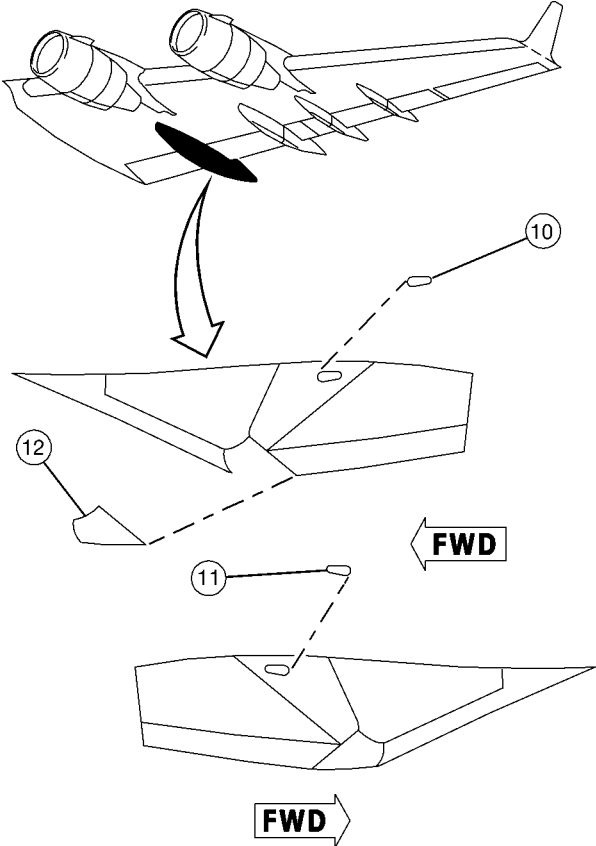


14.	15.	FLAP REF DES	INDEX NO.	ACCESS PANEL	FASTENER QTY
			7	571DLC	12
		2751AA003	8	571ERC	12

16.	17.	FLAP REF DES	INDEX NO.	ACCESS COVER	FASTENER QTY
			9	571FBC	18

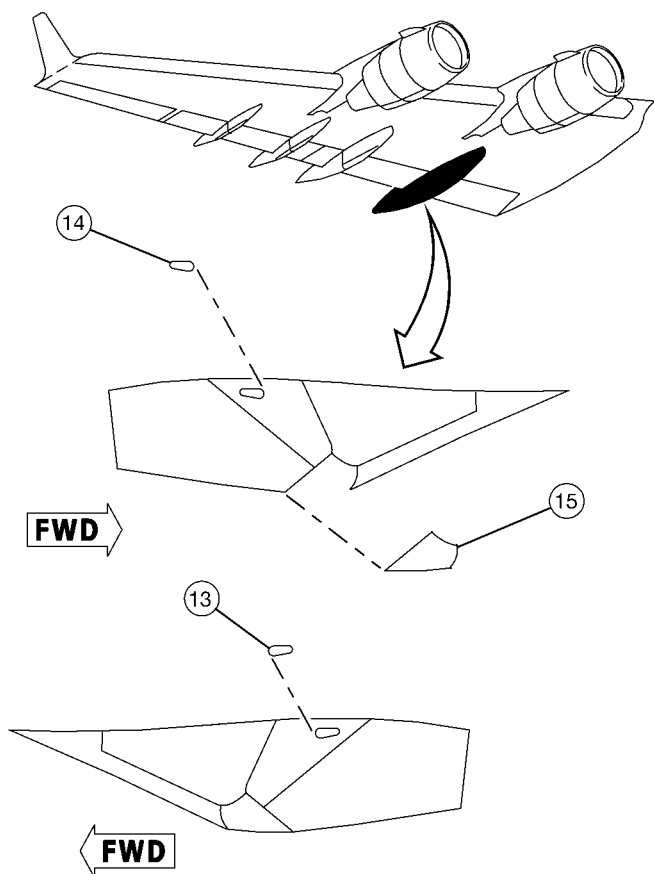
ICN-88277-G2751149-002-01



14.	FLAP REF DES	INDEX NO.	ACCESS PANEL	FASTENER QTY
15.		10	571ALC	12
	2751AA003	11	571BRC	12

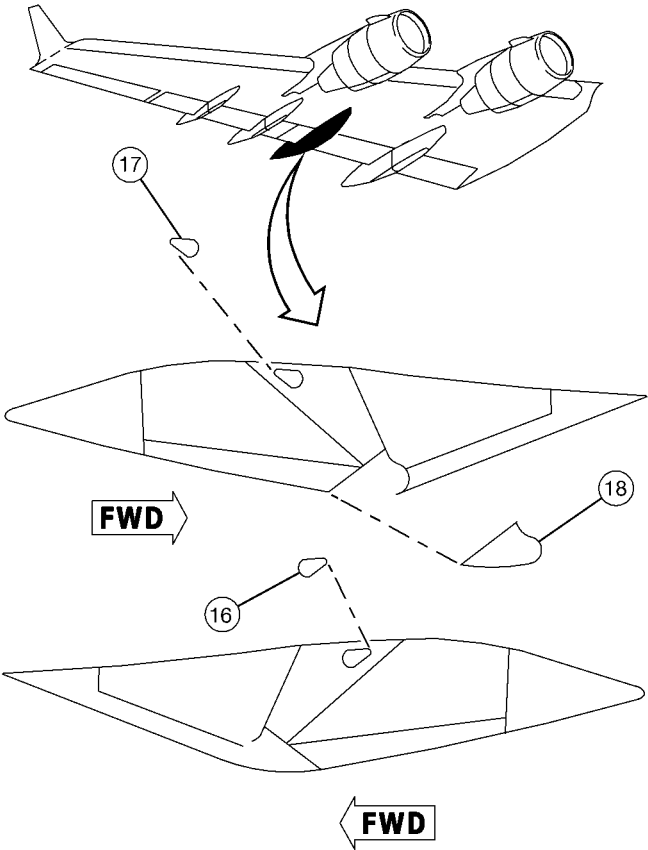
16.	FLAP REF DES	INDEX NO.	ACCESS COVER	FASTENER QTY
17.		12	571CBC	23
	2751AA003			

ICN-88277-G2751150-003-01



14.	FLAP REF DES	INDEX NO.	ACCESS PANEL	FASTENER QTY
15.		13	671ALC	12
	2751AA004	14	671BRC	12
16.	FLAP REF DES	INDEX NO.	ACCESS COVER	FASTENER QTY
17.		15	671CBC	23
	2751AA004			

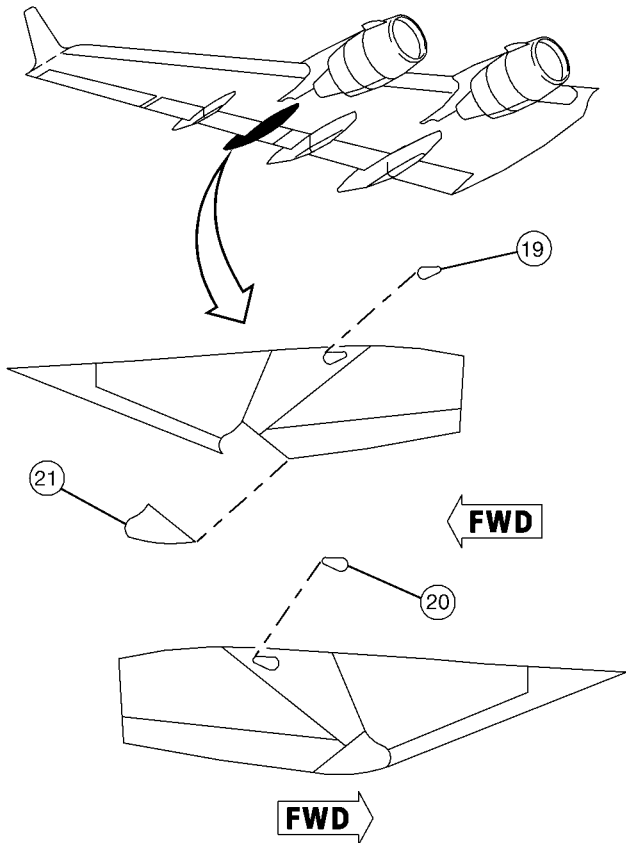
ICN-88277-G2751151-003-01



14.	FLAP REF DES	INDEX NO.	ACCESS PANEL	FASTENER QTY
15.		16	671DLC	12
	2751AA004	17	671ERC	12

16.	FLAP REF DES	INDEX NO.	ACCESS COVER	FASTENER QTY
17.		18	671FBC	18
	2751AA004			

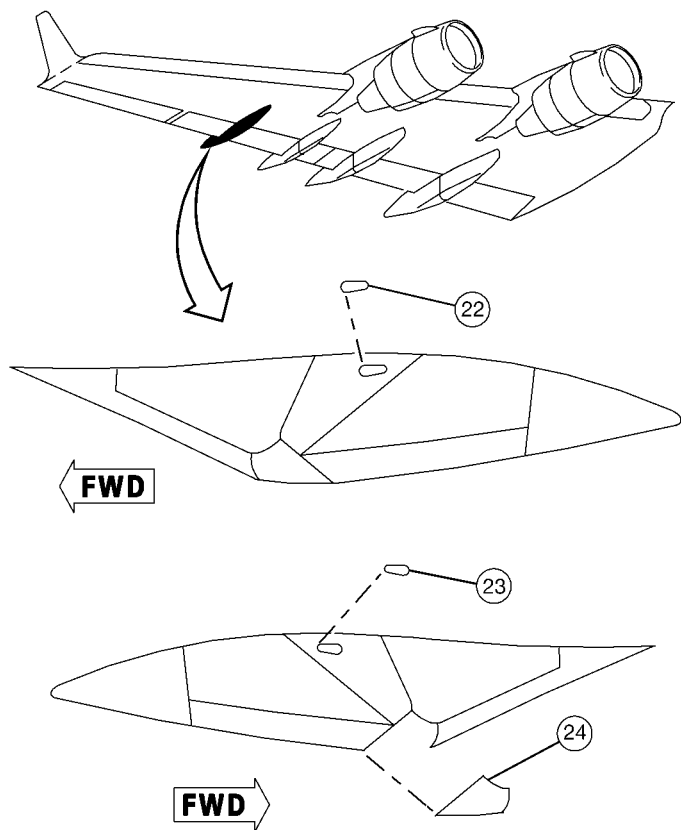
ICN-88277-G2751152-002-01



14.	FLAP REF DES	INDEX NO.	ACCESS PANEL	FASTENER QTY
15.	2751AA005	19	673ALC	12
		20	673BRC	12

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

ICN-88277-G2751153-002-01



14.	FLAP REF DES	INDEX NO.	ACCESS PANEL	FASTENER QTY
15.	2751AA005	22	673DLC	12
		23	673ERC	12

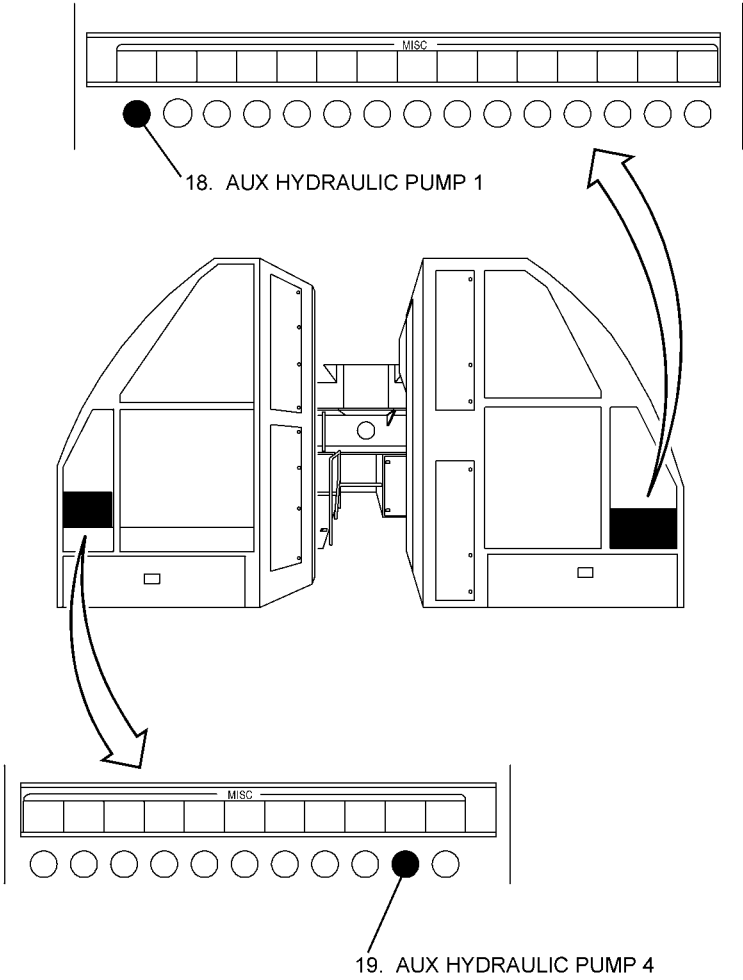
16.	FLAP REF DES	INDEX NO.	ACCESS COVER	FASTENER QTY
17.	2751AA005	24	673FBC	17

ICN-88277-G2751154-003-01

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

- 18. (A) Remove warning tag and close **AUX HYDRAULIC PUMP 1** circuit breaker on Electrical Power Center (EPC), row **LL**, column **68**.
- 19. (A) Remove warning tag and close **AUX HYDRAULIC PUMP 4** circuit breaker on EPC, row **LL**, column **10**.
- 20. 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



**FLAP AND VANE STRUCTURAL ASSEMBLY
INSTALLATION
(27-51-10-3)**

FUNCTIONAL INPUT CONDITIONS:

Applicability:	Task
All	All

Additional information:

This procedure consists of the following tasks:

- 3-1. Preparation for 2751AA002 and 2751AA005.
- 3-1A. Preparation for 2751AA002 and 2751AA005 using PN 17G110482-505.
- 3-2. Preparation for 2751AA003 and 2751AA004.
- 3-2A. Preparation for 2751AA003 and 2751AA004 using PN 17G110482-505.
- 3-3. Installation.
- 3-4. Follow-on maintenance for 2751AA002 and 2751AA005.
- 3-4A. Follow-on maintenance for 2751AA002 and 2751AA005 using PN 17G110482-505.
- 3-5. Follow-on maintenance for 2751AA003 and 2751AA004.
- 3-5A. Follow-on maintenance for 2751AA003 and 2751AA004 using PN 17G110482-505.

NOTE	Task
-------------	-------------

This is a typical installation task for all flap and vane structural assemblies.	All
--	-----

Additional data:	Task
TO 1300i-2-00JG-00-1	3-5, 3-5A

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

	Task
TO 1300i-2-05JG-10-1	3-1, 3-1A, 3-2, 3-2A, 3-4, 3-4A, 3-5, 3-5A
TO 1300i-2-27JG-00-1	3-4, 3-4A, 3-5, 3-5A
TO 1300i-2-27JG-50-1	3-4, 3-4A, 3-5, 3-5A
TO 1300i-23	3-1, 3-1A, 3-2, 3-2A, 3-4, 3-4A, 3-5, 3-5A
TO 1300i-3-1	3-5, 3-5A

Personnel recommended:

	Task
Six	All
Person (A) performs task.	
Person (B) assists person A.	
Person (C) assists person A.	
Person (D) assists person A.	

Task

Person (E) assists person A.

Person (F) assists person A.

