



COMPONENT MAINTENANCE MANUAL WITH ILLUSTRATED PARTS LIST

FUEL TANK ACCESS DOOR ASSEMBLY

PART NUMBER

**110U6011-1, -2, 110U6012-1, -2, 110U6021-1, -2,
110U6022-1, -2, 112N6101-1, -10, -11, -2, -3, -6, -9,
112N6102-1, 112T4607-3, -5, 112W6201-3,
112W6202-3, 112W8201-1, 112W8202-1,**

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342W2801-10, -3, -4, -5, -6, -7, -8, -9,
65C33092-2, -3, -4, -5, -6, -7, -8, -9,
65C33147-10, -3, -4, -5, -6, -7, -8, -9

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COMPONENT MAINTENANCE MANUAL

Revision No. 20
Jul 01/2009

To: All holders of FUEL TANK ACCESS DOOR ASSEMBLY 28-11-07.

Attached is the current revision to this COMPONENT MAINTENANCE MANUAL

The COMPONENT MAINTENANCE MANUAL is furnished either as a printed manual, on microfilm, or digital products, or any combination of the three. This revision replaces all previous microfilm cartridges or digital products. All microfilm and digital products are reissued with all obsolete data deleted and all updated pages added.

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

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TRANSMITTAL LETTER

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Location of Change

Description of Change

NO HIGHLIGHTS

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A = Added, R = Revised, D = Deleted, O = Overflow

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TEMPORARY REVISION AND SERVICE BULLETIN RECORD

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVE	DATE ADDED TO THE MANUAL

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TR AND SB RECORD

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All revisions to this manual will be accompanied by transmittal sheet bearing the revision number. Enter the revision number in numerical order, together with the revision date, the date filed and the initials of the person filing.

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**SEE TITLE PAGE FOR
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REVISION RECORD

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COMPONENT MAINTENANCE MANUAL

INTRODUCTION

1. General

- A. The instructions in this manual supply the data necessary to do the maintenance functions together with the test, fault isolation, repair, and replacement of the defective parts.
- B. This manual is divided into different parts:
 - (1) Title Page
 - (2) Transmittal Letter
 - (3) Highlights
 - (4) List of Effective Pages
 - (5) Table of Contents
 - (6) Temporary Revision & Service Bulletin Record
 - (7) Record of Revisions
 - (8) Record of Temporary Revisions
 - (9) Introduction
 - (10) Procedures & IPL Sections
- C. Components that can be repaired have a different repair number for each specified repair. To find the repair number location of a component, look in the Repair-General procedure at the beginning of the REPAIR section. The Repair-General procedure also has an explanation of the True Position Dimension symbols used.
- D. All dimensions, measures, quantities and weights included are in English units. When metric equivalents are given they will be in the parentheses that follow the English units.
- E. The introduction to the Illustrated Parts List (IPL) shows how the IPL data is used.
- F. Design changes, optional parts, configuration differences and Service Bulletin modifications may cause different part numbers. These part numbers are identified in the IPL with an alphabetical letter which is added to the end of the basic item number. This new item number is referred to as an alpha-variant. Throughout the manual, IPL basic item number references also apply to alpha-variants unless shown differently.
- G. The tool reference numbers found in the individual procedures and in the Special Tools, Fixtures, and Equipment section are used to identify if a tool is a standard tool (STD-XXXX), a commercial tool (COM-XXXX), or a Special Tool (SPL-XXXX). This reference number is also used to distinguish between tools with similar names in the same procedure. These reference numbers are for use in the documentation only. They are not to be used for ordering tools.

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INTRODUCTION

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FUEL TANK ACCESS DOOR ASSEMBLIES - DESCRIPTION AND OPERATION

1. Description

A. The fuel tank access door assemblies have doors, seals, latches and fasteners.

2. Operation

A. The fuel tank access door assemblies permit access to the fuel tank of the airplane.

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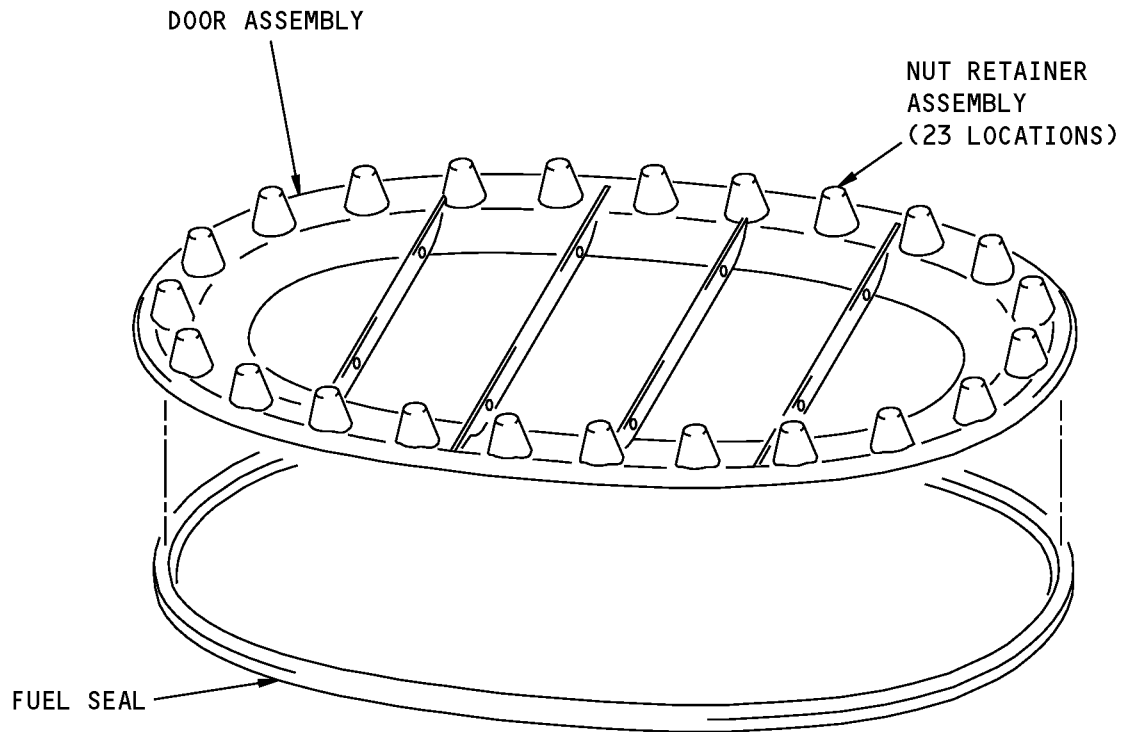
DESCRIPTION AND OPERATION

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112N6101-1 SHOWN

Fuel Tank Access Door Assembly
Figure 1

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TESTING AND FAULT ISOLATION

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TESTING AND FAULT ISOLATION

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DISASSEMBLY

1. General

A. This section has the necessary data to disassemble the fuel tank access door assemblies.

2. Fuel Tank Access Door Disassembly

A. General

(1) Disassemble the fuel tank access door assemblies only as necessary to isolate the defect, do necessary repairs, and restore the component to a serviceable condition.

B. Procedure

(1) Use the standard industry procedures to disassemble the fuel tank access door assemblies.

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DISASSEMBLY

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CHECK

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REPAIR

1. General

A. This section refers to the repair of specified subassembly parts.

B. Instructions for repair, refinish and replacement are included in each REPAIR when applicable:

PART NUMBER	NAME	REPAIR
112N6101	10 X 18 FUEL TANK ACCESS DOOR	1-1
112N6102	8 X 18 FUEL TANK ACCESS DOOR	2-1
112T4607	INSPAR LOWER WING	3-1
342W2801	FUEL VENT SYSTEMS STANDPIPE/FLAME ARRESTOR	4-1
112W8100	VENT SCOOP DOOR	4-2
110U6011	10 X 18 FUEL TANK	5-1
110U6021	ACCESS DOOR	
65C33092		
110U6012	10 X 18 FUEL TANK	6-1
110U6022	ACCESS DOOR	
65C33147		

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REPAIR - GENERAL

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—	STRAIGHTNESS	∅	DIAMETER
□	FLATNESS	S ∅	SPHERICAL DIAMETER
⊥	PERPENDICULARITY (OR SQUARENESS)	R	RADIUS
//	PARALLELISM	SR	SPHERICAL RADIUS
○	ROUNDNESS	()	REFERENCE
⊘	CYLINDRICITY	BASIC	A THEORETICALLY EXACT DIMENSION USED
⌒	PROFILE OF A LINE	(BSC)	TO DESCRIBE SIZE, SHAPE OR LOCATION OF
⌒	PROFILE OF A SURFACE	OR	A FEATURE. FROM THIS FEATURE PERMISSIBLE
◎	CONCENTRICITY	DIM	VARIATIONS ARE ESTABLISHED BY TOLERANCES ON OTHER DIMENSIONS OR
≡	SYMMETRY		NOTES.
∠	ANGULARITY	-A-	DATUM
↗	RUNOUT	(M)	MAXIMUM MATERIAL CONDITION (MMC)
↗	TOTAL RUNOUT	(L)	LEAST MATERIAL CONDITION (LMC)
□	COUNTERBORE OR SPOTFACE	(S)	REGARDLESS OF FEATURE SIZE (RFS)
∇	COUNTERSINK	(P)	PROJECTED TOLERANCE ZONE
⊕	THEORETICAL EXACT POSITION OF A FEATURE (TRUE POSITION)	FIM	FULL INDICATOR MOVEMENT

EXAMPLES

— 0.002	STRAIGHT WITHIN 0.002	◎ ∅ 0.0005 C	CONCENTRIC TO DATUM C WITHIN 0.0005 DIAMETER
⊥ 0.002 B	PERPENDICULAR TO DATUM B WITHIN 0.002	≡ 0.010 A	SYMMETRICAL WITH DATUM A WITHIN 0.010
// 0.002 A	PARALLEL TO DATUM A WITHIN 0.002	∠ 0.005 A	ANGULAR TOLERANCE 0.005 WITH DATUM A
○ 0.002	ROUND WITHIN 0.002	⊕ ∅ 0.002 S B	LOCATED AT TRUE POSITION WITHIN 0.002 DIA RELATIVE TO DATUM B, REGARDLESS OF FEATURE SIZE
⊘ 0.010	CYLINDRICAL SURFACE MUST LIE BETWEEN TWO CONCENTRIC CYLINDERS, ONE OF WHICH HAS A RADIUS 0.010 INCH GREATER THAN THE OTHER	⊥ ∅ 0.010 M A	AXIS IS TOTALLY WITHIN A CYLINDER OF 0.010 INCH DIAMETER, PERPENDICULAR TO DATUM A, AND EXTENDING 0.510 INCH ABOVE DATUM A, MAXIMUM MATERIAL CONDITION
⌒ 0.006 A	EACH LINE ELEMENT OF THE SURFACE AT ANY CROSS SECTION MUST LIE BETWEEN TWO PROFILE BOUNDARIES 0.006 INCH APART RELATIVE TO DATUM A	0.510 P	
⌒ 0.020 A	SURFACES MUST LIE WITHIN PARALLEL BOUNDARIES 0.020 INCH APART AND EQUALLY DISPOSED ABOUT TRUE PROFILE	2.000	THEORETICALLY EXACT DIMENSION IS 2.000
		OR	
		2.000	
		BSC	

True Position Dimensioning Symbols
Figure 601

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REPAIR - GENERAL

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FUEL TANK ACCESS DOOR ASSEMBLY - REPAIR 1-1

112N6101-1, -2, -3, -6, -9, -10, -11

1. General

- A. This section has the necessary data to replace the fuel seal (55, IPL Figure 1; 35, IPL Figure 6 and IPL Figure 8; 25, IPL Figure 7).
- B. Refer to Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 1, IPL Figure 6, IPL Figure 7 and IPL Figure 8 for the item numbers.

2. Fuel Seal Replacement

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A50153	Sealant - Fuel Tank - Class A-2	BMS5-45 Class A-2
C00175	Primer - Urethane Compatible, Corrosion Resistant (Less Than 1% Aromatic Amines)	BMS10-79, Type III
C00307	Coating - Corrosion Resistant Finish For Integral Fuel Tanks	BMS10-20, Type II
C50075	Coating - Exterior Protective Enamel, Gray	BMS10-60, Type II, BAC707 Gray

- B. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-50-12	APPLICATION OF ADHESIVES
SOPM 20-60-02	FINISHING MATERIALS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

- C. Procedure (REPAIR 1-1, Figure 601, REPAIR 1-1, Figure 602, REPAIR 1-1, Figure 603)

NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02. For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Install the fuel seal (55, IPL Figure 1; 35, IPL Figure 6 and IPL Figure 8; 25, IPL Figure 7):
 - (a) Fully clean the fuel seal (55, IPL Figure 1; 35, IPL Figure 6 and IPL Figure 8; 25, IPL Figure 7) before you install it on the door casting (70, IPL Figure 1; 50, IPL Figure 6 and IPL Figure 8; 40, IPL Figure 7).
 - (b) Apply sealant, A50153 to the full width of the groove of fuel seal (55, IPL Figure 1; 35, IPL Figure 6 and IPL Figure 8; 25, IPL Figure 7).

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REPAIR 1-1

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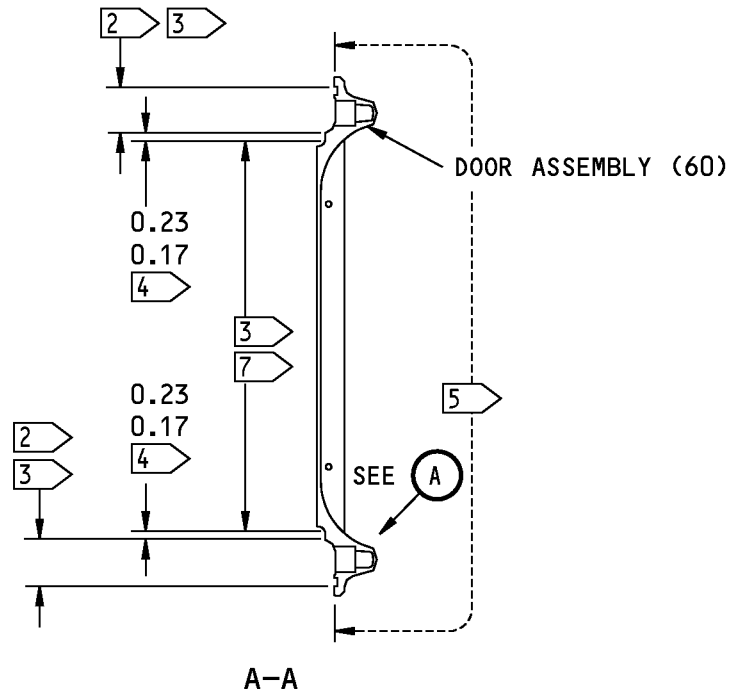
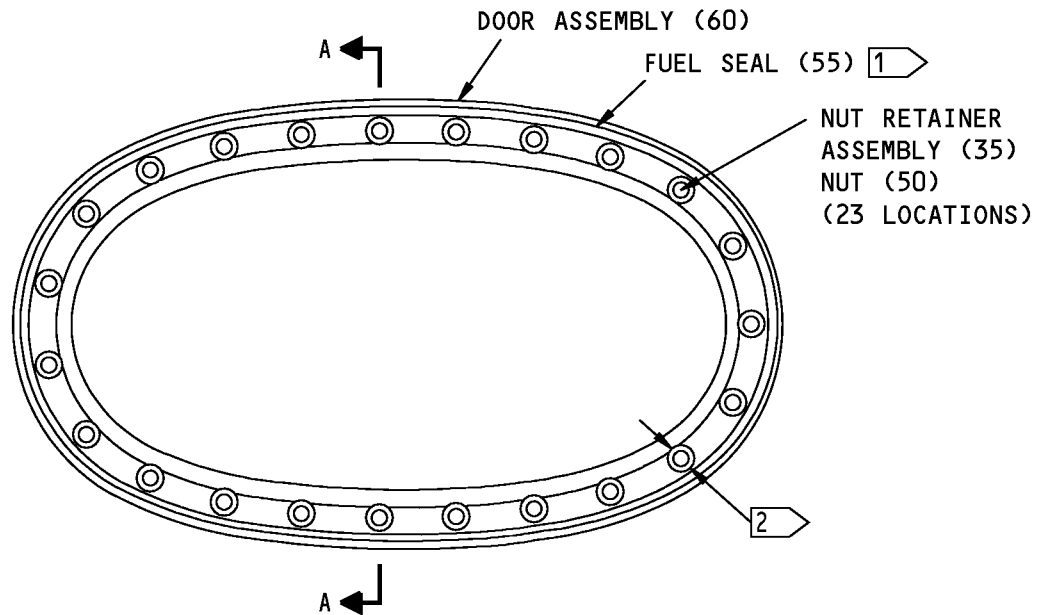
- (c) Use sealant, A50153 to bond the fuel seal (55, IPL Figure 1; 35, IPL Figure 6 and IPL Figure 8; 25, IPL Figure 7) to the door casting (70, IPL Figure 1; 50, IPL Figure 6 and IPL Figure 8; 40, IPL Figure 7) as shown by flag note 1 in REPAIR 1-1, Figure 601, REPAIR 1-1, Figure 602 and REPAIR 1-1, Figure 603. (SOPM 20-50-12)
- (d) Chemical treat (F-17.15) and apply primer, C00175 (F-19.47) as shown by flag note 2 and 3 in REPAIR 1-1, Figure 601, REPAIR 1-1, Figure 602 and REPAIR 1-1, Figure 603.
- (e) Chemical treat (F-17.15) to the surface shown by flag note 4 in REPAIR 1-1, Figure 601, REPAIR 1-1, Figure 602 and REPAIR 1-1, Figure 603.
- (f) Chemical treat (F-17.15) and apply one layer of corrosion resistant coating, C00307 (F-19.22) as shown by flag note 5 in REPAIR 1-1, Figure 601, REPAIR 1-1, Figure 602 and REPAIR 1-1, Figure 603.
- (g) Obey the flag note 6 in REPAIR 1-1, Figure 601, REPAIR 1-1, Figure 602 and REPAIR 1-1, Figure 603.
- (h) Chemical treat (F-17.15) the internal surface of the hole.
 - 1) Obey the flag note 7 in REPAIR 1-1, Figure 602.
 - 2) Obey the flag note 8 in REPAIR 1-1, Figure 602.
 - 3) Obey the flag notes 9 and 10 in REPAIR 1-1, Figure 602.
- (i) Do not apply primer because of electrical bonding requirements in areas shown by flag note 7 in REPAIR 1-1, Figure 603.
- (j) Apply coating, C50075 as shown by flag note 7 in REPAIR 1-1, Figure 601..

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REPAIR 1-1
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112N6101-1,-2,-9 10 x 18 Fuel Tank Access Door Assembly
Figure 601 (Sheet 1 of 2)

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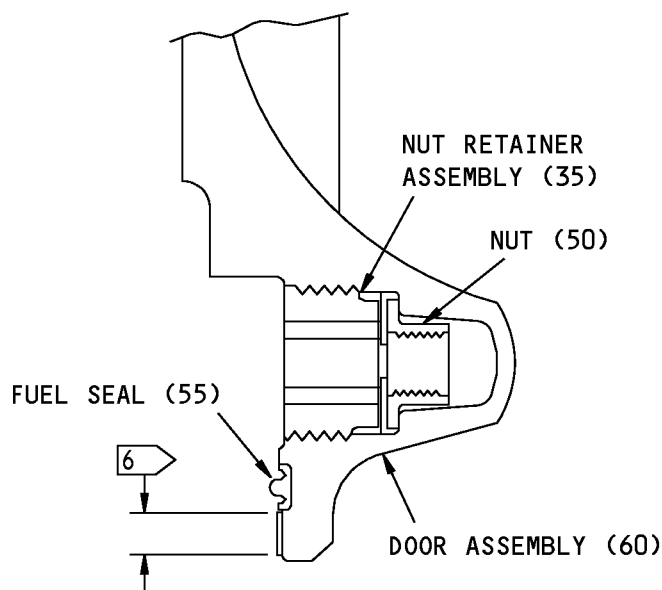
REPAIR 1-1

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A

- 1 BOND THE FUEL SEAL (55) WITH BMS 5-45, CLASS A.
- 2 IT IS NOT NECESSARY TO APPLY PRIMER ON THE INTERNAL SURFACE OF THE BOSS. OVERSPRAY IS PERMITTED.
- 3 CHEMICAL TREAT (F-17.15) AND APPLY ONE LAYER OF BMS 10-79 TYPE 3 PRIMER (F-19.47).
- 4 CHEMICAL TREAT (F-17.15 ONLY).
- 5 CHEMICAL TREAT (F-17.15) AND APPLY ONE LAYER OF BMS 10-20 TYPE 2, CORROSION RESISTANT FINISH (F-19.22).
- 6 DO NOT APPLY PRIMER ON THE PHENOLIC RING IN THIS AREA.
- 7 FOR 112N6101-2, APPLY BMS 10-60, TYPE 2, GLOSS ENAMEL, COLOR 707.

ITEM NUMBERS REFER TO IPL FIG. 1

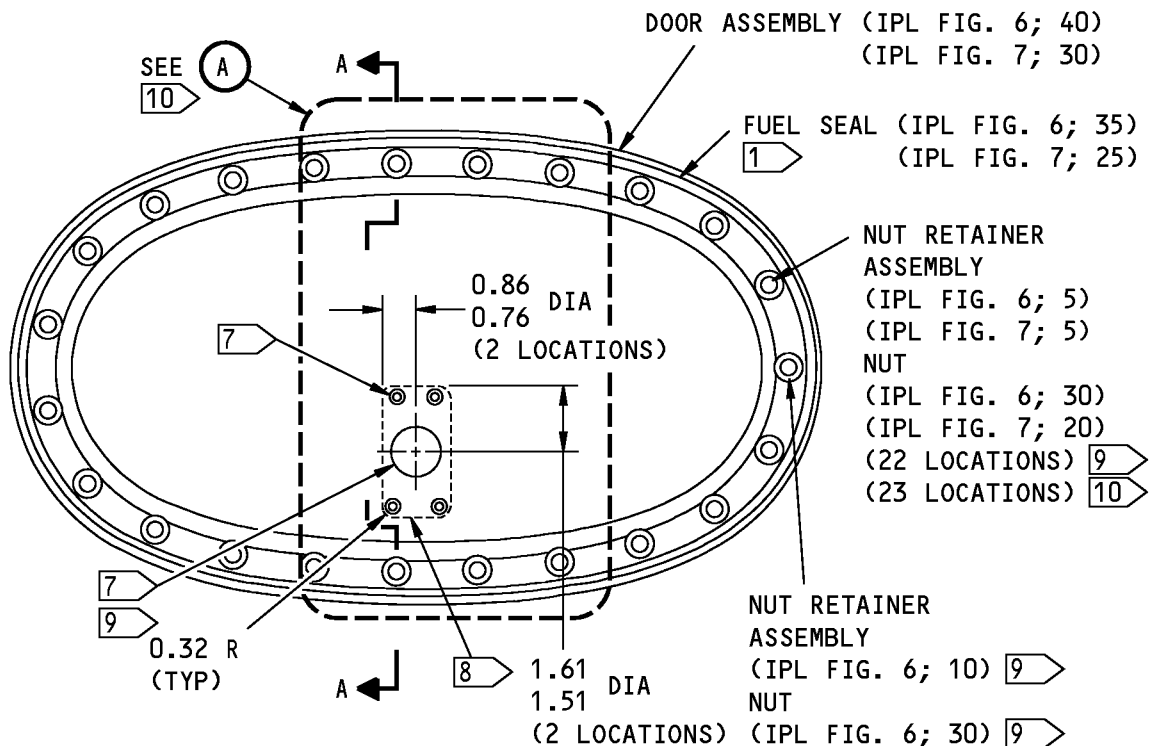
ALL DIMENSIONS ARE IN INCHES

112N6101-1,-2,-9 10 x 18 Fuel Tank Access Door Assembly
Figure 601 (Sheet 2 of 2)

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REPAIR 1-1
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- 1 BOND THE FUEL SEAL (55) WITH BMS 5-45, CLASS A.
- 2 IT IS NOT NECESSARY TO APPLY PRIMER ON THE INTERNAL SURFACE OF THE BOSS. OVERSPRAY IS PERMITTED.
- 3 CHEMICAL TREAT (F-17.15) AND APPLY ONE LAYER OF BMS 10-79 TYPE 3 PRIMER (F-19.47).
- 4 CHEMICAL TREAT (F-17.15 ONLY).

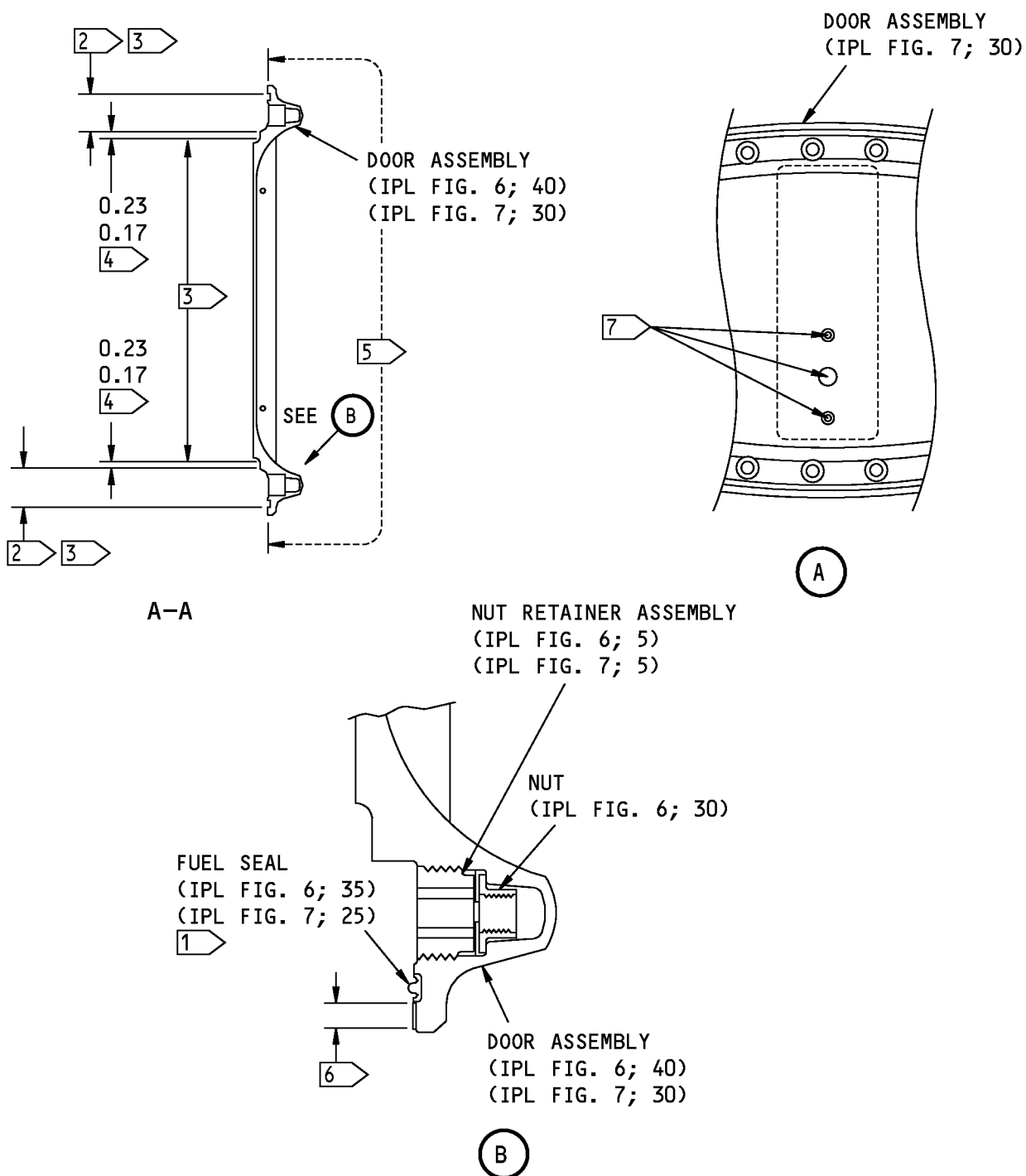
- 5 CHEMICAL TREAT (F-17.15) AND APPLY ONE LAYER OF BMS 10-20 TYPE 2, CORROSION RESISTANT FINISH (F-19.22).
- 6 DO NOT APPLY PRIMER ON THE PHENOLIC RING IN THIS AREA.
- 7 CHEMICAL TREAT (F-17.15) IS PERMITTED ON THE INTERNAL SURFACE OF THE HOLE. DO NOT APPLY OTHER FINISHES.
- 8 DO NOT APPLY PRIMER IN THIS AREA (FAR SIDE).
- 9 FOR 112N6101-3,-4,-5,-7
- 10 FOR 112N6101-6,-8,-10

112N6101-3 thru -8,-10 10 x 18 Fuel Tank Access Door Repair
Figure 602 (Sheet 1 of 2)

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ALL DIMENSIONS ARE IN INCHES

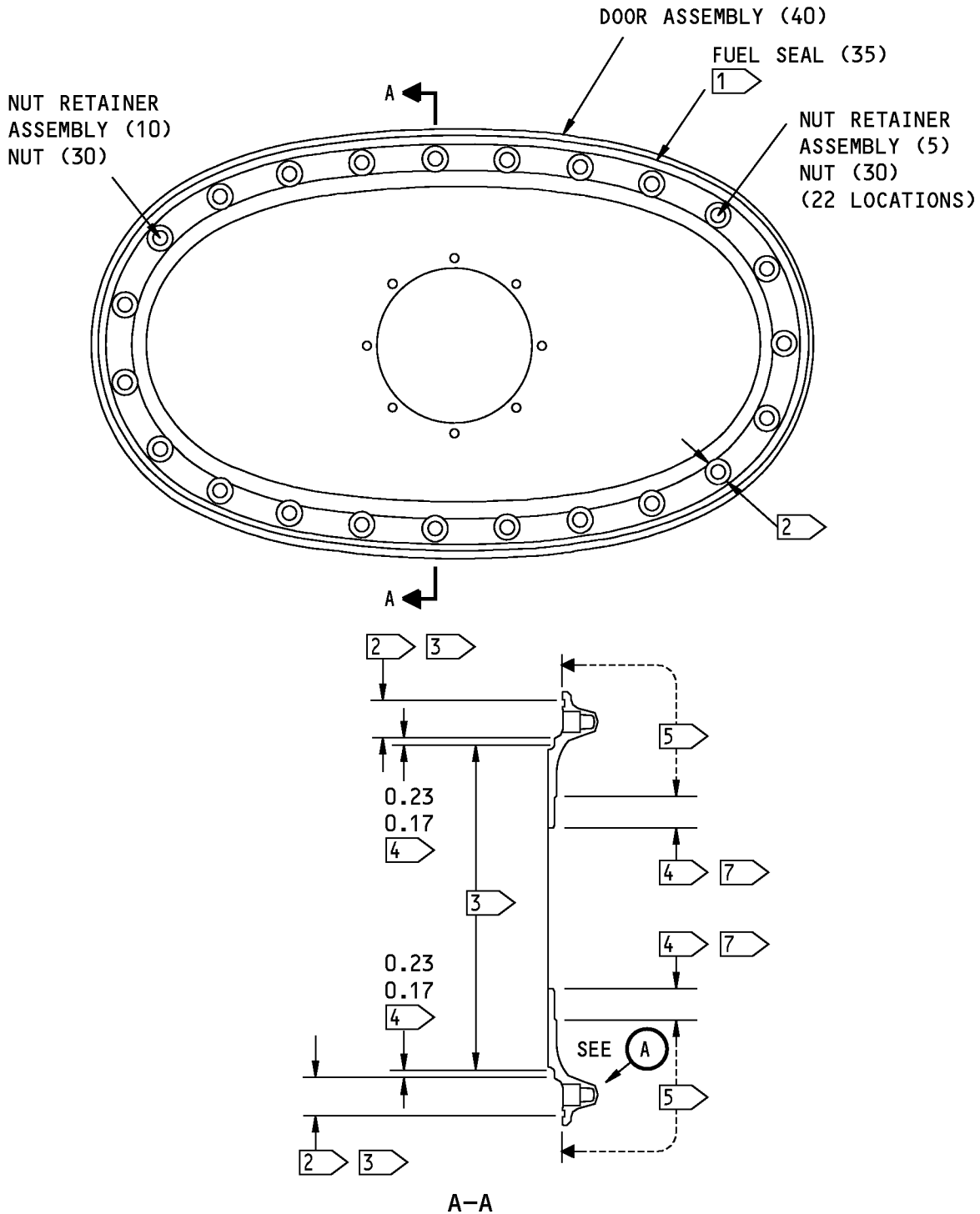
112N6101-3 thru -8,-10 10 x 18 Fuel Tank Access Door Repair
Figure 602 (Sheet 2 of 2)

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REPAIR 1-1
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ITEM NUMBERS REFER TO IPL FIG. 8

ALL DIMENSIONS ARE IN INCHES

112N6101-11 10 x 18 Fuel Tank Access Door Repair
Figure 603 (Sheet 1 of 2)

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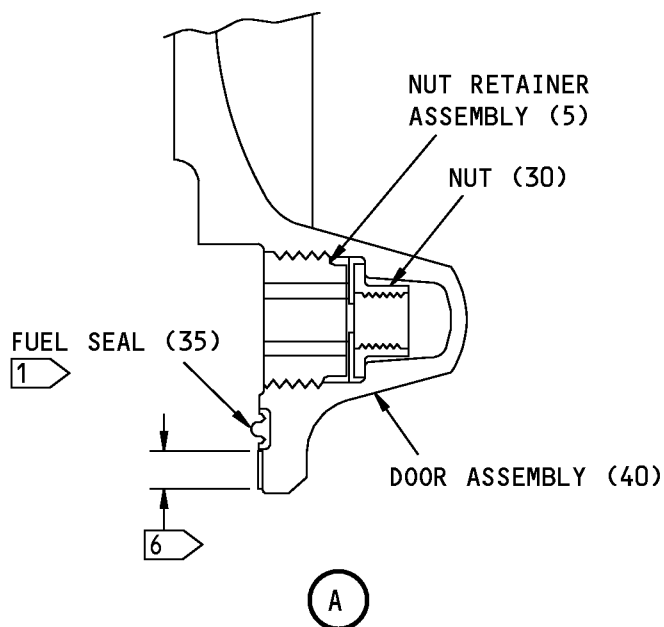
REPAIR 1-1

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COMPONENT MAINTENANCE MANUAL



- 1 BOND THE FUEL SEAL (55) WITH BMS 5-45, CLASS A.
- 2 IT IS NOT NECESSARY TO APPLY PRIMER ON THE INTERNAL SURFACE OF THE BOSS. OVERSPRAY IS PERMITTED.
- 3 CHEMICAL TREAT (F-17.15) AND APPLY ONE LAYER OF BMS 10-79 TYPE 3 PRIMER (F-19.47).
- 4 CHEMICAL TREAT (F-17.15) ONLY.

