



737-600/700/800/900

Powerplant Buildup Manual

Avia Capital Services, LLC

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POWERPLANT BUILDUP MANUAL

Avia Capital Services, LLC
AKS
Revision No. 46
Jun 15/2015

To: All holders of this Boeing Document D633A106-AKS

Attached is the current revision to the Boeing 737-600/700/800/900 CFM56-7 Powerplant Buildup Manual.

The Powerplant Buildup Manual (PPBU) is furnished either as a printed manual or as digital products, or a combination of the two. This revision replaces all previous digital products. All products are reissued with all obsolete data deleted and all updated pages added.

For printed manuals, changes are indicated on the List of Effective Pages (LEP). The pages which are revised will be identified on the LEP by an R (Revised), A (Added), O (Overflow, i.e. changes to the document structure and/or page layout), or D (Deleted). The pages that contain customer originated data will be identified on the LEP by a C (COC). Each page in the LEP is identified by Chapter-Section-Subject number, page number and page date.

Pages replaced or made obsolete by this revision should be removed and destroyed.

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TEMPORARY REVISIONS

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A TR status report is sent with each TR. The TR status report has a list of all TRs that were sent for this manual during the last two revision cycles. At the top of the list is the date and time that the list was created.

When you have more than one TR, the TR status report with the latest date and time gives you the most current information.

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Location of Change

FRONTMATTER

Description of Change

Added the data to show the optional method of reducing P-CLAMP distortion.
Changed commercial tool table.
Changed special tool table.
Changed standard consumable table
Changed the data in the Numerical Index to reflect the latest information.

CHAPTER 71

71-00-02

FIGURE 5-1

Added the data to show the part number for the BRACKET ASSY.

FIGURE 8-1

Changed the grip length of the BOLT.

FIGURE 9-1

Added the data to update the procedure to prevent p-clamp distortion upon installation.

FIGURE 10-1

Added the data to update the procedure to prevent p-clamp distortion upon installation.

Re-issued the page.

Changed the item number and torque for the BOLT.

FIGURE 14-1

Added the data to show the part number for the O-RING.

Added the data to show the part number for the PRECOOLER CONTROL VALVE.

Added the data to show the optional part number for the SEAL.

Added the data to show the optional part number for the COUPLING.

Changed the data to show the Length of the BOLT.

FIGURE 15-1

Added the data to update the procedure to prevent p-clamp distortion upon installation.

Added the data to show the part number for the O-RING.

Added the data to show the part number for the O-RING.

Added the data to show the optional part number for the COUPLING.

Added the data to show the optional part number for the SEAL.

Changed the quantity of the safety cable.

FIGURE 17-1

Added the data to update the procedure to prevent p-clamp distortion upon installation.

Changed the torque requirements for the BOLT.

Added the data to show the part number for the O-RING.

Added the data to show the part number for the O-RING.

Added the data to show the optional part number for the SEAL.

Added the data to show the optional part number for the COUPLING.

Added a CAUTION to the procedure.

Changed the quantity of the CLAMP and BOLT.

Changed the illustration to show the CLAMP.

FIGURE 18-1

Added the data to show the optional part number for the SEAL.

FIGURE 21-1

Added the data to show the optional part number for the COUPLING.

FIGURE 24-1

Added a CAUTION to the procedure.

Changed the quantity of the CLAMP and BOLT.

Changed the illustration to show the CLAMP.

Added the data to update the procedure to prevent p-clamp distortion upon installation.

HIGHLIGHTS



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Location of Change

(Cont)

FIGURE 25-1

Description of Change

Changed the illustration to show WITH and WITHOUT FASTENER.

Changed the data to limit (LTD) engines with the Pressure Relief Valve.

Added the data to show the optional part number for the SEAL.

Added the data to show the optional part number for the COUPLING.

Removed a flex joint from the illustration.

Added the data to show the part number for the BRACKET ASSY.

Added the data to show the optional part number for the SEAL.

Added the data to show the optional part number for the COUPLING.

Added the data to show the part number for the O-RING.

Changed the structure of a sentence.

Added the data to show the part number for the VALVE ASSEMBLY.

Re-issued the page.

Added the data to show the optional part number for the SEAL.

Added the data to show the optional part number for the COUPLING.

FIGURE 27-1

FIGURE 33-1

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EFFECTIVE PAGES



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REVISION RECORD



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RECORD OF TEMPORARY REVISION



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RECORD OF TEMPORARY REVISION



**737-600/700/800/900
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INTRODUCTION

1. General

- A. The 737-600/700/800/900 CFM56-7 series Powerplant Buildup Manual provides procedures for installing a Boeing QEC kit on a CFM56-7 series engine.
- (1) The manual is divided into four major sections: Front Matter, 71-00-02 Powerplant Buildup, 71-00-03 QEC System Tests, and 71-00-04 QEC Inspection/Check.
 - (2) Section Front Matter contains these items:
 - (a) Description of major characteristics of the powerplant
 - (b) Usage instructions for this manual
 - (c) List of special tools, fixtures, and equipment used in this manual
 - (d) List of vendor names and addresses
 - (e) List of all consumable materials used in this manual
 - (f) A summary of applicable standard practices
 - (g) An index which lists all installation tasks in the manual in alphanumerical sequence by title, and
 - (h) A numerical index which lists all part numbers contained in each installation parts list.
 - (3) Section 71-00-02 Powerplant Buildup contains these items:
 - (a) An illustrated installation index of all buildup installations in order of accomplishment.
 - (b) Parts lists and procedures to build up a basic engine into a demountable powerplant.
 - (4) Section 71-00-03 QEC System Test contains procedures that are used to test the installed components before engine installation on an airplane.
 - (5) Section 71-00-04 QEC Inspection/Check contains general inspection/check procedures for QEC components.

- B. Abbreviations and terms used in this manual are defined below as follows:

Table 1:

ABBREVIATION	DEFINITION
AEW&C	Airborne Early Warning and Control
AGB	Accessory Gearbox
ASSY	Assembly
BIFUR	Bifurcation
BRKT	Bracket
BTWN	Between
CFMI	Commercial Fan Moteur International
CON	Consumable
CONT	Continued
CSK	Countersink/Countersunk
CRES	Corrosion Resistant Steel
DAC	Double Annular Combustor
DEL	Deleted

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ABBREVIATION	DEFINITION
DET	Detector, Detection
EEC	Electronic Engine Control
ENG	Engine
FIG	Figure
FLG	Flange
FTG	Fitting
FWD	Forward
GSE	Ground Support Equipment
HMU	Hydro/Mechanical Unit
HYD	Hydraulic
ID	Inner Diameter
IDG	Integrated Drive Generator
INSTL	Installation
LH	Left
LTD	Limited
LPT	Low Pressure Turbine
LWR	Lower
MAX	Maximum
OPT	Optional
OUTBD	Outboard
PRESS	Pressure
QAD	Quick Attach Detach
QEC	Quick Engine Change (Kit)
QTY	Quantity
REF	Reference
REG	Regulator
REQD	Required
RH	Right
SAC	Single Annular Combustor
SYS	System
TAI	Thermal Anti-Ice
TEMP	Temperature
TOL	Tool
UPR	Upper
VEN	Vendor

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ABBREVIATION	DEFINITION
W/B	Wire Bundle

Table 2:

TERMS:	DEFINITION
Basic Engine	The assembled engine as furnished by the engine manufacturer.
Demountable Powerplant	Basic engine with QEC equipment installed.
QEC Equipment	Airframe manufacturer supplied parts installed during powerplant buildup.
Run-On Torque	Torque required to check self-locking features of nuts or nut plates.

2. Description

A. CFM56-7 Series Basic Engine

- (1) The CFM56-7 series engine is a dual-rotor, axial-flow, high bypass ratio turbofan. A single-stage high pressure turbine drives the 9 stage high pressure compressor. A four stage low pressure turbine drives the integrated front fan and low pressure compressor. The accessory drive system extracts energy from the high pressure, high-speed rotor to drive engine accessories and engine mounted airplane accessories.
- (2) Accessory items pertaining to engine operation such as hydro/mechanical unit, electronic engine control, fuel filter, fuel pump, oil/fuel heat exchanger, oil tank, oil filter, oil pump, starter, and other necessary equipment are supplied and installed by CFMI. Installation procedures for these items are contained in the CFMI CFM56-7 Engine Manual.
- (3) Identification of engine flanges is given in Figure 1.

B. Demountable Powerplant

- (1) The demountable powerplant consists of the CFMI CFM56-7 series basic engine and Boeing furnished QEC kit parts.
- (2) Principal physical characteristics of the powerplant are approximately Figure 2:

NOTE: The weights provided below are approximate and should not be used for weight and balance purposes.

Table 3:

ITEM	WEIGHT	LENGTH	DIAMETER
Basic Engine	5185 lb (2351 kg)	121.7 in. (309 cm.)	66.1 in. (167.8 cm.)
Short Primary Nozzle Assembly	107 lb (48.5 kg)	27 in. (68 cm.)	38 in. (96 cm.)
Short Primary Plug Assembly	77 lb (35 kg)	61.7 in. (156.7 cm.)	26 in. (66 cm.)
Inlet Cowl	355 lb (161 kg)	TBD in. (TBD cm.)	89 in. (226 cm.)
Demountable Powerplant (w/ Short Nozzle/Plug)	6620 lb (3002 kg)	200 in. (508 cm.)	89 in.* (226 cm.)

* Maximum diameter.

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- (3) Engines and inlet cowls are directly interchangeable between engine positions 1 and 2 on all 737-600/700/800/900 series airplanes.

C. QEC Equipment

- (1) Accessory items installed on the engine are supplied by Boeing in the form of a QEC (Quick Engine Change) kit. Contact Boeing Customer Services-Spares for the correct kit part/dash number. Procedures for installing this equipment are given in this manual.
- (2) QEC kit parts packaging
- (a) The QEC kit parts are packaged in a series of tasks identified in the Special Spares Breakdown - Powerplant document issued by Boeing Customer Services - Spares. The task numbers correlate to the figure numbers of 71-00-02. As an example, parts for Figure 8-1 are contained in Task No. 8.
 - (b) Task No. 110 contains all standards and attaching hardware of the QEC kit with the exception of, Figure 2-1, Figure 3-1, and Figure 31-1. For these figures, the standards and attaching hardware will be packaged together with the other Figure/Item hardware. As an example, the standards and attaching hardware for Figure 2-1 are contained in Task No. 2.
- (3) The installations that follow make up a QEC kit:

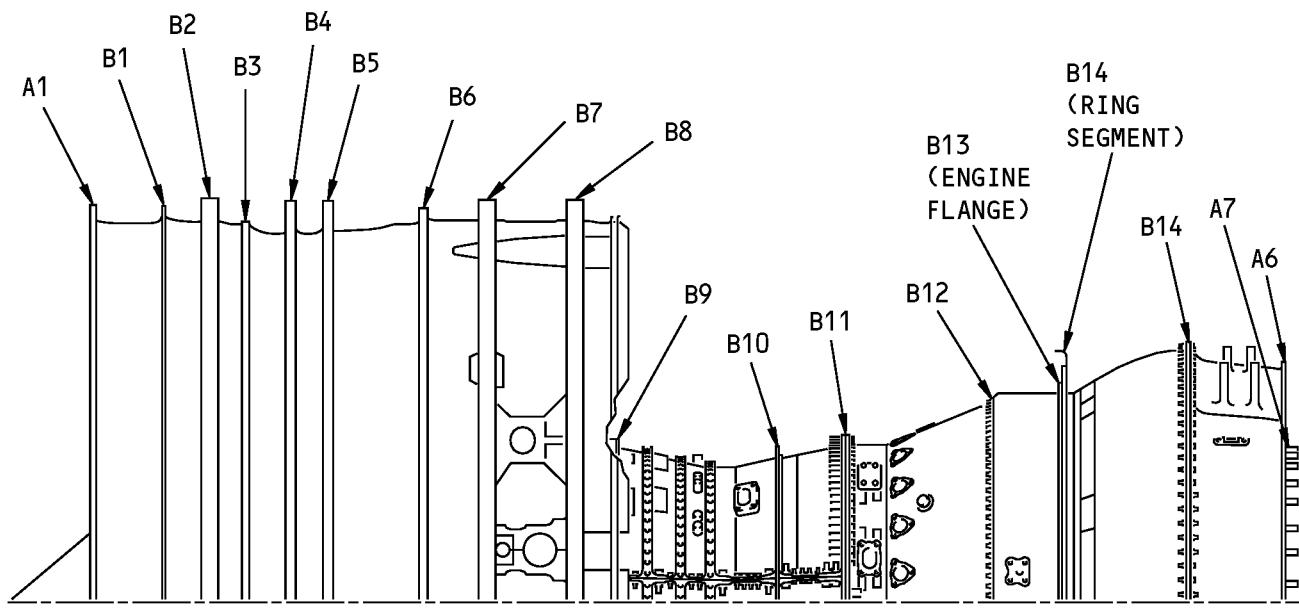
Table 4:

INSTALLATION	DWG NUMBER
ENGINE TO STRUT	310A2010
FWD ENGINE MOUNT	310A2020
AFT ENGINE MOUNT	310A2030
THRUST LINK	310A2040
MARKER	330A2010
DRAINS	332A2100
FUEL SUPPLY HOSE	332A2100
IDG PLUMBING	332A2100
PNEU BLEED SYSTEM	332A2100
WIRE HARNESS	332A2200
INLET COWL TAI SYSTEM	332A2300
PNEU BLEED CONTROLLER	332A2300
PNEU BLEED DUCT	332A2300
START VALVE AND DUCT	332A2300
12 O'CLOCK STRUT	332A2370
HYDRAULIC PUMP	332A2400
FIRE DETECTION	332A2500
IDG	332A2600
BRACKET	332A2900
PRIMARY EXHAUST	333A2100
INLET	334A2000

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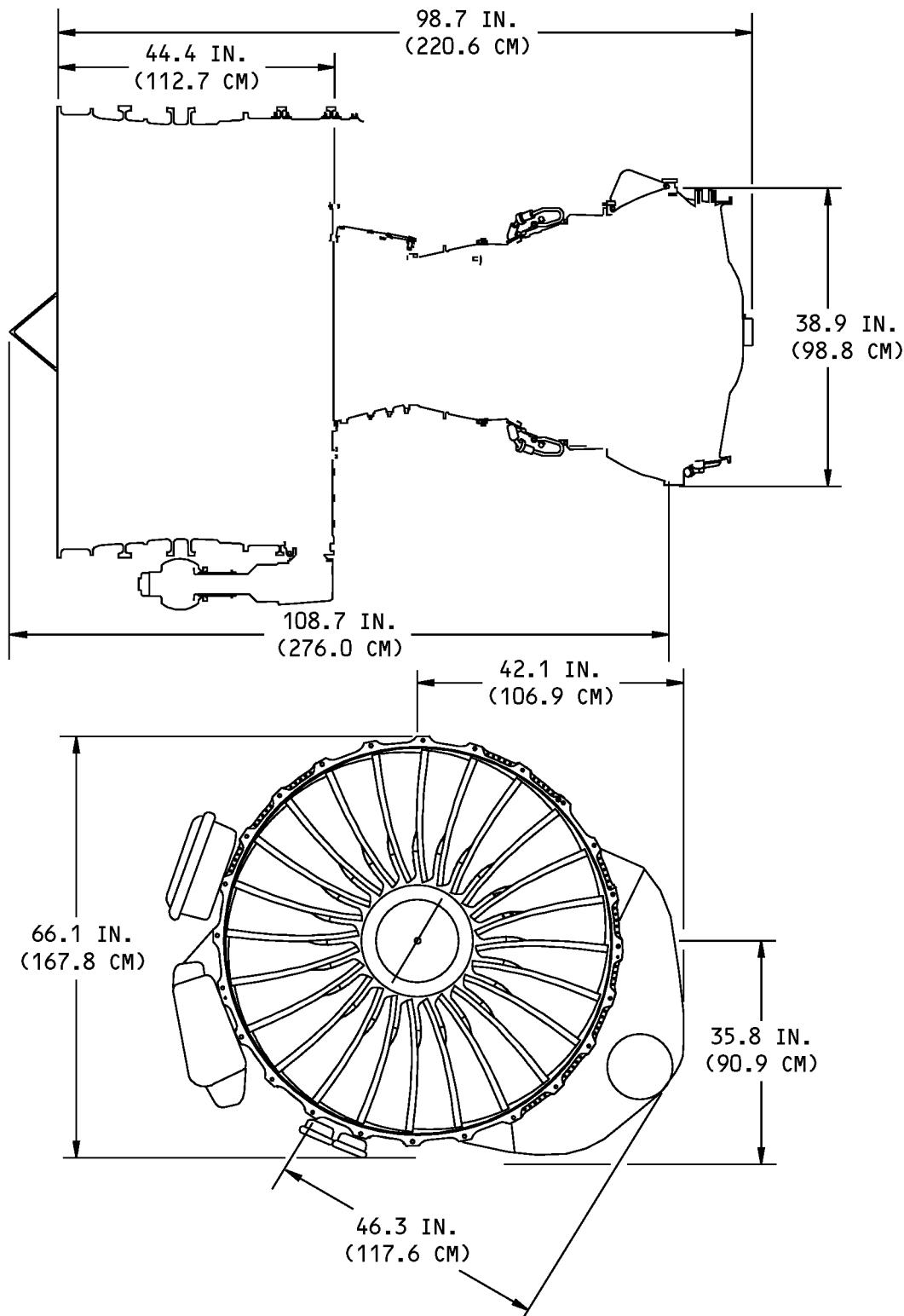


Engine Flange Locations
Figure 1 (Sheet 1)

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Bare Engine Dimensions
Figure 2 (Sheet 1)

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3. Instructions for Using Manual

A. Figure and Item Numbers (71-00-02)

- (1) Figure numbers are assigned to individual segments of build up in a sequential order of accomplishment. Figures in 71-00-02, Powerplant Buildup, utilize a two-part naming nomenclature. The first part is the assigned buildup sequence number. The second part is used to control the configuration. (An exception is Figure 1-1, which is an index figure for 71-00-02.). Please note that if a particular configuration is not applicable to your fleet, it will not be included.
- (2) Item numbers are assigned to parts, wherever possible, in order of installation. The part listing with item numbers and nomenclatures appear on the text pages immediately following the applicable steps for installation of the parts. Unless specified differently, each figure is a complete task and contains its individual set of item numbers.
- (3) Item numbers for consumable materials are assigned a prefix C (e.g. C1). Each of the consumable materials has a unique item number that remains the same throughout each figure. The item number, bulk code number, nomenclature and specification for each consumable material appears on the text page immediately following the applicable steps for the use of that consumable material.
- (4) Item numbers for special tools, fixtures and equipment are assigned a prefix T (e.g. T1). Each of the tools has a unique item number that remains the same throughout each figure. The item number, tool part number and nomenclature for each tool appears on the text page immediately following the applicable steps for the use of that tool.
- (5) Item numbers preceded by a dash (-) in the FIG. ITEM or ITEM NO. column indicates the item is not illustrated.
- (6) Gaps in item numbers are used either for configuration control or for future growth, and does not indicate missing parts.
- (7) This manual uses the indenture system for listing its parts. This system shows the relationship of one part to another. For a given part, the number of indentures defines the relationship of that part to the associated installation, next higher assembly, or components of the part as follows:
Detail parts, Assembly, or Attaching parts for assembly
Detail parts for assembly, or Sub-assembly, or Attaching parts for sub-assembly

B. Locating a Part

- (1) If a part number is known and it is required to identify the location of the part, find the part number in the Numerical Index in section 71-00-00 and note the section, figure and item number of the part. Locate the item number on the text page of the applicable figure for identification of the part.
- (2) If the part number is not known, but the system or general area on the engine is known, then it may be possible to locate the applicable figure from the alphabetical listing of installations in the Installation Index, 71-00-00, or from the sequential listing in Figure 1-1.
- (3) BCREF() - (Boeing Company Ref) part number is a reference number assigned to all part numbers that exceed 15 digits.
 - (a) The actual part number is included in parenthesis after the part name in the nomenclature column.
 - (b) When ordering these parts from Boeing, use either the BCREF() part number or the actual part number.

C. Use of Assembly Procedures

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- (1) Assembly procedures assume the engine is supported on pedestals, adapters, and brackets.
- (2) Each area of work as illustrated has the instructions and parts list located on the page facing the illustration. The parts required to perform a step are listed immediately following the step.
- (3) Vendor codes are listed for vendor parts in the parts list to enable identification of the vendors. A list of vendors and their codes and addresses is provided in the Vendor Codes list.
- (4) All tightening requirements are specified in the applicable steps of the buildup procedures.
- (5) Consumable materials, such as lubricants, sealants and tape as specified in buildup procedures, are listed in section 71-00-00 with their specification. In addition, if all usage location are required for a consumable, use the table in paragraph () of section 71-00-00 to determine the bulk code. Then use the Numerical Index, section 71-00-00 to find all locations where that consumable is used.

D. Definitions of part effectiveness terms

- (1) AR - Parts with AR (AS REQUIRED) in the QTY (quantity) column can be used as required.
- (2) CON - Items with CON (CONSUMABLE) in the UC (usage code) column, and AR (as required) in the QTY (quantity) column, are consumable materials that are used in that figure. Each consumable material's bulk code is listed in the PART NUMBER column and the description and specification are listed in the NOMENCLATURE column. These consumable materials are not part of the QEC kit.
- (3) DEL - Parts with DEL in the UC (usage code) column and a dash in the QTY (quantity) column should not be used or reinstalled.
- (4) OPT - Parts with OPT (OPTIONAL) in the NOMENCLATURE column, OPT in the UC (usage code) column and a dash in the QTY (quantity) column, are optional and interchangeable with the same item number listed with a quantity listed in the QTY column. Parts listed with a quantity are preferred and should be used if available.
- (5) REF - Parts with REF (REFERENCE) in the UC (usage code) column and a dash in the QTY (quantity) column have been identified and installed on an earlier or later sheet or page in the same figure or is a sub-part of an assembly and included for clarification.
- (6) REPLD BY - Parts with REPLD BY (REPLACED BY) in the NOMENCLATURE column, a LTD (LIMITED) in the UC (usage code) column and a dash in the QTY (quantity) column have been installed on engines delivered on earlier new airplanes and/or have been supplied in earlier QEC kits. These parts are no longer preferred and should not be ordered. Parts having the same item number with a quantity listed in the QTY column are improved designs or are required due to adjacent engine configuration changes and are supplied in current QEC kits.
- (7) TOL - Parts with TOL (TOOL) in the UC (usage code) column, and a dash in the QTY (quantity) column, are special tools, fixtures and equipment that may be required. These tools are not part of the QEC kit.
- (8) VEN - Parts with a vendor cage code in the NOMENCLATURE column and/or VEN (VENDOR) in the UC (usage code) column are vendor part number.

4. Standard Practices

- A. Before starting engine buildup, read applicable section of manual to become familiar with items to be installed and procedures to be followed.
Also, review the Standard Overhaul Practices Manual (D6-51702) for additional information on standard practices, specifically the following:

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Table 5:

Title	Standard Overhaul Practices Manual Chapter
Repair of electrical terminations and electrical bonding areas	20-11-03
Bolt and Nut Installation	20-50-01
Installation of Safety Devices	20-50-02
Bearing Installation and Retention	20-50-03
Installation of Permanent Drill Passage Pin and Plug	20-50-04
Application of Aluminum Foil and Other Markers	20-50-05
Installation of O-Rings and Teflon Seals	20-50-06
Lubrication	20-50-07
Application of Dry Lubricant	20-50-08
Installation of Protective Grommets	20-50-09
Application of Stencils, Insignia, Silk Screen, Part Numbering and Identification Markings	20-50-10
Application of Aerodynamic Smoothing Sealant	20-50-11
Application of Adhesives	20-50-12
Application of Weather, Fuel Oil, Solvent and Heat Resistant Protective Coatings	20-50-13
Cleaners	20-60-01
Finishing Materials	20-60-02
Lubricants	20-60-03
Miscellaneous Materials	20-60-04

B. Counter-Sunk (CSK) Washers

- (1) CSK washers are manufactured with a chamfer on one of the edges of the inside diameter. Position the chamfered edge of the washer against the bottom surface of the bolt head.

C. Electrical Harness

- (1) Position electrical harness between connectors to provide equal distribution of support loading on clamps. Maintain sufficient slack at connectors to prevent stress loading the connection.
- (2) Do not wrap tape on the wire bundle under the clamp.
- (3) When connecting to electrical connectors, turn knurled coupling ring while wiggling the backshell assembly. After fully seating the coupling ring, use soft-jawed pliers or a strap wrench to tighten the coupling ring an additional 1/8 turn or until plier slippage occurs Figure 3 (Sheet 1).
- (4) Install protective covers on connectors and receptacles not connected. Lockwire all threaded connectors after installation.
- (5) Boeing-furnished wire bundles shall have a maximum tie spacing of 2 inches.

D. Clamps

- (1) Floating Clamps

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- (a) Floating clamps are utilized to establish adequate clearance between tubing, hoses and wire bundles to dampen vibration and prevent chafing.
- (b) Illustrations which show clamping for wire bundles, tubing, and hoses in most cases show floating clamp installations in approximate clamping locations.
- (c) Actual clamp locations may be adjusted from those illustrated and additional clamps may be used to provide required clearances. A minimum clearance of 0.5 inch is desirable, however, 0.2 inch is permissible where 0.5 inch cannot be obtained.

E. Lockwiring

- (1) Perform all lockwiring using double twist method per Overhaul Manual 20-50-02 and standard industry practice.
- (2) Use of safety cable in place of lockwire is allowed. Safety cable can only be used with bolts which have center drilled heads. Refer to the applicable installation figures for usage instructions.

F. Lubrication

- (1) Lubricate O-ring packings and fittings prior to installation unless specified otherwise.
- (2) Apply grease or anti-seize compound to splines as specified.

G. Tubes and Fittings

- (1) Proper alignment must be obtained between fittings and tubing to prevent preloading of lines and assure proper mating of threaded parts.

Table 6:

FLUID TUBING MINIMUM CLEARANCE REQUIREMENTS: (UNLESS NOTED OTHERWISE)
BETWEEN ALL RIGID LINES AND ADJACENT STRUCTURE
0.50 INCH - AT NON-SUPPORTED LOCATIONS
0.10 INCH - AT SUPPORTED LOCATIONS (OR THE THICKNESS OF THE SUPPORTING CLAMPS WHEN THE TUBING IS CLAMPED DIRECTLY TO THE SUPPORTING STRUCTURE)
NEAR ANY POSITION OF AN OPERATING MECHANISM
0.50 INCH - AT NON-SUPPORTED LOCATIONS
0.25 INCH - AT SUPPORTED LOCATIONS WHEN IT IS EVIDENT THAT NO CHAFING OR INTERFERENCE WILL RESULT
BETWEEN TUBES THAT CROSS OR RUN PARALLEL
0.50 INCH - OR THE THICKNESS RESULTING FROM BACK-TO-BACK CLAMPING (ADDITIONAL BACK-TO-BACK CLAMPING MAY BE USED TO MEET MINIMUM CLEARANCE REQUIREMENTS)
BETWEEN TUBES AND CONTROL CABLES
0.625 INCH - BETWEEN BREAK POINTS OR FAIRLEADS AND CLAMPBLOCK
NOTE: Tubing installations shall be considered supported for a distance of 3 inches from a B-nut that attaches a tube to a rigid piece of equipment.

- (2) Allowable preload shall not exceed the following limits at clamp points when end fittings are attached and torqued.

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Table 7:

Tube Size	Max. Preload
5/8" & Larger	20 lbs. (89 newtons)
1/2"	10 lbs. (44.5 newtons)
3/8"	5 lbs. (22.2 newtons)
1/4"	3 lbs. (13.3 newtons)

- (3) Up to three BACS18AF spacers may be used under support clamp to meet preload limitations.

NOTE: Ovality of tubes shall not exceed 5% after installation.

H. Tamper-proof "Inspection Verification" seal

- (1) This seal can be used as a visual check of the component after the final torque is applied. It is not required, but its application may be operator policy.
- (2) Make the seal an 1/8-inch wide strip of tamper-proof putty that extends across the junction of the mating parts and continues for 1/2-inch on each side of the mating connection.
 - (a) On tubes, locate the tamper-proof putty to minimize the possibility of the putty entering the tube when the tube is disconnected later.

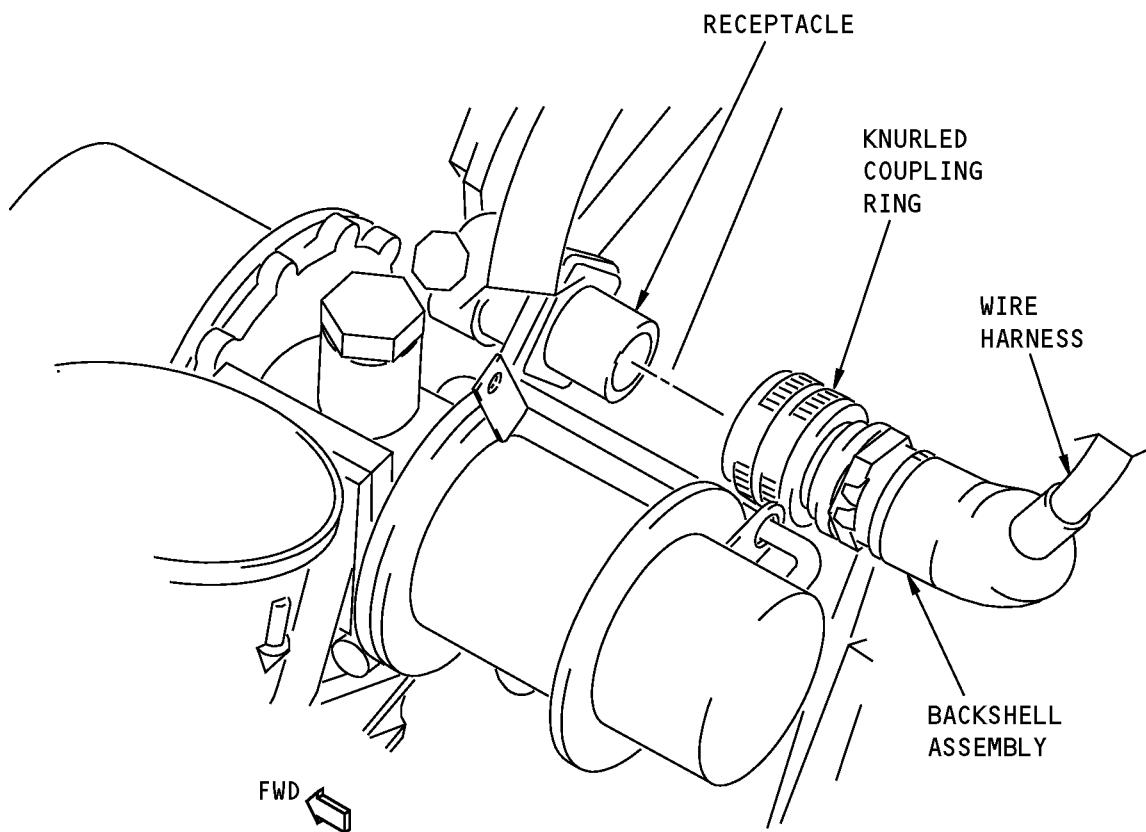
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Wire Harness Connectors
Figure 3 (Sheet 1)

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5. Part Substitution

- A. Preferred parts are listed first and are applicable to the engine buildup configuration which was installed on the most recent engine configuration to be delivered.
- B. Replaced-by parts should not be used on new engines but may be required for buildup of previous engine configurations.
- C. Optional parts are listed immediately below the preferred part and may be used in place of preferred parts.
- D. Optional parts may be ordered if preferred parts are not available.
- E. Replaced by parts should not be ordered if preferred parts are not available.
- F. The following table lists obsolete part numbers for standard parts. These obsolete parts are no longer preferred and are not shown in the installation procedure.

Table 8:

OBSOLETE PART NUMBER	PREFERRED PART NUMBER
AS3236-06	BACB30ZF3-06
AS3236-08	BACB30ZF3-08
AS3236-10	BACB30ZF3-10
AS3236-28	BACB30ZF3-28
AS3237-05	BACB30ZF4-05
AS3237-06	BACB30ZF4-06
AS3237-07	BACB30ZF4-07
AS3237-08	BACB30ZF4-08
AS3237-09	BACB30ZF4-09
AS3237-10	BACB30ZF4-10
AS3237-11	BACB30ZF4-11
AS3237-12	BACB30ZF4-12
AS3237-14	BACB30ZF4-14
AS3237-22	BACB30ZF4-22
AS3237-23	BACB30ZF4-23
AS3237-24	BACB30ZF4-24
AS3237-29	BACB30ZF4-29
AS3237-32	BACB30ZF4-32
AS3237-34	BACB30ZF4-34
AS3510-02()K	BACC13AT3K()
BACE21BT0606JN	AS4138J0606
BACE21BT0606T	AS4138T0606
MS21043-3	BACN10JC3C
MS21902-6T	AS5230T0606

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(Continued)

OBSOLETE PART NUMBER	PREFERRED PART NUMBER
MS21902-12T	AS5230T1212
MS21902J6	AS5230J0606
MS21902K6	MS21902J6
MS21924J20	AS1007T2020
MS21924-20T	AS1007T2020
MS24391J6	AS5169J06
MS35338-120	BACW10EC4M
MS35842-12	BACC10JB034C064
NAS1611-024	NAS1611-024A
NAS1611-153	NAS1611-153A
NAS1612-12	NAS1612-12A
NAS1612-20	NAS1612-20A
NAS1612-6	NAS1612-6A
NAS1802-4-16	BACS12HN4U16
NAS1805-3	BACN11Z3CK
NAS1805-4	BACN11Z4CK
NAS1805-6L	BACN11Z6CD
NAS1805-8P	BACN11Z8C

6. Customer Originated Material

- A. Customer originated material, incorporated into the manual at customer request to reflect data or procedures originated by and peculiar to that specific customer, will be permanently identified by the customer's three-letter designator in the space adjacent to the revision bar. In addition, these pages are identified on the List of Effective Pages (LEP) with a special character called a hollow lozenge which is located to the right of the date field. THE BOEING COMPANY does not assume responsibility for the validity and/or the technical accuracy of material so identified. THE BOEING COMPANY will not undertake to test or evaluate in any form the validity or the technical accuracy of the customer-originated material, and the customer shall have the sole and exclusive responsibility for the validity and accuracy of material submitted for incorporation into the manual.
- B. THE BOEING COMPANY HEREBY EXPRESSLY DISCLAIMS ANY AND ALL WARRANTIES, EXPRESSED OR IMPLIED, ORAL OR WRITTEN, ARISING BY LAW, COURSE OF DEALING, OR OTHERWISE, AND WITHOUT LIMITATION ALL WARRANTIES AS TO QUALITY, OPERATION, MERCHANTABILITY, FITNESS FOR ANY INTENDED PURPOSE, AND ALL OTHER CHARACTERISTICS WHATSOEVER, OF CUSTOMER-ORIGINATED MATERIAL INCORPORATED INTO THIS MANUAL. THE FOREGOING DISCLAIMER SHALL ALSO APPLY TO ANY OTHER PORTION OF THIS MANUAL WHICH MAY BE AFFECTED OR COMPROMISED BY SUCH CUSTOMER-ORIGINATED CHANGES.

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7. Normal Revision Service

- A. Aircraft operators who have contracted continuing revision service for this manual receive revisions one time per year dated June 15. Pages which are revised will be so indicated on the list of effective pages by an symbol (R) and identified by both a date and a page code. A revised page may carry a new or the same code and may be dated prior to, the same as, or subsequent to the date of the page it replaces. On each individual page the revised area is indicated by a revision bar on the left margin. Those pages which have not been technically revised, but have been reprinted due to recombination, are so indicated by a revision bar opposite the page number and date.

8. Temporary Revision Service

- A. Temporary revision service to this manual will be issued as necessary to alert the customer of configuration changes and to provide advance information prior to the next scheduled revision. Each temporary revision will be incorporated into the next available scheduled revision of the manual, except for "open dated" temporary revisions issued to cover temporary configuration changes, due to e.g., installation of test equipment. These "open dated" temporary revisions will remain active until Boeing has been advised by the customer that the final configuration has been completed.
- B. Each temporary revision will apply to one subject only and will be keyed within this manual so that the temporary revision may be filed facing or to replace the affected pages. Temporary revisions will not be revised.

If changes are required to an existing temporary revision, the temporary revision will be reissued.

9. Publications Change Requests

- A. Communications concerning this publication should be directed to Boeing Commercial Airplanes; Attention: Maintenance Engineering Technical Services, M/S 2J-02; P.O. Box 3707, Seattle WA 98124. To facilitate uniform handling and to provide direct routing of your questions to the proper Boeing organization, use of the Publications Change Request (PCR) Form is encouraged. Boeing makes this form available through your publications organization.

10. Consumable Material Lists

The tables that follow list all of the consumable materials used in this manual.

A separate table will be shown for each different material code. The data in the table is then sorted by the bulk reference number.

- The first set of tables contain all the standard consumable materials.
- The second set of tables contain all the engine consumable materials and will include the engine manufacturers reference number.

Table 9: Adhesives, Cements, Sealants

Reference	Description	Specification	Material	Supplier
A00027	Adhesive - Silicone Rubber, 1 Part, RTV	BAC5010, Type 60	RTV 102	71984
A00803	Sealant - Firewall - Hydraulic Fluid Resistant	BMS5-63 Type I	Dapco 18-4	0V7G8
A01076	Adhesive - Synthetic Rubber	BAC5010, Type 93 (BMS5-95, Class B)		
A50096	Sealant - Firewall - Hydraulic Fluid Resistant	BMS5-63 Type II		

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Table 10: Cleaners, Polishes

Reference	Description	Specification	Material	Supplier
B00074	Solvent - Degreasing	MIL-PRF-680 (Supersedes P-D-680)		
B00083	Solvent - Aliphatic Naphtha (For Acrylic Plastics)	TT-N-95 Type II, ASTM D-3735 Type III		
B00130	Alcohol - Isopropyl	TT-I-735		
B00571	Coating - Clear Skydrol Resistant Topcoating	BAC5710, Type 41		

Table 11: Finishing Materials

Reference	Description	Specification	Material	Supplier
C00259	Coating - Chemical And Solvent Resistant Finish, Corrosion Inhibiting Primer	BMS10-11, Type I		
C00944	Primer - Firewall - Dapco No. 1-100	BMS5-63, Type I	Dapco No. 1-100	58093

Table 12: Lubricants (Oils, Greases, Dry Lubes)

Reference	Description	Specification	Material	Supplier
D00006	Compound - Antiseize Pure Nickel Special - Never-Seez NSBT-8N		Never-Seez NSBT-8N	5W425
D00054	Fluid - Hydraulic Assembly Lubricant - MCS 352B (Formerly Monsanto MCS 352B)		MCS 352B	1CHP6
D00068	Oil - Aircraft Turbine Engine, Synthetic Base	MIL-PRF-23699F, Class STD (Standard)		
D00071	Oil - Aircraft Turbine Engine, Synthetic Base	MIL-PRF-7808, Grade 3		
D00153	Fluid - Hydraulic Fluid, Fire Resistant (Interchangeable And Intermixable With BMS 3-11 Type V)	BMS3-11 Type IV		
D00173	Grease - Aircraft and Instrument, Fuel And Oxidizer Resistant	MIL-PRF-27617 (Supersedes MIL-G-27617)		
D00254	Compound - Silicone	SAE AS8660 (NATO S-736) (Supersedes MIL-S-8660)	DC-4	71984

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Reference	Description	Specification	Material	Supplier
D00276	Compound - Silicone (Novagard Silicones - G624)	SAE AS8660 (Supercedes MIL-S-8660)	G624	0609Y
D00504	Grease - Petrolatum	VV-P-236		
D00648	Lubricant - O-Ring - Syn-Tech NS-6074			
D50004	Compound - Antiseize	BMS 3-28	ARMITE LF-AS 328	81205

Table 13: Miscellaneous Materials

Reference	Description	Specification	Material	Supplier
G00251	Abrasive - Mat, Non-Woven, Non-Metallic	A-A-58054		
G01912	Lockwire - MS20995NC32, Monel - 0.032 Inch (0.8128 mm) Diameter	NASM20995		
G50043	Tubing - Fluoroelastomer, Tyco Electronics Viton-3/16-0-SP (Formerly Raychem RT-1146 Tubing)	AMS-DTL-23053/13	Viton-3/16-0-SP	06090
G50044	Sleeve - Ben-Har Viton 44, 3/16 inch, P/N 3800300503			
G50365	Agent - Peelable Parting (AC Products - AC962-73C) Production discontinued, use stock until depleted.		AC962-73C	77490
G50367	Agent - Peelable Parting (Aztec Chemical AZ 634-2)	MIL-PRF-6799, BAC 5000	AZ 634-2	0A3C8
G50368	Agent - Peelable Parting (Rexco Chemical Company - Partall Coverall Film)		Partall Film	17629
G50369	Coating - Alkaline Removable, Water Resistant	BMS 15-12, Type I, Class 1		
G50375	Kit - Safety Cable, 321 CRES - 0.032 Inch (0.81 mm) Diameter, (Contains both Cable and Ferrule)	BACC13AT3K, AMS 5689	BAC~ C13AT3K	70958
G51223	Marker - Permanent, Felt Tip Pen	Commercially Available		

Table 14: Lubricants (Oils, Greases, Dry Lubes) - CFM International

Reference	Engine Mfr Reference	Description	Specification	Material	Supplier
D00601	CP2101	Grease - Graphite, High Temperature	SAE AMS 2518		

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Reference	Engine Mfr Reference	Description	Specification	Material	Supplier
D00625	CP2338	Grease - Conductive - Brisal OX		Brisal OX	K0680

11. Tool Lists

Refer to the tables below for the complete applicability before you use a tool.

The tables that follow show all of the tools that are referred to in this manual.

There is a table for each type of tool. The data in each table is sorted by the GSE requirement identifier.

- The table for Standard Tools shows the standard tools.
- The table for Commercial Tools shows the tools that are commercially available.
- The table for Special Tools shows the tools that are manufactured for specific requirements.
- When there is a fourth table, it shows the airline-specific tools.

Table 15: Commercial Tools

Reference	Description	Part Number	Supplier	A/P Effectivity
COM-1443	Jack - Hydraulic, General Low Profile, Capacity: 2000 lbs, Lift: 10 to 44 Inches, or Equivalent Jack Capable of Lifting 300 lbs.	HW93718 Opt: W93718	28047 36251	737-600, -700, -700BC, -700BJ, -700C, -700ER, -700QC, -800, -800BJ, -900, -900BJ, -900ER 737-600, -700, -700BC, -700BJ, -700C, -700ER, -700QC, -800, -800BJ, -900, -900BJ, -900ER

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Reference	Description	Part Number	Supplier	A/P Effectivity
COM-1568	Jack - Hydraulic, General Low Profile	B67563	36251	737-600, -700, -700BC, -700BJ, -700C, -700ER, -700QC, -800, -800BJ, -900, -900BJ, -900ER
		HW93718	28047	737-600, -700, -700BC, -700BJ, -700C, -700ER, -700QC, -800, -800BJ, -900, -900BJ, -900ER
		Opt: W93718	36251	737-600, -700, -700BC, -700BJ, -700C, -700ER, -700QC, -800, -800BJ, -900, -900BJ, -900ER
COM-2060	Dolly - Nose Cowl, Removal/ Installation, CFM56-3 and -7 Engine	AGSE-T073-G03	9M323	737-600, -700, -700BC, -700BJ, -700C, -700ER, -700QC, -800, -800BJ, -900, -900BJ, -900ER

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Reference	Description	Part Number	Supplier	A/P Effectivity
		Opt: AM-1940-400	9M323	737-600, -700, -700BC, -700BJ, -700C, -700ER, -700QC, -800, -800BJ, -900, -900BJ, -900ER

Table 16: Special Tools

Reference	Description	Part Number	Supplier	A/P Effectivity
SPL-1634	Jack Adapter - VSCF and IDG	C24002-77	81205	737-600, -700, -700BC, -700BJ, -700C, -700ER, -700QC, -800, -800BJ, -900, -900BJ, -900ER

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Reference	Description	Part Number	Supplier	A/P Effectivity
SPL-2062	Sling - Inlet Cowl	B71040-39	81205	737-600, -700, -700BC, -700BJ, -700C, -700ER, -700QC, -800, -800BJ, -900, -900BJ, -900ER
		Opt: B71040-38	81205	737-600, -700, -700BC, -700BJ, -700C, -700ER, -700QC, -800, -800BJ, -900, -900BJ, -900ER
SPL-2107	Fixture - Lift, Engine Aft Mount	C71024-10	81205	737-600, -700, -700BC, -700BJ, -700C, -700ER, -700QC, -800, -800BJ, -900, -900BJ, -900ER
		Opt: C71024-1	81205	737-600, -700, -700BC, -700BJ, -700C, -700ER, -700QC, -800, -800BJ, -900, -900BJ, -900ER

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Reference	Description	Part Number	Supplier	A/P Effectivity
SPL-2165	Installation/Removal Frame Equipment - Inlet Cowl, CFM56-7 Engine	C71027-1	81205	737-600, -700, -700BC, -700BJ, -700C, -700ER, -700QC, -800, -800BJ, -900, -900BJ, -900ER
SPL-2419	Equipment - Handling, Primary Exhaust Sleeve and Plug	C78009-39	81205	737-600, -700, -700BC, -700BJ, -700C, -700ER, -700QC, -800, -800BJ, -900, -900BJ, -900ER
		Opt: C78009-38	81205	737-600, -700, -700BC, -700BJ, -700C, -700ER, -700QC, -800, -800BJ, -900, -900BJ, -900ER
SPL-2430	Hoist - Boom, Ground Based	C78026-259	81205	737-600, -700, -700BC, -700BJ, -700C, -700ER, -700QC, -800, -800BJ, -900, -900BJ, -900ER

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Reference	Description	Part Number	Supplier	A/P Effectivity
		Opt: C78026-161	81205	737-600, -700, -700BC, -700BJ, -700C, -700ER, -700QC, -800, -800BJ, -900, -900BJ, -900ER

12. Supplier List for Consumables and Tools

The table that follows lists all of the suppliers for the consumable materials and tools used in this manual.

The table is sorted by the CAGE code.

VENDOR CODES

Code	Name
00624	EATON CORPORATION DIV CONVEYANCE SYSTEM DBA AEROSPACE DIV 300 S EAST AVE JACKSON, MICHIGAN 49203-1972
02750	EATON AEROSPACE ENGINEERED SENSORS 15 DURANT AVENUE BETHEL, CONNECTICUT 06801-1901 FORMERLY CONSOLIDATED CONTROLS; FORMERLY EATON CORP PRESSURE SENSORS DIV
05228	PTI TECHNOLOGIES INC 501 DEL NORTE BLVD OXNARD, CALIFORNIA 93030-7983 FORMERLY PUROLATOR TECH; PTI TECH; TEXTRON FILTRATION SYS; FORMERLY IN NEWBURY PARK, CA
06090	TYCO ELECTRONICS CORPORATION (FORMALLY RAYCHEM CORP.) 300 CONSTITUTION DR. MENLO PARK, CA 94025-1164 Telephone: (650) 361-3333 Facsimile: (650) 361-5447

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Code	Name
0609Y	NOVAGARD SOLUTIONS 5109 HAMILTON AVENUE CLEVELAND, OH 44114 Telephone: 800-380-0138 Facsimile: 216-881-6977
07482	GENERAL ELECTRIC COMPANY DBA GE DIV GE - AVIATION 1 NEUMANN WAY CINCINNATI, OH 45215
08844	NORCO, INCORPORATED 139 ETHAN ALLEN HIGHWAY RIDGEFIELD, CONNECTICUT 06877
0A3C8	AZTEC CHEMICAL INCORPORATED 10770 LOWER AZUSA ROAD EL MONTE, CA 91733 Telephone: + 1-626-448-9262 Facsimile: + 1-626-448-9628
0V7G8	CYTEC INDUSTRIES INC 5 GARRET MOUNTAIN PLZ WOODLAND PARK, NJ 07424 Telephone: 973-357-3100
11362	PARKER-HANNIFIN CORPORATION DIV STRATOFLEX PRODUCTS DIVISION COUPLING BUSINESS UNIT DBA PARKER STRATOFLEX 3800 CALLE TECATE CAMARILLO, CA 93012
14242	VOSS INDUSTRIES INC 2168 WEST 25TH STREET CLEVELAND, OHIO 44113-4115
15284	EATON CORPORATION DIV CONVEYANCE SYSTEMS DIVISION DBA FLUID CONVEYANCE 11642 OLD BALTIMORE PIKE BELTSVILLE, MARYLAND 20705

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Code	Name
17629	REXCO CHEMICAL CO 879 DAVIS DR SE CONYERS, GA 30094-5963 Telephone: 770-483-7610 Facsimile: 700-483-8550
1CHP6	SOLUTIA INC. 575 MARYVILLE CENTRE DRIVE SAINT LOUIS, MO 63166-6760 Telephone: 314-674-3651 Facsimile: 314-674-1585
25693	WHITTAKER CORP WHITTAKER SAFETY SYSTEMS DIV 2731 SYSTRON DRIVE CONCORD, CALIFORNIA 94518-1355 FORMERLY IN BERKLEY, CALIF.; LINDBERG, JOHN E VB0124 FORMERLY SAFETY SYS DIV SYSTRON DONNER; SYSTRON-DONNER CORP
28047	HEIN-WERNER CORP. (SNAP-ON TOOLS) 2120 PEWAUKEE ROAD 2514 181st NE REDMOND, WA 98052 WAUKESHA, WI 53188-2404 Telephone: 414-542-6611 Facsimile: 414-464-4298
36251	MCNEIL OHIO CORP 1 LINCOLN WAY ST. LOUIS, MO 63120 Telephone: (314) 679-4200/ Facsimile: (314) 679-4380/4359
51563	ROHR INC FOOT OF H STREET PO BOX 878 CHULA VISTA, CALIFORNIA 92012
58093	CYTEC ENGINEERED MATERIALS INC. 1191 HAWK CIRCLE ANAHEIM, CA 92807 Telephone: 714-632-8444

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Code	Name
59364	HONEYWELL INTERNATIONAL INC DBA ENGINES & SYSTEMS DIV 1300 WEST WARNER ORAD M/S 1207-2W TEMPE, ARIZONA 85285-2986 FORMERLY IN PHOENIX, ARIZONA FORMERLY GARRETT PNEUMATIC SYSTEMS DIV OF GARRETT CORP
5W425	BOSTIK INC 211 BOSTON ST MIDDLETON, MA 01949 Telephone: 978-777-0100
60980	MEGGITT-OREGON INC DBA MEGGITT SILICONE PROD DIV MSP 2010 LAFAYETTE AVE P.O. BOX 887 MCMINNVILLE, OREGON 97128 FORMERLY ELASTOMERIC SILICON PRODUCTS
62983	EATON AEROSPACE LLC 5353 HIGHLAND DR JACKSON, MS 39206
70958	BERGEN CABLE TECHNOLOGIES INC 343 KAPLAN DRIVE FAIRFIELD, NJ 07004-2510 Telephone: 973-276-9596 Facsimile: 973-276-9566
71984	DOW CORNING CORPORATION P.O. BOX 994 / 2200 WEST SALZBURG ROAD MIDLAND, MI 48686-0994 Telephone: 1-989-496-4400 Facsimile: 1-989-496-6731
77490	AC PRODUCTS INCORPORATED (DIVISION OF QUAKER CHEMICAL CORPORATION) 172 EAST LA JOLLA STREET One Quaker Park, 901 Hector Street, Conshohocken, PA 19428-0809 PLACENTIA, CA 92870 Telephone: 714-630-7311 Facsimile: 714-666-8309

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Code	Name
78570	TITEFLEX CORP SUB OF BUNDY CORP 603 HENDEE STREET PO BOX 90054 SPRINGFIELD, MASSACHUSETTS 01139
78943	TRIUMPH THERMAL SYSTEMS INC 200 RAILROAD STREET FOREST, OHIO 45843-9193 FORMERLY UNITED AIRCRAFT PRODUCTS FORMERLY PARKER HANNIFIN CORP. UNITED AIRCRAFT PRODUCTS DIV.
81205	THE BOEING COMPANY 17930 INTERNATIONAL BLVD. SOUTH SEATAC, WA 98188-4321 Telephone: 206-662-6650 Facsimile: 206-662-7145
83930	ADEL WIGGINS GROUP 5000 TRIGGS STREET LOS ANGELES, CALIFORNIA 90022-4833 FORMERLY ADEL PROD DIV OF DELAVAL TURBINE CALIF INC; FORMERLY EXACTO IND V72285; FORMERLY DELAVAL ADEL FSTN DIV FORMERLY TRANSAMERICA DELAVAL ADEL FTNRS DIV; FORMERLY IMO DELAVAL IN HUNTINGTON, WV
84971	KIRKHILL-TA CO DIV TA AEROSPACE DBA TA DIVISION 28065 FRANKLIN PKWY VALENCIA, CA 91355
96941	UNISON INDUSTRIES LLC DBA ELANO DIV 2455 DAYTON-XENIA RD DAYTON, OH 45434
97393	SHUR-LOK COMPANY DBA SPS FASTENER DIVISION A PCC COMPANY DIV SPS FASTENER DIVISION 2541 WHITE RD IRVINE, CA 92614
98441	STRATOFLEX AEROSPACE MILITARY CONNECTOR DIV 220 ROBERTS CUT-OFF FT. WORTH, TEXAS 76114 FORMERLY STRATOFLEX INC; PARKER-HANNIFIN FLUID CONN GROUP; FORMERLY PARKER-HANNIFIN FLUID PWR DIV V82271

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Code	Name
99167	HAMILTON SUNDSTRAND CORPORATION 4747 HARRISON AVE ROCKFORD, IL 61108
99755	FMH INVESTOR GROUP 17072 DAIMLER STREET IRVINE, CALIFORNIA 92614-4541 FORMERLY FLEXIBLE METAL HOSE MFG CO
9M323	ADVANCED GROUND SYSTEMS ENGINEERING CORP (AGSE) 10805 PAINTER AVENUE SANTA FE SPRINGS, CA 90670 Telephone: (562) 906-9300 Facsimile: (562) 906-9308
K0680	ROLLS-ROYCE PLC MOOR LANE FOR 717 CONTACT 49-337-086-1479 DERBY, – DE24-8BJ Telephone: (44)1332-242424 Facsimile: (44) 1332-2499367

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FIGURE TITLE	LOCATION	
	SUBJECT	FIG
AFT ENGINE MOUNT INSTALLATION	71-00-02	3-1
BLEED CONTROL SYSTEM INSTALLATION - LOWER	71-00-02	15-1
BLEED CONTROL SYSTEM INSTALLATION - UPPER	71-00-02	17-1
BLEED CONTROLLER INSTALLATION	71-00-02	14-1
BLEED DUCT INSTALLATION - LOWER 5TH- AND 9TH-STAGE	71-00-02	16-1
BLEED DUCT INSTALLATION - UPPER 5TH- AND 9TH-STAGE	71-00-02	18-1
BRACKET INSTALLATION - LEFT SIDE CORE CASE	71-00-02	7-1
BRACKET INSTALLATION - LOWER LEFT FAN CASE	71-00-02	5-1
BRACKET INSTALLATION - RIGHT SIDE CORE CASE	71-00-02	8-1
BRACKET INSTALLATION - RIGHT SIDE FAN CASE	71-00-02	6-1
BRACKET INSTALLATION - UPPER LEFT FAN CASE	71-00-02	4-1
DRAINS INSTL - LEFT SIDE FAN CASE	71-00-02	9-1
DRAINS INSTL - RIGHT SIDE FAN CASE	71-00-02	10-1
FIRE/OVERHEAT DETECTOR INSTALLATION	71-00-02	28-1
FORWARD ENGINE MOUNT INSTALLATION	71-00-02	2-1
FUEL SUPPLY HOSE INSTALLATION	71-00-02	12-1
HYDRAULIC PLUMBING INSTALLATION	71-00-02	21-1
HYDRAULIC PUMP INSTALLATION (VICKERS)	71-00-02	20-1
IDG AIR/OIL COOLER INSTALLATION	71-00-02	23-1
IDG PLUMBING INSTALLATION	71-00-02	24-1
INLET COWL INSTALLATION	71-00-02	33-1
INLET COWL TAI SYSTEM INSTALLATION	71-00-02	27-1
INTEGRATED DRIVE GENERATOR INSTALLATION	71-00-02	22-1
MARKERS INSTALLATION	71-00-02	30-1
PRIMARY EXHAUST INSTALLATION	71-00-02	32-2
STARTER VALVE AND DUCT INSTALLATION	71-00-02	25-1

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FIGURE TITLE	LOCATION	
	SUBJECT	FIG
THRUST LINK INSTALLATION	71-00-02	31-1
W1062 WIRE BUNDLE INSTALLATION	71-00-02	29-1
12 O'CLOCK STRUT INSTALLATION	71-00-02	13-1

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PART NUMBER	AIRLINE PART NUMBER	LOCATION			QTY
		SUBJECT	FIG	ITEM	
AE713733-1		71-00-02	12-1	10	1
AM-1940-400		71-00-02	33-1	T2	-
AS1007T2020		71-00-02	20-1	55	1
AS1895-1-350		71-00-02	16-1	180	1
AS1895-1-350		71-00-02	16-1	210	1
AS1895-1-350		71-00-02	18-1	55	1
AS1895-1-350		71-00-02	18-1	110	1
AS1895-4-175		71-00-02	16-1	320	1
AS1895-4-175		71-00-02	27-1	260	1
AS1895-4-200		71-00-02	27-1	235	1
AS1895-4-200		71-00-02	27-1	305	1
AS1895-4-200		71-00-02	27-1	380	1
AS1895-4-200		71-00-02	33-1	100	-
AS1895-4-325		71-00-02	25-1	110	1
AS1895-4-350		71-00-02	16-1	260	1
AS1895-4-350		71-00-02	16-1	310	2
AS1895-4-400		71-00-02	14-1	120	1
AS1895-4-450		71-00-02	18-1	155	1
AS1895-7-175		71-00-02	16-1	315	1
AS1895-7-175		71-00-02	27-1	255	1
AS1895-7-200		71-00-02	27-1	230	1
AS1895-7-200		71-00-02	27-1	300	1
AS1895-7-200		71-00-02	27-1	375	1
AS1895-7-200		71-00-02	33-1	50	-
AS1895-7-300		71-00-02	25-1	180	1
AS1895-7-300		71-00-02	25-1	255	1
AS1895-7-300		71-00-02	25-1	300	1
AS1895-7-325		71-00-02	25-1	105	1
AS1895-7-350		71-00-02	16-1	175	1
AS1895-7-350		71-00-02	16-1	205	1
AS1895-7-350		71-00-02	16-1	255	1

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PART NUMBER	AIRLINE PART NUMBER	LOCATION			QTY
		SUBJECT	FIG	ITEM	
AS1895-7-350		71-00-02	16-1	305	2
AS1895-7-350		71-00-02	18-1	50	1
AS1895-7-350		71-00-02	18-1	105	1
AS1895-7-400		71-00-02	14-1	115	1
AS1895-7-450		71-00-02	18-1	150	1
AS1895/1-350		71-00-02	16-1	180	-
AS1895/1-350		71-00-02	16-1	210	-
AS1895/1-350		71-00-02	18-1	55	-
AS1895/1-350		71-00-02	18-1	110	-
AS1895/4-175		71-00-02	16-1	320	-
AS1895/4-175		71-00-02	27-1	260	-
AS1895/4-200		71-00-02	27-1	235	-
AS1895/4-200		71-00-02	27-1	305	-
AS1895/4-200		71-00-02	27-1	380	-
AS1895/4-200		71-00-02	33-1	100	-
AS1895/4-325		71-00-02	25-1	110	-
AS1895/4-350		71-00-02	16-1	260	-
AS1895/4-350		71-00-02	16-1	310	-
AS1895/4-400		71-00-02	14-1	120	-
AS1895/4-450		71-00-02	18-1	155	-
AS1895/7-175		71-00-02	16-1	315	-
AS1895/7-175		71-00-02	27-1	255	-
AS1895/7-200		71-00-02	27-1	230	-
AS1895/7-200		71-00-02	27-1	300	-
AS1895/7-200		71-00-02	27-1	375	-
AS1895/7-200		71-00-02	33-1	50	-
AS1895/7-300		71-00-02	25-1	180	-
AS1895/7-300		71-00-02	25-1	255	-
AS1895/7-300		71-00-02	25-1	300	-
AS1895/7-325		71-00-02	25-1	105	-
AS1895/7-350		71-00-02	16-1	175	-
AS1895/7-350		71-00-02	16-1	205	-

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PART NUMBER	AIRLINE PART NUMBER	LOCATION			QTY
		SUBJECT	FIG	ITEM	
AS1895/7-350		71-00-02	16-1	255	-
AS1895/7-350		71-00-02	16-1	305	-
AS1895/7-350		71-00-02	18-1	50	-
AS1895/7-350		71-00-02	18-1	105	-
AS1895/7-400		71-00-02	14-1	115	-
AS1895/7-450		71-00-02	18-1	150	-
AS3209-216		71-00-02	22-1	55	-
AS3485-09		71-00-02	14-1	110	4
AS3485-09		71-00-02	25-1	235	1
AS3485-09		71-00-02	27-1	360	1
AS3485-10		71-00-02	4-1	20	2
AS3485-10		71-00-02	4-1	90	2
AS3485-10		71-00-02	4-1	115	2
AS3485-10		71-00-02	4-1	290	2
AS3485-10		71-00-02	4-1	380	2
AS3485-10		71-00-02	4-1	415	2
AS3485-10		71-00-02	4-1	565	1
AS3485-10		71-00-02	4-1	610	2
AS3485-10		71-00-02	4-1	670	2
AS3485-10		71-00-02	4-1	720	2
AS3485-10		71-00-02	4-1	785	2
AS3485-10		71-00-02	4-1	815	2
AS3485-10		71-00-02	4-1	840	2
AS3485-10		71-00-02	5-1	20	3
AS3485-10		71-00-02	5-1	40	2
AS3485-10		71-00-02	5-1	165	2
AS3485-10		71-00-02	5-1	195	3
AS3485-10		71-00-02	5-1	215	3
AS3485-10		71-00-02	5-1	240	2
AS3485-10		71-00-02	5-1	265	2
AS3485-10		71-00-02	6-1	90	2
AS3485-10		71-00-02	6-1	140	2

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PART NUMBER	AIRLINE PART NUMBER	LOCATION			QTY
		SUBJECT	FIG	ITEM	
AS3485-10		71-00-02	6-1	190	1
AS3485-10		71-00-02	6-1	365	1
AS3485-10		71-00-02	6-1	425	2
AS3485-10		71-00-02	6-1	465	2
AS3485-10		71-00-02	7-1	185	3
AS3485-10		71-00-02	7-1	235	2
AS3485-10		71-00-02	7-1	310	2
AS3485-10		71-00-02	7-1	360	2
AS3485-10		71-00-02	8-1	35	1
AS3485-10		71-00-02	9-1	25	1
AS3485-10		71-00-02	9-1	45	1
AS3485-10		71-00-02	9-1	90	1
AS3485-10		71-00-02	9-1	120	1
AS3485-10		71-00-02	9-1	165	2
AS3485-10		71-00-02	9-1	260	2
AS3485-10		71-00-02	10-1	20	2
AS3485-10		71-00-02	10-1	45	2
AS3485-10		71-00-02	10-1	65	2
AS3485-10		71-00-02	10-1	95	1
AS3485-10		71-00-02	10-1	120	1
AS3485-10		71-00-02	10-1	145	2
AS3485-10		71-00-02	16-1	30	1
AS3485-10		71-00-02	16-1	65	1
AS3485-10		71-00-02	16-1	420	1
AS3485-10		71-00-02	16-1	470	1
AS3485-10		71-00-02	17-1	118	1
AS3485-10		71-00-02	21-1	155	1
AS3485-10		71-00-02	21-1	242	1
AS3485-10		71-00-02	24-1	165	2
AS3485-10		71-00-02	25-1	80	2
AS3485-10		71-00-02	25-1	145	2
AS3485-10		71-00-02	27-1	205	2

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PART NUMBER	AIRLINE PART NUMBER	LOCATION			QTY
		SUBJECT	FIG	ITEM	
AS3485-10		71-00-02	27-1	270	3
AS3485-10		71-00-02	27-1	340	2
AS3485-10		71-00-02	28-1	290	1
AS3485-10		71-00-02	29-1	35	4
AS3485-10		71-00-02	33-1	140	1
AS3485-10		71-00-02	33-1	265	1
AS3485-11		71-00-02	22-1	30	3
AS3485-11		71-00-02	22-1	110	1
AS3485-11		71-00-02	22-1	125	1
AS3485-12		71-00-02	5-1	300	1
AS3485-12		71-00-02	16-1	535	1
AS4138J0606		71-00-02	27-1	125	1
AS4138J0606		71-00-02	27-1	140	1
AS4138T0606		71-00-02	21-1	100	1
AS5169J06		71-00-02	18-1	35	1
AS5230J0606		71-00-02	27-1	130	1
AS5230T0606		71-00-02	20-1	80	1
AS5230T0606		71-00-02	21-1	30	1
AS5230T1212		71-00-02	20-1	10	1
A00027		71-00-02	4-1	C6	AR
A00027		71-00-02	27-1	C6	AR
A00803		71-00-02	4-1	C4	AR
A00803		71-00-02	13-1	C3	AR
A00803		71-00-02	27-1	C4	AR
A01076		71-00-02	4-1	C9	AR
A50096		71-00-02	4-1	C5	AR
A50096		71-00-02	13-1	C4	AR
A50096		71-00-02	27-1	C5	AR
BACB28AK03-027		71-00-02	4-1	885	1
BACB28AK04-030		71-00-02	16-1	55	1
BACB28AK04-030		71-00-02	16-1	410	1
BACB28AK04-030		71-00-02	16-1	460	1

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PART NUMBER	AIRLINE PART NUMBER	LOCATION			QTY
		SUBJECT	FIG	ITEM	
BACB28AK04-030		71-00-02	25-1	70	2
BACB28AK04-030		71-00-02	25-1	135	2
BACB28AK04-030		71-00-02	27-1	195	2
BACB28AK04-030		71-00-02	27-1	330	2
BACB28AK04-042		71-00-02	16-1	20	1
BACB28AK06-040		71-00-02	16-1	525	1
BACB28AK06-055		71-00-02	16-1	525	-
BACB28BA0608060		71-00-02	5-1	290	1
BACB30LE3U18		71-00-02	4-1	875	1
BACB30LE4HU1		71-00-02	7-1	30	1
BACB30LE4HU1		71-00-02	7-1	50	2
BACB30LE4HU2		71-00-02	7-1	31	1
BACB30LE4K12		71-00-02	5-1	180	3
BACB30LE4K4		71-00-02	13-1	215	2
BACB30LE4K6		71-00-02	5-1	135	2
BACB30LE4K6		71-00-02	13-1	210	-
BACB30LE4K6		71-00-02	13-1	210	2
BACB30LE4K8		71-00-02	13-1	215	-
BACB30LE5K14		71-00-02	22-1	100	1
BACB30LE5K8		71-00-02	22-1	20	3
BACB30LE5K8		71-00-02	22-1	115	1
BACB30LE5U6		71-00-02	4-1	955	2
BACB30LE5U6		71-00-02	6-1	230	2
BACB30LE6K14		71-00-02	5-1	280	1
BACB30LH3U4		71-00-02	14-1	105	4
BACB30LT4U2		71-00-02	32-2	30	-
BACB30NM4K11		71-00-02	4-1	395	2
BACB30NM4K3		71-00-02	4-1	455	1
BACB30NM4K5		71-00-02	4-1	630	1
BACB30NM4K6		71-00-02	5-1	30	2
BACB30NM4K6		71-00-02	21-1	145	1
BACB30NM4K7		71-00-02	4-1	655	2

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PART NUMBER	AIRLINE PART NUMBER	LOCATION			QTY
		SUBJECT	FIG	ITEM	
BACB30NM4K7		71-00-02	5-1	10	3
BACB30NM4K7		71-00-02	5-1	205	3
BACB30NM4K7		71-00-02	5-1	230	2
BACB30NN4K11		71-00-02	13-1	250	-
BACB30NN4K16		71-00-02	13-1	110	2
BACB30NN4K18		71-00-02	13-1	105	4
BACB30NN4K6		71-00-02	13-1	100	6
BACB30NN4K6		71-00-02	13-1	250	2
BACB30PN10-19		71-00-02	2-1	100	-
BACB30PN10-19M		71-00-02	2-1	100	4
BACB30PN14-32M		71-00-02	3-1	100	4
BACB30PN4-10		71-00-02	32-2	80	3
BACB30PN4-10		71-00-02	32-2	120	3
BACB30PN4-14		71-00-02	16-1	40	1
BACB30PN4-14		71-00-02	16-1	400	1
BACB30PN4-14		71-00-02	16-1	450	1
BACB30PN4-14		71-00-02	25-1	50	2
BACB30PN4-14		71-00-02	25-1	125	2
BACB30PN4-14		71-00-02	27-1	175	2
BACB30PN4-14		71-00-02	27-1	320	2
BACB30PN4-16		71-00-02	16-1	5	1
BACB30PN4-6		71-00-02	32-2	160	85
BACB30PN4H7		71-00-02	13-1	15	4
BACB30PN5H3		71-00-02	16-1	100	4
BACB30PN6C22		71-00-02	16-1	500	1
BACB30PN6C24		71-00-02	16-1	500	-
BACB30US4-10		71-00-02	32-2	80	-
BACB30US4-10		71-00-02	32-2	120	-
BACB30US4-6		71-00-02	32-2	160	-
BACB30US8K29		71-00-02	33-1	75	24
BACB30VF4K3		71-00-02	13-1	60	2
BACB30ZF3-06		71-00-02	25-1	225	1

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PART NUMBER	AIRLINE PART NUMBER	LOCATION			QTY
		SUBJECT	FIG	ITEM	
BACB30ZF3-06		71-00-02	27-1	350	1
BACB30ZF3-08		71-00-02	27-1	70	-
BACB30ZF3-08		71-00-02	27-1	70	2
BACB30ZF3-09		71-00-02	14-1	205	3
BACB30ZF3-10		71-00-02	14-1	200	1
BACB30ZF3-28		71-00-02	14-1	15	3
BACB30ZF4-05		71-00-02	15-1	40	2
BACB30ZF4-05		71-00-02	15-1	135	2
BACB30ZF4-05		71-00-02	17-1	240	2
BACB30ZF4-06		71-00-02	4-1	120	2
BACB30ZF4-06		71-00-02	4-1	365	-
BACB30ZF4-06		71-00-02	4-1	385	2
BACB30ZF4-06		71-00-02	4-1	615	2
BACB30ZF4-06		71-00-02	6-1	330	2
BACB30ZF4-06		71-00-02	7-1	105	5
BACB30ZF4-06		71-00-02	7-1	130	4
BACB30ZF4-06		71-00-02	7-1	280	2
BACB30ZF4-06		71-00-02	7-1	330	2
BACB30ZF4-06		71-00-02	8-1	130	2
BACB30ZF4-06		71-00-02	10-1	180	1
BACB30ZF4-06		71-00-02	21-1	130	1
BACB30ZF4-06		71-00-02	21-1	180	2
BACB30ZF4-06		71-00-02	24-1	60	1
BACB30ZF4-06		71-00-02	24-1	115	3
BACB30ZF4-06		71-00-02	24-1	160	2
BACB30ZF4-06		71-00-02	24-1	215	3
BACB30ZF4-06		71-00-02	28-1	25	4
BACB30ZF4-06		71-00-02	28-1	50	2
BACB30ZF4-06		71-00-02	28-1	55	1
BACB30ZF4-06		71-00-02	28-1	150	4
BACB30ZF4-06		71-00-02	28-1	175	8
BACB30ZF4-06		71-00-02	28-1	275	2

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PART NUMBER	AIRLINE PART NUMBER	LOCATION			QTY
		SUBJECT	FIG	ITEM	
BACB30ZF4-06		71-00-02	28-1	300	2
BACB30ZF4-06		71-00-02	28-1	302	2
BACB30ZF4-06		71-00-02	28-1	400	2
BACB30ZF4-06		71-00-02	28-1	425	1
BACB30ZF4-06		71-00-02	29-1	55	3
BACB30ZF4-07		71-00-02	5-1	335	-
BACB30ZF4-07		71-00-02	7-1	155	2
BACB30ZF4-07		71-00-02	7-1	205	3
BACB30ZF4-07		71-00-02	7-1	305	2
BACB30ZF4-07		71-00-02	7-1	355	2
BACB30ZF4-07		71-00-02	8-1	30	1
BACB30ZF4-07		71-00-02	10-1	40	1
BACB30ZF4-07		71-00-02	10-1	60	2
BACB30ZF4-07		71-00-02	10-1	85	1
BACB30ZF4-07		71-00-02	10-1	90	1
BACB30ZF4-07		71-00-02	12-1	55	4
BACB30ZF4-07		71-00-02	17-1	20	2
BACB30ZF4-07		71-00-02	17-1	106	2
BACB30ZF4-07		71-00-02	17-1	114	1
BACB30ZF4-07		71-00-02	24-1	170	-
BACB30ZF4-07		71-00-02	28-1	215	1
BACB30ZF4-07		71-00-02	28-1	250	4
BACB30ZF4-07		71-00-02	28-1	405	2
BACB30ZF4-07		71-00-02	29-1	60	1
BACB30ZF4-08		71-00-02	4-1	270	2
BACB30ZF4-08		71-00-02	4-1	395	-
BACB30ZF4-08		71-00-02	4-1	485	-
BACB30ZF4-08		71-00-02	4-1	770	2
BACB30ZF4-08		71-00-02	5-1	350	2
BACB30ZF4-08		71-00-02	7-1	230	2
BACB30ZF4-08		71-00-02	9-1	40	1
BACB30ZF4-08		71-00-02	9-1	85	1

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PART NUMBER	AIRLINE PART NUMBER	LOCATION			QTY
		SUBJECT	FIG	ITEM	
BACB30ZF4-08		71-00-02	9-1	110	1
BACB30ZF4-08		71-00-02	9-1	160	3
BACB30ZF4-08		71-00-02	9-1	255	3
BACB30ZF4-08		71-00-02	10-1	15	2
BACB30ZF4-08		71-00-02	10-1	35	1
BACB30ZF4-08		71-00-02	10-1	115	1
BACB30ZF4-08		71-00-02	13-1	155	2
BACB30ZF4-08		71-00-02	14-1	280	4
BACB30ZF4-08		71-00-02	21-1	190	2
BACB30ZF4-08		71-00-02	21-1	240	5
BACB30ZF4-08		71-00-02	21-1	275	3
BACB30ZF4-08		71-00-02	21-1	315	-
BACB30ZF4-08		71-00-02	21-1	315	2
BACB30ZF4-08		71-00-02	21-1	330	4
BACB30ZF4-08		71-00-02	24-1	1	-
BACB30ZF4-08		71-00-02	24-1	161	2
BACB30ZF4-08		71-00-02	27-1	105	-
BACB30ZF4-08		71-00-02	28-1	276	1
BACB30ZF4-08		71-00-02	28-1	301	1
BACB30ZF4-08		71-00-02	29-1	30	4
BACB30ZF4-08		71-00-02	33-1	125	4
BACB30ZF4-09		71-00-02	8-1	10	1
BACB30ZF4-09		71-00-02	9-1	20	1
BACB30ZF4-10		71-00-02	5-1	105	2
BACB30ZF4-10		71-00-02	7-1	180	-
BACB30ZF4-10		71-00-02	10-1	135	2
BACB30ZF4-10		71-00-02	21-1	241	1
BACB30ZF4-10		71-00-02	21-1	280	1
BACB30ZF4-10		71-00-02	23-1	15	8
BACB30ZF4-10		71-00-02	27-1	10	1
BACB30ZF4-10		71-00-02	27-1	265	3
BACB30ZF4-11		71-00-02	5-1	85	2

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PART NUMBER	AIRLINE PART NUMBER	LOCATION			QTY
		SUBJECT	FIG	ITEM	
BACB30ZF4-11		71-00-02	5-1	155	2
BACB30ZF4-12		71-00-02	4-1	10	2
BACB30ZF4-12		71-00-02	4-1	80	2
BACB30ZF4-12		71-00-02	4-1	105	2
BACB30ZF4-12		71-00-02	4-1	155	2
BACB30ZF4-12		71-00-02	4-1	510	1
BACB30ZF4-12		71-00-02	4-1	805	2
BACB30ZF4-12		71-00-02	5-1	255	2
BACB30ZF4-12		71-00-02	6-1	455	2
BACB30ZF4-12		71-00-02	7-1	180	3
BACB30ZF4-12		71-00-02	21-1	355	2
BACB30ZF4-14		71-00-02	4-1	370	2
BACB30ZF4-14		71-00-02	4-1	765	1
BACB30ZF4-14		71-00-02	4-1	830	2
BACB30ZF4-14		71-00-02	6-1	80	2
BACB30ZF4-14		71-00-02	6-1	130	2
BACB30ZF4-14		71-00-02	6-1	180	1
BACB30ZF4-14		71-00-02	6-1	355	1
BACB30ZF4-14		71-00-02	12-1	15	4
BACB30ZF4-16		71-00-02	4-1	555	1
BACB30ZF4-16		71-00-02	4-1	760	1
BACB30ZF4-24		71-00-02	6-1	415	2
BACB30ZF4-24		71-00-02	29-1	10	2
BACB30ZF4-26		71-00-02	4-1	265	1
BACB30ZF4-26		71-00-02	4-1	405	2
BACB30ZF4-26		71-00-02	4-1	605	2
BACB30ZF4-29		71-00-02	4-1	260	1
BACB30ZF4-32		71-00-02	21-1	50	3
BACB30ZF4-34		71-00-02	4-1	710	2
BACC10GF24CT		71-00-02	27-1	50	1
BACC10GT2-04		71-00-02	15-1	30	4
BACC10GT2-04		71-00-02	15-1	125	4

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PART NUMBER	AIRLINE PART NUMBER	LOCATION			QTY
		SUBJECT	FIG	ITEM	
BACC10GT2-04		71-00-02	17-1	15	4
BACC10GT2-04		71-00-02	17-1	104	4
BACC10GT2-04		71-00-02	17-1	112	4
BACC10GT2-04		71-00-02	17-1	235	4
BACC10GT2-06		71-00-02	9-1	35	4
BACC10GT2-08		71-00-02	28-1	65	-
BACC10GT2-08		71-00-02	28-1	185	-
BACC10GT2-08		71-00-02	28-1	285	-
BACC10GT2-08		71-00-02	28-1	310	-
BACC10GT2-08		71-00-02	28-1	435	-
BACC10JB034C064		71-00-02	33-1	105	1
BACC14AD04J		71-00-02	25-1	200	-
BACJ40AC54-7		71-00-02	4-1	500	1
BACJ40AC54-9		71-00-02	27-1	5	1
BACM10L1EBZ		71-00-02	30-1	5	1
BACM10L1EBZ		71-00-02	30-1	35	1
BACN10HR4C		71-00-02	32-2	110	3
BACN10HR4C		71-00-02	32-2	150	3
BACN10HR4C		71-00-02	32-2	180	85
BACN10HR5CS		71-00-02	22-1	30	-
BACN10HR5CS		71-00-02	22-1	110	-
BACN10HR5CS		71-00-02	22-1	125	-
BACN10HR8C		71-00-02	32-2	60	16
BACN10HR8CS		71-00-02	33-1	90	24
BACN10HY6AC		71-00-02	20-1	120	6
BACN10JC3C		71-00-02	28-1	105	-
BACN10JC3C		71-00-02	28-1	205	-
BACN10JC3C		71-00-02	28-1	355	-
BACN10JC3C		71-00-02	28-1	455	-
BACN10JC8CM		71-00-02	2-1	85	3
BACN10JC8CM		71-00-02	31-1	40	2
BACN10JC8CM		71-00-02	31-1	65	2

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PART NUMBER	AIRLINE PART NUMBER	LOCATION			QTY
		SUBJECT	FIG	ITEM	
BACN10YR3C		71-00-02	28-1	105	-
BACN10YR3C		71-00-02	28-1	205	-
BACN10YR3C		71-00-02	28-1	355	-
BACN10YR3C		71-00-02	28-1	455	-
BACN10YR4CD		71-00-02	4-1	525	1
BACN10YR4CD		71-00-02	27-1	20	1
BACN10YR4CM		71-00-02	28-1	120	1
BACN10YR4CM		71-00-02	33-1	15	2
BACN11Z3CK		71-00-02	4-1	900	1
BACN11Z4CK		71-00-02	6-1	40	1
BACN11Z4CK		71-00-02	6-1	210	1
BACN11Z4CK		71-00-02	13-1	70	2
BACN11Z4CK		71-00-02	13-1	120	6
BACN11Z4CK		71-00-02	13-1	270	2
BACN11Z8C		71-00-02	3-1	35	2
BACN11Z8C		71-00-02	3-1	65	2
BACP18BC03B06P		71-00-02	2-1	87	3
BACP18BC03B06P		71-00-02	3-1	40	-
BACP18BC03B06P		71-00-02	3-1	70	2
BACP18BC03B06P		71-00-02	31-1	42	2
BACP18BC03B06P		71-00-02	31-1	67	2
BACP18BC03B07P		71-00-02	2-1	87	-
BACP18BC03B07P		71-00-02	3-1	40	2
BACP18BC03B07P		71-00-02	3-1	70	-
BACP18BC03B07P		71-00-02	31-1	42	-
BACP18BC03B07P		71-00-02	31-1	67	-
BACP18BC03B08P		71-00-02	2-1	87	-
BACP18BC03B08P		71-00-02	3-1	40	-
BACP18BC03B08P		71-00-02	3-1	70	-
BACP18BC03B08P		71-00-02	31-1	42	-
BACP18BC03B08P		71-00-02	31-1	67	-
BACS12HN4U12		71-00-02	4-1	50	1

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PART NUMBER	AIRLINE PART NUMBER	LOCATION			QTY
		SUBJECT	FIG	ITEM	
BACS18K25-39W		71-00-02	5-1	380	2
BACS18K25-45W		71-00-02	6-1	405	2
BACV10CE12		71-00-02	21-1	15	1
BACW10BN6UC		71-00-02	16-1	520	1
BACW10BP10ACU		71-00-02	2-1	105	4
BACW10BP12ACU		71-00-02	31-1	30	2
BACW10BP12ACU		71-00-02	31-1	55	2
BACW10BP14ACU		71-00-02	3-1	105	4
BACW10BP3ACU		71-00-02	4-1	880	1
BACW10BP4ACU		71-00-02	4-1	560	1
BACW10BP4ACU		71-00-02	4-1	635	1
BACW10BP4ACU		71-00-02	4-1	660	2
BACW10BP4ACU		71-00-02	4-1	780	1
BACW10BP4ACU		71-00-02	5-1	15	3
BACW10BP4ACU		71-00-02	5-1	35	2
BACW10BP4ACU		71-00-02	5-1	140	2
BACW10BP4ACU		71-00-02	5-1	185	3
BACW10BP4ACU		71-00-02	5-1	210	3
BACW10BP4ACU		71-00-02	5-1	235	2
BACW10BP4ACU		71-00-02	7-1	35	2
BACW10BP4ACU		71-00-02	7-1	60	2
BACW10BP4ACU		71-00-02	13-1	17	4
BACW10BP4ACU		71-00-02	16-1	15	1
BACW10BP4ACU		71-00-02	16-1	50	1
BACW10BP4ACU		71-00-02	16-1	405	1
BACW10BP4ACU		71-00-02	16-1	455	1
BACW10BP4ACU		71-00-02	21-1	150	1
BACW10BP4ACU		71-00-02	25-1	60	2
BACW10BP4ACU		71-00-02	25-1	130	2
BACW10BP4ACU		71-00-02	27-1	190	2
BACW10BP4ACU		71-00-02	27-1	325	2
BACW10BP4ACU		71-00-02	32-2	100	3

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PART NUMBER	AIRLINE PART NUMBER	LOCATION			QTY
		SUBJECT	FIG	ITEM	
BACW10BP4ACU		71-00-02	32-2	140	3
BACW10BP4ACU		71-00-02	32-2	170	77
BACW10BP4APU		71-00-02	4-1	60	2
BACW10BP4CD		71-00-02	5-1	140	-
BACW10BP4CD		71-00-02	27-1	190	-
BACW10BP4PK		71-00-02	13-1	65	2
BACW10BP4PK		71-00-02	13-1	115	6
BACW10BP4PK		71-00-02	13-1	265	2
BACW10BP5ACU		71-00-02	4-1	960	2
BACW10BP5ACU		71-00-02	6-1	235	2
BACW10BP5ACU		71-00-02	16-1	115	4
BACW10BP5ACU		71-00-02	22-1	25	3
BACW10BP5ACU		71-00-02	22-1	105	1
BACW10BP5ACU		71-00-02	22-1	120	1
BACW10BP5APU		71-00-02	22-1	106	1
BACW10BP5CD		71-00-02	22-1	25	-
BACW10BP5CD		71-00-02	22-1	105	-
BACW10BP5CD		71-00-02	22-1	120	-
BACW10BP6ACU		71-00-02	5-1	285	1
BACW10BP8ACU		71-00-02	2-1	25	10
BACW10BP8ACU		71-00-02	33-1	85	24
BACW10BP8APU		71-00-02	32-2	50	16
BACW10EC4M		71-00-02	4-1	55	1
BACW10P393CB		71-00-02	4-1	15	2
BACW10P393CB		71-00-02	4-1	85	2
BACW10P393CB		71-00-02	4-1	110	2
BACW10P393CB		71-00-02	4-1	160	2
BACW10P393CB		71-00-02	4-1	287	1
BACW10P393CB		71-00-02	4-1	375	2
BACW10P393CB		71-00-02	4-1	410	2
BACW10P393CB		71-00-02	4-1	512	1
BACW10P393CB		71-00-02	4-1	562	1

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PART NUMBER	AIRLINE PART NUMBER	LOCATION			QTY
		SUBJECT	FIG	ITEM	
BACW10P393CB		71-00-02	4-1	607	2
BACW10P393CB		71-00-02	4-1	775	3
BACW10P393CB		71-00-02	4-1	810	2
BACW10P393CB		71-00-02	4-1	835	2
BACW10P393CB		71-00-02	5-1	90	2
BACW10P393CB		71-00-02	5-1	110	2
BACW10P393CB		71-00-02	5-1	160	2
BACW10P393CB		71-00-02	5-1	190	3
BACW10P393CB		71-00-02	5-1	237	2
BACW10P393CB		71-00-02	5-1	260	4
BACW10P393CB		71-00-02	6-1	87	2
BACW10P393CB		71-00-02	6-1	135	4
BACW10P393CB		71-00-02	6-1	185	2
BACW10P393CB		71-00-02	6-1	362	1
BACW10P393CB		71-00-02	6-1	420	1
BACW10P393CB		71-00-02	6-1	460	2
BAC27DHY0337		71-00-02	30-1	25	1
BAC27DPP470		71-00-02	30-1	15	1
B00083		71-00-02	28-1	C1	AR
B00083		71-00-02	30-1	C1	AR
B00130		71-00-02	4-1	C2	AR
B00130		71-00-02	5-1	C1	AR
B00130		71-00-02	6-1	C1	AR
B00130		71-00-02	7-1	C1	AR
B00130		71-00-02	8-1	C1	AR
B00130		71-00-02	14-1	C1	AR
B00130		71-00-02	27-1	C2	AR
B00571		71-00-02	30-1	C2	AR
B700-2		71-00-02	10-1	100	1
B71040		71-00-02	33-1	T1	-
C00259		71-00-02	4-1	C8	AR
C00944		71-00-02	4-1	C3	AR

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PART NUMBER	AIRLINE PART NUMBER	LOCATION			QTY
		SUBJECT	FIG	ITEM	
C00944		71-00-02	13-1	C2	AR
C00944		71-00-02	27-1	C3	AR
C24002		71-00-02	22-1	T1	-
C71024-1		71-00-02	3-1	T1	-
C71027		71-00-02	33-1	T3	-
C78009		71-00-02	32-2	T1	-
C78026		71-00-02	33-1	T4	-
D00006		71-00-02	2-1	C1	AR
D00006		71-00-02	3-1	C1	AR
D00006		71-00-02	7-1	C2	AR
D00006		71-00-02	9-1	C6	AR
D00006		71-00-02	10-1	C6	AR
D00006		71-00-02	12-1	C2	AR
D00006		71-00-02	13-1	C1	AR
D00006		71-00-02	14-1	C2	AR
D00006		71-00-02	15-1	C1	AR
D00006		71-00-02	16-1	C1	AR
D00006		71-00-02	17-1	C1	AR
D00006		71-00-02	18-1	C1	AR
D00006		71-00-02	22-1	C5	AR
D00006		71-00-02	23-1	C1	AR
D00006		71-00-02	24-1	C1	AR
D00006		71-00-02	25-1	C1	AR
D00006		71-00-02	27-1	C7	AR
D00006		71-00-02	28-1	C2	AR
D00006		71-00-02	29-1	C1	AR
D00006		71-00-02	31-1	C1	AR
D00006		71-00-02	32-2	C1	AR
D00054		71-00-02	20-1	C1	AR
D00054		71-00-02	21-1	C1	AR
D00068		71-00-02	22-1	C3	AR
D00071		71-00-02	22-1	C2	AR

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PART NUMBER	AIRLINE PART NUMBER	LOCATION			QTY
		SUBJECT	FIG	ITEM	
D00153		71-00-02	20-1	C2	AR
D00173		71-00-02	21-1	C2	AR
D00254		71-00-02	20-1	C4	AR
D00254		71-00-02	22-1	C4	AR
D00276		71-00-02	20-1	C3	AR
D00504		71-00-02	9-1	C1	AR
D00504		71-00-02	10-1	C1	AR
D00504		71-00-02	12-1	C1	AR
D00601		71-00-02	33-1	C1	AR
D00625		71-00-02	33-1	C1	AR
D00648		71-00-02	22-1	C1	AR
D50004		71-00-02	4-1	C7	AR
D50004		71-00-02	5-1	C2	AR
D50004		71-00-02	6-1	C6	AR
G00251		71-00-02	27-1	C1	AR
G01912		71-00-02	2-1	C2	AR
G01912		71-00-02	7-1	C4	AR
G01912		71-00-02	13-1	C7	AR
G01912		71-00-02	16-1	C2	AR
G01912		71-00-02	22-1	C7	AR
G01912		71-00-02	25-1	C2	AR
G01912		71-00-02	27-1	C8	AR
G50043		71-00-02	2-1	C4	AR
G50044		71-00-02	2-1	C5	-
G50365		71-00-02	13-1	C5	AR
G50367		71-00-02	13-1	C8	AR
G50368		71-00-02	13-1	C9	AR
G50369		71-00-02	13-1	C10	AR
G50375		71-00-02	2-1	C3	1
G50375		71-00-02	7-1	C3	3
G50375		71-00-02	13-1	C6	AR
G50375		71-00-02	16-1	C3	1

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PART NUMBER	AIRLINE PART NUMBER	LOCATION			QTY
		SUBJECT	FIG	ITEM	
G50375		71-00-02	16-1	C3	2
G50375		71-00-02	22-1	C6	1
G50375		71-00-02	25-1	C3	2
G50375		71-00-02	27-1	C9	2
G51223		71-00-02	4-1	C1	AR
HW93718		71-00-02	22-1	T2	-
HW93718		71-00-02	32-2	T2	-
J1221G06		71-00-02	9-1	15	1
J1221G06		71-00-02	9-1	30	2
J1221G06		71-00-02	9-1	80	2
J1221G06		71-00-02	9-1	105	1
J1221G06		71-00-02	9-1	155	3
J1221G06		71-00-02	9-1	250	3
J1221G06		71-00-02	10-1	110	1
J1221G06		71-00-02	10-1	130	3
J1221G06		71-00-02	10-1	175	1
J1221G06		71-00-02	21-1	125	1
J1221G06		71-00-02	21-1	140	1
J1221G06		71-00-02	21-1	175	2
J1221G08		71-00-02	10-1	10	2
J1221G08		71-00-02	10-1	30	2
J1221G08		71-00-02	10-1	55	2
J1221G08		71-00-02	10-1	80	2
J1221G10		71-00-02	24-1	55	1
J1221G10		71-00-02	24-1	110	3
J1221G12		71-00-02	24-1	155	4
J1221G12		71-00-02	24-1	210	3
J1221G28		71-00-02	21-1	310	-
J1221G28		71-00-02	21-1	310	2
J1238P54		71-00-02	14-1	30	1
J1238P54		71-00-02	15-1	155	1
J522P52		71-00-02	14-1	160	2

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PART NUMBER	AIRLINE PART NUMBER	LOCATION			QTY
		SUBJECT	FIG	ITEM	
J522P52		71-00-02	14-1	260	1
J522P52		71-00-02	16-1	155	1
J522P52		71-00-02	18-1	15	1
J522P53		71-00-02	14-1	85	2
J522P53		71-00-02	14-1	170	1
J522P53		71-00-02	14-1	270	1
J522P53		71-00-02	17-1	175	1
J522P53		71-00-02	18-1	25	1
MS21914-4J		71-00-02	25-1	200	-
MS27198-24		71-00-02	12-1	5	1
MS35650-3254		71-00-02	4-1	65	1
M83248-1-216		71-00-02	22-1	55	-
NAS1057T3-050		71-00-02	14-1	10	3
NAS1057W4A-064		71-00-02	4-1	275	-
NAS1057W4A-080		71-00-02	4-1	280	-
NAS1057W4A025		71-00-02	13-1	220	-
NAS1057W4A025		71-00-02	13-1	255	-
NAS1149C0316R		71-00-02	25-1	230	1
NAS1149C0316R		71-00-02	27-1	355	1
NAS1149C0316R		71-00-02	28-1	100	2
NAS1149C0316R		71-00-02	28-1	200	2
NAS1149C0316R		71-00-02	28-1	350	2
NAS1149C0316R		71-00-02	28-1	450	2
NAS1149C0332R		71-00-02	28-1	100	-
NAS1149C0332R		71-00-02	28-1	200	-
NAS1149C0332R		71-00-02	28-1	350	-
NAS1149C0332R		71-00-02	28-1	450	-
NAS1149C0363R		71-00-02	27-1	75	-
NAS1149C0416R		71-00-02	13-1	20	AR
NAS1149C0432R		71-00-02	4-1	285	1
NAS1149C0432R		71-00-02	4-1	397	2
NAS1149C0432R		71-00-02	4-1	460	1

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PART NUMBER	AIRLINE PART NUMBER	LOCATION			QTY
		SUBJECT	FIG	ITEM	
NAS1149C0432R		71-00-02	4-1	715	2
NAS1149C0432R		71-00-02	6-1	35	1
NAS1149C0432R		71-00-02	6-1	85	2
NAS1149C0432R		71-00-02	6-1	205	1
NAS1149C0432R		71-00-02	6-1	360	1
NAS1149C0432R		71-00-02	8-1	15	1
NAS1149C0432R		71-00-02	10-1	140	2
NAS1149C0432R		71-00-02	13-1	20	AR
NAS1149C0432R		71-00-02	16-1	25	1
NAS1149C0432R		71-00-02	16-1	60	1
NAS1149C0432R		71-00-02	16-1	415	1
NAS1149C0432R		71-00-02	16-1	465	1
NAS1149C0432R		71-00-02	17-1	116	1
NAS1149C0432R		71-00-02	21-1	55	3
NAS1149C0432R		71-00-02	25-1	75	2
NAS1149C0432R		71-00-02	25-1	140	2
NAS1149C0432R		71-00-02	27-1	200	2
NAS1149C0432R		71-00-02	27-1	335	2
NAS1149C0432R		71-00-02	28-1	115	1
NAS1149C0432R		71-00-02	28-1	220	1
NAS1149C0463R		71-00-02	23-1	20	8
NAS1149C0632R		71-00-02	5-1	295	1
NAS1149D0416H		71-00-02	4-1	515	2
NAS1149D0416H		71-00-02	4-1	665	2
NAS1149D0416H		71-00-02	27-1	15	3
NAS1149E0332R		71-00-02	4-1	895	1
NAS1149E0432P		71-00-02	9-1	115	1
NAS1149E0432P		71-00-02	33-1	10	2
NAS1149E0432R		71-00-02	33-1	130	4
NAS1149E0432R		71-00-02	33-1	135	1
NAS1149E0432R		71-00-02	33-1	255	1
NAS1149E0516P		71-00-02	22-1	27	2

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PART NUMBER	AIRLINE PART NUMBER	LOCATION			QTY
		SUBJECT	FIG	ITEM	
NAS1149E0516P		71-00-02	22-1	122	1
NAS1149E0532P		71-00-02	22-1	26	4
NAS1149E0532P		71-00-02	22-1	121	1
NAS1149E0563R		71-00-02	22-1	28	3
NAS1149E0563R		71-00-02	22-1	107	1
NAS1149E0563R		71-00-02	22-1	123	1
NAS1149E0616R		71-00-02	16-1	505	4
NAS1149E0632R		71-00-02	16-1	530	1
NAS1611-024A		71-00-02	21-1	301	-
NAS1611-153A		71-00-02	20-1	100	-
NAS1612-12A		71-00-02	20-1	5	1
NAS1612-20A		71-00-02	20-1	50	1
NAS1612-6A		71-00-02	20-1	75	1
NAS1612-6A		71-00-02	21-1	10	1
NAS1612-6A		71-00-02	21-1	25	1
RC2769-1		71-00-02	4-1	890	1
RP235-00		71-00-02	33-1	200	-
SL4147CA10A		71-00-02	2-1	110	4
SL4147CA14EBSP1		71-00-02	3-1	110	4
TA025146-15		71-00-02	29-1	25	5
TA025146-15		71-00-02	29-1	50	4
TA0910064-06		71-00-02	21-1	185	1
TA0910083		71-00-02	21-1	325	2
TA0910083		71-00-02	21-1	350	1
TA0910091H1		71-00-02	12-1	50	2
UA538551-3		71-00-02	23-1	5	1
U542648		71-00-02	23-1	10	-
VR1030-300		71-00-02	25-1	185	-
VR1030-300		71-00-02	25-1	260	-
VR1030-300		71-00-02	25-1	305	-
X-310A		71-00-02	30-1	-	-
0646C624-18		71-00-02	22-1	90	-

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PART NUMBER	AIRLINE PART NUMBER	LOCATION			QTY
		SUBJECT	FIG	ITEM	
107484-7		71-00-02	14-1	150	1
107492-6		71-00-02	14-1	250	1
115096-2		71-00-02	24-1	200	1
115096-4		71-00-02	24-1	100	1
11777-08		71-00-02	28-1	60	3
11777-08		71-00-02	28-1	180	8
11777-08		71-00-02	28-1	280	3
11777-08		71-00-02	28-1	305	5
11777-08		71-00-02	28-1	430	1
155006-06-16		71-00-02	21-1	200	1
155006-06-23		71-00-02	21-1	75	1
155012-12-21		71-00-02	21-1	225	1
155012-73-20		71-00-02	20-1	20	1
155016-20-11		71-00-02	21-1	300	-
155016-20-11		71-00-02	21-1	300	1
16135-80		71-00-02	17-1	50	1
16135-80		71-00-02	17-1	275	1
16135-81		71-00-02	17-1	125	1
16135-83		71-00-02	17-1	75	-
16135-84		71-00-02	15-1	175	1
16135-96		71-00-02	17-1	75	1
1794M49P01		71-00-02	15-1	35	2
1794M49P01		71-00-02	15-1	130	2
1794M49P01		71-00-02	17-1	10	2
1794M49P01		71-00-02	17-1	102	2
1794M49P01		71-00-02	17-1	110	2
1794M49P01		71-00-02	17-1	230	2
21SN41-52		71-00-02	27-1	60	-
21SN41-52		71-00-02	27-1	60	1
286A1062-002		71-00-02	29-1	5	1
30645-300		71-00-02	25-1	185	1
30645-300		71-00-02	25-1	260	1

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PART NUMBER	AIRLINE PART NUMBER	LOCATION			QTY
		SUBJECT	FIG	ITEM	
30645-300		71-00-02	25-1	305	1
310A2020-12		71-00-02	2-1	15	1
310A2020-6		71-00-02	2-1	20	2
310A2021-6		71-00-02	2-1	50	1
310A2029-11		71-00-02	2-1	5	8
310A2029-19		71-00-02	2-1	10	2
310A2030-19		71-00-02	3-1	5	1
310A2037-14		71-00-02	3-1	25	2
310A2037-15		71-00-02	3-1	50	1
310A2037-16		71-00-02	3-1	55	1
310A2039-1		71-00-02	3-1	30	2
310A2039-2		71-00-02	3-1	60	2
310A2040-7		71-00-02	2-1	78	2
310A2040-7		71-00-02	31-1	32	1
310A2040-7		71-00-02	31-1	57	1
310A2041-10		71-00-02	31-1	10	1
310A2041-9		71-00-02	31-1	5	1
310A2042-3		71-00-02	2-1	75	3
310A2042-3		71-00-02	31-1	25	2
310A2042-3		71-00-02	31-1	50	2
310A2043-2		71-00-02	2-1	80	3
310A2043-2		71-00-02	31-1	35	2
310A2043-2		71-00-02	31-1	60	2
314-2100-2		71-00-02	33-1	25	-
314-2100-3		71-00-02	33-1	25	-
314-2100-4		71-00-02	33-1	25	1
314A2630-103		71-00-02	32-2	70	1
314A2640-100		71-00-02	32-2	10	-
314A2640-100		71-00-02	32-2	10	1
314A2640-17		71-00-02	32-2	40	-
314A2640-34		71-00-02	32-2	20	-
314T3019-3		71-00-02	33-1	5	2

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PART NUMBER	AIRLINE PART NUMBER	LOCATION			QTY
		SUBJECT	FIG	ITEM	
315A2080-1		71-00-02	13-1	72	-
315A2080-4		71-00-02	13-1	72	1
315A2081-5		71-00-02	13-1	80	-
315A2083-1		71-00-02	13-1	75	-
3202222-1		71-00-02	16-1	250	1
320548-2		71-00-02	14-1	5	1
3214446-4		71-00-02	16-1	150	1
3214552-6		71-00-02	18-1	5	1
3215618-4		71-00-02	27-1	225	-
3215618-5		71-00-02	27-1	225	-
3215618-6		71-00-02	27-1	225	1
322U2338-2		71-00-02	25-1	55	2
3289562-5		71-00-02	14-1	75	1
3289562-7		71-00-02	14-1	75	-
3289630-2		71-00-02	25-1	175	1
332A1325-1		71-00-02	27-1	55	-
332A1325-1		71-00-02	27-1	55	1
332A2240-1		71-00-02	24-1	50	1
332A2240-10		71-00-02	24-1	5	1
332A2240-11		71-00-02	24-1	150	1
332A2310-4		71-00-02	25-1	250	1
332A2313-1		71-00-02	25-1	100	1
332A2321-10		71-00-02	16-1	200	1
332A2322-54		71-00-02	16-1	300	1
332A2323-14		71-00-02	16-1	105	1
332A2326-45		71-00-02	18-1	100	1
332A2341-2		71-00-02	27-1	185	1
332A2341-3		71-00-02	27-1	180	1
332A2341-4		71-00-02	16-1	10	1
332A2341-5		71-00-02	16-1	45	1
332A2350-1		71-00-02	27-1	145	1
332A2350-11		71-00-02	15-1	55	1

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PART NUMBER	AIRLINE PART NUMBER	LOCATION			QTY
		SUBJECT	FIG	ITEM	
332A2350-12		71-00-02	17-1	200	1
332A2350-13		71-00-02	17-1	225	1
332A2350-14		71-00-02	17-1	150	1
332A2350-4		71-00-02	15-1	100	1
332A2350-5		71-00-02	17-1	5	1
332A2350-7		71-00-02	17-1	100	1
332A2350-9		71-00-02	15-1	5	1
332A2371-3		71-00-02	13-1	5	-
332A2371-4		71-00-02	13-1	5	1
332A2372-3		71-00-02	13-1	50	1
332A2372-4		71-00-02	13-1	55	1
332A2373-1		71-00-02	13-1	30	AR
332A2373-2		71-00-02	13-1	35	AR
332A2374-10		71-00-02	13-1	205	-
332A2374-13		71-00-02	13-1	200	1
332A2374-14		71-00-02	13-1	205	1
332A2374-9		71-00-02	13-1	200	-
332A2376-1		71-00-02	13-1	225	-
332A2376-1		71-00-02	13-1	260	-
332A2390-12		71-00-02	27-1	250	1
332A2390-3		71-00-02	27-1	100	-
332A2390-43		71-00-02	13-1	10	-
332A2390-45		71-00-02	13-1	10	1
332A2390-48		71-00-02	27-1	100	1
332A2410-1		71-00-02	21-1	110	1
332A2600-4		71-00-02	22-1	5	1
332A2600-5		71-00-02	22-1	10	1
332A2600-6		71-00-02	22-1	15	1
332A2710-1		71-00-02	9-1	10	1
332A2710-11		71-00-02	9-1	125	-
332A2710-13		71-00-02	9-1	150	1
332A2710-15		71-00-02	9-1	200	1

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PART NUMBER	AIRLINE PART NUMBER	LOCATION			QTY
		SUBJECT	FIG	ITEM	
332A2710-25		71-00-02	10-1	105	1
332A2710-27		71-00-02	9-1	225	1
332A2710-3		71-00-02	9-1	5	1
332A2710-30		71-00-02	9-1	100	-
332A2710-31		71-00-02	10-1	75	1
332A2710-32		71-00-02	10-1	5	-
332A2710-33		71-00-02	10-1	50	1
332A2710-36		71-00-02	9-1	75	1
332A2710-38		71-00-02	9-1	100	1
332A2710-42		71-00-02	10-1	5	-
332A2710-43		71-00-02	10-1	5	1
332A2910-1		71-00-02	27-1	65	-
332A2910-101		71-00-02	5-1	225	-
332A2910-104		71-00-02	5-1	375	-
332A2910-106		71-00-02	7-1	275	1
332A2910-108		71-00-02	7-1	325	1
332A2910-111		71-00-02	7-1	225	1
332A2910-112		71-00-02	5-1	150	1
332A2910-125		71-00-02	5-1	100	1
332A2910-128		71-00-02	4-1	700	1
332A2910-134		71-00-02	7-1	200	1
332A2910-136		71-00-02	5-1	75	1
332A2910-138		71-00-02	4-1	755	1
332A2910-141		71-00-02	4-1	625	1
332A2910-143		71-00-02	5-1	375	1
332A2910-147		71-00-02	4-1	75	1
332A2910-149		71-00-02	4-1	400	-
332A2910-159		71-00-02	4-1	450	-
332A2910-161		71-00-02	4-1	400	1
332A2910-163		71-00-02	4-1	450	1
332A2910-165		71-00-02	5-1	390	1
				225	1

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PART NUMBER	AIRLINE PART NUMBER	LOCATION			QTY
		SUBJECT	FIG	ITEM	
332A2910-24		71-00-02	5-1	5	1
332A2910-26		71-00-02	6-1	325	1
332A2910-39		71-00-02	7-1	300	1
332A2910-41		71-00-02	4-1	505	1
332A2910-51		71-00-02	6-1	400	1
332A2910-67		71-00-02	5-1	325	-
332A2910-69		71-00-02	5-1	75	-
332A2910-74		71-00-02	5-1	150	1
332A2910-87		71-00-02	4-1	355	-
332A2910-89		71-00-02	4-1	755	-
332A2910-91		71-00-02	4-1	625	-
332A2910-95		71-00-02	6-1	125A	-
332A2910-96		71-00-02	6-1	125B	-
332A2910-99		71-00-02	6-1	125	1
332A2911-1		71-00-02	5-1	275	1
332A2911-2		71-00-02	5-1	175	1
332A2911-5		71-00-02	5-1	200	1
332A2911-9		71-00-02	8-1	125	1
332A2920-110		71-00-02	5-1	25	-
332A2920-115		71-00-02	4-1	360	-
332A2920-117		71-00-02	4-1	255	-
332A2920-119		71-00-02	5-1	250	1
332A2920-124		71-00-02	7-1	25	-
332A2920-131		71-00-02	4-1	250	-
332A2920-132		71-00-02	6-1	175	2
332A2920-142		71-00-02	4-1	150	1
332A2920-143		71-00-02	7-1	100	-
332A2920-15		71-00-02	4-1	825	1
332A2920-157		71-00-02	4-1	250	1
332A2920-178		71-00-02	4-1	325	1
332A2920-179		71-00-02	7-1	175	1
332A2920-185		71-00-02	7-1	125	1

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PART NUMBER	AIRLINE PART NUMBER	LOCATION			QTY
		SUBJECT	FIG	ITEM	
332A2920-193		71-00-02	5-1	25	-
332A2920-197		71-00-02	4-1	350	1
332A2920-199		71-00-02	7-1	100	1
332A2920-201		71-00-02	7-1	25	1
332A2920-222		71-00-02	4-1	800	1
332A2920-224		71-00-02	4-1	750	1
332A2920-225		71-00-02	7-1	55	1
332A2920-228		71-00-02	4-1	600	1
332A2920-229		71-00-02	4-1	5	1
332A2920-230		71-00-02	8-1	5	1
332A2920-232		71-00-02	4-1	100	1
332A2920-235		71-00-02	5-1	330	1
332A2920-236		71-00-02	4-1	390	-
332A2920-237		71-00-02	6-1	450	1
332A2920-245		71-00-02	5-1	25	1
332A2920-29		71-00-02	6-1	175	-
332A2920-39		71-00-02	7-1	125	-
332A2920-48		71-00-02	6-1	450	-
332A2920-55		71-00-02	7-1	350	1
332A2920-92		71-00-02	5-1	80	1
332A2920-92		71-00-02	5-1	130	1
332A2921-1		71-00-02	8-1	25	1
332A2930-1		71-00-02	6-1	50	1
332A2930-1		71-00-02	6-1	75	1
332A2930-17		71-00-02	7-1	175	-
332A2930-26		71-00-02	6-1	405	-
332A2930-30		71-00-02	4-1	325	-
332A2930-33		71-00-02	4-1	550	-
332A2930-49		71-00-02	14-1	10	-
332A2930-54		71-00-02	5-1	330	-
332A2930-57		71-00-02	4-1	700	-
332A2930-60		71-00-02	5-1	380	-

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PART NUMBER	AIRLINE PART NUMBER	LOCATION			QTY
		SUBJECT	FIG	ITEM	
332A2930-61		71-00-02	4-1	950	1
332A2930-62		71-00-02	6-1	225	1
332A2930-7		71-00-02	4-1	650	1
332A2930-85		71-00-02	4-1	550	-
332A2930-88		71-00-02	4-1	705	1
332A2930-89		71-00-02	4-1	602	1
332A2930-90		71-00-02	6-1	350	1
332A2930-98		71-00-02	4-1	392	1
332A2930-99		71-00-02	4-1	550	1
332A2931-3		71-00-02	5-1	125	1
332T3323-2		71-00-02	20-1	110	1
332W1910-9		71-00-02	24-1	220	3
332W3130-18		71-00-02	21-1	245	3
332W3130-18		71-00-02	21-1	285	2
332W5101-10		71-00-02	21-1	250	3
332W5101-10		71-00-02	21-1	290	2
333A2020-5		71-00-02	32-2	90	1
333A2020-5		71-00-02	32-2	130	1
334A2010-1		71-00-02	33-1	80	24
340-087-904-0		71-00-02	24-1	2	-
370D1005-5		71-00-02	6-1	30	1
370D1005-5		71-00-02	6-1	200	1
387999		71-00-02	20-1	105	-
649-304-004-0		71-00-02	33-1	270	-
649-341-011-0		71-00-02	33-1	260	-
683-3-20		71-00-02	30-1		-
69A94		71-00-02	33-1	250	-
731476		71-00-02	22-1	85	-
7579078		71-00-02	21-1	5	1
761574		71-00-02	22-1	50	-
761574B		71-00-02	22-1	50	1
762075		71-00-02	22-1	80	-

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PART NUMBER	AIRLINE PART NUMBER	LOCATION			QTY
		SUBJECT	FIG	ITEM	
762246		71-00-02	22-1	75	1
801A50-0004-A		71-00-02	14-1	25	1
801A50-0004-A		71-00-02	15-1	150	1
801A50-0004A		71-00-02	14-1	25	-
801A50-0004A		71-00-02	15-1	150	-
801A50-0005-A		71-00-02	14-1	155	2
801A50-0005-A		71-00-02	14-1	255	1
801A50-0005-A		71-00-02	16-1	160	1
801A50-0005-A		71-00-02	18-1	10	1
801A50-0005A		71-00-02	14-1	155	-
801A50-0005A		71-00-02	14-1	255	-
801A50-0005A		71-00-02	16-1	160	-
801A50-0005A		71-00-02	18-1	10	-
801A50-0006-A		71-00-02	14-1	80	2
801A50-0006-A		71-00-02	14-1	165	1
801A50-0006-A		71-00-02	14-1	265	1
801A50-0006-A		71-00-02	17-1	180	1
801A50-0006-A		71-00-02	18-1	20	1
801A50-0006-A		71-00-02	18-1	30	1
801A50-0006-A		71-00-02	27-1	135	1
801A50-0006A		71-00-02	14-1	80	-
801A50-0006A		71-00-02	14-1	165	-
801A50-0006A		71-00-02	14-1	265	-
801A50-0006A		71-00-02	17-1	180	-
801A50-0006A		71-00-02	18-1	20	-
801A50-0006A		71-00-02	18-1	30	-
801A50-0006A		71-00-02	27-1	135	-
82C10020-2		71-00-02	14-1	100	1
849589		71-00-02	20-1	15	1
8757-350		71-00-02	16-1	110	1
902016-01		71-00-02	28-1	10	1
902018-01		71-00-02	28-1	20	1

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PART NUMBER	AIRLINE PART NUMBER	LOCATION			QTY
		SUBJECT	FIG	ITEM	
902862		71-00-02	28-1	15	1
902864		71-00-02	28-1	5	1
9134M25P29		71-00-02	13-1	150	1
9352M41P03		71-00-02	9-1	35	-
9352M41P04		71-00-02	28-1	65	6
9352M41P04		71-00-02	28-1	185	16
9352M41P04		71-00-02	28-1	285	6
9352M41P04		71-00-02	28-1	310	10
9352M41P04		71-00-02	28-1	435	2
9352M41P16		71-00-02	15-1	30	-
9352M41P16		71-00-02	15-1	125	-
9352M41P16		71-00-02	17-1	15	-
9352M41P16		71-00-02	17-1	104	-
9352M41P16		71-00-02	17-1	112	-
9352M41P16		71-00-02	17-1	235	-
974219		71-00-02	20-1	150	-

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EFFECTIVE PAGES			71-00-02 P/P BUILDUP FIGURE 3-1 (cont)			71-00-02 P/P BUILDUP FIGURE 4-1 (cont)		
1 thru 6	Jun 15/2015		12	BLANK		37	Jun 15/2014	
71-CONTENTS			71-00-02 P/P BUILDUP FIGURE 4-1			38	Jun 15/2014	
1	Jun 15/2013		1	Feb 15/2013		39	Jun 15/2014	
2	Feb 15/2013		2	Feb 15/2013		40	Jun 15/2014	
71-00-02 SUBJECT INDEX FIGURE 1-1			3	Jun 15/2014		41	Jun 15/2014	
1	Feb 15/2013		4	Feb 15/2013		42	Jun 15/2014	
2	Feb 15/2013		5	Feb 15/2013		43	Jun 15/2014	
3	Feb 15/2013		6	Feb 15/2013		44	Jun 15/2014	
4	Feb 15/2013		7	Feb 15/2013		45	Jun 15/2014	
5	Jun 15/2013		8	Feb 15/2013		46	Jun 15/2014	
6	Feb 15/2013		9	Feb 15/2013		47	Jun 15/2014	
7	Feb 15/2013		10	Feb 15/2013		48	Jun 15/2014	
8	BLANK		11	Feb 15/2013		49	Jun 15/2014	
71-00-02 P/P BUILDUP FIGURE 2-1			12	Feb 15/2013		50	Jun 15/2014	
1	Feb 15/2013		13	Feb 15/2013		51	Jun 15/2014	
2	Feb 15/2013		14	Feb 15/2013		52	Jun 15/2014	
3	Feb 15/2013		15	Feb 15/2013		53	Jun 15/2014	
4	Feb 15/2013		16	Feb 15/2013		54	Jun 15/2014	
5	Feb 15/2013		17	Feb 15/2013		55	Jun 15/2014	
6	Feb 15/2013		18	Feb 15/2013		56	Jun 15/2014	
7	Feb 15/2013		19	Feb 15/2013		57	Jun 15/2014	
8	Feb 15/2013		20	Feb 15/2013		58	Jun 15/2014	
9	Feb 15/2013		21	Feb 15/2013		59	Jun 15/2014	
10	Feb 15/2013		22	Feb 15/2013		60	Jun 15/2014	
11	Feb 15/2013		23	Feb 15/2013		61	Jun 15/2014	
12	BLANK		24	Jun 15/2014		62	BLANK	
71-00-02 P/P BUILDUP FIGURE 3-1			25	Jun 15/2014		71-00-02 P/P BUILDUP FIGURE 5-1		
1	Feb 15/2013		26	Jun 15/2014		1	Feb 15/2013	
2	Feb 15/2013		27	Jun 15/2014		2	Feb 15/2013	
3	Feb 15/2013		28	Jun 15/2014		3	Feb 15/2013	
4	Feb 15/2013		29	Jun 15/2014	R 4	Jun 15/2015		
5	Feb 15/2013		30	Jun 15/2014	R 5	Jun 15/2015		
6	Feb 15/2013		31	Jun 15/2014	R 6	Jun 15/2015		
7	Feb 15/2013		32	Jun 15/2014	7	Feb 15/2013		
8	Feb 15/2013		33	Jun 15/2014	R 8	Jun 15/2015		
9	Feb 15/2013		34	Jun 15/2014	9	Feb 15/2013		
10	Feb 15/2013		35	Jun 15/2014	R 10	Jun 15/2015		
11	Feb 15/2013		36	Jun 15/2014	11	Feb 15/2013		

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71-00-02 P/P BUILDUP FIGURE 5-1 (cont)			71-00-02 P/P BUILDUP FIGURE 6-1 (cont)			71-00-02 P/P BUILDUP FIGURE 7-1 (cont)		
R 12	Jun 15/2015		19	Feb 15/2013		30	BLANK	
13	Feb 15/2013		20	Feb 15/2013		71-00-02 P/P BUILDUP FIGURE 8-1		
R 14	Jun 15/2015		21	Feb 15/2013		1	Feb 15/2013	
15	Feb 15/2013		22	Feb 15/2013		2	Feb 15/2013	
R 16	Jun 15/2015		23	Feb 15/2013		R 3	Jun 15/2015	
17	Feb 15/2013		24	Feb 15/2013		4	Feb 15/2013	
18	Feb 15/2013		25	Feb 15/2013		5	Feb 15/2013	
R 19	Jun 15/2015		26	BLANK		6	Feb 15/2013	
20	Feb 15/2013		71-00-02 P/P BUILDUP FIGURE 7-1			7	Feb 15/2013	
21	Feb 15/2013		1	Feb 15/2013		8	Feb 15/2013	
22	Feb 15/2013		2	Feb 15/2013		9	Feb 15/2013	
23	Feb 15/2013		3	Feb 15/2013		10	Feb 15/2013	
24	Feb 15/2013		4	Feb 15/2013		11	Feb 15/2013	
25	Feb 15/2013		5	Feb 15/2013		12	BLANK	
26	Feb 15/2013		6	Feb 15/2013		71-00-02 P/P BUILDUP FIGURE 9-1		
27	Feb 15/2013		7	Feb 15/2013		1	Feb 15/2013	
28	Feb 15/2013		8	Feb 15/2013		2	Feb 15/2013	
29	Feb 15/2013		9	Feb 15/2013		R 3	Jun 15/2015	
30	BLANK		10	Feb 15/2013		4	Feb 15/2013	
71-00-02 P/P BUILDUP FIGURE 6-1			11	Feb 15/2013		R 5	Jun 15/2015	
1	Feb 15/2013		12	Feb 15/2013		6	Feb 15/2013	
2	Feb 15/2013		13	Feb 15/2013		R 7	Jun 15/2015	
3	Feb 15/2013		14	Feb 15/2013		8	Feb 15/2013	
4	Feb 15/2013		15	Feb 15/2013		R 9	Jun 15/2015	
5	Feb 15/2013		16	Feb 15/2013		10	Feb 15/2013	
6	Feb 15/2013		17	Feb 15/2013		11	Feb 15/2013	
7	Feb 15/2013		18	Feb 15/2013		12	Feb 15/2013	
8	Feb 15/2013		19	Feb 15/2013		R 13	Jun 15/2015	
9	Feb 15/2013		20	Feb 15/2013		14	Feb 15/2013	
10	Feb 15/2013		21	Feb 15/2013		15	Feb 15/2013	
11	Feb 15/2013		22	Feb 15/2013		16	Feb 15/2013	
12	Feb 15/2013		23	Feb 15/2013		R 17	Jun 15/2015	
13	Feb 15/2013		24	Feb 15/2013		18	BLANK	
14	Feb 15/2013		25	Feb 15/2013		71-00-02 P/P BUILDUP FIGURE 10-1		
15	Feb 15/2013		26	Feb 15/2013		1	Feb 15/2013	
16	Feb 15/2013		27	Feb 15/2013		2	Feb 15/2013	
17	Feb 15/2013		28	Feb 15/2013		R 3	Jun 15/2015	
18	Feb 15/2013		29	Feb 15/2013		4	Feb 15/2013	

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R 5	Jun 15/2015	19	Feb 15/2013			R 3	Jun 15/2015	
6	Feb 15/2013	20	Feb 15/2013			4	Feb 15/2013	
R 7	Jun 15/2015	21	Feb 15/2013			R 5	Jun 15/2015	
R 8	Jun 15/2015	22	Feb 15/2013			6	Feb 15/2013	
R 9	Jun 15/2015	23	Feb 15/2013			7	Feb 15/2013	
10	Feb 15/2013	24	Feb 15/2013			8	Feb 15/2013	
11	Feb 15/2013	25	Feb 15/2013			9	Feb 15/2013	
12	Feb 15/2013	26	Feb 15/2013			10	Feb 15/2013	
R 13	Jun 15/2015	27	Feb 15/2013			R 11	Jun 15/2015	
14	Feb 15/2013	28	BLANK			12	Feb 15/2013	
R 15	Jun 15/2015		71-00-02 P/P BUILDUP FIGURE 14-1			R 13	Jun 15/2015	
16	BLANK	1	Feb 15/2013			14	BLANK	
71-00-02 P/P BUILDUP FIGURE 12-1		2	Feb 15/2013			71-00-02 P/P BUILDUP FIGURE 16-1		
1	Feb 15/2013	3	Feb 15/2013			1	Feb 15/2013	
2	Feb 15/2013	4	Feb 15/2013			2	Feb 15/2013	
3	Feb 15/2013	R 5	Jun 15/2015			3	Feb 15/2013	
4	Feb 15/2013	6	Feb 15/2013			4	Feb 15/2013	
5	Feb 15/2013	7	Feb 15/2013			5	Feb 15/2013	
6	BLANK	8	Feb 15/2013			6	Feb 15/2013	
71-00-02 P/P BUILDUP FIGURE 13-1		R 9	Jun 15/2015			7	Feb 15/2013	
1	Feb 15/2013	10	Feb 15/2013			8	Feb 15/2013	
2	Feb 15/2013	R 11	Jun 15/2015			R 9	Jun 15/2015	
3	Jun 15/2014	12	Feb 15/2013			10	Feb 15/2013	
4	Feb 15/2013	R 13	Jun 15/2015			R 11	Jun 15/2015	
5	Feb 15/2013	14	Feb 15/2013			12	Feb 15/2013	
6	Feb 15/2013	R 15	Jun 15/2015			R 13	Jun 15/2015	
7	Feb 15/2013	16	Feb 15/2013			14	Feb 15/2013	
8	Feb 15/2013	R 17	Jun 15/2015			R 15	Jun 15/2015	
9	Feb 15/2013	18	Feb 15/2013			16	Feb 15/2013	
10	Feb 15/2013	19	Feb 15/2013			R 17	Jun 15/2015	
11	Feb 15/2013	20	Feb 15/2013			18	Feb 15/2013	
12	Feb 15/2013	21	Feb 15/2013			19	Feb 15/2013	
13	Feb 15/2013	22	Feb 15/2013			20	Feb 15/2013	
14	Feb 15/2013	23	Feb 15/2013			21	Feb 15/2013	
15	Feb 15/2013	24	BLANK			22	Feb 15/2013	
16	Feb 15/2013		71-00-02 P/P BUILDUP FIGURE 15-1			R 23	Jun 15/2015	
17	Jun 15/2013	1	Feb 15/2013			24	Feb 15/2013	
18	Feb 15/2013	2	Feb 15/2013			25	Feb 15/2013	

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71-00-02 P/P BUILDUP FIGURE 16-1 (cont)			71-00-02 P/P BUILDUP FIGURE 20-1			71-00-02 P/P BUILDUP FIGURE 21-1 (cont)		
26	BLANK		1	Jun 15/2013		R 25	Jun 15/2015	
71-00-02 P/P BUILDUP FIGURE 17-1			2	Jun 15/2013		R 26	Jun 15/2015	
1	Feb 15/2013		3	Jun 15/2013		R 27	Jun 15/2015	
2	Feb 15/2013		4	Jun 15/2013		R 28	Jun 15/2015	
R 3	Jun 15/2015		5	Jun 15/2013		A 29	Jun 15/2015	
4	Feb 15/2013		6	Jun 15/2013		A 30	BLANK	
5	Feb 15/2013		7	Jun 15/2013		71-00-02 P/P BUILDUP FIGURE 22-1		
6	Feb 15/2013		8	Jun 15/2013		1	Feb 15/2013	
7	Feb 15/2013		9	Jun 15/2013		2	Feb 15/2013	
8	Feb 15/2013		10	Jun 15/2013		3	Feb 15/2013	
R 9	Jun 15/2015		11	Jun 15/2013		4	Feb 15/2013	
10	Feb 15/2013		12	Jun 15/2013		5	Feb 15/2013	
11	Feb 15/2013		13	Jun 15/2013		6	Feb 15/2013	
12	Feb 15/2013		14	BLANK		7	Feb 15/2013	
13	Feb 15/2013		71-00-02 P/P BUILDUP FIGURE 21-1			8	Feb 15/2013	
14	Feb 15/2013		1	Feb 15/2013		9	Feb 15/2013	
R 15	Jun 15/2015		2	Feb 15/2013		10	Feb 15/2013	
16	Feb 15/2013		R 3	Jun 15/2015		11	Feb 15/2013	
17	Feb 15/2013		4	Feb 15/2013		12	Feb 15/2013	
18	Feb 15/2013		5	Jun 15/2013		13	Jun 15/2013	
R 19	Jun 15/2015		6	Feb 15/2013		14	Feb 15/2013	
20	Feb 15/2013		R 7	Jun 15/2015		15	Feb 15/2013	
21	Feb 15/2013		8	Feb 15/2013		16	BLANK	
22	BLANK		9	Feb 15/2013		71-00-02 P/P BUILDUP FIGURE 23-1		
71-00-02 P/P BUILDUP FIGURE 18-1			10	Feb 15/2013		1	Feb 15/2013	
1	Feb 15/2013		11	Jun 15/2013		2	Feb 15/2013	
2	Feb 15/2013		12	Feb 15/2013		3	Feb 15/2013	
R 3	Jun 15/2015		13	Feb 15/2013		4	BLANK	
4	Feb 15/2013		14	Feb 15/2013		71-00-02 P/P BUILDUP FIGURE 24-1		
R 5	Jun 15/2015		15	Feb 15/2013		1	Feb 15/2013	
6	Feb 15/2013		R 17	Jun 15/2015		2	Feb 15/2013	
7	Feb 15/2013		16	Feb 15/2013		R 3	Jun 15/2015	
8	Feb 15/2013		18	Feb 15/2013		4	Feb 15/2013	
R 9	Jun 15/2015		19	Feb 15/2013		5	Feb 15/2013	
10	Feb 15/2013		20	Feb 15/2013		6	Feb 15/2013	
R 11	Jun 15/2015		21	Feb 15/2013		7	Feb 15/2013	
12	BLANK		R 22	Jun 15/2015		8	Feb 15/2013	
			R 23	Jun 15/2015		9	Feb 15/2013	
			R 24	Jun 15/2015				

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10	Feb 15/2013		1	Feb 15/2013		15	Feb 15/2013	
R 11	Jun 15/2015		2	Jun 15/2013		16	Feb 15/2013	
12	Feb 15/2013		3	Jun 15/2013		17	Feb 15/2013	
R 13	Jun 15/2015		4	Feb 15/2013		18	Feb 15/2013	
R 14	Jun 15/2015		5	Feb 15/2013		19	Feb 15/2013	
R 15	Jun 15/2015		6	Feb 15/2013		20	Feb 15/2013	
16	Feb 15/2013		R 7	Jun 15/2015		21	Feb 15/2013	
17	Feb 15/2013		8	Feb 15/2013		22	Feb 15/2013	
18	Feb 15/2013		R 9	Jun 15/2015		23	Feb 15/2013	
R 19	Jun 15/2015		10	Feb 15/2013		24	Feb 15/2013	
20	Feb 15/2013		11	Jun 15/2013		25	Feb 15/2013	
21	Feb 15/2013		12	Feb 15/2013		26	Jun 15/2013	
22	Feb 15/2013		R 13	Jun 15/2015		27	Feb 15/2013	
23	Feb 15/2013		14	Feb 15/2013		28	Feb 15/2013	
24	BLANK		R 15	Jun 15/2015		29	Feb 15/2013	
71-00-02 P/P BUILDUP FIGURE 25-1			16	Feb 15/2013		30	Feb 15/2013	
1	Feb 15/2013		R 17	Jun 15/2015		31	Feb 15/2013	
2	Feb 15/2013		18	Feb 15/2013		32	Feb 15/2013	
3	Feb 15/2013		R 19	Jun 15/2015		33	Feb 15/2013	
4	Feb 15/2013		20	Feb 15/2013		34	Feb 15/2013	
5	Feb 15/2013		21	Jun 15/2013		35	Feb 15/2013	
6	Feb 15/2013		22	Feb 15/2013		36	Jun 15/2013	
R 7	Jun 15/2015		R 23	Jun 15/2015		37	Feb 15/2013	
8	Feb 15/2013		24	BLANK		38	Feb 15/2013	
9	Feb 15/2013		71-00-02 P/P BUILDUP FIGURE 28-1			39	Feb 15/2013	
10	Feb 15/2013		1	Feb 15/2013		40	BLANK	
R 11	Jun 15/2015		2	Feb 15/2013		71-00-02 P/P BUILDUP FIGURE 29-1		
12	Feb 15/2013		3	Feb 15/2013		1	Feb 15/2013	
13	Feb 15/2013		4	Feb 15/2013		2	Feb 15/2013	
R 14	Jun 15/2015		5	Feb 15/2013		3	Feb 15/2013	
R 15	Jun 15/2015		6	Feb 15/2013		4	Feb 15/2013	
16	Feb 15/2013		7	Feb 15/2013		5	Feb 15/2013	
17	Feb 15/2013		8	Feb 15/2013		6	Feb 15/2013	
18	Feb 15/2013		9	Feb 15/2013		7	Feb 15/2013	
19	Feb 15/2013		10	Feb 15/2013		8	Feb 15/2013	
R 20	Jun 15/2015		11	Feb 15/2013		9	Feb 15/2013	
R 21	Jun 15/2015		12	Feb 15/2013		10	BLANK	
22	BLANK		13	Feb 15/2013				
			14	Feb 15/2013				

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1	Feb 15/2013		16	Feb 15/2013				
2	Feb 15/2013		17	Feb 15/2013				
3	Feb 15/2013		18	Feb 15/2013				
4	Feb 15/2013		19	Feb 15/2013				
5	Feb 15/2013		20	BLANK				
6	Feb 15/2013		71-00-02 P/P BUILDUP FIGURE 33-1					
7	Feb 15/2013		1	Feb 15/2013				
8	Jun 15/2013		2	Feb 15/2013				
9	Feb 15/2013		3	Feb 15/2013				
10	Feb 15/2013		4	Feb 15/2013				
11	Feb 15/2013		5	Jun 15/2014				
12	Feb 15/2013		6	Feb 15/2013				
13	Feb 15/2013		7	Feb 15/2013				
14	BLANK		8	Feb 15/2013				
71-00-02 P/P BUILDUP FIGURE 31-1			9	Feb 15/2013				
1	Feb 15/2013		10	Feb 15/2013				
2	Feb 15/2013		R 11	Jun 15/2015				
3	Feb 15/2013		12	Feb 15/2013				
4	Feb 15/2013		13	Feb 15/2013				
5	Feb 15/2013		14	Feb 15/2013				
6	Feb 15/2013		R 15	Jun 15/2015				
7	Feb 15/2013		16	Feb 15/2013				
8	BLANK		17	Feb 15/2013				
71-00-02 P/P BUILDUP FIGURE 32-2			18	Feb 15/2013				
1	Feb 15/2013		19	Feb 15/2013				
2	Feb 15/2013		20	Feb 15/2013				
3	Feb 15/2013		21	Feb 15/2013				
4	Feb 15/2013		22	Feb 15/2013				
5	Feb 15/2013		23	Jun 15/2014				
6	Feb 15/2013		24	BLANK				
7	Feb 15/2013		71-00-03 FIGURE 1					
8	Feb 15/2013		1	Feb 15/2013				
9	Feb 15/2013		2	Feb 15/2013				
10	Feb 15/2013		71-00-04 FIGURE 1					
11	Feb 15/2013		1	Feb 15/2013				
12	Feb 15/2013		2	Feb 15/2013				
13	Feb 15/2013							
14	Feb 15/2013							
15	Feb 15/2013							

A = Added, R = Revised, O = Overflow, D = Deleted, C = Customer Originated Change

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FIGURE 1-1

CFM56-7 SERIES POWERPLANT WITH QEC INSTALLED

REF DWG: 300A2020

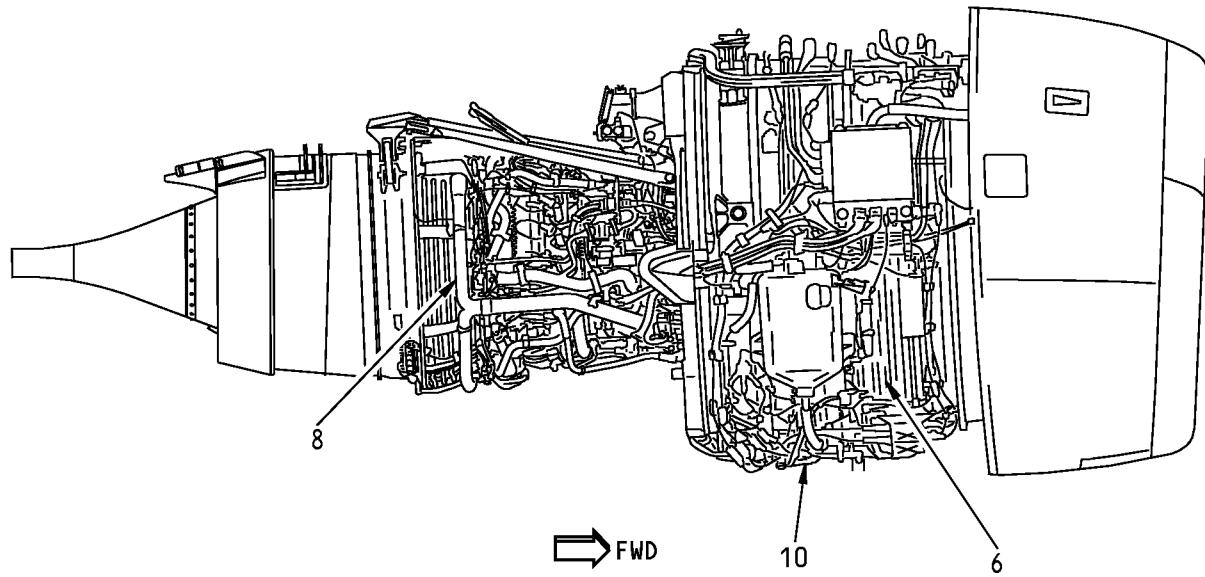
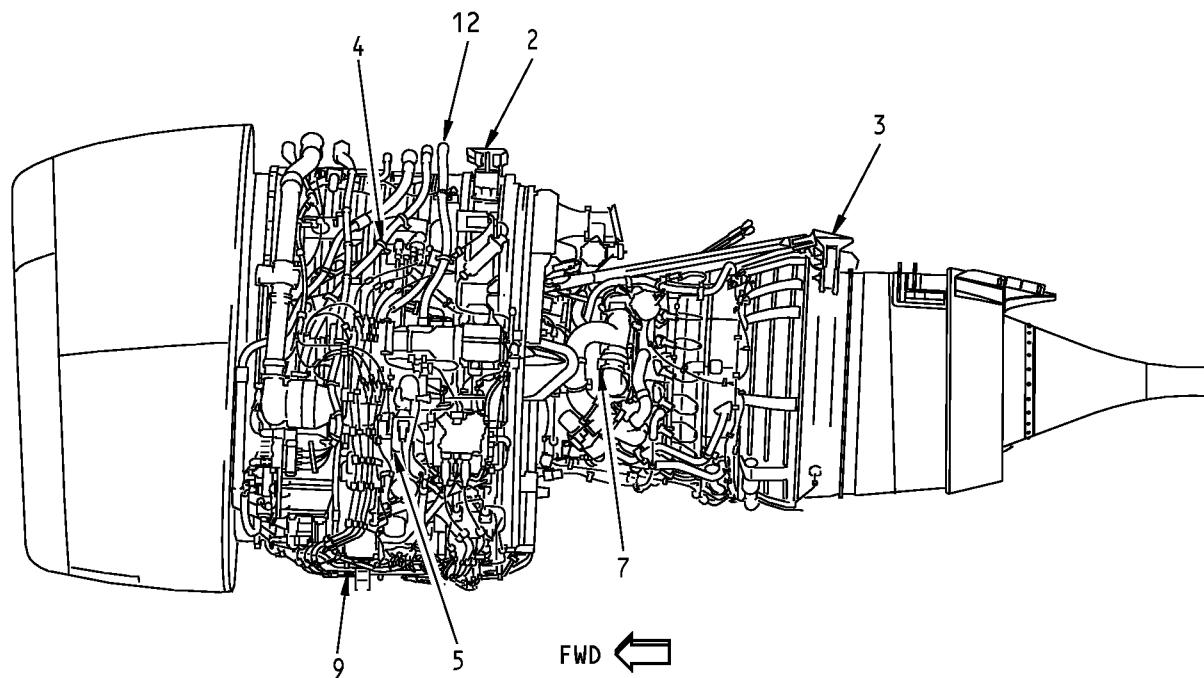
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G71239 S00041153622_V3

CFM56-7 Powerplant with QEC Installed
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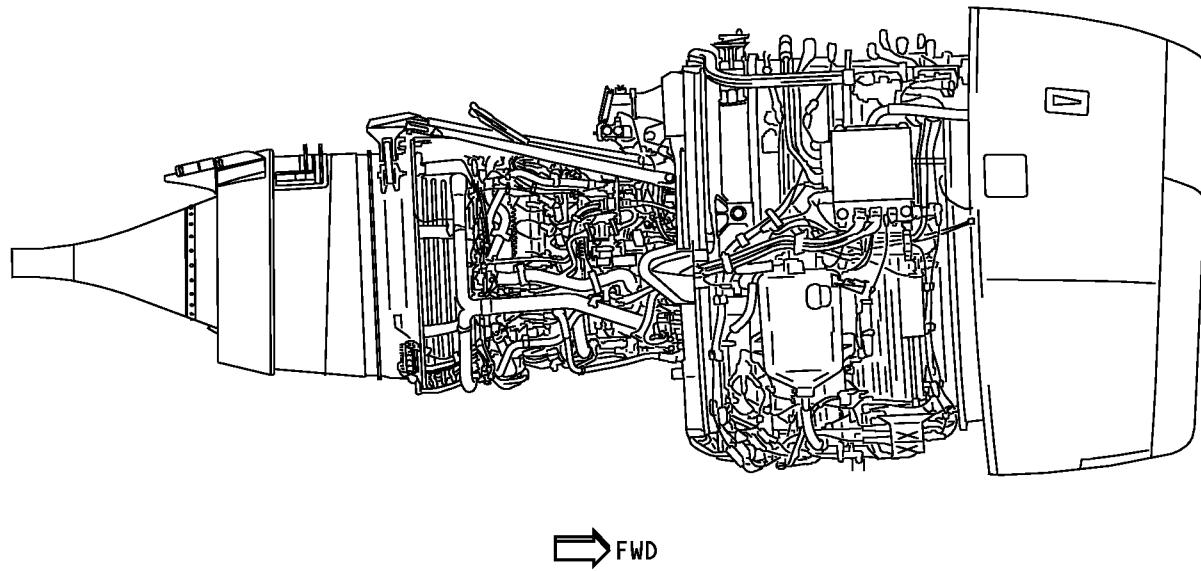
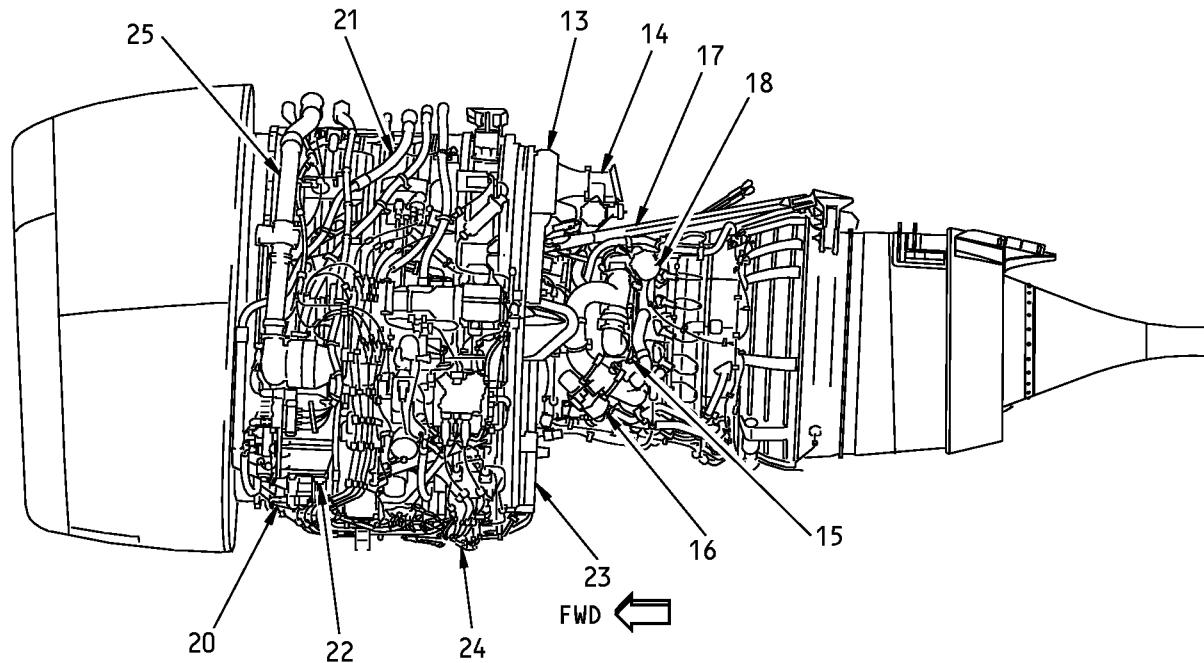
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G71244 S00041153623_V3

CFM56-7 Powerplant with QEC Installed
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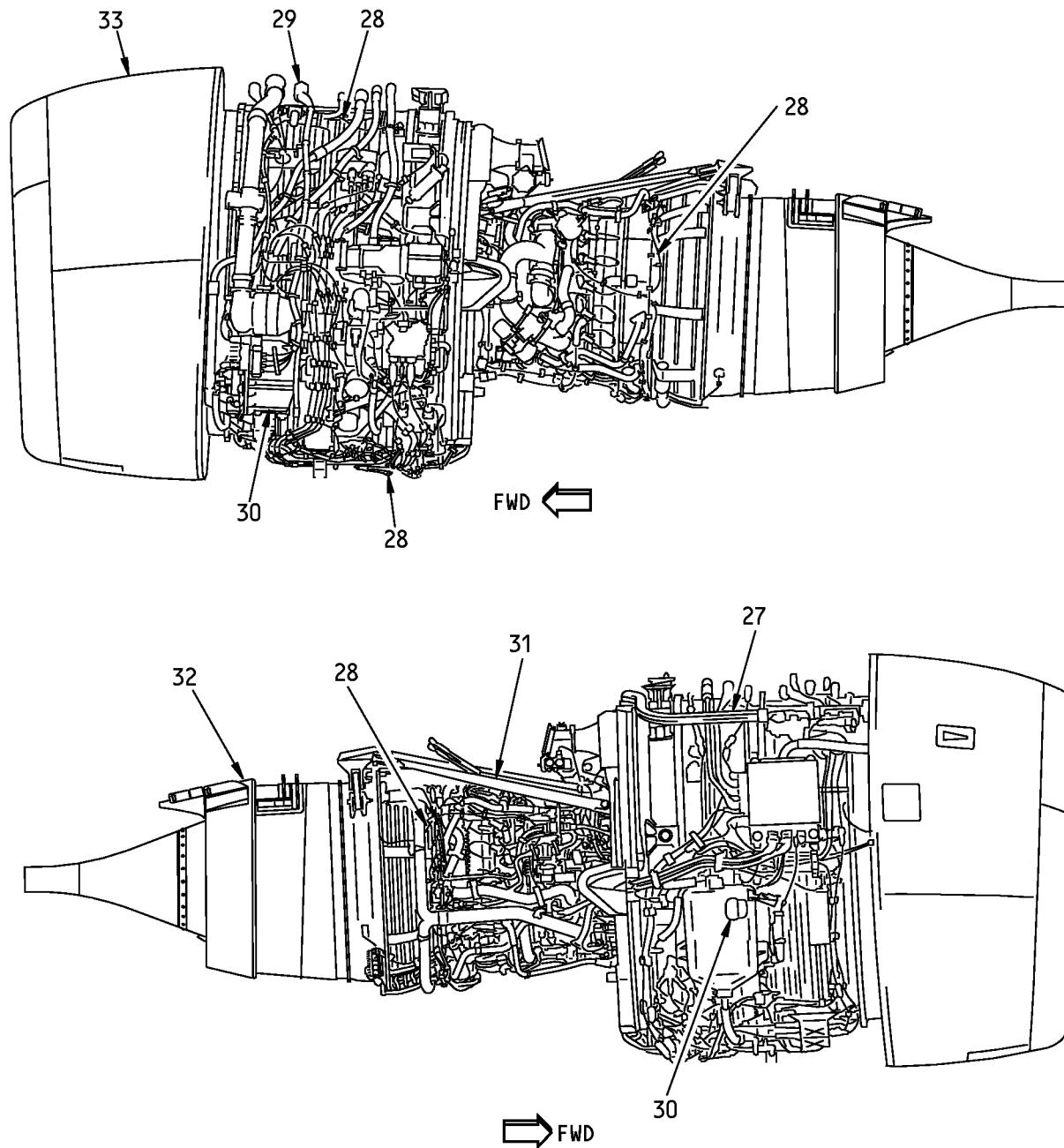
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2103708 S0000448651_V1

CFM56-7 Powerplant with QEC Installed
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FIGURE 2-1

FORWARD ENGINE MOUNT INSTALLATION

REF QEC TASK NO.: 2

**REF DWG: 310A2020
310A2010**

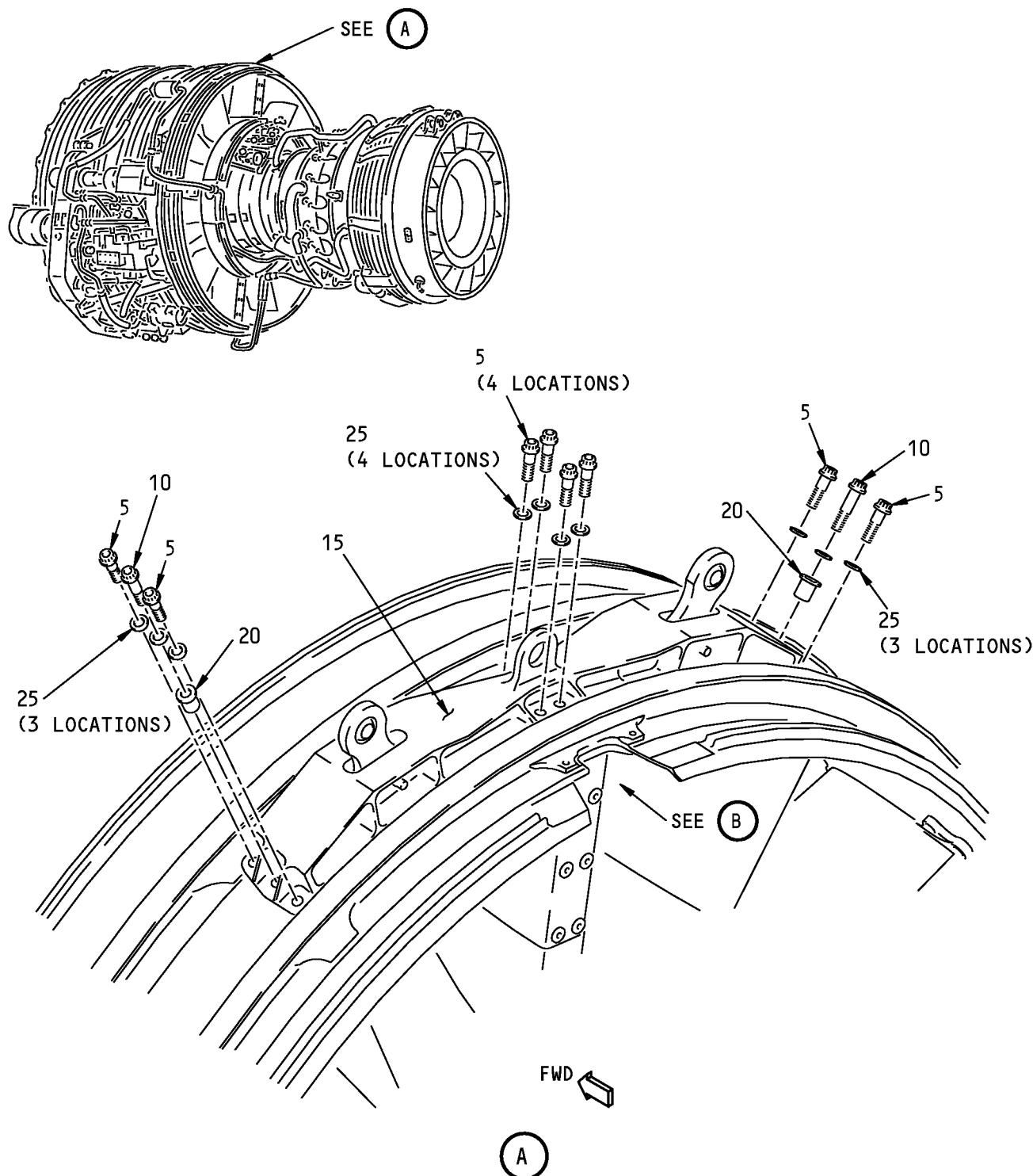
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P/P BUILDUP FIGURE 2-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
2-1		FORWARD ENGINE MOUNT INSTALLATION (FIGURE 2-1, SHEET 1) <p>NOTE: DUE TO LIMITED ACCESS, IT IS RECOMMENDED THAT BRACKET INSTALLATION - UPPER LEFT FAN CASE/Figure 4-1, ITEM NO. (800) BRACKET ASSY BE INSTALLED PRIOR TO FORWARD MOUNT SUB-ASSY (15) INSTALLATION.</p> <p>APPLY LIGHT COATING OF Never-Seez NSBT-8N compound, D00006 (C1) TO THREADS AND UNDERSIDE HEAD OF BOLTS (5) AND (10).</p> <p>NOTE: DO NOT APPLY LUBRICANT IN HEAVY AMOUNTS.</p>		
5	310A2029-11	. BOLT		8
10	310A2029-19	. BOLT		2
C1	D00006	. NEVER-SEEZ NSBT-8N COMPOUND	CON	AR
		WARNING: FWD MOUNT SUB-ASSY WEIGHS APPROXIMATELY 55 POUNDS (25 KG). MAKE SURE YOU USE A SLING OR A SUFFICIENT NUMBER OF PERSONS TO LIFT THE MOUNT ONTO ENGINE. IF YOU DO NOT, MOUNT CAN FALL AND CAUSE INJURIES TO PERSONS.		
15	310A2020-12	USE SLING OR TWO PERSONS TO POSITION FWD MOUNT SUB-ASSY (15) ON ENGINE FAN FRAME BETWEEN FLANGES B7 AND B8. . FWD MOUNT SUB-ASSY		1
		LOOSELY SECURE FWD MOUNT SUB-ASSY (15) TO ENGINE WITH LUBRICATED BOLTS (5) AND (10), BUSHINGS (20) AND WASHERS (25). MAKE SURE BOLTS (10) AND BUSHINGS (20) ARE IN OUTBOARD CENTER POSITION ONLY AND CSK SIDE OF WASHER IS AGAINST BOLT HEAD.		
20	310A2020-6	. BUSHING		2
25	BACW10BP8ACU	. WASHER (CSK)		10

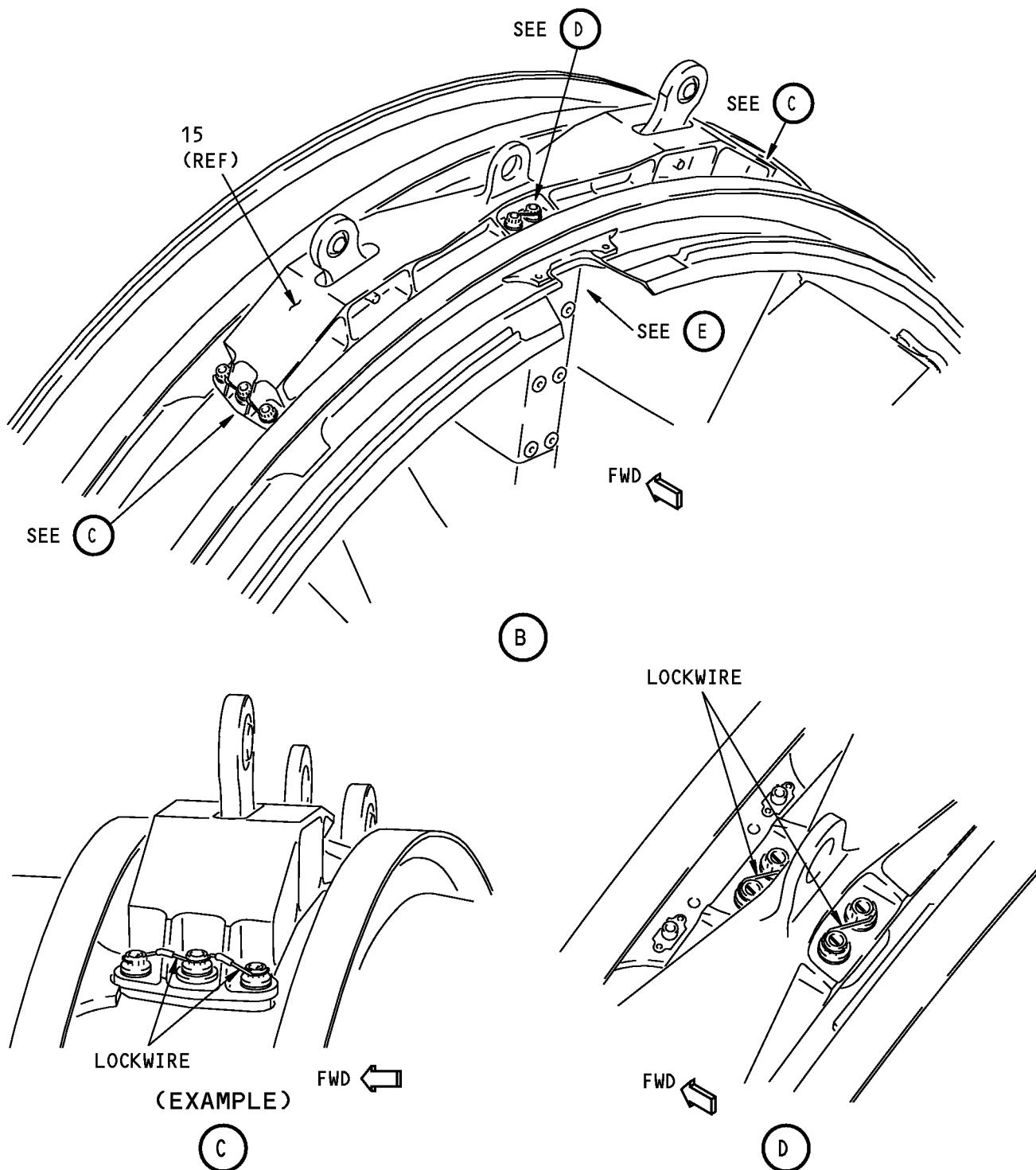
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P/P BUILDUP FIGURE 2-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
2-1		FORWARD ENGINE MOUNT INSTALLATION (FIGURE 2-1, SHEET 2) TIGHTEN BOLTS (5) AND (10) TO 585-715 POUND-INCHES (66-81 NEWTON METERS). ATTACH MS20995NC32 lockwire, G01912 (C2) OR safety cable kit, G50375 (C3) BETWEEN BOLTS (5) AT 12 O'CLOCK POSITION AND BETWEEN OUTBOARD BOLTS (5) AND (10). COVER EXPOSED LOCKWIRE OR SAFETY CABLE WITH Tyco Fluoroelastomer Tubing, G50043 (C4) OR Viton sleeve, G50044 (C5) BETWEEN FASTENER HEADS TO PREVENT CONTACT WITH LOCKWIRE AND FAN CASE FITTING. . MS20995NC32 LOCKWIRE . SAFETY CABLE KIT ^[1] . TYCO FLUOROELASTOMER TUBING . VITON SLEEVE *[1] USE 12 OR 18 INCH LENGTH SAFETY CABLE		
C2	G01912		CON	AR
C3	G50375		CON	1
C4	G50043		CON	AR
C5	G50044		OPT	-

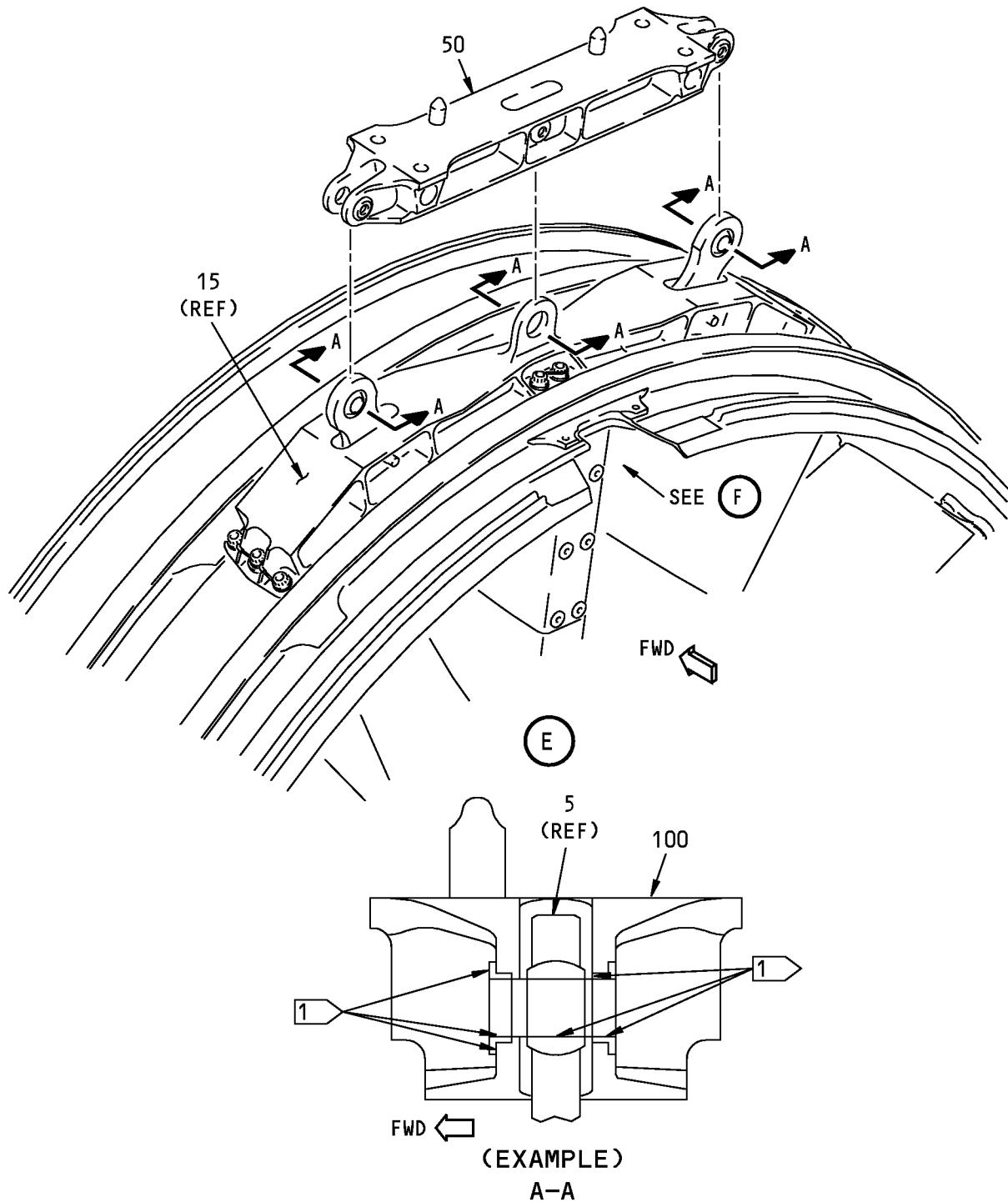
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P/P BUILDUP FIGURE 2-1

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1 ➤ APPLY ANTI-SEIZE COMPOUND AS INDICATED.

Forward Engine Mount Installation
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P/P BUILDUP FIGURE 2-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
2-1		FORWARD ENGINE MOUNT INSTALLATION (FIGURE 2-1, SHEET 3) POSITION HANGER FTG ASSY (50) ON FWD MOUNT SUB ASSY (15). MAKE SURE ALL HOLES ARE ALIGNED. CAUTION: MAKE SURE SHEAR PINS ARE ON FWD SIDE OF HANGER FTG ASSY. IF THEY ARE NOT, DAMAGE TO AIRPLANE STRUT CAN OCCUR DURING ENGINE INSTALLATION.		
50	310A2021-6	. HANGER FTG ASSY APPLY LIGHT COATING OF Never-Seez NSBT-8N compound, D00006 (C1) TO SPHERICAL BEARING BORE AND BALL FLAT SURFACES OF HANGER FTG ASSY (50). APPLY LIGHT COATING OF Never-Seez NSBT-8N compound, D00006 (C1) TO BUSHING BORES AND FLANGE FACES OF FWD MOUNT SIDE LINKS. NOTE: DO NOT APPLY LUBRICANT IN HEAVY AMOUNTS.	1	
C1	D00006	. NEVER-SEEZ NSBT-8N COMPOUND	CON	AR

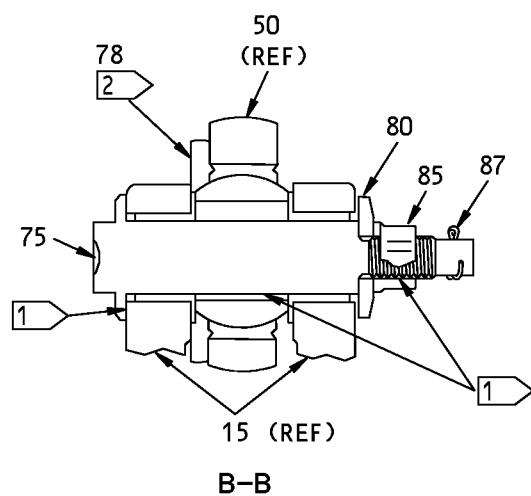
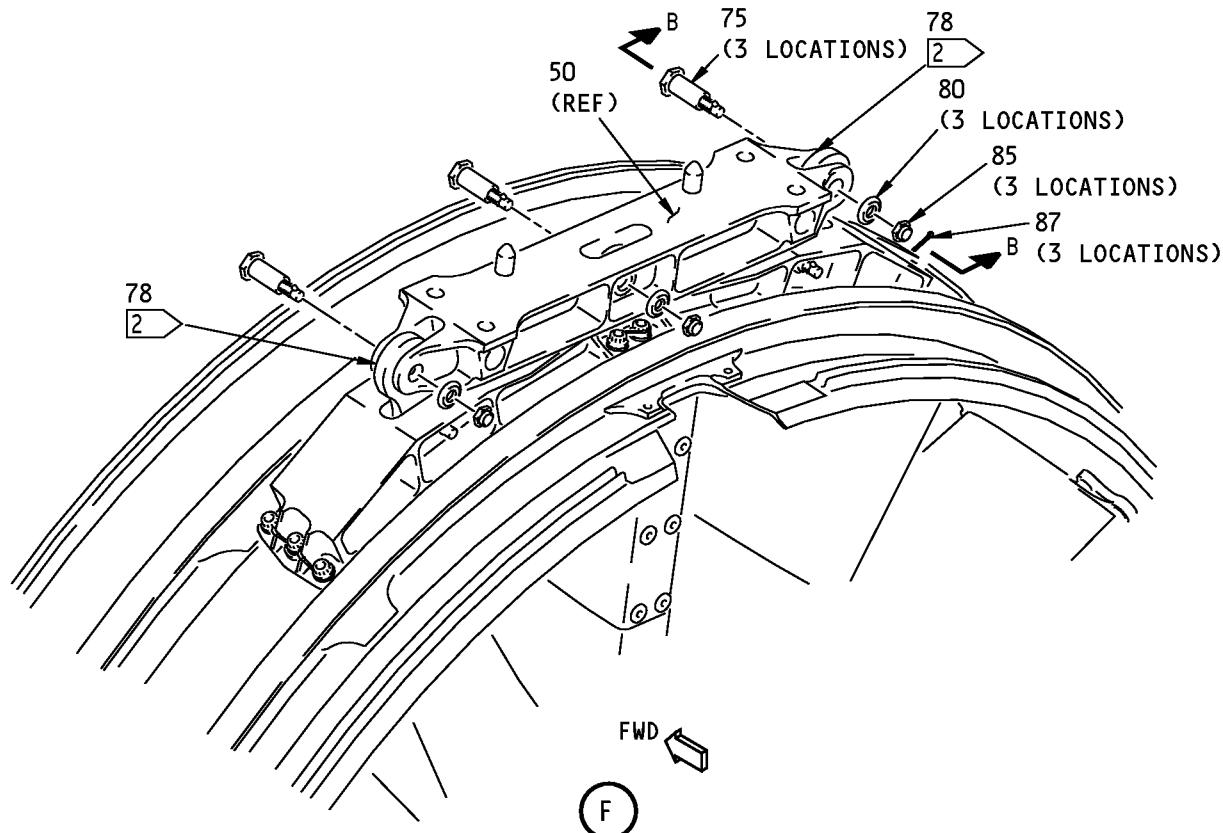
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P/P BUILDUP FIGURE 2-1

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1) APPLY ANTI-SEIZE COMPOUND AS INDICATED.

2) INSTALL ON EITHER FORWARD OR AFT SIDE OF HANGER FITTING ASSEMBLY (50).

Forward Engine Mount Installation
Figure 2-1 (Sheet 4)

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P/P BUILDUP FIGURE 2-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
2-1		FORWARD ENGINE MOUNT INSTALLATION (FIGURE 2-1, SHEET 4) APPLY LIGHT COATING OF Never-Seez NSBT-8N compound, D00006 (C1) TO THREADS, SHANK AND UNDERNEATH HEAD OF PINS (75). <u>NOTE:</u> DO NOT APPLY LUBRICANT IN HEAVY AMOUNTS.		
75 C1	310A2042-3 D00006	. THRUST LINK PIN . NEVER-SEEZ NSBT-8N COMPOUND INSTALL THRUST LINK PIN (75) WITH HEAD SIDE FORWARD IN THREE LOCATIONS ON HANGER FTG ASSY (50). INSTALL WASHER (78) BETWEEN EITHER FORWARD OR AFT SIDE OF HANGER FITTING ASSY (50) AND FORWARD MOUNT (15). ENSURE WASHER (78) CHAMFER FACES BEARING THEN ATTACH WITH END CAP (80) AND NUT (85). <u>NOTE:</u> MAKE SURE FLAT SIDE OF END CAP IS AGAINST PIN SHOULDER.	CON	3 AR
78	310A2040-7	. WASHER		2
80	310A2043-2	. END CAP		3
85	BACN10JC8CM	. NUT		3
		TIGHTEN NUT (85) TO 290-510 POUND-INCHES (33-58 NEWTON METERS). APPLY TORQUE TO NUT. INSTALL COTTER PINS (87).		
87	BACP18BC03B06P	. COTTER PIN		3
87	BACP18BC03B07P	. COTTER PIN (OPTIONAL TO BACP18BC03B06P)	OPT	-
87	BACP18BC03B08P	. COTTER PIN (OPTIONAL TO BACP18BC03B06P)	OPT	-

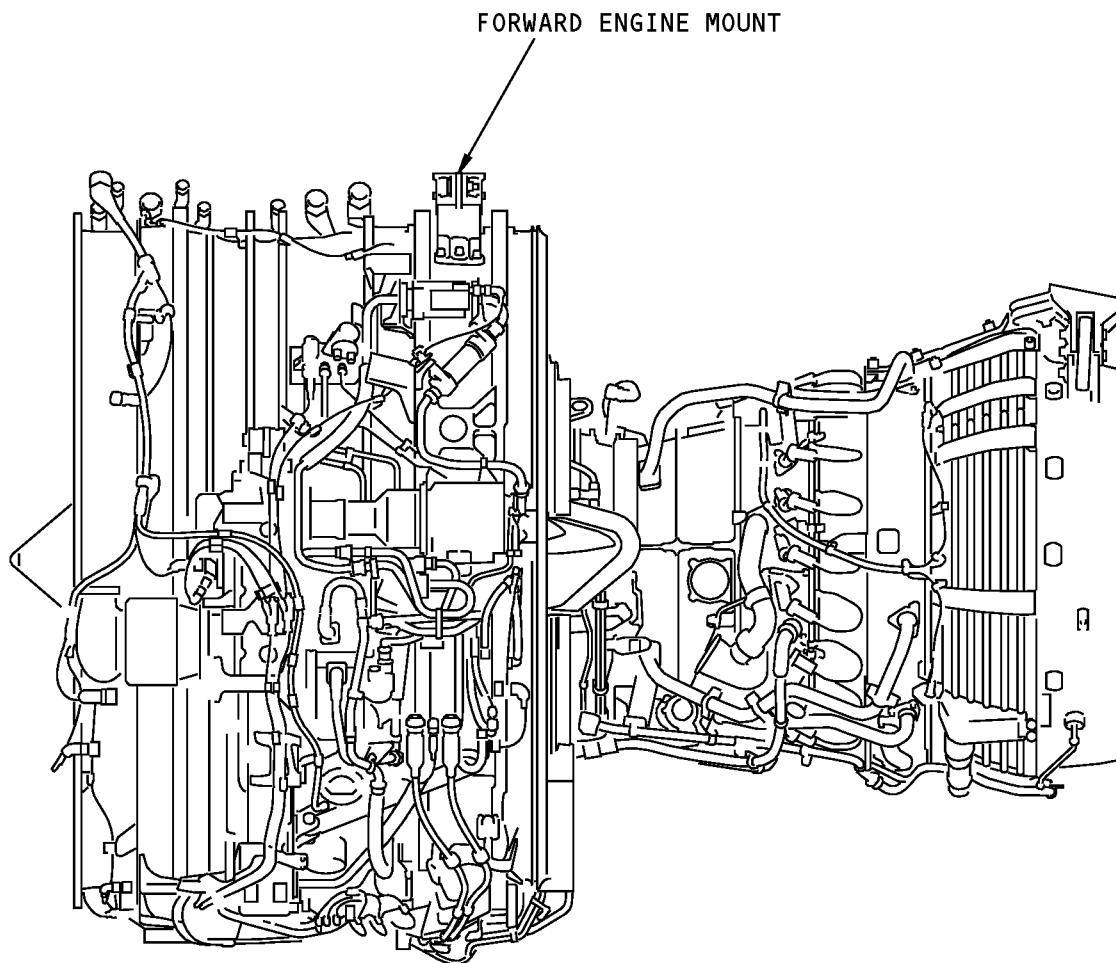
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P/P BUILDUP FIGURE 2-1

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Forward Engine Mount Installation
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P/P BUILDUP FIGURE 2-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
2-1		FORWARD ENGINE MOUNT INSTALLATION (FIGURE 2-1, SHEET 5) PUT ITEMS (100) THRU (110) IN A BAG AND SECURE TO FWD MOUNT ASSY. NOTE: ITEMS (100) THRU (110) ARE INSTALLED DURING POWERPLANT INSTALLATION ON AIRPLANE STRUT (AMM PAGEBLOCK 71-00-02/401).		
100	BACB30PN10-19M	. BOLT ^[1]		4
100	BACB30PN10-19	. BOLT (OPTIONAL TO BACB30PN10-19M) ^[1]	OPT	-
105	BACW10BP10ACU	. WASHER ^[1]		4
110	SL4147CA10A	. BARREL NUT ASSY (V97393) ^[1]	VEN	4
		*[1] ITEM NOT ILLUSTRATED		

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P/P BUILDUP FIGURE 2-1

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FIGURE 3-1

AFT ENGINE MOUNT INSTALLATION

REF QEC TASK NO.: 3

**REF DWG: 310A2030
310A2010**

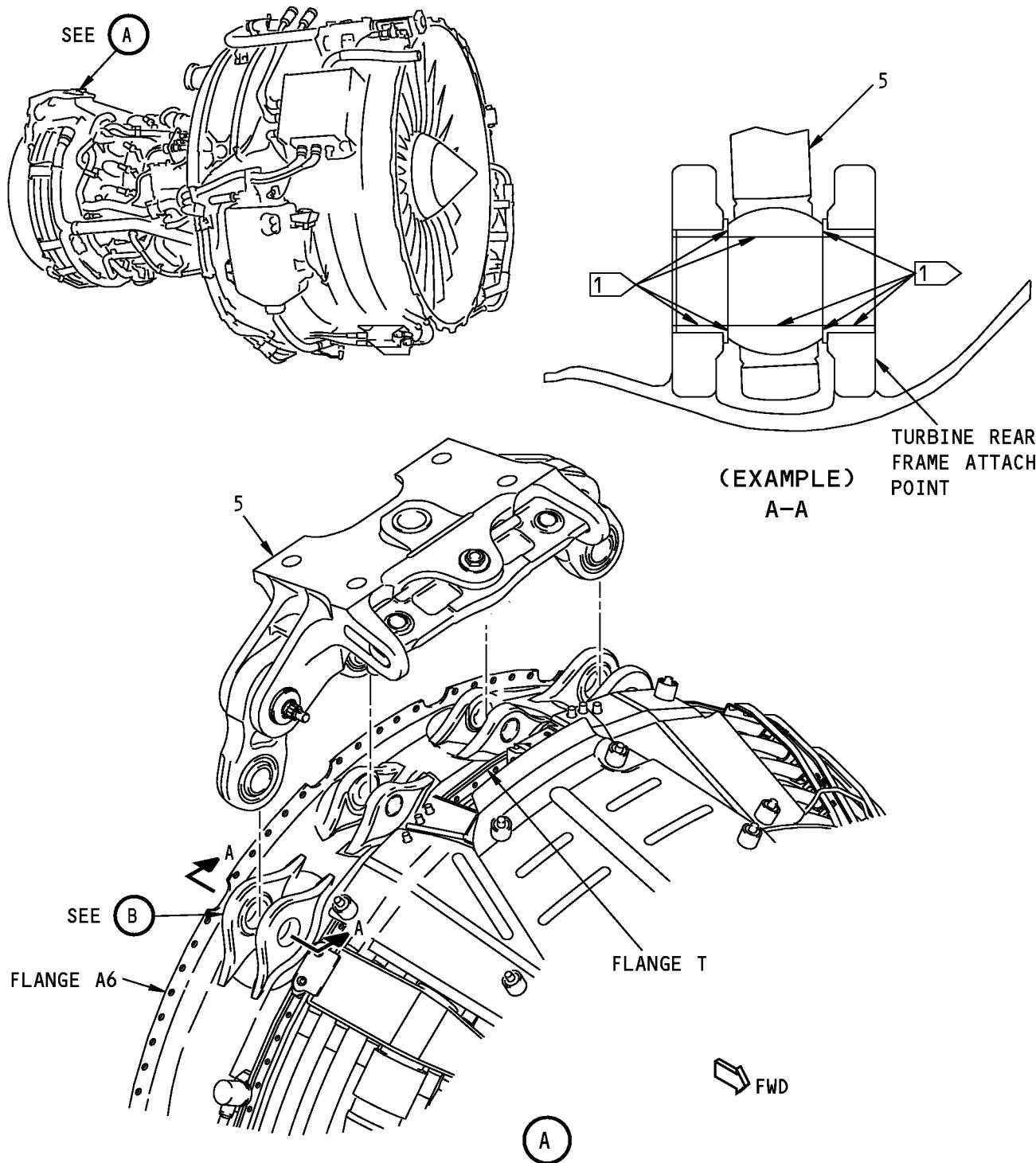
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P/P BUILDUP FIGURE 3-1

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1) APPLY ANTI-SEIZE COMPOUND AS INDICATED.

Aft Engine Mount Installation
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P/P BUILDUP FIGURE 3-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
3-1		AFT ENGINE MOUNT INSTALLATION (FIGURE 3-1, SHEET 1) APPLY LIGHT COATING OF Never-Seez NSBT-8N compound, D00006 (C1) TO SPHERICAL BEARING BORE AND BALL FLAT SURFACES OF AFT ENGINE MOUNT ASSY (5). APPLY LIGHT COATING OF Never-Seez NSBT-8N compound, D00006 (C1) TO BUSHING BORES AND FLANGE FACES OF TURBINE REAR FRAME ATTACH POINTS. NOTE: DO NOT APPLY LUBRICANT IN HEAVY AMOUNTS.		
5 C1	310A2030-19 D00006	. AFT ENGINE MOUNT ASSY . NEVER-SEEZ NSBT-8N COMPOUND WARNING: AFT ENGINE MOUNT ASSY WEIGHS APPROXIMATELY 80 POUNDS (36 KG). MAKE SURE YOU USE SLING OR SUFFICIENT NUMBER OF PERSONS TO LIFT MOUNT ONTO ENGINE. IF YOU DO NOT, MOUNT CAN FALL AND CAUSE INJURIES TO PERSONS.	CON	1 AR
T1	C71024-1	ATTACH fixture, SPL-2107 (T1) TO AFT ENGINE MOUNT ASSY (5) AND POSITION MOUNT ON ENGINE TURBINE REAR FRAME BETWEEN FLANGES T AND A6. . FIXTURE, SPL-2107	TOL	-

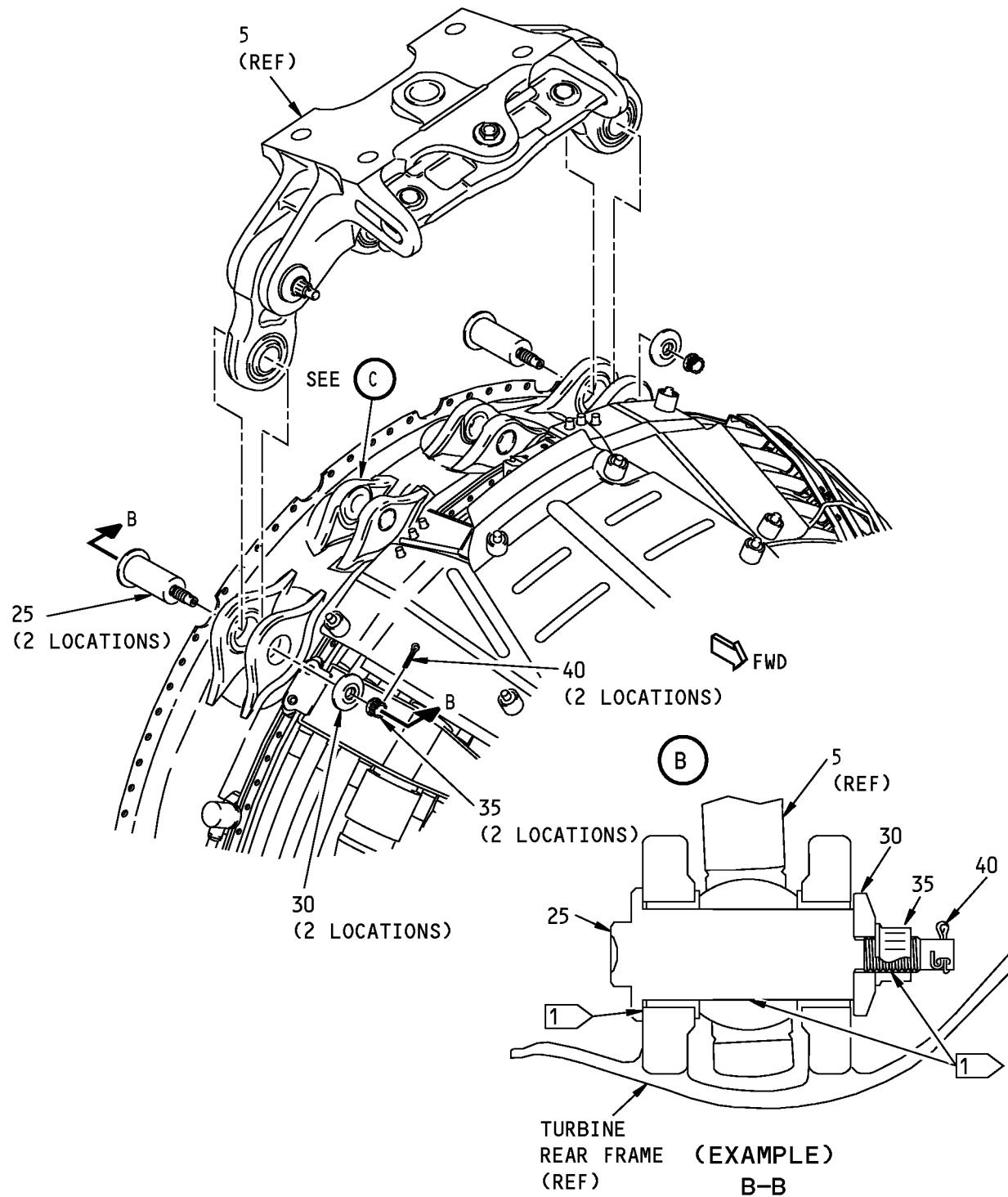
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P/P BUILDUP FIGURE 3-1

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1 ➤ APPLY ANTI-SEIZE COMPOUND AS INDICATED.

