

1. Approving Civil Aviation
Authority Country:

FAA/UNITED STATES

2

AUTHORIZED RELEASE CERTIFICATE

FAA Form 8130-3
AIRWORTHINESS APPROVAL TAG

3 Form Tracking Number:

N-184517

4. Organization Name and Address

Aviation Technical Services, Inc.
3121 109th St.SW
Everett, WA 98204

FAA Approved
Repair Station No. HN6R593N

5. Work Order/Contract/Invoice Number:

Work Order: 548161

Customer PO: R3922863

6. Item:	7. Description	8. Part Number	9. Quantity	10. Serial Number	11. Status/Work
1	STAB TRIM ACTUATOR	251A4510-12	1	KE00027	Overhauled

12. Remarks:

Documents describing the actual work performed on work order #548161 are provided. Note: See attached parts usage list for all replacement parts used. The described work was performed in accordance with FAA accepted / approved data for return to service by personnel who were part of a current drug and alcohol testing program as required by 14CFR120.

Manufactured by: BOEING

STAB TRIM ACTUATOR P/N 251A4510-6 HAS BEEN MODIFIED TO 251A4510-12 BY REPLACING THE BALL SCREW ASSY WITH A 07322P000-04 BALL SCREW ASSY.
STAB TRIM ACTUATOR HAS BEEN OVERHAULED AND BENCH TESTED PER BOEING CMM 27-45-12 REV 58 DATED 01-NOV-2023 & ATS ENG 22-01775 REV IR DATED 07-JUN-2022

NOTE: POST UMBRA SERVICE BULLETIN 07322-27-01 BALL SCREW ASSEMBLY INSTALLED ON UNIT. REMOVED FROM A/C# N372FL MSN 28327 TSO: 0 CSO: 0

Certifies that the work specified in Block 11/12 was carried out in accordance with EASA Part 145 and in respect to that work the article is considered ready for release to service under EASA Part 145 approval no. EASA 145-4942

13a. Certifies the items identified above were manufactured in conformity to:

- ☐ Approved design data and are in a condition for safe operation.
☐ Non-approved design data specified in Block 12.

14a. ☒ 14 CFR 43.9 Return to Service ☒ Other regulation specified in Block 12

Certifies that unless otherwise specified in Block 12, the work identified in Block 11 and described in Block 12 was accomplished in accordance with Title 14, Code of Federal Regulations, Part 43 and in respect to that work, the items are approved for return to service.

13b. Authorized Signature:	13c. Approval/Authorization No.:	14b. Authorized Signature:	14c. Approval/Certificate No.:
-N/A-	-N/A-	<i>Brian Wilkins</i>	HN6R593N
13d. Name (Typed or printed): -N/A-	13e. Date (dd/mm/yy): -N/A-	14d. Name (Typed or Printed): Wilkins, Brian L	14e. Date (dd/mm/yy): 21/NOV/2023

User/Installer Responsibilities

It is important to understand that the existence of this document alone does not automatically constitute authority to install the aircraft engine/propeller/article.

Where the user/installer performs work in accordance with the national regulations of an airworthiness authority different than the airworthiness authority of the country specified in Block 1 it is essential that the user/installer ensures that his/her airworthiness authority accepts aircraft engine(s)/propeller(s)/article(s) from the airworthiness authority of the country specified in Block 1.

Statements in Blocks 13a and 14a do not constitute installation certification. In all cases aircraft maintenance records must contain an installation certification issued in accordance with the national regulations by the user/installer before the aircraft may be flown.



Customer Name	A.J. WALTER AVIATION
Customer RO No	R392863
Manufacturer	BOEING
Job Number	548161

WORK ORDER

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Issues and Resolutions

Resolution

All Parts Listed In CMM Pg. 501-502 Par. 2. B. (3) Passed Penetrant Inspection Per SOPM 20-20-02 & CMM CMM Pg. 501-502 Par. 2. B. (3) and was recorded on TR-061 Dated: 23 May 2022

Uncert 059437 24-MAY-22**Mechanic** 056209 24-MAY-22**Inspector** 001780 21-NOV-23*** Issue**

Unit Has Faded And Chipped Paint

Enter By 056209 18-MAR-22**Resolution**

Applied Paint Per CMM Repairs 1-1, 3-3, 3-5, 4-3, 5-2, 7-1, 9-1, 10-1, 13-1 & 14-1

Uncert 060350 25-MAY-22**Mechanic** 056209 08-JUN-22**Inspector** 001780 21-NOV-23**ECA Issue**

Apply BMS 10-11 Type I Primer per CMM Repairs 1-1, 3-3, 3-5, 4-3, 5-2, 7-1, 9-1, 10-1, 13-1

Uncert**Cert** 056209 18-MAR-22**ECA Resolution**

Applied BMS 10-11 Type I Primer Per CMM Repairs 1-1, 3-3, 3-5, 4-3, 5-2, 7-1, 9-1, 10-1, 13-1.