- 5 CHEMICAL TREAT (F-17.15) AND APPLY ONE LAYER OF BMS 10-20 TYPE 2, CORROSION RESISTANT FINISH (F-19.22).
- 6 DO NOT APPLY PRIMER ON THE PHENOLIC RING IN THIS AREA.
- 7 DO NOT APPLY PRIMER IN THIS AREA BECAUSE OF ELECTRICAL BONDING REQUIREMENTS.

ITEM NUMBERS REFER TO IPL FIG. 8
ALL DIMENSIONS ARE IN INCHES

112N6101-11 10 x 18 Fuel Tank Access Door Repair
Figure 603 (Sheet 2 of 2)

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REPAIR 1-1
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FUEL TANK ACCESS DOOR ASSEMBLY - REPAIR 2-1

112N6102-1

1. General

- A. This section has the necessary data to replace the fuel seal (25).
- B. Refer to Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 2 for the item numbers.

2. Fuel Seal Replacement

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A50153	Sealant - Fuel Tank - Class A-2	BMS5-45 Class A-2
C00175	Primer - Urethane Compatible, Corrosion Resistant (Less Than 1% Aromatic Amines)	BMS10-79, Type III
C00307	Coating - Corrosion Resistant Finish For Integral Fuel Tanks	BMS10-20, Type II

- B. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-50-12	APPLICATION OF ADHESIVES
SOPM 20-60-02	FINISHING MATERIALS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

- C. Procedure (REPAIR 2-1, Figure 601)

NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02. For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Install the fuel seal (25):
 - (a) Fully clean the fuel seal (25) before you install it on the door casting (40).
 - (b) Apply sealant, A50153 to the full width of the groove of fuel seal (25).
 - (c) Use sealant, A50153 to bond the fuel seal (25) to the door casting (40) as shown in SOPM 20-50-12.
 - 1) Obey the flag note 1 in REPAIR 2-1, Figure 601.
 - (d) Chemical treat (F-17.15) and apply primer, C00175 (F-19.47).
 - 1) Obey the flag note 2 in REPAIR 2-1, Figure 601.
 - 2) Obey the flag note 3 in REPAIR 2-1, Figure 601.

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REPAIR 2-1
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- (e) Chemical treat (F-17.15) to 0.20 inches on the surface shown.
 - 1) Obey the flag note 4 in REPAIR 2-1, Figure 601.
- (f) Chemical treat (F-17.15) and apply corrosion resistant coating, C00307 (F-19.22).
 - 1) Obey the flag note 5 in REPAIR 2-1, Figure 601.
- (g) Obey the flag note 6 in REPAIR 2-1, Figure 601.

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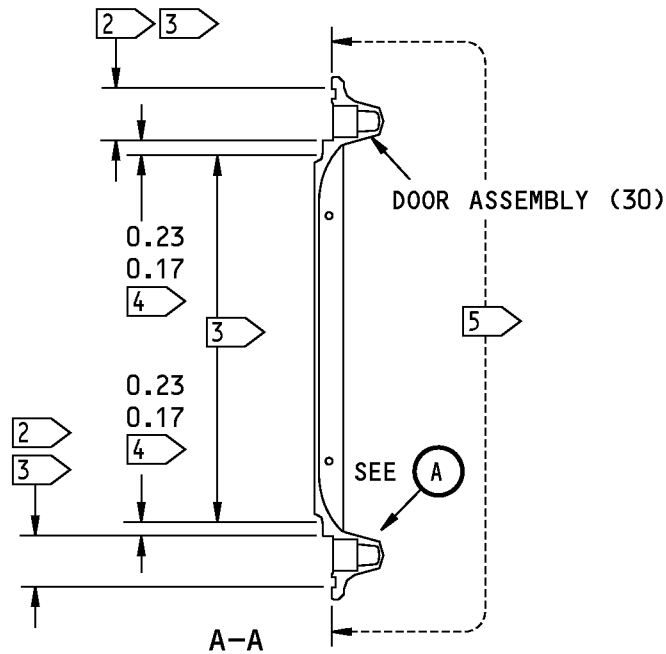
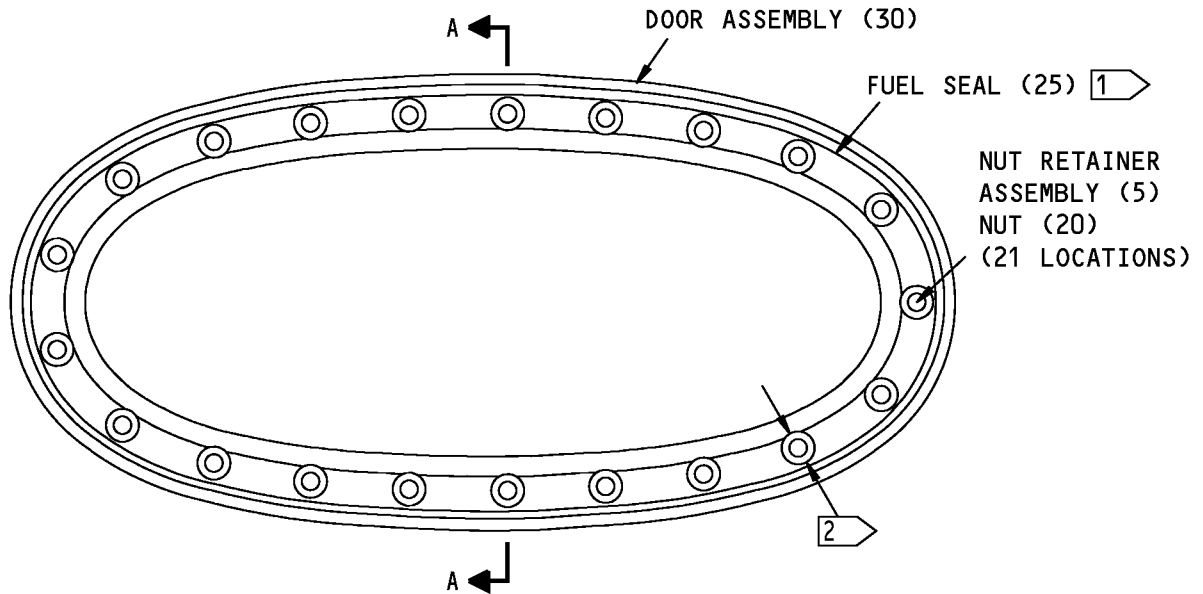
REPAIR 2-1

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112N6102-1 8 x 18 Fuel Tank Access Door Repair
Figure 601 (Sheet 1 of 2)

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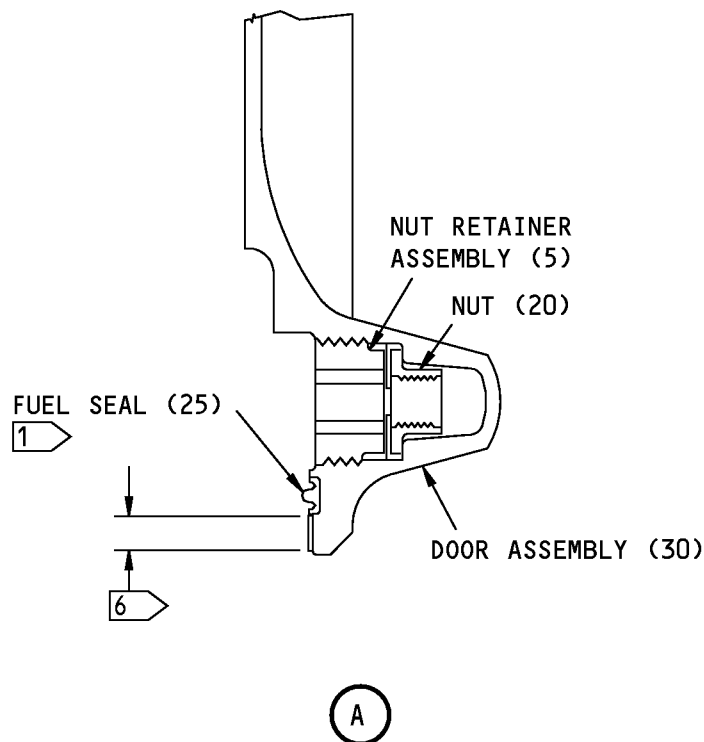
REPAIR 2-1

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- 1 BOND THE FUEL SEAL (55) WITH BMS 5-45, CLASS A.
- 2 IT IS NOT NECESSARY TO APPLY PRIMER ON THE INTERNAL SURFACE OF THE BOSS. OVERSPRAY IS PERMITTED.
- 3 CHEMICAL TREAT (F-17.15) AND APPLY ONE LAYER OF BMS 10-79 TYPE 3 PRIMER (F-19.47).

- 4 CHEMICAL TREAT (F-17.15 ONLY).
- 5 CHEMICAL TREAT (F-17.15) AND APPLY ONE LAYER OF BMS 10-20 TYPE 2, CORROSION RESISTANT FINISH (F-19.22).
- 6 DO NOT APPLY PRIMER ON THE PHENOLIC RING IN THIS AREA.

ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

112N6102-1 8 x 18 Fuel Tank Access Door Repair
Figure 601 (Sheet 2 of 2)

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REPAIR 2-1
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FUEL TANK ACCESS DOOR ASSEMBLY - REPAIR 3-1

112T4607-3, -5

1. General

- A. This section has the necessary data to refinish the door (IPL Figure 3, 15; IPL Figure 10, 15).
- B. Refer to Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 3, and IPL Figure 10.

2. Door Refinish

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
C00175	Primer - Urethane Compatible, Corrosion Resistant (Less Than 1% Aromatic Amines)	BMS10-79, Type III

- B. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

- C. Procedure (REPAIR 3-1, Figure 601 and REPAIR 3-1, Figure 602)

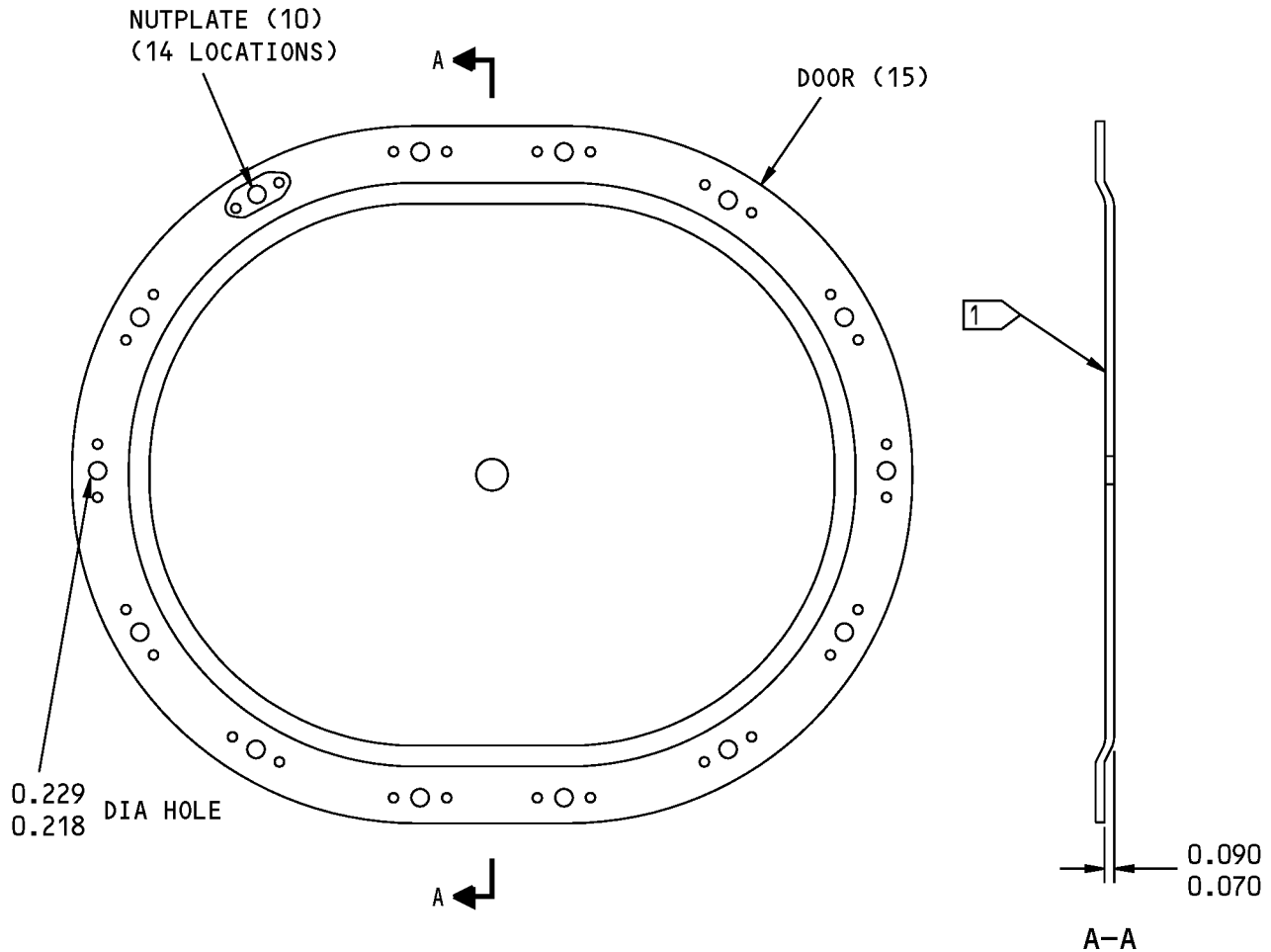
NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Put a finish on the door (IPL Figure 3, 15):
 - (a) Chemical treat (F-17.07) all the surfaces and apply one layer of primer, C00175 (F-19.47).
 - (b) Obey the flag note 1 in REPAIR 3-1, Figure 601.
- (2) Put a finish on the door (IPL Figure 10, 15):
 - (a) Chemical treat (F-17.15) all the surfaces and apply primer, C00175 (F-19.47).
 - (b) Obey the flag notes 1, 2 and 3 in REPAIR 3-1, Figure 602.

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1 RUBBER STAMP THE PART NUMBER ON
THIS SIDE (LOCATION IS OPTIONAL)

ITEM NUMBERS REFER TO IPL FIG. 3
ALL DIMENSIONS ARE IN INCHES

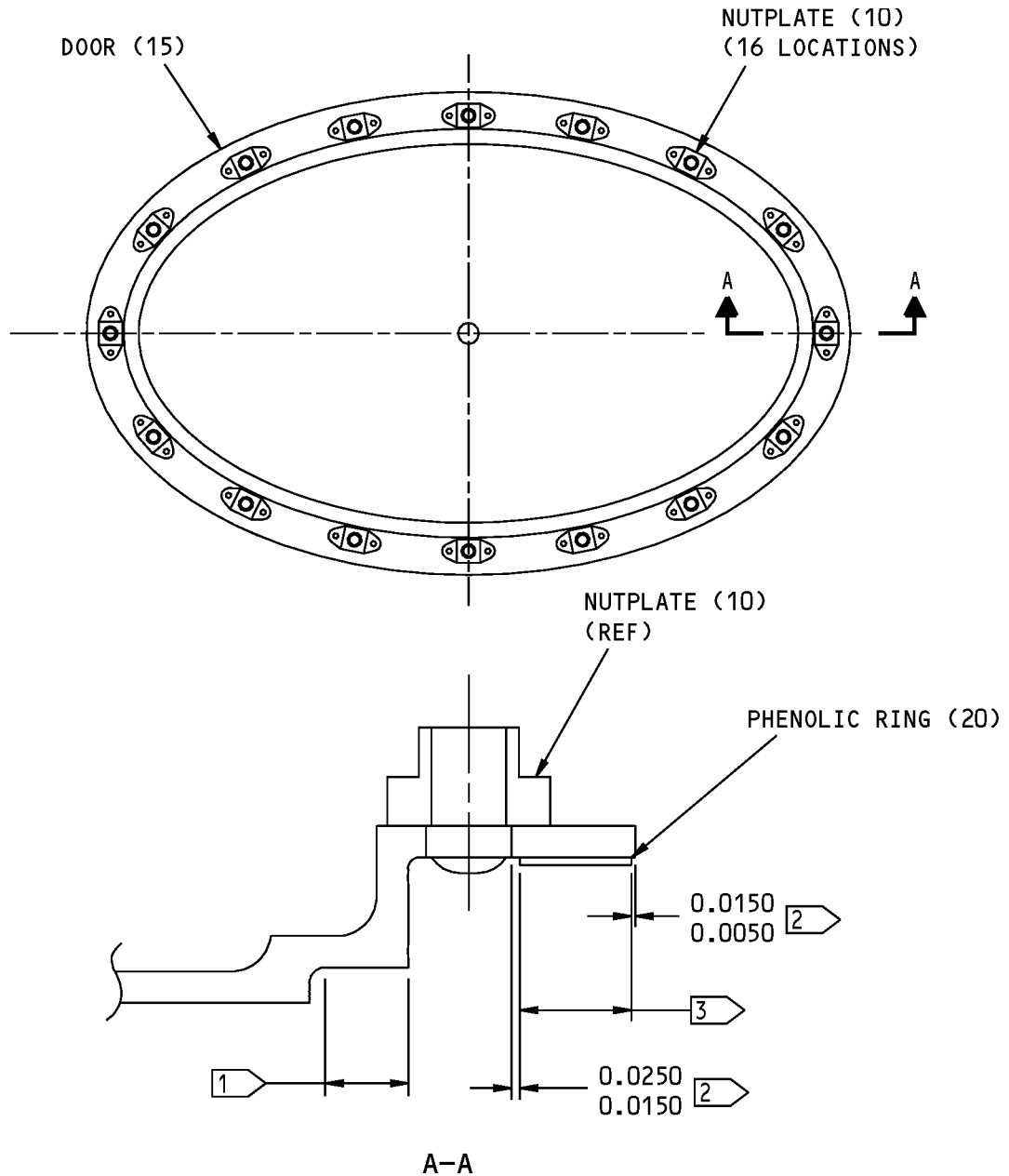
112T4607-3 Inspar Lower Wing Door Repair
Figure 601

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REPAIR 3-1
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- [1] CHEMICAL TREAT (F-17.15) THE AREA SHOWN
- [2] TRIM THE PHENOLIC RING (20) AS NECESSARY
- [3] DO NOT APPLY PRIMER ON THE AREA SHOWN

125 ✓ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

ITEM NUMBERS REFER TO IPL FIG. 1C
ALL DIMENSIONS ARE IN INCHES

112T4607-5 Inspar Lower Wing Door Repair
Figure 602

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REPAIR 3-1
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FUEL TANK ACCESS DOOR ASSEMBLY - REPAIR 4-1

342W2801-3, -4, -5, -6, -7, -8, -9, -10

1. General

- A. This section has the necessary data to replace the parts on the door assembly.
- B. Refer to Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 4 for the item numbers.

2. Door Parts Replacement

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A50110	Sealant	BMS5-45 Class B-2

- B. References

Reference	Title
SOPM 20-11-03	REPAIR OF ELECTRICAL TERMINATIONS AND ELECTRICAL BONDING AREAS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

- C. Procedure (REPAIR 4-1, Figure 601)

NOTE: For miscellaneous materials, refer to SOPM 20-60-04.

- (1) After you install the screws (60) and the washers (65), fillet seal the lower ducts (70, 75) with sealant, A50110 as shown in flag note 1.
- (2) Fillet seal the head of the screws (60) and the washers (65) with sealant, A50110 as shown in flag note 2.
- (3) Fay seal the surface with sealant, A50110 as shown in flag note 3.
- (4) Clean the lower surface of the upper duct assembly (45 thru 48) as shown in flag note 4 (SOPM 20-11-03).
- (5) Install the bonding jumper (40) as shown in flag note 5 (SOPM 20-11-03).

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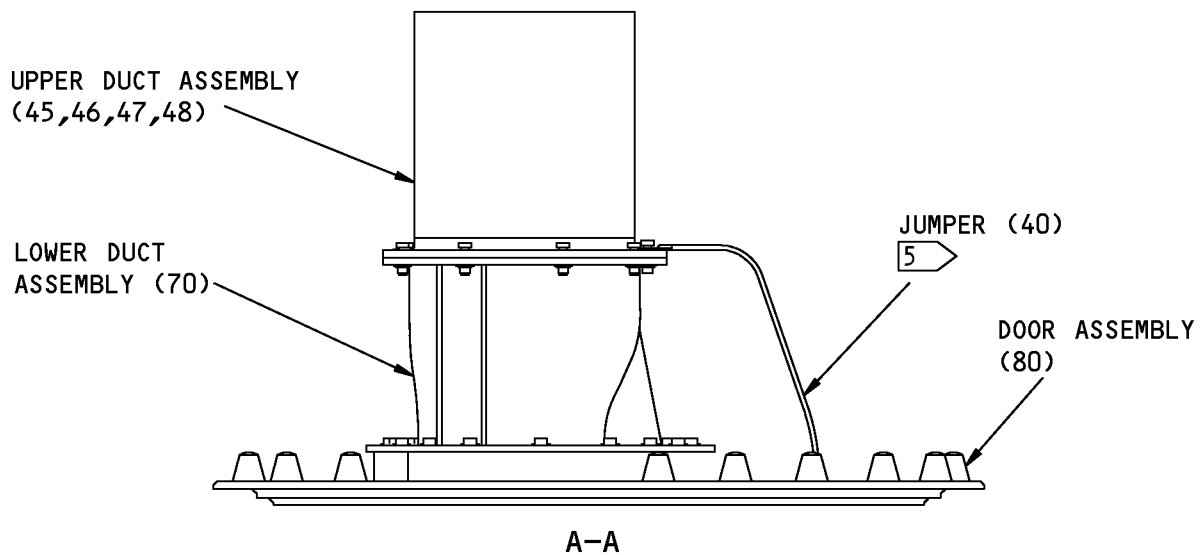
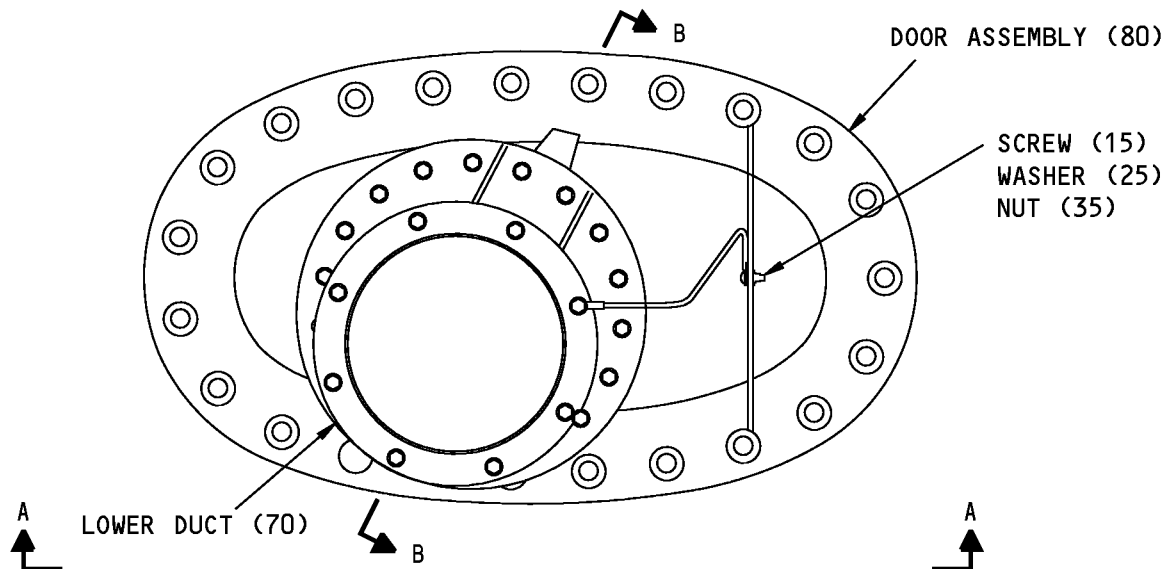
REPAIR 4-1

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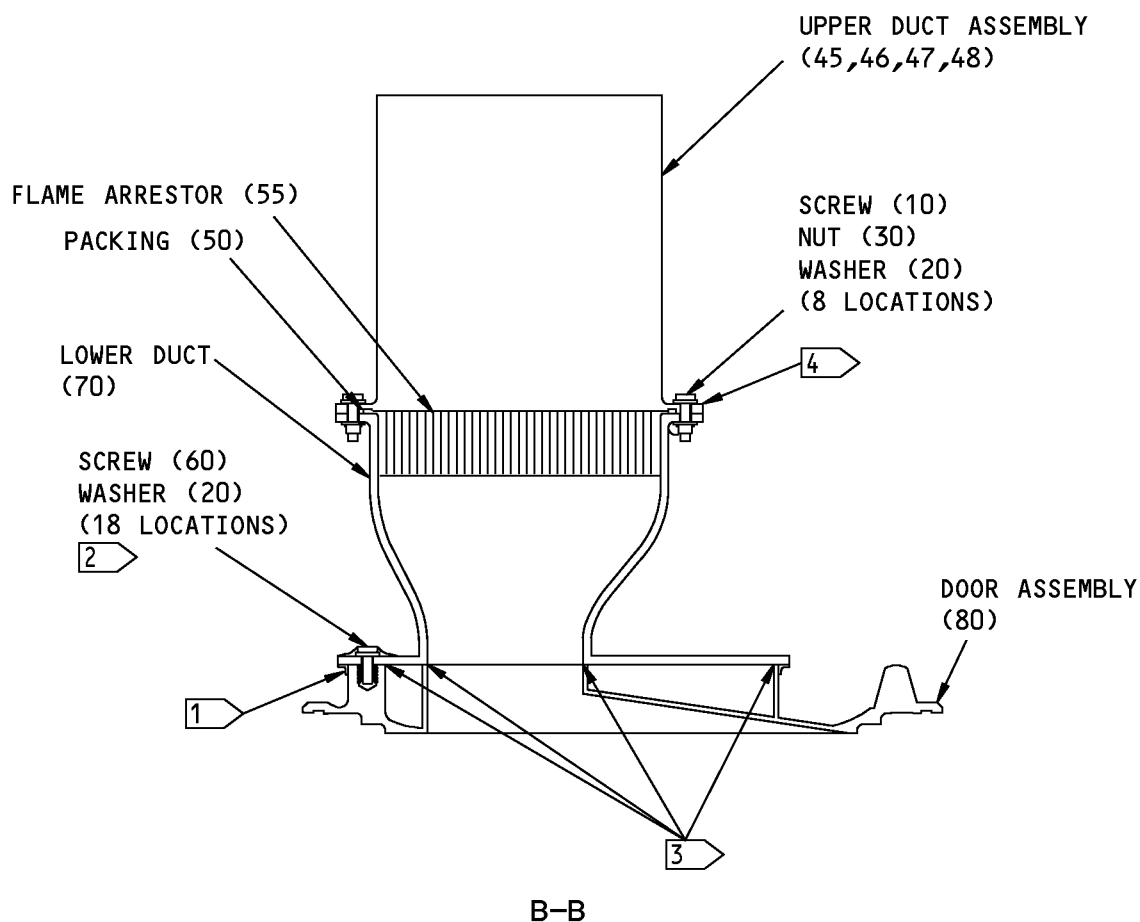


342W2801-3 Thru -10 Fuel Vent Systems Standpipe/Flame Arrestor Door Repair
Figure 601 (Sheet 1 of 2)

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REPAIR 4-1
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- 1 FILLET SEAL WITH BMS 5-45,
SEALANT. (SOPM 20-60-04).
- 2 FILLET SEAL THE FASTENER HEAD
AND THE WASHER WITH BMS 5-45,
SEALANT (SOPM 20-60-04).
- 3 FAY SEAL THE SURFACE SHOWN
WITH BMS 5-45, SEALANT
(SOPM 20-60-04)

- 4 CLEAN THE LOWER SURFACE OF THE
342W2108, UPPER DUCT AS SHOWN IN
SOPM 20-11-03 BEFORE YOU INSTALL IT
AGAINST THE 342W2001, LOWER DUCT.
- 5 INSTALL THE BONDING JUMPERS AS SHOWN
IN SOPM 20-11-03. THE MAXIMUM
RESISTANCE BETWEEN THE UPPER DUCT
AND THE ACCESS DOOR MUST NOT BE MORE
THAN 0.01 OHMS.

