

CHAPTER

54

**NACELLES/
PYLONS**



737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL

CHAPTER 54
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3	Oct 15/2023		224	Oct 15/2023		260	Oct 15/2024	
4	Oct 15/2024		225	Oct 15/2023		261	Oct 15/2024	
5	Oct 15/2024		226	Oct 15/2023		262	Oct 15/2024	
6	Oct 15/2024		227	Oct 15/2023		263	Oct 15/2024	
7	Oct 15/2019		228	Oct 15/2023		264	Oct 15/2024	
8	Oct 15/2024		229	Oct 15/2023		265	Oct 15/2024	
9	Jun 15/2020		230	Oct 15/2023		266	Oct 15/2024	
10	Feb 15/2024		231	Oct 15/2023		267	Oct 15/2024	
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13	Oct 15/2023		234	Oct 15/2023		270	Oct 15/2024	
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206	Oct 15/2023		242	Oct 15/2024		278	Oct 15/2024	
207	Oct 15/2023		243	Oct 15/2024		54-05-03		
208	Oct 15/2023		244	Oct 15/2024		201	Jun 15/2022	
209	Oct 15/2023		245	Oct 15/2024		202	Oct 15/2024	
210	Oct 15/2023		246	Oct 15/2024		203	Oct 15/2024	
211	Oct 15/2023		247	Oct 15/2024		204	Jun 15/2022	
212	Oct 15/2024		248	Oct 15/2024		205	Oct 15/2024	
213	Oct 15/2024		249	Oct 15/2024		206	Oct 15/2024	
214	Oct 15/2024		250	Oct 15/2024		207	Jun 15/2022	
215	Oct 15/2023		251	Oct 15/2024		208	Oct 15/2024	
216	Oct 15/2023		252	Oct 15/2024		209	Oct 15/2024	
217	Oct 15/2023		253	Oct 15/2024		210	Jun 15/2022	
218	Oct 15/2023		254	Oct 15/2024		211	Oct 15/2024	
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214	Oct 15/2024		250	Feb 15/2023		54-51-01		
215	Oct 15/2024		251	Oct 15/2024		401	Jun 15/2020	
216	Oct 15/2024		252	Oct 15/2024		402	Jun 15/2020	
217	Oct 15/2024		253	Jun 15/2024		403	Feb 15/2021	
218	Jun 15/2022		254	Jun 15/2024		404	Feb 15/2021	
219	Oct 15/2024		255	Oct 15/2023		405	Feb 15/2021	
220	Oct 15/2024		256	Oct 15/2024		406	Feb 15/2021	
221	Oct 15/2024		257	Oct 15/2024		407	Oct 15/2024	
222	Oct 15/2024		258	Oct 15/2023		408	Feb 15/2020	
223	Jun 15/2022		259	Jun 15/2024		409	Jun 15/2017	
224	Oct 15/2024		260	Jun 15/2024		410	Feb 15/2020	
225	Oct 15/2024		261	Oct 15/2023		411	Feb 15/2020	
226	Jun 15/2022		262	Oct 15/2024		412	Feb 15/2020	
227	Oct 15/2024		263	Oct 15/2024		413	Feb 15/2021	
228	Oct 15/2024		264	Oct 15/2023		414	Jun 15/2020	
229	Feb 15/2023		265	Jun 15/2024		415	Feb 15/2017	
230	Feb 15/2023		266	Jun 15/2024		416	Feb 15/2017	
231	Oct 15/2024		267	Jun 15/2024		417	Feb 15/2017	
232	Oct 15/2024		268	Oct 15/2024		418	Feb 15/2017	
233	Feb 15/2023		269	Oct 15/2024		419	Feb 15/2017	
234	Feb 15/2023		270	Jun 15/2024		420	Feb 15/2017	
235	Oct 15/2024		271	Jun 15/2024		421	Feb 15/2017	
236	Oct 15/2024		272	Jun 15/2024		422	Feb 15/2017	
237	Oct 15/2023		273	Jun 15/2024		423	Feb 15/2017	
238	Oct 15/2023		274	Oct 15/2024		424	Feb 15/2017	
239	Oct 15/2024		275	Oct 15/2024		54-51-01		
240	Oct 15/2024		276	Jun 15/2024		601	Jun 15/2020	
241	Oct 15/2023	54-51-01				602	Oct 15/2014	
242	Oct 15/2023		201	Feb 15/2021		603	Oct 15/2018	
243	Oct 15/2024		202	Oct 15/2017		604	Oct 15/2014	
244	Oct 15/2024		203	Oct 15/2017		54-51-02		
245	Jun 15/2024		204	Oct 15/2017		401	Feb 15/2015	
246	Feb 15/2023		205	Oct 15/2017		402	Oct 15/2019	
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R 407	Feb 15/2025		424	Oct 15/2024		425	Oct 15/2024	
408	Oct 15/2019		425	Oct 15/2024		426	Oct 15/2019	
409	Oct 15/2024		426	Oct 15/2019		54-51-04		
410	Oct 15/2024		54-51-03			601	Oct 15/2014	
411	Oct 15/2019		601	Oct 15/2014		602	Oct 15/2014	
412	Oct 15/2019		602	Oct 15/2014		603	Oct 15/2014	
54-51-02			603	Oct 15/2014		604	Oct 15/2014	
601	Oct 15/2014		604	Oct 15/2014		605	Oct 15/2024	
602	Oct 15/2014		605	Oct 15/2024		606	Oct 15/2024	
603	Oct 15/2024		606	Oct 15/2024		607	Oct 15/2015	
604	Oct 15/2024		607	Oct 15/2019		608	BLANK	
605	Oct 15/2015		608	BLANK		54-51-05		
606	BLANK		54-51-04			401	Feb 15/2015	
54-51-03			401	Oct 15/2019		R 402	Feb 15/2025	
401	Jun 15/2020		402	Oct 15/2019		R 403	Feb 15/2025	
402	Jun 15/2020		403	Oct 15/2019		404	Oct 15/2024	
403	Jun 15/2020		404	Oct 15/2019		405	Oct 15/2024	
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412	Oct 15/2024		413	Oct 15/2024		R 414	Feb 15/2025	
413	Oct 15/2024		414	Oct 15/2024		415	Jun 15/2023	
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416	Oct 15/2024		417	Oct 15/2019		R 418	Feb 15/2025	
417	Oct 15/2019		418	Oct 15/2024		419	Jun 15/2023	
418	Oct 15/2024		419	Oct 15/2024		420	BLANK	
419	Oct 15/2024		420	Oct 15/2019		54-51-05		
420	Oct 15/2019		421	Oct 15/2024		601	Oct 15/2014	
421	Oct 15/2024		422	Oct 15/2024		602	Oct 15/2014	
422	Oct 15/2024		423	Oct 15/2019		603	Oct 15/2014	

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605	Oct 15/2024		54-52-02			R 409	Feb 15/2025	
606	Oct 15/2015		401	Jun 15/2019		410	Oct 15/2024	
54-52-00			402	Jun 15/2019		411	Oct 15/2024	
201	Jun 15/2023		403	Oct 15/2024		412	Oct 15/2024	
202	Feb 15/2024		404	Oct 15/2024		413	Oct 15/2024	
203	Feb 15/2024		54-52-02			414	Oct 15/2024	
204	Feb 15/2024		501	Oct 15/2024		415	Oct 15/2024	
205	Feb 15/2024		502	Oct 15/2017		416	Oct 15/2024	
206	Feb 15/2024		54-52-03			417	Oct 15/2024	
207	Oct 15/2024		401	Jun 15/2020		418	Oct 15/2024	
208	Oct 15/2024		402	Oct 15/2024		419	Oct 15/2016	
209	Jun 15/2023		403	Oct 15/2024		420	Oct 15/2016	
210	Oct 15/2015		404	Oct 15/2024		R 421	Feb 15/2025	
211	Oct 15/2015		405	Oct 15/2024		422	Oct 15/2024	
212	Oct 15/2015		406	Jun 15/2020		423	Feb 15/2022	
213	Oct 15/2015		407	Oct 15/2024		424	Oct 15/2024	
214	Oct 15/2024		408	Oct 15/2024		425	Oct 15/2024	
215	Oct 15/2024		409	Oct 15/2024		426	Oct 15/2024	
216	Oct 15/2015		410	Jun 15/2020		427	Oct 15/2024	
217	Oct 15/2015		411	Jun 15/2023		428	Oct 15/2024	
218	BLANK		412	Oct 15/2024		429	Oct 15/2024	
54-52-01			413	Oct 15/2024		430	Oct 15/2024	
401	Oct 15/2022		414	Oct 15/2024		431	Oct 15/2024	
402	Oct 15/2022		415	Feb 15/2022		432	Oct 15/2016	
403	Oct 15/2024		416	BLANK		433	Oct 15/2016	
404	Oct 15/2024		54-52-03			434	Jun 15/2023	
405	Oct 15/2024		601	Oct 15/2021		435	Oct 15/2024	
406	Oct 15/2024		602	Oct 15/2021		436	Jun 15/2023	
407	Oct 15/2024		54-52-04			437	Oct 15/2024	
408	Oct 15/2024		401	Jun 15/2023		438	Oct 15/2024	
409	Oct 15/2024		402	Oct 15/2024		439	Oct 15/2024	
410	Oct 15/2024		403	Oct 15/2024		440	Oct 15/2024	
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445	Oct 15/2016		412	Oct 15/2024		404	Oct 15/2024	
446	Oct 15/2016		413	Oct 15/2024		405	Oct 15/2024	
54-52-04			414	Oct 15/2024		406	Oct 15/2024	
601	Oct 15/2014		415	Oct 15/2024		407	Oct 15/2023	
602	Oct 15/2014		416	Oct 15/2024		408	Oct 15/2023	
603	Oct 15/2014		417	Oct 15/2024		54-53-02		
604	Oct 15/2014		418	Oct 15/2024		601	Oct 15/2014	
54-52-06			54-52-09			602	Oct 15/2014	
401	Oct 15/2017		401	Jun 15/2018		54-54-00		
402	Oct 15/2017		402	Jun 15/2018		201	Feb 15/2021	
403	Oct 15/2017		403	Jun 15/2018		202	Feb 15/2021	
404	Oct 15/2017		404	Oct 15/2015		203	Oct 15/2022	
405	Oct 15/2024		405	Oct 15/2014		204	Feb 15/2021	
406	Oct 15/2024		406	Feb 15/2024		205	Oct 15/2022	
407	Oct 15/2024		407	Oct 15/2015		206	Feb 15/2021	
408	Oct 15/2024		408	Oct 15/2015		207	Oct 15/2022	
409	Oct 15/2024		54-53-01			208	Feb 15/2021	
410	Oct 15/2024		401	Jun 15/2023		54-54-00		
54-52-06			402	Oct 15/2023		601	Oct 15/2014	
701	Jun 15/2023		403	Oct 15/2023		602	Oct 15/2017	
702	Oct 15/2024		404	Oct 15/2024		603	Oct 15/2014	
703	Oct 15/2024		405	Oct 15/2024		604	Oct 15/2015	
704	Oct 15/2024		406	Oct 15/2024		54-54-01		
705	Oct 15/2024		407	Oct 15/2024		401	Oct 15/2024	
706	Oct 15/2024		408	Oct 15/2024		402	Oct 15/2024	
54-52-08			409	Oct 15/2024		403	Oct 15/2024	
401	Oct 15/2024		410	Oct 15/2024		404	Oct 15/2024	
402	Oct 15/2024		411	Jun 15/2024		405	Oct 15/2024	
403	Oct 15/2024		412	Oct 15/2023		406	Oct 15/2024	
404	Oct 15/2024		413	Oct 15/2024		407	Oct 15/2024	
405	Oct 15/2024		414	Oct 15/2024		408	Oct 15/2024	
406	Oct 15/2024		415	Oct 15/2024		409	Oct 15/2024	
407	Oct 15/2024		416	Oct 15/2023		410	Jun 15/2021	
408	Oct 15/2024		54-53-02			411	Jun 15/2021	
409	Oct 15/2024		401	Jun 15/2023		412	Oct 15/2024	
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415	Oct 15/2024		214	Oct 15/2023				
416	Oct 15/2024		215	Oct 15/2023				
417	Oct 15/2024		216	Oct 15/2023				
418	Oct 15/2024		217	Oct 15/2023				
419	Oct 15/2024		218	Oct 15/2024				
420	Oct 15/2024		219	Oct 15/2024				
421	Oct 15/2024		220	Oct 15/2023				
422	Oct 15/2024		54-55-02					
54-54-01			201	Oct 15/2022				
601	Oct 15/2024		202	Jun 15/2021				
602	Oct 15/2024		203	Oct 15/2017				
54-54-01			204	Oct 15/2024				
801	Nov 15/2022		205	Oct 15/2024				
802	Nov 15/2022		206	Oct 15/2024				
803	Jun 15/2016		207	Oct 15/2024				
804	Oct 15/2015		208	BLANK				
805	Oct 15/2014		54-55-02					
806	Jun 15/2016		601	Oct 15/2022				
807	Jun 15/2016		602	Feb 15/2020				
808	BLANK		603	Oct 15/2017				
54-54-02			604	BLANK				
601	Jun 15/2023		54-55-02					
602	BLANK		801	Oct 15/2022				
54-55-01			802	Feb 15/2020				
201	Jun 15/2021		803	Oct 15/2022				
202	Jun 15/2021		804	Feb 15/2020				
203	Feb 15/2017		805	Oct 15/2017				
204	Oct 15/2024		806	BLANK				
205	Oct 15/2024							
206	Oct 15/2017							
207	Oct 15/2017							
208	Feb 15/2017							
209	Oct 15/2023							
210	Oct 15/2023							
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EXTERNAL - GENERAL VISUAL: RIGHT FORWARD ENGINE MOUNT ASSEMBLY					204	LOM ALL
TASK 54-05-03-210-802						
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INTERNAL - GENERAL VISUAL: RIGHT STRUT ATTACH BOLTS AT FORWARD ENGINE MOUNTS					210	LOM ALL
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TASK 54-05-03-210-808						
INTERNAL - GENERAL VISUAL: LEFT STRUT TO WING ATTACHMENTS					229	LOM ALL
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INTERNAL - DETAILED: LEFT STRUT TO WING ATTACHMENTS TASK 54-05-03-211-803				245	LOM ALL
INTERNAL - DETAILED: RIGHT STRUT TO WING ATTACHMENTS TASK 54-05-03-211-804				249	LOM ALL
INTERNAL - GENERAL VISUAL: EXTERNAL - LEFT STRUT BOX TASK 54-05-03-210-811				253	LOM ALL
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INTERNAL - SPECIAL DETAILED: LOWER SPAR CHORD - CHORD ONLY TASK 54-05-02-250-806				217	LOM ALL
INTERNAL - SPECIAL DETAILED: LOWER SPAR CHORD - COMPRESSION PAD BRACKET - HORIZONTAL LEG TASK 54-05-02-250-807				218	LOM ALL
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INTERNAL - SPECIAL DETAILED: LOWER SPAR CHORD - COMPRESSION PAD BRACKET - VERTICAL LEG TASK 54-05-02-250-808				221	LOM ALL
INTERNAL - SPECIAL DETAILED: LOWER SPAR CHORD — TYPICAL FRAME DETAIL, VERTICAL LEG (DIRECTION 1) TASK 54-05-02-130-805				222	LOM ALL
EXTERNAL - SPECIAL DETAILED: LOWER SPAR CHORD - TYPICAL FRAME DETAIL, VERTICAL LEG (DIRECTION 2) TASK 54-05-02-250-809				224	LOM ALL

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INTERNAL - SPECIAL DETAILED: LOWER SPAR CHORD - TYPICAL FRAME DETAIL, HORIZONTAL LEG				226	LOM ALL
TASK 54-05-02-250-810					
INTERNAL - DETAILED: LOWER SPAR CHORD				227	LOM ALL
TASK 54-05-02-211-801					
INTERNAL - SPECIAL DETAILED: FORWARD ENGINE MOUNT BULKHEAD				231	LOM ALL
TASK 54-05-02-250-811					
INTERNAL - SPECIAL DETAILED: MID STRUT BULKHEAD				232	LOM ALL
TASK 54-05-02-250-812					
INTERNAL - SPECIAL DETAILED: SIDE SKIN CUTOUTS				234	LOM ALL
TASK 54-05-02-250-813					
INTERNAL - SPECIAL DETAILED: STRUT SIDE SKIN				236	LOM ALL
TASK 54-05-02-130-806					
INTERNAL - SPECIAL DETAILED: UPPER SPAR CHORD				238	LOM ALL
TASK 54-05-02-250-814					
INTERNAL - SPECIAL DETAILED: UPPER SPAR CHORD NEAR CUTOUTS (DIRECTION 1)				240	LOM ALL
TASK 54-05-02-250-815					
INTERNAL - SPECIAL DETAILED: UPPER SPAR CHORD NEAR CUTOUTS (DIRECTION 2)				243	LOM ALL
TASK 54-05-02-250-816					
INTERNAL - SPECIAL DETAILED: UPPER SPAR, R1 - FITTING AND UPPER SPAR WEB JOINTS, CHORD ONLY (DIRECTION 1)				245	LOM ALL
TASK 54-05-02-250-817					
INTERNAL - SPECIAL DETAILED: UPPER SPAR, R1 - FITTING AND UPPER SPAR WEB JOINTS - CHORD ONLY (DIRECTION 2)				246	LOM ALL
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INTERNAL - SPECIAL DETAILED: UPPER SPAR, R1 - FITTING AND UPPER SPAR JOINTS - WEB ONLY				248	LOM ALL
TASK 54-05-02-250-819					

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INTERNAL - SPECIAL DETAILED: UPPER AND LOWER SPAR CHORDS				250	LOM ALL
TASK 54-05-02-250-820					
INTERNAL - SPECIAL DETAILED: UPPER AND LOWER SPAR CHORDS				252	LOM ALL
TASK 54-05-02-250-821					
INTERNAL - SPECIAL DETAILED: UPPER SPAR CHORD				255	LOM ALL
TASK 54-05-02-250-822					
INTERNAL - SPECIAL DETAILED: UPPER SPAR CHORD				257	LOM ALL
TASK 54-05-02-130-807					
INTERNAL - SPECIAL DETAILED: UPPER SPAR CHORD				259	LOM ALL
TASK 54-05-02-250-823					
INTERNAL - SPECIAL DETAILED: R3/R4 FIRST FASTENER ROW - VERTICAL LEG				262	LOM ALL
TASK 54-05-02-250-824					
INTERNAL - SPECIAL DETAILED: FORWARD ENGINE MOUNT HANGER				263	LOM ALL
TASK 54-05-02-230-801					
INTERNAL - GENERAL VISUAL: THRUST LINK ASSEMBLY				265	LOM ALL
TASK 54-05-02-210-802					
INTERNAL - GENERAL VISUAL: THRUST LINK PIN				268	LOM ALL
TASK 54-05-02-210-803					
INTERNAL - SPECIAL DETAILED: AFT ENGINE MOUNT HANGER				271	LOM ALL
TASK 54-05-02-230-802					
INTERNAL - GENERAL VISUAL: EVENER BAR ASSEMBLY - OUTBOARD LUGS				272	LOM ALL
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INTERNAL - SPECIAL DETAILED: AFT ENGINE MOUNT EVENER BAR - MID SPAN				275	LOM ALL
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INTERNAL - SPECIAL DETAILED: STRUT ATTACH BOLTS (FORWARD AND AFT MOUNTS) TASK 54-05-02-700-801					276	LOM ALL
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NACELLE STRUT - MAINTENANCE PRACTICES	54-51-01				201	LOM ALL
Prepare the Strut for Maintenance Operations TASK 54-51-01-040-801					201	LOM ALL
Put the Strut Back to its Usual Condition TASK 54-51-01-440-801					202	LOM ALL
Support the Strut with the Engine Installed TASK 54-51-01-580-801					203	LOM ALL
Remove Support from the Strut with the Engine Installed TASK 54-51-01-580-802					205	LOM ALL
Support the Strut with the Engine Removed TASK 54-51-01-580-803					206	LOM ALL
Remove Support from the Strut with the Engine Removed TASK 54-51-01-580-804					207	LOM ALL
NACELLE STRUT - REMOVAL/INSTALLATION	54-51-01				401	LOM ALL
Nacelle Strut Removal TASK 54-51-01-000-801					401	LOM ALL
Nacelle Strut Installation TASK 54-51-01-400-801					405	LOM ALL
NACELLE STRUT - INSPECTION/CHECK	54-51-01				601	LOM ALL
Nacelle Strut Examination TASK 54-51-01-200-801					601	LOM ALL
Strut Bushing Examination TASK 54-51-01-200-802					602	LOM ALL
Corrosion Prevention - Nacelle Strut TASK 54-51-01-200-803					603	LOM ALL

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Remove the Midspar Fuse Pin					401	LOM ALL
TASK 54-51-02-000-803						
Install the Midspar Fuse Pin					404	LOM ALL
TASK 54-51-02-400-803						
<u>MIDS PAR FUSE PIN - INSPECTION/CHECK</u>	54-51-02				601	LOM ALL
Midspare Fuse Pin and Bushing Examination					601	LOM ALL
TASK 54-51-02-220-805						
<u>UPPER LINK - REMOVAL/INSTALLATION</u>	54-51-03				401	LOM ALL
Upper Link Removal					401	LOM ALL
TASK 54-51-03-000-801						
Upper Link Installation					402	LOM ALL
TASK 54-51-03-400-801						
Upper Link Fuse Pin Removal					403	LOM ALL
TASK 54-51-03-000-802						
Upper Link Fuse Pin Installation					406	LOM ALL
TASK 54-51-03-400-802						
<u>UPPER LINK - INSPECTION/CHECK</u>	54-51-03				601	LOM ALL
Upper Link Forward Fuse Pin and Bushing Examination					601	LOM ALL
TASK 54-51-03-220-801						
Upper Link Aft Pin and Bushing Examination					602	LOM ALL
TASK 54-51-03-220-802						
<u>DIAGONAL BRACE - REMOVAL/INSTALLATION</u>	54-51-04				401	LOM ALL
Diagonal Brace Removal					401	LOM ALL
TASK 54-51-04-000-801						
Diagonal Brace Installation					402	LOM ALL
TASK 54-51-04-400-801						
Diagonal Brace Forward/Aft Fuse Pin Removal					403	LOM ALL
TASK 54-51-04-000-802						
Diagonal Brace Fuse Pin Installation					408	LOM ALL
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Diagonal Brace Aft Fuse Pin and Bushing Examination					601	LOM ALL
TASK 54-51-04-220-801						
Diagonal Brace Forward Pin and Bushing Examination					602	LOM ALL
TASK 54-51-04-220-802						
<u>SIDE LINK - REMOVAL/INSTALLATION</u>	54-51-05				401	LOM ALL
Side Link Removal					401	LOM ALL
TASK 54-51-05-000-801						
Original Side Link Installation					408	LOM ALL
TASK 54-51-05-400-801						
New Side Link Installation					411	LOM ALL
TASK 54-51-05-400-802						
Lower Shoulder Bolt Removal					415	LOM ALL
TASK 54-51-05-000-802						
Lower Shoulder Bolt Installation					417	LOM ALL
TASK 54-51-05-400-803						
<u>STRUT SIDE LINK - INSPECTION/CHECK</u>	54-51-05				601	LOM ALL
Strut Side Link Examination					601	LOM ALL
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<u>STRUT TO WING FAIRINGS - MAINTENANCE PRACTICES</u>	54-52-00				201	LOM ALL
Aerodynamic Smoothness Requirements					201	LOM ALL
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<u>FORWARD FAIRINGS - REMOVAL/INSTALLATION</u>	54-52-01				401	LOM ALL
Forward Fairing Removal					401	LOM ALL
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Forward Fairing Installation					407	LOM ALL
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<u>FORWARD FAIRINGS - INSPECTION/CHECK</u>	54-52-01				601	LOM ALL
Forward Fairings Examination					601	LOM ALL
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TASK 54-52-02-020-801					
Forward Fairing Pressure Relief Door Latch Installation				401	LOM ALL
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FORWARD FAIRING PRESSURE RELIEF DOOR - ADJUSTMENT/TEST	54-52-02			501	LOM ALL
Pressure Relief Door Latch Test				501	LOM ALL
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WING JUNCTION FAIRINGS - REMOVAL/INSTALLATION	54-52-03			401	LOM ALL
Wing Junction Fairing - Removal				401	LOM ALL
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Wing Junction Fairing - Installation				411	LOM ALL
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WING JUNCTION FAIRINGS - INSPECTION/CHECK	54-52-03			601	LOM ALL
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AFT FAIRING - REMOVAL/INSTALLATION	54-52-04			401	LOM ALL
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Aft Fairing Removal (Engine Not Removed)				403	LOM ALL
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Aft Fairing Removal (Without Primary Nozzle and Plug)				406	LOM ALL
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Aft Fairing Installation (Engine Removed)				408	LOM ALL
TASK 54-52-04-410-801					
Aft Fairing Installation (Engine Not Removed)				421	LOM ALL
TASK 54-52-04-410-802					
Aft Fairing Installation (Without Primary Plug and Nozzle)				434	LOM ALL
TASK 54-52-04-400-801					

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Aft Fairing Examination			601			LOM ALL
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Aft Fairing Frame Examination			602			LOM ALL
TASK 54-52-04-000-802						
AFT FAIRING ACCESS PANELS - REMOVAL/INSTALLATION	54-52-06		401			LOM ALL
Aft Fairing Access Panel Removal			401			LOM ALL
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Aft Fairing Access Panel Installation			402			LOM ALL
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AFT FAIRING ACCESS PANELS - CLEANING/PAINTING	54-52-06		701			LOM ALL
Repair the aft fairing access panels enamel paint			701			LOM ALL
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AFT FAIRING HEATSHIELD - REMOVAL/INSTALLATION	54-52-08		401			LOM ALL
Aft Fairing Heatshield Removal			401			LOM ALL
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Aft Fairing Heatshield Installation			414			LOM ALL
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LEADING EDGE GAP COVERS - REMOVAL/INSTALLATION	54-52-09		401			LOM ALL
Leading Edge Gap Covers Removal			401			LOM ALL
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TASK 54-52-09-400-801						
Aerodynamic Smoothness Requirements for the Leading Edge Gap Covers.			405			LOM ALL
TASK 54-52-09-200-801						
STRUT ACCESS PANELS- REMOVAL/INSTALLATION	54-53-01		401			LOM ALL
Strut Access Panel Removal			401			LOM ALL
TASK 54-53-01-000-801						

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<u>FORWARD STRUT FAIRING PANELS (THRUST REVERSER STRUT FAIRINGS) - REMOVAL/INSTALLATION</u>	54-53-02			401	LOM ALL
Forward Strut Fairing Panel (Thrust Reverser Strut Fairing) Removal TASK 54-53-02-000-802				401	LOM ALL
Forward Strut Fairing Panel (Thrust Reverser Strut Fairing) Installation TASK 54-53-02-410-801				407	LOM ALL
<u>FORWARD STRUT FAIRING PANELS (THRUST REVERSER STRUT FAIRINGS) - INSPECTION/CHECK</u>	54-53-02			601	LOM ALL
Forward Strut Fairing Panel (Thrust Reverser Strut Fairing) Examination TASK 54-53-02-000-801				601	LOM ALL
<u>FORWARD STRUT FIRE SEAL - MAINTENANCE PRACTICES</u>	54-54-00			201	LOM ALL
Forward Strut Fire Seal - Inspection TASK 54-54-00-200-803				201	LOM ALL
Forward Strut Fire Seal - Removal TASK 54-54-00-000-801				202	LOM ALL
Forward Strut Fire Seal - Installation TASK 54-54-00-400-801				207	LOM ALL
<u>STRUT FIRESEAL AND FIRESEAL DEPRESSOR - INSPECTION/CHECK</u>	54-54-00			601	LOM ALL
Strut Fireseal Depressor Inspection TASK 54-54-00-200-801				601	LOM ALL
Forward Strut Fireseal Inspection TASK 54-54-00-200-802				602	LOM ALL
<u>STRUT INSULATION BLANKETS - REMOVAL/INSTALLATION</u>	54-54-01			401	LOM ALL
Strut Forward Insulation Blankets Removal TASK 54-54-01-000-801				401	LOM ALL

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SUBJECT	CHAPTER	SECTION	SUBJECT	CONF	PAGE	EFFECT
Strut Forward Insulation Blankets Installation TASK 54-54-01-400-801					402	LOM ALL
Strut Mid Insulation Blankets Removal TASK 54-54-01-000-802					404	LOM ALL
Strut Mid Insulation Blankets Installation TASK 54-54-01-400-802					406	LOM ALL
Strut Aft Insulation Blankets Removal TASK 54-54-01-000-803					407	LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 PRE SB 737-78-1089
Strut Aft Insulation Blankets Installation TASK 54-54-01-400-803					414	LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 PRE SB 737-78-1089
Strut Aft Insulation Blankets Removal TASK 54-54-01-000-804					415	LOM 427-434, 437-447, 450-999; LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 POST SB 737-78-1089
Strut Aft Insulation Blankets Installation TASK 54-54-01-400-804					421	LOM 427-434, 437-447, 450-999; LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 POST SB 737-78-1089
STRUT INSULATION BLANKETS - INSPECTION/CHECK	54-54-01				601	LOM ALL
Strut Insulation Blankets Inspection TASK 54-54-01-200-801					601	LOM ALL
STRUT INSULATION BLANKETS - REPAIR	54-54-01				801	LOM ALL
Strut Insulation Blanket Repair On-Aircraft TASK 54-54-01-300-801					801	LOM ALL
Strut Insulation Blanket Repair Off-Aircraft TASK 54-54-01-300-802					804	LOM ALL
AFT FAIRING INSULATION BLANKETS - INSPECTION/CHECK	54-54-02				601	LOM ALL
Aft Fairing Insulation Blankets Inspection TASK 54-54-02-200-801					601	LOM ALL
STRUT DRAINS - MAINTENANCE PRACTICES	54-55-01				201	LOM ALL
Condensate Drain Clean TASK 54-55-01-100-801					201	LOM ALL

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TASK 54-55-01-200-801					
Strut Drain - Functional Test				209	LOM ALL
TASK 54-55-01-720-801					
Strut Seal Plane Access Panels- Functional Test				213	LOM ALL
TASK 54-55-01-720-802					
AFT FAIRING STRUT DRAINS - MAINTENANCE PRACTICES	54-55-02			201	LOM ALL
Strut Drain and Aft Fairing Sump Drain Clean				201	LOM ALL
TASK 54-55-02-100-801					
AFT FAIRING STRUT DRAINS - INSPECTION/CHECK	54-55-02			601	LOM ALL
Aft Fairing Sump Drain Inspection				601	LOM ALL
TASK 54-55-02-100-802					
AFT FAIRING STRUT DRAINS - REPAIRS	54-55-02			801	LOM ALL
Aft Fairing Strut Drain - Permanent Repair				801	LOM ALL
TASK 54-55-02-310-801					
Aft Fairing Strut Drain - Temporary Repair				803	LOM ALL
TASK 54-55-02-390-801					

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NACELLES/PYLONS - STRUCTURAL INSPECTIONS - MAINTENANCE PRACTICES

TASK 54-05-03-210-801

1. EXTERNAL - GENERAL VISUAL: LEFT FORWARD ENGINE MOUNT ASSEMBLY
(Figure 201)

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)

B. Location Zones

Zone	Area
413	Engine 1 - Fan Cowl, Left
414	Engine 1 - Fan Cowl, Right

C. Access Panels

Number	Name/Location
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1

D. Inspection

SUBTASK 54-05-03-010-001

- (1) Open these access panels:

Number	Name/Location
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1

SUBTASK 54-05-03-210-001

- (2) Do a general visual inspection of the left forward engine mount assembly, including fan case fitting, side links, hanger, and link pins.

SUBTASK 54-05-03-910-001

- (3) 737-6789 Basic Task Description, TASK 51-05-01-210-809.

SUBTASK 54-05-03-410-001

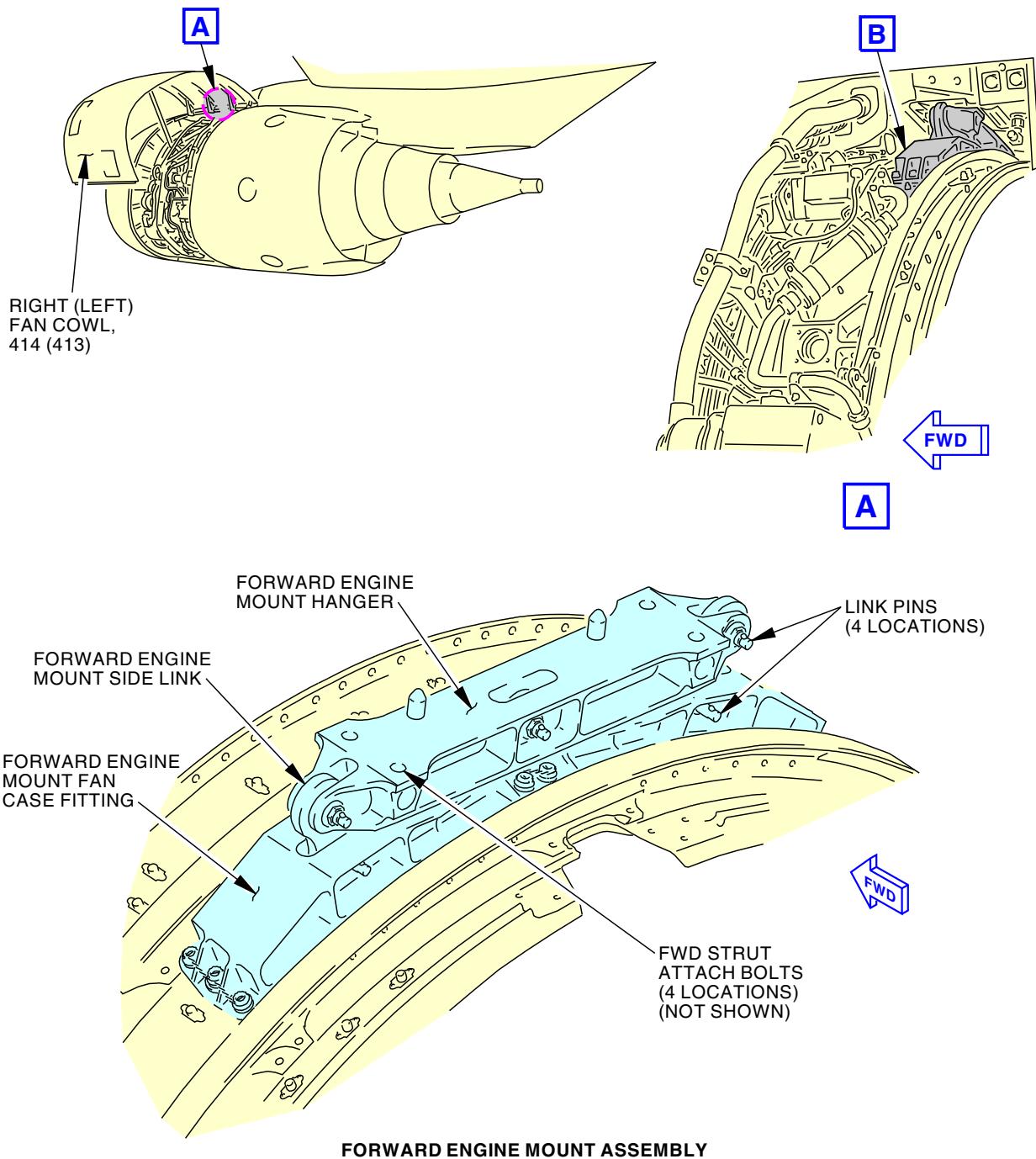
- (4) Close these access panels:

Number	Name/Location
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1

———— END OF TASK ————



54-05-03

MPD ITEM
54-010-01

N80841 S0006584671_V3

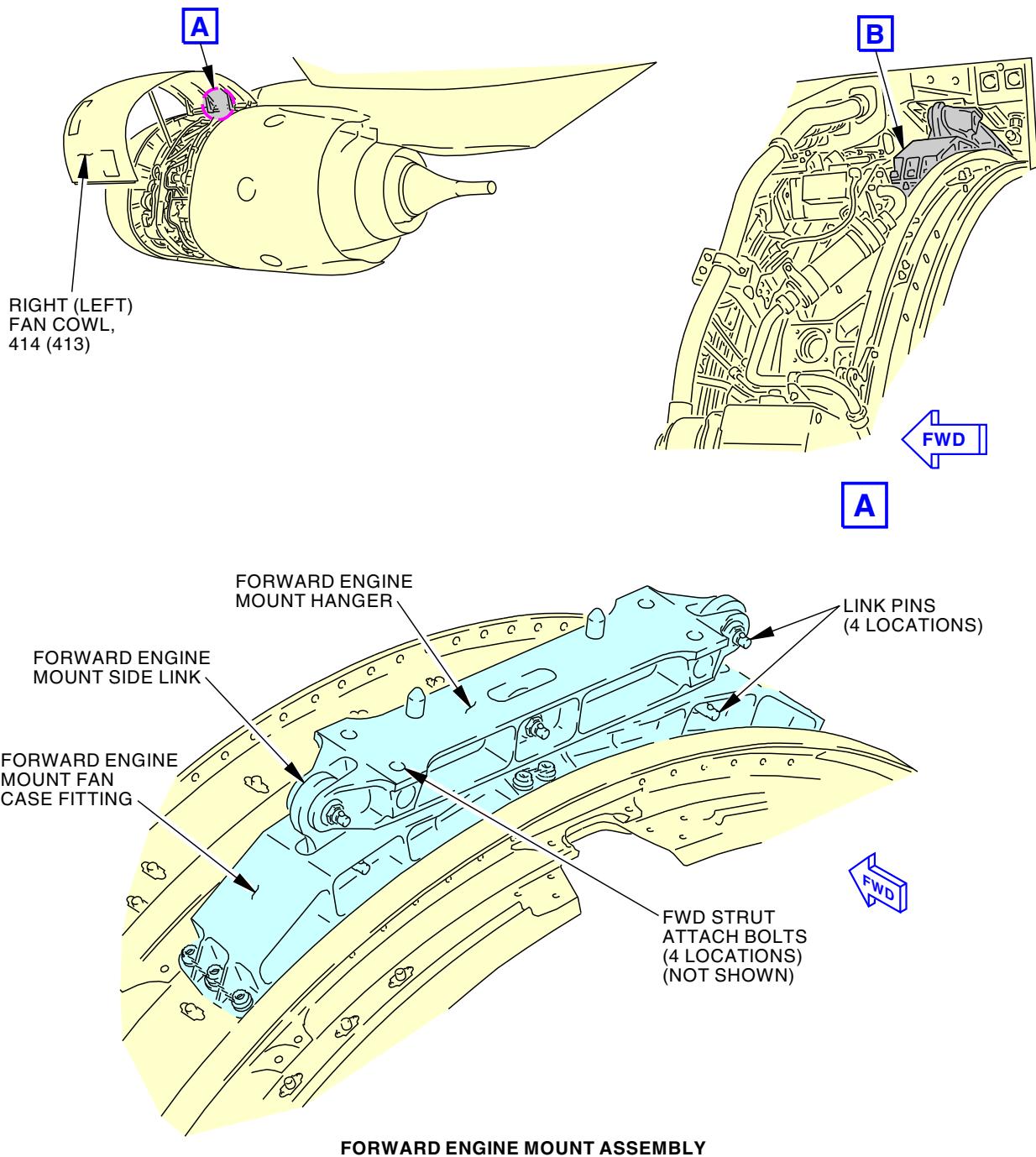
Left Strut Forward Engine Mount Assembly General Visual (External)
Figure 201/54-05-03-990-801 (Sheet 1 of 2)

EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-78-1089; AIRPLANES WITH
LONG EXHAUST NOZZLE

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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MPD ITEM
54-010-01

2081358 S0000433824_V3

Left Strut Forward Engine Mount Assembly General Visual (External)
Figure 201/54-05-03-990-801 (Sheet 2 of 2)

EFFECTIVITY
LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
407, 411, 412, 415, 416, 420, 422-426 POST SB
737-78-1089; AIRPLANES WITH SHORT EXHAUST
NOZZLE

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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TASK 54-05-03-210-802

2. EXTERNAL - GENERAL VISUAL: RIGHT FORWARD ENGINE MOUNT ASSEMBLY

(Figure 202)

NOTE: This procedure is a scheduled maintenance task.

A. References

<u>Reference</u>	<u>Title</u>
51-05-01-210-809	737-6789 Basic Task Description (P/B 201)

B. Location Zones

<u>Zone</u>	<u>Area</u>
423	Engine 2 - Fan Cowl, Left
424	Engine 2 - Fan Cowl, Right

C. Access Panels

<u>Number</u>	<u>Name/Location</u>
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2

D. Inspection

SUBTASK 54-05-03-010-002

- (1) Open these access panels:

<u>Number</u>	<u>Name/Location</u>
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2

SUBTASK 54-05-03-210-002

- (2) Do a general visual inspection of the right forward engine mount assembly, including fan case fitting, side links, hanger, and link pins.

SUBTASK 54-05-03-910-002

- (3) 737-6789 Basic Task Description, TASK 51-05-01-210-809.

SUBTASK 54-05-03-410-002

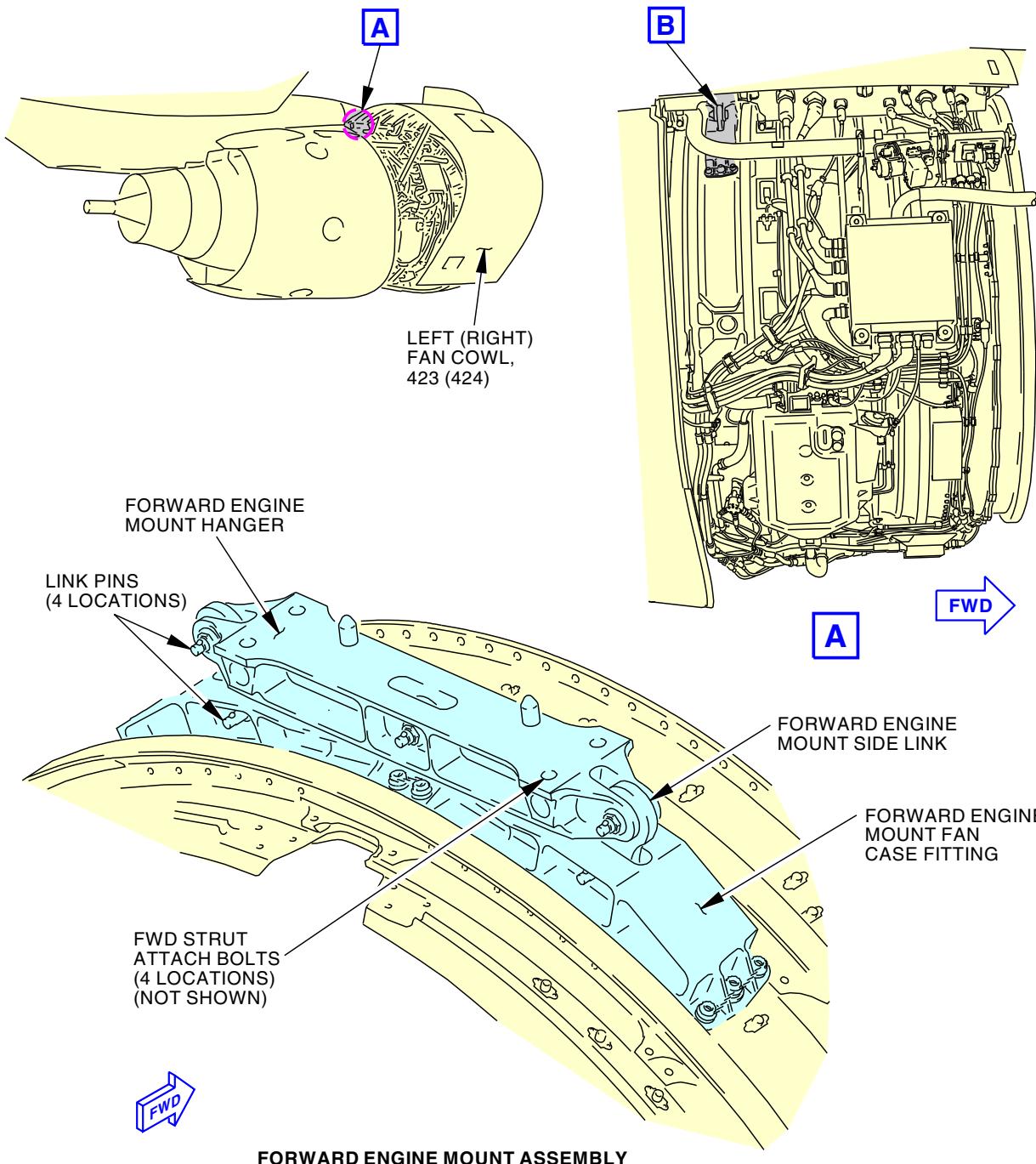
- (4) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2

———— END OF TASK ————

EFFECTIVITY
LOM ALL

54-05-03

MPD ITEM
54-010-02

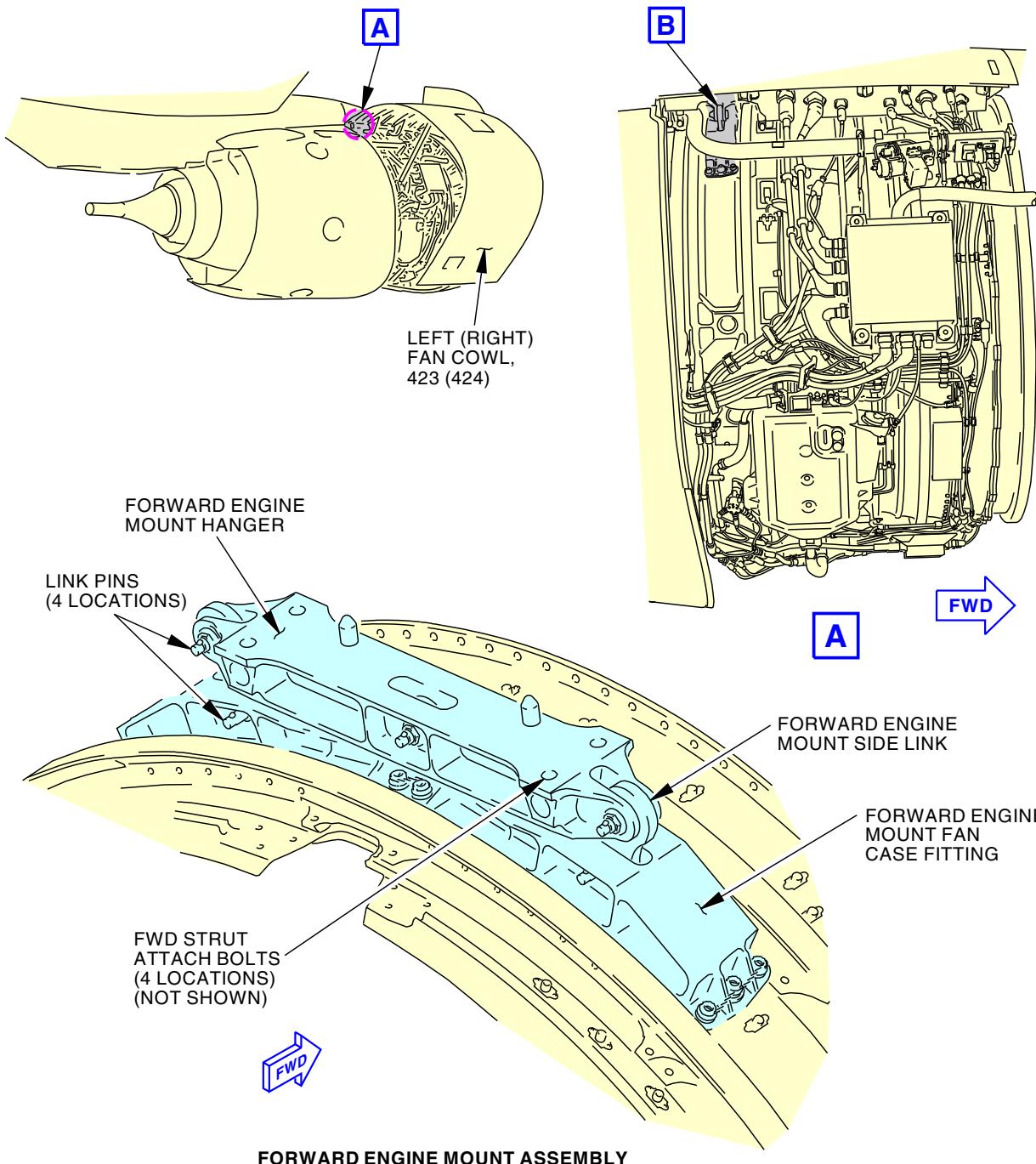
N80868 S0006584673_V3

Right Strut Forward Engine Mount Assembly General Visual (External)
Figure 202/54-05-03-990-802 (Sheet 1 of 2)EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-78-1089**54-05-03**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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2081372 S0000433834_V3

Right Strut Forward Engine Mount Assembly General Visual (External)
Figure 202/54-05-03-990-802 (Sheet 2 of 2)

EFFECTIVITY
 LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
 407, 411, 412, 415, 416, 420, 422-426 POST SB
 737-78-1089

54-05-03

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details



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TASK 54-05-03-210-803

3. **INTERNAL - GENERAL VISUAL: LEFT STRUT ATTACH BOLTS AT FORWARD ENGINE MOUNT**
(Figure 203)

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)

B. Location Zones

Zone	Area
413	Engine 1 - Fan Cowl, Left
414	Engine 1 - Fan Cowl, Right

C. Access Panels

Number	Name/Location
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
431AT	Forward Strut Fairing, Thumbnail Fairing, Strut 1

D. Inspection

SUBTASK 54-05-03-010-003

- (1) Open these access panels:

Number	Name/Location
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
431AT	Forward Strut Fairing, Thumbnail Fairing, Strut 1

SUBTASK 54-05-03-210-003

- (2) Do a general visual inspection of the left strut attach bolts at forward engine mount.

SUBTASK 54-05-03-910-003

- (3) 737-6789 Basic Task Description, TASK 51-05-01-210-809.

SUBTASK 54-05-03-410-003

- (4) Close these access panels:

Number	Name/Location
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
431AT	Forward Strut Fairing, Thumbnail Fairing, Strut 1

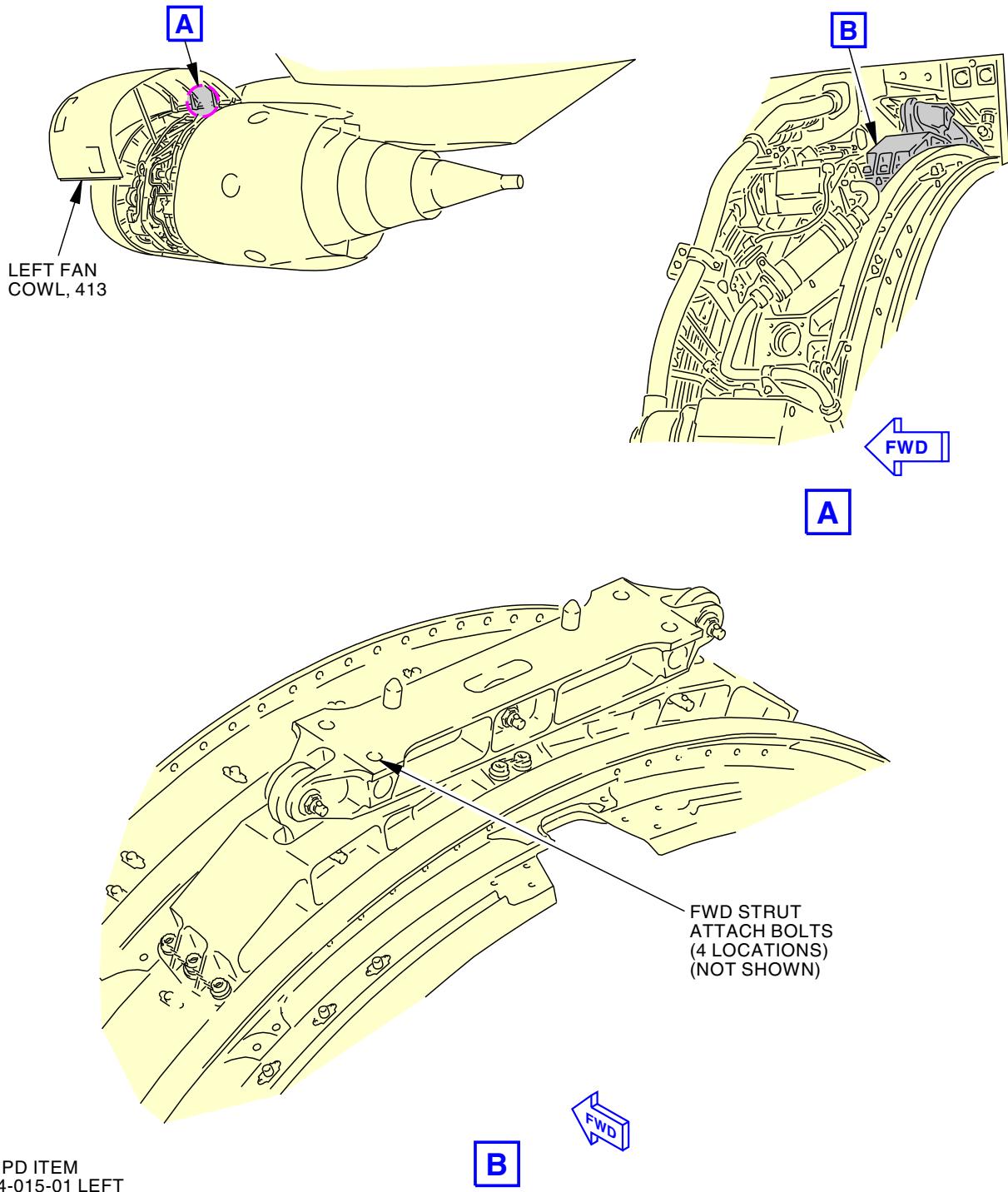
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EFFECTIVITY
LOM ALL

54-05-03



737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL



N82158 S0006584675_V4

Forward Engine Mount Bolts - General Visual (Internal) Inspection
Figure 203/54-05-03-990-803 (Sheet 1 of 2)

EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-78-1089

54-05-03

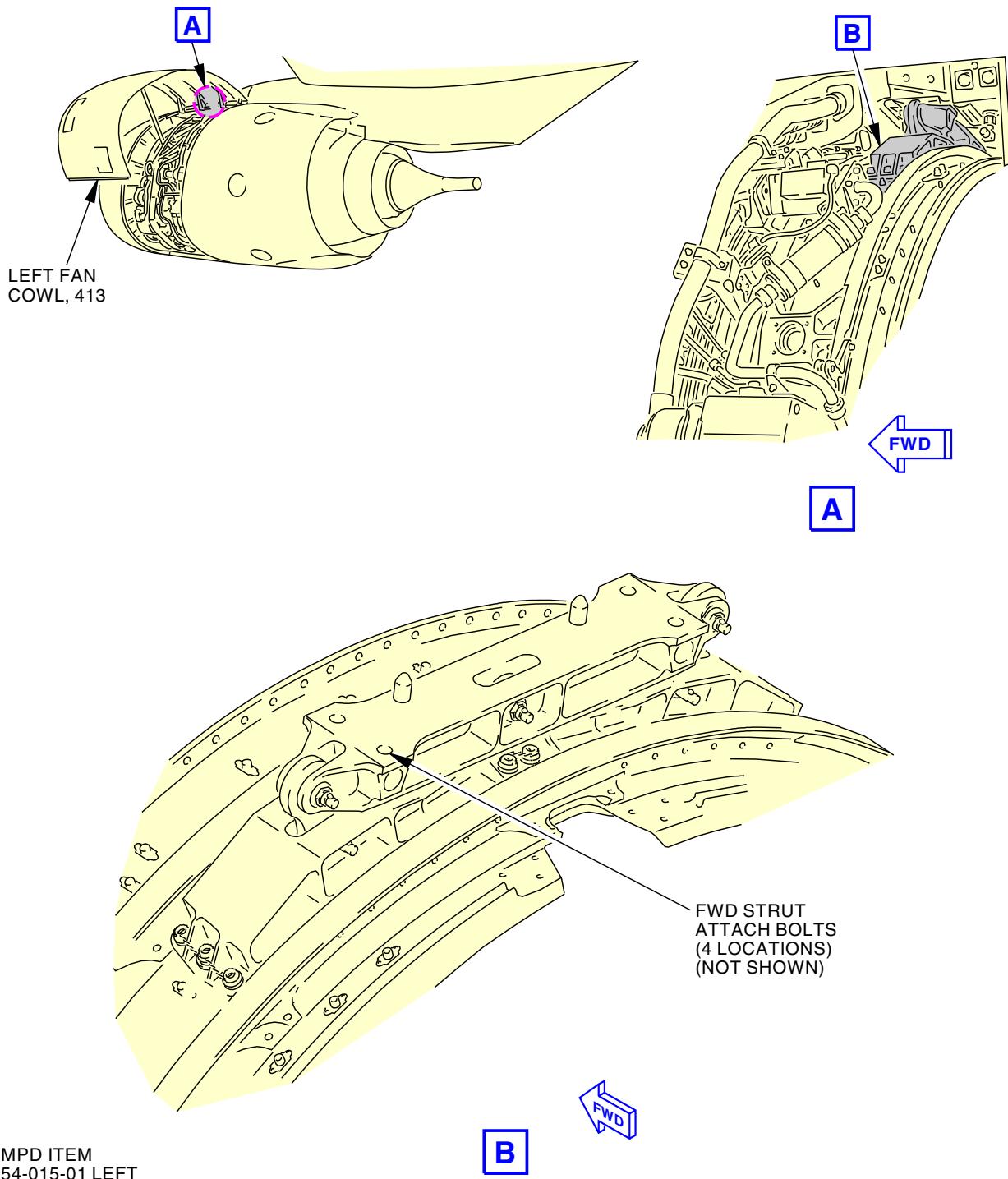
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL



2081381 S0000433842_V3

Forward Engine Mount Bolts - General Visual (Internal) Inspection
Figure 203/54-05-03-990-803 (Sheet 2 of 2)

EFFECTIVITY
LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
407, 411, 412, 415, 416, 420, 422-426 POST SB
737-78-1089

54-05-03

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL

TASK 54-05-03-210-804

4. **INTERNAL - GENERAL VISUAL: RIGHT STRUT ATTACH BOLTS AT FORWARD ENGINE MOUNTS**
(Figure 204)

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)

B. Location Zones

Zone	Area
423	Engine 2 - Fan Cowl, Left
424	Engine 2 - Fan Cowl, Right

C. Access Panels

Number	Name/Location
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
441AT	Forward Strut Fairing, Thumbnail Fairing, Strut 2

D. Inspection

SUBTASK 54-05-03-010-004

- (1) Open these access panels:

Number	Name/Location
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
441AT	Forward Strut Fairing, Thumbnail Fairing, Strut 2

SUBTASK 54-05-03-210-004

- (2) Do a general visual inspection of the right strut attach bolts at forward engine mount.

SUBTASK 54-05-03-910-004

- (3) 737-6789 Basic Task Description, TASK 51-05-01-210-809.

SUBTASK 54-05-03-410-004

- (4) Close these access panels:

Number	Name/Location
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
441AT	Forward Strut Fairing, Thumbnail Fairing, Strut 2

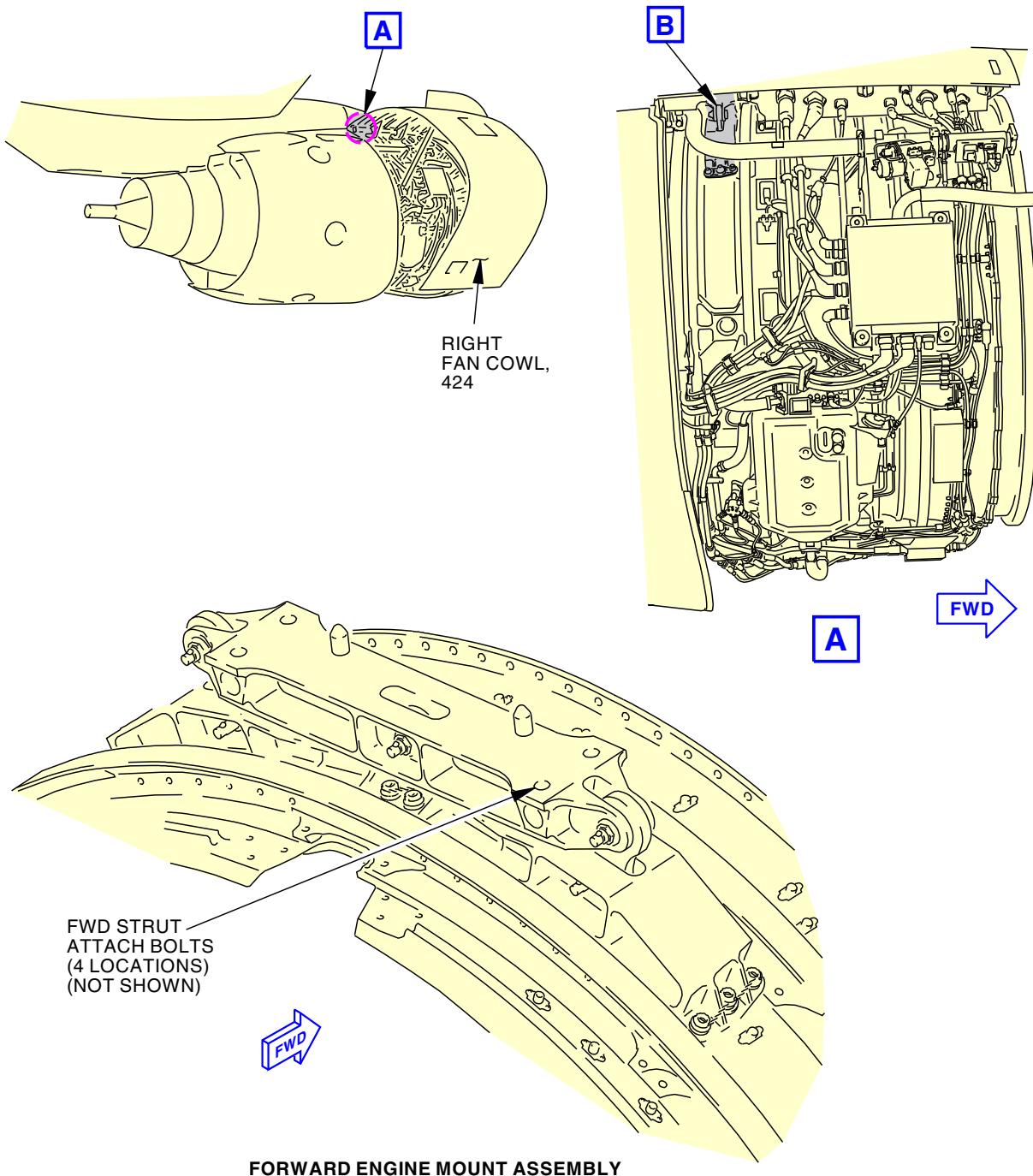
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54-05-03



737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL



MPD ITEM
54-015-02

N78635 S0006584677_V3

Right Forward Engine Mount Bolts General Visual (Internal) Inspection
Figure 204/54-05-03-990-804 (Sheet 1 of 2)

EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-78-1089

54-05-03

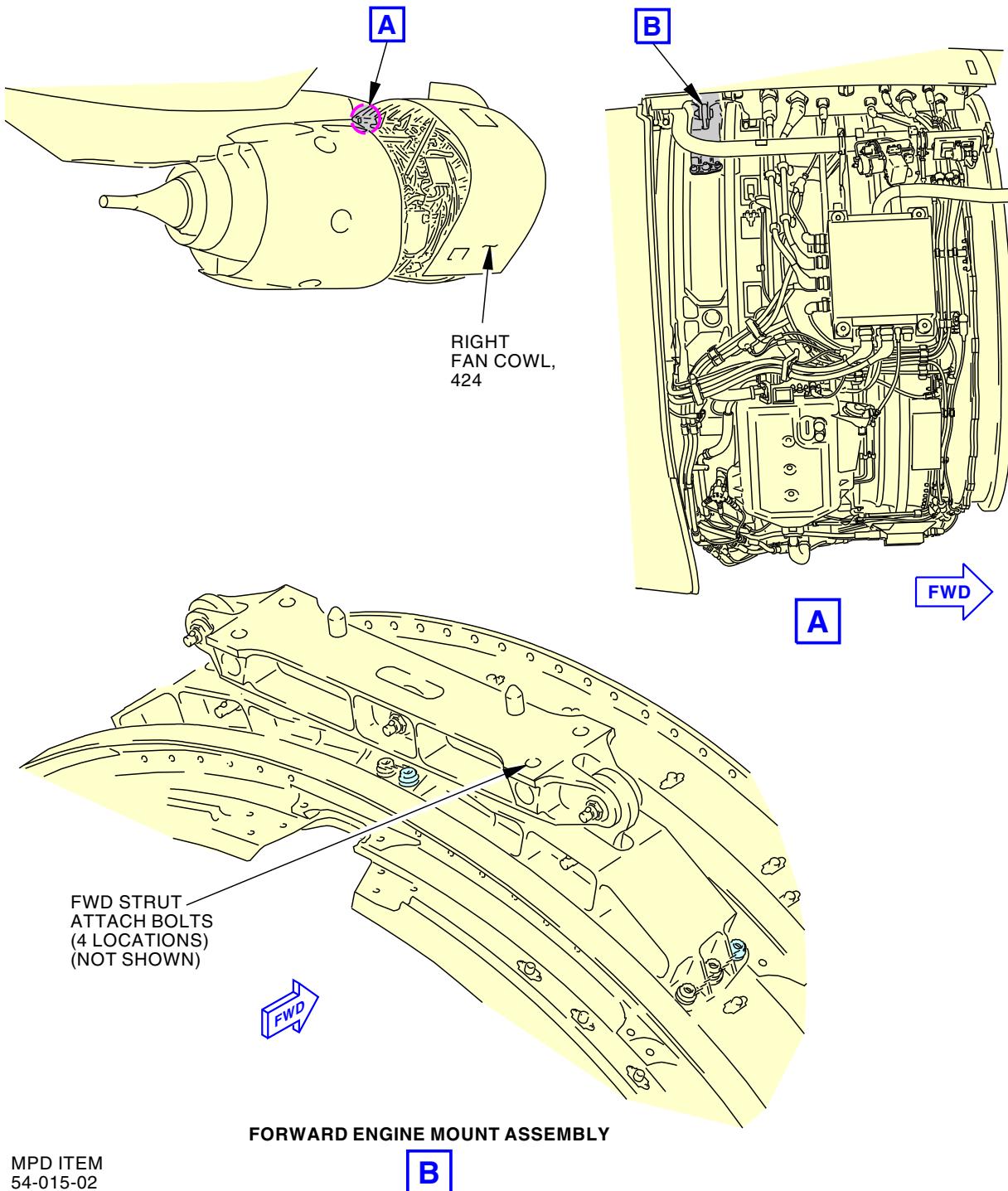
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL



MPD ITEM
54-015-02

2081387 S0000433847_V3

Right Forward Engine Mount Bolts General Visual (Internal) Inspection
Figure 204/54-05-03-990-804 (Sheet 2 of 2)

EFFECTIVITY
LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
407, 411, 412, 415, 416, 420, 422-426 POST SB
737-78-1089

54-05-03

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL

TASK 54-05-03-210-805

**5. INTERNAL - GENERAL VISUAL: LEFT STRUT FORWARD AND AFT ENGINE MOUNT TO STRUT
SHEAR PINS**

(Figure 205)

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)

B. Location Zones

Zone	Area
413	Engine 1 - Fan Cowl, Left
414	Engine 1 - Fan Cowl, Right
433	Engine 1 - Strut Torque Box

C. Inspection

NOTE: Engine removal required.

SUBTASK 54-05-03-210-005

- (1) Do a general visual inspection of the forward and aft engine mount to strut shear pins.

SUBTASK 54-05-03-910-019

- (2) 737-6789 Basic Task Description, TASK 51-05-01-210-809.

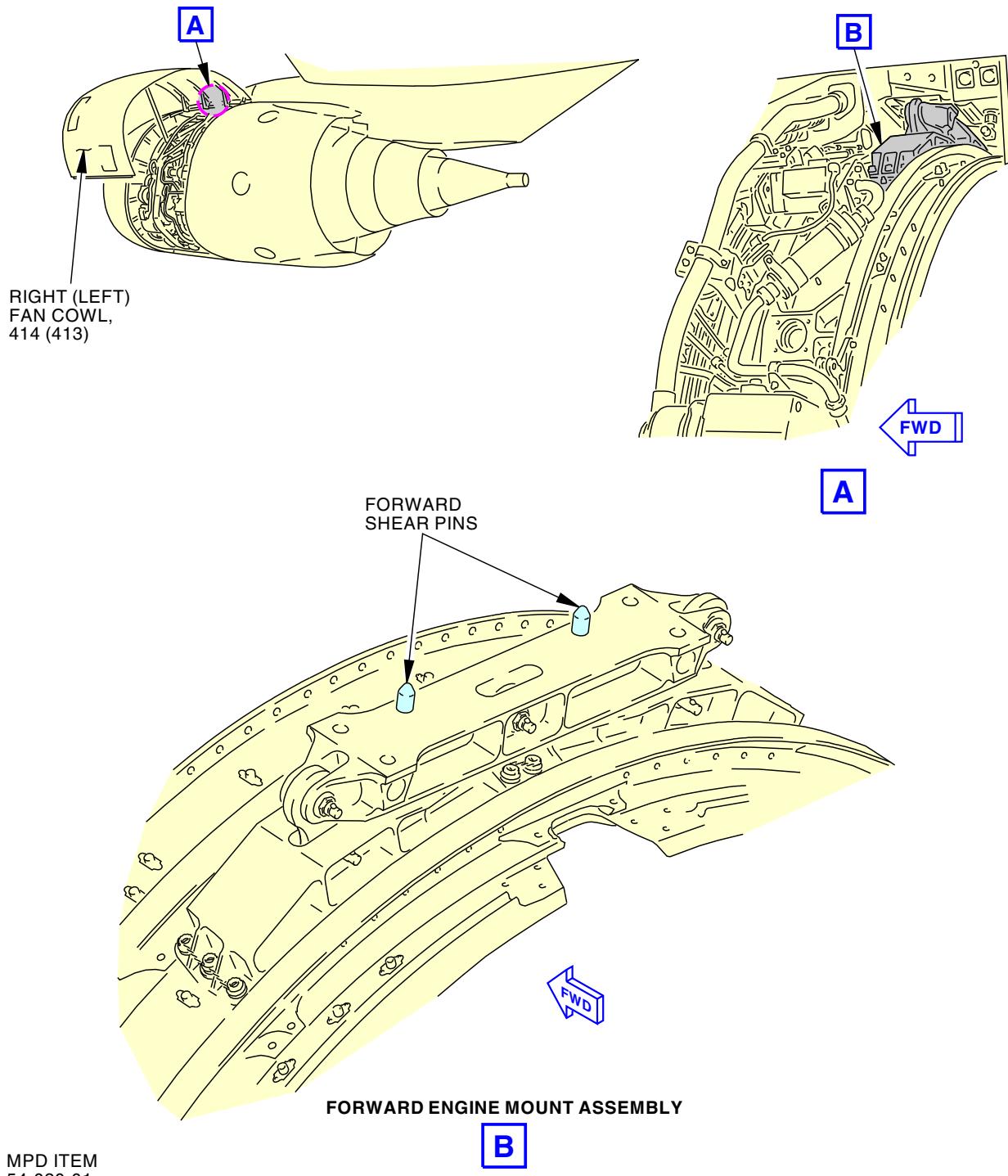
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EFFECTIVITY
LOM ALL

54-05-03



737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL



MPD ITEM
54-020-01

M32645 S0006584679_V2

Left Strut Forward and Aft Engine Mount Assemblies General Visual (Internal)
Figure 205/54-05-03-990-805 (Sheet 1 of 4)

EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-78-1089

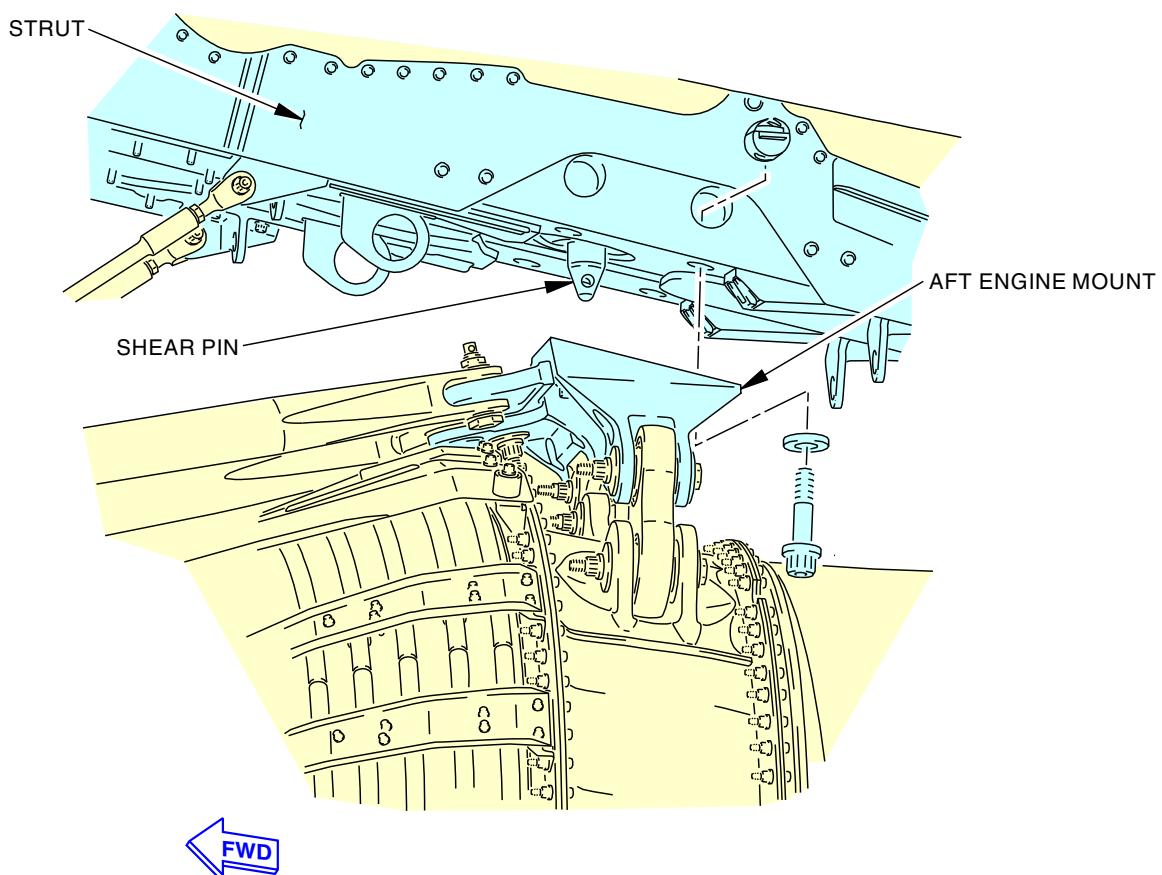
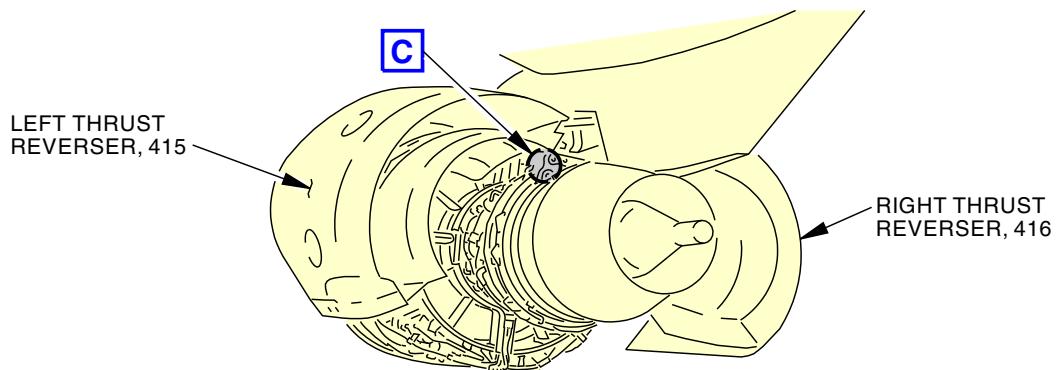
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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BOEING
737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL



AFT ENGINE MOUNT ASSEMBLY

C

MPD ITEM
54-020-01

M32647 S0006584680_V2

Left Strut Forward and Aft Engine Mount Assemblies General Visual (Internal)
Figure 205/54-05-03-990-805 (Sheet 2 of 4)

EFFECTIVITY
 LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
 422-426 PRE SB 737-78-1089

54-05-03

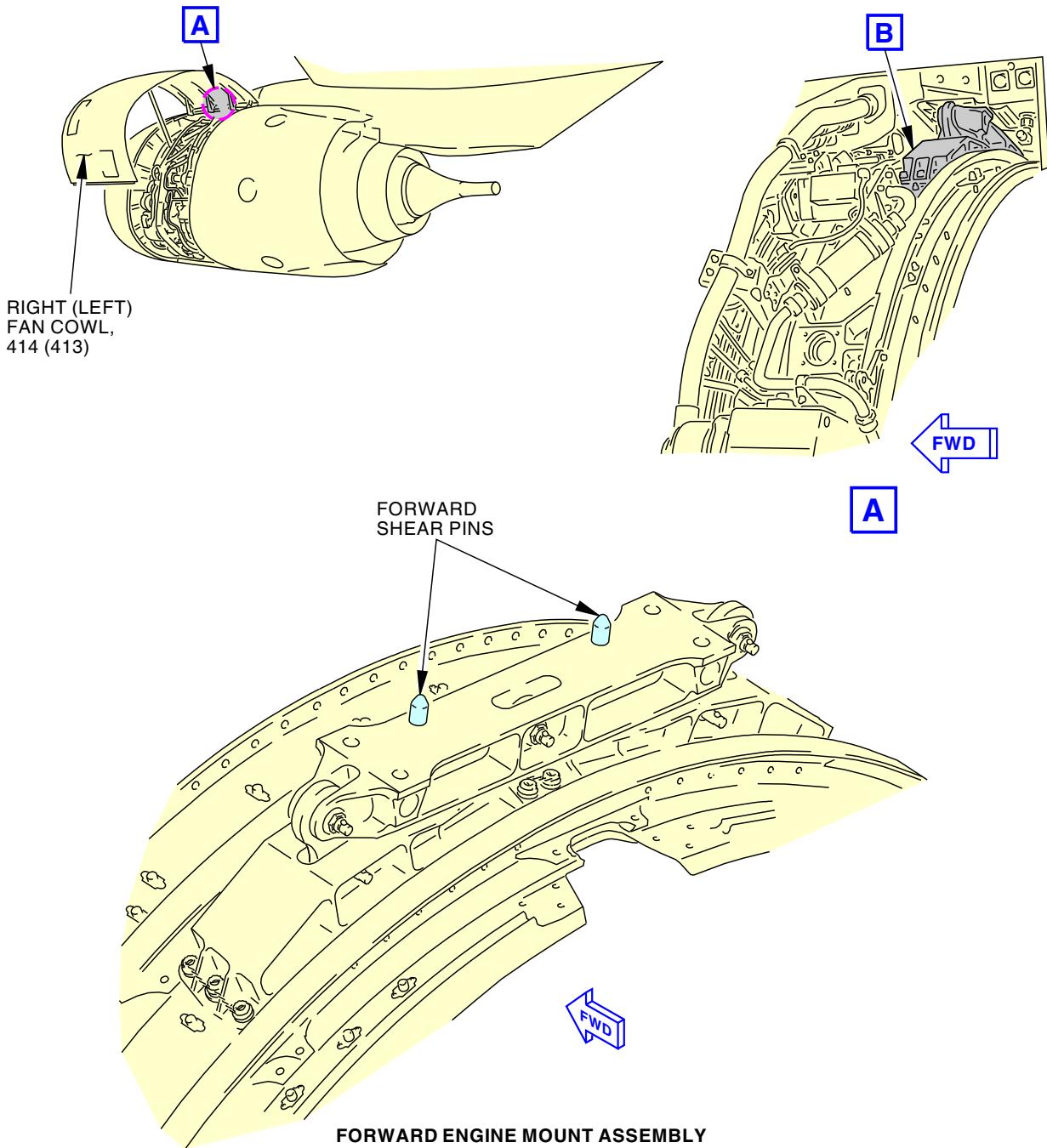
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL



MPD ITEM
54-020-01

2081809 S0000433862_V2

Left Strut Forward and Aft Engine Mount Assemblies General Visual (Internal)
Figure 205/54-05-03-990-805 (Sheet 3 of 4)

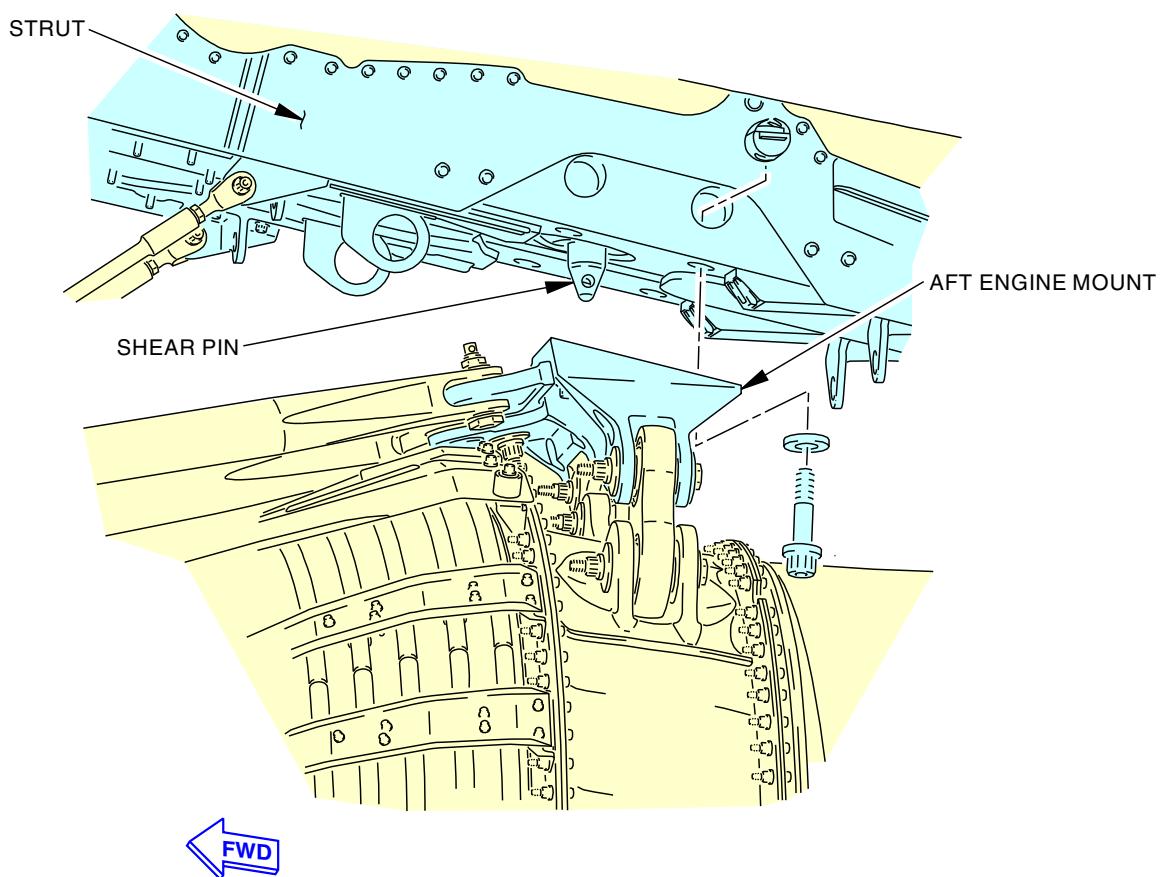
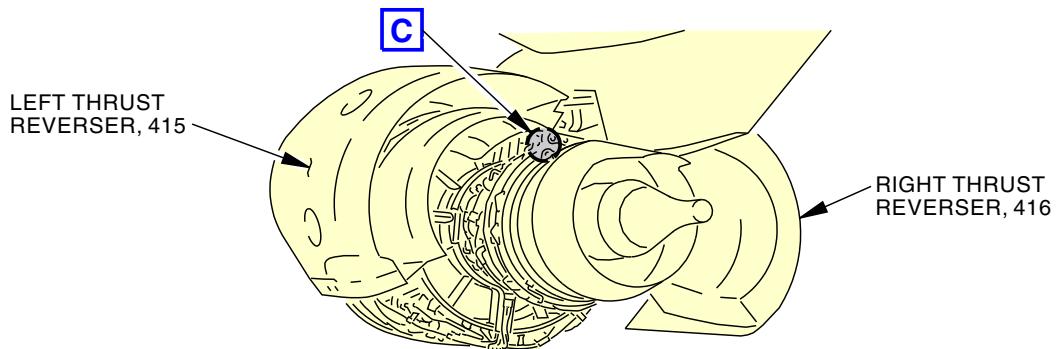
EFFECTIVITY
LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
407, 411, 412, 415, 416, 420, 422-426 POST SB
737-78-1089

54-05-03

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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MPD ITEM
54-020-01

2081392 S0000433864_V2

Left Strut Forward and Aft Engine Mount Assemblies General Visual (Internal)
Figure 205/54-05-03-990-805 (Sheet 4 of 4)

EFFECTIVITY
LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
407, 411, 412, 415, 416, 420, 422-426 POST SB
737-78-1089

54-05-03

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL

TASK 54-05-03-210-806

6. INTERNAL - GENERAL VISUAL: RIGHT STRUT FORWARD AND AFT ENGINE MOUNT TO STRUT SHEAR PINS

(Figure 206)

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)

B. Location Zones

Zone	Area
423	Engine 2 - Fan Cowl, Left
424	Engine 2 - Fan Cowl, Right
443	Engine 2 - Strut Torque Box

C. Inspection

NOTE: Engine removal required.

SUBTASK 54-05-03-210-006

- (1) Do a general visual inspection of the forward and aft engine mount to strut shear pins.

SUBTASK 54-05-03-910-006

- (2) 737-6789 Basic Task Description, TASK 51-05-01-210-809.

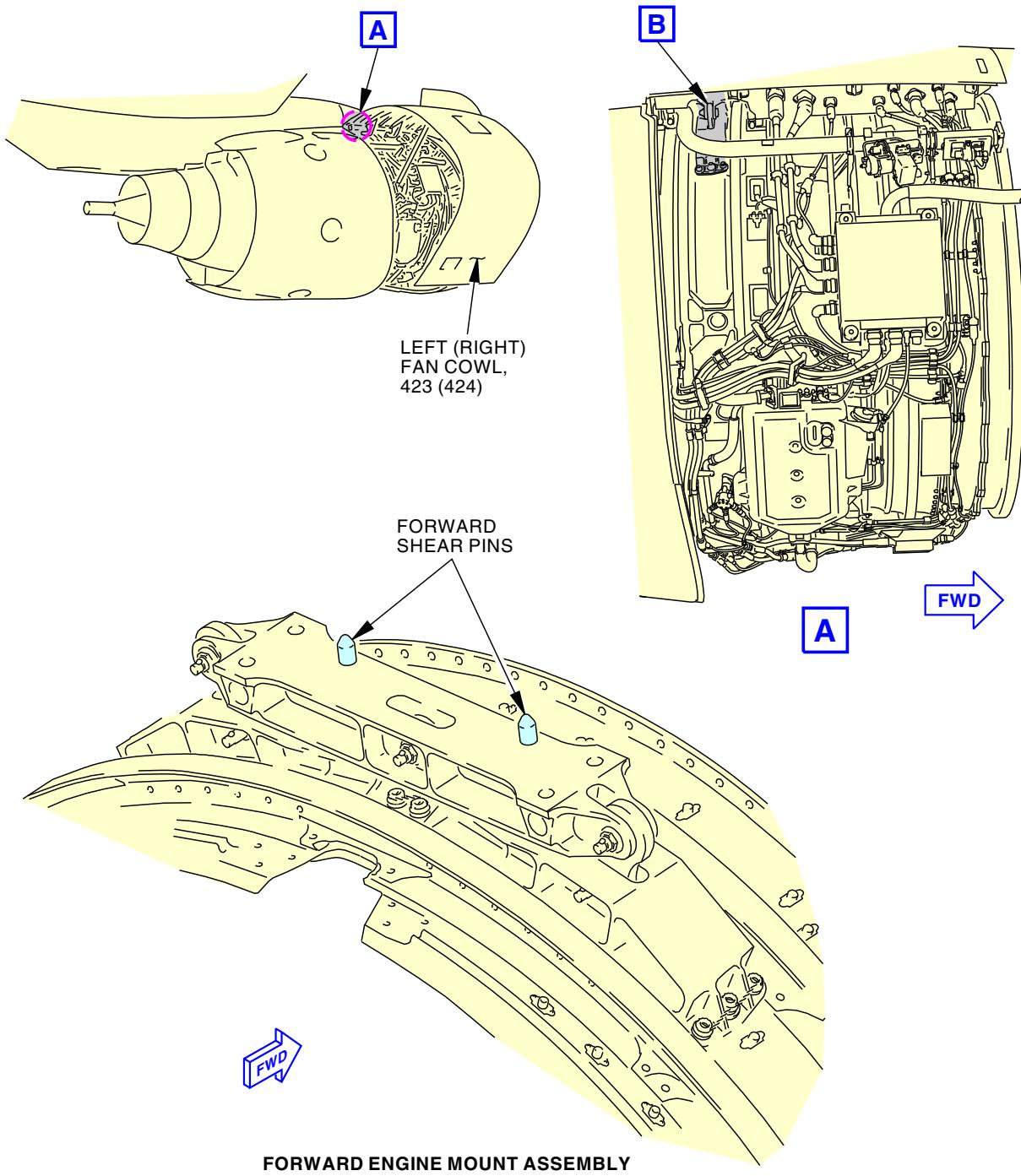
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EFFECTIVITY
LOM ALL

54-05-03

BOEING

**737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL**



MPD ITEM
54-020-02

M32653 S0006584682_V2

Right Strut Forward and Aft Engine Mount Assemblies General Visual (Internal)
Figure 206/54-05-03-990-806 (Sheet 1 of 4)

EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-78-1089

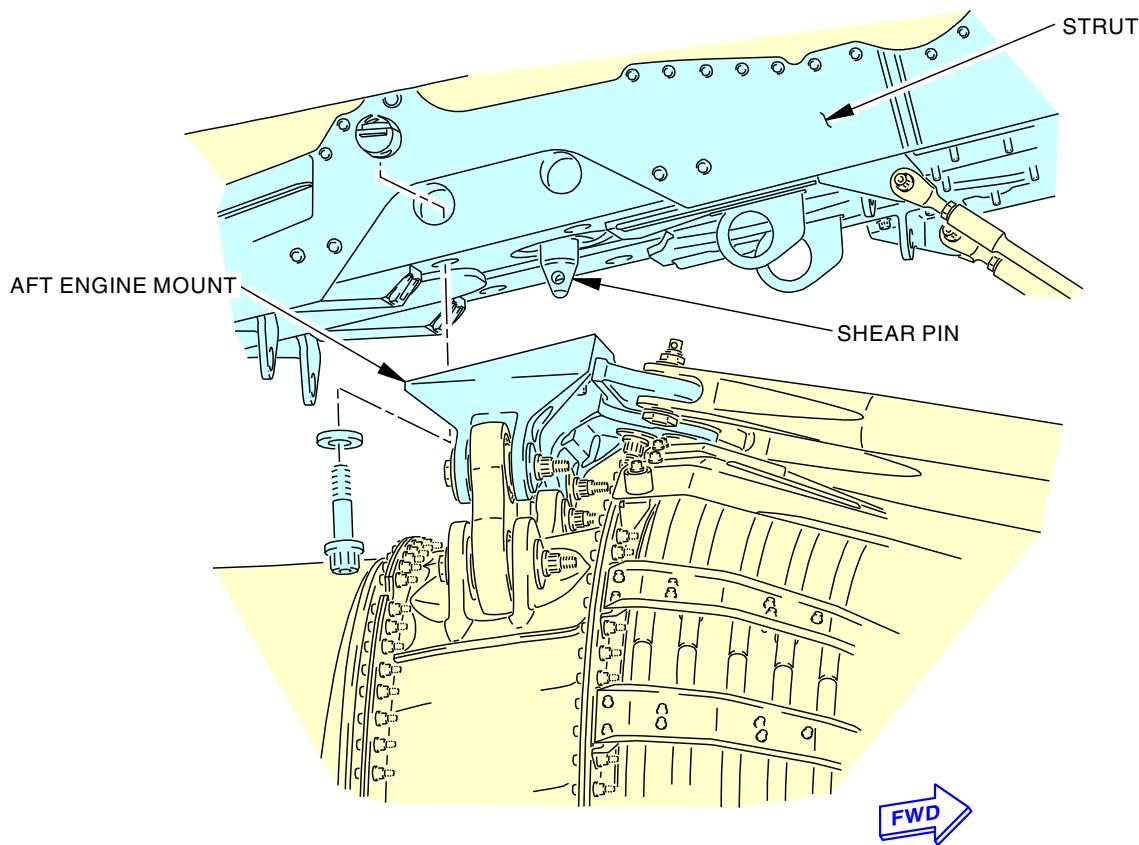
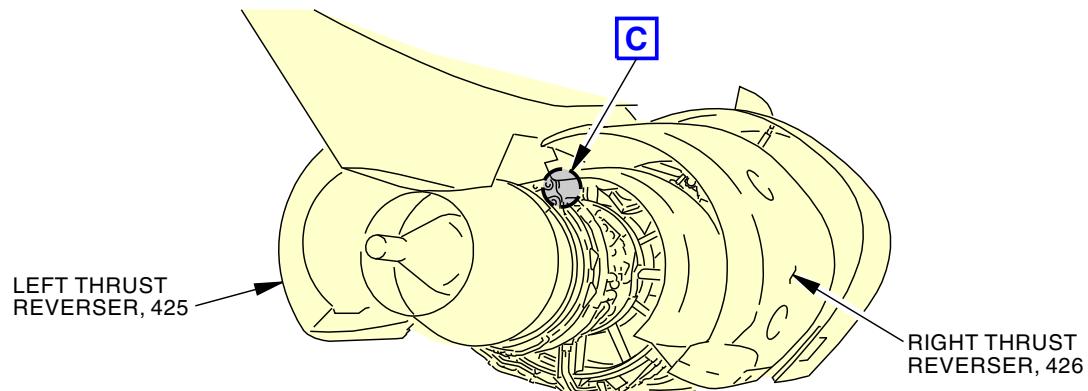
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D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details



737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL



AFT ENGINE MOUNT ASSEMBLY

C

MPD ITEM
54-020-02

M32655 S0006584683_V2

Right Strut Forward and Aft Engine Mount Assemblies General Visual (Internal)
Figure 206/54-05-03-990-806 (Sheet 2 of 4)

EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-78-1089

54-05-03

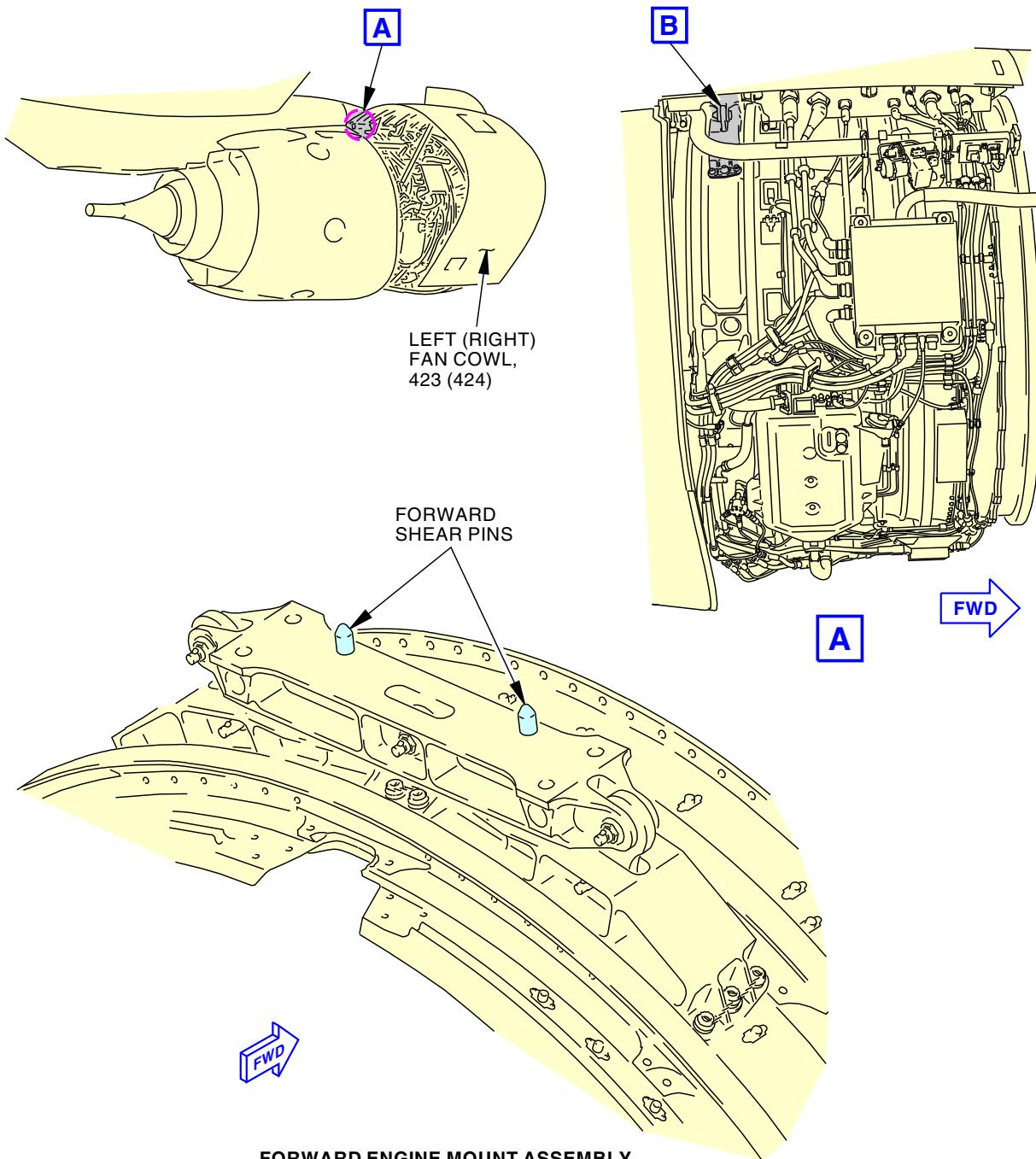
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL



MPD ITEM
54-020-02

2081397 S0000433896_V2

Right Strut Forward and Aft Engine Mount Assemblies General Visual (Internal)
Figure 206/54-05-03-990-806 (Sheet 3 of 4)

EFFECTIVITY
LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
407, 411, 412, 415, 416, 420, 422-426 POST SB
737-78-1089

54-05-03

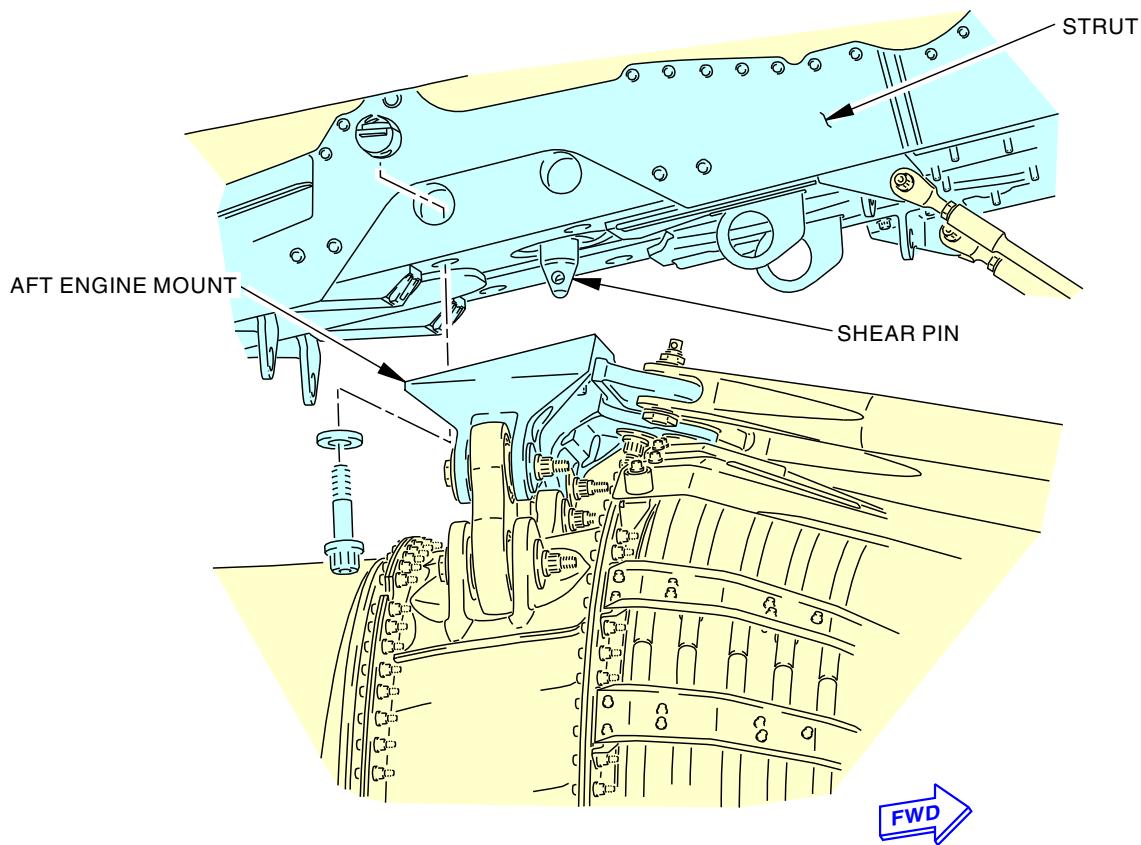
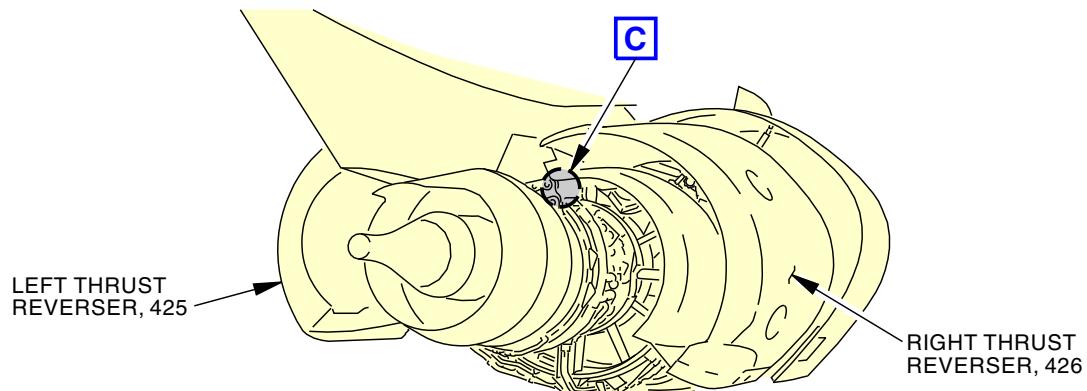
D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL



AFT ENGINE MOUNT ASSEMBLY

MPD ITEM
54-020-02

2081403 S0000433898_V2

Right Strut Forward and Aft Engine Mount Assemblies General Visual (Internal)
Figure 206/54-05-03-990-806 (Sheet 4 of 4)

EFFECTIVITY
LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
407, 411, 412, 415, 416, 420, 422-426 POST SB
737-78-1089

54-05-03

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL

TASK 54-05-03-210-807

7. EXTERNAL - GENERAL VISUAL: LEFT STRUT AFT ENGINE MOUNT ASSEMBLY

(Figure 207)

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)

B. Location Zones

Zone	Area
415	Engine 1 - Thrust Reverser, Left
416	Engine 1 - Thrust Reverser, Right

C. Access Panels

Number	Name/Location
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1

D. Inspection

SUBTASK 54-05-03-010-007

- (1) Open these access panels:

Number	Name/Location
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1

SUBTASK 54-05-03-210-007

- (2) Do a general visual inspection of the aft engine mount assembly, including thrust links and thrust link pins; mount to engine left, center and right links, including link pins; hanger and evener bar; attach bolts.

SUBTASK 54-05-03-910-007

- (3) 737-6789 Basic Task Description, TASK 51-05-01-210-809.

SUBTASK 54-05-03-410-007

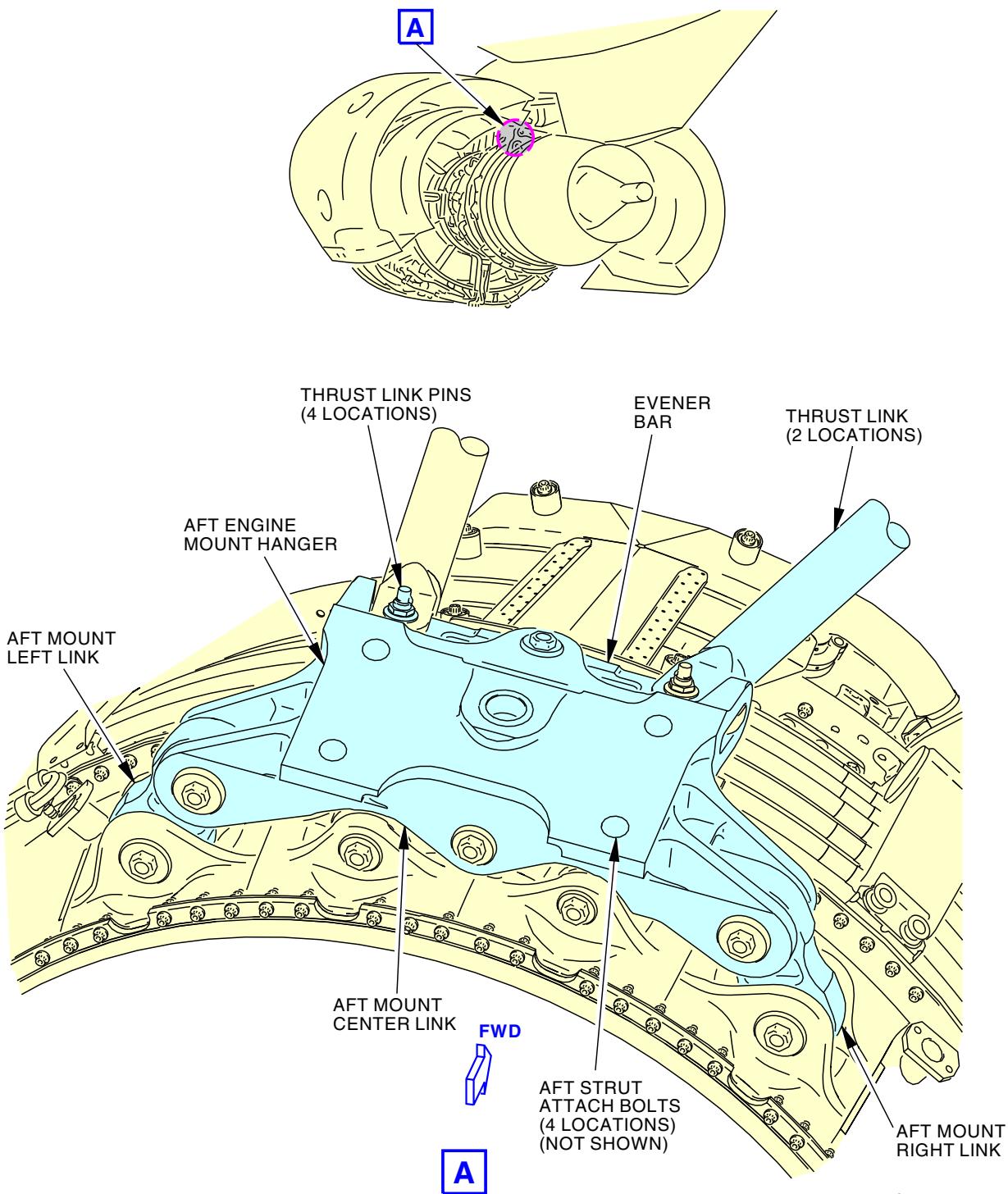
- (4) Close these access panels:

Number	Name/Location
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1

— END OF TASK —



54-05-03



361778 S0000132416_V3

Left Aft Engine Mount
Figure 207/54-05-03-990-811 (Sheet 1 of 2)

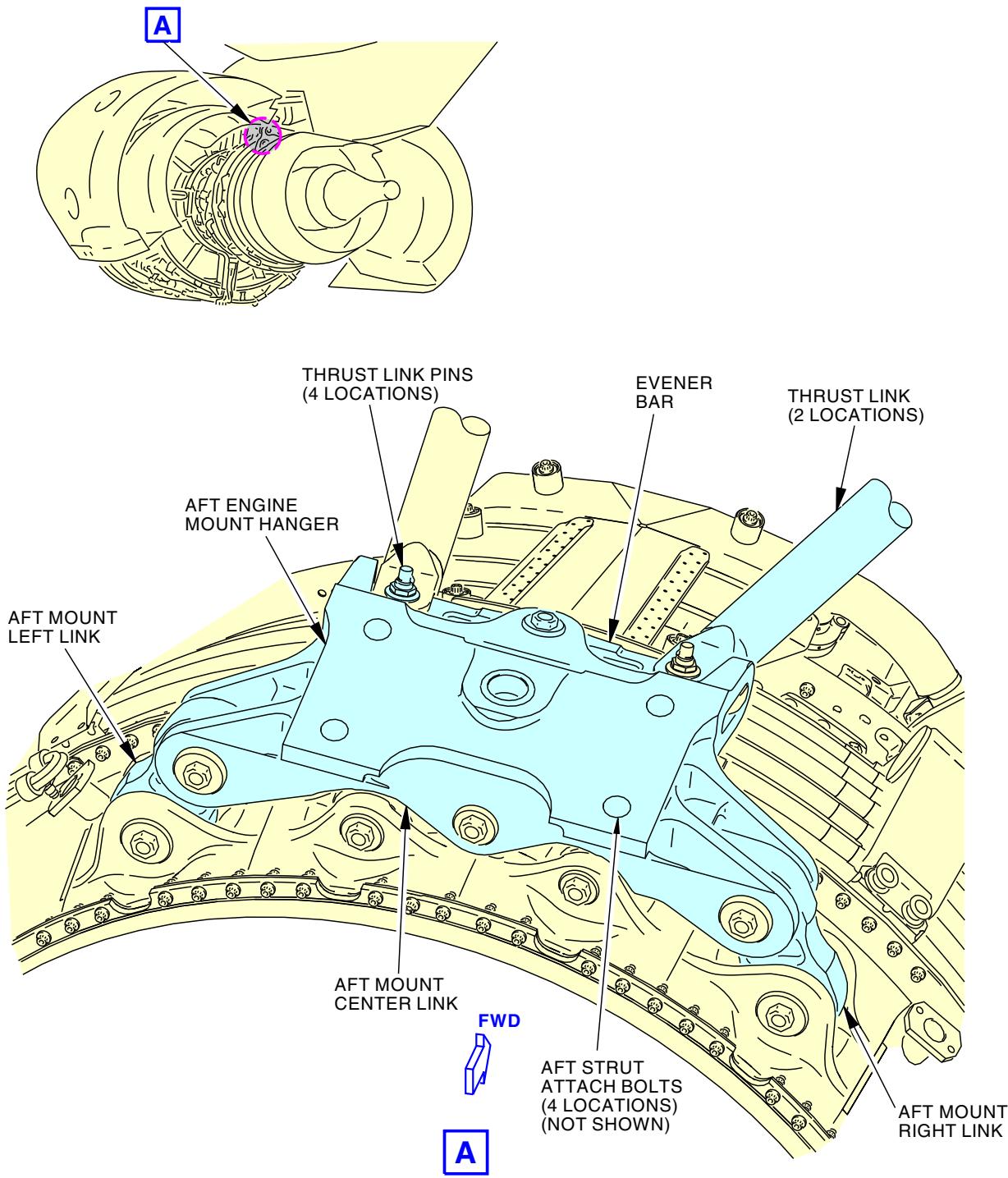
EFFECTIVITY
 LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
 422-426 PRE SB 737-78-1089

54-05-03

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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2081405 S0000433901_V3

Left Aft Engine Mount
Figure 207/54-05-03-990-811 (Sheet 2 of 2)

EFFECTIVITY
LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
407, 411, 412, 415, 416, 420, 422-426 POST SB
737-78-1089

54-05-03

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details



737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL

TASK 54-05-03-210-808

8. EXTERNAL - GENERAL VISUAL: RIGHT STRUT AFT ENGINE MOUNT ASSEMBLY

(Figure 208)

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)

B. Location Zones

Zone	Area
425	Engine 2 - Thrust Reverser, Left
426	Engine 2 - Thrust Reverser, Right

C. Access Panels

Number	Name/Location
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

D. Inspection

SUBTASK 54-05-03-010-008

- (1) Open these access panels:

Number	Name/Location
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

SUBTASK 54-05-03-210-008

- (2) Do general visual inspection of the aft engine mount assembly, including thrust links and thrust link pins; mount to engine left, center and right links, including link pins; hanger and evener bar; attach bolts.

SUBTASK 54-05-03-910-008

- (3) 737-6789 Basic Task Description, TASK 51-05-01-210-809.

SUBTASK 54-05-03-410-008

- (4) Close these access panels:

Number	Name/Location
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

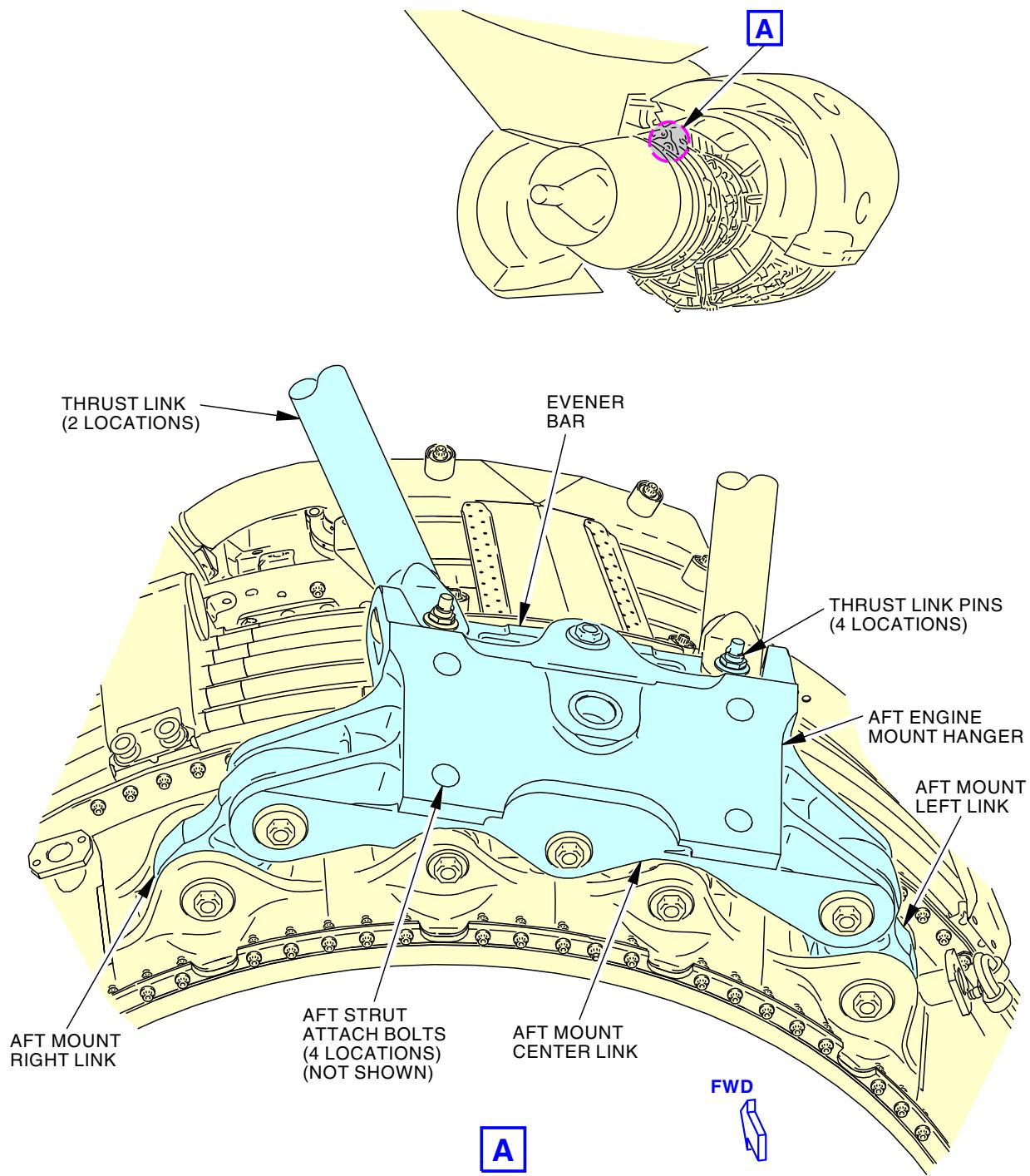
— END OF TASK —

EFFECTIVITY
LOM ALL

54-05-03



737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL



1751238 S0000279506_V3

Right Aft Engine Mount
Figure 208/54-05-03-990-821 (Sheet 1 of 2)

EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-78-1089

54-05-03

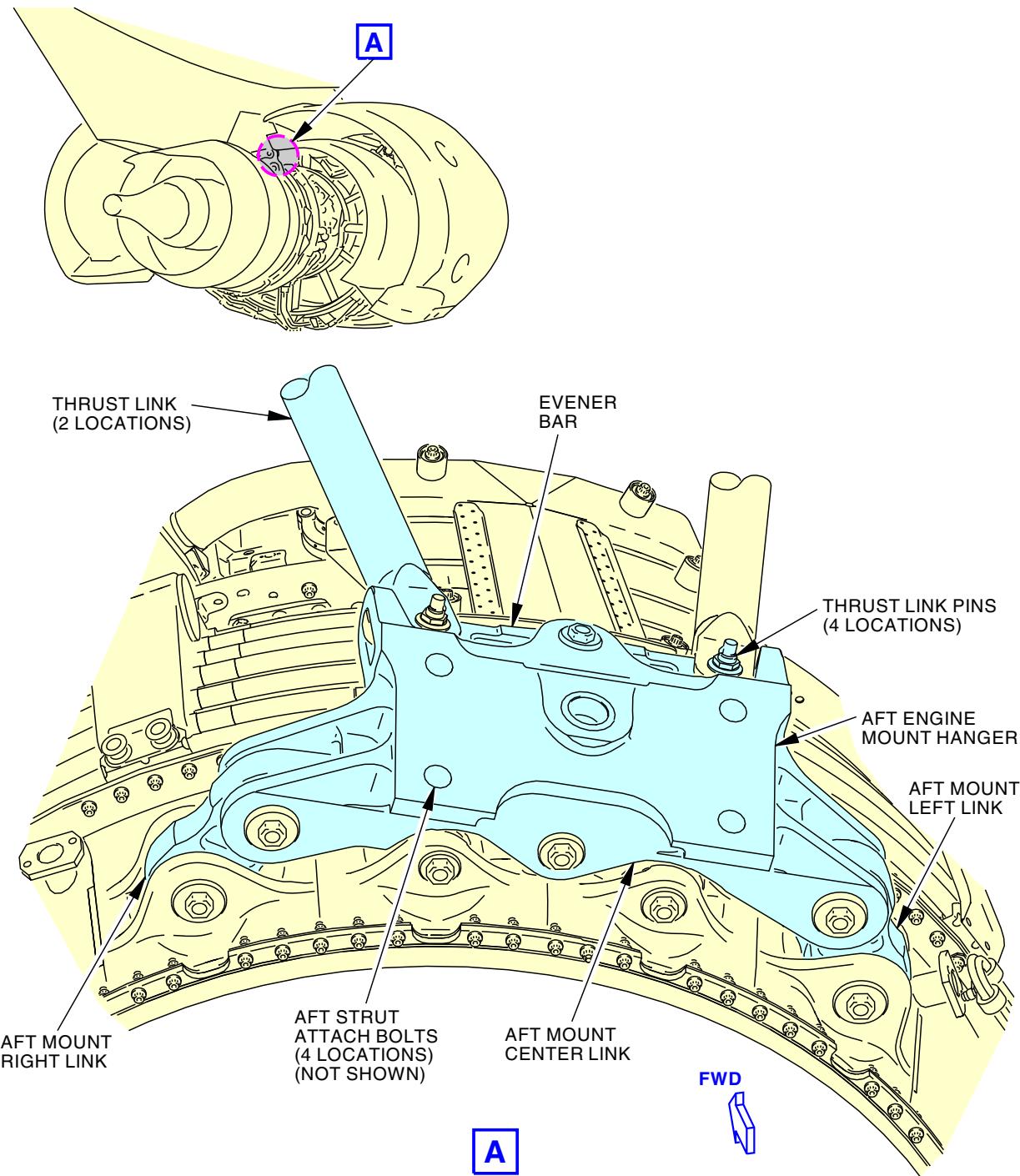
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL



2081406 S0000433902_V3

Right Aft Engine Mount
Figure 208/54-05-03-990-821 (Sheet 2 of 2)

EFFECTIVITY
LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
407, 411, 412, 415, 416, 420, 422-426 POST SB
737-78-1089

54-05-03

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL

TASK 54-05-03-210-809

9. INTERNAL - GENERAL VISUAL: LEFT STRUT TO WING ATTACHMENTS

(Figure 209)

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
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
431DL	Forward Strut Fairing, Left Underwing Fairing, Strut 1
431DR	Forward Strut Fairing, Right Underwing Fairing, Strut 1
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

D. Inspection

SUBTASK 54-05-03-010-009

- (1) To remove the applicable aft fairing access panels, refer to Aft Fairing Access Panel Removal, TASK 54-52-06-010-801.

Open these access panels:

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

SUBTASK 54-05-03-210-009

- (2) Do a general visual inspection of the strut to wing upper link, diagonal brace, side links, and strut attachment fittings.

SUBTASK 54-05-03-910-009

- (3) 737-6789 Basic Task Description, TASK 51-05-01-210-809.

EFFECTIVITY
LOM ALL

54-05-03



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AIRCRAFT MAINTENANCE MANUAL

SUBTASK 54-05-03-410-009

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

Close these access panels:

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

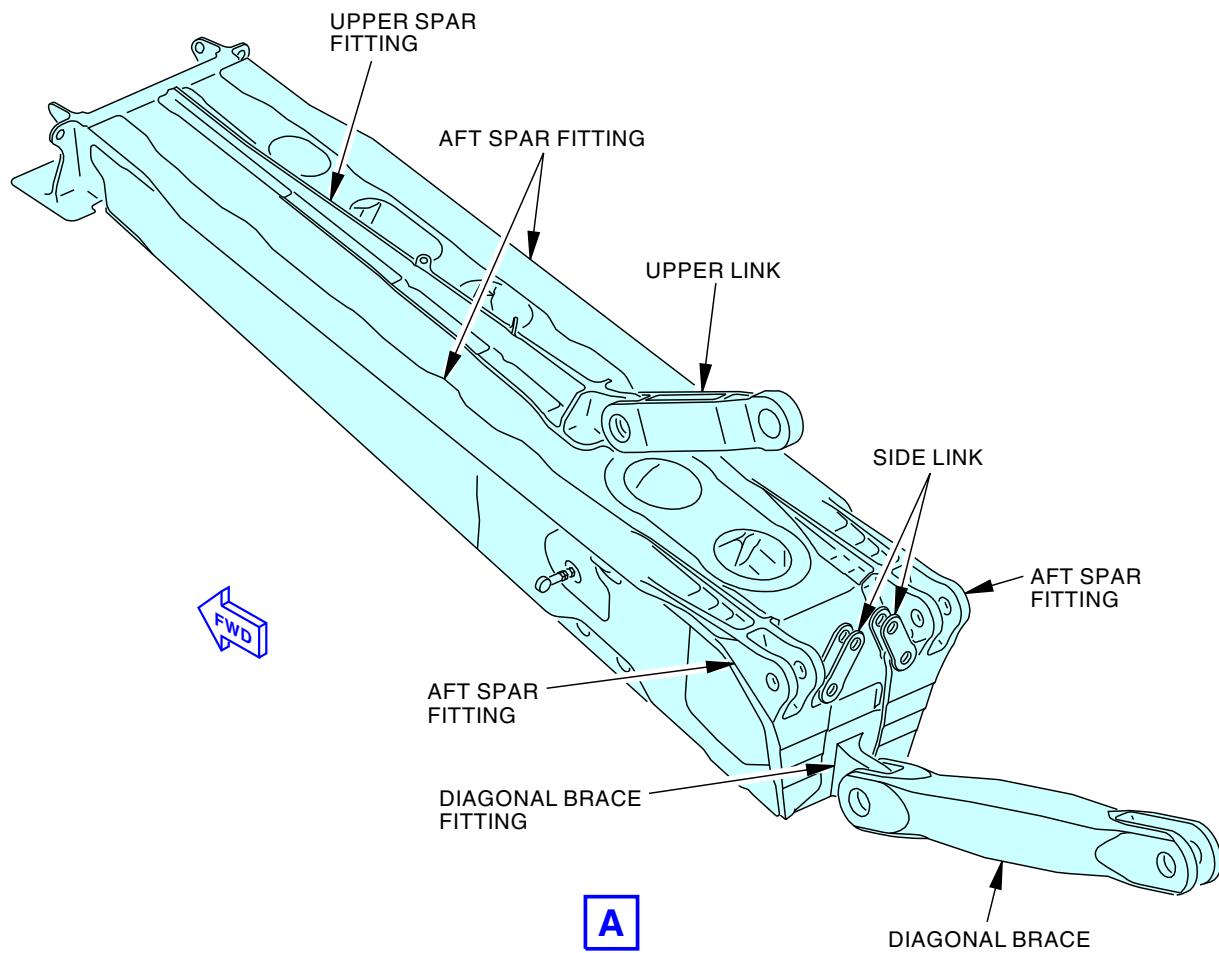
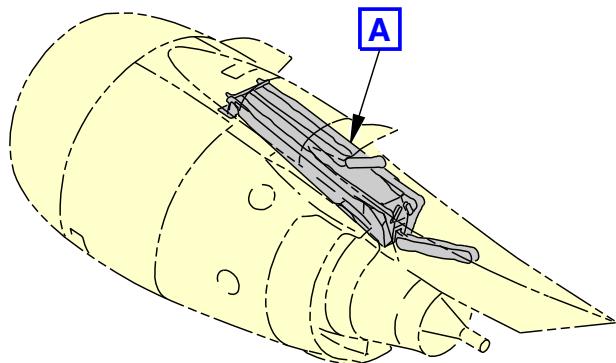
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EFFECTIVITY
LOM ALL

54-05-03



737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL



K56170 S0006584688_V2

Engine Strut-to-Wing Attachments
Figure 209/54-05-03-990-807 (Sheet 1 of 2)

EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-78-1089

54-05-03

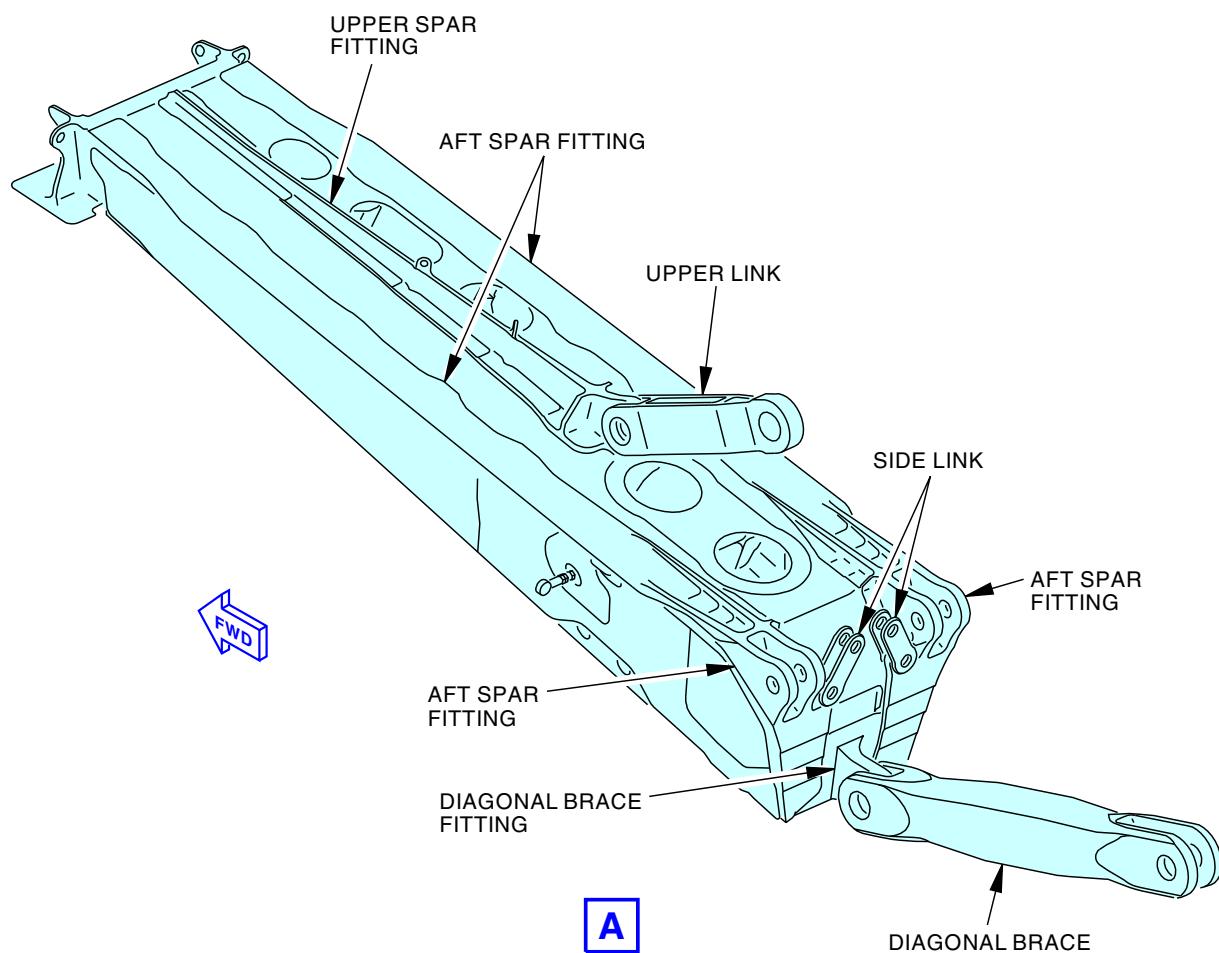
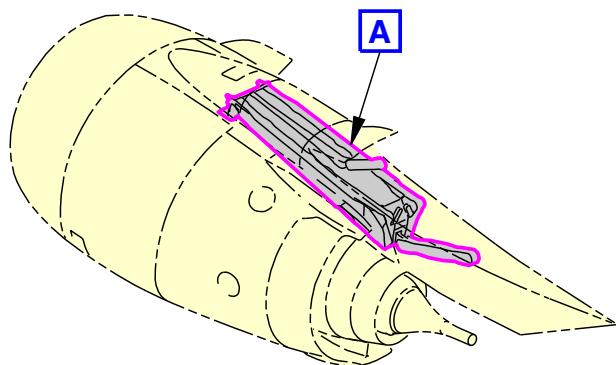
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL



2081414 S0000433903_V2

Engine Strut-to-Wing Attachments
Figure 209/54-05-03-990-807 (Sheet 2 of 2)

EFFECTIVITY
LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
407, 411, 412, 415, 416, 420, 422-426 POST SB
737-78-1089

54-05-03

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL

TASK 54-05-03-210-810

10. INTERNAL - GENERAL VISUAL: RIGHT STRUT TO WING ATTACHMENTS

(Figure 210)

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
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
441DL	Forward Strut Fairing, Left Underwing Fairing, Strut 2
441DR	Forward Strut Fairing, Right Underwing Fairing, Strut 2
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 54-05-03-010-010

- (1) To remove the applicable aft fairing access panels, refer to Aft Fairing Access Panel Removal, TASK 54-52-06-010-801.

Open these access panels:

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

SUBTASK 54-05-03-210-010

- (2) Do a general visual inspection of the strut to wing upper link, diagonal brace, side links, and strut attachment fittings.

SUBTASK 54-05-03-910-010

- (3) 737-6789 Basic Task Description, TASK 51-05-01-210-809.

EFFECTIVITY
LOM ALL

54-05-03



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SUBTASK 54-05-03-410-010

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

Close these access panels:

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

———— END OF TASK ————

EFFECTIVITY
LOM ALL

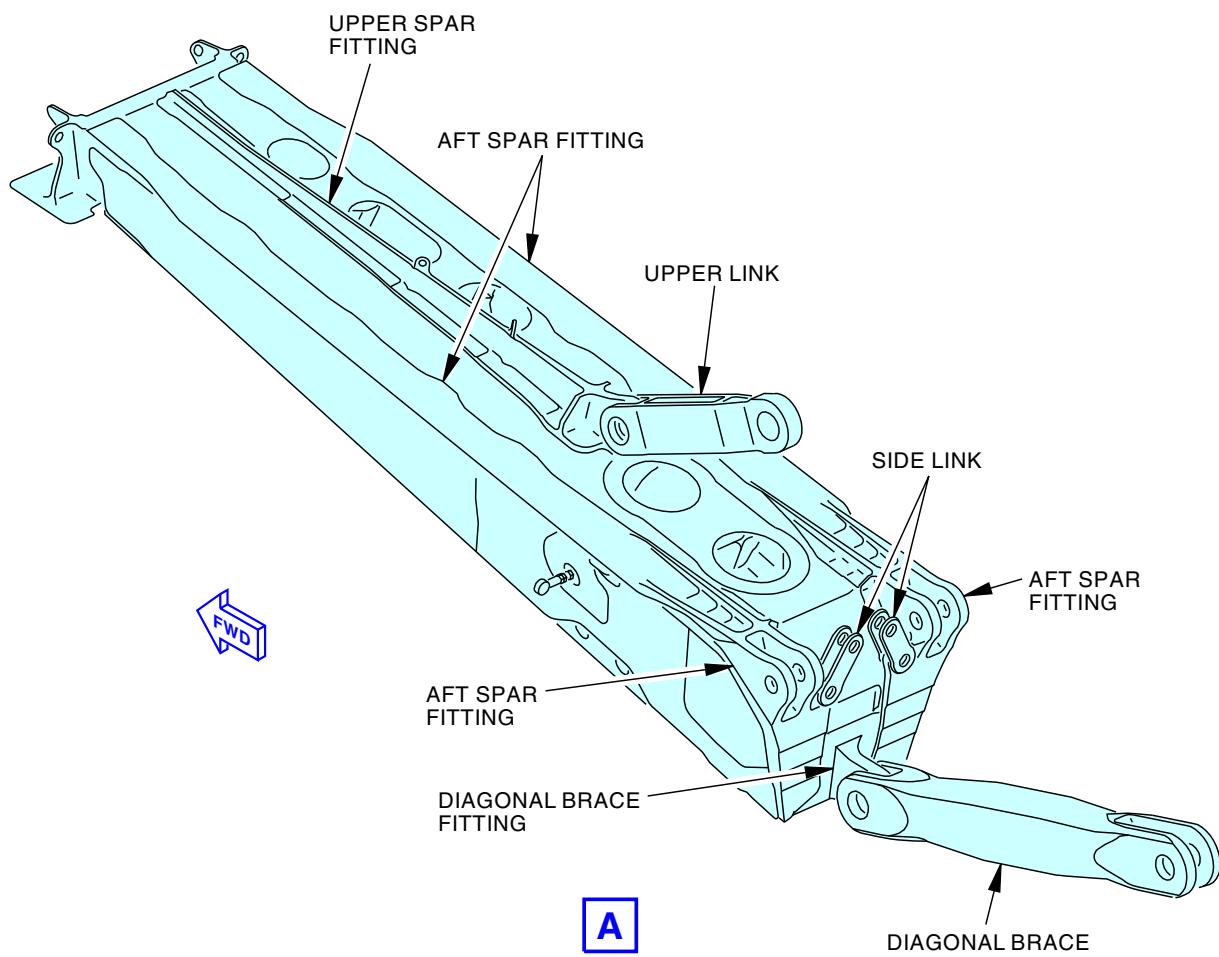
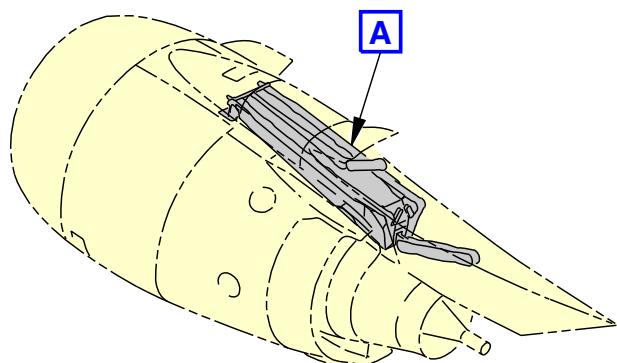
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D633A101-LOM



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AIRCRAFT MAINTENANCE MANUAL



K56171 S0006584691_V2

Engine Strut-to-Wing Attachments
Figure 210/54-05-03-990-808 (Sheet 1 of 2)

EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-78-1089

54-05-03

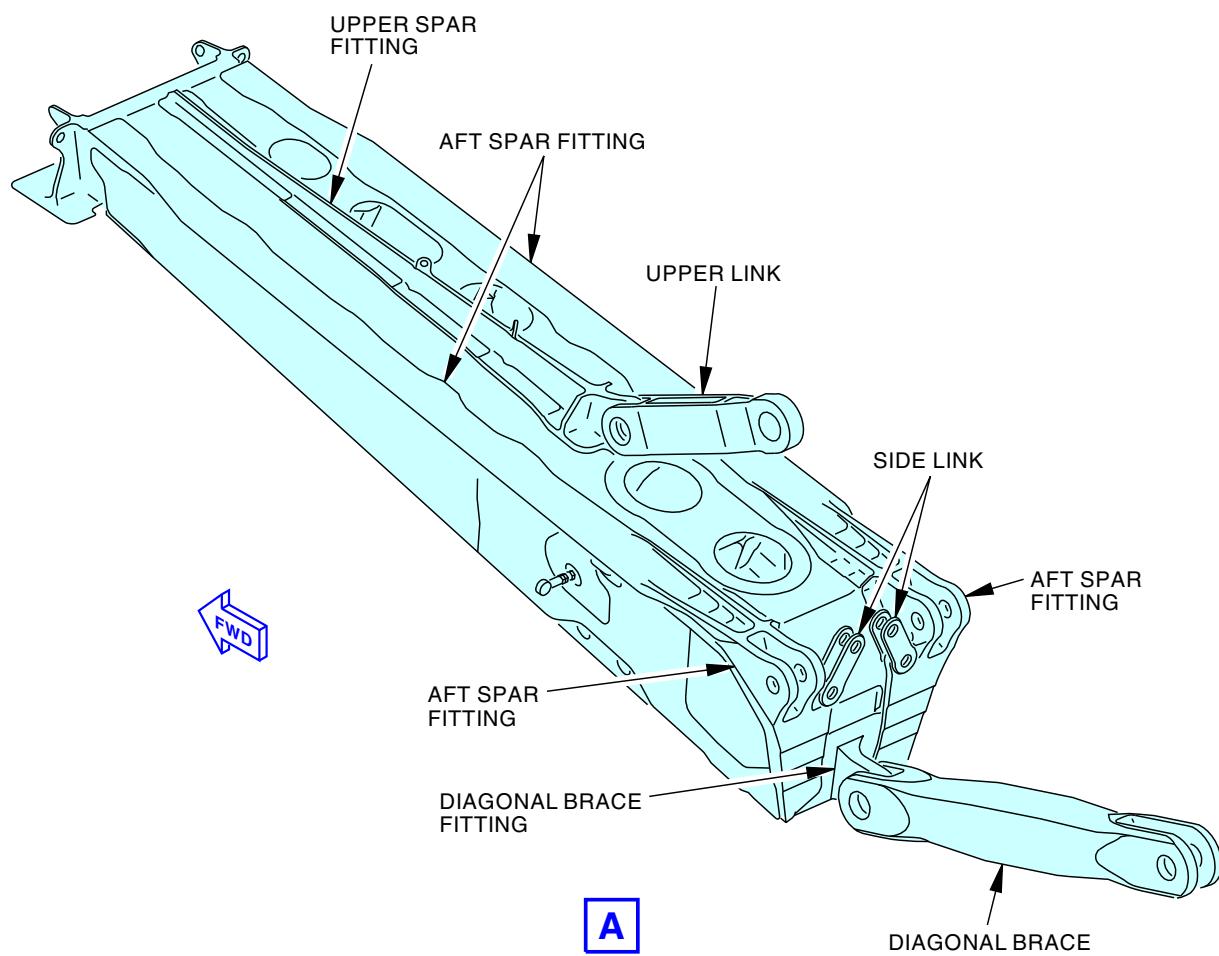
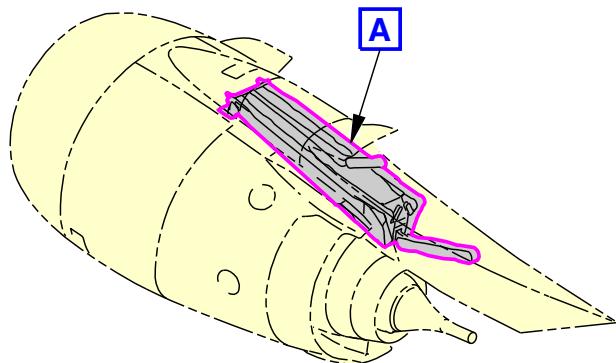
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL



2081415 S0000434100_V2

Engine Strut-to-Wing Attachments
Figure 210/54-05-03-990-808 (Sheet 2 of 2)

EFFECTIVITY
LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
407, 411, 412, 415, 416, 420, 422-426 POST SB
737-78-1089

54-05-03

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL

TASK 54-05-03-211-801

11. INTERNAL - DETAILED: LEFT STRUT TO WING ATTACHMENTS - PINS AND FUSE PINS

(Figure 211)

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
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
431DL	Forward Strut Fairing, Left Underwing Fairing, Strut 1
431DR	Forward Strut Fairing, Right Underwing Fairing, Strut 1
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

D. Inspection

SUBTASK 54-05-03-010-019

- (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:

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 54-05-03-010-015

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

- (a) Remove these access panels:

Number	Name/Location
431CL	Forward Strut Fairing, Left Overwing Fairing, Strut 1
431CR	Forward Strut Fairing, Right Overwing Fairing, Strut 1
431DL	Forward Strut Fairing, Left Underwing Fairing, Strut 1
431DR	Forward Strut Fairing, Right Underwing Fairing, Strut 1
431EL	Forward Strut Fairing, Left T.R. Strut Fairing, Strut 1
431ER	Forward Strut Fairing, Right T.R. Strut Fairing, Strut 1

EFFECTIVITY
LOM ALL

54-05-03



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AIRCRAFT MAINTENANCE MANUAL

SUBTASK 54-05-03-211-001

- (3) Do a detailed inspection of the pins and fuse pins on upper link, midspar, diagonal brace, and side links.

NOTE: Pin removal is not required.

SUBTASK 54-05-03-910-011

- (4) 737-6789 Basic Task Description, TASK 51-05-01-210-809.

SUBTASK 54-05-03-010-020

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

- (a) Install these access panels:

<u>Number</u>	<u>Name/Location</u>
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 54-05-03-410-015

- (6) Install these FWD fairing access panels:

- (a) Install these access panels:

<u>Number</u>	<u>Name/Location</u>
431CL	Forward Strut Fairing, Left Overwing Fairing, Strut 1
431CR	Forward Strut Fairing, Right Overwing Fairing, Strut 1
431DL	Forward Strut Fairing, Left Underwing Fairing, Strut 1
431DR	Forward Strut Fairing, Right Underwing Fairing, Strut 1
431EL	Forward Strut Fairing, Left T.R. Strut Fairing, Strut 1
431ER	Forward Strut Fairing, Right T.R. Strut Fairing, Strut 1

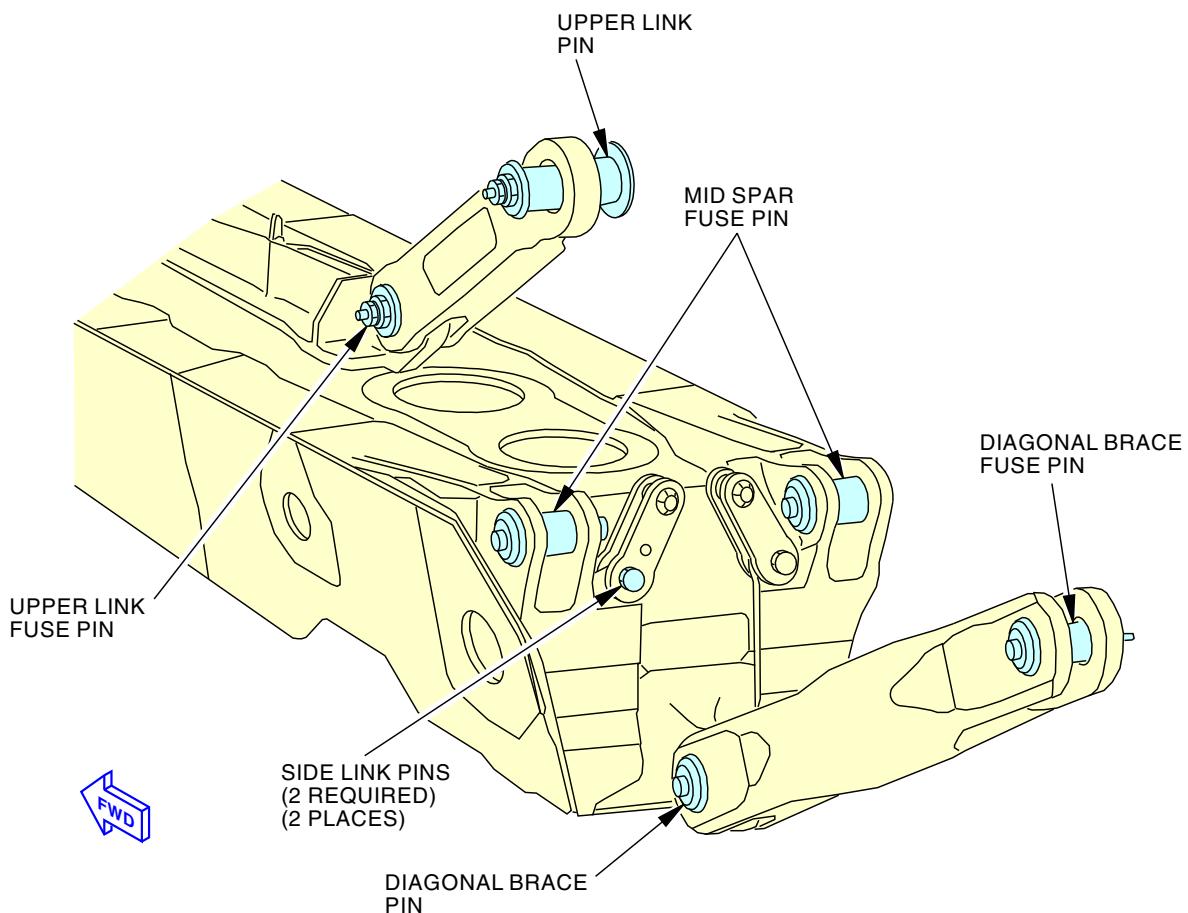
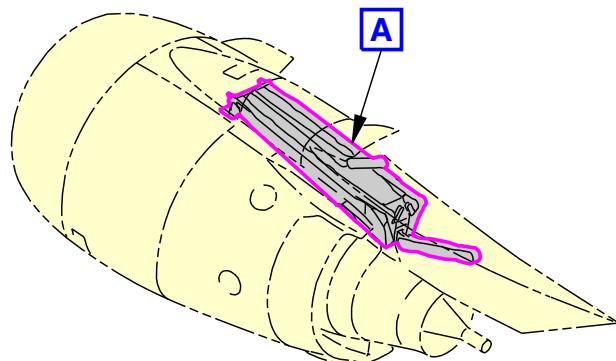
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54-05-03



737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL



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Engine Strut-to-Wing Pins
Figure 211/54-05-03-990-809 (Sheet 1 of 2)

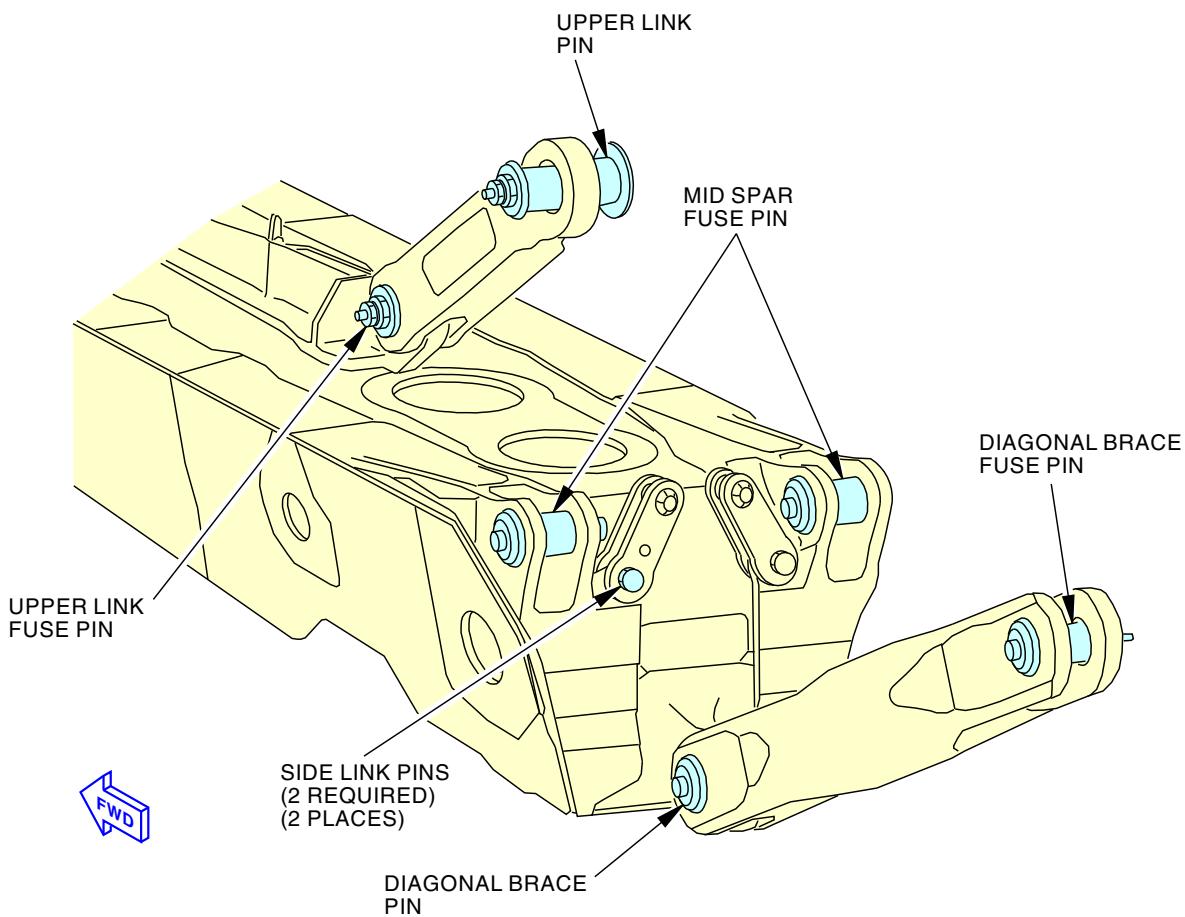
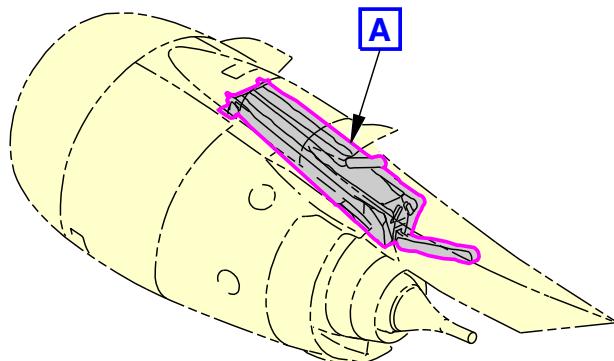
EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-78-1089

54-05-03

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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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2081741 S0000434120_V2

Engine Strut-to-Wing Pins
Figure 211/54-05-03-990-809 (Sheet 2 of 2)

EFFECTIVITY
LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
407, 411, 412, 415, 416, 420, 422-426 POST SB
737-78-1089

54-05-03

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL

TASK 54-05-03-211-802

12. INTERNAL - DETAILED: RIGHT STRUT TO WING ATTACHMENTS - PINS AND FUSE PINS

(Figure 212)

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
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
441DL	Forward Strut Fairing, Left Underwing Fairing, Strut 2
441DR	Forward Strut Fairing, Right Underwing Fairing, Strut 2
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 54-05-03-010-021

- (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:

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 54-05-03-010-016

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

- (a) Remove these access panels:

Number	Name/Location
441CL	Forward Strut Fairing, Left Overwing Fairing, Strut 2
441CR	Forward Strut Fairing, Right Overwing Fairing, Strut 2
441DL	Forward Strut Fairing, Left Underwing Fairing, Strut 2
441DR	Forward Strut Fairing, Right Underwing Fairing, Strut 2
441EL	Forward Strut Fairing, Left T.R. Strut Fairing, Strut 2
441ER	Forward Strut Fairing, Right T.R. Strut Fairing, Strut 2

EFFECTIVITY
LOM ALL

54-05-03



737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL

SUBTASK 54-05-03-211-002

- (3) Do a detailed inspection of the pins and fuse pins on upper link, midspar, diagonal brace, and side links.

NOTE: Pin removal is not required.

SUBTASK 54-05-03-910-012

- (4) 737-6789 Basic Task Description, TASK 51-05-01-210-809.

SUBTASK 54-05-03-410-019

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

- (a) Install these access panels:

<u>Number</u>	<u>Name/Location</u>
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 54-05-03-410-016

- (6) Install these FWD fairing access panels:

- (a) Install these access panels:

<u>Number</u>	<u>Name/Location</u>
441CL	Forward Strut Fairing, Left Overwing Fairing, Strut 2
441CR	Forward Strut Fairing, Right Overwing Fairing, Strut 2
441DL	Forward Strut Fairing, Left Underwing Fairing, Strut 2
441DR	Forward Strut Fairing, Right Underwing Fairing, Strut 2
441EL	Forward Strut Fairing, Left T.R. Strut Fairing, Strut 2
441ER	Forward Strut Fairing, Right T.R. Strut Fairing, Strut 2

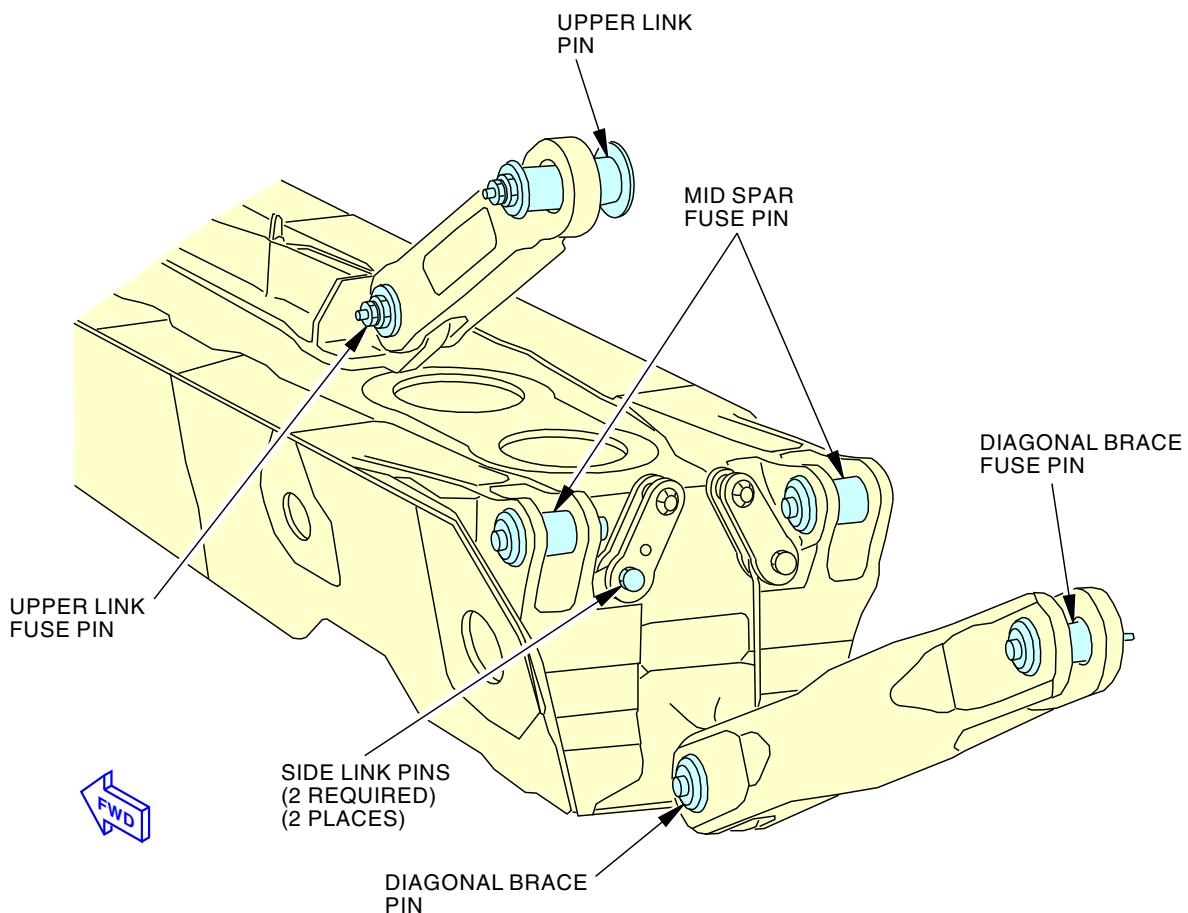
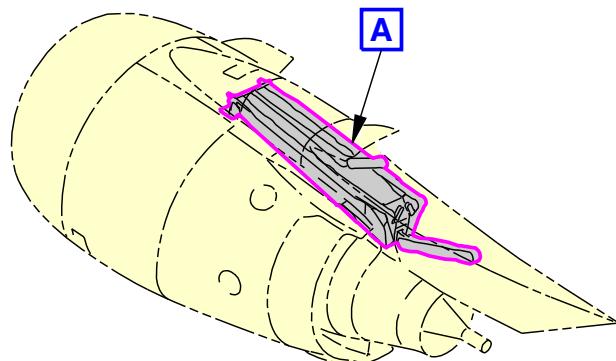
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EFFECTIVITY
LOM ALL

54-05-03



737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL



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Engine Strut-to-Wing Pins
Figure 212/54-05-03-990-810 (Sheet 1 of 2)

EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-78-1089

54-05-03

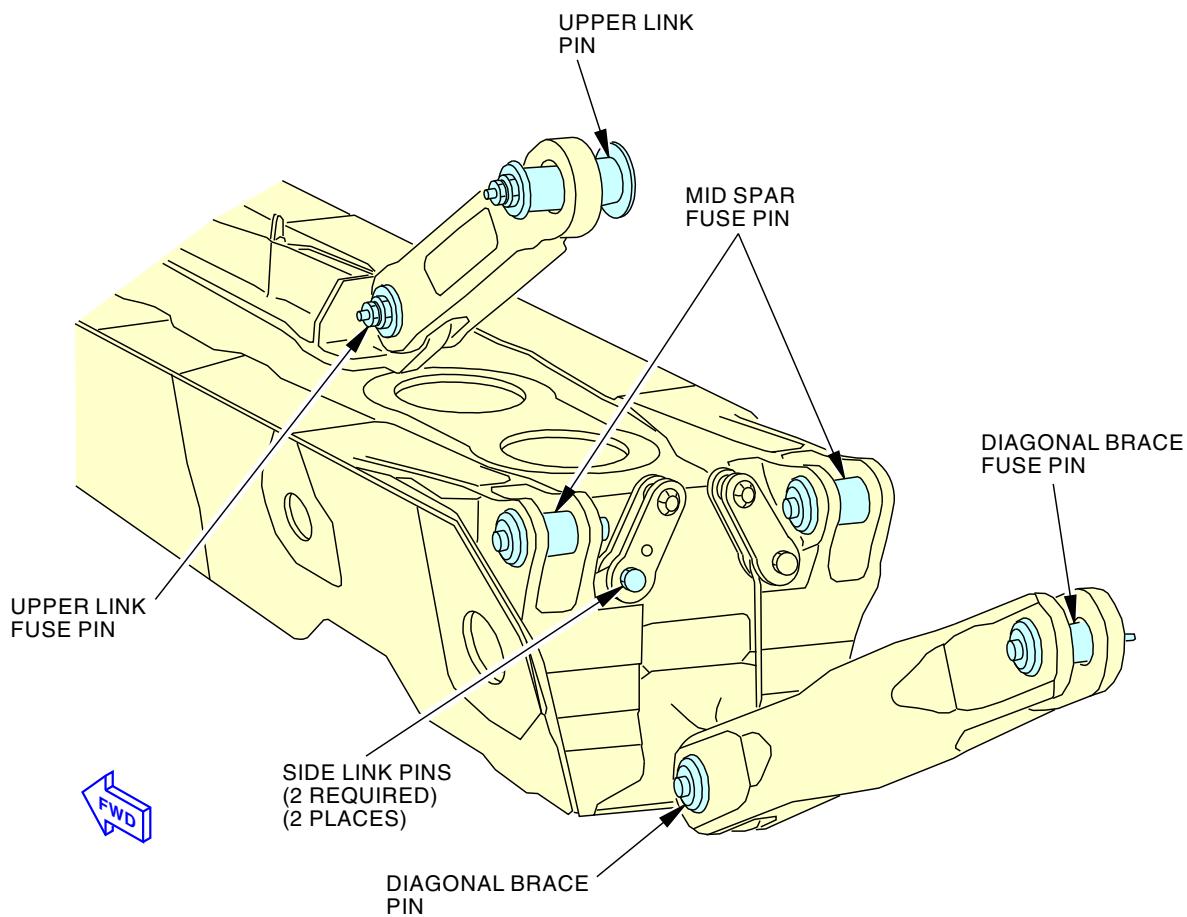
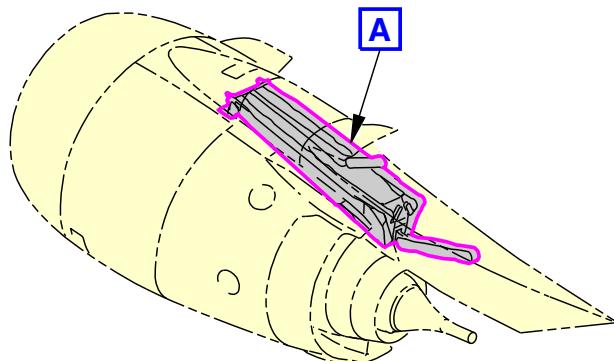
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AIRCRAFT MAINTENANCE MANUAL



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2081739 S0000436538_V2

Engine Strut-to-Wing Pins
Figure 212/54-05-03-990-810 (Sheet 2 of 2)

EFFECTIVITY
LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
407, 411, 412, 415, 416, 420, 422-426 POST SB
737-78-1089

54-05-03

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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL

TASK 54-05-03-211-803

13. INTERNAL - DETAILED: LEFT STRUT TO WING ATTACHMENTS

(Figure 213)

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
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
431DL	Forward Strut Fairing, Left Underwing Fairing, Strut 1
431DR	Forward Strut Fairing, Right Underwing Fairing, Strut 1
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

D. Inspection

SUBTASK 54-05-03-010-017

- (1) To remove the applicable aft fairing access panels, refer to Aft Fairing Access Panel Removal, TASK 54-52-06-010-801.

Open these access panels:

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

NOTE: Thrust reversers must be open to remove access panels 431EL and 431ER.

SUBTASK 54-05-03-211-003

- (2) Do a detailed inspection of the bores of pins and fuse pins on upper link, midspars, diagonal brace, and side links.

NOTE: Bolts, washers, nuts and end caps removed. Pin removal is not required.

EFFECTIVITY
LOM ALL

54-05-03



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SUBTASK 54-05-03-910-013

- (3) 737-6789 Basic Task Description, TASK 51-05-01-210-809.

SUBTASK 54-05-03-410-017

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

Close these access panels:

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

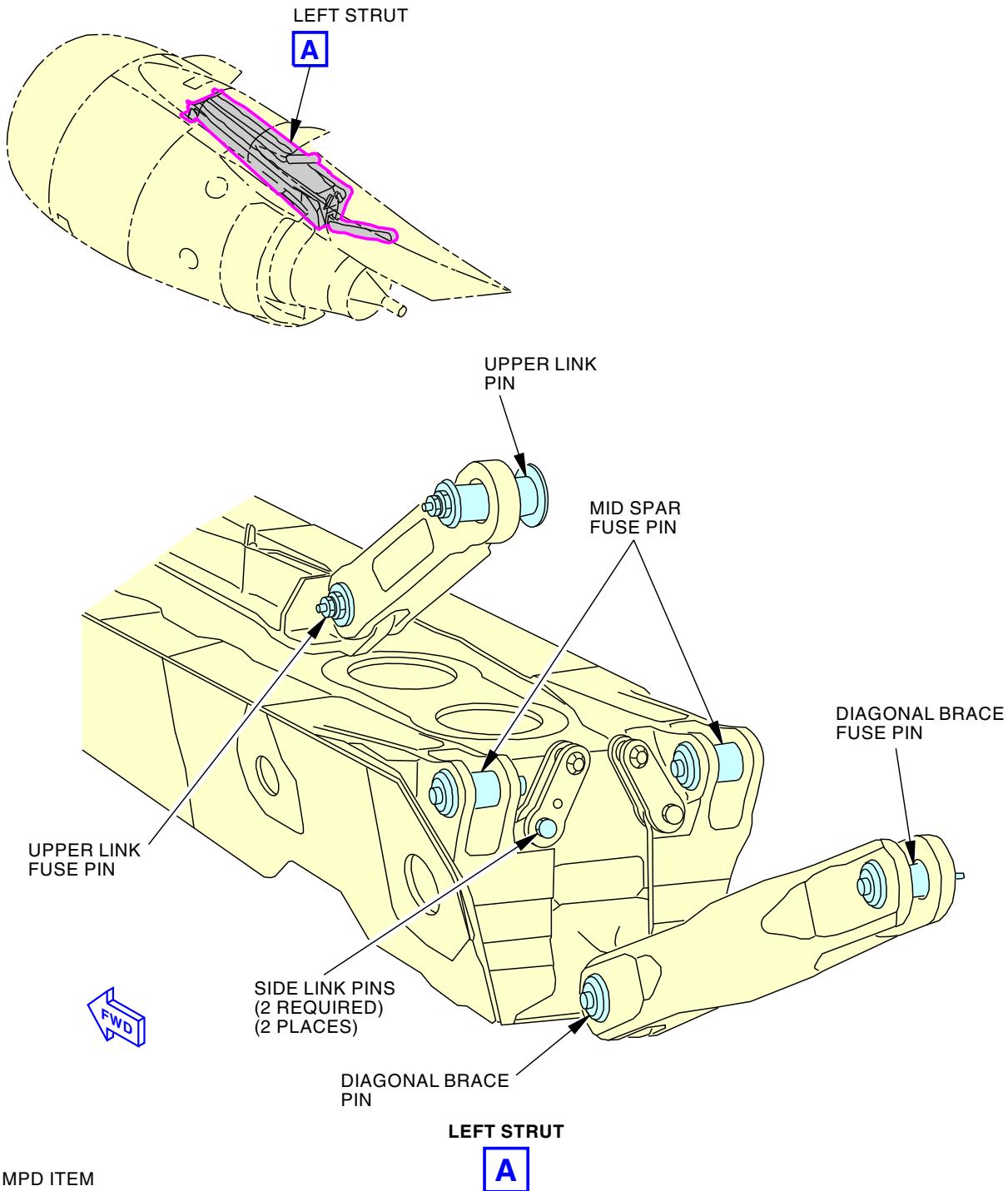
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EFFECTIVITY
LOM ALL

54-05-03

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D633A101-LOM



MPD ITEM
54-060-01

D63226 S0000162559_V4

Left Strut-To-Wing Pins
Figure 213/54-05-03-990-820 (Sheet 1 of 2)

EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-78-1089

54-05-03

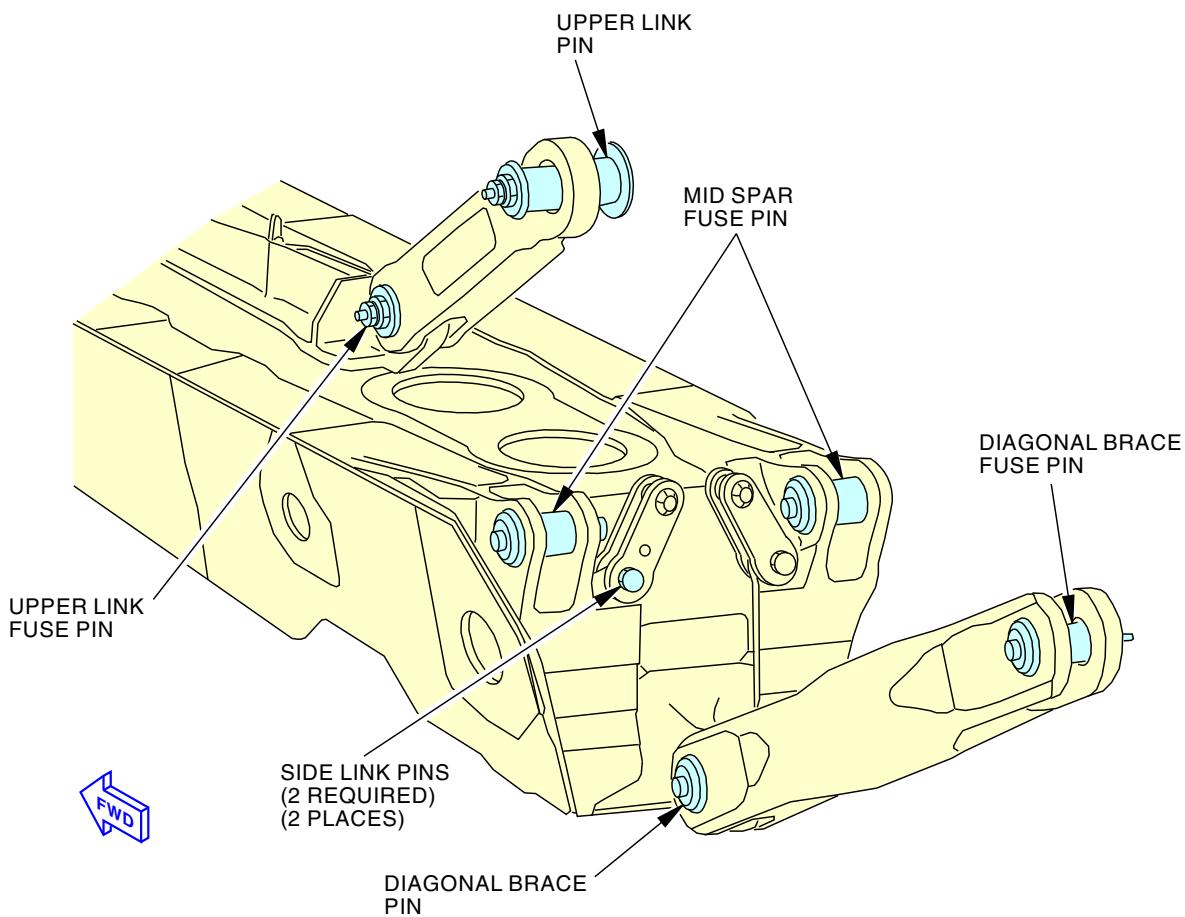
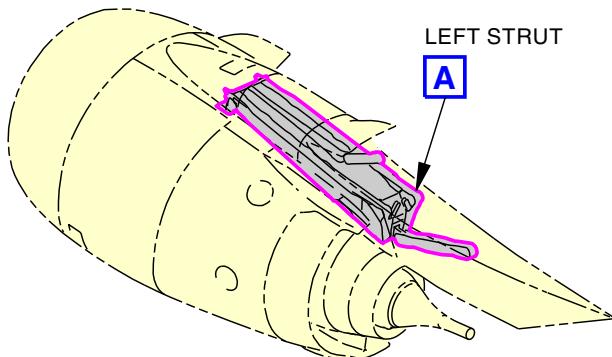
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL



MPD ITEM
54-060-01

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2081735 S0000436622_V3

Left Strut-To-Wing Pins
Figure 213/54-05-03-990-820 (Sheet 2 of 2)

EFFECTIVITY
LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
407, 411, 412, 415, 416, 420, 422-426 POST SB
737-78-1089

54-05-03

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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL

TASK 54-05-03-211-804

14. INTERNAL - DETAILED: RIGHT STRUT TO WING ATTACHMENTS

(Figure 214)

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
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
441DL	Forward Strut Fairing, Left Underwing Fairing, Strut 2
441DR	Forward Strut Fairing, Right Underwing Fairing, Strut 2
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 54-05-03-010-018

- (1) To remove the applicable aft fairing access panels, refer to Aft Fairing Access Panel Removal, TASK 54-52-06-010-801.

Open these access panels:

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

NOTE: Thrust reversers must be open to remove access panels 441EL and 441ER.

SUBTASK 54-05-03-211-004

- (2) Do a detailed inspection of the bores of pins and fuse pins on upper link, midspars, diagonal brace, and side links.

NOTE: Bolts, washers, nuts, and end caps removed. Pin removal is not required.

EFFECTIVITY
LOM ALL

54-05-03



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SUBTASK 54-05-03-910-014

- (3) 737-6789 Basic Task Description, TASK 51-05-01-210-809.

SUBTASK 54-05-03-410-018

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

Close these access panels:

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

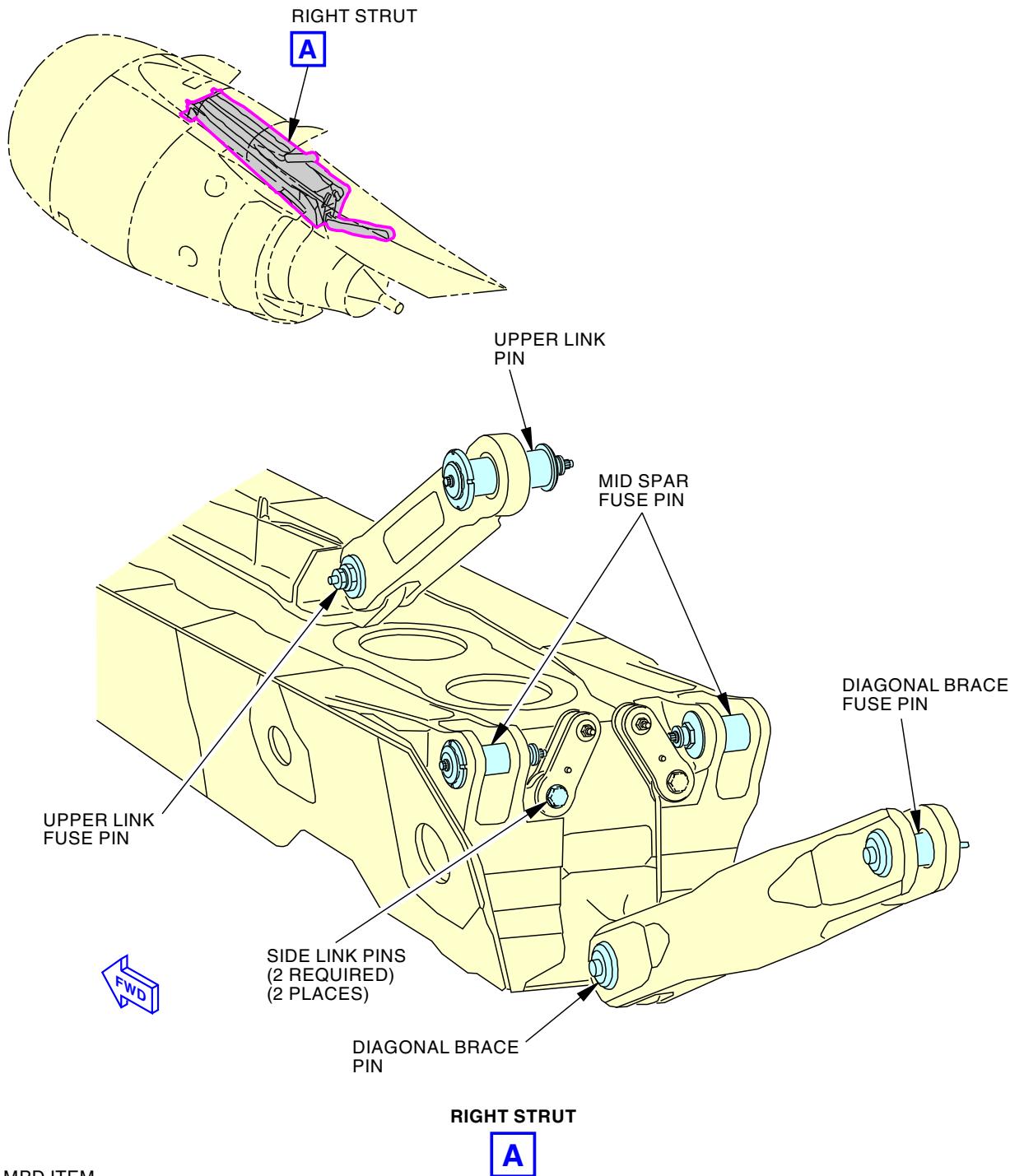
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— EFFECTIVITY —
LOM ALL

54-05-03

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D633A101-LOM

MPD ITEM
54-060-02

D63229 S0000162558_V4

Right Strut-To-Wing-Pins
Figure 214/54-05-03-990-819 (Sheet 1 of 2)

EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-78-1089

54-05-03

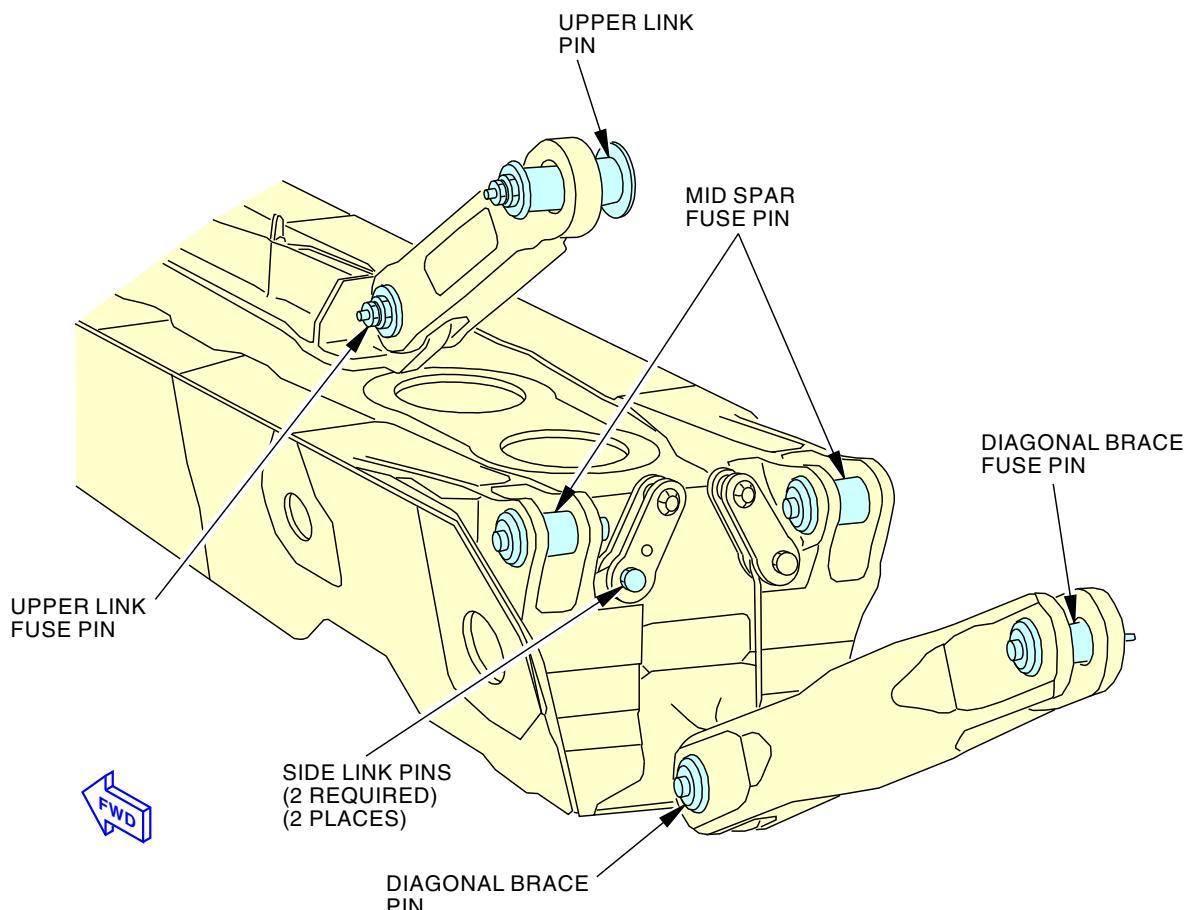
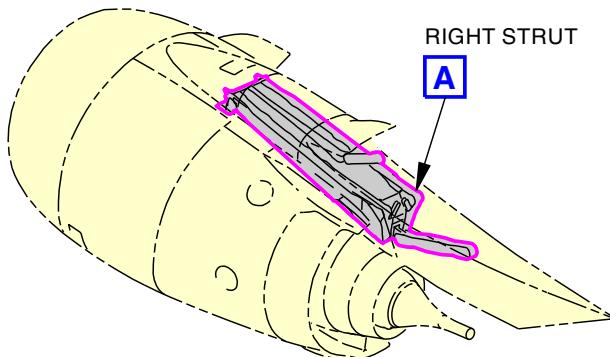
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL



MPD ITEM
54-060-02

RIGHT STRUT

A

2081672 S0000436623_V3

Right Strut-To-Wing-Pins
Figure 214/54-05-03-990-819 (Sheet 2 of 2)

EFFECTIVITY
LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
407, 411, 412, 415, 416, 420, 422-426 POST SB
737-78-1089

54-05-03

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL

TASK 54-05-03-210-811

15. INTERNAL - GENERAL VISUAL: EXTERNAL - LEFT STRUT BOX

(Figure 215, Figure 216)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-803	737-6789 Basic Task Description (P/B 201)
54-54-01-000-802	Strut Mid Insulation Blankets Removal (P/B 401)
54-54-01-000-803	Strut Aft Insulation Blankets Removal (P/B 401)
54-54-01-000-804	Strut Aft Insulation Blankets Removal (P/B 401)
54-54-01-400-802	Strut Mid Insulation Blankets Installation (P/B 401)
54-54-01-400-803	Strut Aft Insulation Blankets Installation (P/B 401)
54-54-01-400-804	Strut Aft Insulation Blankets Installation (P/B 401)
71-11-02-000-801-F00	Fan Cowl Panel Removal (Selection) (P/B 401)
71-11-02-400-801-F00	Fan Cowl Panel Installation (Selection) (P/B 401)
78-31-00-010-801-F00	Open the Thrust Reverser (Selection) (P/B 201)
78-31-00-010-804-F00	Close the Thrust Reverser (Selection) (P/B 201)

B. Location Zones

Zone	Area
433	Engine 1 - Strut Torque Box

C. Access Panels

Number	Name/Location
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1
431AT	Forward Strut Fairing, Thumbnail Fairing, Strut 1
431BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 1
431BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 1
431CL	Forward Strut Fairing, Left Overwing Fairing, Strut 1
431CR	Forward Strut Fairing, Right Overwing Fairing, Strut 1
431DL	Forward Strut Fairing, Left Underwing Fairing, Strut 1
431DR	Forward Strut Fairing, Right Underwing Fairing, Strut 1
431EL	Forward Strut Fairing, Left T.R. Strut Fairing, Strut 1
431ER	Forward Strut Fairing, Right T.R. Strut Fairing, Strut 1
S4331	Left Strut Box External Inspection

D. Inspection

SUBTASK 54-05-03-010-011

- (1) Open these access panels:

Number	Name/Location
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1

EFFECTIVITY
LOM ALL

54-05-03



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(Continued)

<u>Number</u>	<u>Name/Location</u>
431AT	Forward Strut Fairing, Thumbnail Fairing, Strut 1
431BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 1
431BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 1
431CL	Forward Strut Fairing, Left Overwing Fairing, Strut 1
431CR	Forward Strut Fairing, Right Overwing Fairing, Strut 1
431DL	Forward Strut Fairing, Left Underwing Fairing, Strut 1
431DR	Forward Strut Fairing, Right Underwing Fairing, Strut 1
431EL	Forward Strut Fairing, Left T.R. Strut Fairing, Strut 1
431ER	Forward Strut Fairing, Right T.R. Strut Fairing, Strut 1

Special Access:

<u>Number</u>	<u>Name/Location</u>
S4331	Left Strut Box External Inspection

NOTE: Thrust reversers must be open to remove access panels 431EL and 431ER. The removal of the engine is not necessary.