Aft Engine Mount Installation
Figure 3-1 (Sheet 2)

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P/P BUILDUP FIGURE 3-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
3-1		AFT ENGINE MOUNT INSTALLATION (FIGURE 3-1, SHEET 2) APPLY LIGHT COATING OF Never-Seez NSBT-8N compound, D00006 (C1) TO THREADS, SHANK AND UNDERNEATH HEAD OF PIN (25). NOTE: DO NOT APPLY LUBRICANT IN HEAVY AMOUNTS.		
25 C1	310A2037-14 D00006	. LINK PIN USED WITH COTTER PIN . NEVER-SEEZ NSBT-8N COMPOUND INSTALL PIN (25) IN OUTBOARD LOCATIONS OF ENGINE MOUNT (5) AND ATTACH WITH END CAP (30) AND NUT (35). NOTE: MAKE SURE FLAT SIDE OF END CAP IS AGAINST PIN SHOULDER. MAKE SURE NO PRELOAD IS PRESENT WHEN LINK PINS ARE INSTALLED.	CON	2 AR
30 35	310A2039-1 BACN11Z8C	. END CAP . NUT TIGHTEN NUT (35) TO 440-650 POUND-INCHES (50-73 NEWTON METERS). APPLY TORQUE TO EITHER NUT OR PIN HEAD.		2 2
40	BACP18BC03B07P	INSTALL COTTER PINS (40).		2
40	BACP18BC03B06P	. COTTER PIN	OPT	-
40	BACP18BC03B08P	. COTTER PIN (OPTIONAL TO BACP18BC03B07P) . COTTER PIN (OPTIONAL TO BACP18BC03B07P)	OPT	-

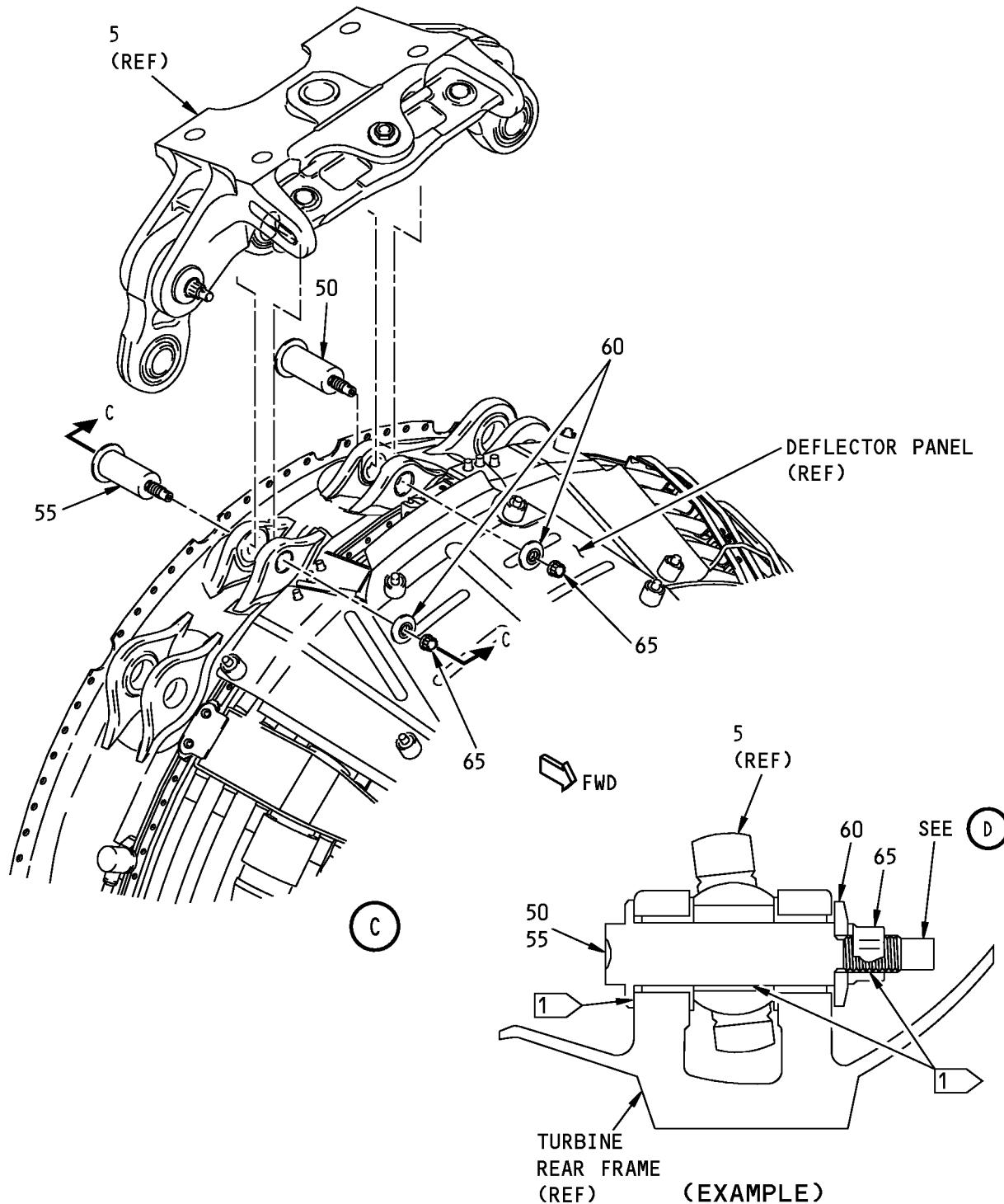
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P/P BUILDUP FIGURE 3-1

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Aft Engine Mount Installation
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P/P BUILDUP FIGURE 3-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
3-1		AFT ENGINE MOUNT INSTALLATION (FIGURE 3-1, SHEET 3) APPLY LIGHT COATING OF Never-Seez NSBT-8N compound, D00006 (C1) TO THREADS, SHANK AND UNDERNEATH HEAD OF PINS (50) AND (55). NOTE: DO NOT APPLY LUBRICANT IN HEAVY AMOUNTS.		
50	310A2037-15	. LINK PIN USED WITH COTTER PIN		1
55	310A2037-16	. LINK PIN USED WITH COTTER PIN		1
C1	D00006	. NEVER-SEEZ NSBT-8N COMPOUND INSTALL PROTECTIVE PAD BETWEEN AFT ENGINE MOUNT ASSY (5) AND DEFLECTOR PANEL. NOTE: PROTECTIVE PAD WILL BE REMOVED AFTER THRUST LINKS ARE INSTALLED. INSTALL PIN (50) IN LEFT INBOARD LOCATION OF ENGINE MOUNT (5) AND PIN (55) IN RIGHT INBOARD LOCATION. ATTACH WITH END CAPS (60) AND NUTS (65). NOTE: MAKE SURE FLAT SIDE OF END CAP IS AGAINST PIN SHOULDER. MAKE SURE NO PRELOAD IS PRESENT WHEN LINK PINS ARE INSTALLED. NOTE: PIN (55) DIAMETER IS UNDERSIZED TO SPHERICAL BEARING BORE OF MOUNT BY DESIGN. PIN SERVES AS A FAIL-SAFE BOLT.	CON	AR
60	310A2039-2	. END CAP		2
65	BACN11Z8C	. NUT TIGHTEN NUTS (65) TO 440-650 POUND-INCHES (50-73 NEWTON METERS). APPLY TORQUE TO EITHER NUT OR PIN HEAD.		2

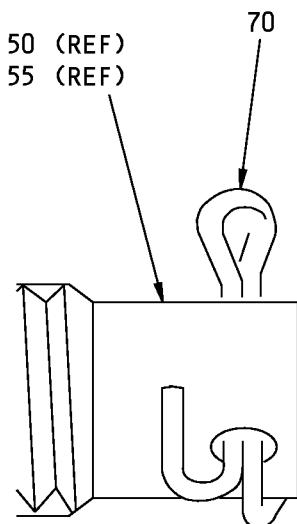
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P/P BUILDUP FIGURE 3-1

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POWERPLANT BUILDUP MANUAL

1994882 S0000388522_V1

Aft Engine Mount Installation
Figure 3-1 (Sheet 4)**71-00-02**

P/P BUILDUP FIGURE 3-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
3-1		AFT ENGINE MOUNT INSTALLATION (FIGURE 3-1, SHEET 4)		
70	BACP18BC03B06P	INSTALL COTTER PINS (70). . COTTER PIN	OPT	2
70	BACP18BC03B07P	. COTTER PIN (OPTIONAL TO BACP18BC03B06P)	OPT	-
70	BACP18BC03B08P	. COTTER PIN (OPTIONAL TO BACP18BC03B06P)	OPT	-

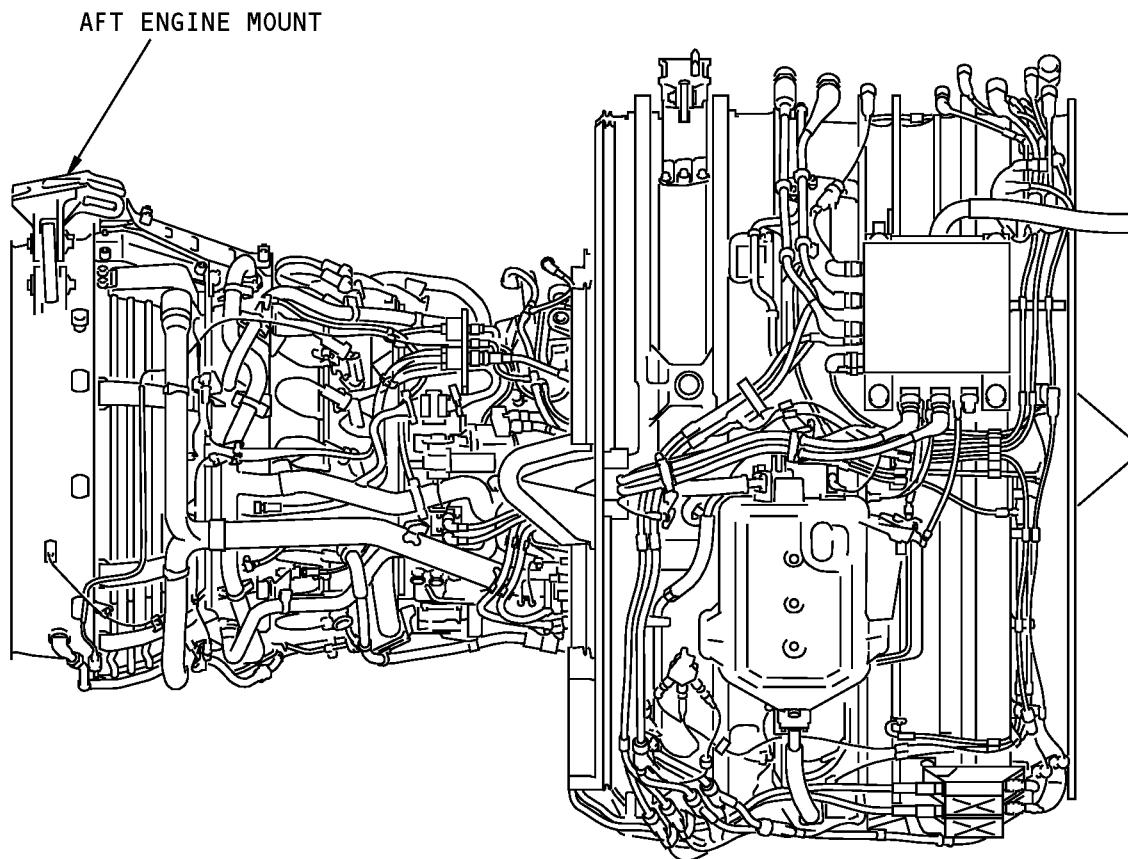
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P/P BUILDUP FIGURE 3-1

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Aft Engine Mount Installation
Figure 3-1 (Sheet 5)

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P/P BUILDUP FIGURE 3-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
3-1		AFT ENGINE MOUNT INSTALLATION (FIGURE 3-1, SHEET 5)		
T1	C71024-1	<p>REMOVE fixture, SPL-2107 (T1) FROM AFT ENGINE MOUNT.</p> <p>. FIXTURE, SPL-2107</p> <p>PUT ITEMS (100) THRU (110) IN A BAG AND SECURE TO AFT MOUNT ASSY.</p> <p>NOTE: ITEMS (100) THRU (110) ARE INSTALLED DURING POWERPLANT INSTALLATION ON AIRPLANE STRUT (AMM PAGEBLOCK 71-00-02/401).</p>	TOL	-
100	BACB30PN14-32M	. BOLT ^[6]		4
105	BACW10BP14ACU	. WASHER ^[6]		4
110	SL4147CA14EBSP1	. BARREL NUT ASSY (V97393) ^[6] *[6] ITEM NOT ILLUSTRATED	VEN	4

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P/P BUILDUP FIGURE 3-1

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FIGURE 4-1

**BRACKET INSTALLATION - UPPER LEFT FAN
CASE**

REF QEC TASK NO.: 4

REF DWG: 332A2900

NOTE: ALL STANDARDS AND ATTACHING HARDWARE FOR THIS FIGURE WILL BE PACKAGED
IN QEC TASK NO. 110.

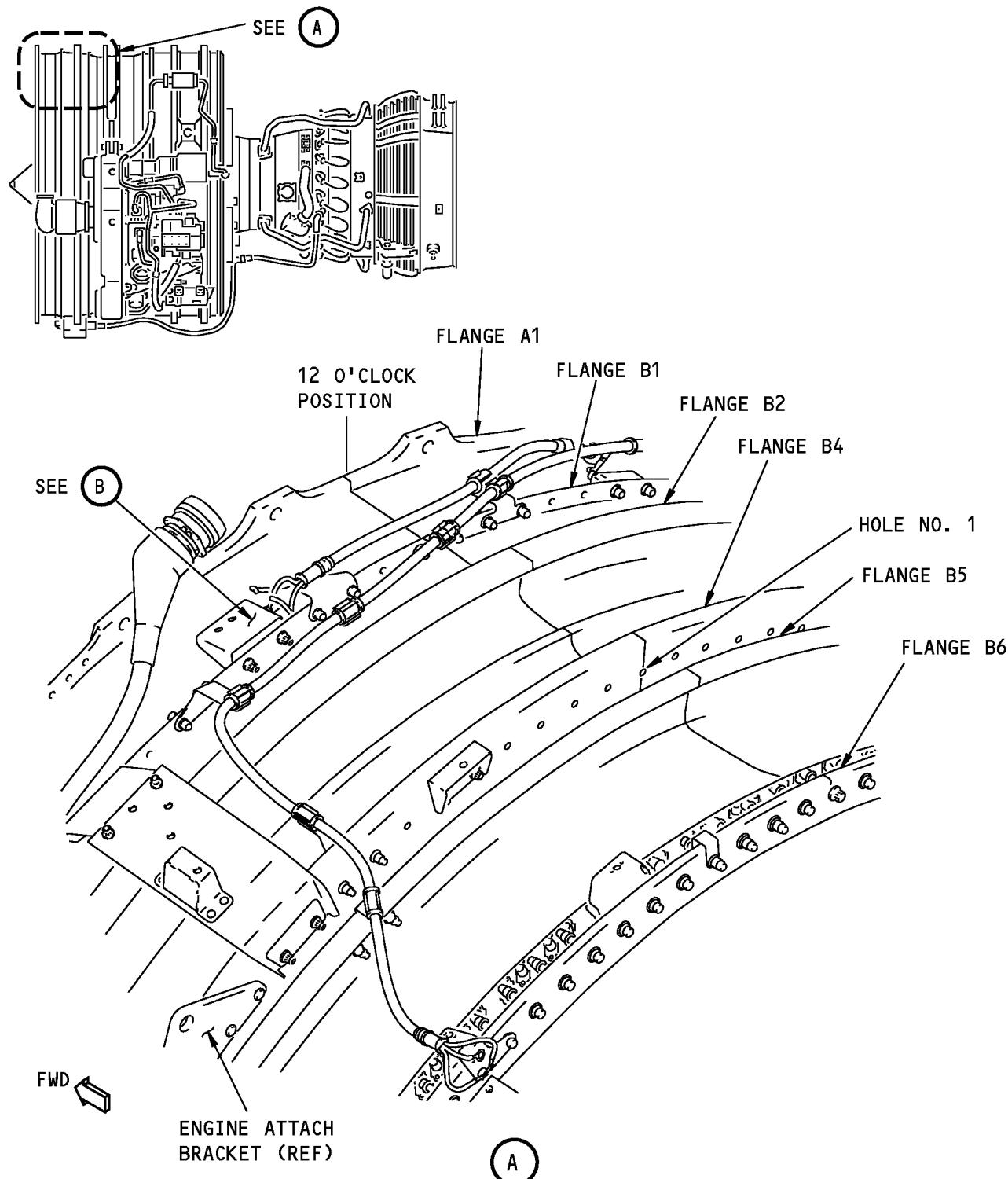
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P/P BUILDUP FIGURE 4-1

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Bracket Installation - Upper Left Side Fan Case
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P/P BUILDUP FIGURE 4-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
4-1 C1	G51223	<p>BRACKET INSTALLATION - UPPER LEFT SIDE FAN CASE (FIGURE 4-1, SHEET 1)</p> <p>COUNT 12 HOLES UP FROM ENGINE ATTACH BRACKET ON FLANGE B4. USE A marker, G51223 (C1) TO MARK THE LOCATION OF THIS HOLE ON ALL FAN FLANGES. THIS IS HOLE NO. 1 AND INDICATES THE 12 O'CLOCK POSITION.</p> <p>NOTE: IN THIS FIGURE, HOLES ARE COUNTED FROM THE NO. 1 HOLE COUNTERCLOCKWISE (AFT LOOKING FWD) UNLESS OTHERWISE STATED.</p> <p>. MARKER</p>			CON	AR

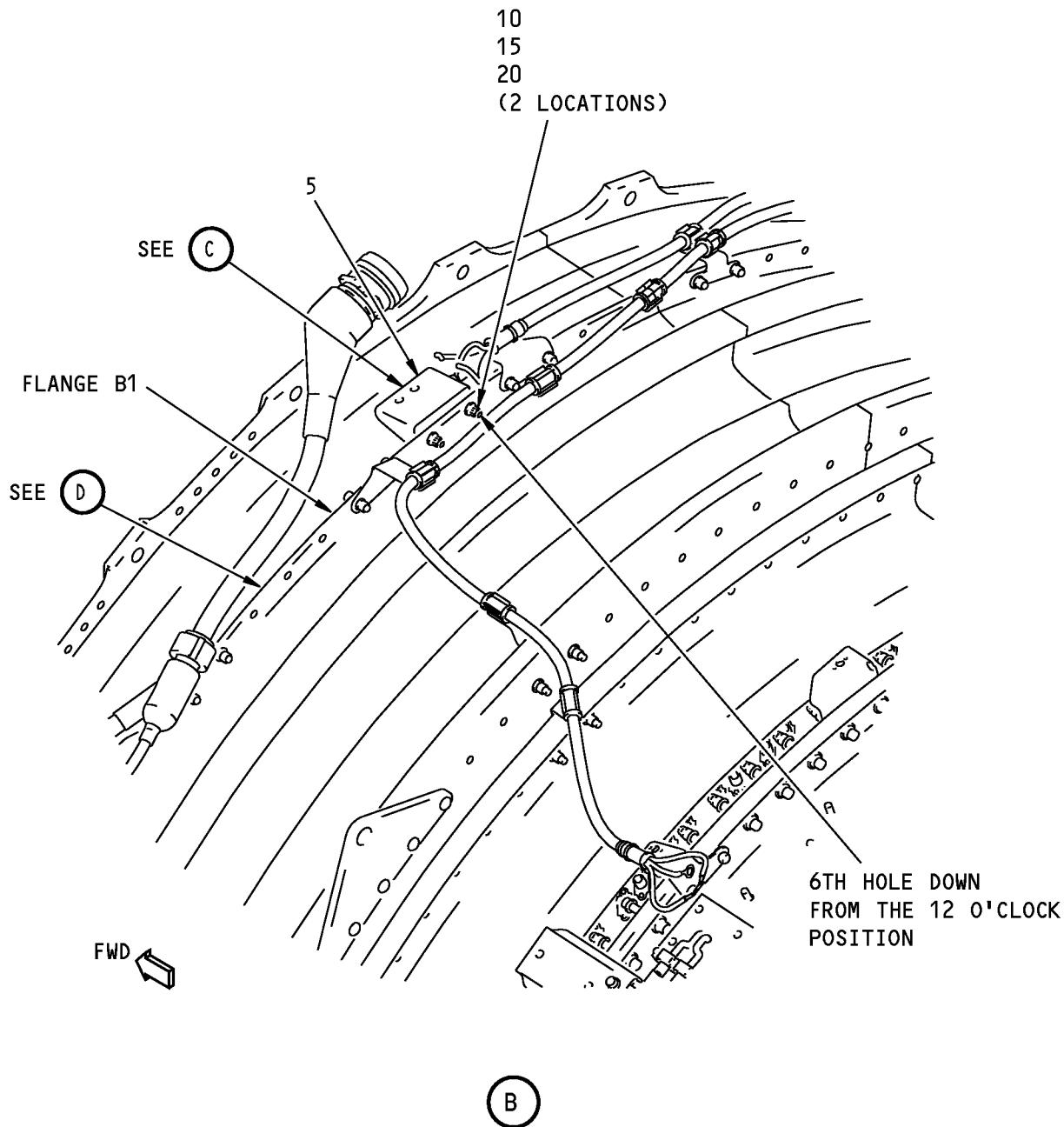
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P/P BUILDUP FIGURE 4-1

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P/P BUILDUP FIGURE 4-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
4-1		BRACKET INSTALLATION - UPPER LEFT SIDE FAN CASE (FIGURE 4-1, SHEET 2) CLEAN MATING SURFACES OF BRACKET ASSY (5) AND FLANGE B1 WITH alcohol, B00130 (C2). MAKE SURE YOU REMOVE ALL GREASE AND OTHER CONTAMINANTS. . BRACKET ASSY . ALCOHOL <u>NOTE:</u> DUE TO LIMITED ACCESS, IT IS RECOMMENDED ITEMS 50 THRU 65 BE INSTALLED PRIOR TO BRACKET (5) ATTACHMENT. ATTACH BRACKET ASSY (5) TO 6TH AND 7TH HOLE DOWN FROM 12 O'CLOCK ON FLANGE B1. USE BOLTS (10), WASHERS (15) AND NUT (20). . BOLT (FWD SIDE) . WASHER (UNDER NUT) . NUT TIGHTEN BOLTS (10) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS).				
5 C2	332A2920-229 B00130		FWD	FWD	CON	1 AR
10	BACB30ZF4-12					2
15	BACW10P393CB					2
20	AS3485-10					2

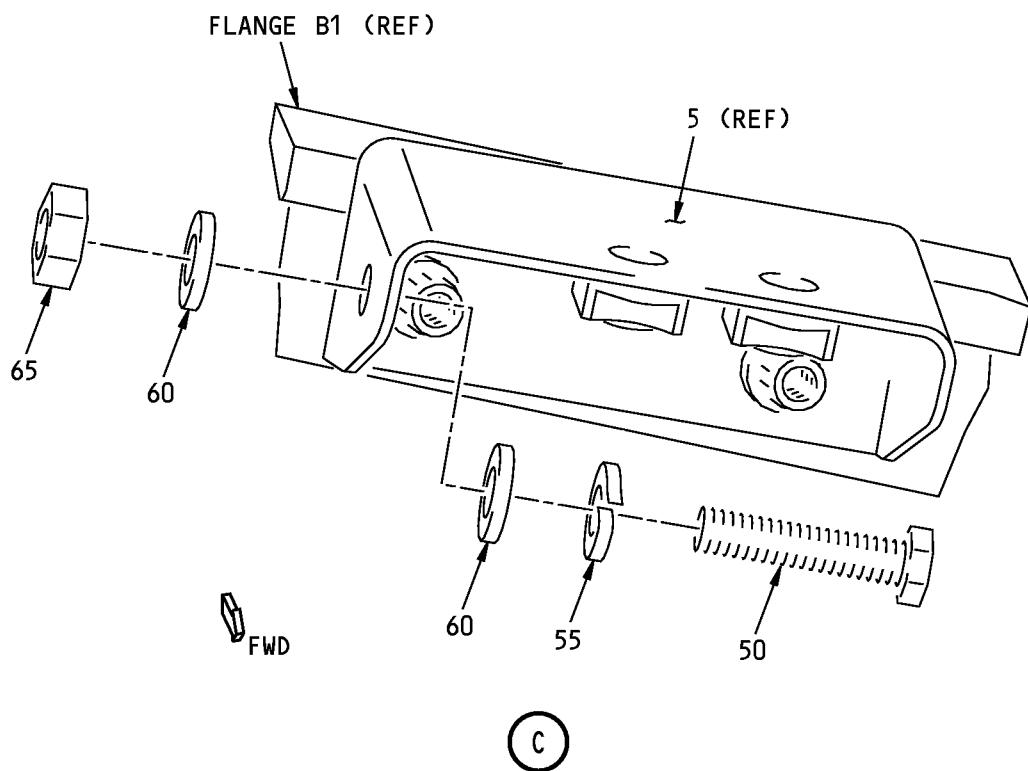
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P/P BUILDUP FIGURE 4-1

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POWERPLANT BUILDUP MANUAL

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Bracket Installation - Upper Left Side Fan Case
Figure 4-1 (Sheet 3)

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P/P BUILDUP FIGURE 4-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
4-1		BRACKET INSTALLATION - UPPER LEFT SIDE FAN CASE (FIGURE 4-1, SHEET 3) CLEAN SURFACES OF TOP BOLT HOLE ON BRACKET ASSY (5) WITH alcohol, B00130 (C2). MAKE SURE YOU REMOVE ALL GREASE AND OTHER CONTAMINANTS. . ALCOHOL				
C2	B00130	ON TOP HOLE OF BRACKET ASSY (5), ATTACH GROUNDING BOLT (50), LOCK WASHER (55), WASHERS (60) AND ELECTRICAL NUT (65). . SCREW . LOCK WASHER . WASHER . ELECTRICAL NUT		CON	AR	
50	BACS12HN4U12				1	
55	BACW10EC4M				1	
60	BACW10BP4APU				2	
65	MS35650-3254	TIGHTEN BOLT (50) TO 90-105 POUND-INCHES (10.2-11.9 NEWTON METERS).			1	

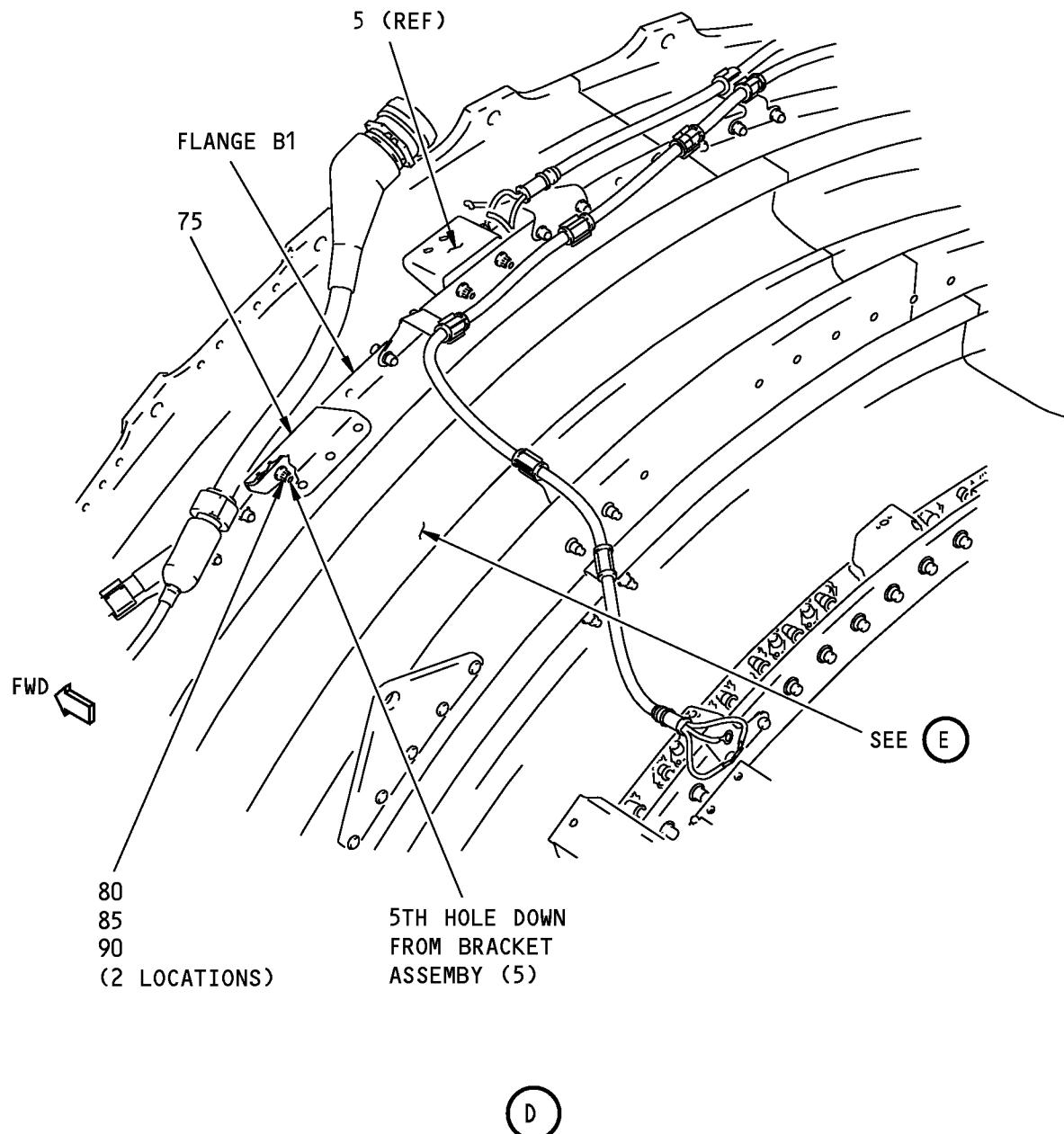
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P/P BUILDUP FIGURE 4-1

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POWERPLANT BUILDUP MANUAL

Bracket Installation - Upper Left Side Fan Case
Figure 4-1 (Sheet 4)

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P/P BUILDUP FIGURE 4-1

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737-600/700/800/900
POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
4-1		BRACKET INSTALLATION - UPPER LEFT SIDE FAN CASE (FIGURE 4-1, SHEET 4) ATTACH BRACKET (75) TO 4TH AND 5TH HOLES DOWN FROM BRACKET ASSY (5) ON FLANGE B1. USE BOLTS (80), WASHERS (85) AND NUTS (90). 75 332A2910-143 . BRACKET 80 BACB30ZF4-12 . BOLT (FWD SIDE) 85 BACW10P393CB . WASHER (UNDER BOLT) 90 AS3485-10 . NUT TIGHTEN BOLTS (80) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS).				
75	332A2910-143		AFT	AFT		1
80	BACB30ZF4-12					2
85	BACW10P393CB					2
90	AS3485-10					2

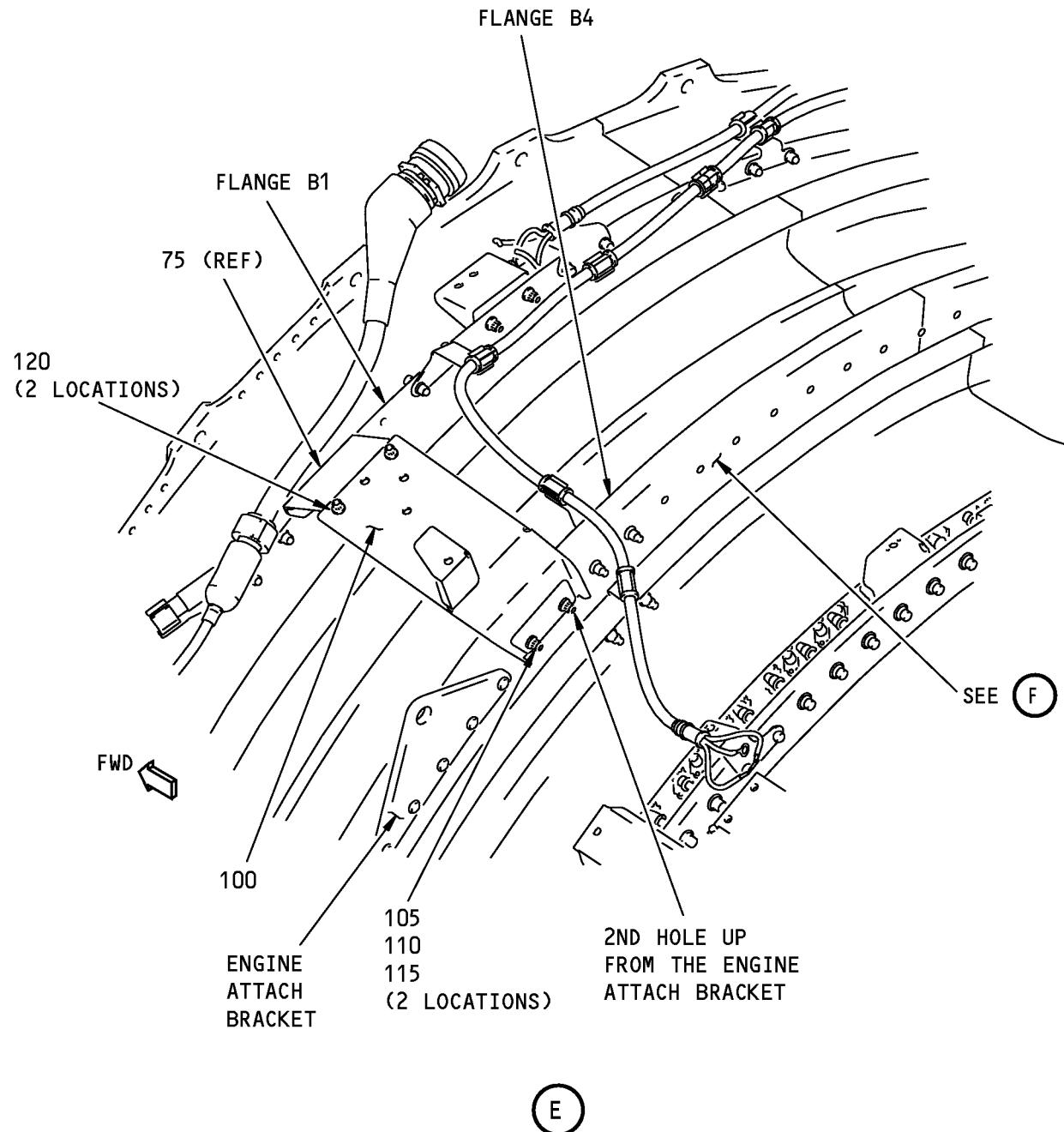
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P/P BUILDUP FIGURE 4-1

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POWERPLANT BUILDUP MANUAL

Bracket Installation - Upper Left Side Fan Case
Figure 4-1 (Sheet 5)

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P/P BUILDUP FIGURE 4-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
4-1		<p>BRACKET INSTALLATION - UPPER LEFT SIDE FAN CASE (FIGURE 4-1, SHEET 5)</p> <p>ATTACH BRACKET ASSY (100) TO 1ST AND 2ND HOLES UP FROM ENGINE ATTACH BRACKET ON FLANGE B4 ALIGNING HOLES ON FWD END WITH BRACKET (75). USE BOLTS (105), WASHERS (110) AND NUTS (115) ON FLANGE B4 AND BOLTS (120) ON BRACKET (75).</p> <p>NOTE: DO NOT INSTALL BOLT IN CENTER HOLE OF BRACKET ASSY (100). HOLE WILL BE USED TO ATTACH HYDRAULIC FILTER (REF HYDRAULIC PLUMBING INSTALLATION/Figure 21-1).</p> <p>100 332A2920-232 . BRKT ASSY 105 BACB30ZF4-12 . BOLT (FWD SIDE) 110 BACW10P393CB . WASHER (UNDER BOLT) 115 AS3485-10 . NUT 120 BACB30ZF4-06 . BOLT</p> <p>TIGHTEN BOLTS (105) AND (120) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS).</p>				
100	332A2920-232	. BRKT ASSY	AFT	FWD		1
105	BACB30ZF4-12	. BOLT (FWD SIDE)				2
110	BACW10P393CB	. WASHER (UNDER BOLT)				2
115	AS3485-10	. NUT				2
120	BACB30ZF4-06	. BOLT				2

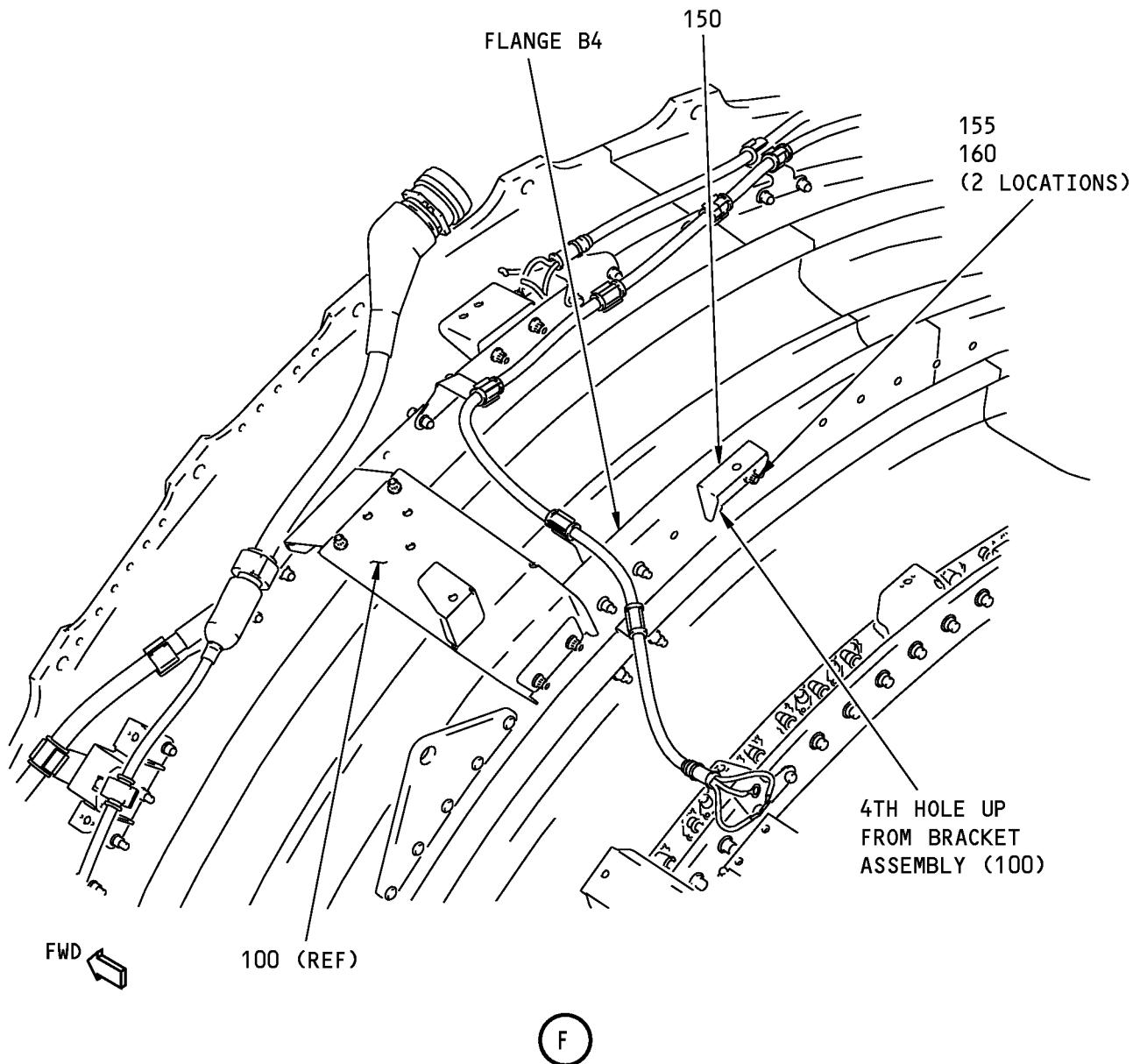
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P/P BUILDUP FIGURE 4-1

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POWERPLANT BUILDUP MANUAL

Bracket Installation - Upper Left Side Fan Case
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P/P BUILDUP FIGURE 4-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
4-1		BRACKET INSTALLATION - UPPER LEFT SIDE FAN CASE (FIGURE 4-1, SHEET 6) ATTACH BRACKET ASSY (150) TO 4TH AND 5TH HOLES UP FROM BRACKET ASSY (100) ON FLANGE B4. USE BOLTS (155) AND WASHERS (160). . BRACKET ASSY . BOLT (FWD SIDE) . WASHER (UNDER BOLT) TIGHTEN BOLTS (155) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS).				
150	332A2920-142		AFT	AFT		1
155	BACB30ZF4-12					2
160	BACW10P393CB					2

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P/P BUILDUP FIGURE 4-1

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POWERPLANT BUILDUP MANUAL

THIS SHEET NOT USED

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Bracket Installation - Upper Left Side Fan Case
Figure 4-1 (Sheet 7)

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P/P BUILDUP FIGURE 4-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
4-1		BRACKET INSTALLATION - UPPER LEFT SIDE FAN CASE (FIGURE 4-1, SHEET 7) THIS SHEET NOT USED		

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P/P BUILDUP FIGURE 4-1

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THIS SHEET NOT USED

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Bracket Installation - Upper Left Side Fan Case
Figure 4-1 (Sheet 8)

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P/P BUILDUP FIGURE 4-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
4-1		BRACKET INSTALLATION - UPPER LEFT SIDE FAN CASE (FIGURE 4-1, SHEET 8) THIS SHEET NOT USED		

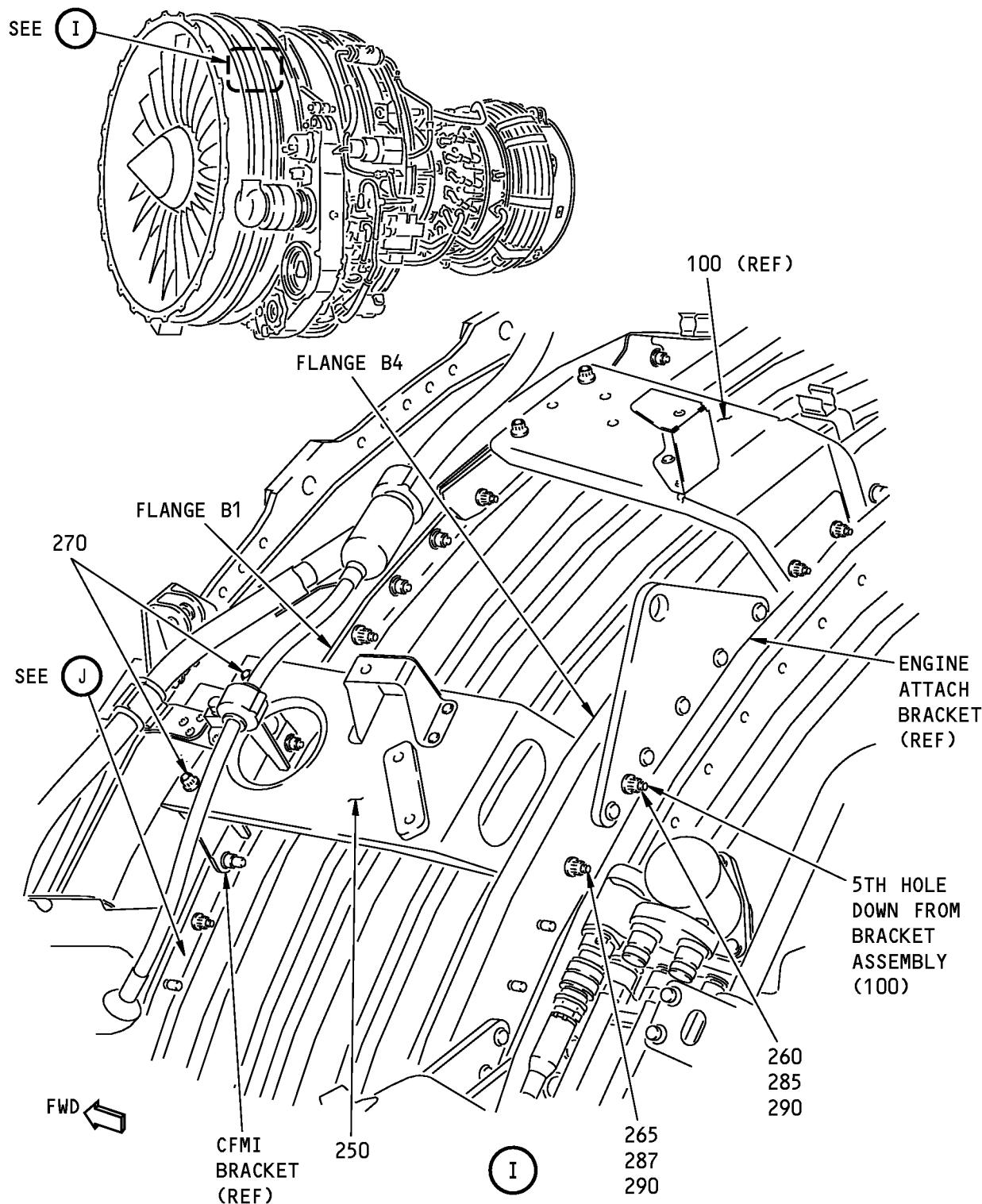
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P/P BUILDUP FIGURE 4-1

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POWERPLANT BUILDUP MANUAL

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Bracket Installation - Upper Left Side Fan Case
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P/P BUILDUP FIGURE 4-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
4-1		<p>BRACKET INSTALLATION - UPPER LEFT SIDE FAN CASE (FIGURE 4-1, SHEET 9)</p> <p>ATTACH BRACKET ASSY (250) OR (255) TO 5TH AND 7TH HOLES DOWN FROM BRACKET ASSY (100) ON FLANGE B4, ALIGNING FWD HOLES WITH CFMI BRACKET ON FLANGE B1. USE BOLTS (260) AND (265), WASHERS (285, 287) AND NUTS (290) ON FLANGE B4 AND BOLTS (270) ON CFMI BRACKET ON FLANGE B1.</p> <p>IF BRACKET ASSY (255) IS USED, INSTALL SPACER (275) ON UPR HOLE AND SPACER (280) ON LWR HOLE.</p>				
250	332A2920-157	. BRACKET ASSY	FWD	FWD		1
250	332A2920-131	. BRACKET ASSY (OPTIONAL)	FWD	FWD	OPT	-
255	332A2920-117	. BRACKET ASSY (OPTIONAL) * ^{[3]*[4]}	FWD	FWD	OPT	-
260	BACB30ZF4-29	. BOLT (FWD SIDE) (UPPER HOLE)				1
265	BACB30ZF4-26	. BOLT (FWD SIDE) (LOWER HOLE)				1
270	BACB30ZF4-08	. BOLT				2
275	NAS1057W4A-064	. SPACER (UPR HOLE) (1 REQD) * ^{[3]*[4]}			OPT	-
280	NAS1057W4A-080	. SPACER (LWR HOLE) (1 REQD) * ^{[3]*[4]}			OPT	-
285	NAS1149C0432R	. WASHER (UNDER NUT)				1
287	BACW10P393CB	. WASHER (UNDER NUT)				1
290	AS3485-10	. NUT				2
		TIGHTEN BOLTS (260), (265) AND (270) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS).				
		* ^[3] BRACKET ASSY (255) WITH SPACERS (275) AND (280) IS OPTIONAL TO BRACKET ASSY (250)				
		* ^[4] ITEM NOT ILLUSTRATED				

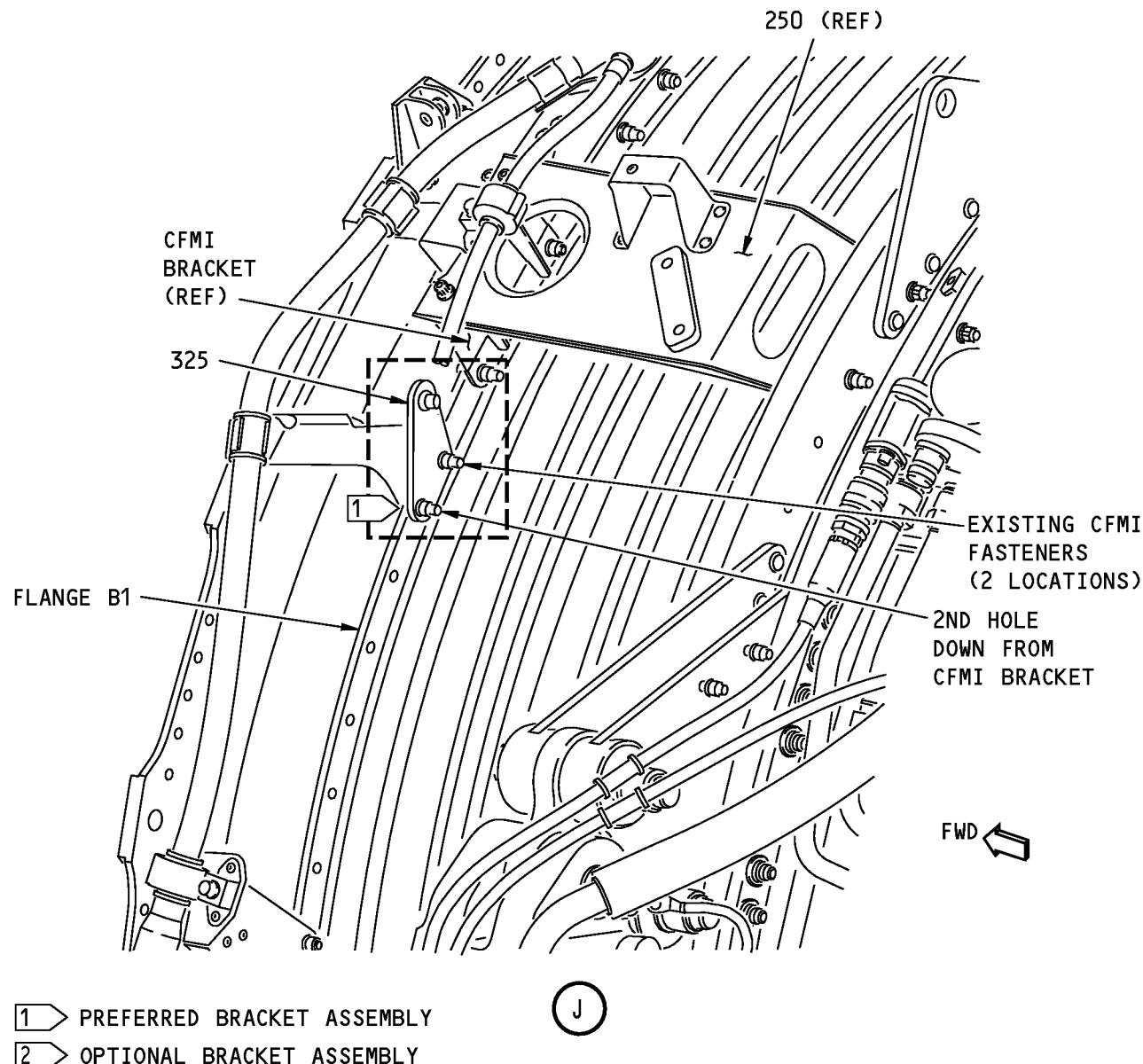
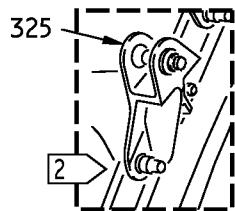
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P/P BUILDUP FIGURE 4-1

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POWERPLANT BUILDUP MANUAL

Bracket Installation - Upper Left Side Fan Case
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P/P BUILDUP FIGURE 4-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
4-1		<p>BRACKET INSTALLATION - UPPER LEFT SIDE FAN CASE (FIGURE 4-1, SHEET 10)</p> <p>REMOVE EXISTING CFMI FASTENERS FROM 1ST AND 2ND HOLES DOWN FROM CFMI BRACKET ON FLANGE B1.</p> <p>ATTACH BRACKET ASSY (325) USING EXISTING CFMI FASTENERS.</p>				
325	332A2920-178	. BRACKET ASSY	AFT			1
325	332A2930-30	. BRKT ASSY (OPTIONAL TO 332A2920-178)	AFT		OPT	-
		TIGHTEN EXISTING CFMI FASTENERS TO 100-112 POUND-INCHES (11.3-12.7 NEWTON METERS).				

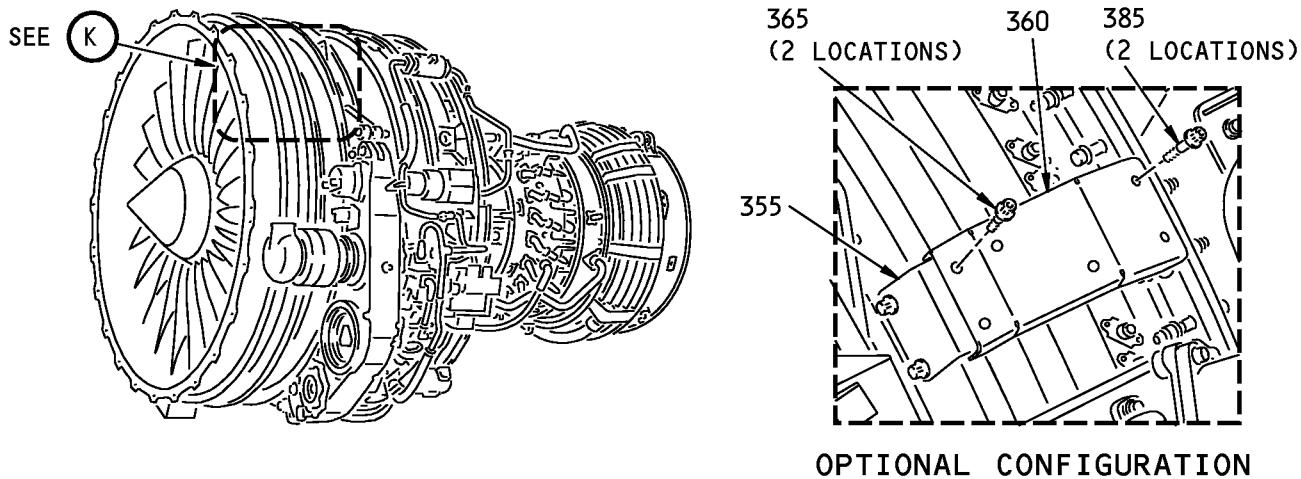
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P/P BUILDUP FIGURE 4-1

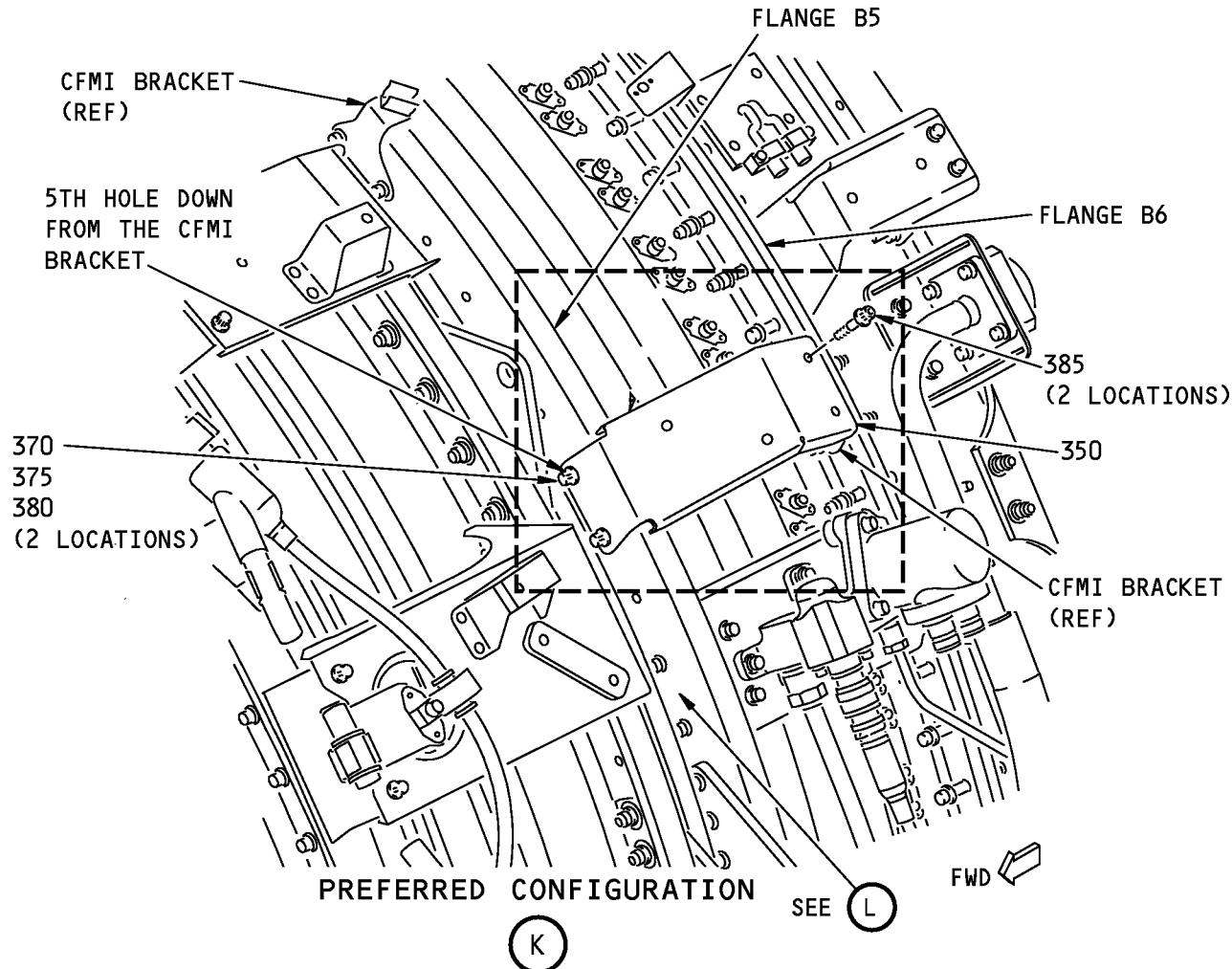
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POWERPLANT BUILDUP MANUAL

OPTIONAL CONFIGURATION

Bracket Installation - Upper Left Side Fan Case
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P/P BUILDUP FIGURE 4-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
4-1		<p>BRACKET INSTALLATION - UPPER LEFT SIDE FAN CASE (FIGURE 4-1, SHEET 11)</p> <p>PREFERRED CONFIGURATION:</p> <p>ATTACH BRACKET ASSY (350) TO 5TH AND 6TH HOLES DOWN FROM CFMI BRACKET ON FLANGE B5 USING BOLTS (370), WASHERS (375) AND NUTS (380) AND TO CFMI BRACKET ON FLANGE B6 USING BOLTS (385).</p> <p>OPTIONAL CONFIGURATION:</p> <p>ATTACH BRACKET (355) TO BRACKET ASSY (360) USING BOLTS (365). TIGHTEN BOLTS TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS).</p> <p>ATTACH BRACKET (355) TO 5TH AND 6TH HOLES DOWN FROM CFMI BRACKET ON FLANGE B5 USING BOLTS (370), WASHERS (375) AND NUTS (380).</p> <p>ATTACH BRACKET (360) TO CFMI BRACKET ON FLANGE B6 USING BOLTS (385).</p> <p>. BRACKET ASSY</p> <p>. BRACKET (1 REQD)</p> <p>. BRACKET ASSY (1 REQD)</p> <p>. BOLT (2 REQD)</p> <p>. BOLT (FWD SIDE)</p> <p>. WASHER (UNDER NUT)</p> <p>. NUT</p> <p>. BOLT</p> <p>TIGHTEN BOLTS (370, 385) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS).</p>				
350	332A2920-197		FWD	AFT		1
355	332A2910-87		FWD	AFT	OPT	-
360	332A2920-115				OPT	-
365	BACB30ZF4-06				OPT	-
370	BACB30ZF4-14					2
375	BACW10P393CB					2
380	AS3485-10					2
385	BACB30ZF4-06					2

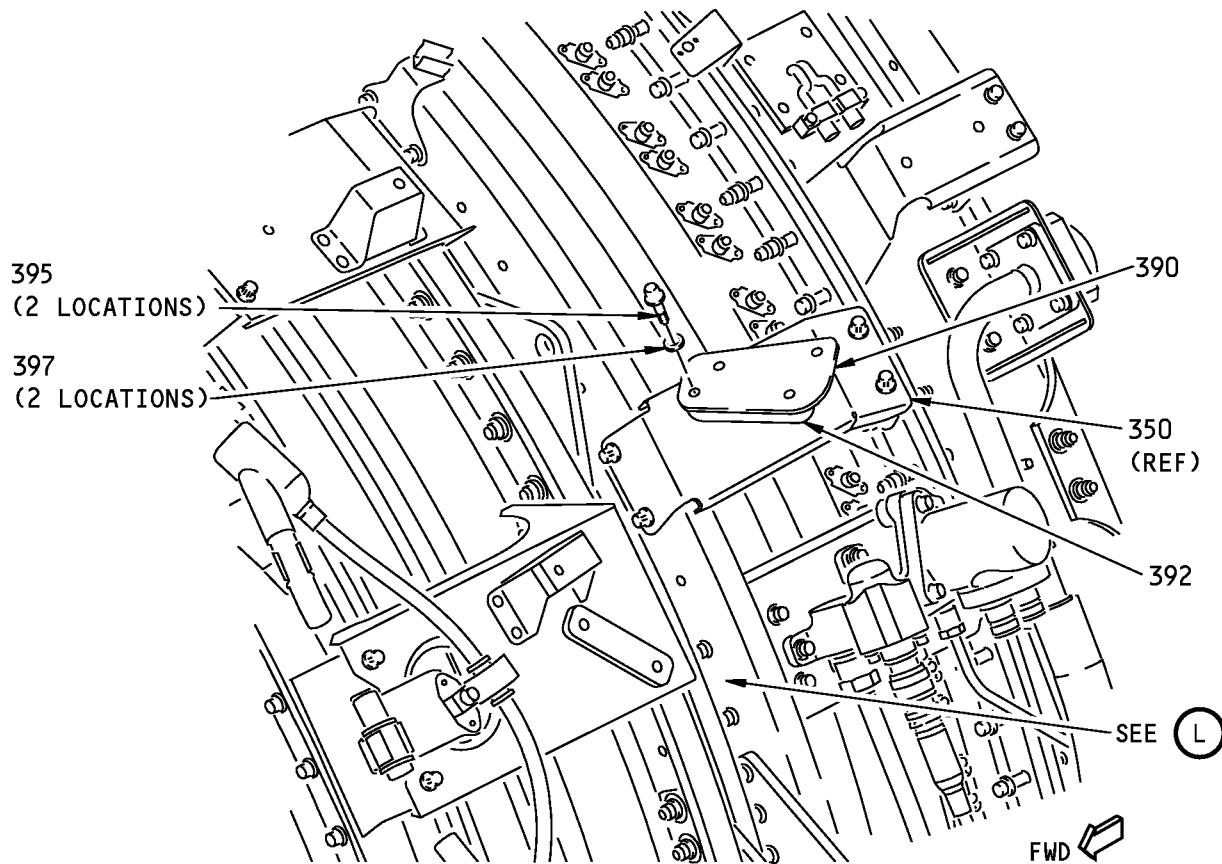
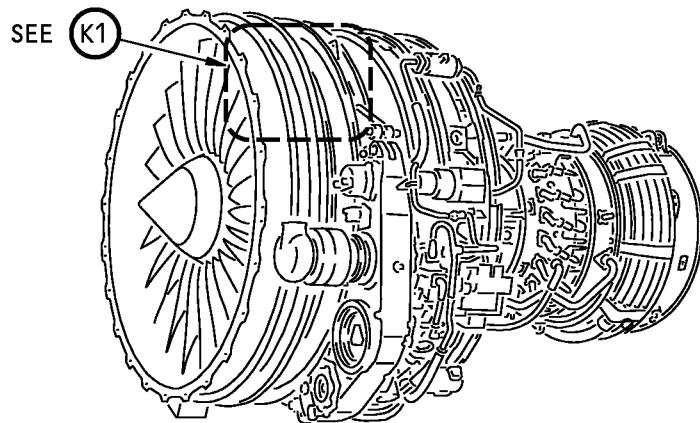
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P/P BUILDUP FIGURE 4-1

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POWERPLANT BUILDUP MANUAL

PREFERRED CONFIGURATION

K1

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Bracket Installation - Upper Left Side Fan Case
Figure 4-1 (Sheet 12)

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P/P BUILDUP FIGURE 4-1
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ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
4-1		<p>BRACKET INSTALLATION - UPPER LEFT SIDE FAN CASE (FIGURE 4-1, SHEET 12)</p> <p>PREFERRED CONFIGURATION</p> <p>APPLY primer, C00259 (C8) OR adhesive, A01076 (C9) TO THE SHANKS OF BOLTS (395). ATTACH BRACKET ASSY (390) AND BRACKET DETAIL (392) USING BOLTS (395) AND WASHERS (397).</p>				
390	332A2910-163	. BRACKET ASSY	FWD	AFT		1
392	332A2930-98	. BRACKET DETAIL	FWD	AFT		1
395	BACB30NM4K11	. BOLT	FWD	AFT		2
397	NAS1149C0432R	. WASHER	FWD	AFT		2
C8	C00259	. PRIMER			CON	AR
C9	A01076	. ADHESIVE			CON	AR
		TIGHTEN BOLTS (395) TO 73-78 POUND-INCHES (8.2-8.8 NEWTON METERS).				

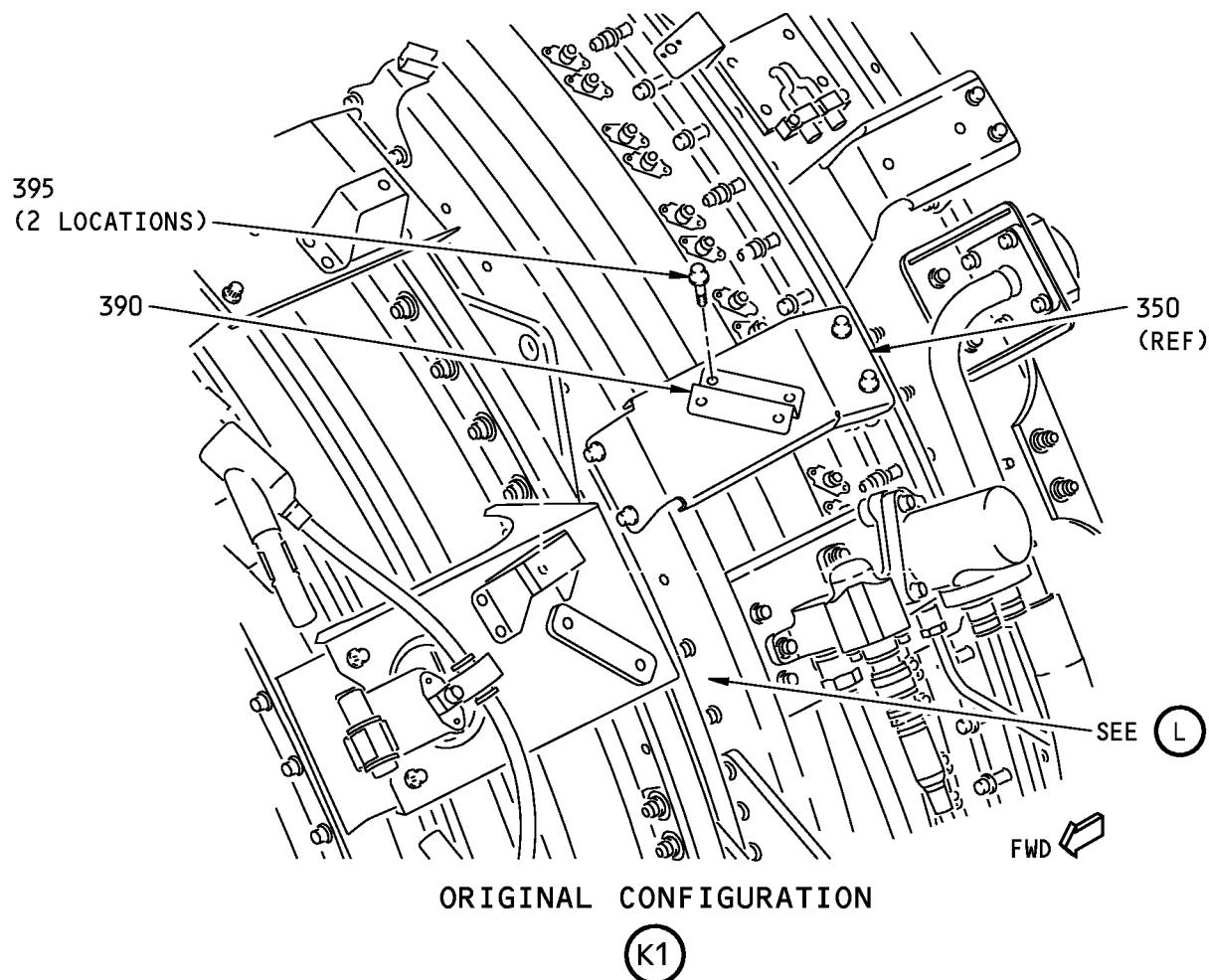
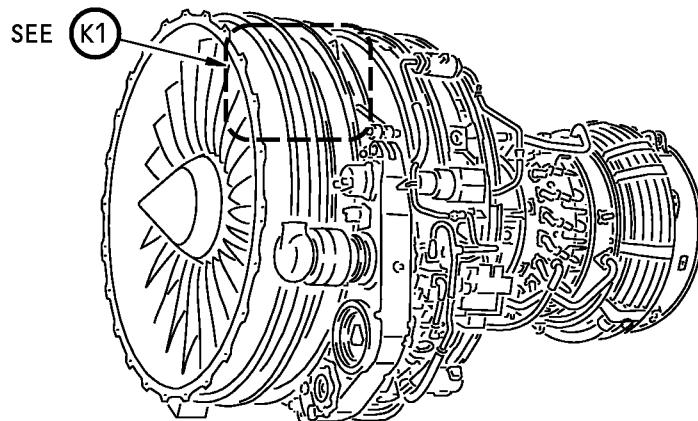
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P/P BUILDUP FIGURE 4-1

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POWERPLANT BUILDUP MANUAL

1732670 S0000313567_V3

Bracket Installation - Upper Left Side Fan Case
Figure 4-1 (Sheet 13)

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P/P BUILDUP FIGURE 4-1

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737-600/700/800/900
POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
4-1 390 395	332A2920-236 BACB30ZF4-08	<p>BRACKET INSTALLATION - UPPER LEFT SIDE FAN CASE (FIGURE 4-1, SHEET 13)</p> <p><u>ORIGINAL CONFIGURATION</u></p> <p>ATTACH BRACKET ASSY (390) USING BOLTS (395).</p> <p>. BRACKET ASSY*^[5] *^[14] . BOLT (QTY 2)</p> <p>TIGHTEN BOLTS (395) TO 78-82 POUND-INCHES (8.8-9.3 NEWTON METERS).</p> <p>*[5] ENGINES WITH IMPROVED HYDRAULIC PRESSURE HOSE SUPPORT BRACKETS (POST SB 737-29-1111).</p> <p>*[14] BRACKET ASSY 332A2920-236 (390) REPLACED BY BRACKET ASSY 332A2910-163 (390) TOGETHER WITH BRACKET DETAIL (392).</p>	FWD FWD	AFT AFT	LTD LTD	- -

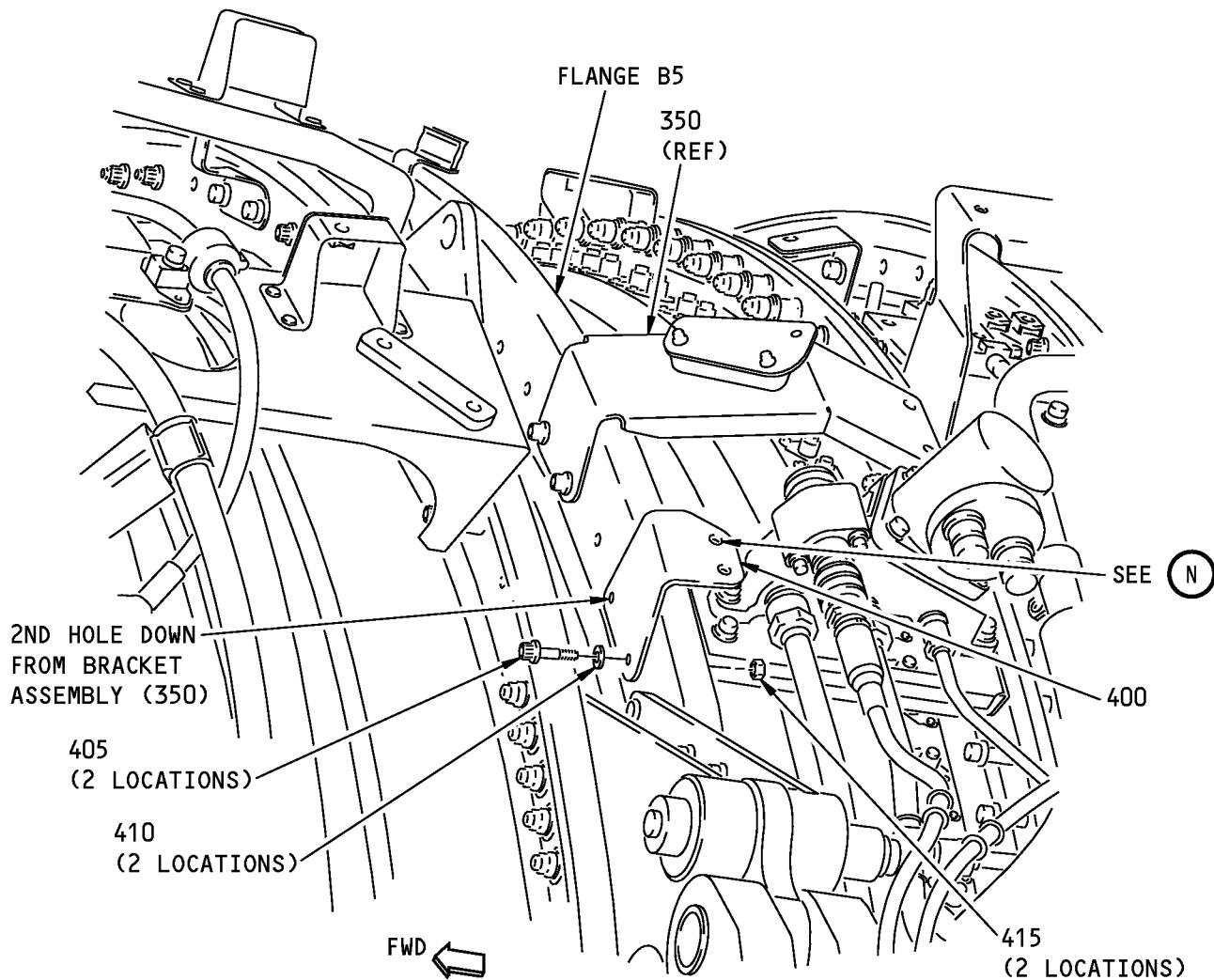
71-00-02

P/P BUILDUP FIGURE 4-1

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737-600/700/800/900
POWERPLANT BUILDUP MANUAL

2339292 S0000533011_V1

Bracket Installation - Upper Left Side Fan Case
Figure 4-1 (Sheet 14)

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P/P BUILDUP FIGURE 4-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
4-1		<p>BRACKET INSTALLATION - UPPER LEFT SIDE FAN CASE (FIGURE 4-1, SHEET 14)</p> <p>PREFERRED CONFIGURATION</p> <p>ON FLANGE B5 REMOVE EXISTING CFMI FASTENERS FROM 2ND AND 3RD HOLES DOWN FROM BRACKET ASSY (350) OR BRACKET (355) AND DISCARD.</p> <p>APPLY primer, C00259 (C8) OR adhesive, A01076 (C9) TO THE SHANKS OF BOLTS (405). ATTACH BRACKET ASSY (400) USING BOLTS (405), WASHERS (410) AND NUTS (415).</p> <p>400 332A2910-159 . BRACKET ASSY FWD AFT 1</p> <p>405 BACB30ZF4-26 . BOLT FWD AFT 2</p> <p>410 BACW10P393CB . WASHER FWD AFT 2</p> <p>415 AS3485-10 . NUT FWD AFT 2</p> <p>C8 C00259 . PRIMER CON AR</p> <p>C9 A01076 . ADHESIVE CON AR</p> <p>TIGHTEN BOLTS (405) TO 80-90 POUND-INCHES (9.0-10.2 NEWTON METERS).</p>				

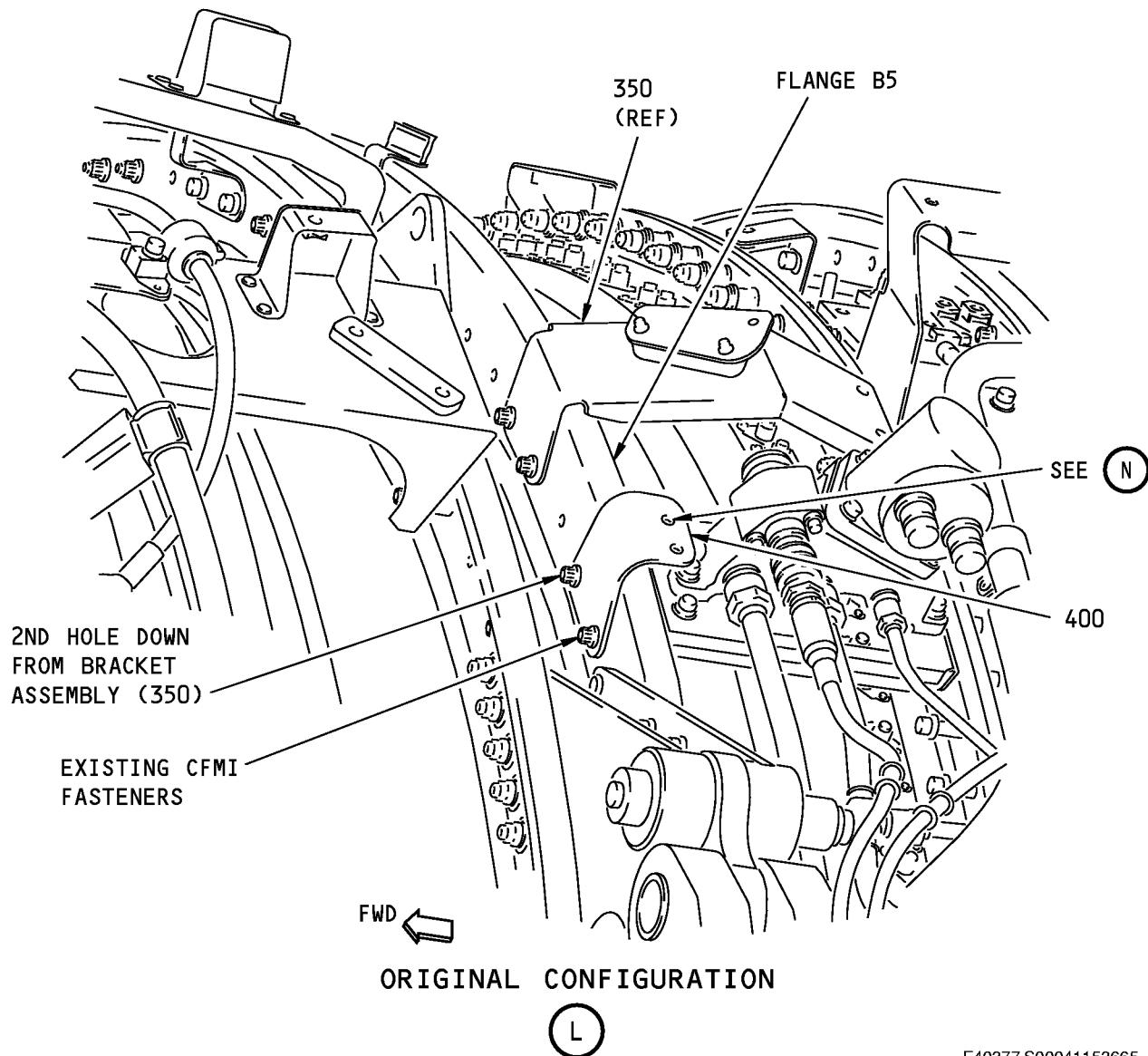
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P/P BUILDUP FIGURE 4-1

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POWERPLANT BUILDUP MANUAL

F40377 S00041153665_V5

Bracket Installation - Upper Left Side Fan Case
Figure 4-1 (Sheet 15)

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P/P BUILDUP FIGURE 4-1

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737-600/700/800/900
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ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
4-1 400	332A2910-147	<p>BRACKET INSTALLATION - UPPER LEFT SIDE FAN CASE (FIGURE 4-1, SHEET 15)</p> <p><u>ORIGINAL CONFIGURATION</u></p> <p>ON FLANGE B5 REMOVE EXISTING CFMI FASTENERS FROM 2ND AND 3RD HOLES DOWN FROM BRACKET ASSY (350) OR BRACKET (355). DISCARD THE RED CFMI SPACERS.</p> <p>ATTACH BRACKET ASSY (400) USING EXISTING CFMI FASTENERS.</p> <p>. BRKT (REPLACED BY 332A2910-159)</p> <p>TIGHTEN EXISTING CFMI FASTENERS TO 100-112 POUND-INCHES (11.3-12.7 NEWTON METERS).</p>	FWD	AFT	LTD	-

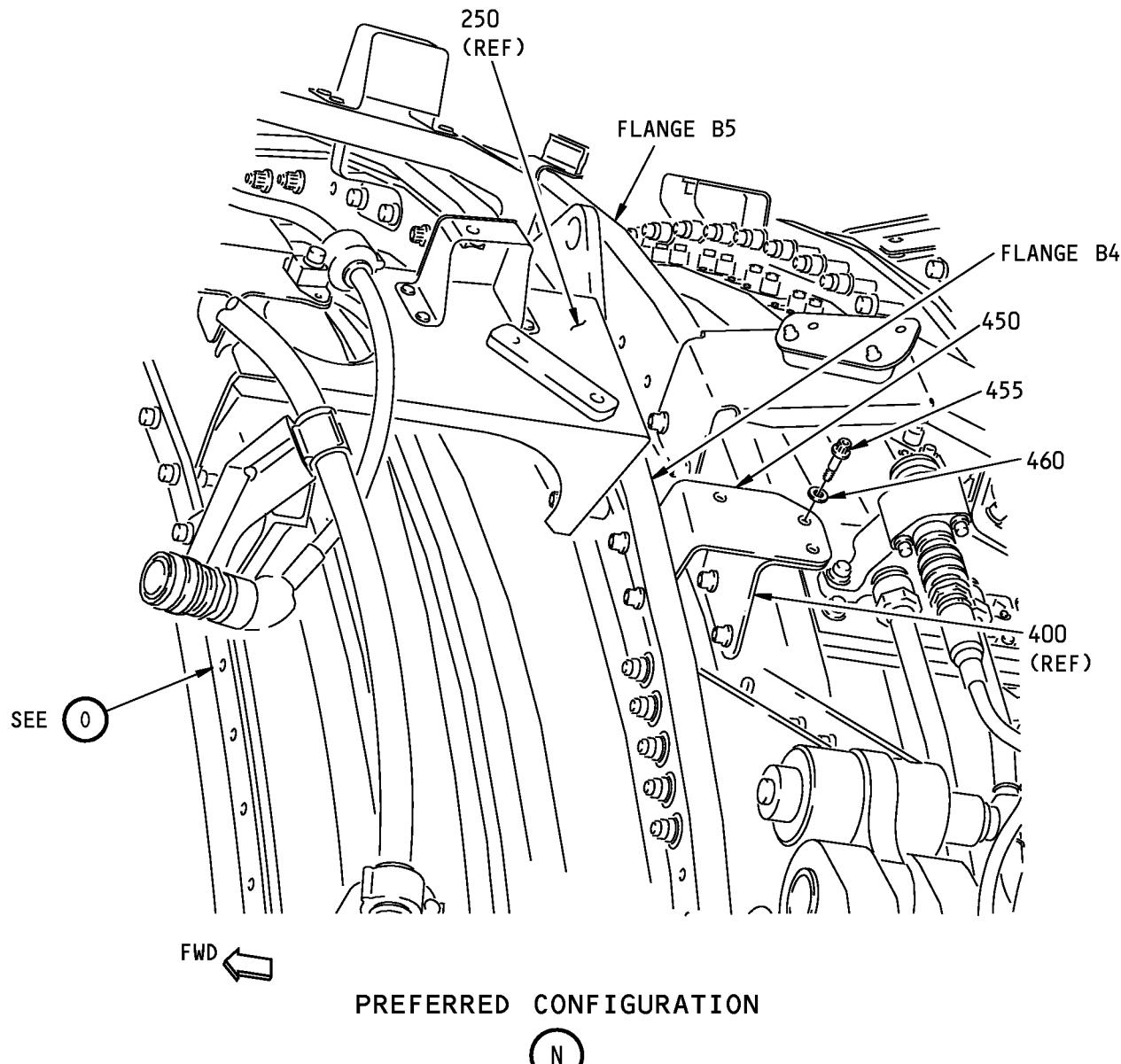
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P/P BUILDUP FIGURE 4-1

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POWERPLANT BUILDUP MANUAL

2339295 S0000533012_V1

Bracket Installation - Upper Left Side Fan Case
Figure 4-1 (Sheet 16)

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P/P BUILDUP FIGURE 4-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
4-1		<p>BRACKET INSTALLATION - UPPER LEFT SIDE FAN CASE (FIGURE 4-1, SHEET 16)</p> <p>PREFERRED CONFIGURATION</p> <p>ATTACH BRACKET ASSY (450) TO BRACKET ASSY (400) WITH BOLT (455) AND WASHER (460) AT UPPER LOCATION ONLY. TIGHTEN BOLT TO 78-82 POUND-INCHES (8.0-9.0 NEWTON METERS)</p> <p>NOTE: LOWER HOLE WILL BE USED TO ATTACH HYD PRESSURE HOSE (REF HYDRAULIC PLUMBING INSTALLATION/Figure 21-1). BRACKET (450) FASTENERS TO FLANGE B4 ARE INSTALLED LATER.</p>				
450	332A2910-161	. BRACKET ASSY	AFT	AFT		1
455	BACB30NM4K3	. BOLT				1
460	NAS1149C0432R	. WASHER				1

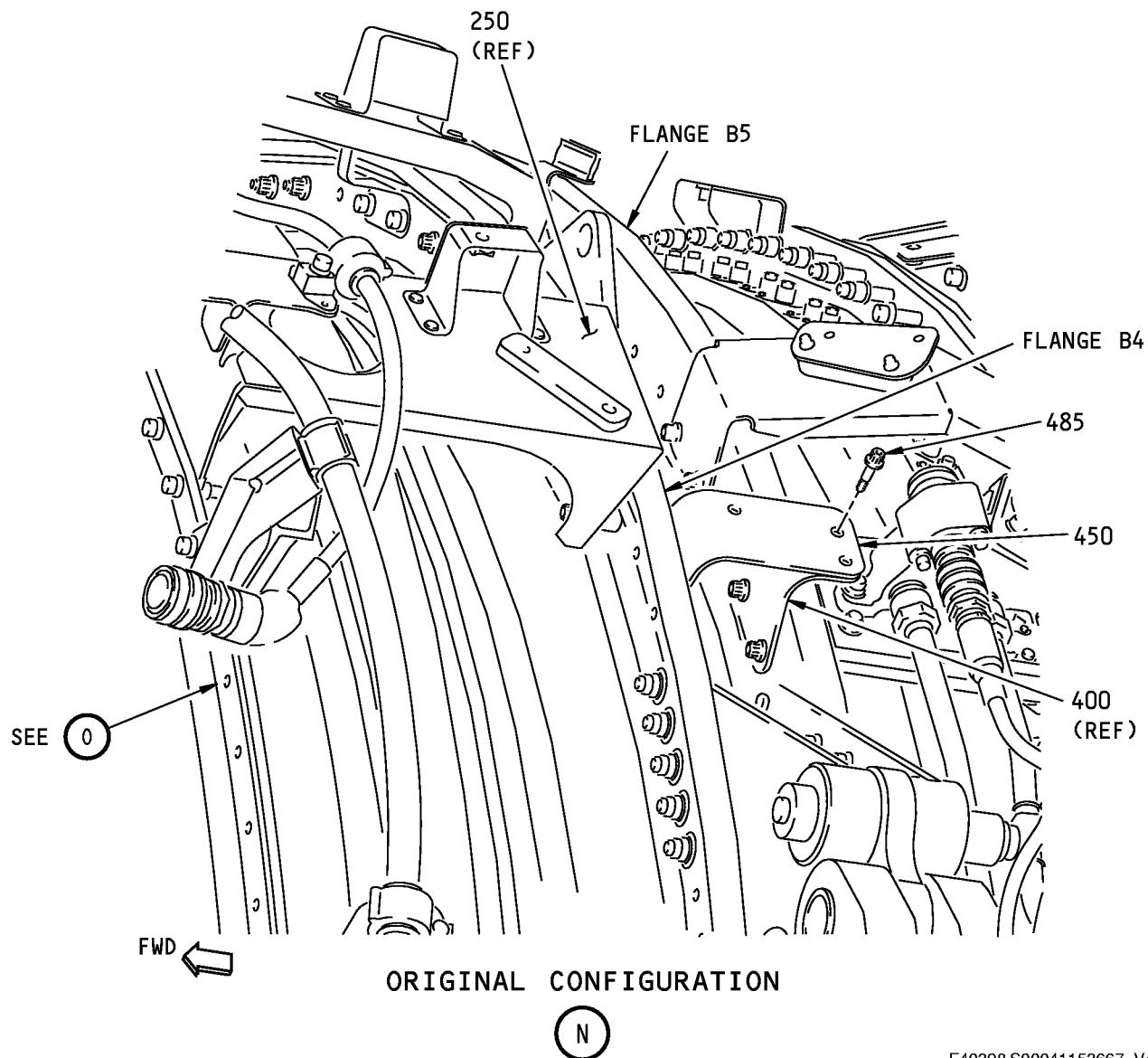
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P/P BUILDUP FIGURE 4-1

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Bracket Installation - Upper Left Side Fan Case
Figure 4-1 (Sheet 17)

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P/P BUILDUP FIGURE 4-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
4-1		<p>BRACKET INSTALLATION - UPPER LEFT SIDE FAN CASE (FIGURE 4-1, SHEET 17)</p> <p><u>ORIGINAL CONFIGURATION</u></p> <p>ATTACH BRACKET ASSY (450) TO BRACKET ASSY (400) WITH BOLT (485) AT UPPER LOCATION ONLY. TIGHTEN BOLT TO 70-80 POUND-INCHES (8.0-9.0 NEWTON METERS)</p> <p>NOTE: LOWER HOLE WILL BE USED TO ATTACH HYD PRESSURE HOSE (REF HYDRAULIC PLUMBING INSTALLATION/Figure 21-1). BRACKET (450) FASTENERS TO FLANGE B4 ARE INSTALLED LATER.</p>				
450	332A2910-149	. BRACKET ASSY (REPLACED BY 332A2910-161)	AFT	AFT	LTD	-
485	BACB30ZF4-08	. BOLT (QTY 1)			LTD	-

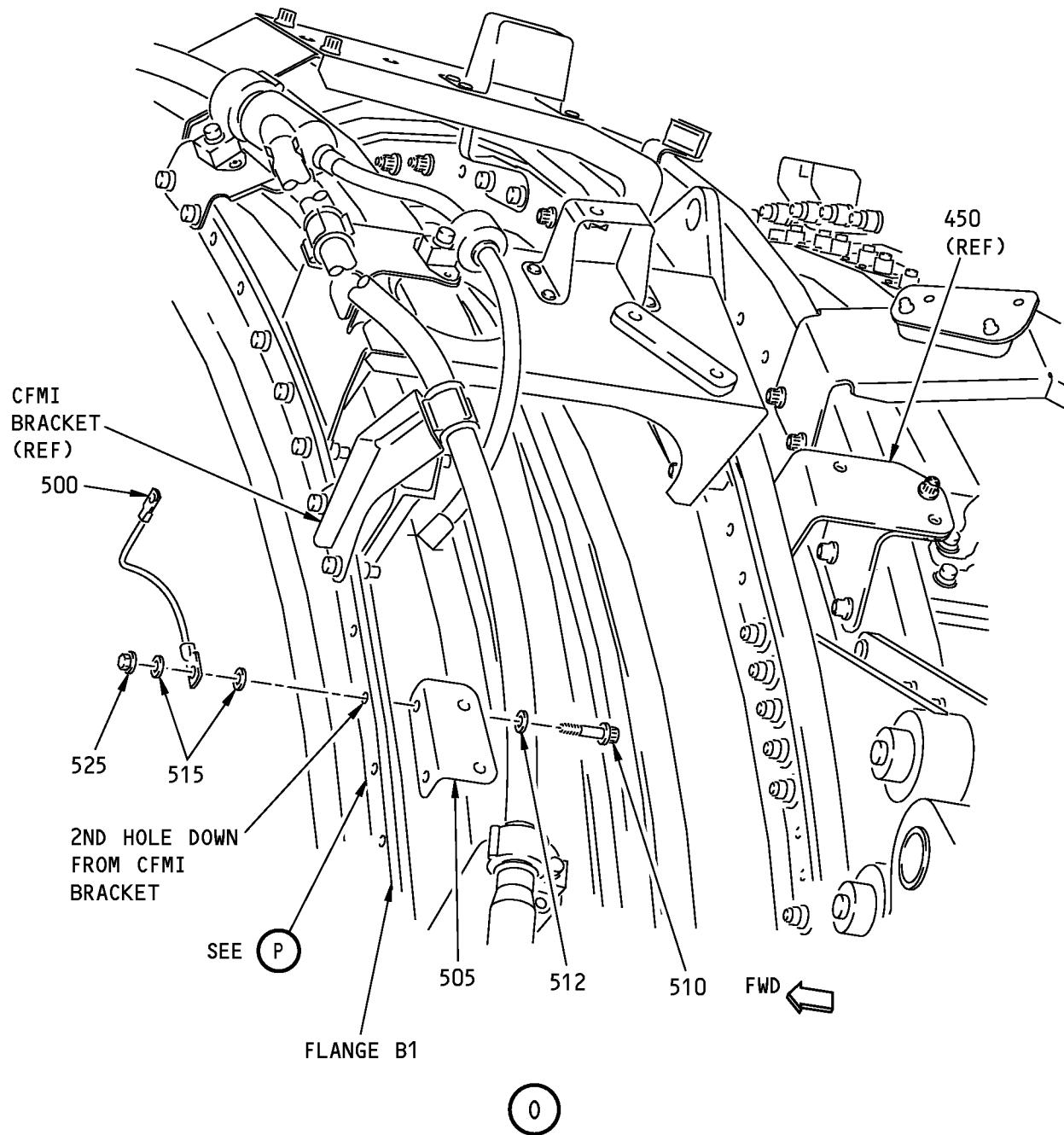
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P/P BUILDUP FIGURE 4-1

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737-600/700/800/900
POWERPLANT BUILDUP MANUAL

F40417 S00041153668_V4

Bracket Installation - Upper Left Side Fan Case
Figure 4-1 (Sheet 18)

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P/P BUILDUP FIGURE 4-1

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737-600/700/800/900
POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
4-1		BRACKET INSTALLATION - UPPER LEFT SIDE FAN CASE (FIGURE 4-1, SHEET 18) CLEAN MATING SURFACES OF BONDING JUMPER (500) AND 2ND HOLE DOWN FROM CFMI BRKT ON FLANGE B1 WITH alcohol, B00130 (C2). MAKE SURE YOU REMOVE ALL GREASE AND OTHER CONTAMINANTS. . BONDING JUMPER . ALCOHOL POSITION BRACKET ASSY (505) ON 2ND AND 3RD HOLE DOWN FROM CFMI BRKT. AT UPPER HOLE, LOOSELY ATTACH BONDING JUMPER (500) WITH BOLT (510), WASHERS (512, 515) AND NUT (525) (LOWER BOLT WILL BE ATTACHED LATER). <u>NOTE:</u> 3RD HOLE DOWN IS SHARED WITH BRACKET ASSY (550). <u>NOTE:</u> UPPER END OF BONDING JUMPER (500) IS ATTACHED IN STARTER VALVE AND DUCT INSTALLATION/Figure 25-1.				
500 C2	BACJ40AC54-7 B00130				CON	1 AR
505	332A2910-41	. BRACKET ASSY				1
510	BACB30ZF4-12	. BOLT (AFT SIDE) (UPPER HOLE)				1
512	BACW10P393CB	. WASHER (UNDER BOLT HEAD)				1
515	NAS1149D0416H	. WASHER				2
525	BACN10YR4CD	. NUT	AFT	AFT		1

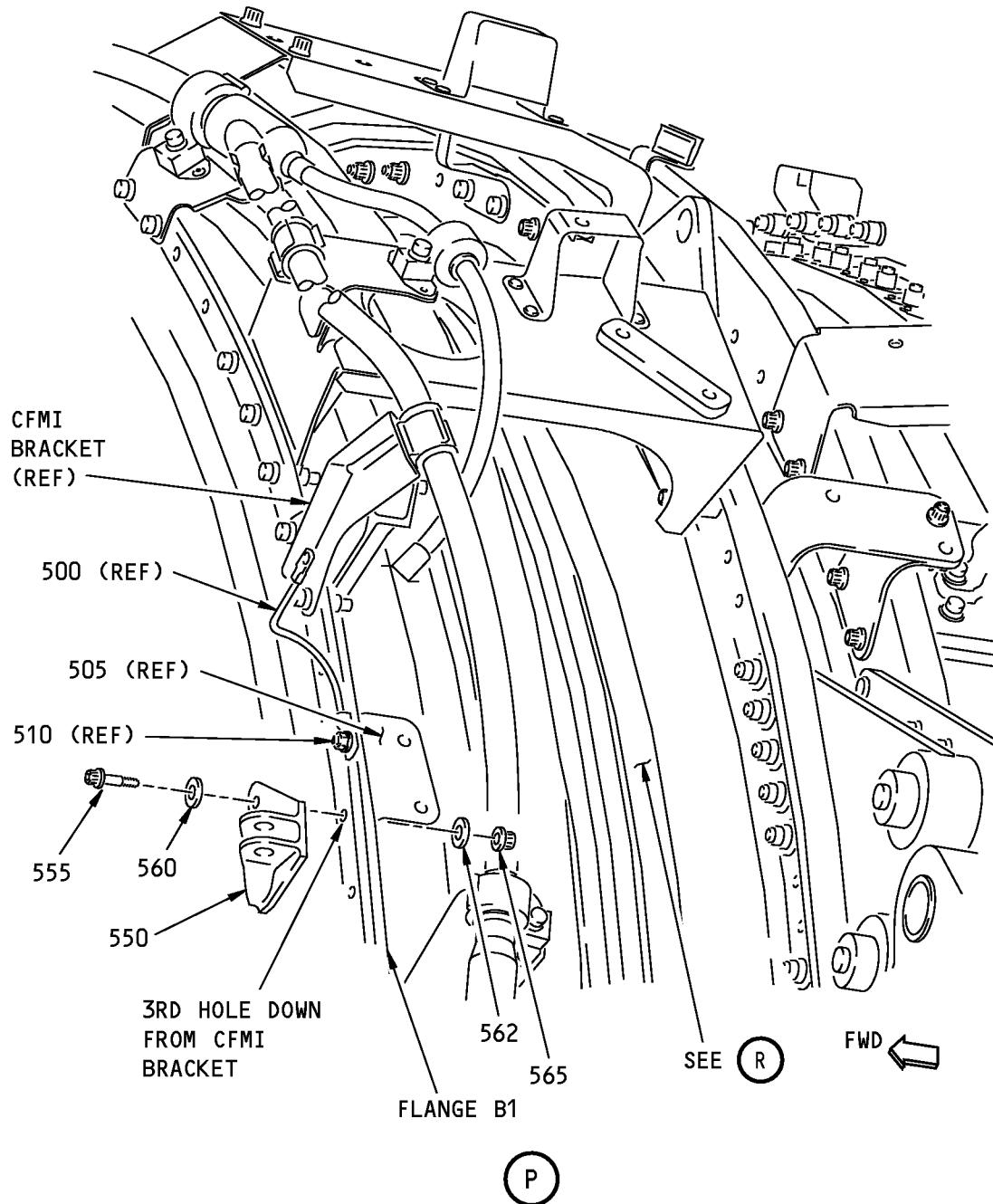
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P/P BUILDUP FIGURE 4-1

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737-600/700/800/900
POWERPLANT BUILDUP MANUAL

2042232 S0000412902_V1

Bracket Installation - Upper Left Side Fan Case
Figure 4-1 (Sheet 19)

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P/P BUILDUP FIGURE 4-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
4-1		<p>BRACKET INSTALLATION - UPPER LEFT SIDE FAN CASE (FIGURE 4-1, SHEET 19)</p> <p>LOOSELY ATTACH BRACKET ASSY (550) TO 3RD HOLE DOWN FROM CFMI BRKT. USE BOLT (555), WASHERS (560, 562) AND NUT (565) AT UPPER LOCATION ONLY (LOWER HOLE WILL BE ATTACHED LATER).</p> <p>NOTE: 3RD HOLE DOWN IS SHARED WITH BRACKET ASSY (505).</p> <p>550 332A2930-99 . BRACKET ASSY FWD 1</p> <p>550 332A2930-85 . BRACKET ASSY (REPLACED BY 332A2930-99) FWD LTD -</p> <p>550 332A2930-33 . BRKT ASSY (OPTIONAL TO 332A2930-85) FWD OPT -</p> <p>555 BACB30ZF4-16 . BOLT (FWD SIDE) 1</p> <p>560 BACW10BP4ACU . WASHER (CSK) (UNDER BOLT HEAD) 1</p> <p>562 BACW10P393CB . WASHER (UNDER NUT) 1</p> <p>565 AS3485-10 . NUT 1</p> <p>WHILE ALIGNING LOWER HOLE ON BRACKET ASSY (550), TIGHTEN BOLTS (510) AND (555) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS).</p> <p>APPLY FILLET SEAL OF sealant, A00803 (C4) OR sealant, A50096 (C5) OR adhesive, A00027 (C6) AROUND JUMPER (500) AND BOLT (510). IF sealant, A00803 (C4) IS USED, APPLY Dapco No. 1-100 primer, C00944 (C3) BEFORE SEALANT APPLICATION.</p> <p>C3 C00944 . DAPCO NO. 1-100 PRIMER CON AR</p> <p>C4 A00803 . SEALANT CON AR</p> <p>C5 A50096 . SEALANT CON AR</p> <p>C6 A00027 . ADHESIVE CON AR</p>				

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P/P BUILDUP FIGURE 4-1

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POWERPLANT BUILDUP MANUAL

THIS SHEET NOT USED

U64289 S00041154064_V2

Bracket Installation - Upper Left Side Fan Case
Figure 4-1 (Sheet 20)

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P/P BUILDUP FIGURE 4-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
4-1		BRACKET INSTALLATION - UPPER LEFT SIDE FAN CASE (FIGURE 4-1, SHEET 20) THIS SHEET NOT USED		

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P/P BUILDUP FIGURE 4-1

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737-600/700/800/900
POWERPLANT BUILDUP MANUAL

THIS SHEET NOT USED

U64289 S00041154064_V2

Bracket Installation - Upper Left Side Fan Case
Figure 4-1 (Sheet 21)

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P/P BUILDUP FIGURE 4-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
4-1		BRACKET INSTALLATION - UPPER LEFT SIDE FAN CASE (FIGURE 4-1, SHEET 21) THIS SHEET NOT USED		

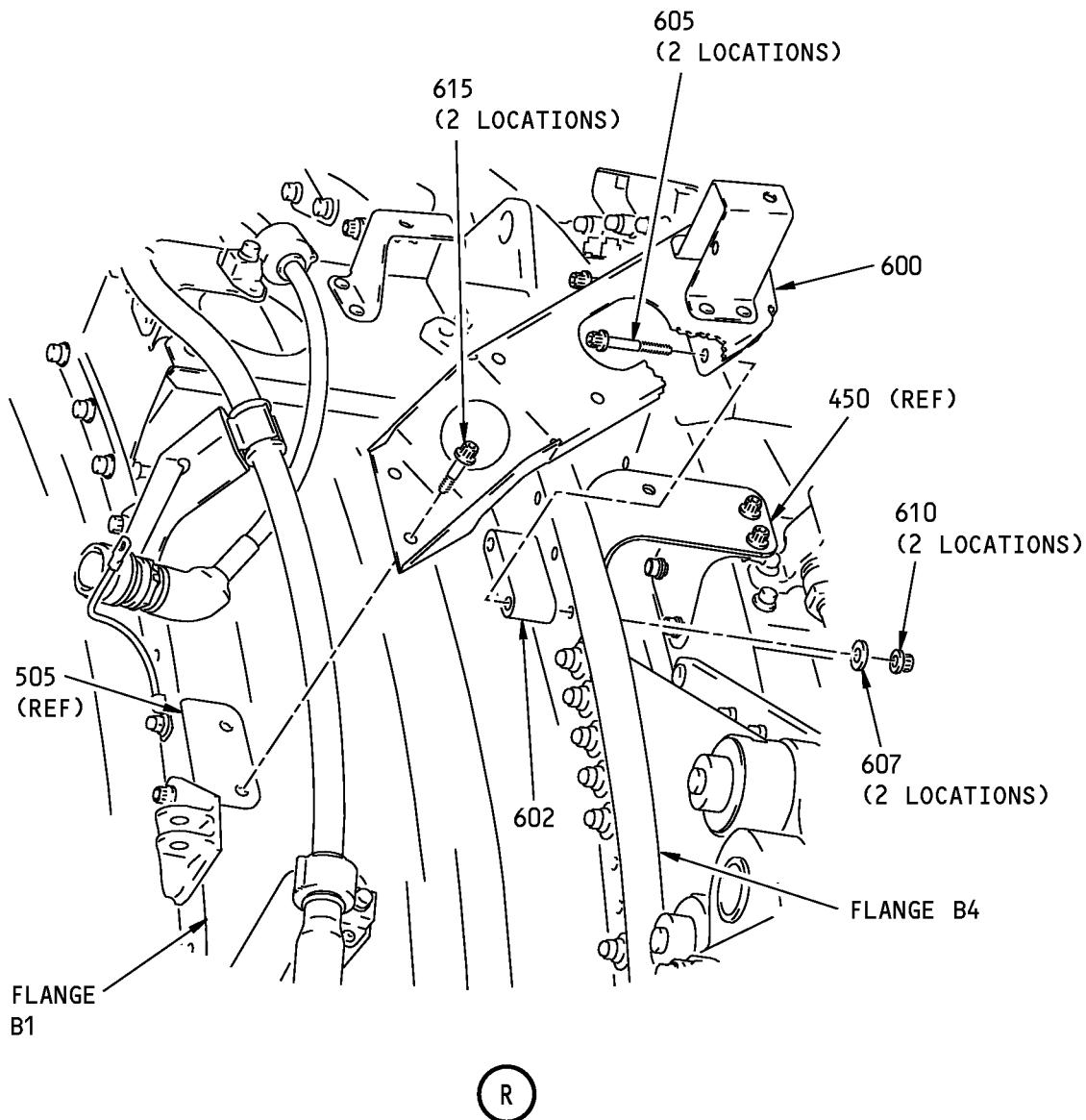
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P/P BUILDUP FIGURE 4-1

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737-600/700/800/900
POWERPLANT BUILDUP MANUAL

W45440 S00041153675_V2

Bracket Installation - Upper Left Side Fan Case
Figure 4-1 (Sheet 22)

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P/P BUILDUP FIGURE 4-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
4-1		BRACKET INSTALLATION - UPPER LEFT SIDE FAN CASE (FIGURE 4-1, SHEET 22) ATTACH BRACKET ASSY (600), BRACKET DETAIL (602), AND BRACKET ASSY (450) TO FLANGE B4 USING BOLTS (605), WASHERS (607) AND NUTS (610). 600 332A2920-228 . BRACKET ASSY 602 332A2930-89 . BRACKET DETAIL 605 BACB30ZF4-26 . BOLT (FWD SIDE) 607 BACW10P393CB . WASHER (UNDER NUT) 610 AS3485-10 . NUT 615 BACB30ZF4-06 ATTACH BRACKET ASSY (600) TO BRACKET (505) USING BOLTS (615). . BOLT TIGHTEN BOLTS (605) TO 80-90 POUND-INCHES (9.0-10.0 NEWTON METERS), AND BOLTS (615) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS).	FWD			1 1 2 2 2 2

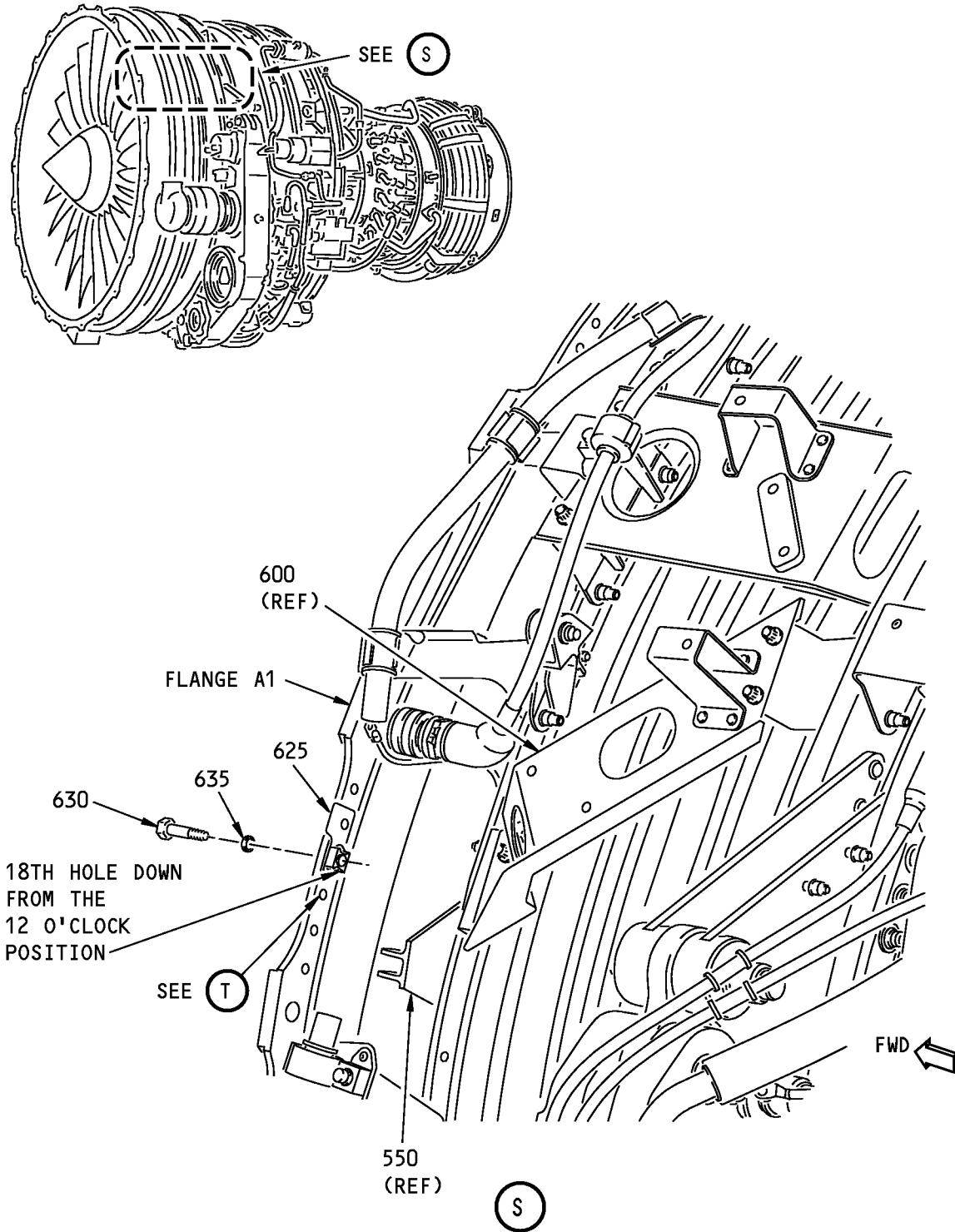
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P/P BUILDUP FIGURE 4-1

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POWERPLANT BUILDUP MANUAL

F40454 S00041153676_V2

Bracket Installation - Upper Left Side Fan Case
Figure 4-1 (Sheet 23)

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P/P BUILDUP FIGURE 4-1
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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
4-1		BRACKET INSTALLATION - UPPER LEFT SIDE FAN CASE (FIGURE 4-1, SHEET 23) ATTACH BRACKET ASSY (625) TO 18TH HOLE DOWN ON FLANGE A1. USE BOLT (630) AND WASHER (635). . BRACKET ASSY . BRACKET ASSY (OPTIONAL TO 332A2910-138) . BOLT (FWD SIDE) . WASHER (CSK) (UNDER BOLT HEAD) TIGHTEN BOLT (630) TO 90-110 POUND-INCHES (10.2-12.4 NEWTON METERS).				
625	332A2910-138		AFT			1
625	332A2910-91		AFT		OPT	-
630	BACB30NM4K5					1
635	BACW10BP4ACU					1

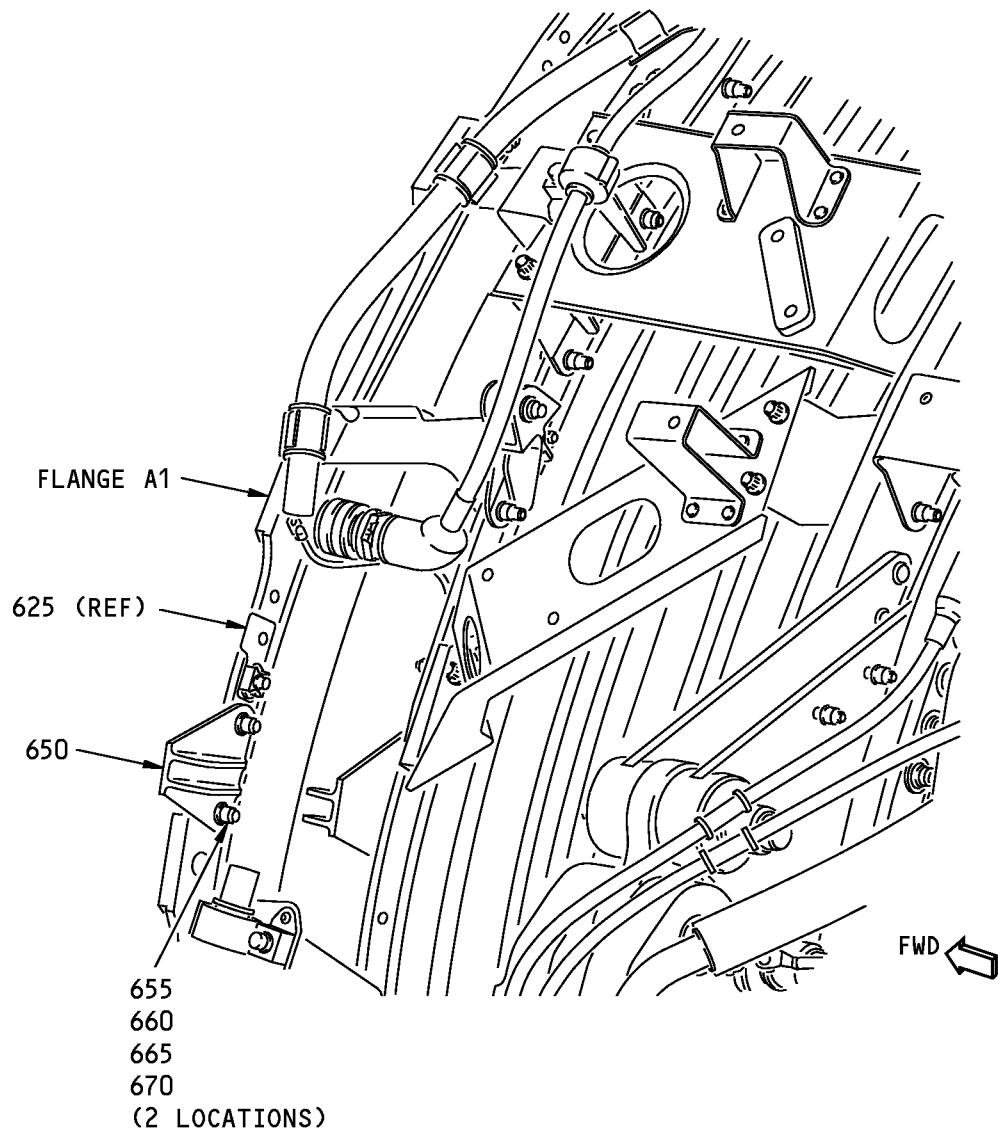
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P/P BUILDUP FIGURE 4-1

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POWERPLANT BUILDUP MANUAL

Bracket Installation - Upper Left Side Fan Case
Figure 4-1 (Sheet 24)

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P/P BUILDUP FIGURE 4-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
4-1		BRACKET INSTALLATION - UPPER LEFT SIDE FAN CASE (FIGURE 4-1, SHEET 24) ATTACH BRACKET ASSY (650) TO 1ST AND 3RD HOLES DOWN FROM BRACKET ASSY (625) ON FLANGE A1. USE BOLTS (655), WASHER (660) AND (665), AND NUTS (670). . BRACKET ASSY . BOLT (FWD SIDE) . WASHER (CSK) (UNDER BOLT) . WASHER (UNDER NUT) . NUT TIGHTEN BOLTS (655) TO 50-80 POUND-INCHES (5.6-9.0 NEWTON METERS).	AFT			1
650	332A2930-7					2
655	BACB30NM4K7					2
660	BACW10BP4ACU					2
665	NAS1149D0416H					2
670	AS3485-10					2

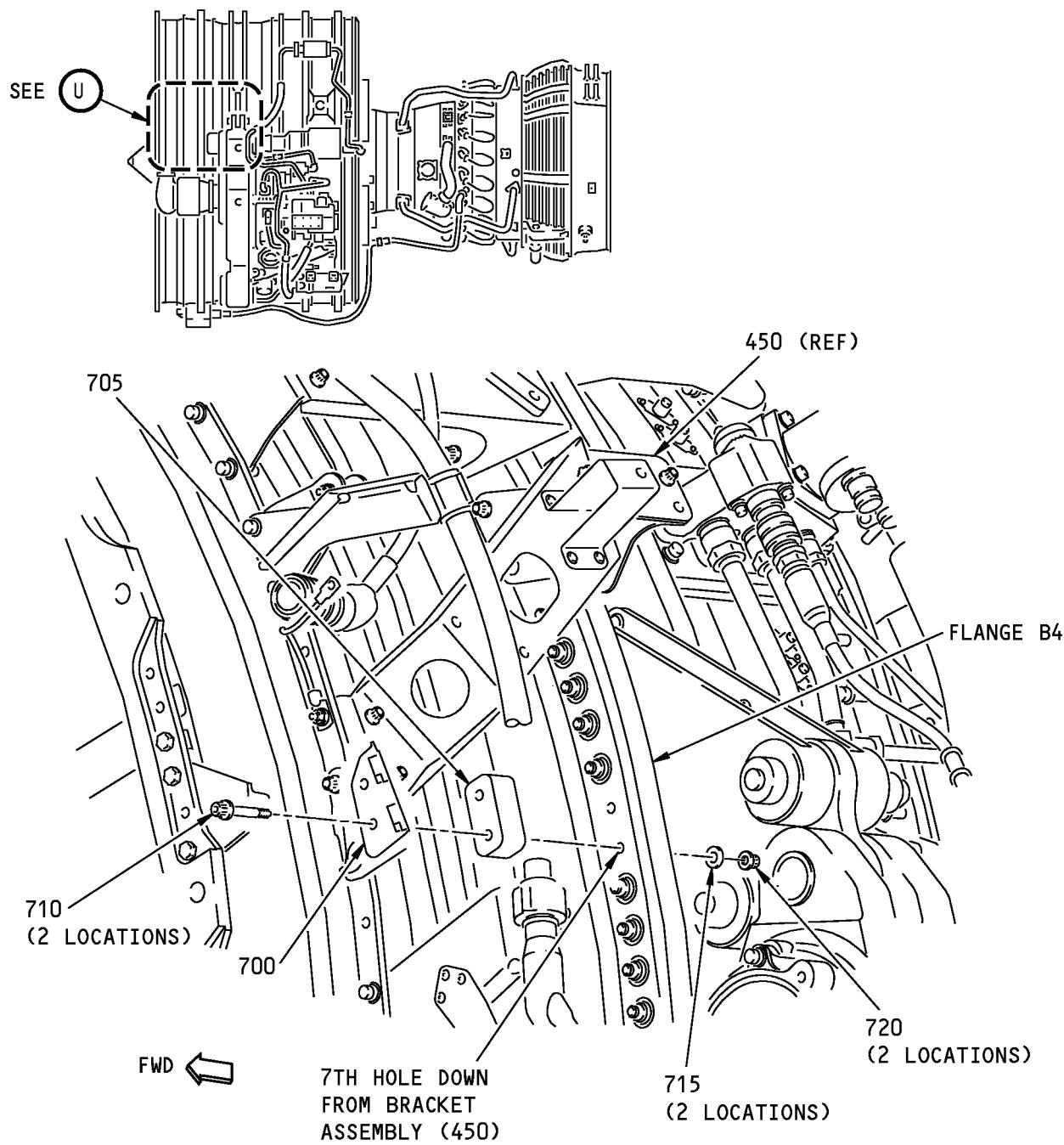
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P/P BUILDUP FIGURE 4-1

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POWERPLANT BUILDUP MANUAL

Bracket Installation - Upper Left Side Fan Case
Figure 4-1 (Sheet 25)

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P/P BUILDUP FIGURE 4-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
4-1		BRACKET INSTALLATION - UPPER LEFT SIDE FAN CASE (FIGURE 4-1, SHEET 25) ATTACH BRACKET ASSYS (700) AND (705) TO 6TH AND 7TH HOLES DOWN FROM BRACKET ASSY (450) ON FLANGE B4. USE BOLTS (710), WASHERS (715) AND NUTS (720). <ul style="list-style-type: none"> . BRACKET ASSY . BRACKET ASSY (OPTIONAL TO 332A2910-125) . BRACKET . BOLT (FWD SIDE) . WASHER (UNDER NUT) . NUT TIGHTEN BOLTS (710) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS).				
700	332A2910-125		FWD	FWD		1
700	332A2930-57		FWD	FWD	OPT	-
705	332A2930-88					1
710	BACB30ZF4-34					2
715	NAS1149C0432R					2
720	AS3485-10					2

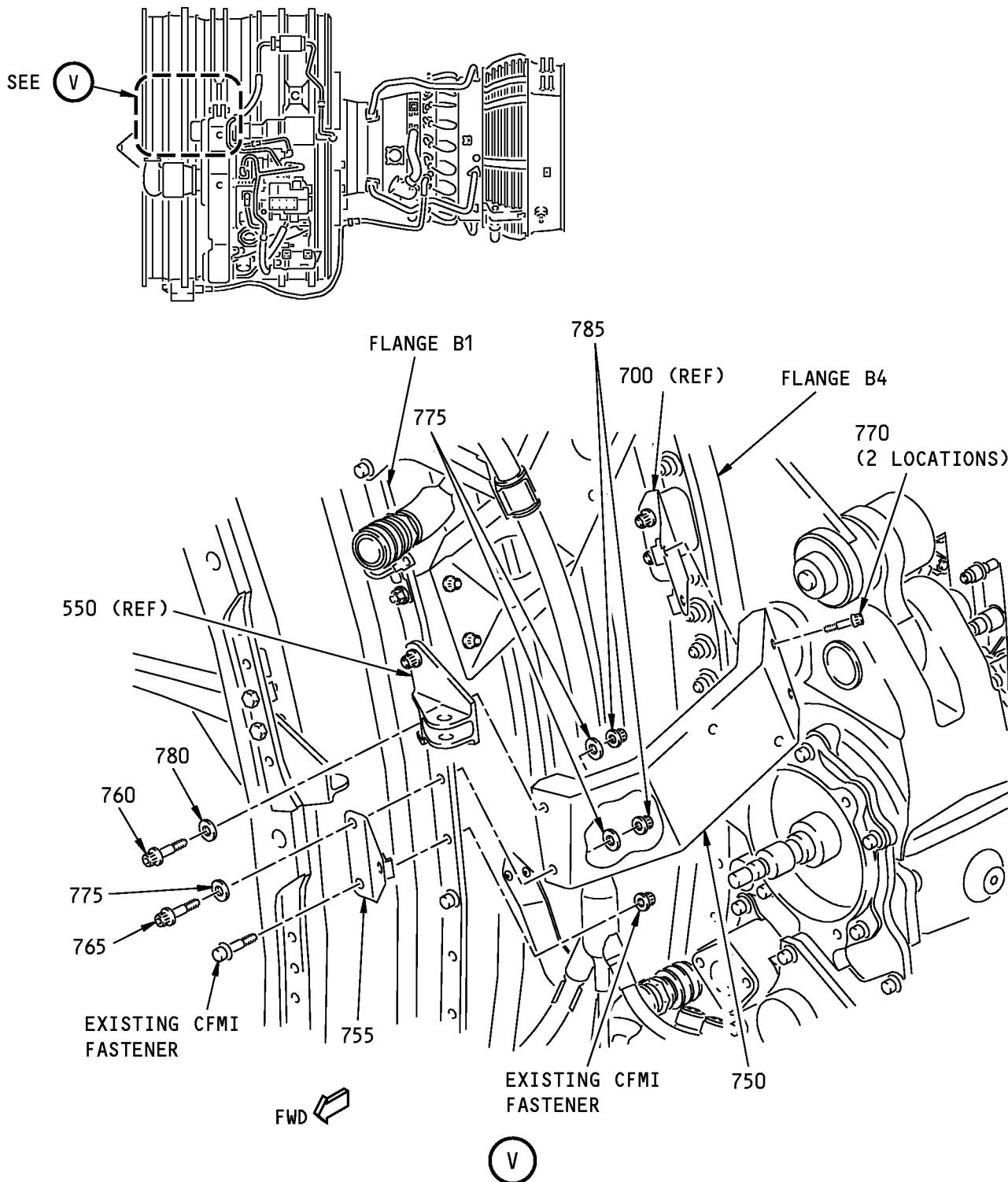
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P/P BUILDUP FIGURE 4-1

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POWERPLANT BUILDUP MANUAL

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Bracket Installation - Upper Left Side Fan Case
Figure 4-1 (Sheet 26)

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P/P BUILDUP FIGURE 4-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
4-1		BRACKET INSTALLATION - UPPER LEFT SIDE FAN CASE (FIGURE 4-1, SHEET 26) ATTACH BRACKET ASSY (750) TO BRACKET ASSY (700) ON FLANGE B4 AND BRACKET ASSYS (550) AND (755) ON FLANGE B1. USE BOLTS (760, 765 AND 770), WASHERS (775, 780), NUTS (785) AND EXISTING CFMI FASTENERS.				
750	332A2920-224	. BRACKET ASSY	AFT	AFT		1
755	332A2910-136	. BRACKET ASSY	FWD			1
755	332A2910-89	. BRACKET ASSY (OPTIONAL TO 332A2910-136)	FWD		OPT	-
760	BACB30ZF4-16	. BOLT (FWD SIDE) (THROUGH LOWER HOLE OF ITEM 550 AND UPPER HOLE OF ITEM 750)				1
765	BACB30ZF4-14	. BOLT (FWD SIDE) (THROUGH UPPER HOLE OF ITEM 755 AND LOWER HOLE OF ITEM 750)				1
770	BACB30ZF4-08	. BOLT				2
775	BACW10P393CB	. WASHER (UNDER BOLT HEAD (ITEM 765) AND UNDER NUTS (ITEM 785))				3
780	BACW10BP4ACU	. WASHER (UNDER BOLT HEAD (ITEM 760))				1
785	AS3485-10	. NUT				2
		TIGHTEN BOLTS (760, 765 AND 770) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS). TIGHTEN EXISTING CFMI FASTENER TO 100-112 POUND-INCHES (11.3-12.7 NEWTON METERS).				

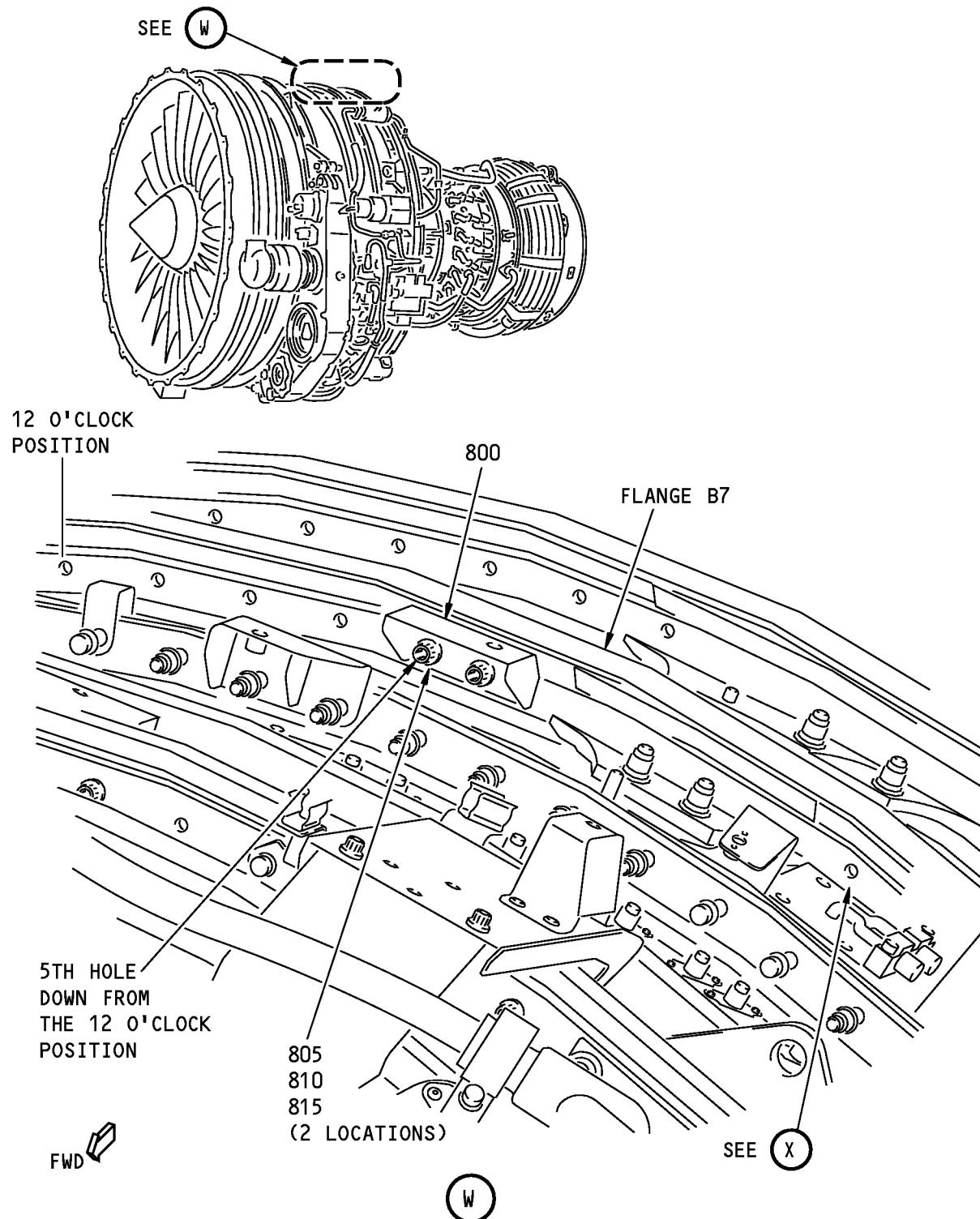
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P/P BUILDUP FIGURE 4-1

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POWERPLANT BUILDUP MANUAL

Bracket Installation - Upper Left Side Fan Case
Figure 4-1 (Sheet 27)

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P/P BUILDUP FIGURE 4-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
4-1		BRACKET INSTALLATION - UPPER LEFT SIDE FAN CASE (FIGURE 4-1, SHEET 27) ATTACH BRACKET ASSY (800) TO 5TH AND 6TH HOLES DOWN FROM 12 O'CLOCK ON FLANGE B7. USE BOLTS (805), WASHERS (810), AND NUTS (815). . BRACKET ASSY . BOLT (FWD SIDE) . WASHER (UNDER NUT) . NUT TIGHTEN BOLTS (805) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS). NOTE: BRACKET (800) MAY BE INSTALLED IN FORWARD ENGINE MOUNT INSTALLATION/Figure 2-1 FORWARD ENGINE MOUNT INSTALLATION.	FWD	FWD		
800	332A2920-222					1
805	BACB30ZF4-12					2
810	BACW10P393CB					2
815	AS3485-10					2

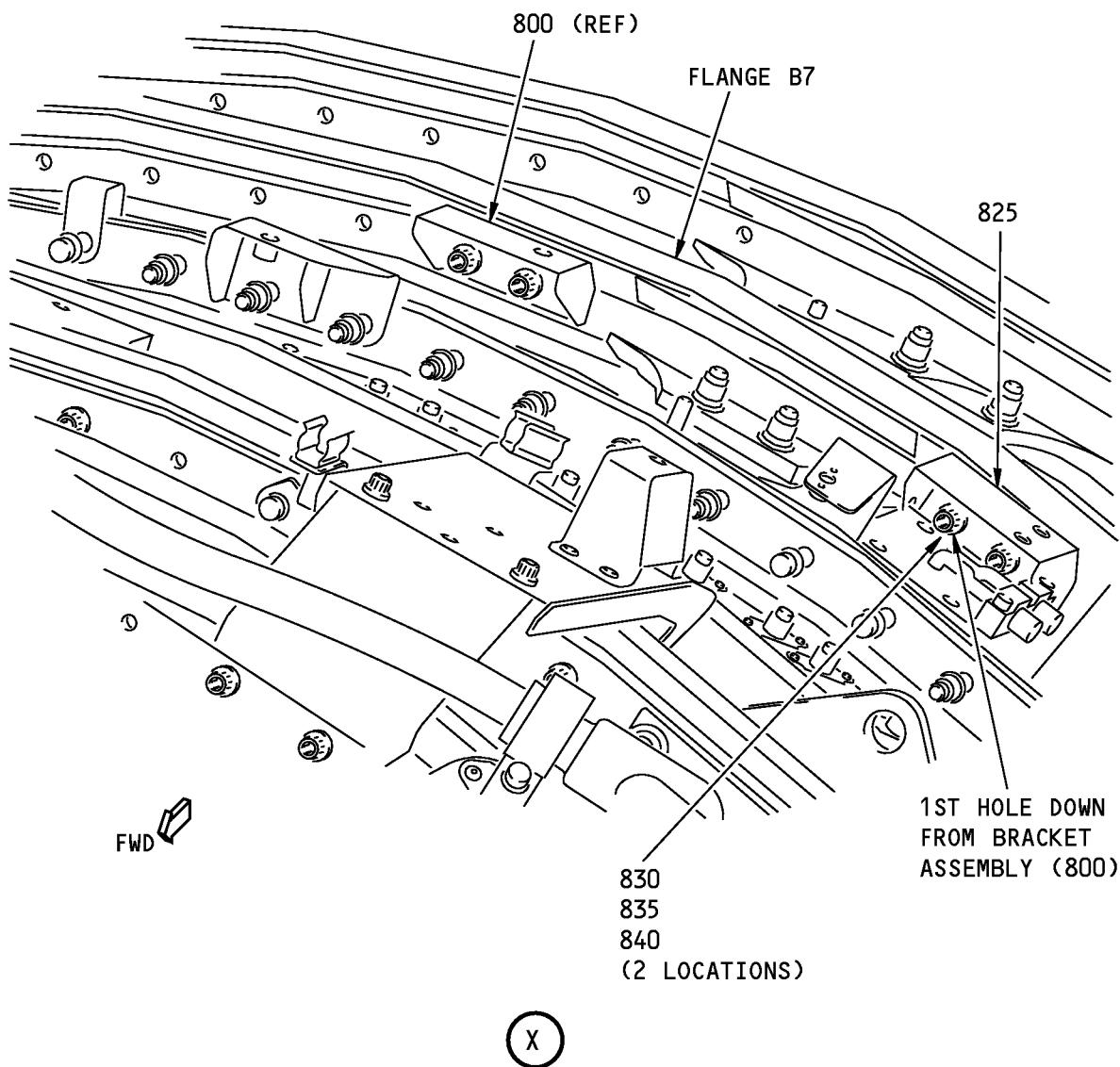
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P/P BUILDUP FIGURE 4-1

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737-600/700/800/900
POWERPLANT BUILDUP MANUAL

Bracket Installation - Upper Left Side Fan Case
Figure 4-1 (Sheet 28)

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P/P BUILDUP FIGURE 4-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
4-1		BRACKET INSTALLATION - UPPER LEFT SIDE FAN CASE (FIGURE 4-1, SHEET 28) CLEAN MATING SURFACES OF BRACKET ASSY (825) AND FLANGE B7 WITH alcohol, B00130 (C2). MAKE SURE YOU REMOVE ALL GREASE AND OTHER CONTAMINANTS. . BRACKET ASSY . ALCOHOL				
825 C2	332A2920-15 B00130	ATTACH BRACKET ASSY (825) TO 1ST AND 2ND HOLES DOWN FROM BRACKET ASSY (800) ON FLANGE B7. USE BOLTS (830), WASHERS (835), AND NUTS (840). . BOLT (FWD SIDE) . WASHER (UNDER NUT) . NUT	FWD	FWD	CON	1 AR
830	BACB30ZF4-14	TIGHTEN BOLTS (830) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS).				2
835	BACW10P393CB					2
840	AS3485-10					2

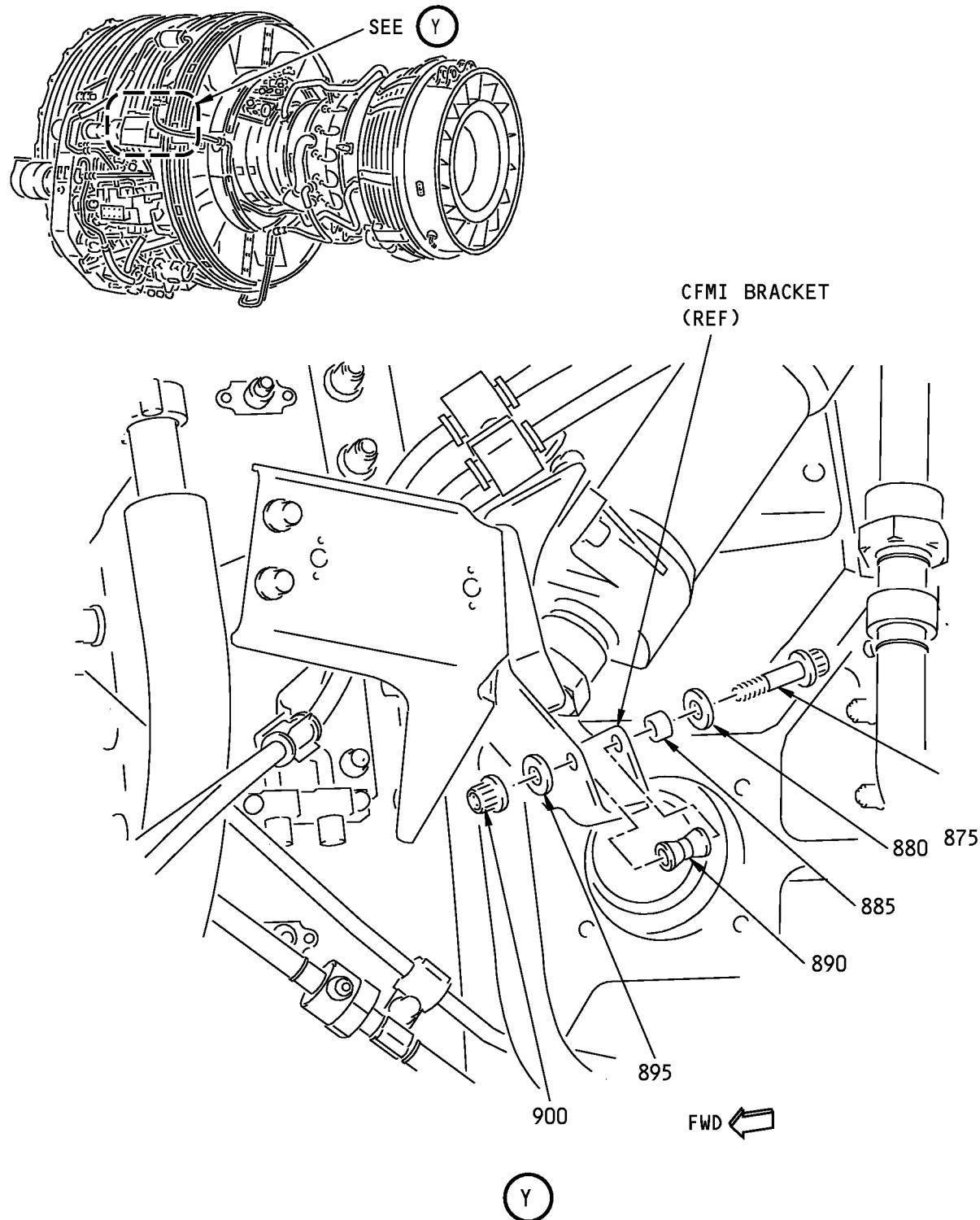
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P/P BUILDUP FIGURE 4-1

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737-600/700/800/900
POWERPLANT BUILDUP MANUAL

Bracket Installation - Upper Left Side Fan Case
Figure 4-1 (Sheet 29)

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P/P BUILDUP FIGURE 4-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
4-1		BRACKET INSTALLATION - UPPER LEFT SIDE FAN CASE (FIGURE 4-1, SHEET 29) INSTALL SPOOL (890) USING BOLT (875), WASHERS (880) AND (895), BUSHING (885) AND NUT (900). 875 BACB30LE3U18 . BOLT (AFT SIDE) 880 BACW10BP3ACU . WASHER (CSK) (UNDER BOLT HEAD) 885 BACB28AK03-027 . BUSHING 890 RC2769-1 . SPOOL (V08844) 895 NAS1149E0332R . WASHER (UNDER NUT) 900 BACN11Z3CK . NUT (FWD SIDE) TIGHTEN BOLT (875) TO 30-35 POUND-INCHES (3.4-4.0 NEWTON METERS).			VEN	1 1 1 1 1 1

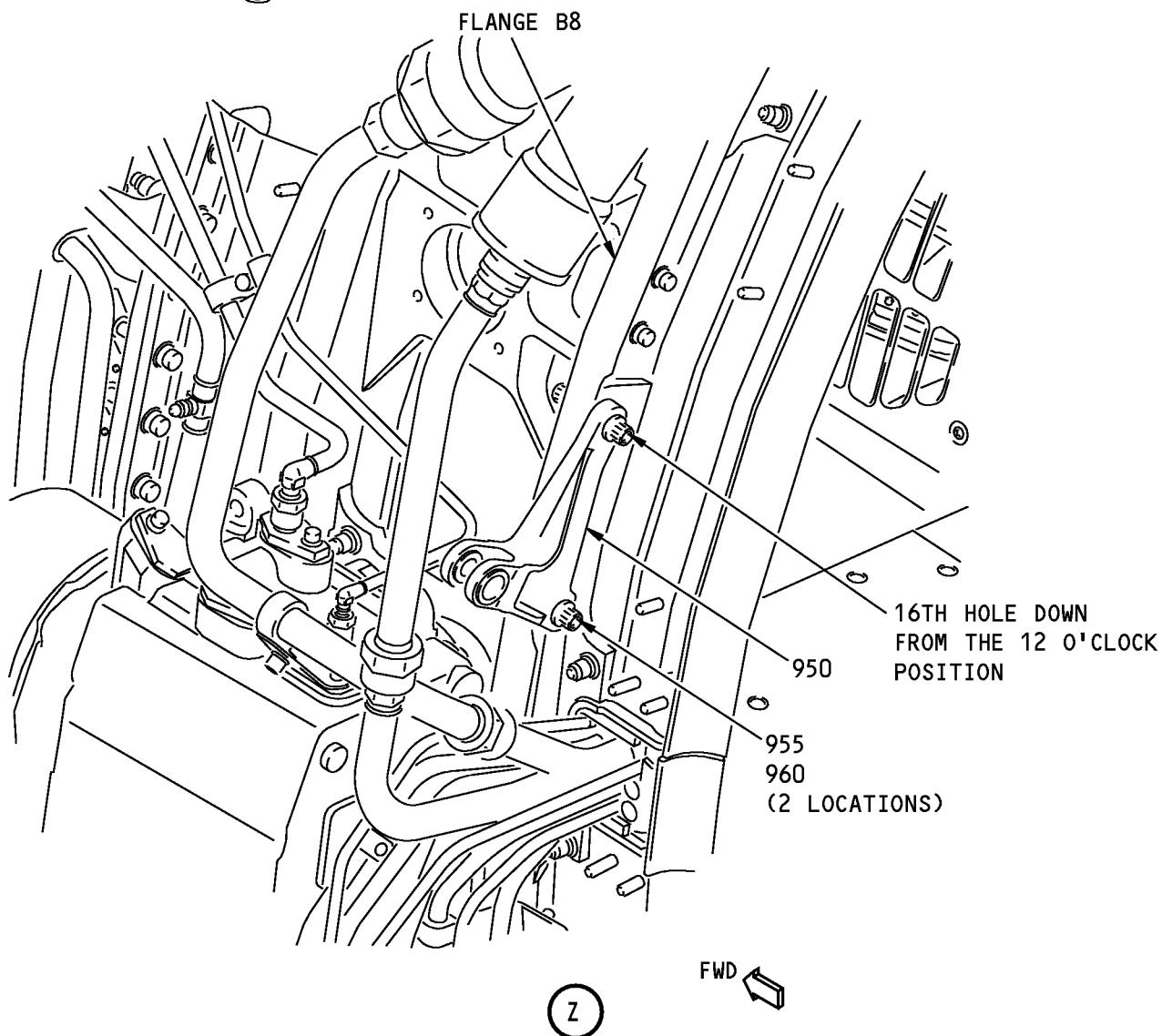
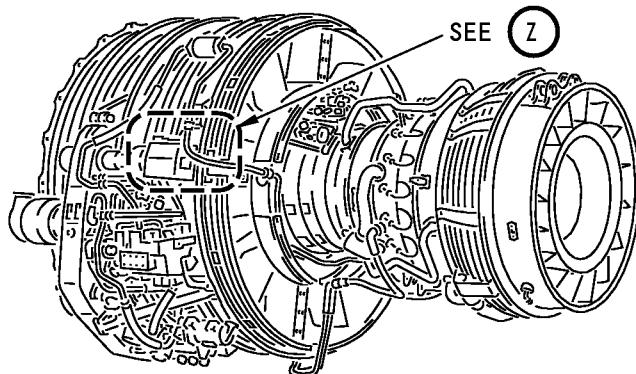
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P/P BUILDUP FIGURE 4-1

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POWERPLANT BUILDUP MANUAL

Bracket Installation - Upper Left Side Fan Case
Figure 4-1 (Sheet 30)

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P/P BUILDUP FIGURE 4-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
4-1 950 955 960 C7	332A2930-61 BACB30LE5U6 BACW10BP5ACU D50004	<p>BRACKET INSTALLATION - UPPER LEFT SIDE FAN CASE (FIGURE 4-1, SHEET 30)</p> <p>APPLY A THIN COATING OF compound, D50004 (C7) TO BOLTS (955).</p> <p>ATTACH BRACKET ASSY (950) TO 16TH AND 17TH HOLE DOWN FROM 12 O'CLOCK ON FLANGE B8. USE BOLTS (955) AND WASHERS (960).</p> <p>. BRACKET ASSY . BOLT (AFT SIDE) . WASHER (CSK) (UNDER BOLT HEAD) . COMPOUND</p> <p>TIGHTEN BOLTS (955) TO 123-136 POUND-INCHES (13.9-15.4 NEWTON METERS).</p>	AFT		CON	1 2 2 AR

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P/P BUILDUP FIGURE 4-1

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FIGURE 5-1

BRACKET INSTALLATION - LOWER LEFT FAN CASE

REF QEC TASK NO.: 5

REF DWG: 332A2900

NOTE: ALL STANDARDS AND ATTACHING HARDWARE FOR THIS FIGURE WILL BE PACKAGED IN QEC TASK NO. 110.

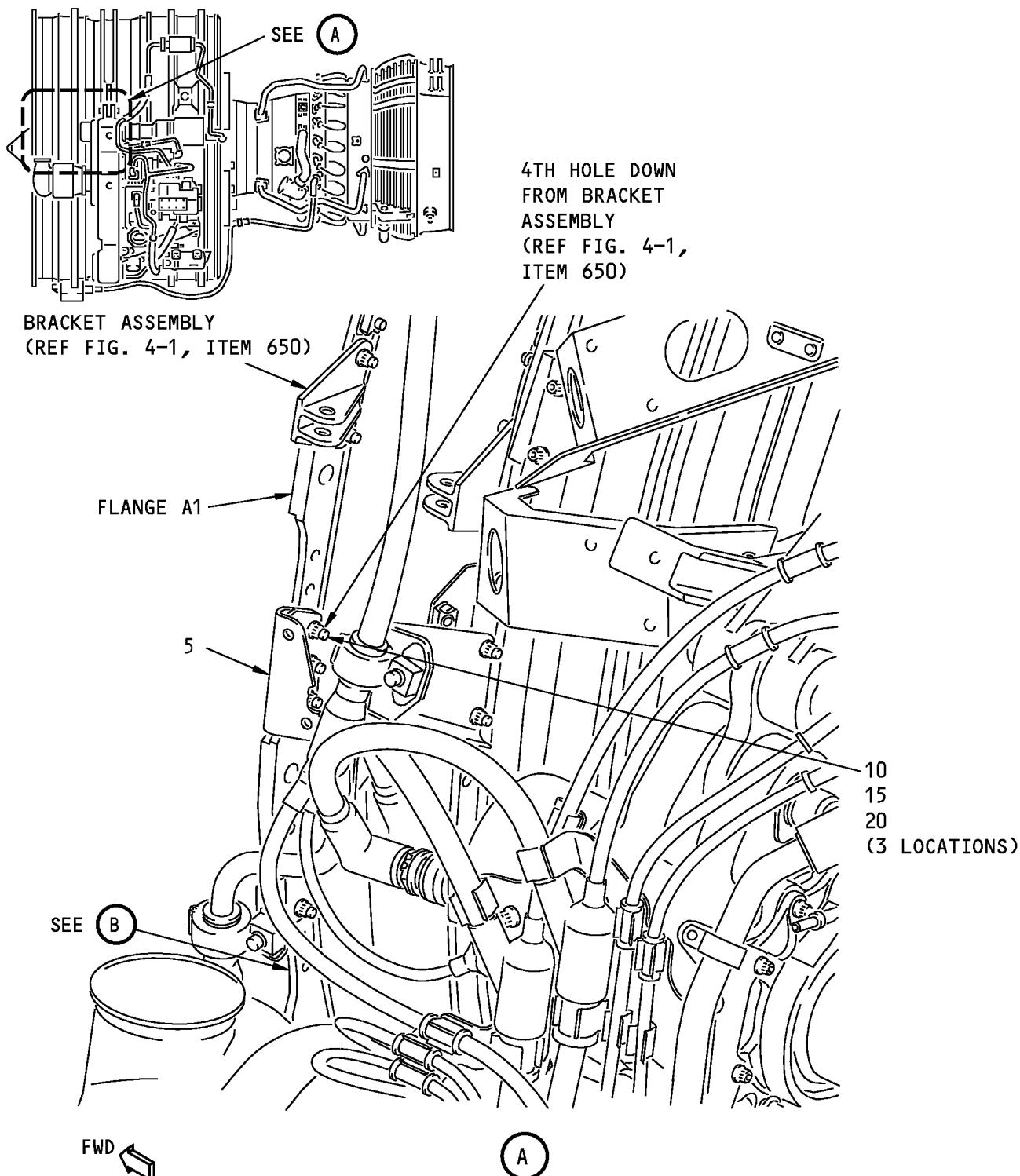
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P/P BUILDUP FIGURE 5-1

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Bracket Installation - Lower Left Side Fan Case
Figure 5-1 (Sheet 1)

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P/P BUILDUP FIGURE 5-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
5-1		BRACKET INSTALLATION - LOWER LEFT SIDE FAN CASE (FIGURE 5-1, SHEET 1) ATTACH BRACKET ASSY (5) TO 4TH, 5TH AND 6TH HOLE DOWN FROM BRACKET ASSY (BRACKET INSTALLATION - UPPER LEFT FAN CASE/Figure 4-1, ITEM (650)) ON FLANGE A1. USE BOLTS (10), WASHERS (15) AND NUTS (20). . BRACKET ASSY . BOLT (FWD SIDE) . WASHER (CSK) (UNDER BOLT HEAD) . NUT TIGHTEN BOLTS (10) TO 50-80 POUND-INCHES (5.6-9.0 NEWTON METERS).				
5	332A2910-24		AFT	AFT		1
10	BACB30NM4K7					3
15	BACW10BP4ACU					3
20	AS3485-10					3

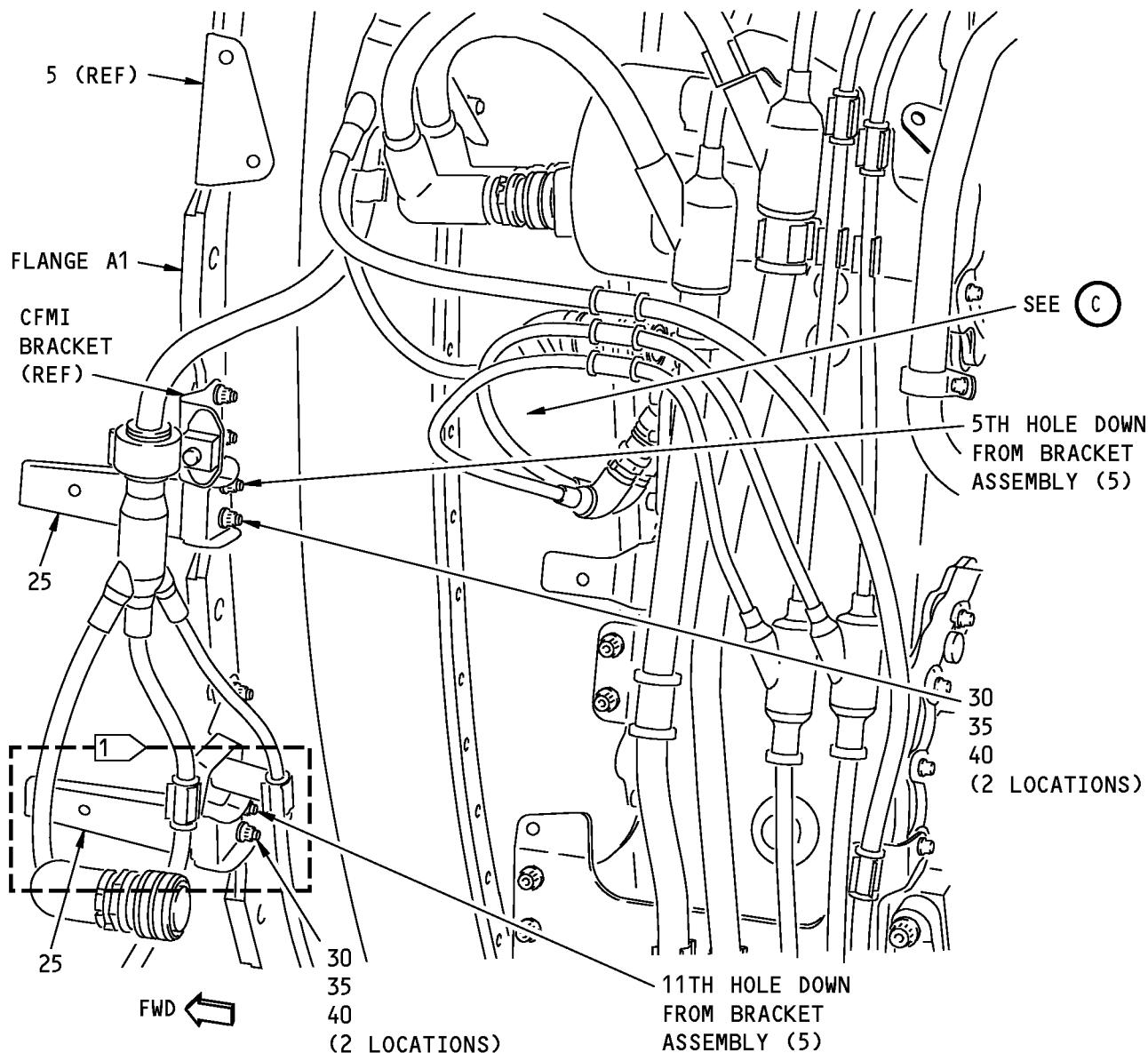
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P/P BUILDUP FIGURE 5-1

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POWERPLANT BUILDUP MANUAL

2426183 S0000561028_V1

Bracket Installation - Lower Left Side Fan Case
Figure 5-1 (Sheet 2)

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P/P BUILDUP FIGURE 5-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
5-1		BRACKET INSTALLATION - LOWER LEFT SIDE FAN CASE (FIGURE 5-1, SHEET 2) ATTACH BRACKET ASSY (25) TO 5TH AND 6TH HOLE DOWN FROM BRACKET ASSY (5) ON FLANGE A1. USE BOLTS (30), WASHERS (35) AND NUTS (40). 25 332A2920-245 . BRACKET ASSY AFT FWD 1 25 332A2920-193 . BRACKET ASSY (REPLACED BY 332A2920-245) AFT FWD LTD - 25 332A2920-110 . BRACKET ASSY (OPTIONAL TO 332A2920-193) AFT FWD OPT - 30 BACB30NM4K6 . BOLT (FWD SIDE) 2 35 BACW10BP4ACU . WASHER (CSK) (UNDER BOLT HEAD) 2 40 AS3485-10 . NUT 2 <u>PREFERRED BRACKET CONFIGURATION</u> ATTACH BRACKET ASSY (25) TO 11TH AND 12TH HOLE DOWN FROM BRACKET ASSY (5) ON FLANGE A1. USE BOLTS (30), WASHERS (35) AND NUTS (40). 25 332A2920-245 . BRACKET ASSY AFT FWD 1 30 BACB30NM4K6 . BOLT (FWD SIDE) 2 35 BACW10BP4ACU . WASHER (CSK) (UNDER BOLT HEAD) 2 40 AS3485-10 . NUT 2 TIGHTEN BOLTS (30) TO 50-80 POUND-INCHES (5.6-9.0 NEWTON METERS).				

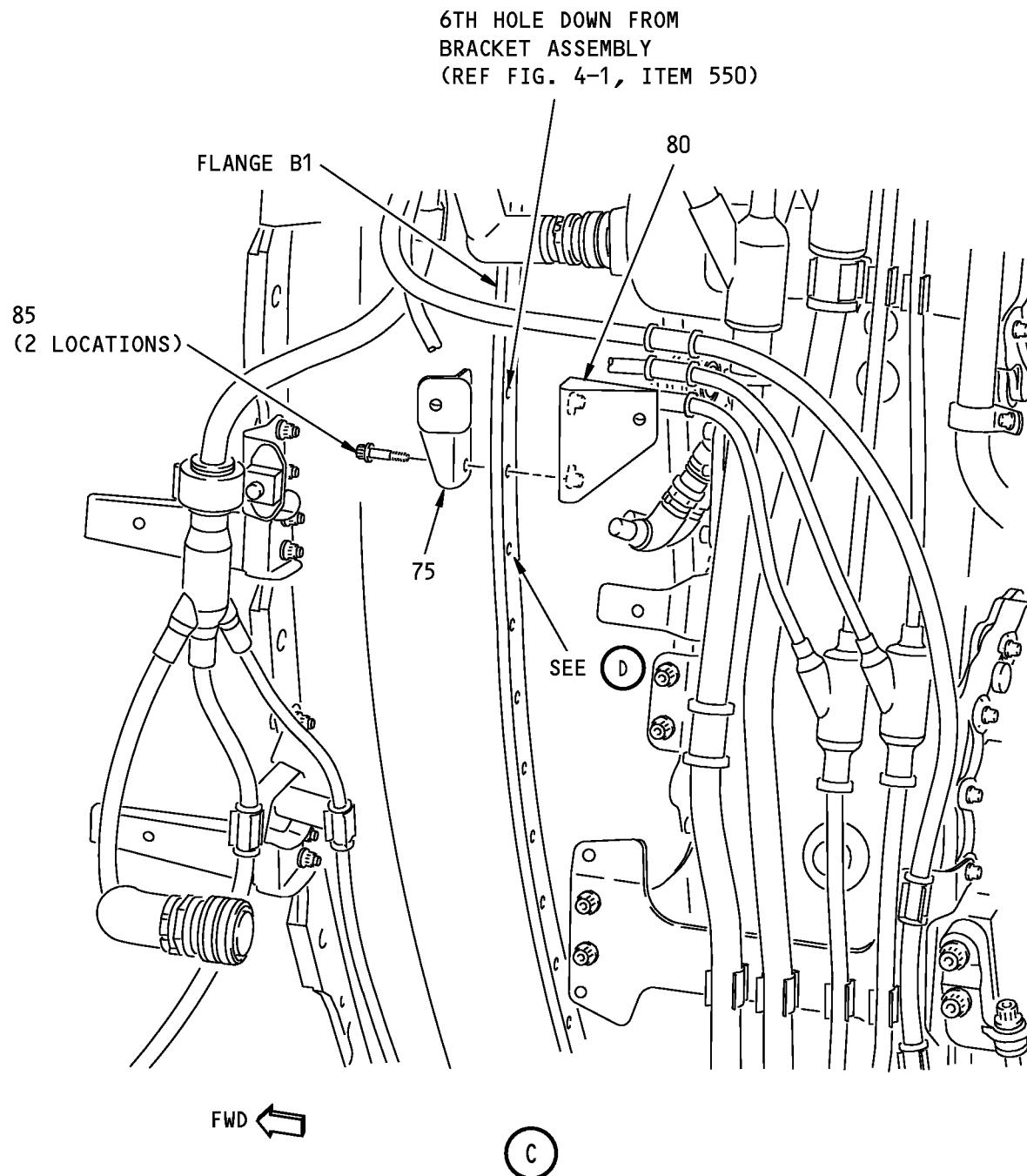
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P/P BUILDUP FIGURE 5-1

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POWERPLANT BUILDUP MANUAL

F38207 S00041153688_V3

Bracket Installation - Lower Left Side Fan Case
Figure 5-1 (Sheet 3)

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P/P BUILDUP FIGURE 5-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
5-1		BRACKET INSTALLATION - LOWER LEFT SIDE FAN CASE (FIGURE 5-1, SHEET 3) ATTACH BRACKET ASSYS (75) AND (80) ON 6TH AND 7TH HOLE DOWN FROM BRACKET ASSY (BRACKET INSTALLATION - UPPER LEFT FAN CASE/Figure 4-1, ITEM (550)) ON FLANGE B1. USE BOLTS (85) AND WASHERS (90). <ul style="list-style-type: none"> . BRACKET ASSY . BRACKET ASSY (OPTIONAL TO 332A2910-134) . BRACKET ASSY . BOLT (FWD SIDE) . WASHER (UNDER BOLT HEAD) TIGHTEN BOLTS (85) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS).				
75	332A2910-134		FWD	FWD		1
75	332A2910-69		FWD	FWD	OPT	-
80	332A2920-92		AFT	AFT		1
85	BACB30ZF4-11					2
90	BACW10P393CB					2

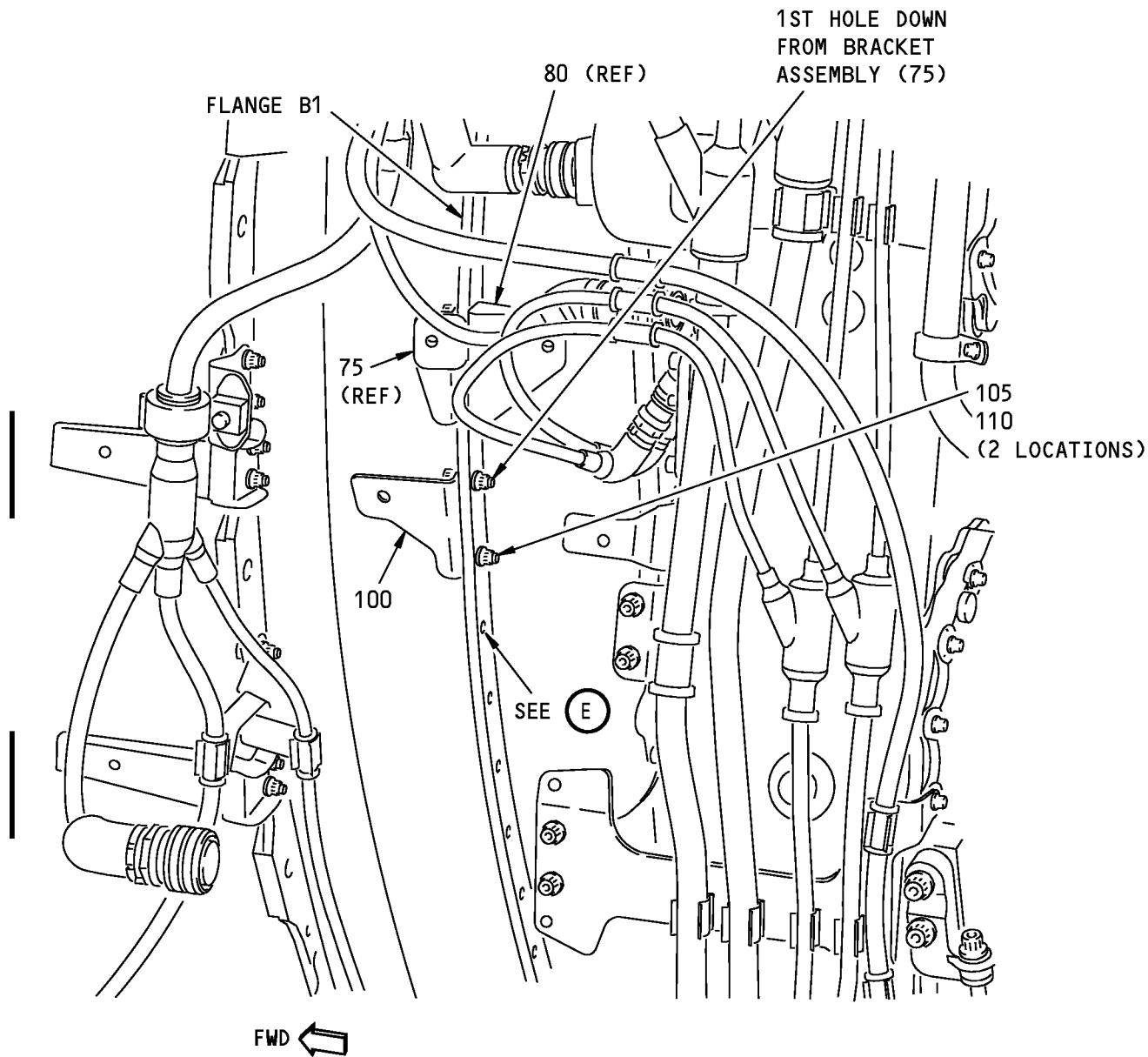
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P/P BUILDUP FIGURE 5-1

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POWERPLANT BUILDUP MANUAL

NOTE: STARTER NOT SHOWN FOR CLARITY.

H49627 S00041153690_V2

Bracket Installation - Lower Left Side Fan Case
Figure 5-1 (Sheet 4)

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P/P BUILDUP FIGURE 5-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
5-1		BRACKET INSTALLATION - LOWER LEFT SIDE FAN CASE (FIGURE 5-1, SHEET 4) ATTACH BRACKET ASSY (100) ON 1ST AND 2ND HOLE DOWN FROM BRACKET ASSY (75) ON FLANGE B1. USE BOLTS (105) AND WASHERS (110). . BRKT ASSY . BOLT (AFT SIDE) . WASHER (UNDER BOLT HEAD) TIGHTEN BOLTS (105) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS).				
100	332A2910-112		FWD	FWD		1
105	BACB30ZF4-10					2
110	BACW10P393CB					2

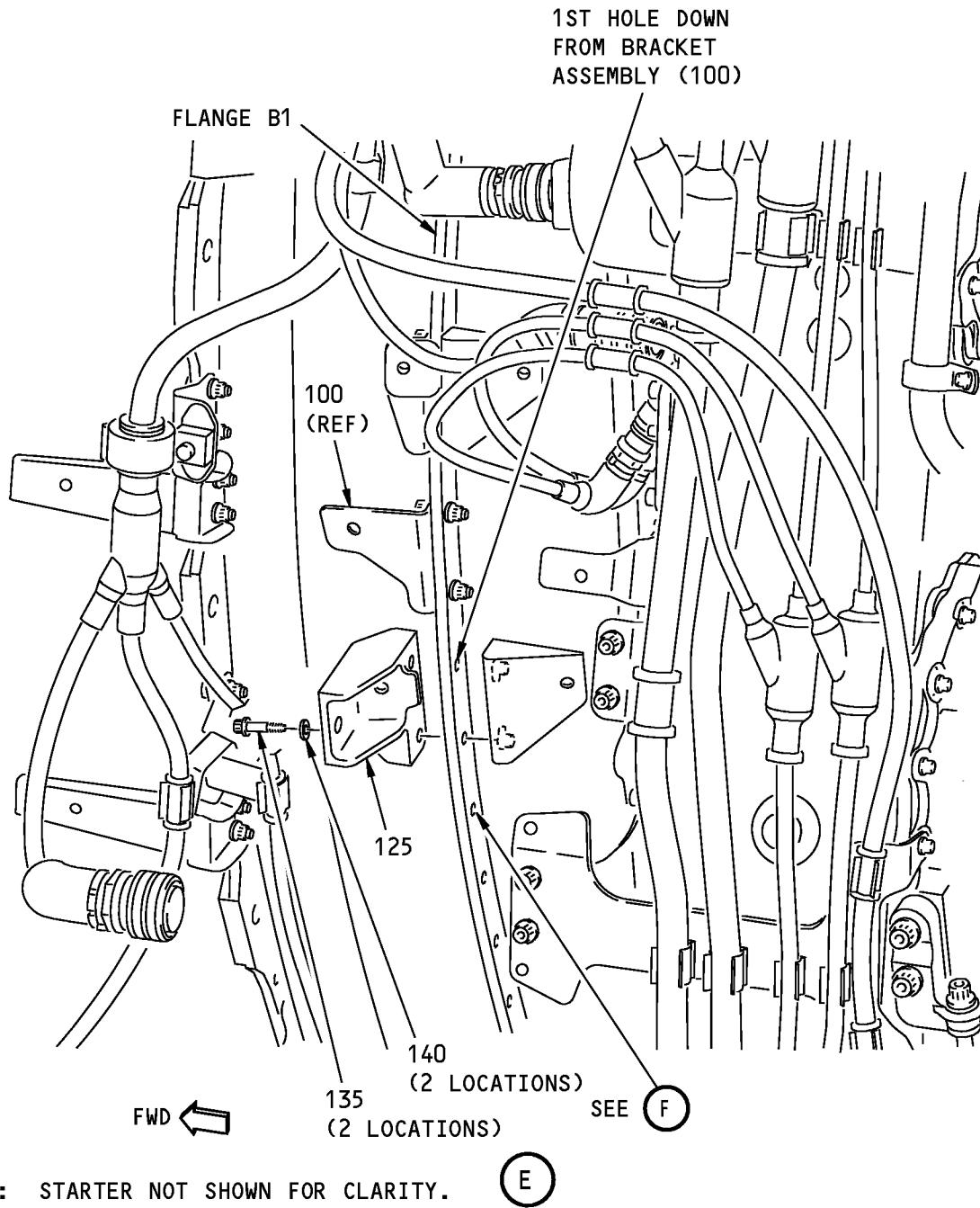
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P/P BUILDUP FIGURE 5-1

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POWERPLANT BUILDUP MANUAL

F38222 S00041153691_V2

Bracket Installation - Lower Left Side Fan Case
Figure 5-1 (Sheet 5)

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P/P BUILDUP FIGURE 5-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
5-1		<p>BRACKET INSTALLATION - LOWER LEFT SIDE FAN CASE (FIGURE 5-1, SHEET 5)</p> <p>NOTE: DUE TO LIMITED ACCESS, IT IS RECOMMENDED THAT INTEGRATED DRIVE GENERATOR INSTALLATION/Figure 22-1 ITEM NO. (15) LANYARD ASSY BE LOOSELY ATTACHED TO BRACKET (125) PRIOR TO BRACKET INSTALLATION.</p> <p>ATTACH BRACKET (125) AND BRACKET ASSY (130) ON 1ST AND 2ND HOLES DOWN FROM BRACKET ASSY (100) ON FLANGE B1.</p> <p>USE BOLTS (135) AND WASHERS (140).</p> <ul style="list-style-type: none"> . BRACKET . BRACKET ASSY . BOLT (FWD SIDE) . WASHER (CSK) (UNDER BOLT HEAD) . WASHER (CSK) (OPTIONAL TO BACW10BP4ACU) <p>TIGHTEN BOLTS (135) TO 90-110 POUND-INCHES (10.2-12.4 NEWTON METERS).</p>				
125	332A2931-3		FWD	FWD		1
130	332A2920-92		AFT	AFT		1
135	BACB30LE4K6					2
140	BACW10BP4ACU					2
140	BACW10BP4CD				OPT	-

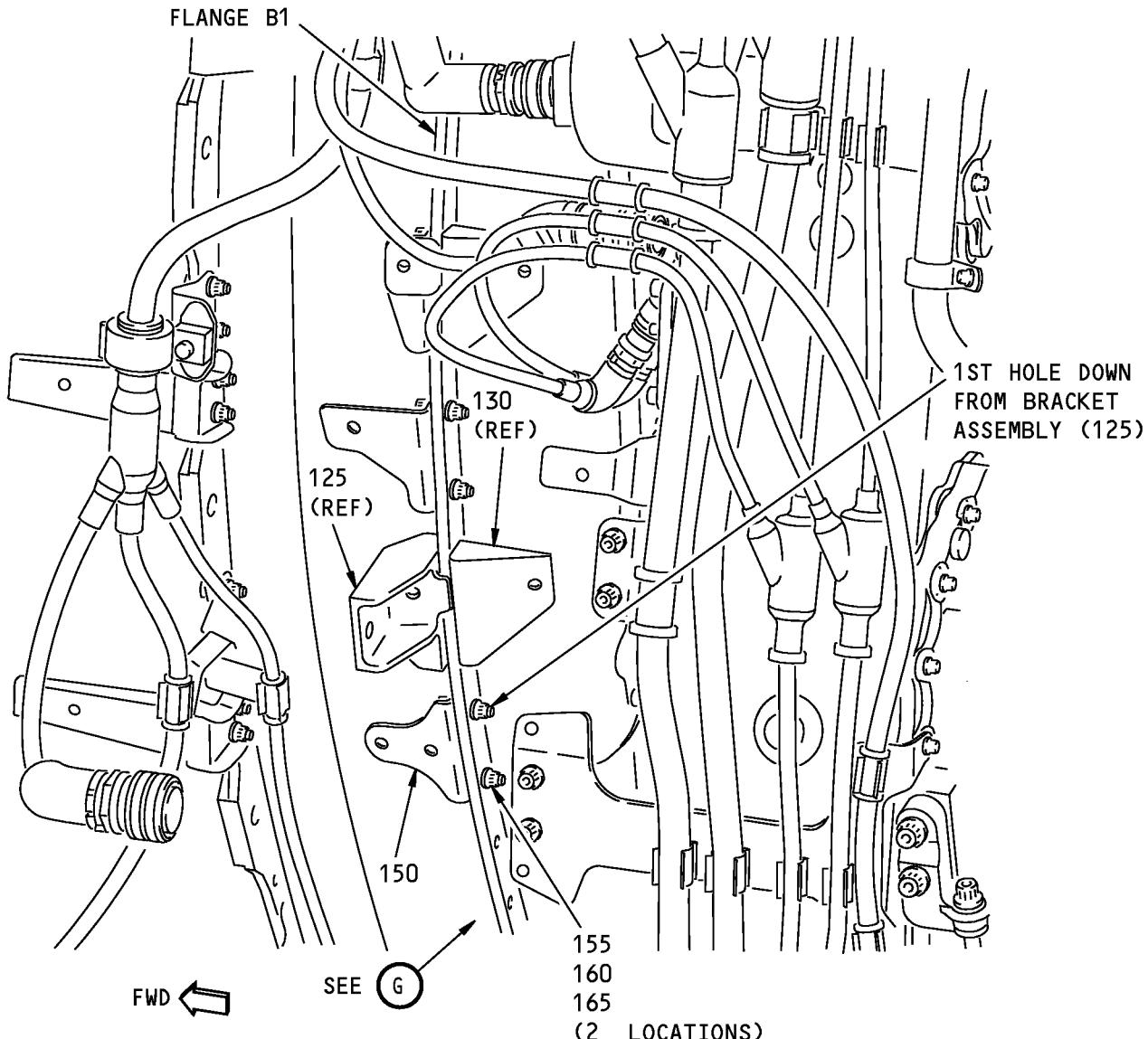
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P/P BUILDUP FIGURE 5-1

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POWERPLANT BUILDUP MANUAL

NOTE: STARTER NOT SHOWN FOR CLARITY.

F38224 S00041153692_V2

Bracket Installation - Lower Left Side Fan Case
Figure 5-1 (Sheet 6)

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P/P BUILDUP FIGURE 5-1
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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
5-1		BRACKET INSTALLATION - LOWER LEFT SIDE FAN CASE (FIGURE 5-1, SHEET 6) ATTACH BRACKET ASSY (150) ON 1ST AND 2ND HOLE DOWN FROM BRACKET ASSY (125) ON FLANGE B1. USE BOLTS (155), WASHERS (160) AND NUTS (165). . BRACKET ASSY . BOLT (FWD SIDE) . WASHER (UNDER NUT) . NUT TIGHTEN BOLTS (155) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS).				
150	332A2910-74		FWD	FWD		1
155	BACB30ZF4-11					2
160	BACW10P393CB					2
165	AS3485-10					2

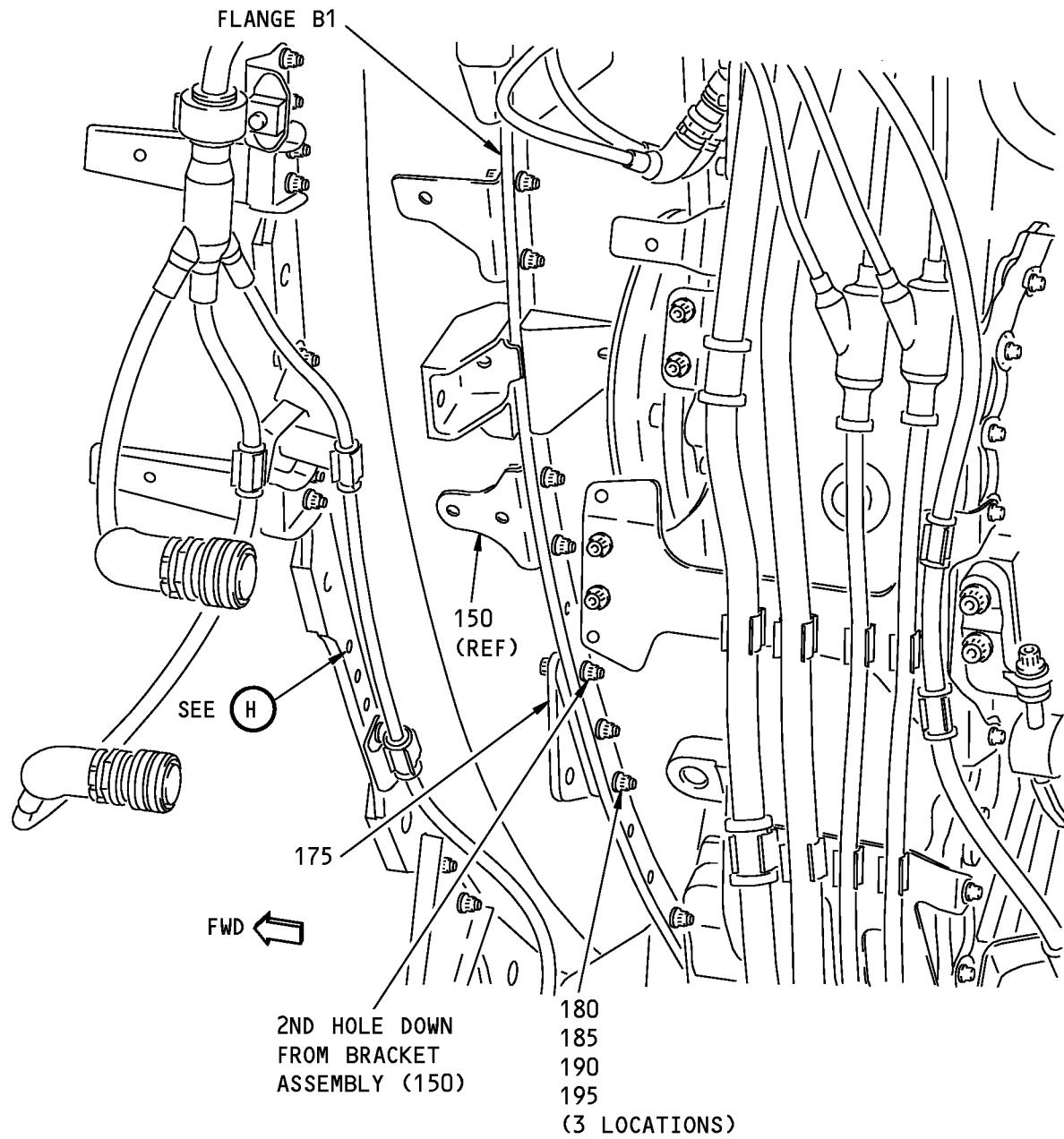
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P/P BUILDUP FIGURE 5-1

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POWERPLANT BUILDUP MANUAL

NOTE: STARTER NOT SHOWN FOR CLARITY.

