



COMPONENT MAINTENANCE MANUAL WITH ILLUSTRATED PARTS LIST

MAIN LANDING GEAR DOOR COMPONENTS

PART NUMBER

**113A8100-3, -4, -5, -6, 113A8200-3, -4, -5, -6,
113A8331-1, -2, 113A8500-1, -2, 113A8600-3**

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COMPONENT MAINTENANCE MANUAL

Revision No. 12
Jul 01/2009

To: All holders of MAIN LANDING GEAR DOOR COMPONENTS 32-13-23.

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.

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

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113A8100, 113A8200, 113A8331,
113A8500, 113A8600



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Location of Change

Description of Change

NO HIGHLIGHTS

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HIGHLIGHTS

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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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COMPONENT MAINTENANCE MANUAL

MAIN LANDING GEAR DOOR COMPONENTS - DESCRIPTION AND OPERATION

1. Description

- A. The main landing gear components include the inboard door assembly, the outboard door assembly, the center door assembly, the inboard pushrod assembly, and the outboard pushrod assembly.

2. Operation

- A. The main landing gear components operate when the main landing gear is extended or retracted. When the doors are closed they help make the surface of the airplane aerodynamically smooth.

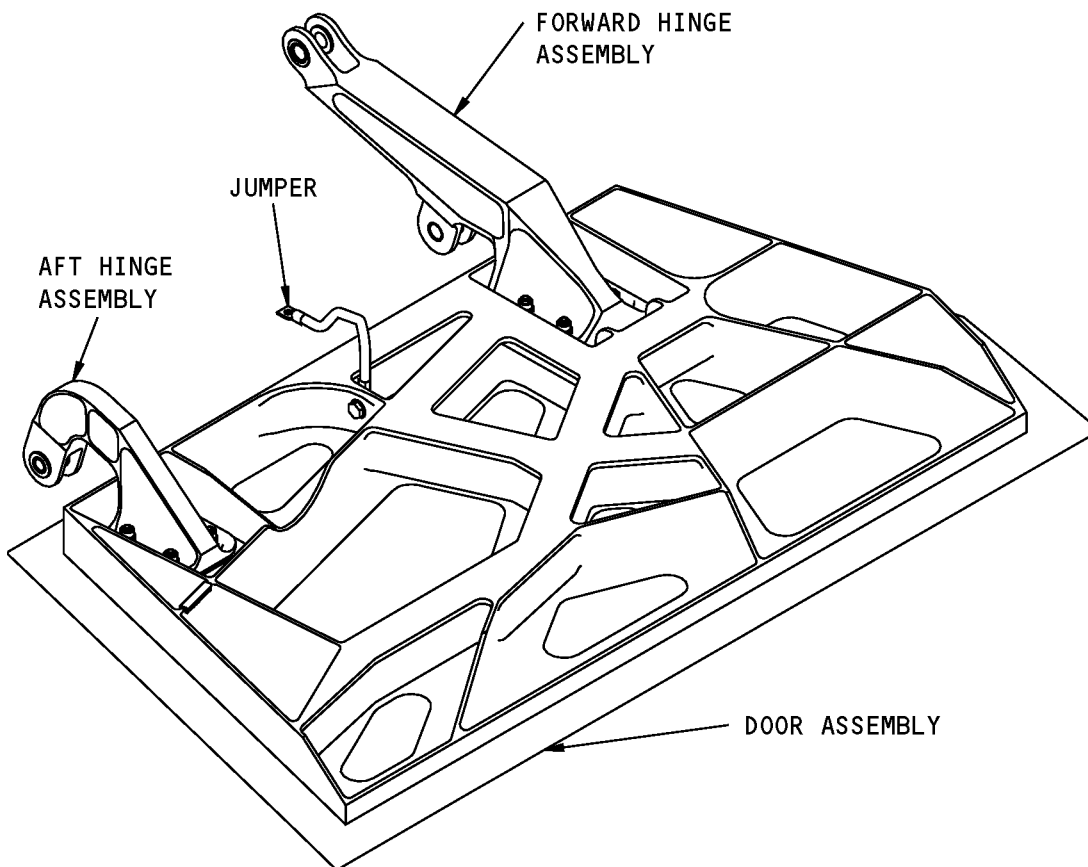
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OUTBOARD MAIN LANDING GEAR DOOR ASSEMBLY

Main Landing Gear Door Components
Figure 1 (Sheet 1 of 3)

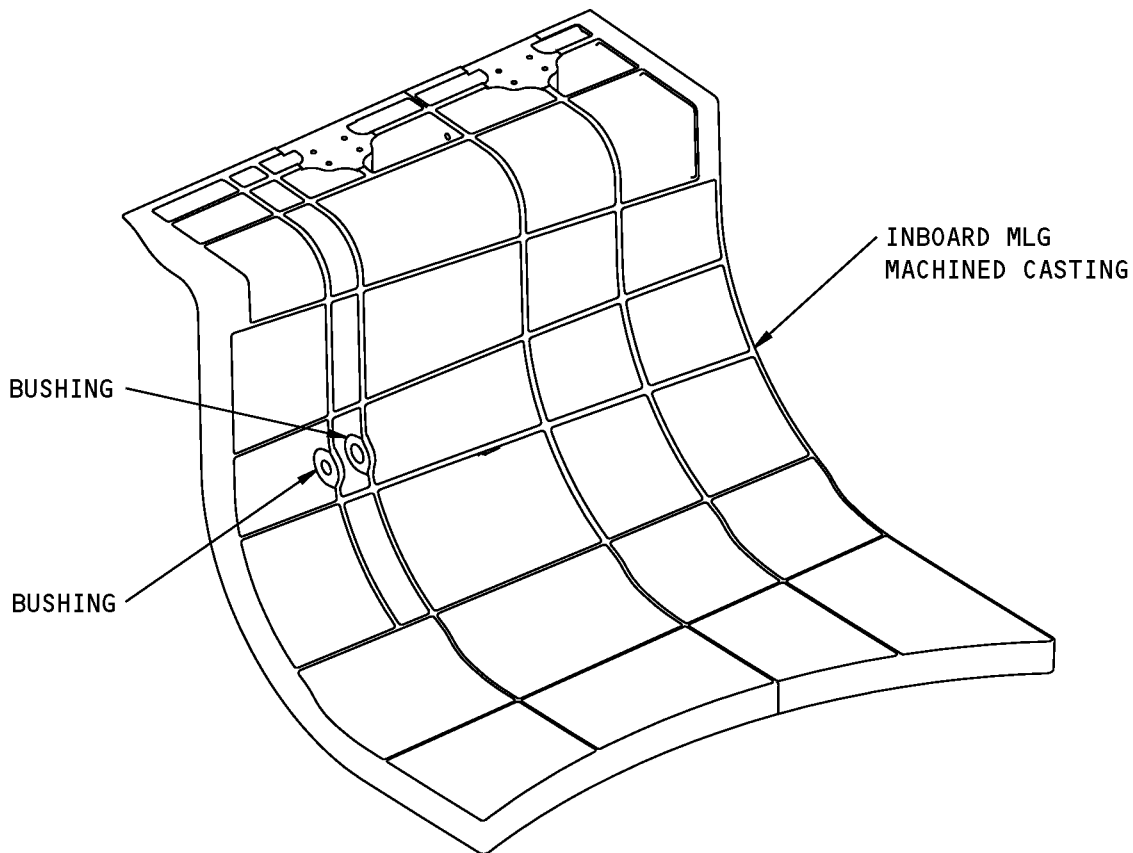
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INBOARD MAIN LANDING GEAR DOOR ASSEMBLY

Main Landing Gear Door Components
Figure 1 (Sheet 2 of 3)

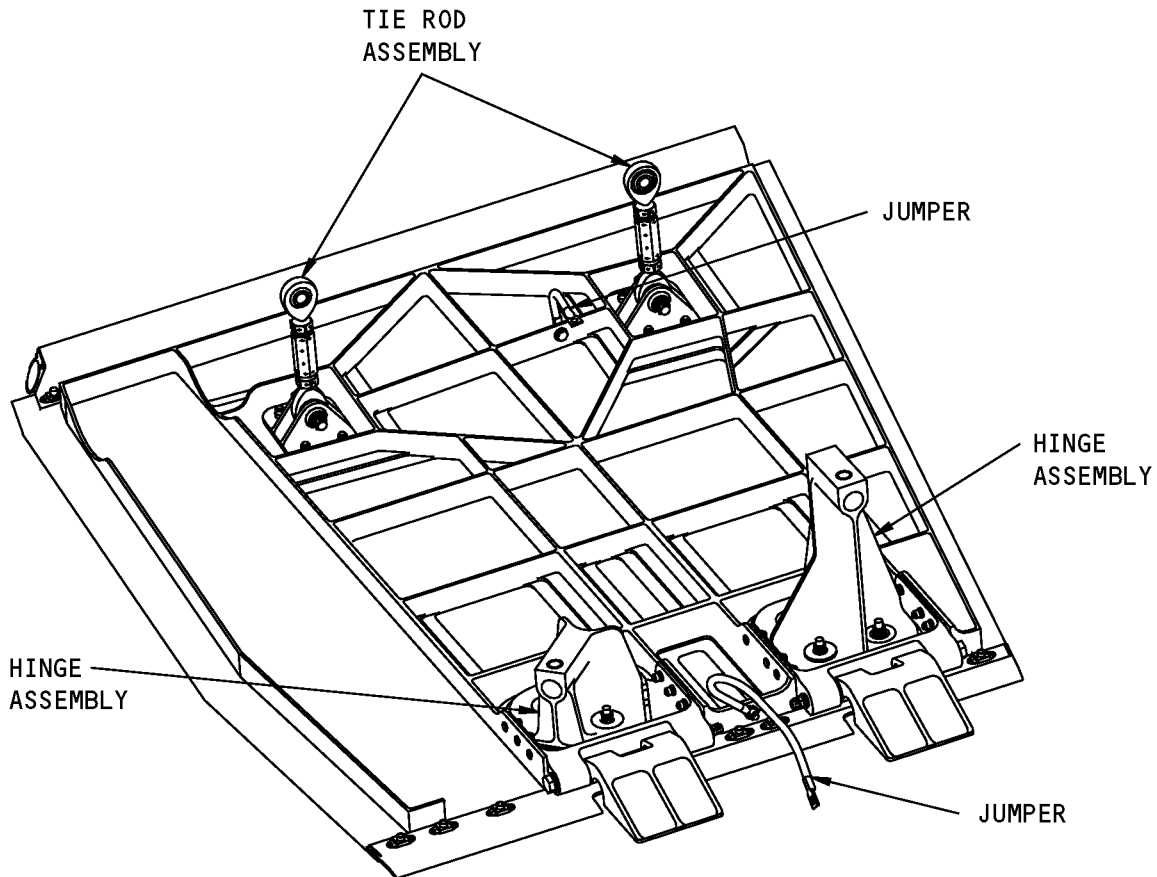
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CENTER MAIN LANDING GEAR DOOR ASSEMBLY

Main Landing Gear Door Components
Figure 1 (Sheet 3 of 3)

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TESTING AND FAULT ISOLATION

(NOT APPLICABLE)

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TESTING AND FAULT ISOLATION

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DISASSEMBLY

1. General

- A. This procedure has the data necessary to disassemble the main landing gear door components.
- B. Disassemble this component sufficiently to isolate the defects, do the necessary repairs, and put the component back to a serviceable condition.

2. Disassembly

- A. Procedure
 - (1) Use standard industry procedures and the instructions in the individual repair sections.

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DISASSEMBLY

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CLEANING

1. General

- A. This procedure has the data necessary to clean the main landing gear door components.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 4 for item numbers.

2. Cleaning

A. References

| <u>Reference</u> | <u>Title</u> |
|------------------|-------------------------------------|
| SOPM 20-30-01 | CLEANING AND RELUBRICATING BEARINGS |
| SOPM 20-30-03 | GENERAL CLEANING PROCEDURES |

B. Procedure

- (1) Clean the bearings (5, 25) as specified in SOPM 20-30-01.
- (2) Clean the other parts by standard industry procedures and the instructions in SOPM 20-30-03.

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CLEANING

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CHECK

1. General

- A. This procedure has the data necessary to find defects in the specified parts.
- B. Refer to FITS AND CLEARANCES for design dimensions and wear limits.
- C. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- D. Refer to IPL Figure 1 thru IPL Figure 6 for item numbers.

2. Check

A. References

| <u>Reference</u> | <u>Title</u> |
|------------------|---------------------------------|
| SOPM 20-20-01 | MAGNETIC PARTICLE INSPECTION |
| SOPM 20-20-02 | PENETRANT METHODS OF INSPECTION |

B. Procedure

- (1) Use standard industry procedures to do a visual check of all the parts for defects. Do the penetrant or magnetic particle check if the visual check shows possible defects.
- (2) Do a magnetic particle check (SOPM 20-20-01) of these parts:
 - (a) IPL Figure 2 - Link (60)
 - (b) IPL Figure 4 - Pushrod (30)
 - (c) IPL Figure 5 - Pushrod (30)
- (3) Do a penetrant check (SOPM 20-20-02) of these parts:
 - (a) IPL Figure 1 - Door Casting (145, 150)
 - (b) IPL Figure 1 - Hinge Fitting (85, 90, 115, 120)
 - (c) IPL Figure 2 - Fitting (305, 310)
 - (d) IPL Figure 2 - Hinge (255, 260, 410, 415)
 - (e) IPL Figure 2 - Hinge Fitting (205, 365)
 - (f) IPL Figure 3 - Door (30, 35)

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CHECK

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COMPONENT MAINTENANCE MANUAL

REPAIR

1. General

- A. Instructions for repair, refinish, and replacement of the specified subassembly parts are included in each REPAIR when applicable:

Table 601:

| PART NUMBER | NAME | REPAIR |
|---------------------------------|-------------------------|---------------|
| — | REFINISH OF OTHER PARTS | 1-1 |
| 113A8100-3 THRU -6 | OUTBOARD DOOR ASSY | 2-1 |
| 113A8140-1, -2 | FWD HINGE ASSY | 2-2 |
| 113A8140-3, -4 | FWD HINGE FITTING | 2-3 |
| 113A8141-1, -2 | AFT HINGE ASSY | 2-4 |
| 113A8141-3, -4 | AFT HINGE FITTING | 2-5 |
| 113A8200-3 THRU -8 | CENTER DOOR ASSY | 3-1 |
| 113A8221-1, -2, -5, -6, -9, -10 | SEAL RETAINER ASSY | 3-2 |
| 113A8223-5, -6 | SEAL RETAINER ASSY | 3-3 |
| 113A8240-1, -2 | FITTING ASSY | 3-4 |
| 113A8240-3, -4 | FITTING | 3-5 |
| 113A8241-1, -2 | FITTING ASSY | 3-6 |
| 113A8241-3, -4 | FITTING | 3-7 |
| 113A8245-1, -2 | CLEVIS ASSY | 3-8 |
| 113A8245-3, -4 | CLEVIS | 3-9 |
| 113A8248-1,-2, -5, -6 | HINGE ASSY | 3-10 |
| 113A8248-3, -4, -7, -8 | HINGE | 3-11 |
| 113A8341-1, -2 | HINGE FITTING ASSY | 3-12 |
| 113A8341-3, -4 | HINGE FITTING | 3-13 |
| 113A8700-1 | TIE ROD ASSY | 3-14 |
| 113A8331-1, -2 | INBOARD DOOR ASSY | 4-1 |
| 113A8331-5, -6, -7, -8 | INBOARD DOOR | 4-2 |
| 113A8500-1, -2 | OUTBOARD PUSHROD ASSY | 5-1 |
| 113A8600-3 | INBOARD PUSHROD ASSY | 6-1 |

2. Dimensioning Symbols

- A. Standard True Position Dimensioning Symbols used in the applicable repair procedures are shown in REPAIR-GENERAL, Figure 601.

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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 | Ⓜ | MAXIMUM MATERIAL CONDITION (MMC) |
| ↗↗ | TOTAL RUNOUT | Ⓛ | LEAST MATERIAL CONDITION (LMC) |
| ⊔ | COUNTERBORE OR SPOTFACE | Ⓢ | REGARDLESS OF FEATURE SIZE (RFS) |
| ∇ | COUNTERSINK | Ⓟ | PROJECTED TOLERANCE ZONE |
| ⊕ | THEORETICAL EXACT POSITION OF A FEATURE (TRUE POSITION) | FIM | FULL INDICATOR MOVEMENT |

EXAMPLES

| | | | |
|----------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------|
| $\boxed{\text{—}} \boxed{0.002}$ | STRAIGHT WITHIN 0.002 | $\boxed{\text{◎}} \boxed{\text{∅}} \boxed{0.0005} \boxed{\text{C}}$ | CONCENTRIC TO DATUM C WITHIN 0.0005 DIAMETER |
| $\boxed{\text{⊥}} \boxed{0.002} \boxed{\text{B}}$ | PERPENDICULAR TO DATUM B WITHIN 0.002 | $\boxed{\text{≡}} \boxed{0.010} \boxed{\text{A}}$ | SYMMETRICAL WITH DATUM A WITHIN 0.010 |
| $\boxed{\text{//}} \boxed{0.002} \boxed{\text{A}}$ | PARALLEL TO DATUM A WITHIN 0.002 | $\boxed{\text{∠}} \boxed{0.005} \boxed{\text{A}}$ | ANGULAR TOLERANCE 0.005 WITH DATUM A |
| $\boxed{\text{○}} \boxed{0.002}$ | ROUND WITHIN 0.002 | $\boxed{\text{⊕}} \boxed{\text{∅}} \boxed{0.002} \boxed{\text{Ⓢ}} \boxed{\text{B}}$ | LOCATED AT TRUE POSITION WITHIN 0.002 DIA RELATIVE TO DATUM B, REGARDLESS OF FEATURE SIZE |
| $\boxed{\text{⊘}} \boxed{0.010}$ | CYLINDRICAL SURFACE MUST LIE BETWEEN TWO CONCENTRIC CYLINDERS, ONE OF WHICH HAS A RADIUS 0.010 INCH GREATER THAN THE OTHER | $\boxed{\text{⊥}} \boxed{\text{∅}} \boxed{0.010} \boxed{\text{Ⓜ}} \boxed{\text{A}}$ | 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 |
| $\boxed{\text{⌒}} \boxed{0.006} \boxed{\text{A}}$ | EACH LINE ELEMENT OF THE SURFACE AT ANY CROSS SECTION MUST LIE BETWEEN TWO PROFILE BOUNDARIES 0.006 INCH APART RELATIVE TO DATUM A | $\boxed{0.510} \boxed{\text{Ⓟ}}$ | |
| $\boxed{\text{⌓}} \boxed{0.020} \boxed{\text{A}}$ | SURFACES MUST LIE WITHIN PARALLEL BOUNDARIES 0.020 INCH APART AND EQUALLY DISPOSED ABOUT TRUE PROFILE | $\boxed{2.000}$ | 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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COMPONENT MAINTENANCE MANUAL

REFINISH OF OTHER PARTS - REPAIR 1-1

1. General

- A. This procedure tells how to refinish the parts which are not in the other repairs.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 1 thru IPL Figure 5 for item numbers.

2. Refinish of Other Parts

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

| Reference | Description | Specification |
|-----------|----------------------------------------------------------------------------------|-------------------------------------------------|
| C00033 | Coating - Exterior Protective Enamel, Flexibility Use | BMS10-60, Type II |
| C00064 | Coating - Aluminum Chemical Conversion | BAC5719, Type II, Class A (MIL-C-5541, Class A) |
| C00175 | Primer - Urethane Compatible, Corrosion Resistant (Less Than 1% Aromatic Amines) | BMS10-79, Type III |
| C00259 | Primer - Chemical And Solvent Resistant Finish, Epoxy Resin | BMS10-11, Type I |
| D00113 | Lubricant - Liquid Dispersed Solid Film Lubricant | BMS3-8, BAC 5811, TYPE VIII |

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 |
| SOPM 20-60-03 | LUBRICANTS |

C. Procedure

NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02. For lubricants, refer to SOPM 20-60-03.

- (1) Instructions for the repair of these parts is only replacement of the original finish.
- (2) Refer to REPAIR 1-1, Table 601 for the refinish details.

Table 601: Refinish Details

| IPL FIG. & ITEM | MATERIAL | FINISH |
|-------------------------|----------|--------------------------------------|
| IPL Fig. 1 | | |
| Door casting (145, 150) | Al alloy | (F-17.31) + primer, C00175 (F-19.47) |

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REPAIR 1-1
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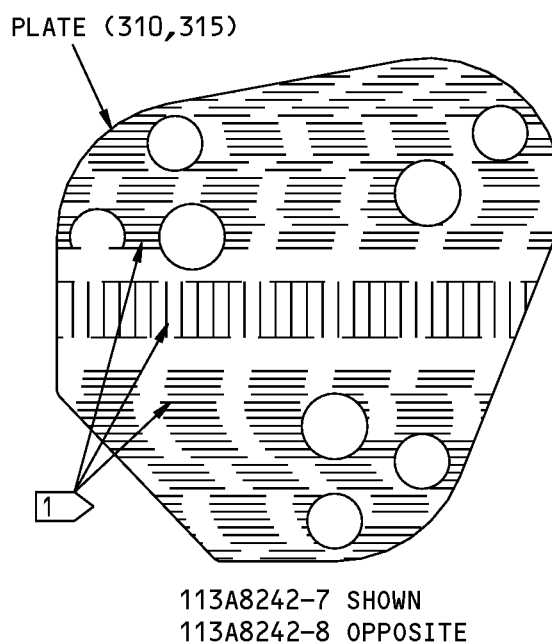
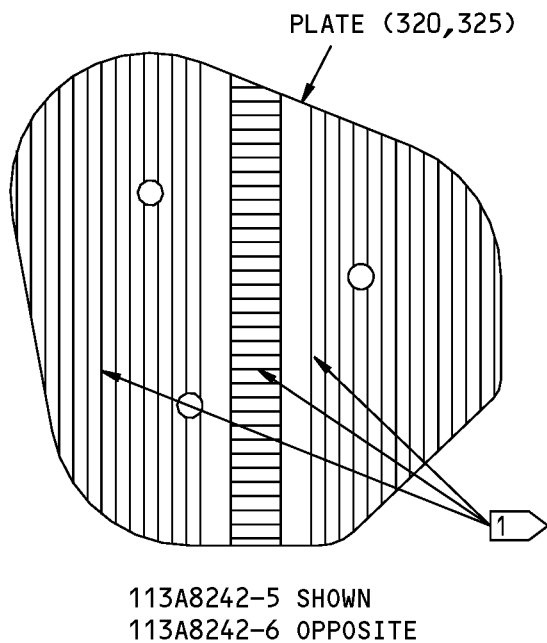
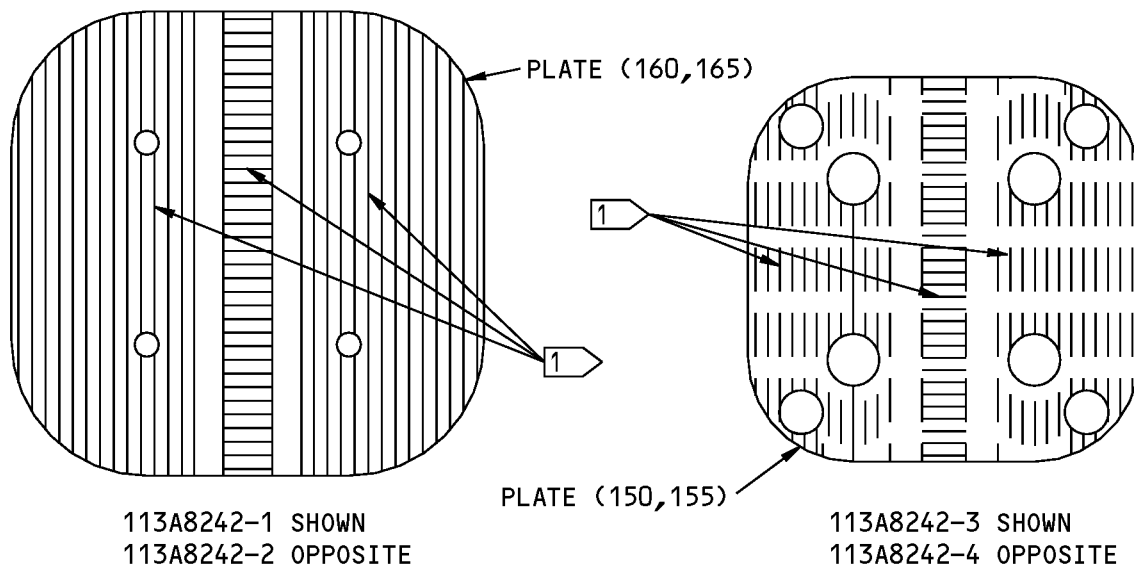


COMPONENT MAINTENANCE MANUAL

Table 601: Refinish Details (Continued)

| IPL FIG. & ITEM | MATERIAL | FINISH |
|-------------------------------------------|----------------------------|---------------------------------------------------------------------------------------------------------------------|
| IPL Fig. 2 | | |
| Seal retainer (495, 500) | Al alloy | coating, C00064 (F-17.07) + primer, C00175 (F-19.47) + enamel coating, C00033 (F-19.39-707) |
| Seal retainer (450, 455) | Al alloy | (F-17.31) + primer, C00175 (F-19.47) + enamel coating, C00033 (F-19.39-707) |
| Door casting (555, 560) | Al alloy | (F-17.31) + primer, C00175 (F-19.47) |
| Plate (150,155,160, 165,310,315,320, 325) | Al alloy | (F-17.31) + primer, C00259 (F-20.02) + enamel coating, C00033 (F-19.39-707) unless shown in REPAIR 1-1, Figure 601. |
| Washer (280) | 15-5PH CRES 180-200 ksi | (F-16.06) + primer, C00259 (F-20.02) |
| Link (60) | 15-5PH CRES 125-145 ksi | (F-17.25). On 113A8243-1 only, apply lubricant, D00113 (F-19.10) on threads. |
| IPL Fig. 4 | | |
| Washer (15) | 15-5PH CRES 125-145 ksi | (F-17.25) |
| Tube (30) | 17-7PH CRES 150-170 ksi | (F-17.25) |

COMPONENT MAINTENANCE MANUAL



1 APPLY ONE LAYER OF PRIMER ONLY. NO OVERSPRAY IS PERMITTED. DO NOT APPLY ENAMEL IN THE SERRATIONS.

ITEM NUMBERS REFER TO IPL FIG. 2
ALL DIMENSIONS ARE IN INCHES

113A8242-1 Thru -8 Plate Refinish
Figure 601

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COMPONENT MAINTENANCE MANUAL

OUTBOARD DOOR ASSEMBLY - REPAIR 2-1

113A8100-3, -4, -5, -6

1. General

- A. This procedure tells how to repair the outboard door assembly.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols used in the repair.
- D. Refer to IPL Figure 1 or IPL Figure 6 for item numbers, as applicable.

2. Assembly

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

| <u>Reference</u> | <u>Description</u> | <u>Specification</u> |
|------------------|-------------------------------------------------------------|----------------------|
| A00188 | Adhesive - Urethane, Two Component | BMS5-105 Type V |
| A00247 | Sealant - Pressure And Environmental - Chromate Type | BMS 5-95 |
| C00259 | Primer - Chemical And Solvent Resistant Finish, Epoxy Resin | BMS10-11, Type I |

B. References

| <u>Reference</u> | <u>Title</u> |
|------------------|---------------------------|
| SOPM 20-50-01 | BOLT AND NUT INSTALLATION |
| SOPM 20-50-12 | APPLICATION OF ADHESIVES |
| SOPM 20-50-19 | GENERAL SEALING |
| SOPM 20-60-02 | FINISHING MATERIALS |
| SOPM 20-60-04 | MISCELLANEOUS MATERIALS |

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

NOTE: For finishing materials, refer to SOPM 20-60-02. For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Use standard industry practices and these steps.
- (2) Bond replacement grommets to the door casting with Type 82 adhesive, A00188 (SOPM 20-50-12) as shown.
- (3) Hinges
 - (a) To keep the correct hinge centerline, do not remove more than one hinge at a time. Identify the thickness and location of all shims to help during assembly.
 - (b) At the interfaces noted by flagnote 3, use shims as necessary to get the 0.0050-inch gap. Apply primer, C00259 before fastener installation. Apply sealant, A00247 (SOPM 20-50-19).

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REPAIR 2-1

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- (c) For fasteners noted by flagnote 4, install with wet sealant, A00247 (SOPM 20-50-01 and SOPM 20-50-19).

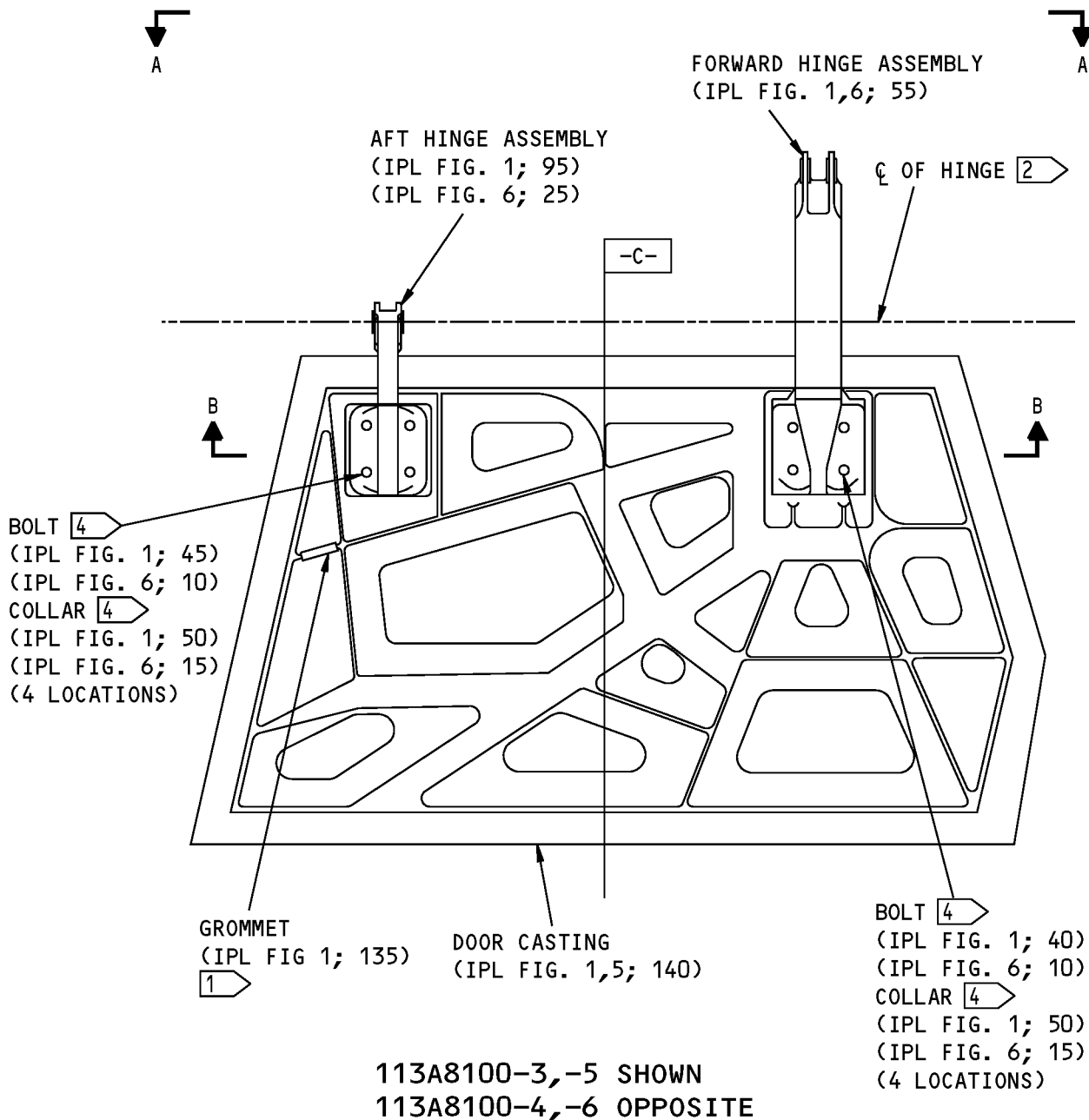
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REPAIR 2-1

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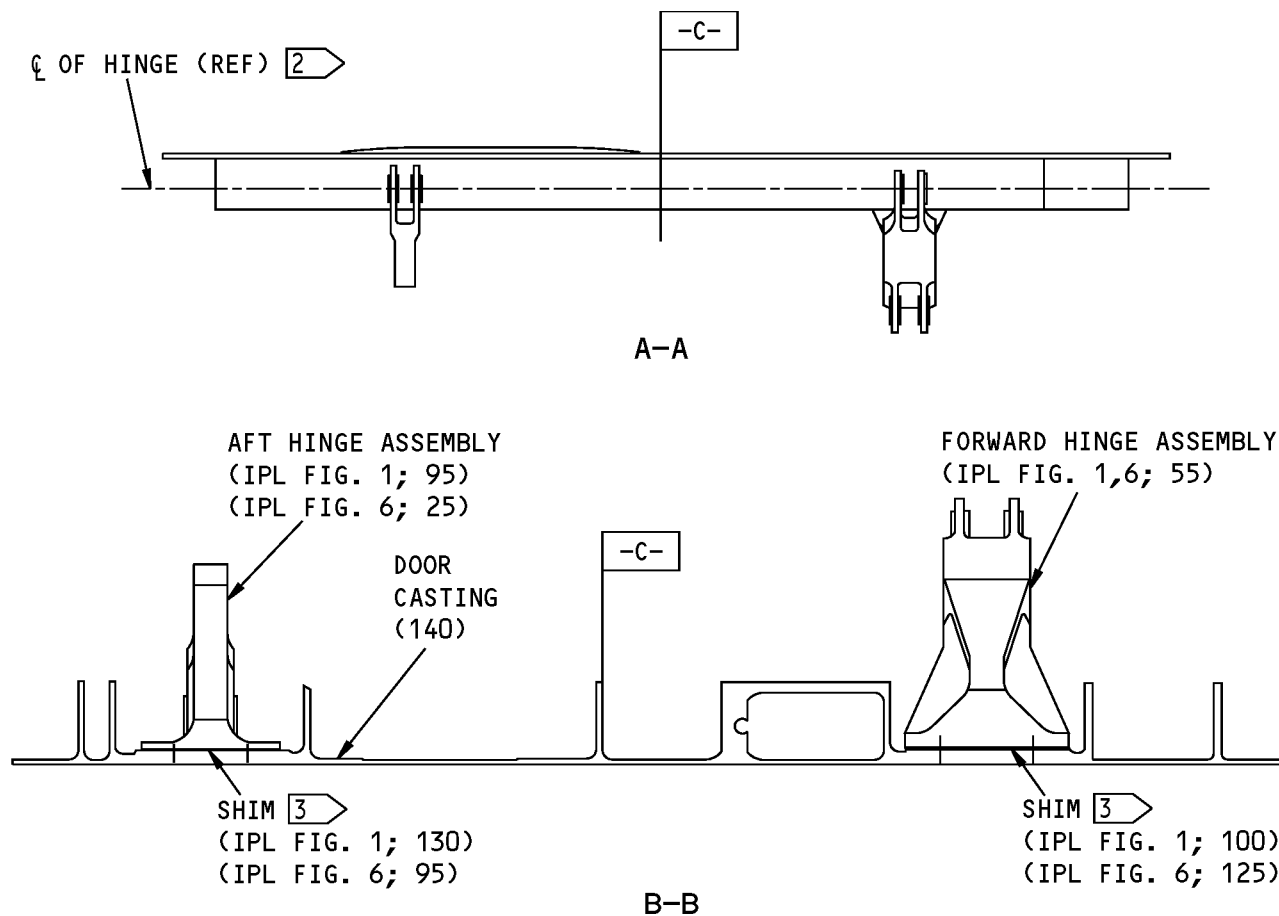
COMPONENT MAINTENANCE MANUAL



113A8100-3 Thru -6 Outboard Door Assembly Repair
Figure 601 (Sheet 1 of 2)

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1 BOND TO THE DOOR CASTING WITH TYPE 82 ADHESIVE (SOPM 20-50-12) THE LOCATION IS APPROXIMATE

4 INSTALL THE FASTENER WITH BMS 5-95 SEALANT (SOPM 20-50-19, METHOD 2)

2 TO KEEP THE HINGE LINE, BE SURE TO REPLACE ONLY ONE HINGE AT A TIME

3 SHIM TO ALIGN BORES WITH THE HINGE CENTERLINE. REMOVE LAMINATIONS AND TAPER AS NECESSARY. THE MAXIMUM PERMITTED GAP IS 0.0050 INCH. APPLY BMS 10-11, TYPE 1 PRIMER BEFORE FASTENER INSTALLATION. APPLY BMS 5-95 FAY SURFACE SEALANT (SOPM 20-50-19)

113A8100-3 Thru -6 Outboard Door Assembly Repair
Figure 601 (Sheet 2 of 2)

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COMPONENT MAINTENANCE MANUAL

FORWARD HINGE ASSEMBLY - REPAIR 2-2

113A8140-1, -2

1. General

- A. This procedure has the data necessary to repair the forward hinge assembly (55, 60).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols used in the repair.
- D. Refer to IPL Figure 1 for item numbers.