Lot# 45061005-148

Uncert 060350 25-MAY-22**Mechanic** 056209 08-JUN-22**Inspector** 001780 21-NOV-23*** Issue**

Drum Assy #848 Requires Dye Penetrant Inspection Per CMM

Enter By 056209 18-MAR-22**Resolution**

"PASSED" Dye Penetrant Inspection And Was Recorded On TR-061 Per CMM Pg. 502 Par. 2.B. (4) DATED: 23-MAR-2022

Uncert**Mechanic** 013282 23-MAR-22**Inspector** 001780 21-NOV-23*** Issue**

Unit To Be Re-worked From A -6 To A -12 Assembly Per BAC DWG 251A4510-6

Enter By 056209 23-MAY-22**Resolution**

Modified To A 251A4510-12 Per BAC DWG 251A4510-6, Due To Unavailability Of Nameplate, The Existing Nameplate Was Used And Restamped With A -12 Per ATS ER# 22-01775

Uncert**Mechanic** 056209 08-JUN-22**Inspector** 001780 21-NOV-23*** Issue**

Input Gear P/N: 251A4826-1 Figure 2 Item# 288 Corroded.

Enter By 056209 21-NOV-23**Resolution**

SEV Input Gear P/N: 251A4826-1 Figure 2 Item# 288 transfered from ATS Job# 559774 AJW RO# R410723 to be used on ATS Job# 548161 AJW RO# R392863. (Gear inspected On Job# 559774, no defects noted)

Uncert**Mechanic** 056209 21-NOV-23**Inspector** 001780 21-NOV-23

Work Order Final Inspection

Cleaned per	CMM Pg. 401 Par. 1. & 2. B. (2)	Uncert
		Mechanic 013282 21-MAR-22

Inspected per	CMM Pg. 501 Par. 1. & 2. B. (1)-(6) (a)	Uncert
		Mechanic 013282 23-MAR-22

Passed Final Test per	CMM Pg. 105-108 Par. D. (2) (a)-(h)	Uncert
		Mechanic 056209 21-NOV-23

Validated that all replacement parts conform to the Manual Reference listed.
See attached Components Parts Usage List for discrepancy and parts being replaced.

Cal Tools ID

This Unit Has Been Overhauled	Other Comments
	Removed from A/C# N372FL MSN 28327 TSO: 0 CSO: 0

The work identified on this work order was accomplished in accordance with Title 14, Code of Federal Regulations, part 43 and in respect to that work, the items are approved for return to service.

Work Order Final Inspection Signoff

Mechanic	056209 21-NOV-23	AD Requirement Verified By QC	001780 21-NOV-23
Supervisor	020060 21-NOV-23		
Inspector	001780 21-NOV-23		



Customer Name	A.J. WALTER AVIATION
Customer RO No	R392863
Manufacturer	BOEING
Job Number	548161

WORK ORDER

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Unit P/N (in)		Unit P/N (out)		Cust Part Num	
Part Number	251A4510-6	Part Number	251A4510-12	FCS REQ	N/A
Serial Number	KE00027	Serial Number	KE00027	Warranty REQ	No
Workscope	Overhauled	Workscope	Overhauled	RII REQ	N/A
Description	STAB TRIM ACTUATOR			Quantity	1
Reason for Removal	LARGDE AMOUNT OF GREASE WHEN LUBRICATION WAS PERFORMED IN AREA OF NUT TUBE RETAINER. WHEN LUBRICATION WAS PERFORMED ALL GREASE EXIT THROUGH RETURN TUBES NOT VENT HOLE				
Customer Instructions	PLEASE OVHL UNDER T&M- QUOTE AND HOLD.				

Manual Reference					
Type	Number	Rev	Date	Location	Notes
CMM	27-45-12	58	01-NOV-23	MBF	
ER	22-01775	IR	07-JUN-22	H-Drive	

Preliminary Inspection					
P/N Verified	Yes	S/N Verified	Yes	Repairs Required	Yes
Uncert				Life Limited	No
Mechanic	056209	20-MAY-22		AD Required	No
Comments Verified P/N & S/N Of Unit With Customer Repair Order. Customer requests overhaul. Unit Will Be Modded To 251A4510-12 Per Customer Request Per BAC DWG 251A4510-6 by Installing 07322P000-04 OR 07322P000-05 BALLSCREW ASSY & REMOVING EXISTING 251A4590-6 NAMEPLATE AND REPLACE WITH 251A4590-10 NAMEPLATE, STEEL STAMP ASSY DASH NUMBER (-12).					

Preliminary Functional Testing	
Test N/A	Comments
Uncert	
Mechanic	056209 18-MAR-22

Issues and Resolutions		
* Issue		
Disassembly Required To Overhaul Unit Per CMM.		
Enter By 056209 18-MAR-22		
Resolution		
Disassembled Per CMM Pgs. 306-309 Par. (2) (a)-(bb)		
Uncert	Mechanic 013282 21-MAR-22	Inspector 060210 01-JUN-22
* Issue		
Required Assembly Safety Closures.		
Enter By 013282 21-MAR-22		
Resolution		
Accomplished all safety closures Per CMM Pgs. 728-738, Par. F.(a)-(cm)		
Uncert	Mechanic 056209 21-NOV-23	Inspector 001780 21-NOV-23
ECA Issue		
Cotter Pins #886 4ea. Require Ok To Close.		
Uncert	Cert 056209 19-JUL-22	
ECA Resolution		
Ok To Close		
Q/C IS N/A		
Uncert	Mechanic 013282 19-JUL-22	Inspector 001780 21-NOV-23
ECA Issue		
Nut #916 Lockwire Requires Ok To Close.		
Uncert	Cert 056209 19-JUL-22	
ECA Resolution		
Ok To Close		
Q/C IS N/A		
Uncert	Mechanic 013282 19-JUL-22	Inspector 001780 21-NOV-23



Customer Name	A.J. WALTER AVIATION
Customer RO No	R392863
Manufacturer	BOEING
Job Number	548161

WORK ORDER

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Issues and Resolutions

ECA Issue

Cotter Pin #823 Requires Ok To Close.