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G71533 S00041153693_V2

Bracket Installation - Lower Left Side Fan Case
Figure 5-1 (Sheet 7)

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P/P BUILDUP FIGURE 5-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
5-1		<p>BRACKET INSTALLATION - LOWER LEFT SIDE FAN CASE (FIGURE 5-1, SHEET 7)</p> <p>NOTE: DUE TO LIMITED ACCESS, IT IS RECOMMENDED THAT INTEGRATED DRIVE GENERATOR INSTALLATION/FIGURE 22-1 ITEM NO. (5) LANYARD ASSY BE LOOSELY ATTACHED TO BRACKET ASSY (175) PRIOR TO BRACKET ASSY INSTALLATION.</p> <p>ATTACH BRACKET ASSY (175) TO 2ND, 3RD AND 4TH HOLES DOWN FROM BRACKET ASSY (150) ON FLANGE B1.</p> <p>USE BOLTS (180), WASHERS (185) AND (190) AND NUTS (195).</p> <p>. BRACKET ASSY . BOLT (FWD SIDE) . WASHER (CSK) (UNDER BOLT HEAD) . WASHER (UNDER NUT) . NUT</p> <p>TIGHTEN BOLTS (180) TO 72-88 POUND-INCHES (8.1-9.9 NEWTON METERS).</p>	FWD			
175	332A2911-2					1
180	BACB30LE4K12					3
185	BACW10BP4ACU					3
190	BACW10P393CB					3
195	AS3485-10					3

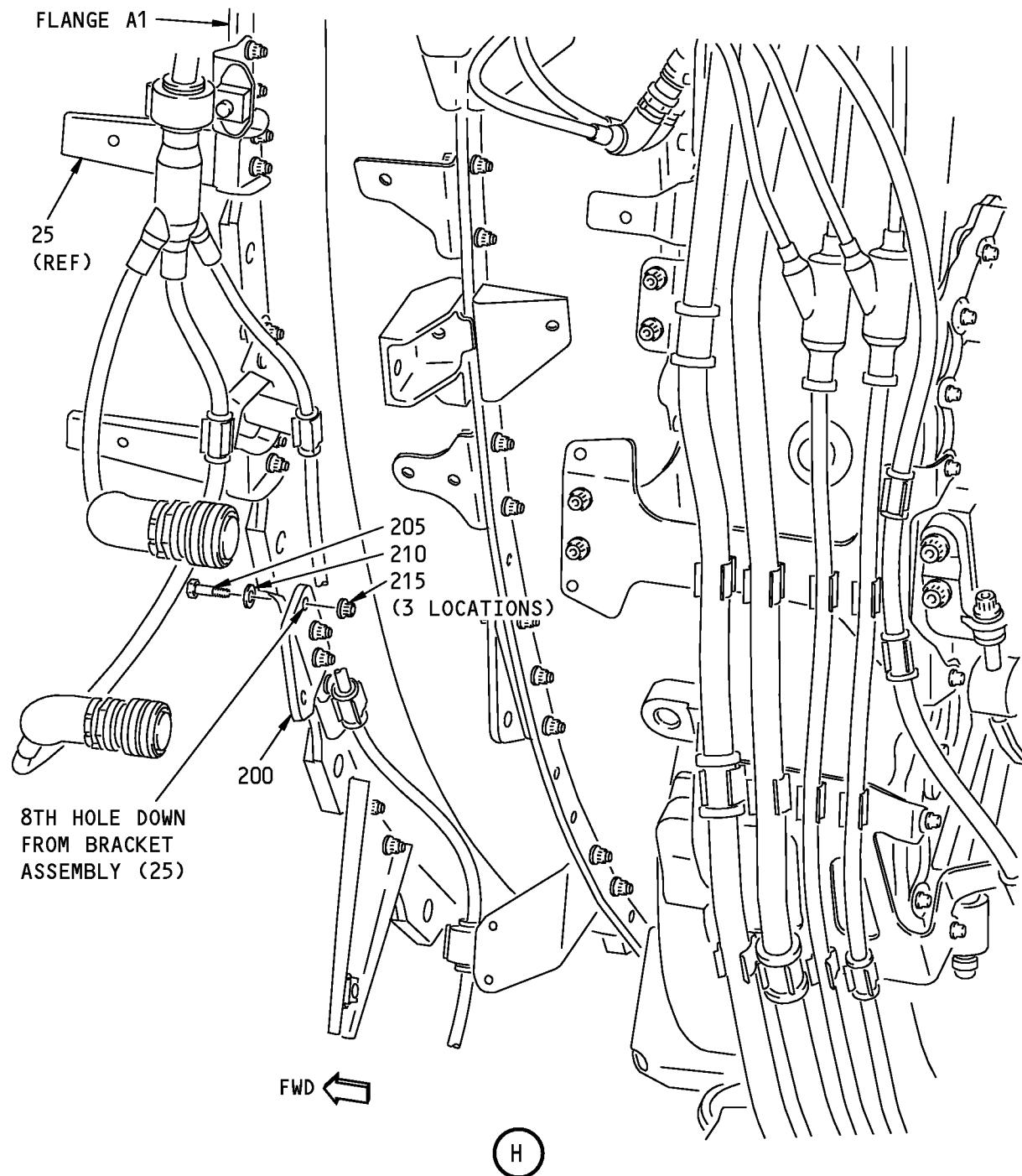
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P/P BUILDUP FIGURE 5-1

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POWERPLANT BUILDUP MANUAL

NOTE: STARTER NOT SHOWN FOR CLARITY.

G72623 S00041153694_V2

Bracket Installation - Lower Left Side Fan Case
Figure 5-1 (Sheet 8)

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P/P BUILDUP FIGURE 5-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
5-1		<p>BRACKET INSTALLATION - LOWER LEFT SIDE FAN CASE (FIGURE 5-1, SHEET 8)</p> <p>NOTE: DUE TO LIMITED ACCESS, IT IS RECOMMENDED THAT INTEGRATED DRIVE GENERATOR INSTALLATION/Figure 22-1 ITEM NO. (10) LANYARD ASSY BE LOOSELY ATTACHED TO BRACKET (200) PRIOR TO BRACKET INSTALLATION.</p> <p>ATTACH BRACKET DETAIL (200) TO 8TH, 9TH AND 10TH HOLES DOWN FROM BRACKET ASSY (25) ON FLANGE A1.</p> <p>USE BOLTS (205), WASHERS (210) AND NUTS (215).</p> <p>. BRACKET DETAIL . BOLT (FWD SIDE) . WASHER (CSK) (UNDER BOLT HEAD) . NUT</p> <p>TIGHTEN BOLTS (205) TO 50-80 POUND-INCHES (5.6-9.0 NEWTON METERS).</p>				
200	332A2911-5		AFT	AFT		1
205	BACB30NM4K7					3
210	BACW10BP4ACU					3
215	AS3485-10					3

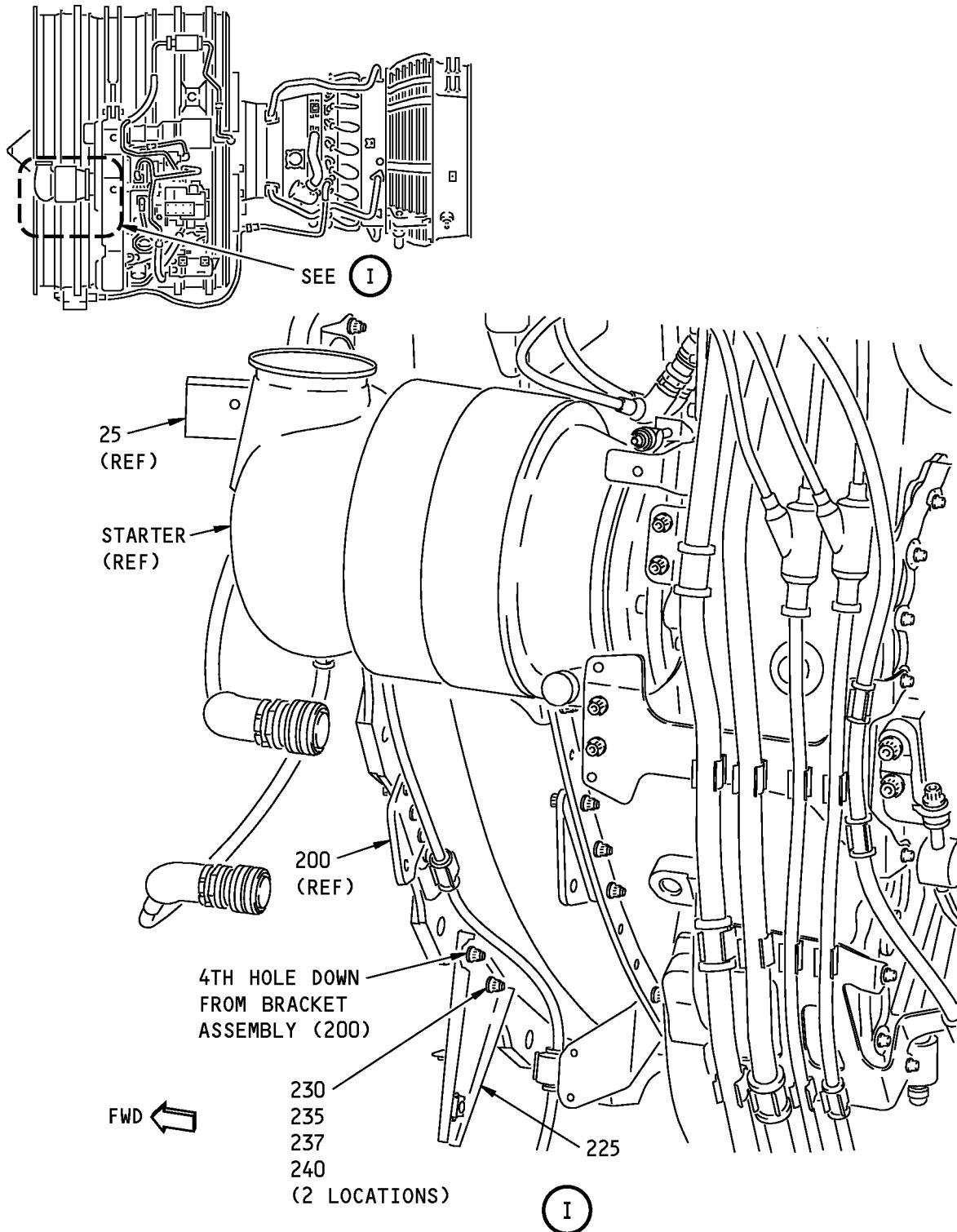
71-00-02

P/P BUILDUP FIGURE 5-1

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POWERPLANT BUILDUP MANUAL

F38225 S00041153695_V2

Bracket Installation - Lower Left Side Fan Case
Figure 5-1 (Sheet 9)

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P/P BUILDUP FIGURE 5-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
5-1		BRACKET INSTALLATION - LOWER LEFT SIDE FAN CASE (FIGURE 5-1, SHEET 9) ATTACH BRACKET ASSY (225) TO 4TH AND 6TH HOLES DOWN FROM BRACKET DETAIL (200) ON FLANGE A1. USE BOLTS (230), WASHERS (235, 237) AND NUTS (240).				
225	332A2910-165	. BRACKET ASSY	AFT	AFT		1
225	332A2910-101	. BRACKET ASSY (REPLACED BY 332A2910-165)	AFT	AFT	LTD	-
230	BACB30NM4K7	. BOLT (FWD SIDE)				2
235	BACW10BP4ACU	. WASHER (CSK) (UNDER BOLT HEAD)				2
237	BACW10P393CB	. WASHER (UNDER NUT)				2
240	AS3485-10	. NUT				2
		TIGHTEN BOLTS (230) TO 50-80 POUND-INCHES (5.6-9.0 NEWTON METERS).				

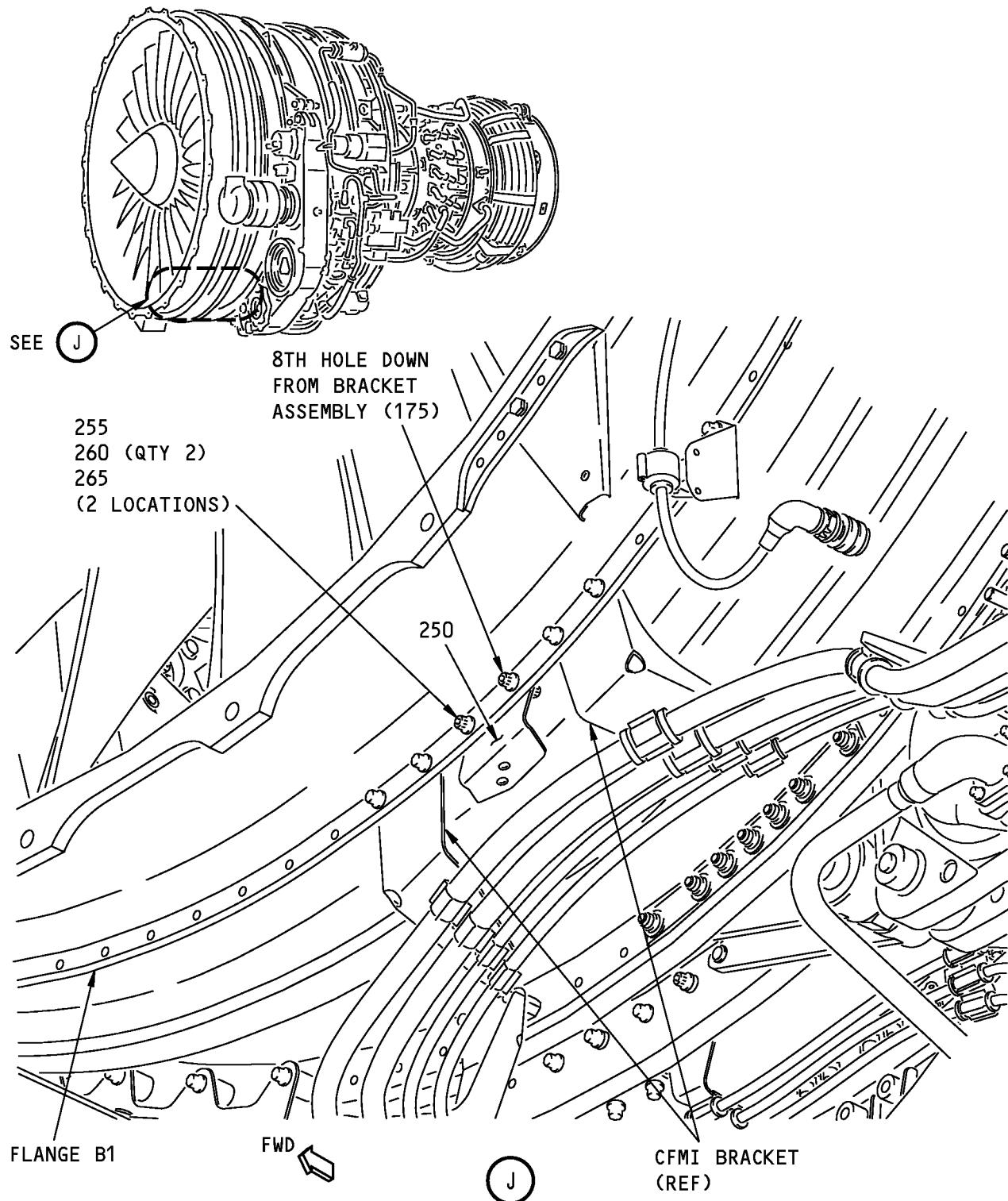
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P/P BUILDUP FIGURE 5-1

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POWERPLANT BUILDUP MANUAL

F38397 S00041153696_V2

Bracket Installation - Lower Left Side Fan Case
Figure 5-1 (Sheet 10)

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P/P BUILDUP FIGURE 5-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
5-1		BRACKET INSTALLATION - LOWER LEFT SIDE FAN CASE (FIGURE 5-1, SHEET 10) ATTACH BRACKET (250) TO 8TH AND 9TH HOLES DOWN FROM BRACKET ASSY (175) ON FLANGE B1 (BETWEEN TWO CFMI BRACKETS). USE BOLTS (255), WASHERS (260), AND NUTS (265).				
250	332A2920-119	. BRACKET ASSY	AFT	AFT		1
255	BACB30ZF4-12	. BOLT (FWD SIDE)				2
260	BACW10P393CB	. WASHER (UNDER BOLT HEAD AND UNDER NUT)				4
265	AS3485-10	. NUT				2
		TIGHTEN BOLTS (255) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS).				

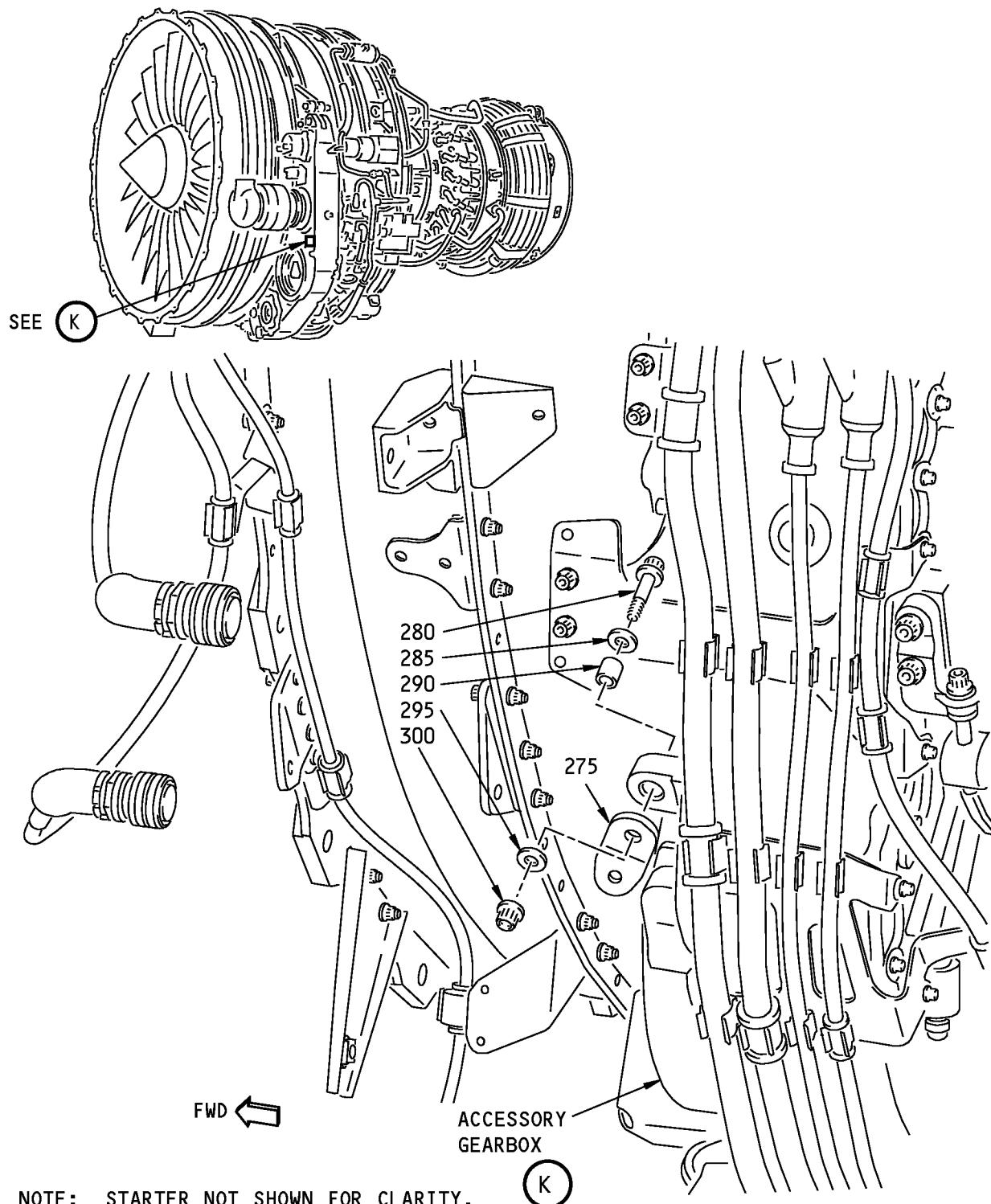
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P/P BUILDUP FIGURE 5-1

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POWERPLANT BUILDUP MANUAL

Bracket Installation - Lower Left Side Fan Case
Figure 5-1 (Sheet 11)

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P/P BUILDUP FIGURE 5-1

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737-600/700/800/900
POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
5-1		BRACKET INSTALLATION - LOWER LEFT SIDE FAN CASE (FIGURE 5-1, SHEET 11) ATTACH BRACKET DETAIL (275) TO ACCESSORY GEARBOX NEAR IDG PAD. USE BOLT (280), WASHER (285), BUSHING (290) AND NUT (295).				
275	332A2911-1	. BRACKET DETAIL				1
280	BACB30LE6K14	. BOLT				1
285	BACW10BP6ACU	. WASHER (CSK) (UNDER BOLT HEAD)				1
290	BACB28BA0608060	. BUSHING				1
295	NAS1149C0632R	. WASHER (UNDER NUT)				1
300	AS3485-12	. NUT				1
		TIGHTEN BOLT (280) TO 160-240 POUND-INCHES (18.0-27.2 NEWTON METERS).				

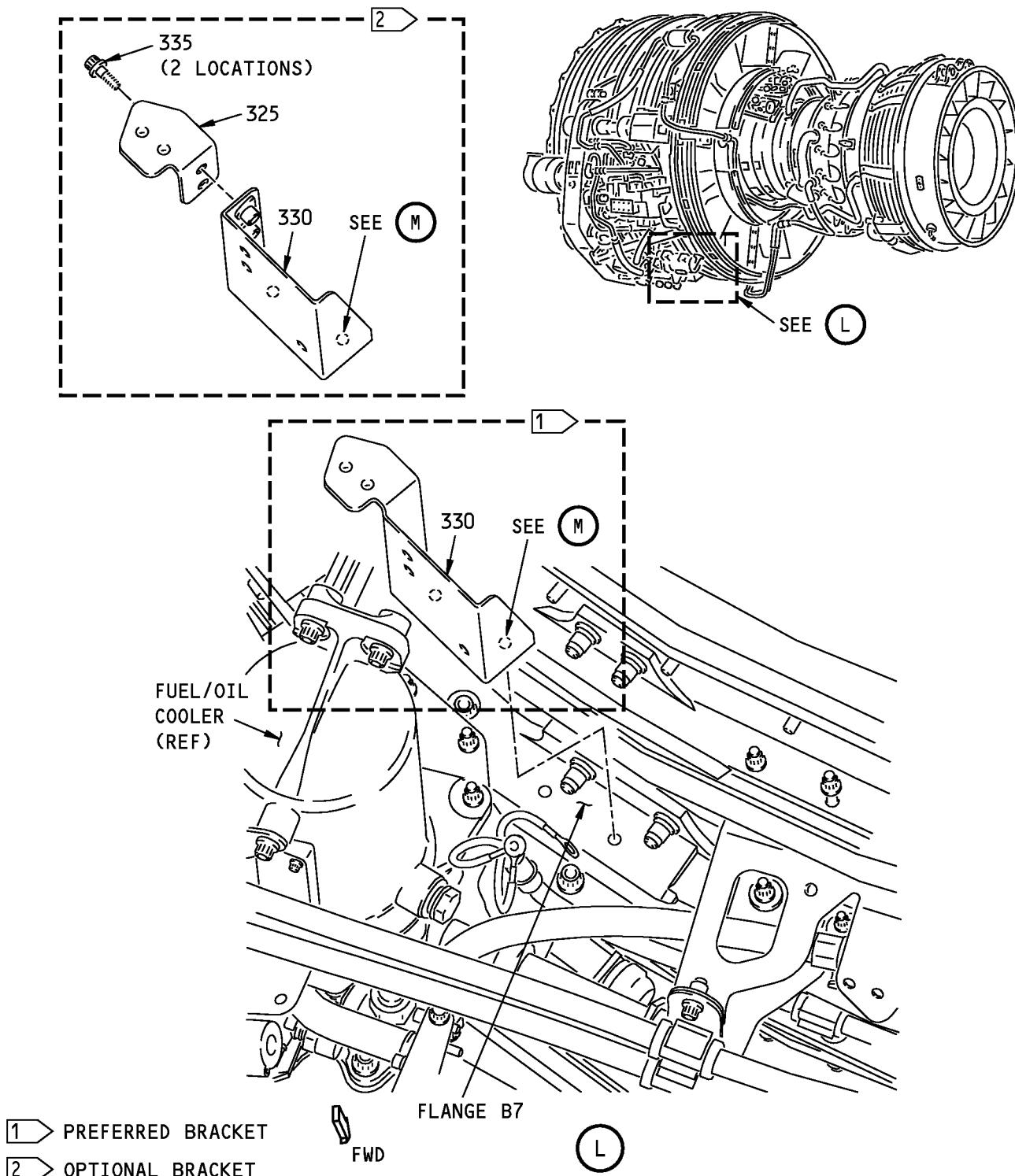
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P/P BUILDUP FIGURE 5-1

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737-600/700/800/900
POWERPLANT BUILDUP MANUAL

Bracket Installation - Lower Left Side Fan Case
Figure 5-1 (Sheet 12)

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P/P BUILDUP FIGURE 5-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
5-1		BRACKET INSTALLATION - LOWER LEFT SIDE FAN CASE (FIGURE 5-1, SHEET 12) <u>PREFERRED BRACKET CONFIGURATION:</u> ATTACH BRACKET ASSY (330) TO FLANGE ON SHEET 13. . BRACKET ASSY (1 PIECE BRACKET)				
330	332A2920-235	<u>OPTIONAL BRACKET CONFIGURATION:</u> ATTACH BRACKET ASSY (325) TO BRACKET ASSY (330) USING BOLTS (335). . BRACKET ASSY . BRACKET ASSY . BOLT (2 REQD)	AFT	AFT		1
325	332A2910-67					-
330	332A2930-54					-
335	BACB30ZF4-07	TIGHTEN BOLTS (335) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS).	OUTBD AFT	OUTBD AFT	OPT OPT OPT	-

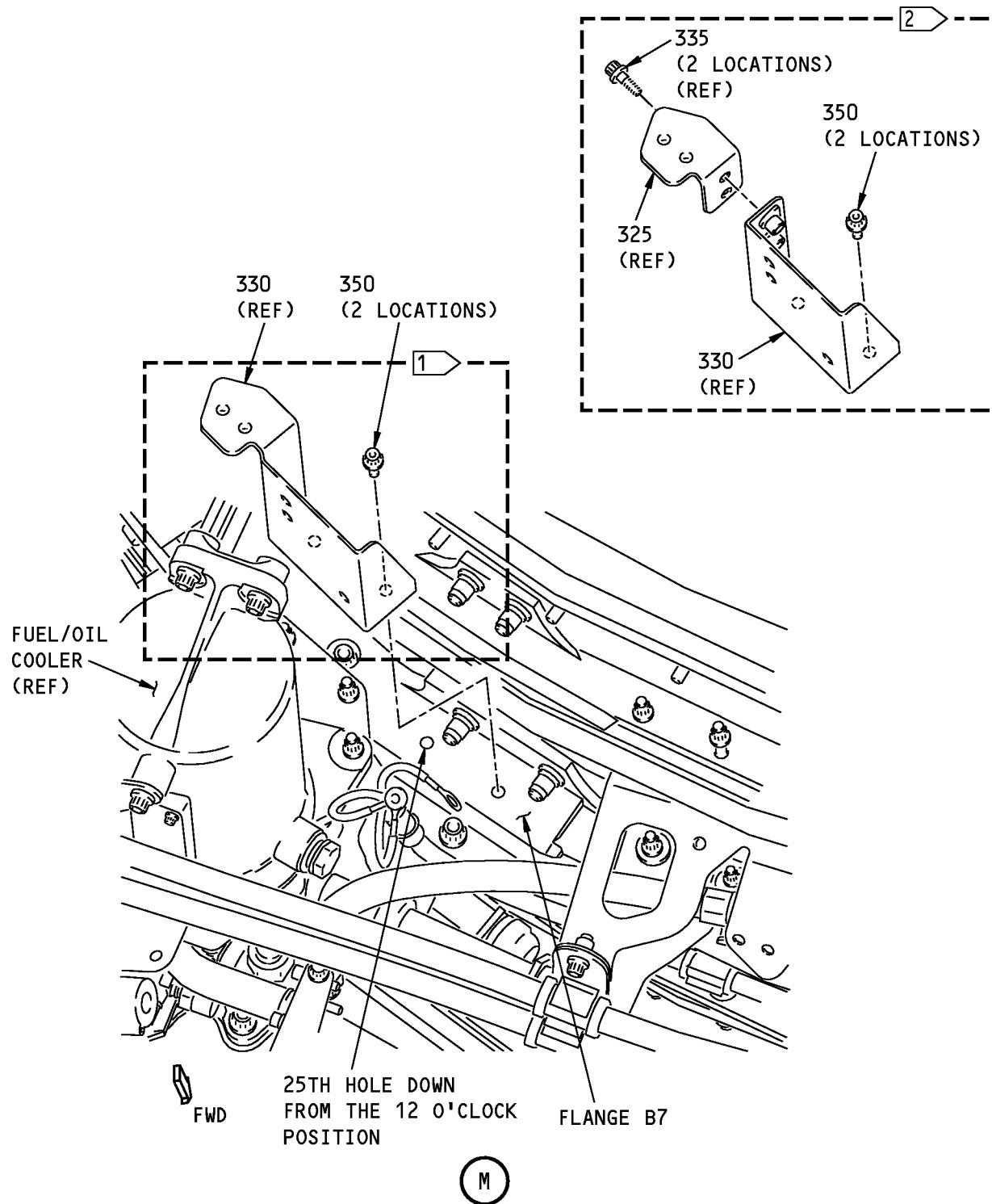
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P/P BUILDUP FIGURE 5-1

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737-600/700/800/900
POWERPLANT BUILDUP MANUAL

Bracket Installation - Lower Left Side Fan Case
Figure 5-1 (Sheet 13)

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P/P BUILDUP FIGURE 5-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
5-1 C1 350	B00130 BACB30ZF4-08	<p>BRACKET INSTALLATION - LOWER LEFT SIDE FAN CASE (FIGURE 5-1, SHEET 13)</p> <p>CLEAN MATING SURFACES OF BRACKET (330) AND 25TH AND 26TH HOLES DOWN FROM 12 O'CLOCK ON FLANGE B7 WITH alcohol, B00130 (C1). MAKE SURE YOU REMOVE ALL GREASE AND OTHER CONTAMINANTS.</p> <p>. ALCOHOL</p> <p>ATTACH BRACKET ASSY (330) TO FLANGE B7 WITH BOLTS (350).</p> <p>. BOLT</p> <p>TIGHTEN BOLTS (350) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS).</p>		CON	AR 2	

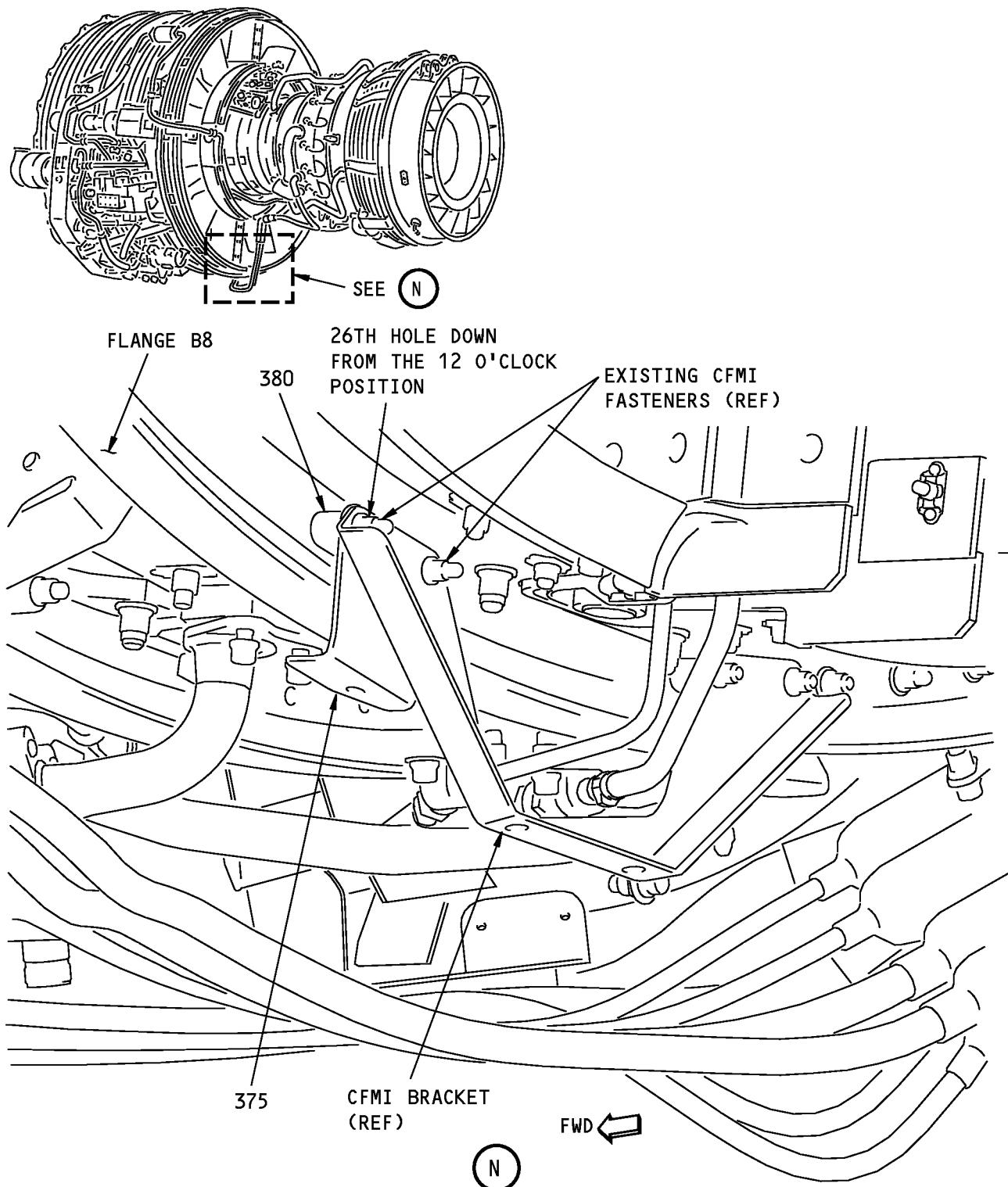
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P/P BUILDUP FIGURE 5-1

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737-600/700/800/900
POWERPLANT BUILDUP MANUAL

Bracket Installation - Lower Left Side Fan Case
Figure 5-1 (Sheet 14)

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P/P BUILDUP FIGURE 5-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
5-1		<p>BRACKET INSTALLATION - LOWER LEFT SIDE FAN CASE (FIGURE 5-1, SHEET 14)</p> <p>REMOVE EXISTING CFMI FASTENERS AND SPACER FROM 26TH AND 27TH HOLES DOWN FROM 12 O'CLOCK ON FLANGE B8.</p> <p>APPLY THIN COATING OF ANTI-SEIZE compound, D50004 (C2) TO EXISTING CFMI FASTENERS.</p> <p>ATTACH BRACKET ASSY (375) AND SPACERS (380) OR BRACKET DETAIL (380) BETWEEN CFMI BRACKET AND FLANGE B8 USING EXISTING FASTENERS.</p> <p>. BRACKET ASSY . BRACKET ASSY (OPTIONAL TO 332A2910-141) . SPACER^[2] . BRACKET DETAIL (1 REQD)^[2] . COMPOUND</p> <p>TIGHTEN EXISTING CFMI FASTENERS TO 98-110 POUND-INCHES (11.1-12.4 NEWTON METERS).</p> <p>*[2] QTY (1) 332A2930-60 BRACKET DETAIL OPTIONAL TO QTY (2) BACS18K25-39W SPACER.</p>				
375	332A2910-141		AFT	FWD		1
375	332A2910-104		AFT	FWD	OPT	-
380	BACS18K25-39W		AFT			2
380	332A2930-60		AFT		OPT	-
C2	D50004				CON	AR

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P/P BUILDUP FIGURE 5-1

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FIGURE 6-1

**BRACKET INSTALLATION - RIGHT SIDE FAN
CASE**

REF QEC TASK NO.: 6

REF DWG: 332A2900

NOTE: ALL STANDARDS AND ATTACHING HARDWARE FOR THIS FIGURE WILL BE PACKAGED
IN QEC TASK NO. 110.

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P/P BUILDUP FIGURE 6-1

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THIS SHEET NOT USED

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Bracket Installation - Right Side Fan Case
Figure 6-1 (Sheet 1)

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P/P BUILDUP FIGURE 6-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
6-1		BRACKET INSTALLATION - RIGHT SIDE FAN CASE (FIGURE 6-1, SHEET 1) THIS SHEET NOT USED		

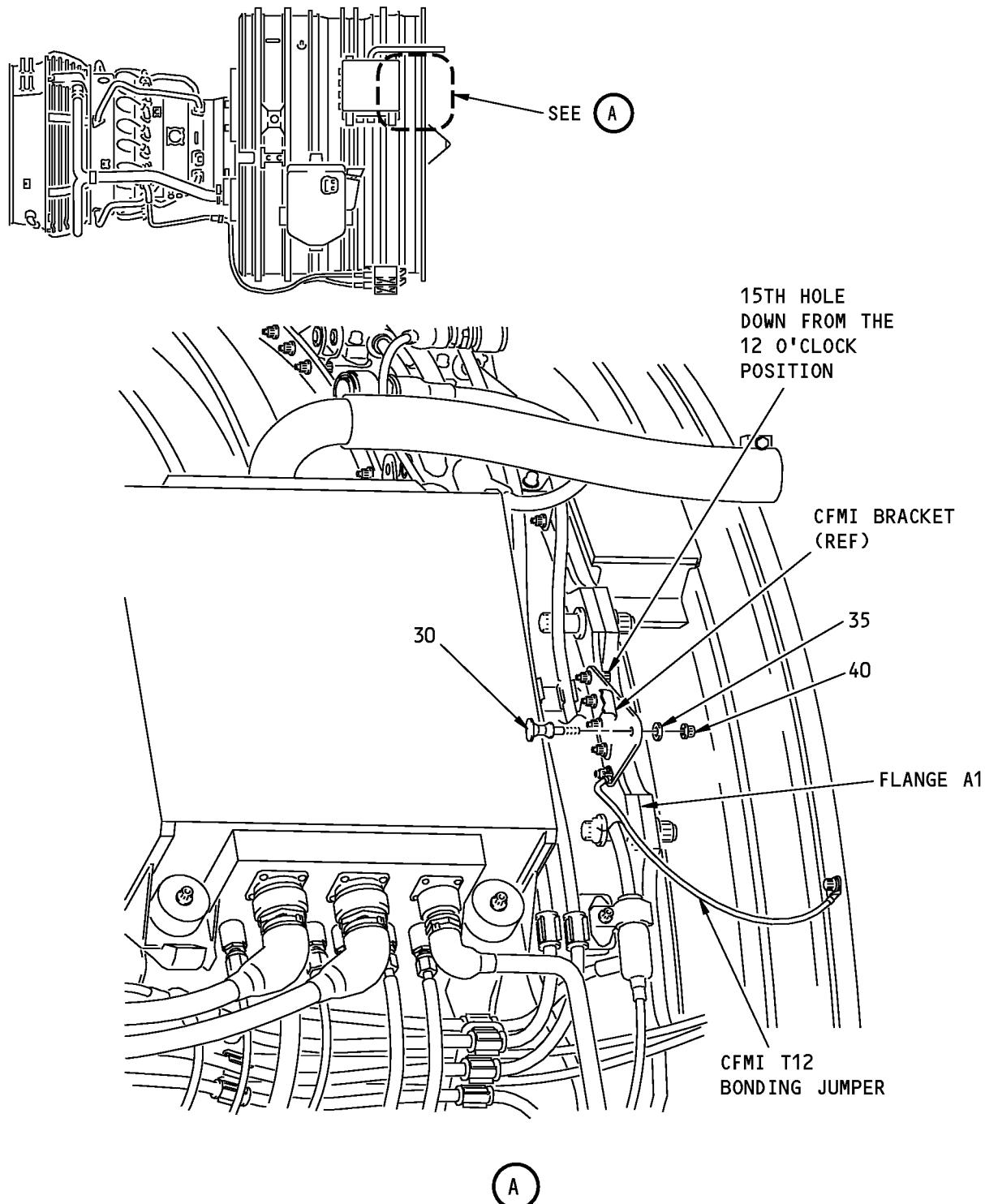
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P/P BUILDUP FIGURE 6-1

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737-600/700/800/900
POWERPLANT BUILDUP MANUALBracket Installation - Right Side Fan Case
Figure 6-1 (Sheet 2)

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P/P BUILDUP FIGURE 6-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
6-1		BRACKET INSTALLATION - RIGHT SIDE FAN CASE (FIGURE 6-1, SHEET 2) ATTACH RECEIVER (30) TO HOLE ON CFMI BRACKET LOCATED ON 15TH THRU 19TH HOLES DOWN FROM 12 O'CLOCK POSITION ON FLANGE A1. USE WASHER (35) AND NUT (40). 30 370D1005-5 35 NAS1149C0432R 40 BACN11Z4CK . RECEIVER . WASHER (UNDER NUT) . NUT TIGHTEN NUT (40) TO 65-100 POUND-INCHES (7.3-11.3 NEWTON METERS).				
			AFT			1 1 1

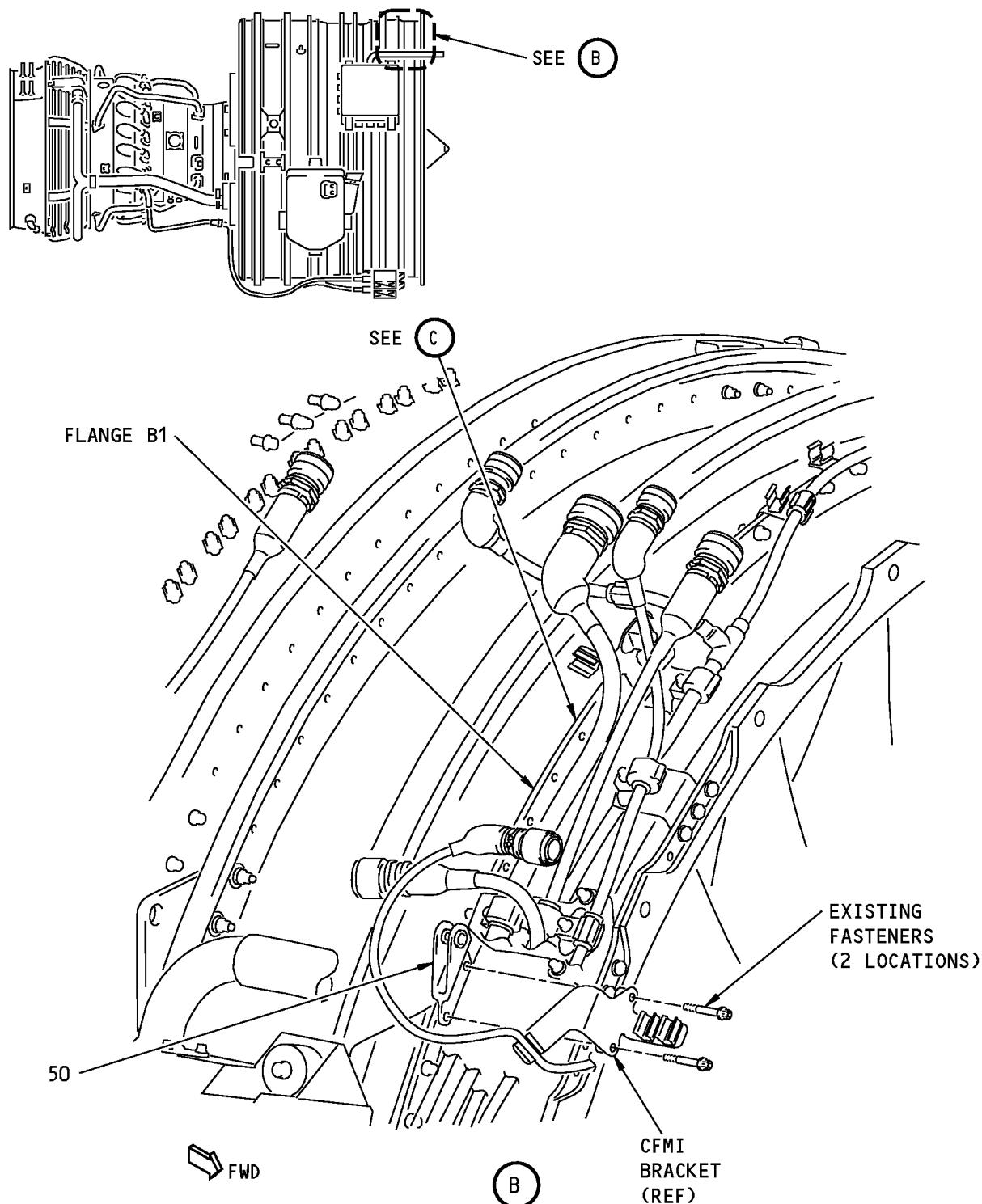
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P/P BUILDUP FIGURE 6-1

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POWERPLANT BUILDUP MANUAL

Bracket Installation - Right Side Fan Case
Figure 6-1 (Sheet 3)

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P/P BUILDUP FIGURE 6-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
6-1 50	332A2930-1	<p>BRACKET INSTALLATION - RIGHT SIDE FAN CASE (FIGURE 6-1, SHEET 3)</p> <p>REMOVE EXISTING CFMI FASTENERS AND CFMI BRACKET FROM FLANGE B1. INSTALL BRACKET ASSY (50) BETWEEN FLANGE B1 AND CFMI BRACKET. REINSTALL CFMI BRACKET USING EXISTING CFMI FASTENERS.</p> <p>. BRACKET ASSY</p> <p>TIGHTEN EXISTING CFMI FASTENERS TO 100-112 POUND-INCHES (11.3-12.7 NEWTON METERS).</p>	FWD			1

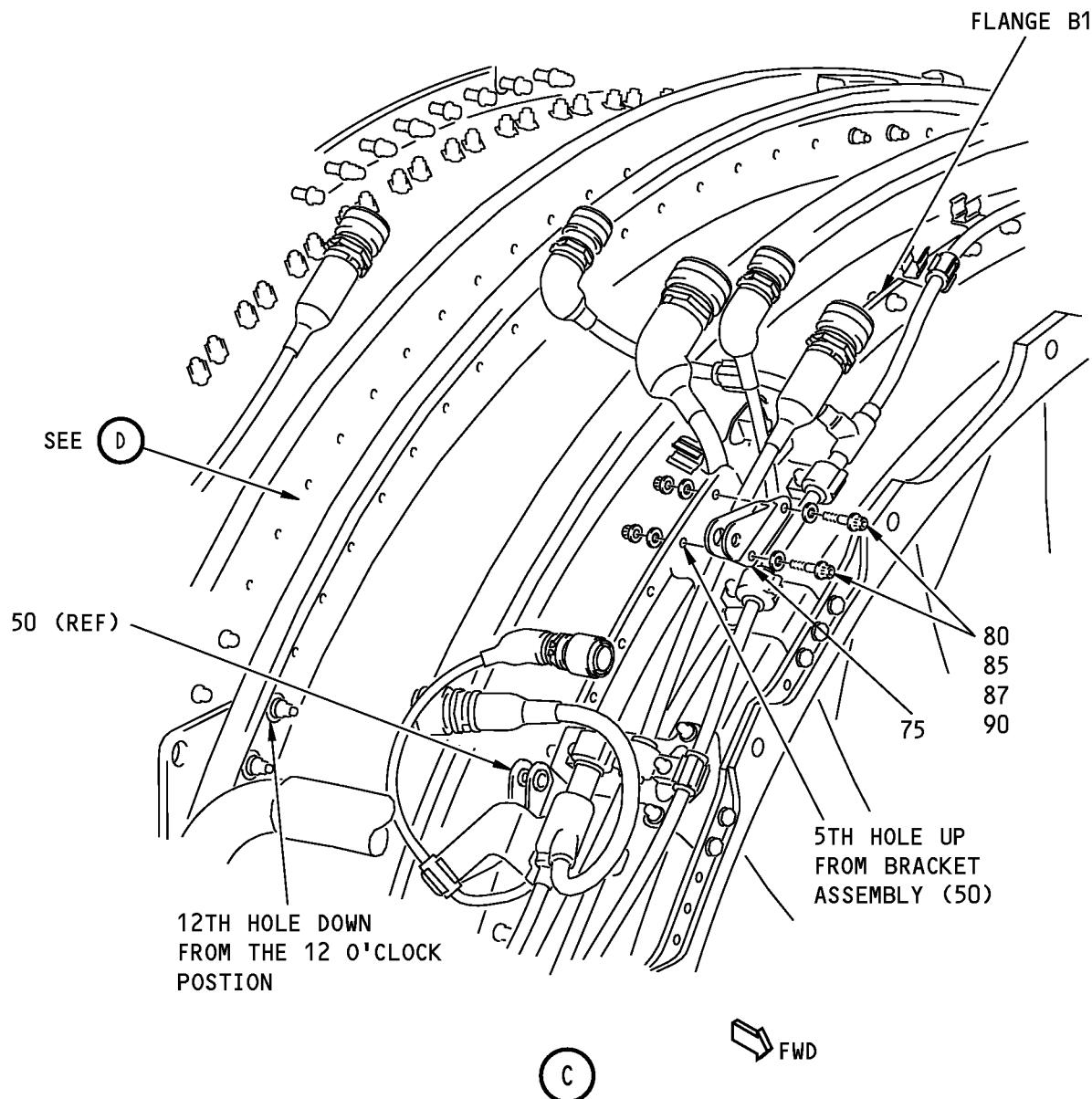
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P/P BUILDUP FIGURE 6-1

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POWERPLANT BUILDUP MANUAL

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Bracket Installation - Right Side Fan Case
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P/P BUILDUP FIGURE 6-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
6-1		BRACKET INSTALLATION - RIGHT SIDE FAN CASE (FIGURE 6-1, SHEET 4) ATTACH BRACKET ASSY (75) TO 5TH AND 6TH HOLES UP FROM BRACKET ASSY (50) ON FLANGE B1. USE BOLTS (80), WASHERS (85, 87) AND NUTS (90). 75 332A2930-1 . BRACKET ASSY 80 BACB30ZF4-14 . BOLT (FWD SIDE) 85 NAS1149C0432R . WASHER (UNDER BOLT HEAD) 87 BACW10P393CB . WASHER (UNDER NUT) 90 AS3485-10 . NUT TIGHTEN BOLTS (80) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS).	FWD			
						1 2 2 2 2

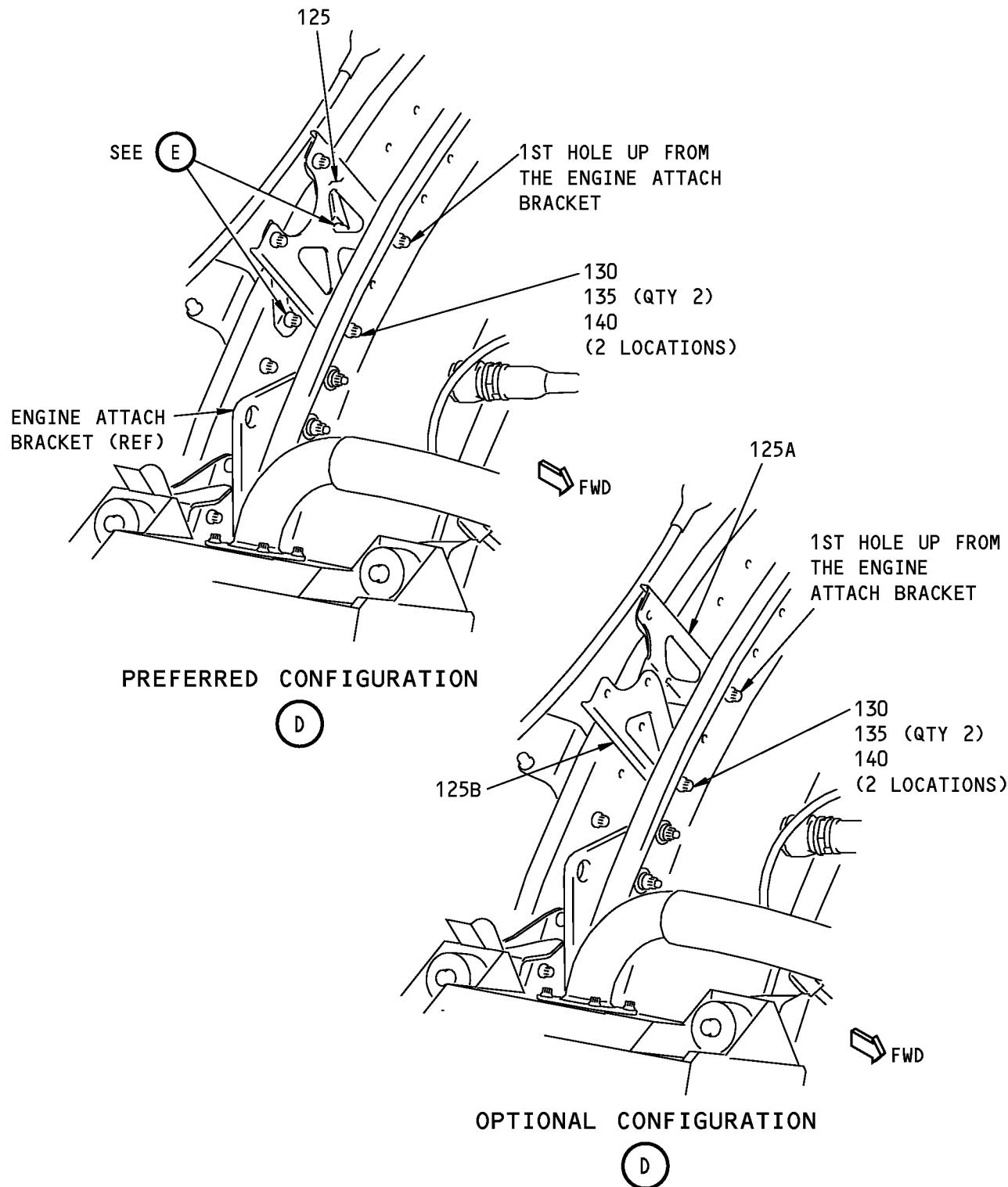
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P/P BUILDUP FIGURE 6-1

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POWERPLANT BUILDUP MANUAL

F37825 S00041153719_V2

Bracket Installation - Right Side Fan Case
Figure 6-1 (Sheet 5)

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P/P BUILDUP FIGURE 6-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
6-1		<p>BRACKET INSTALLATION - RIGHT SIDE FAN CASE (FIGURE 6-1, SHEET 5)</p> <p>PREFERRED CONFIGURATION:</p> <p>ATTACH BRACKET ASSY (125) TO 1ST AND 3RD HOLES UP FROM ENGINE ATTACH BRACKET ON FLANGE B4. USE BOLTS (130), WASHERS (135) AND NUTS (140).</p> <p>OPTIONAL CONFIGURATION:</p> <p>ATTACH BRACKET (125B) TO 1ST HOLE UP FROM ENGINE ATTACH BRACKET AND ATTACH BRACKET (125A) TO 3RD HOLE UP. USE BOLTS (130), WASHERS (135) AND NUTS (140).</p> <p>NOTE: DO NOT INSTALL A FASTENER BETWEEN BRACKETS (125A) AND (125B) AT THIS TIME.</p>				
125	332A2910-99	. BRACKET	AFT			1
125A	332A2910-95	. BRACKET (OPTIONAL) ^{*[1]}	AFT		OPT	-
125B	332A2910-96	. BRACKET (OPTIONAL) ^{*[1]}	AFT		OPT	-
130	BACB30ZF4-14	. BOLT (FWD SIDE)				2
135	BACW10P393CB	. WASHER (UNDER BOLT HEAD AND UNDER NUT)				4
140	AS3485-10	. NUT				2
		TIGHTEN BOLTS (130) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS).				
		*[1] BRACKETS (125A) AND (125B) TOGETHER ARE OPTIONAL TO BRACKET (125).				

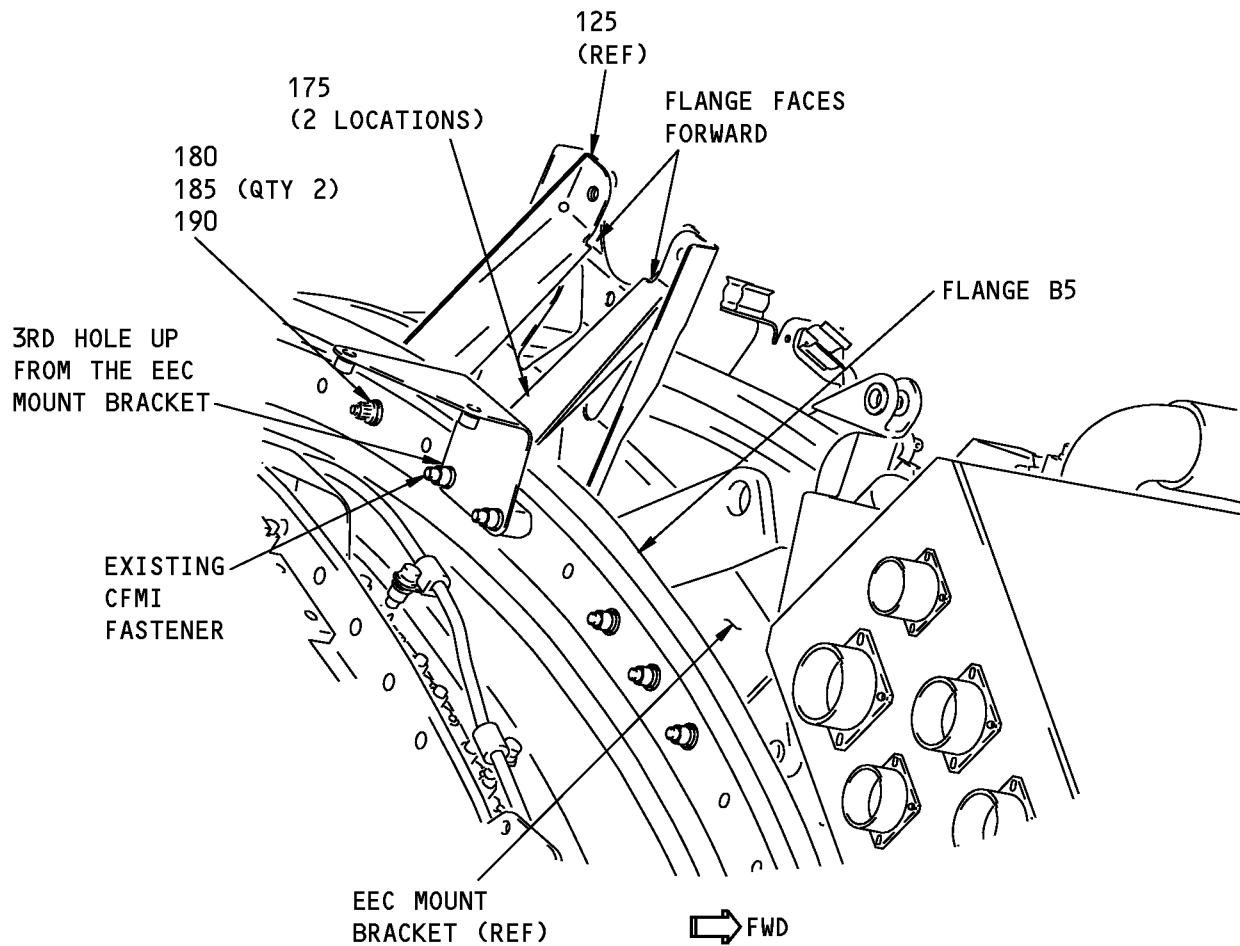
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P/P BUILDUP FIGURE 6-1

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POWERPLANT BUILDUP MANUAL

F37792 S00041153720_V2

Bracket Installation - Right Side Fan Case
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P/P BUILDUP FIGURE 6-1
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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
6-1		<p>BRACKET INSTALLATION - RIGHT SIDE FAN CASE (FIGURE 6-1, SHEET 6)</p> <p>REMOVE EXISTING CFMI FASTENER FROM 3RD HOLE UP FROM EEC MOUNT BRACKET ON FLANGE B5.</p> <p>ATTACH BRACKET ASSYS (175) TO 3RD AND 5TH HOLES UP FROM EEC MOUNT BRACKET ON FLANGE B5. USE EXISTING CFMI FASTENER AT LOWER HOLE AND BOLT (180), WASHER (185) AND NUT (190) AT UPPER HOLE.</p> <p>NOTE: BRACKETS (125) AND (175) WILL BE CONNECTED TO INLET COWL TAI DUCT (REF INLET COWL TAI SYSTEM INSTALLATION/Figure 27-1).</p>				
175	332A2920-132	. BRACKET ASSY	FWD	FWD		2
175	332A2920-29	. BRACKET ASSY (OPTIONAL)	FWD	FWD	OPT	-
180	BACB30ZF4-14	. BOLT (FWD SIDE)				1
185	BACW10P393CB	. WASHER (UNDER BOLT HEAD AND UNDER NUT)				2
190	AS3485-10	. NUT				1
		TIGHTEN BOLT (180) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS). TIGHTEN EXISTING CFMI FASTENER TO 100-112 POUND-INCHES (11.3-12.7 NEWTON METERS).				

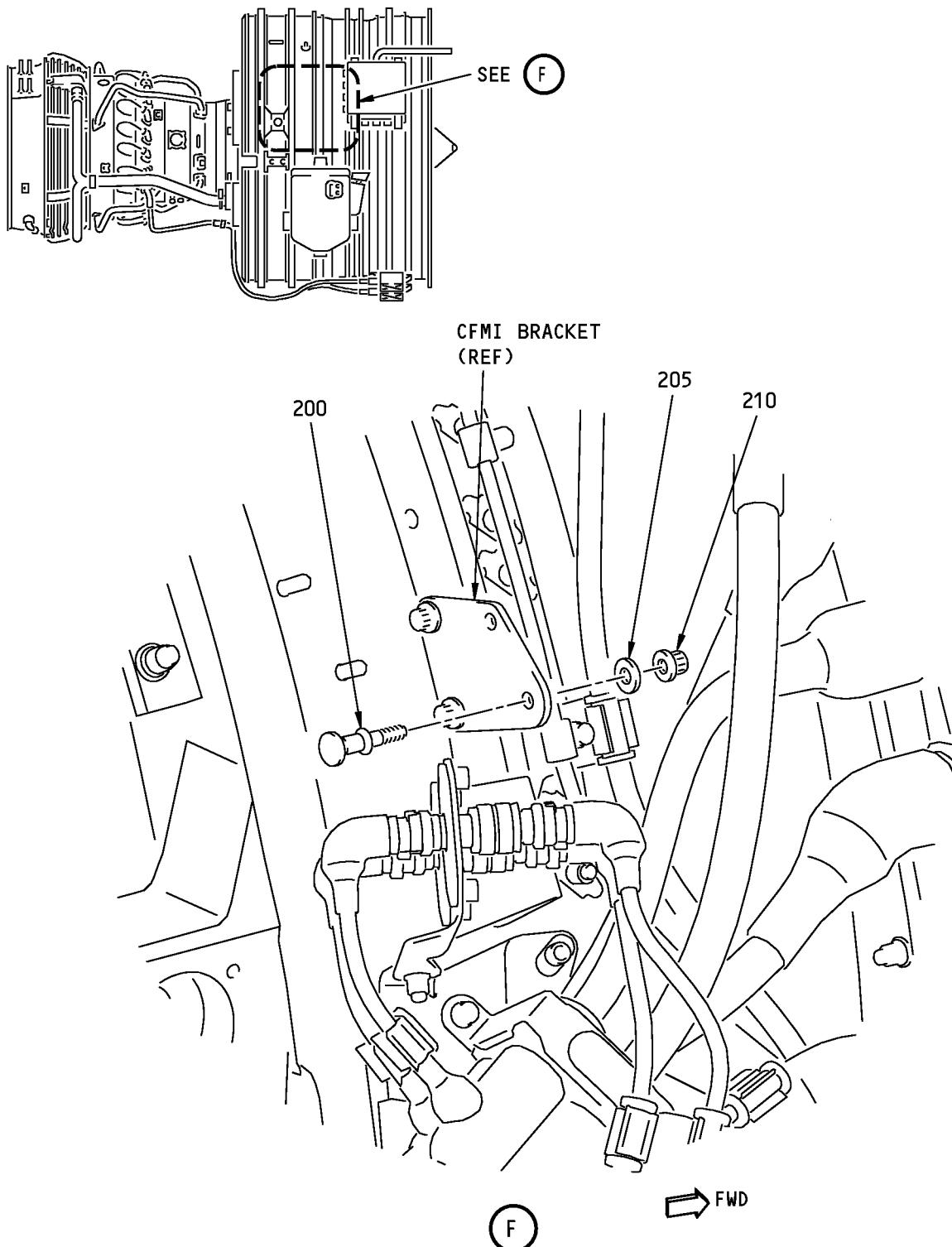
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P/P BUILDUP FIGURE 6-1

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POWERPLANT BUILDUP MANUAL

Bracket Installation - Right Side Fan Case
Figure 6-1 (Sheet 7)

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P/P BUILDUP FIGURE 6-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
6-1		BRACKET INSTALLATION - RIGHT SIDE FAN CASE (FIGURE 6-1, SHEET 7) ATTACH RECEIVER (200) TO HOLE ON CFMI BRACKET ON 21ST AND 22ND HOLES DOWN FROM 12 O'CLOCK POSITION ON FLANGE B6. USE WASHER (205) AND NUT (210). . RECEIVER . WASHER (UNDER NUT) . NUT TIGHTEN NUT (210) TO 65-100 POUND-INCHES (7.3-11.3 NEWTON METERS).				
200	370D1005-5					1
205	NAS1149C0432R					1
210	BACN11Z4CK		AFT			1

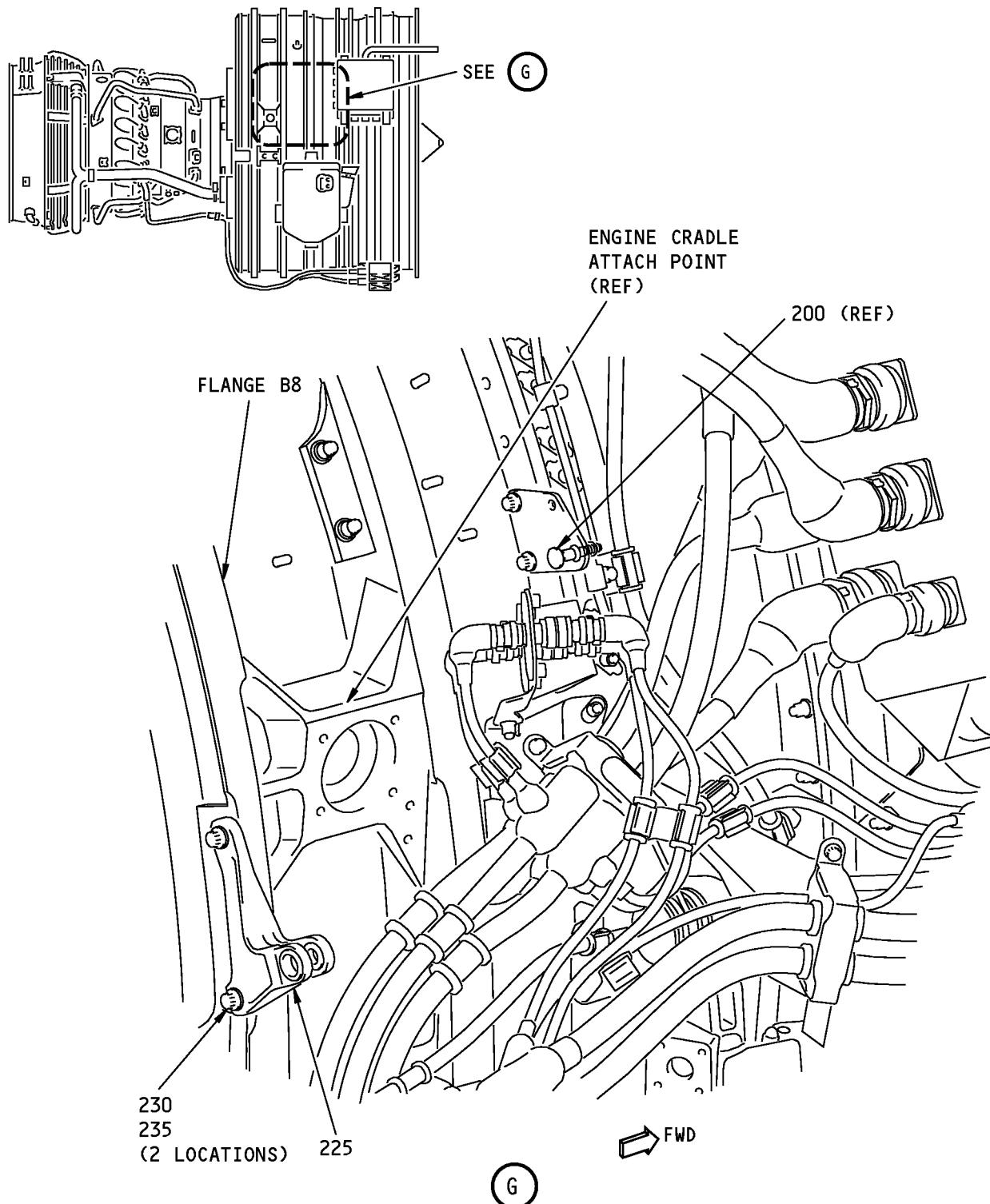
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P/P BUILDUP FIGURE 6-1

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POWERPLANT BUILDUP MANUAL

Bracket Installation - Right Side Fan Case
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P/P BUILDUP FIGURE 6-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
6-1		BRACKET INSTALLATION - RIGHT SIDE FAN CASE (FIGURE 6-1, SHEET 8) APPLY A THIN COATING OF ANTI-SEIZE compound, D50004 (C6) TO BOLTS (230). ATTACH BRACKET ASSY (225) TO FLANGE B8 JUST ABOVE 3 O'CLOCK POSITION AND AFT OF ENGINE CRADLE ATTACH POINT. USE BOLTS (230) AND WASHERS (235). . BRACKET ASSY . BOLT (AFT SIDE) . WASHER (UNDER BOLT HEAD) . COMPOUND TIGHTEN BOLTS (230) TO 123-136 POUND-INCHES (13.89-15.36 NEWTON METERS).				
225	332A2930-62		AFT			1
230	BACB30LE5U6					2
235	BACW10BP5ACU					2
C6	D50004			CON		AR

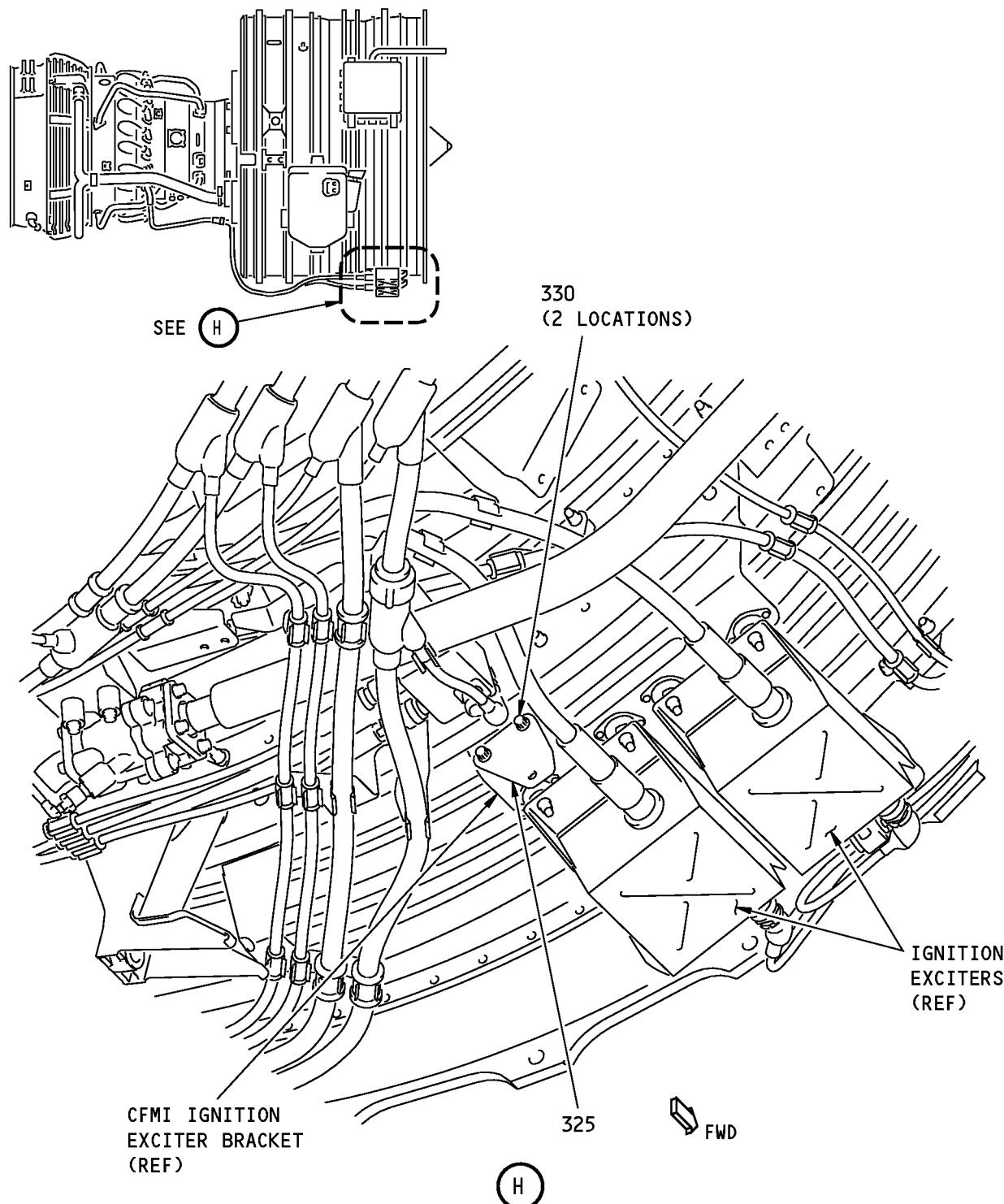
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P/P BUILDUP FIGURE 6-1

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POWERPLANT BUILDUP MANUAL

Bracket Installation - Right Side Fan Case
Figure 6-1 (Sheet 9)

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P/P BUILDUP FIGURE 6-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
6-1 325 330	332A2910-26 BACB30ZF4-06	<p>BRACKET INSTALLATION - RIGHT SIDE FAN CASE (FIGURE 6-1, SHEET 9)</p> <p>ATTACH BRACKET (325) TO LOWER AFT SIDE OF CFMI IGNITION EXCITER BRACKET ON FLANGE B4. USE BOLTS (330).</p> <p>. BRACKET . BOLT</p> <p>TIGHTEN BOLTS (330) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS).</p>				1 2

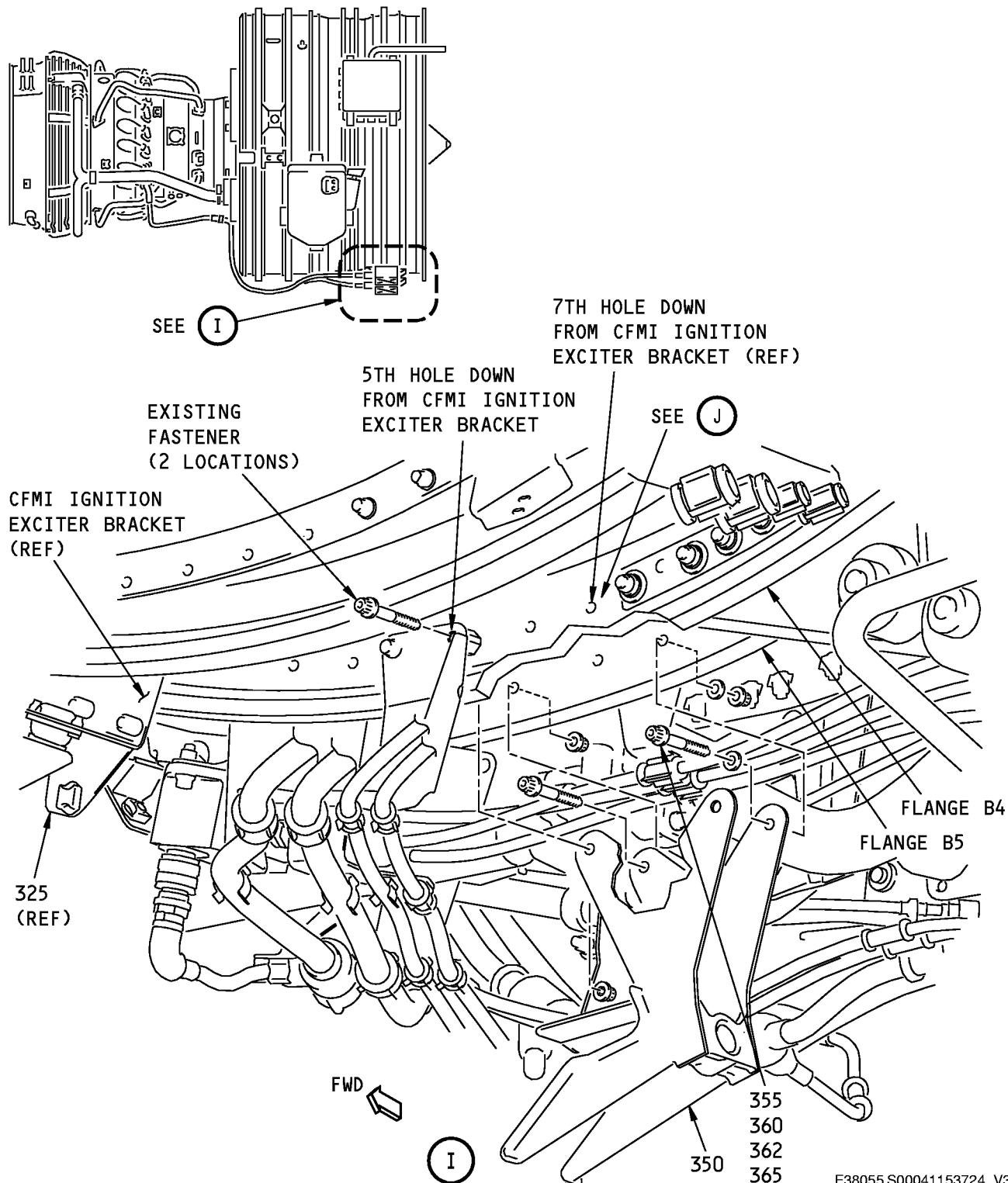
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P/P BUILDUP FIGURE 6-1

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POWERPLANT BUILDUP MANUAL

F38055 S00041153724_V3

Bracket Installation - Right Side Fan Case
Figure 6-1 (Sheet 10)

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P/P BUILDUP FIGURE 6-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
6-1		<p>BRACKET INSTALLATION - RIGHT SIDE FAN CASE (FIGURE 6-1, SHEET 10)</p> <p>REMOVE EXISTING CFMI FASTENERS FROM 5TH AND 7TH HOLES DOWN ON FLANGE B4 FROM CFMI IGNITION EXCITER BRACKET AND 7TH HOLE DOWN ON FLANGE B5.</p> <p>POSITION BRACKET ASSY (350) BETWEEN FLANGES B4 AND B5 AND ATTACH WITH EXISTING CFMI FASTENERS AT 5TH HOLES DOWN ON FLANGES B4 AND B5 AND BOLT (355), WASHERS (360, 362) AND NUT (365) AT 7TH HOLE DOWN ON FLANGE B5.</p> <p>NOTE: DO NOT INSTALL A FASTENER AT THE 7TH HOLE DOWN ON FLANGE B4 AT THIS TIME.</p> <p>. BRKT ASSY . BOLT (FWD SIDE) . WASHER (UNDER BOLT HEAD) . WASHER (UNDER NUT) . NUT</p> <p>TIGHTEN BOLT (355) TO 80-90 POUNDS-INCHES (9.0-10.1 NEWTON METERS) AND EXISTING CFM BOLTS TO 100-112 POUND-INCHES (11.3-12.6 NEWTON METERS).</p> <p>*[2] FORKS OF BRACKET ASSY (350) FACE RIGHT SIDE OF ENGINE (SIDE WITH THE OIL TANK).</p>				
350	332A2930-90			*[2]		1
355	BACB30ZF4-14					1
360	NAS1149C0432R					1
362	BACW10P393CB					1
365	AS3485-10					1

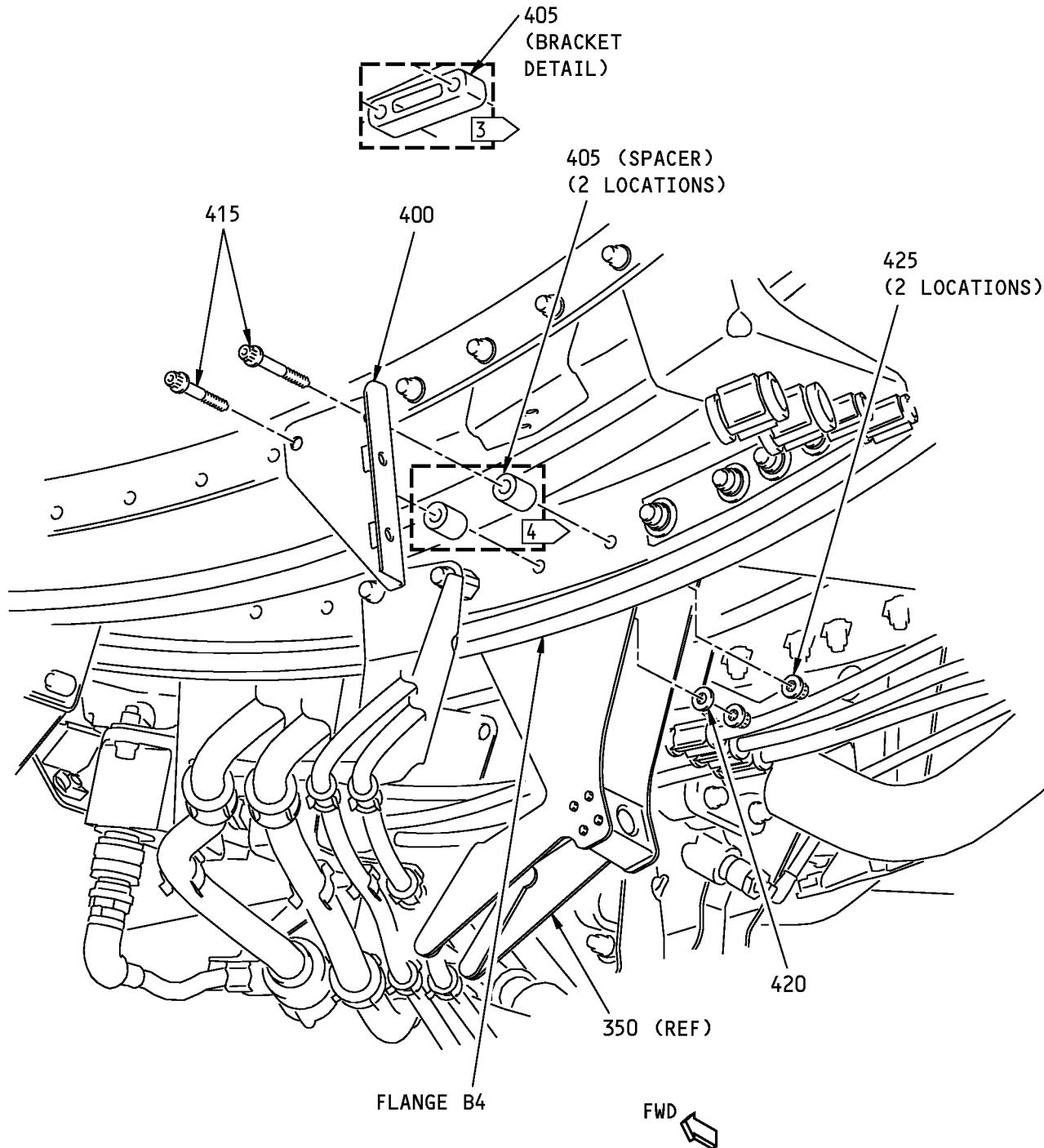
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P/P BUILDUP FIGURE 6-1

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POWERPLANT BUILDUP MANUAL

3 OPTIONAL CONFIGURATION

4 PREFERRED CONFIGURATION

F38076 S00041153725_V2

Bracket Installation - Right Side Fan Case
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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
6-1		BRACKET INSTALLATION - RIGHT SIDE FAN CASE (FIGURE 6-1, SHEET 11) AT REMAINING BOLT LOCATION ON BRACKET ASSY (350), ATTACH BRACKET ASSY (400) AND SPACERS (405) OR BRACKET DETAIL (405) TO FLANGE B4. USE BOLTS (415), WASHER (420) AND NUTS (425).				
400	332A2910-51	. BRACKET ASSY	FWD	FWD		1
405	BACS18K25-45W	. SPACER (PREFERRED CONFIGURATION)			OPT	2
405	332A2930-26	. BRACKET DETAIL (OPT CONFIGURATION)				-
415	BACB30ZF4-24	. BOLT (FWD SIDE)				2
420	BACW10P393CB	. WASHER (UNDER NUT)				1
425	AS3485-10	. NUT				2
		TIGHTEN BOLTS (415) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS).				

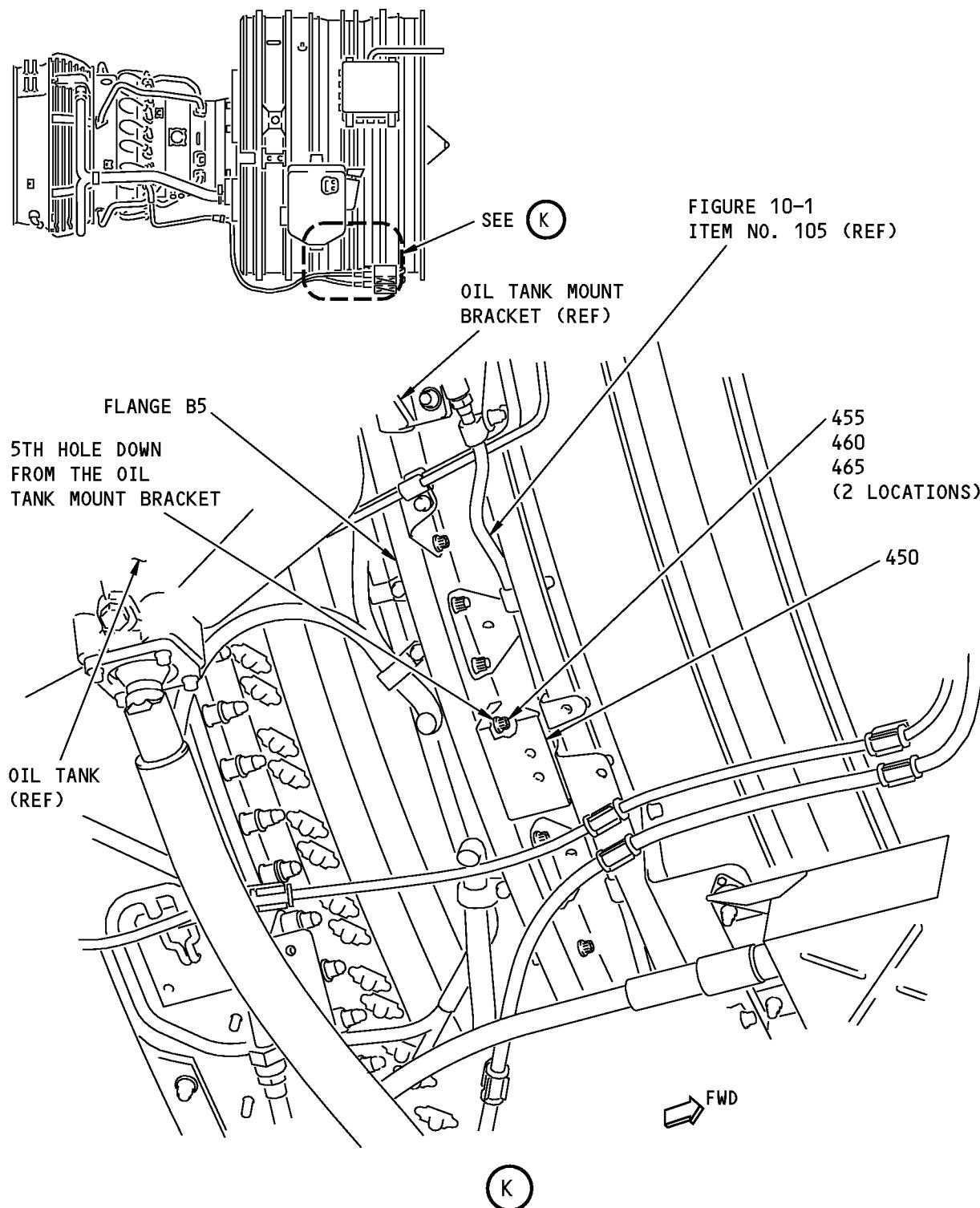
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P/P BUILDUP FIGURE 6-1

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737-600/700/800/900
POWERPLANT BUILDUP MANUALBracket Installation - Right Side Fan Case
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P/P BUILDUP FIGURE 6-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
6-1		<p>BRACKET INSTALLATION - RIGHT SIDE FAN CASE (FIGURE 6-1, SHEET 12)</p> <p>NOTE: DUE TO LIMITED ACCESS, IT IS RECOMMENDED THAT DRAINS INSTL - RIGHT SIDE FAN CASE/Figure 10-1 ITEM NO. (100) HOSE ASSY AND (105) TUBE ASSY BE INSTALLED PRIOR TO INSTALLATION OF BRACKET ASSY (450).</p> <p>CLEAN MATING SURFACES OF BRACKET ASSY (450) AND FLANGE B5 WITH alcohol, B00130 (C1). MAKE SURE YOU REMOVE ALL GREASE AND OTHER CONTAMINANTS.</p>				
450	332A2920-237	. BRACKET ASSY	FWD			1
450	332A2920-48	. BRACKET ASSY (OPTIONAL TO 332A2920-237)	FWD		OPT	-
C1	B00130	. ALCOHOL			CON	AR
		ATTACH BRACKET ASSY (450) TO 5TH AND 6TH HOLES DOWN FROM OIL TANK MOUNT BRACKET ON FLANGE B5. USE BOLTS (455), WASHERS (460) AND NUTS (465).				
455	BACB30ZF4-12	. BOLT (FWD SIDE)				2
460	BACW10P393CB	. WASHER (UNDER NUT)				2
465	AS3485-10	. NUT				2
		TIGHTEN BOLTS (455) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS).				

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P/P BUILDUP FIGURE 6-1

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FIGURE 7-1

**BRACKET INSTALLATION - LEFT SIDE CORE
CASE**

REF QEC TASK NO.: 7

REF DWG: 332A2900

NOTE: ALL STANDARDS AND ATTACHING HARDWARE FOR THIS FIGURE WILL BE PACKAGED
IN QEC TASK NO. 110.

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P/P BUILDUP FIGURE 7-1

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737-600/700/800/900
POWERPLANT BUILDUP MANUAL

THIS SHEET NOT USED

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Bracket Installation - Left Side Core Case
Figure 7-1 (Sheet 1)

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P/P BUILDUP FIGURE 7-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
7-1		BRACKET INSTALLATION - LEFT SIDE CORE CASE (FIGURE 7-1, SHEET 1) THIS SHEET NOT USED		

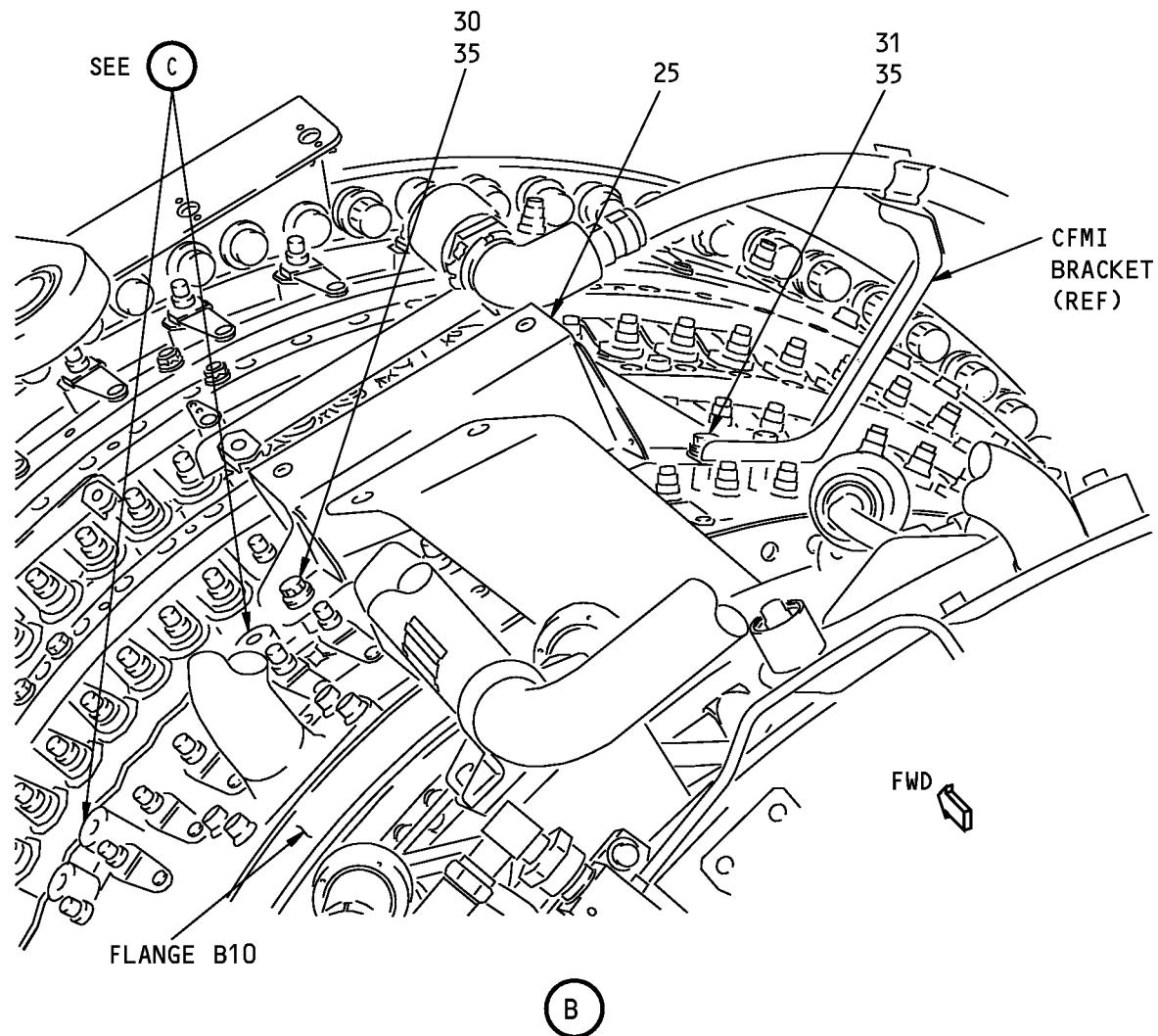
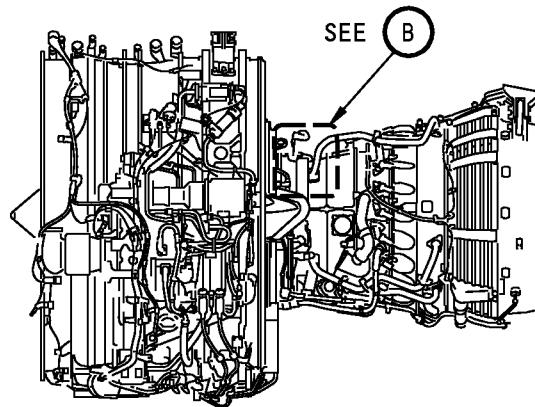
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P/P BUILDUP FIGURE 7-1

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POWERPLANT BUILDUP MANUAL

Bracket Installation - Left Side Core Case
Figure 7-1 (Sheet 2)

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P/P BUILDUP FIGURE 7-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
7-1		BRACKET INSTALLATION - LEFT SIDE CORE CASE (FIGURE 7-1, SHEET 2) CLEAN MATING SURFACES OF BRACKET ASSY (25) AND ENGINE BOSSES FWD OF FLANGE B10 WITH alcohol, B00130 (C1). MAKE SURE YOU REMOVE ALL GREASE AND OTHER CONTAMINANTS. . BRACKET ASSY . BRKT ASSY (OPTIONAL TO 332A2920-201) . ALCOHOL				
25	332A2920-201					1
25	332A2920-124					-
C1	B00130	APPLY LIGHT COATING OF Never-Seez NSBT-8N compound, D00006 (C2) TO BOLT (30) AND BOLT (31) THREADS. . BOLT . BOLT . NEVER-SEEZ NSBT-8N COMPOUND			OPT CON	AR
30	BACB30LE4HU1	LOOSELY ATTACH BRACKET ASSY (25) TO ENGINE BOSSES WITH LUBRICATED BOLTS (30, 31) AND WASHERS (35). POSITION UPPER FLANGE OF BRACKET UNDER CFMI BRACKET (IF INSTALLED).				1
31	BACB30LE4HU2					1
C2	D00006				CON	AR
35	BACW10BP4ACU	. WASHER (CSK)				2

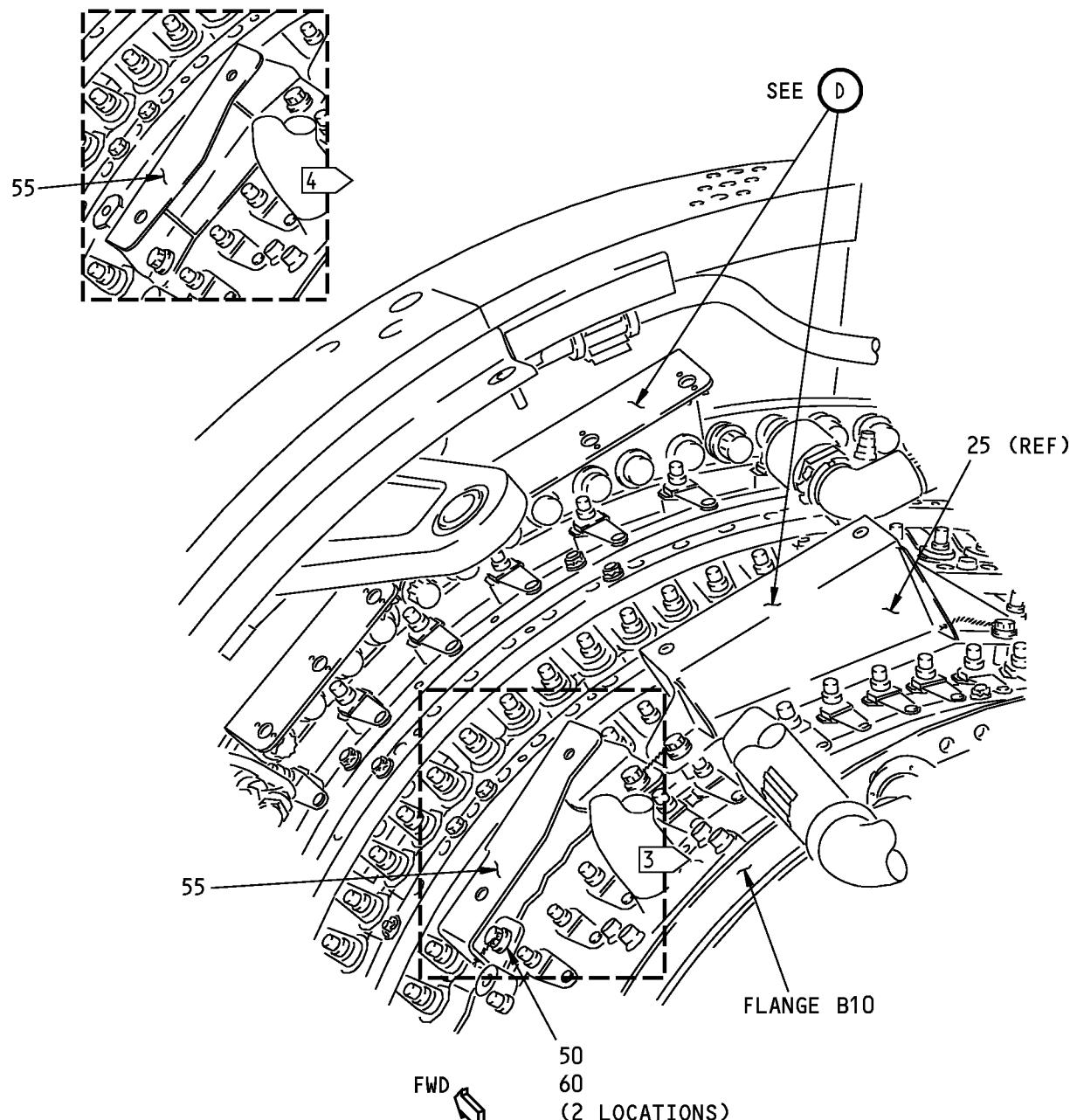
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P/P BUILDUP FIGURE 7-1

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POWERPLANT BUILDUP MANUAL

1 NOT USED

2 NOT USED

3 PREFERRED CONFIGURATION

4 OPTIONAL CONFIGURATION

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Bracket Installation - Left Side Core Case
Figure 7-1 (Sheet 3)

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P/P BUILDUP FIGURE 7-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
7-1		BRACKET INSTALLATION - LEFT SIDE CORE CASE (FIGURE 7-1, SHEET 3) APPLY LIGHT COATING OF Never-Seez NSBT-8N compound, D00006 (C2) TO BOLT (50) THREADS. . BOLT . NEVER-SEEZ NSBT-8N COMPOUND				
50 C2	BACB30LE4HU1 D00006	LOOSELY ATTACH BRACKET ASSY (55) TO ENGINE BOSSES FWD OF FLANGE B10 AT APPROXIMATELY 10 O'CLOCK POSITION WITH LUBRICATED BOLTS (50) AND WASHERS (60). . BRACKET ASSY . WASHER (CSK)				2 AR
55 60	332A2920-225 BACW10BP4ACU					1 2

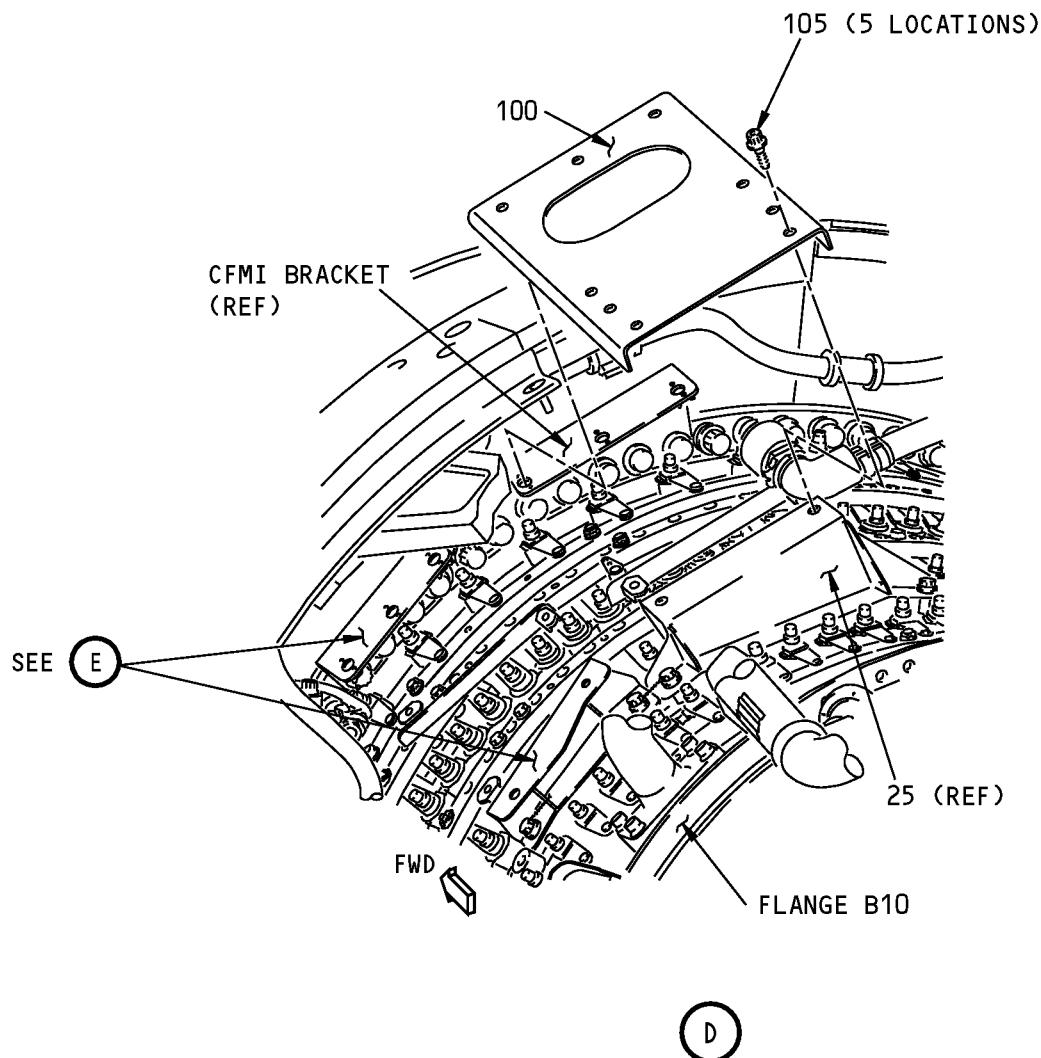
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P/P BUILDUP FIGURE 7-1

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POWERPLANT BUILDUP MANUAL

Bracket Installation - Left Side Core Case
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P/P BUILDUP FIGURE 7-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
7-1		BRACKET INSTALLATION - LEFT SIDE CORE CASE (FIGURE 7-1, SHEET 4) CLEAN MATING SURFACES OF CFMI BRACKET, BRACKET ASSY (100) AND BRACKET ASSY (25) WITH alcohol, B00130 (C1). 100 332A2920-199 . BRACKET ASSY 100 332A2920-143 . BRKT ASSY (OPTIONAL TO 332A2920-199) C1 B00130 . ALCOHOL ATTACH BRACKET ASSY (100) TO BRACKET BRACKET ASSY (25) AND CFMI BRACKET USING BOLTS (105). 105 BACB30ZF4-06 . BOLT TIGHTEN BOLTS (105) TO 70-80 POUND-INCHES (7.9-9.0 NEWTON METERS).				
				OPT CON		1 - AR
						5

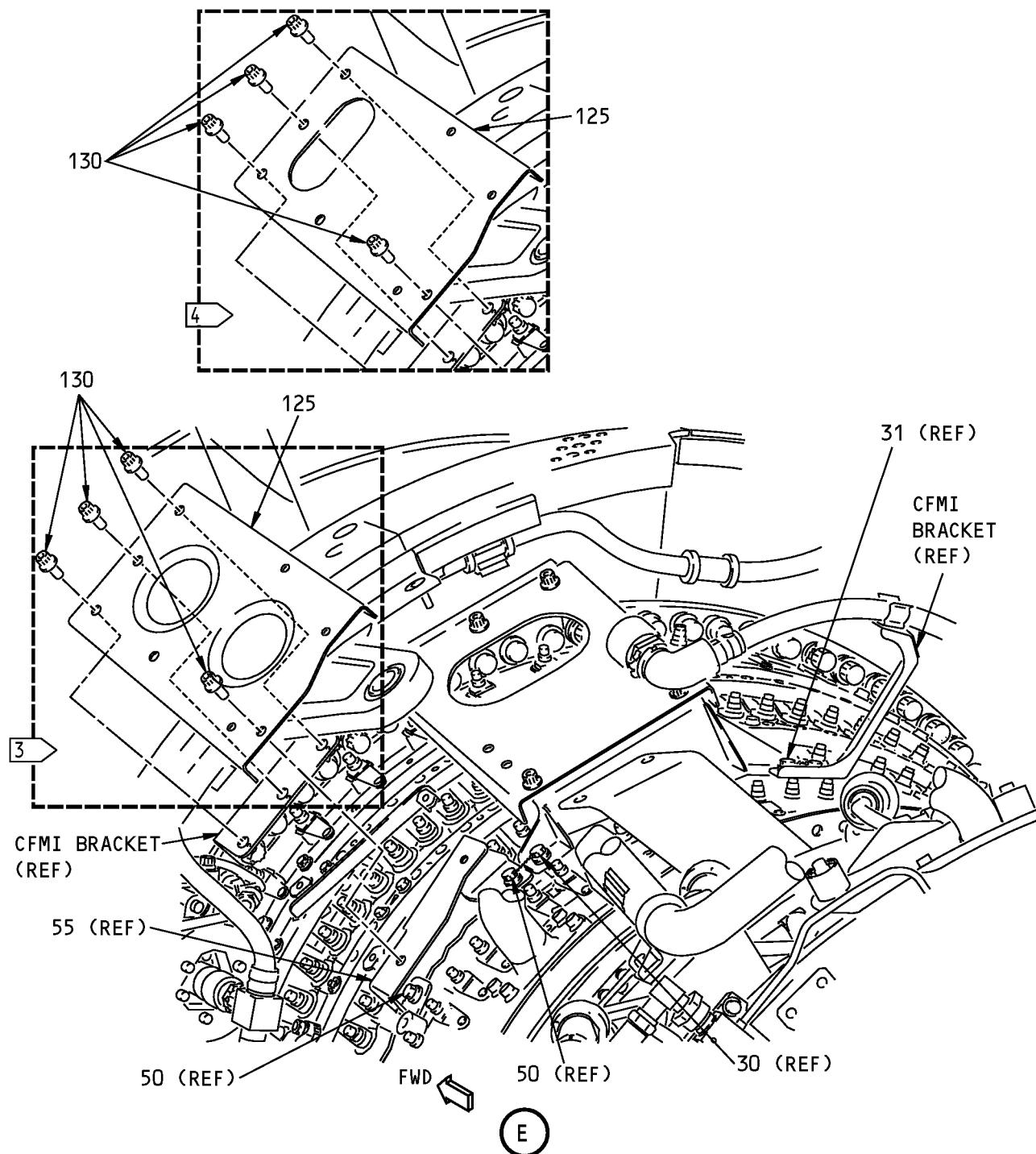
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P/P BUILDUP FIGURE 7-1

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POWERPLANT BUILDUP MANUALBracket Installation - Left Side Core Case
Figure 7-1 (Sheet 5)

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P/P BUILDUP FIGURE 7-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
7-1		BRACKET INSTALLATION - LEFT SIDE CORE CASE (FIGURE 7-1, SHEET 5) ATTACH BRACKET ASSY (125) TO BRACKET ASSY (55) AND CFMI BRACKET USING BOLTS (130). 125 332A2920-185 . BRACKET ASSY 125 332A2920-39 . BRKT ASSY (OPTIONAL TO 332A2920-185) 130 BACB30ZF4-06 . BOLT TIGHTEN BOLTS (130) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS). TIGHTEN BOLT (30), BOLT (31) AND BOLTS (50) TO 90-110 POUND-INCHES (10.2-12.4 NEWTON METERS). SECURE BOLTS USING safety cable kit, G50375 (C3) OR MS20995NC32 lockwire, G01912 (C4) AS SHOWN. NOTE: IF OPT BRACKET ASSY (55) IS INSTALLED, SECURE LOWER BOLT (50) TO STIFFENER ABOVE BOLT.				
C3	G50375	. SAFETY CABLE KIT			CON	3
C4	G01912	. MS20995NC32 LOCKWIRE			CON	AR

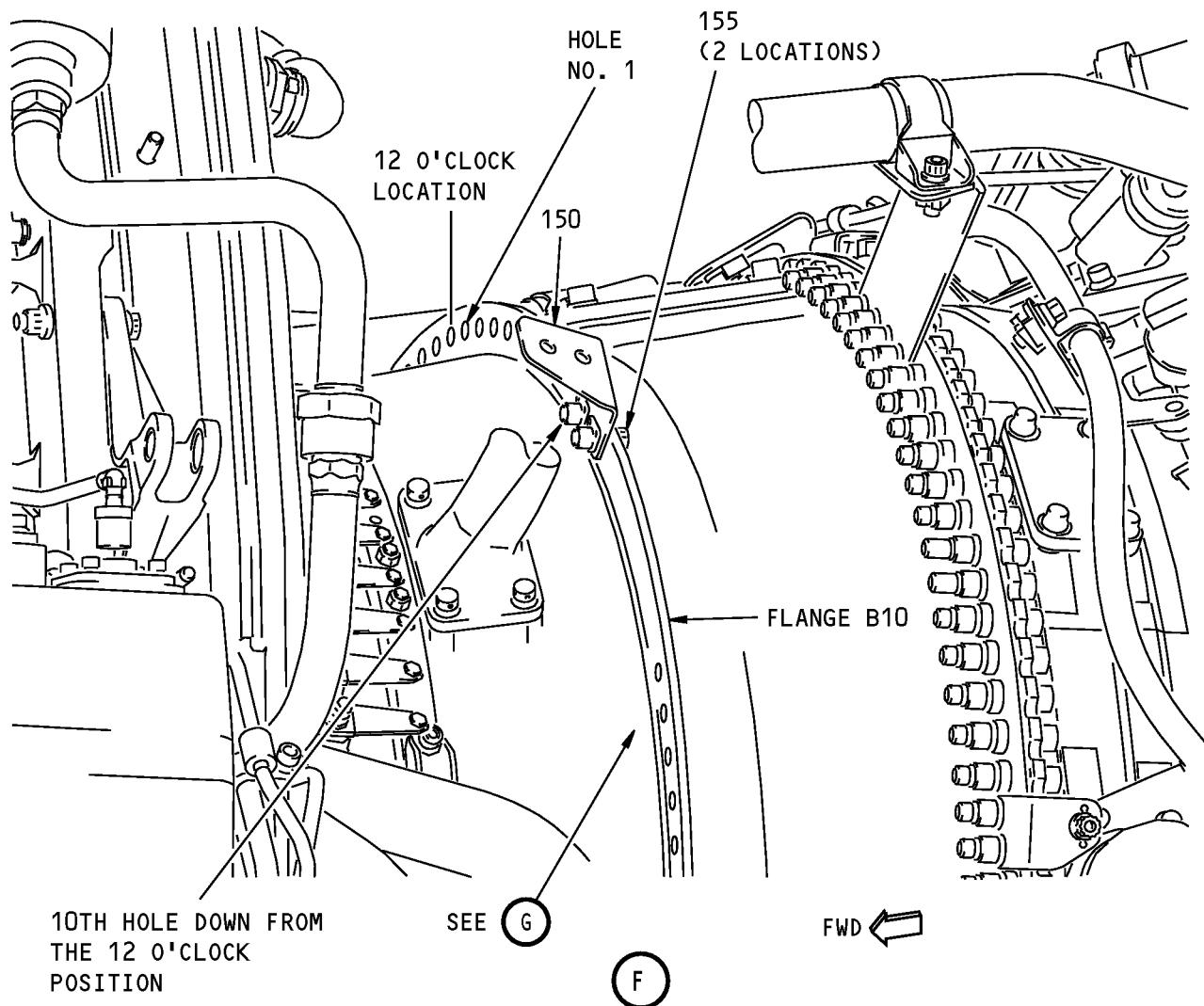
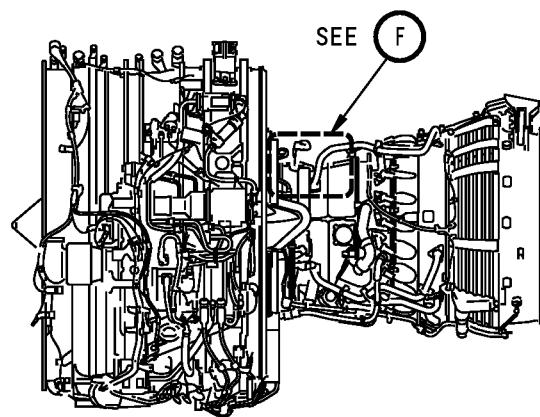
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P/P BUILDUP FIGURE 7-1

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POWERPLANT BUILDUP MANUAL

Bracket Installation - Left Side Core Case
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P/P BUILDUP FIGURE 7-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
7-1 150 155	332A2910-111 BACB30ZF4-07	<p>BRACKET INSTALLATION - LEFT SIDE CORE CASE (FIGURE 7-1, SHEET 6)</p> <p>ATTACH BRACKET ASSY (150) TO LEFT BOTTOM 2 HOLES ON TOP HOLE SEGMENT (10TH AND 11TH HOLE DOWN FROM 12 O'CLOCK) ON FLANGE B10. USE BOLTS (155).</p> <p>. BRACKET ASSY . BOLT</p> <p>TIGHTEN BOLTS (155) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS).</p>	FWD	FWD		1 2

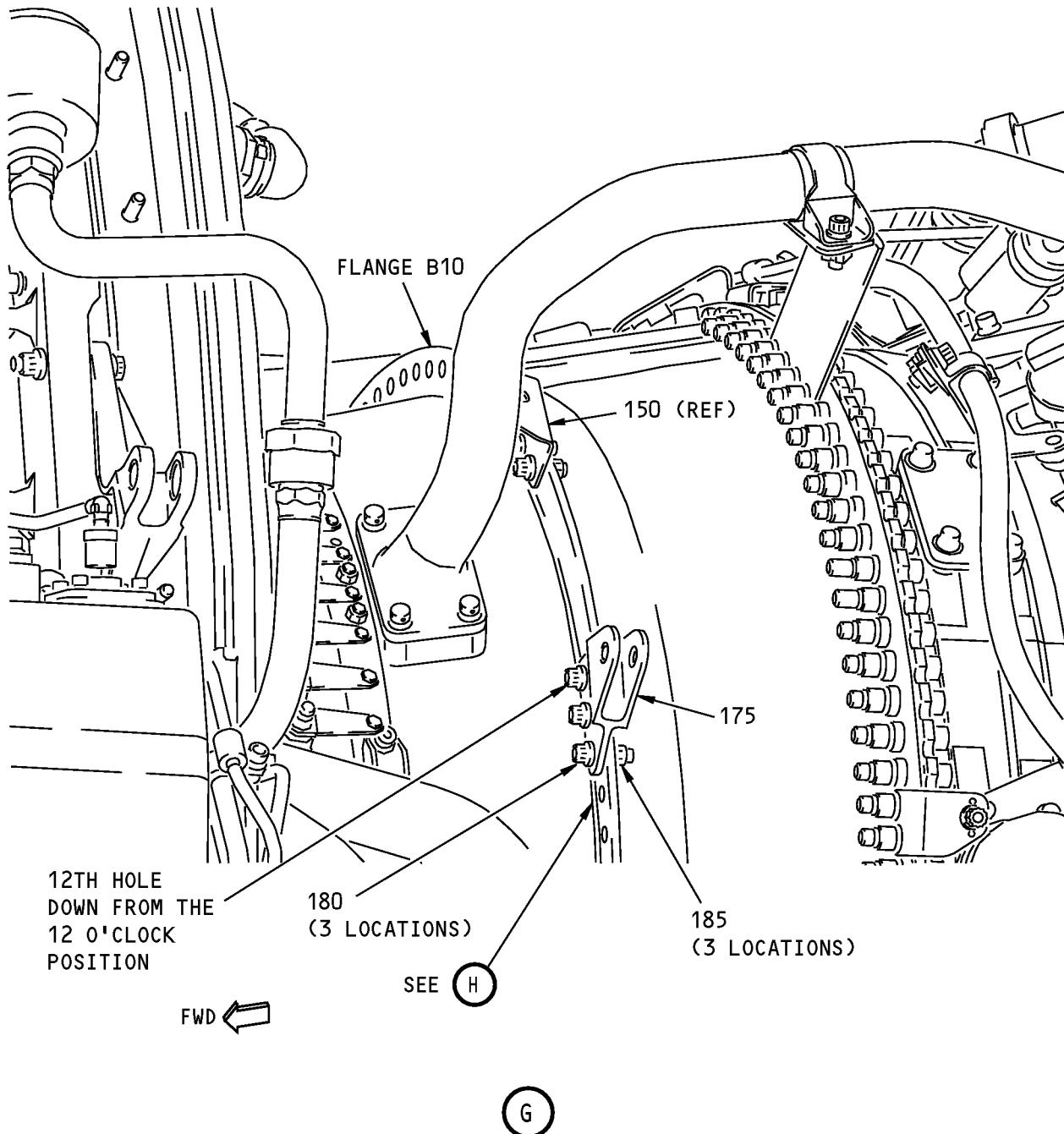
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P/P BUILDUP FIGURE 7-1

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POWERPLANT BUILDUP MANUALBracket Installation - Left Side Core Case
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P/P BUILDUP FIGURE 7-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
7-1		BRACKET INSTALLATION - LEFT SIDE CORE CASE (FIGURE 7-1, SHEET 7) ATTACH BRACKET ASSY (175) TO FIRST THREE HOLES IN CENTER BOLT HOLE SEGMENT (12TH, 13TH AND 14TH HOLE DOWN FROM 12 O'CLOCK) ON FLANGE B10. USE BOLTS (180) AND NUTS (185). . BRACKET ASSY . BRACKET ASSY* ^[7] . BOLT (FWD SIDE) . BOLT (FWD SIDE)* ^[7] . NUT TIGHTEN BOLTS (180) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS). * ^[7] 332A2930-17 BRACKET ASSY (175) TOGETHER WITH BACB30ZF4-10 BOLTS (180) OPTIONAL TO 332A2920-179 BRACKET ASSY (175) TOGETHER WITH BACB30ZF4-12 BOLTS (180).				
175	332A2920-179		FWD			1
175	332A2930-17		FWD		OPT	-
180	BACB30ZF4-12					3
180	BACB30ZF4-10				OPT	-
185	AS3485-10					3

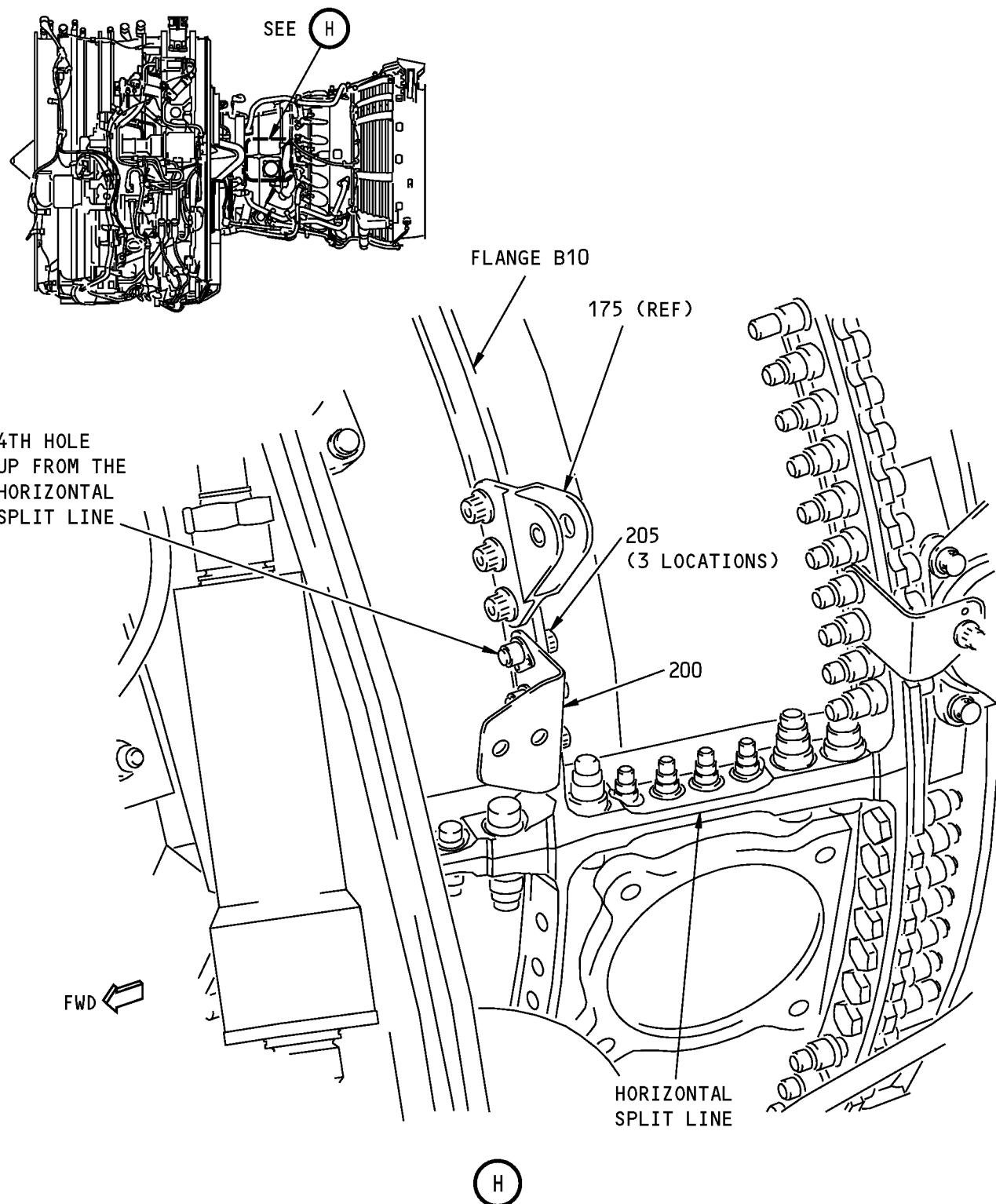
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P/P BUILDUP FIGURE 7-1

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POWERPLANT BUILDUP MANUALBracket Installation - Left Side Core Case
Figure 7-1 (Sheet 8)

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P/P BUILDUP FIGURE 7-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
7-1 200 205	332A2910-128 BACB30ZF4-07	<p>BRACKET INSTALLATION - LEFT SIDE CORE CASE (FIGURE 7-1, SHEET 8)</p> <p>ATTACH BRACKET ASSY (200) TO 2ND, 3RD AND 4TH HOLES UP FROM HORIZONTAL SPLIT LINE ON FLANGE B10. USE BOLTS (205).</p> <p>. BRACKET ASSY . BOLT</p> <p>TIGHTEN BOLTS (205) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS).</p>	FWD	FWD		1 3

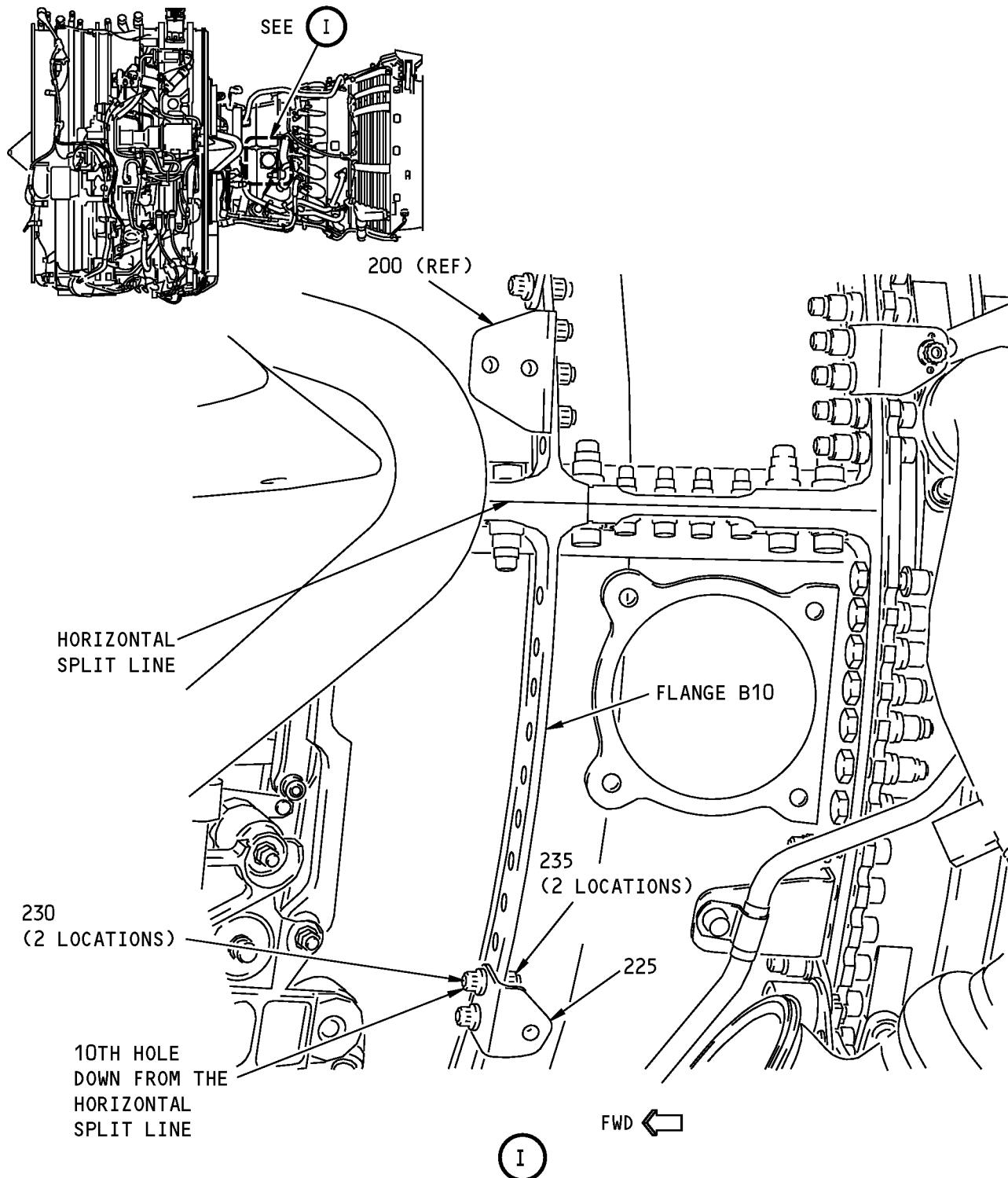
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P/P BUILDUP FIGURE 7-1

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POWERPLANT BUILDUP MANUAL

Bracket Installation - Left Side Core Case
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P/P BUILDUP FIGURE 7-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
7-1		BRACKET INSTALLATION - LEFT SIDE CORE CASE (FIGURE 7-1, SHEET 9) ATTACH BRACKET ASSY (225) TO 10TH AND 11TH HOLE DOWN FROM HORIZONTAL SPLIT LINE ON FLANGE B10. USE BOLTS (230) AND NUTS (235). 225 332A2910-11 230 BACB30ZF4-08 235 AS3485-10 . BRACKET ASSY . BOLT (FWD SIDE) . NUT TIGHTEN BOLTS (230) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS).				
			FWD	AFT		1 2 2

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P/P BUILDUP FIGURE 7-1

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737-600/700/800/900
POWERPLANT BUILDUP MANUAL

THIS SHEET NOT USED

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Bracket Installation - Left Side Core Case
Figure 7-1 (Sheet 10)

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P/P BUILDUP FIGURE 7-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
7-1		BRACKET INSTALLATION - LEFT SIDE CORE CASE (FIGURE 7-1, SHEET 10) THIS SHEET NOT USED		

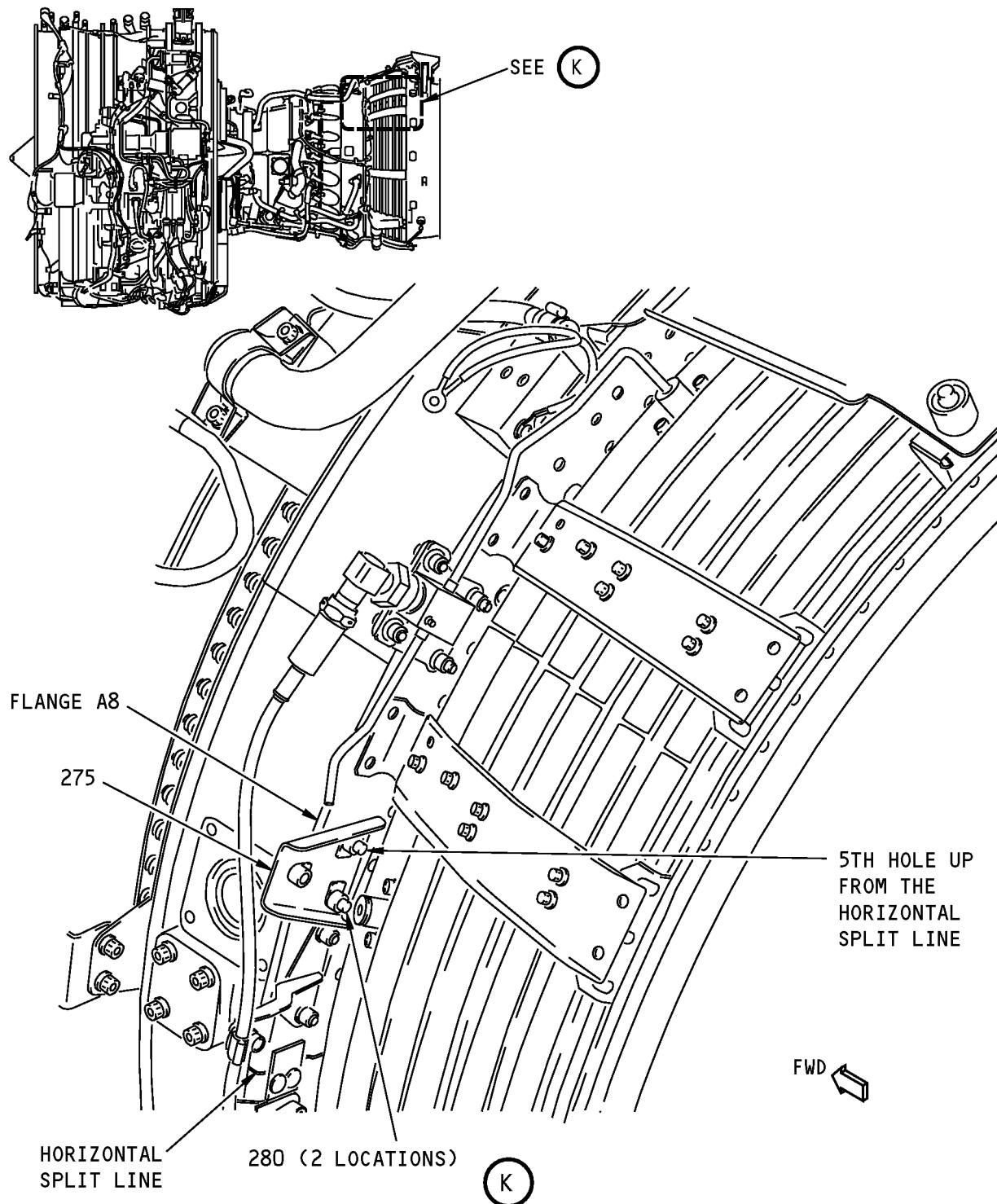
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P/P BUILDUP FIGURE 7-1

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POWERPLANT BUILDUP MANUAL

Bracket Installation - Left Side Core Case
Figure 7-1 (Sheet 11)

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P/P BUILDUP FIGURE 7-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
7-1 275 280	332A2910-106 BACB30ZF4-06	<p>BRACKET INSTALLATION - LEFT SIDE CORE CASE (FIGURE 7-1, SHEET 11)</p> <p>ATTACH BRACKET ASSY (275) TO 4TH AND 5TH HOLES UP FROM HORIZONTAL SPLIT LINE ON FLG A8 USING BOLTS (280).</p> <p>. BRACKET ASSY . BOLT (FWD SIDE)</p> <p>TIGHTEN BOLTS (280) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS).</p>	AFT			1 2

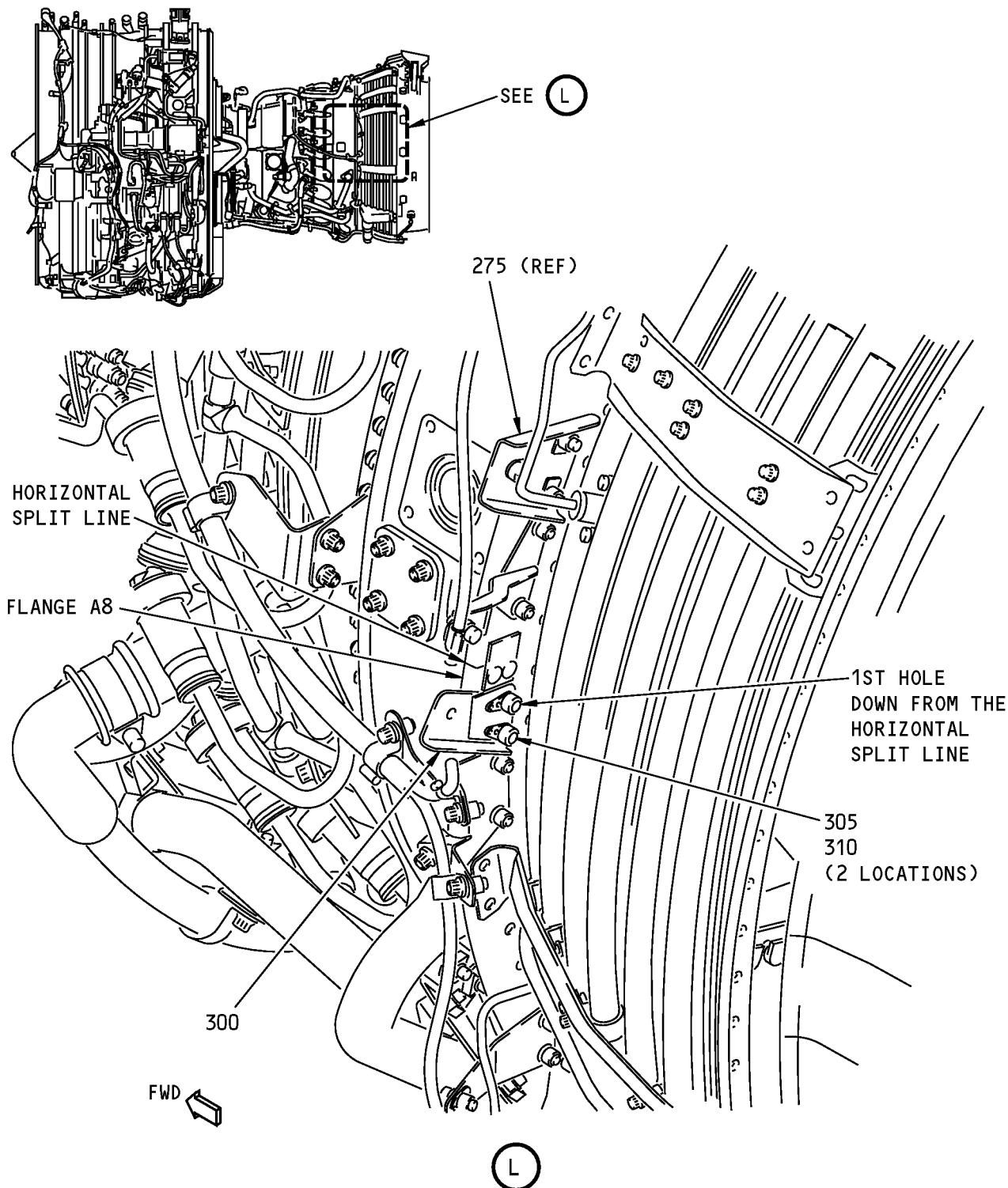
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P/P BUILDUP FIGURE 7-1

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POWERPLANT BUILDUP MANUAL

Bracket Installation - Left Side Core Case
Figure 7-1 (Sheet 12)

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P/P BUILDUP FIGURE 7-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
7-1		<p>BRACKET INSTALLATION - LEFT SIDE CORE CASE (FIGURE 7-1, SHEET 12)</p> <p>ATTACH BRACKET ASSY (300) TO 1ST AND 2ND HOLES DOWN FROM HORIZONTAL SPLIT LINE ON FLANGE A8 USING BOLTS (305) AND NUTS (310).</p> <p>300 332A2910-39 305 BACB30ZF4-07 310 AS3485-10</p> <p>. BRACKET ASSY . BOLT (FWD SIDE) . NUT</p> <p>TIGHTEN BOLTS (305) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS).</p>	AFT			1 2 2

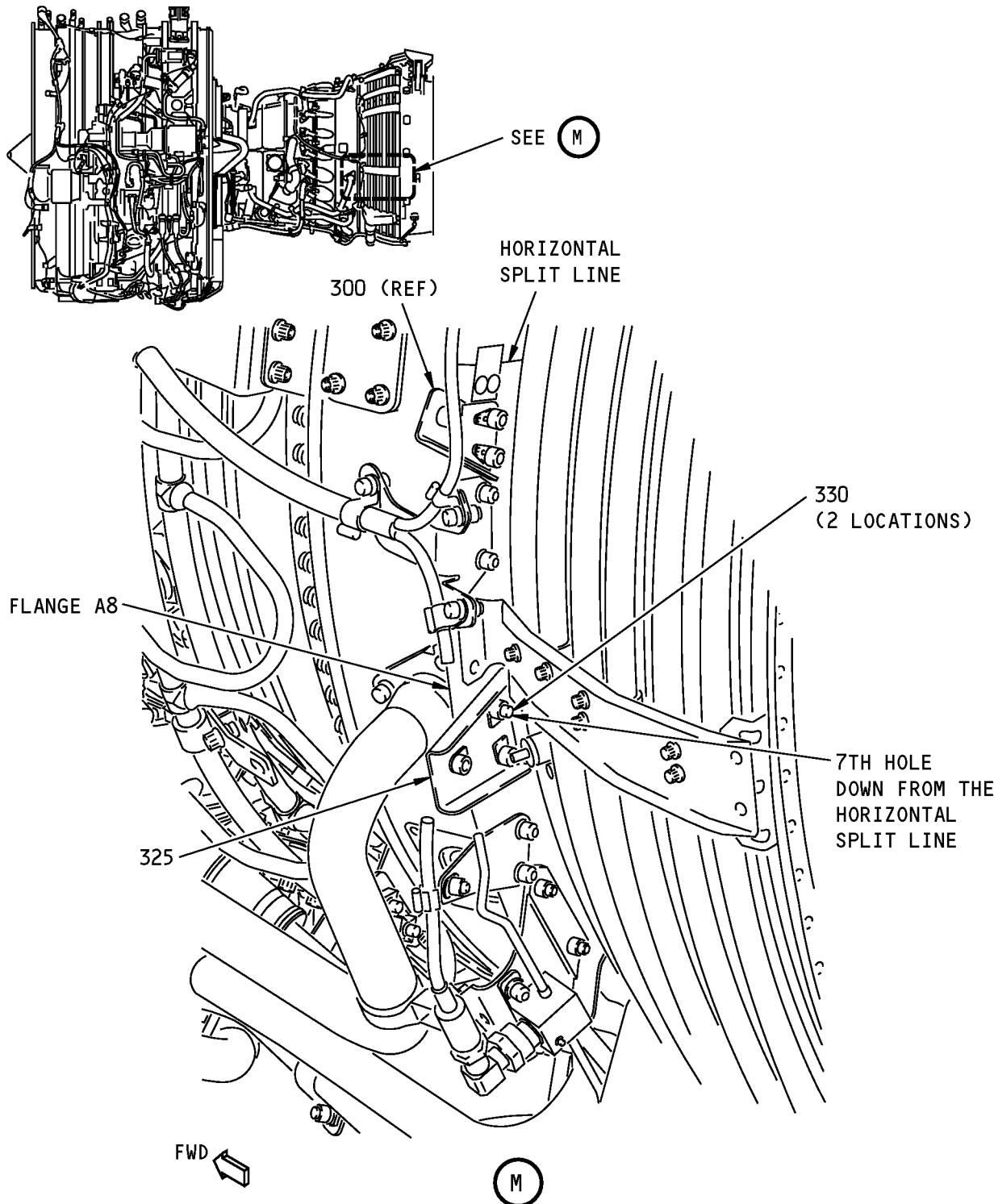
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P/P BUILDUP FIGURE 7-1

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737-600/700/800/900
POWERPLANT BUILDUP MANUAL

Bracket Installation - Left Side Core Case
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P/P BUILDUP FIGURE 7-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
7-1 325 330	332A2910-108 BACB30ZF4-06	<p>BRACKET INSTALLATION - LEFT SIDE CORE CASE (FIGURE 7-1, SHEET 13)</p> <p>ATTACH BRACKET ASSY (325) TO 7TH AND 8TH HOLES DOWN FROM HORIZONTAL SPLIT LINE ON FLANGE A8 USING BOLTS (330).</p> <p>. BRACKET ASSY . BOLT (FWD SIDE)</p> <p>TIGHTEN BOLTS (330) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS).</p>	AFT			1 2

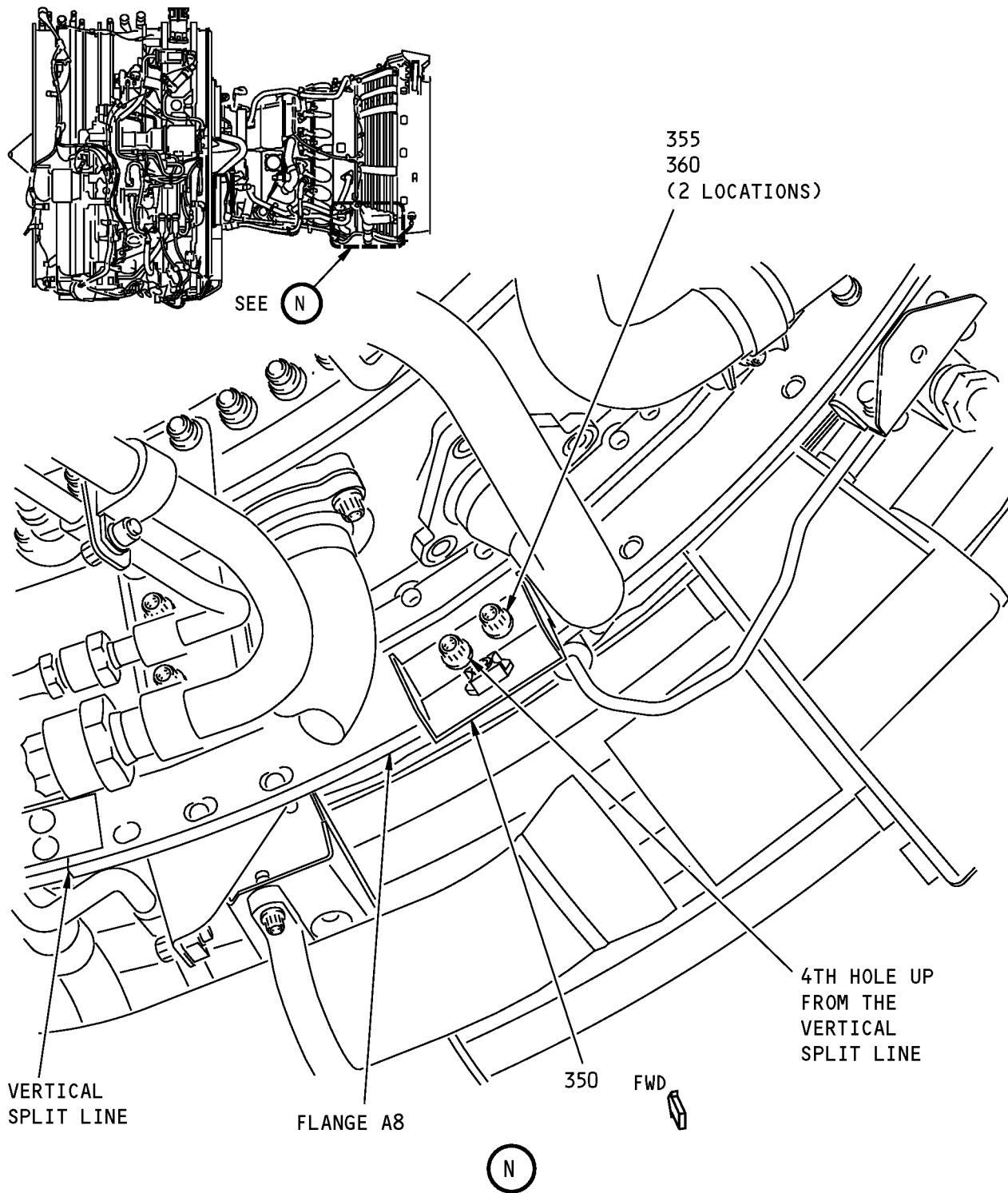
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P/P BUILDUP FIGURE 7-1

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Bracket Installation - Left Side Core Case
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P/P BUILDUP FIGURE 7-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
7-1		<p>BRACKET INSTALLATION - LEFT SIDE CORE CASE (FIGURE 7-1, SHEET 14)</p> <p>ATTACH BRACKET ASSY (350) TO 4TH AND 5TH HOLES UP FROM VERTICAL SPLIT LINE AT 6 O'CLOCK POSITION ON FLANGE A8. USE BOLTS (355) AND NUTS (360).</p> <p>. BRACKET ASSY . BOLT (FWD SIDE) . NUT</p> <p>TIGHTEN BOLTS (355) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS).</p>	FWD			1 2 2

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P/P BUILDUP FIGURE 7-1

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FIGURE 8-1

**BRACKET INSTALLATION - RIGHT SIDE CORE
CASE**

REF QEC TASK NO.: 8

REF DWG: 332A2900

NOTE: ALL STANDARDS AND ATTACHING HARDWARE FOR THIS FIGURE WILL BE PACKAGED
IN QEC TASK NO. 110.

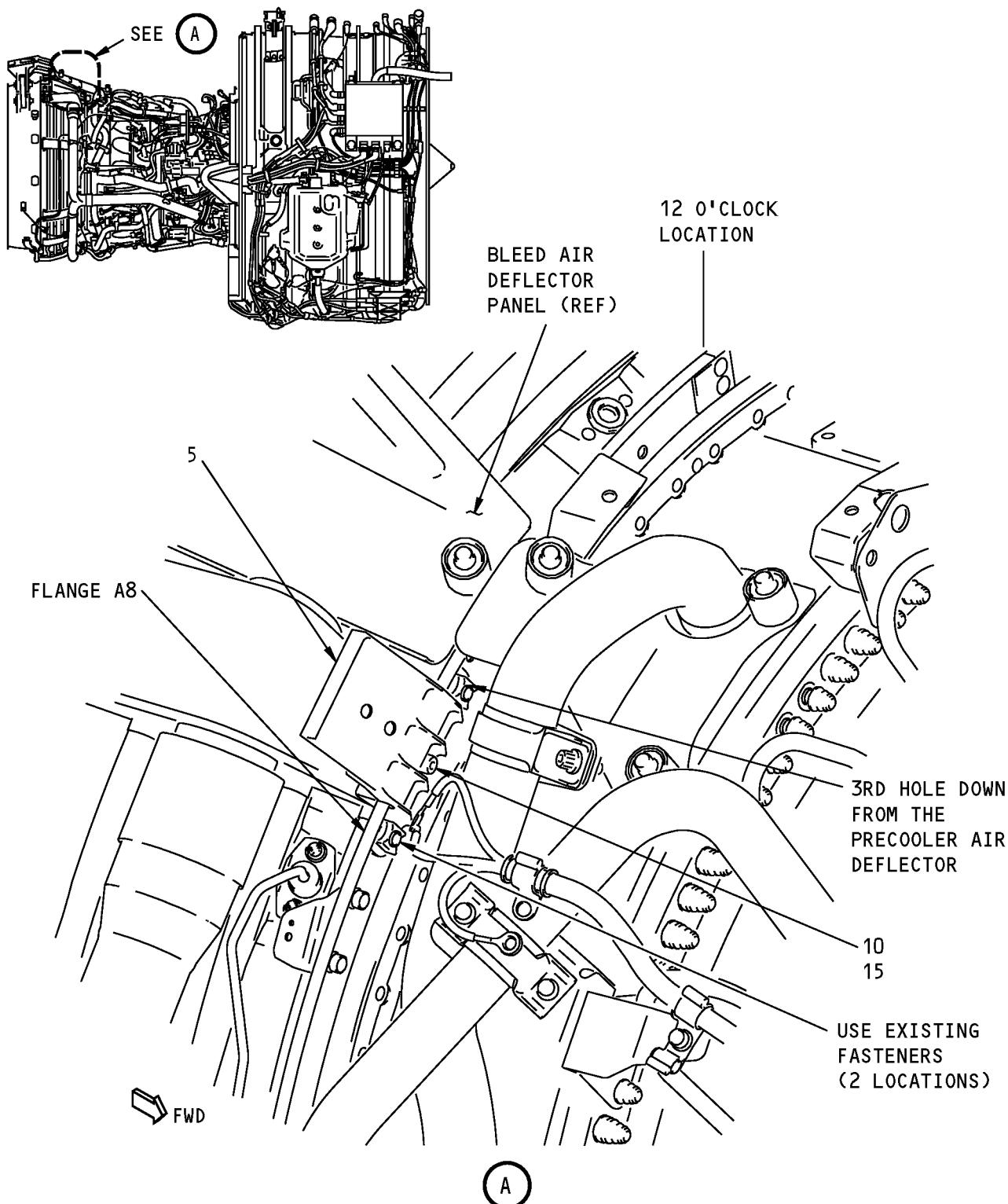
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P/P BUILDUP FIGURE 8-1

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POWERPLANT BUILDUP MANUALBracket Installation - Right Side Core Case
Figure 8-1 (Sheet 1)

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P/P BUILDUP FIGURE 8-1

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737-600/700/800/900
POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
8-1		BRACKET INSTALLATION - RIGHT SIDE CORE CASE (FIGURE 8-1, SHEET 1) REMOVE EXISTING CFMI FASTENERS FROM 3RD, 4TH AND 5TH HOLES DOWN FROM PRECOOLER AIR DEFLECTOR ON FLANGE A8. CLEAN MATING SURFACES OF BRACKET ASSY (5) AND ENGINE FLANGE WITH alcohol, B00130 (C1). MAKE SURE YOU REMOVE ALL GREASE AND OTHER CONTAMINANTS.				
5 C1	332A2920-230 B00130	. BRACKET ASSY . ALCOHOL ATTACH BRACKET ASSY (5) TO ENGINE FLANGE A8. USE EXISTING CFMI FASTENERS ON OUTBOARD HOLES AND BOLT (10), WASHER (15) AND EXISTING CFMI NUT AT CENTER LOCATION.	FWD		CON	1 AR
10 15	BACB30ZF4-09 NAS1149C0432R	. BOLT (FWD SIDE) . WASHER (UNDER BOLT HEAD) TIGHTEN BOLT (10) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS). TIGHTEN EXISTING CFMI BOLTS TO 100-112 POUND-INCHES (11.3-12.7 NEWTON METERS).				1 1

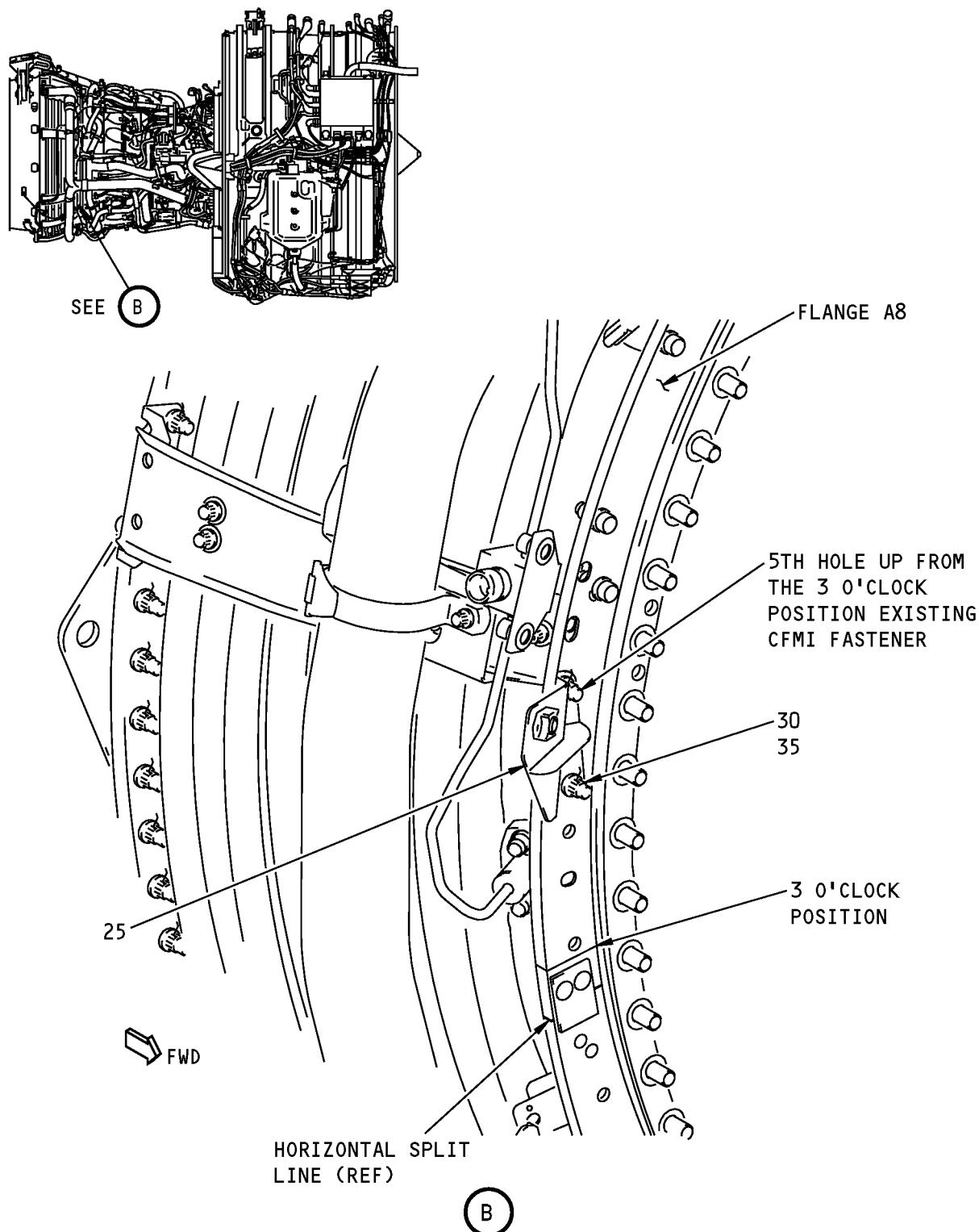
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P/P BUILDUP FIGURE 8-1

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POWERPLANT BUILDUP MANUAL

Bracket Installation - Right Side Core Case
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P/P BUILDUP FIGURE 8-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
8-1		BRACKET INSTALLATION - RIGHT SIDE CORE CASE (FIGURE 8-1, SHEET 2) REMOVE EXISTING CFMI FASTENER FROM 5TH HOLE UP FROM 3 O'CLOCK POSITION ON FLANGE A8. ATTACH BRACKET ASSY (25) TO 5TH HOLE UP FROM 3 O'CLOCK POSITION ON FLANGE A8 USING EXISTING CFMI FASTENER AND 4TH HOLE UP USING BOLT (30) AND NUT (35). . BRACKET ASSY . BOLT . NUT TIGHTEN BOLTS (30) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS). TIGHTEN EXISTING CFMI BOLTS TO 100-112 POUND-INCHES (11.3-12.7 NEWTON METERS).				
25	332A2921-1		FWD			1
30	BACB30ZF4-07					1
35	AS3485-10					1

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P/P BUILDUP FIGURE 8-1

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POWERPLANT BUILDUP MANUAL

THIS SHEET NOT USED

U64289 S00041154064_V2

Bracket Installation - Right Side Core Case
Figure 8-1 (Sheet 3)

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P/P BUILDUP FIGURE 8-1

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737-600/700/800/900
POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
8-1		BRACKET INSTALLATION - RIGHT SIDE CORE CASE (FIGURE 8-1, SHEET 3) THIS SHEET NOT USED		

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P/P BUILDUP FIGURE 8-1

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THIS SHEET NOT USED

U64289 S00041154064_V2

Bracket Installation - Right Side Core Case
Figure 8-1 (Sheet 4)

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P/P BUILDUP FIGURE 8-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
8-1		BRACKET INSTALLATION - RIGHT SIDE CORE CASE (FIGURE 8-1, SHEET 4) THIS SHEET NOT USED		

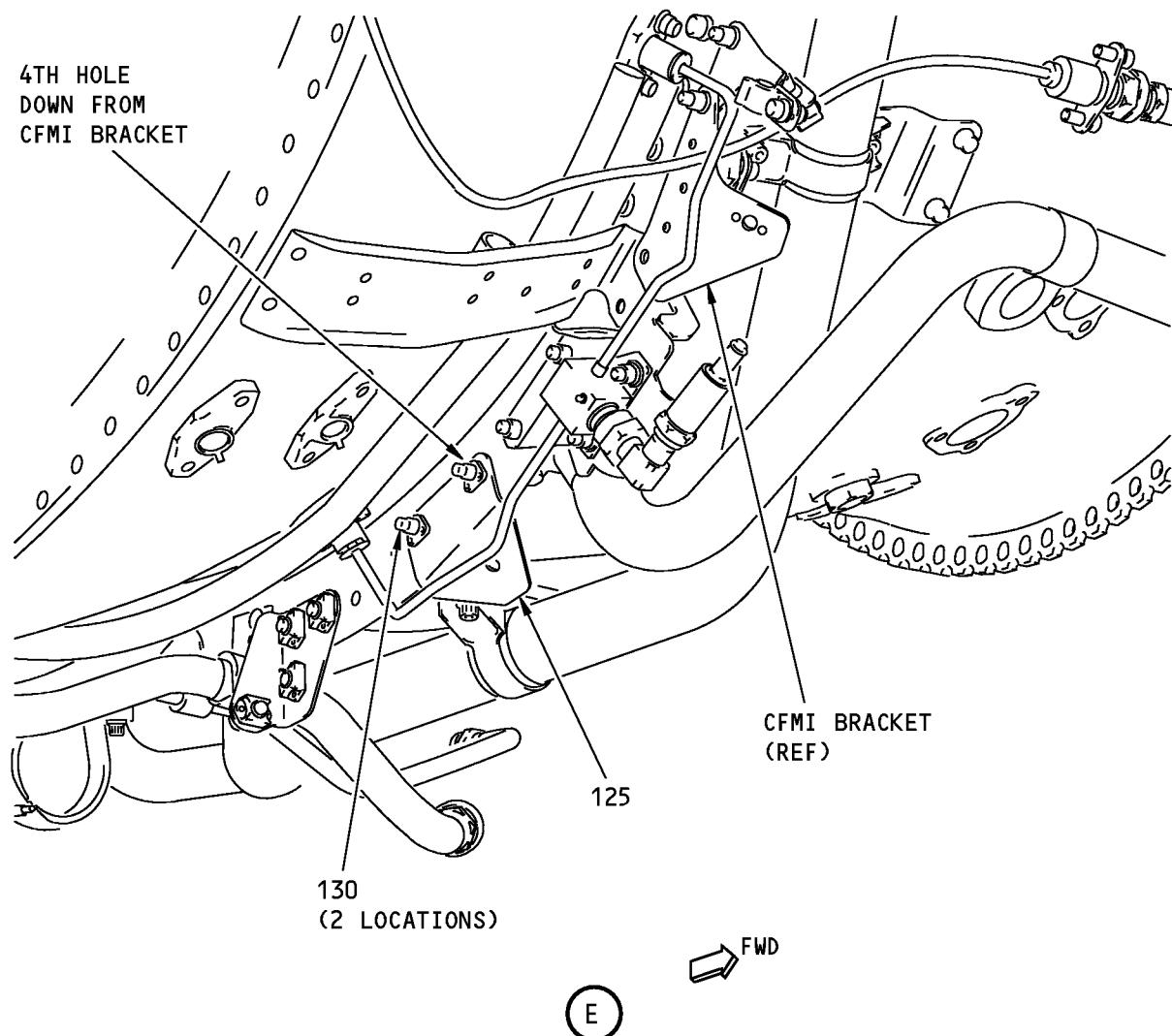
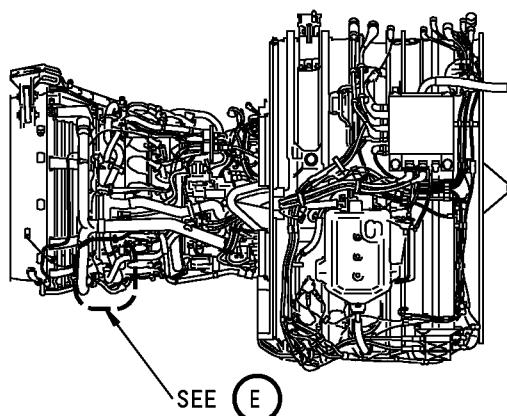
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P/P BUILDUP FIGURE 8-1

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Bracket Installation - Right Side Core Case
Figure 8-1 (Sheet 5)

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P/P BUILDUP FIGURE 8-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	BRACKET LOCATION AND ORIENTATION			QTY
			BRKT OR FLG SIDE	ANGLE FACES	UC	
8-1 125 130	332A2911-9 BACB30ZF4-06	<p>BRACKET INSTALLATION - RIGHT SIDE CORE CASE (FIGURE 8-1, SHEET 5)</p> <p>ATTACH BRACKET ASSY (125) TO 4TH AND 5TH HOLES DOWN FROM CFMI BRACKET (REF) ON FLANGE A8. USE BOLTS (130).</p> <p>. BRACKET ASSY . BOLT</p> <p>TIGHTEN BOLTS (130) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS).</p>	AFT	FWD		1 2

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P/P BUILDUP FIGURE 8-1

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FIGURE 9-1

DRAINS INSTL - LEFT SIDE FAN CASE

REF QEC TASK NO.: 9

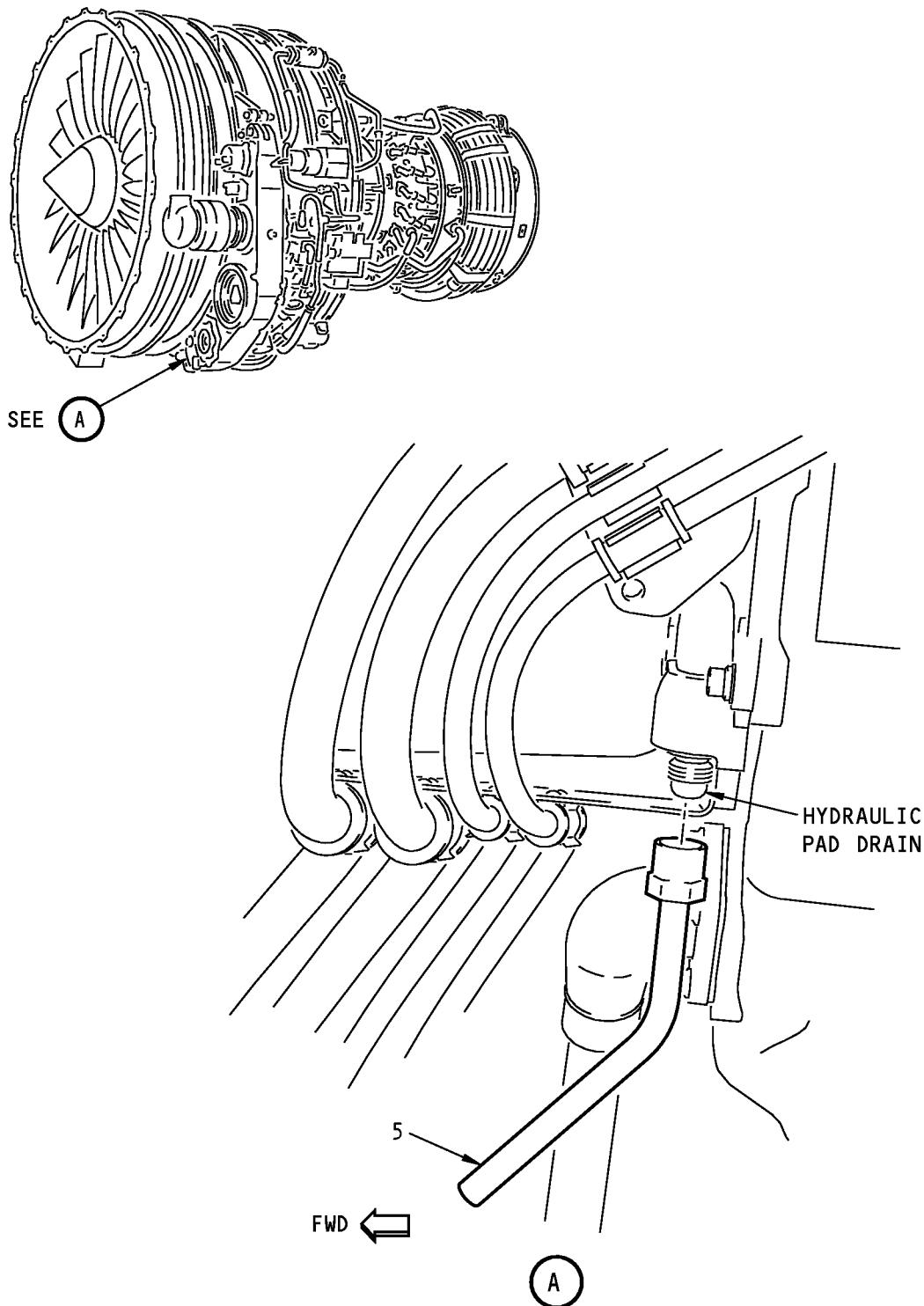
REF DWG: 332A2100

NOTE: ALL STANDARDS AND ATTACHING HARDWARE FOR THIS FIGURE WILL BE PACKAGED IN QEC TASK NO. 110.

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P/P BUILDUP FIGURE 9-1
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POWERPLANT BUILDUP MANUALDrains Installation - Left Side Fan Case
Figure 9-1 (Sheet 1)

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P/P BUILDUP FIGURE 9-1

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737-600/700/800/900
POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
9-1		<p>DRAINS INSTALLATION - LEFT SIDE FAN CASE (FIGURE 9-1, SHEET 1)</p> <p>NOTE: IN THIS PROCEDURE, DO NOT TIGHTEN SCREWS AND TUBE OR HOSE NUTS TO THE INDICATED TORQUE UNTIL INSTRUCTED. WHEN TIGHTENING TUBE AND HOSE NUTS, USE TWO WRENCHES; ONE TO HOLD THE SPANNER FLATS ON THE NIPPLE AND ONE TO TIGHTEN THE NUT.</p> <p>TO REDUCE CLAMP DISTORTION UPON INSTALLATION, APPLY Never-Seez NSBT-8N compound, D00006 (C6) TO BOLT HEAD SURFACE THAT COMES INTO CONTACT WITH THE CLAMP. APPLY TO BOLT HEAD UNDERSIDE ONLY. DO NOT APPLY TO BOLT THREADS.</p>		
C1	D00504	REMOVE PROTECTIVE CAP FROM NIPPLE ON HYDRAULIC PAD DRAIN. LUBRICATE THREADS OF NIPPLE WITH grease, D00504 (C1).	CON	AR
C6	D00006	<ul style="list-style-type: none"> . GREASE . NEVER-SEEZ NSBT-8N COMPOUND 	CON	AR
5	332A2710-3	<p>LOOSELY ATTACH TUBE ASSY (5) TO NIPPLE.</p> <ul style="list-style-type: none"> . TUBE ASSY 		1

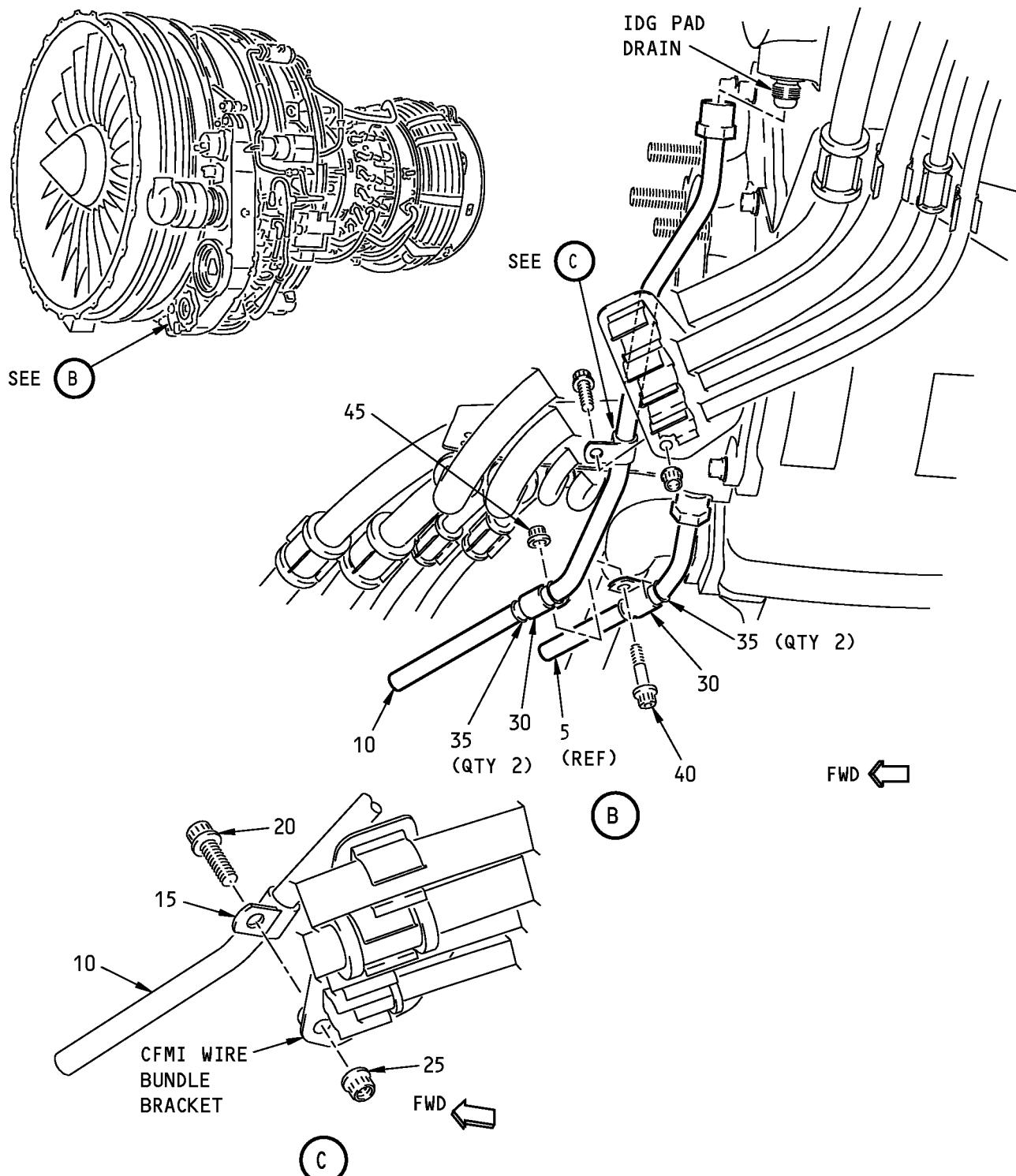
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P/P BUILDUP FIGURE 9-1

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POWERPLANT BUILDUP MANUALDrains Installation - Left Side Fan Case
Figure 9-1 (Sheet 2)

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P/P BUILDUP FIGURE 9-1

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737-600/700/800/900
POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
9-1		DRAINS INSTALLATION - LEFT SIDE FAN CASE (FIGURE 9-1, SHEET 2)		
C1	D00504	REMOVE PROTECTIVE CAP FROM NIPPLE ON IDG PAD DRAIN AND LUBRICATE THREADS OF NIPPLE WITH grease, D00504 (C1). . GREASE	CON	AR
10	332A2710-1	ROUTE TUBE ASSY (10) INBOARD OF CFMI WIRE BUNDLE BRACKET AND LOOSELY ATTACH TO NIPPLE. . TUBE ASSY		1
15	J1221G06	APPLY LIGHT COATING OF Never-Seez NSBT-8N compound, D00006 (C6) TO UNDERSIDE HEAD OF BOLT (20). LOOSELY ATTACH TUBE ASSY (10) TO CFMI WIRE BUNDLE BRACKET WITH CLAMP (15), BOLT (20) AND NUT (25). . CLAMP (V07482)	VEN	1
20	BACB30ZF4-09	. BOLT		1
25	AS3485-10	. NUT		1
C6	D00006	. NEVER-SEEZ NSBT-8N COMPOUND	CON	AR
		APPLY LIGHT COATING OF Never-Seez NSBT-8N compound, D00006 (C6) TO UNDERSIDE HEAD OF BOLT (40). LOOSELY INSTALL FLOATING CLAMPS (30) BETWEEN TUBE ASSY (5) AND (10) AT APPROXIMATE LOCATION SHOWN. USE CLAMPSHELLS (35), BOLT (40) AND NUT (45). . CLAMP (V07482)		
30	J1221G06	. CLAMPSHELL	VEN	2
35	BACC10GT2-06	. CLAMPSHELL (V83930) (OPTIONAL)	OPT	4
35	9352M41P03			-
40	BACB30ZF4-08	. BOLT		1
45	AS3485-10	. NUT		1
C6	D00006	. NEVER-SEEZ NSBT-8N COMPOUND	CON	AR
		ADJUST TUBE ASSY (5) AND (10) TO BEST POSITION. MAKE SURE PRELOAD AT ALL CLAMP POINTS IS NOT MORE THAN 10 POUNDS (44.5 NEWTONS). TIGHTEN TUBE ASSY (5) AND (10) TO 257-284 POUND-INCHES (29.0-32.0 NEWTON METERS). BACK OFF NUT TO RELAX TORQUE, THEN RETIGHTEN. TIGHTEN BOLTS (20) AND (40) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS).		