ITEM NUMBERS REFER TO IPL FIG. 4
ALL DIMENSIONS ARE IN INCHES

342W2801-3 Thru -10 Fuel Vent Systems Standpipe/Flame Arrestor Door Repair
Figure 601 (Sheet 2 of 2)

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VENT SCOOP DOOR ASSEMBLY - REPAIR 4-2

112W8100-1, -2

1. General

- A. This section has the necessary data to refinish the door (80, 85).
- B. Refer to Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 4 for the item numbers.

2. Door Refinish

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A50153	Sealant - Fuel Tank - Class A-2	BMS5-45 Class A-2

- B. References

Reference	Title
SOPM 20-50-12	APPLICATION OF ADHESIVES
SOPM 20-60-04	MISCELLANEOUS MATERIALS

- C. Procedure (REPAIR 4-2, Figure 601)

NOTE: For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Install the fuel seal (125):

- (a) Fully clean the fuel seal (125) before you install it on the door (135, 140).
- (b) Apply sealant, A50153 to the full width of the groove of fuel seal (125).
- (c) Use sealant, A50153 to bond the fuel seal (125) to the door (135, 140) as shown in SOPM 20-50-12.
 - 1) Visual signs of bond delamination must not be more than 25 percent after machining of the seal groove.
 - 2) The thickness of the phenolic ring (130) must be 0.015 minimum.
 - a) Obey the flag note 4 in REPAIR 4-2, Figure 601.
 - 3) You must keep the dimensions of the phenolic ring (130) when you install the phenolic ring (130).
 - a) Obey the flag note 4 in REPAIR 4-2, Figure 601.

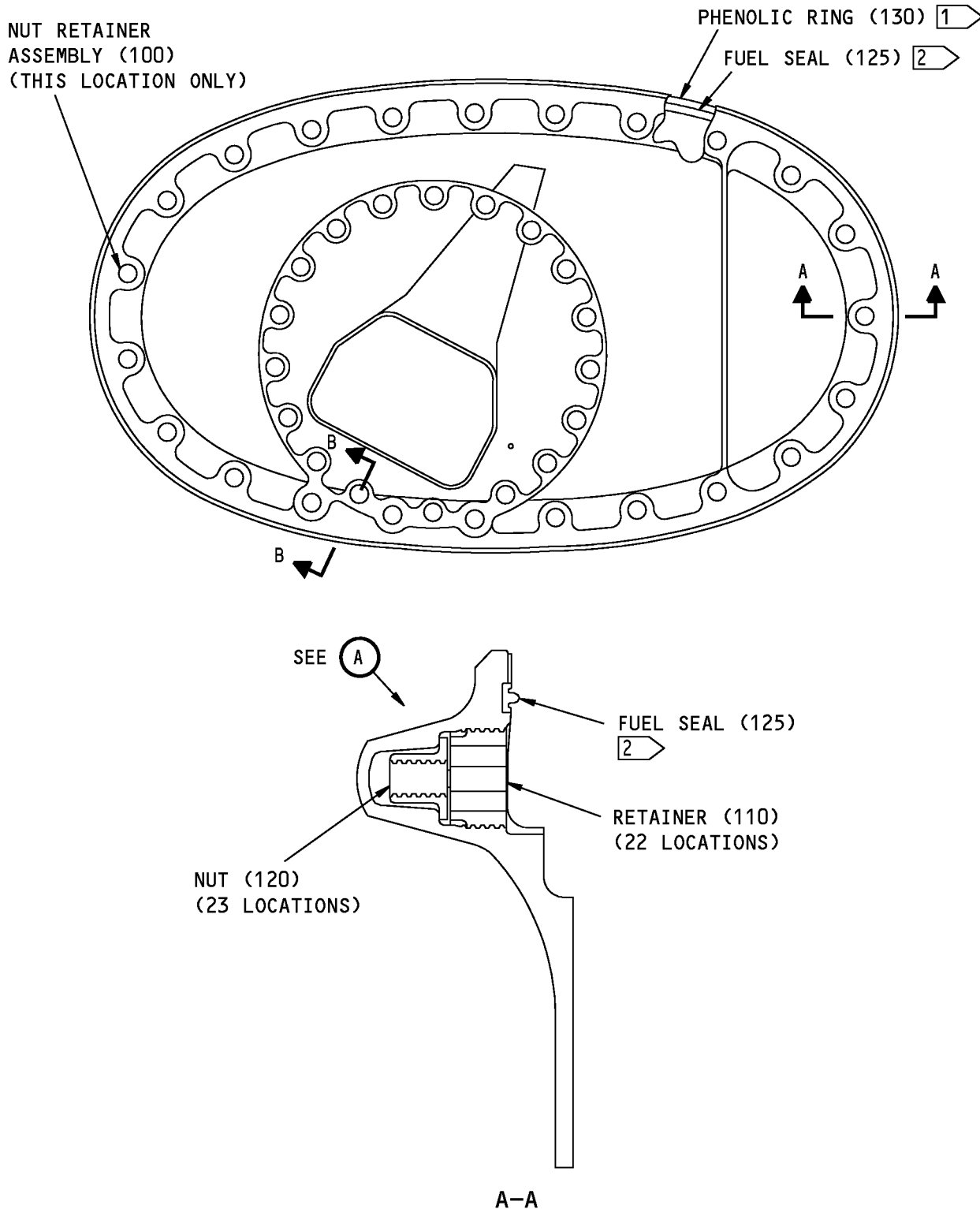
- (2) Install the phenolic ring (130):

- (a) Use sealant, A50153 to bond the phenolic ring (130).
 - 1) Obey the flag note 1 in REPAIR 4-2, Figure 601.
- (b) Obey the flag note 3 in REPAIR 4-2, Figure 601.

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112W8100-1,-2 Vent Scoop Door Repair
Figure 601 (Sheet 1 of 2)

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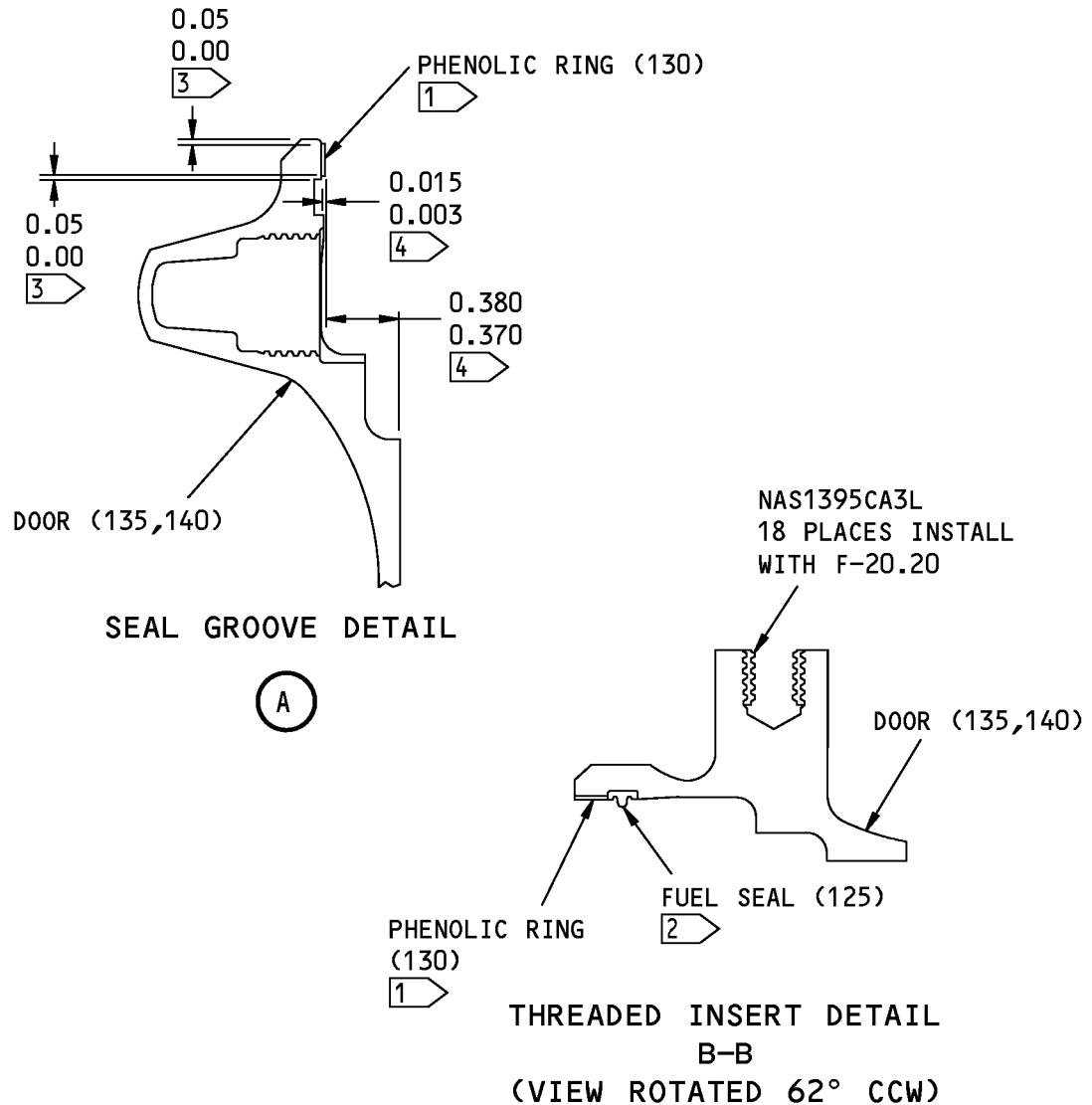
REPAIR 4-2

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1 BOND AS SHOWN IN SOPM 20-50-12
TYPE 44 AND APPLY BMS 5-45,
CLASS A SEALANT.

2 BOND THE FUEL SEAL (125) WITH
BMS 5-45, CLASS A.

3 TRIM THE PHENOLIC RING (130) IF
IT IS NECESSARY.

4 INSTALLED DIMENSIONS

ITEM NUMBERS REFER TO IPL FIG. 4
ALL DIMENSIONS ARE IN INCHES

112W8100-1,-2 Vent Scoop Door Repair
Figure 601 (Sheet 2 of 2)

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REPAIR 4-2

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FUEL TANK ACCESS DOOR ASSEMBLY - REPAIR 5-1

015T0415-15, 110U6011-1, -2, 110U6021-1, -2, 65C33092-2, -3, -4, -5, -6, -7, -8, -9

1. General

- A. This section has the necessary data to repair and refinish the fuel tank access door assembly.
- B. Refer to Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the standard true position dimensioning symbols shown in the repair.
- D. Refer to IPL Figure 5 for the item numbers.

2. Repair and Refinish

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A50153	Sealant - Fuel Tank - Class A-2	BMS5-45 Class A-2
C00032	Coating - Exterior Protective Enamel, General Use	BMS10-60, Type I
C00175	Primer - Urethane Compatible, Corrosion Resistant (Less Than 1% Aromatic Amines)	BMS10-79, Type III
C00307	Coating - Corrosion Resistant Finish For Integral Fuel Tanks	BMS10-20, Type II
C00700	Coating - Exterior Protective Enamel, Gray Gloss Enamel	BMS10-60, Type I, BAC 707
C00767	Coating - Anti-Static Coating	BMS10-21, Type III
C50016	Coating - Flexible Corrosion Inhibiting Topcoat	BMS10-100

- B. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-50-12	APPLICATION OF ADHESIVES
SOPM 20-60-02	FINISHING MATERIALS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

- C. Fuel Seal Replacement (REPAIR 5-1, Figure 601)

NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02. For miscellaneous materials, refer to SOPM 20-60-04.

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- (1) Install the fuel seal (30):
 - (a) Fully clean the fuel seal (30) before you install it on the door casting.
 - (b) Apply sealant, A50153 to the full width of the groove of fuel seal (30):
 - 1) Use sealant, A50153 to bond the fuel seal (30) to the door casting per flag note 1 in REPAIR 5-1, Figure 601 (SOPM 20-50-12).

D. Install Inserts (5) and Nut Retainers

- (1) Install insert (5) and nut (25) or self-locking nut (27) per D6-38192 per flag notes 5 and 7 in REPAIR 5-1, Figure 601.
- (2) Install the nut retainer assembly (10) on the insert (5):
 - (a) Make sure the bottom of the nut retainer assembly (10) touches the land area of the insert (5) per flag note 6 in REPAIR 5-1, Figure 601.

E. Refinish

- (1) Refinish the face sheet (35) as defined in flag note 2 in REPAIR 5-1, Figure 601.
 - (a) For 65C33092-2:
 - 1) Apply primer, C00175 (F-19.47).
 - 2) Apply enamel coating, C50016 (F-19.70).
 - (b) For 65C33092-3, -4, -6, -8:
 - 1) Apply primer, C00175 (F-19.47).
 - 2) Apply enamel coating, C00700 (F-19.39-707).
 - (c) For 65C33092-5, -7, -9:
 - 1) Apply primer, C00175 (F-19.47).
- (2) Refinish the backing plate (40) as follows: For 65C33092-3
 - (a) For 65C33092-3:
 - 1) Apply a layer of coating, C00767 (F-14.685, which replaces SRF-14.685) and a layer of coating, C00307 (F-19.22) to all the surfaces of the backing plate (40) that you can see. Apply coating, C00767 (SRF-14.685) approximately 0.10 inches of the outer surface of the face sheet (35) only per flag note 3 in REPAIR 5-1, Figure 601.
 - (b) For 110U6011-1, -2; 110U6021-1, -2; 65C33092-2, -4 thru -9:
 - 1) Apply a layer of anti-static coating, C00767 (F-14.685, which replaces SRF-14.685) to all the surfaces of the backing plate (40) that you can see. Apply anti-static coating, C00767 (F-14.685, which replaces SRF-14.685) approximately 0.10 inches of the outer surface of the face sheet (35) only per flag note 3 in REPAIR 5-1, Figure 601.
 - 2) Apply a layer of coating, C00307 (F-19.22) to all the surfaces of the backing plate (40) that you can see. Apply coating, C00307 (F-19.22) approximately 0.02 inches of the outer surface of the face sheet (35) only per flag note 4 in REPAIR 5-1, Figure 601.
- (3) Apply one layer of coating, C00307 (F-19.22) on the inner wall of the insert to a minimum depth of 0.125 inches as measured from the top of the insert per flag note 8 in REPAIR 5-1, Figure 601.

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- (4) Refinish of stenciled fuel tank access door assembly P/N 015T0415-15 as shown in REPAIR 5-1, Figure 602.

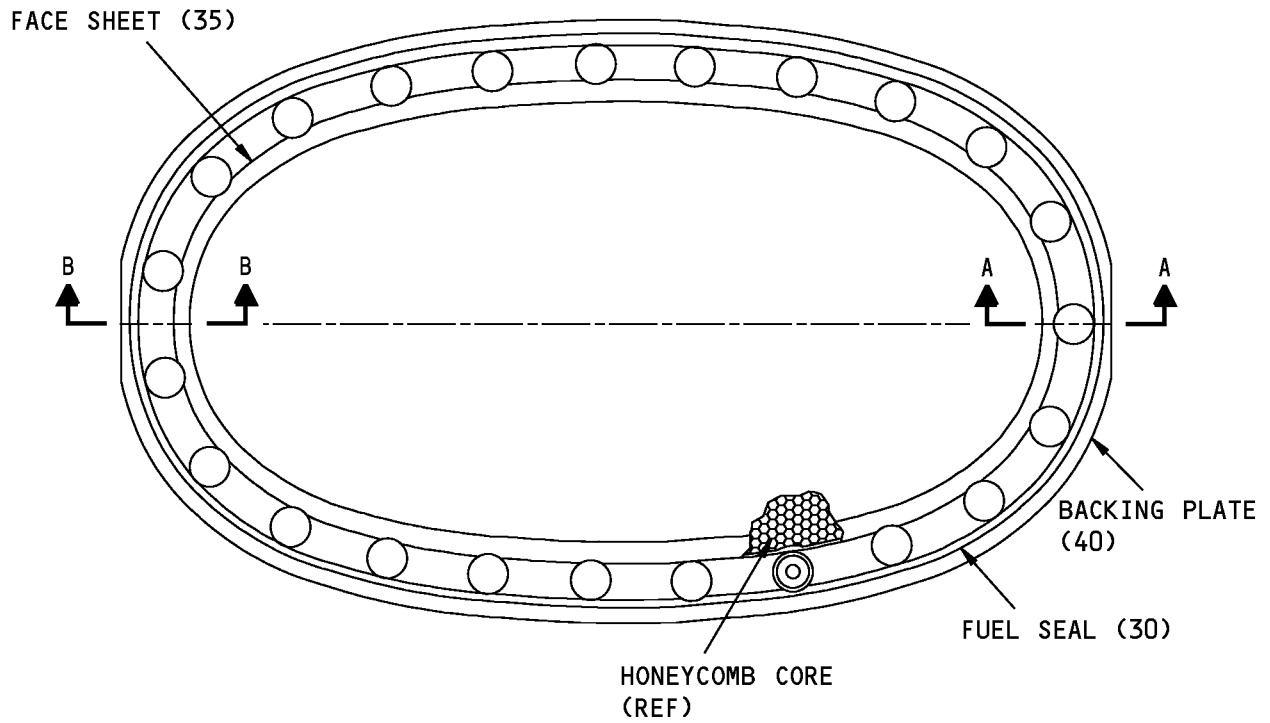
NOTE: Fuel access door assembly P/N P/N 015T0415-15 is made from the fuel access door assembly P/N 015T0415-8 with stencils applied by the following procedures.

- (a) For 015T0415-8 : Apply primer, C00175 and enamel coating, C50016 (F-19.70) to fuel tank access door assembly P/N 65C33092-5 or 65C33092-9 per flag note 1 in REPAIR 5-1, Figure 602.
- (b) Stencil in 0.50 inch letters with gloss enamel coating, C00032, BAC701 black on P/N 015T0415-8 fuel tank access door per flag note 2 in REPAIR 5-1, Figure 602.
- (c) Stencil index mark with gloss enamel coating, C00032, BAC701 black on P/N 015T0415-8 fuel tank access door per flag note 3 in REPAIR 5-1, Figure 602.

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110U6011-1,-2; 110U6021-1,-2; 65C33092-2 thru -9 10 x 18 Fuel Tank Access Door Repair
Figure 601 (Sheet 1 of 4)

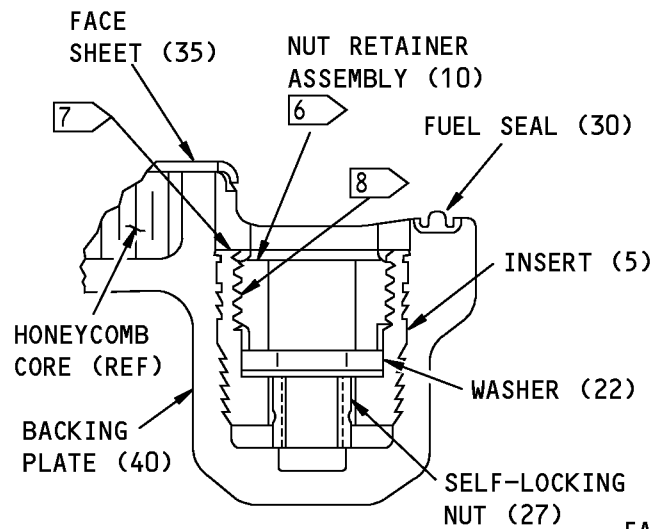
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REPAIR 5-1

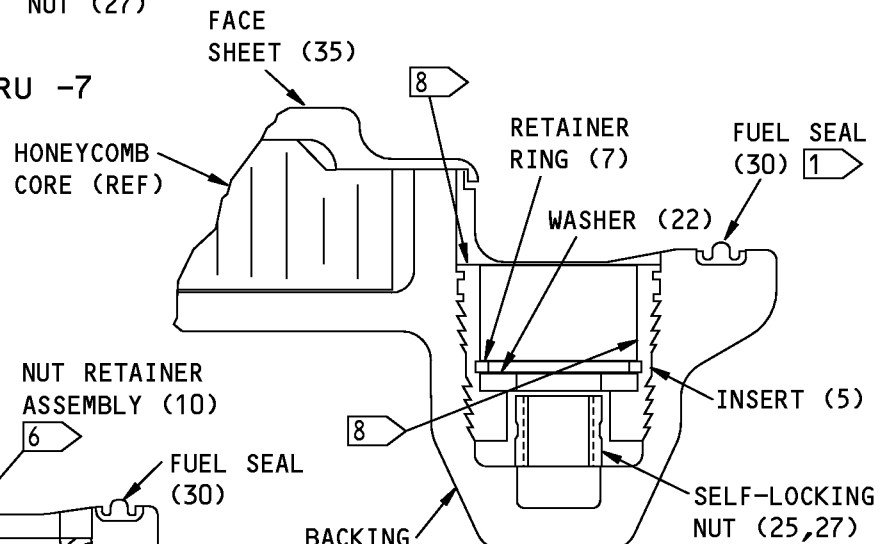
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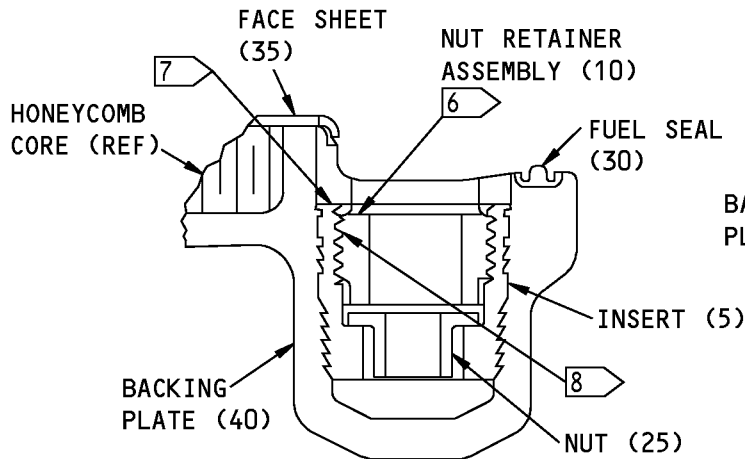
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A-A
65C33092-2,-4 THRU -7



A-A
65C33092-3
110U6011-1
110U6021-1



A-A
110U6011-2
1110U6021-2
65C33092-8,-9

M51698 S0006771370_V3

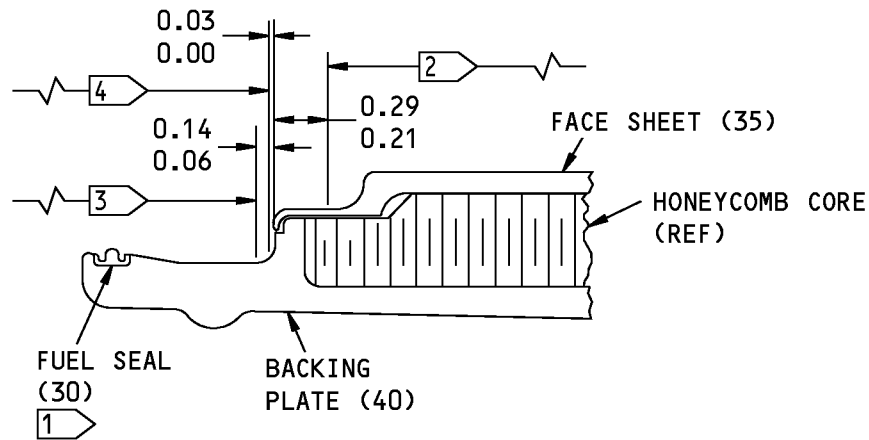
110U6011-1,-2; 110U6021-1,-2; 65C33092-2 thru -9 10 x 18 Fuel Tank Access Door Repair
Figure 601 (Sheet 2 of 4)

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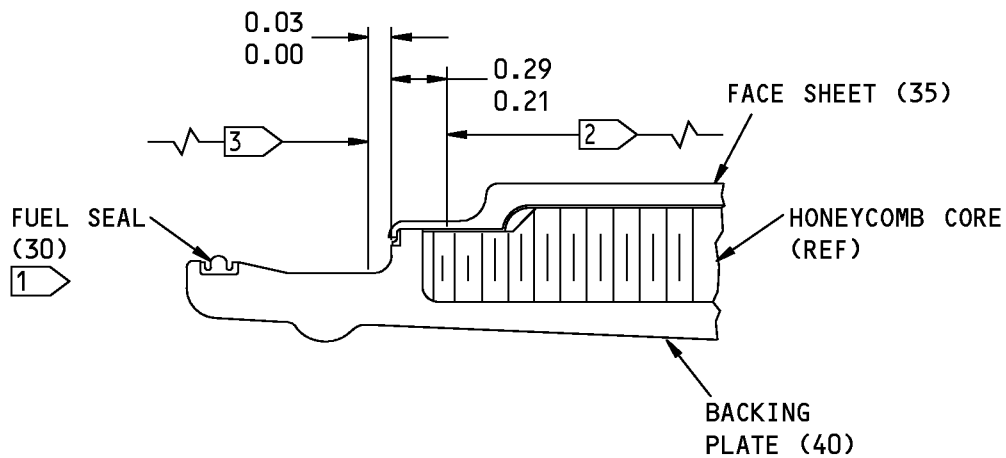
REPAIR 5-1
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B-B
110U6011-1,-2
110U6021-1,-2
65C33092-2,-4 THRU -9



B-B
65C33092-3

M51690 S0006771371_V3

110U6011-1,-2; 110U6021-1,-2; 65C33092-2 thru -9 10 x 18 Fuel Tank Access Door Repair
Figure 601 (Sheet 3 of 4)

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- 1 BOND THE FUEL SEAL (30) WITH
BMS 5-45 CLASS A-2,
- 2 FOR 65C33092-2:
APPLY BMS 10-79, TYPE 3, PRIMER
(F-19.47) PLUS BMS 10-100 ENAMEL
(F-19.70).
FOR 65C33092-3,-4,-6,-8:
APPLY BMS 10-79, TYPE 3, PRIMER
(F-19.47) PLUS BMS 10-60 ENAMEL
(F-19.39-707).
FOR 65C33092-5,-7,-9;
110U6011-1,-2; 110U6021-1,-2:
APPLY BMS 10-79, TYPE 3, PRIMER
(F-19.47).
- 3 FOR 65C33092-3:
APPLY BMS 10-21 COATING
(F-14.685, WHICH REPLACES
SRF-14.68) PLUS APPLY BMS 10-20,
TYPE 2 COATING (F-19.22).
FOR 65C33092-2,-4 THRU -9;
110U6011-1,-2; 110U6021-1,-2:
APPLY BMS 10-21 COATING
(F-14.685, WHICH REPLACES
SRF-14.68).
- 4 FOR 65C33092-2,-4 THRU -9;
110U6011-1,-2; 110U6021-1,-2:
APPLY BMS 10-20, TYPE 2 COATING
(F-19.22).
- 5 INSTALL INSERT PER D6-38192.
- 6 **CAUTION:** DO NOT APPLY ADDITIONAL
TORQUE TO THE NUT RETAINER
ASSEMBLY ONCE THE BOTTOM OF THE
NUT RETAINER ASSEMBLY TOUCHES
THE LAND AREA OF THE INSERT.
ADDITIONAL TORQUE COULD DAMAGE
THE INSERT.

- 7 THE INSERTS MUST BE ALIGNED AND
SMOOTH WITH BACKING PLATE, SPOTFACE
TO WITHIN 0.000-0.020 INCHES.
- 8 APPLY ONE LAYER OF BMS 10-20 TYPE 2
(F-19.22) ON THE INNER WALL OF THE
INSERT TO A MINIMUM DEPTH OF 0.125
INCHES AS MEASURED FROM THE TOP OF
THE INSERT.

ITEM NUMBERS REFER TO IPL FIG. 5
ALL DIMENSIONS ARE IN INCHES

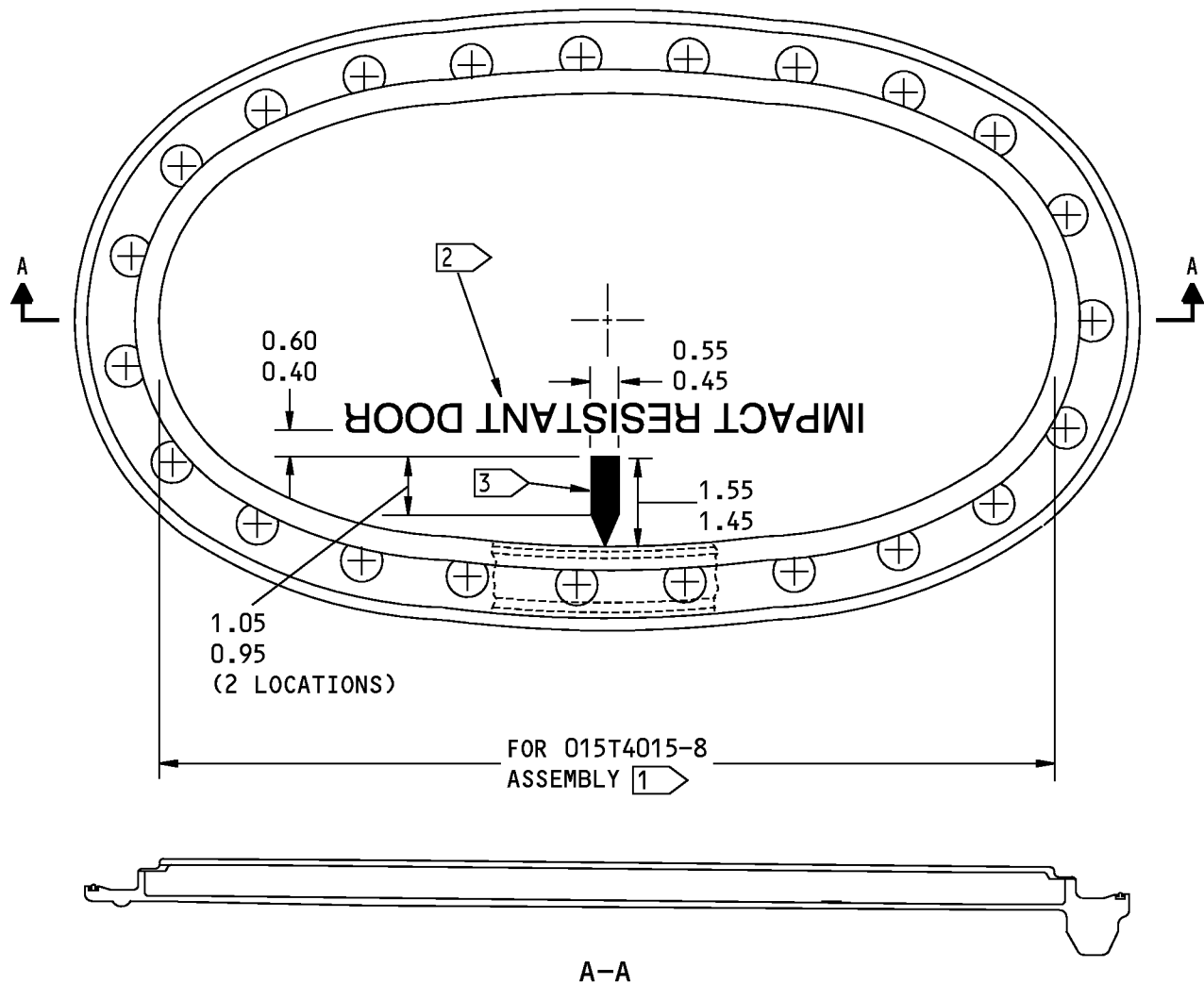
F30878 S0006771372_V3

110U6011-1,-2; 110U6021-1,-2; 65C33092-2 thru -9 10 x 18 Fuel Tank Access Door Repair
Figure 601 (Sheet 4 of 4)

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REPAIR 5-1
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- 1 APPLY BMS 1-79, TYPE 3 PRIMER
AND BMS 10-100 ENAMEL (F-19.70)
- 2 APPLY STENCIL IN 0.50 INCH LETTERS
WITH BMS 10-60, POLYURETHANE GLOSS
ENAMEL, BLACK BAC701
- 3 APPLY INDEX MARK WITH BMS 10-60
POLYURETHANE GLOSS ENAMEL BLACK
BAC701

ALL DIMENSIONS ARE IN INCHES

015T0415-15 Fuel Tank Access Door Stencil Details
Figure 602

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FUEL TANK ACCESS DOOR ASSEMBLY - REPAIR 6-1

110U6012-1, -2, 110U6022-1, -2, 65C33147-3, -4, -5, -6, -7, -8, -9, -10

1. General

- A. This section has the necessary data to repair and refinish the fuel tank access door assembly (1A, IPL Figure 9).
- B. Refer to Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the standard true position dimensioning symbols shown in the repair.
- D. Refer to IPL Figure 9 for the item numbers.