2. Bushing Replacement

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

| <u>Reference</u> | <u>Description</u> | <u>Specification</u> |
|------------------|------------------------------------------------------|----------------------|
| A00247 | Sealant - Pressure And Environmental - Chromate Type | BMS 5-95 |

- B. References

| <u>Reference</u> | <u>Title</u> |
|------------------|----------------------------------|
| SOPM 20-30-02 | STRIPPING OF PROTECTIVE FINISHES |
| SOPM 20-50-03 | BEARING AND BUSHING REPLACEMENT |
| SOPM 20-60-04 | MISCELLANEOUS MATERIALS |

- C. Procedure REPAIR 2-2, Figure 601

NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Remove the old bushings (65, 70, 75, 80) from the forward hinge assembly (55, 60) (SOPM 20-50-03).
- (2) Use the shrink-fit procedure of SOPM 20-50-03 to install replacement bushings with wet sealant, A00247.
- (3) Machine the bushings to the dimensions shown.

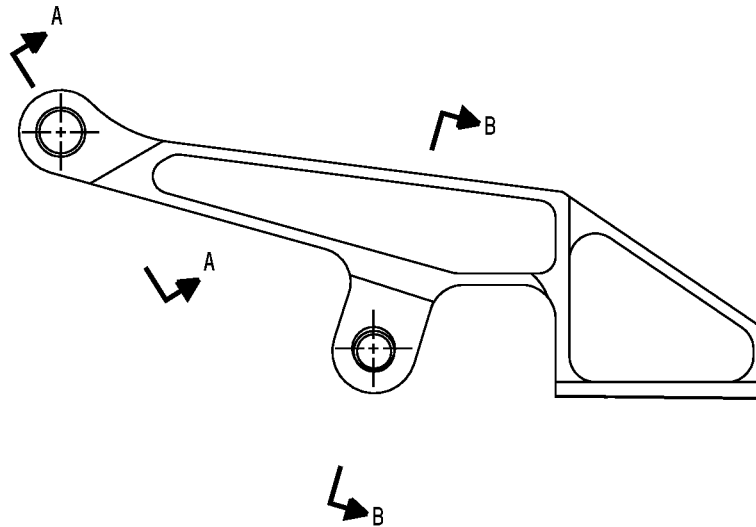
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REPAIR 2-2

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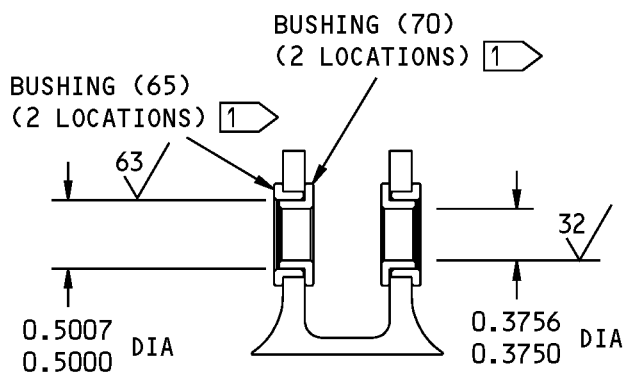
113A8140-1 SHOWN
113A8140-2 OPPOSITE

113A8140-1,-2 Forward Hinge Fitting Assembly Repair
Figure 601 (Sheet 1 of 2)

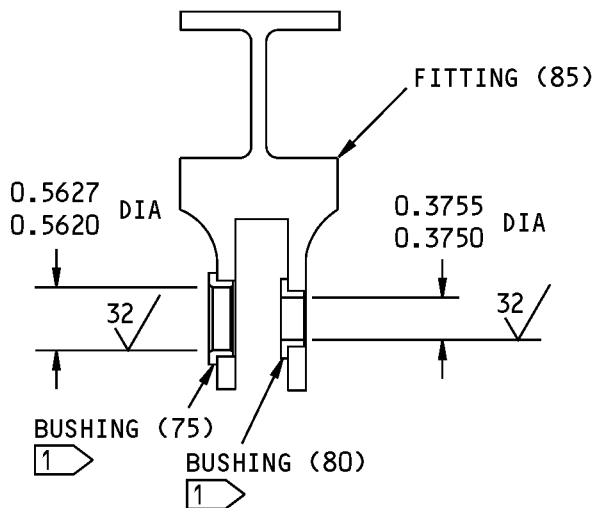
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REPAIR 2-2
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COMPONENT MAINTENANCE MANUAL



ROTATED COUNTERCLOCKWISE 30.1°
A-A



ROTATED COUNTERCLOCKWISE 17.7°
B-B

1 USE THE SHRINK-FIT PROCEDURE TO
INSTALL THE BUSHING WITH WET
BMS 5-95 SEALANT

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

113A8140-1,-2 Forward Hinge Fitting Assembly Repair
Figure 601 (Sheet 2 of 2)

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REPAIR 2-2
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COMPONENT MAINTENANCE MANUAL

FORWARD HINGE FITTING - REPAIR 2-3

113A8140-3, -4

1. General

- A. This procedure has the data necessary to refinish the forward hinge fitting (85, 90).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols used in the repair.
- D. Refer to IPL Figure 1 for item numbers.
- E. General repair details:
 - (1) Material: Aluminum alloy
 - (2) Shot peen: All surfaces, but not in holes, Intensity 0.005-0.010A2, Overspray is permitted.

2. Repair procedures

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

| Reference | Description | Specification |
|-----------|----------------------------------------------------------------|---------------------|
| C00032 | Coating - Exterior Protective Enamel, General Use | BMS10-60, Type I |
| C00259 | Primer - Chemical And Solvent Resistant Finish, Epoxy Resin | BMS10-11, Type I |

- B. References

| Reference | Title |
|---------------|----------------------------------------|
| SOPM 20-10-03 | SHOT PEENING |
| 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. Forward Hinge Fitting Refinish (REPAIR 2-3, Figure 601)

NOTE: For shotpeening, refer to SOPM 20-10-03. For stripping of protective finishes, refer to SOPM 20-30-02. For decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Boric acid-sulfuric acid anodize (F-17.31). Apply primer, C00259 (F-20.02) and enamel coating, C00032 (F-14.9813, which replaces SRF-14.9813) unless shown.

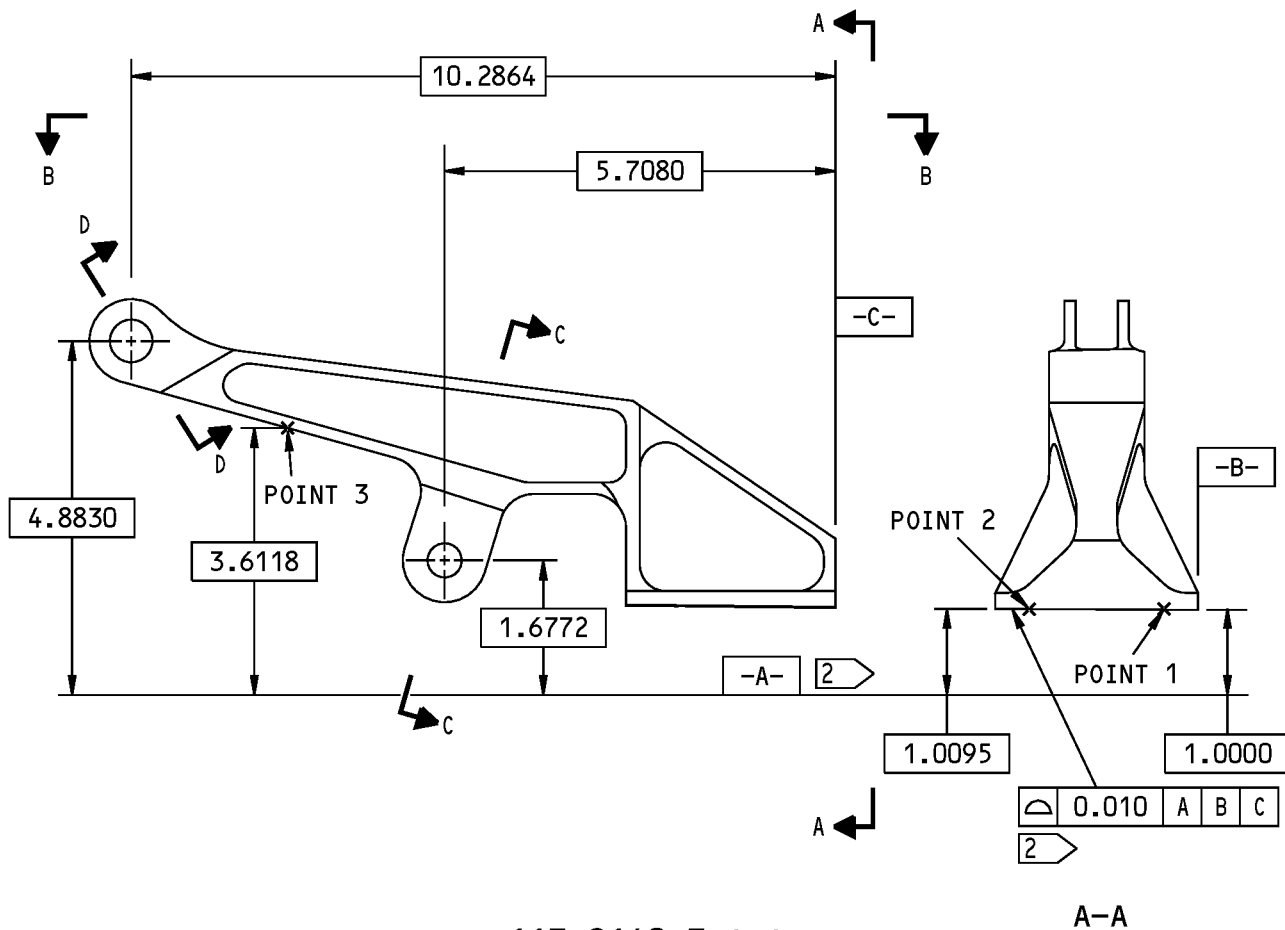
32-13-23

REPAIR 2-3

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COMPONENT MAINTENANCE MANUAL



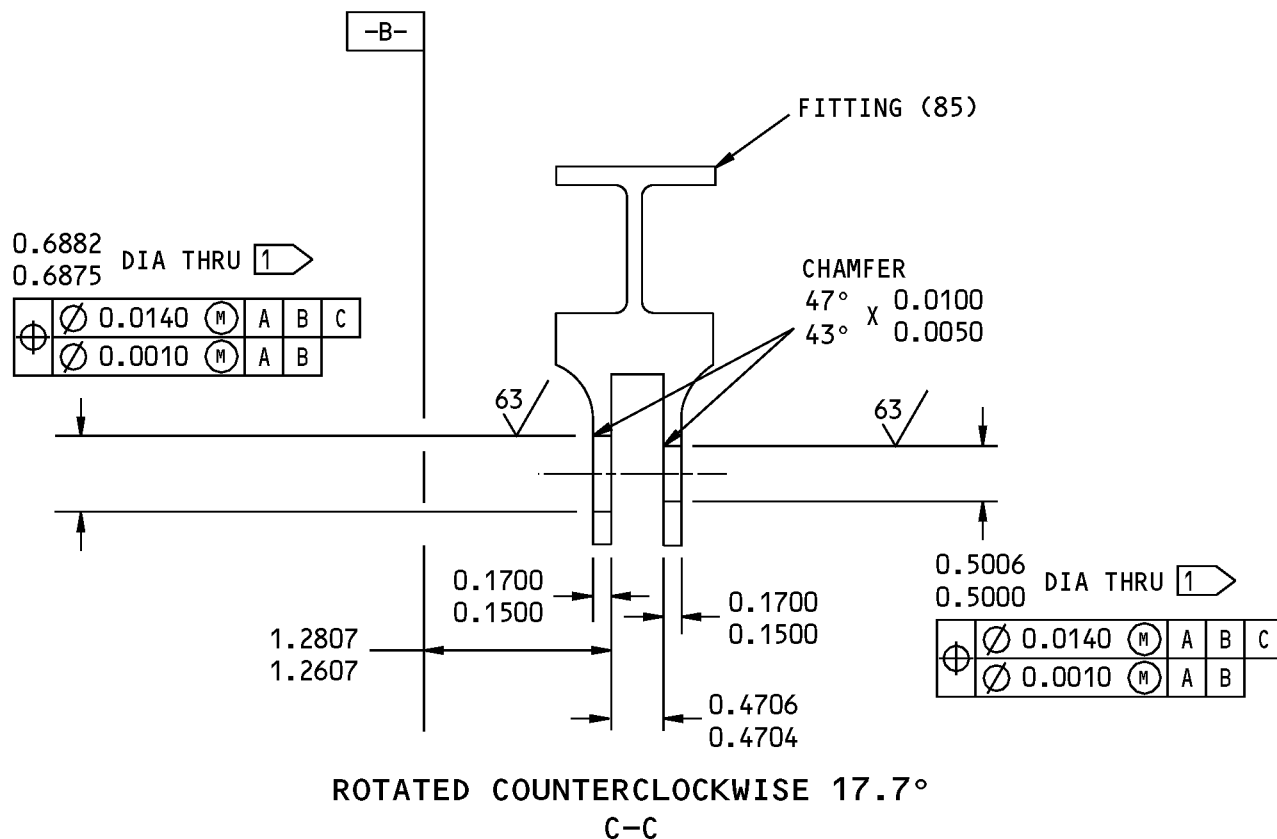
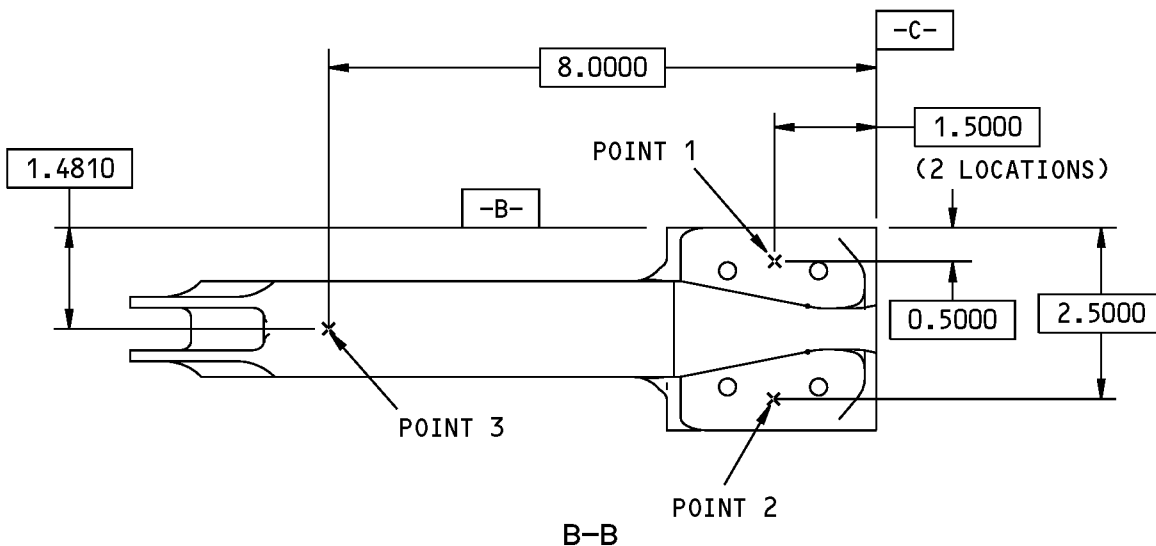
113A8140-3 SHOWN
113A8140-4 OPPOSITE

113A8140-3,4 Forward Hinge Fitting Repair
Figure 601 (Sheet 1 of 3)

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REPAIR 2-3
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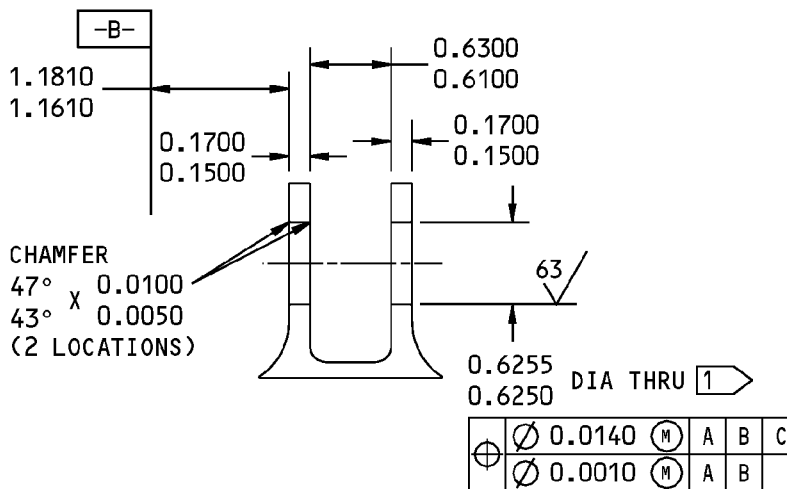
COMPONENT MAINTENANCE MANUAL



113A8140-3,-4 Forward Hinge Fitting Repair
Figure 601 (Sheet 2 of 3)

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COMPONENT MAINTENANCE MANUAL



ROTATED CLOCKWISE 17.7°
D-D

- 1 DO NOT APPLY BMS 10-11, TYPE 1 PRIMER OR BMS 10-60 ENAMEL IN THE HOLE
- 2 THIS PLANAR SURFACE IS DEFINED BY DATUM TARGETS POINTS 1,2,3

125/63 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

113A8140-3,-4 Forward Hinge Fitting Repair
Figure 601 (Sheet 3 of 3)

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REPAIR 2-3

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COMPONENT MAINTENANCE MANUAL

AFT HINGE ASSEMBLY - REPAIR 2-4

113A8141-1, -2

1. General

- A. This procedure has the data necessary to repair the aft hinge (95, 100).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols used in the repair.
- D. Refer to IPL Figure 1 for item numbers.

2. Repair procedures

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

| <u>Reference</u> | <u>Description</u> | <u>Specification</u> |
|------------------|------------------------------------------------------|----------------------|
| A00247 | Sealant - Pressure And Environmental - Chromate Type | BMS 5-95 |

- B. References

| <u>Reference</u> | <u>Title</u> |
|------------------|----------------------------------|
| SOPM 20-30-02 | STRIPPING OF PROTECTIVE FINISHES |
| SOPM 20-50-03 | BEARING AND BUSHING REPLACEMENT |
| SOPM 20-60-04 | MISCELLANEOUS MATERIALS |

- C. Bushing Replacement (REPAIR 2-4, Figure 601)

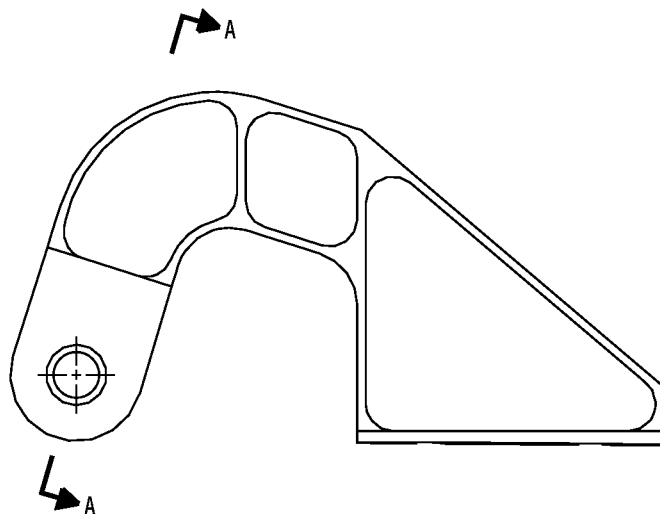
NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Remove the old bushings (105, 110) from the aft hinge assy (95, 100) (SOPM 20-50-03).
- (2) Use the shrink-fit procedure of SOPM 20-50-03 to install replacement bushings with wet sealant, A00247.
- (3) Machine the bushings to the design dimensions shown.

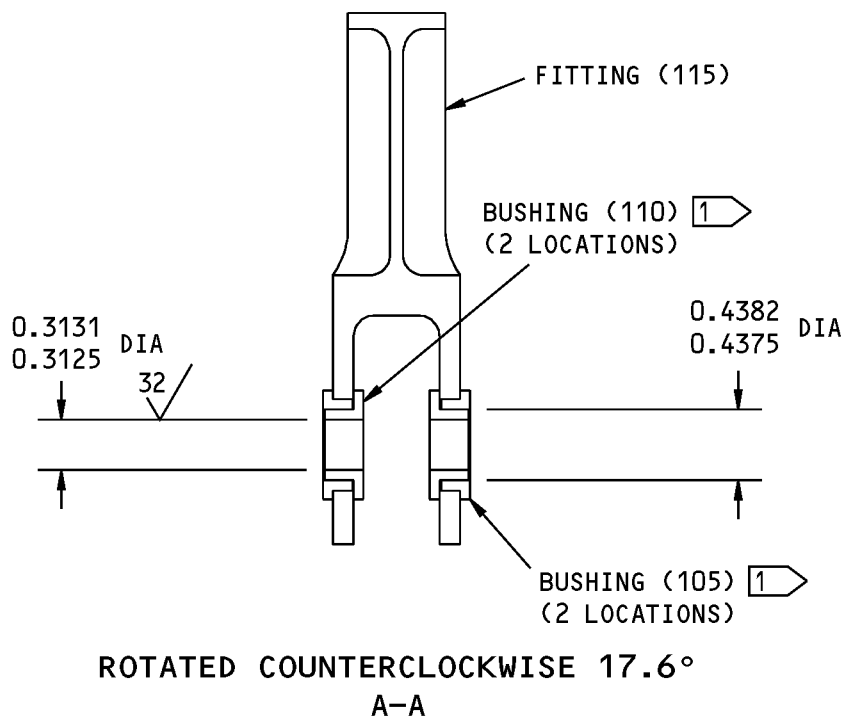
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REPAIR 2-4
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COMPONENT MAINTENANCE MANUAL



113A8141-1 SHOWN
113A8141-2 OPPOSITE



1 USE THE SHRINK-FIT PROCEDURE TO
INSTALL THE BUSHINGS WITH WET
BMS 5-95 SEALANT

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

113A8141-1,-2 Aft Hinge Fitting Assembly Repair
Figure 601

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REPAIR 2-4
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COMPONENT MAINTENANCE MANUAL

AFT HINGE FITTING - REPAIR 2-5

113A8141-3, -4

1. General

- A. This procedure has the data necessary to refinish the aft hinge fitting (115, 120).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols used in the repair.
- D. Refer to IPL Figure 1 for item numbers.
- E. General repair details:
 - (1) Material: Aluminum alloy
 - (2) Shot peen: All surfaces, but not in holes
Intensity 0.004-0.007A2

2. Repair Procedures

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

| Reference | Description | Specification |
|-----------|----------------------------------------------------------------|---------------------|
| C00032 | Coating - Exterior Protective Enamel, General Use | BMS10-60, Type I |
| C00259 | Primer - Chemical And Solvent Resistant Finish, Epoxy Resin | BMS10-11, Type I |

- B. References

| Reference | Title |
|---------------|----------------------------------------|
| SOPM 20-10-03 | SHOT PEENING |
| 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. Aft Hinge Fitting Refinish (REPAIR 2-5, Figure 601)

NOTE: For shotpeening, refer to SOPM 20-10-03. For stripping of protective finishes, refer to SOPM 20-30-02. For decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Boric acid-sulfuric acid anodize (F-17.37). Apply primer, C00259 (F-20.02) and enamel coating, C00032 (F-14.9813, which replaces SRF-14.9813) unless shown.

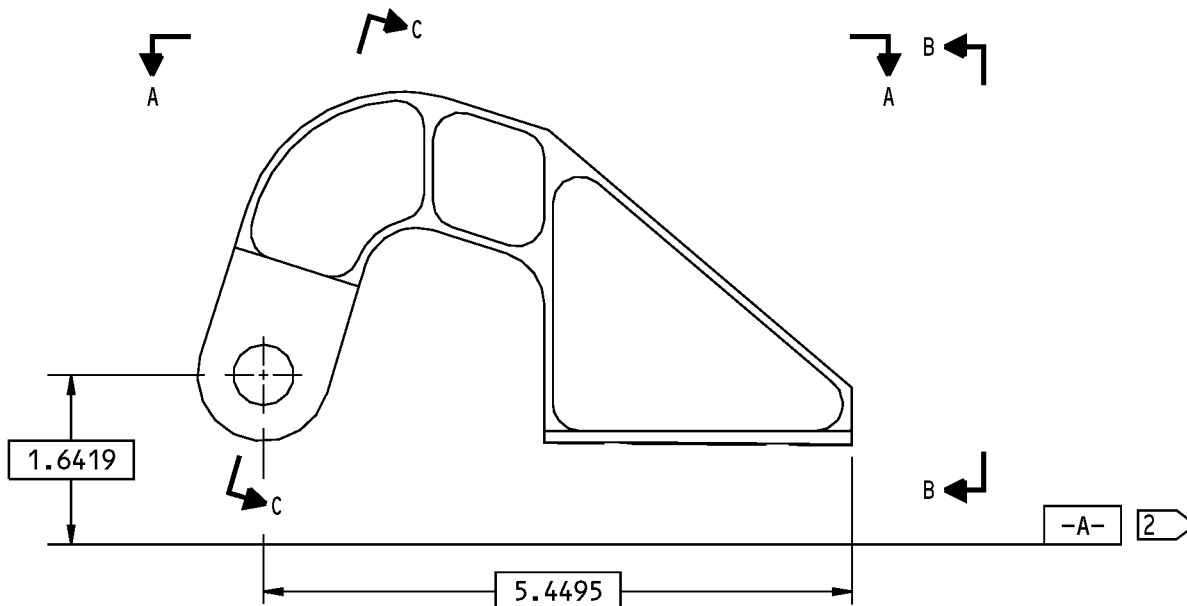
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REPAIR 2-5

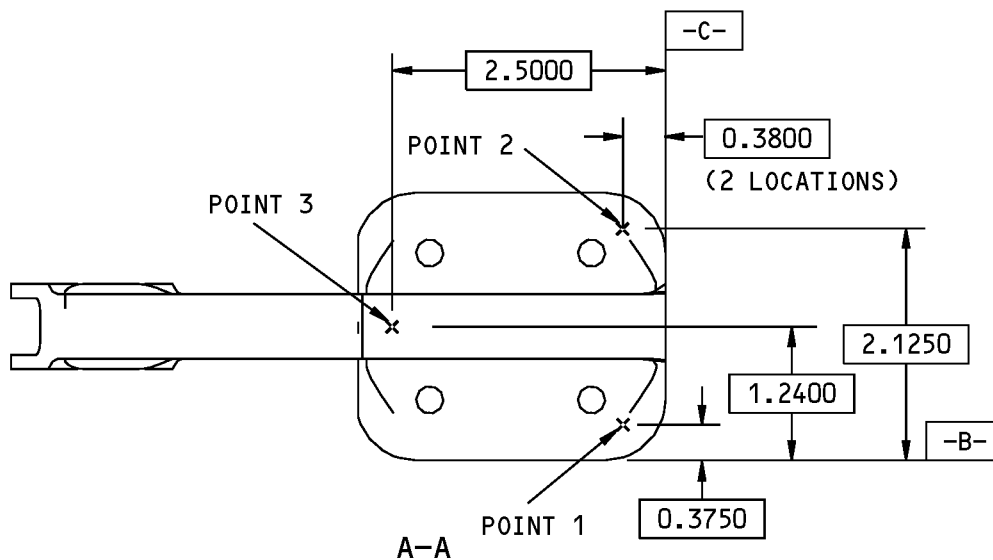
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113A8141-3 SHOWN
113A8141-4 OPPOSITE

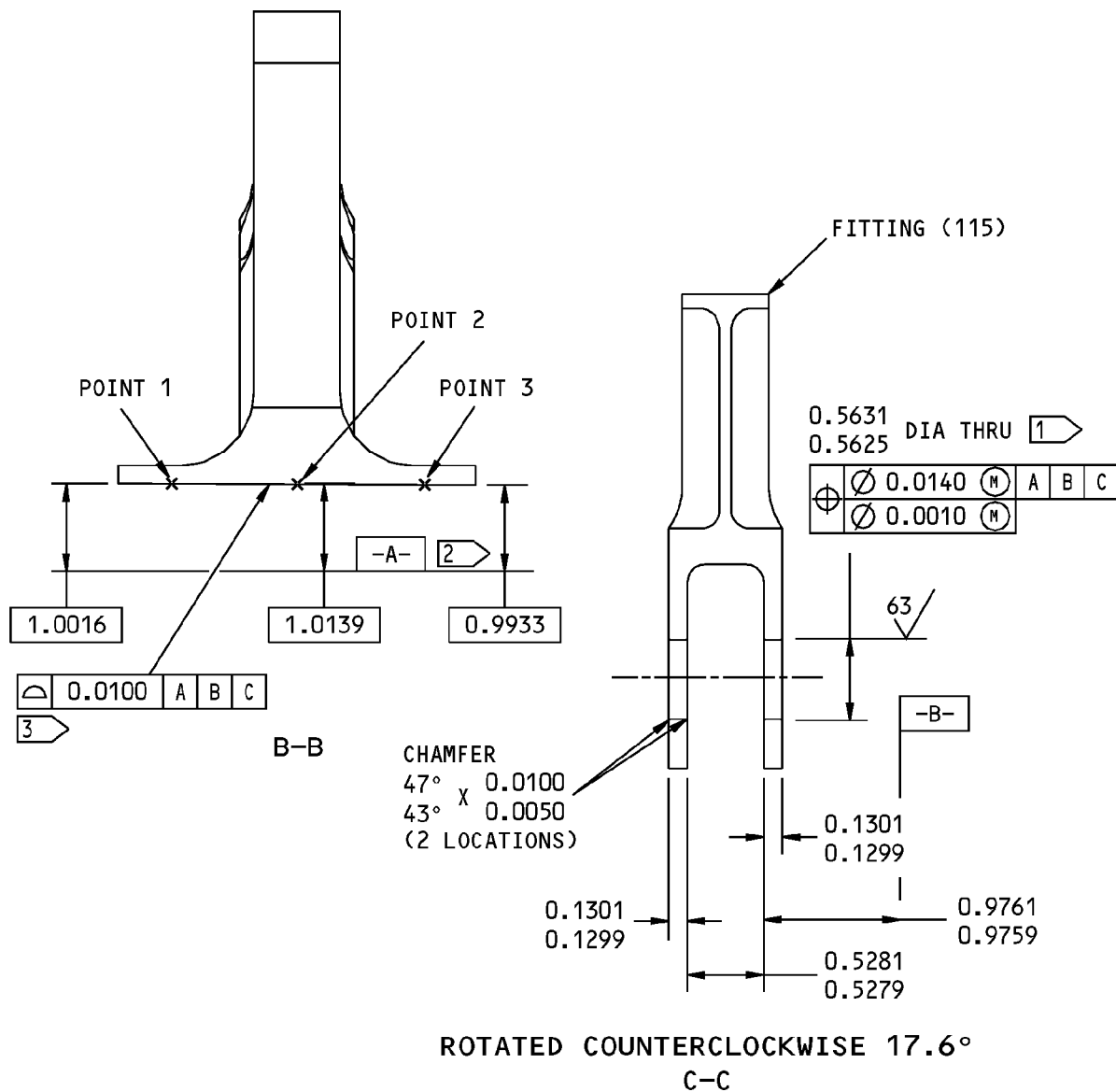


113A8141-3,-4 Aft Hinge Fitting Repair
Figure 601 (Sheet 1 of 2)

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REPAIR 2-5
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- 1 DO NOT APPLY BMS 10-11, TYPE 1 PRIMER OR BMS 10-60 ENAMEL IN THE HOLE.
- 2 THIS PLANAR SURFACE IS DEFINED BY DATUM TARGETS POINTS 1,2,3.

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES
ITEM NUMBERS REFER TO IPL FIG. 1
ALL DIMENSIONS ARE IN INCHES

113A8141-3,-4 Aft Hinge Fitting Repair
Figure 601 (Sheet 2 of 2)

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CENTER DOOR ASSEMBLY - REPAIR 3-1

113A8200-3, -4, -5, -6, -7, -8

1. General

- A. This procedure tells how to repair the center door assembly.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols used in the repair.
- D. Refer to IPL Figure 2 for item numbers.

2. Assembly

- A. Procedure (REPAIR 3-1, Figure 601)
 - (1) Use standard industry procedures and these steps.
 - (2) To keep the correct hinge centerline, do not remove more than one hinge at a time. Identify the thickness and location of all shims to help during assembly.