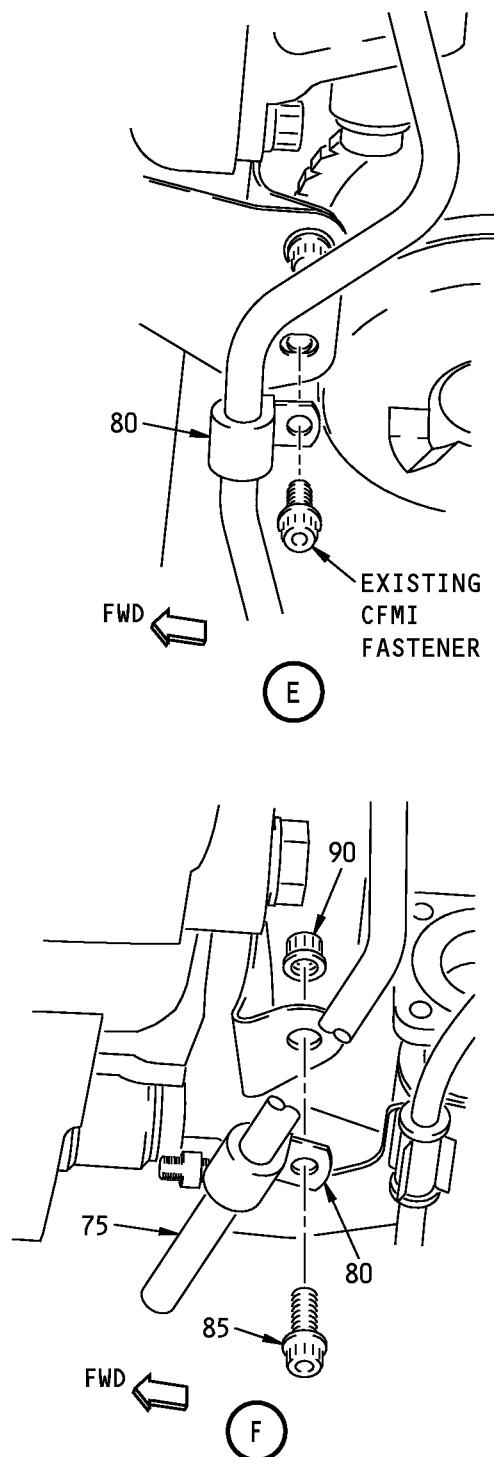
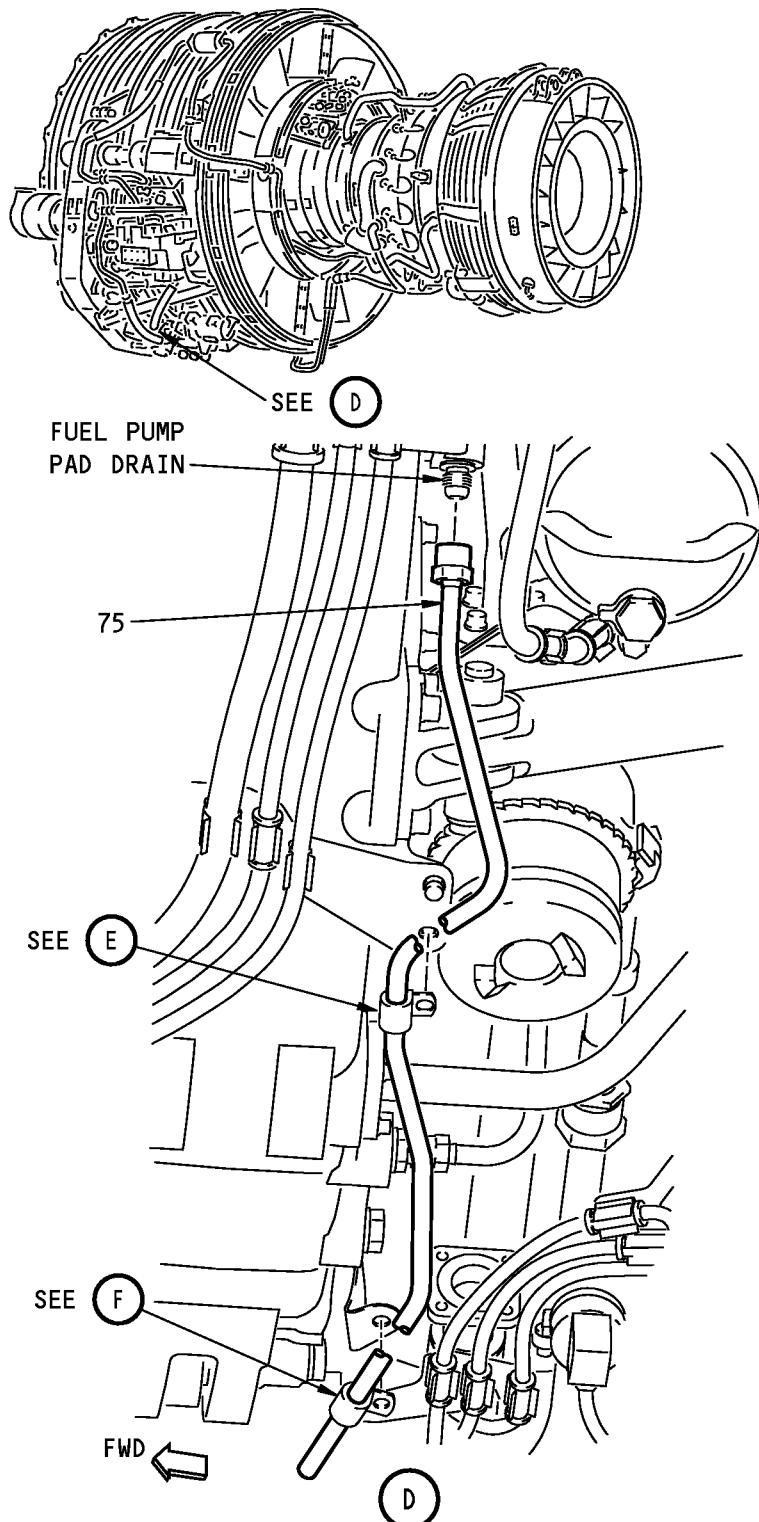
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P/P BUILDUP FIGURE 9-1

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POWERPLANT BUILDUP MANUAL

Drains Installation - Left Side Fan Case
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P/P BUILDUP FIGURE 9-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
9-1		DRAINS INSTALLATION - LEFT SIDE FAN CASE (FIGURE 9-1, SHEET 3) REMOVE PROTECTIVE CAP FROM NIPPLE ON FUEL PUMP PAD DRAIN AND LUBRICATE THREADS OF NIPPLE WITH grease, D00504 (C1).		
C1	D00504	. GREASE	CON	AR
75	332A2710-36	. LOOSELY ATTACH TUBE ASSY (75) TO NIPPLE. . TUBE ASSY		1
80	J1221G06	APPLY LIGHT COATING OF Never-Seez NSBT-8N compound, D00006 (C6) TO UNDERSIDE HEAD OF BOLT (85). AT 2 LOCATIONS, LOOSELY ATTACH TUBE ASSY (75) TO ENGINE BRACKETS ON AFT SIDE OF AGB. USE CLAMP (80) AND EXISTING CFMI FASTENERS AT UPPER LOCATION AND CLAMP (80), BOLT (85) AND NUT (90) AT LOWER LOCATION.	VEN	2
85	BACB30ZF4-08	. CLAMP (V07482)		1
90	AS3485-10	. BOLT		1
C6	D00006	. NUT	CON	AR
		. NEVER-SEEZ NSBT-8N COMPOUND		
		ADJUST TUBE ASSY (75) TO BEST POSITION. MAKE SURE PRELOAD AT ALL CLAMP POINTS IS NOT MORE THAN 10 POUNDS (44.5 NEWTONS).		
		TIGHTEN TUBE ASSY (75) TO 257-284 POUND-INCHES (29.0-32.0 NEWTON METERS). BACK OFF NUT TO RELAX TORQUE, THEN RETIGHTEN.		
		TIGHTEN BOLT (85) AND EXISTING CFMI FASTENER TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS).		

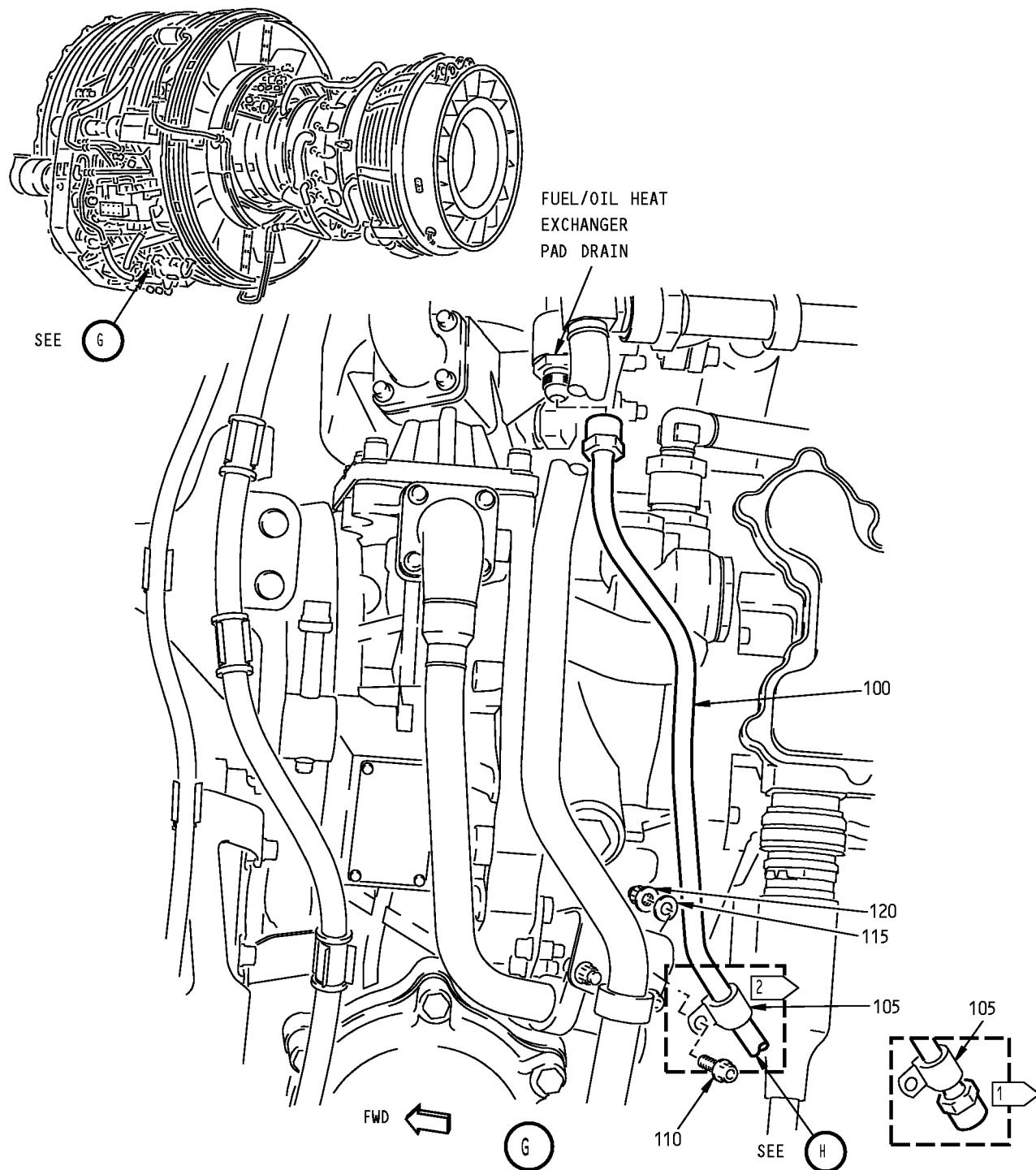
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P/P BUILDUP FIGURE 9-1

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POWERPLANT BUILDUP MANUAL

1) ENGINES WITH 332A2710-30 TUBE ASSEMBLY (100) (OPTIONAL)

2) ENGINES WITH 332A2710-38 TUBE ASSEMBLY (100) (PREFERRED)

Drains Installation - Left Side Fan Case
Figure 9-1 (Sheet 4)

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P/P BUILDUP FIGURE 9-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
9-1		DRAINS INSTALLATION - LEFT SIDE FAN CASE (FIGURE 9-1, SHEET 4) NOTE: DUE TO LIMITED ACCESS, IT IS RECOMMENDED IDG AIR/OIL COOLER INSTALLATION/Figure 23-1 IDG AIR/OIL COOLER INSTALLATION AND IDG PLUMBING INSTALLATION/Figure 24-1 IDG PLUMBING INSTALLATION BE INSTALLED AT THIS TIME. REMOVE PROTECTIVE CAP FROM NIPPLE ON FUEL/OIL HEAT EXCHANGER PAD DRAIN AND LUBRICATE THREADS OF NIPPLE WITH grease, D00504 (C1). . GREASE		
C1	D00504	PREFERRED CONFIGURATION - ENGINES WITH 332A2710-38 TUBE ASSY (100): ROUTE TUBE ASSY (100) UNDER CFMI WIRE BUNDLE (REF SHEET 5) AND LOOSELY ATTACH TUBE ASSY (100) TO NIPPLE. OPTIONAL CONFIGURATION - ENGINES WITH 332A2710-30 TUBE ASSY (100): LOOSELY ATTACH TUBE ASSY (100) TO NIPPLE. . TUBE ASSY* ^[1] . TUBE ASSY* ^[1]	CON	AR
100	332A2710-38			1
100	332A2710-30	APPLY LIGHT COATING OF Never-Seez NSBT-8N compound, D00006 (C6) TO UNDERSIDE HEAD OF BOLT (110). LOOSELY ATTACH TUBE ASSY (100) TO ENGINE BRACKET JUST ABOVE FUEL FILTER. USE CLAMP (105), BOLT (110), WASHER (115) AND NUT (120). . CLAMP (V07482) . BOLT . WASHER	OPT	-
105	J1221G06			1
110	BACB30ZF4-08			1
115	NAS1149E0432P			1
120	AS3485-10			1
C6	D00006	. NUT . NEVER-SEEZ NSBT-8N COMPOUND ADJUST TUBE ASSY (100) TO BEST POSITION. MAKE SURE PRELOAD AT ALL CLAMP POINTS IS NOT MORE THAN 10 POUNDS (44.5 NEWTONS). TIGHTEN TUBE ASSY (100) TO HAND TIGHT. * ^[1] 332A2710-30 TUBE ASSY (100) TOGETHER WITH 332A2710-11 TUBE ASSY (125) OPTIONAL TO 332A2710-38 TUBE ASSY (100). ENGINES WITH 332A2710-38 TUBE ASSY (100) DO NOT REQUIRE TUBE (125).	CON	AR

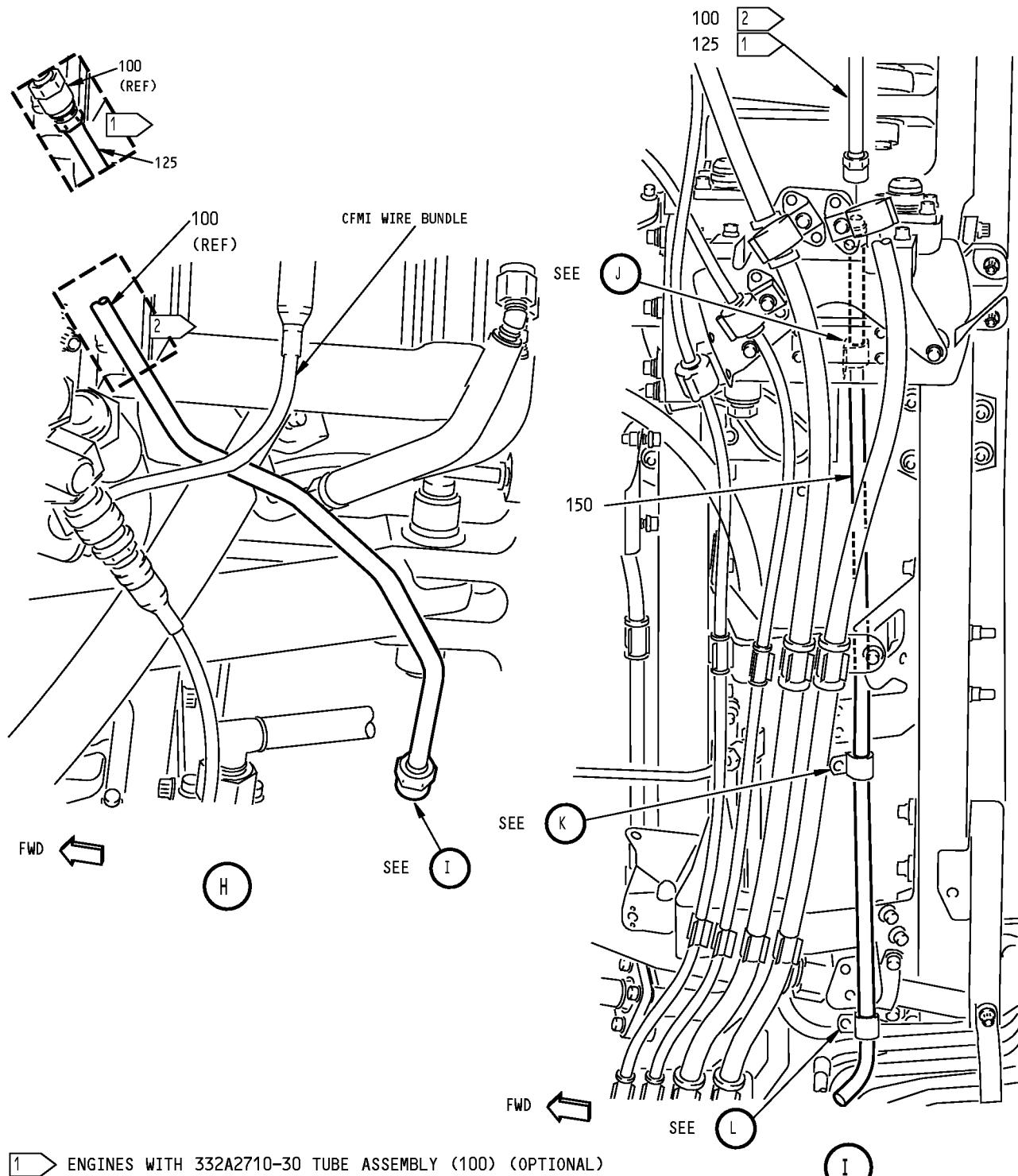
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P/P BUILDUP FIGURE 9-1

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POWERPLANT BUILDUP MANUAL

1) ENGINES WITH 332A2710-30 TUBE ASSEMBLY (100) (OPTIONAL)

2) ENGINES WITH 332A2710-38 TUBE ASSEMBLY (100) (PREFERRED)

Drains Installation - Left Side Fan Case
Figure 9-1 (Sheet 5)

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P/P BUILDUP FIGURE 9-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
9-1		DRAINS INSTALLATION - LEFT SIDE FAN CASE (FIGURE 9-1, SHEET 5) <u>ENGINES WITH 332A2710-30 TUBE ASSY (100):</u> LUBRICATE THREADS OF TUBE ASSY (125) WITH grease, D00504 (C1). ROUTE TUBE ASSY (125) UNDER CFMI WIRE BUNDLE AND LOOSELY ATTACH TO 332A2710-30 TUBE ASSY (100). . TUBE ASSY ^[1] . GREASE		
125 C1	332A2710-11 D00504	LUBRICATE THREADS OF TUBE ASSY (150) WITH grease, D00504 (C1). ROUTE TUBE ASSY (150) BEHIND FUEL/OIL COOLER AND UNDER CFMI WIRE BUNDLE BRACKETS AND LOOSELY ATTACH TO 332A2710-38 TUBE ASSY (100) OR TUBE ASSY (125). . TUBE ASSY . GREASE	OPT CON	- AR
150 C1	332A2710-13 D00504	*[1] 332A2710-30 TUBE ASSY (100) TOGETHER WITH 332A2710-11 TUBE ASSY (125) OPTIONAL TO 332A2710-38 TUBE ASSY (100). ENGINES WITH 332A2710-38 TUBE ASSY (100) DO NOT REQUIRE TUBE (125).	CON	1 AR

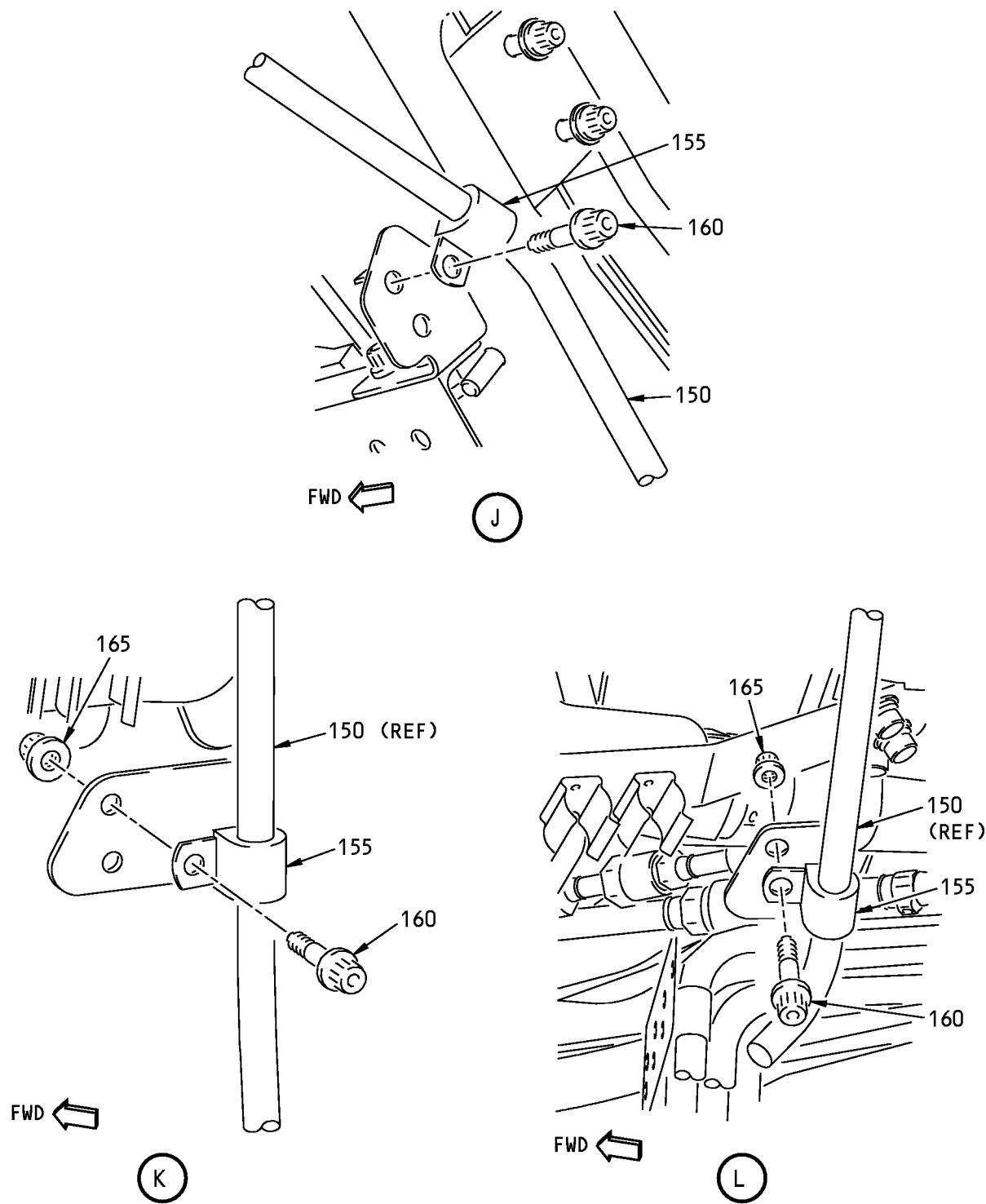
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P/P BUILDUP FIGURE 9-1

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POWERPLANT BUILDUP MANUALDrains Installation - Left Side Fan Case
Figure 9-1 (Sheet 6)

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P/P BUILDUP FIGURE 9-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
9-1		DRAINS INSTALLATION - LEFT SIDE FAN CASE (FIGURE 9-1, SHEET 6) APPLY LIGHT COATING OF Never-Seez NSBT-8N compound, D00006 (C6) TO UNDERSIDE HEAD OF BOLTS (160). AT 3 LOCATIONS, ATTACH TUBE (150) TO ENGINE BRACKETS. USE CLAMP (155) AND BOLT (160) AT UPR LOCATION AND CLAMPS (155), BOLTS (160) AND NUTS (165) AT LWR LOCATIONS.		
155	J1221G06	. CLAMP (V07482)	VEN	3
160	BACB30ZF4-08	. BOLT		3
165	AS3485-10	. NUT		2
C6	D00006	. NEVER-SEEZ NSBT-8N COMPOUND	CON	AR
		ADJUST TUBE ASSY (100), (125) (IF USED) AND (150) TO BEST POSITION. MAKE SURE PRELOAD AT ALL CLAMP POINTS IS NOT MORE THAN 10 POUNDS (44.5 NEWTONS).		
		TIGHTEN TUBE ASSY (100), (125) (IF USED) AND (150) TO 257-284 POUND-INCHES (29.0-32.0 NEWTON METERS). BACK OFF NUT TO RELAX TORQUE, THEN RETIGHTEN.		
		TIGHTEN BOLTS (110) AND (160) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS).		

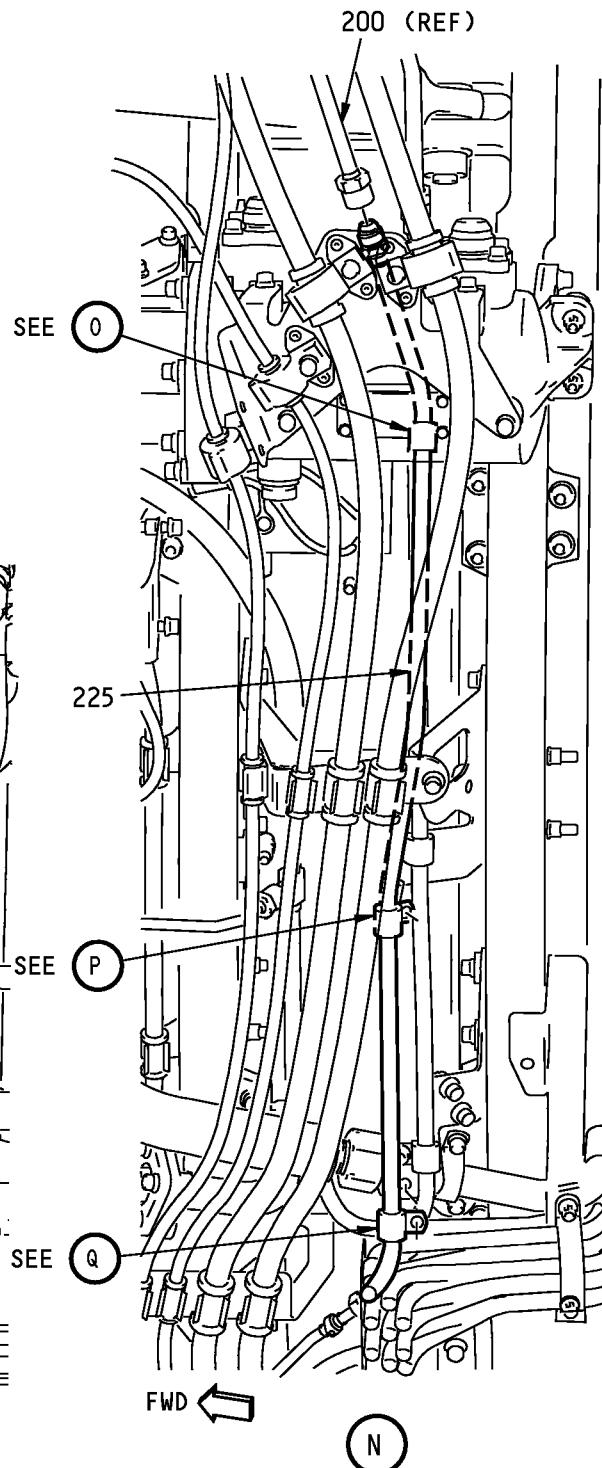
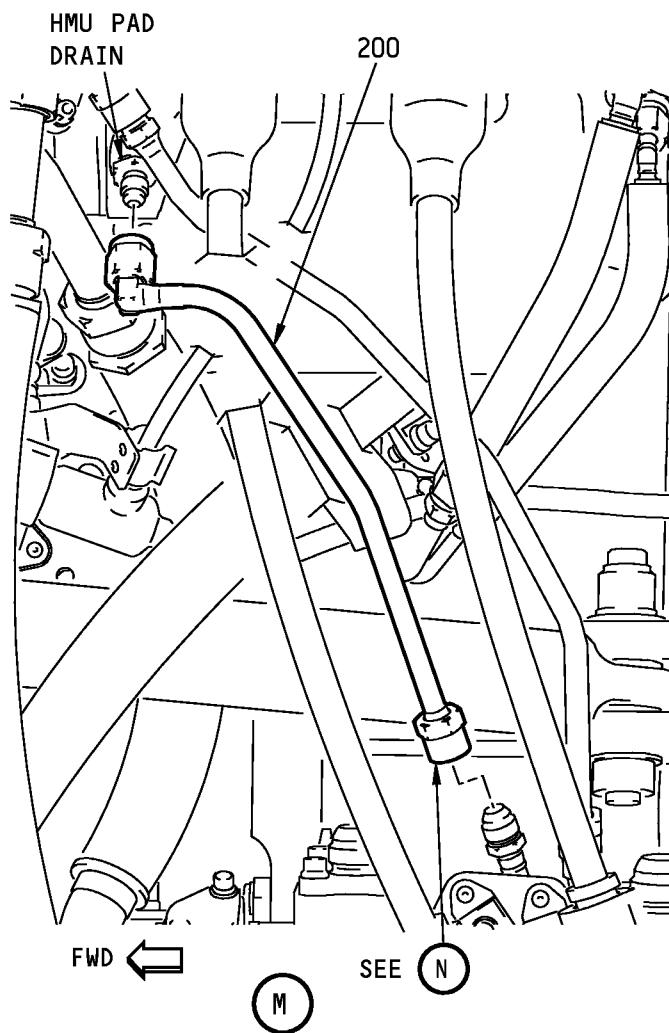
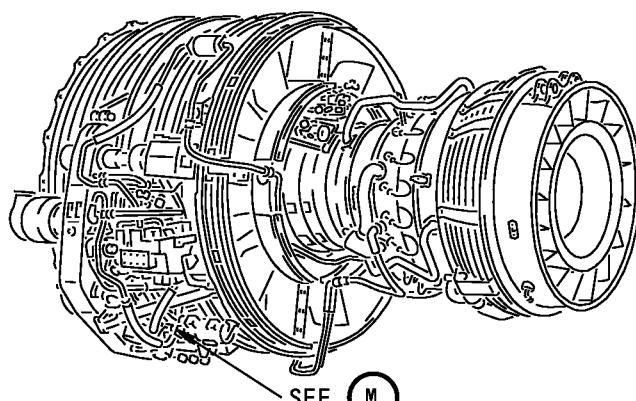
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P/P BUILDUP FIGURE 9-1

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POWERPLANT BUILDUP MANUALDrains Installation - Left Side Fan Case
Figure 9-1 (Sheet 7)

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P/P BUILDUP FIGURE 9-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
9-1		DRAINS INSTALLATION - LEFT SIDE FAN CASE (FIGURE 9-1, SHEET 7)		
C1	D00504	REMOVE PROTECTIVE CAP FROM NIPPLE ON HMU PAD DRAIN AND LUBRICATE THREADS OF NIPPLE WITH grease, D00504 (C1). . GREASE	CON	AR
200	332A2710-15	LOOSELY ATTACH TUBE ASSY (200) TO NIPPLE. . TUBE ASSY		1
C1	D00504	LUBRICATE THREADS OF TUBE ASSY (225) WITH grease, D00504 (C1). . GREASE	CON	AR
225	332A2710-27	ROUTE TUBE ASSY (225) BEHIND FUEL/OIL COOLER AND UNDER CFMI WIRE BUNDLE BRACKETS AND LOOSELY ATTACH TO TUBE ASSY (200). . TUBE ASSY		1

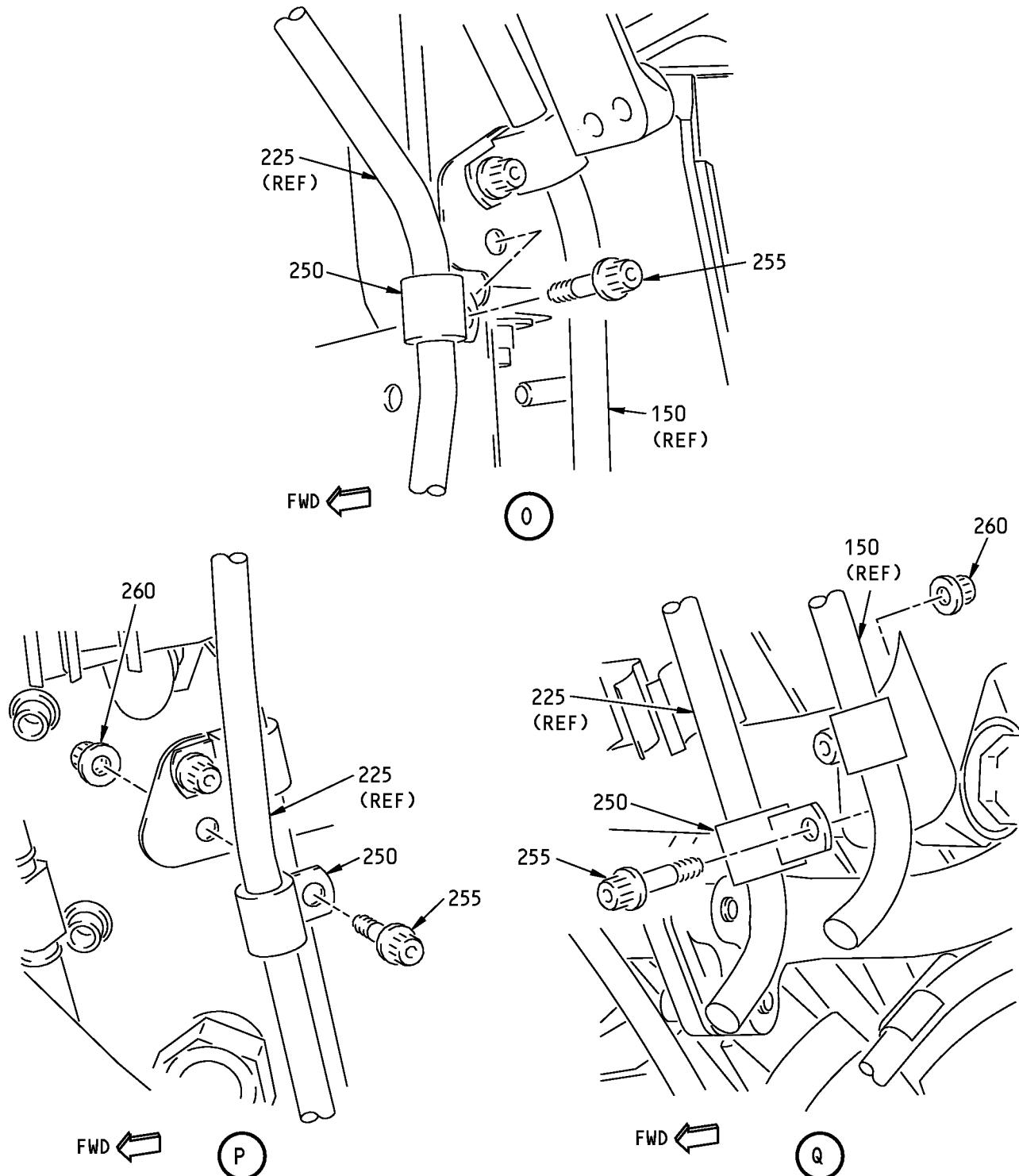
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P/P BUILDUP FIGURE 9-1

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POWERPLANT BUILDUP MANUALDrains Installation - Left Side Fan Case
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P/P BUILDUP FIGURE 9-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
9-1		DRAINS INSTALLATION - LEFT SIDE FAN CASE (FIGURE 9-1, SHEET 8) APPLY LIGHT COATING OF Never-Seez NSBT-8N compound, D00006 (C6) TO UNDERSIDE HEAD OF BOLTS (255). AT 3 LOCATIONS, ATTACH TUBE ASSY (225) TO ENGINE BRACKETS. USE CLAMP (250) AND BOLT (255) AT UPR LOCATION AND CLAMPS (250), BOLTS (255) AND NUTS (260) AT LWR LOCATIONS. 250 J1221G06 . CLAMP (V07482) 255 BACB30ZF4-08 . BOLT 260 AS3485-10 . NUT C6 D00006 . NEVER-SEEZ NSBT-8N COMPOUND ADJUST TUBES ASSY (200) AND (225) TO BEST POSITION. MAKE SURE PRELOAD AT ALL CLAMP POINTS IS NOT MORE THAN 10 POUNDS (44.5 NEWTONS). TIGHTEN TUBE ASSY (200) AND (225) TO 257-284 POUND-INCHES (29.0-32.0 NEWTON METERS). BACK OFF NUT TO RELAX TORQUE, THEN RETIGHTEN. TIGHTEN BOLTS (255) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS).	VEN CON	3 3 2 AR

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P/P BUILDUP FIGURE 9-1

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FIGURE 10-1

DRAINS INSTL - RIGHT SIDE FAN CASE

REF QEC TASK NO.: 10

REF DWG: 332A2100

NOTE: ALL STANDARDS AND ATTACHING HARDWARE FOR THIS FIGURE WILL BE PACKAGED IN QEC TASK NO. 110.

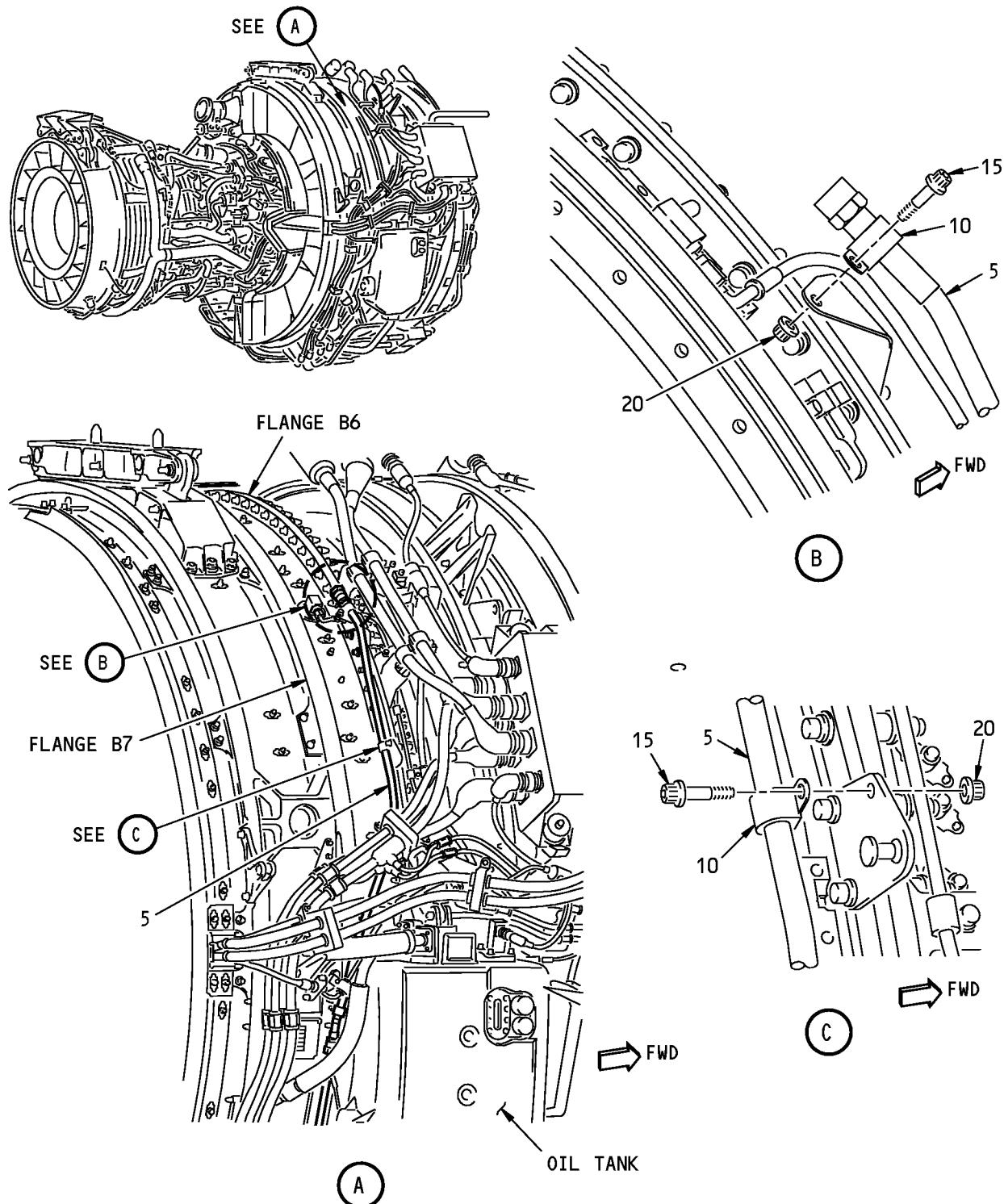
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P/P BUILDUP FIGURE 10-1

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POWERPLANT BUILDUP MANUAL

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
10-1		DRAINS INSTALLATION - RIGHT SIDE FAN CASE (FIGURE 10-1, SHEET 1) NOTE: IN THIS PROCEDURE, DO NOT TIGHTEN SCREWS AND TUBE OR HOSE NUTS TO THE INDICATED TORQUE UNTIL INSTRUCTED. WHEN TIGHTENING TUBE AND HOSE NUTS, USE TWO WRENCHES; ONE TO HOLD THE SPANNER FLATS ON THE NIPPLE AND ONE TO TIGHTEN THE NUT. TO REDUCE CLAMP DISTORTION UPON INSTALLATION, APPLY Never-Seez NSBT-8N compound, D00006 (C6) TO BOLT HEAD SURFACE THAT COMES INTO CONTACT WITH THE CLAMP. APPLY TO BOLT HEAD UNDERSIDE ONLY. NO NOT APPLY TO BOLT THREADS.		
C6	D00006	. NEVER-SEEZ NSBT-8N COMPOUND POSITION TUBE ASSY (5) ON ENGINE FAN CASE AT 1 AND 3 O'CLOCK POSITIONS BETWEEN FLANGES B6 AND B7. APPLY LIGHT COATING OF Never-Seez NSBT-8N compound, D00006 (C6) TO UNDERSIDE HEAD OF BOLTS (15). LOOSELY ATTACH TUBE ASSY (5) AT TOP TWO LOCATIONS TO ENGINE BRACKETS WITH CLAMPS (10), BOLTS (15) AND NUTS (20). MAKE SURE UPPER CLAMP (10) IS INSTALLED BETWEEN MARKS ON TUBE ASSY (5).	CON	AR
5	332A2710-43	. TUBE ASSY		1
5	332A2710-42	. TUBE ASSY (REPLACED BY 332A2710-43)	LTD	-
5	332A2710-32	. TUBE ASSY (REPLACED BY 332A2710-42)	LTD	-
10	J1221G08	. CLAMP (V07482)	VEN	2
15	BACB30ZF4-08	. BOLT		2
20	AS3485-10	. NUT		2
C6	D00006	. NEVER-SEEZ NSBT-8N COMPOUND ADJUST TUBE ASSY (5) TO BEST POSITION. MAKE SURE PRELOAD ON ALL CLAMP POINTS IS NOT MORE THAN 10 POUNDS (44.5 NEWTONS). TIGHTEN BOLTS (15) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS). INSTALL PROTECTIVE CAP ON UPPER END OF TUBE ASSY (5).	CON	AR

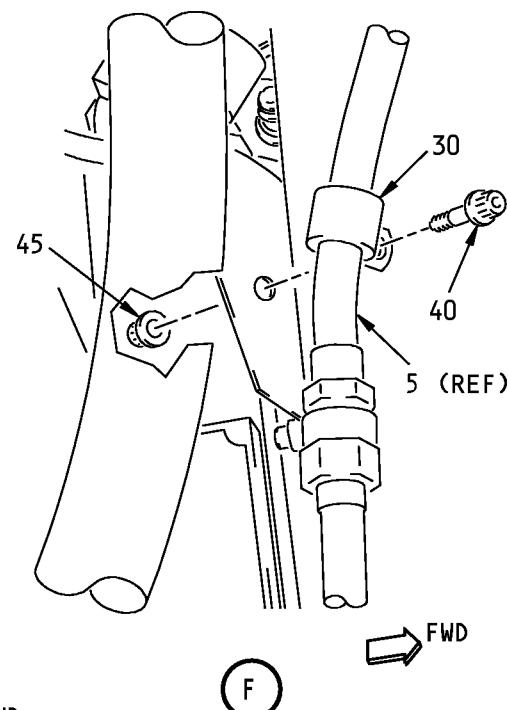
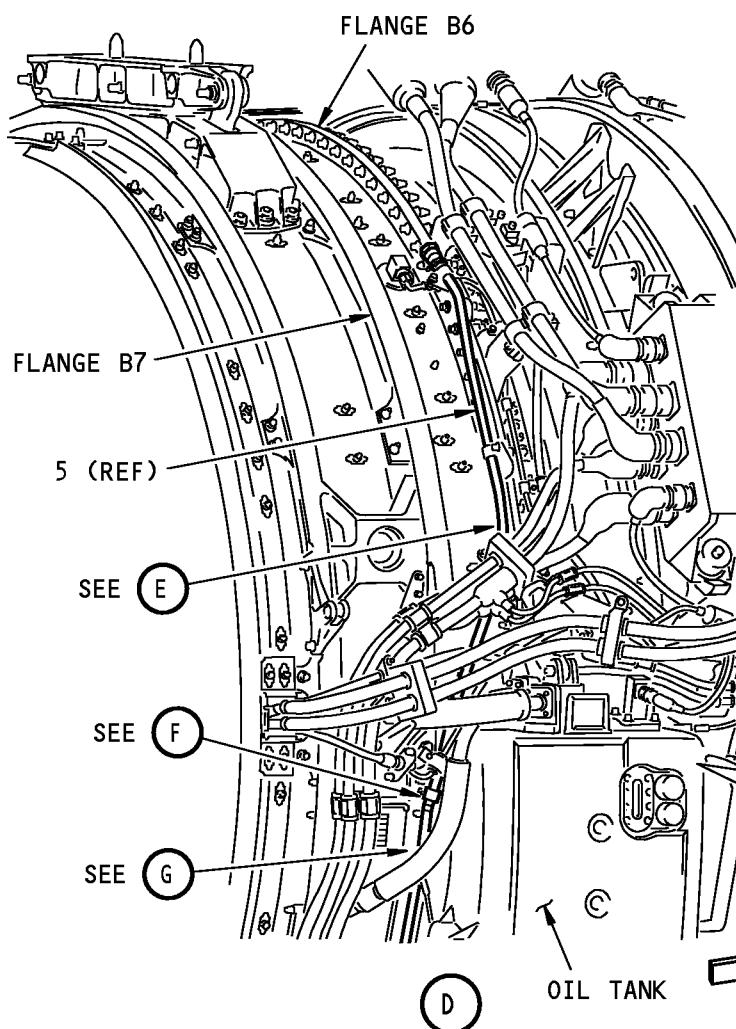
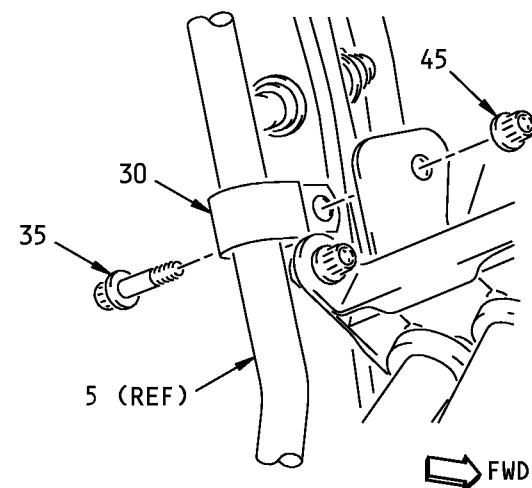
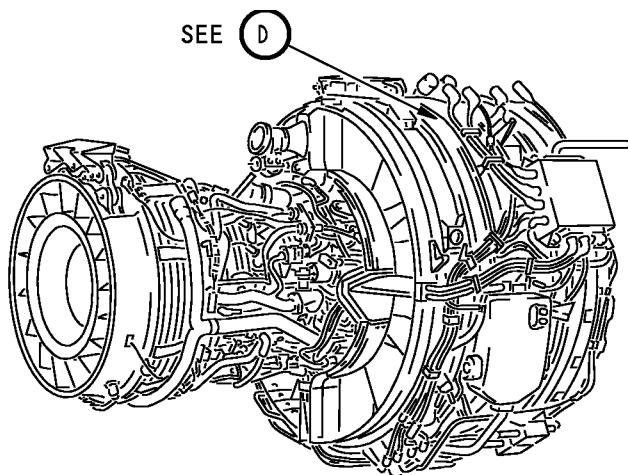
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P/P BUILDUP FIGURE 10-1

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Drains Installation - Right Side Fan Case
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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
10-1		DRAINS INSTALLATION - RIGHT SIDE FAN CASE (FIGURE 10-1, SHEET 2) APPLY LIGHT COATING OF Never-Seez NSBT-8N compound, D00006 (C6) TO UNDERSIDE HEAD OF BOLTS (35, 40). LOOSELY ATTACH TUBE ASSY (5) WITH CLAMP (30), BOLT (35) AND NUT (45) AT UPPER LOCATION AND CLAMP (30), BOLT (40) AND NUT (45) AT LOWER LOCATION.		
30	J1221G08	. CLAMP (V07482)	VEN	2
35	BACB30ZF4-08	. BOLT		1
40	BACB30ZF4-07	. BOLT		1
45	AS3485-10	. NUT		2
C6	D00006	. NEVER-SEEZ NSBT-8N COMPOUND TIGHTEN BOLT (35) AND (40) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS).	CON	AR

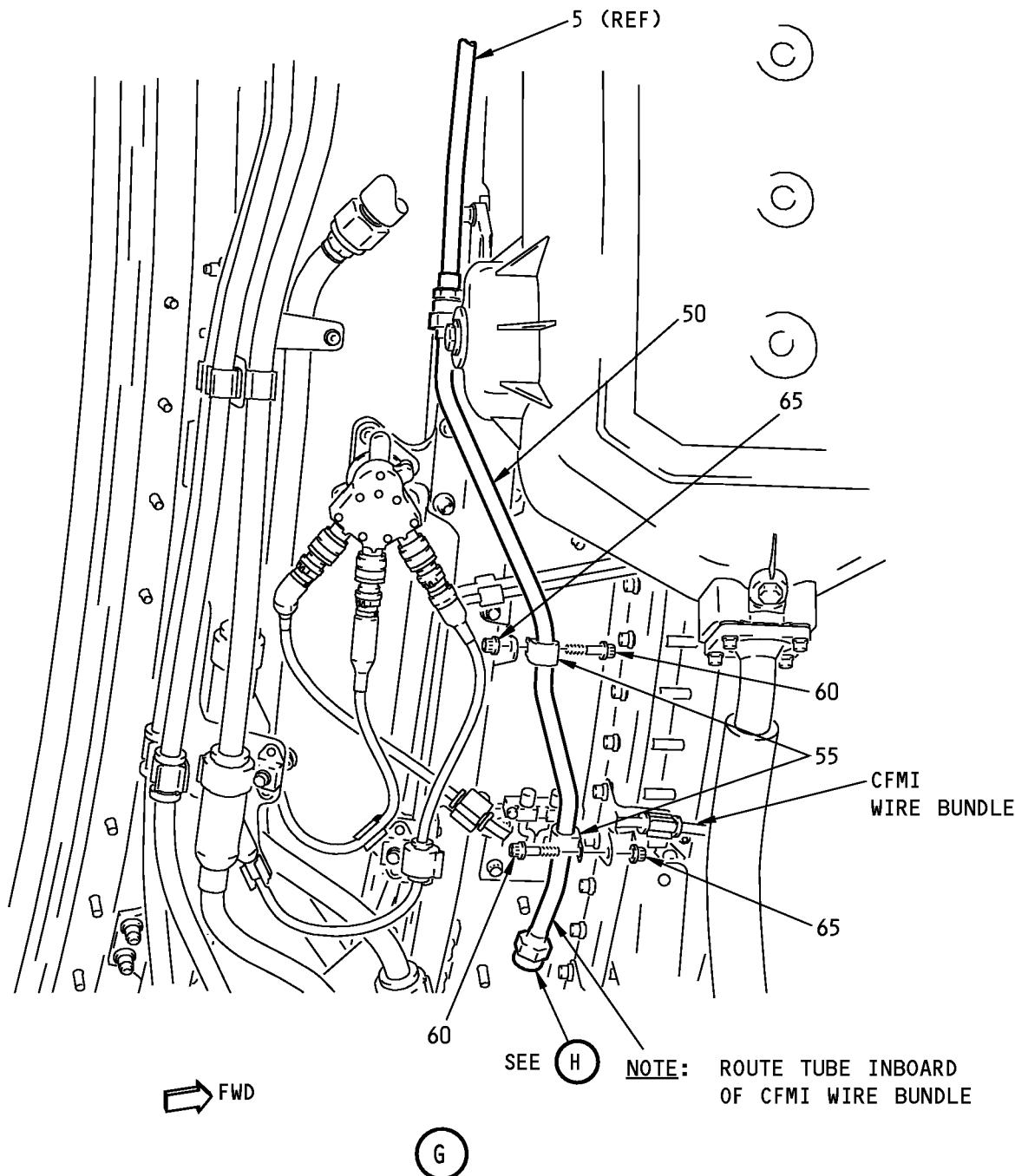
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P/P BUILDUP FIGURE 10-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
10-1		DRAINS INSTALLATION - RIGHT SIDE FAN CASE (FIGURE 10-1, SHEET 3) LUBRICATE THREADS OF TUBE ASSY (5) WITH grease, D00504(C1). ALIGN TUBE ASSY (50) ON ENGINE FAN CASE AND LOOSELY CONNECT TO TUBE ASSY (5). <u>NOTE:</u> ROUTE TUBE ASSY (50) INBOARD OF CFMI WIRE BUNDLE.		
50 C1	332A2710-33 D00504	. TUBE ASSY . GREASE APPLY LIGHT COATING OF Never-Seez NSBT-8N compound, D00006 (C6) TO UNDERSIDE HEAD OF BOLTS (60). LOOSELY SECURE TUBE ASSY (50) TO ENGINE BRACKETS AT 2 LOCATIONS WITH CLAMPS (55), BOLTS (60) AND NUTS (65).	CON	1 AR
55	J1221G08	. CLAMP (V07482)	VEN	2
60	BACB30ZF4-07	. BOLT		2
65	AS3485-10	. NUT		2
C6	D00006	. NEVER-SEEZ NSBT-8N COMPOUND TIGHTEN TUBE ASSY (50) TO 475-525 POUND-INCHES (53.7-59.3 NEWTON METERS). BACK OFF NUT TO RELAX TORQUE, THEN RETIGHTEN. ADJUST TUBE ASSY (50) TO BEST POSITION. MAKE SURE PRELOAD AT CLAMP POINTS IS NOT MORE THAN 10 POUNDS (44.5 NEWTONS). TIGHTEN BOLTS (60) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS).	CON	AR

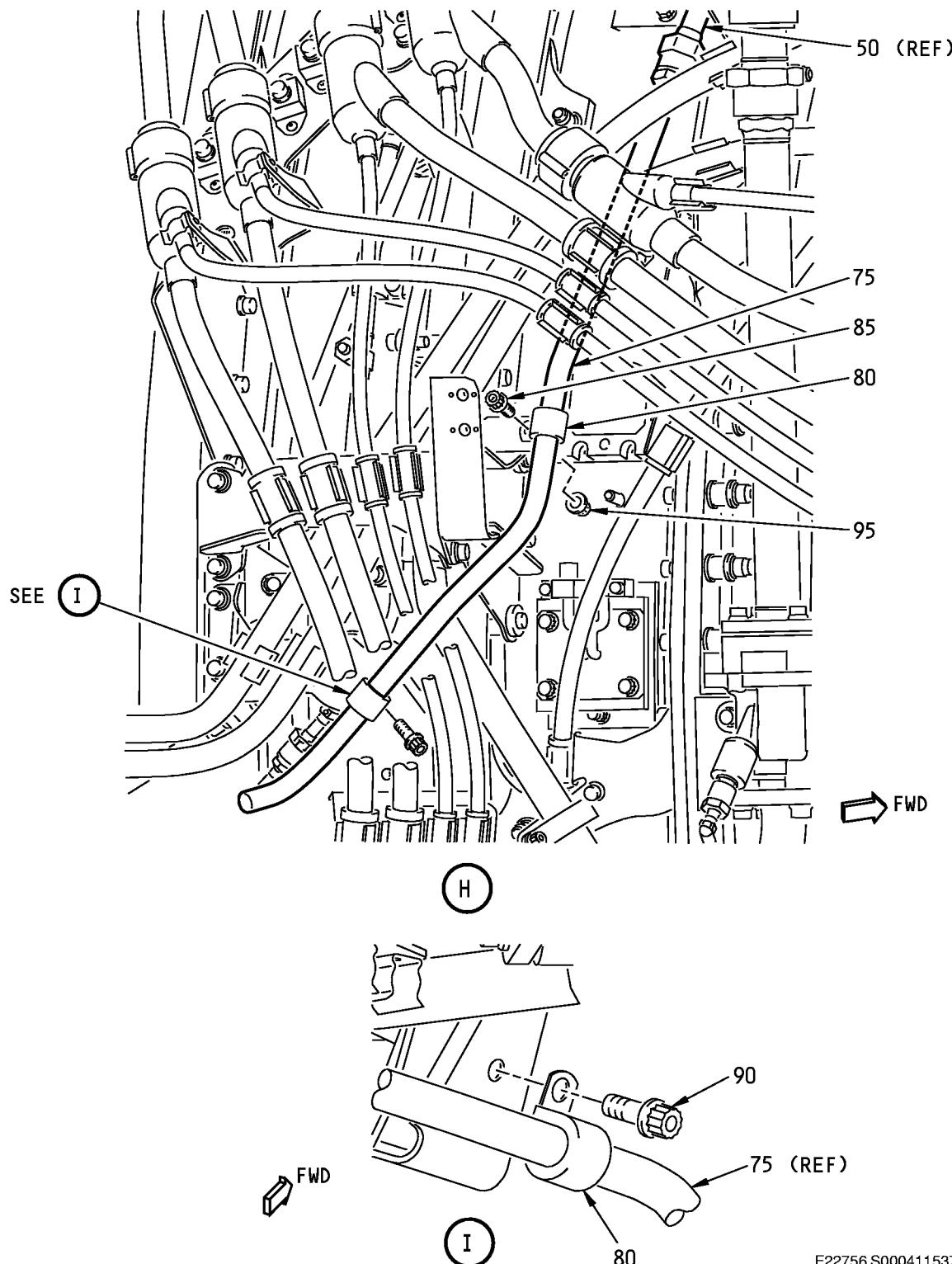
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P/P BUILDUP FIGURE 10-1

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Drains Installation - Right Side Fan Case
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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
10-1		DRAINS INSTALLATION - RIGHT SIDE FAN CASE (FIGURE 10-1, SHEET 4) LUBRICATE THREADS OF TUBE ASSY (50) WITH grease, D00504 (C1). POSITION TUBE ASSY (75) UNDER CFMI WIRE BUNDLES AND BRACKETS AND LOOSELY CONNECT TO TUBE ASSY (50).		
75 C1	332A2710-31 D00504	. TUBE ASSY . GREASE APPLY LIGHT COATING OF Never-Seez NSBT-8N compound, D00006 (C6) TO UNDERSIDE HEAD OF BOLTS (85, 90). LOOSELY ATTACH TUBE ASSY (75) AT TWO LOCATIONS TO ENGINE BRACKETS WITH CLAMPS (80), BOLTS (85, 90) AND NUT (95).	CON	1 AR
80	J1221G08	. CLAMP (V07482)	VEN	2
85	BACB30ZF4-07	. BOLT		1
90	BACB30ZF4-07	. BOLT		1
95	AS3485-10	. NUT		1
C6	D00006	. NEVER-SEEZ NSBT-8N COMPOUND TIGHTEN TUBE ASSY (75) TO 475-525 POUND-INCHES (53.7-59.3 NEWTON METERS). BACK OFF NUT TO RELAX TORQUE, THEN RETIGHTEN. ADJUST TUBE ASSY (75) TO BEST POSITION. MAKE SURE PRELOAD AT ALL CLAMP POINTS IS NOT MORE THAN 10 POUNDS (44.5 NEWTONS). TIGHTEN BOLT (85) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS). TIGHTEN BOLT (90) TO 62-72 POUND-INCHES (7.0-8.1 NEWTON METERS).	CON	AR

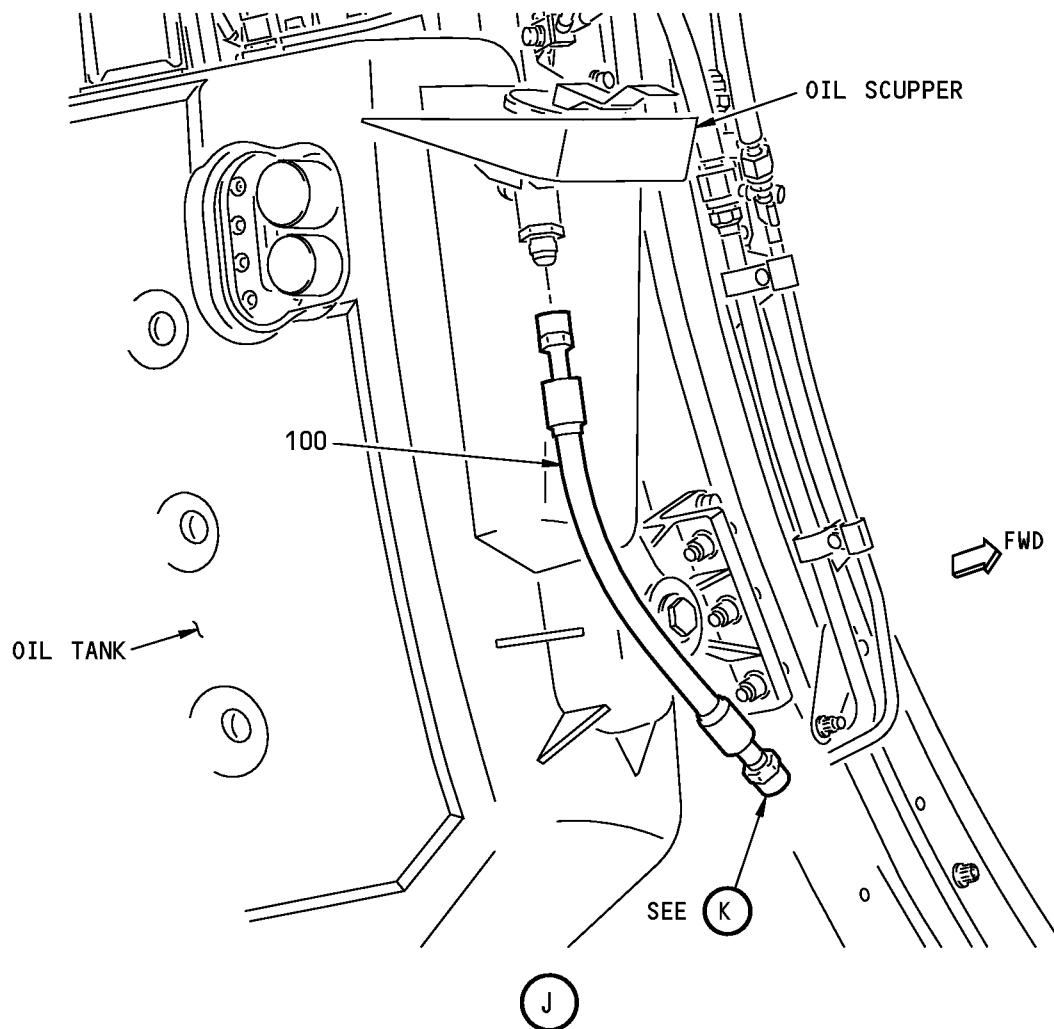
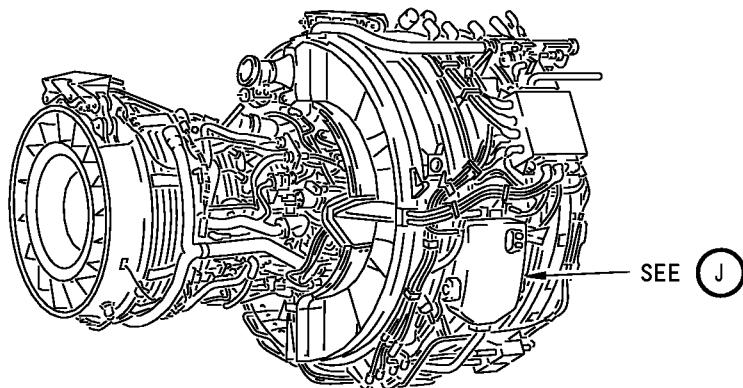
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P/P BUILDUP FIGURE 10-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
10-1 C1	D00504	<p>DRAINS INSTALLATION - RIGHT SIDE FAN CASE (FIGURE 10-1, SHEET 5)</p> <p>REMOVE PROTECTIVE CAP FROM OIL SCUPPER DRAIN NIPPLE. LUBRICATE THREADS OF NIPPLE WITH grease, D00504 (C1).</p> <p>. GREASE</p> <p>ATTACH HOSE ASSY (100) TO NIPPLE AND TIGHTEN TO 257-284 POUND-INCHES (29.0-32.0 NEWTON METERS). BACK OFF NUT TO RELAX TORQUE, THEN RETIGHTEN.</p>	CON	AR
100	B700-2	. HOSE ASSY (V98441) (SPEC S332W110-2)	VEN	1

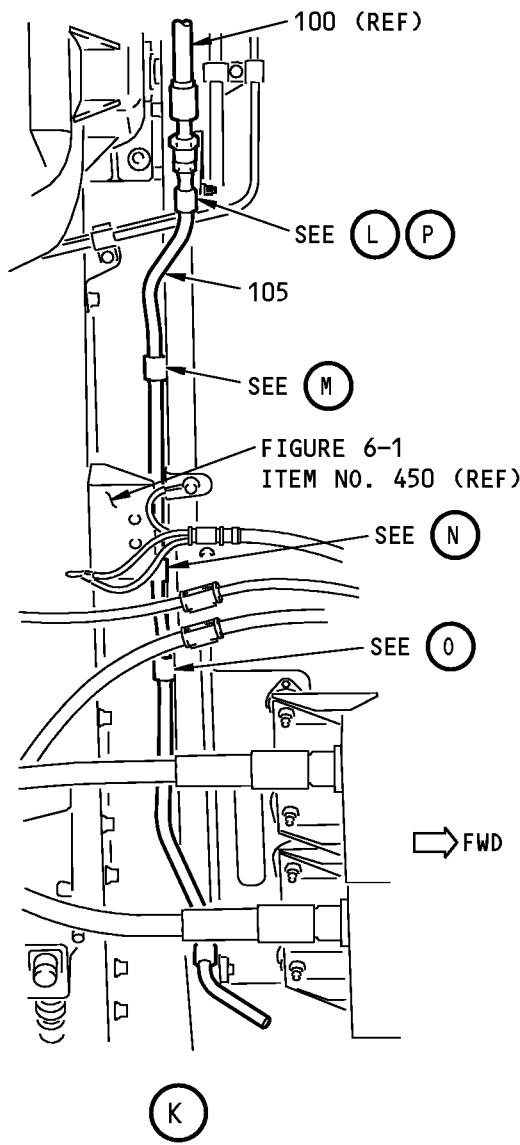
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P/P BUILDUP FIGURE 10-1

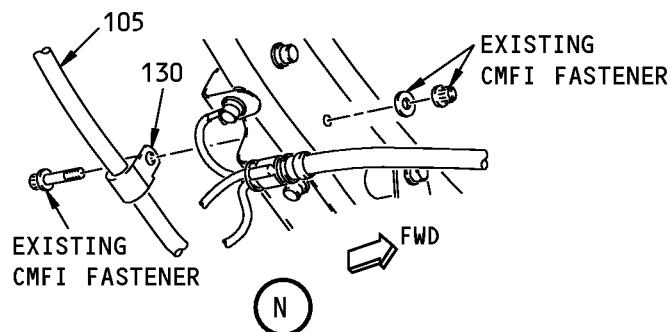
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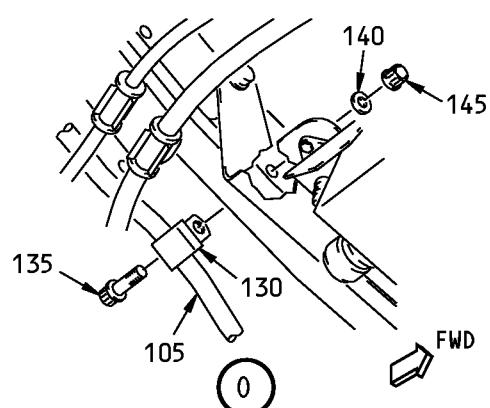
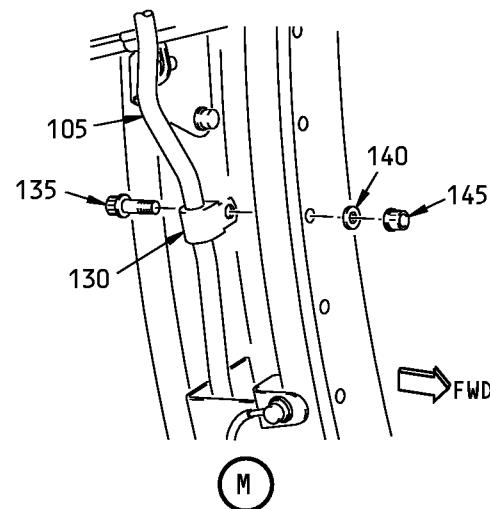
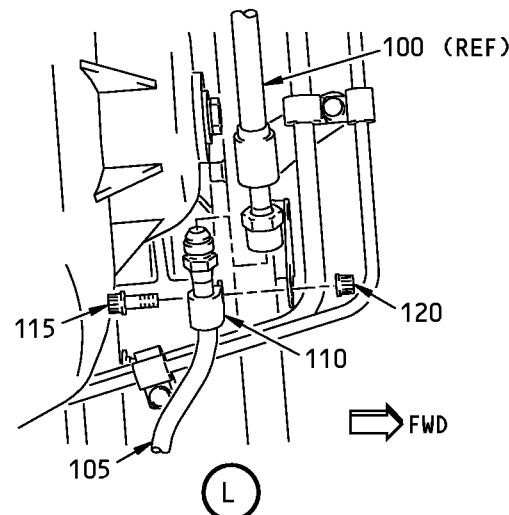
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Drains Installation - Right Side Fan Case
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P/P BUILDUP FIGURE 10-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
10-1		DRAINS INSTALLATION - RIGHT SIDE FAN CASE (FIGURE 10-1, SHEET 6)		
105	332A2710-25	LUBRICATE THREADS ON TUBE ASSY (105) WITH grease, D00504 (C1)		
C1	D00504	AND POSITION TUBE ASSY (105) ON ENGINE FAN CASE AND LOOSELY CONNECT TO HOSE ASSY (100).		
		. TUBE ASSY	CON	1
		. GREASE	AR	
		APPLY LIGHT COATING OF Never-Seez NSBT-8N compound, D00006 (C6) TO UNDERSIDE HEAD OF BOLT (115). JUST BELOW TUBE UNION, LOOSELY ATTACH TUBE (105) TO ENGINE BRACKETS WITH CLAMP (110), BOLT (115) AND NUT (120).		
110	J1221G06	. CLAMP (V07482)	VEN	1
115	BACB30ZF4-08	. BOLT		1
120	AS3485-10	. NUT		1
C6	D00006	. NEVER-SEEZ NSBT-8N COMPOUND	CON	AR
		APPLY LIGHT COATING OF Never-Seez NSBT-8N compound, D00006 (C6) TO UNDERSIDE HEAD OF BOLTS (135). AT FIRST AND THIRD THREE LOCATIONS, LOOSELY ATTACH TUBE ASSY (105) TO ENGINE BRACKETS. USE CLAMPS (130), BOLTS (135), WASHERS (140) AND NUTS (145). AT REMAINING LOCATION USE EXISTING CFMI FASTENER.		
130	J1221G06	. CLAMP (V07482)	VEN	3
135	BACB30ZF4-10	. BOLT		2
140	NAS1149C0432R	. WASHER (AGAINST ENGINE CASE)		2
145	AS3485-10	. NUT		2
C6	D00006	. NEVER-SEEZ NSBT-8N COMPOUND	CON	AR
		TIGHTEN TUBE ASSY (105) TO 257-284 POUND-INCHES (29.0-32.0 NEWTON METERS). BACK OFF NUT TO RELAX TORQUE, THEN RETIGHTEN.		

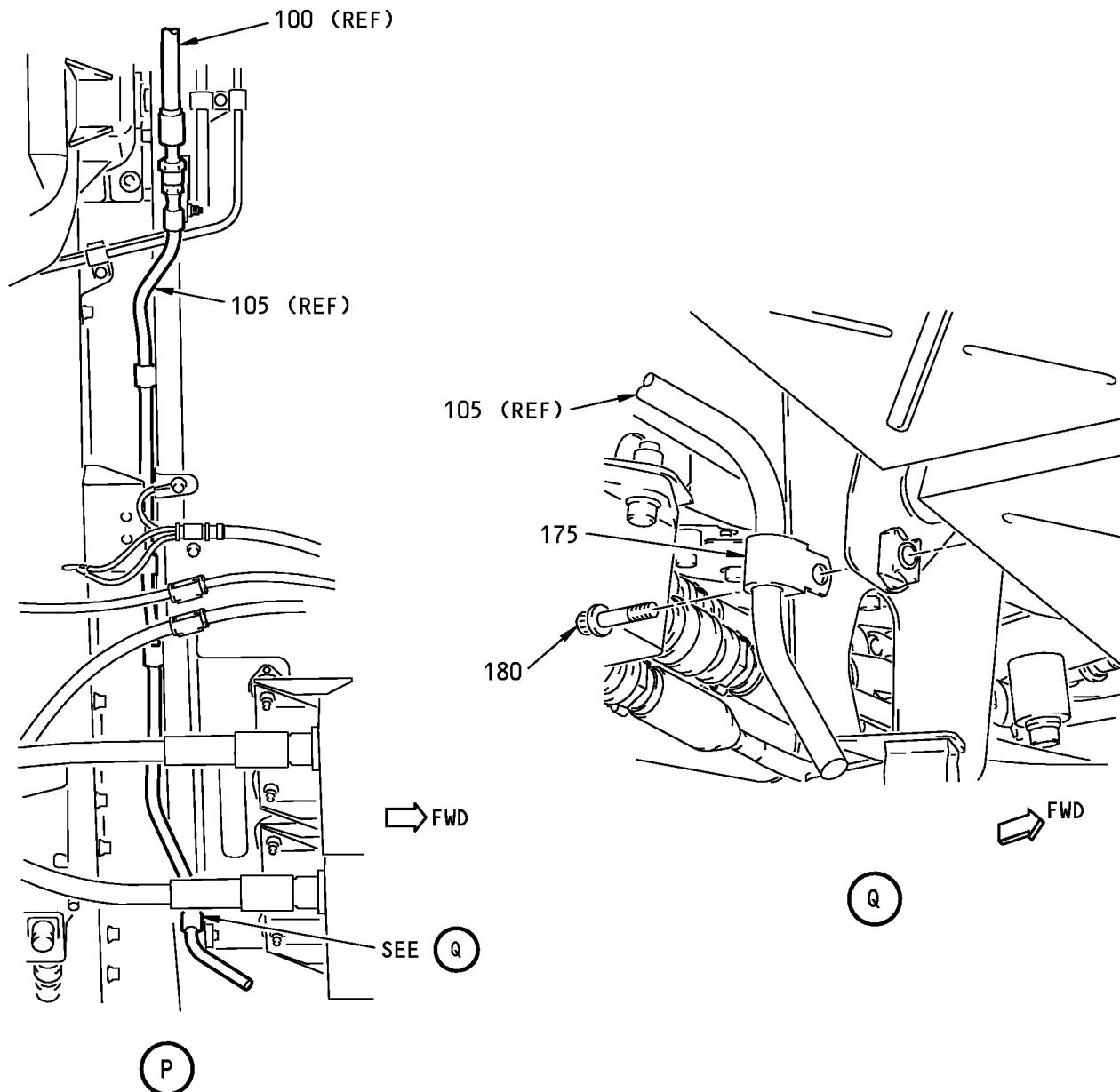
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P/P BUILDUP FIGURE 10-1

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POWERPLANT BUILDUP MANUAL

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Drains Installation - Right Side Fan Case
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P/P BUILDUP FIGURE 10-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
10-1		DRAINS INSTALLATION - RIGHT SIDE FAN CASE (FIGURE 10-1, SHEET 7) APPLY LIGHT COATING OF Never-Seez NSBT-8N compound, D00006 (C6) TO UNDERSIDE HEAD OF BOLT (180). AT BOTTOM LOCATION, LOOSELY ATTACH TUBE ASSY (105) TO ENGINE BRACKET WITH CLAMP (175) AND BOLT (180). . CLAMP (V07482) . BOLT . NEVER-SEEZ NSBT-8N COMPOUND ADJUST TUBE ASSY (105) TO BEST POSITION. MAKE SURE PRELOAD AT ALL CLAMP POINTS IS NOT MORE THAN 10 POUNDS (44.5 NEWTONS). TIGHTEN BOLTS (115), (135), (180) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS). TIGHTEN EXISTING CFMI FASTENER TO 100-110 POUND-INCHES (11.3-12.4 NEWTON METERS).		
175	J1221G06		VEN	1
180	BACB30ZF4-06			1
C6	D00006		CON	AR

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P/P BUILDUP FIGURE 10-1

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FIGURE 12-1

FUEL SUPPLY HOSE INSTALLATION

REF QEC TASK NO.: 12

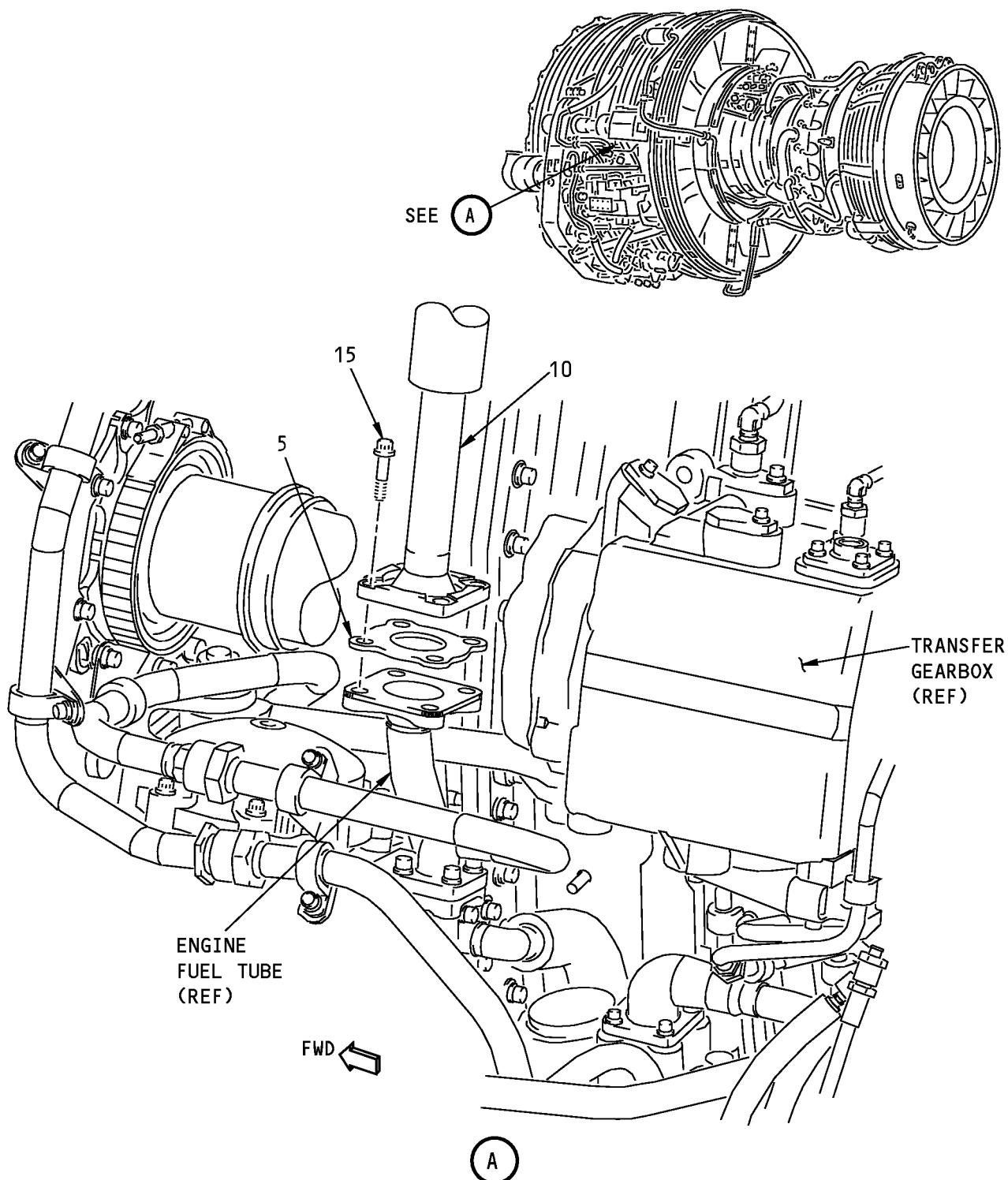
REF DWG: 332A2100

NOTE: ALL STANDARDS AND ATTACHING HARDWARE FOR THIS FIGURE WILL BE PACKAGED IN QEC TASK NO. 110.

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POWERPLANT BUILDUP MANUALFuel Supply Hose Installation
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P/P BUILDUP FIGURE 12-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
12-1		FUEL SUPPLY HOSE INSTALLATION (FIGURE 12-1, SHEET 1) VISUALLY EXAMINE ALL GASKETS AND FITTINGS FOR DAMAGE. REJECT PARTS WITH DAMAGE TO THREADS, SEAL AREAS ON FITTINGS, AND O-RINGS. LUBRICATE GASKET (5) WITH grease, D00504 (C1). POSITION GASKET (5) ON ENGINE FUEL TUBE. . GASKET . GREASE		
5 C1	MS27198-24 D00504	POSITION FUEL SUPPLY HOSE ASSY (10) ON ENGINE FUEL TUBE AND GASKET (5). APPLY A COATING OF Never-Seez NSBT-8N compound, D00006 (C2) TO THREADS AND SHANKS OF BOLTS (15). ATTACH HOSE ASSY (10) TO ENGINE FUEL TUBE WITH BOLTS (15). . HOSE ASSY, FUEL SUPPLY (V00624) (SPEC S332A280-5) . BOLT . NEVER-SEEZ NSBT-8N COMPOUND	CON	1 AR
10 15 C2	AE713733-1 BACB30ZF4-14 D00006	TIGHTEN BOLTS (15) TO 50-55 POUND-INCHES (5.6 - 6.2 NEWTON METERS)	VEN CON	1 4 AR

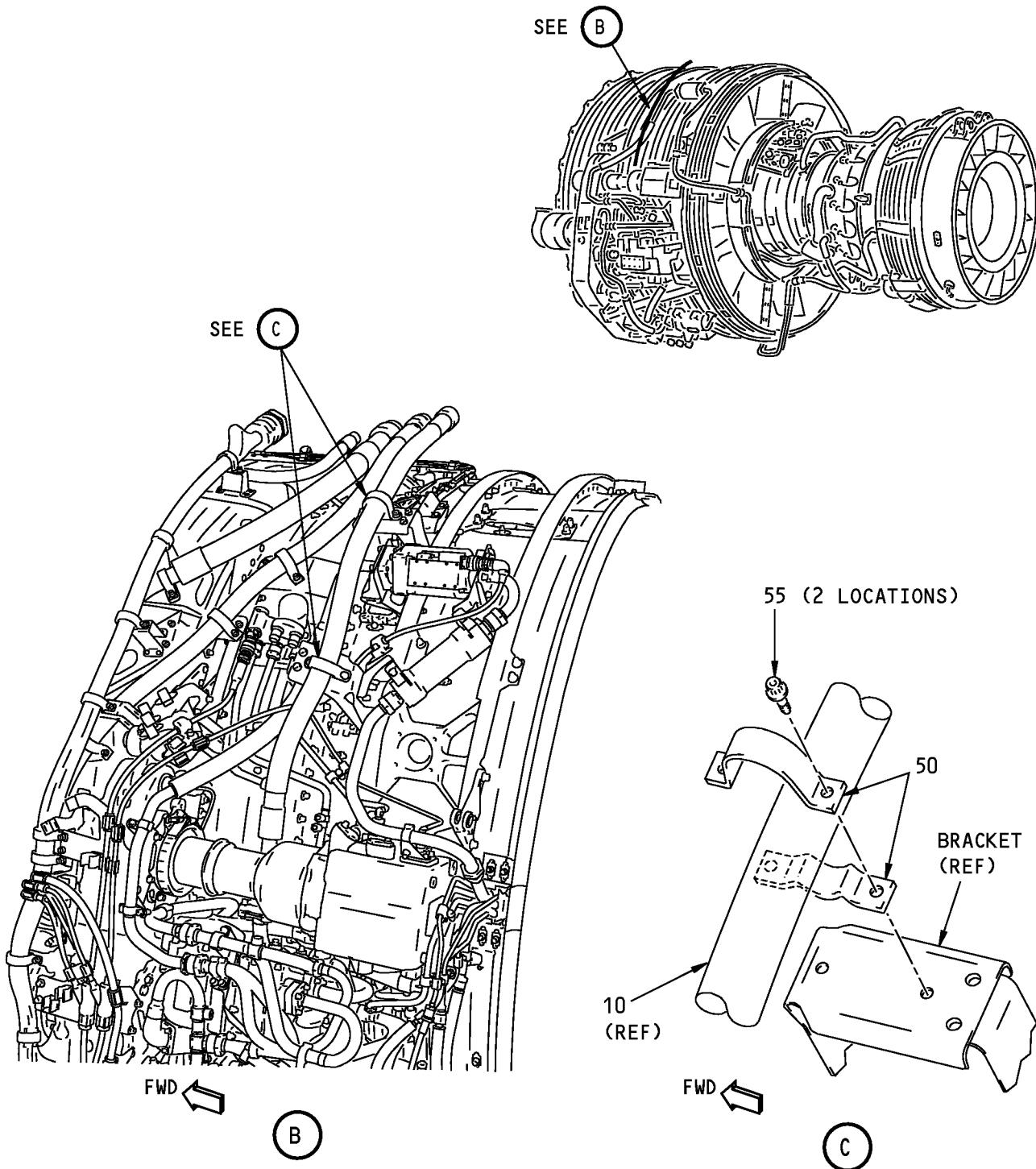
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P/P BUILDUP FIGURE 12-1

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POWERPLANT BUILDUP MANUALFuel Supply Hose Installation
Figure 12-1 (Sheet 2)**71-00-02**

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
12-1		<p>FUEL SUPPLY HOSE INSTALLATION (FIGURE 12-1, SHEET 2)</p> <p>APPLY A COATING OF Never-Seez NSBT-8N compound, D00006 (C2) TO THREADS AND SHANKS OF BOLTS (55).</p> <p>AT TWO LOCATIONS, LOOSELY INSTALL HOSE ASSY (10) ON LEFT FAN CASE WITH CLAMPS (50) AND BOLTS (55).</p> <p>NOTE: MAINTAIN A MINIMUM CLEARANCE OF 5/8 INCHES (15.9 MM) BETWEEN FUEL SUPPLY HOSE ASSY (10) AND ADJACENT ELECTRICAL WIRING.</p>		
50	TA0910091H1	. CLAMP (V84971)	VEN	2
55	BACB30ZF4-07	. BOLT		4
C2	D00006	. NEVER-SEEZ NSBT-8N COMPOUND	CON	AR
		ADJUST HOSE ASSY (10) TO BEST POSITION AND TIGHTEN BOLTS (55) TO 98-110 POUND-INCHES (11.1-12.4 NEWTON METERS).		

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P/P BUILDUP FIGURE 12-1

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FIGURE 13-1

12 O'CLOCK STRUT INSTALLATION

REF QEC TASK NO.: 13

**REF DWG: 332A2300
332A2370**

NOTE: ALL STANDARDS AND ATTACHING HARDWARE FOR THIS FIGURE WILL BE PACKAGED
IN QEC TASK NO. 110.

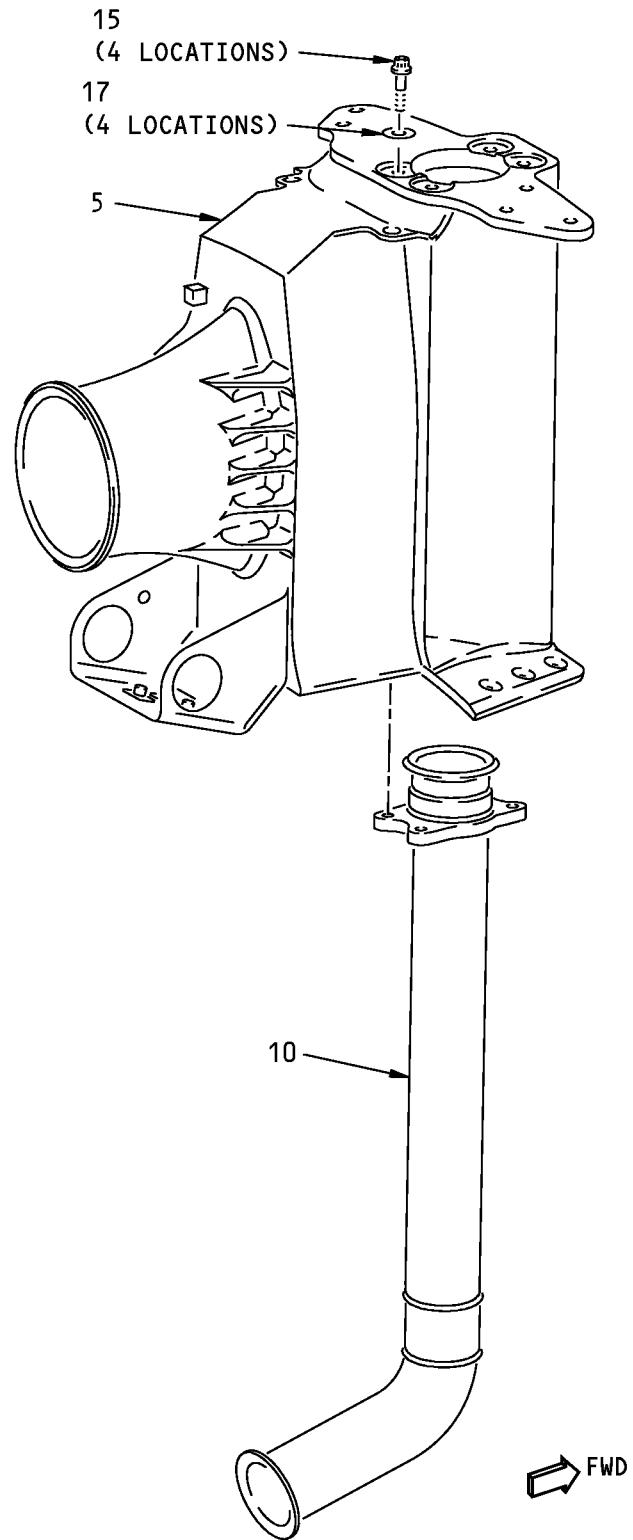
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P/P BUILDUP FIGURE 13-1

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POWERPLANT BUILDUP MANUAL12 O'Clock Strut Installation
Figure 13-1 (Sheet 1)**71-00-02**

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
13-1		<p>12 O'CLOCK STRUT INSTALLATION (FIGURE 13-1, SHEET 1)</p> <p>IN THIS PROCEDURE, DO NOT TIGHTEN BOLTS UNLESS INSTRUCTED OR INSTALL PARTS IN A DIFFERENT SEQUENCE.</p> <p>PREASSEMBLY OF 12 O'CLOCK STRUT</p> <p>CAUTION: BE CAREFUL NOT TO GOUGE THE INNER WALL OF THE 12 O'CLOCK STRUT WHEN THE CTAI DUCT ASSY IS INSTALLED.</p> <p>INSTALL DUCT ASSY (10) INTO 12 O'CLOCK STRUT (5) FROM BOTTOM.</p> <p>LOOSELY SECURE WITH BOLTS (15) AND WASHERS (17).</p> <ul style="list-style-type: none"> . 12 O'CLOCK STRUT ASSY . 12 O'CLOCK STRUT ASSY (REPLACED BY 332A2371-4) . DUCT ASSY-CTAI . DUCT ASSY-CTAI (OPTIONAL TO 332A2390-45) . BOLT . WASHER 		
5	332A2371-4	. 12 O'CLOCK STRUT ASSY	1	
5	332A2371-3	. 12 O'CLOCK STRUT ASSY (REPLACED BY 332A2371-4)	LTD	-
10	332A2390-45	. DUCT ASSY-CTAI		1
10	332A2390-43	. DUCT ASSY-CTAI (OPTIONAL TO 332A2390-45)	OPT	-
15	BACB30PN4H7	. BOLT		4
17	BACW10BP4ACU	. WASHER		4

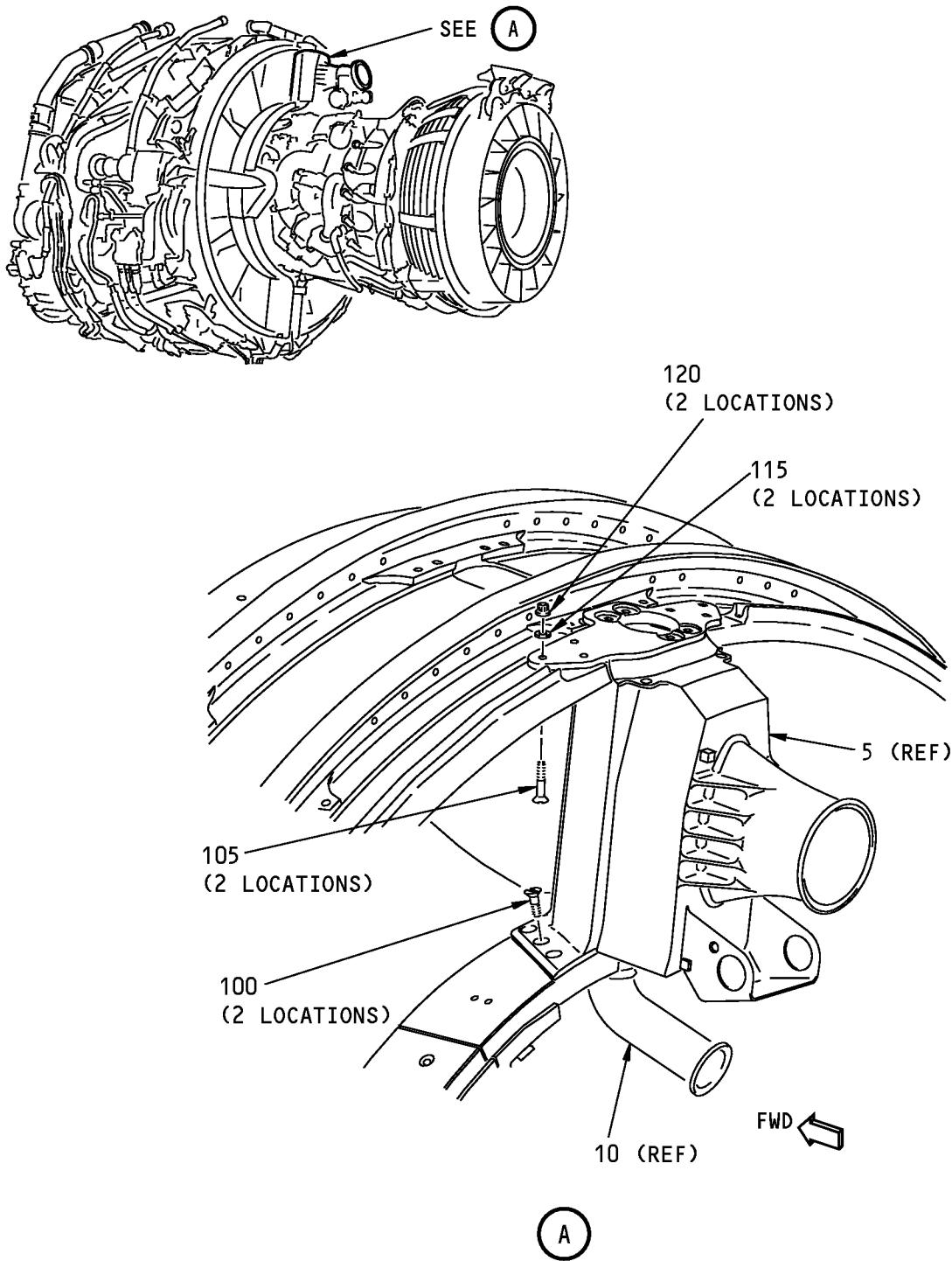
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P/P BUILDUP FIGURE 13-1

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12 O'Clock Strut Installation
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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
13-1		<p>12 O'CLOCK STRUT INSTALLATION (FIGURE 13-1, SHEET 2)</p> <p>TEMPORARILY SECURE 12 O'CLOCK STRUT ASSY (5) TO FAN CASE. LOOSELY ATTACH LOWER FLANGES OF STRUT ASSY TO EXTENSION RING OF ENGINE USING BOLTS (100) IN CENTER HOLE OF FLANGES. LOOSELY ATTACH UPPER FLANGES OF STRUT ASSY TO OUTER FAN CASE USING BOLTS (105), WASHERS (115) AND NUTS (120) IN OUTER HOLE OF FLANGES.</p>		

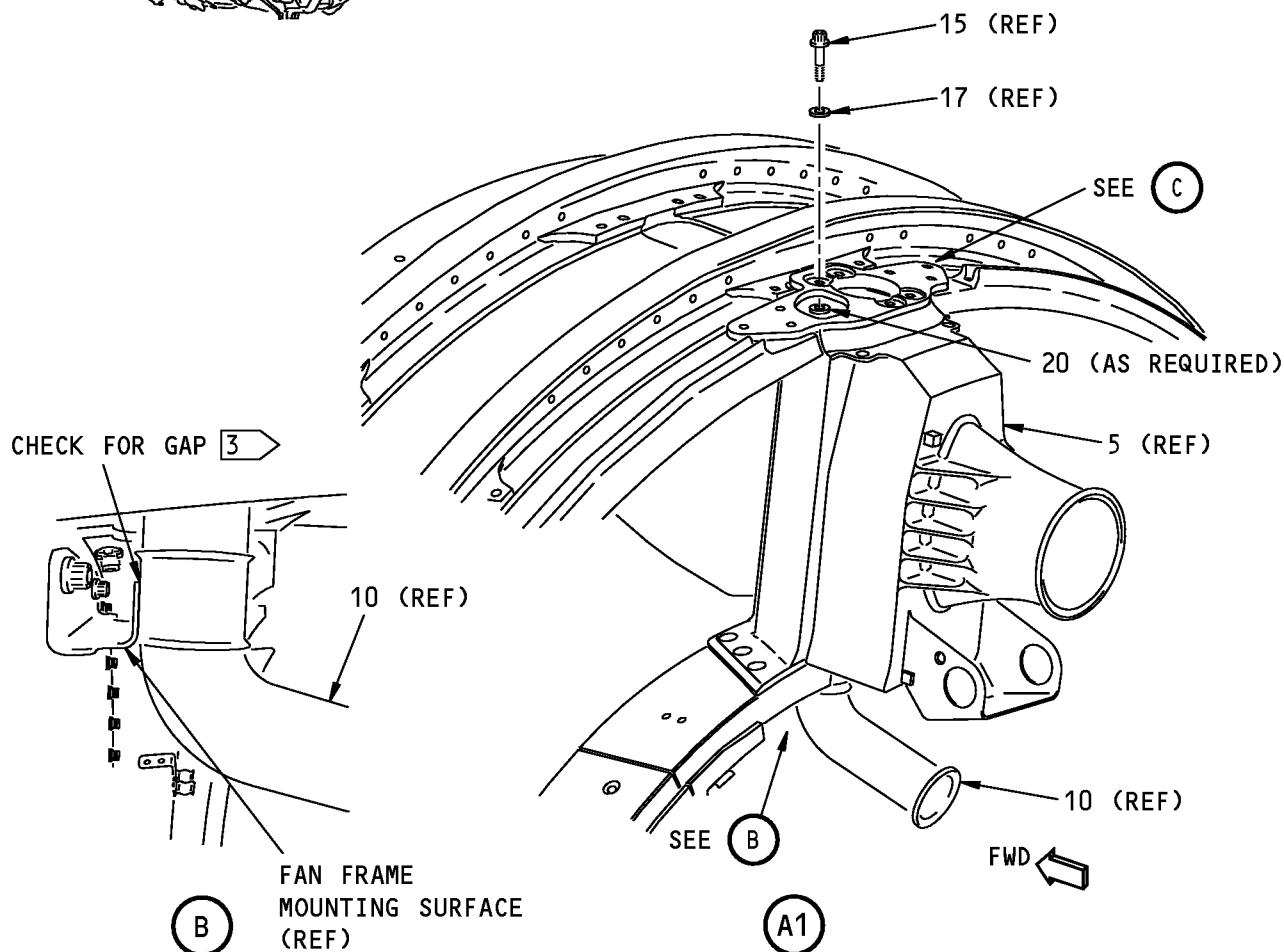
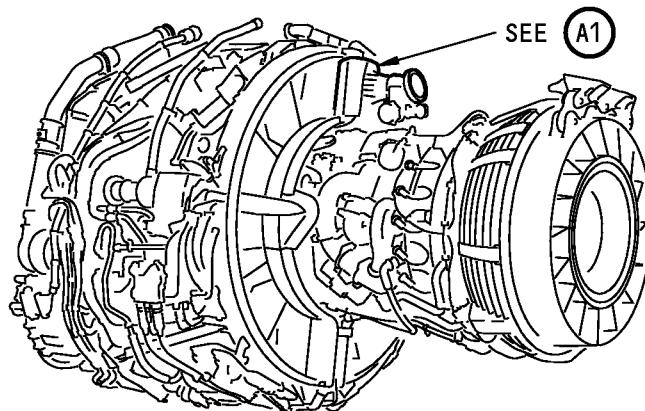
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P/P BUILDUP FIGURE 13-1

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- 3 DUCT (10) MUST BE FLUSH WITH FAN FRAME MOUNTING SURFACE WITHOUT PRELOAD. INSTALL WASHERS (20) IN MATCHED PAIRS BETWEEN DUCT FLANGE (10) AND STRUT ASSEMBLY (5). DIAGONAL PAIRS NOT ACCEPTABLE.

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12 O'Clock Strut Installation
Figure 13-1 (Sheet 3)

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
13-1		<p>12 O'CLOCK STRUT INSTALLATION (FIGURE 13-1, SHEET 3)</p> <p>CHECK DUCT ASSY (10) POSITION.</p> <p>DUCT MUST BE FLUSH TO FAN FRAME MOUNTING SURFACE WITHOUT PRELOADING DUCT.</p> <p>TO ADJUST DUCT POSITION:</p> <p>REMOVE 12 O'CLOCK STRUT ASSY (5) FROM ENGINE. REMOVE DUCT ASSY (10) FROM 12 O'CLOCK STRUT.</p> <p>INSTALL WASHERS (20) BETWEEN FLANGE HOLES OF DUCT ASSY AND 12 O'CLOCK STRUT. WASHERS MUST BE INSTALLED IN MATCHED FORWARD, AFT, LEFT OR RIGHT PAIRS ONLY. DIAGONAL PAIRS NOT ACCEPTABLE.</p> <p>TEMPORARILY RE-SECURE 12 O'CLOCK STRUT. RECHECK DUCT POSITION. REPEAT THE ABOVE PROCEDURE UNTIL DUCT IS ALIGNED.</p> <p>IF INSTALLED, MAKE A RECORD OF THE QUANTITY AND LOCATIONS OF WASHERS (20).</p> <p>REMOVE BOLTS (15), WASHERS (17) AND, IF INSTALLED, WASHERS (20).</p> <p>APPLY Never-Seez NSBT-8N compound, D00006 (C1) TO THREADS AND SHANK OF BOLTS (15).</p> <p>INSTALL BOLTS (15), WASHERS (17) AND, IF REQUIRED, WASHERS (20)</p> <ul style="list-style-type: none"> . WASHER (THICK) . WASHER (THIN) . NEVER-SEEZ NSBT-8N COMPOUND <p>ONCE DUCT IS ALIGNED, TIGHTEN BOLTS (15) TO 73-77 POUND-INCHES (8.25-8.7 NEWTON METERS) AND INSTALL safety cable kit, G50375 (C6) OR MS20995NC32 lockwire, G01912 (C7).</p> <ul style="list-style-type: none"> . SAFETY CABLE KIT . MS20995NC32 LOCKWIRE 		
20	NAS1149C0432R		OPT	AR
20	NAS1149C0416R		OPT	AR
C1	D00006		CON	AR
C6	G50375		CON	AR
C7	G01912		CON	AR

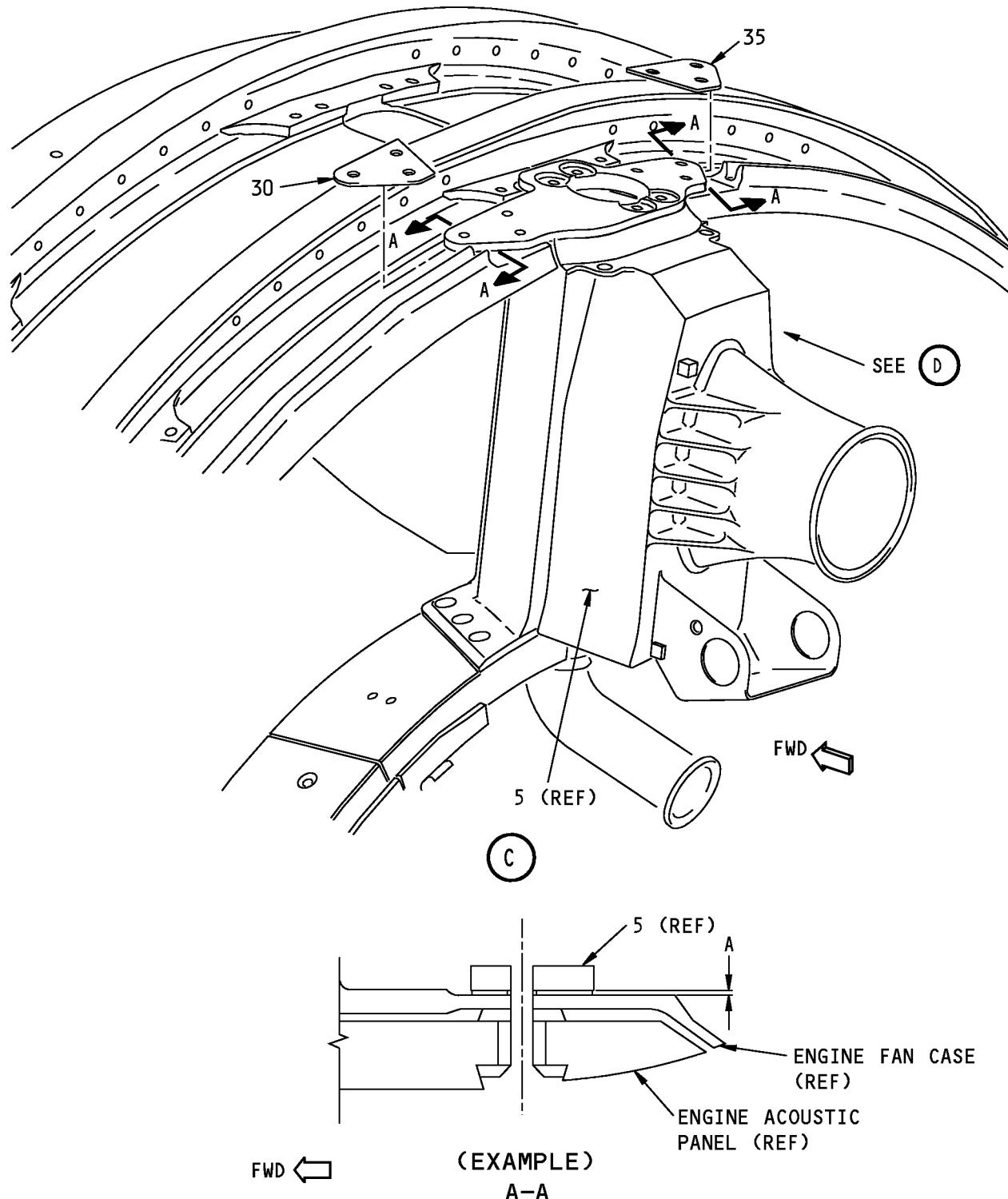
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P/P BUILDUP FIGURE 13-1

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737-600/700/800/900
POWERPLANT BUILDUP MANUAL12 O'Clock Strut Installation
Figure 13-1 (Sheet 4)

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P/P BUILDUP FIGURE 13-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
13-1		<p>12 O'CLOCK STRUT INSTALLATION (FIGURE 13-1, SHEET 4)</p> <p>MEASURE GAP "A" BETWEEN OUTER FAN CASE AND 12 O'CLOCK STRUT ON BOTH SIDES. PEEL SHIMS (30) AND (35) UNTIL DESIRED THICKNESS IS ACHIEVED.</p> <p>NOTE: IF GAP EXCEEDS 0.063 INCH (1.6 MM), USE TWO SHIMS. GAPS OF 0.070 INCH (1.78 MM) OR MORE ARE NOT PERMITTED.</p>		
30	332A2373-1	. SHIM, LH (MAX OF 2)	AR	
35	332A2373-2	. SHIM, RH (MAX OF 2)	AR	

REMOVE 12 O'CLOCK STRUT (5) FROM ENGINE. KEEP SHIMS AND FASTENERS FOR LATER INSTALLATION.

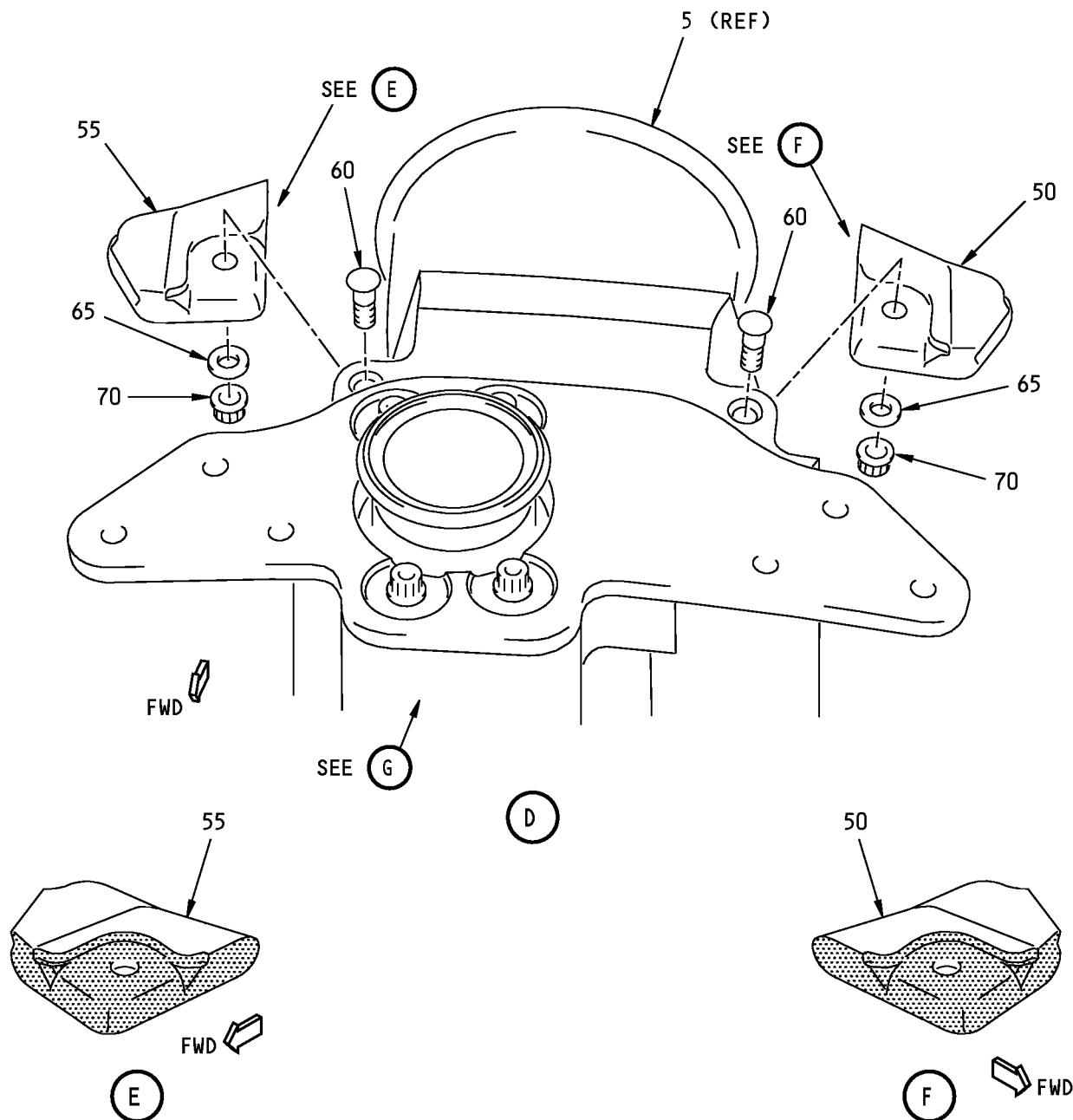
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P/P BUILDUP FIGURE 13-1

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POWERPLANT BUILDUP MANUAL

█ AREAS OF SEALANT APPLICATION.

12 O'Clock Strut Installation
Figure 13-1 (Sheet 5)

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P/P BUILDUP FIGURE 13-1
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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
13-1		<p>12 O'CLOCK STRUT INSTALLATION (FIGURE 13-1, SHEET 5)</p> <p>CAUTION: MAKE SURE ALL SEALANTS ARE APPLIED CORRECTLY. 12 O'CLOCK STRUT IS PART OF FIRE SHIELD BETWEEN ENGINE AND STRUT. INCORRECT APPLICATION OF SEALANTS MAY WEAKEN FIRE PROTECTION.</p> <p>IF sealant, A00803 (C3) IS USED, BRUSH APPLY Dapco No. 1-100 primer, C00944 (C2) TO FAYING SURFACES ON SEALS (50) AND (55) AND 12 O'CLOCK STRUT (5).</p> <p>50 332A2372-3 . SEAL, LH 1 55 332A2372-4 . SEAL, RH 1 C2 C00944 . DAPCO NO. 1-100 PRIMER CON AR</p> <p>APPLY sealant, A00803 (C3) OR sealant, A50096 (C4) TO FAYING SURFACES SHOWN ON SEALS (50) AND (55). ATTACH SEALS TO 12 O'CLOCK STRUT (5) WITH BOLTS (60), WASHERS (65) AND NUTS (70).</p> <p>60 BACB30VF4K3 . BOLT 2 65 BACW10BP4PK . WASHER (UNDER NUT) 2 70 BACN11Z4CK . NUT 2 C3 A00803 . SEALANT CON AR C4 A50096 . SEALANT CON AR</p> <p>TIGHTEN BOLTS (60) TO 10 POUND-INCHES (1.1 NEWTON METERS).</p> <p>NOTE: TO FACILITATE INSTALLATION, BLEED CONTROLLER INSTALLATION/FIGURE 14-1 ITEMS 5 THRU 30 MAY BE ATTACHED TO 12 O'CLOCK STRUT (5) AT THIS TIME.</p>		

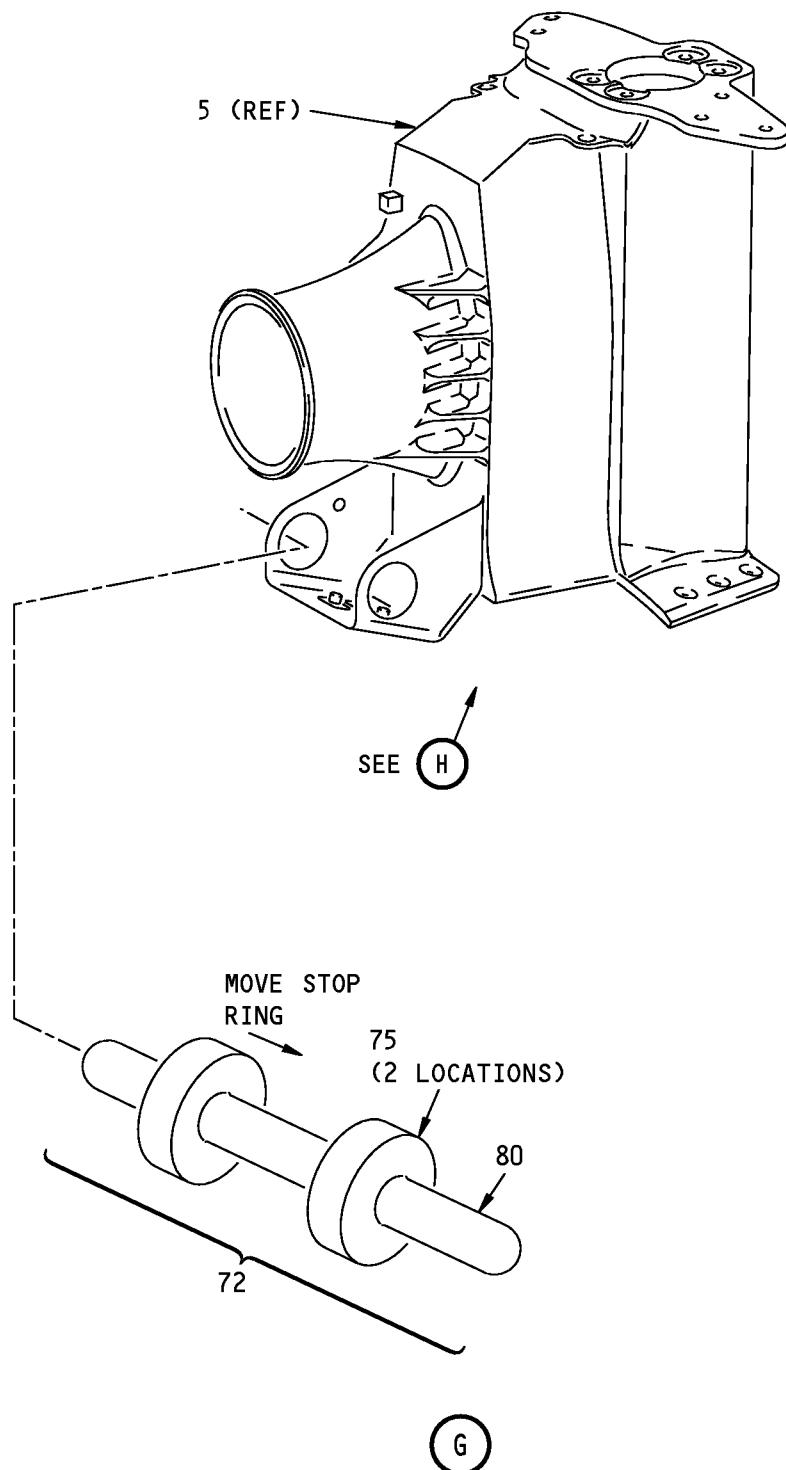
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P/P BUILDUP FIGURE 13-1

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737-600/700/800/900
POWERPLANT BUILDUP MANUAL12 O'Clock Strut Installation
Figure 13-1 (Sheet 6)

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P/P BUILDUP FIGURE 13-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
13-1		12 O'CLOCK STRUT INSTALLATION (FIGURE 13-1, SHEET 6) MOVE LH RUBBER STOP RING (75) TOWARDS CENTER OF ROD (80). POSITION ROD ASSY (72) IN 12 O'CLOCK STRUT (5) BRACKET. RE-POSITION LH STOP RING (75) IN ROD (80) CHANNEL. . ROD ASSY . ROD ASSY (OPTIONAL TO 315A2080-4) . . STOP RING (QTY 2) . . ROD (QTY 1)		
72	315A2080-4		OPT	1
72	315A2080-1		REF	-
75	315A2083-1		REF	-
80	315A2081-5		REF	-

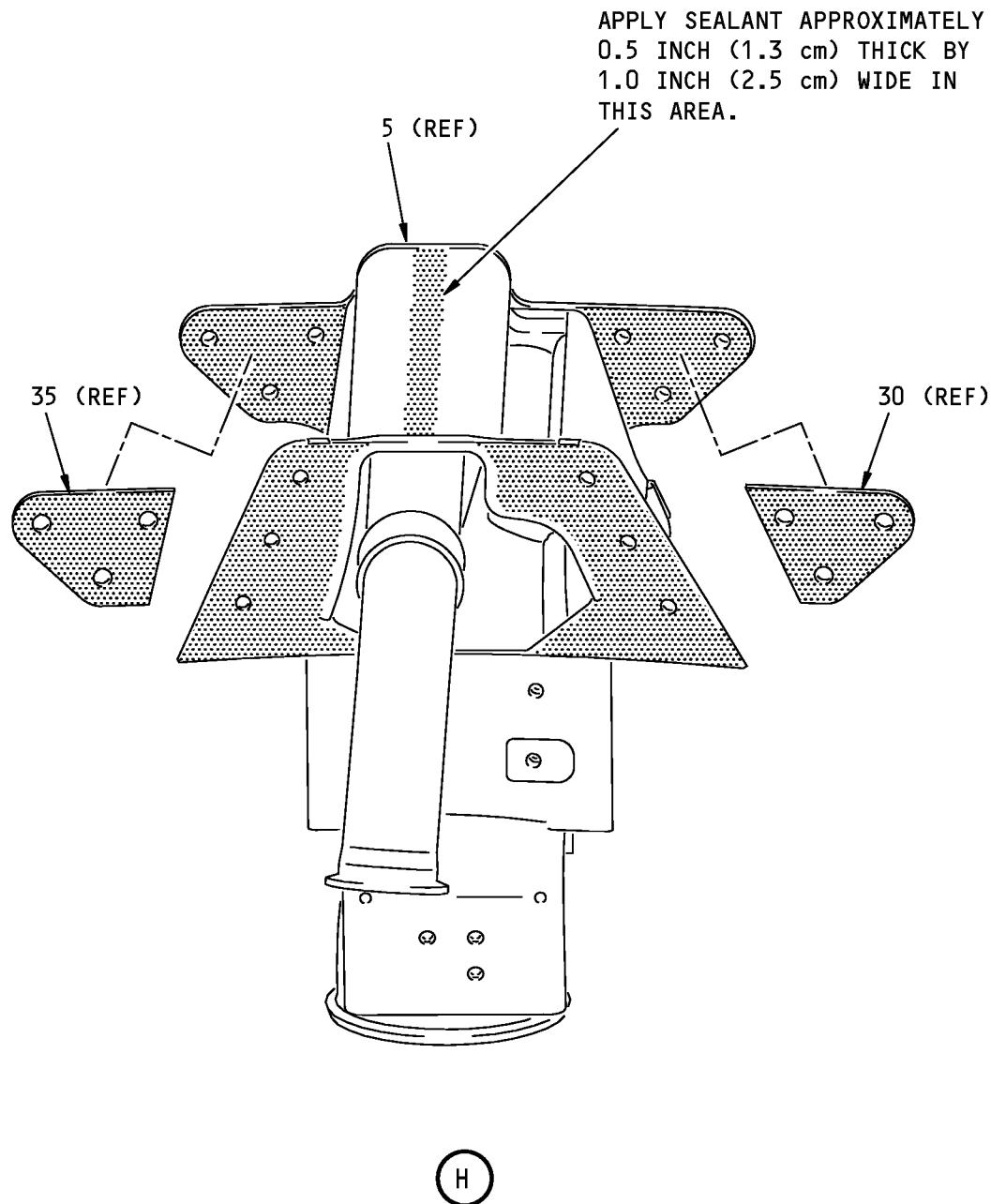
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P/P BUILDUP FIGURE 13-1

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POWERPLANT BUILDUP MANUAL

AREAS OF SEALANT APPLICATION.

12 O'Clock Strut Installation
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P/P BUILDUP FIGURE 13-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
13-1		<p>12 O'CLOCK STRUT INSTALLATION (FIGURE 13-1, SHEET 7)</p> <p>IF sealant, A00803 (C3) IS USED, APPLY Dapco No. 1-100 primer, C00944 (C2) TO FAYING SURFACES OF 12 O'CLOCK STRUT ASSY (5) AND INNER AND OUTER ENGINE FAN CASE AND TO BOTH SIDES OF SHIMS (30) AND (35). PERMIT PRIMER TO DRY.</p> <p>NOTE: Dapco No. 1-100 primer, C00944 (C2) DRIES IN APPROXIMATELY 1 HOUR AND CHANGES FROM A GREEN COLOR TO A PINK COLOR.</p>		
C2	C00944	<p>. DAPCO NO. 1-100 PRIMER</p> <p>APPLY sealant, A00803 (C3) OR sealant, A50096 (C4) TO FAYING SURFACES OF 12 O'CLOCK STRUT ASSY (5) WITH INNER AND OUTER FAN CASE, TO FORWARD LOCATION OF 12 O'CLOCK STRUT AND TO BOTTOM OF SHIMS (30) AND (35) AS SHOWN.</p> <p>NOTE: WHEN APPLYING SEALANT, ENSURE LAYER IS UNIFORM AND COVERS ENTIRE FAYING SURFACE TO A DEPTH OF 0.005-0.010 INCH. AN ADDITIONAL SMALL BEAD OF SEALANT NEAR EDGE OF FAYING SURFACE IS PERMITTED TO ENSURE PROPER SQUEEZE-OUT OF SEALANT.</p> <p>ATTACH SHIMS (30) AND (35) TO OUTER ENGINE FAN CASE FAYING SURFACES, ALIGNING HOLES IN SHIMS WITH HOLES IN ENGINE FAN CASE. APPLY sealant, A00803 (C3) TO TOP FAYING SURFACE OF SHIMS (30) AND (35).</p> <p>NOTE: SEALANT MUST BE APPLIED ON BOTH SIDES OF SHIMS.</p>	CON	AR
C3	A00803	. SEALANT	CON	AR
C4	A50096	. SEALANT	CON	AR

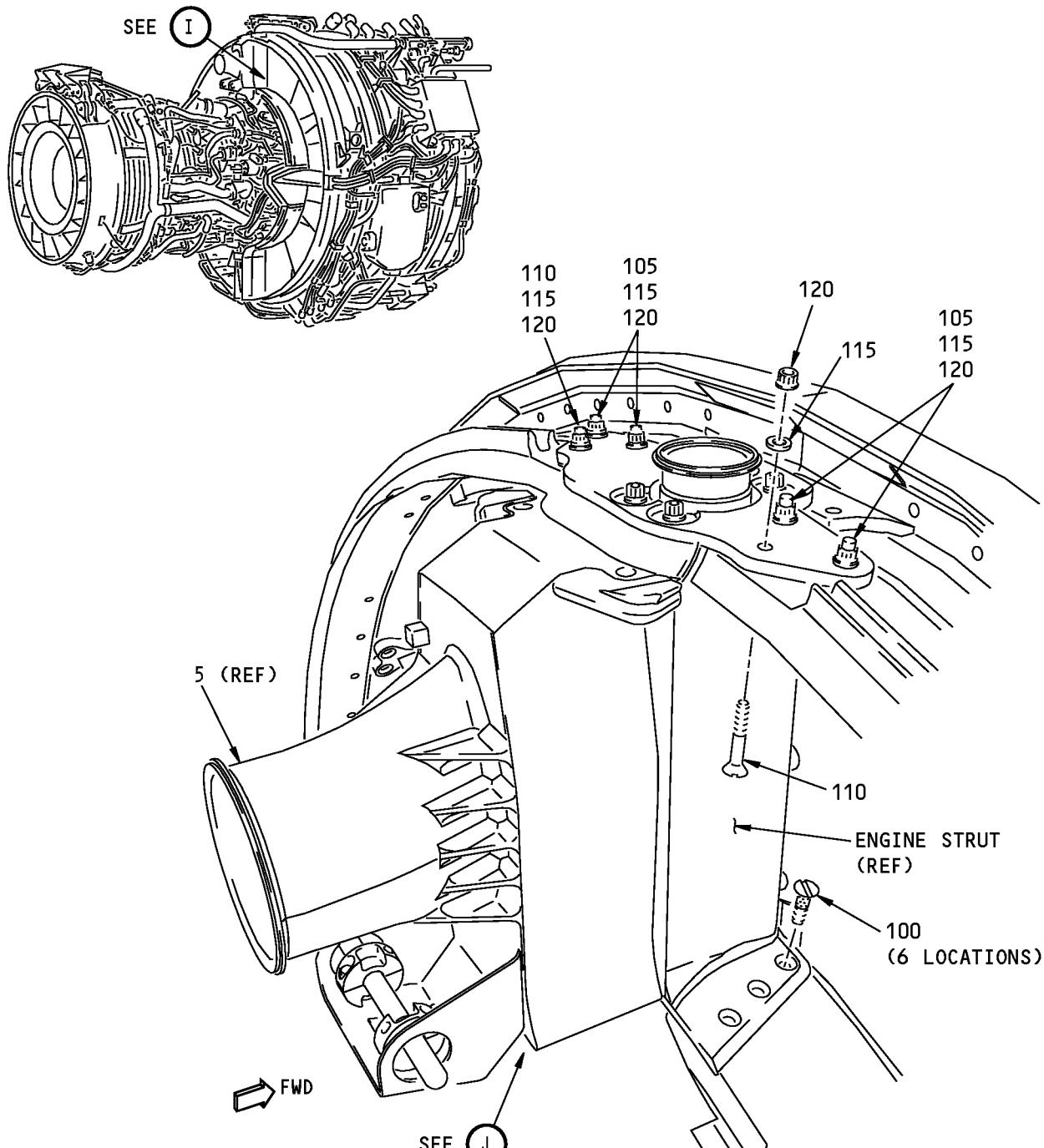
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P/P BUILDUP FIGURE 13-1

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POWERPLANT BUILDUP MANUAL

AREAS OF SEALANT APPLICATION.

I

12 O'Clock Strut Installation
Figure 13-1 (Sheet 8)

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P/P BUILDUP FIGURE 13-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
13-1		12 O'CLOCK STRUT INSTALLATION (FIGURE 13-1, SHEET 8) <p>APPLY AC962-73C peelable parting agent, G50365 (C5) OR AZ 634-2 peelable parting agent, G50367 (C8) OR Rexco Partall Coverall Film peelable parting agent, G50368 (C9) OR temporary coating, G50369 (C10) TO SURFACES ON ENGINE OPPOSITE WHERE SEALANT (C3) OR (C4) WAS APPLIED (INNER AND OUTER ENGINE FAN CASE INTERFACES AND DOWN THE CENTER AREA OF ENGINE STRUT INTERFACE WITH 12 O'CLOCK STRUT (5)).</p> <p>NOTE: APPLY AGENT TO A WIDE ENOUGH AREA TO ALLOW FOR SEALANT SQUEEZE-OUT.</p>		
C5	G50365	. AC962-73C PEELABLE PARTING AGENT	CON	AR
C8	G50367	. AZ 634-2 PEELABLE PARTING AGENT	CON	AR
C9	G50368	. REXCO PARTALL COVERALL FILM PEELABLE PARTING AGENT	CON	AR
C10	G50369	. SPRAYLAT SC-1071H-1 AGENT	CON	AR
		LUBRICATE SHANKS OF BOLTS (105) AND (110) WITH sealant, A00803 (C3) OR sealant, A50096 (C4). APPLY Never-Seez NSBT-8N compound, D00006 (C1) TO THREADS AND SHANK OF BOLTS (100). IF sealant, A00803 (C3) IS USED, APPLY Dapco No. 1-100 primer, C00944 (C2) BEFORE SEALANT APPLICATION.		
100	BACB30NN4K6	. BOLT		6
105	BACB30NN4K18	. BOLT		4
110	BACB30NN4K16	. BOLT		2
C1	D00006	. NEVER-SEEZ NSBT-8N COMPOUND	CON	AR
C2	C00944	. DAPCO NO. 1-100 PRIMER	CON	AR
C3	A00803	. SEALANT	CON	AR
C4	A50096	. SEALANT	CON	AR
		POSITION 12 O'CLOCK STRUT ASSY (5) ON ENGINE FAN CASE. ATTACH 12 O'CLOCK STRUT ASSY (5) TO INNER FAN CASE WITH LUBRICATED BOLTS (100). ATTACH 12 O'CLOCK STRUT ASSY TO OUTER FAN CASE WITH LUBRICATED BOLTS (105) AND (110), WASHERS (115) AND NUTS (120).		
		NOTE: IF GAP REMAINS AFTER TIGHTENING BOLT (105, 110), USE OF AN ADDITIONAL WASHER (115) IS PERMITTED.		
115	BACW10BP4PK	. WASHER		6
120	BACN11Z4CK	. NUT		6
		MAKE SURE BOLTS (100) FULLY ENGAGE NUTPLATES. CHECK BOLT PROTRUSION. MINIMUM BOLT PROTRUSION IS WHEN BOLT IS FLUSH WITH THE END OF THE NUTPLATE. TIGHTEN BOLTS (100) TO 68-82 POUND-INCHES (7.7-9.3 NEWTON METERS). TIGHTEN BOLTS (105) AND (110) TO 72-88 POUND-INCHES (8.1-9.9 NEWTON METERS).		

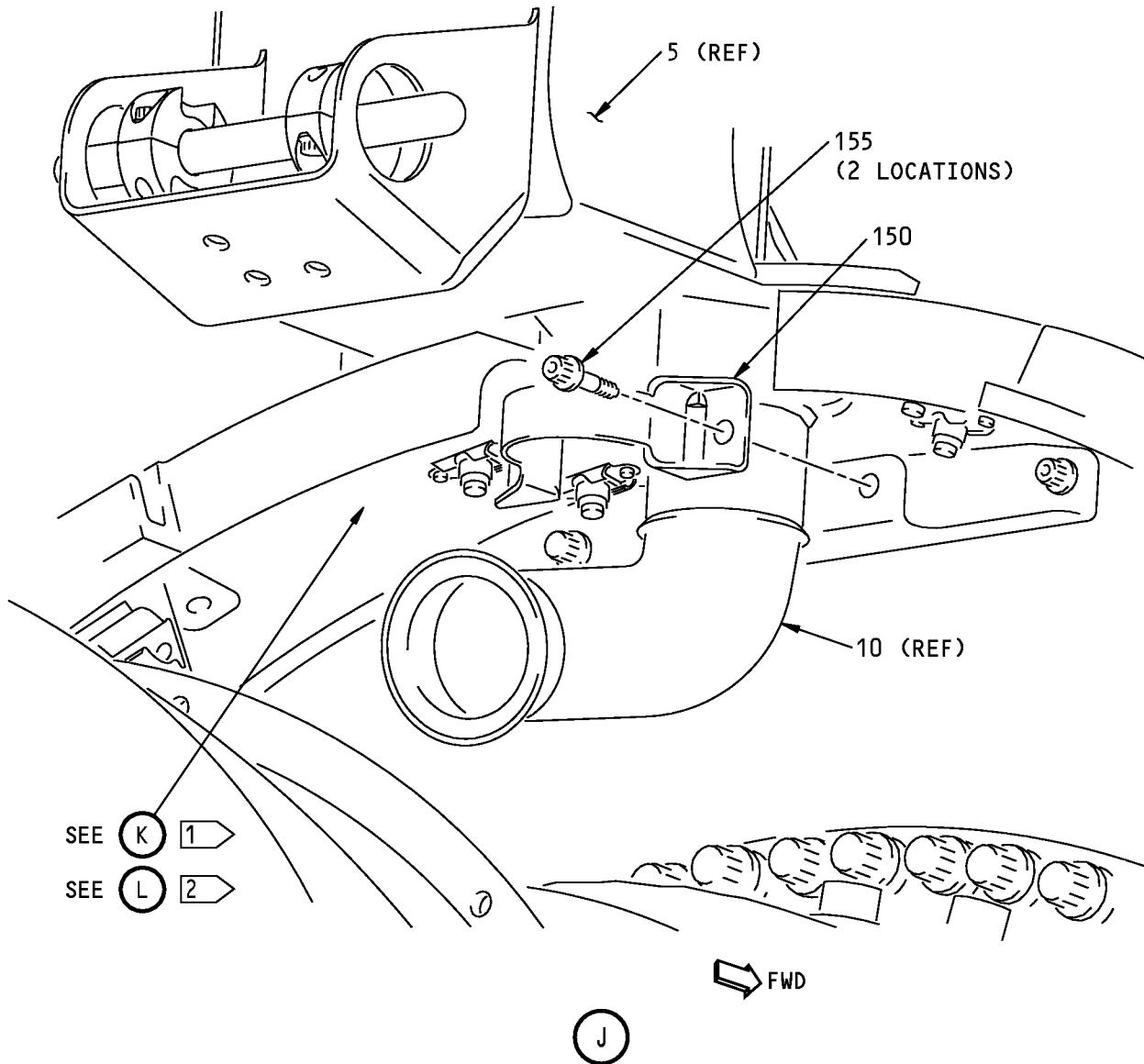
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P/P BUILDUP FIGURE 13-1

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POWERPLANT BUILDUP MANUAL

1 PREFERRED CONFIGURATION

2 OPTIONAL CONFIGURATION

12 O'Clock Strut Installation
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P/P BUILDUP FIGURE 13-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
13-1		12 O'CLOCK STRUT INSTALLATION (FIGURE 13-1, SHEET 9)		
150	9134M25P29	SECURE CTAI DUCT (10) TO ENGINE FAN FRAME WITH RETAINING STRAP (150) AND BOLTS (155).	VEN	1
155	BACB30ZF4-08	<ul style="list-style-type: none"> . RETAINING STRAP (V07482) . BOLT TIGHTEN BOLTS (155) TO 60-70 POUND-INCHES (6.77-7.9 NEWTON METERS).		2

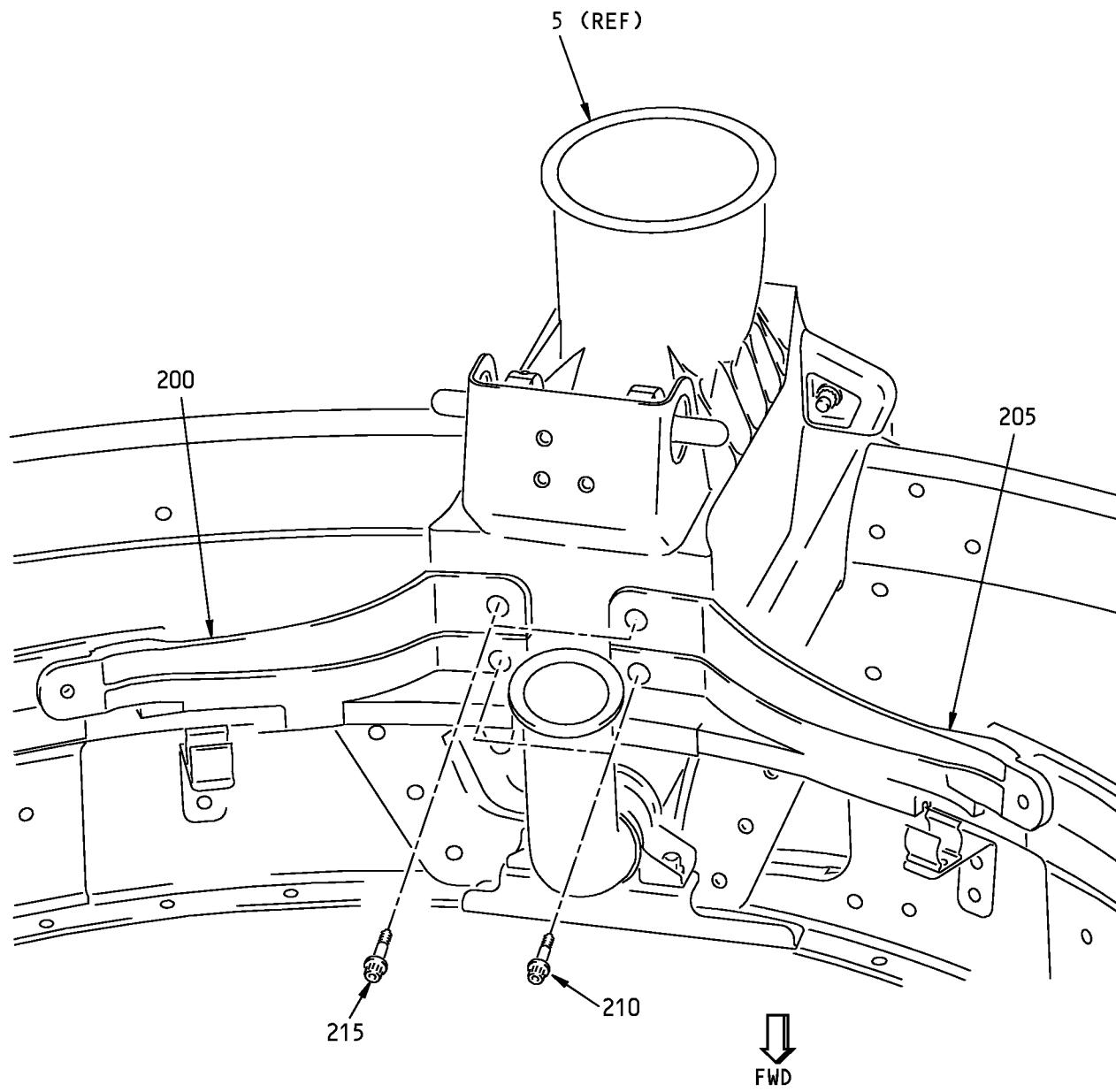
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P/P BUILDUP FIGURE 13-1

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POWERPLANT BUILDUP MANUAL12 O'Clock Strut Installation
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P/P BUILDUP FIGURE 13-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
13-1		<p>12 O'CLOCK STRUT INSTALLATION (FIGURE 13-1, SHEET 10)</p> <p>PREFERRED CONFIGURATION:</p> <p>APPLY Never-Seez NSBT-8N compound, D00006 (C1) TO THREADS AND SHANK OF BOLTS (210) AND (215).</p> <p>LOOSELY ATTACH TRANSITION FITTINGS (200) AND (205) TO BOTTOM OF 12 O'CLOCK STRUT ASSY (5). USE BOLT (210) AT FWD LOCATIONS AND BOLT (215) AT AFT LOCATIONS.</p> <p>. TRANSITION FITTING ASSY, LH . TRANSITION FITTING ASSY, RH . BOLT (FWD LOCATIONS) . BOLT (AFT LOCATIONS) . NEVER-SEEZ NSBT-8N COMPOUND</p> <p>TIGHTEN BOLTS (210) AND (215) TO 68-82 POUND-INCHES (7.7-9.3 NEWTON METERS).</p> <p>NOTE: BOLTS (210) AND (215) WILL BE TIGHTENED AFTER OUTBOARD FASTENERS ARE INSTALLED.</p>		
200	332A2374-13			1
205	332A2374-14			1
210	BACB30LE4K6			2
215	BACB30LE4K4			2
C1	D00006		CON	AR

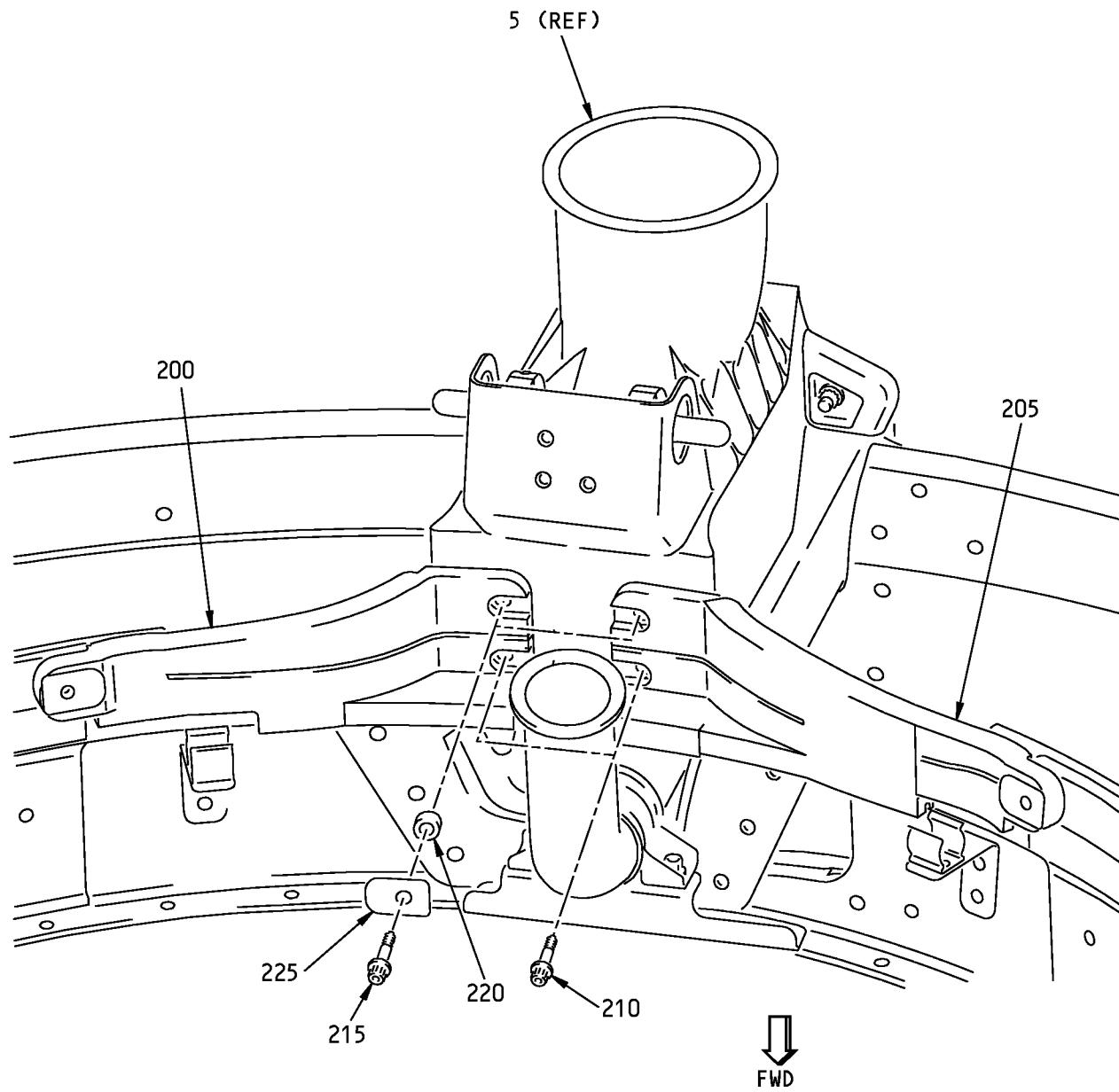
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P/P BUILDUP FIGURE 13-1

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POWERPLANT BUILDUP MANUAL

OPTIONAL CONFIGURATION



12 O'Clock Strut Installation
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P/P BUILDUP FIGURE 13-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
13-1		<p>12 O'CLOCK STRUT INSTALLATION (FIGURE 13-1, SHEET 11)</p> <p><u>OPTIONAL CONFIGURATION:</u></p> <p>LOOSELY ATTACH TRANSITION FITTINGS (200) AND (205) TO BOTTOM OF 12 O'CLOCK STRUT ASSY (5).</p> <p>USE BOLT (210) AT FWD LOCATIONS AND BOLT (215), SPACER (220) AND CLIP (225) AT AFT LOCATIONS.</p> <p>200 332A2374-9 . TRANSITION FITTING ASSY, LH (1 REQD) 205 332A2374-10 . TRANSITION FITTING ASSY, RH (1 REQD) 210 BACB30LE4K6 . BOLT (FWD LOCATIONS) (2 REQD) 215 BACB30LE4K8 . BOLT (AFT LOCATIONS) (2 REQD) 220 NAS1057W4A025 . SPACER (AFT LOCATIONS) (2 REQD) 225 332A2376-1 . CLIP (AFT LOCATIONS) (2 REQD)</p> <p>NOTE: BOLTS (210) AND (215) WILL BE TIGHTENED AFTER OUTBOARD FASTENERS ARE INSTALLED.</p>		

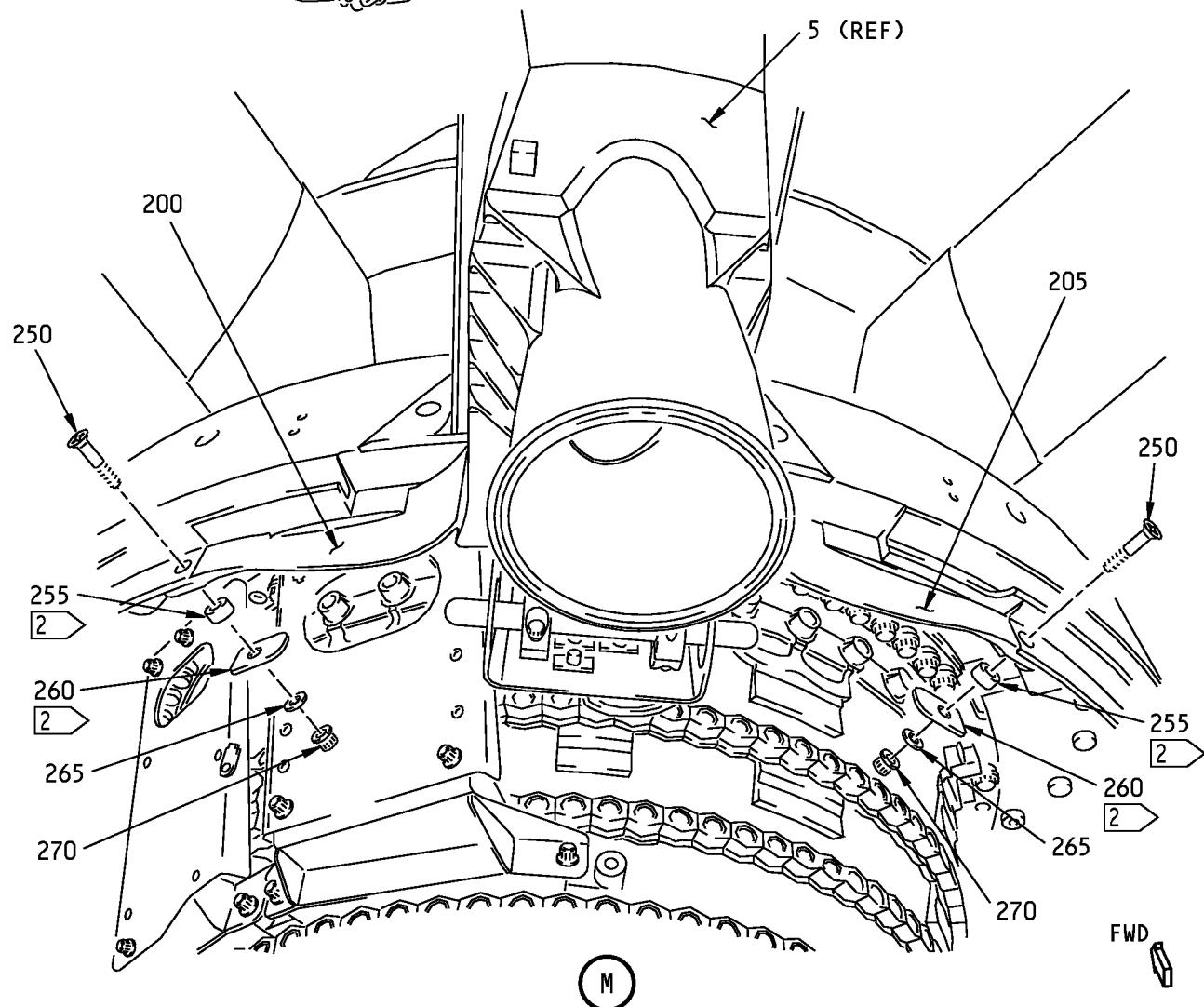
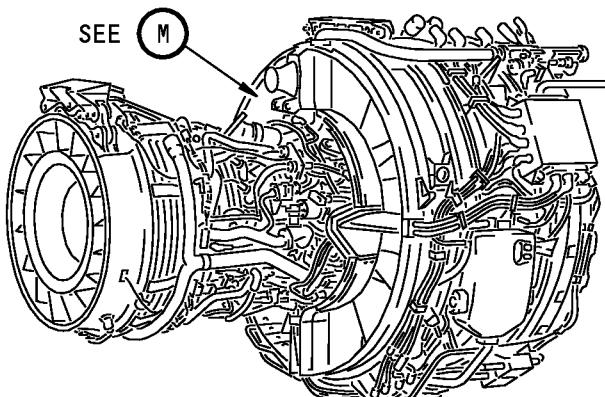
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P/P BUILDUP FIGURE 13-1

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POWERPLANT BUILDUP MANUAL

2 OPTIONAL CONFIGURATION

12 O'Clock Strut Installation
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P/P BUILDUP FIGURE 13-1
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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
13-1		12 O'CLOCK STRUT INSTALLATION (FIGURE 13-1, SHEET 12) SECURE LEFT AND RIGHT TRANSITION FITTINGS (200) AND (205) TO ENGINE EXTENSION RING WITH BOLTS (250), WASHERS (265) AND NUTS (270). USE SPACERS (255) AND CLIPS (260) IF OPTIONAL CONFIGURATION IS INSTALLED. . BOLT ^[4] . BOLT (2 REQD) ^[3] . SPACER (2 REQD) ^[3] . CLIP (2 REQD) ^[3] . WASHER . NUT TIGHTEN BOLTS (210) AND (215) TO 90-110 POUND-INCHES (10.2-12.4 NEWTON METERS). TIGHTEN BOLTS (250) TO 65-100 POUND-INCHES (7.3-11.3 NEWTON METERS). * ^[3] USED WITH OPTIONAL CONFIGURATION 332A2374-9 (LH) AND 332A2374-10 (RH) FITTING ASSEMBLIES (REF VIEW L). * ^[4] USED WITH PREFERRED CONFIGURATION 332A2374-13 (LH) AND 332A2374-14 (RH) FITTING ASSEMBLIES (REF VIEW K).		
250	BACB30NN4K6		OPT	2
250	BACB30NN4K11		OPT	-
255	NAS1057W4A025		OPT	-
260	332A2376-1		OPT	-
265	BACW10BP4PK			2
270	BACN11Z4CK			2

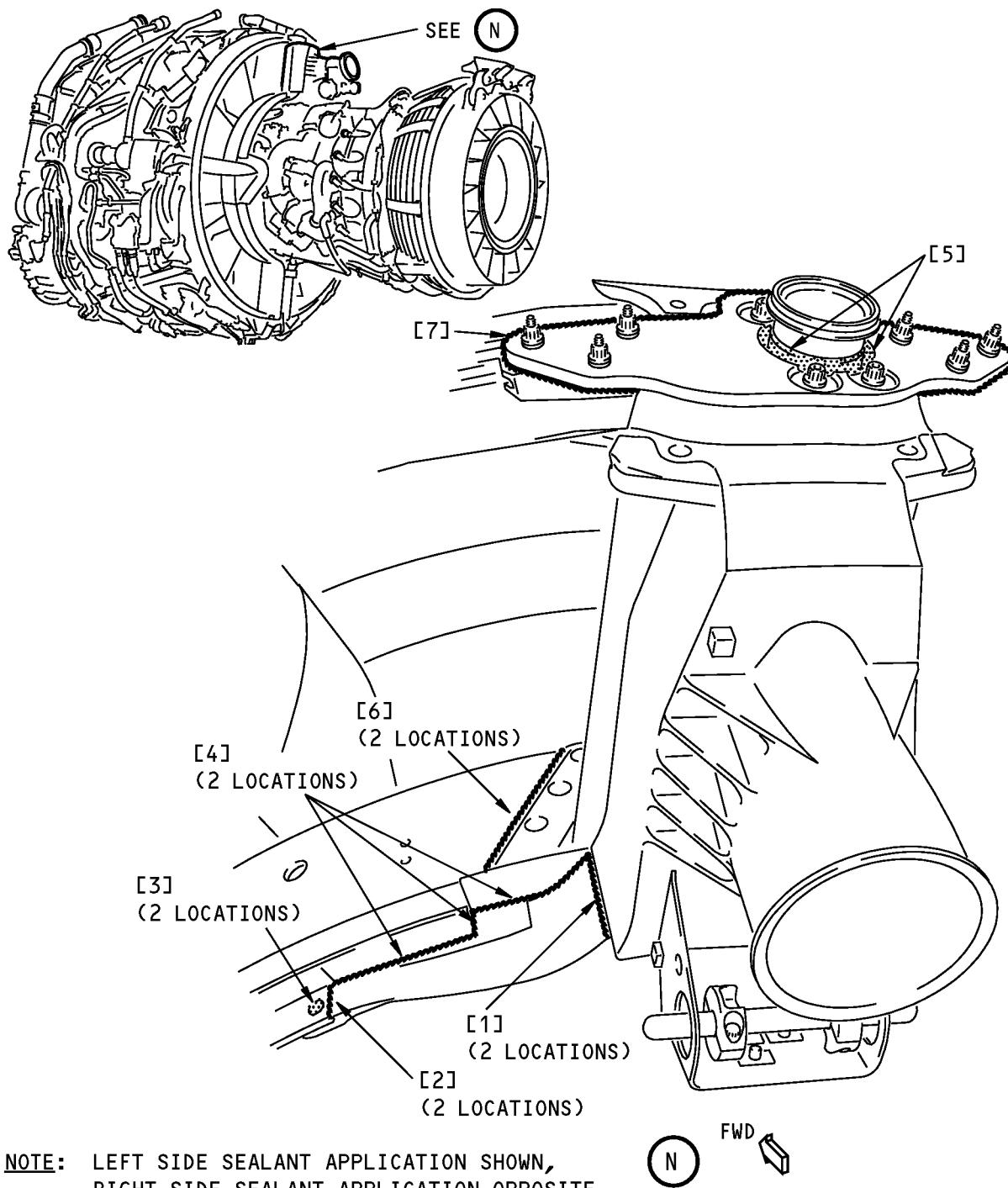
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P/P BUILDUP FIGURE 13-1

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POWERPLANT BUILDUP MANUAL

NOTE: LEFT SIDE SEALANT APPLICATION SHOWN,
RIGHT SIDE SEALANT APPLICATION OPPOSITE.

■ AND —————, AREAS OF SEALANT APPLICATION.

12 O'Clock Strut Installation
Figure 13-1 (Sheet 13)

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P/P BUILDUP FIGURE 13-1
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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
13-1		<p>12 O'CLOCK STRUT INSTALLATION (FIGURE 13-1, SHEET 13)</p> <p>APPLY FILLET SEAL AROUND PARTS OF 12 O'CLOCK STRUT ASSY (5) IDENTIFIED BELOW USING sealant, A00803 (C3) OR sealant, A50096 (C4).</p> <p>MAKE SURE ALL AREAS IDENTIFIED BELOW ARE FLUSH AND/OR SMOOTH WITH SURROUNDING SURFACES.</p> <p>IF sealant, A00803 (C3) IS USED, MAKE SURE ALL FILLET SURFACES HAVE BEEN PRIMED USING Dapco No. 1-100 primer, C00944 (C2) BEFORE SEALANT APPLICATION.</p> <ol style="list-style-type: none"> 1. TRANSITION FITTINGS AND 12 O'CLOCK STRUT. 2. TRANSITION FITTINGS AND ENGINE EXTENSION RING. 3. BOLT (200) CAVITY AND ENGINE EXTENSION RING. 4. FWD EDGE OF TRANSITION FITTINGS AND ENGINE EXTENSION RING. 5. 12 O'CLOCK STRUT AND CTAI DUCT. 6. 12 O'CLOCK STRUT LOWER FLANGE AND ENGINE EXTENSION RING. 7. 12 O'CLOCK STRUT AND ENGINE OUTER FAN CASE. 		
C2	C00944	. DAPCO NO. 1-100 PRIMER	CON	AR
C3	A00803	. SEALANT	CON	AR
C4	A50096	. SEALANT	CON	AR

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P/P BUILDUP FIGURE 13-1

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FIGURE 14-1

BLEED CONTROLLER INSTALLATION

REF QEC TASK NO.: 14

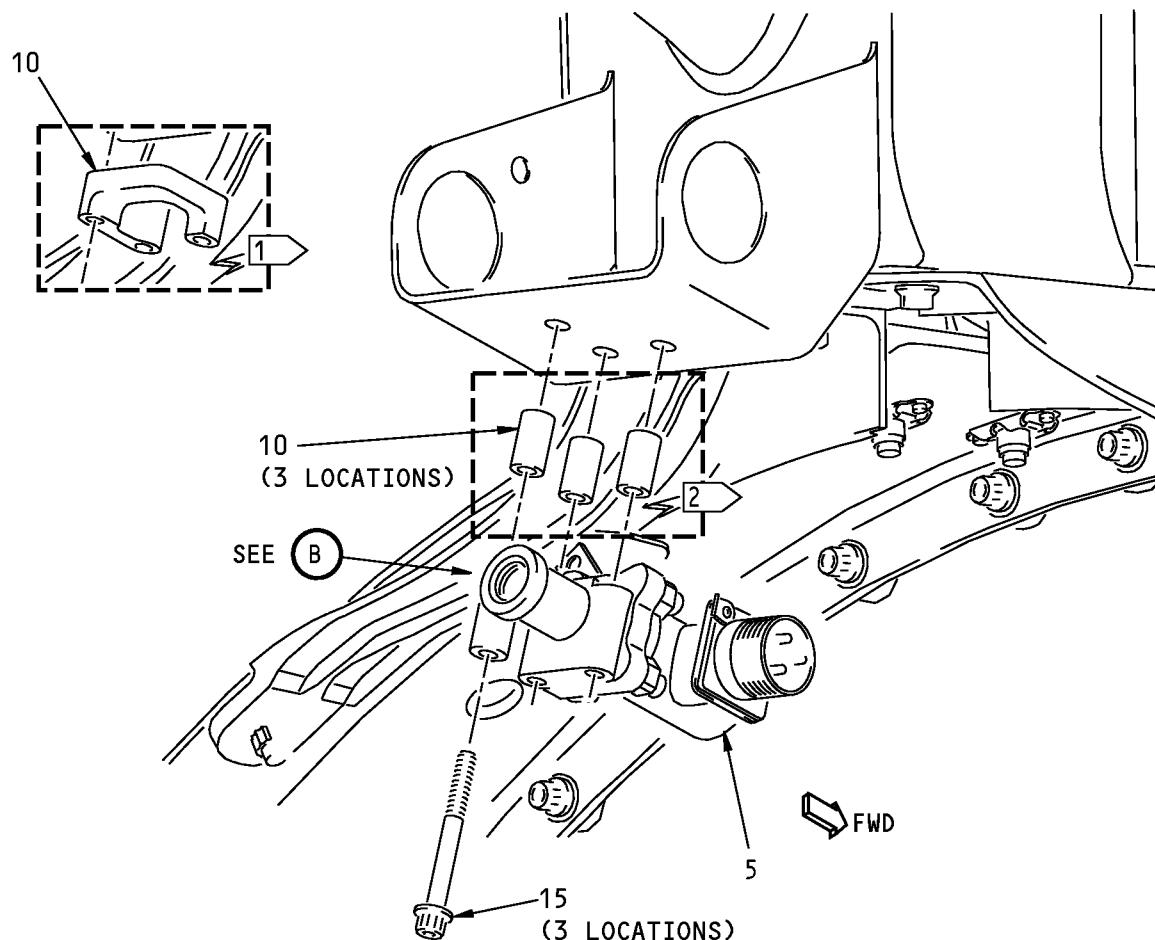
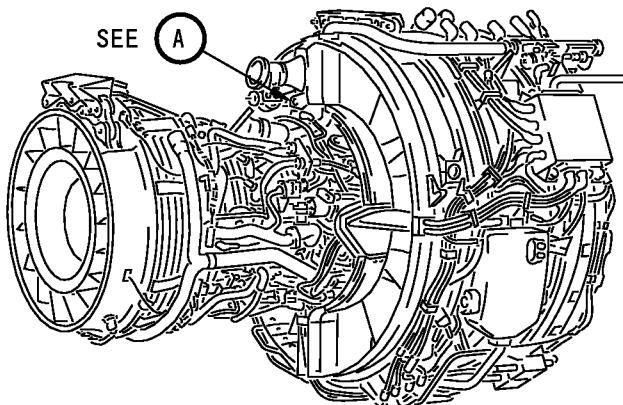
**REF DWG: 332A2300
332A2100**

NOTE: ALL STANDARDS AND ATTACHING HARDWARE FOR THIS FIGURE WILL BE PACKAGED
IN QEC TASK NO. 110.

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P/P BUILDUP FIGURE 14-1
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1 ◻ OPTIONAL CONFIGURATION

2 ◻ PREFERRED CONFIGURATION

A

Bleed Controller Installation
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P/P BUILDUP FIGURE 14-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
14-1		BLEED CONTROLLER INSTALLATION (FIGURE 14-1, SHEET 1) ROTATE BONDING TAB ON VALVE (5) TO GIVE A MINIMUM OF 0.25 INCH (6.4 MM) OF CLEARANCE WITH STRUCTURE. CLEAN MATING SURFACES OF VALVE (5), SPACERS (10) OR SPACER BLOCK (10) AND ENGINE BRACKET WITH alcohol, B00130 (C1). MAKE SURE YOU REMOVE ALL GREASE AND OTHER CONTAMINANTS.		
5	320548-2	. VALVE, GROUND WING TAI TEMP SOLENOID (V59364) (SPEC 10-62008-22)	VEN	1
10	NAS1057T3-050	. SPACER	OPT	3
10	332A2930-49	. SPACER BLOCK (1 REQD)	CON	-
C1	B00130	. ALCOHOL	AR	
		INSTALL VALVE (5) ON BOTTOM BRACKET ON 12 O'CLOCK STRUT SUCH THAT ELECTRICAL CONNECTOR IS ON RIGHT SIDE.		
		INSTALL WITH SPACERS (10) OR SPACER BLOCK (10) AND BOLTS (15).		
15	BACB30ZF3-28	. BOLT TIGHTEN BOLTS (15) TO 50-56 POUND-INCHES (5.6-6.3 NEWTON METERS).		3

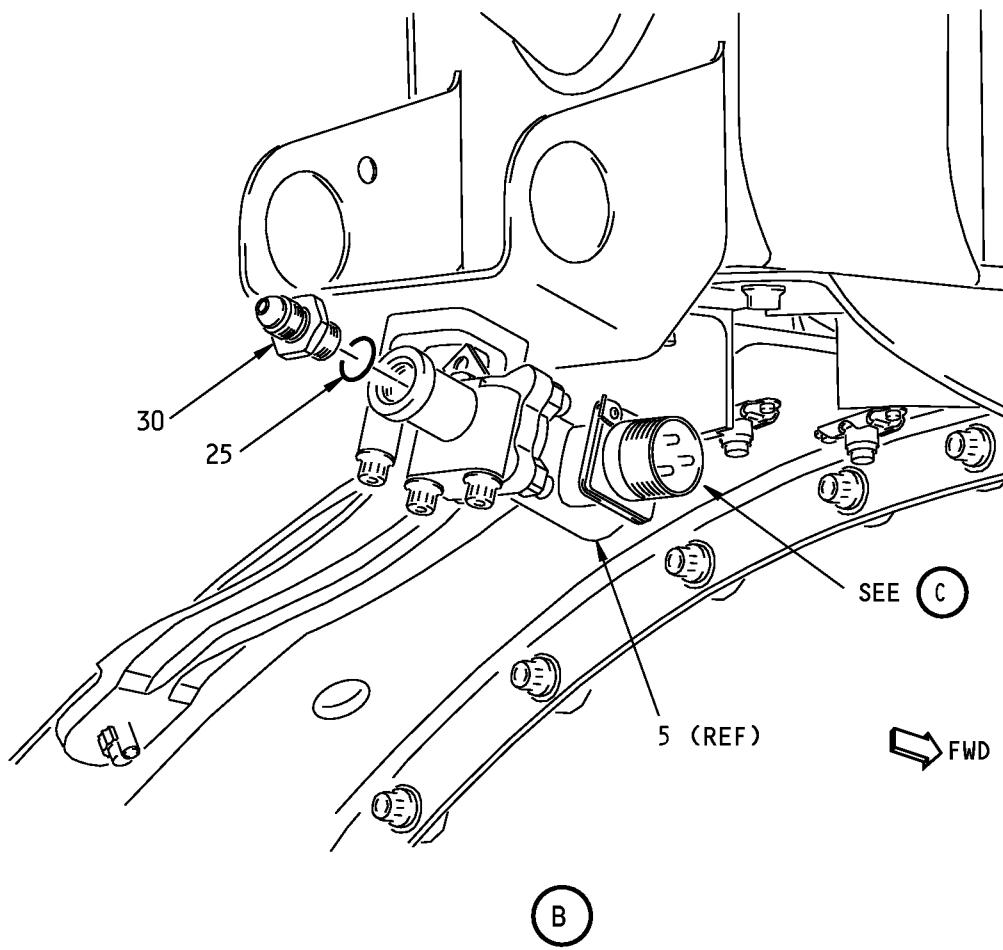
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P/P BUILDUP FIGURE 14-1

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POWERPLANT BUILDUP MANUALBleed Controller Installation
Figure 14-1 (Sheet 2)

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P/P BUILDUP FIGURE 14-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
14-1		BLEED CONTROLLER INSTALLATION (FIGURE 14-1, SHEET 2) INSTALL O-RING (25) ON UNION (30). LUBRICATE THREADS OF UNION (30) WITH Never-Seez NSBT-8N compound, D00006 (C2) AND INSTALL UNION (30) ON VALVE (5). . O-RING (V15284) . O-RING (V15284) (OPTIONAL TO 801A50-0004-A) . UNION (V07482) . NEVER-SEEZ NSBT-8N COMPOUND TIGHTEN UNION (30) TO 133-147 POUND-INCHES (15-17 NEWTON METERS).		
25	801A50-0004-A		VEN	1
25	801A50-0004A		OPT	-
30	J1238P54		VEN	1
C2	D00006		CON	AR

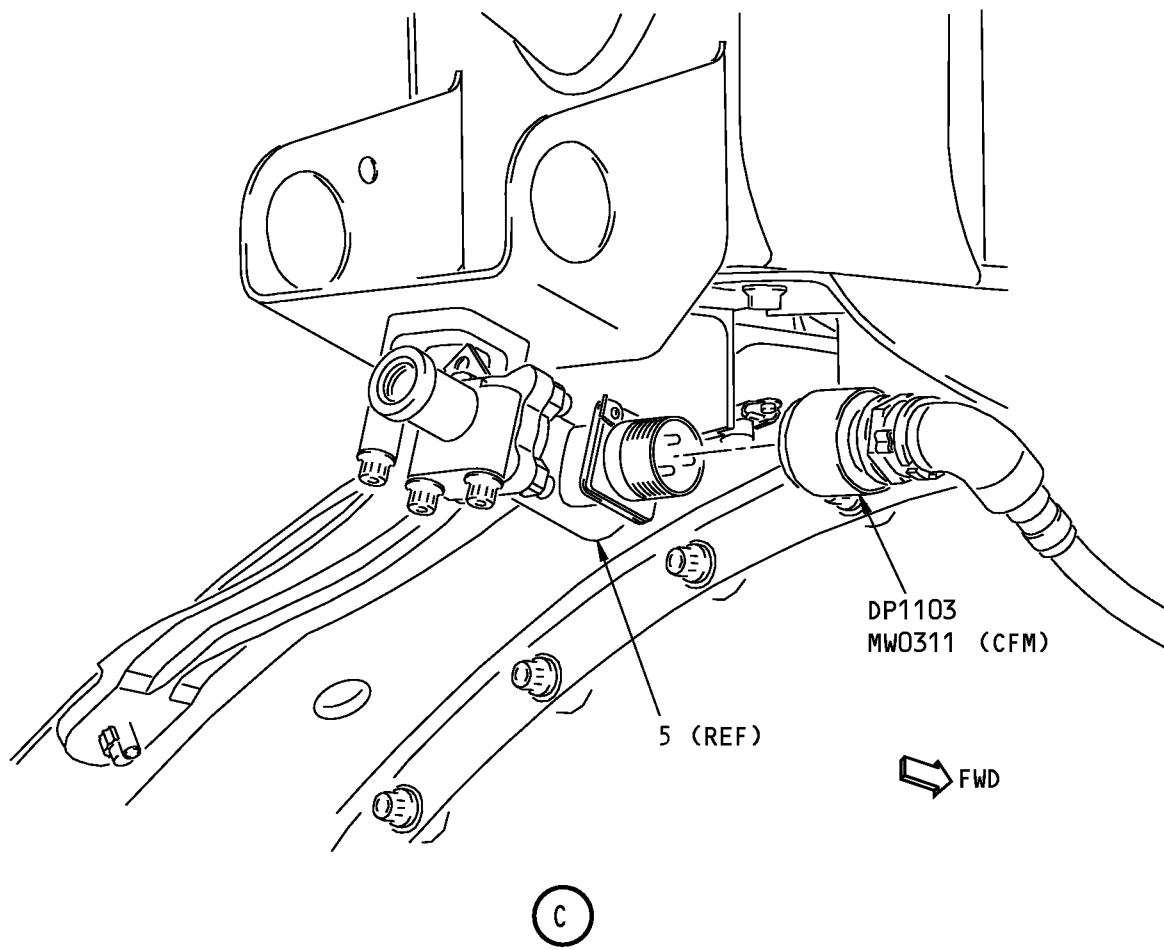
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P/P BUILDUP FIGURE 14-1

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POWERPLANT BUILDUP MANUAL

Bleed Controller Installation
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P/P BUILDUP FIGURE 14-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
14-1		<p>BLEED CONTROLLER INSTALLATION (FIGURE 14-1, SHEET 3)</p> <p>CAUTION: DO NOT OVERTIGHTEN THE PLUG COUPLING RING. DO NOT USE WATER PUMP PLIERS, PIPE WRENCHES OR VISE GRIPS TO TIGHTEN THE COUPLING RING OR DAMAGE TO THE ELECTRICAL CONNECTOR CAN OCCUR.</p> <p>CONNECT MW0311 ELECTRICAL CONNECTOR, DP1103, TO RECEPTACLE ON GROUND WING TAI TEMP SOLENOID VALVE (5).</p> <p>TURN KNULED COUPLING RING WHILE WIGGLING THE BACKSHELL ASSEMBLY.</p> <p>AFTER FULLY SEATING THE COUPLING RING, USE SOFT-JAWED PLIERS OR A STRAP WRENCH TO TIGHTEN THE COUPLING RING AN ADDITIONAL 1/8-TURN OR UNTIL PLIER SLIPPAGE OCCURS.</p>		

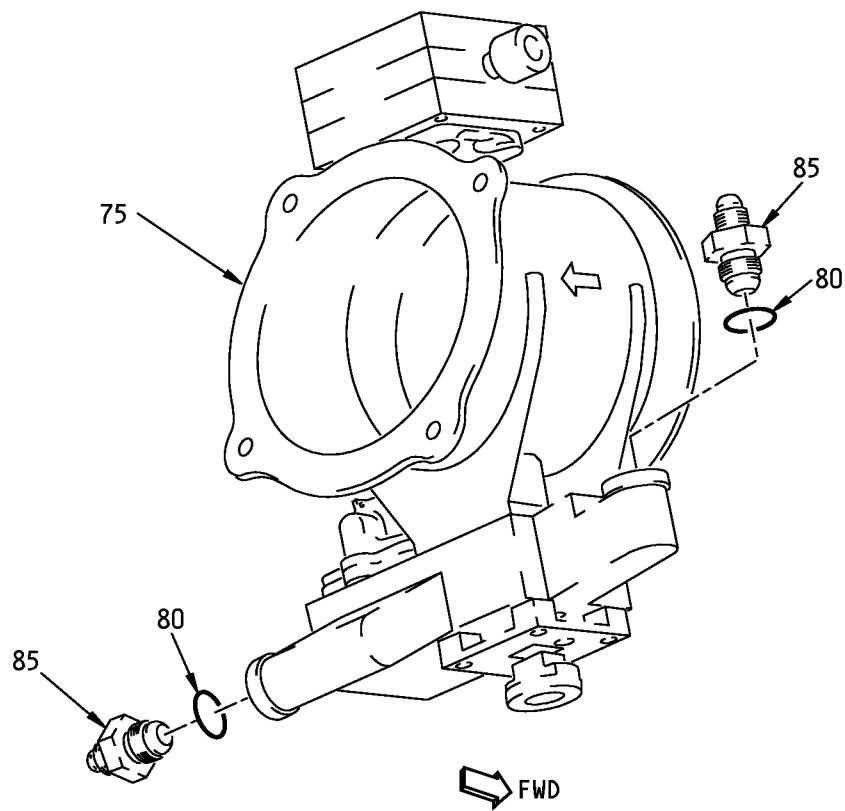
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P/P BUILDUP FIGURE 14-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
14-1		BLEED CONTROLLER INSTALLATION (FIGURE 14-1, SHEET 4) INSTALL ONE O-RING (80) ON EACH REDUCER (85). LUBRICATE THREADS OF REDUCERS WITH Never-Seez NSBT-8N compound, D00006 (C2) AND INSTALL ON PRECOOLER CONTROL VALVE (75).		
75	3289562-5	. PRECOOLER CONTROL VALVE (V59364) (SPEC 10-62008-33)	VEN	1
75	3289562-7	. PRECOOLER CONTROL VALVE (V59364) (SPEC 10-62008-47) (REPLACED BY 3289562-5)	LTD	-
80	801A50-0006-A	. O-RING (V15284)	VEN	2
80	801A50-0006A	. O-RING (V15284) (OPTIONAL TO 801A50-0006-A)	OPT	-
85	J522P53	. REDUCER (V90806)	VEN	2
C2	D00006	. NEVER-SEEZ NSBT-8N COMPOUND	CON	AR
		TIGHTEN REDUCERS (85) TO 258-284 POUND-INCHES (29-32 NEWTON METERS).		
		INSTALL PROTECTIVE CAPS ON ENDS OF UNION (30) AND REDUCER (85).		

