



## TO 1300i-2-27JG-50-2

8. (A,C,D,E,F) Position wheel mounted crane over flap vane assembly and wrap legs of sling around the center of the vane in a choker configuration; remove slack from sling.

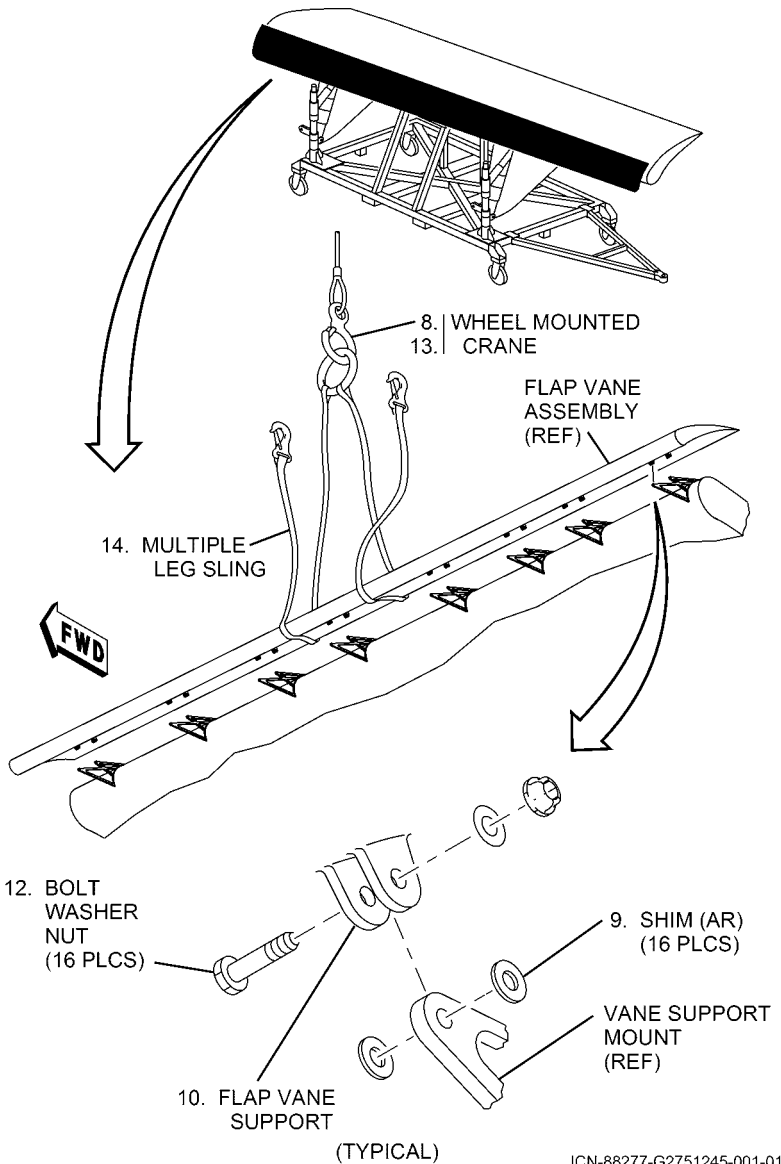
### NOTE

There shall be a maximum of three shims on each side to maintain symmetry during installation.

9. (B,D,E,F) Install shims as identified.
10. (B,D,E,F) Measure gap between flap vane support and vane support mount.
- 0.000 to 0.006 inch maximum gap.
11. Perform wet fastener installation (TO 1300i-23, Chapter 1, Section III).
12. (B,D,E,F) Install bolts, washers, and nuts as identified; torque bolts as follows:

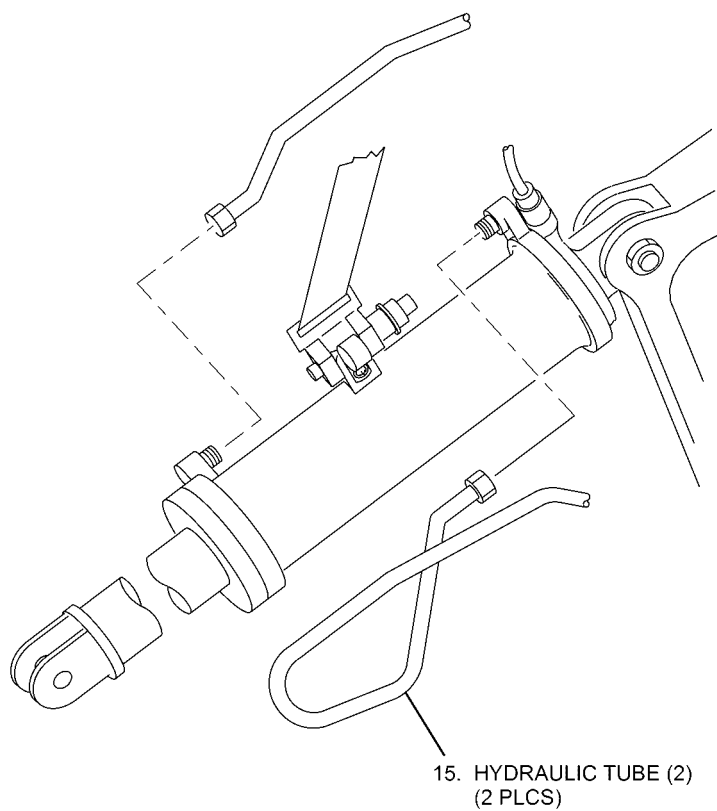
BOLT TYPE	TORQUE (in-lb)
NAS6804	50-70
NAS6805	100-140
NAS6806	160-190

13. (A,C) Operate wheel mounted crane to relieve tension; remove sling from vane.
14. (A,C) Remove multiple leg sling from wheel mounted crane.



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15. (A,B) Disconnect hydraulic tubes.

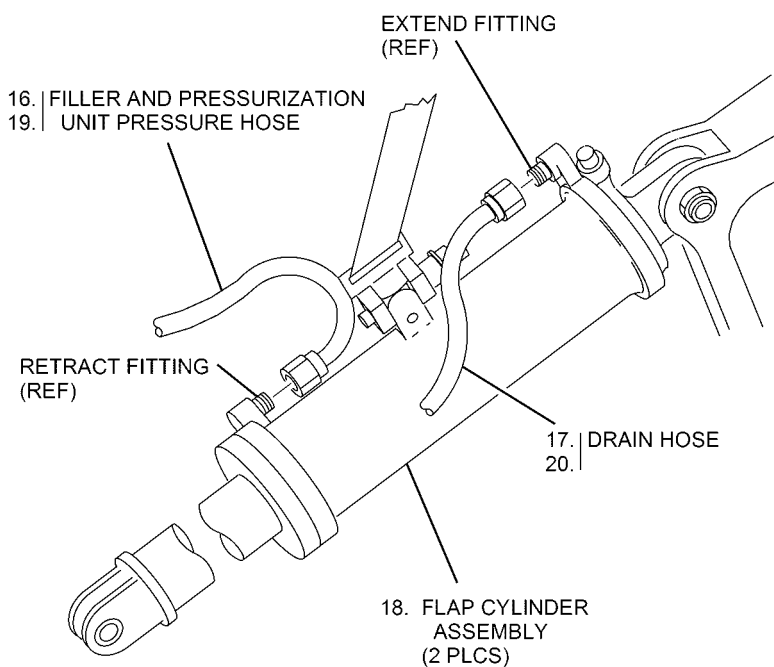


(TYPICAL)

ICN-88277-G2751246-001-01

## **TO 1300i-2-27JG-50-2**

16. (A,B) Connect filler and pressurization unit pressure hose to retract fitting of flap cylinder assemblies.
17. (A,B) Connect drain hose to extend fitting of flap cylinder assemblies.
18. (A,B) Retract flap cylinder assemblies halfway.
19. (A,B) Disconnect filler and pressurization unit pressure hose from flap cylinder assemblies.
20. (A,B) Disconnect drain hose from flap cylinder assemblies.



(TYPICAL)

ICN-88277-G2751247-001-01

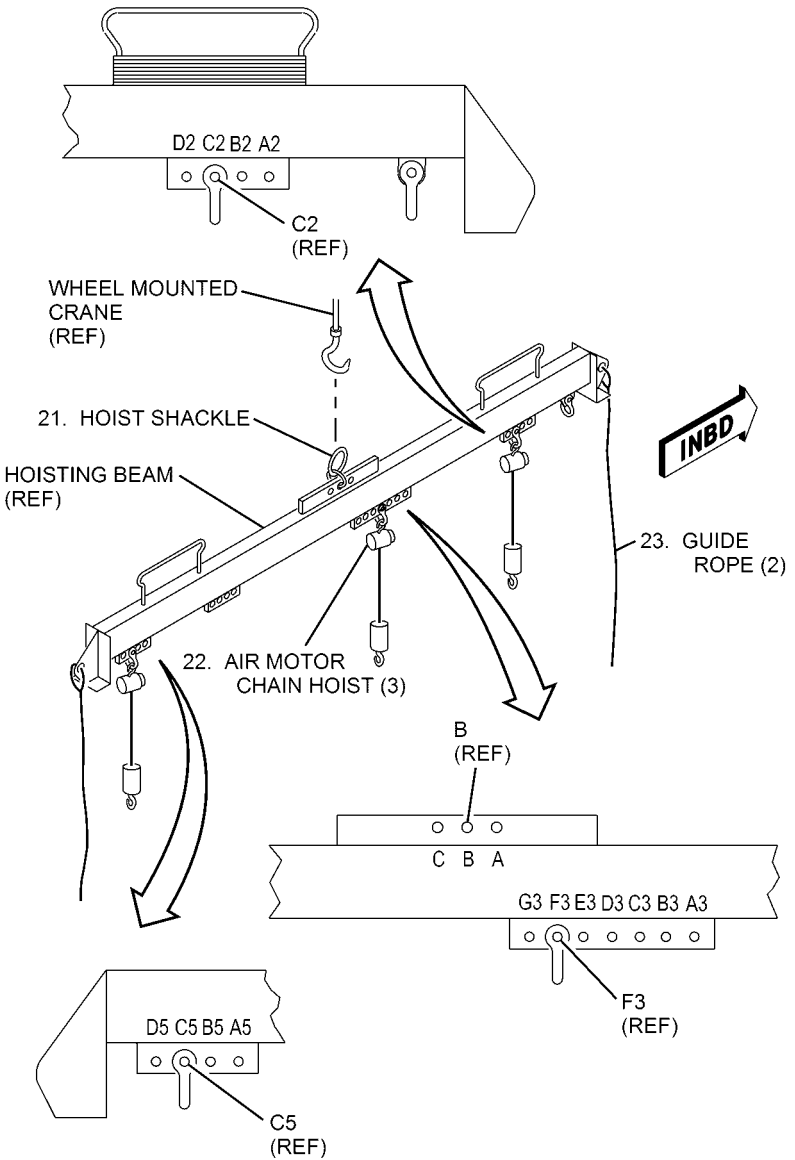
**TO 1300i-2-27JG-50-2**

- 21. (C,E,F) Attach hoist shackle to attachment B on hoisting beam and wheel mounted crane.
- 22. (C,E,F) Attach air motor chain hoists to hoisting beam as follows:

HOIST BEAM HOLE		
SECTION 2	SECTION 3	SECTION 5
C2	F3	C5

- 23. (E,F) Unwrap guide ropes from hoisting beam.



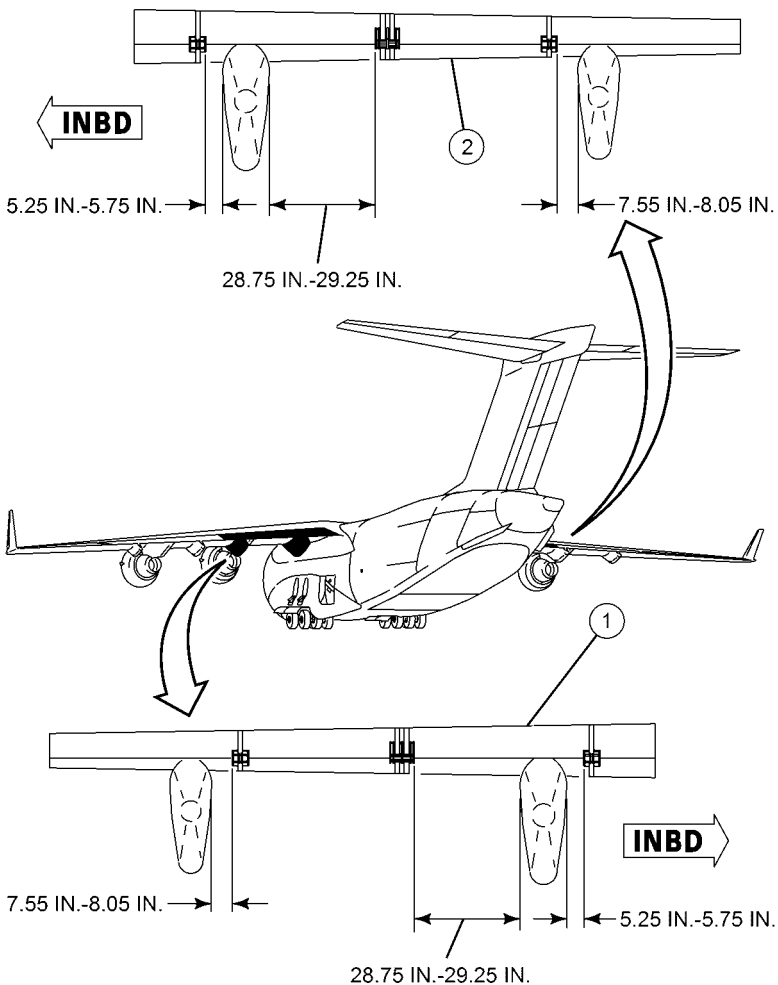


ICN-88277-G2751248-001-01

**WARNING**

Strap shall be wrapped a minimum of 2-1/2 times around the ratchet buckle drum. Failure to comply may cause injury to personnel and damage to equipment.

24. (B,D,E,F) Position adapters and tension straps from taut with a minimum of 5, maximum of 6 clicks on the ratchet buckle.



24.

FLAP REF DES	INDEX NO.	ADAPTER NO.	LOCATION	TOP STRAP (17G113482)		BOTTOM STRAP (17G113482)	
2751AA003	1	17G110482-219	INBOARD	-533		-1	
2751AA004	2	17G110482-221	OUTBOARD	-535		-1	
		17G110482-205	CENTER	-1	-1	-513	-513

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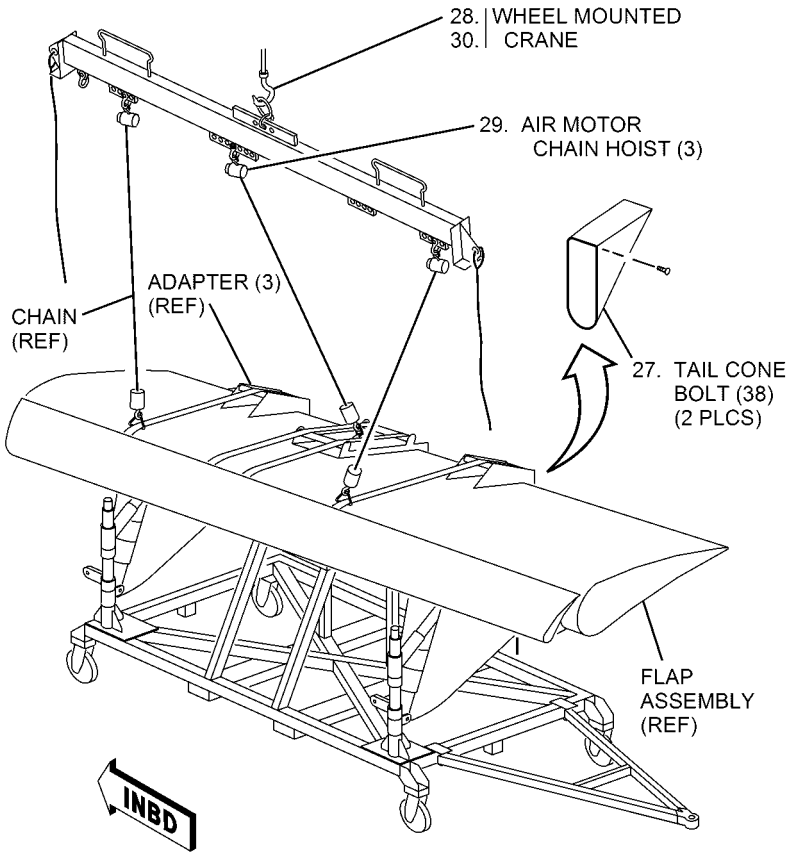
## **TO 1300i-2-27JG-50-2**

25. Perform separable faying surface sealing (TO 1300i-23, Chapter 1, Section III).
26. Perform wet fastener installation (TO 1300i-23, Chapter 1, Section III).
27. (B,D,E,F) Position tail cones; install bolts.
28. (A,C) Position wheel mounted crane over flap assembly.

### **NOTE**

Chain hoist attached to the center adapter. The inboard and outboard hoist chains are installed to the hoisting rings on the straps.

29. (A,C,E,F) Operate air motor chain hoists and attach chains to adapter and straps.
30. (A,C) Operate wheel mounted crane; remove slack from chains.



(TYPICAL)

ICN-88277-G2751250-001-01

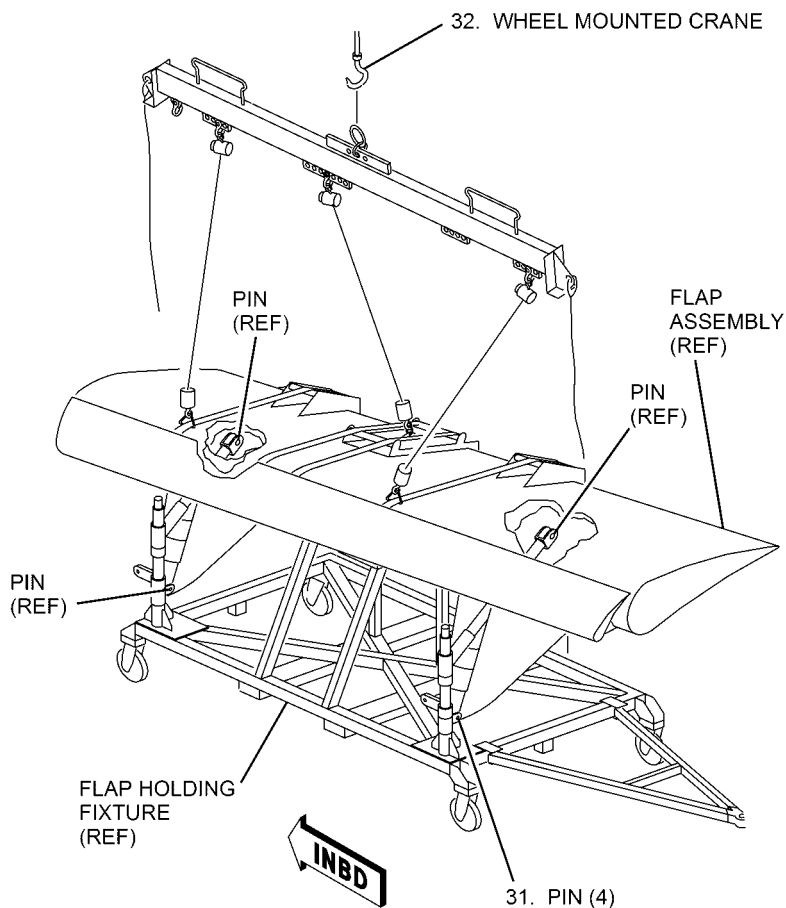
**WARNING**

Failure to comply with step 31 may cause injury to personnel and/or damage to equipment.

