COMPONENT MAINTENANCE MANUAL WITH ILLUSTRATED PARTS LIST

MAIN LANDING GEAR CENTER DOOR ASSEMBLY

PART NUMBER 65C33219–1, –2, –7, –8

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COMPONENT MAINTENANCE MANUAL

Revision No. 10
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To: All holders of MAIN LANDING GEAR CENTER DOOR ASSEMBLY 32-16-23.

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.

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Location of Change	Description of Change
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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

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

Revision		Filed		Revision		Filed	
Number	Date	Date	Initials	Number	Date	Date	Initials

Revision		Filed	
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When the temporary revision is incorporated or cancelled, and the pages are removed, enter the date the pages are removed and the initials of the person who removed the temporary revision.

Temporary Revision		Inserted		Removed	
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Temporary Revision		Inserted		Removed	
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Temporary Revision		Inserted		Removed	
Number	Date	Date	Initials	Date	Initials

Temporary Revision		Inserted		Removed	
Date	Initials	Number	Date	Date	Initials

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.

MAIN LANDING GEAR CENTER DOOR ASSEMBLY - DESCRIPTION AND OPERATION

1. Description and Operation

A. The main landing gear center door assembly is a composite structure consisting of fiberglass and graphite cloth, epoxy resin, and fiberglass honeycomb. Attached to the composite structure are fitting assemblies, a cradle assembly, and a door seal. The center door is rigidly attached to the main landing gear and drag link. Two hinge fittings, attached to the lower edge of the center door assembly, provide a pivot joint between the landing gear door assemblies. The door is opened and closed by the movement of the landing gear.

2. Leading Particulars (Approximate)

A. Length – 25 inches

B. Width – 22 inches

C. Thickness – 3 inches

D. Weight – 12 pounds

COMPONENT MAINTENANCE MANUAL

TESTING AND FAULT ISOLATION

(NOT APPLICABLE)

DISASSEMBLY

1. General

A. This procedure has the data necessary to disassemble the main landing gear center door assembly.

B. Disassemble this component only as necessary for fault isolation, to find the serviceability of parts, to do the repairs, and to put the unit back in serviceable condition.

C. Refer to the Standard Overhaul Practice Manual (SOPM) for the SOPM subjects identified in this procedure.

D. Refer to IPL Figure 1 for the correct item numbers.

2. Disassembly Procedure

A. Procedure

(1) Use standard industry practices for disassembly of this component.

NOTE: Remove fitting assemblies (110, 150, IPL Figure 1) per 20-10-08; Removal of Faying Surface Sealed Fittings from Composite Structure.

(2) Record thickness of shims (45, 50, 55, 85, 90, 95, 195, 200) for reference during assembly. (The thickness of shims has been determined or installation to meet the aerodynamic requirement.)

CLEANING

1. General

A. This procedure tells how to clean the main landing gear center 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 the correct item numbers.

2. Cleaning procedure

A. References

Reference	Title
SOPM 20-30-03	GENERAL CLEANING PROCEDURES
SOPM 20-30-99	SOLVENTS FOR FINAL CLEANING OF COMPOSITES BEFORE STRUCTURAL BONDING (SERIES 99)

B. Procedure

(1) Clean all parts by standard industry practices and the instructions in SOPM 20-30-03, unless as shown in the next step.

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.

CAUTION: DO NOT PUT THE PARTS IN THE SOLVENT OR LET SOLVENT STAY ON THE PARTS.

(2) Clean door bond assembly (210, IPL Figure 1) with a non-chlorinated vapor degreasing agent or a Series 99 solvent (Ref SOPM 20-30-99).

CHECK

1. General

A. This procedure tells how to check the main landing gear center 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 the correct item numbers.

2. Check Procedures

A. References

Reference	Title
737 SRM 52-80-01	Structural Repair Manual
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.

(2) Penetrant check (SOPM 20-20-02) – Fittings (60, 100, 140, 165, 745, IPL Figure 1) and cradle fitting (205).

(3) Examine the honeycomb panel and bonded parts for signs of delamination, internal water, scratches, and contour defects.

(4) Ultrasonically examine for delamination.

(5) Radiographically examine areas that could contain water to see how much damage there is.

(6) 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.

(7) Examine the assembly for nicks, scratches and corrosion and refer to 737 SRM 52-80-02 or 737 SRM 52-80-01, for allowable wear limits and repair data.