2. Repair and Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A50153	Sealant - Fuel Tank - Class A-2	BMS5-45 Class A-2
C00175	Primer - Urethane Compatible, Corrosion Resistant (Less Than 1% Aromatic Amines)	BMS10-79, Type III
C00307	Coating - Corrosion Resistant Finish For Integral Fuel Tanks	BMS10-20, Type II
C00700	Coating - Exterior Protective Enamel, Gray Gloss Enamel	BMS10-60, Type I, BAC 707
C00767	Coating - Anti-Static Coating	BMS10-21, Type III

B. References

Reference	Title
BAC 5504	INTEGRAL FUEL TANK STRUCTURE SEALING
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

C. Fuel Seal Replacement

NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02. For miscellaneous materials, refer to SOPM 20-60-04.

(1) Install the fuel seal (45):

- (a) Fully clean the fuel seal (45) before you install it on the door casting.

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REPAIR 6-1

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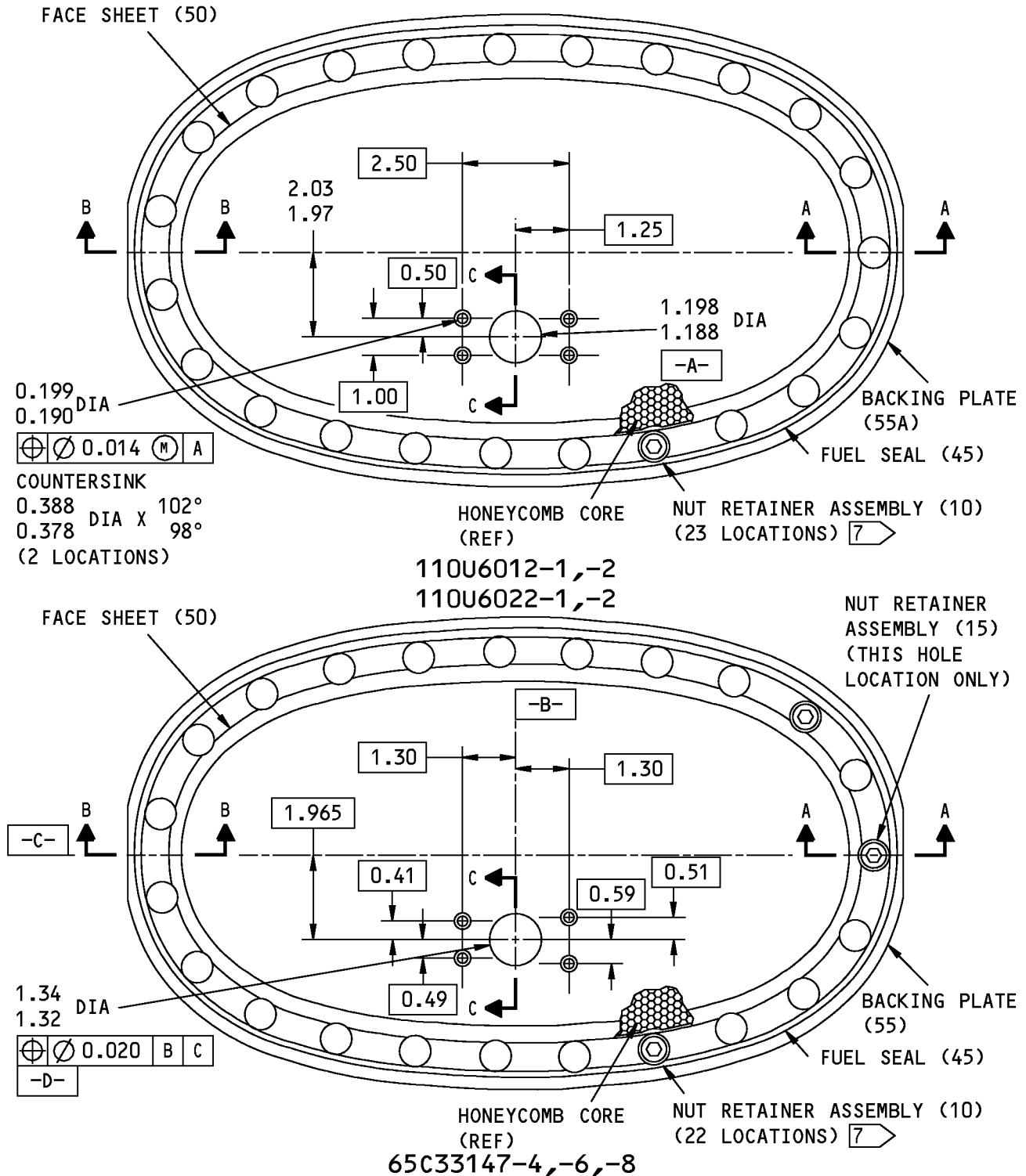
COMPONENT MAINTENANCE MANUAL

- (b) Apply sealant, A50153 to the full width of the groove of fuel seal (45):
 - 1) Use sealant, A50153 to bond the fuel seal (45) to the door casting as shown in flag note 1 in REPAIR 6-1, Figure 601.
- D. Install the insert (5)
 - (1) Install the nut retainer assembly (10) on the insert (5):
 - (a) Make sure the bottom of the nut retainer assembly (10) touches the land area of the insert (5).
 - (b) Obey the flag note 5 and 6 in REPAIR 6-1, Figure 601.
 - (2) Apply one layer of coating, C00307 (F-19.22) on the inner wall of the insert to a minimum depth of 0.125 inches as measured from the top of the insert per flag note 7 in REPAIR 6-1, Figure 601.
- E. Refinish
 - (1) Apply primer, C00175 (F-19.47) per flag note 4 in REPAIR 6-1, Figure 601.
 - (2) Apply a layer of coating, C00767 (SRF-14.685) to all the surfaces of the backing plate (40) that you can see. Apply coating, C00767 (SRF-14.685) approximately 0.10 inches of the outer surface of the face sheet (50) only per flag note 5 in REPAIR 6-1, Figure 601.
 - (3) Apply one layer of coating, C00307 (F-19.22) to all the surfaces of the backing plate (40) that you can see per flag note 6 in REPAIR 6-1, Figure 601.
 - (4) Apply primer, C00175 (F-19.47) and enamel coating, C00700 (F-19.39-707) to the upper surface only per flag note 9 in REPAIR 6-1, Figure 601.
- F. Install base plate (54)
 - (1) Apply sealant, A50153 as a faying surface seal between the base plate (54) and the face sheet (50) per flag note 11 in REPAIR 6-1, Figure 601
 - (2) Apply a continuous fuel fillet seal around the edges of the base plate (54) per flag note 8 in REPAIR 6-1, Figure 601 and BAC 5504.
 - (3) Apply sealant, A50153 to include the upset head of the rivets (52) per flag note 12 and BAC 5504.
 - (4) The maximum resistance permitted between the base plate (54) and the face sheet (50) after assembly is 0.0005 Ohms per flag note 10 in REPAIR 6-1, Figure 601.

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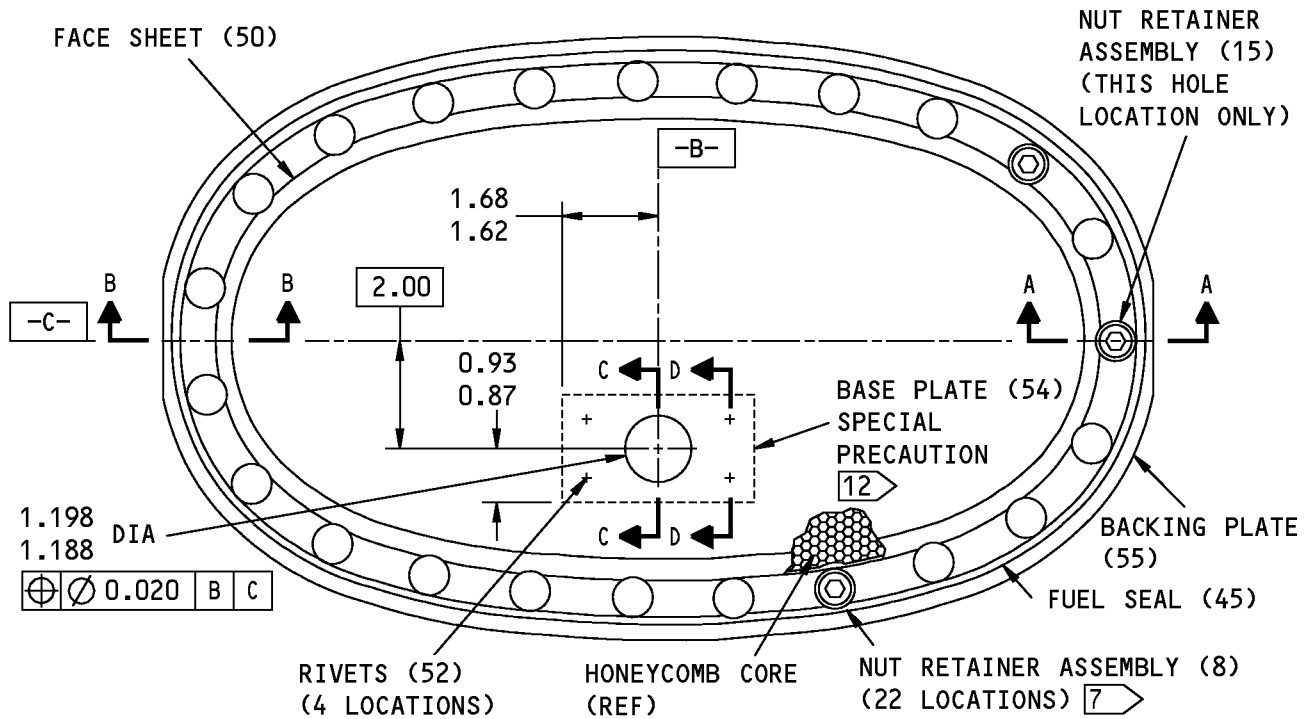


110U6012-1,-2; 110U6022-1,-2; 65C33147-3 Thru -10 10 x 18 Fuel Tank Access Door Repair
Figure 601 (Sheet 1 of 5)

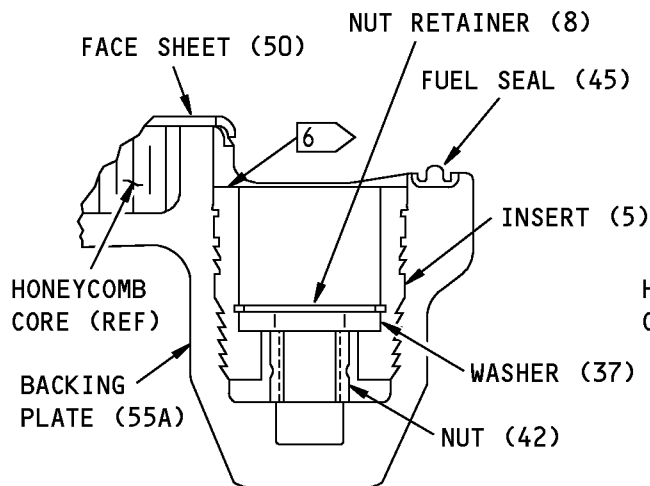
28-11-07

REPAIR 6-1
Page 603
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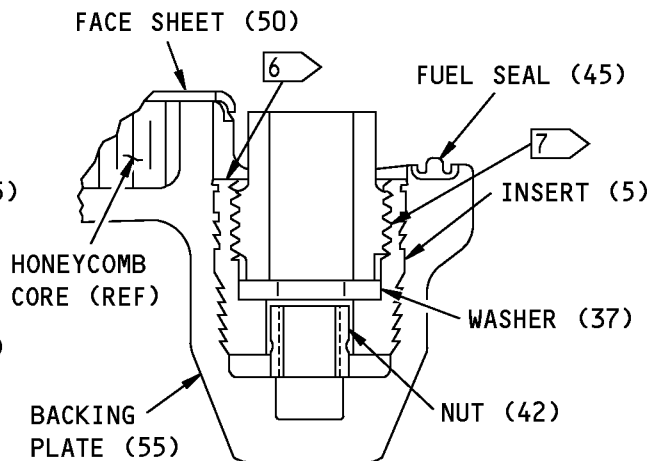
COMPONENT MAINTENANCE MANUAL



65C33147-3,-5,-7,-9,-10



A-A
110U6012-1
110U6022-1



A-A
65C33147-3 THRU -6

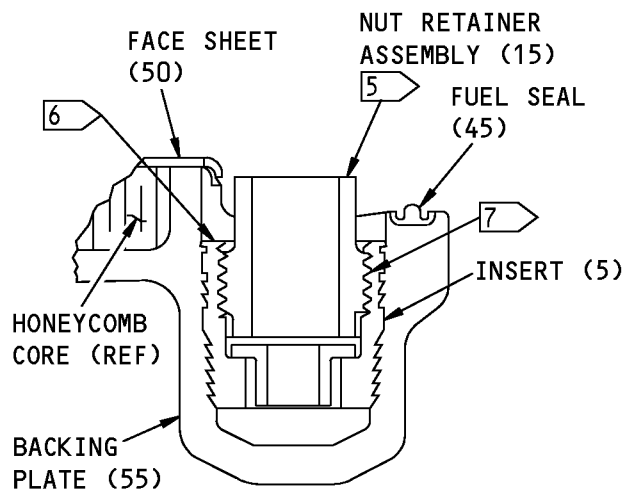
110U6012-1,-2; 110U6022-1,-2; 65C33147-3 Thru -10 10 x 18 Fuel Tank Access Door Repair
Figure 601 (Sheet 2 of 5)

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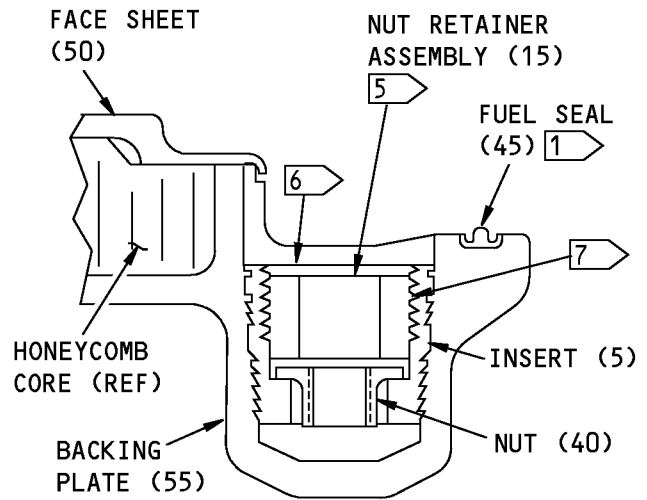
REPAIR 6-1
Page 604
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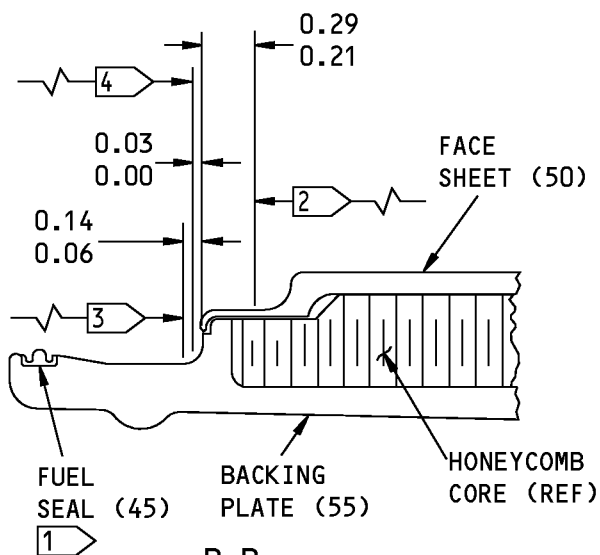
COMPONENT MAINTENANCE MANUAL



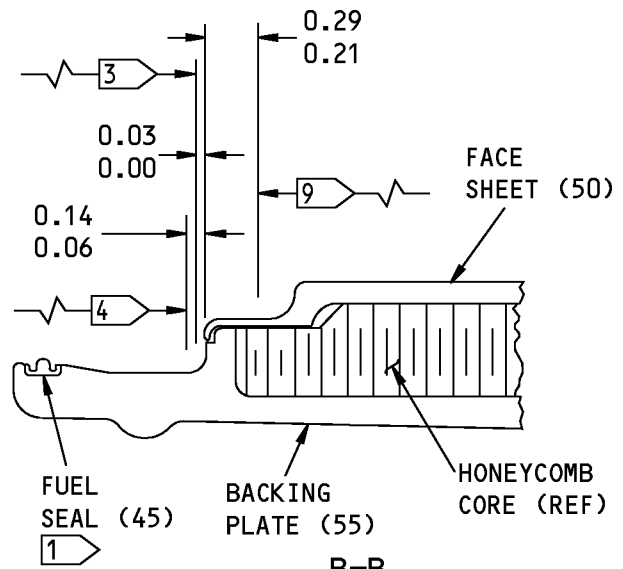
A-A
65C33147-7 THRU -10



A-A
110U6012-2
110U6022-2



B-B
65C33147-4,-6,-8



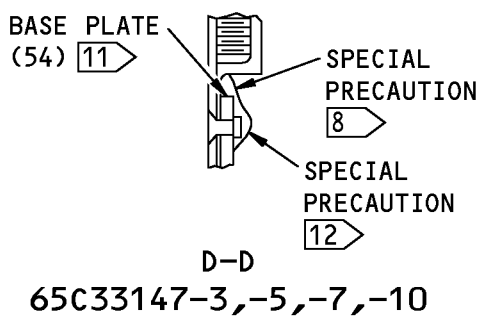
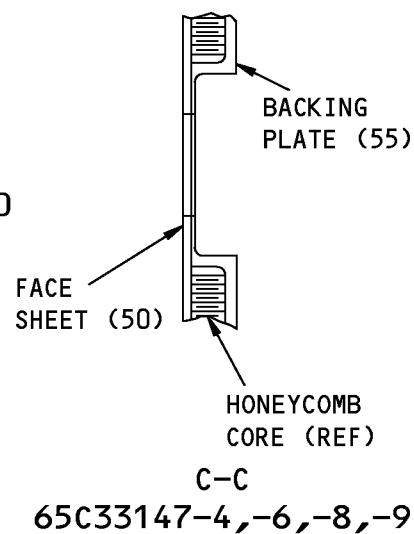
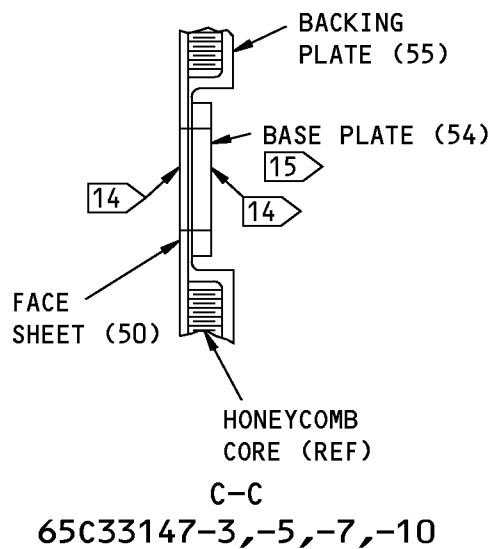
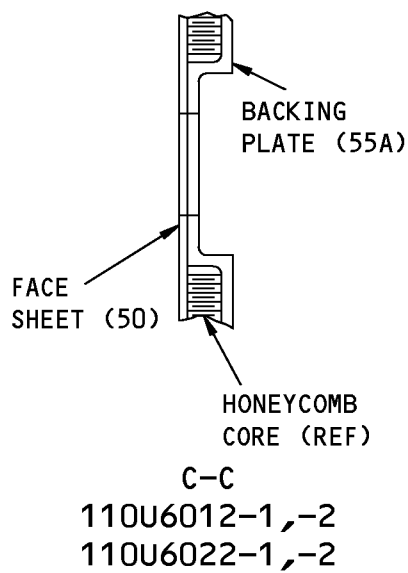
B-B
110U6012-1,-2
110U6022-1,-2
65C33147-3,-5,-7,-9,-10

110U6012-1,-2; 110U6022-1,-2; 65C33147-3 Thru -10 10 x 18 Fuel Tank Access Door Repair
Figure 601 (Sheet 3 of 5)

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110U6012-1,-2; 110U6022-1,-2; 65C33147-3 Thru -10 10 x 18 Fuel Tank Access Door Repair
Figure 601 (Sheet 4 of 5)

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- 1 BOND THE FUEL SEAL (30) WITH BMS 5-45, CLASS A.
 - 2 APPLY ONE LAYER BMS 10-79 TYPE 3, PRIMER (F-19.47).
 - 3 APPLY A LAYER OF BMS 10-21 TYPE 3 (SRF-14.685).
 - 4 APPLY ONE LAYER OF BMS 10-20 TYPE 2 (F-19.22).
 - 5 CAUTION: DO NOT APPLY ADDITIONAL TORQUE TO THE NUT RETAINER ASSEMBLY ONCE THE BOTTOM OF THE NUT RETAINER ASSEMBLY TOUCHES THE LAND AREA OF THE INSERT. ADDITIONAL TORQUE COULD DAMAGE THE INSERT.
 - 6 THE INSERTS MUST BE ALIGNED AND SMOOTH WITH BACKING PLATE, SPOTFACE TO WITHIN 0.000-0.020 INCHES.
 - 7 APPLY ONE LAYER OF BMS 10-20 TYPE 2 (F-19.22) ON THE INNER WALL OF THE INSERT TO A MINIMUM DEPTH OF 0.125 INCHES AS MEASURED FROM THE TOP OF THE INSERT.
 - 8 CONTINUOUS FUEL FILLET SEAL AS SHOWN IN BAC5504.
 - 9 APPLY BMS 10-79, TYPE 3 PRIMER (F-19.47) AND APPLY BMS 10-60 ENAMEL (F-19.39-707) TO THE UPPER SURFACE ONLY.
 - 10 THE MAXIMUM RESISTANCE PERMITTED BETWEEN THE BASE PLATE (54) AND THE FACE SHEET (50) AFTER ASSEMBLY IS 0.0005 OHMS
 - 11 USE BMS 5-45 SEALANT FAYING SURFACE SEAL AS SHOWN IN BAC5504. BEFORE YOU INSTALL THE RIVET (52), REMOVE ANY EXCESS SEALANT FROM COUNTERSINK LOCATIONS, FASTENER HOLE LOCATIONS AND SPECIAL PREPARED SURFACES OF THE BASE PLATE (54) (4 LOCATIONS)
 - 12 APPLY BMS 5-45 SEALANT TO INCLUDE THE UPSET HEAD OF THE RIVETS (52) AS SHOWN IN BAC5504
- ITEM NUMBERS REFER TO IPL FIG. 9
ALL DIMENSIONS ARE IN INCHES

110U6012-1,-2; 110U6022-1,-2; 65C33147-3 Thru -10 10 x 18 Fuel Tank Access Door Repair
Figure 601 (Sheet 5 of 5)

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COMPONENT MAINTENANCE MANUAL

FUEL TANK ACCESS DOOR ASSEMBLY - REPAIR 7-1

112W8201-1

1. General

- A. This section has the necessary data to replace the fuel seal (40).
- B. Refer to Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the standard true position dimensioning symbols shown in the repair.
- D. Refer to IPL Figure 11 for the item numbers.

2. Fuel Seal Replacement

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A01036	Adhesive - Structural Adhesive For Acoustic Panels - 350 F (177 C) Service (Film Adhesive)	BMS5-137, Type I
A01037	Adhesive - Structural Adhesive For Acoustic Panels - 350 F (177 C) Service (Film Adhesive)	BMS5-137, Type II
A50153	Sealant - Fuel Tank - Class A-2	BMS5-45 Class A-2
C00175	Primer - Urethane Compatible, Corrosion Resistant (Less Than 1% Aromatic Amines)	BMS10-79, Type III
C00307	Coating - Corrosion Resistant Finish For Integral Fuel Tanks	BMS10-20, Type II
D00020	Grease - Aircraft Oscillating Bearing	MIL-G-25537 (NATO G-365)

- B. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-50-12	APPLICATION OF ADHESIVES
SOPM 20-60-02	FINISHING MATERIALS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

- C. Procedure (REPAIR 7-1, Figure 601)

NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02. For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Install the fuel seal (40):
 - (a) Fully clean the fuel seal (40) before you install it on the door casting.

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REPAIR 7-1

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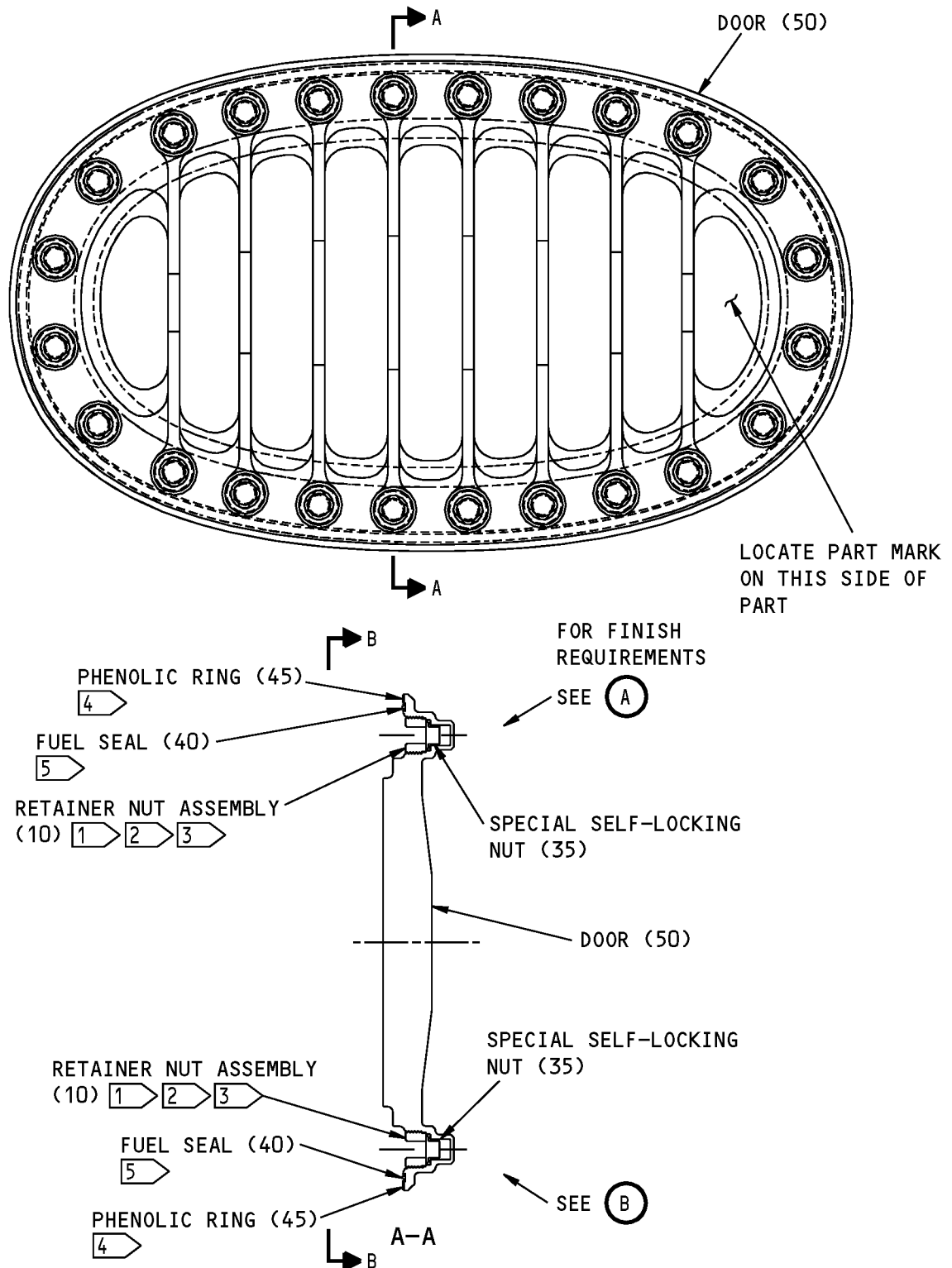
- 1) Refer to the flag note 5, steps (1) thru (5) in REPAIR 7-1, Figure 601.
- (b) Apply sealant, A50153 to the full width of the groove of fuel seal (45):
 - 1) Use sealant, A50153 to bond the fuel seal (45) to the door casting as shown in SOPM 20-50-12.
 - a) Refer to the flag note 5, step (6) in REPAIR 7-1, Figure 601.
- (2) Install the nut retainer assemblies (10, 15) on the nuts (35):
 - (a) Make sure the bottom of the nut retainer assemblies (10, 15) touches the land area of the nuts (35).
 - 1) Apply a thin layer of grease, D00020 to the threads of nut assembly (10) before installation as stated in flag note 3.
 - 2) Refer to the flag note 1 in REPAIR 7-1, Figure 601.
- (3) Install the phenolic ring (45):
 - (a) Refer to flag note 4, steps (1) thru (5) in REPAIR 7-1, Figure 601.
 - 1) Use adhesive, A01036 during step 4.
 - 2) Use adhesive, A01037 during step 5.
 - (b) Trim the phenolic ring (45) if it is necessary as shown in flag note 6.
 - (c) Do not apply finish to the phenolic ring (45) as shown in flag note 7.
- (4) Chemical treat (F-17.15) the area shown.
 - (a) Refer to the flag note 11 in REPAIR 7-1, Figure 601.
- (5) Chemical treat (F-17.15) and apply coating, C00307 (F-19.22) to the area shown.
 - (a) Refer to the flag note 10 in REPAIR 7-1, Figure 601.
- (6) Chemical treat (F-17.15) and apply primer, C00175 (F-19.47) to the area shown.
 - (a) Refer to the flag notes 8 and 12 in REPAIR 7-1, Figure 601.