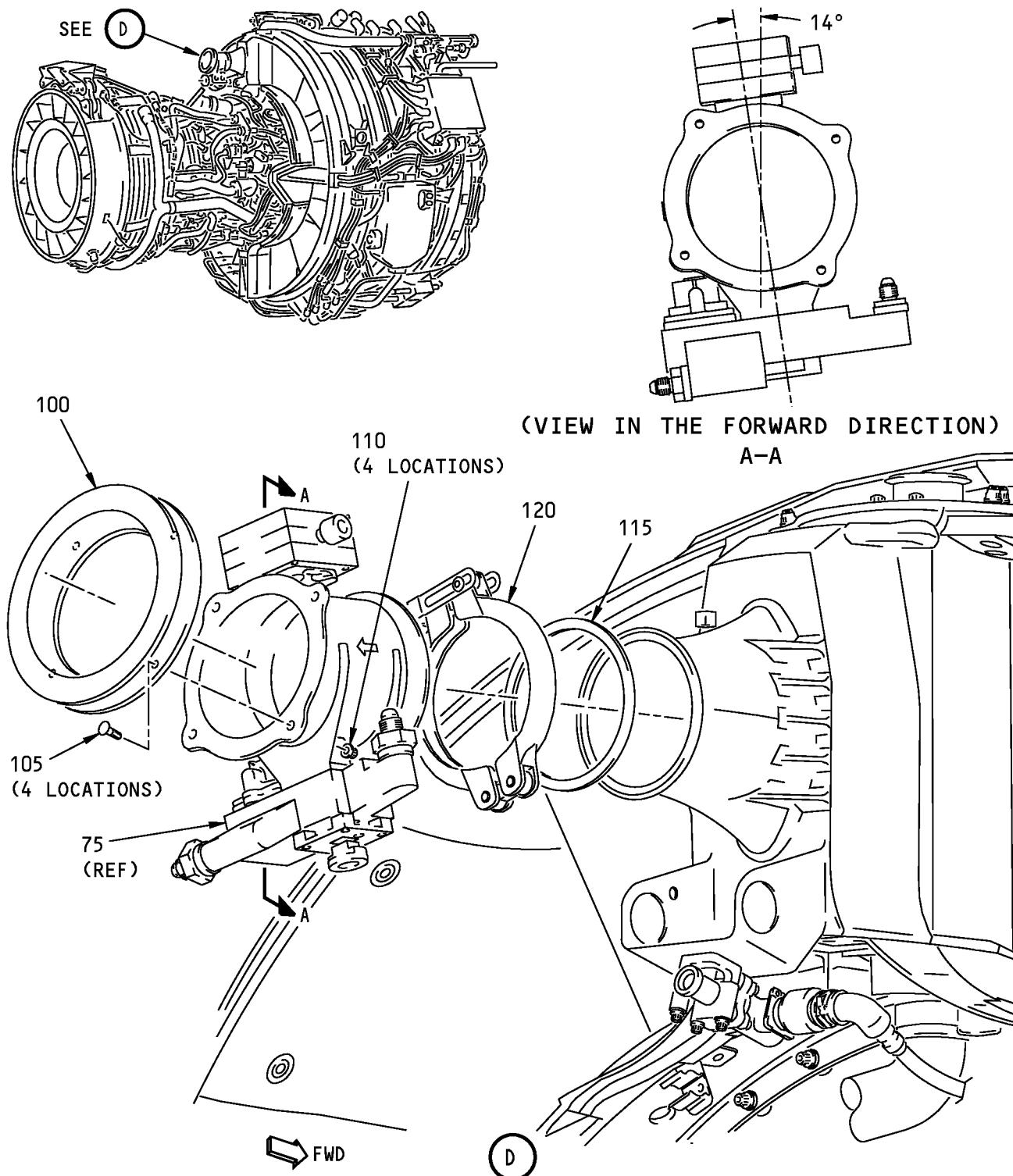
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P/P BUILDUP FIGURE 14-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
14-1		BLEED CONTROLLER INSTALLATION (FIGURE 14-1, SHEET 5) INSTALL SEAL (100) ON PRECOOLER CONTROL VALVE (75) WITH BOLTS (105) AND NUTS (110). 100 82C10020-2 . SEAL (V60980) 105 BACB30LH3U4 . BOLT 110 AS3485-09 . NUT TIGHTEN BOLTS (105) UNTIL 1 1/2 TO 2 THREADS EXTEND OUT FROM NUTS (110). NOTE: REQUIRED TORQUE RANGE IS 25-35 POUND-INCHES (2.8-3.9 NEWTON METERS) FOR SEAL 82C10020-2. INSTALL A PROTECTIVE COVER OVER THE SEAL OPENING. POSITION SEAL (115) AND VALVE (75) ON 12 O'CLOCK STRUT FLANGE WITH VALVE ORIENTED AS SHOWN. LOOSELY CONNECT WITH COUPLING (120). MAKE SURE COUPLING IS POSITIONED AS SHOWN. LOOSELY TIGHTEN COUPLING BOLT. NOTE: COUPLING ORIENTATION ALLOWS ADEQUATE TOOL ACCESS TO COUPLING NUT WHEN VALVE IS REPLACED WITH T/R INSTALLED. NOTE: DO NOT TIGHTEN COUPLING AT THIS TIME. FINAL ORIENTATION OF VALVE WILL OCCUR DURING UPPER BLEED CONTROL INSTALLATION (REF BLEED CONTROL SYSTEM INSTALLATION - UPPER/Figure 17-1).	VEN	1 4 4
115	AS1895-7-400	. SEAL		1
115	AS1895/7-400	. SEAL (OPTIONAL TO AS1895-7-400)	OPT	-
120	AS1895-4-400	. COUPLING		1
120	AS1895/4-400	. SEAL (OPTIONAL TO AS1895-4-400)	OPT	-

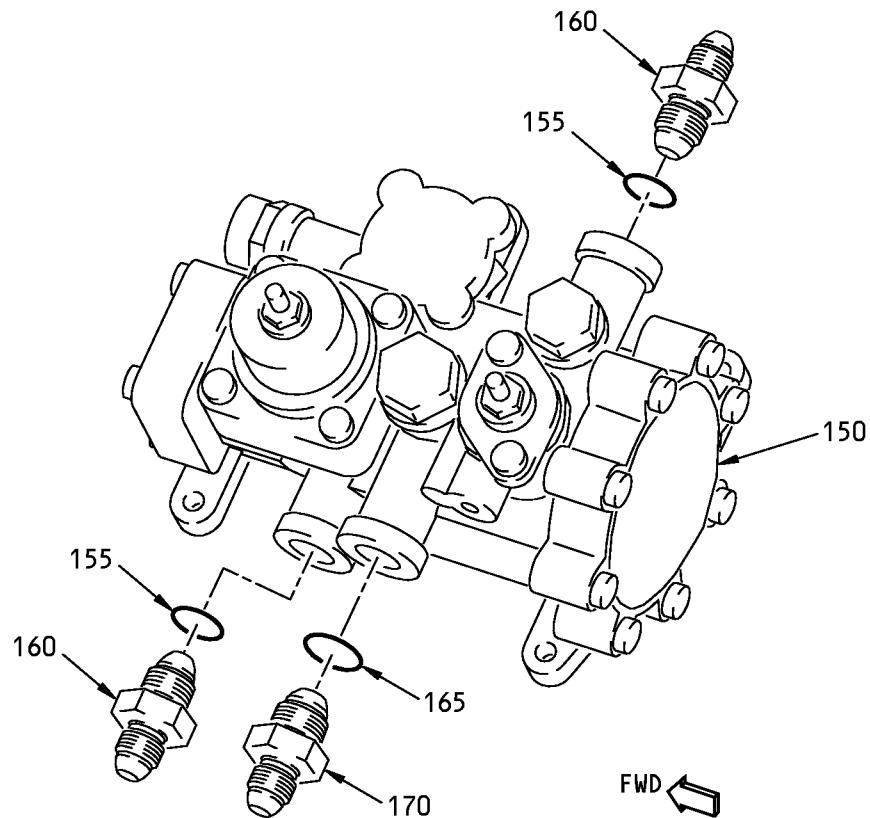
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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
14-1		BLEED CONTROLLER INSTALLATION (FIGURE 14-1, SHEET 6) INSTALL ONE O-RING (155) ON EACH REDUCER (160) AND INSTALL O-RING (165) ON REDUCER (170). LUBRICATE THREADS OF REDUCERS WITH Never-Seez NSBT-8N compound, D00006 (C2) AND INSTALL ON HIGH STAGE REGULATOR (150) AS SHOWN. . HIGH STAGE REGULATOR (V59364) . O-RING (V15284) . O-RING (V15284) (OPTIONAL TO 801A50-0005-A) . REDUCER (V96941) . O-RING (V15284) . O-RING (V15284) (OPTIONAL TO 801A50-0006-A) . REDUCER (V90806) . NEVER-SEEZ NSBT-8N COMPOUND TIGHTEN REDUCERS (160) TO 180-200 POUND-INCHES (20-22 NEWTON METERS) AND TIGHTEN REDUCER (170) TO 258-284 POUND-INCHES (29-32 NEWTON METERS).		
150	107484-7	. HIGH STAGE REGULATOR (V59364)	VEN	1
155	801A50-0005-A	. O-RING (V15284)	VEN	2
155	801A50-0005A	. O-RING (V15284) (OPTIONAL TO 801A50-0005-A)	OPT	-
160	J522P52	. REDUCER (V96941)	VEN	2
165	801A50-0006-A	. O-RING (V15284)	VEN	1
165	801A50-0006A	. O-RING (V15284) (OPTIONAL TO 801A50-0006-A)	OPT	-
170	J522P53	. REDUCER (V90806)	VEN	1
C2	D00006	. NEVER-SEEZ NSBT-8N COMPOUND	CON	AR

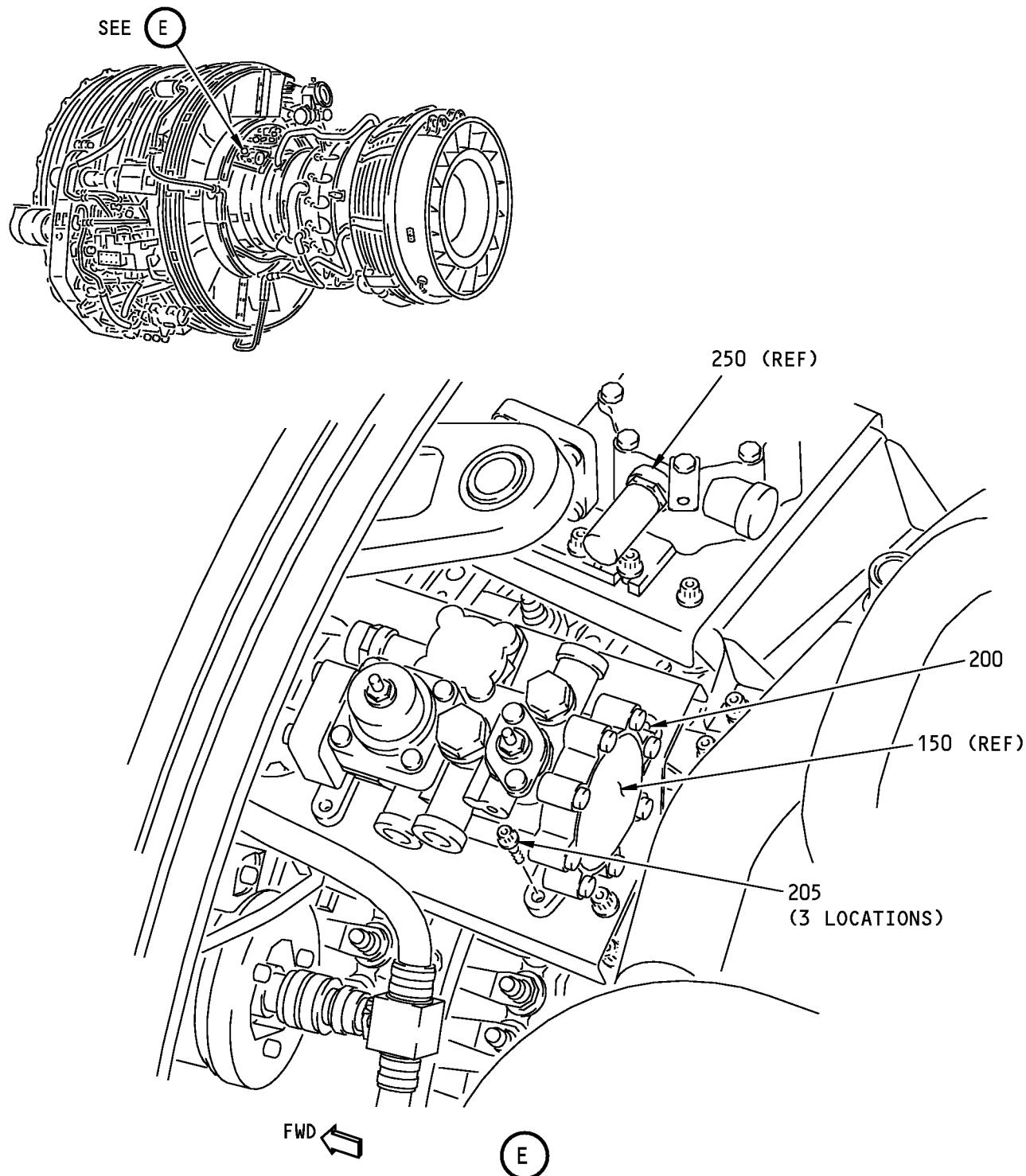
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P/P BUILDUP FIGURE 14-1

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P/P BUILDUP FIGURE 14-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
14-1		BLEED CONTROLLER INSTALLATION (FIGURE 14-1, SHEET 7)		
200	BACB30ZF3-10	ATTACH HIGH STAGE REGULATOR (150) TO ENGINE CORE BRACKET.		1
205	BACB30ZF3-09	USE BOLT (200) AT UPPER AFT LOCATION AND BOLTS (205) AT REMAINING LOCATIONS. . BOLT . BOLT TIGHTEN BOLTS (200) AND (205) TO 34-36 POUND-INCHES (3.8-4.1 NEWTON METERS).		3

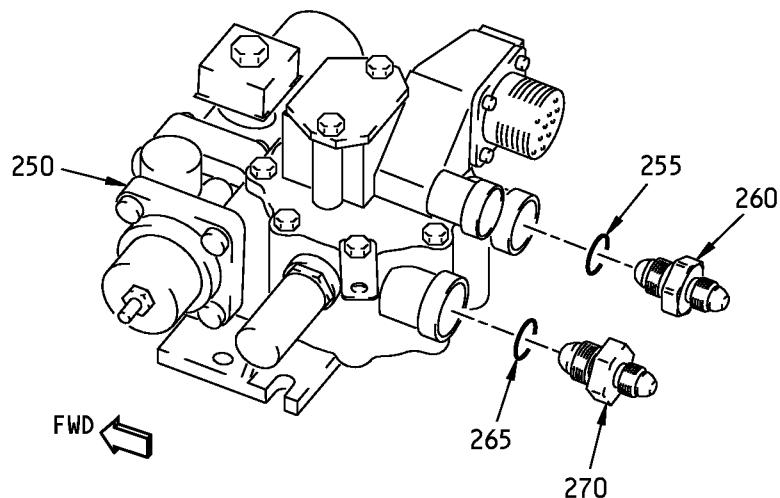
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P/P BUILDUP FIGURE 14-1

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P/P BUILDUP FIGURE 14-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
14-1		BLEED CONTROLLER INSTALLATION (FIGURE 14-1, SHEET 8) INSTALL O-RING (255) ON REDUCER (260) AND INSTALL O-RING (265) ON REDUCER (270). APPLY Never-Seez NSBT-8N compound, D00006 (C2) TO THREADS OF REDUCERS. INSTALL REDUCER (260) IN TOP PORT OF REGULATOR AND INSTALL REDUCER (270) IN BOTTOM PORT OF REGULATOR (250).		
250	107492-6	. BLEED AIR REGULATOR (V59364) (SPEC 10-62008-41)	VEN	1
255	801A50-0005-A	. O-RING (V15284)	VEN	1
255	801A50-0005A	. O-RING (V15284) (OPTIONAL TO 801A50-0005-A)	OPT	-
260	J522P52	. REDUCER (V96941)	VEN	1
265	801A50-0006-A	. O-RING (V15284)	VEN	1
265	801A50-0006A	. O-RING (V15284) (OPTIONAL TO 801A50-0006-A)	OPT	-
270	J522P53	. REDUCER (V90806)	VEN	1
C2	D00006	. NEVER-SEEZ NSBT-8N COMPOUND	CON	AR
		TIGHTEN REDUCER (260) TO 180-200 POUND-INCHES (20-22 NEWTON METERS). TIGHTEN REDUCER (270) TO 258-284 POUND-INCHES (29-32 NEWTON METERS). INSTALL PROTECTIVE CAPS ON ENDS OF REDUCERS (260) AND (270).		

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P/P BUILDUP FIGURE 14-1

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THIS SHEET NOT USED

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Bleed Controller Installation
Figure 14-1 (Sheet 9)

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P/P BUILDUP FIGURE 14-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
14-1		BLEED CONTROLLER INSTALLATION (FIGURE 14-1, SHEET 9) THIS SHEET NOT USED		

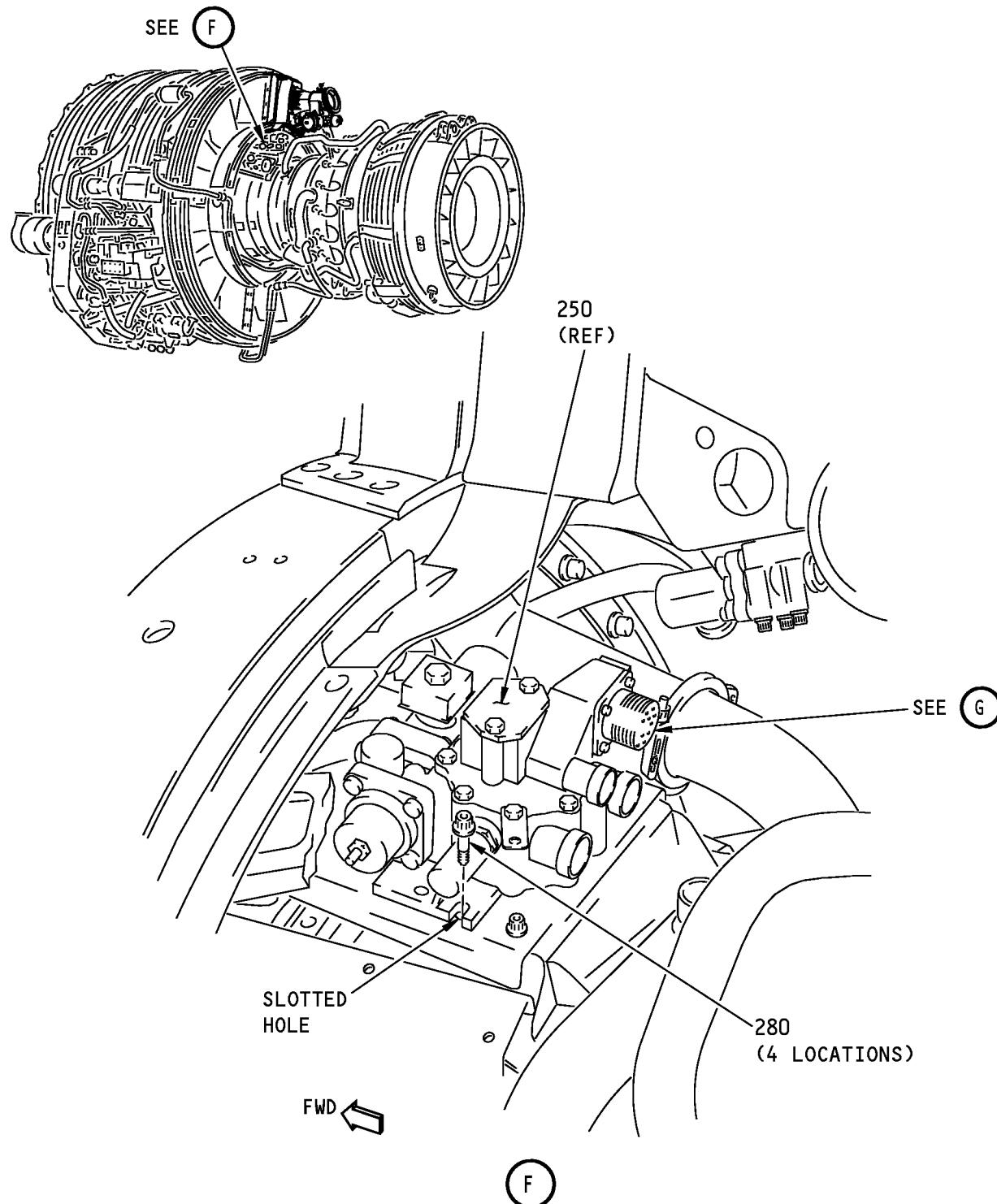
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P/P BUILDUP FIGURE 14-1

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Figure 14-1 (Sheet 10)

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
14-1 280	BACB30ZF4-08	<p>BLEED CONTROLLER INSTALLATION (FIGURE 14-1, SHEET 10)</p> <p>INSTALL ONE BOLT (280) IN AFT OUTBOARD HOLE OF UPPER CORE BRACKET.</p> <p>PUT SLOTTED HOLE OF BLEED AIR REGULATOR OVER BOLT AND INSTALL REMAINING BOLTS (280).</p> <p>. BOLT</p> <p>TIGHTEN BOLTS (280) TO 78-82 POUND-INCHES (8.8-9.3 NEWTON METERS).</p>		4

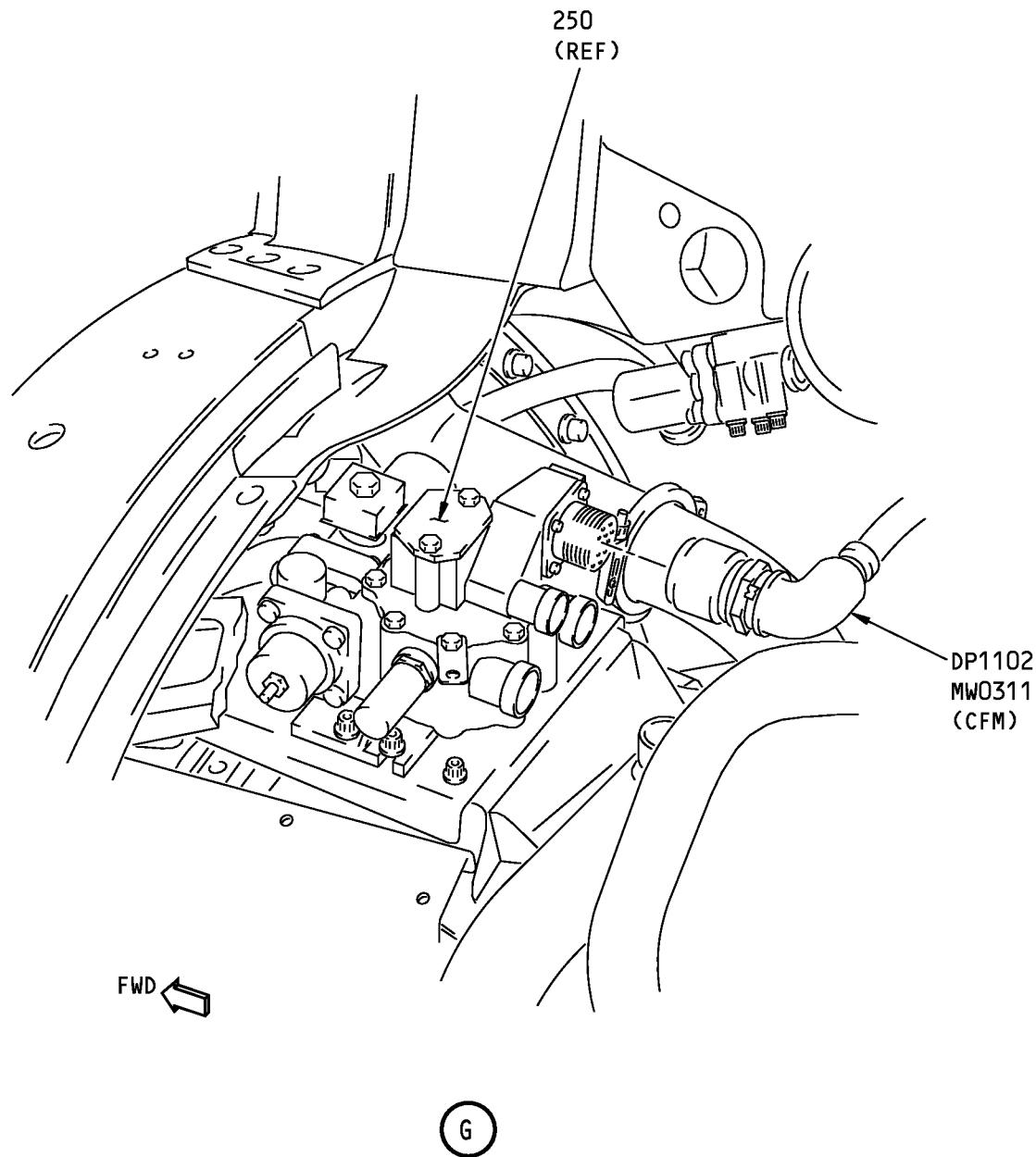
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P/P BUILDUP FIGURE 14-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
14-1		<p>BLEED CONTROLLER INSTALLATION (FIGURE 14-1, SHEET 11)</p> <p>CAUTION: DO NOT OVERTIGHTEN THE PLUG COUPLING RING. DO NOT USE WATER PUMP PLIERS, PIPE WRENCHES OR VISE GRIPS TO TIGHTEN THE COUPLING RING OR DAMAGE TO THE ELECTRICAL CONNECTOR CAN OCCUR.</p> <p>CONNECT MW0311 ELECTRICAL CONNECTOR, DP1102, TO RECEPTACLE ON BLEED AIR REGULATOR.</p> <p>TURN KNULED COUPLING RING WHILE WIGGLING THE BACKSHELL ASSEMBLY.</p> <p>AFTER FULLY SEATING THE COUPLING RING, USE SOFT-JAWED PLIERS OR A STRAP WRENCH TO TIGHTEN THE COUPLING RING AN ADDITIONAL 1/8-TURN OR UNTIL PLIER SLIPPAGE OCCURS.</p>		

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P/P BUILDUP FIGURE 14-1

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FIGURE 15-1

**BLEED CONTROL SYSTEM INSTALLATION -
LOWER**

REF QEC TASK NO.: 15

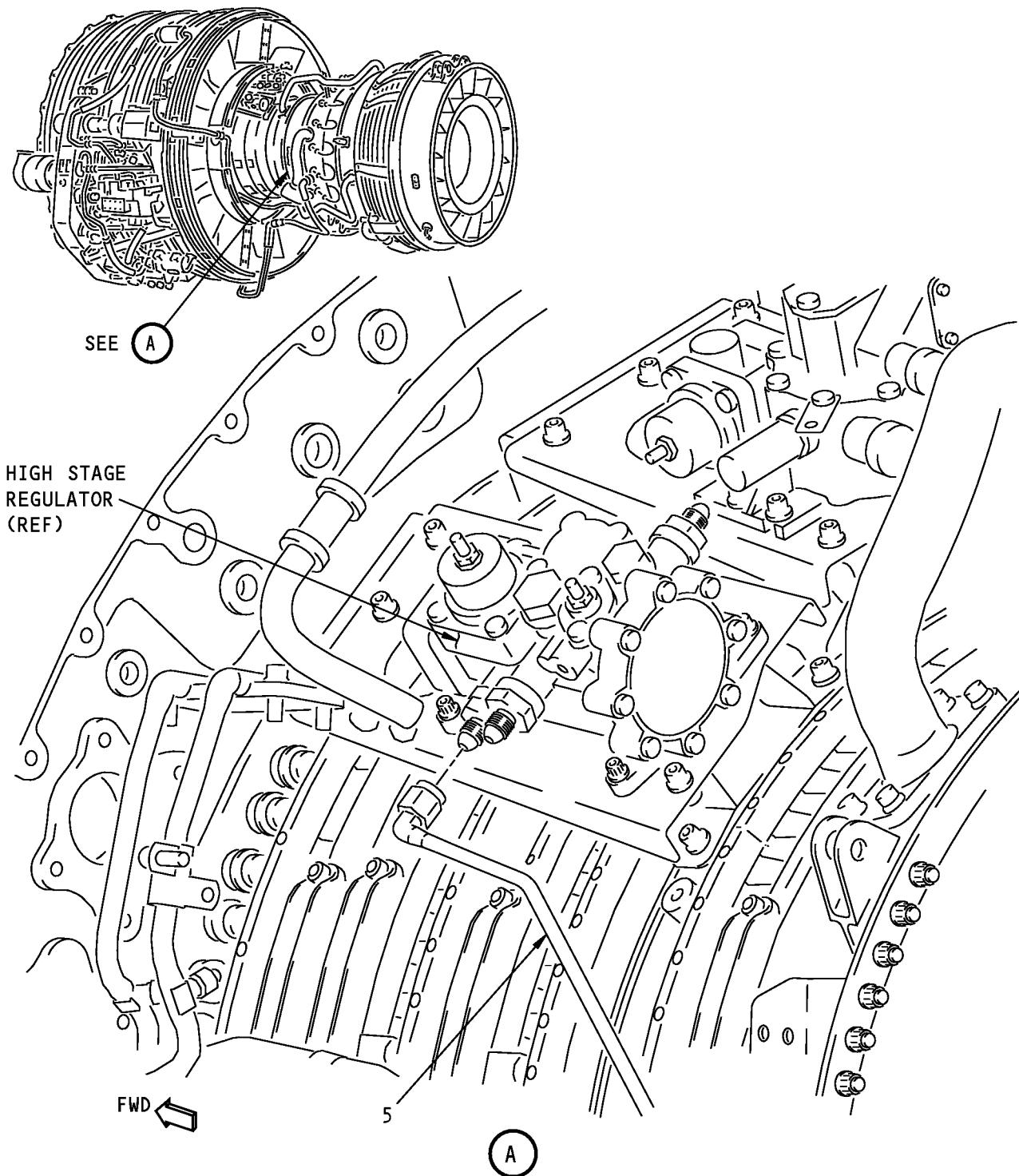
REF DWG: 332A2100

NOTE: ALL STANDARDS AND ATTACHING HARDWARE FOR THIS FIGURE WILL BE PACKAGED
IN QEC TASK NO. 110.

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P/P BUILDUP FIGURE 15-1
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Lower Bleed Control System Installation
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P/P BUILDUP FIGURE 15-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
15-1		LOWER BLEED CONTROL SYSTEM INSTALLATION (FIGURE 15-1, SHEET 1) <p>NOTE: IN THIS PROCEDURE, DO NOT TIGHTEN SCREWS AND TUBE OR HOSE NUTS TO THE INDICATED TORQUE UNTIL INSTRUCTED.</p> <p>WHEN TIGHTENING TUBE AND HOSE NUTS, USE TWO WRENCHES; ONE TO HOLD THE SPANNER FLATS ON THE NIPPLE AND ONE TO TIGHTEN THE NUT.</p> <p>ALL TUBE NUTS HAVE A DRY-FILM LUBRICANT AND DO NOT NEED ADDITIONAL LUBRICATION.</p> <p>TO REDUCE CLAMP DISTORTION UPON INSTALLATION, APPLY Never-Seez NSBT-8N compound, D00006 (C1) TO BOLT HEAD SURFACE THAT COMES INTO CONTACT WITH THE CLAMP. APPLY TO BOLT HEAD UNDERSIDE ONLY. DO NOT APPLY TO BOLT THREADS.</p>		
C1	D00006	. NEVER-SEEZ NSBT-8N COMPOUND LOOSELY ATTACH TUBE (5) TO UNION ON FWD PORT OF HIGH STAGE REGULATOR.	CON	AR
5	332A2350-9	. TUBE ASSY		1

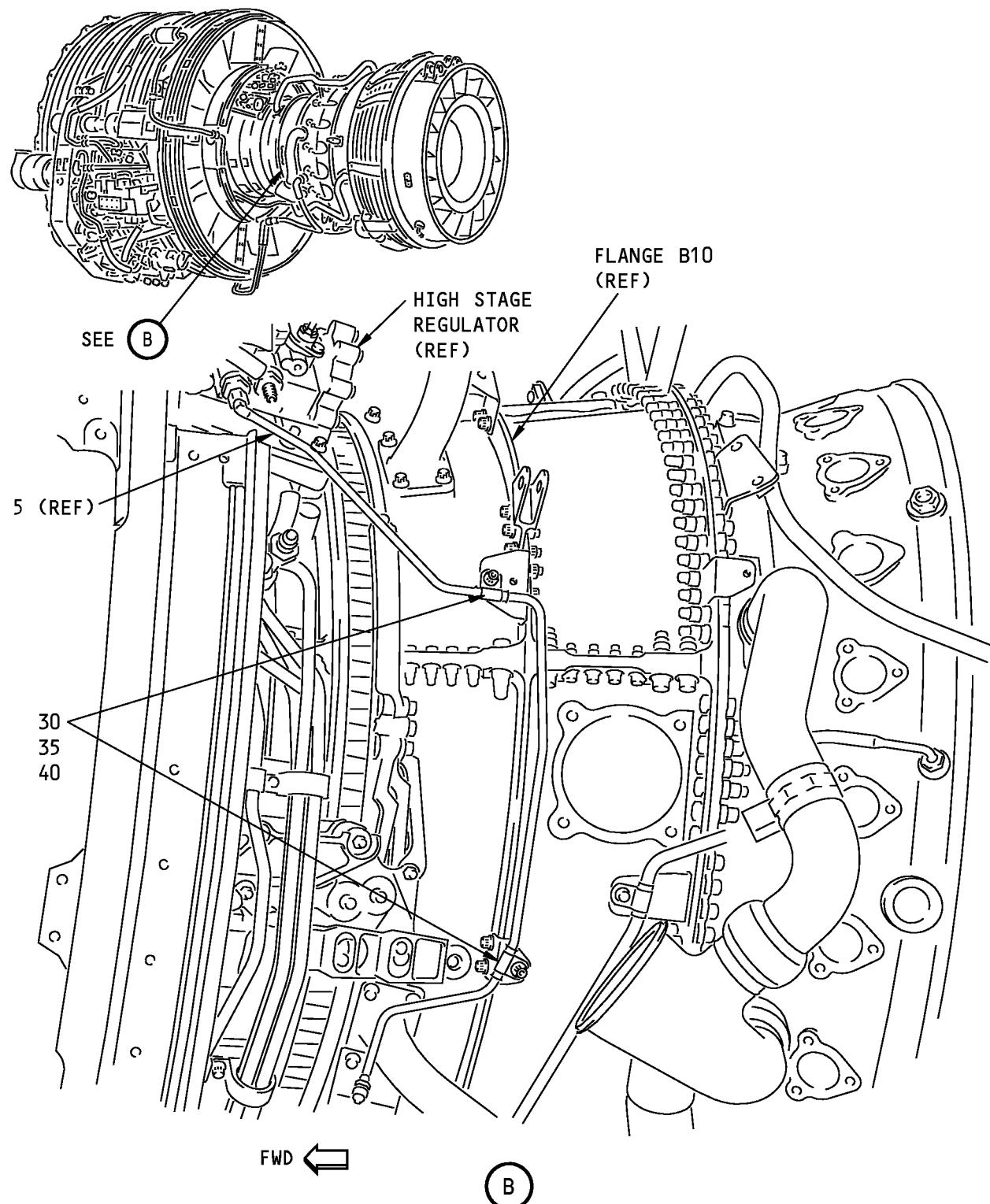
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P/P BUILDUP FIGURE 15-1

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POWERPLANT BUILDUP MANUALLower Bleed Control System Installation
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P/P BUILDUP FIGURE 15-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
15-1		LOWER BLEED CONTROL SYSTEM INSTALLATION (FIGURE 15-1, SHEET 2) APPLY LIGHT COATING OF Never-Seez NSBT-8N compound, D00006 (C1) TO UNDERSIDE HEAD OF BOLTS (40). LOOSELY ATTACH TUBE (5) TO ENGINE BRACKETS AT 8 AND 9 O'CLOCK POSITIONS ON FLANGE B10 WITH CLAMPSHELLS (30), CLAMPS (35) AND BOLTS (40). <u>NOTE:</u> USE FWD HOLE ON BRACKET LOCATED AT 9 O'CLOCK POSITION.		
30	BACC10GT2-04	. CLAMPSHELL		4
30	9352M41P16	. CLAMPSHELL (V83930) (OPTIONAL)	OPT	-
35	1794M49P01	. CLAMP (V96941)	VEN	2
40	BACB30ZF4-05	. BOLT		2
C1	D00006	. NEVER-SEEZ NSBT-8N COMPOUND	CON	AR
		MAKE SURE NO PRELOAD FORCE ON TUBE, OR REGULATOR IS PRESENT.		
		IF PRELOAD IS PRESENT, ADJUST TUBE (5) AND CLAMPS (35) TO BEST POSITION.		
		TIGHTEN BOLTS (40) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS).		
		TIGHTEN TUBE ASSY (5) TO 133-147 POUND-INCHES (15.0-16.6 NEWTON METERS).		
		BACK OFF NUT TO RELAX TORQUE, THEN RETIGHTEN.		

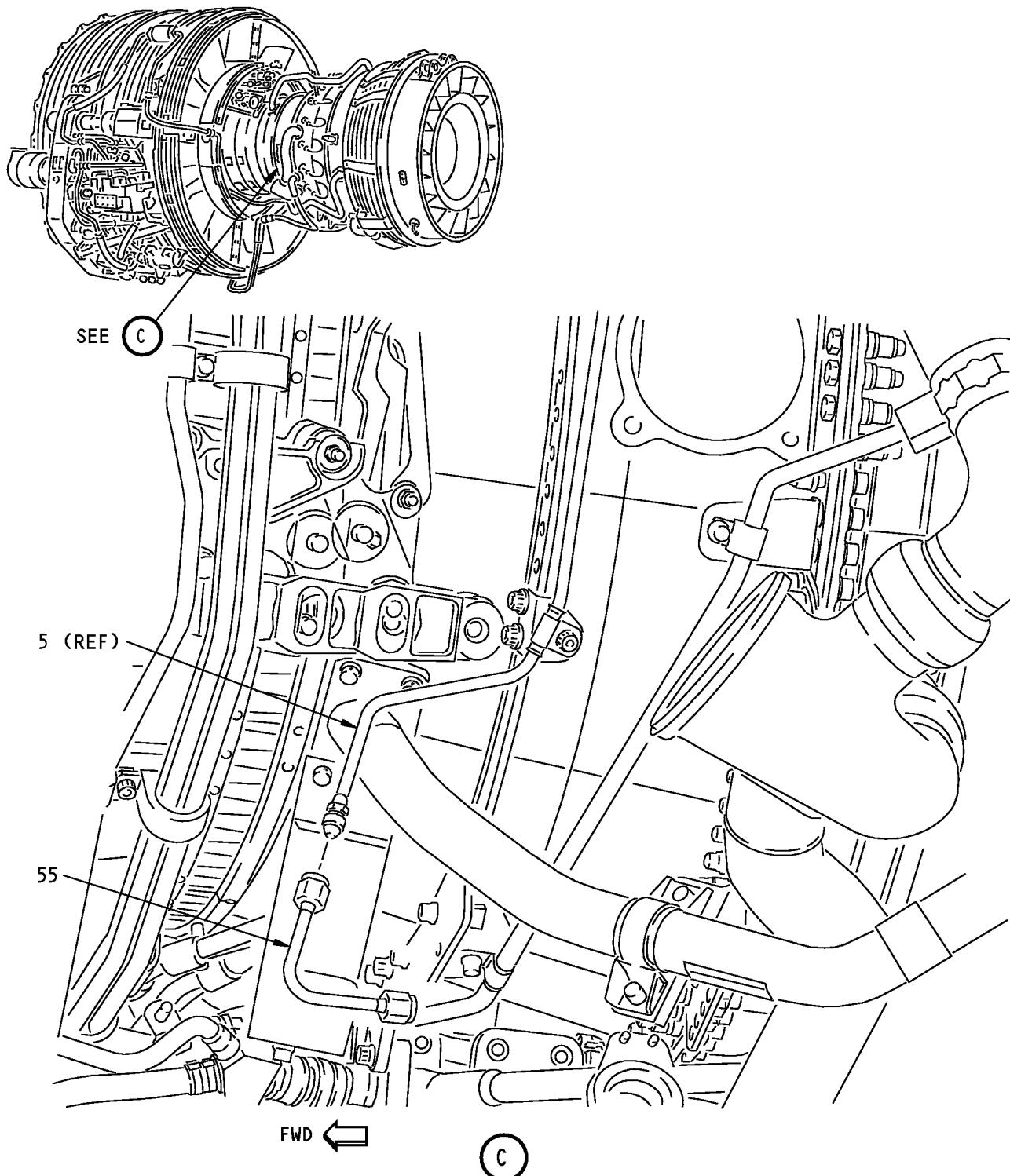
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P/P BUILDUP FIGURE 15-1

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POWERPLANT BUILDUP MANUAL

Lower Bleed Control System Installation
Figure 15-1 (Sheet 3)

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
15-1		LOWER BLEED CONTROL SYSTEM INSTALLATION (FIGURE 15-1, SHEET 3) LOOSELY INSTALL TUBE (55) TO TUBE (5). NOTE: DO NOT TIGHTEN TUBE (55) AT THIS TIME. TUBE WILL BE TIGHTENED DURING THE HIGH STAGE VALVE INSTALLATION (REF BLEED DUCT INSTALLATION - LOWER 5TH- AND 9TH-STAGE/Figure 16-1). 		
55	332A2350-11	. TUBE ASSY MAKE SURE PROTECTIVE CAP IS INSTALLED ON END OF TUBE (55).	1	

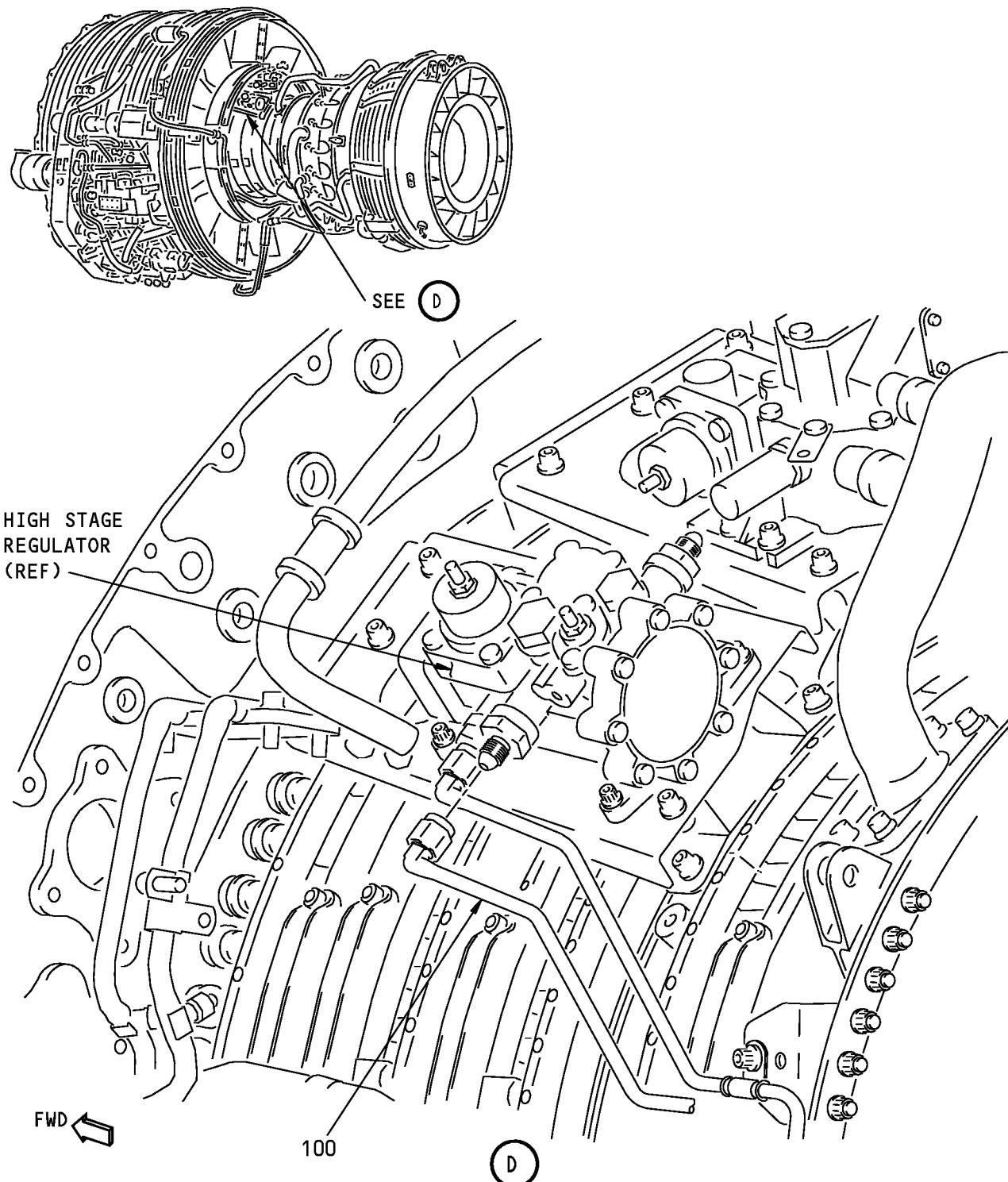
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P/P BUILDUP FIGURE 15-1

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Lower Bleed Control System Installation
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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
15-1 100	332A2350-4	LOWER BLEED CONTROL SYSTEM INSTALLATION (FIGURE 15-1, SHEET 4) LOOSELY ATTACH TUBE (100) TO UNION ON AFT PORT OF HIGH STAGE REGULATOR. . TUBE ASSY		1

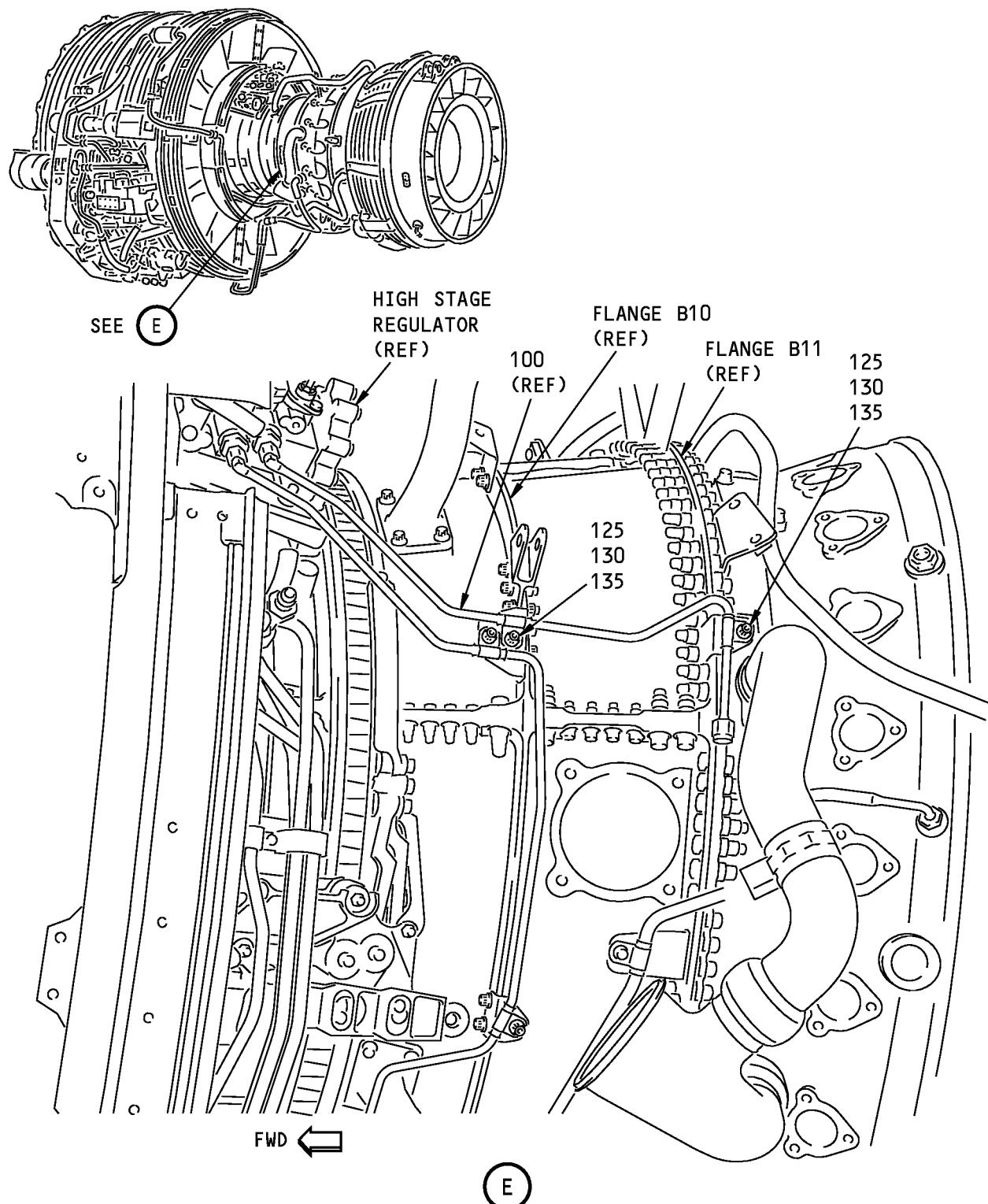
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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
15-1		LOWER BLEED CONTROL SYSTEM INSTALLATION (FIGURE 15-1, SHEET 5) APPLY LIGHT COATING OF Never-Seez NSBT-8N compound, D00006 (C1) TO UNDERSIDE HEAD OF BOLTS (135). LOOSELY ATTACH TUBE (100) TO ENGINE BRACKETS JUST ABOVE 9 O'CLOCK POSITION ON FLANGE B10 AND FLANGE B11 WITH CLAMPSHELLS (125), CLAMPS (130) AND BOLTS (135). . CLAMPSHELL . CLAMPSHELL (V83930) (OPTIONAL) . CLAMP (V96941) . BOLT . NEVER-SEEZ NSBT-8N COMPOUND		
125	BACC10GT2-04	. CLAMPSHELL	OPT	4
125	9352M41P16	. CLAMPSHELL (V83930) (OPTIONAL)	OPT	-
130	1794M49P01	. CLAMP (V96941)	VEN	2
135	BACB30ZF4-05	. BOLT	CON	2
C1	D00006	. NEVER-SEEZ NSBT-8N COMPOUND	CON	AR

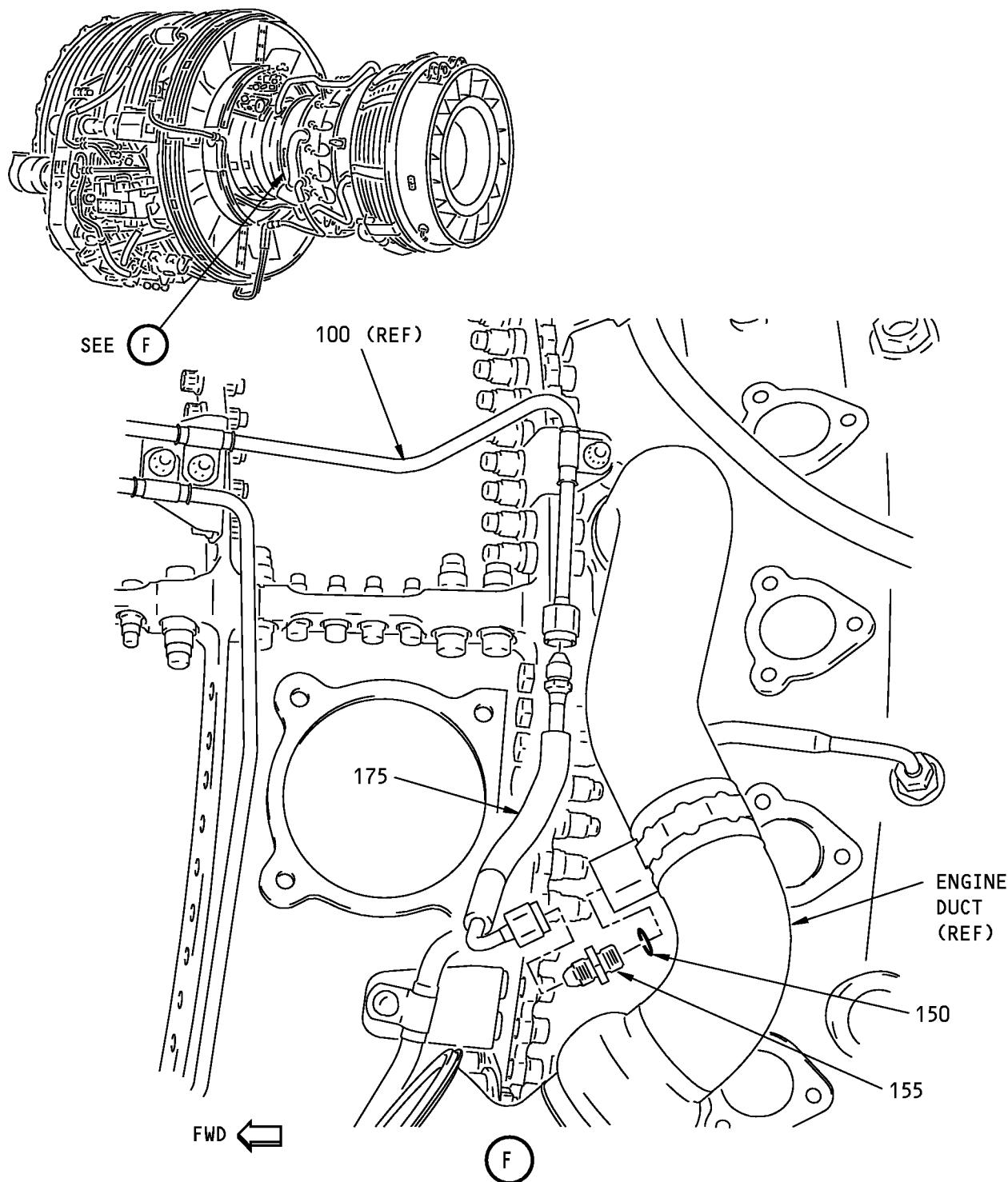
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P/P BUILDUP FIGURE 15-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
15-1		LOWER BLEED CONTROL SYSTEM INSTALLATION (FIGURE 15-1, SHEET 6) INSTALL O-RING (150) ON UNION (155). LUBRICATE THREADS OF UNION (155) WITH Never-Seez NSBT-8N compound, D00006 (C1) AND INSTALL UNION (155) ON ENGINE DUCT. .		
150	801A50-0004-A	. O-RING (V15284)	VEN	1
150	801A50-0004A	. O-RING (V15284) (OPTIONAL TO 801A50-0004-A)	OPT	-
155	J1238P54	. UNION (V07482)	VEN	1
C1	D00006	. NEVER-SEEZ NSBT-8N COMPOUND	CON	AR
		 TIGHTEN UNION (155) TO 130-150 POUND-INCHES (14.7-16.9 NEWTON METERS)		
175	16135-84	 LOOSELY INSTALL HOSE ASSY (175) BETWEEN TUBE (100) AND UNION (155). .	VEN	1
		HOSE ASSY (V99755) (SPEC 60B90135-84)		
		 MAKE SURE NO PRELOAD FORCE ON TUBE, HOSE, REGULATOR OR ENGINE DUCT IS PRESENT.		
		 IF PRELOAD IS PRESENT, ADJUST TUBE (100) AND CLAMPS (130) TO BEST POSITION.		
		 TIGHTEN TUBE ASSY (100) AND HOSE ASSY (175) TO 133-147 POUND-INCHES (15.0-16.6 NEWTON METERS). BACK OFF NUT TO RELAX TORQUE, THEN RETIGHTEN.		
		 TIGHTEN BOLTS (135) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS).		

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P/P BUILDUP FIGURE 15-1

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FIGURE 16-1

**BLEED DUCT INSTALLATION - LOWER 5TH-
AND 9TH-STAGE**

REF QEC TASK NO.: 16

**REF DWG: 332A2100
332A2300**

NOTE: ALL STANDARDS AND ATTACHING HARDWARE FOR THIS FIGURE WILL BE PACKAGED
IN QEC TASK NO. 110.

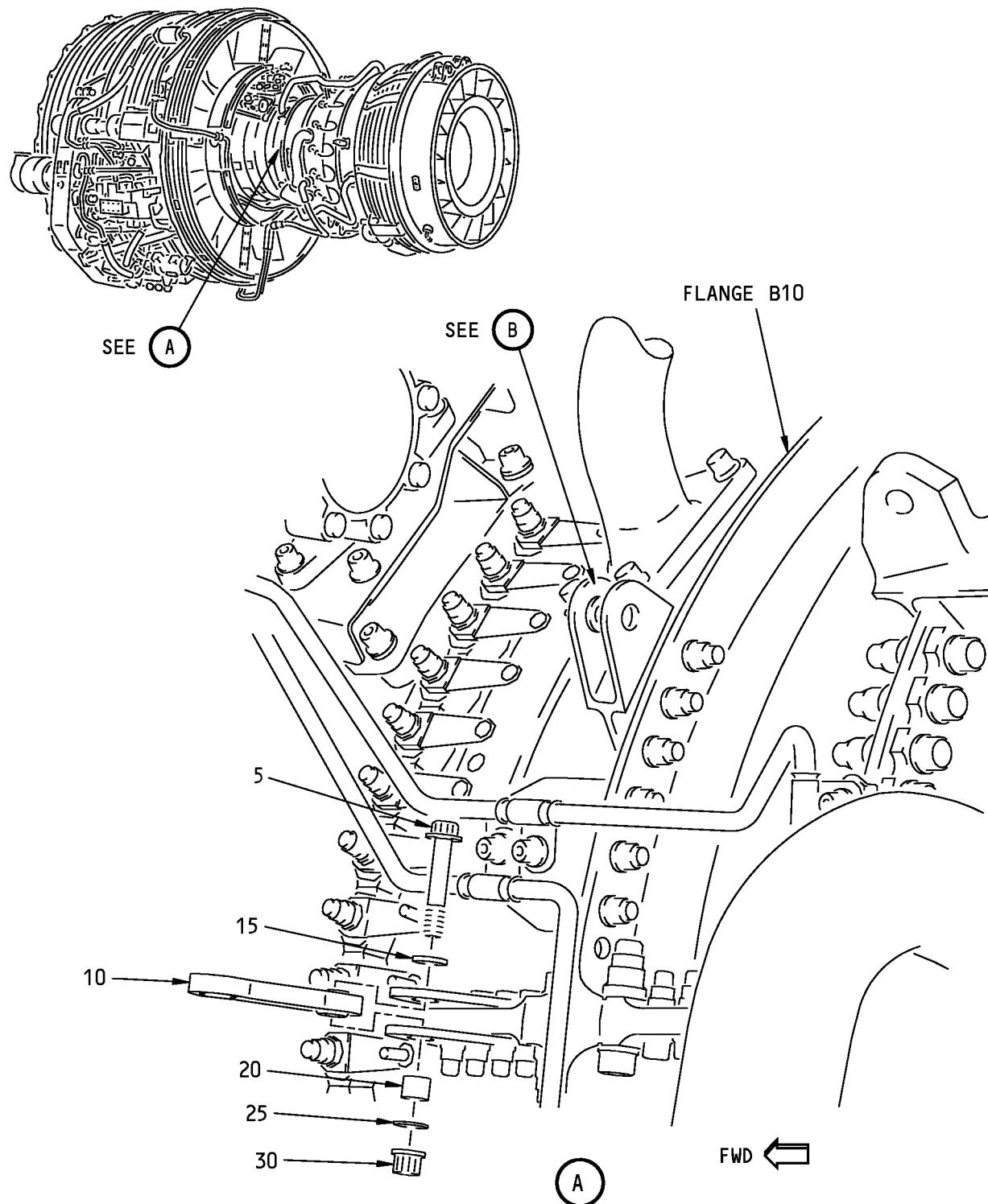
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P/P BUILDUP FIGURE 16-1

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Lower 5th- and 9th-Stage Bleed Duct Installation
Figure 16-1 (Sheet 1)

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P/P BUILDUP FIGURE 16-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
16-1		LOWER 5TH- AND 9TH-STAGE BLEED DUCT INSTALLATION (FIGURE 16-1, SHEET 1) NOTE: IN THIS PROCEDURE, DO NOT TIGHTEN SCREWS AND TUBE OR HOSE NUTS TO THE INDICATED TORQUE UNTIL INSTRUCTED. WHEN TIGHTENING TUBE AND HOSE NUTS, USE TWO WRENCHES; ONE TO HOLD THE SPANNER FLATS ON THE NIPPLE AND ONE TO TIGHTEN THE NUT. APPLY Never-Seez NSBT-8N compound, D00006 (C1) TO THREADS AND SHANK OF BOLT (5). . BOLT . NEVER-SEEZ NSBT-8N COMPOUND LOOSEN CFMI BRACKETS FWD OF FLANGE B10 AT 9 O'CLOCK POSITION ON ENGINE CORE. ATTACH LINK (10) BETWEEN CFMI BRACKETS USING LUBRICATED BOLT (5), WASHERS (15) AND (25), BUSHING (20) AND NUT (30). . LINK ASSY . WASHER (CSK) (UNDER BOLTHEAD) . BUSHING . WASHER (UNDER NUT) . NUT TIGHTEN BOLT (5) TO 50-75 POUND-INCHES (5.6-8.5 NEWTON METERS).		
5 C1	BACB30PN4-16 D00006		CON	1 AR
10	332A2341-4			1
15	BACW10BP4ACU			1
20	BACB28AK04-042			1
25	NAS1149C0432R			1
30	AS3485-10			1

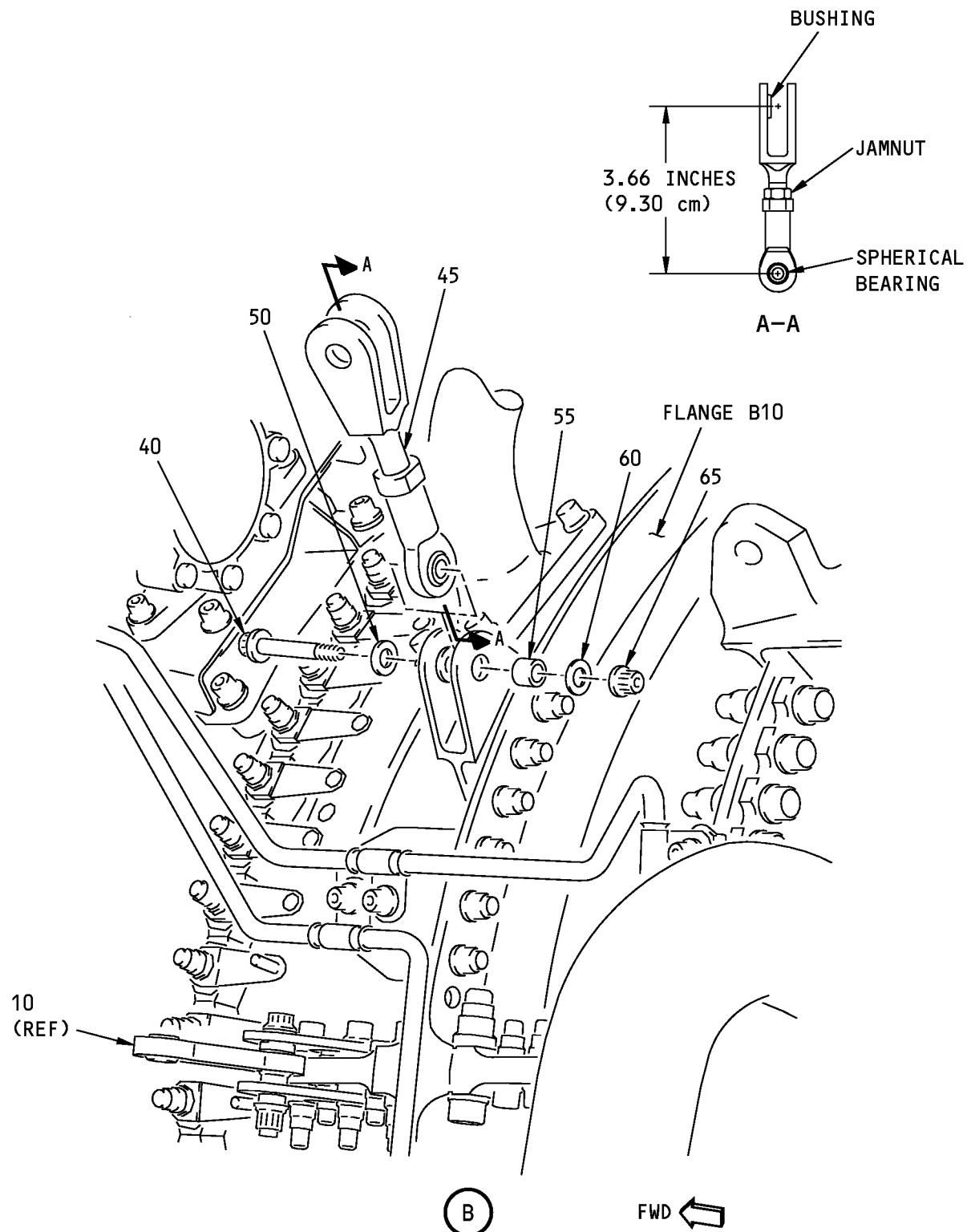
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P/P BUILDUP FIGURE 16-1

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P/P BUILDUP FIGURE 16-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
16-1		LOWER 5TH- AND 9TH-STAGE BLEED DUCT INSTALLATION (FIGURE 16-1, SHEET 2)		
40		APPLY Never-Seez NSBT-8N compound, D00006 (C1) TO THREADS AND SHANK OF BOLT (40).		
C1	BACB30PN4-14 D00006	. BOLT . NEVER-SEEZ NSBT-8N COMPOUND LOOSEN JAMNUT OF LINK ASSY (45) TO FREE ROD END. ADJUST LINK ASSY TO 3.66 INCHES (9.30 CM) FROM CENTERLINE OF BUSHING TO CENTERLINE OF SPHERICAL BEARING. RETIGHTEN JAMNUT. LOOSEN CLEVIS BRACKET ON FLANGE B10 AT 10 O'CLOCK POSITION ON ENGINE CORE. ATTACH LINK ASSY (45) TO CLEVIS BRACKET USING LUBRICATED BOLT (40), WASHERS (50) AND (60), BUSHING (55) AND NUT (65).	CON	1 AR
45	332A2341-5	. LINK ASSY		1
50	BACW10BP4ACU	. WASHER (CSK) (UNDER BOLTHEAD)		1
55	BACB28AK04-030	. BUSHING		1
60	NAS1149C0432R	. WASHER (UNDER NUT)		1
65	AS3485-10	. NUT		1
		TIGHTEN BOLT (40) TO 50-75 POUND-INCHES (5.6-8.5 NEWTON METERS).		

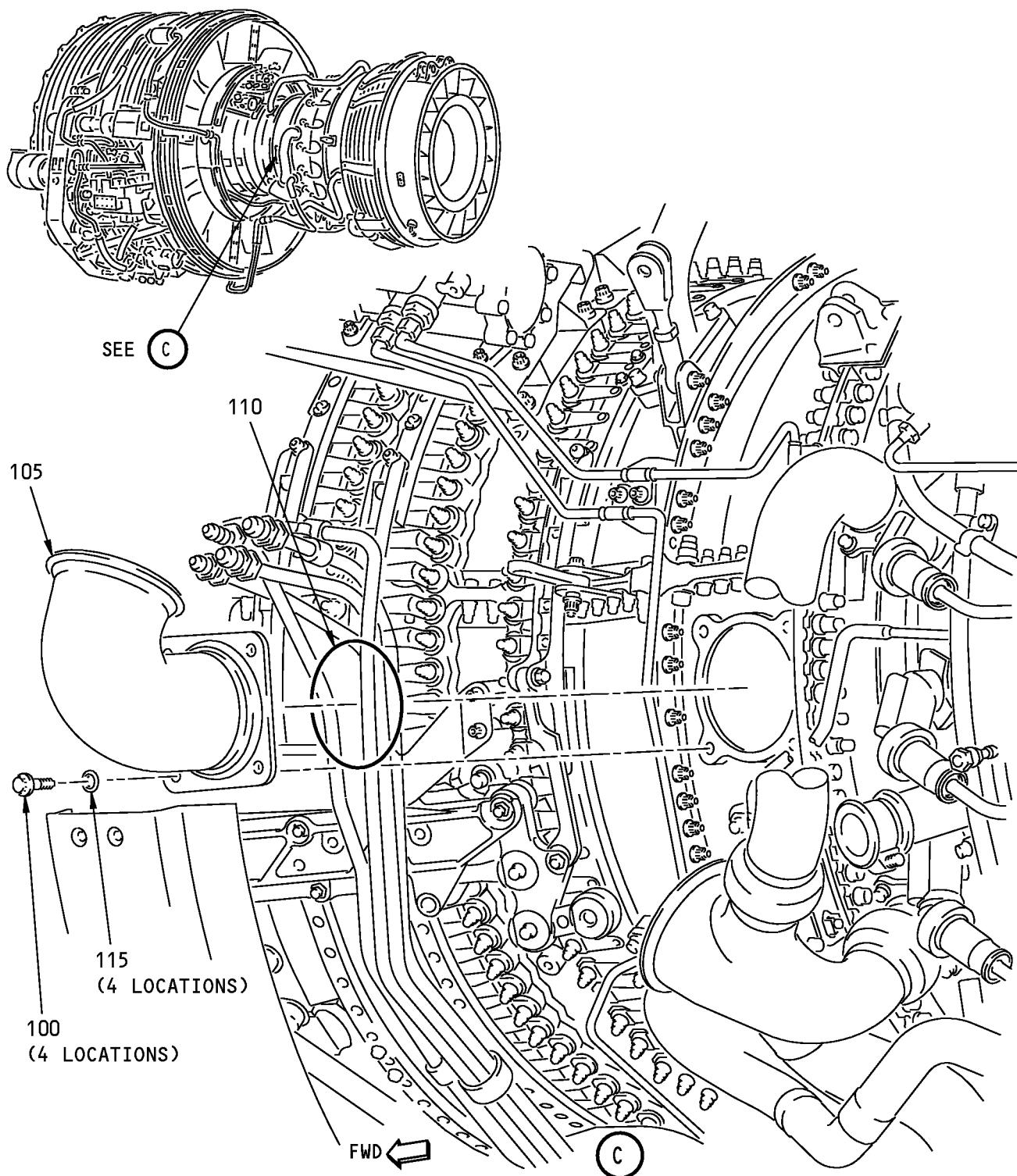
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P/P BUILDUP FIGURE 16-1

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POWERPLANT BUILDUP MANUALLower 5th- and 9th-Stage Bleed Duct Installation
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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
16-1		LOWER 5TH- AND 9TH-STAGE BLEED DUCT INSTALLATION (FIGURE 16-1, SHEET 3)		
100	BACB30PN5H3	APPLY Never-Seez NSBT-8N compound, D00006 (C1) TO THREADS AND SHANK OF BOLTS (100).		
C1	D00006	<ul style="list-style-type: none"> . BOLT . NEVER-SEEZ NSBT-8N COMPOUND 	CON	4 AR
		REMOVE PROTECTIVE COVER FROM ENGINE PORT.		
105	332A2323-14	POSITION DUCT ASSY (105) AND SEAL (110) ON ENGINE PORT AND ATTACH USING BOLTS (100) AND WASHERS (115) (WITH COUNTERSINK TOWARD BOLTHEADS).		
110	8757-350	<ul style="list-style-type: none"> . DUCT ASSY . SEAL (V15284) . WASHERS (CSK) 	VEN	1 1 4
115	BACW10BP5ACU	TIGHTEN BOLTS (100) TO 115-125 POUND-INCHES (13.0-14.2 NEWTON METERS).		
		INSTALL MS20995NC32 lockwire, G01912 (C2) OR safety cable kit, G50375 (C3) TO FWD AND AFT PAIR OF BOLTS (100).		
C2	G01912	<ul style="list-style-type: none"> . MS20995NC32 LOCKWIRE . SAFETY CABLE KIT 	CON	AR
C3	G50375		CON	2

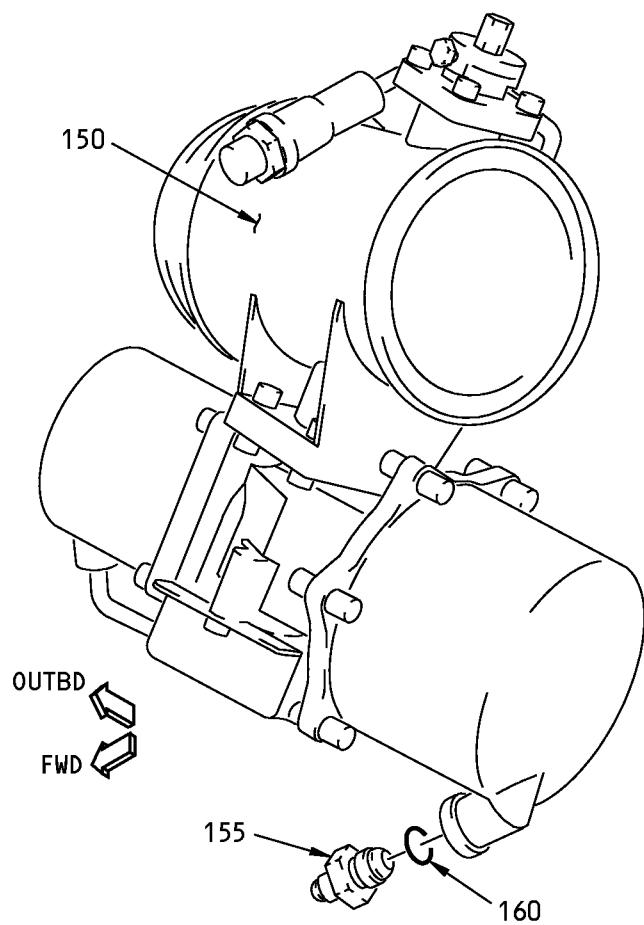
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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
16-1		LOWER 5TH- AND 9TH-STAGE BLEED DUCT INSTALLATION (FIGURE 16-1, SHEET 4) LUBRICATE THREADS OF REDUCER (155) WITH Never-Seez NSBT-8N compound, D00006 (C1). INSTALL O-RING (160) ON REDUCER (155) AND INSTALL ON HIGH STAGE VALVE (150).		
150	3214446-4	. HIGH STAGE VALVE (V59364) (SPEC 10-62008-32)	VEN	1
155	J522P52	. REDUCER (V96941)	VEN	1
160	801A50-0005-A	. O-RING (V15284)	VEN	1
160	801A50-0005A	. O-RING (V15284) (OPTIONAL TO 801A50-0005-A)	OPT	-
C1	D00006	. NEVER-SEEZ NSBT-8N COMPOUND	CON	AR
		TIGHTEN REDUCER (155) TO 180-200 POUND-INCHES (20.3-22.6 NEWTON METERS).		

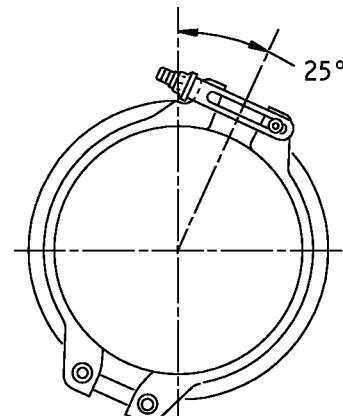
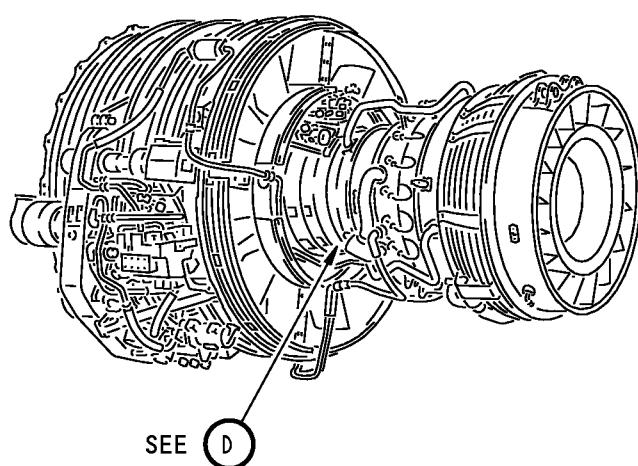
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P/P BUILDUP FIGURE 16-1

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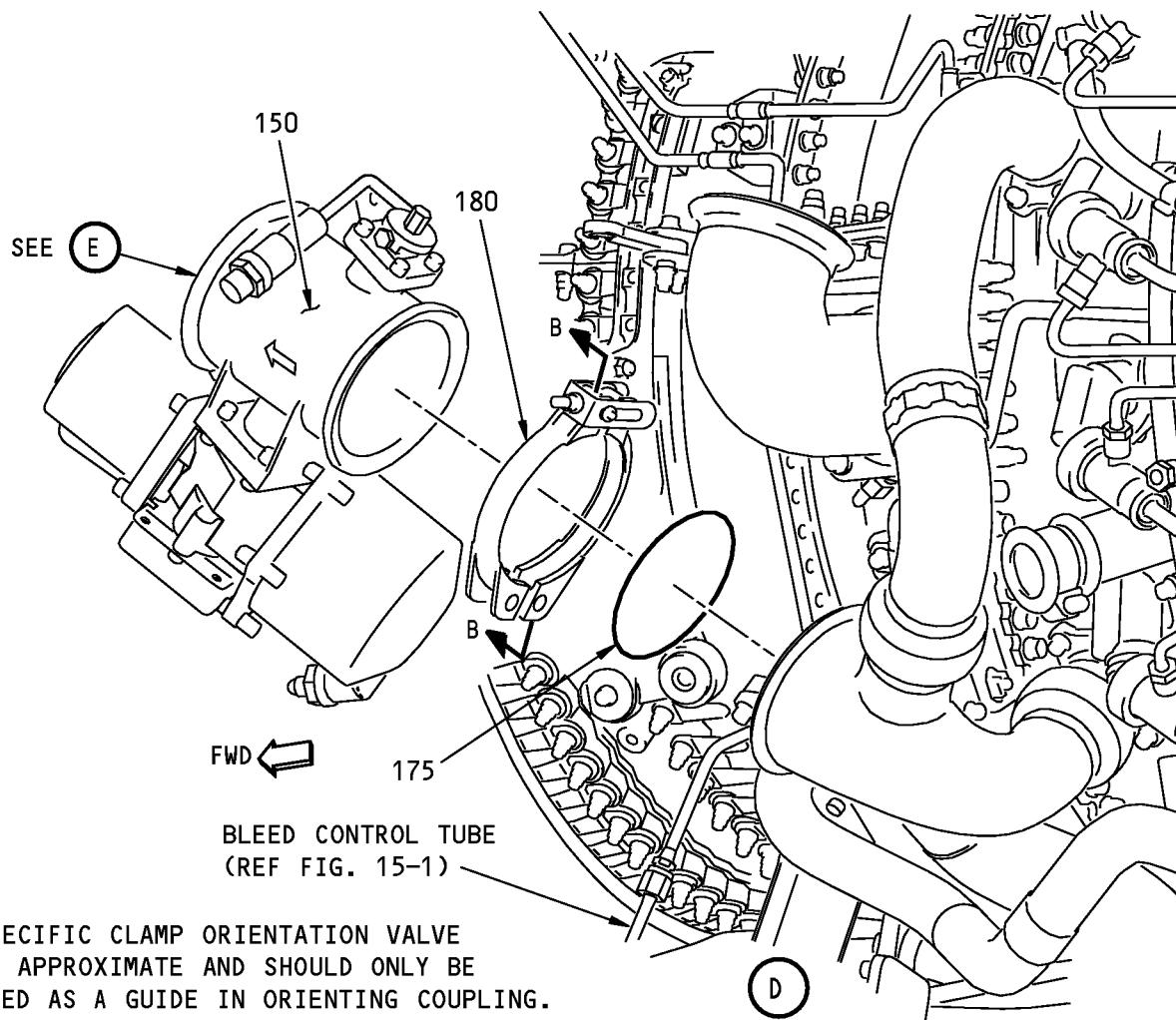
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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
16-1		LOWER 5TH- AND 9TH-STAGE BLEED DUCT INSTALLATION (FIGURE 16-1, SHEET 5) NOTE: ALL DUCT COUPLINGS HAVE A DRY-FILM LUBRICANT AND SHOULD NOT BE LUBRICATED FURTHER. VISUALLY EXAMINE ALL SEAL AND FLANGE SEALING SURFACES BEFORE INSTALLATION TO ENSURE NO SCRATCHES, CUTS, PITS, OR FOREIGN MATERIAL IS PRESENT. LOOSELY ATTACH HIGH STAGE VALVE (150) TO CFMI DUCT AT 8 O'CLOCK LOCATION ON ENGINE CORE. USE SEAL (175) AND COUPLING (180). . SEAL . SEAL (OPTIONAL TO AS1895-7-350) . COUPLING . COUPLING (OPTIONAL TO AS1895-1-350) LOOSELY INSTALL BLEED CONTROL TUBE (REF BLEED CONTROL SYSTEM INSTALLATION - LOWER/Figure 15-1) TO UNION AND ORIENT HIGH STAGE VALVE TO BEST POSITION. NOTE: FINAL ORIENTATION OF HIGH STAGE VALVE IS DETERMINED BY BLEED CONTROL TUBE. ORIENT COUPLING (180) WITH COUPLING BOLT ON TOP AND COUPLING NUT FACING OUTBOARD. COUPLING LINK MUST BE CENTERED ALONG THE TAB LOCATED AT THE BOTTOM OF THE 9TH STAGE BLEED DUCT. TIGHTEN COUPLING (180) TO TORQUE SPECIFIED ON PART. LIGHTLY TAP OUTER SURFACE OF COUPLING WITH NON-METALLIC MALLET. RETIGHTEN COUPLING TO TORQUE GIVEN ON PART. TIGHTEN BLEED CONTROL TUBE TO AT BOTH ENDS TO 133-147 POUND-INCHES (15.0-16.6 NEWTON METERS). BACK OFF NUT TO RELAX TORQUE, THEN RETIGHTEN.		
175	AS1895-7-350			1
175	AS1895/7-350		OPT	-
180	AS1895-1-350			1
180	AS1895/1-350		OPT	-

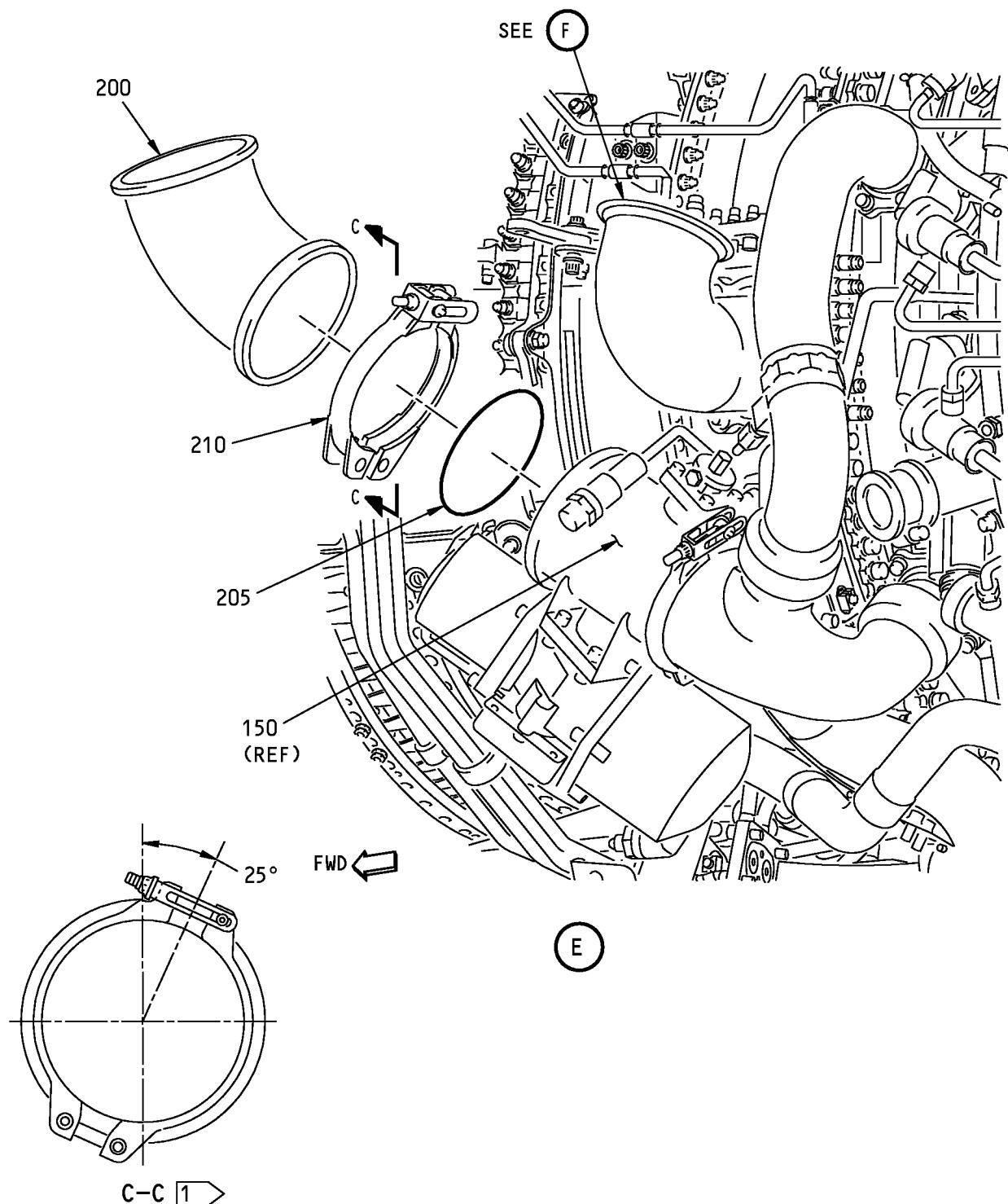
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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
16-1		LOWER 5TH- AND 9TH-STAGE BLEED DUCT INSTALLATION (FIGURE 16-1, SHEET 6)		
200	332A2321-10	LOOSELY ATTACH DUCT ASSY (200) TO HIGH STAGE VALVE (150) WITH SEAL (205) AND COUPLING (210).		1
205	AS1895-7-350	. DUCT ASSY		1
205	AS1895/7-350	. SEAL	OPT	-
210	AS1895-1-350	. SEAL (OPTIONAL TO AS1895-7-350)		1
210	AS1895/1-350	. COUPLING ^[2]	OPT	-
		. COUPLING (OPTIONAL TO AS1895-1-350) ^[2]		
		ORIENT COUPLING (210) WITH COUPLING BOLT ON TOP AND COUPLING NUT FACING OUTBOARD.		
		*[2] ORIENT COUPLING TO MAXIMIZE CLEARANCE.		

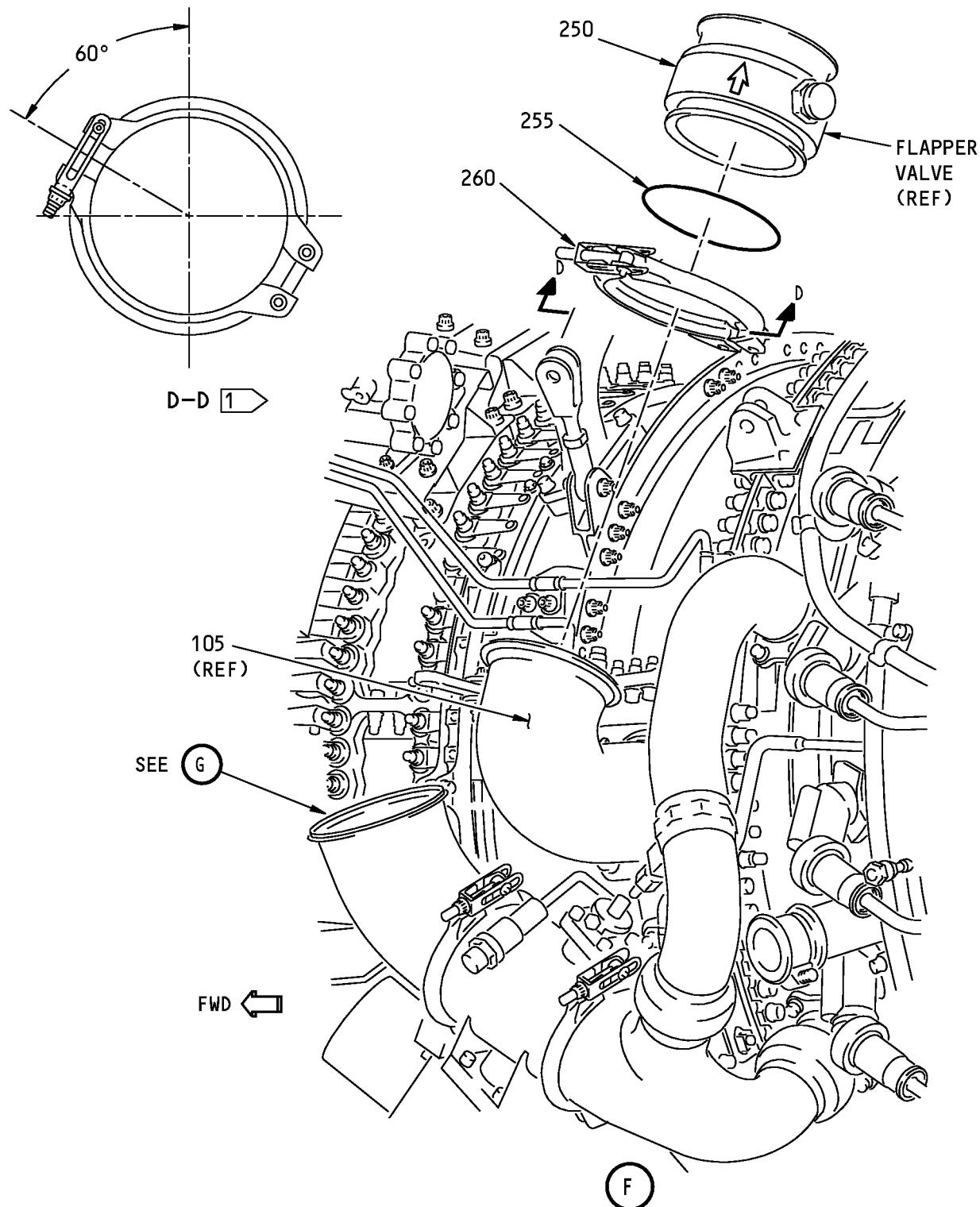
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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
16-1		LOWER 5TH- AND 9TH-STAGE BLEED DUCT INSTALLATION (FIGURE 16-1, SHEET 7) LOOSELY ATTACH CHECK VALVE (250) TO DUCT (105) AT 9 O'CLOCK LOCATION ON ENGINE CORE. USE SEAL (255) AND COUPLING (260). ORIENT CHECK VALVE SO FLOW ARROW POINTS UP AND FLAPPER VALVE SHAFT IS APPROXIMATELY PARALLEL TO 5TH-STAGE PORT +/- 0.25 INCH (6.35 MM) TO MAXIMIZE CLEARANCE WITH THRUST REVERSER. NOTE: DO NOT TIGHTEN COUPLING AT THIS TIME.		
250	3202222-1	. CHECK VALVE (V59364) (SPEC 10-62008-1)	VEN	1
255	AS1895-7-350	. SEAL		1
255	AS1895/7-350	. SEAL (OPTIONAL TO AS1895-7-350)	OPT	-
260	AS1895-4-350	. COUPLING		1
260	AS1895/4-350	. COUPLING (OPTIONAL TO AS1895-4-350)	OPT	-

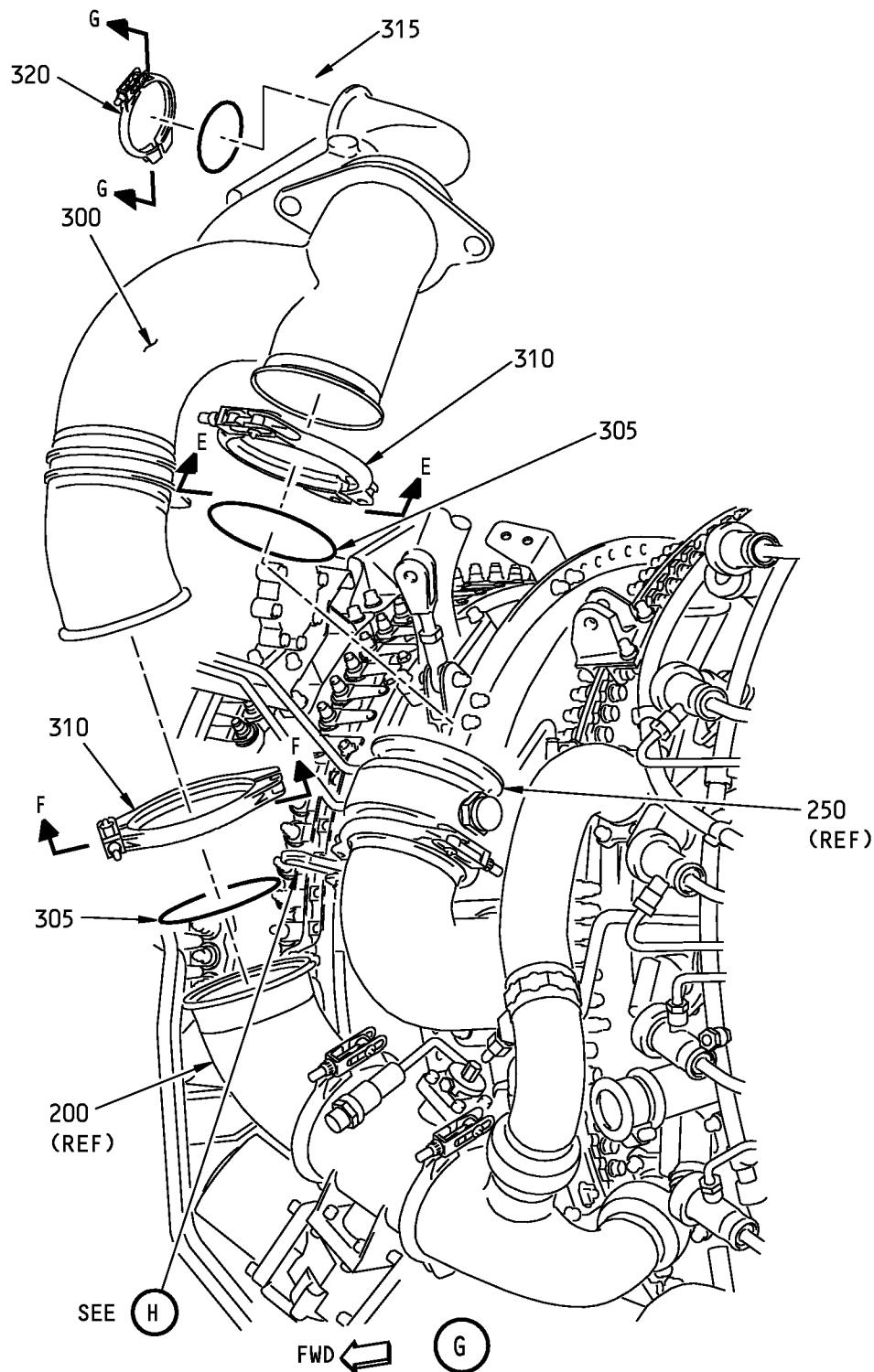
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P/P BUILDUP FIGURE 16-1

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POWERPLANT BUILDUP MANUALLower 5th- and 9th-Stage Bleed Duct Installation
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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
16-1		LOWER 5TH- AND 9TH-STAGE BLEED DUCT INSTALLATION (FIGURE 16-1, SHEET 8) POSITION DUCT ASSY (300) AND SEALS (305) ON DUCT ASSY (200) AND CHECK VALVE (250). LOOSELY CONNECT DUCT ASSY (300) WITH COUPLINGS (310). NOTE: DO NOT TIGHTEN COUPLINGS AT THIS TIME.		
300	332A2322-54	. DUCT ASSY, INTERSECTION MANIFOLD		1
305	AS1895-7-350	. SEAL		2
305	AS1895/7-350	. SEAL (OPTIONAL TO AS1895-7-350)	OPT	-
310	AS1895-4-350	. COUPLING ^[2]		2
310	AS1895/4-350	. COUPLING (OPTIONAL TO AS1895-4-350) ^[2]	OPT	-
		LOOSELY CONNECT CTAI FLANGE OF DUCT (300) TO CTAI BIFUR DUCT AT 12 O'CLOCK POSITION (REF 12 O'CLOCK STRUT INSTALLATION/Figure 13-1) WITH SEAL (315) AND COUPLING (320). NOTE: DO NOT TIGHTEN COUPLING AT THIS TIME.		
315	AS1895-7-175	. SEAL		1
315	AS1895/7-175	. SEAL (OPTIONAL TO AS1895-7-175)	OPT	-
320	AS1895-4-175	. COUPLING ^[2]		1
320	AS1895/4-175	. COUPLING (OPTIONAL TO AS1895-4-175) ^[2]	OPT	-
		MAKE SURE PROTECTIVE CAP IS INSTALLED ON TOP OF DUCT (300). *[2] ORIENT COUPLING TO MAXIMIZE CLEARANCE.		

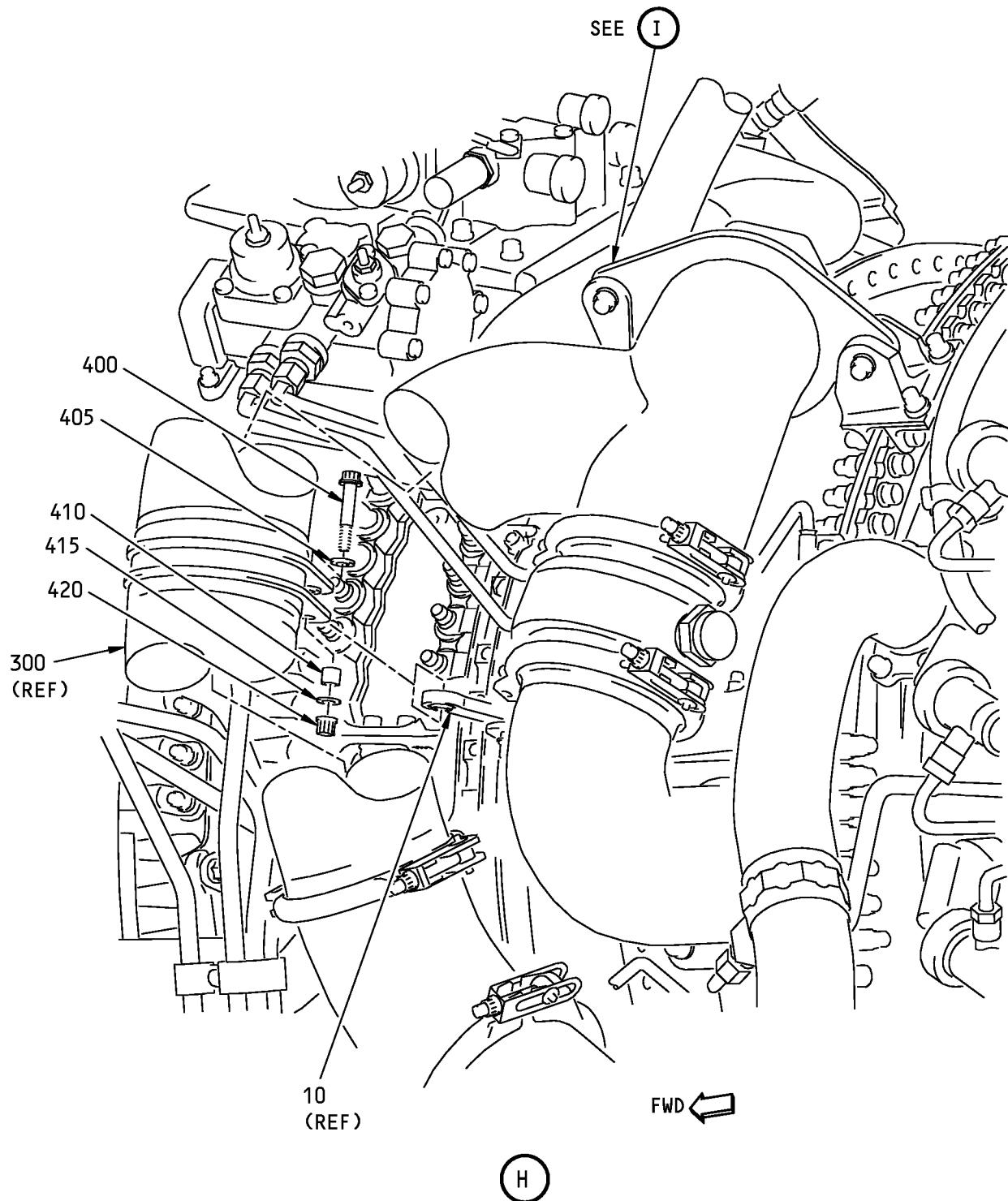
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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
16-1		LOWER 5TH- AND 9TH-STAGE BLEED DUCT INSTALLATION (FIGURE 16-1, SHEET 9)		
400	BACB30PN4-14	APPLY Never-Seez NSBT-8N compound, D00006 (C1) TO THREADS AND SHANK OF BOLT (400).		
C1	D00006	. BOLT . NEVER-SEEZ NSBT-8N COMPOUND	CON	1 AR
405	BACW10BP4ACU	LOOSELY ATTACH DUCT (300) TO LINK ASSY (10) WITH LUBRICATED BOLT (400), WASHERS (405) AND (415), BUSHING (410) AND NUT (420).		1
410	BACB28AK04-030	NOTE: DO NOT TIGHTEN BOLT AT THIS TIME.		1
415	NAS1149C0432R	. WASHER (CSK) (UNDER BOLTHEAD)		1
420	AS3485-10	. BUSHING . WASHER (UNDER NUT)		1
		. NUT		1

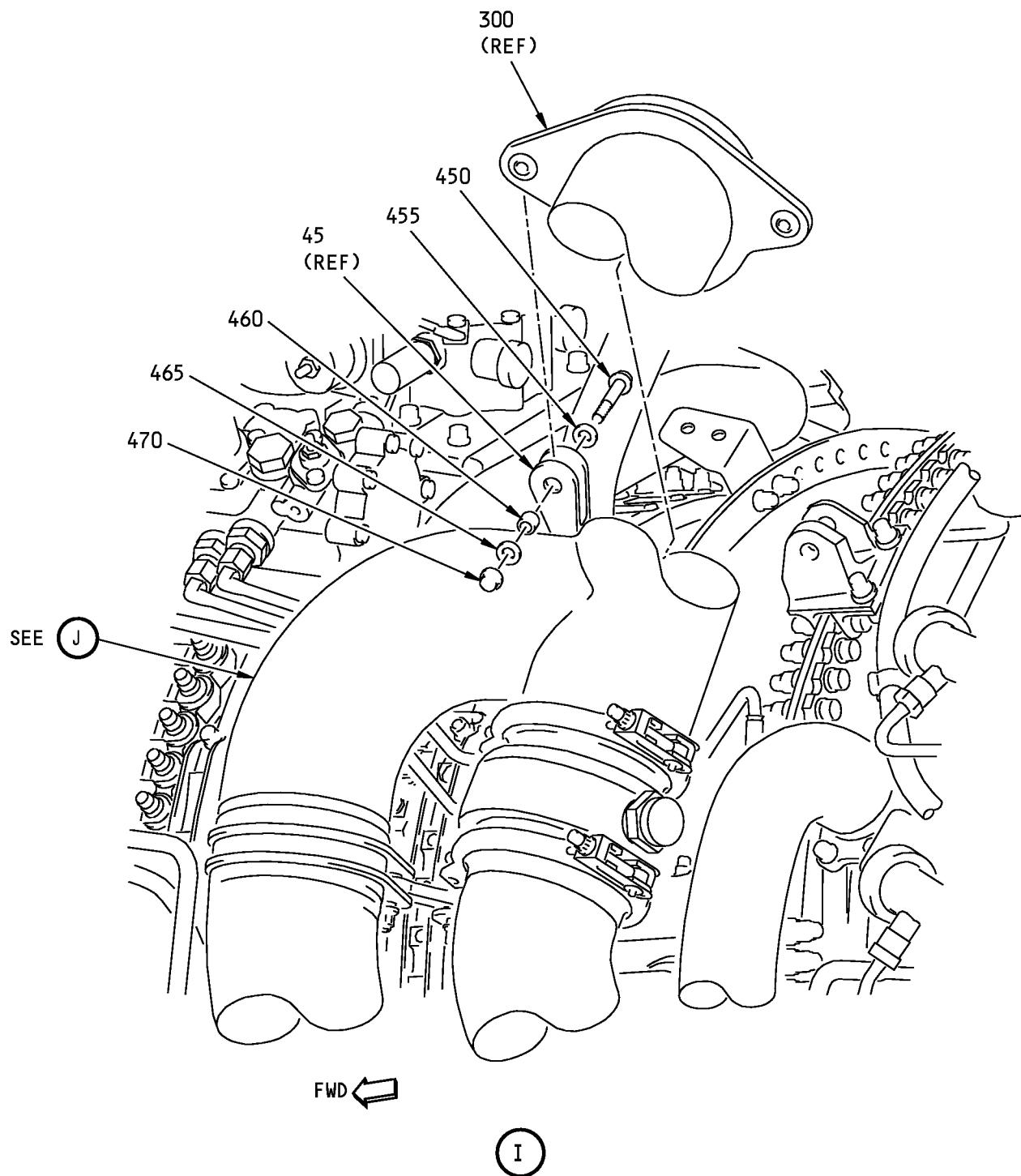
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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
16-1		LOWER 5TH- AND 9TH-STAGE BLEED DUCT INSTALLATION (FIGURE 16-1, SHEET 10)		
450		APPLY Never-Seez NSBT-8N compound, D00006 (C1) TO THREADS AND SHANK OF BOLT (450).		
C1	BACB30PN4-14 D00006	. BOLT . NEVER-SEEZ NSBT-8N COMPOUND	CON	1 AR
455	BACW10BP4ACU	LOOSELY ATTACH LINK (45) TO ATTACH FLANGE OF DUCT ASSY (300) WITH LUBRICATED BOLT (450), WASHERS (455) AND (465), BUSHING (460) AND NUT (470).		1
460	BACB28AK04-030	. WASHER (CSK) (UNDER BOLTHEAD)		1
465	NAS1149C0432R	. BUSHING		1
470	AS3485-10	. WASHER (UNDER NUT)		1
		. NUT		1

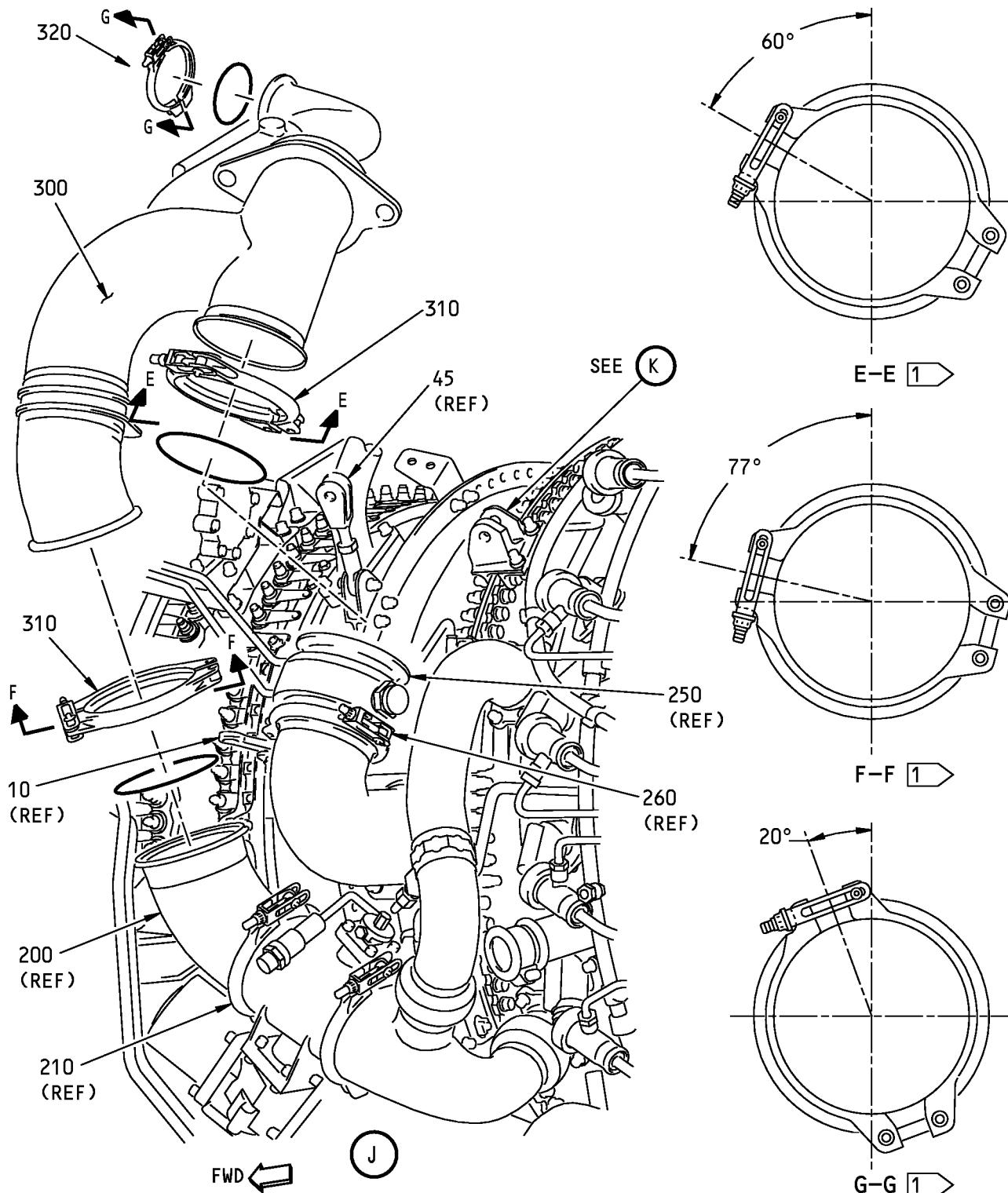
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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
16-1		<p>LOWER 5TH- AND 9TH-STAGE BLEED DUCT INSTALLATION (FIGURE 16-1, SHEET 11)</p> <p>ORIENT COUPLINGS (310) AND (320) AS SHOWN.</p> <p>ADJUST DUCT ASSYS (200) AND (300) TO MAKE SURE NO PRELOAD EXISTS ON DUCTS, CHECK VALVE (250) AND LINKS (10) AND (45).</p> <p>TIGHTEN COUPLINGS (210), (260), (310) AND (320) TO TORQUE GIVEN ON PART.</p> <p>LIGHTLY TAP OUTER SURFACE WITH NON-METALLIC MALLET.</p> <p>RETIGHTEN COUPLINGS TO TORQUE GIVEN ON PART.</p> <p>TIGHTEN CFMI BRACKETS SUPPORTING LINK (10) AND CLEVIS BRACKET SUPPORTING LINK (45) TO ENGINE FLANGES. TIGHTEN BOLTS TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS).</p> <p>TIGHTEN BOLTS (400) AND (450) TO 50-75 POUND-INCHES (5.6-8.5 NEWTON METERS).</p> <p>NOTE: MAKE SURE LINKS DO NOT APPLY A PRELOAD TO ADJACENT DUCT OR SUPPORT HARDWARE.</p> <p>IF NECESSARY, ADJUST LINK (10) BY REPOSITIONING CFMI BRACKETS.</p> <p>LOOSEN CFMI FASTENERS, REPOSITION BRACKETS AND RETIGHTEN FASTENERS TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS).</p> <p>IF NECESSARY, ADJUST LINK (45) BY LOOSENING JAMNUT ON LINK TO FREE ROD END.</p> <p>ADJUST AS NECESSARY AND RETIGHTEN JAMNUT.</p>		
C2 C3	G01912 G50375	<p>APPLY MS20995NC32 lockwire, G01912 (C2) OR safety cable kit, G50375 (C3) BETWEEN JAMNUT AND FEMALE SIDE OF LINK (45).</p> <ul style="list-style-type: none"> . MS20995NC32 LOCKWIRE . SAFETY CABLE KIT 	CON CON	AR 1

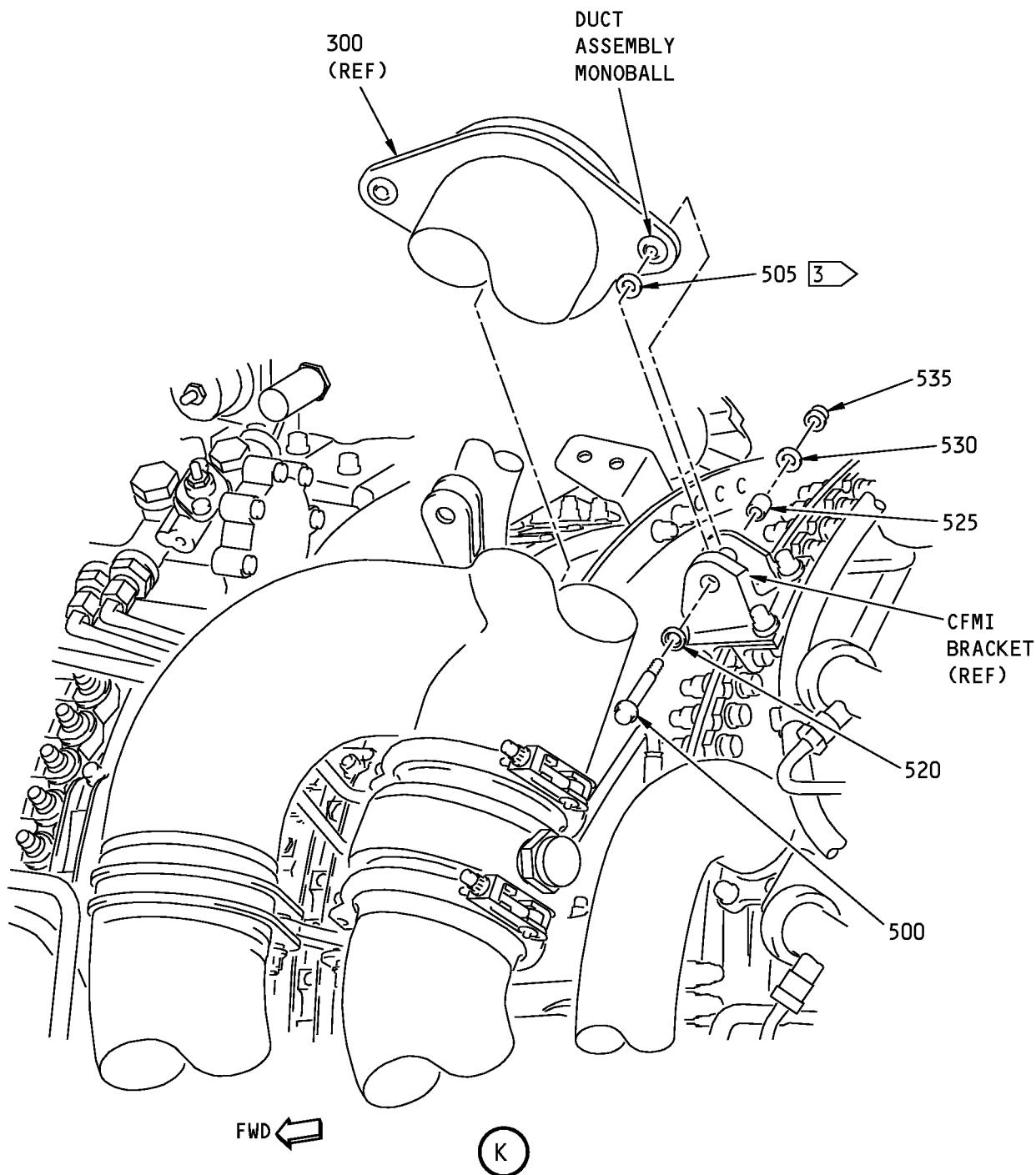
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P/P BUILDUP FIGURE 16-1

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[3] > INSTALL UP TO 4 WASHERS AS NECESSARY BETWEEN LOWER SIDE OF DUCT ASSEMBLY MONOBALL AND CFMI BRACKET.

Lower 5th- and 9th-Stage Bleed Duct Installation
Figure 16-1 (Sheet 12)

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
16-1		LOWER 5TH- AND 9TH-STAGE BLEED DUCT INSTALLATION (FIGURE 16-1, SHEET 12)		
500	BACB30PN6C22	APPLY Never-Seez NSBT-8N compound, D00006 (C1) TO THREADS AND SHANK OF BOLT (500).		
500	BACB30PN6C24	. BOLT ^[4]	OPT	1
C1	D00006	. BOLT (OPTIONAL TO BACB30PN6C22) ^[4]	CON	-
		. NEVER-SEEZ NSBT-8N COMPOUND		AR
505	NAS1149E0616R	INSTALL UP TO 4 WASHERS (505) TO ELIMINATE GAP BETWEEN LOWER SIDE OF DUCT ASSY MONOBALL AND CFMI BRACKET. IF GAP BETWEEN CFMI BRACKET AND DUCT ASSY MONOBALL IS MORE THAN 0.12 INCHES (3.0 MM), REPOSITION CFMI BRACKET TO REDUCE GAP. RETIGHTEN BRACKET FASTENERS TO 210-230 POUND-INCHES (23.7-26.0 NEWTON METERS).		4
520	BACW10BN6UC	. WASHER		
525	BACB28AK06-040	SECURE WASHERS (505) TO DUCT FLANGE AND BRACKET CLEVIS WITH BOLT (500), WASHERS (520) AND (530), BUSHING (525), AND NUT (535).		1
525	BACB28AK06-055	MAKE SURE DUCT INSTALLATION DOES NOT APPLY A PRELOAD OF MORE THAN 50 POUNDS (222.4 NEWTONS) ON ADJACENT STRUCTURE.		1
530	NAS1149E0632R	. WASHER (CSK) (UNDER BOLTHEAD)	OPT	-
535	AS3485-12	. BUSHING ^[4]		1
		. BUSHING ^[4]		1
		. WASHER (UNDER NUT)		1
		. NUT		1
		TIGHTEN BOLT (500) TO 150-250 POUND-INCHES (17.0-28.2 NEWTON METERS).		
		*[4] BACB30PN6C24 BOLT (500) TOGETHER WITH BACB28AK06-055 BUSHING (525) OPTIONAL TO BACB30PN6C22 BOLT (500) TOGETHER WITH BACB28AK06-040 BUSHING (525).		

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P/P BUILDUP FIGURE 16-1

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FIGURE 17-1

**BLEED CONTROL SYSTEM INSTALLATION -
UPPER**

REF QEC TASK NO.: 17

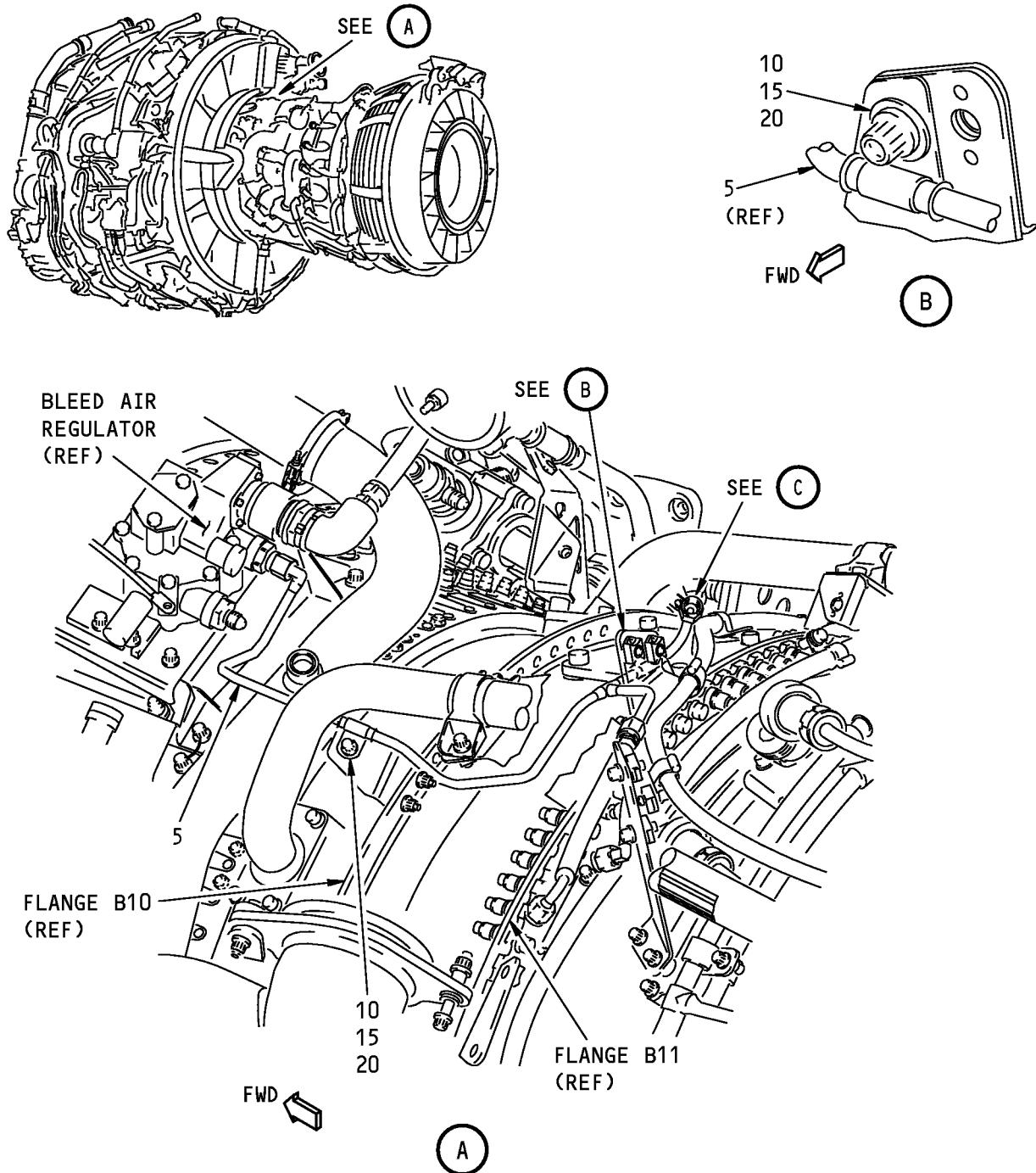
REF DWG: 332A2100

NOTE: ALL STANDARDS AND ATTACHING HARDWARE FOR THIS FIGURE WILL BE PACKAGED
IN QEC TASK NO. 110.

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P/P BUILDUP FIGURE 17-1
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POWERPLANT BUILDUP MANUAL

F14546 S00041153845_V4

Upper Bleed Control System Installation
Figure 17-1 (Sheet 1)

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P/P BUILDUP FIGURE 17-1

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737-600/700/800/900
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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
17-1		UPPER BLEED CONTROL SYSTEM INSTALLATION (FIGURE 17-1, SHEET 1) <p>NOTE: IN THIS PROCEDURE, DO NOT TIGHTEN SCREWS AND TUBE OR HOSE NUTS TO THE INDICATED TORQUE UNTIL INSTRUCTED.</p> <p>WHEN TIGHTENING TUBE AND HOSE NUTS, USE TWO WRENCHES; ONE TO HOLD THE SPANNER FLATS ON THE NIPPLE AND ONE TO TIGHTEN THE NUT.</p> <p>ALL TUBE NUTS HAVE A DRY-FILM LUBRICANT AND DO NOT NEED ADDITIONAL LUBRICATION.</p> <p>TO REDUCE CLAMP DISTORTION UPON INSTALLATION, APPLY Never-Seez NSBT-8N compound, D00006 (C1) TO BOLT HEAD SURFACE THAT COMES INTO CONTACT WITH THE CLAMP. APPLY TO BOLT HEAD ONLY. DO NOT APPLY TO BOLT THREADS.</p>		
C1	D00006	. NEVER-SEEZ NSBT-8N COMPOUND POSITION TUBE ASSY (5) ON ENGINE CORE, ALIGNING FORWARD END WITH UPPER UNION ON BLEED AIR REGULATOR. APPLY LIGHT COATING OF Never-Seez NSBT-8N compound, D00006 (C1) TO UNDERSIDE HEAD OF BOLTS (20). LOOSELY ATTACH TUBE ASSY (5) TO ENGINE CORE BRACKETS ON FLANGES B10 AND B11. USE CLAMPS (10), CLAMPSHELLS (15) AND BOLTS (20).	CON	AR
5	332A2350-5	. TUBE ASSY		1
10	1794M49P01	. CLAMP (V96941)	VEN	2
15	BACC10GT2-04	. CLAMPSHELL		4
15	9352M41P16	. CLAMPSHELL (V83930) (OPTIONAL)	OPT	-
20	BACB30ZF4-07	. BOLT		2
C1	D00006	. NEVER-SEEZ NSBT-8N COMPOUND ADJUST TUBE ASSY (5) TO BEST POSITION, ENSURING NO PRELOAD EXISTS ON TUBE. TIGHTEN TUBE NUT AT BLEED AIR REGULATOR TO 133-147 POUND-INCHES (15.0-16.6 NEWTON METERS). BACK OFF TUBE NUT TO RELAX TORQUE, THEN RETIGHTEN. TIGHTEN BOLTS (20) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS).	CON	AR

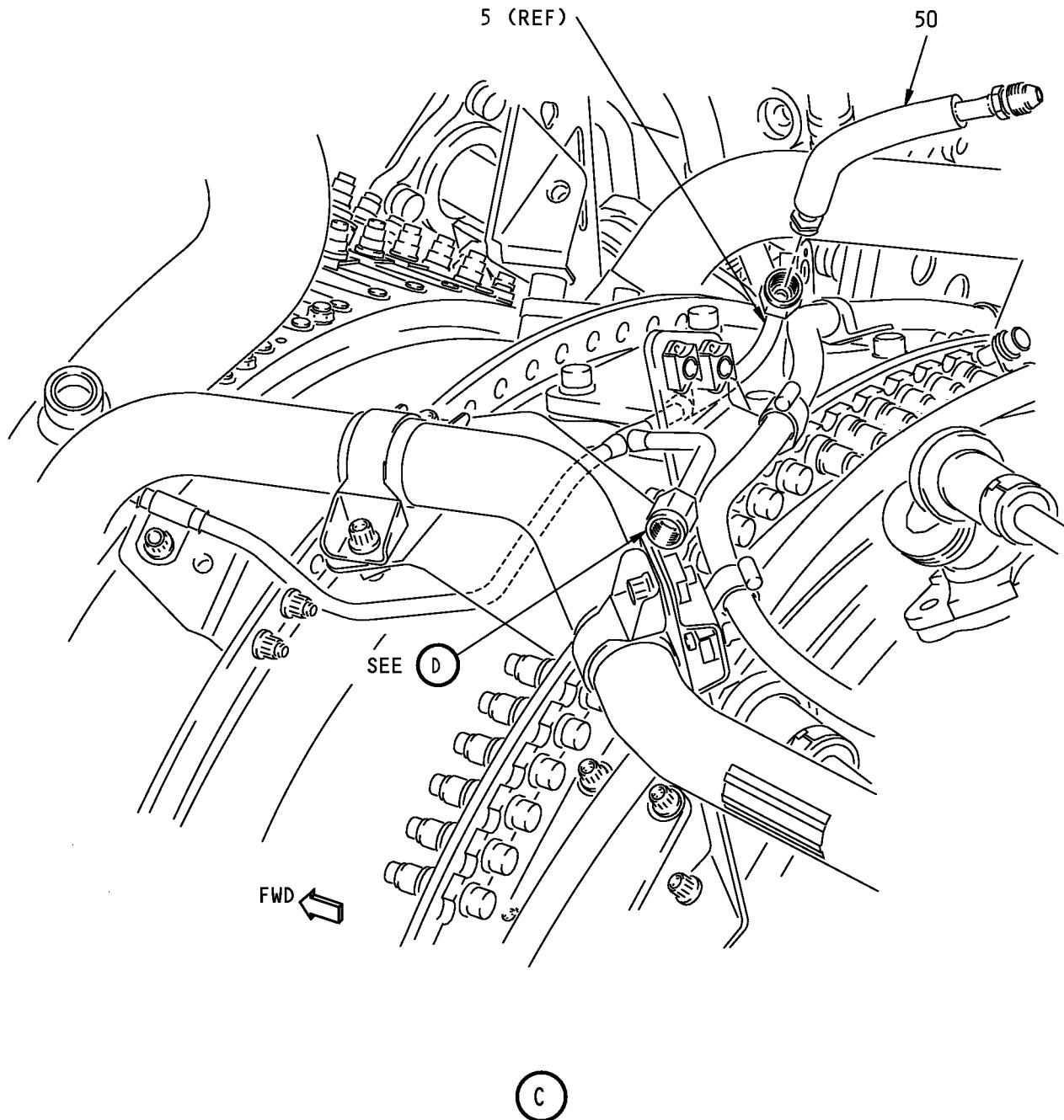
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P/P BUILDUP FIGURE 17-1

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POWERPLANT BUILDUP MANUALUpper Bleed Control System Installation
Figure 17-1 (Sheet 2)**71-00-02**

P/P BUILDUP FIGURE 17-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
17-1 50	16135-80	<p>UPPER BLEED CONTROL SYSTEM INSTALLATION (FIGURE 17-1, SHEET 2)</p> <p>INSTALL HOSE ASSY (50) ON END OF TUBE ASSY (5). . HOSE ASSY (V99755) (SPEC 60B90135-80)</p> <p>TIGHTEN TUBE NUT ON HOSE ASSY (50) TO 133-147 POUND-INCHES (15.0-16.6 NEWTON METERS). BACK OFF TUBE NUT TO RELAX TORQUE, THEN RETIGHTEN.</p> <p>MAKE SURE PROTECTIVE CAP IS INSTALLED ON END OF HOSE ASSY (50).</p>	VEN	1

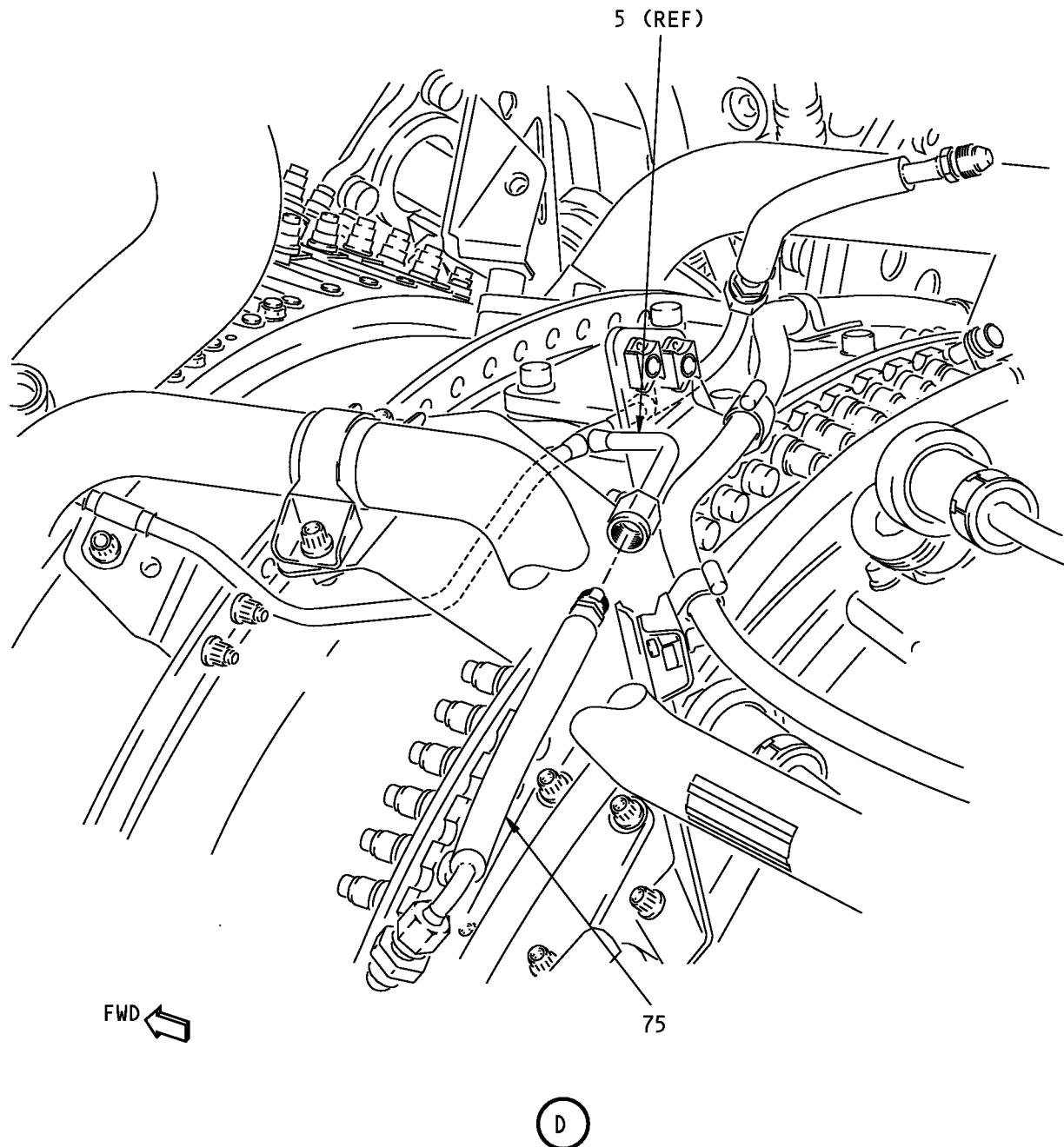
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P/P BUILDUP FIGURE 17-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
17-1		UPPER BLEED CONTROL SYSTEM INSTALLATION (FIGURE 17-1, SHEET 3) LOOSELY INSTALL HOSE ASSY (75) TO TUBE ASSY (5). NOTE: DO NOT TIGHTEN HOSE ASSY (75) AT THIS TIME. HOSE WILL BE TIGHTENED DURING THE PRSOV INSTALLATION (REF BLEED DUCT INSTALLATION - UPPER 5TH- AND 9TH-STAGE/Figure 18-1).		
75	16135-96	. HOSE ASSY (V99755) (SPEC 60B90135-96)	VEN	1
75	16135-83	. HOSE ASSY (V99755) (SPEC 60B90135-83) (OPTIONAL TO 16135-96) MAKE SURE PROTECTIVE CAP IS INSTALLED ON END OF HOSE ASSY (75).	OPT	-

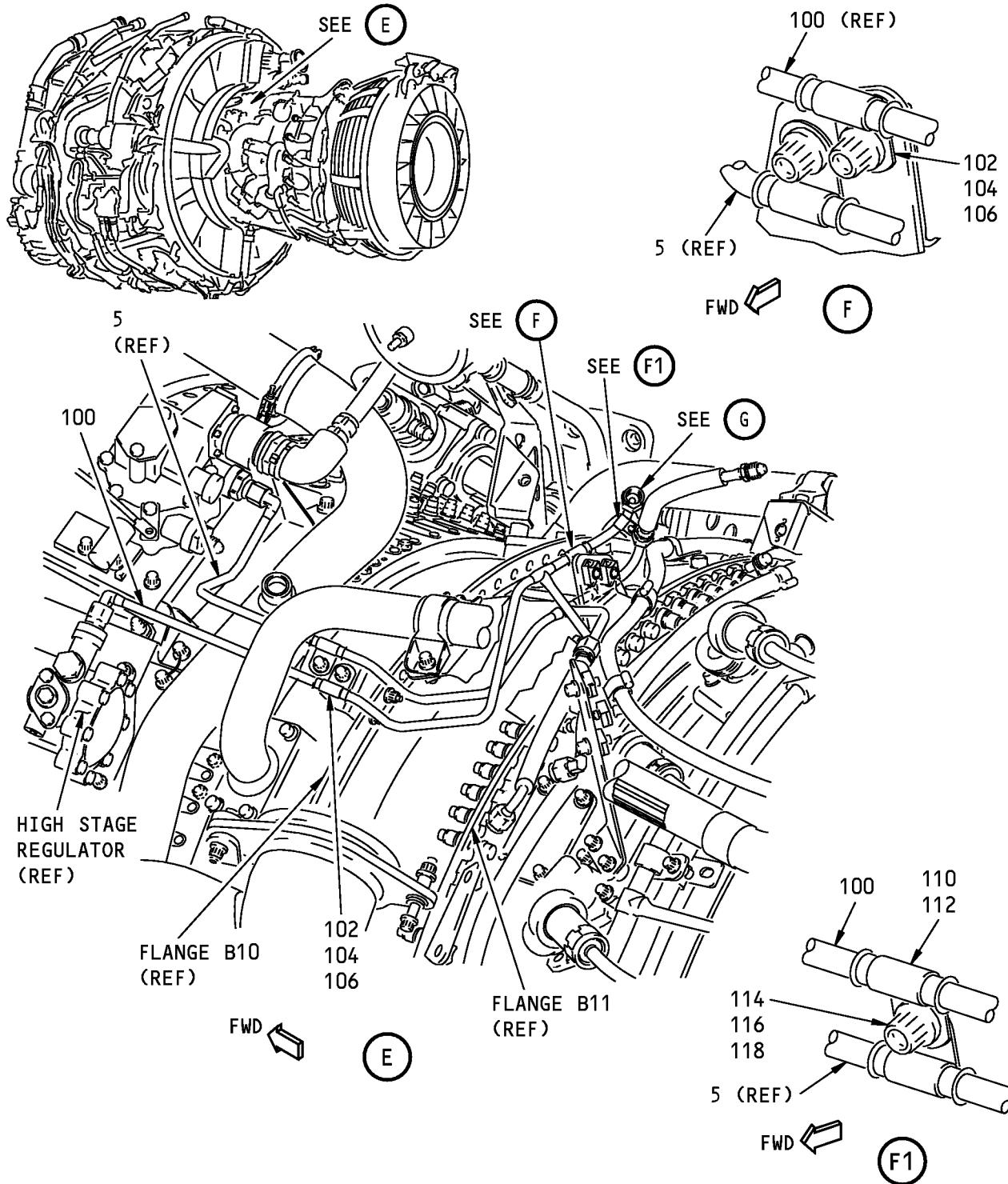
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P/P BUILDUP FIGURE 17-1

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Upper Bleed Control System Installation
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P/P BUILDUP FIGURE 17-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
17-1		UPPER BLEED CONTROL SYSTEM INSTALLATION (FIGURE 17-1, SHEET 4) POSITION TUBE ASSY (100) ON ENGINE CORE, ALIGNING FORWARD END WITH TOP UNION ON HIGH STAGE REGULATOR. APPLY LIGHT COATING OF Never-Seez NSBT-8N compound, D00006 (C1) TO UNDERSIDE HEAD OF BOLTS (106). LOOSELY ATTACH TUBE ASSY (100) TO ENGINE CORE BRACKETS ON FLANGES B10 AND B11. USE CLAMPS (102), CLAMPSHELLS (104) AND BOLTS (106).		
100	332A2350-7	. TUBE ASSY		1
102	1794M49P01	. CLAMP (V96941)	VEN	2
104	BACC10GT2-04	. CLAMPSHELL		4
104	9352M41P16	. CLAMPSHELL (V83930) (OPTIONAL)	OPT	-
106	BACB30ZF4-07	. BOLT		2
C1	D00006	. NEVER-SEEZ NSBT-8N COMPOUND	CON	AR
		ADJUST TUBE ASSY (100) TO BEST POSITION, ENSURING NO PRELOAD EXISTS ON TUBE. TIGHTEN TUBE NUT AT HIGH STAGE REGULATOR TO 133-147 POUND-INCHES (15.0-16.6 NEWTON METERS). BACK OFF TUBE NUT TO RELAX TORQUE, THEN RETIGHTEN.		
		TIGHTEN BOLTS (106) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS).		
		APPLY LIGHT COATING OF Never-Seez NSBT-8N compound, D00006 (C1) TO UNDERSIDE HEAD OF BOLT (114). ON AFT END OF TUBE ASSEMBLIES (5) AND (100), LOOSELY ATTACH CLAMP (110), CLAMPSHELLS (112), BOLT (114), WASHER (116) AND NUT, SELF-LOCK (118) TO TUBE ASSEMBLIES (5) AND (100).		
110	1794M49P01	. CLAMP (V96941)	VEN	2
112	BACC10GT2-04	. CLAMPSHELL		4
112	9352M41P16	. CLAMPSHELL (V83930) (OPTIONAL)	OPT	-
114	BACB30ZF4-07	. BOLT		1
116	NAS1149C0432R	. WASHER		1
118	AS3485-10	. NUT, SELF-LOCK		1
C1	D00006	. NEVER-SEEZ NSBT-8N COMPOUND	CON	AR
		TIGHTEN BOLT (114) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS).		

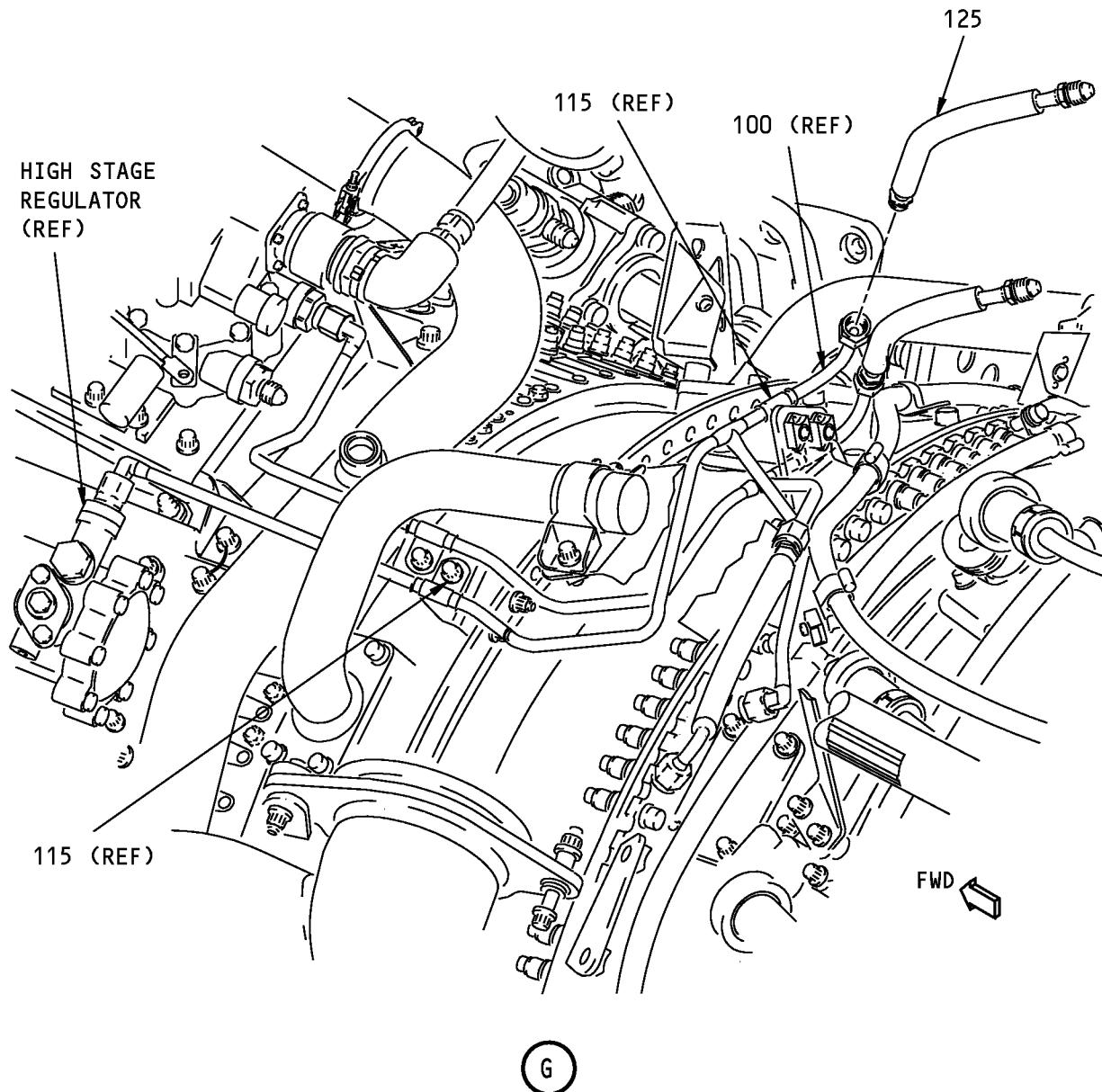
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P/P BUILDUP FIGURE 17-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
17-1 125	16135-81	<p>UPPER BLEED CONTROL SYSTEM INSTALLATION (FIGURE 17-1, SHEET 5)</p> <p>INSTALL HOSE ASSY (125) ON END OF TUBE ASSY (100). . HOSE ASSY (V99755) (SPEC 60B90135-81)</p> <p>TIGHTEN TUBE NUT ON HOSE ASSY TO 133-147 POUND-INCHES (15.0-16.6 NEWTON METERS). BACK OFF TUBE NUT TO RELAX TORQUE, THEN RETIGHTEN.</p> <p>MAKE SURE PROTECTIVE CAP IS INSTALLED ON END OF HOSE ASSY (125).</p>	VEN	1

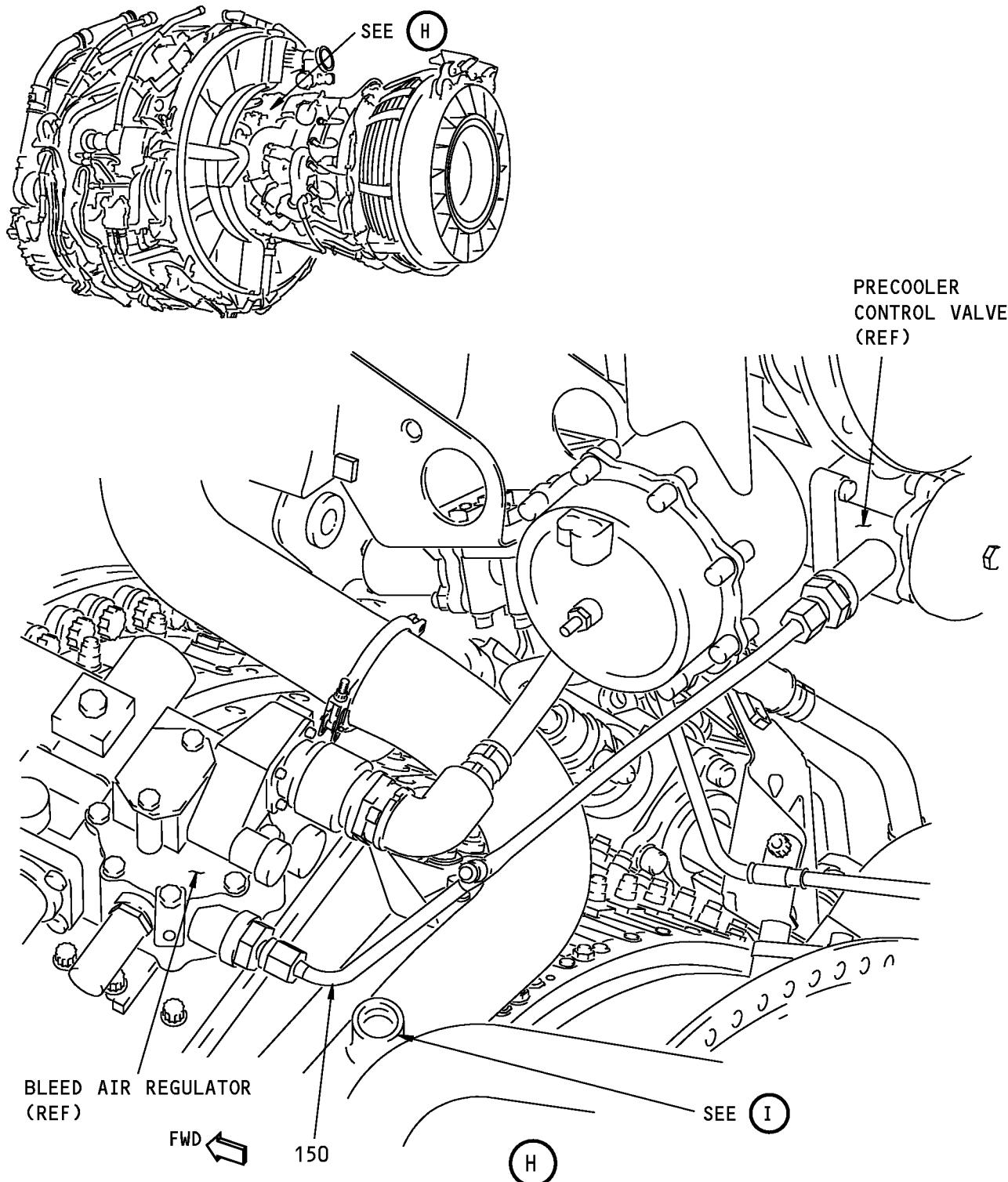
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P/P BUILDUP FIGURE 17-1

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POWERPLANT BUILDUP MANUALUpper Bleed Control System Installation
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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
17-1 150	332A2350-14	<p>UPPER BLEED CONTROL SYSTEM INSTALLATION (FIGURE 17-1, SHEET 6)</p> <p>LOOSELY INSTALL TUBE ASSY (150) BETWEEN UNIONS ON BLEED AIR REGULATOR AND PRECOOLER CONTROL VALVE.</p> <p>NOTE: DO NOT TIGHTEN TUBE ASSY (150) AT THIS TIME.</p> <p>. TUBE ASSY</p>		1

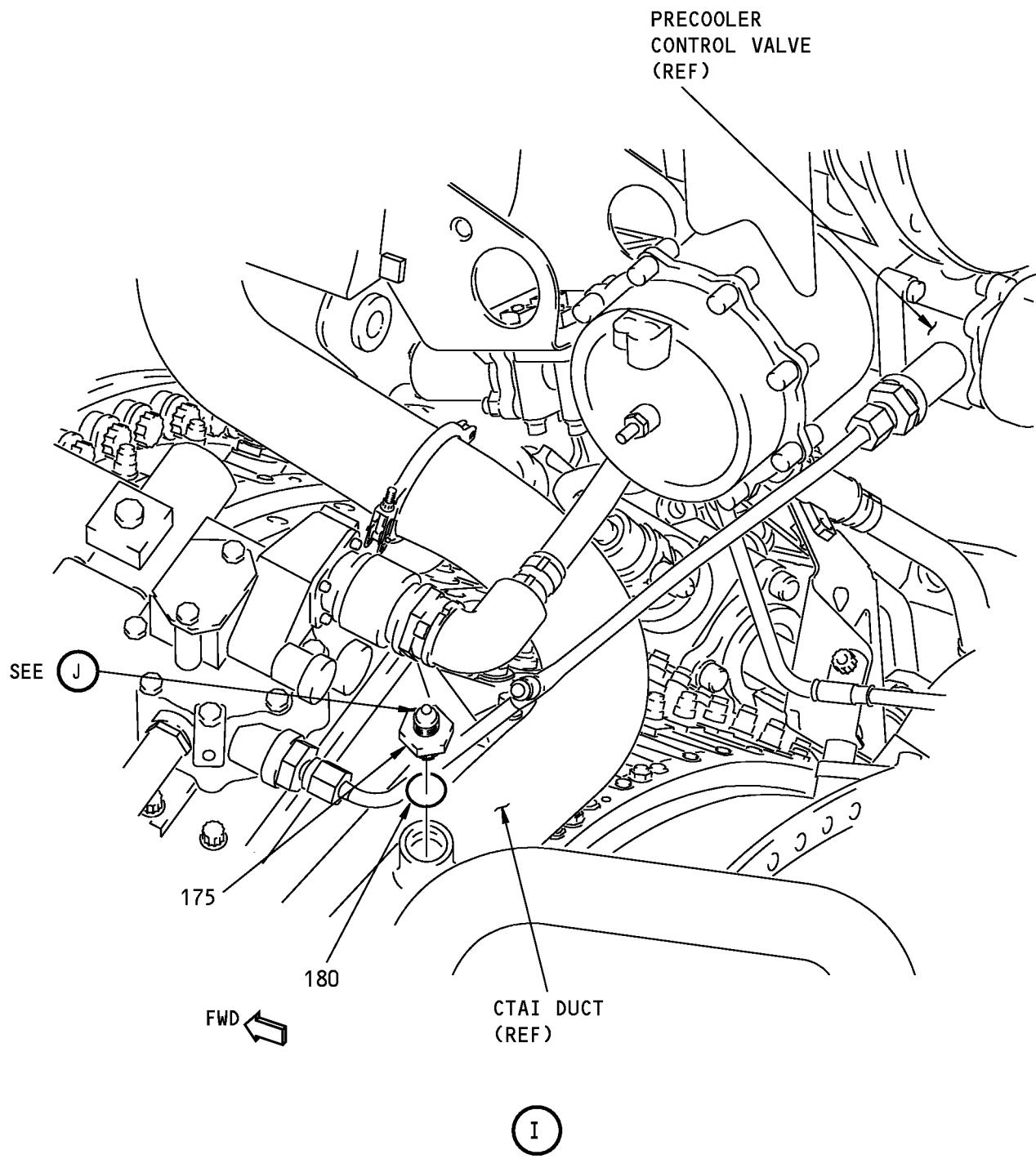
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P/P BUILDUP FIGURE 17-1

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Figure 17-1 (Sheet 7)

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P/P BUILDUP FIGURE 17-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
17-1		UPPER BLEED CONTROL SYSTEM INSTALLATION (FIGURE 17-1, SHEET 7) INSTALL O-RING (180) ON REDUCER (175). LUBRICATE THREADS ON O-RING SIDE OF REDUCER (175) WITH Never-Seez NSBT-8N compound, D00006 (C1) AND INSTALL ON CTAI DUCT.		
175	J522P53	. REDUCER (V90806)	VEN	1
180	801A50-0006-A	. O-RING (V15284)	VEN	1
180	801A50-0006A	. O-RING (V15284) (OPTIONAL TO 801A50-0006-A)	OPT	-
C1	D00006	. NEVER-SEEZ NSBT-8N COMPOUND	CON	AR
		TIGHTEN REDUCER (175) TO 258-284 POUND-INCHES (29-32 NEWTON METERS).		

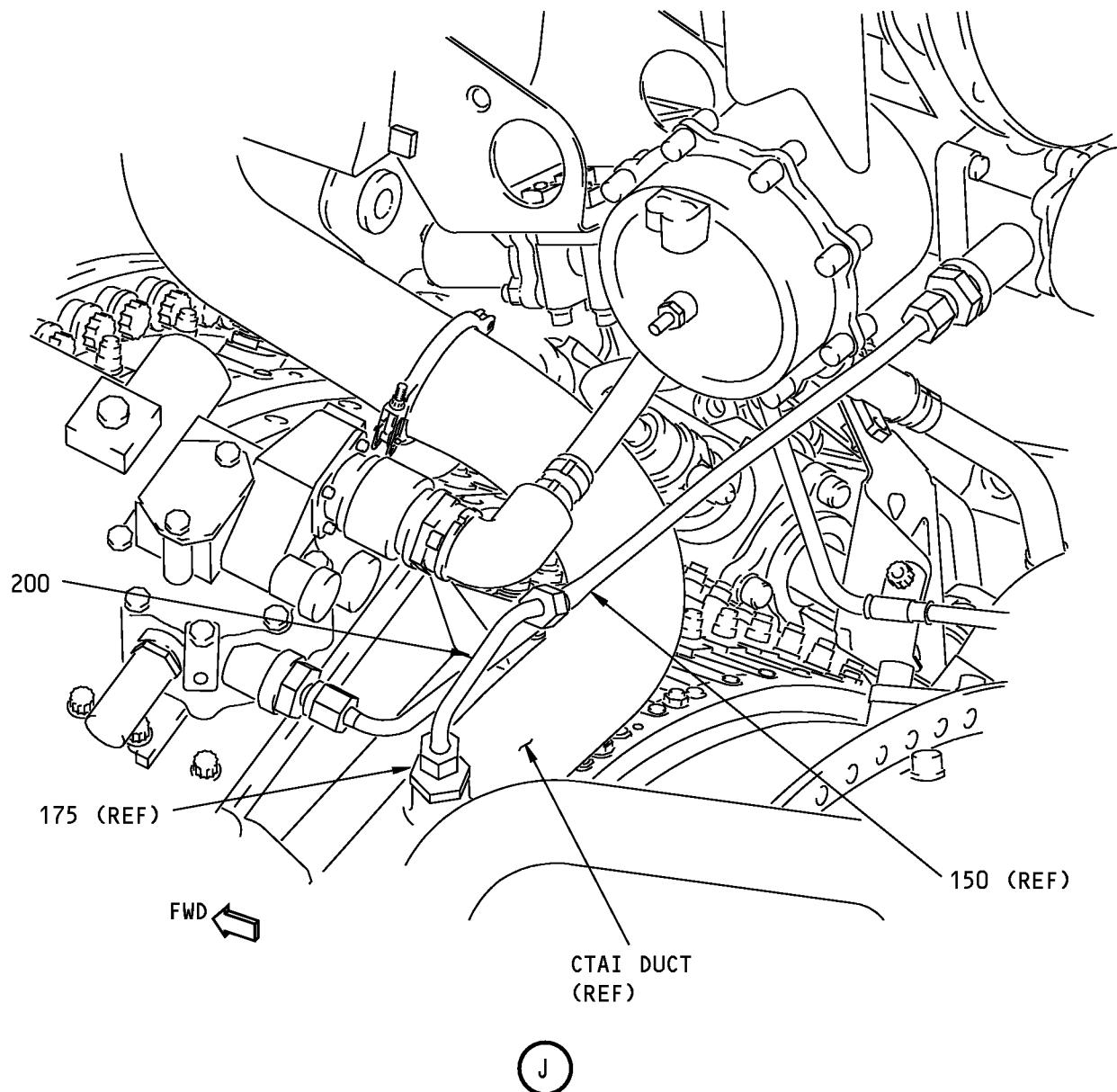
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P/P BUILDUP FIGURE 17-1

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POWERPLANT BUILDUP MANUALUpper Bleed Control System Installation
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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
17-1 200	332A2350-12	<p>UPPER BLEED CONTROL SYSTEM INSTALLATION (FIGURE 17-1, SHEET 8)</p> <p>INSTALL TUBE ASSY (200) BETWEEN TUBE ASSY (150) AND UNION (175) ON CTAI DUCT.</p> <p>NOTE: LONGER LEG OF TUBE ASSY (200) WITH 80 DEGREE BEND MATES TO TUBE ASSY (150).</p> <p>. TUBE ASSY</p> <p>ADJUST TUBE ASSY (150) AND (200) TO BEST POSITION, ENSURING NO PRELOAD EXISTS ON TUBES, BLEED AIR REGULATOR, PRECOOLER CONTROL VALVE AND CTAI DUCT.</p> <p>TIGHTEN TUBE ASSY (150) AND (200) TO 133-147 POUND-INCHES (15.0-16.6 NEWTON METERS). BACK OFF TUBE NUT TO RELAX TORQUE, THEN RETIGHTEN.</p>		1

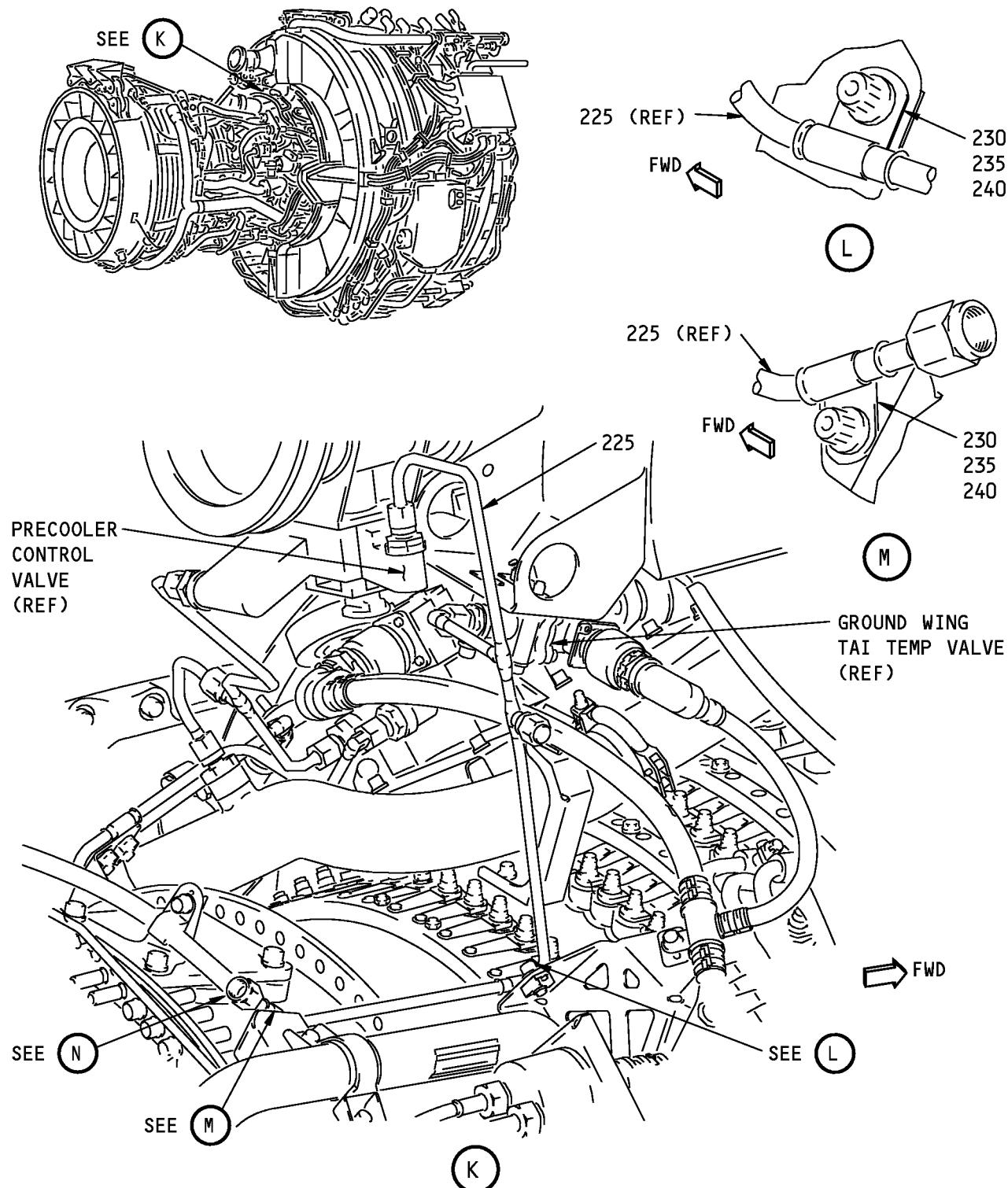
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P/P BUILDUP FIGURE 17-1

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POWERPLANT BUILDUP MANUALUpper Bleed Control System Installation
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P/P BUILDUP FIGURE 17-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
17-1		UPPER BLEED CONTROL SYSTEM INSTALLATION (FIGURE 17-1, SHEET 9) APPLY Never-Seez NSBT-8N compound, D00006 (C1) TO UNDERSIDE OF HEAD AND THREADS OF BOLTS (240). LOOSELY INSTALL TUBE ASSY (225) ON ENGINE CORE, ALIGNING FORWARD END WITH UNION ON RIGHT SIDE OF PRECOOLER CONTROL VALVE AND UNION ON GROUND WING TAI TEMP VALVE. LOOSELY ATTACH TUBE ASSY (225) TO ENGINE CORE BRACKETS AT 1 O'CLOCK POSITION. USE CLAMPS (230), CLAMPSHELLS (235) AND BOLTS (240).		
225	332A2350-13	. TUBE ASSY	VEN	1
230	1794M49P01	. CLAMP (V96941)	VEN	2
235	BACC10GT2-04	. CLAMPSHELL		4
235	9352M41P16	. CLAMPSHELL (V83930) (OPTIONAL)	OPT	-
240	BACB30ZF4-05	. BOLT		2
C1	D00006	. NEVER-SEEZ NSBT-8N COMPOUND ADJUST TUBE ASSY (225) TO BEST POSITION, ENSURING NO PRELOAD EXISTS. TIGHTEN TUBE ASSY (225) TO 133-147 POUND-INCHES (15.0-16.6 NEWTON METER). BACK OFF TUBE NUT TO RELAX TORQUE, THEN RETIGHTEN. TIGHTEN PRECOOLER CONTROL VALVE COUPLING (REF BLEED CONTROLLER INSTALLATION/Figure 14-1 ITEM NO. 120) TO TORQUE GIVEN ON PART. LIGHTLY TAP OUTER SURFACE WITH NON-METALLIC MALLET. RETIGHTEN COUPLING TO TORQUE GIVEN ON PART. TIGHTEN BOLTS (240) TO 61-71 POUND-INCHES (6.9-8.0 NEWTON METERS).	CON	AR

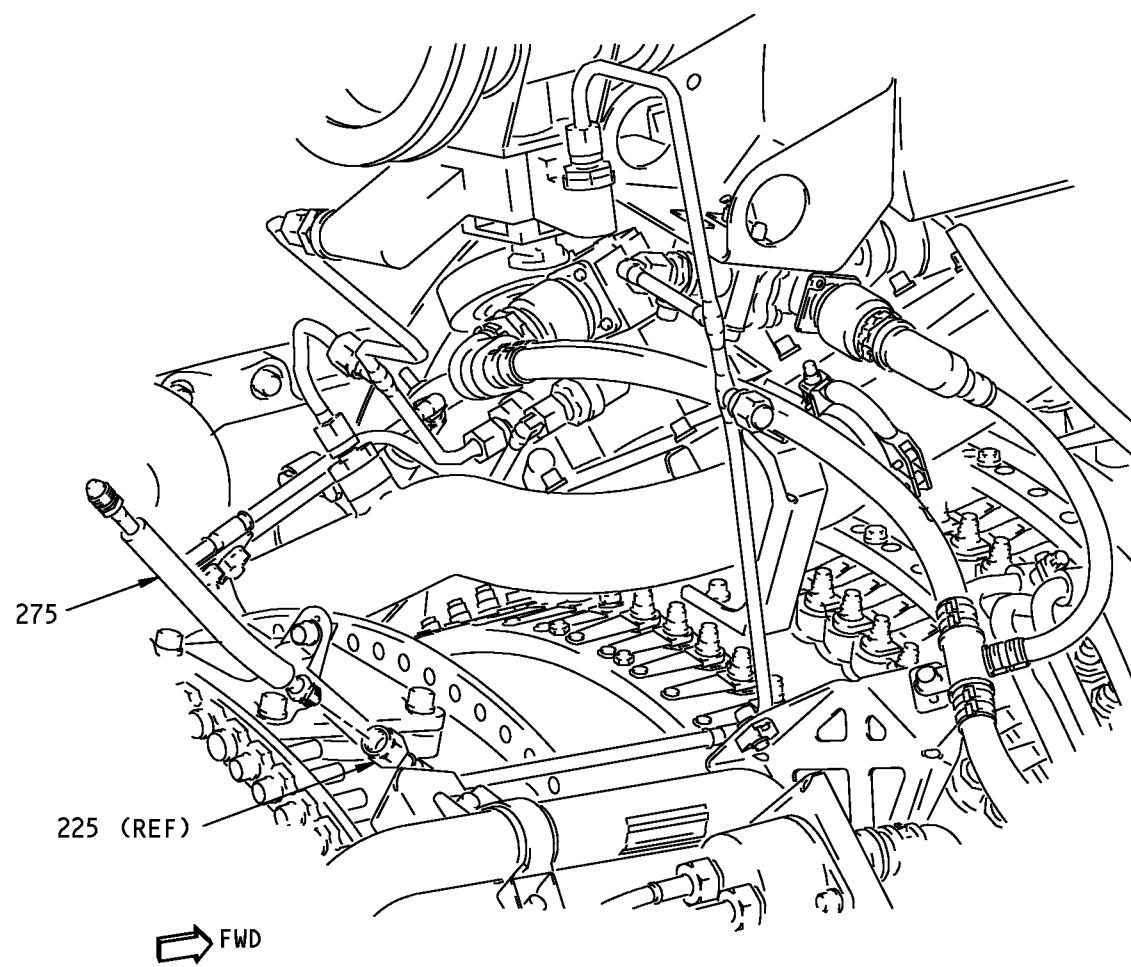
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P/P BUILDUP FIGURE 17-1

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POWERPLANT BUILDUP MANUAL

Upper Bleed Control System Installation
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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
17-1 275	16135-80	<p>UPPER BLEED CONTROL SYSTEM INSTALLATION (FIGURE 17-1, SHEET 10)</p> <p>INSTALL HOSE ASSY (275) ON END OF TUBE ASSY (225). . HOSE ASSY (V99755) (SPEC 60B90135-80)</p> <p>TIGHTEN TUBE NUT ON HOSE ASSY (275) TO 133-147 POUND-INCHES (15.0-16.6 NEWTON METERS). BACK OFF TUBE NUT TO RELAX TORQUE, THEN RETIGHTEN.</p> <p>MAKE SURE PROTECTIVE CAP IS INSTALLED ON END OF HOSE ASSY (275).</p>	VEN	1

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P/P BUILDUP FIGURE 17-1

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FIGURE 18-1

**BLEED DUCT INSTALLATION - UPPER 5TH-
AND 9TH-STAGE**

REF QEC TASK NO.: 18

**REF DWG: 332A2100
332A2300**

NOTE: ALL STANDARDS AND ATTACHING HARDWARE FOR THIS FIGURE WILL BE PACKAGED
IN QEC TASK NO. 110.

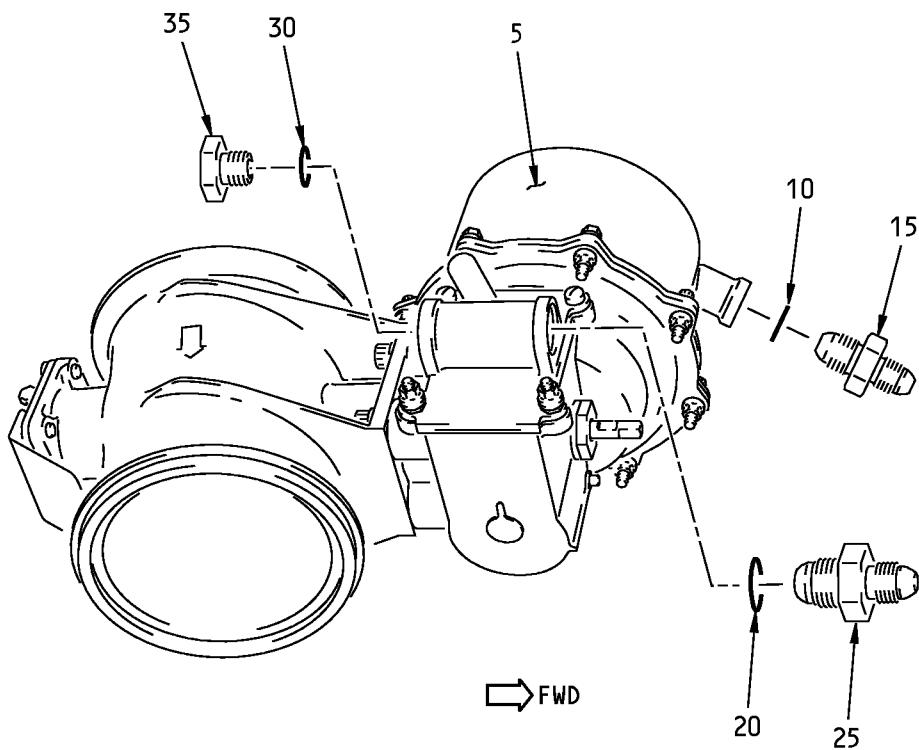
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P/P BUILDUP FIGURE 18-1

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POWERPLANT BUILDUP MANUAL

Upper 5th- and 9th-Stage Bleed Duct Installation
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P/P BUILDUP FIGURE 18-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
18-1		UPPER 5TH- AND 9TH-STAGE BLEED DUCT INSTALLATION (FIGURE 18-1, SHEET 1) INSTALL O-RING (10) ON REDUCER (15), O-RING (20) ON REDUCER (25) AND O-RING (30) ON PLUG (35). LUBRICATE THREADS OF REDUCERS (15) AND (25) AND PLUG (35) WITH Never-Seez NSBT-8N compound, D00006 (C1). INSTALL REDUCER (15) ON AFT PORT OF PRSOV (5). INSTALL REDUCER (25) ON OUTBOARD PORT OF VALVE BODY AND PLUG (35) IN INBOARD PORT OF VALVE BODY.		
5	3214552-6	. PRESS REG AND SHUTOFF VALVE (PRSOV) (V59364) (SPEC 10-62008-43) . O-RING (V15284)	VEN	1
10	801A50-0005-A	. O-RING (V15284) (OPTIONAL TO 801A50-0005-A)	VEN	1
10	801A50-0005A	. O-RING (V15284) (OPTIONAL TO 801A50-0005-A)	OPT	-
15	J522P52	. REDUCER (V96941)	VEN	1
20	801A50-0006-A	. O-RING (V15284)	VEN	1
20	801A50-0006A	. O-RING (V15284) (OPTIONAL TO 801A50-0006-A)	OPT	-
25	J522P53	. REDUCER (V90806)	VEN	1
30	801A50-0006-A	. O-RING (V15284)	VEN	1
30	801A50-0006A	. O-RING (V15284) (OPTIONAL TO 801A50-0006-A)	OPT	-
35	AS5169J06	. PLUG		1
C1	D00006	. NEVER-SEEZ NSBT-8N COMPOUND TIGHTEN REDUCER (15) TO 180-200 POUND-INCHES (20-23 NEWTON METERS). TIGHTEN REDUCER (25) AND PLUG (35) TO 257-284 POUND-INCHES (29-32 NEWTON METERS).	CON	AR

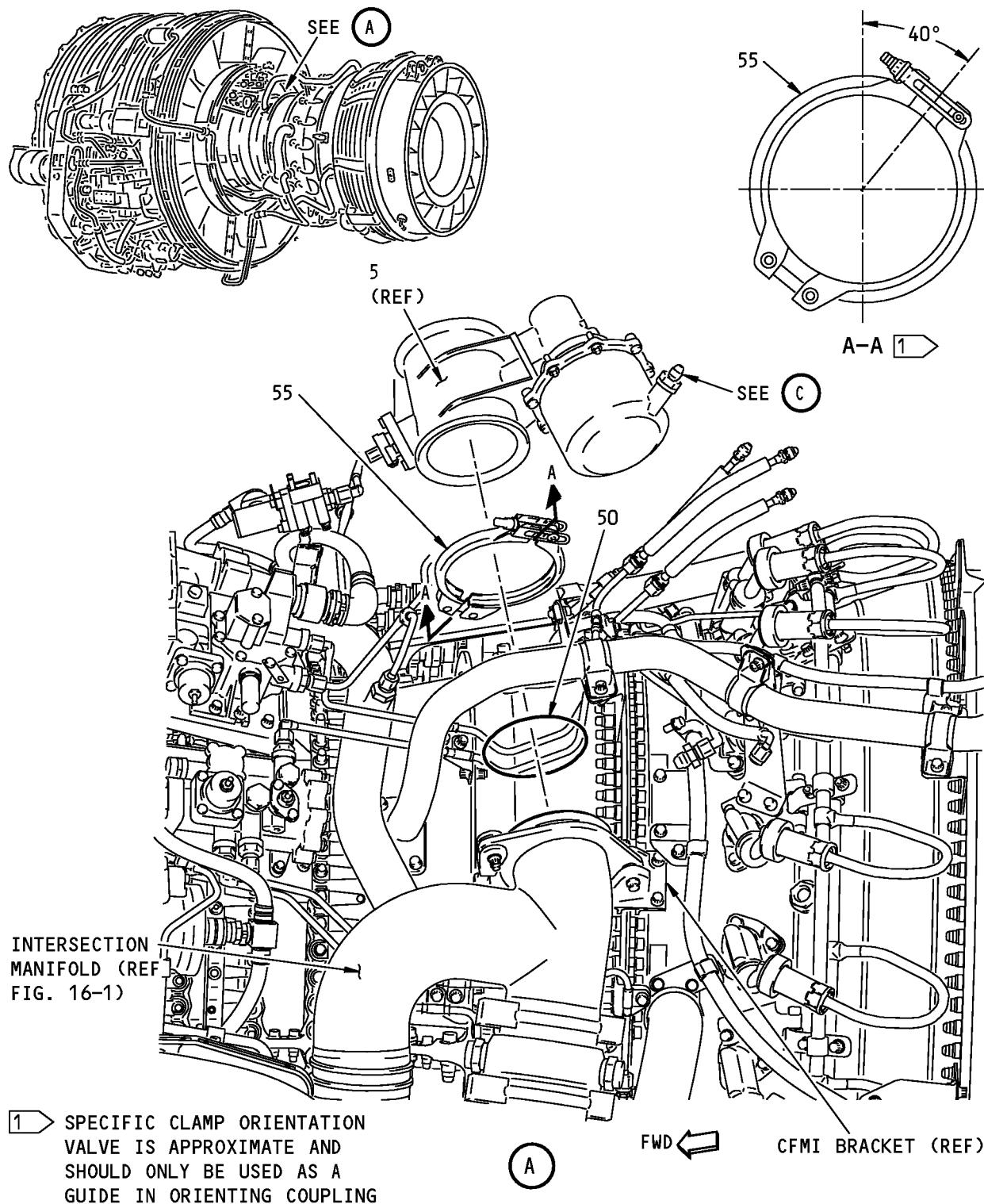
71-00-02

P/P BUILDUP FIGURE 18-1

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POWERPLANT BUILDUP MANUALUpper 5th- and 9th-Stage Bleed Duct Installation
Figure 18-1 (Sheet 2)

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P/P BUILDUP FIGURE 18-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
18-1		<p>UPPER 5TH- AND 9TH-STAGE BLEED DUCT INSTALLATION (FIGURE 18-1, SHEET 2)</p> <p>NOTE: ALL DUCT COUPLINGS HAVE A DRY-FILM LUBRICANT. DO NOT APPLY ANY ADDITIONAL LUBRICANT. VISUALLY EXAMINE ALL SEAL AND FLANGE SEALING SURFACES BEFORE INSTALLATION TO ENSURE NO SCRATCHES, CUTS, PITS, OR FOREIGN MATERIAL IS PRESENT.</p> <p>LOOSELY ATTACH PRSOV (5) TO TOP PORT OF INTERSECTION MANIFOLD WITH SEAL (50) AND COUPLING (55).</p> <p>ORIENT COUPLING (55) AS SHOWN.</p> <p>NOTE: FINAL ORIENTATION OF PRSOV IS DETERMINED BY BLEED CONTROL LINES.</p>		
50	AS1895-7-350	. SEAL		1
50	AS1895/7-350	. SEAL (OPTIONAL TO AS1895-7-350)	OPT	-
55	AS1895-1-350	. COUPLING		1
55	AS1895/1-350	. COUPLING (OPTIONAL TO AS1895-1-350)	OPT	-
		<p>NOTE: CFMI BRACKET (REF) MAY BE LOOSENED TO ALLOW COUPLING (55) TO BE INSTALLED OVER VALVE (5). RETIGHTEN CFMI FASTENERS TO 209-231 POUND-INCHES (23.6-26.1 NEWTON METERS).</p>		

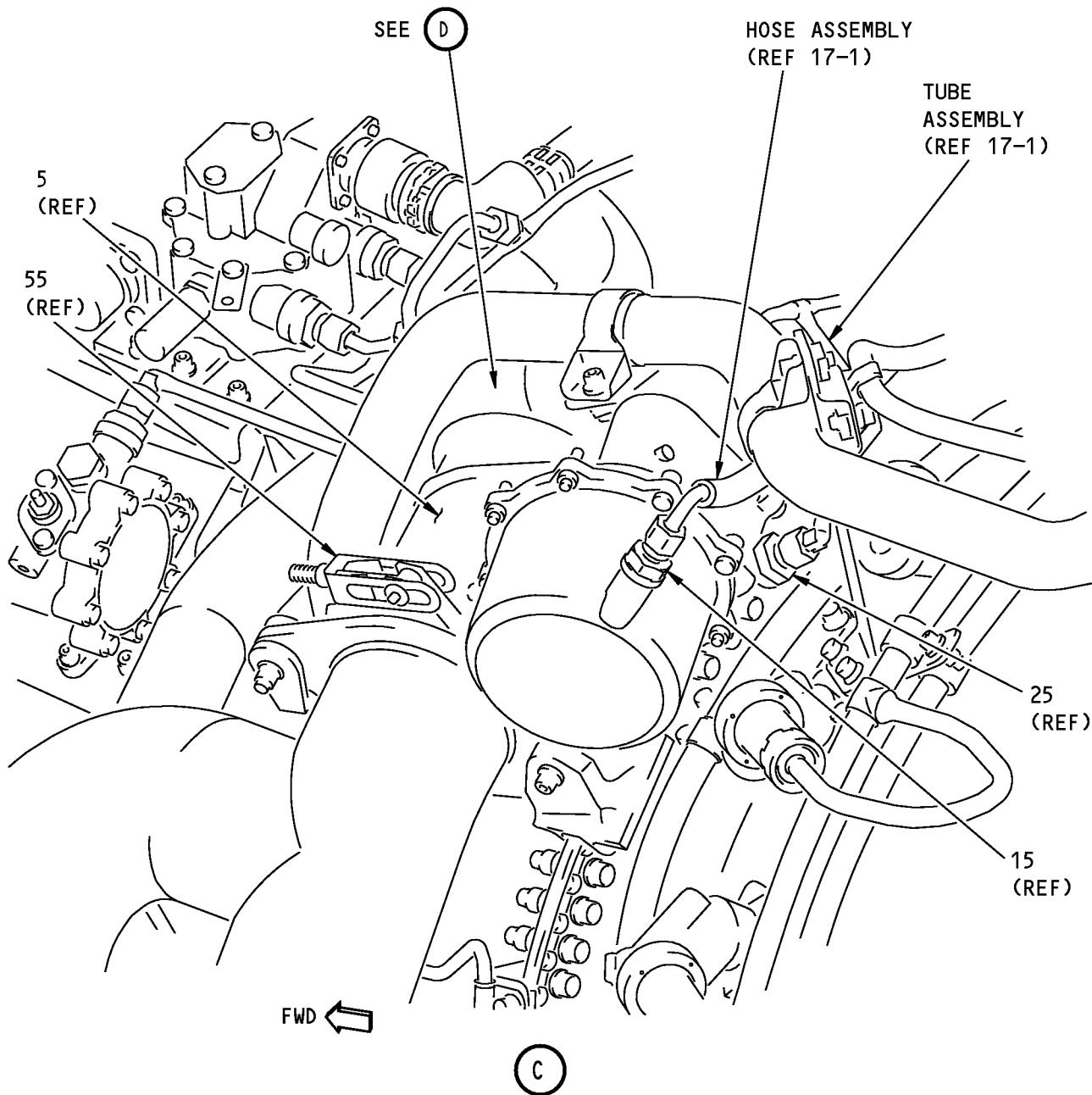
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P/P BUILDUP FIGURE 18-1

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POWERPLANT BUILDUP MANUAL

Upper 5th- and 9th-Stage Bleed Duct Installation
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P/P BUILDUP FIGURE 18-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
18-1		<p>UPPER 5TH- AND 9TH-STAGE BLEED DUCT INSTALLATION (FIGURE 18-1, SHEET 3)</p> <p>CAUTION: MAKE SURE NO PRELOAD EXISTS BETWEEN PRSOV AND BLEED CONTROL LINES.</p> <p>ATTACH TUBE ASSY BLEED CONTROL SYSTEM INSTALLATION - UPPER/Figure 17-1 TO REDUCER (25) AND ATTACH HOSE ASSY BLEED CONTROL SYSTEM INSTALLATION - UPPER/Figure 17-1 TO REDUCER (15).</p> <p>USE TUBE AND HOSE ASSYS TO ORIENT PRSOV (5).</p> <p>TIGHTEN COUPLING (55) TO TORQUE SPECIFIED ON PART. LIGHTLY TAP SURFACE OF COUPLING WITH NON-METALLIC MALLET.</p> <p>RETIGHTEN COUPLING TO TORQUE SPECIFIED ON PART.</p>		

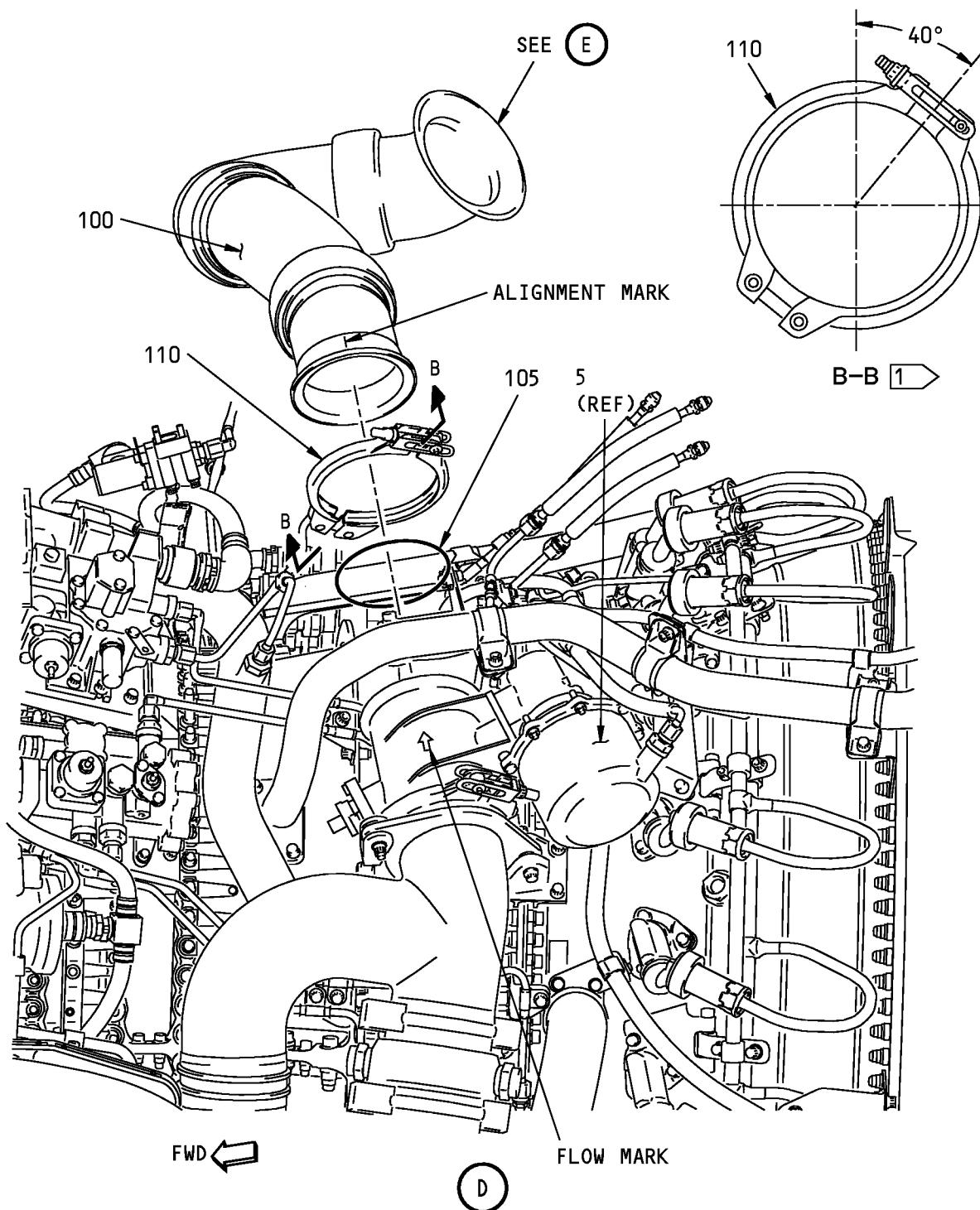
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P/P BUILDUP FIGURE 18-1

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POWERPLANT BUILDUP MANUAL

Upper 5th- and 9th-Stage Bleed Duct Installation
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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
18-1		<p>UPPER 5TH- AND 9TH-STAGE BLEED DUCT INSTALLATION (FIGURE 18-1, SHEET 4)</p> <p>LOOSELY ATTACH DUCT ASSY (100) TO TOP OF PRSOV (5) WITH SEAL (105) AND COUPLING (110).</p> <p>MAKE SURE ALIGNMENT MARK ON DUCT ASSY (100) ALIGNS WITH FLOW ARROW ON PRSOV (5).</p> <p>ORIENT COUPLING (110) AS SHOWN.</p> <p>NOTE: IT WILL BE NECESSARY TO ADJUST THE DUCT ASSY FOR PROPER ALIGNMENT WITH THE PRECOOLER DURING ENGINE INSTALLATION.</p>		
100	332A2326-45	. DUCT ASSY		1
105	AS1895-7-350	. SEAL		1
105	AS1895/7-350	. SEAL (OPTIONAL TO AS1895-7-350)	OPT	-
110	AS1895-1-350	. COUPLING		1
110	AS1895/1-350	. COUPLING (OPTIONAL TO AS1895-1-350)	OPT	-
		<p>TIGHTEN COUPLING (110) TO TORQUE SPECIFIED ON PART.</p> <p>LIGHTLY TAP SURFACE OF COUPLING WITH NON-METALLIC MALLET.</p> <p>RETIGHTEN COUPLING TO TORQUE SPECIFIED ON PART.</p>		

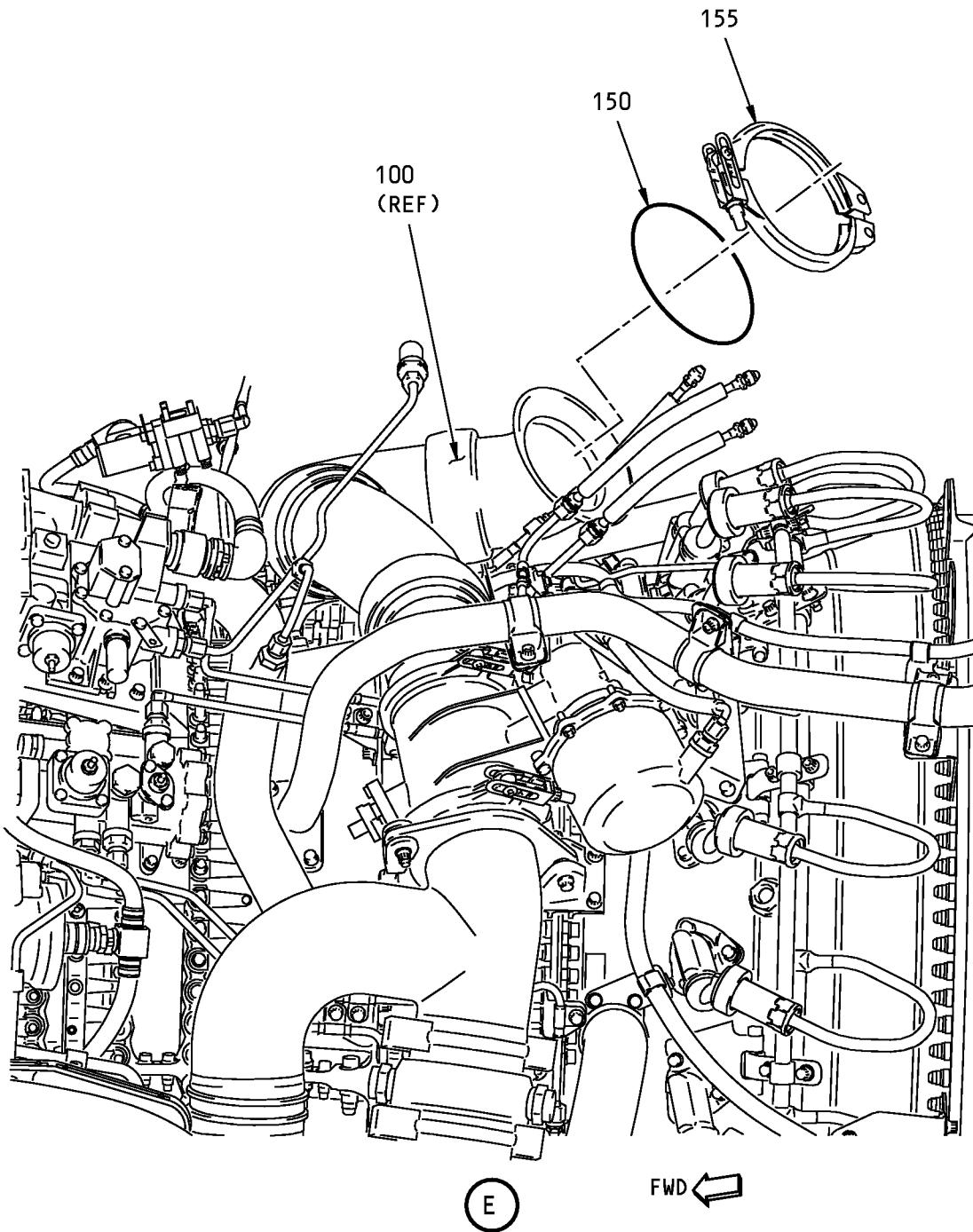
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P/P BUILDUP FIGURE 18-1

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POWERPLANT BUILDUP MANUALUpper 5th- and 9th-Stage Bleed Duct Installation
Figure 18-1 (Sheet 5)**71-00-02**

P/P BUILDUP FIGURE 18-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
18-1		UPPER 5TH- AND 9TH-STAGE BLEED DUCT INSTALLATION (FIGURE 18-1, SHEET 5) PUT ITEMS (150) AND (155) IN A BAG AND SECURE TO DUCT ASSY (100). NOTE: ITEMS (150) AND (155) ARE INSTALLED DURING POWERPLANT INSTALLATION ON AIRPLANE STRUT (AMM PAGEBLOCK 71-00-02/401).		
150	AS1895-7-450	. SEAL		1
150	AS1895/7-450	. SEAL (OPTIONAL TO AS1895-7-450)	OPT	-
155	AS1895-4-450	. COUPLING		1
155	AS1895/4-450	. COUPLING (OPTIONAL TO AS1895-4-450)	OPT	-

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P/P BUILDUP FIGURE 18-1

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FIGURE 20-1

HYDRAULIC PUMP INSTALLATION
(VICKERS)

REF QEC TASK NO.: 20

REF DWG: 332A2400

NOTE: ALL STANDARDS AND ATTACHING HARDWARE FOR THIS FIGURE WILL BE PACKAGED IN QEC TASK NO. 110.