SUBTASK 54-05-03-010-022

- (2) Remove the fan cowls, do this task: Fan Cowl Panel Removal (Selection),
TASK 71-11-02-000-801-F00.

SUBTASK 54-05-03-010-023

- (3) Open the Thrust Reverser Left (TRL) and Thrust Reverser Right (TRR), do this task: Open the Thrust Reverser (Selection), TASK 78-31-00-010-801-F00.

SUBTASK 54-05-03-010-024

- (4) Remove the mid insulation blankets, do this task: Strut Mid Insulation Blankets Removal,
TASK 54-54-01-000-802.

SUBTASK 54-05-03-010-029

- (5) Remove the aft insulation blankets, do this task: Strut Aft Insulation Blankets Removal,
TASK 54-54-01-000-803, or Strut Aft Insulation Blankets Removal, TASK 54-54-01-000-804.

SUBTASK 54-05-03-210-011

- (6) Do a general visual inspection of the external areas of strut box, including upper and lower spars, forward engine mount bulkhead, aft bulkhead, and side skins.

SUBTASK 54-05-03-910-015

- (7) 737-6789 Basic Task Description, TASK 51-05-01-210-803.

SUBTASK 54-05-03-410-020

- (8) Install the aft insulation blankets, do this task: Strut Aft Insulation Blankets Installation,
TASK 54-54-01-400-803, or Strut Aft Insulation Blankets Installation, TASK 54-54-01-400-804.

SUBTASK 54-05-03-410-021

- (9) Install the mid insulation blankets, do this task: Strut Mid Insulation Blankets Installation,
TASK 54-54-01-400-802.

SUBTASK 54-05-03-410-022

- (10) Close the TRL and TRR, do this task: Close the Thrust Reverser (Selection),
TASK 78-31-00-010-804-F00.

SUBTASK 54-05-03-410-028

- (11) Install the fan cowls, do this task: Fan Cowl Panel Installation (Selection),
TASK 71-11-02-400-801-F00.

EFFECTIVITY
LOM ALL

54-05-03



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AIRCRAFT MAINTENANCE MANUAL

SUBTASK 54-05-03-410-011

- (12) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1
431AT	Forward Strut Fairing, Thumbnail Fairing, Strut 1
431BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 1
431BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 1
431CL	Forward Strut Fairing, Left Overwing Fairing, Strut 1
431CR	Forward Strut Fairing, Right Overwing Fairing, Strut 1
431DL	Forward Strut Fairing, Left Underwing Fairing, Strut 1
431DR	Forward Strut Fairing, Right Underwing Fairing, Strut 1
431EL	Forward Strut Fairing, Left T.R. Strut Fairing, Strut 1
431ER	Forward Strut Fairing, Right T.R. Strut Fairing, Strut 1

———— END OF TASK ————

EFFECTIVITY
LOM ALL

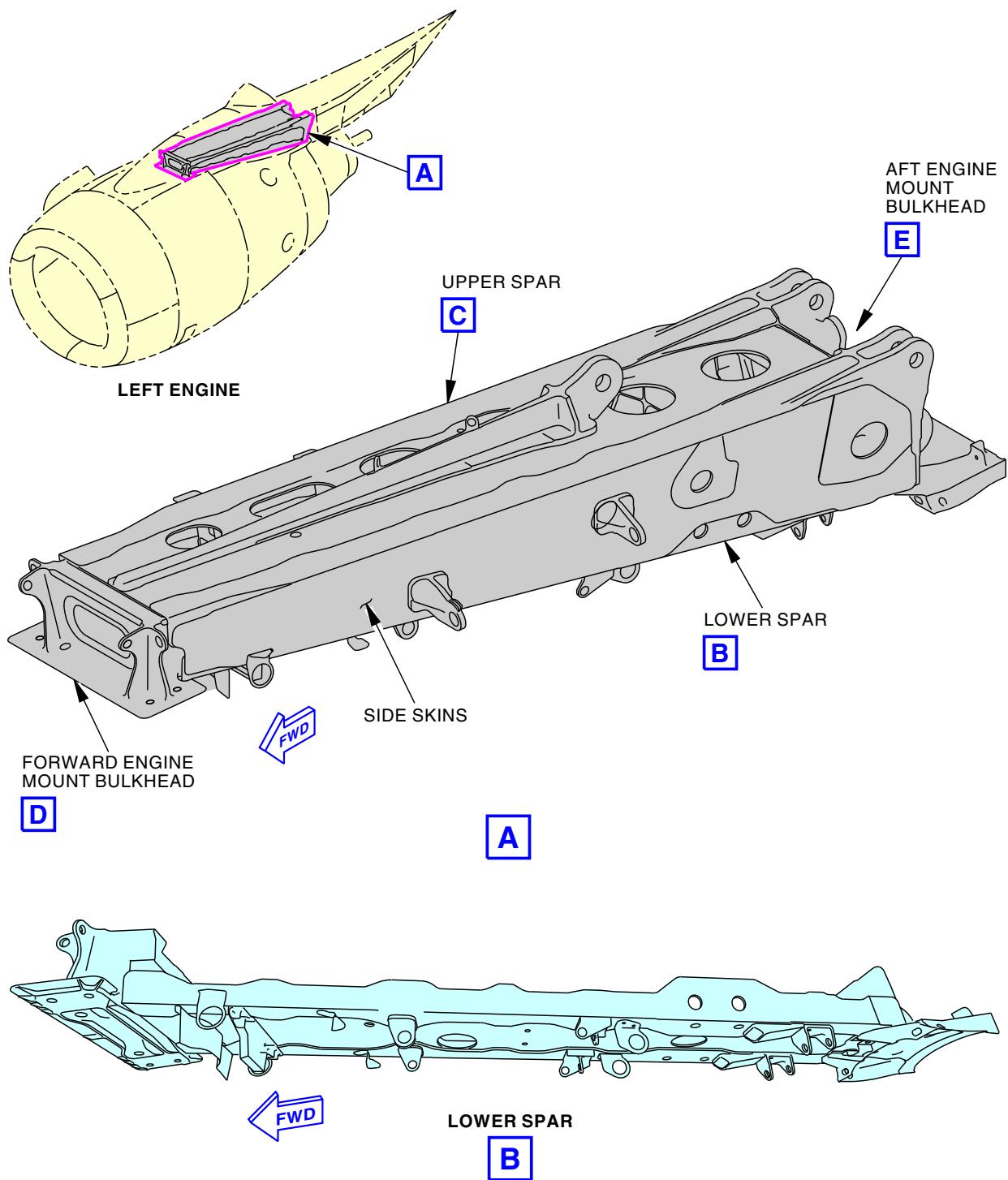
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421666 S0000137953_V2

Left Strut Box - General Visual (Internal)
Figure 215/54-05-03-990-815 (Sheet 1 of 2)

EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-78-1089

54-05-03

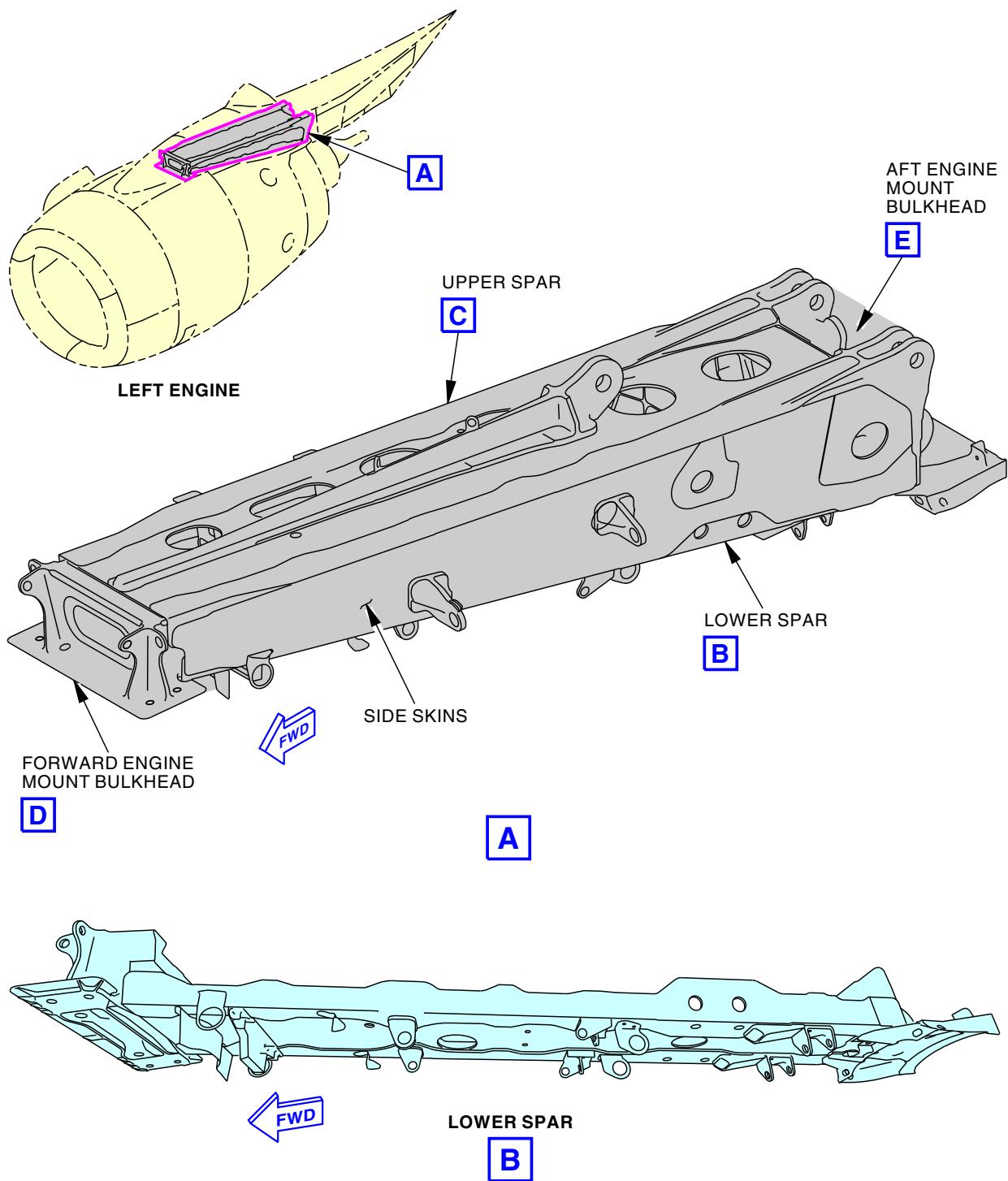
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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2081425 S0000436627_V2

Left Strut Box - General Visual (Internal)
Figure 215/54-05-03-990-815 (Sheet 2 of 2)

EFFECTIVITY
LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
407, 411, 412, 415, 416, 420, 422-426 POST SB
737-78-1089

54-05-03

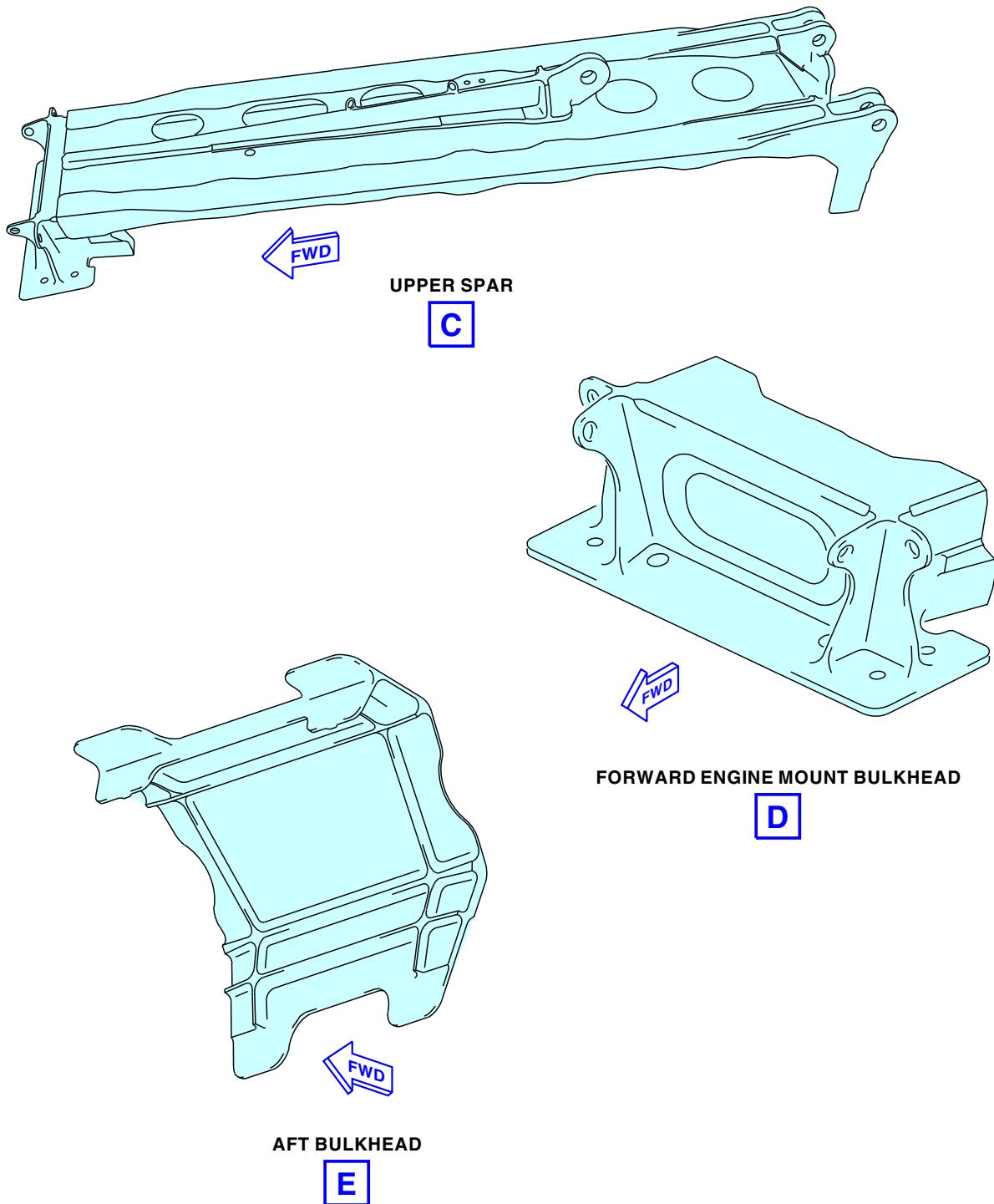
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421667 S0000137954_V3

Left Strut Box - General Visual (Internal)
Figure 216/54-05-03-990-816

EFFECTIVITY
LOM ALL

54-05-03

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TASK 54-05-03-210-812

16. INTERNAL - GENERAL VISUAL: EXTERNAL - RIGHT STRUT BOX

(Figure 217, Figure 218)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-803	737-6789 Basic Task Description (P/B 201)
54-54-01-000-802	Strut Mid Insulation Blankets Removal (P/B 401)
54-54-01-000-803	Strut Aft Insulation Blankets Removal (P/B 401)
54-54-01-000-804	Strut Aft Insulation Blankets Removal (P/B 401)
54-54-01-400-802	Strut Mid Insulation Blankets Installation (P/B 401)
54-54-01-400-803	Strut Aft Insulation Blankets Installation (P/B 401)
54-54-01-400-804	Strut Aft Insulation Blankets Installation (P/B 401)
71-11-02-000-801-F00	Fan Cowl Panel Removal (Selection) (P/B 401)
71-11-02-400-801-F00	Fan Cowl Panel Installation (Selection) (P/B 401)
78-31-00-010-801-F00	Open the Thrust Reverser (Selection) (P/B 201)
78-31-00-010-804-F00	Close the Thrust Reverser (Selection) (P/B 201)

B. Location Zones

Zone	Area
443	Engine 2 - Strut Torque Box

C. Access Panels

Number	Name/Location
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2
441AT	Forward Strut Fairing, Thumbnail Fairing, Strut 2
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
441DL	Forward Strut Fairing, Left Underwing Fairing, Strut 2
441DR	Forward Strut Fairing, Right Underwing Fairing, Strut 2
441EL	Forward Strut Fairing, Left T.R. Strut Fairing, Strut 2
441ER	Forward Strut Fairing, Right T.R. Strut Fairing, Strut 2
S4431	Right Strut Box External Inspection

D. Inspection

SUBTASK 54-05-03-010-012

- (1) Open these access panels:

Number	Name/Location
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

EFFECTIVITY
LOM ALL

54-05-03



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AIRCRAFT MAINTENANCE MANUAL

(Continued)

<u>Number</u>	<u>Name/Location</u>
441AT	Forward Strut Fairing, Thumbnail Fairing, Strut 2
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
441DL	Forward Strut Fairing, Left Underwing Fairing, Strut 2
441DR	Forward Strut Fairing, Right Underwing Fairing, Strut 2
441EL	Forward Strut Fairing, Left T.R. Strut Fairing, Strut 2
441ER	Forward Strut Fairing, Right T.R. Strut Fairing, Strut 2

Special Access:

<u>Number</u>	<u>Name/Location</u>
S4431	Right Strut Box External Inspection

NOTE: Thrust reversers must be open to remove access panels 441EL and 441ER. The removal of the engine is not necessary.

SUBTASK 54-05-03-010-025

- (2) Remove the fan cowls, do this task: Fan Cowl Panel Removal (Selection),
TASK 71-11-02-000-801-F00.

SUBTASK 54-05-03-010-028

- (3) Open Thrust Reverser Left (TRL) and Thrust Reverser Right (TRR), do this task: Open the Thrust Reverser (Selection), TASK 78-31-00-010-801-F00.

SUBTASK 54-05-03-010-026

- (4) Remove the mid insulation blankets, do this task: Strut Mid Insulation Blankets Removal,
TASK 54-54-01-000-802.

SUBTASK 54-05-03-010-027

- (5) Remove the aft insulation blankets, do this task: Strut Aft Insulation Blankets Removal,
TASK 54-54-01-000-803, or Strut Aft Insulation Blankets Removal, TASK 54-54-01-000-804.

SUBTASK 54-05-03-210-012

- (6) Do a general visual inspection of the external areas of strut box, including upper and lower spars, forward engine mount bulkhead, aft bulkhead, and side skins.

SUBTASK 54-05-03-910-016

- (7) 737-6789 Basic Task Description, TASK 51-05-01-210-803.

SUBTASK 54-05-03-410-024

- (8) Install the aft insulation blankets, do this task: Strut Aft Insulation Blankets Installation,
TASK 54-54-01-400-803, or Strut Aft Insulation Blankets Installation, TASK 54-54-01-400-804.

SUBTASK 54-05-03-410-025

- (9) Install the mid insulation blankets, do this task: Strut Mid Insulation Blankets Installation,
TASK 54-54-01-400-802.

SUBTASK 54-05-03-410-026

- (10) Close the TRL and TRR, do this task: Close the Thrust Reverser (Selection),
TASK 78-31-00-010-804-F00.

SUBTASK 54-05-03-410-029

- (11) Install the fan cowls, do this task: Fan Cowl Panel Installation (Selection),
TASK 71-11-02-400-801-F00.

EFFECTIVITY
LOM ALL

54-05-03



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SUBTASK 54-05-03-410-012

- (12) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2
441AT	Forward Strut Fairing, Thumbnail Fairing, Strut 2
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
441DL	Forward Strut Fairing, Left Underwing Fairing, Strut 2
441DR	Forward Strut Fairing, Right Underwing Fairing, Strut 2
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 ————

EFFECTIVITY
LOM ALL

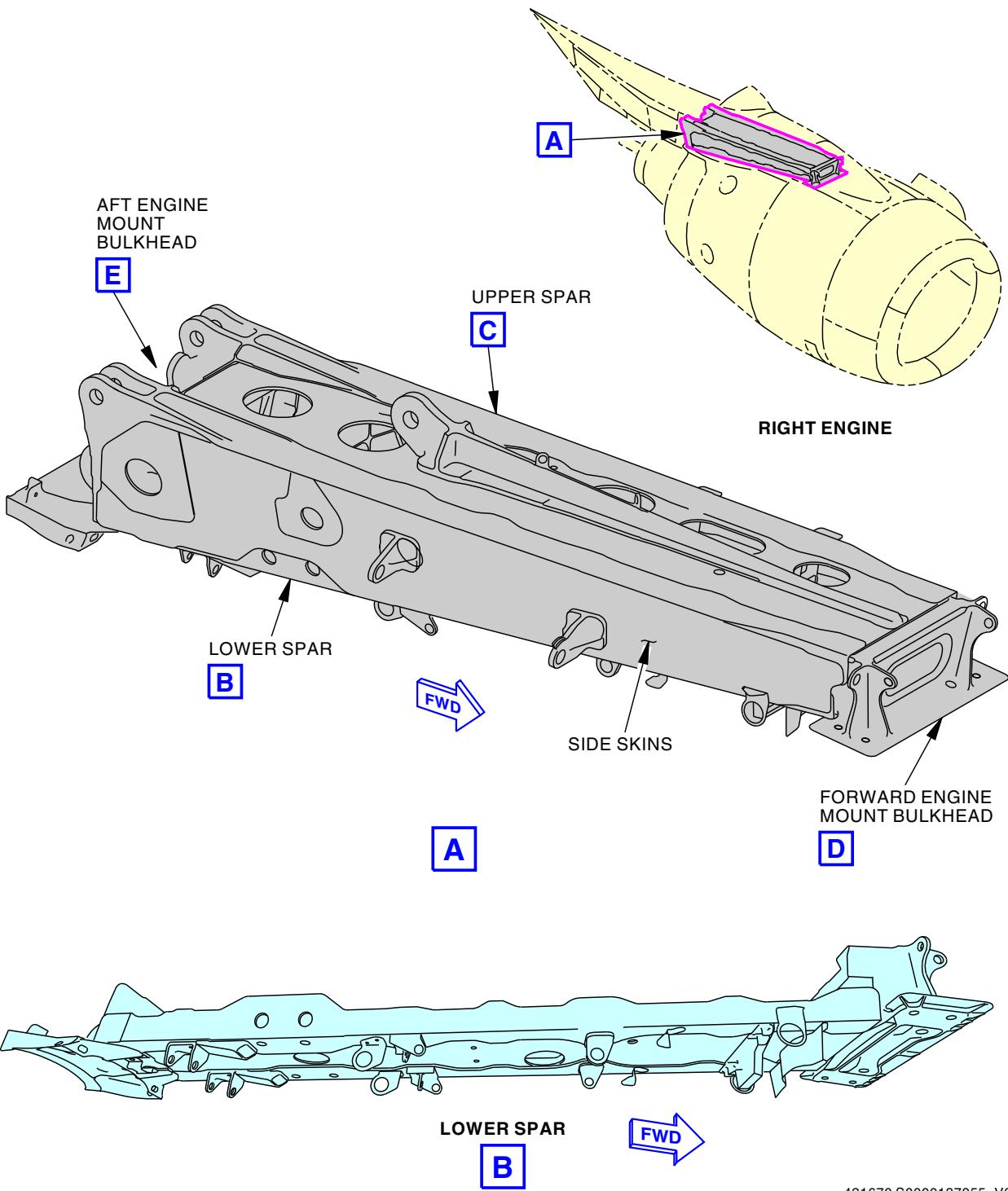
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421670 S0000137955_V2

Right Strut Box - General Visual (Internal)
Figure 217/54-05-03-990-817 (Sheet 1 of 2)

EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-78-1089

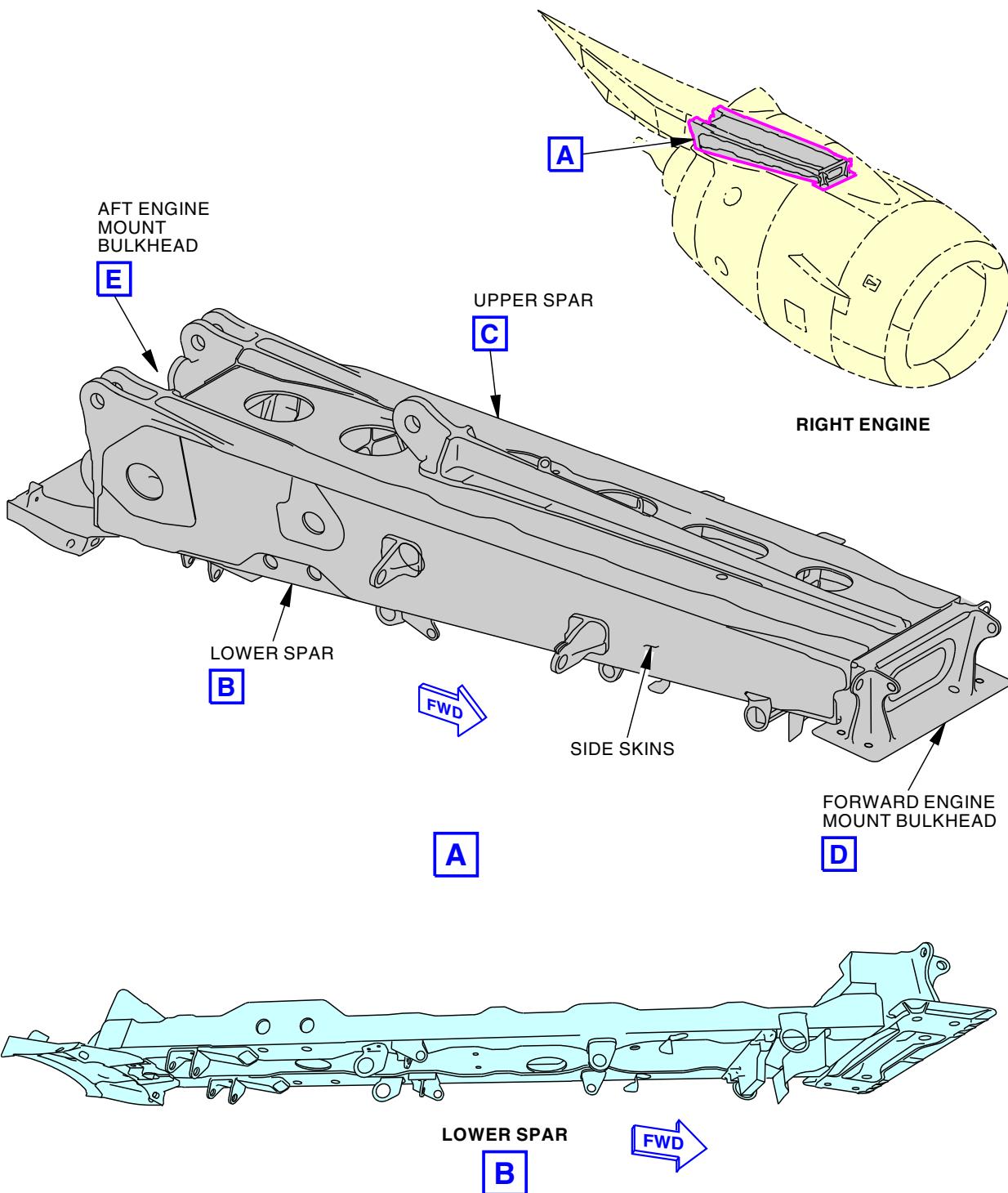
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ECCN 9E991 BOEING PROPRIETARY - See title page for details



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AIRCRAFT MAINTENANCE MANUAL



2081623 S0000436628_V2

Right Strut Box - General Visual (Internal)
Figure 217/54-05-03-990-817 (Sheet 2 of 2)

EFFECTIVITY
LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
407, 411, 412, 415, 416, 420, 422-426 POST SB
737-78-1089

54-05-03

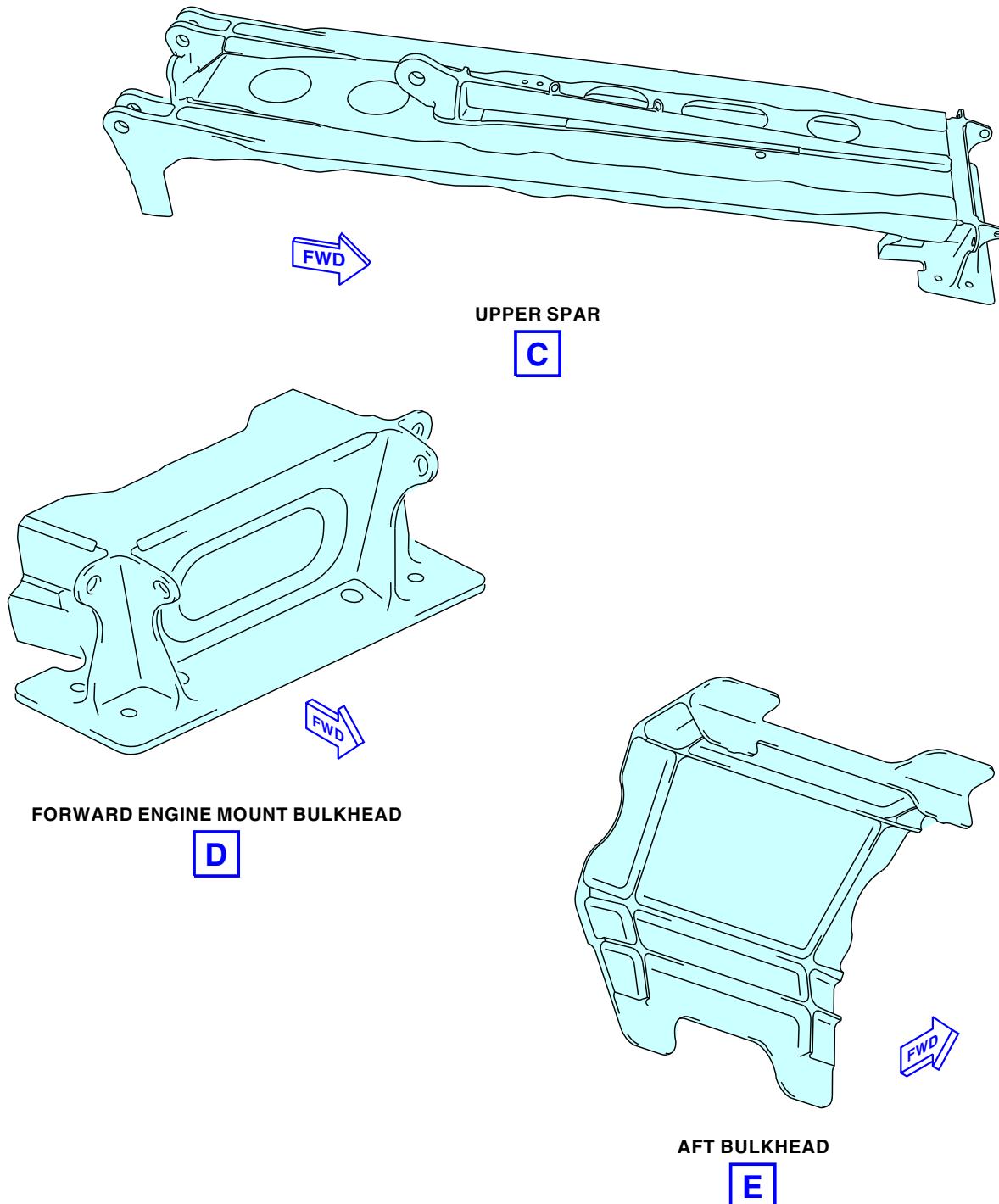
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421674 S0000137956_V3

Right Strut Box - General Visual (Internal)
Figure 218/54-05-03-990-818

EFFECTIVITY
LOM ALL

54-05-03

D633A101-LOM

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TASK 54-05-03-210-813

17. INTERNAL - GENERAL VISUAL: INTERNAL - LEFT STRUT BOX

(Figure 219)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-803	737-6789 Basic Task Description (P/B 201)
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
433	Engine 1 - Strut Torque Box

C. Access Panels

Number	Name/Location
431BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 1
431BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 1
431CL	Forward Strut Fairing, Left Overwing Fairing, Strut 1
431CR	Forward Strut Fairing, Right Overwing Fairing, Strut 1
431DL	Forward Strut Fairing, Left Underwing Fairing, Strut 1
431DR	Forward Strut Fairing, Right Underwing Fairing, Strut 1
431EL	Forward Strut Fairing, Left T.R. Strut Fairing, Strut 1
431ER	Forward Strut Fairing, Right T.R. Strut Fairing, Strut 1
433AL	Strut, Left Aft Dry Bay, Strut 1
433AR	Strut, Right Aft Dry Bay, Strut 1
433AT	Strut, Forward Spar Web, Strut 1
433BT	Strut, Forward Spar Web, Strut 1
433CT	Strut, Upper Spar Web, Strut 1
433DT	Strut, Upper Spar Web, Strut 1
S4332	Left Strut Box Internal Inspection

D. Inspection

SUBTASK 54-05-03-010-030

- (1) Open these access panels:

Number	Name/Location
431BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 1
431BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 1
431CL	Forward Strut Fairing, Left Overwing Fairing, Strut 1
431CR	Forward Strut Fairing, Right Overwing Fairing, Strut 1
431DL	Forward Strut Fairing, Left Underwing Fairing, Strut 1
431DR	Forward Strut Fairing, Right Underwing Fairing, Strut 1
431EL	Forward Strut Fairing, Left T.R. Strut Fairing, Strut 1
431ER	Forward Strut Fairing, Right T.R. Strut Fairing, Strut 1



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Special Access:

Number Name/Location

S4332 Left Strut Box Internal Inspection

NOTE: Disassemble pneumatic ducts as required. TR's must be open to remove access panels 431EL and 431ER.

SUBTASK 54-05-03-010-033

- (2) Open these access panels:

(TASK 54-53-01-000-801)

Number Name/Location

433AL Strut, Left Aft Dry Bay, Strut 1
433AR Strut, Right Aft Dry Bay, Strut 1
433AT Strut, Forward Spar Web, Strut 1
433BT Strut, Forward Spar Web, Strut 1
433CT Strut, Upper Spar Web, Strut 1
433DT Strut, Upper Spar Web, Strut 1

SUBTASK 54-05-03-210-013

- (3) Do a general visual inspection of the internal areas of strut box, including upper and lower spars, forward and aft engine mount bulkheads, aft and mid bulkheads, and side skins.

SUBTASK 54-05-03-910-017

- (4) 737-6789 Basic Task Description, TASK 51-05-01-210-803.

SUBTASK 54-05-03-410-032

- (5) Close these access panels:

(TASK 54-53-01-400-801)

Number Name/Location

433AL Strut, Left Aft Dry Bay, Strut 1
433AR Strut, Right Aft Dry Bay, Strut 1
433AT Strut, Forward Spar Web, Strut 1
433BT Strut, Forward Spar Web, Strut 1
433CT Strut, Upper Spar Web, Strut 1
433DT Strut, Upper Spar Web, Strut 1

SUBTASK 54-05-03-410-030

- (6) Close these access panels:

Number Name/Location

431BL Forward Strut Fairing, Left Mid Strut Fairing, Strut 1
431BR Forward Strut Fairing, Right Mid Strut Fairing, Strut 1
431CL Forward Strut Fairing, Left Overwing Fairing, Strut 1
431CR Forward Strut Fairing, Right Overwing Fairing, Strut 1
431DL Forward Strut Fairing, Left Underwing Fairing, Strut 1
431DR Forward Strut Fairing, Right Underwing Fairing, Strut 1
431EL Forward Strut Fairing, Left T.R. Strut Fairing, Strut 1
431ER Forward Strut Fairing, Right T.R. Strut Fairing, Strut 1

Special Access:

Number Name/Location

S4332 Left Strut Box Internal Inspection

EFFECTIVITY	LOM ALL
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54-05-03

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———— END OF TASK ————

———— EFFECTIVITY ————
LOM ALL

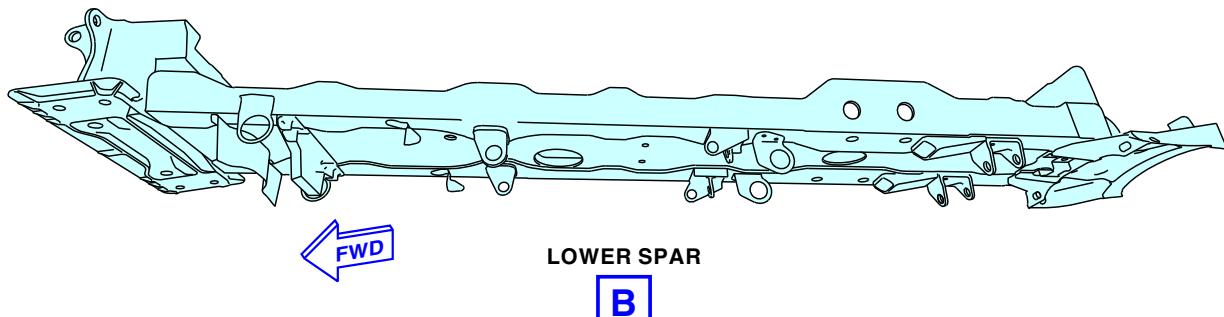
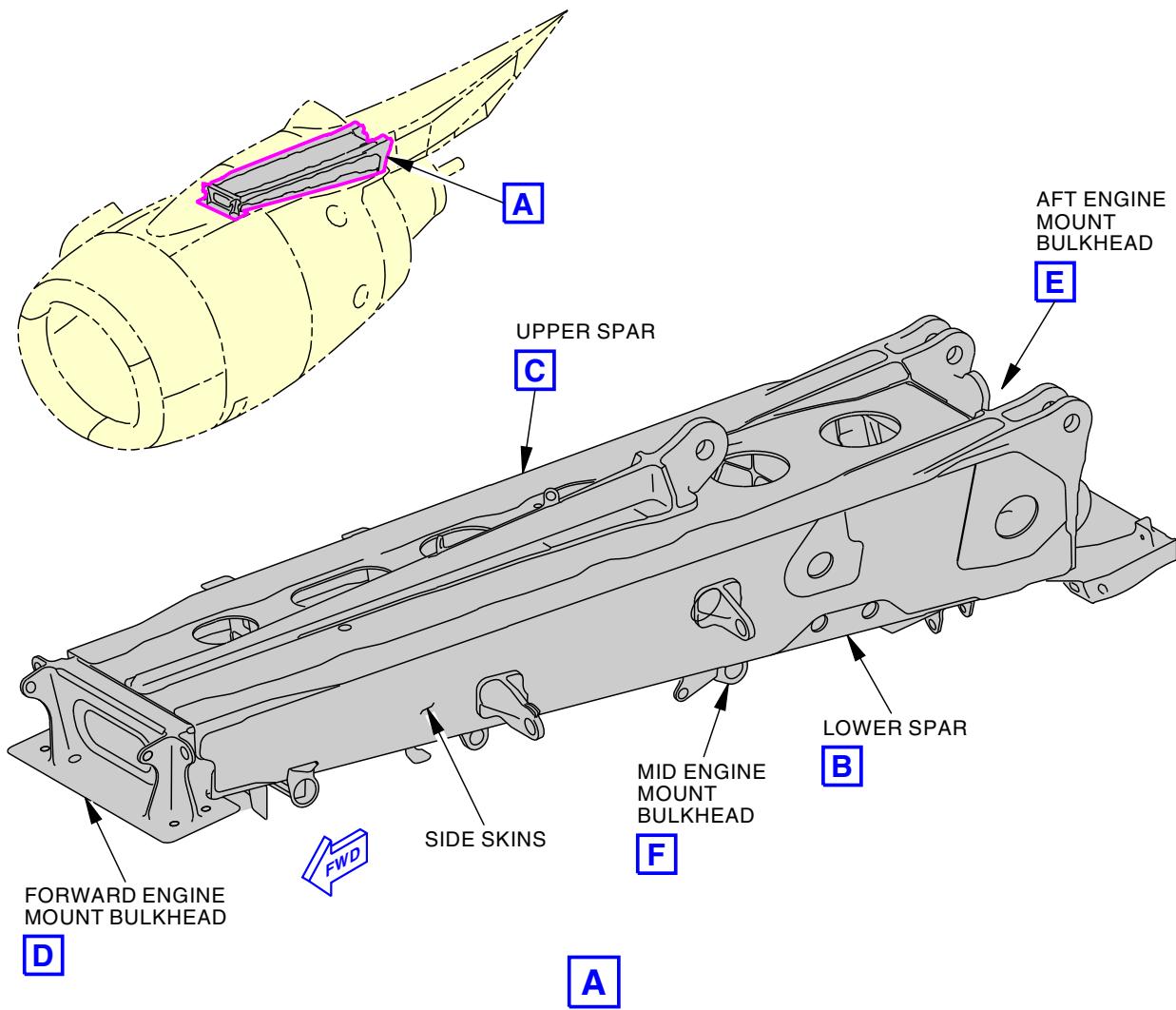
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D633A101-LOM



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367847 S0000132447_V2

Left Strut Box
Figure 219/54-05-03-990-812 (Sheet 1 of 3)

EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-78-1089

54-05-03

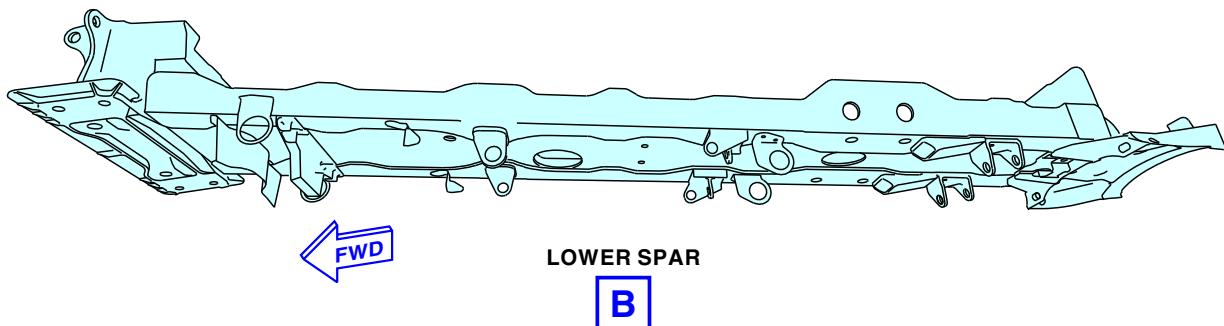
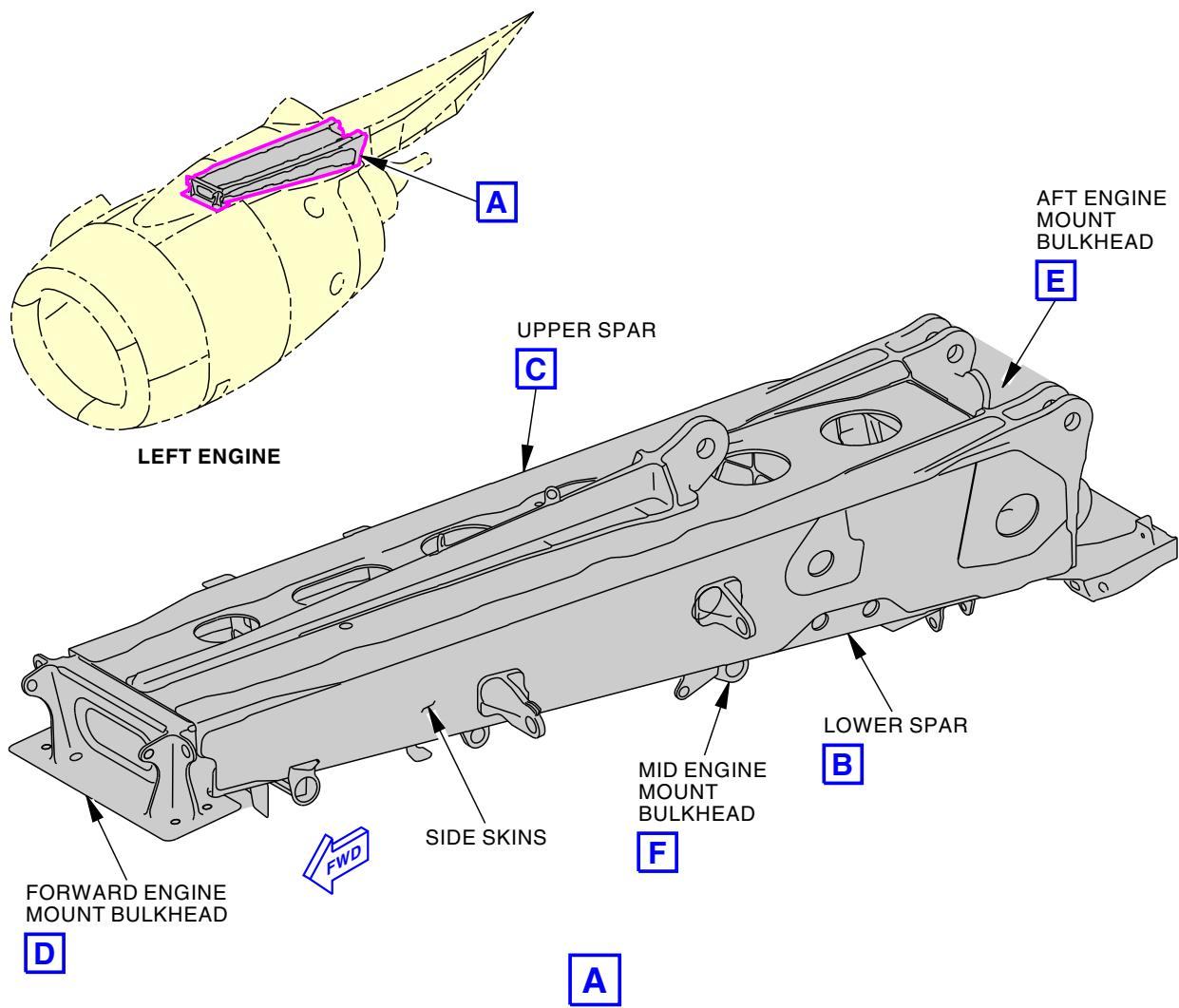
D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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2081632 S0000436632_V2

Left Strut Box
Figure 219/54-05-03-990-812 (Sheet 2 of 3)

EFFECTIVITY
LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
407, 411, 412, 415, 416, 420, 422-426 POST SB
737-78-1089

54-05-03

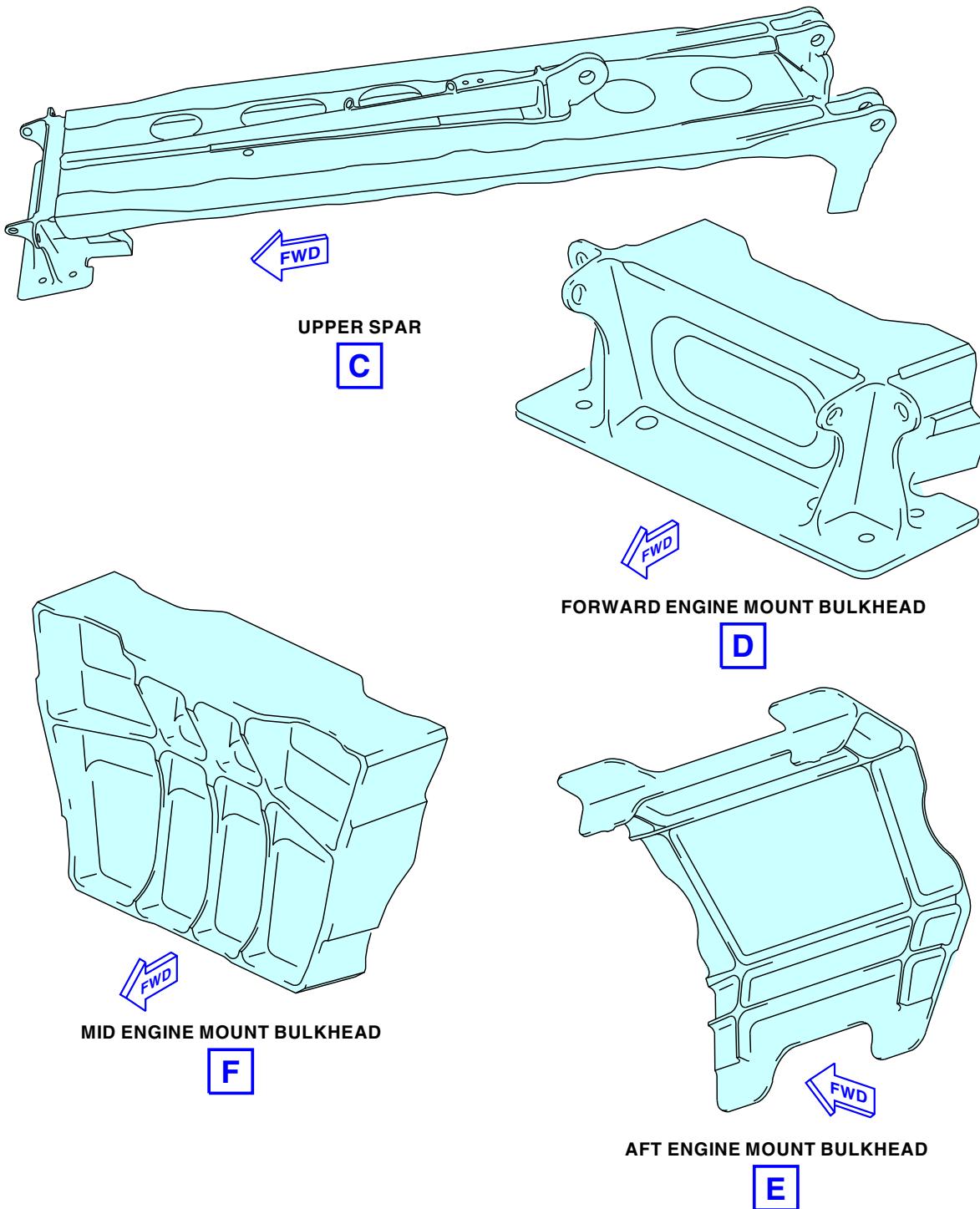
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL



368132 S0000132448_V2

Left Strut Box
Figure 219/54-05-03-990-812 (Sheet 3 of 3)

EFFECTIVITY
LOM ALL

54-05-03

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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TASK 54-05-03-210-814

18. INTERNAL - GENERAL VISUAL: INTERNAL - RIGHT STRUT BOX

(Figure 220, Figure 221)

NOTE: This procedure is a scheduled maintenance task.

A. References

Reference	Title
51-05-01-210-803	737-6789 Basic Task Description (P/B 201)
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
443	Engine 2 - Strut Torque Box

C. 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
441DL	Forward Strut Fairing, Left Underwing Fairing, Strut 2
441DR	Forward Strut Fairing, Right Underwing Fairing, Strut 2
441EL	Forward Strut Fairing, Left T.R. Strut Fairing, Strut 2
441ER	Forward Strut Fairing, Right T.R. Strut Fairing, Strut 2
443AL	Strut, Left Aft Dry Bay, Strut 2
443AR	Strut, Right Aft Dry Bay, 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
S4432	Right Strut Box Internal Inspection

D. Inspection

SUBTASK 54-05-03-010-032

- (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
441DL	Forward Strut Fairing, Left Underwing Fairing, Strut 2
441DR	Forward Strut Fairing, Right Underwing Fairing, Strut 2
441EL	Forward Strut Fairing, Left T.R. Strut Fairing, Strut 2
441ER	Forward Strut Fairing, Right T.R. Strut Fairing, Strut 2



54-05-03



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Special Access:

Number Name/Location

S4432 Right Strut Box Internal Inspection

NOTE: Disassemble pneumatic ducts as required. TR's must be open to remove access panels 441EL and 441ER.

SUBTASK 54-05-03-010-034

- (2) Open these access panels:

(TASK 54-53-01-000-801)

Number Name/Location

443AL Strut, Left Aft Dry Bay, Strut 2
443AR Strut, Right Aft Dry Bay, 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

SUBTASK 54-05-03-210-014

- (3) Do a general visual inspection of the internal areas of strut box, including upper and lower spars, forward and aft engine mount bulkheads, aft and mid bulkheads, and side skins.

SUBTASK 54-05-03-910-018

- (4) 737-6789 Basic Task Description, TASK 51-05-01-210-803.

SUBTASK 54-05-03-410-033

- (5) Close these access panels:

(TASK 54-53-01-400-801)

Number Name/Location

443AL Strut, Left Aft Dry Bay, Strut 2
443AR Strut, Right Aft Dry Bay, 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

SUBTASK 54-05-03-410-031

- (6) 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
441DL Forward Strut Fairing, Left Underwing Fairing, Strut 2
441DR Forward Strut Fairing, Right Underwing Fairing, Strut 2
441EL Forward Strut Fairing, Left T.R. Strut Fairing, Strut 2
441ER Forward Strut Fairing, Right T.R. Strut Fairing, Strut 2

Special Access:

Number Name/Location

S4432 Right Strut Box Internal Inspection

EFFECTIVITY
LOM ALL

54-05-03



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———— END OF TASK ————

———— EFFECTIVITY ————
LOM ALL

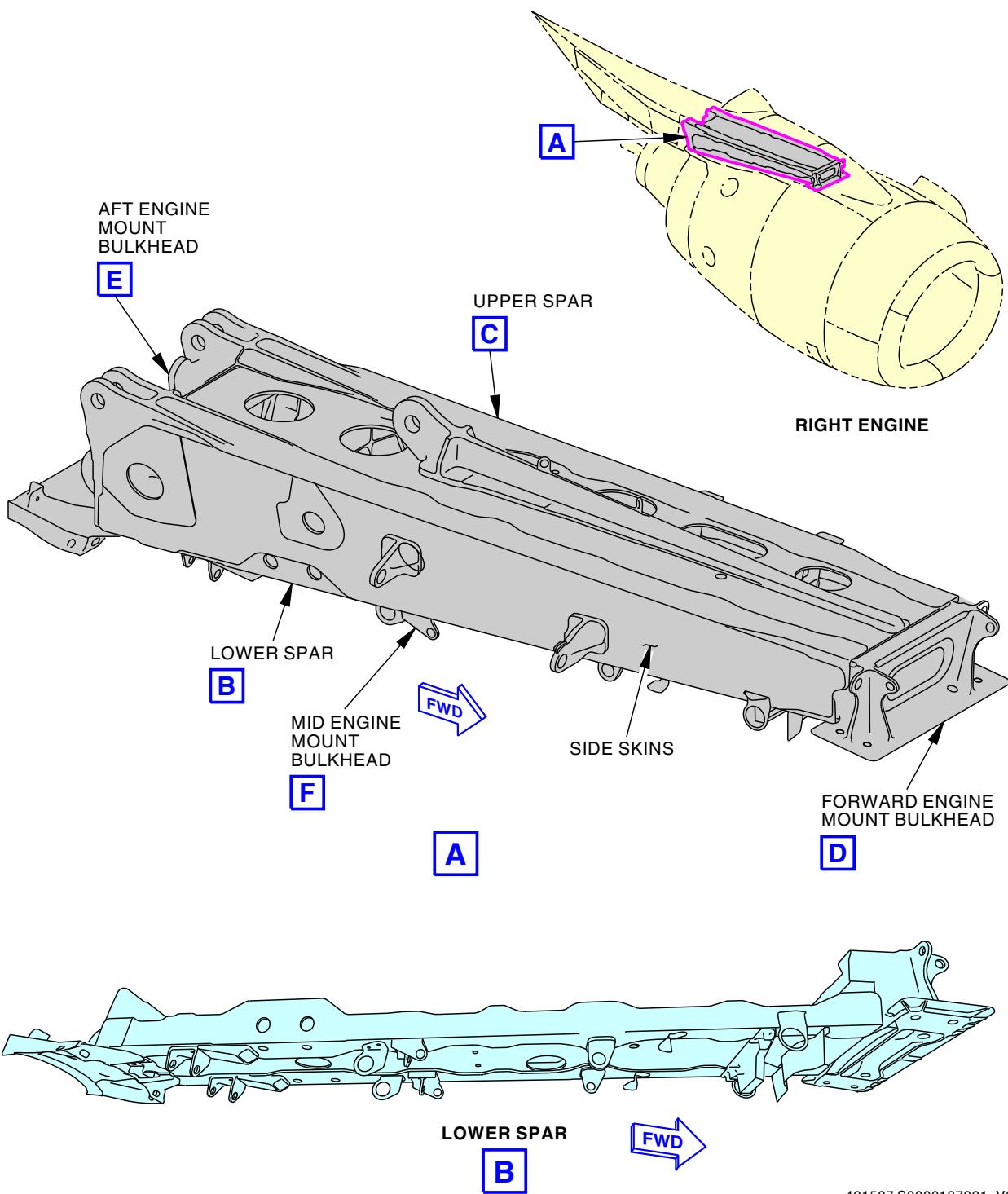
54-05-03

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421537 S0000137921_V2

Right Strut Box - General Visual (Internal)
Figure 220/54-05-03-990-813 (Sheet 1 of 2)

EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-78-1089

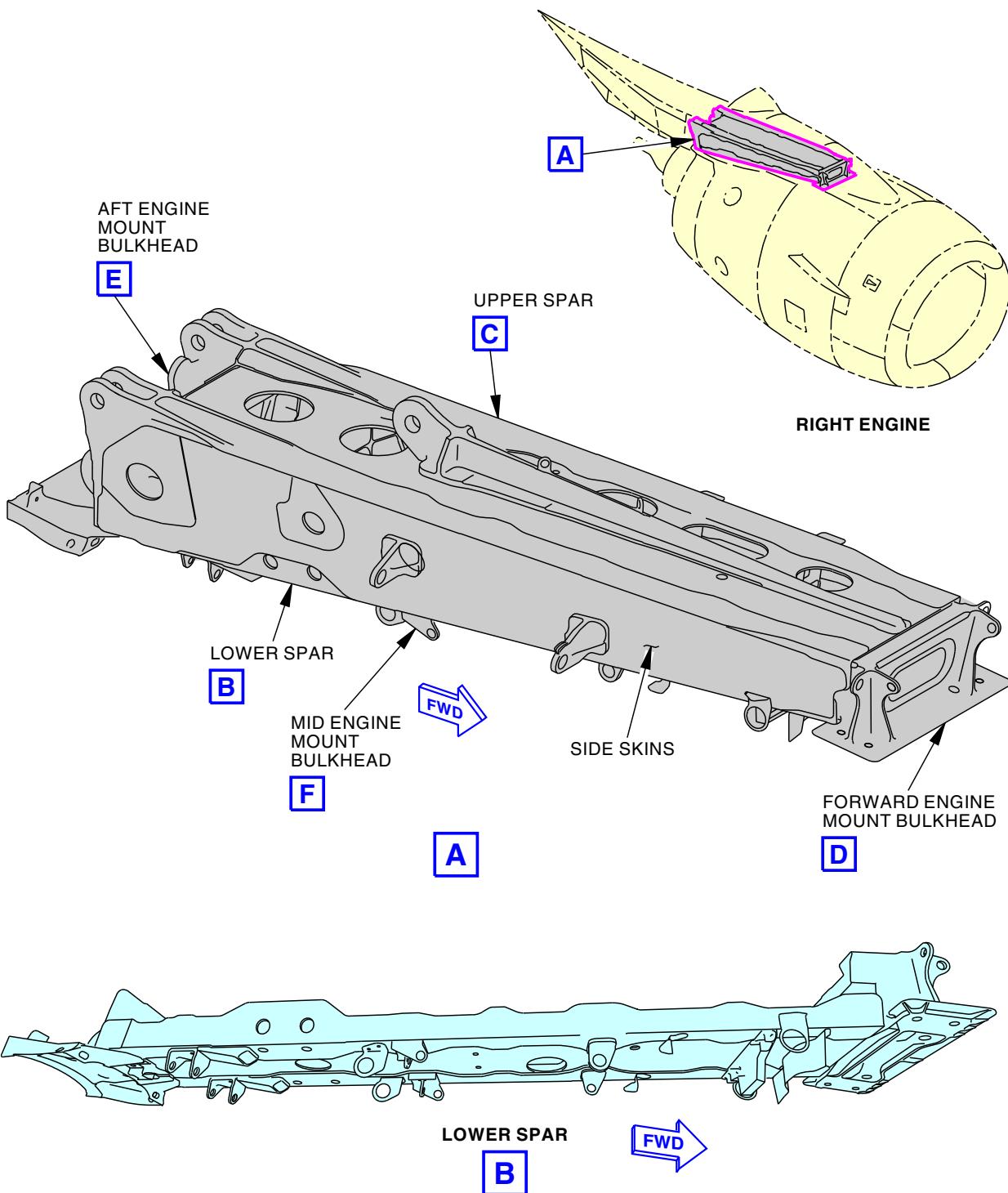
54-05-03

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details



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AIRCRAFT MAINTENANCE MANUAL



2081634 S0000436648_V2

Right Strut Box - General Visual (Internal)
Figure 220/54-05-03-990-813 (Sheet 2 of 2)

EFFECTIVITY
LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
407, 411, 412, 415, 416, 420, 422-426 POST SB
737-78-1089

54-05-03

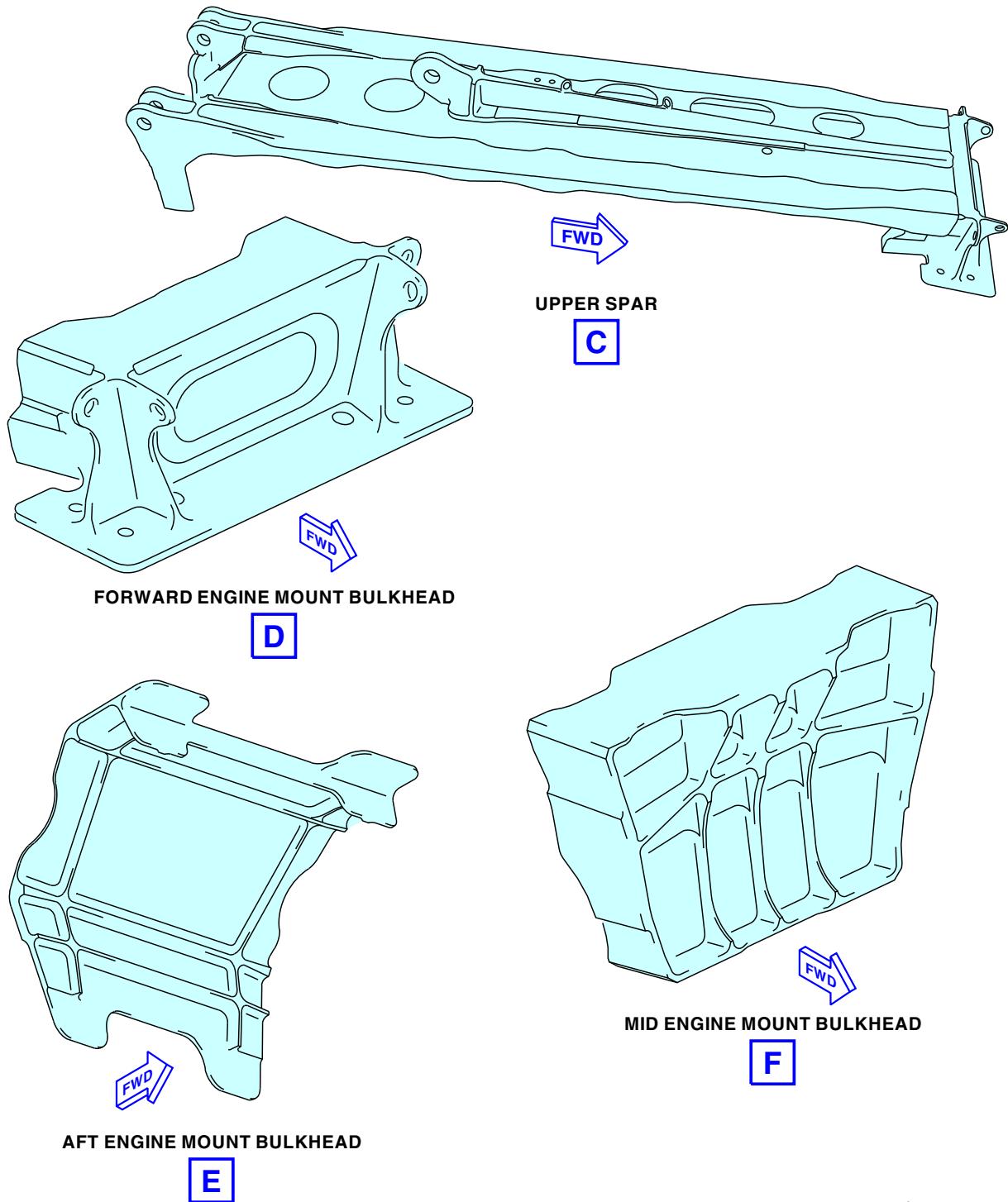
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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421541 S0000137922_V2

Right Strut Box - General Visual (Internal)
Figure 221/54-05-03-990-814

EFFECTIVITY
LOM ALL

54-05-03

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details



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AIRCRAFT MAINTENANCE MANUAL

NACELLES/PYLONS - FATIGUE INSPECTIONS - MAINTENANCE PRACTICES

TASK 54-05-02-210-801

1. INTERNAL - GENERAL VISUAL: STRUT TO WING ATTACHMENTS

Figure 201

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
431	Engine 1 - Forward Strut Fairing
434	Engine 1 - Aft Strut Fairing
441	Engine 2 - Forward Strut Fairing
444	Engine 2 - 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
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
511BT	Fairing

D. Inspection

SUBTASK 54-05-02-010-010

- (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 for Engine No. 1:

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 for Engine No. 2:

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

SUBTASK 54-05-02-010-043

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

EFFECTIVITY
LOM ALL

54-05-02



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- (a) Remove these access panels for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
431CL	Forward Strut Fairing, Left Overwing Fairing, Strut 1
431CR	Forward Strut Fairing, Right Overwing Fairing, Strut 1
511BT	Fairing

- (b) Remove these access panels for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
441CL	Forward Strut Fairing, Left Overwing Fairing, Strut 2
441CR	Forward Strut Fairing, Right Overwing Fairing, Strut 2
511BT	Fairing

SUBTASK 54-05-02-210-001

- (3) Do a General Visual inspection of the lugs and clevises for all the links, fittings and pins.

See Doc D626A001-DTR, DTR check form 54-51-01, 54-51-02, 54-51-03, 54-51-04, 54-51-05, 54-51-06, 54-51-07, 54-51-08, 54-51-09, 54-51-15 for alternative inspections.

SUBTASK 54-05-02-410-043

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

- (a) Install these access panels for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
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 for Engine No. 2:

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

SUBTASK 54-05-02-410-044

- (5) Install these FWD fairing access panels:

- (a) Install these access panels for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
431CL	Forward Strut Fairing, Left Overwing Fairing, Strut 1
431CR	Forward Strut Fairing, Right Overwing Fairing, Strut 1
511BT	Fairing

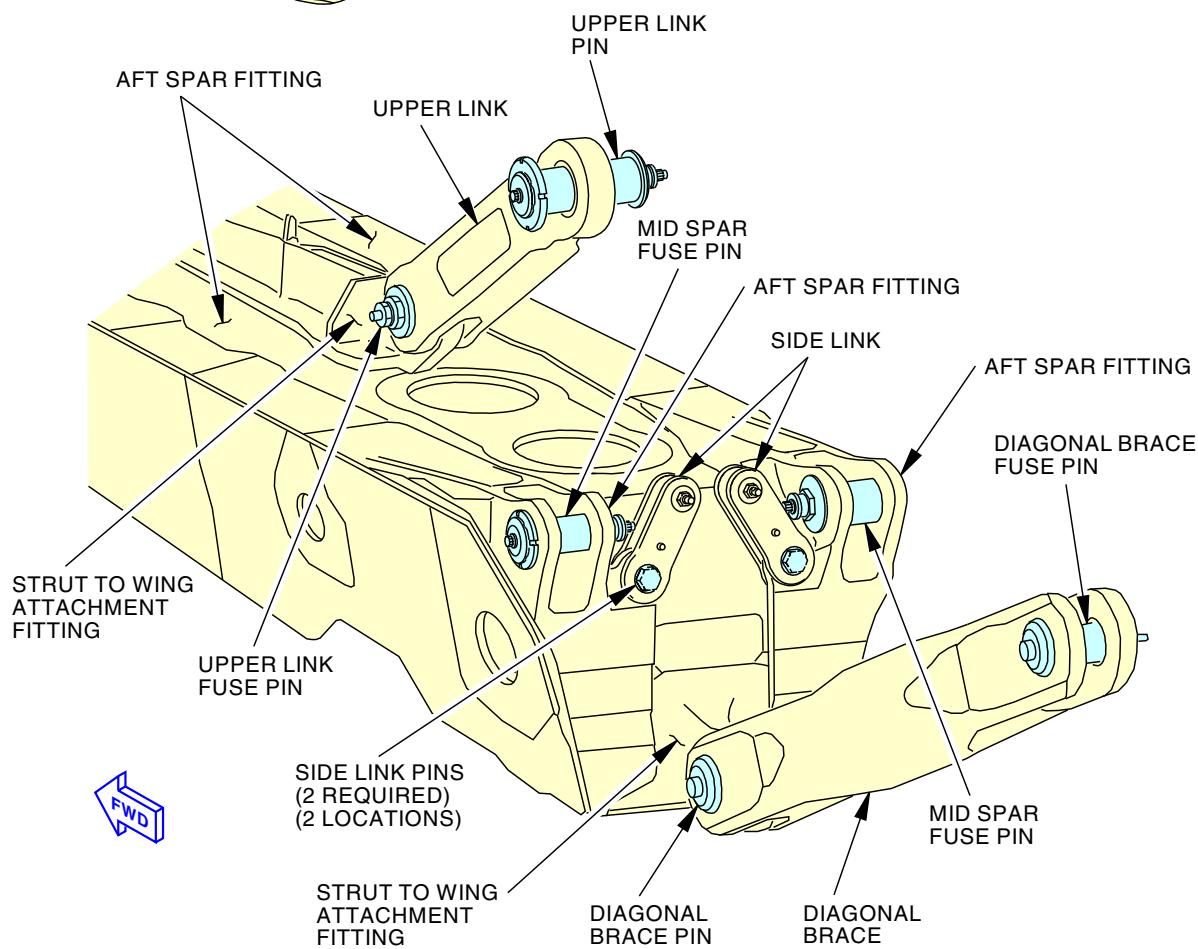
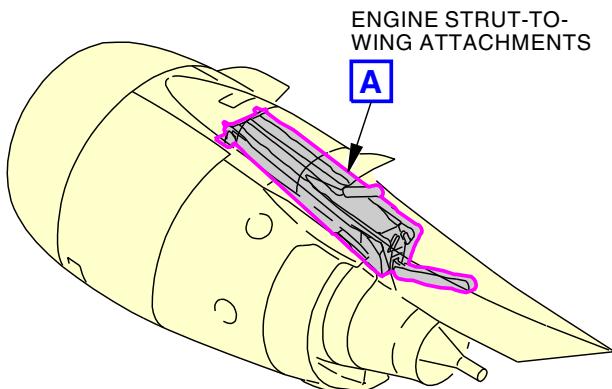
- (b) Install these access panels for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
441CL	Forward Strut Fairing, Left Overwing Fairing, Strut 2
441CR	Forward Strut Fairing, Right Overwing Fairing, Strut 2
511BT	Fairing

———— END OF TASK ————

EFFECTIVITY
LOM ALL

54-05-02


ENGINE STRUT-TO-WING ATTACHMENTS
A

3043546 S0000810785_V1

Strut to wing attachments
Figure 201/54-05-02-990-805

EFFECTIVITY
 LOM ALL

54-05-02



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TASK 54-05-02-250-801

2. INTERNAL - SPECIAL DETAILED: LOWER SPAR CHORD - TYPICAL EXPOSED DETAIL

NOTE: This procedure is a scheduled maintenance task.

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
433	Engine 1 - Strut Torque Box
443	Engine 2 - Strut Torque Box

C. Access Panels

Number	Name/Location
431BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 1
431BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 1
433AT	Strut, Forward Spar Web, Strut 1
433BT	Strut, Forward Spar Web, Strut 1
433CT	Strut, Upper Spar Web, Strut 1
433DT	Strut, Upper Spar Web, Strut 1
441BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 2
441BR	Forward Strut Fairing, Right Mid Strut 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

D. Inspection

SUBTASK 54-05-02-010-018

- (1) Open these access panels for Engine No. 1:

Number	Name/Location
431BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 1
431BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 1

NOTE: Remove/displace heat shields and brackets as required.

SUBTASK 54-05-02-010-045

- (2) Open these access panels for Engine No. 1:

Number	Name/Location
433AT	Strut, Forward Spar Web, Strut 1
433BT	Strut, Forward Spar Web, Strut 1
433CT	Strut, Upper Spar Web, Strut 1
433DT	Strut, Upper Spar Web, Strut 1

(TASK 54-53-01-000-801)

NOTE: Remove/displace heat shields and brackets as required.

EFFECTIVITY
LOM ALL

54-05-02



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SUBTASK 54-05-02-010-046

- (3) Open these access panels for Engine No. 2:

Number Name/Location

441BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 2
441BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 2

NOTE: Remove/displace heat shields and brackets as required.

SUBTASK 54-05-02-010-047

- (4) Open these access panels for Engine No. 2:

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

(TASK 54-53-01-000-801)

NOTE: Remove/displace heat shields and brackets as required.

SUBTASK 54-05-02-250-001

- (5) Do a High Frequency Eddy Current inspection of both legs of the lower spar chords between the forward and aft engine mounts: Nacelle STA 203.6 -209.9 left and right hand chords, nacelle STA 212.3-222.0 left and right hand chords, nacelle STA 224.7-231.8 left hand chord, nacelle STA 234.4-240.4 left and right hand chords, nacelle STA 243.5-250.6 left and right hand chords.

See Doc. D626A001-DTR, DTR check form 54-51-10a, 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 54-40-09.

SUBTASK 54-05-02-410-018

- (6) Close these access panels for Engine No. 1:

Number Name/Location

431BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 1
431BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 1

SUBTASK 54-05-02-410-047

- (7) Close these access panels for Engine No. 1:

Number Name/Location

433AT	Strut, Forward Spar Web, Strut 1
433BT	Strut, Forward Spar Web, Strut 1
433CT	Strut, Upper Spar Web, Strut 1
433DT	Strut, Upper Spar Web, Strut 1

(TASK 54-53-01-400-801)

SUBTASK 54-05-02-410-048

- (8) Close these access panels for Engine No. 2:

Number Name/Location

441BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 2
441BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 2

EFFECTIVITY
LOM ALL

54-05-02

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SUBTASK 54-05-02-410-049

- (9) Close these access panels for Engine No. 2:

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

(TASK 54-53-01-400-801)

———— END OF TASK ————

TASK 54-05-02-250-802

3. INTERNAL - SPECIAL DETAILED: LOWER SPAR CHORD AT FIRE SEAL DEPRESSOR BRACKET

NOTE: This procedure is a scheduled maintenance task.

A. References

<u>Reference</u>	<u>Title</u>
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

<u>Zone</u>	<u>Area</u>
433	Engine 1 - Strut Torque Box
443	Engine 2 - Strut Torque Box

C. Access Panels

<u>Number</u>	<u>Name/Location</u>
431BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 1
431BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 1
433AT	Strut, Forward Spar Web, Strut 1
433BT	Strut, Forward Spar Web, Strut 1
433CT	Strut, Upper Spar Web, Strut 1
433DT	Strut, Upper Spar Web, Strut 1
441BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 2
441BR	Forward Strut Fairing, Right Mid Strut 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

D. Inspection

SUBTASK 54-05-02-010-019

- (1) Open these access panels for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
431BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 1
431BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 1

EFFECTIVITY
LOM ALL

54-05-02

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SUBTASK 54-05-02-010-048

- (2) Open these access panels for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
433AT	Strut, Forward Spar Web, Strut 1
433BT	Strut, Forward Spar Web, Strut 1
433CT	Strut, Upper Spar Web, Strut 1
433DT	Strut, Upper Spar Web, Strut 1

(TASK 54-53-01-000-801)

SUBTASK 54-05-02-010-049

- (3) Open these access panels for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
441BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 2
441BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 2

SUBTASK 54-05-02-010-050

- (4) Open these access panels for Engine No. 2:

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

(TASK 54-53-01-000-801)

SUBTASK 54-05-02-250-002

- (5) Do a High Frequency Eddy Current inspection of the lower spar chord at the fire seal depressor bracket at nacelle STA 203.4 and nacelle STA 207.8 for both the left and right hand chords.

See Doc. D626A001-DTR, DTR check form 54-51-10b, 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 54-40-10.

SUBTASK 54-05-02-410-019

- (6) Close these access panels for Engine No. 1:

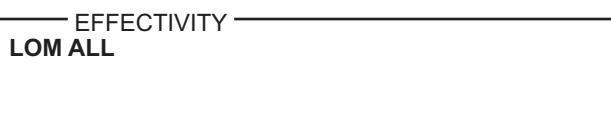
<u>Number</u>	<u>Name/Location</u>
431BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 1
431BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 1

SUBTASK 54-05-02-410-050

- (7) Close these access panels for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
433AT	Strut, Forward Spar Web, Strut 1
433BT	Strut, Forward Spar Web, Strut 1
433CT	Strut, Upper Spar Web, Strut 1
433DT	Strut, Upper Spar Web, Strut 1

(TASK 54-53-01-400-801)



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SUBTASK 54-05-02-410-051

- (8) Close these access panels for Engine No. 2:

Number

Name/Location

441BL

Forward Strut Fairing, Left Mid Strut Fairing, Strut 2

441BR

Forward Strut Fairing, Right Mid Strut Fairing, Strut 2

SUBTASK 54-05-02-410-052

- (9) Close these access panels for Engine No. 2:

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

(TASK 54-53-01-400-801)

———— END OF TASK ————

TASK 54-05-02-130-801

4. INTERNAL - SPECIAL DETAILED: LOWER SPAR CHORD AT FIRE SEAL DEPRESSOR BRACKET

NOTE: This procedure is a scheduled maintenance task.

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
433	Engine 1 - Strut Torque Box
443	Engine 2 - Strut Torque Box

C. Access Panels

Number	Name/Location
431BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 1
431BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 1
431CL	Forward Strut Fairing, Left Overwing Fairing, Strut 1
431CR	Forward Strut Fairing, Right Overwing Fairing, Strut 1
433AT	Strut, Forward Spar Web, Strut 1
433BT	Strut, Forward Spar Web, Strut 1
433CT	Strut, Upper Spar Web, Strut 1
433DT	Strut, Upper Spar Web, Strut 1
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

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D. Inspection

SUBTASK 54-05-02-010-007

- (1) Open these access panels for Engine No. 1:

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

SUBTASK 54-05-02-010-051

- (2) Open these access panels for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
433AT	Strut, Forward Spar Web, Strut 1
433BT	Strut, Forward Spar Web, Strut 1
433CT	Strut, Upper Spar Web, Strut 1
433DT	Strut, Upper Spar Web, Strut 1

(TASK 54-53-01-000-801)

SUBTASK 54-05-02-010-052

- (3) Open these access panels for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
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 54-05-02-010-053

- (4) Open these access panels for Engine No. 2:

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

(TASK 54-53-01-000-801)

SUBTASK 54-05-02-130-001

- (5) Do an Ultrasonic inspection of the the lower spar chord at the fire seal depressor bracket at nacelle STA 203.4 and at nacelle STA 207.8 on the left and right hand chords.

See Doc. D626A001-DTR, DTR check form 54-51-10b, 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 4, Subject 54-40-02.

SUBTASK 54-05-02-410-007

- (6) Close these access panels for Engine No. 1:

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

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Number

Name/Location

431CR Forward Strut Fairing, Right Overwing Fairing, Strut 1

SUBTASK 54-05-02-410-053

- (7) Close these access panels for Engine No. 1:

Number

Name/Location

433AT Strut, Forward Spar Web, Strut 1

433BT Strut, Forward Spar Web, Strut 1

433CT Strut, Upper Spar Web, Strut 1

433DT Strut, Upper Spar Web, Strut 1

(TASK 54-53-01-400-801)

SUBTASK 54-05-02-410-054

- (8) Close these access panels for Engine No. 2:

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 54-05-02-410-055

- (9) Close these access panels for Engine No. 2:

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

(TASK 54-53-01-400-801)

———— END OF TASK ————

TASK 54-05-02-130-802

5. INTERNAL - SPECIAL DETAILED: LOWER SPAR CHORD - BRACKET

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone

Area

433 Engine 1 - Strut Torque Box

443 Engine 2 - Strut Torque Box

B. Access Panels

Number

Name/Location

413 Left Fan Cowl, Engine 1

414 Right Fan Cowl, Engine 1

415 Left Thrust Reverser, Engine 1

416 Right Thrust Reverser, Engine 1

423 Left Fan Cowl, Engine 2

424 Right Fan Cowl, Engine 2

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<u>Number</u>	<u>Name/Location</u>
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

C. Inspection

SUBTASK 54-05-02-010-002

- (1) Open these access panels for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1

Open these access panels for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

NOTE: Removal of insulation heat shield is required. Remove fan cowls, thrust reversers, and engines as required.

SUBTASK 54-05-02-130-002

- (2) Do an Ultrasonis inspection of the lower spar chord bracket at nacelle STA 216.0 on the left hand side and nacelle STA 218.0 on the right hand side.

See Doc. D626A001-DTR, DTR check form 54-51-10c, 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 4, Subject 54-40-06.

SUBTASK 54-05-02-410-002

- (3) Close these access panels for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1

Close these access panels for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

— END OF TASK —



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TASK 54-05-02-130-803

6. INTERNAL - SPECIAL DETAILED: LOWER SPAR CHORD AT FRAMES WITH BRACKETS

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
433	Engine 1 - Strut Torque Box
443	Engine 2 - Strut Torque Box

B. Access Panels

Number	Name/Location
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

C. Inspection

SUBTASK 54-05-02-010-003

- (1) Open these access panels for Engine No. 1:

Number	Name/Location
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1

Open these access panels for Engine No. 2:

Number	Name/Location
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

NOTE: Remove fan cowls, thrust reversers, engine and insulation heat shields as required.

SUBTASK 54-05-02-130-003

- (2) Do an Ultrasonic (UT) inspection of the lower spar chord at the frames with brackets at nacelle STA 222.6 and nacelle STA 242.7 on the left and right chords.

See Doc. D626A001-DTR, DTR check form 54-51-10d, 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 4, Subject 54-40-06.

NOTE: At Nacelle STA 222.6, for the left chord only, Ultrasonic (UT) inspection is not required in the area between fastener and the edge of the chord.

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SUBTASK 54-05-02-410-003

- (3) Close these access panels for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1

Close these access panels for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

———— END OF TASK ————

TASK 54-05-02-250-803

7. INTERNAL - SPECIAL DETAILED: LOWER SPAR CHORD (DIRECTION 1)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
433	Engine 1 - Strut Torque Box
443	Engine 2 - Strut Torque Box

B. Access Panels

<u>Number</u>	<u>Name/Location</u>
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

C. Inspection

SUBTASK 54-05-02-010-020

- (1) Open these access panels for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1

Open these access panels for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
423	Left Fan Cowl, Engine 2

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<u>Number</u>	<u>Name/Location</u>
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

SUBTASK 54-05-02-250-003

- (2) Do a High Frequency Eddy Current inspection of the lower spar chord at the aft engine mount bulkhead.

See Doc. D626A001-DTR, DTR check form 54-51-10e, 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 54-40-03.

SUBTASK 54-05-02-410-020

- (3) Close these access panels for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1

Close these access panels for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

— END OF TASK —

TASK 54-05-02-250-804

8. INTERNAL - SPECIAL DETAILED: LOWER SPAR CHORD (DIRECTION 2)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
433	Engine 1 - Strut Torque Box
443	Engine 2 - Strut Torque Box

B. Access Panels

<u>Number</u>	<u>Name/Location</u>
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2



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C. Inspection

SUBTASK 54-05-02-010-022

- (1) Open these access panels for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1

Open these access panels for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

NOTE: Inspection requires the removal of engine mount.

SUBTASK 54-05-02-250-004

- (2) Do a High Frequency Eddy Current inspection of the lower spar chord at the aft engine mount bulkhead.

See Doc. D626A001-DTR, DTR check form 54-51-10e, 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 54-40-03.

SUBTASK 54-05-02-410-022

- (3) Close these access panels for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1

Close these access panels for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

———— END OF TASK ————

TASK 54-05-02-250-805

9. INTERNAL - SPECIAL DETAILED: LOWER SPAR CHORD - WEB ONLY

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
433	Engine 1 - Strut Torque Box
443	Engine 2 - Strut Torque Box

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B. Access Panels

<u>Number</u>	<u>Name/Location</u>
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

C. Inspection

SUBTASK 54-05-02-010-023

- (1) Open these access panels for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1

Open these access panels for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

NOTE: Open/Remove Thrust Reverser as Required. Removal of Pneumatic Ducting Required.

SUBTASK 54-05-02-250-005

- (2) Do a High Frequency Eddy Current inspection of only the lower right spar web from nacelle STA 224.7 to nacelle STA 231.8.

See Doc. D626A001-DTR, DTR check form 54-51-10f1, 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 54-40-08.

SUBTASK 54-05-02-410-023

- (3) Close these access panels for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1

Close these access panels for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2

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<u>Number</u>	<u>Name/Location</u>
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

———— END OF TASK ————

TASK 54-05-02-250-806

10. INTERNAL - SPECIAL DETAILED: LOWER SPAR CHORD - CHORD ONLY

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
433	Engine 1 - Strut Torque Box
443	Engine 2 - Strut Torque Box

B. Access Panels

<u>Number</u>	<u>Name/Location</u>
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

C. Inspection

SUBTASK 54-05-02-010-024

- (1) Open these access panels for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1

Open these access panels for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

NOTE: Remove Thrust Reverser as required. Removal of insulation heat shields is required.

SUBTASK 54-05-02-250-006

- (2) Do a High Frequency Eddy Current inspection of only the lower right spar chord from nacelle STA 224.7 to nacelle STA 231.8.

See Doc. D626A001-DTR, DTR check form 54-51-10f2, for alternative inspections.

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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 54-40-08.

SUBTASK 54-05-02-410-024

- (3) Close these access panels for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1

Close these access panels for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

———— END OF TASK ————

TASK 54-05-02-250-807

11. INTERNAL - SPECIAL DETAILED: LOWER SPAR CHORD - COMPRESSION PAD BRACKET - HORIZONTAL LEG

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
433	Engine 1 - Strut Torque Box
443	Engine 2 - Strut Torque Box

B. Access Panels

<u>Number</u>	<u>Name/Location</u>
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

C. Inspection

SUBTASK 54-05-02-010-025

- (1) Open these access panels for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1

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Open these access panels for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

NOTE: Remove thrust reverser as required. Removal of insulation heat shields is required.

SUBTASK 54-05-02-250-007

- (2) Do a High Frequency Eddy Current inspection of the horizontal leg of the left and right hand chords, common to the compression pad bracket at nacelle STA 244.9.

See Doc. D626A001-DTR, DTR check form 54-51-10g, 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 54-40-14.

SUBTASK 54-05-02-410-025

- (3) Close these access panels for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1

Close these access panels for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

———— END OF TASK ————

TASK 54-05-02-130-804

12. INTERNAL - SPECIAL DETAILED: LOWER SPAR CHORD - COMPRESSION PAD BRACKET - HORIZONTAL LEG

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
433	Engine 1 - Strut Torque Box
443	Engine 2 - Strut Torque Box

B. Access Panels

<u>Number</u>	<u>Name/Location</u>
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1
423	Left Fan Cowl, Engine 2



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<u>Number</u>	<u>Name/Location</u>
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

C. Inspection

SUBTASK 54-05-02-010-004

- (1) Open these access panels for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1

Open these access panels for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

NOTE: Remove thrust reverser as required. Removal of insulation heat shield is required.

SUBTASK 54-05-02-130-004

- (2) Do an Ultrasonic inspection the horizontal leg of the left and right hand chords, common to the compression pad bracket at nacelle STA 244.9

See Doc. D626A001-DTR, DTR check form 54-51-10g, 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 4, Subject 54-40-07.

SUBTASK 54-05-02-410-004

- (3) Close these access panels for Enigne No. 1:

<u>Number</u>	<u>Name/Location</u>
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1

Close these access panels for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

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TASK 54-05-02-250-808

13. INTERNAL - SPECIAL DETAILED: LOWER SPAR CHORD - COMPRESSION PAD BRACKET - VERTICAL LEG

NOTE: This procedure is a scheduled maintenance task.

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
433	Engine 1 - Strut Torque Box
443	Engine 2 - Strut Torque Box

C. Access Panels

Number	Name/Location
433AT	Strut, Forward Spar Web, Strut 1
433BT	Strut, Forward Spar Web, Strut 1
433CT	Strut, Upper Spar Web, Strut 1
433DT	Strut, Upper Spar Web, Strut 1
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

D. Inspection

SUBTASK 54-05-02-010-026

- (1) Open these access panels for Engine No. 1:

Number	Name/Location
433AT	Strut, Forward Spar Web, Strut 1
433BT	Strut, Forward Spar Web, Strut 1
433CT	Strut, Upper Spar Web, Strut 1
433DT	Strut, Upper Spar Web, Strut 1

(TASK 54-53-01-000-801)

SUBTASK 54-05-02-010-054

- (2) Open these access panels for Engine No. 2:

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

(TASK 54-53-01-000-801)

SUBTASK 54-05-02-250-008

- (3) Do a High Frequency Eddy Current inspection of the vertical leg of the compression pad bracket on the lower left and right spar chords at nacelle STA 244.9.

See Doc. D626A001-DTR, DTR check form 54-51-10h, for alternative inspections.

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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 54-40-14.

SUBTASK 54-05-02-410-026

- (4) Close these access panels for Engine No. 1:

Number	Name/Location
433AT	Strut, Forward Spar Web, Strut 1
433BT	Strut, Forward Spar Web, Strut 1
433CT	Strut, Upper Spar Web, Strut 1
433DT	Strut, Upper Spar Web, Strut 1

(TASK 54-53-01-400-801)

SUBTASK 54-05-02-410-056

- (5) Close these access panels for Engine No. 2:

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

(TASK 54-53-01-400-801)

————— END OF TASK —————

TASK 54-05-02-130-805

14. INTERNAL - SPECIAL DETAILED: LOWER SPAR CHORD — TYPICAL FRAME DETAIL, VERTICAL LEG (DIRECTION 1)

NOTE: This procedure is a scheduled maintenance task.

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
433	Engine 1 - Strut Torque Box
443	Engine 2 - Strut Torque Box

C. Access Panels

Number	Name/Location
431BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 1
431BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 1
431CL	Forward Strut Fairing, Left Overwing Fairing, Strut 1
431CR	Forward Strut Fairing, Right Overwing Fairing, Strut 1
433AT	Strut, Forward Spar Web, Strut 1
433BT	Strut, Forward Spar Web, Strut 1
433CT	Strut, Upper Spar Web, Strut 1
433DT	Strut, Upper Spar Web, Strut 1
441BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 2

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(Continued)

Number	Name/Location
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

D. Inspection

SUBTASK 54-05-02-010-005

- (1) Open these access panels for Engine No. 1:

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

SUBTASK 54-05-02-010-055

- (2) Open these access panels for Engine No. 1:

Number	Name/Location
433AT	Strut, Forward Spar Web, Strut 1
433BT	Strut, Forward Spar Web, Strut 1
433CT	Strut, Upper Spar Web, Strut 1
433DT	Strut, Upper Spar Web, Strut 1

(TASK 54-53-01-000-801)

SUBTASK 54-05-02-010-056

- (3) Open these access panels for Engine No. 2:

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 54-05-02-010-057

- (4) Open these access panels for Engine No. 2:

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

(TASK 54-53-01-000-801)

SUBTASK 54-05-02-130-005

- (5) Do an Ultrasonic inspection of the internal side of the vertical leg at nacelle STA. 209.0 - 212.3, nacelle STA. 231.8 - 234.4 on the left and right hand chords.

See Doc. D626A001-DTR, DTR check form 54-51-10i, for alternative inspections.

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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 54-40-08.

SUBTASK 54-05-02-410-005

- (6) Close these access panels for Engine No. 1:

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

SUBTASK 54-05-02-410-057

- (7) Close these access panels for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
433AT	Strut, Forward Spar Web, Strut 1
433BT	Strut, Forward Spar Web, Strut 1
433CT	Strut, Upper Spar Web, Strut 1
433DT	Strut, Upper Spar Web, Strut 1

(TASK 54-53-01-400-801)

SUBTASK 54-05-02-410-058

- (8) Close these access panels for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
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 54-05-02-410-059

- (9) Close these access panels for Engine No. 2:

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

(TASK 54-53-01-400-801)

———— END OF TASK ————

TASK 54-05-02-250-809

15. EXTERNAL - SPECIAL DETAILED: LOWER SPAR CHORD - TYPICAL FRAME DETAIL, VERTICAL LEG (DIRECTION 2)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
433	Engine 1 - Strut Torque Box
443	Engine 2 - Strut Torque Box

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B. Access Panels

<u>Number</u>	<u>Name/Location</u>
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2
431DL	Forward Strut Fairing, Left Underwing Fairing, Strut 1
431DR	Forward Strut Fairing, Right Underwing Fairing, Strut 1
441DL	Forward Strut Fairing, Left Underwing Fairing, Strut 2
441DR	Forward Strut Fairing, Right Underwing Fairing, Strut 2

C. Inspection

SUBTASK 54-05-02-010-027

- (1) Open these access panels for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1
431DL	Forward Strut Fairing, Left Underwing Fairing, Strut 1
431DR	Forward Strut Fairing, Right Underwing Fairing, Strut 1

Open these access panels for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2
441DL	Forward Strut Fairing, Left Underwing Fairing, Strut 2
441DR	Forward Strut Fairing, Right Underwing Fairing, Strut 2

NOTE: Remove thrust reversers as required.

SUBTASK 54-05-02-250-009

- (2) Do a Low Frequency Eddy Current inspection of the external side of the vertical leg at nacelle STA 209.0 - 212.3, and nacelle STA 231.8 - 234.4 on the left and right hand chords.

See Doc. D626A001-DTR, DTR check form 54-51-10i, 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 54-40-17.

SUBTASK 54-05-02-410-027

- (3) Close these access panels for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
413	Left Fan Cowl, Engine 1

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<u>Number</u>	<u>Name/Location</u>
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1
431DL	Forward Strut Fairing, Left Underwing Fairing, Strut 1
431DR	Forward Strut Fairing, Right Underwing Fairing, Strut 1

Close these access panels for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2
441DL	Forward Strut Fairing, Left Underwing Fairing, Strut 2
441DR	Forward Strut Fairing, Right Underwing Fairing, Strut 2

— END OF TASK —

TASK 54-05-02-250-810

16. INTERNAL - SPECIAL DETAILED: LOWER SPAR CHORD - TYPICAL FRAME DETAIL, HORIZONTAL LEG

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
433	Engine 1 - Strut Torque Box
443	Engine 2 - Strut Torque Box

B. Access Panels

<u>Number</u>	<u>Name/Location</u>
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

C. Inspection

SUBTASK 54-05-02-010-028

- (1) Open these access panels for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1

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Open these access panels for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

NOTE: Remove thrust reversers as required.

SUBTASK 54-05-02-250-010

- (2) Do a high Frequency Eddy Current inspection of the horizontal leg on the left and right chords from nacelle STA 209.0 to nacelle STA 212.3 and from nacelle STA 231.8 to nacelle STA 234.4.

See Doc. D626A001-DTR, DTR check form 54-51-10j, 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 54-40-16.

SUBTASK 54-05-02-410-028

- (3) Close these access panels for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1

Close these access panels for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

———— END OF TASK ————

TASK 54-05-02-211-801

17. INTERNAL - DETAILED: LOWER SPAR CHORD

Figure 202

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
433	Engine 1 - Strut Torque Box
443	Engine 2 - Strut Torque Box

B. Access Panels

<u>Number</u>	<u>Name/Location</u>
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1
423	Left Fan Cowl, Engine 2



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<u>Number</u>	<u>Name/Location</u>
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

C. Inspection

SUBTASK 54-05-02-010-091

- (1) Open these access panels for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1

Open these access panels for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

NOTE: Remove thrust reversers as required. Removal of insulation heat shields required.

SUBTASK 54-05-02-211-002

- (2) Do a Detailed inspection of the lower spar chord aft of the aft engine mount bulkhead.

See Doc. D626A001-DTR, DTR check form 54-51-10k, for alternative inspections.

SUBTASK 54-05-02-410-093

- (3) Close these access panels for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1

Close these access panels for Engine No. 2:

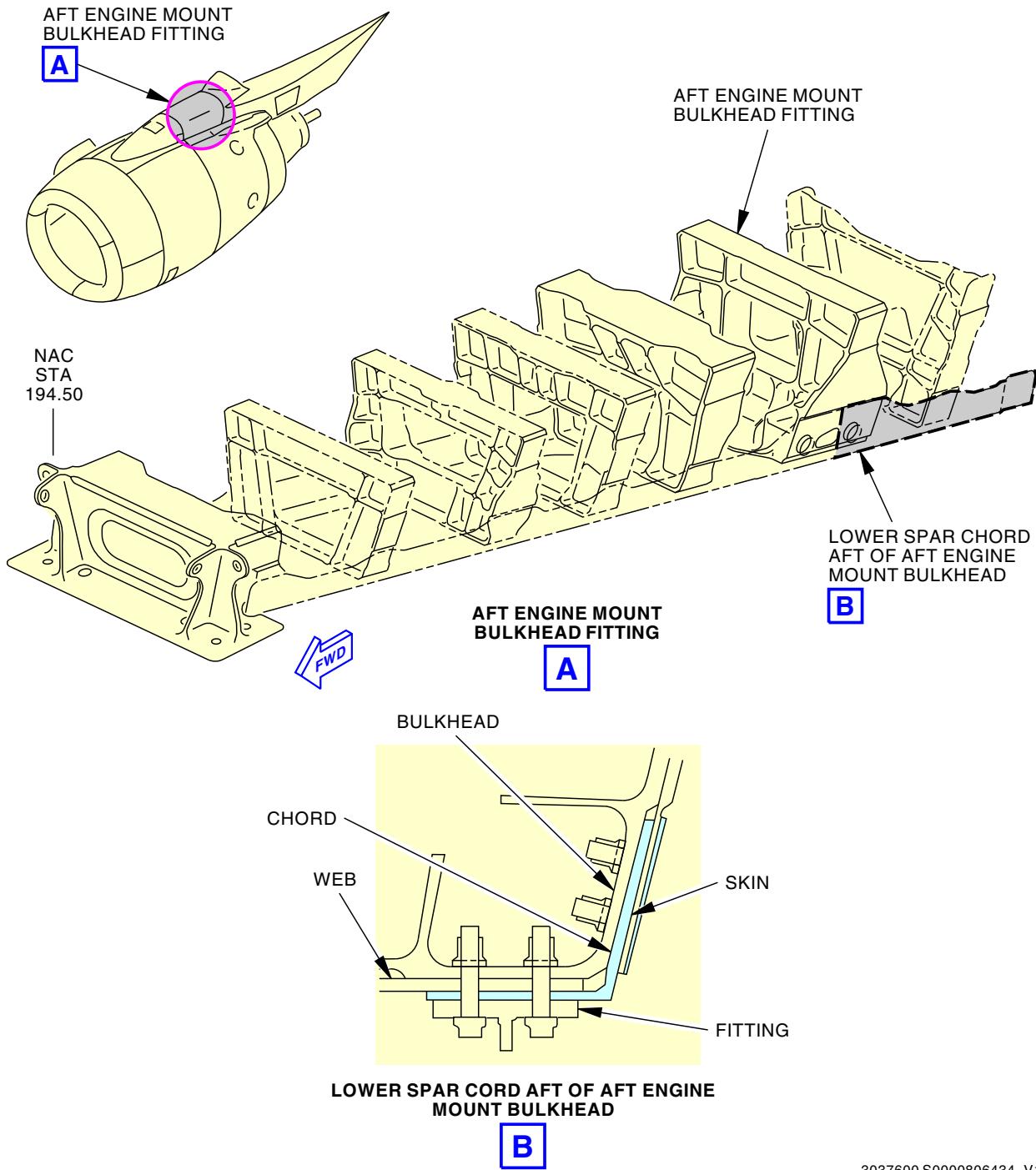
<u>Number</u>	<u>Name/Location</u>
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

———— END OF TASK ————



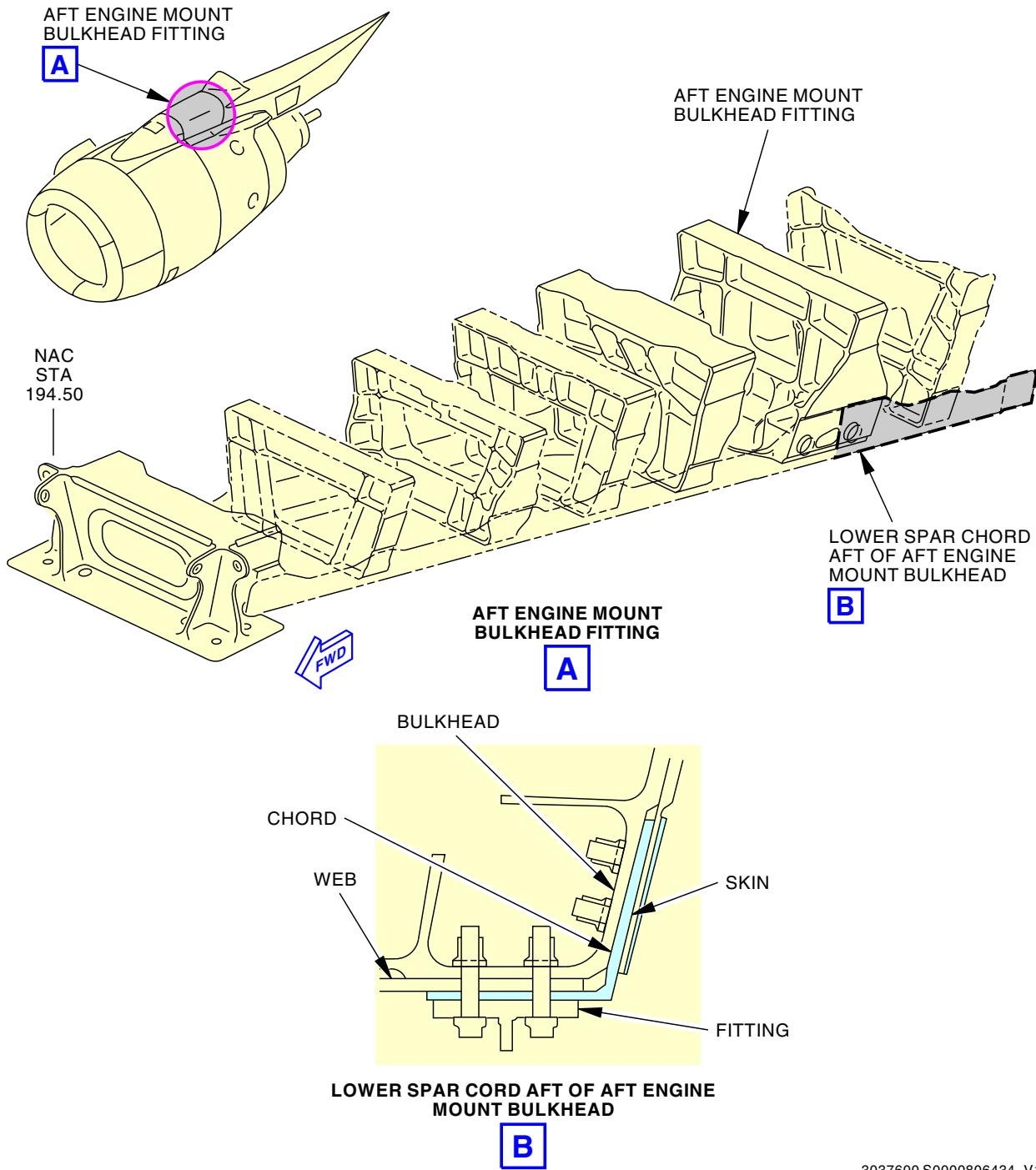
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AFT Engine Mount Bulkhead Fitting
Figure 202/54-05-02-990-802 (Sheet 1 of 2)

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AFT Engine Mount Bulkhead Fitting
Figure 202/54-05-02-990-802 (Sheet 2 of 2)

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TASK 54-05-02-250-811

18. INTERNAL - SPECIAL DETAILED: FORWARD ENGINE MOUNT BULKHEAD

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
433	Engine 1 - Strut Torque Box
443	Engine 2 - Strut Torque Box

B. Access Panels

Number	Name/Location
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

C. Inspection

SUBTASK 54-05-02-010-029

- (1) Open these access panels for Engine No. 1:

Number	Name/Location
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1

Open these access panels for Engine No. 2:

Number	Name/Location
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

NOTE: Bathtub fitting bolts must be sequentially (one at a time) removed for bolt hole eddy current inspection. Retorque tension bolts per dwg requirements.

SUBTASK 54-05-02-250-011

- (2) Do a High Frequency Eddy Current inspection of the end pad bolt holes (4 Locations) at the FWD engine mount bulkhead.

See Doc. D626A001-DTR, DTR check form 54-51-11, 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 54-40-03.

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SUBTASK 54-05-02-410-029

- (3) Close these access panels for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1

Close these access panels for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

———— END OF TASK ————

TASK 54-05-02-250-812

19. INTERNAL - SPECIAL DETAILED: MID STRUT BULKHEAD

NOTE: This procedure is a scheduled maintenance task.

A. References

<u>Reference</u>	<u>Title</u>
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

<u>Zone</u>	<u>Area</u>
433	Engine 1 - Strut Torque Box
443	Engine 2 - Strut Torque Box

C. Access Panels

<u>Number</u>	<u>Name/Location</u>
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
433AT	Strut, Forward Spar Web, Strut 1
433BT	Strut, Forward Spar Web, Strut 1
433CT	Strut, Upper Spar Web, Strut 1
433DT	Strut, Upper Spar Web, Strut 1
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

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D. Inspection

SUBTASK 54-05-02-010-030

- (1) Open these access panels for Engine No. 1:

Number Name/Location

413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1

NOTE: Internal access required.

SUBTASK 54-05-02-010-058

- (2) Open these access panels for Engine No. 1:

Number Name/Location

433AT	Strut, Forward Spar Web, Strut 1
433BT	Strut, Forward Spar Web, Strut 1
433CT	Strut, Upper Spar Web, Strut 1
433DT	Strut, Upper Spar Web, Strut 1

(TASK 54-53-01-000-801)

NOTE: Internal access required.

SUBTASK 54-05-02-010-059

- (3) Open these access panels for Engine No. 2:

Number Name/Location

423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2

NOTE: Internal access required.

SUBTASK 54-05-02-010-060

- (4) Open these access panels for Engine No. 2:

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

(TASK 54-53-01-000-801)

NOTE: Internal access required.

SUBTASK 54-05-02-250-012

- (5) Do a High Frequency Eddy Current inspection of the FWD and Aft flanges of both tension fittings common to the R1 fitting (4) attachment bolts.

See Doc. D626A001-DTR, DTR check form 54-51-14, 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 54-40-12.

SUBTASK 54-05-02-410-030

- (6) Close these access panels for Engine No. 1:

Number Name/Location

413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1

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SUBTASK 54-05-02-410-060

- (7) Close these access panels for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
433AT	Strut, Forward Spar Web, Strut 1
433BT	Strut, Forward Spar Web, Strut 1
433CT	Strut, Upper Spar Web, Strut 1
433DT	Strut, Upper Spar Web, Strut 1

(TASK 54-53-01-400-801)

SUBTASK 54-05-02-410-061

- (8) Close these access panels for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2

SUBTASK 54-05-02-410-062

- (9) Close these access panels for Engine No. 2:

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

(TASK 54-53-01-400-801)

———— END OF TASK ————

TASK 54-05-02-250-813

20. INTERNAL - SPECIAL DETAILED: SIDE SKIN CUTOUTS

NOTE: This procedure is a scheduled maintenance task.

A. References

<u>Reference</u>	<u>Title</u>
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

<u>Zone</u>	<u>Area</u>
433	Engine 1 - Strut Torque Box
443	Engine 2 - Strut Torque Box

C. Access Panels

<u>Number</u>	<u>Name/Location</u>
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2
431DL	Forward Strut Fairing, Left Underwing Fairing, Strut 1
431DR	Forward Strut Fairing, Right Underwing Fairing, Strut 1
433AL	Strut, Left Aft Dry Bay, Strut 1

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Number	Name/Location
433AR	Strut, Right Aft Dry Bay, Strut 1
441DL	Forward Strut Fairing, Left Underwing Fairing, Strut 2
441DR	Forward Strut Fairing, Right Underwing Fairing, Strut 2
443AL	Strut, Left Aft Dry Bay, Strut 2
443AR	Strut, Right Aft Dry Bay, Strut 2

D. Inspection

SUBTASK 54-05-02-010-031

- (1) Open these access panels for Engine No. 1:

Number	Name/Location
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1
431DL	Forward Strut Fairing, Left Underwing Fairing, Strut 1
431DR	Forward Strut Fairing, Right Underwing Fairing, Strut 1

NOTE: Remove thrust reversers as required.

SUBTASK 54-05-02-010-061

- (2) Open these access panels for Engine No. 1:

Number	Name/Location
433AL	Strut, Left Aft Dry Bay, Strut 1
433AR	Strut, Right Aft Dry Bay, Strut 1

(TASK 54-53-01-000-801)

NOTE: Remove thrust reversers as required.

SUBTASK 54-05-02-010-062

- (3) Open these access panels for Engine No. 2:

Number	Name/Location
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2
441DL	Forward Strut Fairing, Left Underwing Fairing, Strut 2
441DR	Forward Strut Fairing, Right Underwing Fairing, Strut 2

NOTE: Remove thrust reversers as required.

SUBTASK 54-05-02-010-063

- (4) Open these access panels for Engine No. 2:

Number	Name/Location
443AL	Strut, Left Aft Dry Bay, Strut 2
443AR	Strut, Right Aft Dry Bay, Strut 2

(TASK 54-53-01-000-801)

NOTE: Remove thrust reversers as required.

SUBTASK 54-05-02-250-013

- (5) Do a High Frequency Eddy Current inspection of all exposed side skin surfaces within 4.5 inches of cutout at nacelle STA 252 and nacelle STA 270 left and right hand sides.

See Doc. D626A001-DTR, DTR check form 54-51-16a, for alternative inspections.

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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 54-40-11.

SUBTASK 54-05-02-410-031

- (6) Close these access panels for Engine No. 1:

Number	Name/Location
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1
431DL	Forward Strut Fairing, Left Underwing Fairing, Strut 1
431DR	Forward Strut Fairing, Right Underwing Fairing, Strut 1

SUBTASK 54-05-02-410-063

- (7) Close these access panels for Engine No. 1:

Number	Name/Location
433AL	Strut, Left Aft Dry Bay, Strut 1
433AR	Strut, Right Aft Dry Bay, Strut 1

(TASK 54-53-01-400-801)

SUBTASK 54-05-02-410-064

- (8) Close these access panels for Engine No. 2:

Number	Name/Location
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2
441DL	Forward Strut Fairing, Left Underwing Fairing, Strut 2
441DR	Forward Strut Fairing, Right Underwing Fairing, Strut 2

SUBTASK 54-05-02-410-065

- (9) Close these access panels for Engine No. 2:

Number	Name/Location
443AL	Strut, Left Aft Dry Bay, Strut 2
443AR	Strut, Right Aft Dry Bay, Strut 2

(TASK 54-53-01-400-801)

———— END OF TASK ————

TASK 54-05-02-130-806

21. INTERNAL - SPECIAL DETAILED: STRUT SIDE SKIN

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
433	Engine 1 - Strut Torque Box
443	Engine 2 - Strut Torque Box

B. Access Panels

Number	Name/Location
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1

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Number	Name/Location
416	Right Thrust Reverser, Engine 1
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2
431DL	Forward Strut Fairing, Left Underwing Fairing, Strut 1
431DR	Forward Strut Fairing, Right Underwing Fairing, Strut 1
441DL	Forward Strut Fairing, Left Underwing Fairing, Strut 2
441DR	Forward Strut Fairing, Right Underwing Fairing, Strut 2

C. Inspection

SUBTASK 54-05-02-010-006

- (1) Open these access panels for Engine No. 1:

Number	Name/Location
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1
431DL	Forward Strut Fairing, Left Underwing Fairing, Strut 1
431DR	Forward Strut Fairing, Right Underwing Fairing, Strut 1

Open these access panels for Engine No. 2:

Number	Name/Location
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2
441DL	Forward Strut Fairing, Left Underwing Fairing, Strut 2
441DR	Forward Strut Fairing, Right Underwing Fairing, Strut 2

SUBTASK 54-05-02-130-006

- (2) Do an Ultrasonic inspection of the strut side skin at nacelle STA 222.6, left and right sides and nacelle STA 242.7, left and right sides.

See Doc. D626A001-DTR, DTR check form 54-51-16b, 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 4, Subject 54-40-05 for Ultrasonic and Part 6, Subject 54-40-21 for HFEC.

NOTE: At nacelle STA 222.6, both an Ultrasonic (UT) and High Frequency Eddy Current (HFEC) inspections are required.

SUBTASK 54-05-02-410-006

- (3) Close these access panels for Engine No. 1:

Number	Name/Location
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1

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<u>Number</u>	<u>Name/Location</u>
416	Right Thrust Reverser, Engine 1
431DL	Forward Strut Fairing, Left Underwing Fairing, Strut 1
431DR	Forward Strut Fairing, Right Underwing Fairing, Strut 1

Close these access panels for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2
441DL	Forward Strut Fairing, Left Underwing Fairing, Strut 2
441DR	Forward Strut Fairing, Right Underwing Fairing, Strut 2

— END OF TASK —

TASK 54-05-02-250-814

22. INTERNAL - SPECIAL DETAILED: UPPER SPAR CHORD

NOTE: This procedure is a scheduled maintenance task.

A. References

<u>Reference</u>	<u>Title</u>
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

<u>Zone</u>	<u>Area</u>
433	Engine 1 - Strut Torque Box
443	Engine 2 - Strut Torque Box

C. Access Panels

<u>Number</u>	<u>Name/Location</u>
431BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 1
431BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 1
431CL	Forward Strut Fairing, Left Overwing Fairing, Strut 1
431CR	Forward Strut Fairing, Right Overwing Fairing, Strut 1
433AT	Strut, Forward Spar Web, Strut 1
433BT	Strut, Forward Spar Web, Strut 1
433CT	Strut, Upper Spar Web, Strut 1
433DT	Strut, Upper Spar Web, Strut 1
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

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D. Inspection

SUBTASK 54-05-02-010-009

- (1) Open these access panels for Engine No. 1:

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

SUBTASK 54-05-02-010-064

- (2) Open these access panels for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
433AT	Strut, Forward Spar Web, Strut 1
433BT	Strut, Forward Spar Web, Strut 1
433CT	Strut, Upper Spar Web, Strut 1
433DT	Strut, Upper Spar Web, Strut 1

(TASK 54-53-01-000-801)

SUBTASK 54-05-02-010-065

- (3) Open these access panels for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
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 54-05-02-010-066

- (4) Open these access panels for Engine No. 2:

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

(TASK 54-53-01-000-801)

SUBTASK 54-05-02-250-014

- (5) Do a High Frequency Eddy Current inspection of the upper spar chord between the forward and aft engine mounts: Nacelle STA 200.9 - 211.5 on the left chords, nacelle STA 213.6 - 225.2 on the left chords, nacelle STA 226.1 - 233.6 on the left chords, nacelle STA 236.3 - 241.8 on the left and right chords.

See Doc. D626A001-DTR, DTR check form 54-51-17a, 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 54-40-07.

SUBTASK 54-05-02-410-009

- (6) Close these access panels for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
431BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 1

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

SUBTASK 54-05-02-410-066

- (7) Close these access panels for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
433AT	Strut, Forward Spar Web, Strut 1
433BT	Strut, Forward Spar Web, Strut 1
433CT	Strut, Upper Spar Web, Strut 1
433DT	Strut, Upper Spar Web, Strut 1

(TASK 54-53-01-400-801)

SUBTASK 54-05-02-410-067

- (8) Close these access panels for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
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 54-05-02-410-068

- (9) Close these access panels for Engine No. 2:

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

(TASK 54-53-01-400-801)

———— END OF TASK ————

TASK 54-05-02-250-815

23. INTERNAL - SPECIAL DETAILED: UPPER SPAR CHORD NEAR CUTOUTS (DIRECTION 1)

NOTE: This procedure is a scheduled maintenance task.

A. References

<u>Reference</u>	<u>Title</u>
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

<u>Zone</u>	<u>Area</u>
433	Engine 1 - Strut Torque Box
443	Engine 2 - Strut Torque Box

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C. Access Panels

<u>Number</u>	<u>Name/Location</u>
431BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 1
431BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 1
431CL	Forward Strut Fairing, Left Overwing Fairing, Strut 1
431CR	Forward Strut Fairing, Right Overwing Fairing, Strut 1
433AT	Strut, Forward Spar Web, Strut 1
433BT	Strut, Forward Spar Web, Strut 1
433CT	Strut, Upper Spar Web, Strut 1
433DT	Strut, Upper Spar Web, Strut 1
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

D. Inspection

SUBTASK 54-05-02-010-032

- (1) Open these access panels for Engine No. 1:

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

SUBTASK 54-05-02-010-067

- (2) Open these access panels for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
433AT	Strut, Forward Spar Web, Strut 1
433BT	Strut, Forward Spar Web, Strut 1
433CT	Strut, Upper Spar Web, Strut 1
433DT	Strut, Upper Spar Web, Strut 1

(TASK 54-53-01-000-801)

SUBTASK 54-05-02-010-068

- (3) Open these access panels for Engine No. 2:

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



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SUBTASK 54-05-02-010-069

- (4) Open these access panels for Engine No. 2:

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

(TASK 54-53-01-000-801)

SUBTASK 54-05-02-250-015

- (5) Do a High Frequency Eddy Current inspection of the upper spar chord near the cutouts:
Nacelle STA 200.9 - nacelle STA 211.5 on the right chord, nacelle STA 213.6 - nacelle STA 225.2 on the right chord, nacelle STA 226.1 - nacelle STA 233.6 on the right chord.

See Doc. D626A001-DTR, DTR check form 54-51-17b, 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 54-40-13.

SUBTASK 54-05-02-410-032

- (6) Close these access panels for Engine No. 1:

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

SUBTASK 54-05-02-410-069

- (7) Close these access panels for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
433AT	Strut, Forward Spar Web, Strut 1
433BT	Strut, Forward Spar Web, Strut 1
433CT	Strut, Upper Spar Web, Strut 1
433DT	Strut, Upper Spar Web, Strut 1

(TASK 54-53-01-400-801)

SUBTASK 54-05-02-410-070

- (8) Close these access panels for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
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 54-05-02-410-071

- (9) Close these access panels for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
443AT	Strut, Forward Spar Web, Strut 2
443BT	Strut, Forward Spar Web, Strut 2
443CT	Strut, Upper Spar Web, Strut 2

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<u>Number</u>	<u>Name/Location</u>
443DT	Strut, Upper Spar Web, Strut 2
(TASK 54-53-01-400-801)	

———— END OF TASK ————

TASK 54-05-02-250-816

24. INTERNAL - SPECIAL DETAILED: UPPER SPAR CHORD NEAR CUTOUTS (DIRECTION 2)

NOTE: This procedure is a scheduled maintenance task.

A. References

<u>Reference</u>	<u>Title</u>
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

<u>Zone</u>	<u>Area</u>
433	Engine 1 - Strut Torque Box
443	Engine 2 - Strut Torque Box

C. Access Panels

<u>Number</u>	<u>Name/Location</u>
431BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 1
431BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 1
431CL	Forward Strut Fairing, Left Overwing Fairing, Strut 1
431CR	Forward Strut Fairing, Right Overwing Fairing, Strut 1
433AT	Strut, Forward Spar Web, Strut 1
433BT	Strut, Forward Spar Web, Strut 1
433CT	Strut, Upper Spar Web, Strut 1
433DT	Strut, Upper Spar Web, Strut 1
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

D. Inspection

SUBTASK 54-05-02-010-033

- (1) Open these access panels for Engine No. 1:

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

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SUBTASK 54-05-02-010-070

- (2) Open these access panels for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
433AT	Strut, Forward Spar Web, Strut 1
433BT	Strut, Forward Spar Web, Strut 1
433CT	Strut, Upper Spar Web, Strut 1
433DT	Strut, Upper Spar Web, Strut 1

(TASK 54-53-01-000-801)

SUBTASK 54-05-02-010-071

- (3) Open these access panels for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
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 54-05-02-010-072

- (4) Open these access panels for Engine No. 2:

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

(TASK 54-53-01-000-801)

SUBTASK 54-05-02-250-016

- (5) Do a High Frequency Eddy Current inspection of the upper spar chord near the cutouts:
Nacelle STA 200.9 - nacelle STA 211.5 on the right chord, nacelle STA 213.6 - nacelle STA 225.2 on the right chord, nacelle STA 226.1 - Nacelle STA 233.6 on the right chord.

See Doc. D626A001-DTR, DTR check form 54-51-17b, 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 54-40-13.

SUBTASK 54-05-02-410-033

- (6) Close these access panels for Engine no. 1:

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

SUBTASK 54-05-02-410-072

- (7) Close these access panels for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
433AT	Strut, Forward Spar Web, Strut 1
433BT	Strut, Forward Spar Web, Strut 1
433CT	Strut, Upper Spar Web, Strut 1



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<u>Number</u>	<u>Name/Location</u>
433DT	Strut, Upper Spar Web, Strut 1
(TASK 54-53-01-400-801)	

SUBTASK 54-05-02-410-073

- (8) Close these access panels for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
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 54-05-02-410-074

- (9) Close these access panels for Engine No. 2:

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

(TASK 54-53-01-400-801)

———— END OF TASK ————

TASK 54-05-02-250-817

25. **INTERNAL - SPECIAL DETAILED: UPPER SPAR, R1 - FITTING AND UPPER SPAR WEB JOINTS, CHORD ONLY (DIRECTION 1)**

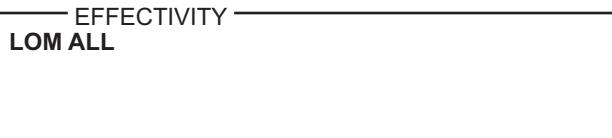
NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
433	Engine 1 - Strut Torque Box
443	Engine 2 - Strut Torque Box

B. Access Panels

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



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C. Inspection

SUBTASK 54-05-02-010-034

- (1) Open these access panels for Engine No. 1:

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

Open these access panels for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
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 54-05-02-250-017

- (2) Do a High Frequency Eddy Current inspection of the upper spar, R1 fitting and upper spar web on the (horizontal) chord only near the cutouts: Nacelle STA 200.9 to nacelle STA 211.5, nacelle STA 213.6 to nacelle STA 225.2, nacelle STA 226.1 to nacelle STA 233.6.

See Doc. D626A001-DTR, DTR check form 54-51-17c1, 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 54-40-18.

SUBTASK 54-05-02-410-034

- (3) Close these access panels for Engine No. 1:

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

Close these access panels for Engine No. 2:

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

———— END OF TASK ————

TASK 54-05-02-250-818

26. INTERNAL - SPECIAL DETAILED: UPPER SPAR, R1 - FITTING AND UPPER SPAR WEB JOINTS - CHORD ONLY (DIRECTION 2)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
433	Engine 1 - Strut Torque Box

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Zone Area

443	Engine 2 - Strut Torque Box
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B. Access Panels

Number Name/Location

431BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 1
431BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 1
431CL	Forward Strut Fairing, Left Overwing Fairing, Strut 1
431CR	Forward Strut Fairing, Right Overwing Fairing, Strut 1
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

C. Inspection

SUBTASK 54-05-02-010-035

- (1) Open these access panels for Engine No. 1:

Number Name/Location

431BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 1
431BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 1
431CL	Forward Strut Fairing, Left Overwing Fairing, Strut 1
431CR	Forward Strut Fairing, Right Overwing Fairing, Strut 1

Open these access panels for Engine No. 2:

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 54-05-02-250-018

- (2) Do a High Frequency Eddy Current inspection of the upper spar, R1 fitting and upper spar web on the (vertical) chord only near the cutouts: Nacelle STA 200.9 to nacelle STA 211.5, nacelle STA 213.6 to nacelle STA 225.2, nacelle STA 226.1 to nacelle STA 233.6.

See Doc. D626A001-DTR, DTR check form 54-51-17c1, 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 54-40-18.

SUBTASK 54-05-02-410-035

- (3) Close these access panels for Engine No. 1:

Number Name/Location

431BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 1
431BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 1
431CL	Forward Strut Fairing, Left Overwing Fairing, Strut 1
431CR	Forward Strut Fairing, Right Overwing Fairing, Strut 1



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Close these access panels for Engine No. 2:

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

———— END OF TASK ————

TASK 54-05-02-250-819

27. INTERNAL - SPECIAL DETAILED: UPPER SPAR, R1 - FITTING AND UPPER SPAR JOINTS - WEB ONLY

NOTE: This procedure is a scheduled maintenance task.

A. References

<u>Reference</u>	<u>Title</u>
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

<u>Zone</u>	<u>Area</u>
433	Engine 1 - Strut Torque Box
443	Engine 2 - Strut Torque Box

C. Access Panels

<u>Number</u>	<u>Name/Location</u>
431BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 1
431BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 1
431CL	Forward Strut Fairing, Left Overwing Fairing, Strut 1
431CR	Forward Strut Fairing, Right Overwing Fairing, Strut 1
433AT	Strut, Forward Spar Web, Strut 1
433BT	Strut, Forward Spar Web, Strut 1
433CT	Strut, Upper Spar Web, Strut 1
433DT	Strut, Upper Spar Web, Strut 1
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

D. Inspection

SUBTASK 54-05-02-010-036

- (1) Open these access panels for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
431BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 1
431BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 1

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Number

Name/Location

431CL	Forward Strut Fairing, Left Overwing Fairing, Strut 1
431CR	Forward Strut Fairing, Right Overwing Fairing, Strut 1

SUBTASK 54-05-02-010-073

- (2) Open these access panels for Engine No. 1:

Number

Name/Location

433AT	Strut, Forward Spar Web, Strut 1
433BT	Strut, Forward Spar Web, Strut 1
433CT	Strut, Upper Spar Web, Strut 1
433DT	Strut, Upper Spar Web, Strut 1

(TASK 54-53-01-000-801)

SUBTASK 54-05-02-010-074

- (3) Open these access panels for Engine No. 2:

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 54-05-02-010-075

- (4) Open these access panels for Engine No. 2:

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

(TASK 54-53-01-000-801)

SUBTASK 54-05-02-250-019

- (5) Do a High Frequency Eddy Current inspection of the upper spar, R1 fitting and upper spar joints, web only near cutouts: Nacelle STA 200.9 - to nacelle STA 211.5, nacelle STA 213.6 - to nacelle STA 225.2, nacelle STA 226.1 - to nacelle STA 233.6.

See Doc. D626A001-DTR, DTR check form 54-51-17c2, for alternative inspections. The inspection procedures are contained in Part 6, Subject 54-40-18.

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 54-40-18.

SUBTASK 54-05-02-410-036

- (6) Close these access panels for Engine No. 1:

Number

Name/Location

431BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 1
431BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 1
431CL	Forward Strut Fairing, Left Overwing Fairing, Strut 1
431CR	Forward Strut Fairing, Right Overwing Fairing, Strut 1



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SUBTASK 54-05-02-410-075

- (7) Close these access panels for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
433AT	Strut, Forward Spar Web, Strut 1
433BT	Strut, Forward Spar Web, Strut 1
433CT	Strut, Upper Spar Web, Strut 1
433DT	Strut, Upper Spar Web, Strut 1

(TASK 54-53-01-400-801)

SUBTASK 54-05-02-410-076

- (8) Close these access panels for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
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 54-05-02-410-077

- (9) Close these access panels for Engine No. 2:

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

(TASK 54-53-01-400-801)

———— END OF TASK ————

TASK 54-05-02-250-820

28. INTERNAL - SPECIAL DETAILED: UPPER AND LOWER SPAR CHORDS

NOTE: This procedure is a scheduled maintenance task.

A. References

<u>Reference</u>	<u>Title</u>
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

<u>Zone</u>	<u>Area</u>
433	Engine 1 - Strut Torque Box
443	Engine 2 - Strut Torque Box

C. Access Panels

<u>Number</u>	<u>Name/Location</u>
431AT	Forward Strut Fairing, Thumbnail Fairing, Strut 1
431BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 1
431BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 1
433AT	Strut, Forward Spar Web, Strut 1
441AT	Forward Strut Fairing, Thumbnail Fairing, Strut 2

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<u>Number</u>	<u>Name/Location</u>
441BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 2
441BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 2
443AT	Strut, Forward Spar Web, Strut 2

D. Inspection

SUBTASK 54-05-02-010-037

- (1) Open these access panels for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
431AT	Forward Strut Fairing, Thumbnail Fairing, Strut 1
431BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 1
431BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 1

SUBTASK 54-05-02-010-076

- (2) Open this access panel for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
433AT	Strut, Forward Spar Web, Strut 1

(TASK 54-53-01-000-801)

SUBTASK 54-05-02-010-077

- (3) Open these access panels for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
441AT	Forward Strut Fairing, Thumbnail Fairing, Strut 2
441BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 2
441BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 2

SUBTASK 54-05-02-010-078

- (4) Open this access panel for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
443AT	Strut, Forward Spar Web, Strut 2

(TASK 54-53-01-000-801)

SUBTASK 54-05-02-250-020

- (5) Do a Low Frequency Eddy Current inspection of the chords, skins, webs, and bulkhead in all splices to the FWD engine mount bulkhead. Inspect the inside and the outside of the strut, and all structure buried in the splices using low frequency subsurface eddy current. Do Ultrasonic shear wave inspections for all fastener locations which cannot be inspected with LFEC.

See Doc. D626A001-DTR, DTR check form 54-51-17d, 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 54-40-20 for LFEC and Part 4, Subject 54-40-09 for Ultrasonic.

SUBTASK 54-05-02-410-037

- (6) Close these access panels for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
431AT	Forward Strut Fairing, Thumbnail Fairing, Strut 1
431BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 1
431BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 1

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SUBTASK 54-05-02-410-078

- (7) Close this access panel for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
433AT	Strut, Forward Spar Web, Strut 1
(TASK 54-53-01-400-801)	

SUBTASK 54-05-02-410-079

- (8) Close these access panels for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
441AT	Forward Strut Fairing, Thumbnail Fairing, Strut 2
441BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 2
441BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 2

SUBTASK 54-05-02-410-080

- (9) Close this access panel for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
443AT	Strut, Forward Spar Web, Strut 2
(TASK 54-53-01-400-801)	

———— END OF TASK ————

TASK 54-05-02-250-821

29. INTERNAL - SPECIAL DETAILED: UPPER AND LOWER SPAR CHORDS

NOTE: This procedure is a scheduled maintenance task.

A. References

<u>Reference</u>	<u>Title</u>
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. Consumable Materials

<u>Reference</u>	<u>Description</u>	<u>Specification</u>
D00633	Grease - Aircraft General Purpose	BMS3-33

C. Location Zones

<u>Zone</u>	<u>Area</u>
433	Engine 1 - Strut Torque Box
443	Engine 2 - Strut Torque Box

D. Access Panels

<u>Number</u>	<u>Name/Location</u>
431AL	Forward Strut Fairing, Left Thrust Reverser Disconnect, Strut 1
431AR	Forward Strut Fairing, Right Thrust Reverser Disconnect, Strut 1
431AT	Forward Strut Fairing, Thumbnail Fairing, Strut 1
431BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 1
431BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 1
433AT	Strut, Forward Spar Web, Strut 1
441AL	Forward Strut Fairing, Left Thrust Reverser Disconnect, Strut 2
441AR	Forward Strut Fairing, Right Thrust Reverser Disconnect, Strut 2
441AT	Forward Strut Fairing, Thumbnail Fairing, Strut 2

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<u>Number</u>	<u>Name/Location</u>
441BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 2
441BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 2
443AT	Strut, Forward Spar Web, Strut 2

E. Inspection

SUBTASK 54-05-02-010-038

- (1) Open these access panels for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
431AL	Forward Strut Fairing, Left Thrust Reverser Disconnect, Strut 1
431AR	Forward Strut Fairing, Right Thrust Reverser Disconnect, Strut 1
431AT	Forward Strut Fairing, Thumbnail Fairing, Strut 1
431BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 1
431BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 1

SUBTASK 54-05-02-010-079

- (2) Open this access panel for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
433AT	Strut, Forward Spar Web, Strut 1

(TASK 54-53-01-000-801)

SUBTASK 54-05-02-010-080

- (3) Open these access panels for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
441AL	Forward Strut Fairing, Left Thrust Reverser Disconnect, Strut 2
441AR	Forward Strut Fairing, Right Thrust Reverser Disconnect, Strut 2
441AT	Forward Strut Fairing, Thumbnail Fairing, Strut 2
441BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 2
441BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 2

SUBTASK 54-05-02-010-081

- (4) Open this access panel for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
443AT	Strut, Forward Spar Web, Strut 2

(TASK 54-53-01-000-801)

SUBTASK 54-05-02-250-021

- (5) Do a High Frequency Eddy Current inspection of the chords, skins, webs, and bulkhead in all splices to the FWD engine mount bulkhead. Inspect the inside and the outside of the strut, and all visible structure in the splices using high frequency surface eddy current. Do Ultrasonic shear wave inspections for all fastener locations which cannot be inspected with HFEC.

See Doc. D626A001-DTR, DTR check form 54-51-17d, 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 54-40-19 for HFEC and Part 4, Subject 54-40-09 for Ultrasonic.

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SUBTASK 54-05-02-410-038

- (6) Close these access panels for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
431AT	Forward Strut Fairing, Thumbnail Fairing, Strut 1
431BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 1
431BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 1

SUBTASK 54-05-02-410-081

- (7) Close this access panel for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
433AT	Strut, Forward Spar Web, Strut 1 (TASK 54-53-01-400-801)

SUBTASK 54-05-02-410-082

- (8) Close these access panels for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
441AT	Forward Strut Fairing, Thumbnail Fairing, Strut 2
441BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 2
441BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 2

SUBTASK 54-05-02-410-083

- (9) Close this access panel for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
443AT	Strut, Forward Spar Web, Strut 2 (TASK 54-53-01-400-801)

SUBTASK 54-05-02-410-046

- (10) Do these steps to close the applicable access panels:

- (a) Close these access panels for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
431AL	Forward Strut Fairing, Left Thrust Reverser Disconnect, Strut 1
431AR	Forward Strut Fairing, Right Thrust Reverser Disconnect, Strut 1

- (b) Close these access panels for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
441AL	Forward Strut Fairing, Left Thrust Reverser Disconnect, Strut 2
441AR	Forward Strut Fairing, Right Thrust Reverser Disconnect, Strut 2

- (c) Install the bolts with grease, D00633, on the access panels.

- 1) Install the two lower bolts and tighten sufficiently to compress the seal before torque.

NOTE: The access panel and seal under panel are installed as one assembly.

- a) Make sure that the seal does not have interference with the seal on the thumbnail fairing.

- 2) Install the four upper bolts.

- 3) Tighten the bolts to 65 ± 15 in-lb (7 ± 2 N·m).

———— END OF TASK ————

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TASK 54-05-02-250-822

30. INTERNAL - SPECIAL DETAILED: UPPER SPAR CHORD

NOTE: This procedure is a scheduled maintenance task.

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
433	Engine 1 - Strut Torque Box
443	Engine 2 - Strut Torque Box

C. Access Panels

Number	Name/Location
431BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 1
431BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 1
431CL	Forward Strut Fairing, Left Overwing Fairing, Strut 1
431CR	Forward Strut Fairing, Right Overwing Fairing, Strut 1
433AT	Strut, Forward Spar Web, Strut 1
433BT	Strut, Forward Spar Web, Strut 1
433CT	Strut, Upper Spar Web, Strut 1
433DT	Strut, Upper Spar Web, Strut 1
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

D. Inspection

SUBTASK 54-05-02-010-039

- (1) Open these access panels for Engine No. 1:

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

SUBTASK 54-05-02-010-082

- (2) Open these access panels for Engine No. 1:

Number	Name/Location
433AT	Strut, Forward Spar Web, Strut 1
433BT	Strut, Forward Spar Web, Strut 1
433CT	Strut, Upper Spar Web, Strut 1

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<u>Number</u>	<u>Name/Location</u>
433DT	Strut, Upper Spar Web, Strut 1
(TASK 54-53-01-000-801)	

SUBTASK 54-05-02-010-083

- (3) Open these access panels for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
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 54-05-02-010-084

- (4) Open these access panels for Engine No. 2:

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

(TASK 54-53-01-000-801)

SUBTASK 54-05-02-250-022

- (5) Do a High Frequency Eddy Current inspection of the left and right upper spar chords at nacelle STA 210.6, nacelle STA 222.6, nacelle STA 235.1, and nacelle STA 256.5.

See Doc. D626A001-DTR, DTR check form 54-51-17e, 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 54-40-05.

SUBTASK 54-05-02-410-039

- (6) Close these access panels for Engine No. 1:

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

SUBTASK 54-05-02-410-084

- (7) Close these access panels for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
433AT	Strut, Forward Spar Web, Strut 1
433BT	Strut, Forward Spar Web, Strut 1
433CT	Strut, Upper Spar Web, Strut 1
433DT	Strut, Upper Spar Web, Strut 1

(TASK 54-53-01-400-801)



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SUBTASK 54-05-02-410-085

- (8) Close these access panels for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
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 54-05-02-410-086

- (9) Close these access panels for Engine No. 2:

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

(TASK 54-53-01-400-801)

———— END OF TASK ————

TASK 54-05-02-130-807

31. INTERNAL - SPECIAL DETAILED: UPPER SPAR CHORD

NOTE: This procedure is a scheduled maintenance task.

A. References

<u>Reference</u>	<u>Title</u>
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

<u>Zone</u>	<u>Area</u>
433	Engine 1 - Strut Torque Box
443	Engine 2 - Strut Torque Box

C. Access Panels

<u>Number</u>	<u>Name/Location</u>
431BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 1
431BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 1
431CL	Forward Strut Fairing, Left Overwing Fairing, Strut 1
431CR	Forward Strut Fairing, Right Overwing Fairing, Strut 1
433AT	Strut, Forward Spar Web, Strut 1
433BT	Strut, Forward Spar Web, Strut 1
433CT	Strut, Upper Spar Web, Strut 1
433DT	Strut, Upper Spar Web, Strut 1
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

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<u>Number</u>	<u>Name/Location</u>
443CT	Strut, Upper Spar Web, Strut 2
443DT	Strut, Upper Spar Web, Strut 2

D. Inspection

SUBTASK 54-05-02-010-008

- (1) Open these access panels for Engine No. 1:

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

SUBTASK 54-05-02-010-085

- (2) Open these access panels for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
433AT	Strut, Forward Spar Web, Strut 1
433BT	Strut, Forward Spar Web, Strut 1
433CT	Strut, Upper Spar Web, Strut 1
433DT	Strut, Upper Spar Web, Strut 1

(TASK 54-53-01-000-801)

SUBTASK 54-05-02-010-086

- (3) Open these access panels for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
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 54-05-02-010-087

- (4) Open these access panels for Engine No. 2:

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

(TASK 54-53-01-000-801)

SUBTASK 54-05-02-130-007

- (5) Do an Ultrasonic inspection of the hidden portion of the upper spar chord at nacelle STA 242.7 on the left and right chords.

See Doc. D626A001-DTR, DTR check form 54-51-17f, 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 4, Subject 54-40-01.

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SUBTASK 54-05-02-410-008

- (6) Close these access panels for Engine No. 1:

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

SUBTASK 54-05-02-410-087

- (7) Close these access panels for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
433AT	Strut, Forward Spar Web, Strut 1
433BT	Strut, Forward Spar Web, Strut 1
433CT	Strut, Upper Spar Web, Strut 1
433DT	Strut, Upper Spar Web, Strut 1

(TASK 54-53-01-400-801)

SUBTASK 54-05-02-410-088

- (8) Close these access panels for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
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 54-05-02-410-089

- (9) Close these access panels for Engine No. 2:

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

(TASK 54-53-01-400-801)

———— END OF TASK ————

TASK 54-05-02-250-823

32. INTERNAL - SPECIAL DETAILED: UPPER SPAR CHORD

NOTE: This procedure is a scheduled maintenance task.

A. References

<u>Reference</u>	<u>Title</u>
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

<u>Zone</u>	<u>Area</u>
433	Engine 1 - Strut Torque Box
443	Engine 2 - Strut Torque Box

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C. Access Panels

<u>Number</u>	<u>Name/Location</u>
431BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 1
431BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 1
431CL	Forward Strut Fairing, Left Overwing Fairing, Strut 1
431CR	Forward Strut Fairing, Right Overwing Fairing, Strut 1
433AT	Strut, Forward Spar Web, Strut 1
433BT	Strut, Forward Spar Web, Strut 1
433CT	Strut, Upper Spar Web, Strut 1
433DT	Strut, Upper Spar Web, Strut 1
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

D. Inspection

SUBTASK 54-05-02-010-040

- (1) Open these access panels for Engine No. 1:

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

SUBTASK 54-05-02-010-088

- (2) Open these access panels for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
433AT	Strut, Forward Spar Web, Strut 1
433BT	Strut, Forward Spar Web, Strut 1
433CT	Strut, Upper Spar Web, Strut 1
433DT	Strut, Upper Spar Web, Strut 1

(TASK 54-53-01-000-801)

SUBTASK 54-05-02-010-089

- (3) Open these access panels for Engine No. 2:

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

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SUBTASK 54-05-02-010-090

- (4) Open these access panels for Engine No. 2:

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

(TASK 54-53-01-000-801)

SUBTASK 54-05-02-250-023

- (5) Do a High Frequency Eddy Current inspection of the visible portion of the upper spar chord at nacelle STA 242.7 on the left and right chords.

See Doc. D626A001-DTR, DTR check form 54-51-17f, 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 54-40-06.

SUBTASK 54-05-02-410-040

- (6) Close these access panels for Engine No. 1:

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

SUBTASK 54-05-02-410-090

- (7) Close these access panels for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
433AT	Strut, Forward Spar Web, Strut 1
433BT	Strut, Forward Spar Web, Strut 1
433CT	Strut, Upper Spar Web, Strut 1
433DT	Strut, Upper Spar Web, Strut 1

(TASK 54-53-01-400-801)

SUBTASK 54-05-02-410-091

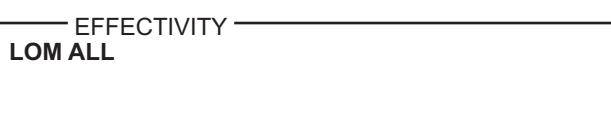
- (8) Close these access panels for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
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 54-05-02-410-092

- (9) Close these access panels for Engine No. 2:

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



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(TASK 54-53-01-400-801)

— END OF TASK —

TASK 54-05-02-250-824

33. INTERNAL - SPECIAL DETAILED: R3/R4 FIRST FASTENER ROW - VERTICAL LEG

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
433	Engine 1 - Strut Torque Box
443	Engine 2 - Strut Torque Box

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
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

D. Inspection

SUBTASK 54-05-02-010-041

- (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 for Engine No. 1:

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

- (b) Remove these access panels for Engine No. 2:

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

SUBTASK 54-05-02-010-044

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

- (a) Remove these access panels for Engine No. 1:

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

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- (b) Remove these access panels for Engine No. 2:

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

SUBTASK 54-05-02-250-024

- (3) Do a High Frequency Eddy Current inspection of all exposed surfaces of the R3/R4 first fastener row on the vertical leg right and left sides.

See Doc. D626A001-DTR, DTR check form 54-51-17g, 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 54-40-04.

SUBTASK 54-05-02-410-041

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

- (a) Install these access panels for Engine No. 1:

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

- (b) Install these access panels for Engine No. 2:

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

SUBTASK 54-05-02-410-045

- (5) Install these FWD fairing access panels:

- (a) Install these access panels for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
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 for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
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 54-05-02-230-801

34. INTERNAL - SPECIAL DETAILED: FORWARD ENGINE MOUNT HANGER

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
413	Engine 1 - Fan Cowl, Left
414	Engine 1 - Fan Cowl, Right
423	Engine 2 - Fan Cowl, Left
424	Engine 2 - Fan Cowl, Right

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B. Access Panels

Number	Name/Location
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

C. Inspection

SUBTASK 54-05-02-010-015

- (1) Open these access panels for Engine No. 1:

Number	Name/Location
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1

Open these access panels for Engine No. 2:

Number	Name/Location
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

NOTE: Removal of engine and engine mount is required.

SUBTASK 54-05-02-230-001

- (2) Do a Penetrant inspection of the entire forward engine mount hanger. The critical detail is the bolt hole detail at the top of the mount.

See Doc. D626A001-DTR, DTR check form 54-55-03, for alternative inspections.

SUBTASK 54-05-02-410-015

- (3) Close these access panels for Engine No. 1:

Number	Name/Location
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1

Close these access panels for Engine No. 2:

Number	Name/Location
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

———— END OF TASK ————



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TASK 54-05-02-210-802

35. INTERNAL - GENERAL VISUAL: THRUST LINK ASSEMBLY

Figure 203

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
415	Engine 1 - Thrust Reverser, Left
416	Engine 1 - Thrust Reverser, Right
425	Engine 2 - Thrust Reverser, Left
426	Engine 2 - Thrust Reverser, Right

B. Access Panels

Number	Name/Location
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

C. Inspection

SUBTASK 54-05-02-010-011

- (1) Open these access panels for Engine No. 1:

Number	Name/Location
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1

Open these access panels for Engine No. 2:

Number	Name/Location
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

SUBTASK 54-05-02-210-002

- (2) Do a General Visual inspection of the thrust link and the thrust link clevis lug. Lead crack is the failed thrust link. Critical detail is the intact thrust link clevis lug.

See Doc. D626A001-DTR, DTR check form 54-55-05, for alternative inspections.

SUBTASK 54-05-02-410-011

- (3) Close these access panels for Engine No. 1:

Number	Name/Location
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1

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<u>Number</u>	<u>Name/Location</u>
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1

Close these access panels for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

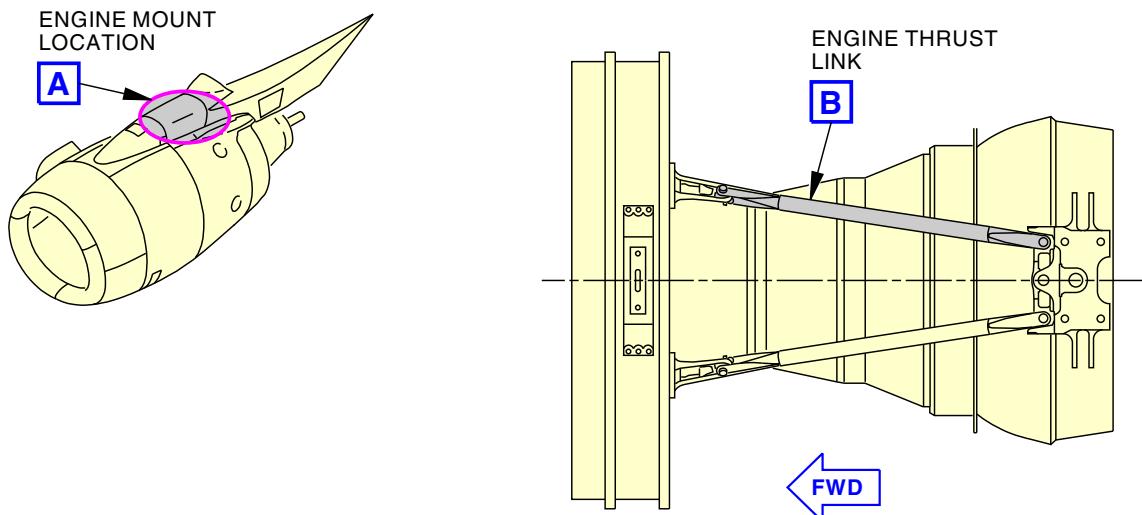
———— END OF TASK ————

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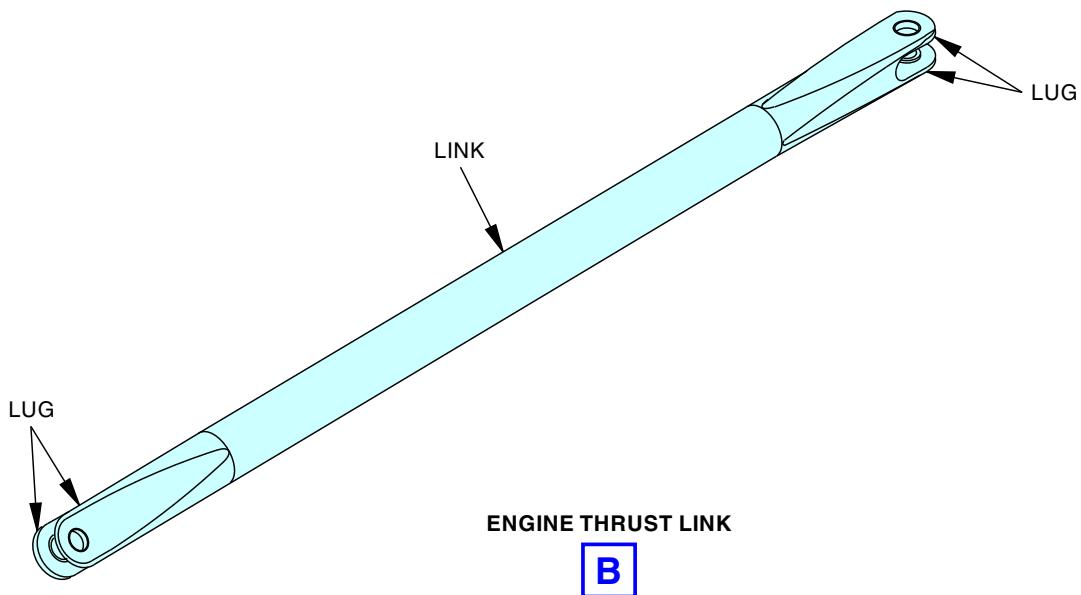


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AFT ENGINE MOUNT LOCATION
(VIEW IN THE INBOARD DIRECTION)

A



3037120 S0000806190_V1

Thrust Link Assembly
Figure 203/54-05-02-990-803

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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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TASK 54-05-02-210-803

36. INTERNAL - GENERAL VISUAL: THRUST LINK PIN

Figure 204

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
415	Engine 1 - Thrust Reverser, Left
416	Engine 1 - Thrust Reverser, Right
425	Engine 2 - Thrust Reverser, Left
426	Engine 2 - Thrust Reverser, Right

B. Access Panels

Number	Name/Location
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

C. Inspection

SUBTASK 54-05-02-010-012

- (1) Open these access panels for Engine No. 1:

Number	Name/Location
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1

Open these access panels for Engine No. 2:

Number	Name/Location
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

SUBTASK 54-05-02-210-003

- (2) Do General Visual inspection of the thrust link pin. Lead crack is the failed thrust link pin.
Critical detail is the intact thrust link clevis lug.

See Doc. D626A001-DTR, DTR check form 54-55-06, for alternative inspections.

SUBTASK 54-05-02-410-012

- (3) Close these access panels for Engine No. 1:

Number	Name/Location
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1

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<u>Number</u>	<u>Name/Location</u>
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1

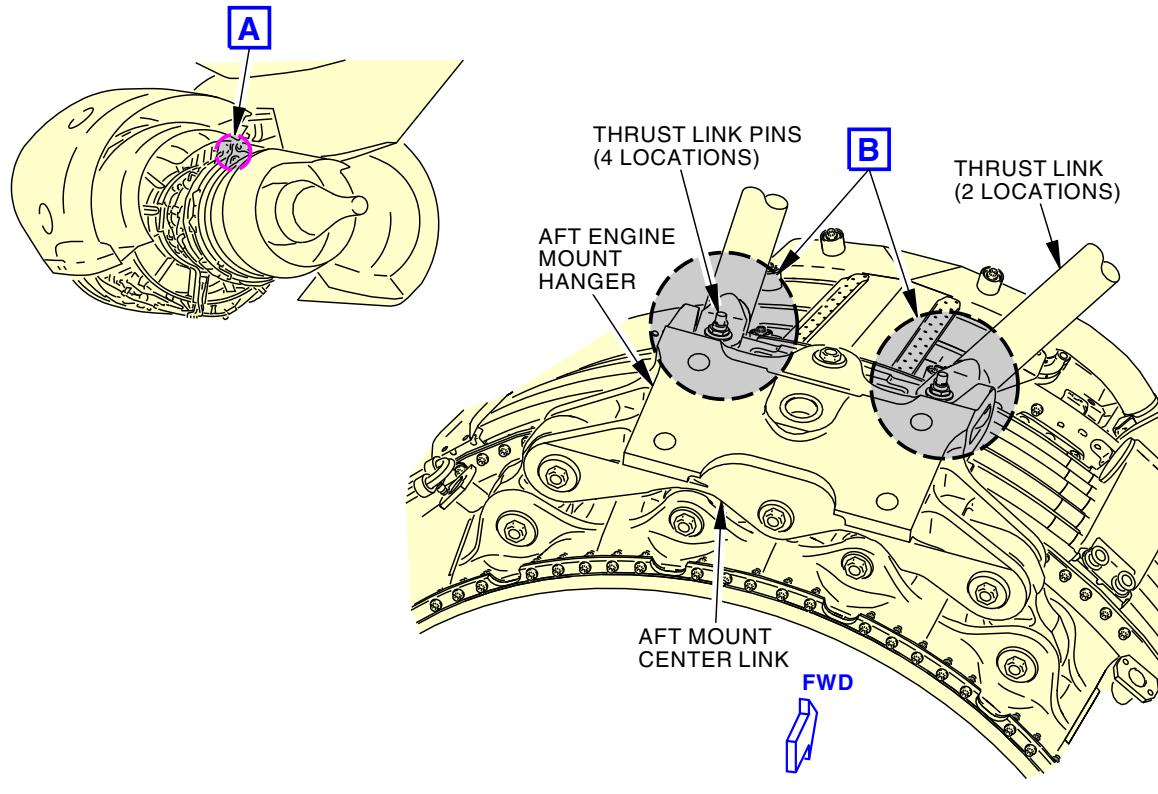
Close these access panels for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

———— END OF TASK ————

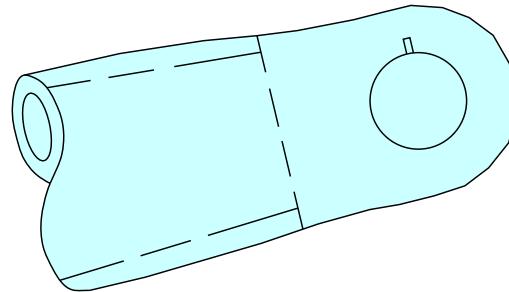
EFFECTIVITY
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**LEFT AFT ENGINE MOUNT
(RIGHT AFT ENGINE MOUNT IS EQUIVALENT)**

A



THRUST LINK CLEVIS LUG

B

3036955 S0000806152_V1

Thrust Link Pin
Figure 204/54-05-02-990-806

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TASK 54-05-02-230-802

37. INTERNAL - SPECIAL DETAILED: AFT ENGINE MOUNT HANGER

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
415	Engine 1 - Thrust Reverser, Left
416	Engine 1 - Thrust Reverser, Right
425	Engine 2 - Thrust Reverser, Left
426	Engine 2 - Thrust Reverser, Right

B. Access Panels

Number	Name/Location
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

C. Inspection

SUBTASK 54-05-02-010-016

- (1) Open these access panels for Engine No. 1:

Number	Name/Location
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1

Open these access panels for Engine No. 2:

Number	Name/Location
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

NOTE: The inspection requires the removal of the engine and disassembly of the engine mount.

SUBTASK 54-05-02-230-002

- (2) Do a Penetrant inspection of the aft engine mount hanger. The aft mount critical detail is the shear pin hole.

See Doc. D626A001-DTR, DTR check form 54-55-10, for alternative inspections.

SUBTASK 54-05-02-410-016

- (3) Close these access panels for Engine No. 1:

Number	Name/Location
413	Left Fan Cowl, Engine 1

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(Continued)

<u>Number</u>	<u>Name/Location</u>
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1

Close these access panels for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

———— END OF TASK ————

TASK 54-05-02-210-804

38. INTERNAL - GENERAL VISUAL: EVENER BAR ASSEMBLY - OUTBOARD LUGS

Figure 205

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
415	Engine 1 - Thrust Reverser, Left
416	Engine 1 - Thrust Reverser, Right
425	Engine 2 - Thrust Reverser, Left
426	Engine 2 - Thrust Reverser, Right

B. Access Panels

<u>Number</u>	<u>Name/Location</u>
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

C. Inspection

SUBTASK 54-05-02-010-013

- (1) Open these access panels for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1

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Open these access panels for Engine No. 2:

Number	Name/Location
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

SUBTASK 54-05-02-210-004

- (2) Do a General Visual inspection of the evener bar assembly outboard lugs. Lead crack is the failed evener bar (outboard lug). Critical detail is the intact thrust link clevis lug.

See Doc. D626A001-DTR, DTR check form 54-55-11a, for alternative inspections.

SUBTASK 54-05-02-410-013

- (3) Close these access panels for Engine No. 1:

Number	Name/Location
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1

Close these access panels for Engine No. 2:

Number	Name/Location
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

———— END OF TASK ————

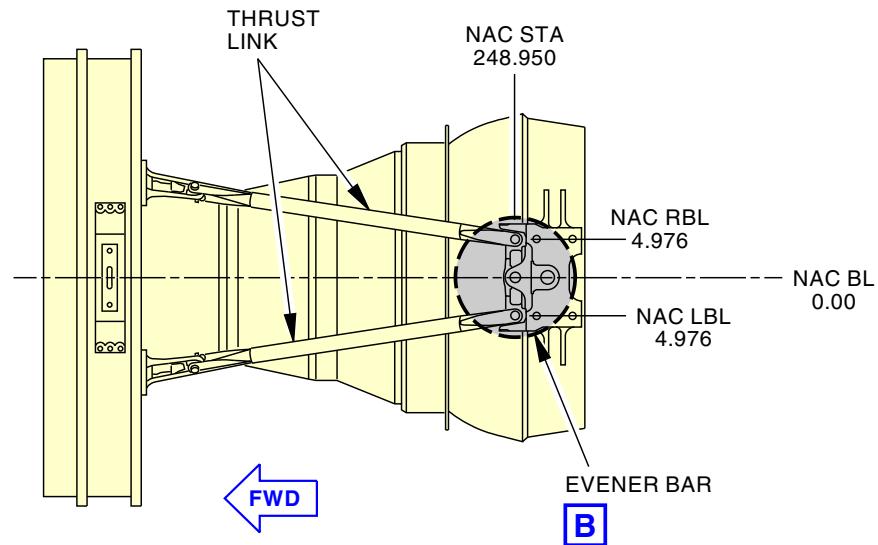
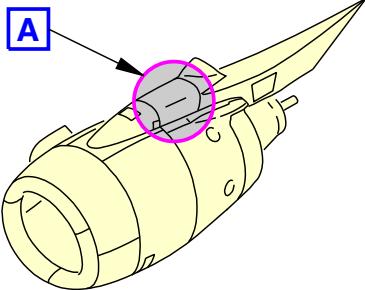


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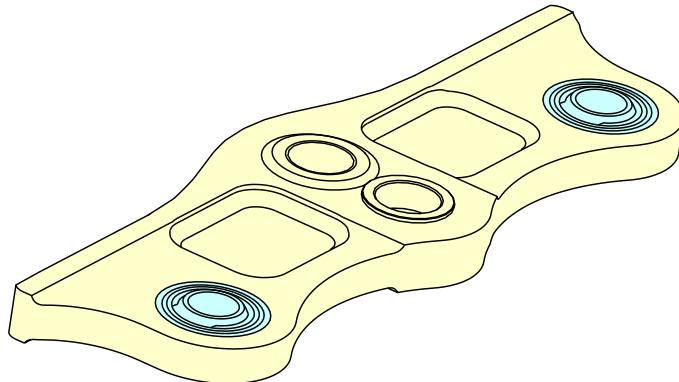
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ENGINE MOUNT LOCATION



AFT ENGINE MOUNT LOCATION
(VIEW IN THE INBOARD DIRECTION)

A



EVENER BAR

B

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Evener Bar Outboard lugs
Figure 205/54-05-02-990-804

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TASK 54-05-02-230-803

39. INTERNAL - SPECIAL DETAILED: AFT ENGINE MOUNT EVENER BAR - MID SPAN

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

Zone	Area
415	Engine 1 - Thrust Reverser, Left
416	Engine 1 - Thrust Reverser, Right
425	Engine 2 - Thrust Reverser, Left
426	Engine 2 - Thrust Reverser, Right

B. Access Panels

Number	Name/Location
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

C. Inspection

SUBTASK 54-05-02-010-021

- (1) Open these access panels for Engine No. 1:

Number	Name/Location
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1

Open these access panels for Engine No. 2:

Number	Name/Location
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

NOTE: Inspection requires the removal and thorough cleaning of the evener bar.

SUBTASK 54-05-02-230-003

- (2) Do a Penetrant inspection of the entire aft engine mount evener bar.

See Doc. D626A001-DTR, DTR check form 54-55-11b, for alternative inspections.

SUBTASK 54-05-02-410-021

- (3) Close these access panels for Engine No. 1:

Number	Name/Location
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1

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<u>Number</u>	<u>Name/Location</u>
416	Right Thrust Reverser, Engine 1

Close these access panels for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

— END OF TASK —

TASK 54-05-02-700-801

40. INTERNAL - SPECIAL DETAILED: STRUT ATTACH BOLTS (FORWARD AND AFT MOUNTS)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
413	Engine 1 - Fan Cowl, Left
414	Engine 1 - Fan Cowl, Right
415	Engine 1 - Thrust Reverser, Left
416	Engine 1 - Thrust Reverser, Right
423	Engine 2 - Fan Cowl, Left
424	Engine 2 - Fan Cowl, Right
425	Engine 2 - Thrust Reverser, Left
426	Engine 2 - Thrust Reverser, Right

B. Access Panels

<u>Number</u>	<u>Name/Location</u>
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

C. Inspection

SUBTASK 54-05-02-010-042

- (1) Open these access panels for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1

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Open these access panels for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

SUBTASK 54-05-02-700-001

- (2) Do a Torque Check of all strut attach bolts on the forward and aft mounts.

See Doc. D626A001-DTR, DTR check form 54-55-13, for alternative inspections.

SUBTASK 54-05-02-410-042

- (3) Close these access panels for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1

Open these access panels for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

————— END OF TASK ————

TASK 54-05-02-230-804

41. INTERNAL - SPECIAL DETAILED: STRUT ATTACH BOLTS (FORWARD AND AFT MOUNTS)

NOTE: This procedure is a scheduled maintenance task.

A. Location Zones

<u>Zone</u>	<u>Area</u>
413	Engine 1 - Fan Cowl, Left
414	Engine 1 - Fan Cowl, Right
415	Engine 1 - Thrust Reverser, Left
416	Engine 1 - Thrust Reverser, Right
423	Engine 2 - Fan Cowl, Left
424	Engine 2 - Fan Cowl, Right
425	Engine 2 - Thrust Reverser, Left
426	Engine 2 - Thrust Reverser, Right

B. Access Panels

<u>Number</u>	<u>Name/Location</u>
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1
423	Left Fan Cowl, Engine 2



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<u>Number</u>	<u>Name/Location</u>
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

C. Inspection

SUBTASK 54-05-02-010-017

- (1) Open these access panels for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1

Open these access panels for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

NOTE: Removal of engine and engine mounts is required.

SUBTASK 54-05-02-230-004

- (2) Do a Penetrant inspection of the strut attach bolts on the forward and aft mounts.

See Doc. D626A001-DTR, DTR check form 54-55-13 for alternative repeat inspection.

SUBTASK 54-05-02-410-017

- (3) Close these access panels for Engine No. 1:

<u>Number</u>	<u>Name/Location</u>
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
415	Left Thrust Reverser, Engine 1
416	Right Thrust Reverser, Engine 1

Close these access panels for Engine No. 2:

<u>Number</u>	<u>Name/Location</u>
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
425	Left Thrust Reverser, Engine 2
426	Right Thrust Reverser, Engine 2

———— END OF TASK ————



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NACELLE STRUT - MAINTENANCE PRACTICES

1. General

- A. This procedure has these tasks:
- (1) Prepare the strut for maintenance operations.
 - (2) Put the strut back to its usual condition.
 - (3) Support the strut with the engine installed.
 - (4) Remove support from the strut with the engine installed.
 - (5) Support the strut with the engine removed.
 - (6) Remove support from the strut with the engine removed.

TASK 54-51-01-040-801

2. Prepare the Strut for Maintenance Operations

A. General

- (1) This task prepares the strut for maintenance operations. Always do this task when you do maintenance operations on or near the nacelle strut.
- (2) This task has these steps:
 - (a) Make the airplane statically grounded.
 - (b) Deactivate the leading edge flaps and slats.
 - (c) Deactivate the thrust reversers.

B. References

Reference	Title
20-40-11-910-801	Static Grounding (P/B 201)
27-81-00-040-801	Leading Edge Flaps and Slats Deactivation (P/B 201)
78-31-00-040-802-F00	Thrust Reverser Deactivation For Ground Maintenance (P/B 201)

C. Location Zones

Zone	Area
410	Subzone - Engine 1
420	Subzone - Engine 2
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

D. Prepare the Strut for Maintenance Operations

SUBTASK 54-51-01-910-001

- (1) Do this task: Static Grounding, TASK 20-40-11-910-801.

SUBTASK 54-51-01-040-001



WARNING

MAKE SURE THAT ALL PERSONS AND EQUIPMENT ARE CLEAR OF THE LE FLAPS, TE FLAPS, AND FLAP DRIVE MECHANISMS BEFORE YOU MOVE THE FLAP CONTROL LEVER. WITH HYDRAULIC POWER REMOVED, THE FLAPS WILL MOVE AUTOMATICALLY BY ELECTRICAL POWER WHEN YOU MOVE THE FLAP CONTROL LEVER. THIS CAN CAUSE INJURIES TO PERSONS AND DAMAGE TO EQUIPMENT.

- (2) Do this task: Leading Edge Flaps and Slats Deactivation, TASK 27-81-00-040-801.

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SUBTASK 54-51-01-040-002



WARNING

DO THE DEACTIVATION PROCEDURE TO PREVENT THE OPERATION OF THE THRUST REVERSER. THE ACCIDENTAL OPERATION OF THE THRUST REVERSER CAN CAUSE INJURIES TO PERSONS AND DAMAGE TO EQUIPMENT.

- (3) To deactivate the thrust reversers, do this task: Thrust Reverser Deactivation For Ground Maintenance, TASK 78-31-00-040-802-F00.

———— END OF TASK ——

TASK 54-51-01-440-801

3. Put the Strut Back to its Usual Condition

A. General

- (1) This task puts the strut back to its usual condition after maintenance operations. Always do this task when all maintenance operations on the nacelle strut are complete.
- (2) This task has these steps:
- Activate the thrust reversers.
 - Activate the leading edge flaps and slats.
 - Remove the static ground from the airplane.

B. References

Reference	Title
27-81-00-440-801	Leading Edge Flaps and Slats - Activation (P/B 201)
78-31-00-440-803-F00	Thrust Reverser Activation After Ground Maintenance (P/B 201)

C. Location Zones

Zone	Area
410	Subzone - Engine 1
420	Subzone - Engine 2
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

D. Put the Strut Back to its Usual Condition

SUBTASK 54-51-01-440-001

- (1) Do this task: Thrust Reverser Activation After Ground Maintenance, TASK 78-31-00-440-803-F00.

SUBTASK 54-51-01-440-002

- (2) Do this task: Leading Edge Flaps and Slats - Activation, TASK 27-81-00-440-801.

SUBTASK 54-51-01-910-002

- (3) If all maintenance operations are complete, remove the static ground from the airplane.

———— END OF TASK ——

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TASK 54-51-01-580-801

4. Support the Strut with the Engine Installed

A. General

- (1) When you remove a strut attach pin, use this procedure to remove the load from the strut pin.
- (2) This task has these steps:
 - (a) Prepare the strut for maintenance operations.
 - (b) Remove the fan cowl panels.
 - (c) Remove the thrust reverser panels.
 - (d) Install the engine support sling.
 - (e) Carefully lift the engine to remove the load from the pin (that you will remove).

B. References

Reference	Title
71-11-02-000-801-F00	Fan Cowl Panel Removal (Selection) (P/B 401)
78-31-00-010-804-F00	Close the Thrust Reverser (Selection) (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-2024	Sling - Equipment, Strut Fuse Pin Removal/Installation Part #: C54010-29 Supplier: 81205 Opt Part #: C54010-26 Supplier: 81205

D. Location Zones

Zone	Area
410	Subzone - Engine 1
420	Subzone - Engine 2
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

E. Prepare to Support the Engine

SUBTASK 54-51-01-040-003

- (1) Do this task: Prepare the Strut for Maintenance Operations, TASK 54-51-01-040-801.

SUBTASK 54-51-01-010-001

- (2) Do this task: Fan Cowl Panel Removal (Selection), TASK 71-11-02-000-801-F00.

SUBTASK 54-51-01-010-003

- (3) Do this task: Close the Thrust Reverser (Selection), TASK 78-31-00-010-804-F00.





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F. Install the Strut Support Sling

SUBTASK 54-51-01-480-003



THRUST REVERSERS MUST BE IN THE CLOSED POSITION WHEN USING EQUIPMENT. DAMAGE TO EQUIPMENT CAN OCCUR.

- (1) Install the engine fitting assemblies on the engine fan case.

NOTE: The latches on the thrust reversers do not need to be in the closed position.

NOTE: The fittings are at approximately NAC STA 195, at the 10 o'clock and 2 o'clock positions.

- (a) Attach the sling, SPL-2024 to an overhead lifting device with a minimum capacity of 10,000 pounds (4,536 kg).
- (b) Attach the chain hoists, dynamometers, and C-beams, to the sling assembly.



USE TETHER LINES AS THE SLING ASSEMBLY IS POSITIONED ABOVE THE ENGINE AND LOWERED. THE C-BEAMS CAN CAUSE DAMAGE TO THE ENGINE OR THE STRUT.

- (c) Put the sling assembly above the engine.
- (d) Attach the C-beams to the engine fittings at approximately NAC STA 195.
- (e) Use the chain hoists to put the chain in tension.

G. Remove the Load from the Strut Pin

SUBTASK 54-51-01-580-001



CAUTION

DO NOT LIFT THE ENGINE WITH A FORCE WHICH IS MORE THAN NECESSARY TO PERMIT THE PIN TO TURN WHEN YOU APPLY 125 POUND-INCHES (14.1 NEWTON-METERS) MAXIMUM TORQUE. DO NOT APPLY A TOTAL LOAD OF MORE THAN 10,000 POUNDS OR 4,536 KILOGRAMS (MORE THAN THE WEIGHT OF THE EQUIPMENT). DO NOT APPLY A LOAD OF MORE THAN 6,500 POUNDS OR 2,948 KILOGRAMS AT ONE ATTACH POINT. DO NOT APPLY A LOAD WITH A DIFFERENCE BETWEEN THE TWO SIDES OF MORE THAN 3,000 POUNDS OR 1,360 KILOGRAMS. LIFT THE ENGINE VERTICALLY ALONG THE CENTERLINE OF THE ENGINE AND THE STRUT. THIS CENTERLINE IS NOT A 90 DEGREE ANGLE FROM THE GROUND FLOOR. THERE IS A SIX DEGREE WING DIHEDRAL. IF YOU LIFT THE ENGINE WITH TOO MUCH FORCE, OR A FORE/AFT ANGLE OF MORE THAN FIVE DEGREES, DAMAGE TO THE ENGINE AND/OR STRUT CAN OCCUR.

- (1) Do these steps to remove the load from the pin (that you will remove):

- (a) Slowly increase the load until you can turn the pin (that you will remove) with a maximum torque of 125 pound-inches (14.1 Nm).

NOTE: If the fuse pin does not turn before the maximum allowable load is applied, it may be necessary to decrease the load on the inboard side then increase the load on the outboard side to free the pin.

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- (b) Make sure the load on the engine support sling is kept the same until you install the pin again.

———— END OF TASK ————

TASK 54-51-01-580-802

5. Remove Support from the Strut with the Engine Installed

A. General

- (1) This task has these steps:
- Remove the load from the engine support sling.
 - Remove the engine support sling.
 - Put the airplane back to its usual condition.

B. References

Reference	Title
71-11-02-400-801-F00	Fan Cowl Panel Installation (Selection) (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-2024	Sling - Equipment, Strut Fuse Pin Removal/Installation Part #: C54010-29 Supplier: 81205 Opt Part #: C54010-26 Supplier: 81205

D. Location Zones

Zone	Area
410	Subzone - Engine 1
420	Subzone - Engine 2
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

E. Remove the Support from the Engine

SUBTASK 54-51-01-210-001



CAUTION DO NOT REMOVE THE LOAD ON THE ENGINE SUPPORT SLING UNTIL THE WORKSTANDS ARE CLEAR. IF YOU DO NOT REMOVE THE WORKSTANDS, DAMAGE TO THE STRUT, WING STRUCTURE, OR WORKSTANDS CAN OCCUR.

- (1) Make sure the workstands are clear of the airplane.

SUBTASK 54-51-01-580-002

- (2) Slowly remove the load from the sling, SPL-2024.

SUBTASK 54-51-01-080-001

- (3) Remove the sling from the engine.

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F. Put the Airplane Back to its Usual Condition

SUBTASK 54-51-01-410-002

- (1) Install the fan cowl panels, do this task: Fan Cowl Panel Installation (Selection), TASK 71-11-02-400-801-F00.

SUBTASK 54-51-01-440-003

- (2) If all maintenance operations on the strut are complete, do this task: Put the Strut Back to its Usual Condition, TASK 54-51-01-440-801.

———— END OF TASK ————

TASK 54-51-01-580-803

6. Support the Strut with the Engine Removed

A. General

- (1) When you remove a strut attach pin, use this procedure to remove the load from the strut pin.
- (2) This task has these steps:
 - (a) Prepare the strut for maintenance operations.
 - (b) Remove the engine.
 - (c) Install the strut support sling.
 - (d) Carefully lift the strut to remove the load from the pin (that you will remove).

B. References

Reference	Title
71-00-02-000-801-F00	Power Plant - Removal (P/B 401)

C. Tools/Equipment

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

Reference	Description
SPL-6248	Tool - Removal/Installation, Engine Strut Part #: C54011-59 Supplier: 81205

D. Location Zones

Zone	Area
410	Subzone - Engine 1
420	Subzone - Engine 2
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

E. Prepare to Support the Strut

SUBTASK 54-51-01-040-004

- (1) Do this task: Prepare the Strut for Maintenance Operations, TASK 54-51-01-040-801.

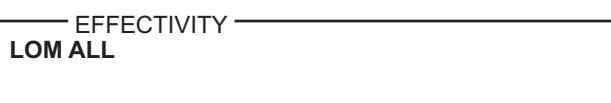
SUBTASK 54-51-01-000-001

- (2) Do this task: Power Plant - Removal, TASK 71-00-02-000-801-F00.

SUBTASK 54-51-01-480-002

- (3) Install the sling, engine strut tool, SPL-6248, to support the strut.

- (a) Find the aft mount bulkhead and do these steps:



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- 1) Find Ground Support Equipment (GSE) attach point behind the aft mount bulkhead and pin aft beam assembly in place with the ball lock pins.
 - 2) The center beam assembly holes will face forward.
 - 3) Put the pin in the forward beam where lynch pins will secure the pin.
- (b) Put brace beam into sling aft beam assembly.
- 1) Put the shaft through the keyhole slot.
 - 2) Rotate ninety degrees until brace beam engages sling forward beam.
 - 3) Pin into place and secure with lynch pins.
- (c) On the outboard side of the strut, pin the center beam assembly at the forward fitting, and secure with lynch pins.
- (d) Attach chain hoists to sling bridal.
- (e) Attach sling bridal to overhead hoist.
- (f) Position sling assembly over strut and attach to center beam assembly.
- (g) Use hoist to lift strut and position strut to neccessary dihedral of wing.

F. Remove the Load from the Strut Pin

SUBTASK 54-51-01-580-003



CAUTION

DO NOT EXCEED THE UPLOAD OR DOWNLOAD NECESSARY TO PERMIT THE PIN TO TURN WHEN YOU APPLY 125 POUND-INCHES (14.1 NEWTON-METERS) MAXIMUM TORQUE. DO NOT LIFT THE STRUT OR PULL DOWN ON THE STRUT WITH MORE THAN 2,000 POUNDS (907 KILOGRAMS) OF FORCE. APPLY THE LOAD VERTICALLY. IF YOU LIFT UP OR PULL DOWN ON THE STRUT WITH TOO MUCH FORCE, OR AT AN INCORRECT ANGLE, DAMAGE TO THE AIRPLANE CAN OCCUR.