Uncert

Cert 056209 19-JUL-22

ECA Resolution

Ok To Close

Q/C IS N/A

Uncert

Mechanic 013282 19-JUL-22

Inspector 001780 21-NOV-23

ECA Issue

Nuts #428, 432 & 916 Lockwire Requires Ok To Close.

Uncert

Cert 056209 19-JUL-22

ECA Resolution

Ok To Close

Q/C IS N/A

Uncert

Mechanic 013282 19-JUL-22

Inspector 001780 21-NOV-23

ECA Issue

Bolts #452 4ea. Lockwire Requires Ok To Close.

Uncert

Cert 056209 21-JUL-22

ECA Resolution

Ok To Close

Q/C IS N/A

Uncert

Mechanic 013282 21-JUL-22

Inspector 001780 21-NOV-23

ECA Issue

Anvil Swaged Staking Ring #396 Requires Ok To Close.

Uncert

Cert 056209 19-JUL-22

ECA Resolution

Ok To Close

Q/C IS N/A

Uncert

Mechanic 013282 19-JUL-22

Inspector 001780 21-NOV-23

ECA Issue

Cotter Pin #412B Requires Ok To Close.

Uncert

Cert 056209 21-JUL-22

ECA Resolution

Ok To Close

Q/C IS N/A

Uncert

Mechanic 013282 21-JUL-22

Inspector 001780 21-NOV-23

ECA Issue

Roll Pin #956 Lockwire Requires Ok To Close.

Uncert

Cert 056209 19-JUL-22

ECA Resolution

Ok To Close

Q/C IS N/A

Uncert

Mechanic 013282 19-JUL-22

Inspector 001780 21-NOV-23

ECA Issue

Cotter Pins #544 2ea. Require Ok To Close.

Uncert

Cert 013282 03-AUG-22

ECA Resolution

Ok To Close

Q/C IS N/A

Uncert

Mechanic 056142 03-AUG-22

Inspector 001780 21-NOV-23

ECA Issue

Screws #584 4ea. Lockwire Require Ok To Close.

Uncert

Cert 013282 03-AUG-22

ECA Resolution

Ok To Close

Q/C IS N/A

Uncert

Mechanic 056142 03-AUG-22

Inspector 001780 21-NOV-23



Customer Name	A.J. WALTER AVIATION
Customer RO No	R392863
Manufacturer	BOEING
Job Number	548161

WORK ORDER

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Issues and Resolutions

ECA Issue

Spring Pin #40 Requires Ok To Close.

Uncert

Cert 013282 03-AUG-22

ECA Resolution

Ok To Close

Q/C IS N/A

Uncert

Mechanic 056142 03-AUG-22

Inspector 001780 21-NOV-23

ECA Issue

Collars #240 Require Ok To Close.

Uncert

Cert 056209 17-NOV-23

ECA Resolution

Ok To Close

Q/C IS N/A

Uncert

Mechanic 013282 17-NOV-23

Inspector 001780 21-NOV-23

ECA Issue

Items #288, 244 & 136 Require Ok To Close.

Uncert

Cert 056209 17-NOV-23

ECA Resolution

Ok To Close

Q/C IS N/A

Uncert

Mechanic 013282 17-NOV-23

Inspector 001780 21-NOV-23

*Issue

Seal Rings # 304 And 977 Are Worn Per CMM Pg. 301 Par. 2. A. (2) (d)

Enter By 056209 18-MAR-22

Resolution

Installed And Machined Seal Rings Per CMM Repair 17-1 Pg. 601 Par. 2. C. (1) & (2) And Repair 16-1 Pg. 601 Par. 2. B. (1), (2) And (3)

Uncert

Mechanic 056209 08-JUN-22

Inspector 001780 21-NOV-23

ECA Issue

Seal rings #304 and #977 require installation Per CMM Repair 16-1 Pg. 601, Step 2.B.(1) and Repair 17-1 Pg. 601, Step 2.C.(1).

Uncert

Cert 013282 21-MAR-22

ECA Resolution

Installed seal rings #304 and #977 Per CMM Repair 16-1 Pg. 601, Step 2.B.(1) and Repair 17-1 Pg. 601, Step 2.C.(1).

Uncert

Mechanic 056209 08-JUN-22

Inspector 001780 21-NOV-23

ECA Issue

Machine Outside Diameter Of Seal Ring (977) On Pinion Gear To 0.791-0.800 Inches, 63 Microinch Finish Then Chamfer Edge Of Seal Ring 45 Degrees By 0.012-0.030 Inches Per CMM Pg. 601 Repair 16-1 Par. 2. B. (2) & (3)

Uncert

Cert 013282 21-MAR-22

ECA Resolution

Machined seal ring O/D on pinion gear to .791"- .800" inches and chamfer edge 45 degrees by .012"- .030" per CMM 27-45-12 repair 16-1 para 2.B, steps (2)(3), page 601.

