768.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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Forward Position Light and Anti-Collision Light Panel Installation
Figure 203/57-21-22-990-809

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TASK 57-21-22-400-806

7. Forward Position Light and Anti-Collision Light Panel (Dual Forward Lens) Installation

(Figure 203)

A. General

(1) This task has the steps to install the leading edge panel on the winglet.

(2) The removal of the leading edge panel gave access to the anti-collision light attentuator in the winglet.

B. References

Reference	Title
20-30-11-910-802	Sealant Cure Time (P/B 201)
27-81-00-440-801	Leading Edge Flaps and Slats - Activation (P/B 201)
51-21-72-370-801	BMS10-79 Primer - Application (P/B 701)
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-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-810	Spatula - Fillet Smoothing, Hardwood or Plastic

D. 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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

LOM ALL; AIRPLANES WITH DUAL FORWARD LENS CONFIGURATION (Continued)

(Continued)

Reference	Description	Specification
C00175	Primer - Urethane Compatible, Corrosion Resistant	BMS10-79 Type III
C00528	Compound - Corrosion Preventive, Petroleum Hot Application (Soft Film)	MIL-C-11796 Class III
G00291	Tape - Aluminum Foil, 3M 425	AMS-T-23397 / L-T-80

E. Location Zones

Zone	Area
500	Left Wing
527	Left Winglet
600	Right Wing
627	Right Winglet

F. Forward Position Light and Anti-Collision Light Panel (Dual Forward Lens) Installation

SUBTASK 57-21-22-420-007

(1) Install the forward position light and anti-collision light panel [91].

(a) Install the panel assembly for the forward position light and anti-collision light in the leading edge skin.

(b) Apply primer, C00175, to the holes of the bolts [92], bolts [93], and bolts [94] (TASK 51-21-72-370-801).

1) Make sure that there is no primer in the countersinks.

NOTE: A small quantity of unwanted primer in the countersinks is permitted for the bolts [92] and bolts [94].

(c) Apply compound, C00528, to all areas of the holes of the bolts [92], bolts [93], and bolts [94].

(d) Install the bolts [92], bolts [93], and bolts [94].

1) Tighten the bolts [92], and bolts [93] to 18 in-lb (2.0 N·m) - 25 in-lb (2.8 N·m).

2) Tighten the bolts [94] to 13 in-lb (1.5 N·m) - 18 in-lb (2.0 N·m).

SUBTASK 57-21-22-765-003

(2) Measure the electrical bonding resistance between the leading edge skin and leading edge ribs (SWPM 20-20-00).

(a) Use an intrinsically safe approved bonding meter, COM-1550.

(b) Make sure that the electrical resistance is 0.0025 ohms (2.5 milliohm) or less.

SUBTASK 57-21-22-390-003

(3) Apply sealant, A00247, or sealant, A50009, at the gap between the leading edge panel [91] and outboard leading edge panel and the upper skin panel and lower skin panel.

(a) Make the sealant smooth and flush with the adjacent surfaces with a hardwood or plastic fillet smoothing spatula, STD-810.

1) If it is necessary to send the airplane before the sealant is fully cured, do these steps:

a) Allow sealant, A00247, or sealant, A50009, to cure as long as possible before applying 3M 425 Aluminum Foil Tape, G00291.

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b) Install 3M 425 Aluminum Foil Tape, G00291, on the sealant.

c) Before each flight, visually examine the 3M 425 Aluminum Foil Tape, G00291.

d) Remove 3M 425 Aluminum Foil Tape, G00291, when the sealant is fully cured (TASK 20-30-11-910-802).

e) Carefully inspect sealant, A00247, or sealant, A50009, to make sure that the sealant is adhered to the edges and that it is has cured properly.

f) If it is necessary, replace sealant.

G. Put the Airplane Back to Its Usual Condition

SUBTASK 57-21-22-090-004

(1) Remove the ladder, work platform, COM-2480, or maintenance platform, COM-659.

SUBTASK 57-21-22-440-008

(2) Do this task: Leading Edge Flaps and Slats - Activation, TASK 27-81-00-440-801.

SUBTASK 57-21-22-865-008

(3) Remove the safety tags and close these circuit breakers:

CAPT Electrical System Panel, P18-3

Row	Col	Number	Name
A	12	C00113	EXTERIOR LIGHTING POSITION RIGHT
A	13	C00114	EXTERIOR LIGHTING POSITION LEFT
B	13	C00115	EXT LIGHTING ANTI COLLISION WHITE

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

WINGLET FORWARD ANTI-COLLISION LIGHT AND POSITION LIGHT LENS - INSPECTION/CHECK

1. General

A. This procedure gives the task to inspect the light lens.

TASK 57-21-22-200-802

2. Forward Position Light and Anti-Collision Light Lens (Dual Lens) Inspection

(Figure 601)

NOTE: This procedure is a scheduled maintenance task.

A. General

(1) This procedure gives the task to do a visual inspection of the exterior surface of the dual lens on the left and right winglet.

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)
57-21-22-000-803	Forward Position Light and Anti-Collision Light Lens (Dual Forward Lens) Removal (P/B 201)
57-21-22-400-804	Forward Position Light and Anti-Collision Light Lens (Dual Forward Lens) 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
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-1097	Caliper - Vernier, 0-6 inch, Readable to 1/1000 inch

D. Location Zones

Zone	Area
500	Left Wing
527	Left Winglet
600	Right Wing
627	Right Winglet

ECCN 9E991 BOEING PROPRIETARY - See title page for details

E. Prepare for the Inspection

SUBTASK 57-21-22-860-005

> **WARNING** DO NOT TOUCH THE ANTI-COLLISION LIGHT FOR 10 MINUTES AFTER YOU REMOVE ELECTRICAL POWER. AN ELECTRICAL SHOCK CAN CAUSE INJURIES TO PERSONNEL OR DAMAGE TO EQUIPMENT.

(1) Open these circuit breakers and install safety tags:

CAPT Electrical System Panel, P18-3

Row	Col	Number	Name
A	12	C00113	EXTERIOR LIGHTING POSITION RIGHT
A	13	C00114	EXTERIOR LIGHTING POSITION LEFT
B	13	C00115	EXT LIGHTING ANTI COLLISION WHITE

SUBTASK 57-21-22-040-009

(2) If it is necessary, then do this task: Trailing Edge Flap System Deactivation, TASK 27-51-00-040-801.

SUBTASK 57-21-22-040-010

(3) Do this task: Leading Edge Flaps and Slats Deactivation, TASK 27-81-00-040-801.

SUBTASK 57-21-22-480-001

(4) Get a ladder, work platform, COM-2480, or maintenance platform, COM-659.

SUBTASK 57-21-22-420-010

(5) Do these steps to prepare the metal support equipment such as work platforms, work or maintenance stands, and ladders:

NOTE: These steps apply to all the metal support equipment within a 50 ft (15.24 m) radius of an open fuel tank.

(a) All the 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.

F. Forward Position Light and Anti-Collision Light Lens (Dual Lens) Inspection

SUBTASK 57-21-22-212-002

(1) Do a visual inspection of the exterior surface of the lens on the left and right winglet for these conditions:

(a) Disbonding

1) No disbonding between the lens and lens retainer are allowed.

(b) Cracks

1) The lens must not have any cracks.

(c) Chipping

1) Use a vernier caliper (0 - 6 inch, readable to 1/1000 inch), STD-1097, to measure and determine the length of chipping.

2) There must be no chipping in the lens area from 0 in. (0 cm) - 4 in. (10 cm) outboard of the inboard trim line.

3) The following is an allowable condition for a lens (Figure 601).

a) Chipping is allowed in a limited area, 4 in. (10 cm) outboard of the inboard trim line.

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b) For the area more than 4 in. (10 cm) outboard, the chip length cannot exceed 0.25 in. (0.64 cm) from the lens retainer inner trim line (measured normal to the trim line edge).

(d) If the other lens has not been inspected, repeat this task for the other lens.

(e) If both lenses have been inspected, this task is complete.

SUBTASK 57-21-22-960-002

(2) If any of these conditions are seen, replace the lens.

(a) Do this task: Forward Position Light and Anti-Collision Light Lens (Dual Forward Lens) Removal, TASK 57-21-22-000-803.

(b) Do this task: Forward Position Light and Anti-Collision Light Lens (Dual Forward Lens) Installation, TASK 57-21-22-400-804.

G. Put the Airplane Back to Its Usual Condition

SUBTASK 57-21-22-860-002

(1) Remove the safety tag and close the applicable circuit breaker:

CAPT Electrical System Panel, P18-3

Row	Col	Number	Name
A	12	C00113	EXTERIOR LIGHTING POSITION RIGHT
A	13	C00114	EXTERIOR LIGHTING POSITION LEFT
B	13	C00115	EXT LIGHTING ANTI COLLISION WHITE

SUBTASK 57-21-22-080-001

(2) Remove the ladder, work platform, COM-2480, or maintenance platform, COM-659.

SUBTASK 57-21-22-440-010

(3) If the trailing edge flaps were deactivated, then do this task: Trailing Edge Flap System Reactivation, TASK 27-51-00-440-801.

SUBTASK 57-21-22-440-009

(4) Do this task: Leading Edge Flaps and Slats - Activation, TASK 27-81-00-440-801.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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Forward Position Light Lens Allowable Chip Area
Figure 601/57-21-22-990-814 (Sheet 1 of 2)

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FORWARD POSITION LIGHT

B

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Forward Position Light Lens Allowable Chip Area
Figure 601/57-21-22-990-814 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

WINGLET LEADING EDGE LIGHT LENS - REPAIR

1. **General**

   A. There is one task to polish a lens in this procedure.

TASK 57-21-22-910-801

2. **Polish the Leading Edge Light Lens**

   (Figure 801)

   A. General

   (1) This task gives the instructions to polish the exterior surface of the lens on the left or right winglet.

   B. Consumable Materials

Reference	Description	Specification
B50025	Compound - Polishing, Final Finish - NuShine IIS	
G50138	Cloth - Soft Cotton	
G50140	Gloves - Protective, Latex or Nitrile	
G50141	Towel - Paper, High Quality, Single Ply, White or Natural Colors	

   C. Location Zones

Zone	Area
500	Left Wing
527	Left Winglet
600	Right Wing
627	Right Winglet

   D. Leading Edge Light Lens Polish

SUBTASK 57-21-22-910-001

(1) Apply small amounts of NuShine IIS compound, B50025, along the leading edge of the lens.

(a) Use a pair of protective gloves, G50140.

(b) Do only half of the length of the lens at a time, or the polish will become dry too soon.

> **CAUTION**
> DO NOT APPLY PRESSURE TO THE SURFACE OF THE LENS. THIS CAN CAUSE DAMAGE TO THE LENS.

(c) Polish with high quality paper towel, G50141, with light pressure only in a linear motion along the leading edge.

NOTE: Use only plain white or natural color paper towels.

NOTE: There will be a transition line, approximately 0.25 in. (6.35 mm) wide between the hazed surface and the undamaged clear surface. Do not try to polish this portion of the lens, a hard coat material remains on the lens and can not be polish out to a clear state.

SUBTASK 57-21-22-910-002

(2) Repeat the polish.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(a) After the polish is completed, use clean soft cotton cloth, G50138, in order to achieve a final luster.

——— END OF TASK ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

M48223 S0006581585_V4

Winglet Leading Edge Light Lens Polish
Figure 801/57-21-22-990-806

ECCN 9E991 BOEING PROPRIETARY - See title page for details

WING DRY BAY TANK ACCESS DOORS - REMOVAL/INSTALLATION

1. General

A. This task gives the procedure to remove and install the access doors for wing, dry bay tanks.

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 57-21-23-000-801

2. Dry Bay Access Doors Removal

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)
24-22-00-860-812	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

E. Access Doors Removal

SUBTASK 57-21-23-760-001

(1) Make sure the airplane is correctly grounded to an approved and identified ground.

(a) Do this task: Static Grounding, TASK 20-40-11-910-801.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 57-21-23-040-001

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

SUBTASK 57-21-23-040-002

(3) Do this task: Leading Edge Flaps and Slats Deactivation, TASK 27-81-00-040-801.

SUBTASK 57-21-23-490-001

(4) Make sure 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 57-21-23-490-002

(5) Get a ladder, work platform, COM-2480, or maintenance platform, COM-659.

SUBTASK 57-21-23-765-001

(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 57-21-23-862-001

(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 24-22-00-860-812.

(c) Do not supply electrical power again until you have completed this procedure.

LOM 461-463; AIRPLANES WITH ONE DRY BAY ACCESS DOOR TYPE

SUBTASK 57-21-23-020-008

(8) Do these steps to remove the access doors [1] (Figure 401):

(a) Remove the bolts [2] from the access doors [1].

(b) Remove the access doors [1].

LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-460, 464-999; AIRPLANES WITH TWO DRY BAY ACCESS DOOR TYPE

SUBTASK 57-21-23-020-009

(9) Do these steps to remove the access door [1] (Figure 402):

(a) Remove the bolts [2] from the access door [1].

(b) Remove the access door [1].

SUBTASK 57-21-23-020-010

(10) Do these steps to remove access door [5] (Figure 402):

(a) Remove the bolts [8] from the access door [5].

(b) Remove the gasket [6] and clamp ring [7] from the access door [5].

(c) Remove the access door [5].

ECCN 9E991 BOEING PROPRIETARY - See title page for details

LOM ALL; AIRPLANES WITH WINGLETS AND WITH ONE DRY BAY ACCESS DOOR TYPE

SUBTASK 57-21-23-020-011

(11) Do these steps to remove access doors [3] (Figure 403):

(a) Remove the bolts [4] from the access doors [3].

(b) Remove the access doors [3].

LOM ALL; AIRPLANES WITH WINGLETS AND WITH TWO DRY BAY ACCESS DOOR TYPE

SUBTASK 57-21-23-020-012

(12) Do these steps to remove access door [1] (Figure 404):

(a) Remove the bolts [2] from the access door [1].

(b) Remove the access door [1].

SUBTASK 57-21-23-020-013

(13) Do these steps to remove the access door [5] (Figure 404):

(a) Remove the bolts [8] from the access door [5].

(b) Remove the gasket [6] and clamp ring [7] from the access door [5].

(c) Remove the access door [5]

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

3056323 S0000820333_V1

Dry Bay Access Doors Installation
Figure 401/57-21-23-990-812 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

ACCESS DOOR (EXAMPLE)

B

BOLT SEQUENCE INSTALLATION (EXAMPLE)

C

3056324 S0000820334_V1

Dry Bay Access Doors Installation
Figure 401/57-21-23-990-812 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

3056325 S0000820335_V1

Dry Bay Access Doors Installation
Figure 402/57-21-23-990-809 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

3056345 S0000820336_V1

Dry Bay Access Doors Installation
Figure 402/57-21-23-990-809 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

LEFT WING
(RIGHT WING IS OPPOSITE)

ACCESS DOORS
A

463693 S0000142207_V4

Wing Dry Bay Access Doors Installation
Figure 403/57-21-23-990-810 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

ACCESS DOOR
(EXAMPLE)

B

3056346 S0000820338_V1

Wing Dry Bay Access Doors Installation
Figure 403/57-21-23-990-810 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

LEFT WING
(RIGHT WING IS OPPOSITE)

ACCESS DOORS
A

2070441 S0000431860_V4

Dry Bay Access Doors Installation
Figure 404/57-21-23-990-811 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

3056347 S0000820342_V1

Dry Bay Access Doors Installation
Figure 404/57-21-23-990-811 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-21-23-400-801

3. Dry Bay Access Doors Installation

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
A50001	compound - corrosion inhibiting - ZC-027L	ZC-027L
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
C00528	Compound - Corrosion Preventive, Petroleum Hot Application (Soft Film)	MIL-C-11796 Class III
D50050	Grease - Multipurpose, Helicopter Oscillating Bearing Grease with Calcium Soap Thickener - Aeroshell 14	MIL-G-25537
G00834	Cloth - Lint-free Cotton	
G50237	Compound - Corrosion Inhibiting, Non-drying - Cor-Ban 27L	BMS3-38

ECCN 9E991 BOEING PROPRIETARY - See title page for details

E. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Access door	57-21-23-02-050	LOM 406, 461-463
		57-21-23-02-055	LOM 406, 461-463
		57-21-23-03-010	LOM 461-463
		57-21-23-03-015	LOM 461-463
		57-21-23-03-020	LOM 461-463
		57-21-23-03-025	LOM 461-463
		57-21-23-03-160	LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-460, 464-999
		57-21-23-03-165	LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-460, 464-999
3	Access door	Not Specified	
5	Access door	57-21-23-02-025	LOM 406, 461-463
		57-21-23-02-030	LOM 406, 461-463
		57-21-23-03-125	LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-460, 464-999
		57-21-23-03-130	LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-460, 464-999

F. Location Zones

Zone	Area
500	Left Wing
534	Left Wing - Dry Bay
600	Right Wing
634	Right Wing - Dry Bay

G. Access Doors Installation

SUBTASK 57-21-23-160-001

(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 57-21-23-942-001

(2) Do a check of the tanks to make sure that you removed all unwanted materials, tools, and equipment.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

LOM 461-463; AIRPLANES WITH ONE DRY BAY ACCESS DOOR TYPE

SUBTASK 57-21-23-420-005

(3) Do these steps to install the access doors [1] (Figure 401):

(a) Put the access door [1] in its position.

(b) Apply a thin layer of compound, C00528, to all areas of the lower wing skin fastener holes.

1) Apply a thin layer to the countersink.

2) Apply a thin layer to the counterbore.

(c) Immediately install the bolts [2] after you apply the compound, C00528.

LOM 461-463; AIRPLANES WITH ACCESS DOORS INSTALLED USING BOLT P/N NAS8703-3

1) Tighten the bolts [2] to 10 in-lb (1.1 N·m) - 20 in-lb (2.3 N·m) (View C, Figure 401).

LOM 461-463; AIRPLANES WITH ACCESS DOORS INSTALLED USING BOLT P/N BACB30ZE3

2) Tighten the bolts [2] to 28 in-lb (3.2 N·m) - 32 in-lb (3.6 N·m) (View C, Figure 401).