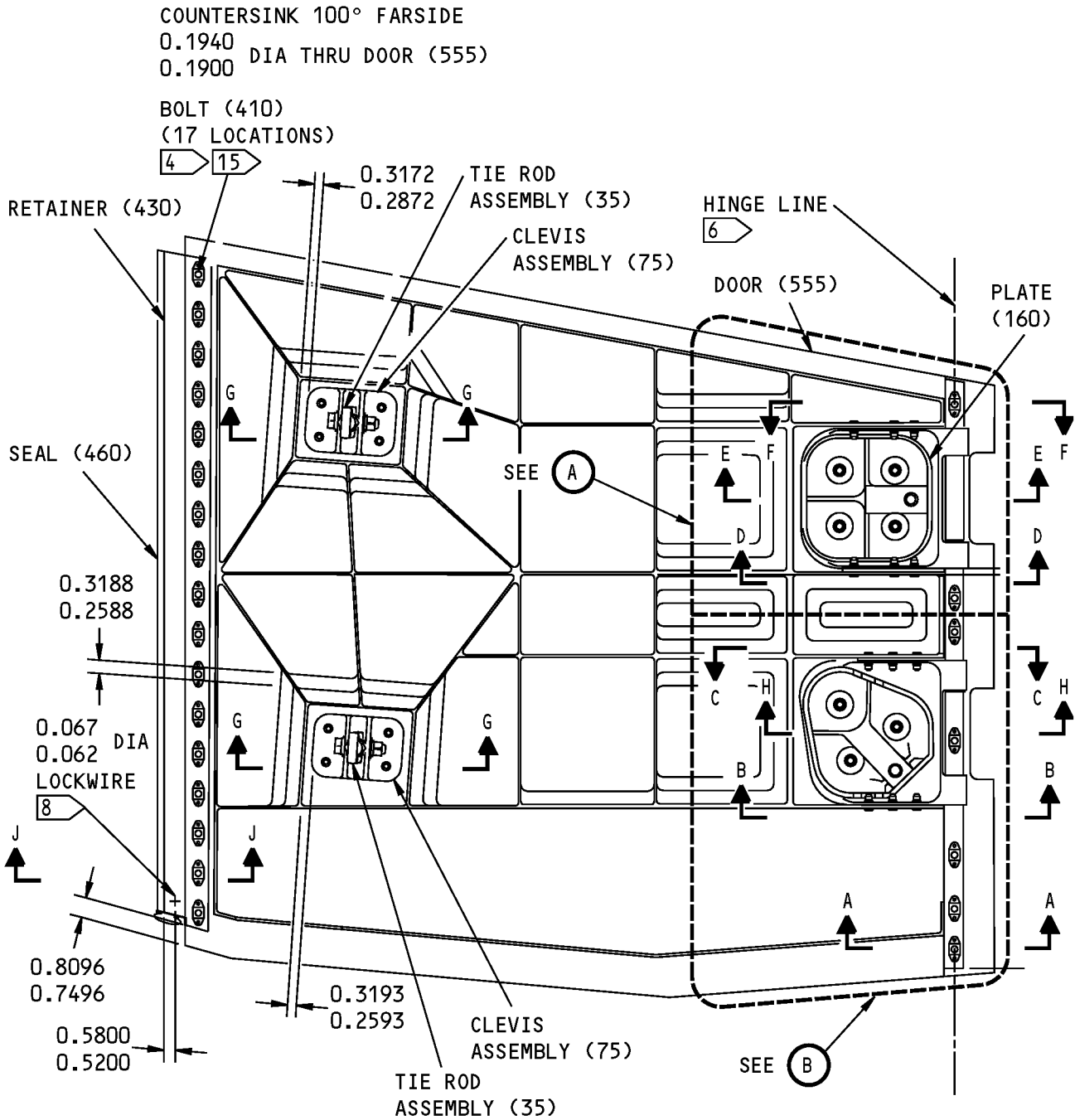
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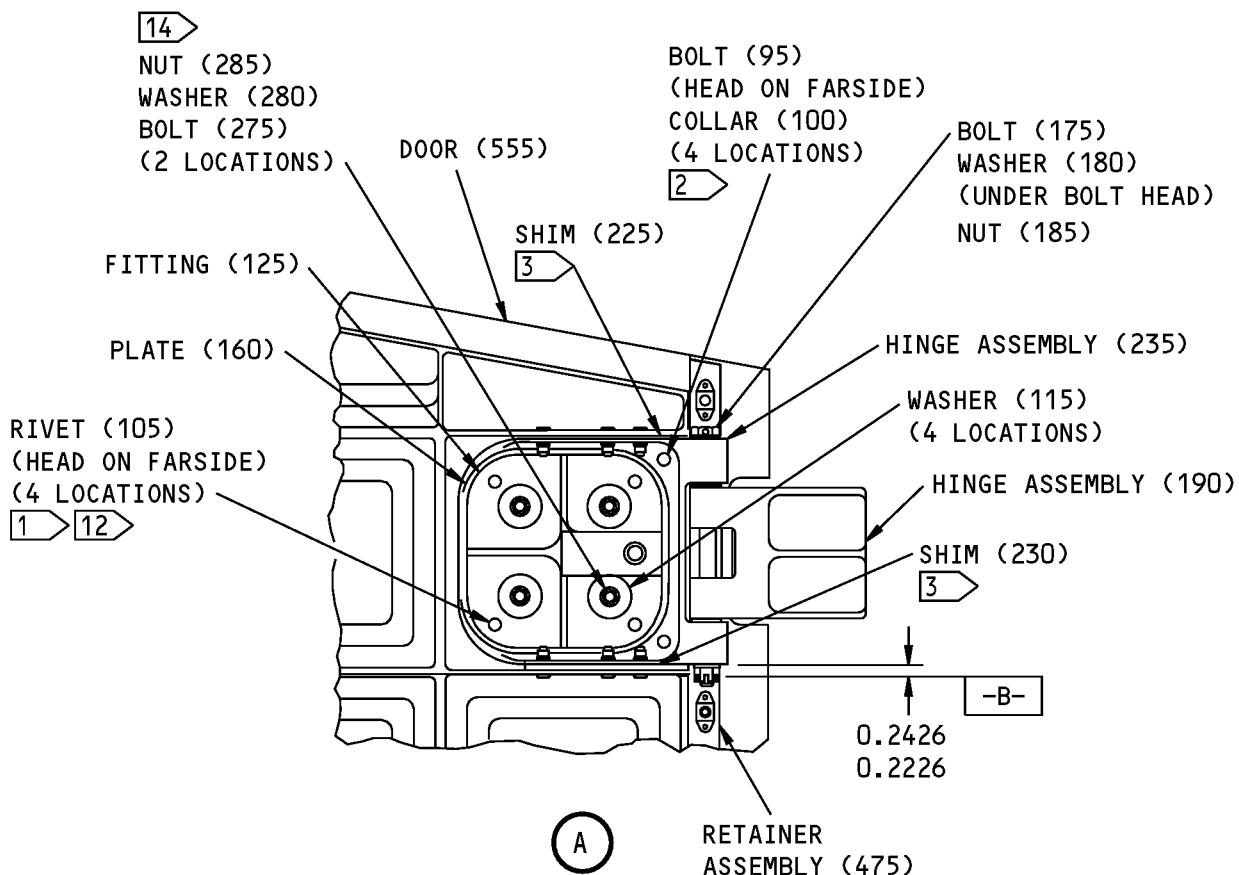
**113A8200-3, -5, -7 SHOWN
113A8200-4, -6, -8 OPPOSITE
(ATTACHMENT HARDWARE NOT SHOWN)**

113A8200-3 Thru -8 Center Door Assembly Repair
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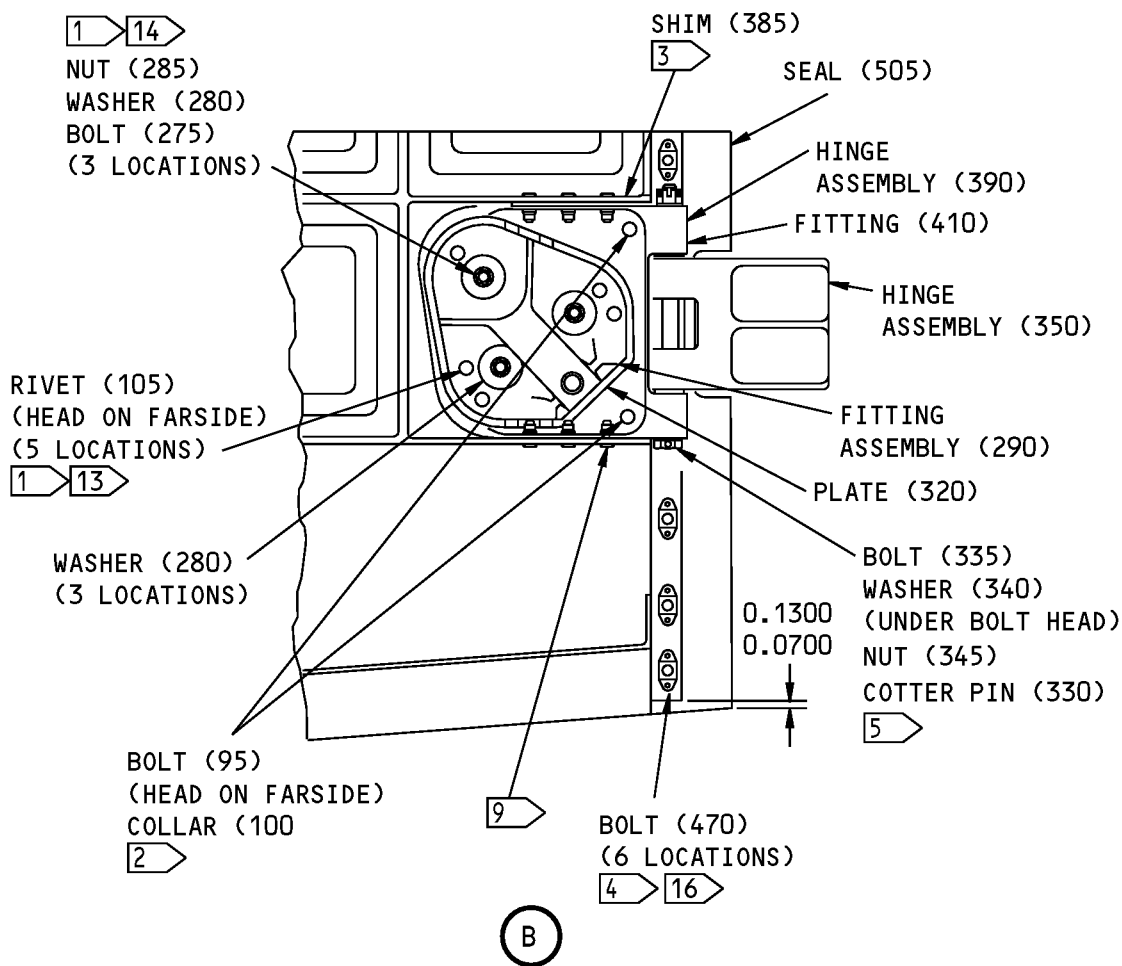


113A8200-3 Thru -8 Center Door Assembly Repair
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REPAIR 3-1
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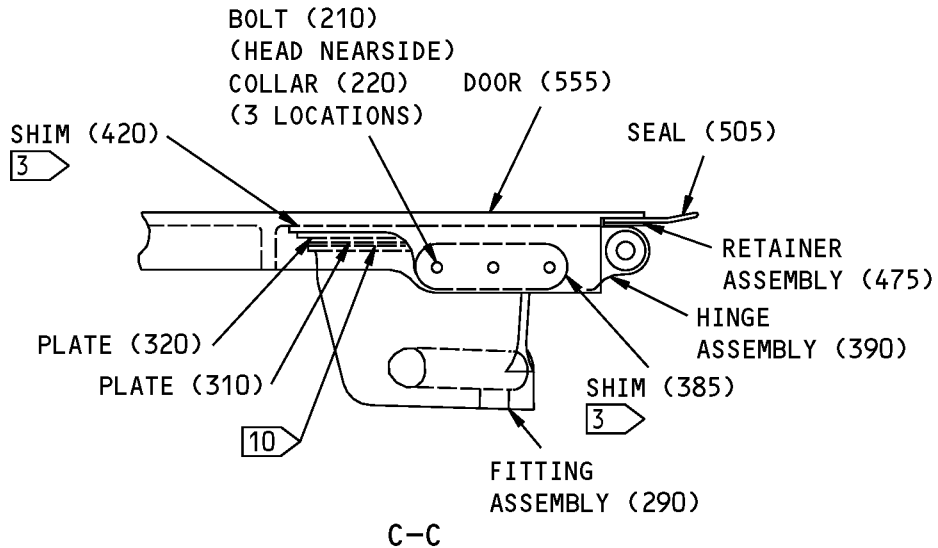
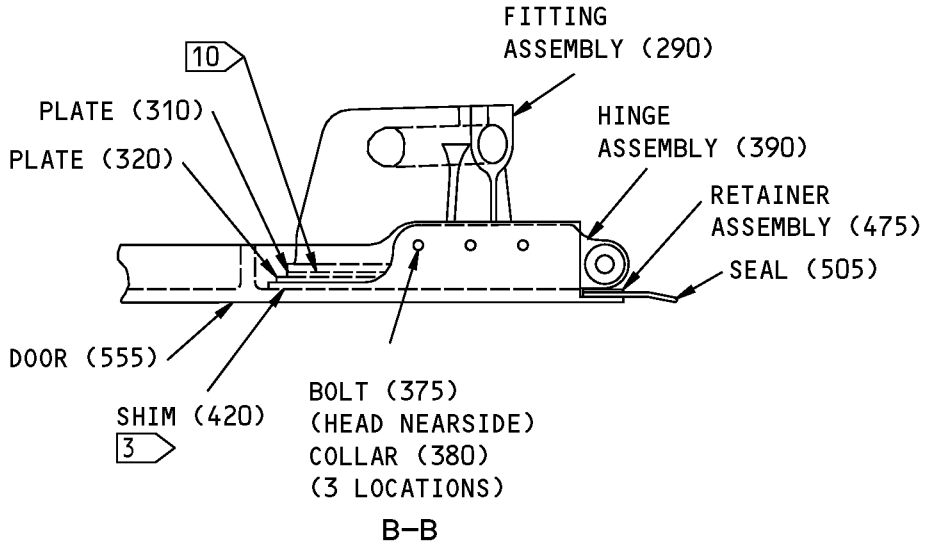
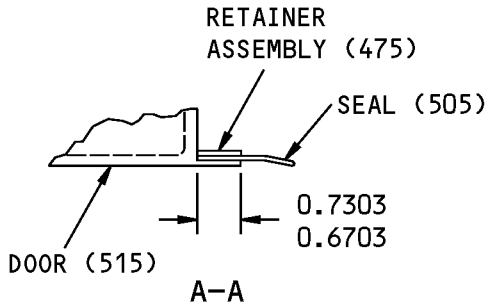


113A8200-3 Thru -8 Center Door Assembly Repair
Figure 601 (Sheet 3 of 7)

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REPAIR 3-1
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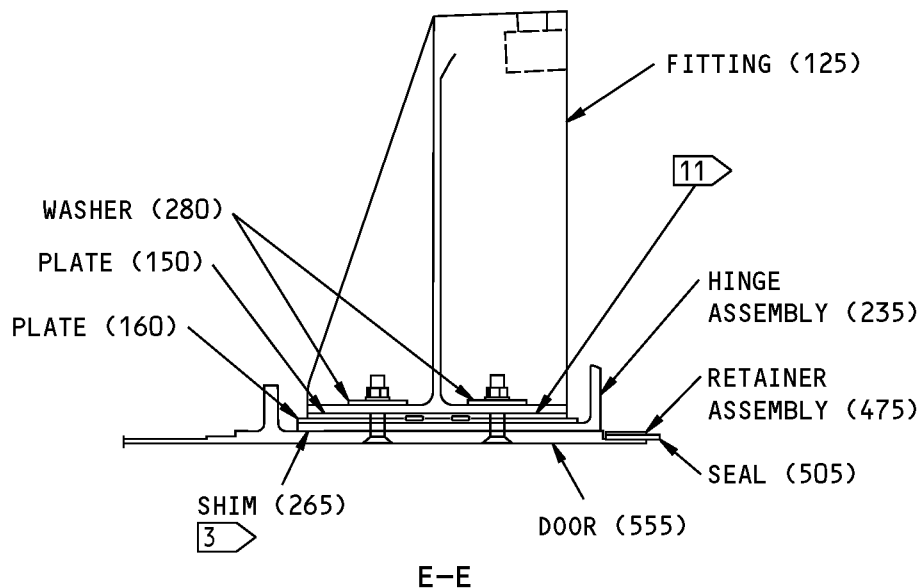
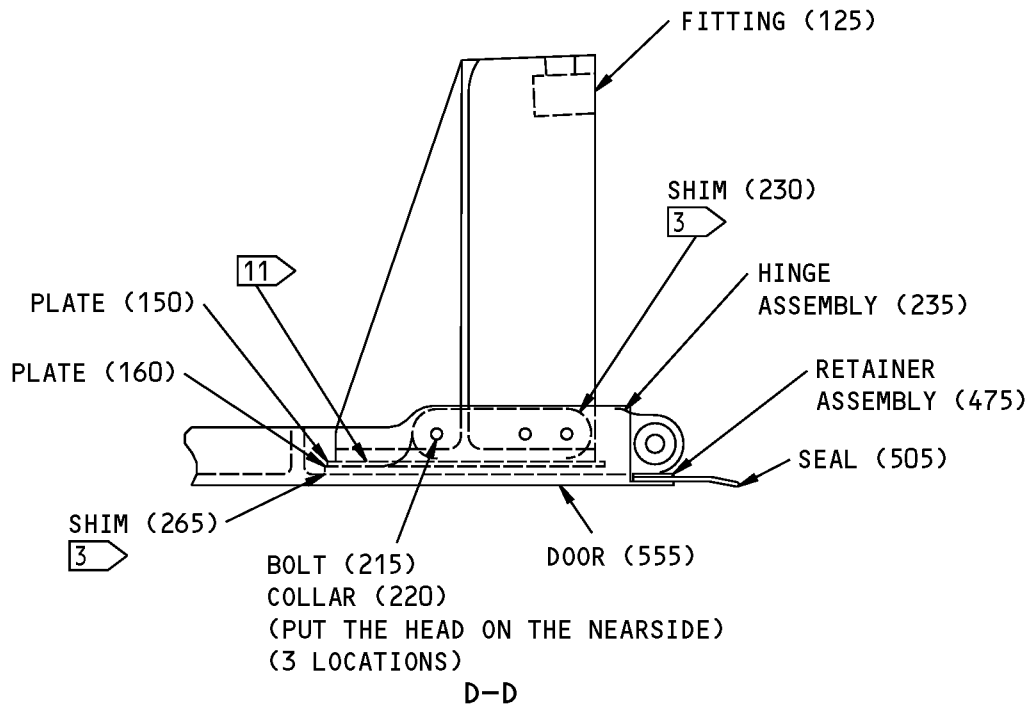


113A8200-3 Thru -8 Center Door Assembly Repair
Figure 601 (Sheet 4 of 7)

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REPAIR 3-1
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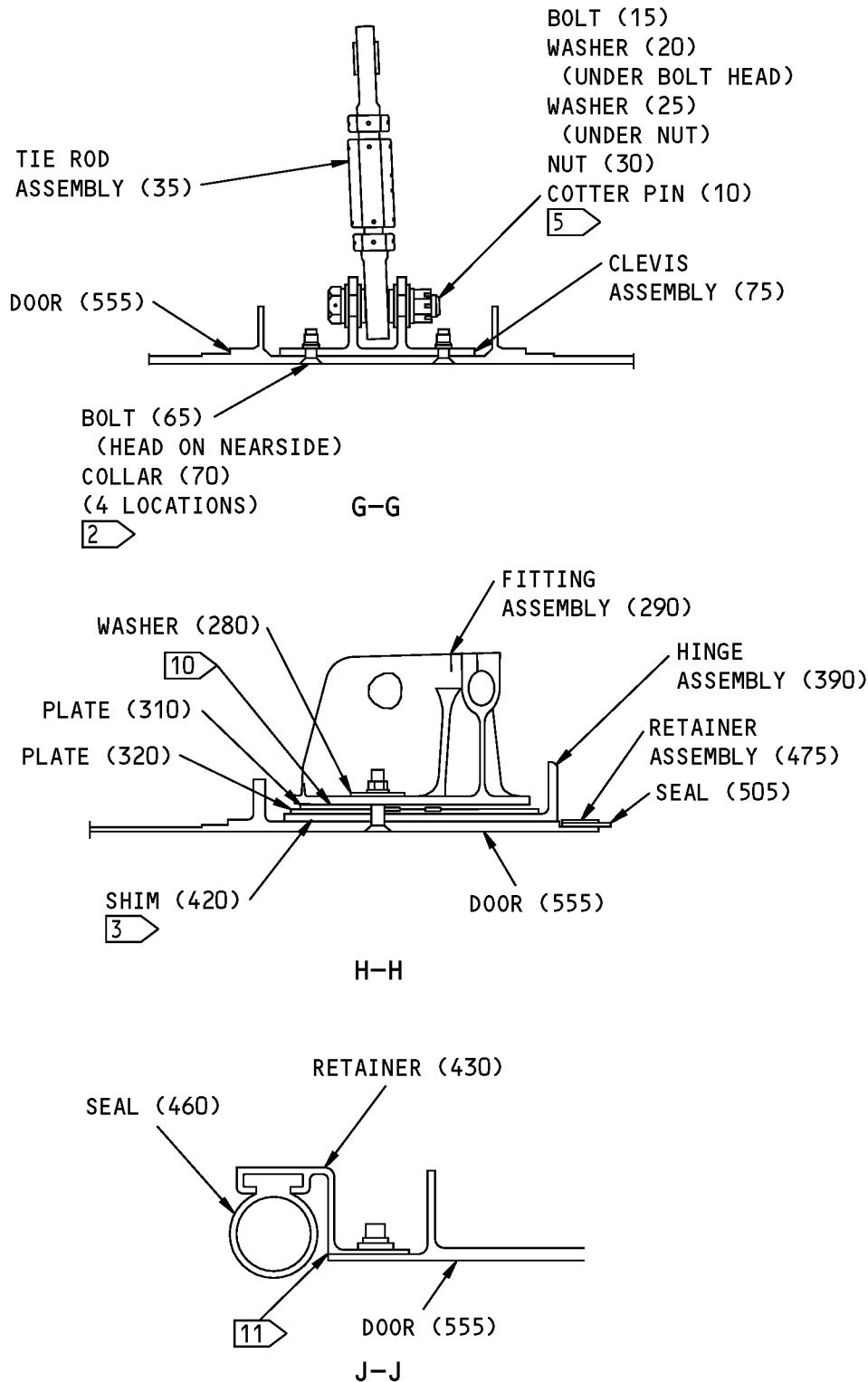


113A8200-3 Thru -8 Center Door Assembly Repair
Figure 601 (Sheet 5 of 7)

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113A8200-3 Thru -8 Center Door Assembly Repair
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COMPONENT MAINTENANCE MANUAL

- 1 PUT A COUNTERSINK ON THE FITTING AND THE PLATE. INSTALL THE RIVET AND MACHINE THE RIVET TAIL TO BE FLUSH TO THE SURFACE WITHIN 0.0000-0.0030, 125 MICROINCHES OR SMOOTHER. TOUCH UP FINISH (F-19.47)
 - 2 INSTALL THE FASTENER WITH BMS 5-95 SEALANT (SOPM 20-50-19, METHOD 2)
 - 3 USE SHIMS AS NECESSARY. REMOVE LAMINATIONS TO GET A 0.0050 GAP BEFORE THE FASTENERS ARE TIGHTENED. INSTALL THE SHIMS WITH WET BMS 10-11 TYPE 1 PRIMER
 - 4 APPLY BMS 10-11 TYPE 1 PRIMER TO THE HOLE (SRF-14.06) BEFORE FASTENER INSTALLATION. INSTALL THE FASTENER WITH MIL-C-11796 CLASS 3 CORROSION PREVENTIVE COMPOUND
 - 5 TIGHTEN THE NUT TO STANDARD TORQUE (SOPM 20-50-01). LOOSEN THE NUT, IF NECESSARY, TO ALIGN THE FIRST AVAILABLE SLOT WITH THE COTTER PIN HOLE IN THE BOLT. INSTALL THE COTTER PIN (SOPM 20-50-02)
 - 6 TO KEEP THE HINGE LINE, BE SURE TO REPLACE ONLY ONE HINGE AT A TIME
 - 7 DELETED
 - 8 INSTALL THE LOCKWIRE 0.50 ± 1.00 FROM THE END OF THE SEAL RETAINER RETAINER AND USE ONE LOCKWIRE PER SEAL. TWIST THE ENDS 5 TO 6 TIMES (TWISTED ENDS 0.25-0.50 LONG). BEND BACK THE TWISTED ENDS ALONG THE RETAINER
 - 9 USE SHIMS AS NECESSARY TO GET A 0.020 GAP BEFORE THE FASTENERS ARE TIGHTENED. INSTALL THE SHIMS WITH WET BMS 10-11 TYPE 1 PRIMER
 - 10 APPLY BMS 5-95 FAY SURFACE SEALANT (SOPM 20-50-19)
 - 11 ALIGN THE RETAINER FLUSH TO THE DOOR.
 - 12 DOUBLE COUNTERSINK THRU HINGE ASSEMBLY (350) AND PLATE (160) ONLY
 - 13 DOUBLE COUNTERSINK THRU FITTING ASSEMBLY (290) AND PLATE (320) ONLY
 - 14 0.2500-0.2540 DIAMETER THRU DOOR (555), ASSEMBLY (235), AND SHIM (265) ONLY. COUNTERSINK 100° FAR SIDE THRU DOOR (555) ONLY
 - 15 COUNTERSINK THRU DOOR (555) ONLY. LOCATE TO MATCH RETAINER (430)
 - 16 COUNTERSINK 100° FAR SIDE, 0.1900-0.1940 THRU DOOR (555) ONLY. LOCATE TO MATCH RETAINER ASSEMBLY (475)
- MAKE SURE ALL FASTENERS INSTALLED THROUGH THE EXTERIOR SURFACE OF THE DOOR ARE FLUSH WITH THE DOOR WITHIN + 0.005/-0.010
- BREAK ALL SHARP EDGES
- ITEM NUMBERS REFER TO IPL FIG. 2
- ALL DIMENSIONS ARE IN INCHES

113A8200-3 Thru -8 Center Door Assembly Repair
Figure 601 (Sheet 7 of 7)

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REPAIR 3-1
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SEAL RETAINER ASSEMBLY - REPAIR 3-2

113A8221-1, -2, -5, -6, -9, -10

1. General

- A. This procedure tells how to repair the seal retainer assemblies (480 thru 488).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols used in the repair.
- D. Refer to IPL Figure 2 for item numbers.

2. Repair procedures

- A. Nutplate Replacement (REPAIR 3-2, Figure 601, REPAIR 3-2, Figure 602, REPAIR 3-2, Figure 603, as applicable)
 - (1) Remove the rivets and bad nutplates from the seal retainer.
 - (2) Install replacement nut plates (490) with new rivets (485) at the dimensions shown.

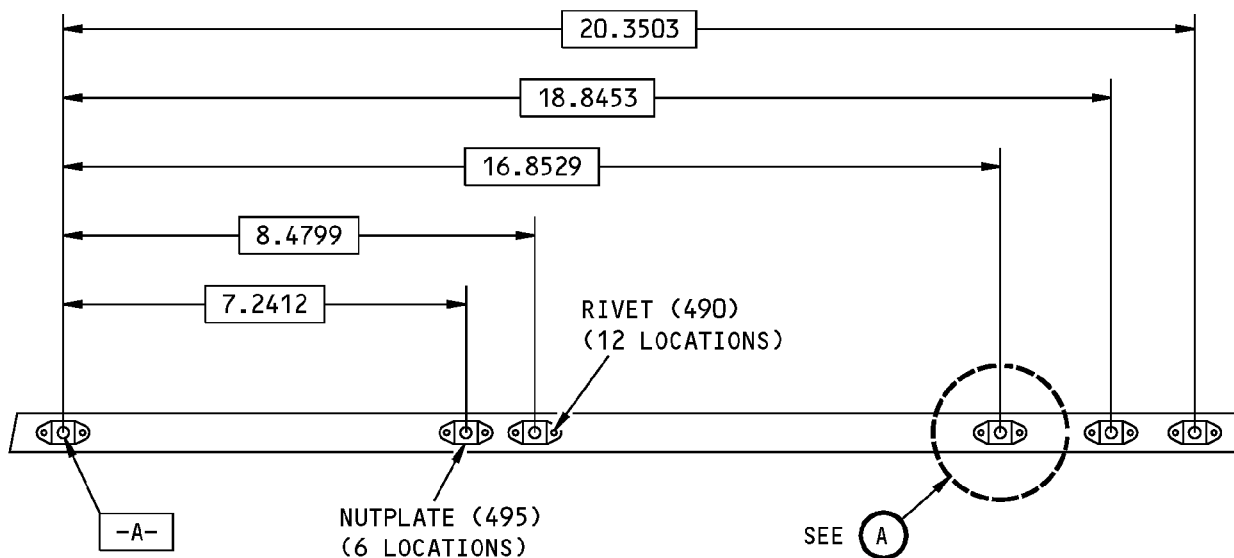
32-13-23

REPAIR 3-2

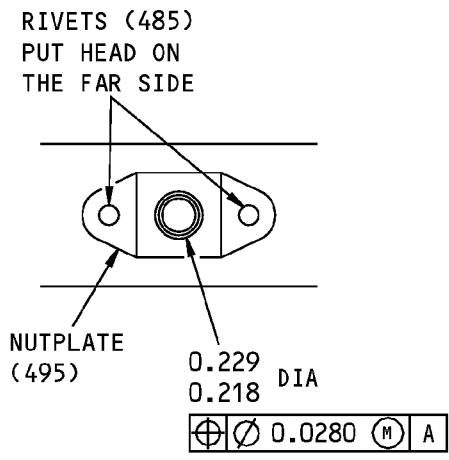
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COMPONENT MAINTENANCE MANUAL



113A8221-1 SHOWN
113A8221-2 OPPOSITE



A

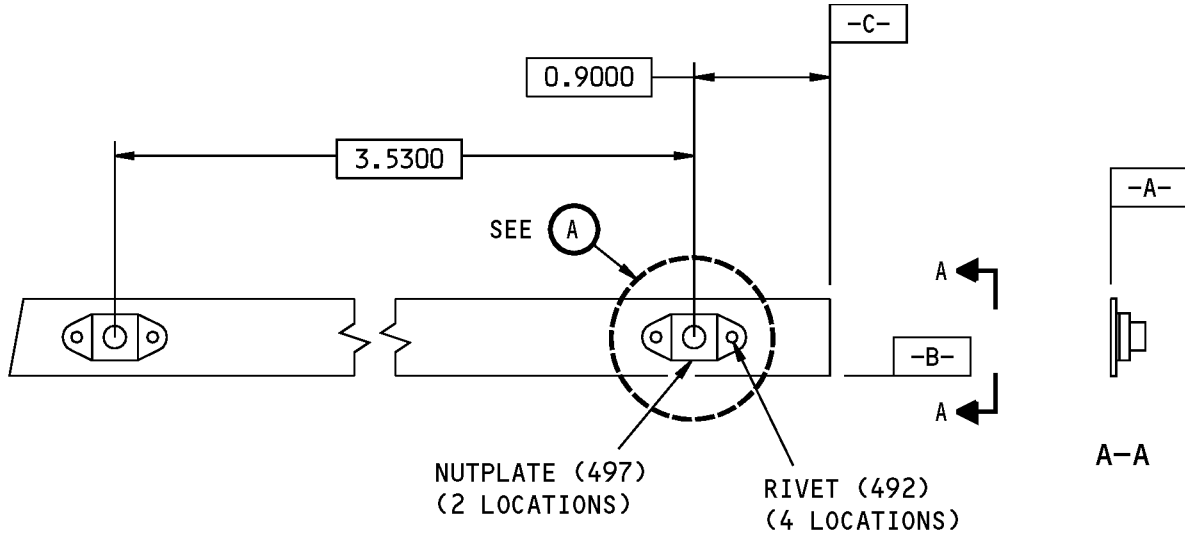
ITEM NUMBERS REFER TO IPL FIG. 2
ALL DIMENSIONS ARE IN INCHES

113A8221-1,-2 Seal Retainer Assembly Repair
Figure 601

32-13-23

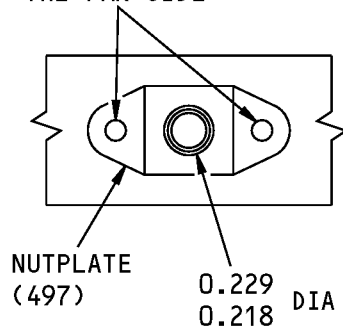
REPAIR 3-2
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COMPONENT MAINTENANCE MANUAL



113A8221-5 SHOWN
113A8221-6 OPPOSITE

RIVETS (492)
PUT HEAD ON
THE FAR SIDE



| | | | | | |
|---|----------|-----|---|---|---|
| ⊕ | ∅ 0.0570 | (M) | A | B | C |
| | ∅ 0.0280 | (M) | A | | |

(A)

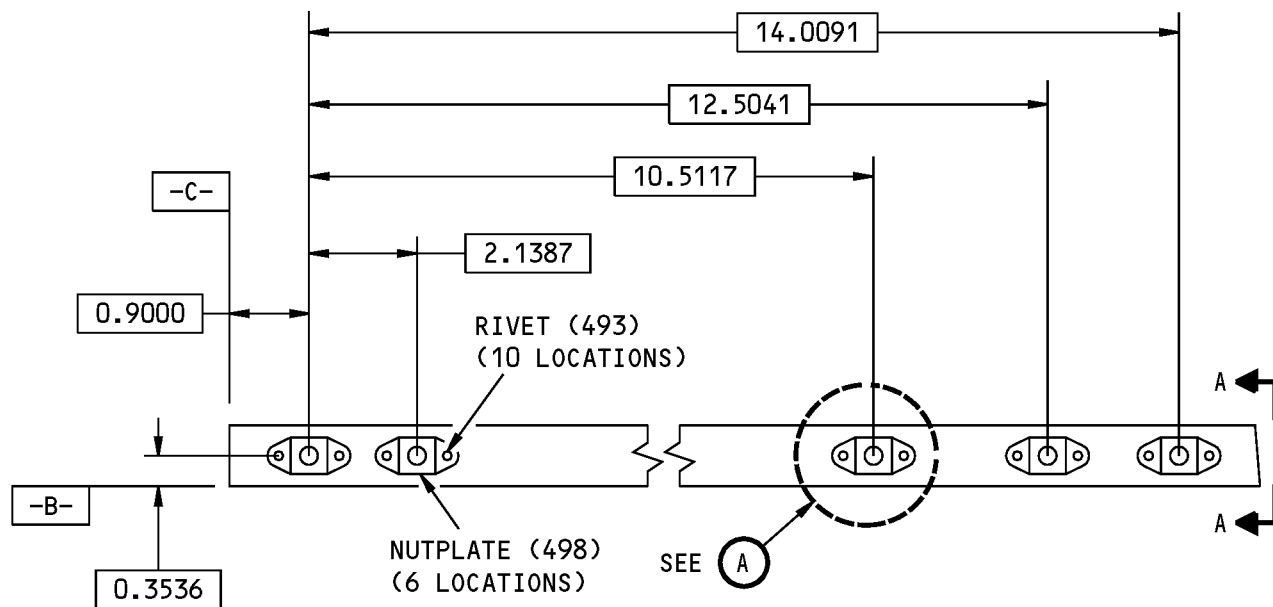
ITEM NUMBERS REFER TO IPL FIG. 2
ALL DIMENSIONS ARE IN INCHES

113A8221-5,-6 Seal Retainer Assembly Repair
Figure 602

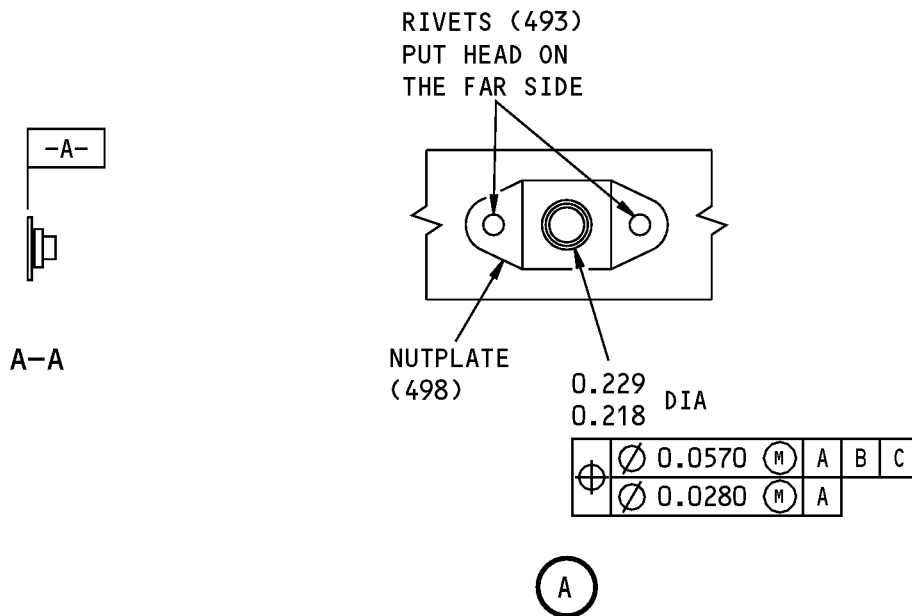
32-13-23

REPAIR 3-2
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COMPONENT MAINTENANCE MANUAL



113A8221-9 SHOWN
113A8221-10 OPPOSITE



ITEM NUMBERS REFER TO IPL FIG. 2
ALL DIMENSIONS ARE IN INCHES

113A8221-9,-10 Seal Retainer Assembly Repair
Figure 603

32-13-23



COMPONENT MAINTENANCE MANUAL

SEAL RETAINER - REPAIR 3-3

113A8223-5, -6

1. General

- A. This procedure has the data necessary to repair the seal retainer assembly (430, 435).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols used in the repair.
- D. Refer to IPL Figure 2 for item numbers.

2. Repair procedures

- A. Nutplate Replacement (REPAIR 3-3, Figure 601)
 - (1) Remove the rivets and bad nutplates (455) from the seal retainer assy (430, 435).
 - (2) Install replacement nutplates with new rivets (440) to the dimensions shown in REPAIR 3-3, Figure 601.

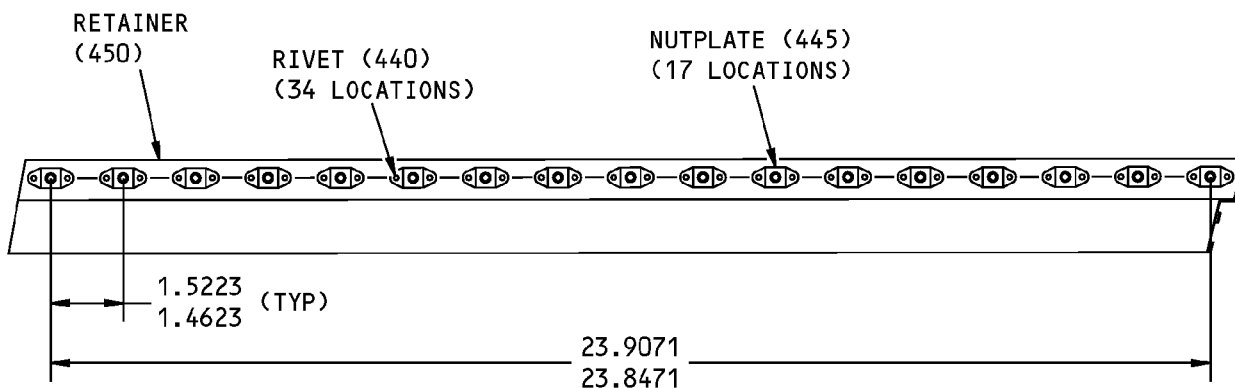
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REPAIR 3-3

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COMPONENT MAINTENANCE MANUAL



113A8223-5 SHOWN
113A8223-6 OPPOSITE

ITEM NUMBERS REFER TO IPL FIG. 2
ALL DIMENSIONS ARE IN INCHES

113A8223-5,-6 Seal Retainer Assembly Repair
Figure 601

32-13-23

REPAIR 3-3
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COMPONENT MAINTENANCE MANUAL

FITTING ASSEMBLY - REPAIR 3-4

113A8240-1, -2

1. General

- A. This procedure has the data necessary to repair the fitting assembly (290, 295).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols used in the repair.
- D. Refer to IPL Figure 2 for item numbers.