Safety conditions:

Task

WARNING

- Do not install flap and vane structural assembly with winds over 15 knots. Failure to comply may cause injury to personnel and damage to equipment. All
- 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. 3-1, 3-2

NOTE

When performing flap assembly installation using hoisting adapter set PN 17G110482-505, if kit is unavailable, contact Boeing engineering. 3-1A, 3-2A

Support equipment:

<u>Nomenclature</u>	<u>PN</u>	<u>Specification</u>	<u>Qty</u>	<u>Task</u>
Adapter Set, Hoisting	17G110482-503	Restricted from Use	--	--
Adapter	17G110482-195	--	1	3-1
Adapter	17G110482-197	--	1	3-1
Adapter	17G110482-199	--	1	3-2
Adapter	17G110482-201	--	1	3-2
Adapter	17G110482-203	--	1	3-1
Adapter	17G110482-205	--	1	3-2
Strap Assembly, Hoisting	17G113482-1	--	AR	3-1, 3-2
Strap Assembly, Hoisting	17G113482-513	--	AR	3-2
Strap Assembly, Hoisting	17G113482-515	--	AR	3-1
Strap Assembly, Hoisting	17G113482-525	--	AR	3-2

<u>Nomenclature</u>	<u>PN</u>	<u>Specification</u>	<u>Qty</u>	<u>Task</u>
Strap Assembly, Hoisting	17G113482-527	--	AR	3-2
Strap Assembly, Hoisting	17G113482-529	--	AR	3-1
Strap Assembly, Hoisting	17G113482-531	--	AR	3-1
Adapter Set, Hoisting	17G110482-505	--	--	--
Adapter	17G110482-215	--	1	3-1A
Adapter	17G110482-217	--	1	3-1A
Adapter	17G110482-219	--	1	3-2A
Adapter	17G110482-221	--	1	3-2A
Adapter	17G110482-203	--	1	3-1A
Adapter	17G110482-205	--	1	3-2A
Strap Assembly, Hoisting	17G113482-1	--	AR	3-1A, 3-2A
Strap Assembly, Hoisting	17G113482-513	--	AR	3-2A

<u>Nomenclature</u>	<u>PN</u>	<u>Specification</u>	<u>Qty</u>	<u>Task</u>
Strap Assembly, Hoisting	17G113482-515	--	AR	3-1A
Strap Assembly, Hoisting	17G113482-533	--	AR	3-2A
Strap Assembly, Hoisting	17G113482-535	--	AR	3-2A
Strap Assembly, Hoisting	17G113482-537	--	AR	3-1A
Strap Assembly, Hoisting	17G113482-539	--	AR	3-1A
Beam, Hoisting	17G110123-1	--	1	All
Crane, Wheel Mounted	LRT-100	--	1	All
Holding Fixture, Flap	17G110116-1	--	1	3-1, 3-1A, 3-2, 3-2A
Hoist, Air Motor, Chain	--	1/2 -1 ton	3	3-1, 3-1A, 3-2, 3-2A

<u>Nomenclature</u>	<u>PN</u>	<u>Specification</u>	<u>Qty</u>	<u>Task</u>
Lanyard, Restraint, Flap Actuator	17G140022-1	--	1	3-1, 3-1A, 3-2, 3-2A, 3-3
Pin, Drift	--	8 inch x 1 3/8 inch (Aluminum or Brass)	2	3-3
Pin, Drift	--	12 inch x 1 3/8 inch (Aluminum or Brass)	2	3-3
Rope, Guide	3827T3-8	--	2	All
Sling, Multiple Leg	17G110012-1	--	1	3-1, 3-1A, 3-2, 3-2A
Socket, Spline, 18 Tooth Involute	ANHC1719	--	1	3-3
Socket, Spline, 20 Tooth Involute	ANHC1721	--	1	3-3

<u>Nomenclature</u>	<u>PN</u>	<u>Specification</u>	<u>Qty</u>	<u>Task</u>
Unit, Filler and Pressurizing	204000	--	1	3-4, 3-4A, 3-5, 3-5A
Wrench, Torque	--	(0-50 ft-lb)	1	3-3
Wrench, Torque	--	(0-100 ft-lb)	1	3-1, 3-2
Wrench, Torque	--	(0-150 in-lb)	1	3-1, 3-1A, 3-2, 3-2A
Wrench, Torque	--	(0-300 in-lb)	1	3-1, 3-1A, 3-2, 3-2A
Wrench, Torque	--	(0-600 in-lb)	1	3-3
Wrench, Torque	--	(0-250 ft-lb)	1	3-3
Wrench, Torque	--	(0-800 ft-lb)	1	3-3

<u>Nomenclature</u>	<u>PN</u>	<u>Specification</u>	<u>Qty</u>	<u>Task</u>
Wrench, Torque	--	(500-2000 ft-lb)	1	3-3

Supplies:

<u>Nomenclature</u>	<u>PN</u>	<u>Specification</u>	<u>Qty</u>	<u>Task</u>
Grease	AEROSHELL GREASE22	--	AR	3-3
Petrolatum, Technical	14P1	--	AR	3-1, 3-1A, 3-2, 3-2A
Pin, Cotter	MS24665-309	--	2	3-3
Pin, Cotter	MS24665-376	--	2	3-3
Pin, Cotter	MS24665-377	--	2	3-3
Pin, Cotter	MS24665-378	--	2	3-3

<u>Nomenclature</u>	<u>PN</u>	<u>Specification</u>	<u>Qty</u>	<u>Task</u>
Sealant	PR-1775 B-2	AMS 3265	AR	3-1, 3-1A, 3-2, 3-2A, 3-4, 3-4A, 3-5, 3-5A
Shim	17P6P4401-5	--	AR	3-1, 3-1A, 3-2, 3-2A
Shim	17P6P4402-5	--	AR	3-1, 3-1A, 3-2, 3-2A
Shim	17P6P4403-5	--	AR	3-1, 3-1A, 3-2, 3-2A

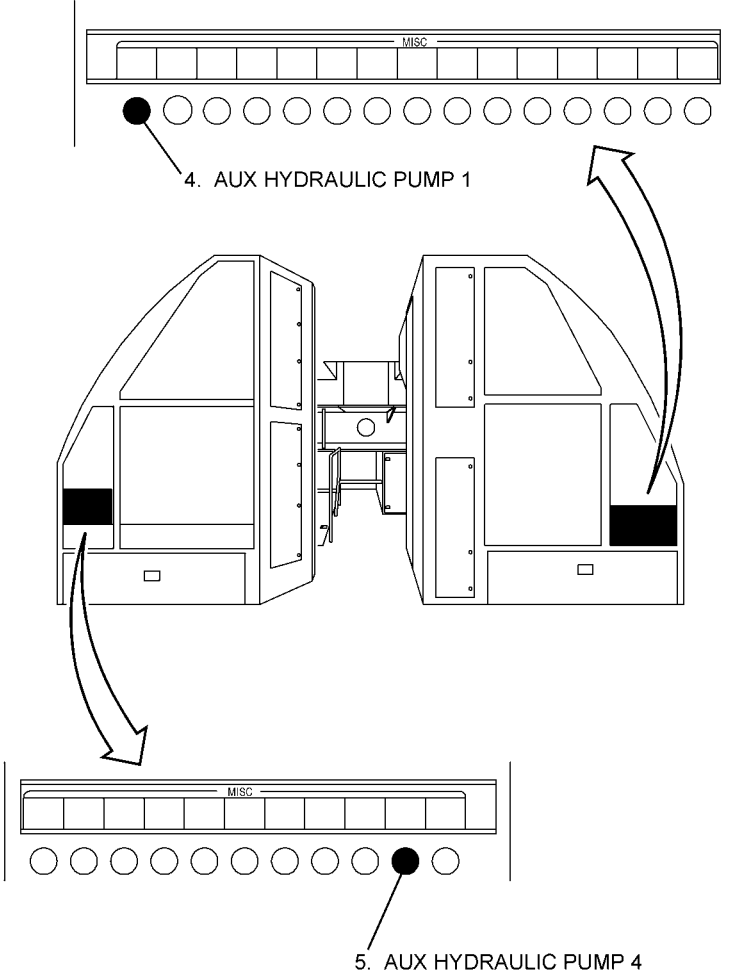
<u>Nomenclature</u>	<u>PN</u>	<u>Specification</u>	<u>Qty</u>	<u>Task</u>
Shim	17P6P4404-5	--	AR	3-1, 3-1A, 3-2, 3-2A
Tag, Warning	--	--	2	3-1, 3-1A, 3-2, 3-2A

3-1. PREPARATION FOR 2751AA002 AND 2751AA005.

WARNING

Flap assembly installation using the 17G110482-503 adapter set shall be temporarily halted until further notice. Hoisting adapter set 17G110482-503 contains defective 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.

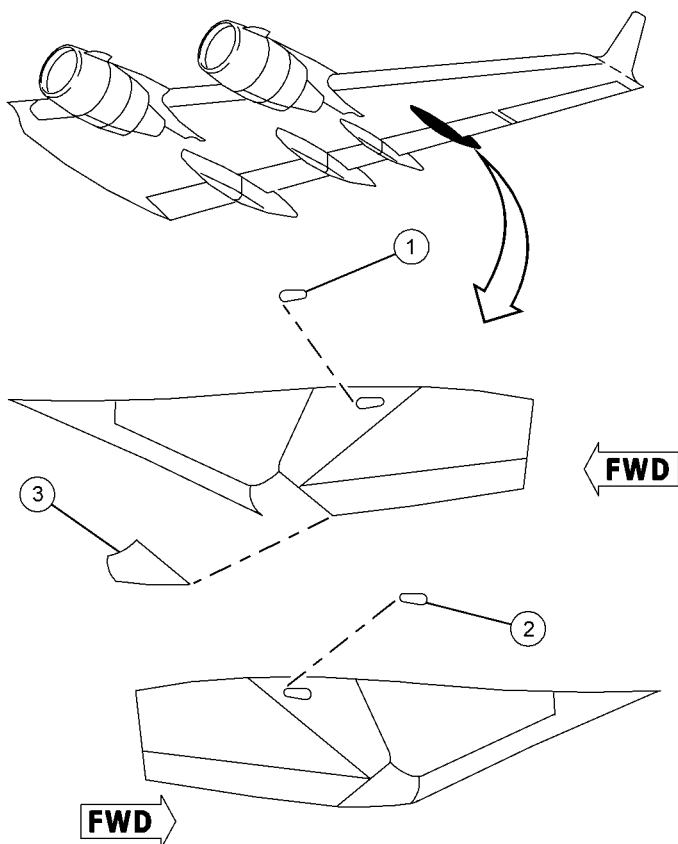
1. Review "Section 1 (General Information)" of this TO for system general warnings, cautions, and notes.
2. Review task "Functional Input Conditions" page for task specific safety conditions.
3. Install outboard spoiler positioning support assembly (05-10-04, tasks 04-1 and 04-3).
4. (A) Open **AUX HYDRAULIC PUMP 1** circuit breaker on Electrical Power Center (EPC), row **LL**, column **68**, and attach warning tag.
5. (A) Open **AUX HYDRAULIC PUMP 4** circuit breaker on EPC, row **LL**, column **10**, and attach warning tag.



ICN-88277-G2751173-004-01

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

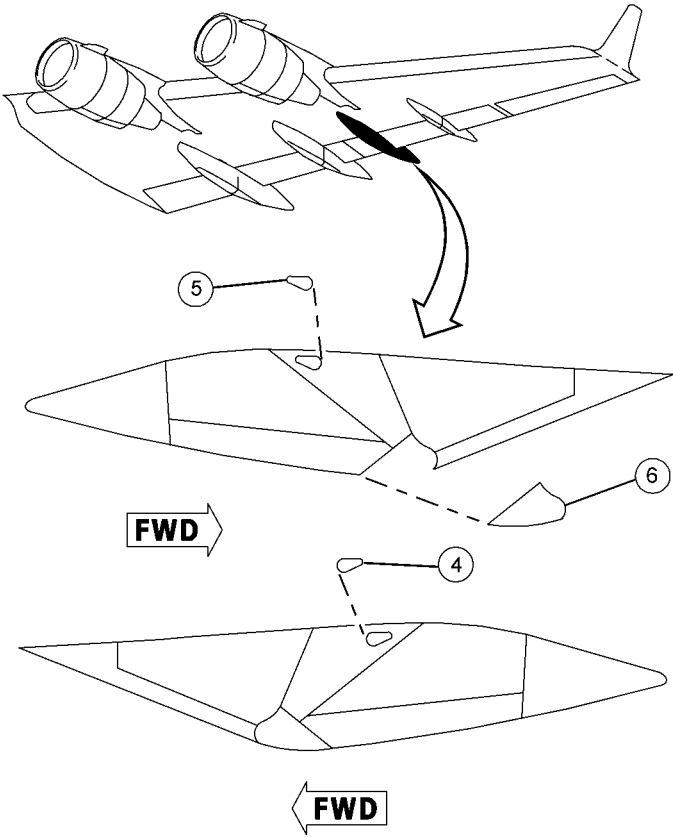
6. (B,D,E,F) Remove fasteners and access panels.
7. (B,D,E,F) Remove fasteners and access covers.



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

7.	FLAP REF DES	INDEX NO.	ACCESS COVER	FASTENER QTY
		3	573FBC	16

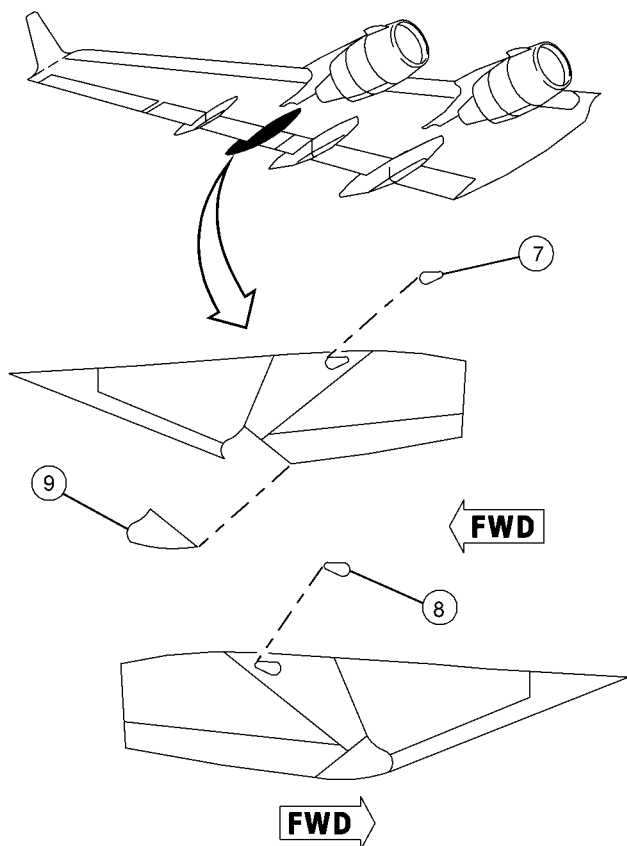
ICN-88277-G2751080-008-01



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

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

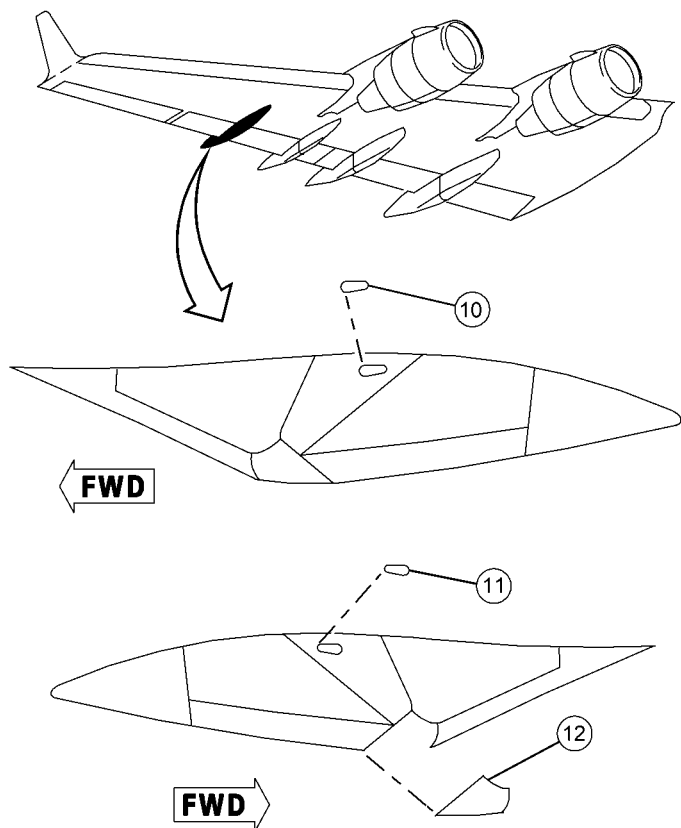
ICN-88277-G2751155-003-01



6.	FLAP REF DES	INDEX NO.	ACCESS PANEL	FASTENER QTY
	2751AA005	7	673ALC	12
		8	673BRC	12

7.	FLAP REF DES	INDEX NO.	ACCESS COVER	FASTENER QTY
	2751AA005	9	673CBC	17

ICN-88277-G2751156-003-01



6.	FLAP REF DES	INDEX NO.	ACCESS PANEL	FASTENER QTY
		10	673DLC	12
	2751AA005	11	673ERC	12

7.	FLAP REF DES	INDEX NO.	ACCESS COVER	FASTENER QTY
		12	673FBC	17
	2751AA005			

ICN-88277-G2751157-004-01

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 center of vane in choker configuration; remove slack from sling.