- (1) Do these steps to remove the load from the pin (that you will remove):
 - (a) Slowly increase the load until you can turn the pin (that you will remove) with a maximum torque of 125 pound-inches (14.1 Nm).
 - (b) Make sure the load on the strut sling is kept the same until you install the pin again.

———— END OF TASK ————

TASK 54-51-01-580-804

7. Remove Support from the Strut with the Engine Removed

A. General

- (1) This task has these steps:
 - (a) Remove the load from the strut support sling.
 - (b) Remove the strut support sling.
 - (c) Install the engine.
 - (d) Put the airplane back to its usual condition.

B. References

Reference	Title
71-00-02-400-801-F00	Power Plant - Installation (P/B 401)

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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-6248	Tool - Removal/Installation, Engine Strut Part #: C54011-59 Supplier: 81205

D. Location Zones

Zone	Area
410	Subzone - Engine 1
420	Subzone - Engine 2
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

E. Remove the Support from the Strut

SUBTASK 54-51-01-210-002



CAUTION
DO NOT REMOVE THE LOAD ON THE STRUT SUPPORT SLING UNTIL THE WORKSTANDS ARE CLEAR. IF YOU DO NOT REMOVE THE WORKSTANDS, DAMAGE TO THE STRUT, WING STRUCTURE, OR WORKSTANDS CAN OCCUR.

- (1) Make sure the workstands are clear of the airplane.

SUBTASK 54-51-01-580-004

- (2) Slowly remove the load from the sling, engine strut tool, SPL-6248.

SUBTASK 54-51-01-080-002

- (3) Remove the sling from the strut.
 - (a) Remove the C-beam assembly from the sling assembly and the A-beam assembly.
 - (b) Remove the A-beam assembly from the engine strut.

F. Put the Airplane Back to its Usual Condition

SUBTASK 54-51-01-400-001

- (1) Do this task: Power Plant - Installation, TASK 71-00-02-400-801-F00.

SUBTASK 54-51-01-440-004

- (2) If all maintenance operations on the strut are complete, do this task: Put the Strut Back to its Usual Condition, TASK 54-51-01-440-801.

— END OF TASK —



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NACELLE STRUT - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) A removal of the nacelle strut.
 - (2) An installation of the nacelle strut.

TASK 54-51-01-000-801

2. Nacelle Strut Removal

A. General

- (1) This task has these steps:
- (a) Prepare for the removal.
 - (b) Remove the power plant.
 - (c) Disconnect the strut systems.
 - (d) Remove the strut.

B. References

Reference	Title
24-22-00-860-812	Remove Electrical Power (P/B 201)
29-09-00-860-802	Hydraulic Reservoirs Depressurization (P/B 201)
36-00-00-860-806	Remove Pressure from the Pneumatic System (P/B 201)
36-13-01-000-803	Wing Leading Edge Duct Removal (P/B 401)
54-51-01-040-801	Prepare the Strut for Maintenance Operations (P/B 201)
54-51-01-580-803	Support the Strut with the Engine Removed (P/B 201)
54-51-02-000-803	Remove the Midspar Fuse Pin (P/B 401)
54-51-03-000-802	Upper Link Fuse Pin Removal (P/B 401)
54-51-04-000-801	Diagonal Brace Removal (P/B 401)
54-51-05-000-802	Lower Shoulder Bolt Removal (P/B 401)
54-52-03-010-801	Wing Junction Fairing - Removal (P/B 401)
54-52-04-010-801	Aft Fairing Removal (Engine Removed) (P/B 401)
54-52-09-000-801	Leading Edge Gap Covers Removal (P/B 401)
71-00-02-000-801-F00	Power Plant - Removal (P/B 401)
78-31-01-000-801-F00	Thrust Reverser Removal (P/B 401)

C. Location Zones

Zone	Area
410	Subzone - Engine 1
420	Subzone - Engine 2
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

D. Access Panels

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



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Number	Name/Location
431DR	Forward Strut Fairing, Right Underwing Fairing, Strut 1
441CL	Forward Strut Fairing, Left Overwing Fairing, Strut 2
441CR	Forward Strut Fairing, Right Overwing Fairing, Strut 2
441DL	Forward Strut Fairing, Left Underwing Fairing, Strut 2
441DR	Forward Strut Fairing, Right Underwing Fairing, Strut 2
511BT	Fairing
521AT	Outbd Leading Edge - Gap Cover Access
611BT	Fairing
621AT	Outbd Leading Edge - Gap Cover Access

E. Prepare for the Removal

SUBTASK 54-51-01-040-007

- (1) Do this task: Prepare the Strut for Maintenance Operations, TASK 54-51-01-040-801.

SUBTASK 54-51-01-010-004

- (2) Open these access panels:

Wing Junction Fairing - Removal, 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
431DL	Forward Strut Fairing, Left Underwing Fairing, Strut 1
431DR	Forward Strut Fairing, Right Underwing Fairing, Strut 1
441CL	Forward Strut Fairing, Left Overwing Fairing, Strut 2
441CR	Forward Strut Fairing, Right Overwing Fairing, Strut 2
441DL	Forward Strut Fairing, Left Underwing Fairing, Strut 2
441DR	Forward Strut Fairing, Right Underwing Fairing, Strut 2

SUBTASK 54-51-01-010-011

- (3) Open these access panels:

Leading Edge Gap Covers Removal, TASK 54-52-09-000-801

Number **Name/Location**

511BT	Fairing
521AT	Outbd Leading Edge - Gap Cover Access
611BT	Fairing
621AT	Outbd Leading Edge - Gap Cover Access

SUBTASK 54-51-01-010-005

- (4) Do this task: Thrust Reverser Removal, TASK 78-31-01-000-801-F00.

F. Power Plant Removal

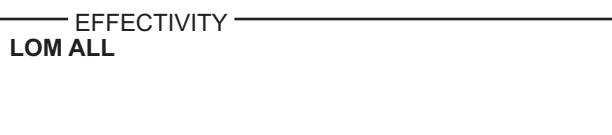
SUBTASK 54-51-01-000-002

- (1) Do this task: Power Plant - Removal, TASK 71-00-02-000-801-F00.

G. Strut Systems Disconnection

SUBTASK 54-51-01-040-008

- (1) Make sure the Pneumatic System has been depressurized, do this task: Remove Pressure from the Pneumatic System, TASK 36-00-00-860-806.



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SUBTASK 54-51-01-000-003

- (2) Remove the pneumatic duct [1] or pneumatic duct [2] between the wing and the strut, do this task: Wing Leading Edge Duct Removal, TASK 36-13-01-000-803.
 - (a) Remove the coupling [5] and coupling [6] (Figure 401).
 - (b) Carefully remove the applicable pneumatic duct [1] or pneumatic duct [2] and seal [7].

SUBTASK 54-51-01-000-004

- (3) To remove the wing thermal anti-ice duct [3] or wing thermal ant-ice duct [4] between the wing and the strut, do these steps (Figure 401):
 - (a) Remove the two coupling [8] and coupling [9] at either end of the duct.
 - (b) Carefully remove the wing thermal anti-ice duct [3] or wing thermal ant-ice duct [4] and seal [10].

SUBTASK 54-51-01-040-009

- (4) Make sure that electrical power has been removed, do this task: Remove Electrical Power, TASK 24-22-00-860-812.

NOTE: The removal of electrical power is necessary to disconnect the electrical connectors.

SUBTASK 54-51-01-020-001



CAUTION

MAKE SURE THAT THE ELECTRICAL CONNECTORS AND RECEPTACLES ARE CLEAN AND CLEAR OF UNWANTED MATERIALS BEFORE YOU DISCONNECT, OR CONNECT THEM. CONTAMINATION OF THE ELECTRICAL CONNECTORS AND RECEPTACLES CAN CAUSE DAMAGE TO EQUIPMENT.



CAUTION

BE CAREFUL WITH THE POWER FEEDER CABLES. DO NOT BEND OR PUT THE CABLES INTO COILS TOO TIGHTLY. IF YOU DO NOT OBEY THESE INSTRUCTIONS, YOU CAN CAUSE DAMAGE TO THE CABLES.

- (5) Disconnect the IDG power feeder cable and the strut wire bundles at the wing forward spar disconnect panel as follows:
 - (a) Put a tag on the wire bundles at the AW0258L (left strut) or AW0258R (right strut) Disconnect Panel to identify their positions for installation (Figure 402).
 - (b) Disconnect the IDG power feeder and wire bundles at the wing forward spar disconnect panel.
 - (c) Install the caps on the connectors and the receptacles.
 - (d) Attach the IDG power feeder cable and the wire bundle ends to the top of the strut for temporary storage.

SUBTASK 54-51-01-040-010

- (6) Prepare the hydraulic system for strut removal:
 - (a) For removal of the left strut (Engine 1), depressurize the system "A" and "B" hydraulic reservoirs, do this task: Hydraulic Reservoirs Depressurization, TASK 29-09-00-860-802.
 - (b) For removal of the right strut (Engine 2), depressurize the system "B" hydraulic reservoir, do this task: Hydraulic Reservoirs Depressurization, TASK 29-09-00-860-802.

SUBTASK 54-51-01-020-002

- (7) Remove the thrust reverser hydraulic tubes that are on the applicable strut, (Figure 403):
 - (a) Disconnect the two thrust reverser hydraulic tubes at the "Disconnect Panel".

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- 1) On the left strut, disconnect the hydraulic tube [27] and hydraulic tube [28].
 - 2) On the right strut, disconnect the hydraulic tube [41] and hydraulic tube [44].
- (b) Remove the support clamps attached to the middle of the hydraulic tubes for the applicable strut:
- 1) On the left strut, remove the clamp band [21], the clamp shell [22], the clamp band [25], the clamp shell [26], the screws [23], and the washers [24] that hold the thrust reverser hydraulic tubes.
 - 2) On the right strut, remove the clamp assembly [42], the screws [43], the washers [24], the clamp assembly [45], the screws [43], the washers [24] that hold the thrust reverser hydraulic tubes.
- (c) Disconnect the hydraulic tubing at the forward end.
- (d) Remove the two pieces of hydraulic tubing:
- 1) On the left strut, remove the hydraulic tube [27] and hydraulic tube [28].
 - 2) On the right strut, remove the hydraulic tube [41] and hydraulic tube [44].
- (e) Keep the two pieces of hydraulic tubing in storage until installation.

SUBTASK 54-51-01-680-001



WARNING

BE CAREFUL WHEN YOU DISCONNECT THE FUEL LINE. A SMALL AMOUNT OF FUEL CAN COLLECT IN THE FUEL LINE. MOVE TO A POSITION WHERE FUEL CANNOT GET ON YOU. IF FUEL GETS ON YOU, INJURY CAN OCCUR.

- (8) Disconnect the aft end of the fuel hose from the wing by the following steps (Figure 403):
- (a) Remove the clamp assembly that holds the fuel hose to the strut.
 - 1) On the left strut, remove the screw [30], the washers [24], and the clamp [29].
 - 2) On the right strut, remove the screw [30], the washers [24], and the clamp [29].
 - (b) Disconnect the aft end of the fuel hose that goes into the wing.
 - (c) Temporarily attach the loose end of the fuel hose to the strut.

SUBTASK 54-51-01-000-005

- (9) Remove the screw [31], the washers [33], the split washer [32], and the nut [34] which attach the bonding jumper to the wing.

NOTE: Keep the end of the bonding jumper clean.

SUBTASK 54-51-01-010-006

- (10) Do this task: Aft Fairing Removal (Engine Removed), TASK 54-52-04-010-801.

SUBTASK 54-51-01-010-007

- (11) Remove the four pieces of tubing that go aft through the vapor barrier of the strut (Figure 403):
- (a) Disconnect the four tubing connections on the forward side of the vapor barrier as shown (Figure 403).
 - 1) On the left strut, disconnect the forward end of the hydraulic tube [37], hydraulic tube [38], hydraulic tube [40], and the fire extinguishing tube [36].
 - 2) On the right strut, disconnect the forward end of the hydraulic tube [47], hydraulic tube [48], hydraulic tube [49], and the fire extinguishing tube [46].
 - (b) Remove the clamp block [35] and clamp block [39] on the forward side of the vapor barrier (Figure 403).

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- (c) At the aft end of the strut, disconnect the four tubes at the connections (Figure 404).
NOTE: These connections are forward of the clamp block that holds all four of the tubes.
- (d) Disassemble the top half of the clamp block that is adjacent to the side links (Figure 404).
NOTE: This allows removal of two hydraulic tube pieces.
- (e) Remove the four pieces of tubing:
 - 1) On the left strut: the hydraulic tube [37], hydraulic tube [38], hydraulic tube [40], and the fire extinguishing tube [36].
 - 2) On the right strut: the hydraulic tube [47], hydraulic tube [48], hydraulic tube [49], and the fire extinguishing tube [46].
- (f) Keep the three hydraulic tubes and the fire extinguishing tube in storage until installation of the strut.
- (g) Reassemble the clamp block that is between the lower bolts of the side links.
NOTE: Do this for support of the strut drain tubing and to keep parts.

H. Remove the Nacelle Strut

SUBTASK 54-51-01-000-006

- (1) Do this task: Diagonal Brace Removal, TASK 54-51-04-000-801.

SUBTASK 54-51-01-000-007

- (2) To remove the lower bolt from the two side link assemblies, do this task: Lower Shoulder Bolt Removal, TASK 54-51-05-000-802.

NOTE: It is not necessary to remove the side links from the under wing fitting.

- (a) Use some tape to temporarily attach the lower end of the side links to the bottom of the wing.

SUBTASK 54-51-01-480-004

- (3) Do this task: Support the Strut with the Engine Removed, TASK 54-51-01-580-803.

SUBTASK 54-51-01-000-008

- (4) Do this task: Upper Link Fuse Pin Removal, TASK 54-51-03-000-802.

- (a) Temporarily tie the upper link to the wing leading edge.

SUBTASK 54-51-01-000-009

- (5) To remove the two midspar fuse pins, do this task: Remove the Midspar Fuse Pin, TASK 54-51-02-000-803.

SUBTASK 54-51-01-580-005

- (6) Carefully, lower the strut with the strut removal sling.

———— END OF TASK ———

TASK 54-51-01-400-801

3. Nacelle Strut Installation

A. General

- (1) This task is the installation of the nacelle strut.
- (2) This task has these steps:
 - (a) Install the nacelle strut.
 - (b) Connect the strut systems.
 - (c) Install the power plant.

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- (d) Test the strut systems.
- (e) Put the airplane back to its usual condition.

B. References

Reference	Title
20-10-51-000-802	Flareless Fittings in Pressurized, Strut, Fuel Tank, and Cargo Areas Installation (P/B 401)
20-30-80-910-801	General Cleaning of Metal (Series 80) (P/B 201)
20-40-11-760-802	Measurement of Airplane Electrical Resistance to Ground (P/B 201)
24-11-00-700-802	Number 1 IDG - Operational Test (P/B 501)
24-11-00-700-803	Number 2 IDG - Operational Test (P/B 501)
24-22-00-860-812	Remove Electrical Power (P/B 201)
26-11-00-730-802	Engine Fire Detection Circuit - System Test (P/B 501)
26-21-00-720-801	Engine Fire Extinguishing Discharge Line Flow Test (P/B 501)
26-21-00-730-803	Engine Fire Extinguishing Discharge Line Pressure Test (P/B 501)
29-11-00-700-801	Operational Test of the Hydraulic Systems A and B (P/B 501)
29-11-00-860-801	Hydraulic System A or B Pressurization (P/B 201)
30-21-00-710-801	Engine Cowl Anti-Icing - Operational Test (P/B 501)
36-11-00-710-801	Engine Bleed Air Crossover Operational Test (P/B 501)
36-13-01-400-801	Wing Leading Edge Duct Installation (P/B 401)
54-51-01-440-801	Put the Strut Back to its Usual Condition (P/B 201)
54-51-02-400-803	Install the Midspar Fuse Pin (P/B 401)
54-51-03-400-802	Upper Link Fuse Pin Installation (P/B 401)
54-51-04-400-801	Diagonal Brace Installation (P/B 401)
54-51-05-400-803	Lower Shoulder Bolt Installation (P/B 401)
54-52-03-410-801	Wing Junction Fairing - Installation (P/B 401)
54-52-04-410-801	Aft Fairing Installation (Engine Removed) (P/B 401)
54-52-09-400-801	Leading Edge Gap Cover Installation (P/B 401)
71-00-00-700-801-F00	Test 3A - Idle-Power Leak Check (P/B 501)
71-00-02-400-801-F00	Power Plant - Installation (P/B 401)
71-11-02-400-801-F00	Fan Cowl Panel Installation (Selection) (P/B 401)
73-21-00-700-802-F00	FADEC System Test (P/B 501)
78-31-01-400-801-F00	Thrust Reverser Installation (P/B 401)
SWPM 20-20-00	ELECTRICAL BONDING PROCESSES
SWPM 20-60-01	Cleaning of Electrical Connectors
SWPM 20-60-06	Standard Wiring Practices Manual

C. Tools/Equipment

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

Reference	Description
SPL-6248	Tool - Removal/Installation, Engine Strut Part #: C54011-59 Supplier: 81205



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D. Consumable Materials

Reference	Description	Specification
A00160	Sealant - Firewall - Hydraulic Fluid Resistant	BMS5-63
A00767	Sealant - Fuel Tank	BMS5-45

E. Location Zones

Zone	Area
410	Subzone - Engine 1
420	Subzone - Engine 2
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

F. Access Panels

Number	Name/Location
431CL	Forward Strut Fairing, Left Overwing Fairing, Strut 1
431CR	Forward Strut Fairing, Right Overwing Fairing, Strut 1
431DL	Forward Strut Fairing, Left Underwing Fairing, Strut 1
431DR	Forward Strut Fairing, Right Underwing Fairing, Strut 1
441CL	Forward Strut Fairing, Left Overwing Fairing, Strut 2
441CR	Forward Strut Fairing, Right Overwing Fairing, Strut 2
441DL	Forward Strut Fairing, Left Underwing Fairing, Strut 2
441DR	Forward Strut Fairing, Right Underwing Fairing, Strut 2
511BT	Fairing
521AT	Outbd Leading Edge - Gap Cover Access
611BT	Fairing
621AT	Outbd Leading Edge - Gap Cover Access

G. Install the Nacelle Strut

SUBTASK 54-51-01-210-003

- (1) Make sure that the upper link is installed as follows:
 - (a) Make sure the aft pin is installed in the upper link.
 - (b) Make sure that the upper link is temporarily tied to the wing leading edge.

SUBTASK 54-51-01-210-004

- (2) If the side links are installed, make sure that they are temporarily attached to the bottom of the wing with some tape.

SUBTASK 54-51-01-500-001

- (3) Carefully, lift the strut to the wing with the strut installation sling, engine strut tool, SPL-6248.

SUBTASK 54-51-01-400-002

- (4) To install the two midspar fuse pins, do this task: Install the Midspar Fuse Pin, TASK 54-51-02-400-803.

SUBTASK 54-51-01-400-003

- (5) Do this task: Upper Link Fuse Pin Installation, TASK 54-51-03-400-802.

SUBTASK 54-51-01-080-003

- (6) Remove the strut installation sling, engine strut tool, SPL-6248.

SUBTASK 54-51-01-400-004

- (7) To install the lower bolts in the side links, do this task: Lower Shoulder Bolt Installation, TASK 54-51-05-400-803

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SUBTASK 54-51-01-400-005

- (8) Do this task: Diagonal Brace Installation, TASK 54-51-04-400-801.

H. Connect the Strut Systems

SUBTASK 54-51-01-360-001

- (1) Make sure all hydraulic connections are secure and there are no leaks.
- (a) If leaks are found, do this task: Flareless Fittings in Pressurized, Strut, Fuel Tank, and Cargo Areas Installation, TASK 20-10-51-000-802.

SUBTASK 54-51-01-400-006

- (2) Install the strut bonding jumper to the wing, (SWPM 20-20-00).
- (a) Apply a solvent, see, do this task: General Cleaning of Metal (Series 80), TASK 20-30-80-910-801
to remove any grease, oil, corrosion inhibiting compound (CIC), or other compounds.
- (b) Install the screw [31], the washers [33], the split washer [32], and the nut [34] which attach the bonding jumper to the wing, (Figure 403).
NOTE: The split washer [31] is installed under the screw head, while the washers [33] are installed on either side of the wing structure.
- (c) Apply sealant, A00160 to the area of the bonding contact.
- (d) Make sure that the maximum resistance is 0.001 ohms or less, do this task: Measurement of Airplane Electrical Resistance to Ground, TASK 20-40-11-760-802.

SUBTASK 54-51-01-010-008

- (3) Install the four pieces of tubing that go through the vapor barrier of the strut, (Figure 404):
NOTE: On the left strut: the hydraulic tube [37], hydraulic tube [38], hydraulic tube [40], and fire extinguishing tube [36].
NOTE: On the right strut: the hydraulic tube [47], hydraulic tube [48], hydraulic tube [49], and fire extinguishing tube [46].

- (a) Disassemble the top half of the clamp block that is between the lower bolts of the side links.
NOTE: This clamp block will be without two pieces of tubing.
- (b) On the left strut, assemble the clamp block [35] and clamp block [39] with the hydraulic tube [37] and hydraulic tube [38].
1) Tighten the bolts to 50 in-lb (6 N·m) to 75 in-lb (8 N·m).
- (c) On the right strut, assemble the clamp block [35] and clamp block [39] with the hydraulic tube [47] and hydraulic tube [48].
1) Tighten the two bolts to 50 in-lb (6 N·m) to 75 in-lb (8 N·m).
- (d) Install the aft end of the four tube pieces to the applicable connections on the underside of the wing as follows:

- NOTE: These connections are forward of the clamp block that holds all four of the tubes.
- 1) Tighten the 1 in. (25 mm) diameter connection to 750 in-lb (85 N·m).
NOTE: On the left strut, this tube is the hydraulic supply tube [38].
NOTE: On the right strut, this tube is the hydraulic supply tube [48].

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- 2) Tighten the 0.75 in. (19.05 mm) diameter connection to 900 in-lb (102 N·m).

NOTE: On the left strut, this tube is the hydraulic tube [40].

NOTE: On the right strut, this tube is the hydraulic tube [49].

- 3) Tighten the 0.625 in. (15.875 mm) diameter connection to 360 in-lb (41 N·m).

NOTE: On the left strut, this tube is the fire extinguishing tube [36].

NOTE: On the right strut, this tube is the fire extinguishing tube [46].

- 4) Tighten the 0.375 in. (9.525 mm) diameter connection to 170 in-lb (19 N·m).

NOTE: On the left strut, this tube is the hydraulic tube [37].

NOTE: On the right strut, this tube is the hydraulic tube [47].

- (e) Connect the four tubing connections on the forward side of the vapor barrier, (Figure 403) as follows:

NOTE: These four connections are aft of where the thrust reverser stow/deploy hydraulic tubing are installed, above access panel 433DT/443DT.

- 1) For the 1.0 in. (25 mm) tube:

NOTE: On the left strut, this tube is the hydraulic supply tube [38].

NOTE: On the right strut, this tube is the hydraulic supply tube [48].

- a) Tighten the connection to 750 in-lb (85 N·m).

- b) Loosen the connection to release the torque.

- c) Again, tighten the connection to 750 in-lb (85 N·m).

- d) Apply a yellow torque stripe on the connection.

- 2) For the 0.75 in. (19.05 mm) tube:

NOTE: On the left strut, this tube is the hydraulic tube [40].

NOTE: On the right strut, this tube is the hydraulic tube [49].

- a) Tighten the connection to 900 in-lb (102 N·m).

- b) Loosen the connection to release the torque.

- c) Again, tighten the connection to 900 in-lb (102 N·m).

- d) Apply a yellow torque stripe on the connection.

- 3) For the 0.625 in. (15.875 mm) tube:

NOTE: On the left strut, this tube is the fire extinguishing tube [36].

NOTE: On the right strut, this tube is the fire extinguishing tube [46].

- a) Tighten the connection to 360 in-lb (41 N·m).

- b) Loosen the connection to release the torque.

- c) Again, tighten the connection to 360 in-lb (41 N·m).

- d) Apply a yellow torque stripe on the connection.

- 4) For the 0.375 in. (9.525 mm) tube:

NOTE: On the left strut, this tube is the hydraulic tube [37].

NOTE: On the right strut, this tube is the hydraulic tube [47].

- a) Tighten the connection to 170 in-lb (19 N·m).

- b) Loosen the connection to release the torque.

- c) Again, tighten the connection to 170 in-lb (19 N·m).

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- d) Apply a yellow torque stripe on the connection.
- (f) Install the clamp block [35] and clamp block [39] on the forward side of the vapor barrier.
 - 1) Apply sealant, A00160 to the two clamp blocks.
 - 2) After inserting the tubes, tighten the bolts on the clamps.

SUBTASK 54-51-01-420-001

- (4) Do this task: Aft Fairing Installation (Engine Removed), TASK 54-52-04-410-801.

SUBTASK 54-51-01-680-002



WARNING

BE CAREFUL WHEN YOU RECONNECT THE FUEL LINE. A SMALL AMOUNT OF FUEL CAN COLLECT IN THE FUEL LINE. MOVE TO A POSITION WHERE FUEL CANNOT GET ON YOU. IF FUEL GETS ON YOU, INJURY CAN OCCUR.

- (5) Reconnect the fuel hose by the following steps, (Figure 403):

- (a) Position the fuel hose into its appropriate position.
- (b) Loosely install the clamp [29], screws [30], and washers [24] that hold the middle of the fuel hose.



CAUTION

MAKE SURE TO TIGHTEN THE FUEL LINE TO 750 IN-LB (85 N·m). DAMAGE TO THE EQUIPMENT MAY OCCUR THROUGH A FUEL LEAK.

- (c) Tighten the aft end connection of the fuel hose to 750 in-lb (85 N·m).
- (d) Loosen the torque on the connection to relieve tension in the hose.
- (e) Again, tighten the aft end connection of the fuel hose to 750 in-lb (85 N·m).
- (f) Install the screws [30], washers [24], and the clamp [29] that hold the middle of the fuel hose to the wing leading edge structure.
 - 1) Apply sealant, A00767 between the clamp and the mounting bracket.
 - 2) Tighten the screws [30] on the clamp.

SUBTASK 54-51-01-420-002

- (6) Install the thrust reverser hydraulic tubing, (Figure 403, Figure 404):

- (a) Connect the hydraulic tubes at the "Disconnect Panel" as follows:
 - 1) Tighten the forward end connection of the thrust reverser hydraulic tube [28] (left strut) or hydraulic tube [41] (right strut) to 500 in-lb (56 N·m).
 - a) Loosen the connection to release the torque.
 - b) Again, tighten the connection to 500 in-lb (56 N·m).
 - c) Apply a yellow torque stripe on the connection.
 - 2) Tighten the forward end connection of the thrust reverser hydraulic tube [27] (left strut) or hydraulic tube [44] to 700 in-lb (79 N·m).
 - a) Loosen the connection to release the torque.
 - b) Again, tighten the connection to 700 in-lb (79 N·m).
 - c) Apply a yellow torque stripe on the connection.
- (b) Connect the other two ends of the hydraulic tubes to the other connections near the forward upper link pin fitting on the strut as follows:

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- 1) Tighten the aft end connection of the thrust reverser hydraulic tube [28] (left strut) or hydraulic tube [41] (right strut) to 500 in-lb (56 N·m).
 - a) Loosen the connection to release the torque.
 - b) Again, tighten the connection to 500 in-lb (56 N·m).
 - c) Apply a yellow torque stripe on the connection.
- 2) Tighten the aft end connection of the thrust reverser hydraulic tube [27] (left strut) or hydraulic tube [44] (right strut) to 700 in-lb (79 N·m).
 - a) Loosen the connection to release the torque.
 - b) Again, tighten the connection to 700 in-lb (79 N·m).
 - c) Apply a yellow torque stripe on the connection.
- (c) If working on the left strut, install the clamp band [21], clamp shell [22], clamp band [25], clamp shell [26], screws [23], washers [24] that hold the thrust reverser hydraulic tube [28] and hydraulic tube [27].
 - 1) Put the clamp band [21], clamp shell [22], clamp band [25], clamp shell [26] over the tubes.
 - 2) Apply sealant, A00767 between the clamp assemblies and the mounting bracket.
 - 3) Install the screws [23] and the washers [24].
- (d) If working on the right strut, install the clamp assembly [42], clamp assembly [45], screws [43], washers [24] that hold the thrust reverser hydraulic tube [41] and hydraulic tube [44].
 - 1) Put the clamp assembly [42] and the clamp assembly [45] over the tubes.
 - 2) Apply sealant, A00767 between the clamp assemblies and the mounting bracket.
 - 3) Install the screws [43] and the washers [24].

SUBTASK 54-51-01-040-011

- (7) Make sure that electrical power has been removed, as specified in this task: Remove Electrical Power, do this task: Remove Electrical Power, TASK 24-22-00-860-812.

NOTE: The removal of electrical power is necessary to connect the electrical connectors.

SUBTASK 54-51-01-420-003



CAUTION

BE CAREFUL WITH THE POWER FEEDER CABLES. DO NOT BEND OR PUT THE CABLES INTO COILS TOO TIGHTLY. IF YOU DO NOT OBEY THESE INSTRUCTIONS, YOU CAN CAUSE DAMAGE TO THE CABLES.

- (8) Connect the IDG power feeder and the strut wire bundles at the wing forward spar disconnect panel as follows, (Figure 402):
 - (a) Remove the caps from the electrical connectors.



CAUTION

MAKE SURE THAT THE ELECTRICAL CONNECTORS ARE CLEAN BEFORE YOU CONNECT THEM. THE CONTAMINATION OF THE ELECTRICAL CONNECTOR CAN CAUSE DAMAGE TO THE EQUIPMENT.

- (b) Make sure that all of the electrical connectors are clean.
 - 1) If the connectors are not clean, do this task: Cleaning of Electrical Connectors (SWPM 20-60-01).

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- (c) Install the connectors in the AW0258L (left) or AW0258R (right) wing forward spar disconnect panel as specified in this procedure: Electrical Connector Installation (SWPM 20-60-06).

SUBTASK 54-51-01-400-007

- (9) To install the Wing Thermal Anti-Ice (TAI) Duct between the strut and the wing, do these steps, (Figure 401):
- (a) Examine the seal [10].
 - 1) Make sure the seal [10] does not have cracks, dents, or other damage.
 - 2) Replace the seal [10] if it is damaged.
 - (b) Put the Wing TAI duct with the seal [10] into its position.
 - (c) Install the coupling [8] and coupling [9].
 - 1) Carefully align the coupling [9] so that alignment pins fall in the gap between the two coupling halves.

NOTE: This is to align the duct correctly.
 - 2) Tighten the coupling [9] to the torque range specified on the part.
 - 3) Lightly tap the outer periphery of the coupling [9] with a rubber mallet.
 - 4) Tighten the coupling [9] again to the torque range specified on the part.
 - (d) Tighten the trunnion nut on the coupling [8] to 40 in-lb (5 N·m) to 50 in-lb (6 N·m).

SUBTASK 54-51-01-400-008

- (10) Install the pneumatic duct [1] or pneumatic duct [2] between the strut and the wing, do this task: Wing Leading Edge Duct Installation, TASK 36-13-01-400-801.
- (a) Examine the seal [7] (Figure 401).
 - 1) Make sure the seal [7] does not have cracks, dents, or other damage.
 - 2) Replace the seal [7] if it is damaged.
 - (b) Put the pneumatic duct [1] or pneumatic duct [2] with the seal [7] into its position.
 - (c) Install the coupling [6].
 - 1) Tighten the coupling [6] to the torque range specified on the part.
 - 2) Lightly tap the outer periphery of the coupling [6] with a rubber mallet.
 - 3) Tighten the coupling [6] again to the torque range specified on the part.
 - (d) Tighten the coupling [5] to 40 in-lb (5 N·m) to 50 in-lb (6 N·m).

NOTE: This coupling is near the "Disconnect Panel".
 - (e) Make sure that the coupling [5] is aligned so that a minimum clearance of 0.5 in. (12.7 mm) is maintained after installation of the bonding jumper for the overwing fairing.

I. Power Plant Installation

SUBTASK 54-51-01-000-010

- (1) Do this task: Power Plant - Installation, TASK 71-00-02-400-801-F00.

SUBTASK 54-51-01-010-009

- (2) Do this task: Thrust Reverser Installation, TASK 78-31-01-400-801-F00.

SUBTASK 54-51-01-010-010

- (3) If you did not do a Fan Cowl Installation on the applicable engine, do this task: Fan Cowl Panel Installation (Selection), TASK 71-11-02-400-801-F00

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J. Test the Operation of Strut Systems

SUBTASK 54-51-01-200-008

- (1) If you did not pressurize the Main Hydraulic System when you installed the power plant, do this task: Hydraulic System A or B Pressurization, TASK 29-11-00-860-801.
 - (a) Do this task: Operational Test of the Hydraulic Systems A and B, TASK 29-11-00-700-801.
 - (b) Examine the hydraulic system connections in the strut and aft fairing for leaks.
 - (c) If hydraulic fitting is found loose in this area or has persistent leaks, re-torque using TASK 20-10-51-000-802.
 - (d) Examine the seals where the hydraulic tubes go through the strut aft vapor barrier for leaks.

SUBTASK 54-51-01-200-009

- (2) Do this task: Engine Fire Extinguishing Discharge Line Flow Test, TASK 26-21-00-720-801.

SUBTASK 54-51-01-200-010

- (3) Do this task: Engine Fire Extinguishing Discharge Line Pressure Test, TASK 26-21-00-730-803.

SUBTASK 54-51-01-200-011

- (4) Do this task: Engine Fire Detection Circuit - System Test, TASK 26-11-00-730-802.

SUBTASK 54-51-01-200-012

- (5) If you did not do an EEC System Test when you installed the power plant, do this task: FADEC System Test, TASK 73-21-00-700-802-F00.

SUBTASK 54-51-01-200-013

- (6) If you did not do an Idle-Power Leak Check when you installed the power plant, do this task: Test 3A - Idle-Power Leak Check, TASK 71-00-00-700-801-F00.

NOTE: Thrust reversers must be closed for this test.

- (a) Do a check of the engine and strut drains for signs of leakage.
- (b) Examine the fuel line between the wing and the engine for leaks.
- (c) If you installed the left strut, do the Load Test for the left IDG, as specified in this task: Operational Test for the Left IDG, do this task: Number 1 IDG - Operational Test, TASK 24-11-00-700-802.
- (d) If you installed the right strut, do the Load Test for the right IDG, as specified in this task: Operational Test for the Right IDG, do this task: Number 2 IDG - Operational Test, TASK 24-11-00-700-803.

SUBTASK 54-51-01-200-014

- (7) Do this task: Engine Bleed Air Crossover Operational Test, TASK 36-11-00-710-801.

SUBTASK 54-51-01-200-015

- (8) Do this task: Engine Cowl Anti-Icing - Operational Test, TASK 30-21-00-710-801.

K. Put the Airplane Back to its Usual Condition

SUBTASK 54-51-01-410-003

- (1) Do these steps to close access to the strut systems:
 - (a) Examine the applicable strut areas for leaks.

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CAUTION

MAKE SURE THAT THE PNEUMATIC DUCT COUPLING AT THE "DISCONNECT PANEL" HAS A MINIMUM CLEARANCE OF 0.50 INCH (12.7 MM) WITH THE BONDING JUMPER ADJACENT TO IT. THE BONDING JUMPER IS CONNECTED TO THE INBOARD OVERWING FAIRING. IF THIS CLEARANCE IS NOT MAINTAINED, DAMAGE TO THE STRUT AND WING MAY OCCUR.

- (b) Install the applicable overwing fairings, do this task:

Wing Junction Fairing - Installation, 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
431DL	Forward Strut Fairing, Left Underwing Fairing, Strut 1
431DR	Forward Strut Fairing, Right Underwing Fairing, Strut 1
441CL	Forward Strut Fairing, Left Overwing Fairing, Strut 2
441CR	Forward Strut Fairing, Right Overwing Fairing, Strut 2
441DL	Forward Strut Fairing, Left Underwing Fairing, Strut 2
441DR	Forward Strut Fairing, Right Underwing Fairing, Strut 2

SUBTASK 54-51-01-010-012

- (2) Install the applicable inboard and outboard leading edge gap covers, do this task:

Leading Edge Gap Cover Installation, TASK 54-52-09-400-801

Number Name/Location

511BT	Fairing
521AT	Outbd Leading Edge - Gap Cover Access
611BT	Fairing
621AT	Outbd Leading Edge - Gap Cover Access

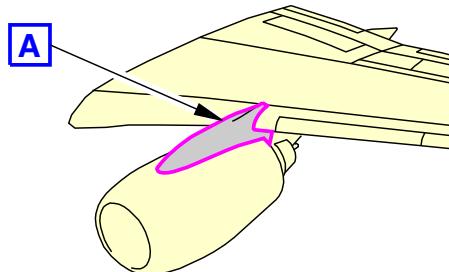
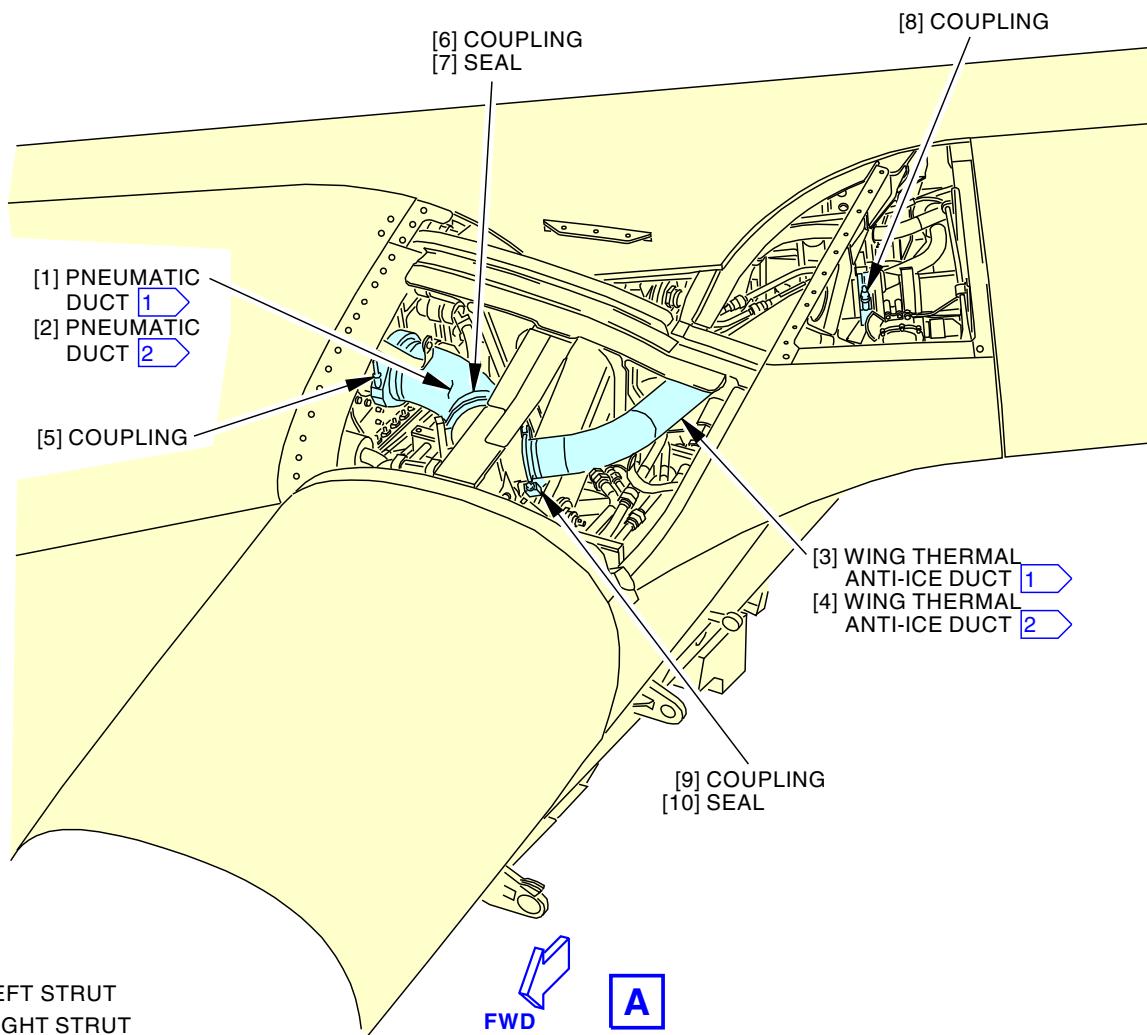
SUBTASK 54-51-01-040-012

- (3) Do this task: Put the Strut Back to its Usual Condition, TASK 54-51-01-440-801.

———— END OF TASK ————

EFFECTIVITY
LOM ALL

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LEFT STRUT
(RIGHT STRUT IS OPPOSITE)

H21334 S0006581095_V2

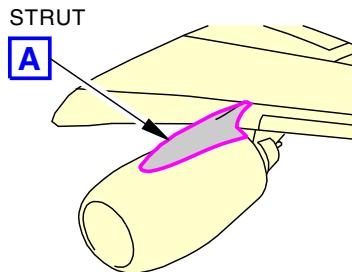
Strut Duct Installation
Figure 401/54-51-01-990-801

EFFECTIVITY
LOM ALL

54-51-01

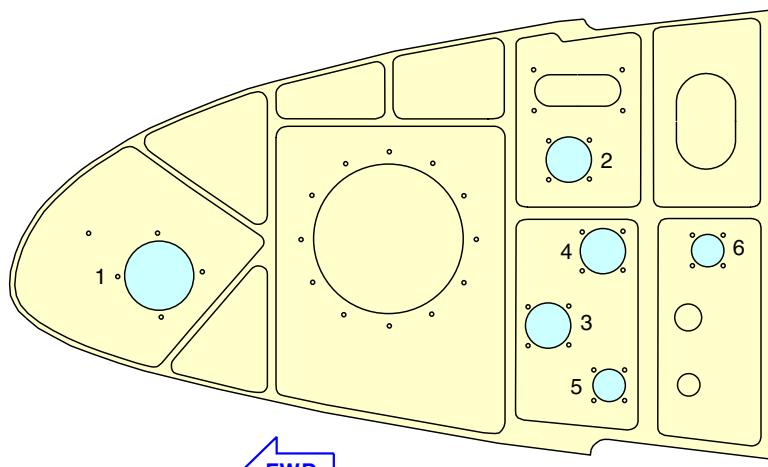


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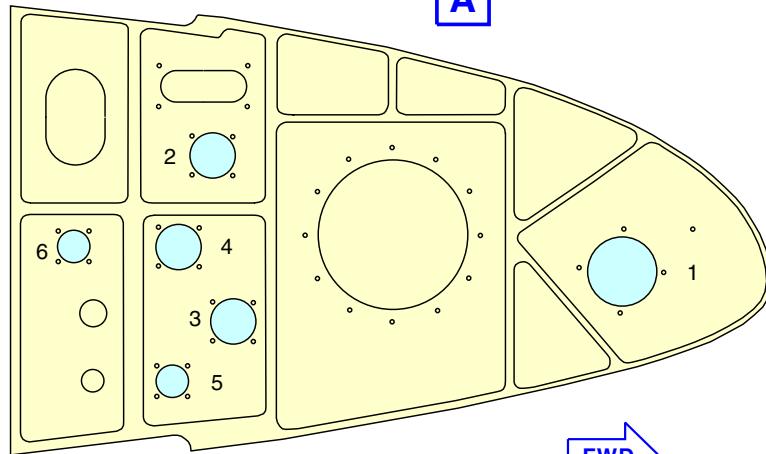
POSITION	STRUT (LEFT)	
	DISC	W/B
1	D08094P	286A1162
2	D30042	286A1172
3	D30084	286A1168
4	D30016	286A1164
5	D30064	286A1166
6	D08056P	286A1170

DISCONNECT PANEL AW0258L



POSITION	STRUT (RIGHT)	
	DISC	W/B
1	D08194P	286A1262
2	D30142	286A1272
3	D30184	286A1268
4	D30116	286A1264
5	D30164	286A1266
6	D08156P	286A1270

DISCONNECT PANEL AW0258R

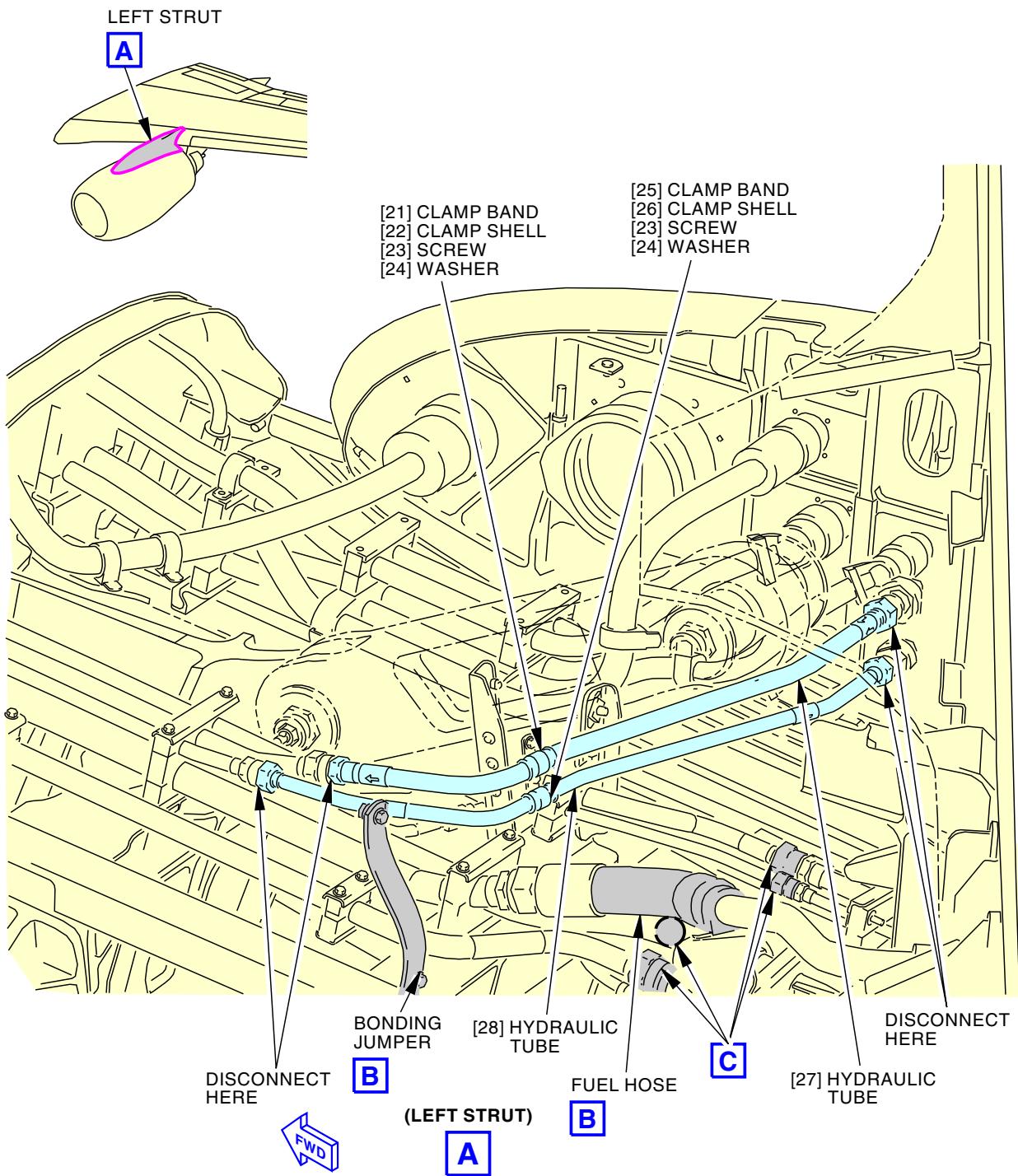


H22893 S0006581096_V2

**Strut Electrical Disconnects
Figure 402/54-51-01-990-802**

EFFECTIVITY
LOM ALL

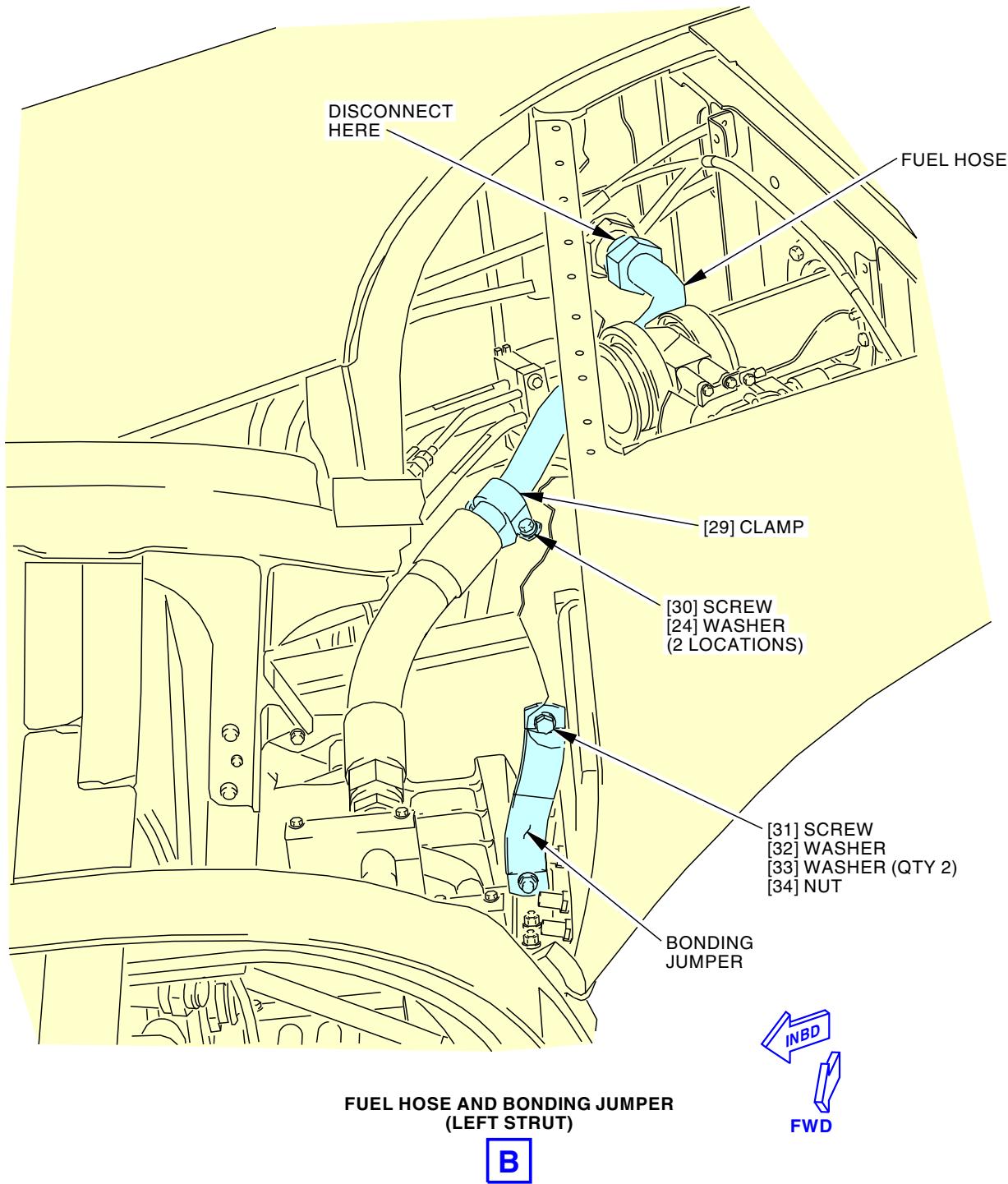
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Strut Hydraulic and Fire Extinguishing Installation
Figure 403/54-51-01-990-803 (Sheet 1 of 6)

EFFECTIVITY
LOM ALL

54-51-01



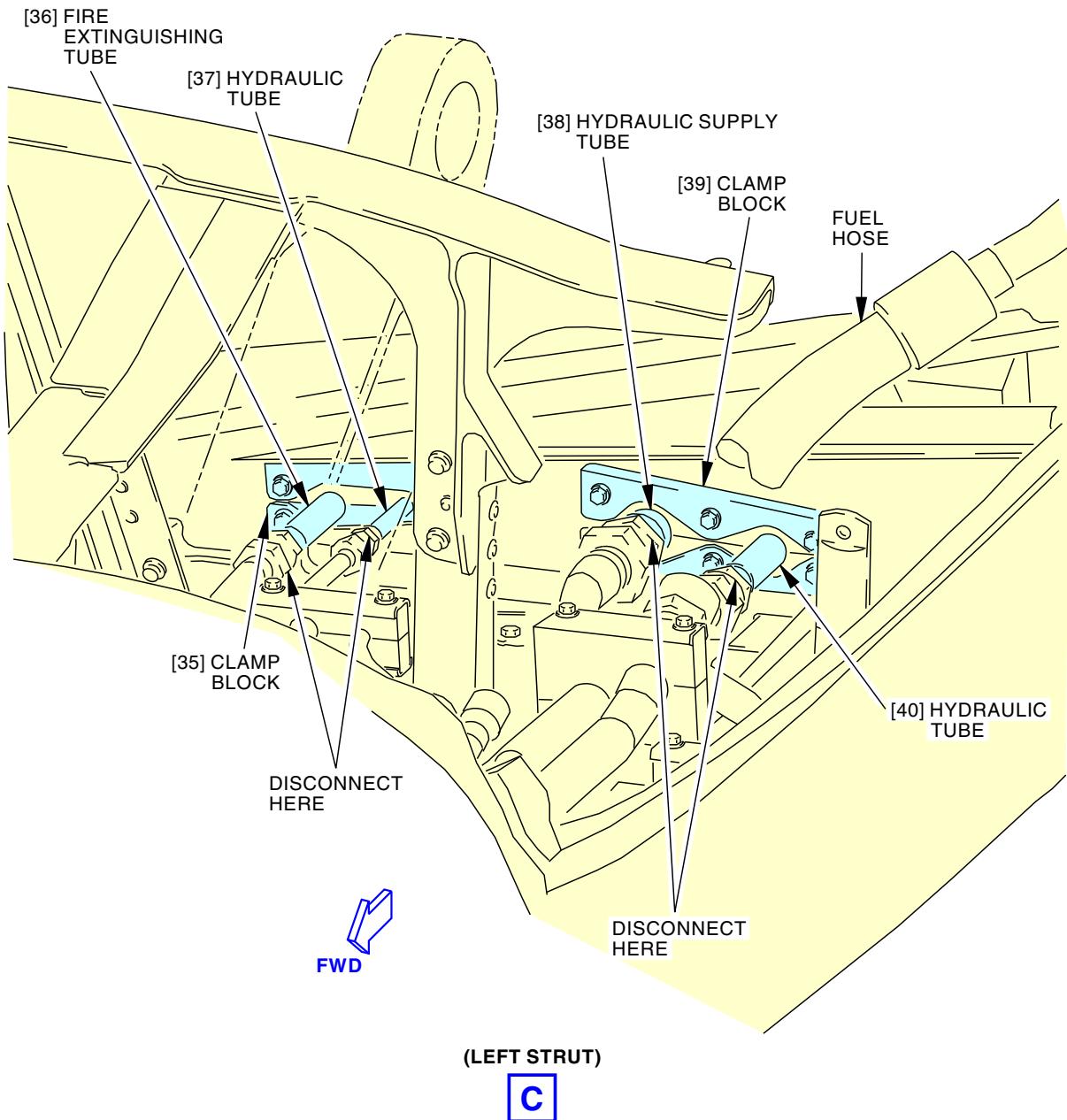
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Strut Hydraulic and Fire Extinguishing Installation
Figure 403/54-51-01-990-803 (Sheet 2 of 6)

EFFECTIVITY
LOM ALL

54-51-01

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ECCN 9E991 BOEING PROPRIETARY - See title page for details



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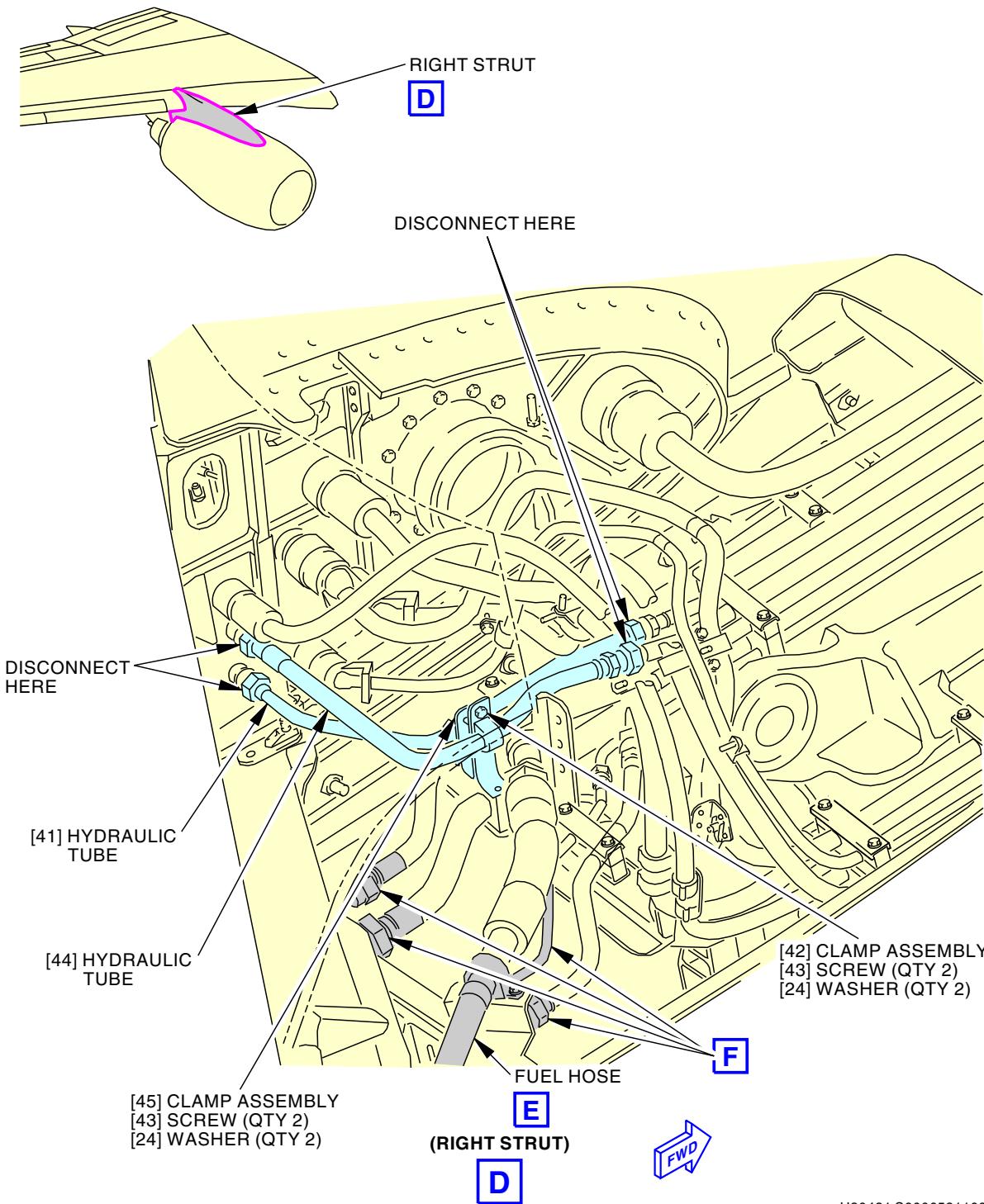
Strut Hydraulic and Fire Extinguishing Installation
Figure 403/54-51-01-990-803 (Sheet 3 of 6)

EFFECTIVITY
LOM ALL

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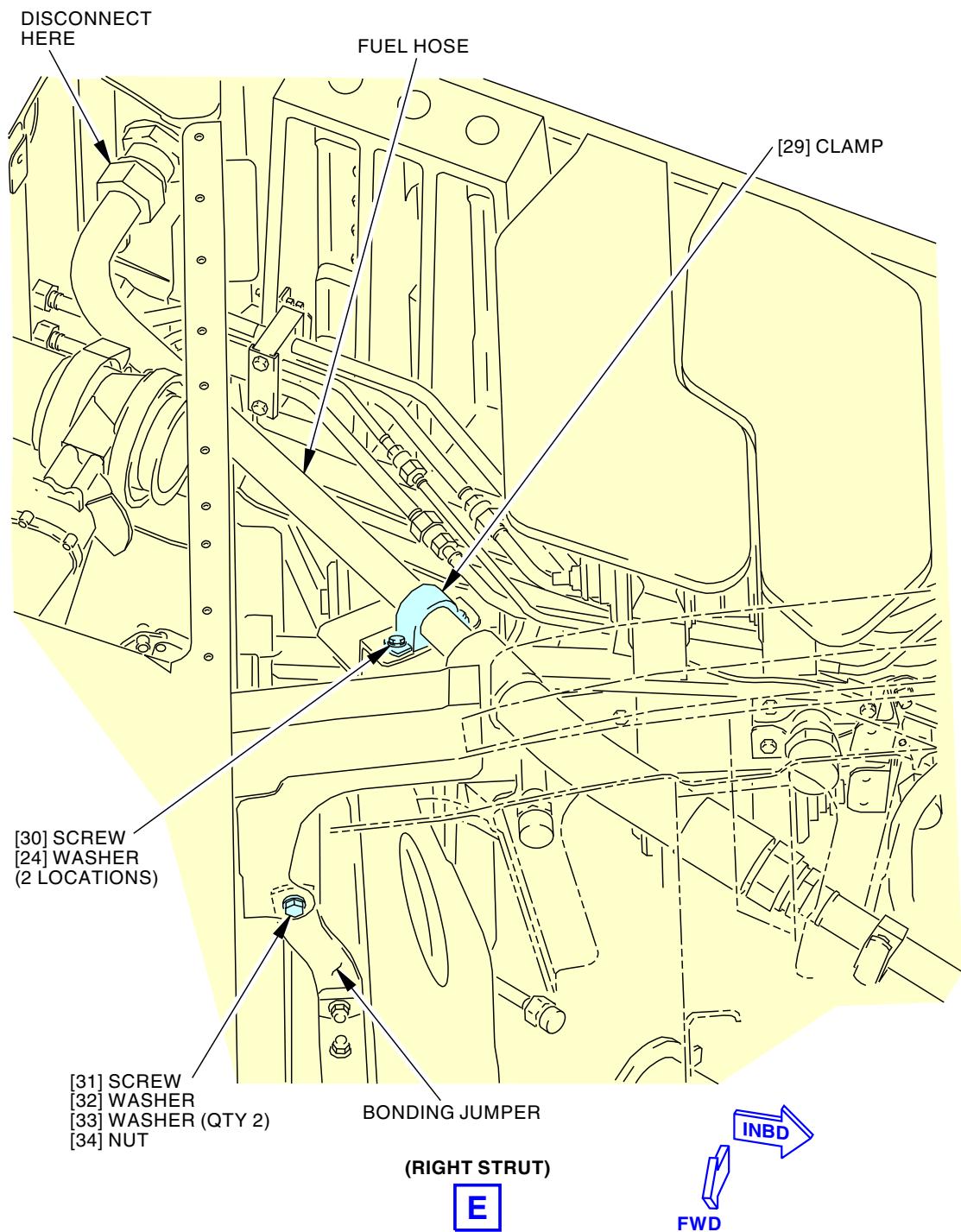


H30431 S0006581100_V2

Strut Hydraulic and Fire Extinguishing Installation
Figure 403/54-51-01-990-803 (Sheet 4 of 6)

EFFECTIVITY
LOM ALL

54-51-01

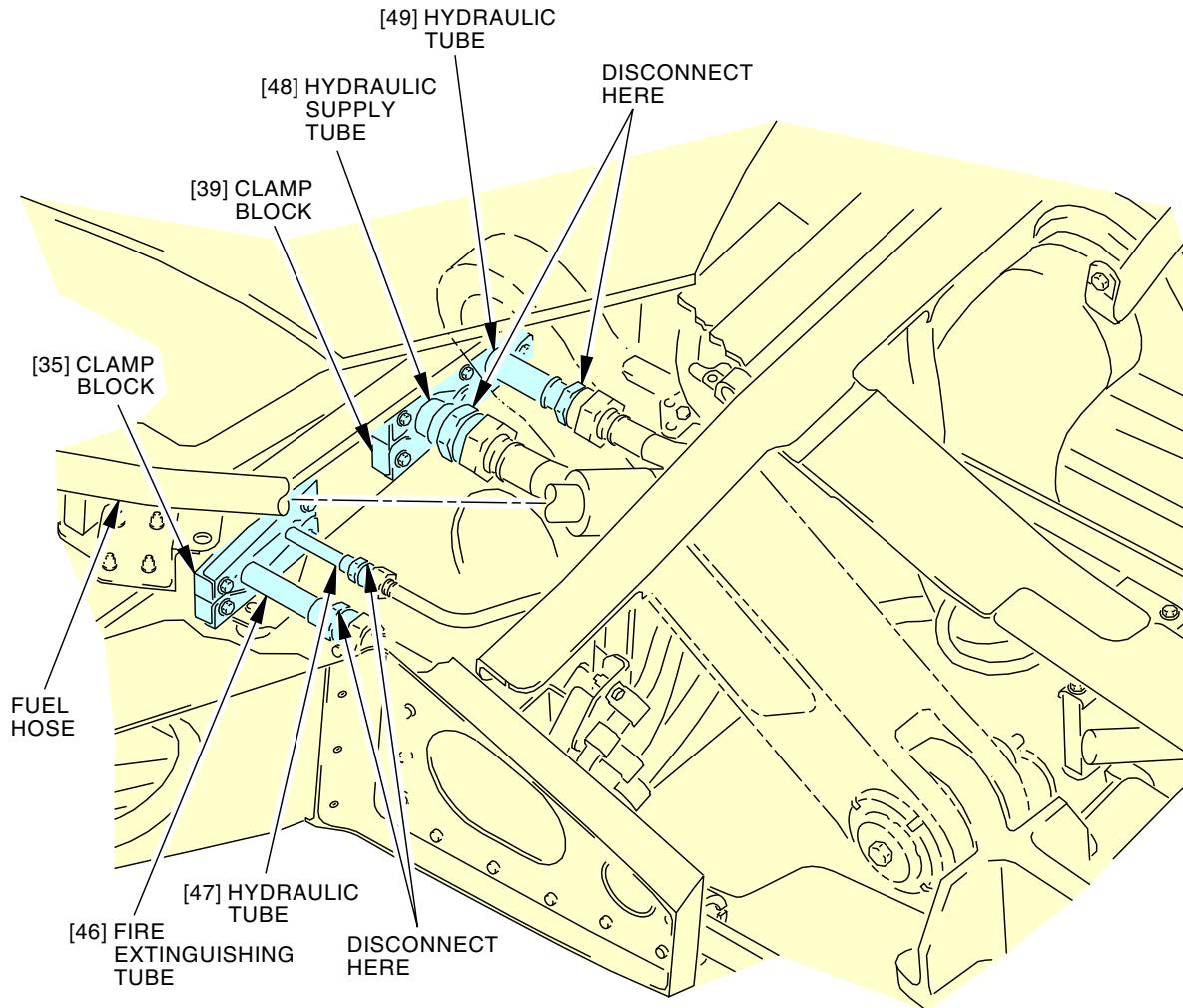


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Strut Hydraulic and Fire Extinguishing Installation
Figure 403/54-51-01-990-803 (Sheet 5 of 6)

EFFECTIVITY
LOM ALL

54-51-01


(RIGHT STRUT)
F

H30607 S0006581102_V2

**Strut Hydraulic and Fire Extinguishing Installation
Figure 403/54-51-01-990-803 (Sheet 6 of 6)**

 EFFECTIVITY
LOM ALL

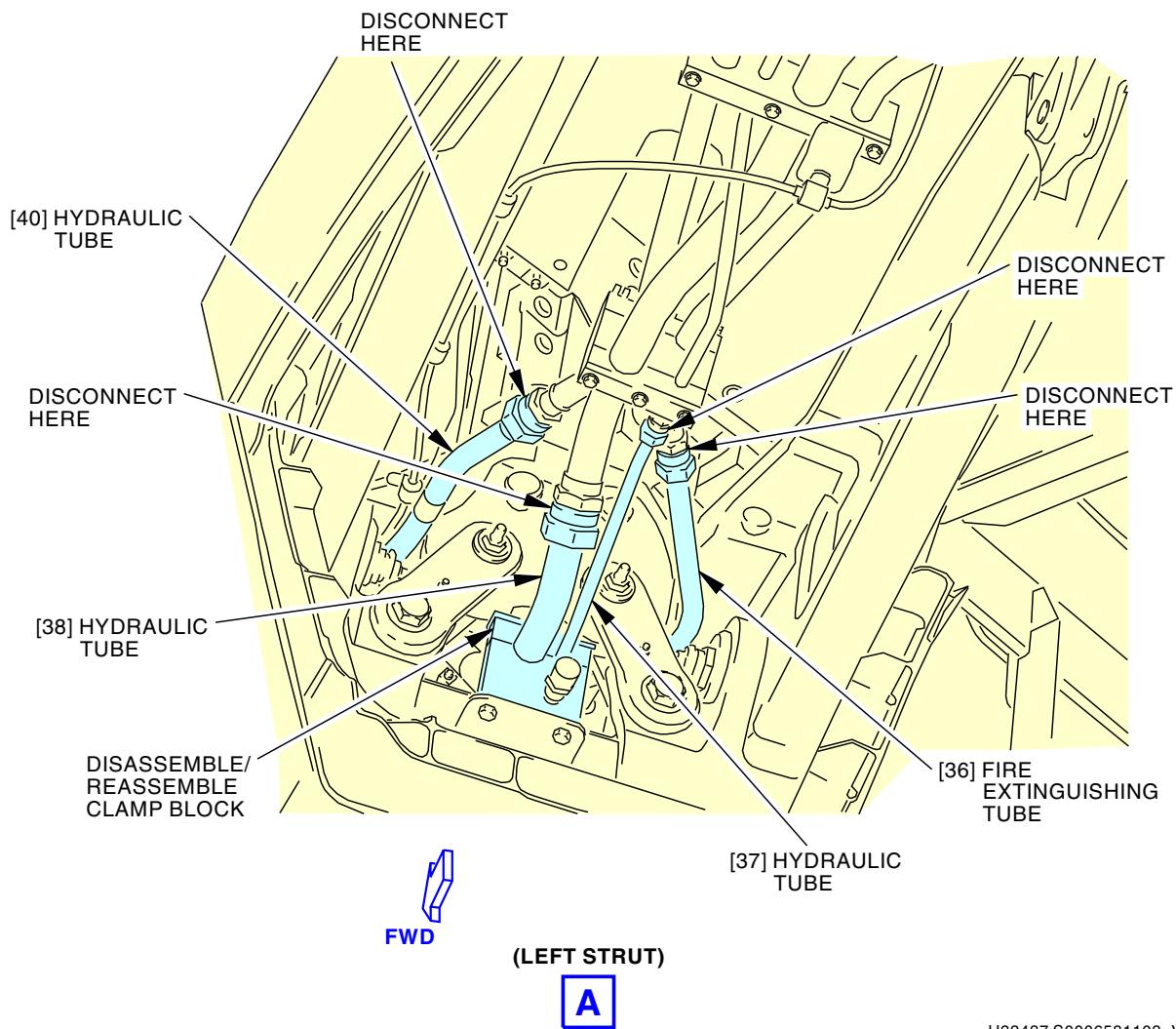
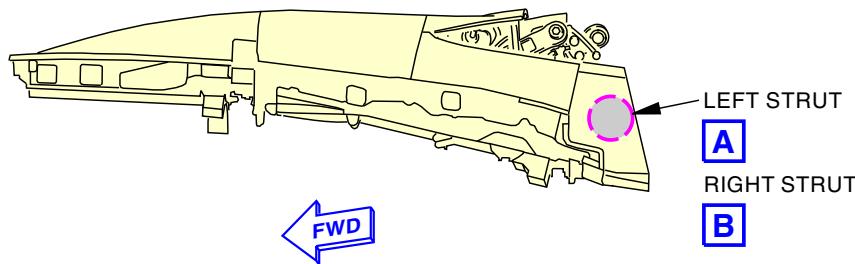
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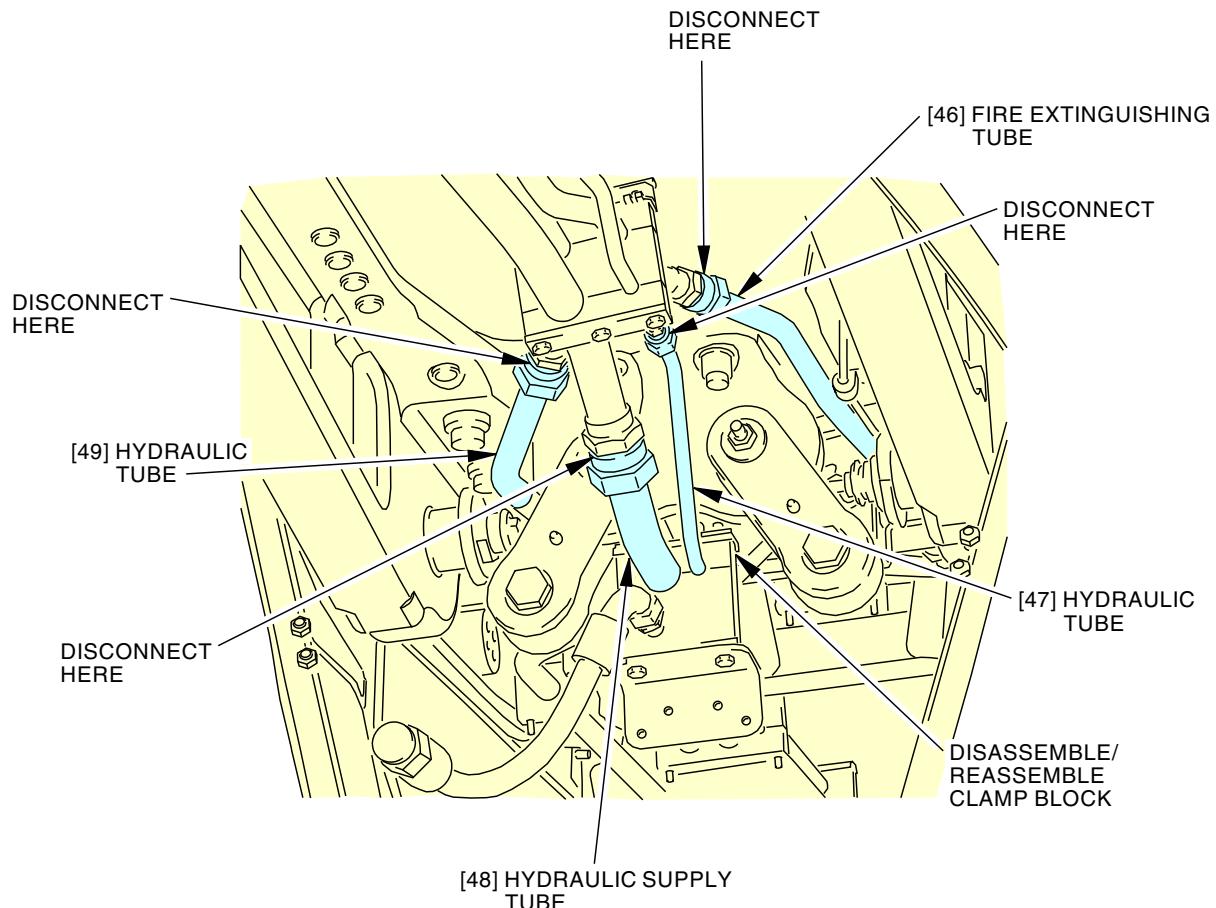


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Aft Fairing Hydraulic and Fire Extinguishing Installation
Figure 404/54-51-01-990-804 (Sheet 1 of 2)

EFFECTIVITY
LOM ALL

54-51-01



(RIGHT STRUT)

B

H33432 S0006581104_V2

Aft Fairing Hydraulic and Fire Extinguishing Installation
Figure 404/54-51-01-990-804 (Sheet 2 of 2)

EFFECTIVITY
LOM ALL**54-51-01**

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ECCN 9E991 BOEING PROPRIETARY - See title page for details



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NACELLE STRUT - INSPECTION/CHECK

1. General

- A. This procedure has these tasks:
- (1) Visually examine the strut for worn areas or damage.
 - (2) Examine the bushings in the strut fittings for worn areas.
 - (3) Examine the strut for corrosion.

TASK 54-51-01-200-801

2. Nacelle Strut Examination

A. General

- (1) This task examines the strut for worn areas or damage. Interference between the wing leading edge and the nacelle strut can cause damage to the wing and the strut. To prevent damage to the airplane structure in this area, examine the wing leading edge structure and the strut skin for interference damage.

B. References

Reference	Title
54-51-01-040-801	Prepare the Strut for Maintenance Operations (P/B 201)
54-51-01-440-801	Put the Strut Back to its Usual Condition (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)
SRM 54-50-70	Structural Repair Manual

C. Location Zones

Zone	Area
410	Subzone - Engine 1
420	Subzone - Engine 2
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

D. Strut Examination

SUBTASK 54-51-01-040-005

- (1) Do this task: Prepare the Strut for Maintenance Operations, TASK 54-51-01-040-801.

SUBTASK 54-51-01-200-001

- (2) Examine the wing leading edge and strut underwing fairings for worn areas or damage.
 - (a) If it is necessary to get access to the damaged area, (TASK 54-52-03-010-801).
 - (b) Look for signs of damage caused by interference between the strut and the wing during flight.
 - (c) If you find nicks, gouges, abrasion, or worn areas, repair as specified in this procedure: (SRM 54-50-70).
 - (d) If you removed the underwing fairings, (TASK 54-52-03-410-801).

SUBTASK 54-51-01-040-006

- (3) Do this task: Put the Strut Back to its Usual Condition, TASK 54-51-01-440-801.

———— END OF TASK ————

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TASK 54-51-01-200-802

3. Strut Bushing Examination

A. General

- (1) This task examines the bushings in the strut fittings for worn areas. This task also examines the bushings in the wing forward spar and underwing attach fittings for worn areas.
- (2) For each strut fitting location that you will examine, this task has these steps:
 - (a) Remove the attach pin.
 - (b) Measure the bushing or bearing dimensions.
 - (c) Make sure the dimensions are in the tolerances.
 - (d) Replace the bushings or bearings, if it is necessary.
 - (e) Install the attach pin.
- (3) You can only examine the bushings in one strut fitting at a time, unless you remove the strut.

B. References

Reference	Title
54-51-02-220-805	Midspur Fuse Pin and Bushing Examination (P/B 601)
54-51-03-220-801	Upper Link Forward Fuse Pin and Bushing Examination (P/B 601)
54-51-03-220-802	Upper Link Aft Pin and Bushing Examination (P/B 601)
54-51-04-220-801	Diagonal Brace Aft Fuse Pin and Bushing Examination (P/B 601)
54-51-04-220-802	Diagonal Brace Forward Pin and Bushing Examination (P/B 601)
54-51-05-220-801	Strut Side Link Examination (P/B 601)

C. Location Zones

Zone	Area
410	Subzone - Engine 1
420	Subzone - Engine 2
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

D. Strut Bushing Examination

SUBTASK 54-51-01-200-002

- (1) To examine the bushings in the strut upper spar fitting, do this task: Upper Link Forward Fuse Pin and Bushing Examination, TASK 54-51-03-220-801.

SUBTASK 54-51-01-200-003

- (2) To examine the bushings in the wing forward spar fitting, do this task: Upper Link Aft Pin and Bushing Examination, TASK 54-51-03-220-802.

SUBTASK 54-51-01-200-004

- (3) To examine the bushings in the strut lower spar fitting, do this task: Diagonal Brace Forward Pin and Bushing Examination, TASK 54-51-04-220-802.

SUBTASK 54-51-01-200-005

- (4) To examine the bushings in the aft underwing fitting, do this task: Diagonal Brace Aft Fuse Pin and Bushing Examination, TASK 54-51-04-220-801.

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LOM ALL

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SUBTASK 54-51-01-200-006

- (5) To examine the fuse pin bushings in the midspar fittings and the forward underwing fittings, do this task: Midspar Fuse Pin and Bushing Examination, TASK 54-51-02-220-805.

SUBTASK 54-51-01-200-007

- (6) To examine the side link bearing races in the midspar fittings and the center underwing fittings, do this task: Strut Side Link Examination, TASK 54-51-05-220-801.

———— END OF TASK ————

TASK 54-51-01-200-803

4. Corrosion Prevention - Nacelle Strut

A. General

- (1) This task examines the strut for corrosion. Corrosion can occur on the engine nacelle support fitting. Make regular inspections 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.

B. References

Reference	Title
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
410	Subzone - Engine 1
420	Subzone - Engine 2
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

E. Corrosion Examination

SUBTASK 54-51-01-200-016

- (1) Following cleaning of suspected areas, a visual inspection using bright lighting and mirror is effective for finding corrosion.

SUBTASK 54-51-01-200-017

- (2) Where corrosion exists it will produce noticeable bulges of the skin or white deposits of corrosion products at fastener heads.

SUBTASK 54-51-01-200-018

- (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.

SUBTASK 54-51-01-200-019

- (4) Frequency of Application

— EFFECTIVITY —
LOM ALL

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- (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 ——

———— EFFECTIVITY ——
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MID SPAR FUSE PIN - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) A removal of the midspar fuse pin
 - (2) An installation of the midspar fuse pin

TASK 54-51-02-000-803

2. Remove the Midspare Fuse Pin

(Figure 401)

A. General

- (1) If you will remove a midspare fuse pin, you must have the two upper link pins and the two diagonal brace pins installed (unless you will remove the strut).
- (2) You will remove only one midspare fuse pin at a time (unless you will remove the strut).
- (3) You can remove the two upper link pins or the two diagonal brace pins at the same time, but you can only have one link free at a time (unless you will remove the strut).

B. References

Reference	Title
54-51-01-040-801	Prepare the Strut for Maintenance Operations (P/B 201)
54-51-01-580-801	Support the Strut with the Engine Installed (P/B 201)
54-51-01-580-803	Support the Strut with the Engine Removed (P/B 201)
54-52-06-010-801	Aft Fairing Access Panel Removal (P/B 401)
54-53-02-000-802	Forward Strut Fairing Panel (Thrust Reverser Strut Fairing) Removal (P/B 401)

C. Tools/Equipment

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

Reference	Description
SPL-2020	Kit - Fuse Pin, Removal/Installation Part #: C54009-27 Supplier: 81205
STD-6213	Wrench - Torque, 300 lb-in

D. Consumable Materials

Reference	Description	Specification
D00633	Grease - Aircraft General Purpose	BMS3-33

E. Location Zones

Zone	Area
410	Subzone - Engine 1
420	Subzone - Engine 2
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

F. Access Panels

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

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(Continued)

Number	Name/Location
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
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

G. Prepare for the Removal

SUBTASK 54-51-02-040-003

- (1) Do this task: Prepare the Strut for Maintenance Operations, TASK 54-51-01-040-801.

SUBTASK 54-51-02-010-005

- (2) To get access to the midspar fuse pin, do these steps to remove the applicable access panels:

- (a) Remove the applicable strut access panels:

(TASK 54-53-02-000-802)

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
441EL	Forward Strut Fairing, Left T.R. Strut Fairing, Strut 2
441ER	Forward Strut Fairing, Right T.R. Strut Fairing, Strut 2

- (b) Remove the applicable aft fairing 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
444AL	Aft Strut Fairing, Left Forward Panel, Strut 2
444AR	Aft Strut Fairing, Right Forward Panel, Strut 2

H. Remove the Midspar Fuse Pin

LOM ALL; AIRPLANES WITH BOLT PN 311A2097

SUBTASK 54-51-02-000-007

- (1) Remove these parts:



MAKE SURE PAWL ON BOLT IS PRESSED DOWN WHILE REMOVING NUT. DAMAGE TO THE EQUIPMENT CAN OCCUR.

- (a) Remove the nuts [27], bolts [22], and end caps [23].
(b) Remove the nuts [24] and end caps [25].

LOM ALL; AIRPLANES WITH BOLT PN BACB30LE

SUBTASK 54-51-02-000-021

- (2) Remove these parts:

- (a) Remove the nuts [27], nuts [24], washers [28], and end caps [25].

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LOM ALL; AIRPLANES WITH BOLT PN BACB30LE (Continued)

- (b) Remove the bolts [22] and end caps [23].

LOM ALL

SUBTASK 54-51-02-000-008

- (3) If the strut will stay installed, do these steps to remove the fuse pin:

- (a) Support the strut as follows:

- 1) If you will remove the fuse pin with the engine installed, do this task: Support the Strut with the Engine Installed, TASK 54-51-01-580-801.
- 2) If you will remove the fuse pin with the engine removed, do this task: Support the Strut with the Engine Removed, TASK 54-51-01-580-803.



CAUTION

MAKE SURE ALL THE UPPER LINK PINS, DIAGONAL BRACE PINS, AND THE OTHER MIDSPAR FUSE PIN ARE INSTALLED. DAMAGE TO THE STRUCTURE CAN OCCUR.

- (b) Use the torque wrench, STD-6213, and the adapter fuse pin kit, SPL-2020, to make sure the fuse pin turns easily.
- 1) When the load is correctly removed, the fuse pin will turn with 125 in-lb (14 N·m) maximum torque.



CAUTION

MAKE SURE YOU USE A BRASS SLUG TO PUSH OUT THE FUSE PIN. IF YOU DO NOT USE A BRASS SLUG, THE CLEVIS MAY NOT STAY ALIGNED WITH THE LUG. DAMAGE TO THE BUSHINGS OR STRUCTURE CAN OCCUR.

- (c) Use a brass slug from the pin removal fuse pin kit, SPL-2020, with grease, D00633, to push out the fuse pins [26].

NOTE: Make sure the clevis and the flange stay aligned.

- 1) Keep the support load on the strut until you install a fuse pin at this location.

NOTE: The hydraulic system in the crane can bleed which can cause the load to change.

SUBTASK 54-51-02-000-009

- (4) If you will remove the strut, do this step to remove the fuse pin:

- (a) Do this task: Support the Strut with the Engine Removed, TASK 54-51-01-580-803.

- (b) Use the torque wrench, STD-6213, and the adapter fuse pin kit, SPL-2020, to make sure the fuse pin turns easily.

- 1) When the load is correctly removed, the fuse pin will turn with 125 in-lb (14 N·m) maximum torque.

- (c) Use the pin removal fuse pin kit, SPL-2020, to remove the fuse pins [26].

———— END OF TASK ————

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TASK 54-51-02-400-803

3. Install the Midspar Fuse Pin

(Figure 401)

A. General

- (1) This task installs a midspar fuse pin.
- (2) This task has these steps:
 - (a) Make sure there is no corrosion on the fuse pin.
 - (b) If you did not remove the strut, make sure there is no load on the brass slug.
 - (c) Install the fuse pin with grease.
 - (d) Install the end caps, bolt, and nuts.
 - (e) Remove the support from the strut.
 - (f) If you will do no more maintenance operations on the strut, put the airplane back to its usual condition.

B. References

Reference	Title
12-21-32-600-801	Lubricate the Strut Attach Fittings (P/B 301)
51-00-53	CORROSION REMOVAL
54-51-01-440-801	Put the Strut Back to its Usual Condition (P/B 201)
54-51-01-580-802	Remove Support from the Strut with the Engine Installed (P/B 201)
54-51-01-580-804	Remove Support from the Strut with the Engine Removed (P/B 201)
54-51-02-220-805	Midspar Fuse Pin and Bushing Examination (P/B 601)
54-52-06-410-801	Aft Fairing Access Panel Installation (P/B 401)
54-53-02-410-801	Forward Strut Fairing Panel (Thrust Reverser Strut Fairing) Installation (P/B 401)

C. Tools/Equipment

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

Reference	Description
SPL-2020	Kit - Fuse Pin, Removal/Installation Part #: C54009-27 Supplier: 81205
SPL-11064	FEELER GAGE - CFM56-7 STRUT TO WING Part #: C54007-1 Supplier: 81205

D. Consumable Materials

Reference	Description	Specification
D00006	Compound - Antiseize, Pure Nickel Special - Never-Seez NSBT-8N/-16N	
D00633	Grease - Aircraft General Purpose	BMS3-33

E. Location Zones

Zone	Area
410	Subzone - Engine 1

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(Continued)

Zone	Area
420	Subzone - Engine 2
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

F. 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
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

G. Install the Midspar Fuse Pin

SUBTASK 54-51-02-200-005

- (1) Do this task: Midspar Fuse Pin and Bushing Examination, TASK 54-51-02-220-805.

LOM ALL; AIRPLANES WITH BOLT PN 311A2097

SUBTASK 54-51-02-210-005

- (2) Do a check that the bolts [22], end caps [23], nuts [24], end caps [25], fuse pins [26], and nuts [27] are free from corrosion.
(a) Include the interior of the fuse pin.

LOM ALL; AIRPLANES WITH BOLT PN BACB30LE

SUBTASK 54-51-02-210-007

- (3) Do a check that the fuse pins [26], end caps [25], nuts [27], nuts [24], end caps [23], bolts [22], and washers [28] are free from corrosion.
(a) Include the interior of the fuse pins [26].

LOM ALL

SUBTASK 54-51-02-210-006

- (4) If you removed the strut, do a check that the interior of the bushings at the installation fittings are free from corrosion.

SUBTASK 54-51-02-300-003

- (5) Do these steps if you find corrosion:
(a) To remove corrosion, refer to the CORROSION REMOVAL, SUBJECT 51-00-53.
(b) To repair or replace the corroded part, contact Boeing for corrective action.

SUBTASK 54-51-02-400-009

- (6) If you did not remove the strut, install the fuse pins [26] as follows:
(a) Make sure that the brass slug is unloaded.
(b) Apply a thin layer of grease, D00633, to the fuse pin that you will install.
(c) Use the pin installation fuse pin kit, SPL-2020, to push out the brass slug with the fuse pin.

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- 1) For the inboard midspar fuse pin, put the head of the fuse pin on the inboard side of the midspar fitting.
- 2) For the outboard midspar fuse pin, put the head of the fuse pin on the outboard side of the midspar fitting.

SUBTASK 54-51-02-400-010

- (7) If you removed the strut, install the fuse pins [26] as follows:
 - (a) Apply a thin layer of grease, D00633, to the fuse pin to be installed.
 - (b) Use the pin installation fuse pin kit, SPL-2020, to install the fuse pin.
 - 1) For the inboard midspar fuse pin, put the head of the fuse pin on the inboard side of the midspar fitting.
 - 2) For the outboard midspar fuse pin, put the head of the fuse pin on the outboard side of the midspar fitting.

LOM ALL; AIRPLANES WITH BOLT PN 311A2097

SUBTASK 54-51-02-400-012

- (8) Install these parts:
 - (a) Install the bolts [22] and end caps [23].
 - 1) For the inboard midspar bolt, put the head of the bolt on the inboard side of the midspar fitting.
 - 2) For the outboard midspar bolt, put the head of the bolt on the outboard side of the midspar fitting.
 - (b) Install the end cap [25].
 - (c) Install the nut [24].
 - 1) Apply a layer of Pure Nickel Special compound, D00006, to the nuts [24].
 - 2) Do a check of the run-on torque.
 - a) If the run-on torque is not 70 in-lb (8 N·m) to 600 in-lb (68 N·m), replace the nuts [24] and do the check again.
 - 3) Tighten the nuts [24] to 900 ± 100 in-lb (102 ± 12 N·m)
 - (d) Install the nuts [27].
 - 1) Apply Pure Nickel Special compound, D00006, to the threads of the nuts [27].
 - 2) Do a check of the run-on torque.
 - a) If the run-on torque is not 9.5 in-lb (1.1 N·m) to 80 in-lb (9 N·m), replace the nuts [27] and do the check again.
 - 3) Tighten the nuts [27] to 175 ± 25 in-lb (20 ± 3 N·m).
 - (e) Make sure the spring loaded pawl on the bolts [22] fully extends when you tighten the nuts [27].

LOM ALL; AIRPLANES WITH BOLT PN BACB30LE

SUBTASK 54-51-02-420-001

- (9) Install the parts that follow.
 - (a) Install the end caps [23] to the bolts [22]
 - (b) Install the bolts [22] and end caps [23] to the fuse pins [26].
 - 1) For the inboard midspar bolt, put the head of the bolt on the inboard side of the midspar fitting.

EFFECTIVITY
LOM ALL

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LOM ALL; AIRPLANES WITH BOLT PN BACB30LE (Continued)

- 2) for the outboard midspar bolt, put the head of the bolt on the outboard side of the midspar fitting.
- (c) Install the end caps [25].
- (d) Install the nuts [24].
 - 1) Apply a layer of Pure Nickel Special compound, D00006, to the nuts [24].
 - 2) Do a check of the run-on torque.
 - a) If the run-on torque is not 70 in-lb (8 N·m) to 600 in-lb (68 N·m), replace the nuts [24] and do the check again.
 - 3) Tighten the nuts [24] to 900 ± 100 in-lb (102 ± 12 N·m)
- (e) Install the washers [28].
- (f) Install the nuts [27].
 - 1) Apply Pure Nickel Special compound, D00006, to the threads of the nuts [27].
 - 2) Do a check of the run-on torque.
 - a) If the run-on torque is not 9.5 in-lb (1.1 N·m) to 80 in-lb (9 N·m), replace the nuts [27] and do the check again.
 - 3) Tighten the nuts [27] to 175 ± 25 in-lb (20 ± 3 N·m).

LOM ALL

SUBTASK 54-51-02-200-006

- (10) Make sure that all parts are firmly seated.

SUBTASK 54-51-02-200-007

- (11) Use a feeler gage, SPL-11064, to check the gap between the strut and wing fitting.

SUBTASK 54-51-02-640-002

- (12) To inject grease, D00633, into the midspar grease fittings, do this task: Lubricate the Strut Attach Fittings, TASK 12-21-32-600-801.

H. Put the Airplane Back to Its Usual Condition

SUBTASK 54-51-02-580-003

- (1) Remove the support from the strut as follows:

- (a) If you installed the fuse pin with the engine installed, do this task: Remove Support from the Strut with the Engine Installed, TASK 54-51-01-580-802.
- (b) If you installed the fuse pin with the engine removed, do this task: Remove Support from the Strut with the Engine Removed, TASK 54-51-01-580-804.

SUBTASK 54-51-02-410-001

- (2) Install the aft fairing 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
444AL	Aft Strut Fairing, Left Forward Panel, Strut 2
444AR	Aft Strut Fairing, Right Forward Panel, Strut 2

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SUBTASK 54-51-02-410-002

- (3) Install these strut access panels:

(TASK 54-53-02-410-801)

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
441EL	Forward Strut Fairing, Left T.R. Strut Fairing, Strut 2
441ER	Forward Strut Fairing, Right T.R. Strut Fairing, Strut 2

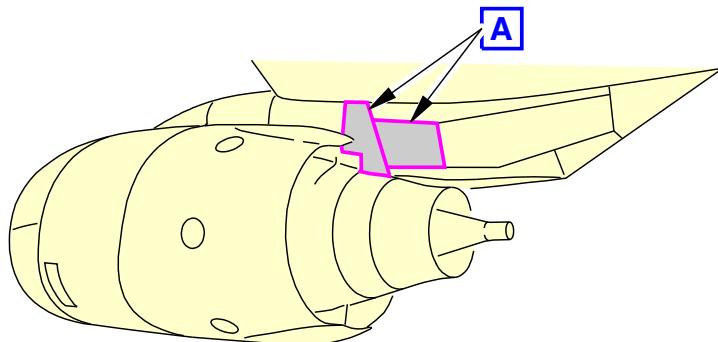
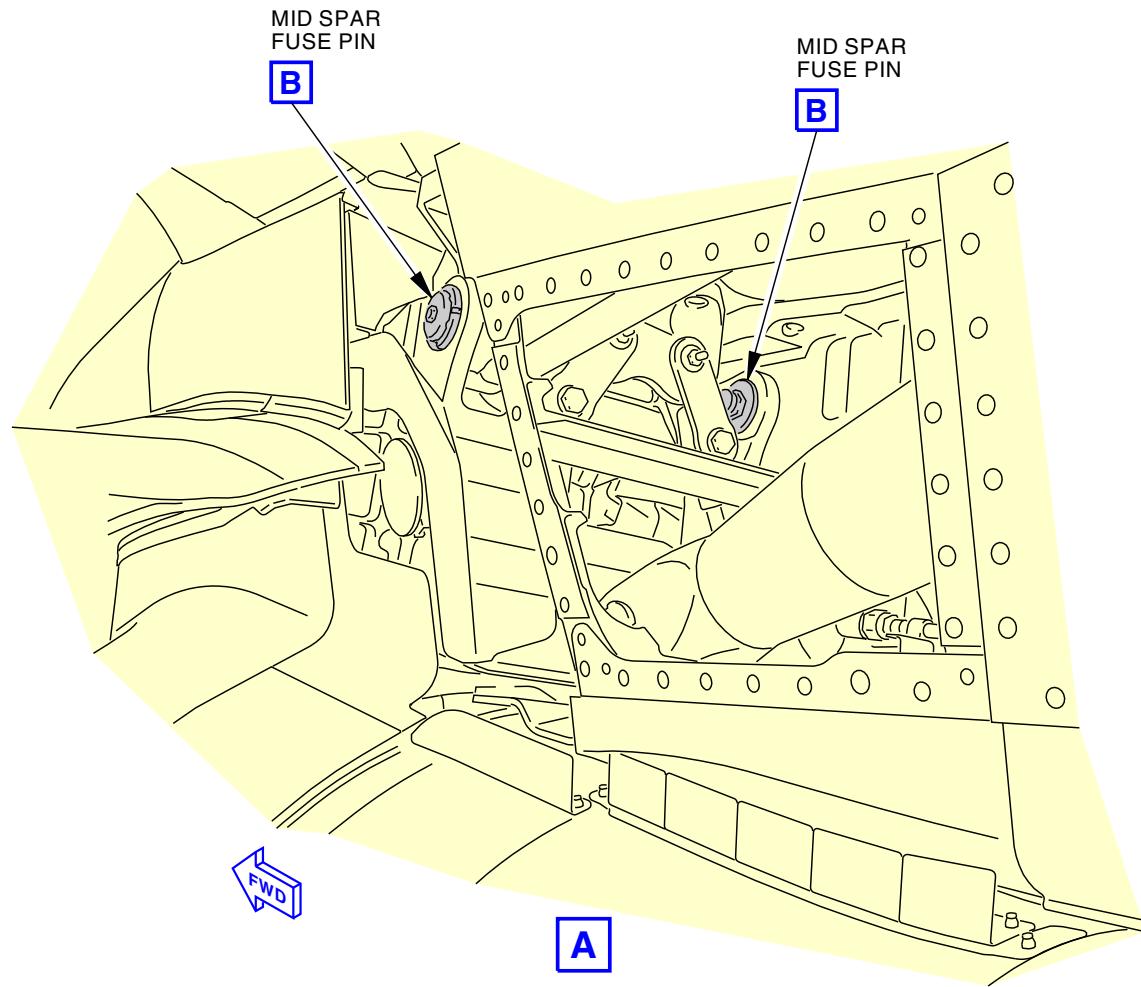
SUBTASK 54-51-02-440-003

- (4) If you will do no more maintenance operations on the strut, do this task: Put the Strut Back to its Usual Condition, TASK 54-51-01-440-801.

———— END OF TASK ————

EFFECTIVITY
LOM ALL

54-51-02

LEFT STRUT
(RIGHT SIDE IS OPPOSITE)

G49355 S0006581112_V2

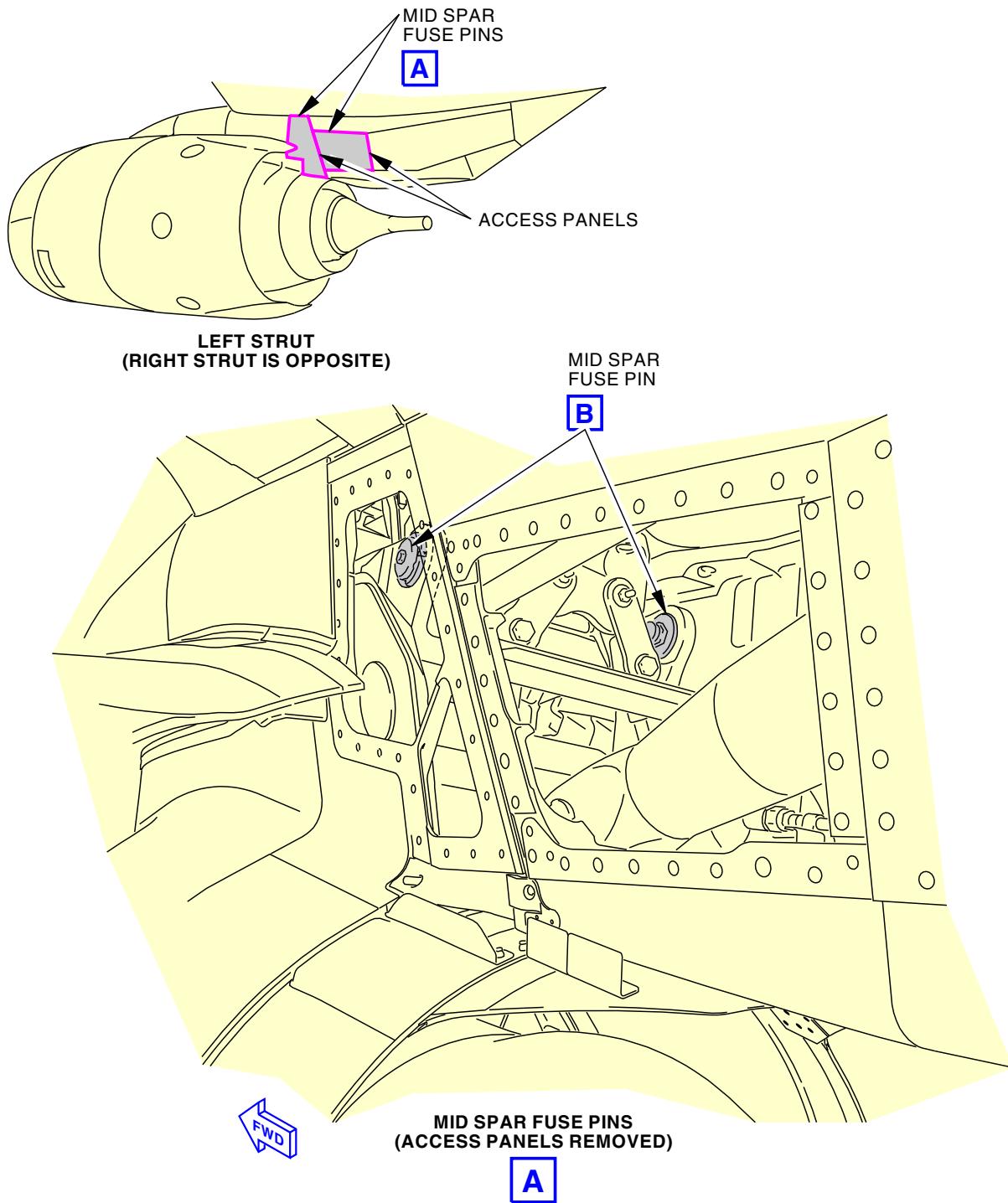
Mid Spar Fuse Pin Installation
Figure 401/54-51-02-990-801 (Sheet 1 of 4)

EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-78-1089

54-51-02

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details



2082413 S0000437978_V2

Mid Spar Fuse Pin Installation
Figure 401/54-51-02-990-801 (Sheet 2 of 4)

EFFECTIVITY
LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
407, 411, 412, 415, 416, 420, 422-426 POST SB
737-78-1089

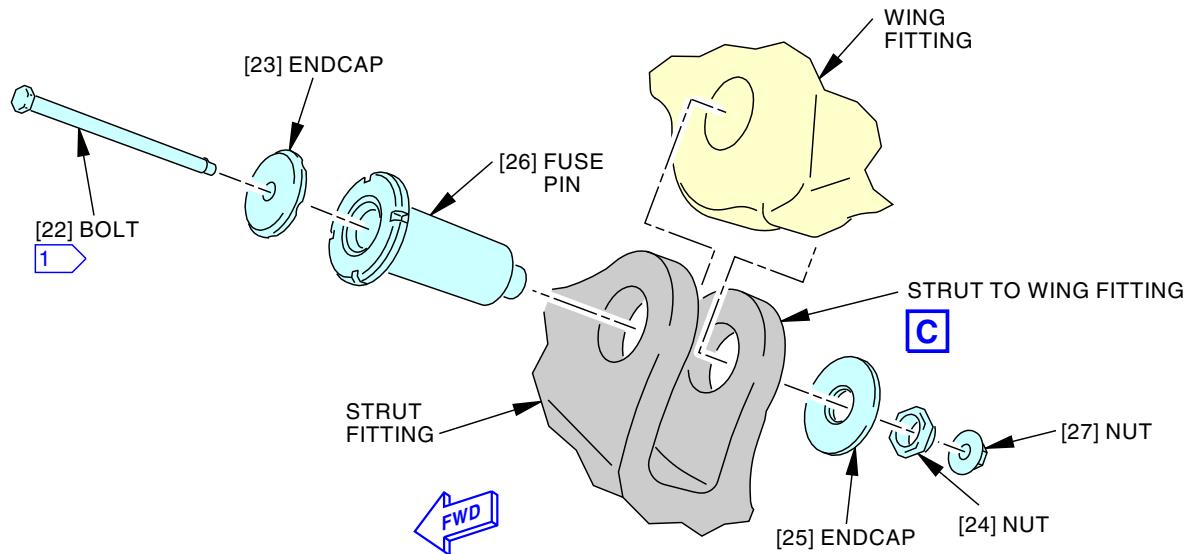
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D633A101-LOM

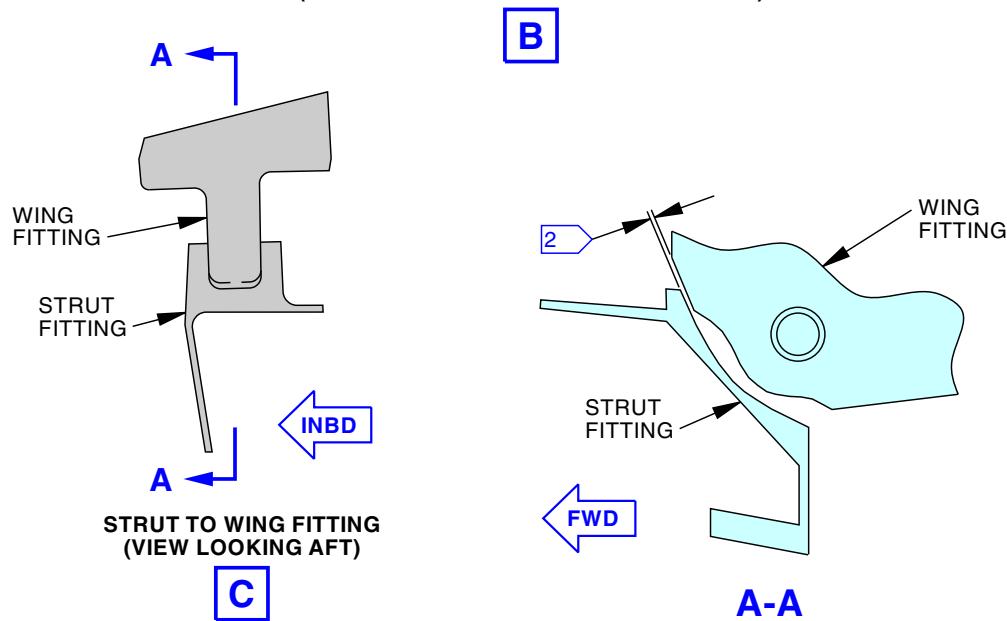
ECCN 9E991 BOEING PROPRIETARY - See title page for details



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LEFT MID SPAR FUSE PIN
(RIGHT MID SPAR FUSE PIN IS OPPOSITE)



[1] BOLT MUST BE INSTALLED IN DIRECTION SHOWN.

[2] MINIMUM 0.05 GAP REQUIRED BETWEEN STRUT AND WING FITTINGS IN AREA SHOWN. APPLIES TO INBD WING AND STRUT FITTINGS ONLY.

G49857 S0006581113_V4

Mid Spar Fuse Pin Installation
Figure 401/54-51-02-990-801 (Sheet 3 of 4)

EFFECTIVITY
LOM ALL; AIRPLANES WITH BOLT PN 311A2097

54-51-02

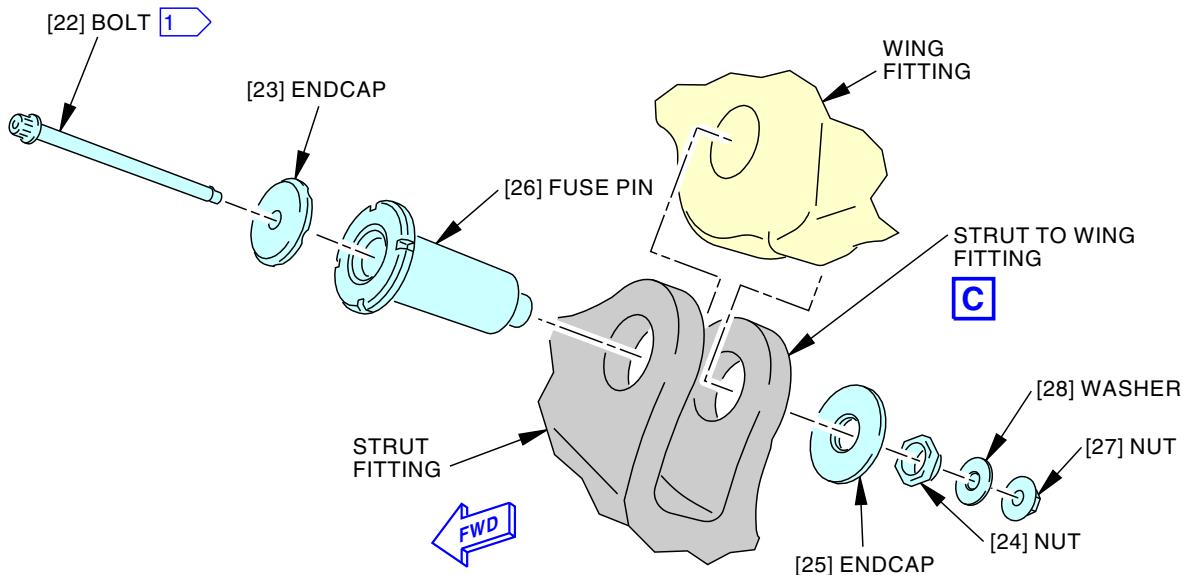
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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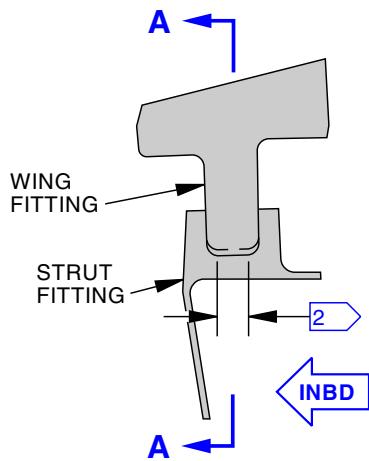


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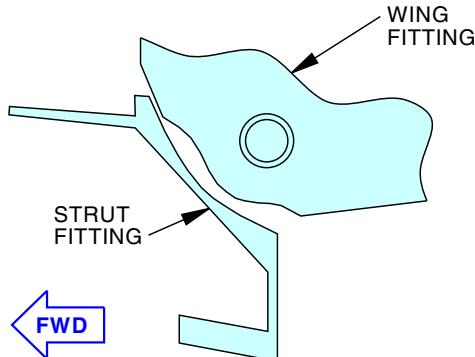
LEFT MID SPAR FUSE PIN
(RIGHT MID SPAR FUSE PIN IS OPPOSITE)

B



STRUT TO WING FITTING
(VIEW LOOKING AFT)

C



A-A

INSTALL BOLT IN
DIRECTION SHOWN.

1 ⌢ INSTALL BOLT IN DIRECTION SHOWN.

MINIMUM 0.05 INCH (1.27 mm) GAP BETWEEN STRUT AND WING FITTINGS.

2 ⌢ THIS APPLIES TO INBOARD WING AND STRUT FITTINGS ONLY.

1925663 S0000363904_V2

Mid Spar Fuse Pin Installation
Figure 401/54-51-02-990-801 (Sheet 4 of 4)

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LOM ALL; AIRPLANES WITH BOLT PN BACB30LE

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D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details



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MIDSPAR FUSE PIN - INSPECTION/CHECK

1. General

- A. This procedure has this task:
- (1) Examine the midspar fuse pins and bushings.

TASK 54-51-02-220-805

2. Midspar Fuse Pin and Bushing Examination

(Figure 601)

A. General

- (1) This task examines the midspar fuse pin for worn areas. This task also examines the bushings in the strut midspar attach fittings for worn areas.
- (2) This task has these steps:
 - (a) Remove the midspar fuse pin.
 - (b) Measure the midspar fuse pin and bushing dimensions.
 - (c) Make sure the dimensions are in the tolerances.
 - (d) Replace the midspar fuse pin or bushings, if it is necessary.
 - (e) Install the midspar fuse pin.
- (3) You can examine only one midspar fuse pin at a time. Both diagonal brace pins, and both upper link pins, and one midspar fuse pin must stay installed, unless you remove the strut.

B. References

Reference	Title
54-51-02-000-803	Remove the Midspar Fuse Pin (P/B 401)
54-51-02-400-803	Install the Midspar Fuse Pin (P/B 401)
SRM 54-50-90	Structural Repair Manual

C. Location Zones

Zone	Area
410	Subzone - Engine 1
420	Subzone - Engine 2
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

D. Prepare for the Examination

SUBTASK 54-51-02-000-020

- (1) Do this task: Remove the Midspar Fuse Pin, TASK 54-51-02-000-803.

E. Fuse Pin and Bushing Examination

SUBTASK 54-51-02-220-005

- (1) Measure these dimensions:
 - (a) Measure the outside diameter of the midspar fuse pin.
 - (b) Measure the inside diameter of the bushings in the forward underwing fitting.
 - (c) Measure the inside diameter of the bushings in the strut midspar fitting.

SUBTASK 54-51-02-300-010

- (2) Make sure the dimensions are in the tolerances as specified in Table 601.

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Table 601/54-51-02-993-811 Mid Spar Fuse Pin Wear Limits

INDEX NO.	NAME OF THE PARTS THAT ARE IN CONTACT	DIM.	DIAMETER DESIGN LIMITS		WEAR LIMITS	
			MINIMUM inches/mm	MAXIMUM inches/mm	PERMITTED WEAR DIMENSIONS	MAX CLEARANCE
1	BUSHING	I.D.	1.6515 in 41.948 mm	1.6523 in 41.968 mm	1.6546 in 42.027 mm	0.0046 in 0.117 mm
	FUSE PIN	O.D.	1.6500 in 41.910 mm	1.6505 in 41.922 mm	1.6477 in 41.851 mm	
2	BUSHING	I.D.	1.6515 in 41.948 mm	1.6523 in 41.968 mm	1.6546 in 42.027 mm	0.0046 in 0.117 mm
	FUSE PIN	O.D.	1.6500 in 41.910 mm	1.6505 in 41.922 mm	1.6477 in 41.851 mm	

- (a) If the fuse pin dimensions are not in the tolerances, replace the fuse pin.
- (b) If the bushing dimensions in the forward underwing fitting are not in the tolerances, replace the bushings as specified in this procedure: (SRM 54-50-90).
- (c) If the bushing dimensions in the strut midspar fitting are not in the tolerances, replace the bushings as specified in this procedure: (SRM 54-50-90).

F. Put the Airplane Back to its Usual Condition

SUBTASK 54-51-02-400-025

- (1) Do this task: Install the Midspare Fuse Pin, TASK 54-51-02-400-803.

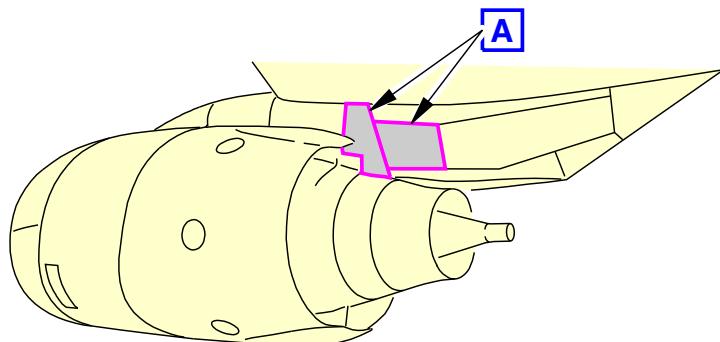
— END OF TASK —

EFFECTIVITY
LOM ALL

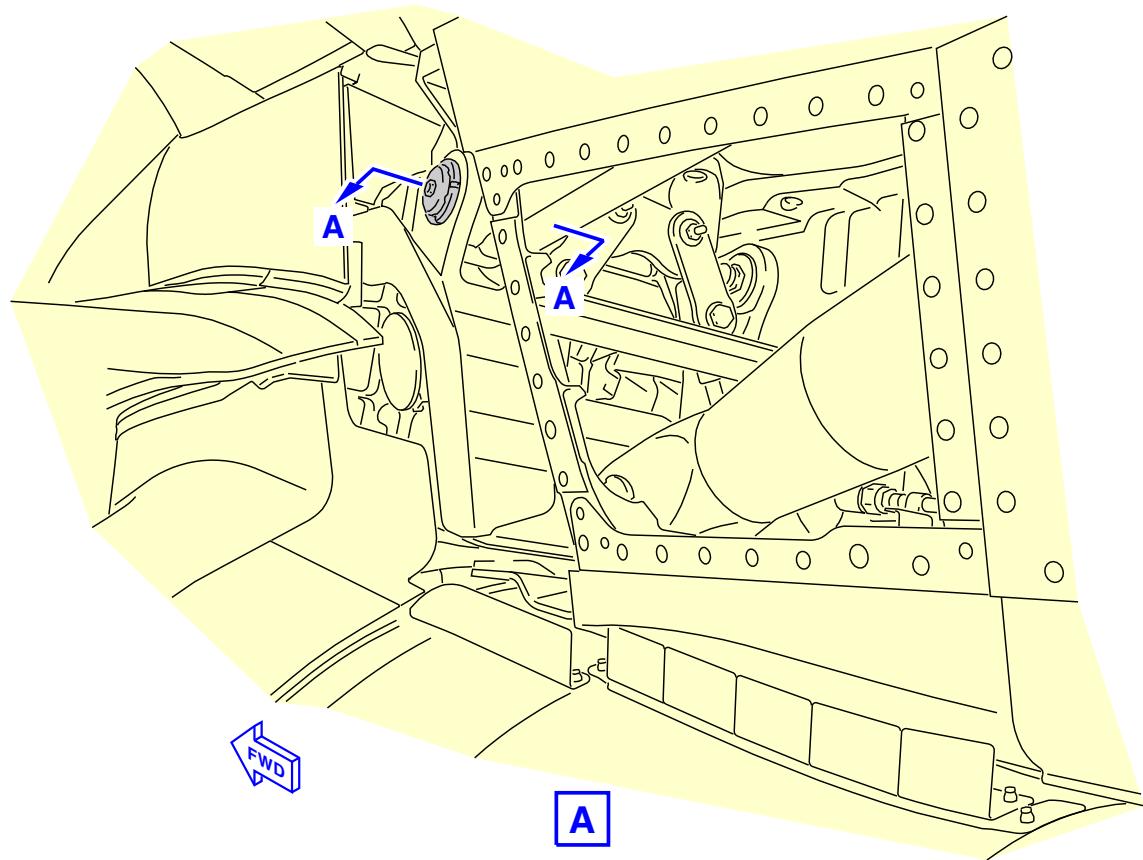
54-51-02



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LEFT STRUT
(RIGHT SIDE IS OPPOSITE)



H01032 S0006581117_V2

Midspar Examination
Figure 601/54-51-02-990-811 (Sheet 1 of 3)

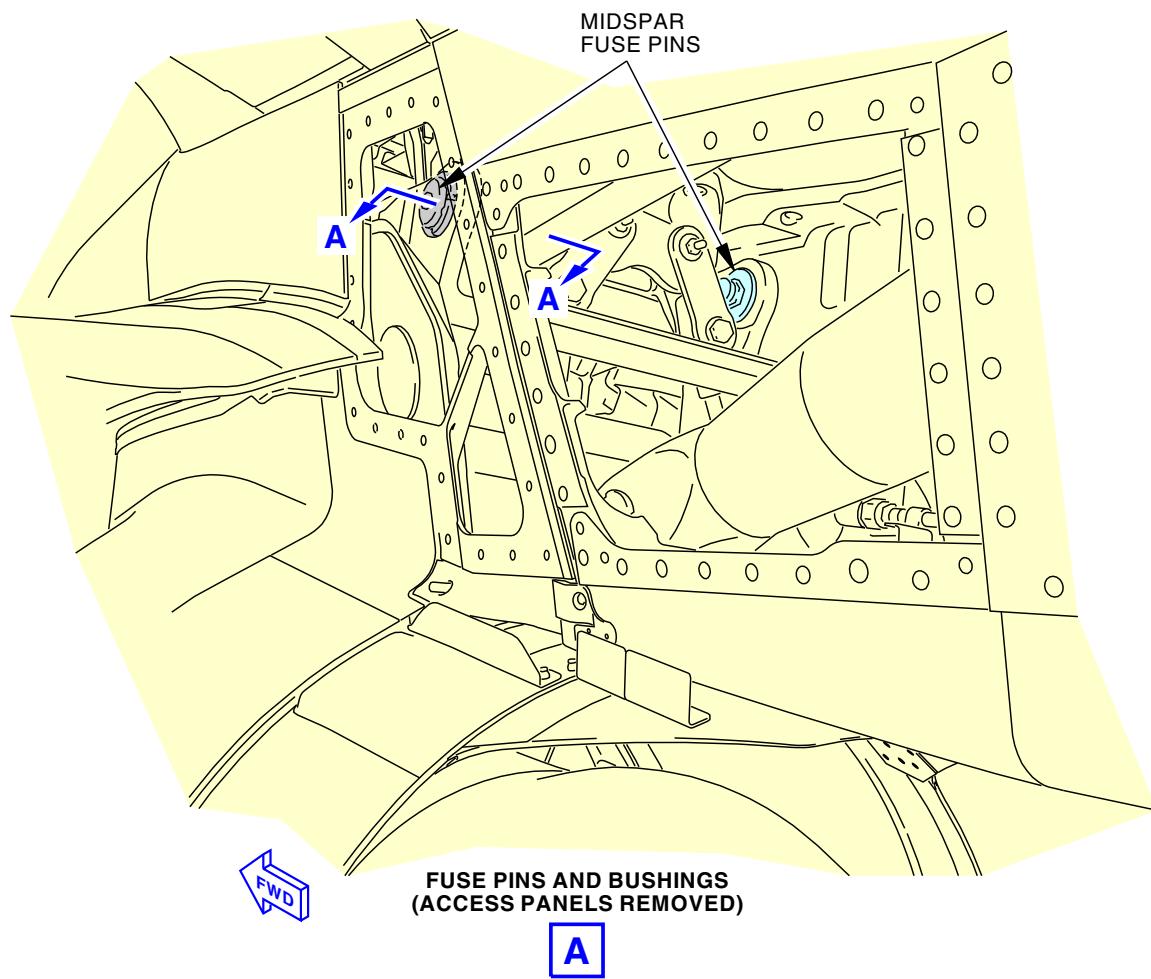
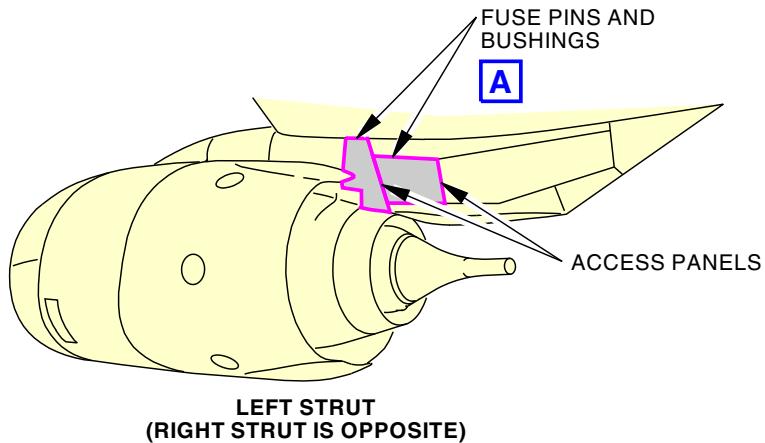
EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-78-1089

54-51-02

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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2084213 S0000437979_V2

Midspar Examination
Figure 601/54-51-02-990-811 (Sheet 2 of 3)

EFFECTIVITY
 LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
 407, 411, 412, 415, 416, 420, 422-426 POST SB
 737-78-1089

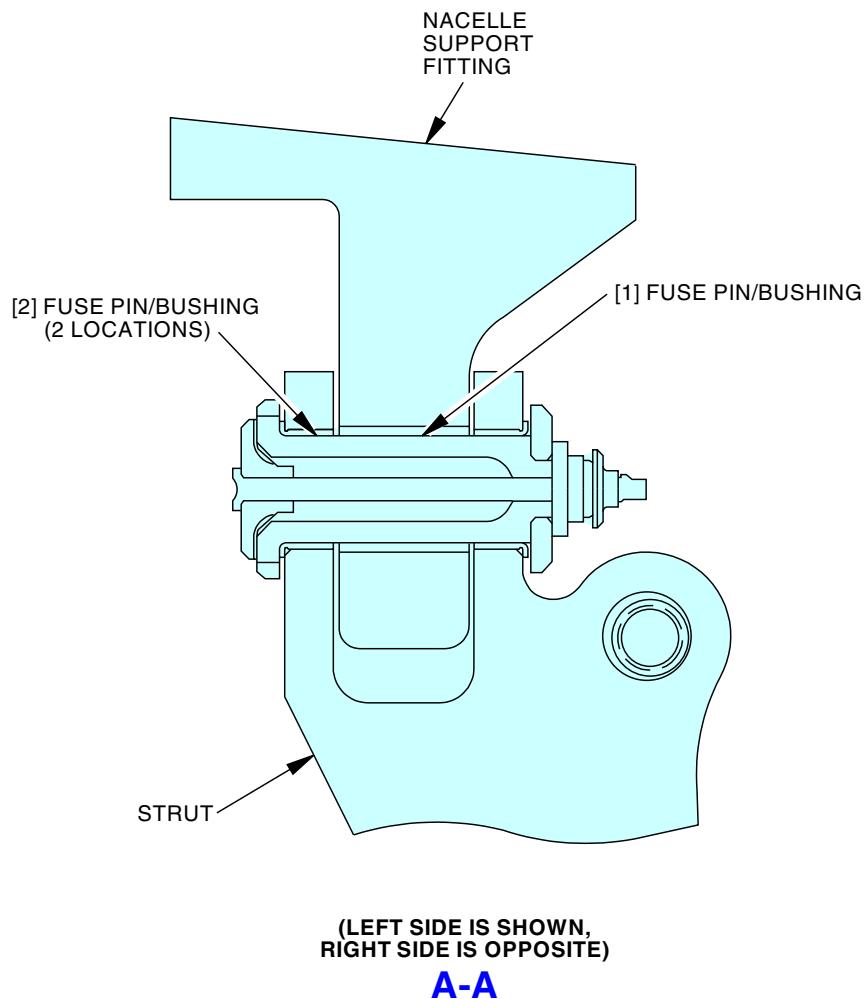
54-51-02

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details



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H00901 S0006581118_V2

Midspar Examination
Figure 601/54-51-02-990-811 (Sheet 3 of 3)

EFFECTIVITY
LOM ALL

54-51-02

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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UPPER LINK - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) A removal of the upper link,
 - (2) An installation of the upper link,
 - (3) A removal of the upper link forward or aft fuse pin,
 - (4) An installation of the upper link forward or aft fuse pin,

TASK 54-51-03-000-801

2. Upper Link Removal

(Figure 401, Figure 402 or Figure 403, Figure 404 or Figure 405)

A. References

Reference	Title
54-51-01-040-801	Prepare the Strut for Maintenance Operations (P/B 201)
54-51-01-580-801	Support the Strut with the Engine Installed (P/B 201)
54-51-01-580-803	Support the Strut with the Engine Removed (P/B 201)
54-52-03-010-801	Wing Junction Fairing - Removal (P/B 401)

B. Location Zones

Zone	Area
410	Subzone - Engine 1
420	Subzone - Engine 2
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

C. Access Panels

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

D. Prepare for the Removal

SUBTASK 54-51-03-040-001

- (1) Do this task: Prepare the Strut for Maintenance Operations, TASK 54-51-01-040-801.

SUBTASK 54-51-03-010-001

- (2) To get access to the upper link aft and forward fuse pins, do this step(TASK 54-52-03-010-801):

Open the applicable access panels:

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

SUBTASK 54-51-03-980-001

- (3) Do one of these following procedures, as applicable:

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LOM ALL

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- (a) Do this task: Support the Strut with the Engine Installed, TASK 54-51-01-580-801.
- (b) Do this task: Support the Strut with the Engine Removed, TASK 54-51-01-580-803.

E. Upper Link Removal

SUBTASK 54-51-03-020-002

- (1) Carefully remove the upper link [1] from the strut.

————— END OF TASK ————

TASK 54-51-03-400-801

3. Upper Link Installation

(Figure 401, Figure 402 or Figure 403, Figure 404 or Figure 405)

A. References

Reference	Title
54-51-01-440-801	Put the Strut Back to its Usual Condition (P/B 201)
54-51-01-580-802	Remove Support from the Strut with the Engine Installed (P/B 201)
54-51-01-580-804	Remove Support from the Strut with the Engine Removed (P/B 201)
54-51-03-220-801	Upper Link Forward Fuse Pin and Bushing Examination (P/B 601)
54-51-03-220-802	Upper Link Aft Pin and Bushing Examination (P/B 601)
54-52-03-410-801	Wing Junction Fairing - Installation (P/B 401)

B. Location Zones

Zone	Area
410	Subzone - Engine 1
420	Subzone - Engine 2
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

C. Access Panels

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

D. Upper Link Installation

SUBTASK 54-51-03-200-001

- (1) Do these examinations of the upper link pins:
 - (a) Do this task: Upper Link Forward Fuse Pin and Bushing Examination, TASK 54-51-03-220-801.
 - (b) Do this task: Upper Link Aft Pin and Bushing Examination, TASK 54-51-03-220-802.



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SUBTASK 54-51-03-020-003



CAUTION

MAKE SURE THAT THE UPPER LINK IS IN THE CORRECT POSITION.
DAMAGE TO THE STRUT CAN OCCUR IF IT IS NOT IN THE CORRECT POSITION.

- (2) To install the forward or aft pin on the upper link [1], do this task: (TASK 54-51-03-400-802).

NOTE: Determine the correct installation of the upper link ramp feature as shown by the UP arrow in Figure 401

E. Put the Airplane Back to Its Usual Condition

SUBTASK 54-51-03-980-002

- (1) Do one of these applicable procedures:

- (a) Do this task: Remove Support from the Strut with the Engine Installed, TASK 54-51-01-580-802.
(b) Do this task: Remove Support from the Strut with the Engine Removed, TASK 54-51-01-580-804.

SUBTASK 54-51-03-010-002

- (2) Close the applicable 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
441CL	Forward Strut Fairing, Left Overwing Fairing, Strut 2
441CR	Forward Strut Fairing, Right Overwing Fairing, Strut 2

SUBTASK 54-51-03-440-001

- (3) Do this task: Put the Strut Back to its Usual Condition, TASK 54-51-01-440-801.

———— END OF TASK ————

TASK 54-51-03-000-802

4. Upper Link Fuse Pin Removal

(Figure 402 or Figure 403, Figure 404 or Figure 405)

A. General

- (1) This task removes the forward/aft fuse pin from the upper link.
(a) The procedure and torque values for forward and aft fuse pin removal are the same.
(2) You can remove the two upper link pins at the same time. But you may not remove any additional strut attach pin, while the upper link pins are removed. Only one link can be free at a time (unless you will remove the strut).

B. References

Reference	Title
54-51-01-040-801	Prepare the Strut for Maintenance Operations (P/B 201)
54-51-01-580-801	Support the Strut with the Engine Installed (P/B 201)
54-51-01-580-803	Support the Strut with the Engine Removed (P/B 201)
54-52-03-010-801	Wing Junction Fairing - Removal (P/B 401)

— EFFECTIVITY —
LOM ALL

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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-2020	Kit - Fuse Pin, Removal/Installation Part #: C54009-27 Supplier: 81205
STD-6213	Wrench - Torque, 300 lb-in

D. Consumable Materials

Reference	Description	Specification
D00633	Grease - Aircraft General Purpose	BMS3-33

E. Location Zones

Zone	Area
410	Subzone - Engine 1
420	Subzone - Engine 2
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

F. Access Panels

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

G. Prepare for the Removal

SUBTASK 54-51-03-040-002

- (1) Do this task: Prepare the Strut for Maintenance Operations, TASK 54-51-01-040-801.

SUBTASK 54-51-03-010-003

- (2) To get access to the upper link forward fuse pin, do this step (TASK 54-52-03-010-801):

Open these access panels:

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

H. Forward/Aft Fuse Pin Removal

LOM ALL; AIRPLANES WITH BOLT PN 311A2097

SUBTASK 54-51-03-000-003

- (1) To remove the forward pin assembly, do the steps that follow.
- Push the pawl down and remove the nut [21].
 - Push the pawl down and remove the nut [24].
 - Remove the end cap [25], the bolt [22], and the end cap [23].



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LOM ALL; AIRPLANES WITH BOLT PN BACB30LE

SUBTASK 54-51-03-020-004

- (2) To remove the forward pin assembly, do the steps that follow.
 - (a) Remove the nut [21], washer [27], nut [24], and end cap [25].
 - (b) Remove the bolt [22], and end cap [23].

LOM ALL; AIRPLANES WITH BOLT PN 311A2097

SUBTASK 54-51-03-020-005

- (3) To remove the aft pin assembly, do the steps that follow.
 - (a) Push the pawl down and remove the nut [41].
 - (b) Push the pawl down and remove the nut [44].
 - (c) Remove the end cap [45].
 - (d) Remove the bolt [42], and end cap [43].

LOM ALL; AIRPLANES WITH BOLT PN BACB30LE

SUBTASK 54-51-03-020-006

- (4) To remove the aft pin assembly, do the steps that follow.
 - (a) Remove the nut [41], washer [47], nut [44], and end cap [45].
 - (b) Remove the bolt [42], and end cap [43].

LOM ALL

SUBTASK 54-51-03-000-004

- (5) If the strut will stay installed, do these steps to remove the fuse pin:
 - (a) Support the strut as follows:
 - 1) If you will remove the fuse pin with the engine installed, do this task: Support the Strut with the Engine Installed, TASK 54-51-01-580-801.
 - 2) If you will remove the fuse pin with the engine removed, do this task: Support the Strut with the Engine Removed, TASK 54-51-01-580-803.



MAKE SURE ALL THE DIAGONAL BRACE PINS AND MIDSPAR FUSE PINS ARE INSTALLED. DAMAGE TO THE STRUCTURE CAN OCCUR.

- | (b) Use the torque wrench, STD-6213, and the adapter fuse pin kit, SPL-2020, to make sure the fuse pin turns easily.
 - 1) When the load is correctly removed, the fuse pin will turn with 125 in-lb (14 N·m) maximum torque.



MAKE SURE YOU USE A BRASS SLUG TO PUSH OUT THE FUSE PIN. IF YOU DO NOT USE A BRASS SLUG, THE CLEVIS MAY NOT STAY ALIGNED WITH THE LUG. DAMAGE TO THE BUSHINGS OR STRUCTURE CAN OCCUR.

- | (c) Use a brass slug from the pin removal fuse pin kit, SPL-2020, with grease, D00633, to push out the fuse pin [26] or pin [46].

NOTE: Make sure the clevis and the flange stay aligned.

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LOM ALL

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- 1) Keep the support load on the strut until you install a fuse pin at this location.

NOTE: The hydraulic system in the crane can bleed which can cause the load to change.

SUBTASK 54-51-03-000-005

- (6) If you will remove the strut, do this step to remove the fuse pin:
 - (a) Do this task: Support the Strut with the Engine Removed, TASK 54-51-01-580-803.
 - (b) Use the torque wrench, STD-6213, and the adapter fuse pin kit, SPL-2020, to make sure the fuse pin turns easily.
 - 1) When the load is correctly removed, the fuse pin will turn with 125 in-lb (14 N·m) maximum torque.
 - (c) Use the pin removal fuse pin kit, SPL-2020, to remove the fuse pin [26] or pin [46].

———— END OF TASK ————

TASK 54-51-03-400-802

5. Upper Link Fuse Pin Installation

(Figure 402 or Figure 403)

A. General

- (1) This task installs the forward/aft fuse pin to the upper link.

B. References

Reference	Title
51-00-53	CORROSION REMOVAL
54-51-01-440-801	Put the Strut Back to its Usual Condition (P/B 201)
54-51-01-580-802	Remove Support from the Strut with the Engine Installed (P/B 201)
54-51-01-580-804	Remove Support from the Strut with the Engine Removed (P/B 201)
54-51-03-220-801	Upper Link Forward Fuse Pin and Bushing Examination (P/B 601)
54-52-03-410-801	Wing Junction Fairing - Installation (P/B 401)

C. Tools/Equipment

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

Reference	Description
SPL-2020	Kit - Fuse Pin, Removal/Installation Part #: C54009-27 Supplier: 81205

D. Consumable Materials

Reference	Description	Specification
D00006	Compound - Antiseize, Pure Nickel Special - Never-Seez NSBT-8N/-16N	
D00633	Grease - Aircraft General Purpose	BMS3-33

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LOM ALL

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E. Location Zones

Zone	Area
410	Subzone - Engine 1
420	Subzone - Engine 2
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

F. Access Panels

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

G. Fuse Pin Installation

LOM ALL; AIRPLANES WITH BOLT PN 311A2097

SUBTASK 54-51-03-210-001

- (1) Do this task: Upper Link Forward Fuse Pin and Bushing Examination, TASK 54-51-03-220-801.
 - (a) Do a check that the fuse pin [26], end cap [25], nut [21], end cap [23], bolt [22], and nut [24] are free from corrosion.
 - (b) Do a check that the pin [46], end cap [45], nut [44], end cap [43], bolt [42], and nut [41] are free from corrosion.
 - (c) Include the interior of the fuse pin.

LOM ALL; AIRPLANES WITH BOLT PN BACB30LE

SUBTASK 54-51-03-210-003

- (2) Do this task: Upper Link Forward Fuse Pin and Bushing Examination, TASK 54-51-03-220-801.
 - (a) Do a check that the fuse pin [26], washer [27], end cap [25], nut [24], end cap [23], bolt [22], and nut [21] are free from corrosion.
 - (b) Do a check that the pin [46], washer [47], end cap [45], nut [44], end cap [43], bolt [42], and nut [41] are free from corrosion.
 - (c) Include the interior of the fuse pin.

LOM ALL

SUBTASK 54-51-03-210-002

- (3) If you removed the upper link, make sure the interior of the bushings at the installation fittings are free from corrosion.

SUBTASK 54-51-03-300-003

- (4) Do these steps if you find corrosion:
 - (a) To remove corrosion, refer to the CORROSION REMOVAL, SUBJECT 51-00-53.
 - (b) To repair or replace the corroded part, contact Boeing for corrective action.

SUBTASK 54-51-03-400-003

- (5) If you did not remove the strut, install the fuse pin [26] or pin [46] as follows:
 - (a) Make sure that the brass slug is unloaded.

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LOM ALL

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- (b) Apply a thin layer of grease, D00633, to the fuse pin to be installed.
- (c) Use the pin installation fuse pin kit, SPL-2020, to push out the brass slug with the fuse pin [26] or pin [46].
 - 1) For the left strut, put the head of the forward fuse pin [26] on the inboard side of the installation fitting.
 - 2) For the right strut, put the head of the forward fuse pin [26] on the outboard side of the installation fitting.
 - 3) Put the head of the pin [46] on the inboard side of the installation fitting for both the left and right struts.

SUBTASK 54-51-03-400-004

- (6) If you removed the strut, install the fuse pin [26] or pin [46] as follows:
 - (a) Apply a thin layer of grease, D00633, to the fuse pin to be installed.
 - (b) Use the pin installation fuse pin kit, SPL-2020, to install the fuse pin [26] or pin [46].
 - 1) For the left strut, put the head of the forward fuse pin [26] on the inboard side of the installation fitting.
 - 2) For the right strut, put the head of the forward fuse pin [26] on the outboard side of the installation fitting.
 - 3) Put the head of the aft pin [46] on the inboard side of the installation fitting for both left and right struts.

LOM ALL; AIRPLANES WITH BOLT PN 311A2097

SUBTASK 54-51-03-400-005

- (7) Install these parts on the forward fitting.
 - (a) Install the end cap [23] to the bolt [22].
 - (b) Install the end cap [23] and bolt [22] to the fuse pin [26].
 - 1) For the left strut, put the head of the bolt [22] on the inboard side of the installation fitting.
 - 2) For the right strut, put the head of the bolt [22] on the outboard side of the installation fitting.
 - (c) Install the end cap [25].
 - (d) Install the nut [24].
 - 1) Apply Pure Nickel Special compound, D00006, to the threads of the nut [24].
 - 2) Do a check of the run-on torque of the nut [24].
 - a) If the run-on torque is not 70 in-lb (8 N·m) to 600 in-lb (68 N·m), replace the nut [24] and do the check again.
 - 3) Tighten the nut [24] to 800 in-lb (90 N·m) to 1000 in-lb (113 N·m).
 - (e) Install the nut [21].
 - 1) Apply Pure Nickel Special compound, D00006, to the threads of the nut [21].
 - 2) Do a check of the run-on torque of the nut [21].
 - a) If the run-on torque is not 9.50 in-lb (1.07 N·m) to 80.00 in-lb (9.04 N·m), replace the nut [21] and do the check again.
 - 3) Tighten the nut [21].

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LOM ALL

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LOM ALL; AIRPLANES WITH BOLT PN 311A2097 (Continued)

- a) If the torque is applied to the nut side, tighten the nut [21] to 150 in-lb (17 N·m) to 200 in-lb (23 N·m).
- b) If the torque is applied to the bolt side, tighten the bolt [22] to 165 in-lb (19 N·m) to 220 in-lb (25 N·m).
- (f) Make sure that the spring loaded pawl on the bolt fully extends after the nut is tightened.

LOM ALL; AIRPLANES WITH BOLT PN BACB30LE

SUBTASK 54-51-03-420-001

- (8) Install these parts on the forward fitting.
 - (a) Install the end cap [23] to the bolt [22].
 - (b) Install the end cap [23] and bolt [22] to the fuse pin [26].
 - 1) For the left strut, put the head of the bolt [22] on the inboard side of the installation fitting.
 - 2) For the right strut, put the head of the bolt [22] on the outboard side of the installation fitting.
 - (c) Install the end cap [25].
 - (d) Install the nut [24].
 - 1) Apply Pure Nickel Special compound, D00006, to the threads of the nut [24].
 - 2) Do a check of the run-on torque of the nut [24].
 - a) If the run-on torque is not 70 in-lb (8 N·m) to 600 in-lb (68 N·m), replace the nut [24] and do the check again.
 - 3) Tighten the nut [24] to 800 in-lb (90 N·m) to 1000 in-lb (113 N·m).
 - (e) Install the washer [27].
 - (f) Install the nut [21].
 - 1) Do a check of the run-on torque of the nut [21].
 - a) If the run-on torque is not 9.50 in-lb (1.07 N·m) to 80.00 in-lb (9.04 N·m), replace the nut [21] and do the check again.
 - 2) Tighten the nut [21].
 - a) If the torque is applied to the nut side, tighten the nut [21] to 150 in-lb (17 N·m) to 200 in-lb (23 N·m).
 - b) If the torque is applied to the bolt side, tighten the bolt [22] to 165 in-lb (19 N·m) to 220 in-lb (25 N·m).

LOM ALL; AIRPLANES WITH BOLT PN 311A2097

SUBTASK 54-51-03-420-002

- (9) Install these parts on the aft fitting.
 - (a) Install the end cap [43] on the bolt [42].
 - (b) Install the bolt [42] and end cap [43] on the pin [46].
 - 1) For the left and right struts, put the head of the bolt [42] on the inboard side of the installation fitting.
 - (c) Install the end cap [45].
 - (d) Install the nut [44].

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LOM ALL

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LOM ALL; AIRPLANES WITH BOLT PN 311A2097 (Continued)

- 1) Apply Pure Nickel Special compound, D00006, to the threads of the nut [44].
 - 2) Do a check of the run-on torque of the nut [44].
 - a) If the run-on torque is not 70 in-lb (8 N·m) to 600 in-lb (68 N·m), replace the nut and do the check again.
 - 3) Tighten the nut [44] to 800 in-lb (90 N·m) to 1000 in-lb (113 N·m).
- (e) Install the nut [41].
- 1) Apply Pure Nickel Special compound, D00006, to the threads of the nut [41].
 - 2) Do a check of the run-on torque of the nut [41].
 - a) If the run-on torque is not 9.50 in-lb (1.07 N·m) to 80.00 in-lb (9.04 N·m), replace the nut and do the check again.
 - 3) Tighten the nut [41].
 - a) If the torque is applied to the nut side, tighten the nut [41] to 150 in-lb (17 N·m) to 200 in-lb (23 N·m).
 - b) If the torque is applied to the bolt side, tighten the bolt [42] to 165 in-lb (19 N·m) to 220 in-lb (25 N·m).
- (f) Make sure that the spring loaded pawl on the bolt fully extends after the nut is tightened.

LOM ALL; AIRPLANES WITH BOLT PN BACB30LE

SUBTASK 54-51-03-420-003

- (10) Install these parts on the aft fitting.
- (a) Install the end cap [43] on the bolt [42].
 - (b) Install the bolt [42] and end cap [43] on the pin [46].
 - 1) For the left and right struts, put the head of the bolt [42] on the inboard side of the installation fitting.
 - (c) Install the end cap [45].
 - (d) Install the nut [44].
- 1) Apply Pure Nickel Special compound, D00006, to the threads of the nut [44].
- 2) Do a check of the run-on torque of the nut [44].
 - a) If the run-on torque is not 70 in-lb (8 N·m) to 600 in-lb (68 N·m), replace the nut and do the check again.
- 3) Tighten the nut [44] to 800 in-lb (90 N·m) to 1000 in-lb (113 N·m).
- (e) Install the washer [47].
- (f) Install the nut [41].
- 1) Do a check of the run-on torque of the nut [41].
 - a) If the run-on torque is not 9.50 in-lb (1.07 N·m) to 80.00 in-lb (9.04 N·m), replace the nut and do the check again.
 - 2) Tighten the nut [41].
 - a) If the torque is applied to the nut side, tighten the nut [41] to 150 in-lb (17 N·m) to 200 in-lb (23 N·m).

EFFECTIVITY
LOM ALL

54-51-03



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AIRCRAFT MAINTENANCE MANUAL

LOM ALL; AIRPLANES WITH BOLT PN BACB30LE (Continued)

- b) If the torque is applied to the bolt side, tighten the bolt [42] to 165 in-lb (19 N·m) to 220 in-lb (25 N·m).

LOM ALL

SUBTASK 54-51-03-200-005

- (11) Make sure that all parts are firmly seated.

H. Put the Airplane Back to Its Usual Condition

SUBTASK 54-51-03-580-001

- (1) Remove the support from the strut as follows:

- (a) If you installed the fuse pin with the engine installed, do this task: Remove Support from the Strut with the Engine Installed, TASK 54-51-01-580-802.
(b) If you installed the fuse pin with the engine removed, do this task: Remove Support from the Strut with the Engine Removed, TASK 54-51-01-580-804.

SUBTASK 54-51-03-010-004

- (2) To close the access to the upper link forward fuse pin, do this task (TASK 54-52-03-410-801):

Close these access panels:

Number Name/Location

431CL	Forward Strut Fairing, Left Overwing Fairing, Strut 1
431CR	Forward Strut Fairing, Right Overwing Fairing, Strut 1
441CL	Forward Strut Fairing, Left Overwing Fairing, Strut 2
441CR	Forward Strut Fairing, Right Overwing Fairing, Strut 2

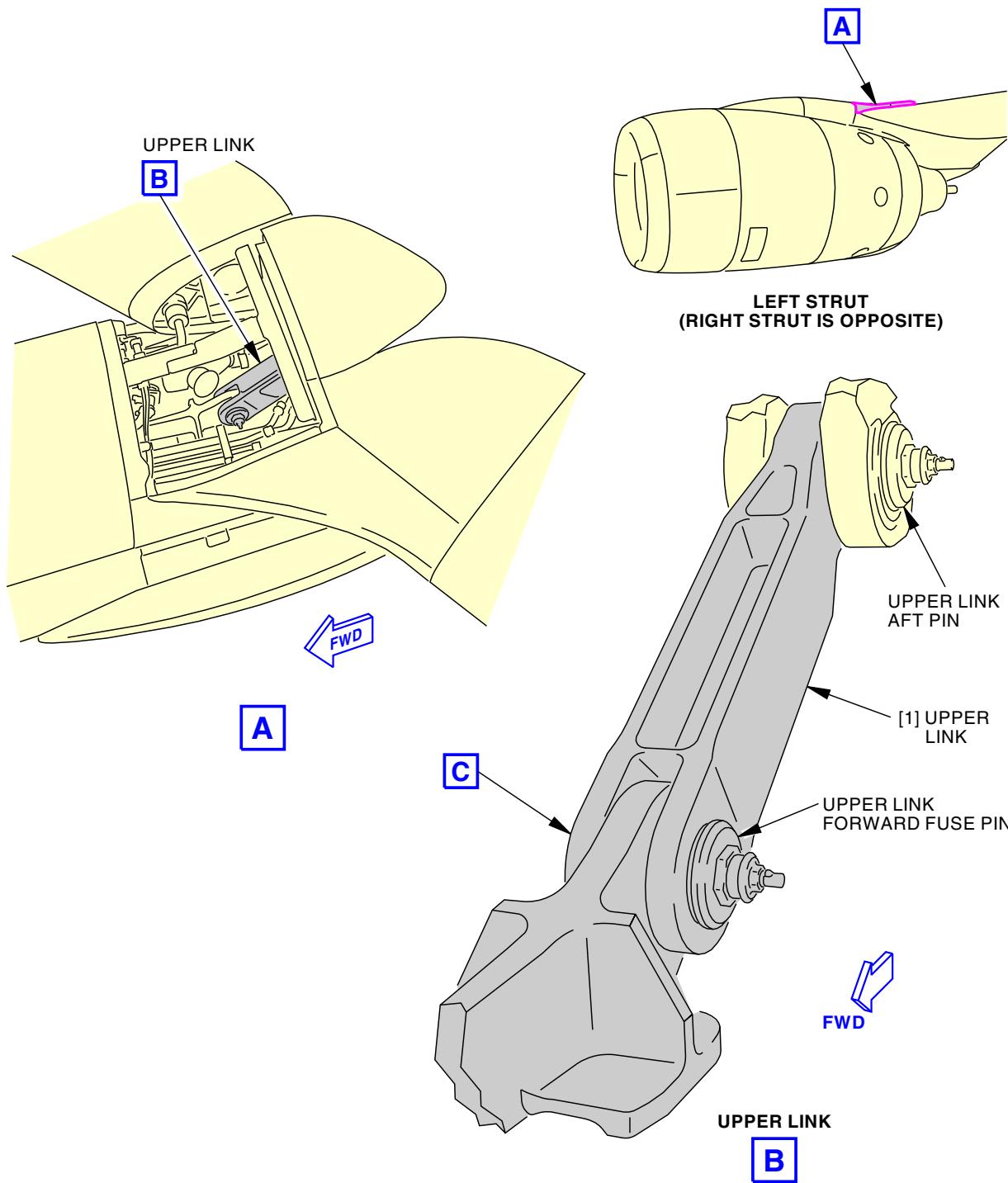
SUBTASK 54-51-03-440-002

- (3) If you will do no more maintenance operations on the strut, do this task: Put the Strut Back to its Usual Condition, TASK 54-51-01-440-801.

———— END OF TASK ————

EFFECTIVITY
LOM ALL

54-51-03



G49525 S0006581125_V3

Upper Link Installation
Figure 401/54-51-03-990-801 (Sheet 1 of 3)

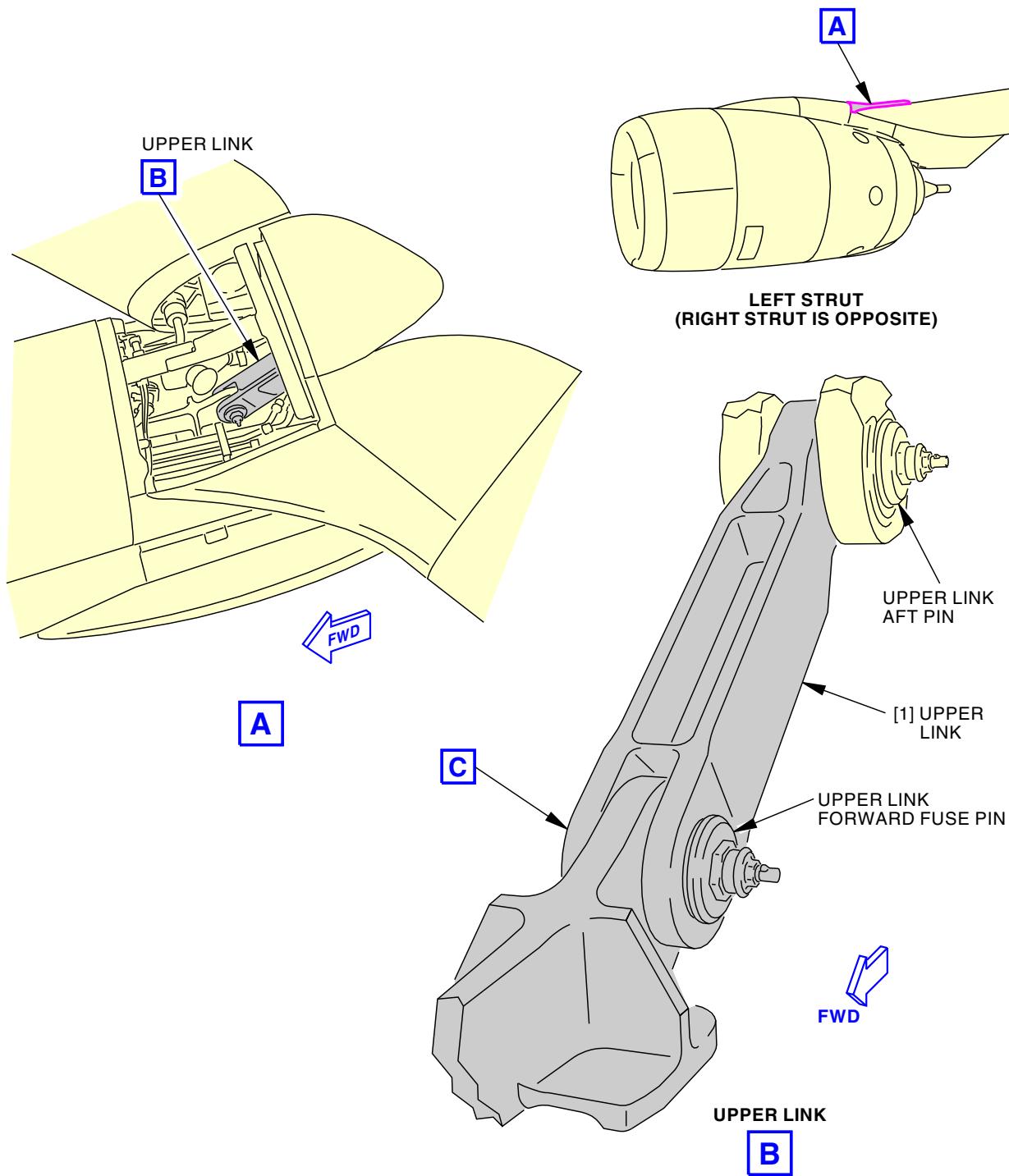
EFFECTIVITY
 LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
 422-426 PRE SB 737-78-1089

54-51-03

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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2092144 S0000442102_V2

Upper Link Installation
Figure 401/54-51-03-990-801 (Sheet 2 of 3)

EFFECTIVITY
 LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
 407, 411, 412, 415, 416, 420, 422-426 POST SB
 737-78-1089

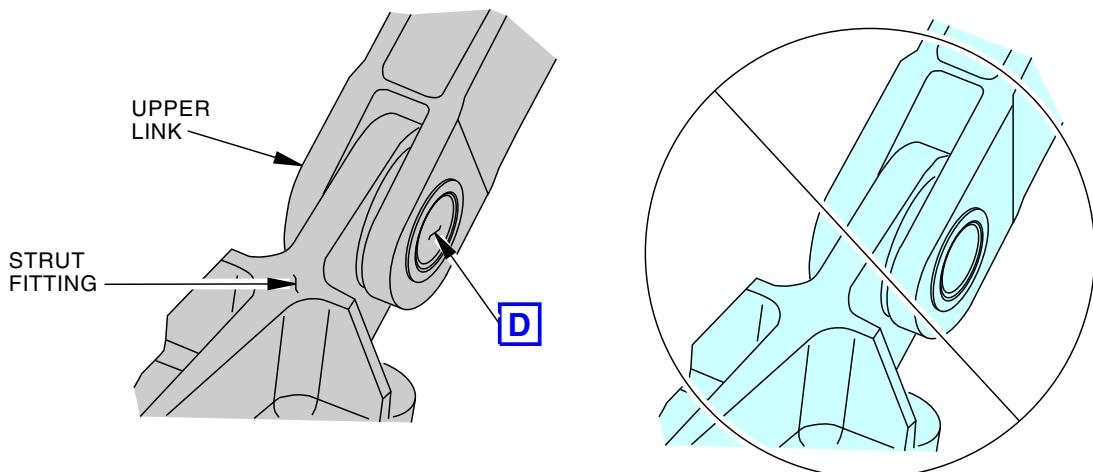
54-51-03

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D633A101-LOM



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AIRCRAFT MAINTENANCE MANUAL

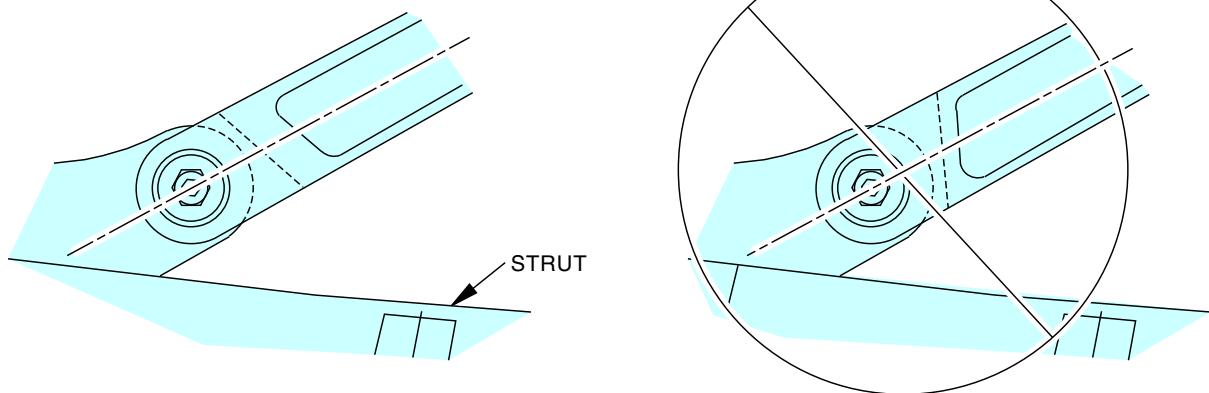


CORRECT
INSTALLATION

C

INCORRECT
INSTALLATION

D



CORRECT
INSTALLATION

D

INCORRECT
INSTALLATION

D

J15018 S0000168471_V3

Upper Link Installation
Figure 401/54-51-03-990-801 (Sheet 3 of 3)

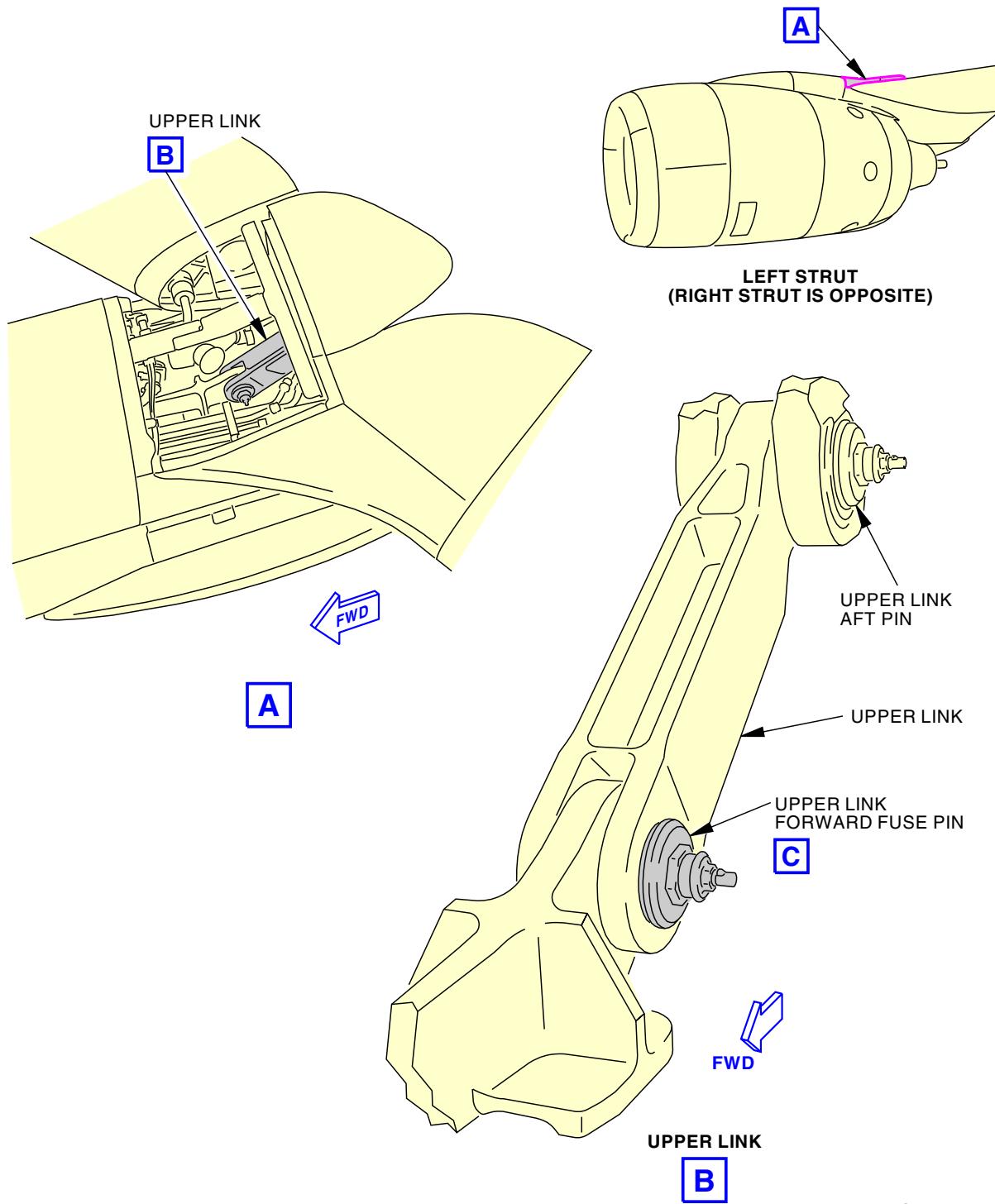
EFFECTIVITY
LOM ALL

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

54-51-03

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H09396 S0006581126_V2

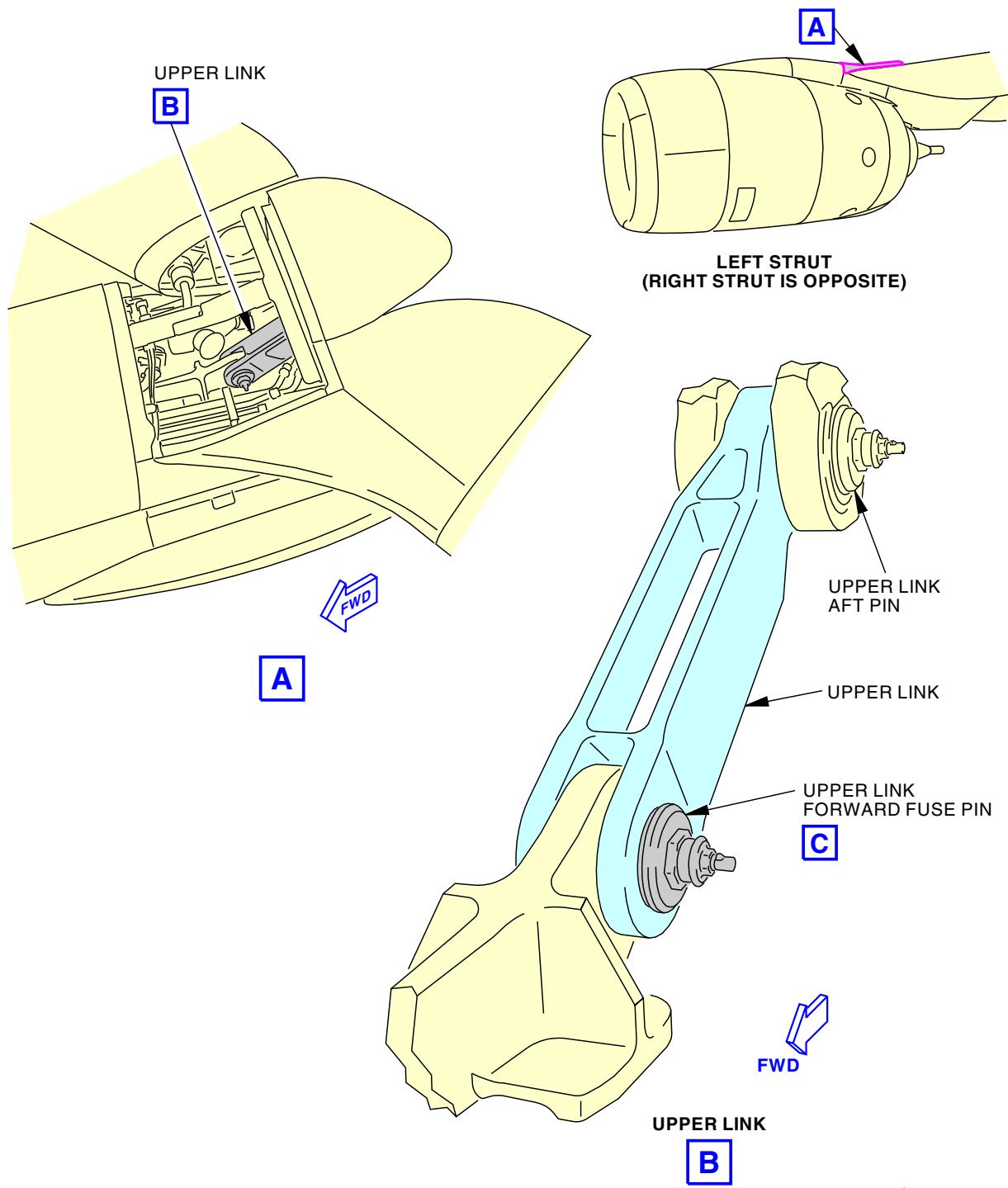
Upper Link Forward Fuse Pin Installation
Figure 402/54-51-03-990-805 (Sheet 1 of 3)

EFFECTIVITY
 LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
 422-426 PRE SB 737-78-1089

54-51-03

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details



2082479 S0000438603_V2

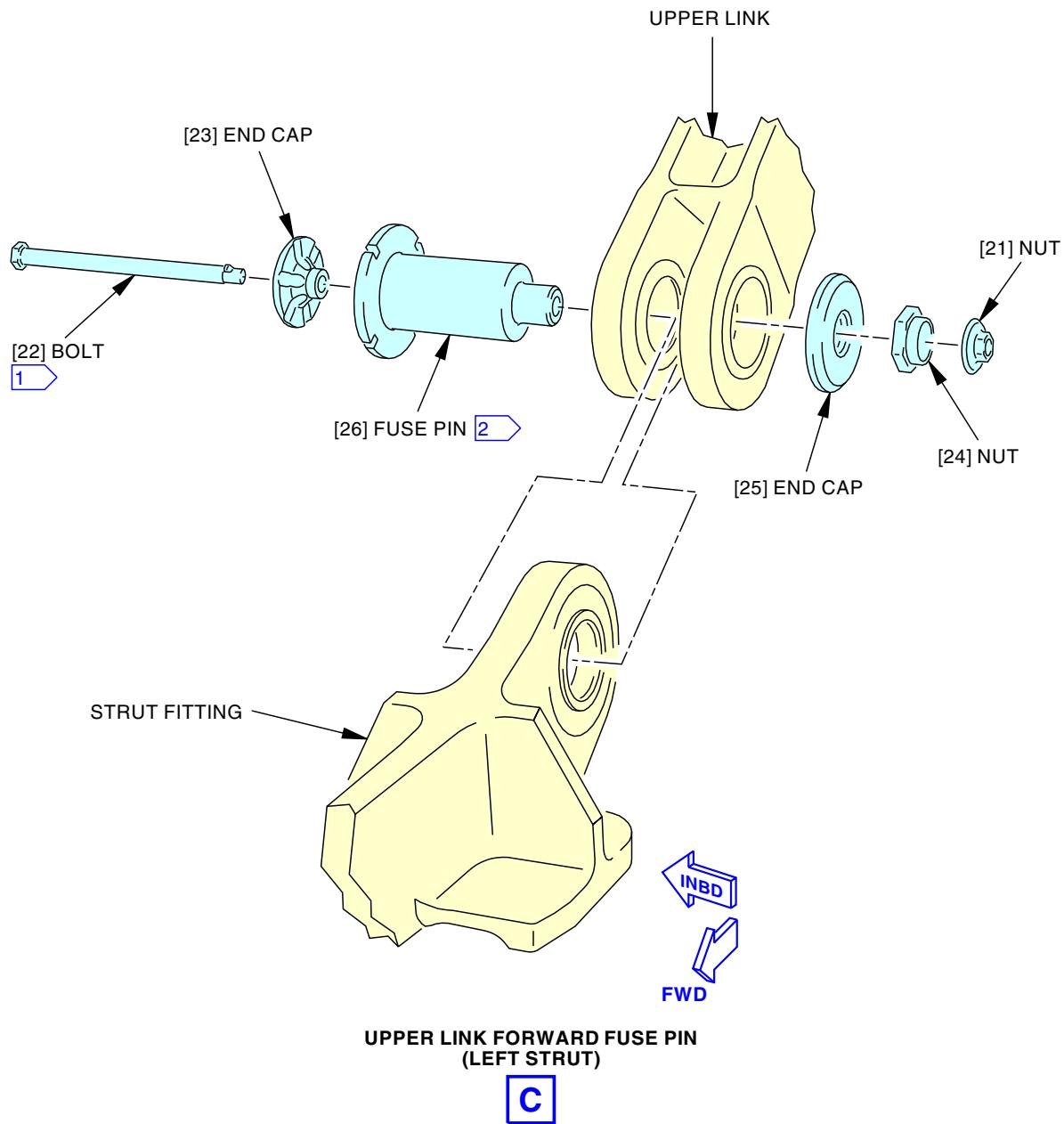
**Upper Link Forward Fuse Pin Installation
Figure 402/54-51-03-990-805 (Sheet 2 of 3)**

EFFECTIVITY
 LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
 407, 411, 412, 415, 416, 420, 422-426 POST SB
 737-78-1089

54-51-03

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details



1 BOLT MUST BE INSTALLED IN DIRECTION SHOWN.

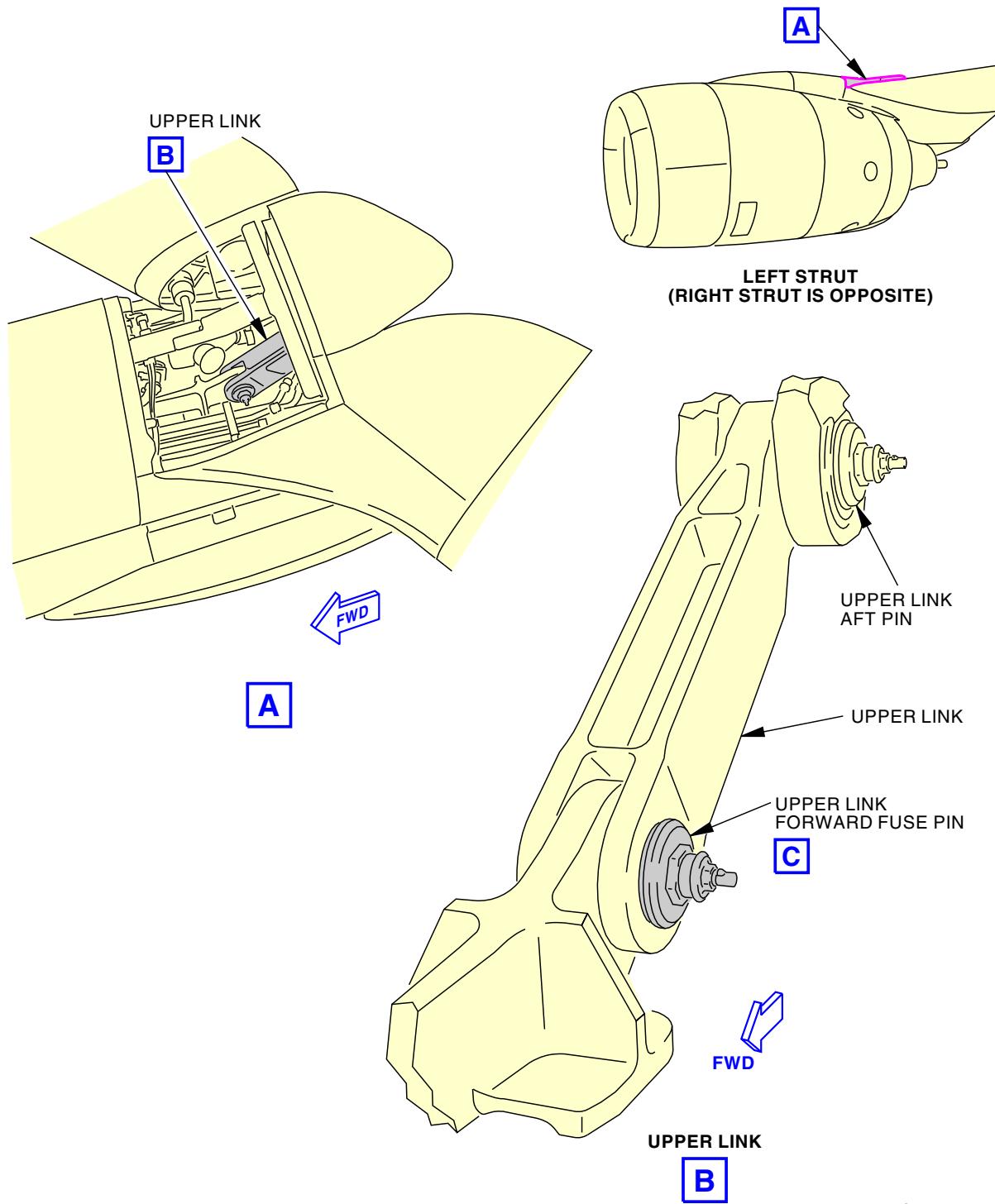
2 FOR THE RIGHT STRUT, THE HEAD OF FORWARD FUSE PIN IS PLACED ON THE OUTBOARD SIDE.