2. Repair procedures

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

| <u>Reference</u> | <u>Description</u> | <u>Specification</u> |
|------------------|------------------------------------------------------|----------------------|
| A00247 | Sealant - Pressure And Environmental - Chromate Type | BMS 5-95 |

- B. References

| <u>Reference</u> | <u>Title</u> |
|------------------|----------------------------------|
| SOPM 20-30-02 | STRIPPING OF PROTECTIVE FINISHES |
| SOPM 20-50-03 | BEARING AND BUSHING REPLACEMENT |
| SOPM 20-60-04 | MISCELLANEOUS MATERIALS |

- C. Bushing Replacement REPAIR 3-4, Figure 601

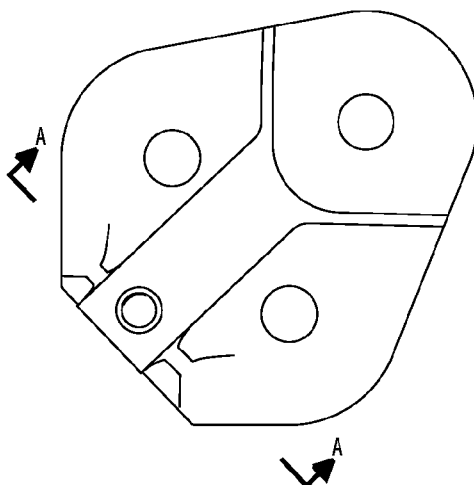
NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Remove the old bushing (300) from the fitting (305, 310) (SOPM 20-50-03).
- (2) Use the shrink-fit procedure of SOPM 20-50-03 to install the replacement bushing in the fitting assembly with wet sealant, A00247. Make sure the bushing face is flush with the fitting surface within +0.0000/-0.0200 inch.
- (3) Machine the bushing to the dimension shown.

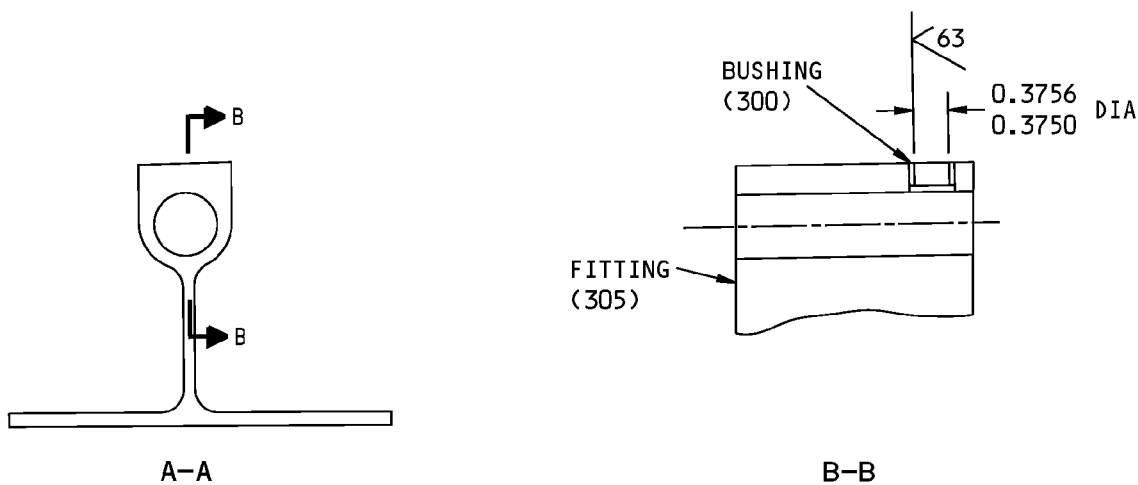
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REPAIR 3-4
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113A8240-1 SHOWN
113A8240-2 OPPOSITE



ITEM NUMBERS REFER TO IPL FIG. 2
ALL DIMENSIONS ARE IN INCHES

113A8240-1,-2 Fitting Assembly Repair
Figure 601

32-13-23

REPAIR 3-4
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COMPONENT MAINTENANCE MANUAL

FITTING - REPAIR 3-5

113A8240-3, -4

1. General

- A. This procedure has the data necessary to refinish the fitting (305, 310).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols used in the repair.
- D. Refer to IPL Figure 2 for item numbers.
- E. General repair details:
 - (1) Material: Aluminum alloy
 - (2) Shot peen: All surfaces, but not in holes, Intensity 0.005-0.010A2.

2. Repair procedures

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

| <u>Reference</u> | <u>Description</u> | <u>Specification</u> |
|------------------|----------------------------------------------------------------|----------------------|
| C00033 | Coating - Exterior Protective Enamel, Flexibility Use | BMS10-60, Type II |
| C00259 | Primer - Chemical And Solvent Resistant Finish, Epoxy Resin | BMS10-11, Type I |

- B. References

| <u>Reference</u> | <u>Title</u> |
|------------------|----------------------------------------|
| SOPM 20-10-03 | SHOT PEENING |
| 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. Fitting Refinish (REPAIR 3-5, Figure 601)

NOTE: For shotpeening, refer to SOPM 20-10-03. For stripping of protective finishes, refer to SOPM 20-30-02. For decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Boric acid - sulfuric acid anodize (F-17.31). Apply primer, C00259 (F-20.02) and enamel coating, C00033 (F-19.39-707) to all but the flagnote 1 surfaces.

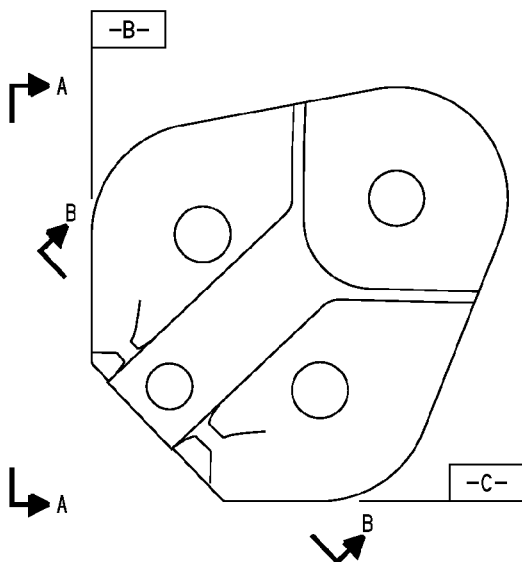
32-13-23

REPAIR 3-5

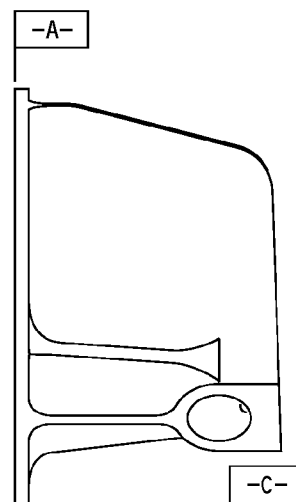
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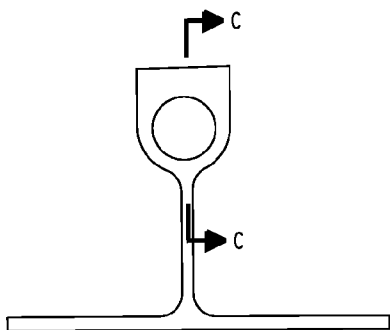
COMPONENT MAINTENANCE MANUAL



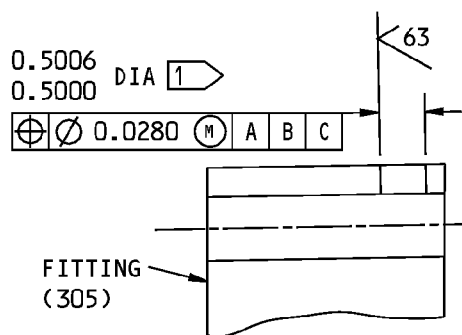
113A8240-3 SHOWN
113A8240-4 OPPOSITE



A-A



B-B



C-C

DO NOT APPLY PRIMER OR ENAMEL
IN THE HOLE

ALL MACHINED SURFACES UNLESS
SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

113A8240-3,-4 Fitting Refinish
Figure 601

32-13-23

REPAIR 3-5

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COMPONENT MAINTENANCE MANUAL

FITTING ASSEMBLY - REPAIR 3-6

113A8241-1, -2

1. General

- A. This procedure has the data necessary to repair the fitting assembly (125, 130).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols used in the repair.
- D. Refer to IPL Figure 2 for item numbers.

2. Repair procedures

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

| <u>Reference</u> | <u>Description</u> | <u>Specification</u> |
|------------------|------------------------------------------------------|----------------------|
| A00247 | Sealant - Pressure And Environmental - Chromate Type | BMS 5-95 |

- B. References

| <u>Reference</u> | <u>Title</u> |
|------------------|----------------------------------|
| SOPM 20-30-02 | STRIPPING OF PROTECTIVE FINISHES |
| SOPM 20-50-03 | BEARING AND BUSHING REPLACEMENT |
| SOPM 20-60-04 | MISCELLANEOUS MATERIALS |

- C. Bushing Replacement (REPAIR 3-6, Figure 601)

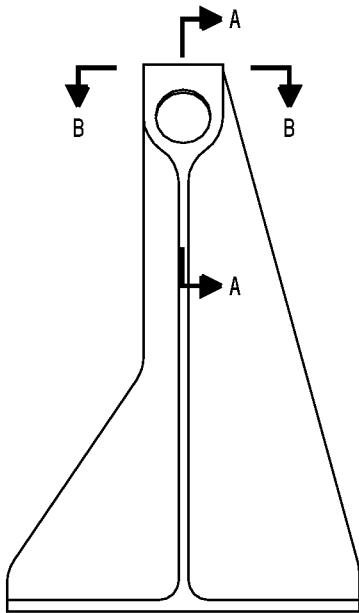
NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Remove the old bushing (135) from the fitting (140, 145) (SOPM 20-50-03).
- (2) Use the shrink-fit procedure of SOPM 20-50-03 to install the replacement bushing with wet sealant, A00247.
- (3) Machine the bushing to the design dimensions.

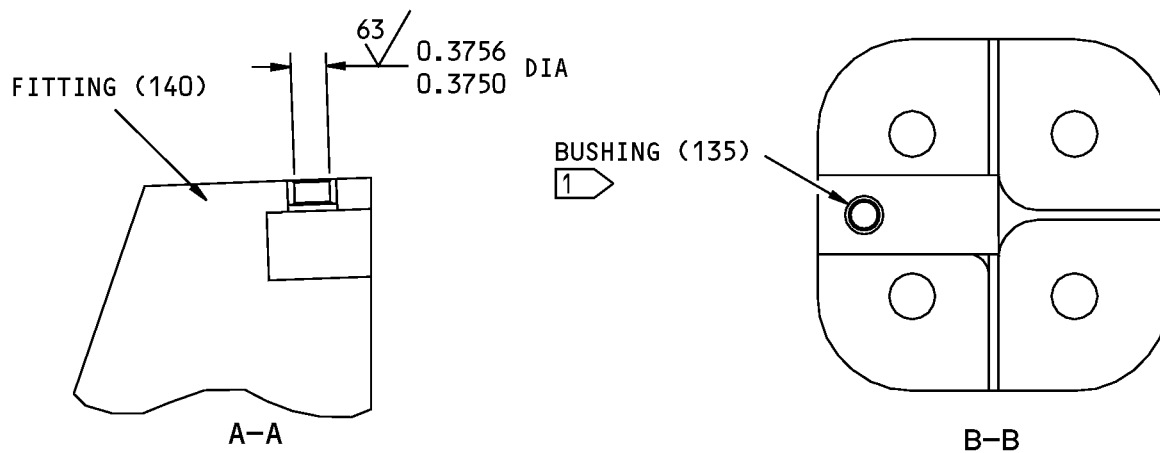
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REPAIR 3-6
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COMPONENT MAINTENANCE MANUAL



113A8241-1 SHOWN
113A8241-2 OPPOSITE



1 USE THE SHRINK-FIT PROCEDURE TO
INSTALL THE BUSHING WITH WET
BMS 5-95 SEALANT.

ITEM NUMBERS REFER TO IPL FIG. 2
ALL DIMENSIONS ARE IN INCHES

113A8241-1,-2 Fitting Assembly Repair
Figure 601

32-13-23

REPAIR 3-6
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COMPONENT MAINTENANCE MANUAL

FITTING - REPAIR 3-7

113A8241-3, -4

1. General

- A. This procedure has the data necessary to refinish the fitting (140, 145).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols used in the repair.
- D. Refer to IPL Figure 2 for item numbers.
- E. General repair details:
 - (1) Material: Aluminum alloy
 - (2) Shot peen: All surfaces, but not in holes, Intensity 0.005-0.010A2.

2. Repair Procedures

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

| <u>Reference</u> | <u>Description</u> | <u>Specification</u> |
|------------------|----------------------------------------------------------------|----------------------|
| C00032 | Coating - Exterior Protective Enamel, General Use | BMS10-60, Type I |
| C00259 | Primer - Chemical And Solvent Resistant Finish, Epoxy Resin | BMS10-11, Type I |

- B. References

| <u>Reference</u> | <u>Title</u> |
|------------------|----------------------------------------|
| 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. Fitting Refinish (REPAIR 3-7, Figure 601)

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

- (1) Boric acid - sulfuric acid anodize (F-17.31). Apply primer, C00259 (F-20.02) and enamel coating, C00032 (F-14.9813, which replaces SRF-14.9813) unless shown.

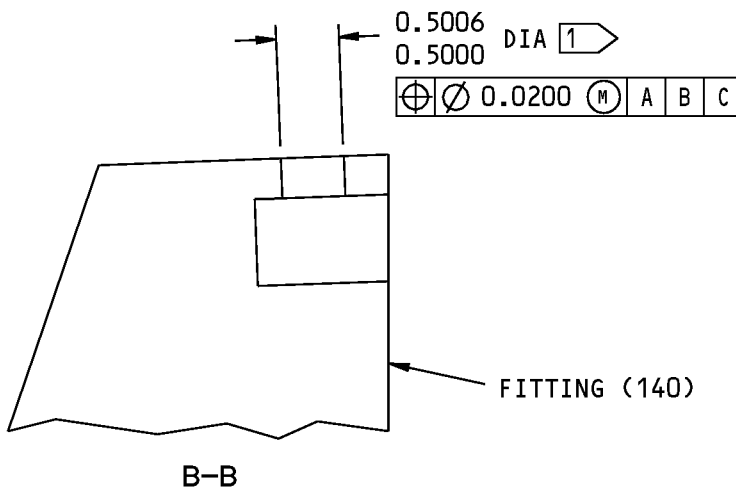
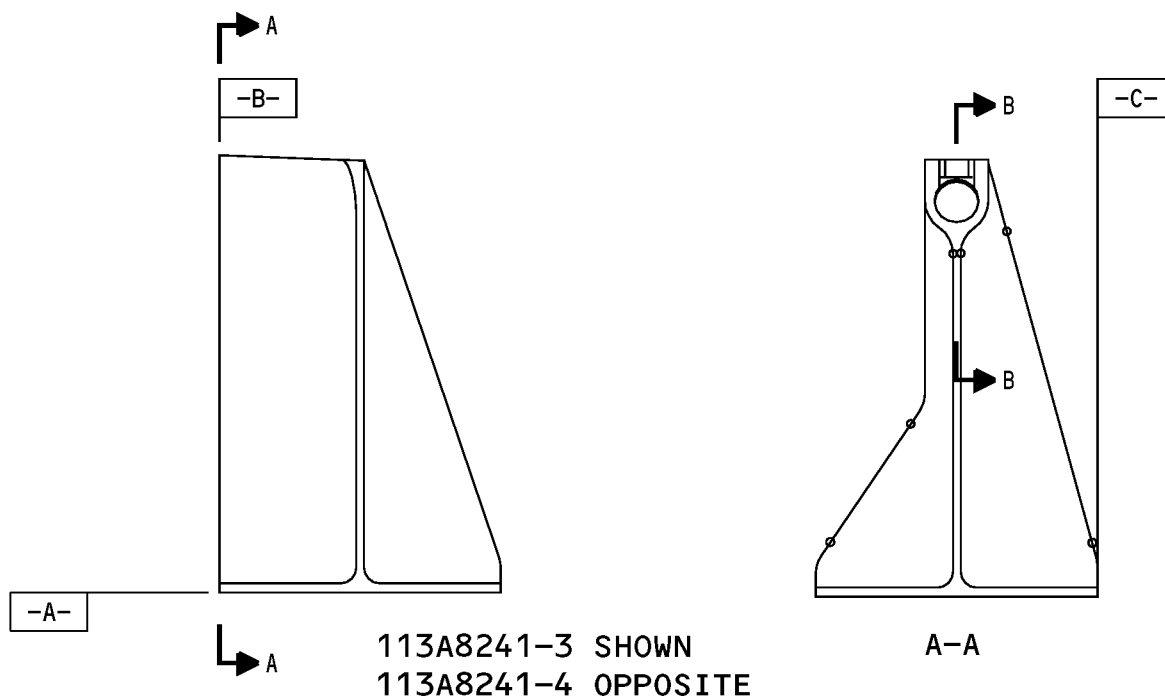
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REPAIR 3-7

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COMPONENT MAINTENANCE MANUAL



1 DO NOT APPLY PRIMER OR ENAMEL IN THE HOLE.

125 ✓ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

113A8241-3,-4 Fitting Refinish
Figure 601

32-13-23

REPAIR 3-7

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COMPONENT MAINTENANCE MANUAL

CLEVIS ASSEMBLY - REPAIR 3-8

113A8245-1

1. General

- A. This procedure has the data necessary to repair the clevis assembly (75).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols used in the repair.
- D. Refer to IPL Figure 2 for item numbers.

2. Repair Procedures

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

| <u>Reference</u> | <u>Description</u> | <u>Specification</u> |
|------------------|------------------------------------------------------|----------------------|
| A00247 | Sealant - Pressure And Environmental - Chromate Type | BMS 5-95 |

- B. References

| <u>Reference</u> | <u>Title</u> |
|------------------|----------------------------------|
| SOPM 20-30-02 | STRIPPING OF PROTECTIVE FINISHES |
| SOPM 20-50-03 | BEARING AND BUSHING REPLACEMENT |
| SOPM 20-60-04 | MISCELLANEOUS MATERIALS |

- C. Bushing Replacement (REPAIR 3-8, Figure 601)

NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Remove the old bushings (80, 85) from the clevis (90) (SOPM 20-50-03).
- (2) Use the shrink-fit procedure of SOPM 20-50-03 to install the replacement bushings with wet sealant, A00247.
- (3) Machine the bushings to the design dimensions shown.

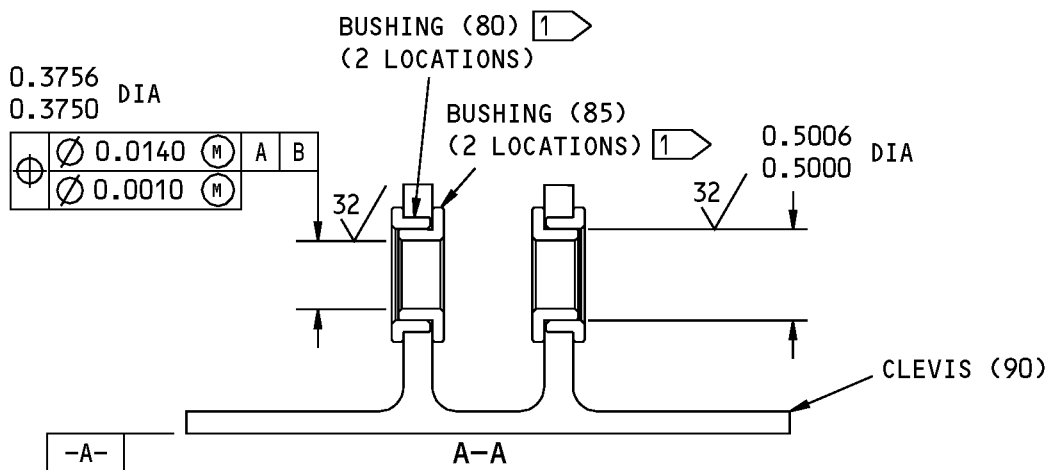
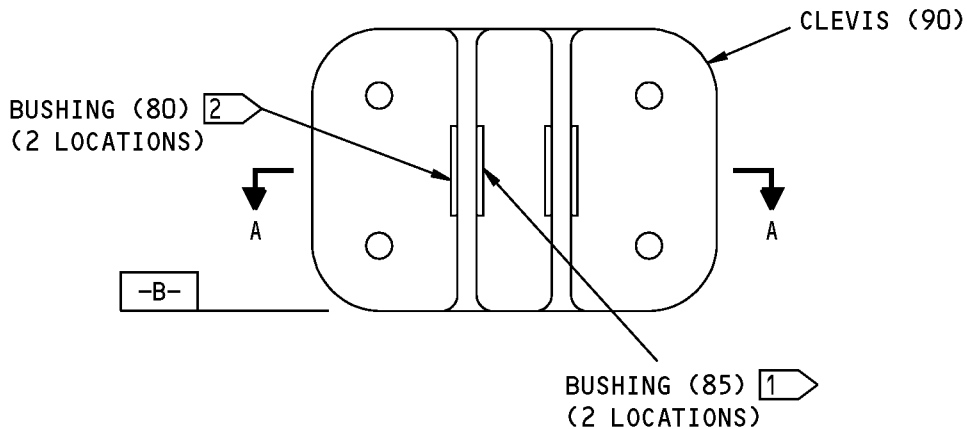
32-13-23

REPAIR 3-8

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1 USE THE SHRINK-FIT PROCEDURE TO
INSTALL THE BUSHINGS WITH WET
BMS 5-95 SEALANT

ITEM NUMBERS REFER TO IPL FIG. 2
ALL DIMENSIONS ARE IN INCHES

113A8245-1 Clevis Repair
Figure 601

32-13-23

REPAIR 3-8
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COMPONENT MAINTENANCE MANUAL

CLEVIS - REPAIR 3-9

113A8245-3

1. General

- A. This procedure has the data necessary to refinish the clevis (90).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols used in the repair.
- D. Refer to IPL Figure 2 for item numbers.
- E. General repair details:
 - (1) Material: Aluminum alloy
 - (2) Shot peen: All surfaces, but not in holes
Intensity 0.005-0.010A2
Overspray is permitted

2. Repair Procedures

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

| Reference | Description | Specification |
|-----------|----------------------------------------------------------------|---------------------|
| C00032 | Coating - Exterior Protective Enamel, General Use | BMS10-60, Type I |
| C00259 | Primer - Chemical And Solvent Resistant Finish, Epoxy Resin | BMS10-11, Type I |

- B. References

| Reference | Title |
|---------------|----------------------------------------|
| SOPM 20-10-03 | SHOT PEENING |
| 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. Clevis Refinish (REPAIR 3-9, Figure 601)

NOTE: For shotpeening, refer to SOPM 20-10-03. For stripping of protective finishes, refer to SOPM 20-30-02. For decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Boric acid - sulfuric acid anodize (F-17.31). Apply primer, C00259 (F-20.02) and enamel coating, C00032 (F-14.9813, which replaces SRF-14.9813) to all but the flagnote 1 surfaces.

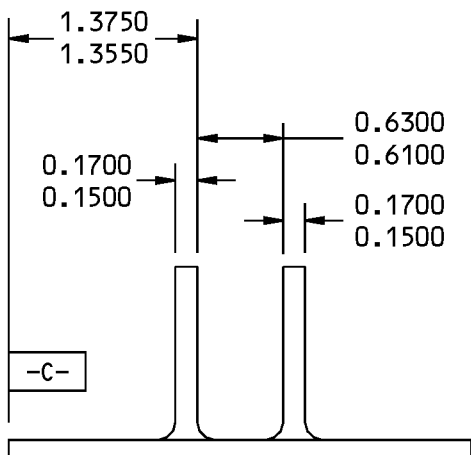
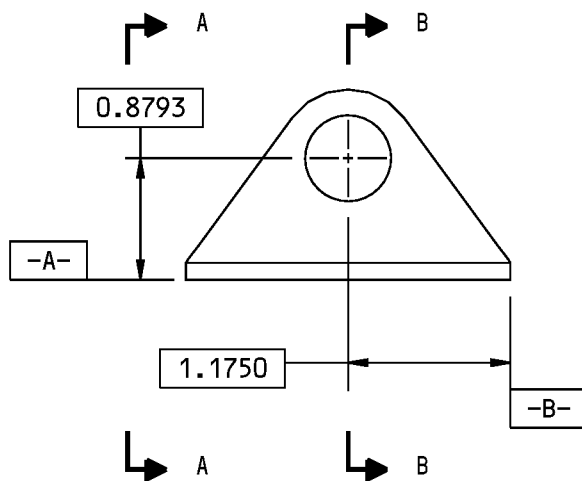
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REPAIR 3-9

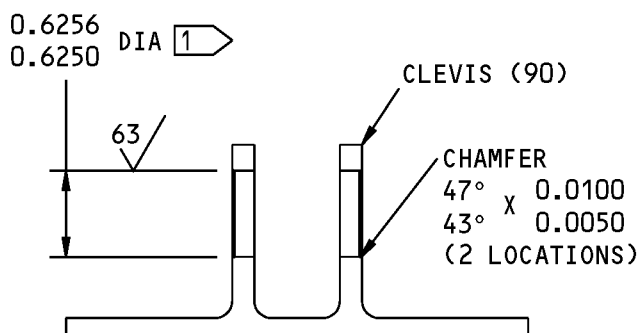
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COMPONENT MAINTENANCE MANUAL



A-A



B-B

1 DO NOT APPLY PRIMER OR ENAMEL IN THE HOLE

125 ✓ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

113A8245-3 Clevis Refinish
Figure 601

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REPAIR 3-9

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COMPONENT MAINTENANCE MANUAL

HINGE ASSEMBLY - REPAIR 3-10

113A8248-1, -2, -5, -6

1. General

- A. This procedure has the data necessary to repair the hinge assembly (235, 240, 390, 395).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols used in the repair.
- D. Refer to IPL Figure 2 for item numbers.

2. Repair Procedures

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

| <u>Reference</u> | <u>Description</u> | <u>Specification</u> |
|------------------|------------------------------------------------------|----------------------|
| A00247 | Sealant - Pressure And Environmental - Chromate Type | BMS 5-95 |

- B. References

| <u>Reference</u> | <u>Title</u> |
|------------------|----------------------------------|
| SOPM 20-30-02 | STRIPPING OF PROTECTIVE FINISHES |
| SOPM 20-50-03 | BEARING AND BUSHING REPLACEMENT |
| SOPM 20-60-04 | MISCELLANEOUS MATERIALS |

- C. Bushing Replacement (REPAIR 3-10, Figure 601, REPAIR 3-10, Figure 602)

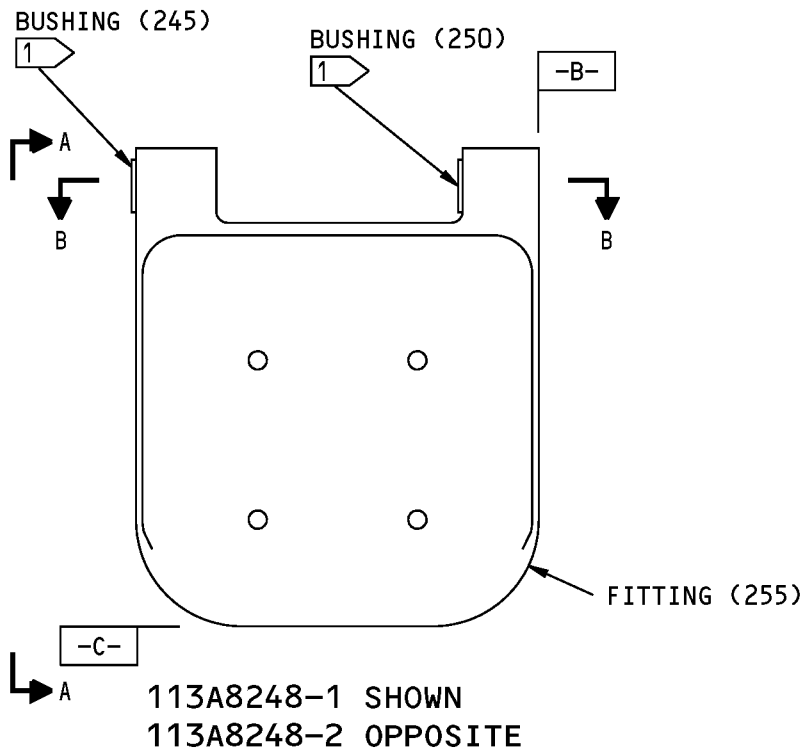
NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Remove the old bushings (245, 250, 400, 405) from the hinge assembly (SOPM 20-50-03).
- (2) Use the shrink-fit procedure of SOPM 20-50-03 to install the replacement bushings with wet sealant, A00247.
- (3) Machine the bushings to the design dimensions shown.

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REPAIR 3-10
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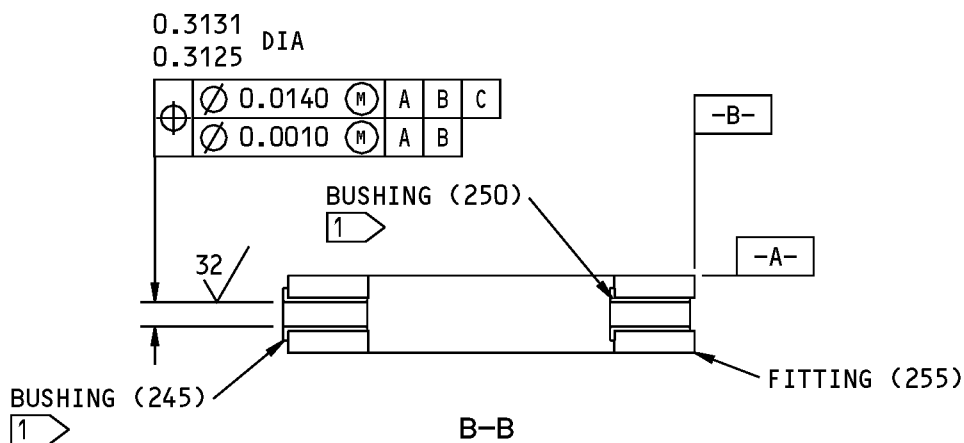
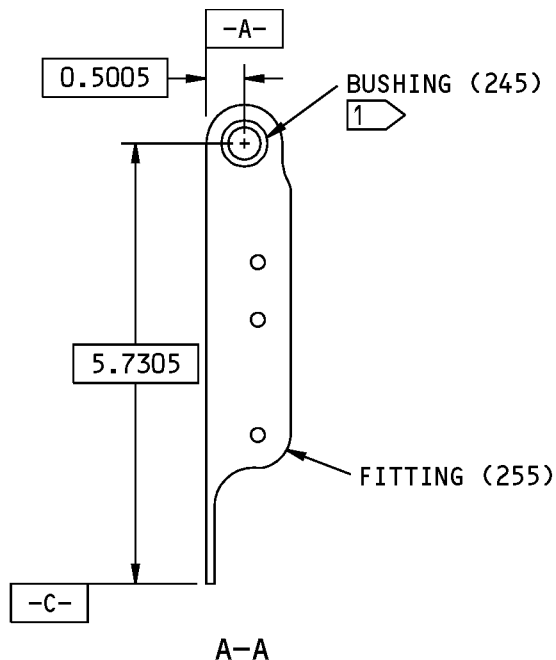


113A8248-1,-2 Hinge Assembly Repair
Figure 601 (Sheet 1 of 2)

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REPAIR 3-10
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COMPONENT MAINTENANCE MANUAL



1 USE THE SHRINK-FIT PROCEDURE TO
INSTALL THE BUSHING WITH WET
BMS 5-95 SEALANT

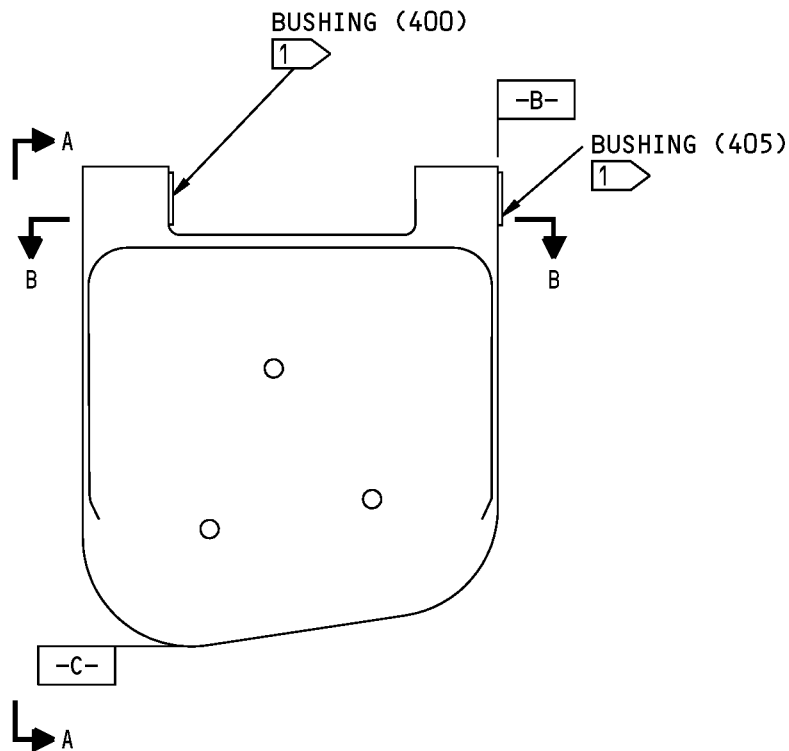
ITEM NUMBERS REFER TO IPL FIG. 2
ALL DIMENSIONS ARE IN INCHES

113A8248-1,-2 Hinge Assembly Repair
Figure 601 (Sheet 2 of 2)

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REPAIR 3-10
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COMPONENT MAINTENANCE MANUAL



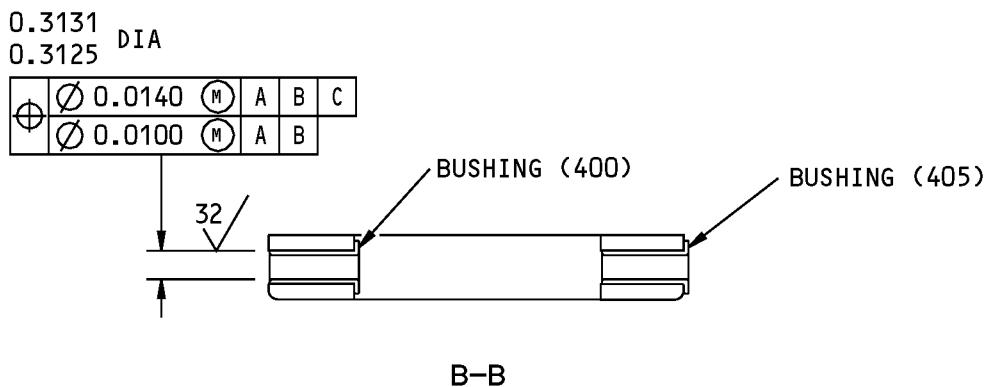
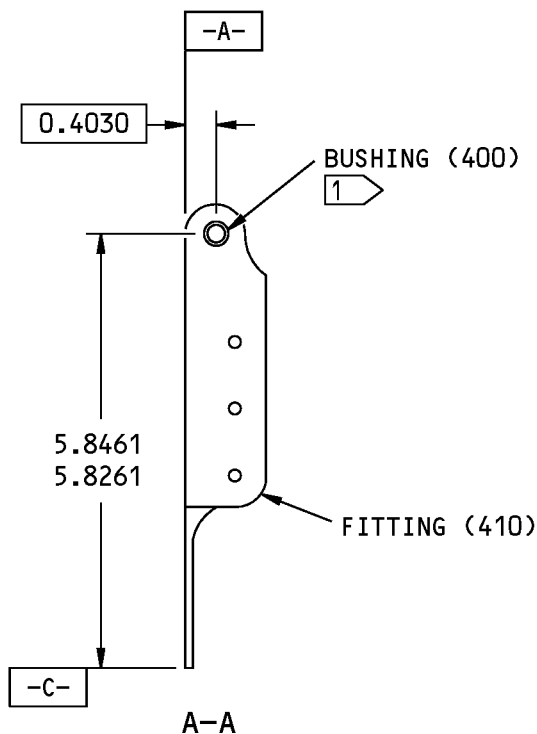
113A8248-5 SHOWN
113A8248-6 OPPOSITE

113A8248-5,6 Hinge Assembly Repair
Figure 602 (Sheet 1 of 2)

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COMPONENT MAINTENANCE MANUAL



1 USE THE SHRINK-FIT PROCEDURE TO
INSTALL THE BUSHING WITH WET
BMS 5-95 SEALANT

ITEM NUMBERS REFER TO IPL FIG. 2
ALL DIMENSIONS ARE IN INCHES

113A8248-5,-6 Hinge Assembly Repair
Figure 602 (Sheet 2 of 2)

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REPAIR 3-10
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COMPONENT MAINTENANCE MANUAL

HINGE - REPAIR 3-11

113A8248-3, -4, -7, -8

1. General

- A. This procedure has the data necessary to refinish the hinge (255, 260, 410, 415).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols used in the repair.
- D. Refer to IPL Figure 2 for item numbers.
- E. General repair details:
 - (1) Material: Aluminum alloy
 - (2) Shot peen: All surfaces, but not in holes, Intensity 0.004-0.007A2, Overspray is permitted.