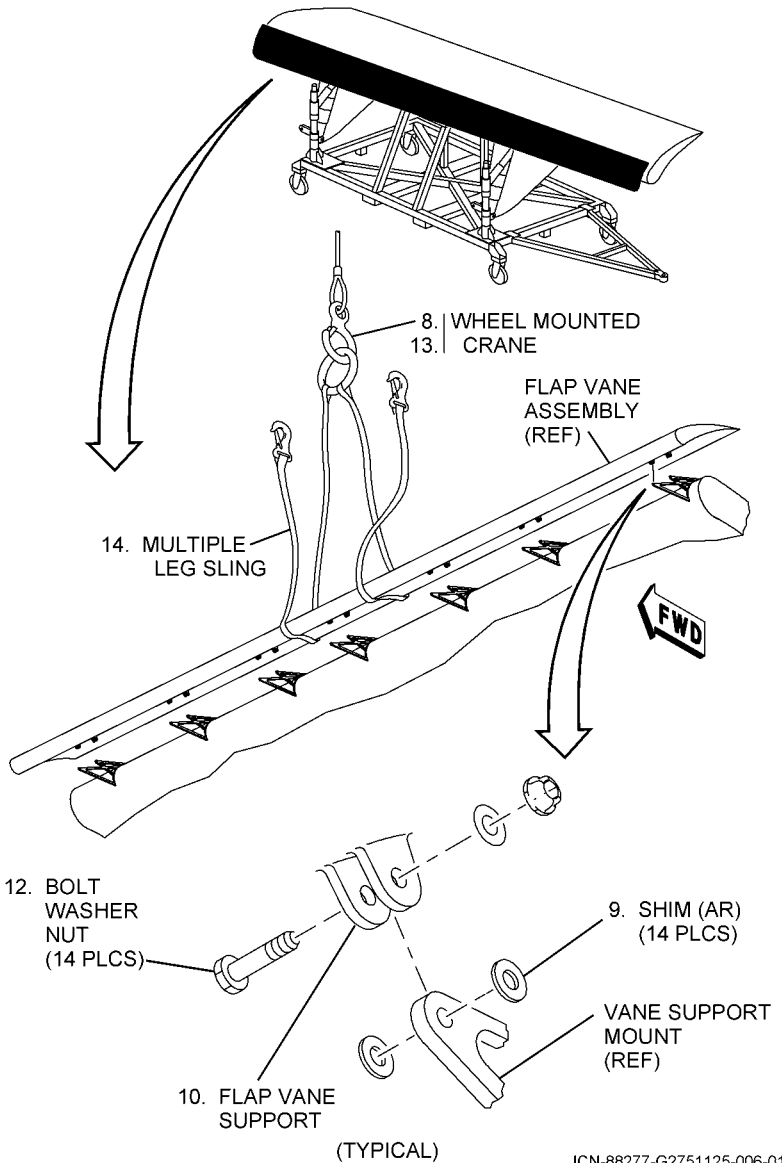
NOTE

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:

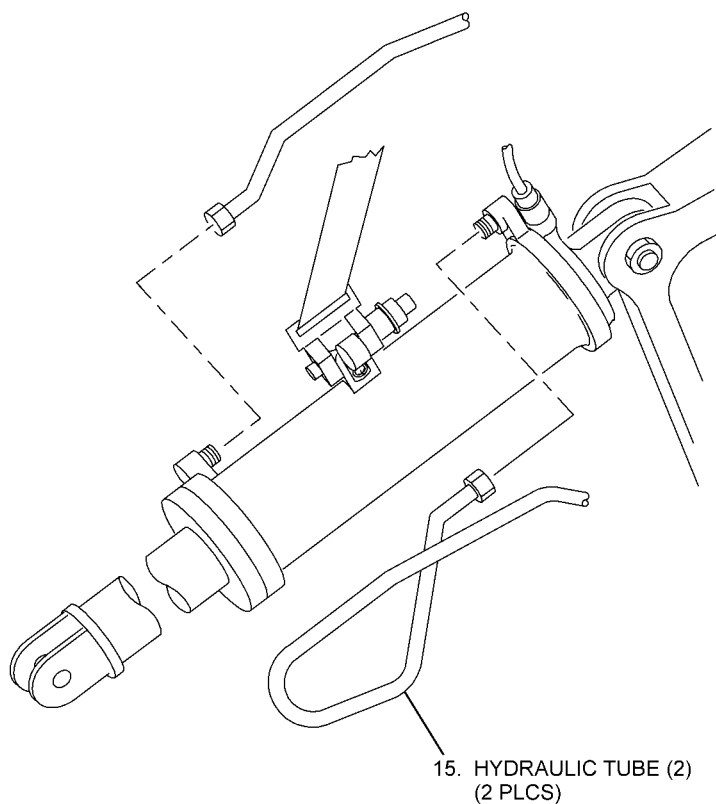
BOLT TYPE	TORQUE (in-lb)
NAS6804	50-70
NAS6805	100-140
NAS6806	160-190

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



ICN-88277-G2751125-006-01

15. (A,B) Disconnect hydraulic tubes.

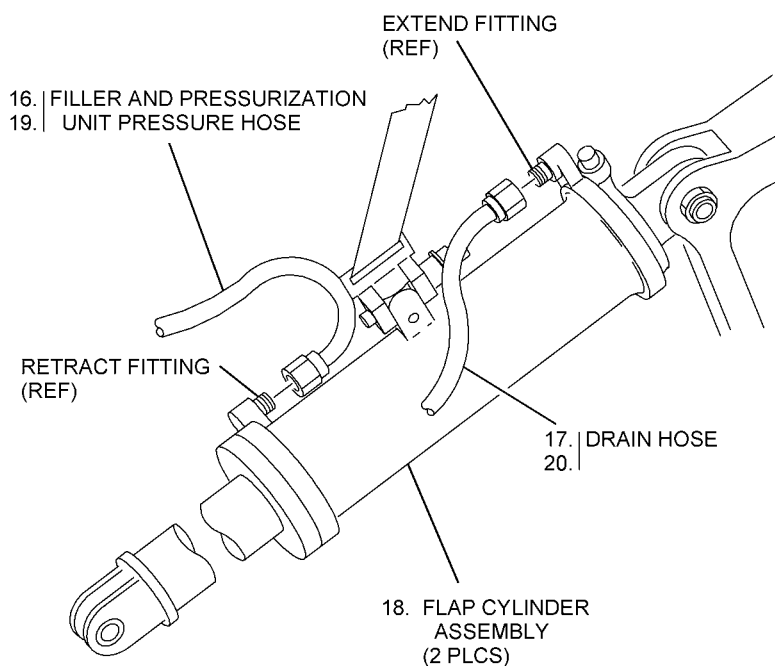


(TYPICAL)

ICN-88277-G2751022-005-01

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)

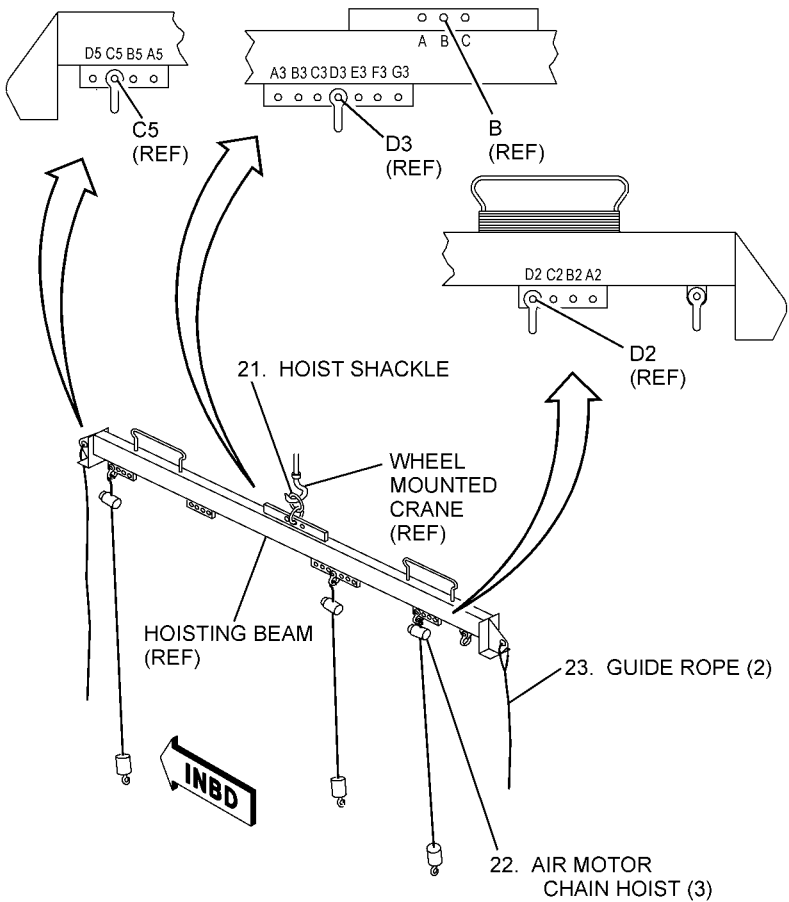
ICN-88277-G2751142-003-01

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
D2	D3	C5

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

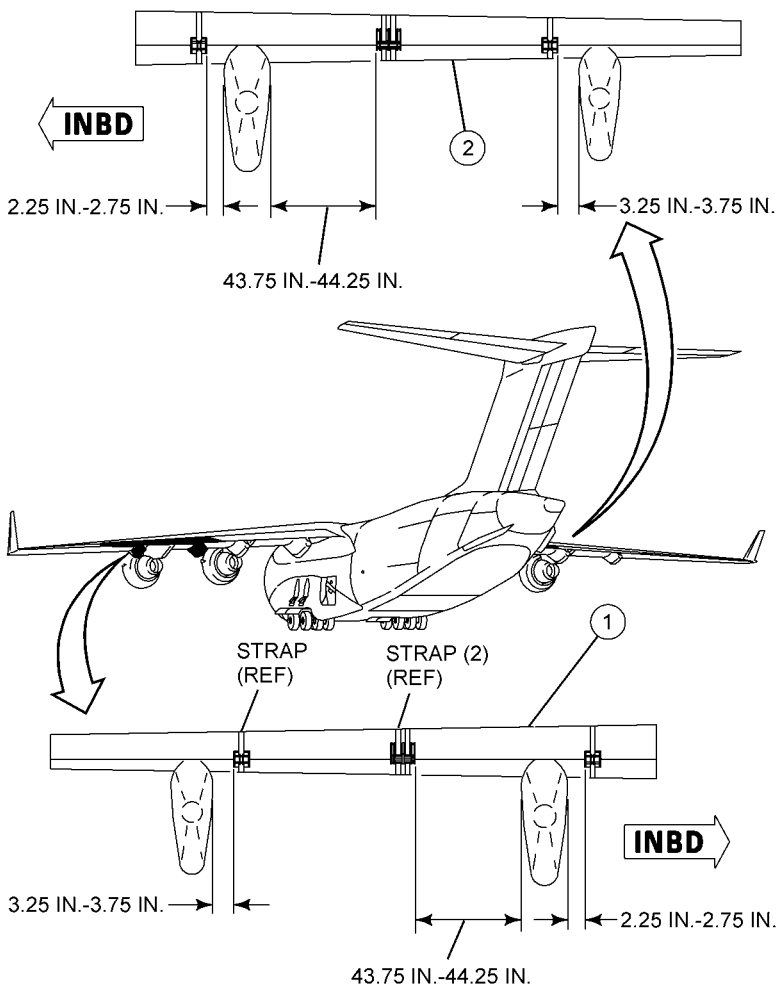


(TYPICAL)

ICN-88277-G2751081-008-01

27-51-10-3
2-127

24. (B,D,E,F) Position adapters and torque straps to **30-35 ft-lbs.**



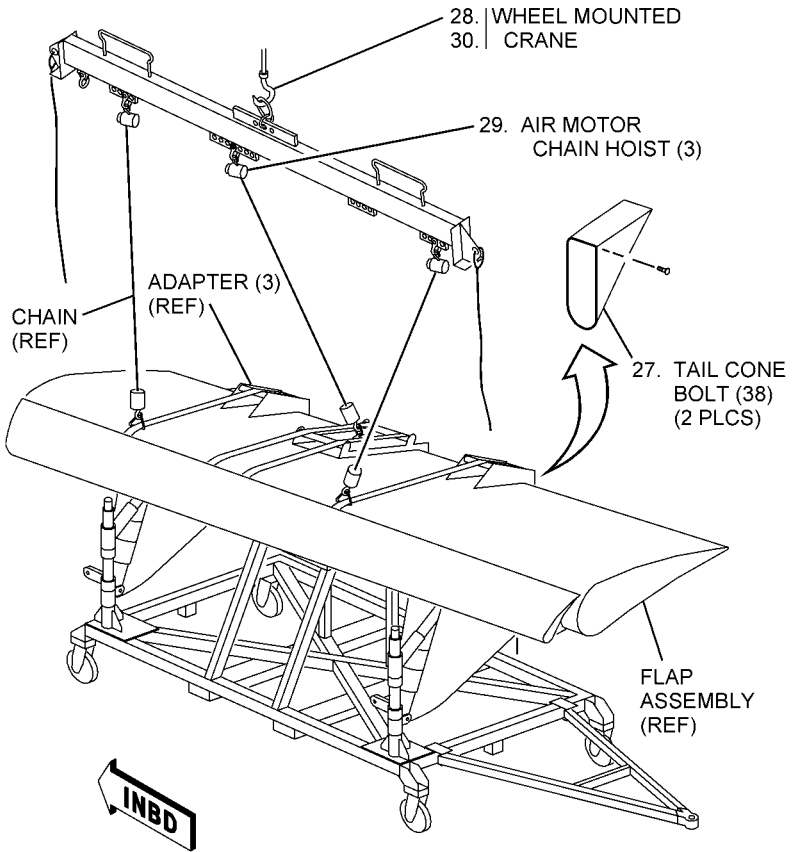
24.