REPAIR

1. Content

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

Table 601:

P/N	NAME	REPAIR
69-77211	FITTING ASSY	1-1
69-77213	ATTACH FITTING ASSY	2-1
69-42372	BRACKET ASSY	3-1
69-42374	BRACKET ASSY	3-1
65C30882	HINGE ASSY	4-1
– – –	MISCELLANEOUS PARTS REFINISH	5-1

2. Materials

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

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

EXAMPLES

[— | 0.002]	STRAIGHT WITHIN 0.002
[⊥ | 0.002 | B]	PERPENDICULAR TO B WITHIN 0.002
[// | 0.002 | A]	PARALLEL TO A WITHIN 0.002
[○ | 0.002]	ROUND WITHIN 0.002
[⌭ | 0.010]	CYLINDRICAL SURFACE MUST LIE BETWEEN TWO CONCENTRIC CYLINDERS, ONE OF WHICH HAS A RADIUS 0.010 INCH GREATER THAN THE OTHER
[⌒ | 0.006 | A]	EACH LINE ELEMENT OF THE SURFACE AT ANY CROSS SECTION MUST LIE BETWEEN TWO PROFILE BOUNDARIES 0.006 INCH APART RELATIVE TO DATUM PLANE A
[⌓ | 0.020 | A]	SURFACES MUST LIE WITHIN PARALLEL BOUNDARIES 0.02 INCH APART AND EQUALLY DISPOSED ABOUT TRUE PROFILE
[◎ | Ø 0.0005 | C]	CONCENTRIC TO C WITHIN 0.0005 DIAMETER
[⌯ | 0.010 | A]	SYMMETRICAL WITH A WITHIN 0.010
[∠ | 0.005 | A]	ANGULAR TOLERANCE 0.005 WITH A
[⌖ | Ø 0.002 Ⓢ | B]	LOCATED AT TRUE POSITION WITHIN 0.002 DIA RELATIVE TO DATUM B, REGARDLESS OF FEATURE SIZE
[⊥ | Ø 0.010 Ⓜ | A] [0.510 Ⓟ]	AXIS IS TOTALLY WITHIN A CYLINDER OF 0.010-INCH DIAMETER, PERPENDICULAR TO, AND EXTENDING 0.510-INCH ABOVE, DATUM A, MAXIMUM MATERIAL CONDITION
[2.000] OR 2.000 BSC	THEORETICALLY EXACT DIMENSION IS 2.000

NOTE: DATUM MAY APPEAR AT EITHER SIDE OF TOLERANCE FRAME [0.020 | A] [A | 0.020]

True Position Dimensioning Symbols
Figure 601

FITTING ASSEMBLY - REPAIR 1-1

69-77211–1

1. General

A. This procedure tells how to replace the bushings of the fitting 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 the item numbers.

2. Repair Procedures

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95

B. References

Reference	Title
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-04	MISCELLANEOUS MATERIALS

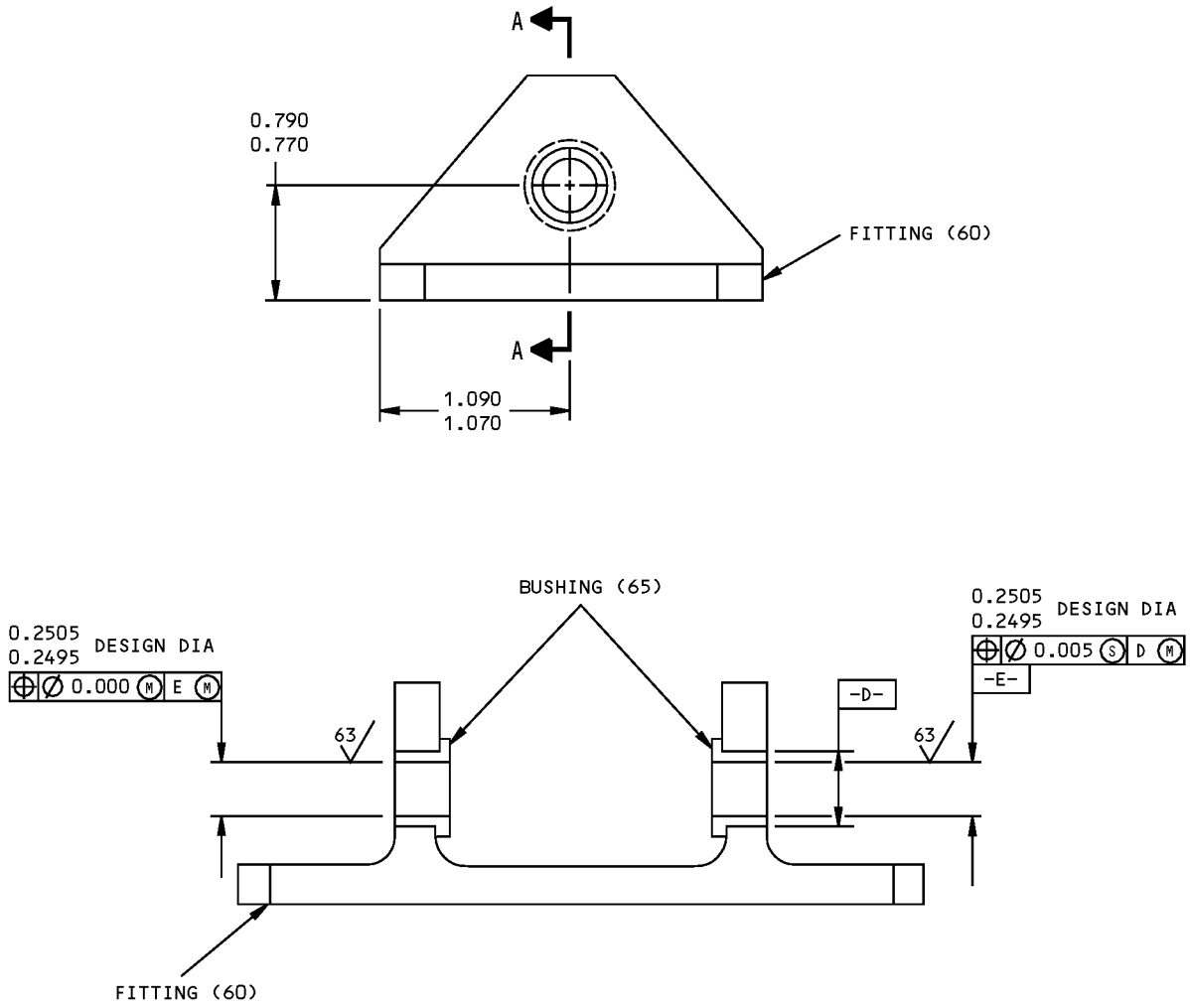
C. Bushing Replacement (65) (IPL Figure 1)