Uncert 010590 01-JUN-22

Mechanic 001060 01-JUN-22

Inspector 060210 01-JUN-22

ECA Issue

Machine Outside Diameter Of Seal Ring (304) On Sleeve Assy To 2.8710-2.8730 Inches, 125 Microinch Finish Per CMM Pg. 601 Repair 17-1 Par. 2. C. (2)

Uncert

Cert 013282 21-MAR-22

ECA Resolution

Machined seal ring O/D on sleeve to 2.8710"- 2.8730" inches per CMM 27-45-12, repair 17-1, para 2.C, step(2), page 601.

Uncert 010590 01-JUN-22

Mechanic 001060 01-JUN-22

Inspector 060210 01-JUN-22

*Issue

Gimbals #56 Have Worn Cadmium Plating

Enter By 056209 18-MAR-22

Resolution

Gimbals 2ea. Exchanged With PPE.

Uncert

Mechanic 056209 08-JUN-22

Inspector 001780 21-NOV-23

*Issue

Ball screw Requires Overhaul S/N: 0518C Unit Was Exchanged With Post UMBRA S.B. 07322-27-01 Overhauled Unit P/N: 07322P000-

Resolution



Customer Name	A.J. WALTER AVIATION
Customer RO No	R392863
Manufacturer	BOEING
Job Number	548161

WORK ORDER

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Issues and Resolutions

S/N: 0144, Fig. 2. Item# 16 Requires Customer Current Work Scope Validation

Enter By 013282 04-AUG-22

Parts & Certs Have Been Reviewed & Are Acceptable For Use On This Unit.

Uncert **Mechanic** 013282 04-AUG-22

Inspector 001780 21-NOV-23

* Issue

Functional Test Required.

Enter By 013282 21-MAR-22

Resolution

Passed Functional Test Per CMM Pg. 105-108 Par. D. (2) (a)-(h)

Uncert **Mechanic** 056209 21-NOV-23

Inspector 001780 21-NOV-23

ECA Issue

Primary Brake End Play Check .004"-.010"

Uncert

Cert 013282 21-MAR-22

ECA Resolution

0.006"

Tooling ID: E10991

QC IS N/A

Uncert

Mechanic 013282 04-AUG-22

Inspector 001780 21-NOV-23

ECA Issue

Primary Brake Load Test

Apply 760-840" Lbs. Tension Load, Difference between C/W and C/C/W Torque 120-186" Lbs.

Uncert

Cert 013282 21-MAR-22

ECA Resolution

170"lbs

Tooling ID: E1447

QC IS N/A

Uncert

Mechanic 013282 04-AUG-22

Inspector 001780 21-NOV-23

ECA Issue

Primary Brake Load Test

Apply 760-840" Lbs. Compression Load, Difference between C/C/W and C/W Torque 120-186" Lbs.

Uncert

Cert 013282 21-MAR-22

ECA Resolution

160"lbs

Tooling ID: E1447

QC IS N/A

Uncert

Mechanic 013282 04-AUG-22

Inspector 001780 21-NOV-23

ECA Issue

Cable Drum Friction Check Less than 140" lbs. C/W & C/C/W

Uncert

Cert 013282 21-MAR-22

ECA Resolution

C/W: 80"lbs

C/C/W: 80"lbs

Tooling ID: E1447

QC IS N/A

Uncert

Mechanic 056209 21-NOV-23

Inspector 001780 21-NOV-23

ECA Issue

Auxiliary Brake Check

Apply 500" lb. load to Ballscrew Less than 720" lbs. C/W & C/C/W then contact upper stop

Uncert

Cert 013282 21-MAR-22

ECA Resolution

C/W: 480"lbs

C/C/W: 480"lbs

Tooling ID: E12372

QC IS N/A

Uncert

Mechanic 056209 21-NOV-23

Inspector 001780 21-NOV-23

ECA Issue

Apply 660" lb. load to motor input Release less than 187" lbs.

Uncert

Cert 013282 21-MAR-22

ECA Resolution

Release at: 130"lbs

Tooling ID: E1447

QC IS N/A

Uncert

Mechanic 056209 21-NOV-23

Inspector 001780 21-NOV-23



Customer Name	A.J. WALTER AVIATION
Customer RO No	R392863
Manufacturer	BOEING
Job Number	548161

WORK ORDER

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Issues and Resolutions

ECA Issue

Load Check 500 lb. Tension Load

C/C/W less than 201" lbs. subtract Friction . Difference less than 77" lbs.

Uncert

Cert 013282 21-MAR-22

ECA Resolution

30"lbs

Tooling ID: E1447 QC IS N/A

Uncert

Mechanic 056209 21-NOV-23

Inspector 001780 21-NOV-23

ECA Issue

Load Check 500 lb. Tension Load

C/W less than 217" lbs. subtract Friction . Difference between 18" & 100" lbs

Uncert

Cert 013282 21-MAR-22

ECA Resolution

30"lbs

Tooling ID: E1447 QC IS N/A

Uncert

Mechanic 056209 21-NOV-23

Inspector 001780 21-NOV-23

ECA Issue

Load Check 500 lb. Compression Load

C/W less than 201" lbs. subtract Friction . Difference less than 77" lbs.

Uncert

Cert 013282 21-MAR-22

ECA Resolution

50"lbs

Tooling ID: E1447 QC IS N/A

Uncert

Mechanic 056209 21-NOV-23

Inspector 001780 21-NOV-23

ECA Issue

Load Check 500 lb. Compression Load

C/C/W less than 217" lbs. subtract Friction . Difference between 18"- 100" lbs.