LOM 461-463; AIRPLANES WITH ONE DRY BAY ACCESS DOOR TYPE

(d) Measure the electrical resistance of the door to the adjacent wing skin with intrinsically safe approved bonding meter, COM-1550.

1) The maximum resistance must not be more than 100 milliohms (0.1 ohm).

2) If it is necessary, remove the paint from the lower skin countersinks to meet the electrical resistance measurement.

LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-460, 464-999; AIRPLANES WITH TWO DRY BAY ACCESS DOOR TYPE

SUBTASK 57-21-23-420-008

(4) Do these steps to install the access door [1] (Figure 402):

(a) Put the access door [1] in position.

(b) Apply a thin layer of compound, C00528, to all areas of the lower wing skin fastener holes.

1) Apply a thin layer to the countersink.

2) Apply a thin layer to the counterbore.

(c) Immediately install the bolts [2] after you apply the compound, C00528.

LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-460, 464-999; AIRPLANES WITH ACCESS DOORS INSTALLED USING BOLT P/N NAS8703-3

1) Torque the bolts [2] to 10 in-lb (1.1 N·m) - 20 in-lb (2.3 N·m) (View D, Figure 402).

LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-460, 464-999; AIRPLANES WITH ACCESS DOORS INSTALLED USING BOLT P/N BACB30ZE3

2) Torque the bolt [2] to 28 in-lb (3.2 N·m) - 32 in-lb (3.6 N·m) (View D, Figure 402).

LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-460, 464-999; AIRPLANES WITH TWO DRY BAY ACCESS DOOR TYPE

(d) Measure the electrical resistance of the door to the adjacent wing skin with intrinsically safe approved bonding meter, COM-1550.

1) The maximum resistance must not be more than 100 milliohms (0.1 ohm).

2) If it is necessary, remove the paint from the lower skin countersinks to meet the electrical resistance measurement.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-460, 464-999; AIRPLANES WITH TWO DRY BAY ACCESS DOOR TYPE (Continued)

SUBTASK 57-21-23-420-006

(5) Do these steps to install the access door [5] (Figure 402):

(a) Put the access door [5] in position.

LOM 402, 404, 406, 407, 411, 412, 415, 416, 420

(b) Apply a layer that is 0.010 in. (0.254 mm) - 0.015 in. (0.381 mm) thick of Aeroshell 14 helicopter grease, D50050, to the mating surface of the clamp ring.

LOM 422-434, 437-447, 450-460, 464-999

(c) Apply a layer that is 0.010 in. (0.254 mm) - 0.015 in. (0.381 mm) thick of Cor-Ban 27L Compound, G50237, to the mating surface of the clamp ring.

LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-460, 464-999; AIRPLANES WITH TWO DRY BAY ACCESS DOOR TYPE

(d) Install the gasket [6] between the clamp ring [7] and the bottom surface of the wing skin.

(e) Apply a thin layer of compound, C00528, to all areas of the clamp ring fastener holes.

1) Apply a thin layer to the countersink.

2) Apply a thin layer to the counterbore.

(f) Immediately install the bolts [8] after you apply the compound, C00528.

1) Torque the bolts [8] to 10 in-lb (1.1 N·m) - 20 in-lb (2.3 N·m) (View D, Figure 402).

(g) Measure the electrical resistance of the door to the adjacent wing skin with intrinsically safe approved bonding meter, COM-1550.

1) The maximum resistance must not be more than 100 milliohms (0.1 ohm).

2) If it is necessary, remove the paint from the lower skin countersinks to meet the electrical resistance measurement.

LOM ALL; AIRPLANES WITH WINGLETS AND WITH ONE DRY BAY ACCESS DOOR TYPE

SUBTASK 57-21-23-420-009

(6) Do these steps to install the access doors [3] (Figure 403):

(a) Apply a thin layer of corrosion inhibitiing compound - ZC-027L, A50001, to the mating surfaces of the access door [3] and the lower wing skin.

(b) Put the access door [3] in position.

(c) Apply a thin layer of corrosion inhibitiing compound - ZC-027L, A50001, to these areas of each bolt [4]:

1) Thread

2) Shank

3) Under the head.

(d) Immediately install the bolts [4] after you apply the corrosion inhibitiing compound - ZC-027L, A50001.

1) Torque the bolts [4] to 50 in-lb (5.6 N·m) - 75 in-lb (8.5 N·m).

(e) Measure the electrical resistance of the door to the adjacent wing skin with intrinsically safe approved bonding meter, COM-1550.

1) The maximum resistance must not be more than 10 milliohms (0.01 ohm).

ECCN 9E991 BOEING PROPRIETARY - See title page for details

2) If it is necessary, remove the paint from the lower skin countersinks to meet the electrical resistance measurement.

LOM ALL; AIRPLANES WITH WINGLETS AND WITH TWO DRY BAY ACCESS DOOR TYPE

SUBTASK 57-21-23-420-007

(7) Do these steps to install the access door [1] (Figure 404):

(a) Apply a thin layer of corrosion inhibitiing compound - ZC-027L, A50001, to the mating surfaces of the access door [1] and the lower wing skin.

(b) Put the access door [1] in position.

(c) Apply a thin layer of corrosion inhibitiing compound - ZC-027L, A50001, to these areas of each bolts [2]:

1) Thread

2) Shank

3) Under the head.

(d) Immediately install the bolts [2] after you apply the corrosion inhibitiing compound - ZC-027L, A50001.

LOM ALL; AIRPLANES WITH ACCESS DOORS INSTALLED USING BOLT P/N NAS8703-3

1) Tighten the bolts [2] to 10 in-lb (1.1 N·m) - 20 in-lb (2.3 N·m) (View D, Figure 404).

LOM ALL; AIRPLANES WITH ACCESS DOORS INSTALLED USING BOLT P/N BACB30ZE3

2) Tighten the bolts [2] to 28 in-lb (3.2 N·m) - 32 in-lb (3.6 N·m) (View D, Figure 404).

LOM ALL; AIRPLANES WITH WINGLETS AND WITH TWO DRY BAY ACCESS DOOR TYPE

(e) Measure the electrical resistance of the door to the adjacent wing skin with intrinsically safe approved bonding meter, COM-1550.

1) The maximum resistance must not be more than 10 milliohms (0.01 ohm).

2) If it is necessary, remove the paint from the lower skin countersinks to meet the electrical resistance measurement.

SUBTASK 57-21-23-420-010

(8) Do these steps to install the access door [5] (Figure 404):

(a) Put the access door [5] in position.

LOM 402, 404, 406, 407, 411, 412, 415, 416, 420

(b) Apply a layer that is 0.010 in. (0.254 mm) - 0.015 in. (0.381 mm) thick of Aeroshell 14 helicopter grease, D50050, to the mating surface of the clamp ring.

LOM 422-434, 437-447, 450-999

(c) Apply a layer that is 0.010 in. (0.254 mm) - 0.015 in. (0.381 mm) thick of Cor-Ban 27L Compound, G50237, to the mating surface of the clamp ring.

LOM ALL; AIRPLANES WITH WINGLETS AND WITH TWO DRY BAY ACCESS DOOR TYPE

(d) Install the gasket [6] between the clamp ring [7] and the bottom surface of the wing skin.

(e) Apply a thin layer of compound, C00528, to all areas of the clamp ring fastener holes.

1) Apply a thin layer to the countersink.

2) Apply a thin layer to the counterbore.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(f) Immediately install the bolts [8] after you apply the compound, C00528.

1) Tighten the bolts [8] to 10 in-lb (1.1 N·m) - 20 in-lb (2.3 N·m).

(g) Measure the electrical resistance of the door to the adjacent wing skin with intrinsically safe approved bonding meter, COM-1550.

1) The maximum resistance must not be more than 100 milliohms (0.1 ohm).

2) If it is necessary, remove the paint from the lower skin countersinks to meet the electrical resistance measurement.

LOM ALL

SUBTASK 57-21-23-090-001

(9) Remove the ladder, work platform, COM-2480, or maintenance platform, COM-659.

SUBTASK 57-21-23-440-001

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

SUBTASK 57-21-23-440-002

(11) Do this task: Leading Edge Flaps and Slats - Activation, TASK 27-81-00-440-801.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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 57-21-23-790-801

2. Vapor Seal Leak Check

(Figure 601)

A. General

LOM 461-463

(1) Regulatory requirements refer to the Supplemental Type Certificate (STC) ST00830SE.

NOTE: Supplemental Type Certificate (STC) ST00830SE changes some wing structures for retrofit installation of the Aviation Partners Boeing (APB) Blended Winglets.

LOM ALL

(2) 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.

(3) The check requires pressurization of the dry bay tank for 10 minutes with a minimum pressure loss.

(4) 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.

(5) The pressure test equipment must be able to supply positive pressure, 2.5 ±0.6 psig (17.2 ±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/H_2O (2.6 psig) and -20 in/H_2O (-0.7 psig) is required.

(a) The water manometer, SPL-1774, does not have a mark for 72 in/H_2O (2.6 psig). It is recommended to put a temporary mark at the height of 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 a 2.6 psig (72.0 in/H_2O) safety relief manometer setting.

(6) All plugs are installed from inside the dry bay tank (the pressure side) to prevent blowout of the plug.

(7) The leading edge slats must be fully extended to install the block off plug in the forward spar.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(8) To prevent damage to the wing, all repairs to the wing structure must be completed before the tank is pressurized.

(9) 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.

(10) All areas where the sealant was changed by damage or rework must be tested again to make sure that the seal is good.

(11) All leak repairs must be tested again with this procedure.

B. References

Reference	Title
20-40-11-910-801	Static Grounding (P/B 201)
24-22-00-860-812	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)
57-21-23-000-801	Dry Bay Access Doors Removal (P/B 401)
57-21-23-390-801	Repair of Sealant Leaks in the Wing Dry Bay Tanks (P/B 801)
57-21-23-400-801	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	Structural Repair 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-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	Water Manometer - 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

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(Continued)

Reference	Description
SPL-11086	Expand Vent Plug Assembly, C57003-2 (included in C57003 Test Equipment) Part #: C57003-49 Supplier: 81205 Part #: C57003-50 Supplier: 81205 Opt Part #: C57003-1 Supplier: 81205 Opt Part #: C57003-41 Supplier: 81205
SPL-11088	Pressure Test Door Assembly - Airplanes With Production Winglets, C57003-3 or -51 (included in C57003 Test Equipment) Part #: C57003-49 Supplier: 81205 Opt Part #: C57003-1 Supplier: 81205
SPL-19125	Test Equipment - Wing Dry Bay Vapor Seal Part #: C57003-49 Supplier: 81205 Part #: C57003-50 Supplier: 81205 Opt Part #: C57003-1 Supplier: 81205 Opt Part #: C57003-41 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 CL A)
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

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F. Access Panels

Number	Name/Location
521ZB	Lower Leading Edge Access Panel - Slat Station 488.05
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 508.31
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

G. Prepare for the Procedure

SUBTASK 57-21-23-760-002

(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 57-21-23-981-001

(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 57-21-23-040-003

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

SUBTASK 57-21-23-040-004

(4) Do this task: Leading Edge Flaps and Slats Deactivation, TASK 27-81-00-040-801.

SUBTASK 57-21-23-490-003

(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 57-21-23-862-002

(6) Remove the electrical power from the airplane before you remove the tank access doors.

(a) Do this task: Remove Electrical Power, TASK 24-22-00-860-812.

(b) Do not supply electrical power again until you have completed this procedure.

SUBTASK 57-21-23-010-001

(7) Remove the access door for the inboard, wing dry bay tank on the applicable wing (TASK 57-21-23-000-801):

(a) Open 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

SUBTASK 57-21-23-490-004

(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.

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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 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.

a) While 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.

LOM ALL; AIRPLANES WITH PRODUCTION WINGLETS

(c) Install the pressure test door assembly, C57003-3 or -51, SPL-11088.

1) Put the pressure test door into position in the hole for the access door.

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.

LOM ALL

(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). 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/H_2O (2.6 psig) or 72 in/H_2O (17.9 kPa) and -20 in/H_2O (-0.72 psig) or -20 in/H_2O (-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 Procedure

SUBTASK 57-21-23-790-001

(1) Do the pressure check.

(a) This task is extremely sensitive to the surrounding temperature changes. 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) of air pressure to the test equipment.

(c) Open the shut off valve on the pressure test door; 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.

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(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; 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/H_2O (0.004 psig) or 0.11 in/H_2O (0.03 kPa), the vapor seal is good.

a) Decrease the pressure in the tank to zero.

b) Put the airplane back to the usual condition.

3) If the pressure drop is more than 0.11 in/H_2O (0.004 psig) or 0.11 in/H_2O (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.

<b> 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 Procedure

SUBTASK 57-21-23-010-002

(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:

Number	Name/Location
521ZB	Lower Leading Edge Access Panel - Slat Station 488.05
621ZB	Lower Leading Edge Access Panel - Slat Station 508.31

SUBTASK 57-21-23-010-003

(2) Open the applicable lower trailing edge access panel on the left or right wing.

(a) Open these access panels:

Number	Name/Location
571FB	Lower Outboard Fixed Trailing Edge Wedge Access Panel
671FB	Lower Outboard Fixed Trailing Edge, Wedge Access Panel

SUBTASK 57-21-23-010-004

(3) Open the access door for the outboard, dry bay tank on the applicable wing (TASK 57-21-23-000-801):

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(a) Open these access doors.

Number	Name/Location
534BB	Dry Bay Tank Access Door - Left Wing Station 748
634BB	Dry Bay Tank Access Door - Right Wing Station 748

SUBTASK 57-21-23-790-002

(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) of air pressure to the test equipment.

(c) Open the shut off valve on the pressure test door.

(d) Monitor these areas for air bubbles.

1) The size of the leak can cause the bubbles to form very slowly. 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 57-21-23-080-001

(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 57-21-23-211-001

(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.

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(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 57-00-00).

SUBTASK 57-21-23-360-001

(7) Repair or replace the sealant if necessary.

(a) Do this task: Repair of Sealant Leaks in the Wing Dry Bay Tanks, TASK 57-21-23-390-801.

J. Put the Airplane Back to the Usual Condition

SUBTASK 57-21-23-080-002

(1) Make sure that the drain holes are free from unwanted material or objects.

SUBTASK 57-21-23-090-002

(2) Do a check of the tanks to make sure that you removed all unwanted materials, tools and equipment.

SUBTASK 57-21-23-160-002

(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 57-21-23-410-001

(4) Close these access doors and panels on the left or right wing if necessary (TASK 57-21-23-400-801):

(a) Close these access doors.

Number	Name/Location
534BB	Dry Bay Tank Access Door - Left Wing Station 748
634BB	Dry Bay Tank Access Door - Right Wing Station 748

SUBTASK 57-21-23-410-002

(5) Close these lower leading edge access panels on the left or right wing if necessary (TASK 57-41-02-400-801):

(a) Close these access panels:

Number	Name/Location
521ZB	Lower Leading Edge Access Panel - Slat Station 488.05
621ZB	Lower Leading Edge Access Panel - Slat Station 508.31

SUBTASK 57-21-23-410-005

(6) Close these lower trailing edge access panels on the left or right wing if necessary.

Close these access panels:

Number	Name/Location
571FB	Lower Outboard Fixed Trailing Edge Wedge Access Panel
671FB	Lower Outboard Fixed Trailing Edge, Wedge Access Panel

SUBTASK 57-21-23-410-003

(7) Close the access door for the inboard, dry bay tank on the left or right wing (TASK 57-21-23-400-801):

(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

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SUBTASK 57-21-23-360-002

(8) Remove the work platform, COM-2480, or maintenance platform, COM-659.

SUBTASK 57-21-23-440-003

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

SUBTASK 57-21-23-440-004

(10) Do this task: Leading Edge Flaps and Slats - Activation, TASK 27-81-00-440-801.

SUBTASK 57-21-23-981-002

(11) Do this task: Leading Edge Flaps and Slats Retraction, TASK 27-81-00-860-804.

END OF TASK

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Dry Bay Tank Pressure Check
Figure 601/57-21-23-990-802 (Sheet 1 of 2)

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Dry Bay Tank Pressure Check
Figure 601/57-21-23-990-802 (Sheet 2 of 2)

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NOTE:

DRAIN THE MANOMETER AFTER YOU USE IT TO PREVENT FREEZING.

1 USE THE VALVE TO ADJUST THE FILL LEVEL AND TO DRAIN THE TUBING

2 USE THE VALVE TO DRAIN THE OVERFLOW TRAP

F69620 S0006571238_V2

Water Manometer Assembly
Figure 602/57-21-23-990-804

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WING DRY BAY TANK VAPOR SEAL - REPAIR

1. **General**
   A. This procedure has this tasks:
      (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 57-21-23-390-801

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.
      (2) The dry bay tanks are sealed as follows:
         (a) The dry bay tanks are sealed with sealant, BMS 5-142.
            1) The sealant was applied to the seams between the ribs and the upper and lower skin panels and the forward and aft spar on the inside of the dry bay tanks.
            2) The sealant was applied to the outside surface of the forward spar and the leading edge panel.
            3) The sealant was applied to the outside surface of the aft spar and the trailing edge panel.
         (b) The leading edge ribs are sealed with sealant, BMS 5-142.
            1) The sealant was applied to the seams between the ribs and the upper and lower skin panels and the outside of the forward spar.
            2) The sealant was applied to the outside surface of the forward spar and the leading edge panel.
         (c) Injection seals with sealant BMS 5-45 are made to the channels and cavities between the rib 25 and the forward and aft spars.
         (d) Injection seals with sealant BMS 5-142 are made to the channels and cavities between the rib 26, rib 27 and the forward and aft spars.
         (e) Injection seals with sealant BMS 5-142 are made to the channels and cavities between the rib 27 and the forward spar.
         (f) All fillet seals must touch the injection and prepack seals to maintain seal continuity.
         (g) Tool holes for manufacture and alignment of the wing parts were filled and sealed.
         (h) All non-aluminum fasteners were fillet sealed for corrosion prevention with sealant, BMS 5-142. A thick sealant layer applied to the fasteners with a brush was optional.
         (i) All exposed sealant was covered with a corrosion resistant finish (topcoat) of primer and enamel paint or hydraulic fluid resistant sealant, BMS 5710 Type 41.