**NOTE**

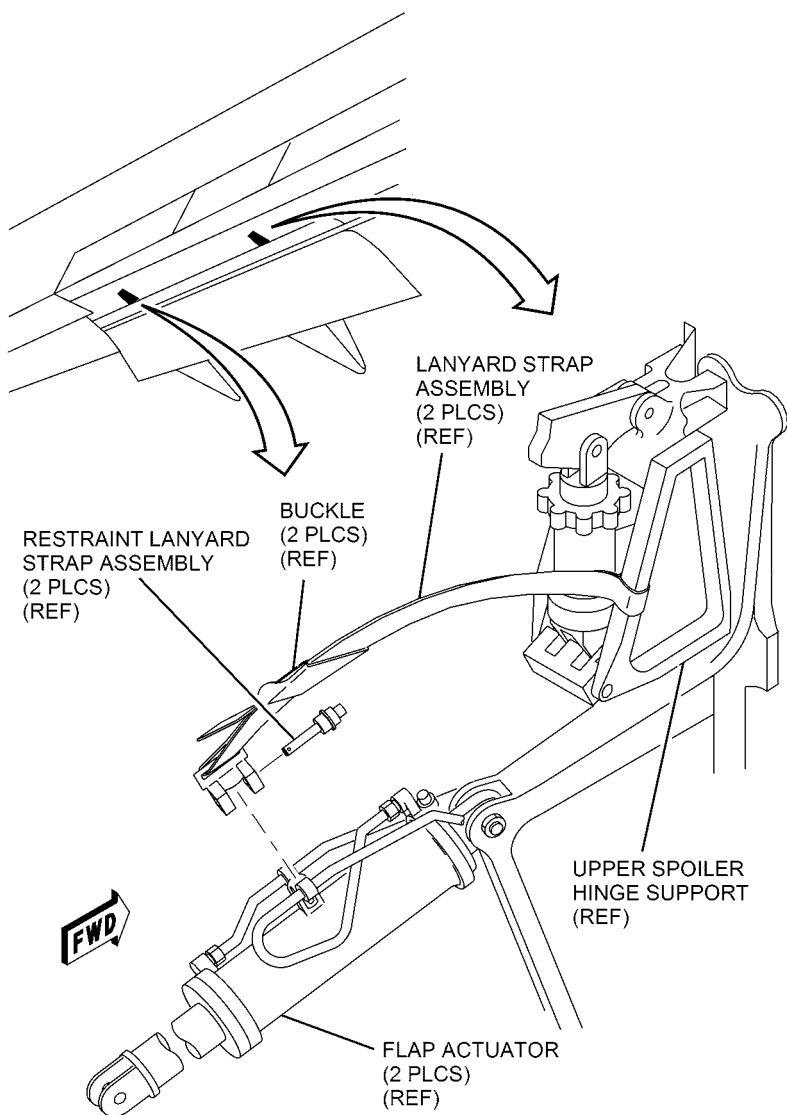
Verify the installation of the restraint lanyard strap assembly on flap actuators and positioning of the actuators prior to flap installation.

31. (E,F) Remove pins.
32. (A,B,C,D,E,F) Operate wheel mounted crane; remove flap and vane structural assembly from flap holding fixture and position for installation.



(TYPICAL)

ICN-88277-G2751251-001-01



(TYPICAL)

ICN-88277-G2751252-001-01





### 3-3. INSTALLATION.

#### **WARNING**

Flap assembly installations using the 17G110482-503 adapter set shall be temporarily halted until further notice. Hoisting adapter set 17G110482-503 contains defective 17G113482-525, 17G113482-527, 17G113482-529, and 17G113482-531 strap assemblies. Contact Boeing engineering when the upgraded 17G110482-505 adapter set is not available and flap installation is required. Failure to comply may cause injury to personnel or damage to aircraft.

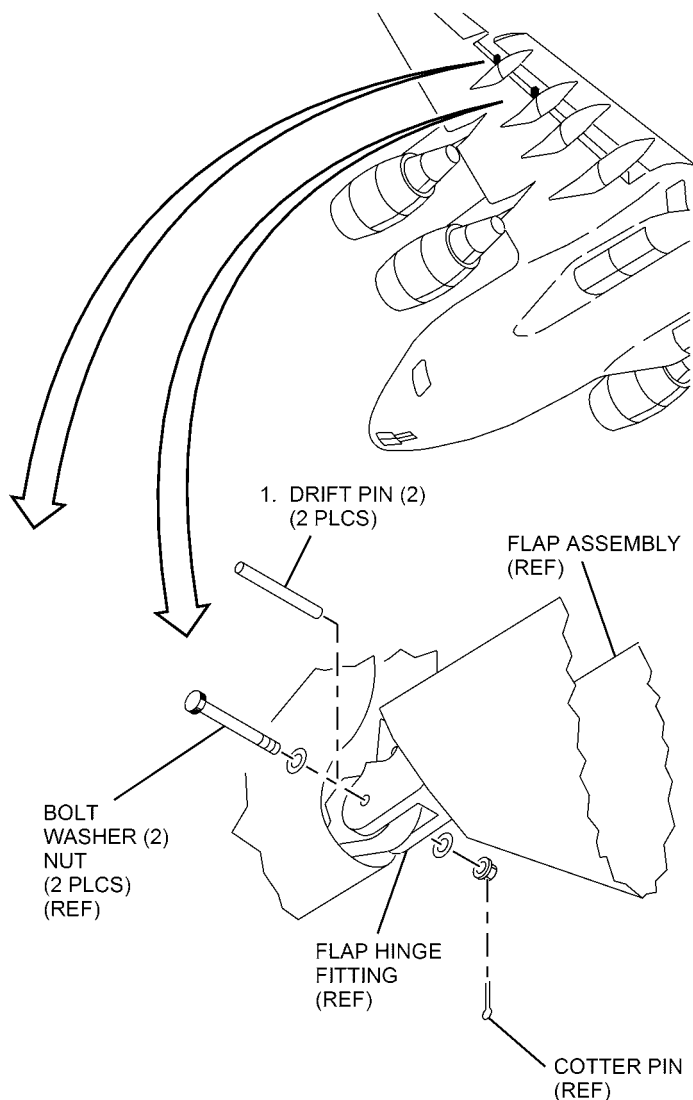
#### **CAUTION**

When both flaps are removed, the inboard flap shall be installed first. Care shall be exercised to ensure the inboard flap does not contact the fuselage. Failure to comply may cause binding condition and damage to aircraft.

#### **NOTE**

- Bolts must be installed with the bolt head out board side.
- When attaching flap and vane structural assembly, the flap shall be aligned such that there shall be no binding condition.
- When performing flap assembly installation using hoisting adapter set PN 17G110482-505, if kit is unavailable, contact Boeing engineering.

1. (A,B,C,D,E,F) Install drift pins attaching flap assembly to flap hinge fittings.



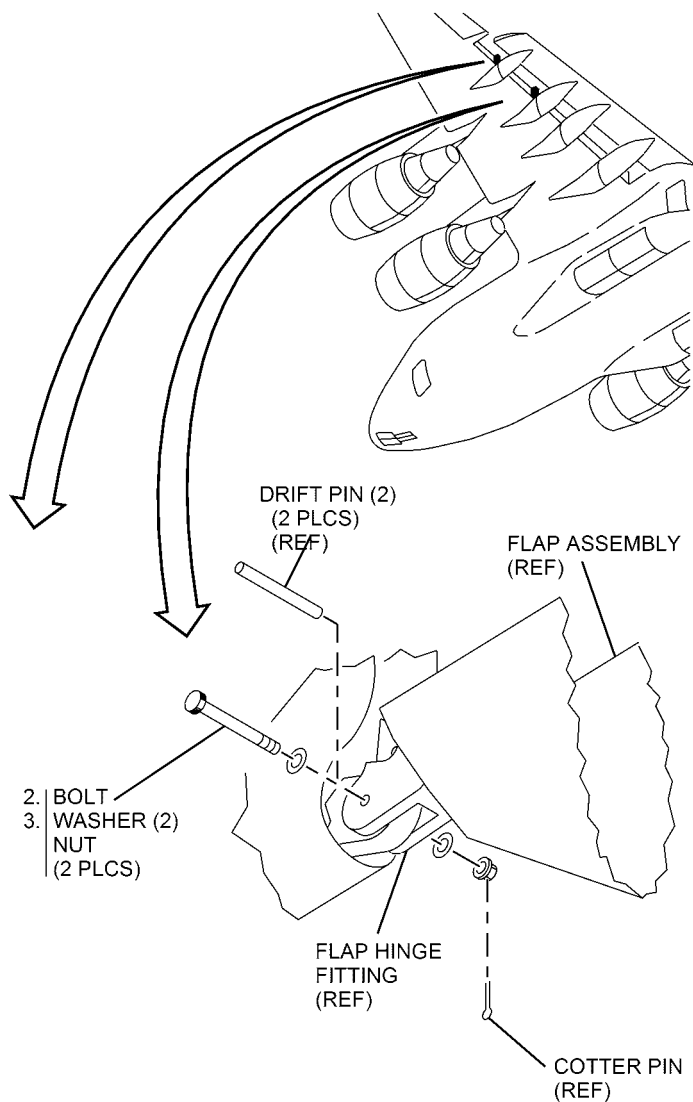
(TYPICAL)

ICN-88277-G2751085-004-01

**TO 1300i-2-27JG-50-2**

- 2. (A,B,D) Remove drift pins; install bolts, washers, and nuts.
- 3. (A,B,D) Torque bolts and install cotter pins as follows:

FLAP REF DES	SOCKET PART NO.	TORQUE (ft-lbs)	COTTER PIN
2751AA002	ANHC1719	320-690	MS24665-376
2751AA003	ANHC1721	385-1050	MS24665-377
2751AA004	ANHC1721	385-1050	MS24665-377
2751AA005	ANHC1719	320-690	MS24665-376



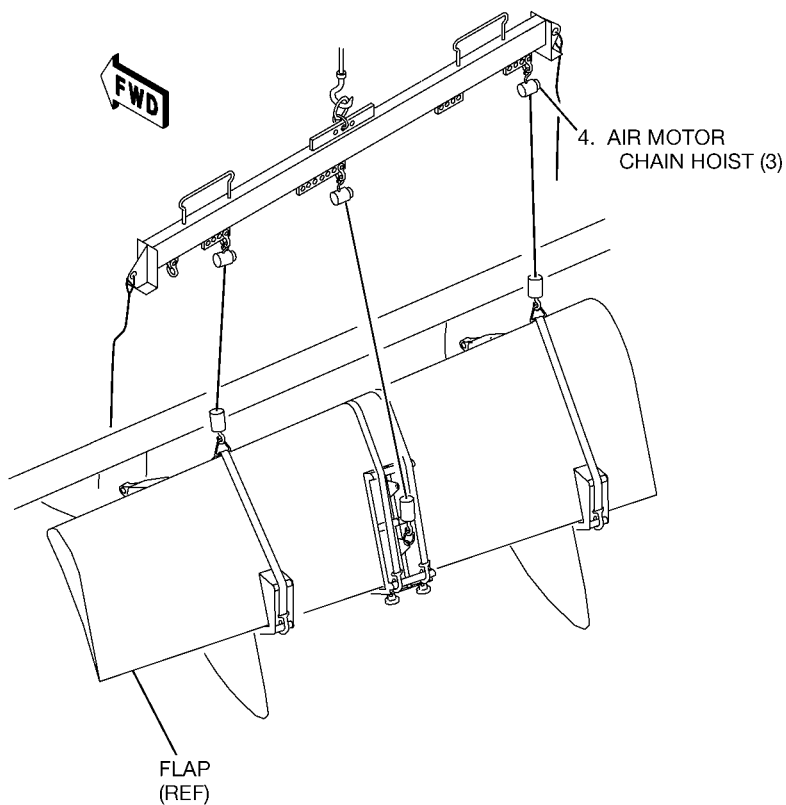
(TYPICAL)

ICN-88277-G2751291-001-01



When raising flap assembly, sudden movement may occur due to pillow seal compression between the inboard and outboard flap. Care shall be exercised to ensure both flap actuator rod ends are clear off the flap attach fittings. Failure to comply may cause damage to aircraft.

4. (A,B,D) Operate air motor chain hoists and raise flap to the horizontal position.



(TYPICAL)

ICN-88277-G2751161-003-01

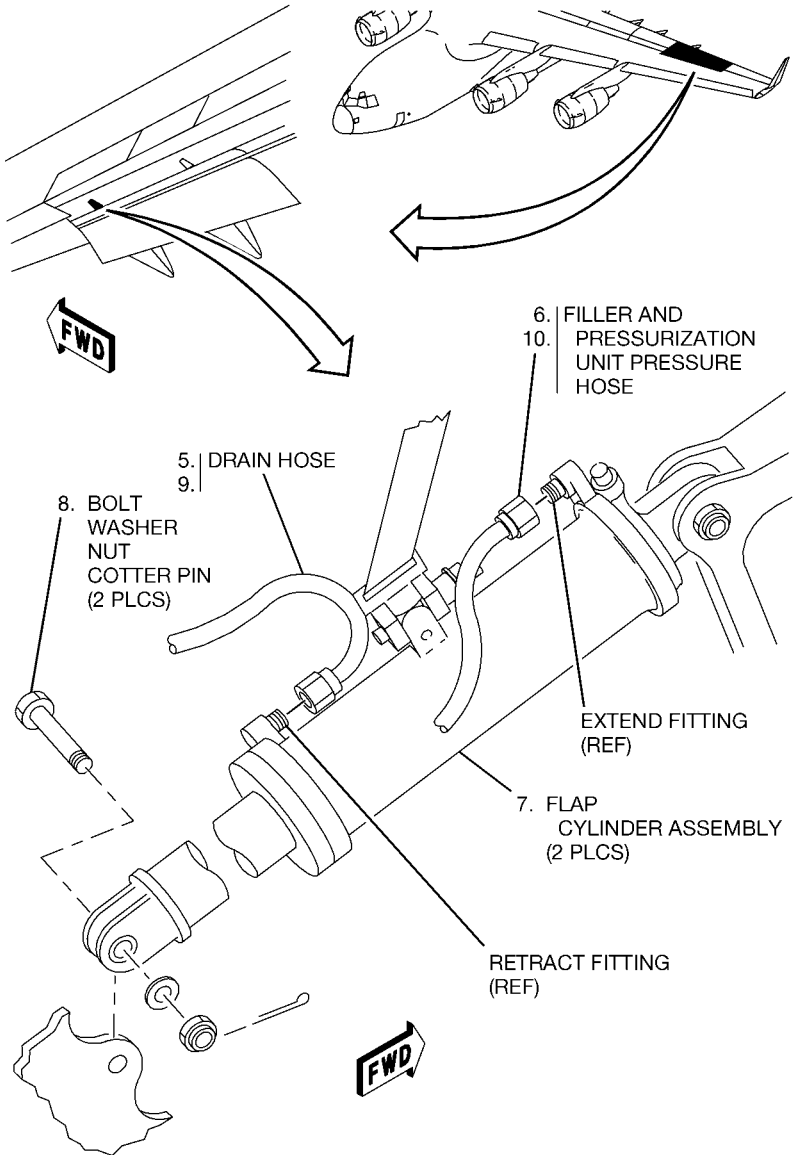
**TO 1300i-2-27JG-50-2**

- 5. (A,B) Connect drain hose to retract fitting of flap cylinder assemblies.
- 6. (A,B) Connect filler and pressurization unit pressure hose to extend fitting on flap cylinder assemblies.
- 7. (A,B) Extend flap cylinder assemblies.
- 8. (A,B) Install bolts, washers, and nuts; torque to specified torque and back off to align with the nearest cotter pin hole and install cotter pins as follows:

FLAP REF DES	TORQUE	COTTER PIN
2751AA002	20-25 ft-lbs	MS24665-377
2751AA003	25-30 ft-lbs	MS24665-378
2751AA004	25-30 ft-lbs	MS24665-378
2751AA005	20-25 ft-lbs	MS24665-377

- 9. (A,B) Disconnect drain hose from flap cylinder assemblies.
- 10. (A,B) Disconnect filler and pressurization unit pressure hose from flap cylinder assemblies.

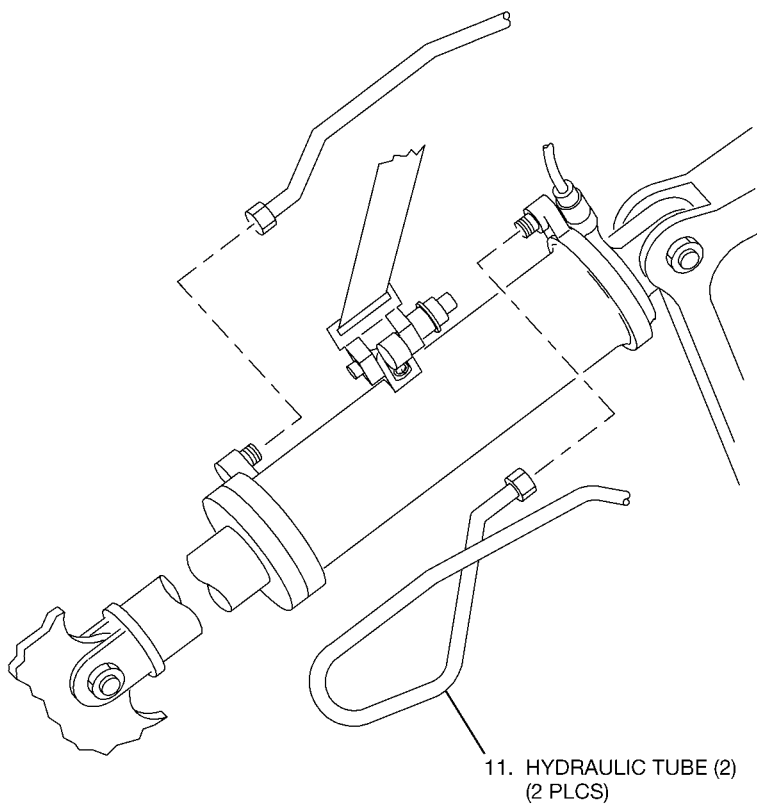




(TYPICAL)

ICN-88277-G2751088-004-01

11. (A,B) Connect hydraulic tubes and torque **215-245 in-lb.**

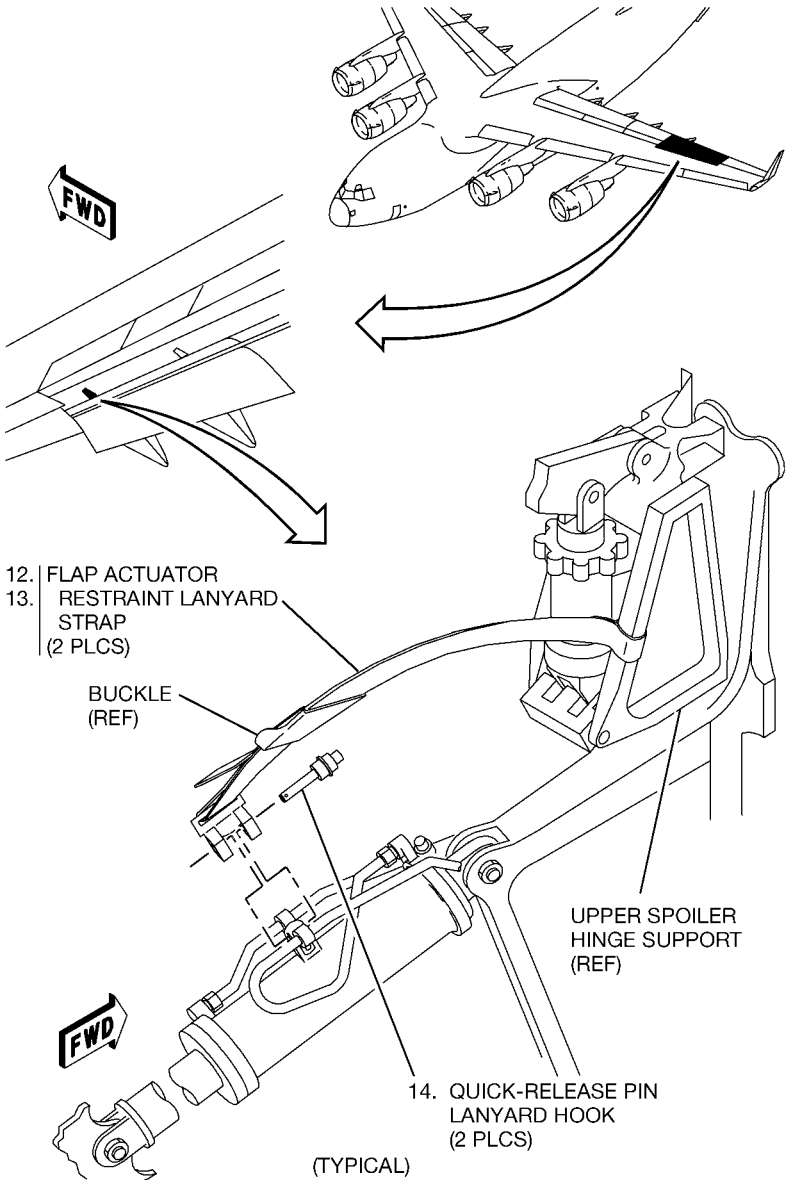


(TYPICAL)

ICN-88277-G2751089-004-01

## **TO 1300i-2-27JG-50-2**

12. (B,D) Loosen and remove flap actuator restraint lanyard straps from buckles.
13. (B,D) Unwrap straps from upper spoiler hinge supports.
14. (B,D) Remove quick-release pins and lanyard hooks.