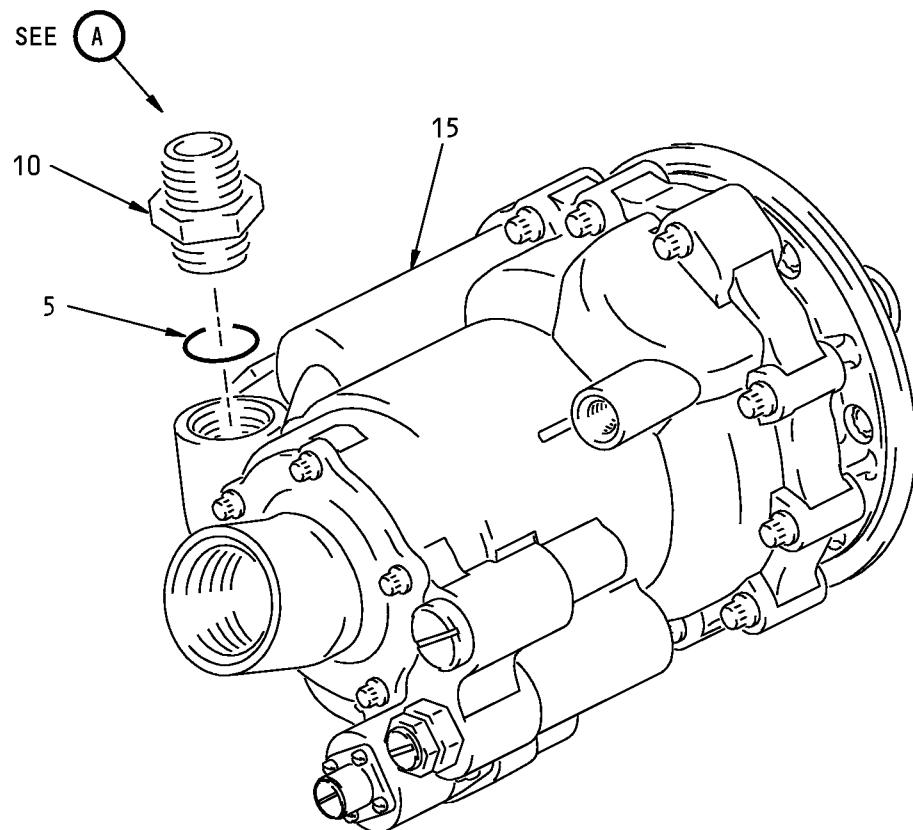
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P/P BUILDUP FIGURE 20-1

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POWERPLANT BUILDUP MANUAL

VICKERS HYDRAULIC PUMP

Hydraulic Pump Installation -
(VICKERS)
Figure 20-1 (Sheet 1)

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P/P BUILDUP FIGURE 20-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
20-1		<p>HYDRAULIC PUMP INSTALLATION - (VICKERS) (FIGURE 20-1, SHEET 1)</p> <p>WARNING: FIRE-RESISTANT HYDRAULIC FLUIDS CONFORMING TO BMS 3-11 (SKYDROL) MAY CAUSE SKIN IRRITATION. AVOID PROLONGED OR REPEATED CONTACT WITH SKIN. IN CASE OF EYE CONTACT, FLUSH EYES WITH WATER AND GET MEDICAL AID. IN CASE OF INGESTION, GET MEDICAL AID.</p> <p>LUBRICATE PACKING (5) AND THREADS OF UNION (10) WITH MCS 352B fluid, D00054 (C1).</p> <p>INSTALL PACKING (5) ON UNION (10) AND INSTALL UNION (10) TO PRESSURE PORT OF HYDRAULIC PUMP (15). TIGHTEN UNION (10) TO 428-473 POUND-INCHES (48.3-53.4 NEWTON METERS).</p>		
5	NAS1612-12A	. PACKING		1
10	AS5230T1212	. UNION		1
15	849589	. VICKERS HYDRAULIC PUMP (V62983) (SPEC 10-62167-3)	VEN	1
C1	D00054	. MCS 352B FLUID	CON	AR

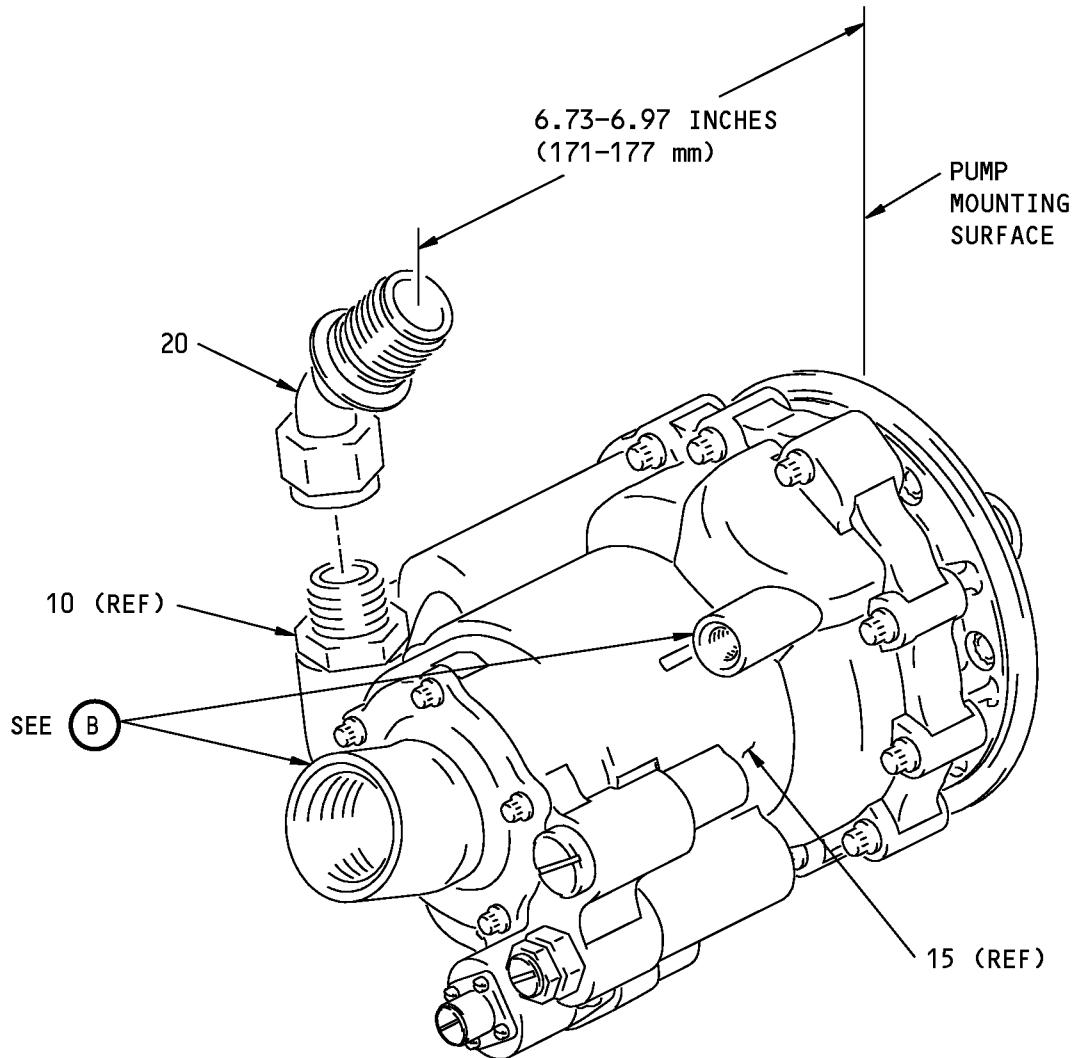
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P/P BUILDUP FIGURE 20-1

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POWERPLANT BUILDUP MANUAL

VICKERS HYDRAULIC PUMP

Hydraulic Pump Installation -
(VICKERS)
Figure 20-1 (Sheet 2)

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P/P BUILDUP FIGURE 20-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
20-1		HYDRAULIC PUMP INSTALLATION - (VICKERS) (FIGURE 20-1, SHEET 2)		
20	155012-73-20	LUBRICATE THREADS OF QUICK-RELEASE FITTING (20) WITH MCS 352B fluid, D00054 (C1) OR hydraulic fluid, D00153 (C2).	VEN	1
C1	D00054	. FITTING, QUICK RELEASE (V11362) (SPEC S332A210-20)	CON	AR
C2	D00153	. MCS 352B FLUID . HYDRAULIC FLUID	CON	AR
		LOOSELY ATTACH FITTING (20) TO UNION (10) AND ORIENT FITTING (20) UNTIL CENTER OF FITTING IS 6.73-6.97 INCHES (171-177 MM) FROM PUMP MOUNTING FACE.		
		TIGHTEN FITTING (20) TO 855-945 POUND-INCHES (96.6-106.8 NEWTON METERS). BACK OFF FITTING TO RELAX TORQUE, THEN RETIGHTEN.		
		RECHECK DISTANCE BETWEEN FITTING (20) AND PUMP MOUNTING FLANGE. IF OUTSIDE LIMIT, LOOSEN AND READJUST.		

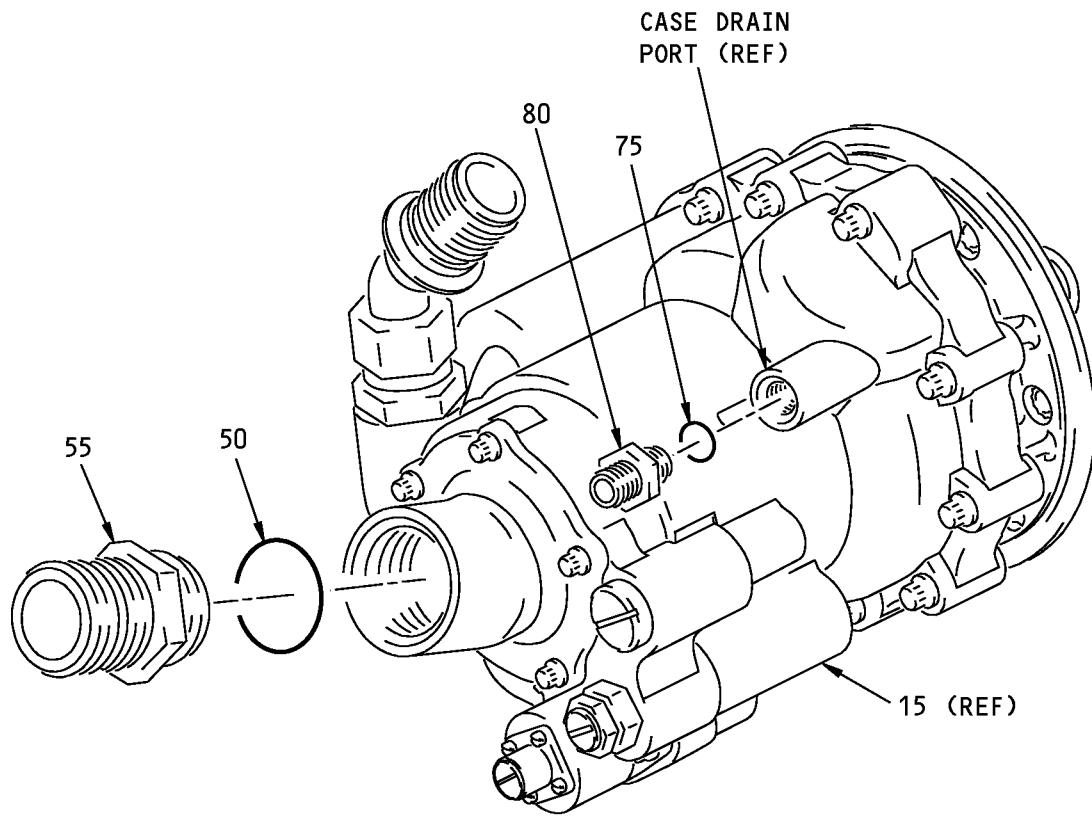
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P/P BUILDUP FIGURE 20-1

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POWERPLANT BUILDUP MANUAL

Hydraulic Pump Installation -
(VICKERS)
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P/P BUILDUP FIGURE 20-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
20-1		HYDRAULIC PUMP INSTALLATION - (VICKERS) (FIGURE 20-1, SHEET 3) LUBRICATE PACKING (50) AND THREADS OF UNION (55) WITH MCS 352B fluid, D00054 (C1). INSTALL PACKING (50) ON UNION (55) AND INSTALL UNION (55) TO HYDRAULIC SUPPLY PORT OF HYDRAULIC PUMP (15). TIGHTEN UNION (55) TO 855-945 POUND-INCHES (96.6-106.8 NEWTON METERS). NOTE: MAKE SURE SINGLE THREADED END OF FITTING IS INSTALLED IN PUMP END.		
50	NAS1612-20A	. PACKING		1
55	AS1007T2020	. UNION		1
C1	D00054	. MCS 352B FLUID	CON	AR
		LUBRICATE PACKING (75) AND THREADS OF UNION (80) WITH MCS 352B fluid, D00054 (C1). INSTALL PACKING (75) ON UNION (80) AND INSTALL UNION (80) TO CASE DRAIN PORT OF HYDRAULIC PUMP (15). TIGHTEN UNION (80) TO 162-179 POUND-INCHES (18.3-20.2 NEWTON METERS).		
75	NAS1612-6A	. PACKING		1
80	AS5230T0606	. UNION		1
C1	D00054	. MCS 352B FLUID	CON	AR

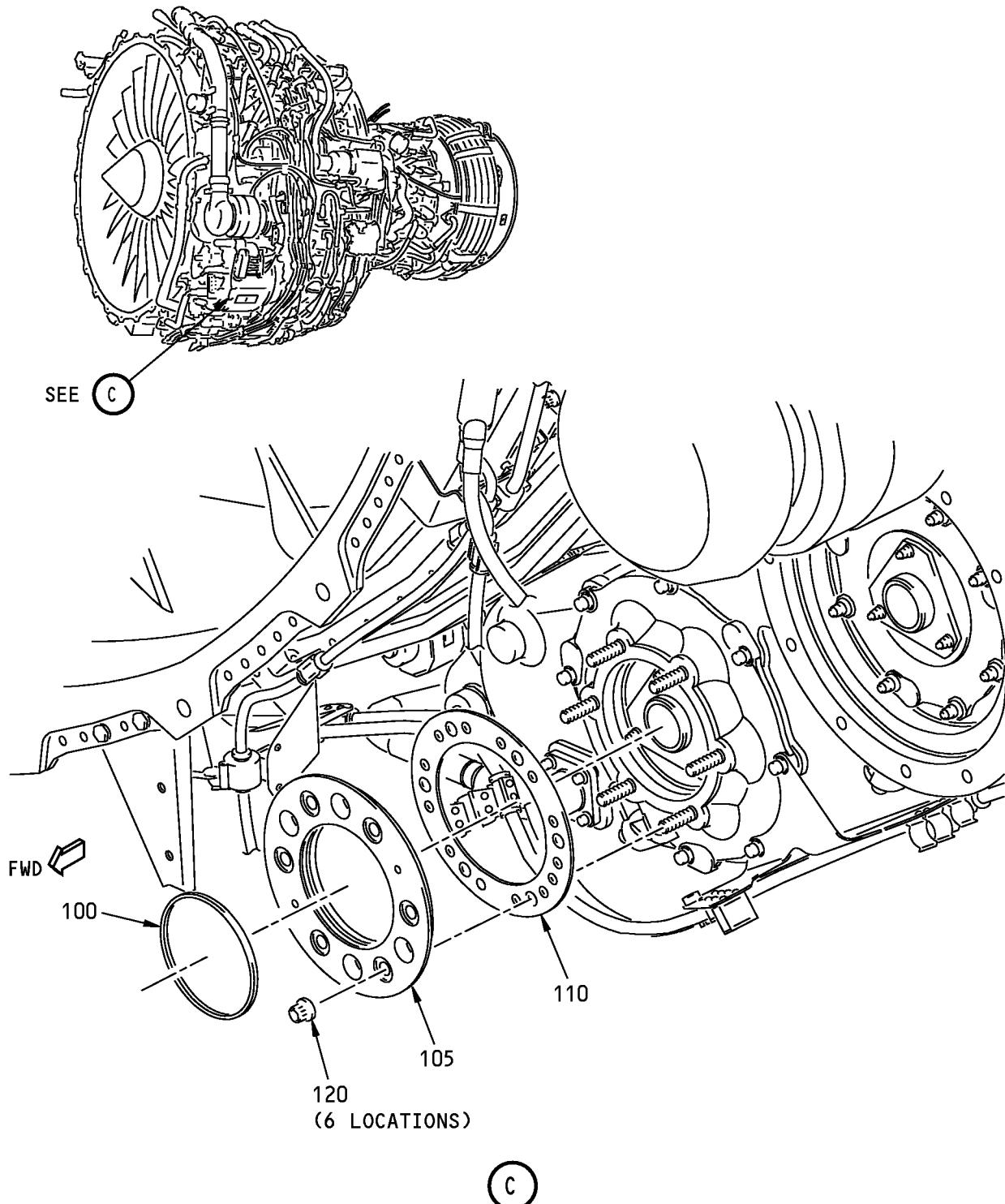
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P/P BUILDUP FIGURE 20-1

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POWERPLANT BUILDUP MANUAL

Hydraulic Pump Installation -
(VICKERS)
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P/P BUILDUP FIGURE 20-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
20-1		HYDRAULIC PUMP INSTALLATION - (VICKERS) (FIGURE 20-1, SHEET 4) REMOVE PROTECTIVE CAP, WASHERS AND NUTS FROM AGB HYDRAULIC PAD AND DISCARD. LUBRICATE PUMP PACKING WITH MCS 352B fluid, D00054 (C1) AND INSTALL ON INNER SURFACE OF ADAPTER PLATE. .. PUMP PACKING (PART OF 849589 (15)) (VENDOR PART NUMBER 972703) (V62983) .. ADAPTER PLATE (V62983) (PART OF 849589 (15)) . MCS 352B FLUID APPLY A THIN COATING OF Novagard G624 Compound, D00276 (C3) OR silicone compound, D00254 (C4) TO MATING SURFACES OF ADAPTER PLATE (105) AND ACCESSORY GEARBOX. . NOVAGARD G624 COMPOUND . SILICONE COMPOUND ATTACH ADAPTER PLATE (105) AND GASKET (110) TO ENGINE GEARBOX WITH NUTS (120). CROSS-TIGHTEN NUTS (120) TO 260-320 POUND-INCHES (29.4-36.1 NEWTON METERS). <u>NOTE:</u> MAKE SURE INDEXING PINS ON ADAPTER PLATE ARE AT 2 AND 8 O'CLOCK POSITIONS (VIEW LOOKING AFT) AFTER INSTALLATION.		
100	NAS1611-153A		REF	-
105	387999		REF	-
C1	D00054		CON	AR
C3	D00276		CON	AR
C4	D00254		CON	AR
110	332T3323-2	. GASKET		1
120	BACN10HY6AC	. NUT		6

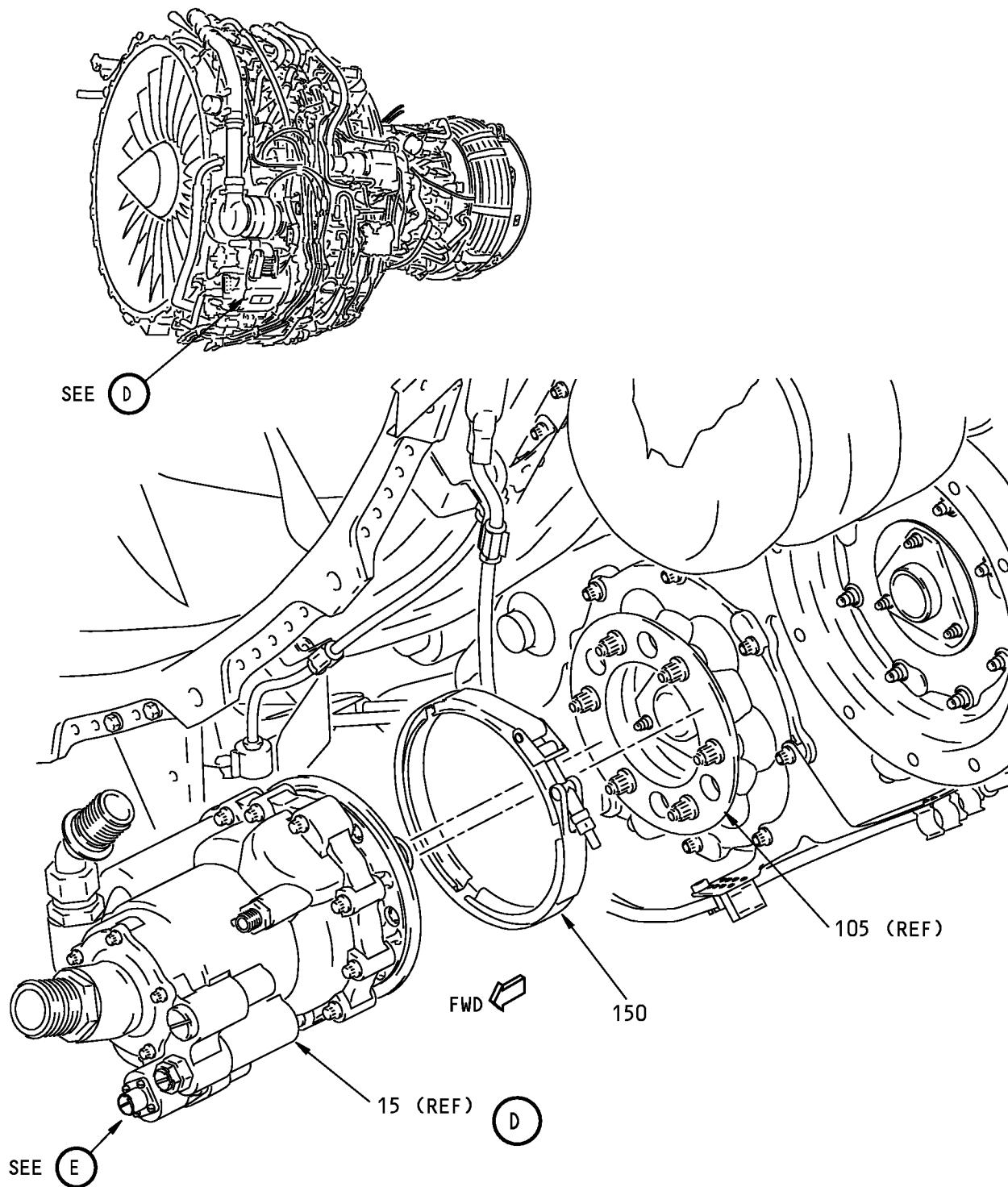
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P/P BUILDUP FIGURE 20-1

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POWERPLANT BUILDUP MANUAL

Hydraulic Pump Installation -
(VICKERS)
Figure 20-1 (Sheet 5)

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P/P BUILDUP FIGURE 20-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
20-1 150	974219	<p>HYDRAULIC PUMP INSTALLATION - (VICKERS) (FIGURE 20-1, SHEET 5)</p> <p>INSTALL CLAMP RING (150) ON ADAPTER PLATE FLANGES.</p> <p>POSITION HYDRAULIC PUMP (15) ON ADAPTER PLATE (105) AND SECURE WITH CLAMP RING.</p> <p>POSITION CLAMP RING (150) WITH BOLT CLOCKED AT 2 O'CLOCK POSITION (LOOKING AFT) TO CLEAR ENGINE DRAIN PORT.</p> <p>TIGHTEN CLAMP RING (150) NUT TO 45-55 POUND-INCHES (5.1-6.2 NEWTON METERS).</p> <p>. . CLAMP RING (V62983) (PART OF 849589 (15))</p>	REF	-

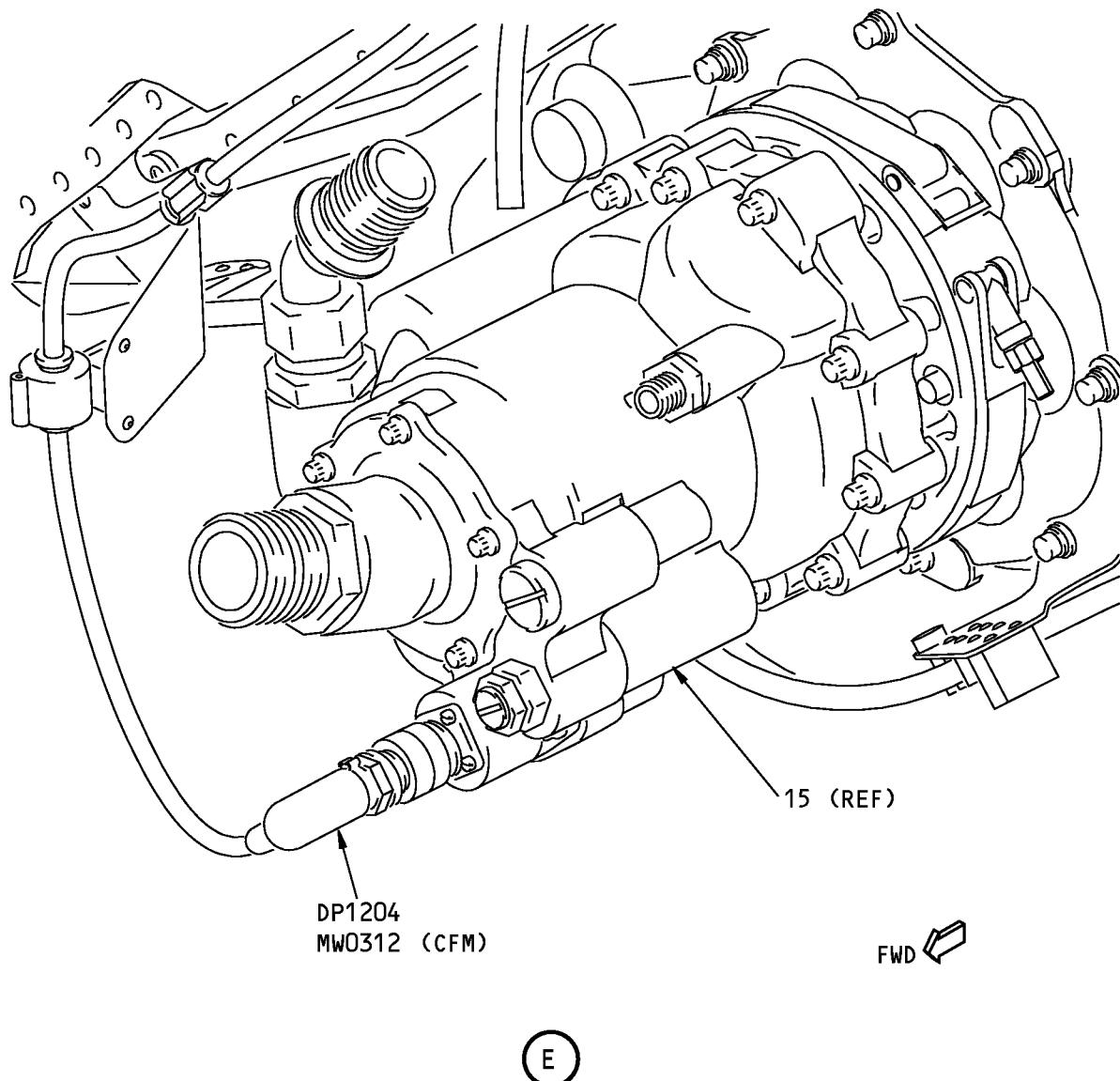
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P/P BUILDUP FIGURE 20-1

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POWERPLANT BUILDUP MANUAL

Hydraulic Pump Installation -
(VICKERS)
Figure 20-1 (Sheet 6)

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P/P BUILDUP FIGURE 20-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
20-1		<p>HYDRAULIC PUMP INSTALLATION - (VICKERS) (FIGURE 20-1, SHEET 6)</p> <p>CAUTION: DO NOT OVERTIGHTEN THE PLUG COUPLING RING. DO NOT USE PLIERS, PIPE WRENCHES OR VISE GRIPS TO TIGHTEN THE COUPLING RING OR DAMAGE TO THE ELECTRICAL CONNECTOR CAN OCCUR.</p> <p>CONNECT MW0312 ELECTRICAL CONNECTOR, DP1204, TO PUMP CONNECTOR RECEPTACLE. TURN KNURLED COUPLING RING WHILE WIGGLING THE BACKSHELL ASSEMBLY.</p> <p>AFTER FULLY SEATING THE COUPLING RING, TIGHTEN THE COUPLING RING TO FINGER TIGHT. DO NOT TWIST BACKSHELL WHILE TIGHTENING THE COUPLING RING.</p> <p>NOTE: AFTER TIGHTENING, MINOR ROTATION OF THE MATED BACKSHELL IS ACCEPTABLE, AND THE CONNECTOR MAY APPEAR LOOSE.</p>		

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P/P BUILDUP FIGURE 20-1

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FIGURE 21-1

HYDRAULIC PLUMBING INSTALLATION

REF QEC TASK NO.: 21

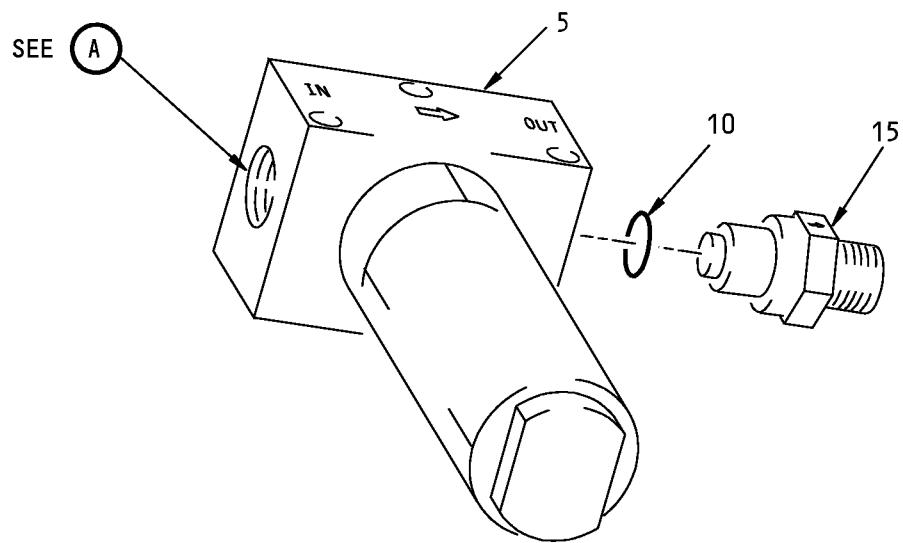
REF DWG: 332A2400

NOTE: ALL STANDARDS AND ATTACHING HARDWARE FOR THIS FIGURE WILL BE PACKAGED IN QEC TASK NO. 110.

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P/P BUILDUP FIGURE 21-1
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POWERPLANT BUILDUP MANUAL

HYDRAULIC FILTER

Hydraulic Plumbing Installation
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P/P BUILDUP FIGURE 21-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
21-1		<p>HYDRAULIC PLUMBING INSTALLATION (FIGURE 21-1, SHEET 1)</p> <p>WARNING: FIRE-RESISTANT HYDRAULIC FLUIDS CONFORMING TO BMS 3-11 (SKYDROL) MAY CAUSE SKIN IRRITATION. AVOID PROLONGED OR REPEATED CONTACT WITH SKIN. IN CASE OF EYE CONTACT, FLUSH EYES WITH WATER AND GET MEDICAL AID. IN CASE OF INGESTION, GET MEDICAL AID.</p> <p>LUBRICATE PACKING (10) AND THREADS OF CHECK VALVE (15) WITH MCS 352B fluid, D00054 (C1).</p> <p>INSTALL PACKING (10) ON CHECK VALVE (15).</p> <p>CAUTION: MAKE SURE THAT THE ARROWS ON THE CHECK VALVE, AND HYDRAULIC FILTER POINT IN SAME DIRECTION. IF THE ARROWS POINT IN DIFFERENT DIRECTIONS, DAMAGE TO THE EDP WILL OCCUR.</p> <p>INSTALL CHECK VALVE (15) TO "OUTLET" PORT OF HYDRAULIC FILTER (5).</p> <ul style="list-style-type: none"> . HYDRAULIC FILTER (V05228) (SPEC 10-60555-7) . PACKING . CHECK VALVE, MINIATURE . MCS 352B FLUID <p>TIGHTEN CHECK VALVE (15) TO 162-178 POUND-INCHES (18.3-20.1 NEWTON METERS).</p>		
5	7579078		VEN	1
10	NAS1612-6A			1
15	BACV10CE12			1
C1	D00054		CON	AR

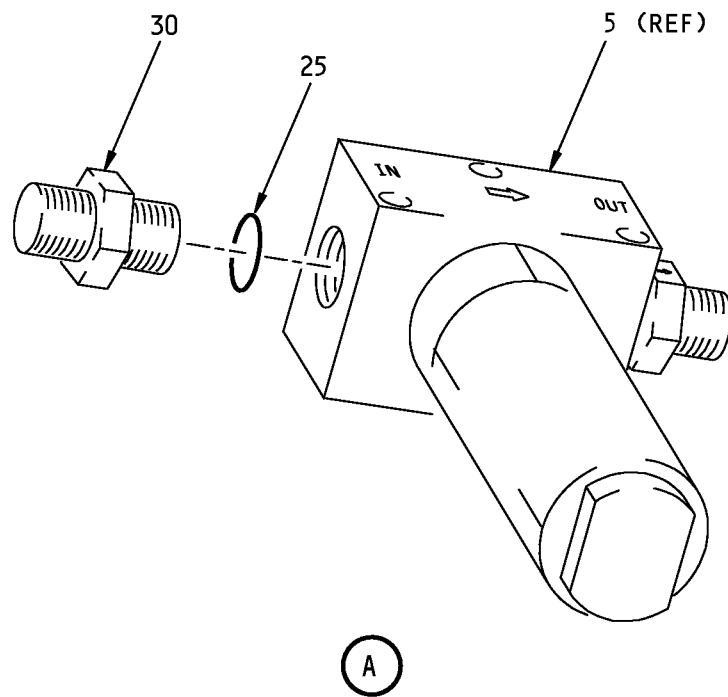
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P/P BUILDUP FIGURE 21-1

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POWERPLANT BUILDUP MANUAL

Hydraulic Plumbing Installation
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P/P BUILDUP FIGURE 21-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
21-1		HYDRAULIC PLUMBING INSTALLATION (FIGURE 21-1, SHEET 2) LUBRICATE PACKING (25) AND THREADS OF UNION (30) WITH MCS 352B fluid, D00054 (C1). INSTALL PACKING (25) ON UNION (30) AND INSTALL ON "IN" PORT OF HYDRAULIC FILTER (5). . PACKING . UNION . MCS 352B FLUID TIGHTEN UNION (30) TO 162-178 POUND-INCHES (18.3-20.1 NEWTON METERS).		
25	NAS1612-6A			1
30	AS5230T0606			1
C1	D00054		CON	AR

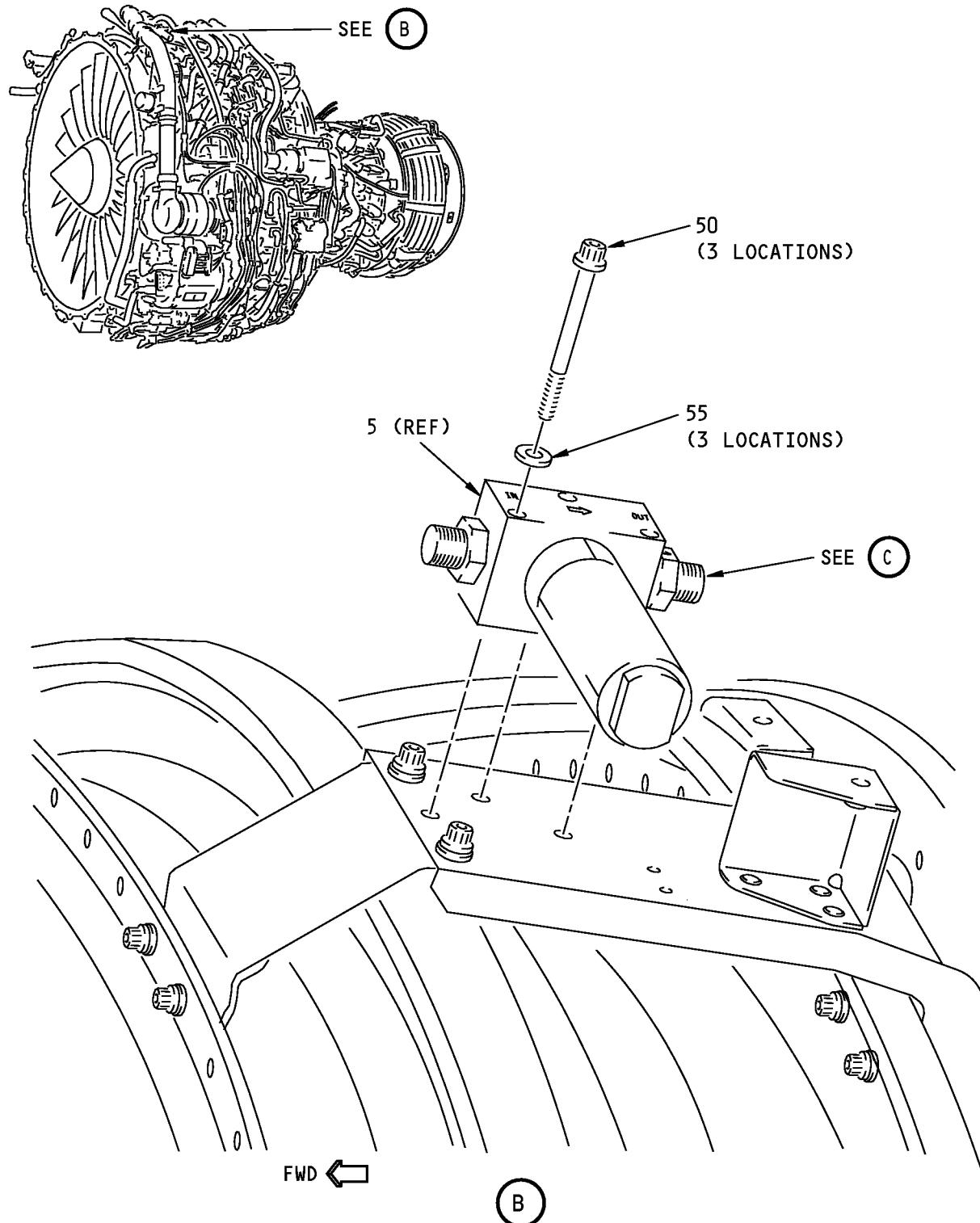
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P/P BUILDUP FIGURE 21-1

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POWERPLANT BUILDUP MANUAL

Hydraulic Plumbing Installation
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P/P BUILDUP FIGURE 21-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
21-1		HYDRAULIC PLUMBING INSTALLATION (FIGURE 21-1, SHEET 3) ATTACH HYDRAULIC FILTER (5) TO ENGINE BRACKET AT 11 O'CLOCK POSITION WITH BOLTS (50) AND WASHERS (55). NOTE: MAKE SURE FLOW ARROW ON HYDRAULIC FILTER (5) POINTS AFT (IN DIRECTION OF FLOW).		
50	BACB30ZF4-32	. BOLT		3
55	NAS1149C0432R	. WASHER		3
		TIGHTEN THE BOLTS (50) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS).		

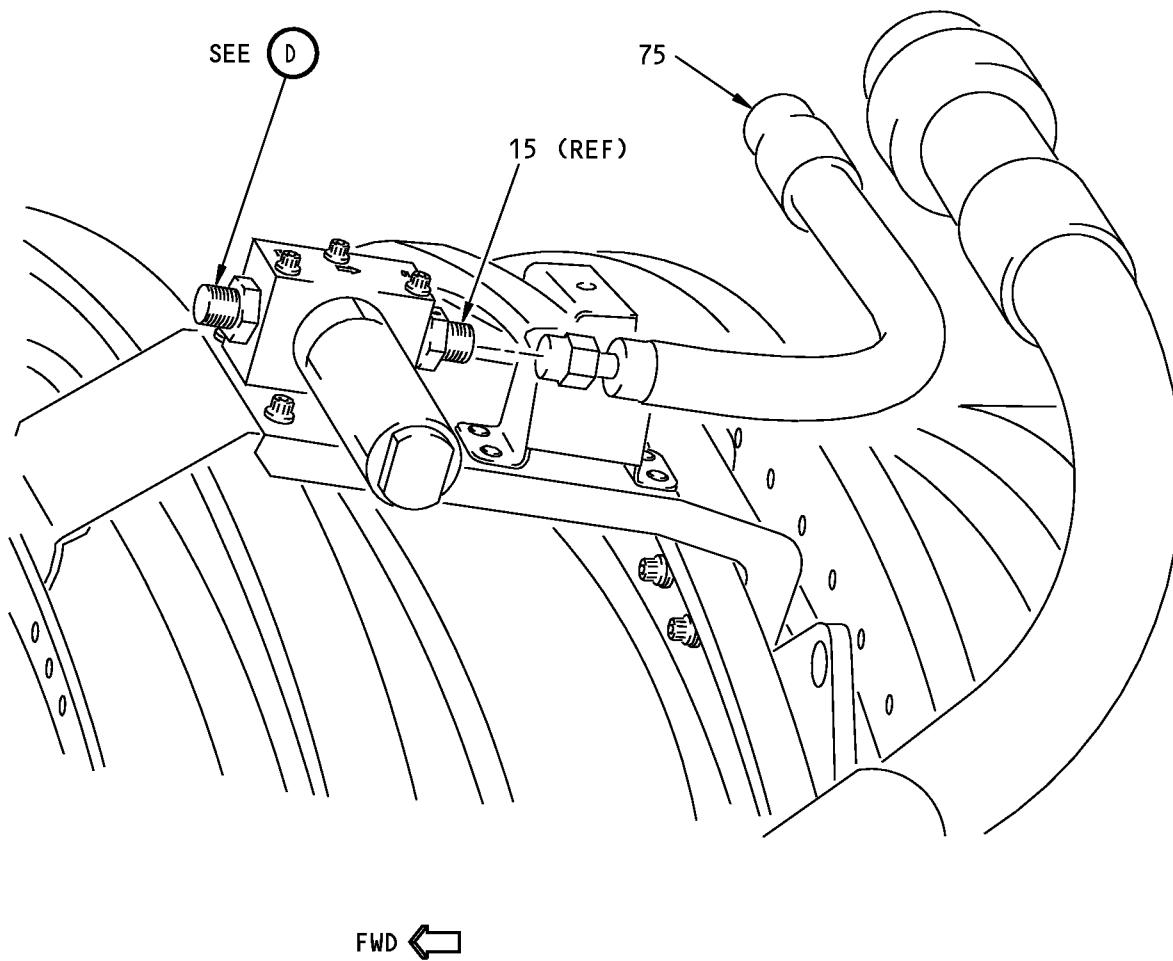
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P/P BUILDUP FIGURE 21-1

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POWERPLANT BUILDUP MANUAL

Hydraulic Plumbing Installation
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P/P BUILDUP FIGURE 21-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
21-1		<p>HYDRAULIC PLUMBING INSTALLATION (FIGURE 21-1, SHEET 4)</p> <p>LUBRICATE THREADS OF CHECK VALVE (15) WITH MCS 352B fluid, D00054 (C1).</p> <p>SECURE HYDRAULIC CASE DRAIN HOSE ASSY (75) TO CHECK VALVE (15).</p> <p>NOTE: MAKE SURE NO PRELOAD IS PRESENT ON HOSE ASSY.</p>		
75 C1	155006-06-23 D00054	<p>. HOSE ASSY, HYDRAULIC CASE DRAIN (V11362) (SPEC S332A210-23)</p> <p>. MCS 352B FLUID</p> <p>TIGHTEN HOSE ASSY (75) TO 257-283 POUND-INCHES (29.0-32.0 NEWTON METERS).</p> <p>BACK OFF TUBE NUT TO RELAX TORQUE, THEN RETIGHTEN.</p> <p>MAKE SURE PROTECTIVE CAP IS INSTALLED ON OPEN END OF HOSE ASSY (75).</p>	VEN CON	1 AR

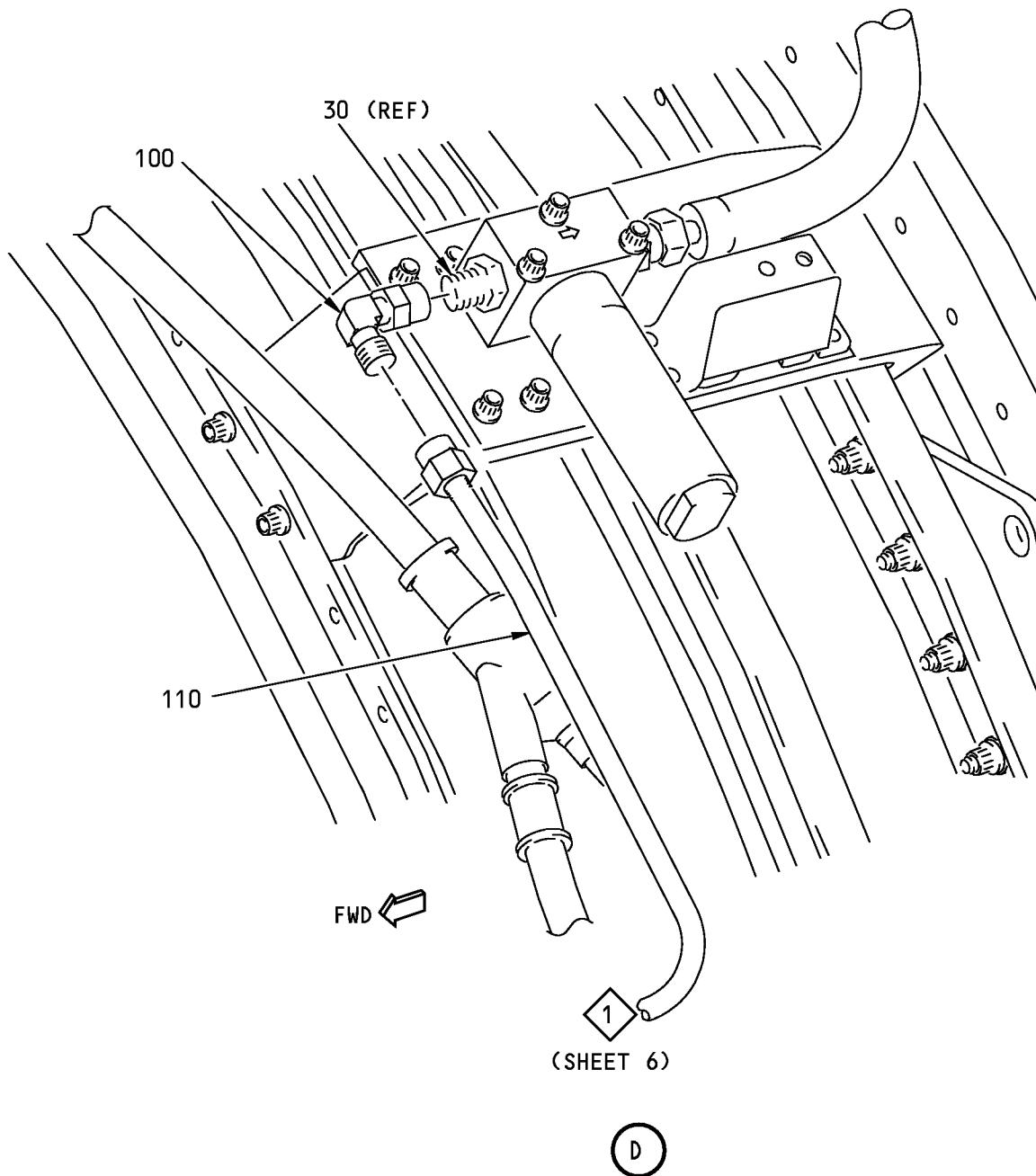
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P/P BUILDUP FIGURE 21-1

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POWERPLANT BUILDUP MANUALHydraulic Plumbing Installation
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P/P BUILDUP FIGURE 21-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
21-1		HYDRAULIC PLUMBING INSTALLATION (FIGURE 21-1, SHEET 5) LOOSELY CONNECT ELBOW (100) TO UNION (30). <u>NOTE:</u> ELBOW HAS A FILM OF DRY FILM LUBRICANT AND DOES NOT REQUIRE LUBRICATION.		
100	AS4138T0606	. TUBE ASSY POSITION TUBE ASSY (110) ON ENGINE FAN CASE, ALIGNING TOP END OF TUBE ASSY WITH ELBOW (100) AND LOWER END WITH CLAMP LOCATIONS. LOOSELY INSTALL TUBE ASSY (110) TO ELBOW (100). <u>NOTE:</u> DO NOT TIGHTEN TUBE ASSY AND ELBOW AT THIS TIME.	1	
110	332A2410-1	. TUBE ASSY		1

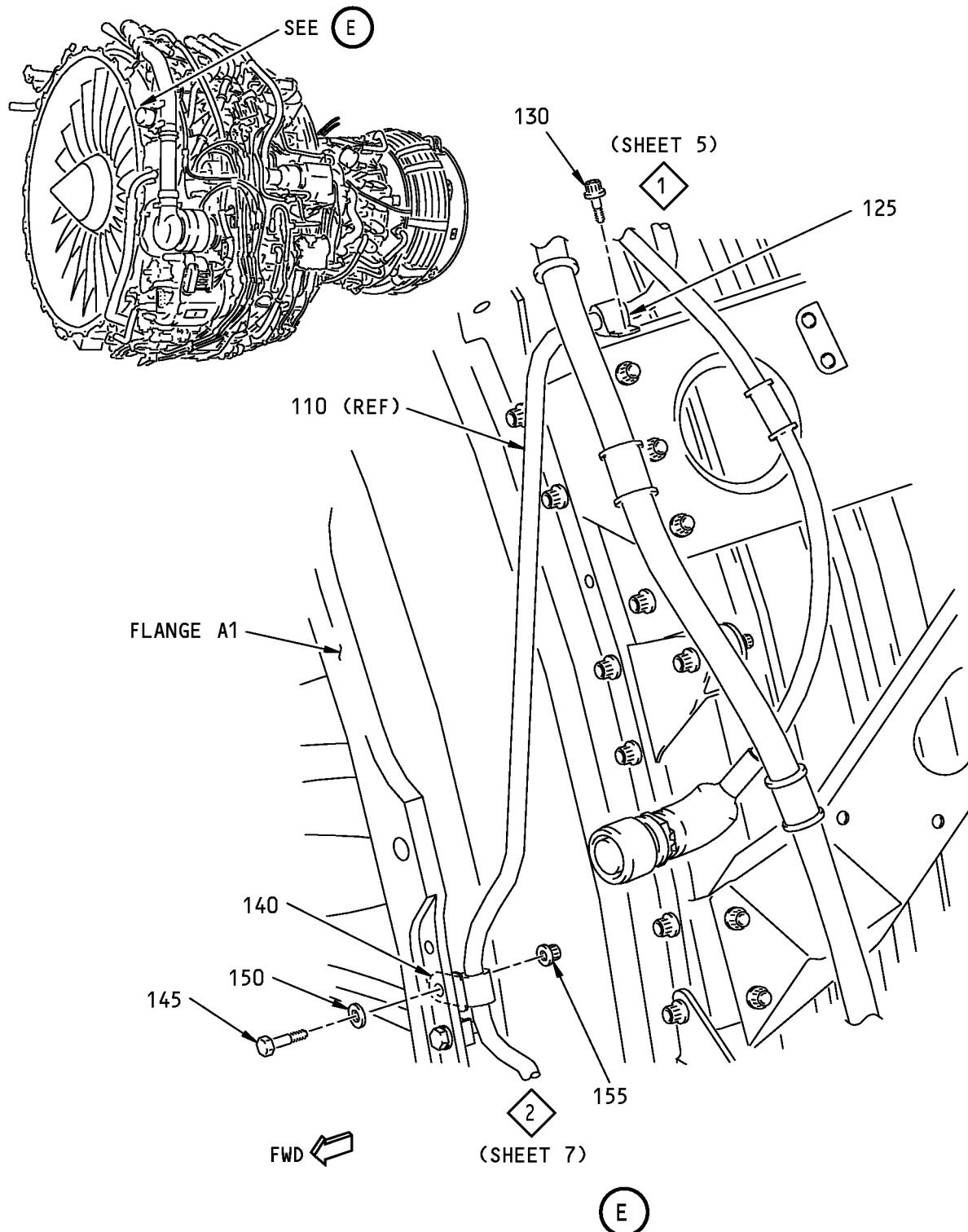
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P/P BUILDUP FIGURE 21-1

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POWERPLANT BUILDUP MANUALHydraulic Plumbing Installation
Figure 21-1 (Sheet 6)

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P/P BUILDUP FIGURE 21-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
21-1		HYDRAULIC PLUMBING INSTALLATION (FIGURE 21-1, SHEET 6)		
125	J1221G06	ATTACH TUBE ASSY (110) TO TOP SIDE OF ENGINE BRACKET AT 10:30 O'CLOCK POSITION WITH CLAMP (125) AND BOLT (130).	VEN	1
130	BACB30ZF4-06	. CLAMP (V07482) . BOLT		1
140	J1221G06	LOOSELY ATTACH TUBE ASSY (110) TO BRACKET ON FLANGE A1.	VEN	1
145	BACB30NM4K6	USE CLAMP (140), BOLT (145), WASHER (150) AND NUT (155).		1
150	BACW10BP4ACU	. CLAMP (V07482) . BOLT		1
155	AS3485-10	. WASHER (CSK) (UNDER BOLT HEAD) . NUT		1
		ADJUST TUBE ASSY (110) AND ELBOW (100) TO BEST POSITION.		
		MAKE SURE NO PRELOAD FORCE EXISTS ON TUBE ASSY (110).		
		TIGHTEN ELBOW (100) ON UNION (30) TO 257-283 POUND-INCHES (29.0-32.0 NEWTON METERS).		
		BACK OFF UNION TO RELAX TORQUE, THEN RETIGHTEN.		
		TIGHTEN TUBE ASSY (110) AT ELBOW (100) TO 257-283 POUND-INCHES (29.0-32.0 NEWTON METERS).		
		BACK OFF TUBE NUT TO RELAX TORQUE, THEN RETIGHTEN.		
		TIGHTEN BOLT (130) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS) AND TIGHTEN BOLT (145) TO 50-80 POUND-INCHES (5.6-9.0 NEWTON METERS).		

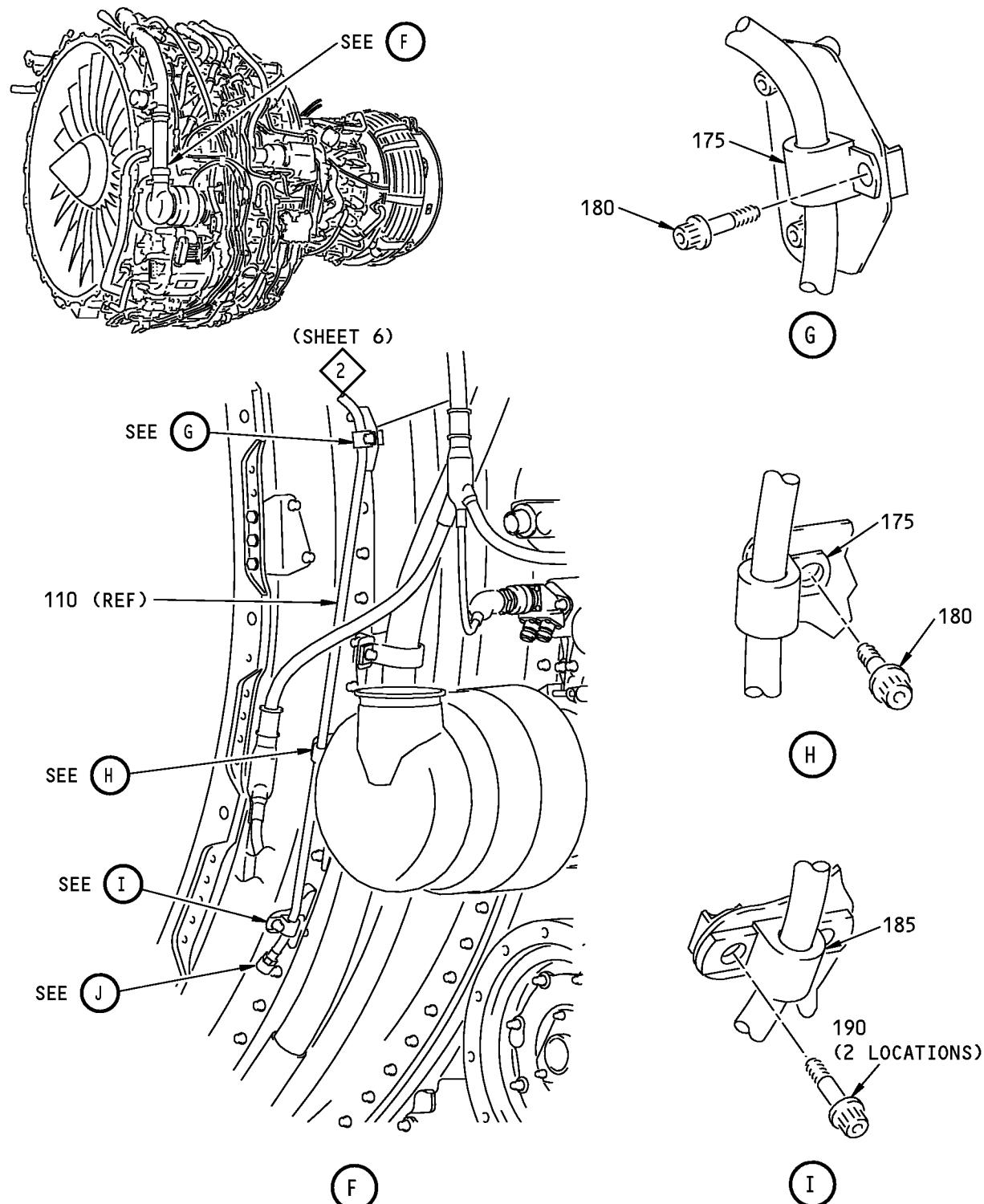
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P/P BUILDUP FIGURE 21-1

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POWERPLANT BUILDUP MANUAL

Hydraulic Plumbing Installation
Figure 21-1 (Sheet 7)

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
21-1		HYDRAULIC PLUMBING INSTALLATION (FIGURE 21-1, SHEET 7)		
175	J1221G06	ATTACH TUBE ASSY (110) TO ENGINE BRACKETS AT 9 AND 8 O'CLOCK POSITIONS USING CLAMPS (175) AND BOLTS (180).	VEN	2
180	BACB30ZF4-06	. CLAMP (V07482) . BOLT		2
		TIGHTEN BOLTS (180) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS).		
185	TA0910064-06	ATTACH TUBE ASSY (110) TO ENGINE BRACKET AT 7:30 O'CLOCK POSITION WITH CLAMP (185) AND BOLTS (190).	VEN	1
190	BACB30ZF4-08	. CLAMP (V84971) . BOLT		2
		TIGHTEN BOLTS (190) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS).		

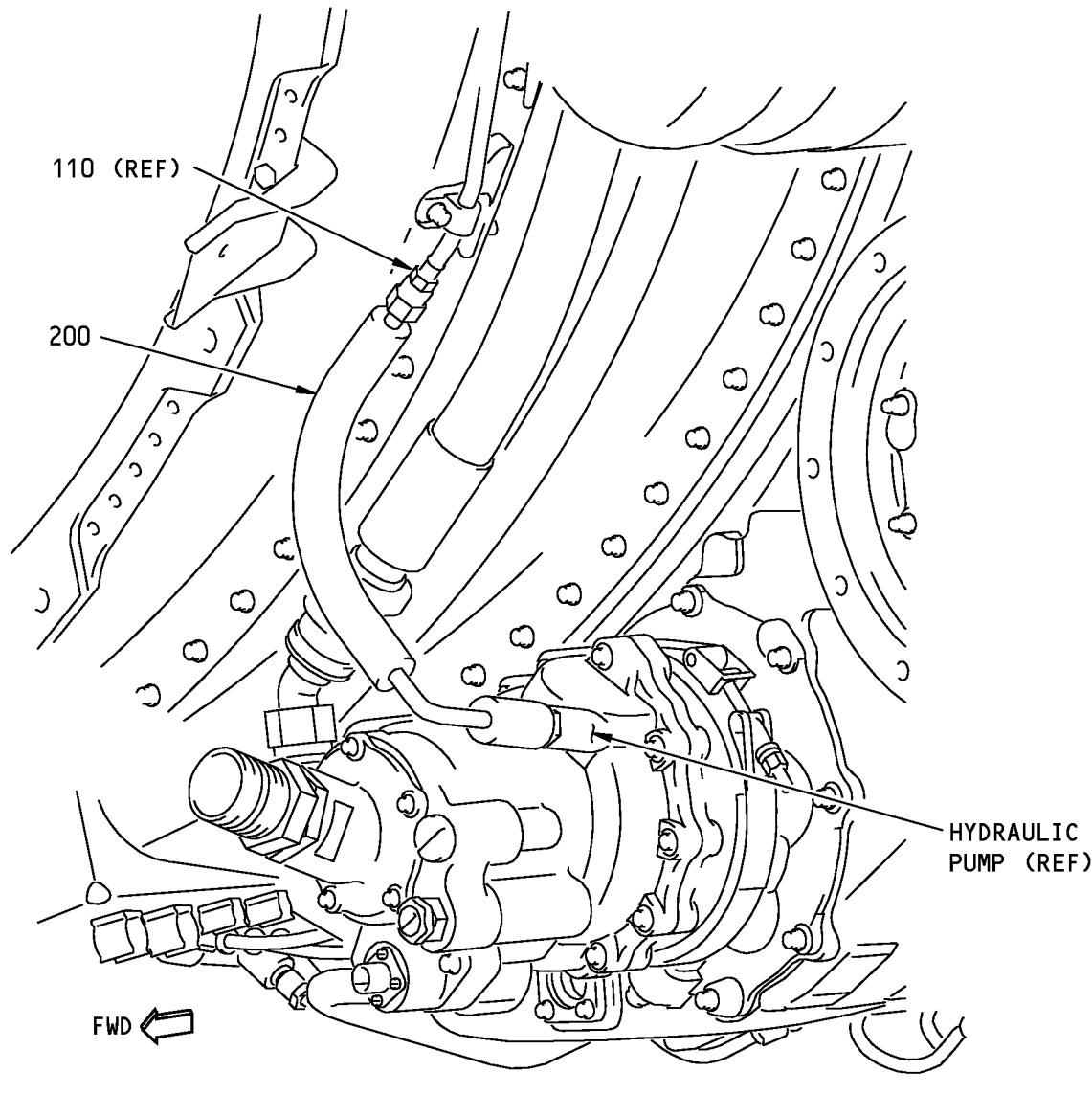
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P/P BUILDUP FIGURE 21-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
21-1 200	155006-06-16	<p>HYDRAULIC PLUMBING INSTALLATION (FIGURE 21-1, SHEET 8)</p> <p>LOOSELY CONNECT HYDRAULIC CASE DRAIN HOSE ASSY (200) TO TUBE ASSY (110) AND CASE DRAIN PORT OF HYDRAULIC PUMP. HOSE ASSY, HYDRAULIC CASE DRAIN (V11362) (SPEC S332A210-16)</p> <p>CAUTION: USE TWO WRENCHES WHEN YOU LOOSEN OR TIGHTEN THE CONNECTION. ONE WRENCH WILL HOLD ONE SIDE OF THE CONNECTION IN ITS POSITION. ONE WRENCH WILL TURN THE OTHER SIDE OF THE CONNECTION. IF YOU DO NOT OBEY THIS TWO-WRENCH PROCEDURE, YOU CAN CAUSE DAMAGE TO THE CONNECTION COMPONENTS.</p> <p>TIGHTEN HOSE ASSY (200) AT UNION ON HYDRAULIC PUMP AND AT TUBE ASSY (110) TO 257-283 POUND-INCHES (29.0-32.0 NEWTON METERS).</p> <p>BACK OFF TUBE NUT TO RELAX TORQUE, THEN RETIGHTEN. MAKE SURE HOSE DOES NOT TWIST OR KINK WHEN TIGHTENING.</p> <p>MAKE SURE NO PRELOAD FORCE IS PRESENT ON HOSE ASSY (200) AND TUBE ASSY (110).</p> <p>MAKE SURE THERE IS MINIMUM OF 0.5 INCH (12.7 MILLIMETERS) CLEARANCE WITH ADJACENT HARDWARE.</p> <p>IF NECESSARY, LOOSEN CLAMPS AND ADJUST AS REQUIRED. TIGHTEN ALL BOLTS.</p>	VEN	1

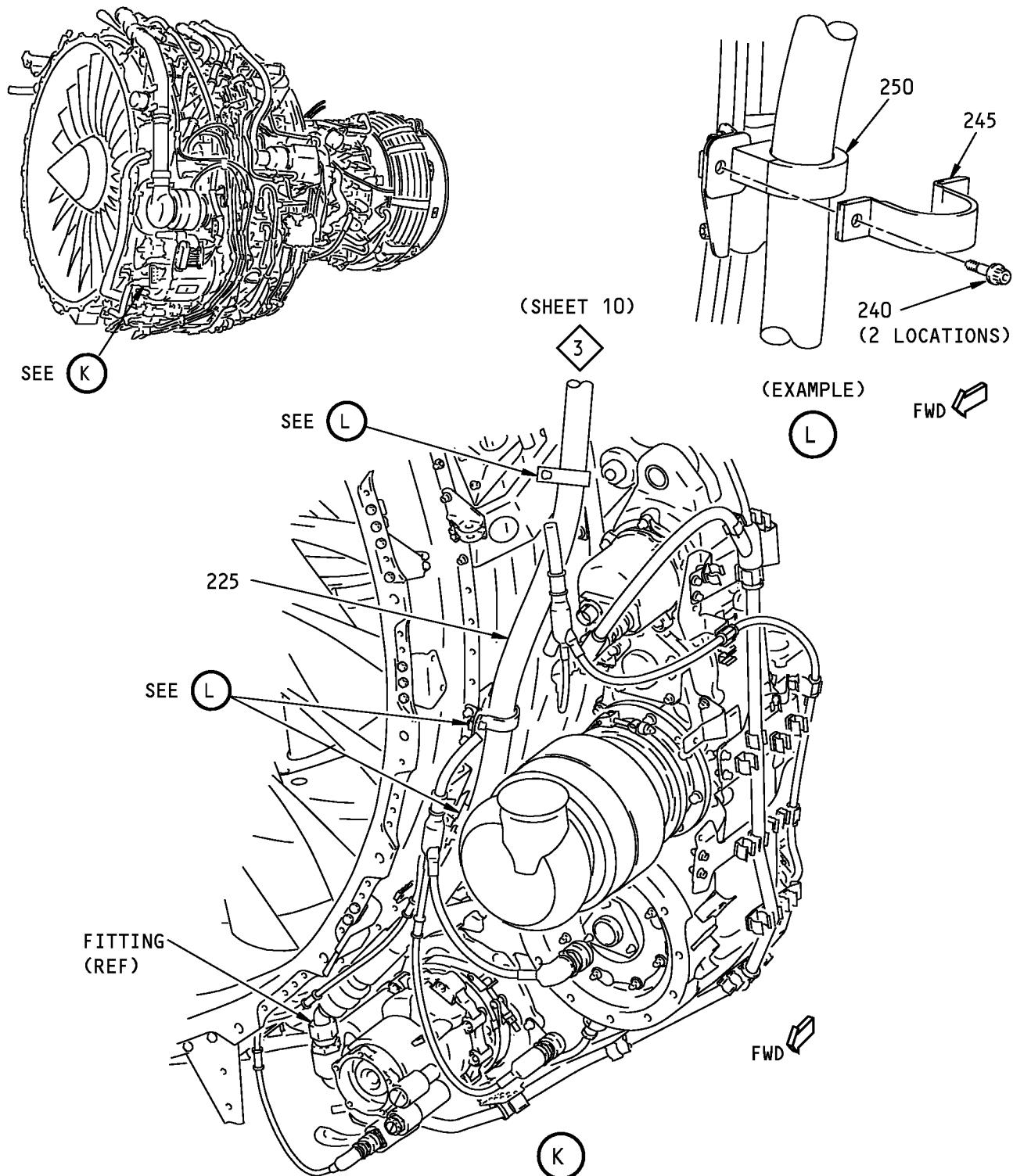
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P/P BUILDUP FIGURE 21-1

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P/P BUILDUP FIGURE 21-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
21-1		HYDRAULIC PLUMBING INSTALLATION (FIGURE 21-1, SHEET 9) CONNECT HYDRAULIC PRESSURE HOSE ASSY (225) TO FITTING ON HYDRAULIC PUMP. TIGHTEN HOSE ASSY (225) UNTIL FITTING LOCKS. NOTE: ENDS OF HOSE ASSY ARE IDENTICAL. THEREFORE, HOSE ASSY IS END-TO-END INTERCHANGEABLE.		
225	155012-12-21	. HOSE ASSY, HYDRAULIC PRESSURE (V11362) (SPEC S332A210-21) <u>OPTIONAL STEP:</u> COAT ID OF CLAMP BLOCK (250) WITH grease, D00173 (C2) TO FACILITATE POSITIONING OF BLOCK UPON INSTALLATION. AT THREE LOCATIONS ON ENGINE FAN CASE, LOOSELY ATTACH HOSE ASSY (225) TO ENGINE BRACKETS. USE BOLTS (240), CLAMP BLOCK STRAPS (245) AND CLAMP BLOCKS (250). USE BOLT (241) AND NUT (242) AT FWD HOLE OF LOWER BRACKET IF BRACKET DOES NOT HAVE NUTPLATE.	VEN	1
240	BACB30ZF4-08	. BOLT		5
241	BACB30ZF4-10	. BOLT (NOT ILLUSTRATED)		1
242	AS3485-10	. NUT (NOT ILLUSTRATED)		1
245	332W3130-18	. CLAMP BLOCK STRAP		3
250	332W5101-10	. CLAMP BLOCK		3
C2	D00173	. GREASE	CON	AR
		ADJUST HOSE ASSY (225) TO BEST POSITION AND TIGHTEN BOLTS (240) AND BOLT (241) TO 97-103 POUND-INCHES (11.0-11.6 NEWTON METERS). TIGHTEN NUT (242) TO 82-88 POUND-INCHES (9.26-9.94 NEWTON METERS).		

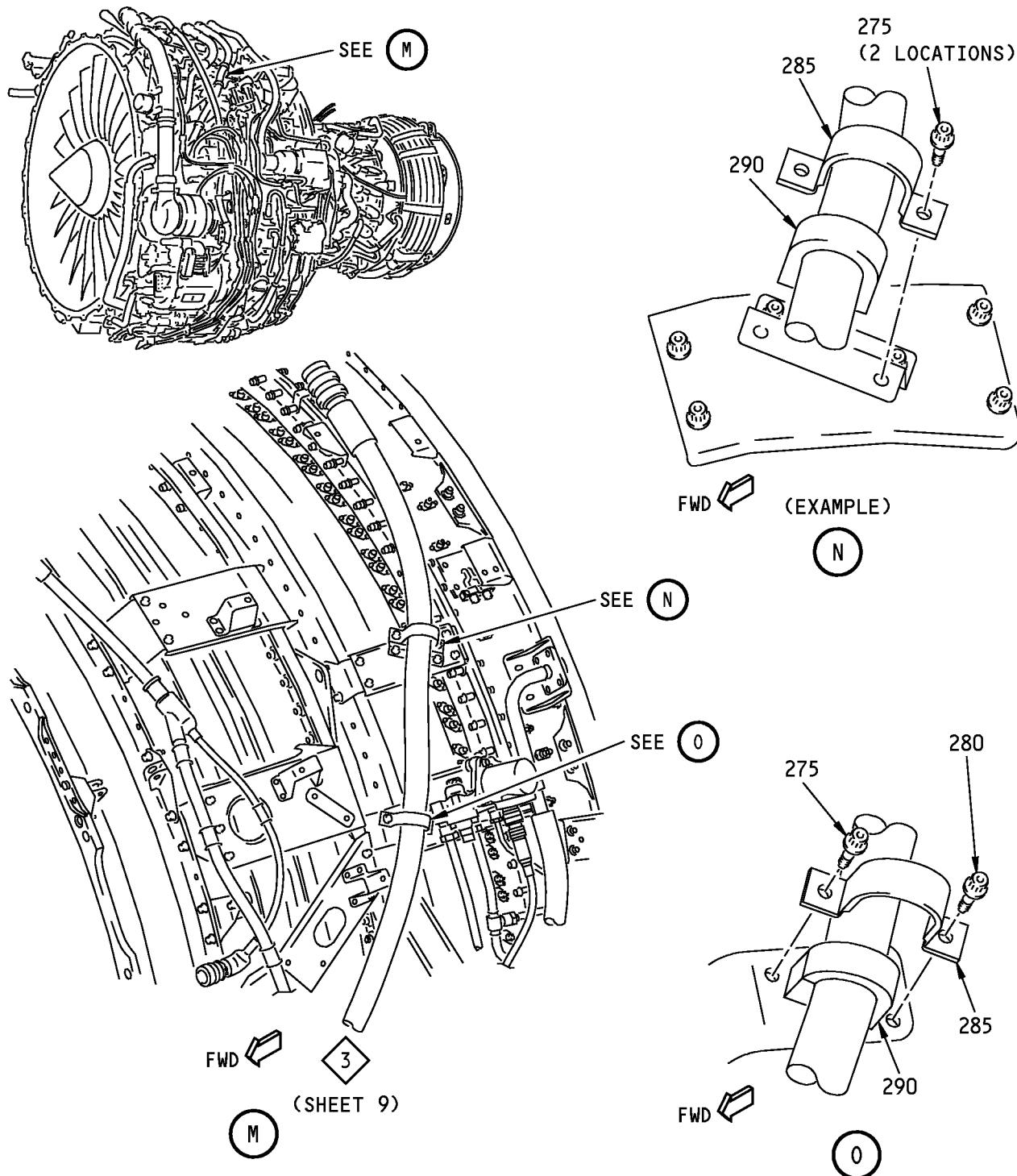
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P/P BUILDUP FIGURE 21-1

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1743428 S0000315636_V3

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P/P BUILDUP FIGURE 21-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
21-1		HYDRAULIC PLUMBING INSTALLATION (FIGURE 21-1, SHEET 10) <u>OPTIONAL STEP:</u> COAT ID OF CLAMP BLOCK (290) WITH grease, D00173 (C2) TO FACILITATE POSITIONING OF BLOCK UPON INSTALLATION. AT TWO LOCATIONS ON ENGINE FAN CASE, LOOSELY ATTACH HOSE ASSY (225) TO ENGINE BRACKETS. USE BOLTS (275) AND (280), CLAMP BLOCK STRAP (285) AND CLAMP BLOCK (290) AT LOWER LOCATION AND BOLTS (275), CLAMP BLOCK STRAP (285) AND CLAMP BLOCK (290) AT UPPER HOLE.		
275	BACB30ZF4-08	. BOLT	3	
280	BACB30ZF4-10	. BOLT	1	
285	332W3130-18	. CLAMP BLOCK STRAP	2	
290	332W5101-10	. CLAMP BLOCK	2	
C2	D00173	. GREASE	CON	AR
		ADJUST HOSE ASSY (225) TO BEST POSITION. MAKE SURE PROTECTIVE CAP IS INSTALLED ON OPEN END OF HOSE ASSY (225). TIGHTEN BOLTS (275) AND (280) TO 78-82 POUND-INCHES (8.81-9.26 NEWTON METERS).		

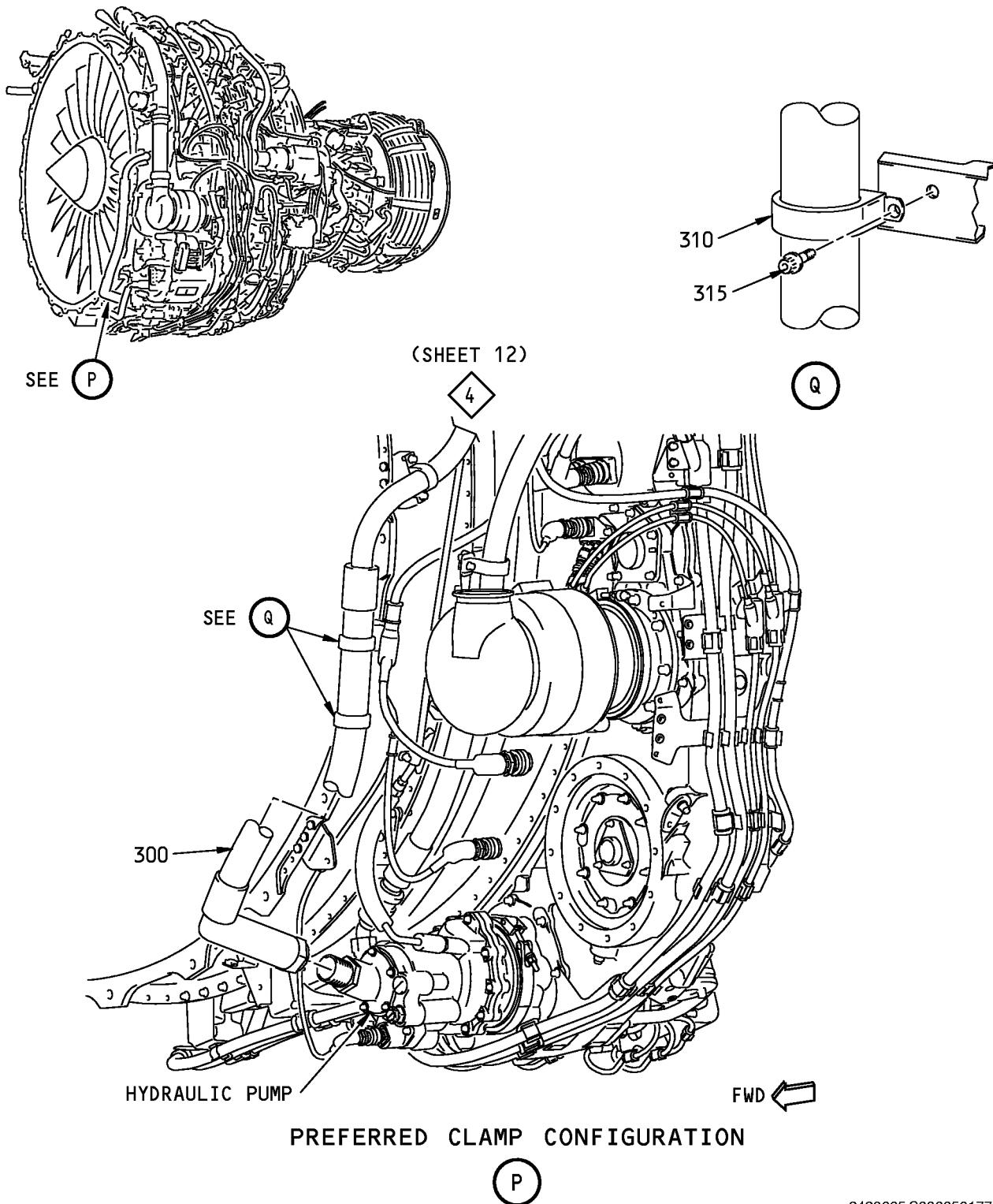
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P/P BUILDUP FIGURE 21-1

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2428665 S0000561774_V1

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P/P BUILDUP FIGURE 21-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
21-1		<p>HYDRAULIC PLUMBING INSTALLATION (FIGURE 21-1, SHEET 11)</p> <p><u>PREFERRED CLAMP CONFIGURATION</u></p> <p>CAUTION: USE TWO WRENCHES WHEN YOU LOOSEN OR TIGHTEN THE CONNECTION. ONE WRENCH WILL HOLD ONE SIDE OF THE CONNECTION IN ITS POSITION. ONE WRENCH WILL TURN THE OTHER SIDE OF THE CONNECTION. IF YOU DO NOT OBEY THIS TWO-WRENCH PROCEDURE, YOU CAN CAUSE DAMAGE TO THE CONNECTION COMPONENTS.</p> <p>MAKE SURE INTERNAL O-RING (301) IS INSTALLED ON HOSE ASSY (300) COUPLING.</p> <p>IF O-RING IS MISSING, INSTALL NEW O-RING (301).</p> <p>NOTE: O-RING (301) NOT INCLUDED IN QEC KIT.</p> <p>CONNECT HOSE ASSY (300) TO SUPPLY PORT OF HYDRAULIC PUMP.</p> <p>TIGHTEN HOSE ASSY (300) TO 1520-1680 POUND-INCHES (127-140 POUND-FEET) (172-190 NEWTON METERS).</p> <p>NOTE: MAKE SURE HOSE ASSY DOES NOT KINK OR TWIST DURING TIGHTENING.</p>		
300 301	155016-20-11 NAS1611-024A	<p>. HOSE ASSY, HYDRAULIC SUPPLY (V11362) (SPEC S332A210-11)</p> <p>. O-RING (1 REQD) *^[3]</p> <p>LOOSELY ATTACH HOSE ASSY (300) TO ENGINE BRACKETS FORWARD OF FLANGE A1 WITH CLAMPS (310) AND BOLTS (315).</p> <p>NOTE: DO NOT TIGHTEN BOLT (315) AT THIS TIME.</p>	VEN REF	1 -
310 315	J1221G28 BACB30ZF4-08	<p>. CLAMP (V07482)</p> <p>. BOLT</p> <p>*^[3] ITEM NOT ILLUSTRATED</p>	VEN	2 2

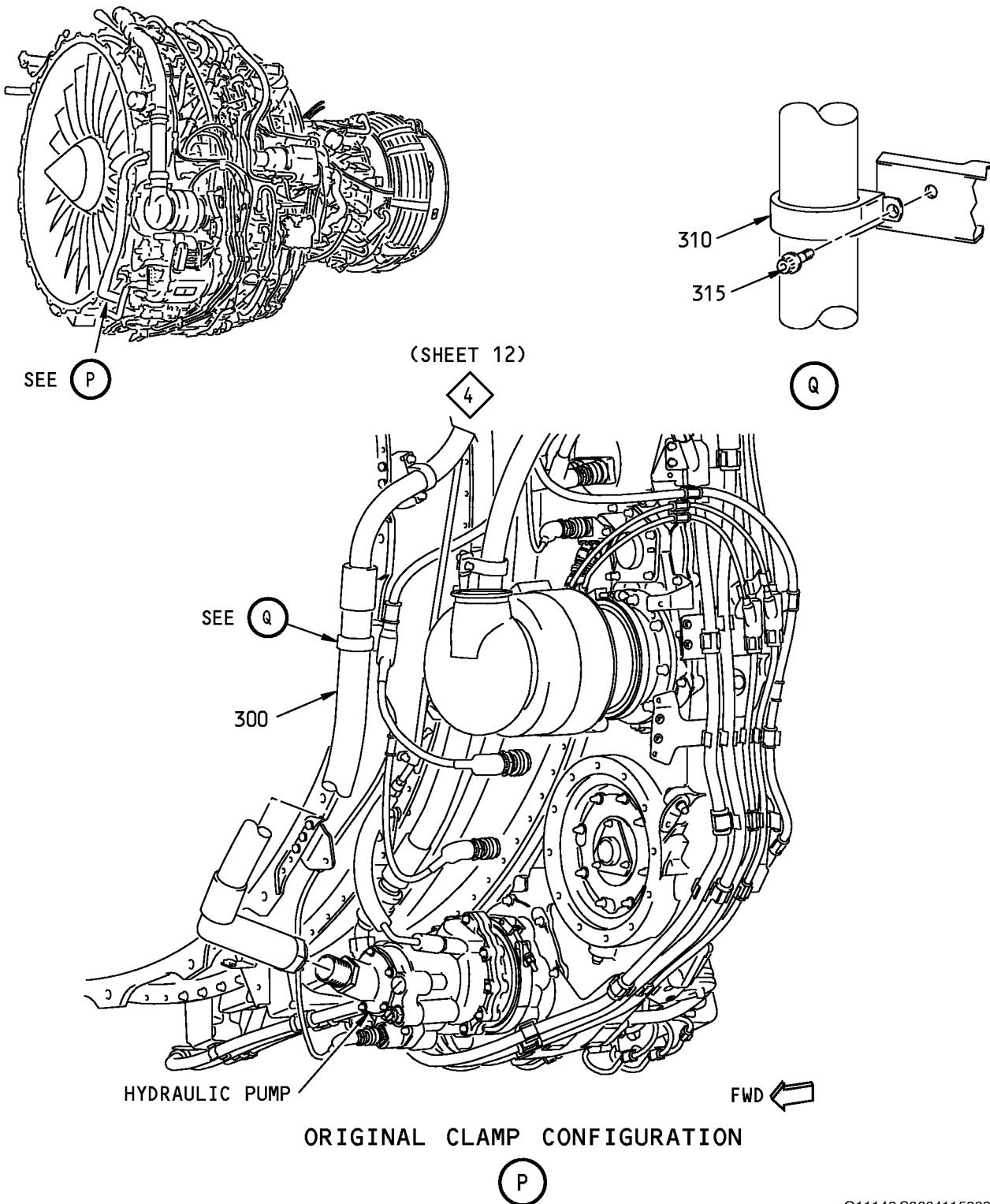
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P/P BUILDUP FIGURE 21-1

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G11149 S00041153890_V2

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P/P BUILDUP FIGURE 21-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
21-1		<p>HYDRAULIC PLUMBING INSTALLATION (FIGURE 21-1, SHEET 12)</p> <p><u>ORIGINAL CLAMP CONFIGURATION</u></p> <p>CAUTION: USE TWO WRENCHES WHEN YOU LOOSEN OR TIGHTEN THE CONNECTION. ONE WRENCH WILL HOLD ONE SIDE OF THE CONNECTION IN ITS POSITION. ONE WRENCH WILL TURN THE OTHER SIDE OF THE CONNECTION. IF YOU DO NOT OBEY THIS TWO-WRENCH PROCEDURE, YOU CAN CAUSE DAMAGE TO THE CONNECTION COMPONENTS.</p> <p>MAKE SURE INTERNAL O-RING (301) IS INSTALLED ON HOSE ASSY (300) COUPLING.</p> <p>IF O-RING IS MISSING, INSTALL NEW O-RING (301).</p> <p>NOTE: O-RING (301) NOT INCLUDED IN QEC KIT.</p> <p>CONNECT HOSE ASSY (300) TO SUPPLY PORT OF HYDRAULIC PUMP.</p> <p>TIGHTEN HOSE ASSY (300) TO 1520-1680 POUND-INCHES (127-140 POUND-FEET) (172-190 NEWTON METERS).</p> <p>NOTE: MAKE SURE HOSE ASSY DOES NOT KINK OR TWIST DURING TIGHTENING.</p>		
300	155016-20-11	. HOSE ASSY, HYDRAULIC SUPPLY (1 REQD) (V11362) (SPEC S332A210-11)	LTD	-
301	NAS1611-024A	. . O-RING (1 REQD) ^[3] LOOSELY ATTACH HOSE ASSY (300) TO ENGINE BRACKET FORWARD OF FLANGE A1 WITH CLAMP (310) AND BOLT (315). NOTE: DO NOT TIGHTEN BOLT (315) AT THIS TIME.	REF	-
310	J1221G28	. CLAMP (1 REQD) (V07482)	LTD	-
315	BACB30ZF4-08	. BOLT (1 REQD) *[3] ITEM NOT ILLUSTRATED	LTD	-

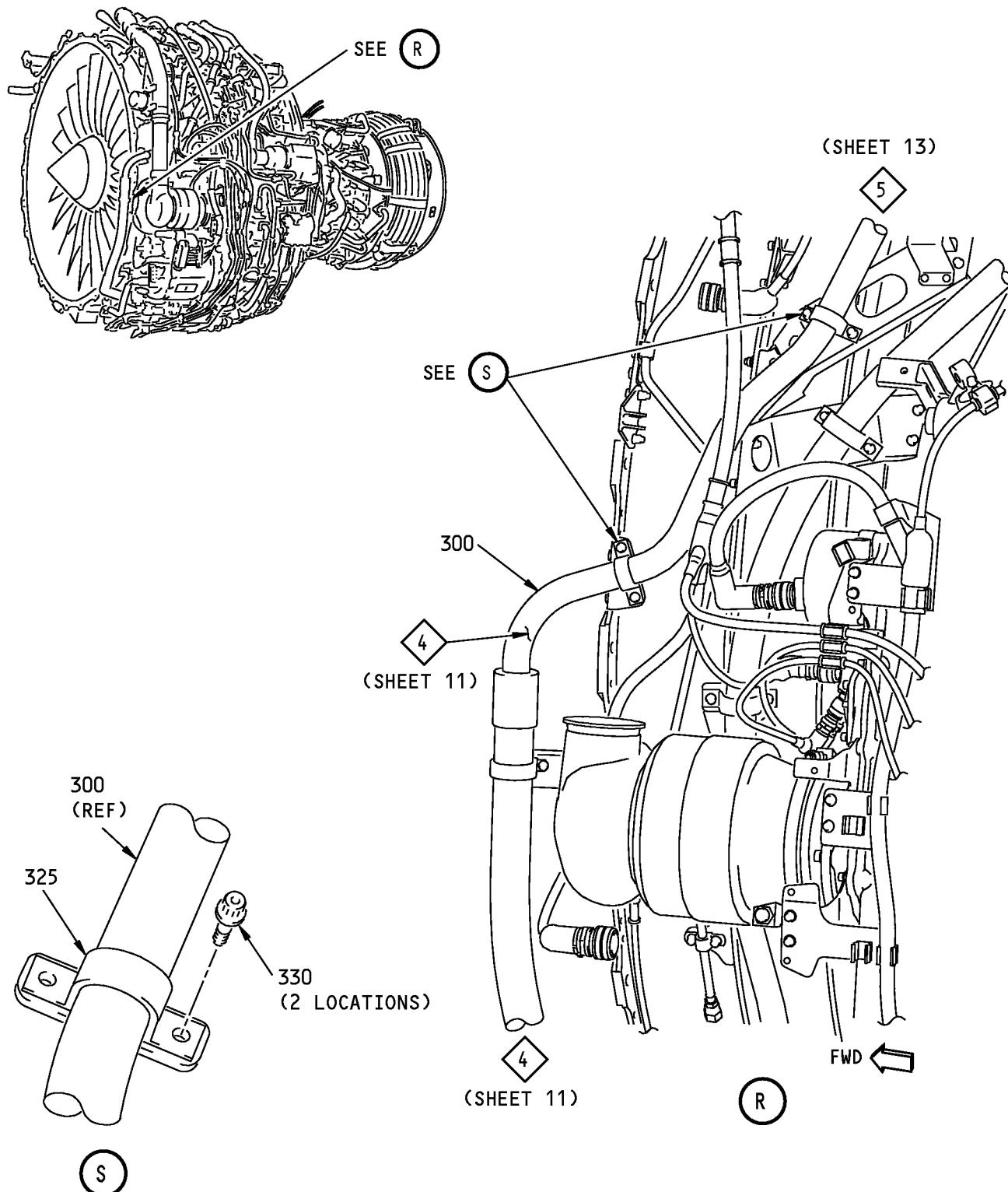
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P/P BUILDUP FIGURE 21-1

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P/P BUILDUP FIGURE 21-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
21-1		HYDRAULIC PLUMBING INSTALLATION (FIGURE 21-1, SHEET 13) CONNECT HOSE ASSY (300) TO ENGINE BRACKETS AT 10:00 AND 9:00 O'CLOCK POSITIONS WITH CLAMPS (325) AND BOLTS (330). NOTE: DO NOT TIGHTEN BOLTS (330) AT THIS TIME.		
325	TA0910083	. CLAMP (V84971)	VEN	2
330	BACB30ZF4-08	. BOLT		4

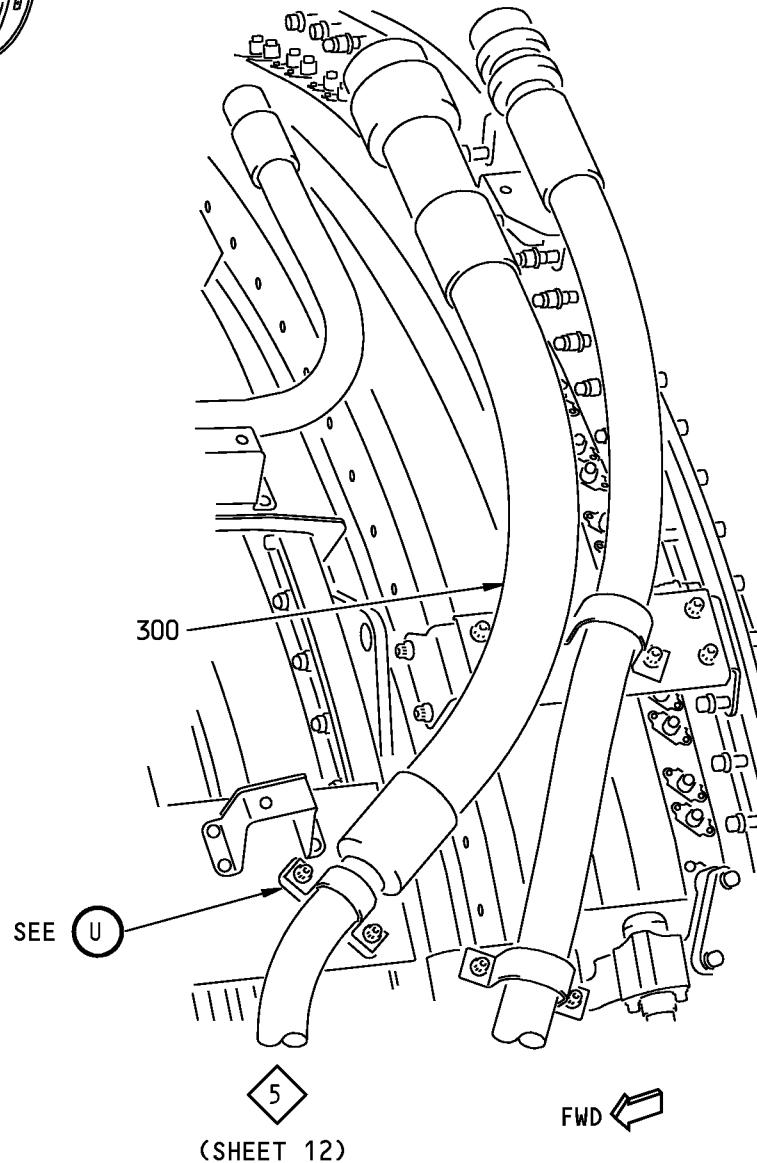
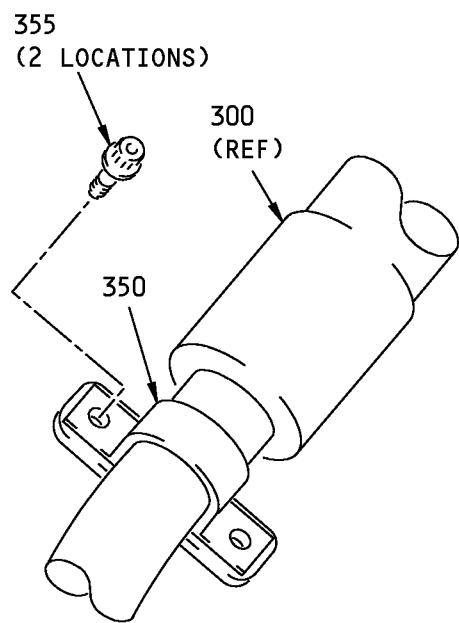
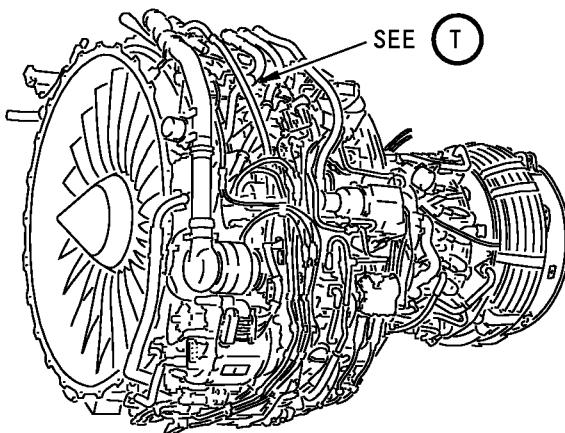
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P/P BUILDUP FIGURE 21-1

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P/P BUILDUP FIGURE 21-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
21-1 350 355	TA0910083 BACB30ZF4-12	<p>HYDRAULIC PLUMBING INSTALLATION (FIGURE 21-1, SHEET 14)</p> <p>LOOSELY ATTACH HOSE ASSY (300) TO BRACKET AT 10:30 O'CLOCK POSITION WITH CLAMP (350) AND BOLTS (355).</p> <p>. CLAMP (V84971) . BOLT</p> <p>ADJUST HOSE ASSY (300) TO BEST POSITION.</p> <p>MAKE SURE THERE IS MINIMUM OF 0.5 INCH (12.7 MILLIMETERS) CLEARANCE WITH ADJACENT HARDWARE.</p> <p>TIGHTEN BOLTS (315), (330) AND (355) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS).</p> <p>MAKE SURE PROTECTIVE CAP IS INSTALLED ON OPEN END OF HOSE ASSY (300).</p>	VEN	1 2

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P/P BUILDUP FIGURE 21-1

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FIGURE 22-1

INTEGRATED DRIVE GENERATOR INSTALLATION

REF QEC TASK NO.: 22

REF DWG: 332A2600

NOTE: ALL STANDARDS AND ATTACHING HARDWARE FOR THIS FIGURE WILL BE PACKAGED
IN QEC TASK NO. 110.

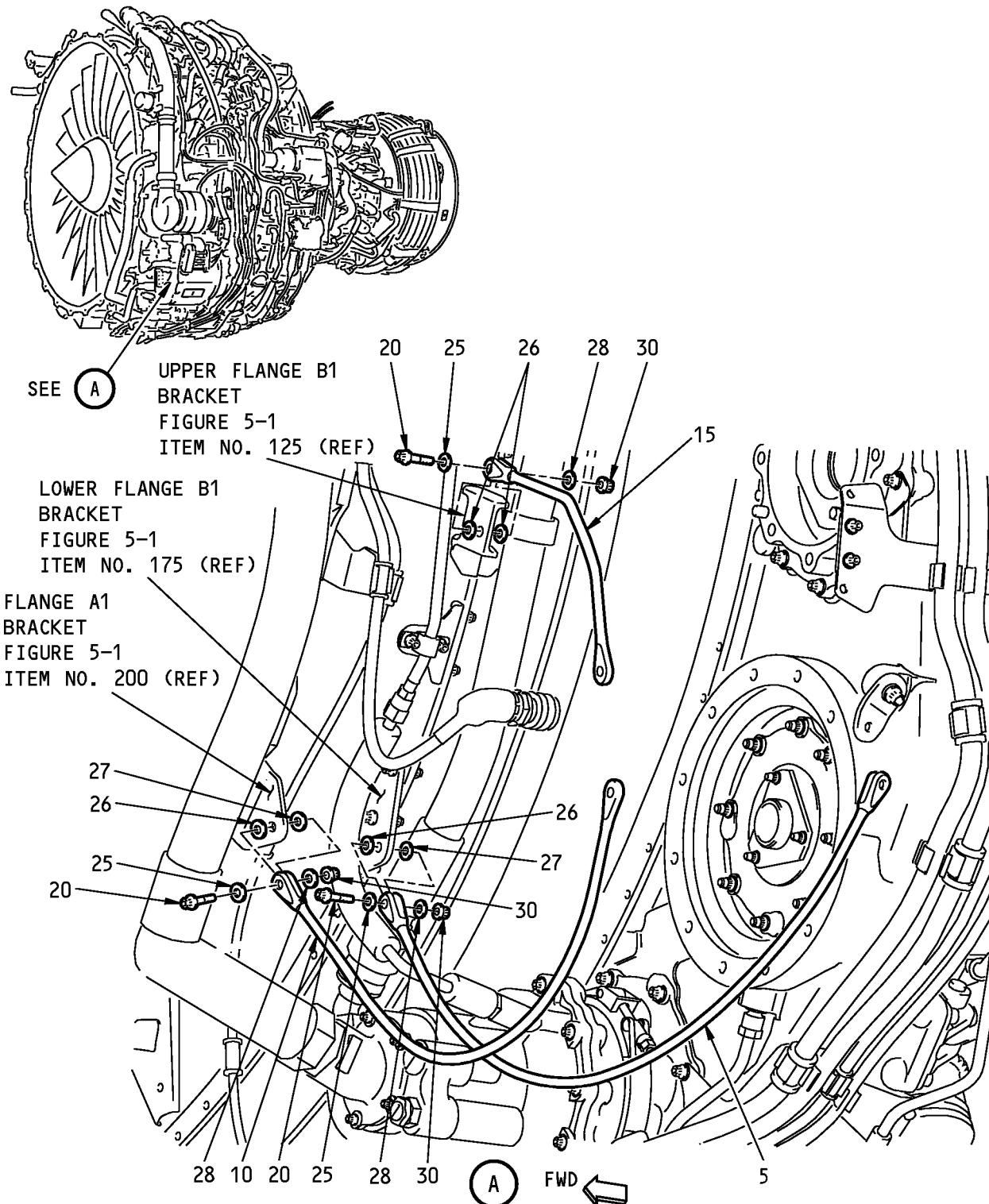
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P/P BUILDUP FIGURE 22-1

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POWERPLANT BUILDUP MANUALIntegrated Drive Generator Installation
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P/P BUILDUP FIGURE 22-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
22-1		INTEGRATED DRIVE GENERATOR INSTALLATION (FIGURE 22-1, SHEET 1) LOOSELY ATTACH LANYARD ASSY (5) TO LOWER FLANGE B1 BRACKET BRACKET INSTALLATION - LOWER LEFT FAN CASE/Figure 5-1 ITEM NO. 175) USING BOLT (20), WASHERS (25 THRU 27) AND NUT (30). LOOSELY ATTACH LANYARD ASSY (10) TO FLANGE A1 BRACKET BRACKET INSTALLATION - LOWER LEFT FAN CASE/Figure 5-1 ITEM NO. 200) USING BOLT (20), WASHERS (25 THRU 27) AND NUT (30). LOOSELY ATTACH LANYARD ASSY (15) TO UPPER FLANGE B1 BRACKET (REF BRACKET INSTALLATION - LOWER LEFT FAN CASE/Figure 5-1 ITEM NO. 125) USING BOLT (20), WASHERS (25 THRU 28) AND NUT (30).		
5	332A2600-4	. LANYARD ASSY		1
10	332A2600-5	. LANYARD ASSY		1
15	332A2600-6	. LANYARD ASSY		1
20	BACB30LE5K8	. BOLT		3
25	BACW10BP5ACU	. WASHER (CSK) (UNDER BOLT HEAD)		3
25	BACW10BP5CD	. WASHER (CSK) (OPTIONAL TO BACW10BP5ACU)	OPT	-
26	NAS1149E0532P	. WASHER (BETWEEN LANYARD CLEVIS AND ENGINE BRKT) (BOLT SIDE)		4
27	NAS1149E0516P	. WASHER (BETWEEN LANYARD CLEVIS AND ENGINE BRKT) (NUT SIDE)		2
28	NAS1149E0563R	. WASHER (UNDER NUT)		3
30	AS3485-11	. NUT		3
30	BACN10HR5CS	. NUT (OPTIONAL TO AS3485-11)	OPT	-
		POSITION LANYARD ASSYS (5), (10) AND (15) AS SHOWN AND TIGHTEN BOLTS (20) TO 100-150 POUND-INCHES (11.3-17.0 NEWTON METERS).		

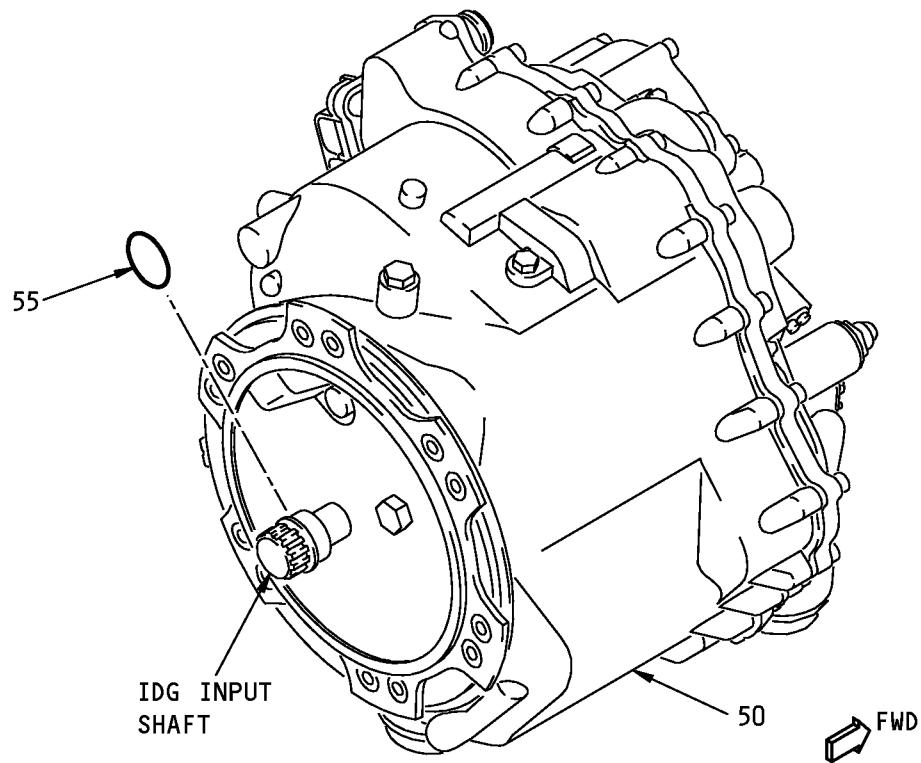
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P/P BUILDUP FIGURE 22-1

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INTEGRATED DRIVE GENERATOR

F14927 S00041153897_V2

Integrated Drive Generator Installation
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P/P BUILDUP FIGURE 22-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
22-1		INTEGRATED DRIVE GENERATOR INSTALLATION (FIGURE 22-1, SHEET 2) REMOVE BOLT FROM 12 O'CLOCK POSITION ON IDG (50) AND INSTALL LIFTING BOLT OR EQUIVALENT. .		
50	761574B	. IDG (V99167) (SPEC S281A001-101)	VEN	1
50	761574	. IDG (V99167) (SPEC S281A001-101) (OPTIONAL TO 761574B)	OPT	-
		LUBRICATE O-RING (55) WITH Syn-Tech NS-6074 lubricant, D00648 (C1) OR oil, D00071 (C2) OR oil, D00068 (C3) AND INSTALL ON INPUT SHAFT OF IDG (50).		
55	AS3209-216	. . O-RING (SUPPLIED WITH IDG)	REF	-
55	M83248-1-216	. . O-RING (SUPPLIED WITH IDG) (OPTIONAL TO AS3209-216)	OPT	-
C1	D00648	. . SYN-TECH NS-6074 LUBRICANT (SUPPLIED WITH IDG)	CON	AR
C2	D00071	. . OIL (OPTIONAL)	CON	AR
C3	D00068	. . OIL (OPTIONAL)	CON	AR

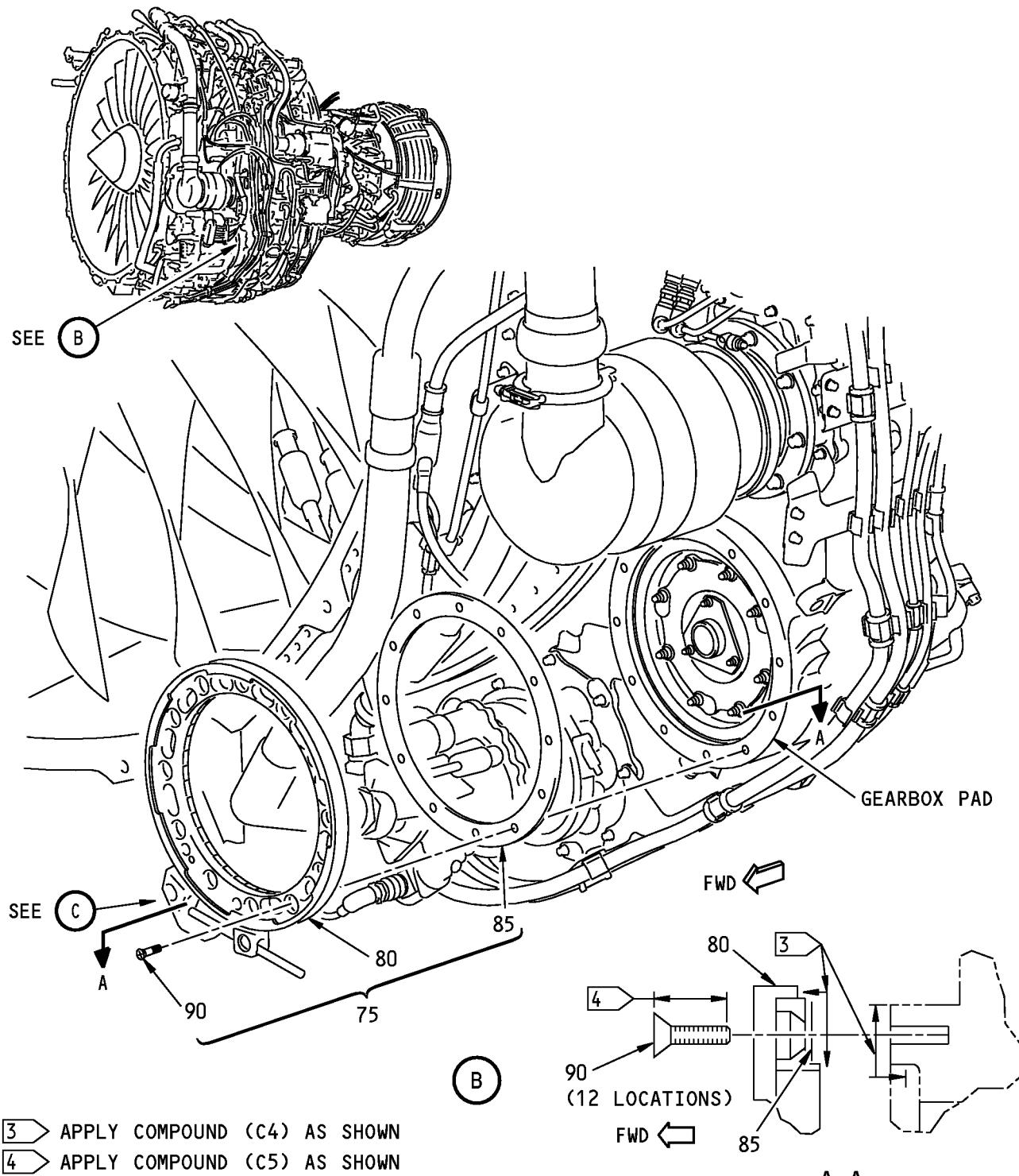
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P/P BUILDUP FIGURE 22-1

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F14935 S00041153898_V2

Integrated Drive Generator Installation
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P/P BUILDUP FIGURE 22-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
22-1		INTEGRATED DRIVE GENERATOR INSTALLATION (FIGURE 22-1, SHEET 3) CAUTION: KEEP GREASE OUT OF DOWEL PIN AND BOLT HOLES. GREASE IN HOLES CAN CAUSE DAMAGE TO GEARBOX DUE TO PRESSURE BUILD-UP WHEN SCREWS ARE INSTALLED. USE CARE TO KEEP FOREIGN MATERIAL OUT OF IDG. APPLY A THIN COATING OF silicone compound, D00254 (C4) TO QAD RING FLANGE (80) AND GEARBOX PAD. APPLY A THIN COATING OF Never-Seez NSBT-8N compound, D00006 (C5) TO THE CONICAL SURFACE OF HEAD AND THREADS OF SCREWS (90).		
C4	D00254	. SILICONE COMPOUND	CON	AR
C5	D00006	. NEVER-SEEZ NSBT-8N COMPOUND	CON	AR
		ENSURE GASKET (85) IS IN POSITION ON AFT SIDE OF QAD RING (80).		
		POSITION QAD RING (80) ON GEARBOX ALIGNING -TOP- MARKING ON QAD RING WITH -TOP- MARKING ON GEARBOX.		
		INSTALL WITH SCREWS (90) AND TIGHTEN TO 275-300 POUND-INCHES (31.1-33.9 NEWTON METERS).		
75	762246	. QAD ADAPTER KIT (V99167) (SPEC S281A001-501)	VEN	1
80	762075	. . QAD RING (V99167) (1 SUPPLIED WITH QAD KIT (75))	REF	-
85	731476	. . GASKET (V99167) (1 SUPPLIED WITH QAD KIT (75))	REF	-
90	0646C624-18	. . SCREW (V99167) (12 SUPPLIED WITH QAD KIT (75))	REF	-

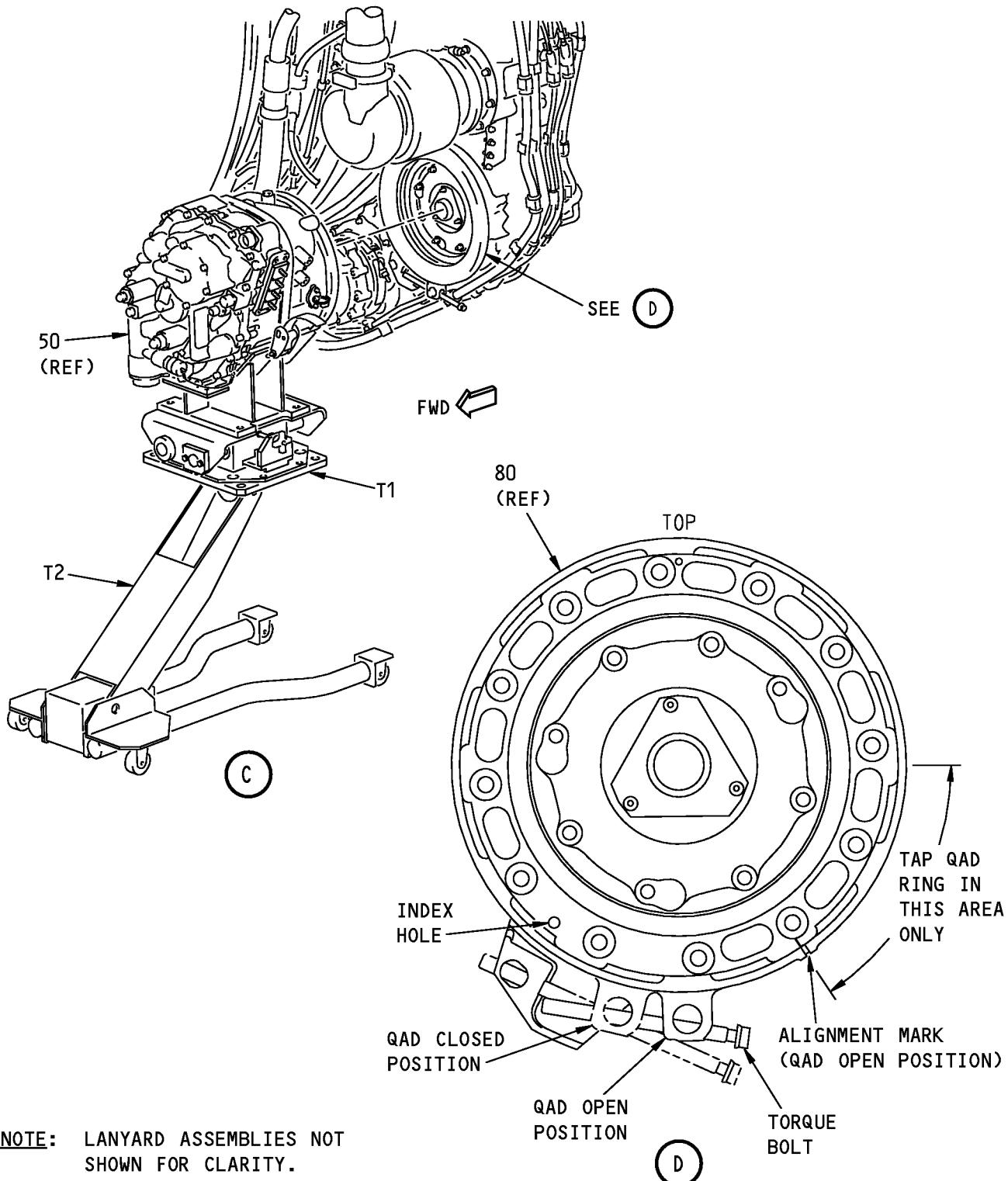
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P/P BUILDUP FIGURE 22-1

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POWERPLANT BUILDUP MANUALIntegrated Drive Generator Installation
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P/P BUILDUP FIGURE 22-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
22-1		<p>INTEGRATED DRIVE GENERATOR INSTALLATION (FIGURE 22-1, SHEET 4)</p> <p>CAUTION: DO NOT USE IDG DRIVE SHAFT FOR A HANDLE DURING INSTALLATION. USE PILOT FLANGE AREA FOR A HAND HOLD. SIDE LOADS ON DRIVE SHAFT CAN DAMAGE IDG CARBON SEALS.</p> <p>MAKE SURE VSCF and IDG jack adapter, SPL-1634 (T1) IS INSTALLED ON low profile hydraulic jack, COM-1443 (T2).</p> <p>SECURE IDG (50) TO JACK ADAPTER WITH STRAP.</p> <ul style="list-style-type: none"> . ADAPTER, SPL-1634 . LOW PROFILE HYDRAULIC JACK, COM-1443 (OR EQUIVALENT) <p>REMOVE LIFTING BOLT AND REINSTALL SUPPLIED FASTENER.</p> <p>TIGHTEN FASTENER TO 100-120 POUND-INCHES (11.3-13.6 NEWTON METERS).</p> <p>CAUTION: DO NOT ALLOW IDG TO HANG ON DRIVE SHAFT DURING INSTALLATION. FAILURE TO PROPERLY SUPPORT IDG MAY RESULT IN DAMAGE TO DRIVE SHAFT AND CARBON SEALS.</p> <p>POSITION IDG (50) AT GEARBOX PAD.</p> <p>ADJUST TORQUE BOLT ON QAD UNTIL OUTER RING OF QAD ROTATES TO THE OPEN POSITION.</p> <p>ALIGN INDEX MARKS ON QAD RING (80) AND IDG (50).</p> <p>MAKE SURE LUGS ON IDG FLANGE CAN ENTER THE QAD RING OPENINGS.</p> <p>ENGAGE DRIVE SHAFT SPLINE FIRST, THEN INDEX PIN.</p> <p>MAKE SURE INDEX PIN ON IDG ENGAGES INDEX HOLE ON QAD.</p> <p>SUPPORT AFT END OF IDG FOR 360-DEGREE CONTACT BETWEEN MATING SURFACES OF QAD RING AND IDG.</p> <p>ADJUST TORQUE BOLT UNTIL QAD RING ROTATES TO THE LOCKED POSITION.</p>		
T1	C24002		TOL	-
T2	HW93718		TOL	-

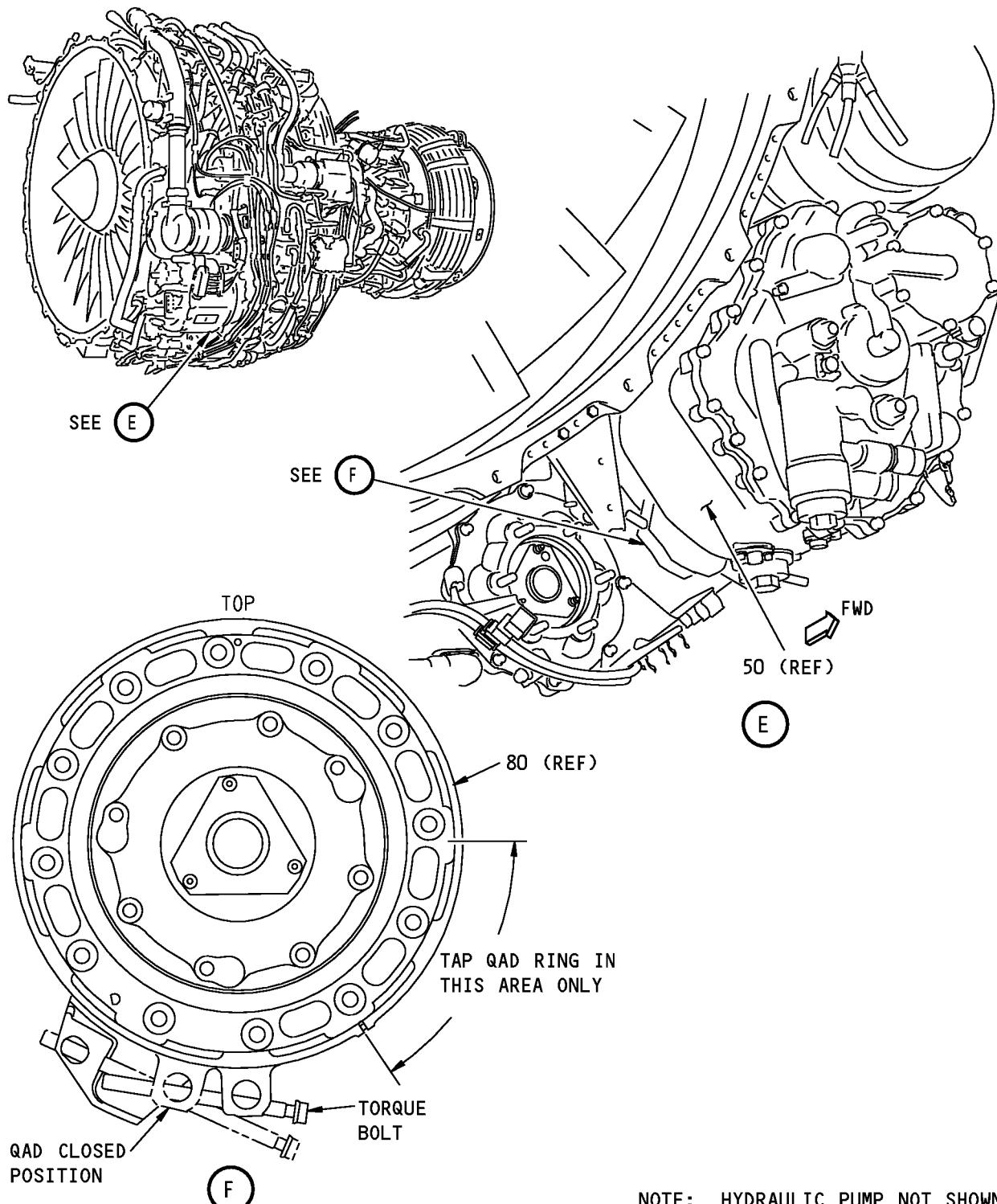
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P/P BUILDUP FIGURE 22-1

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POWERPLANT BUILDUP MANUALIntegrated Drive Generator Installation
Figure 22-1 (Sheet 5)

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P/P BUILDUP FIGURE 22-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
22-1		<p>INTEGRATED DRIVE GENERATOR INSTALLATION (FIGURE 22-1, SHEET 5)</p> <p>CAUTION: OBSERVE ACTION ON QAD RING DURING TIGHTENING TO PREVENT BINDING OR SNAGGING.</p> <p>TIGHTEN TORQUE BOLT SO THE QAD RING LUGS FULLY ENGAGE THE IDG FLANGE LUGS.</p> <p>TIGHTEN TORQUE BOLT TO 240-264 POUND-INCHES (27.1-29.8 NEWTON METERS).</p> <p>TAP QAD RING IN AREA SHOWN WITH SOFT MALLET OR BRASS DRIFT TO CENTER THE QAD RING AND PREVENT FALSE TORQUE READINGS.</p> <p>CHECK TORQUE VALUE ON TORQUE BOLT.</p> <p>IF THE TORQUE IS LESS THAN 180 POUND-INCHES (20.4 NEWTON METERS), TORQUE BOLT TO 240-264 POUND-INCHES (27.1-29.8 NEWTON METERS) AND REPEAT TAP-TORQUE PROCEDURE UNTIL THE TORQUE ON THE TORQUE BOLT DOES NOT DROP BELOW 180 POUND-INCHES (20.4 NEWTON METERS) AFTER TAPPING ON THE QAD RING.</p> <p>TIGHTEN TORQUE BOLT TO 240-264 POUND-INCHES (27.1-29.8 NEWTON METERS).</p> <p>IF THE FIRST TORQUE IS ABOVE 180 POUND-INCHES (20.4 NEWTON METERS), REPEAT TAPPING ON QAD RING AND CHECK TORQUE AGAIN.</p> <p>IF SECOND TORQUE REMAINS ABOVE 180 POUND-INCHES (20.4 NEWTON METERS), LOOSEN TORQUE BOLT.</p> <p>RETIGHTEN TORQUE BOLT TO 240-264 POUND-INCHES (27.1-29.8 NEWTON METERS).</p> <p>INSTALL safety cable kit, G50375 (C6) OR MS20995NC32 lockwire, G01912 (C7) ON TORQUE BOLT.</p> <ul style="list-style-type: none"> . SAFETY CABLE KIT . LOCKWIRE (OPT) <p>REMOVE IDG JACK EQUIPMENT (T1 THRU T2) FROM IDG (50).</p>		
C6 C7	G50375 G01912		CON CON	1 AR

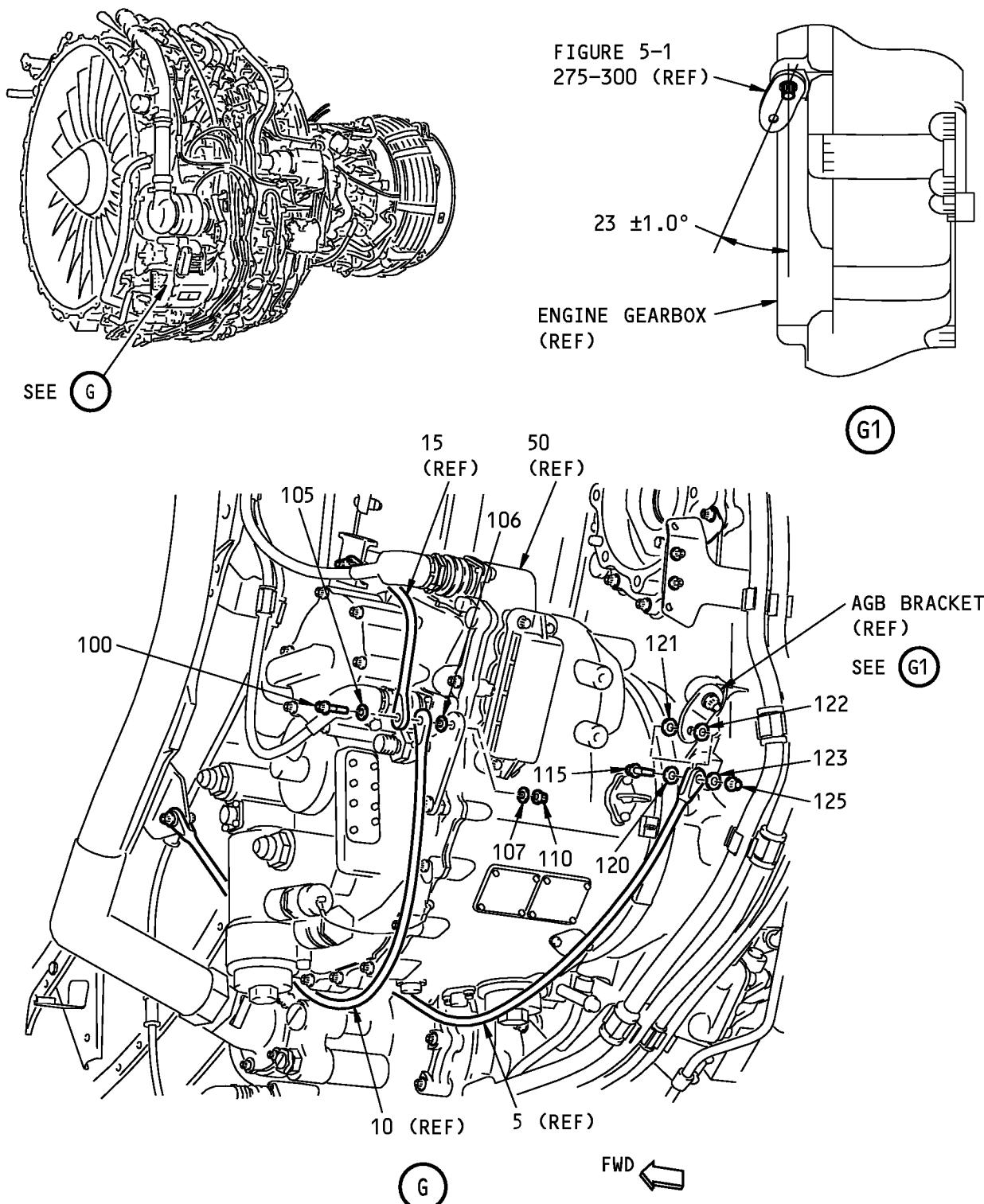
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P/P BUILDUP FIGURE 22-1

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Integrated Drive Generator Installation
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P/P BUILDUP FIGURE 22-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
22-1		INTEGRATED DRIVE GENERATOR INSTALLATION (FIGURE 22-1, SHEET 6) ROUTE LANYARD ASSY (10) UNDER IDG (50) AND ROUTE LANYARD ASSY (15) OVER TOP OF IDG (50). LOOSELY ATTACH LANYARD ASSYS (10) AND (15) TO IDG BRACKET USING BOLT (100), WASHERS (105, 106) AND NUT (110). . BOLT . WASHER (CSK) (UNDER BOLT HEAD) . WASHER (CSK) (OPTIONAL TO BACW10BP5ACU) . WASHER (PLAIN) (BTWN (10) AND IDG BRACKET) . WASHER (UNDER NUT) . NUT . NUT (OPTIONAL TO AS3485-11)		
100	BACB30LE5K14			1
105	BACW10BP5ACU			1
105	BACW10BP5CD		OPT	-
106	BACW10BP5APU			1
107	NAS1149E0563R			1
110	AS3485-11			1
110	BACN10HR5CS		OPT	-
		ROUTE LANYARD (5) UNDER IDG (50) AND LOOSELY ATTACH TO AGB BRACKET USING BOLT (115), WASHERS (120 THRU 123) AND NUT (125). <u>NOTE:</u> ORIENT BRACKET APPROXIMATELY AS SHOWN TO MAXIMIZE CLEARANCE TO THE IDG AND SURROUNDING HARDWARE. FAILURE TO PROPERLY ORIENT BRACKET CAN RESULT IN CHAFING BETWEEN IDG AND LANYARD (5).		
115	BACB30LE5K8	. BOLT		1
120	BACW10BP5ACU	. WASHER (CSK) (UNDER BOLT HEAD)		1
120	BACW10BP5CD	. WASHER (CSK) (OPTIONAL TO BACW10BP5ACU)	OPT	-
121	NAS1149E0532P	. WASHER (BETWEEN LANYARD CLEVIS AND AGB BRACKET) (BOLT SIDE)		1
122	NAS1149E0516P	. WASHER (BETWEEN LANYARD CLEVIS AND ENGINE BRKT) (NUT SIDE)		1
123	NAS1149E0563R	. WASHER (UNDER NUT)		1
125	AS3485-11	. NUT		1
125	BACN10HR5CS	. NUT (OPTIONAL TO AS3485-11)	OPT	-
		ORIENT LANYARD ASSYS (5), AND (15) TO ACHIEVE MAXIMUM CLEARANCE WITH THE SURROUNDING EQUIPMENT.		
		ORIENT LANYARD ASSY (10) TO MAINTAIN A CLEARANCE OF 0.03 - 0.13 INCHES FROM FASTENER ON IDG BRACKET ASSY.		
		TIGHTEN BOLTS (20) TO 100-150 POUND-INCHES (11.3-17.0 NEWTON METERS).		
		TIGHTEN BOLTS (100) AND (115) TO 100-150 POUND-INCHES (11.3-17.0 NEWTON METERS).		

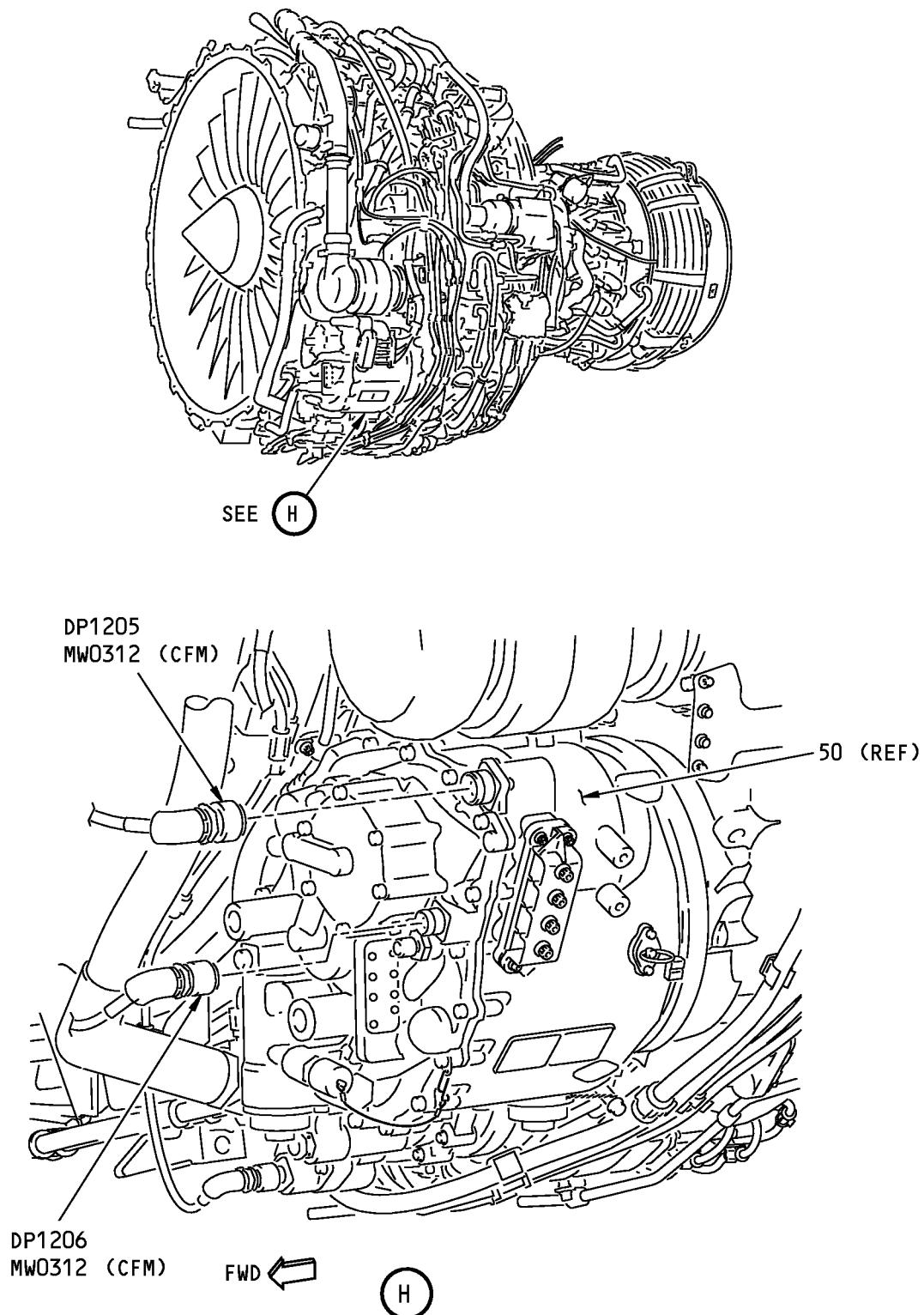
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P/P BUILDUP FIGURE 22-1

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POWERPLANT BUILDUP MANUALIntegrated Drive Generator Installation
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P/P BUILDUP FIGURE 22-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
22-1		<p>INTEGRATED DRIVE GENERATOR INSTALLATION (FIGURE 22-1, SHEET 7)</p> <p>CAUTION: DO NOT OVERTIGHTEN THE PLUG COUPLING RING. DO NOT USE WATER PUMP PLIERS, PIPE WRENCHES OR VISE GRIPS TO TIGHTEN THE COUPLING RING OR DAMAGE TO THE ELECTRICAL CONNECTOR CAN OCCUR.</p> <p>CONNECT MW0312 ELECTRICAL CONNECTOR, DP1205, TO TOP RECEPTACLE AND MW0312 ELECTRICAL CONNECTOR, DP1206, TO LOWER RECEPTACLE.</p> <p>TURN KNULED COUPLING RING WHILE WIGGLING THE BACKSHELL ASSEMBLY.</p> <p>AFTER FULLY SEATING THE COUPLING RING, USE SOFT-JAWED PLIERS OR A STRAP WRENCH TO TIGHTEN THE COUPLING RING AN ADDITIONAL 1/8 TURN OR UNTIL PLIER SLIPPAGE OCCURS.</p>		

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P/P BUILDUP FIGURE 22-1

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FIGURE 23-1

IDG AIR/OIL COOLER INSTALLATION

REF QEC TASK NO.: 23

REF DWG: 332A2600

NOTE: ALL STANDARDS AND ATTACHING HARDWARE FOR THIS FIGURE WILL BE PACKAGED IN QEC TASK NO. 110.

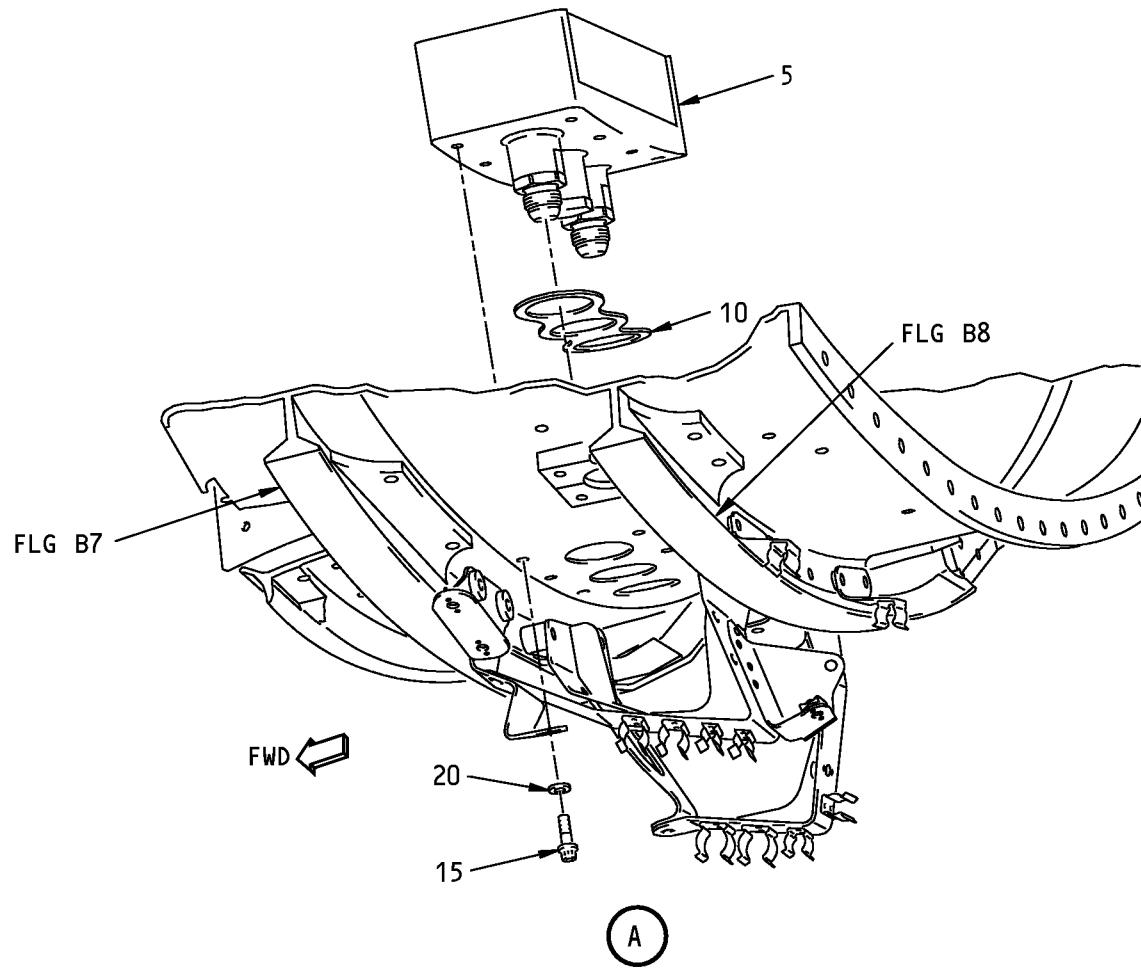
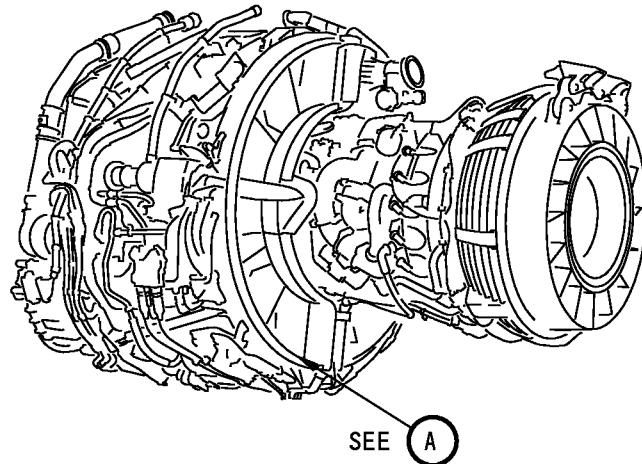
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P/P BUILDUP FIGURE 23-1

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NOTE: CFMI WIRE HARNESSES NOT SHOWN FOR CLARITY.

IDG Air/Oil Cooler Installation
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P/P BUILDUP FIGURE 23-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
23-1		IDG AIR/OIL COOLER INSTALLATION (FIGURE 23-1, SHEET 1) REMOVE PROTECTIVE PLATE AND BOLTS, WASHERS AND NUTS FROM IDG COOLER PORT ON FAN CASE. INSTALL GASKET (10) ON IDG AIR/OIL COOLER (5). . IDG AIR/OIL COOLER (V78943) (SPEC S332A260-1) .. GASKET (V78943) (SPEC S332A260-4) (SUPPLIED WITH IDG AIR/OIL COOLER) APPLY Never-Seez NSBT-8N compound, D00006 (C1) TO IDG AIR/OIL COOLER (5) THREADED INSERTS (8 LOCATIONS). POSITION IDG AIR/OIL COOLER (5) ON FAN CASE AT APPROXIMATELY THE 6:30 O'CLOCK POSITION BETWEEN FLGS B7 AND B8. ATTACH IDG AIR/OIL COOLER TO FAN CASE WITH BOLTS (15) AND WASHERS (20) INSTALLED THROUGH FAN CASE EXTERIOR. .. BOLT .. WASHER .. NEVER SEEZ NSBT-8N COMPOUND TIGHTEN BOLTS (15) TO 70-80 POUND-INCHES (7.9-9.0 NEWTON METERS). MAKE SURE PROTECTIVE CAPS ARE INSTALLED ON IDG AIR/OIL COOLER PORTS.		
5	UA538551-3		VEN	1
10	U542648		REF	-
15	BACB30ZF4-10			8
20	NAS1149C0463R			8
C1	D00006		CON	AR

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P/P BUILDUP FIGURE 23-1

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FIGURE 24-1

IDG PLUMBING INSTALLATION

REF QEC TASK NO.: 24

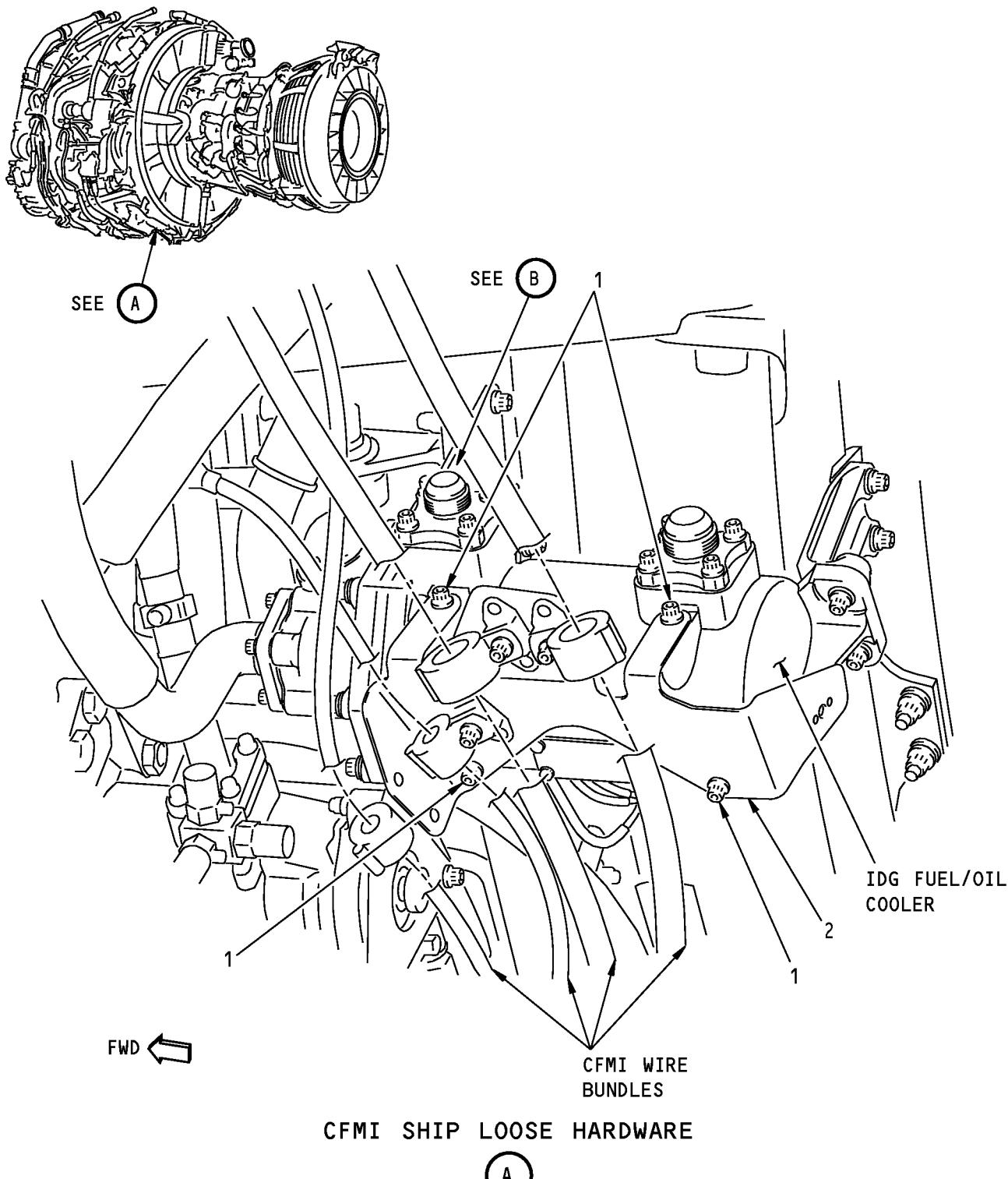
REF DWG: 332A2100

NOTE: ALL STANDARDS AND ATTACHING HARDWARE FOR THIS FIGURE WILL BE PACKAGED IN QEC TASK NO. 110.

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P/P BUILDUP FIGURE 24-1
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P/P BUILDUP FIGURE 24-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
24-1		<p>IDG PLUMBING INSTALLATION (FIGURE 24-1, SHEET 1)</p> <p>NOTE: IN THIS PROCEDURE, DO NOT TIGHTEN SCREWS AND TUBES OR ELBOW NUTS UNLESS INSTRUCTED OR INSTALL PARTS IN A DIFFERENT SEQUENCE.</p> <p>TO REDUCE TUBE ASSY CLAMP DISTORTION UPON INSTALLATION, APPLY Never-Seez NSBT-8N compound, D00006 (C1) TO BOLT HEAD SURFACE THAT COMES INTO CONTACT WITH THE CLAMP. APPLY TO BOLT HEAD ONLY. DO NOT APPLY TO BOLT THREADS.</p> <p>CAUTION: IN THIS PROCEDURE WHEN TIGHTENING TUBE OR ELBOW NUTS, USE TWO WRENCHES; ONE TO HOLD THE SPANNER FLATS ON THE NIPPLE AND ONE TO TIGHTEN THE NUT.</p> <p>CFMI SHIP LOOSE HARDWARE (INSTALLED BY CFMI ON SOME ENGINES)</p> <p>APPLY Never-Seez NSBT-8N compound, D00006 (C1) TO THREADS OF BOLTS (1)</p> <ul style="list-style-type: none"> . BOLT (4 REQD)^[1] . NEVER SEEZ NSBT-8N COMPOUND <p>ATTACH BRACKET ASSY (2) TO IDG FUEL/OIL COOLER WITH LUBRICATED BOLTS (1).</p> <ul style="list-style-type: none"> . BRACKET ASSY (1 REQD)^[1] <p>TIGHTEN BOLTS (1) TO 100-110 POUND-INCHES (11.3-12.4 NEWTON METERS).</p> <p>NOTE: TO ALLOW BETTER ACCESS, DO NOT SECURE CFMI WIRE BUNDLES IN HINGE CLAMPS OF BRACKET ASSY AT THIS TIME. WIRE BUNDLES WILL BE SECURED AT THE END OF THE PROCEDURE.</p> <p>*[1] PART NUMBERS ARE SHOWN FOR REFERENCE ONLY AND ARE SUBJECT TO CHANGE. REFER TO CFMI ILLUSTRATED PARTS CATALOG (IPC) 72-00-00-23 FOR LATEST PART NUMBER INFORMATION.</p>		
1 C1	BACB30ZF4-08 D00006		REF CON	- AR
2	340-087-904-0		REF	-

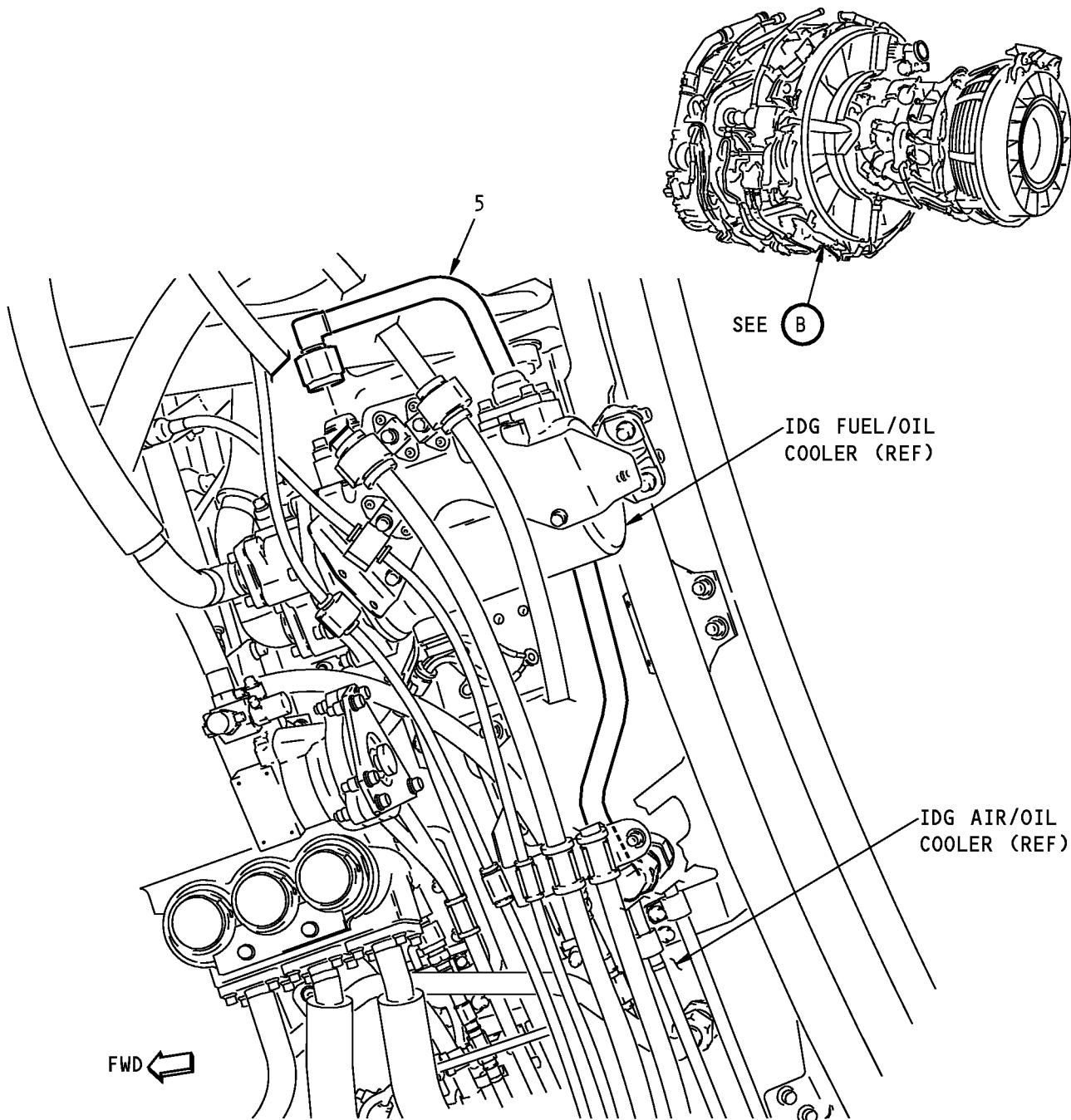
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P/P BUILDUP FIGURE 24-1

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POWERPLANT BUILDUP MANUAL

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IDG Plumbing Installation
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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
24-1 5	332A2240-10	IDG PLUMBING INSTALLATION (FIGURE 24-1, SHEET 2) LOOSELY INSTALL TUBE ASSY (5) TO FORWARD NIPPLE ON FUEL/OIL COOLER AND OUTBOARD NIPPLE ON AIR/OIL COOLER. HAND TIGHTEN TUBE NUT ONLY. . TUBE ASSY		1

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P/P BUILDUP FIGURE 24-1

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IDG Plumbing Installation
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P/P BUILDUP FIGURE 24-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
24-1		IDG PLUMBING INSTALLATION (FIGURE 24-1, SHEET 3) THIS SHEET NOT USED		

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P/P BUILDUP FIGURE 24-1

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IDG Plumbing Installation
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P/P BUILDUP FIGURE 24-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
24-1		IDG PLUMBING INSTALLATION (FIGURE 24-1, SHEET 4) THIS SHEET NOT USED		

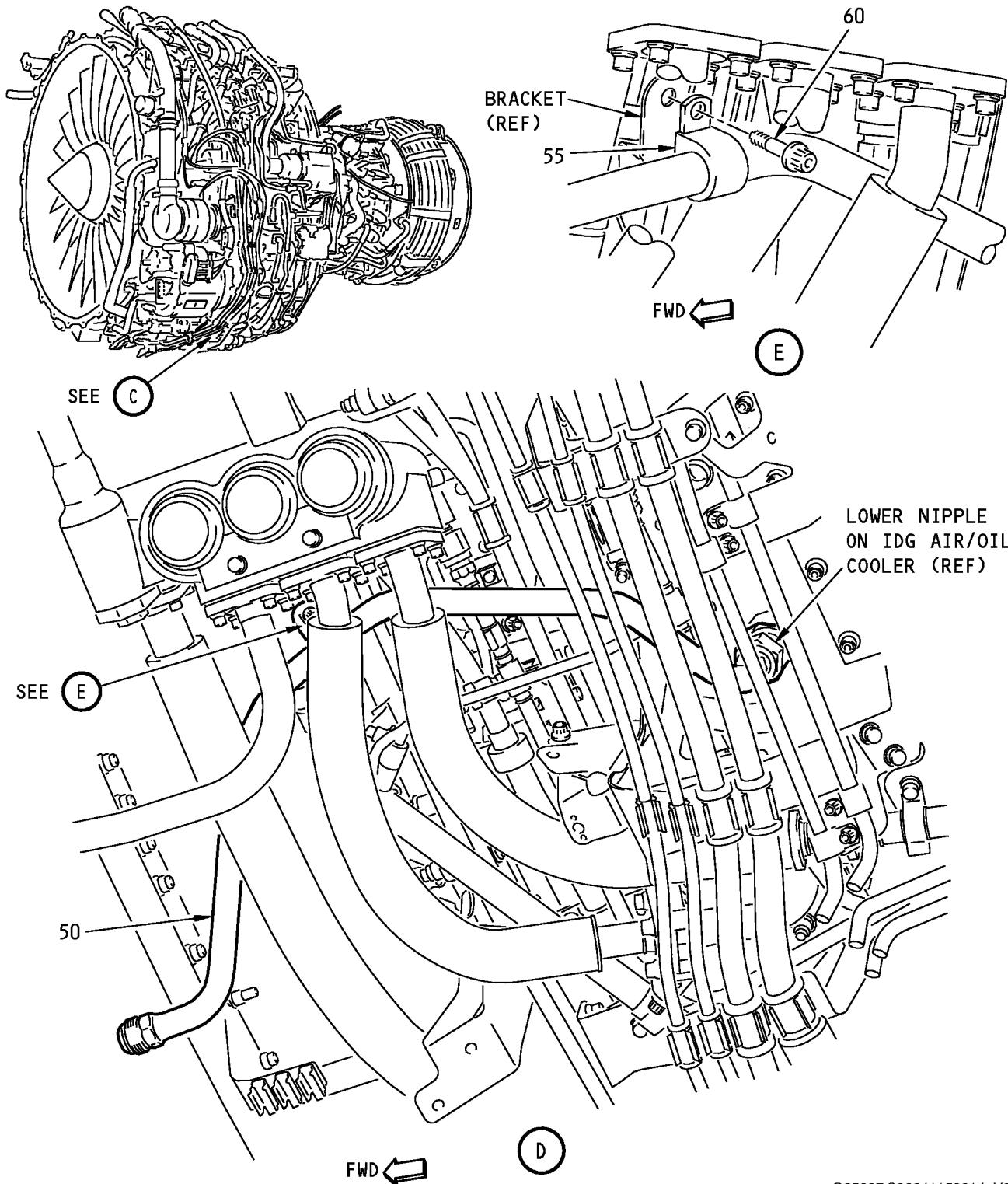
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P/P BUILDUP FIGURE 24-1

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POWERPLANT BUILDUP MANUAL

G25907 S00041153914_V2

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P/P BUILDUP FIGURE 24-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
24-1		IDG PLUMBING INSTALLATION (FIGURE 24-1, SHEET 5) REMOVE PROTECTIVE COVER FROM LOWER NIPPLE ON IDG AIR/OIL COOLER. POSITION TUBE ASSY (50) UNDER OIL SCAVENGE TUBES AND CFMI WIRE BUNDLES AND LOOSELY CONNECT TUBE NUT TO NIPPLE ON IDG AIR/OIL COOLER.		
50	332A2240-1	. TUBE ASSY APPLY LIGHT COATING OF Never-Seez NSBT-8N compound, D00006 (C1) TO UNDERSIDE HEAD OF BOLT (60). ATTACH TUBE ASSY (50) TO ENGINE BRACKET NEXT TO MCD HOUSING. USE CLAMP (55) AND BOLT (60).		1
55	J1221G10	. CLAMP (V07482)	VEN	1
60	BACB30ZF4-06	. BOLT		1
C1	D00006	. NEVER SEEZ NSBT-8N COMPOUND TIGHTEN BOLT (60) TO 73-77 POUND-INCHES (8.24-8.69 NEWTON METERS).	CON	AR

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P/P BUILDUP FIGURE 24-1

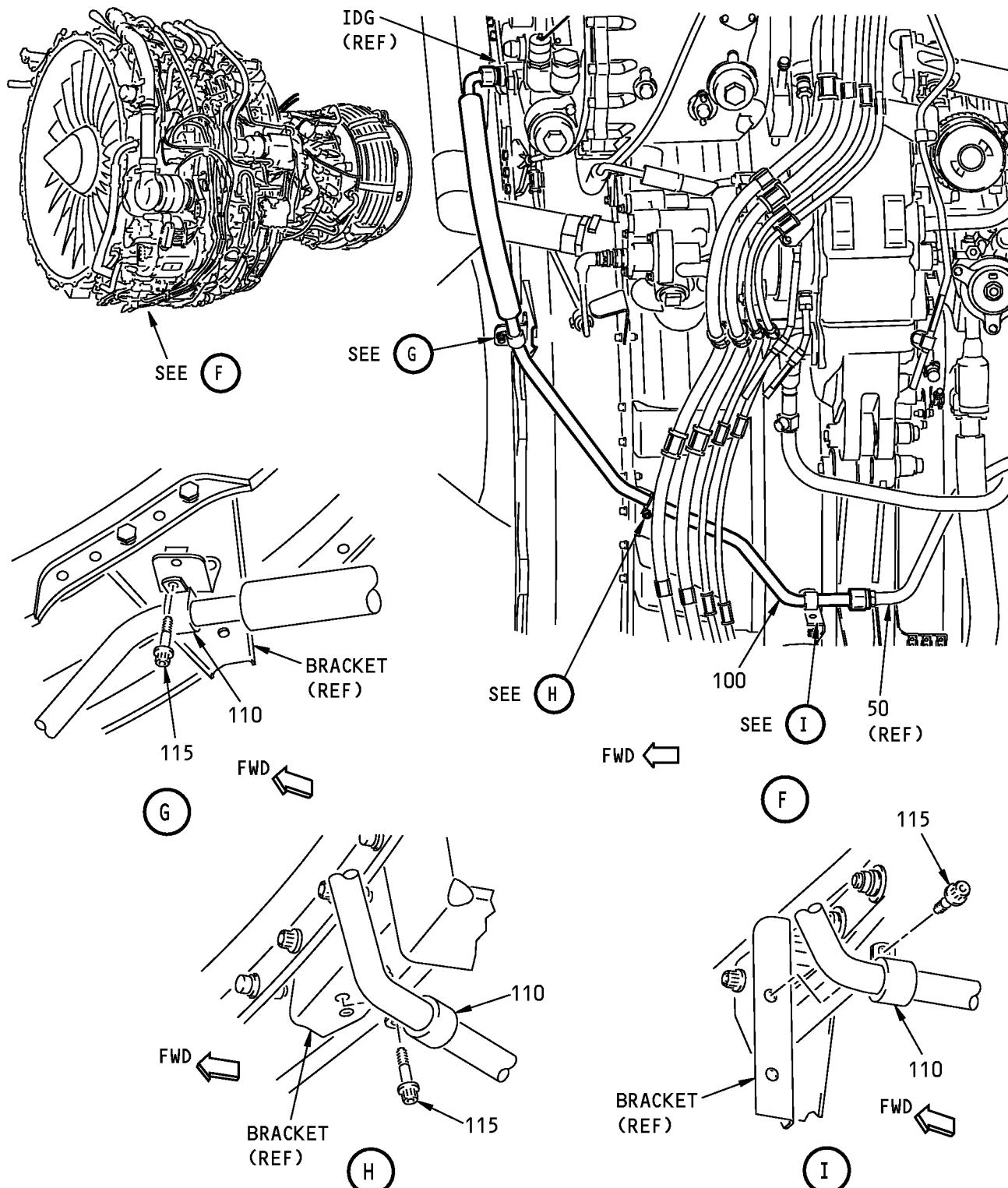
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IDG Plumbing Installation Figure 24-1 (Sheet 6)

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P/P BUILDUP FIGURE 24-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
24-1		IDG PLUMBING INSTALLATION (FIGURE 24-1, SHEET 6)		
100	115096-4	<p>LOOSELY ATTACH HOSE/TUBE ASSY (100) TO TUBE ASSY (50) AND TO OIL-OUT NIPPLE (INBOARD LOCATION) ON IDG. HAND TIGHTEN TUBE NUTS ONLY.</p> <p>. IDG HOSE/TUBE ASSY (V78570) (SPEC S332A240-4)</p> <p>APPLY LIGHT COATING OF Never-Seez NSBT-8N compound, D00006 (C1) TO UNDERSIDE HEAD OF BOLTS (115). AT THREE LOCATIONS, LOOSELY ATTACH HOSE/TUBE ASSY (100) TO ENGINE BRACKETS WITH CLAMPS (110) AND BOLTS (115).</p>	VEN	1
110	J1221G10	. CLAMP (V07482)	VEN	3
115	BACB30ZF4-06	. BOLT	CON	3
C1	D00006	. NEVER SEEZ NSBT-8N COMPOUND	AR	

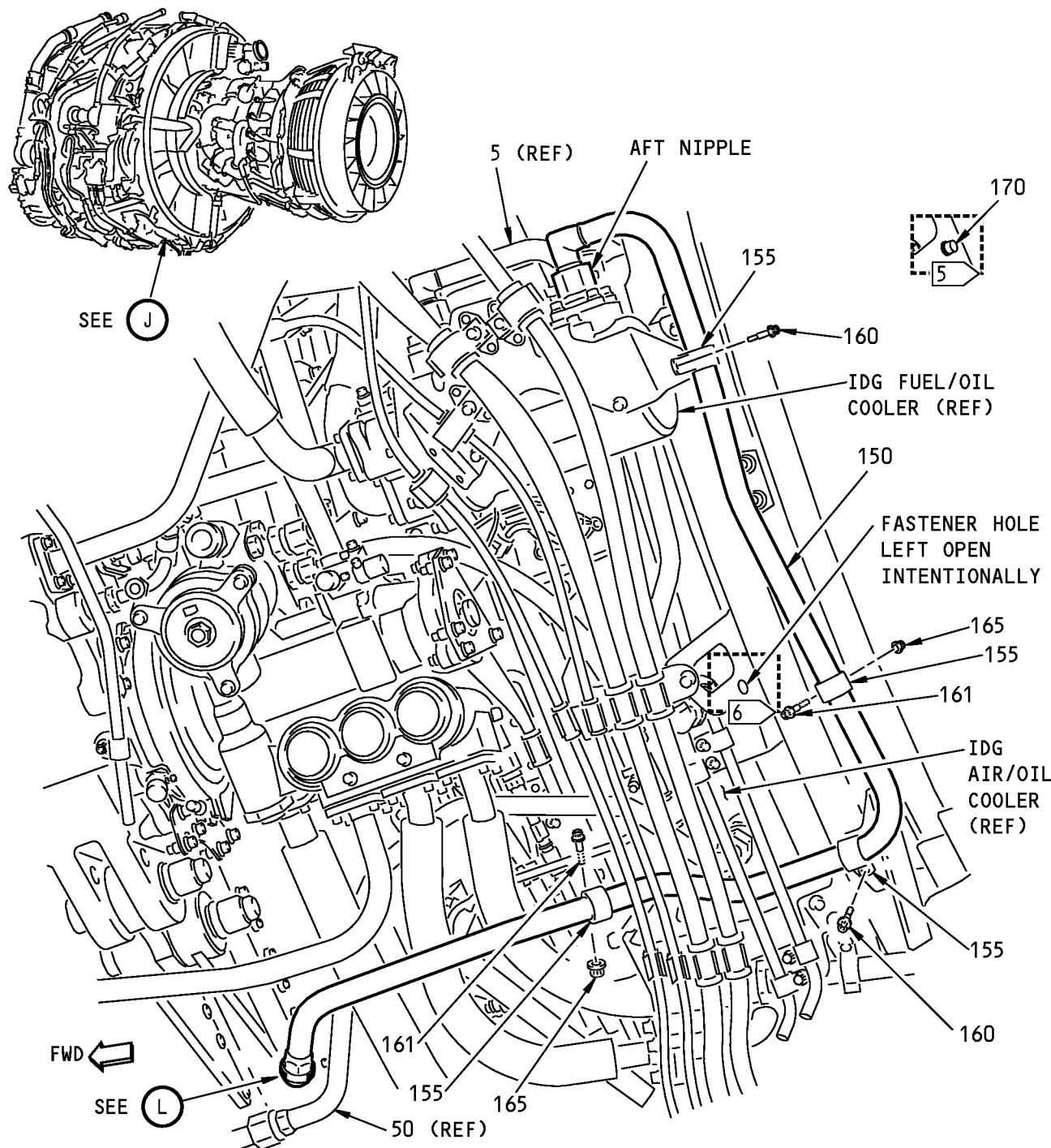
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P/P BUILDUP FIGURE 24-1

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5 → WITH FASTENER

6 → WITHOUT FASTENER



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IDG Plumbing Installation
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P/P BUILDUP FIGURE 24-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
24-1		IDG PLUMBING INSTALLATION (FIGURE 24-1, SHEET 7) REMOVE PROTECTIVE COVER FROM AFT NIPPLE OF FUEL/OIL COOLER. LOOSELY ATTACH TUBE ASSY (150) TO AFT NIPPLE ON IDG FUEL/OIL COOLER. HAND TIGHTEN TUBE NUT. . TUBE ASSY		
150	332A2240-11	APPLY LIGHT COATING OF Never-Seez NSBT-8N compound, D00006 (C1) TO UNDERSIDE HEAD OF BOLTS (160, 161). AT FOUR LOCATIONS, LOOSELY ATTACH TUBE ASSY (150) TO ENGINE BRACKETS USING CLAMPS (155), BOLTS (160, 161) AND NUTS (165). . CLAMP (V07482)	VEN	4
160	BACB30ZF4-06	. BOLT		2
161	BACB30ZF4-08	. BOLT		2
165	AS3485-10	. NUT		2
C1	D00006	. NEVER SEEZ NSBT-8N COMPOUND <u>WITH FASTENER</u> INSTALL BOLT (170) IN FASTENER HOLE. . BOLT (1 REQD) <u>WITHOUT FASTENER</u> FASTENER HOLE LEFT OPEN INTENTIONALLY.	CON	AR
170	BACB30ZF4-07		LTD	-

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P/P BUILDUP FIGURE 24-1

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IDG Plumbing Installation
Figure 24-1 (Sheet 8)

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
24-1		IDG PLUMBING INSTALLATION (FIGURE 24-1, SHEET 8) THIS SHEET NOT USED		

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P/P BUILDUP FIGURE 24-1

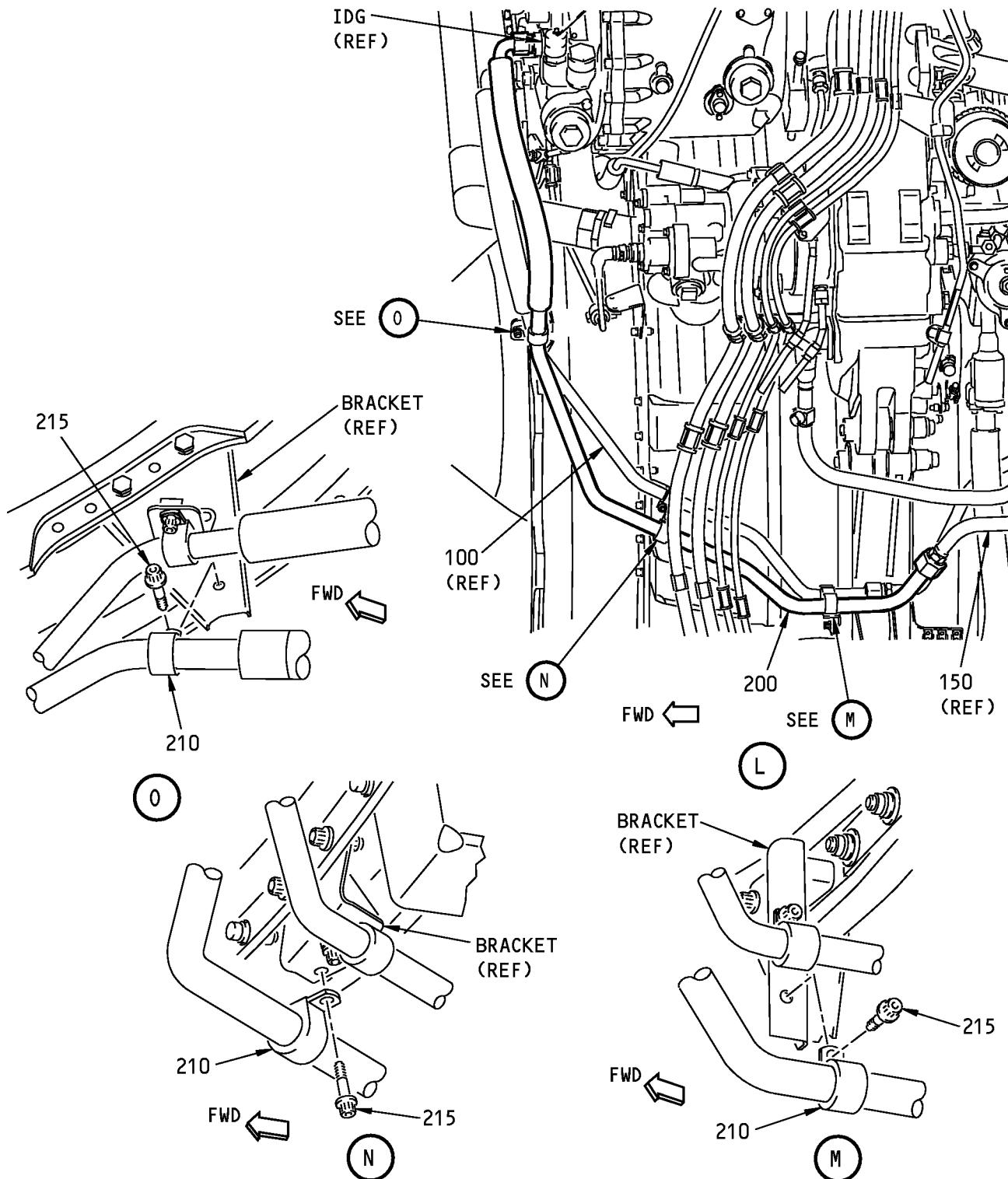
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IDG Plumbing Installation Figure 24-1 (Sheet 9)

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P/P BUILDUP FIGURE 24-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
24-1		IDG PLUMBING INSTALLATION (FIGURE 24-1, SHEET 9) LOOSELY ATTACH HOSE/TUBE ASSEMBLY (200) TO TUBE ASSY (150) AND TO OIL-IN NIPPLE (OUTBOARD LOCATION) ON IDG. HAND TIGHTEN TUBE NUTS ONLY.		
200	115096-2	. IDG HOSE/TUBE ASSY (V78570) (SPEC S332A240-2) APPLY LIGHT COATING OF Never-Seez NSBT-8N compound, D00006 (C1) TO UNDERSIDE HEAD OF BOLTS (215). AT THREE LOCATIONS, LOOSELY ATTACH HOSE/TUBE ASSY (200) TO ENGINE BRACKETS WITH CLAMPS (210) AND BOLTS (215).	VEN	1
210	J1221G12	. CLAMP (V07482)	VEN	3
215	BACB30ZF4-06	. BOLT	CON	3
C1	D00006	. NEVER SEEZ NSBT-8N COMPOUND	AR	

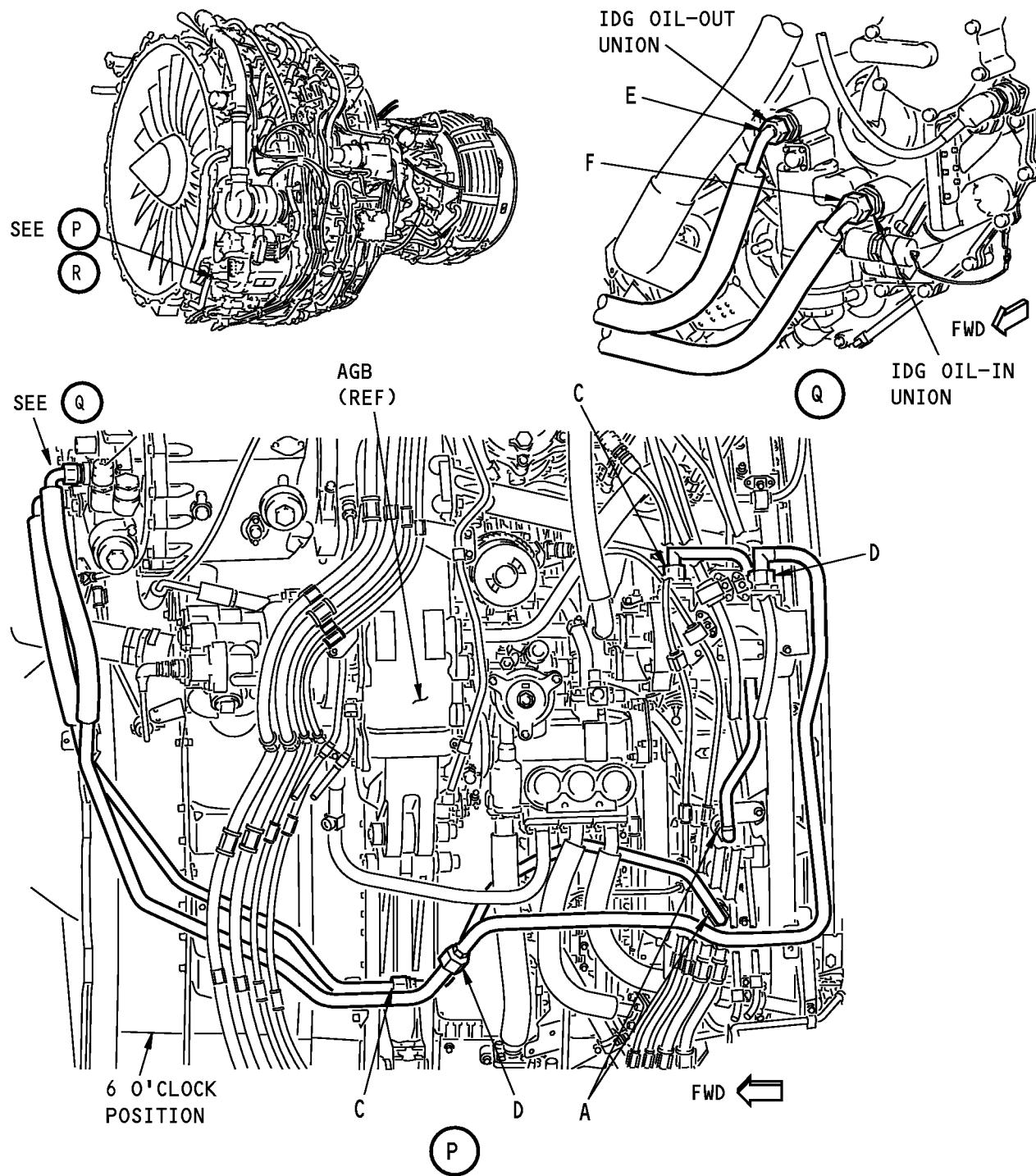
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P/P BUILDUP FIGURE 24-1

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P/P BUILDUP FIGURE 24-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
24-1		<p>IDG PLUMBING INSTALLATION (FIGURE 24-1, SHEET 10)</p> <p>ADJUST ALL TUBES TO BEST POSITION TO MAKE SURE NO PRELOAD FORCE ON TUBES OR VALVE ARE PRESENT.</p> <p>TIGHTEN ALL CONNECTIONS AS FOLLOWS. USE THE LOCATION SHOWN ON THE VIEWS TO TELL YOU WHAT TORQUE VALUE TO APPLY.</p> <p><u>LOCATION A:</u></p> <p>TIGHTEN TUBE NUT TO 342-378 POUND-INCHES (38.6-42.7 NEWTON METERS). BACK OFF NUT TO RELAX TORQUE, THEN RETIGHTEN.</p> <p><u>LOCATION C:</u></p> <p>TIGHTEN TUBE NUT TO 665-735 POUND-INCHES (75.1-83.0 NEWTON METERS). BACK OFF NUT TO RELAX TORQUE, THEN RETIGHTEN.</p> <p><u>LOCATION D:</u></p> <p>TIGHTEN TUBE NUT TO 855-945 POUND-INCHES 96.6-106.8 NEWTON METERS). BACK OFF NUT TO RELAX TORQUE, THEN RETIGHTEN.</p> <p><u>LOCATION E:</u></p> <p>TIGHTEN TUBE NUT TO 475-525 POUND-INCHES 53.7-59.3 NEWTON METERS). USE BACKUP WRENCH ON IDG UNION TO PREVENT TORQUE TRANSFER. BACK OFF NUT TO RELAX TORQUE, THEN RETIGHTEN.</p> <p><u>LOCATION F:</u></p> <p>TIGHTEN TUBE NUT TO 665-735 POUND-INCHES 75.1-83.0 NEWTON METERS). USE BACKUP WRENCH ON IDG UNION TO PREVENT TORQUE TRANSFER. BACK OFF NUT TO RELAX TORQUE, THEN RETIGHTEN.</p>		

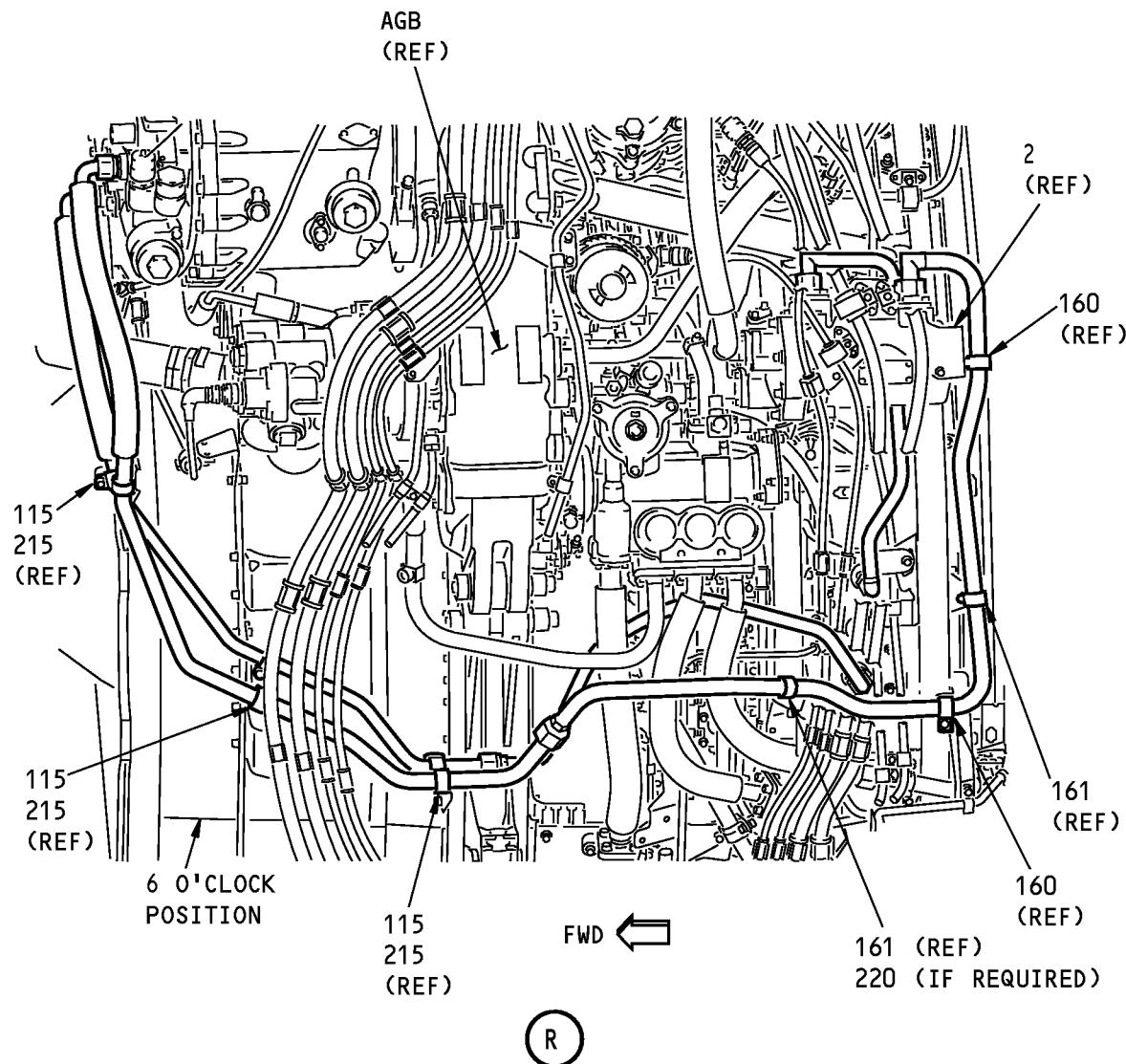
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P/P BUILDUP FIGURE 24-1

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POWERPLANT BUILDUP MANUALIDG Plumbing Installation
Figure 24-1 (Sheet 11)

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P/P BUILDUP FIGURE 24-1

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737-600/700/800/900
POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
24-1 220	332W1910-9	<p>IDG PLUMBING INSTALLATION (FIGURE 24-1, SHEET 11)</p> <p>ADJUST ALL CLAMPS TO BEST POSITION TO MAKE SURE NO PRELOAD FORCES EXIST ON TUBES OR VALVES. IF REQUIRED, INSTALL UP TO 3 SPACERS (220) UNDER CLAMP FOOT AT LOCATION SHOWN TO ELIMINATE PRELOAD.</p> <p>. SPACER (3 MAX ALLOWED)</p> <p>TIGHTEN BOLTS (25), (115), (160), (161) AND (215) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS).</p> <p>SECURE CFMI WIRE BUNDLES IN HINGED CLAMPS OF BRACKET (2).</p>	AR	3

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P/P BUILDUP FIGURE 24-1

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FIGURE 25-1

STARTER VALVE AND DUCT INSTALLATION

REF QEC TASK NO.: 25

REF DWG: 332A2300

NOTE: ALL STANDARDS AND ATTACHING HARDWARE FOR THIS FIGURE WILL BE PACKAGED IN QEC TASK NO. 110.