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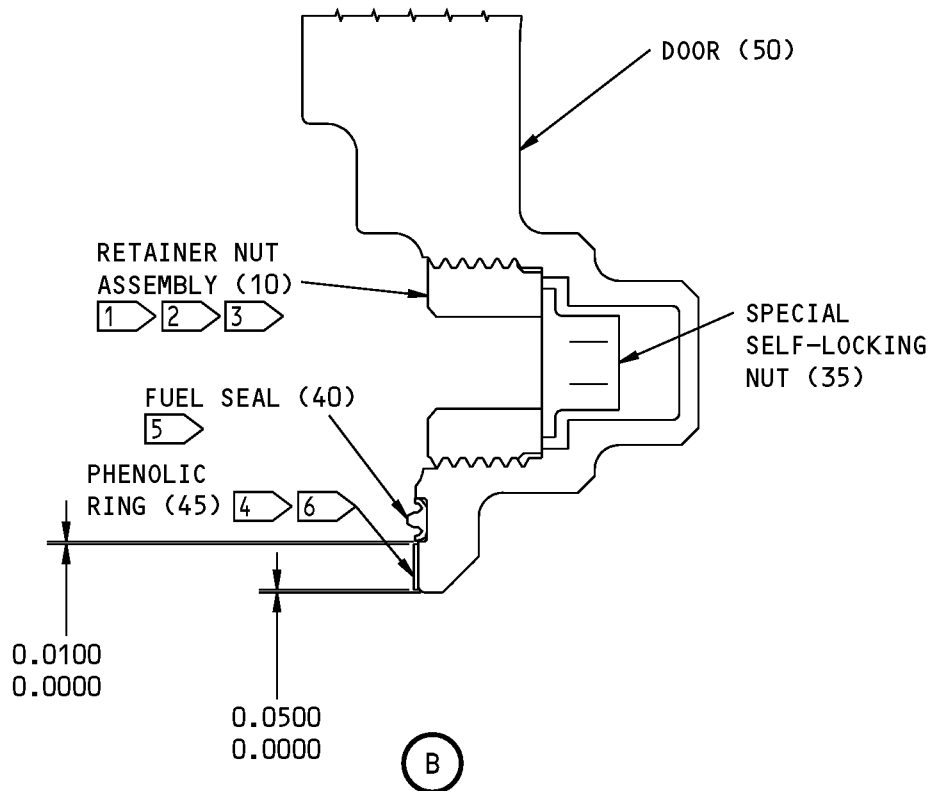
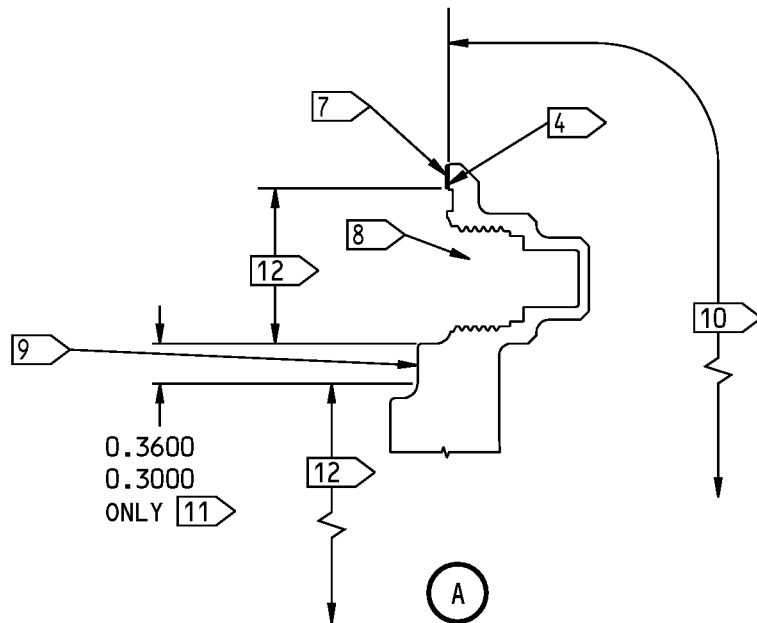
112W8201-1 10 X 18 Impact Resistant Fuel Tank Access Door Repair
Figure 601 (Sheet 1 of 5)

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REPAIR 7-1
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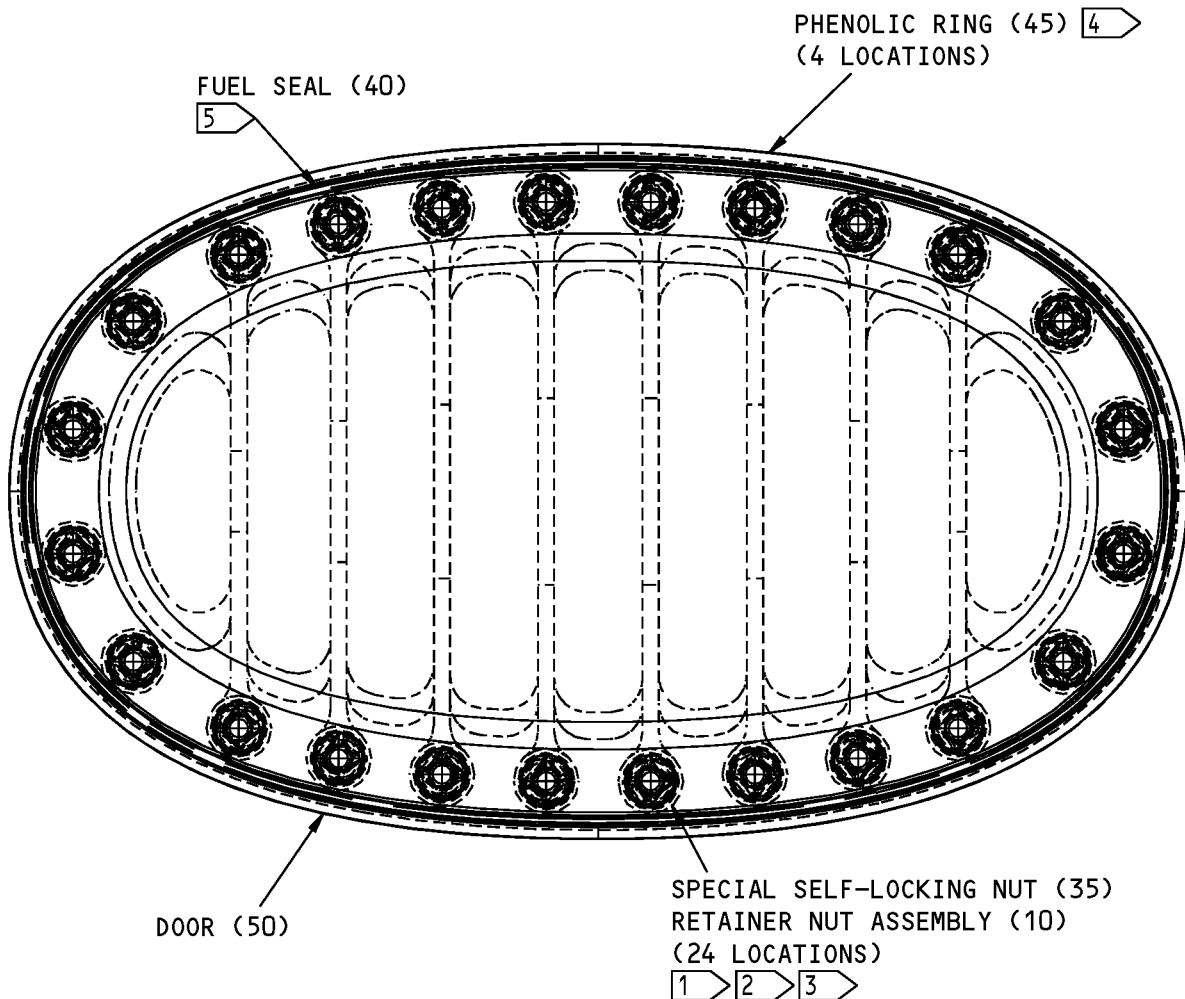
112W8201-1 10 X 18 Impact Resistant Fuel Tank Access Door Repair
Figure 601 (Sheet 2 of 5)

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B-B

1 CAUTION: DO NOT APPLY ADDITIONAL TORQUE TO THE NUT RETAINER ASSEMBLY ONCE THE BOTTOM OF THE NUT RETAINER ASSEMBLY TOUCHES THE LAND AREA OF THE INSERT

2 ALL FINISHES APPLY BEFORE YOU INSTALL THE NUT RETAINERS AND NUTS

3 APPLY A THIN LAYER OF MIL-G-25537 GREASE TO THE THREADS OF THE NUT ASSEMBLY (10) BEFORE INSTALLATION

125 ✓ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

ITEM NUMBERS REFER TO IPL FIG. 11

ALL DIMENSIONS ARE IN INCHES

112W8201-1 10 X 18 Impact Resistant Fuel Tank Access Door Repair
Figure 601 (Sheet 3 of 5)

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- 4 DO NOT APPLY FINISH TO THE DOOR BEFORE YOU DO THE PHENOLIC BONDING PROCEDURES THAT FOLLOW:
- (1) SCRATCH THE MATING SURFACES OF THE DOOR AND THE PHENOLIC RING AS SHOWN IN SOPM 20-30-03 TYPE 2, CLASS 5 WITH SCOTCH-BRITE OR 180-400 GRIT ALUMINUM OXIDE SAND PAPER.
 - (2) SOLVENT CLEAN THE MATING SURFACE AS SHOWN IN SOPM 20-30-03.
 - (3) MAKE SURE THAT THE MATING SURFACES ARE CLEAN AND DRY BEFORE YOU APPLY PRIMER
 - (4) APPLY AND CURE BMS 5-137 TYPE 1, CLASS 2 OR 3 PRIMER (F-20.47) TO THE ALUMINUM MATING SURFACE.
 - (5) APPLY ONE LAYER OF BMS 5-137 TYPE 2, CLASS 1 GRADE 10 OR 15 FILM ADHESIVE TO ONE OF THE MATING SURFACES. LET THE ADHESIVE DRY FOR A MINIMUM OF 90 MINUTES AT 340-360°F, THE RATE OF TEMPERATURE INCREASE MUST BE BETWEEN 1.5 AND 10°F FOR EACH MINUTE TO 300°F AND 0.5 TO 10°F FOR EACH MINUTE FROM 300°F FOR THE ADHESIVE TO DRY. THE BONDING PRESSURE MUST BE 15-25 PSI. YOU CAN USE A VACUUM BAG OR BONDING FIXTURE TO DRY THE ADHESIVE. VOIDS OR UNFILLED AREAS IN THE EDGE OF THE PHENOLIC RING ARE PERMITTED. LOOSE EDGES OR DISCONNECTED AREAS IN THE EDGE OF THE ADHESIVE MUST NOT BE MORE THAN 0.20 INCHES. IF YOU USE MANY PIECES OF PHENOLIC RING SEGMENTS, THE JOINT CLEARANCES BETWEEN THE SEGMENTS MUST NO BE MORE THAN 0.005 INCH.
- 5 ALL FINISHES APPLY BEFORE YOU INSTALL THE FUEL SEAL (40):
- (1) USE DENATURED ALCOHOL TO CLEAN THE SEAL GROOVE AS SHOWN IN SOPM 20-30-03 (MAKE SURE TO PREVENT THE CLEAN SEAL GROOVE FROM CONTAMINATION).
 - (2) INSTALL THE FUEL SEAL (40) TO THE SEAL GROOVE NOT MORE THAN ONE HOUR AFTER YOU SEAL THE GROOVE.
 - (3) DO STEP (1) AGAIN IF YOU INSTALL THE FUEL SEAL (40) TO THE SEAL GROOVE MORE THAN ONE HOUR.
 - (4) USE 180-400 GRIT ALUMINUM OXIDE SAND PAPER TO SCRATCH THE SURFACE OF THE FUEL SEAL (40) THAT TOUCHES THE BOTTOM SURFACE OF THE SEAL GROOVE.
 - (5) USE DENATURED ALCOHOL TO CLEAN THE FUEL SEAL (40) AS SHOWN IN SOPM 20-30-03 BEFORE YOU BOND THE FUEL SEAL (40) TO THE DOOR (50).
 - (6) APPLY BMS 5-45, CLASS A TO THE FUEL SEAL (40) MATING SURFACE AND BOND AS SHOWN IN SOPM 20-50-12 TYPE 44, EXCEPT USE BMS 5-45, CLASS A.
- ONLY USE DENATURED ALCOHOL FOR ALL CLEANING OPERATIONS
- CAUTION:** DO NOT PUT FORCE ON THE BOND LINE FOR A MINIMUM OF 72 HOURS AFTER YOU BOND THE FUEL SEAL (40)
- 6 TRIM IF NECESSARY
- 7 DO NOT APPLY FINISH ON THE SURFACE OF THE PHENOLIC RING (45)
- 8 IT IS NOT NECESSARY TO APPLY PRIMER IN THE RECESS. OVERSPRAY IS PERMITTED
- 9 DO NOT APPLY PRIMER ON THE AREA SHOWN DUE TO ELECTRICAL BONDING REQUIRMENTS
- 10 CHEMICAL TREAT (F-17.15) AND APPLY BMS 10-20 COATING (F-19.22) TO THE AREA SHOWN
- 11 CHEMICAL TREAT (F-17.15) ONLY

112W8201-1 10 X 18 Impact Resistant Fuel Tank Access Door Repair
Figure 601 (Sheet 4 of 5)

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REPAIR 7-1
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12 CHEMICAL TREAT (F-17.15) AND APPLY BMS 10-79, TYPE 3 PRIMER (F-19.47)

112W8201-1 10 X 18 Impact Resistant Fuel Tank Access Door Repair
Figure 601 (Sheet 5 of 5)

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REPAIR 7-1

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FUEL TANK ACCESS DOOR ASSEMBLY - REPAIR 8-1

112W8202-1

1. General

- A. This section has the necessary data to replace the fuel seal (40).
- B. Refer to Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the standard true position dimensioning symbols shown in the repair.
- D. Refer to IPL Figure 11 for the item numbers.

2. Fuel Seal Replacement

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A01036	Adhesive - Structural Adhesive For Acoustic Panels - 350 F (177 C) Service (Film Adhesive)	BMS5-137, Type I
A01037	Adhesive - Structural Adhesive For Acoustic Panels - 350 F (177 C) Service (Film Adhesive)	BMS5-137, Type II
A50153	Sealant - Fuel Tank - Class A-2	BMS5-45 Class A-2
C00175	Primer - Urethane Compatible, Corrosion Resistant (Less Than 1% Aromatic Amines)	BMS10-79, Type III
C00307	Coating - Corrosion Resistant Finish For Integral Fuel Tanks	BMS10-20, Type II
D00020	Grease - Aircraft Oscillating Bearing	MIL-G-25537 (NATO G-365)

- B. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-50-12	APPLICATION OF ADHESIVES
SOPM 20-60-02	FINISHING MATERIALS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

- C. Procedure (REPAIR 8-1, Figure 601)

NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02. For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Install the fuel seal (40):
 - (a) Fully clean the fuel seal (40) before you install it on the door casting.

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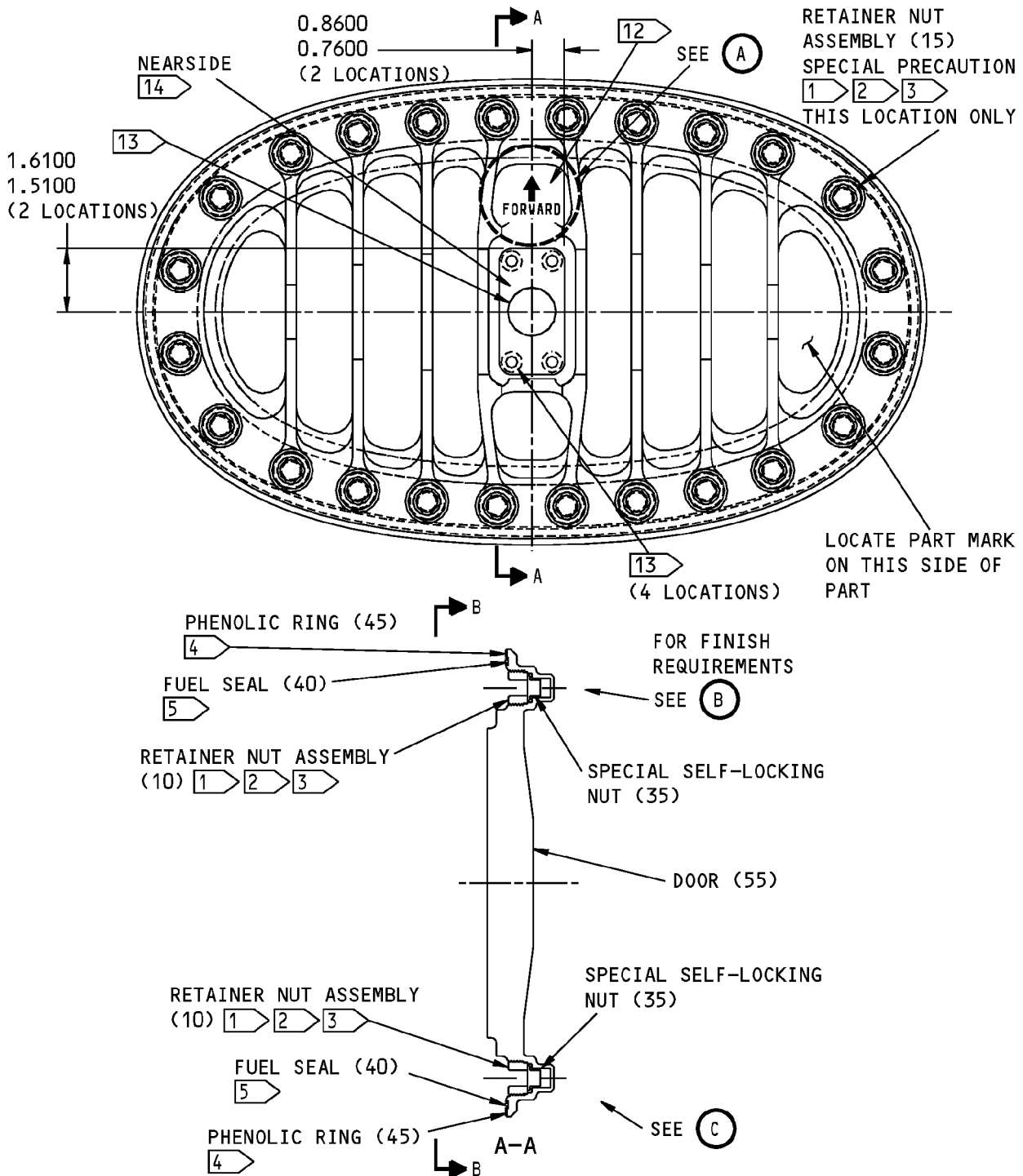
- 1) Refer to the flag note 5, steps (1) thru (5) in REPAIR 8-1, Figure 601.
- (b) Apply sealant, A50153 to the full width of the groove of fuel seal (45):
 - 1) Use sealant, A50153 to bond the fuel seal (45) to the door casting as shown in SOPM 20-50-12.
 - a) Refer to the flag note 5, step (6) in REPAIR 8-1, Figure 601.
- (2) Install the nut retainer assemblies (10, 15) on the nuts (35):
 - (a) Make sure the bottom of the nut retainer assemblies (10, 15) touches the land area of the nuts (35).
 - 1) Apply a thin layer of grease, D00020 to the threads of nut assembly (10) before installation as stated in flag note 3.
 - 2) Refer to the flag note 1 in REPAIR 8-1, Figure 601.
- (3) Install the phenolic ring (45):
 - (a) Refer to flag note 4, steps (1) thru (5) in REPAIR 8-1, Figure 601.
 - 1) Use adhesive, A01036 during step 4.
 - 2) Use adhesive, A01037 during step 5.
 - (b) Trim the phenolic ring (45) if it is necessary as shown in flag note 6.
 - (c) Do not apply finish to the phenolic ring (45) as shown in flag note 7.
- (4) Chemical treat (F-17.15) the area shown.
 - (a) Refer to the flag note 11 in REPAIR 8-1, Figure 601.
- (5) Chemical treat (F-17.15) and apply coating, C00307 (F-19.22) to the area shown.
 - (a) Refer to the flag note 10 in REPAIR 8-1, Figure 601.
- (6) Chemical treat (F-17.15) and apply primer, C00175 (F-19.47) to the area shown.
 - (a) Refer to the flag notes 8 and 15 in REPAIR 8-1, Figure 601.

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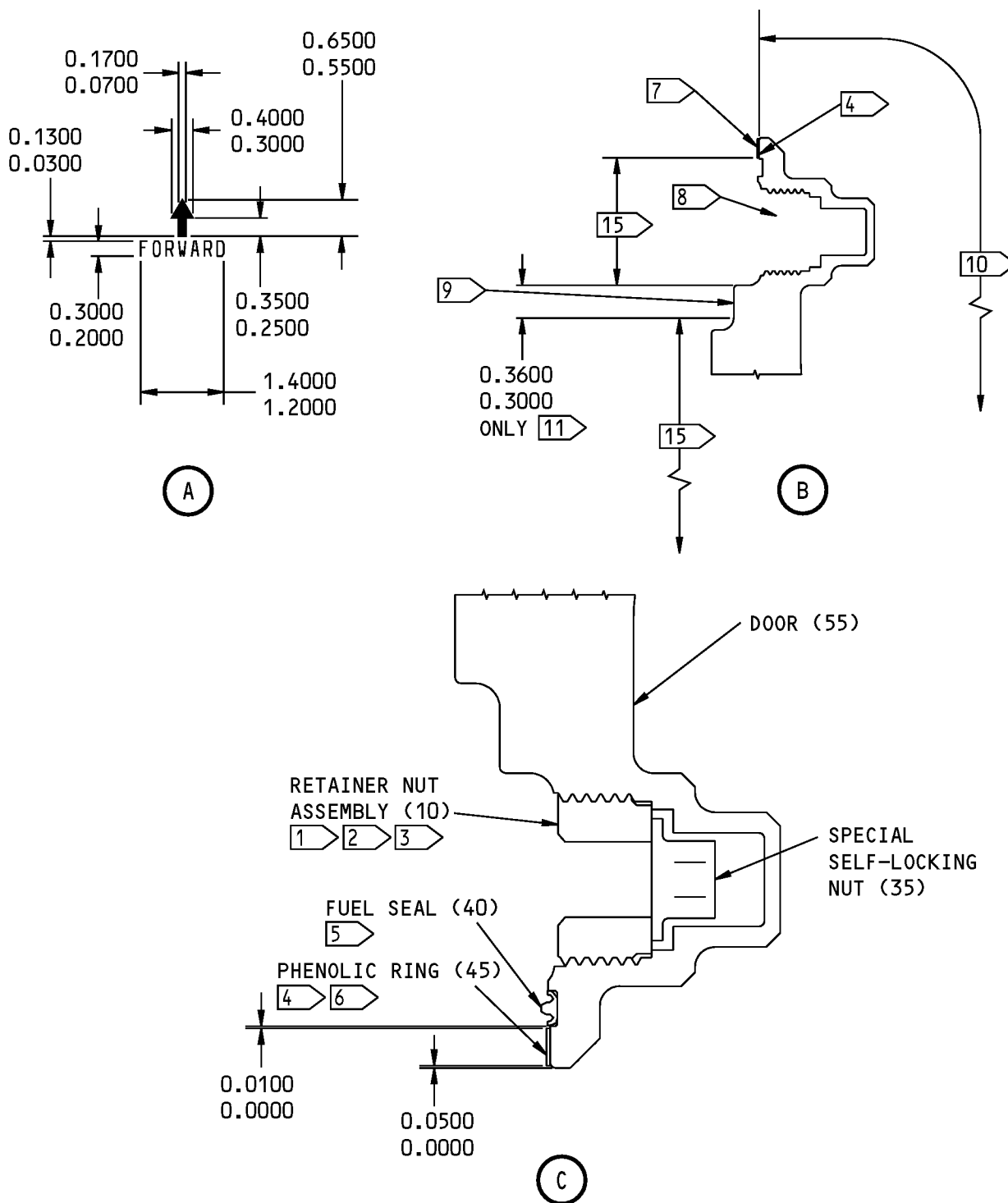


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Figure 601 (Sheet 1 of 5)

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112W8202-1 10 X 18 Measuring Stick Impact Resistant Fuel Tank Access Door Repair
Figure 601 (Sheet 2 of 5)

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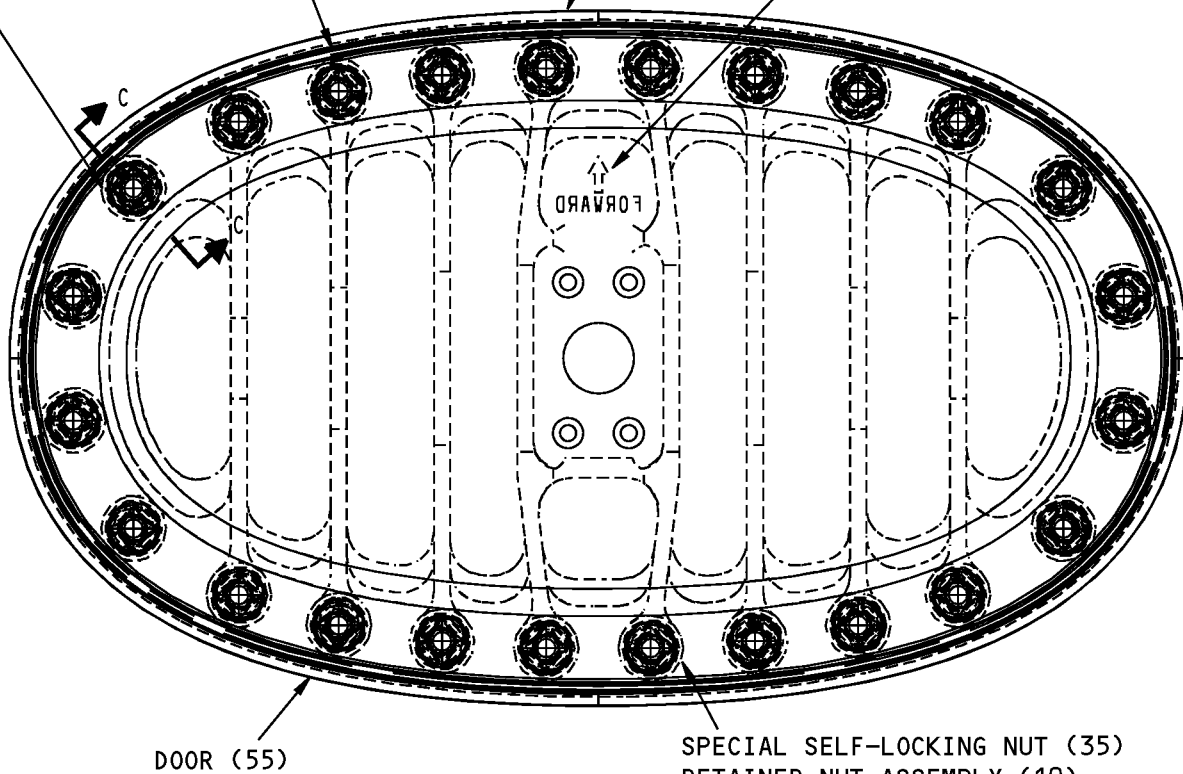
RETAINER NUT ASSEMBLY (10)
SPECIAL SELF-LOCKING NUT (35)
SPECIAL PRECAUTION

1 2 3
THIS LOCATION ONLY

FUEL SEAL (40)
5

PHENOLIC RING (45) 4
(4 LOCATIONS)

TEXT AND ARROW
ARE ON FAR SIDE
OF PART (REF)

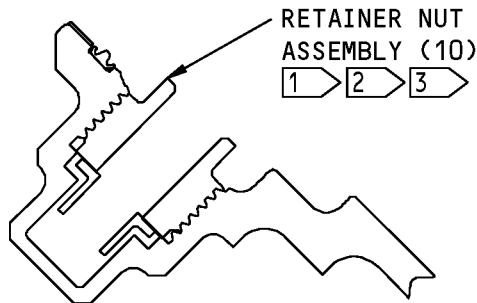


DOOR (55)

SPECIAL SELF-LOCKING NUT (35)
RETAINER NUT ASSEMBLY (10)
(23 LOCATIONS)

B-B

1 2 3



C-C

112W8202-1 10 X 18 Measuring Stick Impact Resistant Fuel Tank Access Door Repair
Figure 601 (Sheet 3 of 5)

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- 1 **CAUTION:** DO NOT APPLY ADDITIONAL TORQUE TO THE NUT RETAINER ASSEMBLY ONCE THE BOTTOM OF THE NUT RETAINER ASSEMBLY TOUCHES THE LAND AREA OF THE INSERT
- 2 ALL FINISHES APPLY BEFORE YOU INSTALL THE NUT RETAINERS AND NUTS
- 3 APPLY A THIN LAYER OF MIL-G-25537 GREASE TO THE THREADS OF THE NUT ASSEMBLY (10) BEFORE INSTALLATION
- 4 DO NOT APPLY FINISH TO THE DOOR BEFORE YOU DO THE PHENOLIC BONDING PROCEDURES THAT FOLLOW:
- (1) SCRATCH THE MATING SURFACES OF THE DOOR AND THE PHENOLIC RING AS SHOWN IN SOPM 20-30-03 TYPE 2, CLASS 5 WITH SCOTCH-BRITE OR 180-400 GRIT ALUMINUM OXIDE SAND PAPER.
 - (2) SOLVENT CLEAN THE MATING SURFACE AS SHOWN IN SOPM 20-30-03.
 - (3) MAKE SURE THAT THE MATING SURFACES ARE CLEAN AND DRY BEFORE YOU APPLY PRIMER
 - (4) APPLY AND CURE BMS 5-137 TYPE 1, CLASS 2 OR 3 PRIMER (F-20.47) TO THE ALUMINUM MATING SURFACE.
 - (5) APPLY ONE LAYER OF BMS 5-137 TYPE 2, CLASS 1 GRADE 10 OR 15 FILM ADHESIVE TO ONE OF THE MATING SURFACES. LET THE ADHESIVE DRY FOR A MINIMUM OF 90 MINUTES AT 340-360°F, THE RATE OF TEMPERATURE INCREASE MUST BE BETWEEN 1.5 AND 10°F FOR EACH MINUTE TO 300°F AND 0.5 TO 10°F FOR EACH MINUTE FROM 300°F FOR THE ADHESIVE TO DRY. THE BONDING PRESSURE MUST BE 15-25 PSI. YOU CAN USE A VACUUM BAG OR BONDING FIXTURE TO DRY THE ADHESIVE. VOIDS OR UNFILLED AREAS IN THE EDGE OF THE PHENOLIC RING ARE PERMITTED. LOOSE EDGES OR DISCONNECTED AREAS IN THE EDGE OF THE ADHESIVE MUST NOT BE MORE THAN 0.20 INCHES. IF YOU USE MANY PIECES OF PHENOLIC RING SEGMENTS, THE JOINT CLEARANCES BETWEEN THE SEGMENTS MUST NO BE MORE THAN 0.005 INCH.