Uncert

Cert 013282 21-MAR-22

ECA Resolution

50"lbs

Tooling ID: E1447 QC IS N/A

Uncert

Mechanic 056209 21-NOV-23

Inspector 001780 21-NOV-23

ECA Issue

Clutch Disconnect Check (dynamic)

Upper & Lower Stops, less than 780" lbs. & pinion rotates freely.

Uncert

Cert 013282 21-MAR-22

ECA Resolution

Upper: 600"lbs Lower: 720"lbs

Tooling ID: E12372 QC IS N/A

Uncert

Mechanic 056209 21-NOV-23

Inspector 001780 21-NOV-23

ECA Issue

Clutch Disconnect Check (static)

C/W less than 750" lbs. X 20

C/C/W less than 750" lbs. X 20

Uncert

Cert 013282 21-MAR-22

ECA Resolution

C/W: 660"lbs x 20 C/C/W: 660"lbs x 20

Tooling ID: E12372 QC IS N/A

Uncert

Mechanic 056209 21-NOV-23

Inspector 001780 21-NOV-23

ECA Issue

Pri. & Aux. Brake Pressure Checks 15-17 psi for 3 minutes

Uncert

Cert 013282 21-MAR-22

ECA Resolution

Pri. & Aux. Brakes Both Hold 16psi for 3 Minutes

Tooling ID: E11011 QC IS N/A

Uncert

Mechanic 056209 21-NOV-23

Inspector 001780 21-NOV-23



Customer Name	A.J. WALTER AVIATION
Customer RO No	R392863
Manufacturer	BOEING
Job Number	548161

WORK ORDER

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Issues and Resolutions

ECA Issue

Timing Check

Gap between lower stop & ballnut .150" – .170"

Uncert

Cert 013282 21-MAR-22

ECA Resolution

0.167"

Tooling ID: PER2083

QC IS N/A

Uncert

Mechanic 056209 21-NOV-23

Inspector 001780 21-NOV-23

ECA Issue

All index marks aligned within 10 Deg.

Uncert

Cert 013282 21-MAR-22

ECA Resolution

Per CMM 27-45-12 pgs. 105-108 sec. (2)

Uncert

Mechanic 056209 21-NOV-23

Inspector 001780 21-NOV-23

*** Issue**

P/N: 69-37970-1 Fig. 2 Item# 56 Requires Customer Current Work Scope Validation.

Enter By 056209 18-MAR-22

Resolution

Parts & Certs Have Been Reviewed & Are Acceptable For Use On This Unit.

Uncert

Mechanic 056209 08-JUN-22

Inspector 001780 21-NOV-23

*** Issue**

Assembly Required Per CMM.

Enter By 013282 21-MAR-22

Resolution

Assembled Per CMM Pgs. 728-738 Par. F. (a)-(cm)

Uncert

Mechanic 056209 21-NOV-23

Inspector 001780 21-NOV-23

ECA Issue

Unit Partially Assembled Per CMM Pg. 728 Par. F. (1) (a)-(n), (r)-(v), (y)-(ae)

Uncert

Cert 056209 19-JUL-22

ECA Resolution

Unit Partially Assembled Per CMM Pg. 728 Par. F. (1) (a)-(n), (r)-(v), (y)-(ae)

Uncert

Mechanic 013282 04-AUG-22

Inspector 001780 21-NOV-23

ECA Issue

Partially assemble unit Per CMM.

Uncert

Cert 013282 04-AUG-22

ECA Resolution

Partially assembled Per CMM Pgs. 730-733 Par. F.(1)(aq)-(bf), (bh)-(bj).

Uncert

Mechanic 013282 04-AUG-22

Inspector 001780 21-NOV-23

ECA Issue

Continued partial assembly

Uncert

Cert 056209 17-NOV-23

ECA Resolution

Partially assembled Per CMM Pgs. 728-7 Par. F.(1) (a)-(bw)

Uncert

Mechanic 056209 17-NOV-23

Inspector 001780 21-NOV-23

*** Issue**

Magnetic Particle Check Required Per CMM Pg. 501 Par. 2. B. (2)

Enter By 056209 18-MAR-22

Resolution

All Parts Listed In CMM Pg. 501 Par. 2. B. (2) Passed Magnetic Particle Inspection Per SOPM 20-20-01 & CMM Pg. 501 Par. 2. B. (2) and was recorded on TR-061 Dated: 24 May 2022

Uncert 059437 24-MAY-22

Mechanic 056209 24-MAY-22

Inspector 001780 21-NOV-23

*** Issue**

Penetrant Check Required Per CMM Pg. 501-502 Par. 2. B. (3)

Enter By 056209 18-MAR-22

Parts Usage List

JOB: 548161 CREW: (all) DASH: (all)