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

(1) Remove the old bushings (65).

(2) Install replacement bushings (see REPAIR 1-2 for oversize bushings) as specified in SOPM 20-50-03 with wet sealant, A00247.

(3) Machine the bushings as specified in REPAIR 1-1, Figure 601.



REFINISH

APPLY BMS 10-60, BAC707 GRAY ENAMEL (SRF-14.9813) ALL OVER, EXCEPT NO ENAMEL IN BUSHING HOLES.

REPAIR

125 ALL MACHINED SURFACES EXCEPT AS NOTED

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

69-77211-1

Bushing Replacement
Figure 601

FITTING ASSEMBLY - REPAIR 1-2

69-77211–2

1. General

A. This procedure tells how to repair the fitting 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 the correct item numbers.

2. Repair procedures

A. Hole for Bushings (REPAIR 1-2, Figure 601)

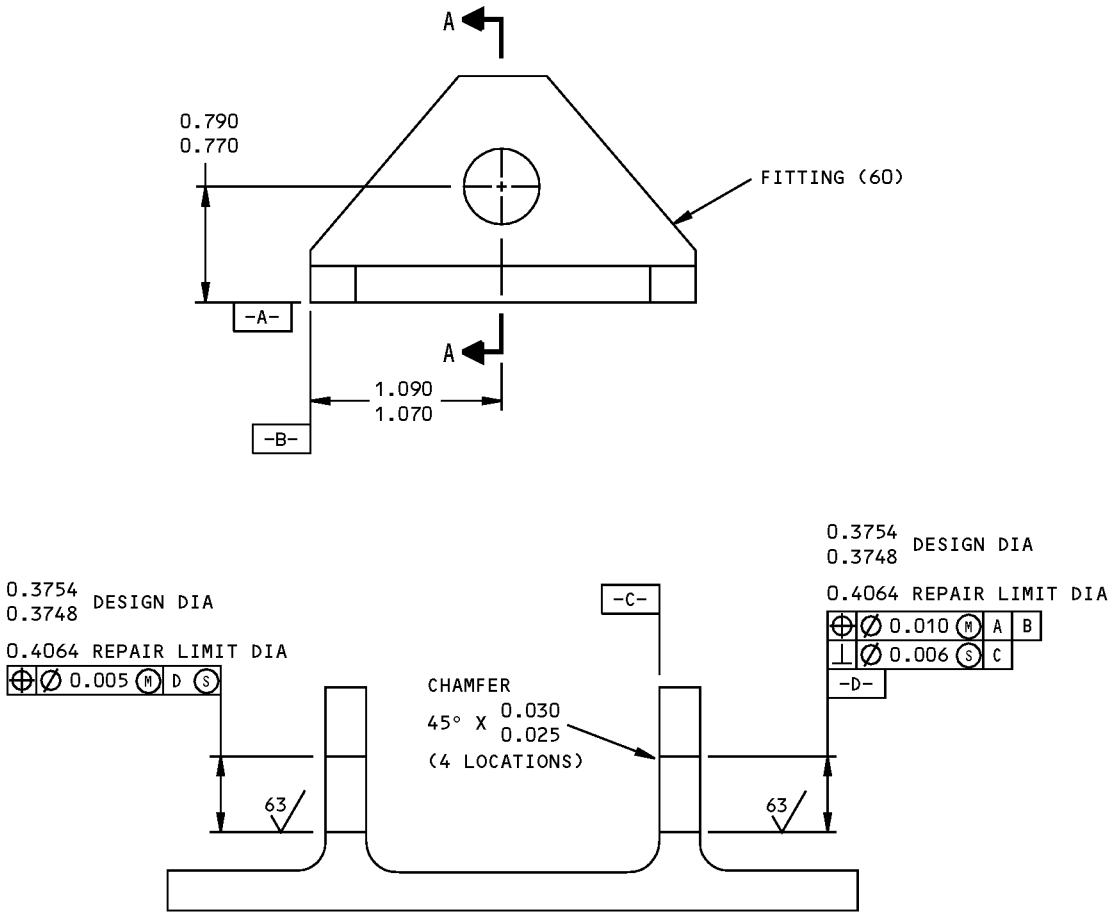
NOTE: For repair of surfaces which is only replacement of the original finish, refer to Refinish instructions, REPAIR 1-2, Figure 601.