H09398 S0006581127_V4

Upper Link Forward Fuse Pin Installation
Figure 402/54-51-03-990-805 (Sheet 3 of 3)

EFFECTIVITY
LOM ALL; AIRPLANES WITH BOLT PN 311A2097

54-51-03



H09396 S0006581126_V2

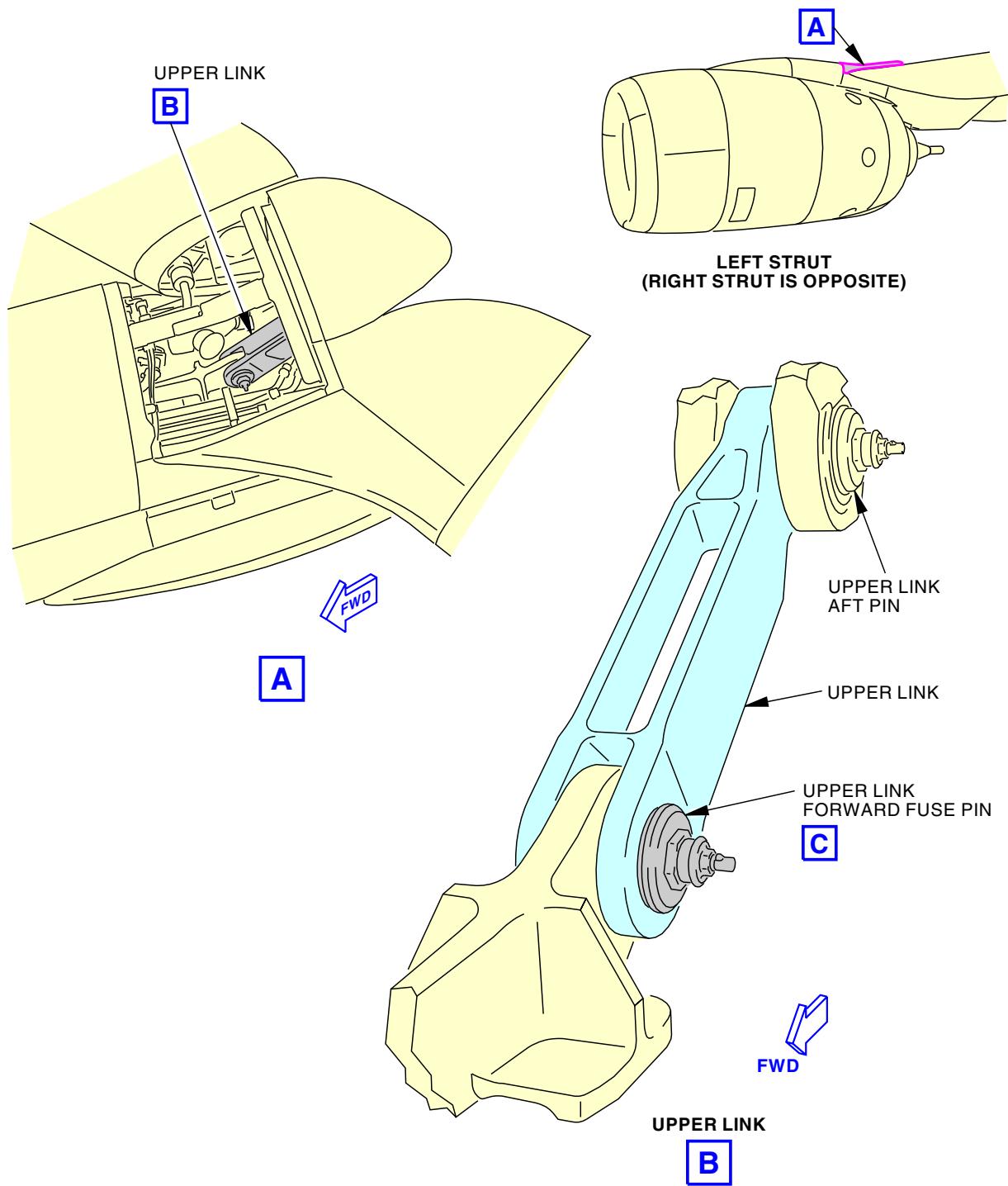
Upper Link Forward Fuse Pin Installation
Figure 403/54-51-03-990-811 (Sheet 1 of 3)

EFFECTIVITY
 LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
 422-426 PRE SB 737-78-1089

54-51-03

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details



2082479 S0000438603_V2

**Upper Link Forward Fuse Pin Installation
Figure 403/54-51-03-990-811 (Sheet 2 of 3)**

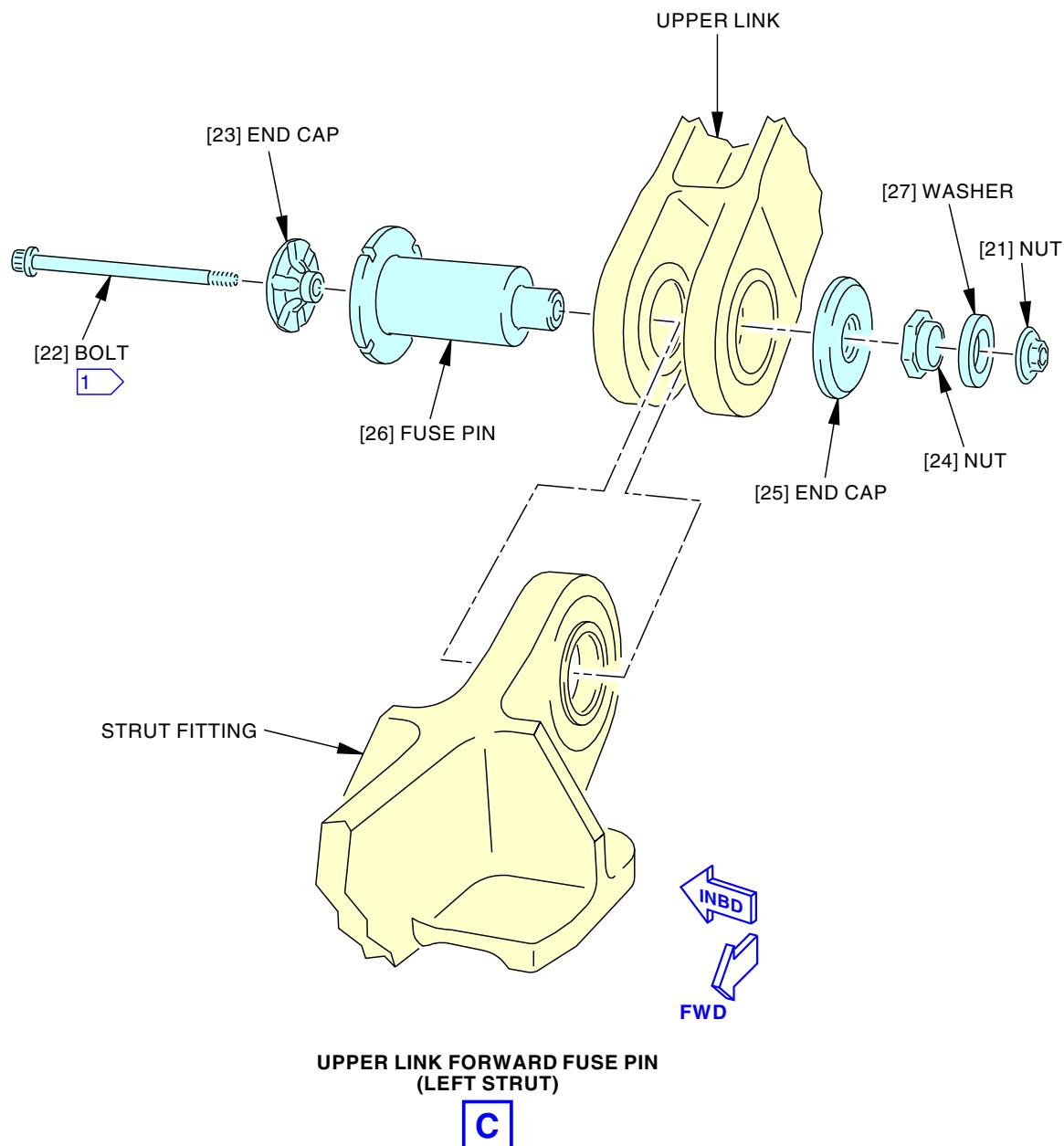
EFFECTIVITY
 LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
 407, 411, 412, 415, 416, 420, 422-426 POST SB
 737-78-1089

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D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

BOEING
737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL



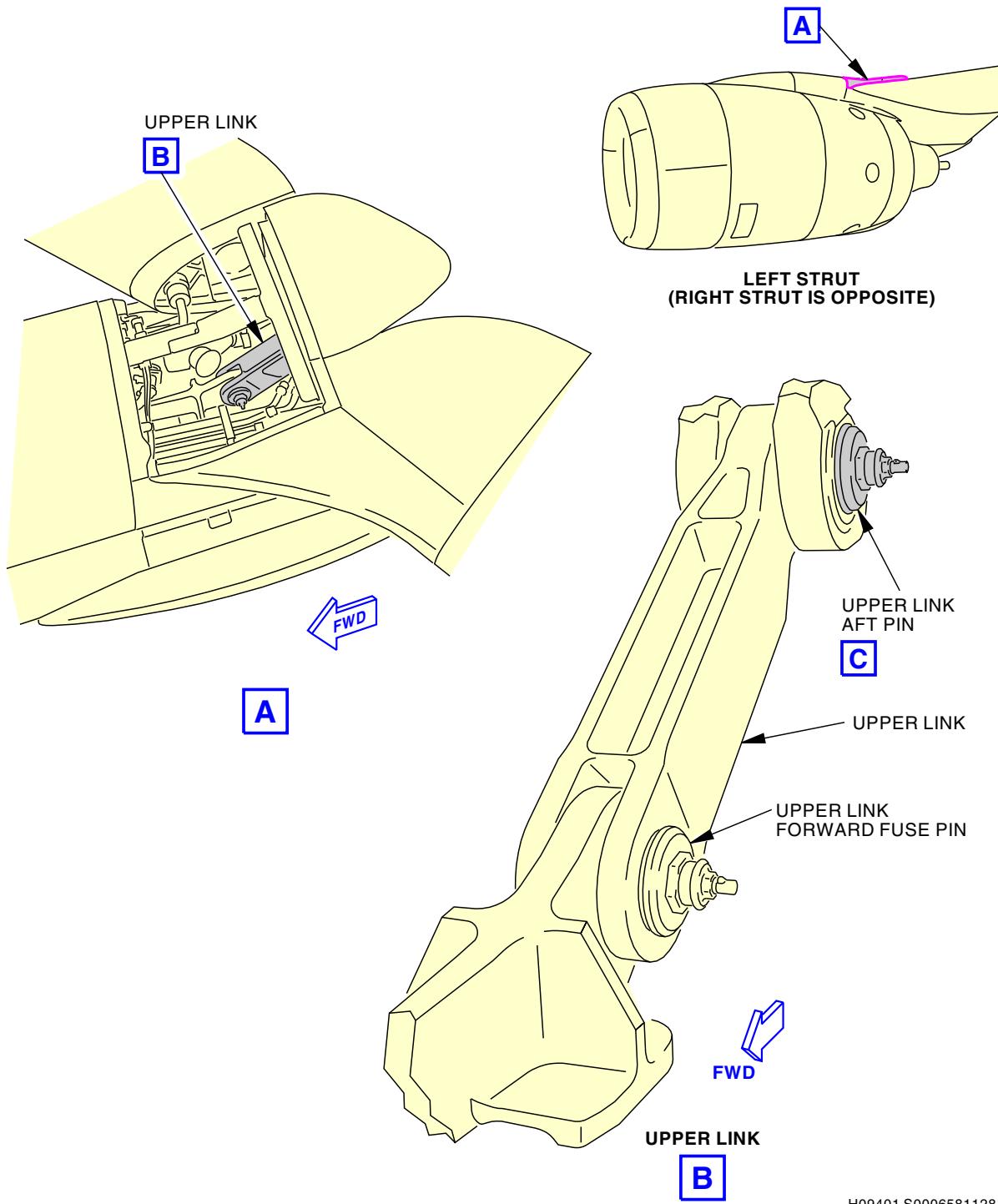
1 BOLT MUST BE INSTALLED IN DIRECTION SHOWN.

1924315 S0000362288_V2

Upper Link Forward Fuse Pin Installation
Figure 403/54-51-03-990-811 (Sheet 3 of 3)

EFFECTIVITY
 LOM ALL; AIRPLANES WITH BOLT PN BACB30LE

54-51-03



H09401 S0006581128_V2

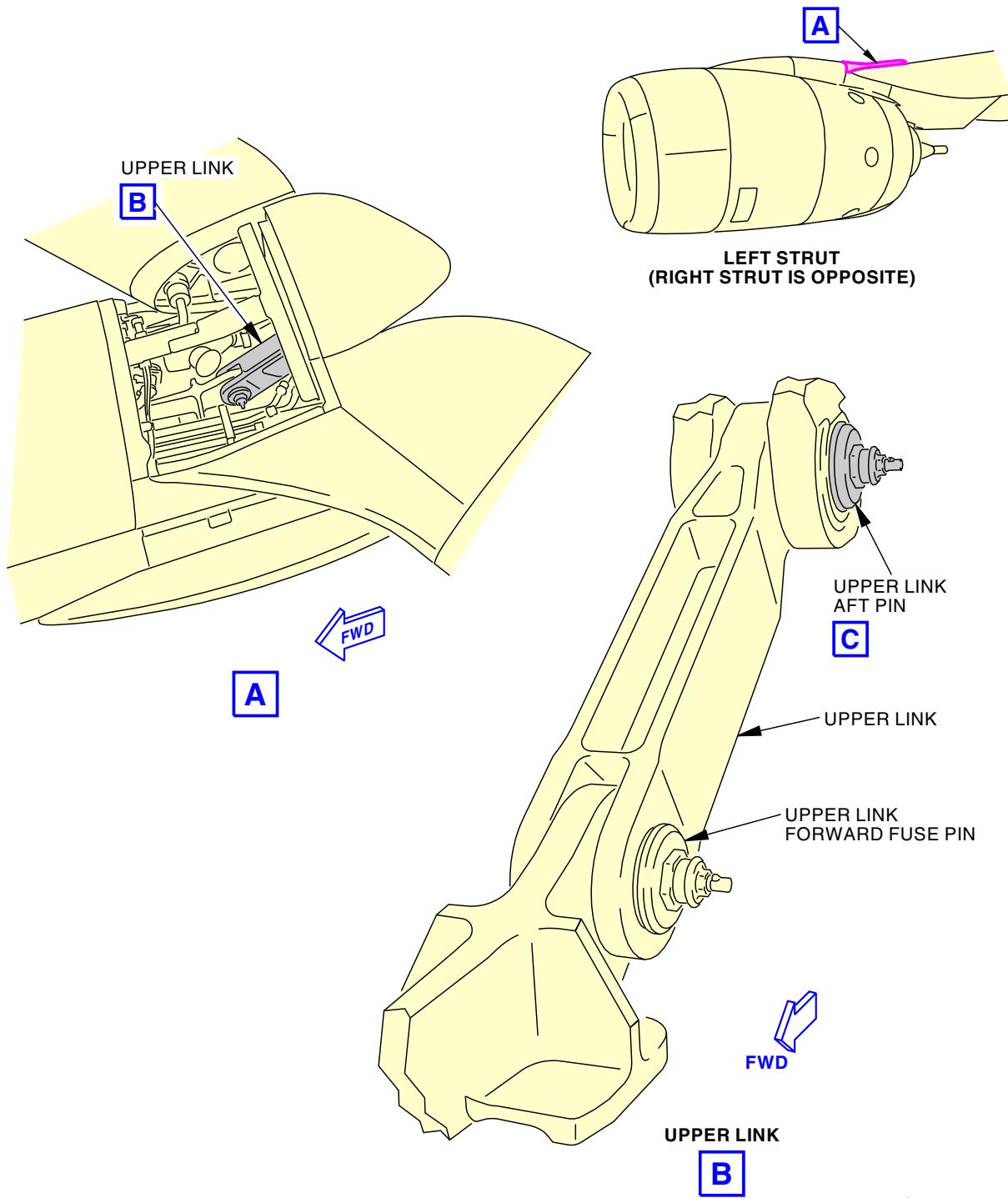
Upper Link Aft Pin Installation
Figure 404/54-51-03-990-806 (Sheet 1 of 3)

EFFECTIVITY
 LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
 422-426 PRE SB 737-78-1089

54-51-03

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details



2082546 S0000438604_V2

Upper Link Aft Pin Installation
Figure 404/54-51-03-990-806 (Sheet 2 of 3)

EFFECTIVITY
 LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
 407, 411, 412, 415, 416, 420, 422-426 POST SB
 737-78-1089

D633A101-LOM

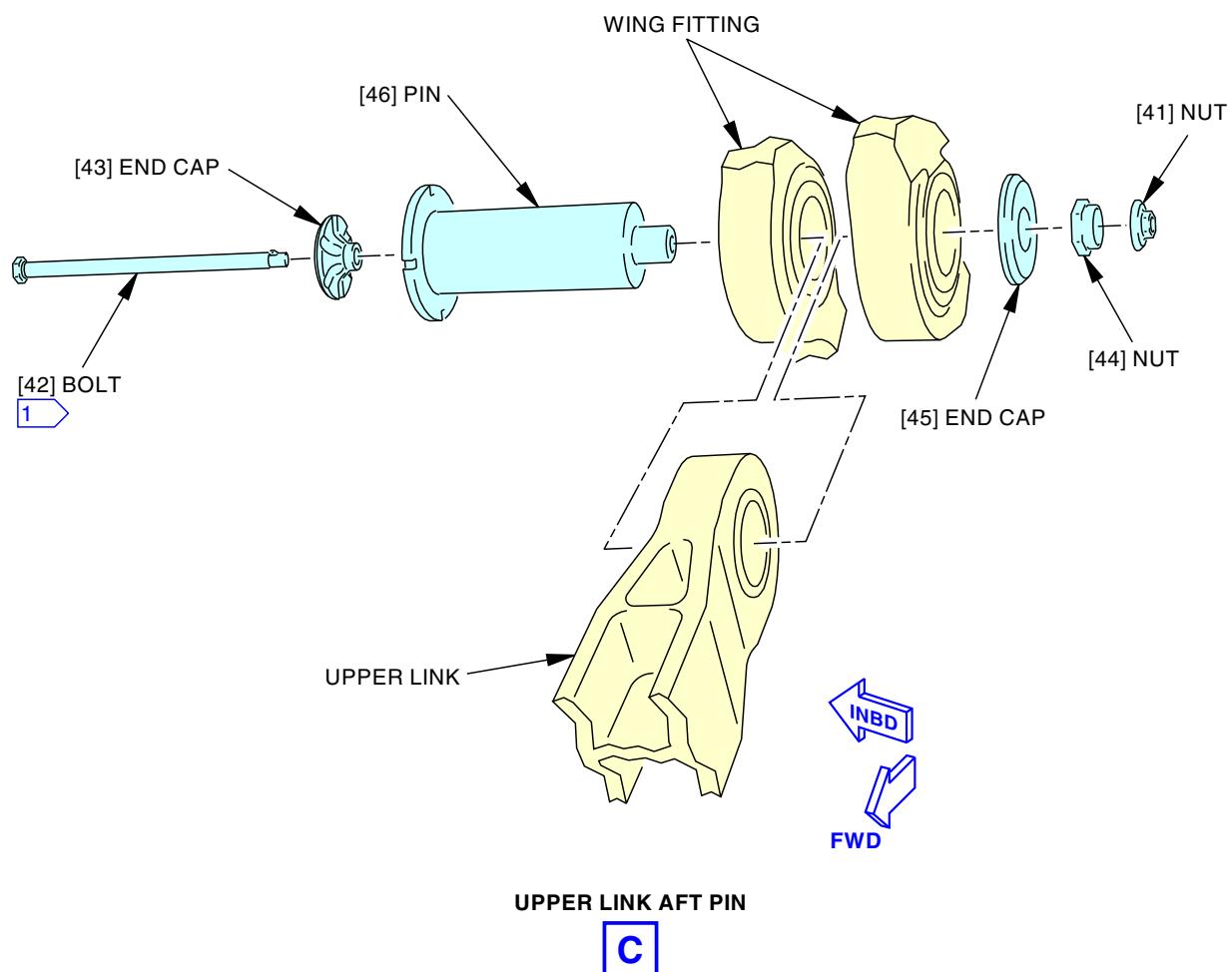
ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL



1 BOLT MUST BE INSTALLED IN DIRECTION SHOWN.

H09403 S0006581129_V4

Upper Link Aft Pin Installation
Figure 404/54-51-03-990-806 (Sheet 3 of 3)

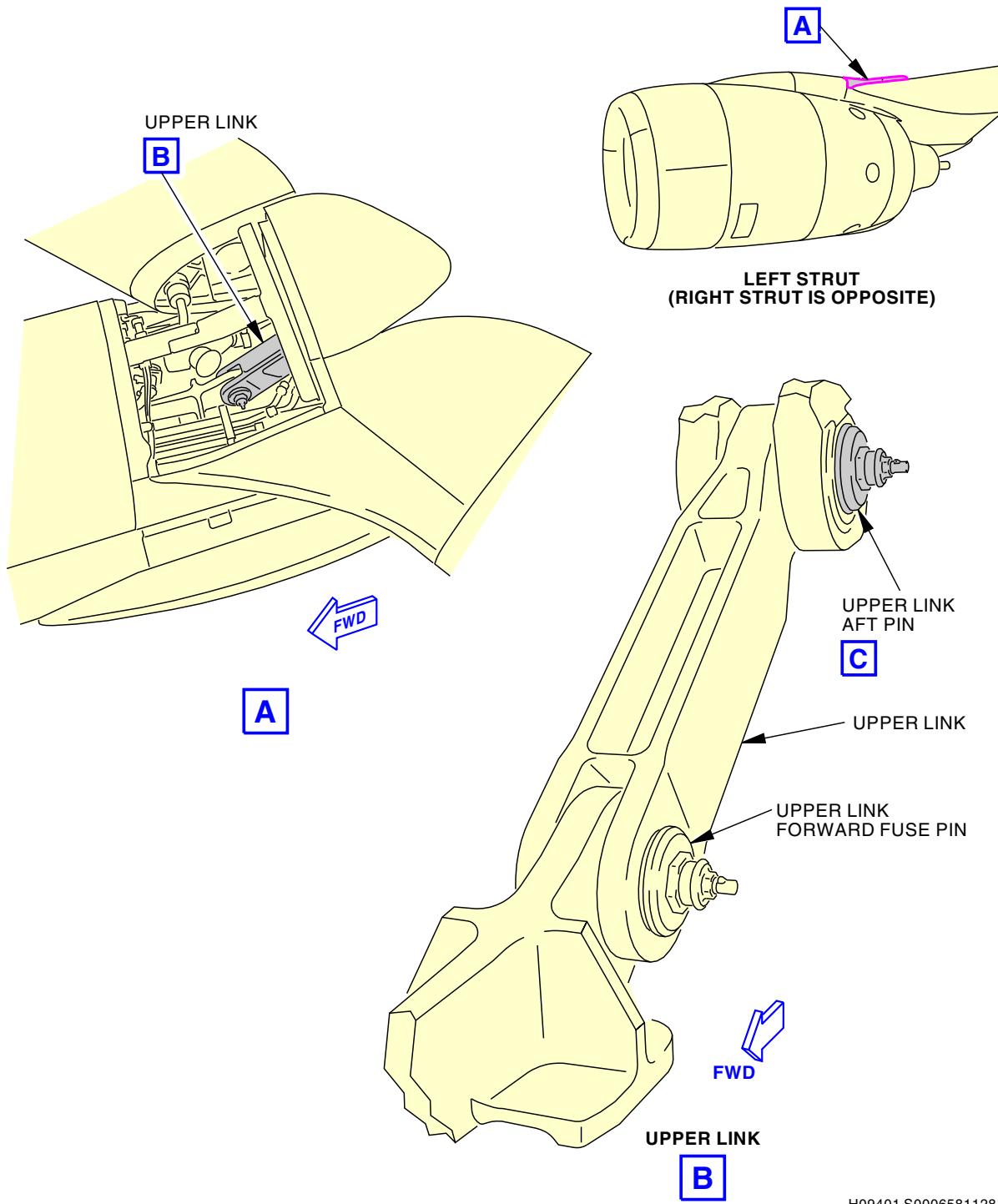
EFFECTIVITY
LOM ALL; AIRPLANES WITH BOLT PN 311A2097

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D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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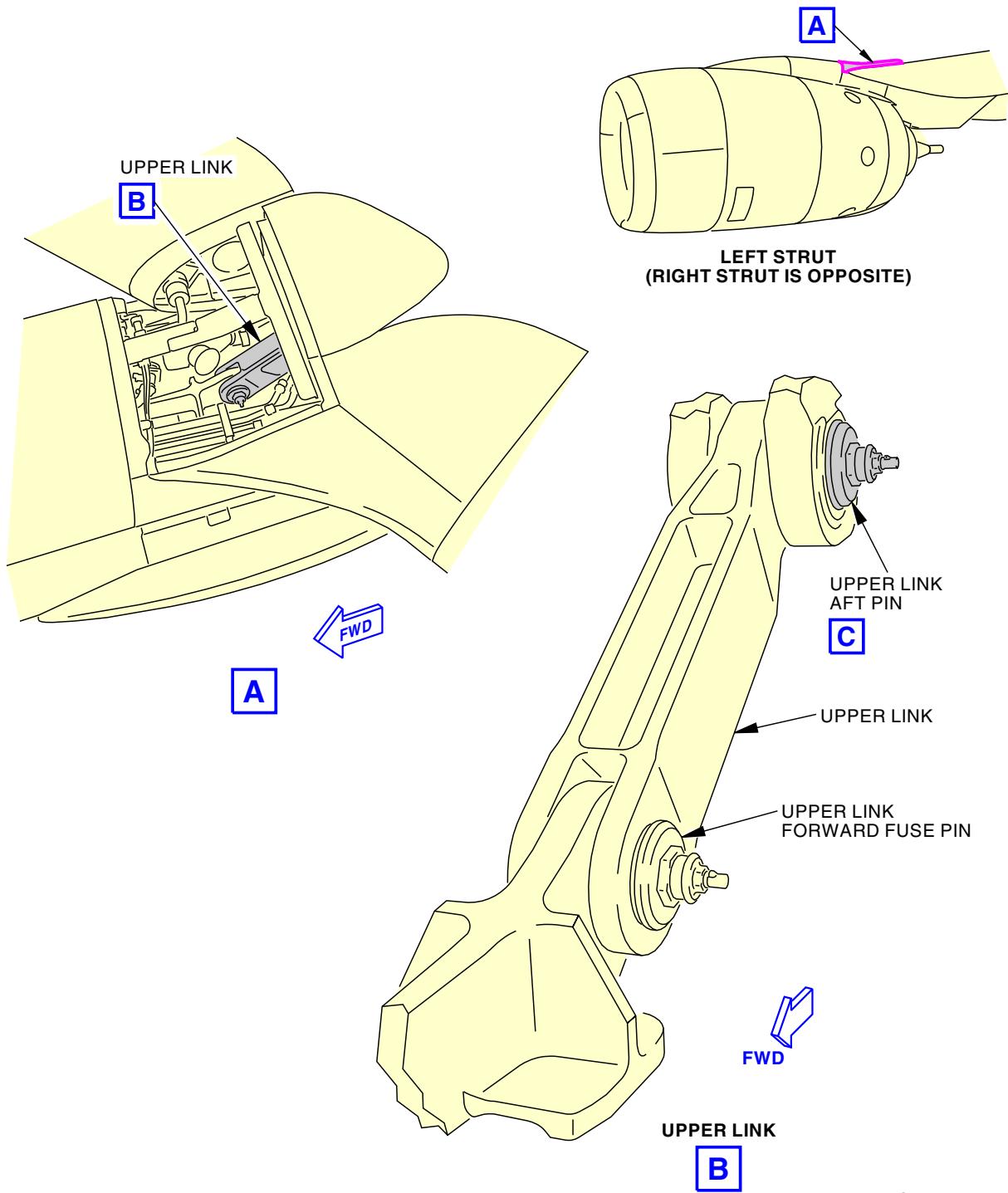
Upper Link Aft Pin Installation
Figure 405/54-51-03-990-812 (Sheet 1 of 3)

EFFECTIVITY
 LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
 422-426 PRE SB 737-78-1089

54-51-03

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details



2082546 S0000438604_V2

Upper Link Aft Pin Installation
Figure 405/54-51-03-990-812 (Sheet 2 of 3)

EFFECTIVITY
 LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
 407, 411, 412, 415, 416, 420, 422-426 POST SB
 737-78-1089

54-51-03

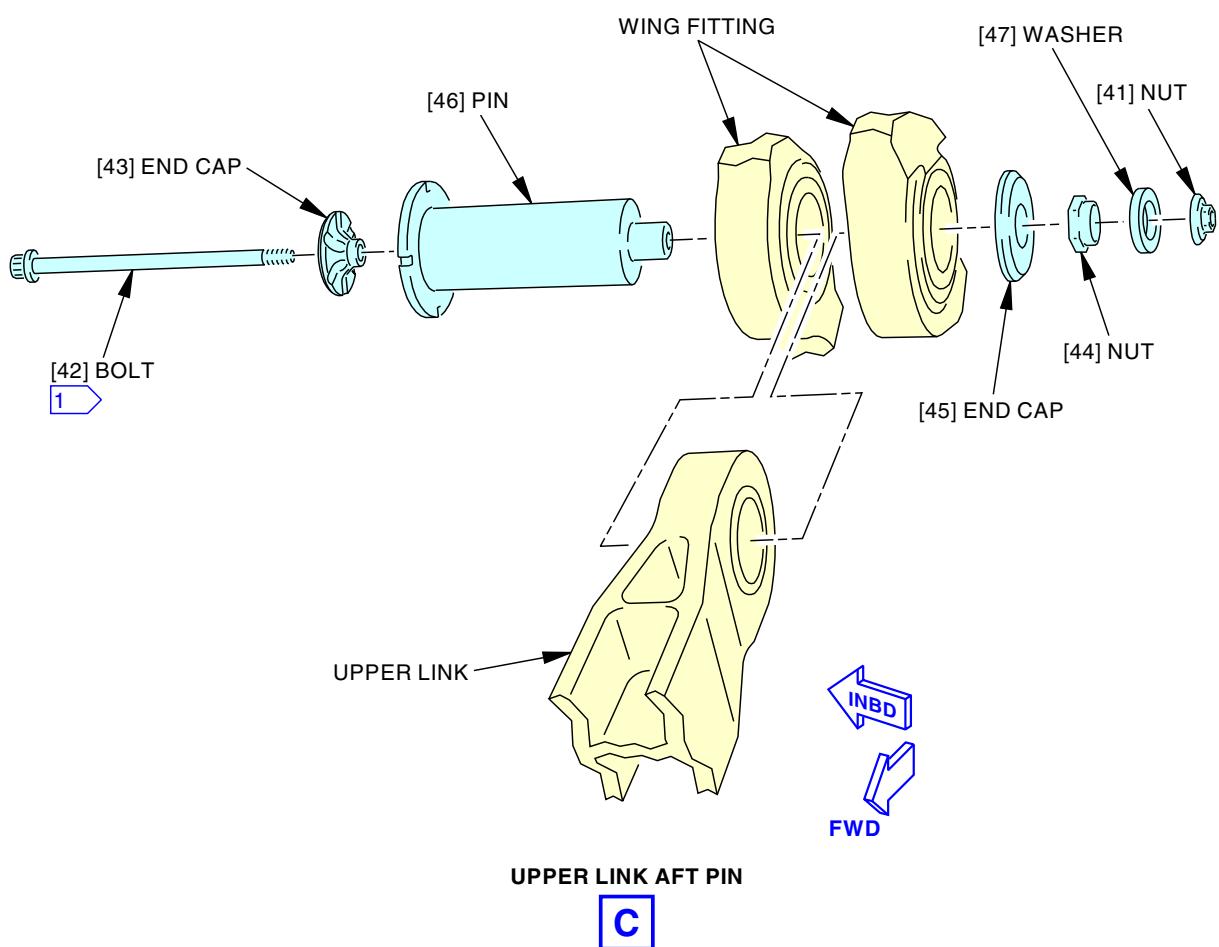
D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL



BOLT MUST BE INSTALLED IN DIRECTION SHOWN.

1924207 S0000362290_V2

Upper Link Aft Pin Installation
Figure 405/54-51-03-990-812 (Sheet 3 of 3)

EFFECTIVITY
LOM ALL

54-51-03



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UPPER LINK - INSPECTION/CHECK

1. General

A. This procedure has these tasks:

- (1) Examine the forward fuse pin and bushings of the upper link for worn areas.
- (2) Examine the aft pin and bushings of the upper link for worn areas.

TASK 54-51-03-220-801

2. Upper Link Forward Fuse Pin and Bushing Examination

(Figure 601)

A. General

- (1) This task examines the forward fuse pin in the upper link for worn areas. This task also examines the bushings in the upper link and the strut attach fitting for worn areas.
- (2) This task has these steps:
 - (a) Remove the forward fuse pin.
 - (b) Measure the forward fuse pin and bushing dimensions.
 - (c) Make sure the dimensions are in the tolerances.
 - (d) Replace the forward fuse pin or bushings, if it is necessary.
 - (e) Install the forward fuse pin.
- (3) You can examine both upper link pins at the same time, but both midspar fuse pins and both diagonal brace pins must stay installed, unless you remove the strut.

B. References

Reference	Title
54-51-03-000-802	Upper Link Fuse Pin Removal (P/B 401)
54-51-03-400-802	Upper Link Fuse Pin Installation (P/B 401)
SRM 54-50-90	Structural Repair Manual

C. Location Zones

Zone	Area
410	Subzone - Engine 1
420	Subzone - Engine 2
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

D. Prepare for the Examination

SUBTASK 54-51-03-000-001

- (1) Do this task: Upper Link Fuse Pin Removal, TASK 54-51-03-000-802.

E. Fuse Pin and Bushing Examination

SUBTASK 54-51-03-220-001

- (1) Measure these dimensions:

- (a) Measure the outside diameter of the fuse pin for the upper link.
- (b) Measure the inside diameter of the bushings in the strut forward upper spar fitting.
- (c) Measure the inside diameter of the bushings in the forward end of the upper link.

EFFECTIVITY
LOM ALL

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SUBTASK 54-51-03-300-001

- (2) Make sure the dimensions are in the tolerances as specified in Table 601.

Table 601/54-51-03-993-805 Upper Link Forward Fuse Pin Wear Limits

INDEX NO.	NAME OF THE PARTS THAT ARE IN CONTACT	DIM.	DIAMETER DESIGN LIMITS		WEAR LIMITS	
			MINIMUM inches/mm	MAXIMUM inches/mm	PERMITTED WEAR DIMENSIONS	MAX CLEARANCE
1	BUSHING	I.D.	1.7215 in 43.726 mm	1.7223 in 43.746 mm	1.7246 in 43.805 mm	0.0046 in 0.117 mm
	FUSE PIN	O.D.	1.7200 in 43.688 mm	1.7205 in 43.700 mm	1.7177 in 43.629 mm	
2	BUSHING	I.D.	1.7215 in 43.726 mm	1.7223 in 43.746 mm	1.7246 in 43.805 mm	0.0046 in 0.117 mm
	FUSE PIN	O.D.	1.7200 in 43.688 mm	1.7205 in 43.700 mm	1.7177 in 43.629 mm	

- (a) If the fuse pin dimensions are not in the tolerances, replace the fuse pin.
- (b) If the bushing dimensions in the strut forward upper spar fitting are not in the tolerances, replace the bushings as specified in this procedure: (SRM 54-50-90).
- (c) If the bushing dimensions in the upper link are not in the tolerances, replace the bushings.

F. Put the Airplane Back to its Usual Condition

SUBTASK 54-51-03-400-001

- (1) Do this task: Upper Link Fuse Pin Installation, TASK 54-51-03-400-802.

———— END OF TASK ————

TASK 54-51-03-220-802

3. Upper Link Aft Pin and Bushing Examination

(Figure 601)

A. General

- (1) This task examines the aft pin in the upper link for worn areas. This task also examines the bushings in the upper link and the wing forward spar fittings for worn areas.
- (2) This task has these steps:
 - (a) Remove the aft pin.
 - (b) Measure the aft pin and bushing dimensions.
 - (c) Make sure the dimensions are in the tolerances.
 - (d) Replace the aft pin or bushings, if it is necessary.
 - (e) Install the aft pin.

EFFECTIVITY
LOM ALL

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- (3) You can examine both upper link pins at the same time, but both midspar pins and both diagonal brace pins must stay installed, unless you remove the strut.

B. References

Reference	Title
54-51-03-000-802	Upper Link Fuse Pin Removal (P/B 401)
54-51-03-400-802	Upper Link Fuse Pin Installation (P/B 401)
SRM 54-50-90	Structural Repair Manual

C. Location Zones

Zone	Area
410	Subzone - Engine 1
420	Subzone - Engine 2
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

D. Prepare for the Examination

SUBTASK 54-51-03-000-002

- (1) Do this task: Upper Link Fuse Pin Removal, TASK 54-51-03-000-802.

E. Pin and Bushing Examination

SUBTASK 54-51-03-220-002

- (1) Measure these dimensions:

- (a) Measure the outside diameter of the pin for the upper link.
- (b) Measure the inside diameter of the bushings in the wing forward spar fittings.
- (c) Measure the inside diameter of the bushings in the forward end of the upper link.

SUBTASK 54-51-03-300-002

- (2) Make sure the dimensions are in the tolerances as specified Table 602.

Table 602/54-51-03-993-806 Upper Link Aft Pin Wear Limits

INDEX NO.	NAME OF THE PARTS THAT ARE IN CONTACT	DIM.	DIAMETER DESIGN LIMITS		WEAR LIMITS	
			MINIMUM inches/mm	MAXIMUM inches/mm	PERMITTED WEAR DIMENSIONS	MAX CLEARANCE
3	BUSHING (UPPER LINK)	I.D.	2.0315 in 51.600 mm	2.0323 in 51.620 mm	2.0346 in 51.679 mm	0.0046 in 0.117 mm
	PIN	O.D.	2.0300 in 51.562 mm	2.0305 in 51.575 mm	2.0277 in 51.504 mm	
4	BUSHING (WING FITTING)	I.D.	2.0315 in 51.600 mm	2.0323 in 51.620 mm	2.0346 in 51.679 mm	0.0046 in 0.117 mm
	PIN	O.D.	2.0300 in	2.0305 in	2.0277 in	

EFFECTIVITY
LOM ALL

54-51-03



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Table 602/54-51-03-993-806 Upper Link Aft Pin Wear Limits (Continued)

INDEX NO.	NAME OF THE PARTS THAT ARE IN CONTACT	DIM.	DIAMETER DESIGN LIMITS		WEAR LIMITS	
			MINIMUM inches/mm	MAXIMUM inches/mm	PERMITTED WEAR DIMENSIONS	MAX CLEARANCE
			51.562 mm	51.575 mm	51.504 mm	

- (a) If the pin dimensions are not in the tolerances, replace the pin.
- (b) If the bushing dimensions in the wing forward spar fittings are not in the tolerances, replace the bushings as specified in this procedure: (SRM 54-50-90).
- (c) If the bushing dimensions in the upper link are not in the tolerances, replace the bushings.

F. Put the Airplane Back to its Usual Condition

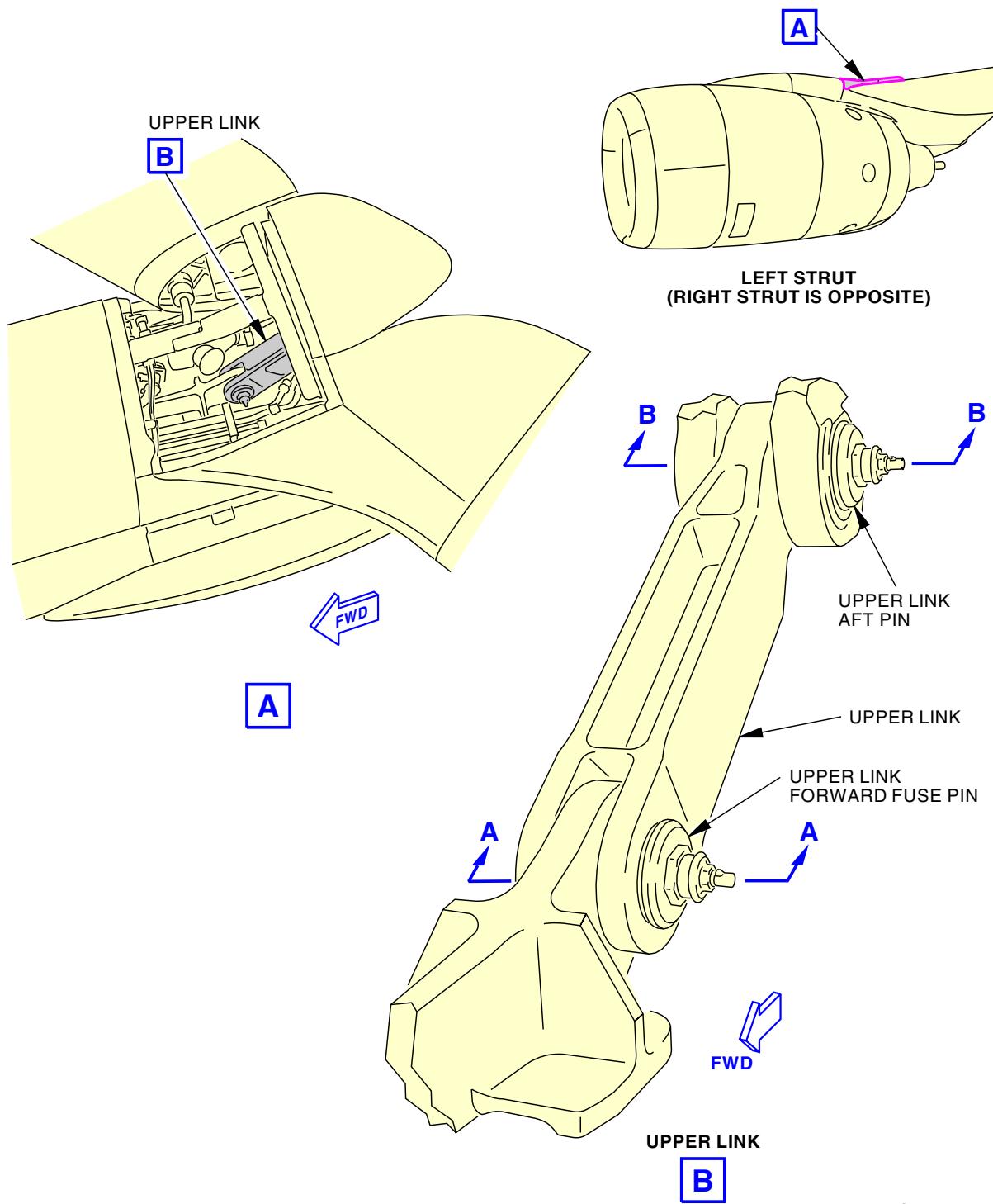
SUBTASK 54-51-03-400-002

- (1) Do this task: Upper Link Fuse Pin Installation, TASK 54-51-03-400-802.

———— END OF TASK ————

— EFFECTIVITY —
LOM ALL

54-51-03



Upper Link Examination
Figure 601/54-51-03-990-802 (Sheet 1 of 3)

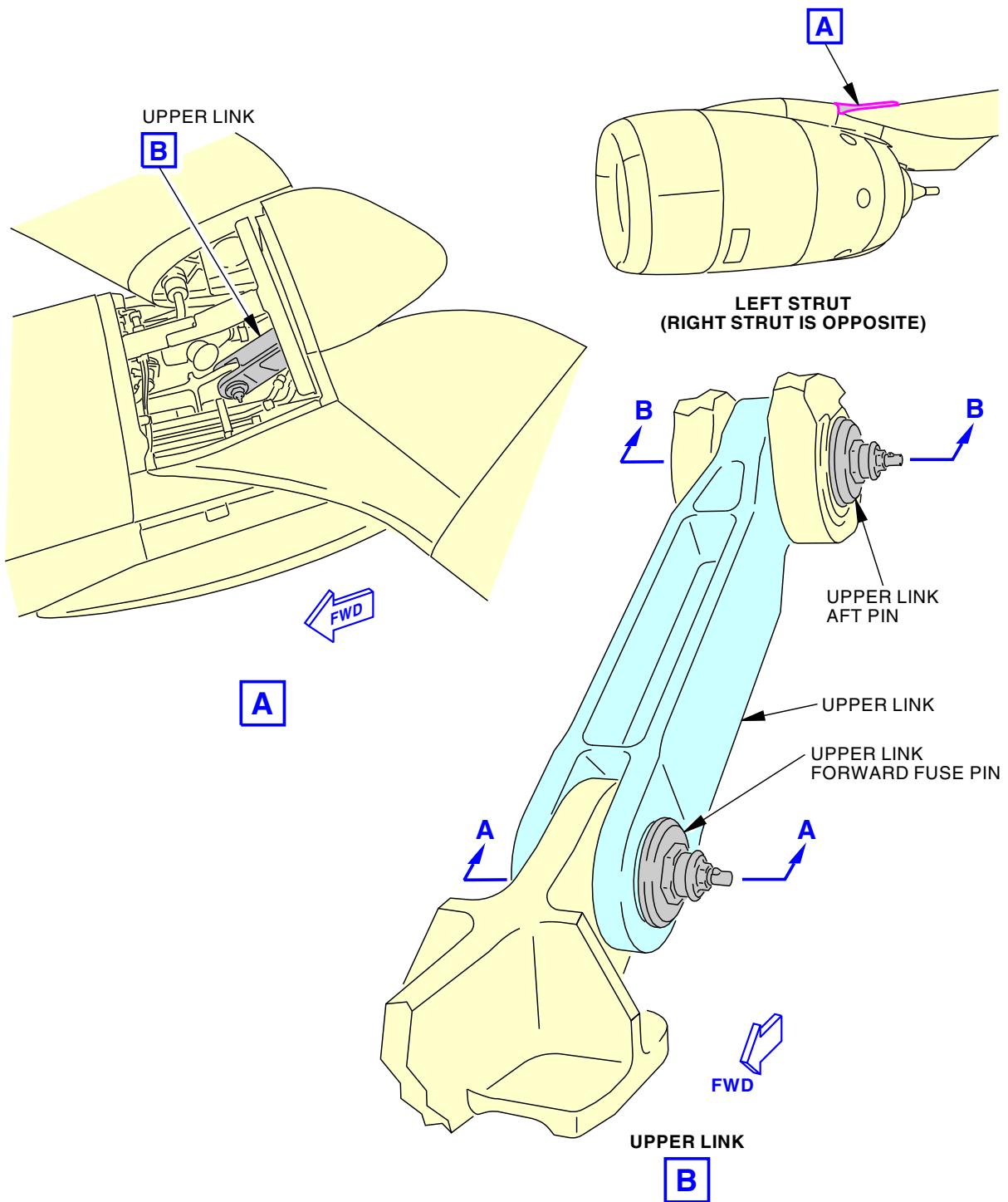
EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-78-1089

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D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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2090056 S0000438665_V2

Upper Link Examination
Figure 601/54-51-03-990-802 (Sheet 2 of 3)

EFFECTIVITY
 LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
 407, 411, 412, 415, 416, 420, 422-426 POST SB
 737-78-1089

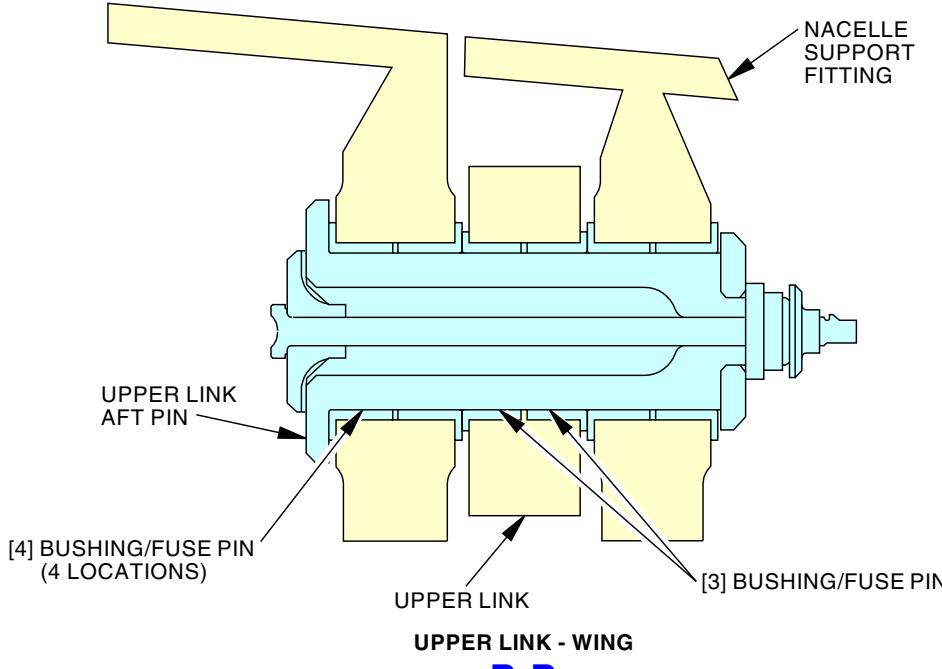
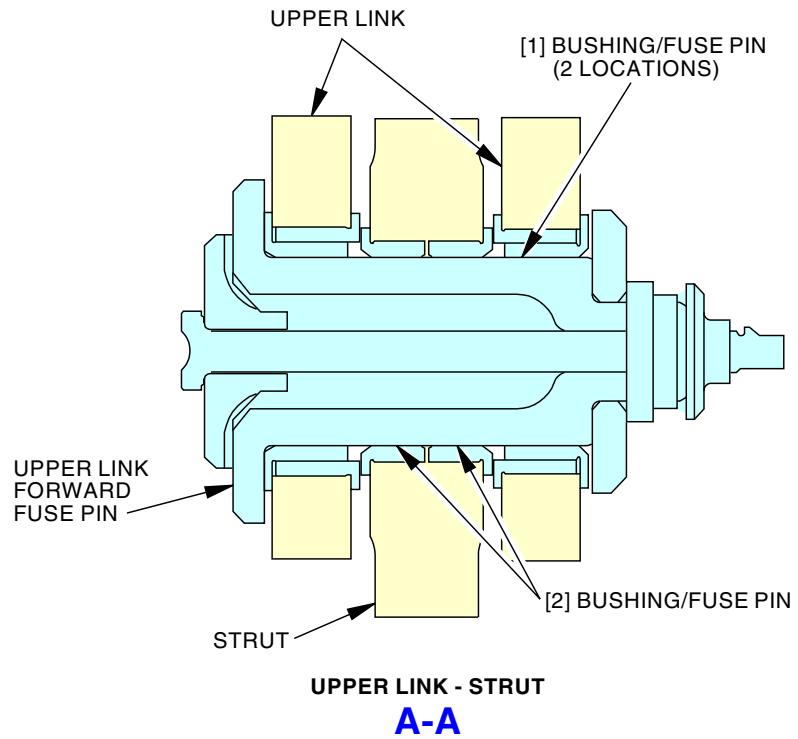
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ECCN 9E991 BOEING PROPRIETARY - See title page for details



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AIRCRAFT MAINTENANCE MANUAL



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Upper Link Examination
Figure 601/54-51-03-990-802 (Sheet 3 of 3)

EFFECTIVITY
LOM ALL

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DIAGONAL BRACE - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) A removal of the diagonal brace.
 - (2) An installation of the diagonal brace.
 - (3) A removal of the diagonal brace forward/aft fuse pin
 - (4) An installation of the diagonal brace forward/aft fuse pin.

TASK 54-51-04-000-801

2. Diagonal Brace Removal

(Figure 401, Figure 402 or Figure 403, Figure 404 or Figure 405)

A. General

- (1) This task removes the diagonal brace.
- (2) This task has these steps:
 - (a) Prepare the strut for maintenance operations.
 - (b) Remove the aft fairing.
 - (c) Look for marks that show if the diagonal brace is a custom fitted diagonal brace.
 - (d) Remove the forward pin from the diagonal brace.
 - (e) Remove the aft fuse pin from the diagonal brace.
 - (f) Carefully lower the diagonal brace.

B. References

Reference	Title
54-51-01-040-801	Prepare the Strut for Maintenance Operations (P/B 201)
54-52-04-010-801	Aft Fairing Removal (Engine Removed) (P/B 401)

C. Location Zones

Zone	Area
410	Subzone - Engine 1
420	Subzone - Engine 2
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

D. Prepare for the Removal

SUBTASK 54-51-04-040-001

- (1) Do this task: Prepare the Strut for Maintenance Operations, TASK 54-51-01-040-801.

SUBTASK 54-51-04-000-001

- (2) Do this task: Aft Fairing Removal (Engine Removed), TASK 54-52-04-010-801.

E. Remove the Diagonal Brace

SUBTASK 54-51-04-280-001

- (1) Look for marks on the diagonal brace that identify the airplane, strut position, and center-to-center distance.

NOTE: If the diagonal brace is identified with this data, it is a custom fitted diagonal brace.





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- (a) If you remove a custom fitted diagonal brace, you must install this same brace (or a new brace with the same center-to-center distance) on the same strut location and airplane where it was removed.

SUBTASK 54-51-04-580-001

- (2) Hold the diagonal brace [1] before you remove the forward pin.

SUBTASK 54-51-04-040-002

- (3) Do this task: Diagonal Brace Forward/Aft Fuse Pin Removal, TASK 54-51-04-000-802.

SUBTASK 54-51-04-580-002

- (4) Carefully lower the aft end of diagonal brace [1] and raise forward end.

SUBTASK 54-51-04-020-002

- (5) Position aft end of diagonal brace [1] inboard of the aft end fitting.

SUBTASK 54-51-04-020-003

- (6) Slide brace aft as far as possible.

SUBTASK 54-51-04-020-004

- (7) Move forward end of diagonal brace [1] outboard and remove from strut assembly.

SUBTASK 54-51-04-930-001

- (8) If the diagonal brace that you removed is a custom fitted diagonal brace, do these steps:

- (a) Put a tag on the diagonal brace with the airplane number, strut location, and center-to-center distance, or make sure this data is identified on the diagonal brace.
(b) Put a tag on the aft attach fitting with the airplane number, strut location, and center-to-center distance.

———— END OF TASK ————

TASK 54-51-04-400-801

3. Diagonal Brace Installation

(Figure 401, Figure 402 or Figure 403, Figure 404 or Figure 405)

A. References

Reference	Title
54-51-01-440-801	Put the Strut Back to its Usual Condition (P/B 201)
54-52-04-410-801	Aft Fairing Installation (Engine Removed) (P/B 401)

B. Location Zones

Zone	Area
410	Subzone - Engine 1
420	Subzone - Engine 2
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

C. Install the Diagonal Brace

SUBTASK 54-51-04-280-002

- (1) Look for marks that show if the diagonal brace is a custom fitted diagonal brace.

- (a) Look for a tag or identification on the diagonal brace with the airplane number, strut location, and center-to-center distance.

NOTE: If the diagonal brace is identified with this data, it is a custom fitted diagonal brace.

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- (b) Look for a tag on the aft attach fitting with the airplane number, strut location, and center-to-center distance.

NOTE: If the aft attach fitting is identified with this data, it is necessary to install a custom fitted diagonal brace at that strut location.

- (c) If you will install a custom fitted diagonal brace, you must do one of these steps:
- 1) Install the same brace on the same strut location and airplane where you removed it.
 - 2) Replace the brace with a new custom fitted diagonal brace (with the same center-to-center distance).

SUBTASK 54-51-04-580-003

- (2) Carefully raise the diagonal brace [1] under the wing.

SUBTASK 54-51-04-420-001

- (3) Do this task: Diagonal Brace Fuse Pin Installation, TASK 54-51-04-400-802.

SUBTASK 54-51-04-420-002

- (4) Do this task: Diagonal Brace Fuse Pin Installation, TASK 54-51-04-400-802.

D. Put the Airplane Back to Its Usual Condition

SUBTASK 54-51-04-410-001

- (1) Do this task: Aft Fairing Installation (Engine Removed), TASK 54-52-04-410-801.

SUBTASK 54-51-04-440-001

- (2) Do this task: Put the Strut Back to its Usual Condition, TASK 54-51-01-440-801.

———— END OF TASK ————

TASK 54-51-04-000-802

4. Diagonal Brace Forward/Aft Fuse Pin Removal

(Figure 402 or Figure 403, Figure 404 or Figure 405)

A. General

- (1) This task removes the forward/aft fuse pin from the diagonal brace.
- (2) You can remove the two diagonal brace pins at the same time. But you may not remove any additional strut attach pin, while the two diagonal brace pins are removed. Only one link can be free at a time on a strut (unless you will remove the strut).
- (3) This task has these steps:
 - (a) Get access to the pin.
 - (b) Remove the nuts, bolt, and end caps.
 - (c) Remove the load from the pin.
 - (d) Remove the pin.

B. References

Reference	Title
54-51-01-040-801	Prepare the Strut for Maintenance Operations (P/B 201)
54-51-01-580-801	Support the Strut with the Engine Installed (P/B 201)
54-51-01-580-803	Support the Strut with the Engine Removed (P/B 201)
54-52-06-010-801	Aft Fairing Access Panel Removal (P/B 401)

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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-2020	Kit - Fuse Pin, Removal/Installation Part #: C54009-27 Supplier: 81205
STD-6213	Wrench - Torque, 300 lb-in

D. Consumable Materials

Reference	Description	Specification
D00633	Grease - Aircraft General Purpose	BMS3-33

E. Location Zones

Zone	Area
410	Subzone - Engine 1
420	Subzone - Engine 2
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

F. Access Panels

Number	Name/Location
434AL	Aft Strut Fairing, Left Forward Panel, Strut 1
434AR	Aft Strut Fairing, Right Forward Panel, Strut 1
444AL	Aft Strut Fairing, Left Forward Panel, Strut 2
444AR	Aft Strut Fairing, Right Forward Panel, Strut 2

G. Prepare for the Removal

SUBTASK 54-51-04-040-003

- (1) Do this task: Prepare the Strut for Maintenance Operations, TASK 54-51-01-040-801.

SUBTASK 54-51-04-010-001

- (2) Get access to the diagonal brace forward pin. To do this, do this task (Aft Fairing Access Panel Removal, TASK 54-52-06-010-801):

Open these access panels:

Number	Name/Location
434AL	Aft Strut Fairing, Left Forward Panel, Strut 1
434AR	Aft Strut Fairing, Right Forward Panel, Strut 1
444AL	Aft Strut Fairing, Left Forward Panel, Strut 2
444AR	Aft Strut Fairing, Right Forward Panel, Strut 2

H. Remove the Diagonal Brace Fuse Pin

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SUBTASK 54-51-04-000-004



MAKE SURE PAWL ON BOLT IS PRESSED DOWN WHILE REMOVING NUT.
DAMAGE TO THE EQUIPMENT CAN OCCUR.

- (1) For the forward fuse bolt, do the steps that follow.

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- (a) Remove the nut [21], bolt [22], and end cap [25].
 - (b) Remove the end cap [23] and bolt [22].
 - (c) If the strut will stay installed, do the steps that follow to remove the pin [26].
 - 1) Support the strut.
 - a) If you will remove the pin with the engine installed, do this task: Support the Strut with the Engine Installed, TASK 54-51-01-580-801.
 - b) If you will remove the pin with the engine removed, do this task: Support the Strut with the Engine Removed, TASK 54-51-01-580-803.
 - 2) Make sure that all of the upper link pins and the midspars are installed.
 - 3) Use the torque wrench, STD-6213, and the adapter fuse pin kit, SPL-2020, to make sure that the pin turns easily.

NOTE: When the load is correctly removed, the pin will turn with 125 in-lb (14 N·m) maximum torque.
 - 4) Use a brass slug from the pin removal fuse pin kit, SPL-2020, with grease, D00633, to push out the pin [26].
 - a) Make sure that the clevis and the flange stay aligned.
 - 5) Make sure that you keep the support load on the strut until you install a pin at this location.

NOTE: The hydraulic system in the crane can bleed which can cause the load to change.
 - (d) If you will remove the strut, do these steps to remove the pin [26].
 - 1) Do this task: Support the Strut with the Engine Removed, TASK 54-51-01-580-803.
 - 2) Use the torque wrench, STD-6213, and the adapter fuse pin kit, SPL-2020, to make sure the pin turns easily.

NOTE: When the load is correctly removed, the pin will turn with 125 in-lb (14 N·m) maximum torque.
 - 3) Use the pin removal fuse pin kit, SPL-2020, to remove the pin [26].
- (2) For the aft fuse bolt, do the steps that follow.
- (a) Remove the nut [41], nut [44], and end cap [45].
 - (b) Remove the bolt [42] and end cap [43].
 - (c) If the strut will stay installed, do the steps that follow to remove the fuse pin [46].
 - 1) Support the strut.
 - a) If you will remove the pin with the engine installed, do this task: Support the Strut with the Engine Installed, TASK 54-51-01-580-801.
 - b) If you will remove the pin with the engine removed, do this task: Support the Strut with the Engine Removed, TASK 54-51-01-580-803.
 - 2) Make sure that all of the upper link pins and the midspars are installed.
 - 3) Use the torque wrench, STD-6213, and the adapter fuse pin kit, SPL-2020, to make sure that the pin turns easily.

NOTE: When the load is correctly removed, the pin will turn with 125 in-lb (14 N·m) maximum torque.

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- 4) Use a brass slug from the pin removal fuse pin kit, SPL-2020, with grease, D00633, to push out the fuse pin [46].

a) Make sure that the clevis and the flange stay aligned.

- 5) Make sure that you keep the support load on the strut until you install a pin at this location.

NOTE: The hydraulic system in the crane can bleed which can cause the load to change.

- (d) If you will remove the strut, do these steps to remove the fuse pin [46].

1) Do this task: Support the Strut with the Engine Removed, TASK 54-51-01-580-803.

- 2) Use the torque wrench, STD-6213, and the adapter fuse pin kit, SPL-2020, to make sure the pin turns easily.

NOTE: When the load is correctly removed, the pin will turn with 125 in-lb (14 N·m) maximum torque.

- 3) Use the pin removal fuse pin kit, SPL-2020, to remove the fuse pin [46].

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SUBTASK 54-51-04-020-006

- (3) For the forward fuse bolt, do the steps that follow.

- (a) Remove the nut [21], spherical washer [27], bolt [22], and end cap [25].

- (b) Remove the end cap [23] and bolt [22].

- (c) If the strut will stay installed, do the steps that follow to remove the pin [26].

- 1) Support the strut.

a) If you will remove the pin with the engine installed, do this task: Support the Strut with the Engine Installed, TASK 54-51-01-580-801.

b) If you will remove the pin with the engine removed, do this task: Support the Strut with the Engine Removed, TASK 54-51-01-580-803.

- 2) Make sure that all of the upper link pins and the midspur fuse pins are installed.

- 3) Use the torque wrench, STD-6213, and the adapter fuse pin kit, SPL-2020, to make sure that the pin turns easily.

NOTE: When the load is correctly removed, the pin will turn with 125 in-lb (14 N·m) maximum torque.

- 4) Use a brass slug from the pin removal fuse pin kit, SPL-2020, with grease, D00633, to push out the pin [26].

a) Make sure that the clevis and the flange stay aligned.

- 5) Make sure that you keep the support load on the strut until you install a pin at this location.

NOTE: The hydraulic system in the crane can bleed which can cause the load to change.

- (d) If you will remove the strut, do these steps to remove the pin [26].

- 1) Do this task: Support the Strut with the Engine Removed, TASK 54-51-01-580-803.

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- 2) Use the torque wrench, STD-6213, and the adapter fuse pin kit, SPL-2020, to make sure the pin turns easily.

NOTE: When the load is correctly removed, the pin will turn with 125 in-lb (14 N·m) maximum torque.

- 3) Use the pin removal fuse pin kit, SPL-2020, to remove the pin [26].

- (4) For the aft fuse bolt, do the steps that follow.

- (a) Remove the nut [41], spherical washer [47], nut [44], and end cap [45].

- (b) Remove the bolt [42] and end cap [43].

- (c) If the strut will stay installed, do the steps that follow to remove the fuse pin [46].

- 1) Support the strut.

- a) If you will remove the pin with the engine installed, do this task: Support the Strut with the Engine Installed, TASK 54-51-01-580-801.

- b) If you will remove the pin with the engine removed, do this task: Support the Strut with the Engine Removed, TASK 54-51-01-580-803.

- 2) Make sure that all of the upper link pins and the midspur fuse pins are installed.

- 3) Use the torque wrench, STD-6213, and the adapter fuse pin kit, SPL-2020, to make sure that the pin turns easily.

NOTE: When the load is correctly removed, the pin will turn with 125 in-lb (14 N·m) maximum torque.

- 4) Use a brass slug from the pin removal fuse pin kit, SPL-2020, with grease, D00633, to push out the fuse pin [46].

- a) Make sure that the clevis and the flange stay aligned.

- 5) Make sure that you keep the support load on the strut until you install a pin at this location.

NOTE: The hydraulic system in the crane can bleed which can cause the load to change.

- (d) If you will remove the strut, do these steps to remove the fuse pin [46].

- 1) Do this task: Support the Strut with the Engine Removed, TASK 54-51-01-580-803.

- 2) Use the torque wrench, STD-6213, and the adapter fuse pin kit, SPL-2020, to make sure the pin turns easily.

NOTE: When the load is correctly removed, the pin will turn with 125 in-lb (14 N·m) maximum torque.

- 3) Use the pin removal fuse pin kit, SPL-2020, to remove the fuse pin [46].

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———— END OF TASK ————

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TASK 54-51-04-400-802

5. Diagonal Brace Fuse Pin Installation

(Figure 401, Figure 402 or Figure 403, Figure 404 or Figure 405)

A. General

- (1) This task installs the forward/aft fuse pin in the diagonal brace.
- (2) This task has these steps:
 - (a) Make sure that there is no corrosion on the pin.
 - (b) If you did not remove the strut, make sure that there is no load on the brass slug.
 - (c) Install the pin with grease.
 - (d) Install the end caps, bolt, and nuts.
 - (e) Remove the support from the strut.
 - (f) If you will do no more maintenance operations on the strut, put the airplane back to its usual condition.

B. References

Reference	Title
51-31-00-390-804	Fillet Seal Application (P/B 201)
54-51-01-440-801	Put the Strut Back to its Usual Condition (P/B 201)
54-51-01-580-802	Remove Support from the Strut with the Engine Installed (P/B 201)
54-51-01-580-804	Remove Support from the Strut with the Engine Removed (P/B 201)
54-51-04-220-802	Diagonal Brace Forward Pin and Bushing Examination (P/B 601)
54-52-06-410-801	Aft Fairing Access Panel 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-2020	Kit - Fuse Pin, Removal/Installation Part #: C54009-27 Supplier: 81205

D. Consumable Materials

Reference	Description	Specification
D00006	Compound - Antiseize, Pure Nickel Special - Never-Seez NSBT-8N/-16N	
D00633	Grease - Aircraft General Purpose	BMS3-33

E. Location Zones

Zone	Area
410	Subzone - Engine 1
420	Subzone - Engine 2
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

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F. Access Panels

Number	Name/Location
434AL	Aft Strut Fairing, Left Forward Panel, Strut 1
434AR	Aft Strut Fairing, Right Forward Panel, Strut 1
444AL	Aft Strut Fairing, Left Forward Panel, Strut 2
444AR	Aft Strut Fairing, Right Forward Panel, Strut 2

G. Install the Pin

SUBTASK 54-51-04-200-003

- (1) Do this task: Diagonal Brace Forward Pin and Bushing Examination, TASK 54-51-04-220-802.

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SUBTASK 54-51-04-210-001

- (2) Do a check that the pin [26], end cap [25], nut [24], end cap [23], bolt [22], and nut [21] are free from corrosion.
(a) Make sure that there is no corrosion internally on the pin.
(3) Do a check that the nut [41], bolt [42], end cap [43], nut [44], end cap [45], and fuse pin [46] are free from corrosion.

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SUBTASK 54-51-04-210-003

- (4) Do a check that the spherical washer [27], pin [26], end cap [25], nut [24], end cap [23], bolt [22], and nut [21] are free from corrosion.
(a) Make sure that there is no corrosion internally on the pin.
(5) Do a check that the nut [41], bolt [42], end cap [43], nut [44], end cap [45], fuse pin [46], and spherical washer [47] are free from corrosion.

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SUBTASK 54-51-04-210-002

- (6) If you removed the diagonal brace, make sure that there is no corrosion internally on the bushings at the strut fitting.

SUBTASK 54-51-04-300-003

- (7) Do these steps if you find corrosion:
(a) To remove corrosion, refer to the Corrosion Prevention Manual.
(b) To repair or replace a part with corrosion, contact Boeing for a corrective action.

SUBTASK 54-51-04-390-001

- (8) Make sure that all flanged bushings at the installation fittings are sealed from corrosion.
(a) If some of the flanged bushings are not sealed, apply sealant to the bushings (Fillet Seal Application, TASK 51-31-00-390-804).
(b) Apply a fillet seal to the flanged end of all bushings.

SUBTASK 54-51-04-400-003

- (9) If you did not remove the strut, install the pin [26] or fuse pin [46] as follows:
(a) Make sure that the brass slug is not loaded.
(b) Apply a thin layer of grease, D00633, to the pin.
(c) Use the pin installation fuse pin kit, SPL-2020, to push out the brass slug with the pin [26].

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- 1) Make sure that the head of the pin is on the outboard side of the installation fitting.

SUBTASK 54-51-04-400-004

- (10) If you removed the strut, install the pin [26] as follows:
 - (a) Apply a thin layer of grease, D00633, to the pin.
 - (b) Use the pin installation fuse pin kit, SPL-2020, to install the pin [26] or fuse pin [46].
 - 1) Make sure that the head of the pin is on the outboard side of the installation fitting.

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SUBTASK 54-51-04-400-005

- (11) Install the forward fuse pin.
 - (a) Install the end cap [23] to the bolt [22].
 - (b) Install the bolt [22] and end cap [23] to the pin [26].

NOTE: Make sure that the bolt is installed in the direction shown.
 - (c) Install the end cap [25].
 - (d) Apply a layer of Pure Nickel Special compound, D00006, to the threads and bottom of the nut [24].
 - (e) Install the nut [24].
 - 1) Make sure that the run-on torque is 70 in-lb (8 N·m) to 600 in-lb (68 N·m).
 - a) If the run-on torque is not 70 in-lb (8 N·m) to 600 in-lb (68 N·m), replace the nut.
 - 2) Tighten the nut to a torque of 800 in-lb (90 N·m) to 1000 in-lb (113 N·m).
 - (f) Apply a layer of Pure Nickel Special compound, D00006, to the threads and bottom of the nut [21].
 - (g) Install the nut [21].
 - 1) Make sure that the run-on torque is 9.5 in-lb (1.1 N·m) to 80 in-lb (9 N·m).
 - a) If the run-on torque is not 9.5 in-lb (1.1 N·m) to 80 in-lb (9 N·m), replace the nut.
 - 2) If torque is applied to the nut, torque the nut to 150 in-lb (17 N·m) to 200 in-lb (23 N·m).
 - 3) If torque is applied to the bolt, torque the bolt to 165 in-lb (19 N·m) to 200 in-lb (23 N·m).
 - (h) Make sure that the spring-loaded pawl is fully extended after you tighten the nut [21].

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SUBTASK 54-51-04-420-003

- (12) Install the forward fuse pin.
 - (a) Install the end cap [23] to the bolt [22].
 - (b) Install the bolt [22] and end cap [23] to the pin [26].

NOTE: Make sure that the bolt is installed in the direction shown.
 - (c) Install the end cap [25].
 - (d) Apply a layer of Pure Nickel Special compound, D00006, to the threads and bottom of the nut [24].
 - (e) Install the nut [24].

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- 1) Make sure that the run-on torque is 70 in-lb (8 N·m) to 600 in-lb (68 N·m).
 - a) If the run-on torque is not 70 in-lb (8 N·m) to 600 in-lb (68 N·m), replace the nut.
 - 2) Tighten the nut to a torque of 800 in-lb (90 N·m) to 1000 in-lb (113 N·m).
- (f) Install the spherical washer [27].
- (g) Install the nut [21].

LOM ALL; AIRPLANES WITH BOLT PN 311A2097

SUBTASK 54-51-04-420-004

- (13) Install the aft fuse pin.
- (a) Install the end cap [43] to the bolt [42].
 - (b) Install the bolt [42] and end cap [43] to the fuse pin [46].

NOTE: Make sure that the bolt is installed in the direction shown.
 - (c) Install the end cap [45].
 - (d) Apply a thin layer of Pure Nickel Special compound, D00006, to the threads and bottom of the nut [44].
 - (e) Install the nut [44].
 - 1) Make sure that the run-on torque is 70 in-lb (8 N·m) to 600 in-lb (68 N·m).
 - a) If the run-on torque is not 70 in-lb (8 N·m) to 600 in-lb (68 N·m), replace the nut.
 - 2) Tighten the nut to 800 in-lb (90 N·m) to 1000 in-lb (113 N·m).
 - (f) Apply a thin layer of Pure Nickel Special compound, D00006, to the threads and bottom of the nut [41].
 - (g) Install the nut [41].
 - 1) Make sure that the run-on torque is 9.5 in-lb (1.1 N·m) to 80 in-lb (9 N·m).
 - a) If the run-on torque is not 9.5 in-lb (1.1 N·m) to 80 in-lb (9 N·m), replace the nut.
 - 2) If torque is applied to the nut, torque the nut to 150 in-lb (17 N·m) to 200 in-lb (23 N·m).
 - 3) If torque is applied to the bolt, torque the bolt to 165 in-lb (19 N·m) to 200 in-lb (23 N·m).
 - (h) Make sure that the spring-loaded pawl is fully extended after you install the nut [41].

LOM ALL; AIRPLANES WITH BOLT PN BACB30LE

SUBTASK 54-51-04-420-005

- (14) Install the aft fuse pin.
- (a) Install the end cap [43] to the bolt [42].
 - (b) Install the bolt [42] and end cap [43] to the fuse pin [46].

NOTE: Make sure that the bolt is installed in the direction shown.
 - (c) Install the end cap [45].

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- | (d) Apply a thin layer of Pure Nickel Special compound, D00006, to the threads and bottom of the nut [44].
- | (e) Install the nut [44].
 - | 1) Make sure that the run-on torque is 70 in-lb (8 N·m) to 600 in-lb (68 N·m).
 - | a) If the run-on torque is not 70 in-lb (8 N·m) to 600 in-lb (68 N·m), replace the nut.
 - | 2) Tighten the nut to 800 in-lb (90 N·m) to 1000 in-lb (113 N·m).
- | (f) Install the spherical washer [47].
- | (g) Install the nut [41].

LOM ALL

SUBTASK 54-51-04-200-004

- (15) Make sure that all parts are tightly seated.

H. Put the Airplane Back to Its Usual Condition

SUBTASK 54-51-04-580-004

- (1) Remove the support from the strut as follows:
 - (a) If you installed the pin with the engine installed, do this task: Remove Support from the Strut with the Engine Installed, TASK 54-51-01-580-802.
 - (b) If you installed the pin with the engine removed, do this task: Remove Support from the Strut with the Engine Removed, TASK 54-51-01-580-804.

SUBTASK 54-51-04-410-002

- (2) To install the aft fairing access panel, do this task (Aft Fairing Access Panel Installation, TASK 54-52-06-410-801):

Close these access panels:

Number Name/Location

434AL	Aft Strut Fairing, Left Forward Panel, Strut 1
434AR	Aft Strut Fairing, Right Forward Panel, Strut 1
444AL	Aft Strut Fairing, Left Forward Panel, Strut 2
444AR	Aft Strut Fairing, Right Forward Panel, Strut 2

SUBTASK 54-51-04-440-002

- (3) If you will do no more maintenance operations on the strut, do this task: Put the Strut Back to its Usual Condition, TASK 54-51-01-440-801.

———— END OF TASK ————

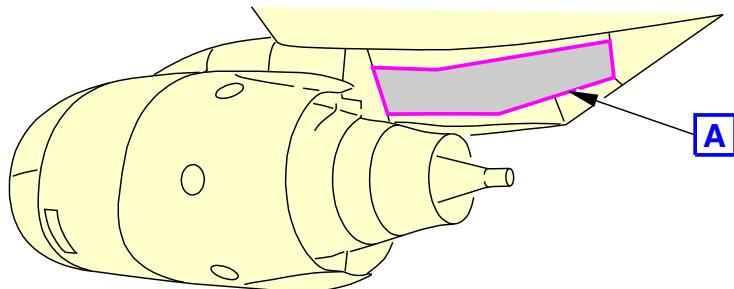


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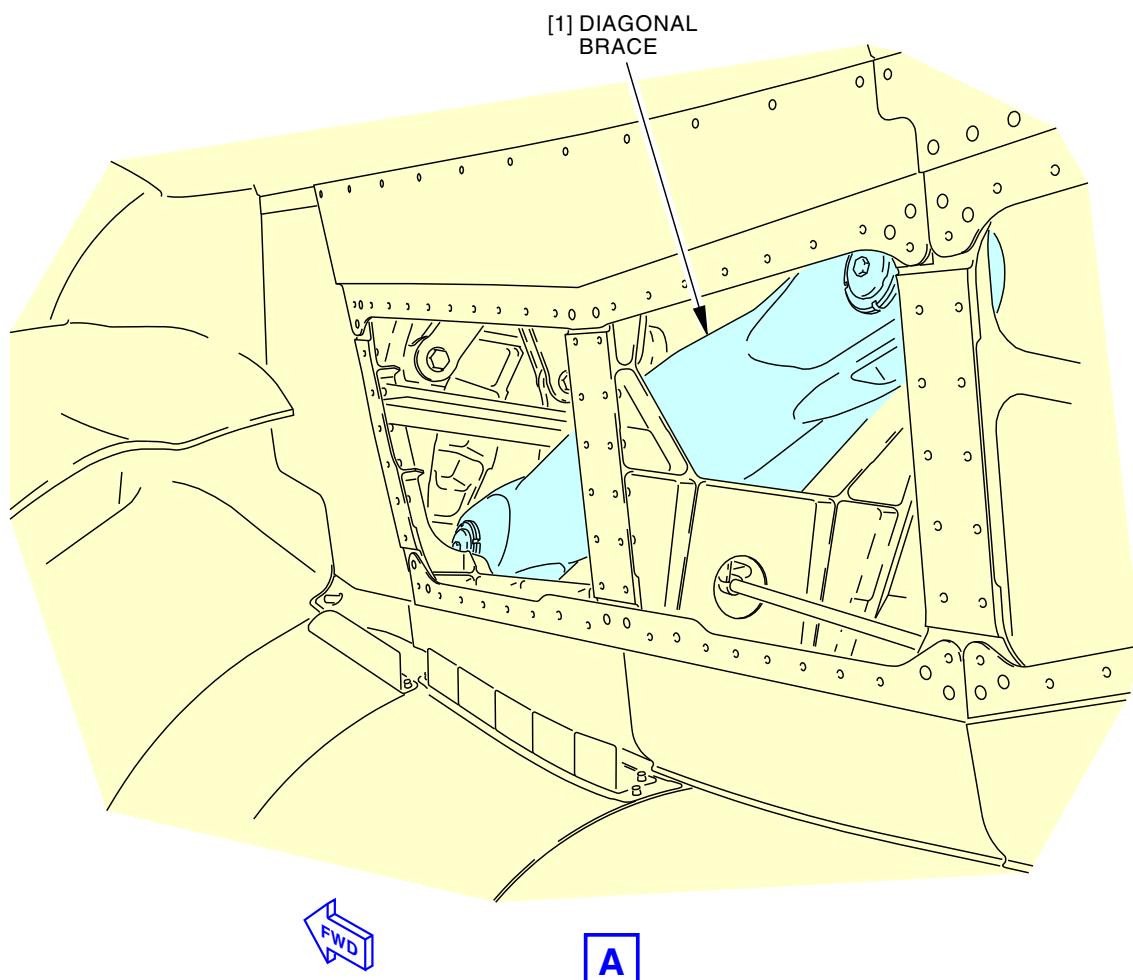
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LEFT STRUT
(RIGHT STRUT IS OPPOSITE)



G56765 S0006581143_V2

Diagonal Brace Installation
Figure 401/54-51-04-990-801 (Sheet 1 of 2)

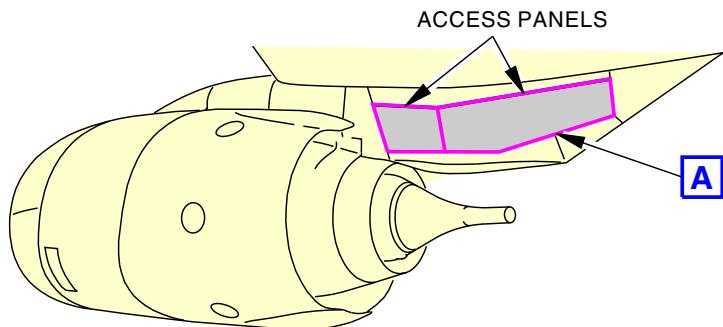
EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-78-1089

54-51-04

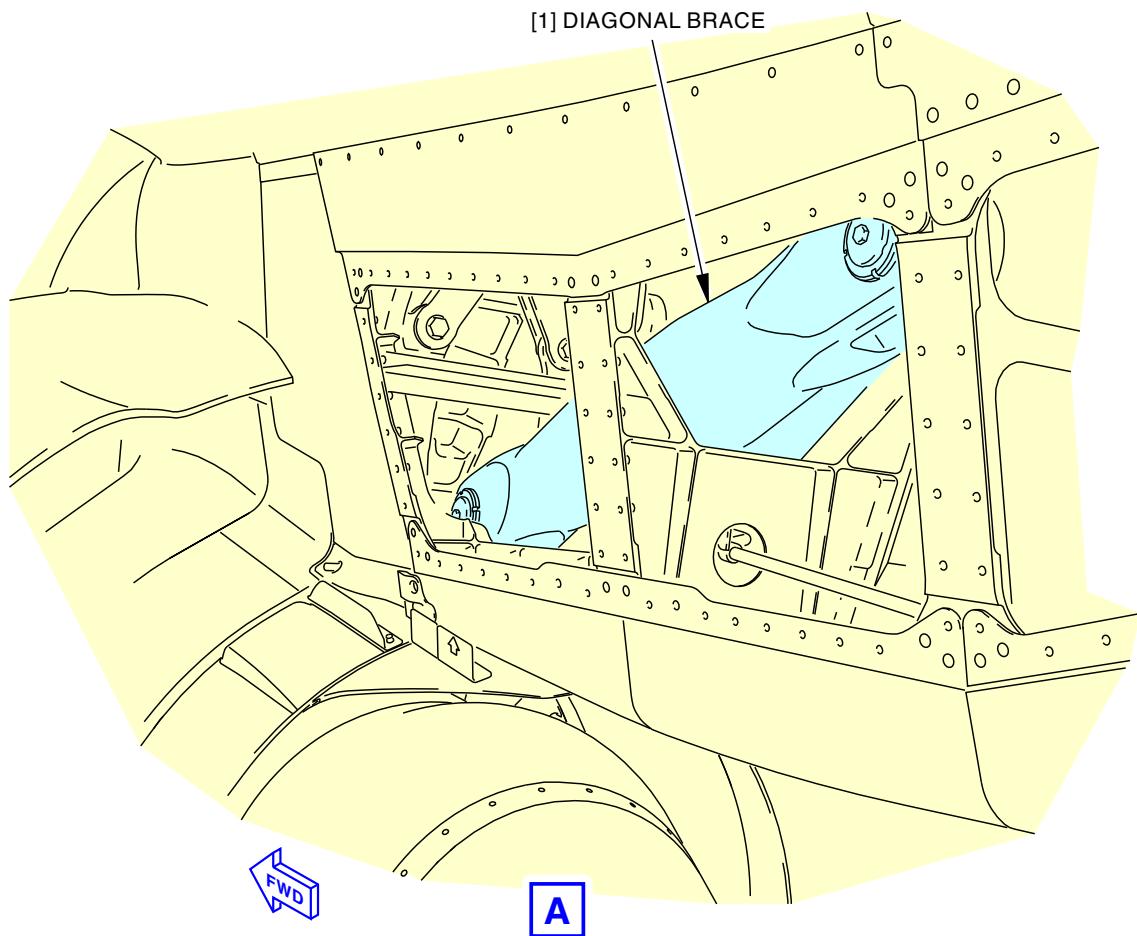
D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

Page 413
Oct 15/2024



LEFT STRUT
(RIGHT STRUT IS OPPOSITE)



2090191 S0000438697_V2

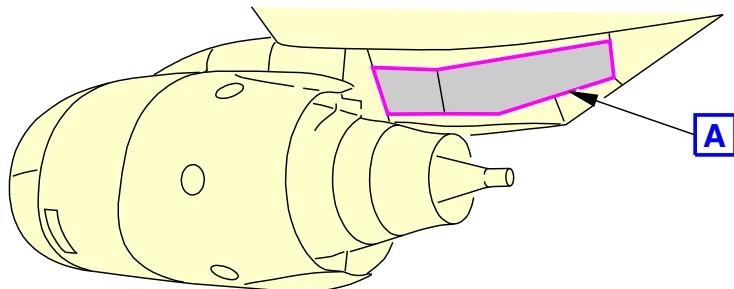
Diagonal Brace Installation
Figure 401/54-51-04-990-801 (Sheet 2 of 2)

EFFECTIVITY
LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
407, 411, 412, 415, 416, 420, 422-426 POST SB
737-78-1089

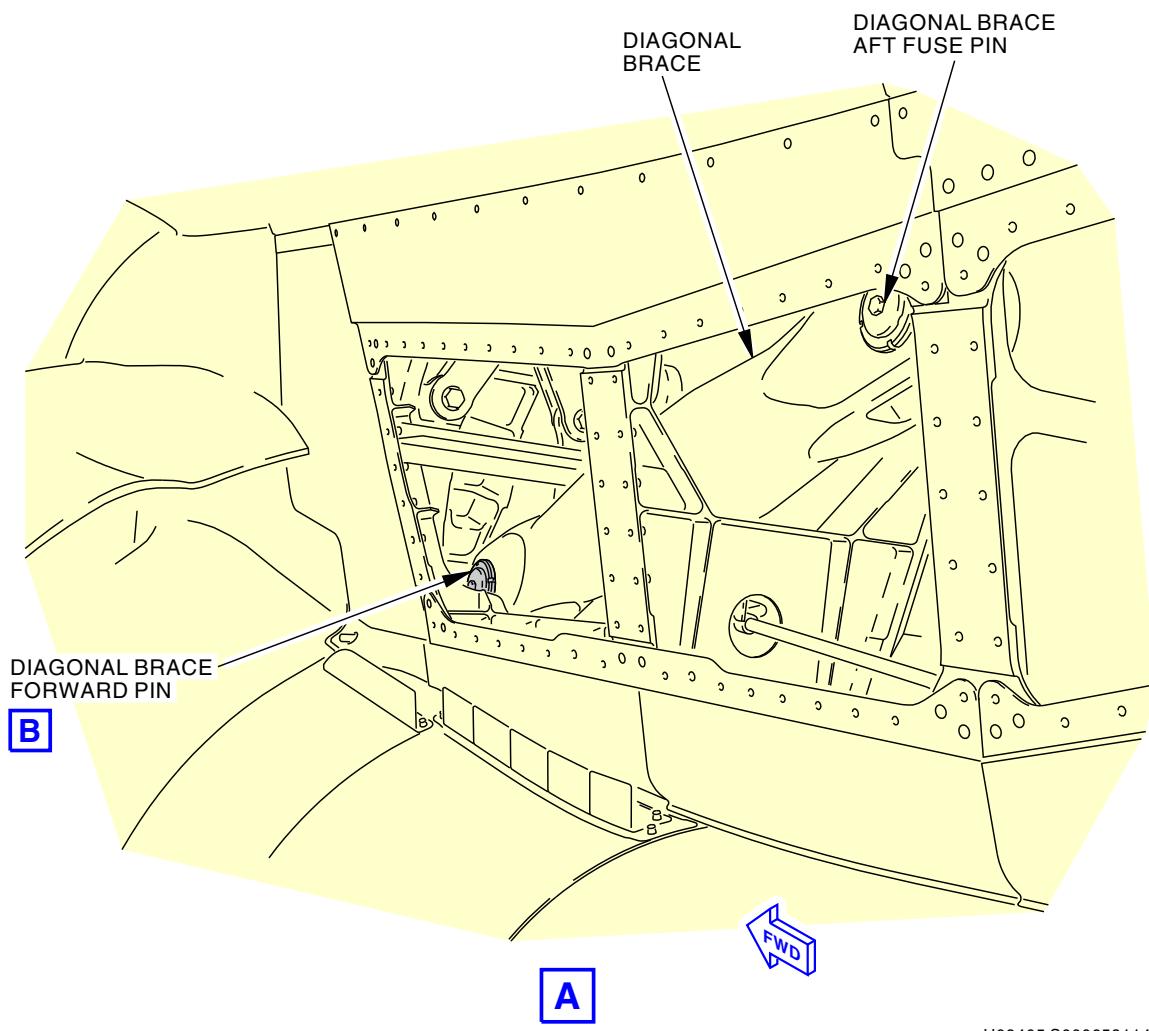
54-51-04

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ECCN 9E991 BOEING PROPRIETARY - See title page for details



LEFT STRUT
(RIGHT STRUT IS OPPOSITE)



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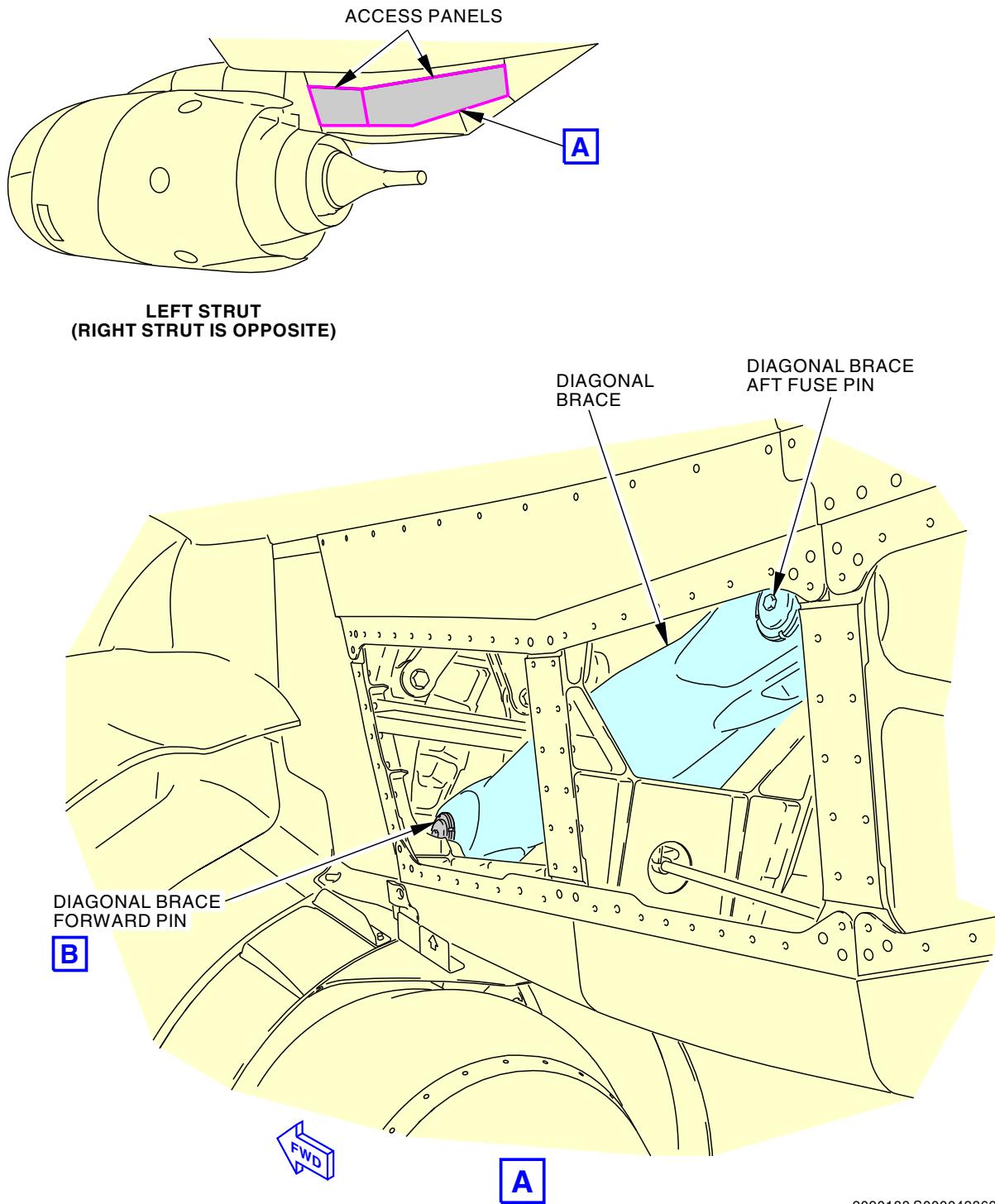
Diagonal Brace Forward Pin Installation
Figure 402/54-51-04-990-805 (Sheet 1 of 3)

EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-78-1089

54-51-04

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details



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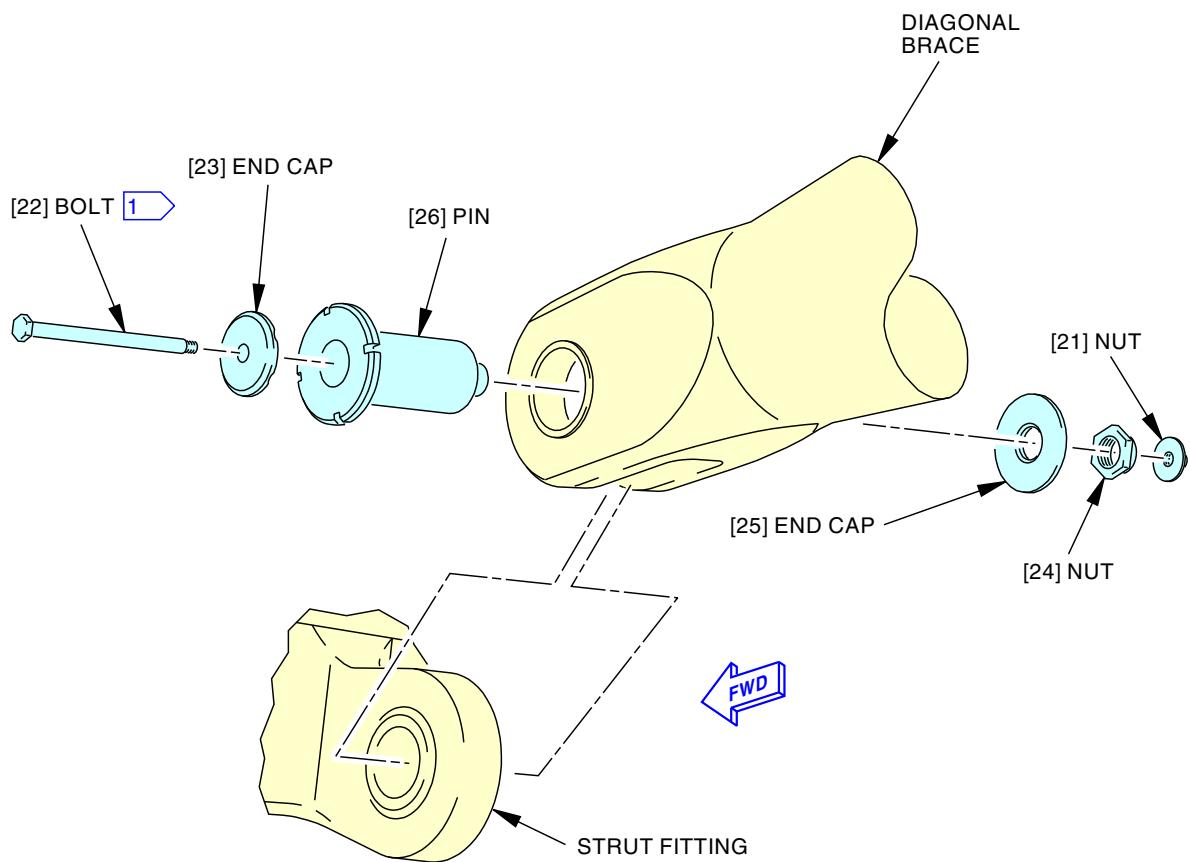
Diagonal Brace Forward Pin Installation
Figure 402/54-51-04-990-805 (Sheet 2 of 3)

EFFECTIVITY
 LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
 407, 411, 412, 415, 416, 420, 422-426 POST SB
 737-78-1089

54-51-04

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details



DIAGONAL BRACE FORWARD PIN

B

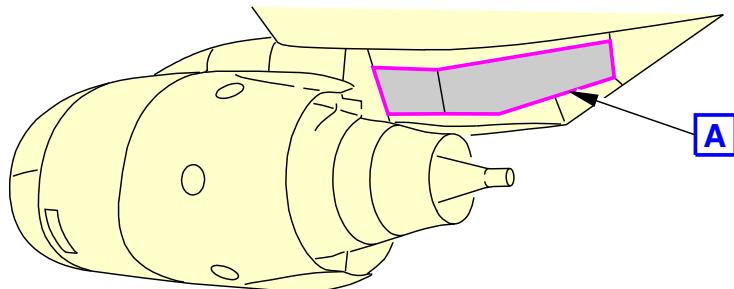
1 BOLT MUST BE INSTALLED IN DIRECTION SHOWN.

H09407 S0006581145_V3

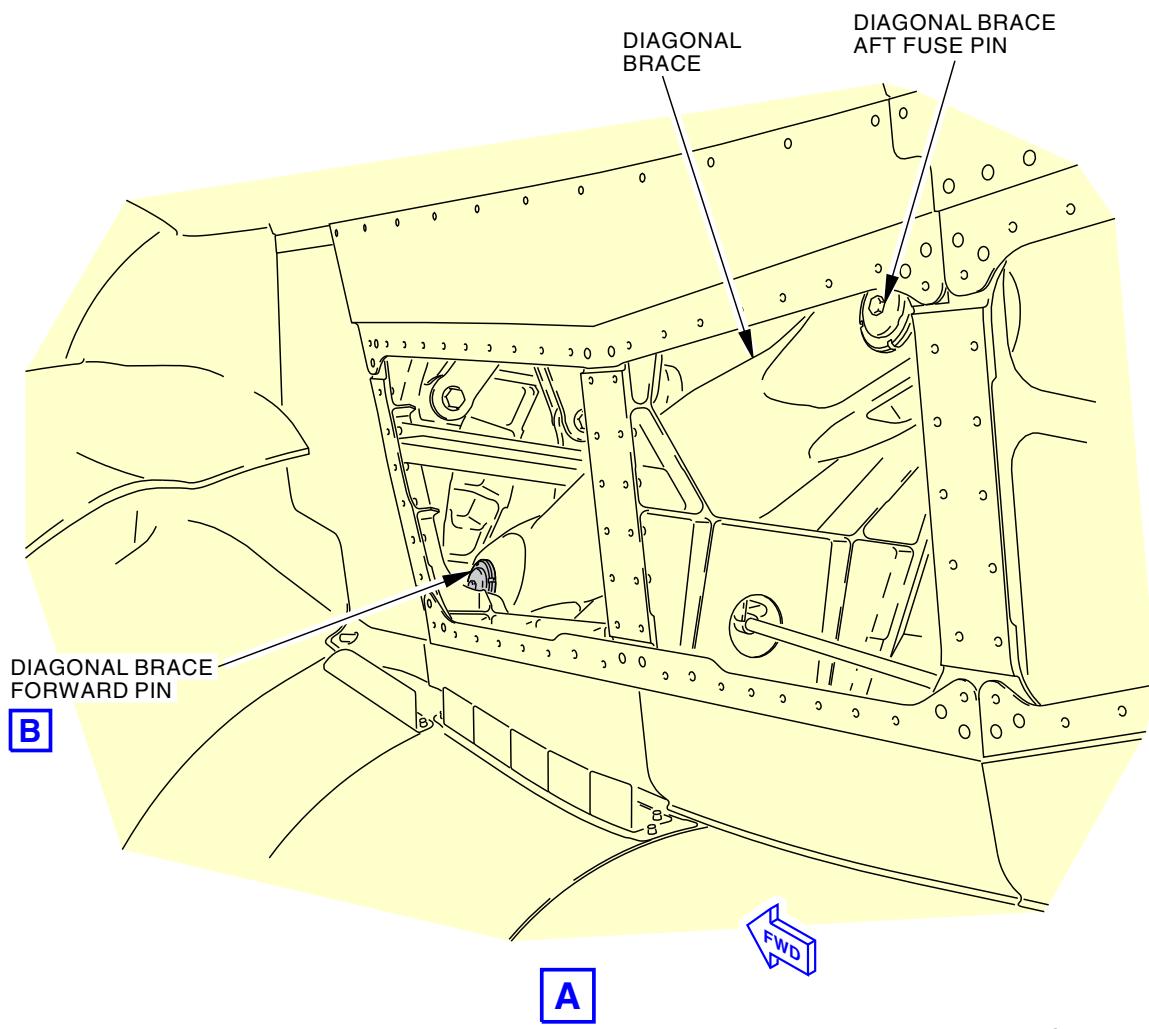
Diagonal Brace Forward Pin Installation
Figure 402/54-51-04-990-805 (Sheet 3 of 3)EFFECTIVITY
LOM ALL; AIRPLANES WITH BOLT PN 311A2097**54-51-04**

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details



LEFT STRUT
(RIGHT STRUT IS OPPOSITE)



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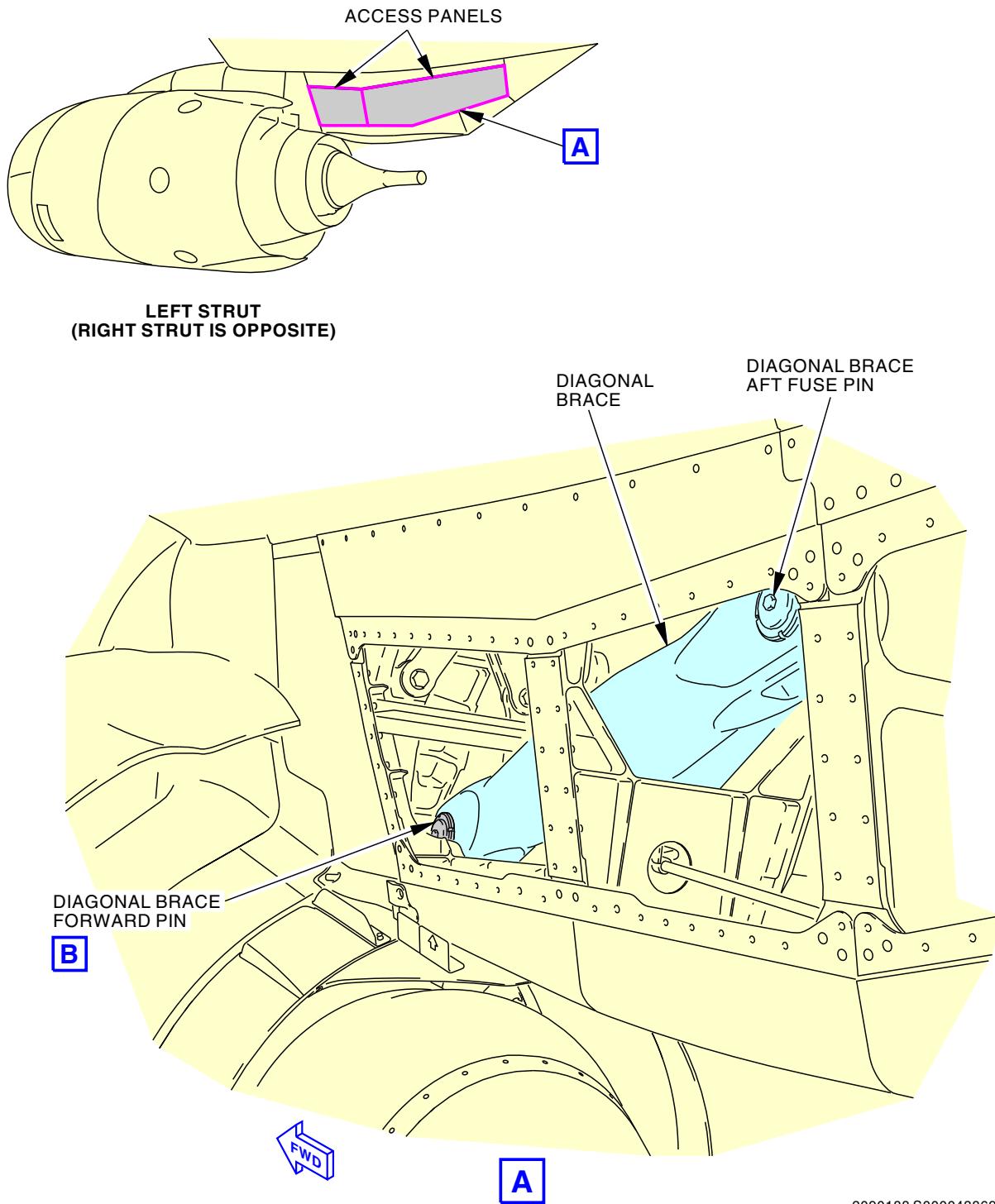
Diagonal Brace Forward Pin Installation
Figure 403/54-51-04-990-807 (Sheet 1 of 3)

EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-78-1089

54-51-04

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details



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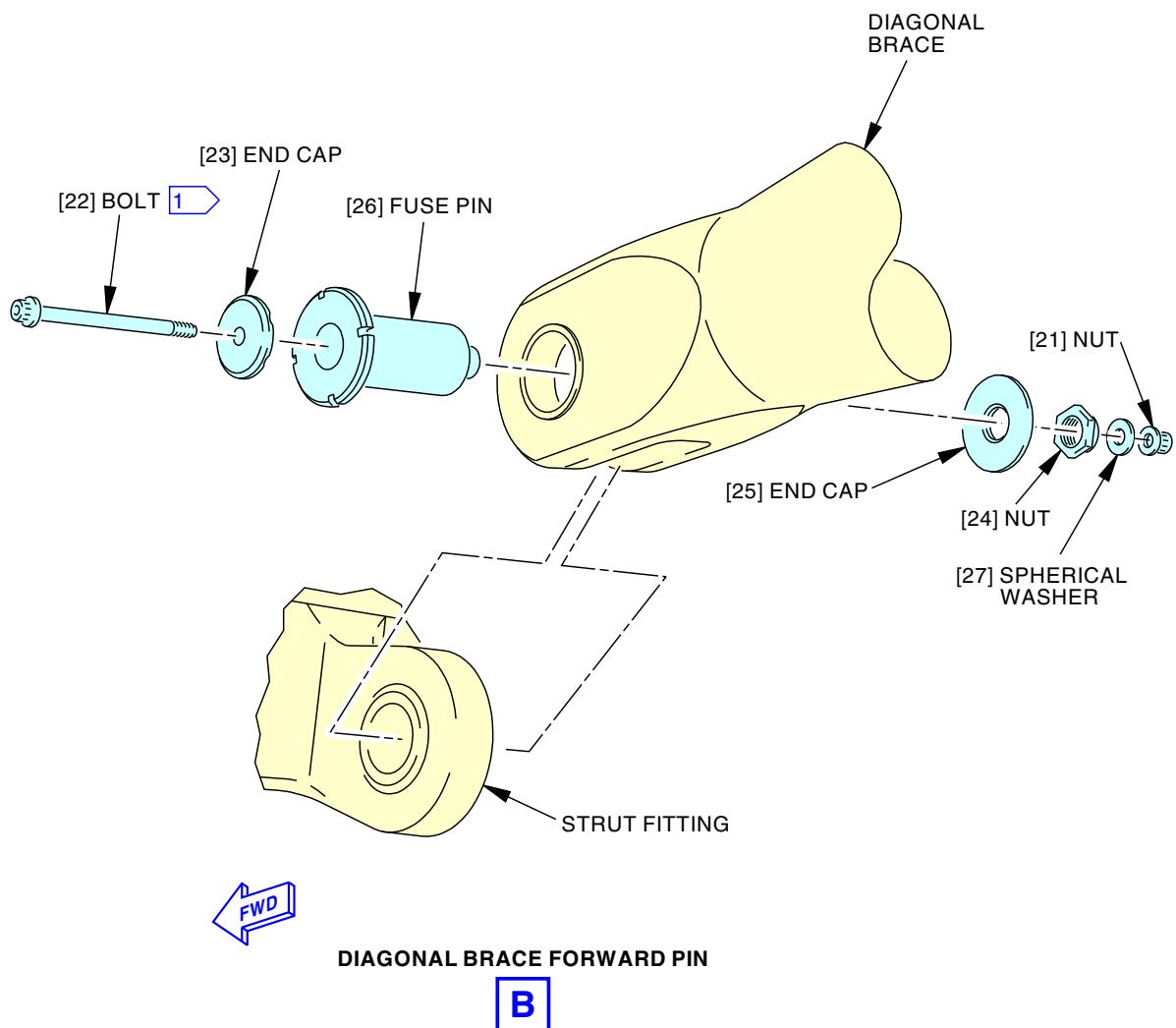
Diagonal Brace Forward Pin Installation
Figure 403/54-51-04-990-807 (Sheet 2 of 3)

EFFECTIVITY
 LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
 407, 411, 412, 415, 416, 420, 422-426 POST SB
 737-78-1089

54-51-04

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details



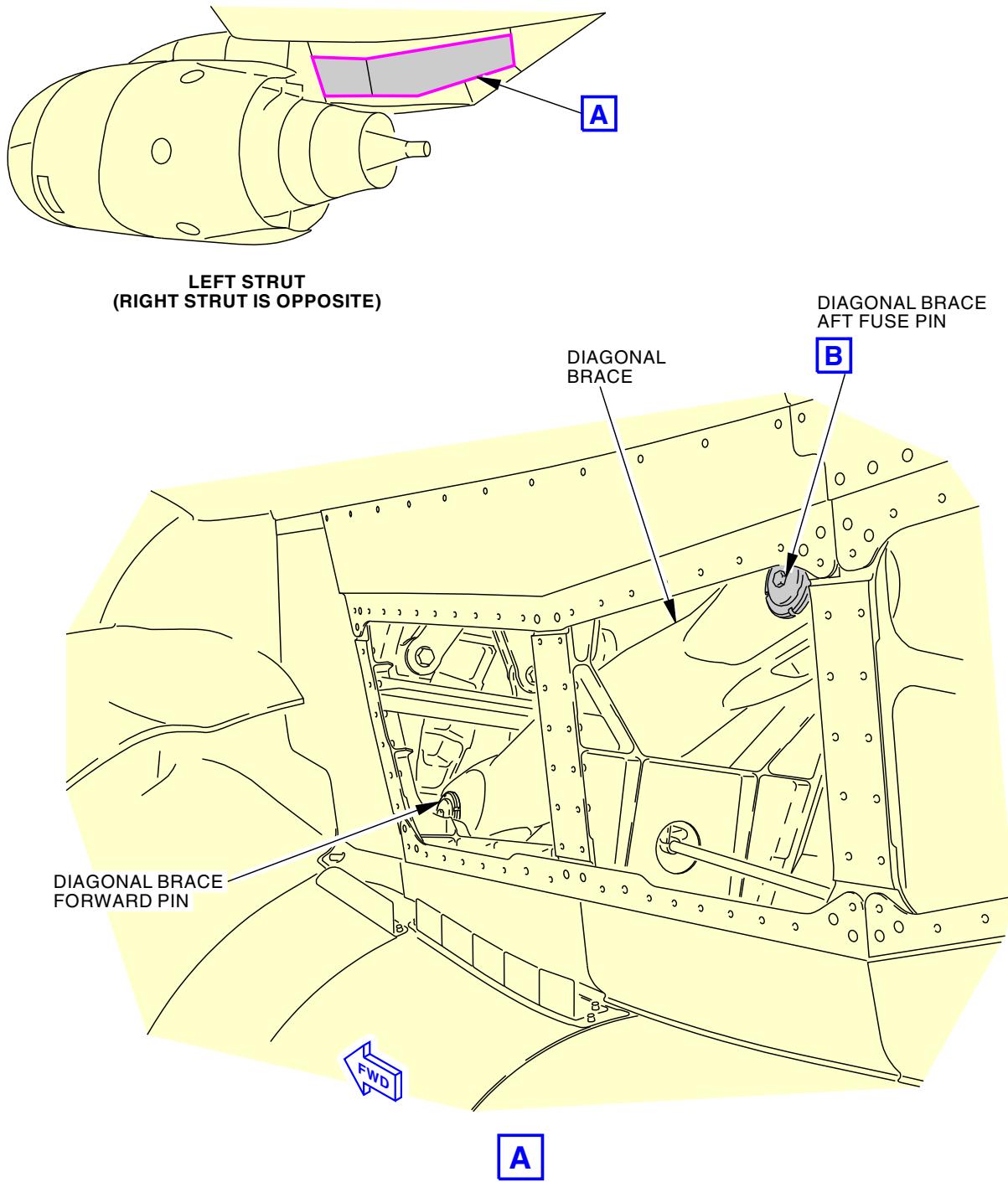
[1] BOLT MUST BE INSTALLED IN DIRECTION SHOWN.

1924784 S0000362545_V2

Diagonal Brace Forward Pin Installation
Figure 403/54-51-04-990-807 (Sheet 3 of 3)

EFFECTIVITY
LOM ALL; AIRPLANES WITH BOLT PN BACB30LE

54-51-04



H09394 S0006581146_V2

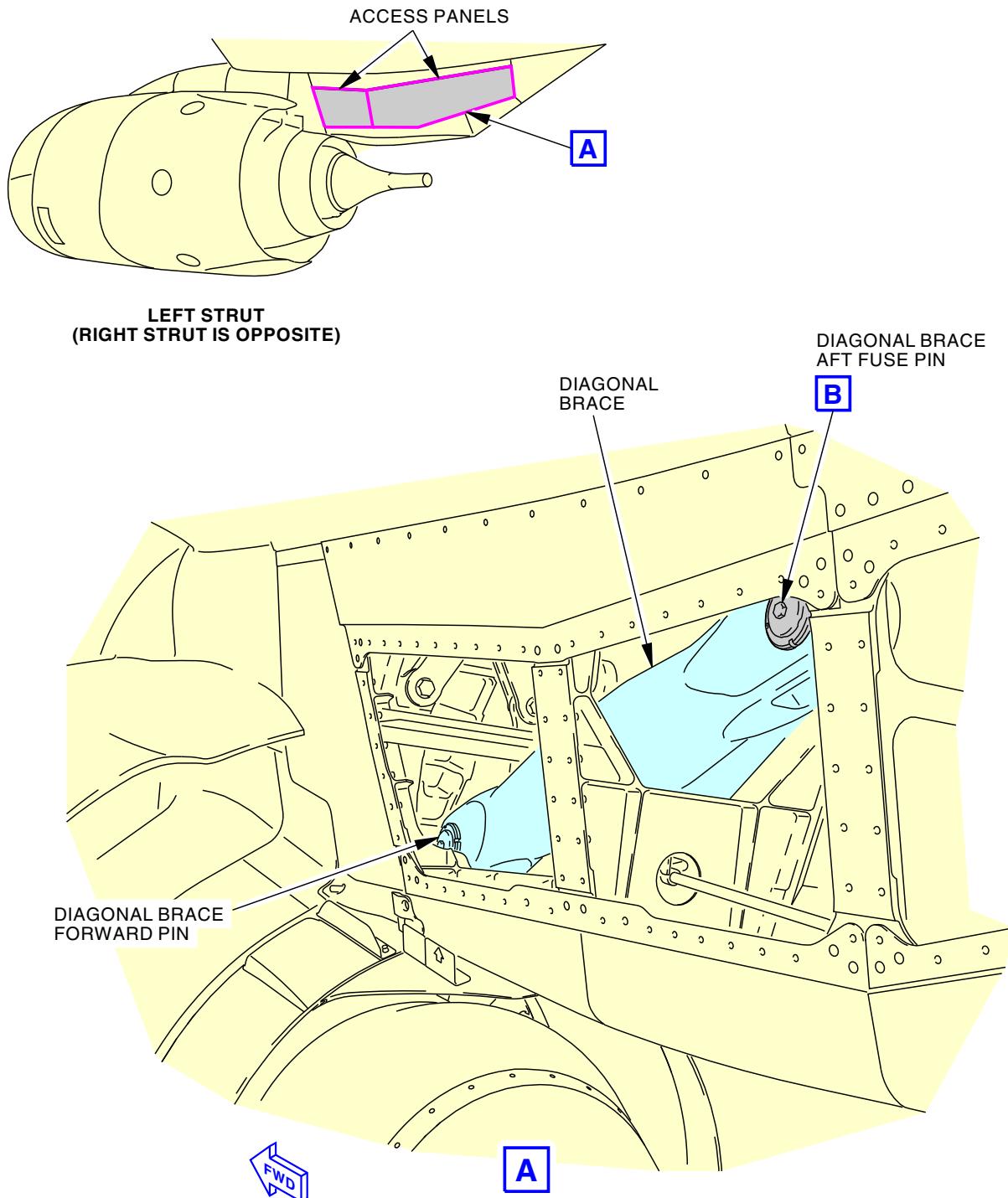
**Diagonal Brace Aft Fuse Pin Installation
Figure 404/54-51-04-990-806 (Sheet 1 of 3)**

EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-78-1089

54-51-04

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details



2090078 S0000438701_V2

Diagonal Brace Aft Fuse Pin Installation
Figure 404/54-51-04-990-806 (Sheet 2 of 3)

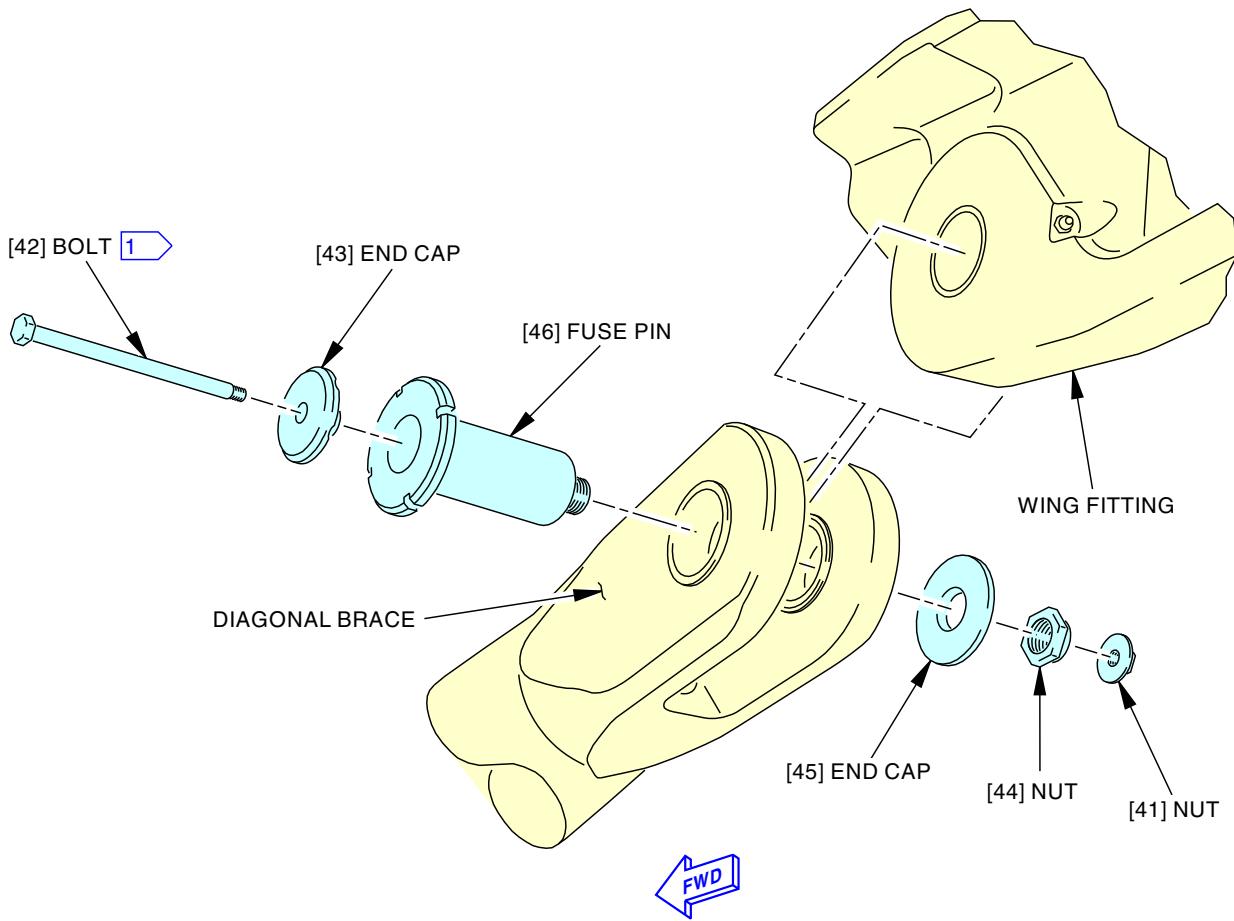
EFFECTIVITY
LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
407, 411, 412, 415, 416, 420, 422-426 POST SB
737-78-1089

54-51-04

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details


BOEING
 737-600/700/800/900
 AIRCRAFT MAINTENANCE MANUAL



 BOLT MUST BE INSTALLED IN DIRECTION SHOWN.

H09408 S0006581147_V3

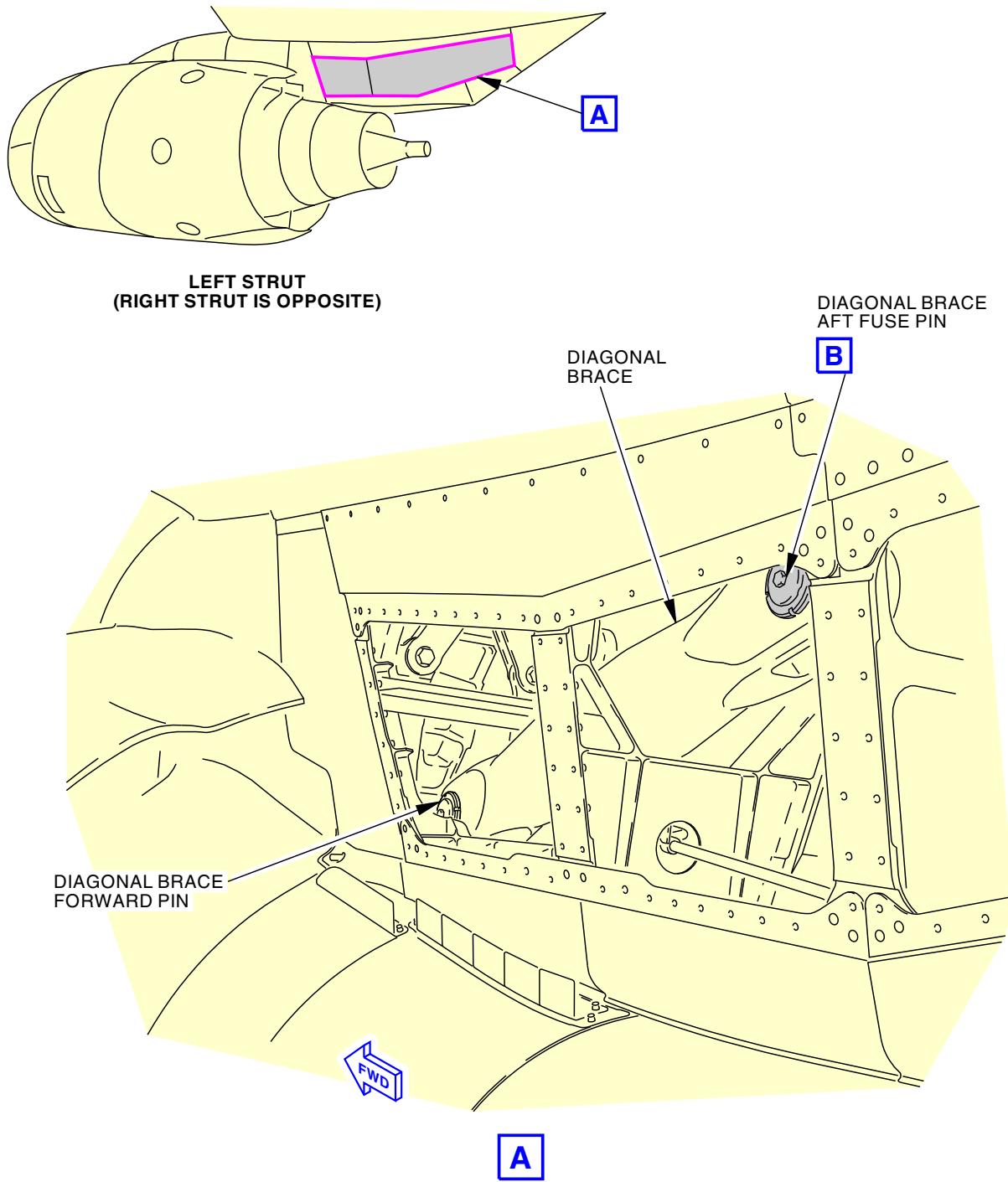
Diagonal Brace Aft Fuse Pin Installation
Figure 404/54-51-04-990-806 (Sheet 3 of 3)

EFFECTIVITY
LOM ALL; AIRPLANES WITH BOLT PN 311A2097

54-51-04



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AIRCRAFT MAINTENANCE MANUAL



H09394 S0006581146_V2

Diagonal Brace Aft Fuse Pin Installation
Figure 405/54-51-04-990-808 (Sheet 1 of 3)

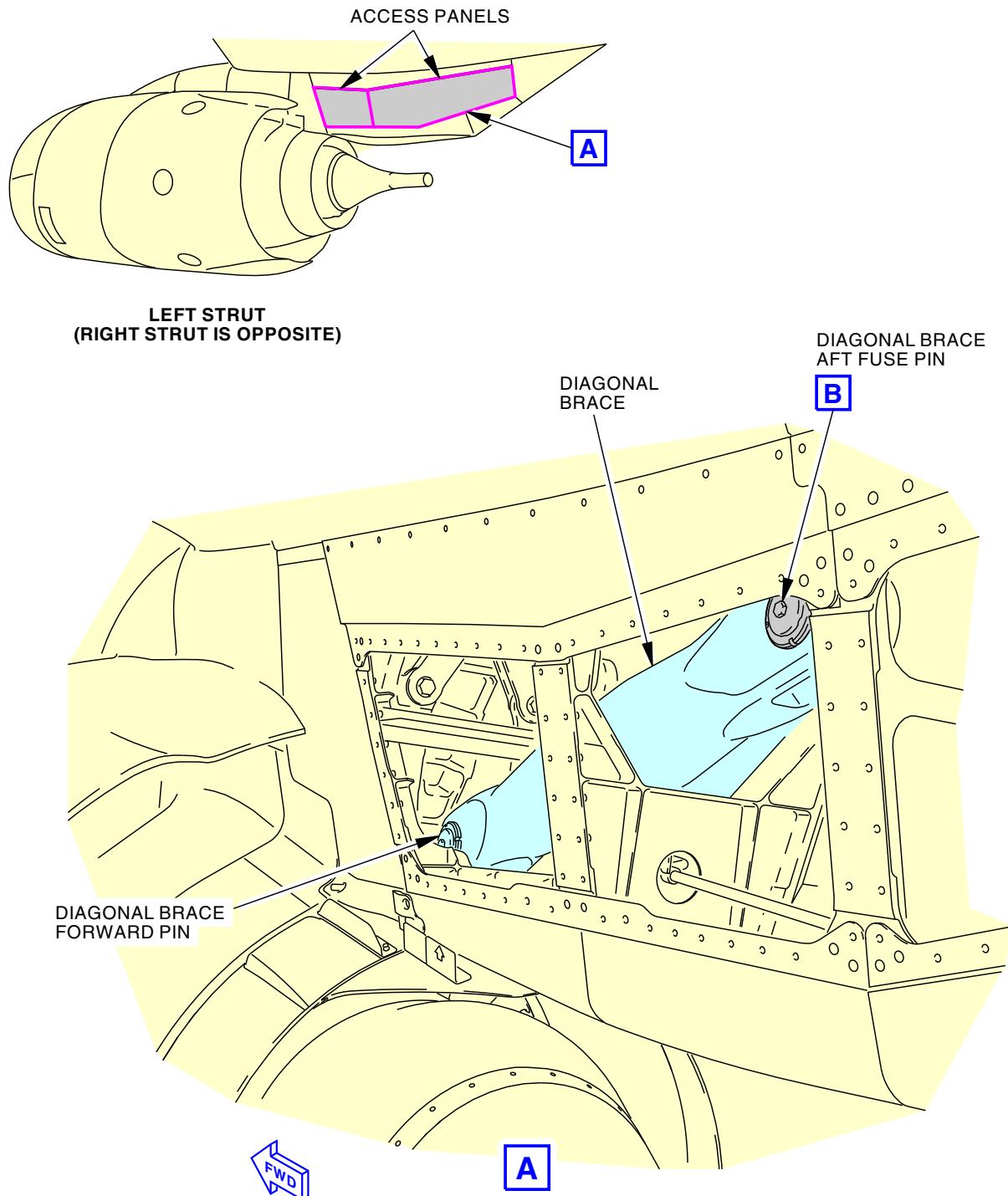
EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-78-1089

54-51-04

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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2090078 S0000438701_V2

Diagonal Brace Aft Fuse Pin Installation
Figure 405/54-51-04-990-808 (Sheet 2 of 3)

EFFECTIVITY
LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
407, 411, 412, 415, 416, 420, 422-426 POST SB
737-78-1089

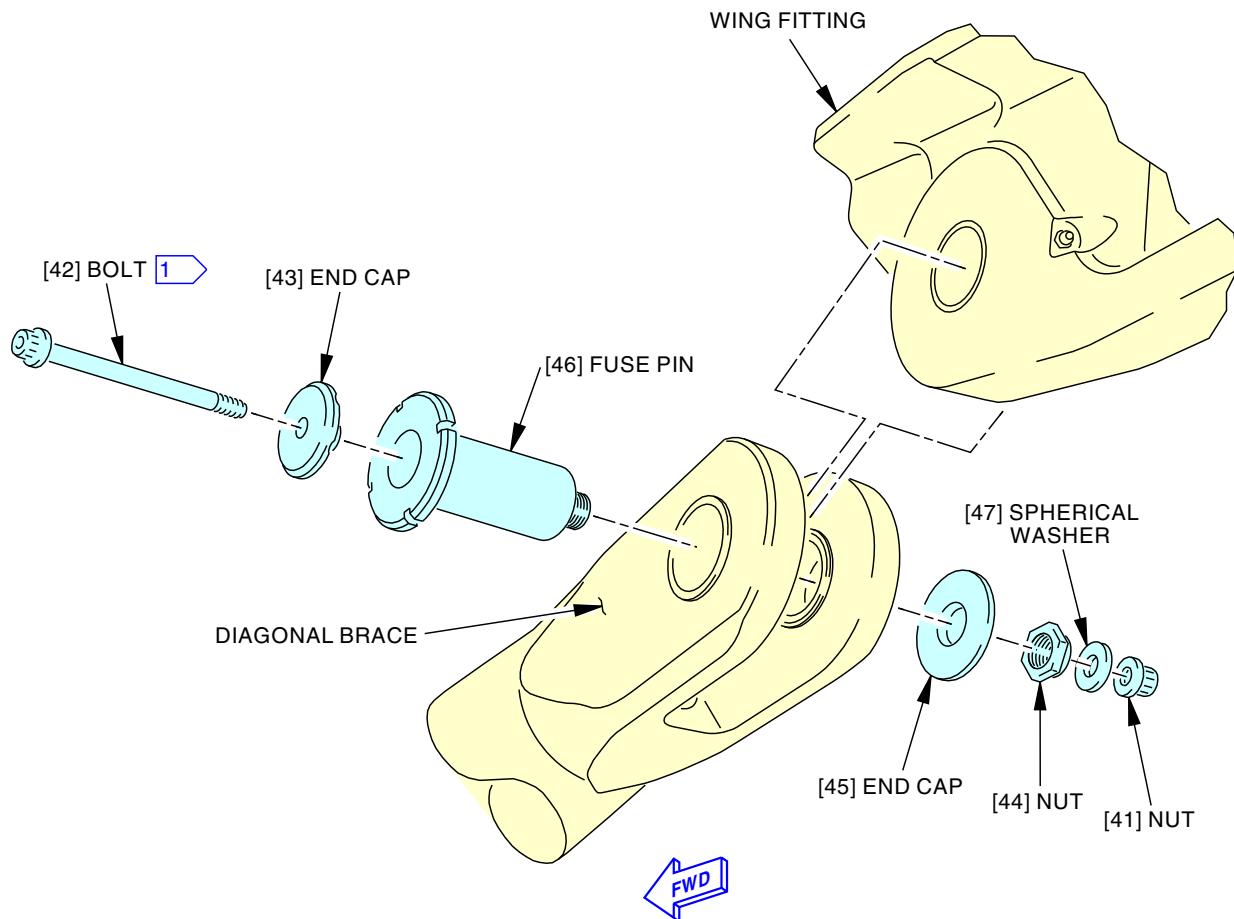
54-51-04

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details



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AIRCRAFT MAINTENANCE MANUAL



DIAGONAL BRACE AFT FUSE PIN

B

1 BOLT MUST BE INSTALLED IN DIRECTION SHOWN.

1924792 S0000362546_V2

Diagonal Brace Aft Fuse Pin Installation
Figure 405/54-04-990-808 (Sheet 3 of 3)

EFFECTIVITY
LOM ALL; AIRPLANES WITH BOLT PN BACB30LE

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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DIAGONAL BRACE - INSPECTION/CHECK

1. General

A. This procedure has these tasks:

- (1) Examine the aft fuse pin and bushings of the diagonal brace for worn areas.
- (2) Examine the forward pin and bushings of the diagonal brace for worn areas.

TASK 54-51-04-220-801

2. Diagonal Brace Aft Fuse Pin and Bushing Examination

(Figure 601)

A. General

- (1) This task examines the aft fuse pin in the diagonal brace for worn areas. This task also examines the bushings in the diagonal brace and the underwing fitting for worn areas.
- (2) This task has these steps:
 - (a) Remove the aft fuse pin.
 - (b) Measure the aft fuse pin and bushing dimensions.
 - (c) Make sure the dimensions are in the tolerances.
 - (d) Replace the aft fuse pin or bushings, if it is necessary.
 - (e) Install the aft fuse pin.
- (3) You can examine both diagonal brace pins at the same time, but both midspar fuse pins and both upper link pins must stay installed, unless you remove the strut.

B. References

Reference	Title
54-51-04-000-802	Diagonal Brace Forward/Aft Fuse Pin Removal (P/B 401)
54-51-04-400-802	Diagonal Brace Fuse Pin Installation (P/B 401)
SRM 54-50-90	Structural Repair Manual

C. Location Zones

Zone	Area
410	Subzone - Engine 1
420	Subzone - Engine 2
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

D. Prepare for the Examination

SUBTASK 54-51-04-000-002

- (1) Do this task: Diagonal Brace Forward/Aft Fuse Pin Removal, TASK 54-51-04-000-802.

E. Fuse Pin and Bushing Examination

SUBTASK 54-51-04-220-001

- (1) Measure these dimensions:

- (a) Measure the outside diameter of the fuse pin for the diagonal brace.
- (b) Measure the inside diameter of the bushing in the underwing attach fitting.
- (c) Measure the inside diameter of the bushings in the aft end of the diagonal brace.



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SUBTASK 54-51-04-300-001

- (2) Make sure the dimensions are in the tolerances as specified in Table 601.

Table 601/54-51-04-993-805 Diagonal Brace Aft Fuse Pin Wear Limits

INDEX NO.	NAME OF THE PARTS THAT ARE IN CONTACT	DIM.	DIAMETER DESIGN LIMITS		WEAR LIMITS	
			MINIMUM inches/mm	MAXIMUM inches/mm	PERMITTED WEAR DIMENSIONS	MAX CLEARANCE
1	BUSHING (WING FITTING)	I.D.	1.7765 in 45.123 mm	1.7773 in 45.143 mm	1.7796 in 45.202 mm	0.0046 in 0.117 mm
	FUSE PIN	O.D.	1.7750 in 45.085 mm	1.7755 in 45.098 mm	1.7727 in 45.027 mm	
2	BUSHING (WING FITTING)	I.D.	1.7765 in 45.123 mm	1.7773 in 45.143 mm	1.7796 in 45.202 mm	0.0046 in 0.117 mm
	FUSE PIN	O.D.	1.7750 in 45.085 mm	1.7755 in 45.098 mm	1.7727 in 45.027 mm	

- (a) If the fuse pin dimensions are not in the tolerances, replace the fuse pin.
- (b) If the bushing dimensions in the aft underwing fitting are not in the tolerances, replace the bushing as specified in this procedure: (SRM 54-50-90).
- (c) If the bushing dimensions in the diagonal brace are not in the tolerances, replace the bushings.

F. Put the Airplane Back to its Usual Condition

SUBTASK 54-51-04-400-001

- (1) Do this task: Diagonal Brace Fuse Pin Installation, TASK 54-51-04-400-802.

———— END OF TASK ————

TASK 54-51-04-220-802

3. Diagonal Brace Forward Pin and Bushing Examination

(Figure 601)

A. General

- (1) This task examines the forward pin in the diagonal brace for worn areas. This task also examines the bushings in the diagonal brace and the strut attach fitting for worn areas.
- (2) This task has these steps:
 - (a) Remove the forward pin.
 - (b) Measure the forward pin and bushing dimensions.
 - (c) Make sure the dimensions are in the tolerances.
 - (d) Replace the forward pin or bushings, if it is necessary.

EFFECTIVITY
LOM ALL

54-51-04



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AIRCRAFT MAINTENANCE MANUAL

- (e) Install the forward pin.
- (3) You can examine both diagonal brace pins at the same time, but both midspur fuse pins and both upper link pins must stay installed, unless you remove the strut.

B. References

Reference	Title
54-51-04-000-802	Diagonal Brace Forward/Aft Fuse Pin Removal (P/B 401)
54-51-04-400-802	Diagonal Brace Fuse Pin Installation (P/B 401)
SRM 54-50-90	Structural Repair Manual

C. Location Zones

Zone	Area
410	Subzone - Engine 1
420	Subzone - Engine 2
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

D. Prepare for the Examination

SUBTASK 54-51-04-000-003

- (1) Do this task: Diagonal Brace Forward/Aft Fuse Pin Removal, TASK 54-51-04-000-802.

E. Pin and Bushing Examination

SUBTASK 54-51-04-220-002

- (1) Measure these dimensions:

- (a) Measure the outside diameter of the pin for the diagonal brace.
- (b) Measure the inside diameter of the bushings in the strut aft lower spar fitting.
- (c) Measure the inside diameter of the bushings in the forward end of the diagonal brace.

SUBTASK 54-51-04-300-002

- (2) Make sure the dimensions are in the tolerances as specified in Table 602.

Table 602/54-51-04-993-806 Diagonal Brace Forward Pin Wear Limits

INDEX NO.	NAME OF THE PARTS THAT ARE IN CONTACT	DIM.	DIAMETER DESIGN LIMITS		WEAR LIMITS	
			MINIMUM inches/mm	MAXIMUM inches/mm	Permitted Wear Dimensions	MAX. Clearance
3	BUSHING (DIAGONAL BRACE)	I.D.	1.9015 in 48.298 mm	1.9023 in 48.318 mm	1.9046 in 48.377 mm	0.0046 in 0.117 mm
	FUSE PIN	O.D.	1.9000 in 48.260 mm	1.9005 in 48.273 mm	1.8977 in 48.202 mm	
4	BUSHING (STRUT)	I.D.	1.9015 in 48.298 mm	1.9023 in 48.318 mm	1.9046 in 48.377 mm	0.0046 in

EFFECTIVITY
LOM ALL

54-51-04



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Table 602/54-51-04-993-806 Diagonal Brace Forward Pin Wear Limits (Continued)

INDEX NO.	NAME OF THE PARTS THAT ARE IN CONTACT	DIM.	DIAMETER DESIGN LIMITS		WEAR LIMITS	
			MINIMUM inches/mm	MAXIMUM inches/mm	Permitted Wear Dimensions	MAX. Clearance
	PIN	O.D.	1.9000 in 48.260 mm	1.9005 in 48.273 mm	1.8977 in 48.202 mm	0.117 mm

- (a) If the pin dimensions are not in the tolerances, replace the pin.
- (b) If the bushing dimensions in the strut aft lower spar fitting are not in the tolerances, replace the bushings as specified in this procedure: (SRM 54-50-90).
- (c) If the bushing dimensions in the diagonal brace are not in the tolerances, replace the bushings.

F. Put the Airplane Back to its Usual Condition

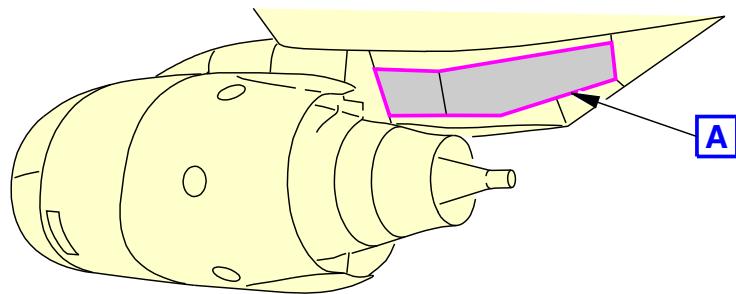
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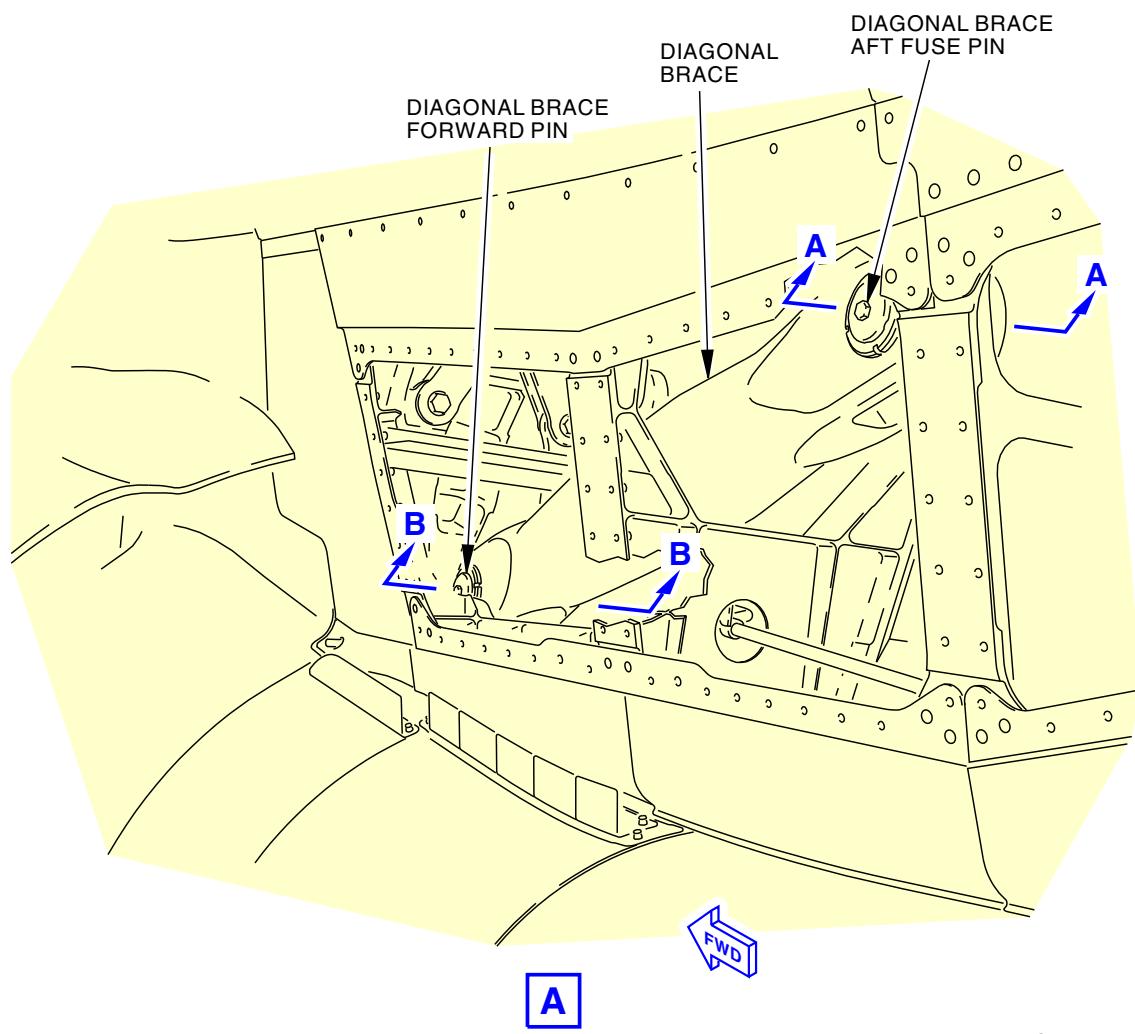
———— END OF TASK ————

— EFFECTIVITY —
LOM ALL

54-51-04



**LEFT STRUT
(RIGHT STRUT IS OPPOSITE)**



H01194 S0006581153_V2

**Diagonal Brace Examination
Figure 601/54-51-04-990-802 (Sheet 1 of 3)**

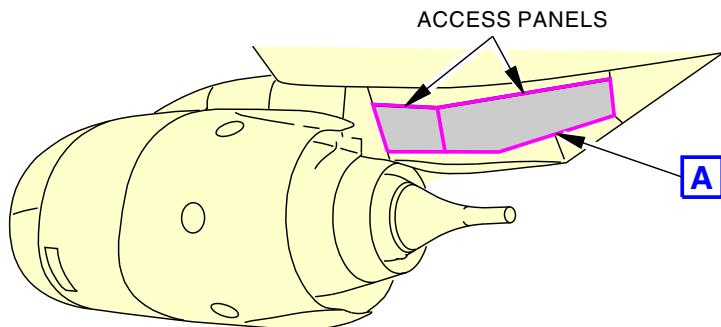
EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-78-1089

54-51-04

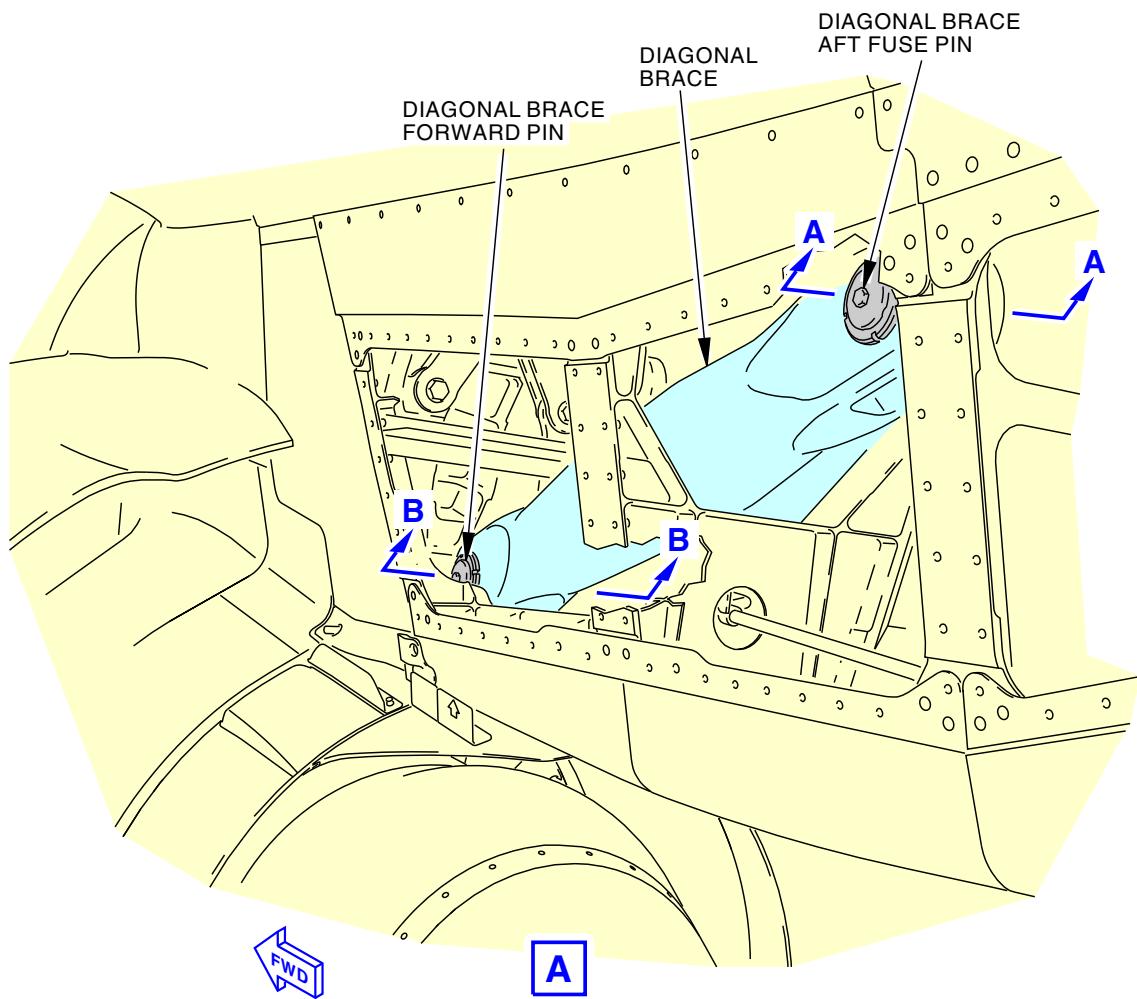
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**LEFT STRUT
(RIGHT STRUT IS OPPOSITE)**



2090238 S0000438729_V2

Diagonal Brace Examination
Figure 601/54-51-04-990-802 (Sheet 2 of 3)

EFFECTIVITY
LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
407, 411, 412, 415, 416, 420, 422-426 POST SB
737-78-1089

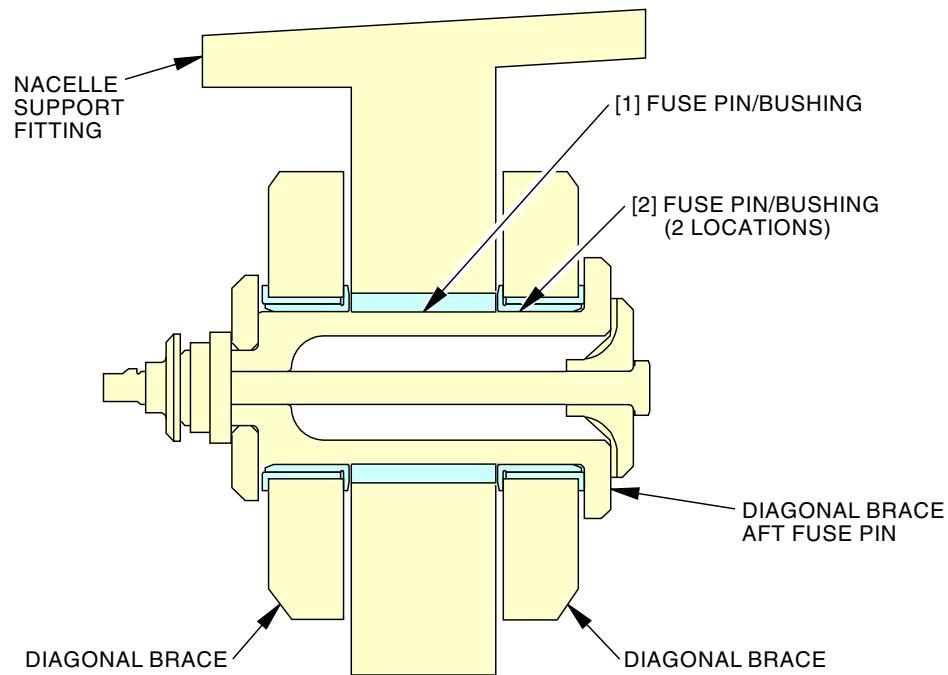
54-51-04

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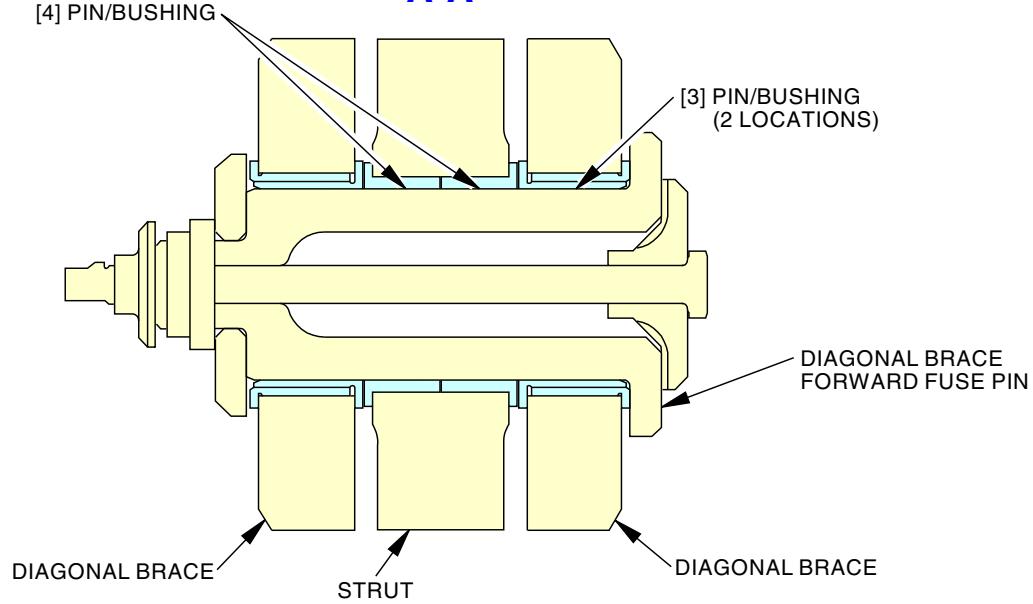
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DIAGONAL BRACE - WING
A-A



DIAGONAL BRACE - STRUT

B-B

H00920 S0006581154_V2

Diagonal Brace Examination
Figure 601/54-51-04-990-802 (Sheet 3 of 3)

EFFECTIVITY
LOM ALL

54-51-04



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SIDE LINK - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) A removal of the side links.
 - (2) An installation of the original side links.
 - (3) An installation of new side links.
 - (4) A removal of the lower shoulder bolt from the side links.
 - (5) An installation of the lower shoulder bolt in the side links.

TASK 54-51-05-000-801

2. Side Link Removal

(Figure 401)

A. General

- (1) This task removes the side links.
- (2) This task has these steps:
 - (a) Prepare the strut for maintenance operations.
 - (b) Get access to the side links.
 - (c) Make a mark of the airplane and strut location on each pair of side links that you will remove.
 - (d) Remove one side link.
- (3) Only one pair of side links may be removed at a time. One pair of side link must remain installed during removal of the other pair of side links.

B. References

Reference	Title
54-51-01-040-801	Prepare the Strut for Maintenance Operations (P/B 201)
54-52-06-010-801	Aft Fairing Access Panel Removal (P/B 401)

C. Tools/Equipment

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

Reference	Description
SPL-2020	Kit - Fuse Pin, Removal/Installation Part #: C54009-27 Supplier: 81205

D. Location Zones

Zone	Area
410	Subzone - Engine 1
420	Subzone - Engine 2
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

E. Access Panels

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

EFFECTIVITY
LOM ALL

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(Continued)

Number Name/Location

434AR	Aft Strut Fairing, Right Forward Panel, Strut 1
444AL	Aft Strut Fairing, Left Forward Panel, Strut 2
444AR	Aft Strut Fairing, Right Forward Panel, Strut 2

F. Prepare for the Removal

SUBTASK 54-51-05-040-001

- (1) Do this task: Prepare the Strut for Maintenance Operations, TASK 54-51-01-040-801.

SUBTASK 54-51-05-010-001

- (2) Open 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
444AL	Aft Strut Fairing, Left Forward Panel, Strut 2
444AR	Aft Strut Fairing, Right Forward Panel, Strut 2

G. Side Link Removal

SUBTASK 54-51-05-930-002

- (1) Make a mark or put a tag on each pair of side links [7] that you will remove, which identifies the airplane and strut location where it was removed.

NOTE: If you will not install the side links on the same side of the same strut where you remove them, do the task to install a new pair of side links (TASK 54-51-05-400-802).

LOM 402

SUBTASK 54-51-05-020-001



WARNING REMOVE ONLY ONE PAIR OF SIDE LINKS AT A TIME. IF YOU REMOVE BOTH, THE STRUT CAN MOVE SUDDENLY AND INJURY TO PERSONS OR DAMAGE TO THE EQUIPMENT CAN OCCUR.

- (2) Use the open-ended wrench from the fuse pin kit, SPL-2020, to remove the shoulder bolt [8] and nut [4] from the strut fitting.

NOTE: To remove the nut, press down the spring-loaded pawl on the threaded end of the bolt.

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

SUBTASK 54-51-05-020-005



WARNING REMOVE ONLY ONE PAIR OF SIDE LINKS AT A TIME. IF YOU REMOVE BOTH, THE STRUT CAN MOVE SUDDENLY AND INJURY TO PERSONS OR DAMAGE TO THE EQUIPMENT CAN OCCUR.

- (3) Remove the pin [10] from the shoulder bolt [8].

SUBTASK 54-51-05-020-008

- (4) Use the open-ended wrench from the fuse pin kit, SPL-2020, to remove the shoulder bolt [8] and nut [4] from the strut fitting.

EFFECTIVITY
LOM ALL

54-51-05



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LOM 402

SUBTASK 54-51-05-020-002

- (5) Use the open-ended wrench from the fuse pin kit, SPL-2020, to remove the shoulder bolt [2] and nut [4] from the wing fitting.

NOTE: To remove the nut, press down the spring-loaded pawl on the threaded end of the bolt.

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

SUBTASK 54-51-05-020-006

- (6) Remove the pin [10] from the shoulder bolt [2].

SUBTASK 54-51-05-020-009

- (7) Use the open-ended wrench from the fuse pin kit, SPL-2020, to remove the shoulder bolt [2], washer [9], and nut [4] from the wing fitting.

LOM ALL

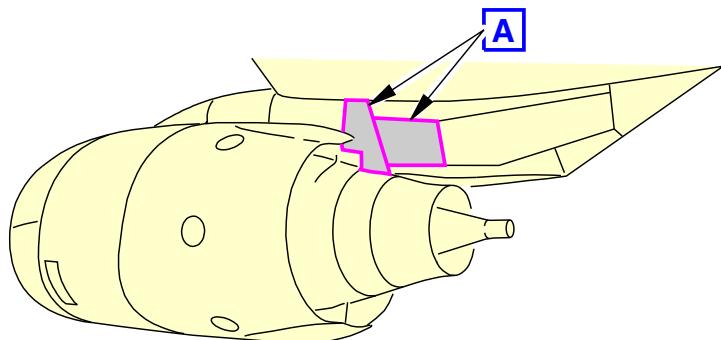
———— END OF TASK ————

EFFECTIVITY
LOM ALL

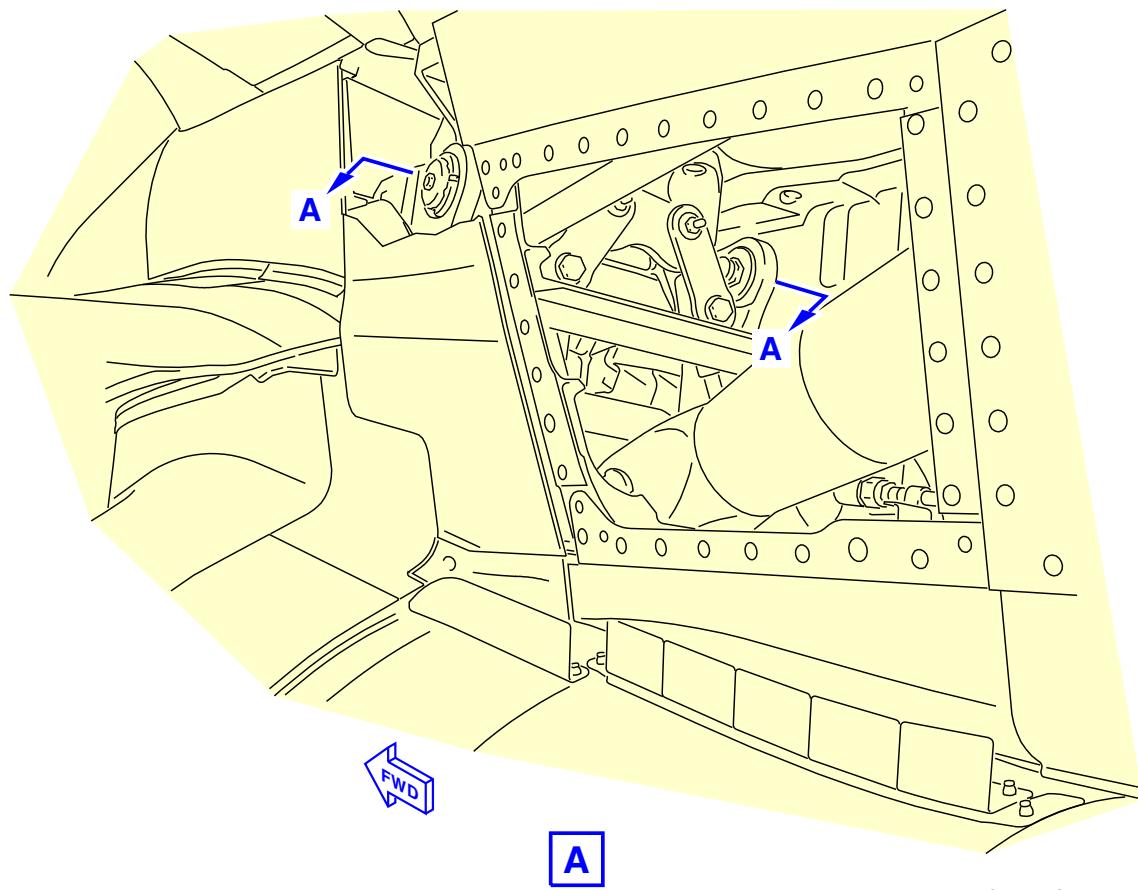
54-51-05



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LEFT STRUT
(RIGHT STRUT IS OPPOSITE)



G39289 S0006581162_V2

Side Links Installation
Figure 401/54-51-05-990-804 (Sheet 1 of 4)

EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-78-1089

54-51-05

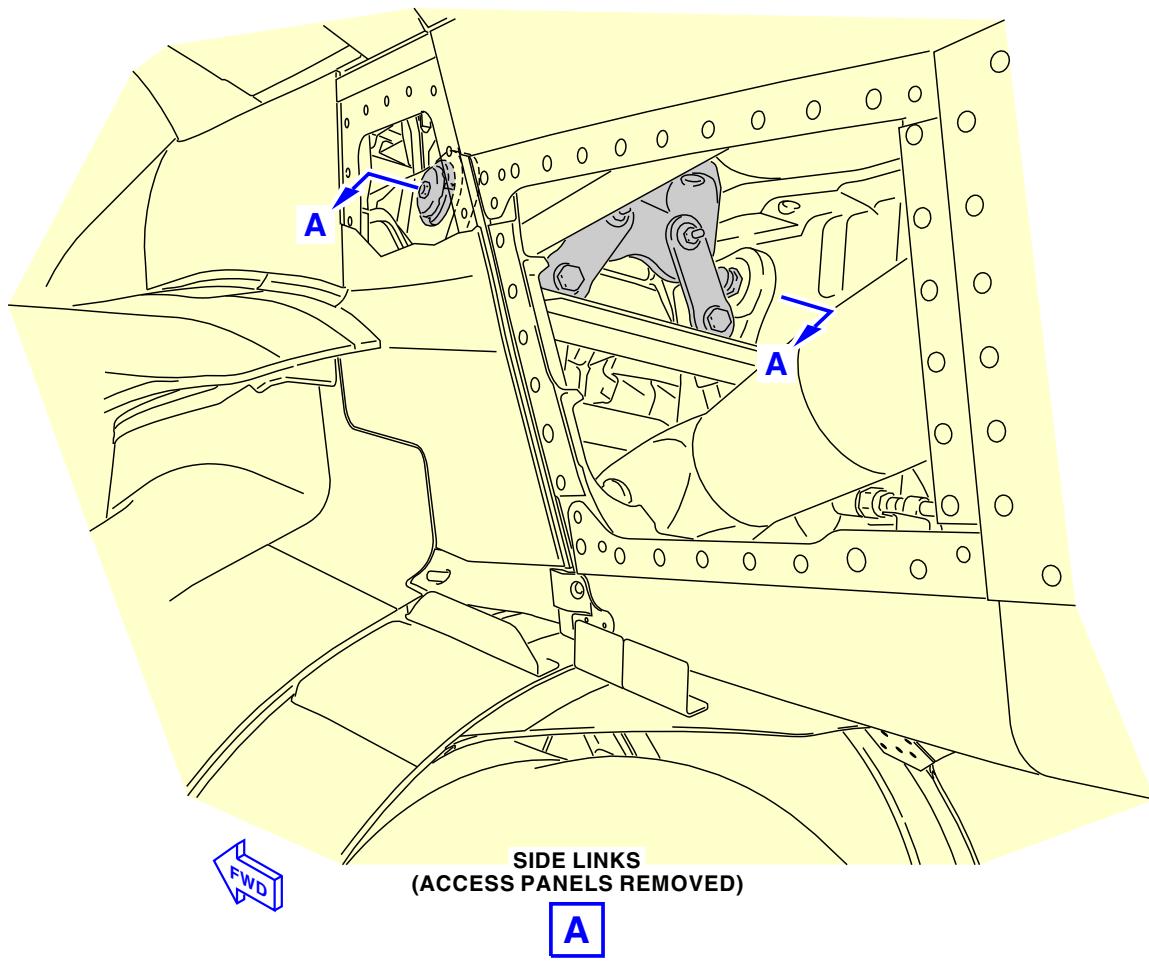
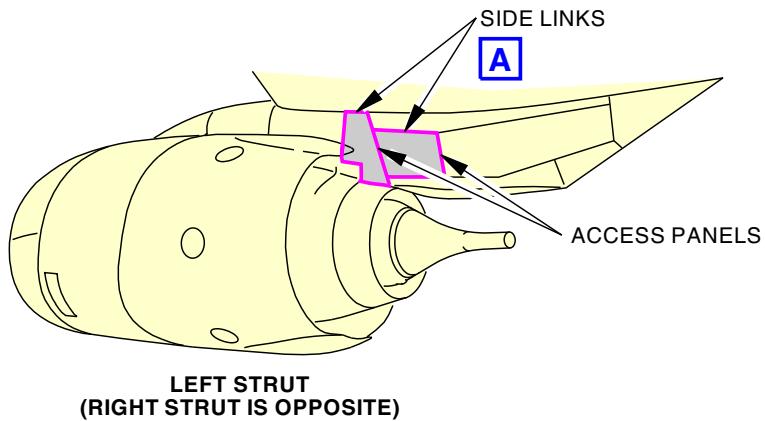
D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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2090329 S0000438918_V2

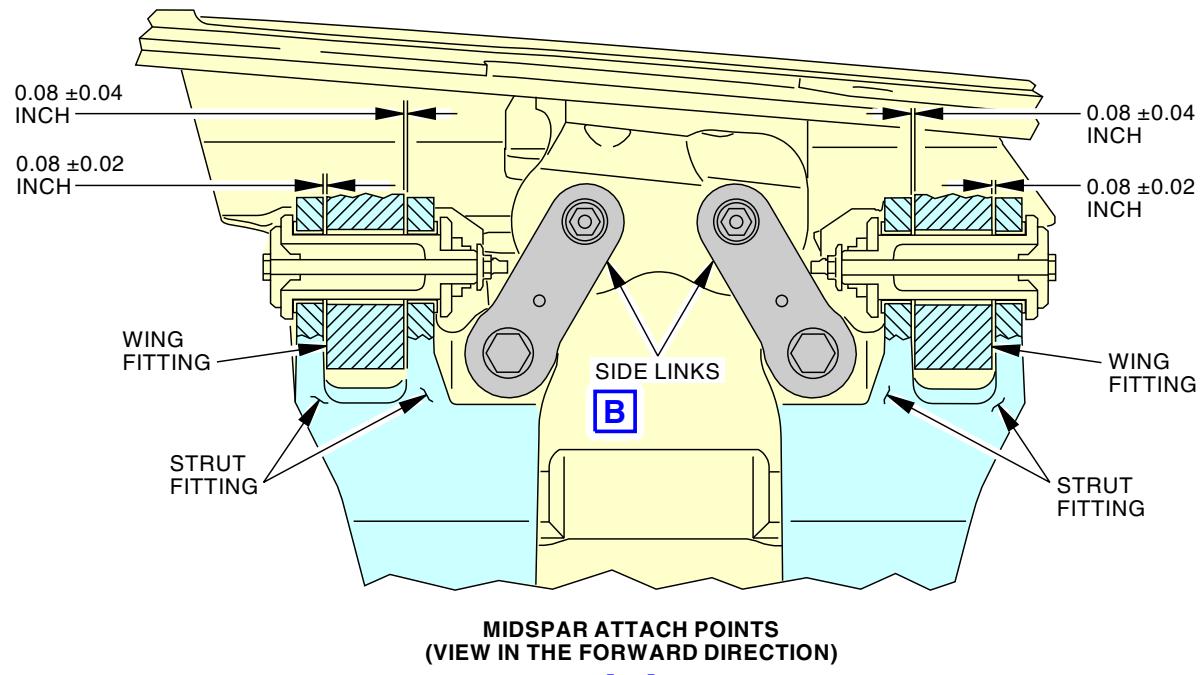
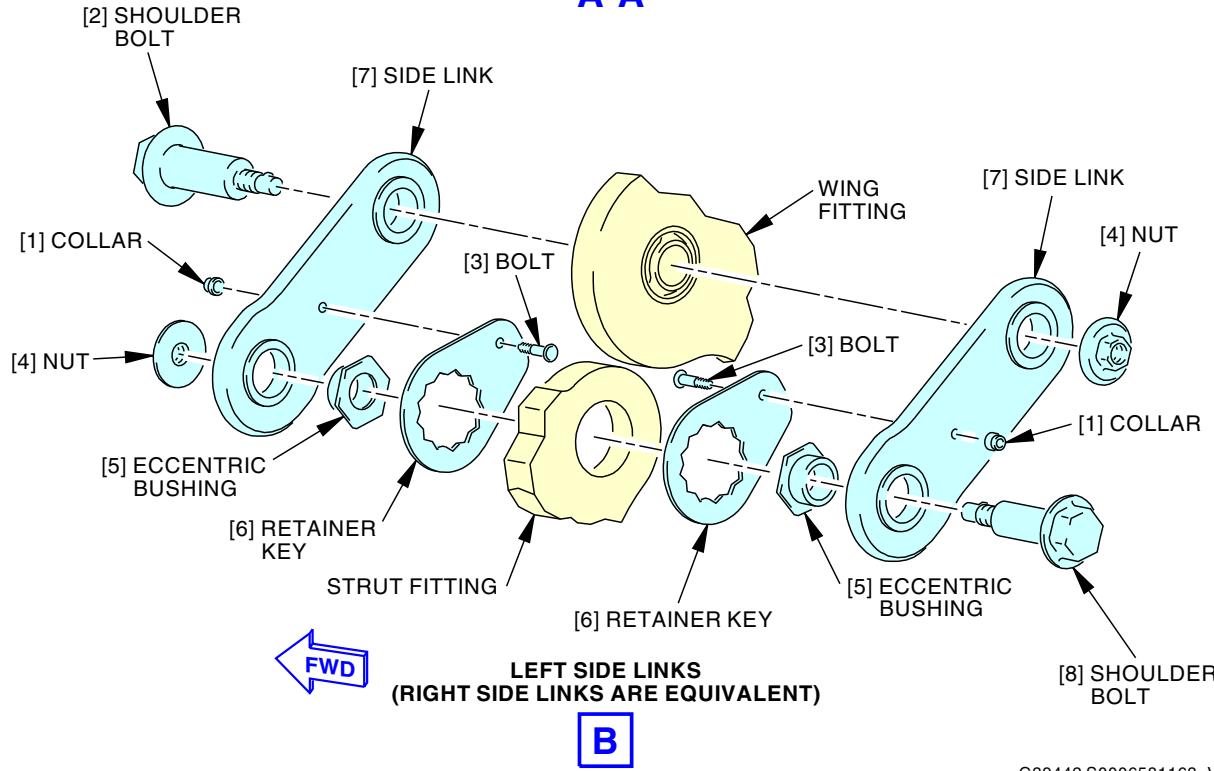
Side Links Installation
Figure 401/54-51-05-990-804 (Sheet 2 of 4)

EFFECTIVITY
LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
407, 411, 412, 415, 416, 420, 422-426 POST SB
737-78-1089

54-51-05

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D633A101-LOM


A-A


G39442 S0006581163_V3

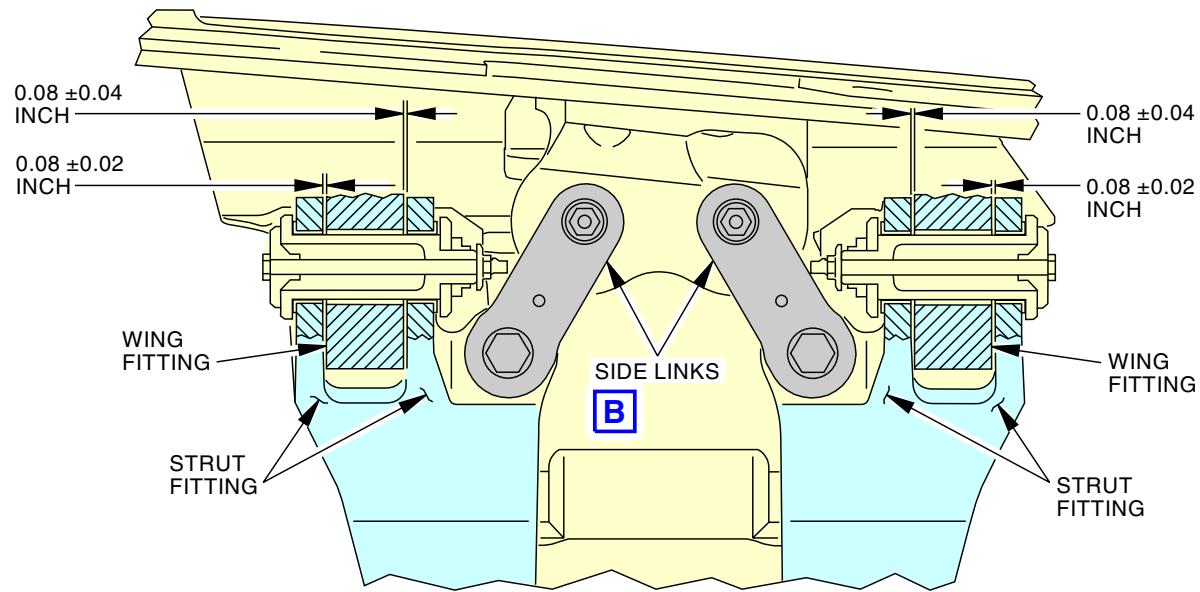
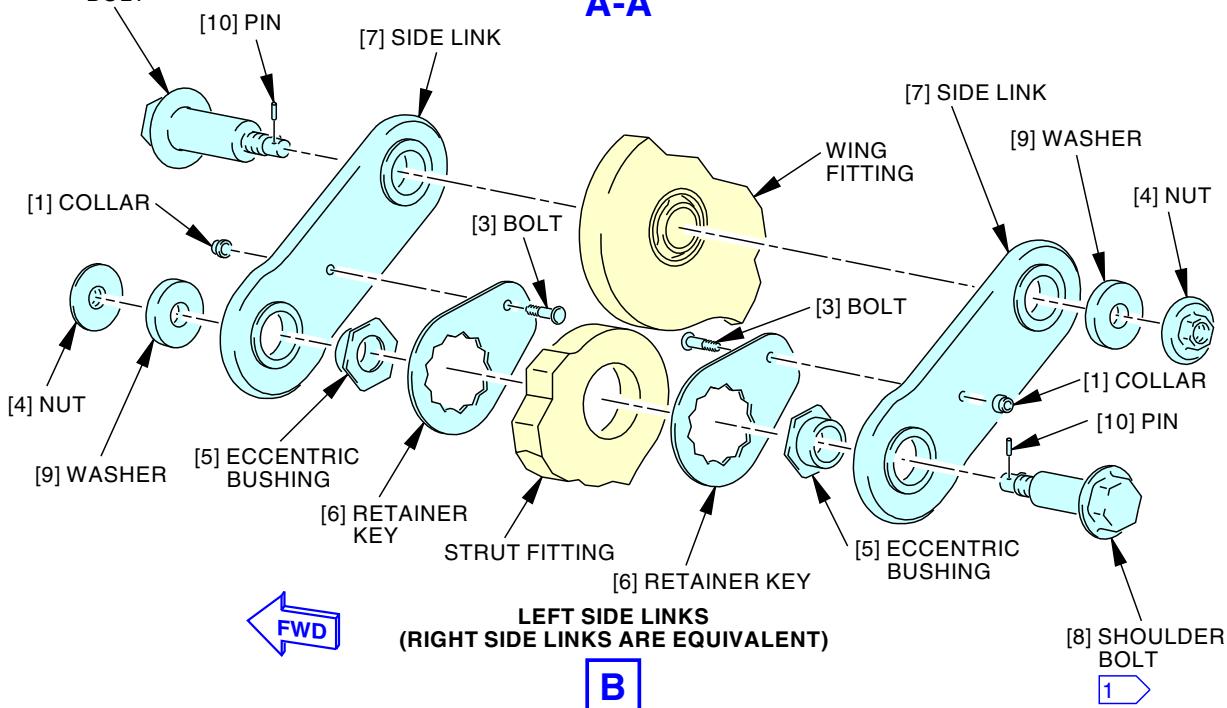
Side Links Installation
Figure 401/54-51-05-990-804 (Sheet 3 of 4)

EFFECTIVITY
LOM 402

54-51-05

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details


**MIDSPAR ATTACH POINTS
(VIEW IN THE FORWARD DIRECTION)**
A-A


1 THE SHOULDER BOLT MAY BE INSTALLED WITH OPPOSITE HEAD ORIENTATION TO THAT SHOWN

3033338 S0000803736_V1

Side Links Installation
Figure 401/54-51-05-990-804 (Sheet 4 of 4)

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

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TASK 54-51-05-400-801

3. Original Side Link Installation

(Figure 401)

A. General

- (1) This task installs the original side links which you removed in the removal task.
- (2) This task has these steps:
 - (a) Install the side links.
 - (b) Make sure that the distance between the wing fitting and the strut fitting is within tolerance.
 - (c) Close the access panels.
 - (d) Put the strut back to its usual condition.
- (3) Make sure that you install each pair of side links in the same location on the same airplane where you removed them.
 - (a) If you will not install the side links on the same side of the same strut where you remove them, you must do the task to install a new pair of side links (TASK 54-51-05-400-802).

B. References

Reference	Title
54-51-01-440-801	Put the Strut Back to its Usual Condition (P/B 201)
54-51-05-220-801	Strut Side Link Examination (P/B 601)
54-52-06-410-801	Aft Fairing Access Panel 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-2020	Kit - Fuse Pin, Removal/Installation Part #: C54009-27 Supplier: 81205

D. Consumable Materials

Reference	Description	Specification
D00006	Compound - Antiseize, Pure Nickel Special - Never-Seez NSBT-8N/-16N	
D00633	Grease - Aircraft General Purpose	BMS3-33

E. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
7	Side link	54-51-05-01-065	LOM ALL
10	Pin	54-51-05-01-029	LOM 404, 406, 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-999

F. Location Zones

Zone	Area
410	Subzone - Engine 1
420	Subzone - Engine 2

EFFECTIVITY	
LOM ALL	

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(Continued)

Zone	Area
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

G. Access Panels

Number	Name/Location
434AL	Aft Strut Fairing, Left Forward Panel, Strut 1
434AR	Aft Strut Fairing, Right Forward Panel, Strut 1
444AL	Aft Strut Fairing, Left Forward Panel, Strut 2
444AR	Aft Strut Fairing, Right Forward Panel, Strut 2

H. Original Side Link Installation

SUBTASK 54-51-05-200-001

- (1) Make sure that the components for the side links [7] are within wear limits, do this task: Strut Side Link Examination, TASK 54-51-05-220-801.

SUBTASK 54-51-05-210-001

- (2) Make sure that the orientation of the eccentric bushing [5] and retainer key [6] is correct.

SUBTASK 54-51-05-210-002

- (3) Make sure that you install each pair of side links [7] on the same side of the same strut where you removed them.

LOM 402

SUBTASK 54-51-05-420-001

- (4) Do these steps to install the side links [7] for the wing fitting and strut fitting:
 - (a) Apply a thin film of grease, D00633, to the shoulder bolt [2] for the wing fitting.
 - (b) Apply Pure Nickel Special compound, D00006, to the base and threads of the nut [4] for the wing fitting.
 - (c) Measure the run-on torque of the nut [4].
 - 1) If the run-on torque is not 9.5 in-lb (1.1 N·m) - 80 in-lb (9.0 N·m), replace the nut [4] and do the check again.
 - (d) Use the open-ended wrench from the fuse pin kit, SPL-2020, to install the shoulder bolt [2] and nut [4] at the wing fitting.
NOTE: Install the shoulder bolt with the head forward.
 - (e) Apply a thin film of grease, D00633, to the shoulder bolt [8] for the strut fitting.
 - (f) Apply Pure Nickel Special compound, D00006, to the base and threads of the nut [4] for the strut fitting.
 - (g) Measure the run-on torque of the nut [4].
 - 1) If the run-on torque is not 9.5 in-lb (1.1 N·m) - 80 in-lb (9.0 N·m), replace the nut [4] and do the check again.
 - (h) Use the open-ended wrench from the fuse pin kit, SPL-2020, to install the shoulder bolt [8] and nut [4] at the strut fitting.
NOTE: Install the shoulder bolt with the head aft.
 - (i) Tighten both of the nuts [4] to 150 in-lb (16.9 N·m) - 200 in-lb (22.6 N·m).
 - 1) Make sure that the spring loaded pawl on the shoulder bolt [2] and shoulder bolt [8] is fully extended after nuts [4] are tightened.



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LOM 402 (Continued)

- (j) Make sure that all parts are seated firmly.

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

SUBTASK 54-51-05-420-005

- (5) Do these steps to install the side links [7] for the wing fitting and strut fitting:
 - (a) Apply a thin film of grease, D00633, to the shoulder bolt [2] for the wing fitting.
 - (b) Apply Pure Nickel Special compound, D00006, to the base and threads of the nut [4] for the wing fitting.
 - (c) Measure the run-on torque of the nut [4].
 - 1) If the run-on torque is not 9.5 in-lb (1.1 N·m) - 80 in-lb (9.0 N·m), replace the nut [4] and do the check again.
 - (d) Use the open-ended wrench from the fuse pin kit, SPL-2020, to install the shoulder bolt [2], washer [9], and nut [4] at the wing fitting.
NOTE: Install the shoulder bolt with the heat forward.
 - (e) Apply a thin film of grease, D00633, to the shoulder bolt [8] for the strut fitting.
 - (f) Apply Pure Nickel Special compound, D00006, to the base and threads of the nut [4] for the strut fitting.
 - (g) Measure the run-on torque of the nut [4].
 - 1) If the run-on torque is not 9.5 in-lb (1.1 N·m) - 80 in-lb (9.0 N·m), replace the nut [4] and do the check again.
 - (h) Use the open-ended wrench from the fuse pin kit, SPL-2020, to install the shoulder bolt [8], washer [9], and nut [4] at the strut fitting.
NOTE: The shoulder bolt may be installed with opposite head orientation to that shown.
 - (i) Tighten both of the nuts [4] to 150 in-lb (16.9 N·m) - 200 in-lb (22.6 N·m).
 - (j) Install the new pins [10].
 - (k) Make sure that all parts are seated firmly.

LOM ALL

SUBTASK 54-51-05-420-002

- (6) If the other pair of the side links [7] are removed, do the steps above.

SUBTASK 54-51-05-220-001

- (7) Make sure that the distance between the wing fitting and the strut fitting is in the tolerance (Figure 401).

I. Put the Airplane Back to Its Usual Condition

SUBTASK 54-51-05-410-001

- (1) Close 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
444AL	Aft Strut Fairing, Left Forward Panel, Strut 2
444AR	Aft Strut Fairing, Right Forward Panel, Strut 2

EFFECTIVITY
LOM ALL

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SUBTASK 54-51-05-440-001

- (2) If you will do no more maintenance operations on the strut, do this task: Put the Strut Back to its Usual Condition, TASK 54-51-01-440-801.

———— END OF TASK ————

TASK 54-51-05-400-802

4. New Side Link Installation

(Figure 401)

A. General

- (1) This task installs new side links.
(2) This task has these steps:
- Make sure that the distance between the wing fitting and the strut fitting is within the tolerance at the midspur location.
 - Set the length of the side link locating jig between the wing fitting and the strut fitting.
 - Set the length of the side links on the side link locating jig.
 - You must set both side links on the same side of the same strut to the same length.
 - Install the side links.
 - Close the aft fairing forward access panels.
 - Put the strut back to its usual condition.

B. References

Reference	Title
54-51-01-440-801	Put the Strut Back to its Usual Condition (P/B 201)
54-51-05-220-801	Strut Side Link Examination (P/B 601)
54-52-06-410-801	Aft Fairing Access Panel 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-2020	Kit - Fuse Pin, Removal/Installation Part #: C54009-27 Supplier: 81205
SPL-11578	Alignment Equipment - Eccentric Bushing, Engine Strut Side Links Part #: C54013-1 Supplier: 81205

D. Consumable Materials

Reference	Description	Specification
D00006	Compound - Antiseize, Pure Nickel Special - Never-Seez NSBT-8N/-16N	
D00633	Grease - Aircraft General Purpose	BMS3-33

E. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Collar	54-51-05-01-030	LOM ALL
7	Side link	54-51-05-01-065	LOM ALL

EFFECTIVITY
LOM ALL

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(Continued)

AMM Item	Description	AIPC Reference	AIPC Effectivity
10	Pin	54-51-05-01-029	LOM 404, 406, 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-999

F. Location Zones

Zone	Area
410	Subzone - Engine 1
420	Subzone - Engine 2
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

G. Access Panels

Number	Name/Location
434AL	Aft Strut Fairing, Left Forward Panel, Strut 1
434AR	Aft Strut Fairing, Right Forward Panel, Strut 1
444AL	Aft Strut Fairing, Left Forward Panel, Strut 2
444AR	Aft Strut Fairing, Right Forward Panel, Strut 2

H. New Side Link Installation

SUBTASK 54-51-05-200-002

- (1) Make sure that the components for the side links [7] are within wear limits, do this task: Strut Side Link Examination, TASK 54-51-05-220-801.

