



COMPONENT MAINTENANCE MANUAL WITH ILLUSTRATED PARTS LIST

MAIN LANDING GEAR CENTER DOOR ASSEMBLY

PART NUMBER

**65C28176-10, -11, -12, -13, -14, -15, -16, -17, -18,
-19, -20, -7, -8, -9**

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COMPONENT MAINTENANCE MANUAL

Revision No. 15
Jul 01/2009

To: All holders of MAIN LANDING GEAR CENTER DOOR ASSEMBLY 32-16-13.

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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TRANSMITTAL LETTER

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Location of Change

Description of Change

NO HIGHLIGHTS

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HIGHLIGHTS

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2	BLANK	32-16-13 REPAIR 3-1			
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A = Added, R = Revised, D = Deleted, O = Overflow

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**COMPONENT MAINTENANCE MANUAL****TEMPORARY REVISION AND SERVICE BULLETIN RECORD**

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVE	DATE OF INCORPORATION INTO MANUAL
		PRR 33180-77	JUN 05/84
		PRR 34915	MAR 05/91

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TR AND SB RECORD

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COMPONENT MAINTENANCE MANUAL

INTRODUCTION

1. General

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

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INTRODUCTION

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COMPONENT MAINTENANCE MANUAL

MAIN LANDING GEAR CENTER DOOR ASSEMBLY - DESCRIPTION AND OPERATION

1. Description and Operation

- A. The main landing gear center door assembly is a fiberglass/graphite/epoxy/honeycomb sandwich bond assembly with attach fitting assemblies and a cradle assembly. Two hinge fittings at the lower edge of the panel assembly attach the door to the landing gear.
- B. The center door is attached to the main landing gear and drag link. The door opens and closes with the landing gear.

2. Leading Particulars (Approximate)

- A. Length – 25 inches
- B. Width – 26 inches
- C. Thickness – 3 inches
- D. Weight – 12 pounds

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DESCRIPTION AND OPERATION

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TESTING AND FAULT ISOLATION

(NOT APPLICABLE)

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TESTING AND FAULT ISOLATION

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COMPONENT MAINTENANCE MANUAL

DISASSEMBLY

1. General

- A. This procedure has the data necessary to do a disassembly.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.

2. Disassembly

A. References

Reference	Title
SOPM 20-10-08	REMOVAL OF FAYING SURFACE SEALED METAL FITTINGS FROM COMPOSITE STRUCTURES

B. Procedure

- (1) Disassemble this component only as necessary to complete fault isolation, to find the serviceability of parts, to do the repairs, and to put the unit back in serviceable condition.
- (2) Use standard industry practices and these steps.
 - (a) Remove fitting assemblies (105, 200) per SOPM 20-10-08
 - (b) Measure and make a note of the thickness of shims (98, 100, 185 thru 195, 300 thru 310) to help during assembly. The thickness of the shims is adjusted to make the door smooth with the airplane body when the door is installed on the airplane.

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DISASSEMBLY

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COMPONENT MAINTENANCE MANUAL

CLEANING

1. General

- A. This procedure has the data necessary to do cleaning.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.

2. Cleaning

A. References

Reference	Title
SOPM 20-30-03	GENERAL CLEANING PROCEDURES

B. Procedure

CAUTION: DO NOT VAPOR DEGREASE EPOXY BONDED STRUCTURES WITH CHLORINATED CLEANING AGENTS SUCH AS METHYLENE CHLORIDE, TRICHLOROETHYLENE, AND TRICHLOROETHANE. CHLORINATED CLEANING AGENTS WILL CAUSE DAMAGE TO EPOXY BONDED STRUCTURES. 1,1,1-TRICHLOROETHANE IS ONE OF THE SOLVENTS ALLOWED FOR CLEANING COMPOSITE COMPONENTS. DO NOT SUBMERGE PARTS IN THE SOLVENT OR ALLOW STANDING SOLVENT ON THE PARTS OR DAMAGE MAY OCCUR. USE 1,1, 1-TRICHLOROETHANE ONLY AS A WIPE SOLVENT.

- (1) Clean all parts by standard industry practices and the instructions to SOPM 20-30-03.

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CLEANING

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COMPONENT MAINTENANCE MANUAL

CHECK

1. General

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

2. Check

A. References

Reference	Title
SOPM 20-20-02	PENETRANT METHODS OF INSPECTION
737 SRM 52-80-02	Structural Repair Manual

B. Procedure

- (1) Examine all parts for defects by standard industry practices. Refer to FITS AND CLEARANCES for design dimensions and wear limits. Do the penetrant checks only if the visual check finds possible defects.
- (2) Penetrant check (SOPM 20-20-02) – Fittings (140, 180, 225, 285, 290, 445 thru 462) and cradle fitting (96).
- (3) Examine honeycomb and bonded parts for signs of delamination, internal water, scratches, and contour defects.
 - (a) Ultrasonically examine for delamination.
 - (b) Radiographically examine areas that could contain water to see how much damage there is.
 - (c) Examine the edges of the panel carefully for cuts and abrasions. Delamination starts very easily from damage to an edge member of the honeycomb panel.
- (4) Refer to the applicable 737 SRM 52-80-02 for damage limits and repair instructions.

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CHECK

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COMPONENT MAINTENANCE MANUAL

REPAIR

1. General

- A. This procedure has the data necessary to repair the summing mechanism assembly (266).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.