(1) Machine as necessary, within repair limits, to remove defects.

(2) Shot peen and passivate.

(3) Make oversize bushings as required per REPAIR 1-2, Figure 602 to adjustfor the defects removed for the fitting in REPAIR 1-2, Paragraph 2.A.(1).

(4) Install the oversize bushings as specified in REPAIR 1-1.



A-A

REFINISH

CHROMIC ACID ANODIZE AND APPLY ONE COAT OF BMS 10-11, TYPE 1 PRIMER (F-18.13). APPLY BMS 10-60, BAC707 GRAY GLOSS ENAMEL (SRF-14.9813) ALL OVER EXCEPT IN BUSHING HOLES

REPAIR

125 ALL MACHINED SURFACES EXCEPT AS NOTED

BREAK ALL SHARP EDGES

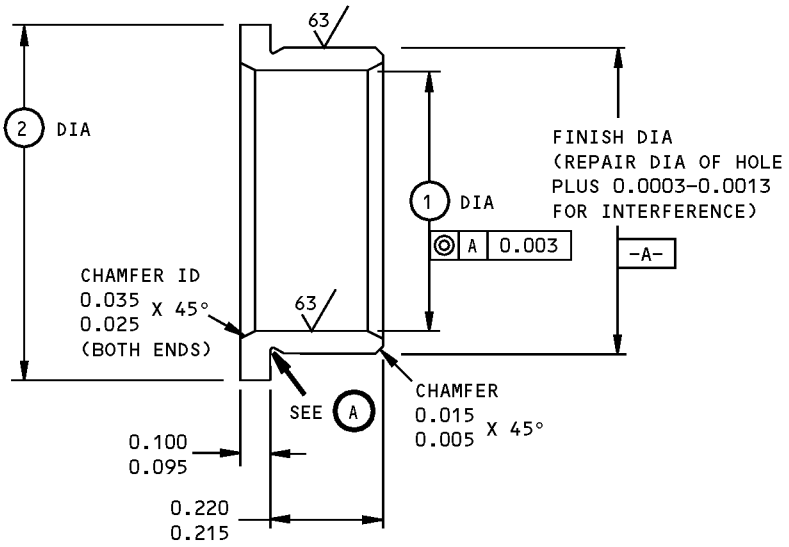
MATERIAL: ALUMINUM ALLOY

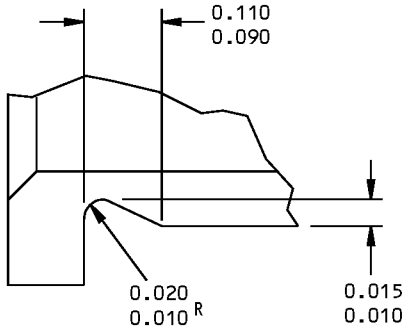
ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

69-77211-2

Fitting Repair
Figure 601





A

BUSHING ITEM NUMBER	1	2
105	0.2430 0.2380 1	0.510 0.490 1

REFINISH

CADMIUM PLATE (F-15.06) ALL OVER EXCEPT IN BUSHING BORE

1 DIMENSIONS AFTER PLATING

REPAIR

63 MACHINED SURFACES EXCEPT AS NOTED

BREAK ALL SHARP EDGES

MATERIAL: 17-4PH CRES (180-200 KSI)

MAGNETIC PARTICLE CHECK

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

69-77211-2 Oversize Bushing Detail
Figure 602

ATTACH FITTING ASSEMBLY - REPAIR 2-1

69-77213–1

1. General

A. This procedure tells how to replace bushings of the fitting 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 the correct item numbers.

2. Repair Procedures

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95

B. References

Reference	Title
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-04	MISCELLANEOUS MATERIALS