SUBTASK 54-51-05-820-001

- (2) Install a temporary shim to set the distance between the wing fitting and the strut fitting at the midspur location (Figure 401).

SUBTASK 54-51-05-820-002

- (3) Do these steps to set the length of the side link [7]:

- (a) Install the bushing alignment equipment, SPL-11578, between the wing fitting and the strut fitting in the location of one pair of the side links [7].
 - 1) Lock the position of the side link locating jig for one side of one strut.
 - 2) Remove the side link locating jig.
- (b) Do these steps for both side links [7] on the same side of the same strut to set the length:
 - 1) Put the side link [7] in the side link locating jig.
 - a) Apply a thin film of grease, D00633, to the outer diameter of an eccentric bushing [5].
 - b) Turn the eccentric bushing [5] until you get the correct length.
 - c) Install the eccentric bushing [5].
 - d) Carefully remove the side link [7] from the side link locating jig.
 - e) Do these steps again for the other side link [7] on the same side of the same strut, using the opposite side of the tool base plate of the side link locating jig.
 - 2) Put the retainer key [6] over the eccentric bushing [5].
 - a) Make sure that the drilled hole in the retainer key [6] has a minimum edge margin of 0.38 in. (9.65 mm).



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- b) If it is necessary, turn over the retainer key [6].
- c) Use a handle drill bushing and a drill to make a pilot hole through the retainer key [6] and the side link [7].
NOTE: The pilot hole should be less than 0.25 in. (6.35 mm) diameter.
- 3) Drill a 0.250 in. (6.350 mm) - 0.254 in. (6.452 mm) diameter hole through the existing pilot hole in the retainer key [6] and into the side link [7].
 - a) Remove the burrs or sharp edges.
- 4) Install the bolt [3] and collar [1] that attach the retainer key [6] to the side link [7] (Figure 401).
 - a) Make sure that the head of the bolt [3] is on the same side of the side link [7] as the retainer key [6].

LOM 402

SUBTASK 54-51-05-420-003

- (4) Do these steps to install the side links [7] for the wing fitting and strut fitting:
 - (a) Apply a thin film of grease, D00633, to the shoulder bolt [2] for the wing fitting.
 - (b) Install the shoulder bolt [2] through the two recently sized side links [7] on the wing fitting on the same side of the strut.
NOTE: Install the shoulder bolt with the head forward.
 - (c) Install the shoulder bolt [8] through the aft side link [7] and strut fitting until it aligns the hole of the forward side link [7].
NOTE: Install the shoulder bolt with the head aft.
 - (d) Clamp the side links [7] together.
NOTE: This will make sure that the lower shoulder bolt will go through the bottom hole of the forward side link completely.
 - (e) Apply a thin film of grease, D00633, to the shoulder bolt [8] for the strut fitting.
 - (f) Tap the shoulder bolt [8] completely through with a rubber mallet.
 - (g) Apply Pure Nickel Special compound, D00006, to the base and threads of the nut [4] for the wing fitting.
 - (h) Measure the run-on torque of the nut [4].
 - 1) If the run-on torque is not 9.5 in-lb (1.1 N·m) - 80 in-lb (9.0 N·m), replace the and do the check again.
 - (i) Use the open-ended wrench from the fuse pin kit, SPL-2020, to install the shoulder bolt [2] and nut [4] at the wing fitting.
 - (j) Apply Pure Nickel Special compound, D00006, to the base and threads of the nut [4] for the strut fitting.
 - (k) Measure the run-on torque of the nut [4].
 - 1) If the run-on torque is not 9.5 in-lb (1.1 N·m) - 80 in-lb (9.0 N·m), replace the nut and do the check again.
 - (l) Use the open-ended wrench from the fuse pin kit, SPL-2020, to install the shoulder bolt [8] and nut [4] at the strut fitting.
 - (m) Tighten both of the nuts [4] to 150.0 in-lb (16.9 N·m) - 200.0 in-lb (22.6 N·m).

EFFECTIVITY
LOM ALL

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LOM 402 (Continued)

- 1) Make sure that the spring loaded pawl on the shoulder bolt [2] and shoulder bolt [8] is fully extended after the nuts [4] are tightened.
- (n) Make sure that all parts are seated firmly.

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

SUBTASK 54-51-05-420-006

- (5) Do these steps to install the side links [7] for the wing fitting and strut fitting:
 - (a) Apply a thin film of grease, D00633, to the shoulder bolt [2] for the wing fitting.
 - (b) Install the shoulder bolt [2] through the two recently sized side links [7] on the wing fitting on the same side of the strut.

NOTE: Install the shoulder bolt with the head forward.
 - (c) Install the shoulder bolt [8] through the aft side link [7] and strut fitting until it aligns the hole of the forward side link [7].

NOTE: The shoulder bolt may be installed with opposite head orientation to that shown.
 - (d) Clamp the side links [7] together.

NOTE: This will make sure that the lower shoulder bolt will go through the bottom hole of the forward side link completely.
 - (e) Apply a thin film of grease, D00633, to the shoulder bolt [8] for the strut fitting.
 - (f) Tap the shoulder bolt [8] completely through with a rubber mallet.
 - (g) Apply Pure Nickel Special compound, D00006, to the base and threads of the nut [4] for the wing fitting.
 - (h) Measure the run-on torque of the nut [4].
 - 1) If the run-on torque is not 9.5 in-lb (1.1 N·m) - 80 in-lb (9.0 N·m), replace the nut and do the check again.
 - (i) Use the open-ended wrench from the fuse pin kit, SPL-2020, to install the shoulder bolt [2], washer [9], and nut [4] at the wing fitting.
 - (j) Apply Pure Nickel Special compound, D00006, to the base and threads of the nut [4] for the strut fitting.
 - (k) Measure the run-on torque of the nut [4].
 - 1) If the run-on torque is not 9.5 in-lb (1.1 N·m) - 80 in-lb (9.0 N·m), replace the nut [4] and do the check again.
 - (l) Use the open-ended wrench from the fuse pin kit, SPL-2020, to install the shoulder bolt [8], washer [9], and nut [4] at the strut fitting.
 - (m) Tighten both of the nuts [4] to 150.0 in-lb (16.9 N·m) - 200.0 in-lb (22.6 N·m).
 - (n) Install the new pins [10].
 - (o) Make sure that all parts are seated firmly.

LOM ALL

SUBTASK 54-51-05-420-004

- (6) If the other pair of side links [7] are removed, do the steps above to install them.

SUBTASK 54-51-05-020-007

- (7) Remove the temporary shims.

EFFECTIVITY
LOM ALL

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SUBTASK 54-51-05-220-002

- (8) Make sure that the distance between the wing fitting and the strut fitting is in the tolerance (Figure 401).

I. Put the Airplane Back to Its Usual Condition

SUBTASK 54-51-05-410-002

- (1) Close 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
444AL	Aft Strut Fairing, Left Forward Panel, Strut 2
444AR	Aft Strut Fairing, Right Forward Panel, Strut 2

SUBTASK 54-51-05-440-002

- (2) If you will do no more maintenance operations on the strut, do this task: Put the Strut Back to its Usual Condition, TASK 54-51-01-440-801.

— END OF TASK —

TASK 54-51-05-000-802

5. Lower Shoulder Bolt Removal

(Figure 401)

A. General

- (1) This task removes the lower shoulder bolt from the side links.
- (2) This task has these steps:
 - (a) Prepare the strut for maintenance operations.
 - (b) Get access to the side links.
 - (c) Remove the lower shoulder bolt from the side links.

B. References

Reference	Title
54-51-01-040-801	Prepare the Strut for Maintenance Operations (P/B 201)
54-52-06-010-801	Aft Fairing Access Panel Removal (P/B 401)

C. Tools/Equipment

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

Reference	Description
SPL-2020	Kit - Fuse Pin, Removal/Installation Part #: C54009-27 Supplier: 81205

D. Location Zones

Zone	Area
410	Subzone - Engine 1
420	Subzone - Engine 2
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

EFFECTIVITY
LOM ALL

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E. Access Panels

<u>Number</u>	<u>Name/Location</u>
434AL	Aft Strut Fairing, Left Forward Panel, Strut 1
434AR	Aft Strut Fairing, Right Forward Panel, Strut 1
444AL	Aft Strut Fairing, Left Forward Panel, Strut 2
444AR	Aft Strut Fairing, Right Forward Panel, Strut 2

F. Prepare for the Removal

SUBTASK 54-51-05-040-002

- (1) Do this task: Prepare the Strut for Maintenance Operations, TASK 54-51-01-040-801.

SUBTASK 54-51-05-010-002

- (2) Open 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
444AL	Aft Strut Fairing, Left Forward Panel, Strut 2
444AR	Aft Strut Fairing, Right Forward Panel, Strut 2

G. Lower Shoulder Bolt Removal

LOM 402

SUBTASK 54-51-05-020-003



WARNING

REMOVE ONLY ONE PAIR OF SIDE LINKS AT A TIME. IF YOU REMOVE BOTH, THE STRUT CAN MOVE SUDDENLY AND INJURY TO PERSONS OR DAMAGE TO THE EQUIPMENT CAN OCCUR.

- (1) Use the open-ended wrench from the fuse pin kit, SPL-2020, to remove the shoulder bolt [8] and nut [4] from the strut fitting.

NOTE: To remove the nut, press down the spring-loaded pawl on the threaded end of the shoulder bolt.

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

SUBTASK 54-51-05-020-004



WARNING

REMOVE ONLY ONE PAIR OF SIDE LINKS AT A TIME. IF YOU REMOVE BOTH, THE STRUT CAN MOVE SUDDENLY AND INJURY TO PERSONS OR DAMAGE TO THE EQUIPMENT CAN OCCUR.

- (2) Remove the pin [10] from the shoulder bolt [8].

SUBTASK 54-51-05-020-010

- (3) Use the open-ended wrench from the fuse pin kit, SPL-2020, to remove the shoulder bolt [8], washer [9], and nut [4] from the strut fitting.

LOM ALL

———— END OF TASK ————

———— EFFECTIVITY ————
LOM ALL

54-51-05



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TASK 54-51-05-400-803

6. Lower Shoulder Bolt Installation

(Figure 401)

A. General

- (1) This task installs the lower shoulder bolt in the side links.
- (2) This task has these steps:
 - (a) Install the lower shoulder bolt in the side links.
 - (b) Make sure that the distance between the wing fitting and the strut fitting is within tolerance.
 - (c) Close the access panels.
 - (d) Put the strut back to its usual condition.
- (3) If you install a strut which is not the same strut that you removed, do this task: New Side Link Installation, TASK 54-51-05-400-802.

B. References

Reference	Title
54-51-01-440-801	Put the Strut Back to its Usual Condition (P/B 201)
54-51-05-220-801	Strut Side Link Examination (P/B 601)
54-52-06-410-801	Aft Fairing Access Panel 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-2020	Kit - Fuse Pin, Removal/Installation Part #: C54009-27 Supplier: 81205

D. Consumable Materials

Reference	Description	Specification
D00006	Compound - Antiseize, Pure Nickel Special - Never-Seez NSBT-8N/-16N	
D00633	Grease - Aircraft General Purpose	BMS3-33

E. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
7	Side link	54-51-05-01-065	LOM ALL
10	Pin	54-51-05-01-029	LOM 404, 406, 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-999

F. Location Zones

Zone	Area
410	Subzone - Engine 1
420	Subzone - Engine 2
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut



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G. Access Panels

Number	Name/Location
434AL	Aft Strut Fairing, Left Forward Panel, Strut 1
434AR	Aft Strut Fairing, Right Forward Panel, Strut 1
444AL	Aft Strut Fairing, Left Forward Panel, Strut 2
444AR	Aft Strut Fairing, Right Forward Panel, Strut 2

H. Lower Shoulder Bolt Installation

SUBTASK 54-51-05-200-006

- (1) Make sure that the components for the side links [7] are within wear limits, do this task: Strut Side Link Examination, TASK 54-51-05-220-801.

LOM 402

SUBTASK 54-51-05-200-003

- (2) Do these steps to install the shoulder bolt [8] at the strut fitting:
 - (a) Apply a thin film of grease, D00633, to the shoulder bolt [8] for the strut fitting.
 - (b) Apply Pure Nickel Special compound, D00006, to the base and threads of the nut [4] for the strut fitting.
 - (c) Measure the run-on torque of the nut [4].
 - 1) If the run-on torque is not 9.5 in-lb (1.1 N·m) - 80 in-lb (9.0 N·m), replace the nut [4] and do the check again.
 - (d) Use the open-ended wrench from the fuse pin kit, SPL-2020, to install the shoulder bolt [8] and nut [4] at the strut fitting.
NOTE: Install the shoulder bolt with the head aft.
 - (e) Tighten the nut [4] to 150 in-lb (16.9 N·m) - 200 in-lb (22.6 N·m).
 - 1) Make sure that the spring loaded pawl on the shoulder bolt [8] is fully extended after the nut [4] is tightened.
 - (f) Make sure that all parts are seated firmly.

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

SUBTASK 54-51-05-200-005

- (3) Do these steps to install the shoulder bolt [8] at the strut fitting:
 - (a) Apply a thin film of grease, D00633, to the shoulder bolt [8] for the strut fitting.
 - (b) Apply Pure Nickel Special compound, D00006, to the base and threads of the nut [4] for the strut fitting.
 - (c) Measure the run-on torque of the nut [4].
 - 1) If the run-on torque is not 9.5 in-lb (1.1 N·m) - 80 in-lb (9.0 N·m), replace the nut [4] and do the check again.
 - (d) Use the open-ended wrench from the fuse pin kit, SPL-2020, to install the shoulder bolt [8], washer [9], and nut [4] at the strut fitting.
NOTE: The shoulder bolt may be installed with opposite head orientation to that shown.
 - (e) Tighten the nut [4] to 150 in-lb (16.9 N·m) - 200 in-lb (22.6 N·m).
 - (f) Install the new pin [10].
 - (g) Make sure that all parts are seated firmly.

LOM ALL

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SUBTASK 54-51-05-200-004

- (4) Make sure that the distance between the wing fitting and the strut fitting is in tolerance (Figure 401).

I. Put the Airplane Back to Its Usual Condition

SUBTASK 54-51-05-410-003

- (1) Close 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
444AL	Aft Strut Fairing, Left Forward Panel, Strut 2
444AR	Aft Strut Fairing, Right Forward Panel, Strut 2

SUBTASK 54-51-05-440-003

- (2) If you will do no more maintenance operations on the strut, do this task: Put the Strut Back to its Usual Condition, TASK 54-51-01-440-801.

———— END OF TASK ————

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STRUT SIDE LINK - INSPECTION/CHECK

1. General

- A. This procedure has this task:
- (1) Examine the strut side links and bushings for worn areas.

TASK 54-51-05-220-801

2. Strut Side Link Examination

(Figure 601)

A. General

- (1) This task examines the strut side links for worn areas. This task also examines the bearings in the underwing and strut midspar fittings for worn areas.
 - (a) Each strut has two side link assemblies.
 - (b) Each side link assembly includes two side links, two pins, and two eccentric bushings.
- (2) You must remove and examine one side link assembly at the same time. Do not change parts from one side link to a different side link.

B. References

Reference	Title
54-51-05-000-801	Side Link Removal (P/B 401)
54-51-05-400-801	Original Side Link Installation (P/B 401)
54-51-05-400-802	New Side Link Installation (P/B 401)

C. Location Zones

Zone	Area
410	Subzone - Engine 1
420	Subzone - Engine 2
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

D. Prepare for the Examination

SUBTASK 54-51-05-000-001

- (1) To remove the applicable side link, do this task: Side Link Removal, TASK 54-51-05-000-801.

SUBTASK 54-51-05-930-003

- (2) Make a mark or put a tag on each part of each side link assembly, which identifies the strut location where you removed it.

NOTE: If you do not install each side link assembly in the same location where you remove it, you must do the task to install a new pair of side links, (TASK 54-51-05-400-802).

E. Side Link Examination

SUBTASK 54-51-05-220-004

- (1) For each side link assembly that you will examine, measure these dimensions:
 - (a) Measure the outside diameter of the upper and lower side link pins.
 - (b) Measure the inside diameter of the upper and lower bushings in the side links.
 - (c) Measure the inside diameter and the outside diameter of the eccentric bushings.
 - (d) Measure the inside diameter and the outside diameter of the upper and lower bearing balls.

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(e) Measure the inside diameter of the upper and lower bearing races.

SUBTASK 54-51-05-300-001

(2) Make sure the dimensions are in the tolerances as specified in Table 601.

Table 601/54-51-05-993-803 Side Link Wear Limits

INDEX NO.	NAME OF THE PARTS THAT ARE IN CONTACT	DIM.	DIAMETER DESIGN LIMITS		WEAR LIMITS	
			Minimum inches / mm	Maximum inches / mm	Allowed Wear Dimension	Maximum Clearance
1	BUSHING	I.D.	0.7495 in 19.025 mm	0.7503 in 19.058 mm	0.7521 in 19.103 mm	0.0036 in
	SHOULDER BOLT (UPPER)	O.D.	0.7485 in 19.012 mm	0.7490 in 19.025 mm	0.7467 in 18.966 mm	0.091 mm
2	BEARING BALL	I.D.	0.7495 in 19.037 mm	0.7500 in 19.050 mm	0.7515 in 19.088 mm	0.0030 in
	SHOULDER BOLT (UPPER)	O.D.	0.7485 in 19.012 mm	0.7490 in 19.025 mm	0.7470 in 18.974 mm	0.762 mm
3	BUSHING	I.D.	0.8755 in 22.238mm	0.8755 in 22.238mm	0.8760 in 22.250mm	0.0010 in
	ECCENTRIC BUSHING	O.D.	0.8750 in 22.225 mm	0.8760 in 25.250 mm	0.8745 in 22.212 mm	0.025 mm
4	ECCENTRIC BUSHING	I.D.	0.6245 in 15.862 mm	0.6252 in 15.880 mm	0.6269 in 15.923 mm	0.0034 in
	SHOULDER BOLT (LOWER)	O.D.	0.6235 in 15.837 mm	0.6240 in 15.850 mm	0.6218 in 15.875 mm	0.086 mm
5	BEARING BALL	I.D.	0.6245 in 15.862mm	0.6250 in 15.875mm	0.6265 in 15.913mm	0.0030 in
	SHOULDER BOLT (LOWER)	O.D.	0.6235 in 15.837mm	0.6240 in 15.850mm	0.6220 in 15.799mm	0.076 mm

- (a) If the side link pin dimensions are not in the tolerances, replace the pin.
- (b) If the bushing dimensions in the side links are not in the tolerances, replace the bushings.
- (c) If the eccentric bushing dimensions are not in the tolerances, replace the eccentric bushing.
- (d) If the bearing ball dimensions are not in the tolerances, replace the bearing ball.

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F. Put the Airplane Back to its Usual Condition

SUBTASK 54-51-05-400-001

- (1) Do this task: Original Side Link Installation, TASK 54-51-05-400-801.

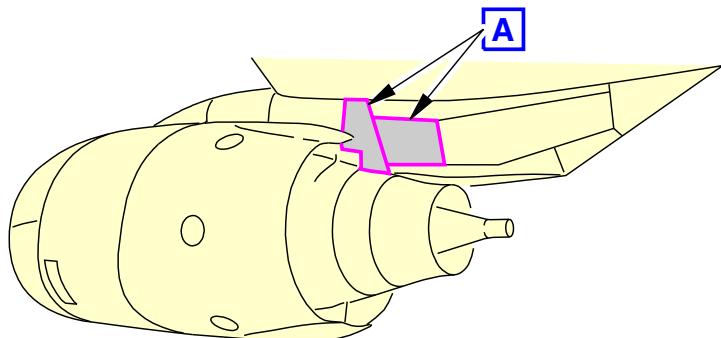
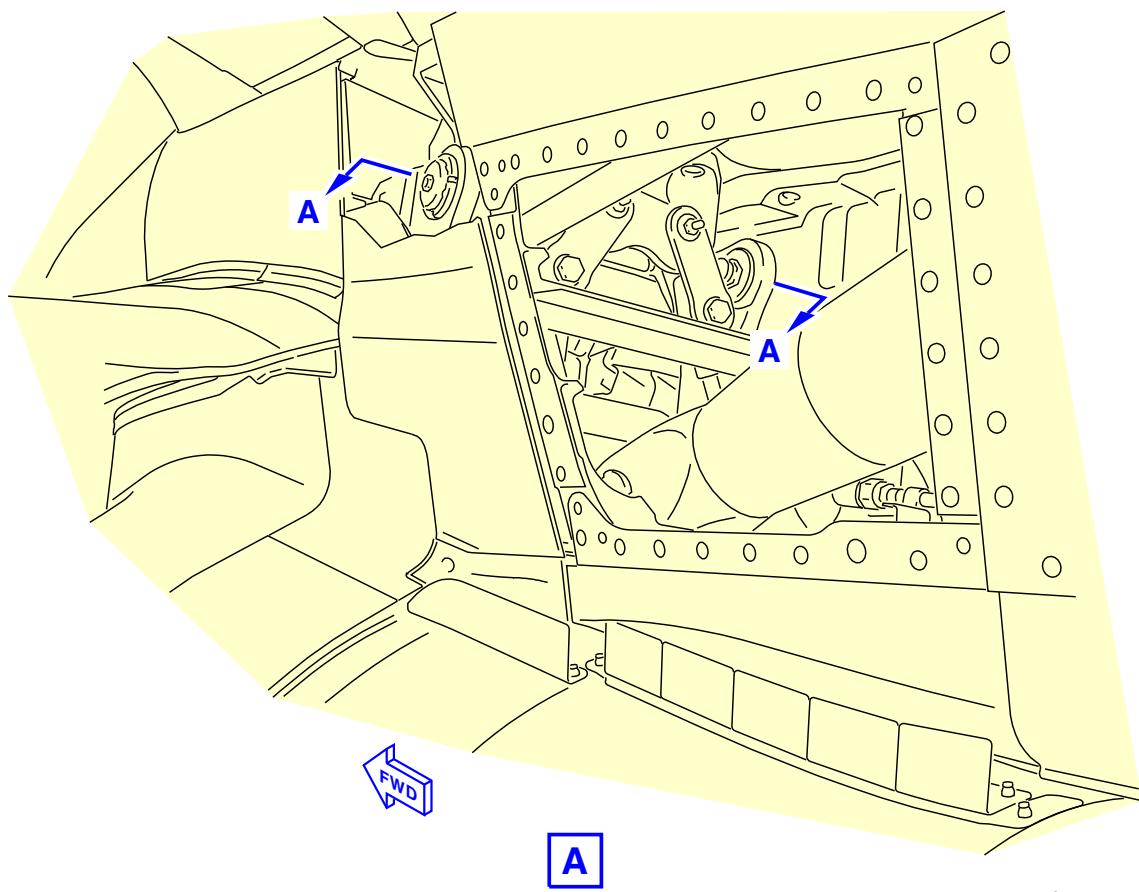
———— END OF TASK ————

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LEFT STRUT
(RIGHT STRUT IS OPPOSITE)

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Side Links Examination
Figure 601/54-51-05-990-803 (Sheet 1 of 3)

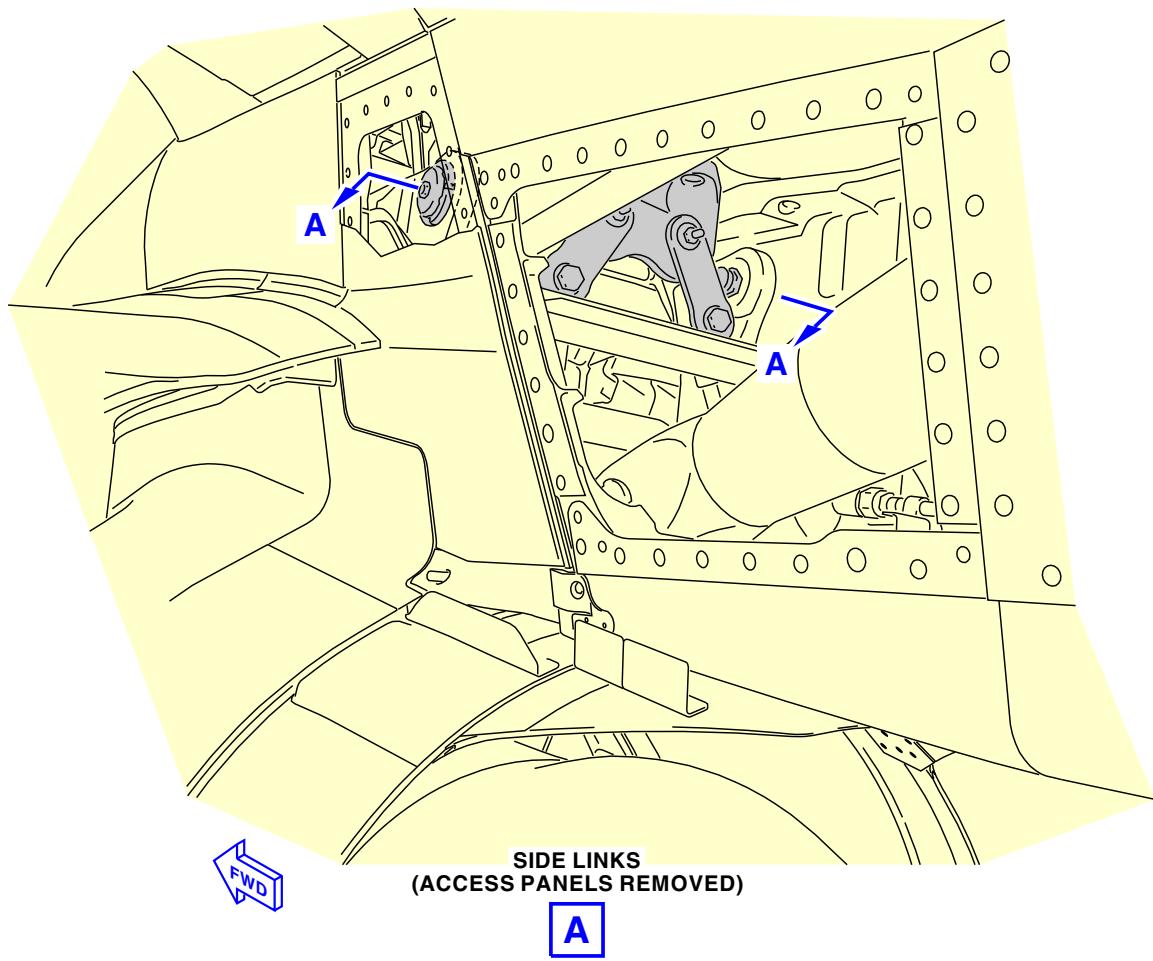
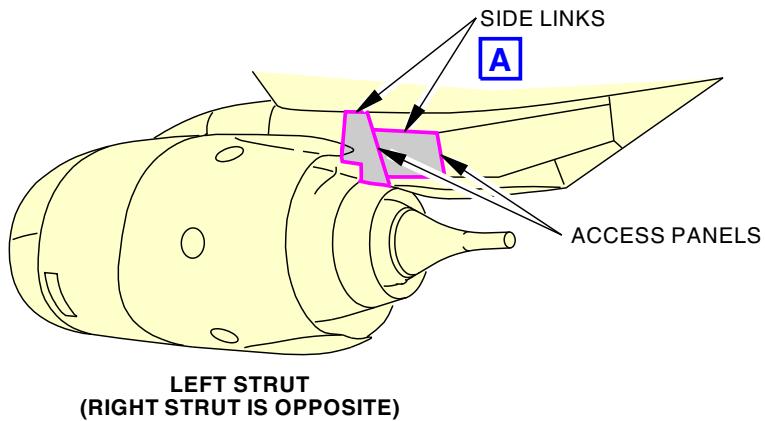
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LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-78-1089**54-51-05**

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Side Links Examination
Figure 601/54-51-05-990-803 (Sheet 2 of 3)

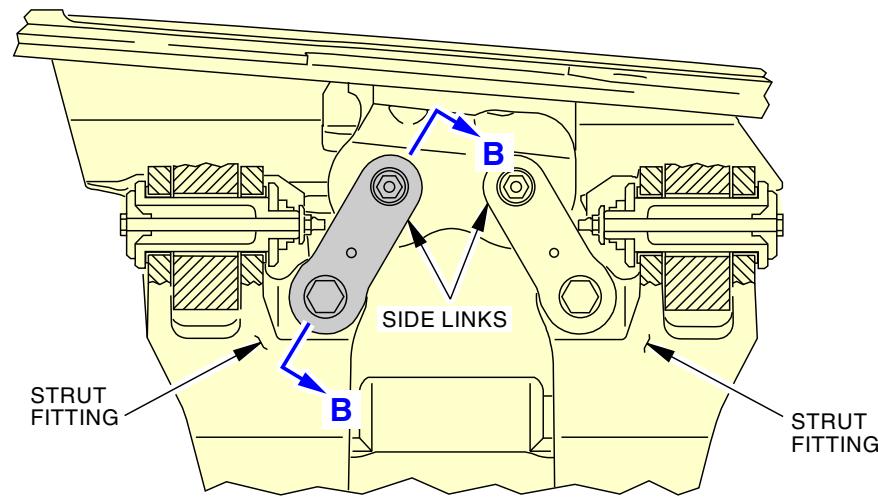
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LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
407, 411, 412, 415, 416, 420, 422-426 POST SB
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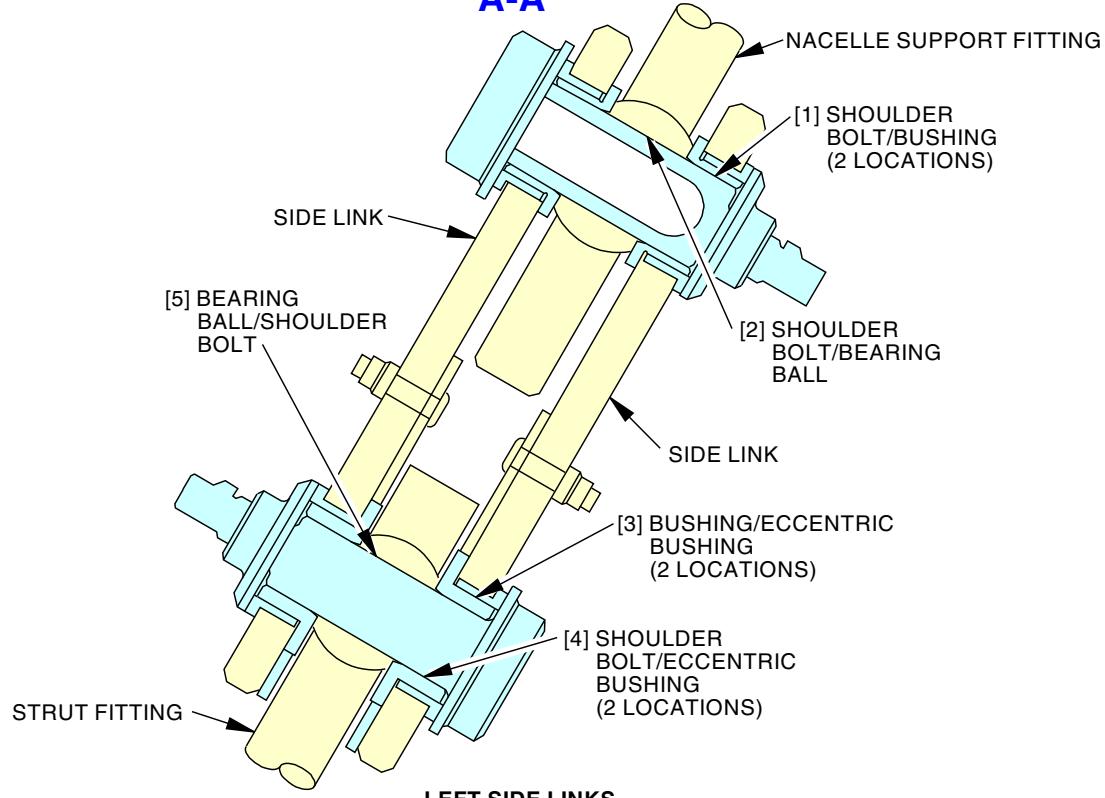
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**MIDSPAR ATTACH POINTS
(VIEW IN THE FORWARD DIRECTION)**

A-A



**LEFT SIDE LINKS
(RIGHT SIDE LINKS ARE EQUIVALENT)**

B-B

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Side Links Examination
Figure 601/54-51-05-990-803 (Sheet 3 of 3)

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STRUT TO WING FAIRINGS - MAINTENANCE PRACTICES

1. General

- A. This procedure has this task:
- (1) Aerodynamic smoothness requirements for the strut doors, panels, and fairings.

TASK 54-52-00-200-801

2. Aerodynamic Smoothness Requirements

(Figure 201)

A. General

- (1) This task gives the aerodynamic smoothness requirements for the strut access doors, panels, and fairings to permit smooth air flow. These doors, panels, and fairings are located in areas where aerodynamic smoothness is very important.
- (2) This task gives the aerodynamic smoothness requirements for these components:
 - (a) The strut forward fairings.
 - (b) The strut wing junction fairings.
 - (c) The strut access doors and panels.
 - (d) The strut aft doors, panels, and fairings.

B. References

Reference	Title
54-51-01-040-801	Prepare the Strut for Maintenance Operations (P/B 201)
54-51-01-440-801	Put the Strut Back to its Usual Condition (P/B 201)
SRM 54-50-70	Structural Repair Manual

C. Location Zones

Zone	Area
410	Subzone - Engine 1
420	Subzone - Engine 2
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

D. Aerodynamic Smoothness Requirements

SUBTASK 54-52-00-040-001

- (1) Do this task: Prepare the Strut for Maintenance Operations, TASK 54-51-01-040-801.

SUBTASK 54-52-00-200-001

- (2) Do these steps to examine the clearance between the adjacent surfaces:

- (a) Look for an unusually large change in contour (misfair/step) or clearance (gap) between adjacent surfaces.
 - (b) The misfair (step) and clearance (gap) between these surfaces must agree with the permitted tolerances in Figure 201.
 - 1) If you cannot get the correct permitted tolerance, use the expanded tolerance in Table 201 if the acceptance criteria include the Net Effect.

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Table 201/54-52-00-993-805 Aerodynamic Smoothness Limits - Strut Fairing

Airplane Effectivity	Edge Zone	Section	Clearance	NEV Table	NEA	Recommended Minimum # of measurements
ALL	[A]	B-B	0.1300 +0.0900 / -0.0600 in. (3.3020 +2.2860 / -1.5240 mm)	203	See Table 3	4 (2 inbd + 2 outbd)
ALL	[B]	B-B	0.0000 +0.0900 / -0.0600 in. (0.0000 +2.2860 / -1.5240 mm)	203	See Table 3	4 (2 inbd + 2 outbd)
ALL	[C]	C-C	0.0000 ±0.1200 in. (0.0000 ±3.0480 mm)	204	See Table 4	5
ALL	[D]	C-C	0.1570 +0.1200 / -0.0500 in. (3.9878 +3.0480 / -1.2700 mm)	204	See Table 4	5
ALL	[E]	C-C	0.2700 +0.0300 / -0.1000 in. (6.8580 +0.7620 / -2.5400 mm)	204	See Table 4	5
ALL	[F]	I-I	0.1000 +0.1050 / -0.0700 in. (2.5400 +2.6670 / -1.7780 mm)	202	0.135	4 (2 inbd + 2 outbd)
ALL	[G]	I-I	0.0000 ±0.0600 in. (0.0000 ±1.5240 mm)	202	0.025	4 (2 inbd + 2 outbd)
ALL	[H]	G-G	0.0000 +0.1125 / -0.1800 in. (0.0000 +2.8575 / -4.5720 mm)	202	0.075	3 (1@ G-G, H-H, C-C)
ALL	[I]	G-G	0.3000 +0.1500 / -0.1000 in. (7.6200 +3.8100 / -2.5400 mm)	202	0.035	3 (1@ G-G, H-H, C-C)
ALL	[J]	H-H	0.1500 +0.1500 / -0.1000 in. (3.8100 +3.8100 / -2.5400 mm)	202	0.025	3 (1@ G-G, H-H, C-C)
ALL	[K]	H-H	0.0000 +0.1125 / -0.1800 in. (0.0000 +2.8575 / -4.5720 mm)	202	0.075	3 (1@ G-G, H-H, C-C)
ALL	[L]	P-P	0.1000 +0.1050 / -0.0700 in. (2.5400 +2.6670 / -1.7780 mm)	202	0.135	5

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Table 201/54-52-00-993-805 Aerodynamic Smoothness Limits - Strut Fairing (Continued)

Airplane Effectivity	Edge Zone	Section	Clearance	NEV Table	NEA	Recommended Minimum # of measurements
ALL	[M]	P-P	0.0000 ±0.0600 in. (0.0000 ±1.5240 mm)	202	0.025	5
ALL	[N]	T-T	0.1000 +0.1050 / -0.0700 in. (2.5400 +2.6670 / -1.7780 mm)	202	0.170	4 (2 inbd + 2 outbd)
ALL	[O]	T-T	0.0000 +0.0600 / -0.1350 in. (0.0000 +1.5240 / -3.4290 mm)	202	0.080	4 (2 inbd + 2 outbd)
ALL	[P]	U-U	0.0000 ±0.0450 in. (0.0000 ±1.1430 mm)	202	0.030	3
ALL	[Q]	U-U	0.1500 +0.0600 / -0.0400 in. (3.8100 +1.5240 / -1.0160 mm)	202	0.190	3
ALL	[R]	V-V	0.1000 +0.0900 / -0.0600 in. (2.5400 +2.2860 / -1.5240 mm)	202	0.015	3
ALL	[S]	V-V	0.0600 +0.0600 / -0.0400 in. (1.5240 +1.5240 / -1.0160 mm)	202	0.080	3
ALL	[T]	W-W	0.0000 ±0.0450 in. (0.0000 ±1.1430 mm)	202	0.030	2
ALL	[U]	W-W	0.1900 +0.0600 / -0.0400 in. (4.8260 +1.5240 / -1.0160 mm)	202	0.260	2
ALL	[V]	Y-Y	0.1000 +0.0900 / -0.0600 in. (2.5400 +2.2860 / -1.5240 mm)	202	0.130	5 (4@ Z-Z + 1@ Y-Y)
ALL	[W]	Y-Y	0.0000 ±0.0750 in. (0.0000 ±1.9050 mm)	202	0.025	5 (4@ Z-Z + 1@ Y-Y)
ALL	[X]	AA-AA	0.0000 ±0.1050 in. (0.0000 ±2.6670 mm)	202	0.070	8 (2 * 4 pl)
ALL	[Y]	AA-AA	0.0725 +0.0863 / -0.0575 in. (1.8415 +2.1920 / -1.4605 mm)	202	0.130	8 (2 * 4 pl)

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Table 201/54-52-00-993-805 Aerodynamic Smoothness Limits - Strut Fairing (Continued)

Airplane Effectivity	Edge Zone	Section	Clearance	NEV Table	NEA	Recommended Minimum # of measurements
ALL	[Z]	Z-Z	0.0000 +0.0750 / -0.0500 in. (0.0000 +1.9050 / -1.2700 mm)	202	0.025	5 (4@ Z-Z + 1@ Y-Y)
ALL	[AA]	Z-Z	0.1000 +0.0900 / -0.0600 in. (2.5400 +2.2860 / -1.5240 mm)	202	0.130	5 (4@ Z-Z + 1@ Y-Y)

SUBTASK 54-52-00-840-001

- (3) Net Effect: Calculate the Net Effect from measured step and/or gap values by the procedure that follow:

- (a) As a minimum, measure in less than 1 in. (25 mm) of each end of an interface and/or corner transition.
 - 1) More measurements should divide the interface length into equal intervals, with one of the measurements located in less than 1 in. (25 mm) of the midpoint of the interface length.
 - 2) See Table 201 for the recommended minimum number of measurements.
 - 3) Add all of the calculated Net Effect Value (NEV) values, both those in tolerance and those that are not in the tolerance and divide the result by the total number of measurements.
 - a) Calculate the net effect value by using linear interpolation of the appropriate column in Table 202.

NOTE: The result is the total NEV for the interface.

- (b) Convert each measured value to NEV by linear interpolation of the applicable column given in Table 202 through Table 204.

NOTE: NEV can be obtained by Table 202, Table 203, or Table 204 after substituting Nitrogen Enriched Air (NEA) with the values from Table 201.

Table 202/54-52-00-993-806 Generic NEA Based Table

GAPS		STEPS	
w (in)	NEV	h (in)	NEV
0	0	-NEA	1
NEA	1	0	0
-	-	NEA	1

Table 203/54-52-00-993-807 Inlet Outer Panel / Thumbnail Fairing

GAPS [A]		STEPS [B]	
w (in)	NEV	h (in)	NEV
0.2200	0.6471	-0.1000	2.3500
0.2600	0.7647	-0.0800	0.9100

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Table 203/54-52-00-993-807 Inlet Outer Panel / Thumbnail Fairing (Continued)

GAPS [A]		STEPS [B]	
0.3000	0.8824	-0.0600	1.5100
0.3400	1.0000	-0.0400	1.1250
0.3800	1.1176	-0.0300	0.9100
		-0.0200	0.7400
		-0.0100	0.5600
		0.0000	0.4000
		0.0100	0.2400
		0.0200	0.1000
		0.0300	0.0600
		0.0400	0.2300
		0.0500	0.5800
		0.0600	1.0000
		0.0700	0.4600
		0.0800	1.9400
		0.1000	2.9300

Table 204/54-52-00-993-808 Forward Panel / T/R-Strut Fairing

GAPS [D] [E]		STEPS [C]	
w (in)	NEV	w (in)	NEV
0.1000	0.2649	-0.1000	1.7865
0.1400	0.4083	-0.0800	1.3409
0.1800	0.5640	-0.0600	0.9263
0.2200	0.7300	-0.0400	0.5500
0.2600	0.9050	-0.0200	0.2256
0.2810	1.0000	0.0000	0.0000
0.3000	1.0878	0.0200	0.4102
0.3400	1.2777	0.0400	1.0000
0.3800	1.4741	0.0600	1.6842
0.4200	1.6765	0.0800	2.4380
0.4600	1.8846	0.1000	3.2482
0.5000	2.0978		

(c) Add all the calculated NEV values and divide the result by the total number of measurements.

- 1) The result is the Interface NEV.
- 2) The Net Effect Limit (NEL) is 1.0 for all interfaces listed in Table 201.

EFFECTIVITY
LOM ALL

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- a) If the Interface NEV is less than or equal to the NEL, the interface is aerodynamically acceptable.
- b) If the Interface NEV is greater than the NEL, the interface does not meet the aerosmoothness requirements.

SUBTASK 54-52-00-350-001

- (4) If it is necessary, repair the fairings to make the surfaces smooth (SRM 54-50-70).

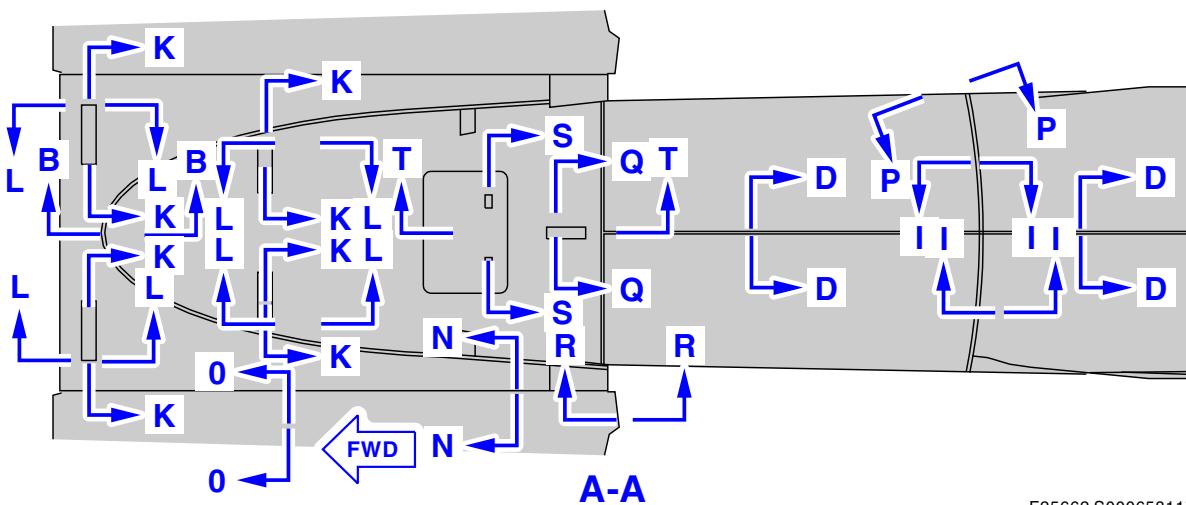
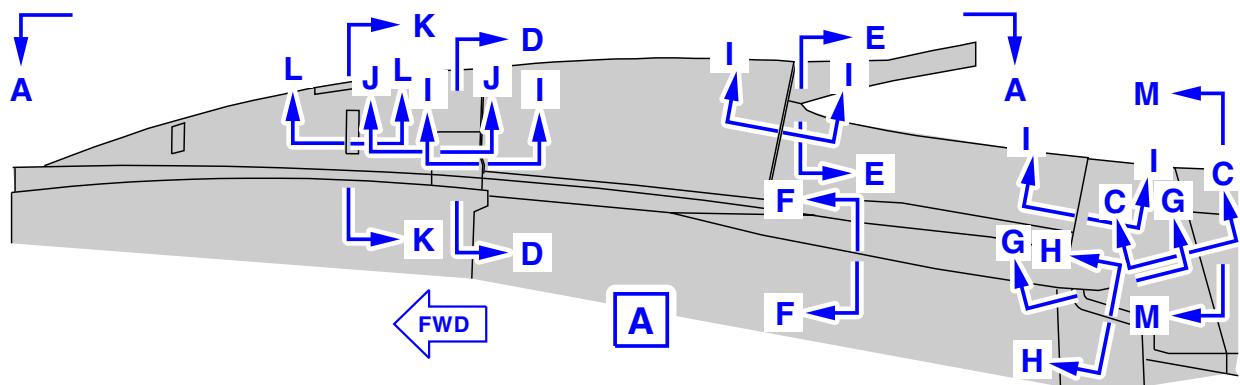
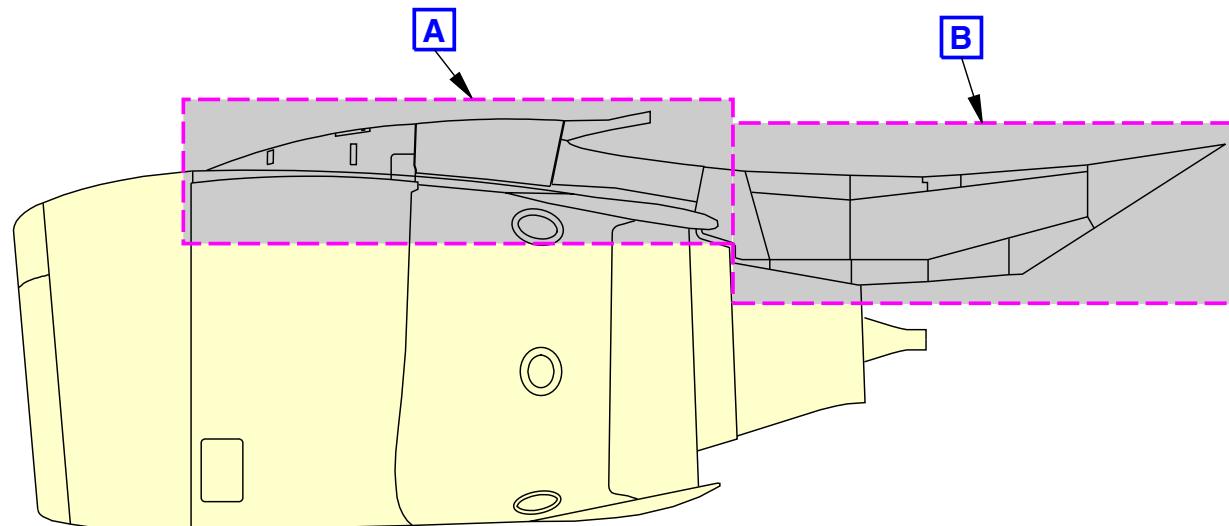
SUBTASK 54-52-00-440-001

- (5) Do this task: Put the Strut Back to its Usual Condition, TASK 54-51-01-440-801.

———— END OF TASK ————

EFFECTIVITY
LOM ALL

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Aerodynamic Smoothness Limits - Strut Fairing
 Figure 201/54-52-00-990-801 (Sheet 1 of 11)

EFFECTIVITY
 LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
 422-426 PRE SB 737-78-1089

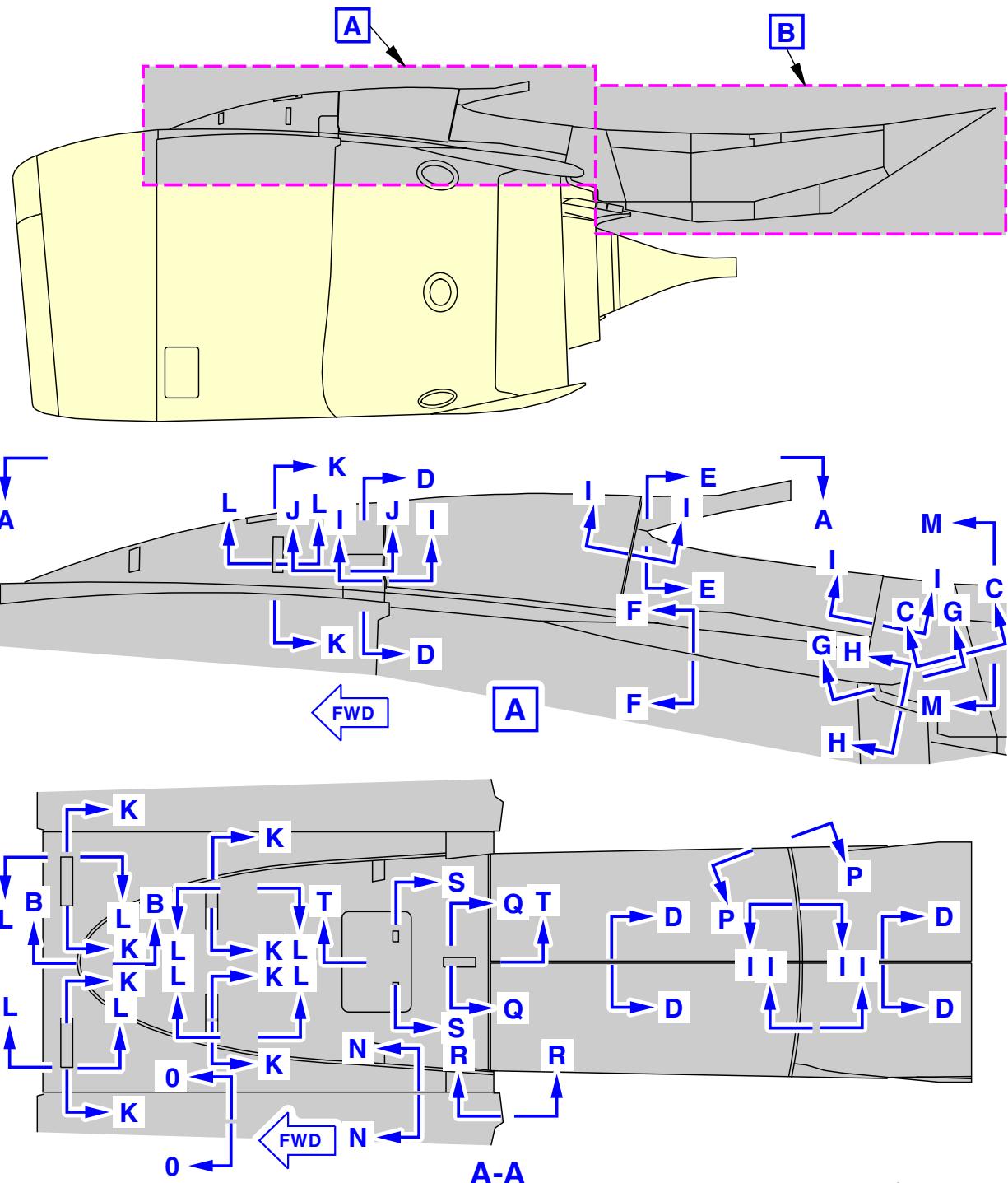
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ECCN 9E991 BOEING PROPRIETARY - See title page for details



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AIRCRAFT MAINTENANCE MANUAL



2097787 S0000443813_V2

Aerodynamic Smoothness Limits - Strut Fairing
Figure 201/54-52-00-990-801 (Sheet 2 of 11)

EFFECTIVITY
LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
407, 411, 412, 415, 416, 420, 422-426 POST SB
737-78-1089

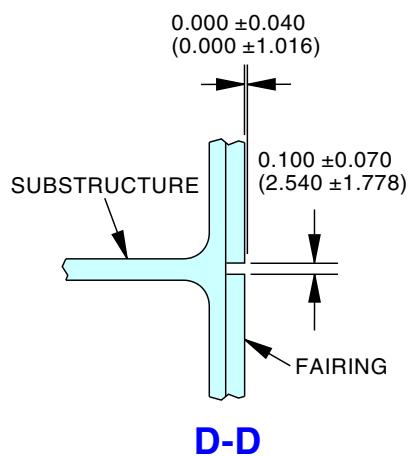
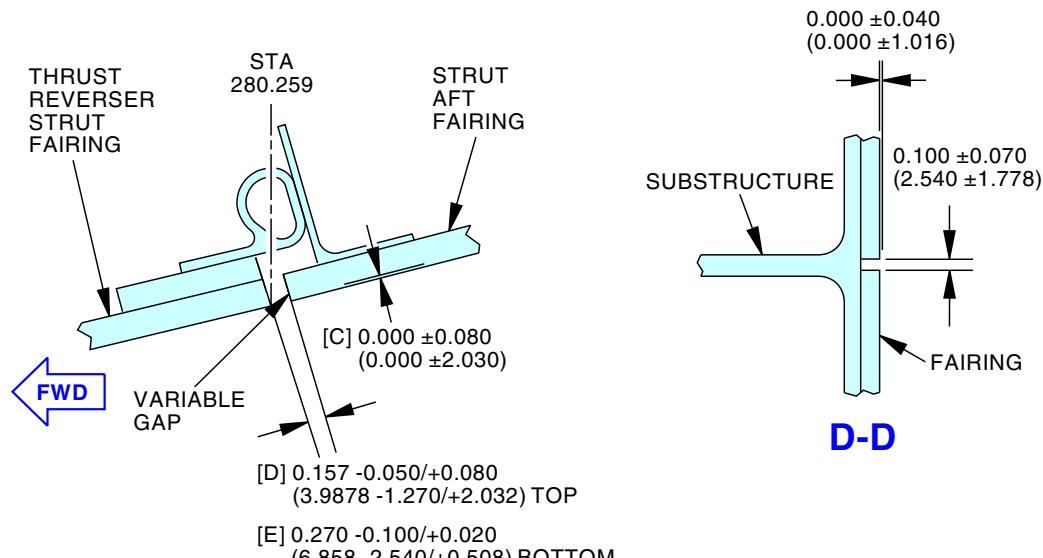
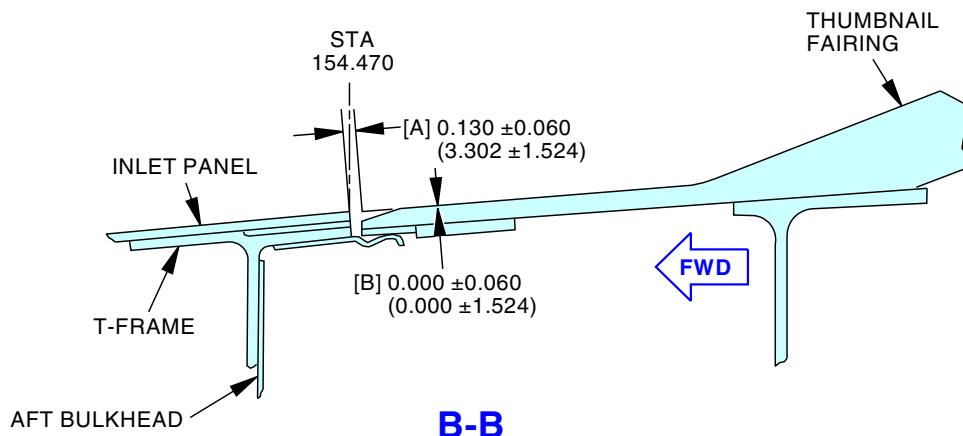
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ECCN 9E991 BOEING PROPRIETARY - See title page for details



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AIRCRAFT MAINTENANCE MANUAL**

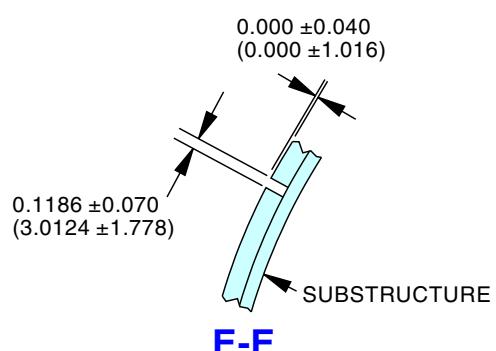


NOTE:

ALL DIMENSIONS ARE IN INCHES
(MILLIMETERS ARE IN PARENTHESES).



1 GAPS FILLED WITH FAY SURFACE SEALANT



F25924 S0006581174_V6

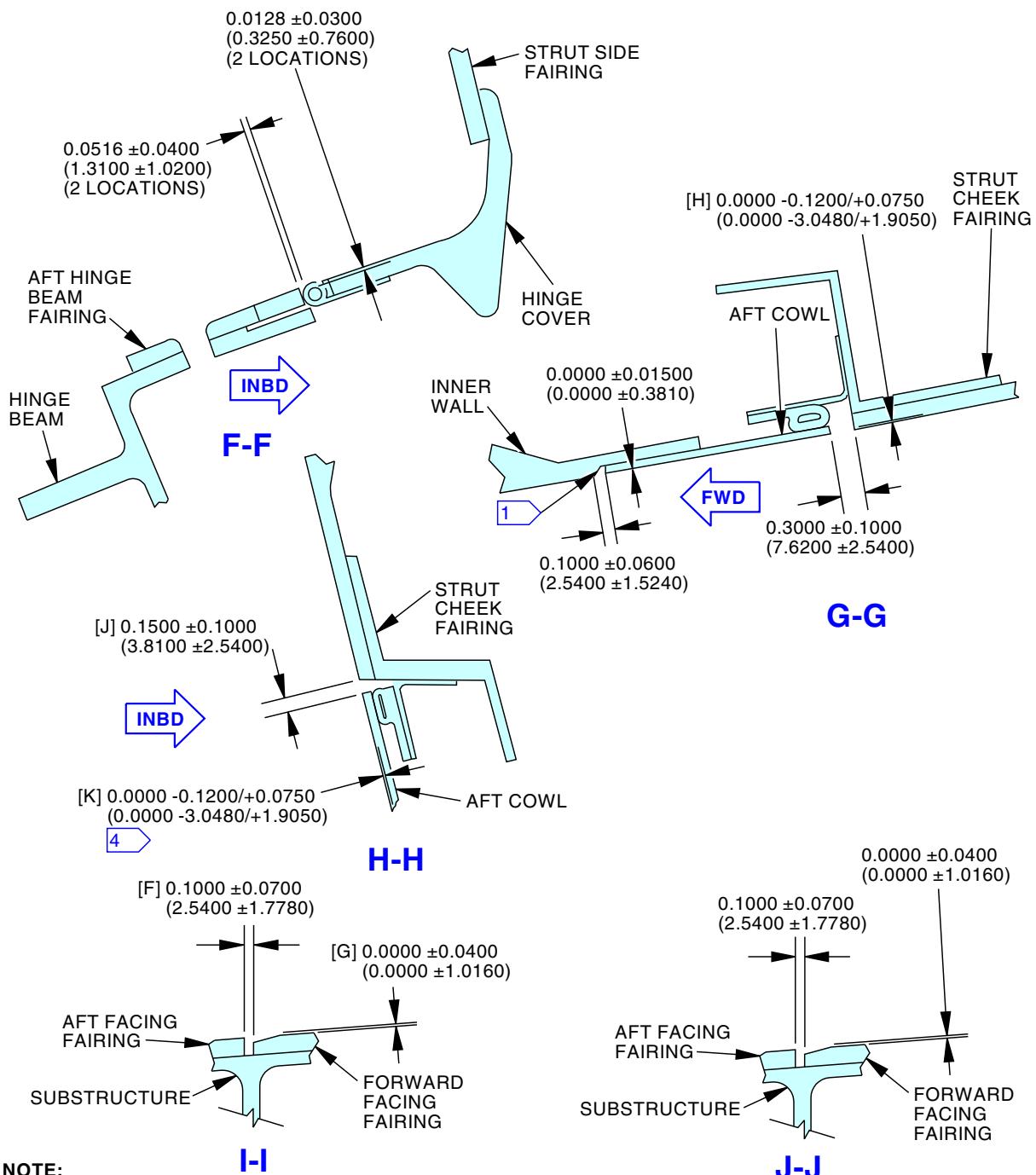
Aerodynamic Smoothness Limits - Strut Fairing
Figure 201/54-52-00-990-801 (Sheet 3 of 11)

EFFECTIVITY
LOM ALL

D633A101-LOM

54-52-00

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NOTE:

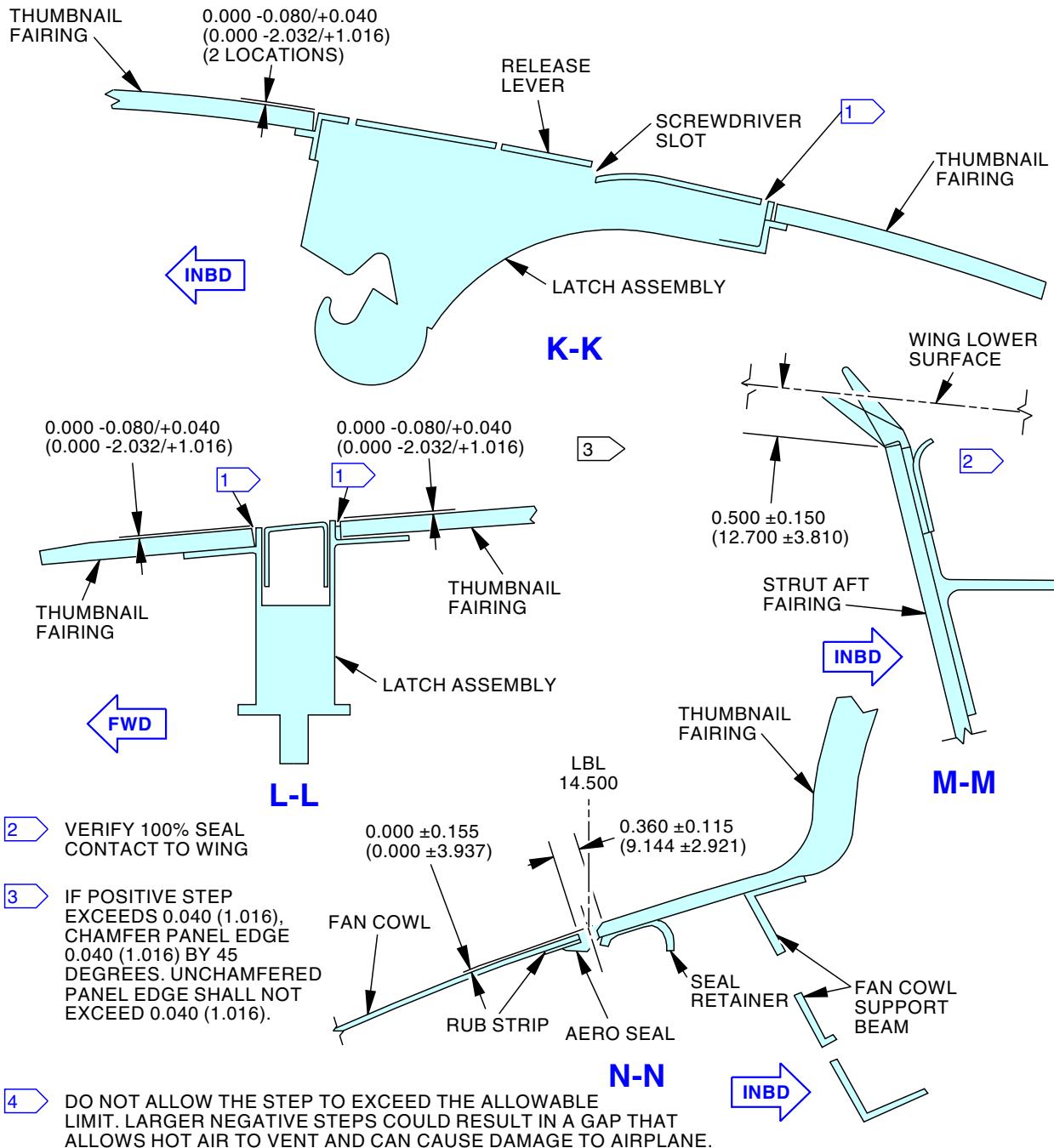
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 (MILLIMETERS ARE IN PARENTHESIS).

F25929 S0006581177_V6

Aerodynamic Smoothness Limits - Strut Fairing
Figure 201/54-52-00-990-801 (Sheet 4 of 11)

EFFECTIVITY
LOM ALL

54-52-00

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NOTE:

ALL DIMENSIONS ARE IN INCHES
(MILLIMETERS ARE IN PARENTHESIS).

F25932 S0006581178_V5

**Aerodynamic Smoothness Limits - Strut Fairing
Figure 201/54-52-00-990-801 (Sheet 5 of 11)**

EFFECTIVITY
LOM ALL

D633A101-LOM

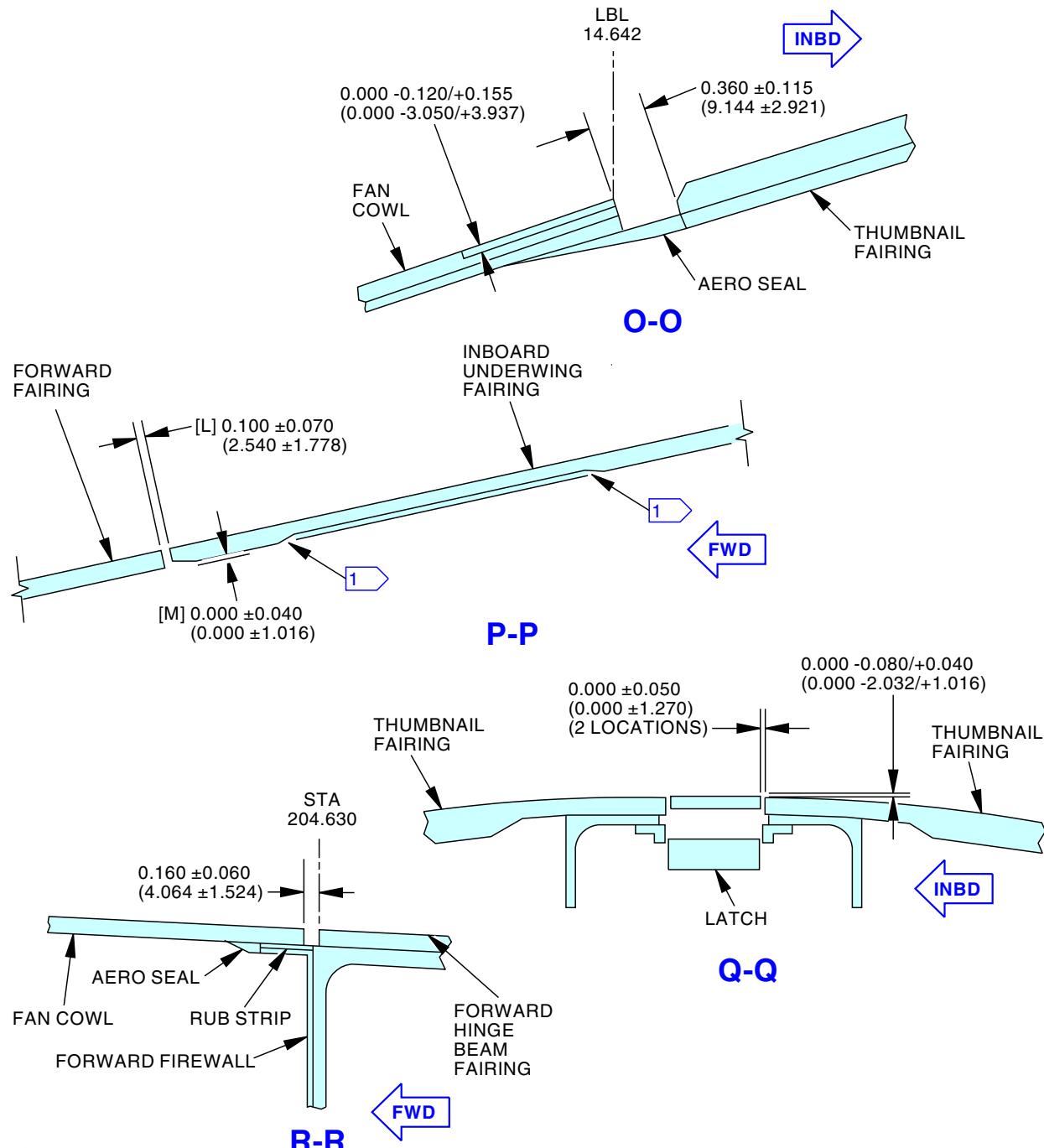
ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL**



F26756 S0006581180_V4

Aerodynamic Smoothness Limits - Strut Fairing
Figure 201/54-52-00-990-801 (Sheet 6 of 11)

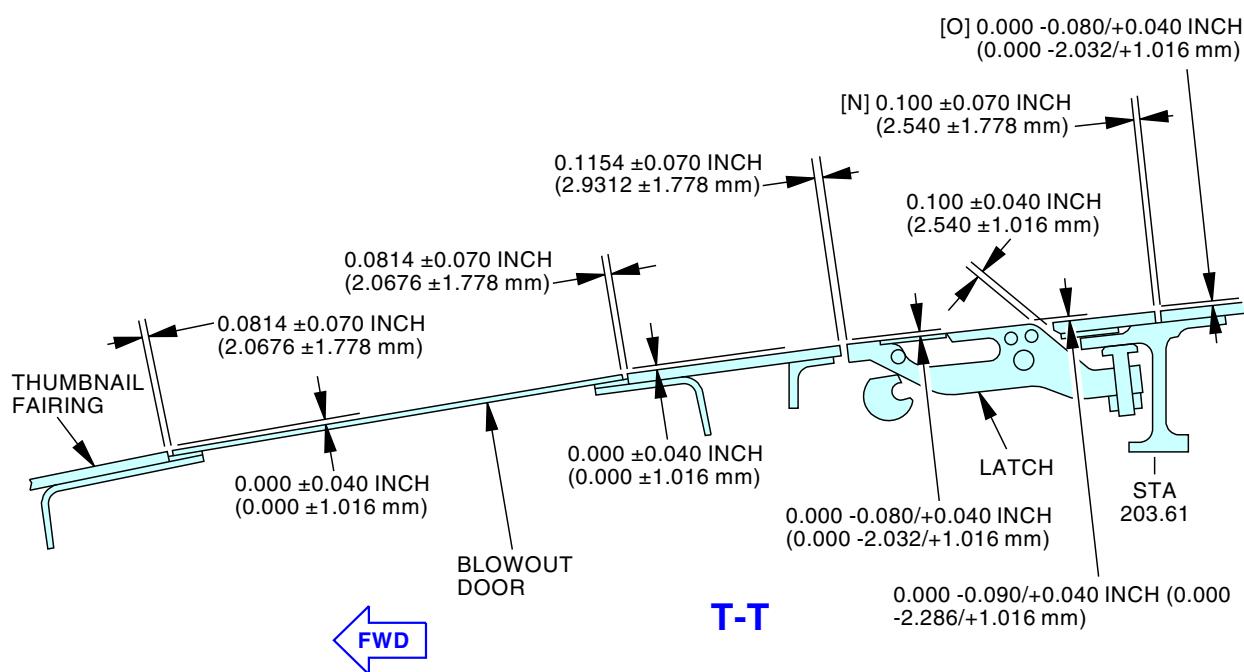
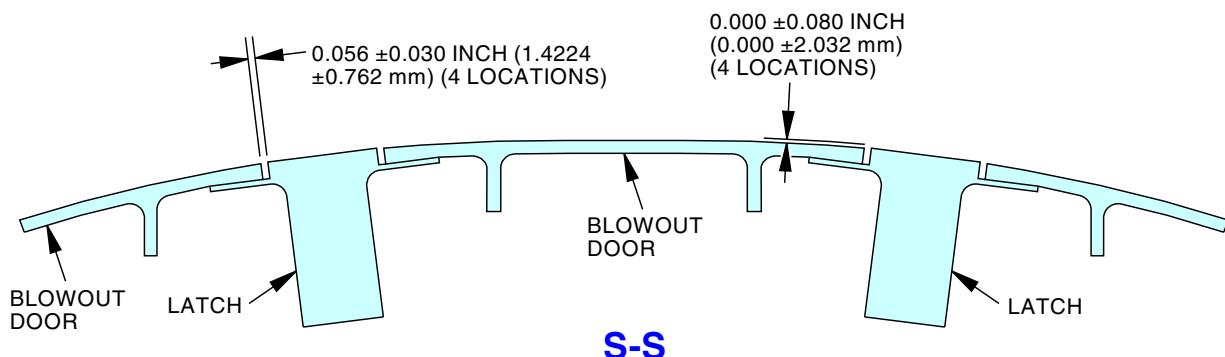
EFFECTIVITY
LOM ALL

54-52-00

ECCN 9E991 BOEING PROPRIETARY - See title page for details



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AIRCRAFT MAINTENANCE MANUAL



F26835 S0006581181_V5

Aerodynamic Smoothness Limits - Strut Fairing
Figure 201/54-52-00-990-801 (Sheet 7 of 11)

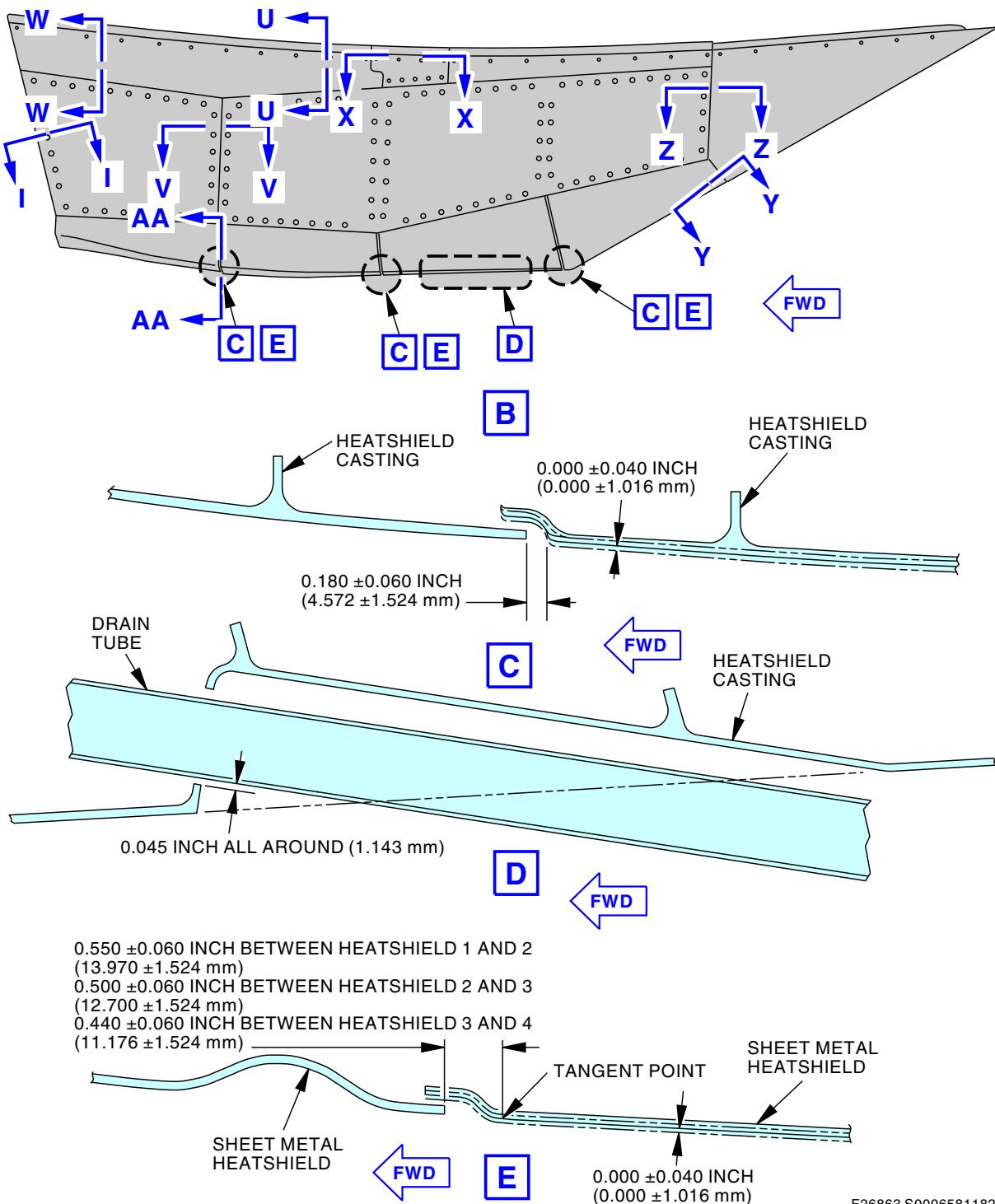
EFFECTIVITY
LOM ALL

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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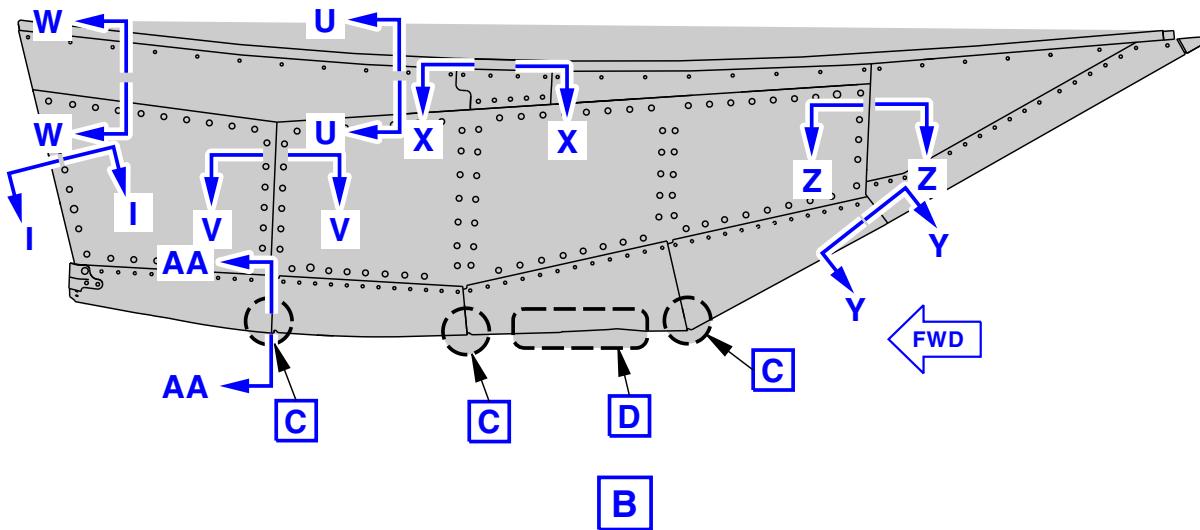
Aerodynamic Smoothness Limits - Strut Fairing
Figure 201/54-52-00-990-801 (Sheet 8 of 11)

EFFECTIVITY
 LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
 422-426 PRE SB 737-78-1089

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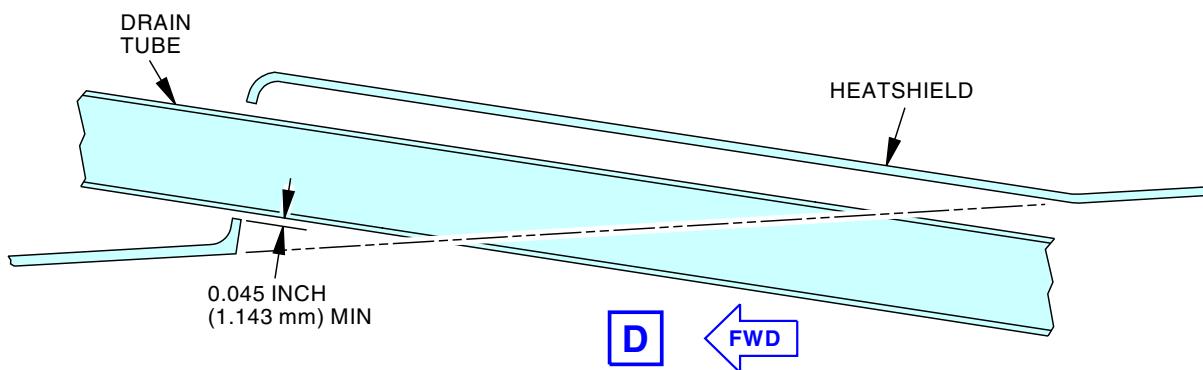
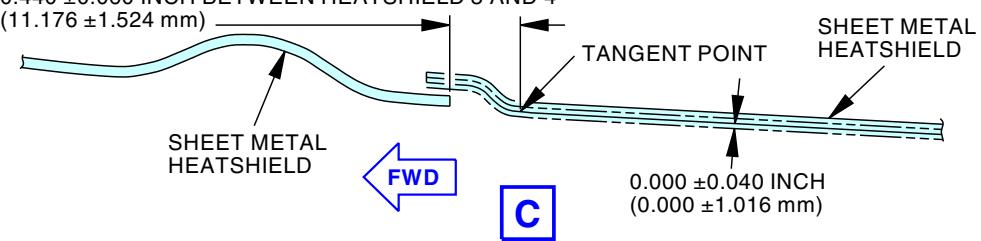
ECCN 9E991 BOEING PROPRIETARY - See title page for details



0.550 ±0.060 INCH BETWEEN HEATSHIELD 1 AND 2
 $(13.970 \pm 1.524 \text{ mm})$

0.500 ±0.060 INCH BETWEEN HEATSHIELD 2 AND 3
 $(12.700 \pm 1.524 \text{ mm})$

0.440 ±0.060 INCH BETWEEN HEATSHIELD 3 AND 4
 $(11.176 \pm 1.524 \text{ mm})$



2098242 S0000443815_V3

Aerodynamic Smoothness Limits - Strut Fairing
Figure 201/54-52-00-990-801 (Sheet 9 of 11)

EFFECTIVITY
 LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
 407, 411, 412, 415, 416, 420, 422-426 POST SB
 737-78-1089

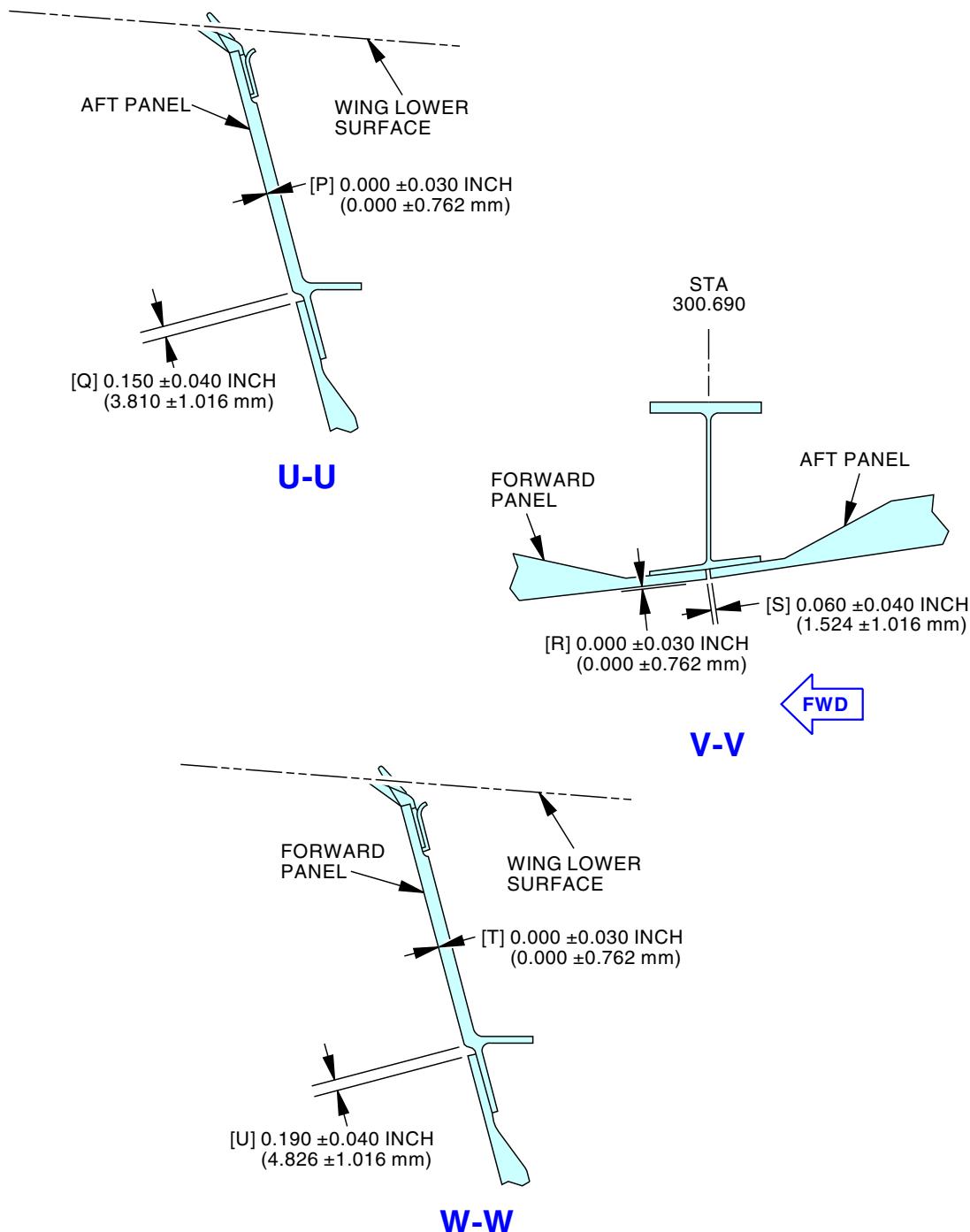
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ECCN 9E991 BOEING PROPRIETARY - See title page for details



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AIRCRAFT MAINTENANCE MANUAL



F27154 S0006581183_V4

Aerodynamic Smoothness Limits - Strut Fairing
Figure 201/54-52-00-990-801 (Sheet 10 of 11)

EFFECTIVITY
LOM ALL

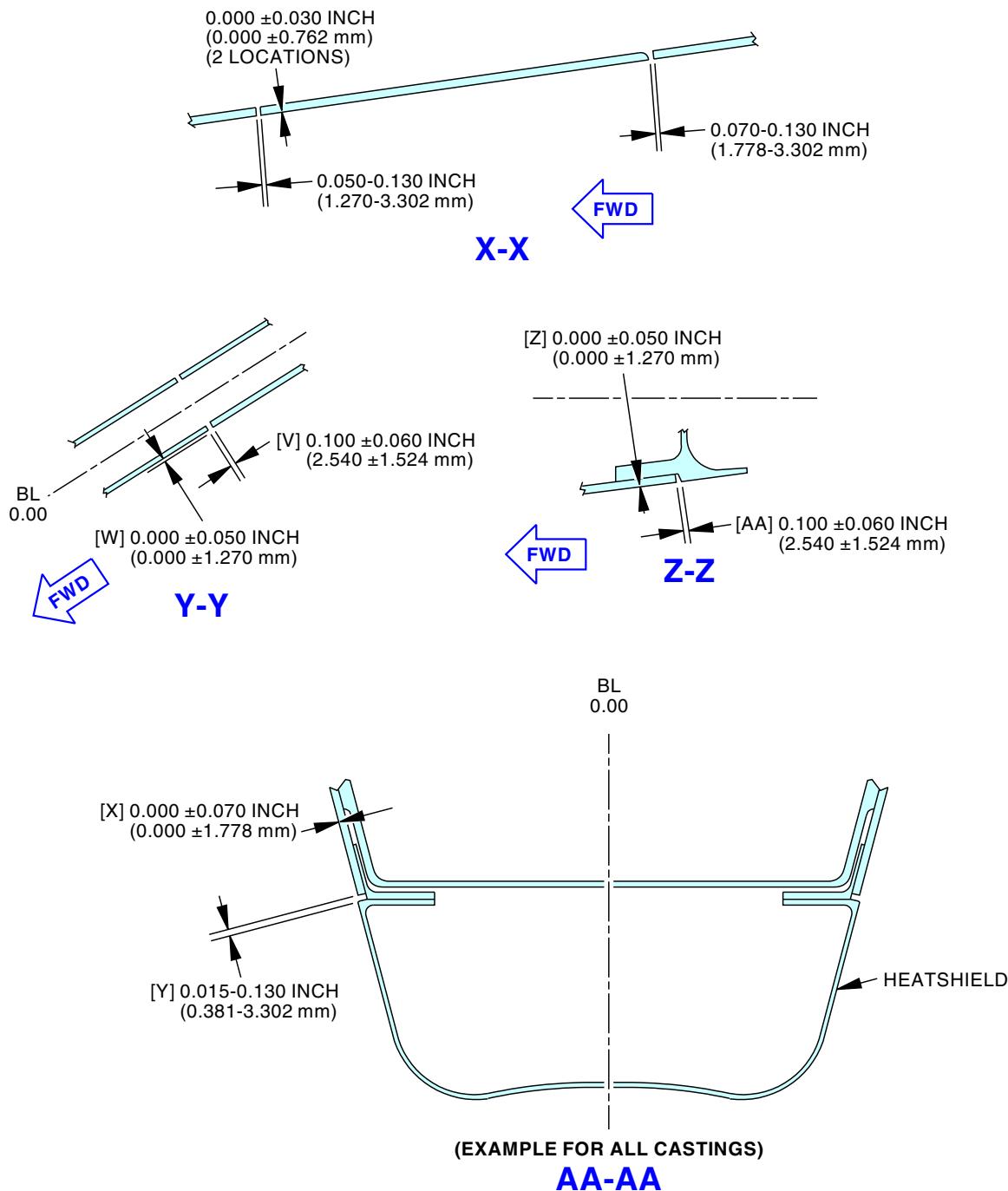
54-52-00

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL



F27183 S0006581184_V4

Aerodynamic Smoothness Limits - Strut Fairing
Figure 201/54-52-00-990-801 (Sheet 11 of 11)

EFFECTIVITY	LOM ALL
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FORWARD FAIRINGS - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) Removal of the forward fairings.
 - (2) Installation of the forward fairings.

TASK 54-52-01-010-801

2. Forward Fairing Removal

(Figure 401)

A. General

- (1) This task is the removal of these strut forward fairings:
 - (a) The thumbnail fairing.
 - (b) The mid strut fairings.

B. References

Reference	Title
54-51-01-040-801	Prepare the Strut for Maintenance Operations (P/B 201)
71-11-02-000-801-F00	Fan Cowl Panel Removal (Selection) (P/B 401)

C. Location Zones

Zone	Area
410	Subzone - Engine 1
420	Subzone - Engine 2
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

D. Access Panels

Number	Name/Location
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
431AT	Forward Strut Fairing, Thumbnail Fairing, Strut 1
431BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 1
431BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 1
441AT	Forward Strut Fairing, Thumbnail Fairing, Strut 2
441BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 2
441BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 2

E. Prepare for the Removal

SUBTASK 54-52-01-040-003

- (1) Do this task: Prepare the Strut for Maintenance Operations, TASK 54-51-01-040-801.

F. Forward Fairing Removal

SUBTASK 54-52-01-000-001

- (1) Do these steps to remove the thumbnail fairing [1]:



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- (a) Remove the applicable fan cowl panels:

(Fan Cowl Panel Removal (Selection), TASK 71-11-02-000-801-F00)

Number Name/Location

413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2

- (b) Unlatch the latches located at the exterior surface of the thumbnail fairing [1].



CAUTION

MAKE SURE THAT YOU PREVENT THE MOVEMENT OF THE FAIRING IN THE HORIZONTAL PLANE. THIS CAN BREAK THE ALIGNMENT PINS FROM THE SUPPORT BEAM AND DAMAGE STRUCTURE.

- (c) Remove the applicable access panels:

Number Name/Location

431AT	Forward Strut Fairing, Thumbnail Fairing, Strut 1
441AT	Forward Strut Fairing, Thumbnail Fairing, Strut 2

SUBTASK 54-52-01-000-002

- (2) Do these steps to remove the mid strut fairing [3] or mid strut fairing [4]:

- (a) Remove the bolts [2] and do this step:

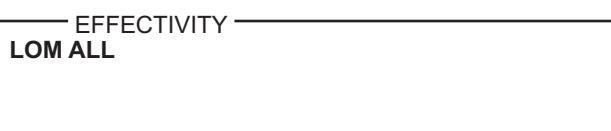
- 1) Open these access panels:

Number Name/Location

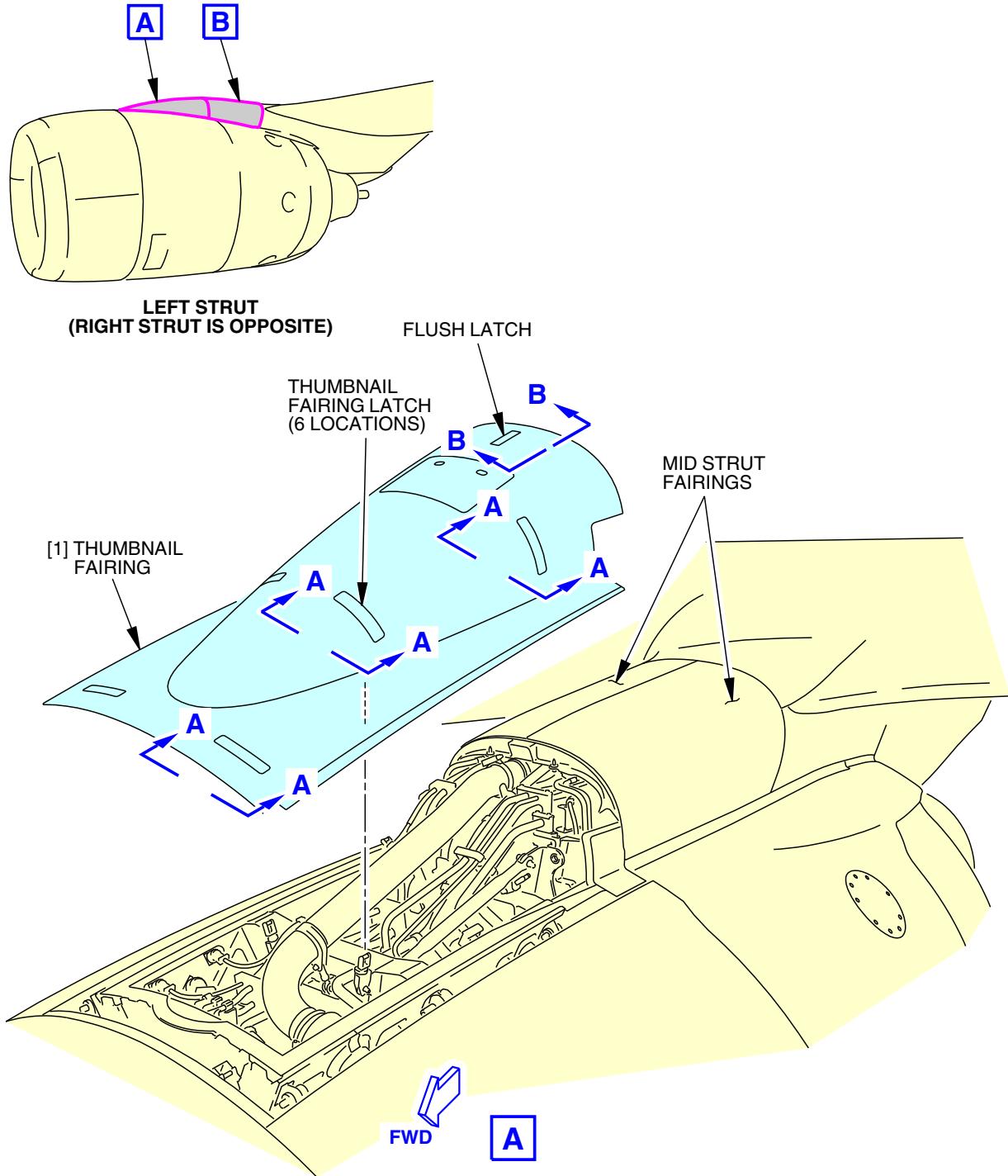
431BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 1
431BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 1
441BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 2
441BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 2

- (b) Remove the mid strut fairing [3] or mid strut fairing [4].

———— END OF TASK ————



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G29654 S0006581189_V4

Forward Fairing Installation
Figure 401/54-52-01-990-802 (Sheet 1 of 4)

EFFECTIVITY
 LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
 422-426 PRE SB 737-78-1089

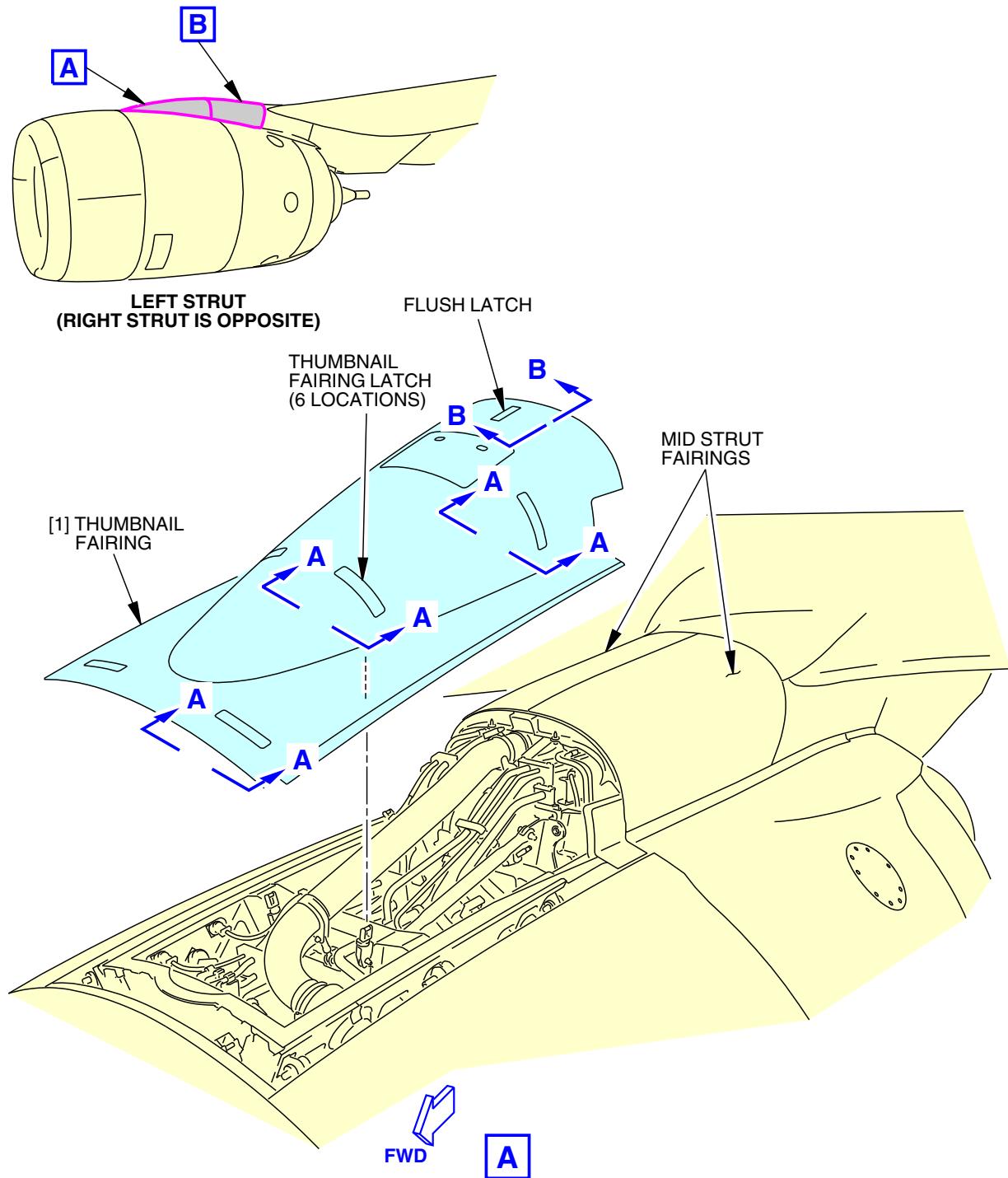
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ECCN 9E991 BOEING PROPRIETARY - See title page for details



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AIRCRAFT MAINTENANCE MANUAL



2090367 S0000439170_V4

Forward Fairing Installation
Figure 401/54-52-01-990-802 (Sheet 2 of 4)

EFFECTIVITY
LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
407, 411, 412, 415, 416, 420, 422-426 POST SB
737-78-1089

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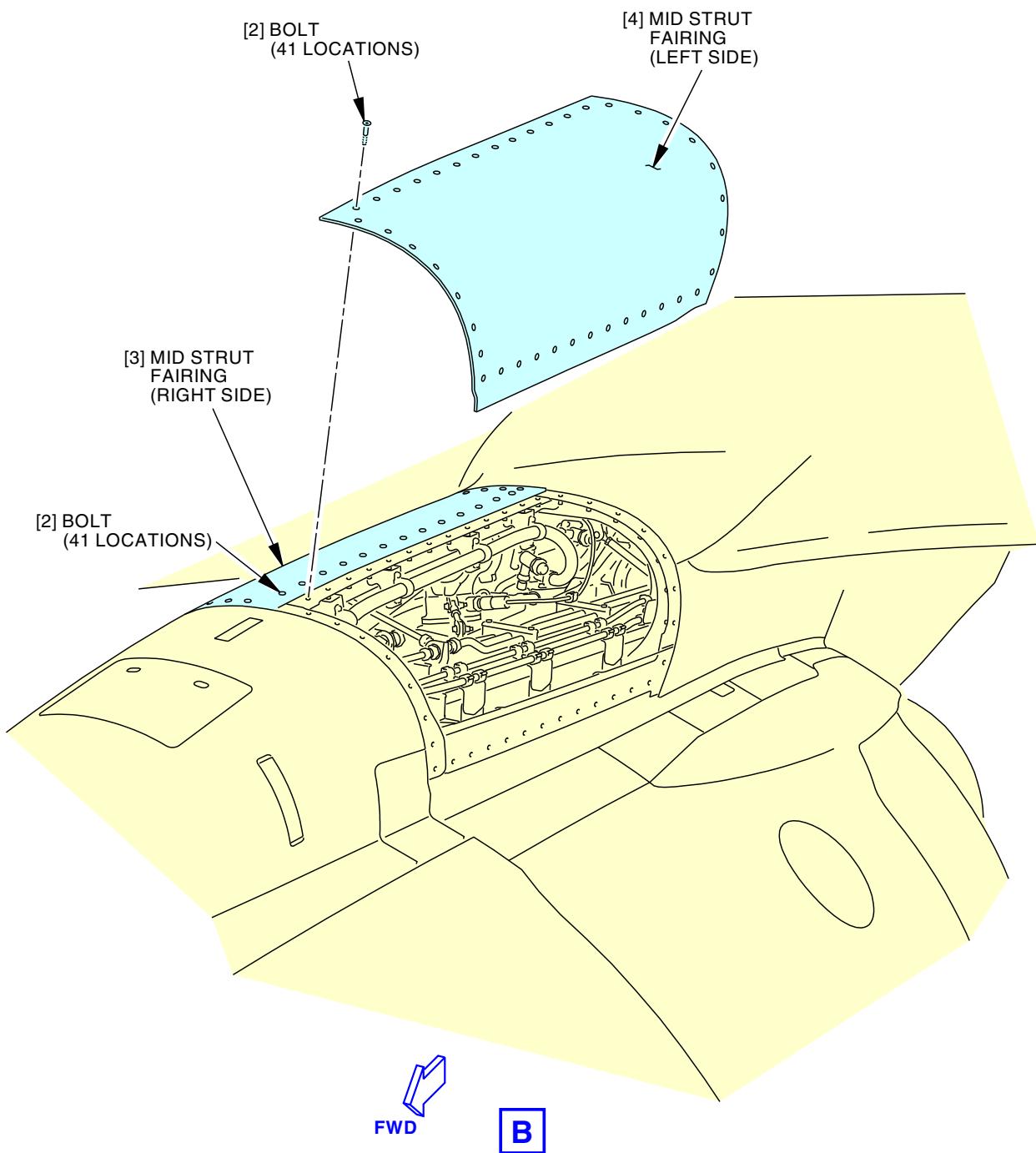
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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G29662 S0006581190_V3

Forward Fairing Installation
Figure 401/54-52-01-990-802 (Sheet 3 of 4)

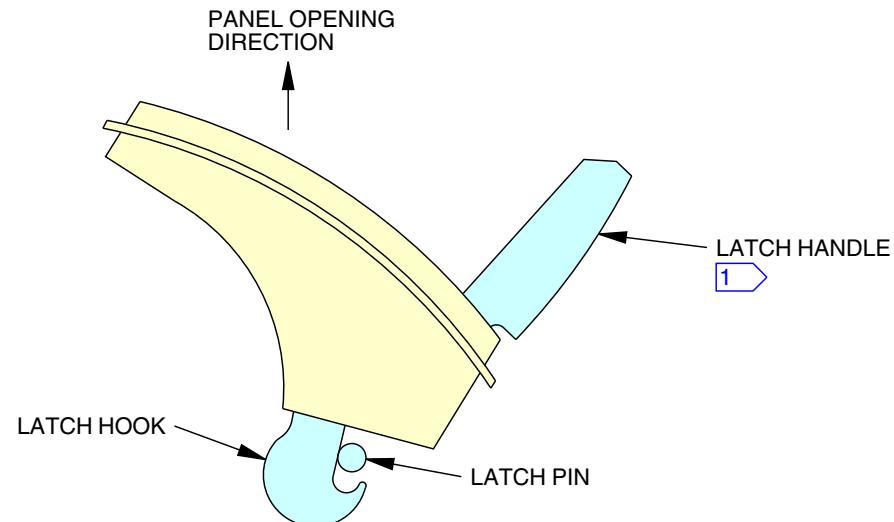
EFFECTIVITY	LOM ALL
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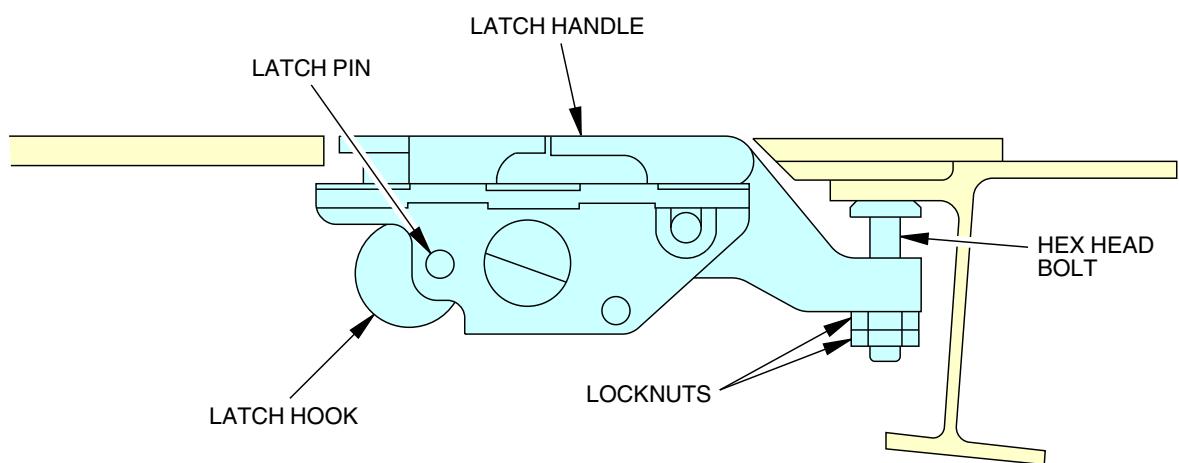


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LATCH KEEPER
(EXAMPLE)

A-A



FLUSH LATCH

B-B

- 1 HANDLE OF LATCH TO SPRING OPEN TO EXPOSE ORANGE COLOR IF HOOK IS NOT ENGAGED WITH KEEPER.

3076506 S0000834271_V1

Forward Fairing Installation
Figure 401/54-52-01-990-802 (Sheet 4 of 4)

EFFECTIVITY
LOM ALL

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TASK 54-52-01-410-801

3. Forward Fairing Installation

(Figure 401)

A. General

- (1) This task is the installation procedure for the strut forward fairings:
 - (a) The thumbnail fairing.
 - (b) The mid strut fairings.

B. References

Reference	Title
20-10-44-000-801	Lockwire, Cotter Pins, and Lockrings - Removal (P/B 401)
20-10-44-400-801	Lockwire, Cotter Pins, and Lockrings - Installation (P/B 401)
54-51-01-440-801	Put the Strut Back to its Usual Condition (P/B 201)
71-11-02-400-801-F00	Fan Cowl Panel Installation (Selection) (P/B 401)

C. Tools/Equipment

Reference	Description
STD-12081	Wrench - Hex, 5/64 inch

D. Consumable Materials

Reference	Description	Specification
D00633	Grease - Aircraft General Purpose	BMS3-33
G01048	Lockwire - MS20995C32, Corrosion Resistant Steel - 0.032 Inch (0.8128 mm) Diameter	NASM20995

E. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
1	Thumbnail fairing	54-52-00-07-010	LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-464
		54-52-00-07-015	LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-464
		54-52-00-11-010	LOM 465-999
		54-52-00-12-010	LOM 465-999
3	Mid strut fairing	54-52-00-07-315	LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-464
		54-52-00-11-325	LOM 465-999
		54-52-00-12-325	LOM 465-999
4	Mid strut fairing	54-52-00-07-320	LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-434, 437-447, 450-464
		54-52-00-11-335	LOM 465-999



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(Continued)

AMM Item	Description	AIPC Reference	AIPC Effectivity
4 (cont.)		54-52-00-12-335	LOM 465-999

F. Location Zones

Zone	Area
410	Subzone - Engine 1
420	Subzone - Engine 2
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

G. Access Panels

Number	Name/Location
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
431AT	Forward Strut Fairing, Thumbnail Fairing, Strut 1
431BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 1
431BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 1
441AT	Forward Strut Fairing, Thumbnail Fairing, Strut 2
441BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 2
441BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 2

H. Forward Fairing Installation

SUBTASK 54-52-01-400-001

- (1) Do these steps to install the thumbnail fairing [1]:
 - (a) Make sure that the fan cowl panel has not been installed.
 - (b) Put the thumbnail fairing [1] in its correct location.
 - 1) Place the aft end of the thumbnail fairing [1] on the two alignment pins on the support beam.
 - 2) Lower the forward end of the thumbnail fairing [1].
 - (c) Close the latches to install the applicable access panels [1] to the strut:

Number	Name/Location
431AT	Forward Strut Fairing, Thumbnail Fairing, Strut 1
441AT	Forward Strut Fairing, Thumbnail Fairing, Strut 2

 - (d) Do these steps to adjust the closing force of the thumbnail fairing latches:
 - 1) Make sure that all the other latches are closed other than the latch that is adjusted.
 - a) One badly adjusted latch may impact the engagement forces of the other latches.

NOTE: The S313A002 latches may not engage properly unless the bridge between the housing and the trigger is rotated beneath the latch handle during handle rotation and latch keeper adjustment.
 - 2) Apply a closing force at 0.50 ± 0.25 in. (12.70 ± 6.35 mm) from the end of the handle.
 - a) Make sure that the force range to close the latch handles is 15.0 lbf (66.7 N) - 20.0 lbf (89.0 N).

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LOM ALL

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- 3) If it is necessary, with the latch handle open, adjust the keeper by turning the hex drive clockwise or counterclockwise as required.
 - 4) To get access for adjustment of the S313A003 latch keepers with a latch access cover plate installed, turn the latch access cover plate with a 5/64 inch hex wrench, STD-12081.
 - a) For the latch keepers adjustment from the top with the cover plate installed, use a hex wrench.
 - 5) After the initial adjustment, do the steps again to make sure that the forces of all the latches are in the permitted range.

NOTE: The adjustment of one latch has an effect on the forces of the other latches.

 - a) Do the steps until all the latches can be engaged with a permitted force without adjustment of force for the other latches.
- (e) Do these steps to adjust the closing force of the flush latch:
- 1) Make sure that all the other latch keepers are closed.
 - 2) Apply a closing force at the interface of the flush latch handle and trigger mechanism.
- NOTE: Keep an approximately 90 degree position between the pressure gage and trigger mechanism.
- a) Make sure that force range to close the flush latch handle is 12.5 lbf (55.6 N) - 36.5 lbf (162.4 N).
- 3) If it is necessary, loosen the locknuts to adjust the hex head bolt.
 - a) Remove the lockwire to loosen the locknuts (TASK 20-10-44-000-801).
 - b) Adjust the hex head bolt to get the correct preload.
 - c) Tighten the locknuts to 30 in-lb (3.4 N·m) - 50 in-lb (5.6 N·m).
 - d) Install MS20995C32 lockwire, G01048, with double twist method (TASK 20-10-44-400-801).
- (f) After all latches are adjusted, close all latch access covers, turn to close the cover plate on latches with a latch access cover plate.
- (g) Install these access panels:
(Fan Cowl Panel Installation (Selection), TASK 71-11-02-400-801-F00)

<u>Number</u>	<u>Name/Location</u>
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2

SUBTASK 54-52-01-000-003

- (2) Do these steps to install the mid strut fairing [3] or mid strut fairing [4]:
 - (a) Place the following in the correct locations:

<u>Number</u>	<u>Name/Location</u>
431BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 1
431BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 1
441BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 2
441BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 2

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- (b) Install the bolts [2] with grease, D00633, on the mid strut fairing [3] or mid strut fairing [4].
1) Tighten the bolts [2] to 75 in-lb (8.5 N·m) - 85 in-lb (9.6 N·m).

I. Put the Airplane Back to Its Usual Condition

SUBTASK 54-52-01-440-002

- (1) Do this task: Put the Strut Back to its Usual Condition, TASK 54-51-01-440-801.

———— END OF TASK ——

EFFECTIVITY
LOM ALL

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FORWARD FAIRINGS - INSPECTION/CHECK

1. General

- A. This procedure examines the forward fairings for damage. If the fall arrest fitting stops a person who falls, you must do this procedure.

TASK 54-52-01-000-801

2. Forward Fairings Examination

A. References

Reference	Title
54-51-01-040-801	Prepare the Strut for Maintenance Operations (P/B 201)
54-51-01-440-801	Put the Strut Back to its Usual Condition (P/B 201)
54-52-00-200-801	Aerodynamic Smoothness Requirements (P/B 201)
54-52-01-010-801	Forward Fairing Removal (P/B 401)
54-52-01-410-801	Forward Fairing Installation (P/B 401)
71-11-02-000-801-F00	Fan Cowl Panel Removal (Selection) (P/B 401)
71-11-02-400-801-F00	Fan Cowl Panel Installation (Selection) (P/B 401)
SRM 54-50-70	Structural Repair Manual
SRM 54-50-71	Structural Repair Manual

B. Consumable Materials

Reference	Description	Specification
B00065	Alcohol - Denatured, Ethyl (Ethanol)	AMS 3002 (Supersedes O-A-396)
B00130	Alcohol - Isopropyl	TT-I-735
G50262	Wiper - Cleaning	BMS15-5
G51301	Tape - Aluminum Foil Tape, Heavy Duty, 3M 438	

C. Location Zones

Zone	Area
431	Engine 1 - Forward Strut Fairing
441	Engine 2 - Forward Strut Fairing

D. Access Panels

Number	Name/Location
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2
431AT	Forward Strut Fairing, Thumbnail Fairing, Strut 1
431BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 1
431BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 1
441AT	Forward Strut Fairing, Thumbnail Fairing, Strut 2
441BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 2
441BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 2

EFFECTIVITY
LOM ALL

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E. Forward Fairing Examination

SUBTASK 54-52-01-040-001

- (1) Do this task: Prepare the Strut for Maintenance Operations, TASK 54-51-01-040-801.

SUBTASK 54-52-01-010-001

- (2) To remove the applicable forward fairing panel, do this task (Forward Fairing Removal, TASK 54-52-01-010-801):

Open these access panels:

Number	Name/Location
431AT	Forward Strut Fairing, Thumbnail Fairing, Strut 1
431BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 1
431BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 1
441AT	Forward Strut Fairing, Thumbnail Fairing, Strut 2
441BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 2
441BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 2

Number	Name/Location
431AT	Forward Strut Fairing, Thumbnail Fairing, Strut 1
431BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 1
431BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 1
441AT	Forward Strut Fairing, Thumbnail Fairing, Strut 2
441BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 2
441BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 2

SUBTASK 54-52-01-010-003

- (3) To remove the applicable forward fairing panel, do this task (Fan Cowl Panel Removal (Selection), TASK 71-11-02-000-801-F00):

Open these access panels:

Number	Name/Location
---------------	----------------------

Number	Name/Location
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2

SUBTASK 54-52-01-020-001

- (4) Examine the forward fairings.

- (a) Examine the forward fairings for cracks in the skin, separation of the bonded layers, and damage to the paint and protective coating.
- 1) If you find damage to the forward fairings, repair the fairing as specified: (SRM 54-50-70).
- (b) Examine the support structure for cracks or damage.
- 1) If you find damage to the forward fairing support structure, repair the structure as specified in this procedure: (SRM 54-50-71).
- (c) Examine the tape on the frame assembly for damage.
- 1) If you find damage to the tape, do these steps:
 - a) Remove the tape that is damaged.
<1> Remove unwanted adhesive.
 - b) Use a wiper, G50262, wet with alcohol, B00130, or alcohol, B00065, to clean the frame assembly surface.
 - c) Use a clean dry wiper, G50262, to remove unwanted alcohol, B00130, or alcohol, B00065.
 - d) Apply 3M 438 Aluminum Foil Tape, G51301, to the frame assembly surface.
<1> If more than one piece of tape is used, make sure that the edges of the tape touch.



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<2> Make sure that the pieces of tape do not overlap.

SUBTASK 54-52-01-010-002

- (5) To install the forward fairing panel, do this task (Forward Fairing Installation, TASK 54-52-01-410-801):

Close these access panels:

Number	Name/Location
431AT	Forward Strut Fairing, Thumbnail Fairing, Strut 1
431BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 1
431BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 1
441AT	Forward Strut Fairing, Thumbnail Fairing, Strut 2
441BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 2
441BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 2

SUBTASK 54-52-01-010-004

- (6) To install the applicable forward fan cowl panel, do this task (Fan Cowl Panel Installation (Selection), TASK 71-11-02-400-801-F00):

Close these access panels:

Number	Name/Location
413	Left Fan Cowl, Engine 1
414	Right Fan Cowl, Engine 1
423	Left Fan Cowl, Engine 2
424	Right Fan Cowl, Engine 2

SUBTASK 54-52-01-040-004

- (7) Do this task: Aerodynamic Smoothness Requirements, TASK 54-52-00-200-801.

SUBTASK 54-52-01-040-002

- (8) Do this task: Put the Strut Back to its Usual Condition, TASK 54-51-01-440-801.

———— END OF TASK ————

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FORWARD FAIRING PRESSURE RELIEF DOOR LATCH - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) A removal of the forward fairing pressure relief door latches.
 - (2) An installation of the forward fairing pressure relief door latches.

TASK 54-52-02-020-801

2. Forward Fairing Pressure Relief Door Latch Removal

(Figure 401)

A. General

- (1) This task is the removal procedure for the forward fairing pressure relief door latches.
- (2) Each strut forward (thumbnail) fairing has a pressure relief door with two latches.

B. References

Reference	Title
54-51-01-040-801	Prepare the Strut for Maintenance Operations (P/B 201)

C. Location Zones

Zone	Area
430	Subzone - Engine 1, Nacelle Strut
431	Engine 1 - Forward Strut Fairing
440	Subzone - Engine 2, Nacelle Strut
441	Engine 2 - Forward Strut Fairing

D. Prepare for the Removal

SUBTASK 54-52-02-040-001

- (1) Do this task: Prepare the Strut for Maintenance Operations, TASK 54-51-01-040-801.

SUBTASK 54-52-02-010-001

- (2) Open the pressure relief door on the top surface by inserting a screwdriver into the tool slot and moving the screwdriver handle parallel to the latch centerline until the latch releases.

E. Pressure Relief Door Latch Removal

SUBTASK 54-52-02-020-001

- (1) Remove the bolts [1], nuts [2] and washers [3] which are located on the aft end of the pressure relief door [5].

SUBTASK 54-52-02-020-002

- (2) Remove the two forward pressure relief door latch [4] from the pressure relief door [5].

— END OF TASK —

TASK 54-52-02-420-801

3. Forward Fairing Pressure Relief Door Latch Installation

(Figure 401)

A. General

- (1) This task is the installation procedure for the forward fairing pressure relief door latches.

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B. References

Reference	Title
54-51-01-440-801	Put the Strut Back to its Usual Condition (P/B 201)
54-52-02-200-801	Pressure Relief Door Latch Test (P/B 501)

C. Consumable Materials

Reference	Description	Specification
A00767	Sealant - Fuel Tank	BMS5-45

D. Location Zones

Zone	Area
430	Subzone - Engine 1, Nacelle Strut
431	Engine 1 - Forward Strut Fairing
440	Subzone - Engine 2, Nacelle Strut
441	Engine 2 - Forward Strut Fairing

E. Prepare for the Installation

SUBTASK 54-52-02-100-001

- (1) Prepare the inside surface of the pressure relief door [5] for sealing.

F. Pressure Relief Door Latch Installation

SUBTASK 54-52-02-390-002

- (1) Make sure that the area between the pressure relief door latches [4] and the pressure relief door [5] is clean.

SUBTASK 54-52-02-390-003

- (2) Apply sealant, A00767, between the pressure relief door latches [4] and the pressure relief door [5].

SUBTASK 54-52-02-390-004

- (3) Install each pressure relief door latch [4] to the pressure relief door [5] as follows:
 - (a) Install the pressure relief door latch [4] to the pressure relief door [5] so that the holes in the latch align with the holes in the door.
 - (b) Install the four bolts [1], washers [3], and nuts [2].
 - (c) Tighten the nuts [2] to 12 in-lb (1.36 N·m) - 15 in-lb (1.69 N·m).

G. Installation Test

SUBTASK 54-52-02-200-001

- (1) Make sure that the pressure relief door [5] opens and closes smoothly.

SUBTASK 54-52-02-200-002

- (2) Do this task: Pressure Relief Door Latch Test, TASK 54-52-02-200-801.

H. Put the Airplane Back to its Usual Condition

SUBTASK 54-52-02-410-001

- (1) Close the forward fairing pressure relief door [5].

SUBTASK 54-52-02-440-001

- (2) Do this task: Put the Strut Back to its Usual Condition, TASK 54-51-01-440-801.

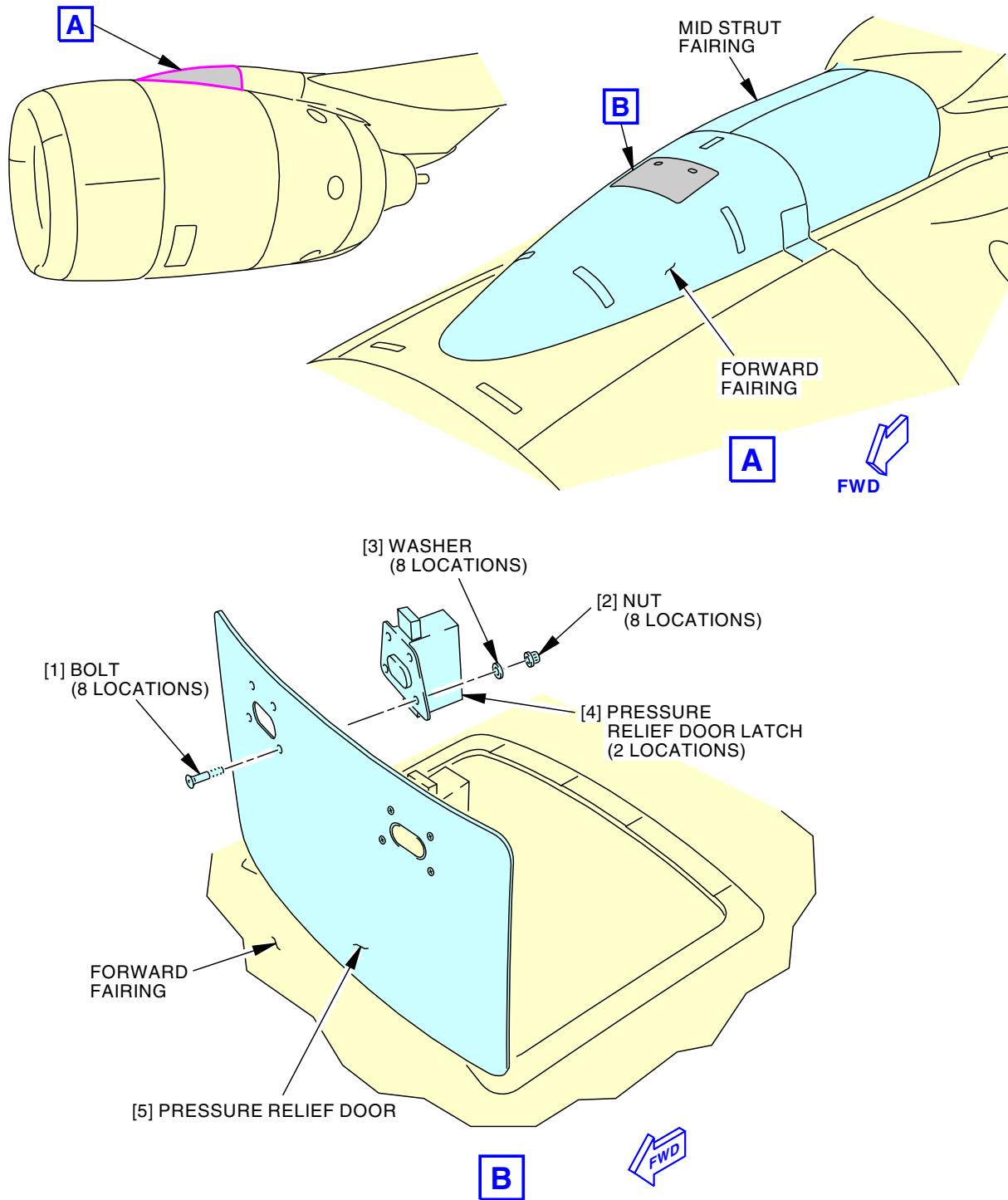
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EFFECTIVITY
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Forward Fairing Pressure Relief Door Latches Installation
Figure 401/54-52-02-990-801 (Sheet 1 of 2)

EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-78-1089

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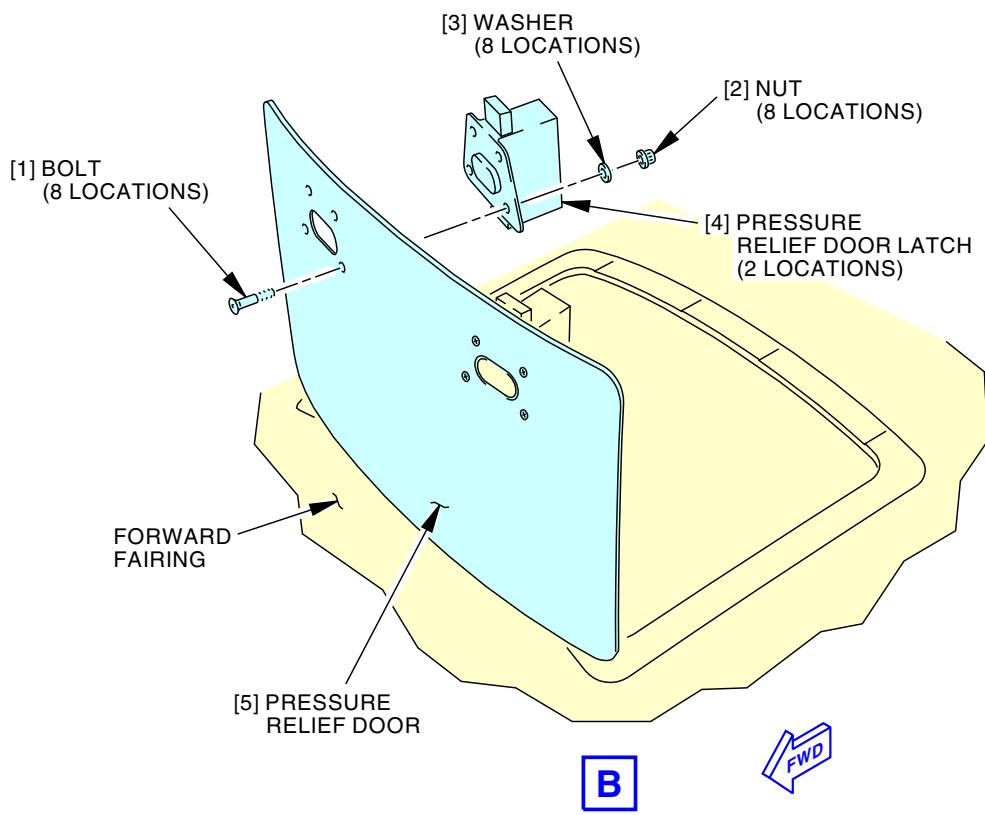
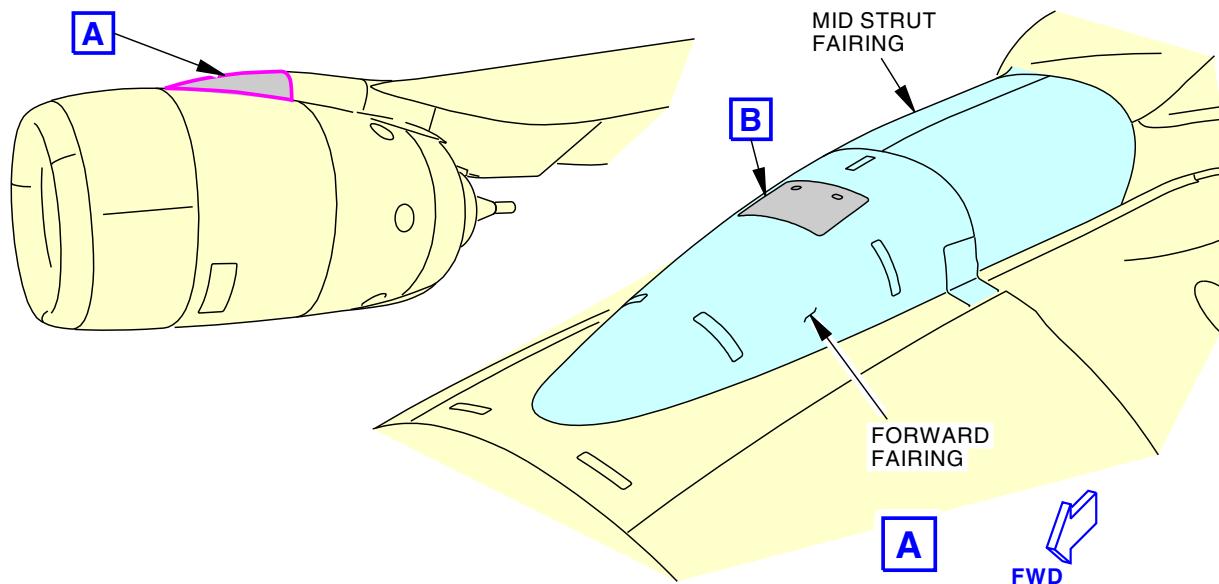
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2090404 S0000439177_V2

Forward Fairing Pressure Relief Door Latches Installation
Figure 401/54-52-02-990-801 (Sheet 2 of 2)

EFFECTIVITY
LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
407, 411, 412, 415, 416, 420, 422-426 POST SB
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FORWARD FAIRING PRESSURE RELIEF DOOR - ADJUSTMENT/TEST

1. General

- A. This procedure has one task:
- (1) A test of the strut pressure relief door latches.

TASK 54-52-02-200-801

2. Pressure Relief Door Latch Test

A. General

- (1) This task is a test for the strut pressure relief door latches.
- (2) Each strut has one pressure relief door, located on the strut forward fairing.
- (3) Each pressure relief door has two latches.

B. References

Reference	Title
54-51-01-040-801	Prepare the Strut for Maintenance Operations (P/B 201)
54-51-01-440-801	Put the Strut Back to its Usual Condition (P/B 201)
54-52-02-020-801	Forward Fairing Pressure Relief Door Latch Removal (P/B 401)
54-52-02-420-801	Forward Fairing Pressure Relief Door Latch 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-4410	Adapter Equipment - Load Test, Pressure Relief Door Latch Part #: B71044-37 Supplier: 81205 Opt Part #: B71044-10 Supplier: 81205
STD-1012	Wrench - Torque, 0 to 100 in-lbs (0 to 11.3 N-m)

D. Location Zones

Zone	Area
430	Subzone - Engine 1, Nacelle Strut
431	Engine 1 - Forward Strut Fairing
440	Subzone - Engine 2, Nacelle Strut
441	Engine 2 - Forward Strut Fairing

E. Prepare for the Check

SUBTASK 54-52-02-040-002

- (1) Do this task: Prepare the Strut for Maintenance Operations, TASK 54-51-01-040-801.

SUBTASK 54-52-02-010-002

- (2) Open both pressure relief door latches on the upper surface.

F. Pressure Relief Door Latch Check

SUBTASK 54-52-02-200-004

- (1) Do these steps to check each pressure relief door latch:

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- (a) Install the adapter equipment, SPL-4410 on the pressure relief door as shown on the usage placard, and close the latch that you will test.
- (b) Attach the pivot support assembly and torque wrench, STD-1012 to the adapter assembly.



CAUTION

TEST ONLY ONE LATCH AT A TIME. MAKE SURE THE OTHER LATCH IS OPEN. IF THE OTHER LATCH IS CLOSED, DAMAGE TO THE PRESSURE RELIEF DOOR CAN OCCUR.

- (c) With the torque wrench handle parallel to door edge, turn the handle until the latch releases, noting the torque required.

SUBTASK 54-52-02-200-006

- (2) Compare the torque just noted with the requirements (below).

NOTE: The adapter/pivot tool will apply a torque value that is two times the load necessary to open the latch. To apply a latch opening load of 50 lbf (222 N), set the torque wrench to 100 in-lb (11 Nm).

- (a) Make sure the latch opens immediately when you apply a force of 53-65 pounds (236-289 newtons) to the door.

SUBTASK 54-52-02-080-001

- (3) Remove the adapter equipment, SPL-4410 and the torque wrench, STD-1012 from the pressure relief door.

SUBTASK 54-52-02-200-005

- (4) Do the steps again to test the other latch.

SUBTASK 54-52-02-400-002

- (5) If the latch is defective, replace the latch. These are the tasks:

- Forward Fairing Pressure Relief Door Latch Removal, TASK 54-52-02-020-801,
- Forward Fairing Pressure Relief Door Latch Installation, TASK 54-52-02-420-801

G. Put the Airplane Back to its Usual Condition.

SUBTASK 54-52-02-410-002

- (1) Make sure you close the pressure relief door.

SUBTASK 54-52-02-440-002

- (2) Do this task: Put the Strut Back to its Usual Condition, TASK 54-51-01-440-801.

———— END OF TASK ————

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WING JUNCTION FAIRINGS - REMOVAL/INSTALLATION

1. General

- A. This procedure has two tasks:
- (1) The removal of the wing junction fairings
 - (2) The installation of the wing junction fairings.

TASK 54-52-03-010-801

2. Wing Junction Fairing - Removal

(Figure 401,Figure 402)

A. General

- (1) This procedure contains the removal of the wing junction fairings.
- (2) Each strut has these wing junction fairings:
 - (a) An inboard and an outboard overwing fairing
 - (b) An inboard and an outboard underwing fairing.

B. References

Reference	Title
54-51-01-040-801	Prepare the Strut for Maintenance Operations (P/B 201)

C. Location Zones

Zone	Area
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

D. Access Panels

Number	Name/Location
431CL	Forward Strut Fairing, Left Overwing Fairing, Strut 1
431CR	Forward Strut Fairing, Right Overwing Fairing, Strut 1
431DL	Forward Strut Fairing, Left Underwing Fairing, Strut 1
431DR	Forward Strut Fairing, Right Underwing Fairing, Strut 1
441CL	Forward Strut Fairing, Left Overwing Fairing, Strut 2
441CR	Forward Strut Fairing, Right Overwing Fairing, Strut 2
441DL	Forward Strut Fairing, Left Underwing Fairing, Strut 2
441DR	Forward Strut Fairing, Right Underwing Fairing, Strut 2

E. Prepare for the Removal

SUBTASK 54-52-03-040-002

- (1) Do this task: Prepare the Strut for Maintenance Operations, TASK 54-51-01-040-801.

F. Wing Junction Fairing Removal

SUBTASK 54-52-03-020-009

- (1) Do these steps to remove the outboard overwing fairing:

- (a) Remove the bolts [5] that attach the outboard overwing fairing [1] to the strut.
 - (b) Open the applicable access panels:

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

EFFECTIVITY
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(Continued)

Number **Name/Location**

441CR Forward Strut Fairing, Right Overwing Fairing, Strut 2

LOM 427-434, 437-447, 450-999

- (c) Remove the screw [6], washers [7], and washer [8] that attach the bonding jumper.

LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426

- (d) Remove the screw [6], washer [7], and washer [8] that attach the bonding jumper.

LOM ALL

- (e) Remove the outboard overwing fairing [1].

SUBTASK 54-52-03-020-010

- (2) Do these steps to remove the outboard underwing fairing:

- (a) Remove the bolts [5] that attach the outboard underwing fairing [2] to the strut.
(b) Open the applicable access panels:

Number **Name/Location**

431DL Forward Strut Fairing, Left Underwing Fairing, Strut 1

441DR Forward Strut Fairing, Right Underwing Fairing, Strut 2

- (c) Remove the outboard underwing fairing [2].

SUBTASK 54-52-03-020-001

- (3) Do these steps to remove the inboard overwing fairing:

- (a) Remove the bolts [5] that attach the inboard overwing fairing [3] to the strut.
(b) Open the applicable access panels:

Number **Name/Location**

431CR Forward Strut Fairing, Right Overwing Fairing, Strut 1

441CL Forward Strut Fairing, Left Overwing Fairing, Strut 2

LOM 427-434, 437-447, 450-999

- (c) Remove the screw [6], washers [7], and washer [8] that attach the bonding jumper.

LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426

- (d) Remove the screw [6], washer [7], and washer [8] that attach the bonding jumper.

LOM ALL

- (e) Remove the inboard overwing fairing [3].

SUBTASK 54-52-03-020-003

- (4) Do these steps to remove the inboard underwing fairing:

- (a) Remove the bolts [5] that attach the inboard underwing fairing [4] to the strut.
(b) Open the applicable access panels:

Number **Name/Location**

431DR Forward Strut Fairing, Right Underwing Fairing, Strut 1

441DL Forward Strut Fairing, Left Underwing Fairing, Strut 2

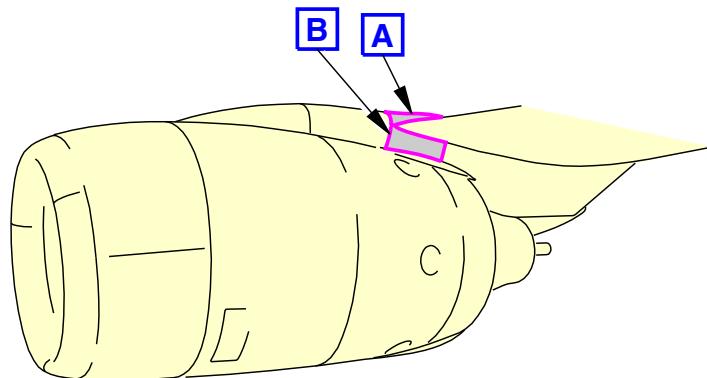
- (c) Remove the inboard underwing fairing [4].

— END OF TASK —

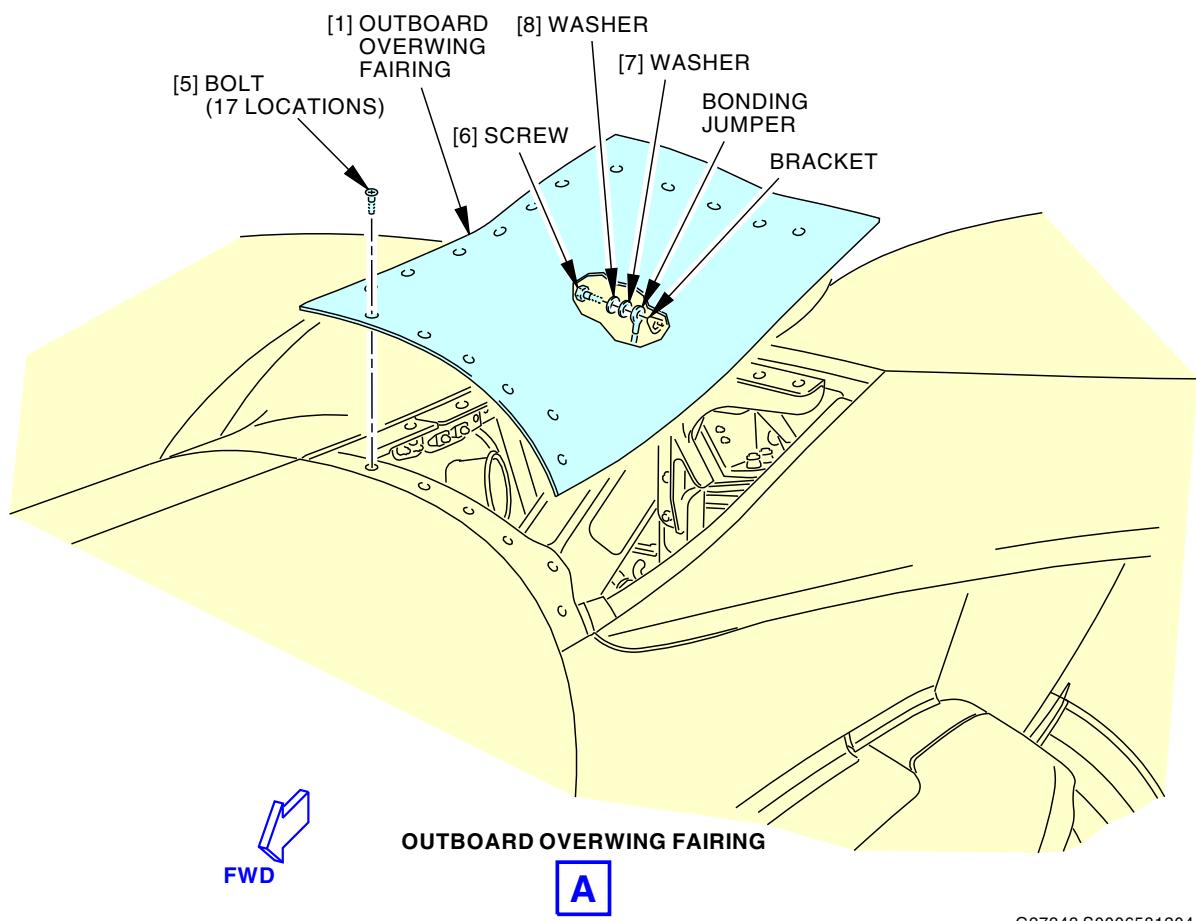
EFFECTIVITY

LOM ALL

54-52-03



**LEFT STRUT
(RIGHT STRUT IS OPPOSITE)**



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**Outboard Wing Junction Fairings
Figure 401/54-52-03-990-803 (Sheet 1 of 4)**

EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-78-1089

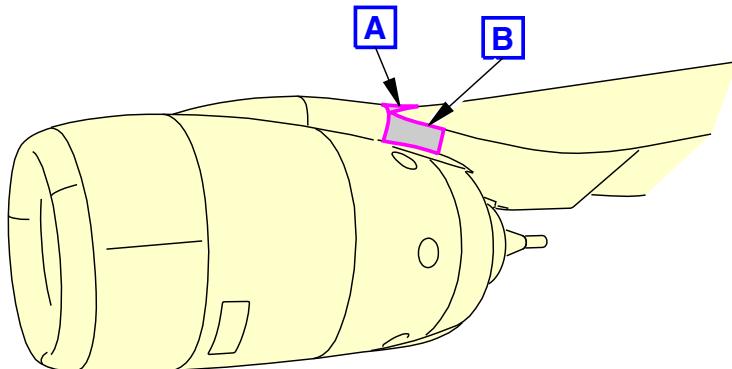
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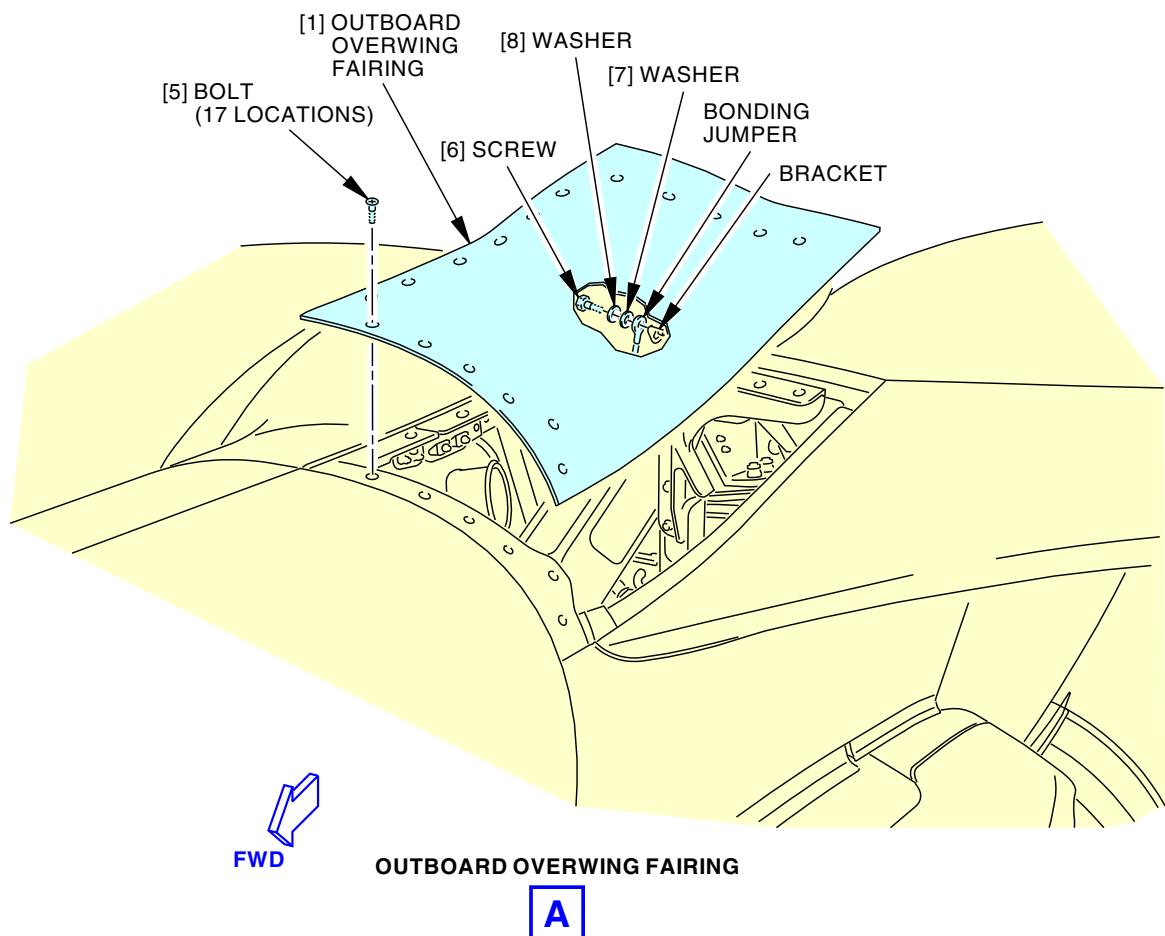
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LEFT STRUT
(RIGHT STRUT IS OPPOSITE)



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Outboard Wing Junction Fairings
Figure 401/54-52-03-990-803 (Sheet 2 of 4)

EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 POST SB 737-78-1089

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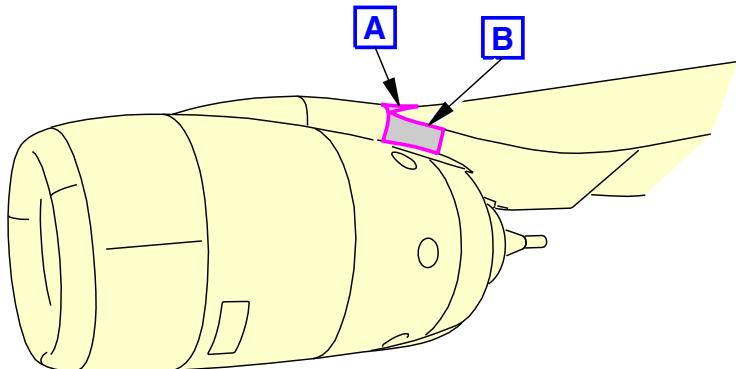
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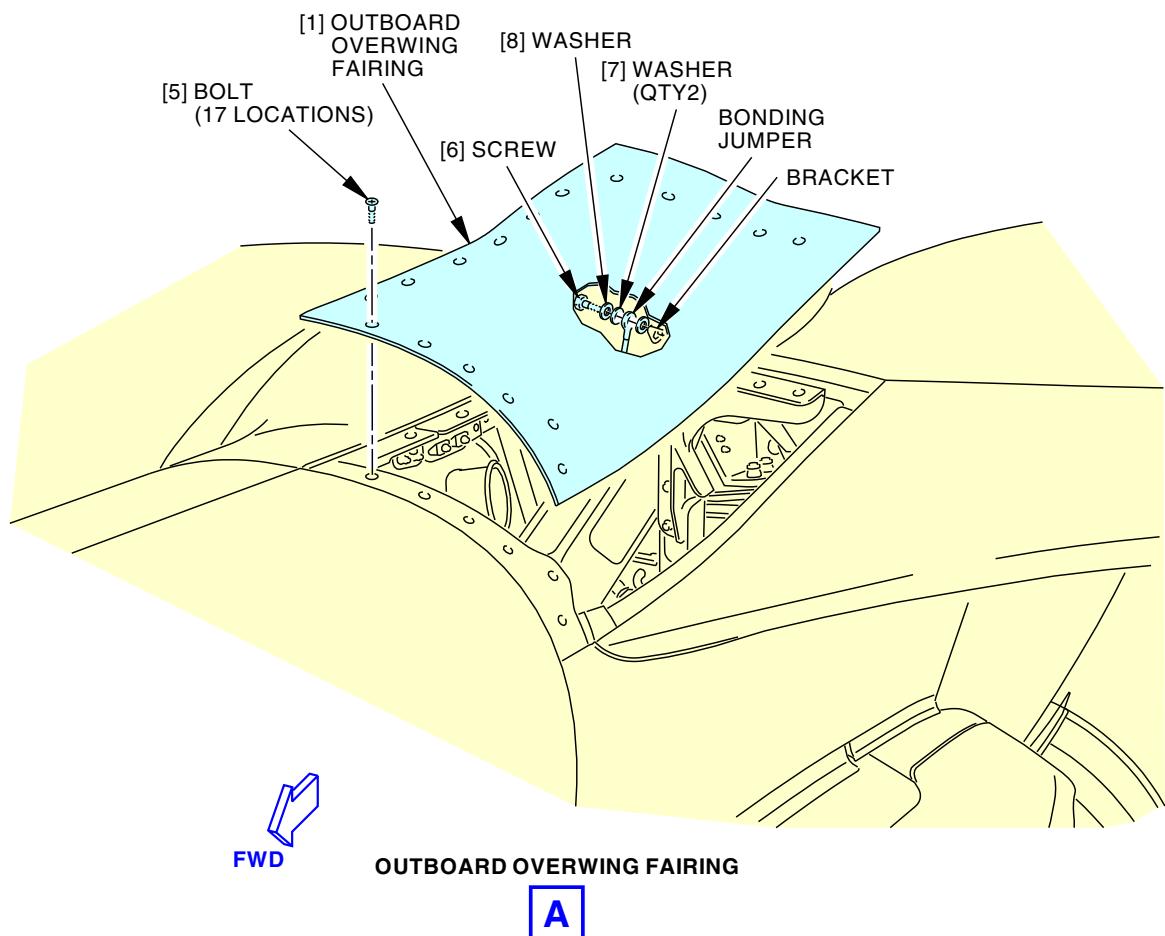
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LEFT STRUT
(RIGHT STRUT IS OPPOSITE)



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Outboard Wing Junction Fairings
Figure 401/54-52-03-990-803 (Sheet 3 of 4)

EFFECTIVITY
LOM 427-434, 437-447, 450-999

54-52-03

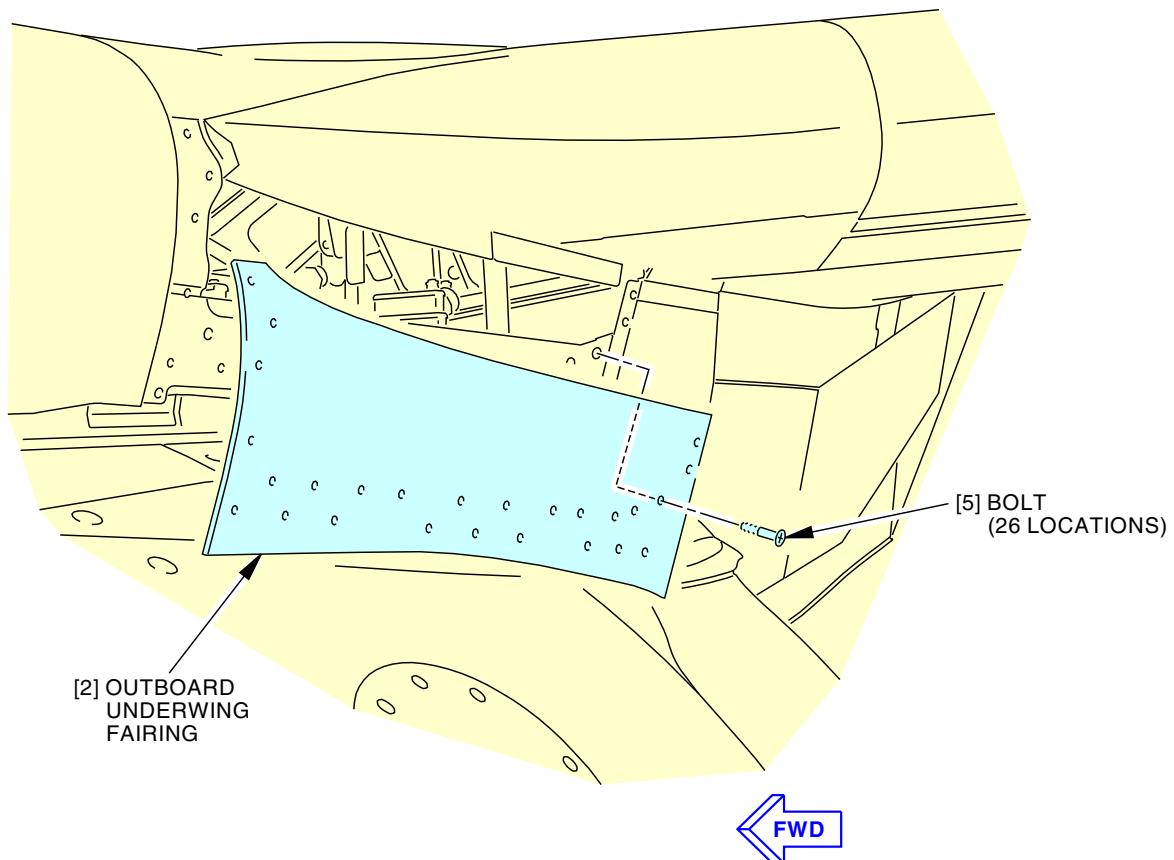
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OUTBOARD UNDERWING FAIRING

B

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Outboard Wing Junction Fairings
Figure 401/54-52-03-990-803 (Sheet 4 of 4)

EFFECTIVITY
LOM ALL

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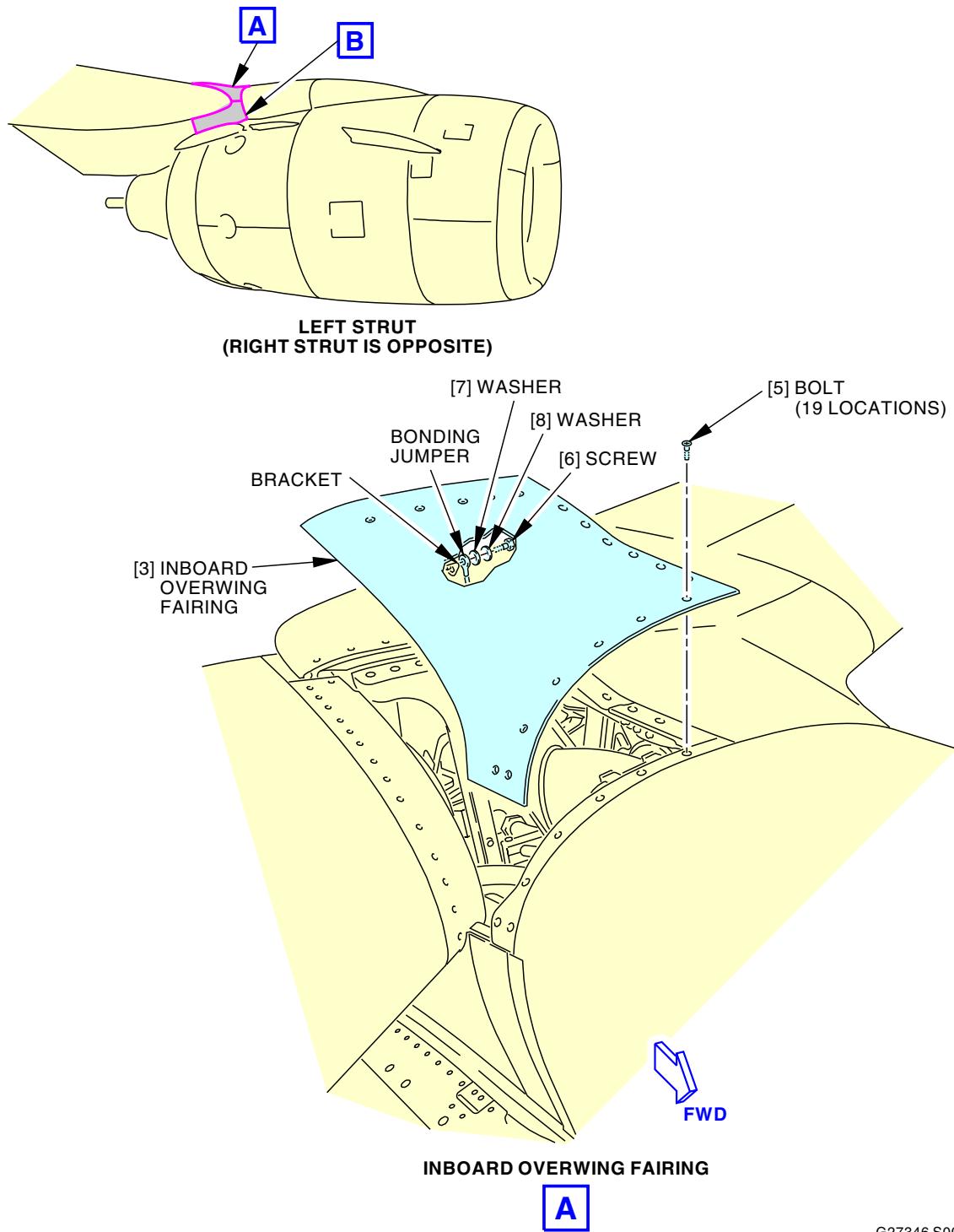
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Inboard Wing Junction Fairings
Figure 402/54-52-03-990-804 (Sheet 1 of 4)

EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-78-1089

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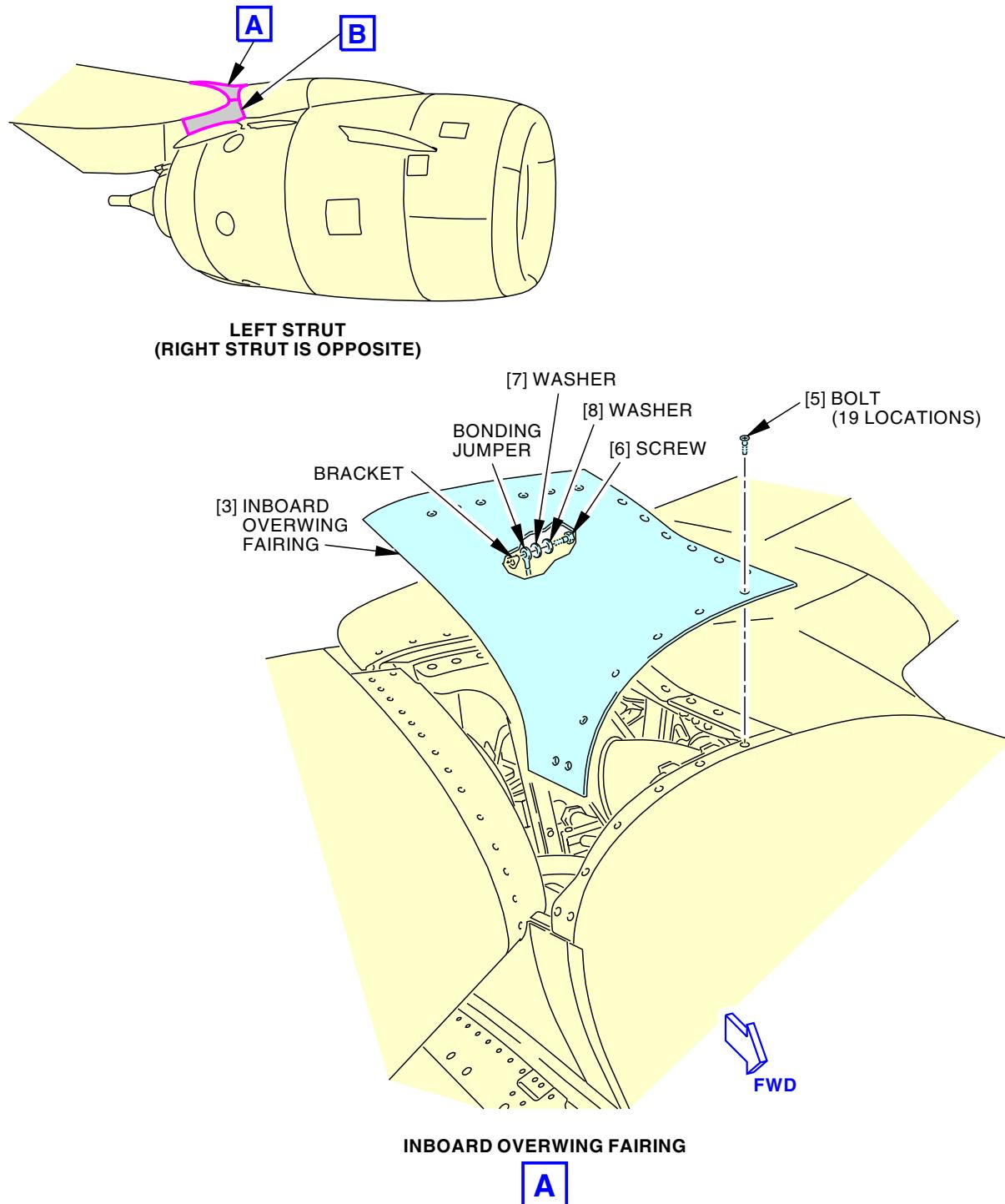
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Inboard Wing Junction Fairings
Figure 402/54-52-03-990-804 (Sheet 2 of 4)

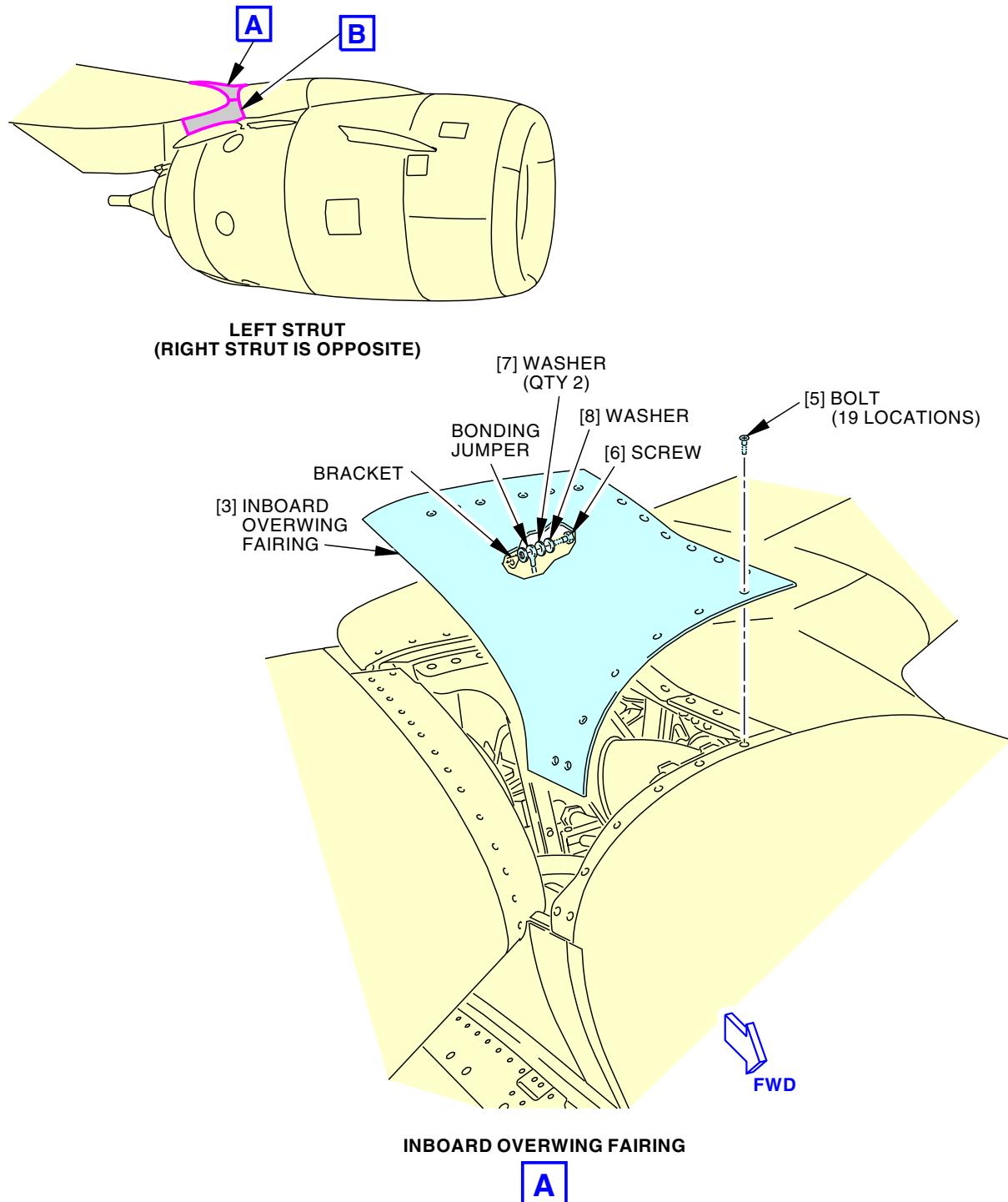
EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 POST SB 737-78-1089

54-52-03

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2933027 S0000709188_V1

Inboard Wing Junction Fairings
Figure 402/54-52-03-990-804 (Sheet 3 of 4)

EFFECTIVITY
LOM 427-434, 437-447, 450-999

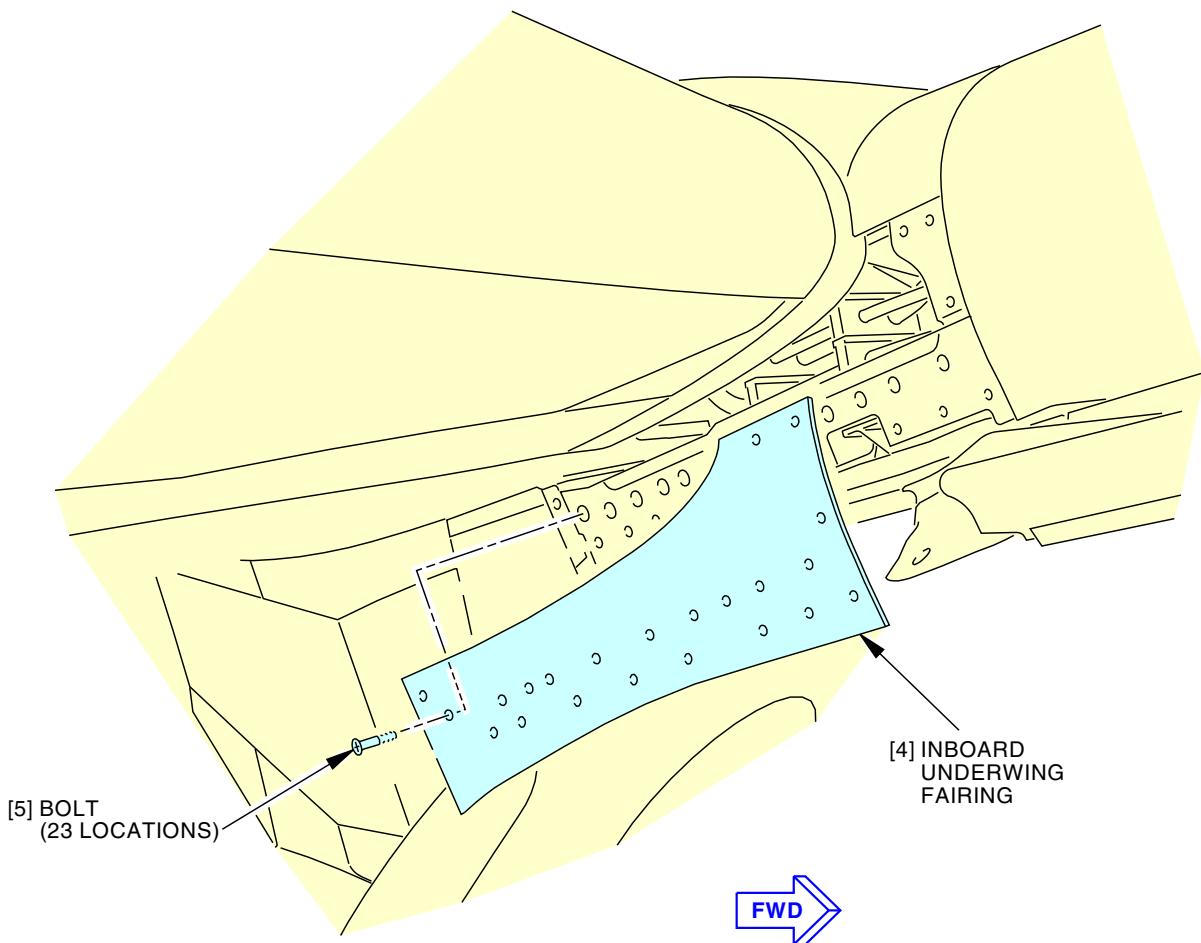
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INBOARD UNDERWING FAIRING

B

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Inboard Wing Junction Fairings
Figure 402/54-52-03-990-804 (Sheet 4 of 4)

EFFECTIVITY
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TASK 54-52-03-410-801

3. Wing Junction Fairing - Installation

(Figure 401 and Figure 402)

A. General

- (1) This procedure contains the installation of the wing junction fairings.
- (2) Each strut has these wing junction fairings:
 - (a) An inboard and an outboard overwing fairing
 - (b) An inboard and an outboard underwing fairing.

B. References

Reference	Title
51-21-41-370-802	Bonderite M-CR 600 Aero, Bonderite M-CR Alcrm 1200 Aero or Bonderite M-CR 1200S Aero Application Process (P/B 701)
54-51-01-440-801	Put the Strut Back to its Usual Condition (P/B 201)
SWPM 20-20-00	ELECTRICAL BONDING PROCESSES

C. Tools/Equipment

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

Reference	Description
COM-1550	Bonding Meter - Approved, Intrinsically Safe (Approved for use in Class I, Divisions I & II hazardous (classified) locations. Outside these hazardous locations, COM-614 can be used in lieu of COM-1550). Part #: 620LK Supplier: 1CRL2 Part #: M1 Supplier: 3AD17 Part #: M1B Supplier: 3AD17 Part #: T477W (C15292) Supplier: 06659

D. Consumable Materials

Reference	Description	Specification
A00160	Sealant - Firewall - Hydraulic Fluid Resistant	BMS5-63
C00259	Coating - Chemical And Solvent Resistant Finish, Corrosion Inhibiting Primer	BMS10-11 Type I
C00862	Coating - Chemical Conversion - Bonderite M-CR 600 Aero (Formerly Alodine 600)	BAC5719 Class A, C or D, MIL-DTL-81706 Type I Class 1A or 3
G50262	Wiper - Cleaning	BMS15-5

E. Location Zones

Zone	Area
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

F. Access Panels

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

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Number	Name/Location
431DL	Forward Strut Fairing, Left Underwing Fairing, Strut 1
431DR	Forward Strut Fairing, Right Underwing Fairing, Strut 1
441CL	Forward Strut Fairing, Left Overwing Fairing, Strut 2
441CR	Forward Strut Fairing, Right Overwing Fairing, Strut 2
441DL	Forward Strut Fairing, Left Underwing Fairing, Strut 2
441DR	Forward Strut Fairing, Right Underwing Fairing, Strut 2

G. Wing Junction Fairing Installation

SUBTASK 54-52-03-420-001

- (1) Do these steps to install the bonding jumper to the outboard overwing fairing [1] (Figure 401):

- (a) Prepare a fay surface bond between the mating surfaces of the outboard overwing fairing [1] and airplane structure (SWPM 20-20-00).
 - 1) Do the abrasive cleaning procedure to manually clean the bracket.
 - 2) Do the solvent cleaning procedure to clean the bonding jumper and the fasteners.
- (b) Install a fay sealed fay surface bond between the mating surfaces of the outboard overwing fairing [1] and airplane structure (SWPM 20-20-00).

LOM 427-434, 437-447, 450-999

- 1) Apply a faying surface seal to the area of the bonding contact of the bracket, bonding jumper, threads of the screw [6], faces of the washers [7] and the washer [8].
 - a) Use sealant, A00160.

LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426

- 2) Apply a faying surface seal to the area of the bonding contact of the bracket, bonding jumper, threads of the screw [6], faces of the washer [7] and the washer [8].
 - a) Use sealant, A00160.

LOM 427-434, 437-447, 450-999

- 3) Install the screw [6], washers [7], washer [8] that attach the bonding jumper to the bracket.
 - a) Torque the screw [6] to 32 in-lb (3.6 N·m) - 38 in-lb (4.3 N·m).

LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426

- 4) Install the screw [6], washer [7], washer [8] that attach the bonding jumper to the bracket.
 - a) Torque the screw [6] to 32 in-lb (3.6 N·m) - 38 in-lb (4.3 N·m).

LOM ALL

- (c) Make sure that the sealant is continuous around each component and fastener.
 - 1) Smooth out the extruded sealant with a clean wiper, G50262.
- (d) Measure the resistance between the bonding jumper and the bracket with an intrinsically safe approved bonding meter, COM-1550 (SWPM 20-20-00).
 - 1) Make sure that the resistance is 0.001 ohm (1.0 milliohm) or less.



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LOM 427-434, 437-447, 450-999

- (e) Refinish abraded surfaces that you can see.
- 1) Apply Bonderite M-CR 600 Aero coating, C00862 (TASK 51-21-41-370-802).
 - 2) Apply one or two coats of primer, C00259.

LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426

- (f) Refinish abraded surfaces that you can see.
- 1) Apply Bonderite M-CR 600 Aero coating, C00862 (TASK 51-21-41-370-802).

LOM ALL

SUBTASK 54-52-03-020-011

- (2) Do these steps to install the outboard overwing fairing [1] (Figure 401):



CAUTION

BONDING GROMMETS HELP PREVENT POSSIBLE DAMAGE DUE TO LIGHTNING. IF THE BONDING GROMMETS ARE NOT INSTALLED, DAMAGE TO THE AIRPLANE MAY OCCUR.

- (a) Make sure that all of the fastener holes have bonding (metallic) grommets.
 - 1) If the grommets are missing, replace them.
- (b) Close the applicable access panels:

Number	Name/Location
431CL	Forward Strut Fairing, Left Overwing Fairing, Strut 1
441CR	Forward Strut Fairing, Right Overwing Fairing, Strut 2
- (c) Install the bolts [5] that attach the outboard overwing fairing [1] to the strut.

SUBTASK 54-52-03-020-012

- (3) Do these steps to install the outboard underwing fairing [2] (Figure 401):



CAUTION

BONDING GROMMETS HELP PREVENT POSSIBLE DAMAGE DUE TO LIGHTNING. IF THE BONDING GROMMETS ARE NOT INSTALLED, DAMAGE TO THE AIRPLANE MAY OCCUR.

- (a) Make sure that all of the fastener holes have bonding (metallic) grommets.
 - 1) If the grommets are missing, replace them.
- (b) Close the applicable access panels:

Number	Name/Location
431DL	Forward Strut Fairing, Left Underwing Fairing, Strut 1
441DR	Forward Strut Fairing, Right Underwing Fairing, Strut 2
- (c) Install the bolts [5] that attach the outboard underwing fairing [2] to the strut.

SUBTASK 54-52-03-420-002

- (4) Do these steps to install the bonding jumper to the inboard overwing fairing [3] (Figure 402):
- (a) Prepare a fay surface bond between the mating surfaces of the inboard overwing fairing [3] and airplane structure (SWPM 20-20-00).
 - 1) Do the abrasive cleaning procedure to manually clean the bracket.
 - 2) Do the solvent cleaning procedure to clean the bonding jumper and the fasteners.

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- (b) Install a fay sealed fay surface bond between the mating surfaces of the inboard overwing fairing [3] and airplane structure (SWPM 20-20-00).

LOM 427-434, 437-447, 450-999

- 1) Apply a faying surface seal to the area of the bonding contact of the bracket, bonding jumper, threads of the screw [6], faces of the washers [7] and the washer [8].
 - a) Use sealant, A00160.

LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426

- 2) Apply a faying surface seal to the area of the bonding contact of the bracket, bonding jumper, threads of the screw [6], faces of the washer [7] and the washer [8].
 - a) Use sealant, A00160.

LOM 427-434, 437-447, 450-999

- 3) Install the screw [6], washers [7], washer [8] that attach the bonding jumper to the bracket.
 - a) Torque the screw [6] to 32 in-lb (3.6 N·m) - 38 in-lb (4.3 N·m).

LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426

- 4) Install the screw [6], washer [7], washer [8] that attach the bonding jumper to the bracket.
 - a) Torque the screw [6] to 32 in-lb (3.6 N·m) - 38 in-lb (4.3 N·m).

LOM ALL

- (c) Make sure that the sealant is continuous around each component and fastener.
 - 1) Smooth out the extruded sealant with a clean wiper, G50262.
- (d) Measure the resistance between the bonding jumper and the bracket with an intrinsically safe approved bonding meter, COM-1550 (SWPM 20-20-00).
 - 1) Make sure that the resistance is 0.001 ohm (1.0 milliohm) or less.

LOM 427-434, 437-447, 450-999

- (e) Refinish abraded surfaces that you can see.
 - 1) Apply Bonderite M-CR 600 Aero coating, C00862 (TASK 51-21-41-370-802).
 - 2) Apply one or two coats of primer, C00259.

LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426

- (f) Refinish abraded surfaces that you can see.
 - 1) Apply Bonderite M-CR 600 Aero coating, C00862 (TASK 51-21-41-370-802).

LOM ALL

SUBTASK 54-52-03-020-005

- (5) Do these steps to install the inboard overwing fairing [3] (Figure 402):



BONDING GROMMETS HELP PREVENT POSSIBLE DAMAGE DUE TO LIGHTNING. IF THE BONDING GROMMETS ARE NOT INSTALLED, DAMAGE TO THE AIRPLANE MAY OCCUR.

- (a) Make sure that all of the fastener holes have bonding (metallic) grommets.

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- 1) If the grommets are missing, replace them.
- (b) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
431CR	Forward Strut Fairing, Right Overwing Fairing, Strut 1
441CL	Forward Strut Fairing, Left Overwing Fairing, Strut 2
- (c) Install the bolts [5] that attach the inboard overwing fairing [3] to the strut.