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Figure 601 (Sheet 4 of 5)

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- 5 > ALL FINISHES APPLY BEFORE YOU INSTALL THE FUEL SEAL (40):
- (1) USE DENATURED ALCOHOL TO CLEAN THE SEAL GROOVE AS SHOWN IN SOPM 20-30-03 (MAKE SURE TO PREVENT THE CLEAN SEAL GROOVE FROM CONTAMINATION).
 - (2) INSTALL THE FUEL SEAL (40) TO THE SEAL GROOVE NOT MORE THAN ONE HOUR AFTER YOU SEAL THE GROOVE.
 - (3) DO STEP (1) AGAIN IF YOU INSTALL THE FUEL SEAL (40) TO THE SEAL GROOVE MORE THAN ONE HOUR.
 - (4) USE 180-400 GRIT ALUMINUM OXIDE SAND PAPER TO SCRATCH THE SURFACE OF THE FUEL SEAL (40) THAT TOUCHES THE BOTTOM SURFACE OF THE SEAL GROOVE.
 - (5) USE DENATURED ALCOHOL TO CLEAN THE FUEL SEAL (40) AS SHOWN IN SOPM 20-30-03 BEFORE YOU BOND THE FUEL SEAL (40) TO THE DOOR (50).
 - (6) APPLY BMS 5-45, CLASS A TO THE FUEL SEAL (40) MATING SURFACE AND BOND AS SHOWN IN SOPM 20-50-12 TYPE 44, EXCEPT USE BMS 5-45, CLASS A.
- ONLY USE DENATURED ALCOHOL FOR ALL CLEANING OPERATIONS
- CAUTION: DO NOT PUT FORCE ON THE BOND LINE FOR A MINIMUM OF 72 HOURS AFTER YOU BOND THE FUEL SEAL (40)
- 6 > TRIM IF NECESSARY
- 7 > DO NOT APPLY FINISH ON THE SURFACE OF THE PHENOLIC RING (45)
- 8 > IT IS NOT NECESSARY TO APPLY PRIMER IN THE RECESS. OVERSPRAY IS PERMITTED
- 9 > DO NOT APPLY PRIMER ON THE AREA SHOWN DUE TO ELECTRICAL BONDING REQUIRMENTS
- 10 > CHEMICAL TREAT (F-15.15) AND APPLY BMS 10-20 COATING (F-19.22) TO THE AREA SHOWN
- 11 > CHEMICAL TREAT (F-15.15) ONLY
- 12 > RUBBER STAMP THE ARROW AND TEXT AS SHOWN IN SOPM 20-50-10, CODE RF (SEE FIGURE 1)
- 13 > CHEMICAL TREAT (F-15.15) IS PERMITTED ON THE INNER SURFACE OF THE HOLE. ALL OTHER FINISHES ARE NOT PERMITTED
- 14 > DO NOT APPLY PRIMER ON THE AREA SHOWN
- 15 > CHEMICAL TREAT (F-15.15) AND APPLY BMS 10-79, TYPE 3 PRIMER (F-19.47)

125/ ✓ ALL MACHINED SURFACES UNLESS
SHOWN DIFFERENTLY

ITEM NUMBERS REFER TO IPL FIG. 11

ALL DIMENSIONS ARE IN INCHES

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Figure 601 (Sheet 5 of 5)

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REPAIR 8-1

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SEE TITLE PAGE FOR
LIST OF PART NUMBERS



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ASSEMBLY

(NOT APPLICABLE)

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ASSEMBLY

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SEE TITLE PAGE FOR
LIST OF PART NUMBERS



COMPONENT MAINTENANCE MANUAL

FITS AND CLEARANCES

(NOT APPLICABLE)

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FITS AND CLEARANCES

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SEE TITLE PAGE FOR
LIST OF PART NUMBERS



COMPONENT MAINTENANCE MANUAL

SPECIAL TOOLS, FIXTURES, AND EQUIPMENT

(NOT APPLICABLE)

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SPECIAL TOOLS, FIXTURES, AND EQUIPMENT

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COMPONENT MAINTENANCE MANUAL

ILLUSTRATED PARTS LIST

1. Introduction

- A. The Illustrated Parts List (IPL) contains an illustration and a list of component parts you can repair or replace. The Illustrated Parts Catalog (IPC) shows how to use the Boeing part number system.
- B. This shows how parts are related: The relation of each item to its next higher assembly (NHA) is shown in the NOMENCLATURE column. Use the indenture system that follows:

1	2	3	4	5	6	7
.	Assembly					
.	Attaching parts for assembly					
.	.	Detail parts for assembly				
.	.	Subassembly				
.	.	Attaching parts for subassembly				
.	.	.	Detail parts for subassembly			
.	.	.	Sub-subassembly			
.	.	.	Attaching parts for subassembly			
.	.	.	.	Details parts for sub-subassembly		

Detail Installation Parts (Included only if installation parts may be sent to the shop as part of assembly)

- C. Each top assembly is given one use code letter (A, B, C, etc.) in the USAGE CODE column. All subsequent component parts in the list can have one or more of the use code letters to show effectivity to top assemblies. A component part without a use code applies to all top assemblies.
- D. An alphabetical letter is added after the item number for optional parts, parts changed by a Service Bulletin, configuration differences (except left-handed and right-handed parts), last engineering releases, and parts added between item numbers in a sequence. The alphabetical letter will not be shown on the illustration for equivalent parts of the same part number.
- E. Color-coded parts are identified with a single digit alpha following the dash number or with "SP" suffix. If the "SP" suffix is used, it represents consolidation of all color codes applicable for a given usage which are not separately listed. Orders for color-coded parts should include the registry number of the airplane for which the parts are ordered.
- F. If a part number is 15 characters long but will not fit in the part number column, the part number will be displayed with a "~" at the end of the line and will be continued on the next line. The "~" denotes that the part number continues on the next line.
- G. Parts changed by a Service Bulletin are shown by PRE SB XXXX and POST SB XXXX added to the NOMENCLATURE column.
 - (1) When a new top assembly is added by a Service Bulletin, PRE SB XXXX and POST SB XXXX will be added at the top assembly level only. The configuration differences at the detail part level are shown by use code letters.
 - (2) When the top assembly part number is not changed by the Service Bulletin, PRE SB XXXX and POST SB XXXX will be added at the detail level.
- H. Interchangeable Parts

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Optional (OPT)	The part is optional to and interchangeable with other parts that have the same item number.
Replaces, Replaced by and not interchangeable with (REPLACES, REPLACED BY AND NOT INTCHG/W)	The part replaces and is not interchangeable with the initial part.
Replaces, Replaced by (REPLACES, REPLACED BY)	The part replaces and is interchangeable with, or is an alternative to, the initial part.

VENDOR CODES

Code	Name
00779	TYCO ELECTRONICS CORP 2800 FULLING MILL ROAD PO BOX 3608 MIDDLETOWN, PENNSYLVANIA 17057 FORMERLY AMP INC; FORMERLY V04618 FORMERLY GENICOM COMP V01526
03038	LONG-LOK FASTENER CORP 13709 S NORMANDIE AVE GARDENA, CALIFORNIA 90249-2609 FORMERLY TEKLON IN LOS ANGELES CALIFORNIA V07358 FORMERLY WHITTAKER CORP PREC FASTRS V05799
11815	CHERRY AEROSPACE FASTENERS DIV OF TEXTRON 1224 EAST WARNER AVENUE PO BOX 2157 SANTA ANA, CALIFORNIA 92707-0157 FORMERLY IN LOS ANGELES, CALIF , FORMERLY CHERRY FASTENERS TOWNSEND DIV OF TEXTRON INC V71087
15653	ALCOA GLOBAL FASTENERS INC DIV KAYNAR PRODUCTS 800 S STATE COLLEGE BLVD FULLERTON, CALIFORNIA 92831-3001 FORMERLY VK6405 MICRODOT AEROSP LTD; FORMERLY KAYNAR TECH FORMERLY FAIRCHILD FASTENERS KAYNAR DIV
1FF12	CIRCUIT SYSTEMS CO 2621 COLORADO CIR PO BOX 171322 ARLINGTON, TEXAS 76017
1GK47	R AND B ELECTRONICS INC 2374 NW DALLAS STREET GRAND PRAIRIE, TEXAS 75050

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COMPONENT MAINTENANCE MANUAL

Code	Name
33483	TJ ELECTRONICS DIV OF TRANSTECHNOLOGY CORP 611 109TH STREET ARLINGTON, TEXAS 76005 FORMERLY TJ ELECTRONICS
52828	REPUBLIC FASTENER MFG CORP 1300 RANCHO CONEJO BLVD NEWBURY PARK, CALIFORNIA 91320-1405 FORMERLY IN SYLMAR, CALIFORNIA
62554	SIMMONDS MECAERO FASTENERS INC 1734 SEQUOIA AVENUE ORANGE, CALIFORNIA 92668
72962	HARVARD INDUSTRIES INC 3 WERNER WAY SUITE 210 LEBANON, NEW JERSEY 08833 FORMERLY ESNA V7A079 FORMERLY ELASTIC STOP NUT IN UNION, NJ
79550	MURPHY INDUSTRIES INC 2801 ROCKCREEK PARKWAY PO BOX 7499 NORTH KANSAS CITY, MISSOURI 64116 FORMERLY WHITAKER CABLE CORPORATION
80539	SPS TECHNOLOGIES INC DIV AERPSOACE - SANTA ANA 2701 SOUTH HARBOR BOULEVARD SANTA ANA, CALIFORNIA 92704-5803 FORMERLY NUTT-SHEL DIV OF SPC WESTERN CO V80539 AND STANDARD PRESSED STEEL WESTERN DIV V17279
83533	ESSEX IND INC ESSEX MFG. DIV 6 SUNNEN DR SAINT LOUIS, MISSOURI 63143-3903 FORMERLY FILM-SOL CORP V27340 FORMERLY ESSEX CRYOGENICS IND INC
86831	KAISER ELECTRO PRECISION AEROSPACE AND ELECTRONIC CO 17000 SOUTH RED HILL AVENUE IRVINE, CALIFORNIA 92714-5626 FORMERLY RUCKER PRECISION A DIV OF THE RUCKER CO SANTA ANA FORMERLY ROYLYN DIV OF THE RUCKER CO GLENDALE, CALIFORNIA

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COMPONENT MAINTENANCE MANUAL

Code	Name
91812	ESTERLINE MASON 13955 BALVOA ROAD SYLMAR, CALIFORNIA 91342 FORMERLY JANCO CORPORATION
92215	FAIRCHILD IND INC FAIRCHILD AEROSPACE FASTENER DIV 3010 W LOMITA BLVD TORRANCE, CALIFORNIA 90505-5102 FORMERLY VOI-SHAN IN CULVER CITY, CALIF
98403	AMERACE CORP CONTROL PRODUCTS DIV 1000 HICKORY STREET GRAFTON, WISCONSIN 53024-1128 FORMERLY AGASTAT DIV OF AMERACE ESNA CORP AND ELASTIC STOP NUT CORP V0217B AND CONTROL PRODUCTS AMERACE CORP AND ENERCON INC SUB OF AMERACE CORP

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NUMERICAL INDEX

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1		AR
		5		1
		9		1
		11		1
10-60522-60		9	54	1
1002AB9		4	40	1
102F9201-3		10	10	16
110U6009-2		1	70B	1
110U6010-2		7	40B	1
110U6011-1		1	26	RF
		5	1J	RF
110U6011-2		1	26A	RF
		5	1K	RF
110U6011-3		5	1N	RF
110U6012-1		1	31	RF
		9	1J	RF
110U6012-2		1	31A	RF
		9	1K	RF
110U6012-3		9	1N	RF
110U6013-1		5	40B	1
110U6013-3		5	40C	1
110U6014-1		9	55A	1
110U6014-3		9	55B	1
110U6021-1		1	27	RF
		5	1L	RF
110U6021-2		1	27A	RF
		5	1M	RF
110U6022-1		1	32	RF
		9	1L	RF
110U6022-2		1	32A	RF
		9	1M	RF
110U6023-2		5	40E	1
110U6024-2		9	55D	1
112N4508-1		5	22	23

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		9	37	23
112N6004-1		1	60	1
112N6004-10		8	40	1
112N6004-2		6	40	1
112N6004-5		7	30	1
112N6004-7		7	30A	1
112N6004-8		1	60A	1
112N6012-1		2	30	1
112N6013-1		2	35	1
112N6101-1		1	1A	RF
112N6101-10		1	1G	RF
		7	1B	RF
112N6101-11		1	1D	RF
		8	1A	RF
112N6101-2		1	1E	RF
112N6101-3		1	1B	RF
		6	1A	RF
112N6101-6		1	1C	RF
		7	1A	RF
112N6101-9		1	1F	RF
112N6102-1		1	5	RF
		2	1A	RF
112T4607-3		1	10	RF
		3	1A	RF
112T4607-4		3	15	1
112T4607-5		1	10A	RF
		10	1A	RF
112T4607-7		10	15	1
112T4607-9		10	20	1
112U6013-1		5	40D	1
112U6014-1		9	55C	1
112W8100-1		4	80	1
112W8100-2		4	85	1
112W8101-1		4	135	1
112W8101-2		4	140	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
112W8102-1		1	65	1
		4	130	1
		6	45	1
		7	35	1
		8	45	1
112W8102-3		1	67	4
		7	37	4
		11	45	4
112W8102-4		11	45A	4
112W8102-5		1	65A	1
		7	35A	1
112W8201-1		1	3	RF
		11	2	RF
112W8201-3		1	3B	RF
112W8202-1		1	3A	RF
		11	5	RF
112W8202-3		1	3C	RF
112W8210-1		11	50	1
112W8210-2		11	55	1
112W8213-1		11	10	23
		11	15	1
112W8213-2		11	15A	1
112W8213-3		11	20	1
		11	25	1
112W8213-4		11	30	1
112W8214-1		11	40	1
30356		4	40	1
342W2001-3		4	70	1
342W2001-4		4	75	1
342W2006-2		4	51	1
342W2108-1		4	45	1
342W2108-3		4	46	1
342W2108-5		4	47	1
342W2108-6		4	48	1
342W2108-7		4	52	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
342W2108-8		4	53	1
342W2801-10		1	20C	RF
		4	5C	RF
342W2801-3		1	15	RF
		4	1A	RF
342W2801-4		1	20	RF
		4	5	RF
342W2801-5		1	15A	RF
		4	1B	RF
342W2801-6		1	20A	RF
		4	5A	RF
342W2801-7		1	15B	RF
		4	1C	RF
342W2801-8		1	20B	RF
		4	5B	RF
342W2801-9		1	15C	RF
		4	1D	RF
4090-0034-60		9	54	1
63-8497		1	35	23
		2	5	21
		4	95	22
		5	10	23
		5	10A	23
		6	5	22
		7	5	23
		8	5	22
		9	8	23
		9	10	22
		9	10A	22
63-8497-1		1	45	1
		2	15	1
		4	110	1
		5	10B	23
		5	20	1
		6	20	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
63-8497-2		7	15	1
		8	20	1
		9	10B	22
		9	30	1
		9	32	1
		1	40	1
		2	10	1
		4	105	1
		5	15	1
		6	15	1
		7	10	1
		8	15	1
		9	20	1
		9	22	1
		9	25A	1
63-8497-3		4	100	1
		6	10	1
		8	10	1
		9	15B	22
63-8497-4		4	115	1
		6	25	1
		8	25	1
		9	35B	1
6301520500-1		4	55	1
6301520800-1		4	55	1
65-76139-3		2	40	1
65-76140-23		8	50	1
65-76140-24		1	70A	1
65-76140-25		7	40A	1
65-76140-3		1	70	1
65-76140-6		6	50	1
65C33092-2		7	40	1
		1	25A	RF
		5	1B	RF
65C33092-3		1	25B	RF

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
65C33092-4		5	1C	RF
		1	25C	RF
65C33092-5		5	1D	RF
		1	25D	RF
65C33092-6		5	1E	RF
		1	25E	RF
65C33092-7		5	1F	RF
		1	25F	RF
65C33092-8		5	1G	RF
		1	25G	RF
65C33092-9		5	1H	RF
		1	25	RF
65C33093-1		5	1A	RF
		5	40A	1
65C33093-2		5	40	1
65C33094-1		5	35	1
		9	50	1
65C33147-10		1	30G	RF
		9	1H	RF
65C33147-3		1	30A	RF
		9	1B	RF
65C33147-4		1	30B	RF
		9	1C	RF
65C33147-5		1	30C	RF
		9	1D	RF
65C33147-6		1	30D	RF
		9	1E	RF
65C33147-7		1	30E	RF
		9	1F	RF
65C33147-8		1	30	RF
		9	1A	RF
65C33147-9		1	30F	RF
		9	1G	RF
65C33148-2		9	55	1
65C33150-3		5	7	23

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
69-77023-1		2	25	1
69-77135-1		1	55	1
		4	125	1
		5	30	1
		6	35	1
		7	25	1
		8	35	1
		9	45	1
69-77137-2		5	27	23
		9	42	23
69-77138-1		5	5B	23
69-77138-2		5	5A	23
		9	5A	23
69-77138-3		5	5C	23
		9	5B	23
69-77138-4		5	5	23
		9	5	23
69-77692-1		9	15A	1
69-77692-2		9	25	1
69-77692-3		9	35A	1
69-77692-4		9	15	1
69-77692-5		9	35	1
728800-60		9	54	1
740A11-9		4	40	1
850095		1	45A	1
		2	15A	1
		4	110A	1
		5	20A	1
		6	20A	1
		7	15A	1
		8	20A	1
		9	30A	1
		9	32A	1
BACJ40A11-9		4	40	1
BACN10JR3CFD		10	10	16

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACN10JR3F		3	10	14
BACN10YR06CD		4	35	1
BACN10YR3CD		4	30	8
BACR15BA3AD		3	5	28
BACR15BA4DC		4	49	3
BACR15BA6ADC		9	52A	4
BACR15BB3AD		10	5	32
BACS12GU3K11		4	10	8
BACS12GU3K9		4	60	18
BACS12HJ06K7		4	15B	1
BACS12HJ06K8		4	15A	1
BRF200A3		3	10	14
BRF200C3D		10	10	16
CD9E		4	40	1
F5000-3BAC		3	10	14
H52732-06CD		4	35	1
H52732-3CD		4	30	8
K19079-01-5CD		11	35	24
K19079-4		1	50	23
		2	20	21
		4	120	23
		5	25A	23
		6	30	23
		7	20	23
		8	30	23
		9	40A	23
K51602-3BAC		10	10	16
M25988-1-162		4	54	1
NAS1149D0332J		4	20	16
		4	65	18
NAS1149DN632J		4	25	2
NAS1395C3L		4	90A	18
NAS1395CA3L		4	90	18
NAS8201A8		4	15	1
NS103203-02		3	10	14

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
NS202476-02		10	10	16
PLH506CD		4	35	1
PLH53CD		4	30	8
RBEJ11-9		4	40	1
RM12LH3614-048		1	50A	23
		2	20A	21
		4	120A	23
		5	25	23
		6	30A	23
		7	20A	23
		8	30A	23
		9	40	23
		3	10	14
		4	55	1
RMF9201-3		3	10	14
S342T002-4		4	55	1
T8091S1032		3	10	14
T8092C1032CD		10	10	16
TJEJ40A11-9		4	40	1
VN152A1-02		3	10	14

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1-			DOOR ASSY		
-1A	112N6101-1		DOOR ASSY-10 X 18 FUEL TANK ACCESS.	A	RF
-1B	112N6101-3		DOOR ASSY-10 X 18 FUEL TANK ACCESS. (FOR DETAILS SEE FIG. 6)	B	RF
-1C	112N6101-6		DOOR ASSY-10 X 18 FUEL TANK ACCESS. (FOR DETAILS SEE FIG. 7)	C	RF
-1D	112N6101-11		DOOR ASSY-10 X 18 FUEL TANK ACCESS. (FOR DETAILS SEE FIG. 8)	D	RF
-1E	112N6101-2		DOOR ASSY-10 X 18 FUEL TANK ACCESS.	AK	RF
-1F	112N6101-9		DOOR ASSY-10 X 18 FUEL TANK ACCESS.	AQ	RF
-1G	112N6101-10		DOOR ASSY-10 X 18 FUEL TANK ACCESS. (FOR DETAILS SEE FIG. 7)	AR	RF
-3	112W8201-1		DOOR ASSY-10 X 18 IMPACT RESISTANT (FOR DETAILS SEE FIG. 11)	AH	RF
-3A	112W8202-1		DOOR ASSY-10 X 18 IMPACT RESISTANT, MEASURING STICK (FOR DETAILS SEE FIG. 11)	AJ	RF
-3B	112W8201-3		DOOR ASSY-10 X 18 FUEL TANK ACCESS, IMPACT RESISTANT (FOR DETAILS SEE FIG. 11)	AW	RF
-3C	112W8202-3		DOOR ASSY-10 X 18 IMPACT RESISTANT, MEASURING STICK (FOR DETAILS SEE FIG. 11)	AX	RF
-5	112N6102-1		DOOR ASSY-8 X 18 FUEL TANK ACCESS. (FOR DETAILS SEE FIG. 2)	E	RF
-10	112T4607-3		DOOR ASSY-INSPAR WING LWR (FOR DETAILS SEE FIG. 3)	F	RF
-10A	112T4607-5		DOOR ASSY-INSPAR WING LWR (FOR DETAILS SEE FIG. 10)	L	RF

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
–15	342W2801-3		DOOR ASSY-FUEL VENT SYS STANDPIPE/FLAME ARRESTOR (FOR DETAILS SEE FIG. 4)	G	RF
–15A	342W2801-5		DOOR ASSY-FUEL VENT SYS STANDPIPE/FLAME ARRESTOR (FOR DETAILS SEE FIG. 4)	M	RF
–15B	342W2801-7		DOOR ASSY-FUEL VENT SYS STANDPIPE/FLAME ARRESTOR (FOR DETAILS SEE FIG. 4)	AL	RF
–15C	342W2801-9		DOOR ASSY-FUEL VENT SYS STANDPIPE/FLAME ARRESTOR (FOR DETAILS SEE FIG. 4)	AM	RF
–20	342W2801-4		DOOR ASSY-FUEL VENT SYS STANDPIPE/FLAME ARRESTOR (FOR DETAILS SEE FIG. 4)	H	RF
–20A	342W2801-6		DOOR ASSY-FUEL VENT SYS STANDPIPE/FLAME ARRESTOR (FOR DETAILS SEE FIG. 4)	N	RF
–20B	342W2801-8		DOOR ASSY-FUEL VENT SYS STANDPIPE/FLAME ARRESTOR (FOR DETAILS SEE FIG. 4)	AN	RF
–20C	342W2801-10		DOOR ASSY-FUEL VENT SYS STANDPIPE/FLAME ARRESTOR (FOR DETAILS SEE FIG. 4)	AP	RF
–25	65C33092-9		DOOR ASSY-10 X 18 FUEL TANK ACCESS. IMPACT RESISTANT (FOR DETAILS SEE FIG. 5)	J	RF
–25A	65C33092-2		DOOR ASSY-10 X 18 FUEL TANK ACCESS. IMPACT RESISTANT (FOR DETAILS SEE FIG. 5)	P	RF
–25B	65C33092-3		DOOR ASSY-10 X 18 FUEL TANK ACCESS. IMPACT RESISTANT (FOR DETAILS SEE FIG. 5)	Q	RF
–25C	65C33092-4		DOOR ASSY-10 X 18 FUEL TANK ACCESS. IMPACT RESISTANT (FOR DETAILS SEE FIG. 5)	R	RF
–25D	65C33092-5		DOOR ASSY-10 X 18 FUEL TANK ACCESS. IMPACT RESISTANT (FOR DETAILS SEE FIG. 5)	S	RF

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
–25E	65C33092-6		DOOR ASSY-10 X 18 FUEL TANK ACCESS. IMPACT RESISTANT (FOR DETAILS SEE FIG. 5)	T	RF
–25F	65C33092-7		DOOR ASSY-10 X 18 FUEL TANK ACCESS. IMPACT RESISTANT (FOR DETAILS SEE FIG. 5)	U	RF
–25G	65C33092-8		DOOR ASSY-10 X 18 FUEL TANK ACCESS. IMPACT RESISTANT (FOR DETAILS SEE FIG. 5)	V	RF
–26	110U6011-1		DOOR ASSY-ACCESS IMPACT RESISTANT WING (FOR DETAILS SEE FIG. 5)	AD	RF
–26A	110U6011-2		DOOR ASSY-ACCESS IMPACT RESISTANT WING (FOR DETAILS SEE FIG. 5)	AE	RF
–27	110U6021-1		DOOR ASSY-ACCESS IMPACT RESISTANT WING (FOR DETAILS SEE FIG. 5)	AS	RF
–27A	110U6021-2		DOOR ASSY-ACCESS IMPACT RESISTANT WING (FOR DETAILS SEE FIG. 5)	AT	RF
–30	65C33147-8		DOOR ASSY-DIPSTICK 10 X 18 FUEL TANK ACCESS. IMPACT RESISTANT (FOR DETAILS SEE FIG. 9)	K	RF
–30A	65C33147-3		DOOR ASSY-DIPSTICK 10 X 18 FUEL TANK ACCESS. IMPACT RESISTANT (FOR DETAILS SEE FIG. 9)	W	RF
–30B	65C33147-4		DOOR ASSY-DIPSTICK 10 X 18 FUEL TANK ACCESS. IMPACT RESISTANT (FOR DETAILS SEE FIG. 9)	X	RF
–30C	65C33147-5		DOOR ASSY-DIPSTICK 10 X 18 FUEL TANK ACCESS. IMPACT RESISTANT (FOR DETAILS SEE FIG. 9)	Y	RF
–30D	65C33147-6		DOOR ASSY-DIPSTICK 10 X 18 FUEL TANK ACCESS. IMPACT RESISTANT (FOR DETAILS SEE FIG. 9)	Z	RF
–30E	65C33147-7		DOOR ASSY-DIPSTICK 10 X 18 FUEL TANK ACCESS. IMPACT RESISTANT (FOR DETAILS SEE FIG. 9)	AA	RF

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
–30F	65C33147-9		DOOR ASSY-DIPSTICK 10 X 18 FUEL TANK ACCESS. IMPACT RESISTANT (FOR DETAILS SEE FIG. 9)	AB	RF
–30G	65C33147-10		DOOR ASSY-DIPSTICK 10 X 18 FUEL TANK ACCESS. IMPACT RESISTANT (FOR DETAILS SEE FIG. 9)	AC	RF
–31	110U6012-1		DOOR ASSY-DIPSTICK IMPACT RESISTANT WING (FOR DETAILS SEE FIG. 9)	AF	RF
–31A	110U6012-2		DOOR ASSY-DIPSTICK IMPACT RESISTANT WING (FOR DETAILS SEE FIG. 9)	AG	RF
–32	110U6022-1		DOOR ASSY-DIPSTICK IMPACT RESISTANT WING (FOR DETAILS SEE FIG. 9)	AU	RF
–32A	110U6022-2		DOOR ASSY-DIPSTICK IMPACT RESISTANT WING (FOR DETAILS SEE FIG. 9)	AV	RF
35	63-8497		. RETAINER ASSY-NUT	A, AK, AQ	23
40	63-8497-2		. . ELEMENT-SELF-LOCKING (V03038)	A, AK, AQ	1
45	63-8497-1		. . RETAINER (OPT ITEM 45A)	A, AK, AQ	1
–45A	850095		. . RETAINER (V98403) (OPT ITEM 45)	A, AK, AQ	1
50	K19079-4		. NUT-SPECIAL (V15653) (OPT ITEM 50A)	A, AK, AQ	23
–50A	RM12LH3614-048		. NUT-SPECIAL (V72962) (OPT ITEM 50)	A, AK, AQ	23
55	69-77135-1		. SEAL-FUEL	A, AK, AQ	1
60	112N6004-1		. DOOR ASSY	A, AK	1
–60A	112N6004-8		. DOOR ASSY	AQ	1
65	112W8102-1		. . RING-PHENOLIC (OPT ITEM 65A)	A, AK, AQ	1

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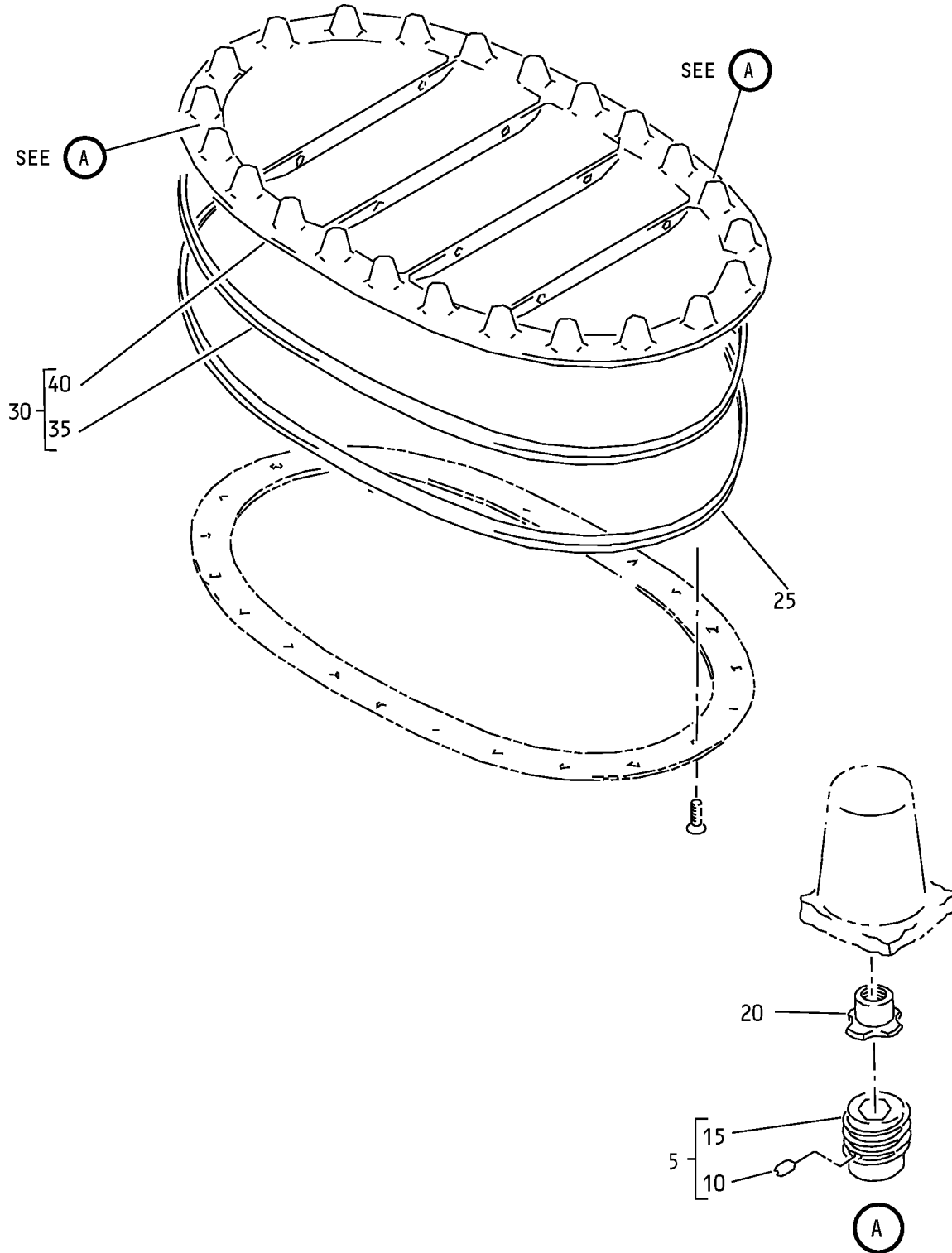
COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1– –65A	112W8102-5		. . KIT-SUBSTITUTE (OPT ITEM 65)	A, AK, AQ	1
67	112W8102-3		. . . SEGMENT-PHENOLIC RING (USED ON ITEM 65A)	A, AK, AQ	4
70	65-76140-3		. . CASTING-DOOR (OPT ITEM 70A)	A, AK	1
–70A	65-76140-24		. . CASTING-DOOR (OPT ITEM 70)	A, AK	1
–70B	110U6009-2		. . DOOR-MACHINED DELETED	AQ	1