2. Content

- A. Repair, refinish and replacement procedures are included in separate repair sections as follows:

Table 601:

P/N	NAME	REPAIR
65C28173	HINGE FITTING ASSY	1-1
69-42372	ATTACH FITTING ASSY	2-1
69-42374	ATTACH FITTING ASSY	2-1
69-42373	ATTACH FITTING ASSY	3-1
69-42377	ATTACH FITTING ASSY	4-1
- - -	MISCELLANEOUS PARTS REFINISH	5-1
65C30882	HINGE FITTING ASSY	6-1

3. Standard Practices

- A. Refer to the following standard practices, as applicable, for details of procedures in individual repairs:
 - SOPM 20-00-00 Introduction
 - SOPM 20-30-02 Stripping of Protective Finishes
 - SOPM 20-41-01 Decoding Table for Boeing Finish Codes
 - SOPM 20-41-02 Application of Chemical and Solvent Resistant Finishes
 - SOPM 20-43-01 Chromic Acid Anodizing
 - SOPM 20-50-03 Bearing and Bushing Replacement
 - SOPM 20-60-02 Finishing Materials
 - SOPM 20-60-04 Miscellaneous Materials

4. Dimensioning Symbols

- A. Standard True Position Dimensioning Symbols used in applicable repair procedures are shown in SOPM 20-00-00.

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REPAIR - GENERAL

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HINGE FITTING ASSEMBLY - REPAIR 1-1

65C28173-9, -10, -11, -12

1. General

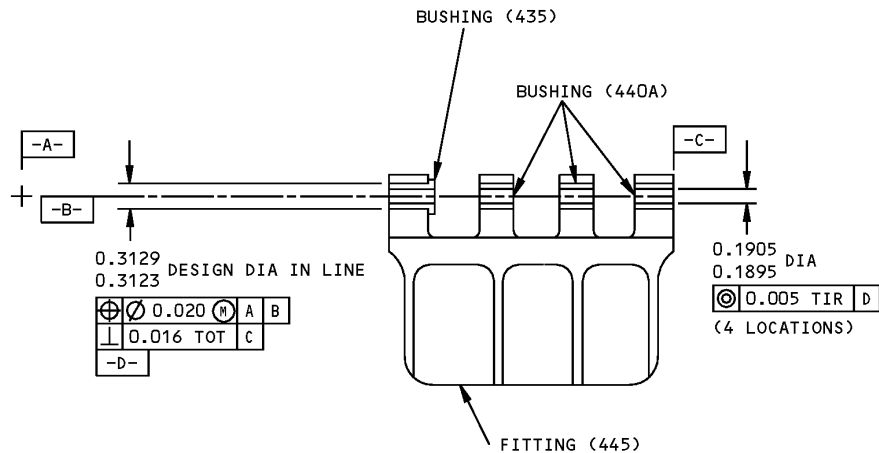
- A. This procedure has the data necessary to repair the summing mechanism assembly (266).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Paragraph 3. for a list of applicable standard practices
- D. Refer to IPL Figure 1 for item numbers.

2. Bushing Replacement (REPAIR 1-1, Figure 601)

- A. Remove the old bushings.
- B. Install replacement bushings by the shrink-fit or press-fit method of SOPM 20-50-03.
- C. Machine the bushing bores to design dimensions and finish.
- D. Fillet seal the flange of bushing (435) with sealant, A00247.

3. Refinish

- A. Fitting (445 thru 460) – Chromic acid anodize and apply primer, C00259 (F-18.13) but no primer in the bores for bushings. Material: Al alloy.
- B. Fitting assembly (400, 405, 410, 415) – Apply enamel coating, C00700 (F-14.9813, which replaces SRF-14.9813) but not in the bushing bores.



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

65C28173-9, -11 SHOWN Bushing Replacement
Figure 601

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REPAIR 1-1

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ATTACH FITTING - REPAIR 2-1

69-42372-7, 69-42374-5

1. General

- A. This procedure tells how to replace parts of the attach fitting and to refinish it.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL for a list of applicable standard practices
- D. For repair of surfaces which is only replacement of the original finish, refer to REPAIR 2-1, Paragraph 3..
- E. Refer to IPL Figure 1 for item numbers.

2. Bushing Replacement ()

- A. Remove the old bushings.
- B. Install replacement bushings by the shrink-fit or press-fit method of SOPM 20-50-03.

3. Refinish

- A. Fitting (140, 225) – Chromic acid anodize and apply primer, C00259(F-18.13), but no primer in bores for bushings. Material: Al alloy.
- B. Fitting assembly (105, 200) – Apply enamel coating, C00700, (F-14.9813, which replaces SRF-14.9813) but not in the bushing bores.

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REPAIR 2-1

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COMPONENT MAINTENANCE MANUAL

ATTACH FITTING - REPAIR 3-1

69-42373-5

1. General

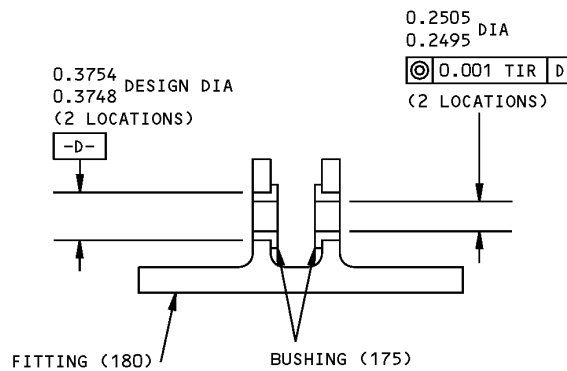
- A. This procedure tells how to replace parts of the attach fitting and to refinish it.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL for a list of applicable standard practices
- D. For repair of surfaces which is only replacement of the original finish, refer to REPAIR 3-1, Paragraph 3..
- E. Refer to IPL Figure 1 for item numbers.

2. Repair

- A. Bushing Replacement (REPAIR 3-1, Figure 601)
 - (1) Remove the old bushings.
 - (2) Install replacement bushings by the shrink-fit or press-fit method of SOPM 20-50-03.
 - (3) Machine the bushing bores to design dimensions and finish.

