

FLAP ROLLERS - REMOVAL/INSTALLATION

EFFECTIVITY: ALL

1. General

- A. This section gives the procedures to remove and install the rollers of the inboard and outboard flaps.
- B. These procedures are applicable to the twenty rollers of the flaps, which are installed in the LH and RH wings and LH and RH inboard and outboard flaps.
- C. The procedures in this section are given in the sequence below. The tasks identified with (◆) are part of the Scheduled Maintenance Requirements Document (SMRD).

TASK NUMBER	DESCRIPTION	EFFECTIVITY
27-51-15-000-801-A	ROLLERS - REMOVAL	ALL
27-51-15-400-801-A	ROLLERS - INSTALLATION	ALL

TASK 27-51-15-000-801-A

EFFECTIVITY: ALL

2. ROLLERS - REMOVAL

A. General

- (1) This procedure gives the instructions to remove the rollers of the LH or RH inboard and outboard flaps.

B. References

REFERENCE	DESIGNATION
AMM TASK 27-50-00-000-801-A/400	INBOARD FLAP - REMOVAL
AMM TASK 27-50-00-000-802-A/400	OUTBOARD FLAP - REMOVAL

C. Zones and Accesses

ZONE	PANEL/DOOR	LOCATION
532		LH wing
541		LH wing
571		LH inboard flap
572		LH outboard flap
632		RH wing
641		RH wing
671		RH inboard flap
672		RH outboard flap

D. Tools and Equipment

Not Applicable

E. Auxiliary Items

Not Applicable

F. Consumable Materials

Not Applicable

G. Expandable Parts

Not Applicable

H. Persons Recommended

QTY	FUNCTION	PLACE
1	Does the task	LH or RH wing, or LH or RH inboard or outboard flap
1	Helps the other technician	LH or RH wing, or LH or RH inboard or outboard flap

I. Preparation

SUBTASK 841-002-A

- (1) Remove the LH or RH inboard or outboard flap ([AMM TASK 27-50-00-000-801-A/400](#)) or ([AMM TASK 27-50-00-000-802-A/400](#)).

J. Removal ([Figure 401](#))

SUBTASK 020-002-A

- (1) Remove the cotter pin (4) (if applicable).
- (2) Remove the nut (3) and washer (2).

WARNING: CA-1000 CORROSION-INHIBITING COMPOUND IS TOXIC TO SKIN, EYES AND RESPIRATORY TRACT. USE PVC GLOVES AND EYE PROTECTION. USE ONLY IN WELL VENTILATED AREAS. OBEY THE MANUFACTURERS' HEALTH AND SAFETY INSTRUCTIONS.

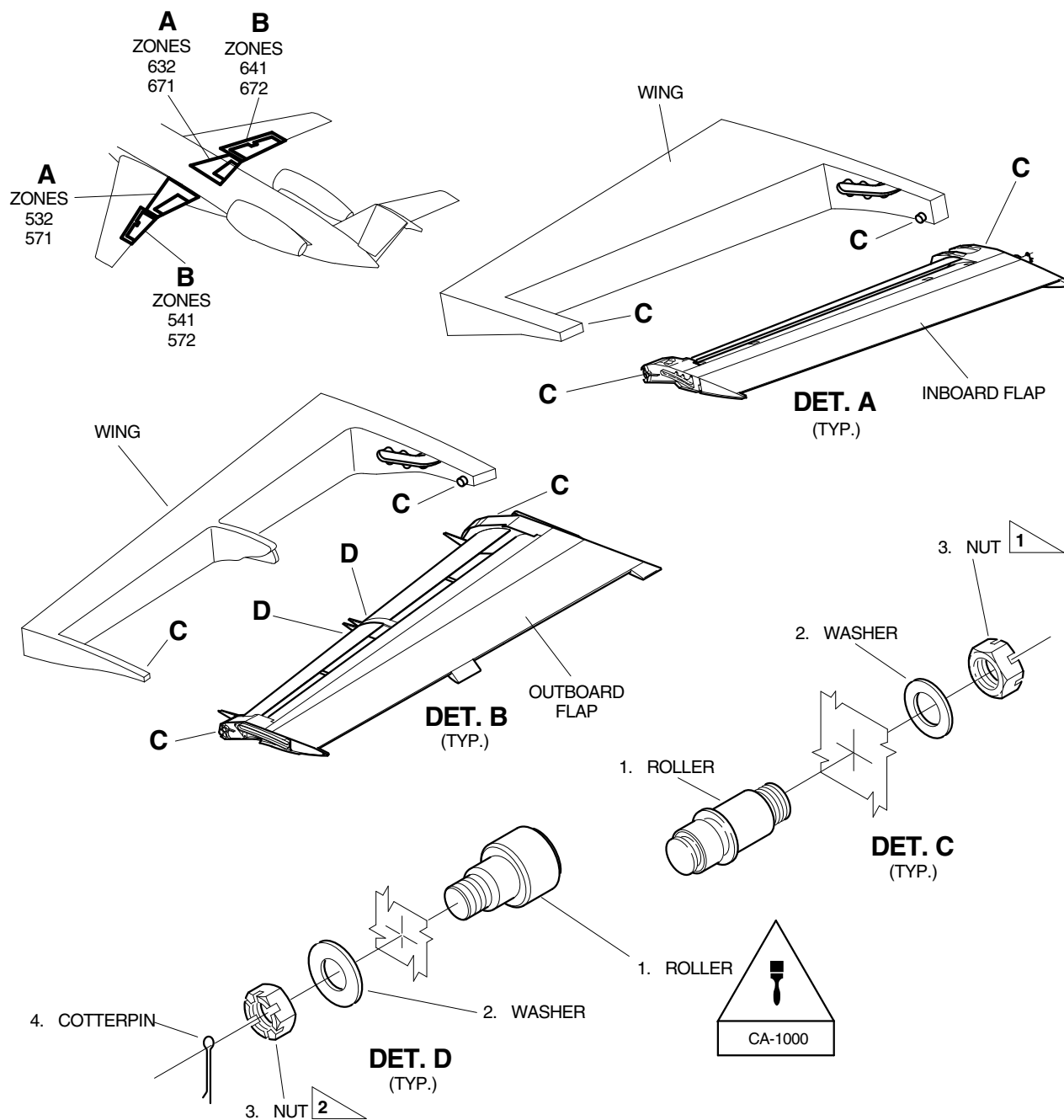
- (3) Remove the roller (1).