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Fuel Tank Access Door Assembly
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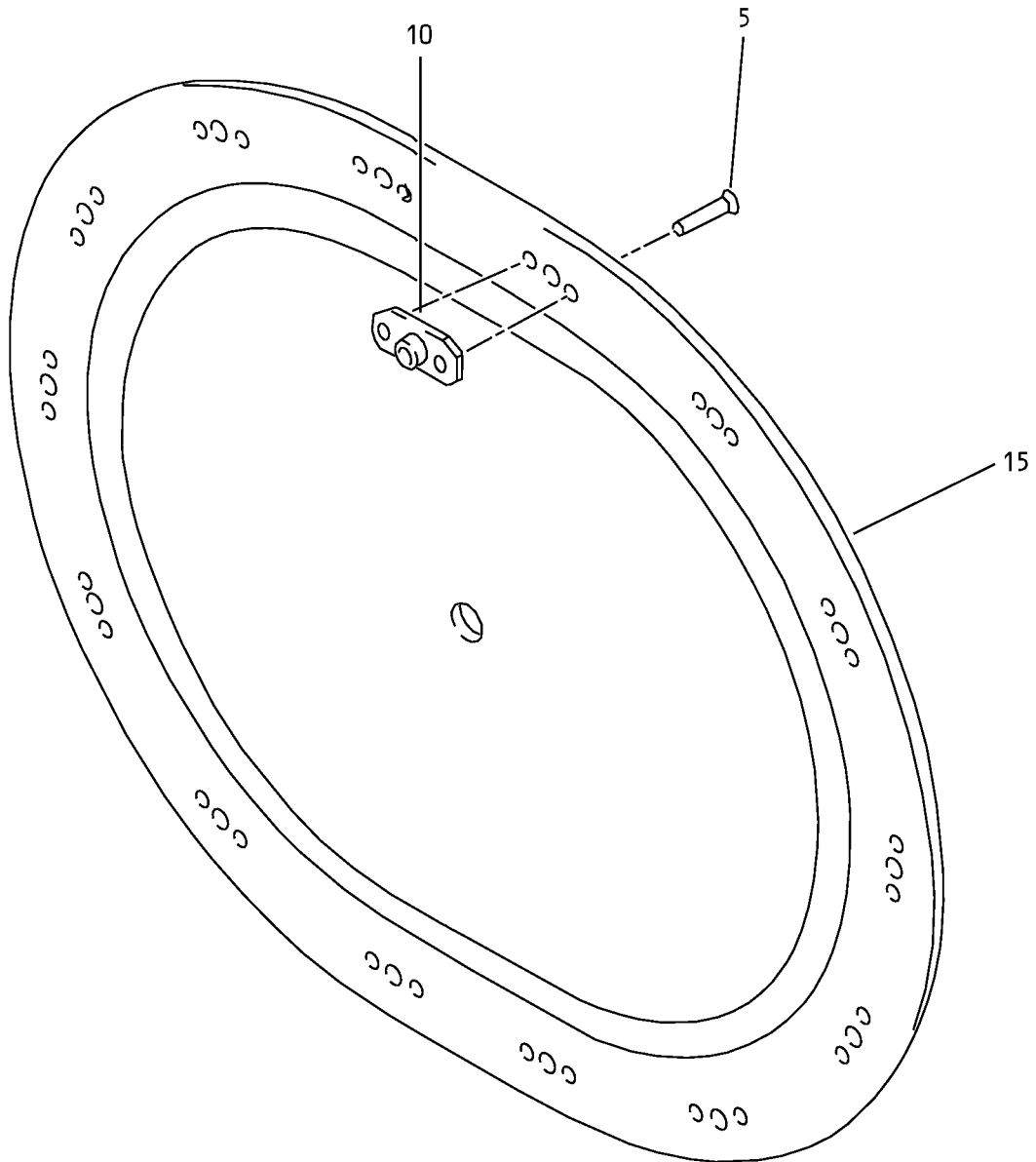
COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2-					
-1A	112N6102-1		DOOR ASSY-8 X 18 FUEL TANK ACCESS.	E	RF
5	63-8497		. RETAINER ASSY-NUT	E	21
10	63-8497-2		. . ELEMENT-SELF-LOCKING (V03038)	E	1
15	63-8497-1		. . RETAINER (OPT ITEM 15A)	E	1
-15A	850095		. . RETAINER (V98403) (OPT ITEM 15)	E	1
20	K19079-4		. NUT-SPECIAL (V15653) (OPT ITEM 20A)	E	21
-20A	RM12LH3614-048		. NUT-SPECIAL (V72962) (OPT ITEM 20)	E	21
25	69-77023-1		. SEAL	E	1
30	112N6012-1		. DOOR ASSY	E	1
35	112N6013-1		. . RING-PHENOLIC	E	1
40	65-76139-3		. . CASTING-DOOR	E	1

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Fuel Tank Access Door Assembly
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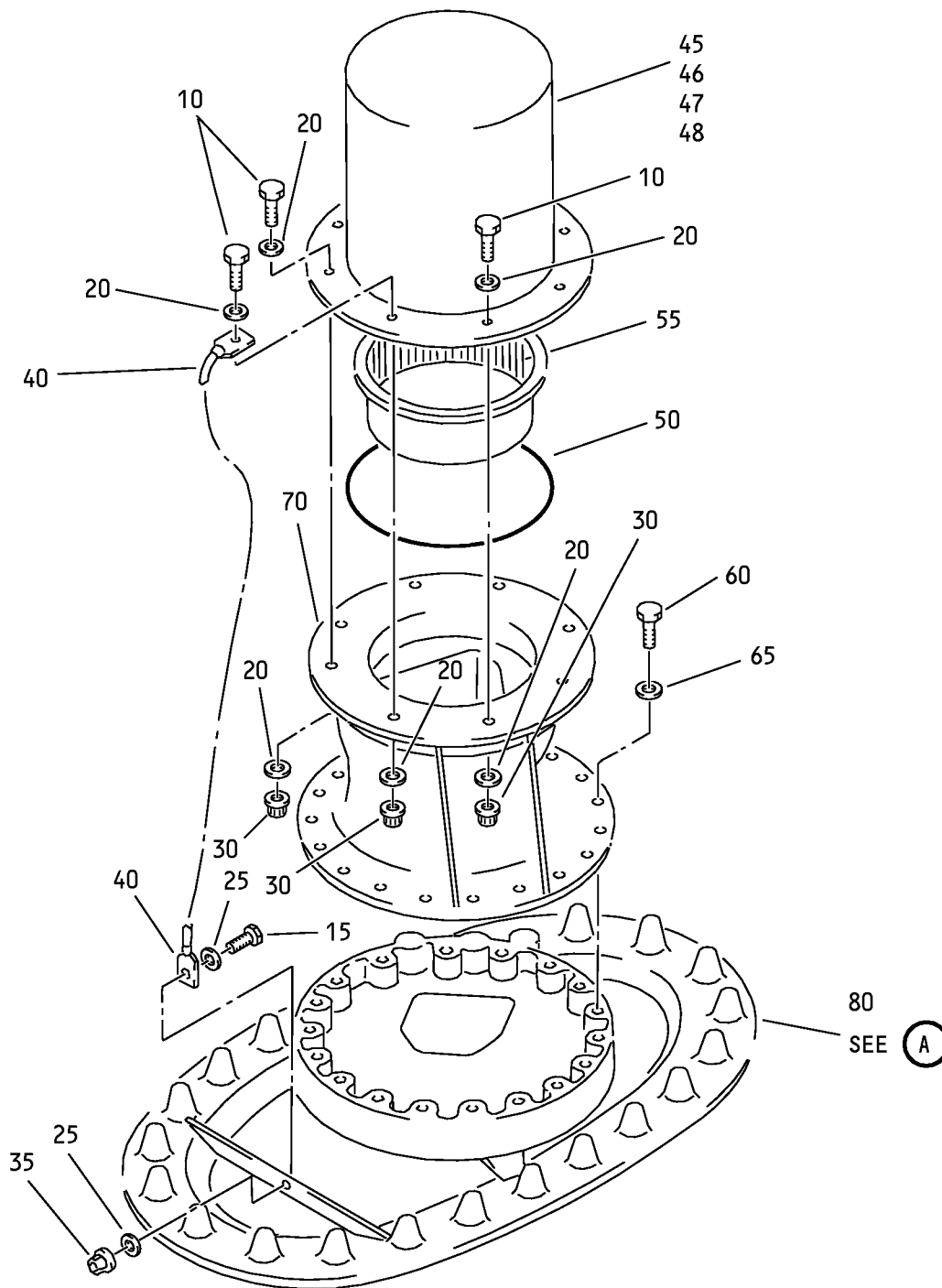


COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
3-					
-1A	112T4607-3		DOOR ASSY-INSPAR WING LWR	F	RF
5	BACR15BA3AD		. RIVET (SIZE DETERMINED ON INST)	F	28
10	F5000-3BAC		. NUTPLATE (V15653) (SPEC BACN10JR3F) (OPT NS103203-02 (V80539)) (OPT RMF9201-3 (V72962)) (OPT T8091S1032 (V11815)) (OPT VN152A1-02 (V92215)) (OPT BRF200A3 (V52828))	F	14
15	112T4607-4		. DOOR	F	1

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Fuel Tank Access Door Assembly
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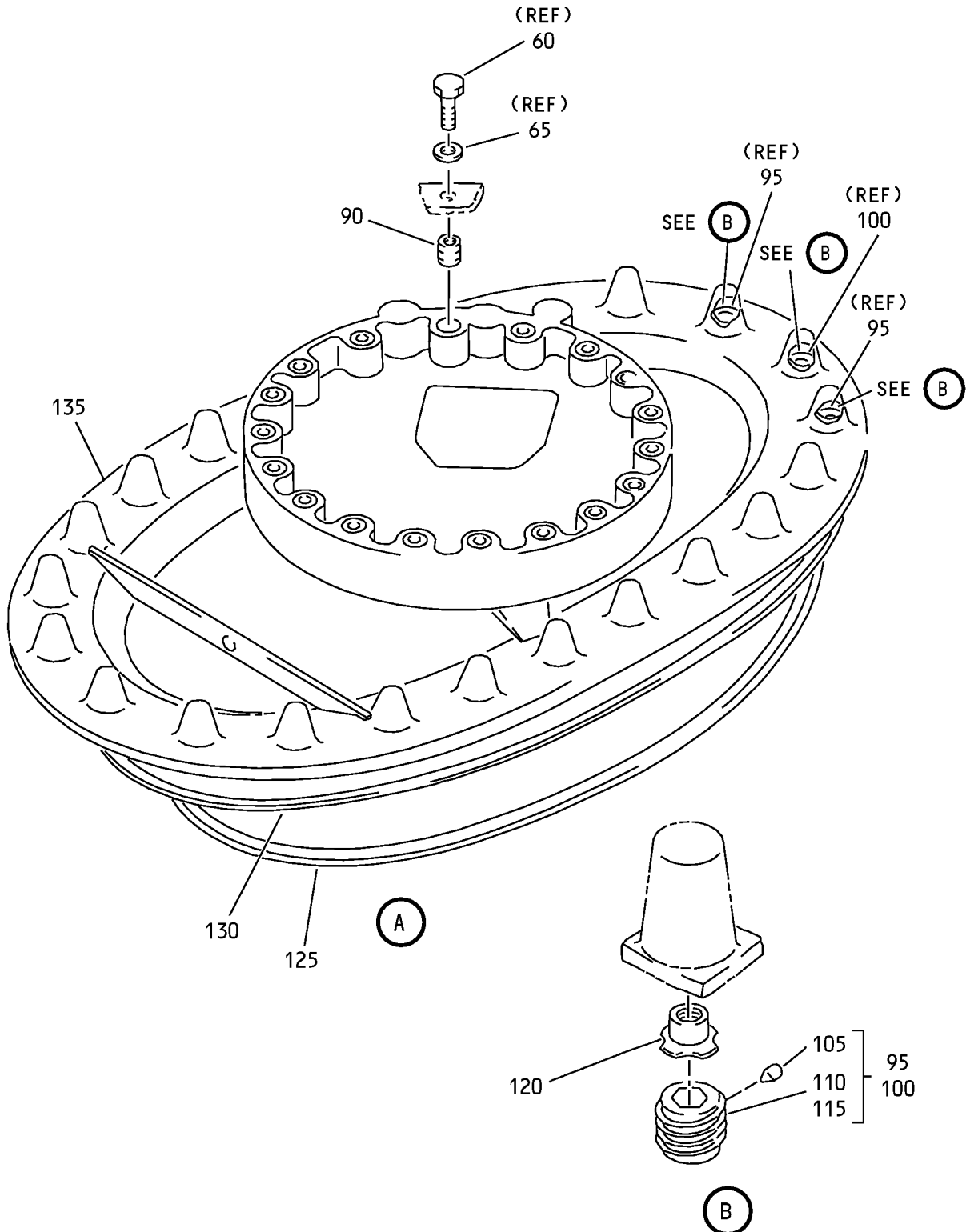
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Fuel Tank Access Door Assembly
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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
4-					
-1A	342W2801-3		DOOR ASSY-FUEL VENT SYS STANDPIPE/FLAME ARRESTOR	G	RF
-1B	342W2801-5		DOOR ASSY-FUEL VENT SYS STANDPIPE/FLAME ARRESTOR	M	RF
-1C	342W2801-7		DOOR ASSY-FUEL VENT SYS STANDPIPE/FLAME ARRESTOR	AL	RF
-1D	342W2801-9		DOOR ASSY-FUEL VENT SYS STANDPIPE/FLAME ARRESTOR	AM	RF
-5	342W2801-4		DOOR ASSY-FUEL VENT SYS STANDPIPE/FLAME ARRESTOR	H	RF
-5A	342W2801-6		DOOR ASSY-FUEL VENT SYS STANDPIPE/FLAME ARRESTOR	N	RF
-5B	342W2801-8		DOOR ASSY-FUEL VENT SYS STANDPIPE/FLAME ARRESTOR	AN	RF
-5C	342W2801-10		DOOR ASSY-FUEL VENT SYS STANDPIPE/FLAME ARRESTOR	AP	RF
10	BACS12GU3K11		. SCREW	G, H, M, N, AL-AP	8
15	NAS8201A8		. SCREW	G, H	1
-15A	BACS12HJ06K8		. SCREW	M, N	1
-15B	BACS12HJ06K7		. SCREW	AL-AP	1
20	NAS1149D0332J		. WASHER	G, H, M, N, AL-AP	16
25	NAS1149DN632J		. WASHER	G, H, M, N, AL-AP	2
30	H52732-3CD		. NUT (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))	G, H, M, N, AL-AP	8
35	H52732-06CD		. NUT (V15653) (SPEC BACN10YR06CD) (OPT PLH506CD (V62554))	G, H, M, N, AL-AP	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
4- 40	1002AB9		. JUMPER (V1FF12) (SPEC BACJ40A11-9) (OPT 30356 (V00779)) (OPT CD9E (V79550)) (OPT TJEJ40A11-9 (V33483)) (OPT 740A11-9 (V91812)) (OPT RBEJ11-9 (V1GK47))	G, H, M, N, AL-AP	1
45	342W2108-1		. WELD ASSY-VENT SCOOP, UPR DUCT	G, H	1
46	342W2108-3		. WELD ASSY-VENT SCOOP, UPR DUCT	M, N	1
47	342W2108-5		. STANDPIPE ASSY-VENT SCOOP, UPR DUCT	AL, AN	1
48	342W2108-6		. STANDPIPE ASSY-VENT SCOOP, UPR DUCT	AM, AP	1
49	BACR15BA4DC		. . RIVET (SIZE DETERMINED ON INST)	AL-AP	3
-50	M25988-1-162		DELETED		
51	342W2006-2		. . FLANGE	AL-AP	1
52	342W2108-7		. . STANDPIPE	AL, AN	1
53	342W2108-8		. . STANDPIPE	AM, AP	1
-54	M25988-1-162		. PACKING	G, H, M, N	1
55	6301520800-1		. ARRESTOR-FLAME (V83533) (SPEC S342T002-4) (OPT 6301520500-1 (V83533))	G, H, M, N, AL-AP	1
60	BACS12GU3K9		. SCREW	G, H, M, N, AL-AP	18
65	NAS1149D0332J		. WASHER	G, H, M, N, AL-AP	18
70	342W2001-3		. DUCT-VENT SCOOP LWR	G, M, AL, AM	1
-75	342W2001-4		. DUCT-VENT SCOOP LWR	H, N, AN, AP	1
80	112W8100-1		. DOOR ASSY-VENT SCOOP	G, M, AL, AM	1
-85	112W8100-2		. DOOR ASSY-VENT SCOOP	H, N, AN, AP	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
4-					
90	NAS1395CA3L		. . INSERT (OPT ITEM 90A)	G, H, M, N, AL-AP	18
-90A	NAS1395C3L		. . INSERT (OPT ITEM 90)	G, H, M, N, AL-AP	18
95	63-8497		. . RETAINER ASSY-NUT	G, H, M, N, AL-AP	22
100	63-8497-3		. . RETAINER ASSY-NUT	G, H, M, N, AL-AP	1
105	63-8497-2		. . . ELEMENT-SELF-LOCKING (V03038)	G, H, M, N, AL-AP	1
110	63-8497-1		. . . RETAINER (OPT ITEM 110A) (USED ON ITEM 95)	G, H, M, N, AL-AP	1
-110A	850095		. . . RETAINER (V98403) (OPT ITEM 110) (USED ON ITEM 95)	G, H, M, N, AL-AP	1
115	63-8497-4		. . . RETAINER (USED ON ITEM 100)	G, H, M, N, AL-AP	1
120	K19079-4		. . NUT-SPECIAL (V15653) (OPT ITEM 120A)	G, H, M, N, AL-AP	23
-120A	RM12LH3614-048		. . NUT-SPECIAL (V72962) (OPT ITEM 120)	G, H, M, N, AL-AP	23
125	69-77135-1		. . SEAL-FUEL	G, H, M, N, AL-AP	1
130	112W8102-1		. . RING-PHENOLIC	G, H, M, N, AL-AP	1
135	112W8101-1		. . DOOR	G, M, AL, AM	1
-140	112W8101-2		. . DOOR	H, N, AN, AP	1

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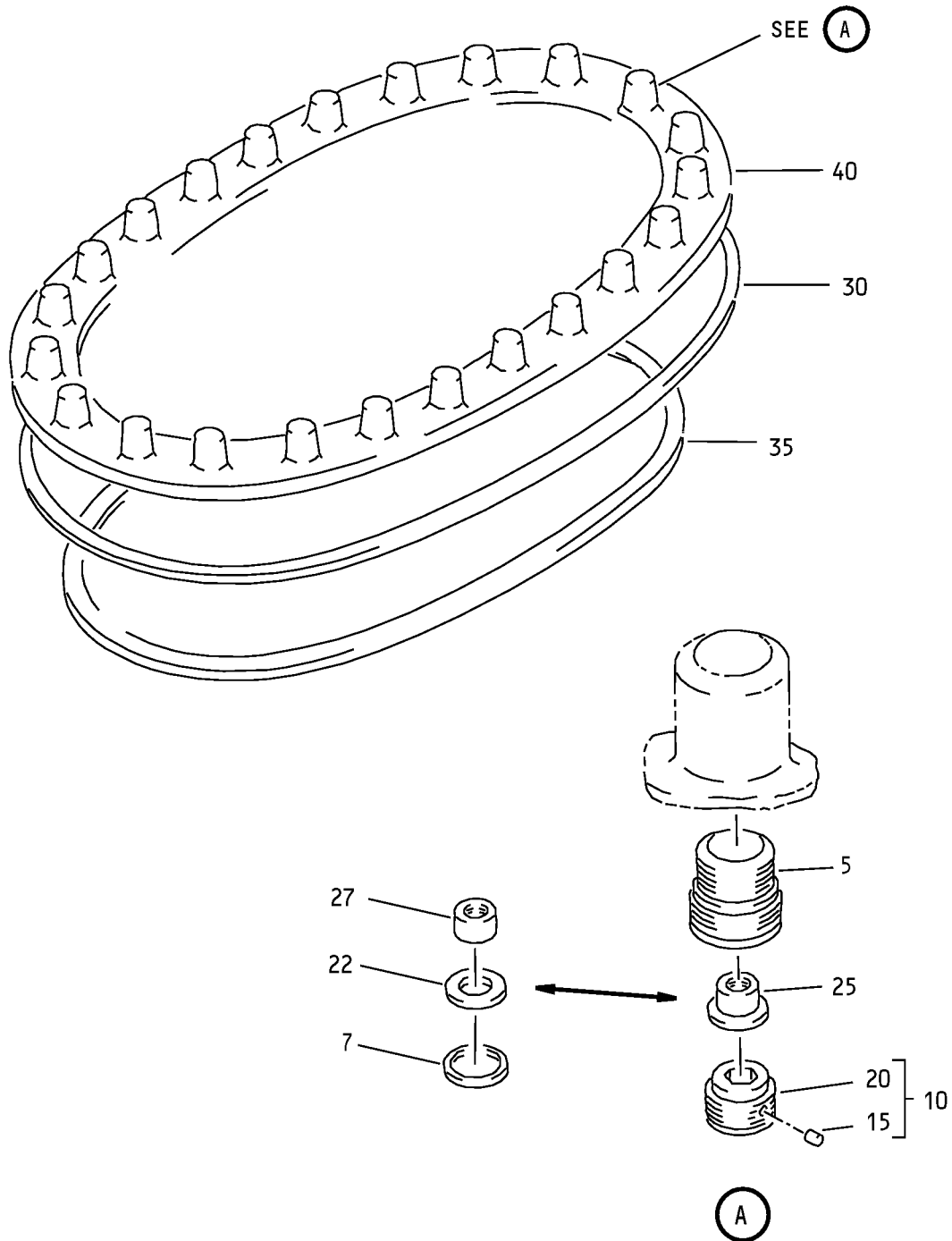
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Fuel Tank Access Door Assembly
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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
5-			DOOR ASSY-FUEL TANK ACCESS		
-1A	65C33092-9		DOOR ASSY-10 X 18 FUEL TANK ACCESS, IMPACT RESISTANT	J	RF
-1B	65C33092-2		DOOR ASSY-10 X 18 FUEL TANK ACCESS, IMPACT RESISTANT	P	RF
-1C	65C33092-3		DOOR ASSY-10 X 18 FUEL TANK ACCESS, IMPACT RESISTANT	Q	RF
-1D	65C33092-4		DOOR ASSY-10 X 18 FUEL TANK ACCESS, IMPACT RESISTANT	R	RF
-1E	65C33092-5		DOOR ASSY-10 X 18 FUEL TANK ACCESS, IMPACT RESISTANT	S	RF
-1F	65C33092-6		DOOR ASSY-10 X 18 FUEL TANK ACCESS, IMPACT RESISTANT	T	RF
-1G	65C33092-7		DOOR ASSY-10 X 18 FUEL TANK ACCESS, IMPACT RESISTANT	U	RF
-1H	65C33092-8		DOOR ASSY-10 X 18 FUEL TANK ACCESS, IMPACT RESISTANT	V	RF
-1J	110U6011-1		DOOR ASSY-ACCESS, IMPACT RESISTANT, WING	AD	RF
-1K	110U6011-2		DOOR ASSY-ACCESS, IMPACT RESISTANT, WING	AE	RF
-1L	110U6021-1		DOOR ASSY-ACCESS, IMPACT RESISTANT, WING	AS	RF
-1M	110U6021-2		DOOR ASSY-ACCESS, IMPACT RESISTANT, WING	AT	RF
-1N	110U6011-3		DOOR ASSY-ACCESS	AY	RF
5	69-77138-4		. INSERT	J, V, AE, AT, AY	23
-5A	69-77138-2		. INSERT	P, R, S	23
-5B	69-77138-1		. INSERT	Q	23
-5C	69-77138-3		. INSERT	T, U, AD, AS	23
7	65C33150-3		. RING-RETAINING	Q	23

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
5-											
10	63-8497		.							J, T, U, V, AD, AE, AS, AT, AY	23
-10A	63-8497		.							P, R, S	23
-10B	63-8497-1		.							P, R, S	23
15	63-8497-2		.	.						J, P, R-V, AD, AE, AS, AT, AY	1
20	63-8497-1		.	.						J, P, R-V, AD, AE, AS, AT, AY	1
-20A	850095		.	.						J, P, R-V, AD, AE, AS, AT, AY	1
22	112N4508-1		.							P-U, AD, AS	23
25	RM12LH3614-048		.							J, V, AE, AT, AY	23
-25A	K19079-4		.							J, V, AE, AT, AY	23
27	69-77137-2		.							P-U, AD, AS	23
30	69-77135-1		.							J, P-V, AD, AE, AS, AT, AY	1
35	65C33094-1		.							J, P-V, AD, AE, AY	1
40	65C33093-2		.							J, V	1
-40A	65C33093-1		.							P-U	1
-40B	110U6013-1		.							AD	1

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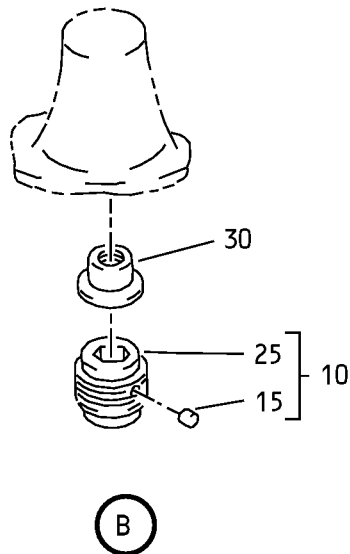
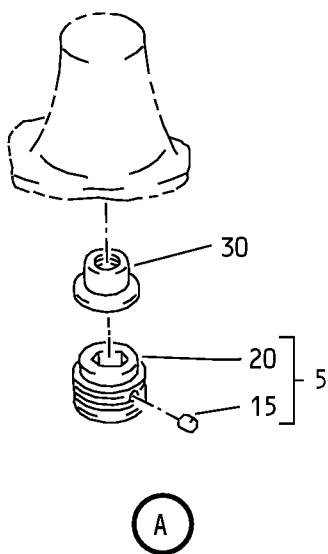
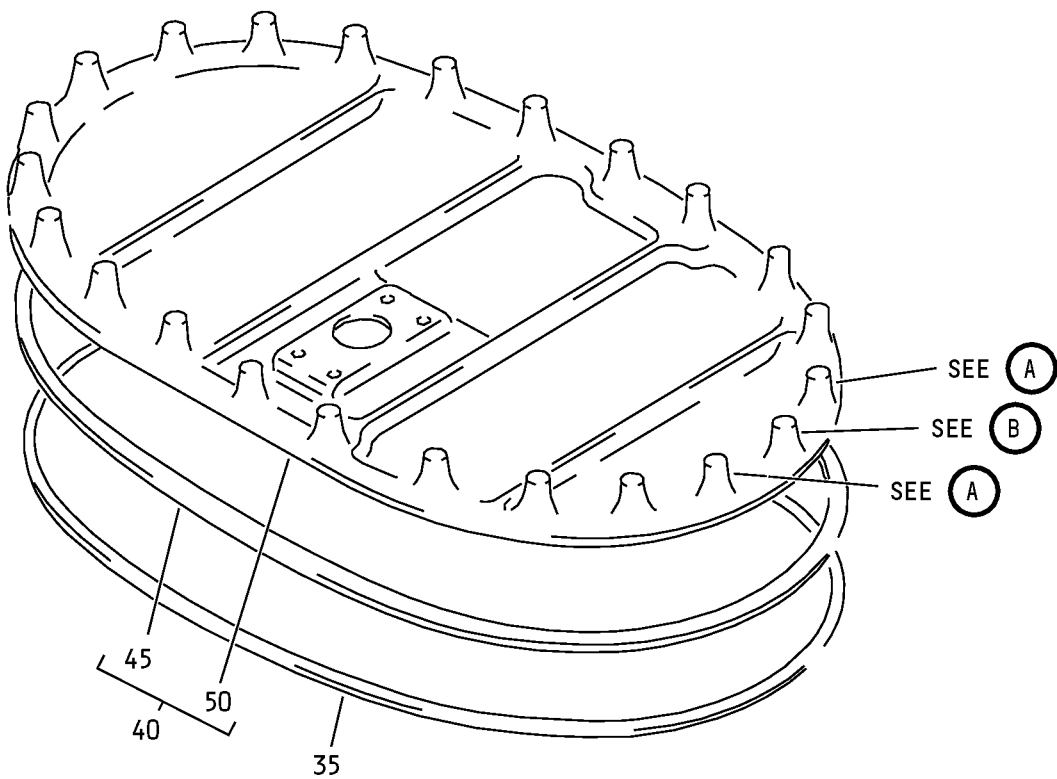
FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
5-					
-40C	110U6013-3		. PLATE-BACKING	AE	1
-40D	112U6013-1		. PLATE-BACKING	AY	1
-40E	110U6023-2		. PLATE-BACKING	AT	1

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COMPONENT MAINTENANCE MANUAL



Fuel Tank Access Door Assembly
IPL Figure 6



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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
6-					
-1A	112N6101-3		DOOR ASSY-10 X 18 FUEL TANK ACCESS.	B	RF
5	63-8497		. RETAINER ASSY-NUT	B	22
10	63-8497-3		. RETAINER ASSY-NUT	B	1
15	63-8497-2		. . ELEMENT-SELF-LOCKING (V03038)	B	1
20	63-8497-1		. . RETAINER (OPT ITEM 20A) (USED ON ITEM 5)	B	1
-20A	850095		. . RETAINER (V98403) (OPT ITEM 20) (USED ON ITEM 5)	B	1
25	63-8497-4		. . RETAINER (USED ON ITEM 10)	B	1
30	K19079-4		. NUT-SPECIAL (V15653) (OPT ITEM 30A)	B	23
-30A	RM12LH3614-048		. NUT-SPECIAL (V72962) (OPT ITEM 30)	B	23
35	69-77135-1		. SEAL-FUEL	B	1
40	112N6004-2		. DOOR ASSY	B	1
45	112W8102-1		. . RING-PHENOLIC	B	1
50	65-76140-6		. . CASTING-DOOR	B	1