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(j) After all sealant application was complete, corrosion inhibiting compound, BMS 3-23 was applied to the dry bay tanks.

(3) Application of sealants.

(a) If you do not do the subsequent steps, vapor leaks can occur:

1) Make sure the surfaces are prepared correctly.

a) The surfaces must not contain unwanted materials such as grease, metal particles, hair, loose paint, corrosion inhibiting compounds or wax.

b) Unwanted materials can cause the sealant not to bond correctly; make the surfaces clean.

2) Follow all manufacturer's instructions for the sealant.

a) Sealants are supplied in two parts; base material and accelerator.

NOTE: You must be very careful to make sure the correct proportions of the base material and the accelerator recommended by the manufacturer are used. If you do not obey the manufacturer's instructions, you can change the physical properties of the mixture which can cause a seal failure and a tank leak.

b) Sealing compounds have a specified shelf life.

NOTE: After the specified time, you must do a test of the sealing compounds to find out if you can use them.

c) You can keep some sealants in refrigeration for a short time after they are mixed with the accelerator.

NOTE: You must discard these sealants after the specified time.

d) Make sure the sealant is applied during the work life or application time after you mix the sealant.

3) Use a brush to apply precoat when recommended.

4) Do all the steps to apply the sealant.

5) Make sure there are no air bubbles in the sealant.

6) Make sure you fill all the spaces completely with sealant.

7) Make sure you do not make an overlap with the sealants.

8) Make sure the sealant touches all the surfaces.

(4) After you find the external leak point and the internal leak source, find the point where the vapor goes through the seal plane.

(a) The area where you see the bubbles usually shows the point where the vapor goes through the seal plane.

(b) If there is an injection, prepack or hidden seal failure, the vapor can move along the tank structure and leak at a point far from the leak source.

(c) If you repair the internal area where you see the bubbles and do not repair the injection, prepack or hidden seal failure, you can only temporarily repair the leak.

(d) You must find all possible leak paths between the external leak point and internal leak source to repair the seal failure.

NOTE: You can increase the height of the seal plane as an alternative to a repair of the seal.

(e) Look for loose fasteners.

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1) Loose fasteners start vapor leaks because they let attached surfaces move.
2) Faying surface seals get cracks and let vapor leak through the seal plane.
3) Loose rivets are not self-sealing.
4) Sealant or metal seal covers do not bond with loose fasteners.

(f) To understand the leak, examine the tank structure and sealant.

B. References

Reference	Title
20-30-82-910-801	General Cleaning of Solvent Resistant Organic Coatings (Series 82) (P/B 201)
20-30-92-910-801	Final Cleaning Prior to General Sealing (Series 92) (P/B 201)
20-30-93-910-801	Final Cleaning Prior to Fuel Tank Sealing (Series 93) (P/B 201)
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)
51-31-00-390-802	Injection Seal Application (P/B 201)
51-31-00-390-804	Fillet Seal Application (P/B 201)
51-31-00-390-805	Fastener Seal Application (P/B 201)
57-21-23-000-801	Dry Bay Access Doors Removal (P/B 401)
57-21-23-400-801	Dry Bay Access Doors 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
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

D. Consumable Materials

Reference	Description	Specification
A00767	Sealant - Fuel Tank	BMS5-45
A02315	Sealant - Low Density, Synthetic Rubber. 2 Part	BMS5-142 Type II
B00130	Alcohol - Isopropyl	TT-I-735
B01002	Solvent - General Cleaning Of Solvent Resistant Organic Coatings (AMM 20-30-82) - Series 82	
B01012	Solvent - Final Cleaning Prior To General Sealing (AMM 20-30-92) - Series 92	
B01013	Solvent - Final Cleaning Prior To Fuel Tank Sealing (AMM 20-30-93) - Series 93	

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(Continued)

Reference	Description	Specification
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 CL A)
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 Procedure

SUBTASK 57-21-23-010-005

(1) Do the task: Dry Bay Access Doors Removal, TASK 57-21-23-000-801.

SUBTASK 57-21-23-212-001

(2) Examine the area you think contains a leak; look for seal defects such as cracked or loose fillets, pinholes, or loose fasteners.

(a) Use an explosion proof flashlight, STD-1081 when you look inside the dry bay tank.

(b) If it is necessary, use an inspection mirror, STD-600 to examine seals which are difficult to see.

(c) You can increase the seal plane to isolate a bad seal, or.

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.

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(d) You can remove the sealant to replace the bad seal.

SUBTASK 57-21-23-360-003

(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 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 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.

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 57-21-23-360-004

(4) If there is a bad injection or prepack seal at rib 25, refer to this task to repair the seal for the surge fuel tank: Repair of Sealant Leaks in the Fuel Tank Structure, TASK 28-11-00-300-803.

SUBTASK 57-21-23-360-005

(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 the all loose sealant; it is not necessary to remove the sealant inside short injection channels that have a good sealant bond.

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.

(b) If the injection channel does not have any sealant for the length of the channel, do the steps that follow:

1) Remove the any loose sealant with pipe cleaners, STD-185 and small sealant removal tool, SPL-768.

a) Be careful not to cause damage to the tank structure.

2) For channels that are too small for pipe cleaners, apply Series 93 solvent, B01013 to the channel with a brush.

a) Refer to Final Cleaning Prior to Fuel Tank Sealing (Series 93), TASK 20-30-93-910-801 for a complete list of Series 93 solvent, B01013.

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.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 57-21-23-160-003

(6) For tank surfaces covered with corrosion inhibiting compound, G00009 (BMS 3-23), 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 inches (25.4 millimeters) 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 Series 82 solvent, B01002.

a) Refer to General Cleaning of Solvent Resistant Organic Coatings (Series 82), TASK 20-30-82-910-801 for the complete list of Series 82 solvent, B01002.

2) Wipe the surface with a new, clean, dry cloth to remove excess solvent; 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 57-21-23-160-004

(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 Series 92 solvent, B01012 to clean all surfaces and sealant from which you removed the topcoat.

1) Refer to Final Cleaning Prior to General Sealing (Series 92), TASK 20-30-92-910-801 for the complete list of Series 92 solvent, B01012.

(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 57-21-23-350-001

(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.

(a) Apply alodine to the surfaces that are worn, damaged or where the metal is shown.

1) Refer to the task:Apply the Corrosion Resistant Finish (Topcoat), TASK 28-11-00-600-801.

SUBTASK 57-21-23-160-005

(9) Immediately before you apply the sealant, clean the surface with a clean cotton wiper, G00034 moist with Series 92 solvent, B01012.

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.

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(a) Refer to Final Cleaning Prior to General Sealing (Series 92), TASK 20-30-92-910-801 for the complete list of Series 92 solvent, B01012.

(b) Wipe the surface with a clean dry cloth to remove excess solvent; do not let the solvent become dry on the surface.

(c) 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 57-21-23-390-002

(1) To apply a new injection seal of sealant, A00767, do the steps that follow:

(a) Refer to this task for the method and examples of injection seals: Injection Seal Application, TASK 51-31-00-390-802.

(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 dry bay tank.

2) If it is necessary, use an inspection mirror, STD-600 to examine seals which are difficult to see.

(c) Apply the injection seal of sealant, A00767 with the sealant gun, STD-449.

H. Wing Dry Bay Tank Repair - Fillet Seals

SUBTASK 57-21-23-390-004

(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 51-31-00-390-804.

(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 dry bay tank.

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; use a clean cotton wiper, G00034.

2) 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.

(g) Apply a corrosion resistant finish (topcoat).

I. Fastener Sealant Application

SUBTASK 57-21-23-390-005

(1) Repair of the fastener fillet seals.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(a) Refer to this task for the method and examples to apply a fastener fillet seal: Fastener Seal Application, TASK 51-31-00-390-805.

1) Apply sealant, A02315 sealant to the fastener and the area 0.50 inch (12.7 millimeters) in width in all directions from the fastener.

a) Use a stiff bristled tampico fiber brush, G50222 to apply the sealant on the surfaces and into crevices.

2) Let the sealant become dry until it is not tacky.

3) Use a sealing gun or spatula and apply sealant, A02315 around and on the fastener.

4) Move the sealant with a sealant fairing tool until you get the dimensions shown for the fillet seal.

5) Examine the sealant for holes, bubbles, or spaces.

a) If there are holes, bubbles or spaces, do the procedure again.

6) Apply a corrosion resistant finish (topcoat).

J. Apply a Corrosion Resistant Finish (Topcoat)

SUBTASK 57-21-23-390-007

(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 Series 93 solvent, B01013 to clean all surfaces and sealant before you apply the topcoat.

1) Wipe the surface with a clean, dry cloth to remove excess solvent; 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 57-21-23-390-006

(2) After all sealant and corrosion resistant finish (topcoat) application is completed, apply corrosion inhibiting compound, G00009 (BMS 3-23) to the area of repair of the dry bay tank.

K. Put the Airplane Back to the Usual Condition

SUBTASK 57-21-23-410-004

(1) Do this task: Dry Bay Access Doors Installation, TASK 57-21-23-400-801.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

466929 S0000142429_V2

Dry Bay Tank Seals
Figure 801/57-21-23-990-803 (Sheet 1 of 6)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Dry Bay Tank Seals
Figure 801/57-21-23-990-803 (Sheet 2 of 6)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

1 FILLET SEAL BMS 5-142

2 DO NOT FILL WILL SEALANT, KEEP OPEN

479290 S0000142431_V2

Dry Bay Tank Seals
Figure 801/57-21-23-990-803 (Sheet 3 of 6)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Dry Bay Tank Seals
Figure 801/57-21-23-990-803 (Sheet 4 of 6)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Dry Bay Tank Seals
Figure 801/57-21-23-990-803 (Sheet 5 of 6)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

479374 S0000142659_V2

Dry Bay Tank Seals
Figure 801/57-21-23-990-803 (Sheet 6 of 6)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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 57-32-00-000-801

2. Remove the Wing Vortex Generators

(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 #: PT6529-S Supplier: 81205 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 - Remove the Wing Vortex Generator

SUBTASK 57-32-00-020-001

(1) Remove the loose vortex generator [1] with sealant removal tool, COM-2481.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-32-00-400-801

3. Install the Wing Vortex Generator

(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 #: PT6529-S Supplier: 81205 Part #: SCD5019 Supplier: 7RKH2 Part #: ST982LF-9 Supplier: 81205 Part #: TS1275-4 Supplier: 22975

I

C. Consumable Materials

Reference	Description	Specification
A00142	Sealant - Temperature Resistant, Fuel Pressure, And Weather Sealant	BMS5-44
A00436	Sealant - Fuel Tank	BMS5-45 (Supersedes BMS5-26)
A00708	Sealant - Fast Curing, 2-Part - PR-1828	AMS 3277

D. Location Zones

Zone	Area
500	Left Wing
600	Right Wing

ECCN 9E991 BOEING PROPRIETARY - See title page for details

E. Procedure - Install the Wing Vortex Generator

SUBTASK 57-32-00-150-001

(1) Remove the remaining adhesive with a sealant removal tool, COM-2481.

SUBTASK 57-32-00-150-002

(2) Restore any damaged paint prior to installation, do this task: Airplane Surface Preparation for Application of Finish, TASK 51-21-00-100-801.

SUBTASK 57-32-00-820-001

(3) Put the vortex generator [1] in the correct position.

SUBTASK 57-32-00-420-001

(4) Do the steps that follow to bond the vortex generator to the upper wing surface:

(a) Mix the base compound for the sealant, A00436, sealant, A00142, or PR-1828 sealant, A00708 with the activator.

NOTE: Refer to the manufacturer's instructions for the details.

(b) Apply a thin, constant layer of the adhesive mixture to each mating surface.

(c) Put the vortex generator on the upper wing surface immediately with sufficient pressure.

NOTE: Make sure that the surfaces are sealed together completely. Make sure that a continuous bead of extruded adhesive is around the edge of the vortex generator. This seals the surfaces together and indicates proper contact.

(d) Remove the unwanted adhesive around the edges of the vortex generator.

SUBTASK 57-32-00-370-001

(5) After the adhesive dries, (Table 401), apply paint to the wing surface if it is necessary.

Table 401/57-32-00-993-802 Cure Time For BMS 5-44 (Class B), BMS 5-45 (Class B) and PR-1828 (Class B)

Adhesive	Cure Time
BMS 5-44 Class B-1/2	24 hours
BMS 5-44 Class B-2	48 hours
BMS 5-45 Class B-1/2	12 hours
BMS 5-45 Class B-2	24 hours
PR-1828 Class B-1/4	4 hours @ 50°F (10°C); 10 hours @ 35°F (2°C)
PR-1828 Class B-1/2	4.5 hours @ 50°F (10°C); 10 hours @ 35°F (2°C)

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

LEFT WING
(RIGHT WING IS OPPOSITE)

1 LINE ALONG AFT EDGE OF VORTEX GENERATOR'S. INSTALL VORTEX GENERATOR'S AT 90.0 ± 2.0 DEGREE

2 DISTANCE FROM EDGE OF PANEL AT AERO-SEAL:
VG1 8.38
VG2 8.38
VG3 8.38
VG4 8.37
VG5 8.37
VG6 8.37
VG7 8.36
VG8 8.33

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Wing Vortex Generator Installation
Figure 401/57-32-00-990-801

ECCN 9E991 BOEING PROPRIETARY - See title page for details

WING LEADING EDGE - CORROSION PREVENTION

1. General

A. Stress corrosion cracking has been found in the hinge support ribs of the inboard leading edge flaps. Most of the cracks were along the fastener line through the inboard and outboard flanges of the ribs, and the remainder were at the flange radius.The rib webs are considered susceptible to stress corrosion cracks.

B. Severe exfoliation corrosion has been found 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 have been found in the flanges of the slat track roller support ribs attached to the leading edge of the wing front spar.

D. Stress corrosion cracking has been found on the slat actuator support fittings. Two fittings were cracked through the attaching bolt lug, and three fittings were cracked near the lug

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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

E. Procedure

SUBTASK 57-41-00-370-001

(1) At first opportunity consistent with the scheduled maintenance activity, 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

CAUTION	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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

LEFT WING
(RIGHT WING IS OPPOSITE)

HINGE SUPPORT RIBS

A

J21265 S0000167621_V2

Wing Leading Edge - Corrosion Prevention
Figure 201/57-41-00-990-801 (Sheet 1 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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Wing Leading Edge - Corrosion Prevention
Figure 201/57-41-00-990-801 (Sheet 2 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

LEFT WING
(RIGHT WING IS OPPOSITE)

LEADING EDGE SLAT TRACK
ROLLER SUPPORT RIB
(EXAMPLE)
A-A

J21758 S0000167624_V2

Wing Leading Edge - Corrosion Prevention
Figure 201/57-41-00-990-801 (Sheet 3 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

LEADING EDGE ACCESS PANELS - MAINTENANCE PRACTICES

1. General

A. This procedure contains the following tasks:

(1) A removal of the leading edge access panel

(2) An installation of the leading edge access panel.

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 surface 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)
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
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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

E. Access Panels

Number	Name/Location
511AB	Inboard Leading Edge, Lower Removable Panel
521AAB	Lower Leading Edge Access Panel - Slat Station 508.31
521AB	Outboard Leading Edge Blowout Door - Slat Station 20.04
521ABB	Lower Leading Edge Access Panel-Slat Station 524.31
521AT	Outbd Leading Edge - Gap Cover Access
521BB	Outboard Lower Fixed Leading Edge Access Panel - Slat Station 36.02
521CB	Lower Leading Edge Access Panel - Slat Station 53.95
521DB	Lower Leading Edge Access Panel - Slat Station 71.38
521EB	Lower Leading Edge Access Panel - Slat Station 98.95
521FB	Lower Leading Edge Access Panel - Slat Station 116.32
521GB	Lower Leading Edge Access Panel - Slat Station 125.27
521HB	Lower Leading Edge Access Panel - Slat Station 152.81
521JB	Lower Leading Edge Access Panel - Slat Station 170.20
521KB	Lower Leading Edge Access Panel - Slat Station 188.12
521LB	Lower Leading Edge Access Panel - Slat Station 216.76
521MB	Lower Leading Edge Access Panel - Slat Station 234.65
521NB	Lower Leading Edge Access Panel - Slat Station 252.04
521PB	Lower Leading Edge Access Panel - Slat Station 270.42
521QB	Lower Leading Edge Access Panel - Slat Station 289.17
521RB	Lower Leading Edge Access Panel - Slat Station 307.75
521SB	Lower Leading Edge Access Panel - Slat Station 337.62
521TB	Lower Leading Edge Access Panel - Slat Station 356.14
521UB	Lower Leading Edge Access Panel - Slat Station 374.95
521VB	Lower Leading Edge Access Panel - Slat Station 395.64
521WB	Lower Leading Edge Access Panel - Slat Station 415.79
521XB	Lower Leading Edge Access Panel - Slat Station 435.91
521YB	Lower Leading Edge Access Panel - Slat Station 467.98
521ZB	Lower Leading Edge Access Panel - Slat Station 488.05
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 20.04
621AT	Outbd Leading Edge - Gap Cover Access
621BB	Outboard Lower Fixed Leading Edge Access Panel - Slat Station 36.02
621CB	Lower Leading Edge Access Panel - Slat Station 53.95
621DB	Lower Leading Edge Access Panel - Slat Station 71.38
621EB	Defuel Access Panel - Slat Station 95.15
621FB	Lower Leading Edge Access Panel - Slat Station 112.52
621GB	Refuel Access Panel - Slat Station 143.27
621HB	Lower Leading Edge Access Panel - Slat Station 170.21
621JB	Lower Leading Edge Access Panel - Slat Station 188.14
621KB	Lower Leading Edge Access Panel - Slat Station 216.71
621LB	Lower Leading Edge Access Panel - Slat Station 234.59
621MB	Lower Leading Edge Access Panel - Slat Station 252.04

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
621NB	Lower Leading Edge Access Panel - Slat Station 270.63
621PB	Lower Leading Edge Access Panel - Slat Station 289.18
621QB	Lower Leading Edge Access Panel - Slat Station 307.75
621RB	Lower Leading Edge Access Panel - Slat Station 337.62
621SB	Lower Leading Edge Access Panel - Slat Station 356.15
621TB	Lower Leading Edge Access Panel - Slat Station 374.95
621UB	Lower Leading Edge Access Panel - Slat Station 395.64
621VB	Lower Leading Edge Access Panel - Slat Station 415.79
621WB	Lower Leading Edge Access Panel - Slat Station 435.91
621XB	Lower Leading Edge Access Panel - Slat Station 467.98
621YB	Lower Leading Edge Access Panel - Slat Station 488.04
621ZB	Lower Leading Edge Access Panel - Slat Station 508.31

F. Prepare for the Removal

SUBTASK 57-41-02-040-002

(1) Do this task: Leading Edge Flaps and Slats Deactivation, TASK 27-81-00-040-801.