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P/P BUILDUP FIGURE 25-1

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THIS SHEET NOT USED

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Starter Valve and Duct Installation
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P/P BUILDUP FIGURE 25-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
25-1		STARTER VALVE AND DUCT INSTALLATION (FIGURE 25-1, SHEET 1) THIS SHEET NOT USED		

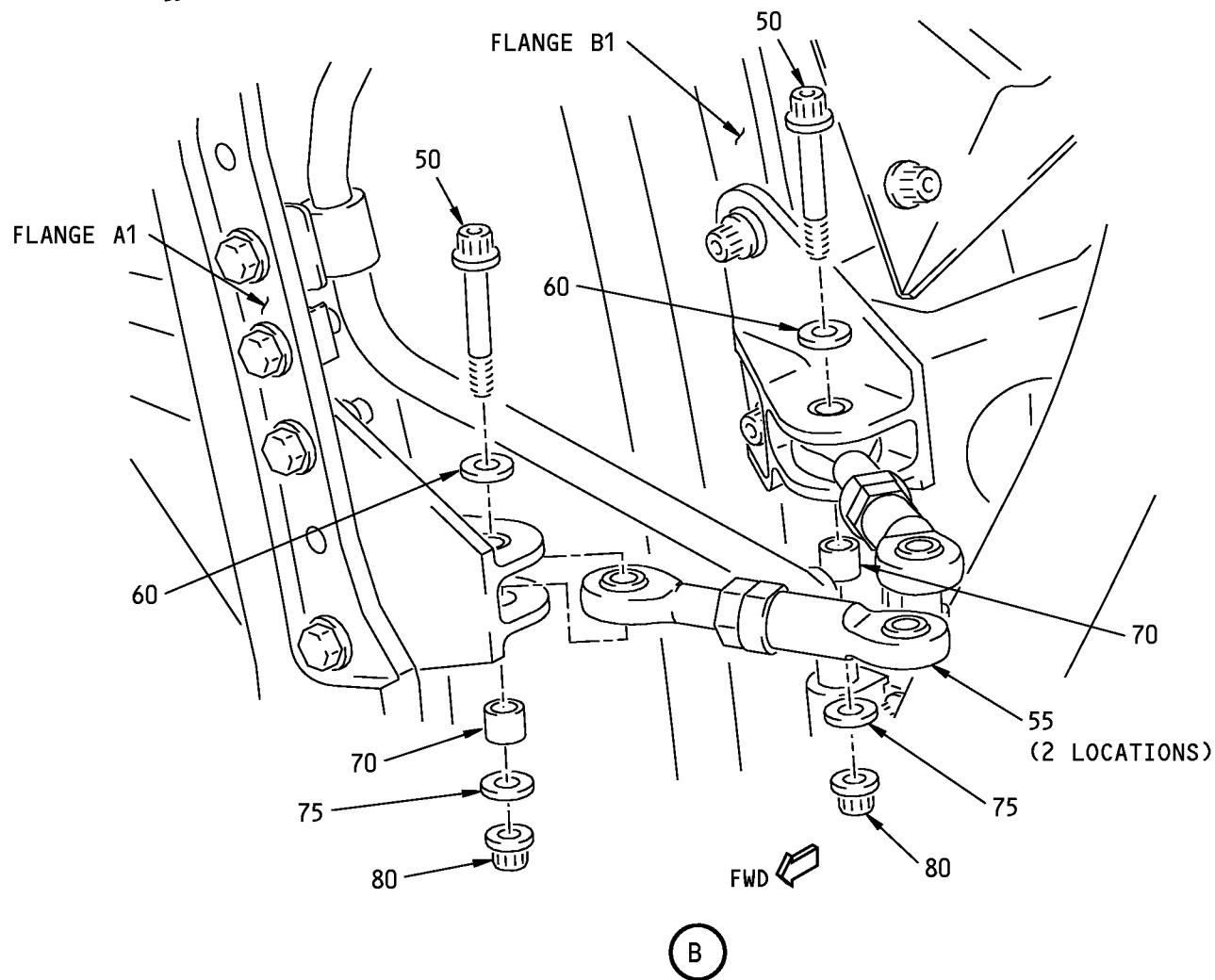
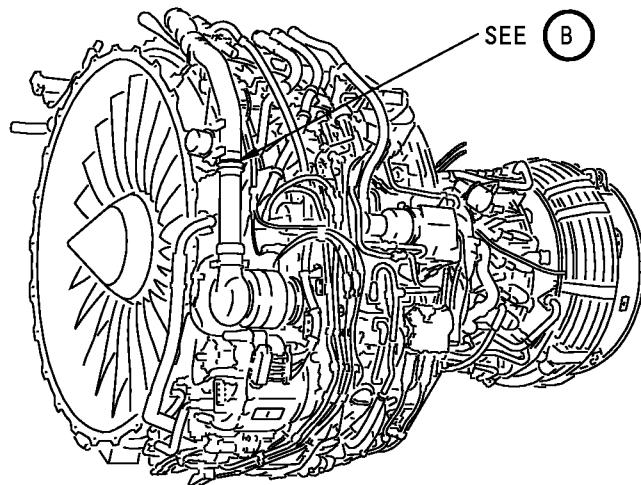
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P/P BUILDUP FIGURE 25-1

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POWERPLANT BUILDUP MANUALStarter Valve and Duct Installation
Figure 25-1 (Sheet 2)

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P/P BUILDUP FIGURE 25-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
25-1		STARTER VALVE AND DUCT INSTALLATION (FIGURE 25-1, SHEET 2)		
50		LUBRICATE THREADS AND SHANK OF BOLTS (50) WITH Never-Seez NSBT-8N compound, D00006 (C1).		
C1	BACB30PN4-14 D00006	. BOLT . NEVER SEEZ NSBT-8N COMPOUND	CON	2 AR
55	322U2338-2	LOOSEN JAMNUTS OF LINK ASSEMBLIES (55) TO FREE ROD ENDS.		2
60	BACW10BP4ACU	ADJUST LINKS TO 3.00 INCHES (7.62 CM) MEASURED FROM THE CENTERLINE OF SPHERICAL BEARINGS. RETIGHTEN JAMNUTS.		2
70	BACB28AK04-030	ATTACH LINK ASSEMBLIES (55) TO ENGINE BRACKETS AT 10:30 O'CLOCK POSITIONS ON FLGS A1 AND B1 WITH LUBRICATED BOLTS (50), WASHERS (60) AND (75), BUSHINGS (70) AND NUTS (80).		2
75	NAS1149C0432R	. LINK ASSY . WASHER (CSK) (UNDER BOLTHEAD)		2
80	AS3485-10	. BUSHING . WASHER (UNDER NUT)		2
		. NUT		2
		CAUTION: BEFORE TIGHTENING NUT, MAKE SURE BUSHING IS FULLY ENGAGED.		
		TIGHTEN BOLTS (50) TO 50-75 POUND-INCHES (5.6-8.5 NEWTON METERS).		

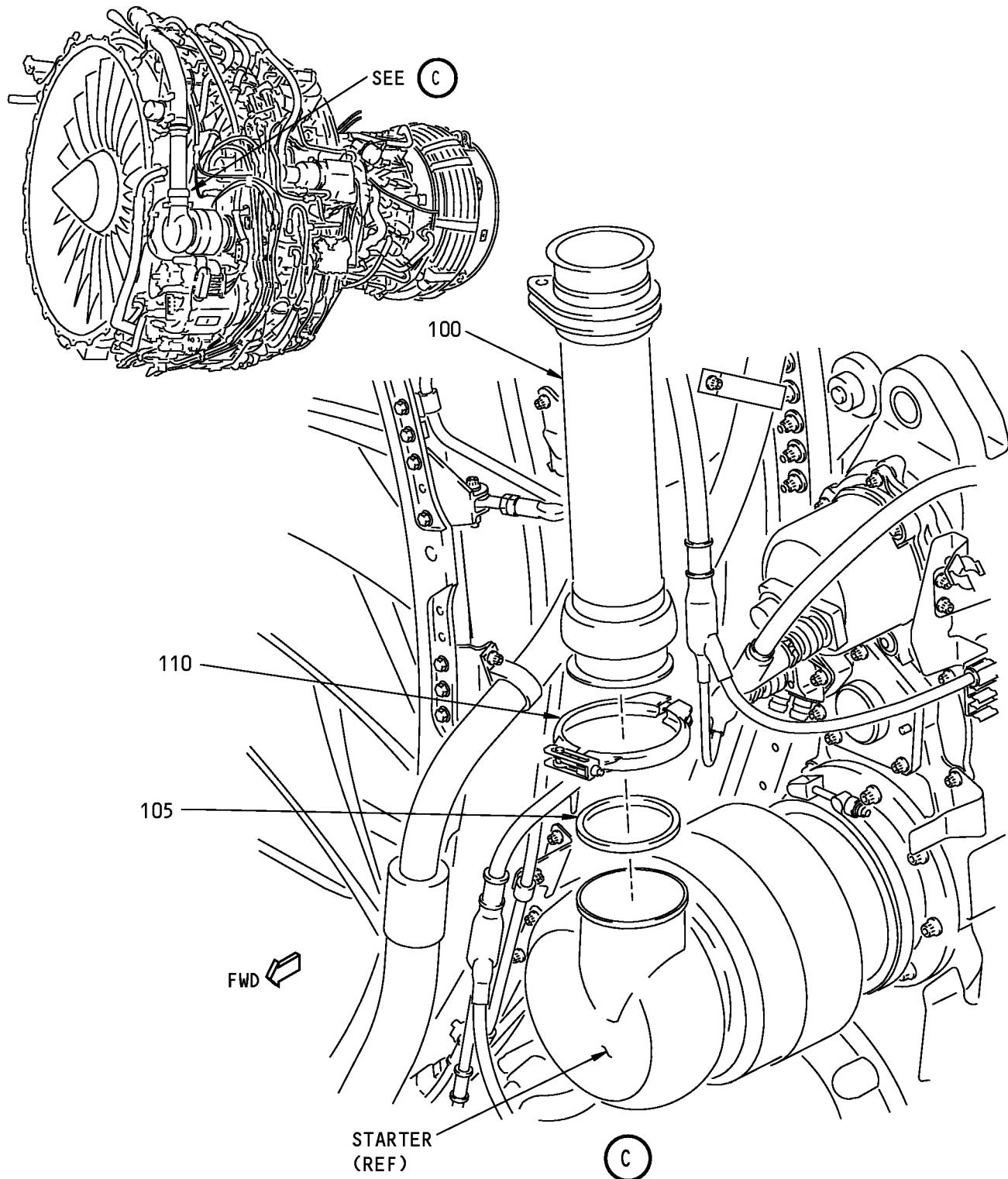
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P/P BUILDUP FIGURE 25-1

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P/P BUILDUP FIGURE 25-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
25-1		STARTER VALVE AND DUCT INSTALLATION (FIGURE 25-1, SHEET 3) INSTALL SEAL (105) IN BOTTOM END OF DUCT ASSY (100). POSITION DUCT (100) ON TOP PORT OF STARTER ALIGNING KEY-SLOT IN DUCT WITH KEY ON STARTER AND LOOSELY SECURE WITH COUPLING (110). <u>NOTE:</u> DO NOT TIGHTEN COUPLING AT THIS TIME. <u>NOTE:</u> EARLIER STARTERS MAY NOT HAVE KEY.		
100	332A2313-1	. DUCT ASSY		1
105	AS1895-7-325	. SEAL		1
105	AS1895/7-325	. SEAL (OPTIONAL TO AS1895-7-325)	OPT	-
110	AS1895-4-325	. COUPLING		1
110	AS1895/4-325	. COUPLING (OPTIONAL TO AS1895-4-325)	OPT	-

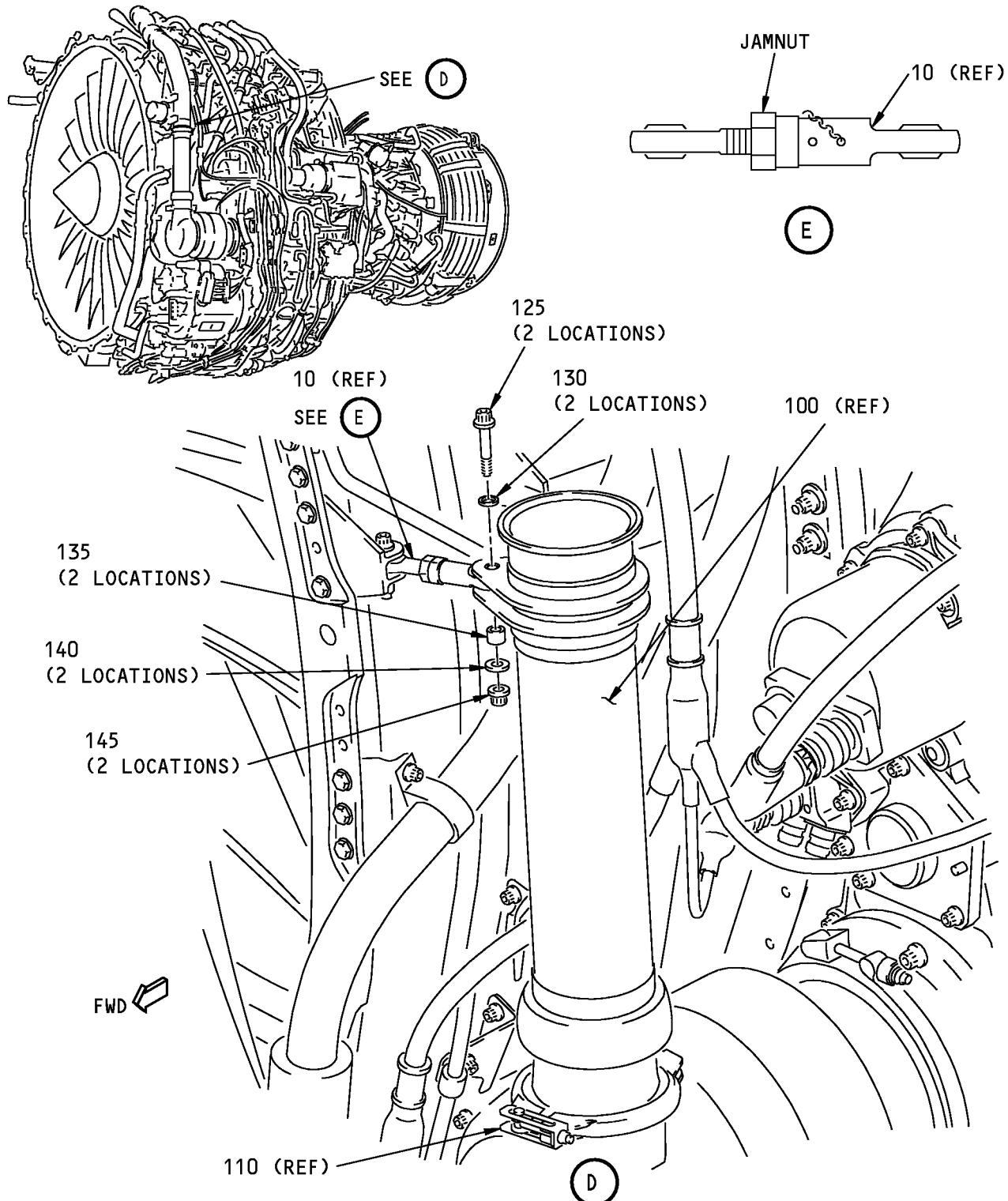
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P/P BUILDUP FIGURE 25-1

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P/P BUILDUP FIGURE 25-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
25-1		STARTER VALVE AND DUCT INSTALLATION (FIGURE 25-1, SHEET 4) LUBRICATE THREADS AND SHANK OF BOLTS (125) WITH Never-Seez NSBT-8N compound, D00006 (C1). 125 . BOLT C1 D00006 . NEVER SEEZ NSBT-8N COMPOUND SECURE LINKS (10) TO DUCT ASSY (100) WITH BOLTS (125), WASHERS (130) AND (140), BUSHINGS (135) AND NUTS (145). NOTE: MAKE SURE LINK(S) DO NOT APPLY PRELOAD TO ADJACENT DUCT OR SUPPORT HARDWARE. IF NECESSARY, ADJUST LINK(S) BY LOOSENING JAMNUT ON EACH LINK TO FREE ROD END. ADJUST AS NECESSARY AND RETIGHTEN JAMNUT.		
130	BACW10BP4ACU	. WASHER (CSK) (UNDER BOLTHEAD)		2
135	BACB28AK04-030	. BUSHING		2
140	NAS1149C0432R	. WASHER (UNDER NUT)		2
145	AS3485-10	. NUT		2
		CAUTION: BEFORE TIGHTENING NUT, MAKE SURE BUSHING IS FULLY ENGAGED. TIGHTEN BOLTS (125) TO 50-75 POUND-INCHES (5.6-8.5 NEWTON METERS). APPLY MS20995NC32 lockwire, G01912 (C2) OR safety cable kit, G50375 (C3) BETWEEN JAMNUT AND FEMALE SIDE OF LINKS (10). C2 G01912 . MS20995NC32 LOCKWIRE C3 G50375 . SAFETY CABLE KIT ORIENT HEAD OF COUPLING (110) UNTIL LATCH FACES FORWARD. TIGHTEN COUPLING (110) TO TORQUE SPECIFIED ON PART. LIGHTLY TAP OUTER SURFACE OF COUPLING (110) WITH NON-METALLIC MALLET. RETIGHTEN COUPLING (110) TO TORQUE GIVEN ON PART.	CON CON	AR 2

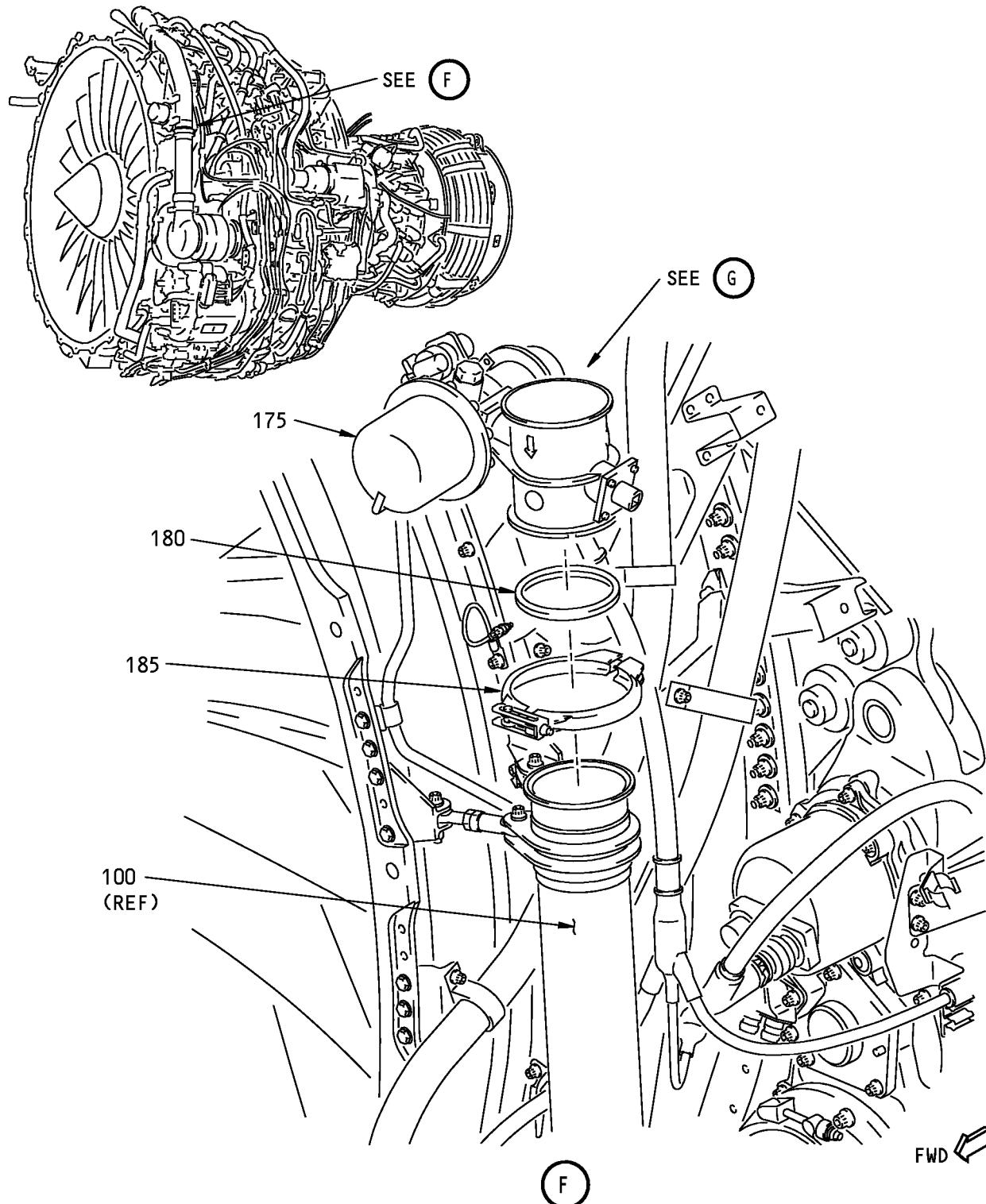
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P/P BUILDUP FIGURE 25-1

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P/P BUILDUP FIGURE 25-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
25-1		<p>STARTER VALVE AND DUCT INSTALLATION (FIGURE 25-1, SHEET 5)</p> <p>ATTACH SEAL (180) ON BOTTOM PORT OF START VALVE (175) AND INSTALL VALVE ON DUCT ASSY (100). MAKE SURE KEY-SLOT IN VALVE FLANGE MATES WITH KEY ON DUCT FLANGE.</p> <p>CAUTION: DO NOT TORQUE COUPLING TO MORE THAN THAT SPECIFIED ON THE PART. OVERTORQUING OF THE COUPLING CAN CAUSE DAMAGE TO START VALVE.</p> <p>SECURE START VALVE (175) TO DUCT ASSY (100) WITH COUPLING (185). TIGHTEN COUPLING (185) TO TORQUE SPECIFIED ON PART. LIGHTLY TAP OUTER SURFACE OF COUPLING (185) WITH NON-METALLIC MALLET. RETIGHTEN COUPLING (185) TO TORQUE GIVEN ON PART.</p>		
175	3289630-2	. START VALVE (V59364) (SPEC S332A002-2)	VEN	1
180	AS1895-7-300	. SEAL		1
180	AS1895/7-300	. SEAL (OPTIONAL TO AS1895-7-300)	OPT	-
185	30645-300	. COUPLING (V15284)		1
185	VR1030-300	. COUPLING (V14242) (OPTIONAL TO 30645-300)	OPT	-

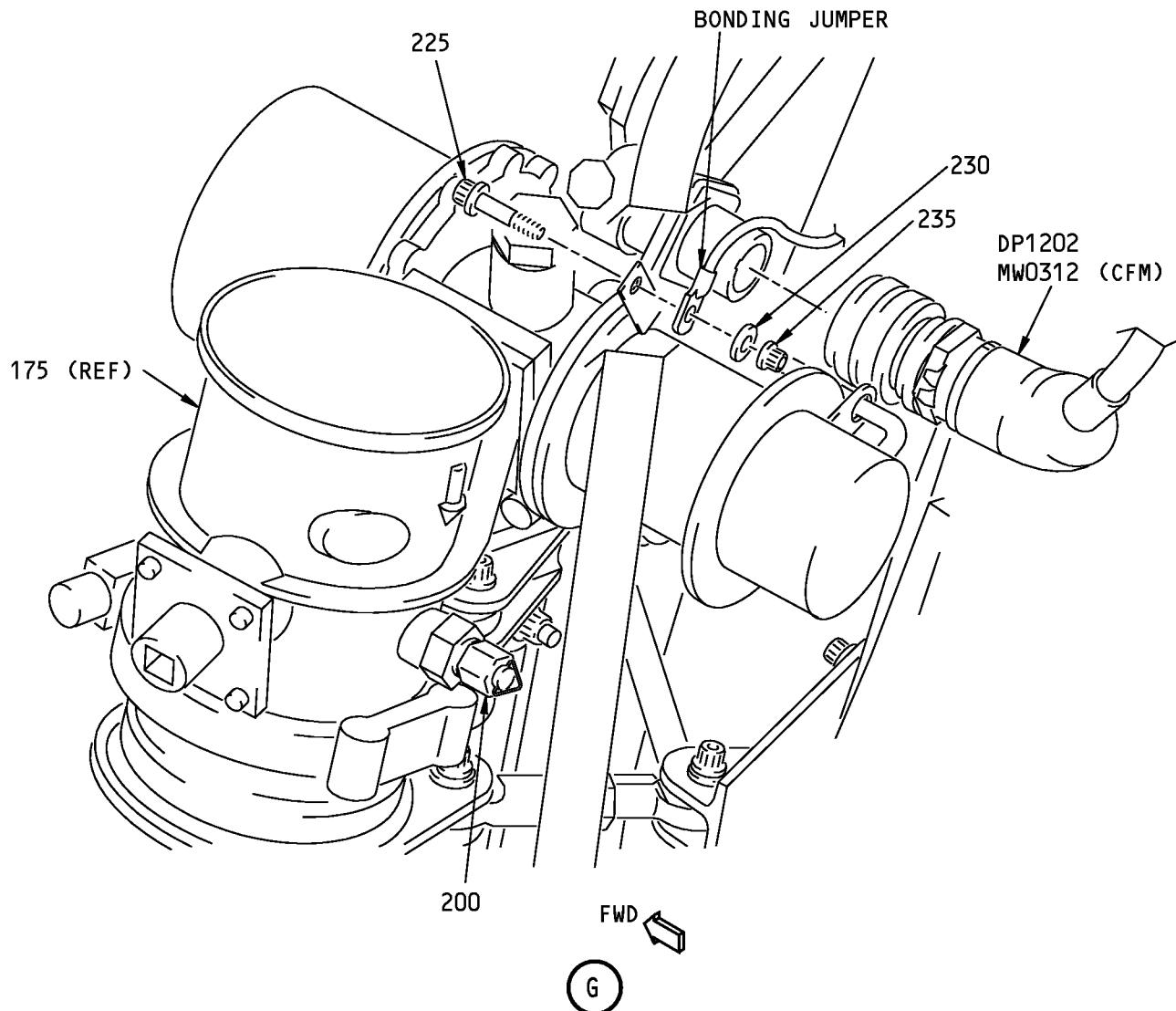
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P/P BUILDUP FIGURE 25-1

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POWERPLANT BUILDUP MANUALStarter Valve and Duct Installation
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P/P BUILDUP FIGURE 25-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
25-1		STARTER VALVE AND DUCT INSTALLATION (FIGURE 25-1, SHEET 6) MAKE SURE PRESSURE CAP IS INSTALLED ON DOWNSTREAM SENSE CONNECTION OF START VALVE. IF CAP IS MISSING, INSTALL ITEM (200). 200 MS21914-4J . PRESSURE CAP (1 REQD) 200 BACC14AD04J . PRESSURE CAP (OPTIONAL TO MS21914-4J) ATTACH BONDING JUMPER (REFERENCED IN BRACKET INSTALLATION - UPPER LEFT FAN CASE/Figure 4-1) FROM FLG B1 TO START VALVE (175) WITH ITEMS (225) THRU (235). 225 BACB30ZF3-06 . BOLT 230 NAS1149C0316R . WASHER (UNDER NUT) 235 AS3485-09 . NUT TIGHTEN BOLT (225) TO 50-56 POUNDS-INCHES (5.6-6.3 NEWTON METERS). CHECK RESISTANCE BETWEEN START VALVE HOUSING AND ENGINE BRACKET. MAX RESISTANCE IS 0.008 OHMS. CAUTION: DO NOT OVERTIGHTEN THE PLUG COUPLING RING. DO NOT USE WATER PUMP PLIERS, PIPE WRENCHES OR VISE GRIPS TO TIGHTEN THE COUPLING RING OR DAMAGE TO THE ELECTRICAL CONNECTOR CAN OCCUR. CONNECT MW0312 ELECTRICAL CONNECTOR, DP1202, TO START VALVE. TURN KNURLED COUPLING RING WHILE WIGGLING BACKSHELL ASSEMBLY. AFTER FULLY SEATING COUPLING RING, USE SOFT-JAWED PLIERS OR STRAP WRENCH TO TIGHTEN COUPLING RING AN ADDITIONAL 1/8 TURN OR UNTIL PLIER SLIPPAGE OCCURS.	REF OPT	- - 1 1 1

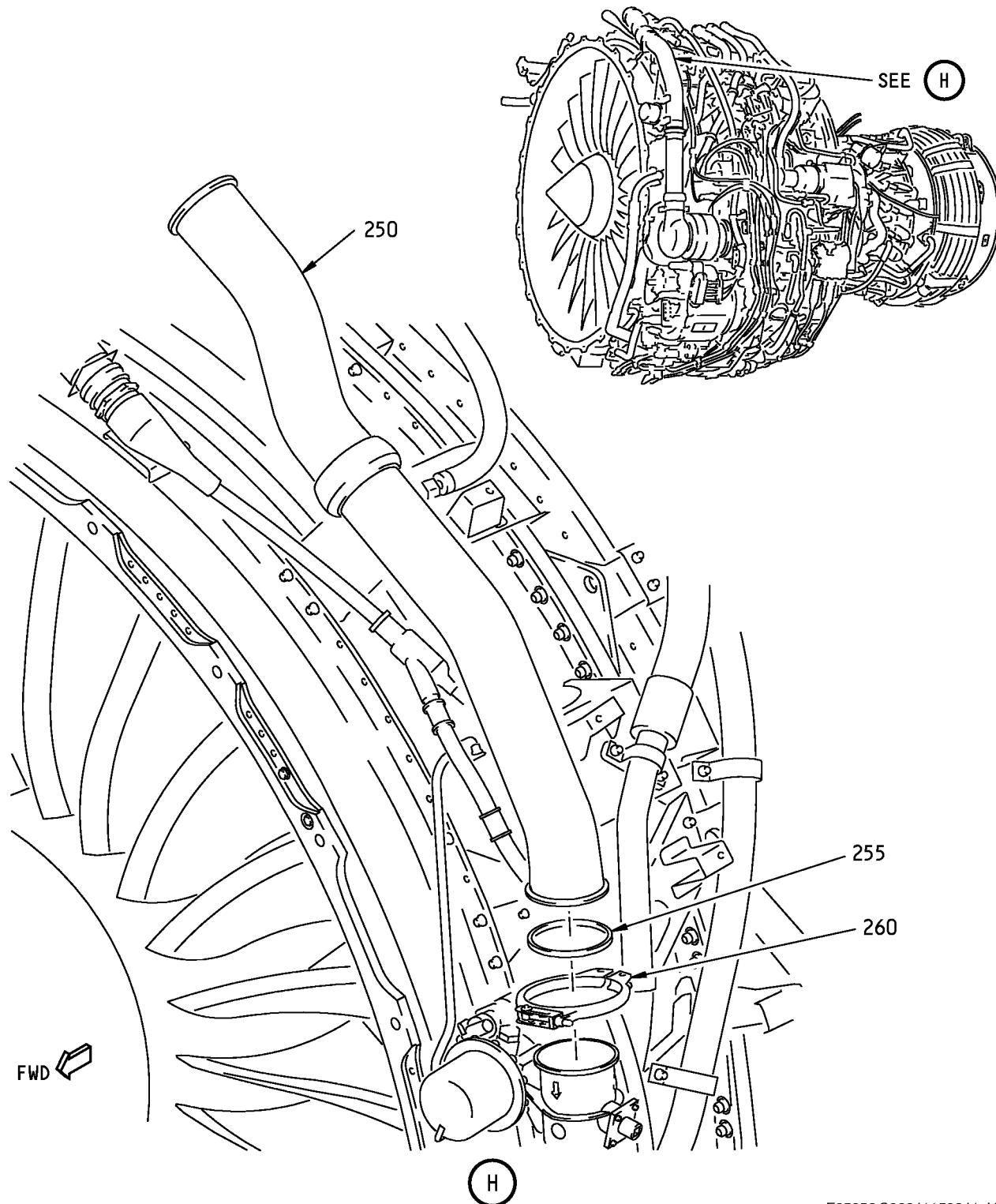
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P/P BUILDUP FIGURE 25-1

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POWERPLANT BUILDUP MANUAL

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Starter Valve and Duct Installation
Figure 25-1 (Sheet 7)**71-00-02**

P/P BUILDUP FIGURE 25-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
25-1		STARTER VALVE AND DUCT INSTALLATION (FIGURE 25-1, SHEET 7) INSTALL SEAL (255) IN BOTTOM END OF DUCT ASSY (250). POSITION DUCT (250) ON TOP PORT OF START VALVE AND LOOSELY SECURE WITH COUPLING (260). <u>NOTE:</u> DO NOT TIGHTEN COUPLING AT THIS TIME.		
250	332A2310-4	. DUCT ASSY		1
255	AS1895-7-300	. SEAL		1
255	AS1895/7-300	. SEAL (OPTIONAL TO AS1895-7-300)	OPT	-
260	30645-300	. COUPLING (V15284)		1
260	VR1030-300	. COUPLING (V14242) (OPTIONAL TO 30645-300)	OPT	-

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P/P BUILDUP FIGURE 25-1

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Starter Valve and Duct Installation
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P/P BUILDUP FIGURE 25-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
25-1		STARTER VALVE AND DUCT INSTALLATION (FIGURE 25-1, SHEET 8) THIS SHEET NOT USED		

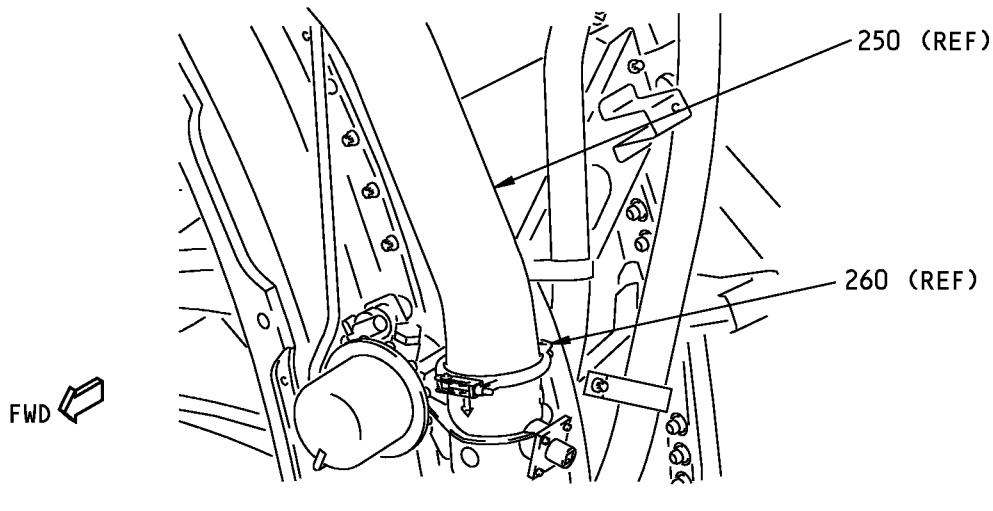
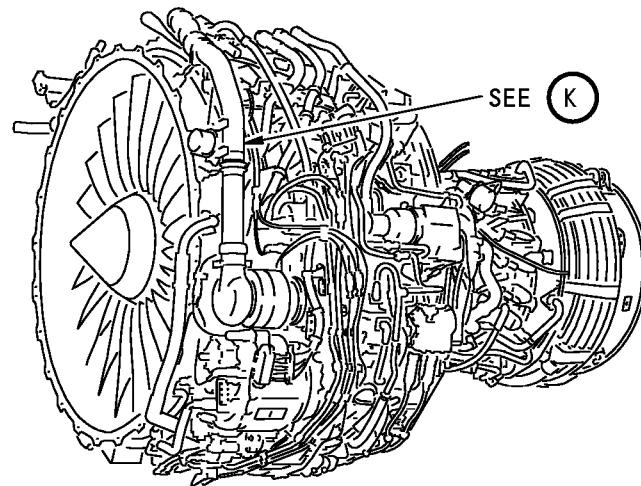
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P/P BUILDUP FIGURE 25-1

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POWERPLANT BUILDUP MANUAL

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Starter Valve and Duct Installation
Figure 25-1 (Sheet 9)

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P/P BUILDUP FIGURE 25-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
25-1		<p>STARTER VALVE AND DUCT INSTALLATION (FIGURE 25-1, SHEET 9)</p> <p>CAUTION: DO NOT TORQUE COUPLING TO MORE THAN THAT SPECIFIED ON THE PART. OVERTORQUING OF THE COUPLING CAN CAUSE DAMAGE TO START VALVE.</p> <p>ORIENT HEAD OF COUPLING (260) UNTIL LATCH FACES FORWARD. TIGHTEN COUPLING (260) TO TORQUE SPECIFIED ON PART. LIGHTLY TAP OUTER SURFACE OF COUPLING (260) WITH NON-METALLIC MALLET. RETIGHTEN COUPLING (260) TO TORQUE GIVEN ON PART.</p>		

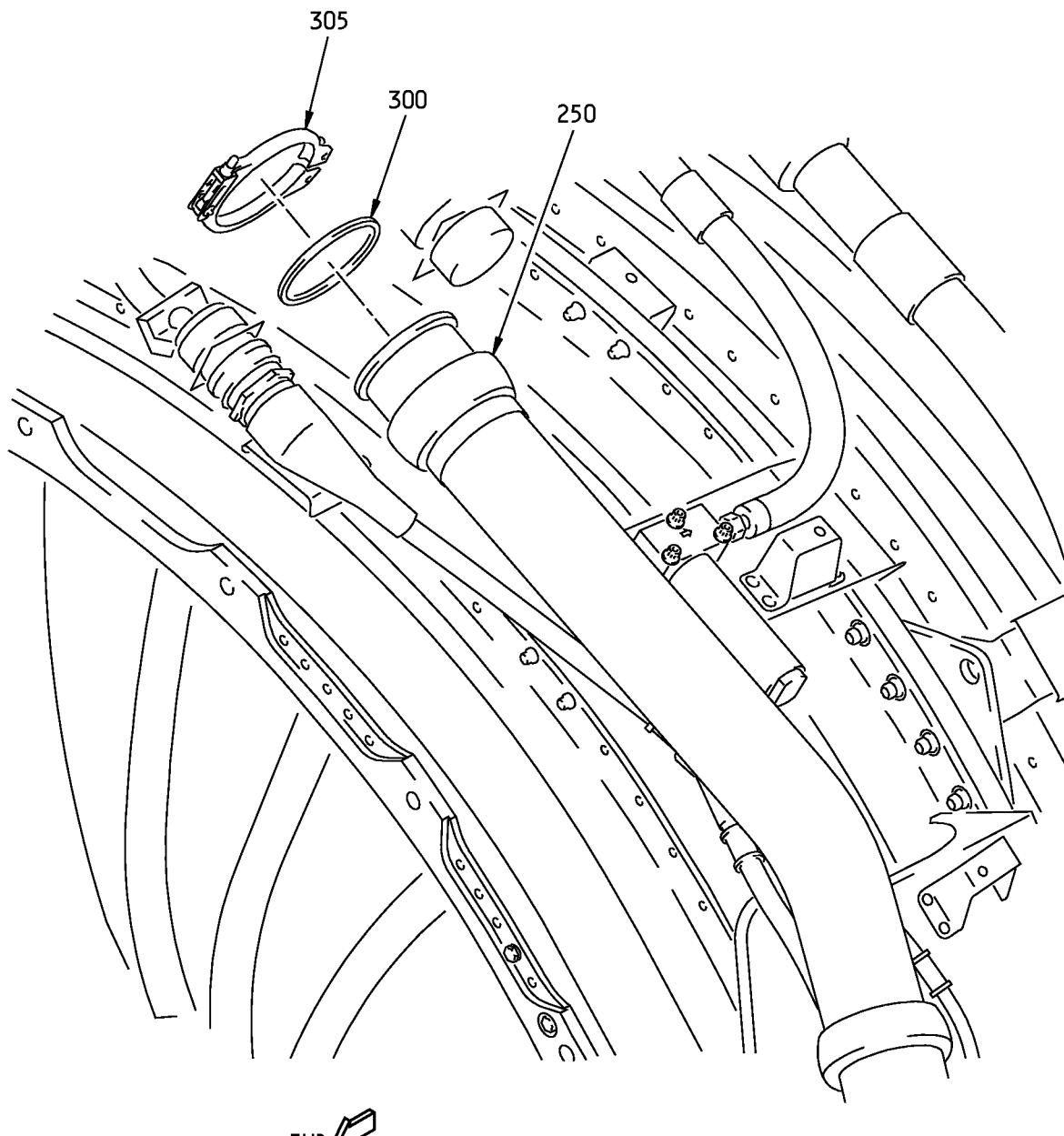
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P/P BUILDUP FIGURE 25-1

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POWERPLANT BUILDUP MANUAL

F05065 S00041153945_V2

Starter Valve and Duct Installation
Figure 25-1 (Sheet 10)**71-00-02**P/P BUILDUP FIGURE 25-1
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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
25-1		STARTER VALVE AND DUCT INSTALLATION (FIGURE 25-1, SHEET 10)		
300	AS1895-7-300	PUT ITEMS (300) AND (305) IN A BAG AND SECURE TO DUCT ASSY (250).		1
300	AS1895/7-300	. SEAL	OPT	-
305	30645-300	. SEAL (OPTIONAL TO AS1895-7-300)		1
305	VR1030-300	. COUPLING (V15284)	OPT	-
		. COUPLING (V14242) (OPTIONAL TO 30645-300)		

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P/P BUILDUP FIGURE 25-1

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FIGURE 27-1

INLET COWL TAI SYSTEM INSTALLATION

REF QEC TASK NO.: 27

REF DWG: 332A2300

NOTE: ALL STANDARDS AND ATTACHING HARDWARE FOR THIS FIGURE WILL BE PACKAGED IN QEC TASK NO. 110.

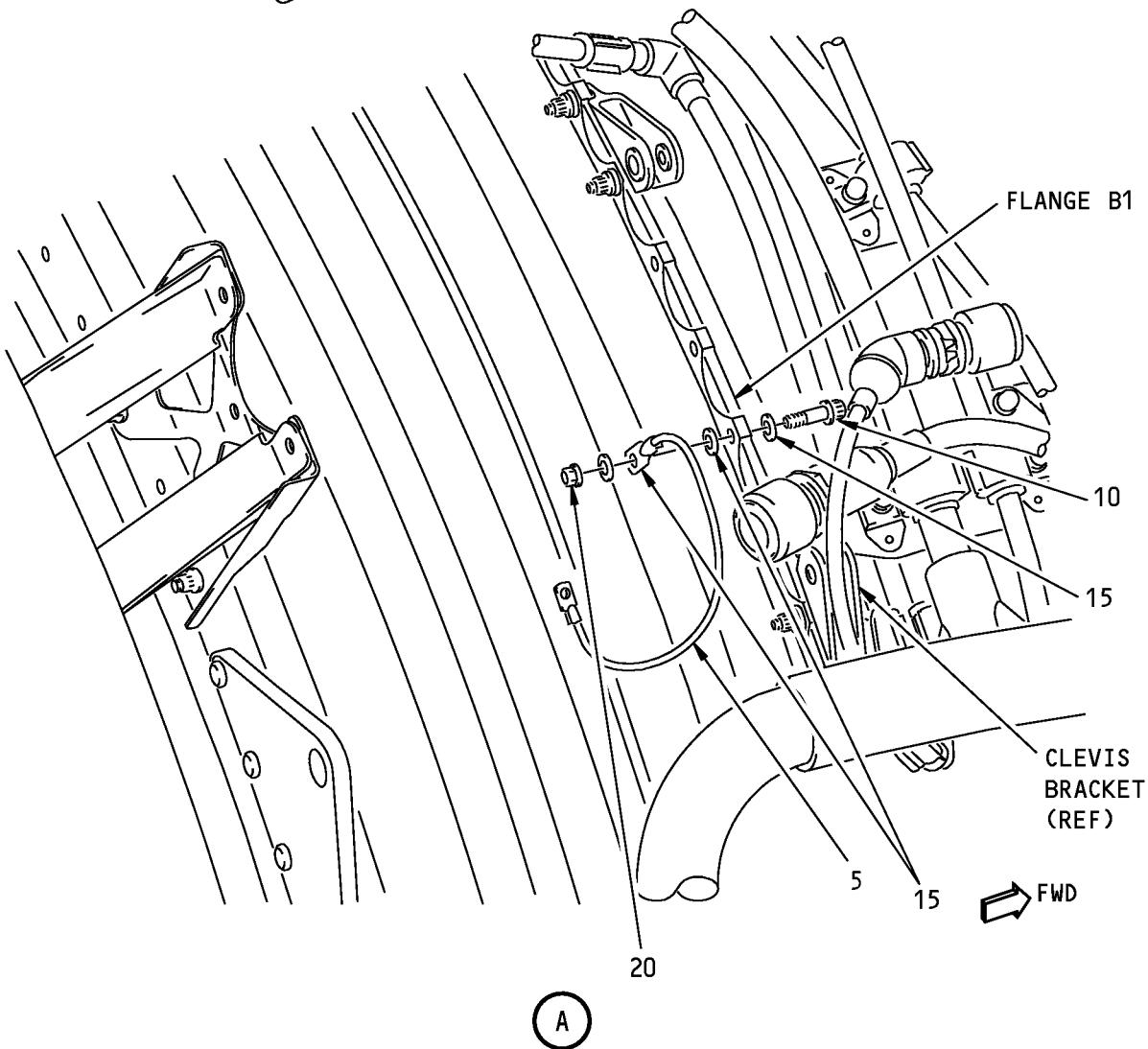
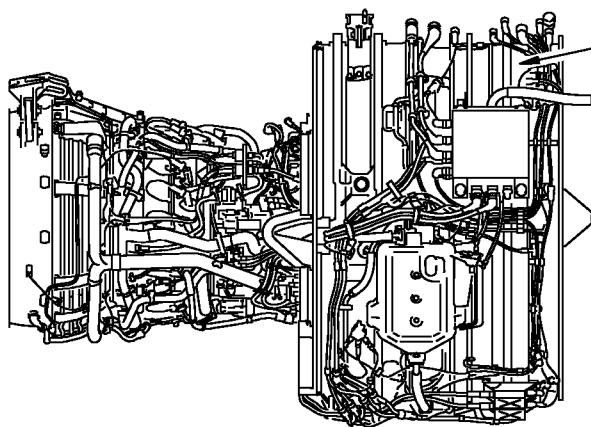
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P/P BUILDUP FIGURE 27-1

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POWERPLANT BUILDUP MANUAL

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Inlet Cowl TAI System Installation
Figure 27-1 (Sheet 1)**71-00-02**

P/P BUILDUP FIGURE 27-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
27-1		INLET COWL TAI SYSTEM INSTALLATION (FIGURE 27-1, SHEET 1) <p>LOCATE 2ND HOLE UP FROM LOWER CLEVIS BRACKET ON FLANGE B1. USE abrasive mat, G00251 (C1) TO REMOVE ANODIZED COATING AROUND HOLE. CONTINUE UNTIL BRIGHT ALUMINUM BONDING SURFACE IS VISIBLE. AFTER COATING HAS BEEN REMOVED, CLEAN SURFACE OF FLANGE AND MATING SURFACE OF BONDING JUMPER (5) WITH alcohol, B00130 (C2).</p> <p>NOTE: REMOVE ONLY A MINIMUM AMOUNT OF ALUMINUM.</p>		
5	BACJ40AC54-9	. BONDING JUMPER	CON	1
C1	G00251	. ABRASIVE MAT	CON	AR
C2	B00130	. ALCOHOL	CON	AR
		ATTACH BONDING JUMPER (5) TO FAN CASE FLANGE B1 USING BOLT (10), WASHERS (15) AND NUT (20). ORIENT LUG ON BONDING JUMPER (5) TO 12 O'CLOCK POSITION.		
		NOTE: INSTALL A WASHER UNDER THE BOLT HEAD, UNDER THE BONDING JUMPER AND UNDER THE NUT.		
10	BACB30ZF4-10	. BOLT (BOLT HEAD FWD)		1
15	NAS1149D0416H	. WASHER		3
20	BACN10YR4CD	. NUT (AFT SIDE)		1
		TIGHTEN BOLT (10) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS).		
		APPLY A FILLET SEAL OF sealant, A00803 (C4) OR sealant, A50096 (C5) OR adhesive, A00027 (C6) AROUND BONDING JUMPER (5) AND BOLT (10). IF sealant, A00803 (C4) IS USED, APPLY Dapco No. 1-100 primer, C00944 (C3) BEFORE SEALANT APPLICATION.		
C3	C00944	. DAPCO NO. 1-100 PRIMER	CON	AR
C4	A00803	. SEALANT	CON	AR
C5	A50096	. SEALANT	CON	AR
C6	A00027	. ADHESIVE	CON	AR

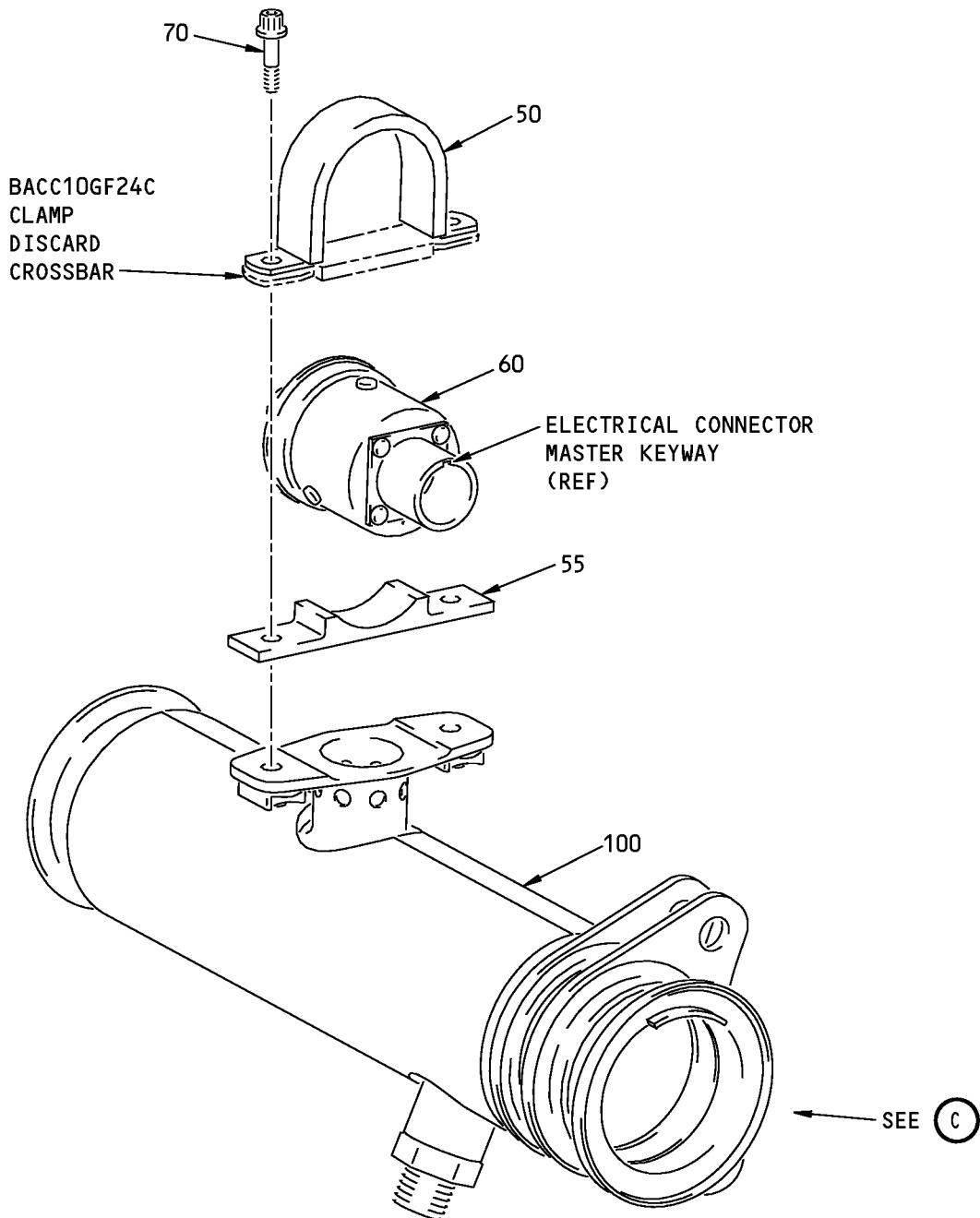
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P/P BUILDUP FIGURE 27-1

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P/P BUILDUP FIGURE 27-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
27-1		INLET COWL TAI SYSTEM INSTALLATION (FIGURE 27-1, SHEET 2) <u>PREFERRED CONFIGURATION:</u> REMOVE CROSSBAR FROM ATTACHMENT FOOT OF CLAMP (50) AND DISCARD. IF CROSSBAR IS ATTACHED BY A RIVET, REMOVE RIVET BY SQUEEZING RIVET RING WITH PLIERS. . CLAMP ATTACH PRESSURE SWITCH (60) TO DUCT ASSY (100) USING CLAMP (50), BRACKET SADDLE (55) AND BOLTS (70). IF RIVET WAS REMOVED FROM OPT CLAMP (50), INSTALL WASHERS (75) UNDER BOLTS (70). <u>NOTE:</u> INSTALL PRESSURE SWITCH SUCH THAT ELECTRICAL CONNECTOR MASTER KEYWAY IS FARTHEST FROM DUCT.		
50	BACC10GF24CT	. BRACKET SADDLE	VEN	1
55	332A1325-1	. PRESSURE SWITCH (V02750)	VEN	1
60	21SN41-52	. BOLT		2
70	BACB30ZF3-08	. WASHER (2 REQD) ^[1]	OPT	-
75	NAS1149C0363R	. DUCT ASSY		1
100	332A2390-48	TIGHTEN BOLTS (70) TO 28-32 POUND-INCHES (3.16-3.62 NEWTON METERS). *[1] ITEM NOT ILLUSTRATED		

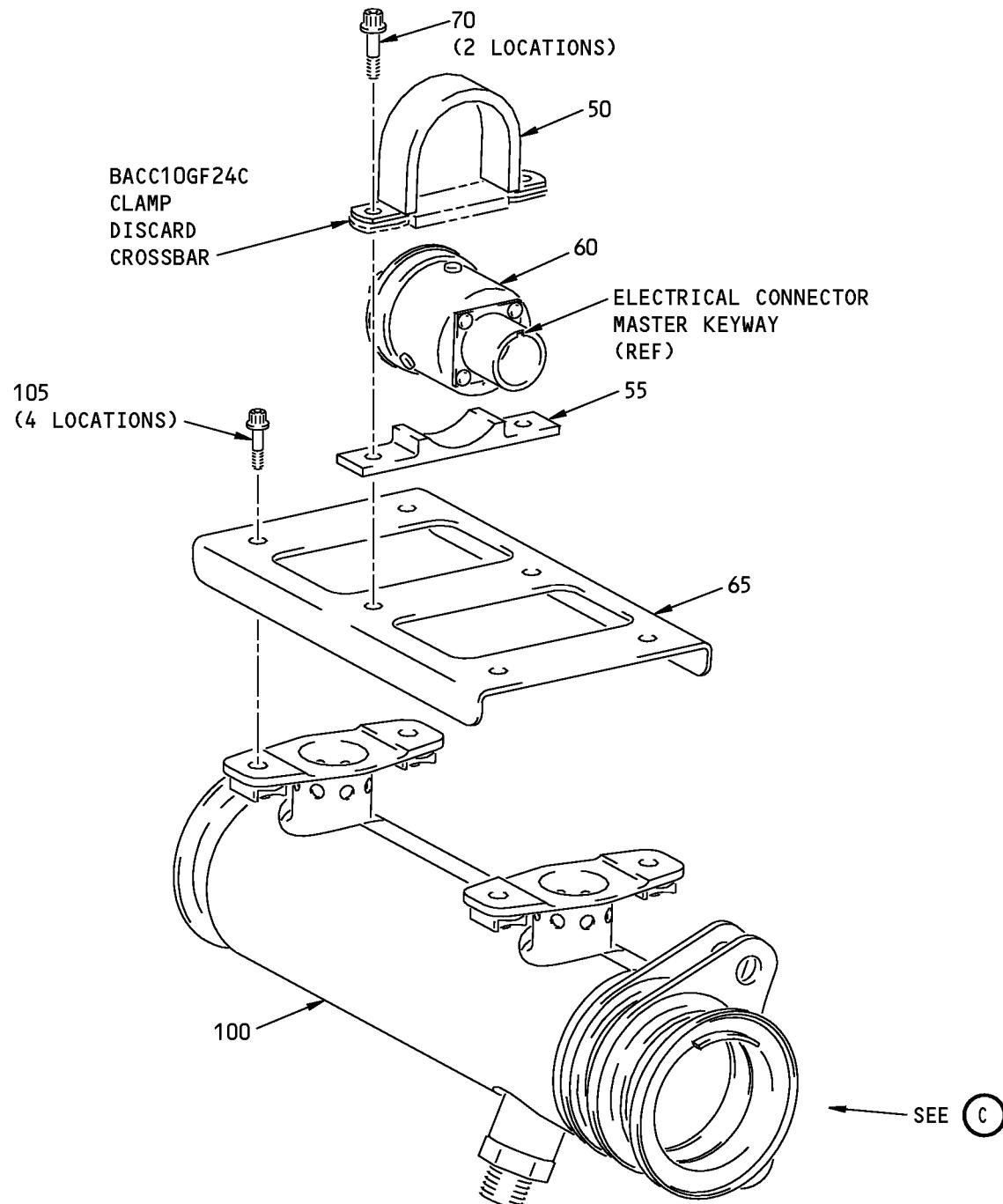
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P/P BUILDUP FIGURE 27-1

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POWERPLANT BUILDUP MANUALInlet Cowl TAI System Installation
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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
27-1		INLET COWL TAI SYSTEM INSTALLATION (FIGURE 27-1, SHEET 3) <u>OPTIONAL CONFIGURATION:</u> REMOVE CROSSBAR FROM ATTACHMENT FOOT OF CLAMP (50) AND DISCARD. IF CROSSBAR IS ATTACHED BY A RIVET, REMOVE RIVET BY SQUEEZING RIVET RING WITH PLIERS. . CLAMP POSITION BRACKET SADDLE (55) AND PRESSURE SWITCH (60) ON BRACKET (65) AND SECURE WITH CLAMP (50) AND BOLTS (70). IF RIVET WAS REMOVED FROM OPT CLAMP (50), INSTALL WASHERS (75) UNDER BOLTS (70). NOTE: INSTALL PRESSURE SWITCH SUCH THAT ELECTRICAL CONNECTOR MASTER KEYWAY IS FARTHEST FROM BRACKET.		
50	BACC10GF24CT	. BRACKET SADDLE (1 REQD) . PRESSURE SWITCH (V02750) (1REQD) . BRACKET (1 REQD) . BOLT (2 REQD) . WASHER (2 REQD) ^[1]	OPT	-
55	332A1325-1		OPT	-
60	21SN41-52		OPT	-
65	332A2910-1		OPT	-
70	BACB30ZF3-08		OPT	-
75	NAS1149C0363R	TIGHTEN BOLTS (70) TO 28-32 POUND-INCHES (3.16-3.62 NEWTON METERS). ATTACH BRACKET AND ATTACHING PARTS TO DUCT (100) WITH BOLTS (105). . DUCT ASSY (1 REQD) . BOLT (4 REQD)	OPT	-
100	332A2390-3		OPT	-
105	BACB30ZF4-08	TIGHTEN BOLTS (105) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS). *[1] ITEM NOT ILLUSTRATED	OPT	-

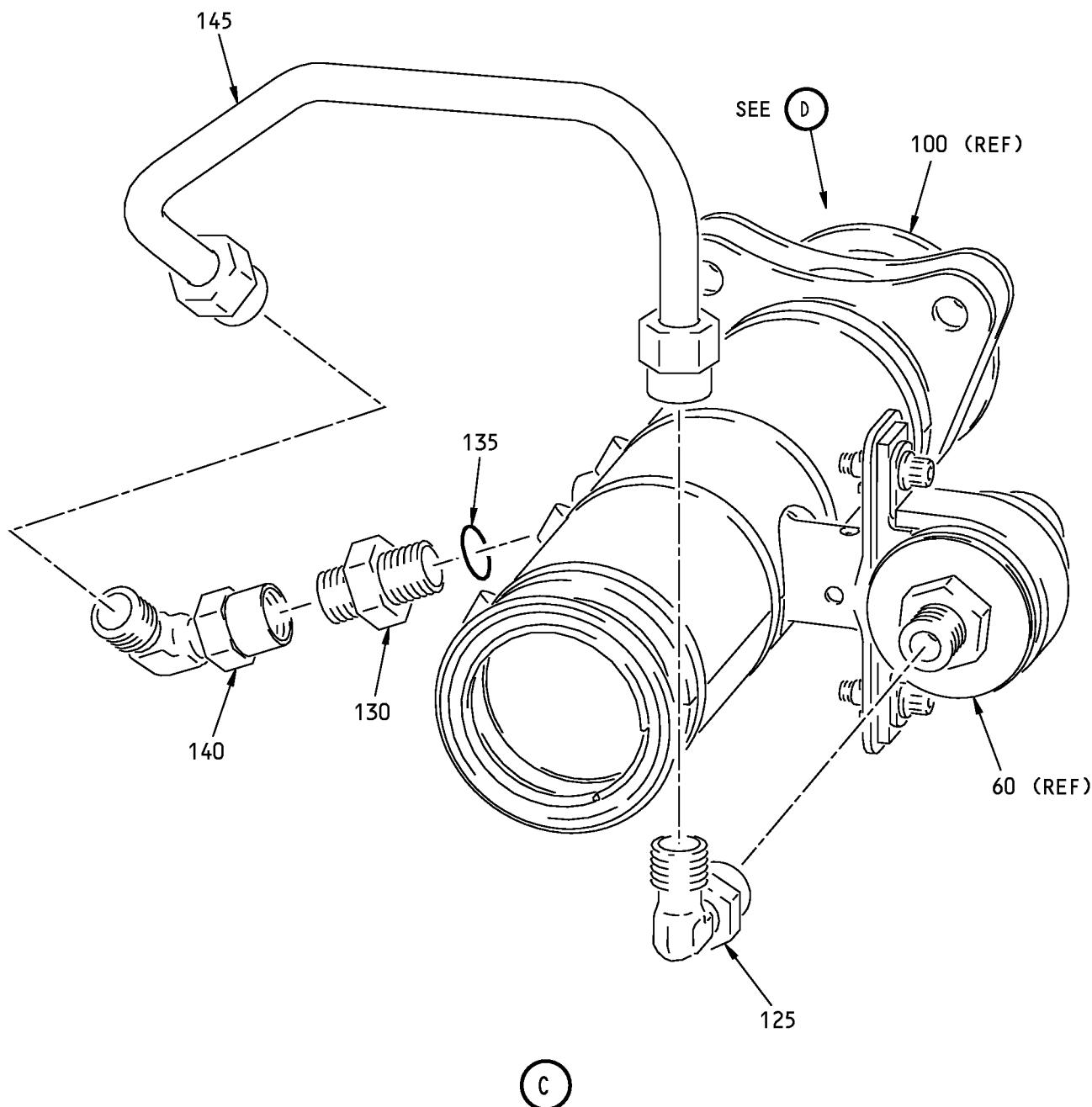
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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
27-1		INLET COWL TAI SYSTEM INSTALLATION (FIGURE 27-1, SHEET 4)		
125	AS4138J0606	INSTALL ELBOW (125) FINGER-TIGHT ON PRESSURE SWITCH (60). . ELBOW		1
130	AS5230J0606	INSTALL O-RING (135) ON UNION (130) AND INSTALL UNION (130) ON DUCT (100). INSTALL ELBOW (140) ON UNION (130) FINGER-TIGHT. . UNION		1
135	801A50-0006-A	. O-RING (V15284)	VEN	1
135	801A50-0006A	. O-RING (V15284) (OPTIONAL TO 801A50-0006-A)	OPT	-
140	AS4138J0606	. ELBOW		1
145	332A2350-1	CONNECT TUBE (145) BETWEEN ELBOWS (125) AND (140). . TUBE ASSY		1
		TIGHTEN UNION (130), ELBOWS (125) AND (140) AND TUBE (145) TO 257-283 POUND-INCHES (29-32 NEWTON METERS).		

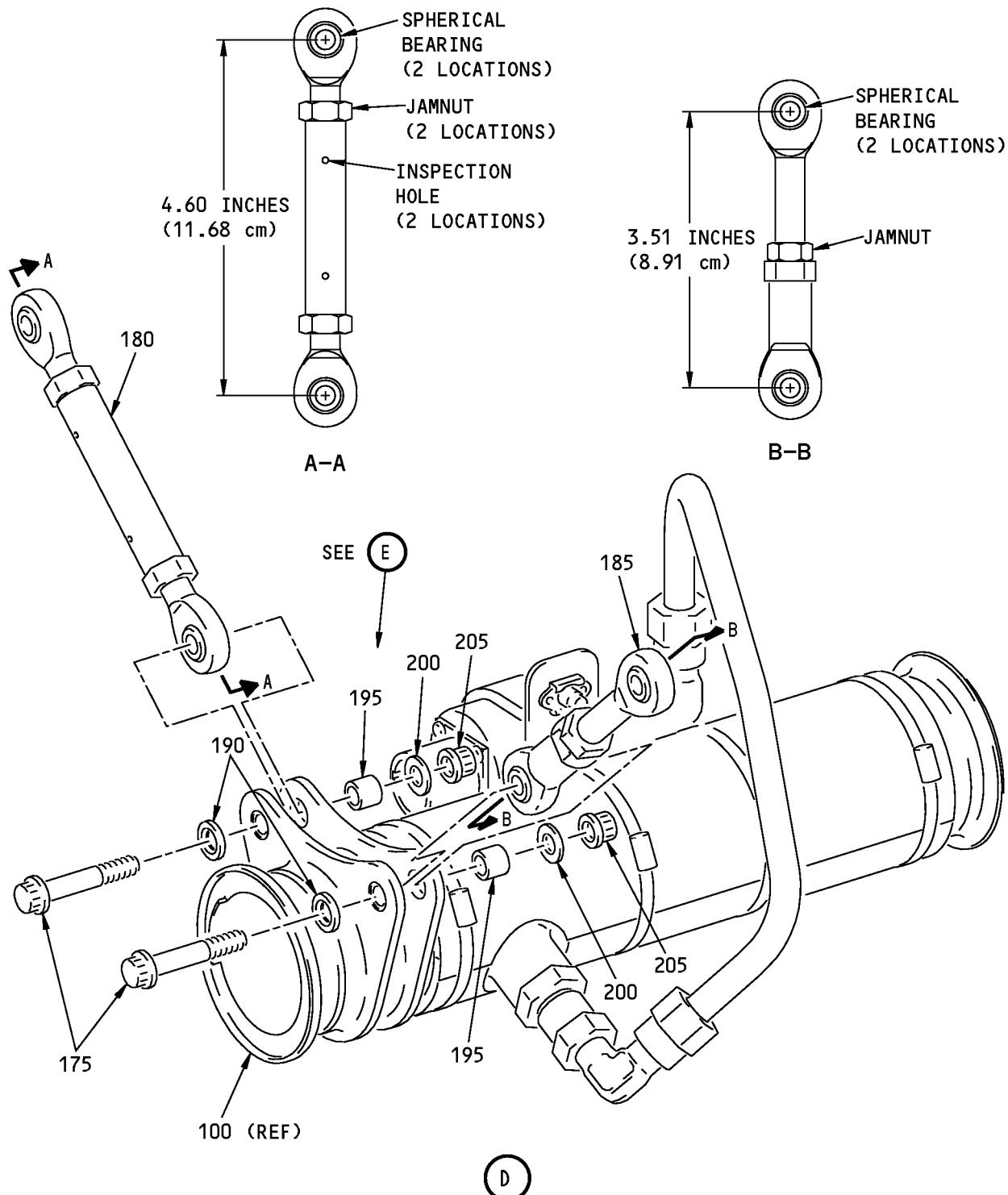
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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
27-1 C7 175	D00006 BACB30PN4-14	<p>INLET COWL TAI SYSTEM INSTALLATION (FIGURE 27-1, SHEET 5)</p> <p>APPLY Never-Seez NSBT-8N compound, D00006 (C7) TO THREADS AND SHANK OF BOLTS (175).</p> <p>. NEVER-SEEZ NSBT-8N COMPOUND . BOLT</p> <p>LOOSEN JAMNUT OF LINK ASSY (180) TO FREE ROD END. ADJUST LINK ASSY TO 4.60 INCHES (11.68 CM) FROM CENTERLINE OF SPHERICAL BEARINGS. RETIGHTEN JAMNUT.</p> <p>NOTE: MAKE SURE THREADS ARE VISIBLE THROUGH BOTH INSPECTION HOLES.</p> <p>LOOSEN JAMNUT OF LINK ASSY (185) TO FREE ROD END. ADJUST LINK TO 3.51 INCHES (8.91 CM) FROM CENTERLINE OF SPHERICAL BEARINGS. RETIGHTEN JAMNUT.</p> <p>ATTACH LINK ASSEMBLY (180) TO BOTTOM ATTACH POINT OF DUCT (100) (BOTTOM OF DUCT HAS TWO BOSSES) AND ATTACH LINK ASSEMBLY (185) TO TOP ATTACH POINT OF DUCT. USE ITEMS (175) AND (190) THRU (205).</p> <p>NOTE: MAKE SURE BOLT HEAD FACES FORWARD.</p> <p>. LINK ASSY . LINK ASSY . WASHER (CSK) (UNDER BOLT) . WASHER (OPTIONAL TO BACW10BP4ACU) . BUSHING . WASHER (UNDER NUT) . NUT</p> <p>TIGHTEN BOLTS (175) TO 50-80 POUND-INCHES (5.6-9.0 NEWTON METERS).</p>	CON	AR 2
180	332A2341-3			1
185	332A2341-2			1
190	BACW10BP4ACU			2
190	BACW10BP4CD			-
195	BACB28AK04-030			2
200	NAS1149C0432R			2
205	AS3485-10			2

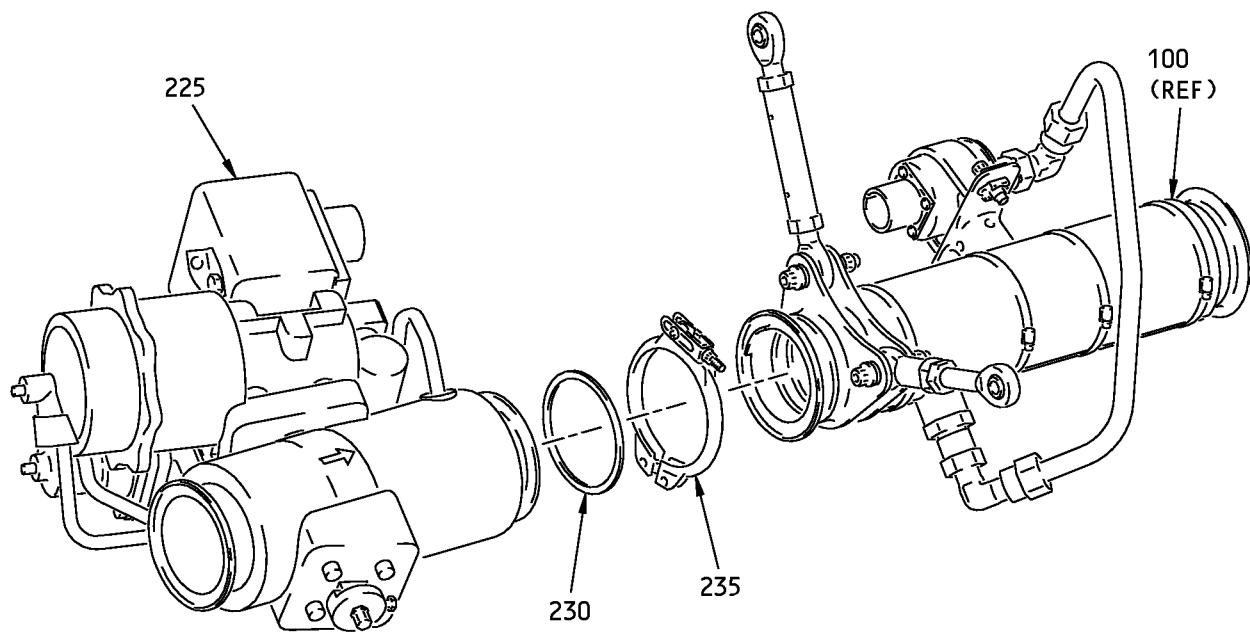
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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
27-1		INLET COWL TAI SYSTEM INSTALLATION (FIGURE 27-1, SHEET 6) INSTALL SEAL (230) IN AFT FLANGE OF DUCT ASSY (100). ATTACH VALVE ASSEMBLY (225) TO DUCT ASSY (100) WITH COUPLING (235) FINGER TIGHT. NOTE: MAKE SURE TO ALIGN THE CLOCKING FEATURE BETWEEN THE VALVE AND THE DUCT. ORIENT COUPLING TO MAXIMIZE CLEARANCE WITH ADJACENT EQUIPMENT.		
225	3215618-6	. VALVE ASSEMBLY (V59364)	VEN	1
225	3215618-5	. VALVE ASSEMBLY (V59364) (REPLACED BY 3215618-6)	LTD	-
225	3215618-4	. VALVE ASSEMBLY (V59364) (SPEC S332A239-4) (REPLACED BY 3215618-5)	LTD	-
230	AS1895-7-200	. SEAL		1
230	AS1895/7-200	. SEAL (OPTIONAL TO AS1895-7-200)	OPT	-
235	AS1895-4-200	. COUPLING		1
235	AS1895/4-200	. COUPLING (OPTIONAL TO AS1895-4-200)	OPT	-
		TIGHTEN COUPLING (235) TO TORQUE SPECIFIED ON PART. LIGHTLY TAP OUTER SURFACE OF COUPLING WITH A NON-METALLIC MALLET. RETIGHTEN COUPLING TO TORQUE SPECIFIED ON PART.		

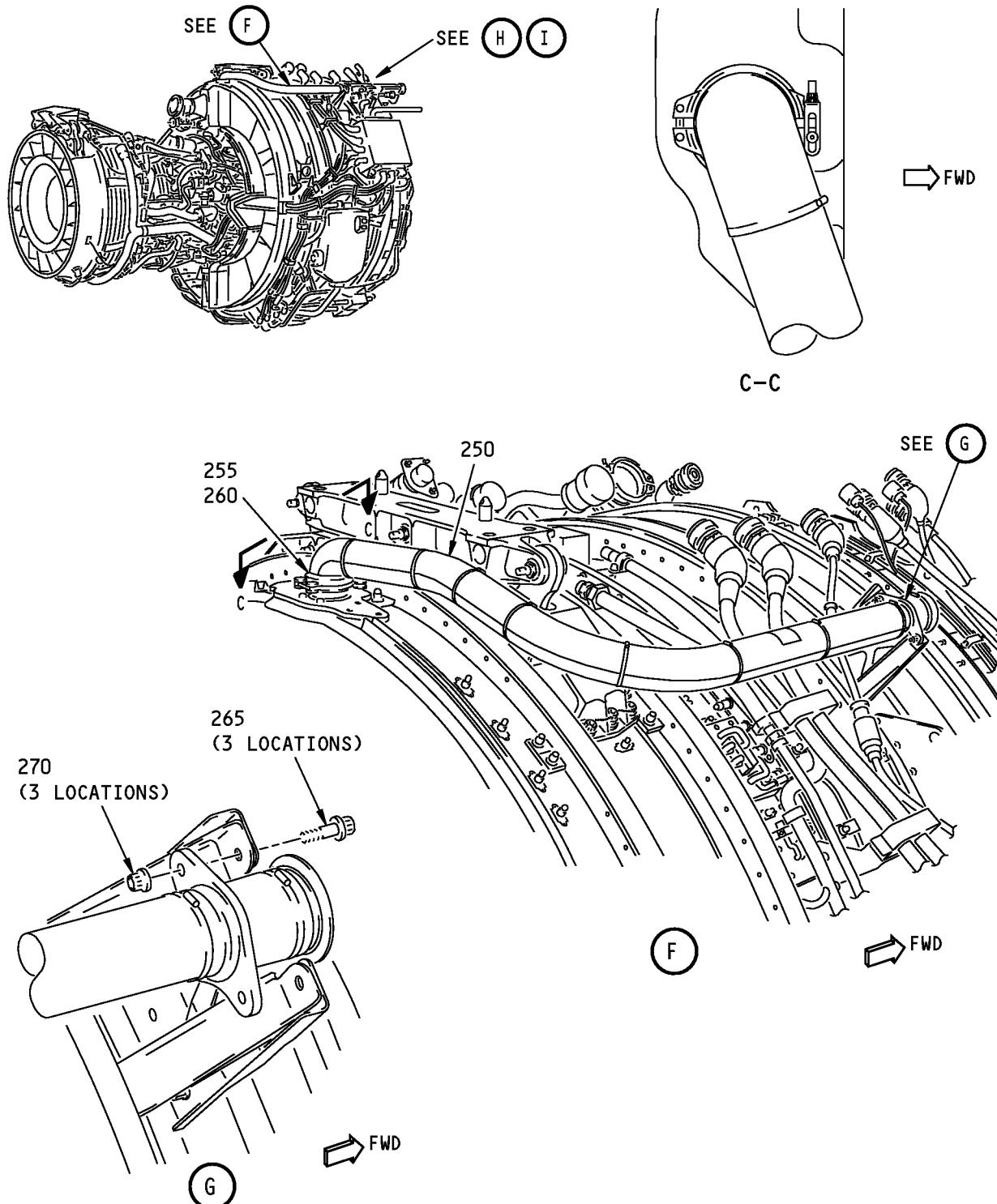
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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
27-1		<p>INLET COWL TAI SYSTEM INSTALLATION (FIGURE 27-1, SHEET 7)</p> <p>CAUTION: COUPLING MUST BE INSTALLED WITH NUT FACING FORWARD ON LEFT SIDE OF ENGINE. DAMAGE TO EQUIPMENT CAN OCCUR.</p> <p>POSITION DUCT ASSY (250) ON ENGINE FAN CASE. SECURE AFT END OF DUCT TO EXISTING TAI BIFUR UPR DUCT FLANGE WITH SEAL (255) AND COUPLING (260). SECURE FWD END OF DUCT TO ENGINE FAN CASE BRACKETS WITH BOLTS (265) AND NUTS (270).</p> <p>NOTE: MAKE SURE COUPLING NUT IS ON LEFT SIDE (EITHER FORWARD OR AFT OF DUCT).</p>		
250	332A2390-12	. DUCT ASSY		1
255	AS1895-7-175	. SEAL		1
255	AS1895/7-175	. SEAL (OPTIONAL TO AS1895-7-175)	OPT	-
260	AS1895-4-175	. COUPLING		1
260	AS1895/4-175	. COUPLING (OPTIONAL TO AS1895-4-175)	OPT	-
265	BACB30ZF4-10	. BOLT		3
270	AS3485-10	. NUT		3
		TIGHTEN COUPLING (260) TO TORQUE SPECIFIED ON PART. LIGHTLY TAP OUTER SURFACE OF COUPLING WITH A NON-METALLIC MALLET. RETIGHTEN COUPLING TO TORQUE SPECIFIED ON PART.		
		TIGHTEN BOLTS (265) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS).		

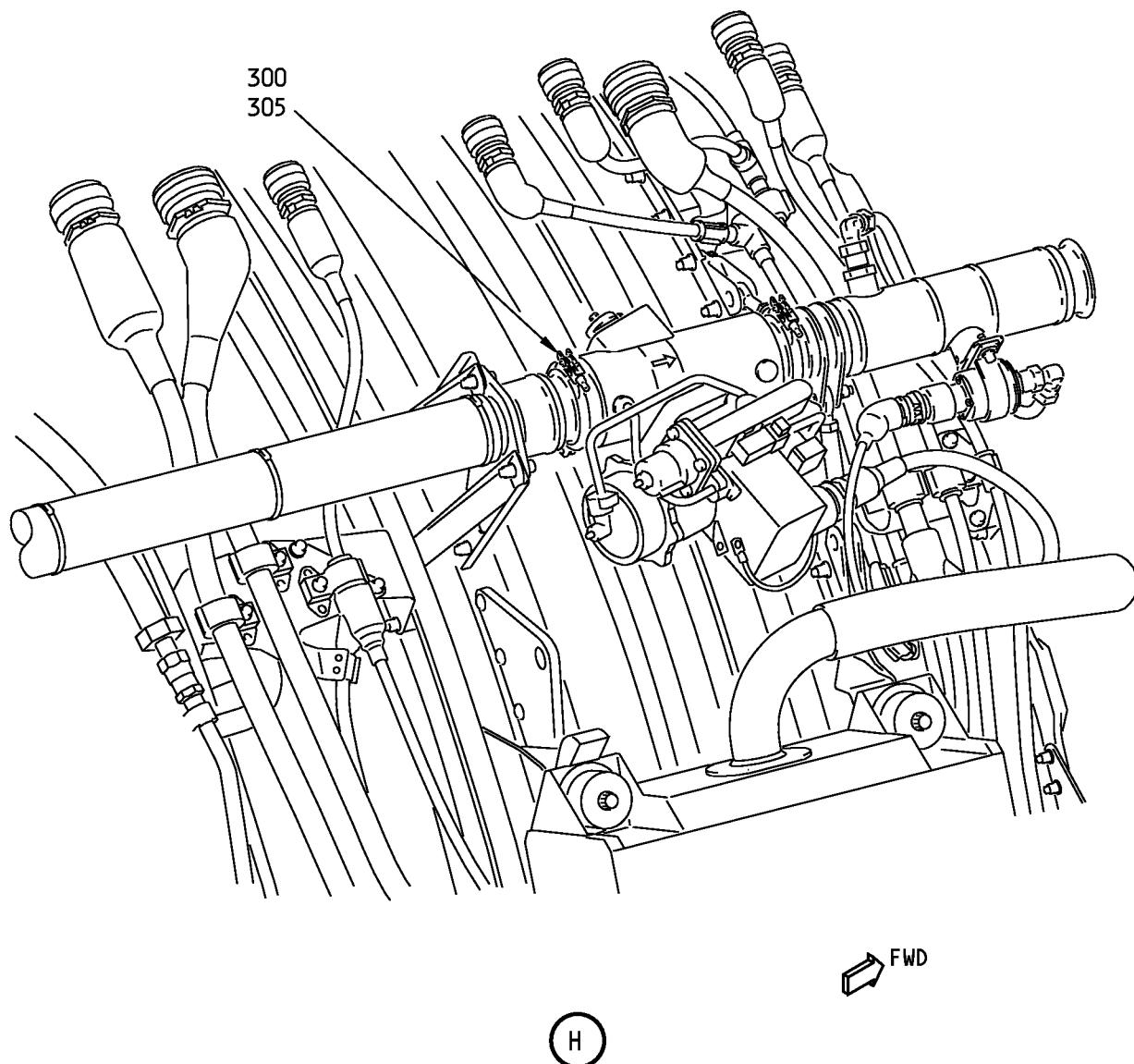
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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
27-1		INLET COWL TAI SYSTEM INSTALLATION (FIGURE 27-1, SHEET 8)		
300	AS1895-7-200	. SEAL		1
300	AS1895/7-200	. SEAL (OPTIONAL TO AS1895-7-200)	OPT	-
305	AS1895-4-200	. COUPLING		1
305	AS1895/4-200	. COUPLING (OPTIONAL TO AS1895-4-200)	OPT	-
		ORIENT COUPLING (305) TO MAXIMIZE CLEARANCE WITH ADJACENT EQUIPMENT. TIGHTEN COUPLING (305) TO TORQUE SPECIFIED ON PART. LIGHTLY TAP OUTER SURFACE OF COUPLING WITH NON-METALLIC MALLET. RETIGHTEN COUPLING TO TORQUE SPECIFIED ON PART.		

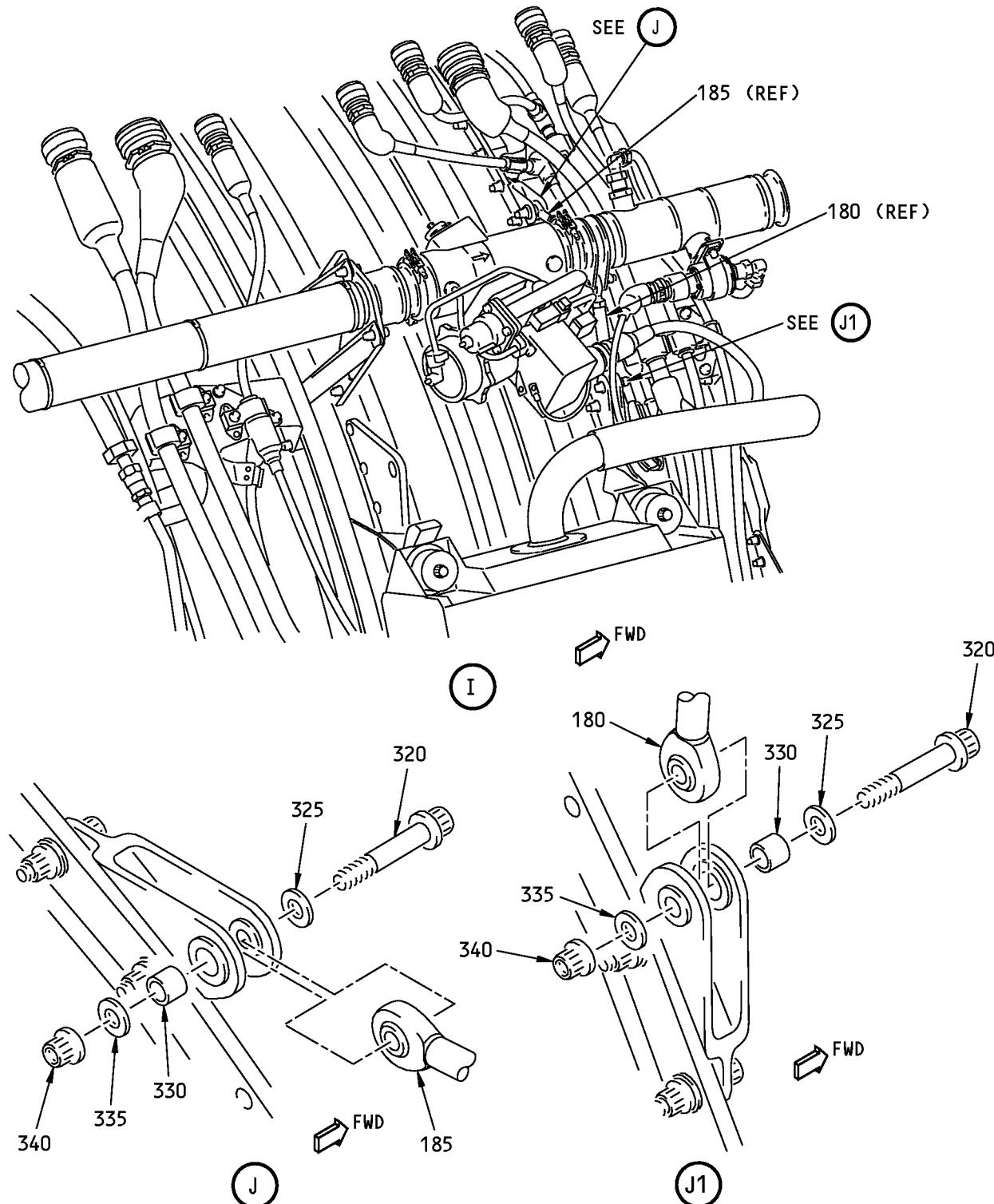
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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
27-1 C7 320	D00006 BACB30PN4-14	<p>INLET COWL TAI SYSTEM INSTALLATION (FIGURE 27-1, SHEET 9)</p> <p>APPLY Never-Seez NSBT-8N compound, D00006 (C7) TO THREADS AND SHANK OF BOLTS (320).</p> <p>. NEVER-SEEZ NSBT-8N COMPOUND . BOLT</p> <p>SECURE LINKS (180) AND (185) TO ENGINE FAN CASE BRACKETS WITH ITEMS (320) THRU (340).</p> <p>NOTE: MAKE SURE NO PRELOAD FORCE EXISTS BETWEEN THE VALVE, DUCT AND ENGINE BRACKET. IF A PRELOAD FORCE EXISTS, FIRST MAKE SURE ALL COMPONENTS ARE INSTALLED CORRECTLY. THEN ADJUST LINKS (180) AND (185) LENGTHS (REF: Figure 27-1 (Sheet 5)PPBU-FIGURE).</p>	CON	AR 2
325	BACW10BP4ACU	. WASHER (CSK) (UNDER BOLT)		2
330	BACB28AK04-030	. BUSHING		2
335	NAS1149C0432R	. WASHER (UNDER NUT)		2
340	AS3485-10	. NUT		2
		TIGHTEN BOLTS (320) TO 50-80 POUND-INCHES (5.6-9.0 NEWTON METERS).		
		APPLY MS20995NC32 lockwire, G01912 (C8) OR safety cable kit, G50375 (C9) BETWEEN JAMNUT AND FEMALE SIDE OF LINK (180) AND LINK (185).		
C8	G01912	. MS20995NC32 LOCKWIRE	CON	AR
C9	G50375	. SAFETY CABLE KIT	CON	2

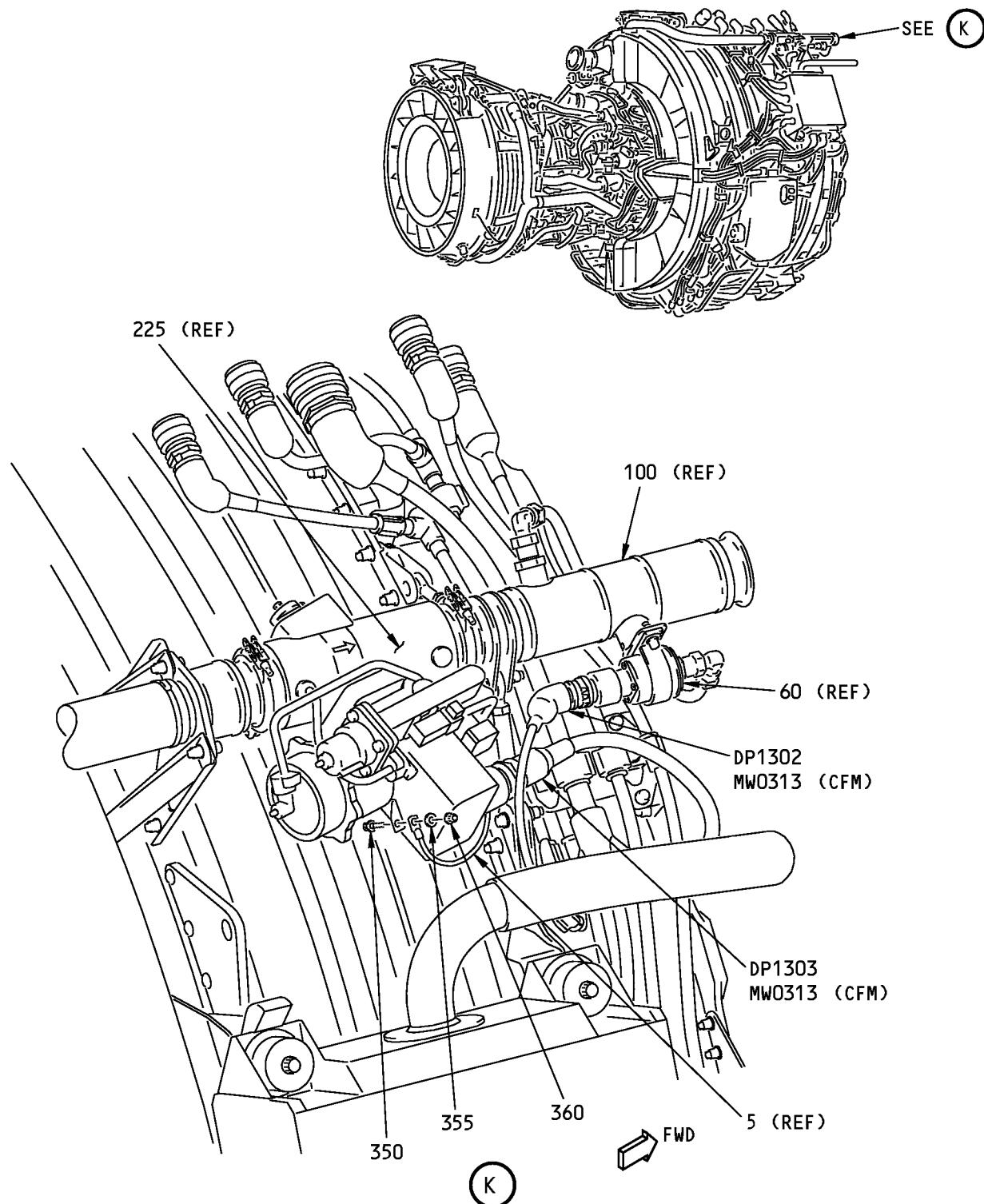
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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
27-1		INLET COWL TAI SYSTEM INSTALLATION (FIGURE 27-1, SHEET 10) CLEAN BONDING JUMPER TAB ON VALVE (225) WITH alcohol, B00130 (C2). . ALCOHOL CAUTION: DO NOT LET THE BONDING JUMPER TOUCH THE VALVE OR ENGINE FAN CASE. DAMAGE TO THE FAN CASE CAN OCCUR. ATTACH BONDING JUMPER (5) TO TAB ON VALVE (225) USING BOLT (350), WASHER (355) AND NUT (360). ORIENT LUG ON BONDING JUMPER (5) TO REDUCE SLACK. . BOLT (BOLT HEAD DOWN) . WASHER (UNDER NUT) . NUT TIGHTEN BOLT (350) TO 50-56 POUND-INCHES (5.6-6.3 NEWTON METERS). MEASURE RESISTANCE BETWEEN VALVE HOUSING AND ENGINE BRACKET. MAXIMUM PERMITTED RESISTANCE IS 0.008 OHMS. CAUTION: DO NOT OVERTIGHTEN THE PLUG COUPLING RING. DO NOT USE WATER PUMP PLIERS, PIPE WRENCHES OR VISE GRIPS TO TIGHTEN THE COUPLING RING OR DAMAGE TO THE ELECTRICAL CONNECTOR CAN OCCUR. CONNECT MW0313 ELECTRICAL CONNECTOR, DP1302, TO PRESSURE SWITCH AND MW0313 ELECTRICAL CONNECTOR, DP1303, TO VALVE. TURN KNURLED COUPLING RING WHILE WIGGLING THE BACKSHELL ASSEMBLY. AFTER FULLY SEATING THE COUPLING RING, USE SOFT-JAWED PLIERS OR A STRAP WRENCH TO TIGHTEN THE COUPLING RING AN ADDITIONAL 1/8 TURN OR UNTIL PLIER SLIPPAGE OCCURS.	CON	AR
C2	B00130			
350	BACB30ZF3-06		1	
355	NAS1149C0316R		1	
360	AS3485-09		1	

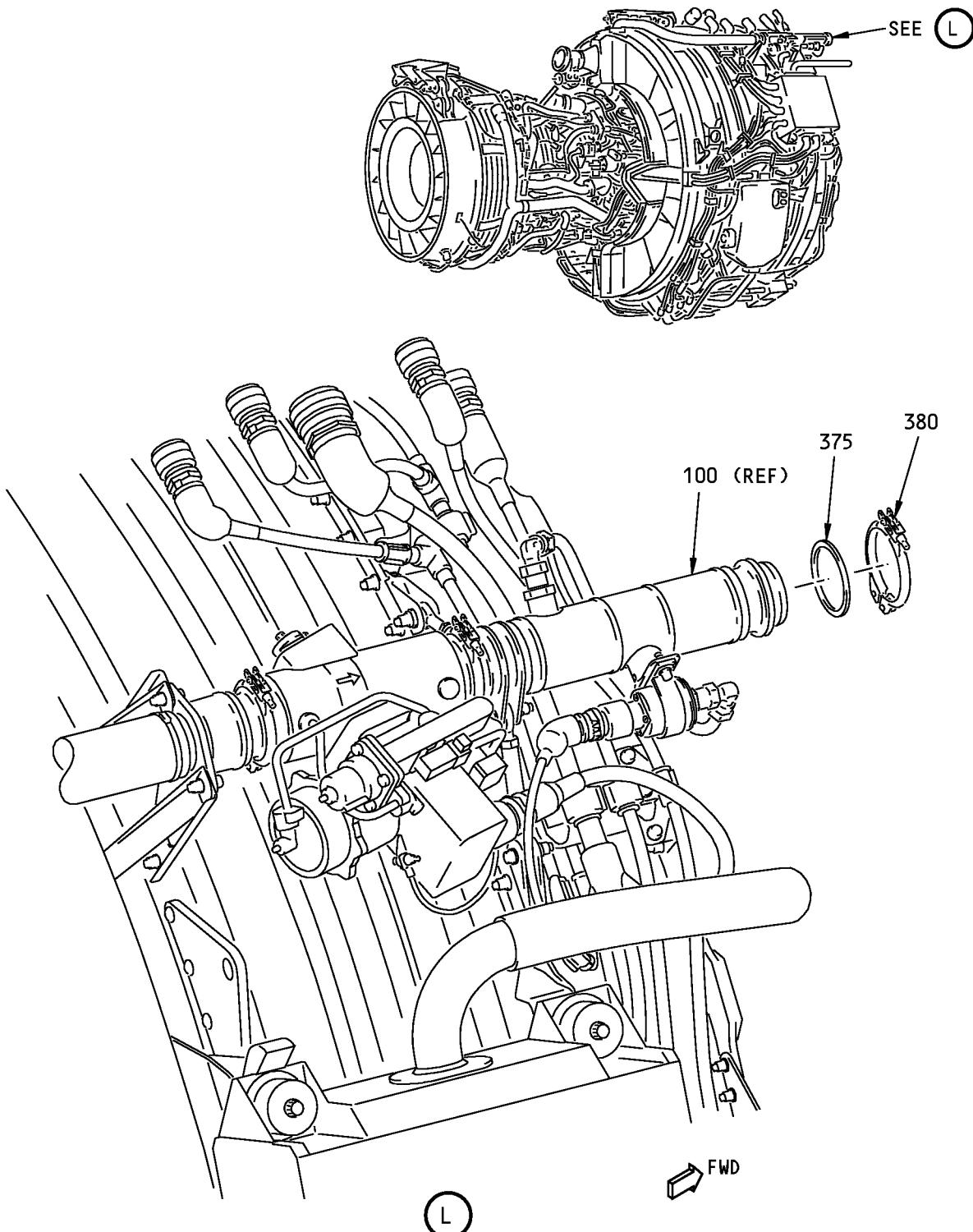
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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
27-1		INLET COWL TAI SYSTEM INSTALLATION (FIGURE 27-1, SHEET 11) PUT ITEMS (375 AND 380) IN A BAG AND SECURE TO DUCT ASSY (100). NOTE: ITEMS (375) AND (380) WILL BE INSTALLED DURING INLET COWL INSTALLATION (INLET COWL INSTALLATION/Figure 33-1).		
375	AS1895-7-200	. SEAL		1
375	AS1895/7-200	. SEAL (OPTIONAL TO AS1895-7-200)	OPT	-
380	AS1895-4-200	. COUPLING		1
380	AS1895/4-200	. COUPLING (OPTIONAL TO AS1895-4-200)	OPT	-

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FIGURE 28-1

FIRE/OVERHEAT DETECTOR INSTALLATION

REF QEC TASK NO.: 28

REF DWG: 332A2500

NOTE: ALL STANDARDS AND ATTACHING HARDWARE FOR THIS FIGURE WILL BE PACKAGED IN QEC TASK NO. 110.

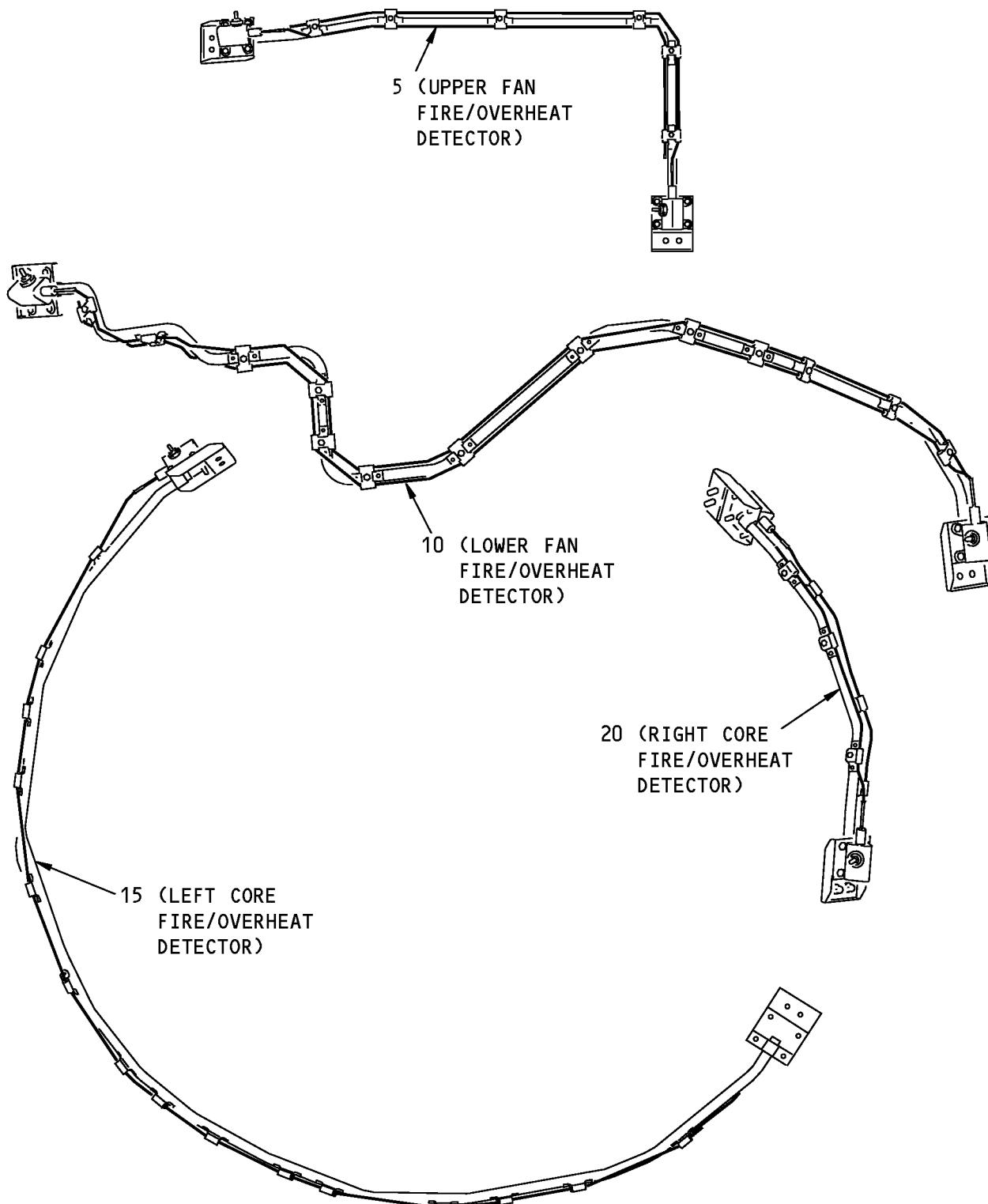
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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
28-1		FIRE/OVERHEAT DETECTOR INSTALLATION (FIGURE 28-1, SHEET 1) BENCH TEST RESISTANCE OF DETECTORS (5), (10), (15) AND (20) FROM THE DETECTOR STUD TO THE MOUNTING BRACKET. MAKE SURE RESISTANCE IS BETWEEN THE FOLLOWING RANGES: DETECTOR (5) BETWEEN 5624 - 6218 (OHMS) DETECTOR (10) BETWEEN 3734 - 4128 (OHMS) DETECTOR (15) BETWEEN 2860 - 3162 (OHMS) DETECTOR (20) BETWEEN 2347 - 2595 (OHMS) . FIRE DETECTOR, UPPER FAN (V25693) (SPEC S332T100-44) . FIRE DETECTOR, LOWER FAN (V25693) (SPEC S332T100-30) . FIRE DETECTOR, LEFT CORE (V25693) (SPEC S332T100-43) . FIRE DETECTOR, RIGHT CORE (V25693) (SPEC S332T100-38) IF DETECTOR DOES NOT TEST WITHIN SPECIFIED RANGE, REPLACE DETECTOR.		
5	902864		VEN	1
10	902016-01		VEN	1
15	902862		VEN	1
20	902018-01		VEN	1

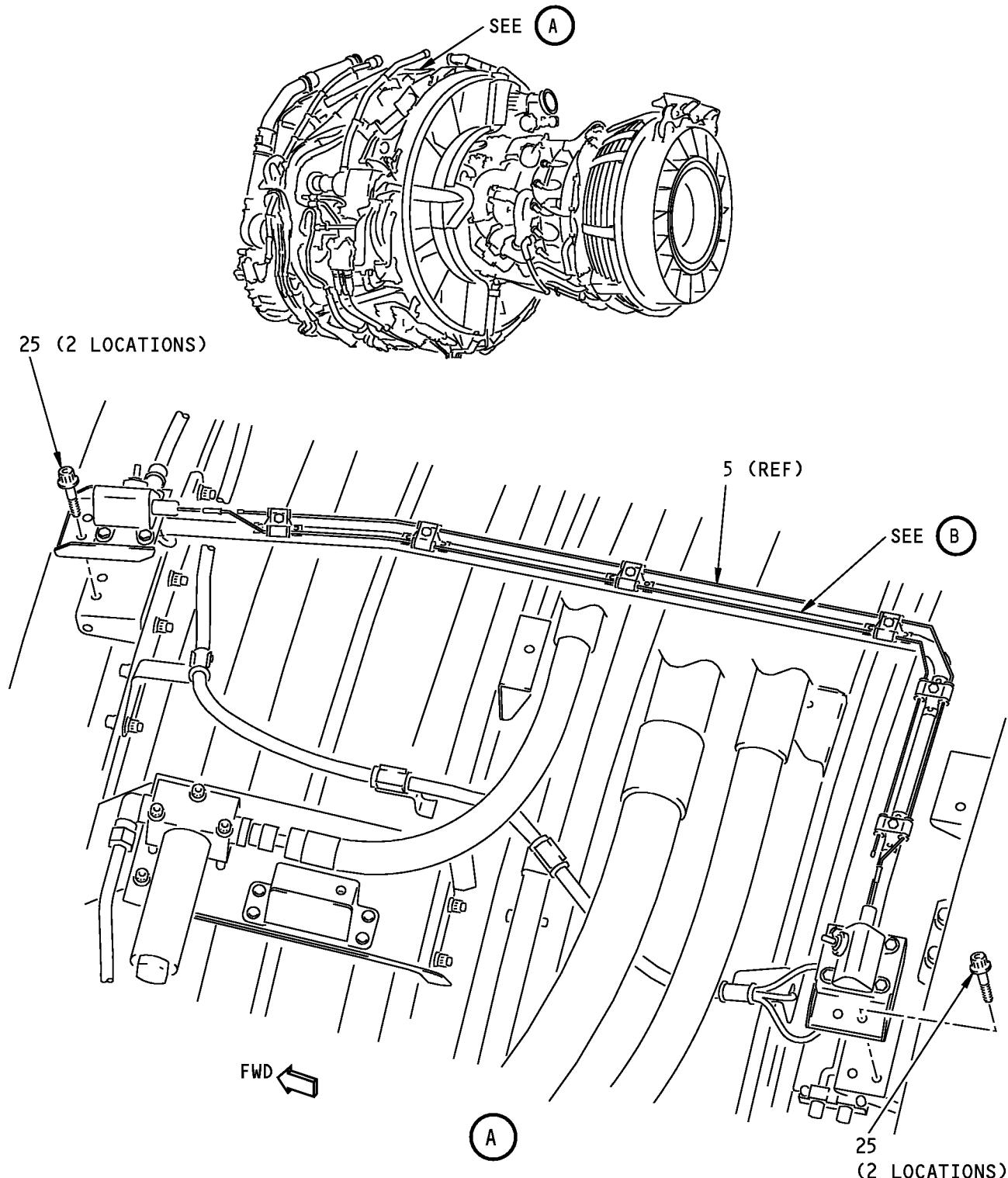
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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
28-1 C1	B00083	FIRE/OVERHEAT DETECTOR INSTALLATION (FIGURE 28-1, SHEET 2) USE solvent, B00083 (C1) TO CLEAN FAY SURFACES OF BOTH ELECTRICAL DETECTOR BRACKETS ON FIRE DETECTOR (5) AND FAY SURFACES OF ENGINE BRACKETS AT 11:00 AND 11:30 O'CLOCK POSITIONS ON TOP OF FAN CASE. . SOLVENT POSITION FIRE DETECTOR (5) ON ENGINE BRACKETS ON TOP OF ENGINE FAN CASE. MAKE SURE SUPPORT TUBE ALIGNSS NEXT TO HOLES IN BRACKETS.	CON	AR
25	BACB30ZF4-06	LOOSELY ATTACH DETECTOR BRACKETS TO ENGINE BRACKETS WITH BOLTS (25). . BOLT		4

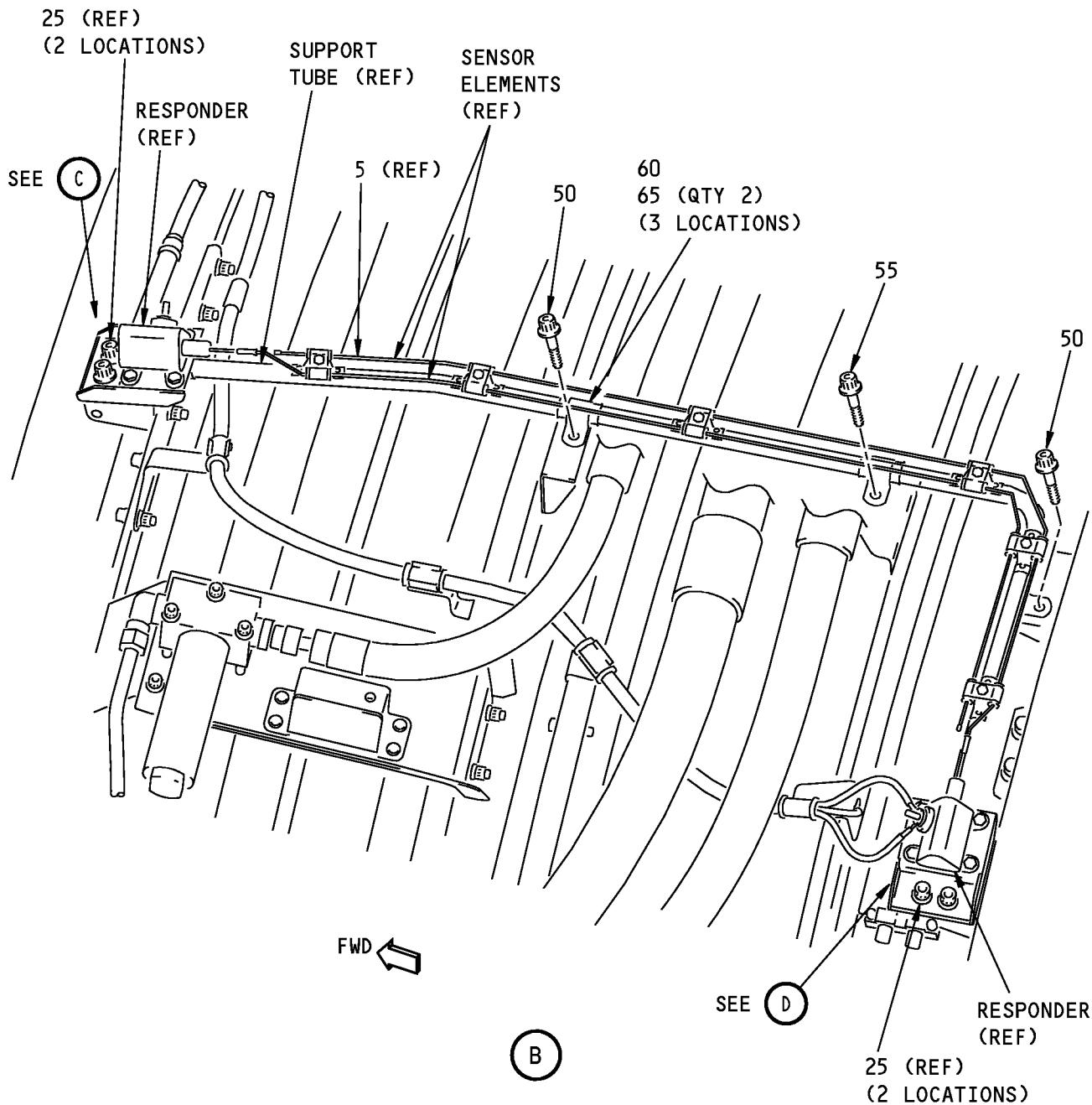
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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
28-1		FIRE/OVERHEAT DETECTOR INSTALLATION (FIGURE 28-1, SHEET 3) APPLY Never-Seez NSBT-8N compound, D00006 (C2) UNDER HEAD OF BOLTS (50 AND 55) TO PREVENT DISTORTION AND TWISTING OF CLAMP DURING TORQUING.		
50	BACB30ZF4-06	. BOLT		2
55	BACB30ZF4-06	. BOLT		1
C2	D00006	. NEVER-SEEZ NSBT-8N COMPOUND	CON	AR
		LOOSELY ATTACH SUPPORT TUBE OF DETECTOR (5) TO ENGINE BRACKETS WITH LOOP CLAMPS (60), CLAMPSHELLS (65) AND BOLTS (50).		
60	11777-08	. LOOP CLAMP (V83930)	VEN	3
65	9352M41P04	. CLAMPSHELL (V83930)	VEN	6
65	BACC10GT2-08	. CLAMPSHELL (OPTIONAL TO 9352M41P04)	OPT	-
		MAKE SURE PRELOAD BETWEEN DETECTOR ASSY AND ATTACH POINTS IS NOT MORE THAN 10 POUNDS (44.5 NEWTONS). TIGHTEN BOLTS (25), THEN BOLTS (50) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS). TIGHTEN BOLTS (55) TO 73-77 POUND-INCHES (8.25-8.70 NEWTON METERS).		
		CHECK THAT RESISTANCE BETWEEN RESPONDER AND ENGINE CASE IS 0.010 OHMS MAXIMUM.		
		CHECK THAT GAP BETWEEN SENSOR ELEMENTS AND SUPPORT TUBE IS NOT LESS THAN 0.12 INCH (3.0 MM).		
		AFTER TIGHTENING, MINIMUM CLEARANCE OF 0.15 INCH (3.8 MM) BETWEEN FIRE DETECTOR AND FAN COWL SUPPORT BEAM INSULATION BLANKET IS PERMITTED.		

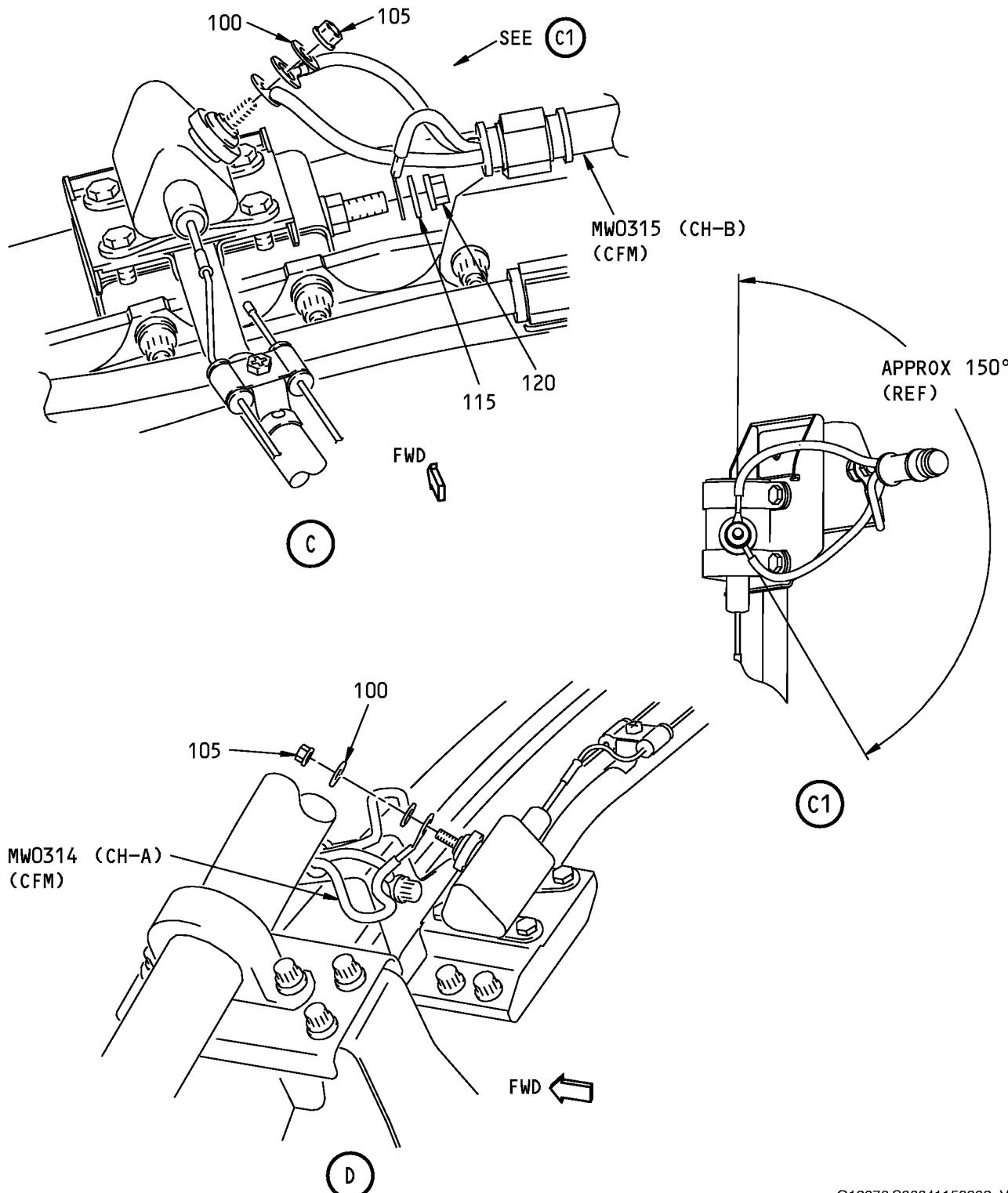
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Fire/Overheat Detector Installation
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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
28-1		FIRE/OVERHEAT DETECTOR INSTALLATION (FIGURE 28-1, SHEET 4) ATTACH W/B MW0315 (CFM) TO UPPER RESPONDER AND ATTACH W/B MW0314 (CFM) TO LOWER RESPONDER. PUT BOTH W/B LEADS ON EACH RESPONDER STUD AND SECURE WITH WASHER (100) AND NUT (105). POSITION W/B MW0315 (CFM) LEADS APPROXIMATELY AS SHOWN AND TIE WRAP WIRES AS REQUIRED TO MAINTAIN THIS POSITION. TIGHTEN NUT TO 25-35 POUND-INCHES (2.8-4.0 NEWTON METERS). MINIMUM STUD THREAD PROTRUSION MUST BE FLUSH WITH TOP OF NUT.		
100	NAS1149C0316R	. WASHER	OPT	2
100	NAS1149C0332R	. WASHER (OPTIONAL TO NAS1149C0316R) (2 REQD)	OPT	-
105	BACN10JC3C	. NUT (SUPPLIED WITH F/O DETECTOR)	REF	-
105	BACN10YR3C	. NUT (OPTIONAL TO BACN10JC3C) (2 REQD)	OPT	-
		ATTACH W/B MW0315 (CFM) GROUNDING WIRE TO UPPER RESPONDER BRACKET. SECURE WITH WASHER (115) AND NUT (120) AND TIGHTEN TO 90-105 POUND-INCHES (10.2-11.9 NEWTON METERS).		
115	NAS1149C0432R	. WASHER		1
120	BACN10YR4CM	. NUT		1

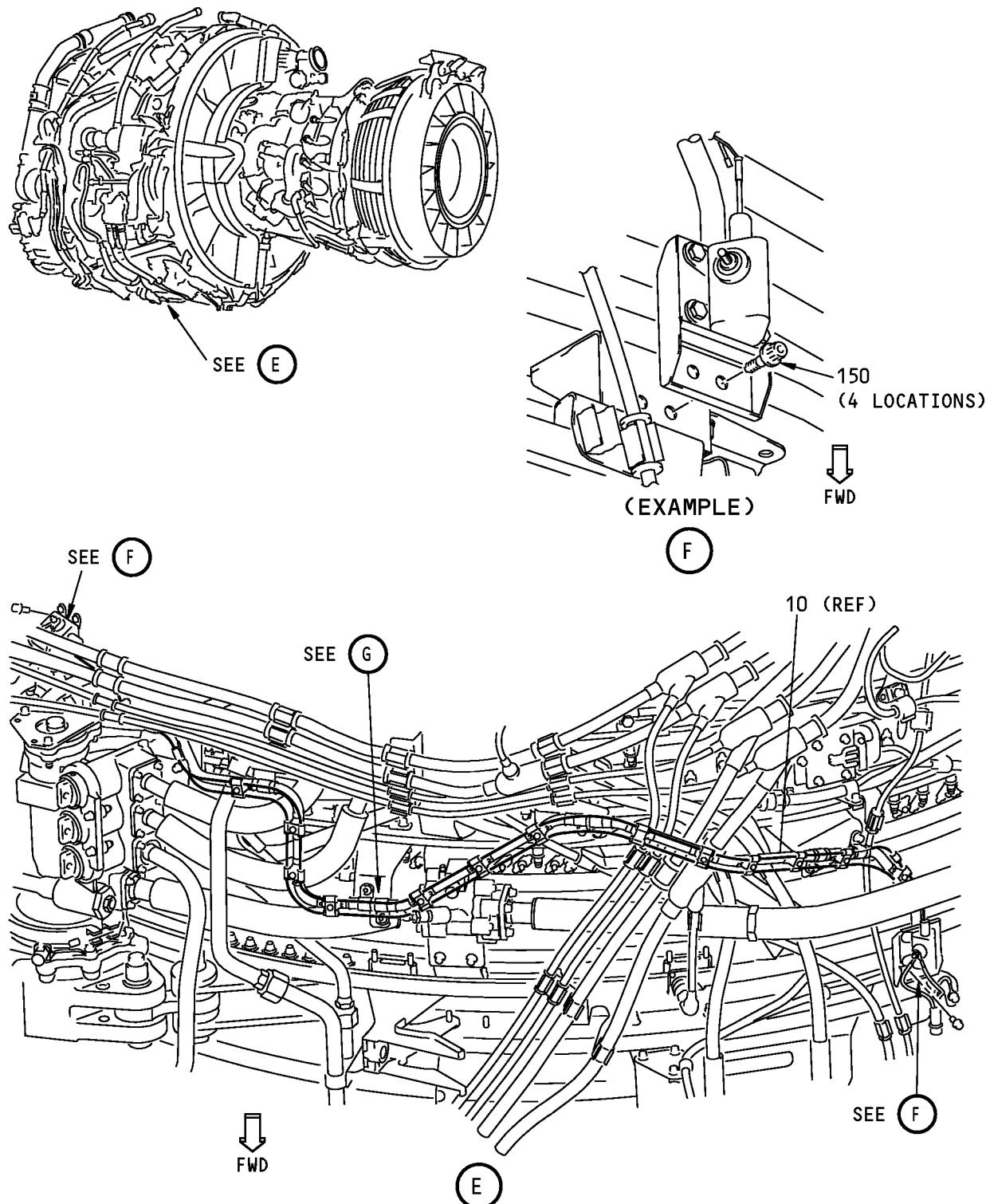
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P/P BUILDUP FIGURE 28-1

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737-600/700/800/900
POWERPLANT BUILDUP MANUALFire/Overheat Detector Installation
Figure 28-1 (Sheet 5)

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
28-1		FIRE/OVERHEAT DETECTOR INSTALLATION (FIGURE 28-1, SHEET 5) USE solvent, B00083 (C1) TO CLEAN FAY SURFACES OF BOTH ELECTRICAL DETECTOR BRACKETS ON FIRE DETECTOR (10) AND FAY SURFACES OF ENGINE BRACKETS AT 3:00 THRU 7:00 O'CLOCK POSITIONS ON FAN CASE. . SOLVENT		
C1	B00083	POSITION FIRE DETECTOR (10) ON ENGINE BRACKETS ON ENGINE FAN CASE. MAKE SURE SUPPORT TUBE ALIGNS NEXT TO HOLES IN BRACKETS.	CON	AR
150	BACB30ZF4-06	LOOSELY ATTACH DETECTOR BRACKETS TO ENGINE BRACKETS WITH BOLTS (150). . BOLT		4

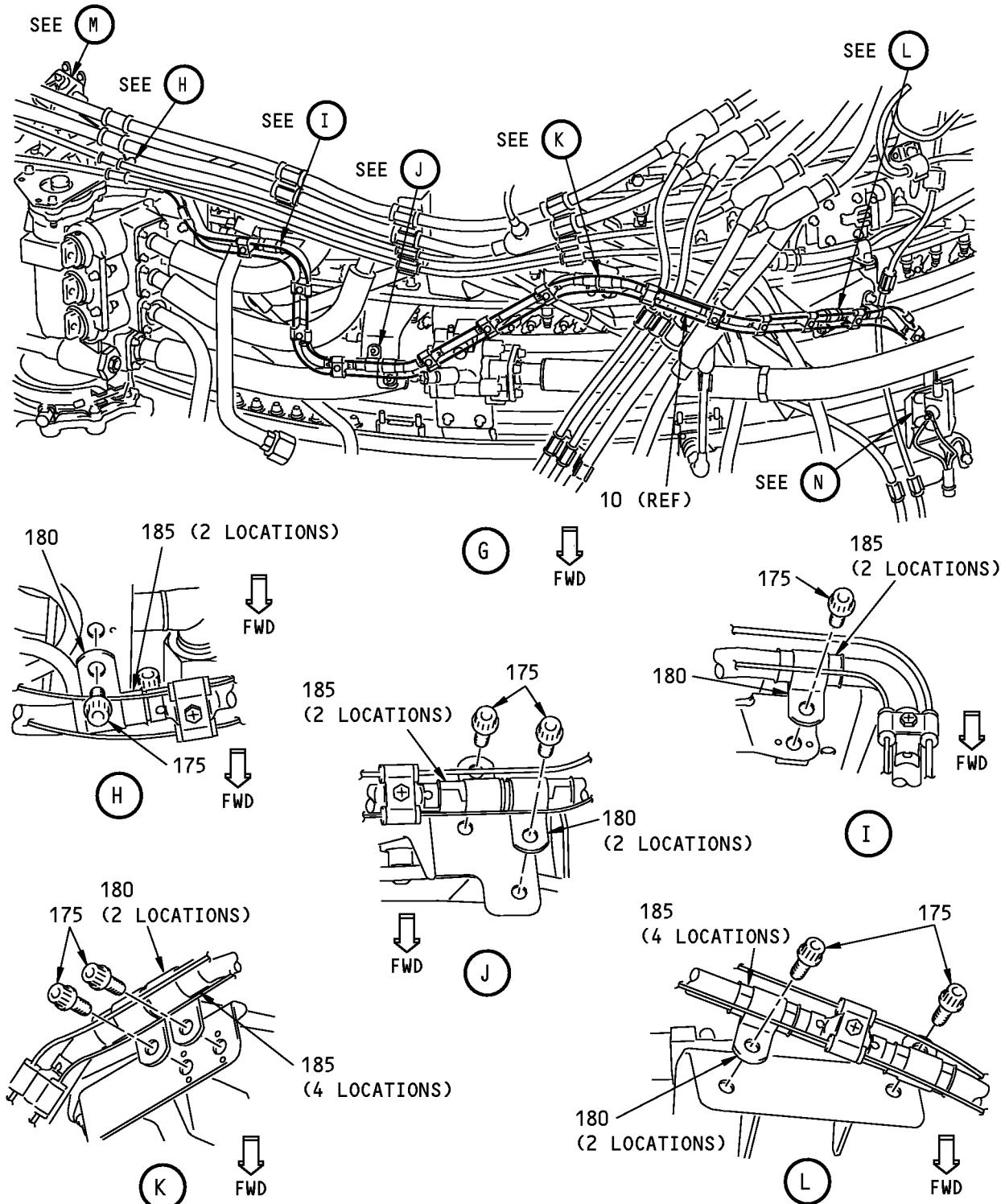
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P/P BUILDUP FIGURE 28-1

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POWERPLANT BUILDUP MANUALFire/Overheat Detector Installation
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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
28-1		FIRE/OVERHEAT DETECTOR INSTALLATION (FIGURE 28-1, SHEET 6) APPLY Never-Seez NSBT-8N compound, D00006 (C2) UNDER HEAD OF BOLTS (175) TO PREVENT DISTORTION AND TWISTING OF CLAMP DURING TORQUING.		
175 C2	BACB30ZF4-06 D00006	. BOLT . NEVER-SEEZ NSBT-8N COMPOUND LOOSELY ATTACH SUPPORT TUBE OF DETECTOR (10) TO ENGINE BRACKETS AT 8 LOCATIONS WITH LOOP CLAMPS (180), CLAMPSHELLS (185) AND BOLTS (175). NOTE: IN LOCATIONS WITH 2 ADJACENT CLAMPS, CLAMPSHELL-TO-CLAMPSHELL CLEARANCE IS LESS THAN 0.005 INCH (0.13 MM). IN THESE LOCATIONS, THE CLAMP MAY RIDE THE RADIUS OF THE CLAMPSHELL.	CON	8 AR
180	11777-08	. LOOP CLAMP (V83930)	VEN	8
185	9352M41P04	. CLAMPSHELL (V83930)	VEN	16
185	BACC10GT2-08	. CLAMPSHELL (OPTIONAL TO 9352M41P04)	OPT	-
		MAKE SURE PRELOAD BETWEEN DETECTOR ASSY AND ATTACH POINTS IS NOT MORE THAN 10 POUNDS (44.5 NEWTONS). TIGHTEN BOLTS (150) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS). TIGHTEN BOLTS (175) TO 73-77 POUND-INCHES (8.25-8.70 NEWTON METERS). CHECK THAT RESISTANCE BETWEEN RESPONDER AND ENGINE CASE IS 0.010 OHMS MAXIMUM. CHECK THAT GAP BETWEEN SENSOR ELEMENTS AND SUPPORT TUBE IS NOT LESS THAN 0.12 INCH (3.0 MM).		

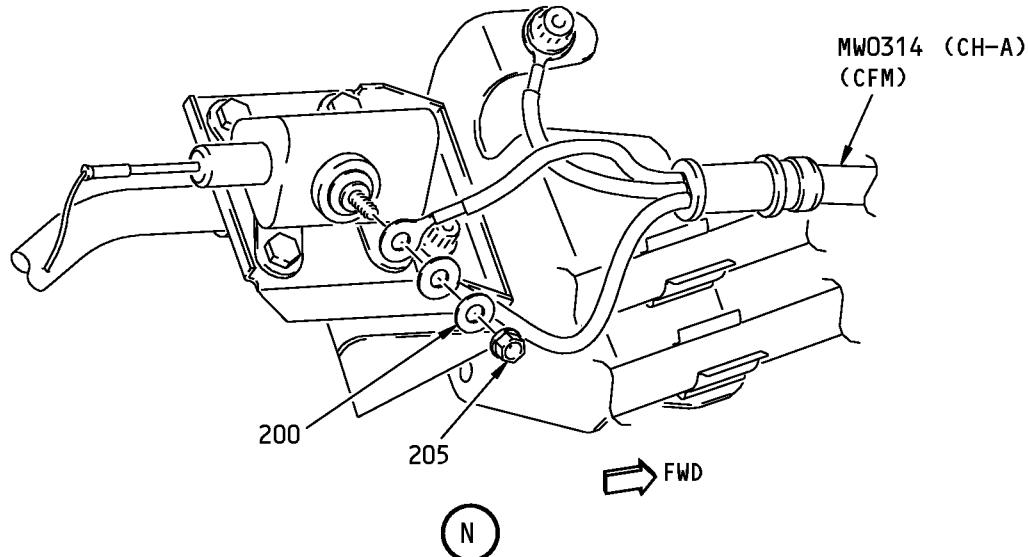
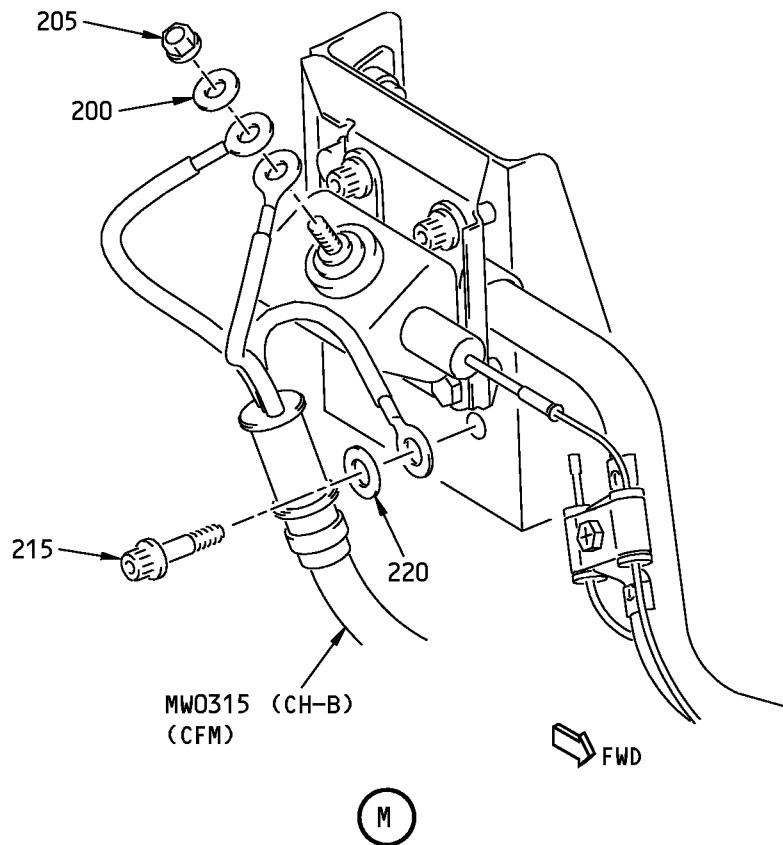
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P/P BUILDUP FIGURE 28-1

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POWERPLANT BUILDUP MANUAL

Fire/Overheat Detector Installation
Figure 28-1 (Sheet 7)

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
28-1		FIRE/OVERHEAT DETECTOR INSTALLATION (FIGURE 28-1, SHEET 7) ATTACH W/B MW0315 (CFM) TO LEFT RESPONDER AND ATTACH W/B MW0314 (CFM) TO RIGHT RESPONDER. PUT BOTH W/B LEADS ON EACH RESPONDER STUD AND SECURE WITH WASHER (200) AND NUT (205). TIGHTEN NUT TO 25-35 POUND-INCHES (2.8-4.0 NEWTON METERS). MINIMUM STUD THREAD PROTRUSION MUST BE FLUSH WITH TOP ON NUT.		
200	NAS1149C0316R	. WASHER	OPT	2
200	NAS1149C0332R	. WASHER (OPTIONAL TO NAS1149C0316R) (2 REQD)	OPT	-
205	BACN10JC3C	. NUT (SUPPLIED WITH F/O DETECTOR)	REF	-
205	BACN10YR3C	. NUT (OPTIONAL TO BACN10JC3C) (2 REQD)	OPT	-
		ATTACH W/B MW0315 (CFM) GROUNDING WIRE TO LEFT RESPONDER BRACKET. SECURE WITH BOLT (215) AND WASHER (220) AND TIGHTEN TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS).		
215	BACB30ZF4-07	. BOLT		1
220	NAS1149C0432R	. WASHER		1

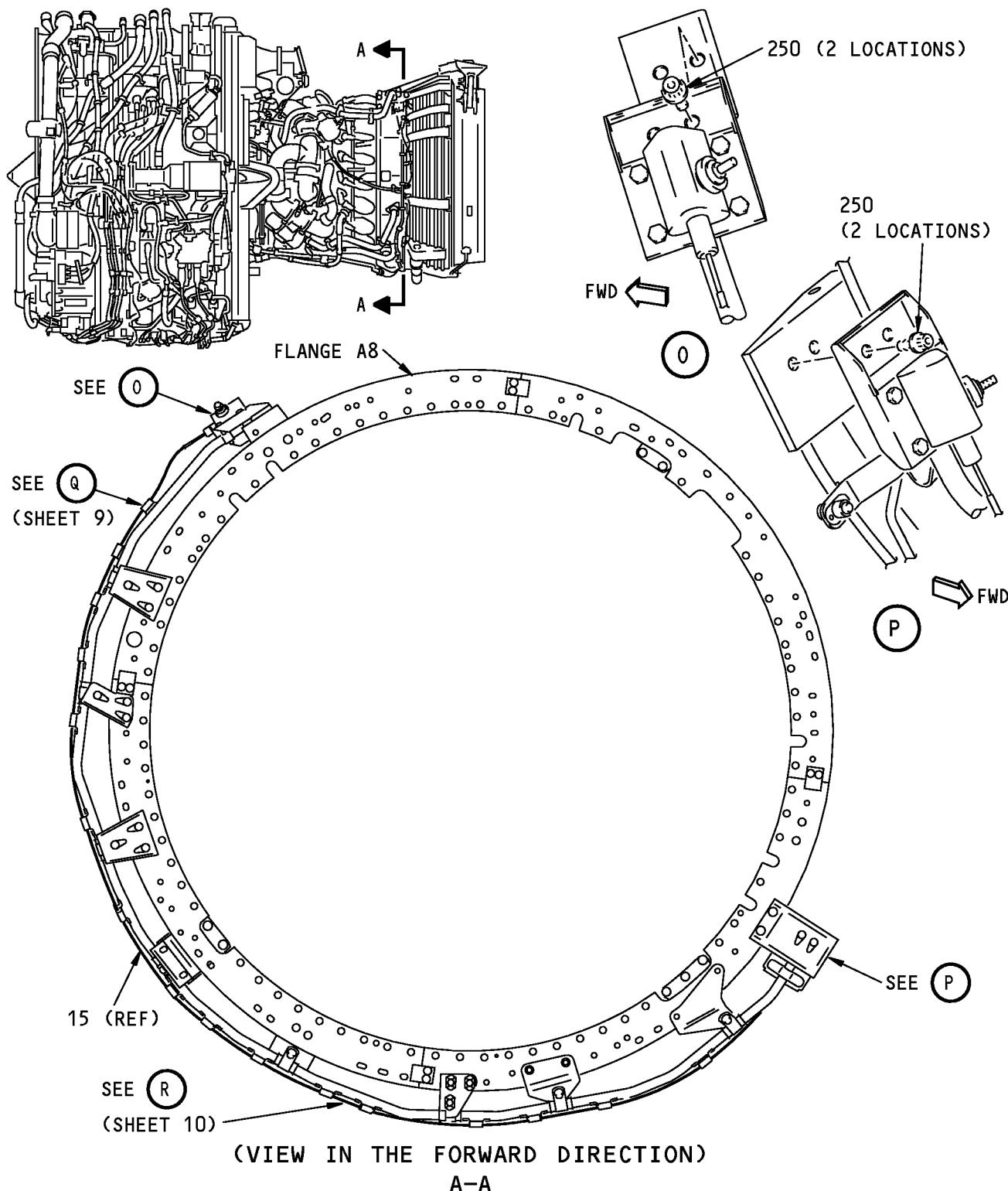
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P/P BUILDUP FIGURE 28-1

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POWERPLANT BUILDUP MANUALFire/Overheat Detector Installation
Figure 28-1 (Sheet 8)

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P/P BUILDUP FIGURE 28-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
28-1 C1 250	B00083 BACB30ZF4-07	<p>FIRE/OVERHEAT DETECTOR INSTALLATION (FIGURE 28-1, SHEET 8)</p> <p>USE solvent, B00083 (C1) TO CLEAN FAY SURFACES OF BOTH ELECTRICAL DETECTOR BRACKETS ON FIRE DETECTOR (15) AND FAY SURFACES OF ENGINE BRACKETS AT 10:30 AND 4:00 O'CLOCK POSITIONS ON ENGINE CORE FLANGE A8.</p> <p>. SOLVENT</p> <p>POSITION FIRE DETECTOR (15) ON ENGINE BRACKETS. MAKE SURE SUPPORT TUBE ALIGNS NEXT TO HOLES IN BRACKETS.</p> <p>LOOSELY ATTACH DETECTOR BRACKETS TO ENGINE BRACKETS WITH BOLTS (250).</p> <p>. BOLT</p>	CON	AR 4

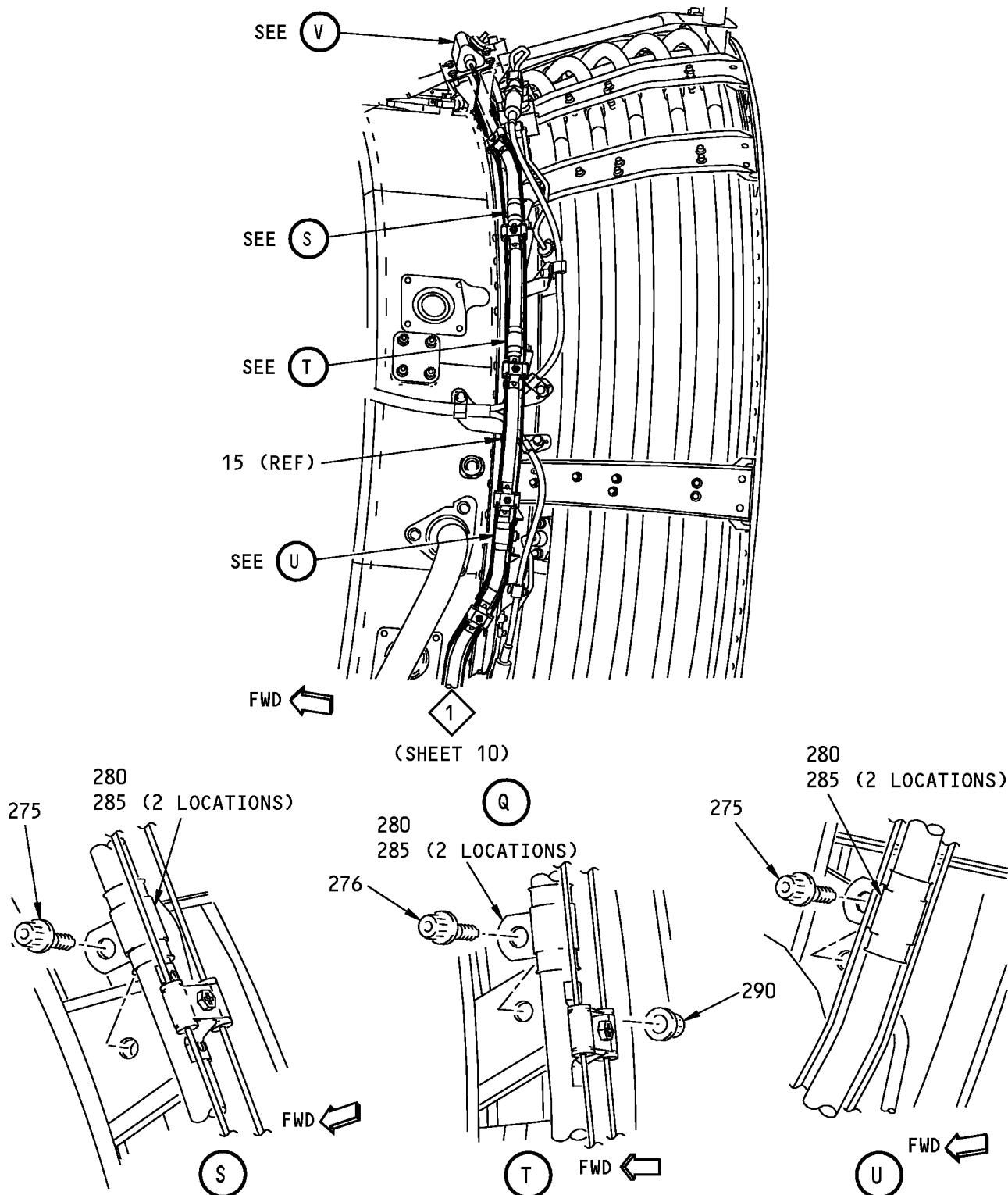
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P/P BUILDUP FIGURE 28-1

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POWERPLANT BUILDUP MANUALFire/Overheat Detector Installation
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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
28-1		FIRE/OVERHEAT DETECTOR INSTALLATION (FIGURE 28-1, SHEET 9) APPLY Never-Seez NSBT-8N compound, D00006 (C2) UNDER HEAD OF BOLTS (275) AND BOLT (276) TO PREVENT DISTORTION AND TWISTING OF CLAMP DURING TORQUING.		
275	BACB30ZF4-06	. BOLT		2
276	BACB30ZF4-08	. BOLT		1
C2	D00006	. NEVER-SEEZ NSBT-8N COMPOUND	CON	AR
		LOOSELY ATTACH SUPPORT TUBE OF DETECTOR (15) TO ENGINE BRACKETS AT 3 LOCATIONS WITH LOOP CLAMPS (280), CLAMPSHELLS (285), BOLTS (275) (2 LOCATIONS), BOLT (276) (1 LOCATION) AND NUT (290).		
280	11777-08	. LOOP CLAMP (V83930)	VEN	3
285	9352M41P04	. CLAMPSHELL (V83930)	VEN	6
285	BACC10GT2-08	. CLAMPSHELL (OPTIONAL TO 9352M41P04)	OPT	-
290	AS3485-10	. NUT		1

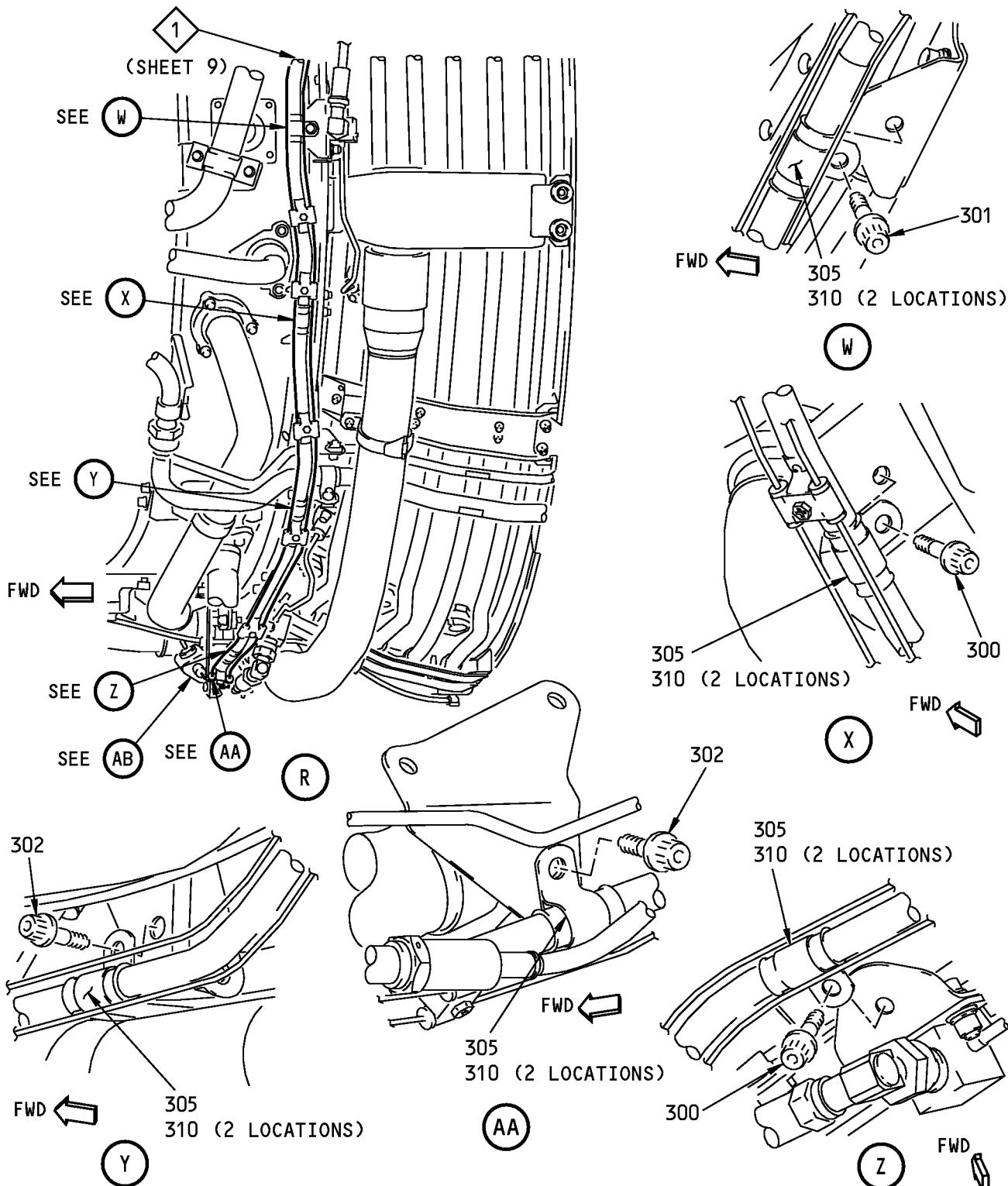
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P/P BUILDUP FIGURE 28-1

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POWERPLANT BUILDUP MANUALFire/Overheat Detector Installation
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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
28-1		FIRE/OVERHEAT DETECTOR INSTALLATION (FIGURE 28-1, SHEET 10) APPLY Never-Seez NSBT-8N compound, D00006 (C2) UNDER HEAD OF BOLTS (300, 301 AND 302) TO PREVENT DISTORTION AND TWISTING OF CLAMP DURING TORQUING.		
300	BACB30ZF4-06	. BOLT		2
301	BACB30ZF4-08	. BOLT		1
302	BACB30ZF4-06	. BOLT		2
C2	D00006	. NEVER-SEEZ NSBT-8N COMPOUND LOOSELY ATTACH SUPPORT TUBE OF DETECTOR (15) TO ENGINE BRACKETS AT 5 LOCATIONS WITH LOOP CLAMPS (305), CLAMPSHELLS (310), BOLTS (300, 301 AND 302).	CON	AR
305	11777-08	. LOOP CLAMP (V83930)	VEN	5
310	9352M41P04	. CLAMPSHELL (V83930)	VEN	10
310	BACC10GT2-08	. CLAMPSHELL (OPTIONAL TO 9352M41P04)	OPT	-
		MAKE SURE PRELOAD BETWEEN DETECTOR ASSY AND ATTACH POINTS IS NOT MORE THAN 10 POUNDS (44.5 NEWTONS). TIGHTEN BOLTS (250), THEN BOLTS (301 AND 302) TO 73-77 POUND-INCHES (8.25-8.70 NEWTON METERS). TIGHTEN BOLTS (275 AND 300) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS). CHECK THAT RESISTANCE BETWEEN RESPONDER AND ENGINE CASE IS 0.010 OHMS MAXIMUM. CHECK THAT GAP BETWEEN SENSOR ELEMENTS AND SUPPORT TUBE IS NOT LESS THAN 0.12 INCH (3.0 MM).		

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P/P BUILDUP FIGURE 28-1

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Fire/Overheat Detector Installation
Figure 28-1 (Sheet 11)

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P/P BUILDUP FIGURE 28-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
28-1		FIRE/OVERHEAT DETECTOR INSTALLATION (FIGURE 28-1, SHEET 11) THIS SHEET NOT USED		

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P/P BUILDUP FIGURE 28-1

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Fire/Overheat Detector Installation
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P/P BUILDUP FIGURE 28-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
28-1		FIRE/OVERHEAT DETECTOR INSTALLATION (FIGURE 28-1, SHEET 12) THIS SHEET NOT USED		

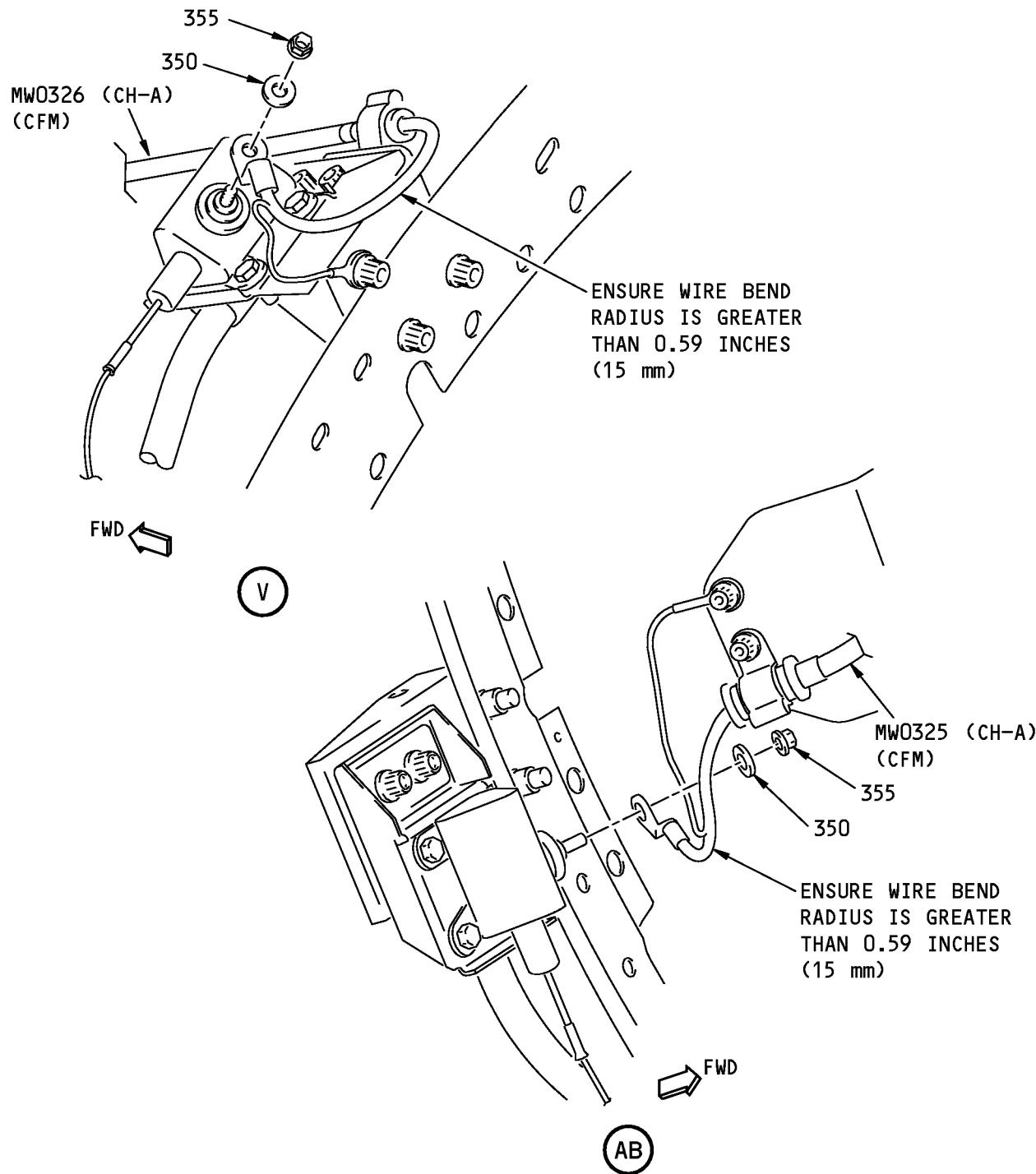
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P/P BUILDUP FIGURE 28-1

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POWERPLANT BUILDUP MANUAL

2026240 S0000403133_V2

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P/P BUILDUP FIGURE 28-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
28-1		FIRE/OVERHEAT DETECTOR INSTALLATION (FIGURE 28-1, SHEET 13) CAUTION: DO NOT BEND THE WIRE LUG. INCORRECT INSTALLATION CAN CAUSE WIRE LUG DAMAGE AND DETECTOR LOOP FAULTS. ATTACH W/B MW0325 (CFM) TO UPPER RESPONDER AND ATTACH W/B MW0325 (CFM) TO LOWER RESPONDER. PUT BOTH W/B LEADS ON EACH RESPONDER STUD AND SECURE WITH WASHER (350) AND NUT (355). TIGHTEN NUT TO 25-35 POUND-INCHES (2.8-4.0 NEWTON METERS). MINIMUM STUD THREAD PROTRUSION MUST BE FLUSH WITH TOP OF NUT.		
350	NAS1149C0316R	. WASHER	OPT	2
350	NAS1149C0332R	. WASHER (OPTIONAL TO NAS1149C0316R) (2 REQD)	OPT	-
355	BACN10JC3C	. NUT (SUPPLIED WITH F/O DETECTOR)	REF	-
355	BACN10YR3C	. NUT (OPTIONAL TO BACN10JC3C) (2 REQD)	OPT	-

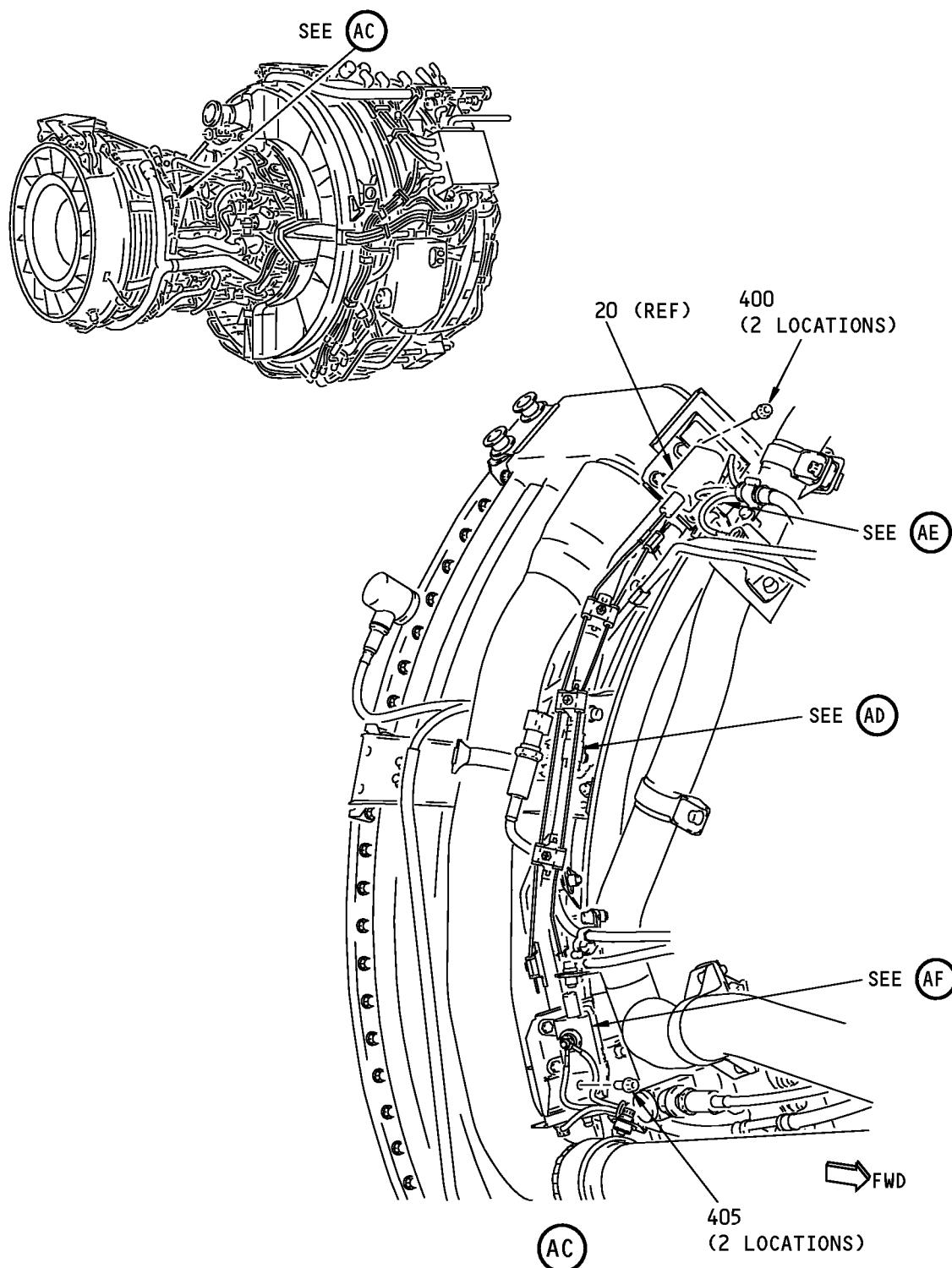
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P/P BUILDUP FIGURE 28-1

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POWERPLANT BUILDUP MANUALFire/Overheat Detector Installation
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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
28-1		FIRE/OVERHEAT DETECTOR INSTALLATION (FIGURE 28-1, SHEET 14)		
C1	B00083	<p>USE solvent, B00083 (C1) TO CLEAN FAY SURFACES OF BOTH ELECTRICAL DETECTOR BRACKETS ON FIRE DETECTOR (20) AND FAY SURFACES OF ENGINE BRACKETS AT 1:00 AND 3:00 O'CLOCK POSITIONS ON ENGINE CORE FLANGE A8.</p> <p>. SOLVENT</p> <p>POSITION FIRE DETECTOR (20) ON ENGINE BRACKETS. MAKE SURE SUPPORT TUBE ALIGNSS NEXT TO HOLES IN BRACKETS.</p> <p>LOOSELY ATTACH DETECTOR BRACKET TO UPPER ENGINE BRACKET WITH BOLTS (400) AND LOWER ENGINE BRACKET WITH BOLTS (405).</p>	CON	AR
400	BACB30ZF4-06	. BOLT		2
405	BACB30ZF4-07	. BOLT		2

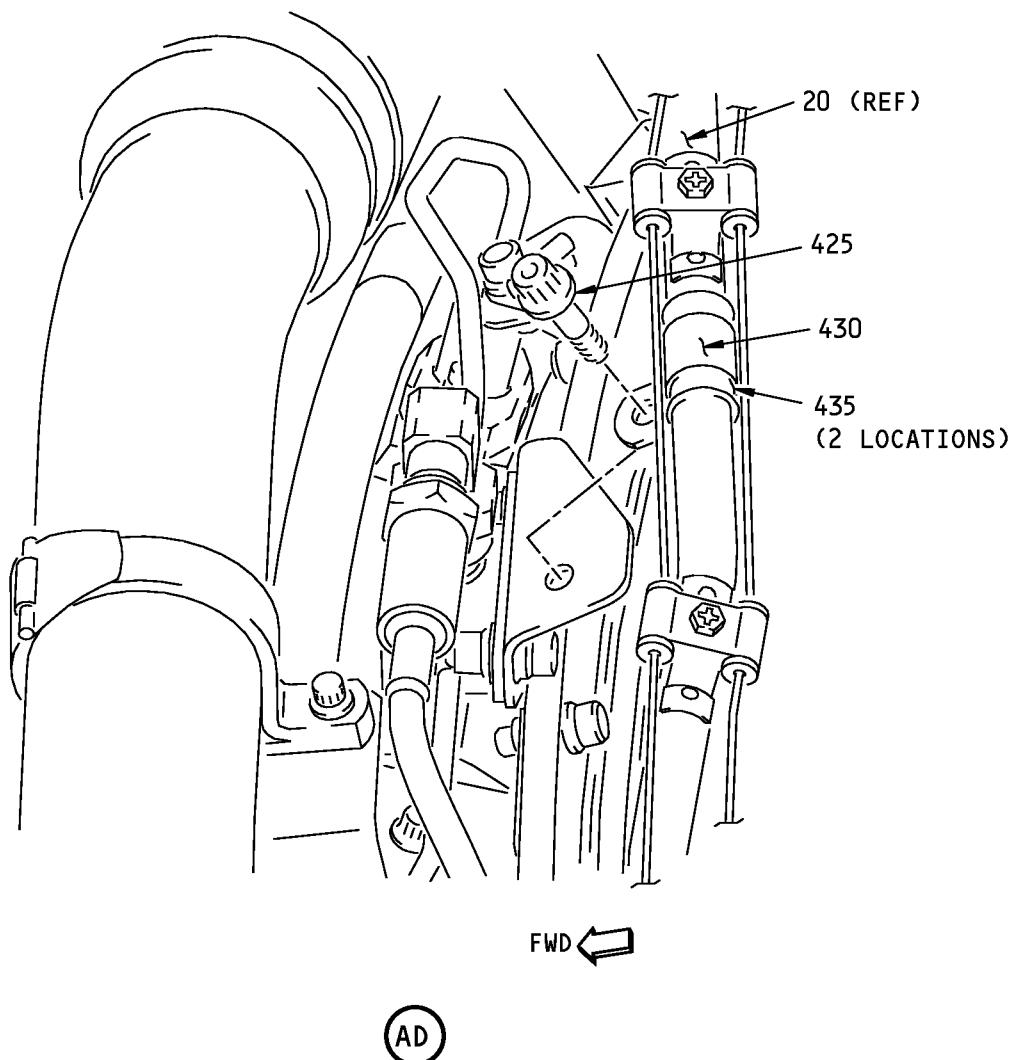
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P/P BUILDUP FIGURE 28-1

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POWERPLANT BUILDUP MANUALFire/Overheat Detector Installation
Figure 28-1 (Sheet 15)**71-00-02**

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
28-1		FIRE/OVERHEAT DETECTOR INSTALLATION (FIGURE 28-1, SHEET 15) APPLY Never-Seez NSBT-8N compound, D00006 (C2) UNDER HEAD OF BOLT (425) TO PREVENT DISTORTION AND TWISTING OF CLAMP DURING TORQUING.		
425 C2	BACB30ZF4-06 D00006	. BOLT . NEVER-SEEZ NSBT-8N COMPOUND LOOSELY ATTACH SUPPORT TUBE OF DETECTOR (20) TO ENGINE BRACKET WITH LOOP CLAMP (430), CLAMPSHELLS (435) AND BOLT (425).	CON	1 AR
430	11777-08	. LOOP CLAMP (V83930)	VEN	1
435	9352M41P04	. CLAMPSHELL (V83930)	VEN	2
435	BACC10GT2-08	. CLAMPSHELL (OPTIONAL TO 9352M41P04)	OPT	-
		MAKE SURE PRELOAD BETWEEN DETECTOR ASSY AND ATTACH POINTS IS NOT MORE THAN 10 POUNDS (44.5 NEWTONS). TIGHTEN BOLTS (400), THEN BOLT (425) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS). CHECK THAT RESISTANCE BETWEEN RESPONDER AND ENGINE CASE IS 0.010 OHMS MAXIMUM. CHECK THAT GAP BETWEEN SENSOR ELEMENTS AND SUPPORT TUBE IS NOT LESS THAN 0.12 INCH (3.0 MM).		