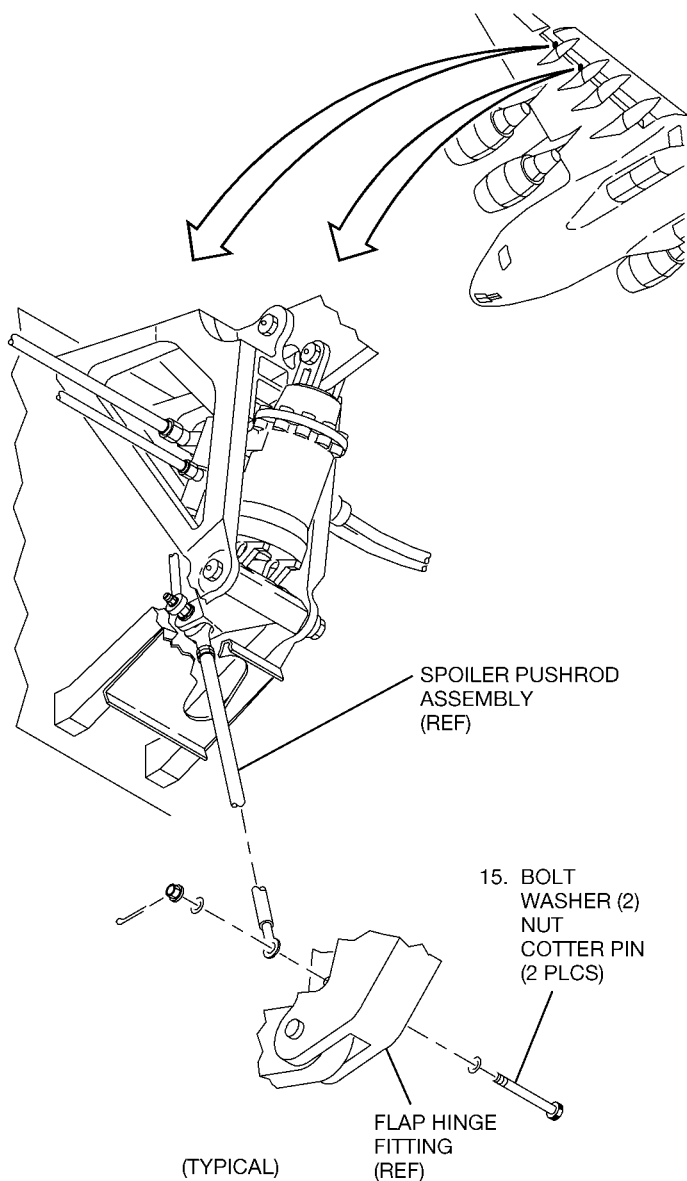


ICN-88277-G2751090-005-01

**NOTE**

- Torque nut until bushing, washer, and nut are all in contact with each other. Do not over torque nut.
- Nut maybe backed off to the nearest hole to install cotter pin (PN MS24665-309).

15. (D,E,F) Install bolts (with bolt head orientation inboard), washers, and nuts attaching spoiler pushrod assemblies to flap hinge fitting; torque bolts **1440-1512 in-lbs** and install cotter pins (PN MS24665-309).

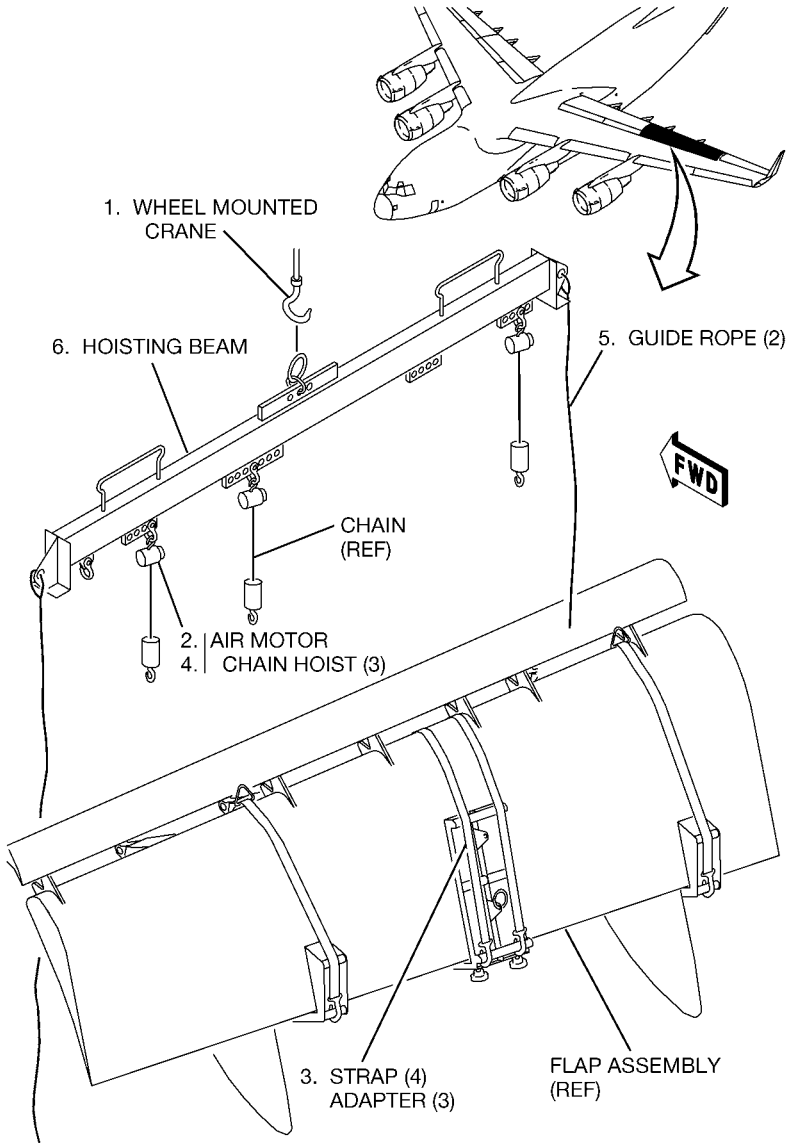


ICN-88277-G2751091-004-01

**3-4. FOLLOW-ON MAINTENANCE FOR 2751AA002  
AND 2751AA005.**

1. (A,C) Operate wheel mounted crane and slacken chains.
2. (A,B,D,E) Operate air motor chain hoists and remove chains from adapters.
3. (B,D,E,F) Loosen straps and remove adapters.
4. (B,D,E,F) Remove air motor chain hoists from hoisting beam.
5. (E,F) Wrap guide ropes on hoisting beam.
6. (B,D,E,F) Remove hoisting beam from wheel mounted crane.



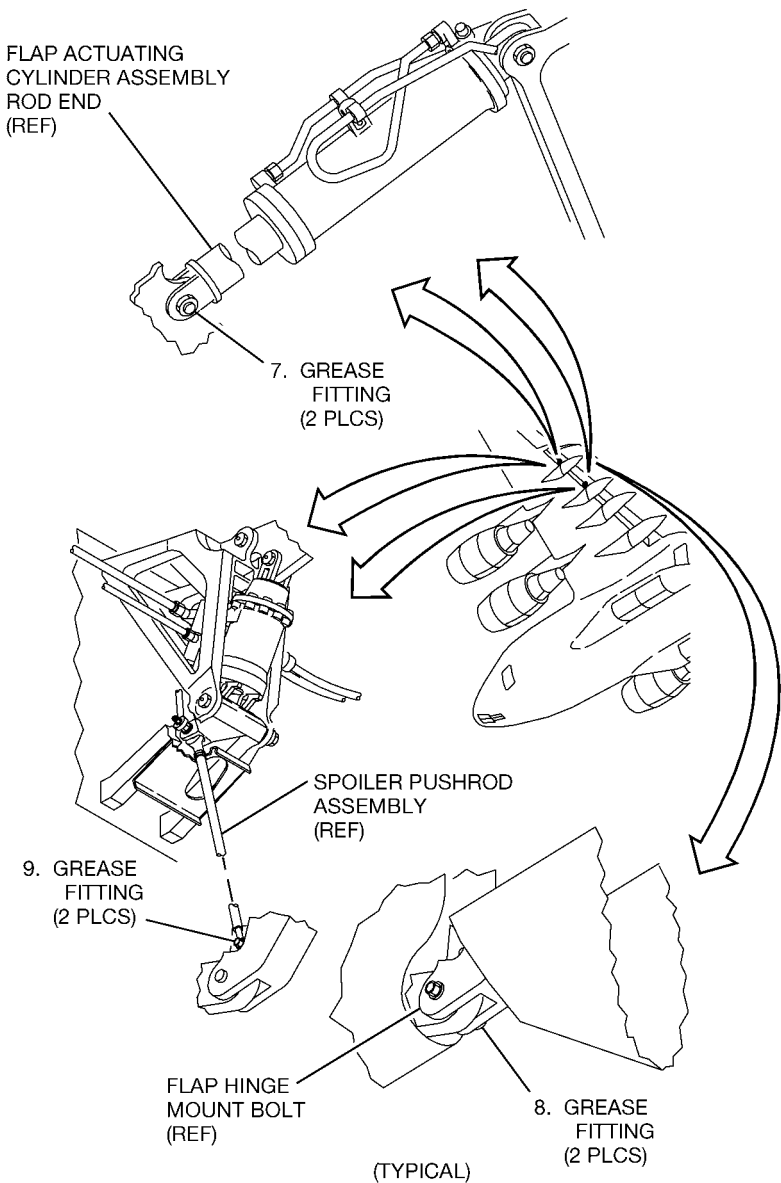


(TYPICAL)

ICN-88277-G2751092-007-01

## **TO 1300i-2-27JG-50-2**

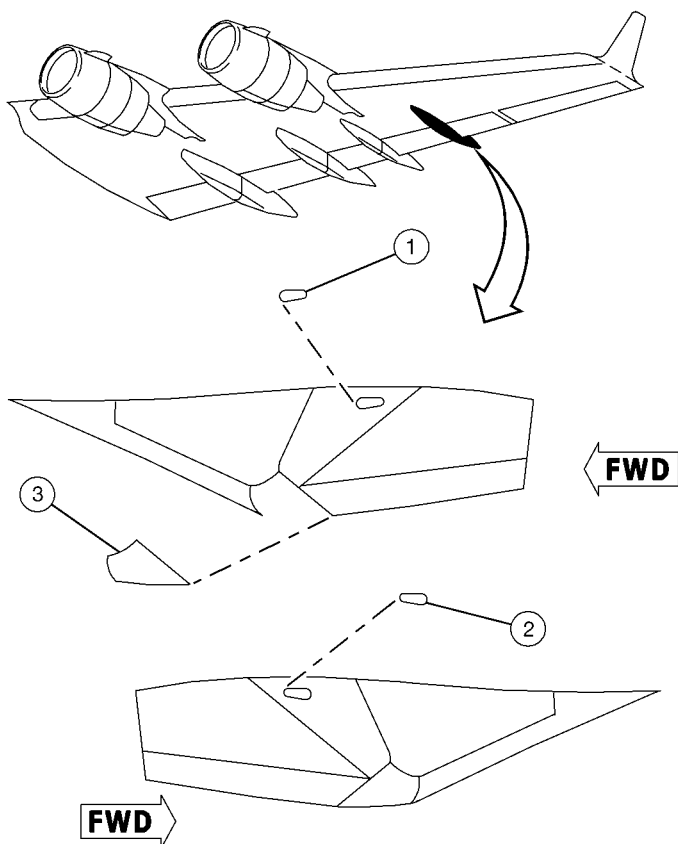
7. (A,B) Lubricate grease fittings on flap actuating cylinder assembly rod ends.
8. (A,B) Lubricate grease fittings on flap hinge mount bolts.
9. (A,B) Lubricate grease fittings on spoiler pushrod assembly.



ICN-88277-G2751093-004-01

## **TO 1300i-2-27JG-50-2**

10. (A,B) Position access panels.
11. Perform wet fastener installation (TO 1300i-23, Chapter 1, Section III).
12. (A,B) Install fasteners.
13. Perform fillet sealing (TO 1300i-23, Chapter 1, Section III).
14. (A,B) Position access covers.
15. Perform wet fastener installation (TO 1300i-23, Chapter 1, Section III).
16. (A,B) Install fasteners.