FLAP REF DES	INDEX NO.	ADAPTER NO.	LOCATION	TOP STRAP (17G113482)	BOTTOM STRAP (17G113482)
2751AA002	1	17G110482-195	INBOARD	-531	-1
		17G110482-197	OUTBOARD	-529	-1
2751AA005	2	17G110482-203	CENTER	-1	-1
				-515	-515

ICN-88277-G2751132-006-01

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



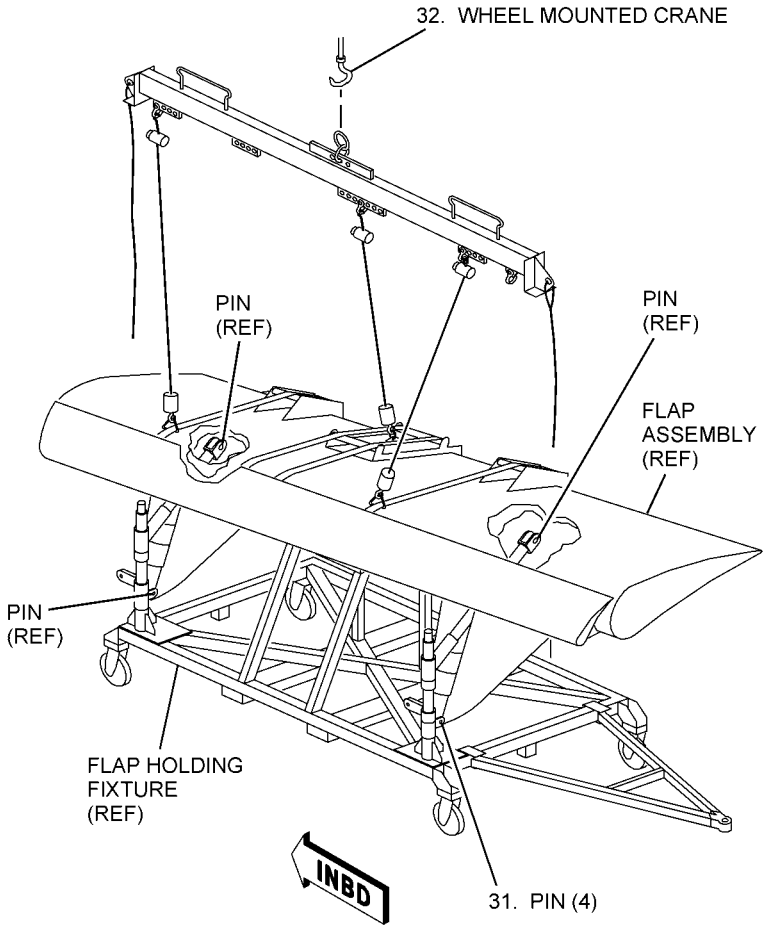
(TYPICAL)

ICN-88277-G2751123-007-01

NOTE

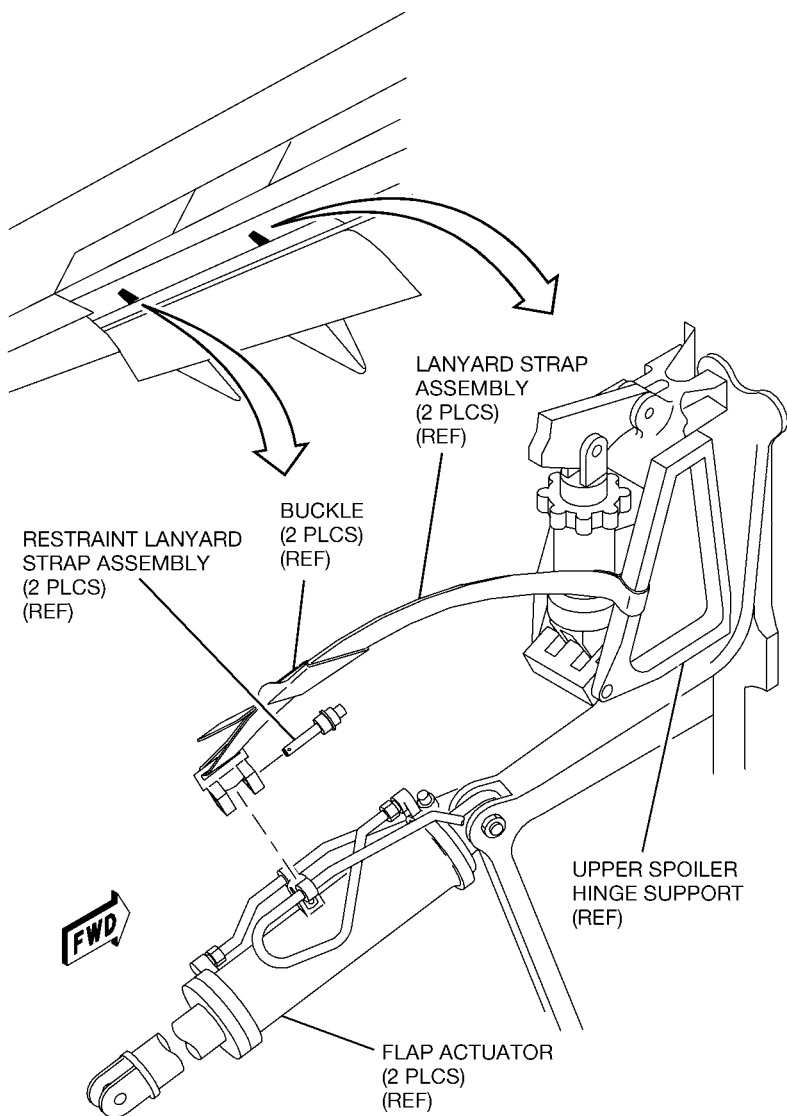
Verify the installation of the restraint lanyard strap assembly on flap actuators and positioning of the actuators prior to flap installation.

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-G2751083-008-01



(TYPICAL)

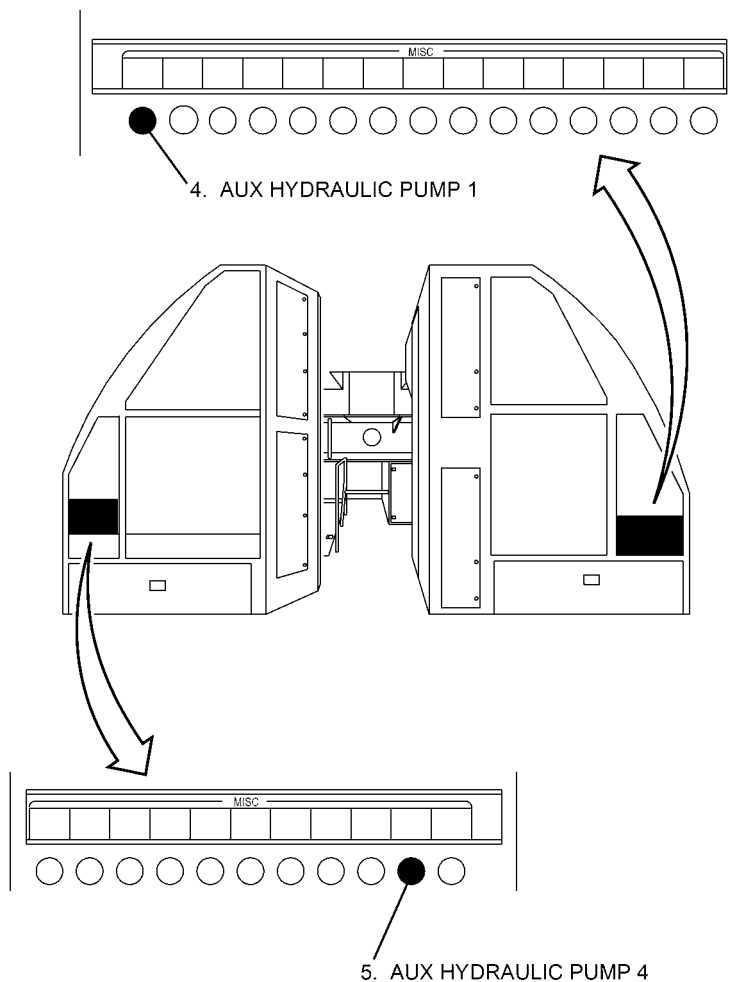
ICN-88277-G2751182-001-01

3-1A. PREPARATION FOR 2751AA002 AND 2751AA005 USING PN 17G110482-505.

NOTE

When performing flap assembly installation using hoisting adapter set PN 17G110482-505, if kit is unavailable, contact Boeing engineering.

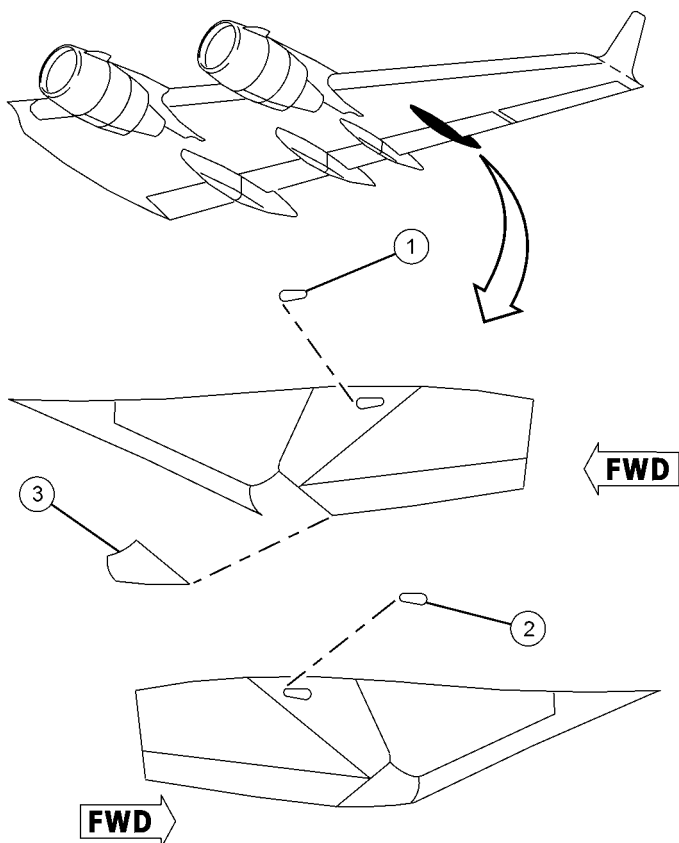
1. Review "Section 1 (General Information)" of this TO for system general warnings, cautions, and notes.
2. Review task "Functional Input Conditions" page for task specific safety conditions.
3. Install outboard spoiler positioning support assembly (05-10-04, tasks 04-1 and 04-3).
4. (A) Open **AUX HYDRAULIC PUMP 1** circuit breaker on Electrical Power Center (EPC), row **LL**, column **68**, and attach warning tag.
5. (A) Open **AUX HYDRAULIC PUMP 4** circuit breaker on EPC, row **LL**, column **10**, and attach warning tag.



ICN-88277-G2751227-001-01

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

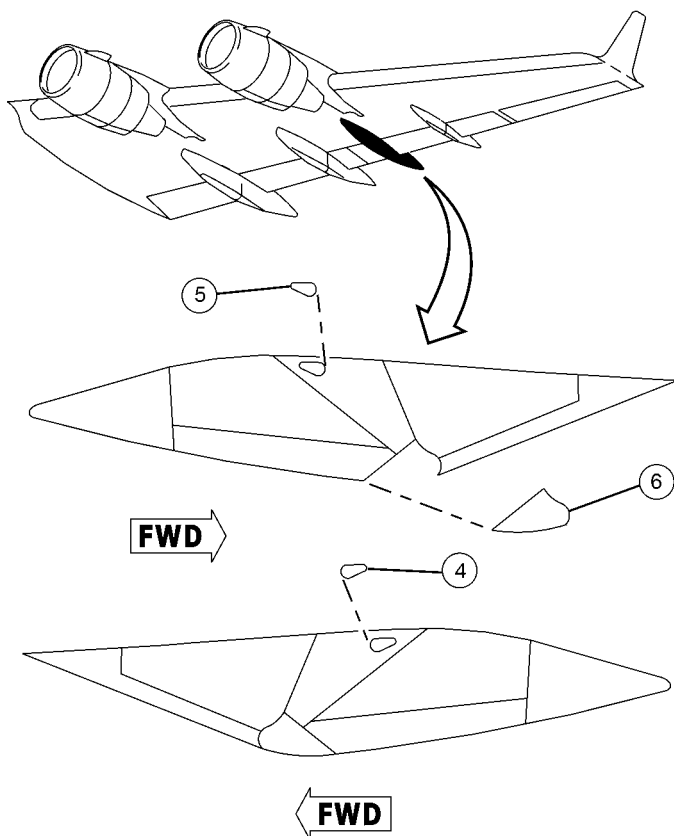
6. (B,D,E,F) Remove fasteners and access panels.
7. (B,D,E,F) Remove fasteners and access covers.



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

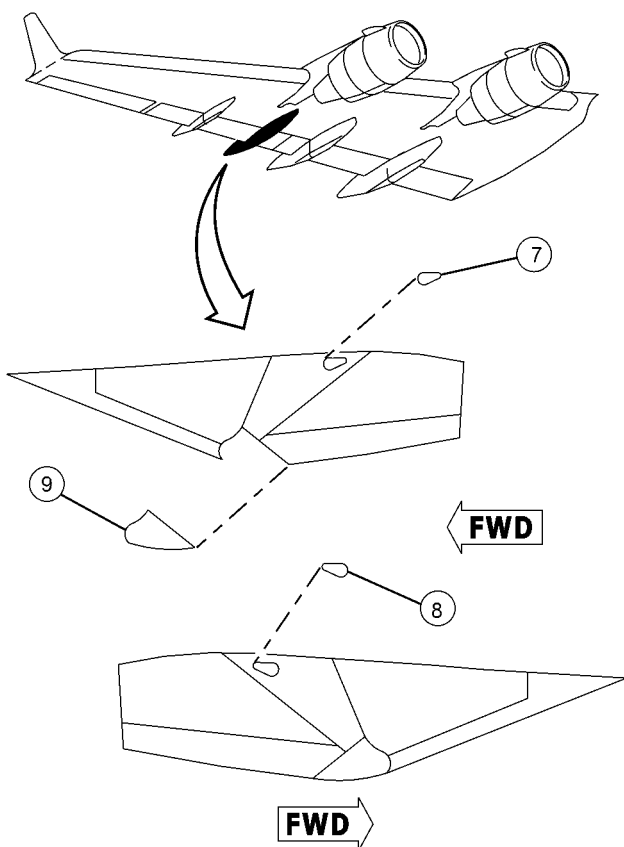
7.	FLAP REF DES	INDEX NO.	ACCESS COVER	FASTENER QTY
		3	573FBC	16
	2751AA002			

ICN-88277-G2751228-001-01



6.	FLAP REF DES	INDEX NO.	ACCESS PANEL	FASTENER QTY
	2751AA002	4	573ALC	12
		5	573BRC	12
7.	FLAP REF DES	INDEX NO.	ACCESS COVER	FASTENER QTY
	2751AA002	6	573CBC	17

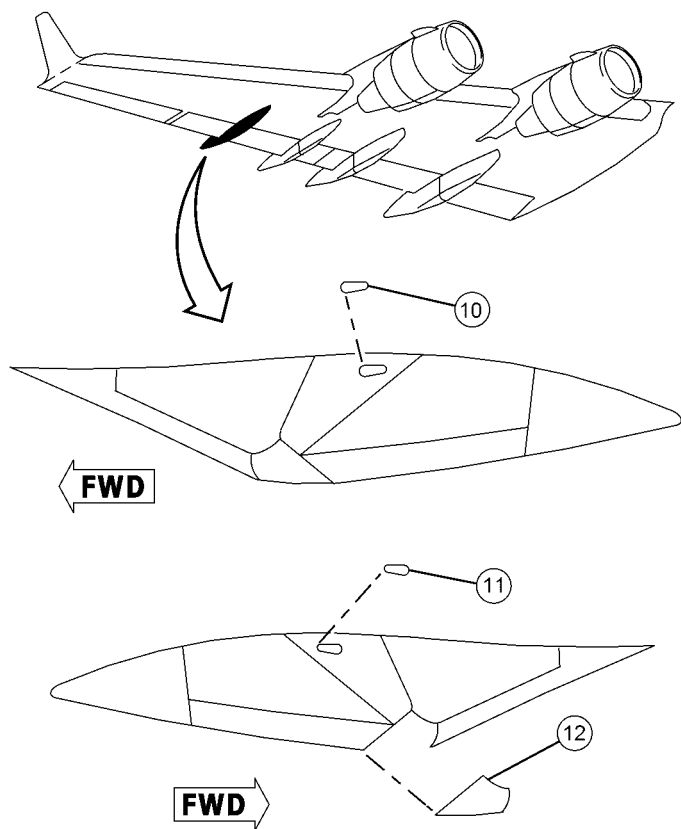
ICN-88277-G2751229-001-01



6.	FLAP REF DES	INDEX NO.	ACCESS PANEL	FASTENER QTY
		7	673ALC	12
	2751AA005	8	673BRC	12

7.	FLAP REF DES	INDEX NO.	ACCESS COVER	FASTENER QTY
		9	673CBC	17

ICN-88277-G2751230-001-01



6.	FLAP REF DES	INDEX NO.	ACCESS PANEL	FASTENER QTY
	2751AA005	10	673DLC	12
		11	673ERC	12

7.	FLAP REF DES	INDEX NO.	ACCESS COVER	FASTENER QTY
	2751AA005	12	673FBC	17

ICN-88277-G2751231-001-01

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 center of vane in choker configuration; remove slack from sling.