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P/P BUILDUP FIGURE 28-1

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Fire/Overheat Detector Installation
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P/P BUILDUP FIGURE 28-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
28-1		FIRE/OVERHEAT DETECTOR INSTALLATION (FIGURE 28-1, SHEET 16) THIS SHEET NOT USED		

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P/P BUILDUP FIGURE 28-1

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Fire/Overheat Detector Installation
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P/P BUILDUP FIGURE 28-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
28-1		FIRE/OVERHEAT DETECTOR INSTALLATION (FIGURE 28-1, SHEET 17) THIS SHEET NOT USED		

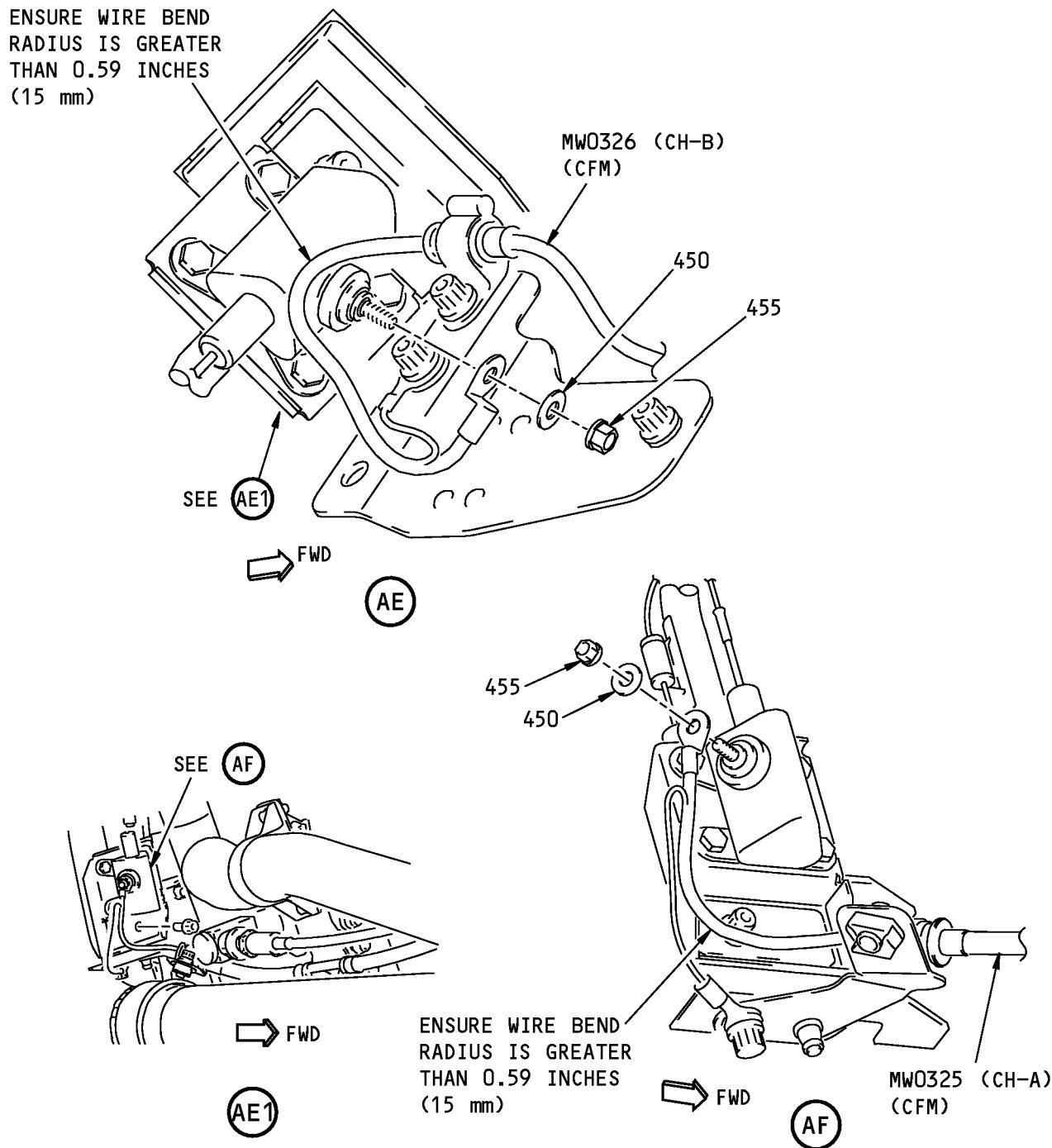
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P/P BUILDUP FIGURE 28-1

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POWERPLANT BUILDUP MANUAL

2026500 S0000403135_V3

Fire/Overheat Detector Installation
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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
28-1		FIRE/OVERHEAT DETECTOR INSTALLATION (FIGURE 28-1, SHEET 18) CAUTION: DO NOT BEND THE WIRE LUG. INCORRECT INSTALLATION CAN CAUSE WIRE LUG DAMAGE AND DETECTOR LOOP FAULTS. ATTACH W/B MW0326 (CFM) TO UPPER RESPONDER AND ATTACH W/B MW0325 (CFM) TO LOWER RESPONDER. PUT BOTH W/B LEADS ON EACH RESPONDER STUD AND SECURE WITH WASHER (450) AND NUT (455). TIGHTEN NUT TO 25-35 POUND-INCHES (2.8-4.0 NEWTON METERS). MINIMUM STUD THREAD PROTRUSION MUST BE FLUSH WITH TOP ON NUT.		
450	NAS1149C0316R	. WASHER	OPT	2
450	NAS1149C0332R	. WASHER (OPTIONAL TO NAS1149C0316R) (2 REQD)	OPT	-
455	BACN10JC3C	. NUT (SUPPLIED WITH F/O DETECTOR)	REF	-
455	BACN10YR3C	. NUT (OPTIONAL TO BACN10JC3C) (2 REQD)	OPT	-

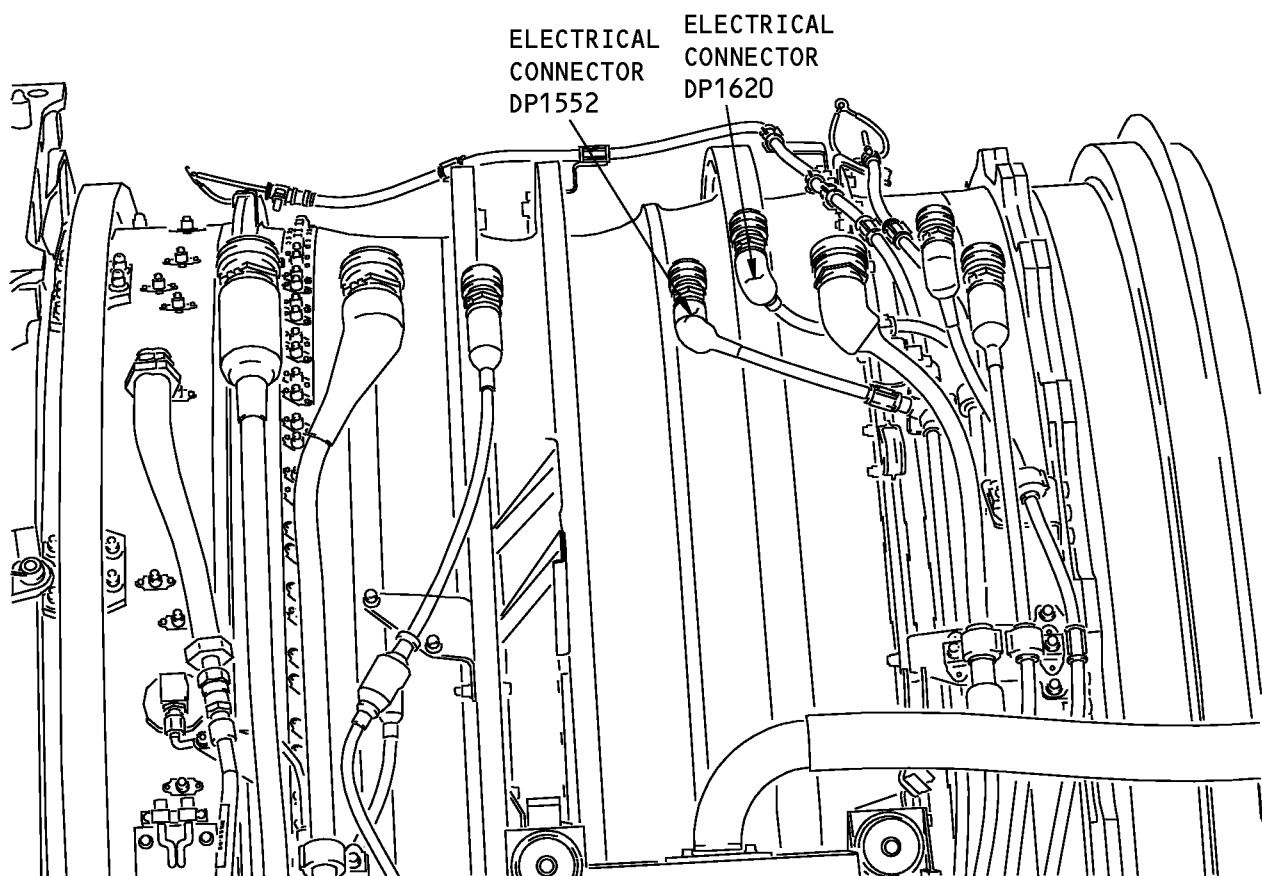
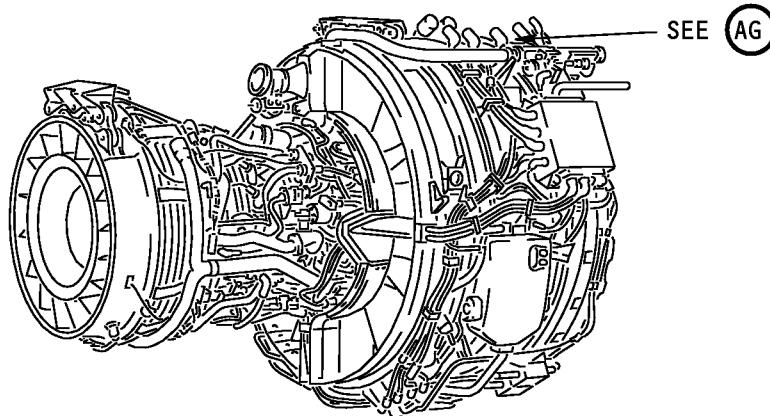
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P/P BUILDUP FIGURE 28-1

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POWERPLANT BUILDUP MANUAL

NOTE: SOME COMPONENTS NOT
SHOWN FOR CLARITY.

AG

FWD

Fire/Overheat Detector Installation
Figure 28-1 (Sheet 19)

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P/P BUILDUP FIGURE 28-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
28-1		<p>FIRE/OVERHEAT DETECTOR INSTALLATION (FIGURE 28-1, SHEET 19)</p> <p>DO A RESISTANCE TEST OF LOOP A OF THE FIRE/OVERHEAT DETECTORS AS FOLLOWS:</p> <ol style="list-style-type: none"> 1. ON THE TOP OF THE RIGHT FAN CASE, LOCATE THE CONNECTORS DP1552 (CFM). 2. CHECK THE RESISTANCE BETWEEN PIN 1 ON CONNECTOR DP1552 AND GROUND. 3. MAKE SURE THE RESISTANCE IS BETWEEN 822-902 OHMS. <p>DO A RESISTANCE TEST OF LOOP B OF THE FIRE/OVERHEAT DETECTORS AS FOLLOWS:</p> <ol style="list-style-type: none"> 1. ON THE TOP OF THE RIGHT FAN CASE, LOCATE THE CONNECTORS DP1620 (CFM). 2. CHECK THE RESISTANCE BETWEEN PIN 3 ON CONNECTOR DP1620 AND GROUND. 3. MAKE SURE THE RESISTANCE IS BETWEEN 822-902 OHMS. 		

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P/P BUILDUP FIGURE 28-1

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FIGURE 29-1

W1062 WIRE BUNDLE INSTALLATION

REF QEC TASK NO.: 29

REF DWG: 332A2200

NOTE: ALL STANDARDS AND ATTACHING HARDWARE FOR THIS FIGURE WILL BE PACKAGED IN QEC TASK NO. 110.

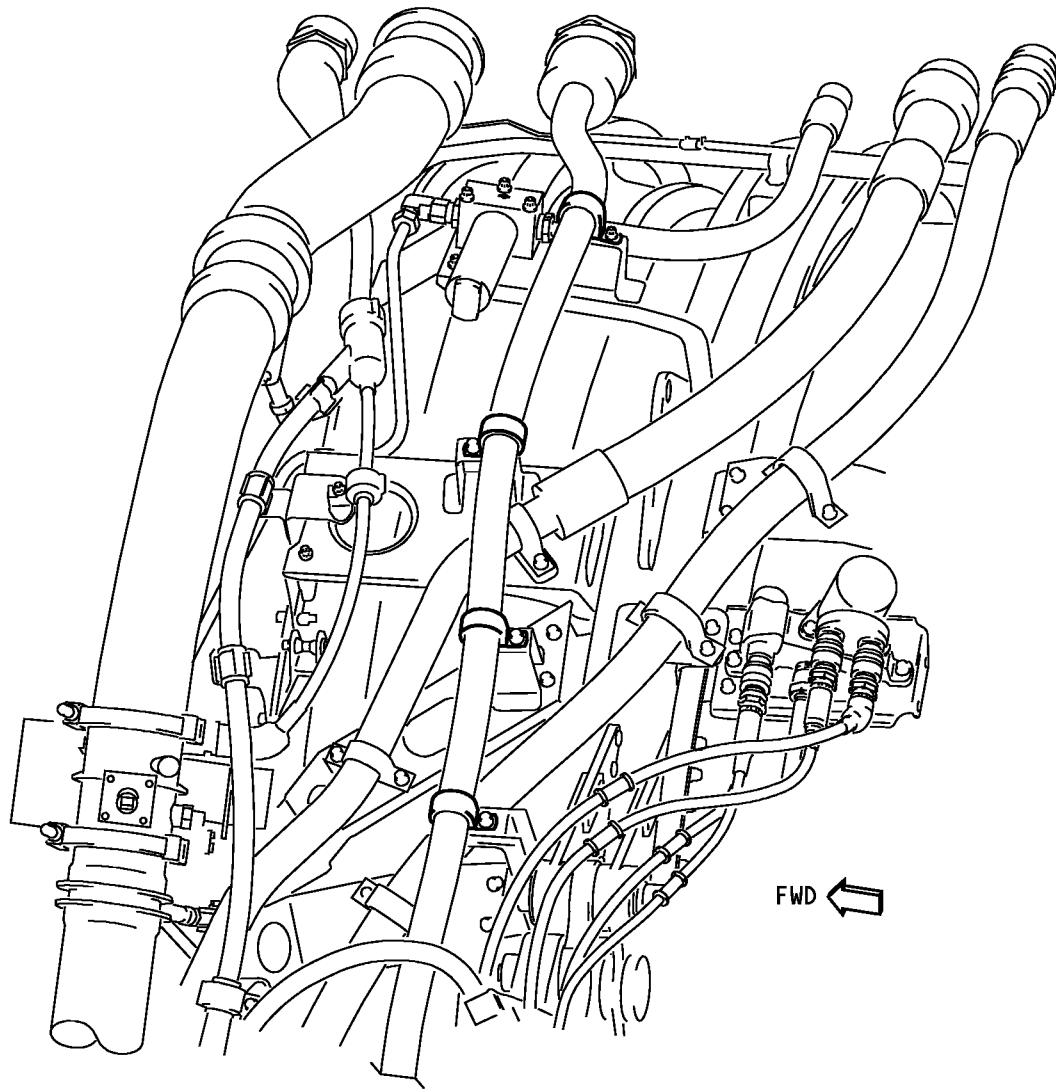
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P/P BUILDUP FIGURE 29-1

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737-600/700/800/900
POWERPLANT BUILDUP MANUAL

EXAMPLE OF WIRE BUNDLE INSTALLATION

- ◇ DIAMOND WITH NUMBER INDICATES A CONTINUATION TO A DIAMOND WITH THE SAME NUMBER IN ANOTHER SHEET OR ILLUSTRATION.

W1062 Wire Bundle Installation
Figure 29-1 (Sheet 1)

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P/P BUILDUP FIGURE 29-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
29-1		<p>W1062 WIRE BUNDLE INSTALLATION (FIGURE 29-1, SHEET 1)</p> <p>NOTE: THIS SHEET IS PROVIDED FOR INFORMATION PURPOSES ONLY.</p> <p>REVIEW ELECTRICAL HARNESS STANDARD PRACTICES (INTRODUCTION) BEFORE BEGINNING PROCEDURE.</p> <p>SYMBOLS TO AID IN THE USE OF THESE ILLUSTRATIONS ARE SHOWN ON THE PRECEDING PAGE.</p>		

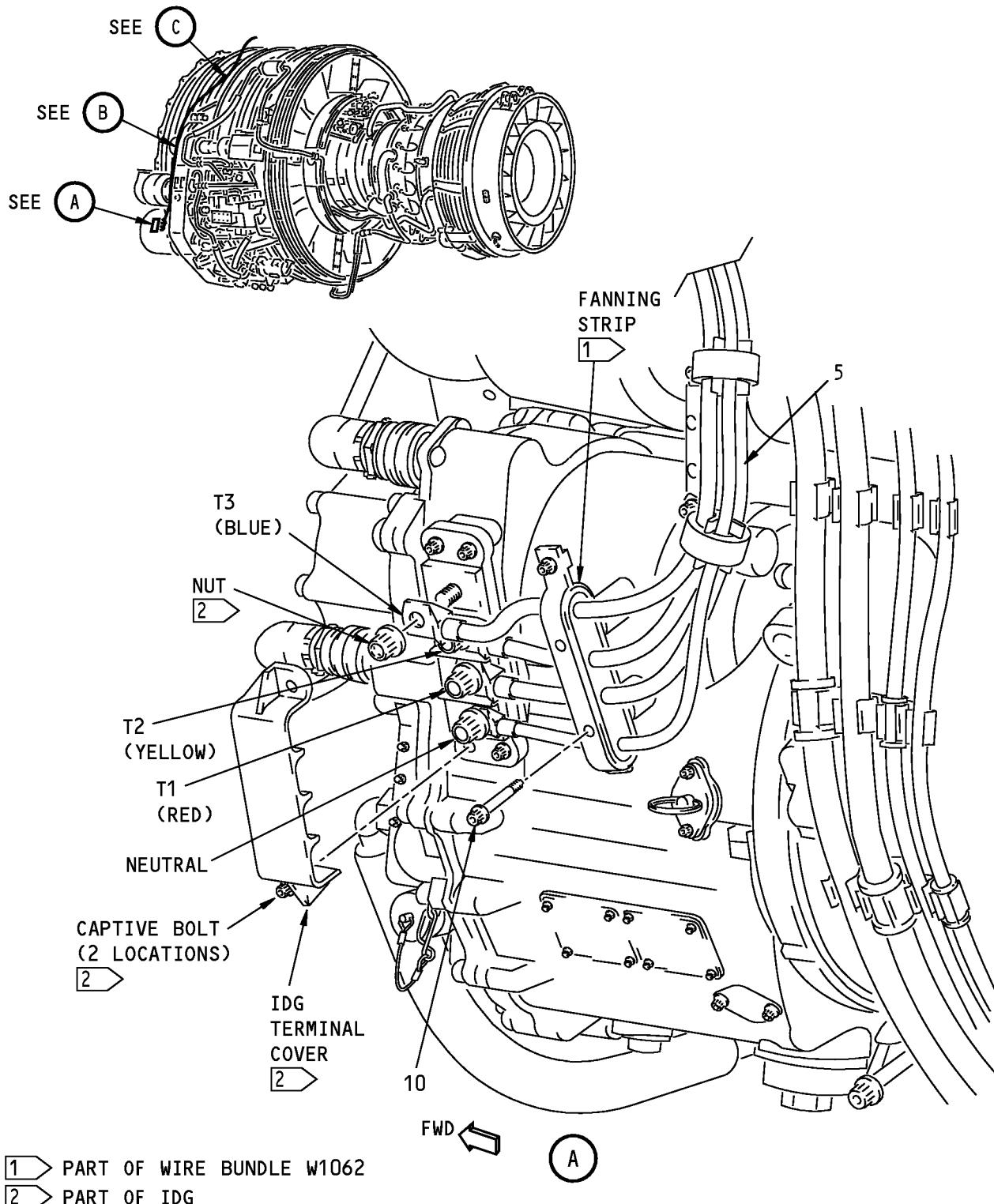
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P/P BUILDUP FIGURE 29-1

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POWERPLANT BUILDUP MANUALW1062 Wire Bundle Installation
Figure 29-1 (Sheet 2)

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P/P BUILDUP FIGURE 29-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
29-1 5	286A1062-002	<p>W1062 WIRE BUNDLE INSTALLATION (FIGURE 29-1, SHEET 2)</p> <p>POSITION WIRE BUNDLE (5) ON LEFT SIDE OF FAN CASE WITH TERMINAL ENDS NEAR IDG STUDS.</p> <p>. WIRE BUNDLE ASSEMBLY (W1062)</p> <p>REMOVE AND RETAIN IDG TERMINAL COVER AND CAPTIVE VENDOR BOLTS.</p> <p>INSTALL W/B W1062 (5) WIRE LUGS TO IDG TERMINAL BLOCK USING VENDOR NUTS. HOLD LEADS TO PREVENT ROTATION AND TIGHTEN VENDOR NUTS TO 144-168 POUND-INCHES (16.3-19.0 NEWTON METERS).</p> <p>INSTALL IDG TERMINAL COVER USING CAPTIVE VENDOR BOLTS. TIGHTEN BOLTS TO 20-22 POUND-INCHES (2.3-2.5 NEWTON METERS).</p> <p>APPLY Never-Seez NSBT-8N compound, D00006 (C1) TO THREADS OF BOLTS (10). POSITION WIRE BUNDLE FANNING STRIP ON IDG AND SECURE WITH LUBRICATED BOLTS (10). TIGHTEN BOLTS (10) TO 48-53 POUND-INCHES (5.4-6.0) NEWTON METERS.</p> <p>. BOLT</p> <p>. NEVER-SEEZ NSBT-8N COMPOUND</p>		1
10 C1	BACB30ZF4-24 D00006		CON	2 AR

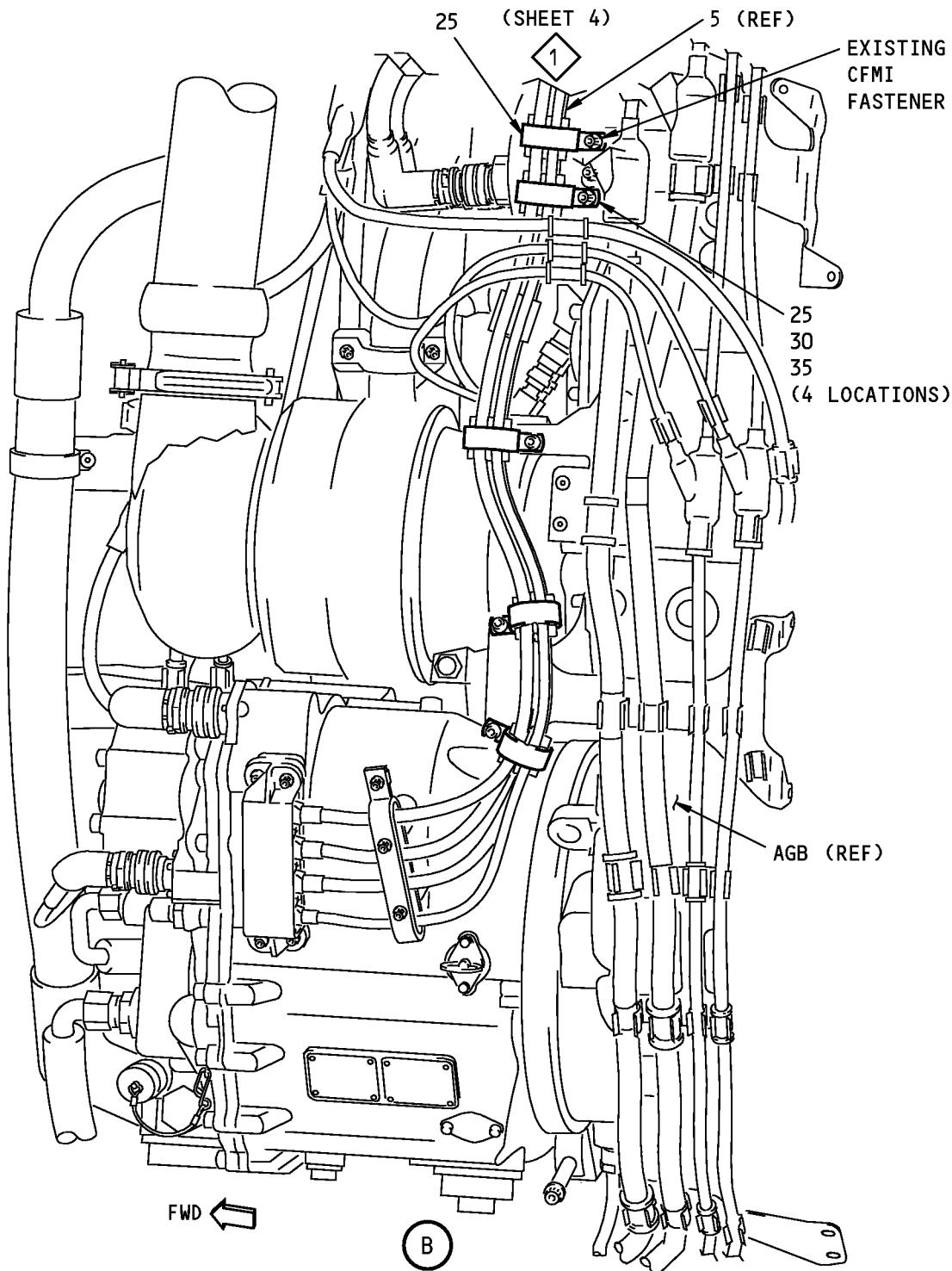
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P/P BUILDUP FIGURE 29-1

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POWERPLANT BUILDUP MANUALW1062 Wire Bundle Installation
Figure 29-1 (Sheet 3)

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
29-1		W1062 WIRE BUNDLE INSTALLATION (FIGURE 29-1, SHEET 3) AT FIVE LOCATIONS, CENTER CLAMPS (25) ON WIRE BUNDLE SPACERS AND LOOSELY ATTACH TO AGB BRACKETS USING BOLTS (30), NUTS (35) AND EXISTING CFMI FASTENER. NOTE: DO NOT TIGHTEN BOLTS AT THIS TIME.		
25	TA025146-15	. CLAMP (V84971)	VEN	5
30	BACB30ZF4-08	. BOLT		4
35	AS3485-10	. NUT		4

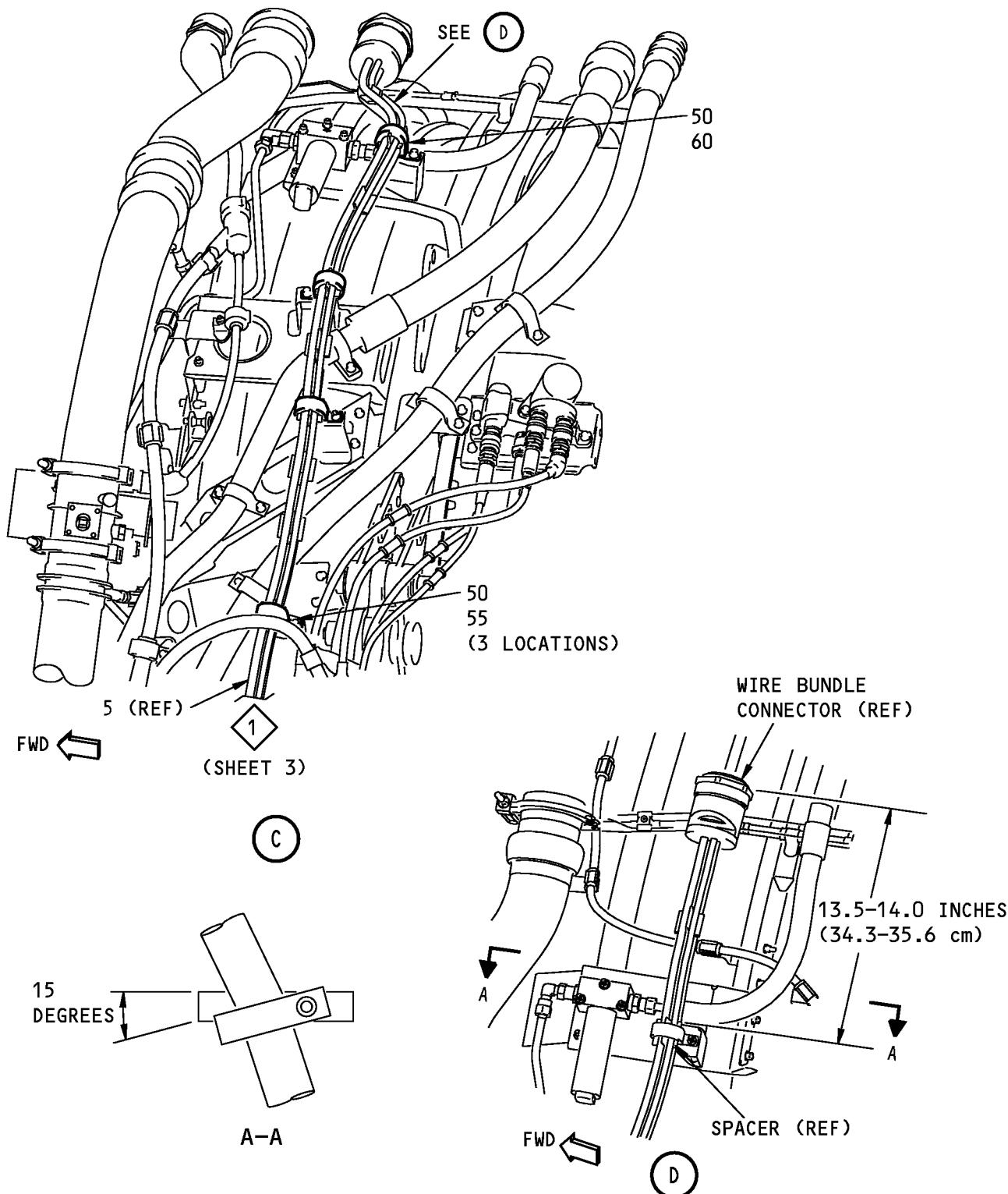
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P/P BUILDUP FIGURE 29-1

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POWERPLANT BUILDUP MANUALW1062 Wire Bundle Installation
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P/P BUILDUP FIGURE 29-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
29-1		W1062 WIRE BUNDLE INSTALLATION (FIGURE 29-1, SHEET 4) AT FOUR LOCATIONS, CENTER CLAMPS (50) ON WIRE BUNDLE SPACERS AND LOOSELY ATTACH TO BRACKETS ON LEFT FAN CASE USING BOLTS (55 AND 60). NOTE: DO NOT TIGHTEN BOLTS AT THIS TIME.		
50	TA025146-15	. CLAMP (V84971)	VEN	4
55	BACB30ZF4-06	. BOLT		3
60	BACB30ZF4-07	. BOLT		1
		MAKE SURE WIRE BUNDLE (5) SPACER IS CENTERED IN UPPER CLAMP (50) AND MAKE SURE TOP CLAMP IS ORIENTED AS SHOWN. TIGHTEN BOLTS (55 AND 60). MEASURE DISTANCE BETWEEN TOP OF WIRE BUNDLE CONNECTOR AND SPACER WITH WIRE BUNDLE STRAIGHT. MEASUREMENT MUST BE 13.5-14.0 INCHES (34.3-35.6 CENTIMETERS). REPOSITION SPACER AS NECESSARY. ADJUST WIRE BUNDLE TO BEST POSITION AND TIGHTEN BOLTS (30, 55 AND 60) TO 110-120 POUND-INCHES (12.4-13.6 NEWTON METERS). TIGHTEN EXISTING CFMI FASTENER TO 98-110 POUND-INCHES (11.1-12.4 NEWTON METERS).		

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P/P BUILDUP FIGURE 29-1

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FIGURE 30-1

MARKERS INSTALLATION

REF QEC TASK NO.: 30

**REF DWG: 330A2010
330A2011**

NOTE: ALL STANDARDS AND ATTACHING HARDWARE FOR THIS FIGURE WILL BE PACKAGED
IN QEC TASK NO. 110.

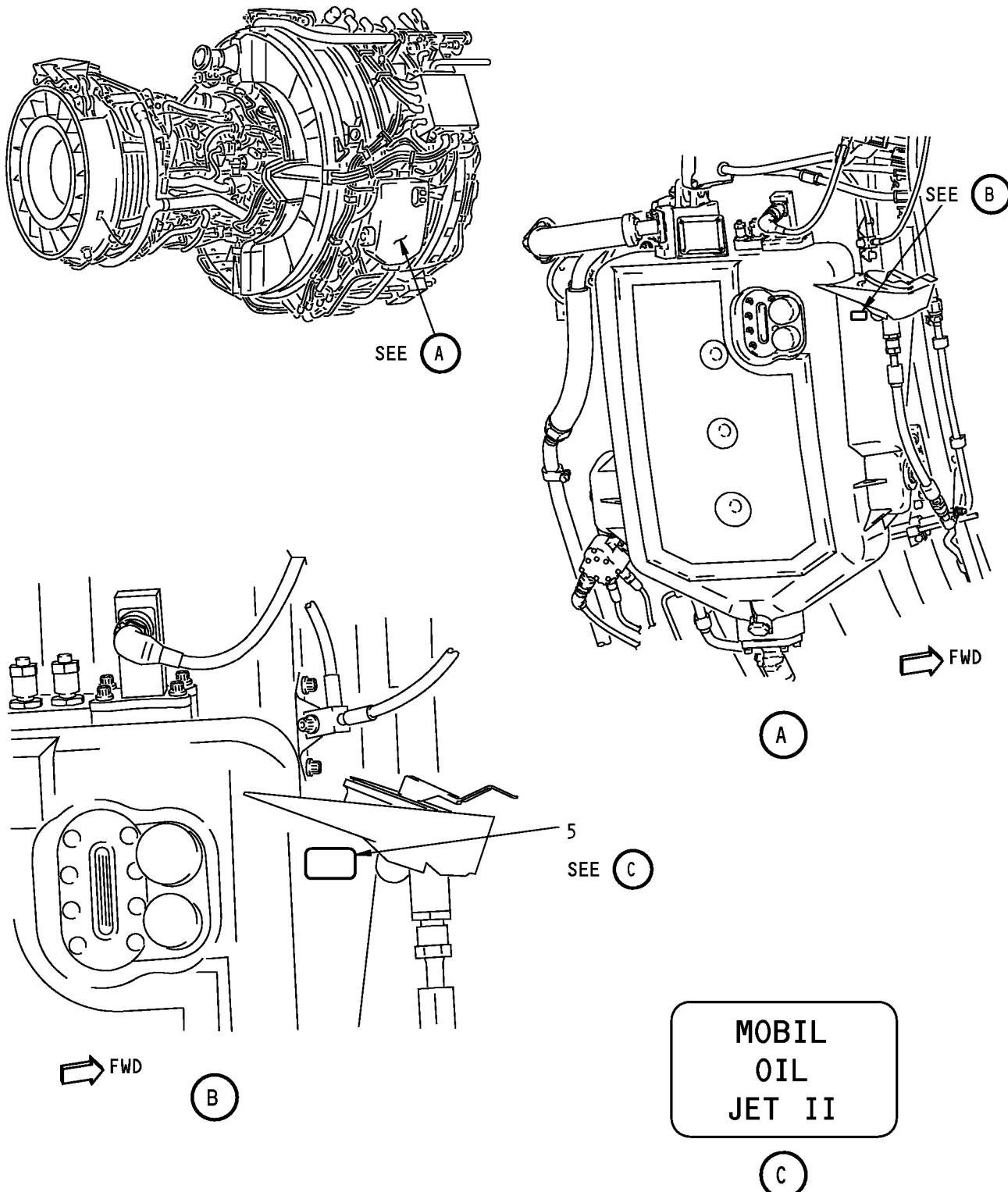
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P/P BUILDUP FIGURE 30-1

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737-600/700/800/900
POWERPLANT BUILDUP MANUALMarkers Installation
Figure 30-1 (Sheet 1)

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P/P BUILDUP FIGURE 30-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
30-1		MARKERS INSTALLATION (FIGURE 30-1, SHEET 1) CAUTION: APPROPRIATE OIL USAGE MARKERS MUST BE INSTALLED TO IDENTIFY THE BRAND USED BY OPERATOR. MIXING OF OIL BRANDS MAY CAUSE DAMAGE TO ENGINE AND ACCESSORIES AND VOID WARRANTIES. CLEAN DESIGNATED SURFACE WITH solvent, B00083 (C1) AND WIPE DRY PRIOR TO MARKER INSTALLATION. . SOLVENT INSTALL MARKER (5) ON OIL TANK SCUPPER DRAIN. . ALUMINUM FOIL MARKER		
C1	B00083		CON	AR
5	BACM10L1EBZ			1

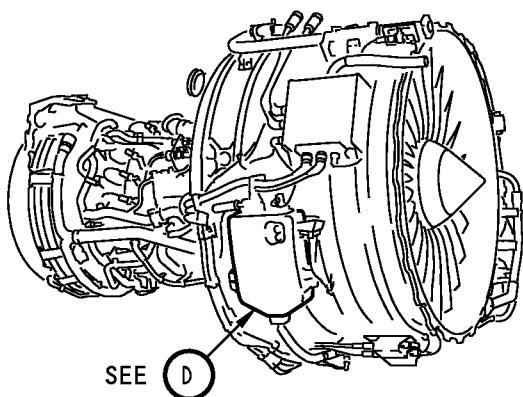
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P/P BUILDUP FIGURE 30-1

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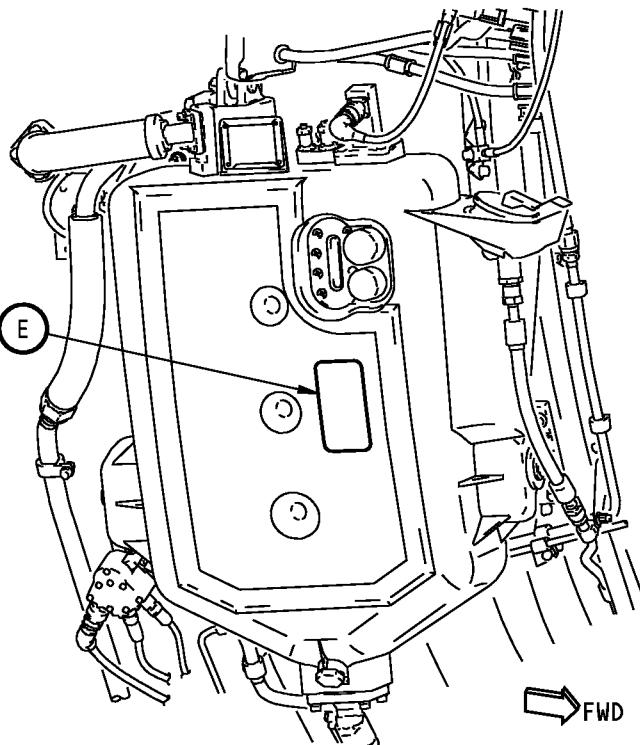
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737-600/700/800/900
POWERPLANT BUILDUP MANUAL

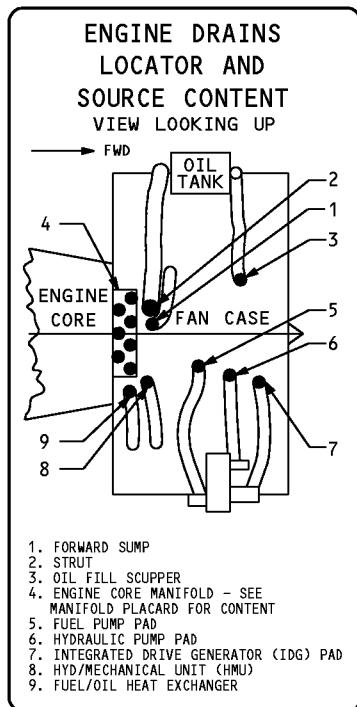
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**Markers Installation
Figure 30-1 (Sheet 2)**
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P/P BUILDUP FIGURE 30-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
30-1		MARKERS INSTALLATION (FIGURE 30-1, SHEET 2)		
C1	B00083	CLEAN DESIGNATED SURFACE WITH solvent, B00083 (C1) AND WIPE DRY PRIOR TO MARKER INSTALLATION. . SOLVENT INSTALL MARKER (15) ON OIL TANK BELOW OIL LEVEL SIGHT GLASS.	CON	AR
15	BAC27DPP470	. ALUMINUM FOIL MARKER, DRAIN LOCATOR		1

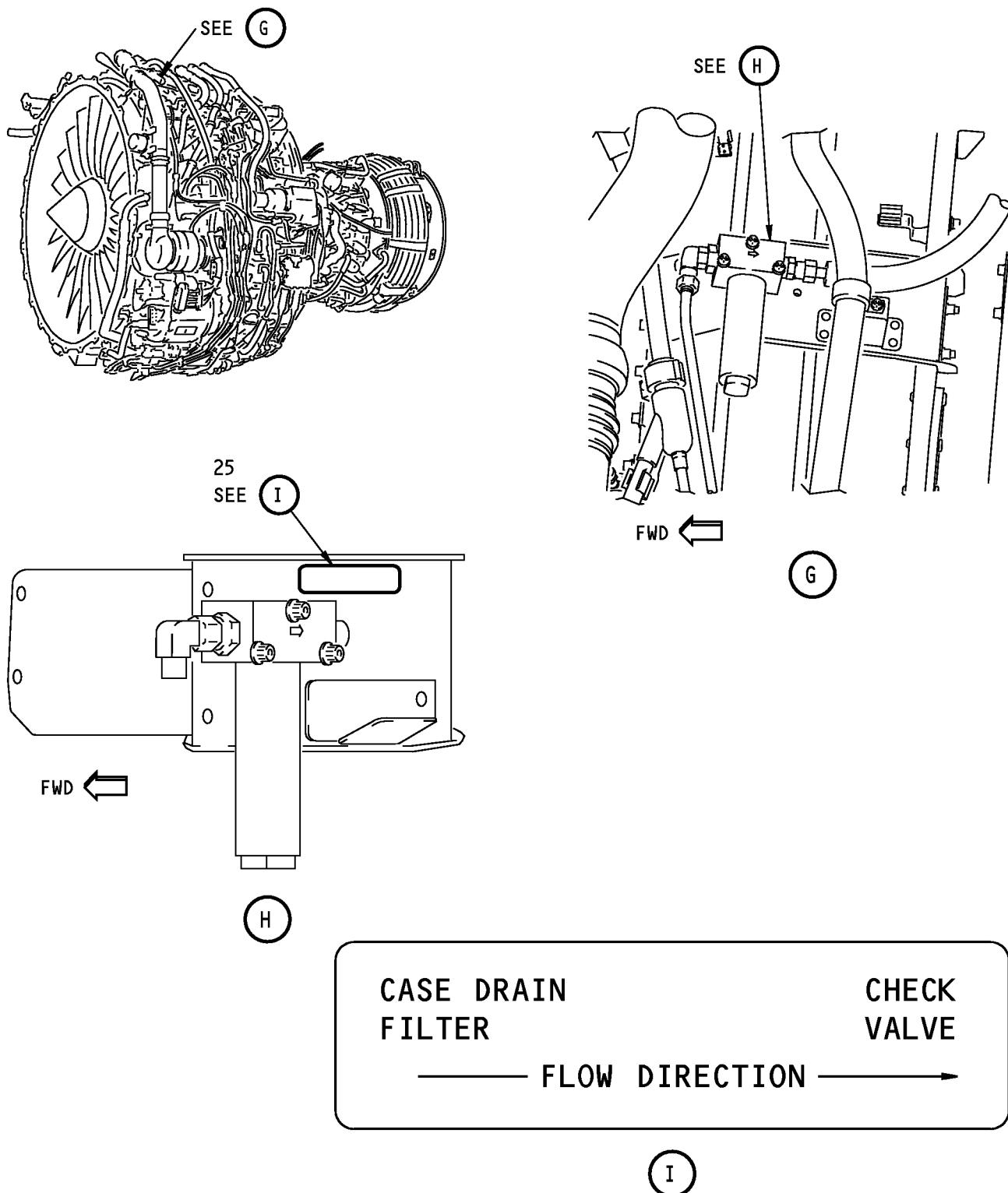
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P/P BUILDUP FIGURE 30-1

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POWERPLANT BUILDUP MANUAL

Markers Installation
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P/P BUILDUP FIGURE 30-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
30-1		MARKERS INSTALLATION (FIGURE 30-1, SHEET 3)		
C1	B00083	CLEAN DESIGNATED SURFACE WITH solvent, B00083 (C1) AND WIPE DRY PRIOR TO MARKER INSTALLATION. . SOLVENT INSTALL MARKER (25) ON BRACKET ABOVE HYDRAULIC CASE DRAIN FILTER.	CON	AR
25	BAC27DHY0337	. ALUMINUM FOIL MARKER, CASE DRAIN FILTER		1

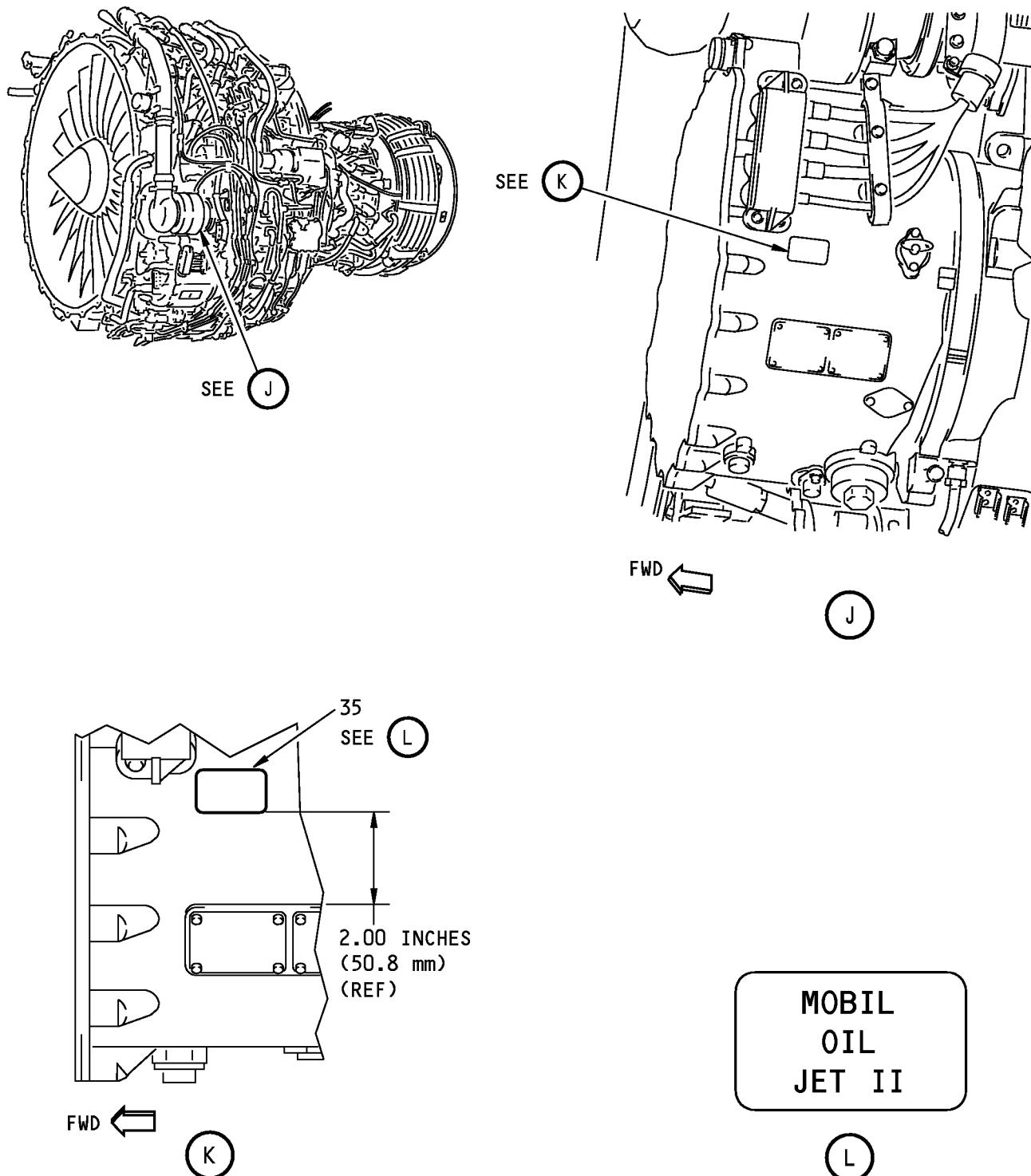
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P/P BUILDUP FIGURE 30-1

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POWERPLANT BUILDUP MANUAL

G06611 S00041154015_V2

Markers Installation
Figure 30-1 (Sheet 4)

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P/P BUILDUP FIGURE 30-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
30-1		MARKERS INSTALLATION (FIGURE 30-1, SHEET 4) CAUTION: APPROPRIATE OIL USAGE MARKERS MUST BE INSTALLED TO IDENTIFY THE BRAND USED BY OPERATOR. MIXING OF OIL BRANDS MAY CAUSE DAMAGE TO ENGINE AND ACCESSORIES AND VOID WARRANTIES. CLEAN DESIGNATED SURFACE WITH solvent, B00083 (C1) AND WIPE DRY PRIOR TO MARKER INSTALLATION. <ul style="list-style-type: none"> . SOLVENT INSTALL MARKER (35) ON IDG. . ALUMINUM FOIL MARKER 		
C1	B00083		CON	AR
35	BACM10L1EBZ			1

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P/P BUILDUP FIGURE 30-1

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THIS SHEET NOT USED

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**Markers Installation
Figure 30-1 (Sheet 5)**

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P/P BUILDUP FIGURE 30-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
30-1		MARKERS INSTALLATION (FIGURE 30-1, SHEET 5) THIS SHEET NOT USED		

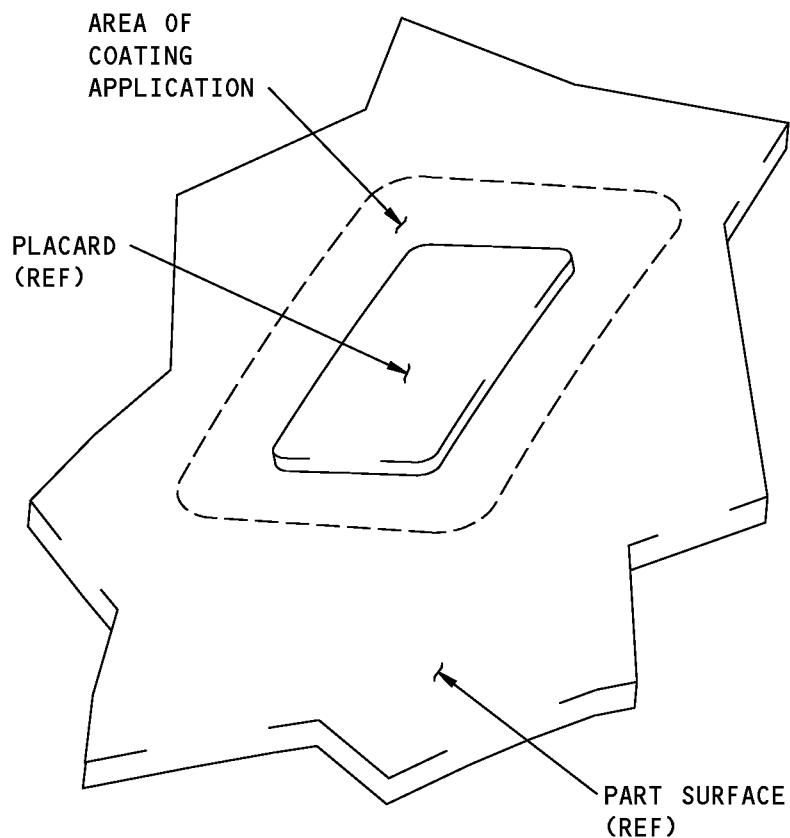
71-00-02

P/P BUILDUP FIGURE 30-1

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POWERPLANT BUILDUP MANUAL

Markers Installation
Figure 30-1 (Sheet 6)

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P/P BUILDUP FIGURE 30-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
30-1 C1	B00083	<p>MARKERS INSTALLATION (FIGURE 30-1, SHEET 6)</p> <p>CLEAN MARKERS (5), (15), (25) AND (35) AND ADJACENT SURFACE WITH solvent, B00083 (C1).</p> <p>. SOLVENT</p> <p>MIX THE COATING AS FOLLOWS:</p> <ol style="list-style-type: none"> 1. MIX 2 PARTS BASE 683-3-20 WITH 1 PART CATALYST X-310A. <p>NOTE: POT LIFE IS 30 MINUTES AT 70°F.</p> <ol style="list-style-type: none"> 2. APPLY coating, B00571 (C2) TO EDGE OF MARKERS WITH BRUSH TO A DEPTH OF 0.001-0.002 INCHES (0.025-0.051 MM). 3. LET THE COATING AIR DRY FOR 30 MINUTES. <p>NOTE: MINIMUM CURE BEFORE OUTDOOR EXPOSURE IS 30 MINUTES. FULL CURE IS 14 DAYS.</p>	CON	AR
C2	B00571 683-3-20 X-310A	<p>. COATING</p> <p>. BASE (PART OF B00571)</p> <p>. CATALYST (PART OF B00571)</p>	CON REF REF	AR - -

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P/P BUILDUP FIGURE 30-1

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FIGURE 31-1

THRUST LINK INSTALLATION

REF QEC TASK NO.: 31

**REF DWG: 310A2040
301A2092**

NOTE: ALL STANDARDS AND ATTACHING HARDWARE FOR THIS FIGURE WILL BE PACKAGED
IN QEC TASK NO. 110.

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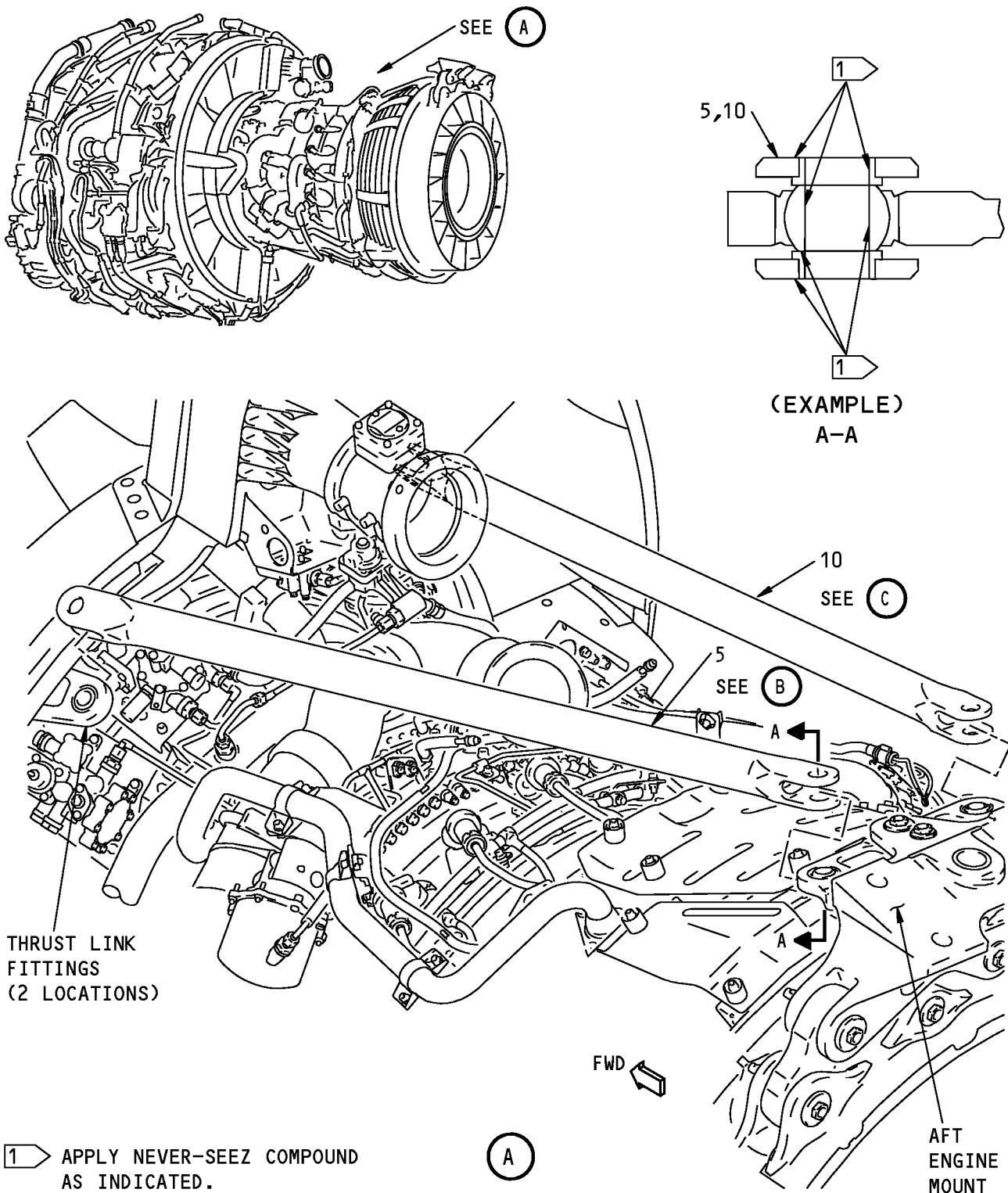
P/P BUILDUP FIGURE 31-1

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Thrust Link Installation Figure 31-1 (Sheet 1)

1 ➤ APPLY NEVER-SEEZ COMPOUND AS INDICATED.

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P/P BUILDUP FIGURE 31-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
31-1		THRUST LINK INSTALLATION (FIGURE 31-1, SHEET 1) APPLY Never-Seez NSBT-8N compound, D00006 (C1) TO SPHERICAL BEARING BORES AND BALL FLAT SURFACES OF THRUST LINK FITTINGS ON ENGINE FAN FRAME AND AFT ENGINE MOUNT ATTACH POINTS. APPLY Never-Seez NSBT-8N compound, D00006 (C1) TO BUSHING BORES AND FLANGE FACES AT EACH END OF TWO THRUST LINKS (5) AND (10). . THRUST LINK ASSY, LEFT . THRUST LINK ASSY, RIGHT . NEVER-SEEZ NSBT-8N COMPOUND		
5	310A2041-9			1
10	310A2041-10			1
C1	D00006		CON	AR

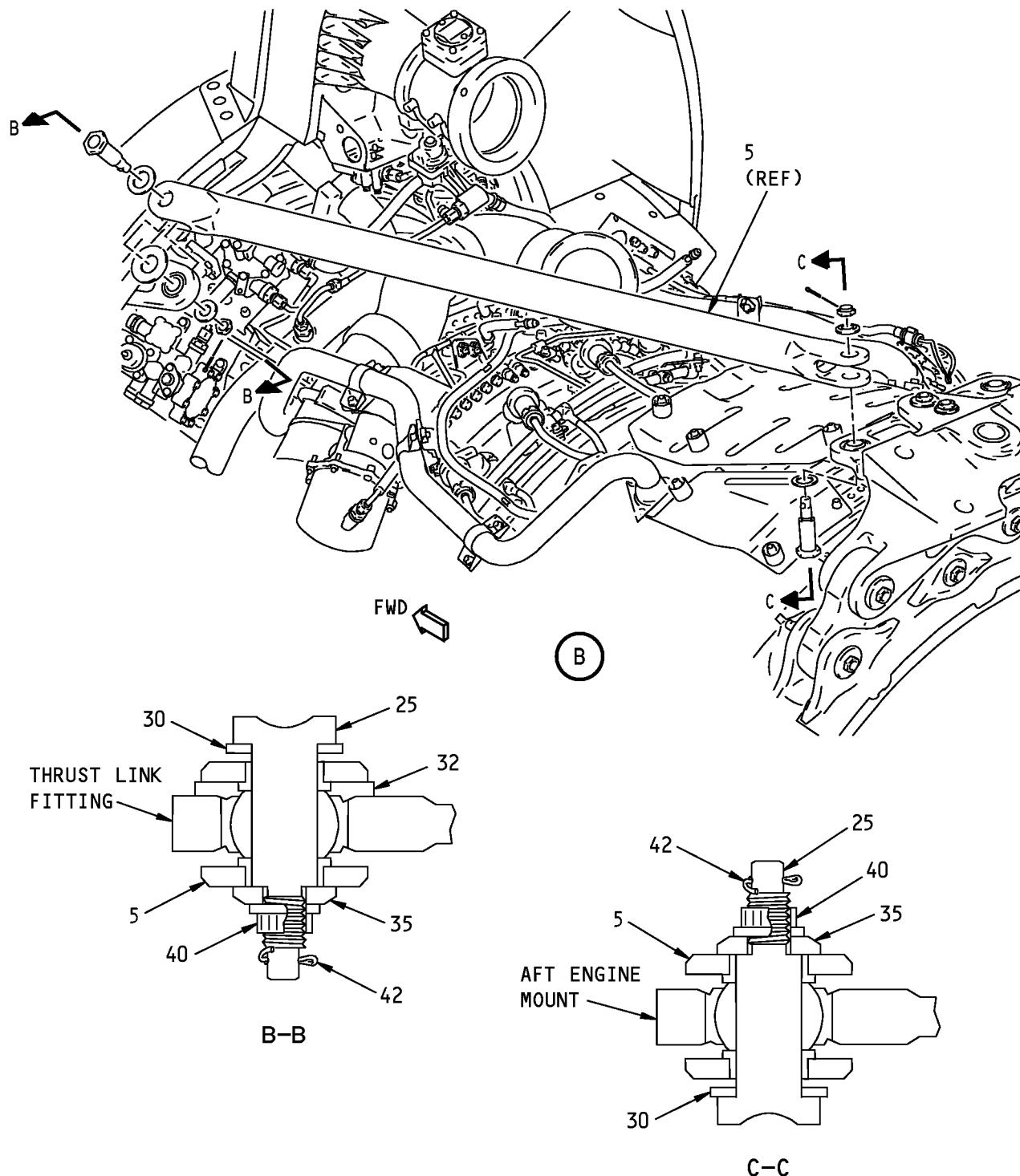
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P/P BUILDUP FIGURE 31-1

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737-600/700/800/900
POWERPLANT BUILDUP MANUALThrust Link Installation
Figure 31-1 (Sheet 2)

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P/P BUILDUP FIGURE 31-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
31-1		THRUST LINK INSTALLATION (FIGURE 31-1, SHEET 2)		
25 C1	310A2042-3 D00006	APPLY Never-Seez NSBT-8N compound, D00006 (C1) TO THREADS, SHANK AND UNDERNEATH HEAD OF PINS (25). . THRUST LINK PIN . NEVER-SEEZ NSBT-8N COMPOUND	CON	2 AR
30	BACW10BP12ACU	INSTALL LEFT THRUST LINK ASSY (5) BETWEEN FAN CASE FITTING AND AFT ENGINE MOUNT ATTACH FITTINGS. USE LUBRICATED THRUST LINK PINS (25), WASHERS (30), WASHER (32), END CAPS (35) AND NUTS (40).		2
32	310A2040-7	. WASHER (CSK)		1
35	310A2043-2	. WASHER (CSK TOWARDS SPHERICAL BEARING)		2
40	BACN10JC8CM	. END CAP (FLAT SIDE TOWARDS PIN SHOULDER) . NUT		2
		TIGHTEN NUTS (40) TO 290-510 POUND-INCHES (32.8-57.6 NEWTON METERS). APPLY TORQUE TO EITHER NUT OR PIN HEAD.		
42	BACP18BC03B06P	INSTALL COTTER PINS (42).		2
42	BACP18BC03B07P	. COTTER PIN	OPT	-
42	BACP18BC03B08P	. COTTER PIN (OPTIONAL TO BACP18BC03B06P) . COTTER PIN (OPTIONAL TO BACP18BC03B06P)	OPT	-

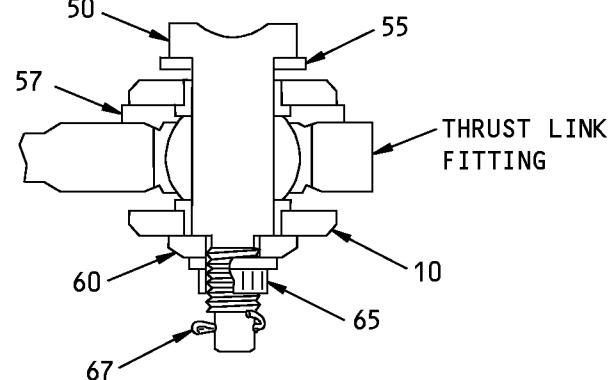
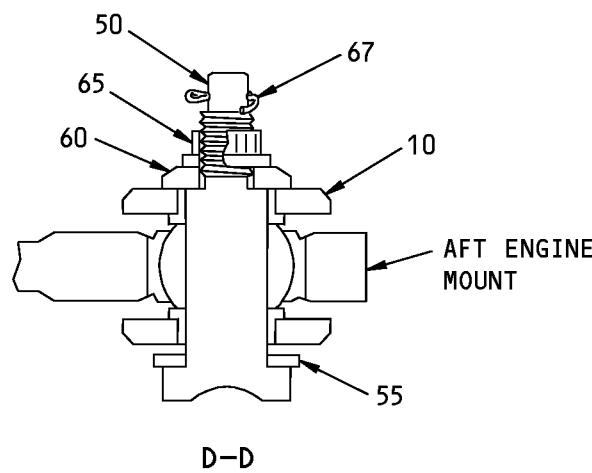
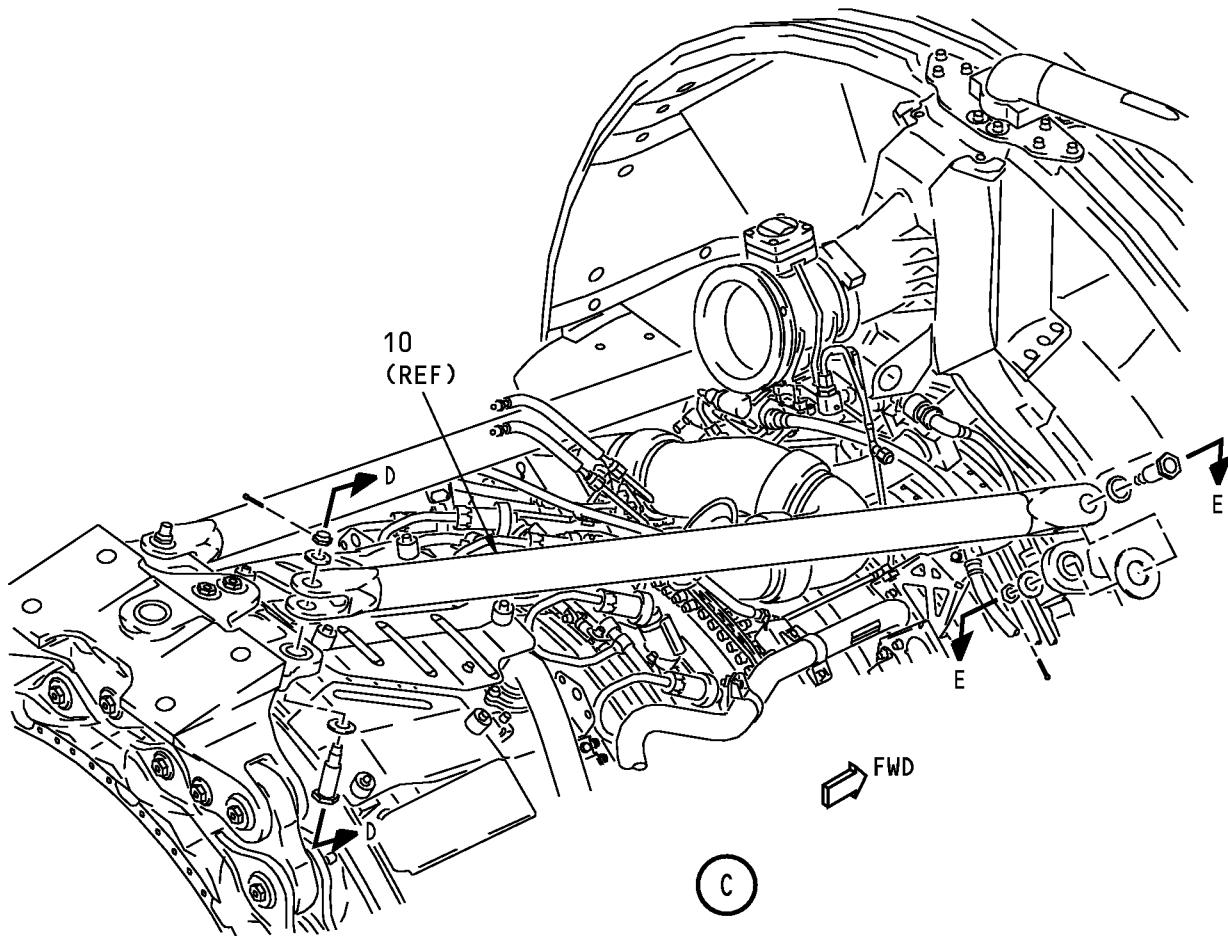
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P/P BUILDUP FIGURE 31-1

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POWERPLANT BUILDUP MANUAL

Thrust Link Installation
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P/P BUILDUP FIGURE 31-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
31-1		THRUST LINK INSTALLATION (FIGURE 31-1, SHEET 3)		
50		APPLY Never-Seez NSBT-8N compound, D00006 (C1) TO THREADS, SHANK AND UNDERNEATH HEAD OF PINS (50).		
C1	310A2042-3 D00006	. THRUST LINK PIN . NEVER-SEEZ NSBT-8N COMPOUND	CON	2 AR
55	BACW10BP12ACU	INSTALL RIGHT THRUST LINK ASSY (10) BETWEEN FAN CASE FITTING AND AFT ENGINE MOUNT ATTACH FITTINGS. USE LUBRICATED PINS (50), WASHERS (55), WASHER (57), END CAPS (60) AND NUTS (65).		2
57	310A2040-7	. WASHER (CSK)		1
60	310A2043-2	. WASHER (CSK TOWARDS SPHERICAL BEARING)		2
65	BACN10JC8CM	. END CAP (FLAT SIDE TOWARDS PIN SHOULDER) . NUT		2
		TIGHTEN NUTS (65) TO 290-510 POUND-INCHES (32.8-57.6 NEWTON METERS). APPLY TORQUE TO EITHER NUT OR PIN HEAD.		
67	BACP18BC03B06P	INSTALL COTTER PINS (67).		2
67	BACP18BC03B07P	. COTTER PIN	OPT	-
67	BACP18BC03B08P	. COTTER PIN (OPTIONAL TO BACP18BC03B06P) . COTTER PIN (OPTIONAL TO BACP18BC03B06P)	OPT	-
		REMOVE PROTECTIVE PAD FROM AFT ENGINE MOUNT (INSTALLED IN AFT ENGINE MOUNT INSTALLATION/Figure 3-1).		

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P/P BUILDUP FIGURE 31-1

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FIGURE 32-2

PRIMARY EXHAUST INSTALLATION

REF QEC TASK NO.: 32

REF DWG: 333A2100

NOTE: ALL STANDARDS AND ATTACHING HARDWARE FOR THIS FIGURE WILL BE PACKAGED IN QEC TASK NO. 110.

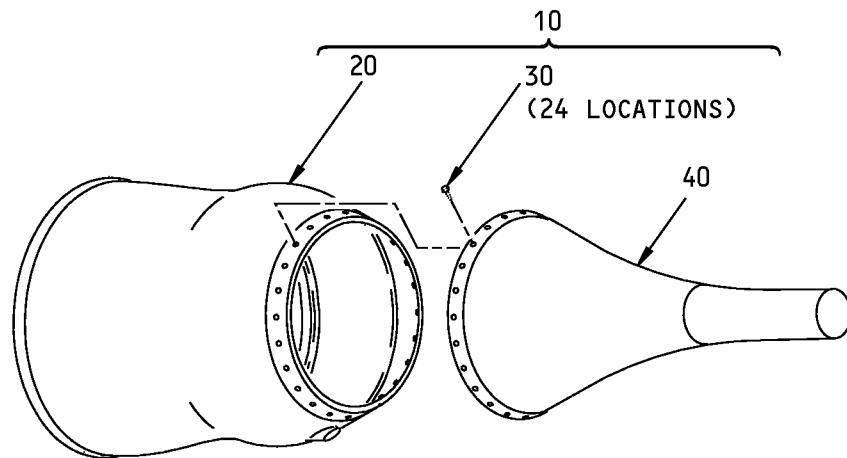
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P/P BUILDUP FIGURE 32-2

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POWERPLANT BUILDUP MANUAL

2053317 S0000417326_V1

Primary Exhaust Installation
Figure 32-2 (Sheet 1)**71-00-02**

P/P BUILDUP FIGURE 32-2

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
32-2		<p>PRIMARY EXHAUST INSTALLATION (FIGURE 32-2, SHEET 1)</p> <p>CAUTION: MAKE SURE THAT THE CONFIGURATION OF THE PRIMARY EXHAUST NOZZLE/PLUG IS CORRECT FOR THE STRUT. AN INCORRECT CONFIGURATION CAN CAUSE DAMAGE TO EQUIPMENT.</p> <p>NOTE: THE FWD PLUG AND AFT PLUG ARE A MATCHED SET AND MUST BE MAINTAINED TOGETHER.</p> <p>LOCATE THE PRIMARY PLUG ASSY (10) CONSISTING OF FWD (20) AND AFT (40) PLUG ASSYS AND BOLTS (30).</p>		
10	314A2640-100	. PRIMARY PLUG ASSY	REF	1
20	314A2640-34	. . FWD PLUG ASSY (PART OF 314A2640-100) (QTY 1)	REF	-
30	BACB30LT4U2	. . BOLT (PART OF 314A2640-100) (QTY 24)	REF	-
40	314A2640-17	. . AFT PLUG ASSY (PART OF 314A2640-100) (QTY 1)	REF	-

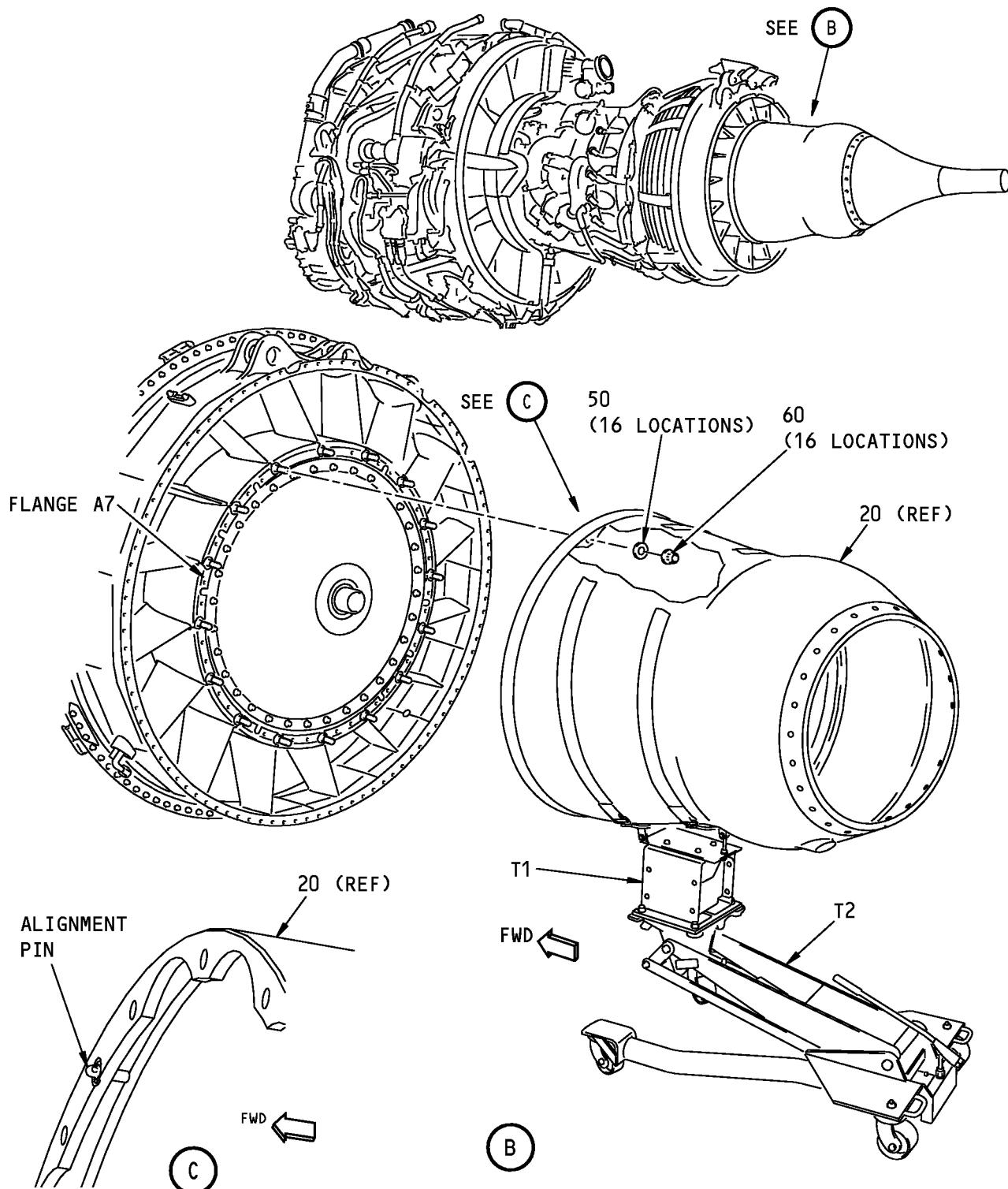
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P/P BUILDUP FIGURE 32-2

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Primary Exhaust Installation
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P/P BUILDUP FIGURE 32-2

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
32-2		<p>PRIMARY EXHAUST INSTALLATION (FIGURE 32-2, SHEET 2)</p> <p>WARNING: BE CAREFUL WHEN YOU MOVE THE COMPONENT. THE COMPONENT IS HEAVY. INJURIES TO PERSONS CAN OCCUR.</p> <p>ATTACH FWD PLUG ASSY (20) WHICH WEIGHS APPROXIMATELY 65 POUNDS (29 KG) TO equipment, SPL-2419 (T1) AND ATTACH TO low profile hydraulic jack, COM-1568 (T2).</p>		
20	314A2640-34	. . FWD PLUG ASSY (PART OF 314A2640-100) (QTY 1)	REF	-
T1	C78009	. EQUIPMENT, SPL-2419	TOL	-
T2	HW93718	. LOW PROFILE HYDRAULIC JACK, COM-1568 (OR EQUIVALENT)	TOL	-
C1	D00006	<p>APPLY Never-Seez NSBT-8N compound, D00006 (C1) TO THREADS OF STUDS ON ENGINE FLANGE A7.</p> <p>. NEVER-SEEZ NSBT-8N COMPOUND</p> <p>POSITION FWD PLUG ASSY (20) BEHIND ENGINE. RAISE WITH low profile hydraulic jack, COM-1568 (T2) UNTIL CENTERLINE IS ALIGNED WITH ENGINE CENTERLINE.</p> <p>MOVE FWD PLUG ASSY (20) FORWARD UNTIL BOLT HOLES ARE ALIGNED WITH ENGINE FLANGE STUDS. ALSO MAKE SURE ALIGNMENT PIN ON FLANGE OF FWD PLUG ASSY IS ALIGNED WITH HOLE IN AFT ENGINE FLANGE. IF NECESSARY, MOVE FWD PLUG ASSY REARWARD AND READJUST ITS POSITION ON THE TOOL. MOVE FWD PLUG ASSY FORWARD UNTIL ALIGNMENT PIN ENGAGES HOLE IN ENGINE FLANGE.</p> <p>LOOSELY ATTACH FWD PLUG ASSY (20) TO FLANGE A7 WITH WASHERS (50) AND NUTS (60).</p> <p>. WASHER</p> <p>. NUT</p>	CON	AR
50	BACW10BP8APU			16
60	BACN10HR8C	<p>SNUG FIT NUTS (60) IN THE FOLLOWING SEQUENCE: 3:00 O'CLOCK, 9:00 O'CLOCK, 6:00 O'CLOCK AND 12:00 O'CLOCK POSITIONS. SNUG FIT REMAINING NUTS. TIGHTEN NUTS AT 3:00, 9:00, 6:00 AND 12:00 O'CLOCK POSITIONS TO THE FINAL TORQUE VALUE NOTED BELOW. SEQUENTIALLY TIGHTEN THE REMAINING NUTS. CHECK TORQUE AT FIRST NUT TORQUED. IF NUT IS NOT WITHIN THE SPECIFIED RANGE, RE-TORQUE AND SEQUENTIALLY CHECK REMAINING NUTS. RE-TORQUE IF REQUIRED.</p> <p>REMOVE GROUND SUPPORT EQUIPMENT (T1 AND T2) FROM FORWARD PLUG ASSY (20).</p> <p>FINAL TORQUE VALUE FOR NUTS (60) IS 500-650 POUND-INCHES (56.5-73.4 NEWTON METERS).</p>		16

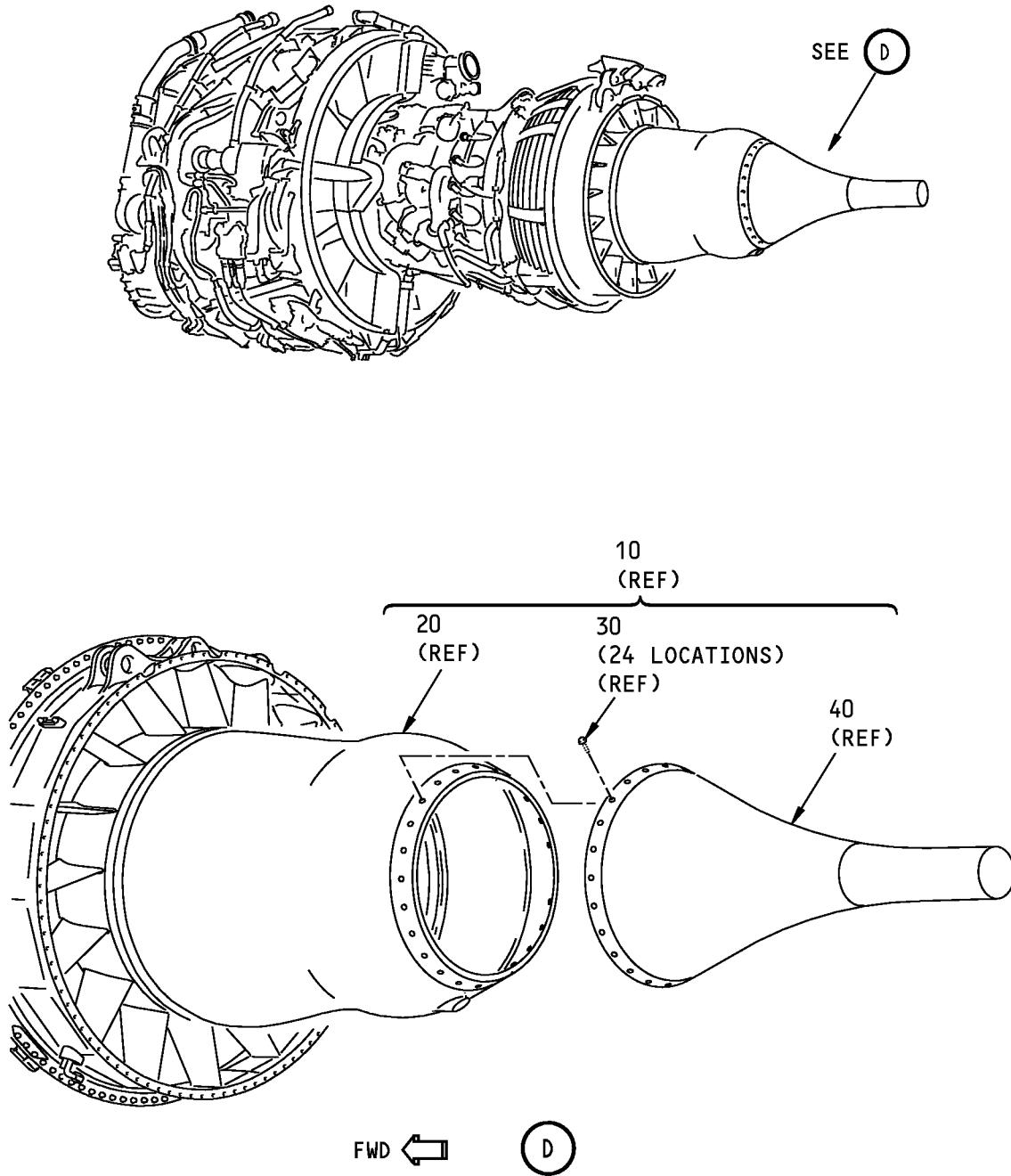
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P/P BUILDUP FIGURE 32-2

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POWERPLANT BUILDUP MANUAL

2053392 S0000417328_V1

Primary Exhaust Installation
Figure 32-2 (Sheet 3)**71-00-02**

P/P BUILDUP FIGURE 32-2

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
32-2		PRIMARY EXHAUST INSTALLATION (FIGURE 32-2, SHEET 3)		
30		APPLY Never-Seez NSBT-8N compound, D00006 (C1) TO THREADS OF BOLTS (30).		
C1	BACB30LT4U2 D00006	. . BOLT (PART OF 314A2640-100) (QTY 24) . NEVER-SEEZ NSBT-8N COMPOUND	REF CON	- AR
10	314A2640-100	POSITION AFT PLUG (40) WHICH WEIGHS APPROXIMATELY 12 POUNDS (5.4 KG) ON MATCHING FWD PLUG ASSY (20). AT 24 LOCATIONS, ATTACH WITH LUBRICATED BOLTS (30).	REF	-
20	314A2640-34	. PRIMARY PLUG ASSY (QTY 1)	REF	-
40	314A2640-17	. . FWD PLUG ASSY (PART OF 314A2640-100) (QTY 1) . . AFT PLUG (PART OF 314A2640-100) (QTY 1)	REF	-
		TIGHTEN BOLTS (30) TO 73-77 POUND-INCHES (8.2-8.7 NEWTON METERS).		

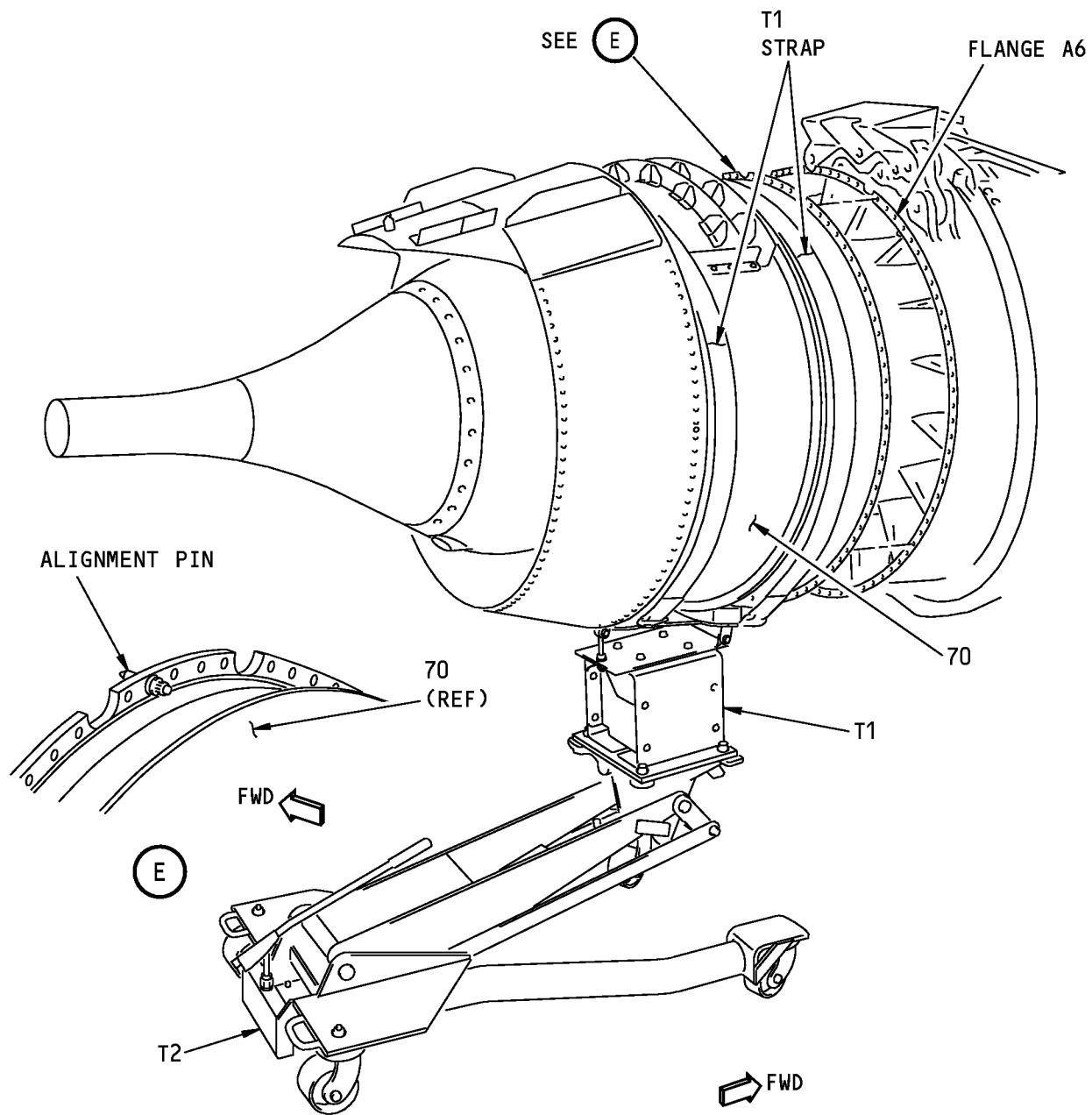
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P/P BUILDUP FIGURE 32-2

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POWERPLANT BUILDUP MANUAL

2053417 S0000417329_V2

Primary Exhaust Installation
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P/P BUILDUP FIGURE 32-2

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
32-2		<p>PRIMARY EXHAUST INSTALLATION (FIGURE 32-2, SHEET 4)</p> <p>WARNING: BE CAREFUL WHEN YOU MOVE THE COMPONENT. THE COMPONENT IS HEAVY. INJURIES TO PERSONS CAN OCCUR.</p> <p>ATTACH PRIMARY NOZZLE ASSY (70) WHICH WEIGHS APPROXIMATELY 107 POUNDS (48.5 KG) TO equipment, SPL-2419 (T1) AND ATTACH TO low profile hydraulic jack, COM-1568 (T2).</p> <p>CAUTION: MAKE SURE TO ATTACH THE STRAPS ALONG THE CONTINUOUS SURFACE OF THE NOZZLE ONLY. DO NOT ATTACH THE STRAPS ACROSS THE COMPONENTS ON TOP OF THE NOZZLE. DAMAGE TO THE NOZZLE CAN OCCUR.</p> <p>NOTE: IF THERE IS DAMAGE, THE NOZZLE IS CONSIDERED UNUSABLE AND MUST BE REPLACED.</p>		
70	314A2630-103	. PRIMARY NOZZLE ASSY		1
T1	C78009	. EQUIPMENT, SPL-2419	TOL	-
T2	HW93718	. LOW PROFILE HYDRAULIC JACK, COM-1568 (OR EQUIVALENT)	TOL	-
		<p>POSITION PRIMARY NOZZLE ASSY (70) BEHIND ENGINE. RAISE WITH low profile hydraulic jack, COM-1568 (T2) UNTIL CENTERLINE IS ALIGNED WITH ENGINE CENTERLINE.</p> <p>MOVE PRIMARY NOZZLE ASSY (70) FORWARD UNTIL NOZZLE IS APPROXIMATELY 2 INCHES (50.8 MM) AFT OF ENGINE FLANGE A6. MAKE SURE ALIGNMENT PIN ON FLANGE OF NOZZLE IS ALIGNED WITH HOLE IN AFT ENGINE FLANGE. IF NECESSARY, MOVE NOZZLE REARWARD AND READJUST POSITION OF NOZZLE ON TOOL. MOVE NOZZLE FORWARD UNTIL ALIGNMENT PIN ENGAGES HOLE IN ENGINE FLANGE.</p>		

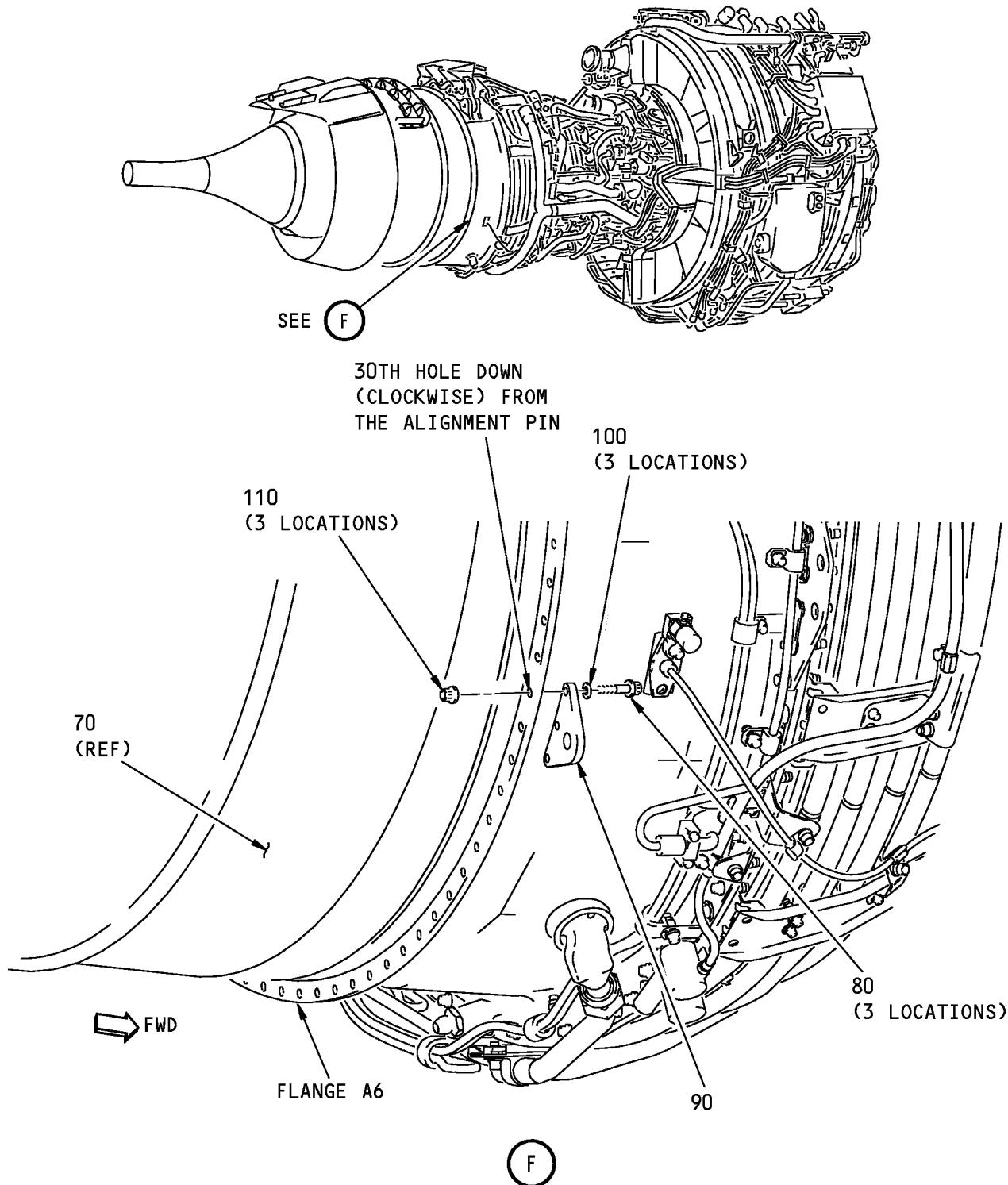
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P/P BUILDUP FIGURE 32-2

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POWERPLANT BUILDUP MANUAL

2053757 S0000417330_V2

Primary Exhaust Installation
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P/P BUILDUP FIGURE 32-2

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
32-2		PRIMARY EXHAUST INSTALLATION (FIGURE 32-2, SHEET 5) AT THE 30TH, 31ST AND 32ND HOLES DOWN (CLOCKWISE) FROM ALIGNMENT PIN, LOOSELY ATTACH GSE BRACKET (90) ON FWD SIDE OF FLANGE A6 WITH BOLTS (80), WASHERS (100) AND NUTS (110). NOTE: IF BOLTS (80) HAVE BEEN PREVIOUSLY INSTALLED, APPLY Never-Seez NSBT-8N compound, D00006 (C1) TO THREADS OF BOLTS (80) OR REPLACE NUTS (110).		
80	BACB30PN4-10	. BOLT		3
80	BACB30US4-10	. BOLT (OPTIONAL TO BACB30PN4-10)	OPT	-
90	333A2020-5	. GSE BRACKET		1
100	BACW10BP4ACU	. WASHER (CSK) (UNDER BOLT HEAD)		3
110	BACN10HR4C	. NUT		3
C1	D00006	. NEVER-SEEZ NSBT-8N COMPOUND	CON	AR
		NOTE: DO NOT TIGHTEN NUTS (110) OR BOLTS (80) AT THIS TIME.		

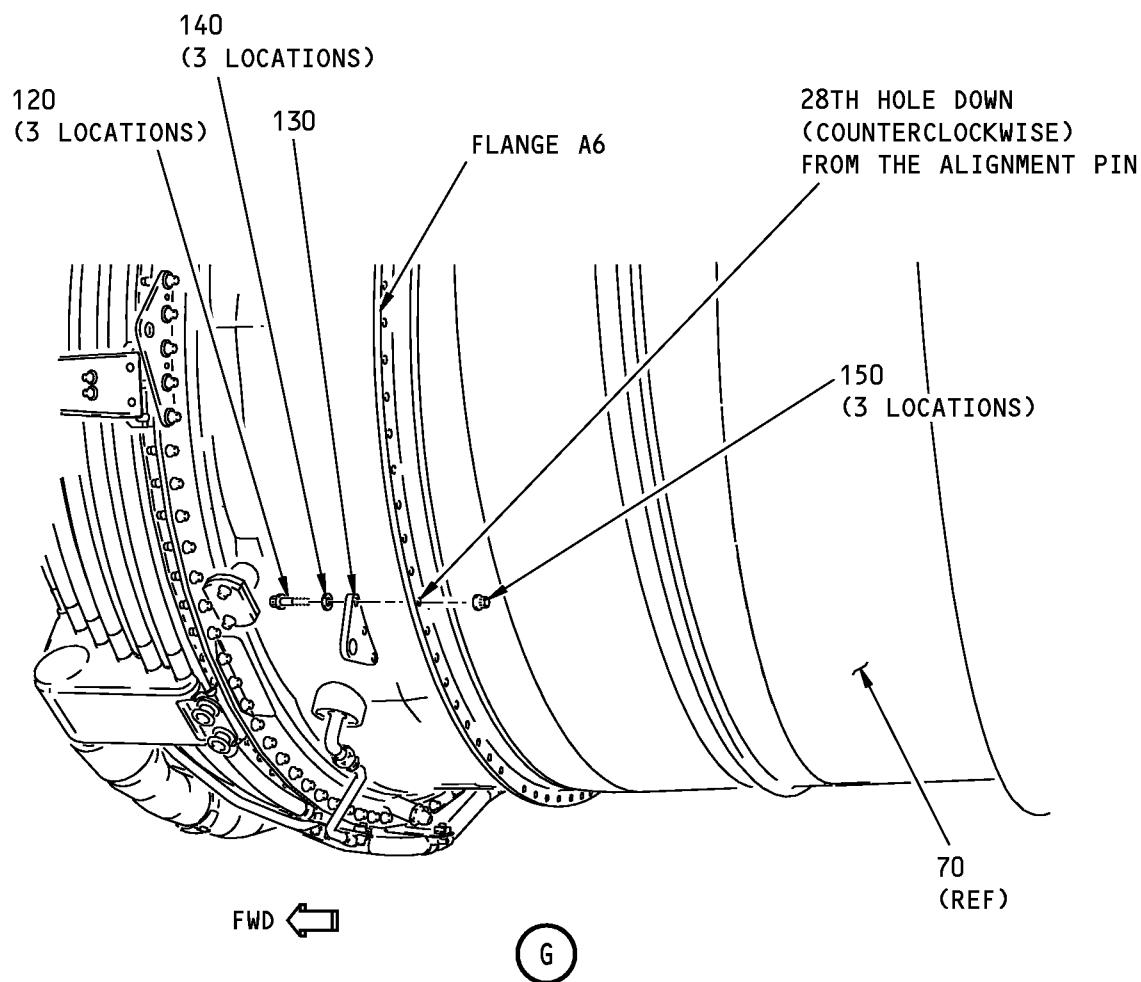
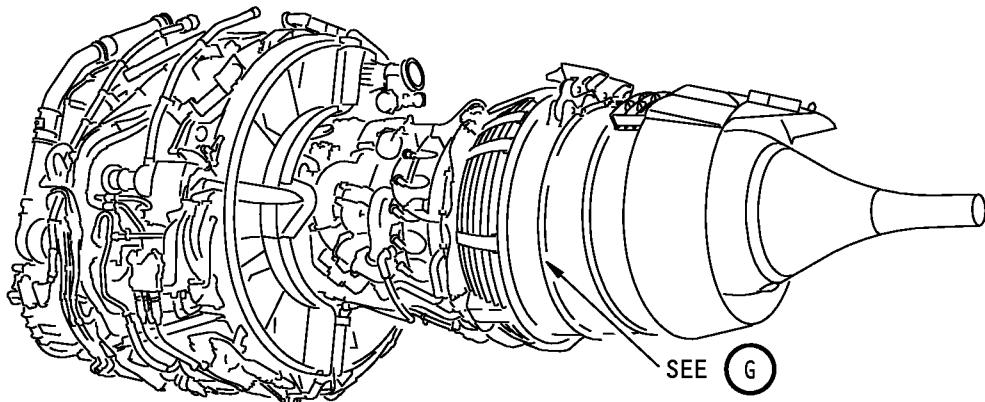
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P/P BUILDUP FIGURE 32-2

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POWERPLANT BUILDUP MANUAL

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Primary Exhaust Installation
Figure 32-2 (Sheet 6)

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P/P BUILDUP FIGURE 32-2

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
32-2		PRIMARY EXHAUST INSTALLATION (FIGURE 32-2, SHEET 6) AT THE 28TH, 29TH AND 30TH HOLES DOWN (COUNTERCLOCKWISE) FROM ALIGNMENT PIN, LOOSELY ATTACH GSE BRACKET (130) ON FWD SIDE OF FLANGE A6 WITH BOLTS (120), WASHERS (140) AND NUTS (150). NOTE: IF BOLTS (120) HAVE BEEN PREVIOUSLY INSTALLED, APPLY Never-Seez NSBT-8N compound, D00006 (C1) TO THREADS OF BOLTS (120) OR REPLACE NUTS (150).		
120	BACB30PN4-10	. BOLT		3
120	BACB30US4-10	. BOLT (OPTIONAL TO BACB30PN4-10)	OPT	-
130	333A2020-5	. GSE BRACKET		1
140	BACW10BP4ACU	. WASHER (CSK) (UNDER BOLT HEAD)		3
150	BACN10HR4C	. NUT		3
C1	D00006	. NEVER-SEEZ NSBT-8N COMPOUND	CON	AR
		NOTE: DO NOT TIGHTEN NUTS (150) OR BOLTS (120) AT THIS TIME.		

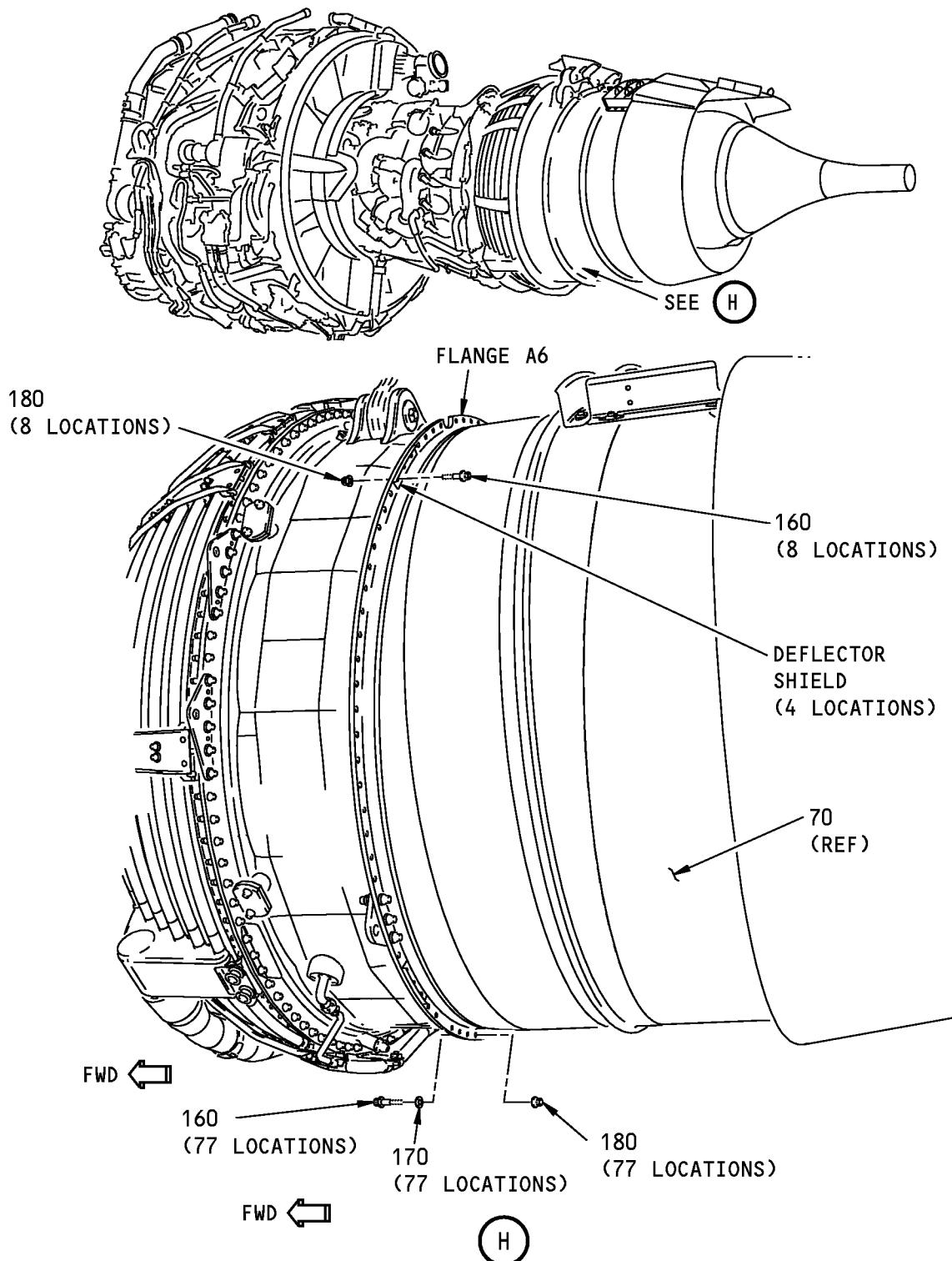
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P/P BUILDUP FIGURE 32-2

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POWERPLANT BUILDUP MANUAL

2053770 S0000417332_V3

Primary Exhaust Installation
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P/P BUILDUP FIGURE 32-2

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
32-2		<p>PRIMARY EXHAUST INSTALLATION (FIGURE 32-2, SHEET 7)</p> <p>DEFLECTOR SHIELDS ARE LOCATED AT 4 PLACES ON THE PRIMARY NOZZLE ASSY FLANGE. LOOSELY INSTALL BOLTS (160) AND NUTS (180) THROUGH THE DEFLECTOR SHIELDS. BOLT HEADS ARE ON THE AFT SIDE OF THE DEFLECTOR SHIELD.</p> <p>AT THE REMAINING 77 LOCATIONS ON THE PRIMARY NOZZLE ASSY FLANGE, LOOSELY INSTALL BOLTS (160), WASHERS (170) AND NUTS (180). BOLT HEADS ARE ON THE FWD SIDE OF ENGINE FLANGE A6.</p> <p>NOTE: IF BOLTS (160) HAVE BEEN PREVIOUSLY INSTALLED, APPLY Never-Seez NSBT-8N compound, D00006 (C1) TO THREADS OF BOLTS (160) OR REPLACE NUTS (180).</p>		
160	BACB30PN4-6	. BOLT		85
160	BACB30US4-6	. BOLT (OPTIONAL TO BACB30PN4-6)	OPT	-
170	BACW10BP4ACU	. WASHER (CSK) (UNDER BOLT HEAD)		77
180	BACN10HR4C	. NUT		85
C1	D00006	. NEVER-SEEZ NSBT-8N COMPOUND	CON	AR
		<p>SNUG FIT NUTS (110, 150 AND 180) OR BOLTS (80, 120 AND 160) IN THE FOLLOWING SEQUENCE: 3:00 O'CLOCK, 9:00 O'CLOCK, 6:00 O'CLOCK AND 12:00 O'CLOCK POSITIONS. SNUG FIT REMAINING NUTS OR BOLTS. TIGHTEN NUTS OR BOLTS AT 3:00, 9:00, 6:00 THEN 12:00 O'CLOCK POSITIONS TO THE FINAL TORQUE VALUE NOTED ON NEXT PAGE. SEQUENTIALLY TIGHTEN THE REMAINING NUTS OR BOLTS. CHECK TORQUE AT FIRST NUT OR BOLT TORQUED. IF NUT OR BOLT IS NOT WITHIN THE SPECIFIED RANGE, RE-TORQUE AND SEQUENTIALLY CHECK REMAINING NUTS OR BOLTS. RE-TORQUE IF REQUIRED.</p> <p>REMOVE GROUND SUPPORT EQUIPMENT (T1 AND T2) FROM PRIMARY NOZZLE ASSY (70).</p>		

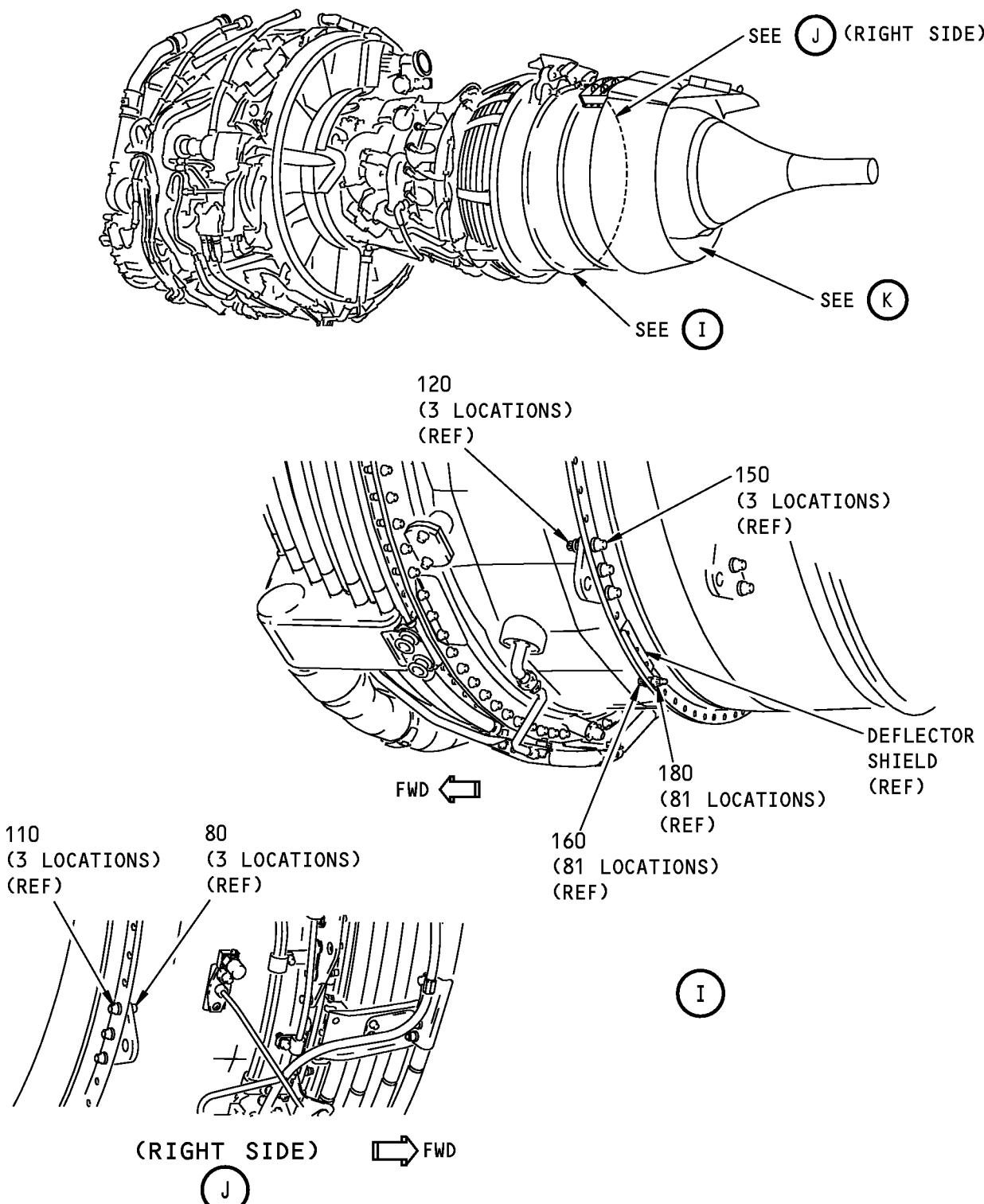
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P/P BUILDUP FIGURE 32-2

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POWERPLANT BUILDUP MANUAL

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Primary Exhaust Installation
Figure 32-2 (Sheet 8)

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P/P BUILDUP FIGURE 32-2

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
32-2		<p>PRIMARY EXHAUST INSTALLATION (FIGURE 32-2, SHEET 8)</p> <p><u>DRY NUTS/BOLTS:</u></p> <p>FINAL TORQUE VALUE FOR BACB30PN BOLT:</p> <p>NUT (110, 150 AND 180) 65-100 POUND-INCHES (7.3-11.3 NEWTON METERS)</p> <p>BOLT (80, 120 AND 160) 90-110 POUND-INCHES (10.2-12.1 NEWTON METERS)</p> <p>FINAL TORQUE VALUE FOR OPT BACB30US BOLT:</p> <p>NUT (110, 150 AND 180) 90-125 POUND-INCHES (10.2-14.1 NEWTON METERS)</p> <p>BOLT (80, 120 AND 160) 113-138 POUND-INCHES (12.8-15.6 NEWTON METERS)</p> <p><u>LUBRICATED NUTS/BOLTS:</u></p> <p>FINAL TORQUE VALUE FOR BACB30PN BOLT:</p> <p>NUT (110, 150 AND 180) 50-75 POUND-INCHES (5.65-8.47 NEWTON METERS)</p> <p>BOLT (80, 120 AND 160) 67.5-82.5 POUND-INCHES (7.63-9.32 NEWTON METERS)</p> <p>FINAL TORQUE VALUE FOR OPT BACB30US BOLT:</p> <p>NUT (110, 150 AND 180) 70-80 POUND-INCHES (7.91-9.04 NEWTON METERS)</p> <p>BOLT (80, 120 AND 160) 72-88 POUND-INCHES (8.13-9.94 NEWTON METERS)</p>		

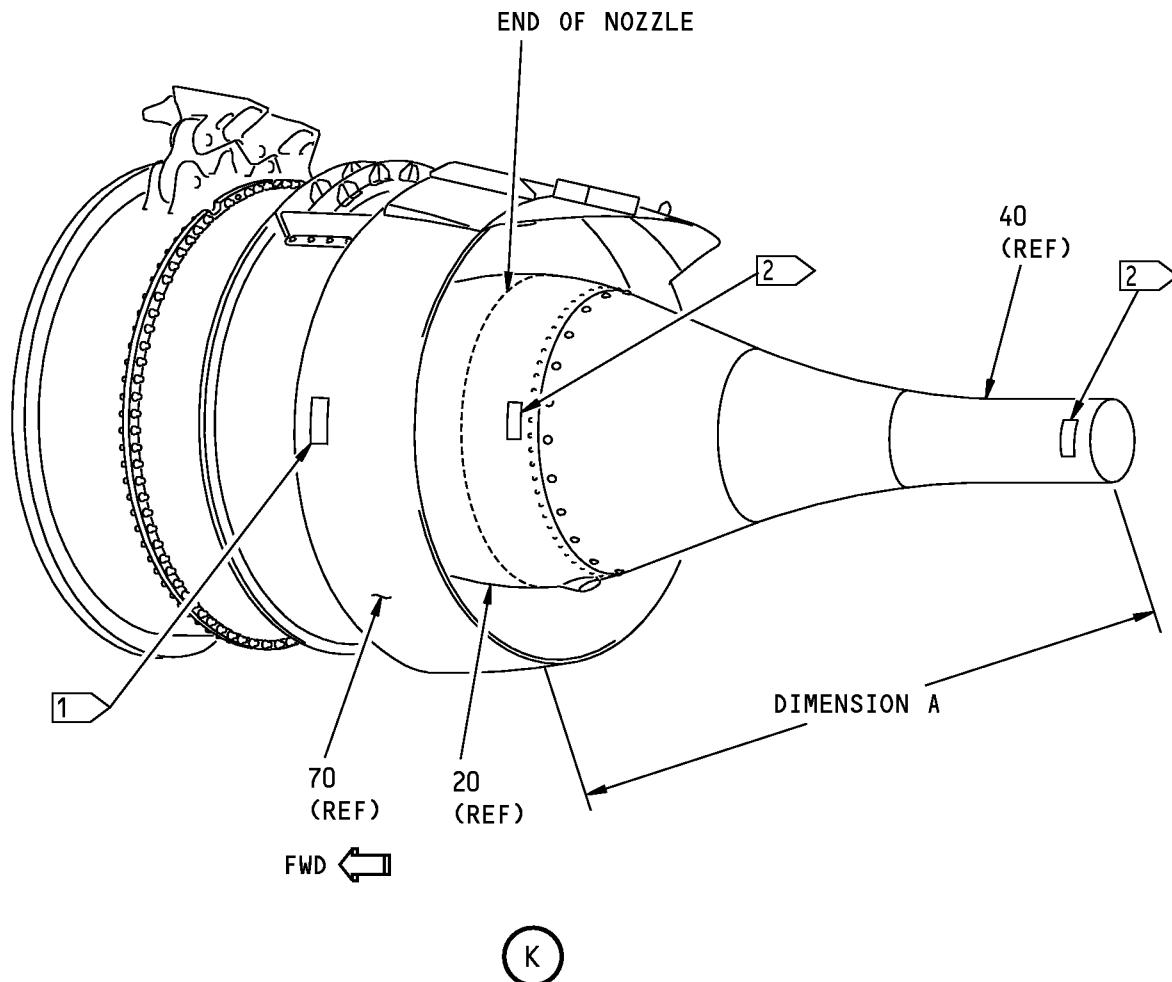
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P/P BUILDUP FIGURE 32-2

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- [1] USE ONLY WITH 314A2640 PLUG
 [2] USE ONLY WITH 314A2630 NOZZLE

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Primary Exhaust Installation
Figure 32-2 (Sheet 9)

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P/P BUILDUP FIGURE 32-2

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
32-2		<p>PRIMARY EXHAUST INSTALLATION (FIGURE 32-2, SHEET 9)</p> <p>CAUTION: THE INTERMIX OF THE LONG NOZZLE AND SHORT PLUG OR THE SHORT NOZZLE AND LONG PLUG IS NOT PERMITTED. DAMAGE TO EQUIPMENT CAN OCCUR.</p> <p><u>NOZZLE AND PLUG FIT CHECK:</u></p> <p>DO THESE STEPS TO MAKE SURE THE CORRECT EXHAUST NOZZLE AND EXHAUST PLUG ARE INSTALLED:</p> <p>MEASURE AND RECORD THE DIMENSION BETWEEN THE AFT EDGE OF THE EXHAUST NOZZLE AT THE 6 O'CLOCK LOCATION AND THE AFT EDGE OF THE EXHAUST PLUG AT THE 6 O'CLOCK POSITION (DIMENSION A = _____).</p> <p>DIMENSION A MUST BE 37.7 INCHES (+/- 0.5 INCHES) (957.58 MM (+/- 12.7 MM)).</p> <p>IF YOU RECORD ANY OTHER DIMENSION, THEN THE EXHAUST NOZZLE AND EXHAUST PLUG ARE NOT COMPATIBLE.</p>		

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P/P BUILDUP FIGURE 32-2

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FIGURE 33-1

INLET COWL INSTALLATION

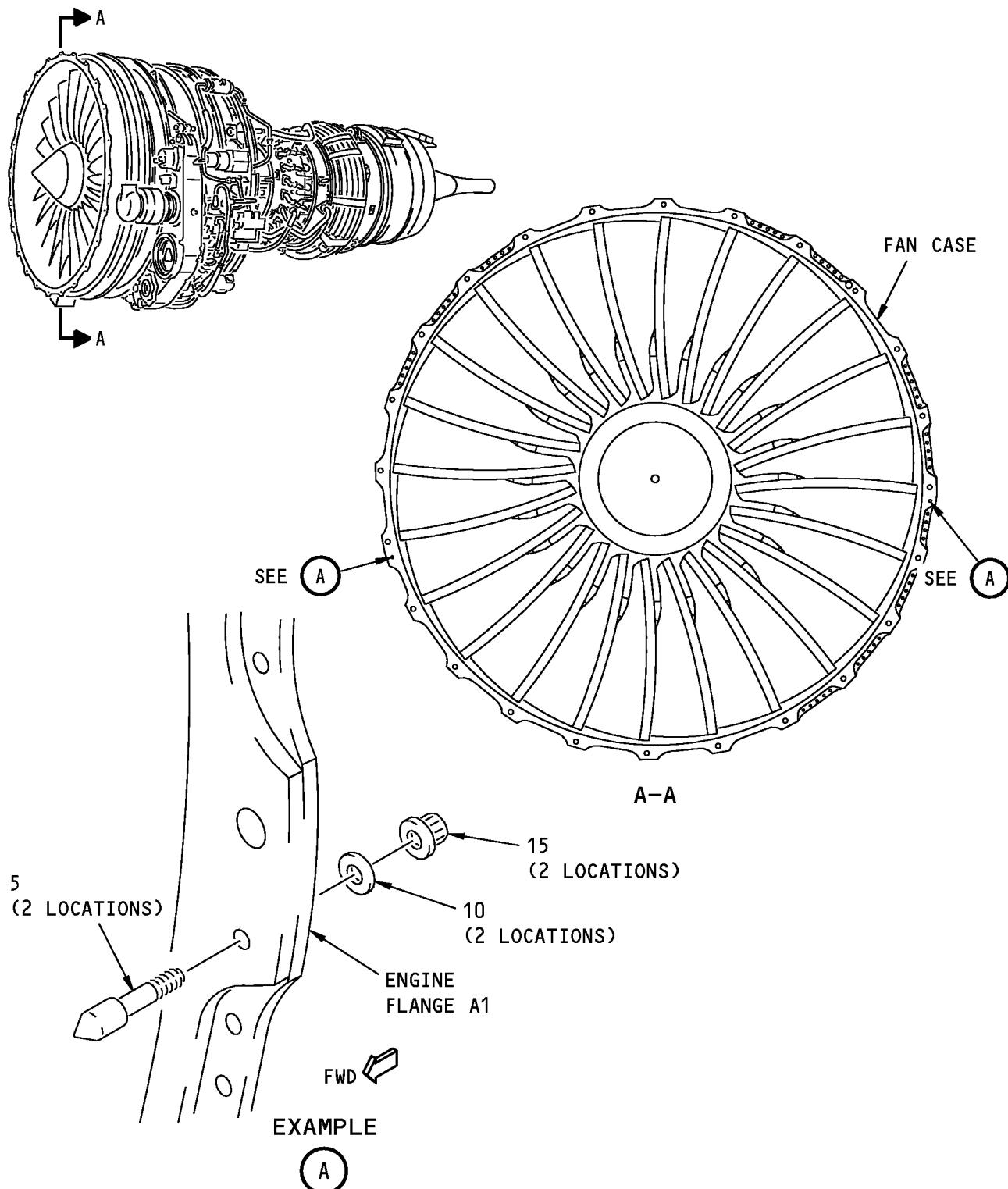
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REF DWG: 334A2000
301A2094

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P/P BUILDUP FIGURE 33-1
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POWERPLANT BUILDUP MANUAL

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Inlet Cowl Installation
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P/P BUILDUP FIGURE 33-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
33-1		INLET COWL INSTALLATION (FIGURE 33-1, SHEET 1) NOTE: INLET COWL IS INTERCHANGEABLE BETWEEN AIRPLANE ENGINE POSITIONS. NO. 1 (LEFT) ENGINE INLET IS THE SAME AS THE NO. 2 (RIGHT) ENGINE INLET. INSTALL SHEAR PINS (5) ON ENGINE FLANGE A1 IN HOLES JUST BELOW 3 AND 9 O'CLOCK POSITIONS WITH PINS FACING FWD. USE WASHERS (10) AND NUTS (15).		
5	314T3019-3	. SHEAR PIN		2
10	NAS1149E0432P	. WASHER		2
15	BACN10YR4CM	. NUT		2
		TIGHTEN NUTS (15) TO 55-70 POUND-INCHES (6.2-7.9 NEWTON METERS).		

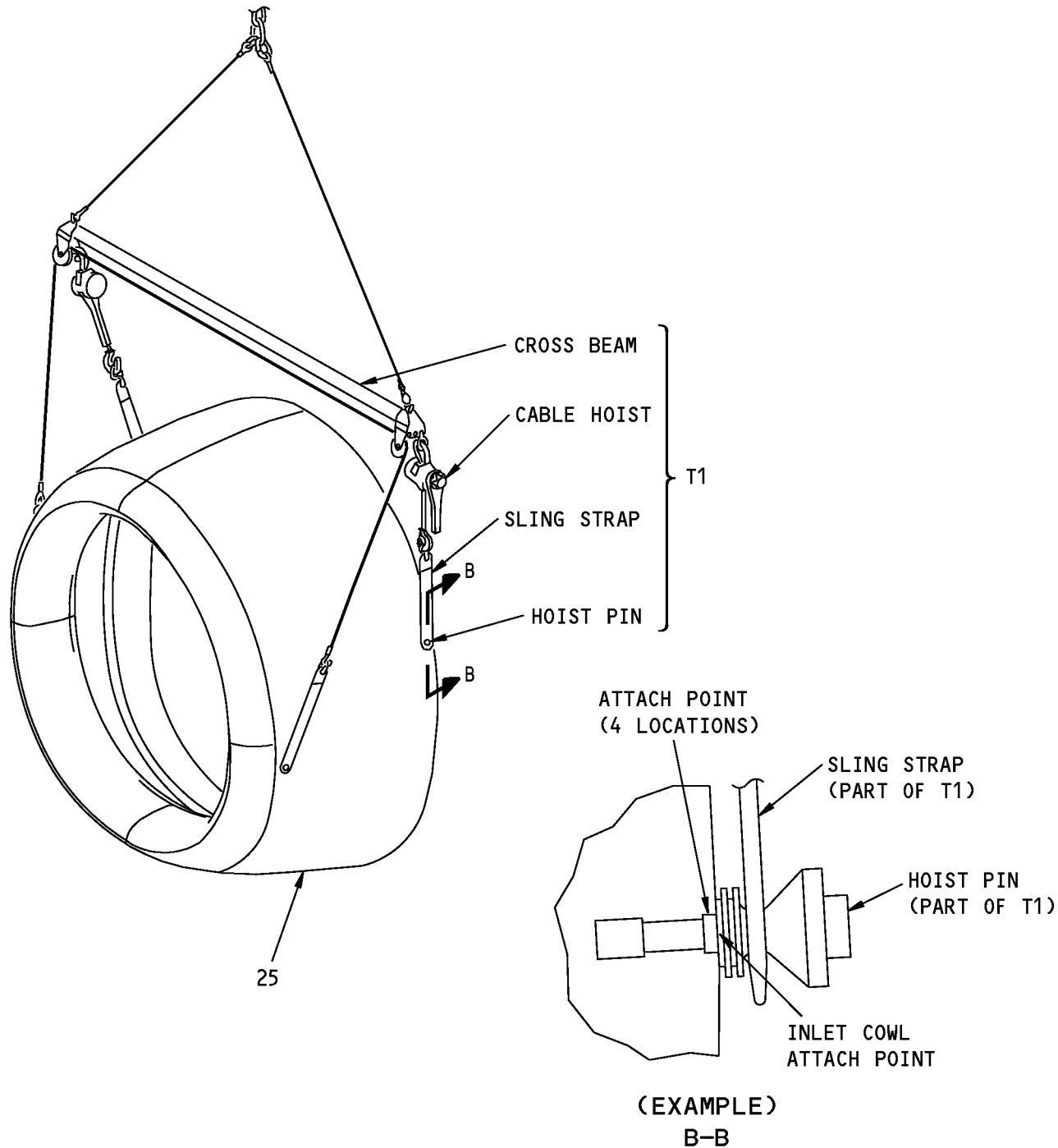
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P/P BUILDUP FIGURE 33-1

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POWERPLANT BUILDUP MANUAL

INLET COWL INSTALLATION WITH INLET COWL SLING

Inlet Cowl Installation
Figure 33-1 (Sheet 2)

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P/P BUILDUP FIGURE 33-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
33-1		INLET COWL INSTALLATION (FIGURE 33-1, SHEET 2) <u>INLET COWL INSTALLATION WITH INLET COWL SLING (PREFERRED METHOD):</u> AT FOUR LOCATIONS, ATTACH inlet cowl sling, SPL-2062 (T1) TO INLET COWL (25) USING HOIST PINS AND SLING STRAPS. . INLET ASSY (V51563) (SPEC S314A210-29) . INLET ASSY (V51563) (SPEC S314A210-21) (OPTIONAL TO 314-2100-4) . INLET ASSY (V51563) (SPEC S314A210-5) (OPTIONAL TO 314-2100-3) . INLET COWL SLING, SPL-2062 LIFT INLET COWL OFF GROUND PALLET AND USE BOTH LEVER HOISTS TO ROTATE INLET COWL (25) UNTIL INLET ATTACHMENT FLANGE IS VERTICAL. <u>NOTE:</u> TO TURN INLET COWL, DECREASE LENGTH OF LEVER HOIST CHAIN. REMOVE PROTECTIVE COVERS FROM CTAI DUCT AND EEC COOLING HOSE ON BOTH ENGINE AND INLET COWL (25).		
25	314-2100-4		VEN	1
25	314-2100-3		OPT	-
25	314-2100-2		OPT	-
T1	B71040		TOL	-

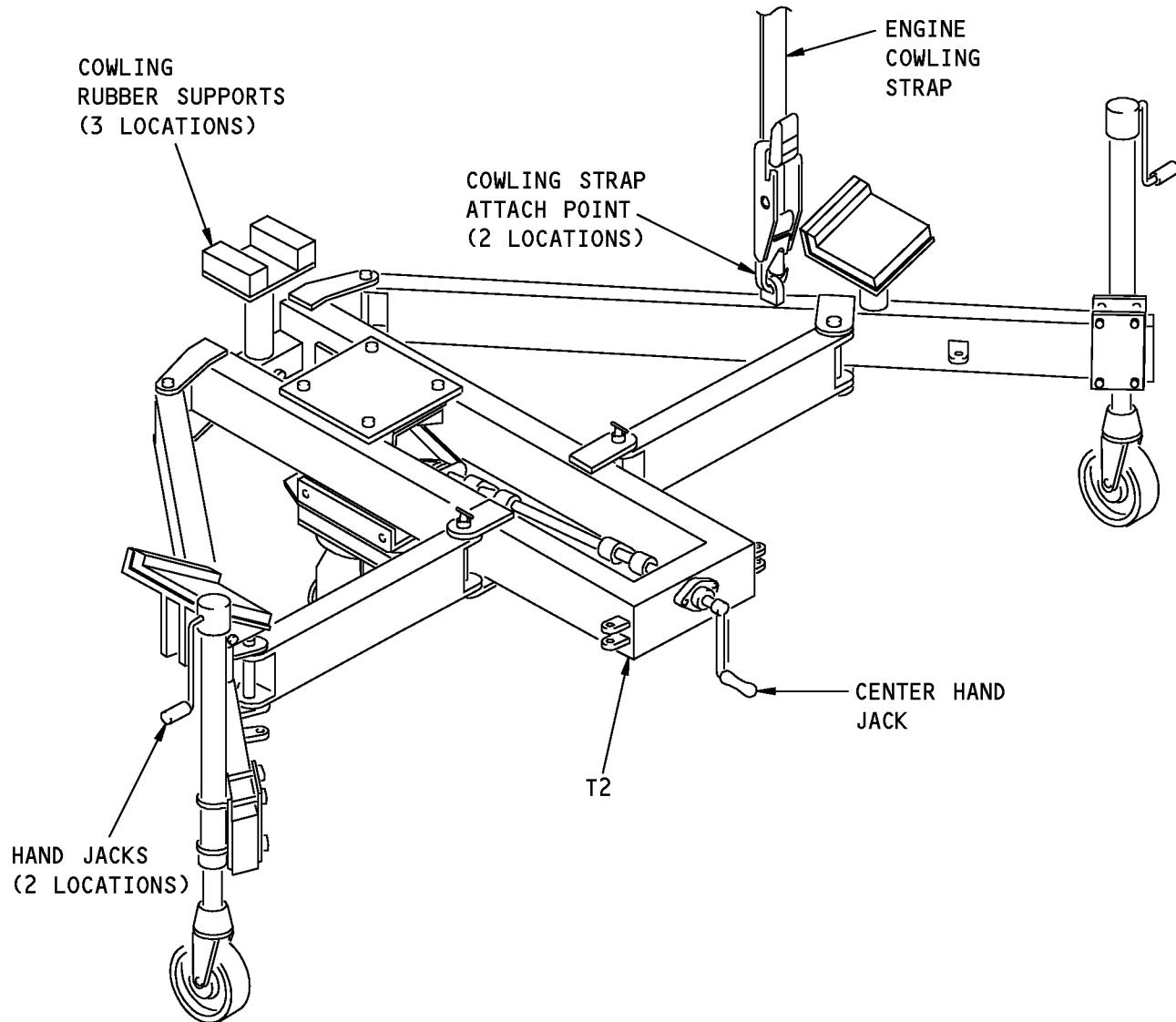
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P/P BUILDUP FIGURE 33-1

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INLET COWL INSTALLATION INLET COWL DOLLY

Inlet Cowl Installation
Figure 33-1 (Sheet 3)

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P/P BUILDUP FIGURE 33-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
33-1		<p>INLET COWL INSTALLATION (FIGURE 33-1, SHEET 3)</p> <p><u>INLET COWL INSTALLATION WITH INLET COWL DOLLY (OPTIONAL METHOD):</u></p> <p>CAUTION: APPLY ONLY THE FORCE NECESSARY TO THE ENGINE COWLING STRAP TO HOLD THE INLET COWL TO THE DOLLY. MORE FORCE CAN CAUSE DAMAGE TO THE INLET COWL.</p> <p>dolly, COM-2060 (T2) CAN BE USED TO TRANSFER AN INLET COWL FROM AN ON-WING ENGINE OR FOR A INLET COWL STORED ON THE DOLLY.</p> <p>NOTE: THE INLET COWL DOLLY IS NOT DESIGNED TO LIFT THE INLET COWL DIRECTLY FROM A GROUND PALLET.</p>		
T2	AM-1940-400	<p>. DOLLY, COM-2060</p> <p>REMOVE PROTECTIVE COVERS FROM CTAI DUCT AND EEC COOLING HOSE ON BOTH ENGINE AND INLET COWL (25).</p>	TOL	-

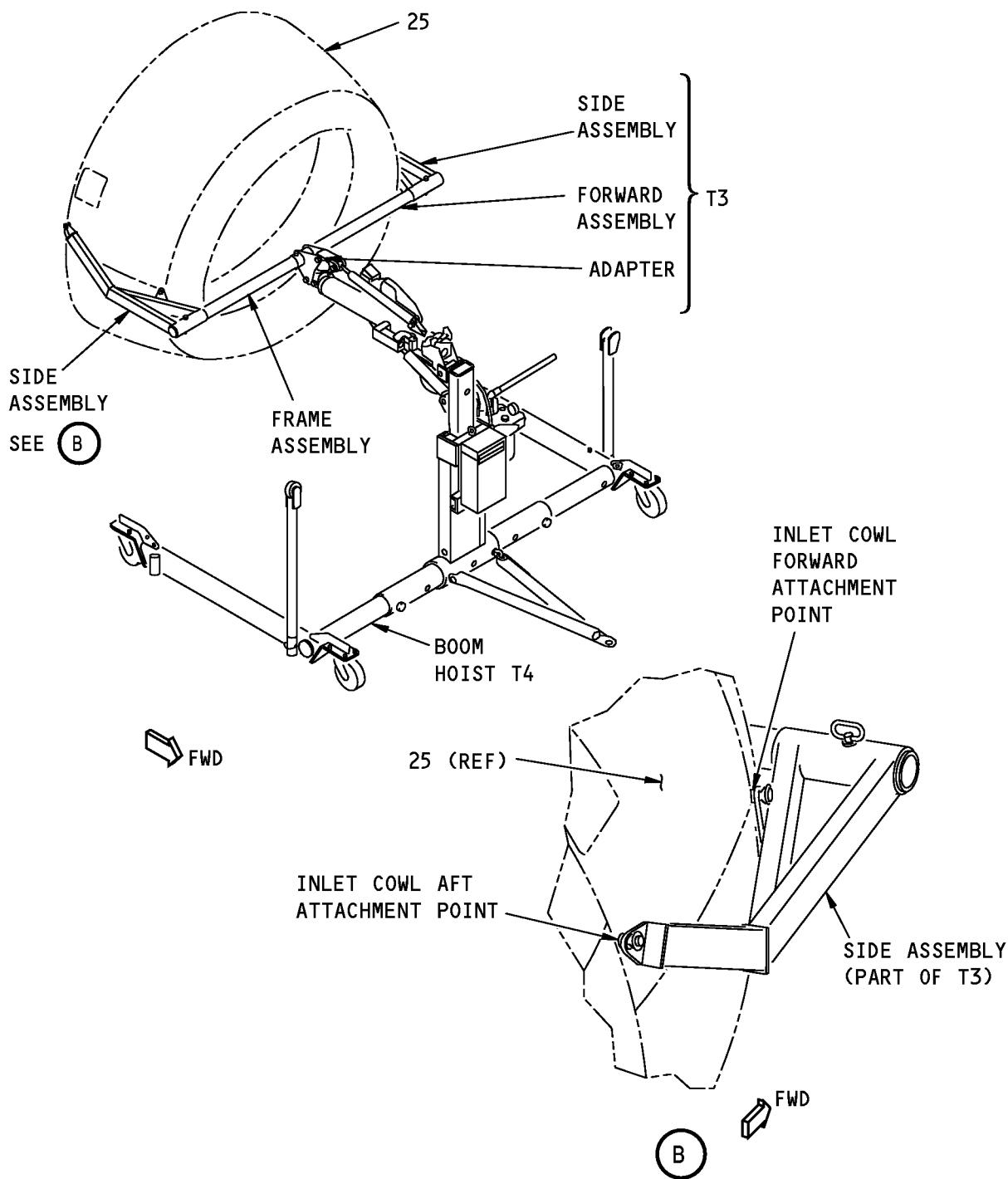
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P/P BUILDUP FIGURE 33-1

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POWERPLANT BUILDUP MANUAL

INLET COWL INSTALLATION WITH BOOM HOIST

Inlet Cowl Installation
Figure 33-1 (Sheet 4)

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P/P BUILDUP FIGURE 33-1

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POWERPLANT BUILDUP MANUAL

ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
33-1		INLET COWL INSTALLATION (FIGURE 33-1, SHEET 4) <u>INLET COWL INSTALLATION WITH BOOM HOIST (OPTIONAL METHOD):</u> AT FOUR LOCATIONS, ATTACH installation/removal frame equipment, SPL-2165 (T3) TO INLET COWL (25). . INSTALLATION/REMOVAL FRAME EQUIPMENT, SPL-2165 USING boom hoist, SPL-2430 (T4), LIFT INLET COWL OFF GROUND PALLET AND ROTATE INLET COWL (25) UNTIL INLET ATTACHMENT FLANGE IS VERTICAL. . BOOM HOIST, SPL-2430 REMOVE PROTECTIVE COVERS FROM CTAI DUCT AND EEC COOLING HOSE ON BOTH ENGINE AND INLET COWL (25).		
T3	C71027		TOL	-
T4	C78026		TOL	-

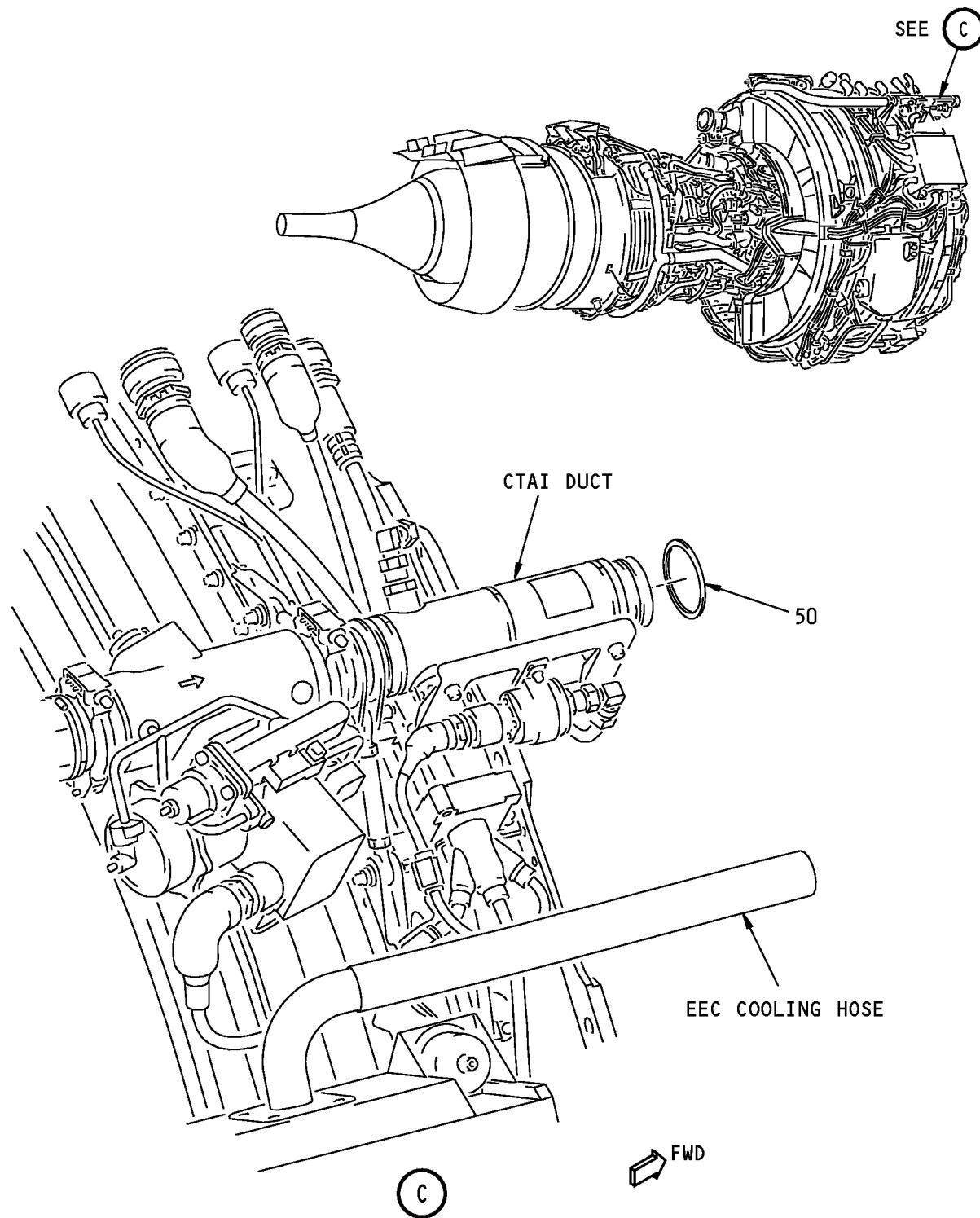
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P/P BUILDUP FIGURE 33-1

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Inlet Cowl Installation
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P/P BUILDUP FIGURE 33-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
33-1		INLET COWL INSTALLATION (FIGURE 33-1, SHEET 5) MAKE SURE FLANGES ON CTAI AND EEC COOLING DUCTS ARE FREE OF SCRATCHES, CUTS, PITS, CREASES, AND UNWANTED MATERIAL. REMOVE ITEM (50) FROM BAG ATTACHED TO FORWARD CTAI DUCT AND INSTALL ON CTAI DUCT FLANGE. . SEAL (PART OF CTAI DUCT INSTL - INLET COWL TAI SYSTEM INSTALLATION/Figure 27-1) . SEAL (OPTIONAL TO AS1895-7-200) (PART OF CTAI DUCT INSTL - INLET COWL TAI SYSTEM INSTALLATION/Figure 27-1)		
50	AS1895-7-200		REF	-
50	AS1895/7-200		OPT	-

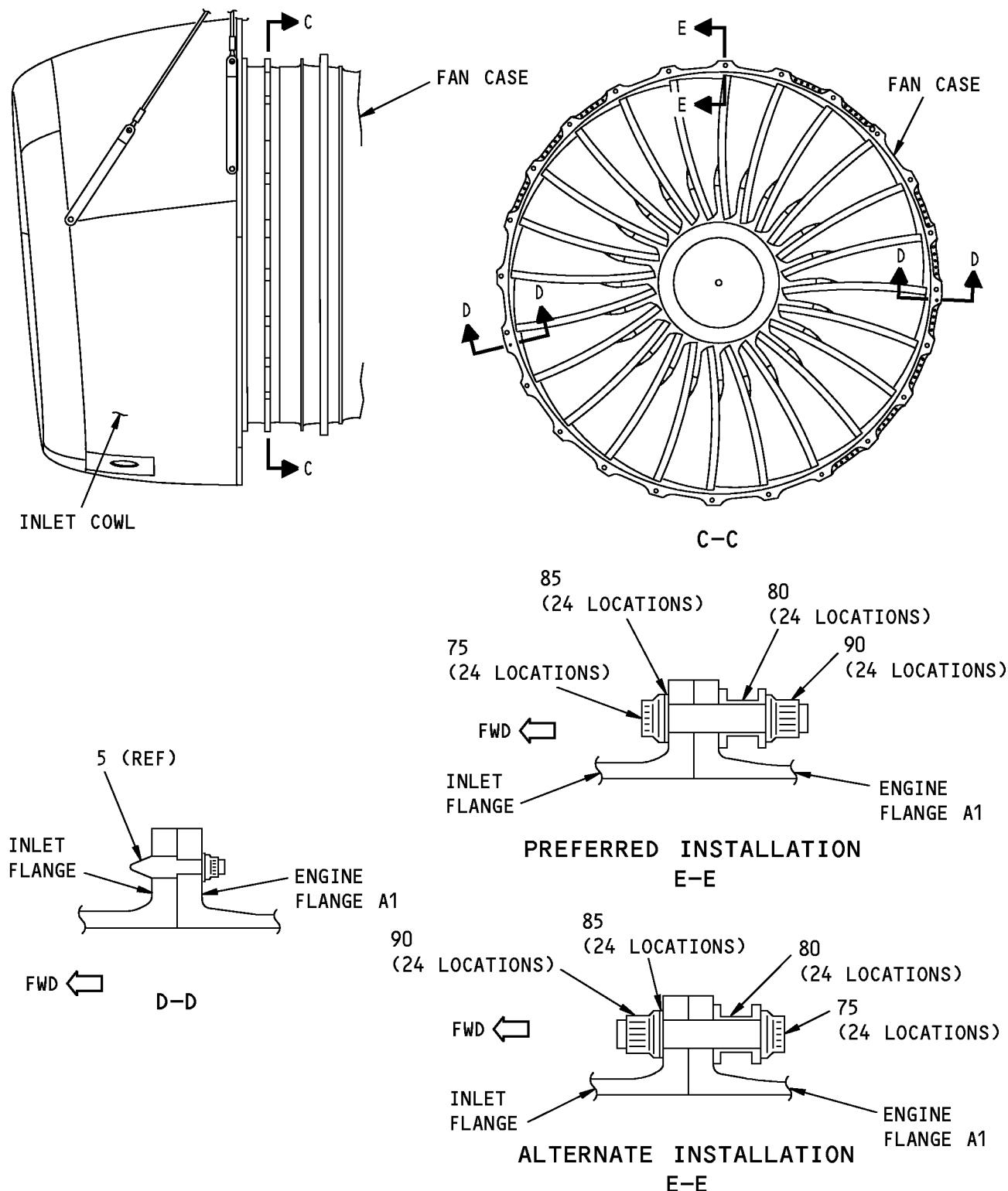
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P/P BUILDUP FIGURE 33-1

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P/P BUILDUP FIGURE 33-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
33-1		<p>INLET COWL INSTALLATION (FIGURE 33-1, SHEET 6)</p> <p>POSITION INLET COWL (25) ON ENGINE ENSURING SHEAR PIN HOLES IN INLET ALIGN WITH SHEAR PINS ON ENGINE FLANGE A1.</p> <p>NOTE: MAKE SURE CTAI DUCT AND EEC COOLING HOSE ARE ALIGNED AND SEATED CORRECTLY.</p> <p>LOOSELY ATTACH INLET COWL (25) TO ENGINE FLANGE A1 WITH BOLTS (75), SPACERS (80), WASHERS (85) AND NUTS (90).</p> <p>NOTE: THE PREFERRED INSTALLATION HAS THE BOLT HEADS FACING FORWARD. AS AN ALTERNATE INSTALLATION, THE BOLT HEADS CAN FACE AFT. HOWEVER, IN BOTH CASES, THE WASHERS MUST BE ON THE FORWARD SIDE OF THE INLET FLANGE AND THE SPACER MUST BE ON THE AFT SIDE OF THE ENGINE FLANGE.</p>		
75	BACB30US8K29	. BOLT		24
80	334A2010-1	. SPACER (AFT SIDE OF FLANGE)		24
85	BACW10BP8ACU	. WASHER (FWD SIDE OF FLANGE)		24
90	BACN10HR8CS	<p>. NUT</p> <p>SNUG FIT BOLTS (75) OR NUTS (90) IN THE FOLLOWING SEQUENCE: 3 O'CLOCK, 9 O'CLOCK, 6 O'CLOCK AND 12 O'CLOCK POSITIONS. SNUG FIT REMAINING BOLTS OR NUTS. TIGHTEN BOLTS OR NUTS AT 3, 9, 6 AND 12 O'CLOCK POSITIONS TO THE FINAL TORQUE VALUE NOTED BELOW. SEQUENTIALLY TIGHTEN THE REMAINING BOLTS OR NUTS. CHECK TORQUE AT FIRST BOLT OR NUT TORQUED. IF BOLT OR NUT IS NOT WITHIN THE SPECIFIED RANGE, RE-TORQUE AND SEQUENTIALLY CHECK REMAINING FASTENERS. RE-TORQUE IF REQUIRED.</p> <p>FINAL TORQUE VALUE: BOLTS (75) 585-715 POUND INCHES (66.1-80.8 NEWTON METERS); NUTS (90) 500-650 POUND INCHES (56.5-73.4 NEWTON METERS).</p> <p>REMOVE inlet cowl sling, SPL-2062 (T1) OR dolly, COM-2060 (T2) OR installation/removal frame equipment, SPL-2165 (T3) AND boom hoist, SPL-2430 (T4) EQUIPMENT.</p>		24

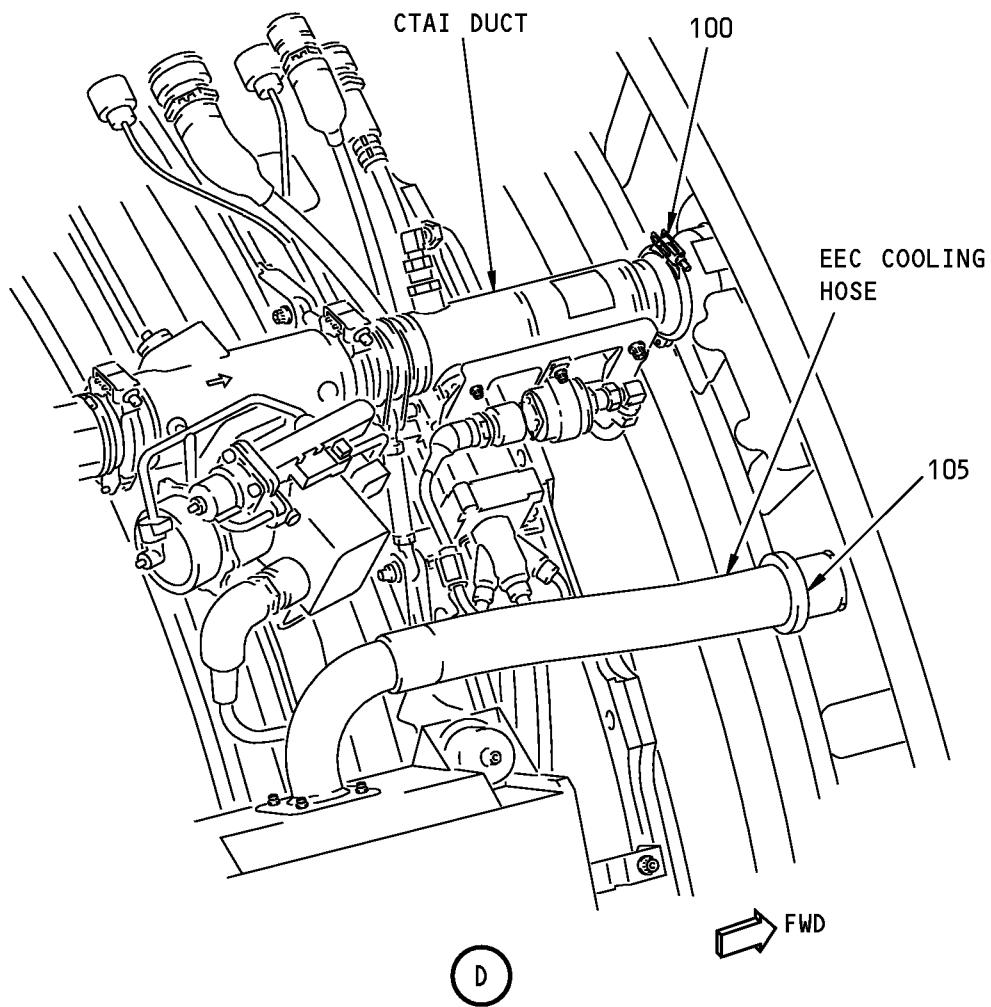
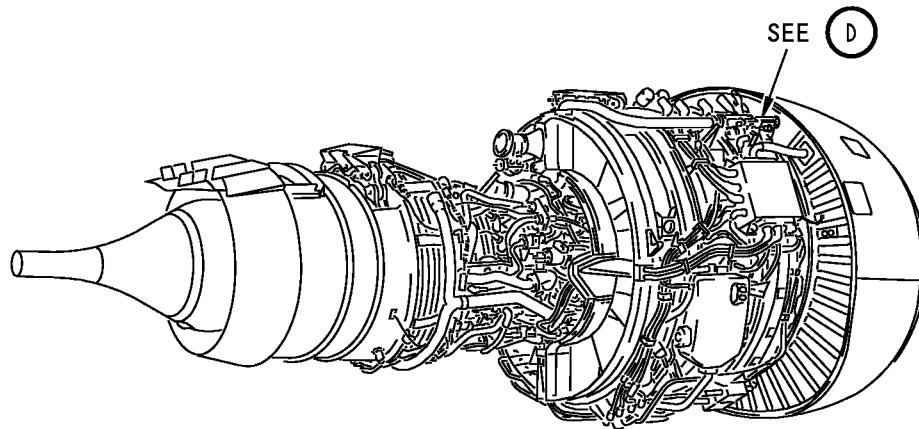
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P/P BUILDUP FIGURE 33-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
33-1		INLET COWL INSTALLATION (FIGURE 33-1, SHEET 7)		
100	AS1895-4-200	REMOVE ITEM (100) FROM BAG ATTACHED TO FORWARD CTAI DUCT. .	REF	-
100	AS1895/4-200	COUPLING (PART OF CTAI DUCT INSTL - INLET COWL TAI SYSTEM INSTALLATION/Figure 27-1) .	OPT	-
		COUPLING (OPTIONAL TO AS1895-4-200) (PART OF CTAI DUCT INSTL - INLET COWL TAI SYSTEM INSTALLATION/Figure 27-1) .		
		POSITION COUPLING (100) ON CTAI DUCT, ENSURING NO PRELOAD EXISTS ON CTAI DUCT ON ENGINE OR INLET COWL. IF PRELOAD EXISTS, REMOVE COUPLING (100) AND ADJUST THE CTAI DUCT FLANGE AS FOLLOWS. LOOSEN BOLTS ON INLET COWL BULKHEAD TO FREE AFT INLET SEAL HOUSING. RE-ATTACH UPSTREAM DUCT WITH COUPLING (100). TAP ON ALUMINUM OR NON-METALLIC SPACER HELD AGAINST UPSTREAM CTAI FLANGE. FOR AFT ADJUSTMENT, APPLY A CONSTANT AFT FORCE TO SAME AFT FLANGE AND AT THE SAME TIME TAP ON PERIPHERY WITH A NON-METALLIC MALLET. .		
		TIGHTEN COUPLING (100) TO TORQUE SPECIFIED ON PART. LIGHTLY TAP OUTER SURFACE OF COUPLING WITH NON-METALLIC MALLET. RETIGHTEN COUPLING TO TORQUE GIVEN ON PART. IN SEQUENCE, RETIGHTEN BOLTS ON AFT INLET SEAL HOUSING TO 20 POUND-INCHES (2.26 NEWTON METERS). .		
105	BACC10JB034C064	ATTACH EEC COOLING HOSE ON ENGINE TO HOSE FLANGE ON INLET COWL WITH HOSE CLAMP (105). .		1
		HOSE CLAMP .		
		TIGHTEN HOSE CLAMP (105) TO 26-30 POUND-INCHES (2.9-3.4 NEWTON METERS). .		

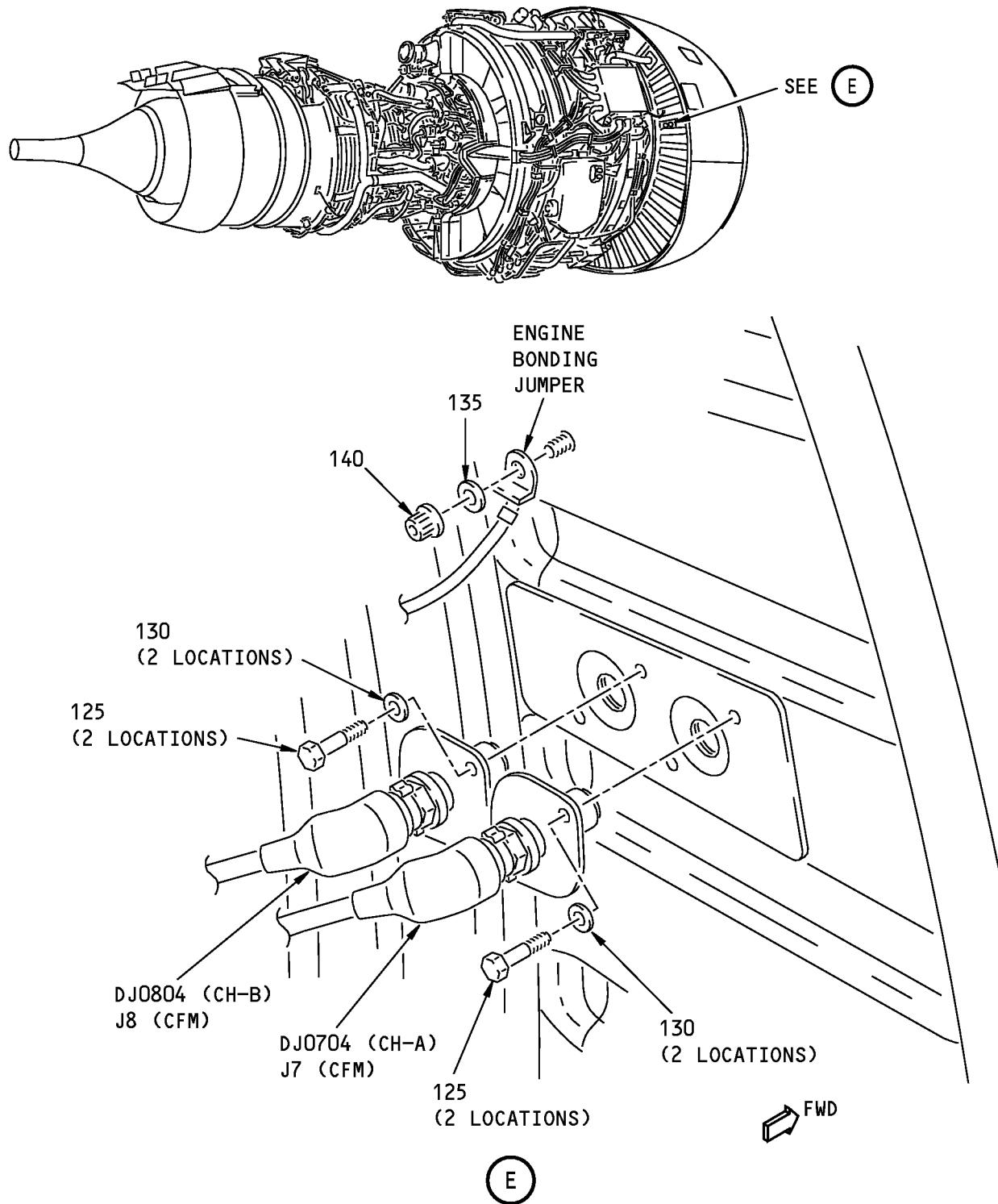
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P/P BUILDUP FIGURE 33-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
33-1		INLET COWL INSTALLATION (FIGURE 33-1, SHEET 8) DISCONNECT T12 SENSOR FROM ENGINE FAN CASE. CONNECT J8 ELECTRICAL HARNESS, DJ0804 (CH-B), TO INBOARD HOLE LOCATION AND CONNECT J7 ELECTRICAL HARNESS, DJ0704 (CH-A), TO OUTBOARD HOLE LOCATION ON INLET COWL AFT BULKHEAD. SECURE BOTH ELECTRICAL HARNESSSES WITH BOLTS (125) AND WASHERS (130).		
125	BACB30ZF4-08	. BOLT		4
130	NAS1149E0432R	. WASHER		4
		TIGHTEN BOLTS (125) TO 55-70 POUND-INCHES (6.2-7.9 NEWTON METERS).		
		ATTACH ENGINE BONDING JUMPER TO TERMINAL LUG AND SECURE WITH WASHER (135) AND NUT (140).		
135	NAS1149E0432R	. WASHER		1
140	AS3485-10	. NUT		1
		TIGHTEN NUT (140) TO 70-85 POUND-INCHES (7.9-9.6 NEWTON METERS).		

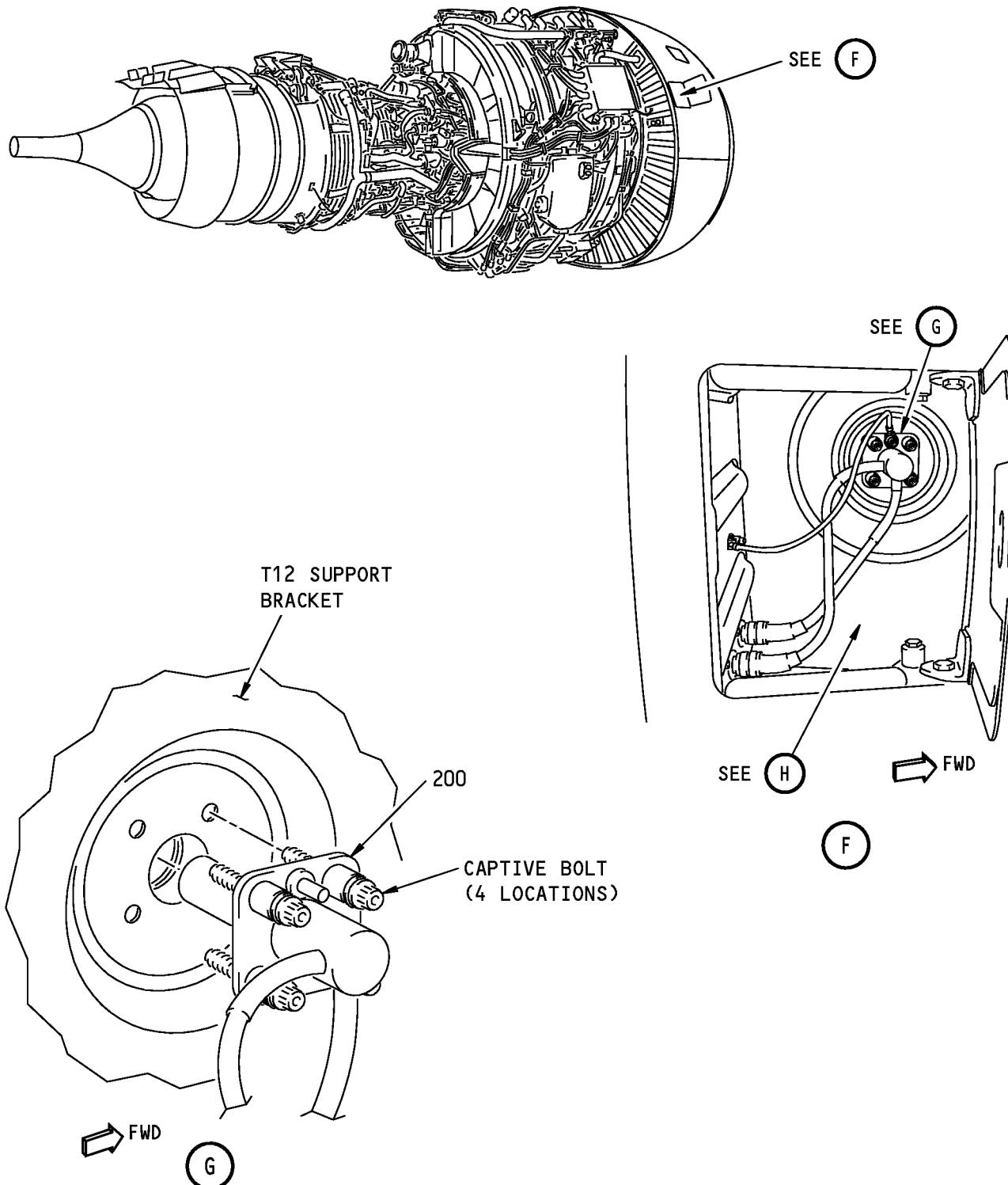
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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
33-1 200 C1	RP235-00 D00601	<p>INLET COWL INSTALLATION (FIGURE 33-1, SHEET 9)</p> <p>OPEN T12 ACCESS DOOR ON UPPER RIGHT SIDE OF INLET COWL. LUBRICATE THREADS OF SENSOR (200) CAPTIVE BOLTS WITH grease, D00601 [CP2101] (C1). POSITION T12 SENSOR (200) ON INLET COWL AND SECURE WITH CAPTIVE BOLTS.</p> <p>. T12 SENSOR (VF6880) (SUPPLIED WITH ENGINE) . GREASE (CP2101)</p> <p>TIGHTEN BOLTS TO 110-121 POUND-INCHES (12.4-13.7 NEWTON METERS).</p>	REF CON	- AR

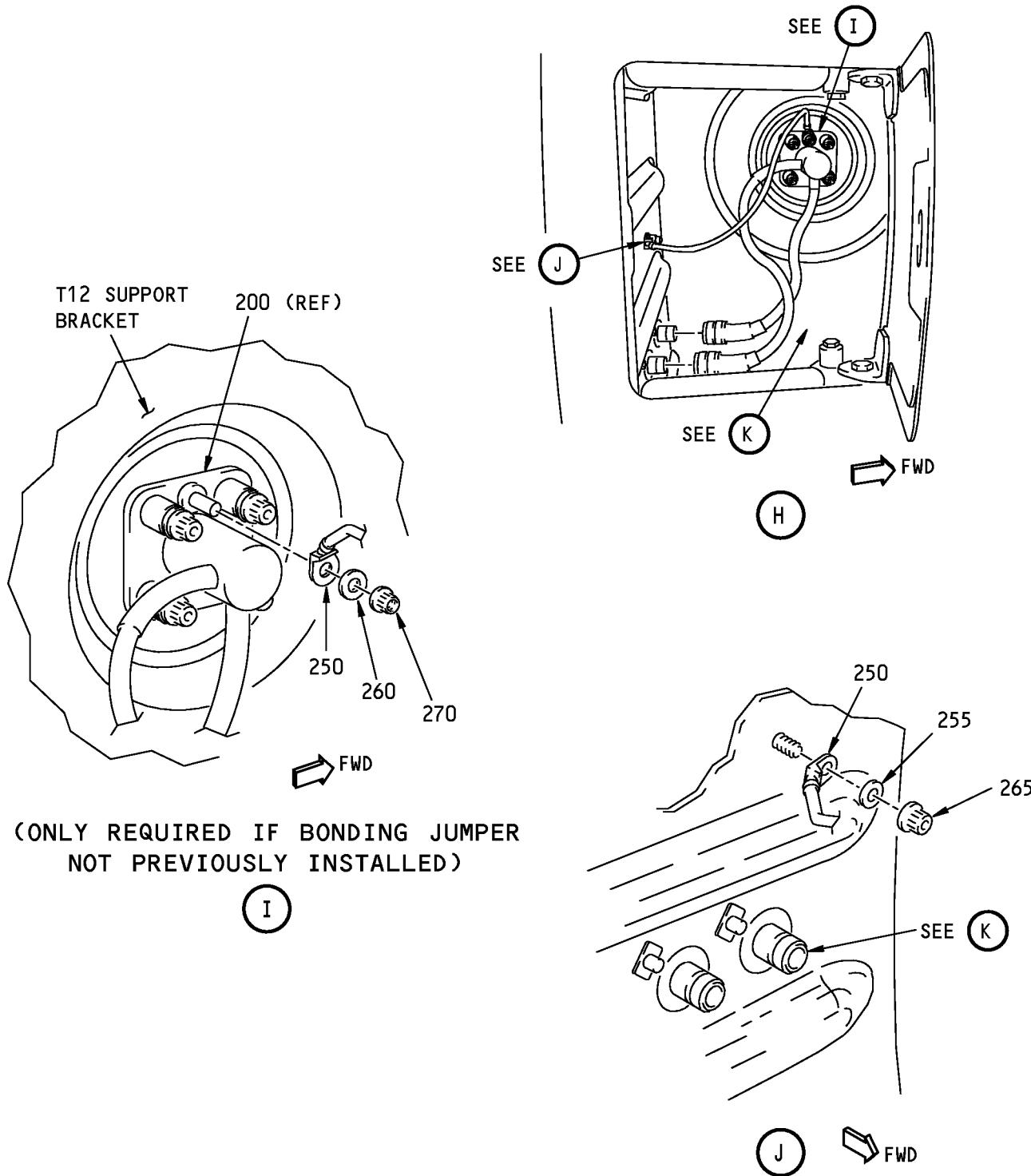
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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
33-1		INLET COWL INSTALLATION (FIGURE 33-1, SHEET 10) ATTACH BONDING JUMPER (250) TO TERMINAL STUDS ON INLET COWL BULKHEAD AND SECURE WITH WASHER (255) AND NUT (265). IF BONDING JUMPER IS NOT INSTALLED ON T12 SENSOR, USE Brisal OX grease, D00625 [CP2338] (C1) TO LUBRICATE BONDING JUMPER (250), WASHER (260) AND NUT (270). ATTACH BONDING JUMPER TO TERMINAL LUG AND SECURE WITH WASHER (260) AND NUT (270).		
250	69A94	. BONDING JUMPER (VF6880) (SUPPLIED WITH ENGINE)	REF	-
255	NAS1149E0432R	. WASHER		1
260	649-341-011-0	. WASHER (VF6880) (SUPPLIED WITH ENGINE) (1 REQD)	REF	-
265	AS3485-10	. NUT		1
270	649-304-004-0	. NUT (V07482) (SUPPLIED WITH ENGINE) (1 REQD)	REF	-
C1	D00625	. BRISAL OX GREASE (CP2338)	CON	AR
		TIGHTEN NUT (265) TO 70-85 POUND-INCHES (7.9-9.6 NEWTON METERS) AND, IF NECESSARY, TIGHTEN NUT (270) TO 95-110 POUND-INCHES (11-12.5 NEWTON METERS).		

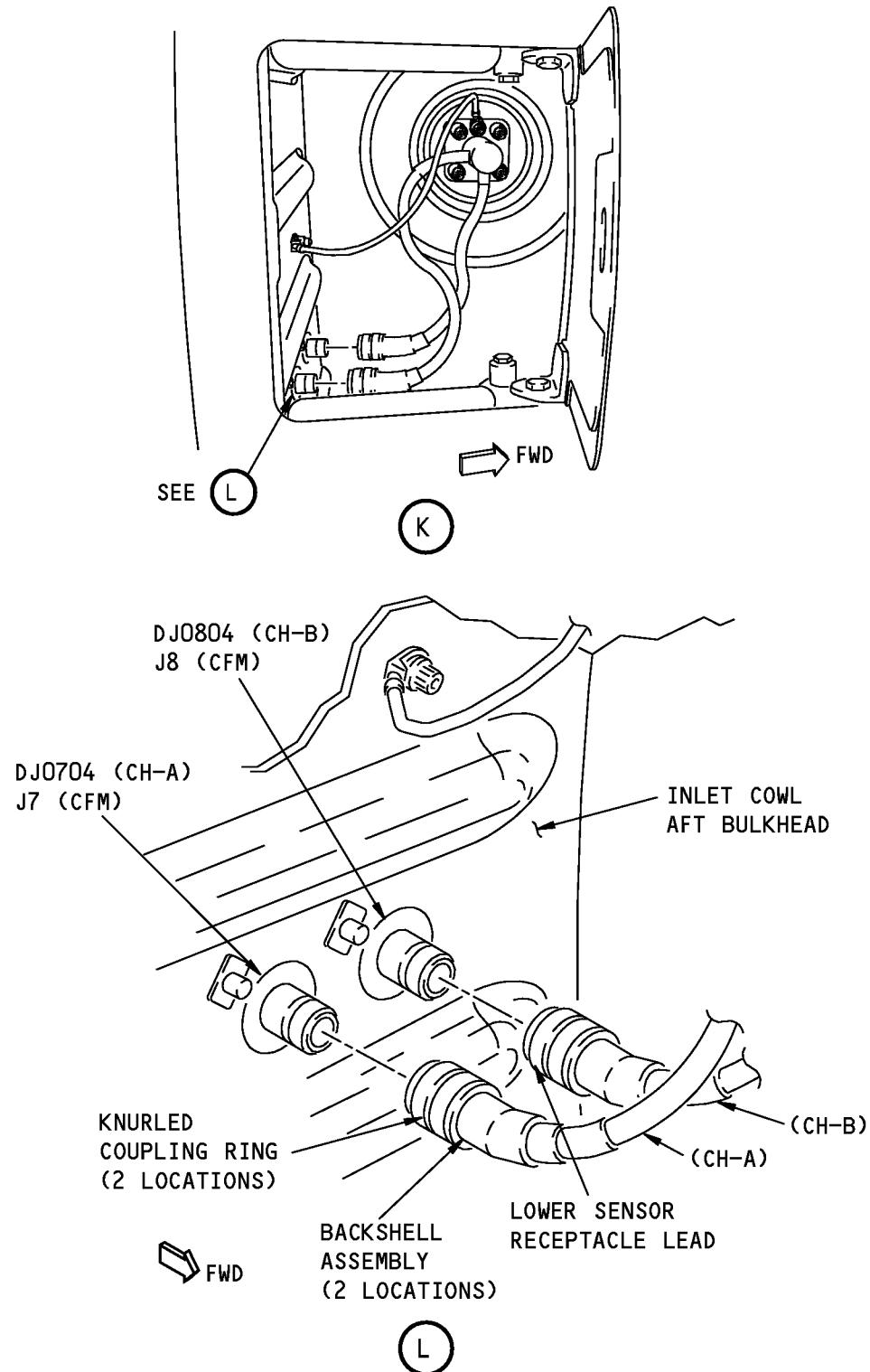
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P/P BUILDUP FIGURE 33-1

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P/P BUILDUP FIGURE 33-1

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ITEM NO.	PART NUMBER	NOMENCLATURE	UC	QTY
33-1		<p>INLET COWL INSTALLATION (FIGURE 33-1, SHEET 11)</p> <p>CAUTION: DO NOT OVERTIGHTEN THE PLUG COUPLING RING. DO NOT USE WATER PUMP PLIERS, PIPE WRENCHES OR VISE GRIPS TO TIGHTEN THE COUPLING RING OR DAMAGE TO THE ELECTRICAL CONNECTOR CAN OCCUR.</p> <p>CONNECT J8 ELECTRICAL CONNECTOR, DJ0804 (CH-B), TO INBOARD RECEPTACLE AND J7 ELECTRICAL CONNECTOR, DJ0704 (CH-A) TO OUTBOARD RECEPTACLE. TURN KNURLED COUPLING RING WHILE WIGGLING THE BACKSHELL ASSEMBLY. AFTER FULLY SEATING THE COUPLING RING, USE SOFT-JAWED PLIERS OR A STRAP WRENCH TO TIGHTEN THE COUPLING RING AN ADDITIONAL 1/8 TURN OR UNTIL PLIER SLIPPAGE OCCURS.</p> <p>CHECK THAT RESISTANCE ON ENGINE JUMPER AT INLET COWL AFT BULKHEAD AND T12 BONDING JUMPER AT INLET COWL FORWARD BULKHEAD IS NOT MORE THAN 0.001 OHMS.</p> <p>CHECK THAT RESISTANCE BETWEEN T12 BONDING JUMPER AT T12 SENSOR IS NOT MORE THAN 0.0025 OHMS.</p> <p>CLOSE T12 ACCESS DOOR ON INLET COWL.</p>		

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P/P BUILDUP FIGURE 33-1

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QEC System Tests

1. General

- A. QEC system tests provided in this section are optional and duplicate tests normally performed after engine installation on an airplane.

2. IDG Cooling Lines Flushing Procedure

- A. General

CAUTION: DO NOT FLUSH THE IDG WHEN YOU DO THIS PROCEDURE. MAKE SURE THE OIL-IN AND OIL-OUT HOSES ARE DISCONNECTED FROM THE IDG. IF THIS STEP IS NOT OBEYED, DAMAGE TO THE IDG CAN OCCUR.

- (1) This flushing procedure is done on the external IDG cooling lines only. The oil-in and oil-out lines must be disconnected from the IDG before you start this procedure.

B. Equipment

- (1) Flushing cart, capable of 14 GPM flow capacity and a maximum pressure of 250 psi, or;
Flushing cart, Boeing Flush Cart F/D 1206-00.29 or equivalent.

- (2) 5-gallon container to collect cleansing oil or solvent.

- (3) Patch filter, 40 micron

C. Consumable Materials

- (1) solvent, B00074 (Optional Type 1)

- (2) Nitrogen, minimum of 3.5 lbs (a pressure drop of 500-1000 psig) from a 230 cubic foot nitrogen tank (atmospheric 2200 psig).

D. Procedure

- (1) Disconnect the oil-in and oil-out hoses from the IDG.

- (2) Connect the patch filter to the IDG oil-out hose.

- (3) Connect the flushing cart to the oil-in hose and the patch filter.

NOTE: Flushing direction should be in the direction of normal oil flow.

- (4) Start the flushing procedure with a new patch filter and with the patch filter in the BY-PASS position.

- (5) Permit the system to flush for a minimum of 10 minutes.

- (6) After 10 minutes, visually examine all tube fittings to make sure no leakage has occurred.

- (7) Continue to flush the external oil system for an additional 5 minutes.

- (8) Turn the patch filter selector valve to either "PATCH FILTER A" or "PATCH FILTER B" position and continue to flush the IDG external oil system for an additional 1 minute.

- (9) Turn the patch filter selector valve to the other patch filter and check the used patch filter as follows:

- (a) Examine the patch filter for signs of visible metallic particles

- 1) All metallic particles are not permitted.

- (b) Light discoloration of the patch filter is permitted.

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QEC SYSTEM TESTS FIGURE 1

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- (10) If the patch filter is acceptable, continue on to the next step. If the patch filter is not acceptable, replace the filter and do the above steps again.

NOTE: Before you do the above steps again, make sure you clean the flush sample port to remove all previous contamination.
- (11) Take a 200 ml solvent sample downstream of the oil system and do a check for contamination using the criteria given in the Sundstrand Bulletin 627, or use one of the inspections methods given below:
 - (a) Particle Count Method
 - 1) Analyze the sample you took and use the particle limits given below for different sizes to determine if the contamination is within permitted levels:
 - a) 5 to 15 microns in size - 1,024,000 particles are permitted
 - b) 15-25 microns in size - 182,400 particles are permitted
 - c) 25-50 microns in size - 32,400 particles are permitted
 - d) 50-100 microns in size - 5,760 particles are permitted
 - e) More than 100 microns in size - 1,024 particles are permitted.
 - 2) Particle Weight Method
 - a) The total weight of the particles in the oil sample can not be more than 2.0 mg for each 100 ml.
 - (12) If the contamination is more than the limits, do the flushing procedure again. If it is not, then do the next step.
 - (13) Use nitrogen gas to purge the flushing cart hoses and to dry the IDG oil cooling circuit.
 - (14) Disconnect the flushing cart from the oil-in hose and the patch filter.
 - (15) Disconnect the patch filter from the oil-out hose.
 - (16) Connect the oil-in and oil-out hoses to the IDG.
 - (a) Use the torques given in IDG PLUMBING INSTALLATION/Figure 24-1.

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QEC SYSTEM TESTS FIGURE 1

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QEC INSPECTION/CHECK

1. General

- A. The following procedure provides general inspection limits you can use when you install new or used QEC components on the engine. This procedure should not be used by itself to determine the serviceability of a part. Rather, this procedure should be used together with your airline's existing standard practices to determine serviceability.
- B. This section is optional but may be operator policy.
- C. This inspection is applicable to Boeing QEC parts only. For parts owned by the engine manufacturer, refer to the applicable procedures in the Airplane Maintenance Manual (AMM) or Engine Shop Manual (ESM).

2. Inspection

A. Procedure

- (1) Use the guidelines below when you must make an inspection of the parts in the QEC kit:
 - (a) Bolts/screws, washers, spacers, couplings, clamps, clampshells:
 - 1) Damage is not permitted.
 - (b) Nuts:
 - 1) Damage is not permitted.
 - 2) For self-locking nuts, do a check of the self locking feature. Refer to AMM PAGEBLOCK 70-20-01/201.
 - (c) O-rings:
 - 1) O-rings should not be used again.
 - (d) Brackets:
 - 1) Cracks:
 - a) Not permitted.
 - 2) Scratches, nicks, pits, scoring:
 - a) Permitted up to 5% of the original thickness. Blend smoothly to 63Ra finish.
 - 3) Deformation:
 - a) Not permitted.
 - (e) Pneumatic ducts:
 - 1) Refer to DUCTS, REPAIR OF PNEUMATIC, THE BOEING COMPANY, CMM 36-10-03 for inspection and repair information.
 - (f) Hoses:
 - 1) Hoses that include fire shielding (hydraulic hoses):
 - a) Visually examine the hose for damage. If damage is found, refer to AMM PAGEBLOCK 20-10-52/801 for inspection and repair information.
 - b) Damage to the fire protection shielding is not permitted.
 - 2) Hoses that do not include fire shielding (IDG oil cooling hoses and pneumatic hoses):
 - a) Visually examine the hose for damage. If damage is found, refer to AMM PAGEBLOCK 20-10-52/401 for inspection and repair information.
 - (g) Tubes:

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QEC INSPECTION/CHECK FIGURE 1

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- 1) Refer to AMM PAGEBLOCK 20-10-51/801 for inspection and repair information.
- (h) Line Replaceable Units (LRU)(IDG, hydraulic pump, bleed air regulator, fire detectors, etc.):
 - 1) Refer to the applicable CMM for inspection and repair information.
- (i) Structural parts (forward and aft engine mounts, thrust links):
 - 1) Refer to the applicable CMM for inspection and repair information.
- (j) Wire Harnesses:
 - 1) For vendor wire harnesses (such as those owned by the engine manufacturer), refer to the applicable vendor CMM for inspection and repair information.
 - 2) For Boeing harnesses, refer to the Standard Wiring Practices Manual for inspection and repair information.
- (k) Aluminum foil markers:
 - 1) Refer to AMM PAGEBLOCK 20-10-21/401 for inspection and replacement information.

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QEC INSPECTION/CHECK FIGURE 1

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