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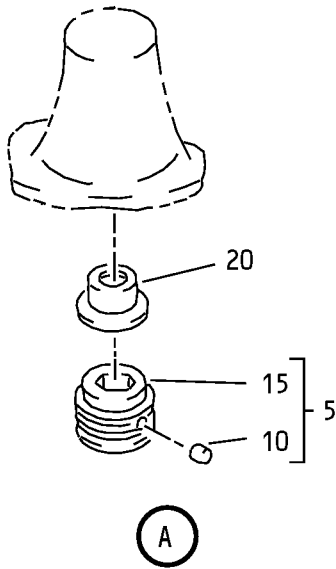
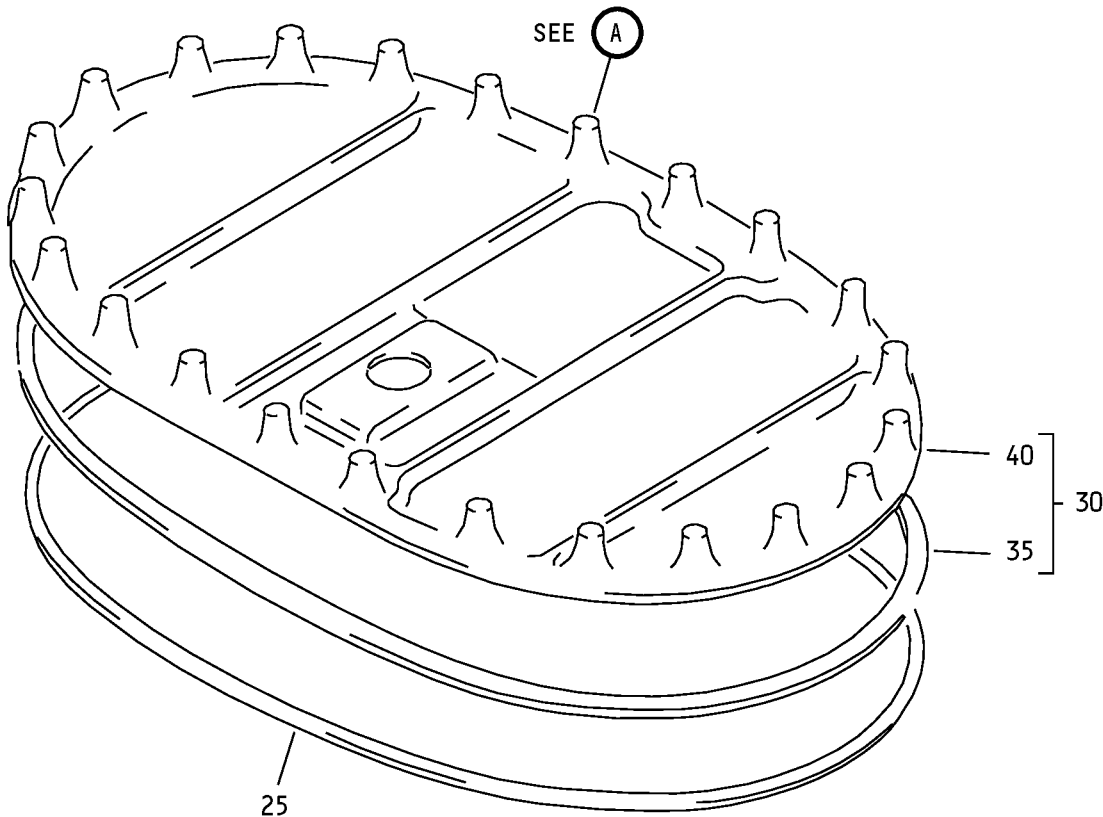
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Fuel Tank Access Door Assembly
IPL Figure 7

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
7-					
-1A	112N6101-6		DOOR ASSY-10 X 18 FUEL TANK ACCESS.	C	RF
-1B	112N6101-10		DOOR ASSY-10 X 18 FUEL TANK ACCESS.	AR	RF
5	63-8497		. RETAINER ASSY-NUT	C, AR	23
10	63-8497-2		. . ELEMENT-SELF-LOCKING (V03038)	C, AR	1
15	63-8497-1		. . RETAINER (OPT ITEM 15A)	C, AR	1
-15A	850095		. . RETAINER (V98403) (OPT ITEM 15)	C, AR	1
20	K19079-4		. NUT-SPECIAL (V15653) (OPT ITEM 20A)	C, AR	23
-20A	RM12LH3614-048		. NUT-SPECIAL (V72962) (OPT ITEM 20)	C, AR	23
25	69-77135-1		. SEAL-FUEL	C, AR	1
30	112N6004-5		. DOOR ASSY	C	1
-30A	112N6004-7		. DOOR ASSY	AR	1
35	112W8102-1		. . RING-PHENOLIC (OPT ITEM 35A)	C, AR	1
-35A	112W8102-5		. . KIT-SUBSTITUTION (OPT ITEM 35)	C, AR	1
37	112W8102-3		. . . SEGMENT-PHENOLIC RING (USED ON ITEM 35A)	C, AR	4
40	65-76140-6		. . CASTING-DOOR (OPT ITEM 40A)	C	1
-40A	65-76140-25		. . CASTING-DOOR (OPT ITEM 40)	C	1
-40B	110U6010-2		. . DOOR-MACHINED	AR	1

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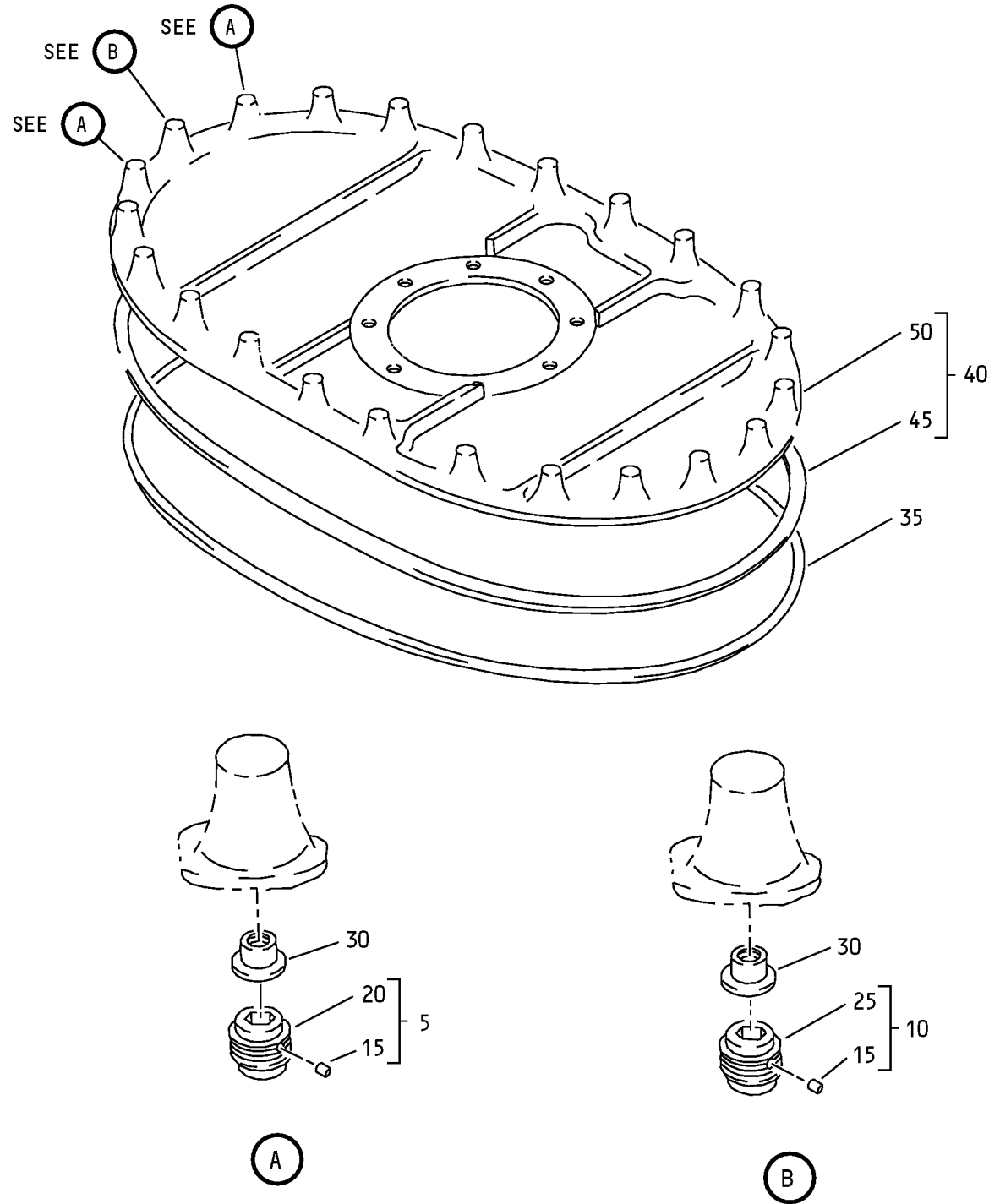
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Fuel Tank Access Door Assembly
IPL Figure 8

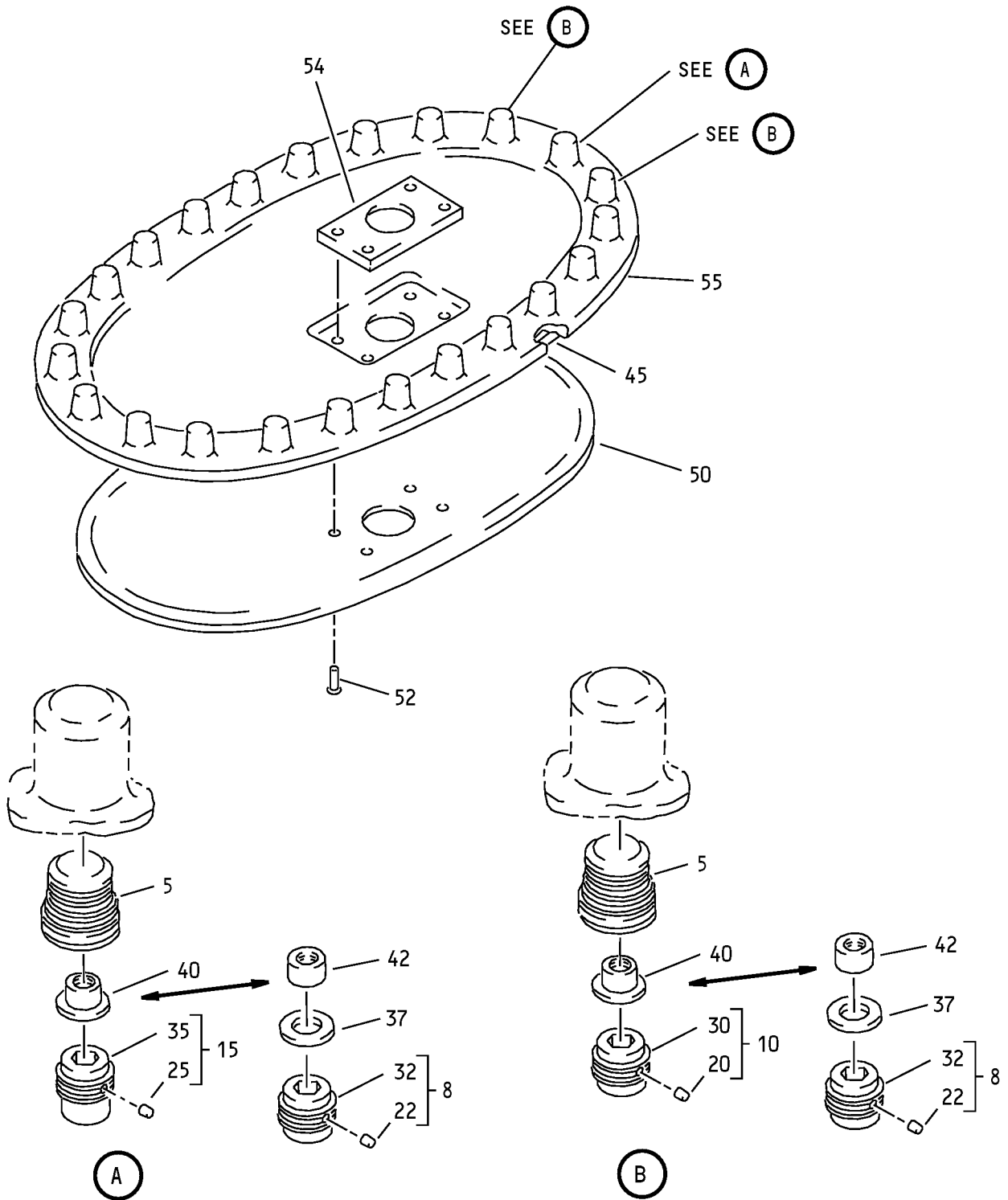


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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
8-					
-1A	112N6101-11		DOOR ASSY-10 X 18 FUEL TANK ACCESS.	D	RF
5	63-8497		. RETAINER ASSY-NUT	D	22
10	63-8497-3		. RETAINER ASSY-NUT	D	1
15	63-8497-2		. . ELEMENT-SELF-LOCKING (V03038)	D	1
20	63-8497-1		. . RETAINER (OPT ITEM 20A) (USED ON ITEM 5)	D	1
-20A	850095		. . RETAINER (V98403) (OPT ITEM 20) (USED ON ITEM 5)	D	1
25	63-8497-4		. . RETAINER (USED ON ITEM 10)	D	1
30	K19079-4		. NUT-SPECIAL (V15653) (OPT ITEM 30A)	D	23
-30A	RM12LH3614-048		. NUT-SPECIAL (V72962) (OPT ITEM 30)	D	23
35	69-77135-1		. SEAL-FUEL	D	1
40	112N6004-10		. DOOR ASSY	D	1
45	112W8102-1		. . RING-PHENOLIC	D	1
50	65-76140-23		. . CASTING-DOOR	D	1

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Fuel Tank Access Door Assembly
IPL Figure 9

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
9-			DOOR ASSY-FUEL TANK ACCESS		
-1A	65C33147-8		DOOR ASSY-DRIPSTICK, 10 X 18 FUEL TANK ACCESS, IMPACT RESISTANT	K	RF
-1B	65C33147-3		DOOR ASSY-DRIPSTICK, 10 X 18 FUEL TANK ACCESS, IMPACT RESISTANT	W	RF
-1C	65C33147-4		DOOR ASSY-DRIPSTICK, 10 X 18 FUEL TANK ACCESS, IMPACT RESISTANT	X	RF
-1D	65C33147-5		DOOR ASSY-DRIPSTICK, 10 X 18 FUEL TANK ACCESS, IMPACT RESISTANT	Y	RF
-1E	65C33147-6		DOOR ASSY-DRIPSTICK, 10 X 18 FUEL TANK ACCESS, IMPACT RESISTANT	Z	RF
-1F	65C33147-7		DOOR ASSY-DRIPSTICK, 10 X 18 FUEL TANK ACCESS, IMPACT RESISTANT	AA	RF
-1G	65C33147-9		DOOR ASSY-DRIPSTICK, 10 X 18 FUEL TANK ACCESS, IMPACT RESISTANT	AB	RF
-1H	65C33147-10		DOOR ASSY-DRIPSTICK, 10 X 18 FUEL TANK ACCESS, IMPACT RESISTANT	AC	RF
-1J	110U6012-1		DOOR ASSY-DRIPSTICK, IMPACT RESISTANT, WING	AF	RF
-1K	110U6012-2		DOOR ASSY-DRIPSTICK, IMPACT RESISTANT, WING	AG	RF
-1L	110U6022-1		DOOR ASSY-DRIPSTICK, IMPACT RESISTANT, WING	AU	RF
-1M	110U6022-2		DOOR ASSY-DRIPSTICK, IMPACT RESISTANT, WING	AV	RF
-1N	110U6012-3		DOOR ASSY-DRIPSTICK	BA	RF
5	69-77138-4		. INSERT	K, AA- AC, AG, AV, BA	23
-5A	69-77138-2		. INSERT	W, X	23
-5B	69-77138-3		. INSERT	Y, Z, AU	23
8	63-8497		. RETAINER ASSY-NUT	AF, AG, AU, AV, BA	23
10	63-8497		. RETAINER ASSY-NUT	K, X-AC	22

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
9-					
-10A	63-8497		. RETAINER ASSY-NUT (OPT ITEM 10B)	W	22
-10B	63-8497-1		. RETAINER-NUT (OPT ITEM 10A)	W	22
15	69-77692-4		. RETAINER ASSY-NUT	K, AA- AC, BA	1
-15A	69-77692-1		. RETAINER ASSY-NUT	W-Z	1
-15B	63-8497-3		. RETAINER ASSY-NUT	BA	22
20	63-8497-2		. . ELEMENT-SELF-LOCKING (V03038) (USED ON ITEMS 10, 10A)	K, W-AC, BA	1
22	63-8497-2		. . ELEMENT-SELF-LOCKING (V03038)	AF, AG, AU, AV	1
25	69-77692-2		. . ELEMENT-SELF-LOCKING (V03038) (USED ON ITEMS 15, 15A)	K, W-AC	1
-25A	63-8497-2		. . ELEMENT-SELF-LOCKING (V03038)	BA	1
30	63-8497-1		. . RETAINER (OPT ITEM 30A) (USED ON ITEMS 10, 10A)	K, W-AC, BA	1
-30A	850095		. . RETAINER (V98403) (OPT ITEM 30) (USED ON ITEMS 10, 10A)	K, W-AC, BA	1
32	63-8497-1		. . RETAINER (OPT ITEM 32A)	AF, AG, AU, AV	1
-32A	850095		. . RETAINER (V98403) (OPT ITEM 32)	AF, AG, AU, AV	1
35	69-77692-5		. . RETAINER (USED ON ITEM 15)	K, AA- AC	1
-35A	69-77692-3		. . RETAINER (USED ON ITEM 15A)	W-Z	1
-35B	63-8497-4		. . RETAINER	BA	1
37	112N4508-1		. WASHER	W-Z, AF, AU	23

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
9— 40	RM12LH3614-048		. NUT-SPECIAL (V72962) (OPT ITEM 40A)	K, AA- AC, AG, AV, BA	23
—40A	K19079-4		. NUT-SPECIAL (V15653) (OPT ITEM 40)	K, AA- AC, AG, AV, BA	23
42	69-77137-2		. NUT-SELF-LOCKING	W-Z, AF, AU	23
45	69-77135-1		. SEAL-FUEL	K, W-AC, AF, AG, AU, AV, BA	1
50	65C33094-1		. SHEET-FACE	K, W-AC, AF, AG, BA	1
—52	BACR15BA6ACD		DELETED		
52A	BACR15BA6ADC		. RIVET (SIZE DETERMINED ON INST)	W, Y, AA, AC	4
54	4090-0034-60		. DIPSTICK-BASE PLATE (V86831) (SPEC 10-60522-60) (OPT 728800-60 (V86831))	W, Y, AA, AC	1
55	65C33148-2		. PLATE-BACKING	K, AA- AC	1
—55A	110U6014-1		. PLATE-BACKING	AF	1
—55B	110U6014-3		. PLATE-BACKING	AG	1
—55C	112U6014-1		. PLATE-BACKING	BA	1
—55D	110U6024-2		. PLATE-BACKING	AV	1

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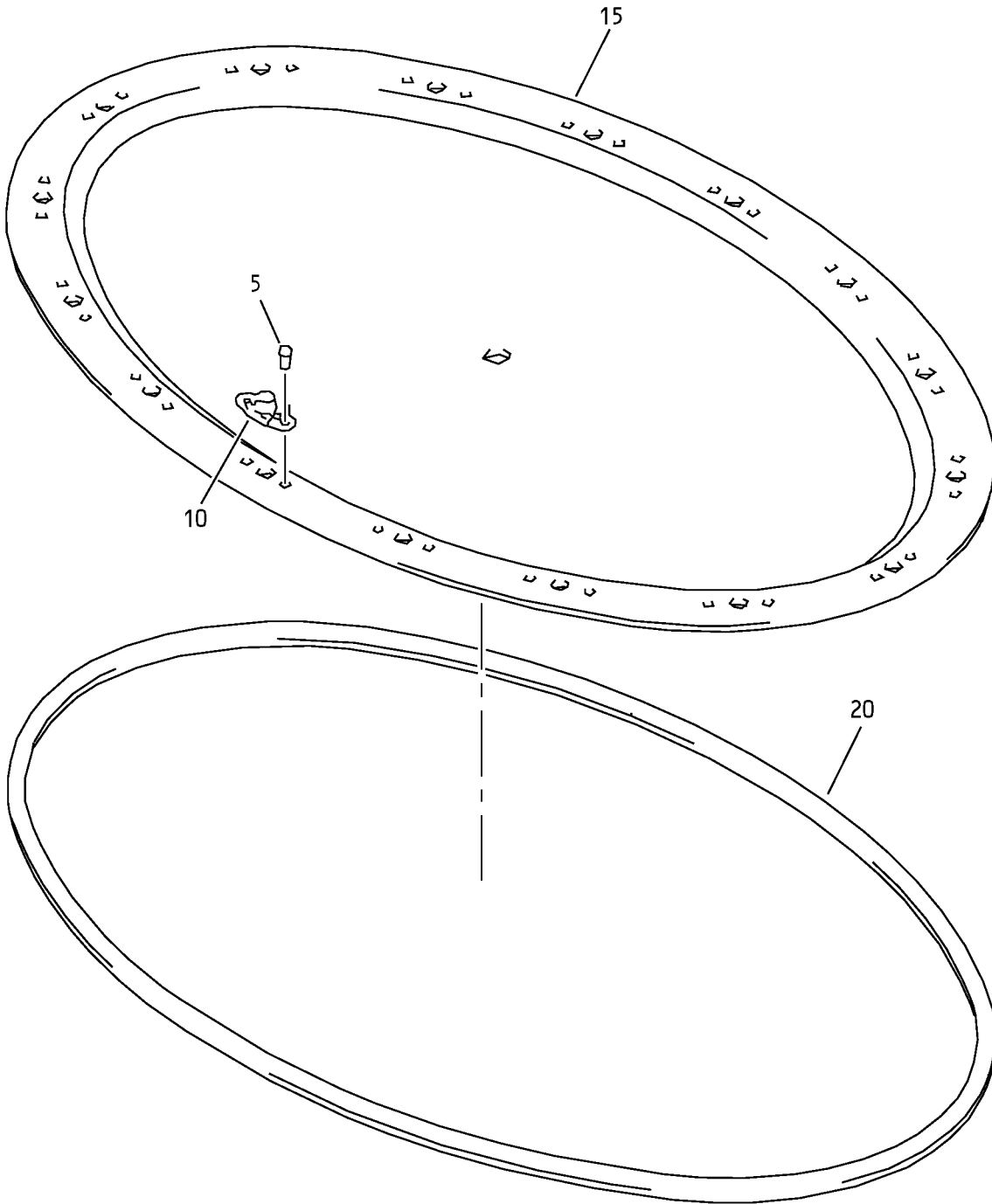
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Fuel Tank Access Door Assembly
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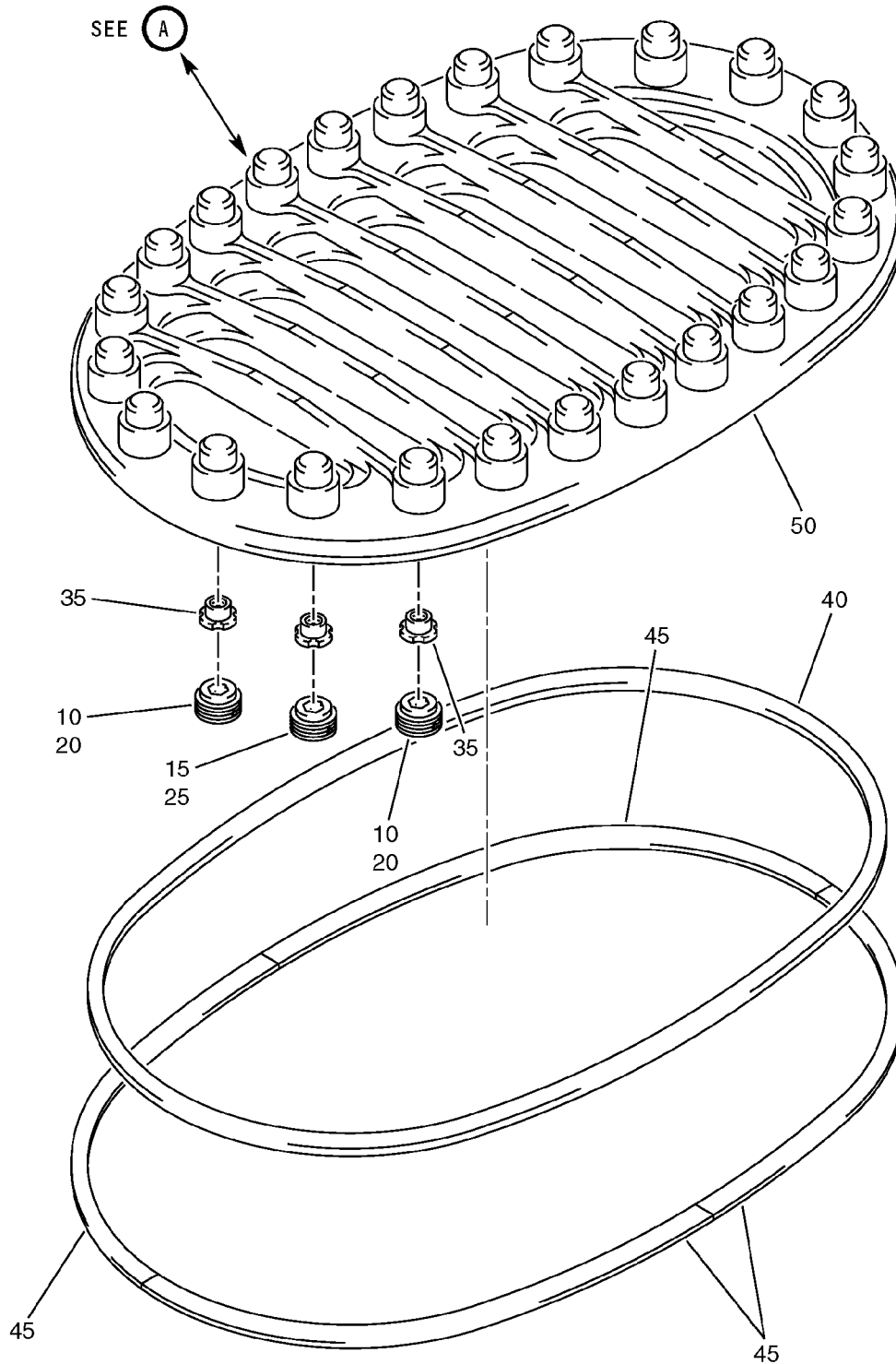


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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
10–					
–1A	112T4607-5		DOOR ASSY-INSPAR WING LWR	L	RF
5	BACR15BB3AD		. RIVET (SIZE DETERMINED ON INST)	L	32
10	BRF200C3D		. NUTPLATE (V52828) (SPEC BACN10JR3CFD) (OPT K51602-3BAC (V15653)) (OPT NS202476-02 (V80539)) (OPT 102F9201-3 (V72962)) (OPT T8092C1032CD (V11815))	L	16
15	112T4607-7		. DOOR	L	1
20	112T4607-9		. RING-PHENOLIC	L	1

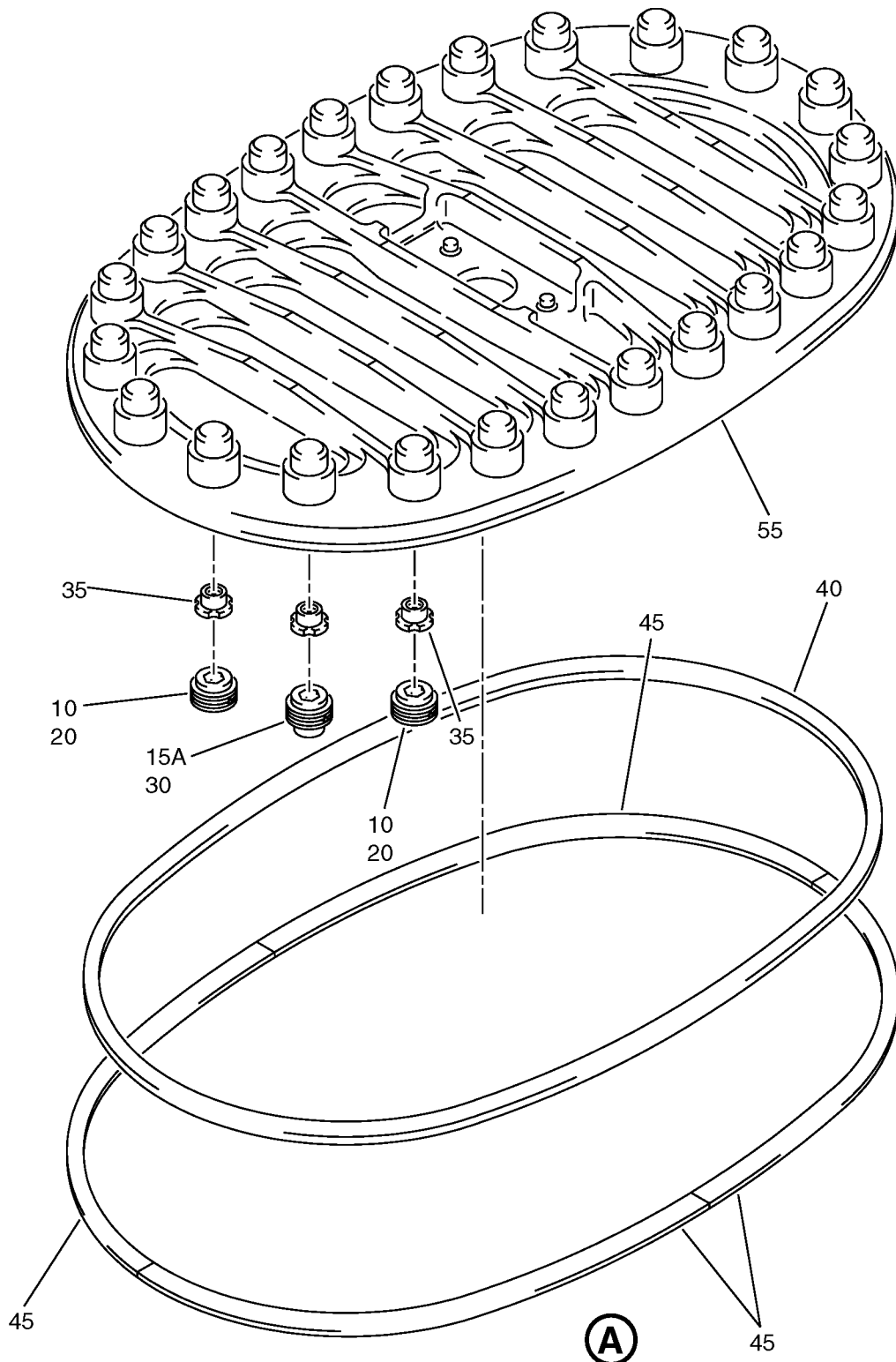
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Fuel Tank Access Door Assembly
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Fuel Tank Access Door Assembly
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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
11-			DOOR ASSY		
-2	112W8201-1		DOOR ASSY-10 X 18 IMPACT RESISTANT	AH	RF
-5	112W8202-1		DOOR ASSY-10 X 18 IMPACT RESISTANT, MEASURING STICK	AJ	RF
10	112W8213-1		. NUT ASSY-RETAINER	AH, AJ	23
15	112W8213-1		. NUT ASSY-RETAINER	AH	1
15A	112W8213-2		. NUT ASSY-RETAINER	AJ	1
20	112W8213-3		. . NUT (USED ON ITEM 10)	AH, AJ	1
25	112W8213-3		. . NUT (USED ON ITEM 15)	AH	1
30	112W8213-4		. . NUT (USED ON ITEM 15A)	AJ	1
35	K19079-01-5CD		. NUT-SPECIAL SELF LOCKING (V15653)	AH, AJ	24
40	112W8214-1		. SEAL-FUEL	AH, AJ	1
45	112W8102-3		. RING-PHENOLIC (OPT ITEM 45A)	AH, AJ	4
-45A	112W8102-4		. RING-PHENOLIC (OPT ITEM 45)	AH, AJ	4
50	112W8210-1		. DOOR	AH	1
55	112W8210-2		. DOOR	AJ	1

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