3. Refinish

- A. Fitting (180) – Chromic acid anodize and apply primer, C00259, (F-18.13), but no primer in bores for bushings. Material: Al alloy.
- B. Fitting assembly (145) – Apply enamel coating, C00700 (F-14.9813, which replaces SRF-14.9813), but not in the bushing bores.



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

69-42373-5 Bushing Replacement
Figure 601

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REPAIR 3-1

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ATTACH FITTING - REPAIR 4-1

69-42377-11, -12

1. General

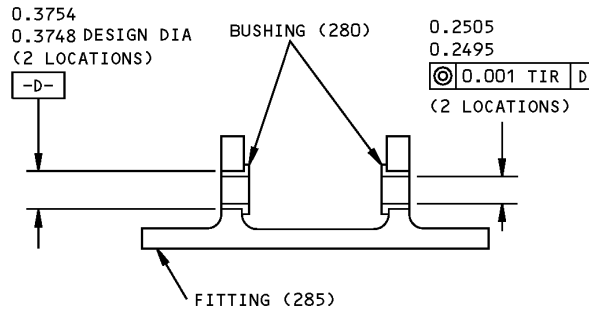
- A. This procedure tells how to replace parts of the attach fitting and to refinish it.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL for a list of applicable standard practices
- D. For repair of surfaces which is only replacement of the original finish, refer to REPAIR 4-1, Paragraph 3..
- E. Refer to IPL Figure 1 for item numbers.

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

- A. Remove the old bushings.
- B. Install replacement bushings by the shrink-fit or press-fit method of SOPM 20-50-03.
- C. Machine the bushing bores to design dimensions and finish.

3. Refinish

- A. Fitting (285, 290) – Chromic acid anodize and apply primer, C00259 (F-18.13) but no primer in bores for bushings. Material: Al alloy.
- B. Fitting assembly (230, 235) – Apply enamel coating, C00700, (F-14.9813, which replaces SRF-14.9813) but not in bushing bores.



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

69-42377-11,-12 Bushing Replacement
Figure 601

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REPAIR 4-1

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MISCELLANEOUS PARTS REFINISH - REPAIR 5-1

1. General

- A. This procedure tells how to refinish parts that are not in the other repairs.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Repair of these parts is only replacement of the original finish.
- D. Refer to IPL Figure 1 for item numbers.

2. Refinish Details

- A. For refinish details, refer to REPAIR 5-1, Table 601.

Table 601: Refinish Details

IPL FIG. & ITEM	MATERIAL	FINISH
IPL Figure 1		
Cradle fitting (96)	Al alloy	Chromic acid anodize and apply primer, C00259 (F-18.13). Apply enamel coating, C00700 (F-14.9813, which replaces SRF-14.9813).
Door - bond assy (10A,15A)	Fiberglass/ graphite/epoxy/ honeycomb sandwich	Prepare the surface (SRF-14.672). Apply coating, C00767 (SRF-14.985, which replaces (SRF-14.68). Apply primer, C00319 (F-19.46). Apply enamel coating, C00700 (F-14.9813), which replaces SRF-14.9813).

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REPAIR 5-1

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HINGE FITTING ASSEMBLY - REPAIR 6-1

65C30882-1, -2

1. General

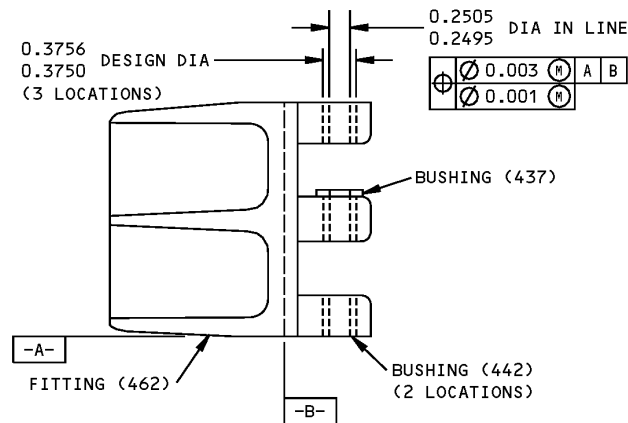
- A. This procedure tells how to replace parts of the hinge fitting assembly and to refinish it.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL for a list of applicable standard practices
- D. For repair of surfaces which is only replacement of the original finish, refer to REPAIR 6-1, Paragraph 3..
- E. Refer to IPL Figure 1 for item numbers.

2. Bushing Replacement (REPAIR 6-1, Figure 601)

- A. Remove the old bushings.
- B. Install replacement bushings by the shrink-fit or press-fit method of SOPM 20-50-03.
- C. Machine the bushing bores to design dimensions and finish.
- D. Fillet seal the flange of bushing (437) with sealant, A00247.

3. Refinish

- A. Fitting (462) – Chromic acid anodize and apply primer, C00259 (F-18.13) but no primer in bores for bushings. Material: Al alloy.
- B. Fitting assembly (402, 407, 412, 417) – Apply enamel coating, C00700 (F-14.9813, which replaces SRF-14.9813) but no enamel in bushing bores.



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

65C30882-1 SHOWN Bushing Replacement
Figure 601

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REPAIR 6-1

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COMPONENT MAINTENANCE MANUAL

ASSEMBLY

1. General

- A. This procedure tells how to assemble the main landing gearcenter door assembly.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 1 for item numbers.

2. Assembly (IPL Figure 1)

CAUTION: BE SURE TO USE ONLY TITANIUM OR CORROSION RESISTANT STEEL FASTENERS THROUGH THE DOOR-BOND ASSEMBLY. DO NOT USE ALUMINUM OR PLATED ALLOY STEEL FASTENERS BECAUSE GALVANIC CORROSION WILL OCCUR.

2.

A.

Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95
A01076	Adhesive - Synthetic Rubber	BAC5010, Type 93 (BMS5-95, Class B)

B. References

Reference	Title
SOPM 20-10-06	REPAIR OF CONDUCTIVE COATINGS
SOPM 20-11-03	REPAIR OF ELECTRICAL TERMINATIONS AND ELECTRICAL BONDING AREAS
SOPM 20-50-12	APPLICATION OF ADHESIVES

C. Procedure

- (1) Use standard industry practices and these steps.
- (2) Bolts (110A, 150A, 250A, 250B) – Apply conductive coating to boltholes per SOPM 20-10-06 and install with wet sealant, A00247. Make a check of the resistance of the bolts per SOPM 20-11-03. Fillet seal them with wet sealant, A00247.
- (3) Bolts (90B, 115, 155B, 155C, 205, 240A, 245A) – Install with wet sealant, A00247.
- (4) Fitting assembly (105, 200) – Fay surface seal with sealant, A00247.
- (5) Identification plate (315) – Bond a replacement plate in the location shown in ASSEMBLY, Figure 701 with adhesive, A01076 type per SOPM 20-50-12.

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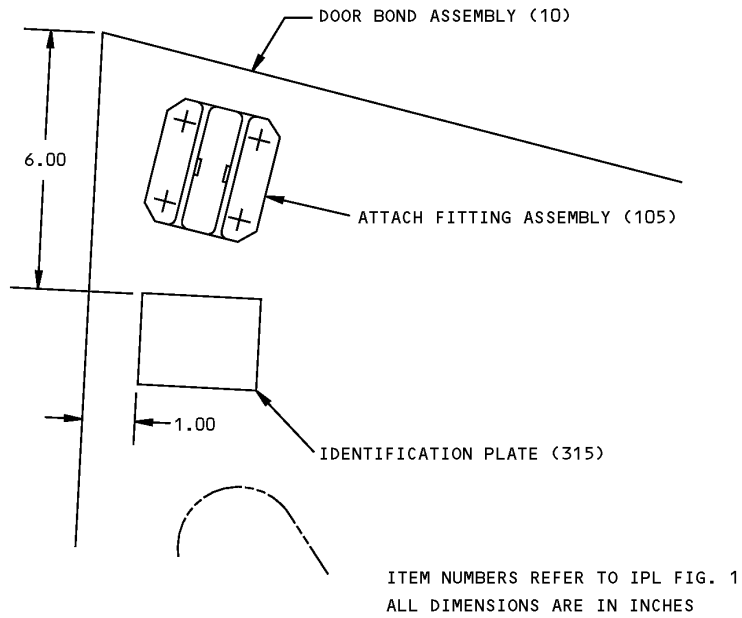
ASSEMBLY

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COMPONENT MAINTENANCE MANUAL



Location of Identification Plate
Figure 701

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ASSEMBLY

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FITS AND CLEARANCES

Ref Letter Fig.801	Mating Item No. IPL Fig.1	Design Dimension				Service Wear Limit		
		Dimension		Assembly Clearance		Dimension		Maximum Clearance
		Min	Max	Min	Max	Min	Max	
	ID 230,235 OD *C1	0.2495 0.2490	0.2505 0.2495	0.0000	0.0015	0.2465	0.2525	0.0030
	ID 145 OD *C2	0.2495 0.2490	0.2505 0.2495	0.0000	0.0015	0.2465	0.2525	0.0030
	ID 105 OD *C2	0.2500 0.2490	0.2515 0.2495	0.0005	0.0025	0.2450	0.2545	0.0050
	ID 200 OD *C2	0.2500 0.2490	0.2515 0.2495	0.0005	0.0025	0.2450	0.2545	0.0050
	ID 400,405, 410,415 OD *C3	0.1895 0.1890	0.1905 0.1895	0.0000	0.0015	0.1865	0.1925	0.0030
	ID 402,407, 417 OD *C4	0.2495 0.2490	0.2505 0.2495	0.0000	0.0015	0.2465	0.2525	0.0030

*C1] INSTALLATION BOLT, NAS6704D32

*C2] INSTALLATION BOLT, NAS6704-14

*C3] INSTALLATION BOLT, NAS6703

*C4] INSTALLATION BOLT, NAS6704

ALL DIMENSIONS ARE IN INCHES

Fits and Clearances
Figure 801

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FITS AND CLEARANCES

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SPECIAL TOOLS, FIXTURES, AND EQUIPMENT

(NOT APPLICABLE)

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SPECIAL TOOLS, FIXTURES, AND EQUIPMENT

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COMPONENT MAINTENANCE MANUAL

ILLUSTRATED PARTS LIST

1. Introduction

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

1	2	3	4	5	6	7
.	Assembly					
.	Attaching parts for assembly					
.	.	Detail parts for assembly				
.	.	Subassembly				
.	.	Attaching parts for subassembly				
.	.	.	Detail parts for subassembly			
.	.	.	Sub-subassembly			
.	.	.	Attaching parts for subassembly			
.	.	.	.	Details parts for sub-subassembly		
						Detail Installation Parts (Included only if installation parts may be sent to the shop as part of assembly)

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

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Optional
(OPT)

The part is optional to and interchangeable with other parts that have the same item number.

Replaces, Replaced by and not interchangeable with
(REPLACES, REPLACED BY AND NOT INTCHG/W)

The part replaces and is not interchangeable with the initial part.

Replaces, Replaced by
(REPLACES, REPLACED BY)

The part replaces and is interchangeable with, or is an alternative to, the initial part.