SUBTASK 57-41-02-490-002

(2) Get a ladder, work platform, COM-2480, or maintenance platform, COM-659.

SUBTASK 57-41-02-490-003

(3) 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.

(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

(4) 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 57-41-02-490-001

(5) 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 must 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).

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(a) For the left wing, remove these access panels.

Number	Name/Location
511AB	Inboard Leading Edge, Lower Removable Panel
521AAB	Lower Leading Edge Access Panel - Slat Station 508.31
521AB	Outboard Leading Edge Blowout Door - Slat Station 20.04
521ABB	Lower Leading Edge Access Panel-Slat Station 524.31
521AT	Outbd Leading Edge - Gap Cover Access
521BB	Outboard Lower Fixed Leading Edge Access Panel - Slat Station 36.02
521CB	Lower Leading Edge Access Panel - Slat Station 53.95
521DB	Lower Leading Edge Access Panel - Slat Station 71.38
521EB	Lower Leading Edge Access Panel - Slat Station 98.95
521FB	Lower Leading Edge Access Panel - Slat Station 116.32
521GB	Lower Leading Edge Access Panel - Slat Station 125.27
521HB	Lower Leading Edge Access Panel - Slat Station 152.81
521JB	Lower Leading Edge Access Panel - Slat Station 170.20
521KB	Lower Leading Edge Access Panel - Slat Station 188.12
521LB	Lower Leading Edge Access Panel - Slat Station 216.76
521MB	Lower Leading Edge Access Panel - Slat Station 234.65
521NB	Lower Leading Edge Access Panel - Slat Station 252.04
521PB	Lower Leading Edge Access Panel - Slat Station 270.42
521QB	Lower Leading Edge Access Panel - Slat Station 289.17
521RB	Lower Leading Edge Access Panel - Slat Station 307.75
521SB	Lower Leading Edge Access Panel - Slat Station 337.62
521TB	Lower Leading Edge Access Panel - Slat Station 356.14
521UB	Lower Leading Edge Access Panel - Slat Station 374.95
521VB	Lower Leading Edge Access Panel - Slat Station 395.64
521WB	Lower Leading Edge Access Panel - Slat Station 415.79
521XB	Lower Leading Edge Access Panel - Slat Station 435.91
521YB	Lower Leading Edge Access Panel - Slat Station 467.98
521ZB	Lower Leading Edge Access Panel - Slat Station 488.05

(b) For the right wing, remove these access panels.

Number	Name/Location
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 20.04
621AT	Outbd Leading Edge - Gap Cover Access
621BB	Outboard Lower Fixed Leading Edge Access Panel - Slat Station 36.02
621CB	Lower Leading Edge Access Panel - Slat Station 53.95
621DB	Lower Leading Edge Access Panel - Slat Station 71.38
621EB	Defuel Access Panel - Slat Station 95.15
621FB	Lower Leading Edge Access Panel - Slat Station 112.52
621GB	Refuel Access Panel - Slat Station 143.27
621HB	Lower Leading Edge Access Panel - Slat Station 170.21
621JB	Lower Leading Edge Access Panel - Slat Station 188.14
621KB	Lower Leading Edge Access Panel - Slat Station 216.71
621LB	Lower Leading Edge Access Panel - Slat Station 234.59

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
621MB	Lower Leading Edge Access Panel - Slat Station 252.04
621NB	Lower Leading Edge Access Panel - Slat Station 270.63
621PB	Lower Leading Edge Access Panel - Slat Station 289.18
621QB	Lower Leading Edge Access Panel - Slat Station 307.75
621RB	Lower Leading Edge Access Panel - Slat Station 337.62
621SB	Lower Leading Edge Access Panel - Slat Station 356.15
621TB	Lower Leading Edge Access Panel - Slat Station 374.95
621UB	Lower Leading Edge Access Panel - Slat Station 395.64
621VB	Lower Leading Edge Access Panel - Slat Station 415.79
621WB	Lower Leading Edge Access Panel - Slat Station 435.91
621XB	Lower Leading Edge Access Panel - Slat Station 467.98
621YB	Lower Leading Edge Access Panel - Slat Station 488.04
621ZB	Lower Leading Edge Access Panel - Slat Station 508.31

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.

(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.

2) For panels which have a resistance check requirement, do the following:

a) Inspect the condition and presence of the anti-static coating on the countersink holes.

b) If necessary, touch-up the anti-static coating.

NOTE: Refer to BAC5117-14 for application of conductive coatings on composite panels.

(d) Examine the area to make sure that objects have not been left in the slat track housing assembly.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

NOTE:

MAJOR ZONE 500 - LEFT WING.
MAJOR ZONE 600 - RIGHT WING.

1858526 S0000333557_V2

Bonded Panels - Removal/Installation
Figure 201/57-41-02-990-801 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

NOTE:

MAJOR ZONE 500 - LEFT WING.
MAJOR ZONE 600 - RIGHT WING.

1857982 S0000333270_V2

Bonded Panels - Removal/Installation
Figure 201/57-41-02-990-801 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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 surface 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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

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. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
3	Seal disk	52-49-21-02-043	LOM ALL

F. 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

G. Access Panels

Number	Name/Location
511AB	Inboard Leading Edge, Lower Removable Panel
521AAB	Lower Leading Edge Access Panel - Slat Station 508.31
521AB	Outboard Leading Edge Blowout Door - Slat Station 20.04
521ABB	Lower Leading Edge Access Panel-Slat Station 524.31
521AT	Outbd Leading Edge - Gap Cover Access
521BB	Outboard Lower Fixed Leading Edge Access Panel - Slat Station 36.02
521CB	Lower Leading Edge Access Panel - Slat Station 53.95
521DB	Lower Leading Edge Access Panel - Slat Station 71.38
521EB	Lower Leading Edge Access Panel - Slat Station 98.95
521FB	Lower Leading Edge Access Panel - Slat Station 116.32
521GB	Lower Leading Edge Access Panel - Slat Station 125.27
521HB	Lower Leading Edge Access Panel - Slat Station 152.81
521JB	Lower Leading Edge Access Panel - Slat Station 170.20
521KB	Lower Leading Edge Access Panel - Slat Station 188.12
521LB	Lower Leading Edge Access Panel - Slat Station 216.76
521MB	Lower Leading Edge Access Panel - Slat Station 234.65
521NB	Lower Leading Edge Access Panel - Slat Station 252.04

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
521PB	Lower Leading Edge Access Panel - Slat Station 270.42
521QB	Lower Leading Edge Access Panel - Slat Station 289.17
521RB	Lower Leading Edge Access Panel - Slat Station 307.75
521SB	Lower Leading Edge Access Panel - Slat Station 337.62
521TB	Lower Leading Edge Access Panel - Slat Station 356.14
521UB	Lower Leading Edge Access Panel - Slat Station 374.95
521VB	Lower Leading Edge Access Panel - Slat Station 395.64
521WB	Lower Leading Edge Access Panel - Slat Station 415.79
521XB	Lower Leading Edge Access Panel - Slat Station 435.91
521YB	Lower Leading Edge Access Panel - Slat Station 467.98
521ZB	Lower Leading Edge Access Panel - Slat Station 488.05
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 20.04
621AT	Outbd Leading Edge - Gap Cover Access
I 621BB	Outboard Lower Fixed Leading Edge Access Panel - Slat Station 36.02
621CB	Lower Leading Edge Access Panel - Slat Station 53.95
621DB	Lower Leading Edge Access Panel - Slat Station 71.38
621EB	Defuel Access Panel - Slat Station 95.15
621FB	Lower Leading Edge Access Panel - Slat Station 112.52
621GB	Refuel Access Panel - Slat Station 143.27
621HB	Lower Leading Edge Access Panel - Slat Station 170.21
621JB	Lower Leading Edge Access Panel - Slat Station 188.14
621KB	Lower Leading Edge Access Panel - Slat Station 216.71
621LB	Lower Leading Edge Access Panel - Slat Station 234.59
621MB	Lower Leading Edge Access Panel - Slat Station 252.04
621NB	Lower Leading Edge Access Panel - Slat Station 270.63
621PB	Lower Leading Edge Access Panel - Slat Station 289.18
621QB	Lower Leading Edge Access Panel - Slat Station 307.75
621RB	Lower Leading Edge Access Panel - Slat Station 337.62
621SB	Lower Leading Edge Access Panel - Slat Station 356.15
621TB	Lower Leading Edge Access Panel - Slat Station 374.95
621UB	Lower Leading Edge Access Panel - Slat Station 395.64
621VB	Lower Leading Edge Access Panel - Slat Station 415.79
621WB	Lower Leading Edge Access Panel - Slat Station 435.91
621XB	Lower Leading Edge Access Panel - Slat Station 467.98
621YB	Lower Leading Edge Access Panel - Slat Station 488.04
621ZB	Lower Leading Edge Access Panel - Slat Station 508.31

H. 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.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 57-41-02-420-001

(2) Install the applicable access panel on the wing (Figure 201).

(a) For the left wing, install the applicable access panels.

Number	Name/Location
511AB	Inboard Leading Edge, Lower Removable Panel
521AAB	Lower Leading Edge Access Panel - Slat Station 508.31
521AB	Outboard Leading Edge Blowout Door - Slat Station 20.04
521ABB	Lower Leading Edge Access Panel-Slat Station 524.31
521AT	Outbd Leading Edge - Gap Cover Access
521BB	Outboard Lower Fixed Leading Edge Access Panel - Slat Station 36.02
521CB	Lower Leading Edge Access Panel - Slat Station 53.95
521DB	Lower Leading Edge Access Panel - Slat Station 71.38
521EB	Lower Leading Edge Access Panel - Slat Station 98.95
521FB	Lower Leading Edge Access Panel - Slat Station 116.32
521GB	Lower Leading Edge Access Panel - Slat Station 125.27
521HB	Lower Leading Edge Access Panel - Slat Station 152.81
521JB	Lower Leading Edge Access Panel - Slat Station 170.20
521KB	Lower Leading Edge Access Panel - Slat Station 188.12
521LB	Lower Leading Edge Access Panel - Slat Station 216.76
521MB	Lower Leading Edge Access Panel - Slat Station 234.65
521NB	Lower Leading Edge Access Panel - Slat Station 252.04
521PB	Lower Leading Edge Access Panel - Slat Station 270.42
521QB	Lower Leading Edge Access Panel - Slat Station 289.17
521RB	Lower Leading Edge Access Panel - Slat Station 307.75
521SB	Lower Leading Edge Access Panel - Slat Station 337.62
521TB	Lower Leading Edge Access Panel - Slat Station 356.14
521UB	Lower Leading Edge Access Panel - Slat Station 374.95
521VB	Lower Leading Edge Access Panel - Slat Station 395.64
521WB	Lower Leading Edge Access Panel - Slat Station 415.79
521XB	Lower Leading Edge Access Panel - Slat Station 435.91
521YB	Lower Leading Edge Access Panel - Slat Station 467.98
521ZB	Lower Leading Edge Access Panel - Slat Station 488.05

(b) For the right wing, install the applicable access panels.

Number	Name/Location
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 20.04
621AT	Outbd Leading Edge - Gap Cover Access
621BB	Outboard Lower Fixed Leading Edge Access Panel - Slat Station 36.02
621CB	Lower Leading Edge Access Panel - Slat Station 53.95
621DB	Lower Leading Edge Access Panel - Slat Station 71.38
621EB	Defuel Access Panel - Slat Station 95.15
621FB	Lower Leading Edge Access Panel - Slat Station 112.52
621GB	Refuel Access Panel - Slat Station 143.27
621HB	Lower Leading Edge Access Panel - Slat Station 170.21

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
621JB	Lower Leading Edge Access Panel - Slat Station 188.14
621KB	Lower Leading Edge Access Panel - Slat Station 216.71
621LB	Lower Leading Edge Access Panel - Slat Station 234.59
621MB	Lower Leading Edge Access Panel - Slat Station 252.04
621NB	Lower Leading Edge Access Panel - Slat Station 270.63
621PB	Lower Leading Edge Access Panel - Slat Station 289.18
621QB	Lower Leading Edge Access Panel - Slat Station 307.75
621RB	Lower Leading Edge Access Panel - Slat Station 337.62
621SB	Lower Leading Edge Access Panel - Slat Station 356.15
621TB	Lower Leading Edge Access Panel - Slat Station 374.95
621UB	Lower Leading Edge Access Panel - Slat Station 395.64
621VB	Lower Leading Edge Access Panel - Slat Station 415.79
621WB	Lower Leading Edge Access Panel - Slat Station 435.91
621XB	Lower Leading Edge Access Panel - Slat Station 467.98
621YB	Lower Leading Edge Access Panel - Slat Station 488.04
621ZB	Lower Leading Edge Access Panel - Slat Station 508.31

(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).

ECCN 9E991 BOEING PROPRIETARY - See title page for details

e) Make sure that the sealant is attached on the door structure and not on the door.

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.

2) For the Fuel Shut Off Access Doors, do the following:

a) Inspect the condition and/or presence of the seal disk [3] on the latches of the access doors (Figure 206).

b) If necessary to replace or install a seal disk [3] on to the access door latch, do the following steps:

<1> Prepare the mounting surface of the seal disk by sanding the contact side of the seal disk to remove any parting agent.

<2> Solvent clean the seal disk to remove any sanding debris.

<3> Solvent clean the mounting surface on the button of each latch where the seal disk will be installed.

<4> Assemble the seal disk onto the button of the latch and align the disk so it is concentric with the button.

<5> Affix the seal disk to underside of button with sealant, A50142. Apply sealant in continuous bead encircling the button stem prior to pressing disk in place.

<6> Wipe off all excess sealant on button face and sides.

<7> Allow sufficient time to cure to tack-free prior to closing latch.

(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 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 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.

(h) Examine the area to make sure objects are not left in the slat track housing assembly.

(i) Install the bolt.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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, +0.002 inch or -0.010 inch.

4) Install the applicable electrical bonding fastener (BACB30ZE4-( )G) 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.

I. Blowout door and Fuel Shutoff Access Door Leak Check

SUBTASK 57-41-02-010-001

(1) For the left wing, open this access panel:

Number	Name/Location
521CB	Lower Leading Edge Access Panel - Slat Station 53.95

SUBTASK 57-41-02-010-002

(2) For the right wing, open this access panel:

Number	Name/Location
621CB	Lower Leading Edge Access Panel - Slat Station 53.95

SUBTASK 57-41-02-790-001

(3) 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.

SUBTASK 57-41-02-790-002

(4) 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.

SUBTASK 57-41-02-410-001

(5) For the left wing, close this access panel:

Number	Name/Location
521CB	Lower Leading Edge Access Panel - Slat Station 53.95

SUBTASK 57-41-02-410-002

(6) For the right wing, close this access panel:

Number	Name/Location
621CB	Lower Leading Edge Access Panel - Slat Station 53.95

ECCN 9E991 BOEING PROPRIETARY - See title page for details

J. Put the Airplane Back to Its 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 ———

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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

1930287 S0000364782_V2

Leading Edge Slat Track Ribs - Sealant Location
Figure 202/57-41-02-990-802 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

1930336 S0000364783_V2

Leading Edge Slat Track Ribs - Sealant Location
Figure 202/57-41-02-990-802 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

1930366 S0000364779_V2

Blowout Door and Fuel Shutoff Access Door - Sealant Location
Figure 203/57-41-02-990-803 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

2458920 S0000570597_V1

Blowout Door and Fuel Shutoff Access Door - Sealant Location
Figure 203/57-41-02-990-803 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(LEFT SIDE IS SHOWN, RIGHT SIDE IS OPPOSITE)

A

1930357 S0000364784_V2

Blowout Door and Fuel Shutoff Access Door - Leak Test
Figure 204/57-41-02-990-804

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(BOTTOM VIEW)

A

1 NOT ON ALL AIRPLANES
2 0.50 OHMS MAXIMUM
3 300,000 OHMS MAXIMUM

1932269 S0000365659_V3

Removable Leading Edge Panel Bonding Resistance
Figure 205/57-41-02-990-806 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

1 NOT ON ALL AIRPLANES
2 0.50 OHMS MAXIMUM
3 300,000 OHMS MAXIMUM

3003863 S0000779165_V2

Removable Leading Edge Panel Bonding Resistance
Figure 205/57-41-02-990-806 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

2862383 S0000674363_V1

Fuel Shutoff Valve Access Door - Seal Disk Installation
Figure 206/57-41-02-990-807 (Sheet 1 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

A-A

2862384 S0000674364_V1

Fuel Shutoff Valve Access Door - Seal Disk Installation
Figure 206/57-41-02-990-807 (Sheet 2 of 2)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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 53.95
521FB	Lower Leading Edge Access Panel - Slat Station 116.32
521HB	Lower Leading Edge Access Panel - Slat Station 152.81
521LB	Lower Leading Edge Access Panel - Slat Station 216.76
521PB	Lower Leading Edge Access Panel - Slat Station 270.42
521SB	Lower Leading Edge Access Panel - Slat Station 337.62
521VB	Lower Leading Edge Access Panel - Slat Station 395.64
521YB	Lower Leading Edge Access Panel - Slat Station 467.98
621CB	Lower Leading Edge Access Panel - Slat Station 53.95
621FB	Lower Leading Edge Access Panel - Slat Station 112.52
621LB	Lower Leading Edge Access Panel - Slat Station 234.59

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(Continued)

Number	Name/Location
621PB	Lower Leading Edge Access Panel - Slat Station 289.18
621SB	Lower Leading Edge Access Panel - Slat Station 356.15
621VB	Lower Leading Edge Access Panel - Slat Station 415.79
621YB	Lower Leading Edge Access Panel - Slat Station 488.04

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 53.95
521FB	Lower Leading Edge Access Panel - Slat Station 116.32
521HB	Lower Leading Edge Access Panel - Slat Station 152.81
521LB	Lower Leading Edge Access Panel - Slat Station 216.76
521PB	Lower Leading Edge Access Panel - Slat Station 270.42
521SB	Lower Leading Edge Access Panel - Slat Station 337.62
521VB	Lower Leading Edge Access Panel - Slat Station 395.64
521YB	Lower Leading Edge Access Panel - Slat Station 467.98

(b) For the right wing, open these access panels:

Number	Name/Location
621CB	Lower Leading Edge Access Panel - Slat Station 53.95
621FB	Lower Leading Edge Access Panel - Slat Station 112.52
621LB	Lower Leading Edge Access Panel - Slat Station 234.59
621PB	Lower Leading Edge Access Panel - Slat Station 289.18
621SB	Lower Leading Edge Access Panel - Slat Station 356.15
621VB	Lower Leading Edge Access Panel - Slat Station 415.79
621YB	Lower Leading Edge Access Panel - Slat Station 488.04

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].