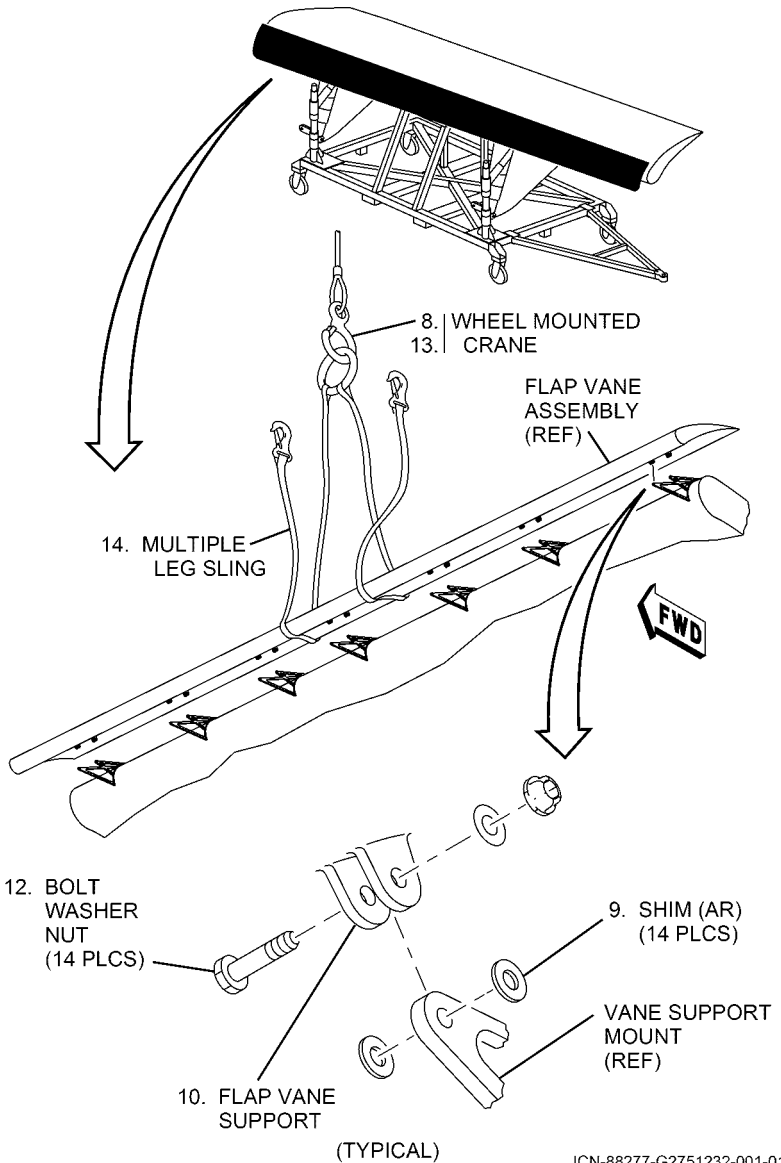
NOTE

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:

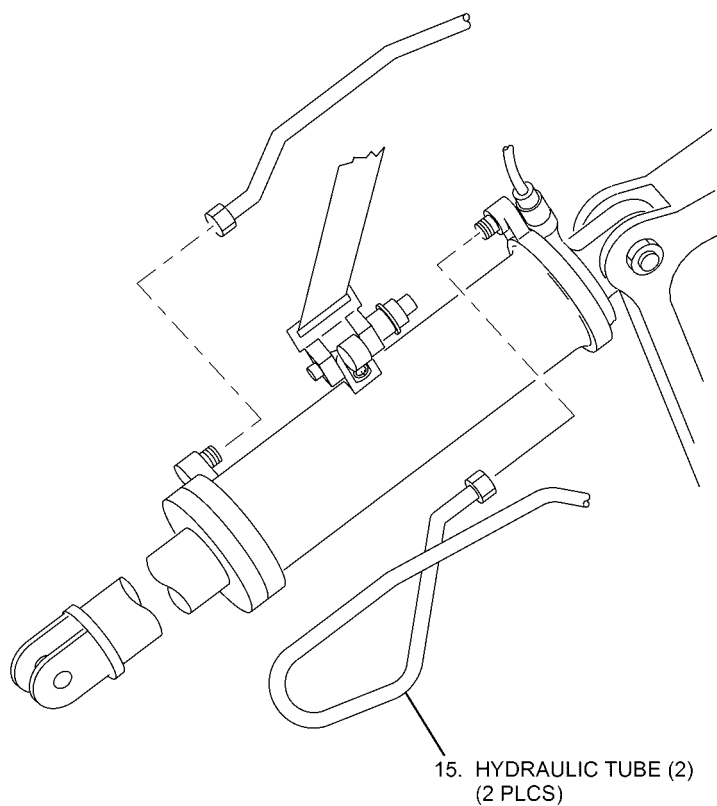
BOLT TYPE	TORQUE (in-lb)
NAS6804	50-70
NAS6805	100-140
NAS6806	160-190

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



ICN-88277-G2751232-001-01

15. (A,B) Disconnect hydraulic tubes.

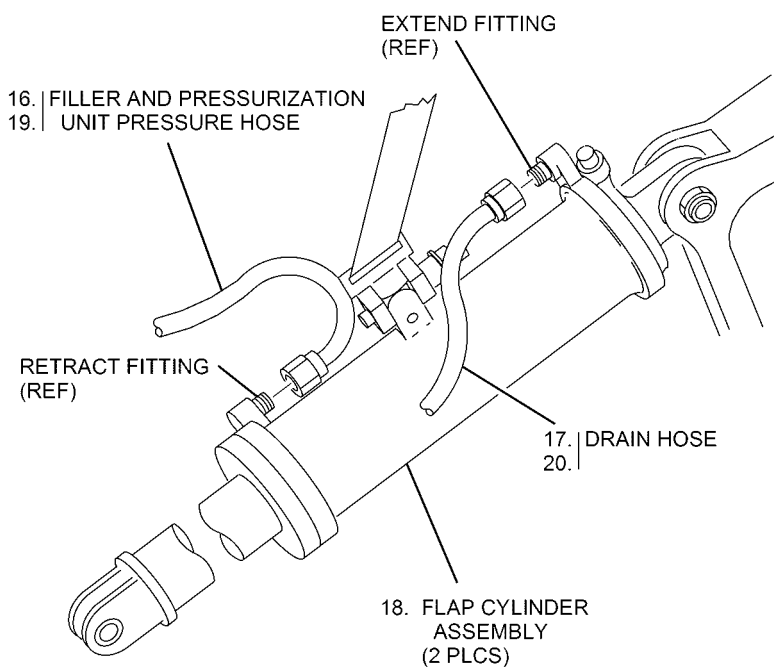


(TYPICAL)

ICN-88277-G2751233-001-01

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)

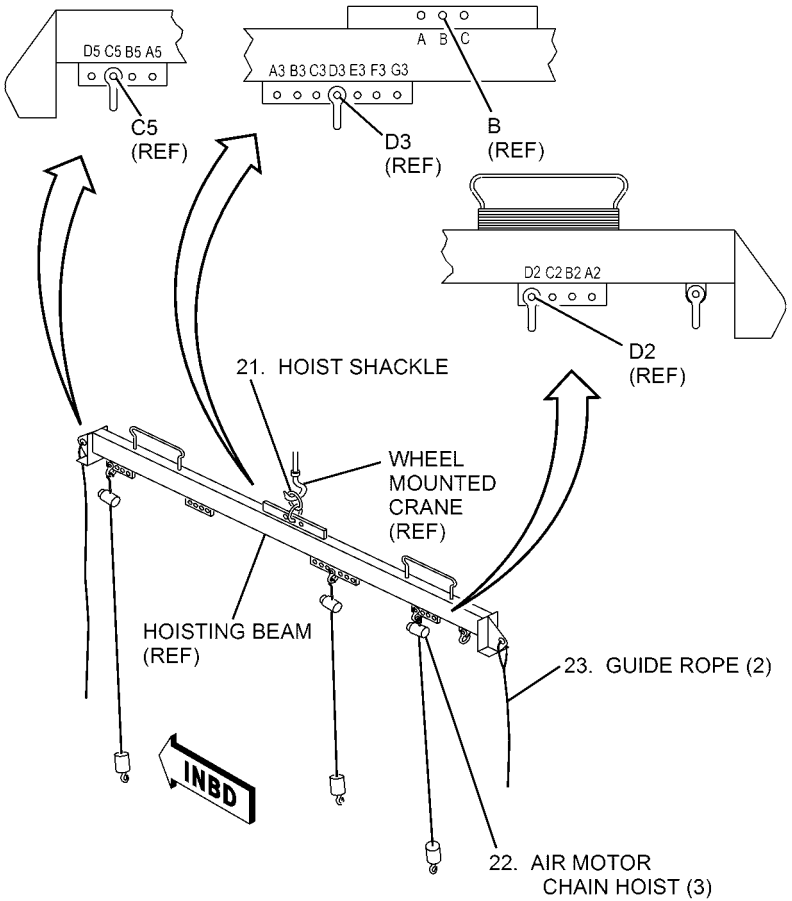
ICN-88277-G2751234-001-01

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
D2	D3	C5

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



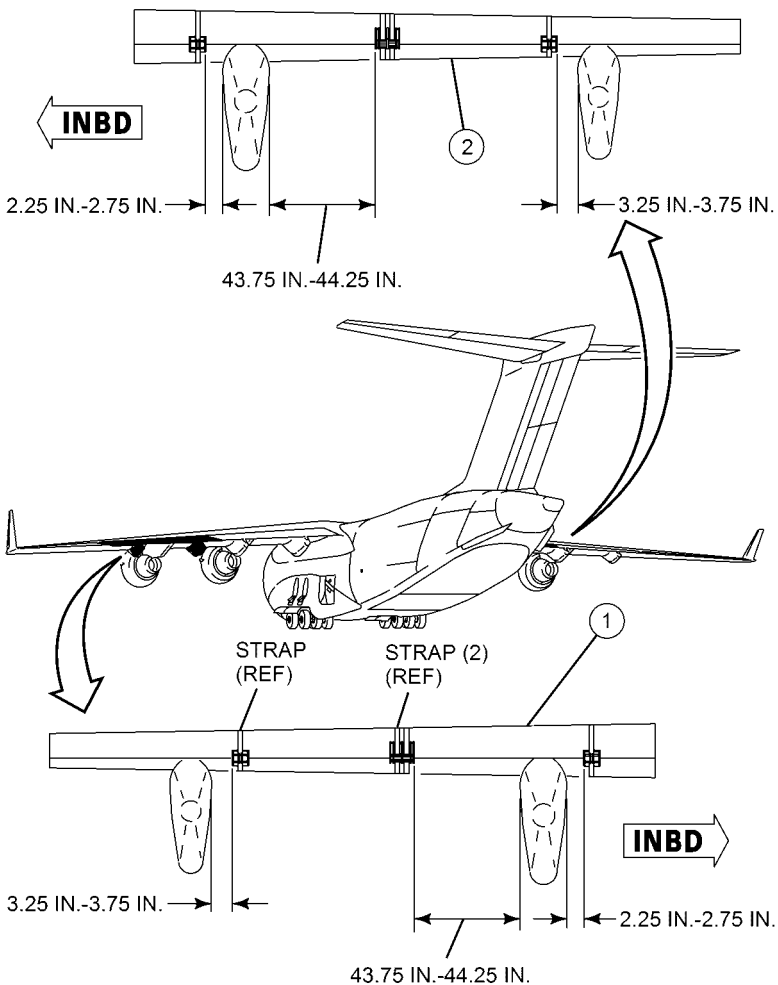
(TYPICAL)

ICN-88277-G2751235-001-01

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)	
	2751AA002	1	17G110482-215	INBOARD	-539		-1	
			17G110482-217	OUTBOARD	-537		-1	
	2751AA005	2	17G110482-203	CENTER	-1	-1	-515	-515

ICN-88277-G2751236-001-01

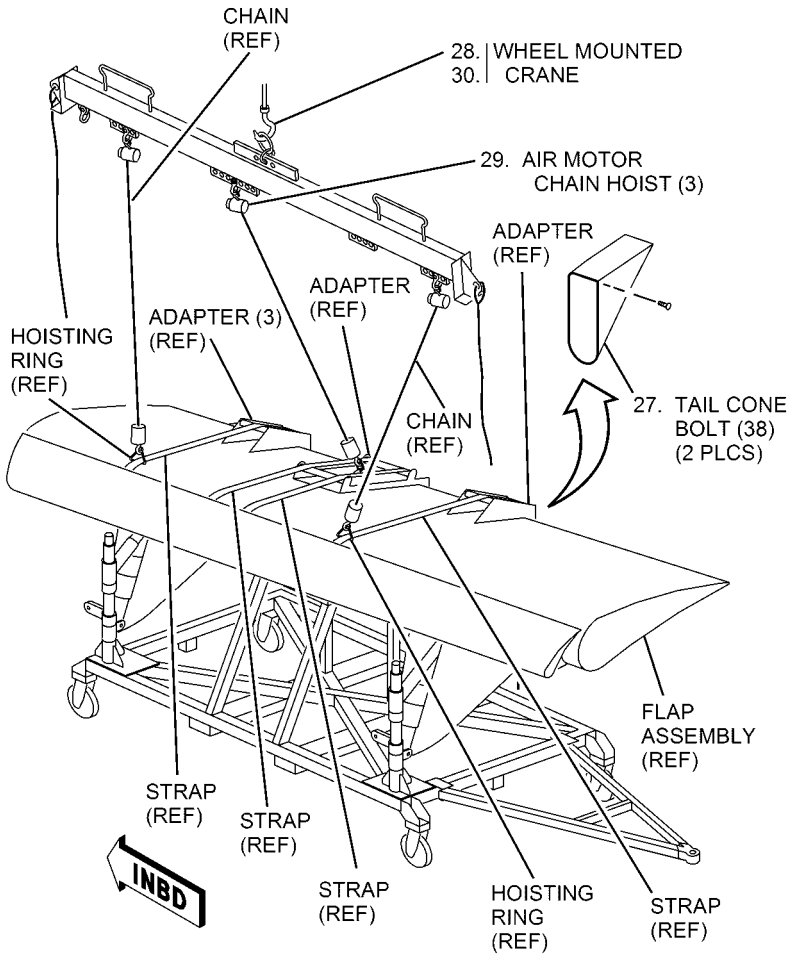
TO 1300i-2-27JG-50-2

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 and remove slack from chains.