						 Return Parts	Deficiency/Identifier			
Item		Cond.	Description	Qty	UOM	SN/Lot	Minimum Returnable Qty	Cond.Code ▲	Deficiency	Fig./Item
251A4833-1		NEW	LOCKWASHER	1	EA	1530704-2	1	REPL	WRN	2-88
69-13364-1		NEW	SPRING	4	EA	1462929-2	1	REPL	WRN	2-572
69-13364-2		NEW	SPRING	4	EA	1462929-3	1	REPL	WRN	2-576
69-36083		NEW	SEAL	1	EA	1462928-3	1	REPL	WRN	2-977
69-36083-15		NEW	SEAL RING	1	EA	1443595-1	1	REPL	WRN	2-304A
700-861-8862-99		NEW	LIP SEAL	1	EA	1462607-5	1	REPL	OTU	2-292C
700-863-8862-99		NEW	SEAL	1	EA	1516349-1	1	REPL	WRN	2-252D
700-867-2272-99		NEW	LIP SEAL	1	EA	1462606-4	1	REPL	OTU	2-108C
AEROSHELL33		NEW	AEROSHELL 33 GREASE (BMS3-33/MIL-PRF-23827C)14OZ.	1	TBE	11722175	1	REPL	OTU	2-80
AS15004-1		NEW	FITTING	1	EA	1430967-1	1	REPL	WRN	2-64S
BACB10FR25JZ		NEW	BEARING	2	EA	1472435-1	1	REPL	RGH	2-444C
BACB10FR49JZ		NEW	BEARING	4	EA	1492204-10	1	REPL	RGH	2-872C
BACB10FS06JZ		NEW	BEARING	1	EA	1492172-1	1	REPL	RGH	2-780
BACB10FS16JZ		NEW	BEARING	3	EA	1479299-1	1	REPL	RGH	2-400A/968
BACB30NM4HK7		NEW	BOLT	4	EA	1505118-1	1	REPL	WRN	2-44A
BACB30NT3K10		NEW	SCREW	3	EA	1441087-2	1	REPL	WRN	2-112
BACB30NT3K10		NEW	SCREW	2	EA	1474398-1	1	REPL	WRN	2-112
BACB30NT3K11		NEW	BOLT	1	EA	1282366-1	1	REPL	WRN	2-116
BACB30NT3K2		NEW	BOLT	3	EA	1439374-1	1	REPL	WRN	2-96
BACC30BL6		NEW	COLLAR (SSS)	4	EA	1468853-2	1	REPL	OTU	2-240
BACN10JD6		NEW	NUT	1	EA	1261035-1	1	REPL	WRN	2-800
BACN10RF36C		NEW	NUT	1	EA	1462226-4	1	REPL	WRN	2-84
BACN10YR3CD		NEW	NUT (SSS)	12	EA	1469823-1	1	REPL	WRN	VARIOUS
BACN10YR4CD		NEW	NUT	11	EA	1469869-1	1	REPL	WRN	2-348/384/656/752
BACN10YR4CD		NEW	NUT	33	EA	1474402-1	1	REPL	WRN	2-348/384/656/752
BACN10YR4CD		NEW	NUT	8	EA	1485324-1	1	REPL	WRN	2-348/384/656/752
BACN11N6CD		NEW	NUT	1	EA	1366782-1	1	REPL	WRN	2-824C
BACP18BC00C04P		NEW	PIN	4	EA	1282474-1	1	REPL	OTU	2-544
BACP18BC02C06P		NEW	PIN COTTER (SSS)	5	EA	1462745-1	1	REPL	OTU	2-412B/886
BACP18BC03C10P		NEW	COTTER PIN	2	EA	1236751-4	1	REPL	OTU	2-796/823
BACP18BC04C16P		NEW	COTTER PIN	1	EA	1427676-1	1	REPL	OTU	2-4

								Deficiency/Identifier		
Item	Cond.	Description	Qty	UOM	SN/Lot	Minimum Returnable Qty	Cond.Code ▲	Deficiency	Fig./Item	
BACR12Y23	NEW	RING	1	EA	1472538-1	1	REPL	OTU	2-396	
BACR15BA5D5C	NEW	RIVET	8	EA	SP9EFSJ	1	REPL	OTU	2-788	
BACS12HL3AH8	NEW	SCREW	4	EA	1492199-1	1	REPL	COR	2-584A	
BACS12HL4AH8	NEW	SCREW	4	EA	1492204-7	1	REPL	OTU	2-240	
BACW10P73S	NEW	WASHER	1	EA	1220395-1	1	REPL	WRN	2-804	
M25988-1-110	NEW	PACKING	3	EA	1472791-1	1	REPL	OTU	2-132/464/692A	
M25988-1-160	NEW	O-RING	1	EA	1424945-3	1	REPL	OTU	2-248	
M83461-1-211	NEW	SEAL	1	EA	1293054	1	REPL	OTU	2-980	
M83461-1-238	NEW	PACKING	1	EA	1474771-1	1	REPL	OTU	2-580	
M83461-1-238	NEW	PACKING	1	EA	5046953	1	REPL	OTU	2-580	
MS16562-51	NEW	PIN	1	EA	1424864-1	1	REPL	OTU	2-40	
MS28778-2	NEW	O-RING	1	EA	1430226-1	1	REPL	OTU	2-983	
MS28778-4	NEW	PACKING	1	EA	1104226	1	REPL	OTU	2-701L	
MS29513-113	NEW	O-RING	2	EA	1218456	1	REPL	OTU	2-24	
MS29513-120	NEW	O-RING	1	EA	832610	1	REPL	OTU	2-28	
MS29513-123	NEW	O-RING	1	EA	1461794-1	1	REPL	OTU	2-32	
MS29513-132	NEW	O-RING	2	EA	1462473-1	1	REPL	OTU	2-80	
MS29513-138	NEW	PACKING	2	EA	1430547-1	1	REPL	OTU	2-312/484	
MS29513-141	NEW	O-RING	1	EA	1462603-1	1	REPL	OTU	2-296	
MS29513-240	NEW	O-RING	1	EA	1263782	1	REPL	OTU	2-528	
MS29513-336	NEW	PACKING	1	EA	1424188-1	1	REPL	OTU	2-708	
NAS1149D0363J	NEW	WASHER (SSS)	11	EA	1486544-1	1	REPL	WRN	2-120	
NAS1149D0463J	NEW	WASHER (SSS)	4	EA	1479045-1	1	REPL	WRN	2-600	
NAS559-3	NEW	CLIP	1	EA	1462927-2	1	REPL	BRK	2-500	
NAS561CF5-22	NEW	PIN	1	EA	1425868-1	1	REPL	WRN	2-956	
YAF03B	NEW	BEARING (REPLACES BACB10ET03)	4	EA	1497710-1	1	REPL	RGH	2-896	
07322P000-04	OVH	BALLSCREW ASSY	1	EA	0144	1	OSR	WRN	CMM 27-45-12	
251A4818-1	NEW	ROTOR COUPLING	1	EA	1492175-8	1	OOSM	COR	2-228	
251A4819-1	NEW	THRUST-PLATE	1	EA	1492175-9	1	OOSM	COR	2-272	
251A4825-2	NEW	SUPPORT	1	EA	1532866-11	1	OOSM	COR	2-276A	
251A4831-1	NEW	THRUST ROLLER ASSY	1	EA	1492175-4	1	OOSM	COR	2-260	
69-37970-1	SFV	GIMBAI FITTING	2	FA	544179	1	PPF	FWR	2-56	
69-37970-1	AIS	GIMBAL FITTING	-2	EA	548161	1	PPE	FWR	2-56	
BACB10GT65NPPJZ	NEW	BEARING	1	EA	1492173-6	1	OOSM	COR	2-704F	
BMS10-	NEW	PAINT PRIMER KIT PINT	1	EA	45061005-	1	--	--	--	