1) Discard the cotter pins [7].

(b) Remove the nut [6], washers [4], and bushing [5] from the upper aft bearing [3].

(c) Remove the nut [9], washers [8], and bushing [10] from the lower aft bearing [3].

ECCN 9E991 BOEING PROPRIETARY - See title page for details

> **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.

(d) Remove the bolts [1] and bearings [3].

(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 57-44-01-200-001

(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].

1) Discard the cotter pins [7].

(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].

> **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.

(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 [12], bushing [16], nut [13], and nut [15].

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

LEFT WING
(RIGHT WING IS EQUIVALENT)

K55802 S0006581598_V2

Outboard Fixed Leading Edge Slat Rollers Installation
Figure 401/57-44-01-990-802 (Sheet 1 of 4)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

INBOARD GUIDE ASSEMBLY
(OUTBOARD GUIDE ASSEMBLY IS OPPOSITE)

B

K55795 S0006581599_V3

Outboard Fixed Leading Edge Slat Rollers Installation
Figure 401/57-44-01-990-802 (Sheet 2 of 4)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

AFT ROLLER

A-A

1 USE A MINIMUM OF 1 WASHER
AND A MAXIMUM OF 4 WASHERS

2842888 S0000663675_V1

Outboard Fixed Leading Edge Slat Rollers Installation
Figure 401/57-44-01-990-802 (Sheet 3 of 4)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

FORWARD ROLLER

B-B

2842889 S0000663676_V1

Outboard Fixed Leading Edge Slat Rollers Installation
Figure 401/57-44-01-990-802 (Sheet 4 of 4)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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. 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 53.95
521FB	Lower Leading Edge Access Panel - Slat Station 116.32
521HB	Lower Leading Edge Access Panel - Slat Station 152.81
521LB	Lower Leading Edge Access Panel - Slat Station 216.76
521PB	Lower Leading Edge Access Panel - Slat Station 270.42
521SB	Lower Leading Edge Access Panel - Slat Station 337.62
521VB	Lower Leading Edge Access Panel - Slat Station 395.64
521YB	Lower Leading Edge Access Panel - Slat Station 467.98
621CB	Lower Leading Edge Access Panel - Slat Station 53.95
621FB	Lower Leading Edge Access Panel - Slat Station 112.52
621HB	Lower Leading Edge Access Panel - Slat Station 170.21
621LB	Lower Leading Edge Access Panel - Slat Station 234.59
621PB	Lower Leading Edge Access Panel - Slat Station 289.18
621SB	Lower Leading Edge Access Panel - Slat Station 356.15
621VB	Lower Leading Edge Access Panel - Slat Station 415.79
621YB	Lower Leading Edge Access Panel - Slat Station 488.04

D. Prepare for the Installation

SUBTASK 57-44-01-000-001

(1) Remove the labels from the bolts [1], bearings [3], washers [2], washers [11], washers [14], nut [13], nut [15], bushing [12], and bushing [16] for the forward roller.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 57-44-01-420-001

> **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 57-44-01-400-001

(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 washers [11], washers [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 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 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 bolt [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 bolt [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).

> **CAUTION** 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).

ECCN 9E991 BOEING PROPRIETARY - See title page for details

10) Rotate the nut 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], nut [6], nut [9], bushing [5], and bushing [10] for the aft roller.

SUBTASK 57-44-01-420-002

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.

(5) Examine the area to make sure that objects are not left in the slat track housing assembly.

SUBTASK 57-44-01-400-002

(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:

CAUTION 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 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] or nut [6].

CAUTION 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 a maximum of one additional castellation to align the cotter pin hole.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

CAUTION

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, tighten the lower nut [9] to a minimum of 200 in-lb (23 N·m).

8) Rotate the nut a maximum of one additional castellation to align the cotter pin hole.

9) Install the new cotter pin [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 this access panels:

Number	Name/Location
521CB	Lower Leading Edge Access Panel - Slat Station 53.95
521FB	Lower Leading Edge Access Panel - Slat Station 116.32
521HB	Lower Leading Edge Access Panel - Slat Station 152.81
521LB	Lower Leading Edge Access Panel - Slat Station 216.76
521PB	Lower Leading Edge Access Panel - Slat Station 270.42
521SB	Lower Leading Edge Access Panel - Slat Station 337.62
521VB	Lower Leading Edge Access Panel - Slat Station 395.64
521YB	Lower Leading Edge Access Panel - Slat Station 467.98

(b) For the right wing, close this access panels:

Number	Name/Location
621CB	Lower Leading Edge Access Panel - Slat Station 53.95
621FB	Lower Leading Edge Access Panel - Slat Station 112.52
621HB	Lower Leading Edge Access Panel - Slat Station 170.21
621LB	Lower Leading Edge Access Panel - Slat Station 234.59
621PB	Lower Leading Edge Access Panel - Slat Station 289.18
621SB	Lower Leading Edge Access Panel - Slat Station 356.15
621VB	Lower Leading Edge Access Panel - Slat Station 415.79
621YB	Lower Leading Edge Access Panel - Slat Station 488.04

SUBTASK 57-44-01-410-003

(9) Do this task: Leading Edge Flaps and Slats - Activation, TASK 27-81-00-440-801.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

OUTBOARD LEADING EDGE BALLAST - REMOVAL/INSTALLATION

1. General

A. This procedure has these tasks:

(1) The removal of the outboard leading edge ballast.

(2) The installation of the outboard leading edge ballast.

TASK 57-44-02-000-801

2. Outboard Leading Edge Ballast Removal

(Figure 401)

A. General

(1) This task gives the procedure to remove the outboard leading edge ballast weight 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)
57-21-21-000-801	Winglet Removal (P/B 401)
57-41-02-000-801	Leading Edge Access Panel Removal (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
521	Left Wing - Leading Edge to Front Spar
527	Left Winglet
600	Right Wing
621	Right Wing - Leading Edge to Front Spar
627	Right Winglet

ECCN 9E991 BOEING PROPRIETARY - See title page for details

E. Access Panels

Number	Name/Location
521ABB	Lower Leading Edge Access Panel-Slat Station 524.31
621AAB	Lower Leading Edge Access Panel - Slat Station 524.31

F. Prepare for the Procedure

SUBTASK 57-44-02-760-001

(1) Make sure the airplane is correctly grounded to an approved and identified ground.

(a) Do this task: Static Grounding, TASK 20-40-11-910-801.

SUBTASK 57-44-02-040-001

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

SUBTASK 57-44-02-040-002

(3) Do this task: Leading Edge Flaps and Slats Deactivation, TASK 27-81-00-040-801.

SUBTASK 57-44-02-490-001

(4) Get a ladders, 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 57-44-02-860-001

(5) 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 (15.24 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 57-44-02-010-002

(6) Remove the applicable access panel [2] located at the wing leading edge, adjacent to the outboard rib 27 and the winglet (TASK 57-41-02-000-801).

(a) Open these access panels.

Number	Name/Location
521ABB	Lower Leading Edge Access Panel-Slat Station 524.31
621AAB	Lower Leading Edge Access Panel - Slat Station 524.31

SUBTASK 57-44-02-010-012

(7) Remove the leading edge upper access panel [3] (TASK 57-41-02-000-801).

(a) Remove the 50 bolts that attach the leading edge upper access panel [3].

(b) Open these access panels:

Number	Name/Location
521ABB	Lower Leading Edge Access Panel-Slat Station 524.31
621AAB	Lower Leading Edge Access Panel - Slat Station 524.31

SUBTASK 57-44-02-010-003

(8) Remove the winglet (TASK 57-21-21-000-801).

ECCN 9E991 BOEING PROPRIETARY - See title page for details

G. Outboard Leading Edge Ballast Removal

SUBTASK 57-44-02-020-002

(1) Remove the ballast weight [11] and ballast weight [12] (View B-B):

(a) Hold the ballast weight [11] and ballast weight [12] as you remove the attachment fasteners.

NOTE: The combined weight of the ballast weight [11] and ballast weight [12] is approximately 28.5 lb (12.9 kg).

(b) Remove the three bolts [13], three washers [14], three washers [15], and three nuts [16] retaining the ballast weight [11] and ballast weight [12] to the support structure.

(c) Remove the ballast weight [11] and ballast weight [12].

SUBTASK 57-44-02-020-009

(2) Remove the ballast weight [21] and ballast weight [22] (View C-C):

(a) Hold the ballast weight [21] and ballast weight [22] as you remove the attachment fasteners.

NOTE: The combined weight of the ballast weight [21] and ballast weight [22] is approximately 30 lb (13.6 kg).

(b) Remove the four bolts [23], four washers [24], four washers [25], and four nuts [26] retaining the ballast weight [21] and ballast weight [22] to the support structure.

(c) Remove the ballast weight [21] and ballast weight [22].

SUBTASK 57-44-02-020-022

(3) Remove the ballast weight [21] (View D-D):

(a) Hold the ballast weight [21] as you remove the attachment fasteners.

NOTE: The weight of the ballast weight [21] is approximately 15 lb (6.8 kg).

(b) Remove the four bolts [23], four washers [24], four washers [25], and four nuts [26] retaining the ballast weight [21] to the support structure.

(c) Remove the ballast weight [21].

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

LEFT WINGLET
(RIGHT WINGLET OPPOSITE)

A

2371152 S0000542731_V3

Outboard Leading Edge Ballast Installation
Figure 401/57-44-02-990-801 (Sheet 1 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

1 FAY SURFACE SEAL BETWEEN BALLAST WEIGHT AND SUPPORT STRUCTURE USING BMS5-95 SEALANT PER BAC5000.

2371153 S0000542732_V3

Outboard Leading Edge Ballast Installation
Figure 401/57-44-02-990-801 (Sheet 2 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

C-C

D-D

1 FAY SURFACE SEAL BETWEEN BALLAST WEIGHT AND FITTING SUPPORT STRUCTURE USING BMS5-95 SEALANT PER BAC5000.

2899949 S0000692378_V1

Outboard Leading Edge Ballast Installation
Figure 401/57-44-02-990-801 (Sheet 3 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-44-02-400-801

3. Outboard Leading Edge Ballast Installation

(Figure 401)

A. General

(1) This task gives the procedure to install the outboard leading edge ballast on 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)
57-21-21-400-801	Winglet Installation (P/B 401)
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
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
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
G50237	Compound - Corrosion Inhibiting, Non-drying - Cor-Ban 27L	BMS3-38

E. Location Zones

Zone	Area
500	Left Wing
521	Left Wing - Leading Edge to Front Spar
527	Left Winglet
600	Right Wing
621	Right Wing - Leading Edge to Front Spar
627	Right Winglet

F. Access Panels

Number	Name/Location
521ABB	Lower Leading Edge Access Panel-Slat Station 524.31
621AAB	Lower Leading Edge Access Panel - Slat Station 524.31

ECCN 9E991 BOEING PROPRIETARY - See title page for details

G. Outboard Leading Edge Ballast Installation

SUBTASK 57-44-02-420-003

(1) Install the ballast weight [11] and ballast weight [12] (View B-B):

(a) Fay surface seal between the ballast weight [11] and support structure with sealant, A00247.

> **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.

(b) Fill the holes with Cor-Ban 27L Compound, G50237, prior to installing the bolts [13].

(c) Install the ballast weight [11] and ballast weight [12] onto the support structure with three bolts [13], three washers [14], three washers [15], and three nuts [16].

NOTE: The combined weight of the ballast weight [11] and ballast weight [12] is approximately 28.5 lb (12.9 kg).

(d) Tighten the bolts [13] to 165 ±35 in-lb (19 ±4 N·m).

SUBTASK 57-44-02-420-011

(2) Install the ballast weight [21] and ballast weight [22] (View C-C):

(a) Fay surface seal between the ballast weight [21] and support structure with sealant, A00247.

> **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.

(b) Fill the holes with Cor-Ban 27L Compound, G50237, prior to installing the bolts [23].

(c) Install the ballast weight [21] and ballast weight [22] onto the support structure with four bolts [23], four washers [24], four washers [25], and four nuts [26].

NOTE: The combined weight of the ballast weight [21] and ballast weight [22] is approximately 30 lb (13.6 kg).

(d) Tighten the bolts [23] to 65 in-lb (7.3 N·m) - 100 in-lb (11.3 N·m).

SUBTASK 57-44-02-420-029

(3) Install the ballast weight [21] (View D-D):

(a) Fay surface seal between the ballast weight [21] and support structure with sealant, A00247.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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.

(b) Fill the holes with Cor-Ban 27L Compound, G50237, prior to installing the bolts [23].

(c) Install the ballast weight [21] onto the support structure with four bolts [23], four washers [24], four washers [25], and four nuts [26].

NOTE: The weight of the ballast weight [21] is approximately 15 lb (6.8 kg).

(d) Tighten the bolts [23] to 65 in-lb (7.3 N·m) - 100 in-lb (11.3 N·m).

H. Put the Airplane Back to Its Usual Condition

SUBTASK 57-44-02-410-002

(1) Install the applicable access panel [2] on the left or right wing (TASK 57-41-02-400-801).

(a) Close these access panels.

Number	Name/Location
521ABB	Lower Leading Edge Access Panel-Slat Station 524.31
621AAB	Lower Leading Edge Access Panel - Slat Station 524.31

SUBTASK 57-44-02-410-016

(2) Install the applicable access panel [3] on the left or right wing (TASK 57-41-02-400-801).

(a) Install the leading edge upper access panel [3] with the 50 bolts.

(b) Close these access panels:

Number	Name/Location
521ABB	Lower Leading Edge Access Panel-Slat Station 524.31
621AAB	Lower Leading Edge Access Panel - Slat Station 524.31

SUBTASK 57-44-02-410-003

(3) Install the winglet (Winglet Installation, TASK 57-21-21-400-801).

SUBTASK 57-44-02-090-001

(4) Remove the ladders, work platform, COM-2480 or maintenance platform, COM-659.

SUBTASK 57-44-02-440-001

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

SUBTASK 57-44-02-440-002

(6) Do this task: Leading Edge Flaps and Slats - Activation, TASK 27-81-00-440-801.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

OUTBOARD LEADING EDGE SEAL RIB - INSPECTION/CHECK

1. General

A. this procedure has the task to inspect the fillet seals on the seal ribs adjacent to the leading edge slats.

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, a repair of the fillet seal or replacement of the fillet seal is neccesary.

(3) The inboard side of rib 27, the forward spar and leading edge seal rib are sealed with sealant, BMS 5-142:

(a) The sealant was applied to the seams between the ribs and the upper and lower skin panels, the leading edge panel and the outside surface of the forward spar.

(b) Injection seals with sealant BMS 5-142 are made to the channels and cavities between the rib 27 and the forward spar.

(c) All fillet seals must touch the injection and prepack seals to maintain seal continuity.

(d) Tool holes for manufacture and alignment of the wing parts were filled and sealed.

(4) Vapor can go through the seal plane from a leak point.

(a) If there is an injection, prepack or hidden seal failure, the vapor can move along the structure and leak at a point far from the leak source.

(b) You must find all possible leak paths between the external leak point and internal leak point to repair the seal failure.

NOTE: You can increase the height of the seal plane as an alternative to a repair of the seal.

(c) Look for loose fasteners.

1) Loose fasteners start vapor leaks because they let attached surfaces move.

2) Faying surface seals get cracks and let vapor leak through the seal plane.

3) Loose rivets are not self-sealing.

4) Sealant does not bond with loose fasteners.

(d) To understand the leak, examine the wing structure and sealant.

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)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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 57-44-03-010-002

(1) Do the task: Leading Edge Access Panel Removal, TASK 57-41-02-000-801.

F. Visual Check

SUBTASK 57-44-03-212-002

(1) Examine the area you think contains a leak; look for seal defects such as cracked or loose fillets, pinholes, or loose fasteners.

(a) Refer to the figure: Leading Edge Seal Rib Fillet Seals/Figure 601.

(b) Use an explosion proof flashlight, STD-1081 when you look inside the leading edge area.

(c) If it is necessary, use an inspection mirror, STD-600 to examine seals which are difficult to see.

SUBTASK 57-44-03-212-003

(2) If you find seal defects, repair or replace the fillet seal:

(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 57-44-03-410-002

(1) Do this task: Leading Edge Access Panel Installation, TASK 57-41-02-400-801.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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Leading Edge Seal Rib Fillet Seals
Figure 601/57-44-03-990-804 (Sheet 1 of 5)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

1 FILLET SEAL BMS 5-142
2 DO NOT FILL WITH SEALANT, KEEP OPEN, DRAINAGE PATH
3 TOOL HOLE SEAL BMS 5-142
4 INJECTION SEAL BMS 5-142
5 PANEL GAPS SEAL BMS 5-95

488162 S0000146255_V2

Leading Edge Seal Rib Fillet Seals
Figure 601/57-44-03-990-804 (Sheet 2 of 5)

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B-B

B-B

488221 S0000146256_V2

Leading Edge Seal Rib Fillet Seals
Figure 601/57-44-03-990-804 (Sheet 3 of 5)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

C-C

C-C

488278 S0000146257_V2

Leading Edge Seal Rib Fillet Seals
Figure 601/57-44-03-990-804 (Sheet 4 of 5)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

D-D

488688 S0000146260_V2

Leading Edge Seal Rib Fillet Seals
Figure 601/57-44-03-990-804 (Sheet 5 of 5)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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.