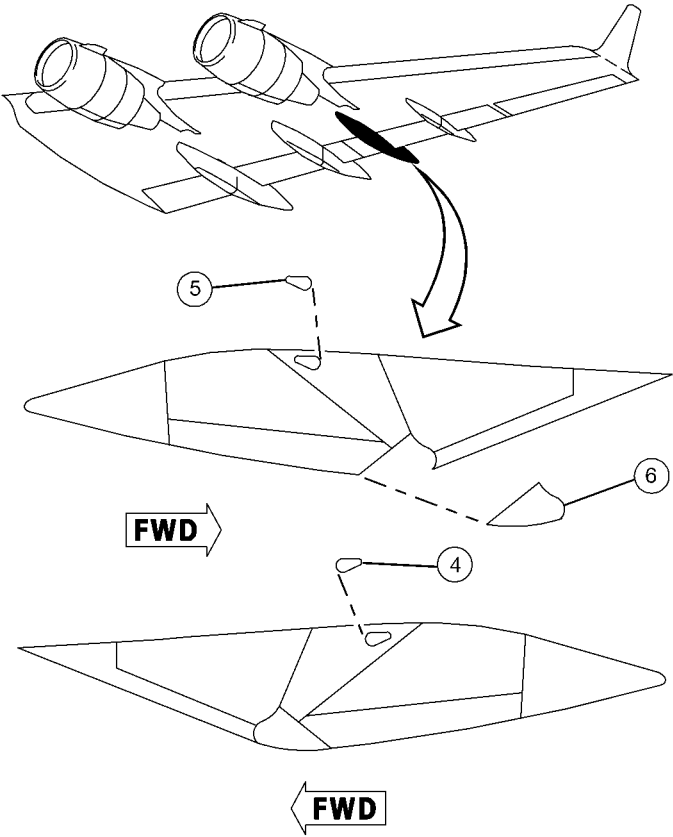


10.	FLAP REF DES	INDEX NO.	ACCESS PANEL	FASTENER QTY
12.		1	573DLC	12
	2751AA002	2	573ERC	12

14.	FLAP REF DES	INDEX NO.	ACCESS COVER	FASTENER QTY
16.		3	573FBC	16
	2751AA002			

ICN-88277-G2751069-006-01

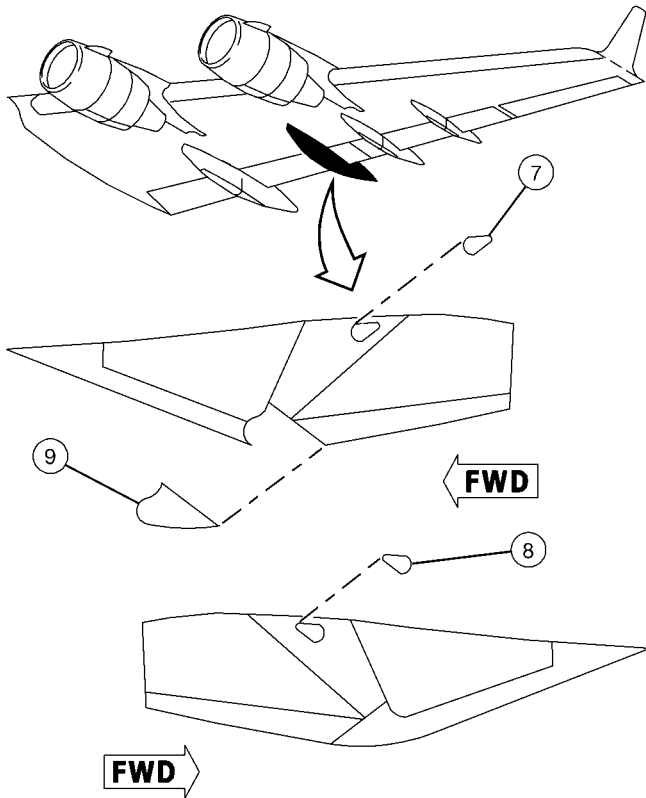


10.	FLAP REF DES	INDEX NO.	ACCESS PANEL	FASTENER QTY
12.		4	573ALC	12
	2751AA002	5	573BRC	12

14.	FLAP REF DES	INDEX NO.	ACCESS COVER	FASTENER QTY
16.		6	573CBC	17
	2751AA002			

ICN-88277-G2751068-005-01

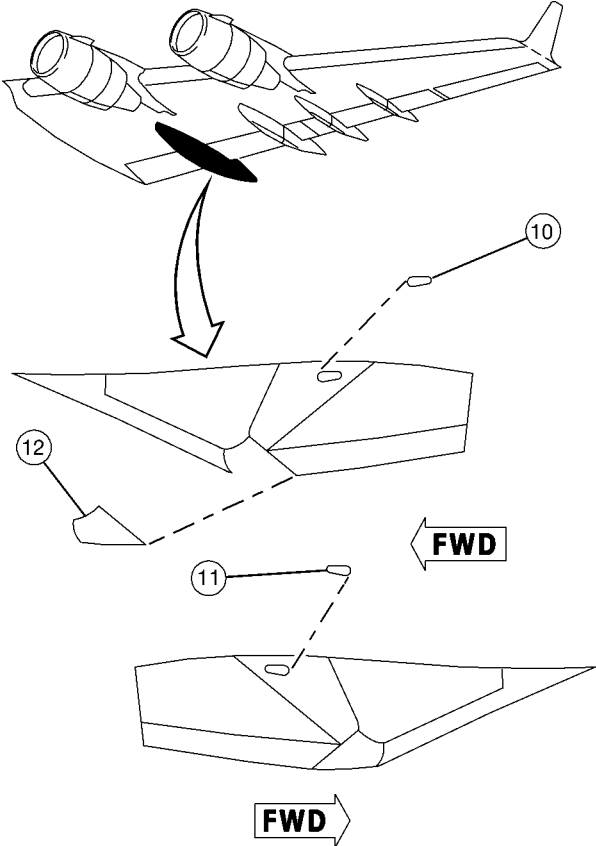


10.	FLAP REF DES	INDEX NO.	ACCESS PANEL	FASTENER QTY
12.		7	571DLC	12
	2751AA003	8	571ERC	12

14.	FLAP REF DES	INDEX NO.	ACCESS COVER	FASTENER QTY
16.		9	571FBC	18
	2751AA003			

ICN-88277-G2751067-005-01

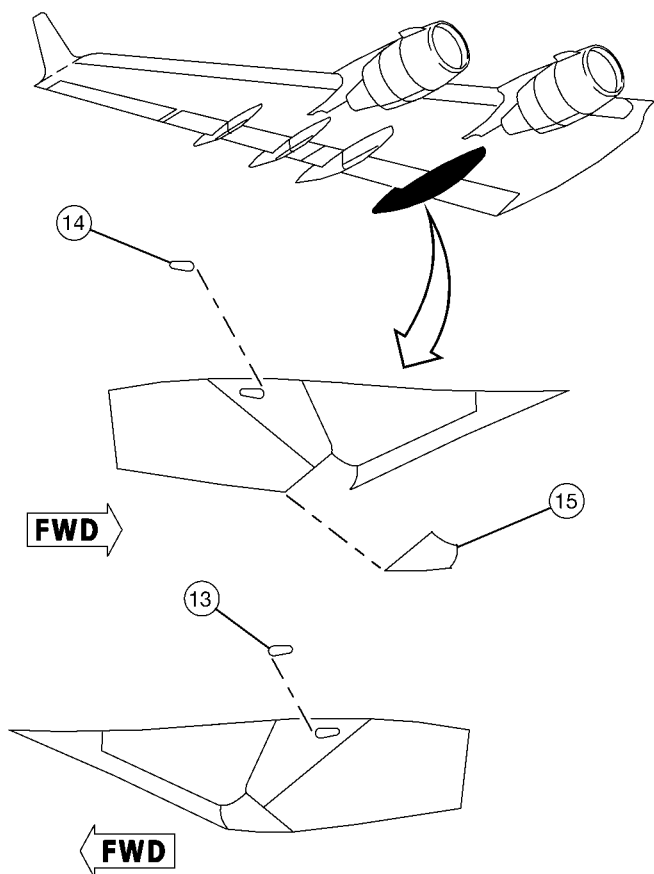


10.	FLAP REF DES	INDEX NO.	ACCESS PANEL	FASTENER QTY
12.		10	571ALC	12
	2751AA003	11	571BRC	12

14.	FLAP REF DES	INDEX NO.	ACCESS COVER	FASTENER QTY
16.		12	571CBC	23
	2751AA003			

ICN-88277-G2751066-006-01



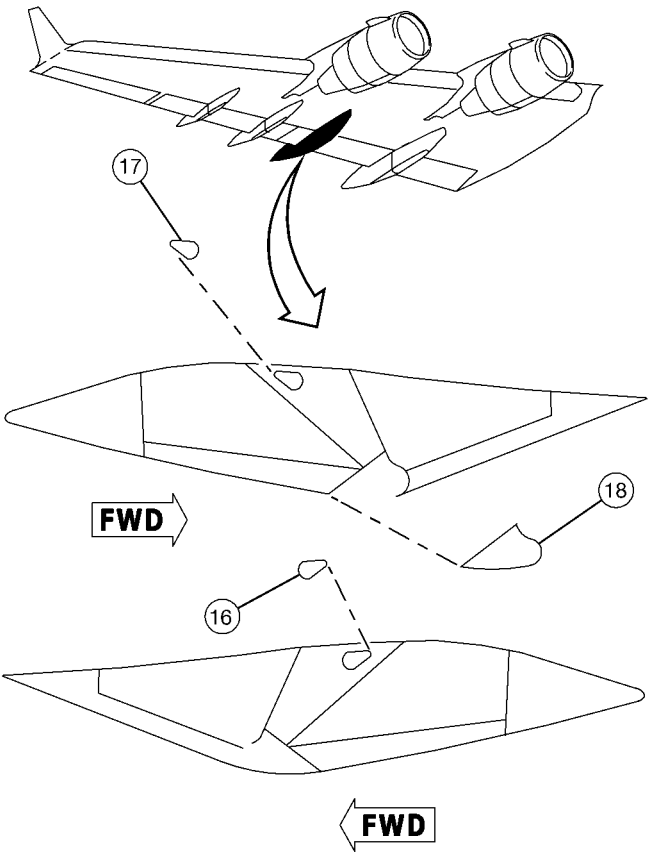


10.	FLAP REF DES	INDEX NO.	ACCESS PANEL	FASTENER QTY
12.		13	671ALC	12
	2751AA004	14	671BRC	12

14.	FLAP REF DES	INDEX NO.	ACCESS COVER	FASTENER QTY
16.		15	671CBC	23
	2751AA004			

ICN-88277-G2751004-006-01

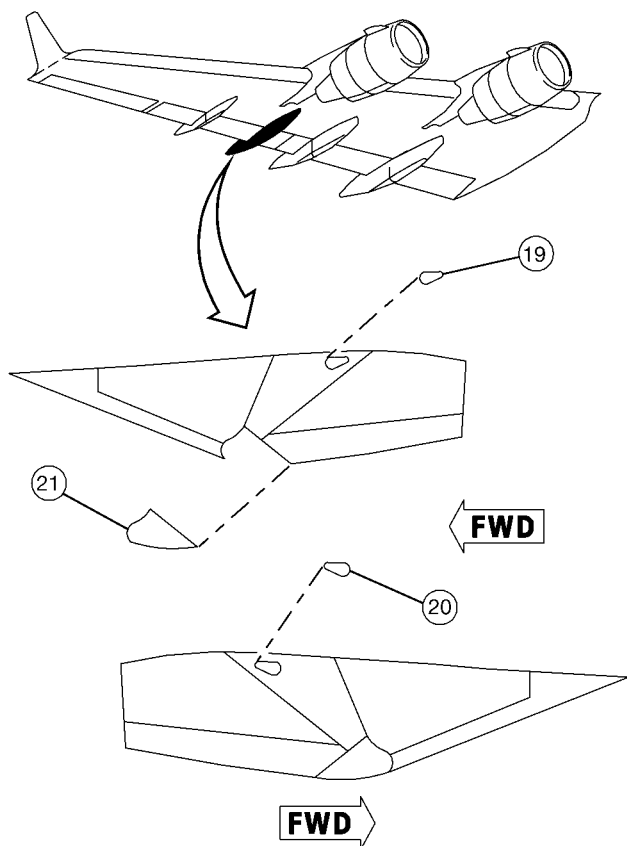


10. 12.	FLAP REF DES	INDEX NO.	ACCESS PANEL	FASTENER QTY
	2751AA004	16	671DLC	12
		17	671ERC	12

14. 16.	FLAP REF DES	INDEX NO.	ACCESS COVER	FASTENER QTY
	2751AA004	18	671FBC	18

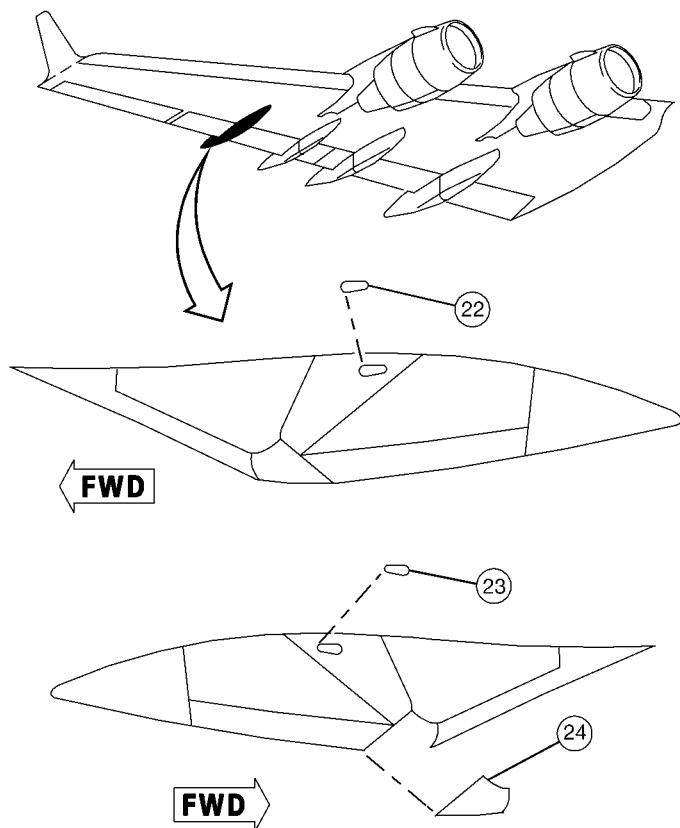
ICN-88277-G2751063-005-01



10.	FLAP REF DES	INDEX NO.	ACCESS PANEL	FASTENER QTY
12.		19	673ALC	12
	2751AA005	20	673BRC	12

14.	FLAP REF DES	INDEX NO.	ACCESS COVER	FASTENER QTY
16.		21	673CBC	17
	2751AA005			

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10.	FLAP REF DES	INDEX NO.	ACCESS PANEL	FASTENER QTY
12.		22	673DLC	12
	2751AA005	23	673ERC	12

14.	FLAP REF DES	INDEX NO.	ACCESS COVER	FASTENER QTY
16.		24	673FBC	17
	2751AA005			

ICN-88277-G2751065-006-01



- 17. (A) Remove warning tag and close **AUX HYDRAULIC PUMP 1** circuit breaker on Electrical Power Center (EPC), row **LL**, column **68**.
- 18. (A) Remove warning tag and close **AUX HYDRAULIC PUMP 4** circuit breaker on EPC row **LL**, column **10**.
- 19. Remove spoiler positioning support assembly (05-10-04) as follows:

FLAP ASSEMBLY REF DES	TASK
2751AA002 AND 2751AA005	04-5 AND 04-6
2751AA003 AND 2751AA004	04-4 AND 04-6

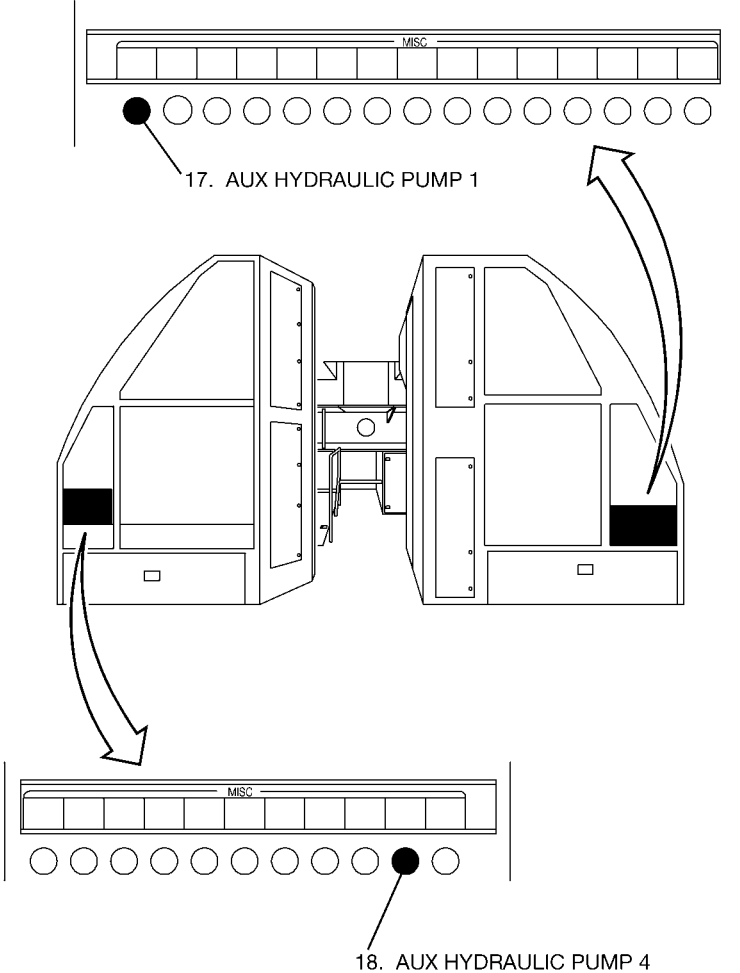
**WARNING**

All ground personnel shall be clear of flaps. Flaps will move to last commanded position. Failure to comply may cause injury to personnel and/or damage to aircraft.

**NOTE**

When performing flaps system operational checkout, flaps shall be in symmetrical position.

- 20. Perform flaps system operational checkout (27-50-01).
- 21. Perform flight controls system major rig (27-00-01, task 01-1).



**3-4A. FOLLOW-ON MAINTENANCE FOR  
2751AA002 AND 2751AA005 USING PN  
17G110482-505.**

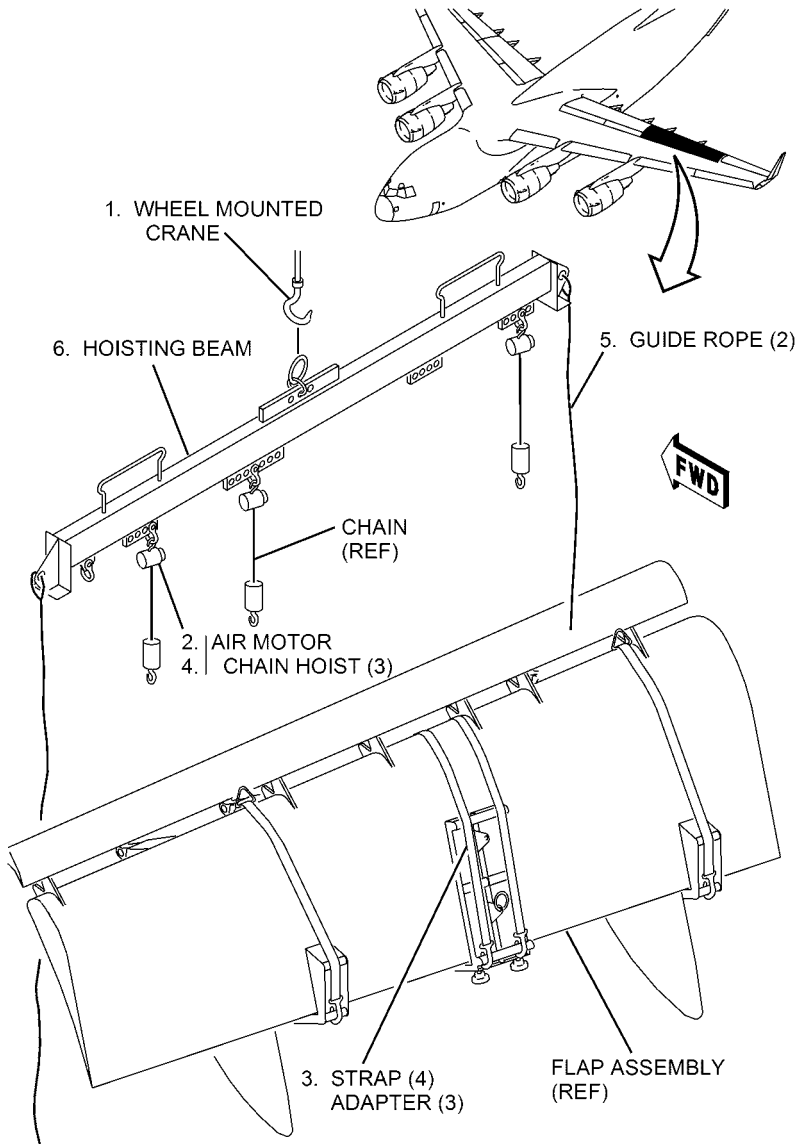
1. (A,C) Operate wheel mounted crane and slacken chains.

**NOTE**

Chain hoist attached to the center adapter. The inboard and outboard hoist chains are installed to the hoisting rings on the straps.

2. (A,B,D,E) Operate air motor chain hoists and remove chains from adapter and straps.
3. (B,D,E,F) Loosen straps and remove adapters.
4. (B,D,E,F) Remove air motor chain hoists from hoisting beam.
5. (E,F) Wrap guide ropes on hoisting beam.
6. (B,D,E,F) Remove hoisting beam from wheel mounted crane.



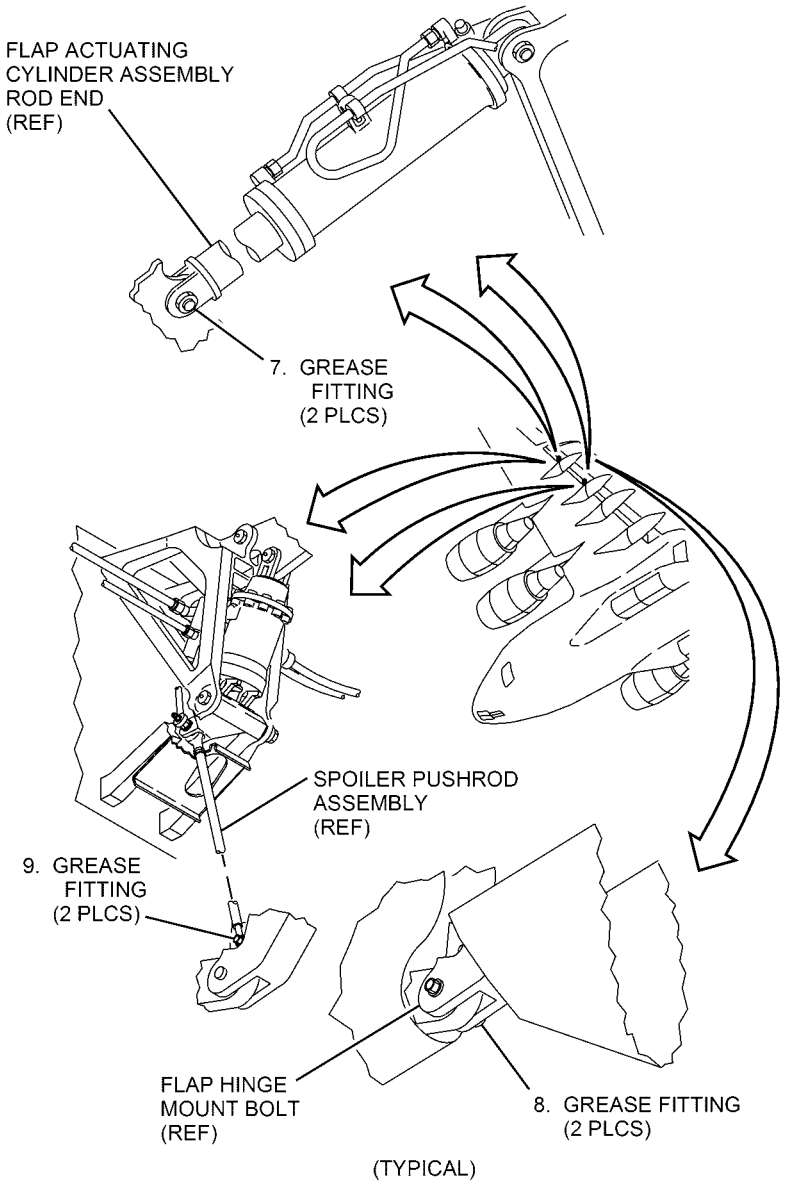


(TYPICAL)

ICN-88277-G2751253-001-01

## **TO 1300i-2-27JG-50-2**

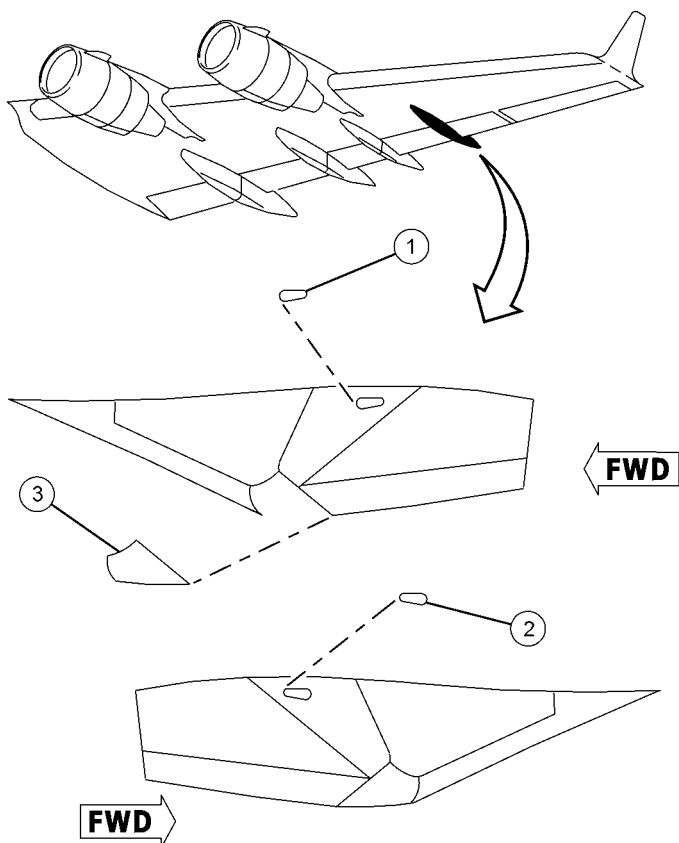
7. (A,B) Lubricate grease fittings on flap actuating cylinder assembly rod ends.
8. (A,B) Lubricate grease fittings on flap hinge mount bolts.
9. (A,B) Lubricate grease fittings on spoiler pushrod assembly.