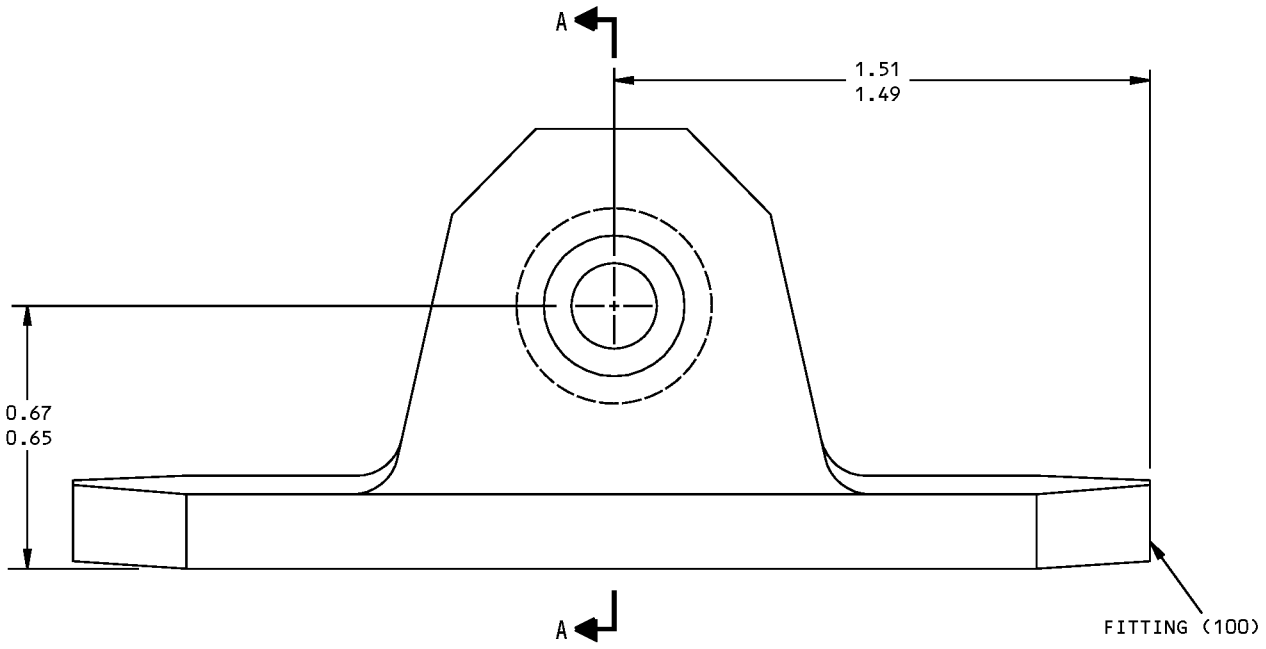
C. Bushing Replacement (105)

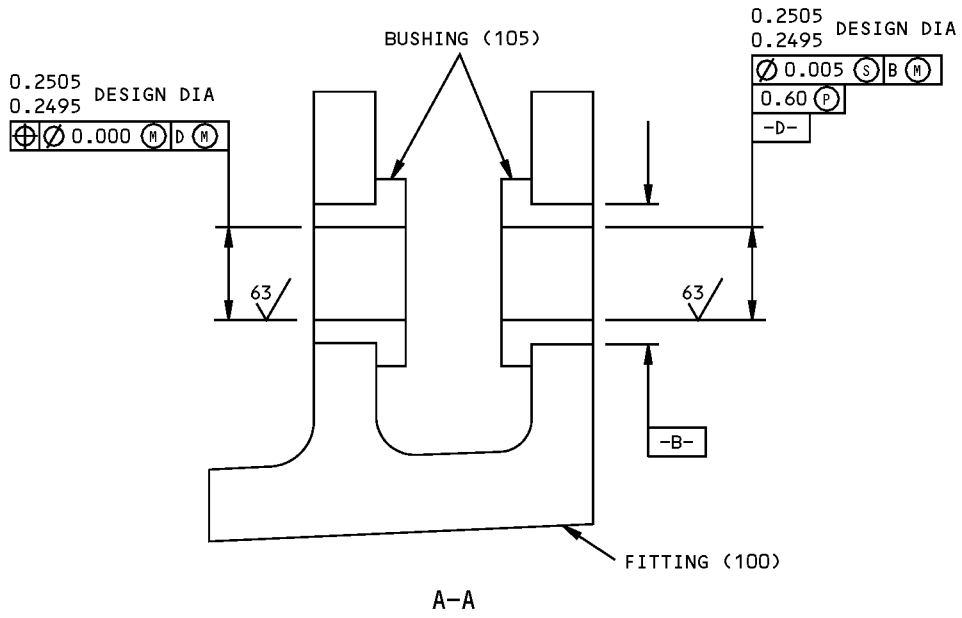
NOTE: For miscellaneous materials, refer to SOPM 20-60-04.

(1) Remove the old bushings (105).

(2) Install replacement bushings (See REPAIR 2-2 for oversize bushings) as specified in SOPM 20-50-03 with wet sealant, A00247.

(3) Machine the bushings as specified in REPAIR 2-1, Figure 601.





A-A

REFINISH

APPLY BMS 10-60, BAC707 GRAY GLOSS ENAMEL (SRF-14.9813), EXCEPT NO ENAMEL IN BUSHING HOLES.

REPAIR

125 ALL MACHINED SURFACES EXCEPT AS NOTED

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

69-77213-1 Bushing Replacement
Figure 601

ATTACH FITTING ASSEMBLY - REPAIR 2-2

69-77213–2

1. General

A. This procedure tells how to repair the fitting.

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.