2. Repair Procedures

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

| Reference | Description | Specification |
|-----------|----------------------------------------------------------------|---------------------|
| C00032 | Coating - Exterior Protective Enamel, General Use | BMS10-60, Type I |
| C00259 | Primer - Chemical And Solvent Resistant Finish, Epoxy Resin | BMS10-11, Type I |

- B. References

| Reference | Title |
|---------------|----------------------------------------|
| SOPM 20-10-03 | SHOT PEENING |
| 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. Hinge Refinish (REPAIR 3-11, Figure 601)

NOTE: For shotpeening, refer to SOPM 20-10-03. For stripping of protective finishes, refer to SOPM 20-30-02. For decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Boric acid - sulfuric acid anodize (F-17.31). Apply primer, C00259 (F-20.02) and enamel coating, C00032 (F-14.9813, which replaces SRF-14.9813) to all but the flagnote 1 surfaces.

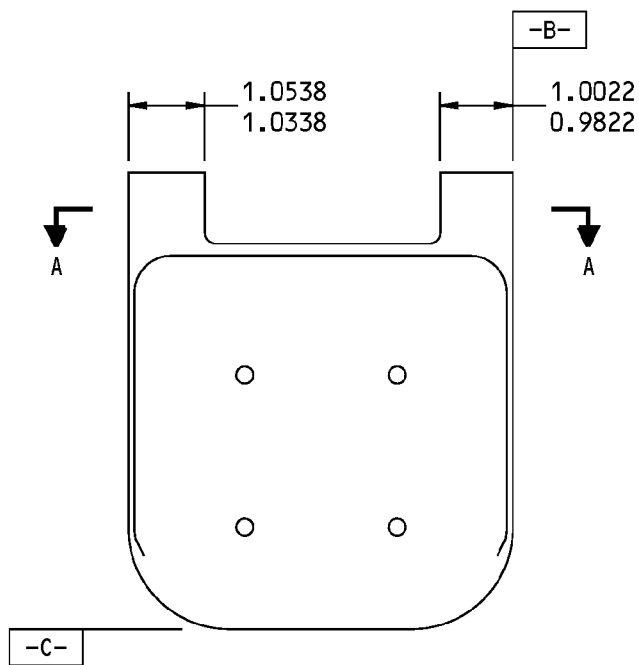
32-13-23

REPAIR 3-11

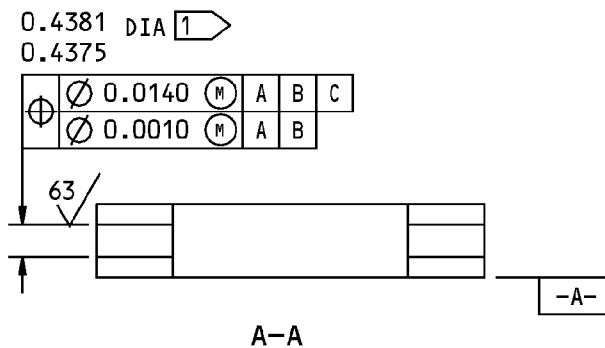
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COMPONENT MAINTENANCE MANUAL



113A8248-3 SHOWN
113A8248-4 OPPOSITE



DO NOT APPLY PRIMER OR ENAMEL IN THE HOLE

ALL MACHINED SURFACES BEFORE SHOT PEEN UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

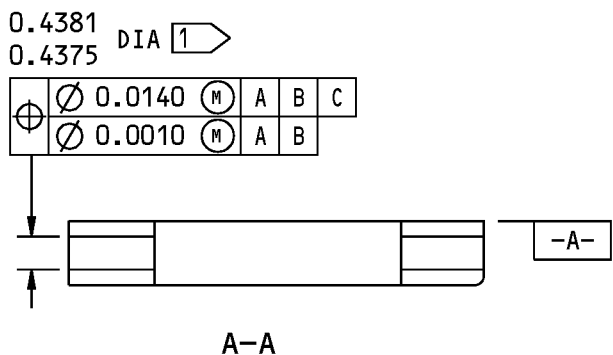
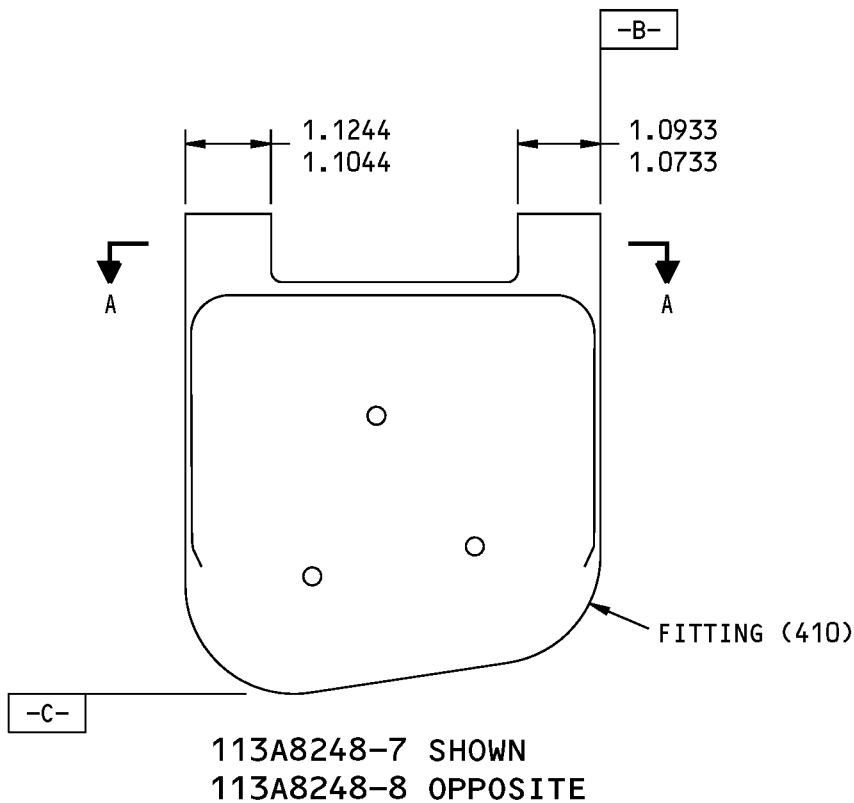
ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

113A8248-3,-4 Hinge Repair
Figure 601

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COMPONENT MAINTENANCE MANUAL



1 DO NOT APPLY PRIMER OR ENAMEL IN THE HOLE

125/ ALL MACHINED SURFACES BEFORE SHOT PEEN UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

113A8248-7,-8 Hinge Repair
Figure 602

32-13-23



COMPONENT MAINTENANCE MANUAL

HINGE FITTING ASSEMBLY - REPAIR 3-12

113A8341-1, -2

1. General

- A. This procedure has the data necessary to repair the hinge fitting assembly (205, 350).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols used in the repair.
- D. Refer to IPL Figure 2 for item numbers.

2. Repair Procedures

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

| <u>Reference</u> | <u>Description</u> | <u>Specification</u> |
|------------------|------------------------------------------------------|----------------------|
| A00247 | Sealant - Pressure And Environmental - Chromate Type | BMS 5-95 |

- B. References

| <u>Reference</u> | <u>Title</u> |
|------------------|----------------------------------|
| SOPM 20-30-02 | STRIPPING OF PROTECTIVE FINISHES |
| SOPM 20-50-03 | BEARING AND BUSHING REPLACEMENT |
| SOPM 20-60-04 | MISCELLANEOUS MATERIALS |

- C. Bushing Replacement (REPAIR 3-12, Figure 601)

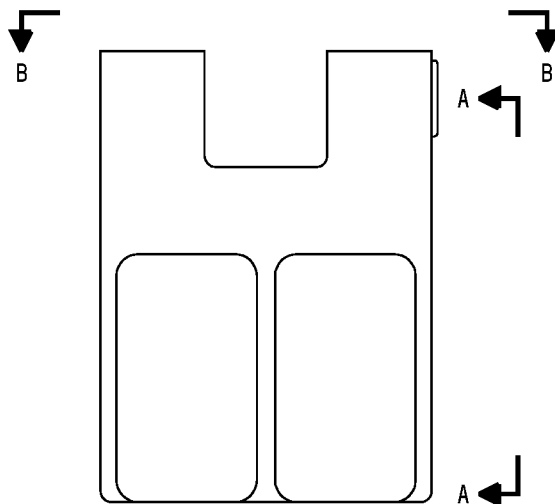
NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Remove the old bushings (195, 200, 355, 360) from the hinge fitting (205, 365) (SOPM 20-50-03).
- (2) Use the shrink-fit procedure of SOPM 20-50-03 to install the replacement bushings with sealant, A00247.
- (3) Machine the bushings to the design dimensions shown.

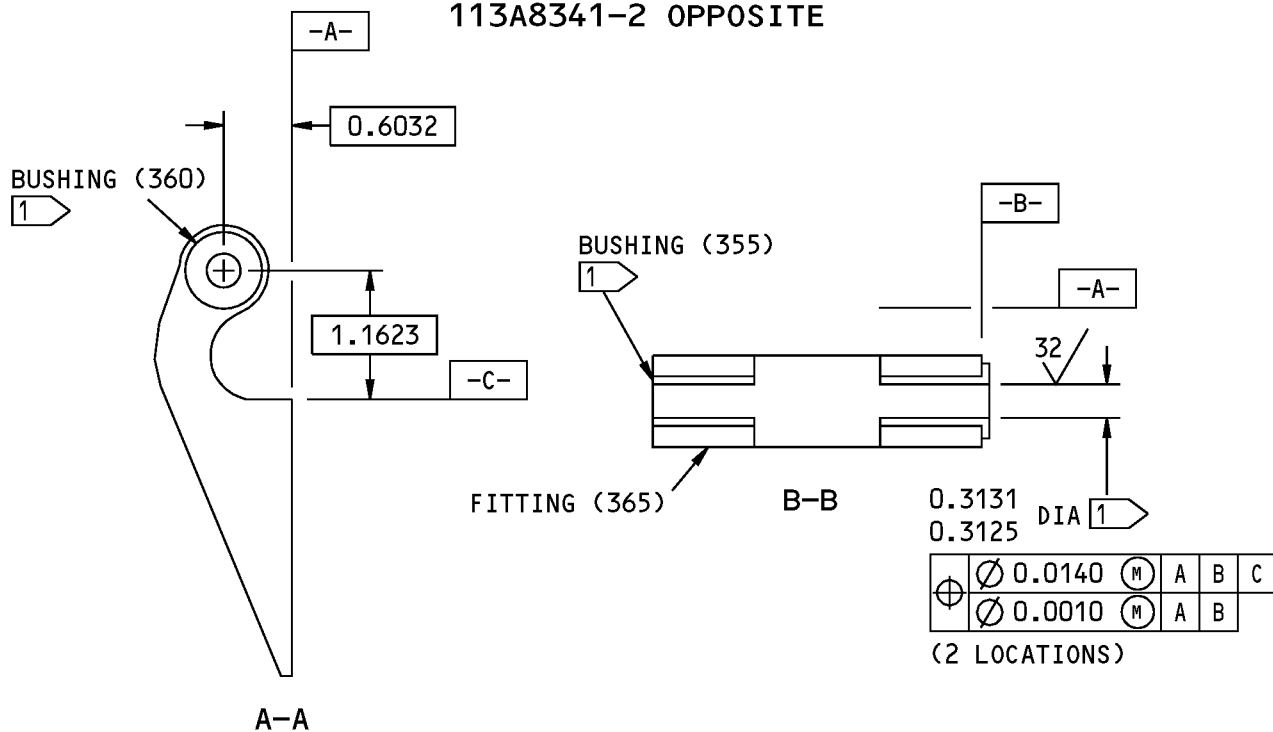
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REPAIR 3-12
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COMPONENT MAINTENANCE MANUAL



113A8341-1 SHOWN
113A8341-2 OPPOSITE



1 USE THE SHRINK-FIT PROCEDURE TO
INSTALL THE BUSHINGS WITH
BMS 5-95 SEALANT

ITEM NUMBERS REFER TO IPL FIG. 2
ALL DIMENSIONS ARE IN INCHES

113A8341-1,-2 Hinge Fitting Assembly Repair
Figure 601

32-13-23

REPAIR 3-12
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COMPONENT MAINTENANCE MANUAL

HINGE FITTING - REPAIR 3-13

113A8341-3, -4

1. General

- A. This procedure has the data necessary to refinish the hinge fitting (205, 365).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols used in the repair.
- D. Refer to IPL Figure 2 for item numbers.
- E. General repair details:
 - (1) Material: Aluminum alloy
 - (2) Shot peen: All surfaces, but not in holes, Intensity 0.005-0.010A2

2. Repair Procedures

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

| <u>Reference</u> | <u>Description</u> | <u>Specification</u> |
|------------------|----------------------------------------------------------------|----------------------|
| C00033 | Coating - Exterior Protective Enamel, Flexibility Use | BMS10-60, Type II |
| C00259 | Primer - Chemical And Solvent Resistant Finish, Epoxy Resin | BMS10-11, Type I |

- B. References

| <u>Reference</u> | <u>Title</u> |
|------------------|----------------------------------------|
| 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. Hinge Fitting Refinish (REPAIR 3-13, Figure 601)

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

- (1) Boric acid - sulfuric acid anodize (F-17.31). Apply primer, C00259 (F-20.02) and enamel coating, C00033 (F-19.39-707) to all but the flagnote 1 surfaces.

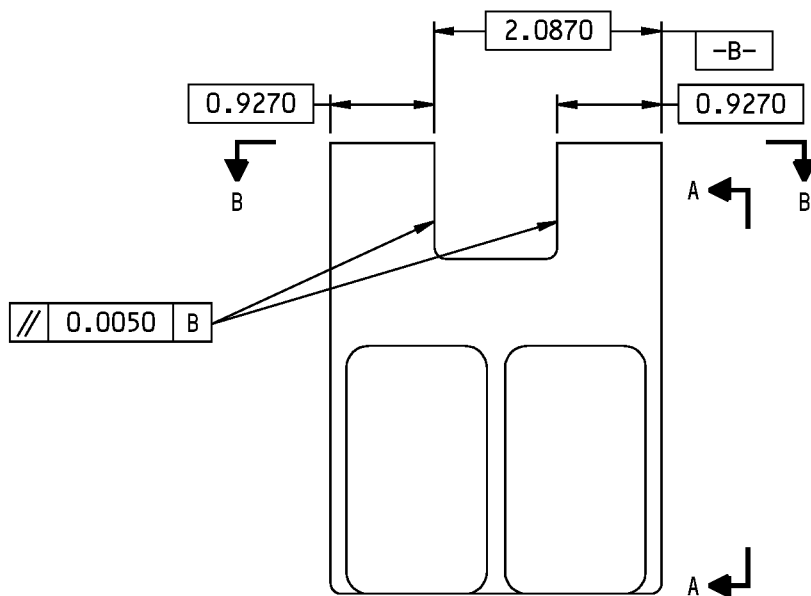
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REPAIR 3-13

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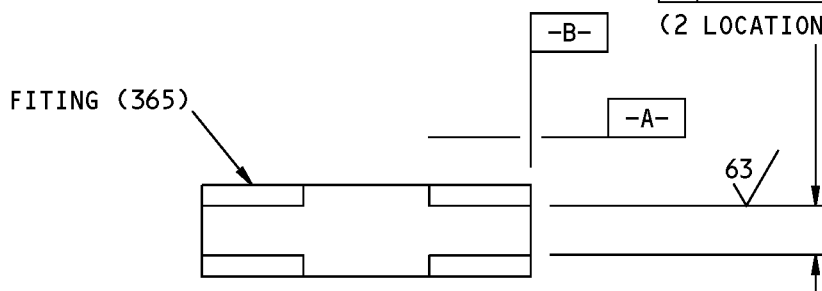


113A8341-3 SHOWN
113A8341-4 OPPOSITE

0.4381 DIA
0.4375

| | | | | | |
|---|----------|-----|---|---|---|
| ⊕ | ∅ 0.0140 | (M) | A | B | C |
| | ∅ 0.0010 | (M) | A | B | |

(2 LOCATIONS) 1



1 DO NOT APPLY PRIMER OR ENAMEL

ITEM NUMBERS REFER TO IPL FIG. 2
ALL DIMENSIONS ARE IN INCHES

113A8341-3,-4 Hinge Fitting Repair
Figure 601

32-13-23

REPAIR 3-13
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COMPONENT MAINTENANCE MANUAL

TIE ROD ASSEMBLY - REPAIR 3-14

113A8700-1

1. General

- A. This procedure has the data necessary to assemble the tie rod assembly (35).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 2 for item numbers.

2. Assembly

- A. Procedure (REPAIR 3-14, Figure 601)
 - (1) Use standard industry procedures and these steps.
 - (2) Install the rod ends (40, 55) onto the link (60) with nuts (45, 50).
 - (3) Adjust the rod ends to give the dimension shown. Make sure you can see the threads through the holes.

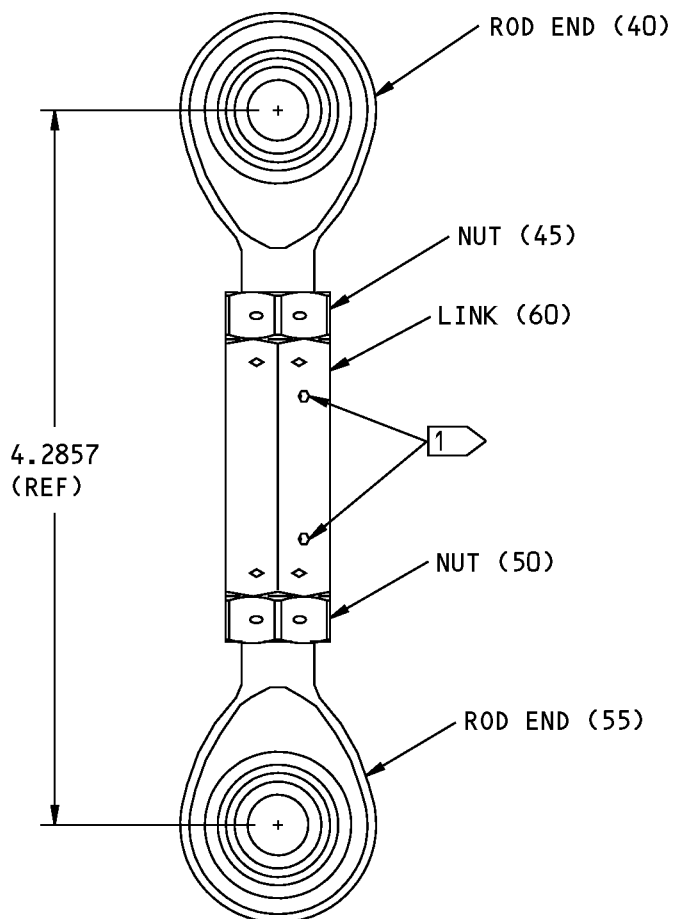
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REPAIR 3-14

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COMPONENT MAINTENANCE MANUAL



1 THREAD THE ROD ENDS INTO THE LINK.
THE THREADS MUST BE VISIBLE THROUGH
THE HOLES

ITEM NUMBERS REFER TO IPL FIG. 2
ALL DIMENSIONS ARE IN INCHES

113A8700-1 Tie Rod Assembly Repair
Figure 601

32-13-23

REPAIR 3-14
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COMPONENT MAINTENANCE MANUAL

INBOARD DOOR ASSEMBLY - REPAIR 4-1

113A8331-1, -2

1. General

- A. This procedure has the data necessary to repair the inboard door assembly.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols used in the repair.
- D. Refer to IPL Figure 3 for item numbers.

2. Repair Procedures

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

| <u>Reference</u> | <u>Description</u> | <u>Specification</u> |
|------------------|------------------------------------------------------|----------------------|
| A00247 | Sealant - Pressure And Environmental - Chromate Type | BMS 5-95 |

- B. References

| <u>Reference</u> | <u>Title</u> |
|------------------|----------------------------------|
| SOPM 20-30-02 | STRIPPING OF PROTECTIVE FINISHES |
| SOPM 20-50-03 | BEARING AND BUSHING REPLACEMENT |
| SOPM 20-60-04 | MISCELLANEOUS MATERIALS |

- C. Bushing Replacement (REPAIR 4-1, Figure 601)

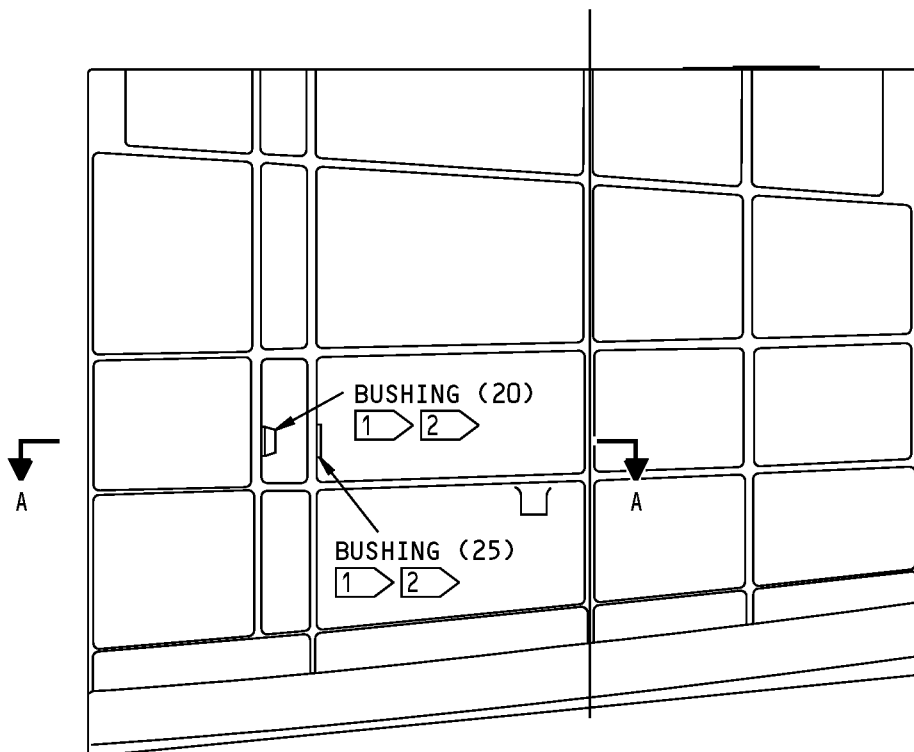
NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Remove the old bushings (20, 25) from the inboard door assembly (1, 5) (SOPM 20-50-03).
- (2) Use the shrink-fit procedure of SOPM 20-50-03 to install the replacement bushings with wet sealant, A00247.
- (3) Machine the bushings to the design dimensions shown.

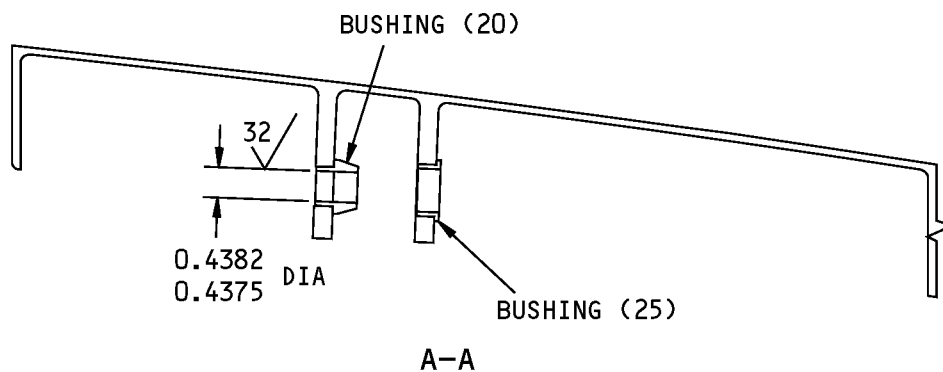
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COMPONENT MAINTENANCE MANUAL



113A8331-1 SHOWN
113A8331-2 OPPOSITE



1 USE THE SHRINK-FIT PROCEDURE TO INSTALL THE BUSHING WITH WET BMS 5-95 SEALANT

2 DO NOT APPLY PRIMER OR ENAMEL TO BUSHINGS

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

113A8331-1,-2 Inboard Door Assembly
Figure 601

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REPAIR 4-1
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COMPONENT MAINTENANCE MANUAL

INBOARD DOOR - REPAIR 4-2

113A8331-5, -6, -7, -8

1. General

- A. This procedure has the data necessary to repair and refinish the inboard door (30, 30A, 35, 35A).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the True Position Dimensioning Symbols used in the repair.
- D. Refer to IPL Figure 3 for item numbers.
- E. General repair details:
 - (1) Material: Aluminum alloy

2. Repair Procedures

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

| Reference | Description | Specification |
|-----------|-------------------------------------------------------------------------------------|-----------------------|
| C00033 | Coating - Exterior Protective Enamel, Flexibility Use | BMS10-60, Type II |
| 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. Inboard Door Refinish (REPAIR 4-2, Figure 601)

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

- (1) Boric acid - sulfuric acid anodize (F-17.31). After bushing installation (REPAIR 4-1), apply primer, C00175 (F-19.47) and enamel coating, C00033(F-19.39-707) but not on bushings.

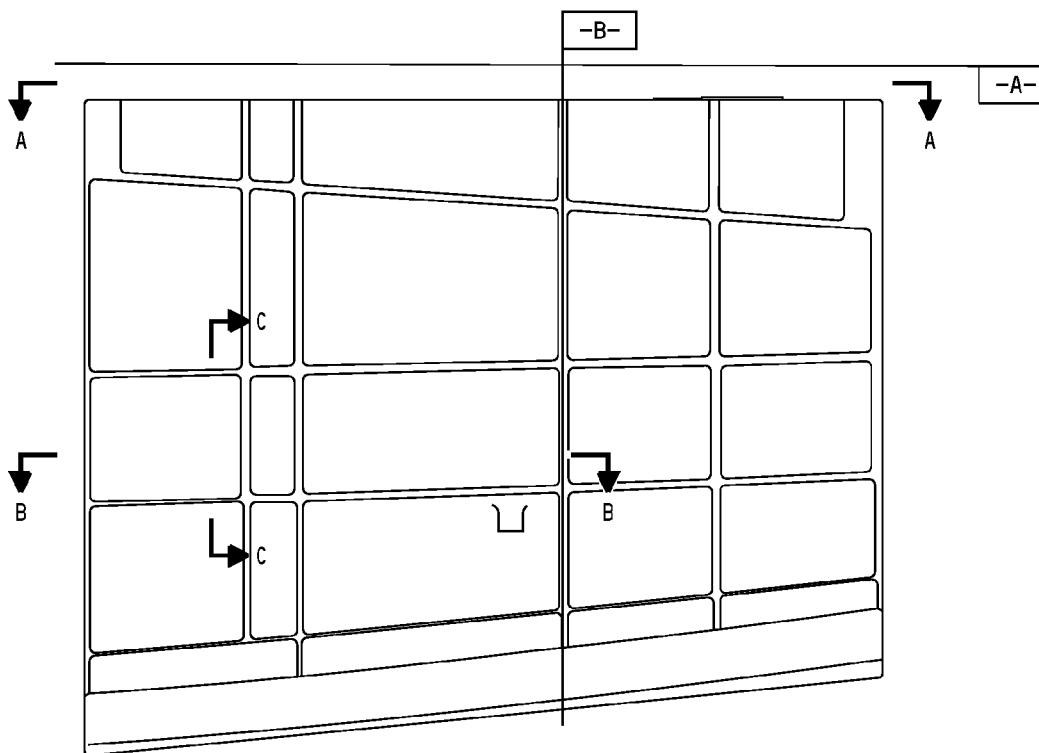
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REPAIR 4-2

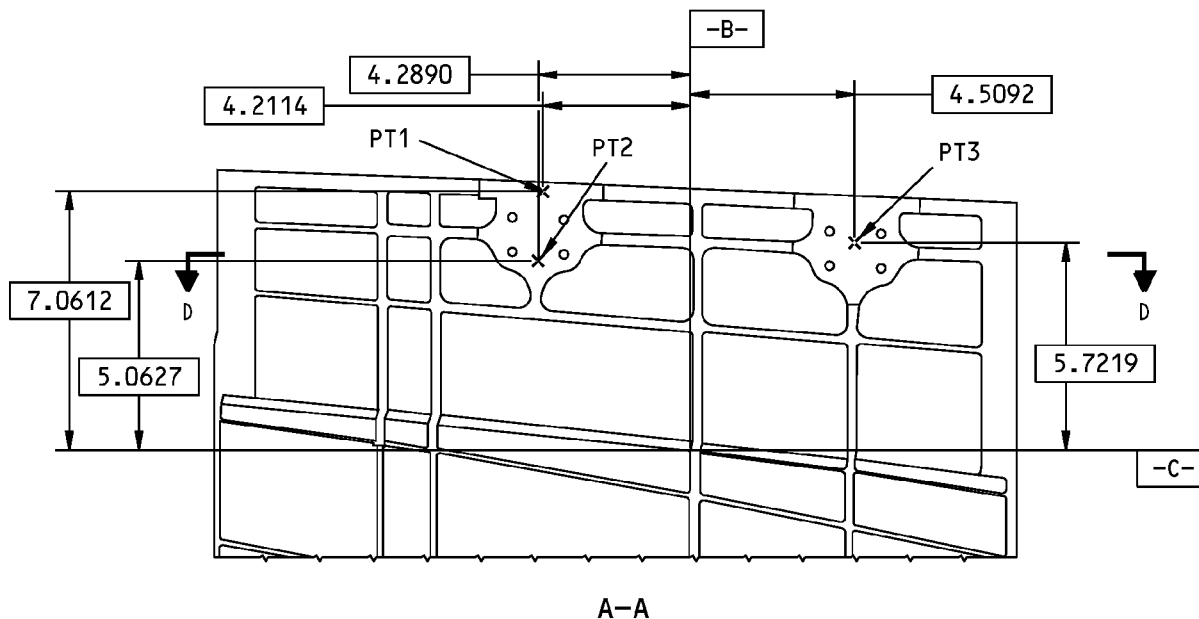
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COMPONENT MAINTENANCE MANUAL



113A8331-5 SHOWN
113A8331-7 SIMILAR
113A8331-6,-8 OPPOSITE

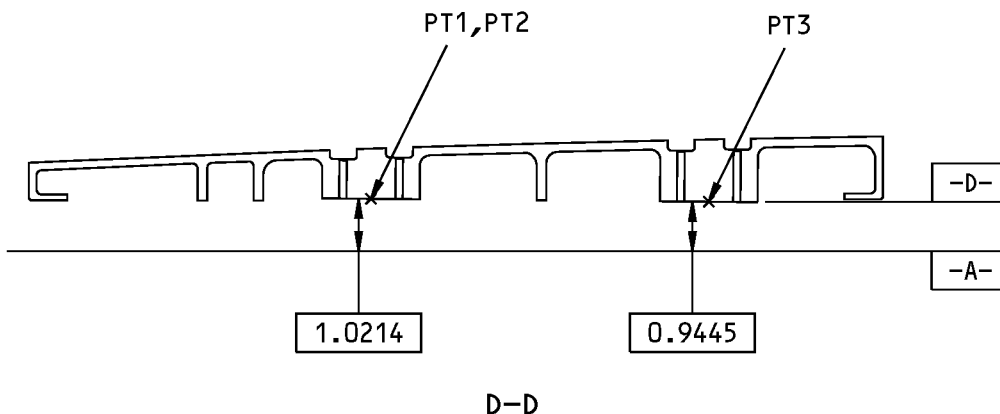


113A8331-5,-6,-7,-8 Inboard Door Repair
Figure 601 (Sheet 1 of 3)

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REPAIR 4-2
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COMPONENT MAINTENANCE MANUAL



1 DO NOT APPLY PRIMER OR ENAMEL TO BORES FOR BUSHINGS

125 ✓ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 3

ALL DIMENSIONS ARE IN INCHES

113A8331-5,-6,-7,-8 Inboard Door Repair
Figure 601 (Sheet 3 of 3)

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REPAIR 4-2

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COMPONENT MAINTENANCE MANUAL

OUTBOARD PUSHROD ASSEMBLY - REPAIR 5-1

113A8500-1, -2

1. General

- A. This procedure has the data necessary to assemble the outboard pushrod assembly (1).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 4 for item numbers.

2. Assembly

A. References

| <u>Reference</u> | <u>Title</u> |
|------------------|---------------------------|
| SOPM 20-50-01 | BOLT AND NUT INSTALLATION |

B. Procedure (REPAIR 5-1, Figure 601)

- (1) Use standard industry procedures to assemble this component (SOPM 20-50-01).

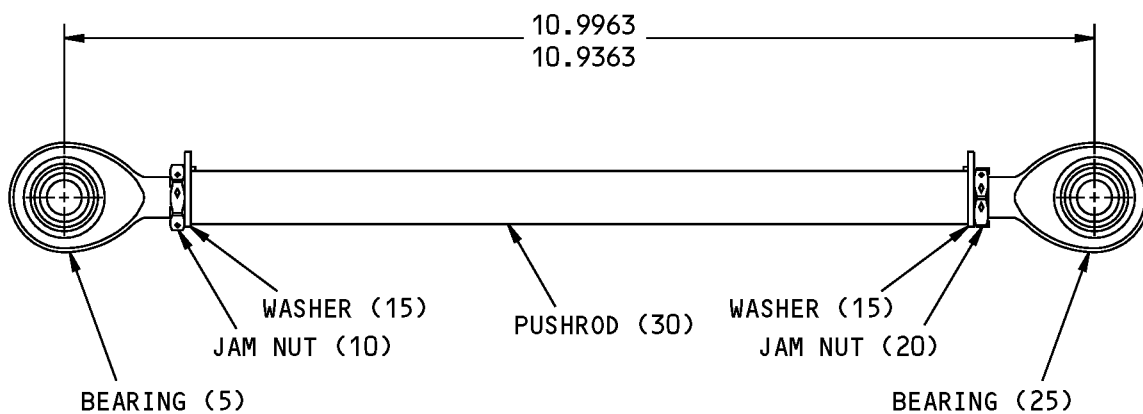
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REPAIR 5-1

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

113A8500-1,-2 Outboard Pushrod Assembly Repair
Figure 601

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REPAIR 5-1
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COMPONENT MAINTENANCE MANUAL

INBOARD PUSHROD ASSEMBLY - REPAIR 6-1

113A8600-3

1. General

- A. This procedure has the data necessary to assemble the inboard pushrod assembly (1).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 5 for item numbers.

2. Assembly

A. References

| <u>Reference</u> | <u>Title</u> |
|------------------|---------------------------|
| SOPM 20-50-01 | BOLT AND NUT INSTALLATION |

B. Procedure (REPAIR 6-1, Figure 601)

- (1) Use standard industry procedures to assemble this component (SOPM 20-50-01).