(TYPICAL)

ICN-88277-G2751237-001-01

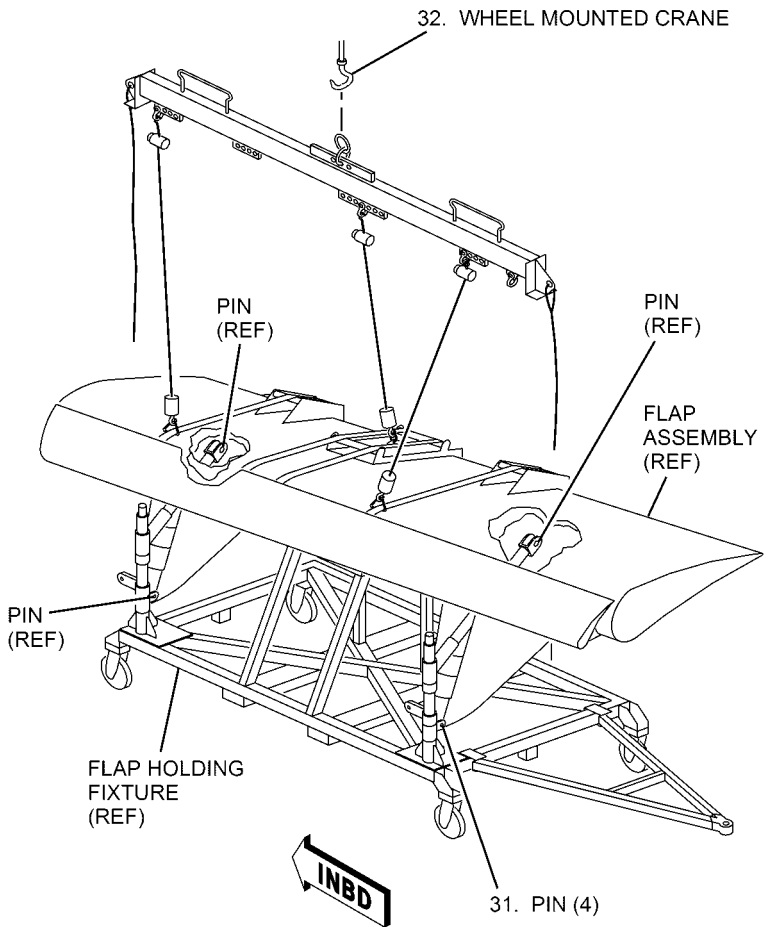
WARNING

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.

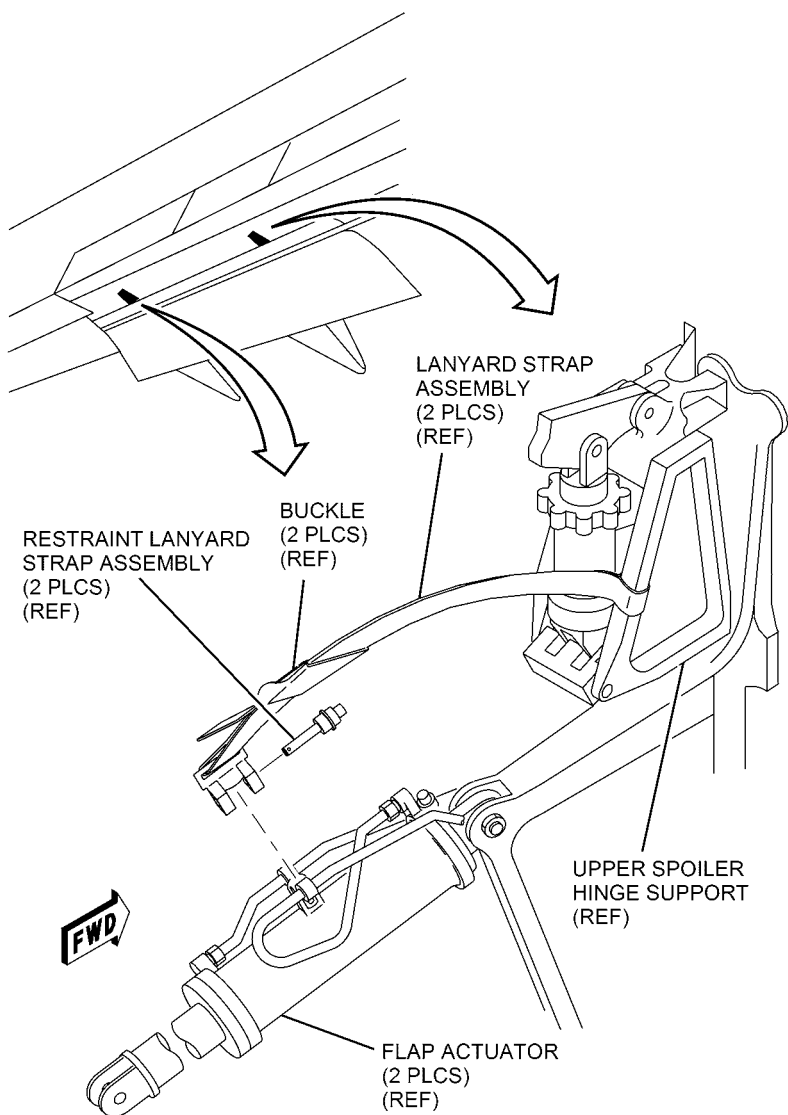
31. (E,F) Remove pins.
32. (A,B,C,D,E,F) Operate wheel mounted crane; remove flap and vane structural assembly from flap holding fixture and position for installation.



(TYPICAL)

ICN-88277-G2751238-001-01

27-51-10-3
2-157



(TYPICAL)

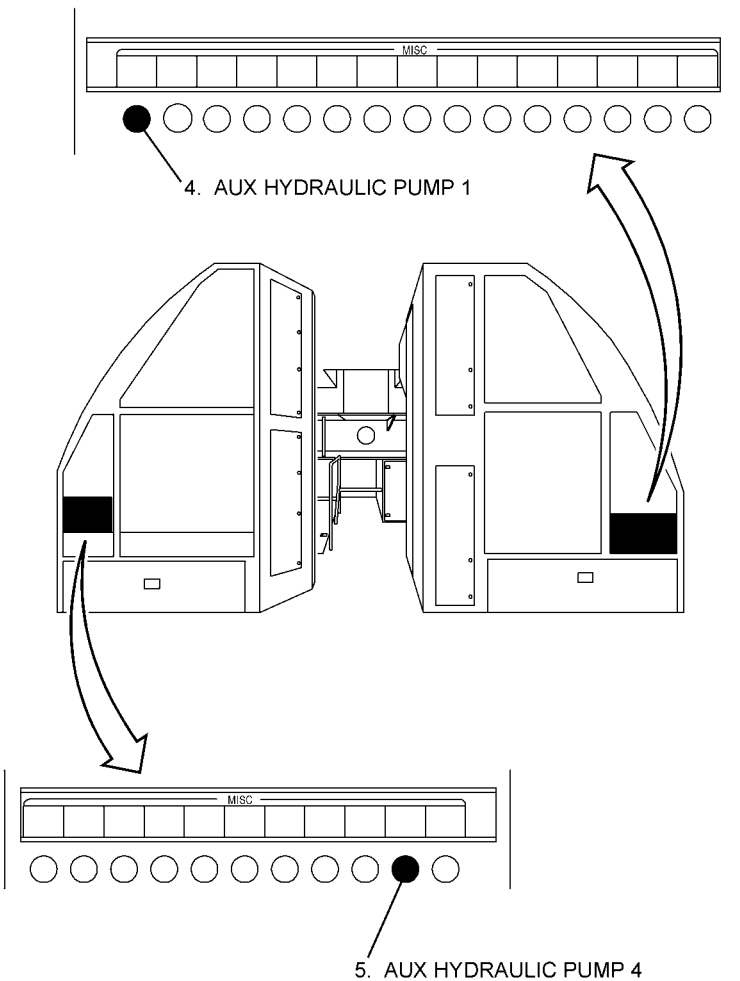
ICN-88277-G2751239-001-01

3-2. PREPARATION FOR 2751AA003 AND 2751AA004.

WARNING

Flap assembly installation using the 17G110482-503 adapter set shall be temporarily halted until further notice. Hoisting adapter set 17G110482-503 contains defective 17G113482-525 and 17G113482-527 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.

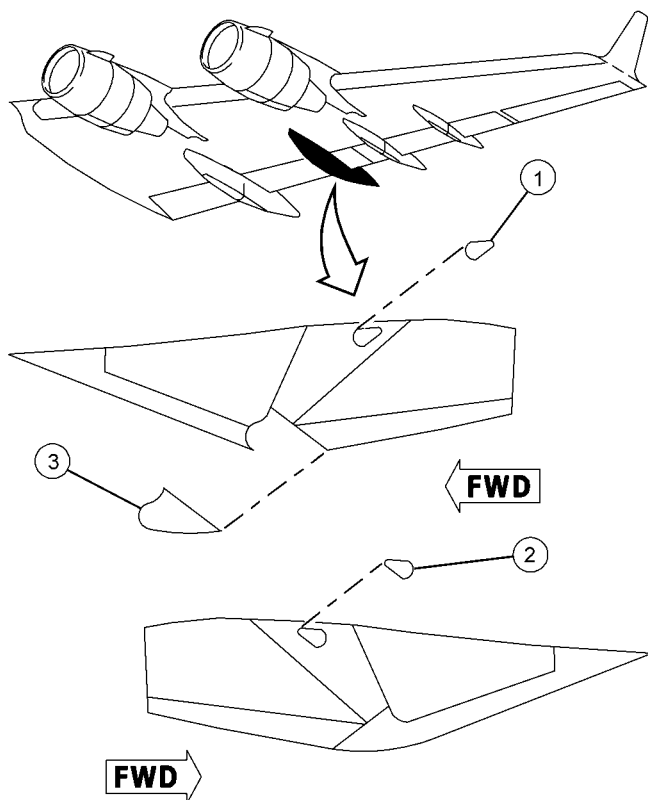
1. Review "Section 1 (General Information)" of this TO for system general warnings, cautions, and notes.
2. Review task "Functional Input Conditions" page for task specific safety conditions.
3. Install inboard spoiler positioning support assembly (05-10-04, tasks 04-1 and 04-2).
4. (A) Open **AUX HYDRAULIC PUMP 1** circuit breaker on Electrical Power Center (EPC), row **LL**, column **68**, and attach warning tag.
5. (A) Open **AUX HYDRAULIC PUMP 4** circuit breaker on EPC, row **LL**, column **10**, and attach warning tag.



ICN-88277-G2751174-004-01

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

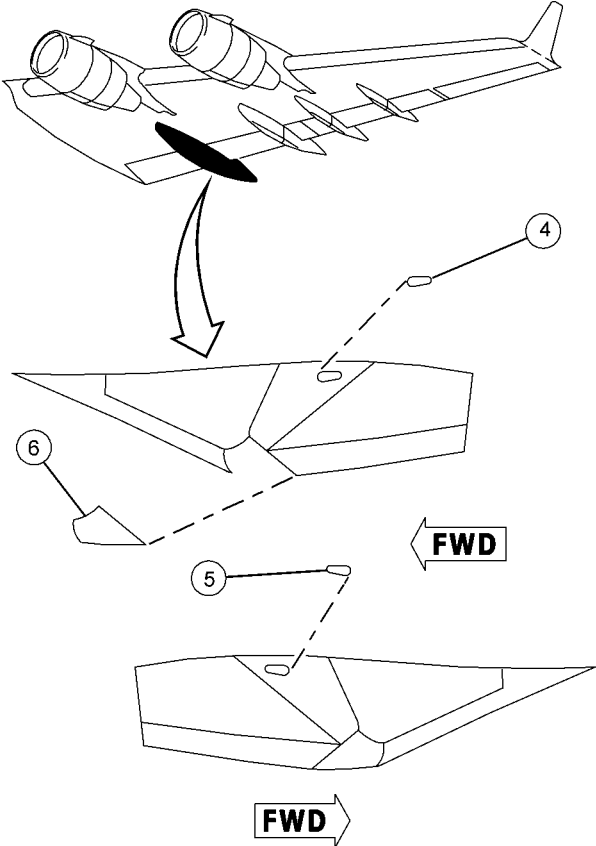
6. (B,D,E,F) Remove fasteners and access panels.
7. (B,D,E,F) Remove fasteners and access covers.



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

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

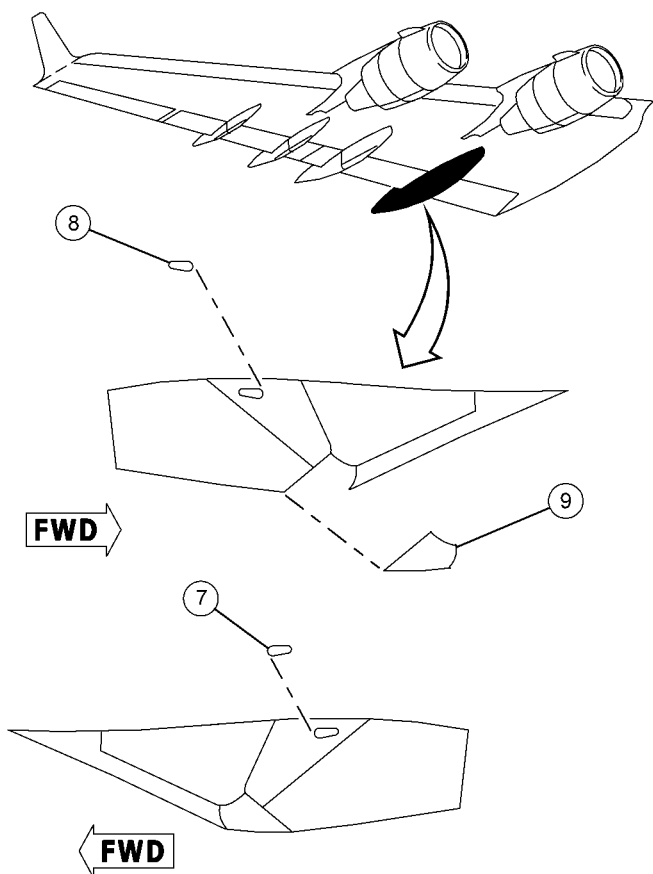
ICN-88277-G2751133-005-01



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

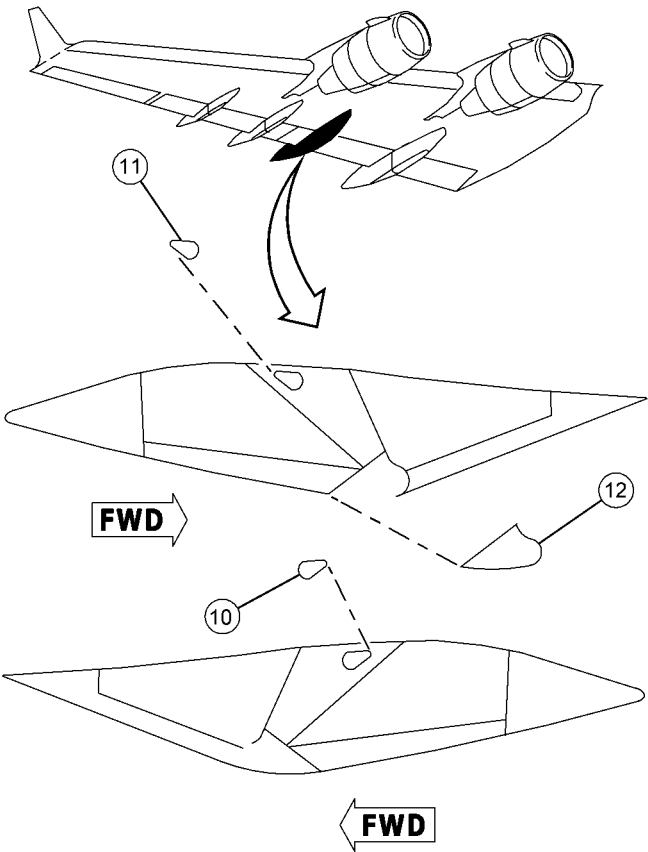
7.	FLAP REF DES	INDEX NO.	ACCESS COVER	FASTENER QTY
	2751AA003	6	571CBC	23

ICN-88277-G2751158-004-01



6.	FLAP REF DES	INDEX NO.	ACCESS PANEL	FASTENER QTY
		7	671ALC	12
		8	671BRC	12
7.	FLAP REF DES	INDEX NO.	ACCESS COVER	FASTENER QTY
		9	671CBC	23

ICN-88277-G2751159-004-01



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

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

ICN-88277-G2751160-003-01

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.