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NUMERICAL INDEX

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
65C28173-10		1	405	1
65C28173-11		1	410	1
65C28173-12		1	415	1
65C28173-3		1	445	1
65C28173-4		1	450	1
65C28173-7		1	455	1
65C28173-8		1	460	1
65C28173-9		1	400	1
65C28176-10		1	5B	RF
65C28176-11		1	1C	RF
65C28176-12		1	5C	RF
65C28176-13		1	1D	RF
65C28176-14		1	5D	RF
65C28176-15		1	1E	RF
65C28176-16		1	5E	RF
65C28176-17		1	1F	RF
65C28176-18		1	5F	RF
65C28176-19		1	1G	RF
65C28176-20		1	5G	RF
65C28176-7		1	1A	RF
65C28176-8		1	5A	RF
65C28176-9		1	1B	RF
65C28177-25		1	10A	1
65C28177-26		1	15A	1
65C28177-35		1	10B	1
65C28177-36		1	15B	1
65C28177-37		1	10C	1
65C28177-38		1	15C	1
65C28177-45		1	10D	1
65C28177-46		1	15D	1
65C28177-55		1	10E	1
65C28177-56		1	15E	1
65C28177-57		1	10F	1
65C28177-58		1	15F	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
65C28177-59		1	10G	1
65C28177-60		1	15G	1
65C30882-1		1	407	1
		1	412	1
65C30882-2		1	402	1
		1	417	1
65C30882-3		1	462	1
69-37867-20		1	175	2
69-37867-23		1	280	2
69-37867-75		1	435	1
69-42370-4		1	96	1
69-42372-7		1	105	1
69-42372-8		1	140	1
69-42373-5		1	145	1
69-42373-6		1	180	1
69-42374-5		1	200	1
69-42374-6		1	225	1
69-42377-11		1	230	1
69-42377-12		1	235	1
69-42377-13		1	285	1
69-42377-14		1	290	1
69-44954-2		1	295	1
69-44987-10		1	100	1
69-44987-11		1	305	1
69-44987-12		1	190	1
69-44987-13		1	310	1
69-44987-14		1	195	1
69-74443-2		1	185	1
69-74443-3		1	300	1
69-74443-4		1	98	1
AN960KD10		1	260	1
		1	425	6
AN960KD416		1	120	4
		1	160	2
		1	210	4

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	255	3
		1	427	4
AN960KD516		1	92	4
BACB28U3B041		1	440A	3
BACB28U4B048		1	442	2
BACB28X4M014		1	135A	2
BACB28X4M019		1	220	2
BACB28X4M046		1	437	1
BACB30LR4-16		1	110B	2
BACB30LR4-21		1	150A	1
		1	155C	1
		1	250B	1
BACB30NN4K16		1	110A	2
BACB30NN4K21		1	155B	1
		1	250A	1
BACB30NN5K17		1	90B	4
BACB30VG6K21		1	245A	1
BACB30VG8K12		1	422	4
BACB30VG8K16		1	115	2
BACB30VG8K17		1	205	4
BACB30VG8K21		1	240A	2
BACB50VG6K12		1	420	6
BACC30M6		1	270	1
		1	430	6
		1	432	4
BACC30M8		1	125	2
		1	215	4
		1	265	2
BACN10JC8CD		1	130	2
BACN10YR4CD		1	130A	2
		1	165A	1
		1	170A	1
		1	275A	1
BACN10YR5CD		1	94B	4
BACS40V033C018		1	465A	2

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
MS27253-1		1	315A	1
MS27253-C1		1	315	1
NAS1805-4L		1	165	1