(2) The forward spar and leading edge ribs are sealed with sealant, BMS 5-142:

(a) The sealant was applied to the seams between the ribs and the upper and lower skin panels, the leading edge panel and the outside surface of the forward spar.

(b) Injection seals with sealant BMS 5-142 are made to the channels and cavities between the rib 27 and the forward spar.

(c) All fillet seals must touch the injection and prepack seals to maintain seal continuity.

(d) Tool holes for manufacture and alignment of the wing parts were filled and sealed.

(3) Application of sealants.

(a) If you do not do the subsequent steps, vapor leaks can occur:

1) Make sure the surfaces are prepared correctly.

a) The surfaces must not contain unwanted materials such as grease, metal particles, hair, loose paint, corrosion inhibiting compounds or wax.

b) Unwanted materials can cause the sealant not to bond correctly; make the surfaces clean.

2) Follow all manufacturer's instructions for the sealant.

a) Sealants are supplied in two parts; base material and accelerator.

NOTE: You must be very careful to make sure the correct proportions of the base material and the accelerator recommended by the manufacturer are used. If you do not obey the manufacturer's instructions, you can change the physical properties of the mixture which can cause a seal failure and a tank leak.

b) Sealing compounds have a specified shelf life.

NOTE: After the specified time, you must do a test of the sealing compounds to find out if you can use them.

c) You can keep some sealants in refrigeration for a short time after they are mixed with the accelerator.

NOTE: You must discard these sealants after the specified time.

d) Make sure the sealant is applied during the work life or application time after you mix the sealant.

3) Use a brush to apply precoat when recommended.

4) Do all the steps to apply the sealant.

5) Make sure there are no air bubbles in the sealant.

6) Make sure you fill all the spaces completely with sealant.

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7) Make sure you do not make an overlap with the sealants.

8) Make sure the sealant touches all the surfaces.

(4) After you find the external leak point and the internal leak source, find the point where the vapor goes through the seal plane.

(a) If there is an injection, prepack or hidden seal failure, the vapor can move along the structure and leak at a point far from the leak source.

(b) You must find all possible leak paths between the external leak point and internal leak source to repair the seal failure.

NOTE: You can increase the height of the seal plane as an alternative to a repair of the seal.

(c) Look for loose fasteners.

1) Loose fasteners start vapor leaks because they let attached surfaces move.

2) Faying surface seals get cracks and let vapor leak through the seal plane.

3) Loose rivets are not self-sealing.

4) Sealant does not bond with loose fasteners.

(d) To understand the leak, examine the wing structure and sealant.

B. References

Reference	Title
20-30-82-910-801	General Cleaning of Solvent Resistant Organic Coatings (Series 82) (P/B 201)
20-30-92-910-801	Final Cleaning Prior to General Sealing (Series 92) (P/B 201)
51-31-00-390-804	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
B00130	Alcohol - Isopropyl	TT-I-735
B01002	Solvent - General Cleaning Of Solvent Resistant Organic Coatings (AMM 20-30-82) - Series 82	

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(Continued)

Reference	Description	Specification
B01012	Solvent - Final Cleaning Prior To General Sealing (AMM 20-30-92) - Series 92	
B01013	Solvent - Final Cleaning Prior To Fuel Tank Sealing (AMM 20-30-93) - Series 93	
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
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	AMS3819 Class 1 Grade A or B Form 1 (Supersede BMS15-5 CL A)
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 57-44-03-010-001

(1) Do the task: Leading Edge Access Panel Removal, TASK 57-41-02-000-801.

SUBTASK 57-44-03-212-001

(2) Examine the area you think contains a leak; look for seal defects such as cracked or loose fillets, pinholes, or loose fasteners.

(a) Refer to this figure to examine the attach fitting for the leading edge ballast, the seal rib and rib 27:Leadng Edge Seal Rib Fillet Seals/Figure 801.

(b) Use an explosion proof flashlight, STD-1081 when you look inside the leading edge area.

(c) If it is necessary, use an inspection mirror, STD-600 to examine seals which are difficult to see.

(d) You can increase the seal plane to isolate a bad seal, or.

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.

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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 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 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.

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 57-44-03-160-002

(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 inches (25.4 millimeters) 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 Series 82 solvent, B01002.

a) Refer to General Cleaning of Solvent Resistant Organic Coatings (Series 82), TASK 20-30-82-910-801 for the complete list of Series 82 solvent, B01002.

2) Wipe the surface with a new, clean, dry cloth to remove excess solvent; 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 57-44-03-160-003

(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 Series 92 solvent, B01012 to clean all surfaces and sealant from which you removed the topcoat.

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1) Refer to Final Cleaning Prior to General Sealing (Series 92), TASK 20-30-92-910-801 for the complete list of Series 92 solvent, B01012.

(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 57-44-03-160-001

(6) Immediately before you apply the sealant, clean the surface with a clean cotton wiper, G00034 moist with Series 92 solvent, B01012.

(a) Refer to Final Cleaning Prior to General Sealing (Series 92), TASK 20-30-92-910-801 for the complete list of Series 92 solvent, B01012.

(b) Wipe the surface with a clean dry cloth to remove excess solvent; do not let the solvent become dry on the surface.

(c) Do not touch the cleaned area with your fingers or allow the surface to become contaminated.

G. Wing Leading Edge Seal Ribs and Forward Spar Repair - Fillet Seals

SUBTASK 57-44-03-390-002

(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 51-31-00-390-804.

(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; use a clean cotton wiper, G00034.

2) 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.

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H. Apply a Corrosion Resistant Finish (Topcoat)

SUBTASK 57-44-03-390-003

(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 Series 93 solvent, B01013 to clean all surfaces and sealant before you apply the topcoat.

1) Wipe the surface with a clean, dry cloth to remove excess solvent; 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 57-44-03-390-004

(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.

I. 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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Leadng Edge Seal Rib Fillet Seals
Figure 801/57-44-03-990-803 (Sheet 1 of 5)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

1 FILLET SEAL BMS 5-142
2 DO NOT FILL WITH SEALANT, KEEP OPEN, DRAINAGE PATH
3 TOOL HOLE SEAL BMS 5-142
4 INJECTION SEAL BMS 5-142
5 PANEL GAPS SEAL BMS 5-95

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Leadng Edge Seal Rib Fillet Seals
Figure 801/57-44-03-990-803 (Sheet 2 of 5)

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B-B

B-B

488221 S0000146256_V2

Leadng Edge Seal Rib Fillet Seals
Figure 801/57-44-03-990-803 (Sheet 3 of 5)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

C-C

C-C

488278 S0000146257_V2

Leadng Edge Seal Rib Fillet Seals
Figure 801/57-44-03-990-803 (Sheet 4 of 5)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

D-D

488688 S0000146260_V2

Leadng Edge Seal Rib Fillet Seals
Figure 801/57-44-03-990-803 (Sheet 5 of 5)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TRAILING EDGE FLAPS - CORROSION PREVENTION

1. General

A. The flap tracks, track attachment fittings on rear spar, and actuator rods are susceptible to corrosion since they are in exposed positions. Damaged finishes of these fittings, flap skin panels, and ribs are caused by exposure to the weather and runway debris. Service wear also causes galling of the moveable bearing surfaces.

B. Corrosion can occur at the main flap track attachments at the wing rear spar.

C. Stress corrosion cracks can occur in aft flap track support fittings.

D. Stress corrosion cracks can occur in the inboard and outboard trailing edge flap tracks. Some of these cracks are found in the web at the aft end of the tracks.

E. Corrosion and stress corrosion cracking can occur in the outboard main flap carriage spindle.

F. Corrosion and subsequent failure of the thrust bearing retention bolts has been found on the main flap carriage.

G. Corrosion has been found on the midflap rear spar in the vicinity of the cutout for the foreflap track.

H. Stress corrosion cracking has been found on the outboard flap carriage spindle located aft of the slider bearing.

I. Corrosion can occur in the rear spar backup fitting of the right-hand outboard trailing edge midflap at WBL 399.8. Cracks are likely to begin in the backup fitting and propagate until the fitting fails. Cracks have been found in the rear spar adjacent to the backup fitting.

J. Corrosion and stress corrosion cracks have been found in the rib flanges and support fittings and brackets at WBL 74.50, 82.58, 84.96, 117.10 and 159.50 in the inboard midflaps.

K. Corrosion has been found on the front spar lower chord of the inboard trailing edge midflap. Corrosion extended from WBL 71.24 to WBL 80.0 on the forward horizontal and vertical flange.

L. Stress corrosion cracks have been found in the gimbal supports and indexing plate of the inboard trailing edge midflap.

M. Heavy corrosion has been found on the inner diameter of the foreflap guide bushings.

N. Heavy corrosion has been found in the outboard trailing edge flap carriage retainer bolt. Stress corrosion crack has also been found on the retainer bolts.

O. Corrosion can occur on the flap drive ballscrew. Although The ballscrew has a thin dense chrome plating, corrosion will start if this plating is not continuous, because the base metal has no resistance to corrosion.

P. Delamination and corrosion of the skin and honeycomb have been found on the inboard and outboard trailing edge flaps. Cracks in the edge potting material permit moisture to go into the aft flaps.

Q. Corrosion has been found on the trailing edge flap track roller contact surfaces. Many airplanes operate in areas with harsh winter environments where runway deicing compounds are frequently used. When exposed to moisture in the form of slush, rain, deicing fluids, or airplane washing, the grease is washed from the track, and it leaves the unpainted wear surfaces unprotected. The best way to protect the flap track wear surfaces from corrosion is to increase the frequency of cleaning and application of BMS 3-24 grease.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-50-00-910-801

2. Trailing Edge Flaps - 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 prevent the accumulation of moisture or corrosive products in the structure of the door openings and surrounding structure to minimize the occurrence of corrosion.

(2) 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.

(3) 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
51-21-91 P/B 701	CORROSION INHIBITING COMPOUND - CLEANING/PAINTING

C. Consumable Materials

Reference	Description	Specification
D00633	Grease - Aircraft General Purpose	BMS3-33
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23

D. Location Zones

Zone	Area
571	Left Wing - Fixed Trailing Edge
671	Right Wing - Fixed Trailing Edge

E. Procedure

SUBTASK 57-50-00-370-001

CAUTION

DO NOT APPLY CORROSION-INHIBITING COMPOUND ON GREASE JOINTS, OR SEALED BEARINGS. THESE COMPOUNDS REMOVE GREASE AND OTHER LUBRICANTS. THEY ARE PENETRATING COMPOUNDS. THEY WILL MOVE AROUND THE SEALS AND INTO THE BEARINGS. THIS WILL CAUSE DAMAGE TO THE BEARINGS, AND JOINTS.

(1) Apply corrosion inhibiting compound, G00009 annually to the areas in flap tracks which are susceptible to corrosion.

(a) Apply corrosion inhibiting compound, G00009 over the full interior surface of the flap tracks at every D check.

SUBTASK 57-50-00-370-002

(2) Apply corrosion inhibitor to broken finishes on flap skin panels and movable flap track fairings as necessary.

(a) Treat the local areas where gouges or scratches have occurred at first opportunity consistent with the maintenance schedule.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 57-50-00-200-001

(3) Inspect the main flap carriage thrust bearing retention bolts periodically for evidence of corrosion.

(a) If there is corrosion, remove the bolts for further examination.

(b) Reinstall bolts with wet primer.

SUBTASK 57-50-00-200-002

(4) Examine the interior of the midflap structure near the foreflap track for corrosion.

(a) Spray the area with water displacing corrosion inhibiting compound.

(b) Add a drain hole in the skin adjacent to the rear spar, if necessary.

SUBTASK 57-50-00-370-003

(5) After application of corrosion inhibitor, regrease all grease fittings in the treated areas.

SUBTASK 57-50-00-370-004

(6) Apply corrosion inhibitor to retard the corrosion process after cleaning off minor corrosion at the main flap track support fittings.

SUBTASK 57-50-00-370-005

(7) Clean off minor corrosion on the aft flap track support fitting. Refinish the areas and apply corrosion inhibitor.

SUBTASK 57-50-00-370-006

(8) Do these steps to prevent corrosion pitting and stop small pits that may not be seen visually on the trailing edge flap track roller contact surfaces.

NOTE: Corrosion pitting occurs frequently especially during winter operations on runways where anti-ice compounds are used.

(a) Clean debris (i.e. sand, corrosion products, residual grease, etc.) from track surfaces.

NOTE: The purpose is to remove salt or sand contaminants from surface and to expose corrosion pits.

(b) Allow surfaces to dry.

(c) Examine the track flanges for visible cracks.

(d) Apply corrosion inhibiting compound, G00009 to entire flange surface.

(e) Allow corrosion inhibiting compound, G00009 to set for a minimum of 30 minutes to ensure penetration into pits.

1) Wipe excess compound off the track.

NOTE: It is important to remove all surface compound residue so that subsequently applied grease does not readily run/wash off.

(f) Apply grease, D00633 to all wear surfaces of the track.

1) Periodically check surfaces of flanges and repeat procedure to preclude further pitting attack to track.

NOTE: Hand application of grease on the outboard flap tracks can generally be accomplished without removing the flap track fairings.

(g) Refer to Structural Repair Manual to remove localized corrosion.

SUBTASK 57-50-00-370-007

(9) After cleaning areas with steam or high pressure water and detergent, apply the corrosion inhibitor and/or grease again.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

J15024 S0000167875_V2

Trailing Edge Flaps - Corrosion Prevention
Figure 201/57-50-00-990-801 (Sheet 1 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

OUTBOARD FLAP OUTBOARD FLAP TRACK

B

FLAP TRACK

C

J15036 S0000167876_V2

Trailing Edge Flaps - Corrosion Prevention
Figure 201/57-50-00-990-801 (Sheet 2 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

OUTBOARD AFT FLAP

E

J15039 S0000167877_V2

Trailing Edge Flaps - Corrosion Prevention
Figure 201/57-50-00-990-801 (Sheet 3 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

FIXED TRAILING EDGE UPPER PANEL - REMOVAL/INSTALLATION

1. General

A. This procedure contains these task:

(1) Removing inboard fixed trailing edge upper panels.

(2) Installing inboard fixed trailing edge upper panels.

TASK 57-50-01-000-801

2. Inboard Fixed Trailing Edge Upper Panel - Removal

Figure 401

A. References

Reference	Title
27-51-00-040-801	Trailing Edge Flap System Deactivation (P/B 201)
27-61-00-800-802	Remove Pressure from the Spoiler Hydraulic Systems A and B (P/B 201)
32-00-01-480-801	Landing Gear Downlock Pins Installation (P/B 201)

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-1744	Lock Set - Inboard Ground Spoiler Actuator (Contains 4 Lock Assemblies) Part #: C27046-13 Supplier: 81205 Opt Part #: C27046-1 Supplier: 81205

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 Removal

SUBTASK 57-50-01-480-003

> **WARNING** MAKE SURE THAT THE DOWNLOCK PINS ARE INSTALLED IN ALL OF 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.

SUBTASK 57-50-01-860-003

(2) Extend the inboard main flaps.

SUBTASK 57-50-01-860-004

(3) Extend spoilers to get access to the upper panels.

ECCN 9E991 BOEING PROPRIETARY - See title page for details

SUBTASK 57-50-01-040-003

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

SUBTASK 57-50-01-430-001

(5) Install lock-lock set, SPL-1744, on the actuator for the applicable ground spoiler.

SUBTASK 57-50-01-864-001

(6) Do this task: Remove Pressure from the Spoiler Hydraulic Systems A and B, TASK 27-61-00-800-802.

E. Inboard Fixed Trailing Edge Upper Panel Removal

SUBTASK 57-50-01-010-003

(1) Remove the upper panel [1].

(a) Remove the bolts [7], washers [8], washers [9], and nuts [10] from the upper links of tie rod [11] and tie rod [12].

1) Disconnect the upper links of the tie rod [11] and tie rod [12] from the upper panel [1].

(b) Remove the retainers [3] (2 locations) on serrated plate.

(c) Remove the bolts [5], collars [6], shim [4].

(d) Remove all sealant from the upper surface of the panel to expose the fasteners attaching the ribs to the panel.

1) Remove all fasteners that attach the panel to the rib, skin, and wing-to-body fillet fairing adjacent to the body.

(e) Remove the upper panel [1].

SUBTASK 57-50-01-010-002

(2) Remove the upper panel [2].

(a) Remove the bolts [13], washers [14], washers [15], and nuts [16].

1) Disconnect the upper link of the tie rod [17] from the upper panel [2].

(b) Remove the bolts [18], washers [19], washers [20], and nuts [22] from the lugs on both side of upper panel [2].

(c) Remove the washer [25], nut [24], and jumper assembly [23].

(d) Remove all sealant from the upper surface of the panel to expose the fasteners attaching the ribs to the panel.

1) Remove all fasteners that attach the panel to the rib, skin, and wing-to-body fillet fairing adjacent to the body.

(e) Remove the upper panel [2].