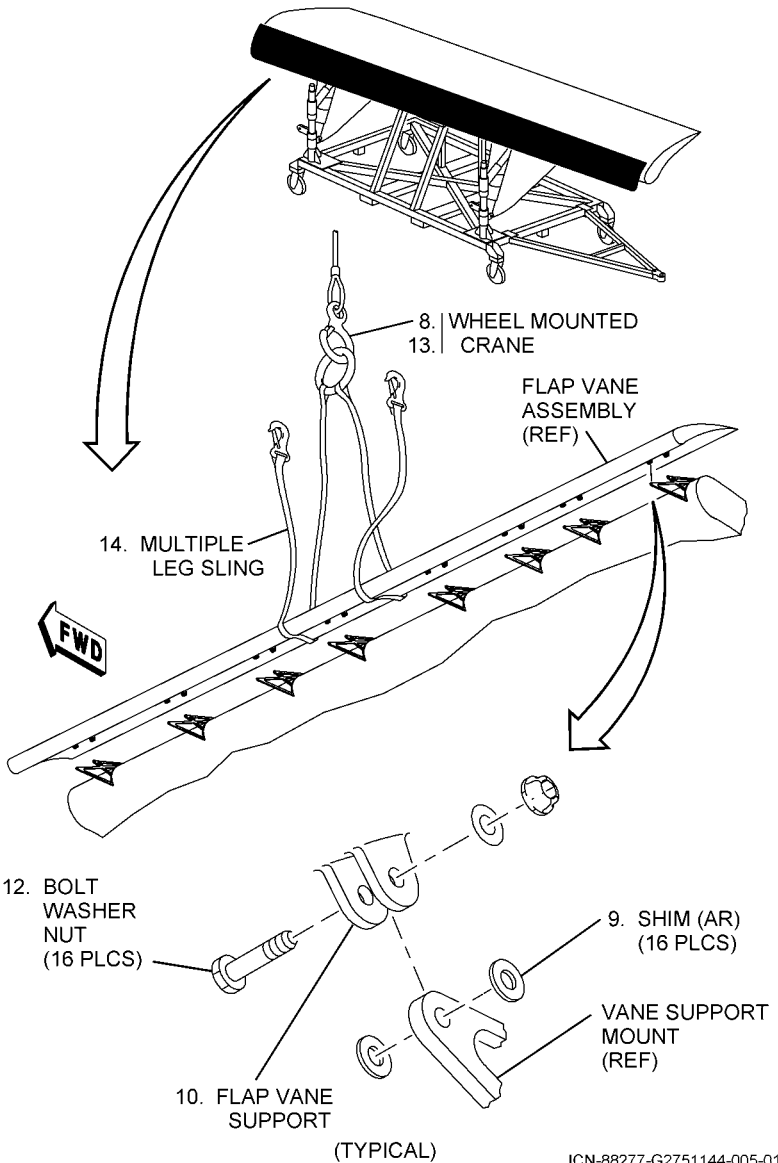
NOTE

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:

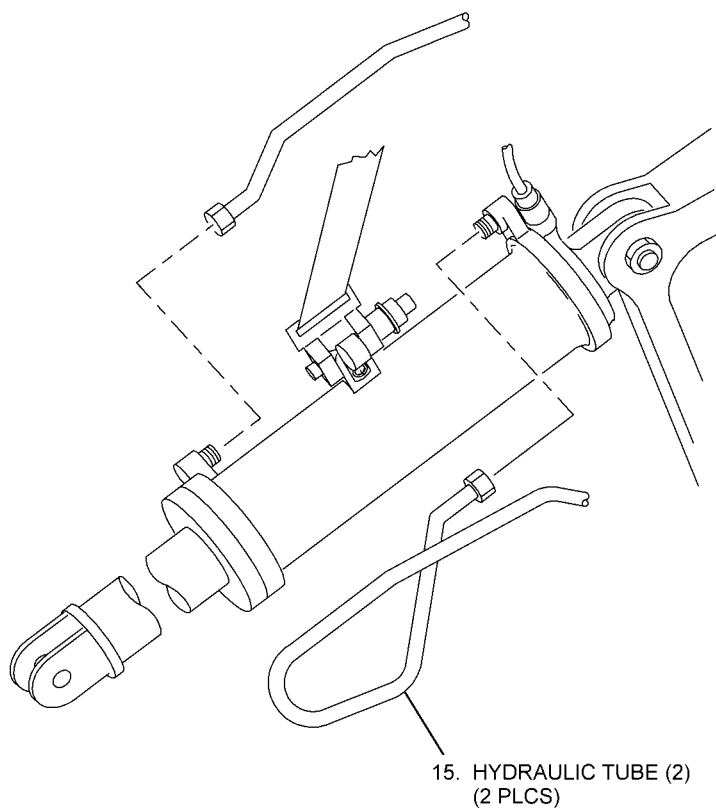
BOLT TYPE	TORQUE (in-lb)
NAS6804	50-70
NAS6805	100-140
NAS6806	160-190

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.



ICN-88277-G2751144-005-01

15. (A,B) Disconnect hydraulic tubes.

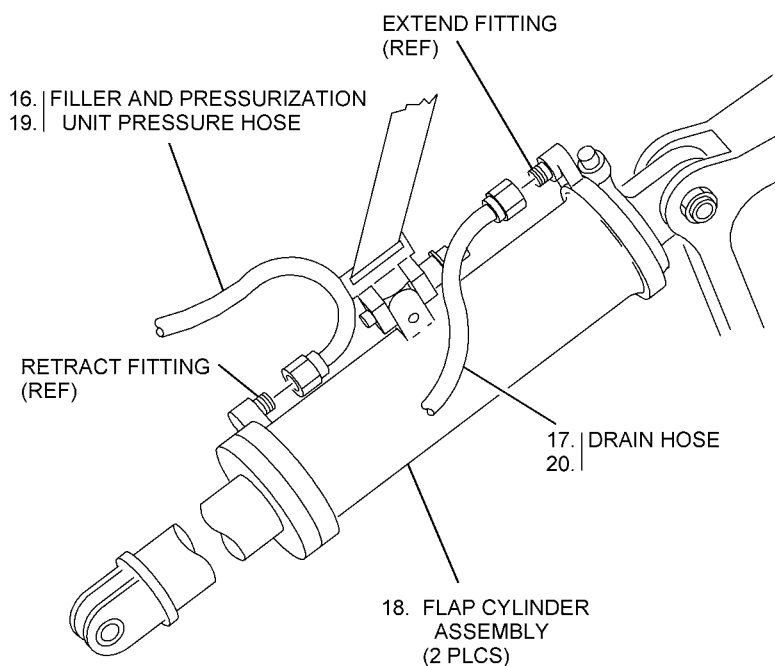


(TYPICAL)

ICN-88277-G2751145-004-01

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)

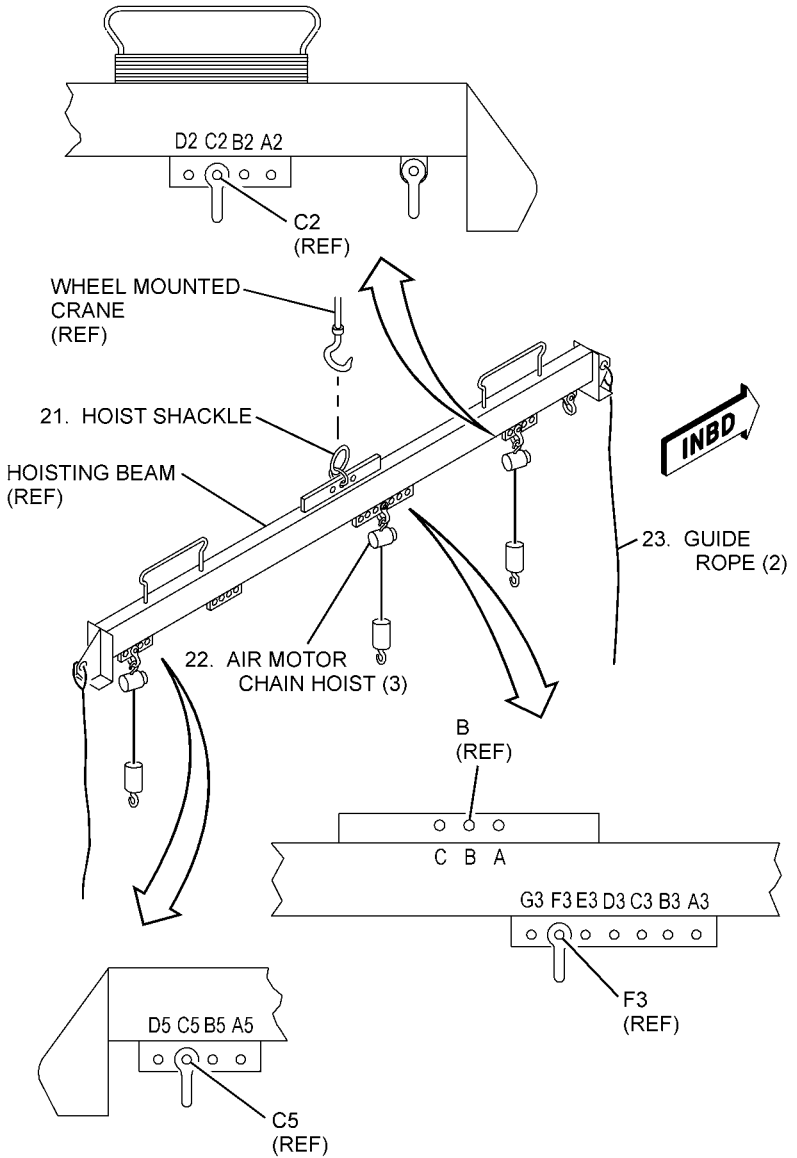
ICN-88277-G2751146-003-01

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:

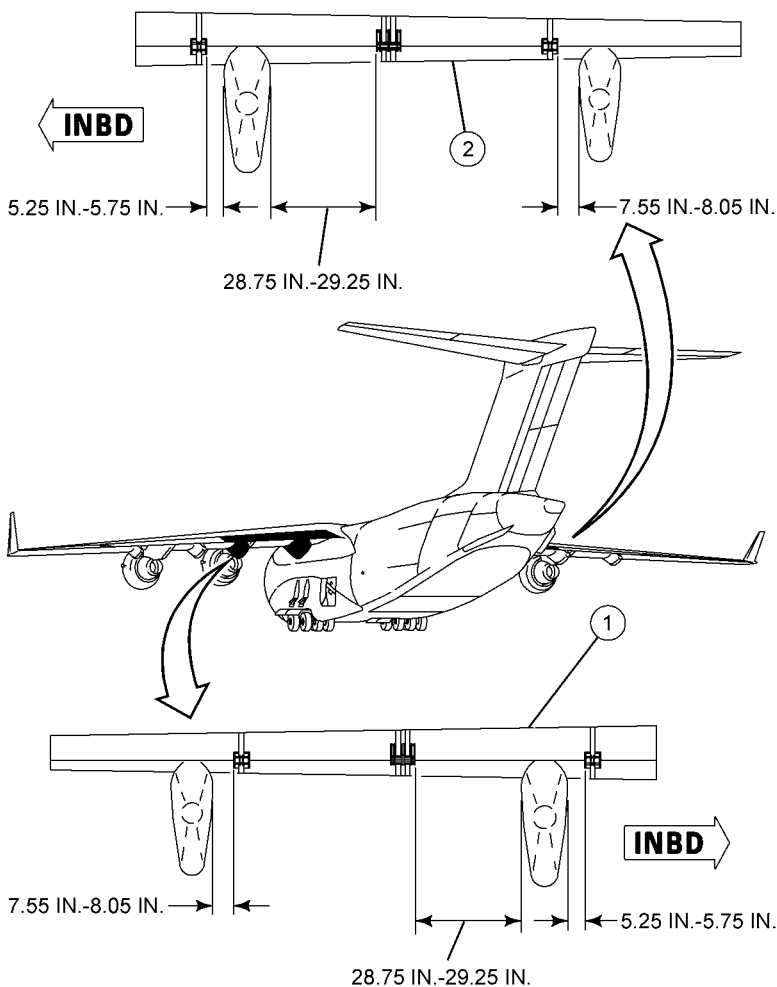
HOIST BEAM HOLE		
SECTION 2	SECTION 3	SECTION 5
C2	F3	C5

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



ICN-88277-G2751138-005-01

24. (B,D,E,F) Position adapters and torque straps **30-35 ft-lbs.**

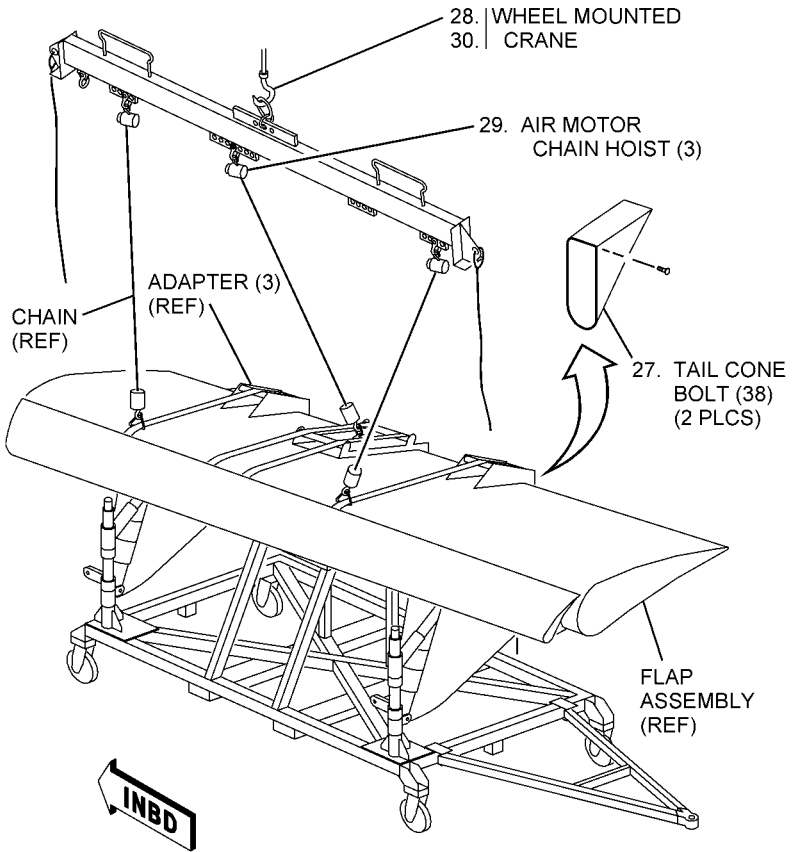


24.	FLAP REF DES	INDEX NO.	ADAPTER NO.	LOCATION	TOP STRAP (17G113482)		BOTTOM STRAP (17G113482)	
	2751AA003	1	17G110482-199	INBOARD	-525		-1	
			17G110482-201	OUTBOARD	-527		-1	
	2751AA004	2	17G110482-205	CENTER	-1	-1	-513	-513