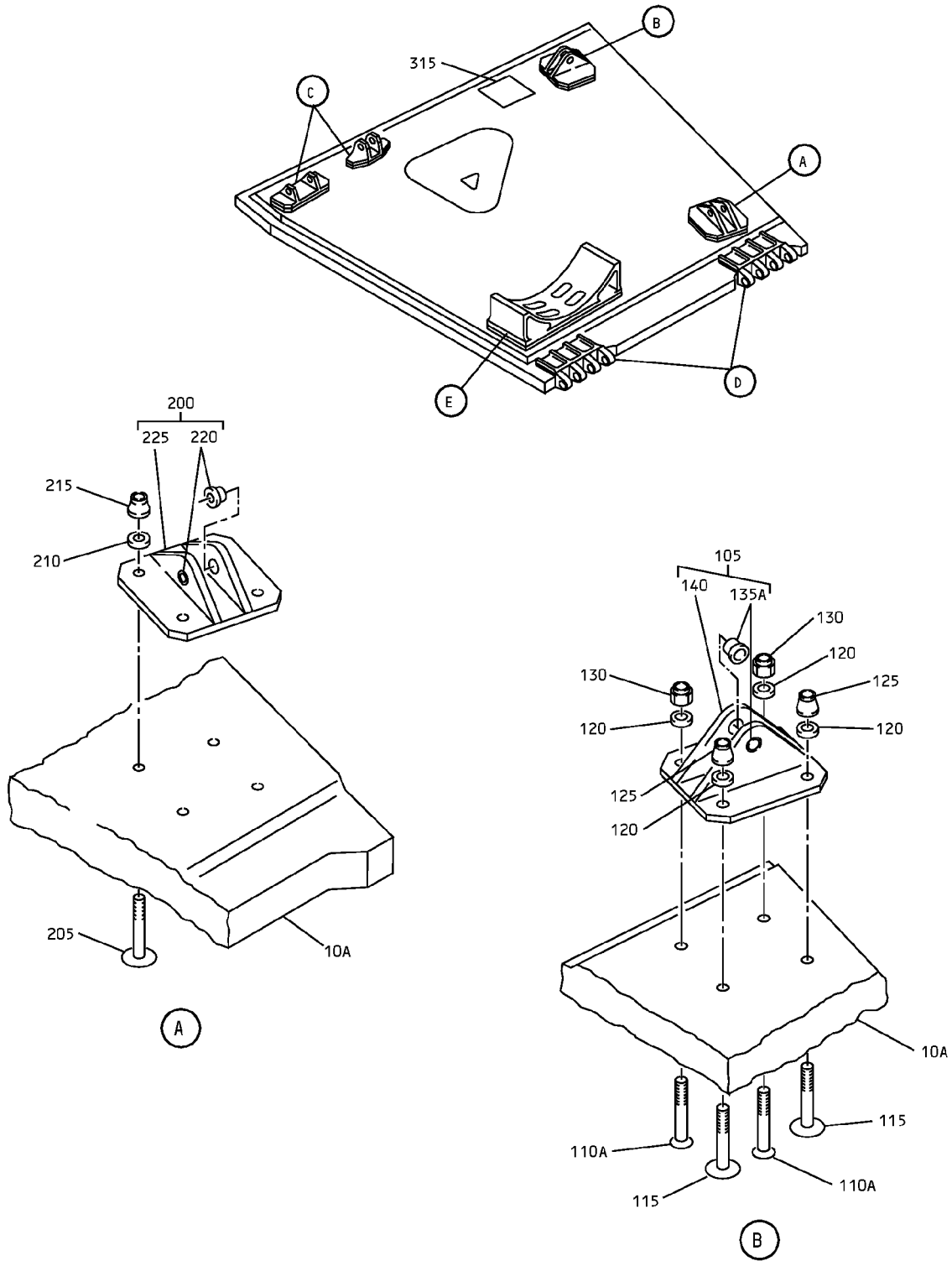
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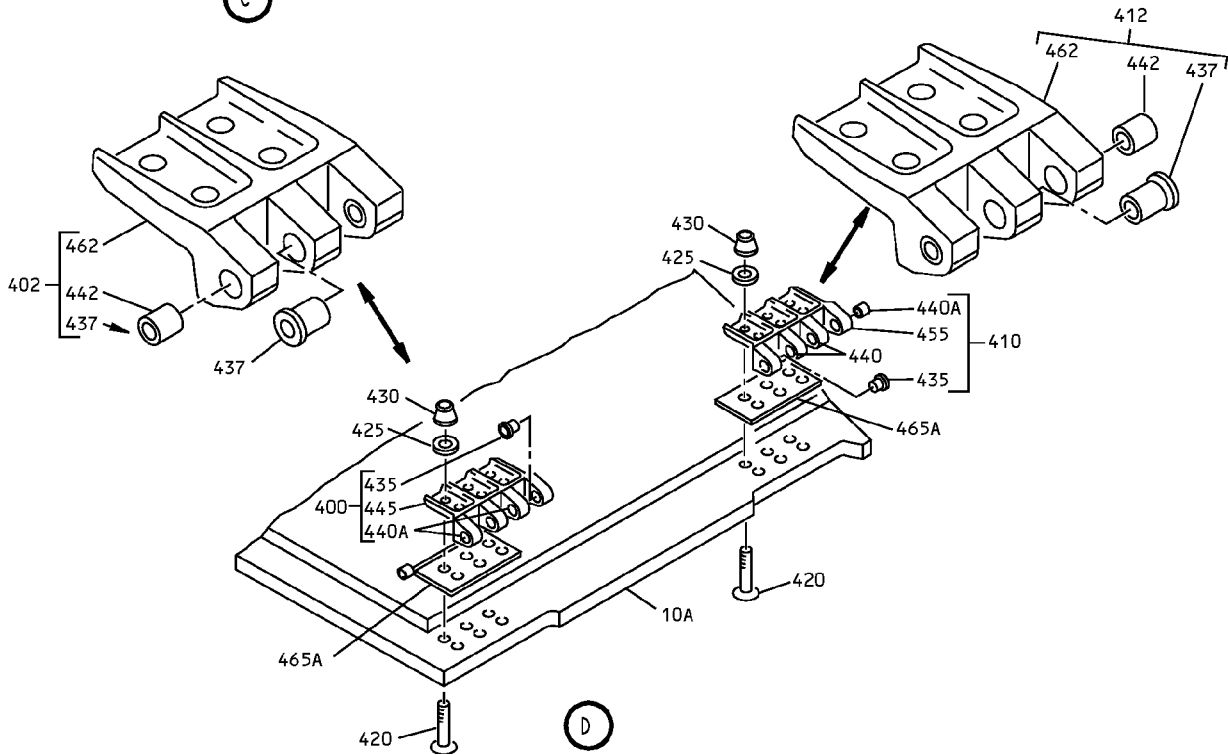
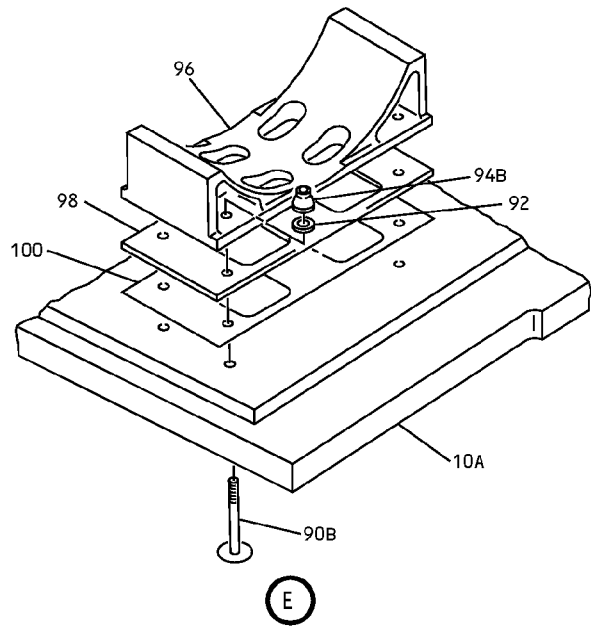
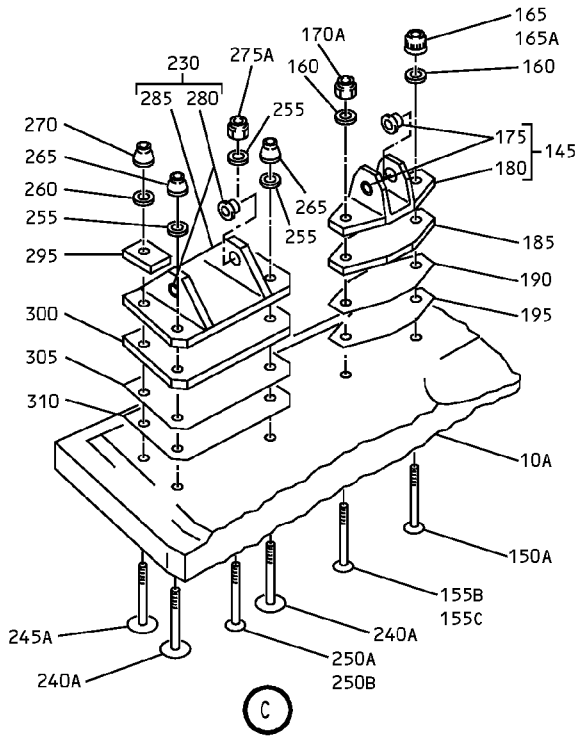
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MLG Center Door Assembly
IPL Figure 1 (Sheet 1 of 2)