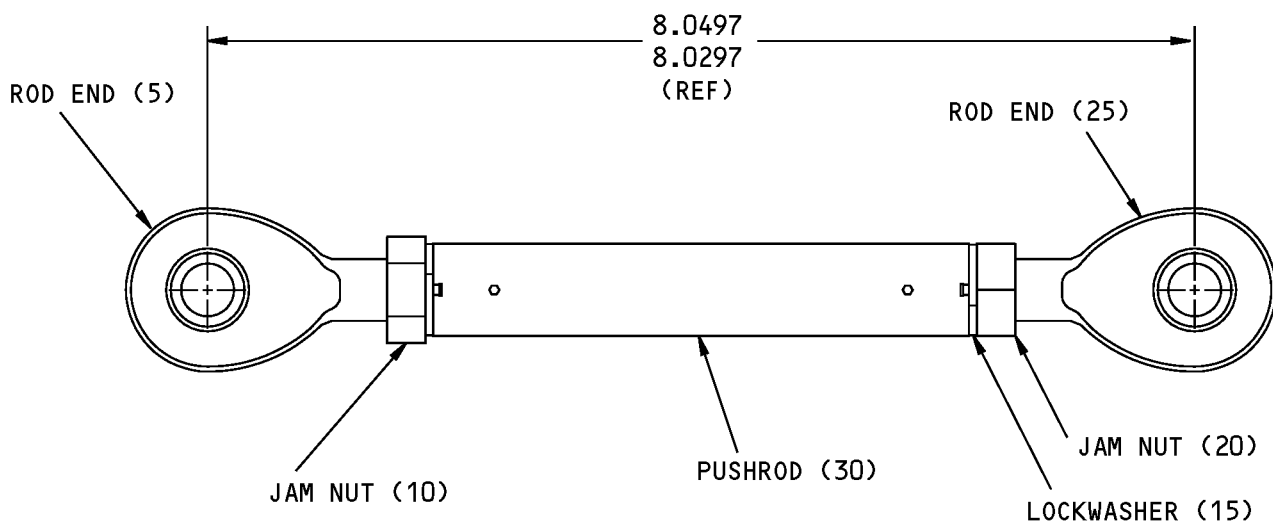
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REPAIR 6-1

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ITEM NUMBERS REFER TO IPL FIG. 5

ALL DIMENSIONS ARE IN INCHES

113A8600-3 Inboard Pushrod Assembly Repair
Figure 601

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REPAIR 6-1

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113A8100, 113A8200, 113A8331,
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ASSEMBLY

(NOT APPLICABLE)

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ASSEMBLY

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FITS AND CLEARANCES

(NOT APPLICABLE)

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FITS AND CLEARANCES

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113A8500, 113A8600



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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ILLUSTRATED PARTS LIST

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COMPONENT MAINTENANCE MANUAL

| | |
|---------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------|
| 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 |
|-------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 06725 | AIR INDUSTRIES CORPORATION 12570 KNOTT STREET GARDEN GROVE, CALIFORNIA 92641-3932 FORMERLY AIR INDUSTRIES OF CALIF IN GARDENA, CALIF. |
| 08524 | Replaced: [V08524] DEUTSCH FASTENER CORP SEE CODE V97928 Replaced: [V97928] SEE V17446 HUCK INTL by Code: Name and Address below 17446: HUCK INTL INC AEROSPACE FASTENER DIV 900 WATSON CENTER ROAD CARSON, CALIFORNIA 90745-4201 FORMERLY V32134 REXNORD INC; FORMERLY V97928 HUCK INTL Referenced in FORMERLY line below [17419] DEUTSCH COMPANY THE WELLS FARGO BANK BLDG 2444 WILSHIRE BLVD #600 SANTA MONICA, CALIFORNIA 90403 FORMERLY DEUTSCH FASTENER CORP V08524 FORMERLY IN LOS ANGELES |
| OPTK6 | SPS TECHNOLOGIES INC AEROSPACE PRODUCTS DIV 5195 W 4700 SALT LAKE CITY, UTAH 94118 SEE V56878 SPS TECHNOLOGIES INC |
| 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 |

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| Code | Name |
|-------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 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 |
| 52828 | REPUBLIC FASTENER MFG CORP 1300 RANCHO CONEJO BLVD NEWBURY PARK, CALIFORNIA 91320-1405 FORMERLY IN SYLMAR, CALIFORNIA |
| 56878 | SPS TECHNOLOGIES INC AEROSPACE AND INDUSTRIAL PRODUCTS DIV 301 HIGHLAND AVE JENKINTOWN, PENNSYLVANIA 19046 FORMERLY STANDARD PRESSED STEEL FORMERLY IN SALT LAKE, UTAH |
| 5M902 | ALCOA GLOBAL FASTENERS INC, DIV OF VOI-SHAN PRODUCTS 3000 W LOMITA BLVD TORRANCE, CALIFORNIA 90505-5103 FORMERLY FAIRCHILD INC INC FAIRCHILD AEROSPACE FASTENERS DIV |
| 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 |
| 73197 | HI-SHEAR TECHNOLOGY CORP 2600 SKYPARK DRIVE TORRANCE, CALIFORNIA 90509 |

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COMPONENT MAINTENANCE MANUAL

| Code | Name |
|-------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 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 |
| 92215 | FAIRCHILD IND INC FAIRCHILD AEROSPACE FASTENER DIV 3010 W LOMITA BLVD TORRANCE, CALIFORNIA 90505-5102 FORMERLY VOI-SHAN IN CULVER CITY, CALIF |
| 97928 | Replaced: [V97928] SEE V17446 HUCK INTL by Code: Name and Address below 17446: HUCK INTL INC AEROSPACE FASTENER DIV 900 WATSON CENTER ROAD CARSON, CALIFORNIA 90745-4201 FORMERLY V32134 REXNORD INC; FORMERLY V97928 HUCK INTL |
| 9N513 | VOI SHAN/CHATSWORTH DIV OF VSI CORP SUB OF FAIRCHILD IND CHATSWORTH, CALIFORNIA 91311-5013 COMPANY NO LONGER WISHES TO BE CONSIDERED FOR FED CONTRCTG |

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NUMERICAL INDEX

| PART NUMBER | AIRLINE PART NUMBER | FIGURE | ITEM | UNITS PER ASSEMBLY |
|--------------|---------------------|--------|------|--------------------|
| 102A9213-2-3 | | 2 | 450 | 17 |
| 102F9201-3 | | 2 | 495A | 6 |
| | | 2 | 497 | 2 |
| | | 2 | 498 | 5 |
| 113A8100-3 | | 1 | 1A | RF |
| 113A8100-4 | | 1 | 5 | RF |
| 113A8100-5 | | 1 | 1B | RF |
| | | 6 | 1A | RF |
| 113A8100-6 | | 1 | 5A | RF |
| | | 6 | 5 | RF |
| 113A8130-5 | | 1 | 140 | 1 |
| 113A8130-6 | | 1 | 145 | 1 |
| 113A8131-1 | | 6 | 125 | 1 |
| 113A8131-2 | | 6 | 130 | 1 |
| 113A8140-1 | | 1 | 55 | 1 |
| | | 6 | 55 | 1 |
| 113A8140-2 | | 1 | 60 | 1 |
| | | 6 | 60 | 1 |
| 113A8140-3 | | 1 | 85 | 1 |
| | | 6 | 85 | 1 |
| 113A8140-4 | | 1 | 90 | 1 |
| | | 6 | 90 | 1 |
| 113A8141-1 | | 1 | 95 | 1 |
| | | 6 | 25 | 1 |
| 113A8141-2 | | 1 | 100 | 1 |
| | | 6 | 30 | 1 |
| 113A8141-3 | | 1 | 115 | 1 |
| | | 6 | 45 | 1 |
| 113A8141-4 | | 1 | 120 | 1 |
| | | 6 | 50 | 1 |
| 113A8200-3 | | 1 | 10 | RF |
| | | 2 | 1 | RF |
| 113A8200-4 | | 1 | 15 | RF |
| | | 2 | 5 | RF |

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| PART NUMBER | AIRLINE PART NUMBER | FIGURE | ITEM | UNITS PER ASSEMBLY |
|-------------|---------------------|--------|------|--------------------|
| 113A8200-5 | | 1 | 10A | RF |
| | | 2 | 1A | RF |
| 113A8200-6 | | 1 | 15A | RF |
| | | 2 | 5A | RF |
| 113A8220-1 | | 2 | 510 | 1 |
| 113A8220-2 | | 2 | 515 | 1 |
| 113A8220-3 | | 2 | 512 | 1 |
| 113A8220-4 | | 2 | 517 | 1 |
| 113A8221-1 | | 2 | 480 | 1 |
| 113A8221-10 | | 2 | 488 | 1 |
| 113A8221-11 | | 2 | 503 | 1 |
| 113A8221-12 | | 2 | 508 | 1 |
| 113A8221-2 | | 2 | 485 | 1 |
| 113A8221-3 | | 2 | 500 | 1 |
| 113A8221-4 | | 2 | 505 | 1 |
| 113A8221-5 | | 2 | 482 | 1 |
| 113A8221-6 | | 2 | 487 | 1 |
| 113A8221-7 | | 2 | 502 | 1 |
| 113A8221-8 | | 2 | 507 | 1 |
| 113A8221-9 | | 2 | 483 | 1 |
| 113A8222-3 | | 2 | 465 | 1 |
| 113A8222-4 | | 2 | 470 | 1 |
| 113A8223-5 | | 2 | 435 | 1 |
| 113A8223-6 | | 2 | 440 | 1 |
| 113A8223-7 | | 2 | 455 | 1 |
| 113A8223-8 | | 2 | 460 | 1 |
| 113A8231-1 | | 2 | 560 | 1 |
| 113A8231-2 | | 2 | 565 | 1 |
| 113A8232-1 | | 2 | 560A | 1 |
| 113A8232-2 | | 2 | 565A | 1 |
| 113A8240-1 | | 2 | 290 | 1 |
| 113A8240-2 | | 2 | 295 | 1 |
| 113A8240-3 | | 2 | 305 | 1 |
| 113A8240-4 | | 2 | 310 | 1 |
| 113A8241-1 | | 2 | 125 | 1 |

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| PART NUMBER | AIRLINE PART NUMBER | FIGURE | ITEM | UNITS PER ASSEMBLY |
|--------------------|----------------------------|---------------|-------------|---------------------------|
| 113A8241-2 | | 2 | 130 | 1 |
| 113A8241-3 | | 2 | 140 | 1 |
| 113A8241-4 | | 2 | 145 | 1 |
| 113A8242-1 | | 2 | 160 | 1 |
| 113A8242-2 | | 2 | 165 | 1 |
| 113A8242-3 | | 2 | 150 | 1 |
| 113A8242-4 | | 2 | 155 | 1 |
| 113A8242-5 | | 2 | 325 | 1 |
| 113A8242-6 | | 2 | 330 | 1 |
| 113A8242-7 | | 2 | 315 | 1 |
| 113A8242-8 | | 2 | 320 | 1 |
| 113A8243-1 | | 2 | 60 | 1 |
| 113A8243-2 | | 2 | 60A | 1 |
| 113A8244-1 | | 2 | 40 | 1 |
| 113A8244-2 | | 2 | 55 | 1 |
| 113A8245-1 | | 2 | 75 | 2 |
| 113A8245-3 | | 2 | 90 | 1 |
| 113A8246-1 | | 2 | 280 | 3 |
| 113A8248-1 | | 2 | 235 | 1 |
| 113A8248-2 | | 2 | 240 | 1 |
| 113A8248-3 | | 2 | 255 | 1 |
| 113A8248-4 | | 2 | 260 | 1 |
| 113A8248-5 | | 2 | 395 | 1 |
| 113A8248-6 | | 2 | 400 | 1 |
| 113A8248-7 | | 2 | 415 | 1 |
| 113A8248-8 | | 2 | 420 | 1 |
| 113A8249-1 | | 2 | 265 | 1 |
| 113A8249-2 | | 2 | 425 | 1 |
| 113A8249-3 | | 2 | 225 | 1 |
| 113A8249-4 | | 2 | 230 | 1 |
| 113A8249-5 | | 2 | 390 | 1 |
| 113A8249-6 | | 1 | 125 | 1 |
| | | 6 | 100 | 1 |
| 113A8249-7 | | 1 | 130 | 1 |
| | | 6 | 95 | 1 |

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| PART NUMBER | AIRLINE PART NUMBER | FIGURE | ITEM | UNITS PER ASSEMBLY |
|-----------------|---------------------|--------|------|--------------------|
| 113A8249-8 | | 2 | 265A | 1 |
| 113A8249-9 | | 2 | 425A | 1 |
| 113A8331-1 | | 1 | 20 | RF |
| | | 3 | 1 | RF |
| 113A8331-2 | | 1 | 25 | RF |
| | | 3 | 5 | RF |
| 113A8331-3 | | 3 | 10 | 1 |
| 113A8331-4 | | 3 | 15 | 1 |
| 113A8331-5 | | 3 | 30 | 1 |
| 113A8331-6 | | 3 | 35 | 1 |
| 113A8331-7 | | 3 | 30A | 1 |
| 113A8331-8 | | 3 | 35A | 1 |
| 113A8332-1 | | 3 | 20 | 1 |
| 113A8341-1 | | 2 | 355 | 1 |
| 113A8341-2 | | 2 | 190 | 1 |
| 113A8341-3 | | 2 | 205 | 1 |
| | | 2 | 370 | 1 |
| 113A8500-1 | | 1 | 30 | RF |
| | | 4 | 1 | RF |
| 113A8500-2 | | 1 | 30A | RF |
| | | 4 | 1A | RF |
| 113A8540-1 | | 4 | 30 | 1 |
| 113A8540-2 | | 4 | 30A | 1 |
| 113A8541-1 | | 4 | 15 | 2 |
| 113A8600-3 | | 1 | 35A | RF |
| | | 5 | 1A | RF |
| 113A8640-1 | | 5 | 30 | 1 |
| 113A8700-1 | | 2 | 35 | 2 |
| 113W8246-1 | | 2 | 115 | 4 |
| BACB28AP05P015 | | 1 | 80A | 1 |
| | | 6 | 80 | 1 |
| BACB28AT07B015C | | 1 | 75A | 1 |
| | | 6 | 75 | 1 |
| BACB28AT07D012C | | 1 | 105 | 2 |
| | | 6 | 35 | 2 |

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| PART NUMBER | AIRLINE PART NUMBER | FIGURE | ITEM | UNITS PER ASSEMBLY |
|--------------------|----------------------------|---------------|-------------|---------------------------|
| BACB28AT08B013C | | 2 | 80 | 2 |
| BACB28AT08D013C | | 1 | 65 | 2 |
| | | 6 | 65 | 2 |
| BACB28AT10B026C | | 3 | 25 | 1 |
| BACB28AU05B018C | | 1 | 110 | 2 |
| | | 6 | 40 | 2 |
| BACB28AU06B019C | | 1 | 70 | 2 |
| | | 2 | 85 | 2 |
| | | 6 | 70 | 2 |
| BACB28AU06D022B | | 2 | 135A | 1 |
| | | 2 | 300 | 1 |
| BACB28BB05A091C | | 2 | 200 | 1 |
| | | 2 | 365 | 1 |
| BACB28BB05A098C | | 2 | 250 | 1 |
| BACB28BB05A103C | | 2 | 245 | 1 |
| BACB28BB05A107C | | 2 | 410 | 1 |
| BACB28BB05A110C | | 2 | 405 | 1 |
| BACB28BC05A091C | | 2 | 195 | 1 |
| | | 2 | 360 | 1 |
| BACB30NN4K12 | | 2 | 110 | 4 |
| | | 2 | 275 | 3 |
| BACB30NY6K4 | | 2 | 65 | 8 |
| BACB30NY6K6 | | 2 | 95 | 4 |
| BACB30NY8K6 | | 1 | 45 | 4 |
| BACB30NY8K7 | | 6 | 10 | 4 |
| BACB30NY8K9 | | 1 | 40 | 4 |
| | | 6 | 15 | 4 |
| BACB30PW5CD86 | | 2 | 175A | 1 |
| BACB30PW5CD88 | | 2 | 340A | 1 |
| BACB30PW6CD19 | | 2 | 15A | 2 |
| BACB30VF3K3 | | 2 | 430 | 17 |
| | | 2 | 477 | 7 |
| BACB30VF3K4 | | 2 | 475 | 6 |
| BACB30VT6K4 | | 2 | 380 | 3 |
| BACB30VT6K5 | | 2 | 210 | 3 |

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| PART NUMBER | AIRLINE PART NUMBER | FIGURE | ITEM | UNITS PER ASSEMBLY |
|----------------|---------------------|--------|------|--------------------|
| | | 2 | 375 | 3 |
| BACB30VT6K6 | | 2 | 215 | 3 |
| BACC30BH6 | | 2 | 70 | 8 |
| | | 2 | 100 | 4 |
| BACC30BH8 | | 1 | 50 | 8 |
| | | 6 | 20 | 8 |
| BACC30BL6 | | 2 | 220 | 6 |
| | | 2 | 385 | 6 |
| BACG20ZC000120 | | 1 | 135 | 1 |
| BACJ40A20-3 | | 2 | 535 | 1 |
| BACJ40A21-7 | | 1 | 138L | 1 |
| BACJ40A21-8 | | 2 | 555 | 1 |
| | | 6 | 120 | 1 |
| BACN10JD4CD | | 2 | 185 | 1 |
| | | 2 | 350 | 1 |
| BACN10JD5CD | | 2 | 30 | 2 |
| BACN10JR3CFD | | 2 | 495A | 6 |
| | | 2 | 497 | 2 |
| | | 2 | 498 | 5 |
| BACN10KE3B2CD | | 2 | 450 | 17 |
| BACN10YR3CD | | 2 | 530 | 1 |
| | | 2 | 550 | 1 |
| BACN10YR4CD | | 1 | 138 | 1 |
| | | 6 | 115 | 1 |
| BACP18BC01A10P | | 2 | 10 | 2 |
| | | 2 | 170 | 1 |
| | | 2 | 335 | 1 |
| BACR15BA3AD | | 2 | 445 | 34 |
| | | 2 | 490 | 12 |
| | | 2 | 492 | 4 |
| | | 2 | 493 | 10 |
| BACR15GF5D | | 2 | 105 | 4 |
| | | 2 | 270 | 5 |
| BACW10BP4DP | | 2 | 180 | 1 |
| | | 2 | 345 | 1 |

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| PART NUMBER | AIRLINE PART NUMBER | FIGURE | ITEM | UNITS PER ASSEMBLY |
|--------------|---------------------|--------|------|--------------------|
| BACW10BP5DP | | 2 | 25 | 2 |
| BACW10BP6CD | | 2 | 20 | 2 |
| BCREF12480 | | 5 | 5 | RF |
| BCREF12763 | | 4 | 25 | 1 |
| BRF200C3D | | 2 | 495A | 6 |
| | | 2 | 497 | 2 |
| | | 2 | 498 | 5 |
| BRFR220C3-2D | | 2 | 450 | 17 |
| F51747-3-2CD | | 2 | 450 | 17 |
| H52732-3CD | | 2 | 530 | 1 |
| | | 2 | 550 | 1 |
| H52732-4CD | | 1 | 138 | 1 |
| | | 6 | 115 | 1 |
| HL1087-6 | | 2 | 70 | 8 |
| | | 2 | 70 | 8 |
| | | 2 | 70 | 8 |
| | | 2 | 70 | 8 |
| | | 2 | 100 | 4 |
| | | 2 | 100 | 4 |
| | | 2 | 100 | 4 |
| | | 2 | 100 | 4 |
| HL1087-8 | | 1 | 50 | 8 |
| | | 1 | 50 | 8 |
| | | 1 | 50 | 8 |
| | | 1 | 50 | 8 |
| | | 6 | 20 | 8 |
| | | 6 | 20 | 8 |
| | | 6 | 20 | 8 |
| | | 6 | 20 | 8 |
| HL13V4 | | 2 | 65 | 8 |
| HL13V6 | | 1 | 45 | 4 |
| | | 2 | 95 | 4 |
| HL13V7 | | 6 | 10 | 4 |
| HL13V9 | | 1 | 40 | 4 |
| | | 6 | 15 | 4 |

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| PART NUMBER | AIRLINE PART NUMBER | FIGURE | ITEM | UNITS PER ASSEMBLY |
|-------------|---------------------|--------|------|--------------------|
| HL13VAZ6-4 | | 2 | 65 | 8 |
| | | 2 | 65 | 8 |
| | | 2 | 65 | 8 |
| | | 2 | 65 | 8 |
| | | 2 | 65 | 8 |
| HL13VAZ6-6 | | 2 | 95 | 4 |
| | | 2 | 95 | 4 |
| | | 2 | 95 | 4 |
| | | 2 | 95 | 4 |
| | | 2 | 95 | 4 |
| HL13VAZ8-6 | | 1 | 45 | 4 |
| | | 1 | 45 | 4 |
| | | 1 | 45 | 4 |
| | | 1 | 45 | 4 |
| | | 1 | 45 | 4 |
| HL13VAZ8-7 | | 6 | 10 | 4 |
| | | 6 | 10 | 4 |
| | | 6 | 10 | 4 |
| | | 6 | 10 | 4 |
| | | 6 | 10 | 4 |
| HL13VAZ8-9 | | 1 | 40 | 4 |
| | | 1 | 40 | 4 |
| | | 1 | 40 | 4 |
| | | 1 | 40 | 4 |
| | | 1 | 40 | 4 |
| | | 6 | 15 | 4 |
| | | 6 | 15 | 4 |
| | | 6 | 15 | 4 |
| | | 6 | 15 | 4 |
| | | 6 | 15 | 4 |
| HST10AG6-4 | | 2 | 380 | 3 |
| | | 2 | 380 | 3 |
| | | 2 | 380 | 3 |
| | | 2 | 380 | 3 |
| HST10AG6-5 | | 2 | 210 | 3 |

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| PART NUMBER | AIRLINE PART NUMBER | FIGURE | ITEM | UNITS PER ASSEMBLY |
|---------------|---------------------|--------|------|--------------------|
| | | 2 | 210 | 3 |
| | | 2 | 210 | 3 |
| | | 2 | 210 | 3 |
| | | 2 | 375 | 3 |
| | | 2 | 375 | 3 |
| | | 2 | 375 | 3 |
| | | 2 | 375 | 3 |
| HST10AG6-6 | | 2 | 215 | 3 |
| | | 2 | 215 | 3 |
| | | 2 | 215 | 3 |
| | | 2 | 215 | 3 |
| HST79-6 | | 2 | 220 | 6 |
| | | 2 | 385 | 6 |
| HST79CY6 | | 2 | 220 | 6 |
| | | 2 | 220 | 6 |
| | | 2 | 220 | 6 |
| | | 2 | 385 | 6 |
| | | 2 | 385 | 6 |
| | | 2 | 385 | 6 |
| K51602-3BAC | | 2 | 495A | 6 |
| | | 2 | 497 | 2 |
| | | 2 | 498 | 5 |
| L801-6K4 | | 2 | 65 | 8 |
| L801-6K6 | | 2 | 95 | 4 |
| L801-8K6 | | 1 | 45 | 4 |
| L801-8K7 | | 6 | 10 | 4 |
| L801-8K9 | | 1 | 40 | 4 |
| | | 6 | 15 | 4 |
| NAS1149D0316H | | 2 | 525 | 3 |
| | | 2 | 545 | 3 |
| NAS1149D0416H | | 1 | 137L | 3 |
| | | 6 | 110 | 3 |
| NAS1801-3-7 | | 2 | 520 | 1 |
| NAS1801-3-9 | | 2 | 540 | 1 |
| NAS1801-4-8 | | 1 | 137 | 1 |

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| PART NUMBER | AIRLINE PART NUMBER | FIGURE | ITEM | UNITS PER ASSEMBLY |
|------------------|---------------------|--------|------|--------------------|
| NAS1805-4L | | 6 | 105 | 1 |
| | | 2 | 120 | 4 |
| | | 2 | 285 | 3 |
| NAS509-7C | | 2 | 45 | 1 |
| | | 4 | 10 | 1 |
| | | 5 | 20 | 1 |
| NAS509-8C | | 2 | 50 | 1 |
| | | 4 | 20 | 1 |
| | | 5 | 10 | 1 |
| NAS509L7C | | 2 | 15 | 2 |
| | | 5 | 15 | 2 |
| | | 5 | 15 | 2 |
| NAS509L8C | | 2 | 495A | 6 |
| | | 2 | 497 | 2 |
| | | 2 | 498 | 5 |
| NAS513-8 | | 2 | 450 | 17 |
| | | 2 | 450 | 17 |
| | | 2 | 450 | 17 |
| NS202476-02 | | 2 | 530 | 1 |
| | | 2 | 550 | 1 |
| | | 2 | 550 | 1 |
| NS202493-02-2 | | 1 | 138 | 1 |
| | | 6 | 115 | 1 |
| | | 6 | 115 | 1 |
| PLH53CD | | 4 | 25 | 1 |
| | | 4 | 25 | 1 |
| | | 4 | 25 | 1 |
| PLH54CD | | 5 | 5 | RF |
| | | 5 | 5 | RF |
| | | 5 | 5 | RF |
| S012T235-106-890 | | 5 | 25 | 1 |
| | | 5 | 25 | 1 |
| | | 5 | 25 | 1 |
| S012T235-106-90 | | 2 | 495A | 6 |
| | | 2 | 497 | 2 |
| | | 2 | 498 | 5 |
| S012T235-507-789 | | 2 | 497 | 2 |
| | | 2 | 497 | 2 |
| | | 2 | 497 | 2 |
| S012T235-507-79 | | 2 | 498 | 5 |
| | | 2 | 498 | 5 |
| | | 2 | 498 | 5 |
| T8092C1032CD | | 2 | 498 | 5 |
| | | 2 | 498 | 5 |
| | | 2 | 498 | 5 |

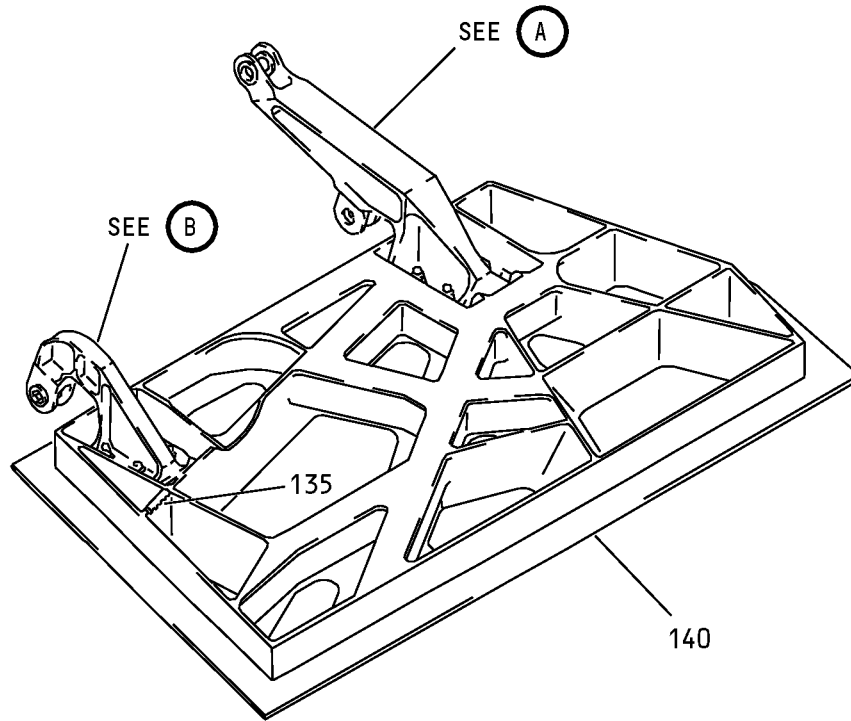
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Outboard Door Assembly
IPL Figure 1 (Sheet 1 of 3)

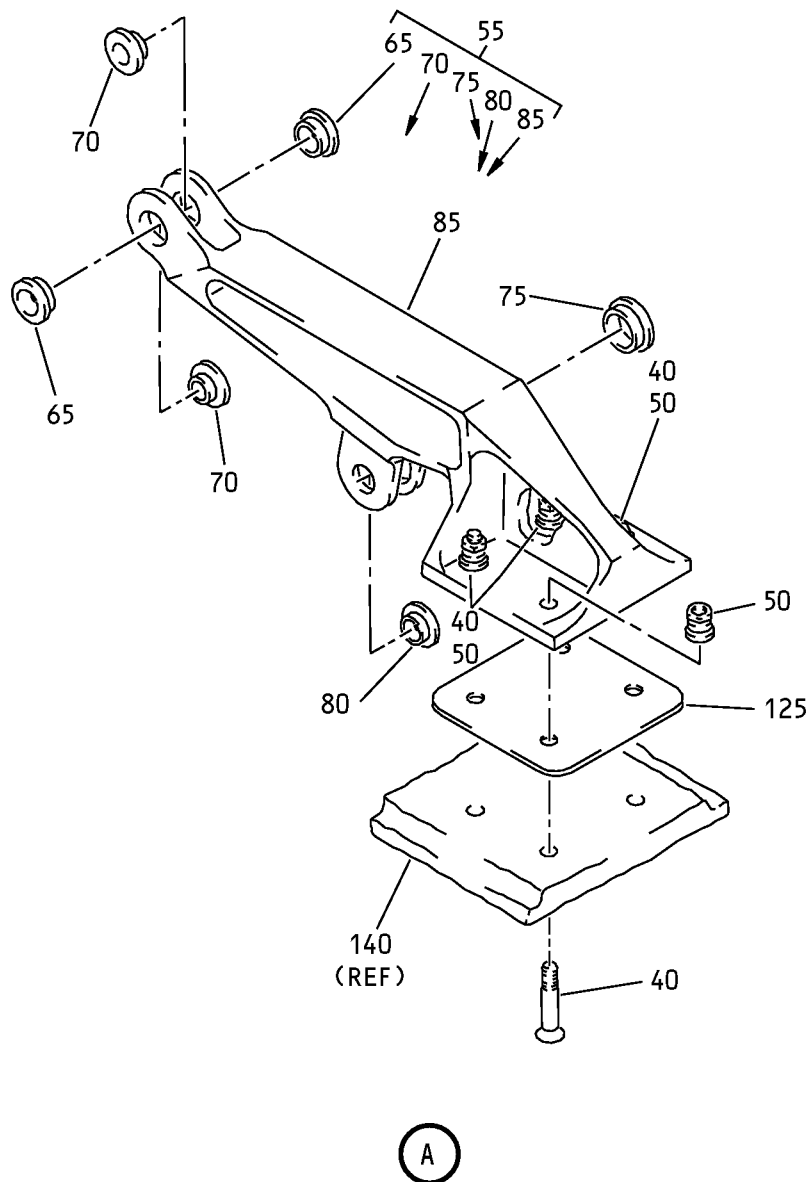
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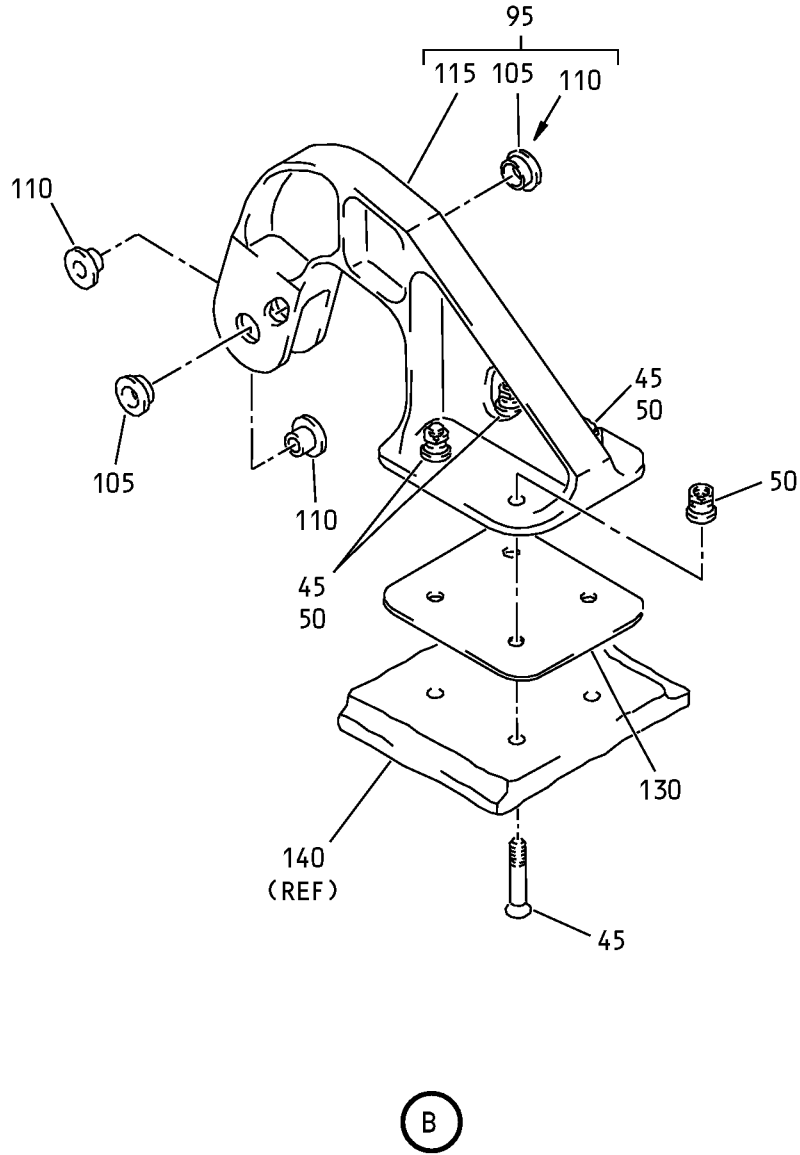
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Outboard Door Assembly
IPL Figure 1 (Sheet 2 of 3)

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(B)

Outboard Door Assembly
IPL Figure 1 (Sheet 3 of 3)

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| FIG/ ITEM | PART NUMBER | AIRLINE PART NUMBER | NOMENCLATURE | | | | | | | USAGE CODE | UNITS PER ASSY |
|--------------|-------------|---------------------------|--------------|---|---|---|---|---|---|---------------|----------------------|
| | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | | |
| 1- | | | | | | | | | | | |
| -1A | 113A8100-3 | | | | | | | | | A | RF |
| -1B | 113A8100-5 | | | | | | | | | H | RF |
| -5 | 113A8100-4 | | | | | | | | | B | RF |
| -5A | 113A8100-6 | | | | | | | | | K | RF |
| -10 | 113A8200-3 | | | | | | | | | C | RF |
| -10A | 113A8200-5 | | | | | | | | | L | RF |
| -15 | 113A8200-4 | | | | | | | | | D | RF |
| -15A | 113A8200-6 | | | | | | | | | M | RF |
| -20 | 113A8331-1 | | | | | | | | | E | RF |
| -25 | 113A8331-2 | | | | | | | | | F | RF |
| -30 | 113A8500-1 | | | | | | | | | G | RF |
| -30A | 113A8500-2 | | | | | | | | | N | RF |
| -35 | 113A8600-1 | | | | | | | | | | |
| -35A | 113A8600-3 | | | | | | | | | J | RF |
| 40 | HL13VAZ8-9 | | | | | | | | | A, B | 4 |

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| FIG/ ITEM | PART NUMBER | AIRLINE PART NUMBER | NOMENCLATURE | USAGE CODE | UNITS PER ASSY |
|--------------|-----------------|---------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------|----------------------|
| | | | | | |
| 1- 45 | HL13VAZ8-6 | | . BOLT (V56878) (SPEC BACB30NY8K6) (OPT HL13VAZ8-6 (V73197)) (OPT HL13VAZ8-6 (V92215)) (OPT HL13VAZ8-6 (V97928)) (OPT L801-8K6 (V06725)) (OPT HL13VAZ8-6 (V08524)) (OPT HL13V6 (V06725)) | A, B | 4 |
| 50 | HL1087-8 | | . COLLAR (V56878) (SPEC BACC30BH8) (OPT HL1087-8 (V92215)) (OPT HL1087-8 (V73197)) (OPT HL1087-8 (V9N513)) | A, B | 8 |
| 55 | 113A8140-1 | | . HINGE ASSY-FWD | A | 1 |
| -60 | 113A8140-2 | | . HINGE ASSY-FWD | B | 1 |
| 65 | BACB28AT08D013C | | . . BUSHING | A, B | 2 |
| 70 | BACB28AU06B019C | | . . BUSHING | A, B | 2 |
| 75 | BACB28AT09B015C | | DELETED | | |
| 75A | BACB28AT07B015C | | . . BUSHING | A, B | 1 |
| 80 | BACB28AP06P015 | | DELETED | | |
| 80A | BACB28AP05P015 | | . . BUSHING | A, B | 1 |
| 85 | 113A8140-3 | | . . FITTING | A | 1 |
| -90 | 113A8140-4 | | . . FITTING | B | 1 |
| 95 | 113A8141-1 | | . HINGE ASSY-AFT | A | 1 |
| -100 | 113A8141-2 | | . HINGE ASSY-AFT | B | 1 |
| 105 | BACB28AT07D012C | | . . BUSHING | A, B | 2 |
| 110 | BACB28AU05B018C | | . . BUSHING | A, B | 2 |
| 115 | 113A8141-3 | | . . FITTING | A | 1 |
| -120 | 113A8141-4 | | . . FITTING | B | 1 |
| 125 | 113A8249-6 | | . SHIM | A, B | 1 |
| 130 | 113A8249-7 | | . SHIM | A, B | 1 |
| 135 | BACG20ZC000120 | | . GROMMET | A, B | 1 |
| 137 | NAS1801-4-8 | | . SCREW | A, B | 1 |
| 137L | NAS1149D0416H | | . WASHER | A, B | 3 |