						Deficiency/Identifier		
Item	Cond.	Description	Qty	UOM	SN/Lot	Minimum Returnable Qty	Cond.Code ▲	Deficiency Fig./Item
11TY1CLAGRE#PT					148			
BMS10-11TY1CLAGRETUP	NEW	PAINT PRIMER KIT 2OZ TOUCH-UP W/BRUSH	1	EA	44563388-445	1	--	--
STB035CB0BAC	NEW	BEARING	1	EA	1492177-2	1	OOSM	COR 2-280B

Deficiency Code	Description	Condition Code	Description
BRK	Broken	OOSM	Out Of Scope - Material Replacement
COR	Corroded	OSR	Outside Services Required
FWR	Finish Worn	PPE	Piece Part Survey Exchange
OTU	One Time Use	REPL	Part Replacement
RGH	Rough	! Standard replacement and consumable items may not be identified with a deficiency identifier.	
WRN	Worn		

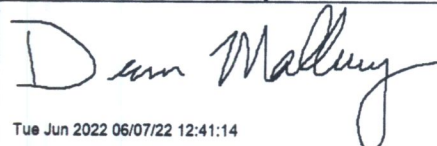


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Customer A.J. WALTER AVIATION		Registry # Spare	Job # 548161	A/C Model 737-NG	Effectivity N/A	Customer PO# R392863	
Part # N/A	Instl Part # N/A	Assy Part # 251A4510-6 251A4510-12		Assy Serial # KE00027	Crew MECHNL	MWO 1	Customer N/R N/A
Name of Structure / Component Stab Trim Actuator Assembly							ATA Code 2748-00
Problem Description ATS is reworking a P/N 251A4510-6 Stabilizer Trim Actuator Assembly to a -12 Assembly per PL 251A4510-6. This rework task requires the purchase of a P/N 251A4590-10 Nameplate which is not available.							
Structural Classification ☐ Primary ☒ Secondary		Damage Tolerant Structure ☐ FCBS note		FAA Approval Required ☒ No ☐ Yes via			
Repair Type ☐ Major ☒ Minor		AMOC Required ☐ Yes ☒ No					
per ATS RSM Vol 1, §4.14.3, App. B&C		AD(s)					
Non-DT Classification ☒ Permanent ☐ Interim (See below) ☐ Time-Limited (See below)		FCBS or FCAS Classification ☐ Category A ☐ Category B (See below) ☐ Category C (See below)			DTE Approval Stage Received ☐ Stage 1, DTE Due in Months ☐ Stage 2 (See below) ☐ Stage 3		
Inspection Requirements and Notes ☐ Inspection Threshold: Days Hours Cycles ☐ Repeat Inspection Interval: Days Hours Cycles or ☐ Replace repair within Months, not to exceed Cycles Notes:							
Prepared by: Devon Mallory		Approved by: Kristen Vernon			Customer Acceptance		
 Tue Jun 2022 06/07/22 12:41:14					N/A		
Empl #: 57313	Date: 07-JUN-2022	Empl #: 55886	Date: 07-JUN-2022				

Substantiation

The rework of the 251A4510-6 Actuator Assembly by replacement of the Ballscrew Assembly makes the -6 Assembly eligible for P/N change. Per PL 251A4510-6, the part number change is accomplished by purchasing a new nameplate, P/N 251A4590-10, which is not available. Also, in Ref /A/ paragraph 6.b., the FAA recommends against removing original identification data. Instead, the FAA recommends adding information. Ref /A/ paragraph 7.c. provides guidelines for part marking by maintenance providers. The part marking instructions in this ER satisfy the guidelines of Ref /A/ paragraph 7.c.(3). Per Ref /A/ paragraph 5.b., if properly applied, part markings do not affect a part's functional performance.