SUBTASK 54-52-03-020-007

- (6) Do these steps to install the inboard underwing fairing [4] (Figure 402):



BONDING GROMMETS HELP PREVENT POSSIBLE DAMAGE DUE TO LIGHTNING. IF THE BONDING GROMMETS ARE NOT INSTALLED, DAMAGE TO THE AIRPLANE MAY OCCUR.

- (a) Make sure that all of the fastener holes have bonding (metallic) grommets.
 - 1) If the grommets are missing, replace them.
- (b) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
431DR	Forward Strut Fairing, Right Underwing Fairing, Strut 1
441DL	Forward Strut Fairing, Left Underwing Fairing, Strut 2
- (c) Install the bolts [5] that attach the inboard underwing fairing [4] to the strut.

H. Put the Airplane Back to Its Usual Condition

SUBTASK 54-52-03-440-003

- (1) Do this task: Put the Strut Back to its Usual Condition, TASK 54-51-01-440-801.

———— END OF TASK ————

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WING JUNCTION FAIRINGS - INSPECTION/CHECK

1. General

- A. This procedure examines the wing junction fairings.

TASK 54-52-03-000-801

2. Wing Junction Fairing Examination

A. References

Reference	Title
20-40-11-760-801	Electrical Bonding (P/B 201)
54-51-01-040-801	Prepare the Strut for Maintenance Operations (P/B 201)
54-51-01-440-801	Put the Strut Back to its Usual Condition (P/B 201)
54-52-00-200-801	Aerodynamic Smoothness Requirements (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)
SRM 54-50-70	Structural Repair Manual
SRM 54-50-71	Structural Repair Manual

B. Location Zones

Zone	Area
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

C. Access Panels

Number	Name/Location
431CL	Forward Strut Fairing, Left Overwing Fairing, Strut 1
431CR	Forward Strut Fairing, Right Overwing Fairing, Strut 1
431DL	Forward Strut Fairing, Left Underwing Fairing, Strut 1
431DR	Forward Strut Fairing, Right Underwing Fairing, Strut 1
441CL	Forward Strut Fairing, Left Overwing Fairing, Strut 2
441CR	Forward Strut Fairing, Right Overwing Fairing, Strut 2
441DL	Forward Strut Fairing, Left Underwing Fairing, Strut 2
441DR	Forward Strut Fairing, Right Underwing Fairing, Strut 2

D. Prepare for the Examination

SUBTASK 54-52-03-040-001

- (1) Do this task: Prepare the Strut for Maintenance Operations, TASK 54-51-01-040-801.

SUBTASK 54-52-03-010-001

- (2) Do this task Wing Junction Fairing - Removal, TASK 54-52-03-010-801:

Open these access panels:

Number	Name/Location
431CL	Forward Strut Fairing, Left Overwing Fairing, Strut 1
431CR	Forward Strut Fairing, Right Overwing Fairing, Strut 1
431DL	Forward Strut Fairing, Left Underwing Fairing, Strut 1
431DR	Forward Strut Fairing, Right Underwing Fairing, Strut 1
441CL	Forward Strut Fairing, Left Overwing Fairing, Strut 2
441CR	Forward Strut Fairing, Right Overwing Fairing, Strut 2

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Number

Name/Location

- | | |
|-------|---|
| 441DL | Forward Strut Fairing, Left Underwing Fairing, Strut 2 |
| 441DR | Forward Strut Fairing, Right Underwing Fairing, Strut 2 |

E. Wing Junction Fairing Examination

SUBTASK 54-52-03-210-001

- (1) Do these steps to examine the wing junction fairings:
 - (a) Examine the wing junction fairings for cracks in the skin, separation of the bonded layers, and damage to the paint and protective coating.
 - (b) Examine the grounding jumpers on the overwing fairings for damage.
 - 1) If you find damage to the wing junction fairings, repair the fairings as specified in this procedure: (SRM 54-50-70).
 - (c) Examine the support structure of the wing junction fairings for cracks or damage.
 - 1) If you find damage to the wing junction fairing support structure, repair the support structure as specified in this procedure: (SRM 54-50-71).

SUBTASK 54-52-03-410-001

- (2) Do this task Wing Junction Fairing - Installation, TASK 54-52-03-410-801:

Close these access panels:

Number

Name/Location

- | | |
|-------|---|
| 431CL | Forward Strut Fairing, Left Overwing Fairing, Strut 1 |
| 431CR | Forward Strut Fairing, Right Overwing Fairing, Strut 1 |
| 431DL | Forward Strut Fairing, Left Underwing Fairing, Strut 1 |
| 431DR | Forward Strut Fairing, Right Underwing Fairing, Strut 1 |
| 441CL | Forward Strut Fairing, Left Overwing Fairing, Strut 2 |
| 441CR | Forward Strut Fairing, Right Overwing Fairing, Strut 2 |
| 441DL | Forward Strut Fairing, Left Underwing Fairing, Strut 2 |
| 441DR | Forward Strut Fairing, Right Underwing Fairing, Strut 2 |

SUBTASK 54-52-03-210-002

- (3) Do a check of the resistance of the grounding jumpers on the overwing fairings as specified in this procedure: (TASK 20-40-11-760-801).

SUBTASK 54-52-03-210-003

- (4) To make sure the wing junction fairings are in the aerodynamic smoothness limits, do this task: Aerodynamic Smoothness Requirements, TASK 54-52-00-200-801.

F. Put the Airplane Back to its Usual Condition

SUBTASK 54-52-03-440-001

- (1) Do this task: Put the Strut Back to its Usual Condition, TASK 54-51-01-440-801.

———— END OF TASK ————

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AFT FAIRING - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) A removal of the aft fairing with the engine removed.
 - (2) A removal of the aft fairing without the engine removed.
 - (3) A removal of the aft fairing with the primary nozzle and the primary plug removed.
 - (4) An installation of the aft fairing with the engine removed.
 - (5) An installation of the aft fairing without the engine removed.
 - (6) An installation of the aft fairing with the primary nozzle and the primary plug removed.

TASK 54-52-04-010-801

2. Aft Fairing Removal (Engine Removed)

(Figure 401, Figure 402, Figure 403)

A. References

Reference	Title
27-51-00-040-801	Trailing Edge Flap System Deactivation (P/B 201)
54-51-01-040-801	Prepare the Strut for Maintenance Operations (P/B 201)
54-52-06-010-801	Aft Fairing Access Panel Removal (P/B 401)
54-52-08-010-801	Aft Fairing Heatshield Removal (P/B 401)
71-00-02-000-801-F00	Power Plant - 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-1561	Jack - Hydraulic Part #: 930002 Supplier: FA2A9 Part #: J20009-110 Supplier: 81205 Opt Part #: J20009-108 Supplier: 81205 Opt Part #: J20009-109 Supplier: 81205
SPL-1584	Adapter Assembly - Telescoping Hydraulic Part #: J20009-136 Supplier: 81205 Opt Part #: J20009-68 Supplier: 81205
SPL-2019	Tool - Removal/Installation, Engine Strut Aft Fairing Part #: C54008-53 Supplier: 81205 Part #: C54008-54 Supplier: 81205 Opt Part #: C54008-1 Supplier: 81205 Opt Part #: C54008-28 Supplier: 81205

C. Location Zones

Zone	Area
410	Subzone - Engine 1
420	Subzone - Engine 2
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

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D. 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

E. Prepare for the Removal

SUBTASK 54-52-04-040-003

- (1) Do this task: Prepare the Strut for Maintenance Operations, TASK 54-51-01-040-801.

SUBTASK 54-52-04-040-004

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

SUBTASK 54-52-04-010-004

- (3) Do this task: Power Plant - Removal, TASK 71-00-02-000-801-F00.

SUBTASK 54-52-04-010-003

- (4) To remove the applicable aft fairing access panel, do this task Aft Fairing Access Panel Removal, TASK 54-52-06-010-801:

Open these 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

LOM 427-434, 437-447, 450-999; LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 POST SB 737-54-1047 OR POST SB 737-78-1089

SUBTASK 54-52-04-010-007

- (5) Remove the pan casting No. 1, (forward end) (TASK 54-52-08-010-801).

LOM ALL

SUBTASK 54-52-04-480-001

- (6) Put the rubber assembly, which is part of the aft fairing tool, SPL-2019, under the pipe as shown in (Figure 401).

SUBTASK 54-52-04-010-005

- (7) Put the installation aft fairing tool, SPL-2019 on the jack hydraulic jack, SPL-1561 with its telescoping hydraulic adapter assembly, SPL-1584 or on a ground based boom hoist, C78026.
- Put the aft fairing installation tool, on the underside of the aft fairing.
 - Make sure the weight of the aft fairing is held by the tool.

F. Aft Fairing Removal

SUBTASK 54-52-04-020-001

- (1) Do these steps to disconnect the strut drain hose [3] from the aft fairing drain tube: (Figure 402)

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- (a) Disconnect the strut drain hose [3] from the aft fairing drain tube [4] at the forward end of the strut drain tube [4].
- (b) Put a cap on the strut drain hose [3] and on the strut drain tube [4].

SUBTASK 54-52-04-020-002

- (2) Do these steps to structurally disconnect the forward end of the aft fairing from the strut: (Figure 403)
 - (a) Remove the bolts [47], the washers [42], the stiffener [46], and the nuts [44] to remove the stiffener.
 - (b) Remove the bolts [43], washers [41] and [42], and the nuts [44] to remove the lateral restraint fittings [40] and [45].

SUBTASK 54-52-04-000-001

- (3) Do these steps to structurally disconnect the aft fairing [1] or [2] from the bottom of the wing: (Figure 403)
 - (a) At the trailing edge of the aft fairing, remove the bolt [11], nut [14], washer [13], and washer [12].
 - (b) Remove the bolts [15], nuts [18], washers [16], and washers [17] from the nacelle support fitting.
 - (c) Remove the bolt [19], nut [22], washer [21], and washer [20] from the fittings on each side of the aft fairing.
 - (d) Remove the bolt [23], nut [28], washer [27], washer [24], bushing [26], and bushing [25] from the fitting on the aft fairing.

SUBTASK 54-52-04-580-001

- (4) Carefully lower the aft fairing [1] or [2] with the aft fairing installation aft fairing tool, SPL-2019.

————— END OF TASK ————

TASK 54-52-04-010-802

3. Aft Fairing Removal (Engine Not Removed)

(Figure 404, Figure 405, Figure 406)

A. References

Reference	Title
27-51-00-040-801	Trailing Edge Flap System Deactivation (P/B 201)
54-51-01-040-801	Prepare the Strut for Maintenance Operations (P/B 201)
54-52-06-010-801	Aft Fairing Access Panel Removal (P/B 401)
54-52-08-010-801	Aft Fairing Heatshield Removal (P/B 401)
78-11-01-000-802-F00	Primary Nozzle 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-1561	Jack - Hydraulic Part #: 930002 Supplier: FA2A9 Part #: J20009-110 Supplier: 81205 Opt Part #: J20009-108 Supplier: 81205 Opt Part #: J20009-109 Supplier: 81205

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Reference	Description
SPL-1584	Adapter Assembly - Telescoping Hydraulic Part #: J20009-136 Supplier: 81205 Opt Part #: J20009-68 Supplier: 81205
SPL-2019	Tool - Removal/Installation, Engine Strut Aft Fairing Part #: C54008-53 Supplier: 81205 Part #: C54008-54 Supplier: 81205 Opt Part #: C54008-1 Supplier: 81205 Opt Part #: C54008-28 Supplier: 81205

C. Location Zones

Zone	Area
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

D. 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

E. Prepare for the Removal

SUBTASK 54-52-04-040-011

- (1) Do this task: Prepare the Strut for Maintenance Operations, TASK 54-51-01-040-801.

SUBTASK 54-52-04-040-012

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

SUBTASK 54-52-04-010-009

- (3) To remove the applicable aft fairing access panel, do this task Aft Fairing Access Panel Removal, TASK 54-52-06-010-801:

Open these 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

SUBTASK 54-52-04-020-011

- (4) If it is necessary, do this task: Primary Nozzle Assembly Removal, TASK 78-11-01-000-802-F00.



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737-54-1047 OR POST SB 737-78-1089**

SUBTASK 54-52-04-010-010

- (5) Remove the pan casting No. 1, (forward end) (TASK 54-52-08-010-801).

LOM ALL

SUBTASK 54-52-04-480-002

- (6) Put the rubber assembly, which is part of the aft fairing tool, SPL-2019, under the pipe (Figure 404).

SUBTASK 54-52-04-010-011

- (7) Put the installation aft fairing tool, SPL-2019, on the jack hydraulic jack, SPL-1561, with its telescoping hydraulic adapter assembly, SPL-1584, or on a ground based boom hoist, C78026.
 - (a) Put the aft fairing installation tool, on the underside of the aft fairing.
 - (b) Make sure the weight of the aft fairing is held by the tool.

F. Aft Fairing Removal

SUBTASK 54-52-04-020-009

- (1) Do these steps to disconnect the strut drain hose [3] from the aft fairing drain tube (Figure 405):
 - (a) Disconnect the strut drain hose [3] from the aft fairing drain tube [4] at the forward end of the aft fairing drain tube [4].
 - (b) Put a cap on the strut drain hose [3] and on the aft fairing drain tube [4].

SUBTASK 54-52-04-020-010

- (2) Do these steps to structurally disconnect the forward end of the aft fairing from the strut (Figure 406):
 - (a) Remove the bolts [47], washers [42] and nuts [44] to remove the stiffener [46].
 - (b) Remove the bolts [43], washers [41], washers [42] and nuts [44] to remove the lateral restraint fitting [40] and fitting [45].

SUBTASK 54-52-04-000-008

- (3) Do these steps to structurally disconnect the left aft fairing [1] or right aft fairing [2] from the bottom of the wing (Figure 406):
 - (a) At the trailing edge of the aft fairing, remove the bolt [11], nut [14], washer [13], and washer [12].
 - (b) Remove the bolt [15], nut [18], washer [16], and washer [17] from the nacelle support fitting.
 - (c) Remove the bolt [19], nut [22], washer [21], and washer [20] from the fittings on each side of the aft fairing.
 - (d) Remove the bolt [23], nut [28], washer [27], washer [24], bushing [26], and bushing [25] from the fitting on the aft fairing.

SUBTASK 54-52-04-580-002

- (4) Carefully lower the left aft fairing [1] or right aft fairing [2] with the aft fairing installation aft fairing tool, SPL-2019.

———— END OF TASK ————

EFFECTIVITY
LOM ALL

54-52-04



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TASK 54-52-04-000-803

4. Aft Fairing Removal (Without Primary Nozzle and Plug)

(Figure 407Figure 408Figure 409)

A. References

Reference	Title
27-51-00-040-801	Trailing Edge Flap System Deactivation (P/B 201)
27-51-00-860-803	Extend the Trailing Edge Flaps (P/B 201)
54-51-01-040-801	Prepare the Strut for Maintenance Operations (P/B 201)
54-52-06-010-801	Aft Fairing Access Panel Removal (P/B 401)
54-52-08-010-801	Aft Fairing Heatshield Removal (P/B 401)
78-11-01-000-801-F00	Primary Nozzle Assembly Removal (P/B 401)
78-11-01-000-802-F00	Primary Nozzle Assembly Removal (P/B 401)
78-11-02-000-801-F00	Primary Plug Assembly Removal (P/B 401)
78-11-02-000-802-F00	Primary Plug 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-1561	Jack - Hydraulic Part #: 930002 Supplier: FA2A9 Part #: J20009-110 Supplier: 81205 Opt Part #: J20009-108 Supplier: 81205 Opt Part #: J20009-109 Supplier: 81205
SPL-1584	Adapter Assembly - Telescoping Hydraulic Part #: J20009-136 Supplier: 81205 Opt Part #: J20009-68 Supplier: 81205
SPL-2019	Tool - Removal/Installation, Engine Strut Aft Fairing Part #: C54008-53 Supplier: 81205 Part #: C54008-54 Supplier: 81205 Opt Part #: C54008-1 Supplier: 81205 Opt Part #: C54008-28 Supplier: 81205
SPL-2430	Hoist ? Boom, 800 lbs WLL, 250 lbs Load Positioner Compatible Part #: C20002-267 Supplier: 81205 Part #: K20017-1 Supplier: 81205 Opt Part #: C78026-161 Supplier: 81205 Opt Part #: C78026-259 Supplier: 81205

C. Location Zones

Zone	Area
410	Subzone - Engine 1
420	Subzone - Engine 2
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

D. Access Panels

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

EFFECTIVITY
LOM ALL

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(Continued)

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

E. Prepare for the Removal

SUBTASK 54-52-04-040-008

- (1) Do this task: Prepare the Strut for Maintenance Operations, TASK 54-51-01-040-801.

SUBTASK 54-52-04-040-010

- (2) Do this task: Extend the Trailing Edge Flaps, TASK 27-51-00-860-803.

SUBTASK 54-52-04-040-009

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

SUBTASK 54-52-04-020-005

- (4) Do this task: Primary Nozzle Assembly Removal, TASK 78-11-01-000-802-F00 or Primary Nozzle Assembly Removal, TASK 78-11-01-000-801-F00.

SUBTASK 54-52-04-020-006

- (5) Do this task: Primary Plug Assembly Removal, TASK 78-11-02-000-802-F00 or Primary Plug Assembly Removal, TASK 78-11-02-000-801-F00.

SUBTASK 54-52-04-010-006

- (6) To remove the applicable aft fairing access panel, do this task Aft Fairing Access Panel Removal, TASK 54-52-06-010-801:

Open these access panels:

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

LOM 427-434, 437-447, 450-999; LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 POST SB 737-54-1047 OR POST SB 737-78-1089

SUBTASK 54-52-04-010-008

- (7) Remove the pan casting No. 1, (forward end) (TASK 54-52-08-010-801).

LOM ALL

SUBTASK 54-52-04-000-002

- (8) Put the rubber assembly, which is part of the aft fairing tool, SPL-2019, under the pipe as shown in Figure 407.

SUBTASK 54-52-04-000-003

- (9) Put the installation aft fairing tool, SPL-2019 on the jack hydraulic jack, SPL-1561 with its telescoping hydraulic adapter assembly, SPL-1584 or on a boom hoist, SPL-2430.

(a) Put the aft fairing installation tool, on the underside of the aft fairing.

(b) Make sure the weight of the aft fairing is held by the tool.

EFFECTIVITY
LOM ALL

54-52-04



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F. Aft Fairing Removal

SUBTASK 54-52-04-000-004

- (1) Do these steps to disconnect the strut drain hose [3] from the aft fairing drain tube:
(Figure 408)
 - (a) Disconnect the strut drain hose [3] from the aft fairing drain tube [4] at the forward end of the strut drain tube [4].
 - (b) Put a cap on the strut drain hose [3] and on the strut drain tube [4].

SUBTASK 54-52-04-000-005

- (2) Do these steps to structurally disconnect the forward end of the aft fairing from the strut:
(Figure 409)
 - (a) Remove the bolts [47], the washers [42], the stiffener [46], and the nuts [44] to remove the stiffener.
 - (b) Remove the bolts [43], washers [41] and [42], and the nuts [44] to remove the lateral restraint fittings [40] and [45].

SUBTASK 54-52-04-000-006

- (3) Do these steps to structurally disconnect the aft fairing [1] or [2] from the bottom of the wing:
(Figure 409)
 - (a) At the trailing edge of the aft fairing, remove the bolt [11], nut [14], washer [13], and washer [12].
 - (b) Remove the bolts [15], nuts [18], washers [16], and washers [17] from the nacelle support fitting.
 - (c) Remove the bolt [19], nut [22], washer [21], and washer [20] from the fittings on each side of the aft fairing.
 - (d) Remove the bolt [23], nut [28], washer [27], washer [24], bushing [26], and bushing [25] from the fitting on the aft fairing.

SUBTASK 54-52-04-000-007

- (4) Carefully lower the aft fairing [1] or [2] with the aft fairing installation aft fairing tool, SPL-2019.

————— END OF TASK ————

TASK 54-52-04-410-801

5. Aft Fairing Installation (Engine Removed)

(Figure 401, Figure 402, Figure 403)

A. References

Reference	Title
20-10-51-400-804	Flareless Tubing Assembly Installation (P/B 401)
27-51-00-440-801	Trailing Edge Flap System Reactivation (P/B 201)
54-51-01-440-801	Put the Strut Back to its Usual Condition (P/B 201)
54-52-06-410-801	Aft Fairing Access Panel Installation (P/B 401)
54-52-08-010-802	Aft Fairing Heatshield Installation (P/B 401)
71-00-02-400-801-F00	Power Plant - 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.



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Reference	Description
SPL-1561	Jack - Hydraulic Part #: 930002 Supplier: FA2A9 Part #: J20009-110 Supplier: 81205 Opt Part #: J20009-108 Supplier: 81205 Opt Part #: J20009-109 Supplier: 81205
SPL-1584	Adapter Assembly - Telescoping Hydraulic Part #: J20009-136 Supplier: 81205 Opt Part #: J20009-68 Supplier: 81205
SPL-2019	Tool - Removal/Installation, Engine Strut Aft Fairing Part #: C54008-53 Supplier: 81205 Part #: C54008-54 Supplier: 81205 Opt Part #: C54008-1 Supplier: 81205 Opt Part #: C54008-28 Supplier: 81205
SPL-2430	Hoist ? Boom, 800 lbs WLL, 250 lbs Load Positioner Compatible Part #: C20002-267 Supplier: 81205 Part #: K20017-1 Supplier: 81205 Opt Part #: C78026-161 Supplier: 81205 Opt Part #: C78026-259 Supplier: 81205

C. Location Zones

Zone	Area
433	Engine 1 - Strut Torque Box
443	Engine 2 - Strut Torque Box

D. 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

E. Aft Fairing Installation

SUBTASK 54-52-04-020-004

- (1) Do these steps to structurally connect the forward end of the aft fairing to the strut:
(Figure 403)
 - (a) Put the forward assembly, on the underside of the strut, (Figure 401).
 - (b) Use the hydraulic jack, SPL-1561 with its telescoping hydraulic adapter assembly, SPL-1584 or the boom hoist, SPL-2430 to lift the aft fairing in its position under the wing.
 - (c) Attach the forward assembly to the aft fairing installation aft fairing tool, SPL-2019.
 - (d) Turn the turnbuckles on the forward assembly to apply a preload in the forward direction.
 - (e) Install the bolts [43], the washers [41], the washers [42], and the nuts [44] to install the two lateral restraint fittings [40] and [45].
 - (f) Install the bolts [47], the washers [42], the stiffener [46], and the nuts [44].

SUBTASK 54-52-04-400-001

- (2) Do these steps to install the aft fairing [1] or [2] under the wing, (Figure 403):

EFFECTIVITY
LOM ALL

54-52-04



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- (a) At the trailing edge of the aft fairing, install the bolt [11], nut [14], washer [12], and the washer [13].
- (b) Install the bolts [15], washer [16], washer [17] and nuts [18] at the wing attach fitting.
- (c) Install the bolt [19], washer [21], washer [20] and nut [22] to the fittings on each side of the aft fairing.
- (d) Install the bolt [23], washer [27], washer [24], bushing [26], bushing [25] and nut [28] to the fittings on each side of the aft fairing.

SUBTASK 54-52-04-080-002

- (3) Remove the aft fairing installation aft fairing tool, SPL-2019, the forward assembly, and the rubber assembly, (Figure 401).

SUBTASK 54-52-04-420-001

- (4) Do these steps to fasten the strut drain hose [3] to the aft fairing drain tube [4]: (Figure 402)
 - (a) Connect the aft fairing drain tube hose to the coupling at the strut aft bulkhead.
 - (b) Tighten the end fitting on the strut drain hose [3], (TASK 20-10-51-400-804).

F. Put the Airplane Back to Its Usual Condition

LOM 427-434, 437-447, 450-999; LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 POST SB 737-54-1047 OR POST SB 737-78-1089

SUBTASK 54-52-04-410-004

- (1) Install the pan casting No. 1, (forward end) (TASK 54-52-08-010-802).

LOM ALL

SUBTASK 54-52-04-410-003

- (2) To install the applicable aft fairing access panel, do this task **Aft Fairing Access Panel Installation**, TASK 54-52-06-410-801:

Close these 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

SUBTASK 54-52-04-040-007

- (3) Do this task: **Power Plant - Installation**, TASK 71-00-02-400-801-F00.

SUBTASK 54-52-04-440-003

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

SUBTASK 54-52-04-440-004

- (5) Do this task: **Put the Strut Back to its Usual Condition**, TASK 54-51-01-440-801.

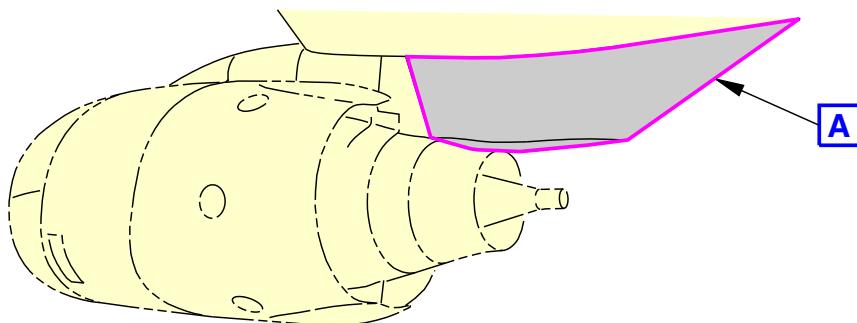
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EFFECTIVITY
LOM ALL

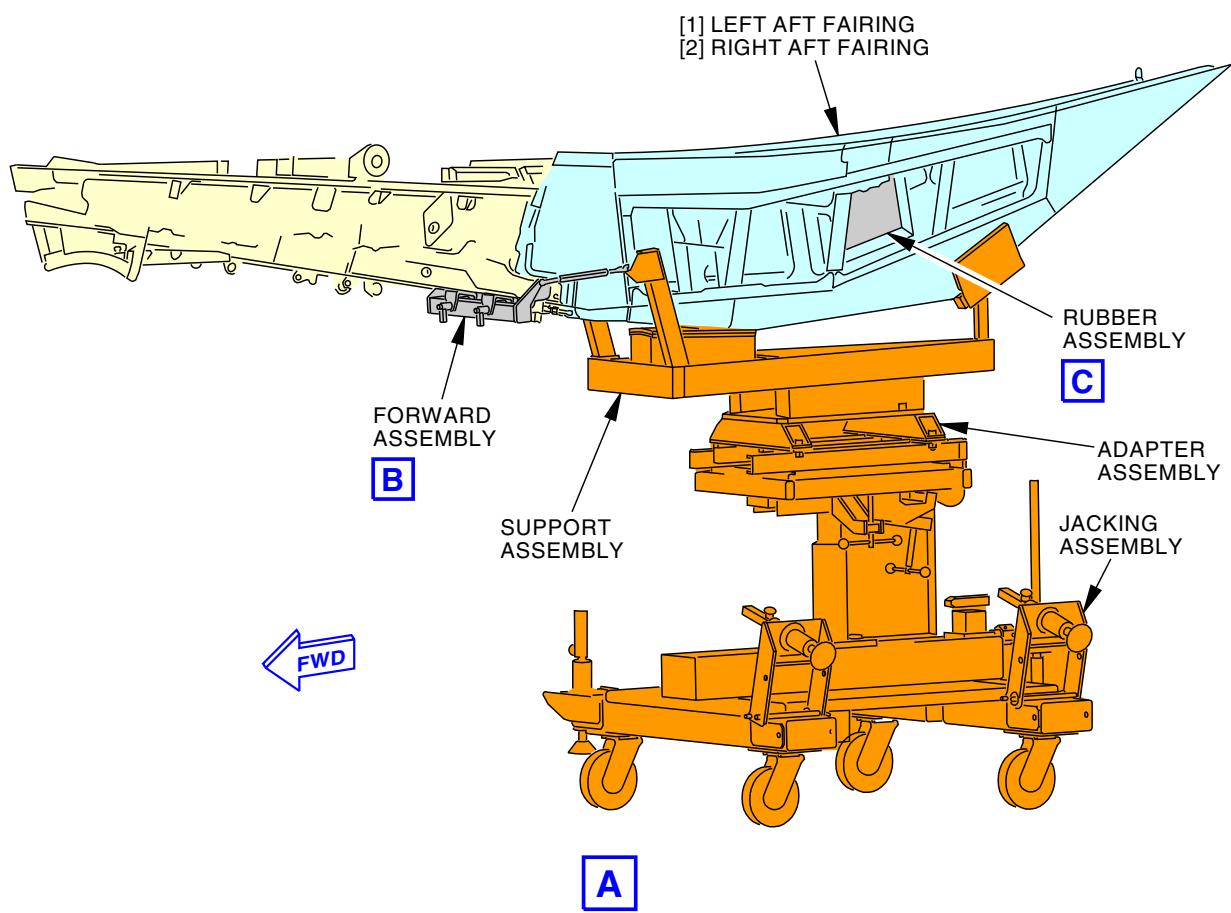
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AIRCRAFT MAINTENANCE MANUAL



LEFT AFT FAIRING
(RIGHT AFT FAIRING IS OPPOSITE)



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Aft Fairing Installation Tool
Figure 401/54-52-04-990-801 (Sheet 1 of 4)

EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-78-1089

54-52-04

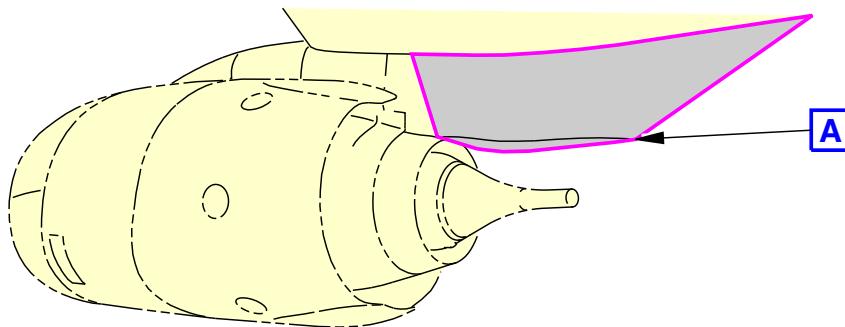
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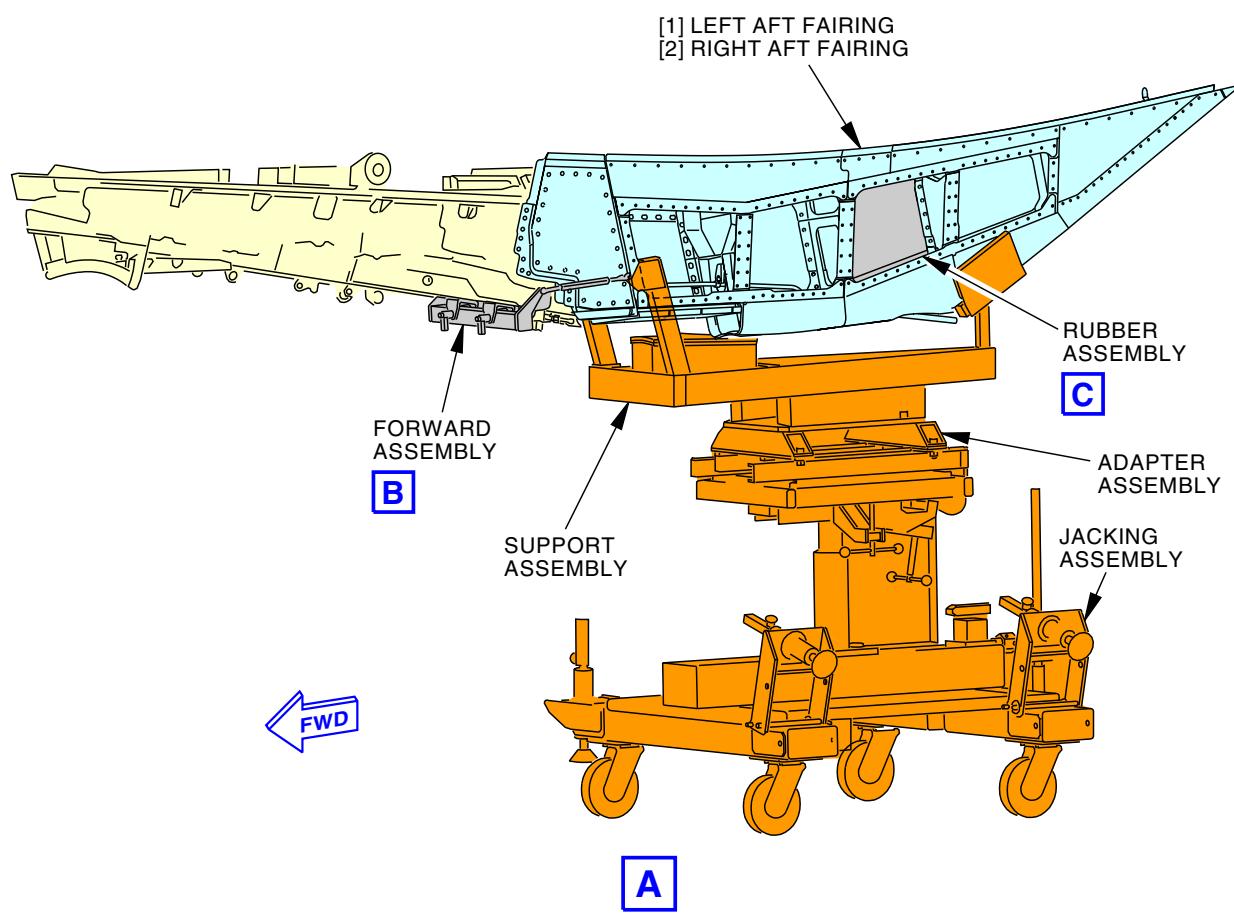
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AIRCRAFT MAINTENANCE MANUAL



LEFT AFT FAIRING
(RIGHT AFT FAIRING IS OPPOSITE)



2095362 S0000439180_V4

Aft Fairing Installation Tool
Figure 401/54-52-04-990-801 (Sheet 2 of 4)

EFFECTIVITY
LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
407, 411, 412, 415, 416, 420, 422-426 POST SB
737-54-1047 OR POST SB 737-78-1089

54-52-04

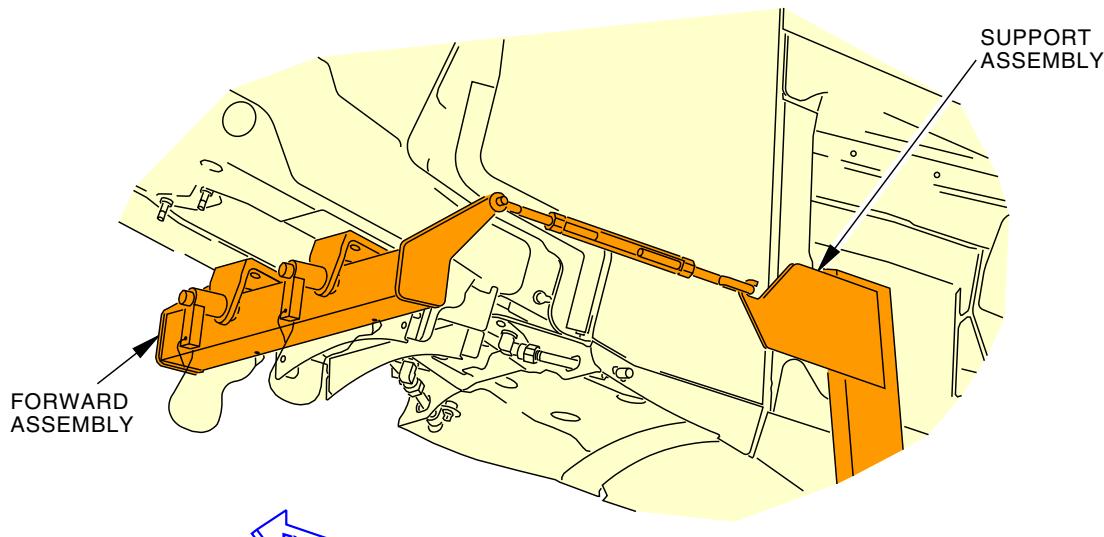
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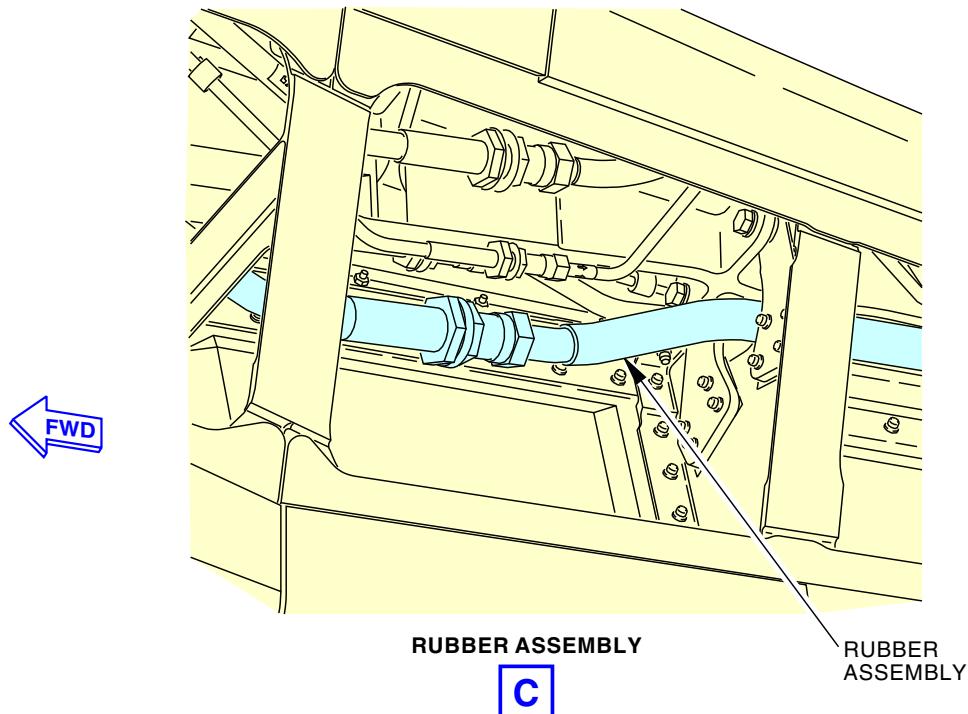
 BOEING

737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL



FORWARD ASSEMBLY

B



RUBBER ASSEMBLY

C

RUBBER ASSEMBLY

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Aft Fairing Installation Tool
Figure 401/54-52-04-990-801 (Sheet 3 of 4)

EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-78-1089

54-52-04

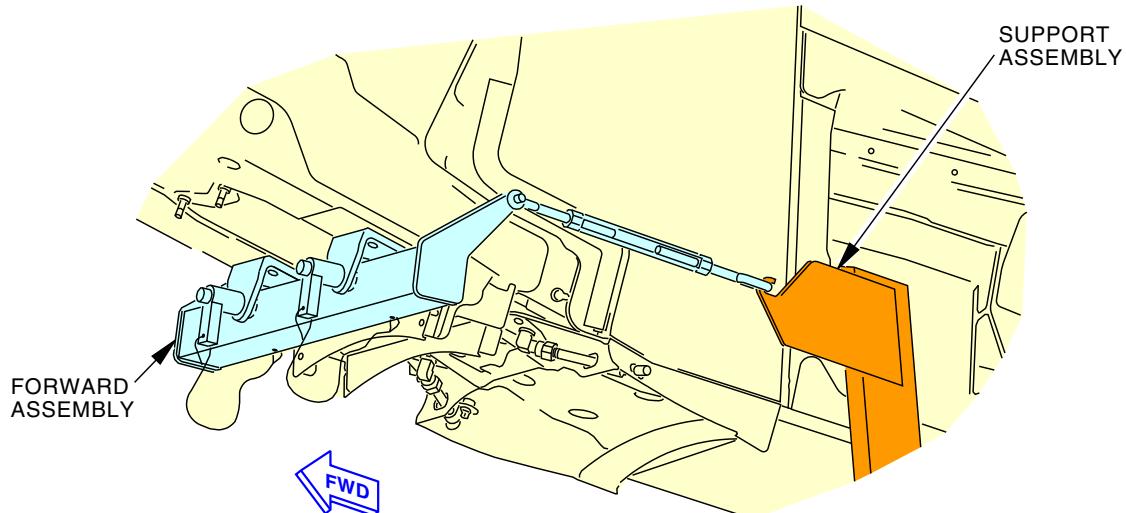
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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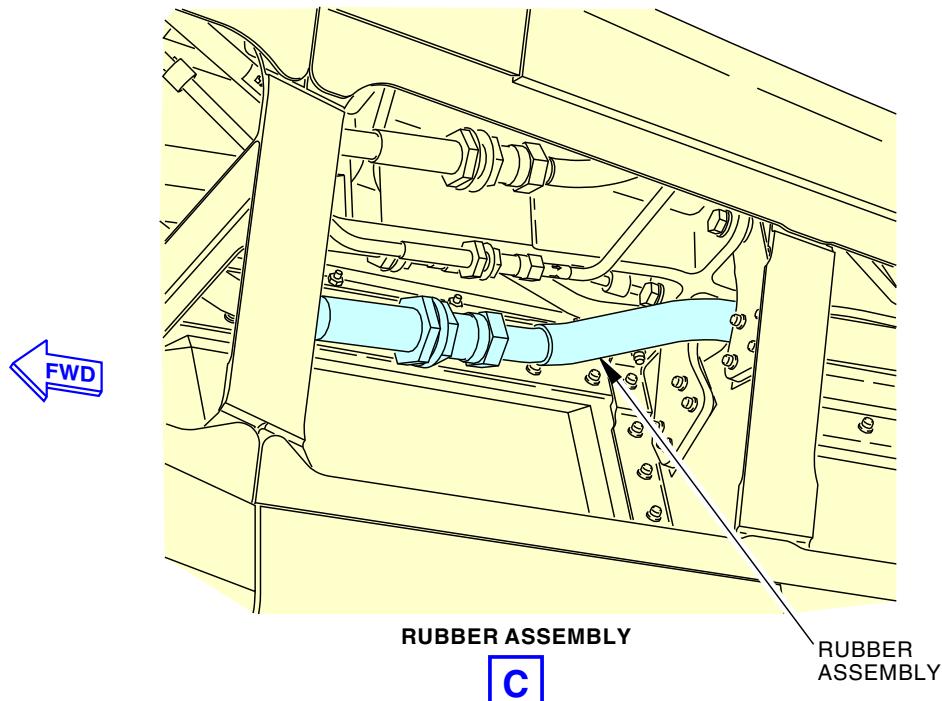
BOEING

**737-600/700/800/900
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FORWARD ASSEMBLY

B



RUBBER ASSEMBLY

C

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**Aft Fairing Installation Tool
Figure 401/54-52-04-990-801 (Sheet 4 of 4)**

EFFECTIVITY
LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
407, 411, 412, 415, 416, 420, 422-426 POST SB
737-54-1047 OR POST SB 737-78-1089

54-52-04

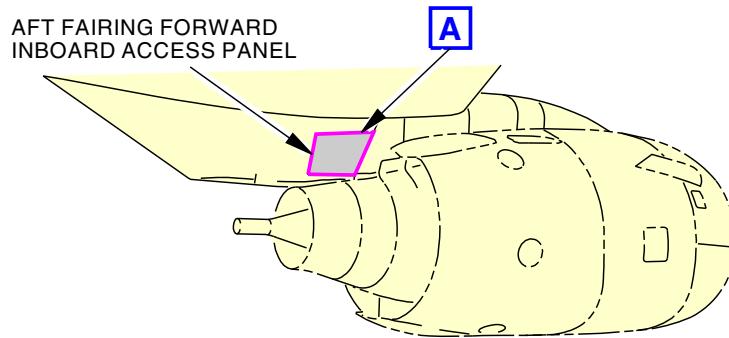
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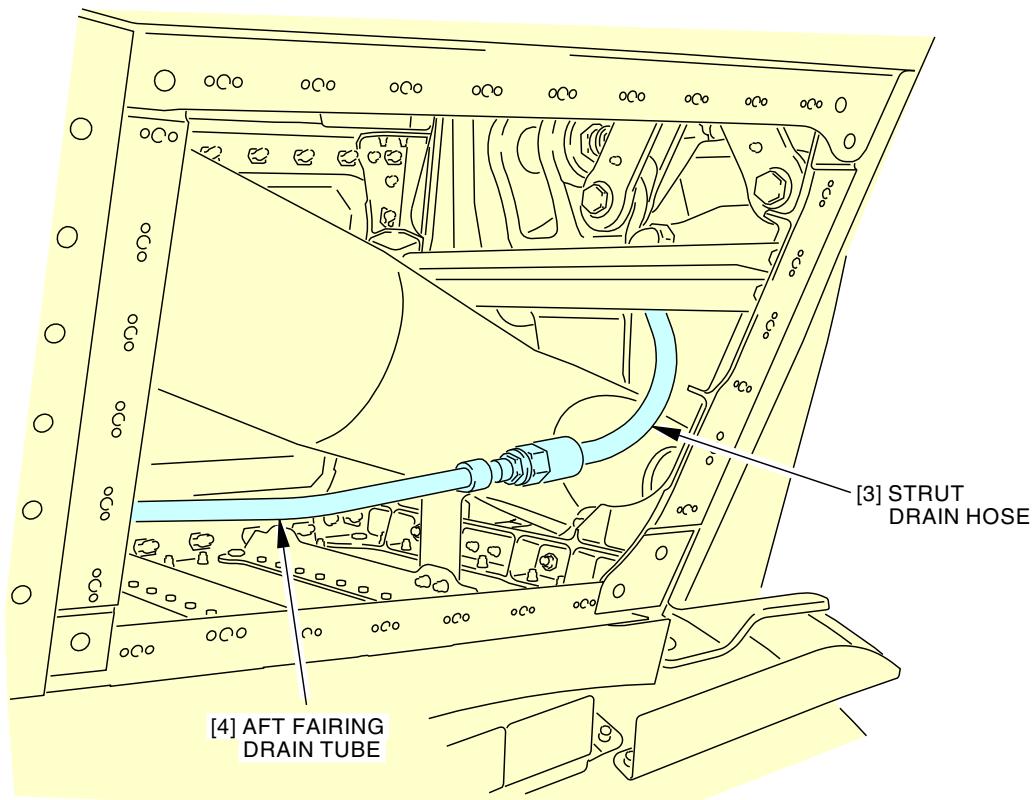
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AIRCRAFT MAINTENANCE MANUAL



LEFT STRUT
(RIGHT STRUT IS OPPOSITE)



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Aft Fairing Drain Tube Disconnect
Figure 402/54-52-04-990-802 (Sheet 1 of 2)

EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-78-1089

54-52-04

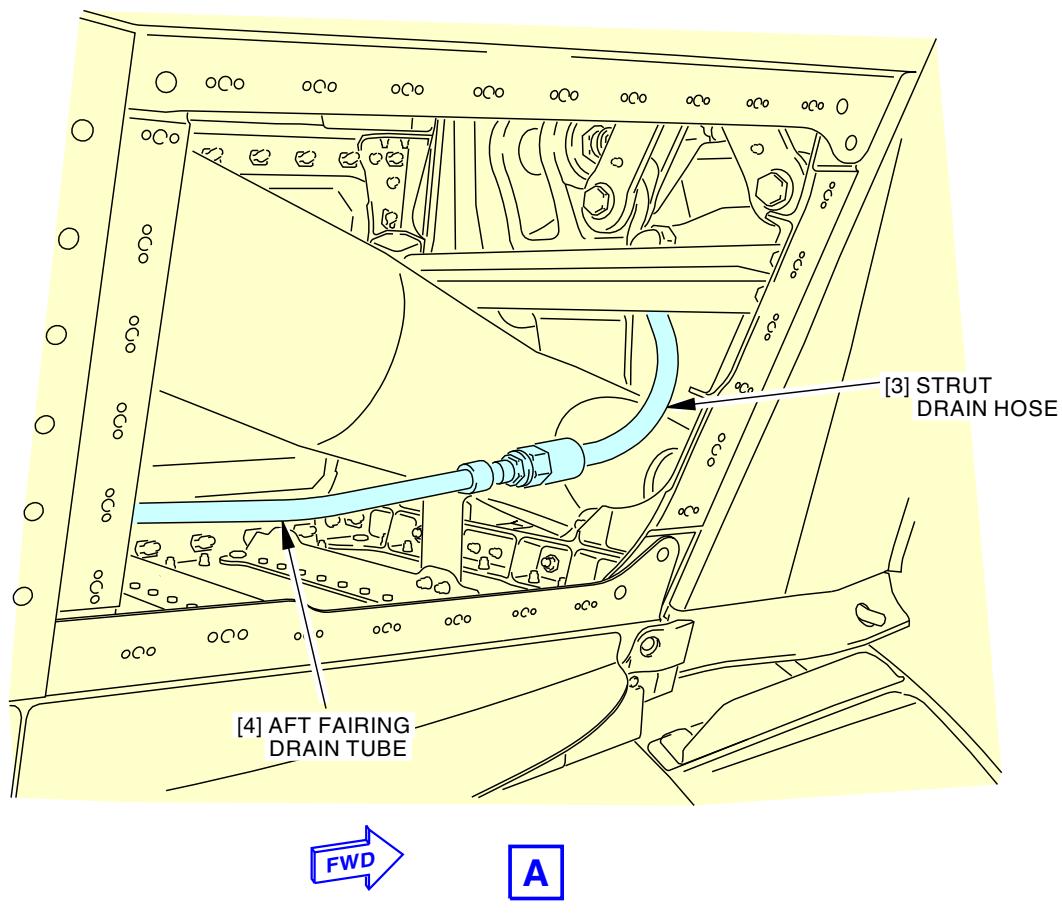
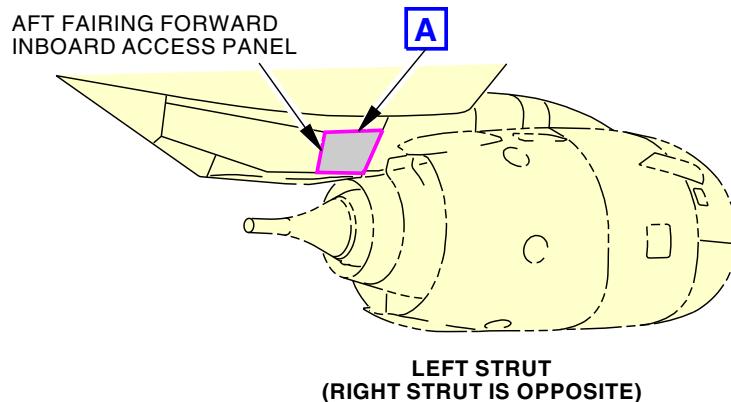
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AIRCRAFT MAINTENANCE MANUAL



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Aft Fairing Drain Tube Disconnect
Figure 402/54-52-04-990-802 (Sheet 2 of 2)

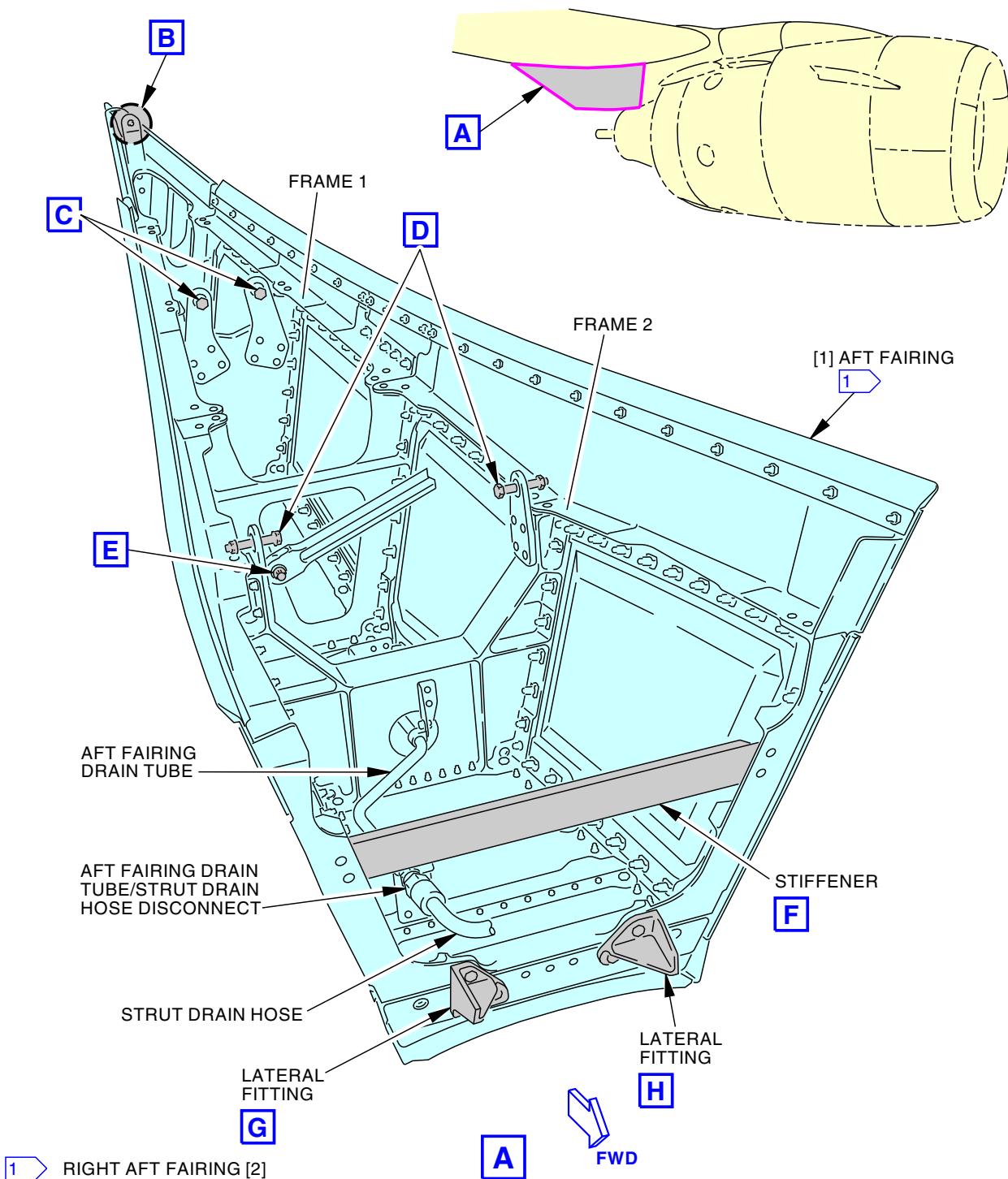
EFFECTIVITY
LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
407, 411, 412, 415, 416, 420, 422-426 POST SB
737-78-1089

54-52-04

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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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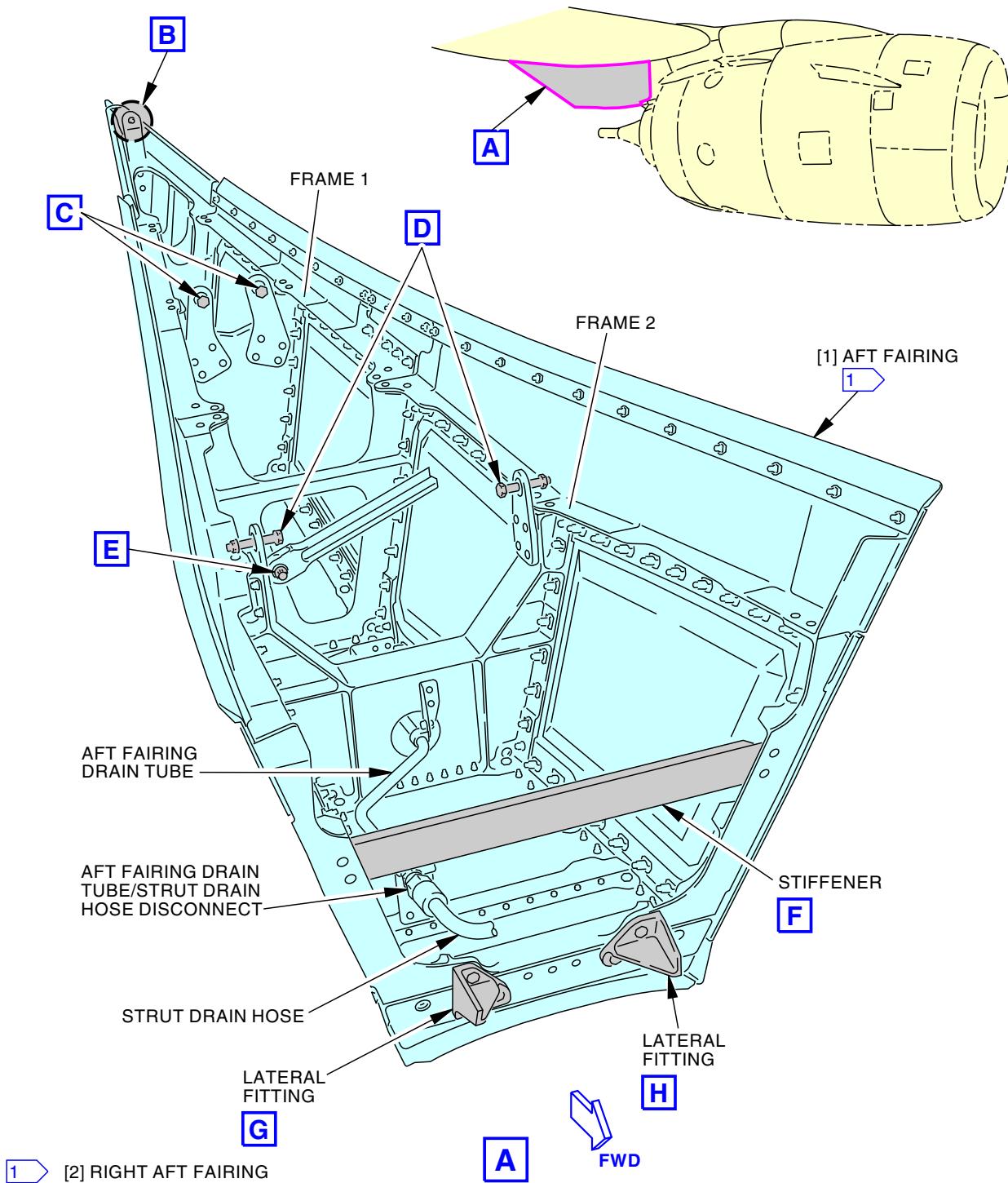
Aft Fairing Installation
Figure 403/54-52-04-990-803 (Sheet 1 of 4)

EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-78-1089

54-52-04

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details



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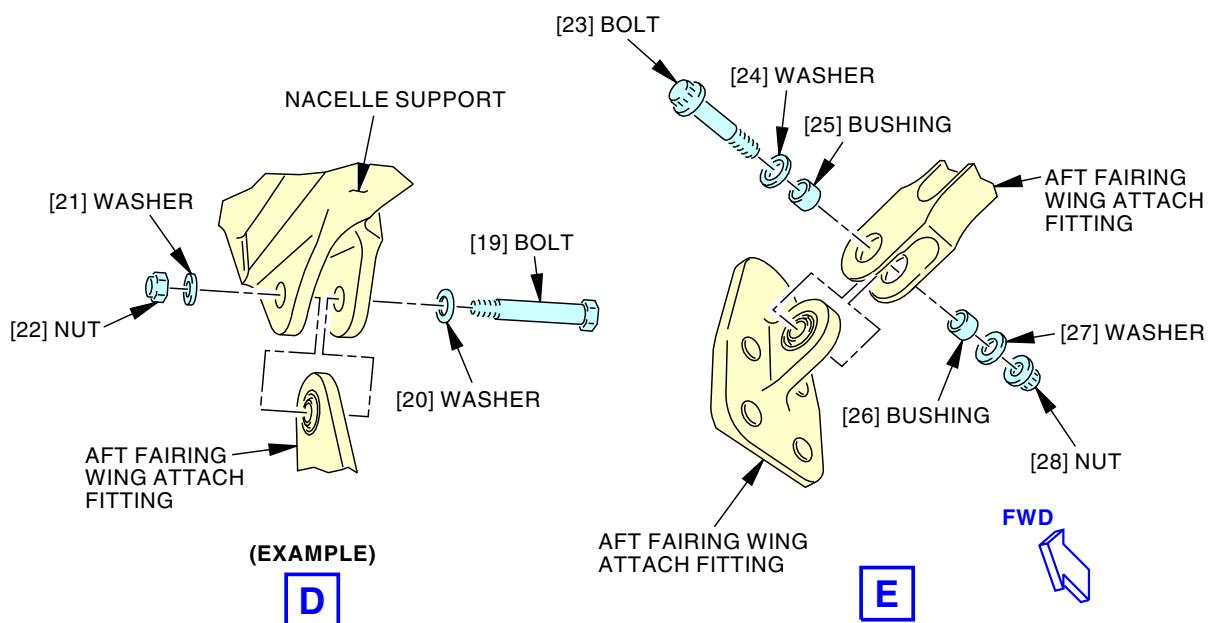
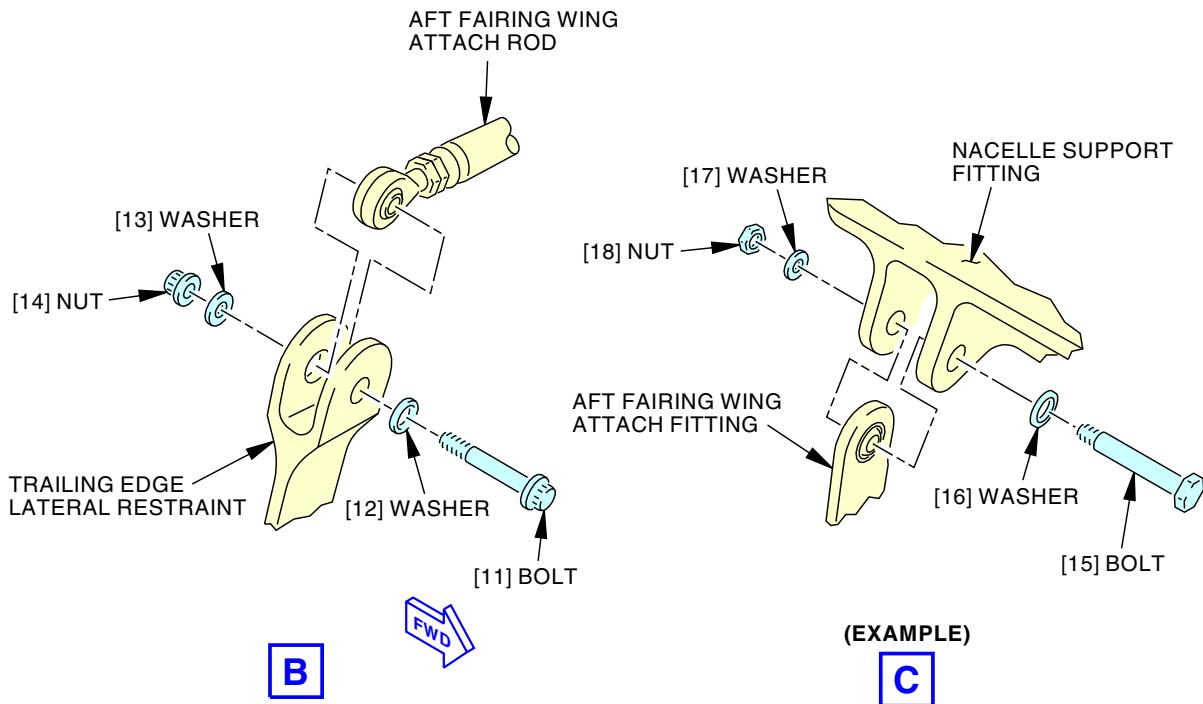
Aft Fairing Installation
Figure 403/54-52-04-990-803 (Sheet 2 of 4)

EFFECTIVITY
LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
407, 411, 412, 415, 416, 420, 422-426 POST SB
737-78-1089

54-52-04

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

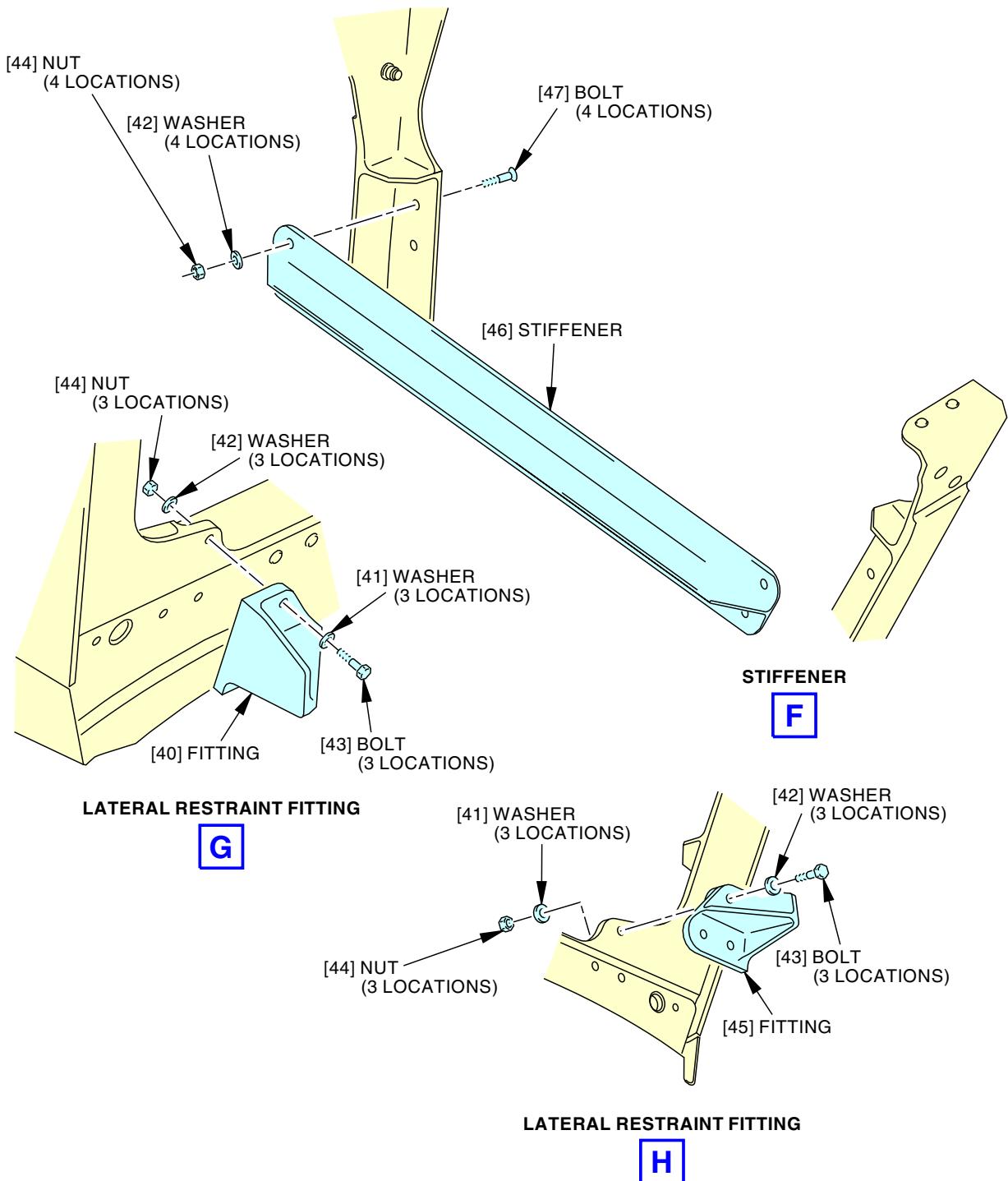


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Aft Fairing Installation
Figure 403/54-52-04-990-803 (Sheet 3 of 4)

EFFECTIVITY
LOM ALL

54-52-04



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Aft Fairing Installation
Figure 403/54-52-04-990-803 (Sheet 4 of 4)

EFFECTIVITY	LOM ALL
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54-52-04



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AIRCRAFT MAINTENANCE MANUAL

TASK 54-52-04-410-802

6. Aft Fairing Installation (Engine Not Removed)

Figure 404, Figure 405, Figure 406

A. References

Reference	Title
20-10-51-400-804	Flareless Tubing Assembly Installation (P/B 401)
27-51-00-440-801	Trailing Edge Flap System Reactivation (P/B 201)
54-51-01-440-801	Put the Strut Back to its Usual Condition (P/B 201)
54-52-06-410-801	Aft Fairing Access Panel Installation (P/B 401)
54-52-08-010-802	Aft Fairing Heatshield Installation (P/B 401)
78-11-01-400-802-F00	Primary Nozzle 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-1561	Jack - Hydraulic Part #: 930002 Supplier: FA2A9 Part #: J20009-110 Supplier: 81205 Opt Part #: J20009-108 Supplier: 81205 Opt Part #: J20009-109 Supplier: 81205
SPL-1584	Adapter Assembly - Telescoping Hydraulic Part #: J20009-136 Supplier: 81205 Opt Part #: J20009-68 Supplier: 81205
SPL-2019	Tool - Removal/Installation, Engine Strut Aft Fairing Part #: C54008-53 Supplier: 81205 Part #: C54008-54 Supplier: 81205 Opt Part #: C54008-1 Supplier: 81205 Opt Part #: C54008-28 Supplier: 81205
SPL-2430	Hoist ? Boom, 800 lbs WLL, 250 lbs Load Positioner Compatible Part #: C20002-267 Supplier: 81205 Part #: K20017-1 Supplier: 81205 Opt Part #: C78026-161 Supplier: 81205 Opt Part #: C78026-259 Supplier: 81205

C. Location Zones

Zone	Area
433	Engine 1 - Strut Torque Box
443	Engine 2 - Strut Torque Box

D. 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

EFFECTIVITY
LOM ALL

54-52-04



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E. Aft Fairing Installation

SUBTASK 54-52-04-420-002

- (1) Do these steps to structurally connect the forward end of the aft fairing to the strut (Figure 406):
 - (a) Put the forward assembly, on the underside of the strut, (Figure 404).
 - (b) Use the hydraulic jack, SPL-1561 with its telescoping hydraulic adapter assembly, SPL-1584 or the boom hoist, SPL-2430 to lift the aft fairing in its position under the wing.
 - (c) Attach the forward assembly to the aft fairing installation aft fairing tool, SPL-2019.
 - (d) Turn the turnbuckles on the forward assembly to apply a preload in the forward direction.
 - (e) Install the bolts [43], washers [41], washers [42], and nuts [44] to install the two lateral restraint fitting [40] and fitting [45].
 - (f) Install the bolts [47], washers [42], stiffener [46], and nuts [44].

SUBTASK 54-52-04-400-011

- (2) Do these steps to install the left aft fairing [1] or right aft fairing [2] under the wing, (Figure 406):
 - (a) At the trailing edge of the aft fairing, install the bolt [11], nut [14], washer [12], and washer [13].
 - (b) Install the bolt [15], washer [16], washer [17] and nut [18] at the wing attach fitting.
 - (c) Install the bolt [19], washer [21], washer [20] and nut [22] to the fittings on each side of the aft fairing.
 - (d) Install the bolt [23], washer [27], washer [24], bushing [26], bushing [25] and nut [28] to the fittings on each side of the aft fairing.

SUBTASK 54-52-04-080-003

- (3) Remove the aft fairing installation aft fairing tool, SPL-2019, the forward assembly, and the rubber assembly, (Figure 404).

SUBTASK 54-52-04-420-005

- (4) Do these steps to fasten the strut drain hose [3] to the aft fairing drain tube [4] (Figure 405):
 - (a) Connect the aft fairing drain tube hose to the coupling at the strut aft bulkhead.
 - (b) Tighten the end fitting on the strut drain hose [3], (TASK 20-10-51-400-804).

F. Put the Airplane Back to Its Usual Condition

LOM 427-434, 437-447, 450-999; LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 POST SB 737-54-1047 OR POST SB 737-78-1089

SUBTASK 54-52-04-410-006

- (1) Install the pan casting No. 1, (forward end) (TASK 54-52-08-010-802).

SUBTASK 54-52-04-420-008

- (2) Do this task: Primary Nozzle Assembly Installation, TASK 78-11-01-400-802-F00.

LOM ALL

SUBTASK 54-52-04-420-007

- (3) To install the applicable aft fairing access panel, do this task, Aft Fairing Access Panel Installation, TASK 54-52-06-410-801:

Close these access panels:

Number Name/Location

434AL Aft Strut Fairing, Left Forward Panel, Strut 1

EFFECTIVITY
LOM ALL

54-52-04

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(Continued)

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

SUBTASK 54-52-04-440-008

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

SUBTASK 54-52-04-440-009

- (5) Do this task: Put the Strut Back to its Usual Condition, TASK 54-51-01-440-801.

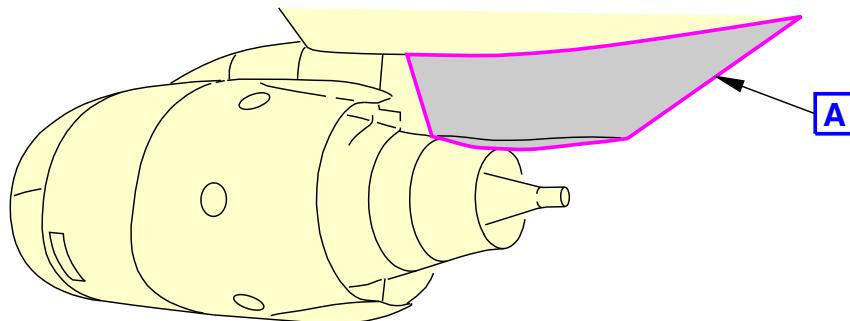
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EFFECTIVITY
LOM ALL

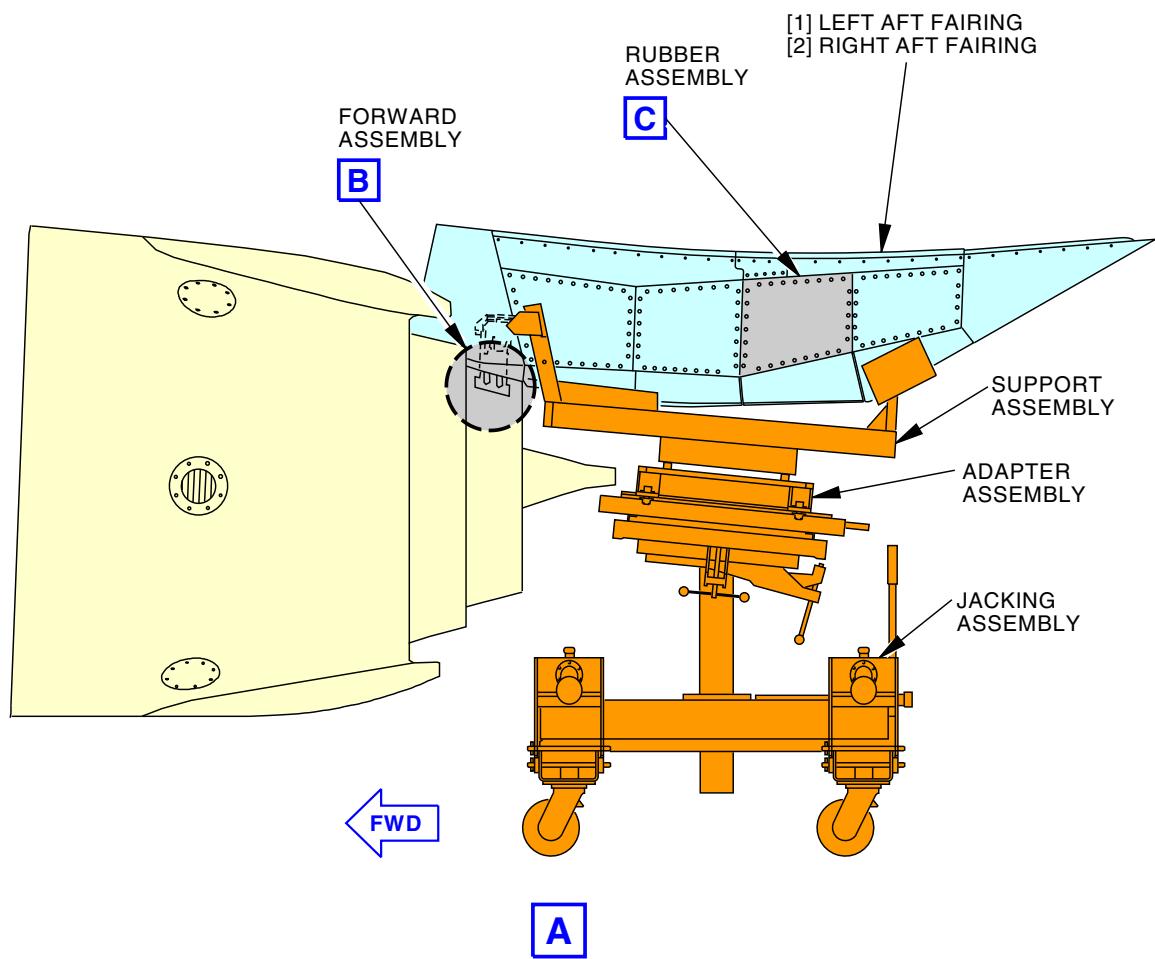
54-52-04



737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL



LEFT AFT FAIRING
(RIGHT AFT FAIRING IS OPPOSITE)



2532649 S0000599325_V1

Aft Fairing Installation Tool (Engine Not Removed)
Figure 404/54-52-04-990-808 (Sheet 1 of 4)

EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-78-1089

54-52-04

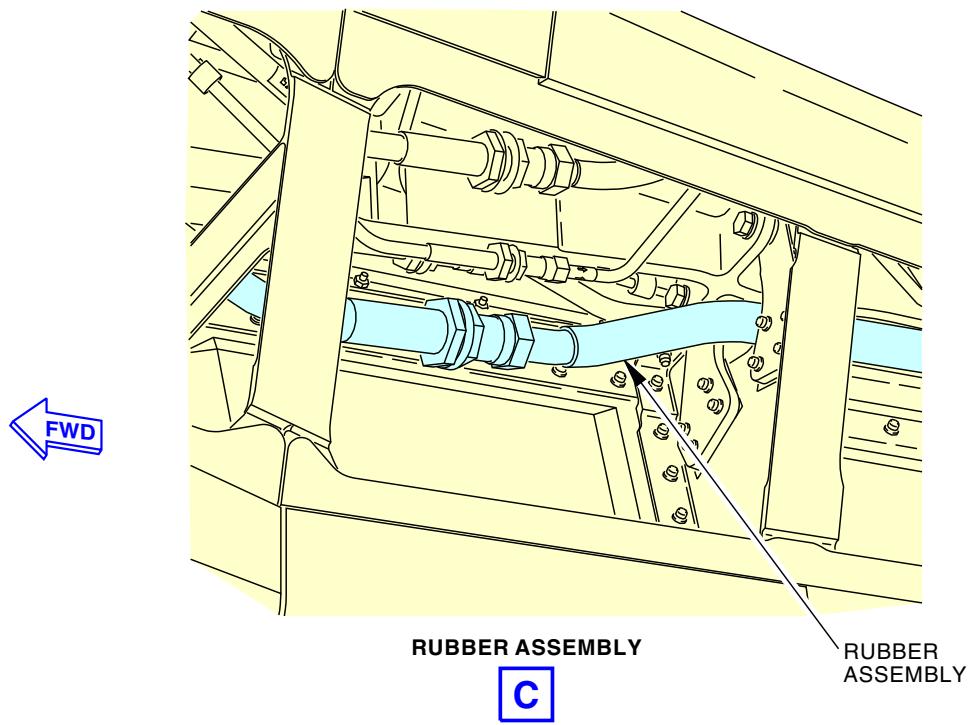
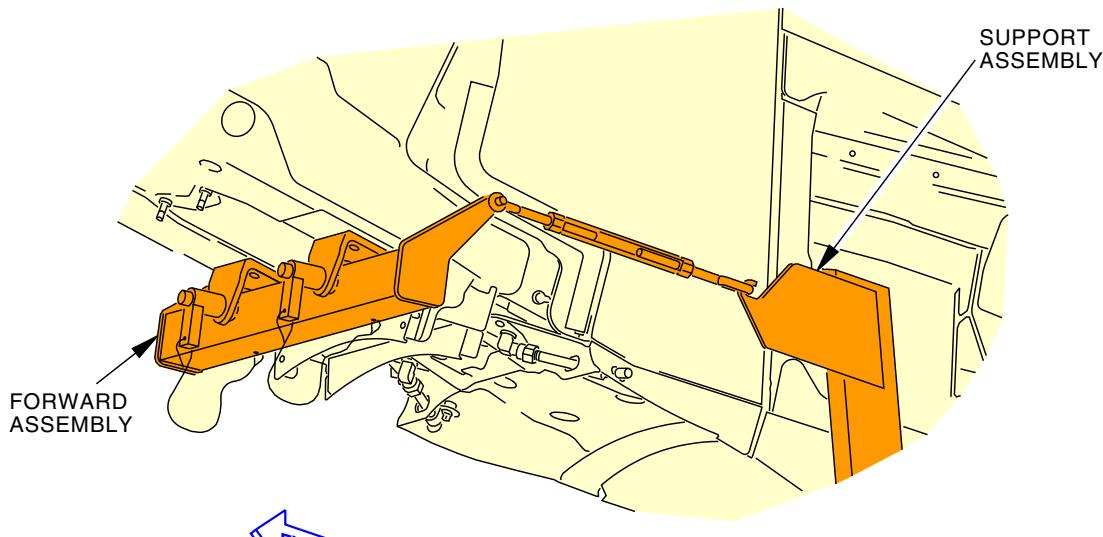
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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 BOEING

737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL



H32519 S0006581215_V2

Aft Fairing Installation Tool (Engine Not Removed)
Figure 404/54-52-04-990-808 (Sheet 2 of 4)

EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-78-1089

54-52-04

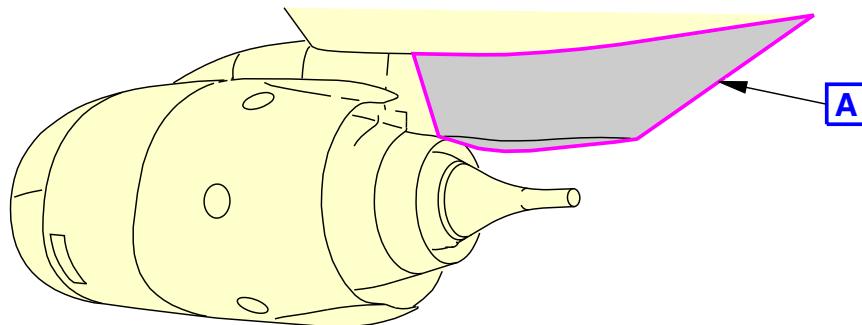
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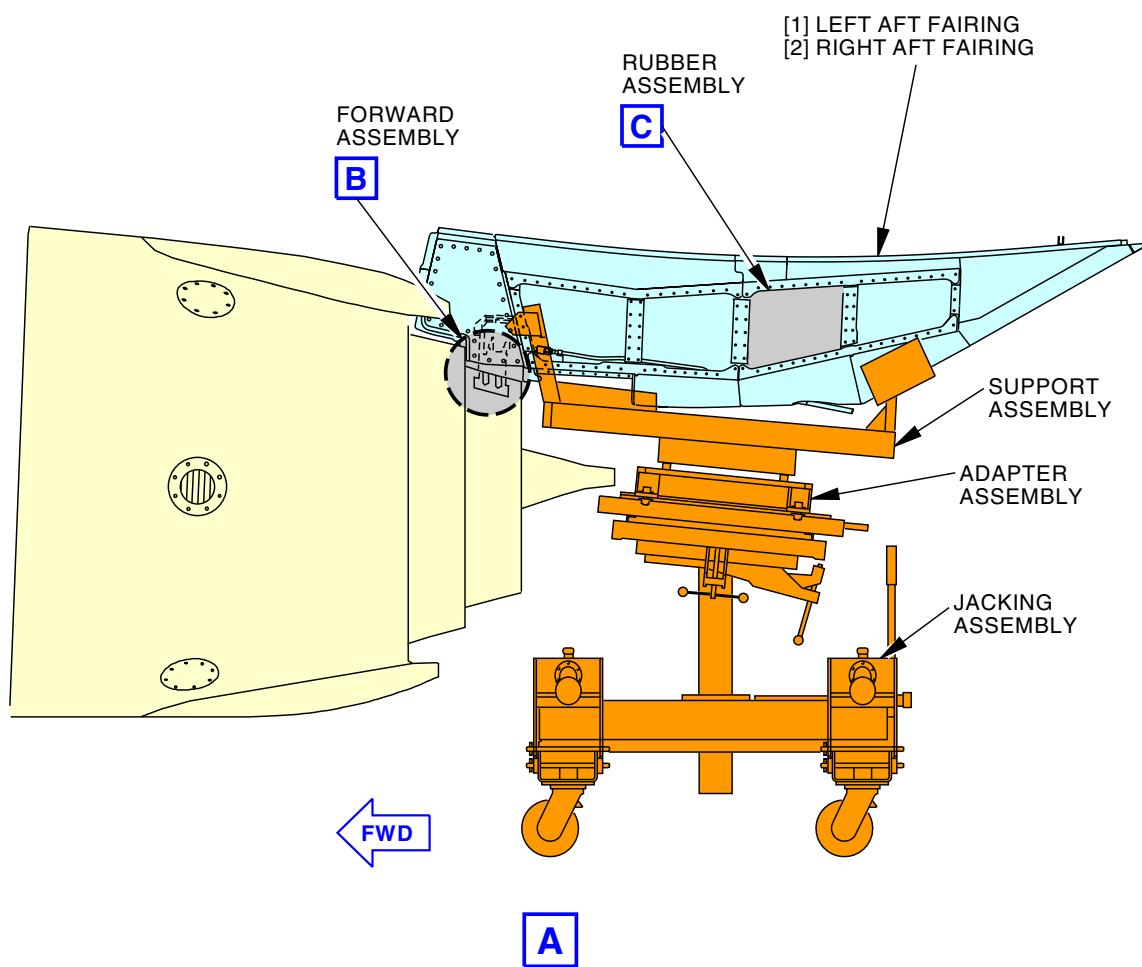
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AIRCRAFT MAINTENANCE MANUAL



LEFT AFT FAIRING
(RIGHT AFT FAIRING IS OPPOSITE)



2532652 S0000599370_V1

Aft Fairing Installation Tool (Engine Not Removed)
Figure 404/54-52-04-990-808 (Sheet 3 of 4)

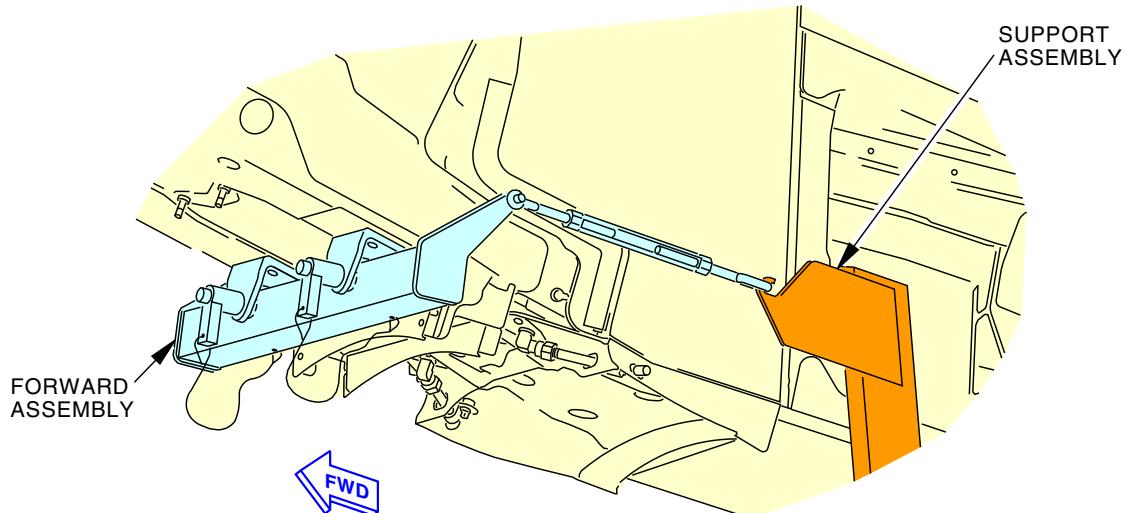
EFFECTIVITY
LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
407, 411, 412, 415, 416, 420, 422-426 POST SB
737-54-1047 OR POST SB 737-78-1089

54-52-04

D633A101-LOM

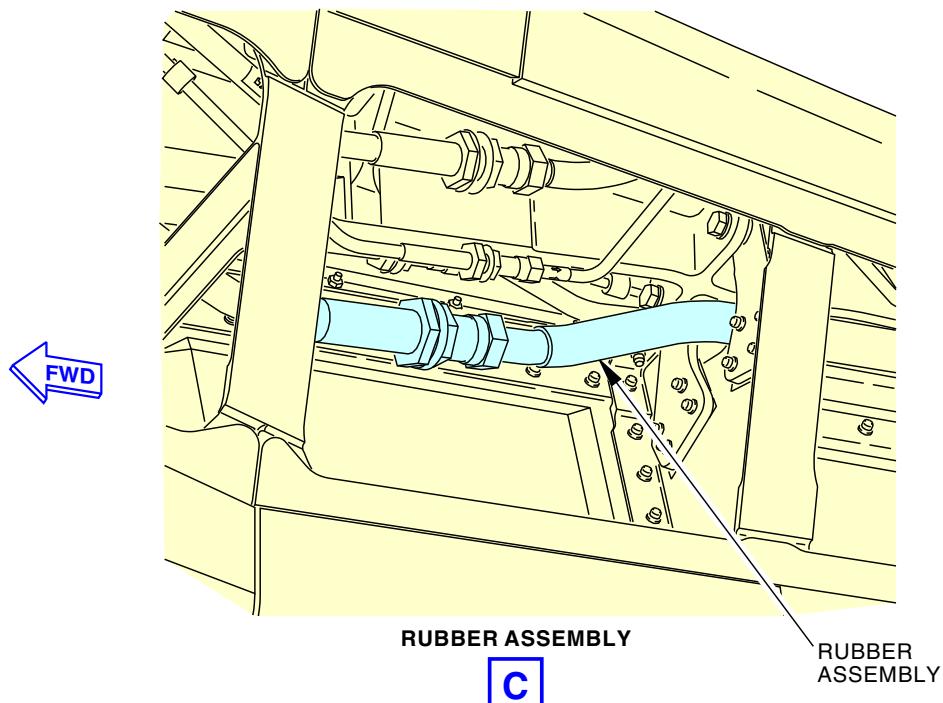
ECCN 9E991 BOEING PROPRIETARY - See title page for details

BOEING
737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL



FORWARD ASSEMBLY

B



RUBBER ASSEMBLY

C

2105682 S0000449310_V2

Aft Fairing Installation Tool (Engine Not Removed)
Figure 404/54-52-04-990-808 (Sheet 4 of 4)

EFFECTIVITY
 LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
 407, 411, 412, 415, 416, 420, 422-426 POST SB
 737-54-1047 OR POST SB 737-78-1089

54-52-04

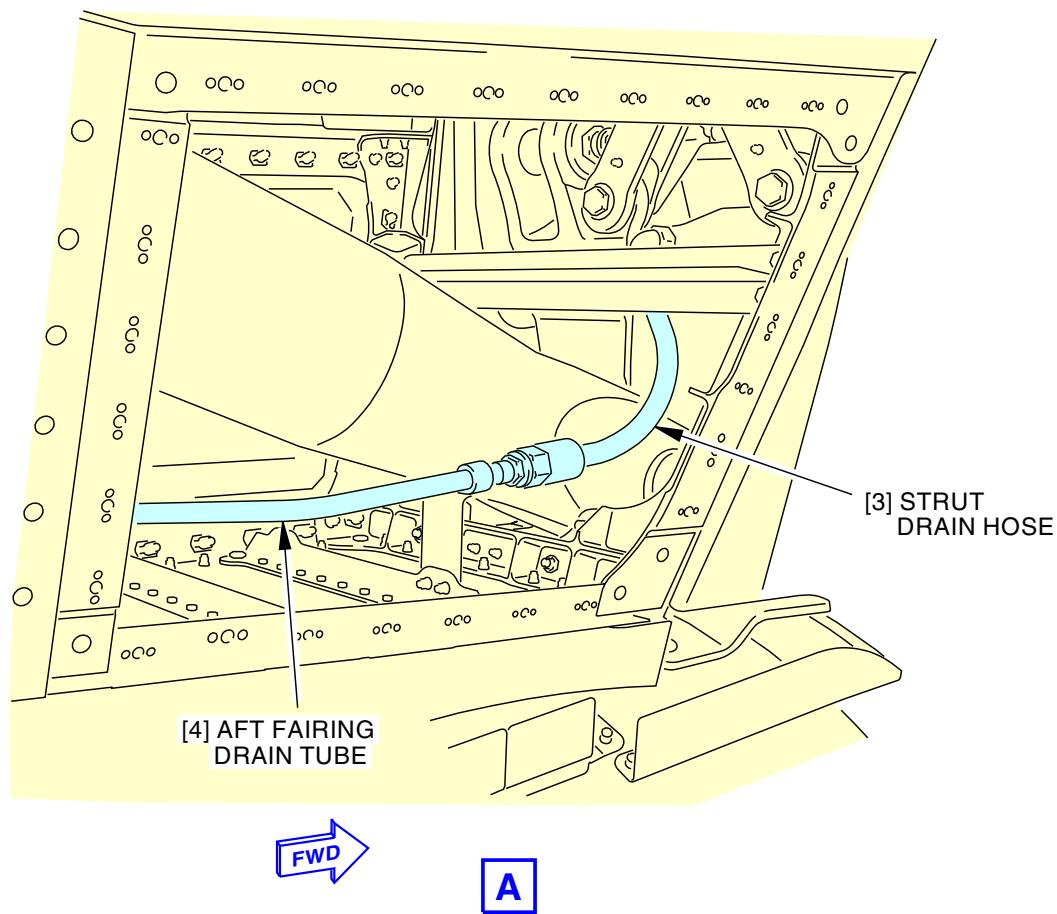
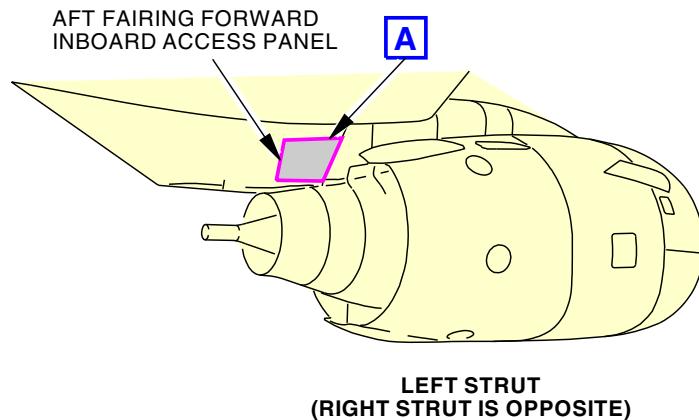
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AIRCRAFT MAINTENANCE MANUAL



2532655 S0000599380_V1

Aft Fairing Drain Tube Disconnect
Figure 405/54-52-04-990-809 (Sheet 1 of 2)

EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-78-1089

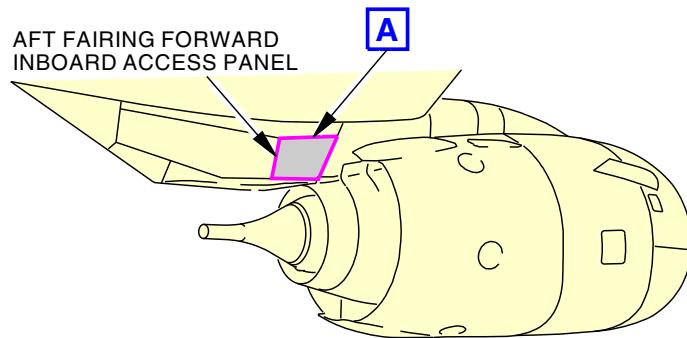
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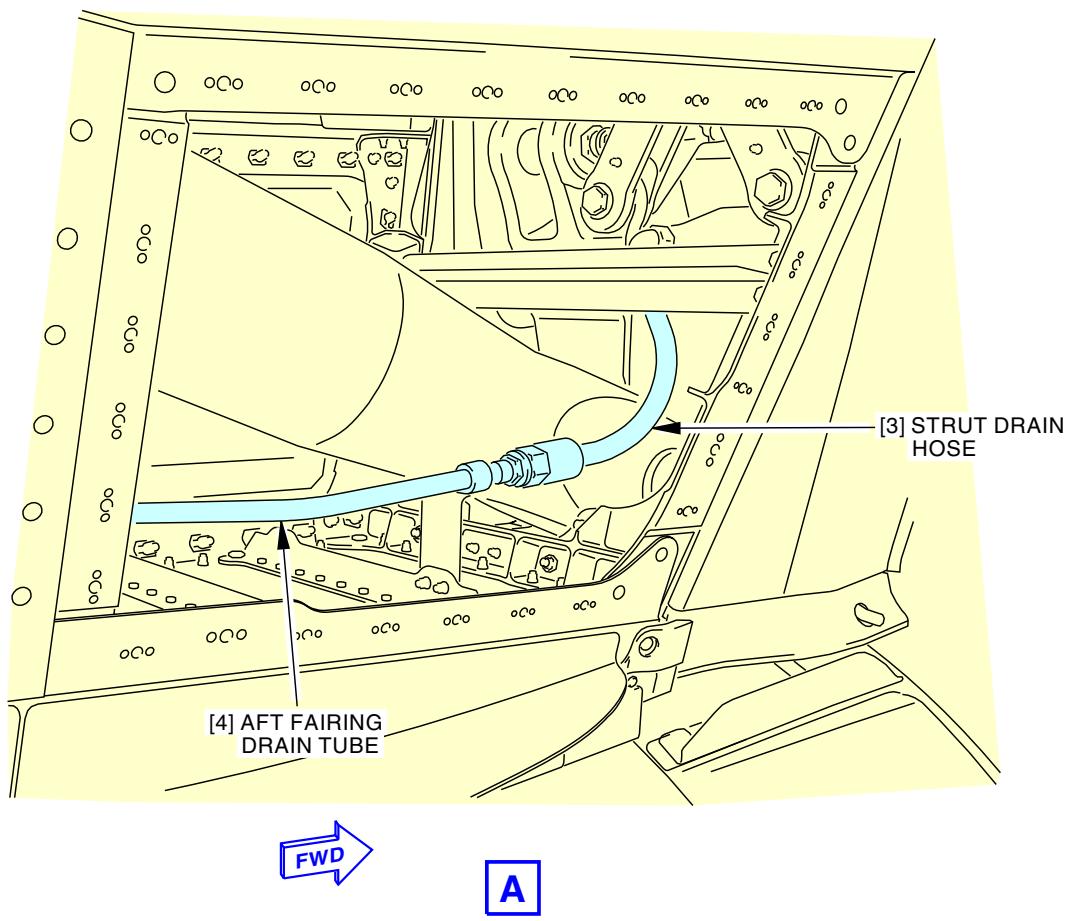
ECCN 9E991 BOEING PROPRIETARY - See title page for details

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BOEING
737-600/700/800/900
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**LEFT STRUT
(RIGHT STRUT IS OPPOSITE)**



2532656 S0000599381_V1

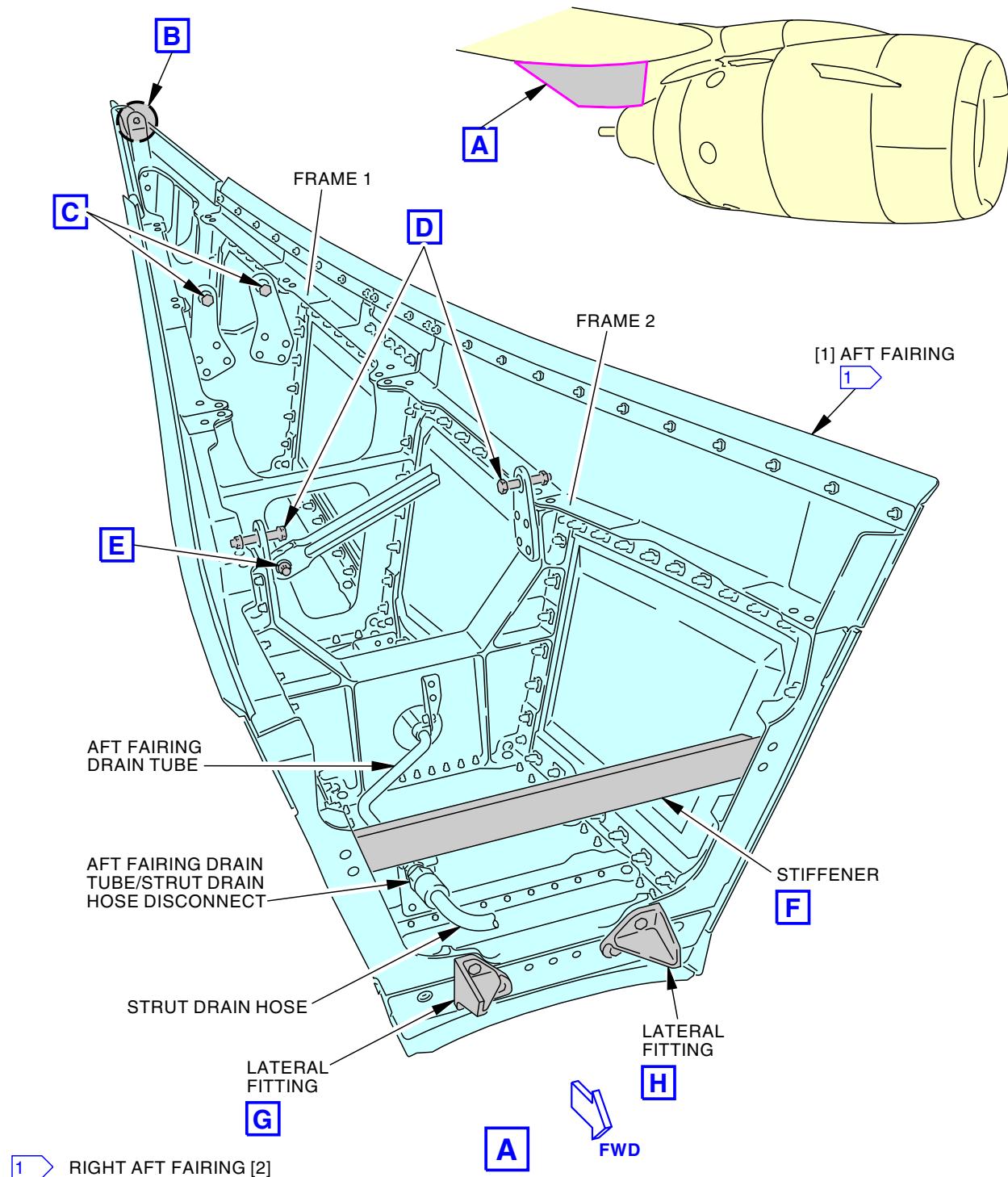
Aft Fairing Drain Tube Disconnect
Figure 405/54-52-04-990-809 (Sheet 2 of 2)

EFFECTIVITY
 LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
 407, 411, 412, 415, 416, 420, 422-426 POST SB
 737-54-1047 OR POST SB 737-78-1089

54-52-04

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ECCN 9E991 BOEING PROPRIETARY - See title page for details



2532643 S0000599382_V1

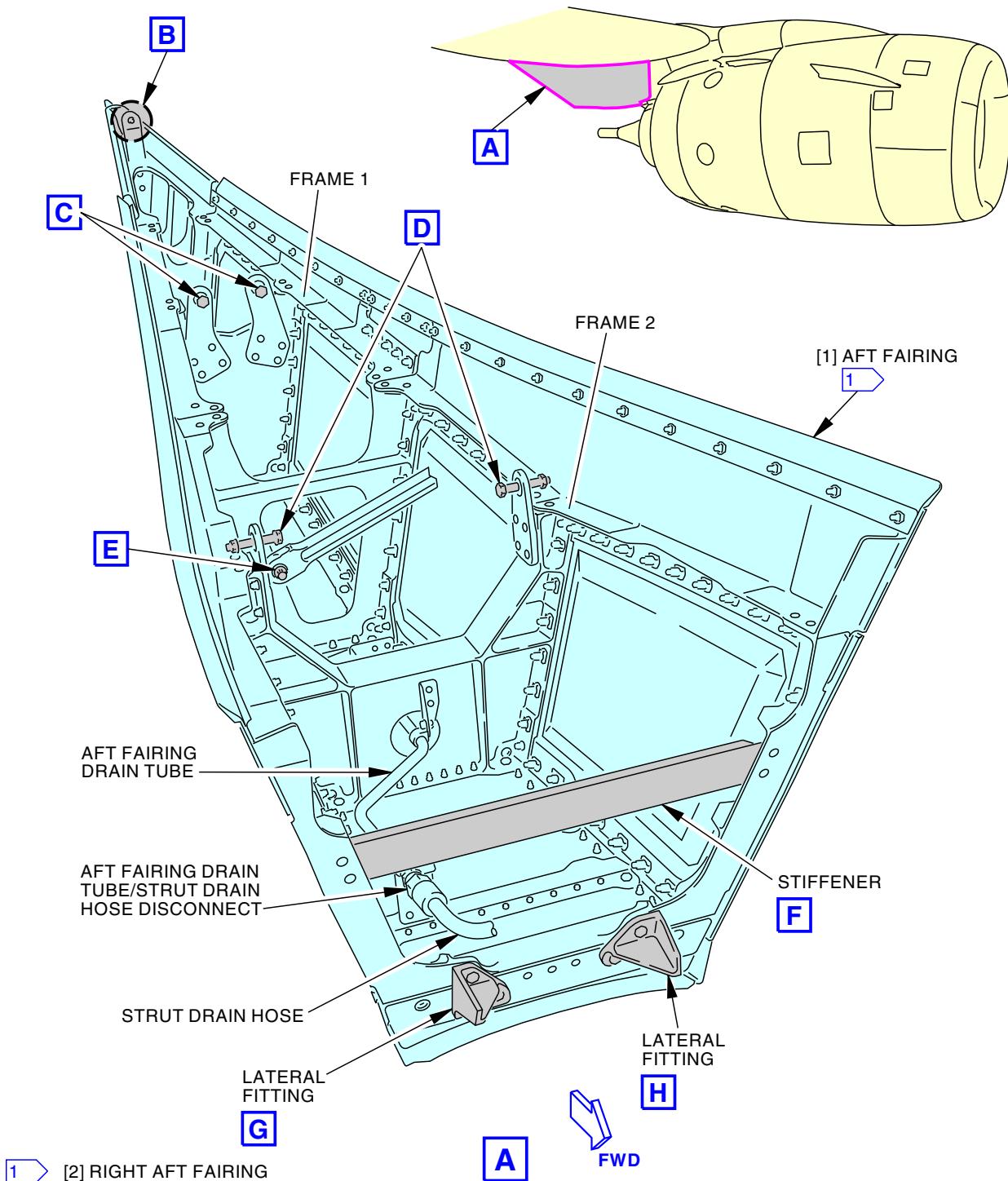
**Aft Fairing Installation
Figure 406/54-52-04-990-810 (Sheet 1 of 4)**

EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-78-1089

54-52-04

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details



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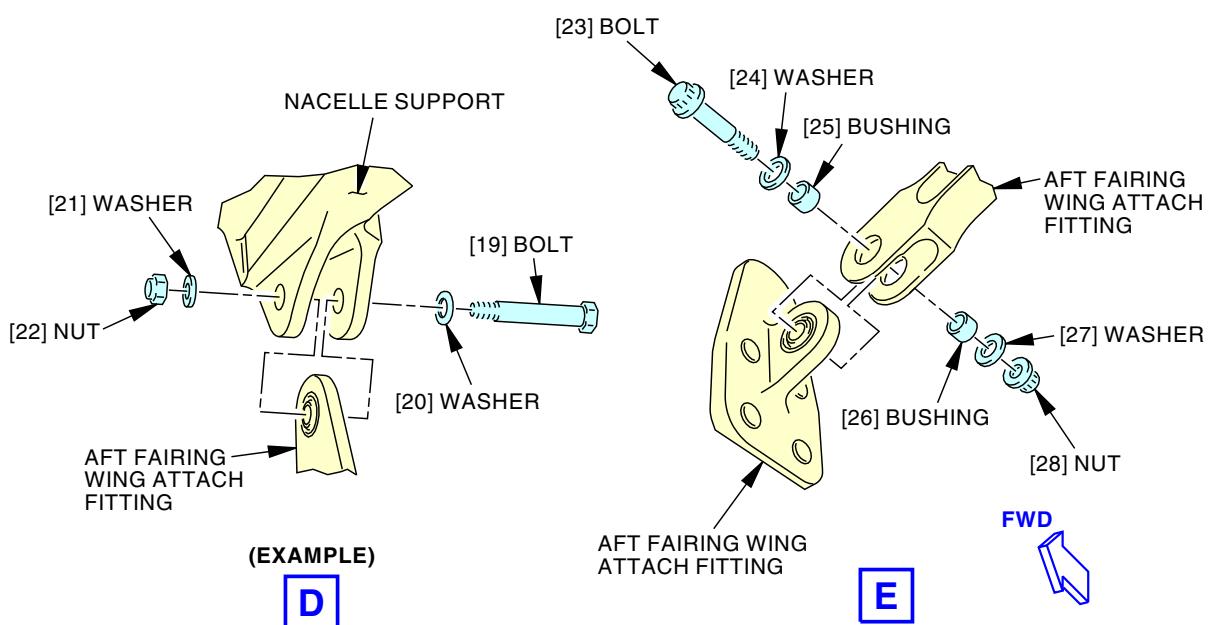
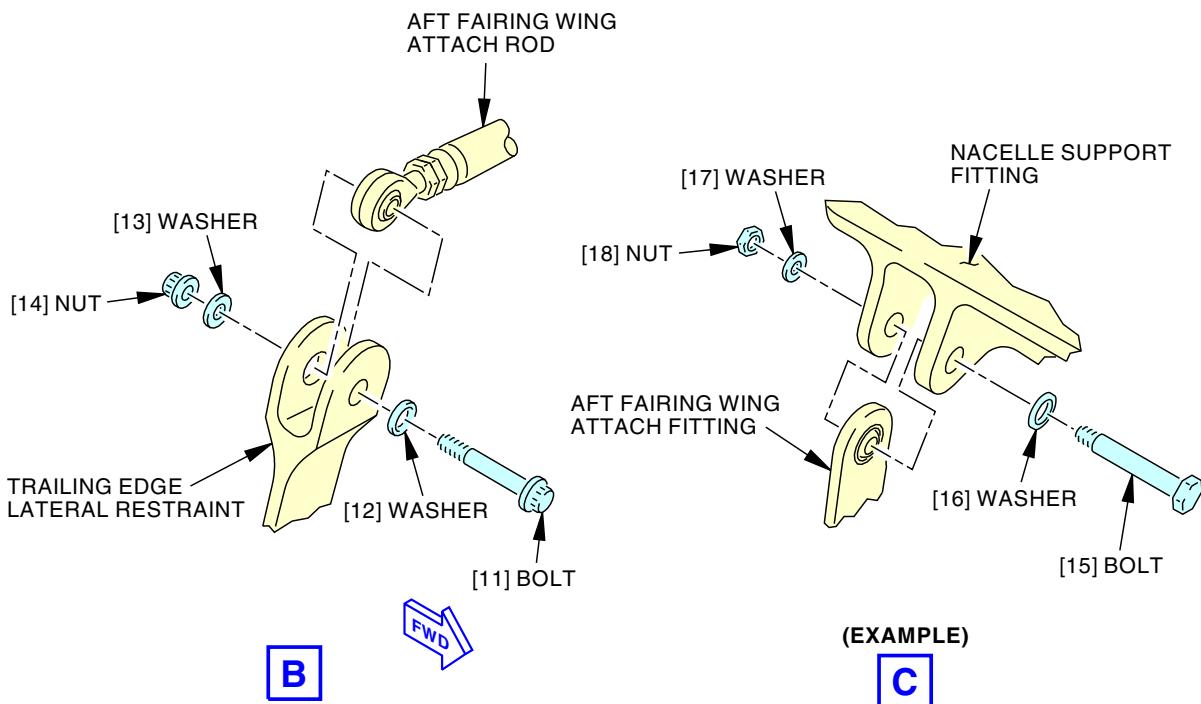
Aft Fairing Installation
Figure 406/54-52-04-990-810 (Sheet 2 of 4)

EFFECTIVITY
LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
407, 411, 412, 415, 416, 420, 422-426 POST SB
737-54-1047 OR POST SB 737-78-1089

54-52-04

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

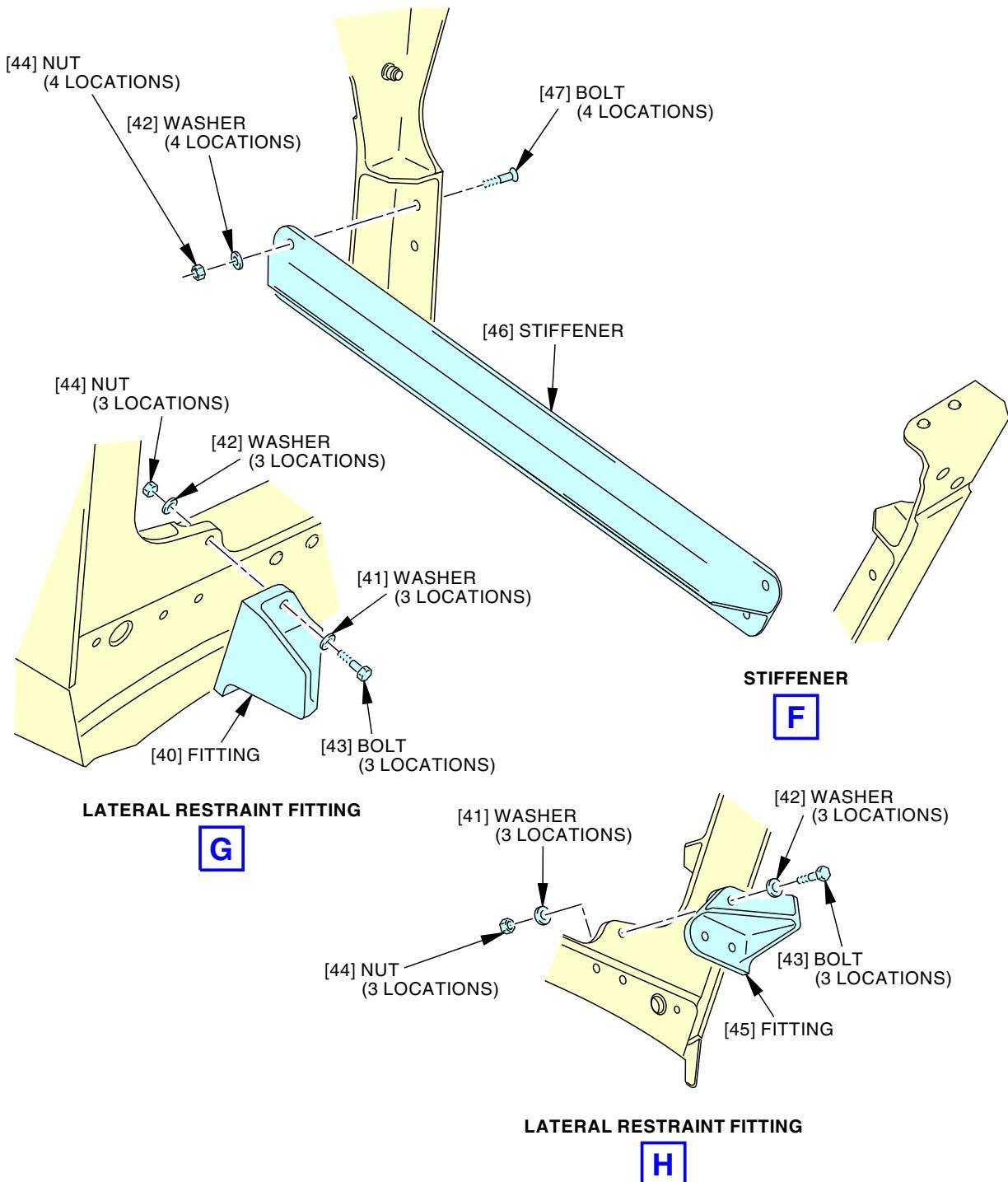


G37225 S0006581218_V2

Aft Fairing Installation
Figure 406/54-52-04-990-810 (Sheet 3 of 4)

EFFECTIVITY
 LOM ALL

54-52-04



G98708 S0006581219_V3

Aft Fairing Installation
Figure 406/54-52-04-990-810 (Sheet 4 of 4)

EFFECTIVITY	LOM ALL
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54-52-04



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AIRCRAFT MAINTENANCE MANUAL

TASK 54-52-04-400-801

7. Aft Fairing Installation (Without Primary Plug and Nozzle)

Figure 407Figure 408Figure 409

A. References

Reference	Title
20-10-51-400-804	Flareless Tubing Assembly Installation (P/B 401)
27-51-00-440-801	Trailing Edge Flap System Reactivation (P/B 201)
27-51-00-860-804	Retract the Trailing Edge Flaps (P/B 201)
54-51-01-440-801	Put the Strut Back to its Usual Condition (P/B 201)
54-52-06-410-801	Aft Fairing Access Panel Installation (P/B 401)
54-52-08-010-802	Aft Fairing Heatshield Installation (P/B 401)
78-11-01-400-801-F00	Primary Nozzle Assembly Installation (P/B 401)
78-11-01-400-802-F00	Primary Nozzle Assembly Installation (P/B 401)
78-11-02-400-801-F00	Primary Plug Assembly Installation (P/B 401)
78-11-02-400-802-F00	Primary Plug 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-1561	Jack - Hydraulic Part #: 930002 Supplier: FA2A9 Part #: J20009-110 Supplier: 81205 Opt Part #: J20009-108 Supplier: 81205 Opt Part #: J20009-109 Supplier: 81205
SPL-1584	Adapter Assembly - Telescoping Hydraulic Part #: J20009-136 Supplier: 81205 Opt Part #: J20009-68 Supplier: 81205
SPL-2019	Tool - Removal/Installation, Engine Strut Aft Fairing Part #: C54008-53 Supplier: 81205 Part #: C54008-54 Supplier: 81205 Opt Part #: C54008-1 Supplier: 81205 Opt Part #: C54008-28 Supplier: 81205

C. Location Zones

Zone	Area
433	Engine 1 - Strut Torque Box
443	Engine 2 - Strut Torque Box

D. 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

EFFECTIVITY
LOM ALL

54-52-04



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E. Aft Fairing Installation

SUBTASK 54-52-04-400-002

- (1) Do these steps to structurally connect the forward end of the aft fairing to the strut, Figure 409:
 - (a) Put the forward assembly, on the underside of the strut, (Figure 407).
 - (b) Use the hydraulic jack, SPL-1561 with its telescoping hydraulic adapter assembly, SPL-1584 or the ground based boom hoist, C78026 to lift the aft fairing in its position under the wing.
 - (c) Attach the forward assembly to the aft fairing installation aft fairing tool, SPL-2019.
 - (d) Turn the turnbuckles on the forward assembly to apply a preload in the forward direction.
 - (e) Install the bolts [43], washers [41], washers [42], and nuts [44] to install the two lateral restraint fitting [40] and fitting [45].
 - (f) Install the bolts [47], washers [42], stiffener [46], and nuts [44].

SUBTASK 54-52-04-400-003



CAUTION

MAKE SURE THAT THE SPAR VALVE CABLE IS LOCATED ABOVE THE AFT FAIRING WING ATTACH-FITTING. IF YOU DO NOT OBEY THIS INSTRUCTION, DAMAGE TO THE SPAR VALVE CABLE CAN OCCUR.

- (2) Do these steps to install the left aft fairing [1] or right aft fairing [2] under the wing, Figure 409:
 - (a) At the trailing edge of the aft fairing, install the bolt [11], nut [14], washer [12], and the washer [13].
 - (b) Install the bolt [15], washer [16], washer [17] and nut [18] at the wing attach fitting.
 - (c) Install the bolt [19], washer [21], washer [20] and nut [22] to the fittings on each side of the aft fairing.
 - (d) Install the bolt [23], washer [27], washer [24], bushing [26], bushing [25] and nut [28] to the fittings on each side of the aft fairing.

SUBTASK 54-52-04-400-004

- (3) Remove the aft fairing installation aft fairing tool, SPL-2019, the forward assembly, and the rubber assembly, Figure 407.

SUBTASK 54-52-04-400-005

- (4) Do these steps to fasten the strut drain hose [3] to the aft fairing drain tube [4], Figure 408:
 - (a) Connect the aft fairing drain tube hose to the coupling at the strut aft bulkhead.
 - (b) Tighten the end fitting on the strut drain hose [3], (TASK 20-10-51-400-804).

F. Put the Airplane Back to Its Usual Condition

LOM 427-434, 437-447, 450-999; LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 POST SB 737-54-1047 OR POST SB 737-78-1089

SUBTASK 54-52-04-410-005

- (1) Install the pan casting No. 1, (forward end) (TASK 54-52-08-010-802).

LOM ALL

SUBTASK 54-52-04-400-006

- (2) To install the applicable aft fairing access panel, do this task Aft Fairing Access Panel Installation, TASK 54-52-06-410-801:

EFFECTIVITY
LOM ALL

54-52-04



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Close these access panels:

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

SUBTASK 54-52-04-400-007

- (3) Do this task: Primary Nozzle Assembly Installation, TASK 78-11-01-400-802-F00 or Primary Nozzle Assembly Installation, TASK 78-11-01-400-801-F00.

SUBTASK 54-52-04-400-008

- (4) Do this task: Primary Plug Assembly Installation, TASK 78-11-02-400-802-F00 or Primary Plug Assembly Installation, TASK 78-11-02-400-801-F00.

SUBTASK 54-52-04-440-005

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

SUBTASK 54-52-04-440-007

- (6) Do this task: Retract the Trailing Edge Flaps, TASK 27-51-00-860-804.

SUBTASK 54-52-04-440-006

- (7) Do this task: Put the Strut Back to its Usual Condition, TASK 54-51-01-440-801.

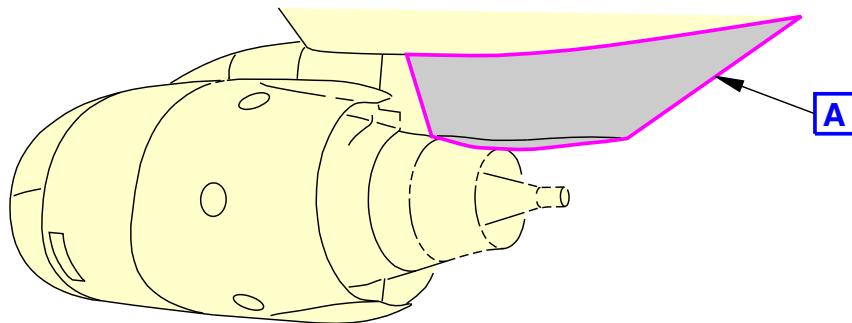
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EFFECTIVITY
LOM ALL

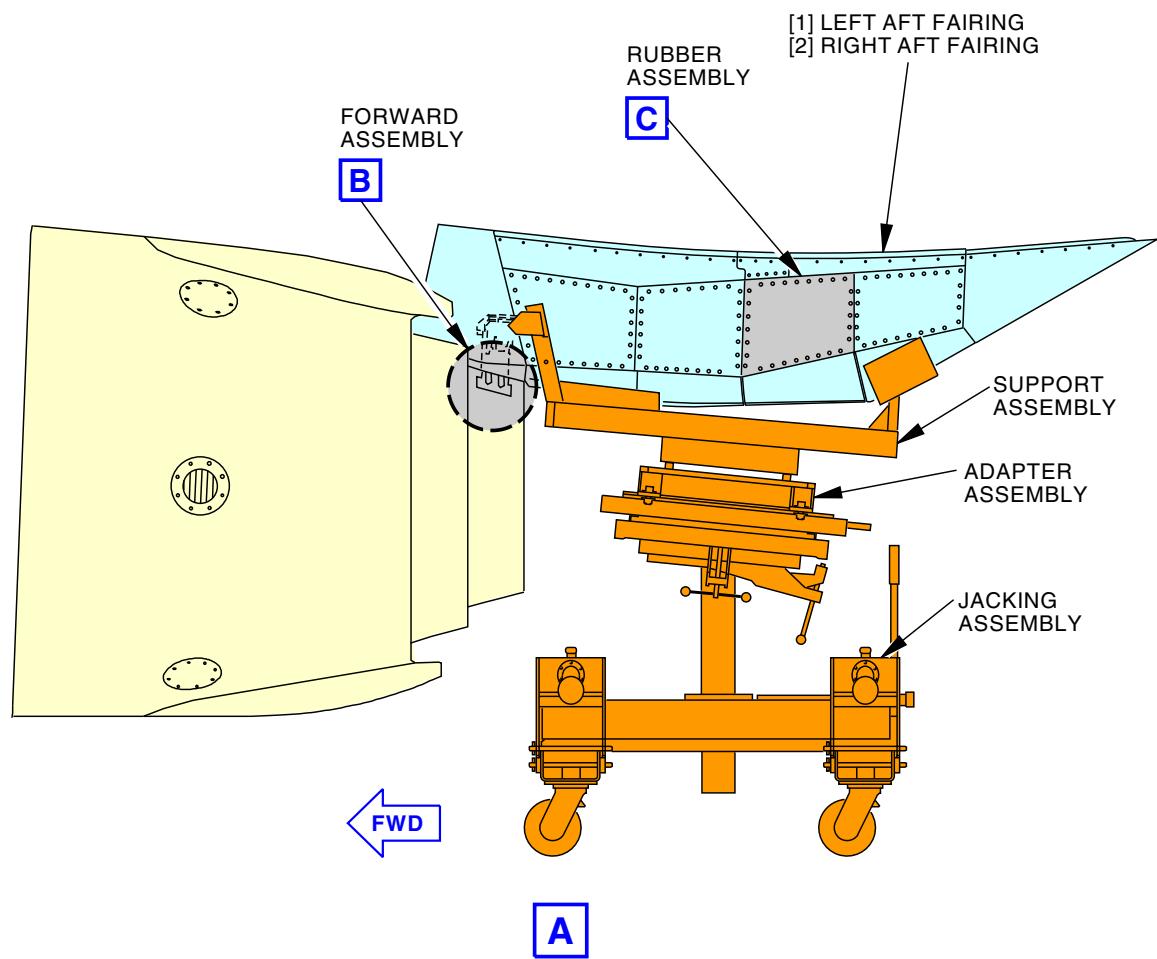
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AIRCRAFT MAINTENANCE MANUAL



LEFT AFT FAIRING
(RIGHT AFT FAIRING IS OPPOSITE)



1308422 S0000227244_V5

Aft Fairing Installation Tool (Without Primary Plug and Nozzle)
Figure 407/54-52-04-990-804 (Sheet 1 of 4)

EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-78-1089

54-52-04

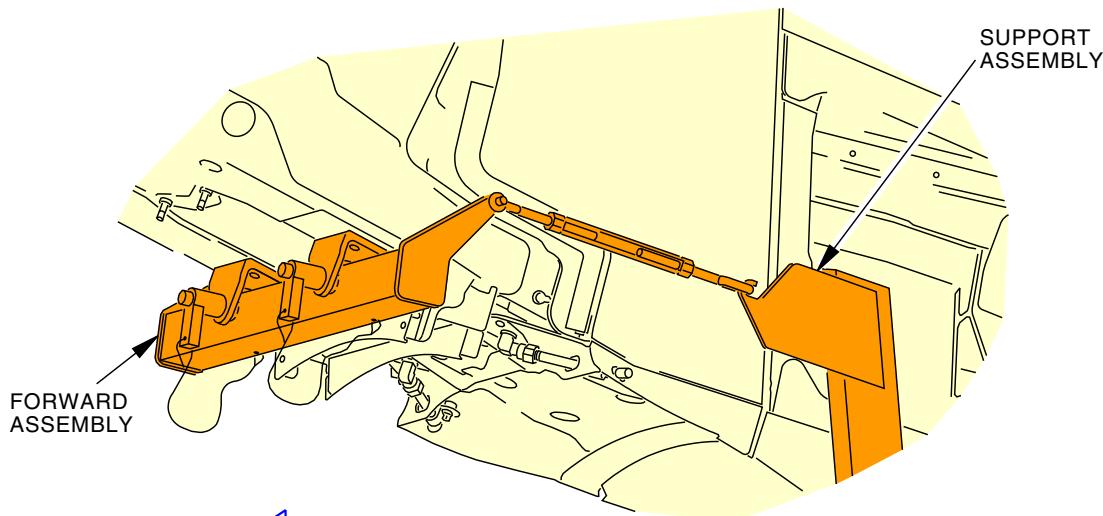
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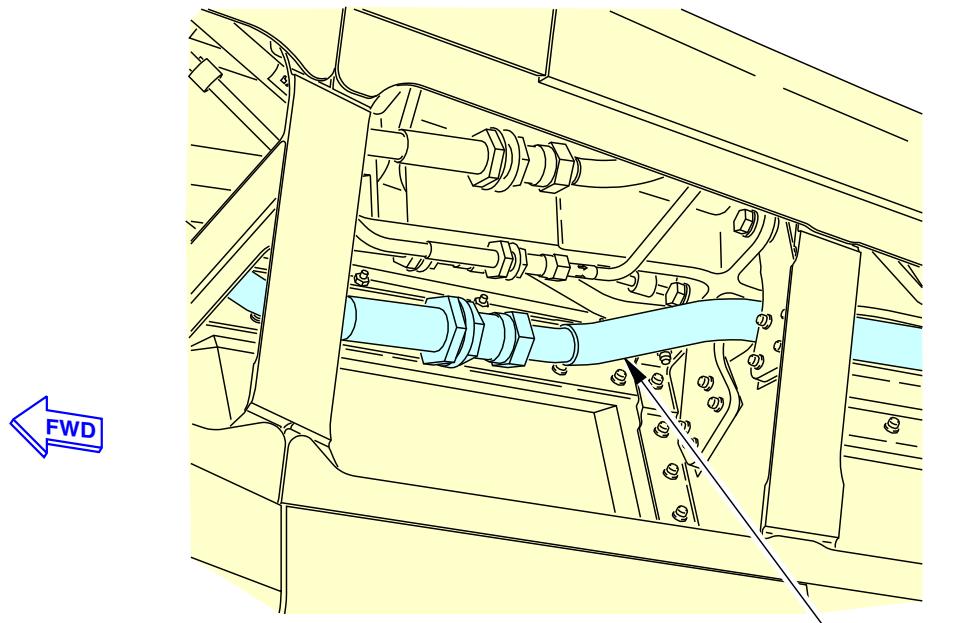
BOEING

**737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL**



FORWARD ASSEMBLY

B



RUBBER ASSEMBLY

C

H32519 S0006581215_V2

**Aft Fairing Installation Tool (Without Primary Plug and Nozzle)
Figure 407/54-52-04-990-804 (Sheet 2 of 4)**

EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-78-1089

54-52-04

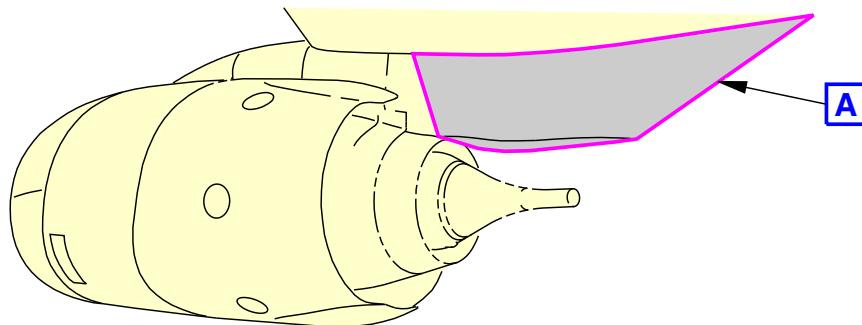
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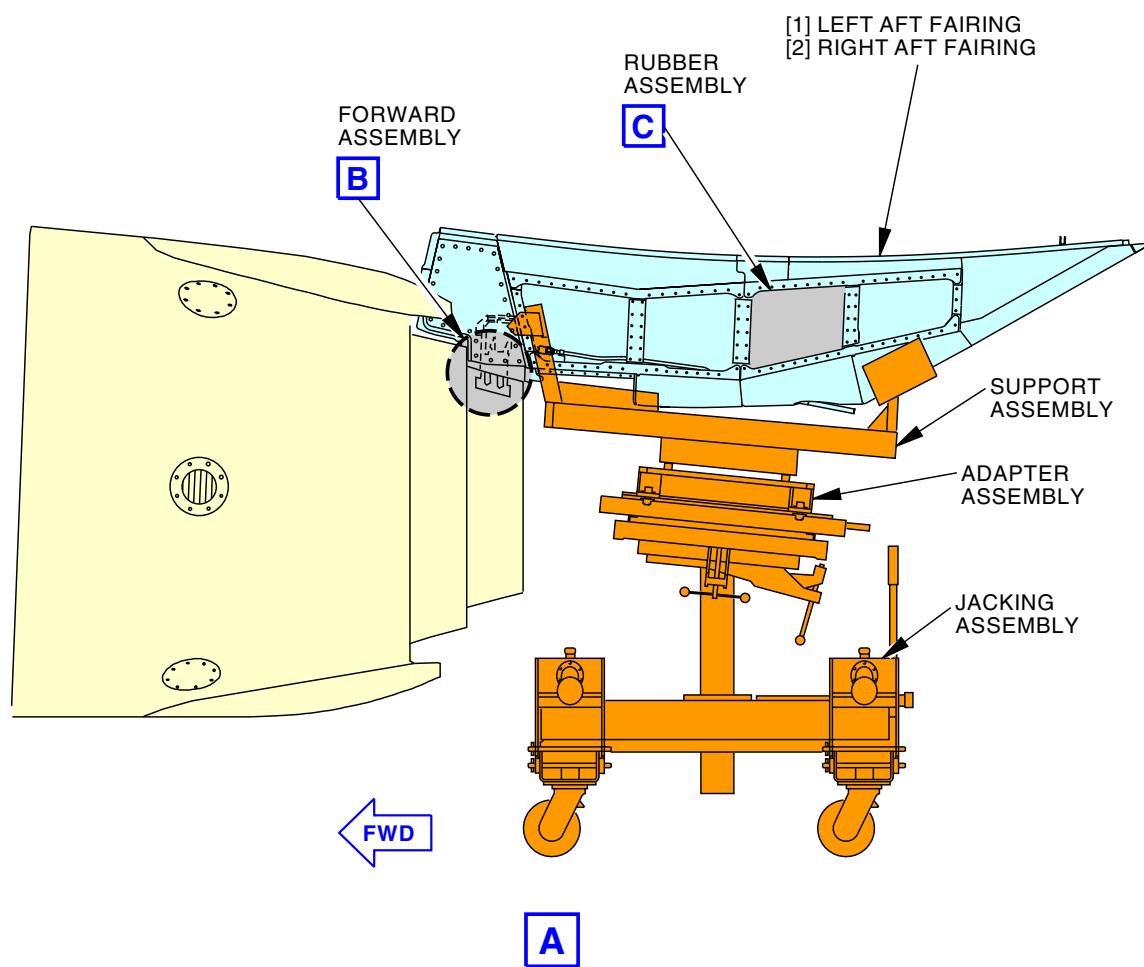
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737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL



LEFT AFT FAIRING
(RIGHT AFT FAIRING IS OPPOSITE)



2097778 S0000443008_V3

Aft Fairing Installation Tool (Without Primary Plug and Nozzle)
Figure 407/54-52-04-990-804 (Sheet 3 of 4)

EFFECTIVITY
LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
407, 411, 412, 415, 416, 420, 422-426 POST SB
737-54-1047 OR POST SB 737-78-1089

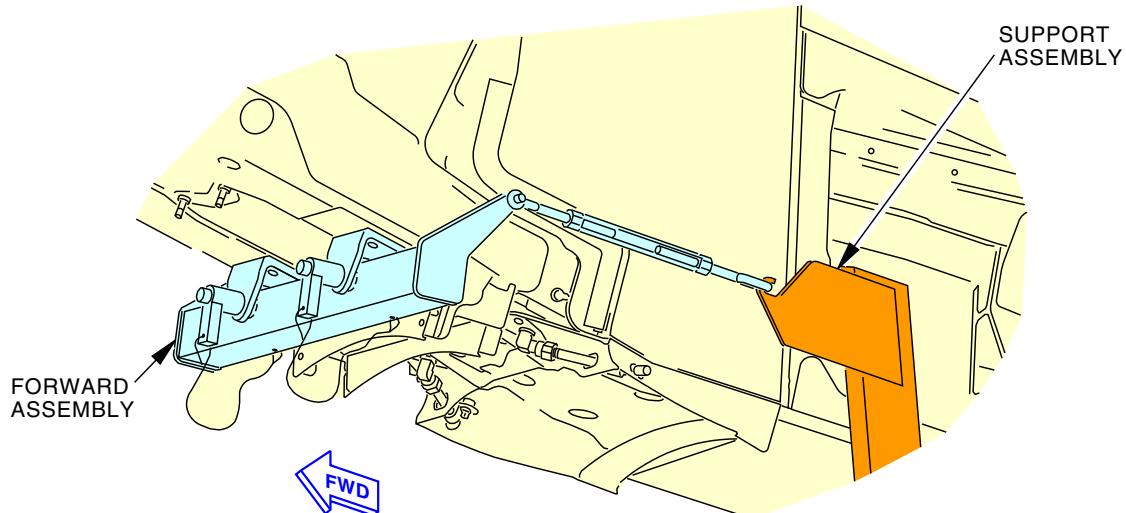
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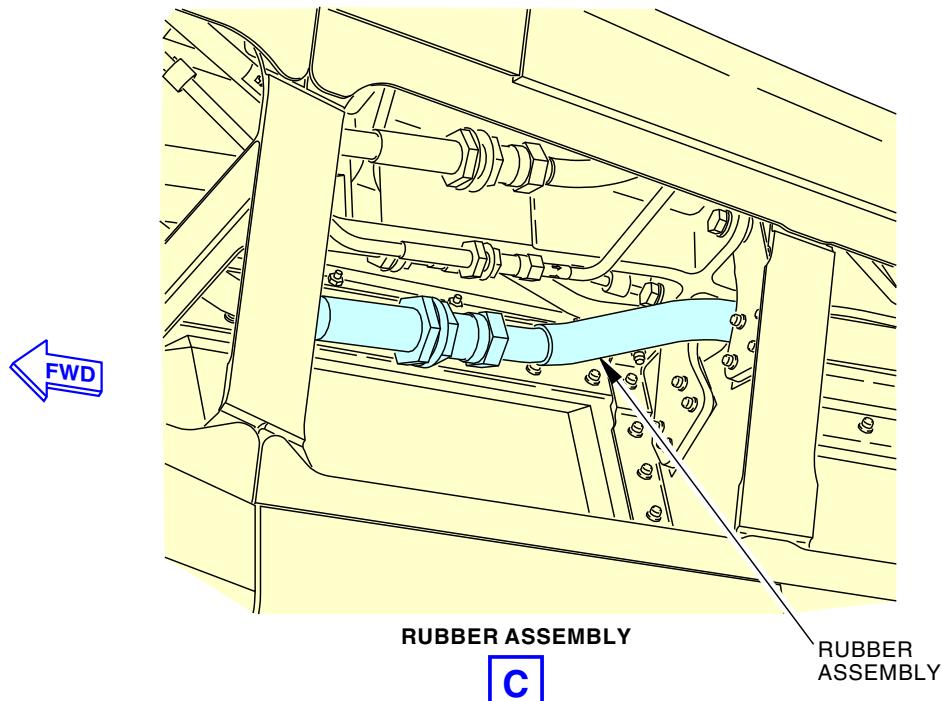
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BOEING
737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL



FORWARD ASSEMBLY

B



RUBBER ASSEMBLY

C

2105682 S0000449310_V2

Aft Fairing Installation Tool (Without Primary Plug and Nozzle)
Figure 407/54-52-04-990-804 (Sheet 4 of 4)

EFFECTIVITY
 LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
 407, 411, 412, 415, 416, 420, 422-426 POST SB
 737-54-1047 OR POST SB 737-78-1089

54-52-04

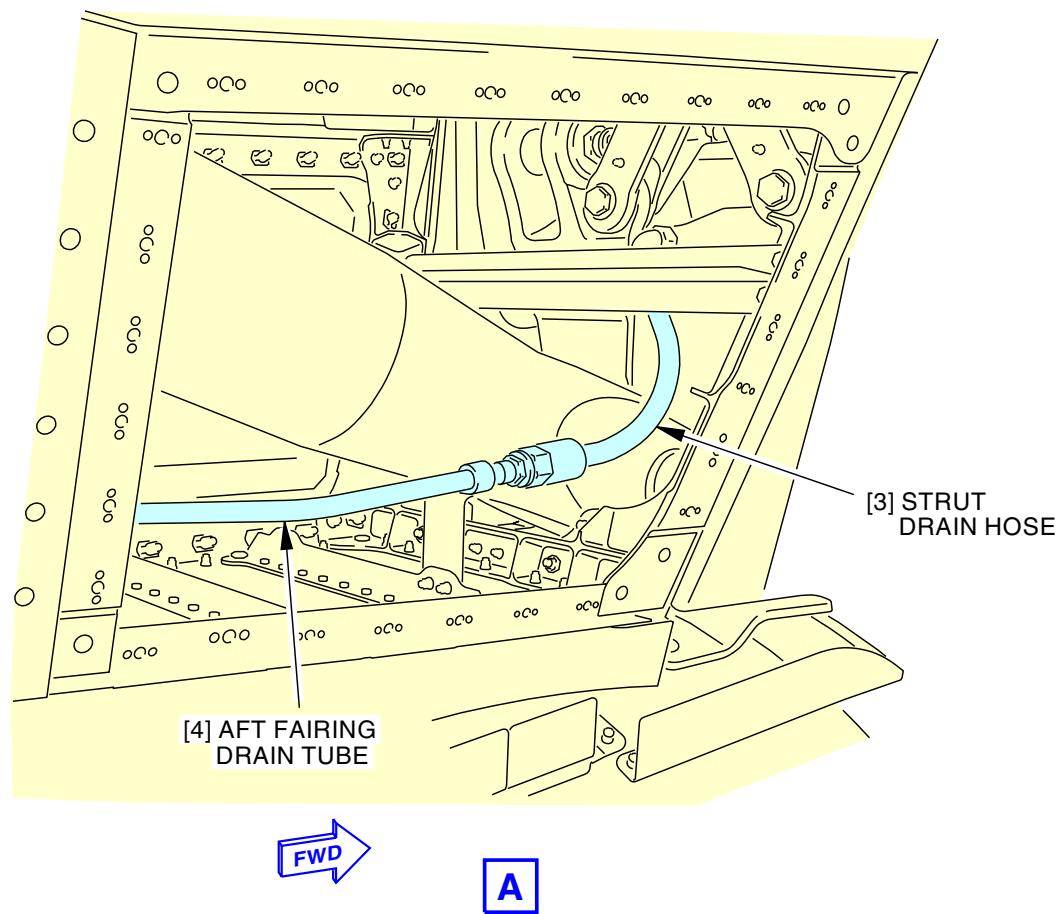
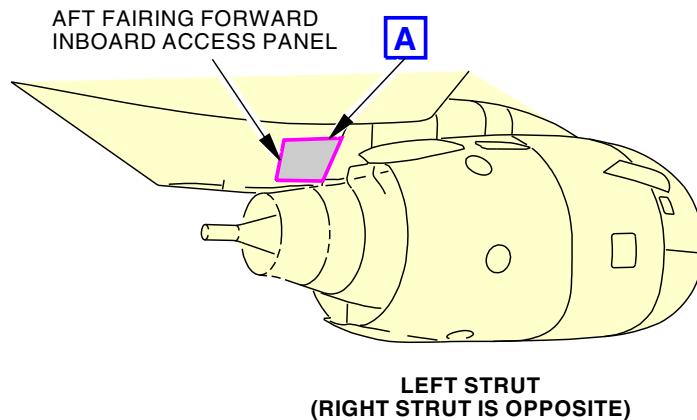
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737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL



2097820 S0000443017_V2

Aft Fairing Drain Tube Disconnect
Figure 408/54-52-04-990-805 (Sheet 1 of 2)

EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-78-1089

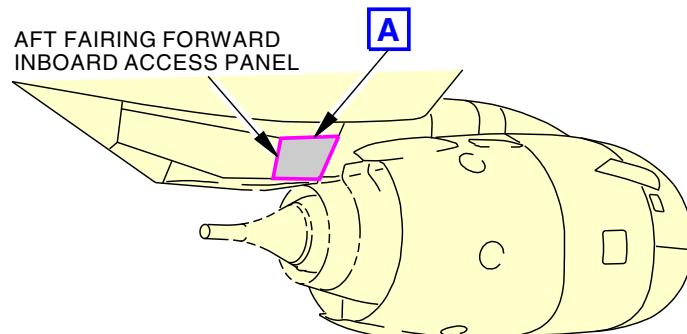
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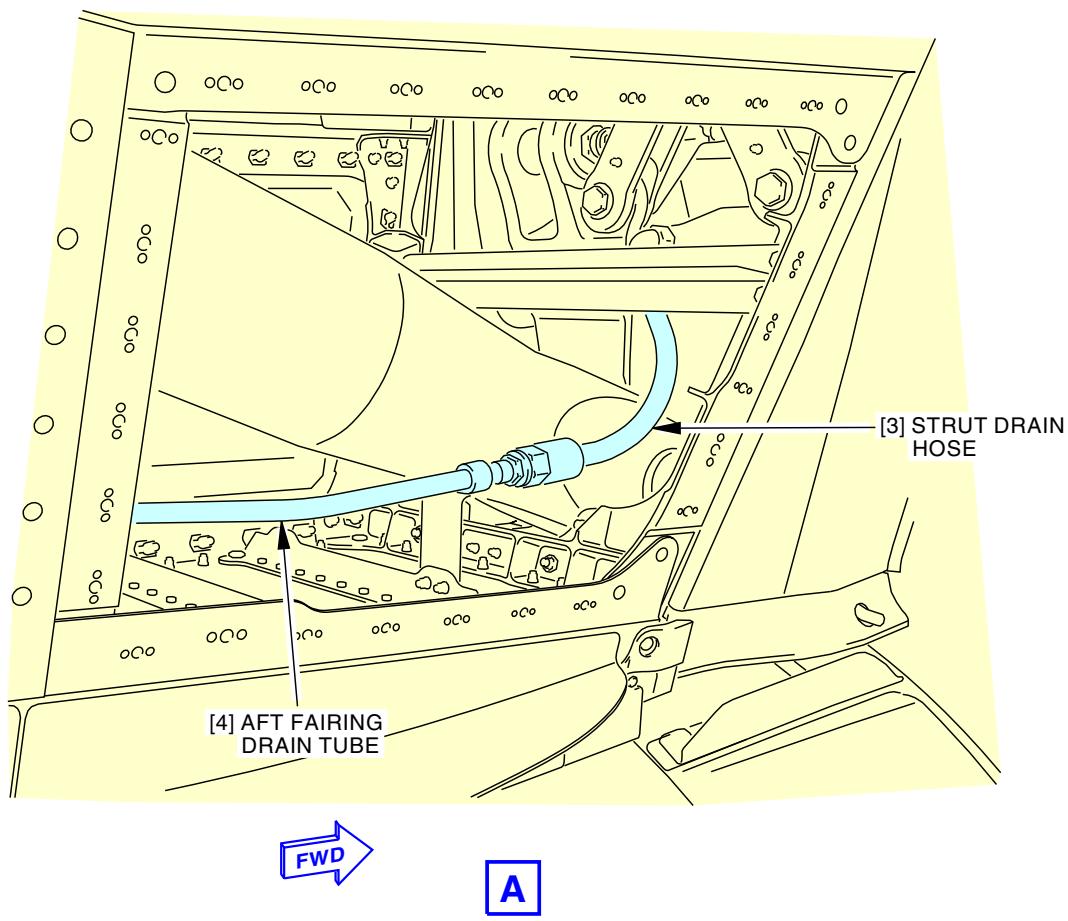
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**LEFT STRUT
(RIGHT STRUT IS OPPOSITE)**



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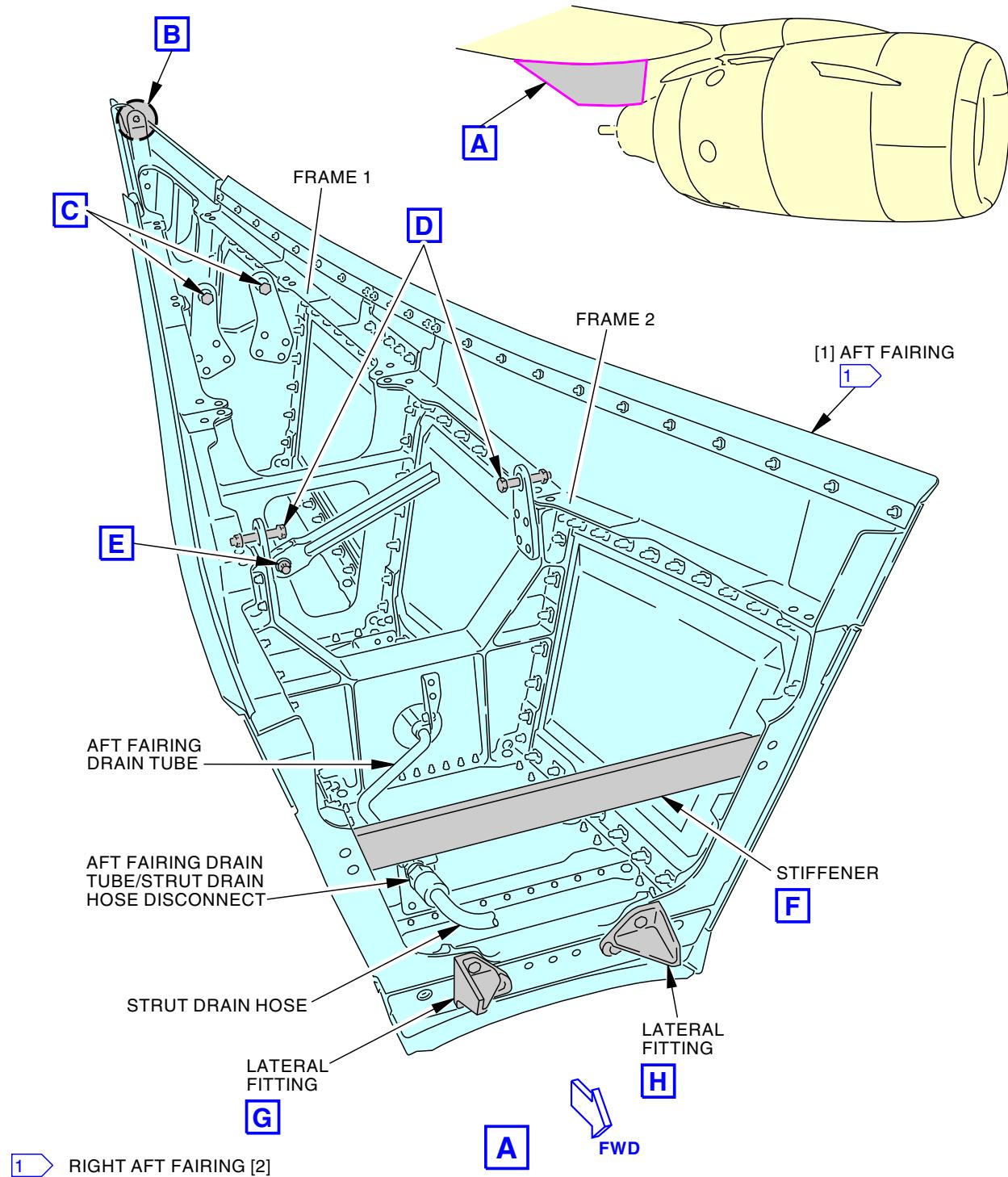
Aft Fairing Drain Tube Disconnect
Figure 408/54-52-04-990-805 (Sheet 2 of 2)

EFFECTIVITY
LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
407, 411, 412, 415, 416, 420, 422-426 POST SB
737-54-1047 OR POST SB 737-78-1089

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Aft Fairing Installation
Figure 409/54-52-04-990-806 (Sheet 1 of 4)

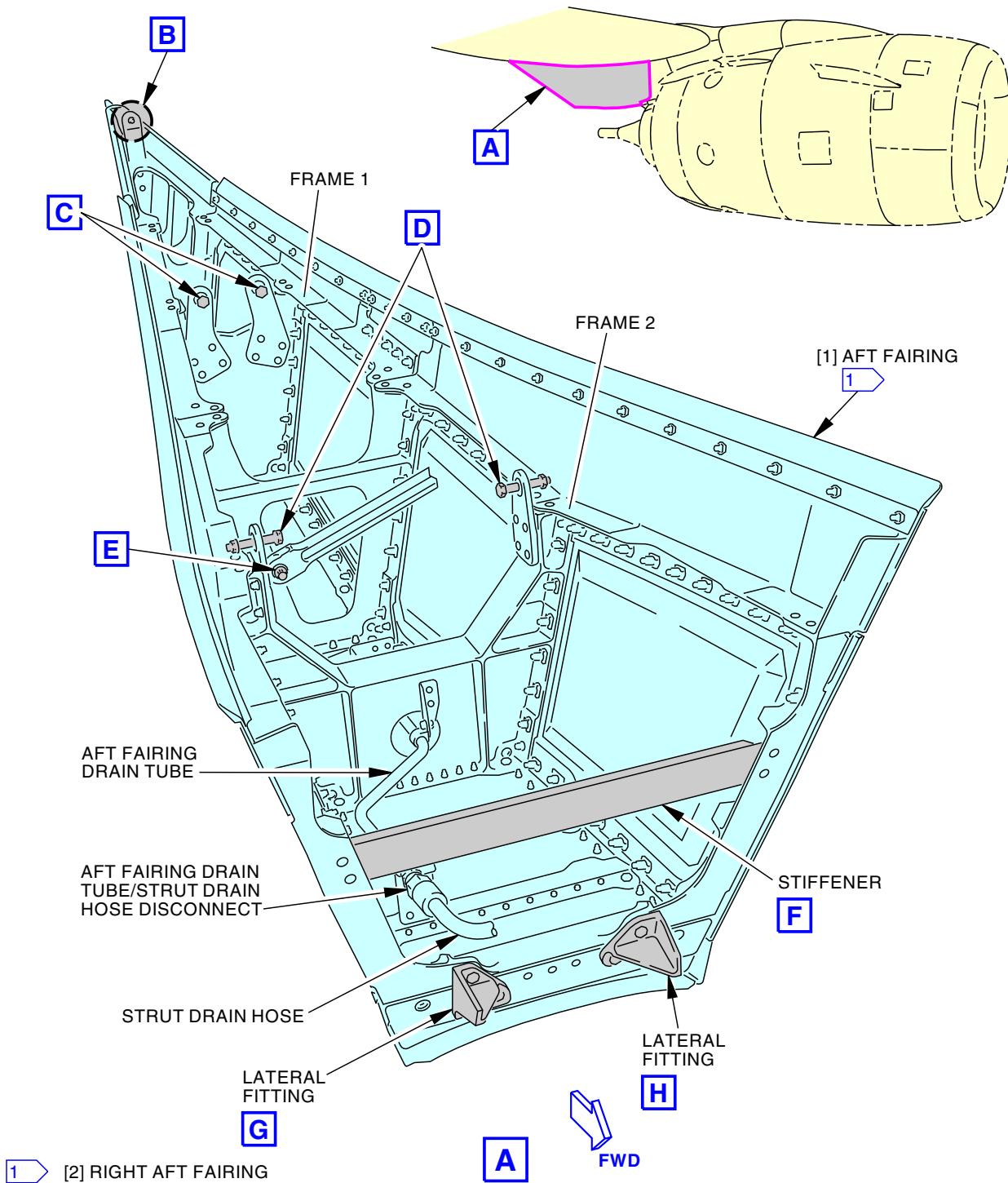
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422-426 PRE SB 737-78-1089

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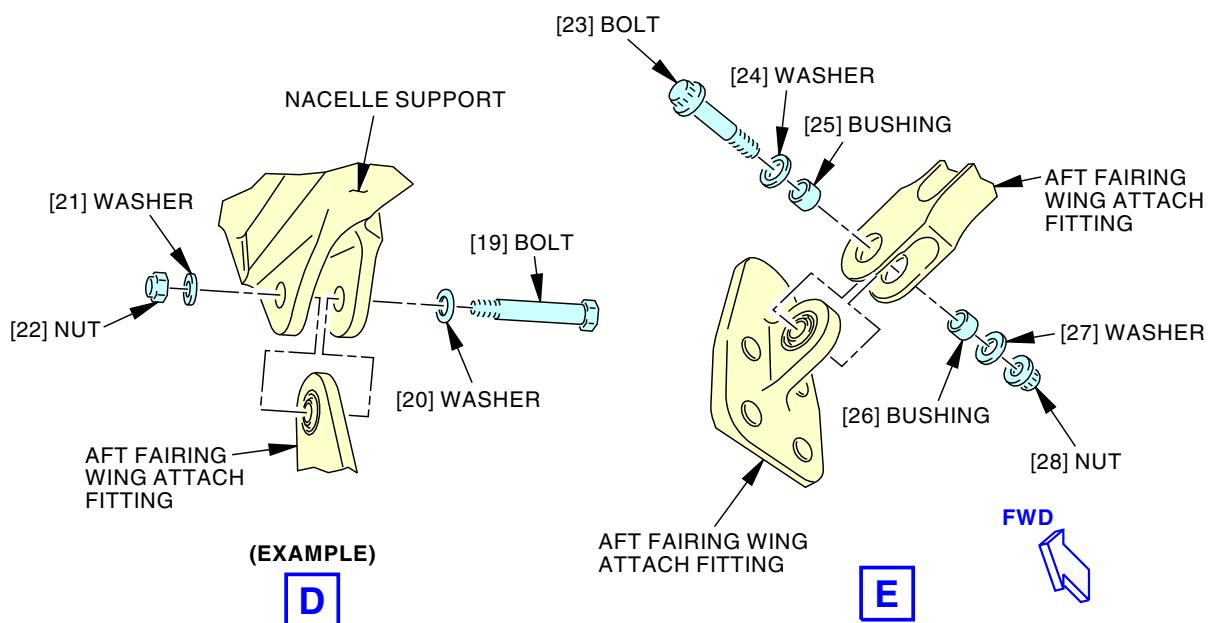
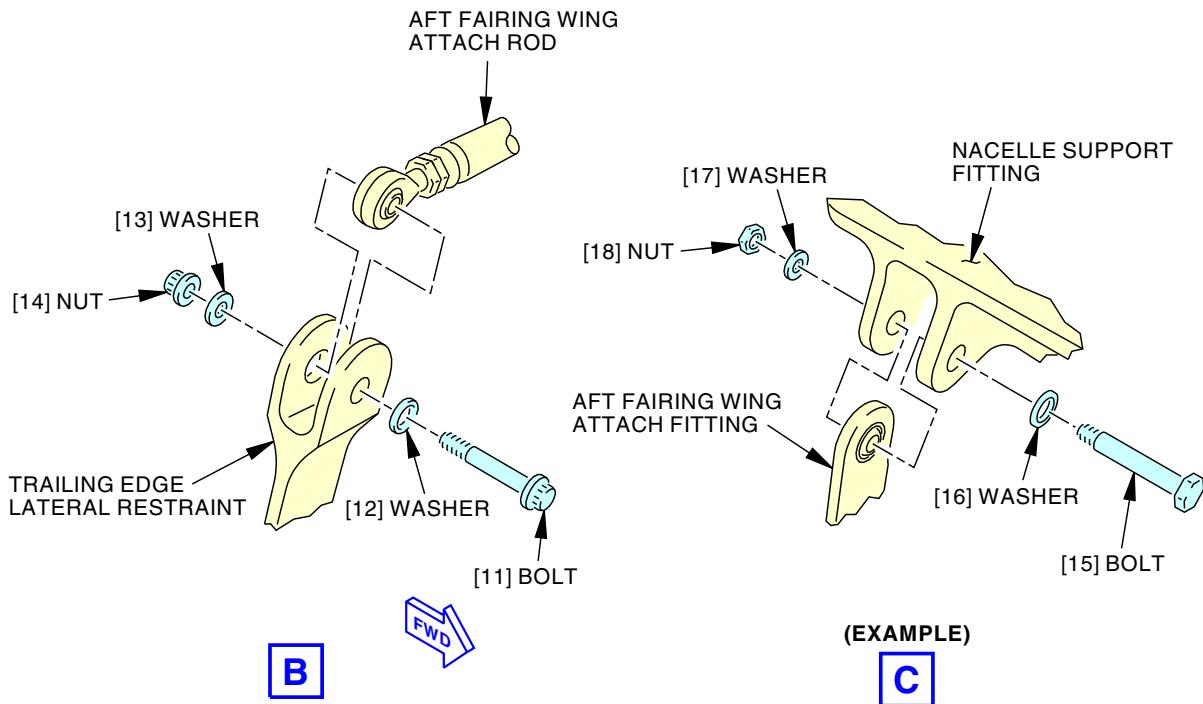
Aft Fairing Installation
Figure 409/54-52-04-990-806 (Sheet 2 of 4)

EFFECTIVITY
LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
407, 411, 412, 415, 416, 420, 422-426 POST SB
737-54-1047 OR POST SB 737-78-1089

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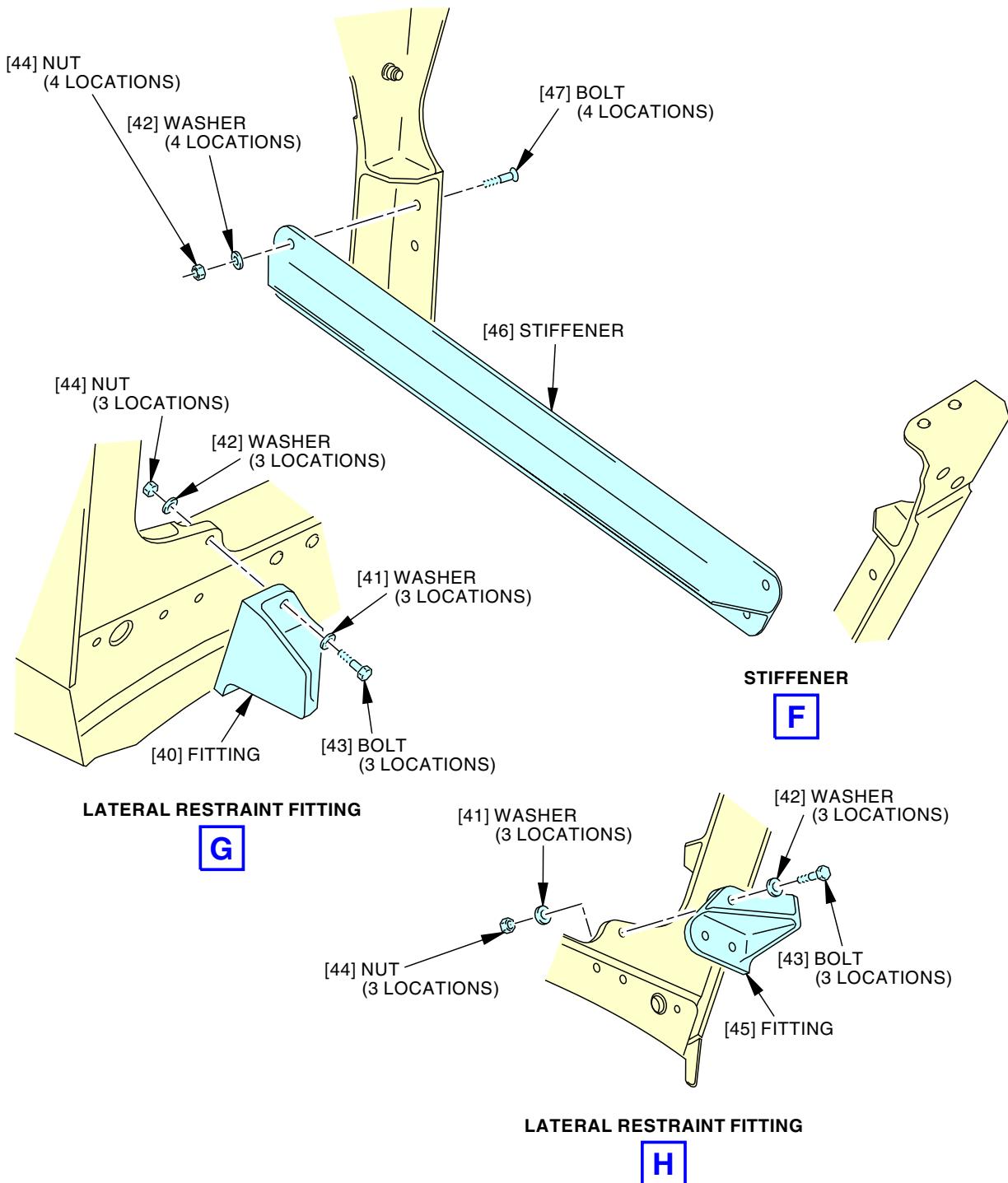


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Aft Fairing Installation
Figure 409/54-52-04-990-806 (Sheet 3 of 4)

EFFECTIVITY
LOM ALL

54-52-04



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Aft Fairing Installation
Figure 409/54-52-04-990-806 (Sheet 4 of 4)

EFFECTIVITY	LOM ALL
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AFT FAIRING - INSPECTION/CHECK

1. General

A. This procedure has these tasks:

- (1) Aft fairing examination of the skin, access panels, fasteners, and drain lines.
- (2) Aft fairing frame examination of the aft fairing structure.

TASK 54-52-04-000-801

2. Aft Fairing Examination

A. References

Reference	Title
54-51-01-040-801	Prepare the Strut for Maintenance Operations (P/B 201)
54-51-01-440-801	Put the Strut Back to its Usual Condition (P/B 201)
54-52-00-200-801	Aerodynamic Smoothness Requirements (P/B 201)
54-52-04-410-801	Aft Fairing Installation (Engine Removed) (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
434	Engine 1 - Aft Strut Fairing
444	Engine 2 - Aft Strut Fairing

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. Prepare for the Examination

SUBTASK 54-52-04-040-001

- (1) Do this task: Prepare the Strut for Maintenance Operations, TASK 54-51-01-040-801.

SUBTASK 54-52-04-010-001

- (2) To remove the applicable access panel from the aft fairing, do this task (TASK 54-52-06-010-801):

Open these 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



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E. Aft Fairing Examination

SUBTASK 54-52-04-210-001

- (1) Do these steps to examine the aft fairing:
 - (a) Examine the aft fairing structure for damage.
 - 1) Examine the aft fairing skin for cracks, separation of the bonded layers, and damage to the paint and protective coating.
 - 2) Examine the frames and bulkheads for cracks or worn areas, and for damage to the protective coating.
 - (b) Examine the support fittings and the underwing fittings for cracks or damage.
 - 1) Make sure that the bushings and bearings have not moved in their bores.
 - 2) Look for damage or worn areas in the bushings and bearings.
 - (c) Make sure the bolts which attach the aft fairing are correctly installed, and are not loose or missing, (TASK 54-52-04-410-801).
 - (d) Examine the seal between the top of the aft fairing and the bottom of the wing for damage.
 - (e) Examine the drainlines for cracks or leaks.
 - 1) Examine the clamps and brackets to make sure the drainlines are correctly installed, and are not loose.
 - (f) Examine the exterior of the heat shield castings for cracks or damage.

SUBTASK 54-52-04-410-001

- (2) To install the access panels on the aft fairing, do this task (TASK 54-52-06-410-801):

Close these 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

SUBTASK 54-52-04-210-002

- (3) Make sure the aft fairings are in the aerodynamic smoothness limits, (TASK 54-52-00-200-801).

F. Put the Airplane Back to its Usual Condition

SUBTASK 54-52-04-440-001

- (1) Do this task: Put the Strut Back to its Usual Condition, TASK 54-51-01-440-801.

———— END OF TASK ————

TASK 54-52-04-000-802

3. Aft Fairing Frame Examination

A. General

- (1) This task gives instructions to examine the frames in the aft fairing for possible cracks.



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B. References

Reference	Title
54-51-01-040-801	Prepare the Strut for Maintenance Operations (P/B 201)
54-51-01-440-801	Put the Strut Back to its Usual Condition (P/B 201)
54-52-00-200-801	Aerodynamic Smoothness Requirements (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)

C. Location Zones

Zone	Area
434	Engine 1 - Aft Strut Fairing
444	Engine 2 - Aft Strut Fairing

D. 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

E. Prepare for the Examination

SUBTASK 54-52-04-040-002

- (1) Do this task: Prepare the Strut for Maintenance Operations, TASK 54-51-01-040-801.

SUBTASK 54-52-04-010-002

- (2) To remove the applicable access panel from the aft fairing, do this task (TASK 54-52-06-010-801):

Open these 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

F. Aft Fairing Frame Examination

SUBTASK 54-52-04-210-003

- (1) Visually examine the frames in the aft fairing.

SUBTASK 54-52-04-210-004

- (2) If you find a crack, then do these steps:
- If the crack is longer than 1.0 inch (25.4 mm) or if you find more than one crack, contact Boeing for corrective action.
 - If a crack is found in one place only and if the crack is no more than 1.0 inch (25.4 mm) long, then do these steps:
 - You may operate the airplane up to 50 more flight cycles, then you must incorporate the appropriate repair.

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- 2) Contact Boeing for corrective action.

G. Put the Airplane Back to its Usual Condition

SUBTASK 54-52-04-410-002

- (1) To install the access panels on the aft fairing, do this task (TASK 54-52-06-410-801):

Close these access panels:

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

SUBTASK 54-52-04-210-005

- (2) Make sure the aft fairings are in the aerodynamic smoothness limits (TASK 54-52-00-200-801).

H. Put the Airplane Back to its Usual Condition

SUBTASK 54-52-04-440-002

- (1) Do this task: Put the Strut Back to its Usual Condition, TASK 54-51-01-440-801.

———— END OF TASK ————

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AFT FAIRING ACCESS PANELS - REMOVAL/INSTALLATION

1. General

- A. This procedure has two tasks:
- (1) A removal of the aft fairing access panels.
 - (2) An installation of the aft fairing access panels.

TASK 54-52-06-010-801

2. Aft Fairing Access Panel Removal

(Figure 401)

A. General

- (1) This task gives the instructions on how to remove the access panels on the strut aft fairing.
- (2) Each strut has these access panels on the aft fairing:
 - (a) An inboard and an outboard forward access panel.
 - (b) An outboard aft access panel.

B. References

Reference	Title
54-51-01-040-801	Prepare the Strut for Maintenance Operations (P/B 201)

C. Location Zones

Zone	Area
434	Engine 1 - Aft Strut Fairing
444	Engine 2 - Aft Strut Fairing

D. 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

E. Prepare for the Removal

SUBTASK 54-52-06-040-001

- (1) Do this task: Prepare the Strut for Maintenance Operations, TASK 54-51-01-040-801.

F. Aft Fairing Access Panel Removal

SUBTASK 54-52-06-000-001

- (1) Do these steps to remove the inboard or outboard forward access panels:



PUT A MARK OR LABEL ON THE BONDING BOLTS AFTER REMOVING THEM. THIS WILL MAKE SURE THAT THEY ARE INSTALLED INTO THE CORRECT FASTENER HOLES. BONDING BOLTS HELP PREVENT POSSIBLE DAMAGE DUE TO LIGHTNING. IF BONDING BOLTS ARE NOT INSTALLED CORRECTLY, DAMAGE TO THE AIRPLANE MAY OCCUR.

- (a) Remove the bolts [1] and the bonding bolts [4] that attach the applicable panel [2], [3], [7], or [8] to the strut aft fairing, and do this step:

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Open the applicable access panels:

<u>Number</u>	<u>Name/Location</u>
434AL	Aft Strut Fairing, Left Forward Panel, Strut 1
434AR	Aft Strut Fairing, Right Forward Panel, Strut 1
444AL	Aft Strut Fairing, Left Forward Panel, Strut 2
444AR	Aft Strut Fairing, Right Forward Panel, Strut 2

SUBTASK 54-52-06-000-002

- (2) Do these steps to remove the outboard aft access panel:



PUT A MARK OR LABEL ON THE BONDING BOLTS AFTER REMOVING THEM. THIS WILL MAKE SURE THAT THEY ARE INSTALLED INTO THE CORRECT FASTENER HOLES. BONDING BOLTS HELP PREVENT POSSIBLE DAMAGE DUE TO LIGHTNING. IF BONDING BOLTS ARE NOT INSTALLED CORRECTLY, DAMAGE TO THE AIRPLANE MAY OCCUR.

- (a) Remove the bolts [1] and the bonding bolts [4] that attach the applicable panel [5] or [6] to the strut aft fairing, and do this step:

Remove the applicable access panels:

<u>Number</u>	<u>Name/Location</u>
434BL	Aft Strut Fairing, Left Aft Panel, Strut 1
444BR	Aft Strut Fairing, Right Aft Panel, Strut 2

———— END OF TASK ————

TASK 54-52-06-410-801

3. Aft Fairing Access Panel Installation

(Figure 401)

A. General

- (1) This task gives the instructions on how to install the access panels on the strut aft fairing.
- (2) Each strut has these access panels on the aft fairing:
 - (a) An inboard and an outboard forward access panel.
 - (b) An outboard aft access panel.

B. References

<u>Reference</u>	<u>Title</u>
51-21-99-300-801	Decorative Exterior Paint System Application (P/B 701)
54-51-01-440-801	Put the Strut Back to its Usual Condition (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.

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Reference	Description
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

D. Consumable Materials

Reference	Description	Specification
C00767	Coating - Anti-Static Coating	BMS10-21 Type III
D50004	Compound - Antiseize	BMS3-28

E. Location Zones

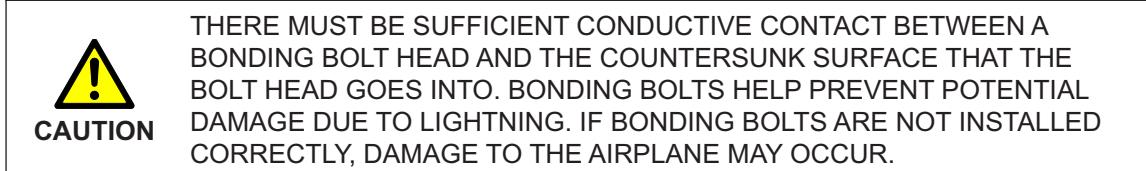
Zone	Area
434	Engine 1 - Aft Strut Fairing
444	Engine 2 - Aft Strut Fairing

F. 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

G. Access Panel Installation

SUBTASK 54-52-06-350-001



- (1) If the countersink hole for a bonding fastener does not have a complete layer of anti-static coating in it, do the following steps:

NOTE: See (Figure 401) for bonding fastener locations on each panel.

- (a) Abrade the uncoated surface in the countersink.
- (b) Apply anti-static coating, C00767 to the sanded surface of a countersink.



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- 1) Make sure that contact is achieved between any existing coating and the newly applied coating.
- (c) Allow anti-static coating to dry completely before installing bonding bolt.
NOTE: A minimum of two hours is required to completely dry the anti-static coating.
NOTE: If coating is not dry completely, it will come off later when the bonding fastener is removed.
- (d) For the areas around the countersink that has missing paint, refer to Decorative Exterior Paint System Application, TASK 51-21-99-300-801, if necessary.

SUBTASK 54-52-06-400-001

- (2) Do these steps to install the inboard or outboard forward access panel:
 - (a) Put the applicable access panel [2], [3], [7], or [8] in its correct location on the aft fairing, and do this step:
Close the applicable access panels:

<u>Number</u>	<u>Name/Location</u>
434AL	Aft Strut Fairing, Left Forward Panel, Strut 1
434AR	Aft Strut Fairing, Right Forward Panel, Strut 1
444AL	Aft Strut Fairing, Left Forward Panel, Strut 2
444AR	Aft Strut Fairing, Right Forward Panel, Strut 2
 - (b) Apply compound, D50004 to the thread of bolts [1].
 - (c) Install the bolt [1] and the bonding bolt [4] that attach the access panel to the strut aft fairing.
 - (d) Make sure that the resistance between the bonding bolts and the structure is no more than 300,000 ohms using an digital/analog multimeter, COM-1793.

SUBTASK 54-52-06-400-002

- (3) Do these steps to install the outboard aft access panel:
 - (a) Put the applicable access panel [5] or [6] in the correct location on the aft fairing, and do this step:
Close the applicable access panel:

<u>Number</u>	<u>Name/Location</u>
434BL	Aft Strut Fairing, Left Aft Panel, Strut 1
444BR	Aft Strut Fairing, Right Aft Panel, Strut 2
 - (b) Apply compound, D50004 to the thread of bolts [1].
 - (c) Install the bolt [1] and the bonding bolt [4] that attach the access panel to the strut aft fairing.
 - (d) Make sure that the resistance between the bonding bolts and the structure is no more than 300,000 ohms using an digital/analog multimeter, COM-1793.

H. Put the Airplane Back to Its Usual Condition

SUBTASK 54-52-06-440-001

- (1) Do this task: Put the Strut Back to its Usual Condition, TASK 54-51-01-440-801.