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

J68266 S0000173707_V2

Inboard Fixed Trailing Edge Upper Panel Installation
Figure 401/57-50-01-990-802 (Sheet 1 of 5)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Inboard Fixed Trailing Edge Upper Panel Installation
Figure 401/57-50-01-990-802 (Sheet 2 of 5)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

J70259 S0000173709_V2

Inboard Fixed Trailing Edge Upper Panel Installation
Figure 401/57-50-01-990-802 (Sheet 3 of 5)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Inboard Fixed Trailing Edge Upper Panel Installation
Figure 401/57-50-01-990-802 (Sheet 4 of 5)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

J70875 S0000173711_V3

Inboard Fixed Trailing Edge Upper Panel Installation
Figure 401/57-50-01-990-802 (Sheet 5 of 5)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-50-01-400-801

3. Inboard Fixed Trailing Edge Upper Panel - Installation

Figure 401

A. References

Reference	Title
27-51-00-440-801	Trailing Edge Flap System Reactivation (P/B 201)
57-50-01-820-801	Inboard Fixed Trailing Edge Upper Panel Adjustment (P/B 501)

B. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95
C50056	Compound - Corrosion Inhibiting Material, Nondrying Resin Mix	BMS3-27
G50237	Compound - Corrosion Inhibiting, Non-drying - Cor-Ban 27L	BMS3-38

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. Inboard Fixed Trailing Edge Upper Panel Installation

SUBTASK 57-50-01-860-005

> **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 ailerons, flaps, and spoilers will not operate.

SUBTASK 57-50-01-400-001

> **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.

> **WARNING** DO NOT GET THIS MATERIAL IN YOUR MOUTH, EYES, OR ON YOUR SKIN. DO NOT BREATHE THE FUMES FROM THIS MATERIAL. PUT ON A RESPIRATOR, EYE PROTECTION (GOGGLES, OR OTHER APPROVED PROTECTION), AND GLOVES BEFORE YOU USE THIS MATERIAL. MAKE SURE THAT THERE IS SUFFICIENT AIRFLOW. KEEP THIS MATERIAL AWAY FROM SPARKS, FLAME, AND HEAT. THIS MATERIAL CAN CAUSE INJURIES TO PERSONNEL AND DAMAGE TO EQUIPMENT.

(2) Install the upper panel [1].

(a) Put the upper panel [1] in place.

(b) Connect the upper links of the tie rod [11] and tie rod [12] to the upper panel [1].

ECCN 9E991 BOEING PROPRIETARY - See title page for details

1) Install the bolts [7], washers [8], washers [9], and nuts [10].

(c) Install the retainers [3] with Cor-Ban 27L Compound, G50237, or Mastinox 6856 K, C50056, (2 locations) on serrated plate.

(d) Install the bolts [5], collars [6], and shim [4] to attach the upper panel [1] to rear spar.

(e) Install the fasteners to attach the panel to the rib, skin, and wing-to-body fillet fairing adjacent to the body.

1) Apply sealant, A00247, prior to installing the fasteners.

SUBTASK 57-50-01-400-002

(3) Install the upper panel [2].

(a) Put the upper panel [2] in place.

(b) Connect the upper links of the tie rods [17] to the upper panel [2].

1) Install the bolts [13], washers [14], washers [15], and nuts [16].

(c) Install the bolts [18], washers [19], washers [20], and nuts [22] to the both sides of the upper panel [2].

(d) Install the washer [25], nut [24], and jumper assembly [23].

(e) Install the fasteners to attach the panel to the rib, skin, and wing-to-body fillet fairing adjacent to the body.

1) Apply sealant, A00247, prior to installing the fasteners.

SUBTASK 57-50-01-830-001

(4) Do this task: Inboard Fixed Trailing Edge Upper Panel Adjustment, TASK 57-50-01-820-801.

E. Put the Airplane Back to Its Usual Condition

SUBTASK 57-50-01-440-001

WARNING	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.

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

SUBTASK 57-50-01-860-006

(2) Retract the inboard trailing edge flaps.

SUBTASK 57-50-01-090-001

(3) Remove the spoiler lock-set tools.

SUBTASK 57-50-01-860-007

(4) Retract the inboard spoilers.

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

FIXED TRAILING EDGE UPPER PANEL - ADJUSTMENT/TEST

1. General

A. This procedure has one task: the adjustment of the inboard fixed trailing edge upper panels.

TASK 57-50-01-820-801

2. Inboard Fixed Trailing Edge Upper Panel Adjustment

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. 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

C. Prepare for the Adjustment

SUBTASK 57-50-01-480-001

WARNING MAKE SURE THAT THE DOWNLOCK PINS ARE INSTALLED IN ALL OF 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.

SUBTASK 57-50-01-040-001

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

D. Procedure

SUBTASK 57-50-01-860-001

(1) Make sure the flap is in the retracted position.

SUBTASK 57-50-01-220-001

(2) Measure the mismatch between the fixed upper panels [1], [2] and the upper surface of the inboard flap assembly.

SUBTASK 57-50-01-820-001

(3) If the mismatch is not in the limit of 0.0050 in. (0.127 mm) - 0.1100 in. (2.794 mm), adjust the applicable upper panel:

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

(b) Extend the trailing edge flaps to get access to the rods [3], [4], [6] for the upper and lower panels. To extend them, do this task: Extend the Trailing Edge Flaps, TASK 27-51-00-860-803.

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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(d) Adjust the fixed upper panel [1]:

1) Loosen the retainers [5] on serrated plate [12].

2) Remove or loosen the lower panel tie rod [6] which is attached to the upper panel support beam.

3) Loosen the nut [10] at each end of the upper panel tie rod [3].

4) Loosen the jam nut [11] for the upper panel tie rod [3].

5) Adjust upper panel tie rod [3] and serrated plate [12] to set the gap between the fixed upper panel [1] and the flap upper surface to within the limit.

(e) Adjust the fixed upper panel [2]:

1) Loosen the nut [17] at each end of the upper panel tie rod [4].

2) Loosen the jam nut [13] for the upper panel tie rod [4].

3) Adjust upper panel tie rod [4] to set the gap between the fixed upper panel [2] and the flap upper surface to within the limit.

(f) Tighten all fasteners loosened or removed in steps for adjusting the upper panel [1], [2].

E. 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.

SUBTASK 57-50-01-860-002

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

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

J15019 S0000169899_V2

Inboard Fixed Upper Panel Adjustment
Figure 501/57-50-01-990-801 (Sheet 1 of 5)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

J15103 S0000169900_V3

Inboard Fixed Upper Panel Adjustment
Figure 501/57-50-01-990-801 (Sheet 2 of 5)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

A-A

J15700 S0000169901_V3

Inboard Fixed Upper Panel Adjustment
Figure 501/57-50-01-990-801 (Sheet 3 of 5)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

A-A

3039998 S0000808085_V1

Inboard Fixed Upper Panel Adjustment
Figure 501/57-50-01-990-801 (Sheet 4 of 5)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

J16159 S0000169902_V3

Inboard Fixed Upper Panel Adjustment
Figure 501/57-50-01-990-801 (Sheet 5 of 5)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

FIXED TRAILING EDGE LOWER PANEL

1. General

A. This procedure contains these tasks:

(1) Removing inboard fixed trailing edge lower panels.

(2) Installing inboard fixed trailing edge lower panels.

TASK 57-50-02-000-801

2. Inboard Fixed Trailing Edge Lower Panel - Removal

(Figure 401, Figure 402, Figure 403)

A. References

Reference	Title
27-51-00-040-801	Trailing Edge Flap System Deactivation (P/B 201)
27-51-18-000-801	Inboard Flap Support Forward Fairing Removal (P/B 401)
32-00-01-480-801	Landing Gear Downlock Pins Installation (P/B 201)
54-52-04-010-802	Aft Fairing Removal (Engine Not Removed) (P/B 401)

B. Location Zones

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

C. Prepare for the Removal

SUBTASK 57-50-02-480-002

> **WARNING** MAKE SURE THAT THE DOWNLOCK PINS ARE INSTALLED IN ALL OF 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.

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.

SUBTASK 57-50-02-020-001

(4) If you remove the 551EB/651EB panels, do this task: Inboard Flap Support Forward Fairing Removal, TASK 27-51-18-000-801.

SUBTASK 57-50-02-020-002

(5) If you remove the 551GB/651GB panels, do this task: Aft Fairing Removal (Engine Not Removed), TASK 54-52-04-010-802.

D. Inboard Fixed Trailing Edge Lower Panel Removal (551FB/651FB)

SUBTASK 57-50-02-010-001

(1) Remove th lower panel [1] as follows (Figure 401):

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(a) Put a rubber pad or rag on top of the door's top edge to prevent damage to the main landing gear wing door.

(b) Disconnect wire bundle on aft end of lower panel [1] from the brackets.

(c) Remove nut [7], washer [6], washer [5], washer [4], washer [3], and bolt [2].

NOTE: Make a note of the location of all of the washers.

1) Disconnect the upper link of tie rod [8] and tie rod [9].

(d) Remove nut [15], washer [14], washer [13], washer [12], washer [11], and bolt [10].

NOTE: Make a note of the location of all of the washers.

1) Disconnect the upper link of tie rods [16].

(e) Remove nut [22], washer [21], washer [20], washer [19], washer [18], and bolt [17].

NOTE: Make a note of the location of all of the washers.

1) Disconnect the upper link of tie rods [23].

(f) Remove lower panel [1].

E. Inboard Fixed Trailing Edge Lower Panel Removal (551EB/651EB)

SUBTASK 57-50-02-010-002

(1) Remove the MLG attach fitting access panel [31] as follows (Figure 402):

(a) Remove the bolts [33] and bolts [32] from the MLG attach fitting access panel [31].

(b) Remove the bolts [34] and bolts [35] from the MLG attach fitting access panel [31].

LOM 407, 411, 412, 415, 416, 420, 422-426; LOM 402, 404, 406 POST SB 737-57-1284

(c) Remove the bolts [36] and washers [37].

LOM ALL

(d) Remove the bolts [52] and bolts [53].

(e) Remove the screw [41], washer [42], and nut-clip [44] to disconnect the clamp [43] from the bracket.

(f) Remove the screw [38] and washer [39] to disconnect the clamp [40] from the bracket.

(g) Remove the bolts [46], washers [47], washers [48] (if installed), washers [49] (if installed), washers [50], and nuts [51] from the tie rods [45].

1) Disconnect the tie rods [45] from MLG attach fitting access panel [31].

(h) Remove the MLG attach fitting access panel [31].

F. Inboard Fixed Trailing Edge Lower Panel Removal (551GB/651GB)

SUBTASK 57-50-02-010-003

(1) Remove the inboard fixed trailing edge panel [61] as follows (Figure 403):

(a) Remove the bolts [62], bolts [63], bolts [64], bolt [65], and bolts [66] from the inboard fixed trailing edge panel [61].

(b) Remove the nuts [71], washers [70], bushings [69], washers [68], and bolts [67] to disconnect the tie rods [72] from the brackets.

(c) Remove the nut [78], washer [77], washer [76] (if installed), washer [75] (if installed), washer [74], and bolt [73] to disconnect the tie rod [79] from the bracket.

(d) Remove the bolt [80], washer [81], bushing [82], washer [83] (if installed), washer [84] (if installed), washer [85], and nut [86] to disconnect the tie rod [87] from bracket.

(e) Remove the bolts [88], bolts [89], and washers [90].

ECCN 9E991 BOEING PROPRIETARY - See title page for details

(f) Remove the inboard fixed trailing edge panel [61].

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

1555079 S0000281992_V4

Inboard Fixed Trailing Edge Lower Panel Installation (551FB/651FB)
Figure 401/57-50-02-990-801 (Sheet 1 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

1555111 S0000281993_V2

Inboard Fixed Trailing Edge Lower Panel Installation (551FB/651FB)
Figure 401/57-50-02-990-801 (Sheet 2 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

1555403 S0000281994_V3

Inboard Fixed Trailing Edge Lower Panel Installation (551FB/651FB)
Figure 401/57-50-02-990-801 (Sheet 3 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

3056475 S0000820520_V1

Inboard Fixed Trailing Edge Lower Panel Installation (551EB/651EB)
Figure 402/57-50-02-990-802 (Sheet 1 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Inboard Fixed Trailing Edge Lower Panel Installation (551EB/651EB)
Figure 402/57-50-02-990-802 (Sheet 2 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Inboard Fixed Trailing Edge Lower Panel Installation (551EB/651EB)
Figure 402/57-50-02-990-802 (Sheet 3 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Inboard Fixed Trailing Edge Panel Installation (551GB/651GB)
Figure 403/57-50-02-990-805 (Sheet 1 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Inboard Fixed Trailing Edge Panel Installation (551GB/651GB)
Figure 403/57-50-02-990-805 (Sheet 2 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Inboard Fixed Trailing Edge Panel Installation (551GB/651GB)
Figure 403/57-50-02-990-805 (Sheet 3 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

TASK 57-50-02-400-801

3. **Inboard Fixed Trailing Edge Lower Panel - Installation**

(Figure 401, Figure 402, Figure 403)

A. **References**

Reference	Title
27-51-00-440-801	Trailing Edge Flap System Reactivation (P/B 201)
27-51-18-400-801	Inboard Flap Support Forward Fairing Installation (P/B 401)
54-52-04-410-802	Aft Fairing Installation (Engine Not Removed) (P/B 401)
57-50-02-820-801	Inboard Fixed Trailing Edge Lower Panel Adjustment (P/B 501)
SWPM 20-20-00 Paragraph 11	Electrical Bonding Through Fastener - Clearance Fit Hole
SWPM 20-20-00 Paragraph19.E	Bonding of a Fastener to a Composite Structure that has BMS8-278 or BMS8-336
SWPM 20-20-00, Paragraph 2.A.	Cleaning Procedure 1

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-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

C. **Consumable Materials**

Reference	Description	Specification
B00184	Solvent - Presealing, Cleaning Solvent	BMS11-7
C00064	Coating - Aluminum Chemical Conversion	BAC5719 Type II Class A (MIL-DTL-5541 Class 1A)
C00175	Primer - Urethane Compatible, Corrosion Resistant	BMS10-79 Type III
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
C00700	Coating - Protective Enamel (BAC 707 Gray Color, Gloss)	BMS10-60 Type I
C50139	Coating - Teflon Filled, Non Decorative, Brushable or Sprayable Material (Color - BAC 707 Grey)	BMS10-86 Type II
C50140	Coating - Teflon Filled, Non Decorative, Sprayable Material (Color - BAC 707 Grey)	BMS10-86 Type I

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(Continued)

Reference	Description	Specification
D50004	Compound - Antiseize	BMS3-28
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	AMS3819 Class 1 Grade A or B Form 1 (Supersede BMS15-5 CL A)
G50136	Compound - Corrosion Inhibiting, Non-drying Paste	BMS3-38

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

E. Inboard Fixed Trailing Edge Lower Panel Installation (551FB/651FB)

SUBTASK 57-50-02-860-002

(1) Make sure that the flaps do not operate.

SUBTASK 57-50-02-400-001

(2) Install the lower panel [1] as follows (Figure 401):

(a) Put a rubber pad or rag on top of the door's top edge to prevent damage to the main landing gear wing door.

(b) Put the lower panel [1] in its position.

NOTE: Use washers when necessary between each side of the lug and clevis. Decrease the total clearance to 0.030 in. (0.762 mm) maximum before you tighten the fastener. Use a minimum of one washer per side. Install the washers evenly. 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 per side.

(c) Connect the top links of tie rod [8] and tie rod [9].

1) Install bolt [2], washer [3], washer [4], washer [5], washer [6], and nut [7].

(d) Connect the top links of tie rods [16].

1) Install bolt [10], washer [11], washer [12], washer [13], washer [14], and nut [15].

(e) Connect the top links of tie rods [23].

1) Install bolt [17], washer [18], washer [19], washer [20], washer [21], and nut [22].

(f) Torque the nuts on the top end of turnbuckles 63 in-lb (7 N·m) to 67 in-lb (8 N·m).

(g) Attach the wire bundle on the aft end of lower panel [1] to the brackets.

(h) 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.

F. Inboard Fixed Trailing Edge Lower Panel Installation (551EB/651EB)

SUBTASK 57-50-02-410-001

(1) Install the MLG attach fitting access panel [31] as follows (Figure 402):

(a) Put the MLG attach fitting access panel [31] in place.

(b) Connect the tie rods [45] to the MLG attach fitting access panel [31].

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1) Install the bolts [46], washers [47], washers [50], and nuts [51] to the tie rods [45].
2) If it is necessary, install the washers [48] and washers [49] to reduce the total gap to 0.03 in. (0.76 mm).

(c) Install the screw [38] and washer [39] to connect the clamp [40] to the bracket.

(d) Install the screw [41], washer [42], and nut-clip [44] to connect the clamp [43] to the bracket.

(e) Apply primer, C00259, to the holes for the bolts [33], bolts [34], and bolts [35].
1) Apply compound, C00528, to the holes for the bolts [33], bolts [34], and bolts [35] and immediately install the bolts [33], bolts [34], and bolts [35].

(f) Install the bolts [32] as follows:
1) Clean the bolts [32] per abrasive cleaning method (SWPM 20-20-00, Paragraph 2.A.).
2) Apply corrosion inhibiting material, G50136, to the holes for the bolts [32] and immediately install the bolts [32].
a) Tighten the bolts [32] to 40 in-lb (4.5 N·m).
3) Measure the electrical bonding resistance between the head of the bolts [32] and MLG attach fitting access panel [31] (SWPM 20-20-00 Paragraph 11).
a) Use an intrinsically safe approved bonding meter, COM-1550.
b) Make sure that the resistance is 1.0 milliohms (0.001 ohms) or less.
4) Manually apply coating, C00064.
a) Apply primer, C00259, and coating, C00700.

LOM 407, 411, 412, 415, 416, 420, 422-426; LOM 402, 404, 406 POST SB 737-57-1284

(g) Apply compound, D50004, to the threads of the bolts [36].
1) Install the bolts [36] and washers [37].

LOM ALL

(h) Apply primer, C00259, to the holes for the bolts [52].
1) Apply corrosion inhibiting material, G50136, to the holes for the bolts [52] and immediately install the bolts [52].

(i) Install the bolts [53] as follows:
1) Clean the holes for the bolts [53] per abrasive cleaning method (SWPM 20-20-00, Paragraph 2.A.).
2) Clean the bolts [53] with cotton wiper, G00034, soaked in solvent, B00184.
3) Install the bolts [53].
4) Measure the electrical bonding resistance between the head of the bolts [53] and structure (SWPM 20-20-00 Paragraph 11).
a) Use an intrinsically safe approved bonding meter, COM-1550.
b) Make sure that the resistance is 1.0 milliohms (0.001 ohms) or less.
5) Manually apply coating, C00064.
a) Apply one coat of primer, C00175.
b) Apply coating, C50139, or coating, C50140.