C. Refer to IPL Figure 1 for the correct item numbers.

2. Repair Procedures (REPAIR 2-2, Figure 601)

A. Hole for Bushings

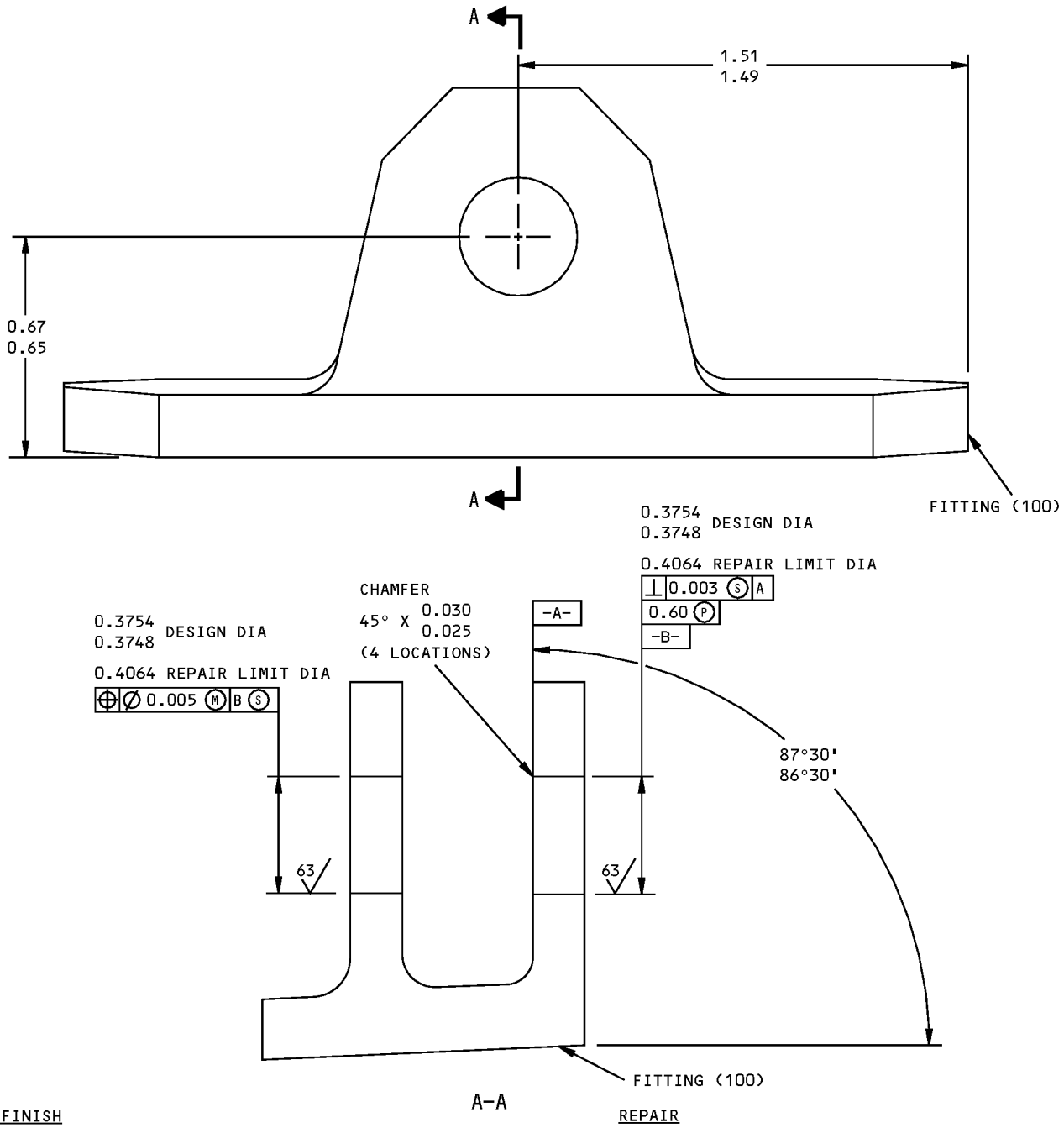
NOTE: For repair of surfaces which is only replacement of the original finish, refer to Refinish instructions, REPAIR 2-2, Figure 601.

(1) Machine the hole as required, within repair limits, to remove defects.

(2) Shot peen and passivate.

(3) Make oversize bushings as required per REPAIR 2-2, Figure 602 to adjust for the material removed in REPAIR 2-2, Paragraph 2.A.(1).

(4) Install the bushings as specified in REPAIR 2-1.



REFINISH

CHROMIC ACID ANODIZE AND APPLY ONE COAT OF BMS 10-11, TYPE 1 PRIMER (F-18.13). APPLY BMS 10-60, BAC707 GRAY GLOSS ENAMEL (SRF-14.9813) ALL OVER EXCEPT IN BUSHING HOLES.