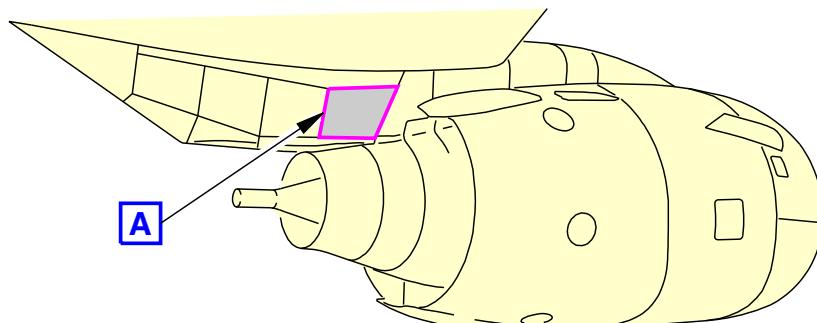
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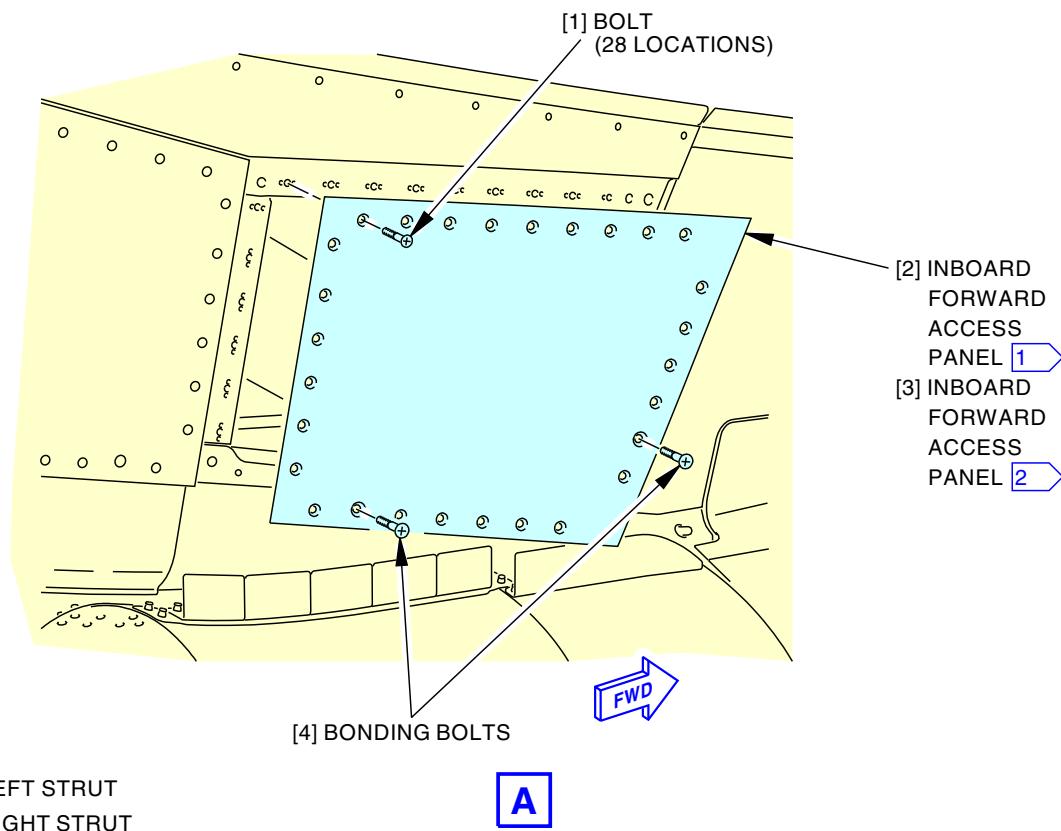
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LEFT STRUT
(RIGHT STRUT IS OPPOSITE)



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Strut Aft Fairing Access Panels
Figure 401/54-52-06-990-801 (Sheet 1 of 6)

EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-78-1089

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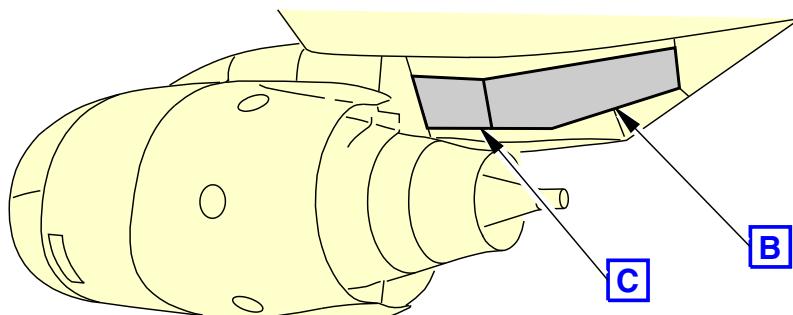
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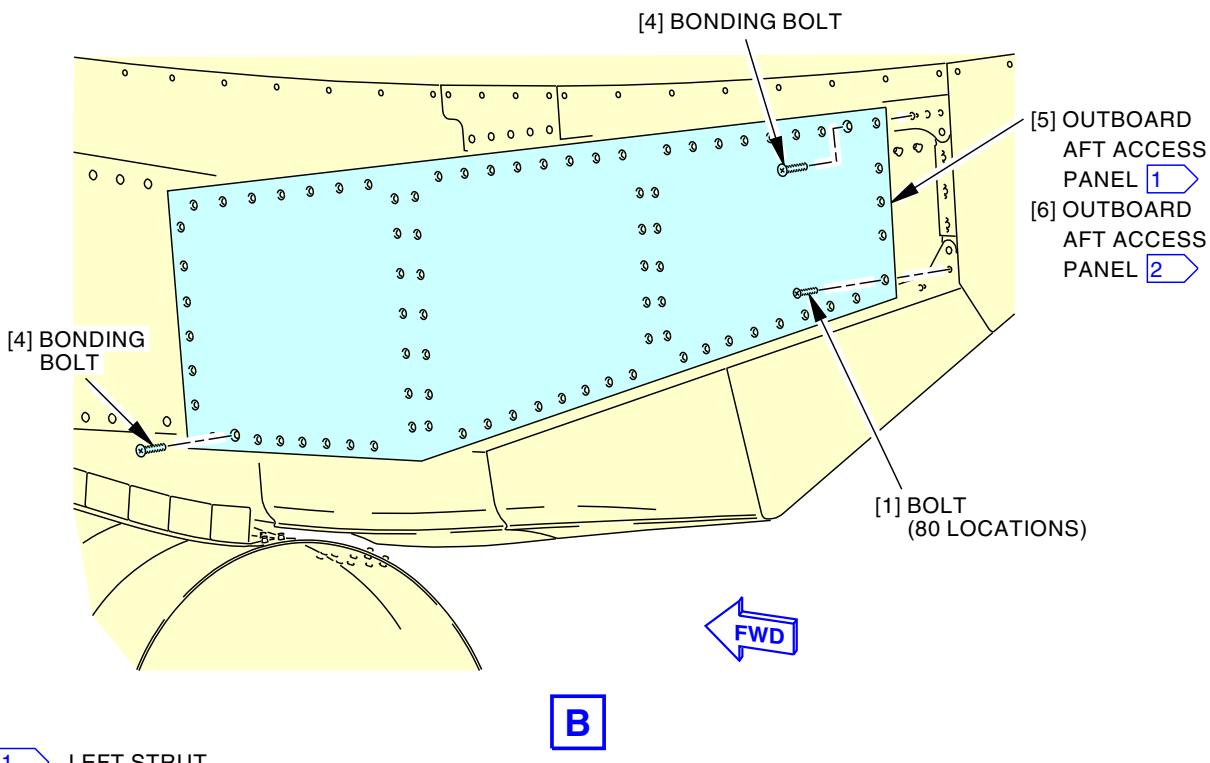
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LEFT STRUT
(RIGHT STRUT IS OPPOSITE)



- 1 LEFT STRUT
 2 RIGHT STRUT

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Strut Aft Fairing Access Panels
Figure 401/54-52-06-990-801 (Sheet 2 of 6)

EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-78-1089

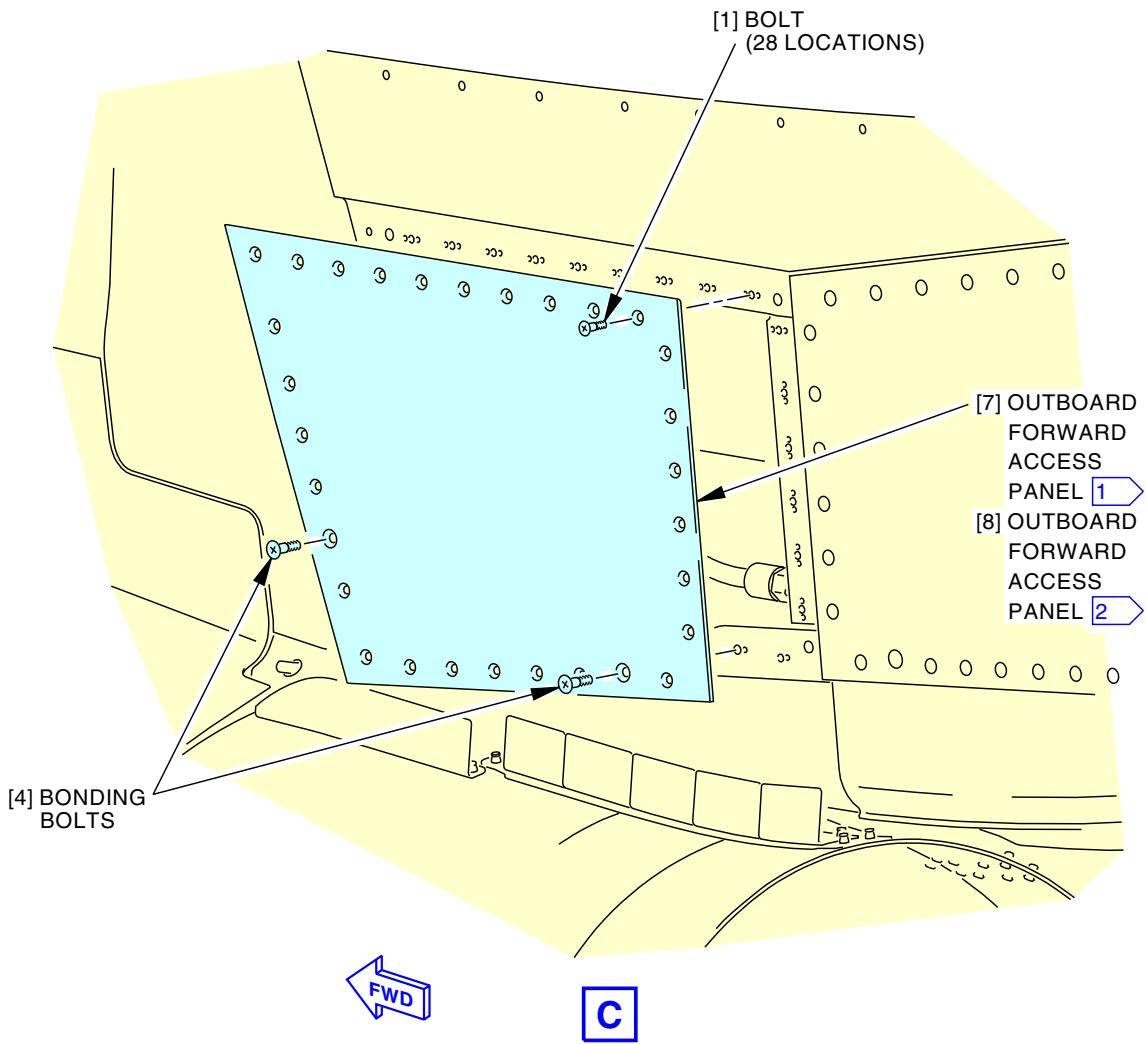
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1 LEFT STRUT
2 RIGHT STRUT

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Strut Aft Fairing Access Panels
Figure 401/54-52-06-990-801 (Sheet 3 of 6)

EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-78-1089

54-52-06

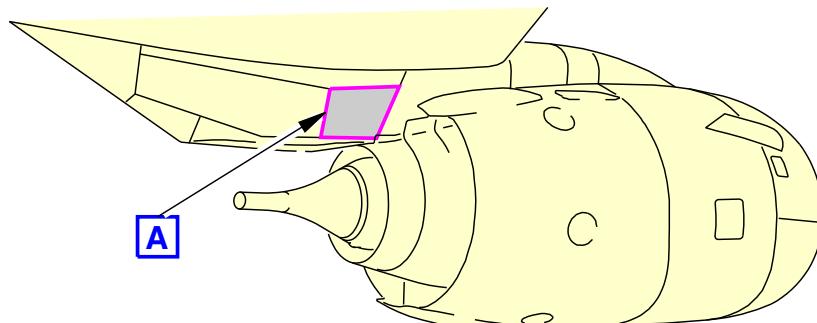
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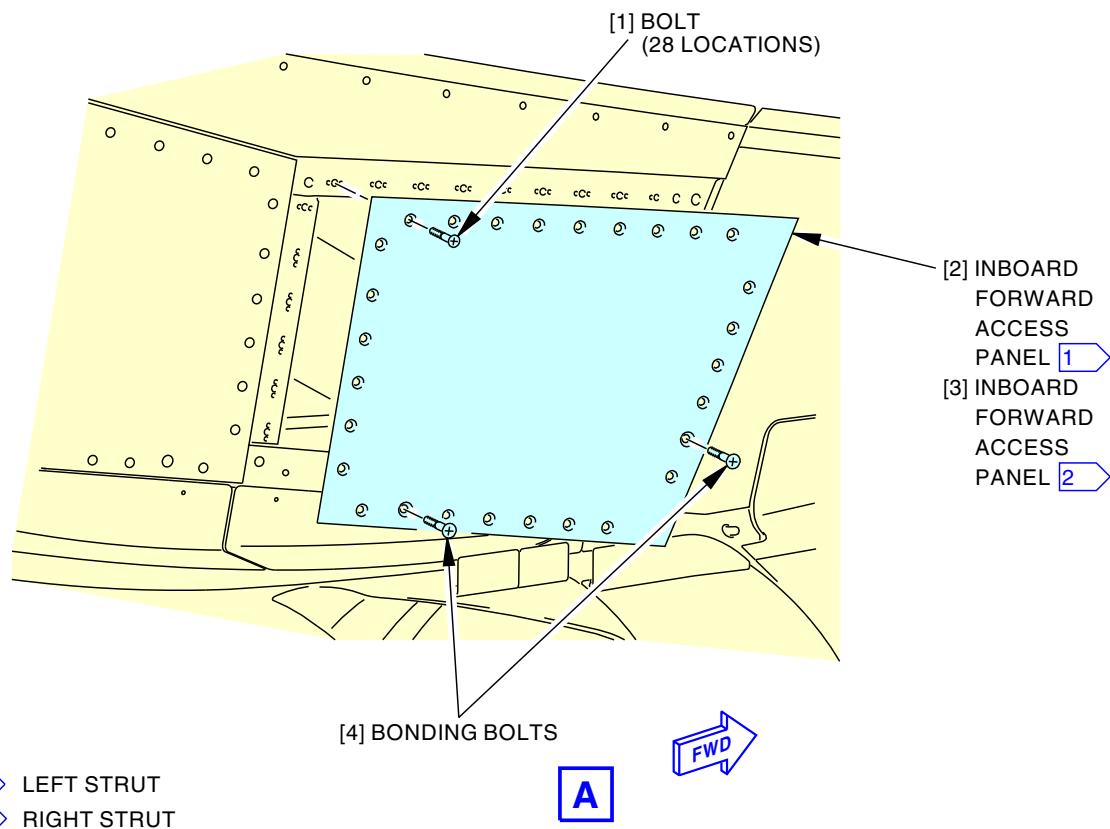
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LEFT STRUT
(RIGHT STRUT IS OPPOSITE)



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Strut Aft Fairing Access Panels
Figure 401/54-52-06-990-801 (Sheet 4 of 6)

EFFECTIVITY
LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
407, 411, 412, 415, 416, 420, 422-426 POST SB
737-78-1089

54-52-06

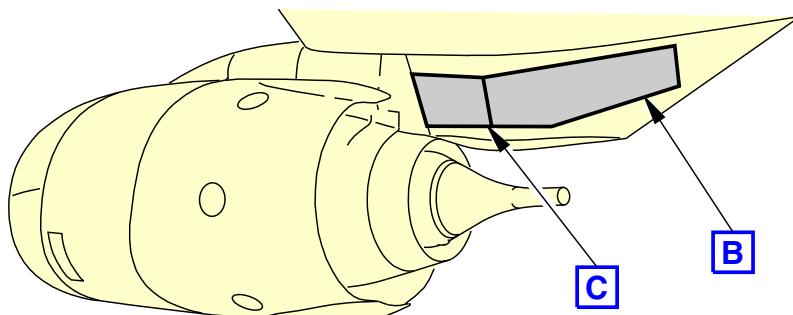
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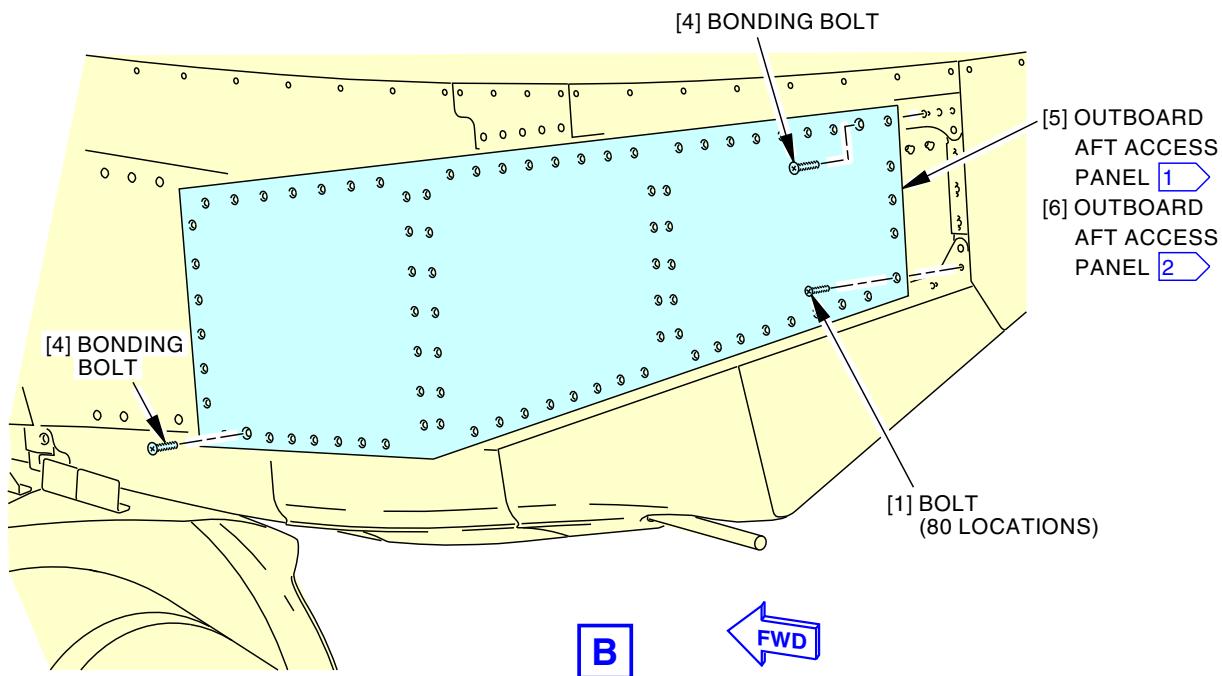
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LEFT STRUT
(RIGHT STRUT IS OPPOSITE)



[1] LEFT STRUT
[2] RIGHT STRUT

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Strut Aft Fairing Access Panels
Figure 401/54-52-06-990-801 (Sheet 5 of 6)

EFFECTIVITY
LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
407, 411, 412, 415, 416, 420, 422-426 POST SB
737-78-1089

54-52-06

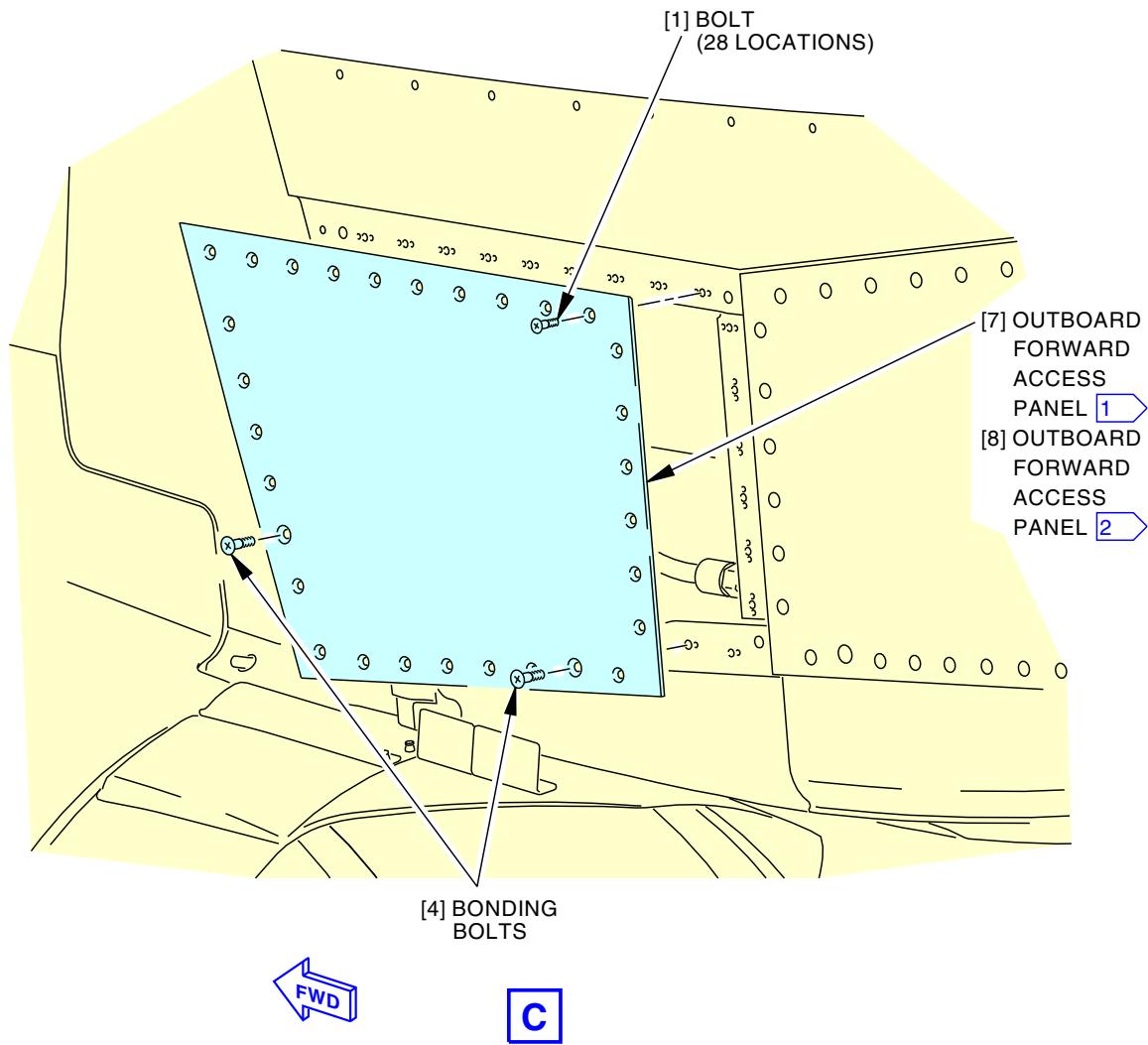
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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Oct 15/2024



737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL



LEFT STRUT
 RIGHT STRUT

2097229 S0000443666_V2

Strut Aft Fairing Access Panels
Figure 401/54-52-06-990-801 (Sheet 6 of 6)

EFFECTIVITY
LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
407, 411, 412, 415, 416, 420, 422-426 POST SB
737-78-1089

54-52-06

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL

AFT FAIRING ACCESS PANELS - CLEANING/PAINTING

1. General

- A. This section contains one procedure:
- (1) Repair the enamel paint on the aft fairing access panels.

TASK 54-52-06-370-801

2. Repair the aft fairing access panels enamel paint

(Figure 701 or Figure 702)

A. References

Reference	Title
51-21-11-150-801	Paint Stripping (P/B 701)
51-21-11-150-815	Composite Parts - Paint Stripping (P/B 701)
51-21-71 P/B 701	CONDUCTIVE COATING FOR EXTERNAL SURFACES - CLEANING/PAINTING
51-21-71-370-801	Apply BMS 10-21 Type III Conductive Coating to Specified External Surfaces (P/B 701)
51-21-72-370-801	BMS10-79 Primer - Application (P/B 701)
51-21-72-370-802	BMS10-103, Type 1, Primer - Application (P/B 701)
51-21-95-300-801	Chemical Conversion Coating Application (P/B 701)

B. Consumable Materials

Reference	Description	Specification
C00175	Primer - Urethane Compatible, Corrosion Resistant	BMS10-79 Type III
C00766	Primer - Nonchromated Primer For Composites	BMS10-103 Type I
C00767	Coating - Anti-Static Coating	BMS10-21 Type III
C00841	Coating - Anti-Static Coating	BMS10-21 Type II
C50021	Enamel - High Temperature, Epoxy, Max Operating Temperature 400F, Intermittent 550F	BAC5710 Type 53
C50075	Coating - Protective Enamel (BAC 707 Gray Color)	BMS10-60 Type II

C. Aluminum Surface

SUBTASK 54-52-06-100-001



WARNING

DO NOT GET PAINT REMOVER IN YOUR EYES, IN YOUR MOUTH OR ON YOUR SKIN. USE GLOVES, EYE PROTECTION AND A RESPIRATOR. WASH AWAY WITH WATER AND GET MEDICAL AID IMMEDIATELY. MAKE SURE THAT THE AREA HAS A GOOD FLOW OF AIR. PAINT REMOVER IS POISONOUS AND FLAMMABLE, WHICH CAN CAUSE SERIOUS INJURY TO PERSONNEL.

- (1) Strip the existing enamel finish and primer (TASK 51-21-11-150-801).

SUBTASK 54-52-06-300-001

- (2) Touch up surface with chemical conversion coating (TASK 51-21-95-300-801).



54-52-06



737-600/700/800/900 AIRCRAFT MAINTENANCE MANUAL

SUBTASK 54-52-06-370-001

- (3) Apply one coat of primer, C00175 (TASK 51-21-72-370-801).

NOTE: Do not apply Type 51 primer. Cure time before fly away is 24 hours, 10 days for full cure.

LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 PRE SB 737-54-1047

SUBTASK 54-52-06-370-009

- (4) Apply a layer of coating, C50075 to the area on the aluminum surfaces not identified with diagonal lines.

SUBTASK 54-52-06-370-010

- (5) Apply high temperature enamel, C50021 to the area on the aluminum surfaces identified with diagonal lines.

LOM 427-434, 437-447, 450-999; LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 POST SB 737-54-1047

SUBTASK 54-52-06-370-015

- (6) Apply a layer of coating, C50075.

LOM ALL

D. Fiberglass Surface

SUBTASK 54-52-06-100-002



WARNING

DO NOT GET PAINT REMOVER IN YOUR EYES, IN YOUR MOUTH OR ON YOUR SKIN. USE GLOVES, EYE PROTECTION AND A RESPIRATOR. WASH AWAY WITH WATER AND GET MEDICAL AID IMMEDIATELY. MAKE SURE THAT THE AREA HAS A GOOD FLOW OF AIR. PAINT REMOVER IS POISONOUS AND FLAMMABLE, WHICH CAN CAUSE SERIOUS INJURY TO PERSONNEL.

- (1) Abrade to remove coating, C50075 and primer, C00766 down to the anti-static coating, C00841 (TASK 51-21-11-150-815).

SUBTASK 54-52-06-370-002

- (2) Inspect existing anti-static coating for continuous appearance and ensure surface complies to electrical bonding requirements (PAGEBLOCK 51-21-71/701).

SUBTASK 54-52-06-370-011

- (3) If anti-static coating is not acceptable, strip the coating and reapply coating, C00767 (TASK 51-21-71-370-801).

SUBTASK 54-52-06-370-012

- (4) Apply primer, C00766 (TASK 51-21-72-370-802).

NOTE: Do not apply Type 51 primer. Cure time before fly away is 24 hours, 10 days for full cure.

LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 PRE SB 737-54-1047

SUBTASK 54-52-06-370-013

- (5) Apply a layer of coating, C50075 to the area on the fiberglass surfaces not identified with diagonal lines.

SUBTASK 54-52-06-370-014

- (6) Apply high temperature enamel, C50021 to the area on the fiberglass surfaces identified with diagonal lines.

EFFECTIVITY
LOM ALL

54-52-06



**737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL**

**LOM 427-434, 437-447, 450-999; LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 POST SB
737-54-1047**

SUBTASK 54-52-06-370-016

- (7) Apply a layer of coating, C50075.

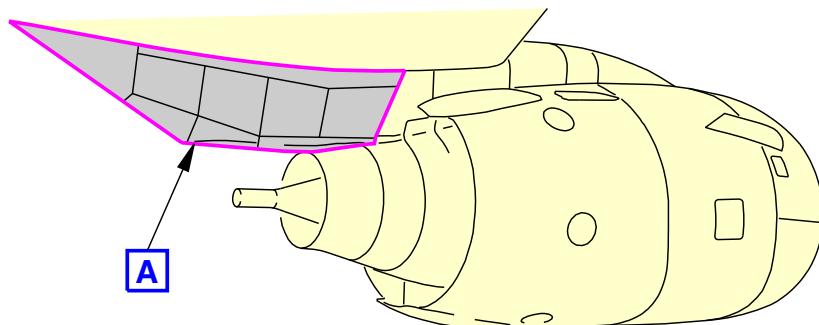
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EFFECTIVITY
LOM ALL

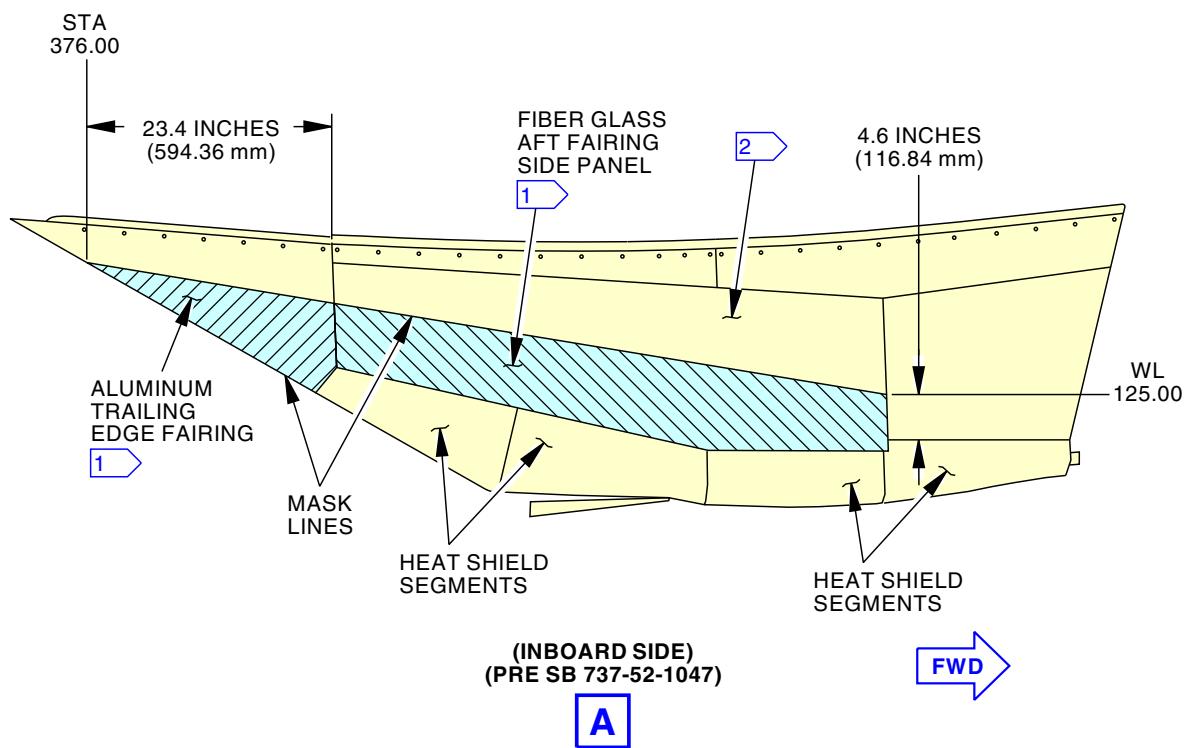
54-52-06



737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL



LEFT STRUT
(RIGHT STRUT IS OPPOSITE)



- [1] ENAMEL - HIGH TEMPERATURE EPOXY IN THE AREA IDENTIFIED WITH DIAGONAL LINES.
- [2] COATING - PROTECTIVE ENAMEL (BAC 707 GRAY COLOR) APPLIED TO THE FIBERGLASS AND ALUMINUM SURFACES NOT IDENTIFIED WITH THE DIAGONAL LINES.

1946592 S0000370474_V4

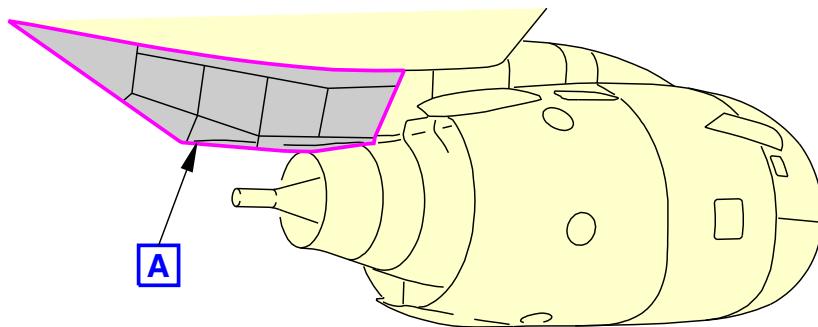
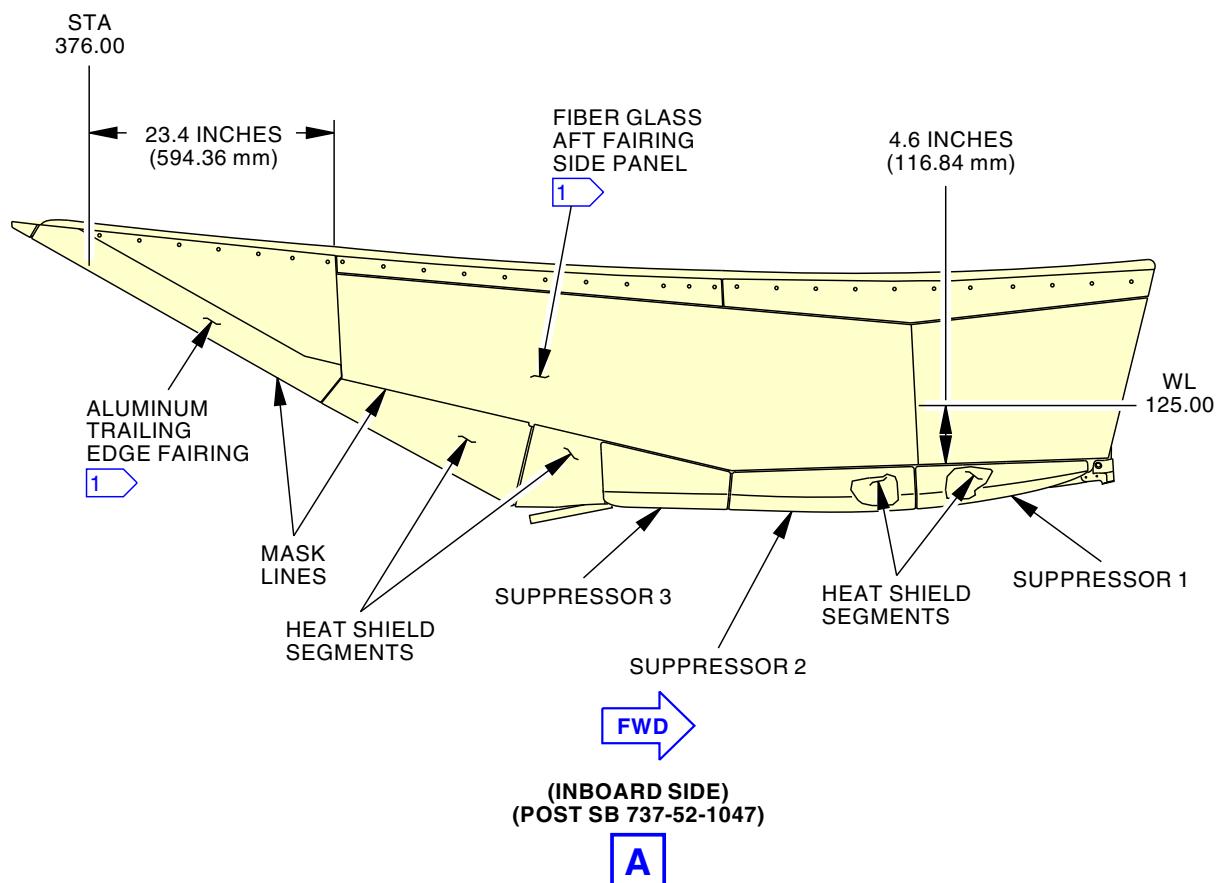
Aft Fairing Access Panel Paint
Figure 701/54-52-06-990-802 (Sheet 1 of 2)

EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-54-1047 AND PRE SB
737-78-1089

54-52-06

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

LEFT STRUT
(RIGHT STRUT IS OPPOSITE)

COATING - PROTECTIVE ENAMEL (BAC 707 GRAY COLOR)
APPLIED TO ALL OF THE FIBERGLASS AND ALUMINUM SURFACES.

3024691 S0000796341_V2

Aft Fairing Access Panel Paint

Figure 701/54-52-06-990-802 (Sheet 2 of 2)

EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 POST SB 737-54-1047 AND PRE SB
737-78-1089

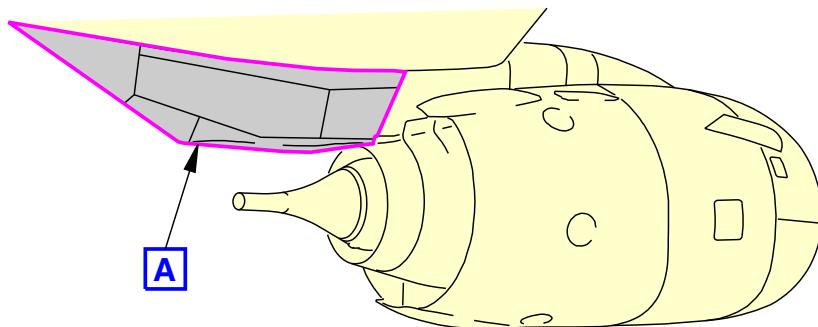
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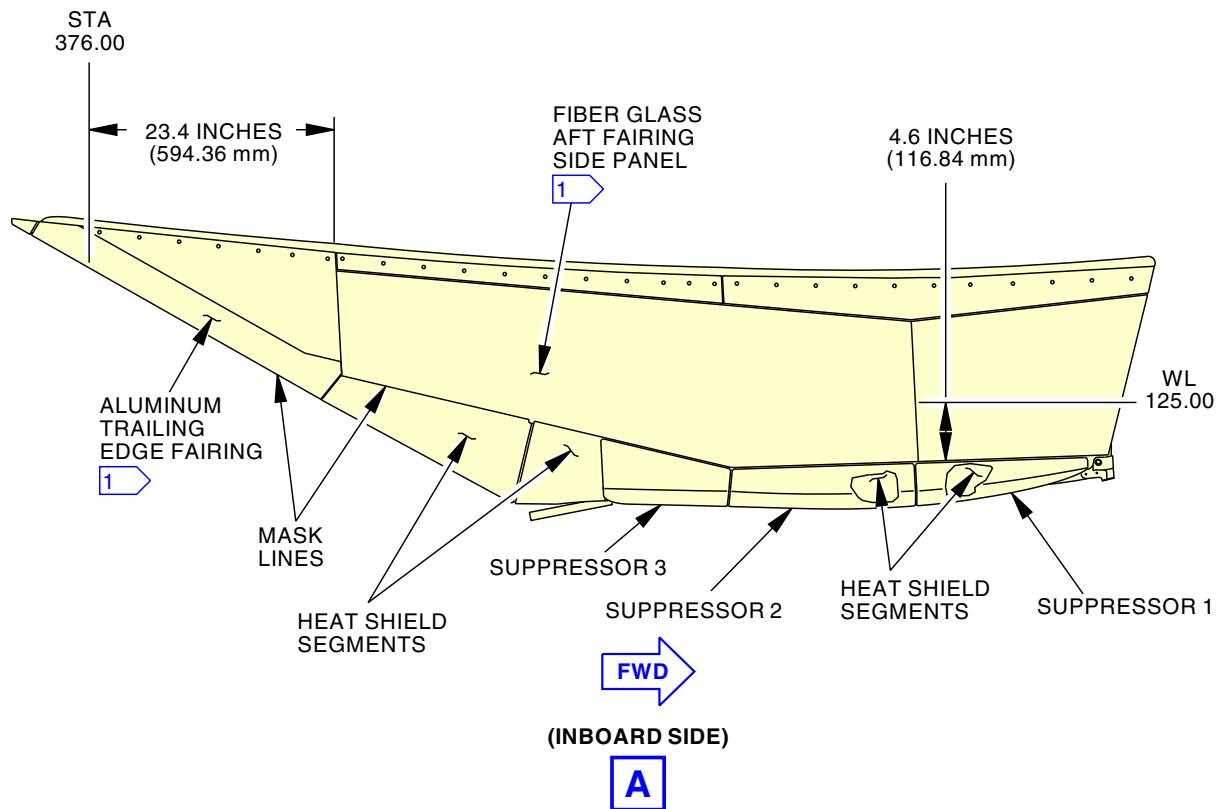
ECCN 9E991 BOEING PROPRIETARY - See title page for details



737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL



LEFT STRUT
(RIGHT STRUT IS OPPOSITE)



1 COATING - PROTECTIVE ENAMEL (BAC 707 GRAY COLOR)
APPLIED TO ALL OF THE FIBERGLASS AND ALUMINUM
SURFACES.

2097151 S0000443682_V5

Aft Fairing Access Panel Paint
Figure 702/54-52-06-990-804

EFFECTIVITY
LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
407, 411, 412, 415, 416, 420, 422-426 POST SB
737-78-1089

54-52-06

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL

AFT FAIRING HEATSHIELD - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) A removal of the aft fairing heatshield assembly.
 - (2) An installation of the aft fairing heatshield assembly.

TASK 54-52-08-010-801

2. Aft Fairing Heatshield Removal

A. General

- (1) This task gives the instruction on how to remove the heatshield assembly from the strut aft fairing.
- (2) There are insulation blankets inside the heatshield sections.

LOM ALL

B. References

Reference	Title
27-51-00-040-801	Trailing Edge Flap System Deactivation (P/B 201)
54-51-01-040-801	Prepare the Strut for Maintenance Operations (P/B 201)
54-52-06-010-801	Aft Fairing Access Panel Removal (P/B 401)
78-11-01-000-802-F00	Primary Nozzle Assembly Removal (P/B 401)
SRM 51-40-02	Structural Repair Manual

C. Location Zones

Zone	Area
434	Engine 1 - Aft Strut Fairing
444	Engine 2 - Aft Strut Fairing

D. 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

E. Prepare the Strut for Maintenance Operations

SUBTASK 54-52-08-040-001

- (1) Do this task: Prepare the Strut for Maintenance Operations, TASK 54-51-01-040-801.

SUBTASK 54-52-08-040-002

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



54-52-08

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**737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL**

**LOM 427-434, 437-447, 450-999; LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 POST SB
737-54-1047 OR POST SB 737-78-1089**

SUBTASK 54-52-08-020-001

- (3) Do this task: Primary Nozzle Assembly Removal, TASK 78-11-01-000-802-F00

LOM ALL

SUBTASK 54-52-08-010-012

- (4) Remove the applicable aft fairing 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
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

LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 PRE SB 737-54-1047

F. Aft Fairing Heatshield Removal

SUBTASK 54-52-08-010-010

- (1) Remove the heatshields from the aft fairing in this sequence (aft to forward) (Figure 401):

- (a) Remove heatshield No. 4 [28] (aft end):

- 1) Remove bolts [5].
- 2) Remove bolts [10].
- 3) Remove bolts [11].

- (b) Remove heatshield No. 3 [27]:

- 1) Remove bolts [5].
- 2) Remove bolts [10].
- 3) Remove bolts [11].

**LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 PRE SB 737-54-1047; AIRPLANES WITH
HEATSHIELDS WITH PLUME SUPPRESSOR ATTACHED**

- 4) Remove bolt [41].
- 5) Remove bolt [42].

LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 PRE SB 737-54-1047

- (c) Remove heatshield No. 2 [26]:

- 1) Remove bolts [5].
- 2) Remove bolts [10].
- 3) Remove bolts [11].

**LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 PRE SB 737-54-1047; AIRPLANES WITH
HEATSHIELDS WITH PLUME SUPPRESSOR ATTACHED**

- 4) Remove bolts [41].
- 5) Remove bolts [42].

LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 PRE SB 737-54-1047

EFFECTIVITY
LOM ALL

54-52-08



**737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL**

LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 PRE SB 737-54-1047 (Continued)

- (d) Remove heatshield No. 1 [25] and heatshield No. 5 [29] (forward end):
 - 1) Remove bolts [5].
 - 2) Remove bolts [10].
 - 3) Remove bolts [11].

LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 PRE SB 737-54-1047; AIRPLANES WITH HEATSHIELDS WITH PLUME SUPPRESSOR ATTACHED

- 4) Remove bolt [41].
- 5) Remove bolt [42].

LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 PRE SB 737-54-1047

- 6) Remove bolts [52] and collars [31], (SRM 51-40-02).
- 7) Remove rivets [53], (SRM 51-40-02).

LOM 427-434, 437-447, 450-999; LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 POST SB 737-54-1047

G. Aft Fairing Heatshield and Insulation Blankets Removal

SUBTASK 54-52-08-010-011

- (1) Remove the heatshields and insulation blankets from the aft fairing in this sequence (aft to forward) (Figure 402):

NOTE: Heatshield No. 1 - 3 have a plume suppressor attached. The heatshield should be removed with plume suppressor attached.

- (a) Remove heatshield No. 4 [35] (aft end):
 - 1) Remove bolts [5].
 - 2) Remove bolts [10].
 - 3) Remove bolts [11].

- (b) Remove heatshield No. 3 [34] with plume suppressor:

NOTE: There is a sleeve of insulation which should stay attached to the drain. Do not try to remove it. The other pieces of insulation may be removed.

- 1) Remove bolts [5].
- 2) Remove bolts [10].
- 3) Remove bolts [11].
- 4) Remove bolt [41].
- 5) Remove bolt [42].

- (c) Remove heatshield No. 2 [33] with plume suppressor:

- 1) Remove bolts [5].
- 2) Remove bolts [10].
- 3) Remove bolts [11].
- 4) Remove bolts [41].
- 5) Remove bolts [42].

- (d) Remove heatshield No. 1 [32] with plume suppressor (forward end):

- 1) Remove bolts [5].

EFFECTIVITY
LOM ALL

54-52-08



**737-600/700/800/900
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**LOM 427-434, 437-447, 450-999; LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 POST SB
737-54-1047 (Continued)**

- 2) Remove bolt [10].
- 3) Remove bolts [11].
- 4) Remove bolts [30].
- 5) Remove bolt [41].
- 6) Remove bolt [42].
- 7) Remove bolts [51].

SUBTASK 54-52-08-010-013

- (2) Remove the insulation blankets in this sequence (aft to forward) (Figure 402):
 - (a) Remove insulation blanket [40] (aft end):
 - 1) Remove bolts [54], washers [43], washers [50], washers [44], and nuts [16].
 - 2) Remove bolts [54], washers [43], washers [50], washers [58], and nuts [16].
 - (b) Remove insulation blanket [39]:
 - 1) Remove bolts [54], washers [43], washers [50], washers [44], and nuts [16].
 - 2) Remove bolts [57], washers [45], washers [50], washers [46], and nuts [47].
 - (c) Remove insulation blanket [38] (forward end):
 - 1) Remove bolts [54], washers [43], washers [50], washers [44], and nuts [16].
 - 2) Remove bolts [54], washers [43], washers [50], washers [49], and nuts [16].
 - 3) Remove bolts [55], washers [45], washers [50], washers [46], and nuts [47].
 - 4) Remove bolts [56], washers [45], washers [50], washers [46], and nuts [47].
 - 5) Remove bolts [57], washers [45], washers [50], washers [46], and nuts [47].

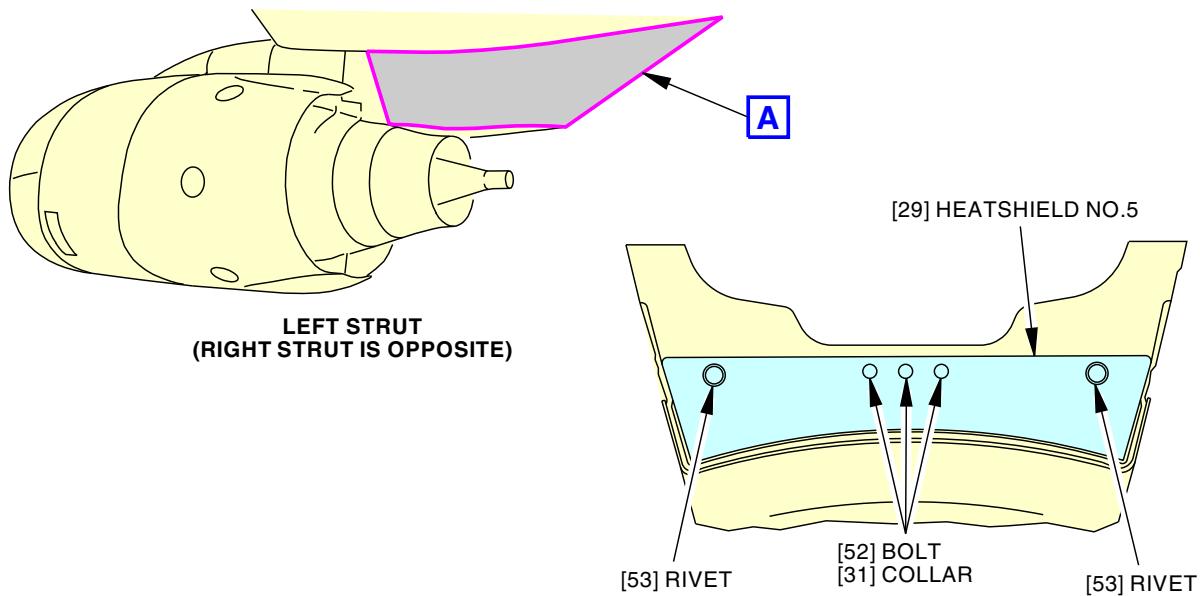
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EFFECTIVITY
LOM ALL

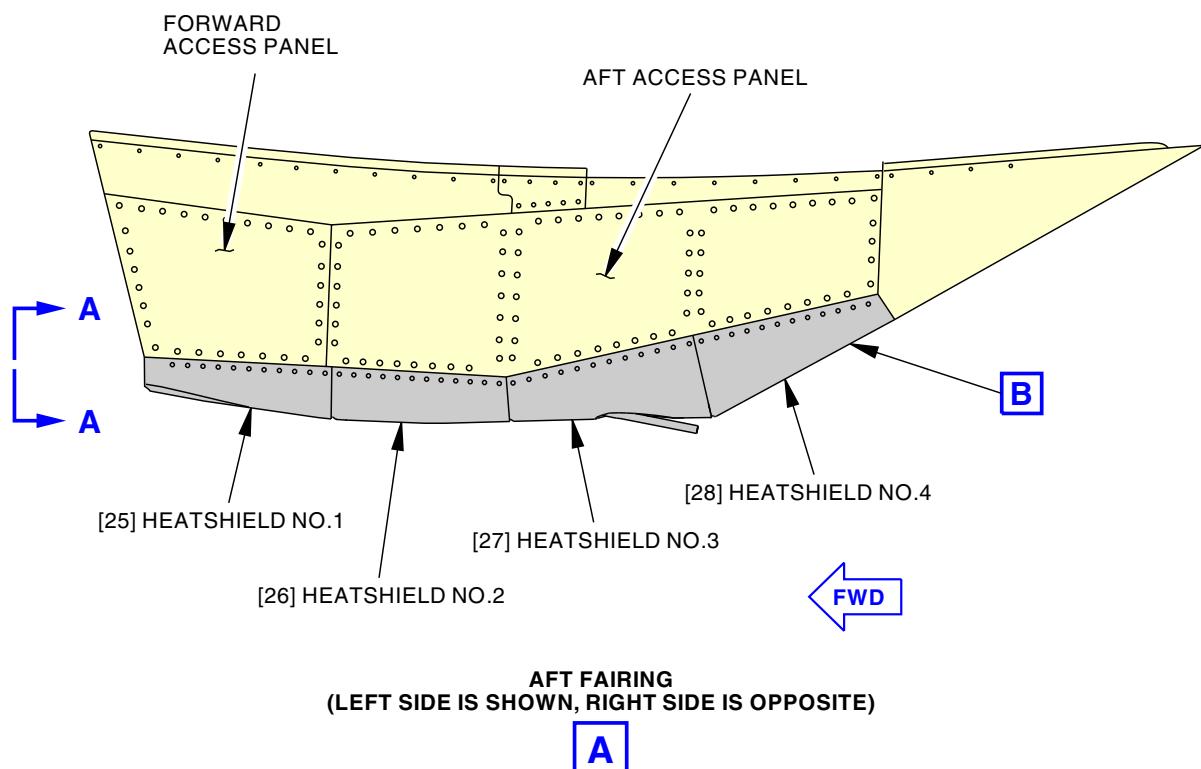
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737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL



A-A



1743018 S0000315220_V3

Heatshield Installation
Figure 401/54-52-08-990-807 (Sheet 1 of 4)

EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-54-1047

54-52-08

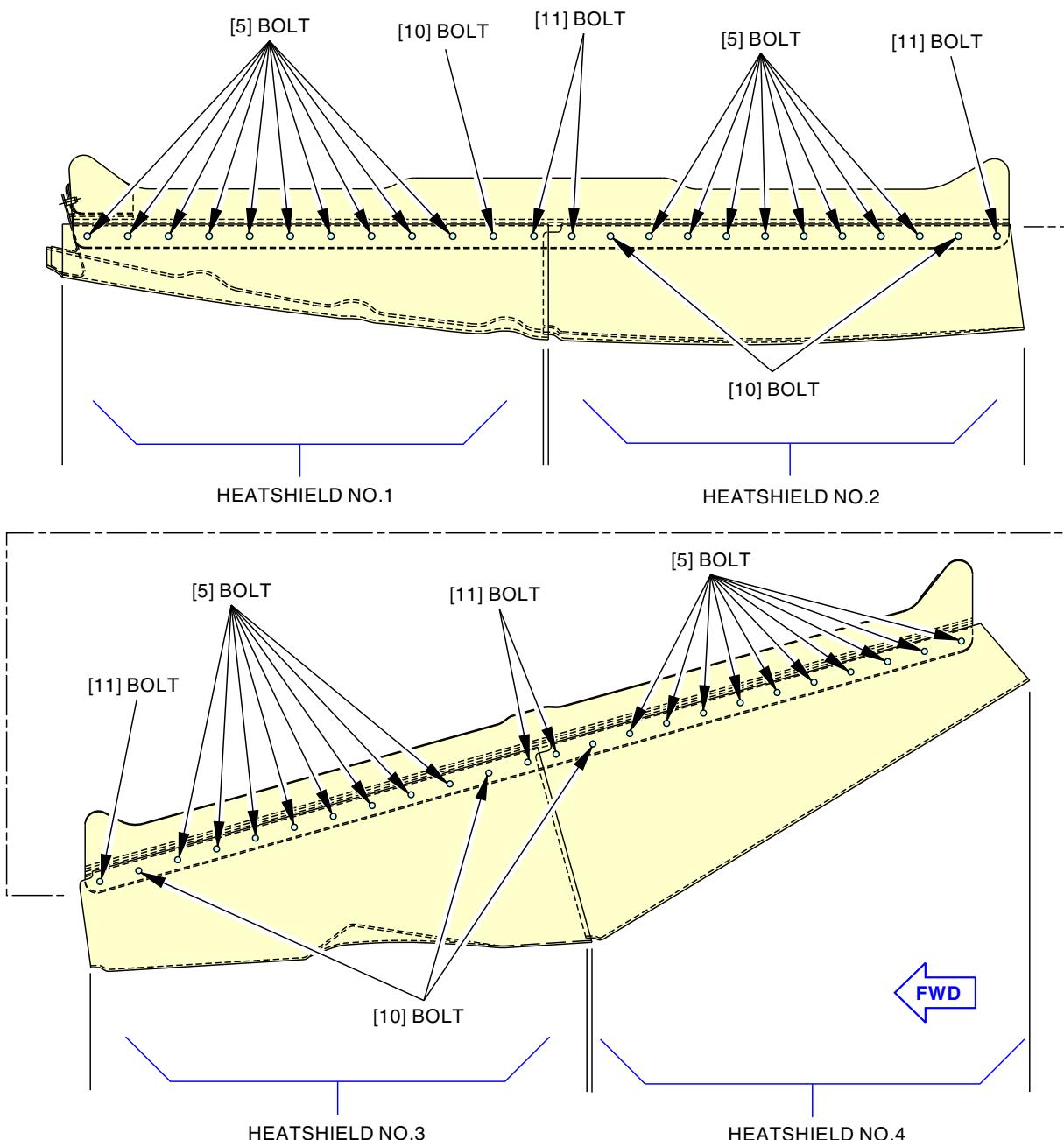
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL



OUTBOARD SIDE OF LEFT STRUT HEATSHIELD

B

1743047 S0000315221_V4

Heatshield Installation
Figure 401/54-52-08-990-807 (Sheet 2 of 4)

EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-54-1047

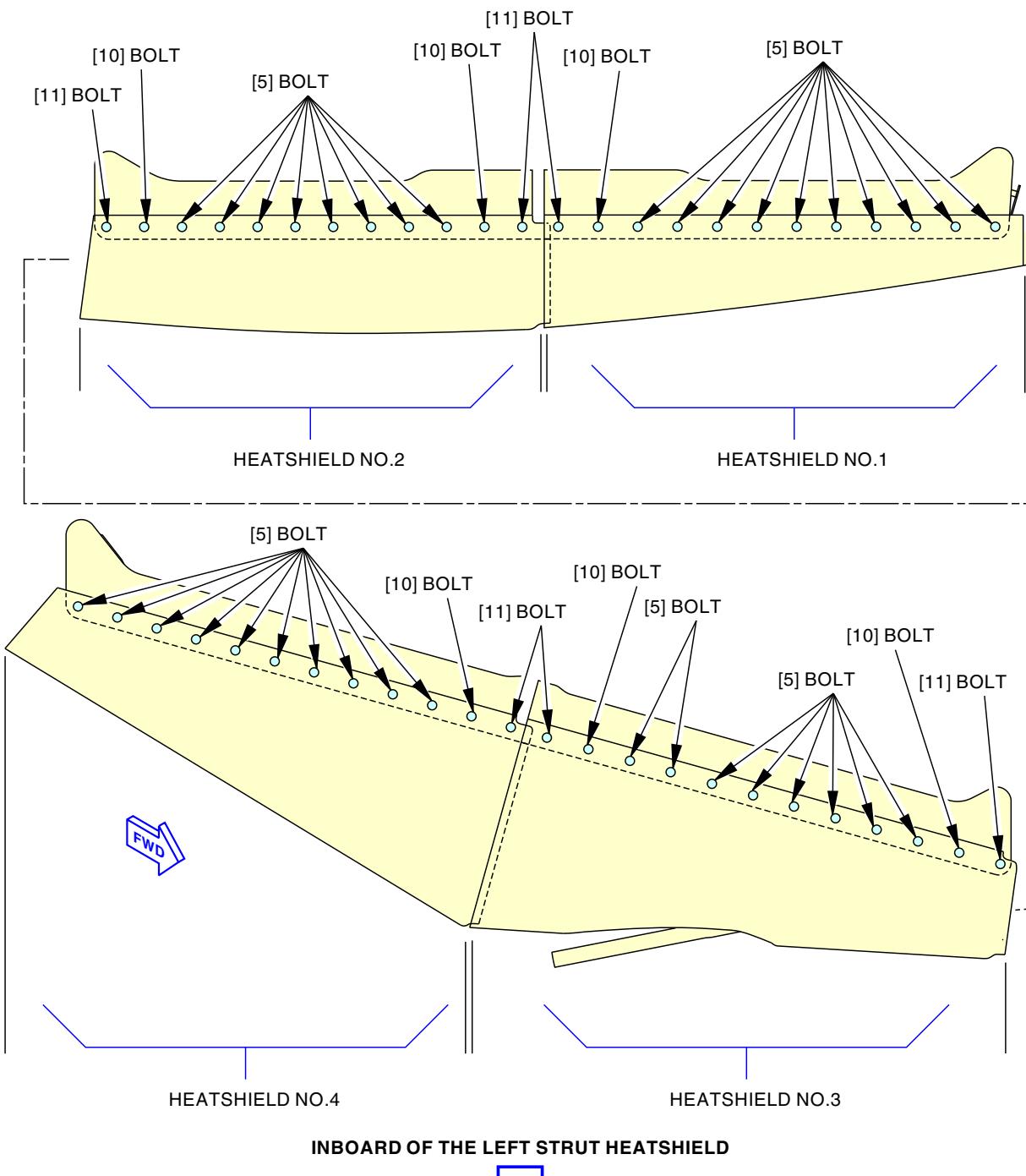
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ECCN 9E991 BOEING PROPRIETARY - See title page for details



737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL



3045820 S0000812478_V1

Heatshield Installation
Figure 401/54-52-08-990-807 (Sheet 3 of 4)

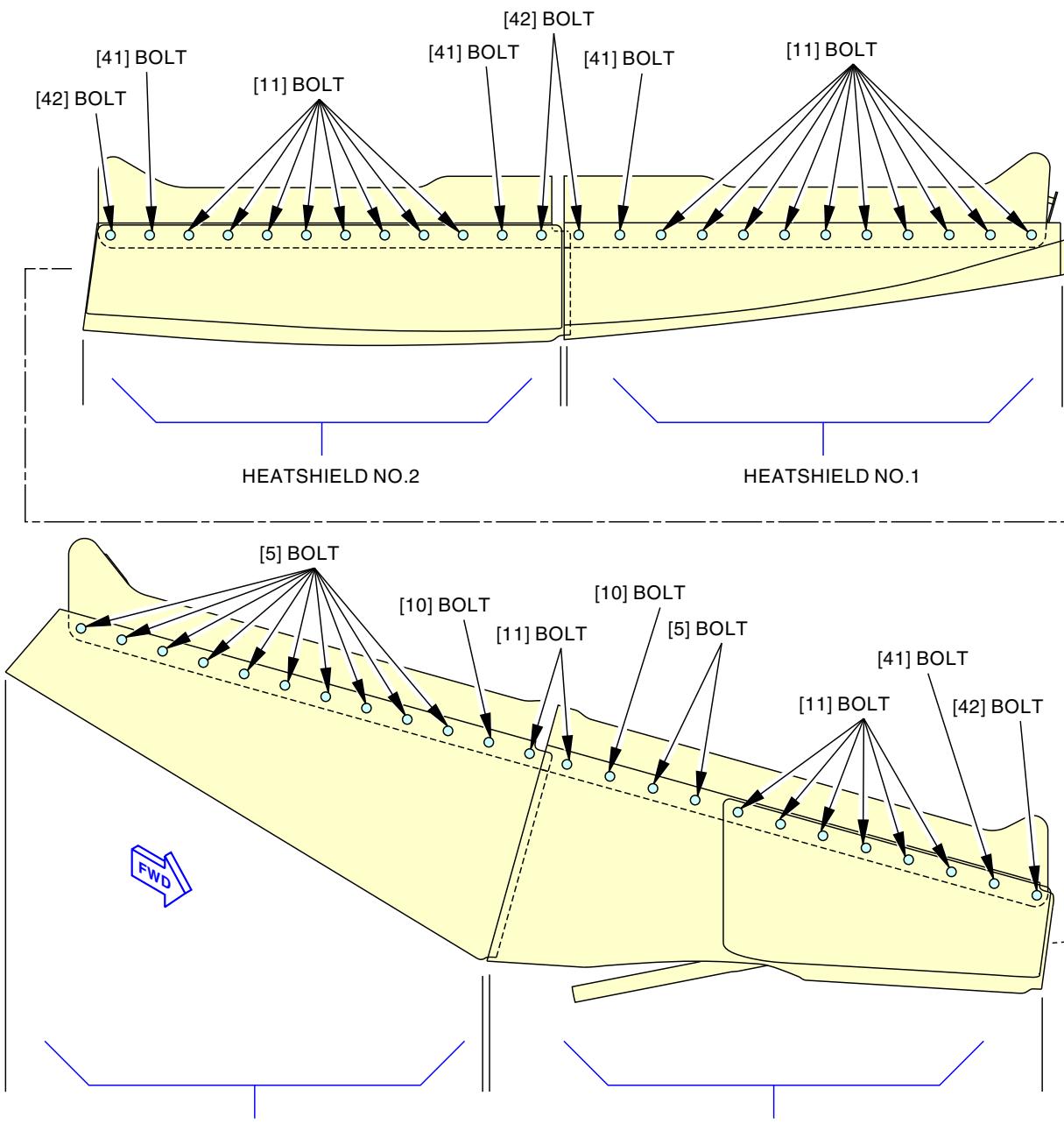
EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-54-1047; AIRPLANES WITH
HEATSHIELDS AND WITHOUT PLUME
SUPPRESSOR ATTACHED

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

54-52-08

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**INBOARD OF THE LEFT STRUT HEATSHIELD
(PLUME SUPPRESSOR SHOWN)**

B

3021694 S0000793529_V2

Heatshield Installation
Figure 401/54-52-08-990-807 (Sheet 4 of 4)

EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-54-1047; AIRPLANES WITH
HEATSHIELDS WITH PLUME SUPPRESSOR
ATTACHED

D633A101-LOM

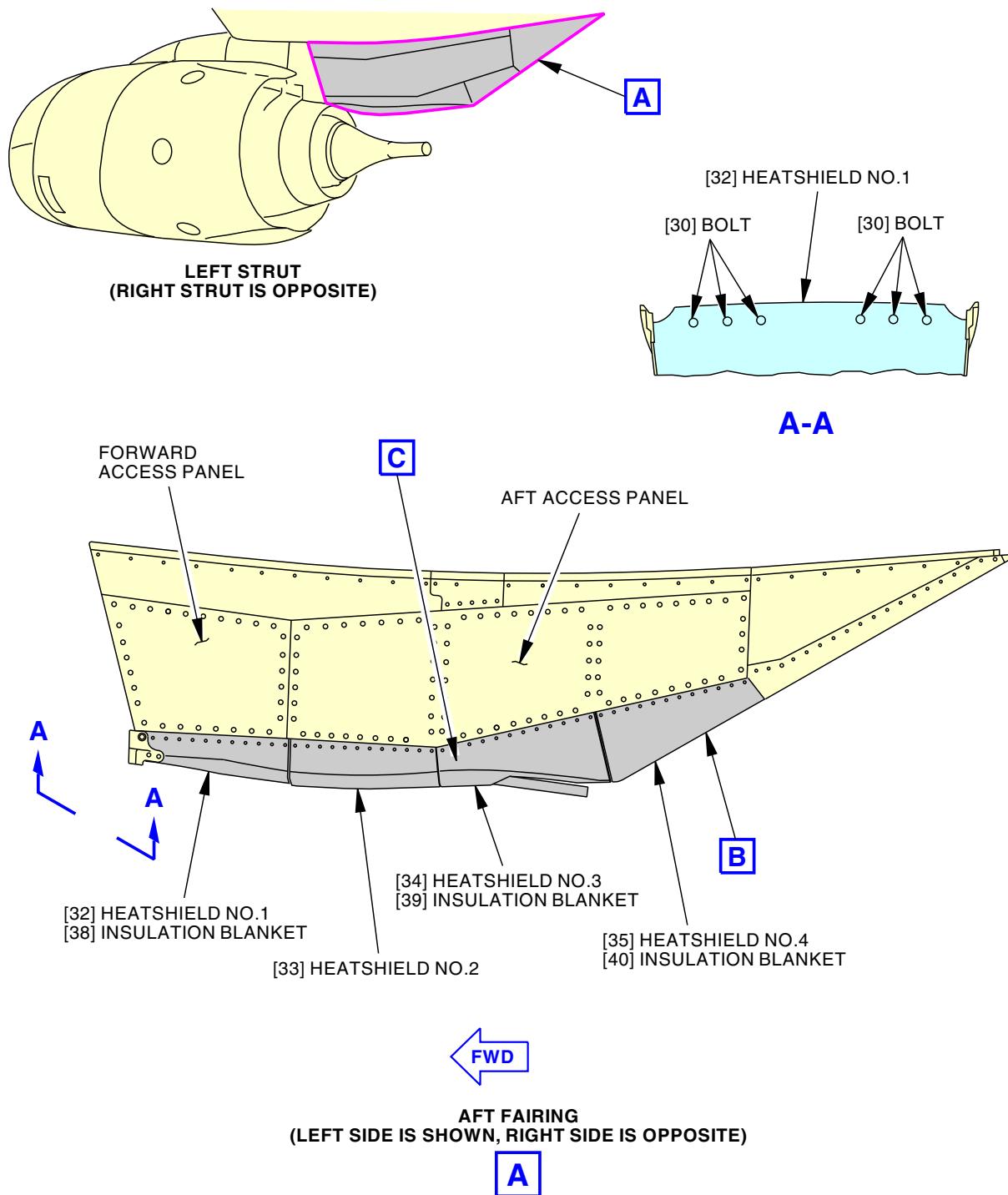
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AIRCRAFT MAINTENANCE MANUAL



2098757 S0000443823_V4

Heatshield and Insulation Blankets Installation
Figure 402/54-52-08-990-808 (Sheet 1 of 5)

EFFECTIVITY
LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
407, 411, 412, 415, 416, 420, 422-426 POST SB
737-54-1047

54-52-08

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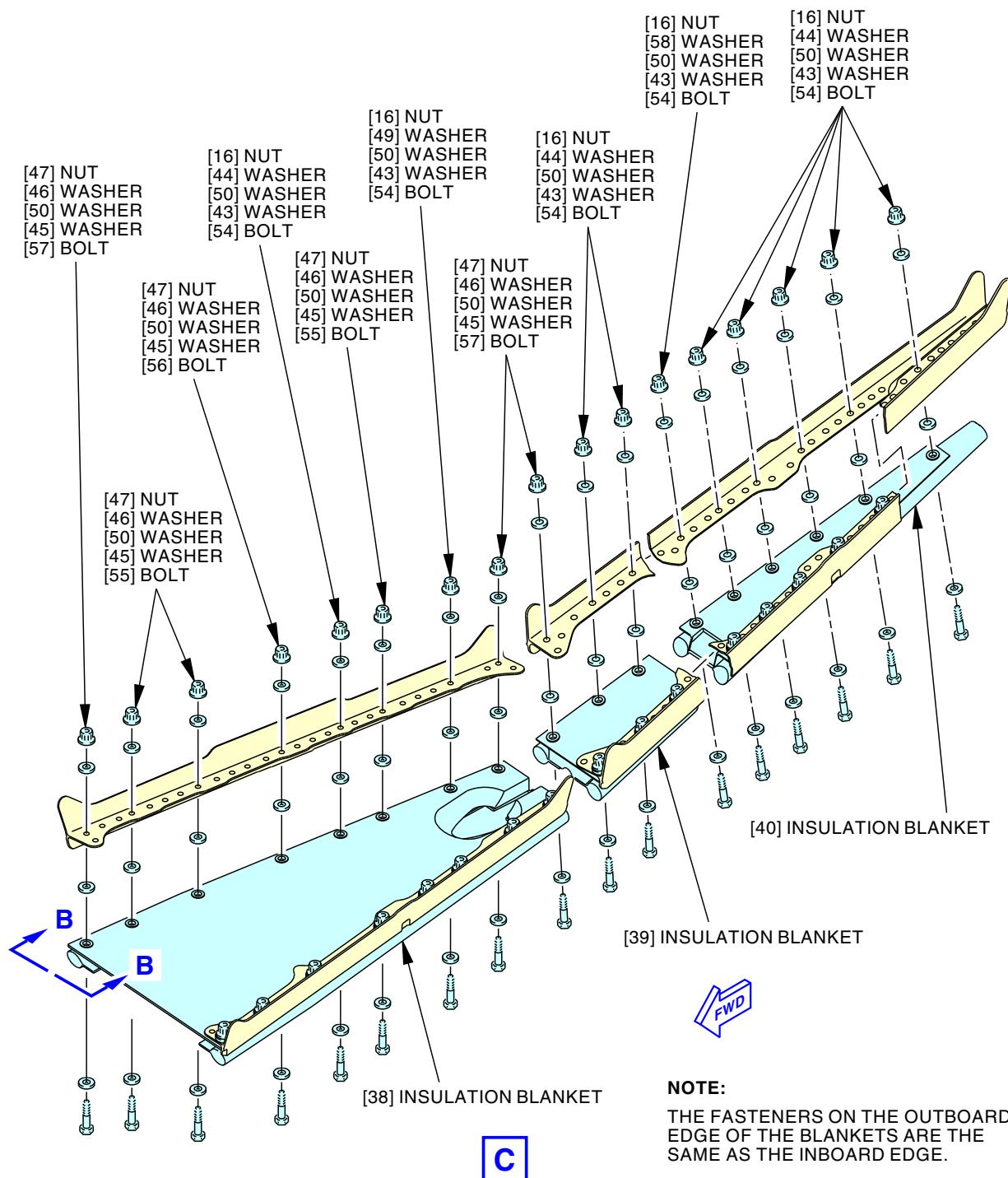
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737-600/700/800/900

AIRCRAFT MAINTENANCE MANUAL



NOTE:

THE FASTENERS ON THE OUTBOARD EDGE OF THE BLANKETS ARE THE SAME AS THE INBOARD EDGE.

3021859 S0000793546 V2

Heatshield and Insulation Blankets Installation Figure 402/54-52-08-990-808 (Sheet 2 of 5)

EFFECTIVITY
**LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
407, 411, 412, 415, 416, 420, 422-426 POST SB
737-54-1047**

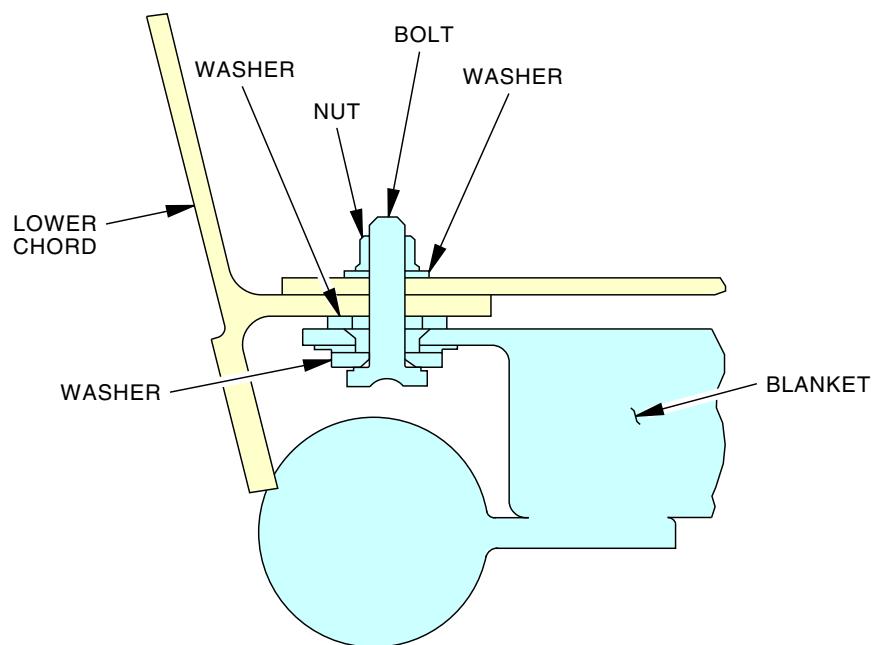
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AIRCRAFT MAINTENANCE MANUAL



B-B

3022258 S0000794362_V2

Heatshield and Insulation Blankets Installation
Figure 402/54-52-08-990-808 (Sheet 3 of 5)

EFFECTIVITY
LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
407, 411, 412, 415, 416, 420, 422-426 POST SB
737-54-1047

54-52-08

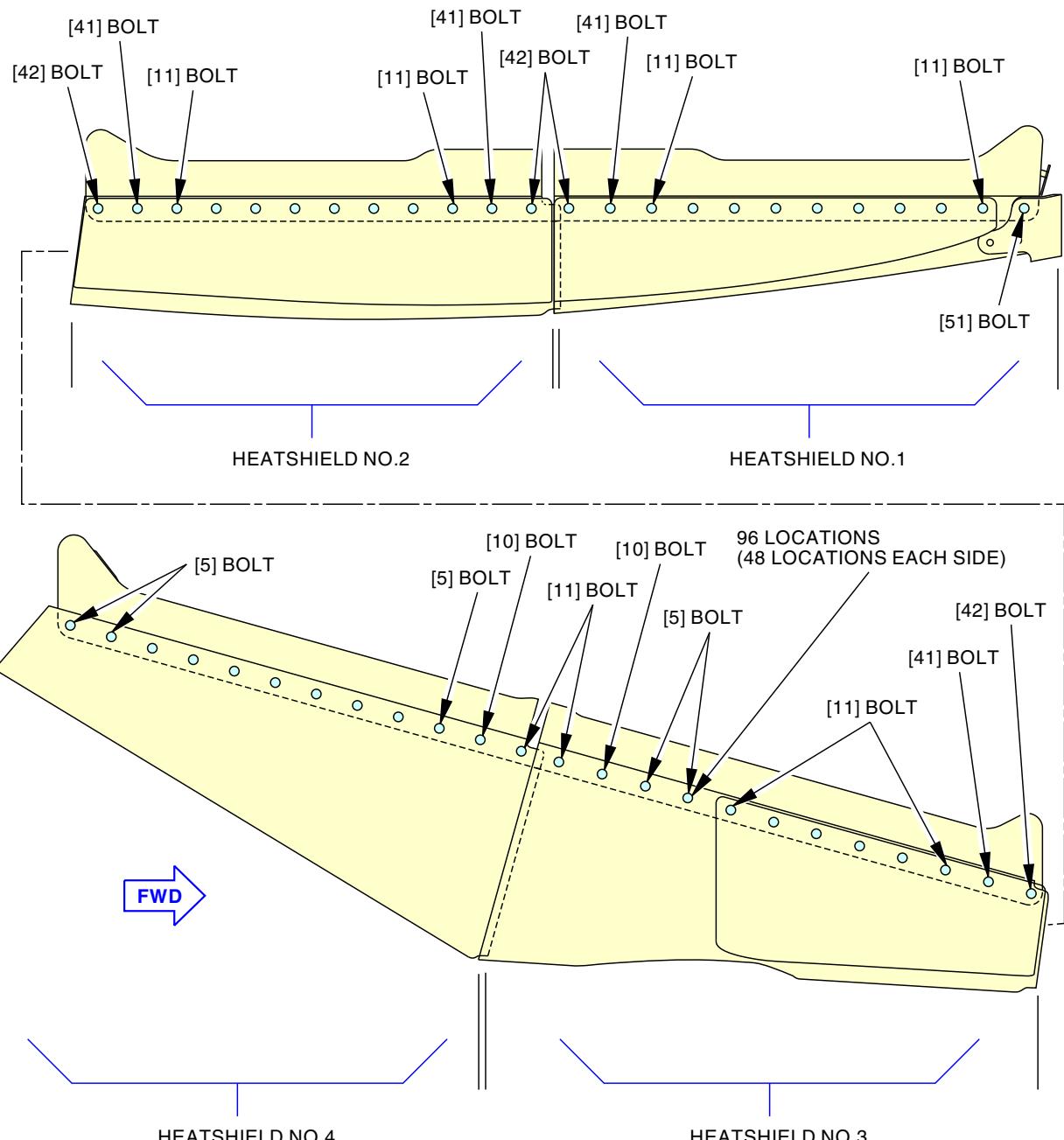
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ECCN 9E991 BOEING PROPRIETARY - See title page for details



737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL



INBOARD OF THE LEFT STRUT HEATSHIELD
(PLUME SUPPRESSOR SHOWN)

B

3021851 S0000792151_V2

Heatshield and Insulation Blankets Installation
Figure 402/54-52-08-990-808 (Sheet 4 of 5)

EFFECTIVITY
LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
407, 411, 412, 415, 416, 420, 422-426 POST SB
737-54-1047

54-52-08

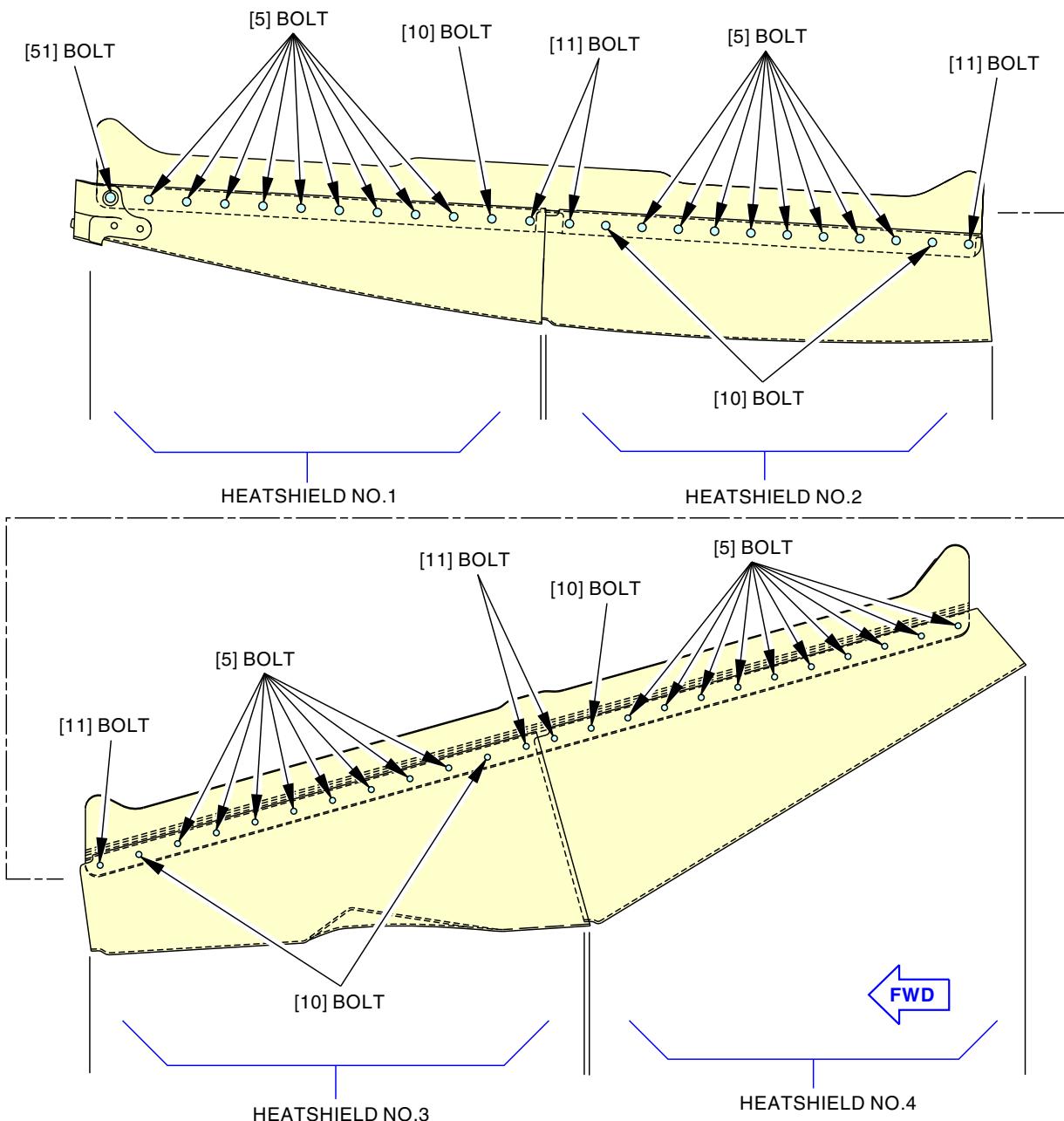
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D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details



737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL



OUTBOARD OF THE LEFT STRUT HEATSHIELD

B

2098919 S0000443851_V4

Heatshield and Insulation Blankets Installation
Figure 402/54-52-08-990-808 (Sheet 5 of 5)

EFFECTIVITY
LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
407, 411, 412, 415, 416, 420, 422-426 POST SB
737-54-1047

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TASK 54-52-08-010-802

3. Aft Fairing Heatshield Installation

A. General

- (1) This task gives the instructions on how to install the heatshield assembly onto the strut aft fairing.

**LOM 427-434, 437-447, 450-999; LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 POST SB
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- (2) There are insulation blankets inside the heatshield sections.

LOM ALL

B. References

Reference	Title
27-51-00-440-801	Trailing Edge Flap System Reactivation (P/B 201)
54-51-01-440-801	Put the Strut Back to its Usual Condition (P/B 201)
54-52-06-410-801	Aft Fairing Access Panel Installation (P/B 401)
78-11-01-400-802-F00	Primary Nozzle Assembly Installation (P/B 401)
SRM 51-40-02	Structural Repair Manual

C. Consumable Materials

Reference	Description	Specification
A00803	Sealant - Firewall - Hydraulic Fluid Resistant	BMS5-63 Type I
A50096	Sealant - Firewall - Hydraulic Fluid Resistant	BMS5-63 Type II

D. Expendables/Parts

AMM Item	Description	AIPC Reference	AIPC Effectivity
25	Heatshield No. 1	54-52-08-01-065	LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426
		54-52-08-03-130	LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426
		54-52-08-04-130	LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426
26	Heatshield No. 2	54-52-08-01-070	LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426
		54-52-08-03-190	LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426
		54-52-08-04-190	LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426
27	Heatshield No. 3	54-52-08-01-075	LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426



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(Continued)

AMM Item	Description	AIPC Reference	AIPC Effectivity
27 (cont.)		54-52-08-03-220	LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426
		54-52-08-04-220	LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426
28	Heatshield No. 4	54-52-08-01-080	LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426
		54-52-08-03-125	LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426
		54-52-08-04-125	LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426

E. Location Zones

Zone	Area
434	Engine 1 - Aft Strut Fairing
444	Engine 2 - Aft Strut Fairing

F. 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

LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 PRE SB 737-54-1047

G. Aft Fairing Heatshield Installation

SUBTASK 54-52-08-400-002

(1) Install the heatshields into the aft fairing in this sequence (forward to aft) (Figure 401):

(a) Install heatshield No. 1 [25] assembly (forward end):

NOTE: heatshield No. 5 [29] is attached to heatshield No. 1 [25].

1) Apply the sealant, A00803 to the mating surfaces of the heatshield No. 5 [29] and the aft fairing frame.

2) Install heatshield No. 1 [25] assembly:

a) Install bolts [5].

b) Install bolts [10].

c) Install bolts [11].

LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 PRE SB 737-54-1047; AIRPLANES WITH HEATSHIELDS WITH PLUME SUPPRESSOR ATTACHED

d) Install bolt [41].

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LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 PRE SB 737-54-1047; AIRPLANES WITH HEATSHIELDS WITH PLUME SUPPRESSOR ATTACHED (Continued)

- e) Install bolt [42].

LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 PRE SB 737-54-1047

- f) Apply sealant, A00803 to bolts [52].
- g) Install bolts [52] and collars [31], (SRM 51-40-02).
- h) Install rivets [53], (SRM 51-40-02).

- (b) Install heatshield No. 2 [26] assembly:

- 1) Install bolts [5].
- 2) Install bolts [10].
- 3) Install bolts [11].

LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 PRE SB 737-54-1047; AIRPLANES WITH HEATSHIELDS WITH PLUME SUPPRESSOR ATTACHED

- 4) Install bolts [41].
- 5) Install bolts [42].

LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 PRE SB 737-54-1047

- (c) Install heatshield No. 3 [27] assembly:
 - 1) Install bolts [5].
 - 2) Install bolts [10].
 - 3) Install bolts [11].

LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 PRE SB 737-54-1047; AIRPLANES WITH HEATSHIELDS WITH PLUME SUPPRESSOR ATTACHED

- 4) Install bolt [41].
- 5) Install bolt [42].

LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 PRE SB 737-54-1047

- (d) Install heatshield No. 4 [28] (aft end):
 - 1) Install bolts [5].
 - 2) Install bolts [10].
 - 3) Install bolts [11].

LOM 427-434, 437-447, 450-999; LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 POST SB 737-54-1047

H. Aft Fairing Heatshield and Insulation Blankets Installation

SUBTASK 54-52-08-400-004

- (1) Install the insulation blankets into the aft fairing in this sequence (forward to aft) (Figure 402):
 - (a) Install insulation blanket [38] (forward end):
 - 1) Apply the sealant, A50096 to the mating surfaces of the insulation blanket [38] and lower chord.
 - 2) Apply the sealant, A50096 to the inside of the holes.
 - 3) Install insulation blanket [38]:
 - a) Install bolts [54], washers [43], washers [50], washers [44], and nuts [16].

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**LOM 427-434, 437-447, 450-999; LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 POST SB
737-54-1047 (Continued)**

- b) Install bolts [54], washers [43], washers [50], washers [49], and nuts [16].
- c) Install bolts [55], washers [45], washers [50], washers [46], and nuts [47].
- d) Install bolts [56], washers [45], washers [50], washers [46], and nuts [47].
- e) Install bolts [57], washers [45], washers [50], washers [46], and nuts [47].
- 4) Apply a fillet seal with sealant, A50096 to the nuts and washers for the top side only.
- (b) Install insulation blanket [39]:
 - 1) Apply the sealant, A50096 to the mating surfaces of the insulation blanket [39] and lower chord.
 - 2) Apply the sealant, A50096 to the inside of the holes.
 - 3) Install insulation blanket [39]:
 - a) Install bolts [54], washer [43], washers [50], washer [44], and nuts [16].
 - b) Install bolts [57], washer [45], washers [50], washer [46], and nut [47].
 - 4) Apply a fillet seal with sealant, A50096 to the nuts and washers for the top side only.
- (c) Install insulation blanket [40] (aft end):
 - 1) Apply the sealant, A50096 to the mating surfaces of the insulation blanket [40] and lower chord.
 - 2) Apply the sealant, A50096 to the inside of the holes.
 - 3) Install insulation blanket [40]:
 - a) Install bolts [54], washers [43], washers [50], washers [44], and nuts [16].
 - b) Install bolt [54], washer [43], washer [50], washer [58], and nut [16].
 - 4) Apply a fillet seal with sealant, A50096 to the nuts and washers for the top side only.

SUBTASK 54-52-08-400-005

- (2) Install the heatshields into the aft fairing in this sequence (forward to aft) (Figure 402):

NOTE: Heatshield No. 1 - 3 have a plume suppressor attached.

- (a) Install heatshield No. 1 [32] assembly (forward end):

NOTE: The heatshield No. 5 [36] and the heatshield No. 1 [32] are attached and installed together (Figure 402).

- 1) Install bolts [5].
- 2) Install bolts [10].
- 3) Install bolts [11].
- 4) Install bolt [41].
- 5) Install bolt [42].
- 6) Install bolts [30].
- 7) Install bolts [51].

- (b) Install heatshield No. 2 [33] assembly:

- 1) Install bolts [5].
- 2) Install bolts [10].
- 3) Install bolts [11].

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**LOM 427-434, 437-447, 450-999; LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 POST SB
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- 4) Install bolts [41].
 - 5) Install bolts [42].
- (c) Install heatshield No. 3 [34] assembly:
- 1) Install bolts [5].
 - 2) Install bolts [10].
 - 3) Install bolts [11].
 - 4) Install bolt [41].
 - 5) Install bolt [42].
- (d) Install heatshield No. 4 [35] (aft end):
- 1) Install bolts [5].
 - 2) Install bolts [10].
 - 3) Install bolts [11].

LOM ALL

I. Put the Strut Back to its Usual Condition

SUBTASK 54-52-08-410-001

- (1) Install the applicable aft fairing access panels:
(TASK 54-52-06-410-801)

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

**LOM 427-434, 437-447, 450-999; LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 POST SB
737-54-1047 OR POST SB 737-78-1089**

SUBTASK 54-52-08-400-006

- (2) Do this task: Primary Nozzle Assembly Installation, TASK 78-11-01-400-802-F00.

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SUBTASK 54-52-08-440-002

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

SUBTASK 54-52-08-040-004

- (4) Do this task: Put the Strut Back to its Usual Condition, TASK 54-51-01-440-801.

———— END OF TASK ————

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LEADING EDGE GAP COVERS - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) A removal of the leading edge gap covers
 - (2) An installation of the leading edge gap covers
 - (3) Aerodynamic Smoothness Requirements for the leading edge gap covers.

TASK 54-52-09-000-801

2. Leading Edge Gap Covers Removal

(Figure 401)

A. General

- (1) This task is the removal procedure for the following gap covers:
 - (a) Inboard leading edge gap cover.
 - (b) Outboard leading edge gap cover.
- (2) Each strut has one inboard leading edge gap cover and one outboard leading edge gap cover.

B. 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

C. Access Panels

Number	Name/Location
511BT	Fairing
521AT	Outbd Leading Edge - Gap Cover Access
611BT	Fairing
621AT	Outbd Leading Edge - Gap Cover Access

D. Procedure

SUBTASK 54-52-09-010-001

- (1) Remove the bolts [2] and the bolts [1] from the applicable gap cover, and do this step:
Open the applicable access panels:

Number	Name/Location
511BT	Fairing
611BT	Fairing

SUBTASK 54-52-09-000-001

- (2) Remove the bolts [3] from the applicable gap cover, and do this step:
Open the applicable access panels:

Number	Name/Location
521AT	Outbd Leading Edge - Gap Cover Access
621AT	Outbd Leading Edge - Gap Cover Access

———— END OF TASK ————

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TASK 54-52-09-400-801

3. Leading Edge Gap Cover Installation

(Figure 401)

A. General

- (1) This task is the installation procedure for the following gap covers:
 - (a) Inboard leading edge gap cover.
 - (b) Outboard leading edge gap cover.
- (2) Each strut has one inboard leading edge gap cover and one outboard leading edge gap cover.

B. Consumable Materials

Reference	Description	Specification
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

C. 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

D. Access Panels

Number	Name/Location
511BT	Fairing
521AT	Outbd Leading Edge - Gap Cover Access
611BT	Fairing
621AT	Outbd Leading Edge - Gap Cover Access

E. Procedure

SUBTASK 54-52-09-400-001

- (1) Install the applicable outboard leading edge gap cover:
 - (a) Put the applicable access panel into its position, do this step:

Install the applicable access panels:

Number	Name/Location
521AT	Outbd Leading Edge - Gap Cover Access
621AT	Outbd Leading Edge - Gap Cover Access

- (b) Install the bolts [3] for the gap covers by the following steps:

NOTE: Bolt grip length must match for each fastener hole.

- 1) Apply primer, C00259 to each countersunk hole.
- 2) Allow primer to dry before installing bolts [3].
- 3) Apply compound, C00528 to each countersunk hole and on the bolts [3].
- 4) Install each fastener immediately after applying compound, C00528.
- 5) Make sure that each bolt [3] is flush to the surrounding skin within +0.002 to -0.010 inch (+0.051 to -0.254 mm).

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SUBTASK 54-52-09-400-002

- (2) Install the applicable inboard leading edge gap cover:

- (a) Install the applicable access panels:

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

511BT	Fairing
-------	---------

611BT	Fairing
-------	---------

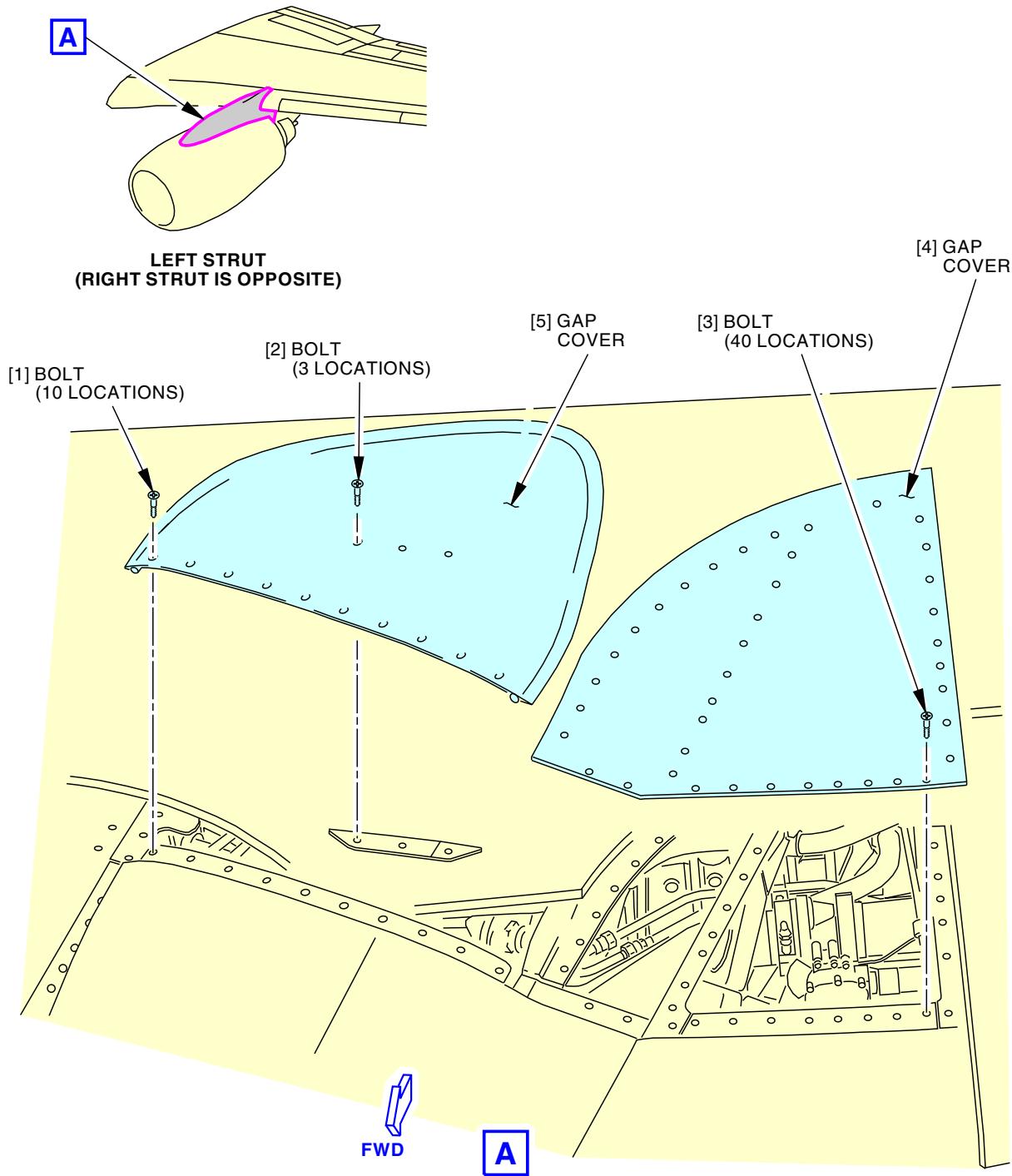
- (b) Install the bolts [2] and the bolts [1] for the gap covers by the following steps:

- 1) Apply primer, C00259 to each countersunk hole.
- 2) Allow primer to dry before installing bolts.
- 3) Apply compound, C00528 to each countersunk hole and on the bolts.
- 4) Install each fastener immediately after applying compound, C00528.
- 5) Make sure that each bolt is flush to the surrounding skin within +0.002 to -0.010 inch (+0.051 to -0.254 mm).
- 6) Check the fit and fair of the panel, do this task: Aerodynamic Smoothness Requirements for the Leading Edge Gap Covers., TASK 54-52-09-200-801

———— END OF TASK ————

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Leading Edge Gap Covers Installation
Figure 401/54-52-09-990-801

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TASK 54-52-09-200-801

4. Aerodynamic Smoothness Requirements for the Leading Edge Gap Covers.

Figure 401

A. General

- (1) This task gives the aerodynamic smoothness requirements for the inboard leading edge gap covers to permit smooth airflow. These covers are located in areas where aerodynamic smoothness is very important.

B. References

Reference	Title
54-51-01-040-801	Prepare the Strut for Maintenance Operations (P/B 201)
54-51-01-440-801	Put the Strut Back to its Usual Condition (P/B 201)
SRM 54-50-70	Structural Repair Manual

C. 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

D. Aerodynamic Smoothness Requirements

SUBTASK 54-52-09-040-001

- (1) Do this task: Prepare the Strut for Maintenance Operations, TASK 54-51-01-040-801.

SUBTASK 54-52-09-220-001

- (2) Do these steps to examine the clearance between the adjacent surfaces:
- Look for an unusually large clearance or a change in contour between adjacent surfaces.
 - The clearance between these surfaces must agree with the permitted tolerances.
 - Use the tolerances, in section A-A of Figure 402, to examine the clearance and misfair between the surfaces.

SUBTASK 54-52-09-220-002

- (3) If the measured value at any measurement location (KC points 1 thru 4) Figure 402 is greater than the indicated tolerances, find and convert all of the misfair (measured step) or clearance (gap) values into a net effect value (NEV).
- Calculate the NEV:
 - Use the Generic NEA Based Table 401.
 - Substitute the NEA values given in Figure 402 in the Generic NEA Based Table 401.
 - Calculate the net effect value at each point by using linear interpolation.Add all of the calculated NEV for misfair and all the NEV for clearance; those in tolerance and those that are not in the tolerance and divide the result by the total number of measurements.

Table 401/54-52-09-993-801 Generic NEA Based Table

Clearance (GAP width)		Misfair (step height)	
w (in)	NEV	h (in)	NEV

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Table 401/54-52-09-993-801 Generic NEA Based Table (Continued)

Clearance (GAP width)		Misfair (step height)	
0	0	-NEA	1.0
NEA	1	0	0
-	-	NEA	1.0

NOTE: The result is the total NEV for the interface.

- (b) Check the NEV result against net effect limit (NEL).
- 1) The NEL for the clearance (gap width) is 1.0. The NEL for the misfair (step height) is 1.5.
 - a) If the calculated NEV is less than or equal to the NEL, the surface clearance is aerodynamically acceptable.
 - b) If the calculated NEV is greater than the NEL, the clearance does not meet the aerodynamic smoothness requirements.
- (c) If it is necessary, repair the fairings to make the surfaces smooth, SRM 54-50-70.

SUBTASK 54-52-09-220-003

- (4) Do this task: Put the Strut Back to its Usual Condition, TASK 54-51-01-440-801.

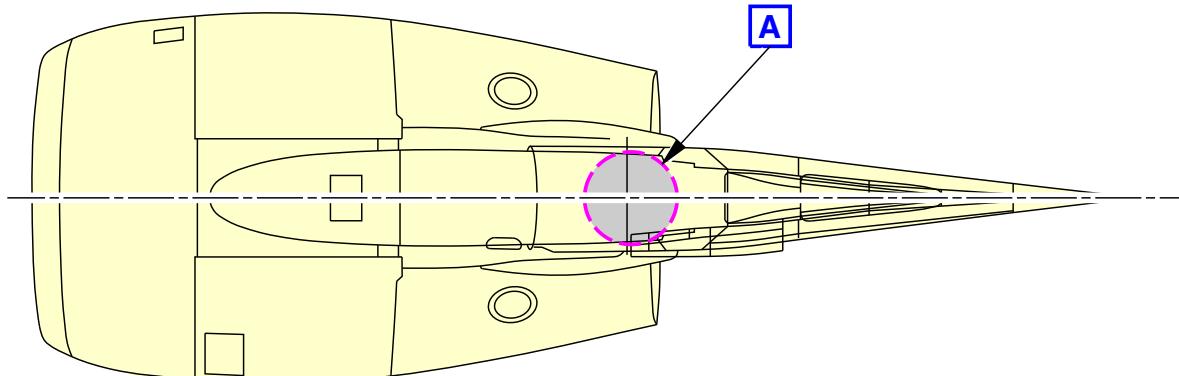
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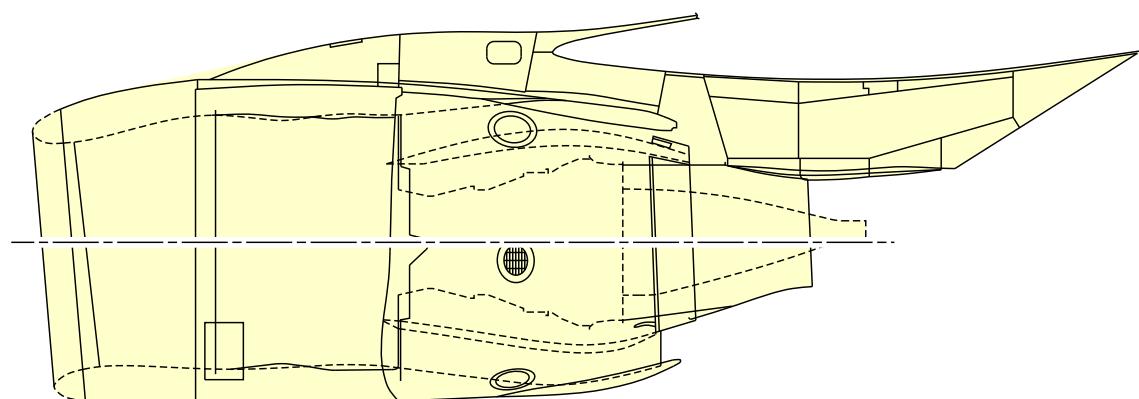
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TOP VIEW



SIDE VIEW

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Aerodynamic Smoothness Limits - Leading Edge Gap Covers
Figure 402/54-52-09-990-802 (Sheet 1 of 2)

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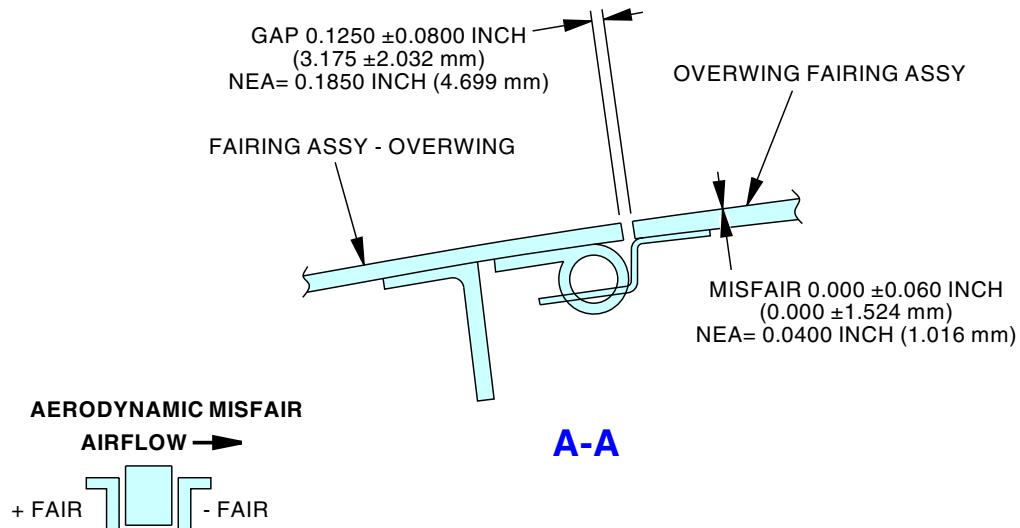
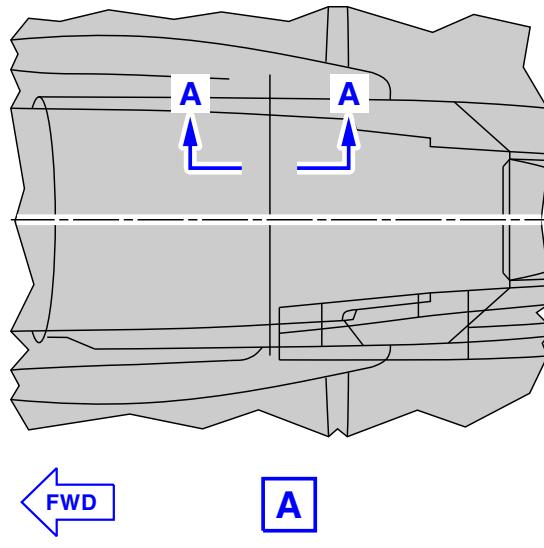
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LOCATION	CLEARANCE VALUES			MISFAIR VALUES		
	"KC"	CLEARANCE	NEV	"KC"	MISFAIR	NEV
1 INBD	1			1		
2 CTR INBD	2			2		
3 CTR OUTBD	3			3		
4 OUTBD	4			4		
CLEARANCE NEA			MISFAIR NEA			

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Aerodynamic Smoothness Limits - Leading Edge Gap Covers
Figure 402/54-52-09-990-802 (Sheet 2 of 2)

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STRUT ACCESS PANELS- REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
 - (1) A removal of the strut access panels
 - (2) An installation of the strut access panels.

TASK 54-53-01-000-801

2. Strut Access Panel Removal

(Figure 401)

A. General

- (1) This task gives the instructions for the removal of the strut access panels.
- (2) Each strut has six access panels.
 - (a) Four panels on each strut are located on the strut upper web:
 - 1) Forward upper web access panel [1], left strut.
 - 2) Forward upper web access panel [2], left strut.
 - 3) Aft upper web access panel [4] (2 panels), left strut.
 - 4) Forward upper web access panel [1], right strut.
 - 5) Forward upper web access panel [2], right strut.
 - 6) Aft upper web access panel [4] (2 panels), right strut.
 - (b) Two panels on each strut are located on the side of the strut, at the aft end:
 - 1) Left aft access panel [3], left strut.
 - 2) Right aft access panel [3], left strut.
 - 3) Left aft access panel [3], right strut.
 - 4) Right aft access panel [3], right strut.
- (3) Each panel has captive fasteners, but the fasteners can fall out if you loosen the latch bolts too much.

B. References

Reference	Title
54-51-01-040-801	Prepare the Strut for Maintenance Operations (P/B 201)
54-52-01-010-801	Forward Fairing Removal (P/B 401)
54-52-03-010-801	Wing Junction Fairing - Removal (P/B 401)
54-52-09-000-801	Leading Edge Gap Covers Removal (P/B 401)
54-53-02-000-802	Forward Strut Fairing Panel (Thrust Reverser Strut Fairing) Removal (P/B 401)

C. Tools/Equipment

Reference	Description
STD-765	Scraper - Plastic

D. Location Zones

Zone	Area
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

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E. Access Panels

<u>Number</u>	<u>Name/Location</u>
431BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 1
431BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 1
431CL	Forward Strut Fairing, Left Overwing Fairing, Strut 1
431CR	Forward Strut Fairing, Right Overwing Fairing, Strut 1
431EL	Forward Strut Fairing, Left T.R. Strut Fairing, Strut 1
431ER	Forward Strut Fairing, Right T.R. Strut Fairing, Strut 1
433AL	Strut, Left Aft Dry Bay, Strut 1
433AR	Strut, Right Aft Dry Bay, Strut 1
433AT	Strut, Forward Spar Web, Strut 1
433BT	Strut, Forward Spar Web, Strut 1
433CT	Strut, Upper Spar Web, Strut 1
433DT	Strut, Upper Spar Web, Strut 1
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
441EL	Forward Strut Fairing, Left T.R. Strut Fairing, Strut 2
441ER	Forward Strut Fairing, Right T.R. Strut Fairing, Strut 2
443AL	Strut, Left Aft Dry Bay, Strut 2
443AR	Strut, Right Aft Dry Bay, 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
521AT	Outbd Leading Edge - Gap Cover Access
621AT	Outbd Leading Edge - Gap Cover Access

F. Prepare for the Removal

SUBTASK 54-53-01-040-001

- (1) Do this task: Prepare the Strut for Maintenance Operations, TASK 54-51-01-040-801.

SUBTASK 54-53-01-010-001

- (2) To get access to the forward access panels [1] and access panels [2] located on the strut upper web, do this step:

- (a) Remove the applicable forward fairings:

(TASK 54-52-01-010-801)

Number Name/Location

431BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 1
431BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 1
441BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 2
441BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 2

SUBTASK 54-53-01-010-002

- (3) To get access to the aft access panels [4] located on the strut upper web, do these steps:

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- (a) Remove the applicable over wing fairings:

(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
441CL	Forward Strut Fairing, Left Overwing Fairing, Strut 2
441CR	Forward Strut Fairing, Right Overwing Fairing, Strut 2

- (b) Remove the applicable leading edge gap covers:

(TASK 54-52-09-000-801)

Number Name/Location

521AT	Outbd Leading Edge - Gap Cover Access
621AT	Outbd Leading Edge - Gap Cover Access

SUBTASK 54-53-01-010-003

- (4) To get access to the access panels [3] that are located on the side of the strut, do this step:

- (a) Remove the applicable thrust reverser fairings:

(TASK 54-53-02-000-802)

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
441EL	Forward Strut Fairing, Left T.R. Strut Fairing, Strut 2
441ER	Forward Strut Fairing, Right T.R. Strut Fairing, Strut 2

G. Strut Access Panel Removal

SUBTASK 54-53-01-020-001

- (1) Remove the strut access panel [3] located on the side of the strut as follows:

- (a) If it is necessary, remove fillet seal from around access panels with a plastic scraper, STD-765.



DO NOT USE POWER TOOLS TO DO THIS TASK. POWER TOOLS CAN CAUSE DAMAGE TO EQUIPMENT.



DO NOT CONTINUE TO LOOSEN THE LATCH BOLTS AFTER THE INDICATORS HAVE TURNED. IF YOU DO, THE LATCH BOLTS AND LATCH CAN FALL OUT.

- (b) Loosen the center bolt with a hand tool until the panel becomes loose.

- (c) Remove the strut access panel [3], do this step:

- 1) Open the applicable access panels:

Number Name/Location

433AL	Strut, Left Aft Dry Bay, Strut 1
433AR	Strut, Right Aft Dry Bay, Strut 1
443AL	Strut, Left Aft Dry Bay, Strut 2
443AR	Strut, Right Aft Dry Bay, Strut 2

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LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-432

SUBTASK 54-53-01-020-002

- (2) Remove the strut access panel [1], access panel [2], or access panel [4] located on the upper web as follows:
- (a) If it is necessary, remove fillet seal from around access panels with a plastic scraper, STD-765.



DO NOT USE POWER TOOLS TO DO THIS TASK. POWER TOOLS CAN CAUSE DAMAGE TO EQUIPMENT.



DO NOT CONTINUE TO LOOSEN THE LATCH BOLTS AFTER THE INDICATORS HAVE TURNED. IF YOU DO, THE LATCH BOLTS AND LATCH CAN FALL OUT.

- (b) Loosen the latch bolts with a hand tool until the slots in the indicators turn approximately 90 degrees counterclockwise from the closed position.
- (c) Remove the strut access panel [1], access panel [2], or access panel [4], do this step:

- 1) Open the applicable access panels:

Number **Name/Location**

433AT	Strut, Forward Spar Web, Strut 1
433BT	Strut, Forward Spar Web, Strut 1
433CT	Strut, Upper Spar Web, Strut 1
433DT	Strut, Upper Spar Web, Strut 1
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

LOM 433, 434, 437-447, 450-999

SUBTASK 54-53-01-020-003

- (3) Remove the strut access panel [1], access panel [2], or access panel [4] located on the upper web as follows:
- (a) If it is necessary, remove fillet seal from around access panels with a plastic scraper, STD-765.



DO NOT USE POWER TOOLS TO DO THIS TASK. POWER TOOLS CAN CAUSE DAMAGE TO EQUIPMENT.

- (b) Loosen the latch bolts approximately 0.5 in. (12.7 mm).

NOTE: This will open the latch sufficiently to remove the panel from the opening.

- (c) Remove the strut access panel [1], access panel [2], or access panel [4], do this step:
- 1) Open the applicable access panels:

Number **Name/Location**

433AT	Strut, Forward Spar Web, Strut 1
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LOM ALL

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LOM 433, 434, 437-447, 450-999 (Continued)

(Continued)

<u>Number</u>	<u>Name/Location</u>
433BT	Strut, Forward Spar Web, Strut 1
433CT	Strut, Upper Spar Web, Strut 1
433DT	Strut, Upper Spar Web, Strut 1
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

LOM ALL

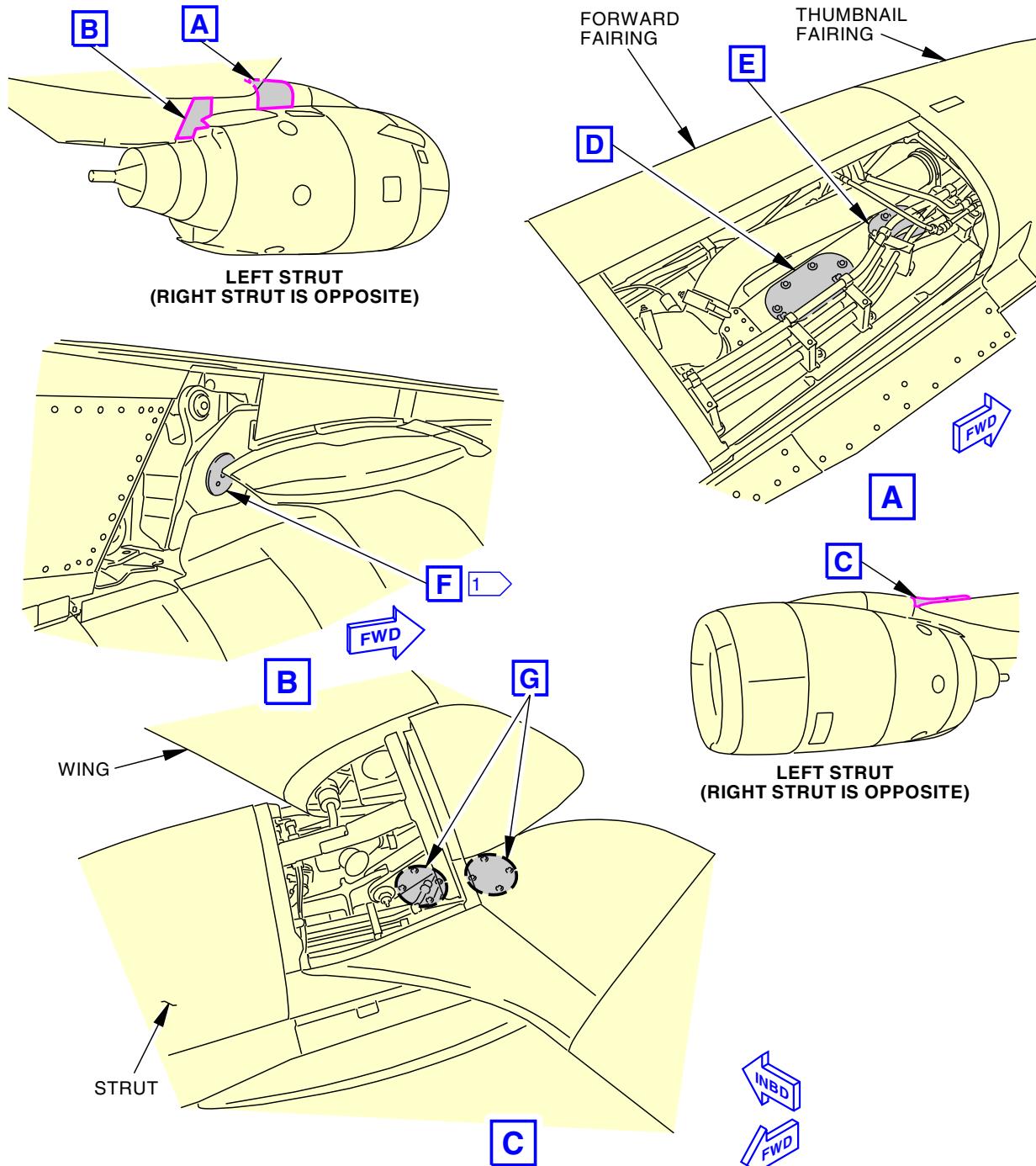
———— END OF TASK ————

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1 THE INBOARD ACCESS PANEL IS SHOWN,
THE OUTBOARD ACCESS PANEL IS OPPOSITE.

F37128 S0006581256_V3

**Strut Access Panel Installation
Figure 401/54-53-01-990-802 (Sheet 1 of 5)**

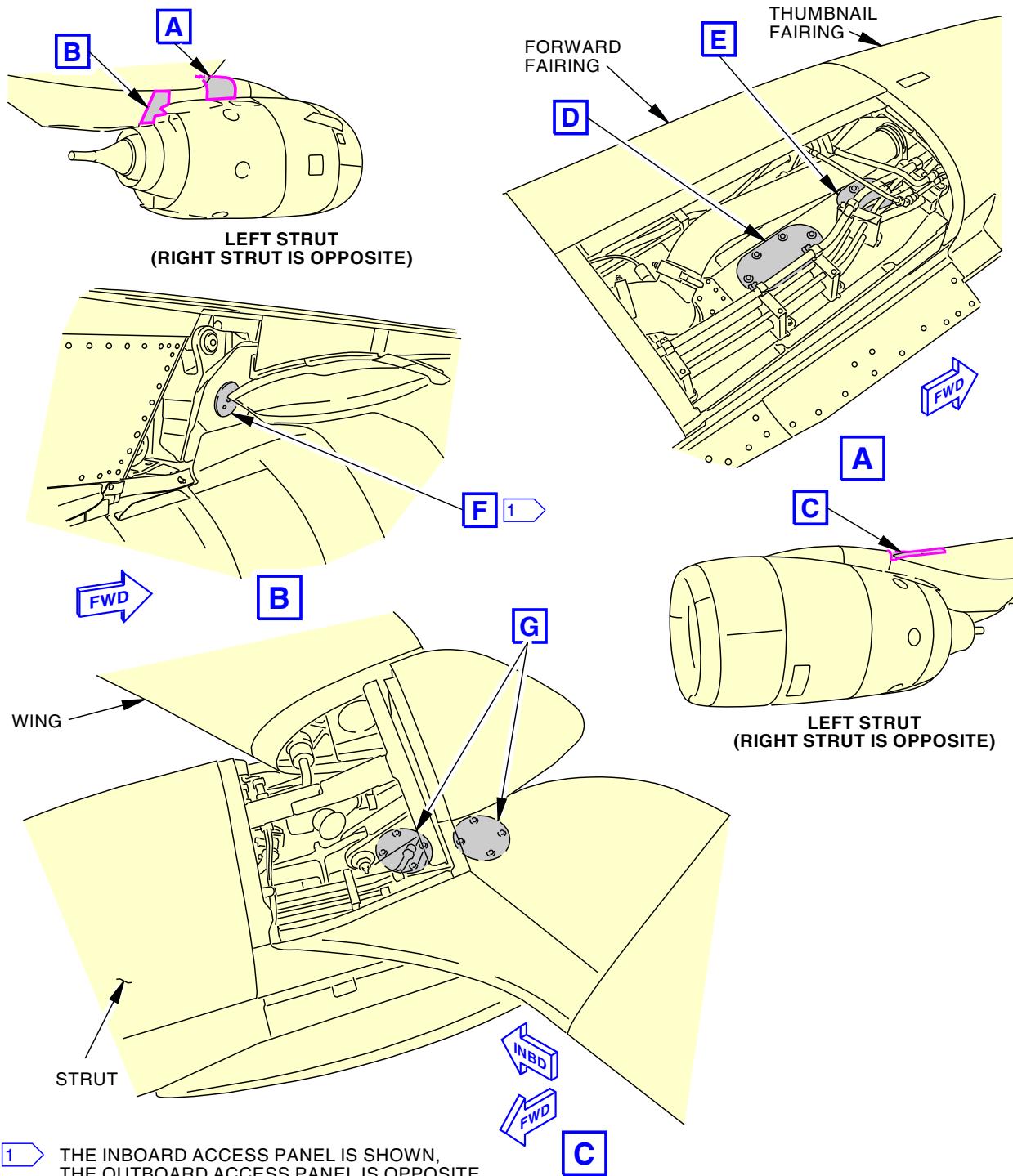
EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-78-1089

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

54-53-01

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1 THE INBOARD ACCESS PANEL IS SHOWN,
THE OUTBOARD ACCESS PANEL IS OPPOSITE.

2099612 S0000443854_V4

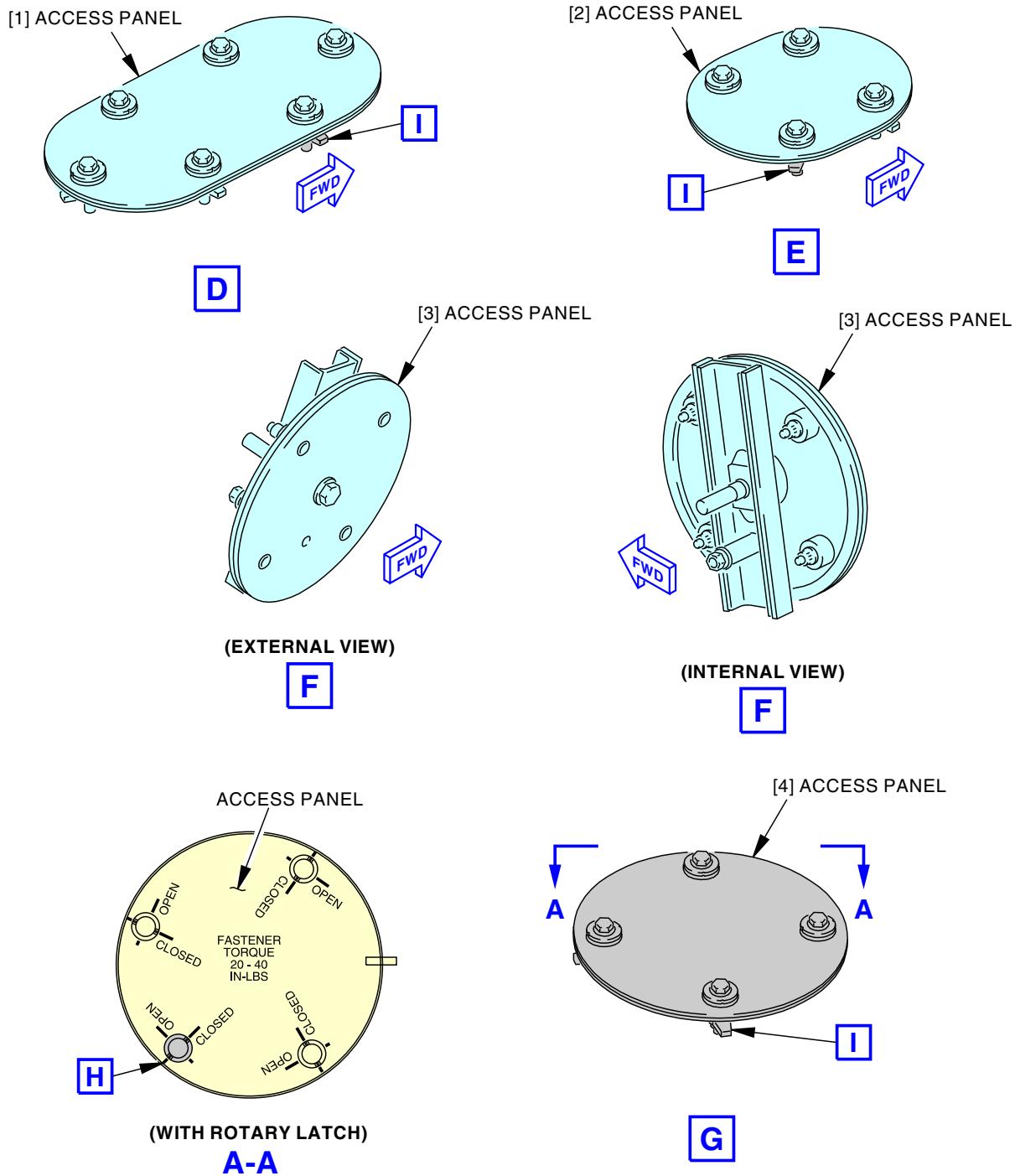
Strut Access Panel Installation
Figure 401/54-53-01-990-802 (Sheet 2 of 5)

EFFECTIVITY
 LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
 407, 411, 412, 415, 416, 420, 422-426 POST SB
 737-78-1089

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F37142 S0006581257_V4

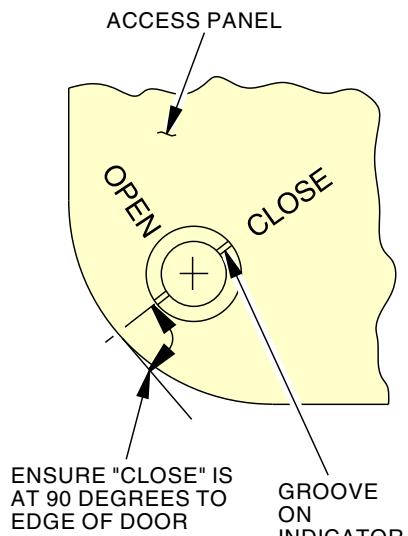
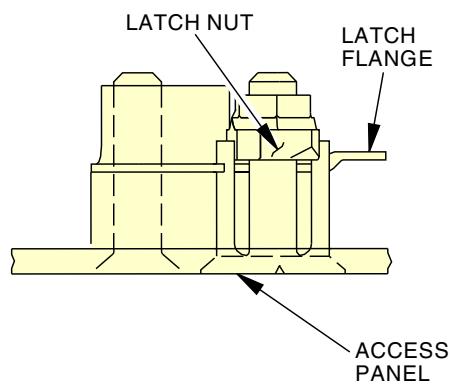
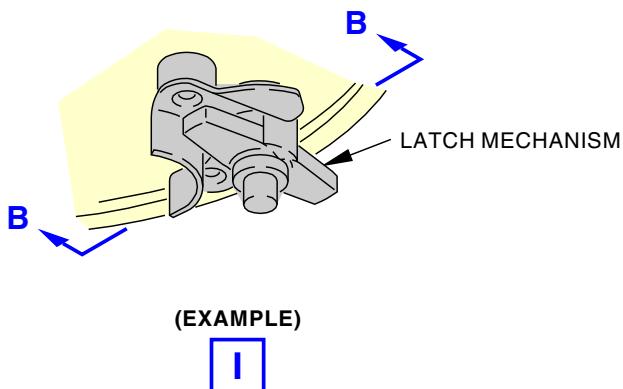
Strut Access Panel Installation
Figure 401/54-53-01-990-802 (Sheet 3 of 5)

EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-432

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**H**

(ROTARY NUT LATCH)

B-B

2547943 S0000606555_V1

Strut Access Panel Installation

Figure 401/54-53-01-990-802 (Sheet 4 of 5)

EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-432

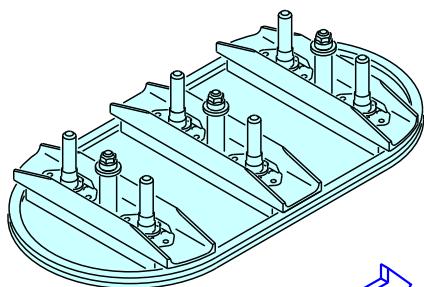
54-53-01

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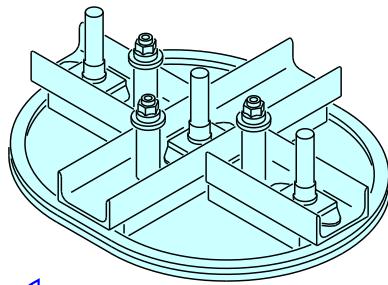


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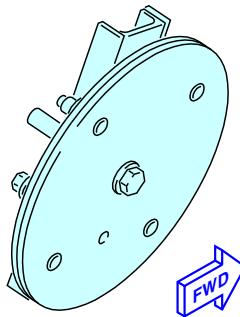
[1] ACCESS PANEL

D



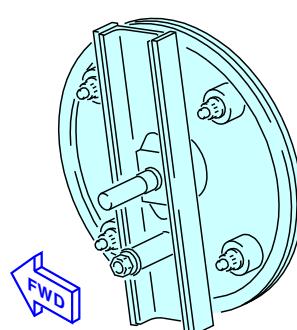
[2] ACCESS PANEL

E



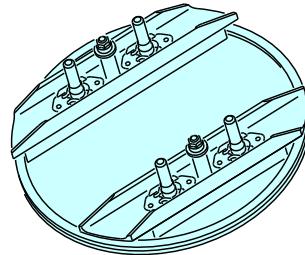
[3] ACCESS PANEL
(EXTERNAL VIEW)

F



[3] ACCESS PANEL
(INTERNAL VIEW)

F



[4] ACCESS PANEL

G

2232694 S0000497283_V2

Strut Access Panel Installation
Figure 401/54-53-01-990-802 (Sheet 5 of 5)

EFFECTIVITY
LOM 433, 434, 437-447, 450-999

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TASK 54-53-01-400-801

3. Strut Access Panel Installation

(Figure 401)

A. General

- (1) This task gives the instructions for the installation of the strut access panels.
- (2) Each strut has six access panels.
 - (a) Four panels on each strut are located on the strut upper web:
 - 1) Forward upper web access panel [1], left strut.
 - 2) Forward upper web access panel [2], left strut.
 - 3) Aft upper web access panel [4] (2 panels), left strut.
 - 4) Forward upper web access panel [1], right strut.
 - 5) Forward upper web access panel [2], right strut.
 - 6) Aft upper web access panel [4] (2 panels), right strut.
 - (b) Two panels on each strut are located on the side of the strut, at the aft end:
 - 1) Left aft access panel [3], left strut.
 - 2) Right aft access panel [3], left strut.
 - 3) Left aft access panel [3], right strut.
 - 4) Right aft access panel [3], right strut.
- (3) Each panel has captive fasteners, but the fasteners can fall out if you loosen the latch bolts too much.

B. References

Reference	Title
05-51-22-210-801	Inspection of Titanium Parts When Contaminated With Fire-Resistant Hydraulic Fluid (P/B 201)
51-31-00-160-801	Prepare For Sealing (P/B 201)
54-51-01-440-801	Put the Strut Back to its Usual Condition (P/B 201)
54-52-00-200-801	Aerodynamic Smoothness Requirements (P/B 201)
54-52-01-410-801	Forward Fairing Installation (P/B 401)
54-52-03-410-801	Wing Junction Fairing - Installation (P/B 401)
54-52-09-400-801	Leading Edge Gap Cover Installation (P/B 401)
54-53-02-410-801	Forward Strut Fairing Panel (Thrust Reverser Strut Fairing) Installation (P/B 401)
54-55-01-720-802	Strut Seal Plane Access Panels- Functional Test (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-4316	Fiberscope - Flexible Borescope Part #: IF2D5 Supplier: 32212 Opt Part #: 7110561 Supplier: 32212 Opt Part #: IF6C5X1-8 Supplier: 32212





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D. Consumable Materials

Reference	Description	Specification
A00160	Sealant - Firewall - Hydraulic Fluid Resistant	BMS5-63
A50057	Adhesive - Silicone Rubber, RTV157	BAC5010 Type 60
C00580	Primer - Adhesive Bonding, RTV - PR-1200 (Formerly DC 1200)	

E. Location Zones

Zone	Area
410	Subzone - Engine 1
420	Subzone - Engine 2
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

F. Access Panels

Number	Name/Location
431BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 1
431BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 1
431CL	Forward Strut Fairing, Left Overwing Fairing, Strut 1
431CR	Forward Strut Fairing, Right Overwing Fairing, Strut 1
431EL	Forward Strut Fairing, Left T.R. Strut Fairing, Strut 1
431ER	Forward Strut Fairing, Right T.R. Strut Fairing, Strut 1
433AL	Strut, Left Aft Dry Bay, Strut 1
433AR	Strut, Right Aft Dry Bay, Strut 1
433AT	Strut, Forward Spar Web, Strut 1
433BT	Strut, Forward Spar Web, Strut 1
433CT	Strut, Upper Spar Web, Strut 1
433DT	Strut, Upper Spar Web, Strut 1
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
441EL	Forward Strut Fairing, Left T.R. Strut Fairing, Strut 2
441ER	Forward Strut Fairing, Right T.R. Strut Fairing, Strut 2
443AL	Strut, Left Aft Dry Bay, Strut 2
443AR	Strut, Right Aft Dry Bay, 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
521AT	Outbd Leading Edge - Gap Cover Access
621AT	Outbd Leading Edge - Gap Cover Access

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G. Strut Access Panel Installation



WARNING

MAKE SURE THAT YOU INSTALL THE ACCESS PANELS CORRECTLY. IF THERE IS A FLUID LEAK, INCORRECTLY INSTALLED ACCESS PANELS CAN LET FLAMMABLE FLUID INTO THE STRUT DRY BAY. FLAMMABLE FLUID IN THE STRUT DRY BAY CAN CAUSE A FIRE.

SUBTASK 54-53-01-211-001

- (1) Prior to installing the access panels, do these steps:
 - (a) Use a fiberscope, COM-4316, to check for hydraulic leaks through the access door cavities.
 - 1) If hydraulic fluid is found during check, refer to: Inspection of Titanium Parts When Contaminated With Fire-Resistant Hydraulic Fluid, TASK 05-51-22-210-801.
 - (b) If any seals/gaskets show damage (tear, worn, deformed, over compressed) that could compromise the access panel sealing capability, do these steps:
 - 1) Do this task: Prepare For Sealing, TASK 51-31-00-160-801.
 - 2) Prime all surfaces where sealant will be applied with PR-1200 primer, C00580.
 - 3) Let the primer dry for 30 minutes minimum and 4 hours maximum.
 - 4) Apply a layer of RTV157 adhesive, A50057, to the mating surfaces of the seal/gasket and access panel.
 - 5) Let the RTV157 adhesive, A50057, cure under contact pressure for 24 hours minimum.
 - (c) Obey these procedures to minimize possible leak into the torque box dry bay:

NOTE: If the latch hardware or the locking function is damaged, the quarter-turn rotary latch can come loose because of high vibration environment. If one or more latch location becomes loose, failure of the access panel seal can occur. If there is a fluid leak, access panels with a defective seal can let flammable/corrosive fluid into the strut dry bay.

 - 1) Install only access panel assemblies in good condition and with serviceable quarter-turn rotary latches (if applicable) (Figure 401).
 - 2) Replace access panels that have excessive wear on the latch mechanism or a bent latch flange that can affect locking feature.
 - 3) Replace the access panel if the latches do not have sufficient locking capability.

LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-432

SUBTASK 54-53-01-420-001

- (2) Do these steps to install the strut access panel [1], access panel [2], or access panel [4] located on the upper web:
 - (a) Install the access panel [1], access panel [2], or access panel [4] with the captive latch bolts, do this step:
 - 1) Close the applicable access panels:
- | <u>Number</u> | <u>Name/Location</u> |
|---------------|----------------------------------|
| 433AT | Strut, Forward Spar Web, Strut 1 |
| 433BT | Strut, Forward Spar Web, Strut 1 |
| 433CT | Strut, Upper Spar Web, Strut 1 |
| 433DT | Strut, Upper Spar Web, Strut 1 |

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LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-432 (Continued)

(Continued)

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



DO NOT USE POWER TOOLS OR APPLY TOO MUCH FORCE TO THE ROTARY-LATCH MECHANISM. POWER TOOLS OR TOO MUCH FORCE CAN CAUSE DAMAGE TO LATCHES. THEY CAN CAUSE BENDS IN THE LATCH FLANGES THAT CAN CAUSE DAMAGE THE LOCK FUNCTION. DECREASED LOCK FUNCTION CAN CAUSE LEAKAGE OF FLUID INTO THE STRUT DRY BAY THAT CAN CAUSE CORROSION. THE FLUID COULD BE FLAMMABLE.



FOR PANELS 433DT AND 443DT, MAKE SURE THAT LEVELING-COMPOUND NEAR THE VAPOR BARRIER DOES NOT CAUSE INTERFERENCE WITH INSTALLATION OF THE ACCESS PANEL. INTERFERENCE MAY CAUSE A NOT COMPLETE SEAL WHEN YOU INSTALL THE PANEL. IF THERE IS A FLUID LEAK, ACCESS PANELS THAT DO NOT HAVE A COMPLETE SEAL CAN LET FLAMMABLE/CORROSIVE FLUID INTO THE STRUT DRY BAY.

- (b) Tighten the latch bolts with a hand tool to 20 in-lb (2.3 N·m) - 40 in-lb (4.5 N·m).
- 1) Make sure that you turn the indicator slots until they are approximately perpendicular to the edge of the panel nearest the latch bolt.

LOM 433, 434, 437-447, 450-999

SUBTASK 54-53-01-420-003

- (3) Do these steps to install the strut access panel [1], access panel [2], or access panel [4] located on the upper web:
- (a) Do this step to install the access panel [1], access panel [2], or access panel [4]:

- 1) Close the applicable access panels:

Number Name/Location

433AT	Strut, Forward Spar Web, Strut 1
433BT	Strut, Forward Spar Web, Strut 1
433CT	Strut, Upper Spar Web, Strut 1
433DT	Strut, Upper Spar Web, Strut 1
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

- (b) Loosen the latch bolts approximately 0.5 in. (12.7 mm).

NOTE: This will open the latch sufficiently to put the panel in the opening.

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LOM 433, 434, 437-447, 450-999 (Continued)



DO NOT USE POWER TOOLS TO DO THIS TASK. POWER TOOLS CAN CAUSE DAMAGE TO EQUIPMENT.



FOR PANELS 433DT AND 443DT, MAKE SURE THAT LEVELING-COMPOUND NEAR THE VAPOR BARRIER DOES NOT CAUSE INTERFERENCE WITH INSTALLATION OF THE ACCESS PANEL. INTERFERENCE MAY CAUSE A NOT COMPLETE SEAL WHEN YOU INSTALL THE PANEL. IF THERE IS A FLUID LEAK, ACCESS PANELS THAT DO NOT HAVE A COMPLETE SEAL CAN LET FLAMMABLE/CORROSIVE FLUID INTO THE STRUT DRY BAY.

- (c) Tighten the latch bolts with a hand tool to 50 in-lb (6 N·m) - 60 in-lb (7 N·m).

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SUBTASK 54-53-01-720-001

- (4) Make sure that the access panels do not leak (TASK 54-55-01-720-802).

SUBTASK 54-53-01-420-002

- (5) Do these steps to install the strut access panel [3] located on the side of the strut:
(a) Install the access panel [3] with the captive center bolt.

- 1) Close the applicable access panels:

Number Name/Location

433AL	Strut, Left Aft Dry Bay, Strut 1
433AR	Strut, Right Aft Dry Bay, Strut 1
443AL	Strut, Left Aft Dry Bay, Strut 2
443AR	Strut, Right Aft Dry Bay, Strut 2



DO NOT USE POWER TOOLS TO DO THIS TASK. POWER TOOLS CAN CAUSE DAMAGE TO EQUIPMENT.

- (b) Tighten the latch bolts with a hand tool to 50 in-lb (6 N·m) - 80 in-lb (9 N·m).

SUBTASK 54-53-01-390-001

- (6) Apply sealant, A00160, in a continuous fillet around periphery to the following parts:
(a) Installed fasteners
(b) Upper spar access panels (optional).

NOTE: Fillet seal around access panel covering is recommended if the aircraft has frequent hydraulic leaks from hydraulic lines, or has history of leaks into the torque box below access panels.

H. Put the Airplane Back to Its Usual Condition

SUBTASK 54-53-01-410-001

- (1) Close the applicable thrust reverser strut fairings:
(TASK 54-53-02-410-801)

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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
441EL	Forward Strut Fairing, Left T.R. Strut Fairing, Strut 2
441ER	Forward Strut Fairing, Right T.R. Strut Fairing, Strut 2

SUBTASK 54-53-01-000-001

- (2) After installing the two aft strut access access panels [3], do the following steps:

- (a) Close the applicable wing junction fairings:

(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
441CL	Forward Strut Fairing, Left Overwing Fairing, Strut 2
441CR	Forward Strut Fairing, Right Overwing Fairing, Strut 2

- (b) Close the applicable leading edge gap covers:

(TASK 54-52-09-400-801)

Number **Name/Location**

521AT	Outbd Leading Edge - Gap Cover Access
621AT	Outbd Leading Edge - Gap Cover Access

SUBTASK 54-53-01-410-002

- (3) Close the applicable forward fairings:

(TASK 54-52-01-410-801)

Number **Name/Location**

431BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 1
431BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 1
441BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 2
441BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 2

SUBTASK 54-53-01-220-001

- (4) Make sure that the panels are in the aerodynamic smoothness limits, do this task:
Aerodynamic Smoothness Requirements, TASK 54-52-00-200-801.

SUBTASK 54-53-01-440-001

- (5) Do this task: Put the Strut Back to its Usual Condition, TASK 54-51-01-440-801.

———— END OF TASK ————

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FORWARD STRUT FAIRING PANELS (THRUST REVERSER STRUT FAIRINGS) - REMOVAL/
INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) A removal of the forward strut fairing panels (thrust reverser strut fairings).
 - (2) An installation of the forward strut fairing panels (thrust reverser strut fairings).

TASK 54-53-02-000-802

2. Forward Strut Fairing Panel (Thrust Reverser Strut Fairing) Removal

(Figure 401)

A. General

- (1) Each strut has two thrust reverser fairing panels:
 - (a) An inboard thrust reverser fairing
 - (b) An outboard thrust reverser fairing.

B. References

Reference	Title
54-51-01-040-801	Prepare the Strut for Maintenance Operations (P/B 201)
78-31-00-010-801-F00	Open the Thrust Reverser (Selection) (P/B 201)

C. Location Zones

Zone	Area
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

D. 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
441EL	Forward Strut Fairing, Left T.R. Strut Fairing, Strut 2
441ER	Forward Strut Fairing, Right T.R. Strut Fairing, Strut 2

E. Prepare for the Removal

SUBTASK 54-53-02-010-003



WARNING

DO THESE SPECIFIED TASKS IN THE CORRECT SEQUENCE BEFORE YOU OPEN THE THRUST REVERSER: RETRACT THE LEADING EDGE, DO THE DEACTIVATION PROCEDURES FOR THE LEADING EDGE AND THE THRUST REVERSER (FOR GROUND MAINTENANCE), AND OPEN THE FAN COWL PANELS. IF YOU DO NOT OBEY THE ABOVE SEQUENCE, INJURIES TO PERSONS AND DAMAGE TO EQUIPMENT CAN OCCUR.

- (1) Do this task: Open the Thrust Reverser (Selection), TASK 78-31-00-010-801-F00.

SUBTASK 54-53-02-040-002

- (2) Do this task: Prepare the Strut for Maintenance Operations, TASK 54-51-01-040-801.

F. Forward Strut Fairing Panel Removal

SUBTASK 54-53-02-000-001

- (1) To remove the outboard thrust reverser fairings, do these steps:



54-53-02



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- (a) Remove the bolts [1] which hold the applicable outboard thrust reverser fairing [2] or outboard thrust reverser fairing [3] in its position, do this step:

Open the applicable access panels:

Number **Name/Location**

431EL Forward Strut Fairing, Left T.R. Strut Fairing, Strut 1

441ER Forward Strut Fairing, Right T.R. Strut Fairing, Strut 2

- (b) Remove the applicable outboard thrust reverser fairing [2] or outboard thrust reverser fairing [3], do this step:

Remove the applicable access panels:

Number **Name/Location**

431EL Forward Strut Fairing, Left T.R. Strut Fairing, Strut 1

441ER Forward Strut Fairing, Right T.R. Strut Fairing, Strut 2

SUBTASK 54-53-02-000-002

- (2) To remove the inboard thrust reverser fairings, do this step:

- (a) Remove the bolts [1] which hold the applicable inboard thrust reverser fairing [4] or inboard thrust reverser fairing [5] in its position, do this step:

Open the applicable access panels:

Number **Name/Location**

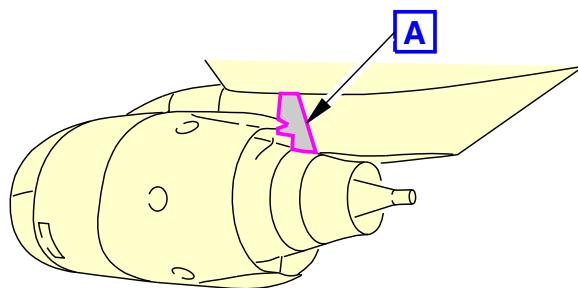
431ER Forward Strut Fairing, Right T.R. Strut Fairing, Strut 1

441EL Forward Strut Fairing, Left T.R. Strut Fairing, Strut 2

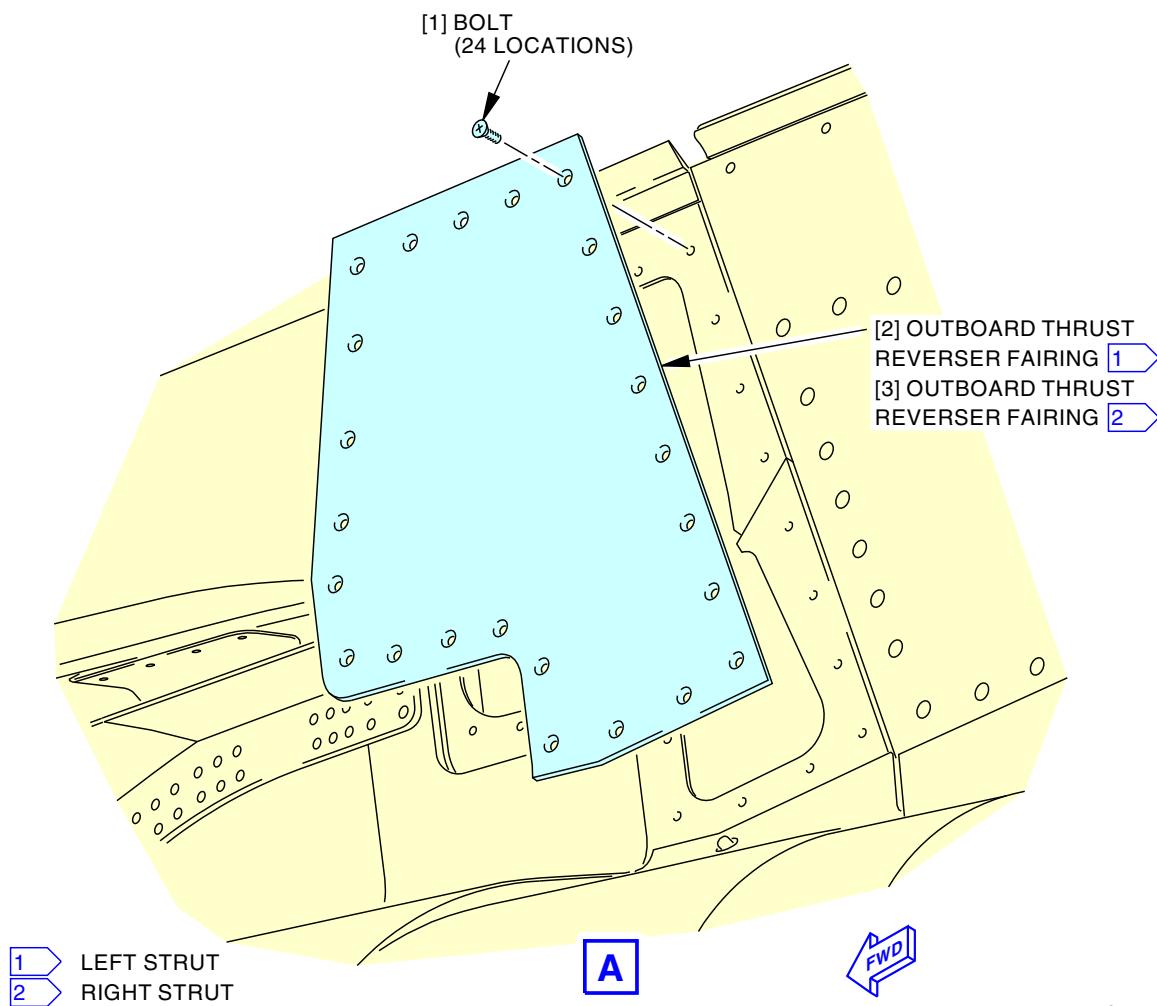
———— END OF TASK ————

EFFECTIVITY
LOM ALL

54-53-02



LEFT STRUT
 (RIGHT STRUT IS OPPOSITE)



F19579 S0006581262_V2

Strut Fairings Installation
Figure 401/54-53-02-990-802 (Sheet 1 of 4)

EFFECTIVITY
 LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
 422-426 PRE SB 737-78-1089

54-53-02

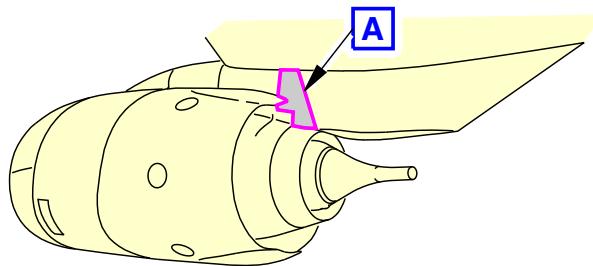
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

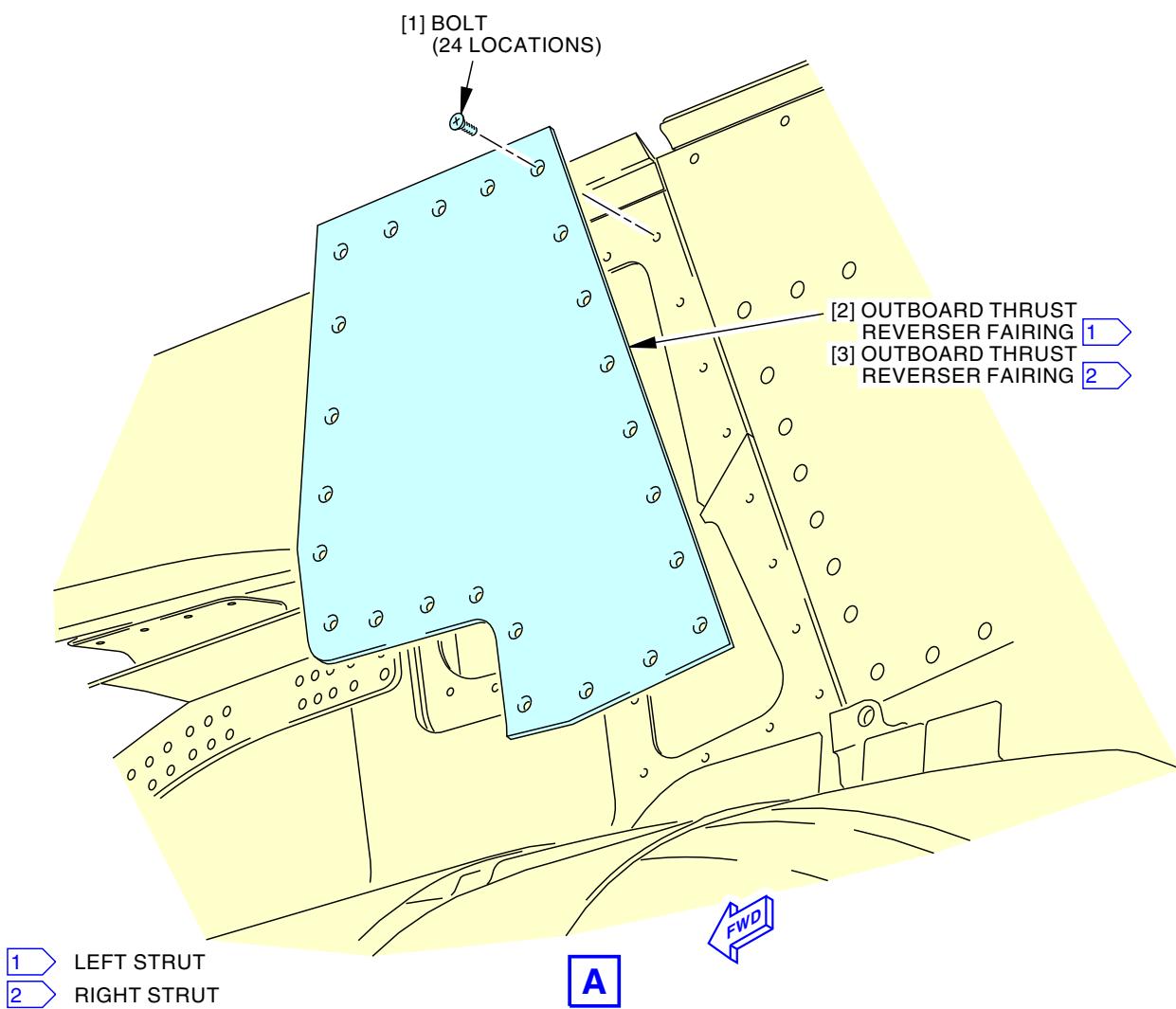
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LEFT STRUT
(RIGHT STRUT IS OPPOSITE)



2099241 S0000443932_V2

Strut Fairings Installation
Figure 401/54-53-02-990-802 (Sheet 2 of 4)

EFFECTIVITY
LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
407, 411, 412, 415, 416, 420, 422-426 POST SB
737-78-1089

54-53-02

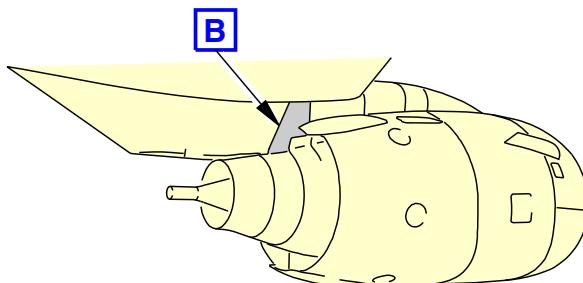
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ECCN 9E991 BOEING PROPRIETARY - See title page for details

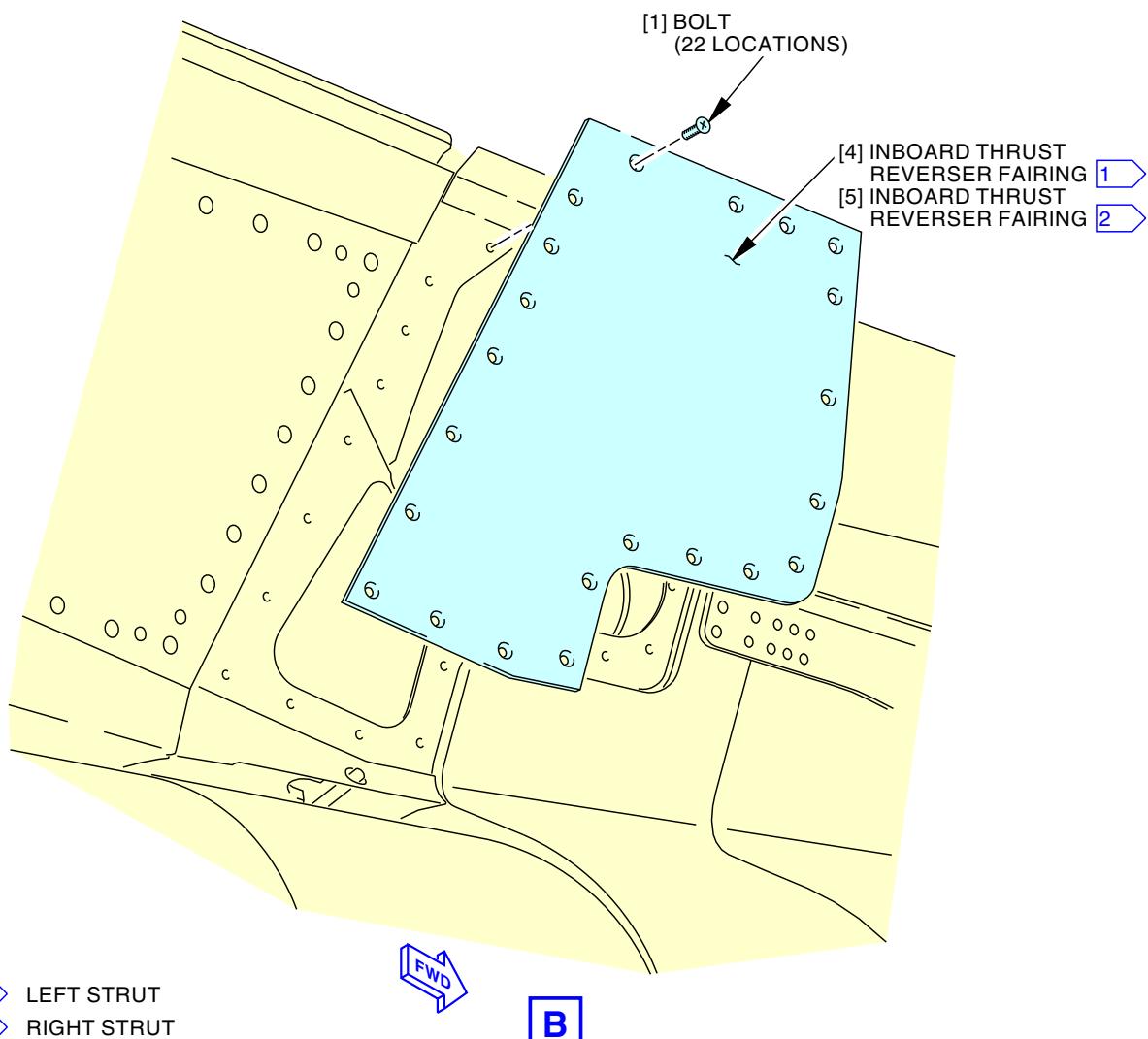
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LEFT STRUT
(RIGHT STRUT IS OPPOSITE)



3034927 S0000804765_V1

Strut Fairings Installation
Figure 401/54-53-02-990-802 (Sheet 3 of 4)

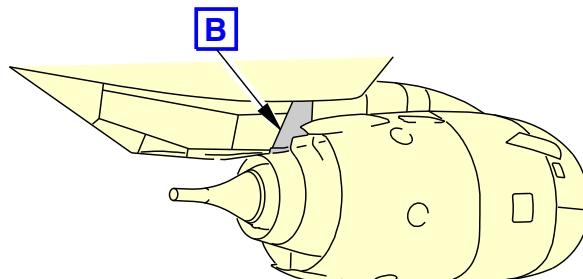
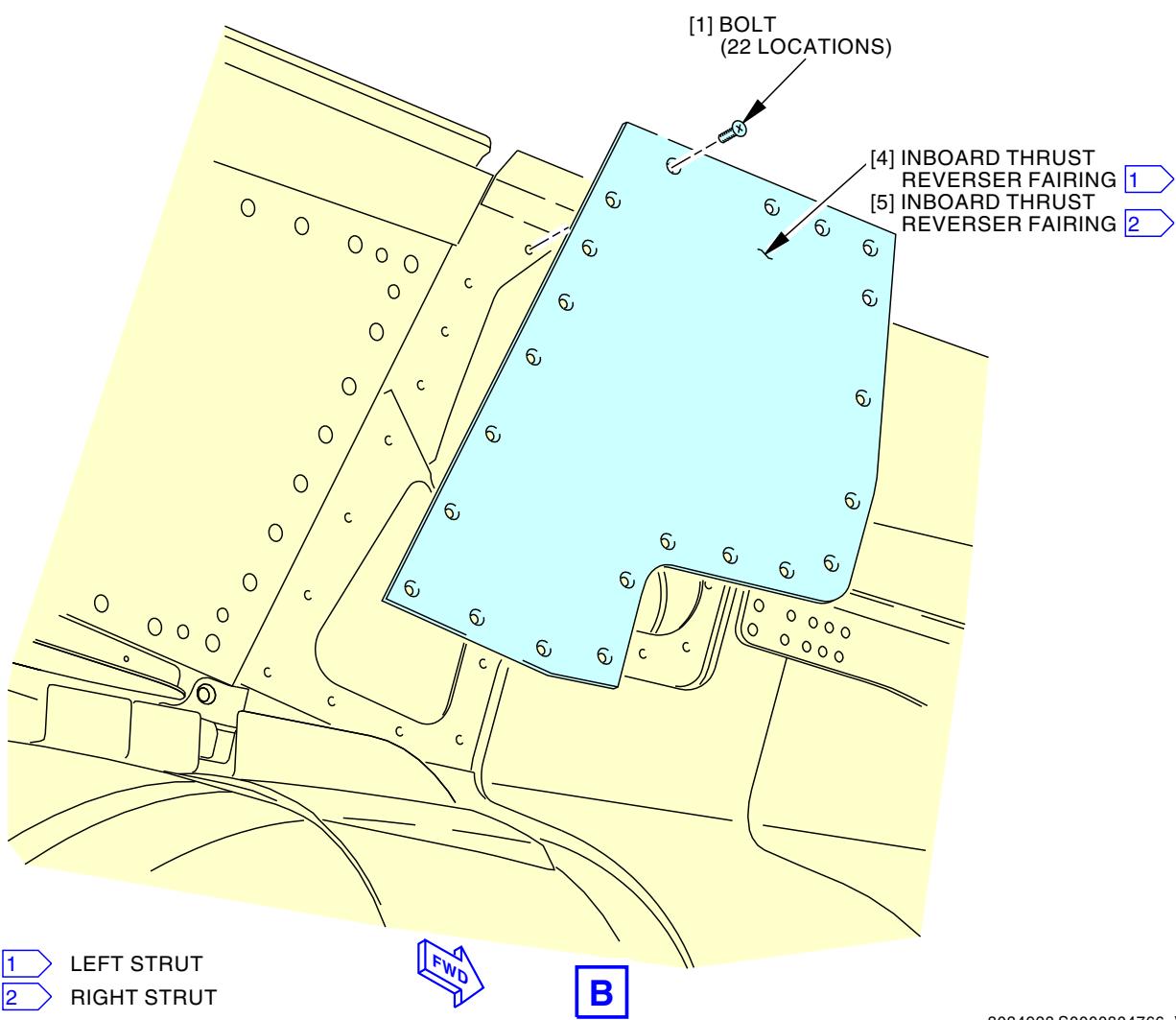
EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-78-1089

54-53-02

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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LEFT STRUT
(RIGHT STRUT IS OPPOSITE)

3034928 S0000804766_V1

Strut Fairings Installation
Figure 401/54-53-02-990-802 (Sheet 4 of 4)

EFFECTIVITY
LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
407, 411, 412, 415, 416, 420, 422-426 POST SB
737-78-1089

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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TASK 54-53-02-410-801

3. Forward Strut Fairing Panel (Thrust Reverser Strut Fairing) Installation
(Figure 401)

A. General

- (1) Each strut has two thrust reverser fairing panels:
 - (a) An inboard thrust reverser fairing.
 - (b) An outboard thrust reverser fairing.

B. References

Reference	Title
54-51-01-440-801	Put the Strut Back to its Usual Condition (P/B 201)
54-52-00-200-801	Aerodynamic Smoothness Requirements (P/B 201)
78-31-00-010-804-F00	Close the Thrust Reverser (Selection) (P/B 201)

C. Consumable Materials

Reference	Description	Specification
D00633	Grease - Aircraft General Purpose	BMS3-33

D. Location Zones

Zone	Area
410	Subzone - Engine 1
420	Subzone - Engine 2
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

E. 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
441EL	Forward Strut Fairing, Left T.R. Strut Fairing, Strut 2
441ER	Forward Strut Fairing, Right T.R. Strut Fairing, Strut 2

F. Forward Strut Fairing Panel Installation

SUBTASK 54-53-02-420-001

- (1) To install the outboard thrust reverser fairings, do these steps:
 - (a) Apply grease, D00633, to the bolts [1].
 - (b) Put the applicable outboard thrust reverser fairing [2] or outboard thrust reverser fairing [3] in its position, do this step:

Close the applicable access panels:

Number	Name/Location
431EL	Forward Strut Fairing, Left T.R. Strut Fairing, Strut 1
441ER	Forward Strut Fairing, Right T.R. Strut Fairing, Strut 2

- (c) Install the bolts [1].

- 1) Tighten the bolts [1] to 72 in-lb (8 N·m) - 88 in-lb (10 N·m).

SUBTASK 54-53-02-400-001

- (2) To install the inboard thrust reverser fairings, do these steps:
 - (a) Apply grease, D00633, to the bolts [1].

EFFECTIVITY
LOM ALL

54-53-02



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- (b) Put the applicable inboard thrust reverser fairing [4] or inboard thrust reverser fairing [5] in its position, do this step:

Close the applicable access panels:

Number **Name/Location**

431ER Forward Strut Fairing, Right T.R. Strut Fairing, Strut 1

441EL Forward Strut Fairing, Left T.R. Strut Fairing, Strut 2

- (c) Install the bolts [1].

- 1) Tighten the bolts [1] to 72 in-lb (8 N·m) - 88 in-lb (10 N·m).

G. Put the Airplane Back to Its Usual Condition

SUBTASK 54-53-02-440-002

- (1) Make sure that the panels are in the aerodynamic smoothness limits, do this task:
Aerodynamic Smoothness Requirements, TASK 54-52-00-200-801.

SUBTASK 54-53-02-440-003

- (2) If you will do no more maintenance operations on the strut, do this task: Put the Strut Back to its Usual Condition, TASK 54-51-01-440-801.

SUBTASK 54-53-02-410-003



OBEY THE INSTRUCTIONS IN THE PROCEDURE TO CLOSE THE THRUST REVERSERS. IF YOU DO NOT OBEY THE INSTRUCTIONS WHEN YOU CLOSE THE THRUST REVERSERS, INJURIES TO PERSONS OR DAMAGE TO EQUIPMENT CAN OCCUR.

- (3) Do this task: Close the Thrust Reverser (Selection), TASK 78-31-00-010-804-F00.

———— END OF TASK ————

EFFECTIVITY
LOM ALL

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FORWARD STRUT FAIRING PANELS (THRUST REVERSER STRUT FAIRINGS) - INSPECTION/CHECK

1. General

- A. This procedure examines the forward strut fairing panels (thrust reverser strut fairings).

TASK 54-53-02-000-801

2. Forward Strut Fairing Panel (Thrust Reverser Strut Fairing) Examination

A. References

Reference	Title
54-51-01-040-801	Prepare the Strut for Maintenance Operations (P/B 201)
54-51-01-440-801	Put the Strut Back to its Usual Condition (P/B 201)
54-52-00-200-801	Aerodynamic Smoothness Requirements (P/B 201)
54-53-02-000-802	Forward Strut Fairing Panel (Thrust Reverser Strut Fairing) Removal (P/B 401)
54-53-02-410-801	Forward Strut Fairing Panel (Thrust Reverser Strut Fairing) Installation (P/B 401)
SRM 54-50-70	Structural Repair Manual

B. Location Zones

Zone	Area
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

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
441EL	Forward Strut Fairing, Left T.R. Strut Fairing, Strut 2
441ER	Forward Strut Fairing, Right T.R. Strut Fairing, Strut 2

D. Prepare for the Examination

SUBTASK 54-53-02-040-001

- (1) Do this task: Prepare the Strut for Maintenance Operations, TASK 54-51-01-040-801.

SUBTASK 54-53-02-010-001

- (2) To remove the applicable forward strut fairing panel (thrust reverser strut fairings), do this task:
Forward Strut Fairing Panel (Thrust Reverser Strut Fairing) Removal, TASK 54-53-02-000-802
Open the applicable 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
441EL	Forward Strut Fairing, Left T.R. Strut Fairing, Strut 2
441ER	Forward Strut Fairing, Right T.R. Strut Fairing, Strut 2

E. Forward Strut Fairing Panel Examination

SUBTASK 54-53-02-210-001

- (1) Do these steps to examine the thrust reverser strut fairings:

- (a) Examine the strut access panels for cracks in the skin, separation of the bonded layers, and damage to the paint and protective coating.

EFFECTIVITY
LOM ALL

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- 1) If you find damage to the strut access panels, repair the panels as specified in this procedure: (SRM 54-50-70).

SUBTASK 54-53-02-410-001

- (2) To install the thrust reverser strut fairings, do this task: Forward Strut Fairing Panel (Thrust Reverser Strut Fairing) Installation, TASK 54-53-02-410-801

Close these access panels:

<u>Number</u>	<u>Name/Location</u>
431EL	Forward Strut Fairing, Left T.R. Strut Fairing, Strut 1
431ER	Forward Strut Fairing, Right T.R. Strut Fairing, Strut 1
441EL	Forward Strut Fairing, Left T.R. Strut Fairing, Strut 2
441ER	Forward Strut Fairing, Right T.R. Strut Fairing, Strut 2

SUBTASK 54-53-02-210-003

- (3) Do this task: Aerodynamic Smoothness Requirements, TASK 54-52-00-200-801.

F. Put the Airplane Back to its Usual Condition

SUBTASK 54-53-02-440-001

- (1) Do this task: Put the Strut Back to its Usual Condition, TASK 54-51-01-440-801.

———— END OF TASK ————

— EFFECTIVITY —

LOM ALL



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FORWARD STRUT FIRE SEAL - MAINTENANCE PRACTICES

1. General

- A. This procedure has these tasks:
- (1) An inspection of the forward strut fire seal.
 - (2) A removal of the forward strut fire seal.
 - (3) An installation of the forward strut fire seal.

TASK 54-54-00-200-803

2. Forward Strut Fire Seal - Inspection

(Figure 201)

A. General

- (1) The forward strut fire seal is located near the forward engine mount.

B. References

Reference	Title
71-00-02-000-801-F00	Power Plant - Removal (P/B 401)
71-00-02-400-801-F00	Power Plant - Installation (P/B 401)

C. Tools/Equipment

Reference	Description
STD-1315	Spatula - Plastic, Stiff

D. Location Zones

Zone	Area
410	Subzone - Engine 1
420	Subzone - Engine 2
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

E. Forward Strut Fire Seal Inspection

SUBTASK 54-54-00-210-007

- (1) Do a visual check of the fire seal [1] condition.
 - (a) If necessary, remove the power plant (Power Plant - Removal, TASK 71-00-02-000-801-F00).
 - (b) Remove the engine fan case away from the fire seal [1].
 - (c) Inspect the fire seal [1] for any cuts or worn areas.

NOTE: If no cuts or worn areas are present and the fire seal, although pinched, is not damaged in any way, the fire seal is serviceable.

- 1) If the fire seal [1] inspection shows cuts or worn areas, replace the fire seal [1], do these tasks:
 - Forward Strut Fire Seal - Removal, TASK 54-54-00-000-801
 - Forward Strut Fire Seal - Installation, TASK 54-54-00-400-801.
- (d) Install the power plant if it was removed (Power Plant - Installation, TASK 71-00-02-400-801-F00).
 - 1) When the engine is being raised, carefully examine the fire seal [1] to make sure it is correctly seated on the edge of the engine fan case.

EFFECTIVITY
LOM ALL

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- 2) Lift the engine.
- 3) Use a stiff plastic spatula, STD-1315 to push the last 3 in. (76 mm) to 4 in. (102 mm) long horizontal section of the seal forward over the edge of the engine fan case coaming.
NOTE: This step prevents the protrusion and pinching of the fire seal [1] corners into the bypass duct after the thrust reversers are closed..
- 4) Continue to lift the engine.

———— END OF TASK ————

TASK 54-54-00-000-801

3. Forward Strut Fire Seal - Removal

(Figure 201 and Figure 202)

A. General

- (1) The forward strut fire seal is located near the forward engine mount.

B. References

Reference	Title
71-00-02-000-801-F00	Power Plant - Removal (P/B 401)
78-31-01-000-801-F00	Thrust Reverser Removal (P/B 401)

C. Tools/Equipment

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

Reference	Description
SPL-14612	Installation Eqpt - Strut Fire Seal Part #: C54020-12 Supplier: 81205

D. Location Zones

Zone	Area
410	Subzone - Engine 1
420	Subzone - Engine 2
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

E. Forward Strut Fire Seal Removal

SUBTASK 54-54-00-020-001

- (1) To remove the fire seal [1], do these steps:

- (a) If it is necessary, remove the power plant, do this task: Power Plant - Removal, TASK 71-00-02-000-801-F00.
- (b) If it is necessary, remove both thrust reversers, do this task: Thrust Reverser Removal, TASK 78-31-01-000-801-F00.

NOTE: Removal of both thrust reversers may not be required. It is recommended to first attempt removal of the fire seal without removal of the thrust reversers. If the fire seal can not be removed, then first remove the thrust reversers and try to remove the fire seal again.

— EFFECTIVITY —

LOM ALL

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- (c) Remove the fasteners [6], fasteners [7], and fasteners [8].
NOTE: This removes the fire seal together with the retainer.
- (d) Label and keep the fasteners [6], fasteners [7], fasteners [8], and retainer [2] for later installation.
- (e) Slide each vertical arm of the fire seal [1] out of its keeper [4] and retainer [3].
 - 1) If available, use strut fire seal installation eqpt, SPL-14612 (Figure 202).

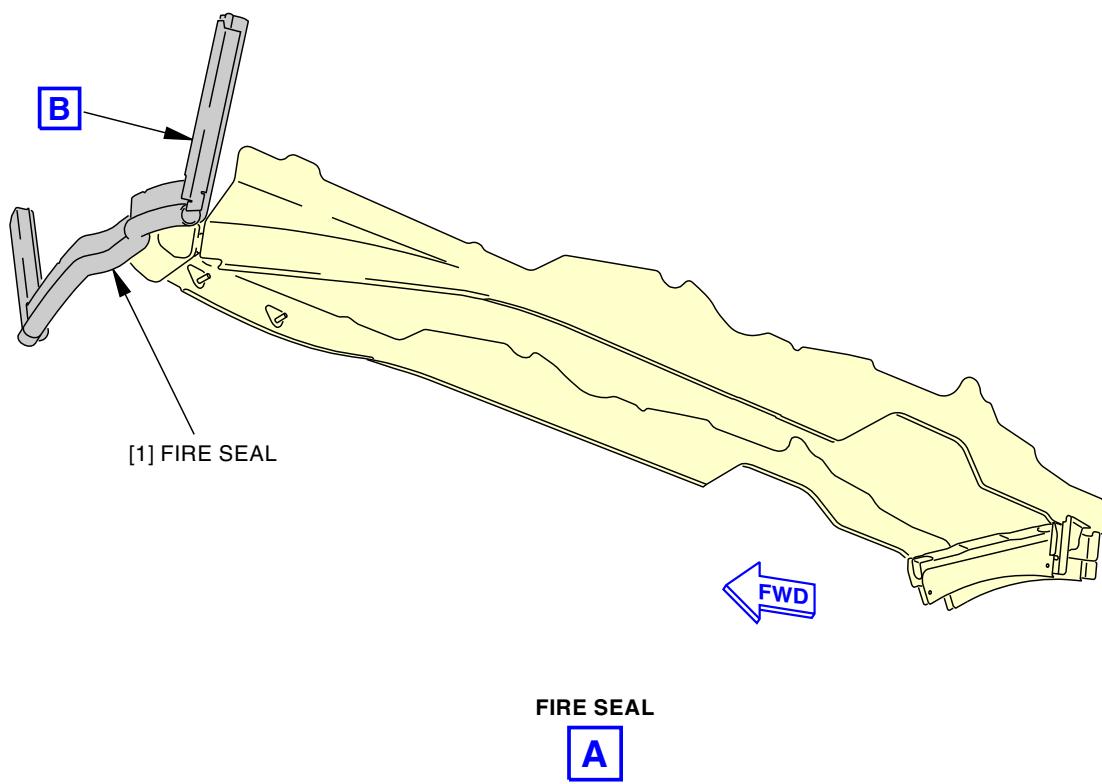
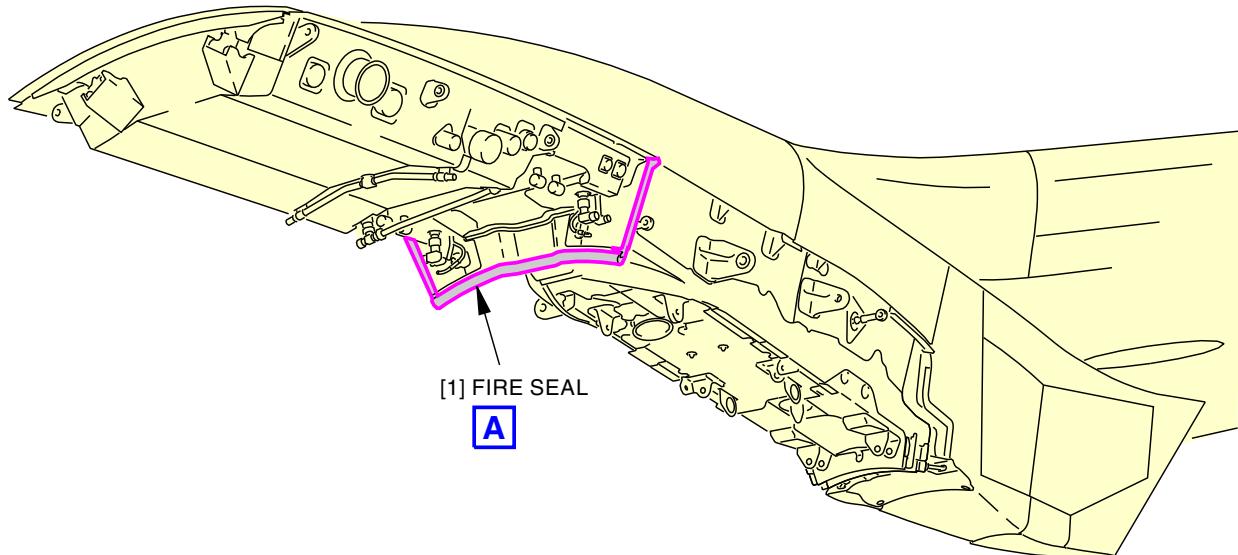
———— END OF TASK ————

EFFECTIVITY
LOM ALL

54-54-00



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Forward Strut Fire Seal Installation
Figure 201/54-54-00-990-804 (Sheet 1 of 2)

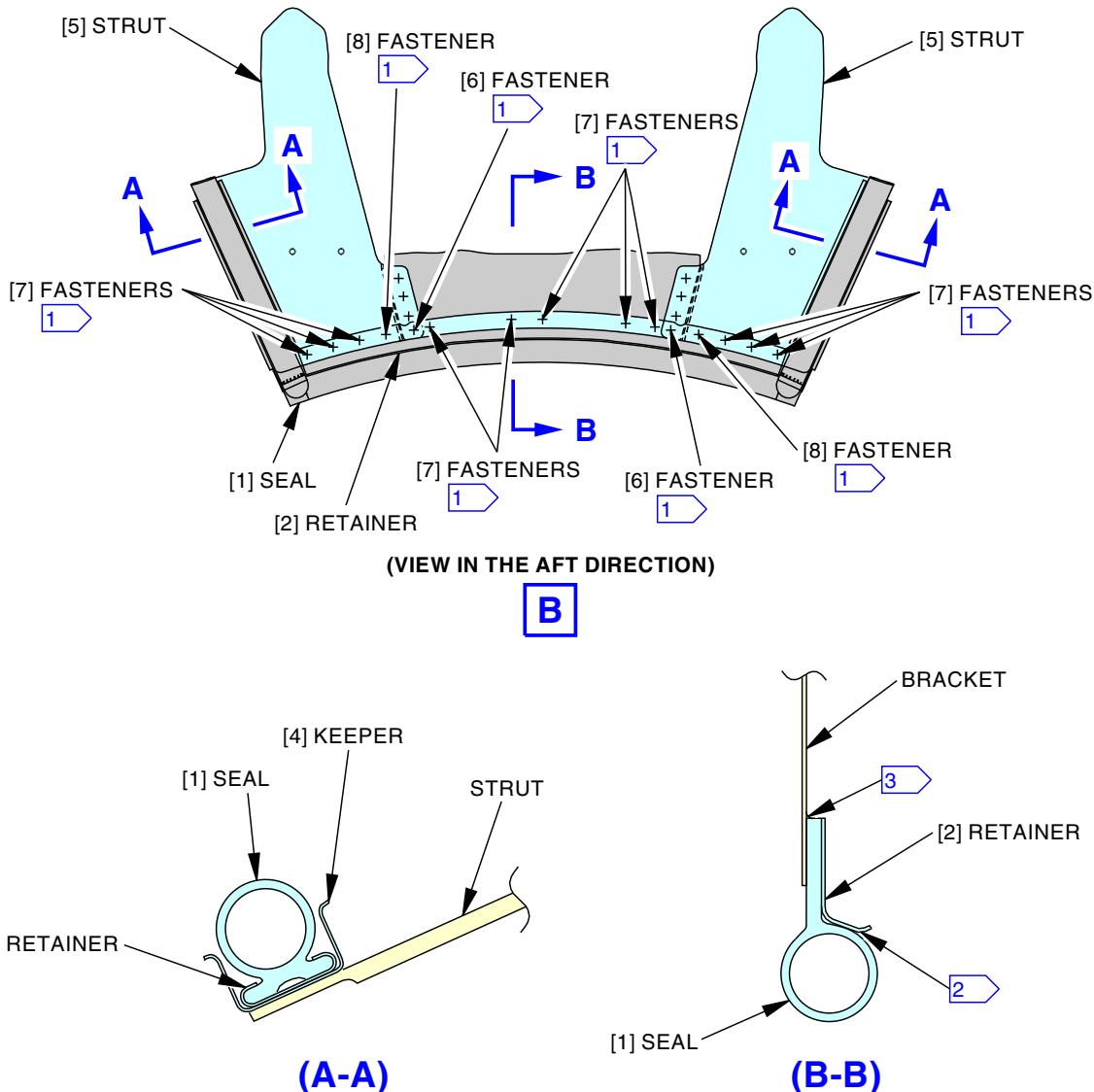
EFFECTIVITY
LOM ALL

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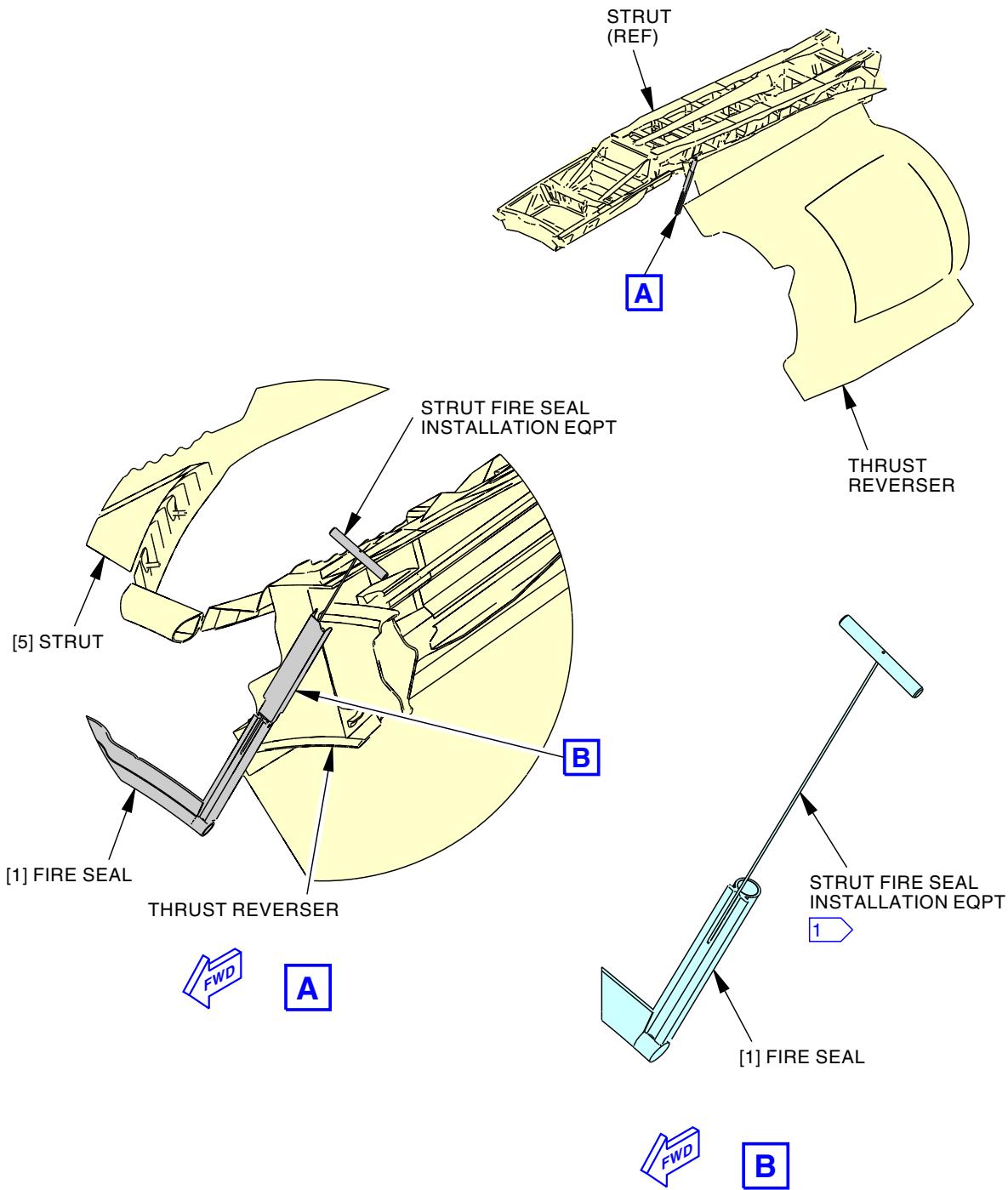
- [1] INSTALL FASTENERS PER BAC5004 EXCEPT TORQUE FASTENERS 12-15 INCH-POUNDS (1.36-1.70 NEWTON-METERS)
- [2] SEAL BULB SHALL BE IN CONTACT WITH THE HORIZONTAL FLANGE OF THE RETAINER ALONG THE ENTIRE LENGTH OF THE MATING SURFACES. PERMISSIBLE TO COMPRESS SEAL AS REQUIRED TO ASSURE CONTACT BETWEEN THE SEAL AND THE RETAINER. TRIM OFF EXCESS ON VERTICAL LEG OF SEAL IS PERMISSIBLE TO FACILITATE FILLET SEALING REQUIREMENT.
- [3] APPLY BMS5-63 FILLET SEAL PER BAC5000 TO FILL ANY GAPS.