ICN-88277-G2751254-001-01

## **TO 1300i-2-27JG-50-2**

10. (A,B) Position access panels.
11. Perform wet fastener installation (TO 1300i-23, Chapter 1, Section III).
12. (A,B) Install fasteners.
13. Perform fillet sealing (TO 1300i-23, Chapter 1, Section III).
14. (A,B) Position access covers.
15. Perform wet fastener installation (TO 1300i-23, Chapter 1, Section III).
16. (A,B) Install fasteners.

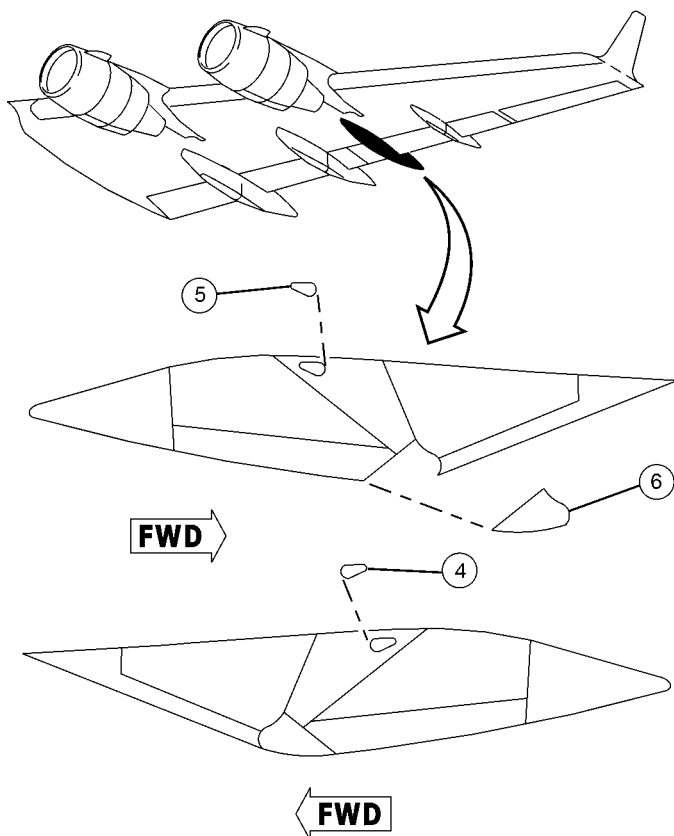


10.	FLAP REF DES	INDEX NO.	ACCESS PANEL	FASTENER QTY
12.		1	573DLC	12
	2751AA002	2	573ERC	12

14.	FLAP REF DES	INDEX NO.	ACCESS COVER	FASTENER QTY
16.		3	573FBC	16
	2751AA002			

ICN-88277-G2751255-001-01

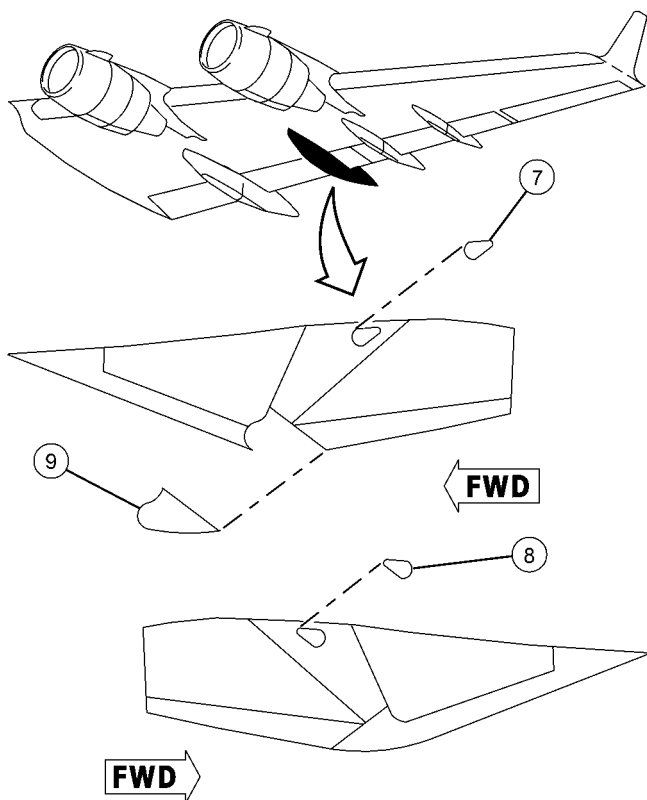


10.	FLAP REF DES	INDEX NO.	ACCESS PANEL	FASTENER QTY
12.		4	573ALC	12
	2751AA002	5	573BRC	12

14.	FLAP REF DES	INDEX NO.	ACCESS COVER	FASTENER QTY
16.		6	573CBC	17
	2751AA002			

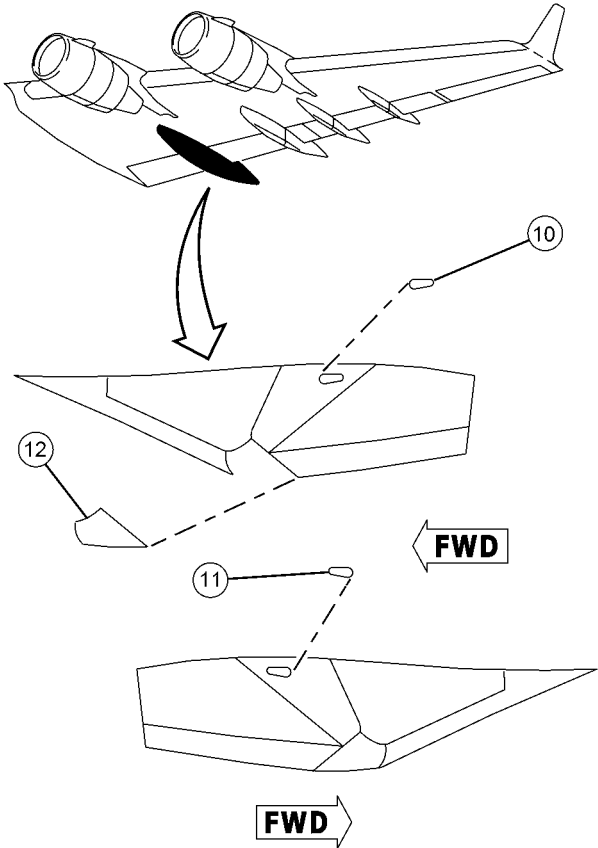
ICN-88277-G2751256-001-01



10.	FLAP REF DES	INDEX NO.	ACCESS PANEL	FASTENER QTY
12.	2751AA003	7	571DLC	12
		8	571ERC	12

14.	FLAP REF DES	INDEX NO.	ACCESS COVER	FASTENER QTY
16.	2751AA003	9	571FBC	18

ICN-88277-G2751257-001-01



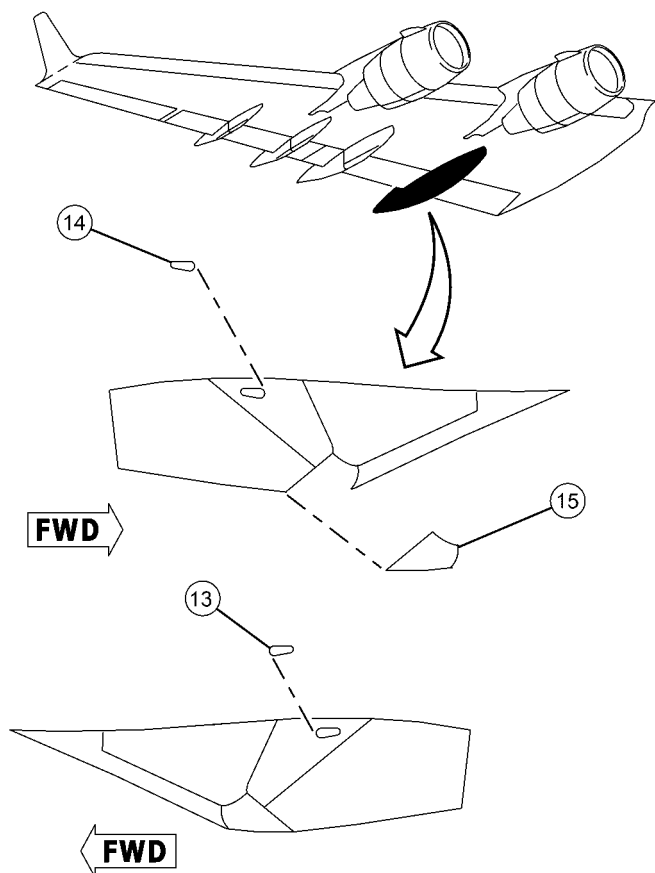
10.	FLAP REF DES	INDEX NO.	ACCESS PANEL	FASTENER QTY
12.		10	571ALC	12
	2751AA003	11	571BRC	12

14.	FLAP REF DES	INDEX NO.	ACCESS COVER	FASTENER QTY
16.		12	571CBC	23
	2751AA003			

ICN-88277-G2751258-001-01

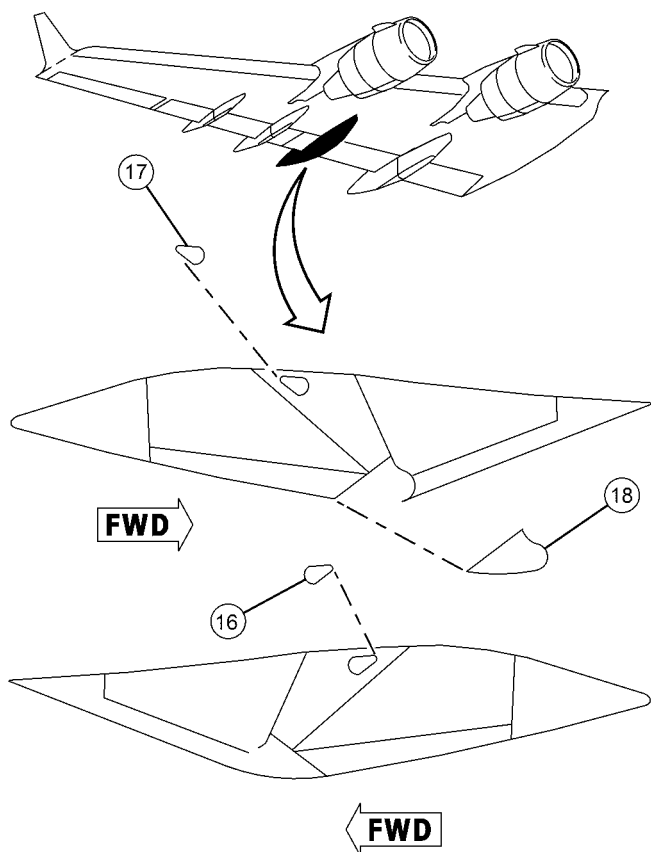




10.	FLAP REF DES	INDEX NO.	ACCESS PANEL	FASTENER QTY
12.	2751AA004	13	671ALC	12
		14	671BRC	12

14.	FLAP REF DES	INDEX NO.	ACCESS COVER	FASTENER QTY
16.	2751AA004	15	671CBC	23

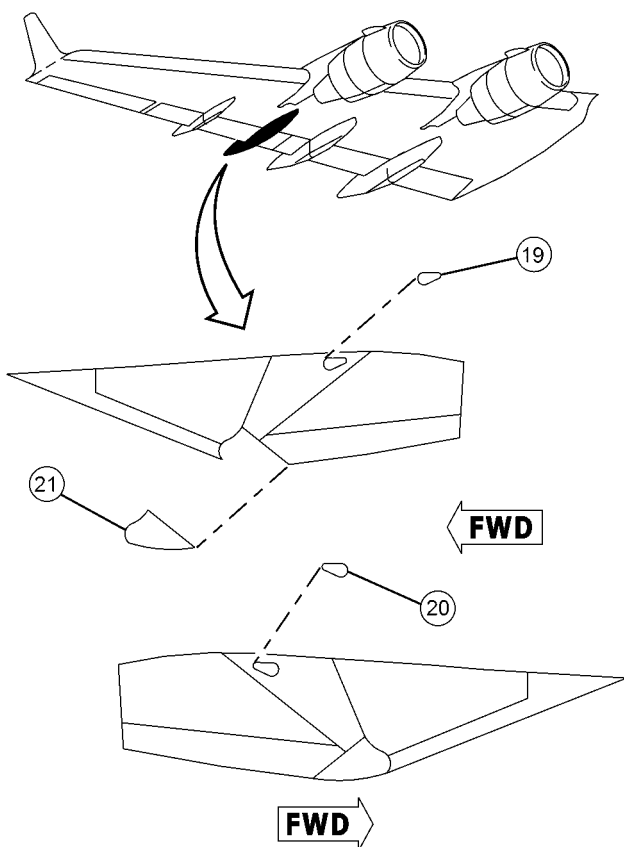
ICN-88277-G2751259-001-01



10.	FLAP REF DES	INDEX NO.	ACCESS PANEL	FASTENER QTY
12.		16	671DLC	12
	2751AA004	17	671ERC	12

14.	FLAP REF DES	INDEX NO.	ACCESS COVER	FASTENER QTY
16.		18	671FBC	18
	2751AA004			

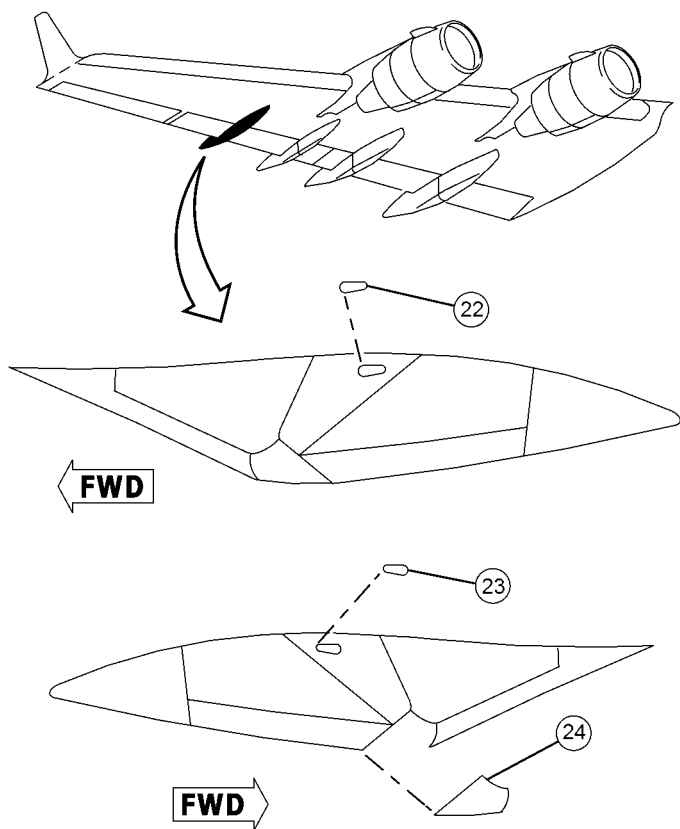
ICN-88277-G2751260-001-01



10.	FLAP REF DES	INDEX NO.	ACCESS PANEL	FASTENER QTY
12.	2751AA005	19	673ALC	12
		20	673BRC	12

14.	FLAP REF DES	INDEX NO.	ACCESS COVER	FASTENER QTY
16.	2751AA005	21	673CBC	17

ICN-88277-G2751261-001-01



10.	FLAP REF DES	INDEX NO.	ACCESS PANEL	FASTENER QTY
12.	2751AA005	22	673DLC	12
		23	673ERC	12

14.	FLAP REF DES	INDEX NO.	ACCESS COVER	FASTENER QTY
16.	2751AA005	24	673FBC	17

ICN-88277-G2751262-001-01



- 17. (A) Remove warning tag and close **AUX HYDRAULIC PUMP 1** circuit breaker on Electrical Power Center (EPC), row **LL**, column **68**.
- 18. (A) Remove warning tag and close **AUX HYDRAULIC PUMP 4** circuit breaker on EPC row **LL**, column **10**.
- 19. Remove spoiler positioning support assembly (05-10-04) as follows:

FLAP ASSEMBLY REF DES	TASK
2751AA002 AND 2751AA005	04-5 AND 04-6
2751AA003 AND 2751AA004	04-4 AND 04-6

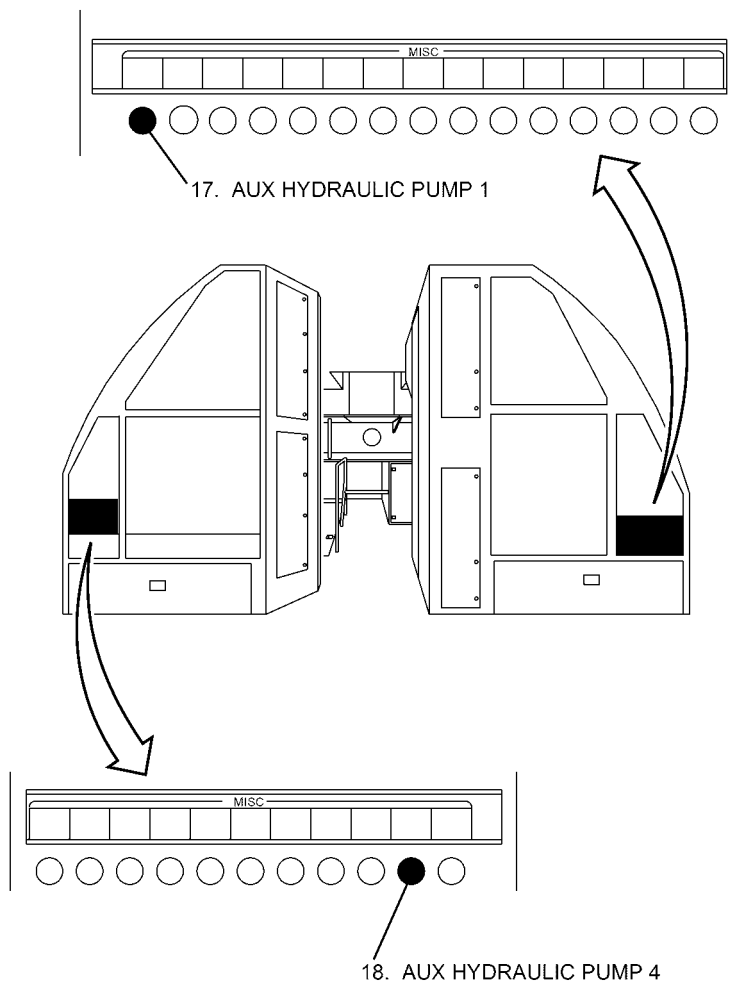
**WARNING**

All ground personnel shall be clear of flaps. Flaps will move to last commanded position. Failure to comply may cause injury to personnel and/or damage to aircraft.

**NOTE**

When performing flaps system operational checkout, flaps shall be in symmetrical position.

- 20. Perform flaps system operational checkout (27-50-01).
- 21. Perform flight controls system major rig (27-00-01, task 01-1).