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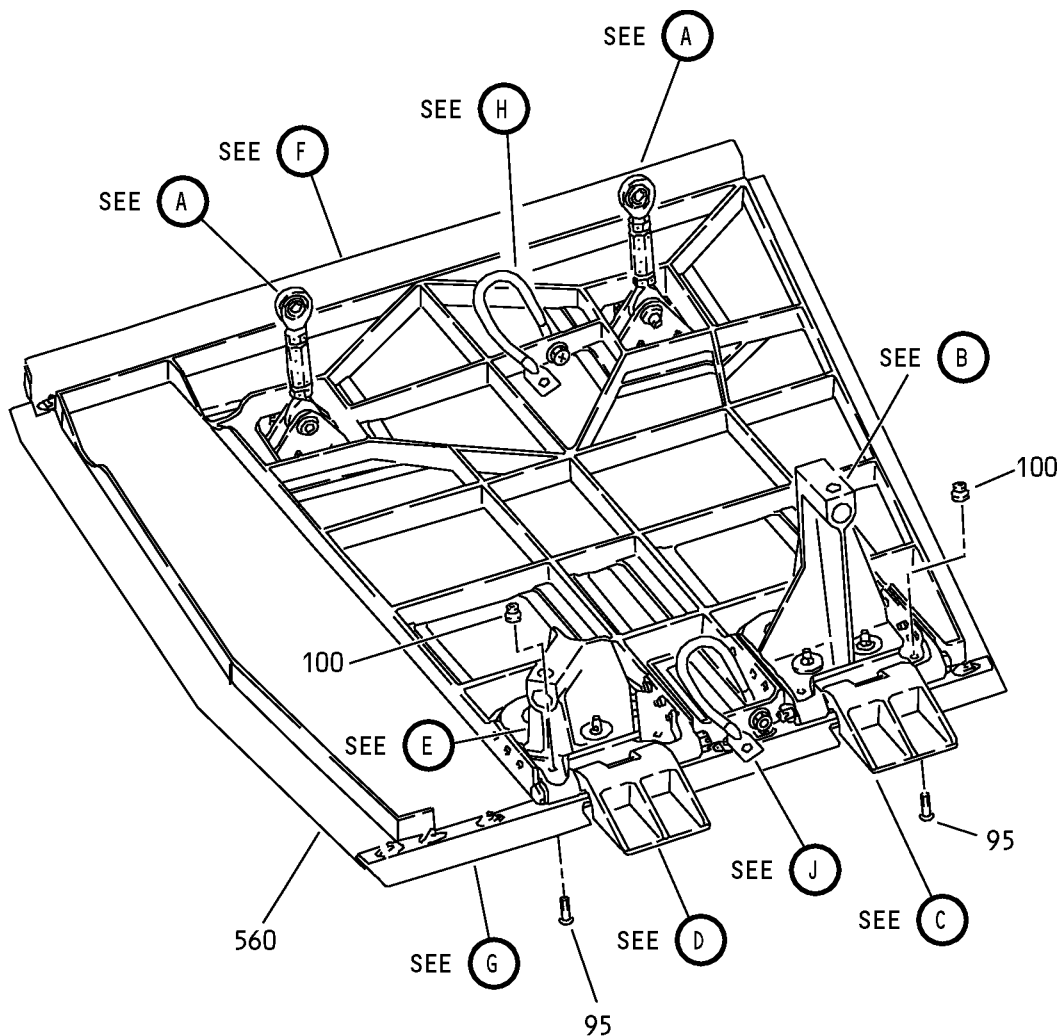


COMPONENT MAINTENANCE MANUAL

| FIG/ ITEM | PART NUMBER | AIRLINE PART NUMBER | NOMENCLATURE | | | | | | | USAGE CODE | UNITS PER ASSY |
|--------------|-------------|---------------------------|--------------|-----------------------------------------------------------------|---|---|---|---|---|---------------|----------------------|
| | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | | |
| 1- 138 | H52732-4CD | | . | NUT (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554)) | | | | | | A, B | 1 |
| 138L | BACJ40A21-7 | | . | JUMPER ASSY | | | | | | A, B | 1 |
| 140 | 113A8130-5 | | . | DOOR-CASTING MACHINED | | | | | | A | 1 |
| -145 | 113A8130-6 | | . | DOOR-CASTING MACHINED | | | | | | B | 1 |
| 145A | 113A8130-5 | | | DELETED | | | | | | | |
| -150 | 113A8130-2 | | | DELETED | | | | | | | |
| -150A | 113A8130-6 | | | DELETED | | | | | | | |

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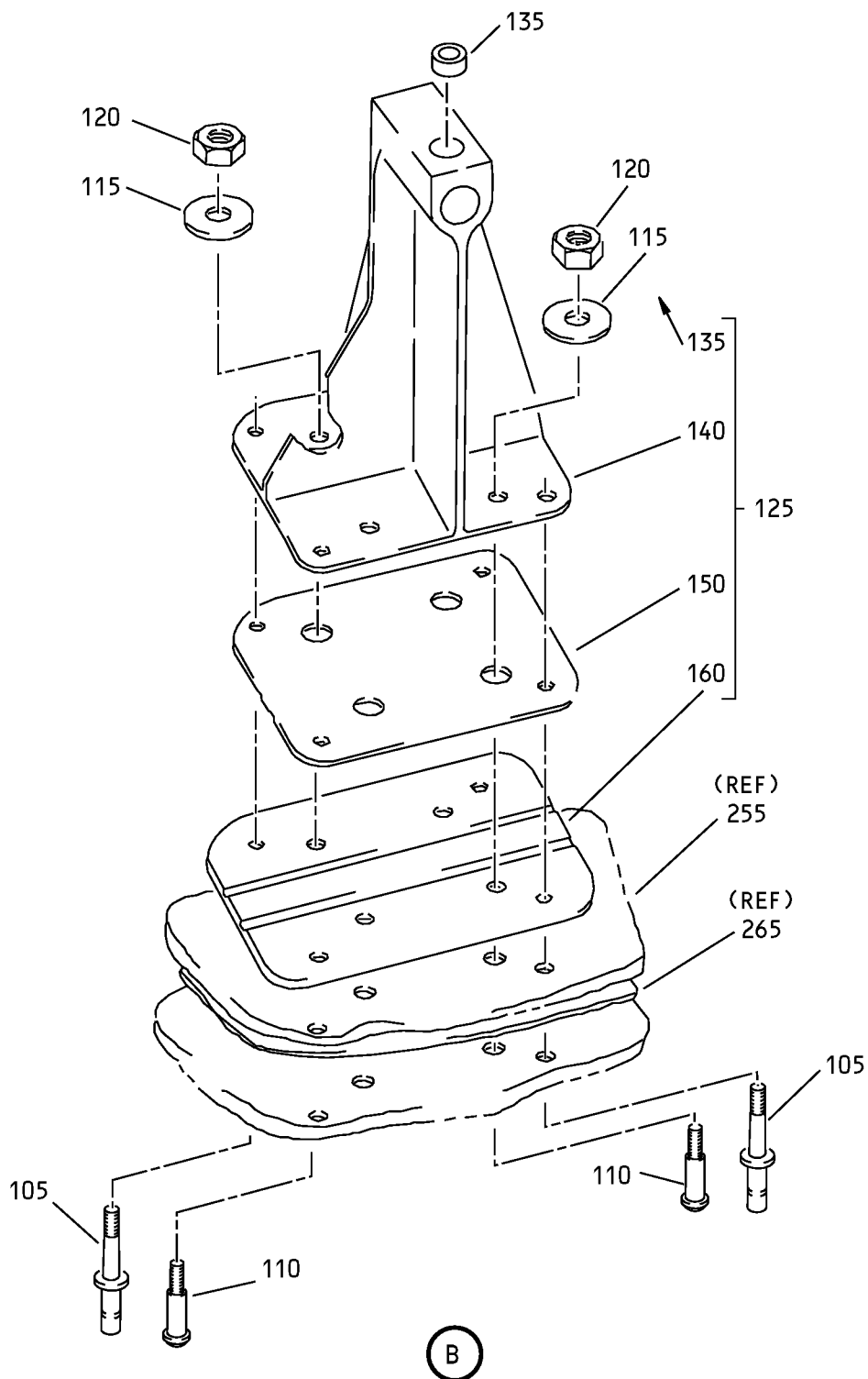
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Center Door Assembly
IPL Figure 2 (Sheet 1 of 8)

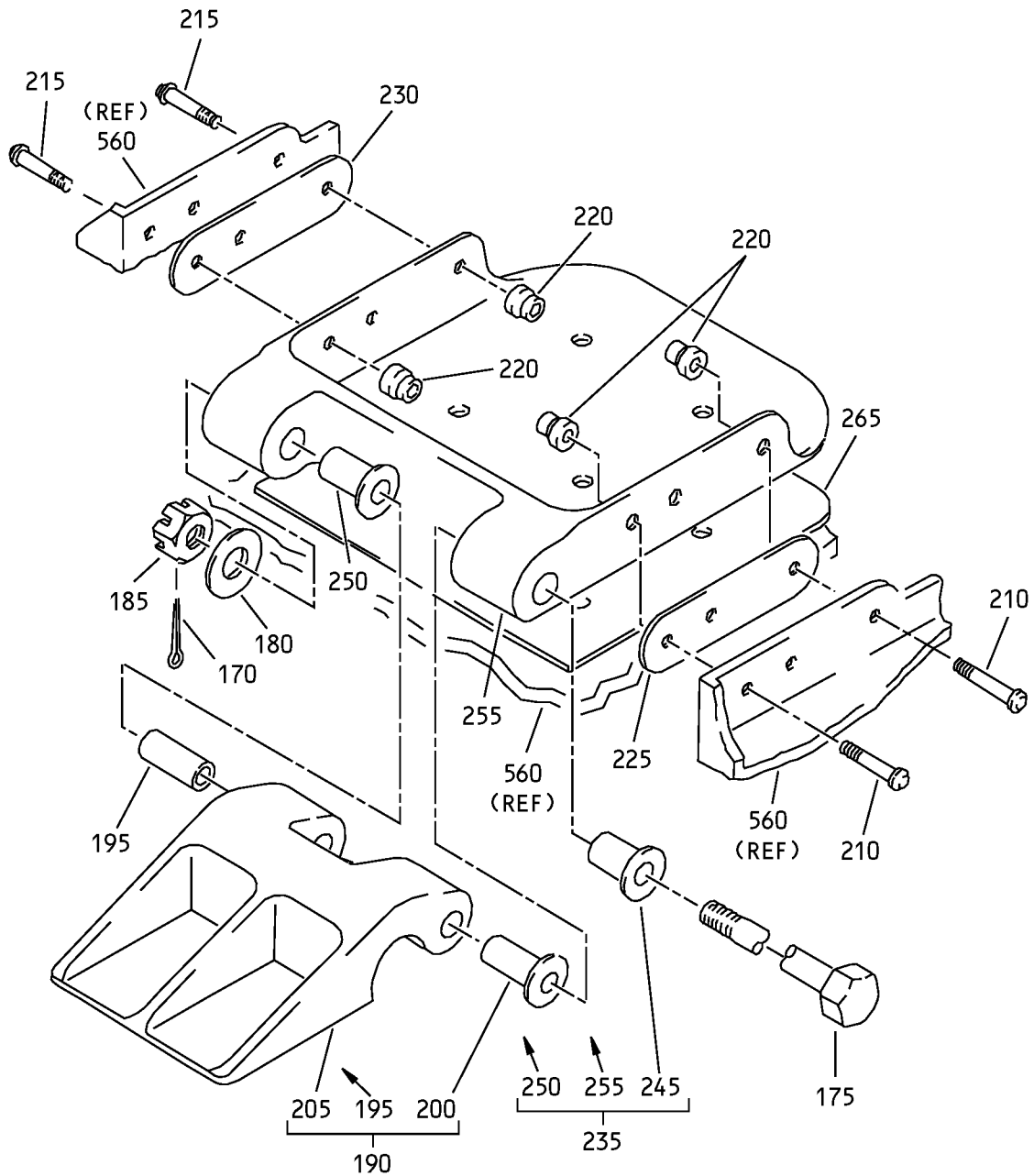
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Center Door Assembly
IPL Figure 2 (Sheet 3 of 8)

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C

Center Door Assembly
IPL Figure 2 (Sheet 4 of 8)

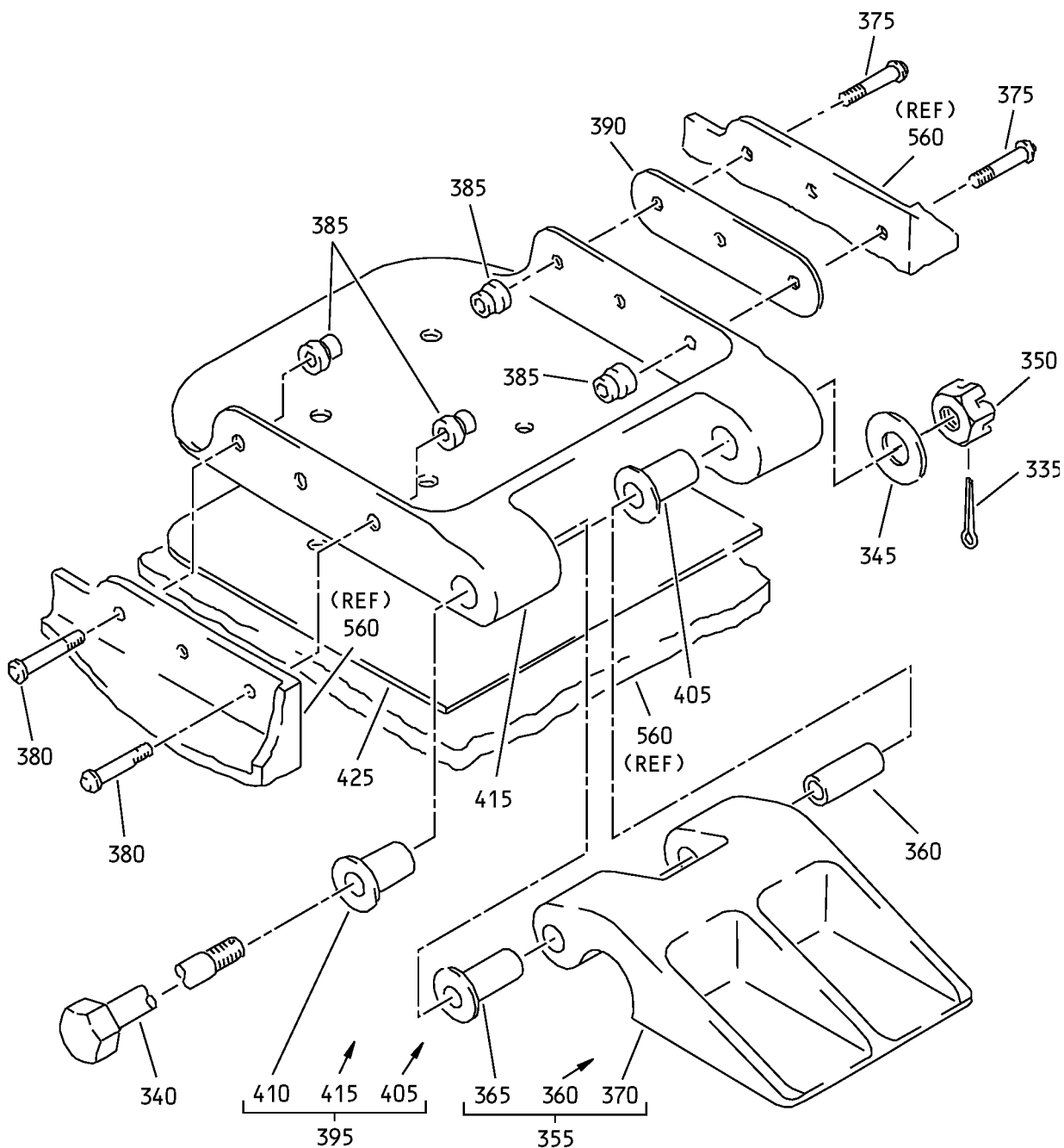
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D

Center Door Assembly
IPL Figure 2 (Sheet 5 of 8)

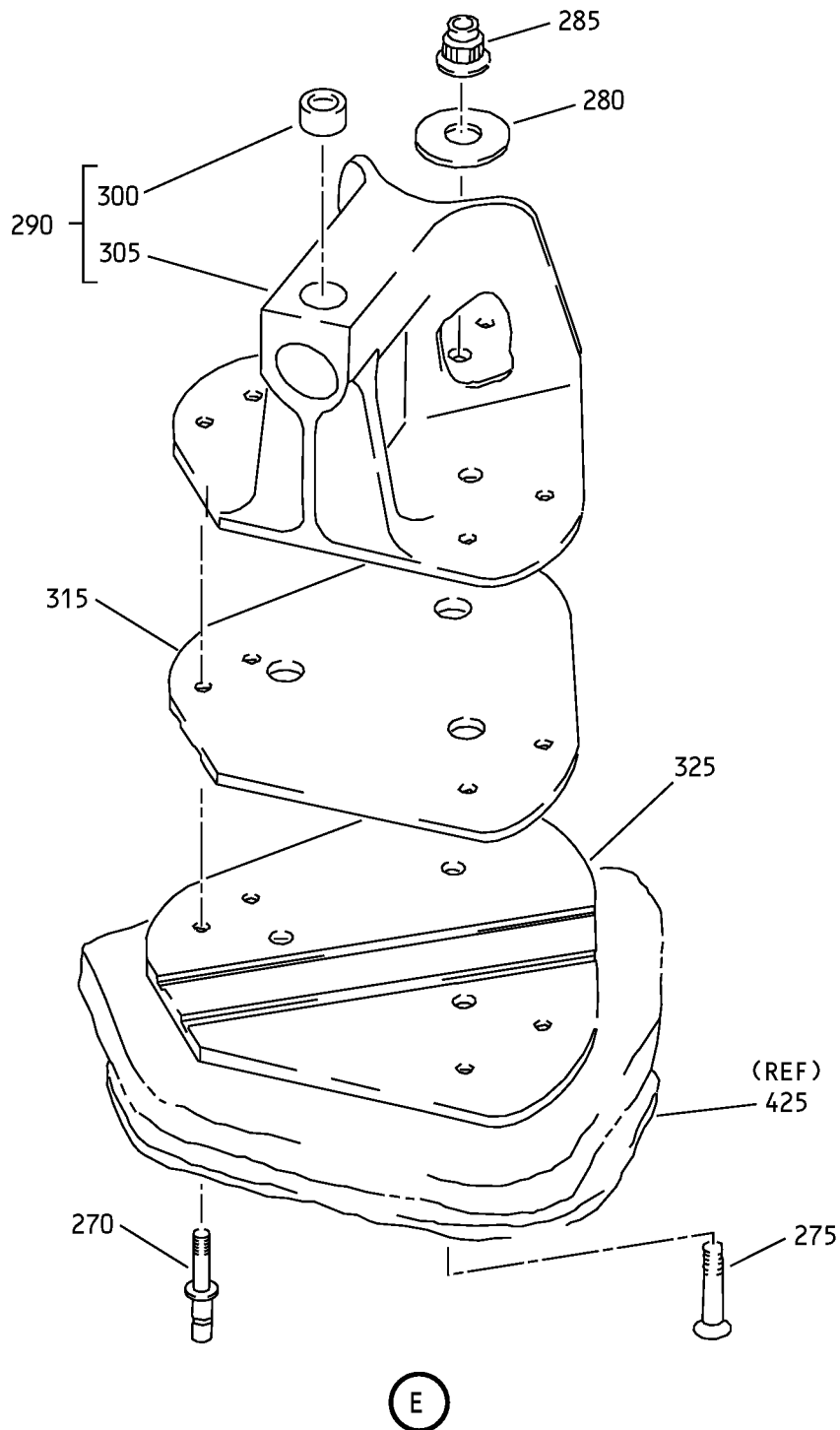
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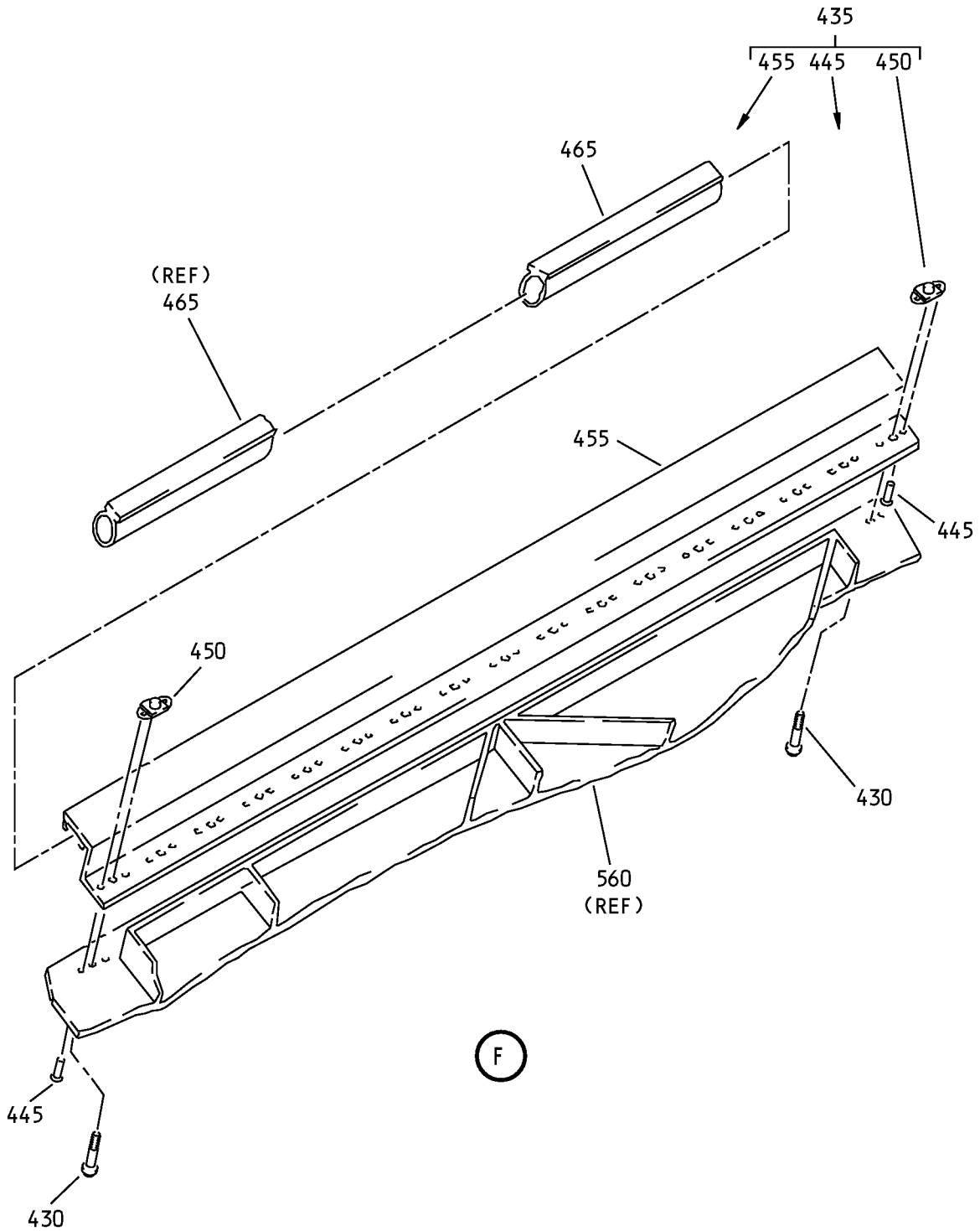
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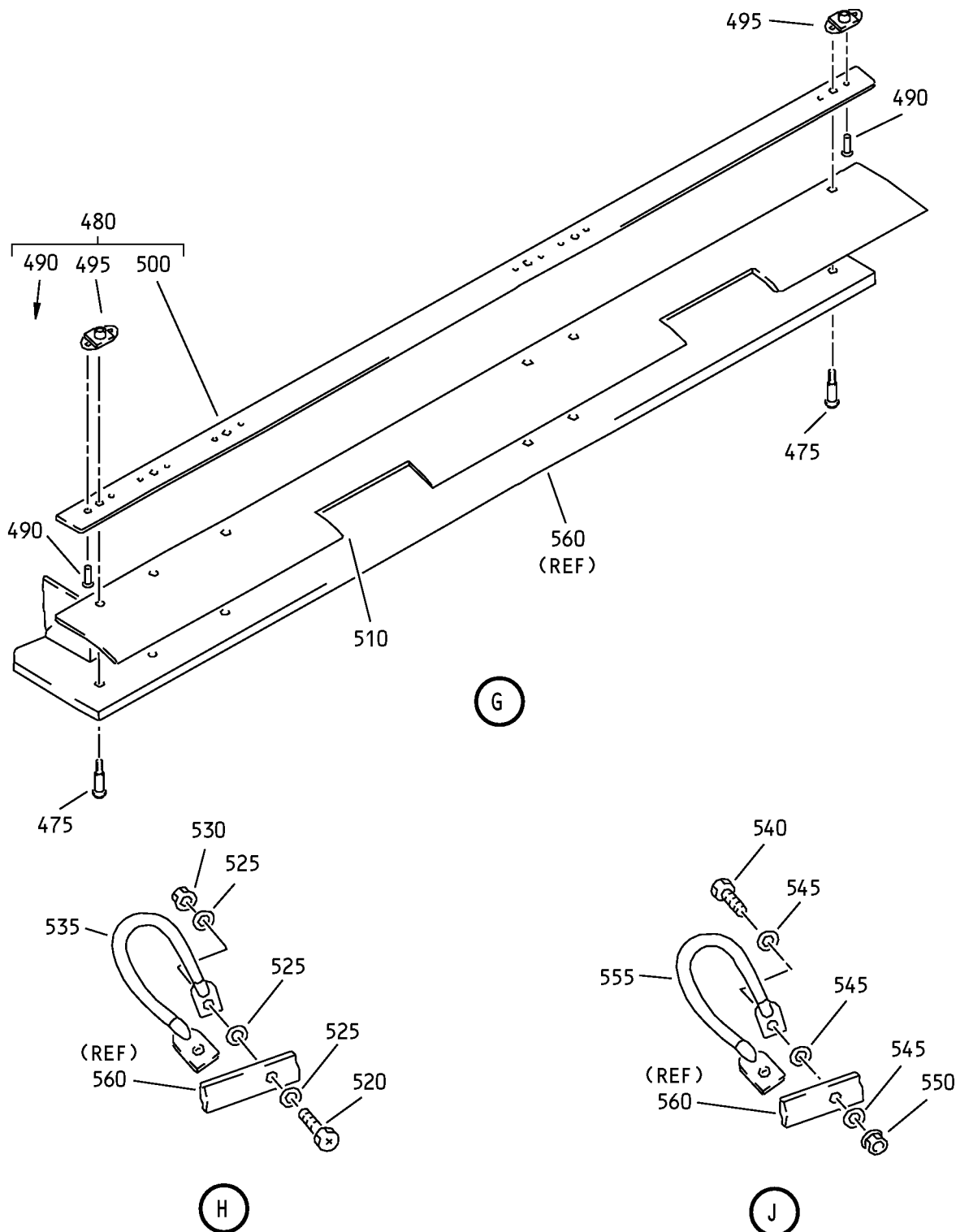
Center Door Assembly
IPL Figure 2 (Sheet 6 of 8)

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Center Door Assembly
IPL Figure 2 (Sheet 7 of 8)

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Center Door Assembly
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| FIG/ ITEM | PART NUMBER | AIRLINE PART NUMBER | NOMENCLATURE | | | | | | | USAGE CODE | UNITS PER ASSY |
|--------------|----------------|---------------------------|--------------|---|---|---|---|---|---|---------------|----------------------|
| | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | | |
| 2- | | | | | | | | | | | |
| -1 | 113A8200-3 | | | | | | | | | C | RF |
| -1A | 113A8200-5 | | | | | | | | | L | RF |
| -5 | 113A8200-4 | | | | | | | | | D | RF |
| -5A | 113A8200-6 | | | | | | | | | M | RF |
| 10 | BACP18BC01A10P | | | | | | | | | C, D, L, M | 2 |
| 15 | BACB30PW6CD19P | | | | | | | | | | DELETED |
| 15A | BACB30PW6CD19 | | | | | | | | | C, D, L, M | 2 |
| 20 | BACW10BP6CD | | | | | | | | | C, D, L, M | 2 |
| 25 | BACW10BP5DP | | | | | | | | | C, D, L, M | 2 |
| 30 | BACN10JD5CD | | | | | | | | | C, D, L, M | 2 |
| 35 | 113A8700-1 | | | | | | | | | C, D, L, M | 2 |
| 40 | 113A8244-1 | | | | | | | | | C, D, L, M | 1 |
| 45 | NAS509-7C | | | | | | | | | C, D, L, M | 1 |
| 50 | NAS509L7C | | | | | | | | | C, D, L, M | 1 |
| 55 | 113A8244-2 | | | | | | | | | C, D, L, M | 1 |
| 60 | 113A8243-1 | | | | | | | | | C, D, L, M | 1 |
| -60A | 113A8243-2 | | | | | | | | | C, D, L, M | 1 |

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| FIG/ ITEM | PART NUMBER | AIRLINE PART NUMBER | NOMENCLATURE | | | | | | | USAGE CODE | UNITS PER ASSY | |
|--------------|-----------------|---------------------------|--------------|---------------------------|--------------------|---------------------------|---------------------------|---------------------------|-------------------------|---------------------------|-----------------------|---|
| | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | | | |
| 2- 65 | HL13VAZ6-4 | | . | B | O | L | T | | | | C, D, L, M | 8 |
| | | | | (V56878) | (SPEC BACB30NY6K4) | (OPT HL13VAZ6-4 (V73197)) | (OPT HL13VAZ6-4 (V92215)) | (OPT HL13VAZ6-4 (V97928)) | (OPT L801-6K4 (V06725)) | (OPT HL13VAZ6-4 (V08524)) | (OPT HL13V4 (V06725)) | |
| 70 | HL1087-6 | | . | C | O | L | L | A | R | | C, D, L, M | 8 |
| | | | | (V73197) | (SPEC BACC30BH6) | (OPT HL1087-6 (V56878)) | (OPT HL1087-6 (V92215)) | (OPT HL1087-6 (V9N513)) | | | | |
| 75 | 113A8245-1 | | . | C | L | E | V | I | S | A | C | 2 |
| 80 | BACB28AT08B013C | | . | . | B | U | S | H | I | N | C | 2 |
| 85 | BACB28AU06B019C | | . | . | B | U | S | H | I | N | C | 2 |
| 90 | 113A8245-3 | | . | . | C | L | E | V | I | S | C, D, L, M | 1 |
| 95 | HL13VAZ6-6 | | . | B | O | L | T | | | | C, D, L, M | 4 |
| | | | | (V56878) | (SPEC BACB30NY6K6) | (OPT HL13VAZ6-6 (V73197)) | (OPT HL13VAZ6-6 (V92215)) | (OPT HL13VAZ6-6 (V97928)) | (OPT L801-6K6 (V06725)) | (OPT HL13VAZ6-6 (V08524)) | (OPT HL13V6 (V06725)) | |
| 100 | HL1087-6 | | . | C | O | L | L | A | R | | C, D, L, M | 4 |
| | | | | (V73197) | (SPEC BACC30BH6) | (OPT HL1087-6 (V56878)) | (OPT HL1087-6 (V92215)) | (OPT HL1087-6 (V9N513)) | | | | |
| 105 | BACR15GF5D | | . | R | I | V | E | T | | | C, D, L, M | 4 |
| | | | | (SIZE DETERMINED ON INST) | | | | | | | | |
| 110 | BACB30NN4K12 | | . | B | O | L | T | | | | C, D, L, M | 4 |

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| FIG/ ITEM | PART NUMBER | AIRLINE PART NUMBER | NOMENCLATURE | | | | | | | USAGE CODE | UNITS PER ASSY |
|--------------|----------------------|---------------------------|--------------|---|---|---|---|---|---|---------------|----------------------|
| | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | | |
| 2- | | | | | | | | | | | |
| 115 | 113W8246-1 | | . | W | A | S | H | E | R | C, D, L, M | 4 |
| 120 | NAS1805-4L | | . | N | U | T | | | | C, D, L, M | 4 |
| 125 | 113A8241-1 | | . | F | I | T | T | I | N | C, L | 1 |
| -130 | 113A8241-2 | | . | F | I | T | T | I | N | D, M | 1 |
| 135 | BACB28A~ W06A014C | | | | | | | | | | |
| 135A | BACB28AU06D022B | | . | . | B | U | S | H | I | C, D, L, M | 1 |
| 140 | 113A8241-3 | | . | . | F | I | T | T | I | C, L | 1 |
| -145 | 113A8241-4 | | . | . | F | I | T | T | I | D, M | 1 |
| 150 | 113A8242-3 | | . | P | L | A | T | E | | C, L | 1 |
| -155 | 113A8242-4 | | . | P | L | A | T | E | | D, M | 1 |
| 160 | 113A8242-1 | | . | P | L | A | T | E | | C, L | 1 |
| -165 | 113A8242-2 | | . | P | L | A | T | E | | D, M | 1 |
| 170 | BACP18BC01A10P | | . | P | I | N | - | C | O | C | C, D, L, M |
| 175 | BACB30PW5CD86D | | | | | | | | | | |
| 175A | BACB30PW5CD86 | | . | B | O | L | T | | | C, D, L, M | 1 |
| 180 | BACW10BP4DP | | . | W | A | S | H | E | R | C, D, L, M | 1 |
| 185 | BACN10JD4CD | | . | N | U | T | | | | C, D, L, M | 1 |
| 190 | 113A8341-2 | | . | F | I | T | T | I | N | C, D, L, M | 1 |
| 195 | BACB28BC05A091C | | . | . | B | U | S | H | I | C, D, L, M | 1 |
| 200 | BACB28BB05A091C | | . | . | B | U | S | H | I | C, D, L, M | 1 |
| 205 | 113A8341-3 | | . | . | F | I | T | T | I | C, D, L, M | 1 |

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| FIG/ ITEM | PART NUMBER | AIRLINE PART NUMBER | NOMENCLATURE | | | | | | | USAGE CODE | UNITS PER ASSY |
|--------------|----------------------|---------------------------|--------------|---------------------------|---|---|---|---|---|---------------|----------------------|
| | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | | |
| 2- | | | | | | | | | | | |
| 210 | HST10AG6-5 | | . | BOLT | | | | | | C, D, L, M | 3 |
| | | | | (V0PTK6) | | | | | | | |
| | | | | (SPEC BACB30VT6K5) | | | | | | | |
| | | | | (OPT HST10AG6-5 (V06725)) | | | | | | | |
| | | | | (OPT HST10AG6-5 (V56878)) | | | | | | | |
| | | | | (OPT HST10AG6-5 (V73197)) | | | | | | | |
| 212 | BACB28A~ W06A014C | | | DELETED | | | | | | | |
| 213 | 113A8241-3 | | | DELETED | | | | | | | |
| -214 | 113A8241-4 | | | DELETED | | | | | | | |
| 215 | HST10AG6-6 | | . | BOLT | | | | | | C, D, L, M | 3 |
| | | | | (V0PTK6) | | | | | | | |
| | | | | (SPEC BACB30VT6K6) | | | | | | | |
| | | | | (OPT HST10AG6-6 (V06725)) | | | | | | | |
| | | | | (OPT HST10AG6-6 (V56878)) | | | | | | | |
| | | | | (OPT HST10AG6-6 (V73197)) | | | | | | | |
| 220 | HST79CY6 | | . | COLLAR | | | | | | C, D, L, M | 6 |
| | | | | (V73197) | | | | | | | |
| | | | | (SPEC BACC30BL6) | | | | | | | |
| | | | | (OPT HST79-6 (V92215)) | | | | | | | |
| | | | | (OPT HST79CY6 (V56878)) | | | | | | | |
| | | | | (OPT HST79CY6 (V5M902)) | | | | | | | |
| 225 | 113A8249-3 | | . | SHIM | | | | | | C, D, L, M | 1 |
| 230 | 113A8249-4 | | . | SHIM | | | | | | C, D, L, M | 1 |
| 235 | 113A8248-1 | | . | HINGE ASSY | | | | | | C, L | 1 |
| -240 | 113A8248-2 | | . | HINGE ASSY | | | | | | D, M | 1 |
| 245 | BACB28BB05A103C | | . . | BUSHING | | | | | | C, D, L, M | 1 |
| 250 | BACB28BB05A098C | | . . | BUSHING | | | | | | C, D, L, M | 1 |
| 255 | 113A8248-3 | | . . | HINGE | | | | | | C, L | 1 |
| -260 | 113A8248-4 | | . . | HINGE | | | | | | D, M | 1 |
| 265 | 113A8249-1 | | . | SHIM | | | | | | C, D, L, M | 1 |
| | | | | (OPT ITEM 265A) | | | | | | | |
| -265A | 113A8249-8 | | . | SHIM | | | | | | C, D, L, M | 1 |
| | | | | (OPT ITEM 265) | | | | | | | |