N91095 S0006581273_V4

Forward Strut Fire Seal Installation
Figure 201/54-54-00-990-804 (Sheet 2 of 2)

EFFECTIVITY	LOM ALL
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54-54-00



1 TO REMOVE TOOL AFTER SEAL INSTALLATION,
TURN HANDLE 90 DEGREES AND PULL.

2484290 S0000584273_V1

Strut Fire Seal Installation Tool
Figure 202/54-54-00-990-805

EFFECTIVITY
LOM ALL

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TASK 54-54-00-400-801

4. Forward Strut Fire Seal - Installation

(Figure 201 and Figure 202)

A. General

- (1) The forward strut fire seal is located near the forward engine mount.

B. References

Reference	Title
71-00-02-400-801-F00	Power Plant - Installation (P/B 401)
78-31-01-400-801-F00	Thrust Reverser 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-14612	Installation Eqpt - Strut Fire Seal Part #: C54020-12 Supplier: 81205
STD-1315	Spatula - Plastic, Stiff

D. Consumable Materials

Reference	Description	Specification
A00160	Sealant - Firewall - Hydraulic Fluid Resistant	BMS5-63

E. Location Zones

Zone	Area
410	Subzone - Engine 1
420	Subzone - Engine 2
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

F. Forward Strut Fire Seal Installation

SUBTASK 54-54-00-400-001

- (1) To install the fire seal [1], do these steps:

- (a) Install the vertical arms of the fire seal [1] in the retainer [3] and keeper [4].
 - 1) If available, use strut fire seal installation eqpt, SPL-14612 (Figure 202).
 - a) Make sure that the fire seal is pushed up as high as possible.
- (b) To secure the fire seal [1] and retainer [2] to the bottom of the strut [5], install the fasteners [6], fasteners [7], and fasteners [8].
 - 1) Make sure that the fire seal is pushed up as high as possible.
- (c) Tighten the fasteners [6], fasteners [7], and fasteners [8] to 12 in-lb (1.36 N·m) – 15 in-lb (1.69 N·m).
- (d) Apply sealant, A00160, to make a fillet seal between the retainer [2] and fire seal [1].

SUBTASK 54-54-00-020-002

- (2) If both thrust reversers were removed, install them, do this task: Thrust Reverser Installation, TASK 78-31-01-400-801-F00.



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SUBTASK 54-54-00-020-003

- (3) If the power plant was removed, install it, do this task: Power Plant - Installation, TASK 71-00-02-400-801-F00.
- (a) When the engine is being raised, carefully examine the fire seal [1] to make sure that it is properly seated on the edge of the engine fan case.
- 1) Raise the engine.
 - 2) Use a stiff plastic spatula, STD-1315, to push the last 3 in. (76 mm) to 4 in. (102 mm) long horizontal section of the seal forward over the edge of the engine fan case coating.
NOTE: This is done to avoid protrusion and pinching of the fire seal corners into the bypass duct after the thrust reverser is closed.
 - 3) Continue to raise the engine.

———— END OF TASK ————

EFFECTIVITY
LOM ALL

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STRUT FIRESEAL AND FIRESEAL DEPRESSOR - INSPECTION/CHECK

1. General

- A. This procedure has two tasks:
 - (1) Strut Fireseal Depressor Inspection.
 - (2) Forward Strut Fireseal Inspection.

TASK 54-54-00-200-801

2. Strut Fireseal Depressor Inspection

(Figure 601)

A. General

- (1) This task has these steps:
 - (a) Get access to the fireseal depressor.
 - (b) Do an inspection of the fireseal depressor for damage.
 - (c) Close access to the fireseal depressor.

B. References

Reference	Title
54-51-01-040-801	Prepare the Strut for Maintenance Operations (P/B 201)
54-51-01-440-801	Put the Strut Back to its Usual Condition (P/B 201)
78-31-00-010-801-F00	Open the Thrust Reverser (Selection) (P/B 201)
78-31-00-010-804-F00	Close the Thrust Reverser (Selection) (P/B 201)

C. Location Zones

Zone	Area
410	Subzone - Engine 1
420	Subzone - Engine 2
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

D. Prepare for the Inspection

SUBTASK 54-54-00-040-001

- (1) Prepare the strut for maintenance operations. To prepare the strut, do this task: Prepare the Strut for Maintenance Operations, TASK 54-51-01-040-801.

SUBTASK 54-54-00-010-001

- (2) Open the applicable thrust reversers. To open the thrust reversers, do this task: Open the Thrust Reverser (Selection), TASK 78-31-00-010-801-F00.

E. Strut Fireseal Depressor Inspection

SUBTASK 54-54-00-210-001

- (1) Make sure the fireseal depressor parts are not loose, damaged, or missing.

SUBTASK 54-54-00-210-002

- (2) Do an inspection of the firewall structure for cracks, nicks, dents, distortion, or other damage.

EFFECTIVITY
LOM ALL

54-54-00



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F. Put the Airplane Back to Its Usual Condition

SUBTASK 54-54-00-100-001



MAKE SURE YOU KEEP THE STRUT AREA CLEAN. LOOSE TOOLS AND UNWANTED MATERIALS IN THE STRUT COMPARTMENTS CAN PREVENT THE REMOVAL OF FLUIDS THROUGH THE STRUT DRAINS. IF YOU DO NOT REMOVE THE UNWANTED MATERIALS, YOU CAN CAUSE DAMAGE TO THE STRUT.

- (1) Remove all unwanted materials from the strut compartments.

SUBTASK 54-54-00-410-001

- (2) Close the applicable thrust reversers. To close the thrust reversers, do this task: Close the Thrust Reverser (Selection), TASK 78-31-00-010-804-F00.

SUBTASK 54-54-00-440-001

- (3) If you will do no more maintenance operations, do this task: Put the Strut Back to its Usual Condition, TASK 54-51-01-440-801.

————— END OF TASK ————

TASK 54-54-00-200-802

3. Forward Strut Fireseal Inspection

(Figure 601)

A. General

- (1) This task does an Inspection of the Forward Strut Fireseal.

B. References

Reference	Title
78-31-00-010-801-F00	Open the Thrust Reverser (Selection) (P/B 201)
78-31-00-010-804-F00	Close the Thrust Reverser (Selection) (P/B 201)

C. Location Zones

Zone	Area
410	Subzone - Engine 1
420	Subzone - Engine 2
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

D. Procedure

SUBTASK 54-54-00-210-006

- (1) Do these steps to do an inspection of the forward strut fireseal:
 - (a) Look in the thrust reverser fan bypass to see if the forward strut fireseal protrudes.
 - (b) If the fireseal protrudes do these steps:
 - 1) Open the applicable thrust reversers. To open the thrust reversers, do this task: Open the Thrust Reverser (Selection), TASK 78-31-00-010-801-F00.
 - 2) Measure the clearance between the fireseal retainer and the engine fan case.
 - a) Make sure there is a minimum clearance of 0.10 inch (2.54 mm).

— EFFECTIVITY —

LOM ALL

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E. Put the Airplane Back to Its Usual Condition

SUBTASK 54-54-00-410-002

- (1) Close the applicable thrust reversers. To close the thrust reversers, do this task: Close the Thrust Reverser (Selection), TASK 78-31-00-010-804-F00.

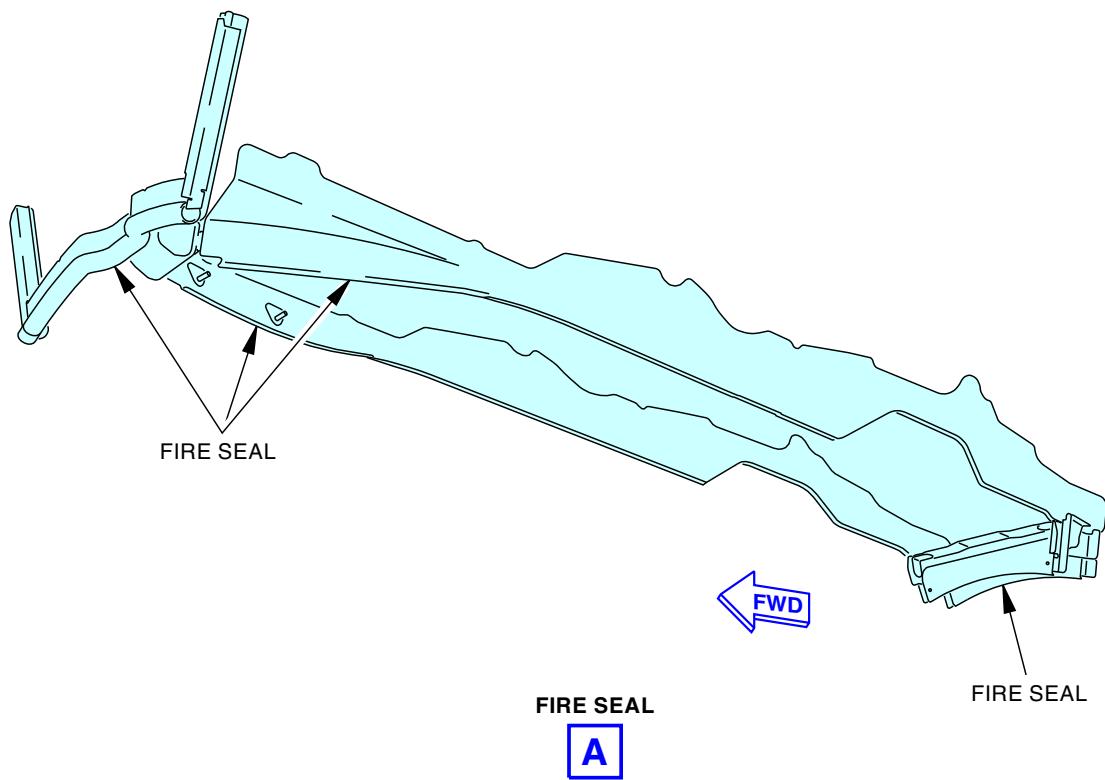
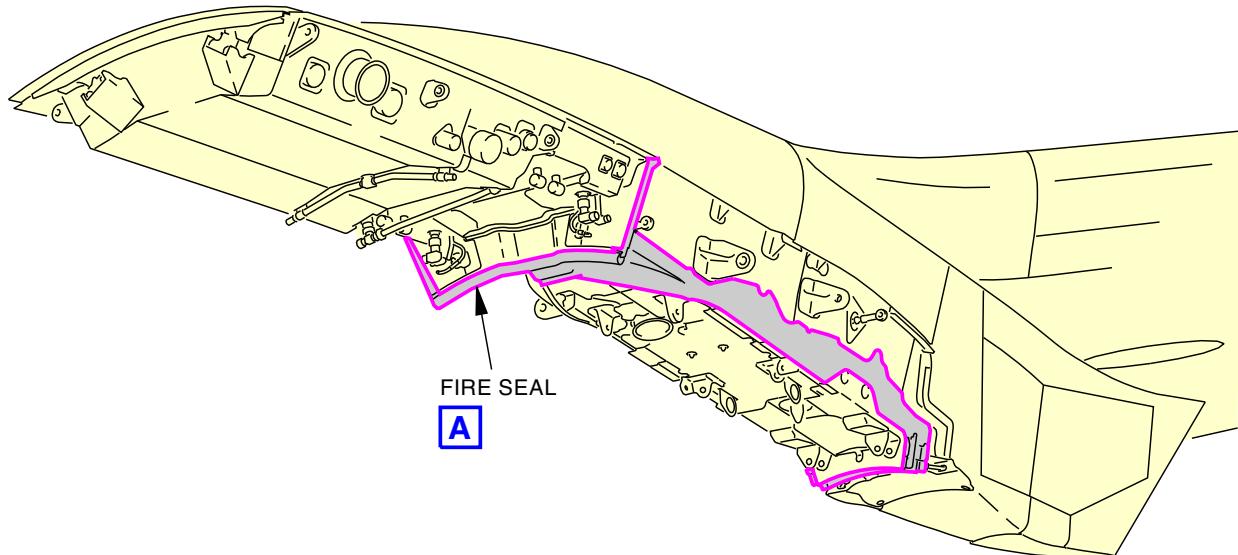
———— END OF TASK ————

— EFFECTIVITY —
LOM ALL

54-54-00



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Strut Fire Seal Depressor Inspection
Figure 601/54-54-00-990-801

EFFECTIVITY
LOM ALL

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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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STRUT INSULATION BLANKETS - REMOVAL/INSTALLATION

1. General

- A. This procedure has these tasks:
- (1) A removal of the strut forward insulation blankets
 - (2) An installation of the strut forward insulation blankets
 - (3) A removal of the strut mid insulation blankets
 - (4) An installation of the strut mid insulation blankets
 - (5) A removal of the strut aft insulation blankets
 - (6) An installation of the strut aft insulation blankets.

TASK 54-54-01-000-801

2. Strut Forward Insulation Blankets Removal

A. General

LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 PRE SB 737-78-1089

- (1) This task gives the instructions on how to remove the strut forward insulation blankets (Figure 401).

LOM 427-434, 437-447, 450-999; LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 POST SB 737-78-1089

- (2) This task gives the instructions on how to remove the strut forward insulation blankets (Figure 402).

LOM ALL

- (3) The strut forward insulation blankets are located near the forward engine mount.

B. References

Reference	Title
54-51-01-040-801	Prepare the Strut for Maintenance Operations (P/B 201)
71-00-02-000-801-F00	Power Plant - Removal (P/B 401)

C. Location Zones

Zone	Area
410	Subzone - Engine 1
420	Subzone - Engine 2
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

D. Prepare for the Removal

SUBTASK 54-54-01-040-002

- (1) Do this task: Prepare the Strut for Maintenance Operations, TASK 54-51-01-040-801.

SUBTASK 54-54-01-860-001

- (2) For Engine 1:

Open these circuit breakers and install safety tags:

CAPT Electrical System Panel, P18-2

Row	Col	Number	Name
B	4	C01003	ENGINE 1 THRUST REVERSER IND

EFFECTIVITY
LOM ALL

54-54-01



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(Continued)

CAPT Electrical System Panel, P18-2

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
B	6	C01412	ENGINE 1 THRUST REVERSER INTLK
B	7	C01266	ENGINE 1 THRUST REVERSER SYNC LOCK

SUBTASK 54-54-01-860-002

- (3) For Engine 2:

Open these circuit breakers and install safety tags:

F/O Electrical System Panel, P6-2

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	5	C01267	ENGINE 2 THRUST REVERSER SYNC LOCK
C	6	C01413	ENGINE 2 THRUST REVERSER INTLK
C	8	C01004	ENGINE 2 THRUST REVERSER IND

SUBTASK 54-54-01-020-001

- (4) Do this task: Power Plant - Removal, TASK 71-00-02-000-801-F00.

SUBTASK 54-54-01-010-002

- (5) Do these steps to disconnect the electrical connectors from the strut receptacles:

- (a) For the left thrust reverser, disconnect the electrical connectors, D30002 and D30006.

NOTE: D30002 connects to a receptacle at the insulation blanket [3]. D30006 connects to a receptacle at the insulation blanket [2].

- (b) For the right thrust reverser, disconnect the electrical connectors, D30008 and D30010.

NOTE: D30008 connects to a receptacle at the insulation blanket [3]. D30010 connects to a receptacle at the insulation blanket [2].

E. Strut Forward Insulation Blankets Removal

SUBTASK 54-54-01-000-001

- (1) Remove the forward insulation blanket [1], do these steps:

- (a) Remove the nuts [19] and washers [18].

- (b) Remove the insulation blanket [1].

SUBTASK 54-54-01-020-002

- (2) Remove the forward insulation blanket [2] or insulation blanket [3], do these steps:

- (a) Remove the bolts [17] and washers [18].

- (b) Remove the insulation blanket [2] or insulation blanket [3].

———— END OF TASK ————

TASK 54-54-01-400-801

3. Strut Forward Insulation Blankets Installation

A. General

LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 PRE SB 737-78-1089

- (1) This task gives the instructions on how to install the strut forward insulation blankets (Figure 401).



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**LOM 427-434, 437-447, 450-999; LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 POST SB
737-78-1089**

- (2) This task gives the instructions on how to install the strut forward insulation blankets (Figure 402).

LOM ALL

- (3) The strut forward insulation blankets are located near the forward engine mount.

B. References

Reference	Title
54-51-01-440-801	Put the Strut Back to its Usual Condition (P/B 201)
71-00-02-400-801-F00	Power Plant - Installation (P/B 401)
78-31-00-700-801-F00	Thrust Reverser Normal Operation Test (P/B 501)
78-31-00-700-806-F00	Thrust Reverser Linear Variable Differential Transformer (LVDT) Test (P/B 501)

C. Location Zones

Zone	Area
410	Subzone - Engine 1
420	Subzone - Engine 2
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

D. Strut Forward Insulation Blankets Installation

SUBTASK 54-54-01-000-002

- (1) Install the forward insulation blanket [1], do these steps:
 - (a) Place the insulation blanket [1] in the correct location.
 - (b) Install the nuts [19] and washers [18].

SUBTASK 54-54-01-020-003

- (2) Install the forward insulation blanket [2] or insulation blanket [3], do these steps:
 - (a) Put the insulation blanket [2] or insulation blanket [3] in the correct location.
 - (b) Install the bolts [17] and washers [18].

SUBTASK 54-54-01-010-003

- (3) Do these steps to connect the electrical connectors to the strut receptacles:
 - (a) For the left thrust reverser, connect the electrical connectors, D30002 and D30006.
NOTE: D30002 connects to a receptacle at the insulation blanket [3]. D30006 connects to a receptacle at the insulation blanket [2].
 - (b) For the right thrust reverser, connect the electrical connectors, D30008 and D30010.
NOTE: D30008 connects to a receptacle at the insulation blanket [3]. D30010 connects to a receptacle at the insulation blanket [2].

E. Put the Airplane Back to Its Usual Condition

SUBTASK 54-54-01-020-004

- (1) Do this task: Power Plant - Installation, TASK 71-00-02-400-801-F00.

SUBTASK 54-54-01-860-003

- (2) For Engine 1:



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Close these circuit breakers:

CAPT Electrical System Panel, P18-2

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
B	4	C01003	ENGINE 1 THRUST REVERSER IND
B	6	C01412	ENGINE 1 THRUST REVERSER INTLK
B	7	C01266	ENGINE 1 THRUST REVERSER SYNC LOCK

SUBTASK 54-54-01-860-004

- (3) For Engine 2:

Close these circuit breakers:

F/O Electrical System Panel, P6-2

<u>Row</u>	<u>Col</u>	<u>Number</u>	<u>Name</u>
C	5	C01267	ENGINE 2 THRUST REVERSER SYNC LOCK
C	6	C01413	ENGINE 2 THRUST REVERSER INTLK
C	8	C01004	ENGINE 2 THRUST REVERSER IND

SUBTASK 54-54-01-040-003

- (4) Do this task: Thrust Reverser Normal Operation Test, TASK 78-31-00-700-801-F00.

SUBTASK 54-54-01-040-004

- (5) Do this task: Thrust Reverser Linear Variable Differential Transformer (LVDT) Test, TASK 78-31-00-700-806-F00.

SUBTASK 54-54-01-040-005

- (6) Do this task: Put the Strut Back to its Usual Condition, TASK 54-51-01-440-801.

———— END OF TASK ————

TASK 54-54-01-000-802

4. Strut Mid Insulation Blankets Removal

A. General

LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 PRE SB 737-78-1089

- (1) This task gives the instructions to remove the strut mid insulation blankets (Figure 401).

LOM 427-434, 437-447, 450-999; LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 POST SB 737-78-1089

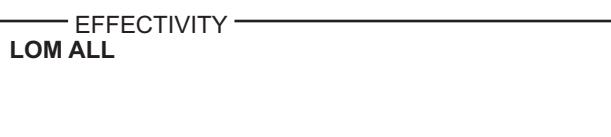
- (2) This task gives the instructions to remove the strut mid insulation blankets (Figure 402).

LOM ALL

- (3) The strut mid insulation blankets are found between the forward and aft engine mounts.
(4) To get access to the mid strut insulation blankets only, open the thrust reversers. If you will also remove the forward or aft insulation blankets, you can remove the power plant for easier access.

B. References

Reference	Title
54-51-01-040-801	Prepare the Strut for Maintenance Operations (P/B 201)
78-31-00-010-801-F00	Open the Thrust Reverser (Selection) (P/B 201)



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C. Location Zones

Zone	Area
410	Subzone - Engine 1
420	Subzone - Engine 2
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

D. Prepare for the Removal

SUBTASK 54-54-01-040-006

- (1) Do this task: Prepare the Strut for Maintenance Operations, TASK 54-51-01-040-801.

SUBTASK 54-54-01-020-005



WARNING

DO THESE SPECIFIED TASKS IN THE CORRECT SEQUENCE BEFORE YOU OPEN THE THRUST REVERSERS: RETRACT THE LEADING EDGE, DO THE DEACTIVATION PROCEDURES FOR THE LEADING EDGE AND THE THRUST REVERSER (FOR GROUND MAINTENANCE), AND OPEN THE FAN COWL PANELS. IF YOU DO NOT OBEY THE ABOVE SEQUENCE, INJURIES TO PERSONS AND DAMAGE TO EQUIPMENT CAN OCCUR.

- (2) Do this task: Open the Thrust Reverser (Selection), TASK 78-31-00-010-801-F00.

E. Strut Mid Insulation Blankets Removal

SUBTASK 54-54-01-000-003



CAUTION

REMOVE AND INSTALL THE INSULATION BLANKETS IN THE CORRECT ORDER GIVEN IN THESE PROCEDURES. IF THE ORDER OF REMOVAL AND INSTALLATION IS NOT FOLLOWED, DAMAGE TO EQUIPMENT CAN OCCUR.

- (1) Remove the mid insulation blankets, do these steps:
- Remove the nuts [19] and washers [18] for the insulation blanket [13].
 - Remove the insulation blanket [13].
 - Remove the nuts [19] and washers [18] for the insulation blanket [12].
 - Remove the insulation blanket [12].
 - Remove the nuts [19] and washers [18] for the insulation blanket [11].
 - Remove the insulation blanket [11].
 - Remove the nuts [19] and washers [18] for the insulation blanket [10].
 - Remove the insulation blanket [10].
 - Remove the nuts [19] and washers [18] for the insulation blanket [9].
 - Remove the insulation blanket [9].
 - Remove the nuts [19] and washers [18] for the insulation blanket [8].
 - Remove the insulation blanket [8].
 - Remove the nuts [19] and washers [18] for the insulation blanket [7].
 - Remove the insulation blanket [7].
 - Remove the nuts [19] and washers [18] for the insulation blanket [6].
 - Remove the insulation blanket [6].
 - Remove the nuts [19] and washers [18] for the insulation blanket [5].

EFFECTIVITY
LOM ALL

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- (r) Remove the insulation blanket [5].
- (s) Remove the nuts [19] and washers [18] for the insulation blanket [4].
- (t) Remove the insulation blanket [4].

— END OF TASK —

TASK 54-54-01-400-802

5. Strut Mid Insulation Blankets Installation

A. General

LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 PRE SB 737-78-1089

- (1) This task gives the instructions to install the strut mid insulation blankets (Figure 401).

LOM 427-434, 437-447, 450-999; LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 POST SB 737-78-1089

- (2) This task gives the instructions to install the strut mid insulation blankets (Figure 402).

LOM ALL

- (3) The strut mid insulation blankets are found between the forward and aft engine mounts.
- (4) To replace one or more mid insulation blankets, they must be installed according to the order indicated below.

B. References

Reference	Title
54-51-01-440-801	Put the Strut Back to its Usual Condition (P/B 201)
78-31-00-010-804-F00	Close the Thrust Reverser (Selection) (P/B 201)

C. Location Zones

Zone	Area
410	Subzone - Engine 1
420	Subzone - Engine 2
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

D. Strut Mid Insulation Blankets Installation

SUBTASK 54-54-01-000-004



CAUTION REMOVE AND INSTALL THE INSULATION BLANKETS IN THE CORRECT ORDER GIVEN IN THESE PROCEDURES. IF THE ORDER OF REMOVAL AND INSTALLATION IS NOT FOLLOWED, DAMAGE TO EQUIPMENT CAN OCCUR.

- (1) Install the mid insulation blankets in the following order:
 - (a) Put the insulation blanket [4] in the correct location.
 - (b) Install the nuts [19] and washers [18].
 - (c) Put the insulation blanket [5] in the correct location.
 - (d) Install the nuts [19] and washers [18].
 - (e) Put the insulation blanket [6] in the correct location.
 - (f) Install the nuts [19] and washers [18].
 - (g) Put the insulation blanket [7] in the correct location.

EFFECTIVITY
LOM ALL

54-54-01



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- (h) Install the nuts [19] and washers [18].
- (i) Put the insulation blanket [8] in the correct location.
- (j) Install the nuts [19] and washers [18].
- (k) Put the insulation blanket [9] in the correct location.
- (l) Install the nuts [19] and washers [18].
- (m) Put the insulation blanket [10] in the correct location.
- (n) Install the nuts [19] and washers [18].
- (o) Put the insulation blanket [11] in the correct location.
- (p) Install the nuts [19] and washers [18].
- (q) Put the insulation blanket [12] in the correct location.
- (r) Install the nuts [19] and washers [18].
- (s) Put the insulation blanket [13] in the correct location.
- (t) Install the nuts [19] and washers [18].

E. Put the Airplane Back to Its Usual Condition

SUBTASK 54-54-01-020-006

- (1) Do this task: Close the Thrust Reverser (Selection), TASK 78-31-00-010-804-F00.

SUBTASK 54-54-01-040-007

- (2) Do this task: Put the Strut Back to its Usual Condition, TASK 54-51-01-440-801.

————— END OF TASK ————

LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 PRE SB 737-78-1089

TASK 54-54-01-000-803

6. Strut Aft Insulation Blankets Removal

(Figure 401)

A. General

- (1) This task gives the instructions to remove the strut aft insulation blankets.
- (2) The strut aft insulation blankets are found aft of the aft engine mount.
- (3) To get access to the aft strut insulation blankets only, remove the exhaust nozzle. If you will also remove the forward or mid insulation blankets, you can remove the power plant for easier access.

B. References

Reference	Title
54-51-01-040-801	Prepare the Strut for Maintenance Operations (P/B 201)
78-11-01-000-801-F00	Primary Nozzle Assembly Removal (P/B 401)

C. Location Zones

Zone	Area
410	Subzone - Engine 1
420	Subzone - Engine 2
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut



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LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 PRE SB 737-78-1089 (Continued)

D. Prepare for the Removal

SUBTASK 54-54-01-040-008

- (1) Do this task: Prepare the Strut for Maintenance Operations, TASK 54-51-01-040-801.

SUBTASK 54-54-01-020-007

- (2) Do this task: Primary Nozzle Assembly Removal, TASK 78-11-01-000-801-F00.

E. Strut Aft Insulation Blankets Removal

SUBTASK 54-54-01-000-005

- (1) Remove the aft insulation blankets, do these steps:

- (a) Remove the nuts [19] and washers [18] for the insulation blanket [14].
1) Remove the bolt [17], washers [18], and nut [19] to disconnect the aft end of the insulation blanket [14].
- (b) Remove the nuts [19] and washers [18] for the insulation blanket [15].
1) Make sure that the forward end of the insulation blanket [15] is disconnected.
NOTE: This is done in one of the steps to remove the insulation blanket [14].

LOM 402, 404, 406, 407 PRE SB 737-54-1045 AND PRE SB 737-78-1089

- (c) Remove the nuts [19], bolts [17], and washers [18] for the insulation blanket [16].

LOM 402, 404, 406, 407 POST SB 737-54-1045 AND PRE SB 737-78-1089; LOM 411, 412, 415, 416, 420, 422-426 PRE SB 737-78-1089

- (d) Do the steps that follow to remove the insulation blanket [16]:
1) Remove the cover plate, do these steps:
a) Remove the bolts [23], washers [24], and spacers [25] (View A-A, Figure 401).
b) Remove the bolts [26], washers [27], and spacers [28] (View B-B, Figure 401).
2) Remove the bolts [22] and washers [21] (View C, Figure 401).
3) Remove the bolts [29] and washers [30] (View H, Figure 401).
4) Remove the nuts [20] and washers [21] (View G, Figure 401).
5) Remove the insulation blanket [16].

LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 PRE SB 737-78-1089

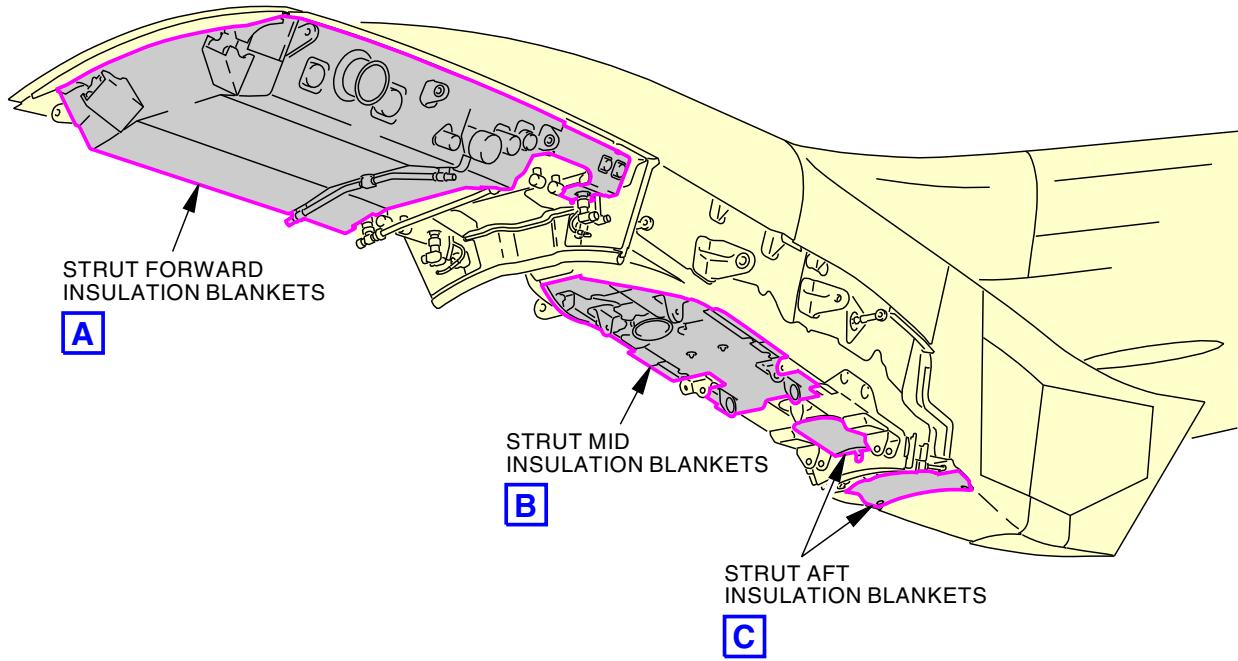
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EFFECTIVITY
LOM ALL

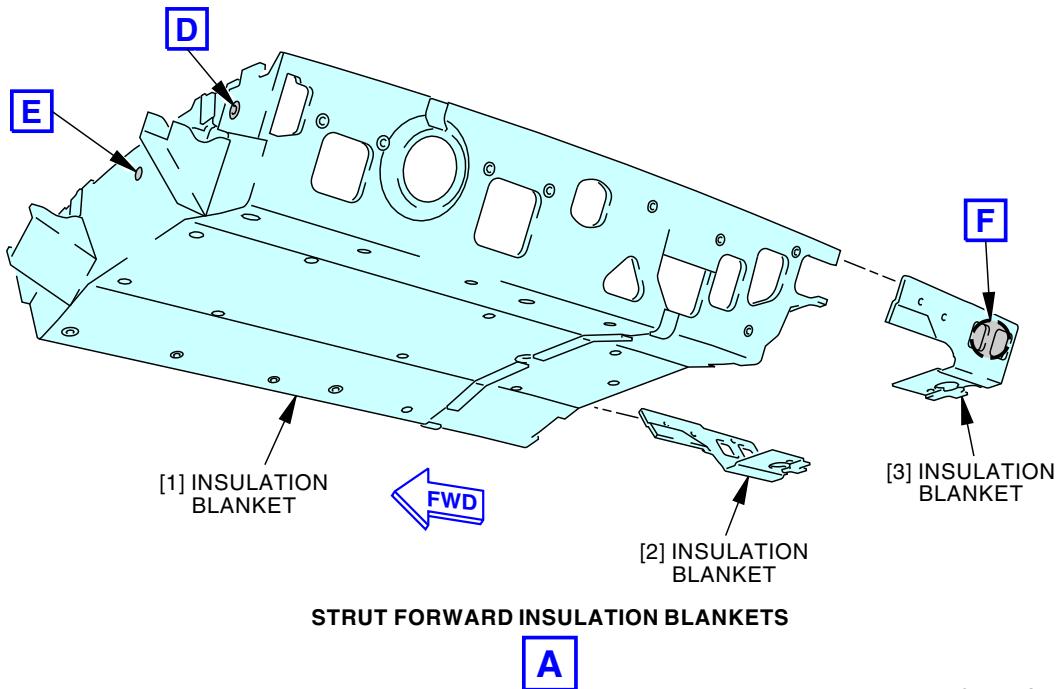
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LEFT STRUT INSULATION BLANKETS
(RIGHT STRUT INSULATION BLANKETS ARE EQUIVALENT)



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Strut Insulation Blankets Installation
Figure 401/54-54-01-990-807 (Sheet 1 of 5)

EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-78-1089

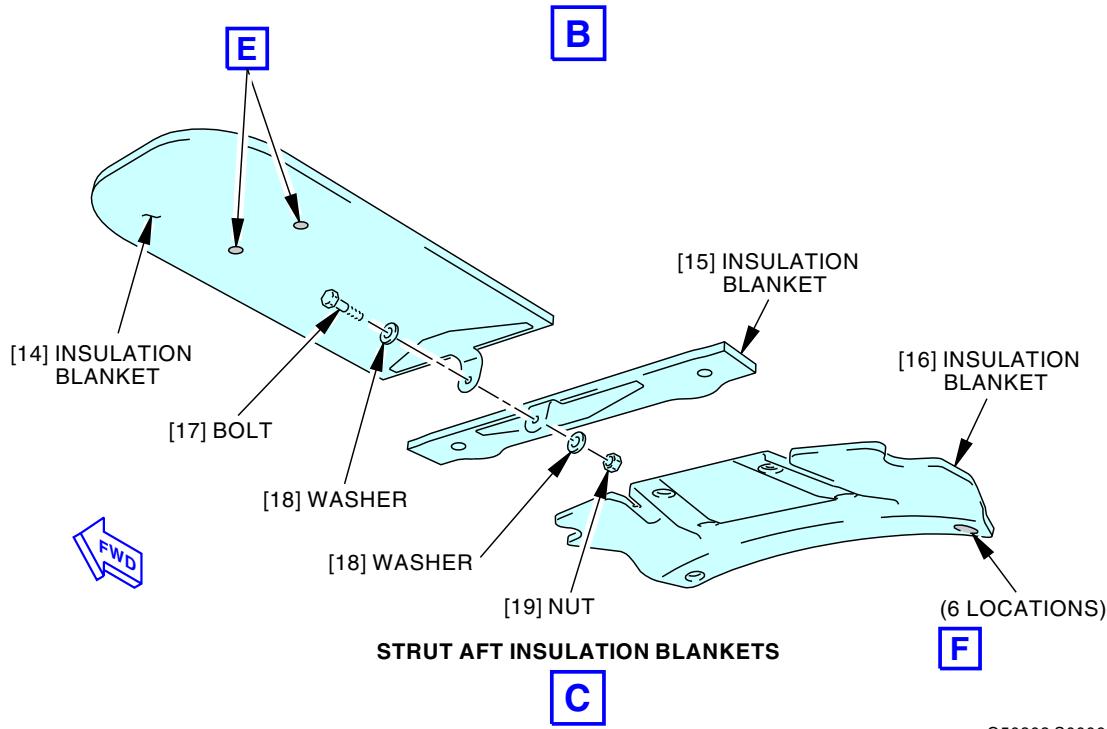
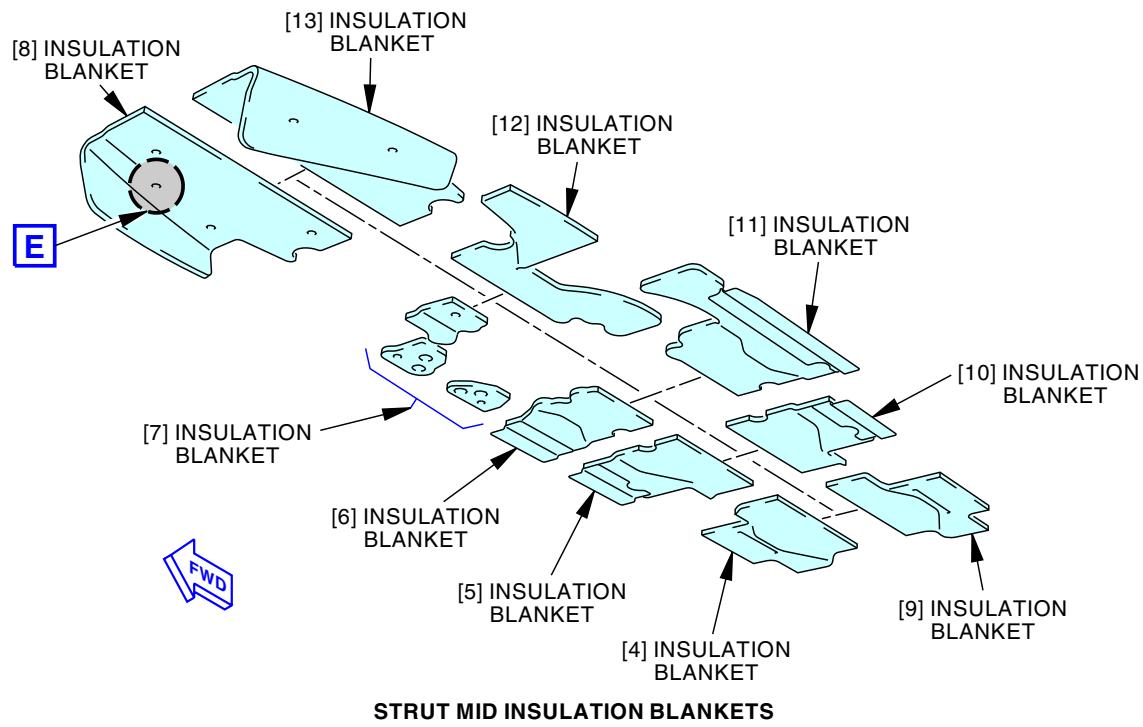
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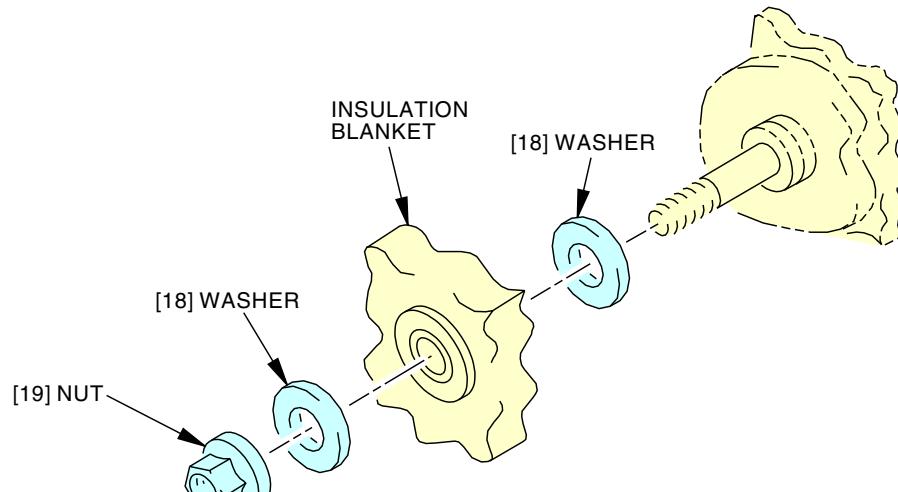


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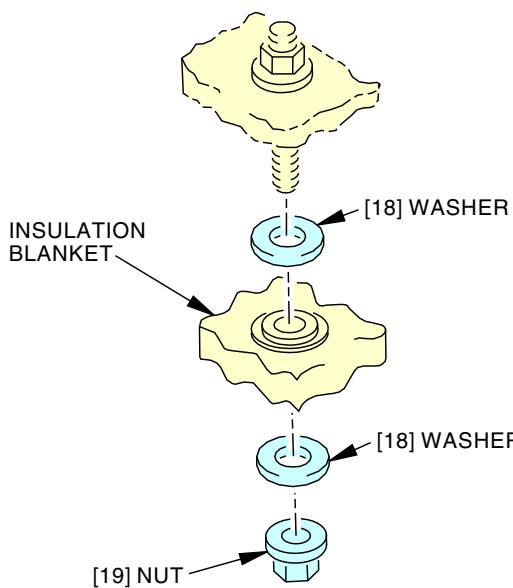
**Strut Insulation Blankets Installation
Figure 401/54-54-01-990-807 (Sheet 2 of 5)**

EFFECTIVITY
LOM 402, 404, 406, 407 PRE SB 737-54-1045 AND
PRE SB 737-78-1089

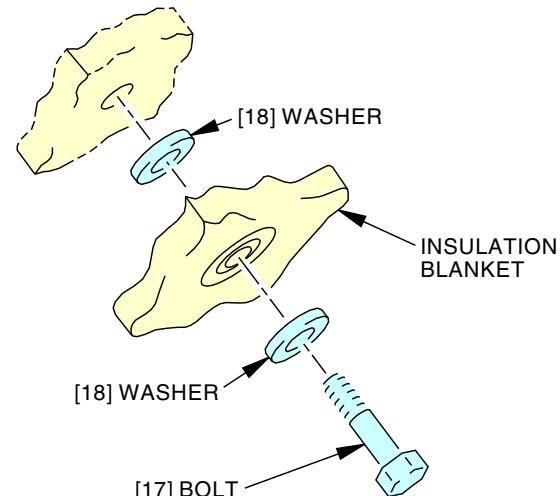
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(EXAMPLE)
D



(EXAMPLE)
E



(EXAMPLE)
F

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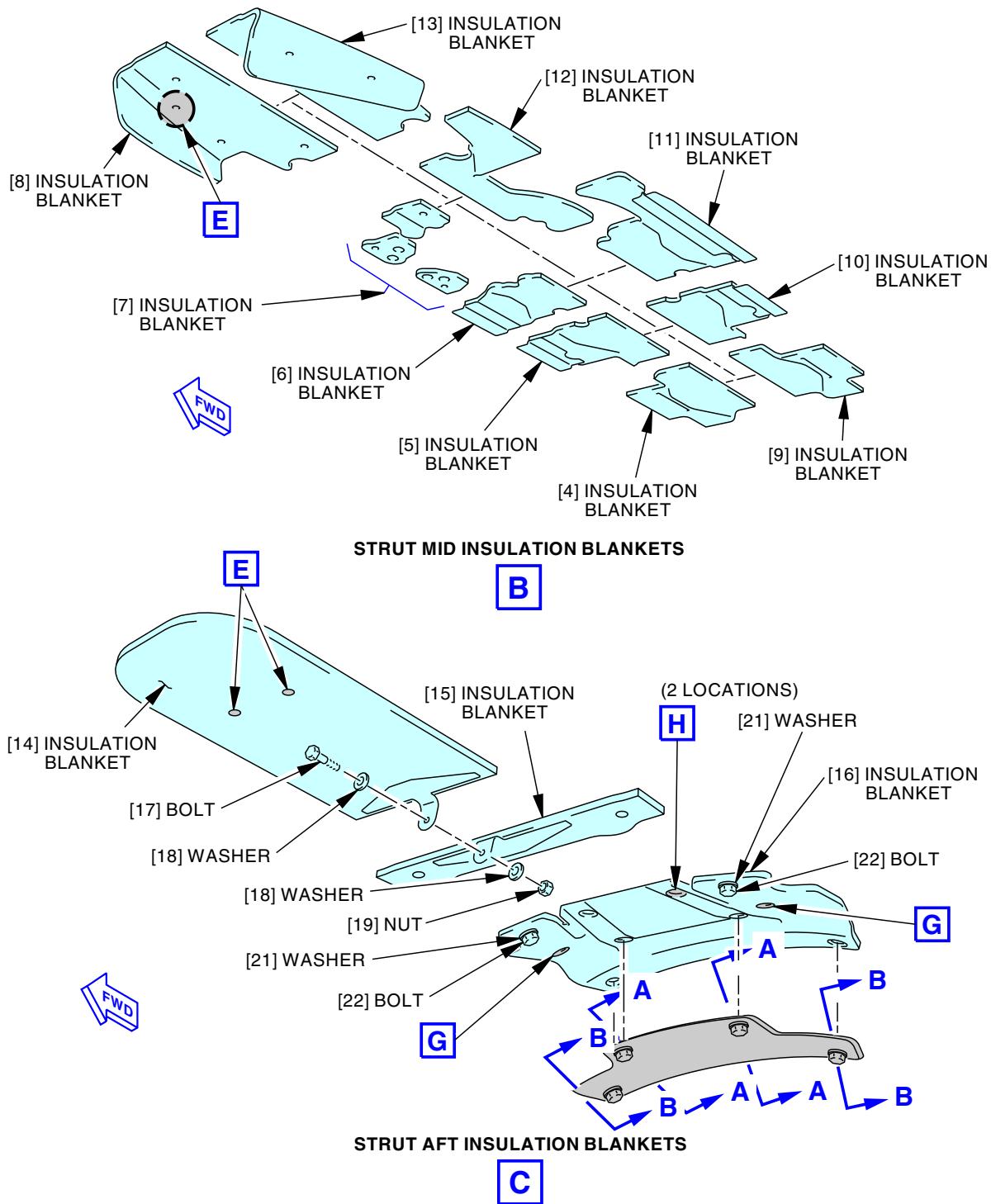
**Strut Insulation Blankets Installation
Figure 401/54-54-01-990-807 (Sheet 3 of 5)**

EFFECTIVITY
LOM 402, 404, 406, 407 PRE SB 737-54-1045 AND
PRE SB 737-78-1089

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AIRCRAFT MAINTENANCE MANUAL**


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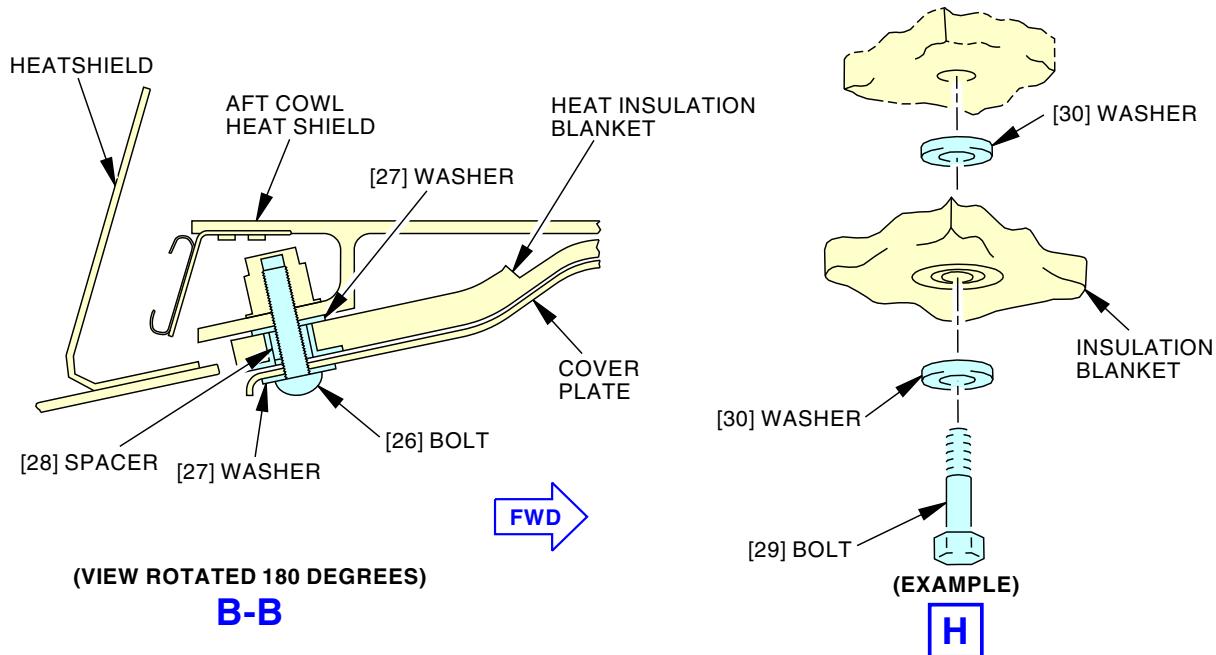
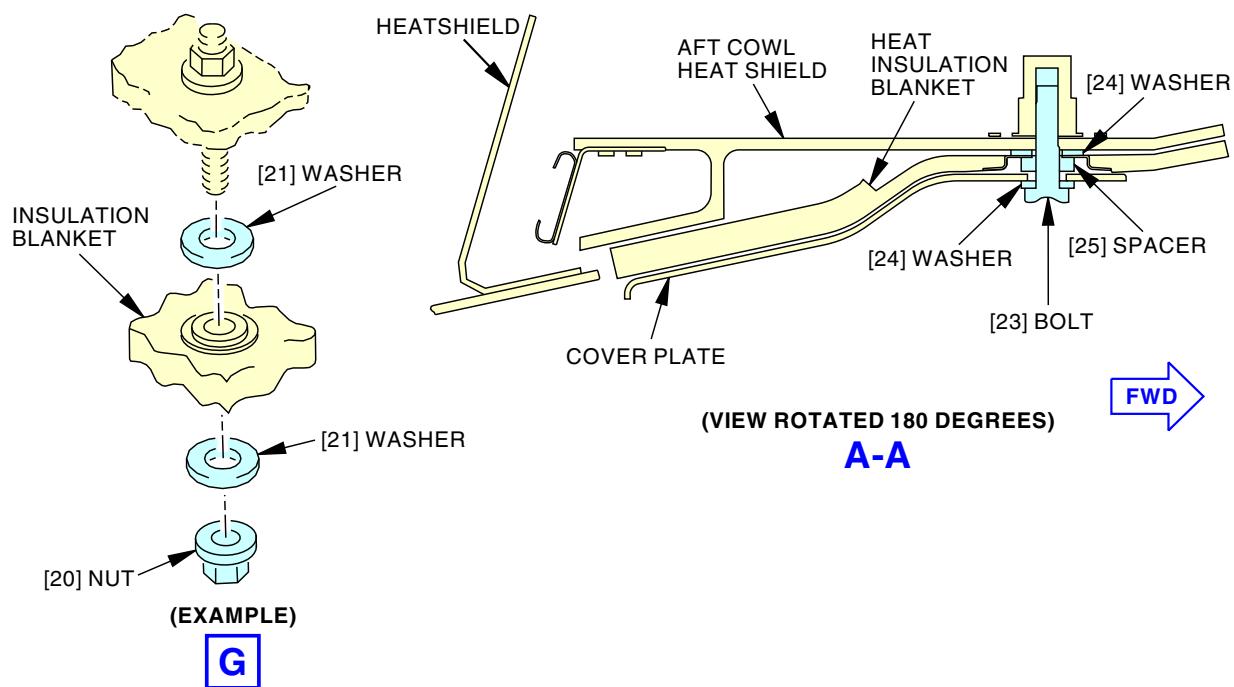
Strut Insulation Blankets Installation
Figure 401/54-54-01-990-807 (Sheet 4 of 5)

EFFECTIVITY
 LOM 402, 404, 406, 407 POST SB 737-54-1045 AND
 PRE SB 737-78-1089; LOM 411, 412, 415, 416, 420,
 422-426 PRE SB 737-78-1089

54-54-01

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details



1347542 S0000240728_V4

Strut Insulation Blankets Installation
Figure 401/54-54-01-990-807 (Sheet 5 of 5)

EFFECTIVITY
 LOM 402, 404, 406, 407 POST SB 737-54-1045 AND
 PRE SB 737-78-1089; LOM 411, 412, 415, 416, 420,
 422-426 PRE SB 737-78-1089

54-54-01

D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details



737-600/700/800/900
AIRCRAFT MAINTENANCE MANUAL

LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 PRE SB 737-78-1089 (Continued)

TASK 54-54-01-400-803

7. Strut Aft Insulation Blankets Installation

(Figure 401)

A. General

- (1) This task gives the instructions to install the strut aft insulation blankets.
- (2) The strut aft insulation blankets are found aft of the aft engine mount.

B. References

Reference	Title
54-51-01-440-801	Put the Strut Back to its Usual Condition (P/B 201)
78-11-01-400-801-F00	Primary Nozzle Assembly Installation (P/B 401)

C. Location Zones

Zone	Area
410	Subzone - Engine 1
420	Subzone - Engine 2
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

D. Strut Aft Insulation Blankets Installation

SUBTASK 54-54-01-000-006

- (1) Install the aft insulation blankets, do these steps:
 - (a) Install the nuts [19] and washers [18] for the insulation blanket [14].
 - 1) Install the bolt [17], washers [18], and nut [19] to connect the aft end of the insulation blanket [14].
 - (b) Install the nuts [19] and washers [18] for the insulation blanket [15].
 - 1) Make sure that the forward end of the insulation blanket [15] is connected.

NOTE: This is done in one of the steps to install the insulation blanket [14].

LOM 402, 404, 406, 407 PRE SB 737-54-1045 AND PRE SB 737-78-1089

- (c) Install the nuts [19], bolts [17], and washers [18] for the insulation blanket [16].

LOM 402, 404, 406, 407 POST SB 737-54-1045 AND PRE SB 737-78-1089; LOM 411, 412, 415, 416, 420, 422-426 PRE SB 737-78-1089

- (d) Do the steps that follow to install the insulation blanket [16]:
 - 1) Put the insulation blanket [16] in its position.
 - 2) Install the bolts [22] and washers [21] (View C, Figure 401).
 - 3) Install the bolts [29] and washers [30] (View H, Figure 401).
 - 4) Install the nuts [20] and washers [21] (View G, Figure 401).
 - 5) Install the cover plate, do these steps:
 - a) Put the cover plate in its position.
 - b) Install the bolts [23], washers [24], and spacers [25] (View A-A, Figure 401).

EFFECTIVITY
LOM ALL

54-54-01



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**LOM 402, 404, 406, 407 POST SB 737-54-1045 AND PRE SB 737-78-1089; LOM 411, 412, 415, 416, 420, 422-426
PRE SB 737-78-1089 (Continued)**

- c) Install the bolts [26], washers [27], and spacers [28] (View B-B, Figure 401).

LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 PRE SB 737-78-1089

E. Put the Airplane Back to Its Usual Condition

SUBTASK 54-54-01-020-008

- (1) Do this task: Primary Nozzle Assembly Installation, TASK 78-11-01-400-801-F00.

SUBTASK 54-54-01-040-009

- (2) Do this task: Put the Strut Back to its Usual Condition, TASK 54-51-01-440-801.

———— END OF TASK ————

**LOM 427-434, 437-447, 450-999; LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 POST SB
737-78-1089**

TASK 54-54-01-000-804

8. Strut Aft Insulation Blankets Removal

(Figure 402)

A. References

Reference	Title
54-51-01-040-801	Prepare the Strut for Maintenance Operations (P/B 201)
78-11-01-000-802-F00	Primary Nozzle Assembly Removal (P/B 401)

B. Prepare for the Removal

SUBTASK 54-54-01-040-010

- (1) Do this task: Prepare the Strut for Maintenance Operations, TASK 54-51-01-040-801.

SUBTASK 54-54-01-010-004

- (2) Do this task: Primary Nozzle Assembly Removal, TASK 78-11-01-000-802-F00.

C. Strut Aft Insulation Blankets Removal

SUBTASK 54-54-01-020-009

- (1) Remove the aft insulation blankets, do these steps:

- (a) Remove the nuts [19] and washers [18] for the insulation blanket [14].

- 1) Remove the bolt [17], washers [18], and nut [19] to disconnect the aft end of the insulation blanket [14].

- (b) Remove the nuts [19] and washers [18] for the insulation blanket [15].

- 1) Make sure that the forward end of the insulation blanket [15] is disconnected.

NOTE: This is done in one of the steps to remove the insulation blanket [14].

- (c) Do the steps that follow to remove the insulation blanket [16]:

- 1) Remove the cover plate, do these steps:

- a) Remove the bolts [23], washers [24], and spacers [25] (View A-A, Figure 402).

- b) Remove the bolts [26], washers [27], and spacers [28] (View B-B, View C-C, Figure 402).

- 2) Remove the bolts [22] and washers [21] (View C, Figure 402).

- 3) Remove the bolts [29] and washers [30] (View H, Figure 402).

EFFECTIVITY
LOM ALL

54-54-01



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**LOM 427-434, 437-447, 450-999; LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 POST SB
737-78-1089 (Continued)**

- 4) Remove the nuts [20] and washers [21] (View G, Figure 402).
- 5) Remove the insulation blanket [16].

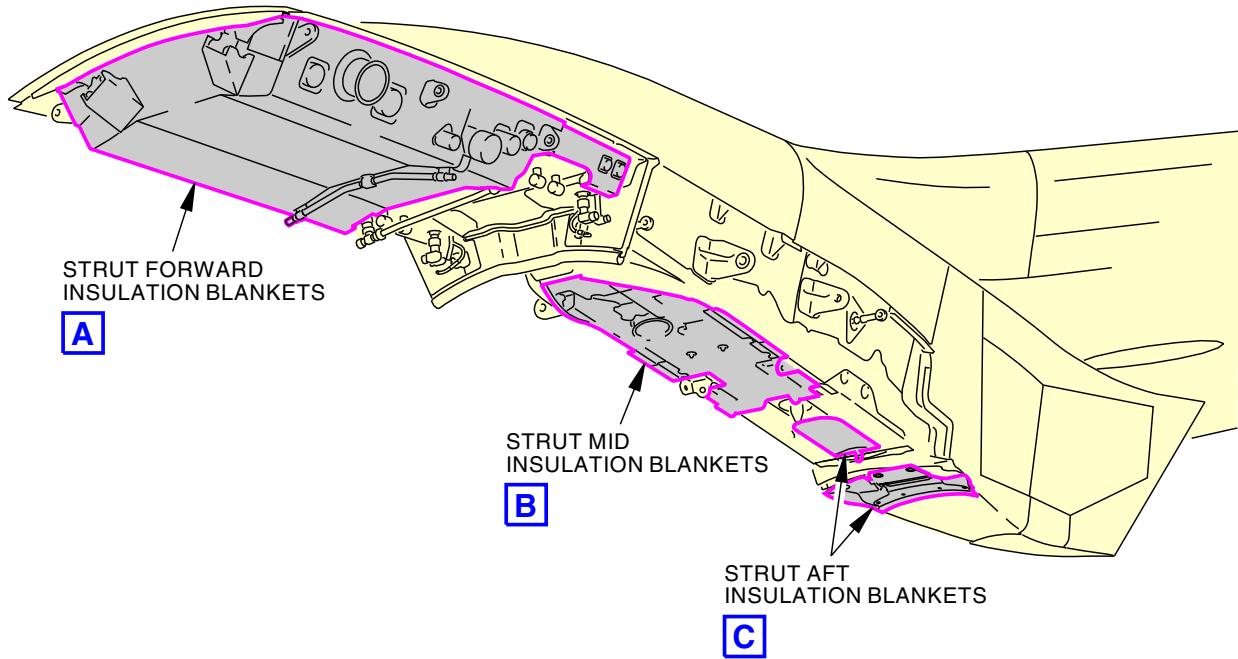
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— EFFECTIVITY —
LOM ALL

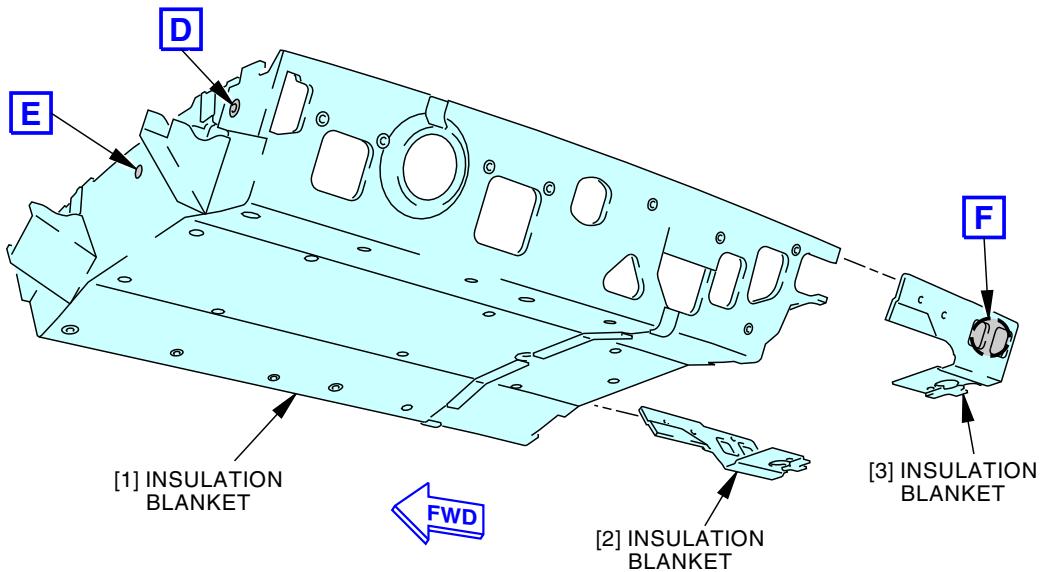
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**LEFT STRUT INSULATION BLANKETS
(RIGHT STRUT INSULATION BLANKETS ARE EQUIVALENT)**



STRUT FORWARD INSULATION BLANKETS

A

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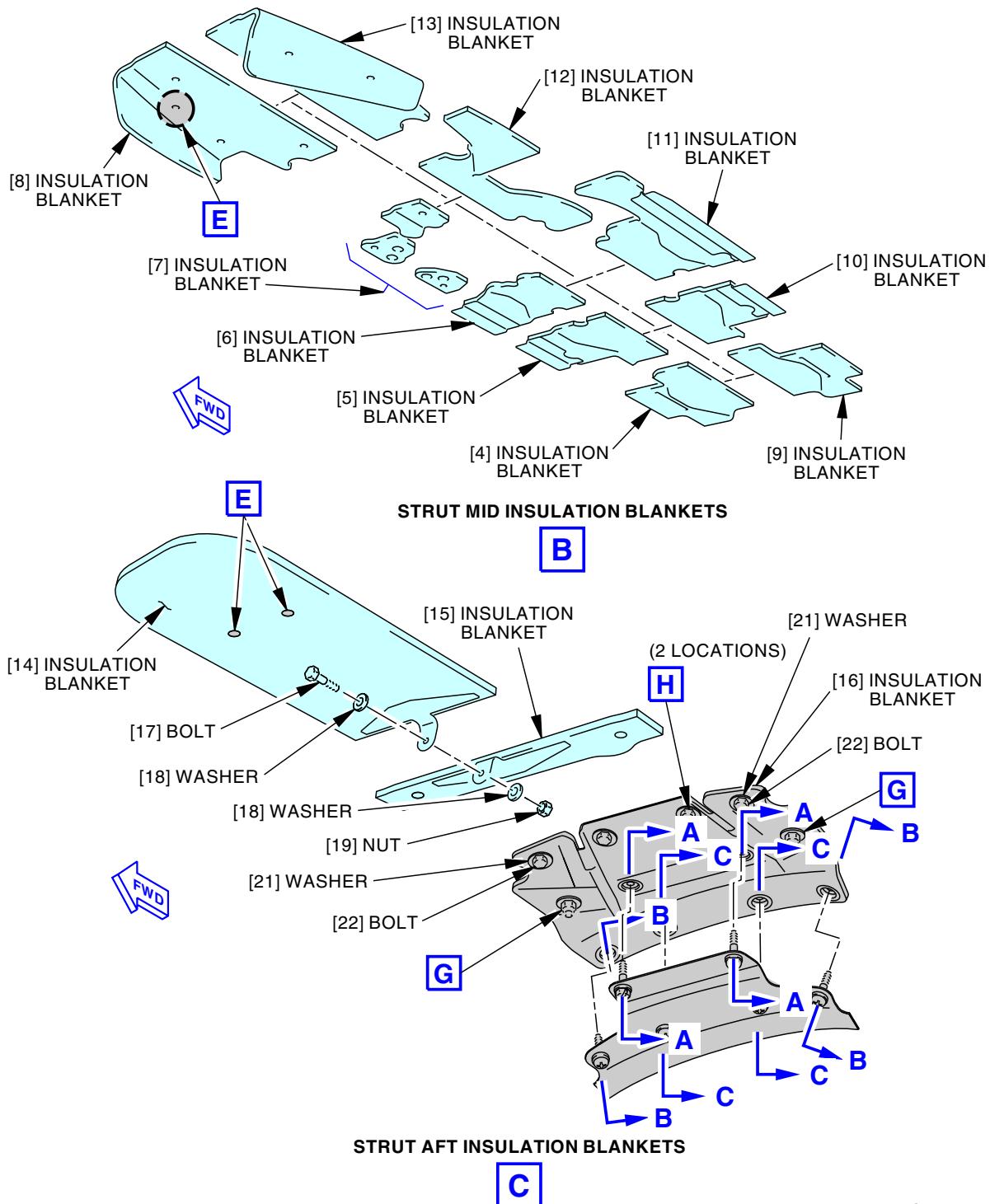
**Strut Insulation Blankets Installation
Figure 402/54-54-01-990-806 (Sheet 1 of 4)**

EFFECTIVITY
LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
407, 411, 412, 415, 416, 420, 422-426 POST SB
737-78-1089

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**737-600/700/800/900
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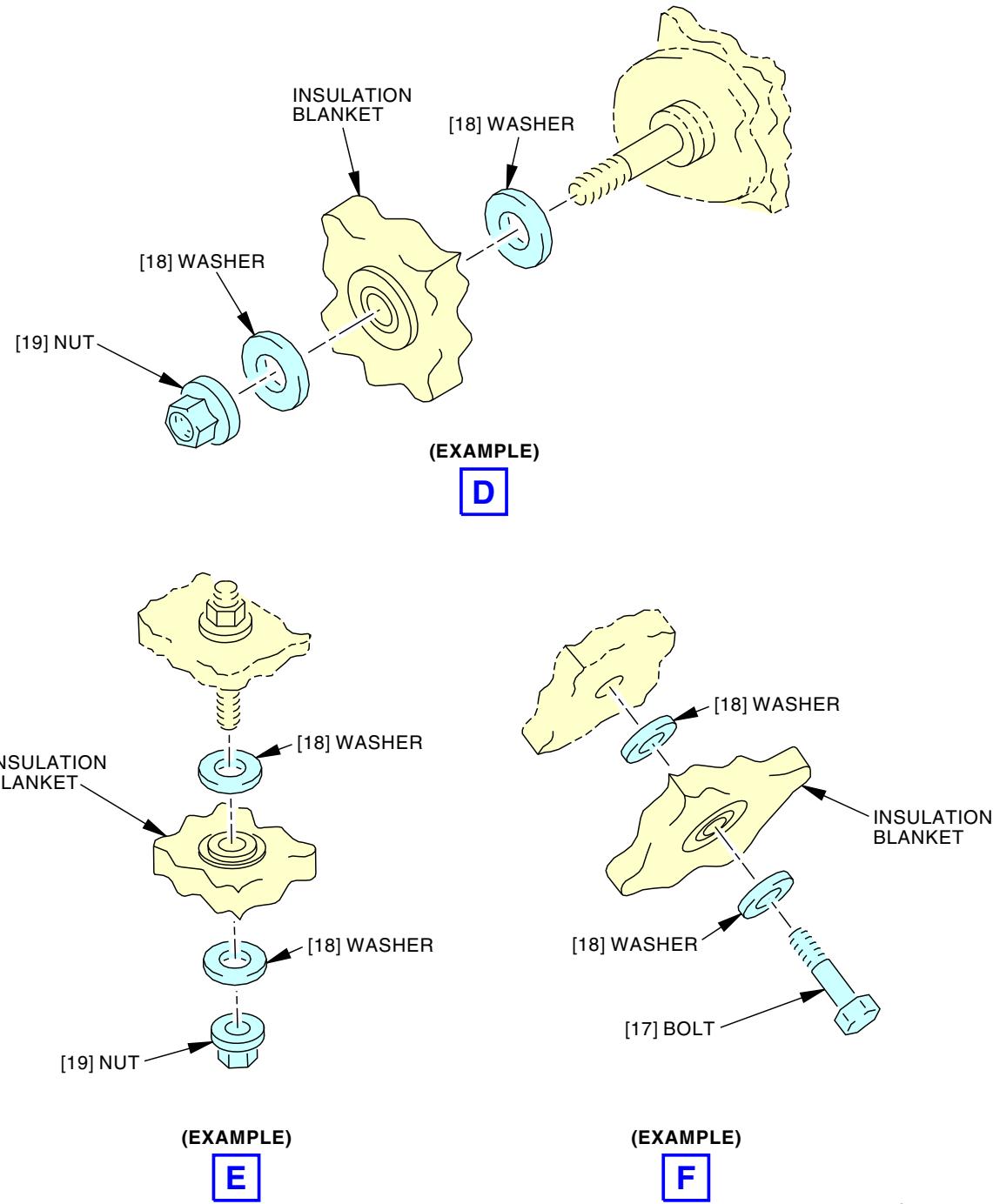
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Strut Insulation Blankets Installation
Figure 402/54-54-01-990-806 (Sheet 2 of 4)

EFFECTIVITY
 LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
 407, 411, 412, 415, 416, 420, 422-426 POST SB
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**Strut Insulation Blankets Installation
Figure 402/54-54-01-990-806 (Sheet 3 of 4)**

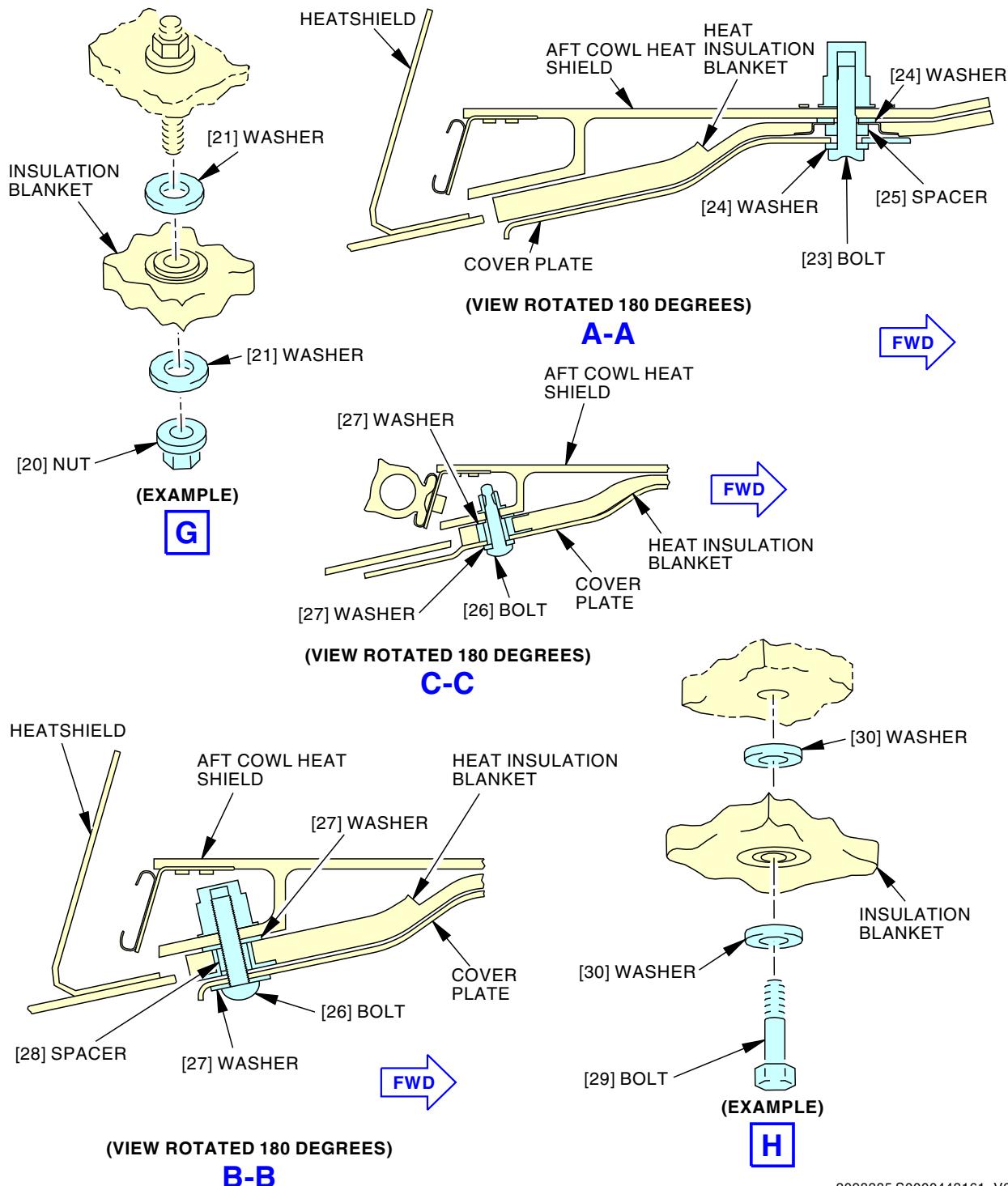
EFFECTIVITY
 LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
 407, 411, 412, 415, 416, 420, 422-426 POST SB
 737-78-1089

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D633A101-LOM

ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AIRCRAFT MAINTENANCE MANUAL**



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**Strut Insulation Blankets Installation
Figure 402/54-54-01-990-806 (Sheet 4 of 4)**

EFFECTIVITY
LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
407, 411, 412, 415, 416, 420, 422-426 POST SB
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**LOM 427-434, 437-447, 450-999; LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 POST SB
737-78-1089 (Continued)**

TASK 54-54-01-400-804

9. Strut Aft Insulation Blankets Installation

(Figure 402)

A. General

- (1) This task gives the instructions to install the strut aft insulation blankets.
- (2) The strut aft insulation blankets are found aft of the aft engine mount.

B. References

Reference	Title
54-51-01-440-801	Put the Strut Back to its Usual Condition (P/B 201)
78-11-01-400-802-F00	Primary Nozzle Assembly Installation (P/B 401)

C. Location Zones

Zone	Area
410	Subzone - Engine 1
420	Subzone - Engine 2
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

D. Strut Aft Insulation Blankets Installation

SUBTASK 54-54-01-420-001

- (1) Install the aft insulation blankets, do these steps:
 - (a) Install the nuts [19] and washers [18] for the insulation blanket [14].
 - 1) Remove the bolt [17], washers [18], and nut [19] to connect the aft end of the insulation blanket [14].
 - (b) Install the nuts [19] and washers [18] for the insulation blanket [15].
 - 1) Make sure that the forward end of the insulation blanket [15] is connected.
NOTE: This is done in one of the steps to install the insulation blanket [14].
 - (c) Do the steps that follow to install the insulation blanket [16]:
 - 1) Put the insulation blanket [16] in its position.
 - 2) Install the bolts [22] and washers [21] (View C, Figure 402).
 - 3) Install the bolts [29] and washers [30] (View H, Figure 402).
 - 4) Install the nuts [20] and washers [21] (View G, Figure 402).
 - 5) Install the cover plate, do these steps:
 - a) Put the cover plate in its position.
 - b) Install the bolts [23], washers [24], and spacers [25] (View A-A, Figure 402).
 - c) Install the bolts [26], washers [27], and spacers [28] (View B-B, View C-C, Figure 402).

E. Put the Airplane Back to Its Usual Condition

SUBTASK 54-54-01-410-002

- (1) Do this task: Primary Nozzle Assembly Installation, TASK 78-11-01-400-802-F00.

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LOM ALL	

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**LOM 427-434, 437-447, 450-999; LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 POST SB
737-78-1089 (Continued)**

SUBTASK 54-54-01-440-002

- (2) Do this task: Put the Strut Back to its Usual Condition, TASK 54-51-01-440-801.

———— END OF TASK ————

— EFFECTIVITY —
LOM ALL

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STRUT INSULATION BLANKETS - INSPECTION/CHECK

1. General

- A. This procedure has this task:
 - (1) An examination of the strut insulation blankets.

TASK 54-54-01-200-801

2. Strut Insulation Blankets Inspection

A. General

- (1) This task examines the strut insulation blankets.
- (2) This task has these steps:
 - (a) Get access to the strut insulation blankets.
 - (b) Examine the strut insulation blankets for damage.
 - (c) Close access to the strut insulation blankets.

B. References

Reference	Title
54-51-01-040-801	Prepare the Strut for Maintenance Operations (P/B 201)
54-51-01-440-801	Put the Strut Back to its Usual Condition (P/B 201)
54-54-01-000-801	Strut Forward Insulation Blankets Removal (P/B 401)
54-54-01-000-802	Strut Mid Insulation Blankets Removal (P/B 401)
54-54-01-000-803	Strut Aft Insulation Blankets Removal (P/B 401)
54-54-01-000-804	Strut Aft Insulation Blankets Removal (P/B 401)
54-54-01-400-801	Strut Forward Insulation Blankets Installation (P/B 401)
54-54-01-400-802	Strut Mid Insulation Blankets Installation (P/B 401)
54-54-01-400-803	Strut Aft Insulation Blankets Installation (P/B 401)
54-54-01-400-804	Strut Aft Insulation Blankets Installation (P/B 401)

C. Location Zones

Zone	Area
434	Engine 1 - Aft Strut Fairing
444	Engine 2 - Aft Strut Fairing

D. Prepare for the Examination

SUBTASK 54-54-01-040-001

- (1) Do this task: Prepare the Strut for Maintenance Operations, TASK 54-51-01-040-801.

SUBTASK 54-54-01-010-001

- (2) Get access to the applicable strut insulation blankets:
 - (a) Do this task: Strut Forward Insulation Blankets Removal, TASK 54-54-01-000-801.
 - (b) Do this task: Strut Mid Insulation Blankets Removal, TASK 54-54-01-000-802.

LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 PRE SB 737-78-1089

- (c) Do this task: Strut Aft Insulation Blankets Removal, TASK 54-54-01-000-803.

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**LOM 427-434, 437-447, 450-999; LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 POST SB
737-78-1089**

- (d) Do this task: Strut Aft Insulation Blankets Removal, TASK 54-54-01-000-804.

LOM ALL

E. Strut Insulation Blanket Examination

SUBTASK 54-54-01-210-001

- (1) Make sure the strut insulation blankets are not damaged or missing.

SUBTASK 54-54-01-960-001

- (2) Replace any insulation blankets that are damaged or missing.

F. Put the Airplane Back to Its Usual Condition

SUBTASK 54-54-01-410-001

- (1) Install the applicable insulation blankets:

- (a) Do this task: Strut Forward Insulation Blankets Installation, TASK 54-54-01-400-801.
(b) Do this task: Strut Mid Insulation Blankets Installation, TASK 54-54-01-400-802.

LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 PRE SB 737-78-1089

- (c) Do this task: Strut Aft Insulation Blankets Installation, TASK 54-54-01-400-803.

**LOM 427-434, 437-447, 450-999; LOM 402, 404, 406, 407, 411, 412, 415, 416, 420, 422-426 POST SB
737-78-1089**

- (d) Do this task: Strut Aft Insulation Blankets Installation, TASK 54-54-01-400-804.

LOM ALL

SUBTASK 54-54-01-440-001

- (2) If you will do no more maintenance operations, do this task: Put the Strut Back to its Usual Condition, TASK 54-51-01-440-801.

———— END OF TASK ————

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STRUT INSULATION BLANKETS - REPAIR

1. General

- A. This procedure contains these tasks:
- (1) A repair of the strut insulation blankets on the aircraft.
 - (2) A repair of the strut insulation blankets off the aircraft.

TASK 54-54-01-300-801

2. Strut Insulation Blanket Repair On-Aircraft

A. General

- (1) Punctures, creases, tears, cracks and scores sustained by dimpled foil skins on insulation blankets are temporary repaired by sealing with RTV sealant when on the airframe.
- (2) This task is a temporary procedure.
 - (a) Blankets repaired using this method must be permanently repaired within 500 hours, do this task: Strut Insulation Blanket Repair Off-Aircraft, TASK 54-54-01-300-802.

B. Consumable Materials

Reference	Description	Specification
A00081	Adhesive - Silicone Rubber - RTV 106	BAC5010 Type 74
A00281	Adhesive - Dow Corning 3145 RTV	MIL-A-46146 (BAC5010 Type 79)
A50154	SilcoSet 152 - cold cure, white, silicone compound	
B50118	Solvent - General	BAC5750
C00954	Primer - Adhesive Bonding - SS4004P RTV	BAC5010 Type 74
G00834	Cloth - Lint-free Cotton	

C. Prepare to Repair the Blanket

SUBTASK 54-54-01-940-003

- (1) If the damage is within the following limits, the insulation blankets can be repaired.
 - A hole in the hot or cold face sheet is not more than 0.25 in. (6.35 mm) in diameter.
 - A gash in the hot or cold face sheet is not longer than 4 in. (102 mm).
 - Around each damaged area in all directions, there is a minimum surface distance that is not damaged of not less than 0.5 in. (12.7 mm).
 - The damaged area is not less than 0.5 in. (12.7 mm) from a grommet, sharp bend, attaching parts or edge.

SUBTASK 54-54-01-210-004

- (2) Visually examine the insulant to ensure there are no voids in the damaged area and no signs of fluid ingress.
 - (a) If there is evidence of voids or fluid ingress within the insulation the CRES blanket must be replaced.

SUBTASK 54-54-01-110-002

- (3) Carefully clean and degrease around the damaged area using general solvent, B50118 on a clean lint-free cloth, G00834 ensuring solvent does not get into the insulant.

SUBTASK 54-54-01-370-001

- (4) Prime the metallic surface using SS4004P RTV primer, C00954.

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SUBTASK 54-54-01-350-004

- (5) A layer of CRES foil is to be bonded to the damaged area using one of the following RTV:
- RTV 106 adhesive, A00081
 - Dow Corning 3145 RTV adhesive, A00281
 - Silcoset 152 adhesive, A50154

SUBTASK 54-54-01-350-005

- (6) Apply RTV sealant to the damaged skin in enough quantity to ensure any hole in the skin is covered.
- (a) Smooth over using a suitable spatula ensuring that the RTV overlaps the edge of the damaged skin by approximately $\frac{1}{2}$ in. (13 mm) and to a maximum depth of approximately $\frac{1}{8}$ in. (3 mm).

SUBTASK 54-54-01-350-006

- (7) A CRES patch which is primed and overlaps the damaged area by $\frac{1}{2}$ in. (13 mm) is then to be pressed into the RTV and held in position until the RTV cures and the CRES is bonded in position.

SUBTASK 54-54-01-940-004

- (8) This should only be considered as a temporary repair and as soon as the blanket is removed from the aircraft, the RTV should be removed and a metallic patch welded within 500 hours, do this task: Strut Insulation Blanket Repair Off-Aircraft, TASK 54-54-01-300-802.

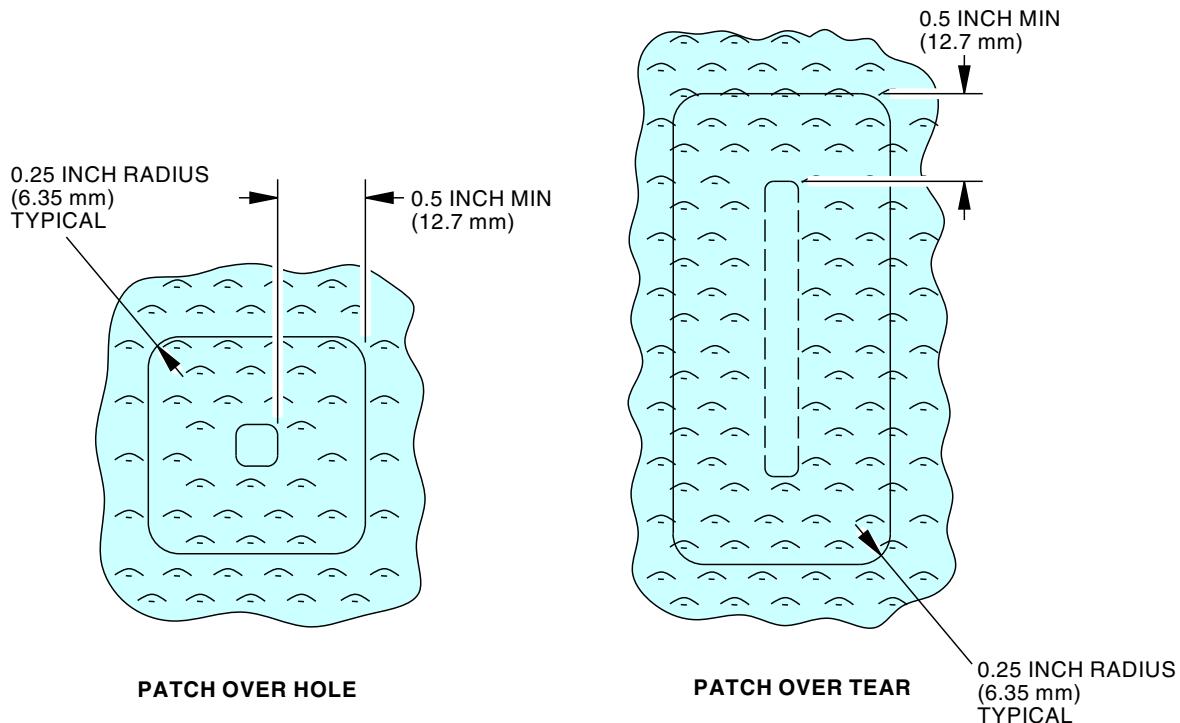
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EFFECTIVITY
LOM ALL

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Insulation Blanket Repair Patch
Figure 801/54-54-01-990-804

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TASK 54-54-01-300-802

3. Strut Insulation Blanket Repair Off-Aircraft

A. General

- (1) Punctures, creases, tears, cracks and scores sustained by dimpled foil skins on insulation blankets are permanently repaired by covering the area with a patch of dimpled foil which is resistance welded to the dimpled foil skin when the blanket is off the airframe.
- (2) This repair is a permanent repair.

B. Consumable Materials

Reference	Description	Specification
B50118	Solvent - General	BAC5750
G00834	Cloth - Lint-free Cotton	

C. Prepare to Repair the Blanket

SUBTASK 54-54-01-210-002

- (1) If the damage is within the following limits, the insulation blankets can be repaired.
 - A hole in the hot or cold face sheet is not more than $\frac{1}{4}$ in. (6 mm) in diameter.
 - A gash in the hot or cold face sheet is not longer than 4 in. (102 mm).
 - Around each damaged area in all directions, there is a minimum surface distance that is not damaged of not less than $\frac{1}{2}$ in. (13 mm).
 - The damaged area is not less than $\frac{1}{2}$ in. (13 mm) from a grommet, sharp bend, attaching parts or edge.

SUBTASK 54-54-01-350-001

- (2) Trim dimpled foil skin around area of damage to remove ragged edges.
 - (a) In the case of a clean crack or gash, using a sharp object, pierce two stop holes approximately $\frac{1}{16}$ in. (2 mm) dia at each end approximately $\frac{1}{16}$ in. (2 mm) from each end of crack to prevent spreading.

SUBTASK 54-54-01-210-003

- (3) Visually examine the insulant to ensure there are no voids in the damaged area and no signs of fluid ingress.
 - (a) If there is evidence of voids or fluid ingress within the insulation the CRES blanket must be replaced.

SUBTASK 54-54-01-350-002

- (4) Cut patch from clean dimpled foil of sufficient size to overlap area of damage by $\frac{1}{2}$ in. (13 mm).

NOTE: Patches should not overlap.

SUBTASK 54-54-01-110-001

- (5) Clean area of damage using general solvent, B50118 on a clean lint-free cloth, G00834 ensuring no solvents enter the insulant.

SUBTASK 54-54-01-940-001

- (6) Set welding machine using scrap foil, sandwich two foils between the electrode and earth plate using enough force to press foils into contact.
- (7) Operate gun then check weld by pulling the two foils apart. A good weld should pull a hole in either of the two foils.
 - (a) If this does not occur, or the electrode sticks to the foils, the set should be adjusted in accordance with the manufacturers instructions.

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SUBTASK 54-54-01-940-002

- (8) Place patch in position. Temporarily hold using adhesive tape if required.

SUBTASK 54-54-01-310-001

- (9) Tack patch to skin by holding earth on skin adjacent to patch and welding on patch approximately 1mm in from edge (using same technique as used when setting machine) repeat at approximately 1 in. (25 mm) pitch around edge of patch.

SUBTASK 54-54-01-310-002

- (10) Fully weld patch to skin by welding at approximately 1mm pitch around the edge of the patch.

SUBTASK 54-54-01-350-003

- (11) Using a blunt tool, smooth down any protruding edges.

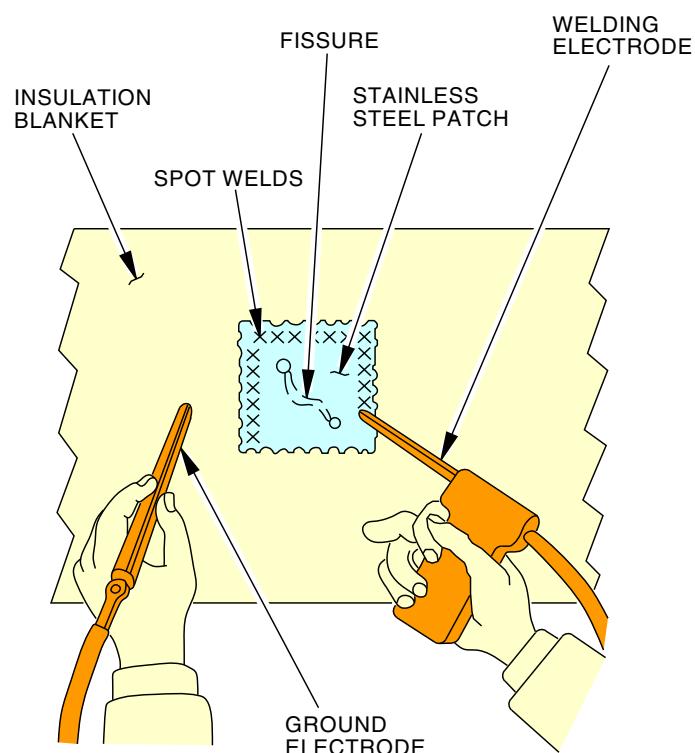
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EFFECTIVITY
LOM ALL

54-54-01



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AIRCRAFT MAINTENANCE MANUAL



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Insulation Blanket Repair Welding Method
Figure 802/54-54-01-990-802

EFFECTIVITY
LOM ALL

54-54-01

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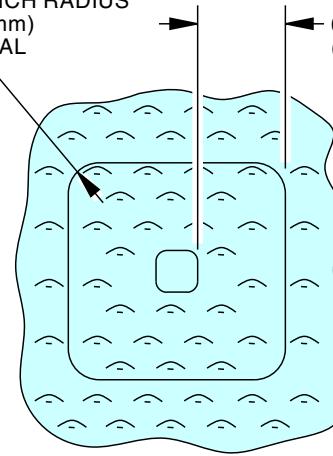
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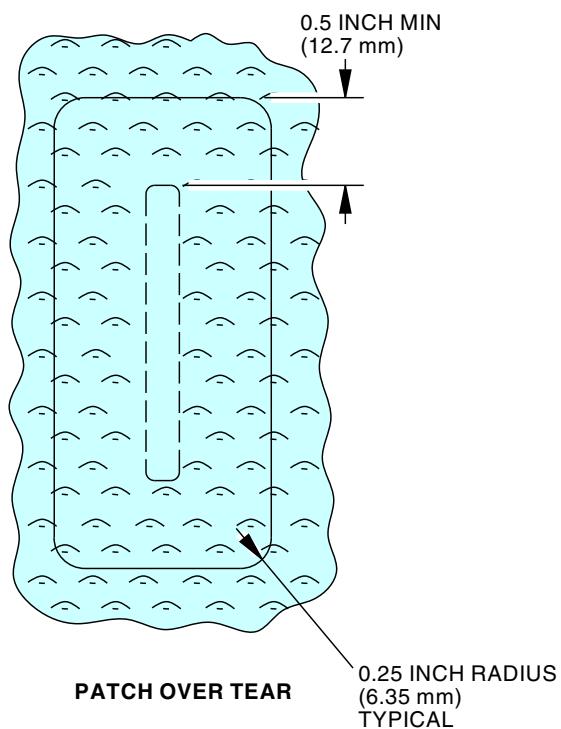
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0.25 INCH RADIUS
(6.35 mm)
TYPICAL



PATCH OVER HOLE

0.5 INCH MIN
(12.7 mm)



PATCH OVER TEAR

1374846 S0000244831_V2

Insulation Blanket Repair Patch
Figure 803/54-54-01-990-803

EFFECTIVITY
LOM ALL

54-54-01

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ECCN 9E991 BOEING PROPRIETARY - See title page for details

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AFT FAIRING INSULATION BLANKETS - INSPECTION/CHECK

1. General

- A. This procedure has this task:
- (1) An examination of the aft fairing insulation blankets.

TASK 54-54-02-200-801

2. Aft Fairing Insulation Blankets Inspection

A. General

- (1) This task examines the aft fairing insulation blankets.
- (2) This task has these steps:
 - (a) Get access to the aft fairing insulation blankets.
 - (b) Examine the aft fairing insulation blankets for damage.
 - (c) Close access to the aft fairing insulation blankets.

B. References

Reference	Title
54-51-01-040-801	Prepare the Strut for Maintenance Operations (P/B 201)
54-51-01-440-801	Put the Strut Back to its Usual Condition (P/B 201)
54-52-08-010-801	Aft Fairing Heatshield Removal (P/B 401)
54-52-08-010-802	Aft Fairing Heatshield Installation (P/B 401)

C. Location Zones

Zone	Area
434	Engine 1 - Aft Strut Fairing
444	Engine 2 - Aft Strut Fairing

D. Prepare for the Examination

SUBTASK 54-54-02-040-001

- (1) Do this task: Prepare the Strut for Maintenance Operations, TASK 54-51-01-040-801.

SUBTASK 54-54-02-010-001

- (2) Do this task: Aft Fairing Heatshield Removal, TASK 54-52-08-010-801.

E. Strut Aft Fairing Insulation Blanket Examination

SUBTASK 54-54-02-210-001

- (1) Make sure the aft fairing insulation blankets are not damaged or missing.

SUBTASK 54-54-02-960-001

- (2) Replace any insulation blankets that are damaged or missing.

F. Put the Airplane Back to Its Usual Condition

SUBTASK 54-54-02-410-001

- (1) Do this task: Aft Fairing Heatshield Installation, TASK 54-52-08-010-802.

SUBTASK 54-54-02-440-001

- (2) If you will do no more maintenance operations, do this task: Put the Strut Back to its Usual Condition, TASK 54-51-01-440-801.

———— END OF TASK ————

EFFECTIVITY
LOM ALL

54-54-02



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STRUT DRAINS - MAINTENANCE PRACTICES

1. General

- A. This procedure has these tasks:
- (1) A task to clean the condensate drain.
 - (2) An operational test of the strut fan cowl support beam drain.
 - (3) A functional test of the strut drain.
 - (4) A functional test of the strut seal plane.

TASK 54-55-01-100-801

2. Condensate Drain Clean

(Figure 201)

A. General

- (1) This task is exclusively for the condensate drain within the torque box.
 - (a) Drain tubes found to be coked or blocked can be cleaned following this procedure.
 - (b) If the drain tubes are damaged, replace the drain tube assembly.
- (2) Do this task to:
 - (a) Make sure that there is no blockage in the condensate drains.
 - (b) Remove any blockage in the drains.
- (3) Each strut has two condensate drain outlets. A single drain outlet is located below each thrust reverser access panel (also called, strut access panel).

B. References

Reference	Title
05-41-04-210-813	INTERNAL - ZONAL (GV): Strut Torque Box - Engine No. 1 (P/B 201)
05-41-04-210-817	INTERNAL - ZONAL (GV): Strut Torque Box - Engine No. 2 (P/B 201)
54-51-01-040-801	Prepare the Strut for Maintenance Operations (P/B 201)
54-51-01-440-801	Put the Strut Back to its Usual Condition (P/B 201)
54-53-01-000-801	Strut Access Panel Removal (P/B 401)
54-53-01-400-801	Strut Access Panel Installation (P/B 401)

C. Tools/Equipment

Reference	Description
STD-1059	Platform - Engine and Strut Access
STD-1174	Drain Snake

D. Location Zones

Zone	Area
410	Subzone - Engine 1
420	Subzone - Engine 2
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut





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E. Access Panels

<u>Number</u>	<u>Name/Location</u>
433AL	Strut, Left Aft Dry Bay, Strut 1
433AR	Strut, Right Aft Dry Bay, Strut 1
443AL	Strut, Left Aft Dry Bay, Strut 2
443AR	Strut, Right Aft Dry Bay, Strut 2

F. Prepare to Clean the Drains

SUBTASK 54-55-01-040-001

- (1) Do this task: Prepare the Strut for Maintenance Operations, TASK 54-51-01-040-801.

SUBTASK 54-55-01-480-001

- (2) Put the platform, STD-1059 in position.

SUBTASK 54-55-01-010-005

- (3) Open these access panels:

<u>Number</u>	<u>Name/Location</u>
433AL	Strut, Left Aft Dry Bay, Strut 1
433AR	Strut, Right Aft Dry Bay, Strut 1
443AL	Strut, Left Aft Dry Bay, Strut 2
443AR	Strut, Right Aft Dry Bay, Strut 2

(Strut Access Panel Removal, TASK 54-53-01-000-801)

G. Condensate Drain Clean

SUBTASK 54-55-01-210-001

- (1) Use (Figure 201) to find the drain tube(s) that you will check.

SUBTASK 54-55-01-160-001

- (2) To make sure that no blockages exist, do the following steps:

- Insert a pipe cleaning brush or a drain snake, STD-1174 into the outlet to remove any possible or known blockages.
- Insert a pipe cleaning brush or drain snake, STD-1174 into the inlet of the drain to remove any possible or known blockages.

SUBTASK 54-55-01-211-001

- (3) If hydraulic fluid, fuel, or anything other than water are found exiting the condensate drain, for the applicable engine do either of the following:

- INTERNAL - ZONAL (GV): Strut Torque Box - Engine No. 1, TASK 05-41-04-210-813
- INTERNAL - ZONAL (GV): Strut Torque Box - Engine No. 2, TASK 05-41-04-210-817

H. Put the Airplane Back to Its Usual Condition

SUBTASK 54-55-01-410-005

- (1) Close these access panels:

<u>Number</u>	<u>Name/Location</u>
433AL	Strut, Left Aft Dry Bay, Strut 1
433AR	Strut, Right Aft Dry Bay, Strut 1
443AL	Strut, Left Aft Dry Bay, Strut 2
443AR	Strut, Right Aft Dry Bay, Strut 2

(Strut Access Panel Installation, TASK 54-53-01-400-801)



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SUBTASK 54-55-01-160-002

- (2) Make sure that the work area is clean, and remove all tools and other items.

SUBTASK 54-55-01-080-001

- (3) Remove the platform, STD-1059.

SUBTASK 54-55-01-440-001

- (4) Do this task: Put the Strut Back to its Usual Condition, TASK 54-51-01-440-801.

———— END OF TASK ————

EFFECTIVITY
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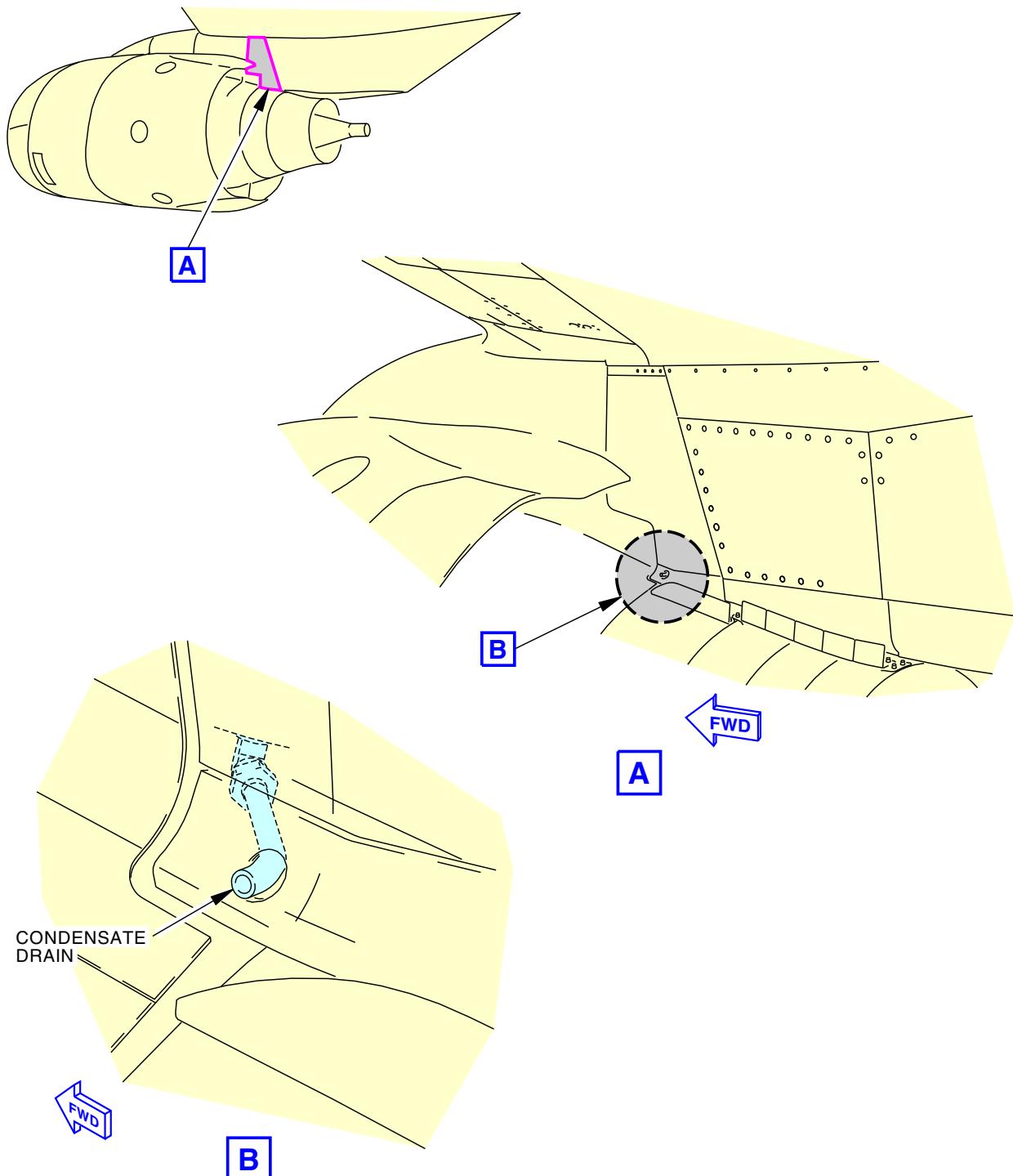
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Condensate Drain Maintenance
Figure 201/54-55-01-990-801 (Sheet 1 of 2)

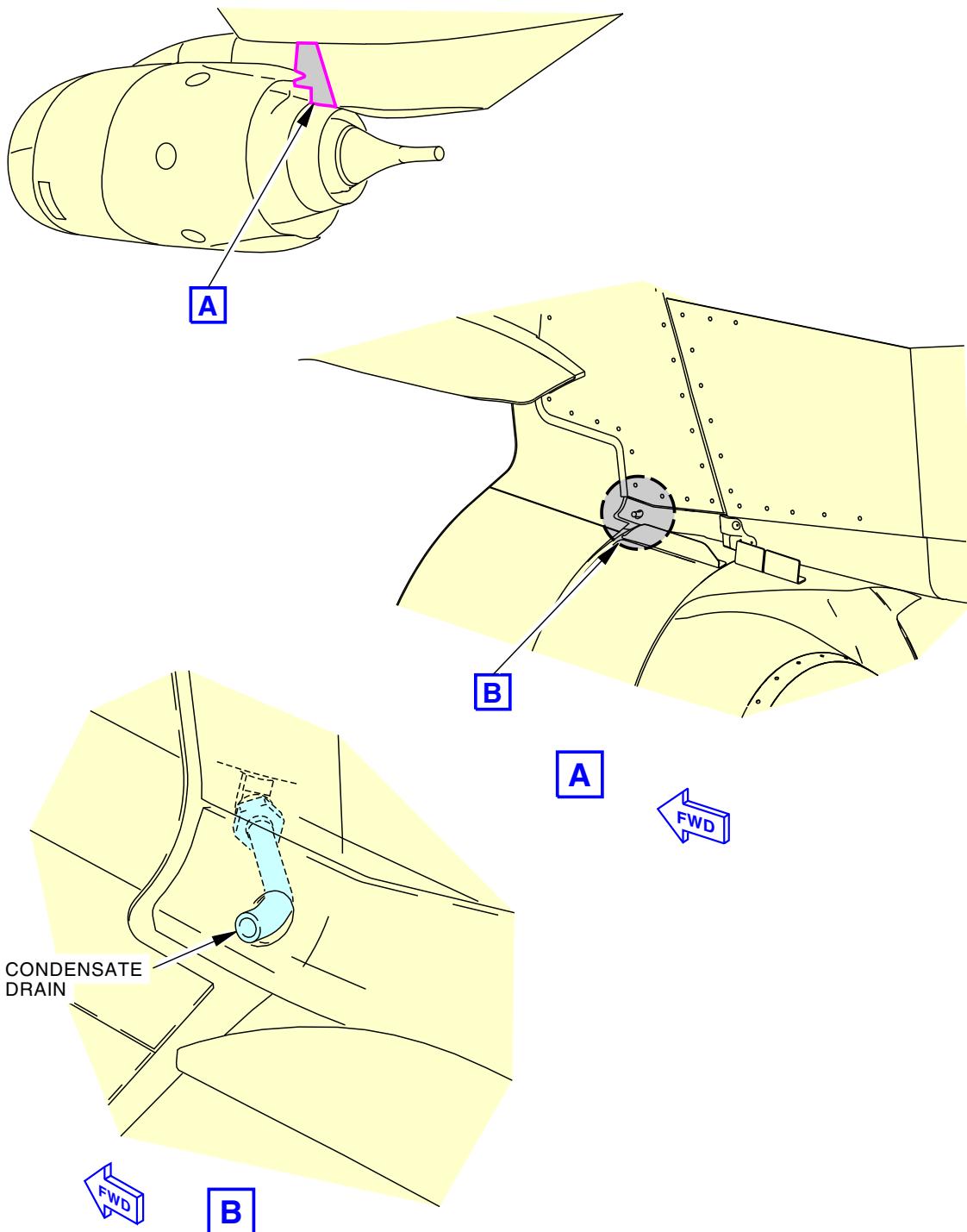
EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-78-1089

54-55-01

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Condensate Drain Maintenance
Figure 201/54-55-01-990-801 (Sheet 2 of 2)

EFFECTIVITY
LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
407, 411, 412, 415, 416, 420, 422-426 POST SB
737-78-1089

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TASK 54-55-01-200-801

3. Strut Fan Cowl Support Beam Drain - Operational Test

Figure 202

NOTE: This procedure is a scheduled maintenance task.

A. General

- (1) This task gives steps to do an operational test of the Fan Cowl Support Beam Drain.

B. Tools/Equipment

Reference	Description
STD-1280	Source - Air, Regulated, Dry Filtered, 0-30 PSIG
STD-5497	Plug/Cap - To block each port

C. Location Zones

Zone	Area
400	Powerplant and Nacelle Struts

D. Access Panels

Number	Name/Location
431AT	Forward Strut Fairing, Thumbnail Fairing, Strut 1
441AT	Forward Strut Fairing, Thumbnail Fairing, Strut 2

E. Prepare for the Operational Test

SUBTASK 54-55-01-010-001

- (1) Open these access panels:

Number	Name/Location
431AT	Forward Strut Fairing, Thumbnail Fairing, Strut 1
441AT	Forward Strut Fairing, Thumbnail Fairing, Strut 2

F. Strut Fan Cowl Support Beam Drain - Operational Test

SUBTASK 54-55-01-210-002

- (1) Make sure that the Fan Cowl Support Beam and drain inlets are free of unwanted material.

SUBTASK 54-55-01-710-003

- (2) Use a Plug/Cap, STD-5497 to plug one drain inlet.

SUBTASK 54-55-01-710-001



BEFORE YOU USE COMPRESSED AIR, PUT ON GOGGLES FOR EYE PROTECTION. DO NOT POINT THE NOZZLE AT OTHER PERSONNEL. IF YOU DO NOT OBEY THESE PRECAUTIONS, INJURIES TO PERSONNEL CAN OCCUR.

- (3) Use a 0-30 psig dry filtered regulated air source, STD-1280 to blow into the top of the applicable drain inlet.

SUBTASK 54-55-01-710-002

- (4) Make sure that the air flows freely through the drain line.

SUBTASK 54-55-01-710-004

- (5) Remove the Plug/Cap, STD-5497.

SUBTASK 54-55-01-710-005

- (6) Use a Plug/Cap, STD-5497 to plug the other drain inlet.

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SUBTASK 54-55-01-710-006



WARNING

BEFORE YOU USE COMPRESSED AIR, PUT ON GOGGLES FOR EYE PROTECTION. DO NOT POINT THE NOZZLE AT OTHER PERSONNEL. IF YOU DO NOT OBEY THESE PRECAUTIONS, INJURIES TO PERSONNEL CAN OCCUR.

- (7) Use a 0-30 psig dry filtered regulated air source, STD-1280 to blow into the top of the applicable drain inlet.

SUBTASK 54-55-01-710-007

- (8) Make sure that the air flows freely through the drain line.

SUBTASK 54-55-01-710-008

- (9) Remove the Plug/Cap, STD-5497.

G. Put the Airplane Back to Its Usual Condition

SUBTASK 54-55-01-410-001

- (1) Close the panels removed for access.

- (a) Close these access panels:

Number

Name/Location

431AT

Forward Strut Fairing, Thumbnail Fairing, Strut 1

441AT

Forward Strut Fairing, Thumbnail Fairing, Strut 2

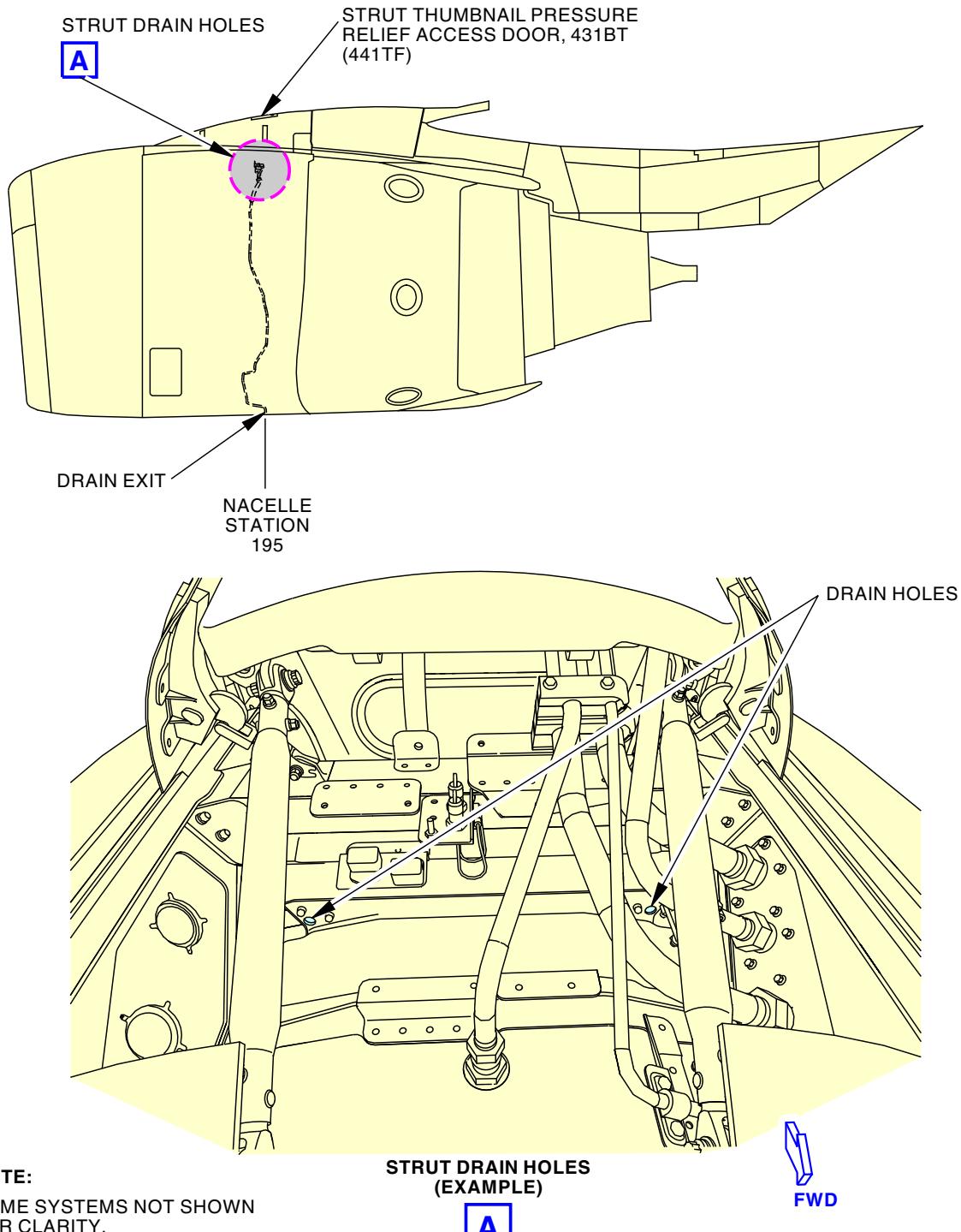
———— END OF TASK ————

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Fan Cowl Support Beam - Drain
Figure 202/54-55-01-990-802

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TASK 54-55-01-720-801

4. Strut Drain - Functional Test

Figure 203

NOTE: This procedure is a scheduled maintenance task.

A. General

- (1) This task gives steps to do a functional test of the strut drain.

B. References

Reference	Title
05-51-22-210-801	Inspection of Titanium Parts When Contaminated With Fire-Resistant Hydraulic Fluid (P/B 201)
10-11-01-580-801	Airplane Parking (P/B 201)
20-10-51-000-802	Flareless Fittings in Pressurized, Strut, Fuel Tank, and Cargo Areas Installation (P/B 401)
24-22-00-860-812	Remove Electrical Power (P/B 201)
54-51-01-040-801	Prepare the Strut for Maintenance Operations (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)
SOPM 20-30-03	General Cleaning Procedures

C. Tools/Equipment

Reference	Description
STD-77	Air Source, Regulated - Dry Filtered, 0-50 psig
STD-1155	Funnel - Long Neck
STD-1280	Source - Air, Regulated, Dry Filtered, 0-30 PSIG
STD-13465	Bucket - 2.5 Gallon Capacity
STD-13870	.75 inch O.D., clear vinyl hose

D. Consumable Materials

Reference	Description	Specification
A00209	Compound - Silicone Rubber - Dow Corning RTV3110	
C50241	Primer - Dow Corning PR-1200 Prime Coat Clear	
G50316	Cloth - Clean, Dry, Lint-free, White, Cotton	
G50381	Abrasive - Aluminum Oxide Paper, 180 Grit	
G50912	Catalyst - Dow Corning RTV-3010-S (Formerly S Tin NW)	
G50913	Catalyst - Dow Corning RTV-3000 F (Formerly Dow Corning F) Catalyst	
G50914	Catalyst - Dow Corning 4 Catalyst	

E. Location Zones

Zone	Area
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut



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F. Access Panels

Number	Name/Location
431BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 1
431BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 1
431CL	Forward Strut Fairing, Left Overwing Fairing, Strut 1
431CR	Forward Strut Fairing, Right Overwing Fairing, Strut 1
434AR	Aft Strut Fairing, Right Forward Panel, Strut 1
434BL	Aft Strut Fairing, Left Aft Panel, Strut 1
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
444AL	Aft Strut Fairing, Left Forward Panel, Strut 2
444BR	Aft Strut Fairing, Right Aft Panel, Strut 2

G. Prepare for the Functional Test

SUBTASK 54-55-01-010-002

- (1) Do this task: Prepare the Strut for Maintenance Operations, TASK 54-51-01-040-801.

SUBTASK 54-55-01-040-002

- (2) Do this task to remove electrical power: Remove Electrical Power, TASK 24-22-00-860-812.

SUBTASK 54-55-01-010-003

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

- (a) Remove these access panels:

Number	Name/Location
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
444BR	Aft Strut Fairing, Right Aft Panel, Strut 2

SUBTASK 54-55-01-010-006

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

- (a) Remove these access panels:

Number	Name/Location
431BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 1
431BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 1
431CL	Forward Strut Fairing, Left Overwing Fairing, Strut 1
431CR	Forward Strut Fairing, Right Overwing Fairing, Strut 1
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 54-55-01-210-007

- (5) Make sure that the internal surface of the strut and drain inlet is free of material that can cause a blockage in the drain.

- (a) Examine the strut upper spar web for hydraulic fluid or remaining hydraulic fluid.



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- 1) If there is hydraulic fluid leakage from the line fittings or connections, do this task:
TASK 20-10-51-000-802.
- 2) If there is hydraulic fluid found on the upper spar it is recommended to visually examine the torque box through side access panels 433AL/433AR or 443AL/443AR.
NOTE: Visual examine can be done with the operation of a borescope.
- 3) Hydraulic fluid found in the torque box should be cleaned/assessed, do this task:
TASK 05-51-22-210-801.

SUBTASK 54-55-01-200-006

- (6) Examine the aft end of strut upper spar for leveling compound near vapor barrier and strut drain inlet hole.
 - (a) Make sure level compound is bonded to strut upper spar.
 - (b) If no level compound is found or if level compound is disbonded, then replace the level compound.
 - (c) If necessary, do these steps to repair or replace the leveling compound:
 - 1) Make sure the airplane is parked in the most level position available, do this task:
Airplane Parking, TASK 10-11-01-580-801.
 - 2) Remove any disbonded leveling compound.
 - 3) Solvent clean the area where leveling compound will be applied (General Cleaning Procedures, SOPM 20-30-03).
 - 4) Lightly abrade primer in area where leveling compound will be applied with 180 grit abrasive paper, G50381.
 - a) Clean the area (General Cleaning Procedures, SOPM 20-30-03).
 - 5) Apply Dow Corning PR-1200 prime coat clear, C50241 and allow to dry.
 - a) Sealant which shall be contacted must be tack free before applying leveling compound.
 - 6) Apply Dow Corning 3110 RTV silicone rubber compound, A00209 with Dow Corning RTV-3010-S Catalyst, G50912, Dow Corning RTV-3000 F Catalyst, G50913, or Dow Corning 4 Catalyst, G50914.
 - a) Make sure Dow Corning 3110 RTV silicone rubber compound, A00209 is level with the bottom of drain hole.
 - b) The leveling compound must be put into the lowest pocket formed by structure.
NOTE: Strut/airplane must not be moved during the work life of leveling compound.
 - 7) Create a drainage channel in the Dow Corning 3110 RTV silicone rubber compound, A00209 at the drain hole as necessary.
NOTE: Do not use thinners with the solvent because it can cause the drain hole to block.

SUBTASK 54-55-01-840-001

- (7) Put a bucket, STD-13465 or equivalent container below the aft drain.

SUBTASK 54-55-01-480-004

- (8) Put a .75 inch O.D. hose, STD-13870 on the drain tube to point the water into the bucket, STD-13465.

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H. Functional Test

SUBTASK 54-55-01-200-001

- (1) Use a long neck funnel, STD-1155, to pour 1 gallon, 128 fl-oz (3.8 l) of clean water along the aft end of the internal floor of the strut spar.

NOTE: Pour water as close to the drain as possible.

- (a) Make sure that the water flows freely from the aft drain.

SUBTASK 54-55-01-200-002

- (2) After 3 minutes, make sure that you collect no less than 122 fl-oz (3.6 l) of water from the drain.

SUBTASK 54-55-01-720-001

- (3) Use a 0-30 psig dry filtered regulated air source, STD-1280 at the strut drain inlet to blow all remaining water out of the strut drain, into the bucket, STD-13465.

SUBTASK 54-55-01-210-009

- (4) Make sure that there are no leaks at the strut drain hose to strut drain line fitting.

SUBTASK 54-55-01-910-001

- (5) Remove remaining water from the strut with a cotton cloth, G50316.

SUBTASK 54-55-01-910-002



WARNING

USE EYE PROTECTION WHEN YOU USE COMPRESSED AIR TO CLEAN, COOL, OR DRY PARTS OR TOOLS. PARTICLES CAN CAUSE AN INJURY TO YOUR EYES. DO NOT USE MORE THAN 30 PSIG (200 KPA). DO NOT POINT COMPRESSED AIR AT YOURSELF OR OTHER PERSONS.

- (6) Use a regulated air source, STD-77 or (0-345 kPa), to dry the internal surfaces of the strut.

I. Put the Airplane Back to Its Usual Condition

SUBTASK 54-55-01-410-004

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

- (a) Install these access panels:

<u>Number</u>	<u>Name/Location</u>
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
444BR	Aft Strut Fairing, Right Aft Panel, Strut 2

SUBTASK 54-55-01-410-006

- (2) Install these FWD fairing access panels:

- (a) Install these access panels:

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



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(Continued)

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

— END OF TASK —

TASK 54-55-01-720-802

5. Strut Seal Plane Access Panels- Functional Test

(Figure 201, Figure 203)

A. General

- (1) This task gives steps to do a functional test of the strut seal plane access panels.

B. References

<u>Reference</u>	<u>Title</u>
05-51-22-210-801	Inspection of Titanium Parts When Contaminated With Fire-Resistant Hydraulic Fluid (P/B 201)
08-21-02-580-801	Level the Airplane With a Plumb Bob and Inclinometers (P/B 201)
08-21-03-580-801	Make the Airplane Level (P/B 201)
10-11-01-580-801	Airplane Parking (P/B 201)
20-10-51-000-802	Flareless Fittings in Pressurized, Strut, Fuel Tank, and Cargo Areas Installation (P/B 401)
24-22-00-860-812	Remove Electrical Power (P/B 201)
54-51-01-040-801	Prepare the Strut for Maintenance Operations (P/B 201)
SOPM 20-30-03	General Cleaning Procedures

C. Tools/Equipment

<u>Reference</u>	<u>Description</u>
STD-77	Air Source, Regulated - Dry Filtered, 0-50 psig
STD-1154	Container - 5 Gallon (19 Liter)
STD-3926	Water Source - Cold, Regulated, 0 to 60 PSIG
STD-13870	.75 inch O.D., clear vinyl hose

D. Consumable Materials

<u>Reference</u>	<u>Description</u>	<u>Specification</u>
A00209	Compound - Silicone Rubber - Dow Corning RTV3110	
C50241	Primer - Dow Corning PR-1200 Prime Coat Clear	
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	AMS3819 Class 1 Grade A or B Form 1 (Supersede BMS15-5 CL A)
G50151	Tissue - Lens (or equivalent), Dry Towelette	
G50381	Abrasive - Aluminum Oxide Paper, 180 Grit	
G50912	Catalyst - Dow Corning RTV-3010-S (Formerly S Tin NW)	
G50913	Catalyst - Dow Corning RTV-3000 F (Formerly Dow Corning F) Catalyst	

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(Continued)

Reference	Description	Specification
G50914	Catalyst - Dow Corning 4 Catalyst	

E. Location Zones

Zone	Area
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

F. Access Panels

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

G. Prepare for the Functional Test

SUBTASK 54-55-01-840-002

- (1) Do this task: Prepare the Strut for Maintenance Operations, TASK 54-51-01-040-801.

SUBTASK 54-55-01-860-002

- (2) Do this task to remove electrical power: Remove Electrical Power, TASK 24-22-00-860-812.

SUBTASK 54-55-01-860-003

- (3) Do one of these tasks to level the airplane, plus or minus 0.5 degrees:

- (a) Level the Airplane With a Plumb Bob and Inclinometers, TASK 08-21-02-580-801, or
(b) Make the Airplane Level, TASK 08-21-03-580-801.

SUBTASK 54-55-01-010-004

- (4) Open these access panels:

Number	Name/Location
431BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 1
431BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 1
431CL	Forward Strut Fairing, Left Overwing Fairing, Strut 1
431CR	Forward Strut Fairing, Right Overwing Fairing, Strut 1
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 54-55-01-210-008

- (5) Make sure that the internal surface of the strut and drain inlet is free of material that can cause a blockage in the drain.

- (a) Examine the strut upper spar web for hydraulic fluid or remaining hydraulic fluid.

- 1) If there is hydraulic fluid leakage from the line fittings or connections, do this task:
Flareless Fittings in Pressurized, Strut, Fuel Tank, and Cargo Areas Installation,
TASK 20-10-51-000-802.

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- 2) If there is hydraulic fluid found on the upper spar it is recommended to visually examine the torque box through side access panels 433AL/433AR or 443AL/443AR.

NOTE: Visual examine can be done with the operation of a borescope.
- 3) Hydraulic fluid found in the torque box should be cleaned/assessed, do this task: Inspection of Titanium Parts When Contaminated With Fire-Resistant Hydraulic Fluid, TASK 05-51-22-210-801.

SUBTASK 54-55-01-200-007

- (6) Examine the aft end of strut upper spar for leveling compound near vapor barrier and strut drain inlet hole.
 - (a) Make sure that the leveling compound is bonded to the strut upper spar.
 - (b) If no leveling compound is found or if level compound is disbonded, then replace the level compound.
 - (c) If necessary, do these steps to repair or replace the leveling compound:
 - 1) Make sure that the airplane is parked in the most level position available, do this task: Airplane Parking, TASK 10-11-01-580-801.
 - 2) Remove any disbonded leveling compound.
 - 3) Solvent clean the area where leveling compound will be applied (General Cleaning Procedures, SOPM 20-30-03).
 - 4) Lightly abrade primer in area where leveling compound will be applied with 180 grit abrasive paper, G50381.
 - a) Clean the area (TASK 10-11-01-580-801).
 - 5) Apply Dow Corning PR-1200 prime coat clear, C50241, and allow to dry.
 - a) Sealant which shall be contacted must be tack free before applying leveling compound.
 - 6) Apply Dow Corning 3110 RTV silicone rubber compound, A00209, with Dow Corning RTV-3010-S Catalyst, G50912, Dow Corning RTV-3000 F Catalyst, G50913, or Dow Corning 4 Catalyst, G50914.
 - a) Make sure that Dow Corning 3110 RTV silicone rubber compound, A00209, is level with the bottom of the drain hole.
 - b) The leveling compound should be put into the lowest pocket formed by the structure.

NOTE: Strut/airplane should not be moved during the work life of leveling compound.
 - 7) Create a drainage channel in Dow Corning 3110 RTV silicone rubber compound, A00209, at the drain hole as necessary.

NOTE: Do not use thinners with the solvent because it can cause the drain hole to block.

SUBTASK 54-55-01-210-010

- (7) Make sure that the condensate drains are clear (Figure 201).
 - (a) If the condensate drains are not clear, do this task: Condensate Drain Clean, TASK 54-55-01-100-801.

SUBTASK 54-55-01-480-003

- (8) Put a 5 gallon (19 liter) container, STD-1154, or equivalent container below the aft drain.

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SUBTASK 54-55-01-480-005

- (9) Put a .75 inch O.D. hose, STD-13870, or equivalent, on the drain tube to point the water into the 5 gallon (19 liter) container, STD-1154.

SUBTASK 54-55-01-800-003

- (10) Put tissue, G50151, below access panels 433AT or 443AT, 433BT or 443BT, 433CT or 443CT, 433DT or 443DT for the applicable strut, one per panel.

NOTE: Paper towel can be placed prior to panel installation, or inserted through side access panels 433AL/443AR or 443AL/443AR.

H. Functional Test

SUBTASK 54-55-01-200-003

- (1) At a rate of 0.5 gpm (1.89 l/min), spray each access panel for the applicable strut (433AT, 443AT, 433BT, 443BT, 433CT, 443CT, 433DT, 443DT) with a 0 to 60 PSIG regulated cold water source, STD-3926.

NOTE: Spray each panel for a total of 4 minutes, with one minute intervals.

- (a) Make sure that you wet all of the top surface of the strut upper-spar access-panels and their edges.
- (b) Make sure that the water flows freely from the aft drain.
- (c) Stop the procedure to drain the 5 gallon (19 liter) container, STD-1154, when necessary.

SUBTASK 54-55-01-200-004

- (2) Make sure that no water comes out of the condensate drains (Figure 201).

NOTE: If water comes out of the condensate drain, then there is a leak at one of the access panels.

SUBTASK 54-55-01-350-001

- (3) Remove tissue, G50151, from the torque box.

NOTE: Use the access holes 433AL/443AL or 433AR/443AR.

- (a) Before the access panels are closed, make sure to remove all paper towels from the strut.

NOTE: If a paper towel is wet, then there is a leak at one of the access panels.

I. Put the Airplane Back to Its Usual Condition

SUBTASK 54-55-01-910-003

- (1) Remove remaining water from the strut with cotton wiper, G00034.

SUBTASK 54-55-01-910-004



WARNING

USE EYE PROTECTION WHEN YOU USE COMPRESSED AIR TO CLEAN, COOL, OR DRY PARTS OR TOOLS. PARTICLES CAN CAUSE AN INJURY TO YOUR EYES. DO NOT USE MORE THAN 30 PSIG (200 KPA). DO NOT POINT COMPRESSED AIR AT YOURSELF OR OTHER PERSONS.

- (2) Use a regulated air source, STD-77 or (0-345 kPa), to dry the internal surfaces of the strut.

SUBTASK 54-55-01-410-003

- (3) Close these access panels:

Number Name/Location

- | | |
|-------|---|
| 431BL | Forward Strut Fairing, Left Mid Strut Fairing, Strut 1 |
| 431BR | Forward Strut Fairing, Right Mid Strut Fairing, Strut 1 |

EFFECTIVITY
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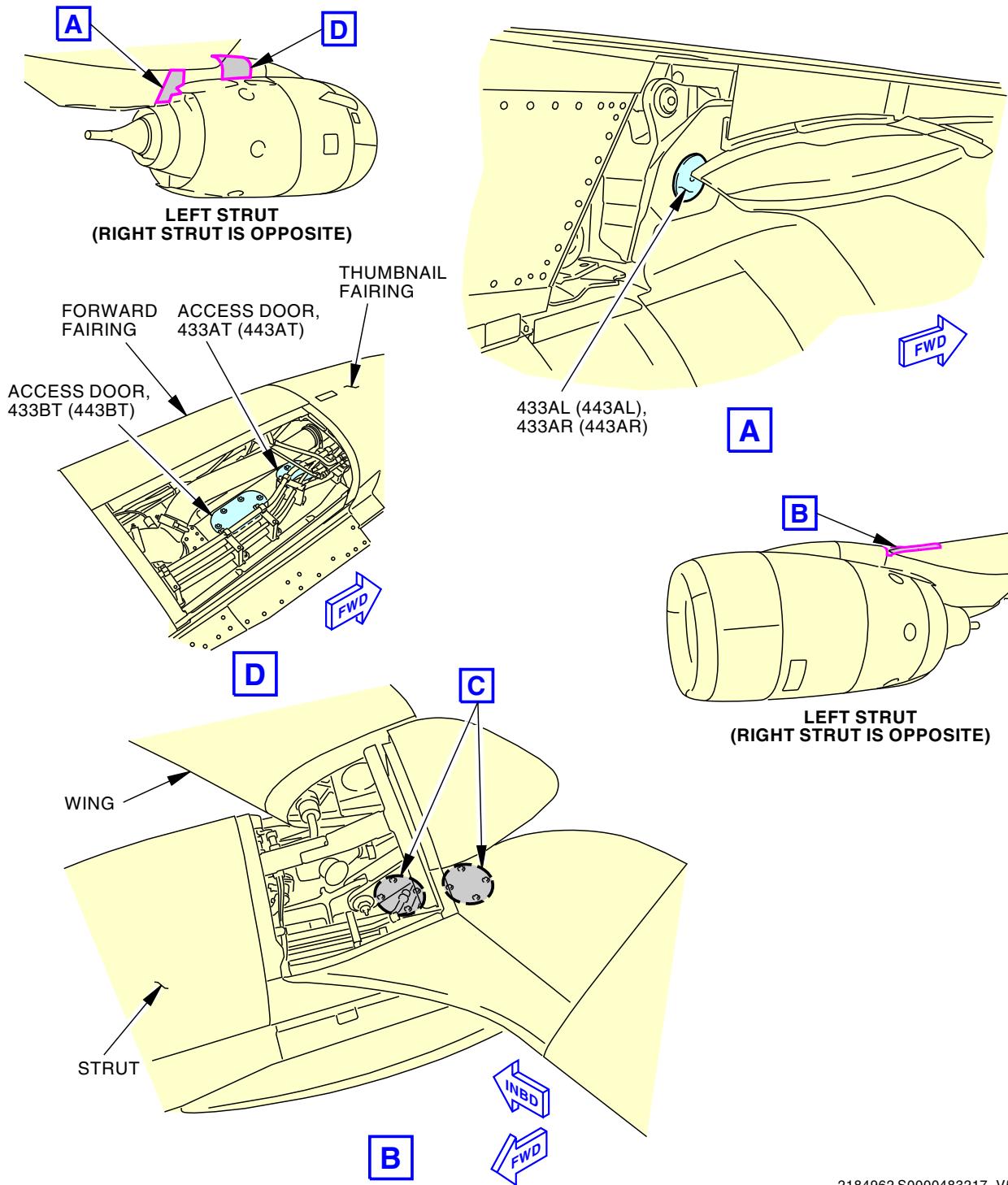
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<u>Number</u>	<u>Name/Location</u>
431CL	Forward Strut Fairing, Left Overwing Fairing, Strut 1
431CR	Forward Strut Fairing, Right Overwing Fairing, Strut 1
441BL	Forward Strut Fairing, Left Mid Strut Fairing, Strut 2
441BR	Forward Strut Fairing, Right Mid Strut Fairing, Strut 2
441CL	Forward Strut Fairing, Left Overwing Fairing, Strut 2
441CR	Forward Strut Fairing, Right Overwing Fairing, Strut 2

———— END OF TASK ————

EFFECTIVITY
LOM ALL

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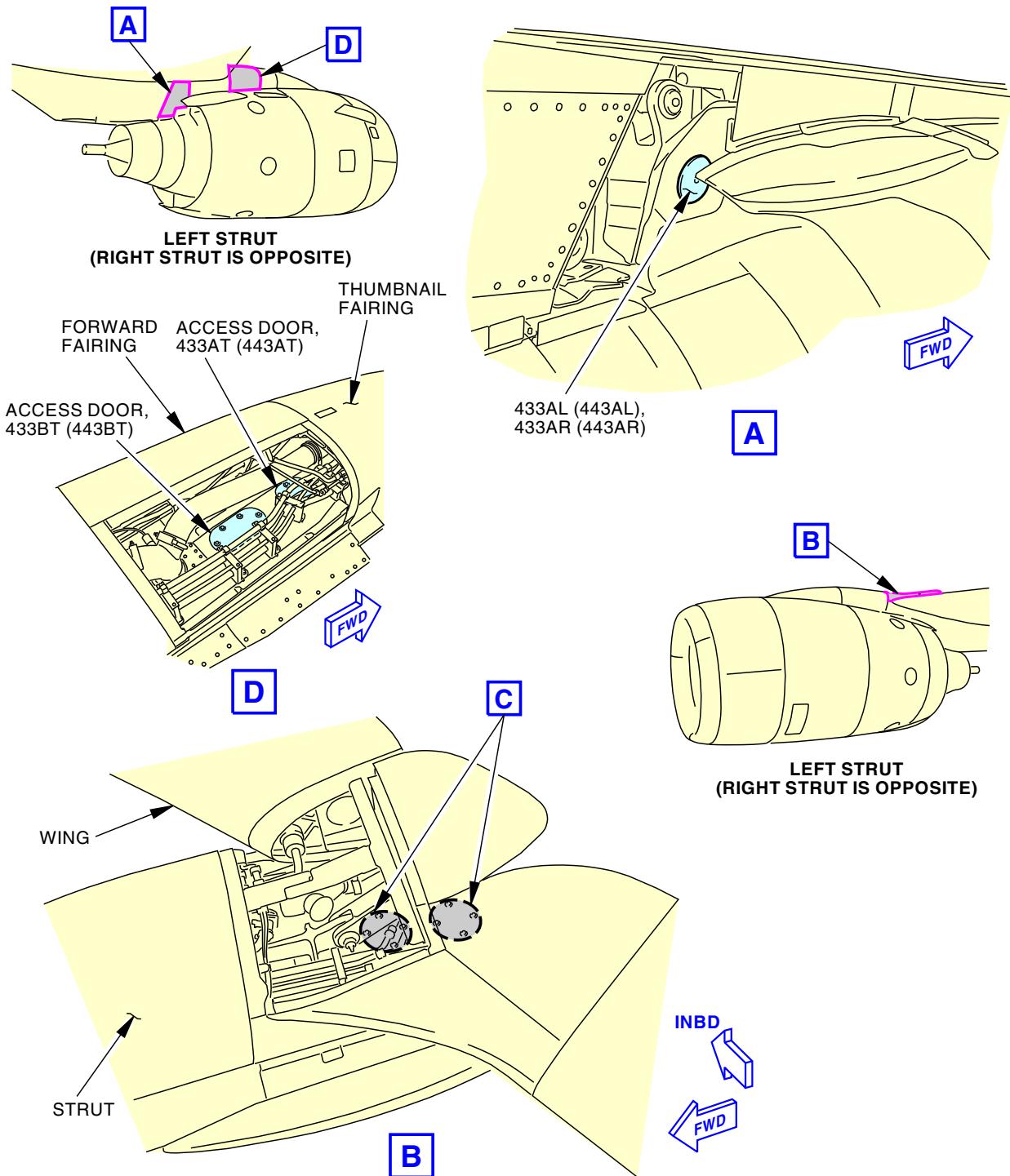
Strut Seal Plane Access Panels- Functional Test
Figure 203/54-55-01-990-803 (Sheet 1 of 3)

EFFECTIVITY
 LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
 407, 411, 412, 415, 416, 420, 422-426 POST SB
 737-78-1089

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**Strut Seal Plane Access Panels- Functional Test
Figure 203/54-55-01-990-803 (Sheet 2 of 3)**

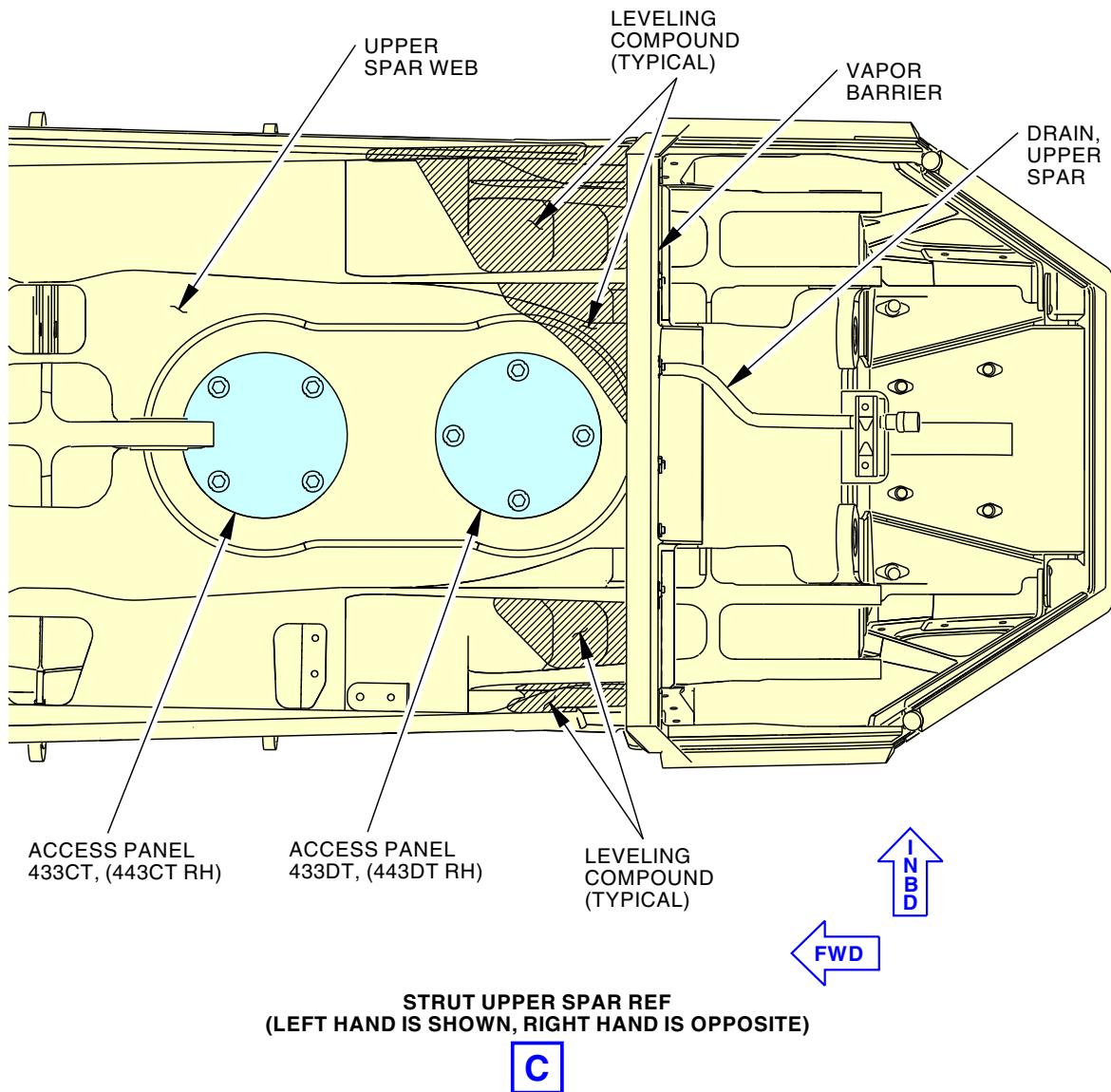
EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-78-1089

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Strut Seal Plane Access Panels- Functional Test
Figure 203/54-55-01-990-803 (Sheet 3 of 3)

EFFECTIVITY
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AIRCRAFT MAINTENANCE MANUAL

AFT FAIRING STRUT DRAINS - MAINTENANCE PRACTICES

1. General

- A. This procedure gives instructions on how to clean the strut drain tubes and aft fairing sump drains if they become clogged.
- B. This procedure has this task:
 - (1) A task to clean the strut drain tube and aft fairing sump drain.
- C. The drain tubes carry fluid leakage (fuel, oil, hydraulic fluid, or water) away from a possible leak source to remove it from the nacelle strut compartment.

TASK 54-55-02-100-801

2. Strut Drain and Aft Fairing Sump Drain Clean

(Figure 201)

A. General

- (1) This procedure is for rigid drain tubes only. If soft rubber drain tubes are coked, damaged or blocked, replace the drain tube assembly.
- (2) Do this task for the strut drain tube when there is a possible blockage.
- (3) The strut drain tube has one inlet, and one outlet.

B. References

Reference	Title
54-51-01-040-801	Prepare the Strut for Maintenance Operations (P/B 201)
54-51-01-440-801	Put the Strut Back to its Usual Condition (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)

C. Tools/Equipment

Reference	Description
STD-77	Air Source, Regulated - Dry Filtered, 0-50 psig
STD-1059	Platform - Engine and Strut Access
STD-1174	Drain Snake

D. Location Zones

Zone	Area
410	Subzone - Engine 1
420	Subzone - Engine 2
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

E. Access Panels

Number	Name/Location
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
444BR	Aft Strut Fairing, Right Aft Panel, Strut 2

F. Prepare to Clean the Strut Drain Tube and Sump Drain

SUBTASK 54-55-02-040-001

- (1) Do this task: Prepare the Strut for Maintenance Operations, TASK 54-51-01-040-801.

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SUBTASK 54-55-02-480-001

- (2) Put the platform, STD-1059 in its position.

SUBTASK 54-55-02-010-001

- (3) Open the applicable aft fairing access panels, do this task: Aft Fairing Access Panel Removal, TASK 54-52-06-010-801

Open the applicable access panels:

Number Name/Location

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
444BR	Aft Strut Fairing, Right Aft Panel, Strut 2

G. Strut Drain Tube Clean

SUBTASK 54-55-02-160-001

- (1) Do these steps to make sure that there is no blockage in the strut drain:

- Disconnect the strut drain hose from the forward end of the strut drain tube, (Figure 201).
- Use an regulated air source, STD-77 to supply 30-40 psig (207-276 kPa) air pressure to the strut drain tube inlet.
- Make sure that there is airflow through the strut drain tube from the inlet to the outlet.
- Remove the air pressure.

SUBTASK 54-55-02-160-002

- (2) If there is decreased airflow, do these steps to remove the blockage:

- Remove the blockage as much as possible with a drain snake, STD-1174.
- Use an regulated air source, STD-77 to supply 30-40 psig (207-276 kPa) air pressure to the strut drain tube inlet.
- Make sure that there is airflow through the strut drain tube from the inlet to the outlet.
- Remove the air pressure.
- Follow the above steps again until airflow is present.
- Put a funnel into the inlet of the strut drain tube.
- Pour hot, soapy water into the funnel to remove remaining blockage.
- Pour hot, clean water into the funnel to flush out the strut drain tube.
- Remove the funnel from the inlet end of the strut drain tube.
- If the following maintenance steps will not be done on the sump drain, reconnect the strut drain hose to the inlet end of the strut drain tube.

H. Aft Fairing Sump and Drain Clean

SUBTASK 54-55-02-100-001

- (1) To remove blockage and clean the aft fairing sump drain, do the following steps, (Figure 202):

- Install plug into forward end of the strut drain tube.
- Remove blockage in the sump drain inlet with a pipe cleaning brush.

NOTE: Blockage will usually occur near the inlet end of the drain where the strut drain tube goes in. Also, make sure that the bottom-side of the drain is clean.

- Pour hot, soapy water into the sump drain inlet to remove remaining loose particles.
- Flush the sump drain with hot, clean water.

EFFECTIVITY
LOM ALL

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- (e) Remove plug from forward end of the strut drain tube.
- (f) Reconnect the hose to the forward end of the strut drain tube, (Figure 201).

I. Put the Airplane Back to Its Usual Condition

SUBTASK 54-55-02-160-003



CAUTION
MAKE SURE YOU KEEP THE STRUT AREA CLEAN. LOOSE TOOLS AND UNWANTED MATERIALS IN THE STRUT COMPARTMENTS CAN PREVENT THE REMOVAL OF FLUIDS THROUGH THE STRUT DRAINS. IF YOU DO NOT REMOVE UNWANTED MATERIALS, YOU CAN CAUSE DAMAGE TO THE STRUT.

- (1) Make sure that the work area is clean and remove all tools and other items.

SUBTASK 54-55-02-410-001

- (2) To close the aft fairing access door, do this task: Aft Fairing Access Panel Installation, TASK 54-52-06-410-801

Close these access panels:

Number Name/Location

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
444BR	Aft Strut Fairing, Right Aft Panel, Strut 2

SUBTASK 54-55-02-080-001

- (3) Remove the platform, STD-1059.

SUBTASK 54-55-02-440-001

- (4) Do this task: Put the Strut Back to its Usual Condition, TASK 54-51-01-440-801.

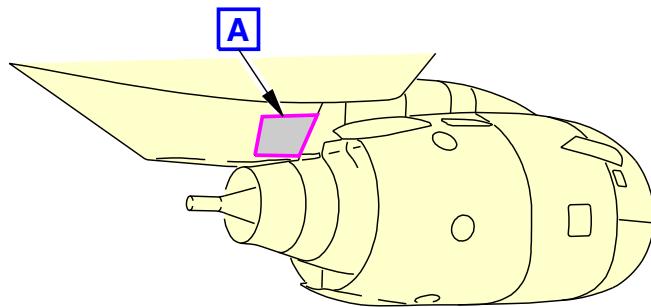
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EFFECTIVITY
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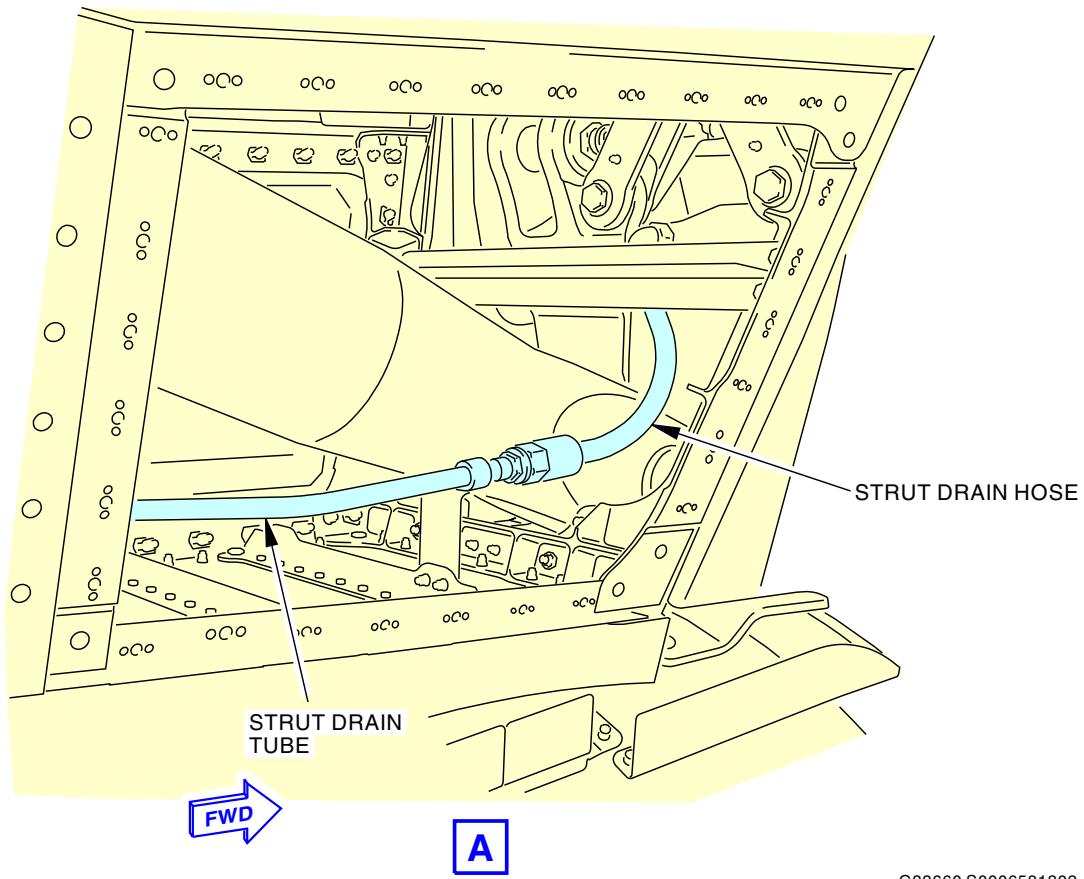
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BOEING

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**LEFT STRUT
(RIGHT STRUT IS OPPOSITE)**



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**Strut Drain - Maintenance Practices
Figure 201/54-55-02-990-801 (Sheet 1 of 2)**

EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-78-1089

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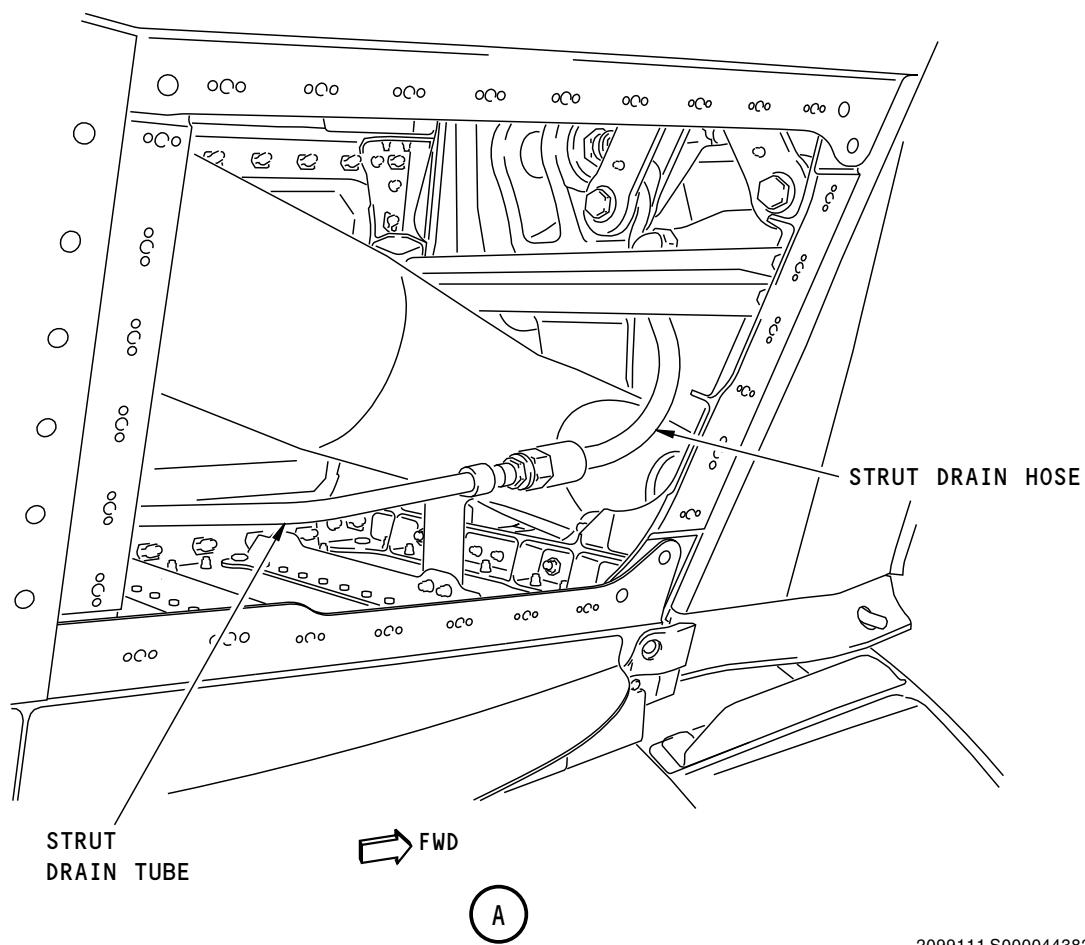
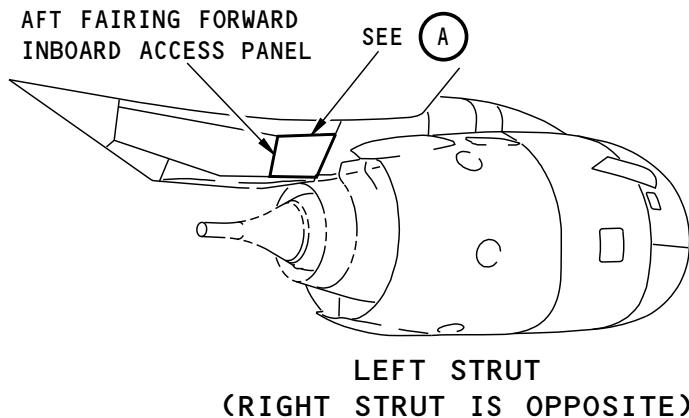
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Strut Drain - Maintenance Practices
Figure 201/54-55-02-990-801 (Sheet 2 of 2)

EFFECTIVITY
LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
407, 411, 412, 415, 416, 420, 422-426 POST SB
737-78-1089

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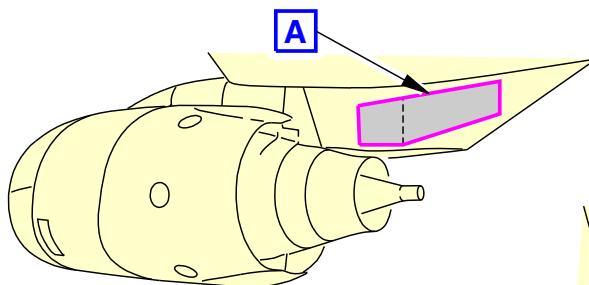
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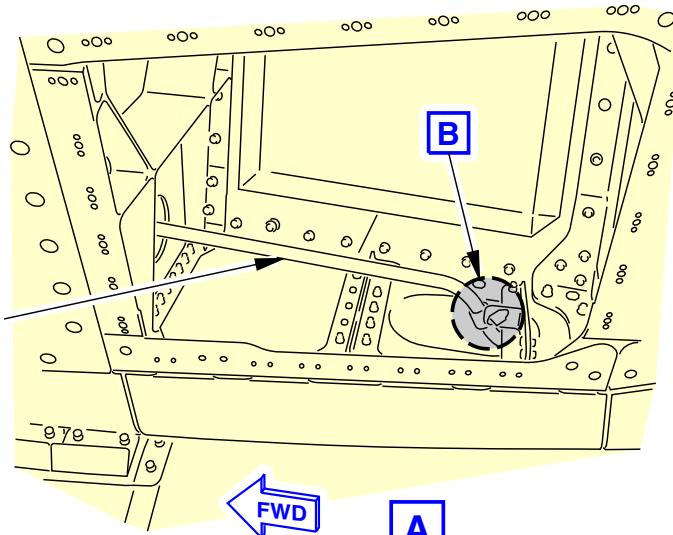
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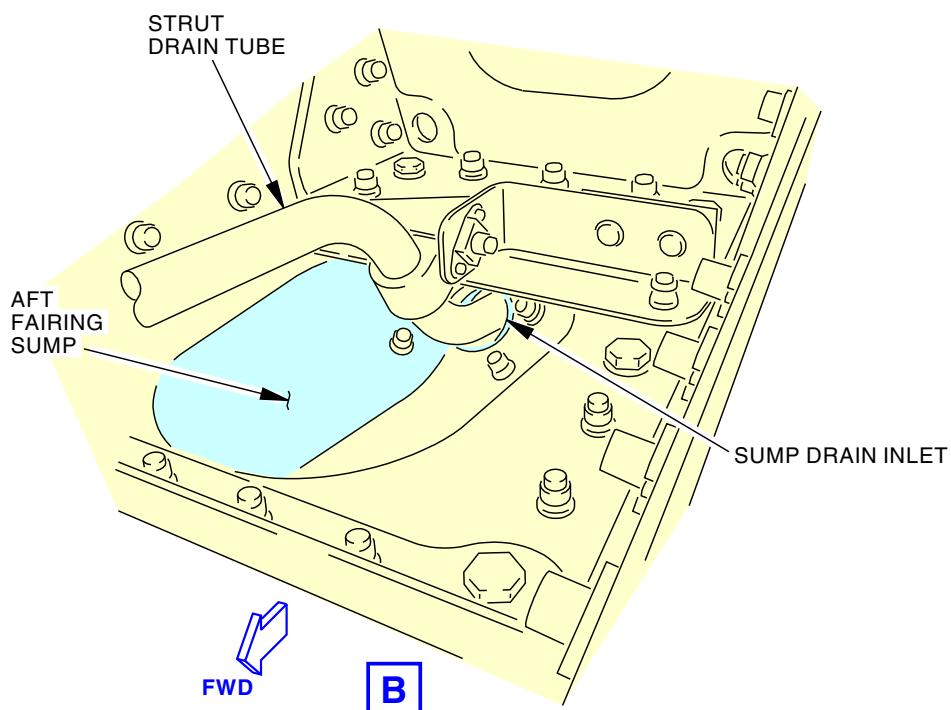
LEFT STRUT
(RIGHT STRUT IS OPPOSITE)



STRUT
DRAIN TUBE

FWD

A



G33659 S0006581303_V3

Aft Fairing Sump- Maintenance Practices
Figure 202/54-55-02-990-802 (Sheet 1 of 2)

EFFECTIVITY
LOM 402, 404, 406, 407, 411, 412, 415, 416, 420,
422-426 PRE SB 737-78-1089

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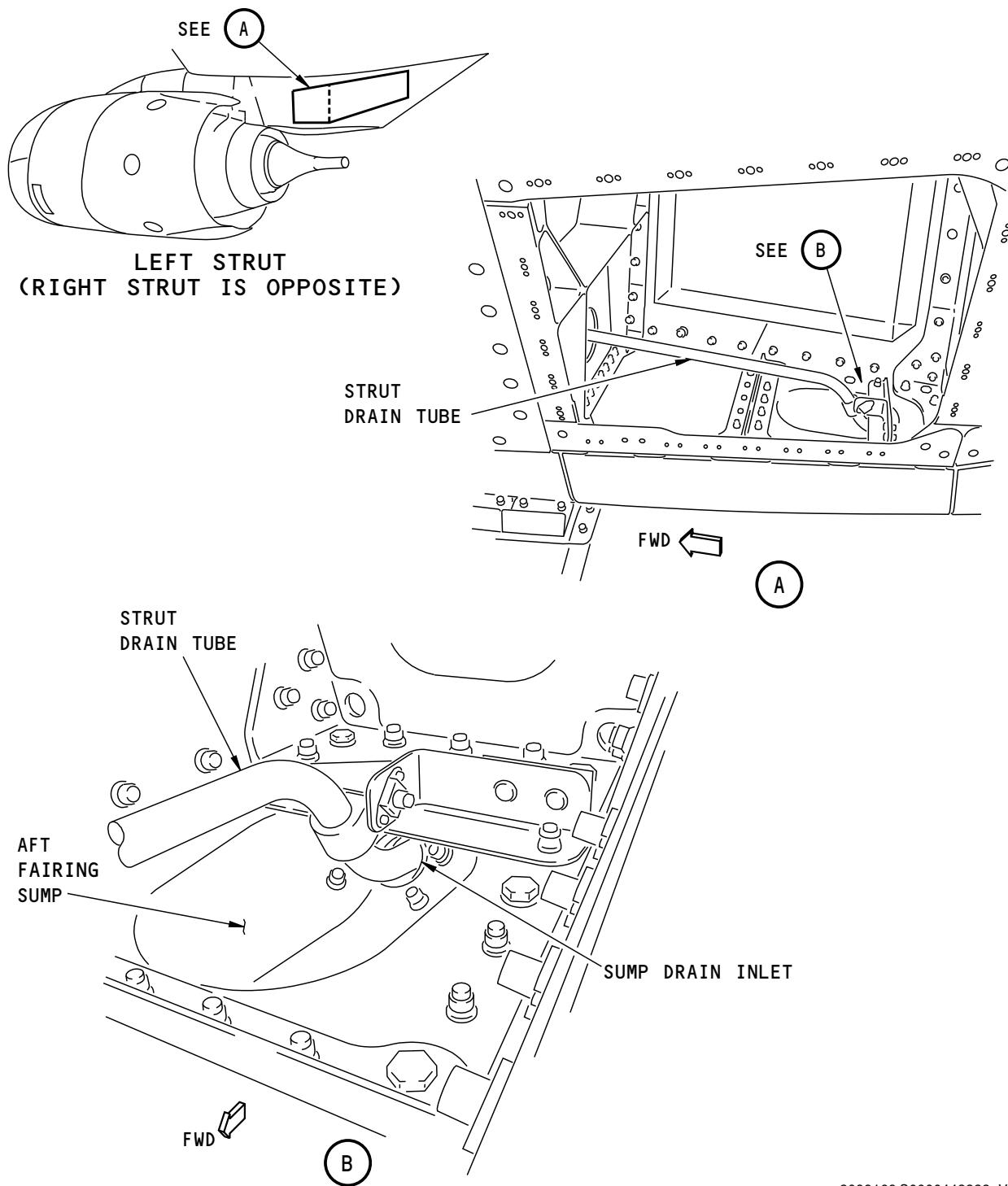
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BOEING

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**Aft Fairing Sump- Maintenance Practices
Figure 202/54-55-02-990-802 (Sheet 2 of 2)**

EFFECTIVITY
LOM 427-434, 437-447, 450-999; LOM 402, 404, 406,
407, 411, 412, 415, 416, 420, 422-426 POST SB
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AFT FAIRING STRUT DRAINS - INSPECTION/CHECK

1. General

- A. This procedure has this task:
 - (1) A task to inspect the aft fairing sump drain.
- B. The aft fairing will carry fluid leakage (fuel, oil, hydraulic fluid, or water) away from a possible leak source to remove it from the nacelle strut compartment.

TASK 54-55-02-100-802

2. Aft Fairing Sump Drain Inspection

NOTE: This procedure is a scheduled maintenance task.

A. General

- (1) Do this task for the aft fairing sump drain when there is a possible blockage.

B. References

Reference	Title
08-21-02-580-801	Level the Airplane With a Plumb Bob and Inclinometers (P/B 201)
54-51-01-040-801	Prepare the Strut for Maintenance Operations (P/B 201)
54-51-01-440-801	Put the Strut Back to its Usual Condition (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)

C. Tools/Equipment

Reference	Description
STD-77	Air Source, Regulated - Dry Filtered, 0-50 psig
STD-3910	Container - Plastic

D. Location Zones

Zone	Area
410	Subzone - Engine 1
420	Subzone - Engine 2
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

E. Access Panels

Number	Name/Location
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
444BR	Aft Strut Fairing, Right Aft Panel, Strut 2

F. Prepare to Inspect the Aft Fairing Sump Drain

SUBTASK 54-55-02-040-003

- (1) Do this task: Level the Airplane With a Plumb Bob and Inclinometers, TASK 08-21-02-580-801.

SUBTASK 54-55-02-040-002

- (2) Do this task: Prepare the Strut for Maintenance Operations, TASK 54-51-01-040-801.



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SUBTASK 54-55-02-010-002

- (3) Open the applicable aft fairing access panels:

(TASK 54-52-06-010-801)

Number Name/Location

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
444BR	Aft Strut Fairing, Right Aft Panel, Strut 2

G. Aft Fairing Drain Inspection

SUBTASK 54-55-02-200-001

- (1) Put a dry container, STD-3910 below the aft fairing drain.

NOTE: Container should hold at least 2 gallons (256 fluid ounces)(7.5 liters).

- (a) Make sure that the internal surface of the aft fairing does not have unwanted material.

SUBTASK 54-55-02-160-005

- (2) Pour 2 gallons (256 fluid ounces)(7.5 liters) +/- 1 fluid ounce (0.03 liter) of clean water along the forward end to the aft end of the internal floor of the aft fairing.

NOTE: Pour water on all internal surfaces.

- (a) After three minutes, make sure that no less than 244 fluid ounces (7.2 liters) is collected into the container below the aft fairing drain.
- (b) Visually make sure that there are no leaks through the bulb seal at the forward end of the aft fairing.
- (c) Use a syringe to make sure that no single puddle of water is larger than 1 fluid ounce (0.03 liter).

SUBTASK 54-55-02-160-006

- (3) Remove remaining water from the aft fairing.

SUBTASK 54-55-02-160-007

- (4) Use a regulated air source, STD-77 or (0-345 kPa), to dry the internal surfaces of the aft fairing.

H. Put the Airplane Back to Its Usual Condition

SUBTASK 54-55-02-160-004



CAUTION

MAKE SURE THAT YOU KEEP THE STRUT AREA CLEAN. LOOSE TOOLS AND UNWANTED MATERIALS IN THE STRUT COMPARTMENTS CAN PREVENT THE REMOVAL OF FLUIDS THROUGH THE STRUT DRAINS. IF YOU DO NOT REMOVE UNWANTED MATERIALS, YOU CAN CAUSE DAMAGE TO THE STRUT.

- (1) Make sure that the work area is clean and remove all tools and other items.

SUBTASK 54-55-02-410-002

- (2) Close the aft fairing access doors:

(TASK 54-52-06-410-801)

Number Name/Location

434AR	Aft Strut Fairing, Right Forward Panel, Strut 1
434BL	Aft Strut Fairing, Left Aft Panel, Strut 1

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AIRCRAFT MAINTENANCE MANUAL

(Continued)

Number Name/Location

444AL Aft Strut Fairing, Left Forward Panel, Strut 2
444BR Aft Strut Fairing, Right Aft Panel, Strut 2

SUBTASK 54-55-02-440-002

- (3) Do this task: Put the Strut Back to its Usual Condition, TASK 54-51-01-440-801.

———— END OF TASK ————

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AFT FAIRING STRUT DRAINS - REPAIRS

1. General

- A. Use this procedure to connect a disconnected aft fairing strut drain.
- B. Make sure that the drain tube is clean and that there is no blockage.
- C. This procedure has these tasks:
 - (1) Permanent repair of the aft fairing strut drain.
 - (2) Temporary repair of the aft fairing strut drain.
- D. Use the temporary repaired aft fairing strut drain only for 60 days. In 15 day intervals, examine the strut drain.

TASK 54-55-02-310-801

2. Aft Fairing Strut Drain - Permanent Repair

A. General

- (1) Do this task to permanently repair the disconnected Aft Fairing Strut Drain.

B. References

Reference	Title
54-51-01-040-801	Prepare the Strut for Maintenance Operations (P/B 201)
54-51-01-440-801	Put the Strut Back to its Usual Condition (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)

C. Tools/Equipment

Reference	Description
STD-77	Air Source, Regulated - Dry Filtered, 0-50 psig

D. Consumable Materials

Reference	Description	Specification
A00160	Sealant - Firewall - Hydraulic Fluid Resistant	BMS5-63
G50671	Brazing Alloy - Silver	QQ-B-654 (Supersedes QQ-S-561)

E. Location Zones

Zone	Area
410	Subzone - Engine 1
420	Subzone - Engine 2
430	Subzone - Engine 1, Nacelle Strut
440	Subzone - Engine 2, Nacelle Strut

F. Access Panels

Number	Name/Location
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
444BR	Aft Strut Fairing, Right Aft Panel, Strut 2

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G. Prepare to Repair the Aft Fairing Strut Drain

SUBTASK 54-55-02-040-004

- (1) Do this task: Prepare the Strut for Maintenance Operations, TASK 54-51-01-040-801

SUBTASK 54-55-02-010-003

- (2) Open the applicable aft fairing access panels:

(TASK 54-52-06-010-801)

<u>Number</u>	<u>Name/Location</u>
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
444BR	Aft Strut Fairing, Right Aft Panel, Strut 2

H. Clean the Aft Fairing Drain Tube, Casting and the Sump Drain

SUBTASK 54-55-02-020-002

- (1) Remove the casting from the sump.

SUBTASK 54-55-02-100-005

- (2) Clean the casting inner-diameter and the drain-tube forward-end outer-diameter of all unwanted materials and all residual filler material.

SUBTASK 54-55-02-100-003

- (3) Use a regulated air source, STD-77 or (0-345 kPa), to dry the internal surfaces of the aft fairing.

SUBTASK 54-55-02-212-001

- (4) Make sure that the drain tube and the sump drain is dry.

I. Silver Braze The Drain Tube

SUBTASK 54-55-02-310-001

- (1) Use silver brazing alloy, G50671 to braze the drain tube. Classification of the silver brazing alloy, G50671:
(a) Class B (50% maximum voids).
(b) Specification is per QQ-B-654A, in form BAg7 (Melting range 1145°F (618°C) to 1205°F (652°C) and Brazing Temperature 1205°F (652°C) to 1400°F (760°C)).
(c) The wire size can be 1/32 in. (0.79 mm) or 1/16 in. (1.59 mm).

J. Install The Drain Tube

SUBTASK 54-55-02-420-002

- (1) Install the tube-casting assembly with four BACB30VT6K3 Hi-Loks, BACC30BL6 Collars and BACW10BP3NAPU washers (under collars).

SUBTASK 54-55-02-420-003

- (2) Install wet with sealant, A00160.

SUBTASK 54-55-02-200-002

- (3) Make sure that the bracket holds the tube at NSTA 326.



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K. Put the Airplane Back to Its Usual Condition.

SUBTASK 54-55-02-200-003



CAUTION

MAKE SURE YOU REMOVE ALL TOOLS, LOOSE MATERIAL, AND DEBRIS FROM THE STRUT CAVITY. IF YOU DO NOT, THE DRAIN MAY BECOME BLOCKED AND CAUSE DAMAGE TO EQUIPMENT.

- (1) Make sure that the work area is clean. Remove all tools and other items.

SUBTASK 54-55-02-210-001

- (2) Close the aft fairing access doors:

(TASK 54-52-06-410-801)

Number Name/Location

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
444BR	Aft Strut Fairing, Right Aft Panel, Strut 2

SUBTASK 54-55-02-902-001

- (3) Do this task: Put the Strut Back to its Usual Condition, TASK 54-51-01-440-801.

———— END OF TASK ————

TASK 54-55-02-390-801

3. Aft Fairing Strut Drain - Temporary Repair

A. General

- (1) Use this task to do a temporary repair of the Aft Fairing Strut Drain.
(a) The temporary repaired Aft Fairing Strut Drain is permitted for 60 days.
(b) Examine the tube-casting interface in 15 day intervals. For each inspection, remove the two aft heat shield segments.

B. References

Reference	Title
54-51-01-040-801	Prepare the Strut for Maintenance Operations (P/B 201)
54-51-01-440-801	Put the Strut Back to its Usual Condition (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)

C. Tools/Equipment

Reference	Description
STD-77	Air Source, Regulated - Dry Filtered, 0-50 psig

D. Consumable Materials

Reference	Description	Specification
A00160	Sealant - Firewall - Hydraulic Fluid Resistant	BMS5-63

E. Location Zones

Zone	Area
410	Subzone - Engine 1
420	Subzone - Engine 2
430	Subzone - Engine 1, Nacelle Strut

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Zone	Area
440	Subzone - Engine 2, Nacelle Strut

F. Access Panels

Number	Name/Location
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
444BR	Aft Strut Fairing, Right Aft Panel, Strut 2

G. Prepare to Repair the Aft Fairing Strut Drain

SUBTASK 54-55-02-040-005

- (1) Do this task: Prepare the Strut for Maintenance Operations, TASK 54-51-01-040-801.

SUBTASK 54-55-02-010-004

- (2) Open the applicable aft fairing access panels:
(TASK 54-52-06-010-801)

Number	Name/Location
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
444BR	Aft Strut Fairing, Right Aft Panel, Strut 2

H. Clean the Aft Fairing Drain Tube, Casting and the Sump Drain

SUBTASK 54-55-02-030-001

- (1) Remove the casting from the sump.

SUBTASK 54-55-02-100-006

- (2) Clean the casting inner-diameter and the drain- tube forward-end outer-diameter of all unwanted materials and all residual filler material.

SUBTASK 54-55-02-800-001

- (3) Use a regulated air source, STD-77 or (0-345 kPa), to dry the internal surfaces of the aft fairing.

SUBTASK 54-55-02-212-002

- (4) Make sure that the drain tube and the sump drain is dry.

I. Apply Sealant and Install the Drain Tube

SUBTASK 54-55-02-914-002

- (1) Apply sealant, A00160 to the inner diameter of the casting.

SUBTASK 54-55-02-430-001

- (2) Insert the drain tube in the casting.

SUBTASK 54-55-02-212-003

- (3) Make sure that you remove all the unwanted sealant, A00160 away from the annular gap(top side) to prevent blockage.

SUBTASK 54-55-02-390-001

- (4) Add a fillet bead of sealant, A00160 at the bottom interface of the tube and casting.

SUBTASK 54-55-02-200-004

- (5) Make sure that the bracket at NSTA 326 holds the tube.

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J. Put the Airplane Back to its Usual Condition

SUBTASK 54-55-02-212-004



MAKE SURE YOU REMOVE ALL TOOLS, LOOSE MATERIAL, AND DEBRIS FROM THE STRUT CAVITY. IF YOU DO NOT, THE DRAIN MAY BECOME BLOCKED AND CAUSE DAMAGE TO EQUIPMENT.

- (1) Make sure that the work area is clean. Remove all tools and other items.

SUBTASK 54-55-02-410-003

- (2) Close the aft fairing access doors:

(TASK 54-52-06-410-801)

Number Name/Location

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
444BR	Aft Strut Fairing, Right Aft Panel, Strut 2

SUBTASK 54-55-02-440-003

- (3) Do this task: Put the Strut Back to its Usual Condition, TASK 54-51-01-440-801.

———— END OF TASK ————

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