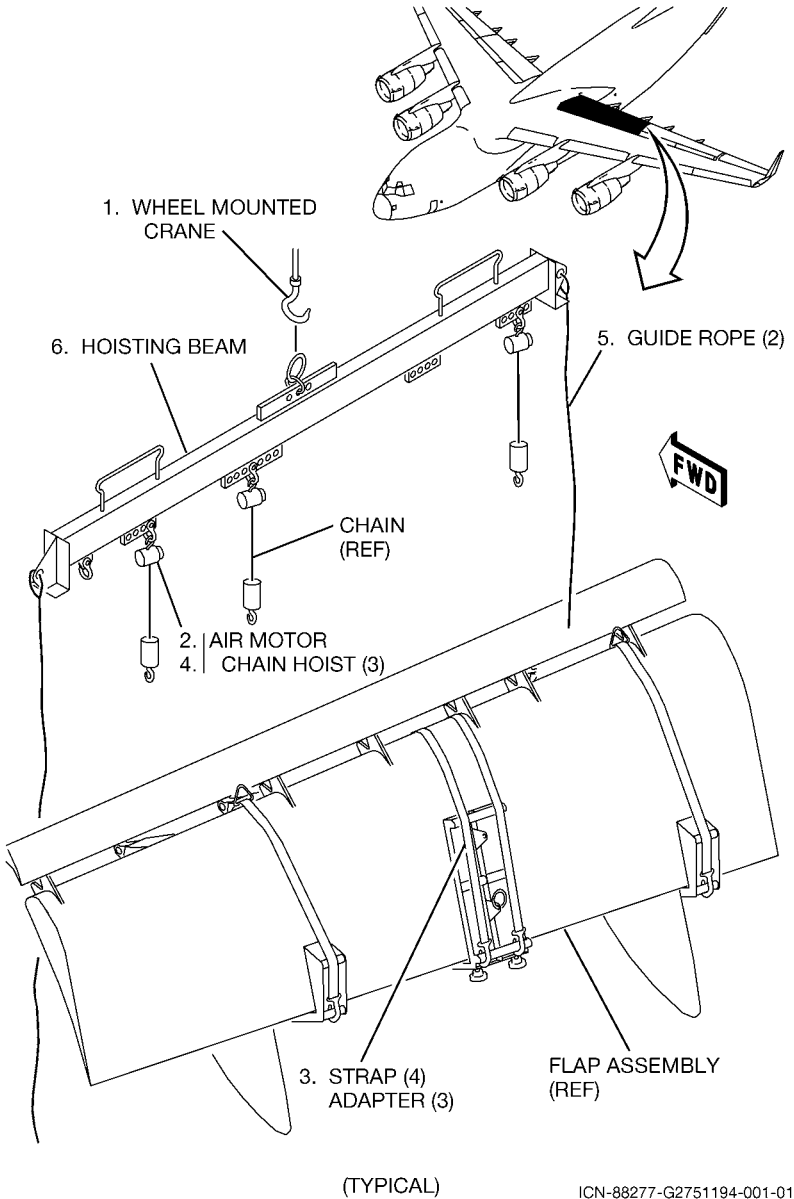


ICN-88277-G2751263-001-01

**3-5. FOLLOW-ON MAINTENANCE FOR 2751AA003  
AND 2751AA004.**

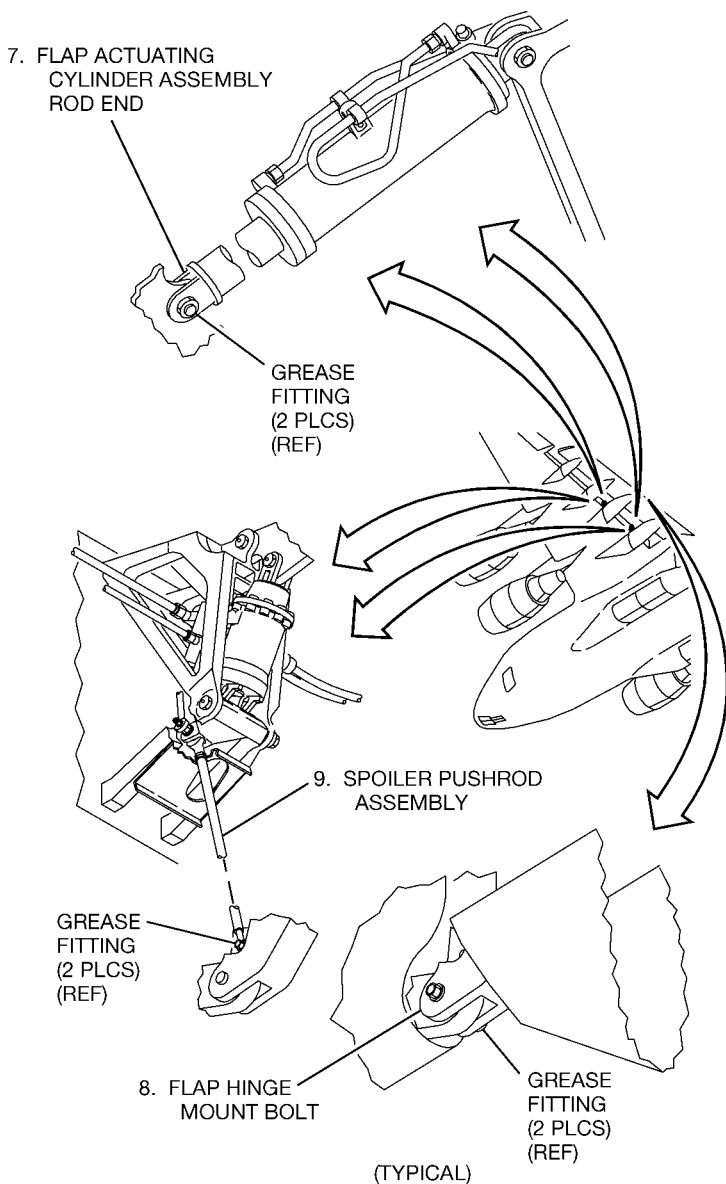
1. (A,C) Operate wheel mounted crane and slacken chains.
2. (A,B,D,E) Operate air motor chain hoists and remove chains from adapters.
3. (B,D,E,F) Loosen straps and remove adapters.
4. (B,D,E,F) Remove air motor chain hoists from hoisting beam.
5. (E,F) Wrap guide ropes on hoisting beam.
6. (B,D,E,F) Remove hoisting beam from wheel mounted crane.





## **TO 1300i-2-27JG-50-2**

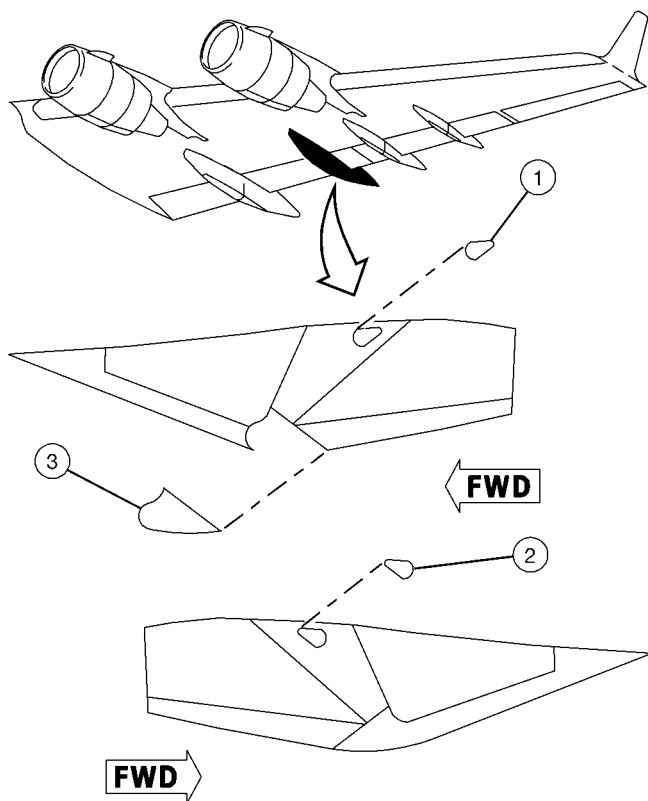
7. (A,B) Lubricate grease fittings on flap actuating cylinder assembly rod ends.
8. (A,B) Lubricate grease fittings on flap hinge mount bolts.
9. (A,B) Lubricate grease fittings on spoiler pushrod assembly.



ICN-88277-G2751195-002-01

## **TO 1300i-2-27JG-50-2**

10. (A,B) Position access panels.
11. Perform wet fastener installation (TO 1300i-23, Chapter 1, Section III).
12. (A,B) Install fasteners.
13. Perform fillet sealing (TO 1300i-23, Chapter 1, Section III).
14. (A,B) Position access covers.
15. Perform wet fastener installation (TO 1300i-23, Chapter 1, Section III).
16. (A,B) Install fasteners.

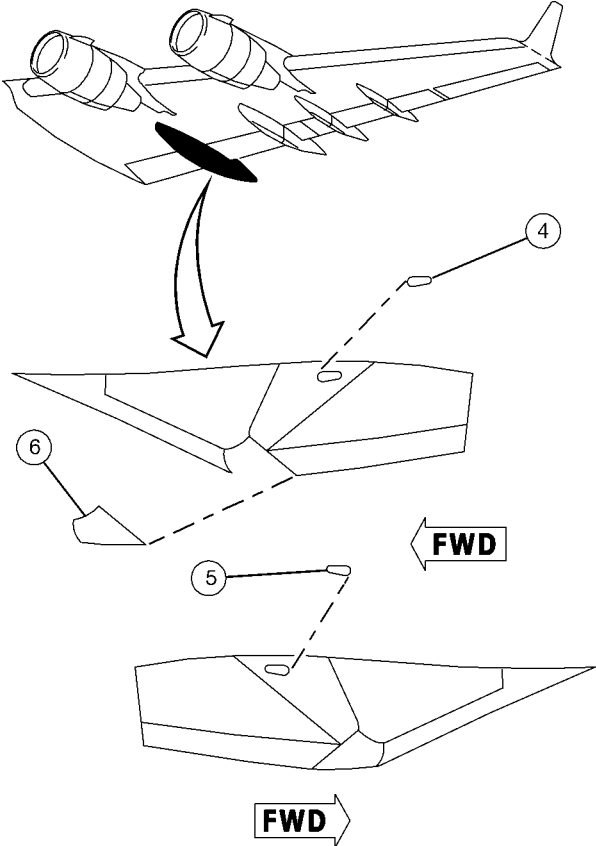


10.	12.	FLAP REF DES	INDEX NO.	ACCESS PANEL	FASTENER QTY
			1	571DLC	12
		2751AA003	2	571ERC	12

14.	16.	FLAP REF DES	INDEX NO.	ACCESS COVER	FASTENER QTY
			3	571FBC	18
		2751AA003			

ICN-88277-G2751205-001-01

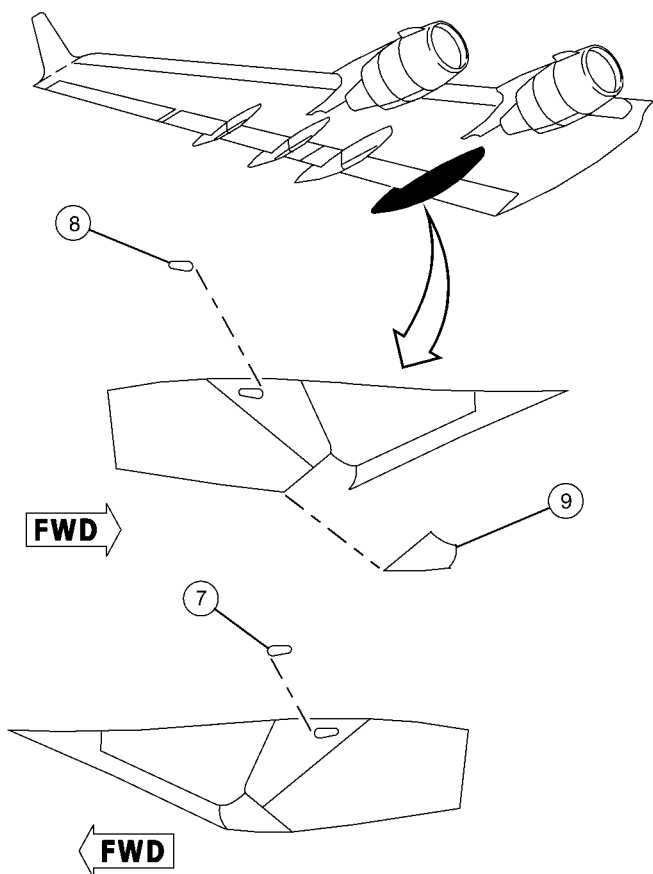


10.	FLAP REF DES	INDEX NO.	ACCESS PANEL	FASTENER QTY
12.		4	571ALC	12
	2751AA003	5	571BRC	12

14.	FLAP REF DES	INDEX NO.	ACCESS COVER	FASTENER QTY
16.		6	571CBC	23
	2751AA003			

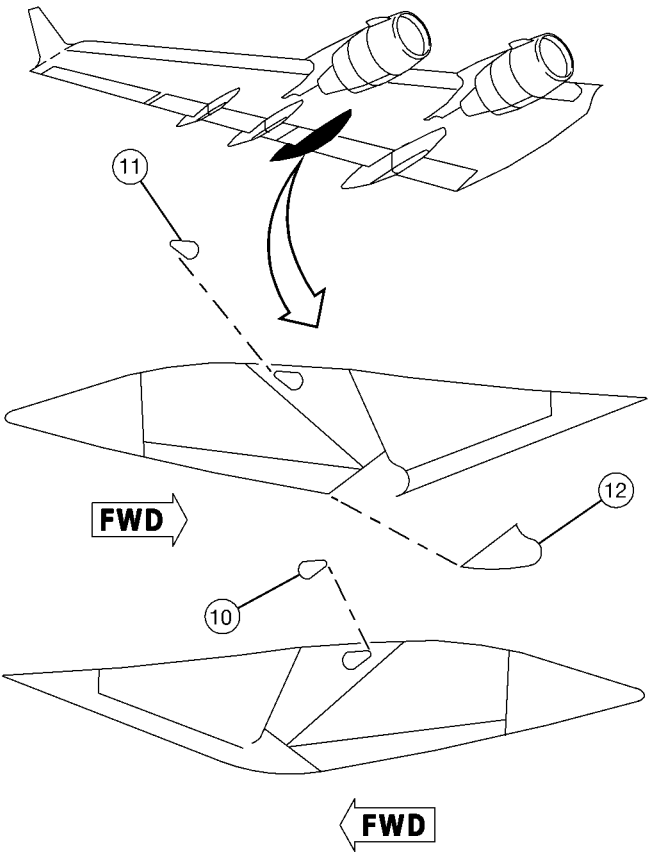
ICN-88277-G2751206-001-01



10.	FLAP REF DES	INDEX NO.	ACCESS PANEL	FASTENER QTY
12.		7	671ALC	12
	2751AA004	8	671BRC	12

14.	FLAP REF DES	INDEX NO.	ACCESS COVER	FASTENER QTY
16.		9	671CBC	23
	2751AA004			

ICN-88277-G2751207-001-01



10.	FLAP REF DES	INDEX NO.	ACCESS PANEL	FASTENER QTY
12.		10	671DLC	12
	2751AA004	11	671ERC	12

14.	FLAP REF DES	INDEX NO.	ACCESS COVER	FASTENER QTY
16.		12	671FBC	18
	2751AA004			

ICN-88277-G2751208-001-01





17. (A) Remove warning tag and close **AUX HYDRAULIC PUMP 1** circuit breaker on Electrical Power Center (EPC), row **LL**, column **68**.
18. (A) Remove warning tag and close **AUX HYDRAULIC PUMP 4** circuit breaker on EPC row **LL**, column **10**.
19. Remove spoiler positioning support assembly (05-10-04, tasks 04-4 and 04-6).

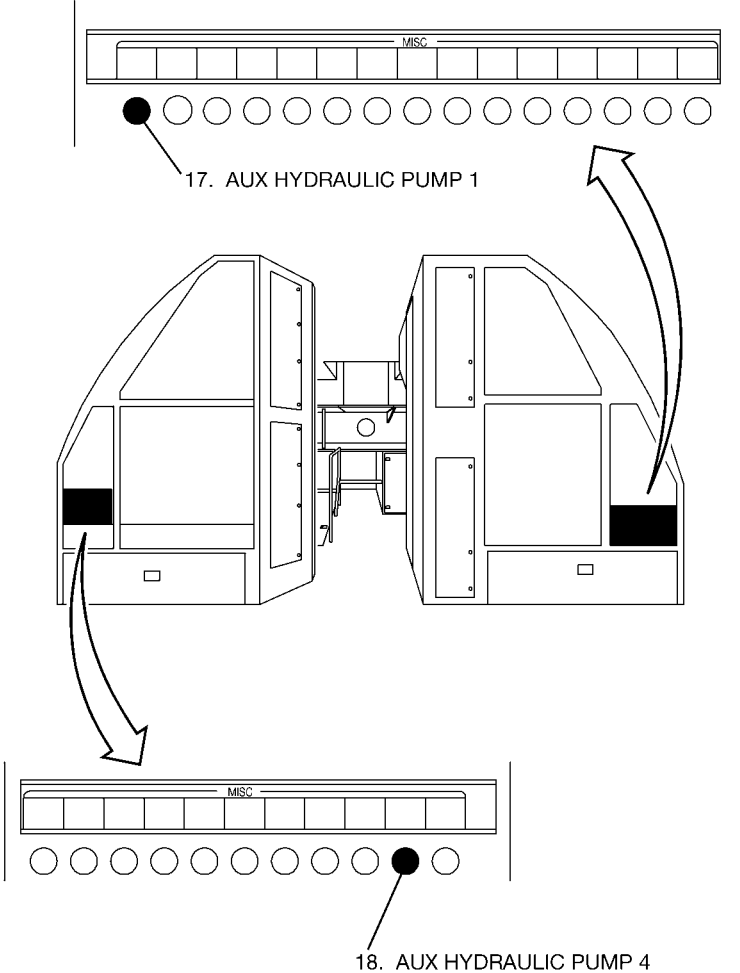
<b>WARNING</b>
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All ground personnel shall be clear of flaps. Flaps will move to last commanded position. Failure to comply may cause injury to personnel and/or damage to aircraft.

**NOTE**

When performing flaps system operational checkout, flaps shall be in symmetrical position.

20. Perform flaps system operational checkout (27-50-01).
21. Perform flight controls system major rig (27-00-01, task 01-1).

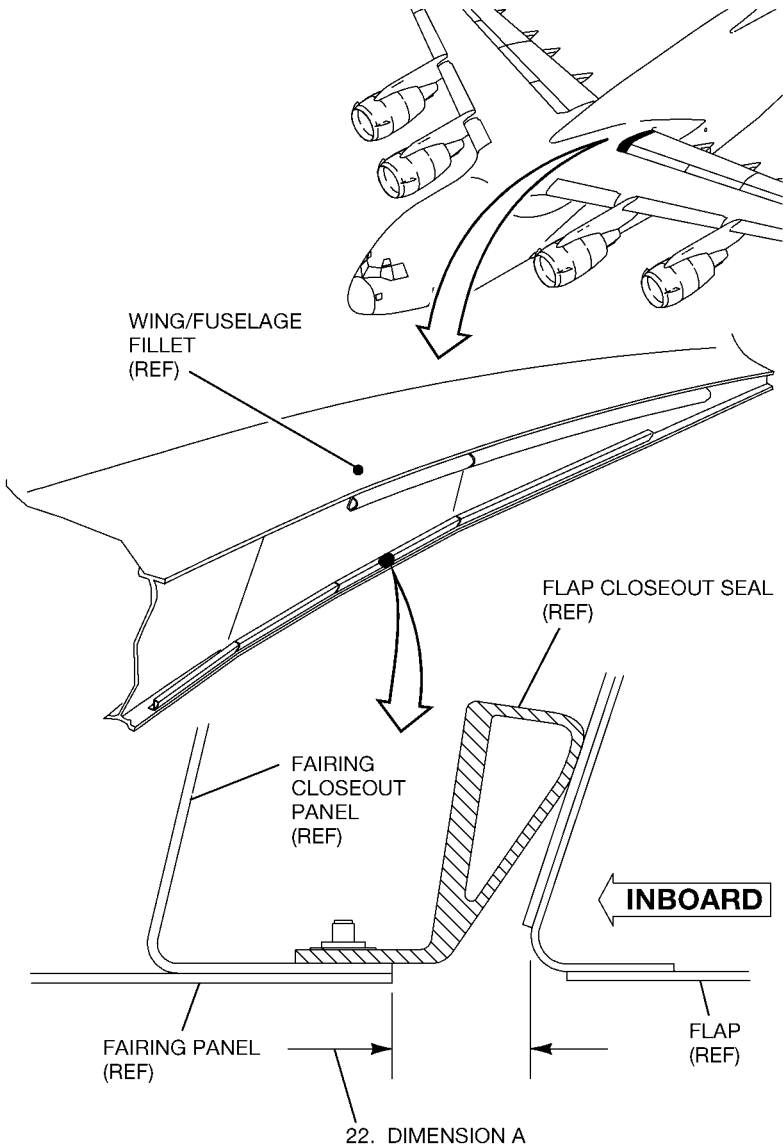


ICN-88277-G2751196-001-01

**NOTE**

Flaps shall be fully retracted when taking measurements.