REPAIR

125 ALL MACHINED SURFACES EXCEPT AS NOTED

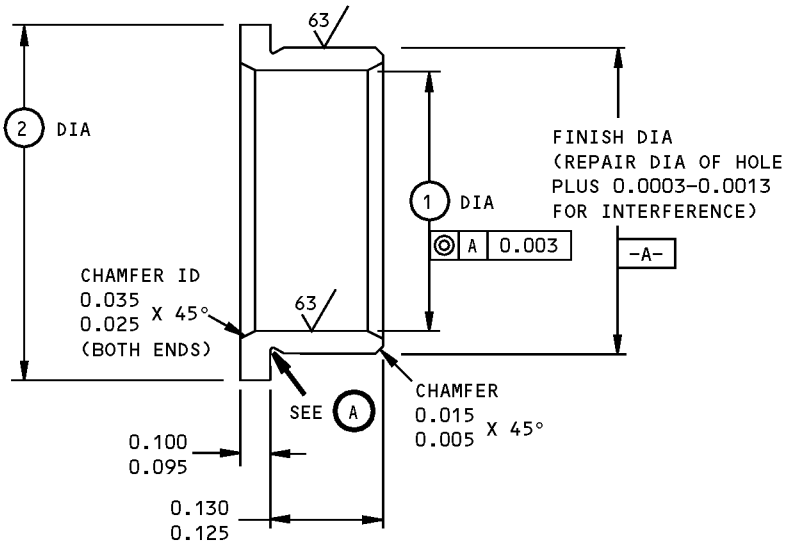
BREAK ALL SHARP EDGES

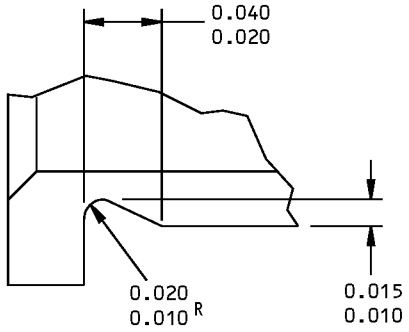
MATERIAL: ALUMINUM ALLOY

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

69-77213-2 Fitting Repair
Figure 601





A

BUSHING ITEM NUMBER	1	2
65	0.2430 0.2380 1	0.510 0.490 1

REFINISH

CADMIUM PLATE (F-15.06) ALL OVER EXCEPT IN BUSHING BORE

1 DIMENSIONS AFTER PLATING

REPAIR

63 MACHINED SURFACES EXCEPT AS NOTED

BREAK ALL SHARP EDGES

MATERIAL: 17-4PH CRES (180-200 KSI)

MAGNETIC PARTICLE CHECK

ALL DIMENSIONS ARE IN INCHES

69-37867-20 Oversize Bushing Detail
Figure 602

BRACKET ASSEMBLY - REPAIR 3-1

69-42372–9, 69-42374–7

1. General

A. This procedure tells how to repair the bracket 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 the item numbers.

2. Repair Procedures

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I
C00700	Coating - Exterior Protective Enamel, Gray Gloss Enamel	BMS10-60, Type I, BAC 707

B. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-02	FINISHING MATERIALS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

C. Bushing Replacement (145, 170) (IPL Figure 1)

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

(1) Remove the old bushings.

(2) Refinish per REPAIR 3-1, Paragraph 2.D..

(3) Install replacement bushings per SOPM 20-50-03 with wet sealant, A00247.

D. Refinish

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

(1) Fitting (140, 165) – Chromic acid anodize and apply primer, C00259 (F-18.13); but no primer in bores for bushings. Material: Al alloy.

(2) Bracket Assembly (110, 150) – Apply enamel coating, C00700 (F-14.9813, which replaces SRF-14.9813); but no enamel in bores for bushings.

HINGE ASSEMBLY - REPAIR 4-1

65C30882–1, –2

1. General

A. This procedure tells how to repair the hinge 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 the item numbers.

2. Repair procedures

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I
C00700	Coating - Exterior Protective Enamel, Gray Gloss Enamel	BMS10-60, Type I, BAC 707

B. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-02	FINISHING MATERIALS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

C. Bushing Replacement (750, 755)

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

(1) Remove the old bushings.

(2) Refinish per REPAIR 4-1, Paragraph 2.D..

(3) Install replacement bushings per SOPM 20-50-03 with wet sealant, A00247.

(4) Machine the bushings per REPAIR 4-1, Figure 601.

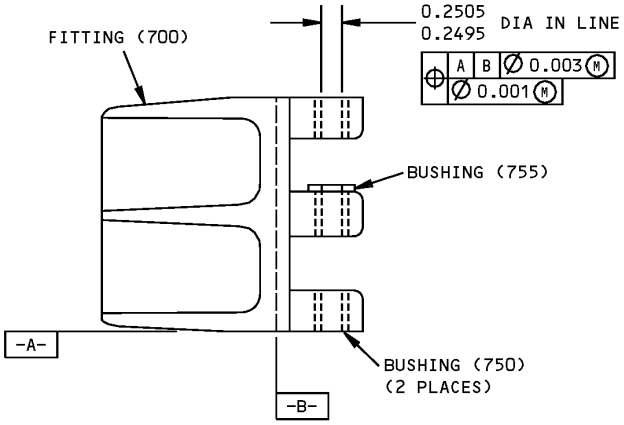
(5) Fillet seal bushing (755) flange with sealant, A00247.