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

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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-												
-1	65C28176-5										DELETED	
-1A	65C28176-7										DOOR ASSY-MAIN LANDING GEAR CENTER	A RF
-1B	65C28176-9										DOOR ASSY-MAIN LANDING GEAR CENTER	C RF
-1C	65C28176-11										DOOR ASSY-MAIN LANDING GEAR CENTER	E RF
-1D	65C28176-13										DOOR ASSY-MAIN LANDING GEAR CENTER	G RF
-1E	65C28176-15										DOOR ASSY-MAIN LANDING GEAR CENTER	I RF
-1F	65C28176-17										DOOR ASSY-MAIN LANDING GEAR CENTER	K RF
-1G	65C28176-19										DOOR ASSY-MAIN LANDING GEAR CENTER	M RF
-5	65C28176-6										DELETED	
-5A	65C28176-8										DOOR ASSY-MAIN LANDING	B RF
-5B	65C28176-10										DOOR ASSY-MAIN LANDING GEAR CENTER	D RF
-5C	65C28176-12										DOOR ASSY-MAIN LANDING GEAR CENTER	F RF
-5D	65C28176-14										DOOR ASSY-MAIN LANDING GEAR CENTER	H RF
-5E	65C28176-16										DOOR ASSY-MAIN LANDING GEAR CENTER	J RF
-5F	65C28176-18										DOOR ASSY-MAIN LANDING GEAR CENTER	L RF
-5G	65C28176-20										DOOR ASSY-MAIN LANDING GEAR CENTER	N RF
-10	65C28177-15										DELETED	
10A	65C28177-25										. BOND ASSY-DOOR	A 1
-10B	65C28177-35										. BOND ASSY-DOOR	C 1
-10C	65C28177-37										. BOND ASSY-DOOR	E 1
-10D	65C28177-45										. BOND ASSY-DOOR	G 1
-10E	65C28177-55										. BOND ASSY-DOOR	I 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		
1-											
-10F	65C28177-57		.	BOND	ASSY-DOOR					K	1
-10G	65C28177-59		.	BOND	ASSY-DOOR					M	1
-15	65C28177-16		DELETED								
-15A	65C28177-26		.	BOND	ASSY-DOOR					B	1
-15B	65C28177-36		.	BOND	ASSY-DOOR					D	1
-15C	65C28177-38		.	BOND	ASSY-DOOR					F	1
-15D	65C28177-46		.	BOND	ASSY-DOOR					H	1
-15E	65C28177-56		.	BOND	ASSY-DOOR					J	1
-15F	65C28177-58		.	BOND	ASSY-DOOR					L	1
-15G	65C28177-60		.	BOND	ASSY-DOOR					N	1
-20	65C28173-9		DELETED								
-25	65C28173-10		DELETED								
-30	65C28173-11		DELETED								
-35	65C28173-12		DELETED								
			ATTACHING PARTS								
-40	BACB30VG6K12		DELETED								6
-45	AN960KD10		DELETED								6
-50	BACC30M6		DELETED								
			----- * -----								
-55	69-37867-75		DELETED								
-60	BACB28U3B41		DELETED								
-65	65C28173-3		DELETED								
-70	65C28173-4		DELETED								
-75	65C28173-7		DELETED								
-80	65C28173-8		DELETED								
-85	65C28176-3		DELETED								
-90	BACB30VG10K8		DELETED								
-90A	BACB30VG10K19		DELETED								
90B	BACB30NN5K17		.	BOLT							4
92	AN960KD516		.	WASHER							4
-94	BACC30M10		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		
1-											
94A	BACN10JC10CD										
-94B	BACN10YR5CD									A, B, K-N	4
96	69-42370-4										1
98	69-74443-4										1
100	69-44987-10										1
105	69-42372-7										1
-110	BACB30NN8K16										
110A	BACB30NN4K16									A-F	2
-110B	BACB30LR4-16									G-N	2
115	BACB30VG8K16										2
120	AN960KD416										4
125	BACC30M8										2
130	BACN10JC8CD									C-J	2
-130A	BACN10YR4CD									A, B, K-N	2
-135	BACB28X4M010										
135A	BACB28X4M014										2
140	69-42372-8										1
145	69-42373-5										1
-150	BACB30LR4-17										
150A	BACB30LR4-21										1
-155	BACB30NN8K17										
-155A	BACB30NN8K21										
155B	BACB30NN4K21									A-F	1
-155C	BACB30LR4-21									G-N	1
160	AN960KD416										2
165	NAS1805-4L									A-F	1
-165A	BACN10YR4CD									G-N	1
170	BACN10JC8CD										