ICN-88277-G2751134-005-01

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



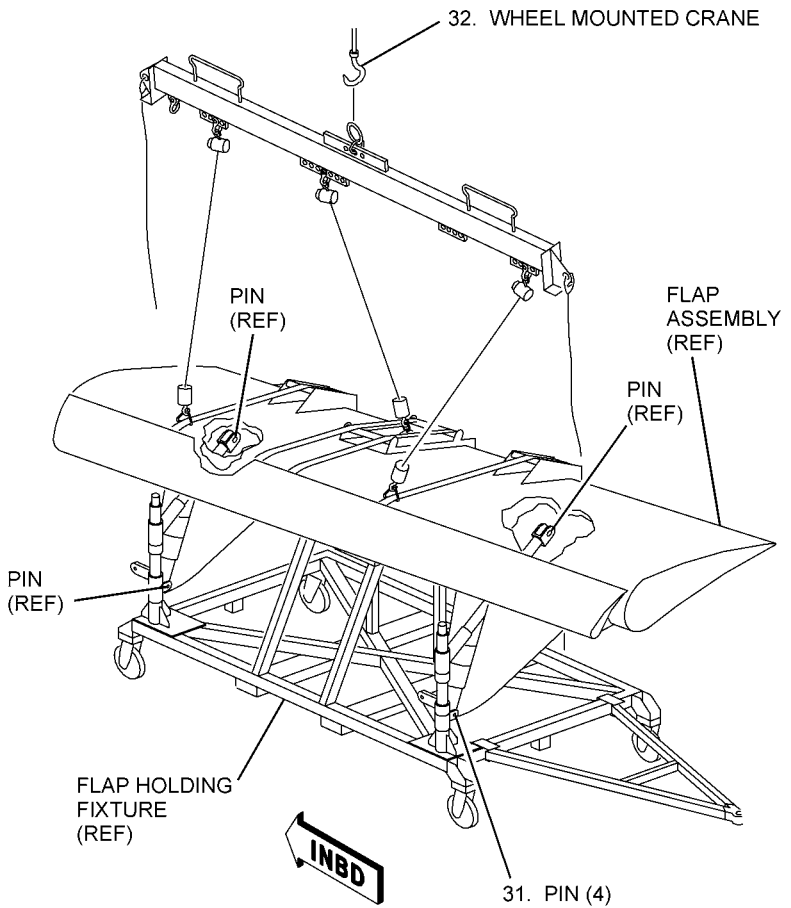
(TYPICAL)

ICN-88277-G2751135-005-01

NOTE

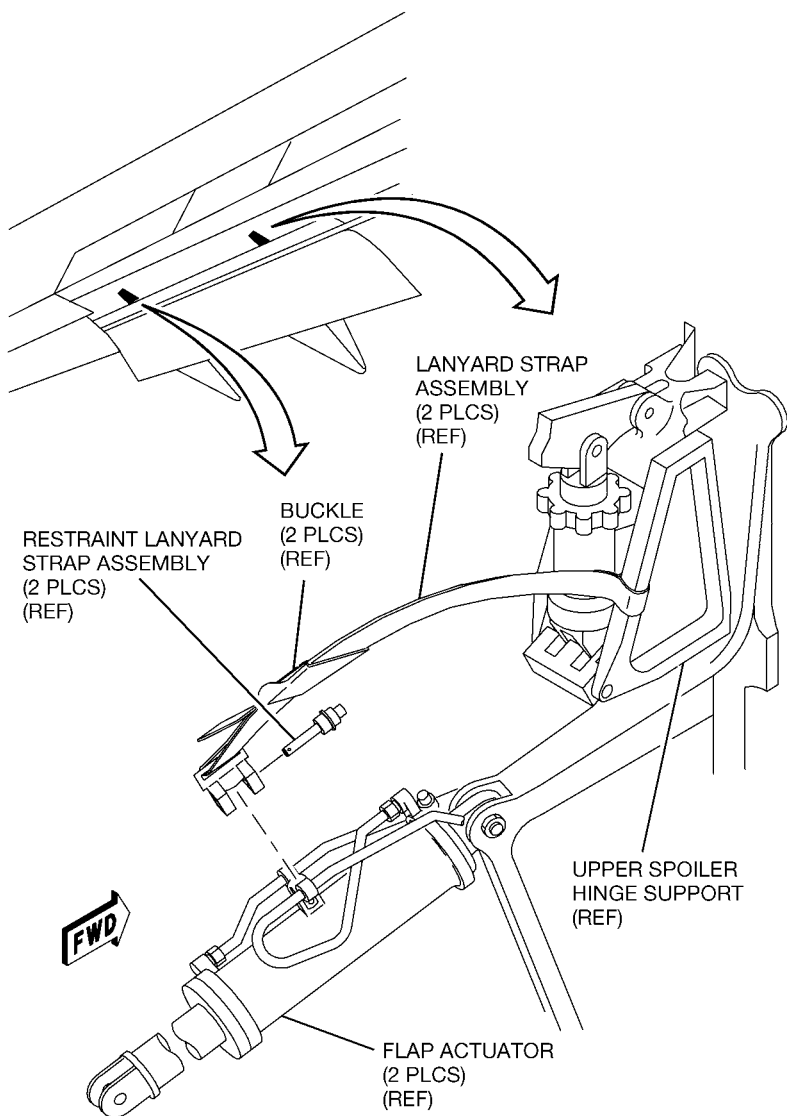
Verify the installation of the restraint lanyard strap assembly on flap actuators and positioning of the actuators prior to flap installation.

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-G2751082-008-01



(TYPICAL)

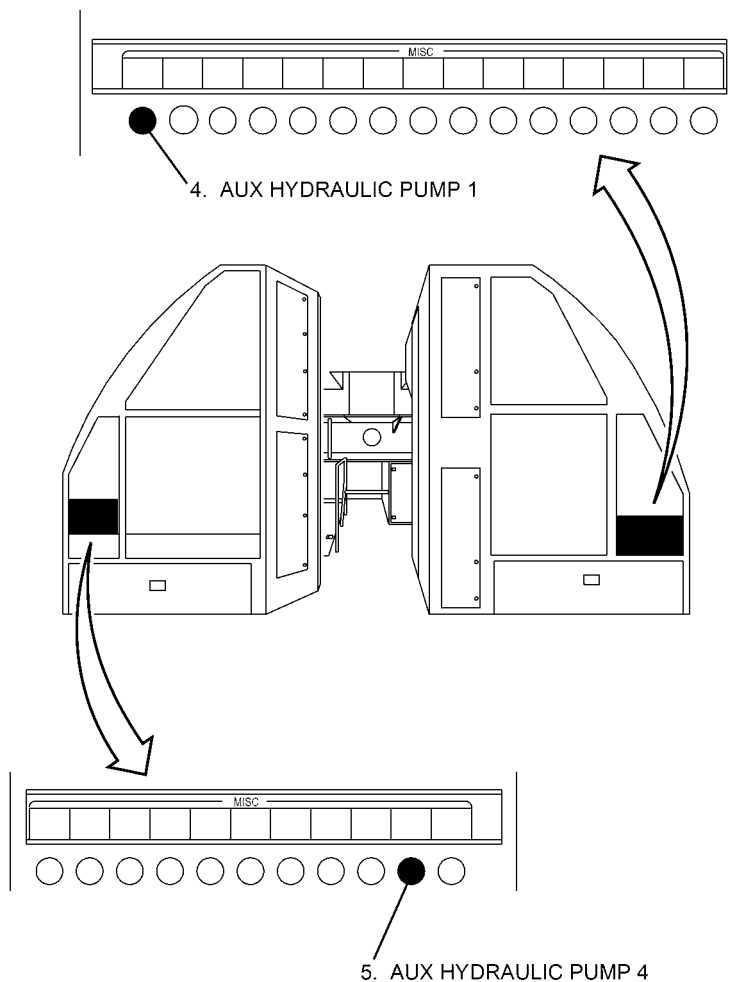
ICN-88277-G2751183-001-01

3-2A. PREPARATION FOR 2751AA003 AND 2751AA004 USING PN 17G110482-505.

NOTE

When performing flap assembly installation using hoisting adapter set PN 17G110482-505, if kit is unavailable, contact Boeing engineering.

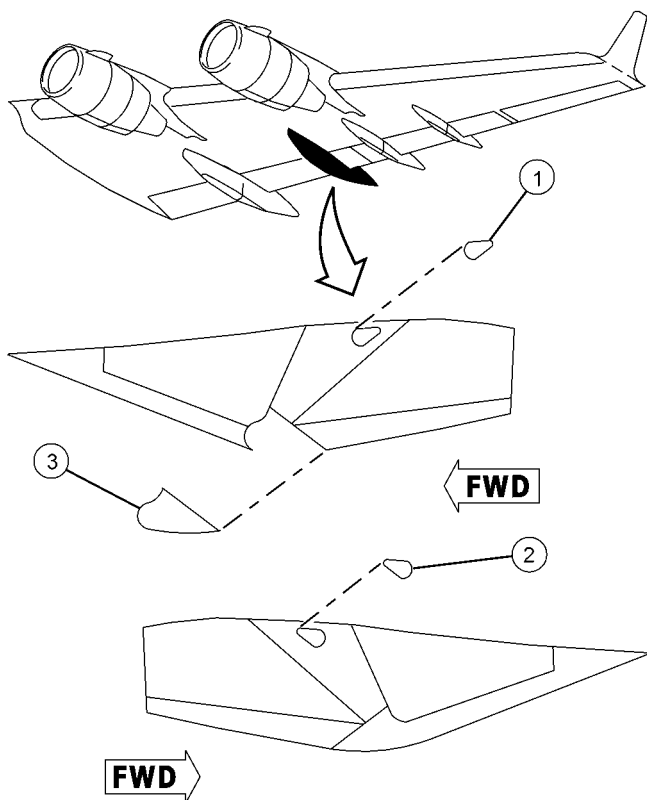
1. Review "Section 1 (General Information)" of this TO for system general warnings, cautions, and notes.
2. Review task "Functional Input Conditions" page for task specific safety conditions.
3. Install inboard spoiler positioning support assembly (05-10-04, tasks 04-1 and 04-2).
4. (A) Open **AUX HYDRAULIC PUMP 1** circuit breaker on Electrical Power Center (EPC), row **LL**, column **68**, and attach warning tag.
5. (A) Open **AUX HYDRAULIC PUMP 4** circuit breaker on EPC, row **LL**, column **10**, and attach warning tag.



ICN-88277-G2751240-001-01

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

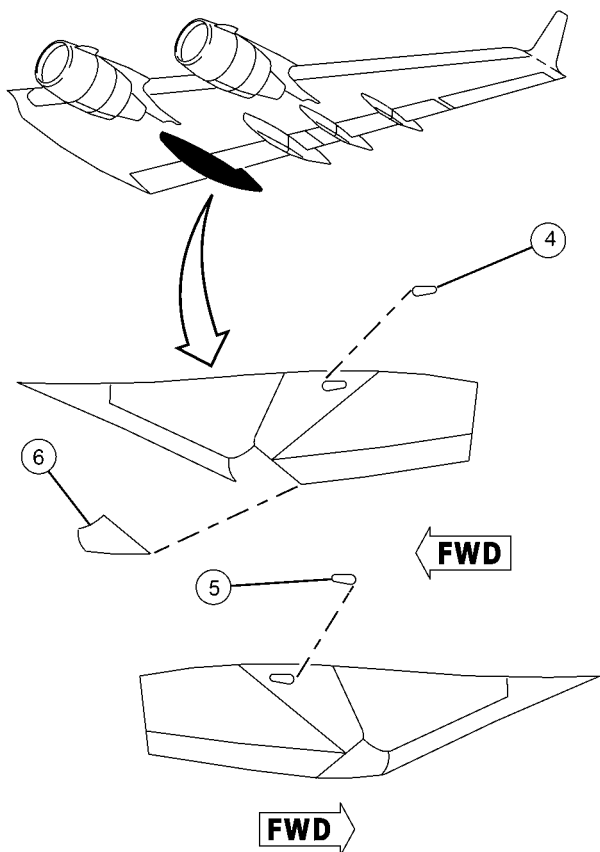
6. (B,D,E,F) Remove fasteners and access panels.
7. (B,D,E,F) Remove fasteners and access covers.



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

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

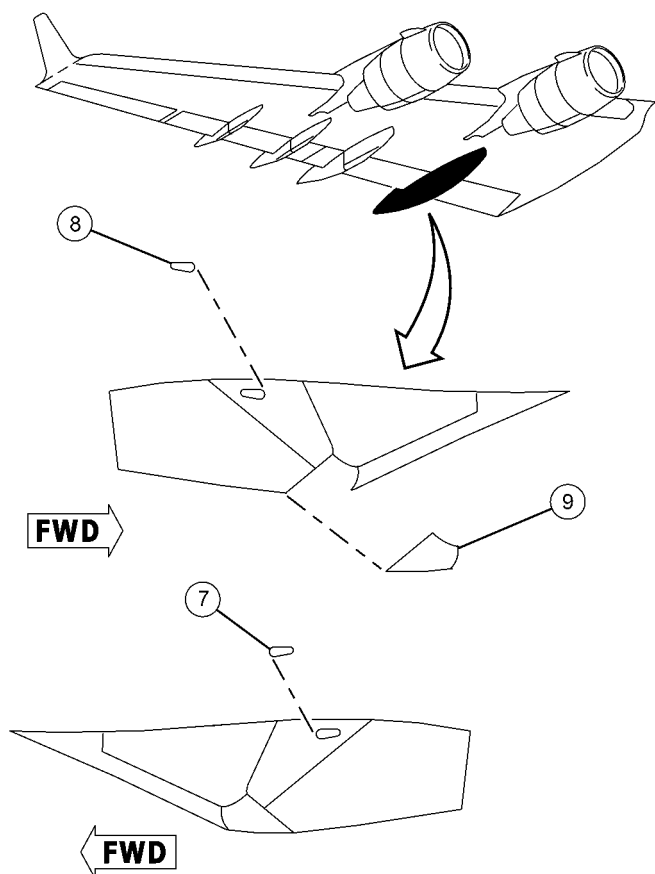
ICN-88277-G2751241-001-01



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

7.	FLAP REF DES	INDEX NO.	ACCESS COVER	FASTENER QTY
		6	571CBC	23

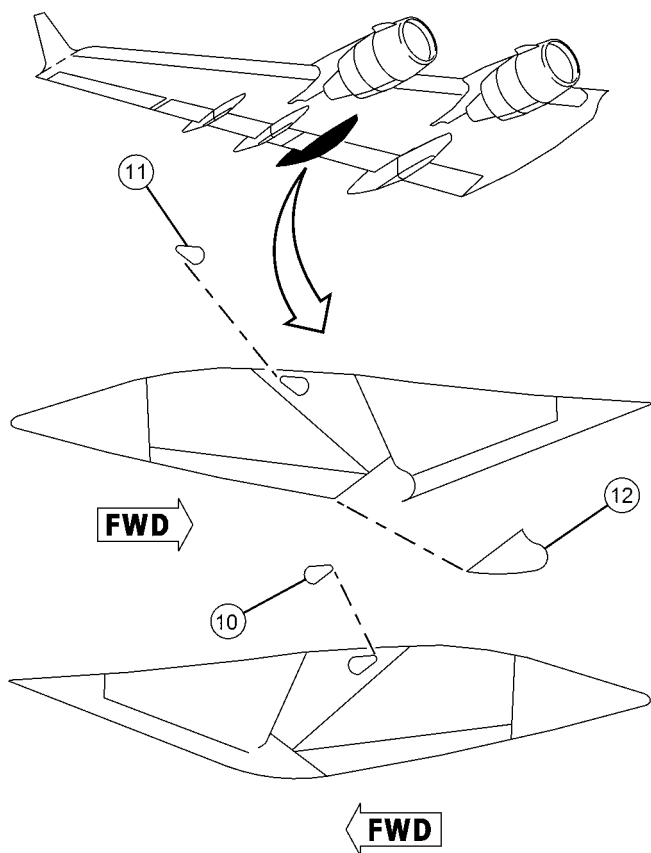
ICN-88277-G2751242-001-01



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

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

ICN-88277-G2751243-001-01



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

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

ICN-88277-G2751244-001-01