22. (A,B) Measure dimension A, along the edges of the flap and wing/fuselage fillet fairing/fairing closeout panels (common to the flap closeout seals); mark the panels for trimming, as required.
- Dimension A gap shall be a minimum of 0.60 inch.



ICN-88277-G2751197-001-01

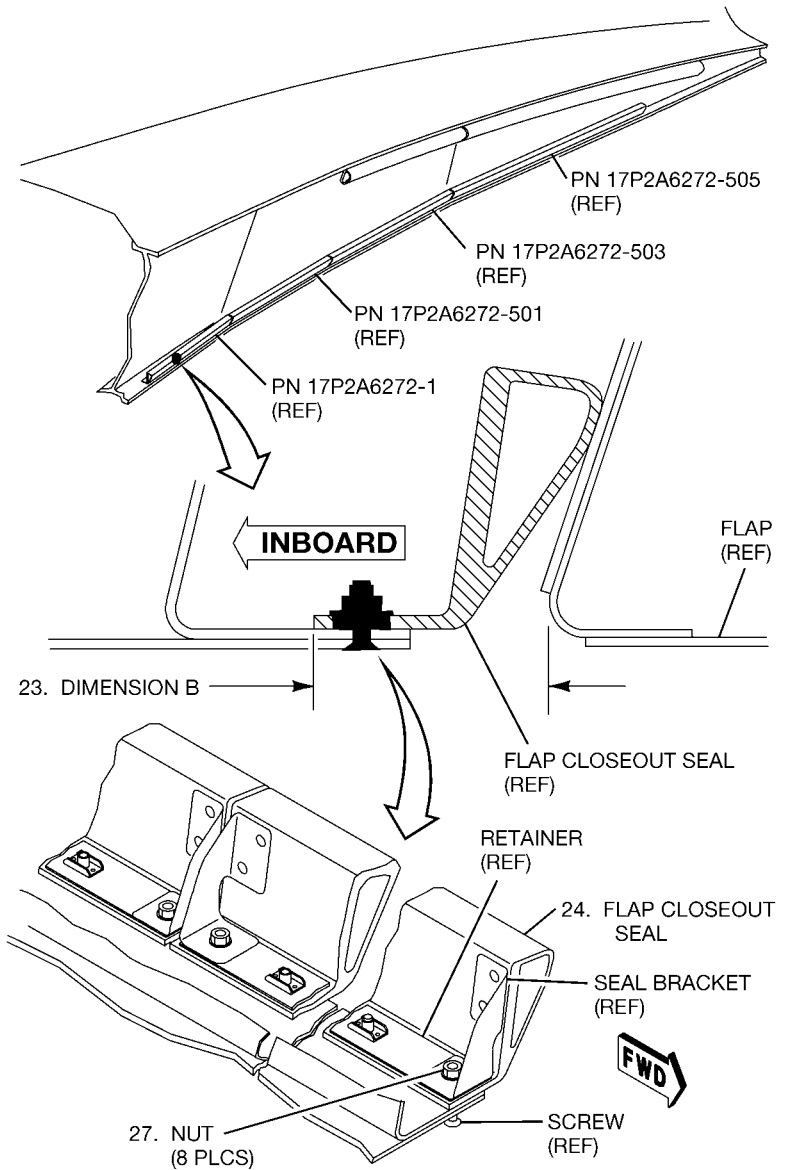
**NOTE**

- Flaps shall be fully retracted when taking measurements.
- For each seal, three measurements shall be taken, one within approximately an inch of either end of the seal, and one approximately in the middle.

23. (A,B) Measure dimension B, along the lower edge of the flap and the edge of the flap closeout seal, as follows:

<b>LH SEAL PN</b>	<b>RH SEAL PN</b>	<b>DIMENSION B</b>
17P2A6272-1	17P2A6272-1	2.07 - 2.13
17P2A6272-501	17P2A6272-502	2.07 - 2.13
17P2A6272-503	17P2A6272-504	2.07 - 2.13
17P2A6272-505	17P2A6272-506	1.99 - 2.05

24. (A,B) Position flap closeout seal (by loosening screws from retainers and seal brackets as required, and floating the seal within the slotted holes) to obtain dimension B; retighten screws.
25. Perform flaps system operation (27-50-03, task 03-3).
26. Trim edge of fairing/fairing closeout panels, as required (TO 1300i-3-1, 51-80-00).
- Fastener edge distance shall be a minimum of 0.48 inch.
27. (A,B) Ensure nuts thru all seal brackets are tight.
28. Perform fastener head sealing (TO 1300i-23, Chapter 1, Section III).
29. Perform flaps system operation (27-50-03, task 03-4).



ICN-88277-G2751199-001-01

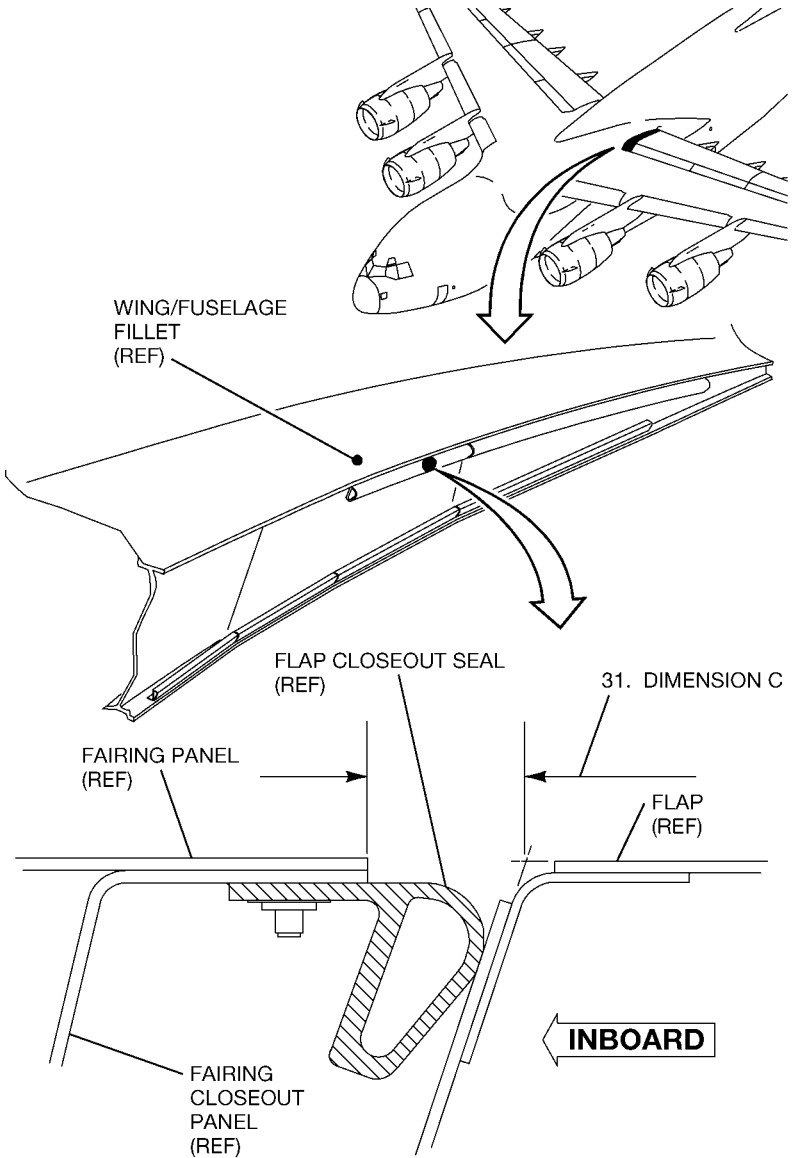
30. Enter fuselage and wing (00-00-01, task 01-1).

**NOTE**

Flaps shall be fully retracted when taking measurements.

31. (A,B) Measure dimension C, along the edges of the flap and wing/fuselage fillet fairing/fairing closeout panels (common to the flap closeout seals); mark the panels for trimming, as required.
- Dimension C gap shall be a minimum of 0.60 inch.





ICN-88277-G2751198-001-01

NOTE

- Flaps shall be fully retracted when taking measurements.
- For each seal, three measurements shall be taken, one within approximately an inch of either end of the seal, and one approximately in the middle.

32. (A,B) Measure dimension D, along the upper edge of the flap and the edge of the flap closeout seal, as follows:

LH SEAL PN	RH SEAL PN	DIMENSION D
17P2A6272-515	17P2A6272-515	2.26 - 2.32
17P2A6272-517	17P2A6272-518	2.26 - 2.32

33. (A,B) Position flap closeout seal (by loosening screws from retainers as required, and floating the seal within the slotted holes) to obtain dimension D; retighten screws.

34. Perform flaps system operation (27-50-03, task 03-3).

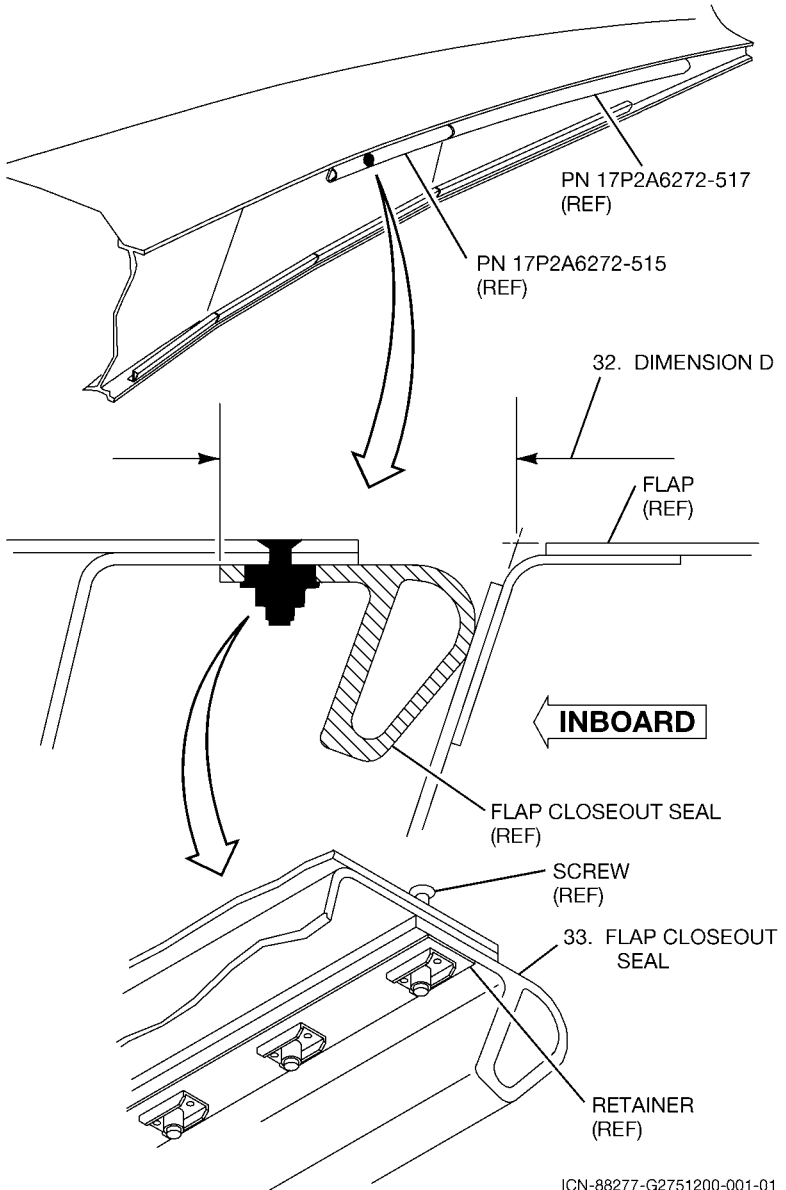
35. Trim edge of fairing/fairing closeout panels, as required (TO 1300i-3-1, 51-80-00).

- Fastener edge distance shall be a minimum of 0.48 inch.

36. Perform fastener head sealing (TO 1300i-23, Chapter 1, Section III).

37. Perform flaps system operation (27-50-03, task 03-4).

38. Exit fuselage and wing (00-00-01, task 01-5).



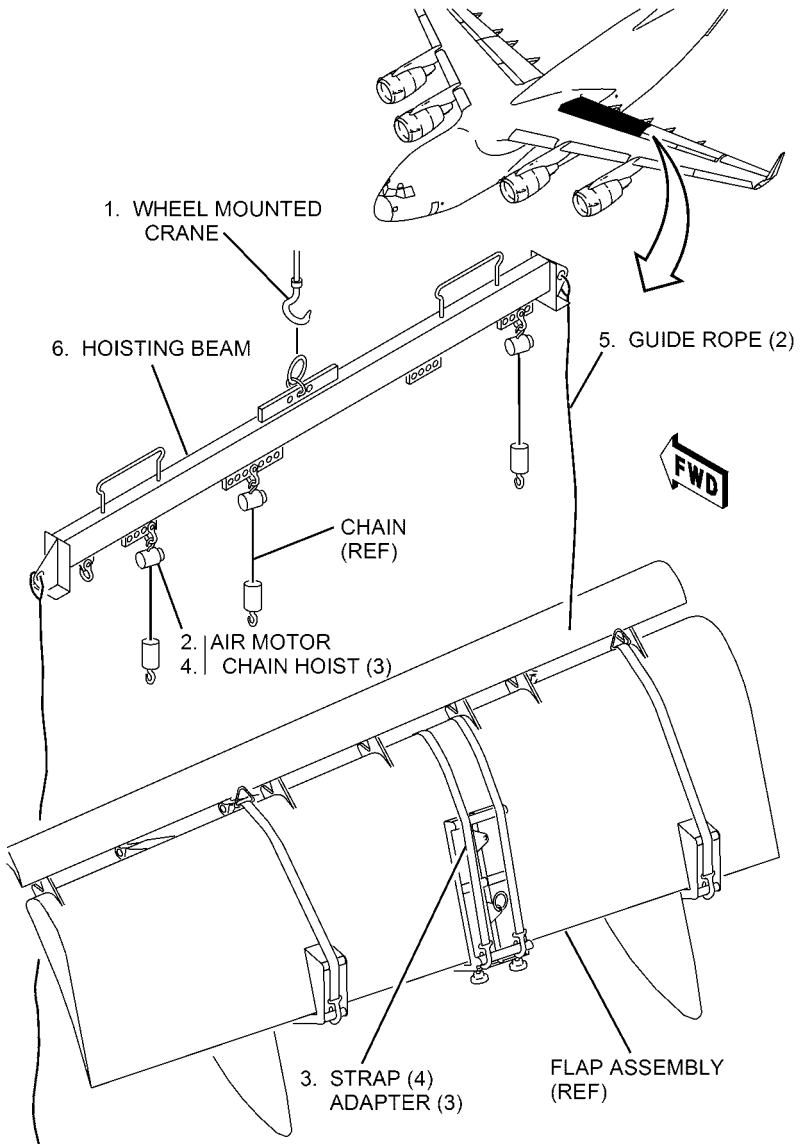
**3-5A. FOLLOW-ON MAINTENANCE FOR  
2751AA003 AND 2751AA004 USING PN  
17G110482-505.**

1. (A,C) Operate wheel mounted crane and slacken chains.

**NOTE**

Chain hoist attached to the center adapter. The inboard and outboard hoist chains are installed to the hoisting rings on the straps.

2. (A,B,D,E) Operate air motor chain hoists and remove chains from adapter and straps.
3. (B,D,E,F) Loosen straps and remove adapters.
4. (B,D,E,F) Remove air motor chain hoists from hoisting beam.
5. (E,F) Wrap guide ropes on hoisting beam.
6. (B,D,E,F) Remove hoisting beam from wheel mounted crane.

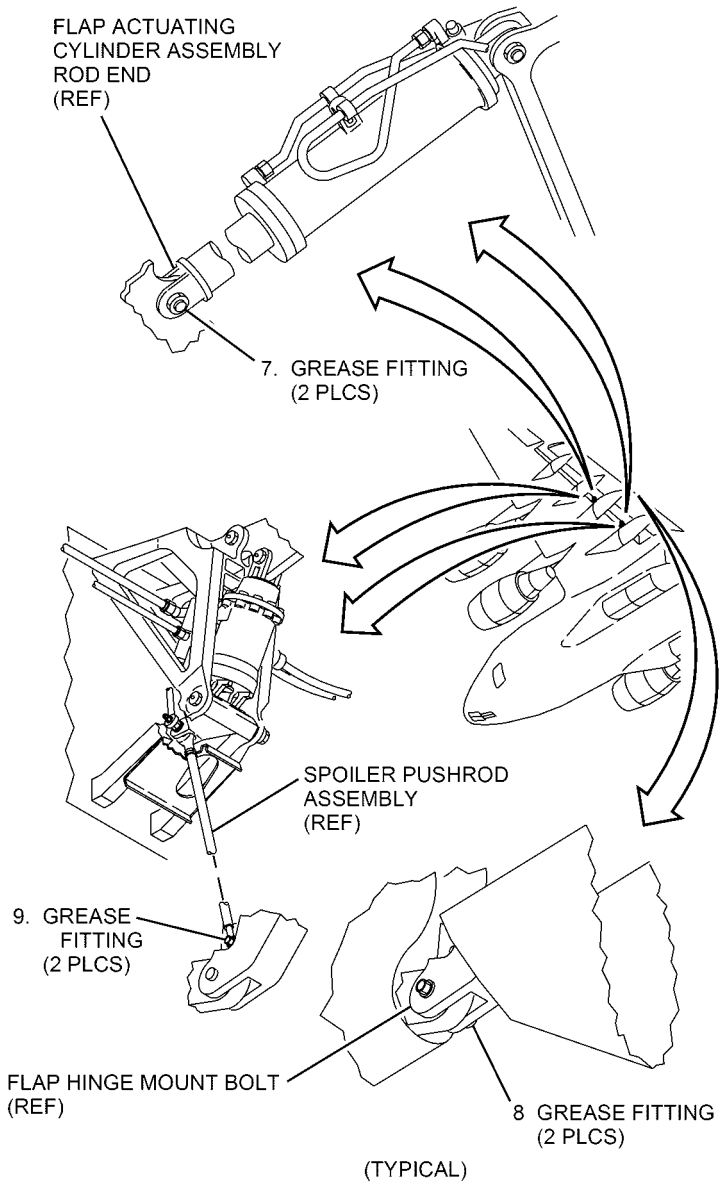


(TYPICAL)

ICN-88277-G2751264-001-01

## **TO 1300i-2-27JG-50-2**

7. (A,B) Lubricate grease fittings on flap actuating cylinder assembly rod ends.
8. (A,B) Lubricate grease fittings on flap hinge mount bolts.
9. (A,B) Lubricate grease fittings on spoiler pushrod assembly.