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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-											
-170A	BACN10YR4CD		.	NUT							1
			-----*								
175	69-37867-20		..	BUSHING							2
180	69-42373-6		..	FITTING							1
185	69-74443-2		.	SHIM							1
190	69-44987-12		.	SHIM							1
195	69-44987-14		.	SHIM							1
200	69-42374-5		.	ATTACH FITTING ASSY							1
				ATTACHING PARTS							
205	BACB30VG8K17		.	BOLT							4
210	AN960KD416		.	WASHER							4
215	BACC30M8		.	COLLAR							4
			-----*								
220	BACB28X4M019		..	BUSHING							2
225	69-42374-6		..	FITTING							1
230	69-42377-11		.	ATTACH FITTING ASSY					A, C, E, G, I, K, M		1
-235	69-42377-12		.	ATTACH FITTING ASSY					B, D, F, H, J, L, N		1
				ATTACHING PARTS							
-240	BACB30VG8K17			DELETED							
240A	BACB30VG8K21		.	BOLT							2
-245	BACB30VG6K17			DELETED							
245A	BACB30VG6K21		.	BOLT							1
-250	BACB30NN8K17			DELETED							
250A	BACB30NN4K21		.	BOLT					A-F		1
-250B	BACB30LR4-21		.	BOLT					G-N		1
255	AN960KD416		.	WASHER							3
260	AN960KD10		.	WASHER							1
265	BACC30M8		.	COLLAR							2
270	BACC30M6		.	COLLAR							1
275	BACN10JC8CD			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		
1-											
-275A	BACN10YR4CD		.	NUT							1
			-----*								
280	69-37867-23		.	BUSHING							2
285	69-42377-13		.	FITTING							1
				(USED ON ITEM 230)							
-290	69-42377-14		.	FITTING							1
				(USED ON ITEM 235)							
295	69-44954-2		.	RADIUS FILLER							1
300	69-74443-3		.	SHIM							1
305	69-44987-11		.	SHIM							1
310	69-44987-13		.	SHIM							1
315	MS27253-C1		.	IDENTIFICATION PLATE							1
				(OPT ITEM 315A)							
-315A	MS27253-1		.	IDENTIFICATION PLATE							1
				(OPT ITEM 315)							
				INSTALLATION PARTS							
400	65C28173-9		HINGE FITTING ASSY-AFT -						A, C, E,		1
			(USED WITH MLG INNER DOOR ASST						G, I, K, M		
			65C28178-19; REF CMM 32-16-12)								
402	65C30882-2		HINGE FITTING ASSY-AFT -						A, C, E,		1
			(USED WITH MLG INNER DOOR ASST						G, I, K, M		
			65C28178-29; REF CMM 32-16-12)								
-405	65C28173-10		HINGE FITTING ASSY-AFT -						B, D, F,		1
			(USED WITH MLG INNER DOOR ASST						H, J, L, N		
			65C28178-20; REF CMM 32-16-12)								
-407	65C30882-1		HINGE FITTING ASSY-AFT -						B, D, F,		1
			(USED WITH MLG INNER DOOR ASST						H, J, L, N		
			65C28178-30; REF CMM 32-16-12)								
410	65C28173-11		HINGE FITTING ASSY-FWD -						A, C, E,		1
			(USED WITH MLG INNER DOOR ASST						G, I, K, M		
			65C28178-19; REF CMM 32-16-12)								
412	65C30882-1		HINGE FITTING ASSY-FWD -						A, C, E,		1
			(USED WITH MLG INNER DOOR ASST						G, I, K, M		
			65C28178-29; REF CMM 32-16-12)								
-415	65C28173-12		HINGE FITTING ASSY-FWD -						B, D, F,		1
			(USED WITH MLG INNER DOOR ASST						H, J, L, N		
			65C28178-20; REF CMM 32-16-12)								

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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- -417	65C30882-2		HINGE FITTING ASSY-FWD - (USED WITH MLG INNER DOOR ASST 65C28178-30; REF CMM 32-16-12)							B, D, F, H, J, L, N	1
			ATTACHING PARTS								
420	BACB50VG6K12		BOLT (USED WITH ITEMS 400, 405, 410, 415)								6
-422	BACB30VG8K12		BOLT (USED WITH ITEM 412, 417)								4
425	AN960KD10		WASHER (USED WITH ITEMS 400, 405, 410, 415)								6
-427	AN960KD416		WASHER (USED WITH ITEM 412, 417)								4
430	BACC30M6		COLLAR (USED WITH ITEMS 400, 405, 410, 415)								6
-432	BACC30M6		COLLAR (USED WITH ITEM 412, 417)								4
			-----*-----								
435	69-37867-75		. BUSHING-FLANGED (USED ON ITEMS 400,405,410,415)								1
437	BACB28X4M046		. BUSHING-FLANGED (USED ON ITEMS 402,407,412,417)								1
440	BACB28U3B41		DELETED								
440A	BACB28U3B041		. BUSHING (USED ON ITEMS 400,405,410,415)								3
442	BACB28U4B048		. BUSHING (USED ON ITEMS 402,407,412,417)								2
445	65C28173-3		. FITTING (USED ON ITEM 400)								1
-450	65C28173-4		. FITTING (USED ON ITEM 405)								1
455	65C28173-7		. FITTING (USED ON ITEM 410)								1
-460	65C28173-8		. FITTING (USED ON ITEM 415)								1
462	65C30882-3		. FITTING (USED ON ITEMS 402,407 412,417)								1
465	65C28176-3		DELETED								

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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- 465A	BACS40V033C018		.	SHIM							2

-Item not Illustrated

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