Conclusion: The 251A4510-6 Actuator Assembly which has been reworked to Assembly 251A4510-12 per Boeing drawing 251A4510-6 and part-marked IAW instructions in this ER is functionally identical to 251A4510-12 actuator assy.

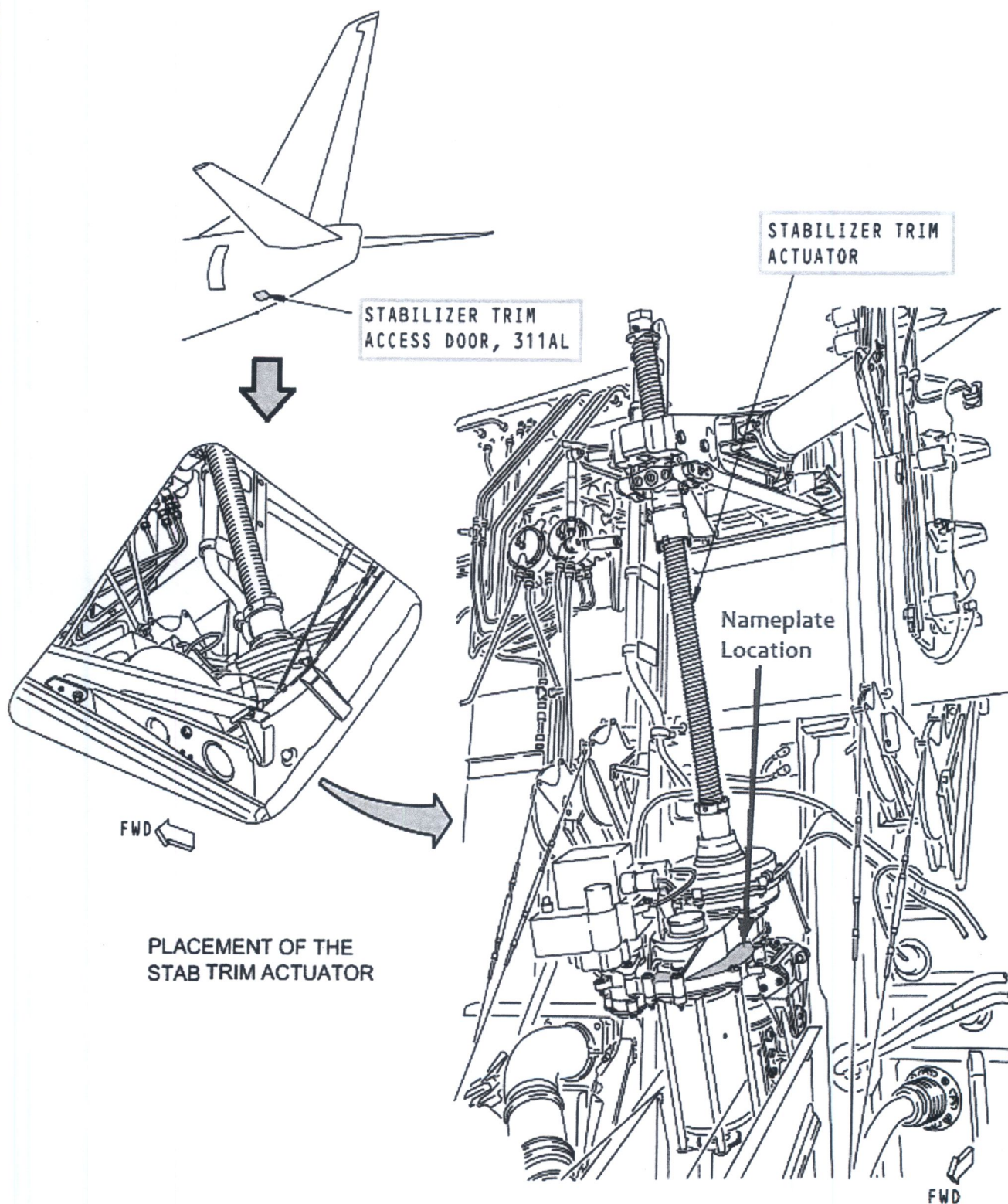
References

/A/ FAA AC 43-213A

No. Revision Description**Date**

Figure 1, Sheet 1 – Damage Location

Ref: SB-737-27-1210





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Signoff of the repair steps below may be found on Preliminary ERs.

Verify

Inspect

Preliminary P1 has been audited for completion.

JUN 08 2022



JUN 08 2022



Work Required

Section I – Damage Removal, Inspections & Repair

- Ensure susceptible areas are protected from metal shavings, debris, and any other sources of foreign object damage, if applicable.
- During conversion of the P/N 251A4510-6 assembly to the P/N 251A4510-12 assembly, it is acceptable to change the existing nameplate by crossing out the old dash number and steel stamping the new dash number per BAC5307.
- Remove any FOD protection measures, if installed, and ensure any metal shavings and other foreign object debris has been removed.