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SUBTASK 57-50-02-820-002

(2) Do this task: Inboard Fixed Trailing Edge Lower Panel Adjustment, TASK 57-50-02-820-801.

G. Inboard Fixed Trailing Edge Lower Panel Installation (551GB/651GB)

SUBTASK 57-50-02-410-003

(1) Install the inboard fixed trailing edge panel [61] as follows (Figure 403):

(a) Put the inboard fixed trailing edge panel [61] in place.

(b) Connect the tie rod [87] to the bracket.

1) Install the bolt [80], washer [81], bushing [82], washer [85], and nut [86] to the tie rod [87].

2) If it is necessary, install the washer [83] and washer [84] to reduce the total gap to 0.03 in. (0.76 mm).

(c) Connect the tie rod [79] to the bracket.

1) Install the nut [78], washer [77], washer [74], and bolt [73] to the tie rod [79].

2) If it is necessary, install the washer [76] and washer [75] to reduce the total gap to 0.03 in. (0.76 mm).

(d) Connect the tie rods [72] to the brackets.

1) Install the nuts [71], washers [70], bushings [69], bolts [67], and washers [68] to the tie rods [72].

(e) Apply primer, C00259, to the holes of the bolts [62], bolts [63], bolts [64], and bolt [65].

1) Apply compound, C00528, to the holes of the bolts [62], bolts [63], bolts [64], and bolt [65] and immediately install the bolts [62], bolts [63], bolts [64], and bolt [65].

(f) Apply compound, C00528, to the holes of the bolts [66] and immediately install the bolts [66].

(g) Apply primer, C00259, to the holes for the bolts [88].

1) Apply compound, C00528, to the holes for the bolts [88] and immediately install the bolts [88].

(h) Install the bolts [89] and washers [90] as follows:

1) Clean the inboard fixed trailing edge panel [61] per abrasive cleaning method (SWPM 20-20-00 Paragraph19.E).

2) Clean the washers [90] and head of the inboard fixed trailing edge panel [61] with cotton wiper, G00034, soaked in solvent, B00184.

3) Install the bolts [89] and washers [90].

4) Measure the electrical bonding resistance between the head of thebolts [89] and structure (SWPM 20-20-00 Paragraph19.E).

a) Use an intrinsically safe approved bonding meter, COM-1550.

b) Make sure that the resistance is 500 milliohms (0.5 ohms) or less.

SUBTASK 57-50-02-820-003

(2) Do this task: Inboard Fixed Trailing Edge Lower Panel Adjustment, TASK 57-50-02-820-801.

H. Put the Airplane Back to Its Usual Condition

SUBTASK 57-50-02-420-001

(1) For the 551EB/651EB panels, do this task: Inboard Flap Support Forward Fairing Installation, TASK 27-51-18-400-801.

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SUBTASK 57-50-02-420-002

(2) For the 551GB/651GB panels, do this task: Aft Fairing Installation (Engine Not Removed), TASK 54-52-04-410-802.

SUBTASK 57-50-02-440-001

WARNING	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.

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

SUBTASK 57-50-02-860-003

(4) Retract the inboard trailing edge flaps.

END OF TASK

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FIXED TRAILING EDGE LOWER PANEL - ADJUSTMENT/TEST

1. General

A. This procedure has this task:

(1) An adjustment of the inboard fixed trailing edge lower panel.

TASK 57-50-02-820-801

2. Inboard Fixed Trailing Edge Lower Panel Adjustment

(Figure 501, Figure 502)

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)
27-51-18-000-801	Inboard Flap Support Forward Fairing Removal (P/B 401)
27-51-18-000-802	Inboard Flap Support Aft Fairing Removal (P/B 401)
27-51-18-400-801	Inboard Flap Support Forward Fairing Installation (P/B 401)
32-00-01-480-801	Landing Gear Downlock Pins Installation (P/B 201)

B. Consumable Materials

Reference	Description	Specification
G01048	Lockwire - MS20995C32, Corrosion Resistant Steel - 0.032 Inch (0.8128 mm) Diameter	NASM20995
G51674	Kit - Safety Cable, 321 CRES - 0.032 Inch (0.81 mm) Diameter, (Contains both Cable and Ferrule), 12 Inches Long	BACC13AT3K12

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 Adjustment

SUBTASK 57-50-02-480-003

> **WARNING** MAKE SURE THAT THE DOWNLOCK PINS ARE INSTALLED IN ALL OF 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.

SUBTASK 57-50-02-040-002

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

E. Main Landing Gear Attach Fitting Access Panel Adjustment (551EB/651EB)

SUBTASK 57-50-02-220-001

(1) Measure the mismatch between the MLG attach fitting access panel [3] and adjacent panels (View A-A, Figure 501).

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SUBTASK 57-50-02-220-002

(2) Measure the mismatch between the MLG attach fitting access panel [3] and inspar wing (View B-B, Figure 501).

SUBTASK 57-50-02-820-001

(3) If the mismatch is not in the limit for the following measurements, adjust the MLG attach fitting access panel [3]:

- 0.0600 ±0.0300 in. (1.524 ±0.762 mm) between the MLG attach fitting access panel [3] and adjacent panels
- 0.0600 ±0.0400 in. (1.524 ±1.016 mm) between the MLG attach fitting access panel [3] and inspar wing.

(a) To get access to the tie rod [1], do these steps:

1) Do this task: Inboard Flap Support Forward Fairing Removal, TASK 27-51-18-000-801.

2) Do this task: Inboard Flap Support Aft Fairing Removal, TASK 27-51-18-000-802.

(b) Adjust the MLG attach fitting access panel [3]:

1) Loosen the jam nuts [2] on the tie rod [1].

2) Adjust the MLG attach fitting access panel [3] to set the gap between the MLG attach fitting access panel [3] and adjacent panels or inspar wing to within the limit.

3) Tighten the jam nuts [2].

(c) Make sure that the mismatch is in the limits.

SUBTASK 57-50-02-420-003

(4) Do this task: Inboard Flap Support Forward Fairing Installation, TASK 27-51-18-400-801.

SUBTASK 57-50-02-220-003

(5) Measure the distance between the lower surface of the inboard flap and blade seal [6] (View C-C, Figure 501).

SUBTASK 57-50-02-220-004

(6) If the distance between the inboard flap and blade seal [6] is not in the limit of 0.00 ±0.03 in. (0.00 ±0.76 mm), adjust the position of the blade seal [6]:

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

(b) Extend the trailing edge flaps to get access to the fasteners for the seal retainer [5], do this task: Extend the Trailing Edge Flaps, TASK 27-51-00-860-803.

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

(d) Loosen the screws [4] that attach the seal retainer [5] to the MLG attach fitting access panel [3].

(e) Move the seal retainer [5] to the correct position.

1) Make sure that you move the blade seal [6] and seal retainer [5] together as a unit.

(f) Tighten the screws [4] that attach the seal retainer [5].

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

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

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

(j) Make sure that the distance between the inboard flap and blade seal [6] is in the limit.

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SUBTASK 57-50-02-820-004

(7) Do a check of the adjustment of the bulb seal [7] on the MLG attach fitting access panel [3] (View C-C, Figure 501):

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

(b) Extend the trailing edge flaps to get access to the fasteners for the seal retainer [5], do this task: Extend the Trailing Edge Flaps, TASK 27-51-00-860-803.

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

(d) Measure the distance from the aft end of the blade seal [6] to the aft end of the bulb seal [7].

(e) If the distance between the blade seal [6] and bulb seal [7] is not in the limit of 1.428 ±0.060 in. (36.271 ±1.524 mm), adjust the position of the bulb seal [7]:

1) Loosen the screws [4] that attach the seal retainer [5].

2) Adjust the position of the bulb seal [7] and seal retainer [5].

a) Make sure that you move the bulb seal [7] and seal retainer [5] together as a unit.

3) Tighten the screws [4].

F. Inboard Fixed Trailing Edge Lower Panel Adjustment (551GB/651GB)

SUBTASK 57-50-02-220-007

(1) Measure the mismatch between the inboard fixed trailing edge panel [11] and MLG attach fitting access panel (View A-A, Figure 502).

SUBTASK 57-50-02-220-006

(2) Measure the mismatch between the inboard fixed trailing edge panel [11] and inspar wing (View B-B, Figure 502).

SUBTASK 57-50-02-220-005

(3) Measure the mismatch between the inboard fixed trailing edge panel [11] and adjacent panel (View C-C, Figure 502).

SUBTASK 57-50-02-820-005

(4) If the mismatch is not in the limit for the following measurements, adjust the inboard fixed trailing edge panel [11]:

- 0.0900 in. (2.29 mm) between the inboard fixed trailing edge panel [11] and adjacent panel
- 0.0600 ±0.0400 in. (1.524 ±1.016 mm) between the inboard fixed trailing edge panel [11] and inspar wing.
- 0.0600 ±0.0300 in. (1.524 ±0.762 mm) between the inboard fixed trailing edge panel [11] and MLG attach fitting access panel.

(a) To get access to the tie rods [12], tie rod [14], and tie rod [16], do these steps:

1) Do this task: Inboard Flap Support Forward Fairing Removal, TASK 27-51-18-000-801.

2) Do this task: Inboard Flap Support Aft Fairing Removal, TASK 27-51-18-000-802.

(b) Adjust the inboard fixed trailing edge panel [11]:

1) Remove the safety cable or lockwire form the jam nuts [13] and jam nuts [17].

2) Loosen the jam nuts [13], jam nuts [15], and jam nuts [17] on the tie rods [12], tie rod [14], and tie rod [16].

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3) Adjust the inboard fixed trailing edge panel [11] to set the gap between the inboard fixed trailing edge panel [11] and adjacent panel or inspar wing or MLG attach fitting access panel to within the limit.

4) Tighten the jam nuts [13], jam nuts [15], and jam nuts [17].

(c) Make sure that the mismatch is in the limits.

(d) Install safety cable kit, G51674, or MS20995C32 lockwire, G01048, on the jam nuts [13] and jam nuts [17].

SUBTASK 57-50-02-420-004

(5) Do this task: Inboard Flap Support Forward Fairing Installation, TASK 27-51-18-400-801.

SUBTASK 57-50-02-020-003

(6) Measure the distance between the lower surface of the inboard flap and blade seal [20] (View D-D, Figure 502).

SUBTASK 57-50-02-820-006

(7) If the distance between the inboard flap and the blade seal [20] is not in the limit of 0.00 ±0.03 in. (0.00 ±0.76 mm), adjust the position of the blade seal [20]:

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

(b) Extend the trailing edge flaps to get access to the fasteners for the seal retainer [19], do this task: Extend the Trailing Edge Flaps, TASK 27-51-00-860-803.

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

(d) Loosen the screws [18] that attach the seal retainer [19] to the inboard fixed trailing edge panel [11].

(e) Move the seal retainer [19] to the correct position.

1) Make sure that you move the blade seal [20] and seal retainer [19] together as a unit.

(f) Tighten the screws [18] that attach the seal retainer [19].

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

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

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

(j) Make sure that the distance between the inboard flap and blade seal [20] is in the limit.

SUBTASK 57-50-02-820-007

(8) Do a check of the adjustment of the bulb seal [21] on the inboard fixed trailing edge panel [11] (View D-D, Figure 502).

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

(b) Extend the trailing edge flaps to get access to the fasteners for the seal retainer [19], do this task: Extend the Trailing Edge Flaps, TASK 27-51-00-860-803.

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

(d) Measure the distance from the aft end of the blade seal [20] to the aft end of the bulb seal [7].

(e) If the distance between the blade seal [20] and bulb seal [21] is not in the limit of 1.428 ±0.060 in. (36.271 ±1.524 mm), adjust the position of the bulb seal [21]:

1) Loosen the screws [18] that attach the seal retainer [19].

2) Adjust the position of the bulb seal [21] and the seal retainer [19].

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a) Make sure that you move the bulb seal [21] and seal retainer [19] together as a unit.

3) Tighten the screws [18].

G. Put the Airplane Back to Its Usual Condition

SUBTASK 57-50-02-440-002

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

SUBTASK 57-50-02-860-005

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

END OF TASK

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Main Landing Gear Attach Fitting Access Panel Adjustment
Figure 501/57-50-02-990-803 (Sheet 1 of 2)

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Main Landing Gear Attach Fitting Access Panel Adjustment
Figure 501/57-50-02-990-803 (Sheet 2 of 2)

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(TOP VIEW)

A

3056467 S0000820575_V1

Inboard Fixed Trailing Edge Panel Adjustment
Figure 502/57-50-02-990-804 (Sheet 1 of 3)

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Inboard Fixed Trailing Edge Panel Adjustment
Figure 502/57-50-02-990-804 (Sheet 2 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

C-C

D-D

3056629 S0000820661_V1

Inboard Fixed Trailing Edge Panel Adjustment
Figure 502/57-50-02-990-804 (Sheet 3 of 3)

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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.

(1) The replacement spoiler support fittings are different from the originally produced spoiler support fittings in two aspects:

(a) They require the installation of shims.

(b) They require mounting holes to be drilled by the operator.

TASK 57-71-01-000-801

2. Spoiler Support Fitting Repair

A. References

Reference	Title
12-40-00-100-801	Clean (Wet Wash) the External Surfaces of the Airplane (P/B 201)
12-40-00-100-803	Clean (Waterless Wash) the External Surfaces of the Airplane (P/B 201)
20-10-51-000-801	Flareless Tubing Assembly Removal (P/B 401)
20-10-51-000-802	Flareless Fittings in Pressurized, Strut, Fuel Tank, and Cargo Areas Installation (P/B 401)
20-40-11-760-801	Electrical Bonding (P/B 201)
27-62-12-000-801	Inboard Ground Spoiler Removal (P/B 401)
27-62-71-400-801	Inboard Ground Spoiler Actuator Installation (P/B 401)
29-09-00-860-802	Hydraulic Reservoirs Depressurization (P/B 201)

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-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

ECCN 9E991 BOEING PROPRIETARY - See title page for details

C. Consumable Materials

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS5-95

D. Location Zones

Zone	Area
734	Left Main Landing Gear
744	Right Main Landing Gear

E. 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

F. Prepare to Repair the Spoiler Support Fitting

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

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 57-71-01-020-001

> **WARNING**
> REMOVE ALL PRESSURE FROM THE HYDRAULIC SYSTEM BEFORE YOU START TO REMOVE HYDRAULIC TUBING. A PRESSURIZED SYSTEM CAN CAUSE INJURY.

(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.

> **WARNING**
> MAKE SURE THAT THE CORRECT TUBING CONNECTIONS CAN BE DETERMINED WHEN YOU INSTALL THE HYDRAULIC TUBING LATER. INCORRECT INSTALLATION OF THE HYDRAULIC TUBING CAN CAUSE INJURY TO PERSONS AND DAMAGE TO THE AIRPLANE.

(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 12-40-00-100-803.

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G. Procedure

SUBTASK 57-71-01-010-004

CAUTION	REMOVE AND INSTALL ONLY ONE SPOILER SUPPORT FITTING PER SPOILER EACH TIME. THE OTHER THREE SUPPORT FITTINGS SHOW THE NEW SUPPORT FITTING'S HOLE LOCATIONS. DAMAGE TO THE AIRPLANE WILL OCCUR IF THE SUPPORT FITTINGS ARE NOT LOCATED CORRECTLY.

CAUTION	IF THERE IS DAMAGE AT A SPOILER SUPPORT FITTING THAT IS NOT BEING REPLACED, THIS PROCEDURE CANNOT BE ACCOMPLISHED. THE SPOILER'S HINGE POINTS MUST CORRECTLY LOCATE THE HOLES OF THE SUPPORT FITTING BEING REPLACED. DAMAGE TO THE AIRPLANE WILL OCCUR IF THE SUPPORT FITTINGS ARE NOT LOCATED CORRECTLY.

(1) Replace one inboard spoiler support fitting.

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 four bolts and the four collars of the support fitting to be replaced.

1) If you are removing the inboard support fitting, remove the two washers for the jumper.

(b) To install the applicable inboard ground spoiler, do this task: Inboard Ground Spoiler Removal, TASK 27-62-12-000-801.

1) Attach the new support fitting to the spoiler hinge.

2) Do not attach the new support fitting to the support beam while installing the spoiler.

(c) Make the holes needed for attaching the support fitting to the support beam.

1) Temporarily hold the support fitting and the two shims against the aft side of the support beam.

2) On the forward side of the support beam, drill through the existing holes in the support beam and into the support fitting and shims.

(d) Attach the support fitting and shims to the support beam.

1) Install the bolts and collars.

a) Put the head of the bolts on the forward face of the support beam.

b) Fillet seal the fasteners with sealant, A00247.

2) If you are installing the inboard support fitting, also install the two washers and the jumper terminal on the forward side of the support beam.

NOTE: Put one washer between the head of the bolt and the jumper terminal. Put the other washer between the jumper terminal and the support beam.

a) Use an intrinsically safe approved bonding meter, COM-1550 to make sure that the resistance between the jumper and structure is no more than 0.003 ohms, (TASK 20-40-11-760-801).

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H. Put the Airplane Back to Its Usual Condition

SUBTASK 57-71-01-020-002

> **WARNING** MAKE SURE THAT THE CORRECT TUBING CONNECTIONS ARE DETERMINED WHEN YOU INSTALL THE HYDRAULIC TUBING. INCORRECT INSTALLATION OF THE HYDRAULIC TUBING CAN CAUSE INJURY TO PERSONS AND DAMAGE TO THE AIRPLANE.

(1) Connect the hydraulic tubes to the support beam, (TASK 20-10-51-000-802).

(a) Remove the caps from the ends of the hydraulic tubes.

SUBTASK 57-71-01-020-003

(2) Install the applicable ground spoiler actuator to the spoiler and the spoiler support fitting, do this task: Inboard Ground Spoiler Actuator Installation, TASK 27-62-71-400-801.

(a) Make sure that the hydraulic tubing that you removed does not leak after you pressurize the hydraulic systems.

SUBTASK 57-71-01-010-005

(3) Install 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

END OF TASK

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