NOTE: If two or more rollers must be removed and installed again, identify their positions to install them correctly.

EFFECTIVITY: ALL

Rollers - Removal/Installation

Figure 401



1 TORQUE: 110-125 Nm (885-1106 lb.in)

2 TORQUE: 75-90 Nm (664-796 lb.in)

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TASK 27-51-15-400-801-A
EFFECTIVITY: ALL

3. ROLLERS - INSTALLATION

A. General

- (1) This procedure gives the instructions to install the rollers of the LH or RH inboard and outboard flaps.

B. References

REFERENCE	DESIGNATION
AMM TASK 27-50-00-400-801-A/400	INBOARD FLAP - INSTALLATION
AMM TASK 27-50-00-400-802-A/400	OUTBOARD FLAP - INSTALLATION
IPC 57-52-00	INBOARD FLAP
IPC 57-53-00	OUTBOARD FLAP

C. Zones and Accesses

ZONE	PANEL/DOOR	LOCATION
532		LH wing
541		LH wing
571		LH inboard flap
572		LH outboard flap
632		RH wing
641		RH wing
671		RH inboard flap
672		RH outboard flap

D. Tools and Equipment

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Torque wrench (0-1500 lb.in)	To tighten the nut which attaches the roller	

E. Auxiliary Items

Not Applicable

F. Consumable Materials

Not Applicable

G. Expendable Parts

ITEM	IPC REFERENCE (VENDOR REFERENCE)	QTY
Inboard flap roller	IPC 57-52-00	AR
Outboard flap roller	IPC 57-53-00	AR

(Continued)

ITEM	IPC REFERENCE (VENDOR REFERENCE)	QTY
Cotter pin	IPC 57-53-00	AR

H. Persons Recommended

QTY	FUNCTION	PLACE
1	Does the task	LH or RH wing, or LH or RH inboard or outboard flap
1	Helps the other technician	LH or RH wing, or LH or RH inboard or outboard flap

I. Installation (Figure 401)

SUBTASK 420-002-A

WARNING: CA-1000 CORROSION-INHIBITING COMPOUND IS TOXIC TO SKIN, EYES AND RESPIRATORY TRACT. USE PVC GLOVES AND EYE PROTECTION. USE ONLY IN WELL VENTILATED AREAS. OBEY THE MANUFACTURERS' HEALTH AND SAFETY INSTRUCTIONS.

(1) Apply corrosion-inhibiting compound to the roller (1). For this use PVC gloves and goggles.

(2) Put the roller (1) in its installation position.

NOTE: If two or more rollers to be installed are those ones which were removed before, refer to their position identification to install them in the same positions as those they were removed from.

(3) Attach the roller (1) with the washer (2) and nut (3).

(4) Tighten the nut (3) with a torque of 100-125 N.m (885-1106 lb.in) or 75-90 N.m (664-796 lb.in), as applicable (refer to DET. C or DET. D).

(5) If applicable, install the cotter pin (4) (refer to DET. D).

J. Follow-on

SUBTASK 842-002-A

(1) Install the LH or RH inboard or outboard flap ([AMM TASK 27-50-00-400-801-A/400](#)) or ([AMM TASK 27-50-00-400-802-A/400](#)).