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| FIG/ ITEM | PART NUMBER | AIRLINE PART NUMBER | NOMENCLATURE | | | | | | | USAGE CODE | UNITS PER ASSY |
|--------------|----------------------|---------------------------|--------------|---------------------------|---|---|---|---|---|---------------|----------------------|
| | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | | |
| 2- | | | | | | | | | | | |
| 270 | BACR15GF5D | | . | RIVET | | | | | | C, D, L, M | 5 |
| | | | | (SIZE DETERMINED ON INST) | | | | | | | |
| 275 | BACB30NN4K12 | | . | BOLT | | | | | | C, D, L, M | 3 |
| 280 | 113A8246-1 | | . | WASHER | | | | | | C, D, L, M | 3 |
| 285 | NAS1805-4L | | . | NUT | | | | | | C, D, L, M | 3 |
| 290 | 113A8240-1 | | . | FITTING ASSY | | | | | | C, L | 1 |
| -295 | 113A8240-2 | | . | FITTING ASSY | | | | | | D, M | 1 |
| 300 | BACB28AU06D022B | | . . | BUSHING | | | | | | C, D, L, M | 1 |
| 305 | 113A8240-3 | | . . | FITTING | | | | | | C, L | 1 |
| -310 | 113A8240-4 | | . . | FITTING | | | | | | D, M | 1 |
| 315 | 113A8242-7 | | . | PLATE | | | | | | C, L | 1 |
| -320 | 113A8242-8 | | . | PLATE | | | | | | D, M | 1 |
| 325 | 113A8242-5 | | . | PLATE | | | | | | C, L | 1 |
| -330 | 113A8242-6 | | . | PLATE | | | | | | D, M | 1 |
| 335 | BACP18BC01A10P | | . | PIN-COTTER | | | | | | C, D, L, M | 1 |
| 340 | BACB30PW5CD88D | | | DELETED | | | | | | | |
| 340A | BACB30PW5CD88 | | . | BOLT | | | | | | C, D, L, M | 1 |
| 345 | BACW10BP4DP | | . | WASHER | | | | | | C, D, L, M | 1 |
| 350 | BACN10JD4CD | | . | NUT | | | | | | C, D, L, M | 1 |
| 355 | 113A8341-1 | | . | FITTING ASSY-HINGE | | | | | | C, D, L, M | 1 |
| 360 | BACB28BC05A091C | | . . | BUSHING | | | | | | C, D, L, M | 1 |
| 362 | BACB28A~ W06A014C | | | DELETED | | | | | | | |
| 362A | BACB28AU06D022B | | | DELETED | | | | | | | |
| 363 | 113A8240-3 | | | DELETED | | | | | | | |

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| FIG/ ITEM | PART NUMBER | AIRLINE PART NUMBER | NOMENCLATURE | | | | | | | USAGE CODE | UNITS PER ASSY |
|--------------|-----------------|---------------------------|--------------|---|---|---|---|---|---|---------------|----------------------|
| | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | | |
| 2- | | | | | | | | | | | |
| -364 | 113A8240-4 | | | | | | | | | | |
| 365 | BACB28BB05A091C | | . | . | | | | | | C, D, L, M | 1 |
| 370 | 113A8341-3 | | . | . | | | | | | C, D, L, M | 1 |
| 375 | HST10AG6-5 | | . | | | | | | | C, D, L, M | 3 |
| | | | | | | | | | | | |
| 380 | HST10AG6-4 | | . | | | | | | | C, D, L, M | 3 |
| | | | | | | | | | | | |
| 385 | HST79CY6 | | . | | | | | | | C, D, L, M | 6 |
| | | | | | | | | | | | |
| 390 | 113A8249-5 | | . | | | | | | | C, D, L, M | 1 |
| 395 | 113A8248-5 | | . | | | | | | | C, L | 1 |
| -400 | 113A8248-6 | | . | | | | | | | D, M | 1 |
| 405 | BACB28BB05A110C | | . | . | | | | | | C, D, L, M | 1 |
| 410 | BACB28BB05A107C | | . | . | | | | | | C, D, L, M | 1 |
| 415 | 113A8248-7 | | . | . | | | | | | C, L | 1 |
| -420 | 113A8248-8 | | . | . | | | | | | D, M | 1 |
| 425 | 113A8249-2 | | . | | | | | | | C, D, L, M | 1 |
| | | | | | | | | | | | |
| -425A | 113A8249-9 | | . | | | | | | | C, D, L, M | 1 |
| | | | | | | | | | | | |
| 430 | BACB30VF3K3 | | . | | | | | | | C, D, L, M | 17 |

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| FIG/ ITEM | PART NUMBER | AIRLINE PART NUMBER | NOMENCLATURE | | | | | | | USAGE CODE | UNITS PER ASSY |
|--------------|---------------|---------------------------|--------------|---|---|---|---|---|---|---------------|----------------------|
| | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | | |
| 2- | | | | | | | | | | | |
| 435 | 113A8223-5 | | . | | | | | | | C, L | 1 |
| -440 | 113A8223-6 | | . | | | | | | | D, M | 1 |
| 445 | BACR15BA3AD | | . | . | | | | | | C, D, L, M | 34 |
| 450 | NS202493-02-2 | | . | . | | | | | | C, D, L, M | 17 |
| 455 | 113A8223-7 | | . | . | | | | | | C, L | 1 |
| -460 | 113A8223-8 | | . | . | | | | | | D, M | 1 |
| 465 | 113A8222-3 | | . | | | | | | | C, L | 1 |
| -470 | 113A8222-4 | | . | | | | | | | D, M | 1 |
| 475 | BACB30VF3K4 | | . | | | | | | | C, D | 6 |
| 477 | BACB30VF3K3 | | . | | | | | | | L, M | 7 |
| 480 | 113A8221-1 | | . | | | | | | | C | 1 |
| 482 | 113A8221-5 | | . | | | | | | | L | 1 |
| 483 | 113A8221-9 | | . | | | | | | | L | 1 |
| -485 | 113A8221-2 | | . | | | | | | | D | 1 |
| -487 | 113A8221-6 | | . | | | | | | | M | 1 |
| -488 | 113A8221-10 | | . | | | | | | | M | 1 |
| 490 | BACR15BA3AD | | . | . | | | | | | C, D | 12 |
| 492 | BACR15BA3AD | | . | . | | | | | | L, M | 4 |
| 493 | BACR15BA3AD | | . | . | | | | | | L, M | 10 |
| 495 | BRFM20C08D | | | | | | | | | | |

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| FIG/ ITEM | PART NUMBER | AIRLINE PART NUMBER | NOMENCLATURE | | | | | | | USAGE CODE | UNITS PER ASSY |
|--------------|-------------|---------------------------|--------------|---|---|---|---|---|---|---------------|----------------------|
| | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | | |
| 2- 495A | BRF200C3D | | . | . | | | | | | C, D | 6 |
| | | | | | | | | | | | |
| 497 | BRF200C3D | | . | . | | | | | | L, M | 2 |
| | | | | | | | | | | | |
| 498 | BRF200C3D | | . | . | | | | | | L, M | 5 |
| | | | | | | | | | | | |
| 500 | 113A8221-3 | | . | . | | | | | | C | 1 |
| 502 | 113A8221-7 | | . | . | | | | | | L | 1 |
| | | | | | | | | | | | |
| 503 | 113A8221-11 | | . | . | | | | | | L | 1 |
| | | | | | | | | | | | |
| -505 | 113A8221-4 | | . | . | | | | | | D | 1 |
| -507 | 113A8221-8 | | . | . | | | | | | M | 1 |
| | | | | | | | | | | | |
| -508 | 113A8221-12 | | . | . | | | | | | M | 1 |
| | | | | | | | | | | | |
| 510 | 113A8220-1 | | . | | | | | | | C | 1 |
| 512 | 113A8220-3 | | . | | | | | | | L | 1 |
| -515 | 113A8220-2 | | . | | | | | | | D | 1 |
| -517 | 113A8220-4 | | . | | | | | | | M | 1 |
| 520 | NAS1801-3-7 | | . | | | | | | | C, D, L, M | 1 |

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| FIG/ ITEM | PART NUMBER | AIRLINE PART NUMBER | NOMENCLATURE | | | | | | | USAGE CODE | UNITS PER ASSY |
|--------------|---------------|---------------------------|--------------|---|---|---|---|------------------------|---|---------------|----------------------|
| | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | | |
| 2- | | | | | | | | | | | |
| 525 | NAS1149D0316H | | . | W | A | S | H | E | R | C, D, L, M | 3 |
| 530 | H52732-3CD | | . | N | U | T | | | | C, D, L, M | 1 |
| | | | | | | | | (V15653) | | | |
| | | | | | | | | (SPEC BACN10YR3CD) | | | |
| | | | | | | | | (OPT PLH53CD (V62554)) | | | |
| 535 | BACJ40A20-3 | | . | J | U | M | P | E | R | C, D, L, M | 1 |
| 540 | NAS1801-3-9 | | . | S | C | R | E | W | | C, D, L, M | 1 |
| 545 | NAS1149D0316H | | . | W | A | S | H | E | R | C, D, L, M | 3 |
| 550 | H52732-3CD | | . | N | U | T | | | | C, D, L, M | 1 |
| | | | | | | | | (V15653) | | | |
| | | | | | | | | (SPEC BACN10YR3CD) | | | |
| | | | | | | | | (OPT PLH53CD (V62554)) | | | |
| 555 | BACJ40A21-8 | | . | J | U | M | P | E | R | C, D, L, M | 1 |
| 560 | 113A8231-1 | | . | D | O | O | R | | | C | 1 |
| -560A | 113A8232-1 | | . | D | O | O | R | | | L | 1 |
| -565 | 113A8231-2 | | . | D | O | O | R | | | D | 1 |
| -565A | 113A8232-2 | | . | D | O | O | R | | | M | 1 |

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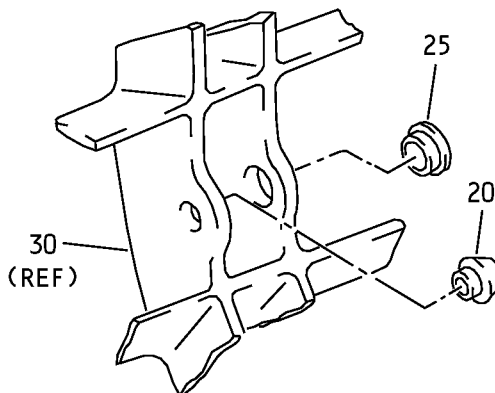
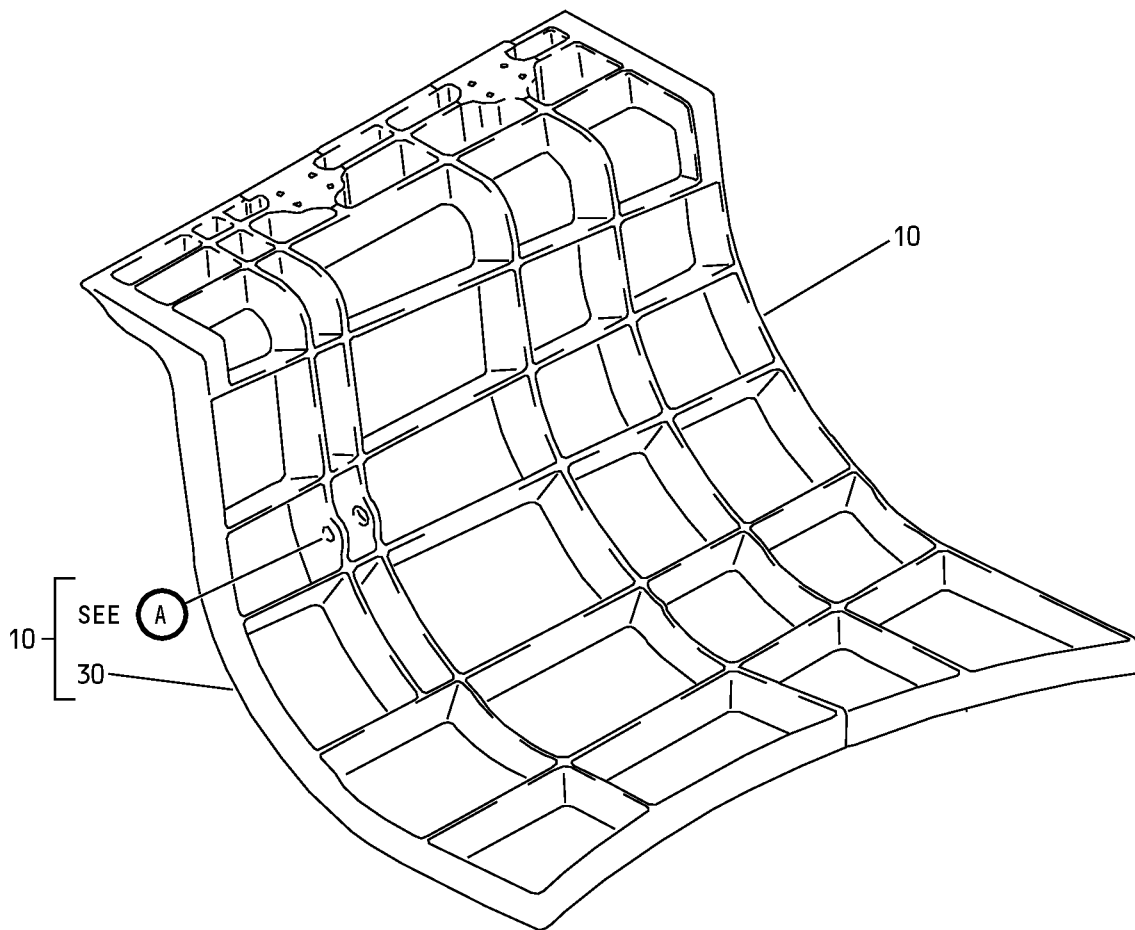
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Inboard Door Assembly
IPL Figure 3



COMPONENT MAINTENANCE MANUAL

| FIG/ ITEM | PART NUMBER | AIRLINE PART NUMBER | NOMENCLATURE | | | | | | | USAGE CODE | UNITS PER ASSY |
|--------------|-----------------|---------------------------|--------------|---|---|---|---|---|---|---------------|----------------------|
| | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | | |
| 3- | | | | | | | | | | | |
| -1 | 113A8331-1 | | | | | | | | | E | RF |
| -5 | 113A8331-2 | | | | | | | | | F | RF |
| 10 | 113A8331-3 | | | | | | | | | E | 1 |
| -15 | 113A8331-4 | | | | | | | | | F | 1 |
| 20 | 113A8332-1 | | | | | | | | | E, F | 1 |
| 25 | BACB28AT10B026C | | | | | | | | | E, F | 1 |
| 30 | 113A8331-5 | | | | | | | | | E | 1 |
| -30A | 113A8331-7 | | | | | | | | | E | 1 |
| -35 | 113A8331-6 | | | | | | | | | F | 1 |
| -35A | 113A8331-8 | | | | | | | | | F | 1 |

-Item not Illustrated

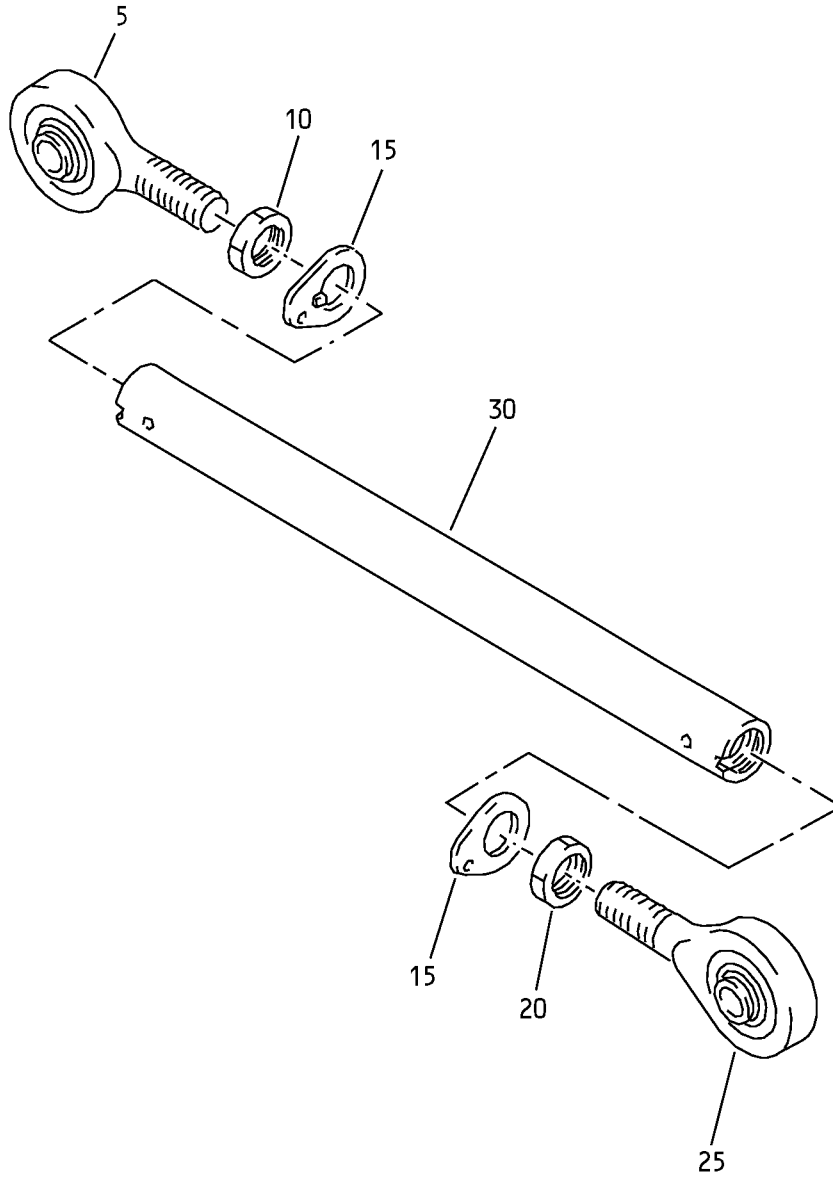
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Outboard Pushrod Assembly
IPL Figure 4

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COMPONENT MAINTENANCE MANUAL

| FIG/ ITEM | PART NUMBER | AIRLINE PART NUMBER | NOMENCLATURE | | | | | | | USAGE CODE | UNITS PER ASSY |
|--------------|-----------------|---------------------------|--------------|---|---|---|---|---|---|---------------|----------------------|
| | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | | |
| 4- | | | | | | | | | | | |
| -1 | 113A8500-1 | | | | | | | | | G | RF |
| -1A | 113A8500-2 | | | | | | | | | N | RF |
| 5 | S012T235-106-90 | | | | | | | | | GN | 1 |
| 10 | NAS509-7C | | | | | | | | | GN | 1 |
| 15 | 113A8541-1 | | | | | | | | | GN | 2 |
| 20 | NAS509L7C | | | | | | | | | GN | 1 |
| 25 | BCREF12763 | | | | | | | | | GN | 1 |
| 30 | 113A8540-1 | | | | | | | | | G | 1 |
| -30A | 113A8540-2 | | | | | | | | | N | 1 |

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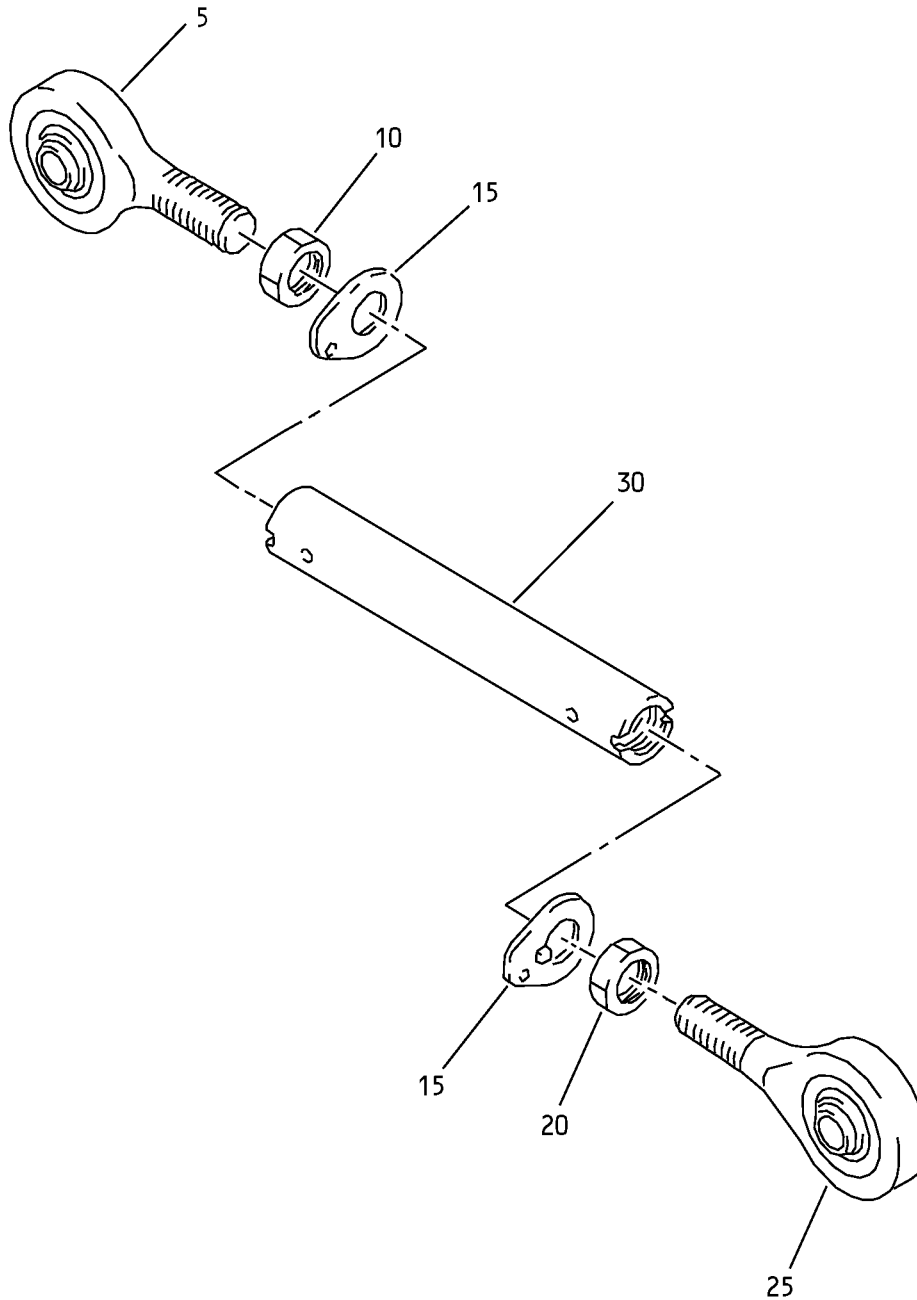
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Inboard Pushrod Assembly
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| FIG/ ITEM | PART NUMBER | AIRLINE PART NUMBER | NOMENCLATURE | | | | | | | USAGE CODE | UNITS PER ASSY |
|--------------|-----------------|---------------------------|--------------|---|---|---|---|---|---|---------------|----------------------|
| | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | | |
| 5- | | | | | | | | | | | |
| -1 | 113A8600-1 | | | | | | | | | | |
| -1A | 113A8600-3 | | | | | | | | J | RF | |
| 5 | BCREF12480 | | | | | | | | J | RF | |
| 10 | NAS509L8C | | | | | | | | J | 1 | |
| 15 | NAS513-8 | | | | | | | | J | 2 | |
| 20 | NAS509-8C | | | | | | | | J | 1 | |
| 25 | S012T235-507-79 | | | | | | | | J | 1 | |
| 30 | 113A8640-1 | | | | | | | | J | 1 | |

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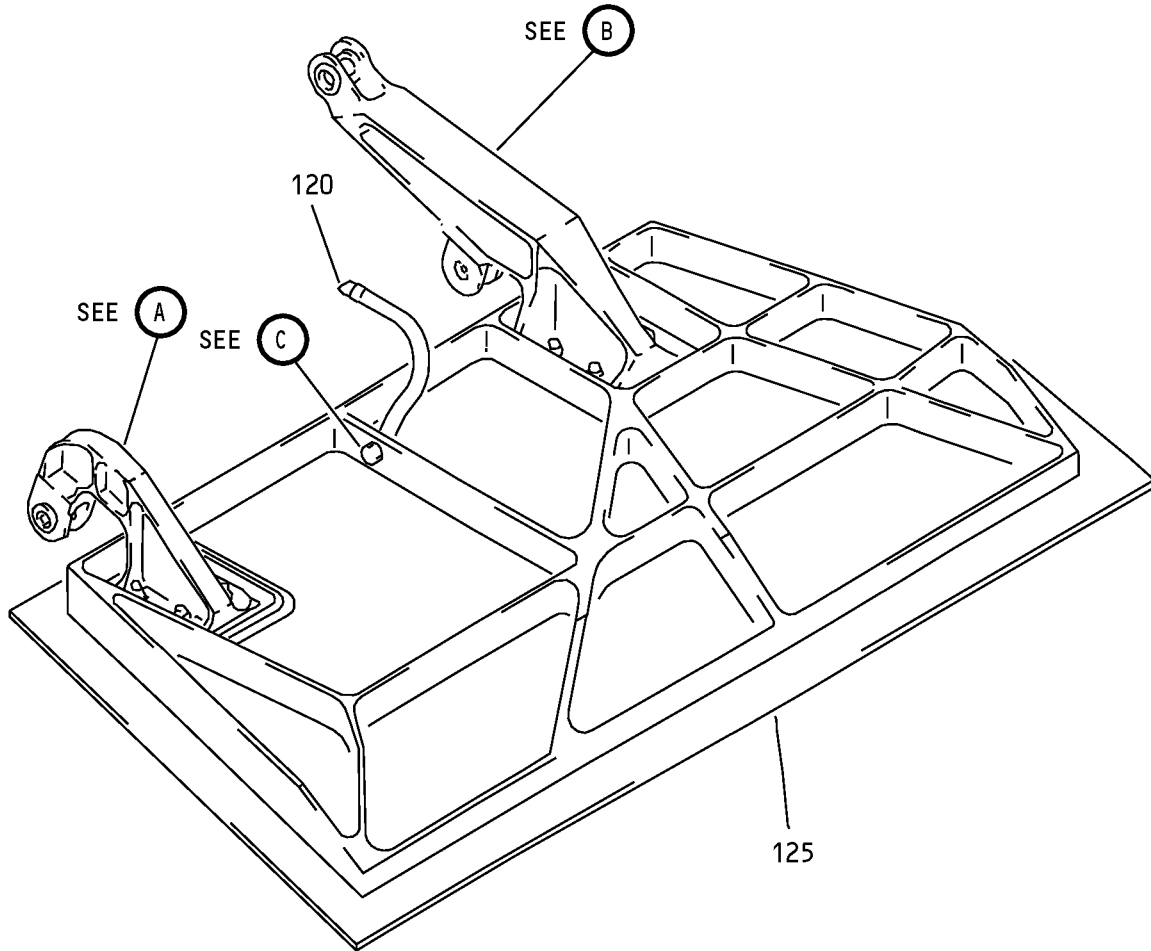
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Outboard Door Assembly
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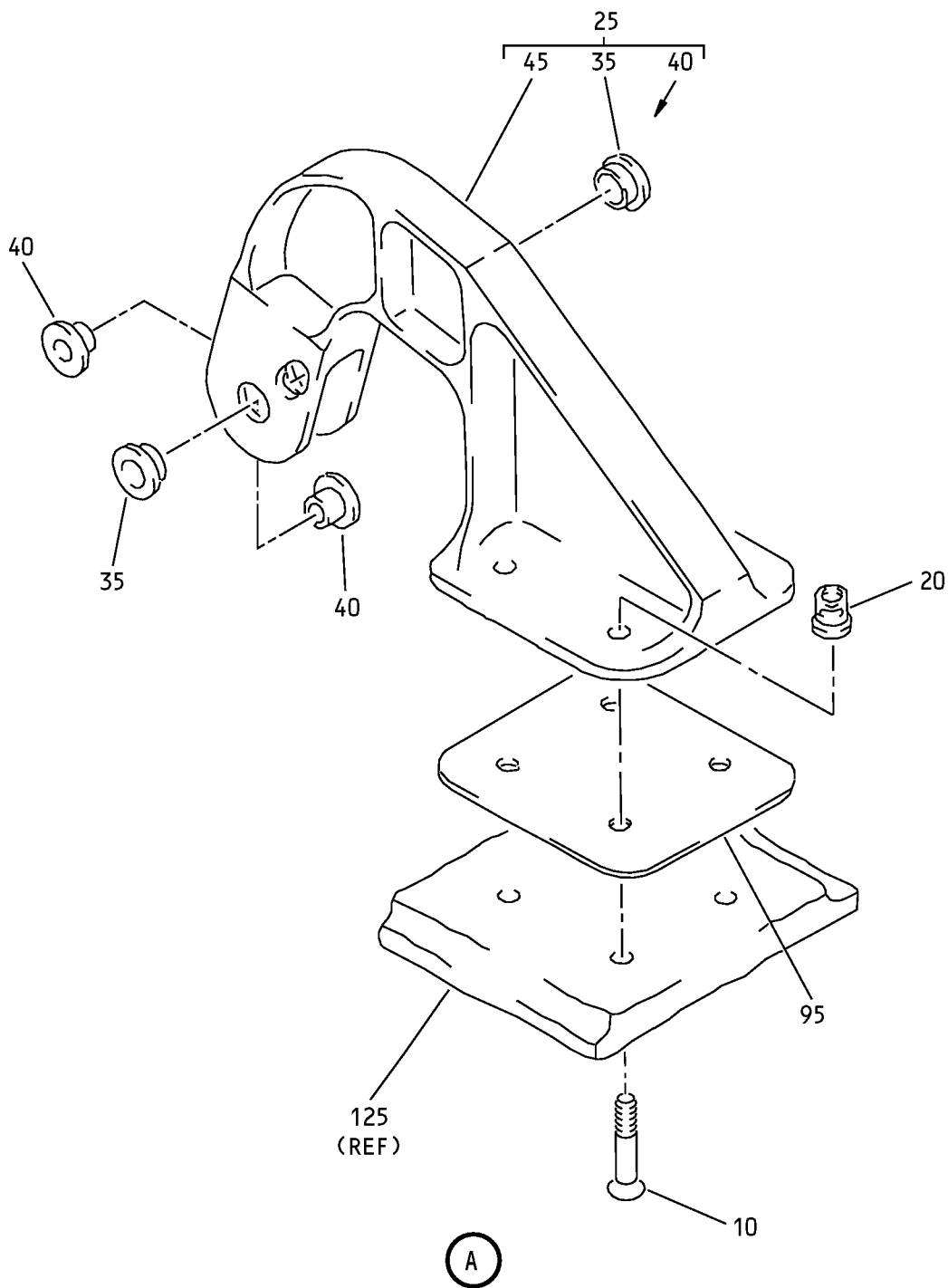
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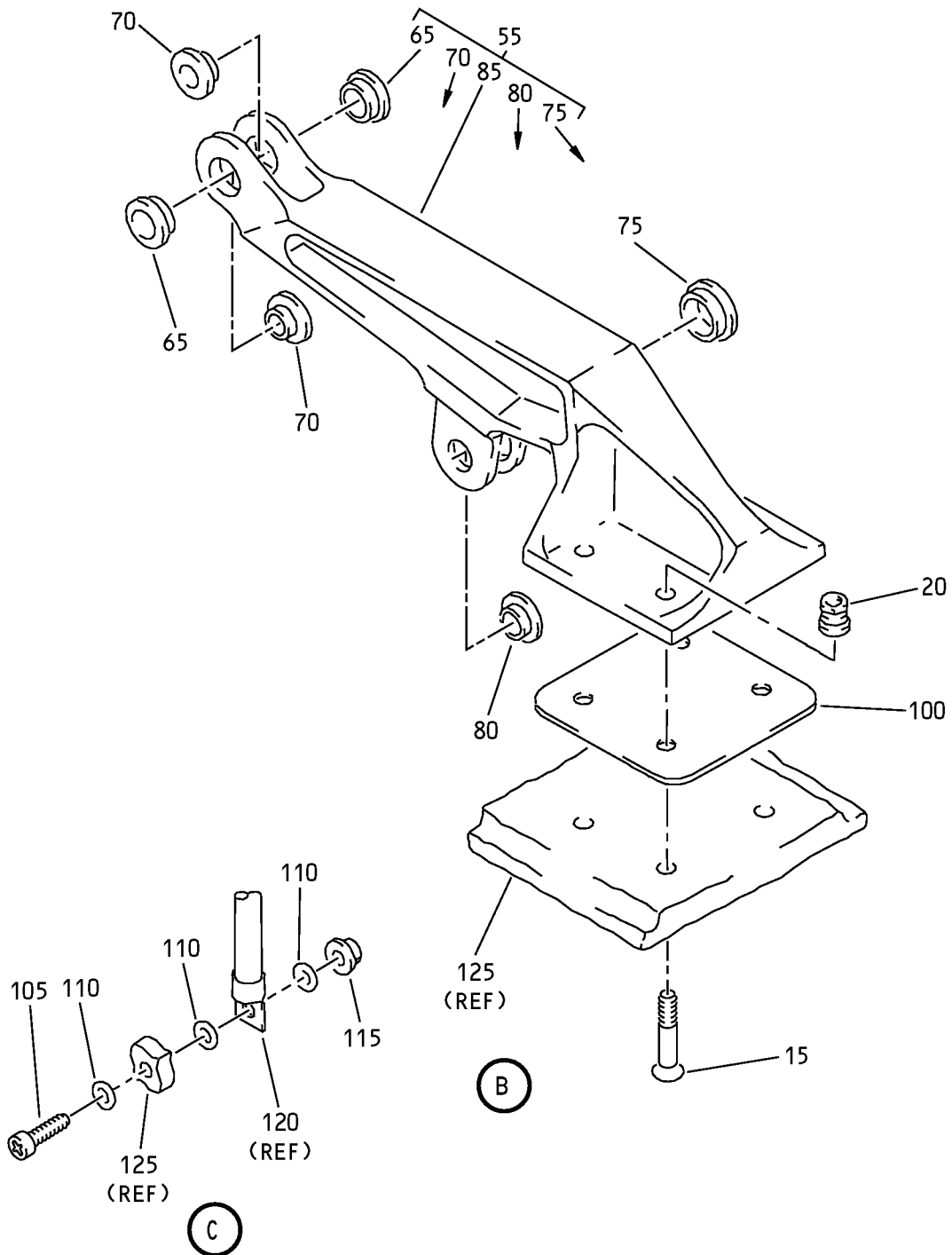
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Outboard Door Assembly
IPL Figure 6 (Sheet 2 of 3)

COMPONENT MAINTENANCE MANUAL



Outboard Door Assembly
IPL Figure 6 (Sheet 3 of 3)



COMPONENT MAINTENANCE MANUAL

| FIG/ ITEM | PART NUMBER | AIRLINE PART NUMBER | NOMENCLATURE | | | | | | | USAGE CODE | UNITS PER ASSY |
|--------------|-----------------|---------------------------|--------------|---|---|---|---|---|---|---------------|----------------------|
| | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | | |
| 6- | | | | | | | | | | | |
| -1A | 113A8100-5 | | | | | | | | | H | RF |
| -5 | 113A8100-6 | | | | | | | | | K | RF |
| 10 | HL13VAZ8-7 | | | | | | | | | H, K | 4 |
| | | | | | | | | | | | |
| 15 | HL13VAZ8-9 | | | | | | | | | H, K | 4 |
| | | | | | | | | | | | |
| 20 | HL1087-8 | | | | | | | | | H, K | 8 |
| | | | | | | | | | | | |
| 25 | 113A8141-1 | | | | | | | | | H | 1 |
| -30 | 113A8141-2 | | | | | | | | | K | 1 |
| 35 | BACB28AT07D012C | | | | | | | | | H, K | 2 |
| 40 | BACB28AU05B018C | | | | | | | | | H, K | 2 |
| 45 | 113A8141-3 | | | | | | | | | H | 1 |
| -50 | 113A8141-4 | | | | | | | | | K | 1 |
| 55 | 113A8140-1 | | | | | | | | | H | 1 |
| -60 | 113A8140-2 | | | | | | | | | K | 1 |
| 65 | BACB28AT08D013C | | | | | | | | | H, K | 2 |
| 70 | BACB28AU06B019C | | | | | | | | | H, K | 2 |
| 75 | BACB28AT07B015C | | | | | | | | | H, K | 1 |
| 80 | BACB28AP05P015 | | | | | | | | | H, K | 1 |

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| FIG/ ITEM | PART NUMBER | AIRLINE PART NUMBER | NOMENCLATURE | | | | | | | USAGE CODE | UNITS PER ASSY |
|--------------|---------------|---------------------------|--------------|---|------------------------|---|---|---|---|---------------|----------------------|
| | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | | |
| 6- | | | | | | | | | | | |
| 85 | 113A8140-3 | | . | . | FITTING | | | | | H | 1 |
| -90 | 113A8140-4 | | . | . | FITTING | | | | | K | 1 |
| 95 | 113A8249-7 | | . | | SHIM | | | | | H, K | 1 |
| 100 | 113A8249-6 | | . | | SHIM | | | | | H, K | 1 |
| 105 | NAS1801-4-8 | | . | | SCREW | | | | | H, K | 1 |
| 110 | NAS1149D0416H | | . | | WASHER | | | | | H, K | 3 |
| 115 | H52732-4CD | | . | | NUT | | | | | H, K | 1 |
| | | | | | (V15653) | | | | | | |
| | | | | | (SPEC BACN10YR4CD) | | | | | | |
| | | | | | (OPT PLH54CD (V62554)) | | | | | | |
| 120 | BACJ40A21-8 | | . | | JUMPER ASSY | | | | | H, K | 1 |
| 125 | 113A8131-1 | | . | | DOOR | | | | | H | 1 |
| -130 | 113A8131-2 | | . | | DOOR | | | | | K | 1 |

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