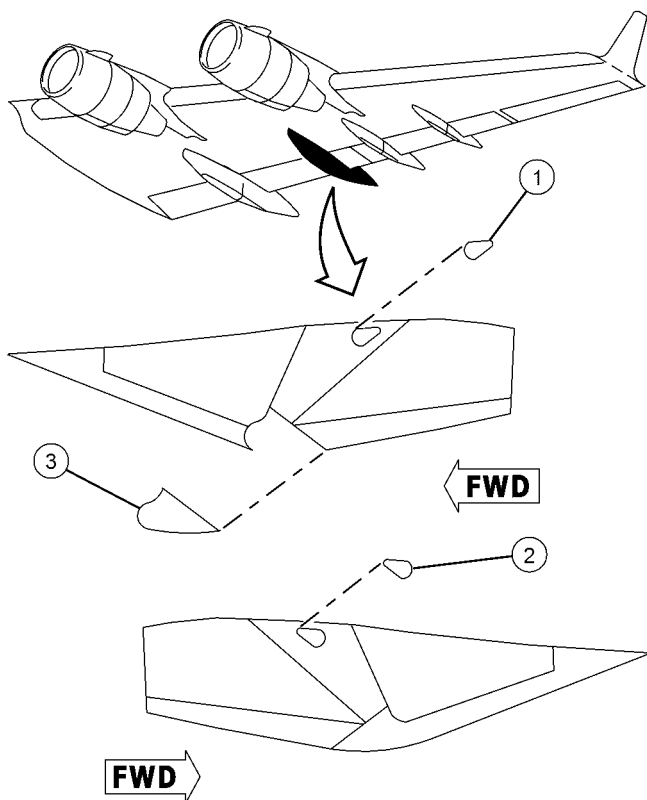


ICN-88277-G2751265-001-01

## **TO 1300i-2-27JG-50-2**

10. (A,B) Position access panels.
11. Perform wet fastener installation (TO 1300i-23, Chapter 1, Section III).
12. (A,B) Install fasteners.
13. Perform fillet sealing (TO 1300i-23, Chapter 1, Section III).
14. (A,B) Position access covers.
15. Perform wet fastener installation (TO 1300i-23, Chapter 1, Section III).
16. (A,B) Install fasteners.

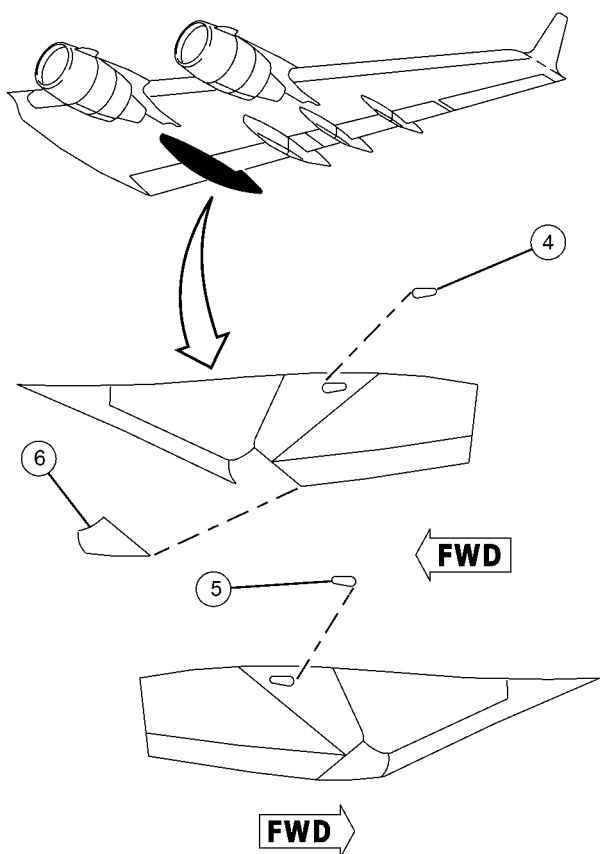




10.	FLAP REF DES	INDEX NO.	ACCESS PANEL	FASTENER QTY
12.		1	571DLC	12
		2	571ERC	12

14.	FLAP REF DES	INDEX NO.	ACCESS COVER	FASTENER QTY
16.		3	571FBC	18

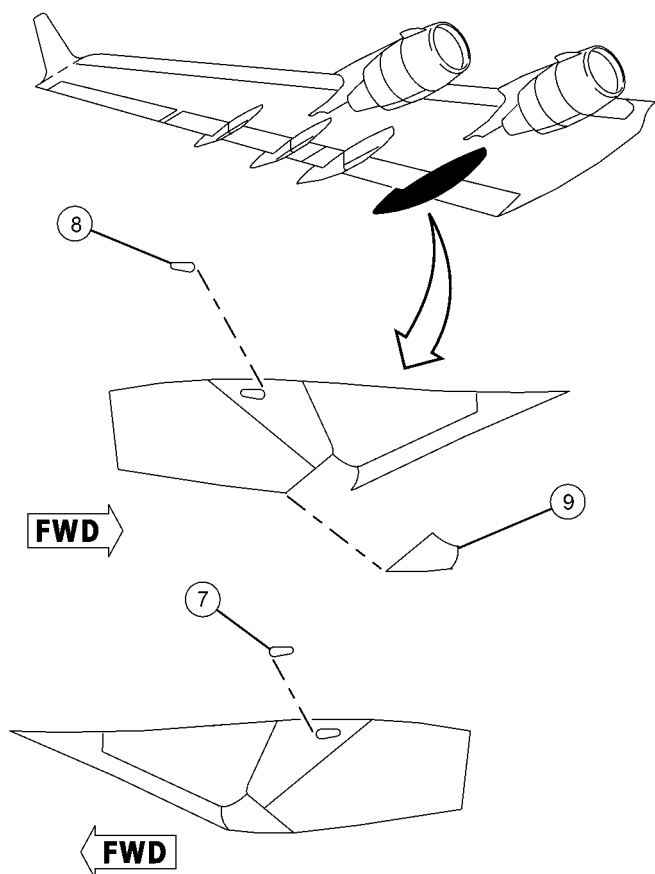
ICN-88277-G2751266-001-01



10.	FLAP REF DES	INDEX NO.	ACCESS PANEL	FASTENER QTY
12.		4	571ALC	12
	2751AA003	5	571BRC	12

14.	FLAP REF DES	INDEX NO.	ACCESS COVER	FASTENER QTY
16.		6	571CBC	23
	2751AA003			

ICN-88277-G2751267-001-01

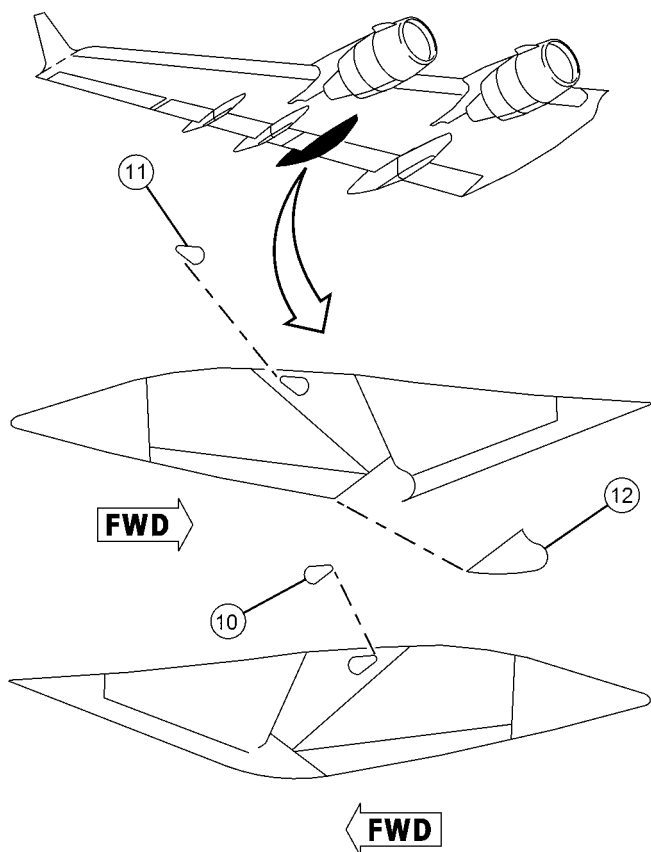


10.	FLAP REF DES	INDEX NO.	ACCESS PANEL	FASTENER QTY
12.		7	671ALC	12
	2751AA004	8	671BRC	12

14.	FLAP REF DES	INDEX NO.	ACCESS COVER	FASTENER QTY
16.		9	671CBC	23
	2751AA004			

ICN-88277-G2751268-001-01



10.	FLAP REF DES	INDEX NO.	ACCESS PANEL	FASTENER QTY
12.		10	671DLC	12
	2751AA004	11	671ERC	12

14.	FLAP REF DES	INDEX NO.	ACCESS COVER	FASTENER QTY
16.		12	671FBC	18
	2751AA004			

ICN-88277-G2751269-001-01



17. (A) Remove warning tag and close **AUX HYDRAULIC PUMP 1** circuit breaker on Electrical Power Center (EPC), row **LL**, column **68**.
18. (A) Remove warning tag and close **AUX HYDRAULIC PUMP 4** circuit breaker on EPC row **LL**, column **10**.
19. Remove spoiler positioning support assembly (05-10-04, tasks 04-4 and 04-6).

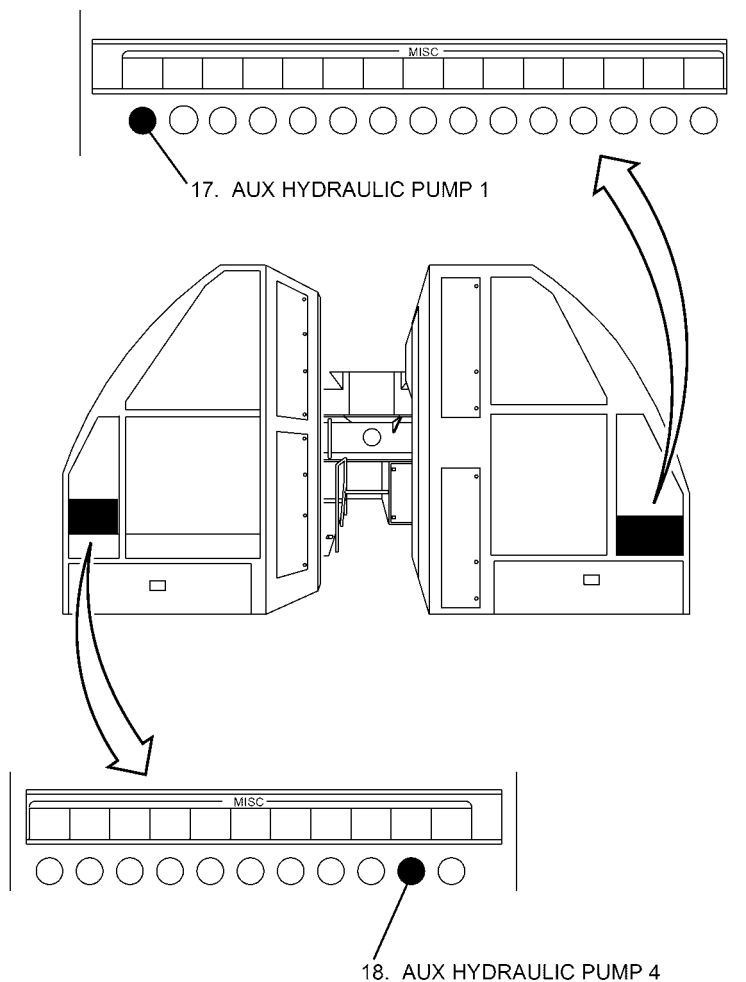
<b>WARNING</b>
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All ground personnel shall be clear of flaps. Flaps will move to last commanded position. Failure to comply may cause injury to personnel and/or damage to aircraft.

**NOTE**

When performing flaps system operational checkout, flaps shall be in symmetrical position.

20. Perform flaps system operational checkout (27-50-01).
21. Perform flight controls system major rig (27-00-01, task 01-1).



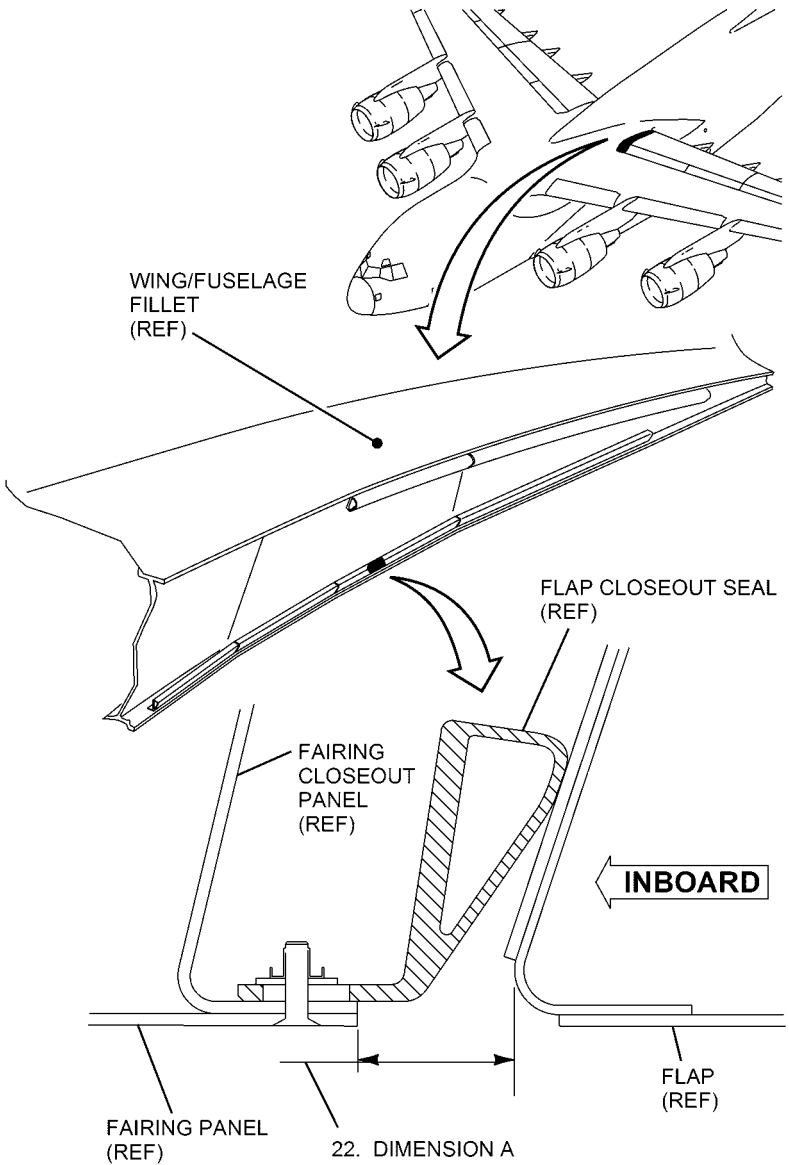
ICN-88277-G2751270-001-01

**NOTE**

Flaps shall be fully retracted when taking measurements.

22. (A,B) Measure dimension A, along the edges of the flap and wing/fuselage fillet fairing/fairing closeout panels (common to the flap closeout seals); mark the panels for trimming, as required.
- Dimension A gap shall be a minimum of 0.60 inch.





ICN-88277-G2751271-001-01

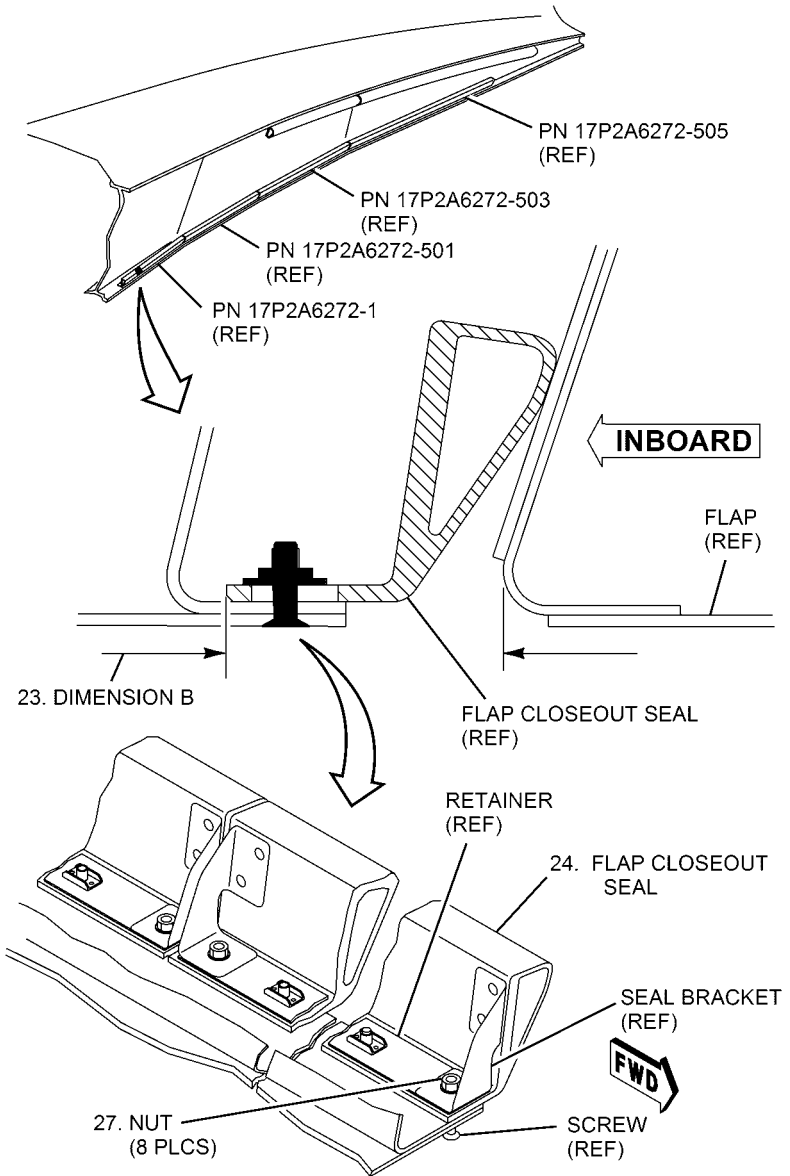
**NOTE**

- Flaps shall be fully retracted when taking measurements.
- For each seal, three measurements should be taken, one within approximately an inch of either end of the seal, and one approximately in the middle.

23. (A,B) Measure dimension B, along the lower edge of the flap and the edge of the flap closeout seal, as follows:

<b>LH SEAL PN</b>	<b>RH SEAL PN</b>	<b>DIMENSION B</b>
17P2A6272-1	17P2A6272-1	2.07 - 2.13
17P2A6272-501	17P2A6272-502	2.07 - 2.13
17P2A6272-503	17P2A6272-504	2.07 - 2.13
17P2A6272-505	17P2A6272-506	1.99 - 2.05

24. (A,B) Position flap closeout seal (by loosening screws from retainers and seal brackets as required, and floating the seal within the slotted holes) to obtain dimension B; retighten screws.
25. Perform flaps system operation (27-50-03, task 03-3).
26. Trim edge of fairing/fairing closeout panels, as required (TO 1300i-3-1, 51-80-00).
- Fastener edge distance shall be a minimum of 0.48 inch.
27. (A,B) Ensure nuts thru all seal brackets are tight.
28. Perform fastener head sealing (TO 1300i-23, Chapter 1, Section III).
29. Perform flaps system operation (27-50-03, task 03-4).



30. Enter fuselage and wing (00-00-01, task 01-1).

**NOTE**

Flaps shall be fully retracted when taking measurements.

31. (A,B) Measure dimension C, along the edges of the flap and wing/fuselage fillet fairing/fairing closeout panels (common to the flap closeout seals); mark the panels for trimming, as required.
- Dimension C gap shall be a minimum of 0.60 inch.