D. Refinish

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

(1) Fitting (745) – Chromic acid anodize and apply primer, C00259 (F-18.13), but no primer in bores for bushings. Material: Al alloy.

(2) Fitting Assembly (700, 705) – Apply coating, C00700 (F-14.9813, which replaces SRF 14.9813), but no enamel in bores for bushings.



ALL DIMENSIONS ARE IN INCHES

65C30882-1 SHOWN Bushing Replacement
Figure 601

MISCELLANEOUS PARTS REFINISH - REPAIR 5-1

1. General

A. This procedure tells how to refinish the 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. Refer to IPL Figure 1 for the correct item numbers.

2. Repair procedures

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I
C00319	Primer - Urethane Compatible, Corrosion Resistant	BMS10-79, Type II
C00700	Coating - Exterior Protective Enamel, Gray Gloss Enamel	BMS10-60, Type I, BAC 707
C00767	Coating - Anti-Static Coating	BMS10-21, Type III

B. References

Reference	Title
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. Refinish

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

(1) Repair of these parts is only replacement of the original finish.

Table 601: Refinish Details

IPL FIG. & ITEM	MATERIAL	FINISH
Fig. 1		
Cradle fitting (205)	Aluminum alloy	Chromic acid anodize and apply primer, C00259 (F-18.13). Apply enamel coating, C00700 (SRF-14.9813).
Door - bond assy (210, 215)	Fiberglass and graphite cloth, epoxy resin, and fiberglass honey- comb	Prepare the surface (SRF-14.672). Applycoating, C00767 (F-14.685, which replaces SRF-14.68). Apply primer, C00319 (F-19.46). Apply enamel coating, C00700 (SRF-14.9813).

ASSEMBLY

1. General

A. This procedure tells how to assemble the fitting 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 the item numbers.

2. Assembly

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00027	Adhesive - Silicone Rubber, 1 Part, RTV	BAC5010, Type 60
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95
A01076	Adhesive - Synthetic Rubber	BAC5010, Type 93 (BMS5-95, Class B)
C00767	Coating - Anti-Static Coating	BMS10-21, Type III

B. References

Reference	Title
BAC 5000	Fay and Fillet Seals
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. Assembly Procedures

CAUTION: ONLY TITANIUM OR CORROSION RESISTANT STEEL FASTENERS SHALL BE USED THROUGH DOOR-BOND ASSEMBLY (210). SUBSTITUTION WITH ALUMINUM OR PLATED ALLOY STEEL FASTENERS IS NOT ALLOWED AS GALVANIC CORROSION WILL SHORTEN COMPONENT SERVICE LIFE.

(1) Use standard industry practices for assembly of this component and the following additional procedures.

(2) Bolts (20, 115) – Apply coating, C00767to bolt holes 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 with wet sealant, A00247.

(3) Bolts (15, 75, 120, 155, 175) – Install with wet sealant, A00247.

(4) Bracket assembly (110, 150) – Fay surface seal with sealant, A00247.

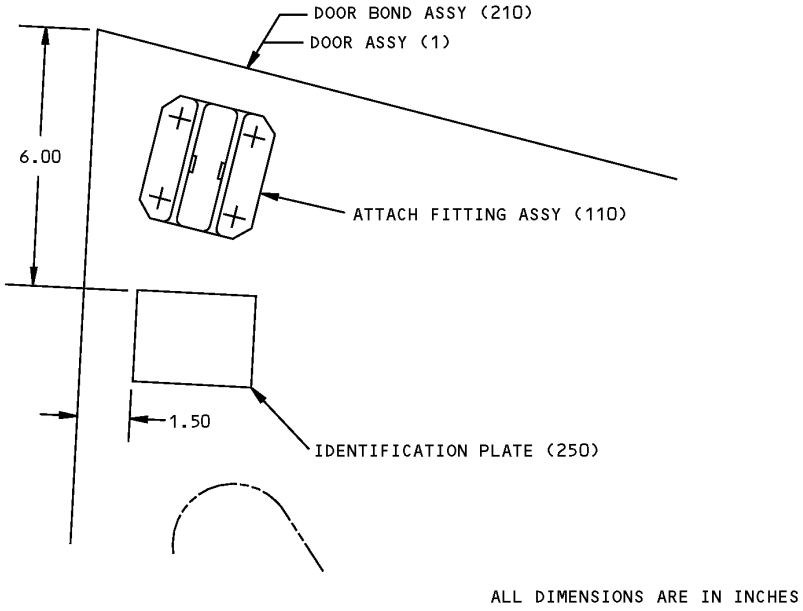
(5) Identification plate (250) – Bond per SOPM 20-50-12, type 93 per ASSEMBLY, Figure 701.

(6) Seal plugs (245) – Bond with Type 60 adhesive, A00027 or adhesive, A01076per SOPM 20-50-12.

(7) Shims (45, 50, 55, 85, 90, 95, 195, 200) – Install with sealant, A00247 per BAC 5000.

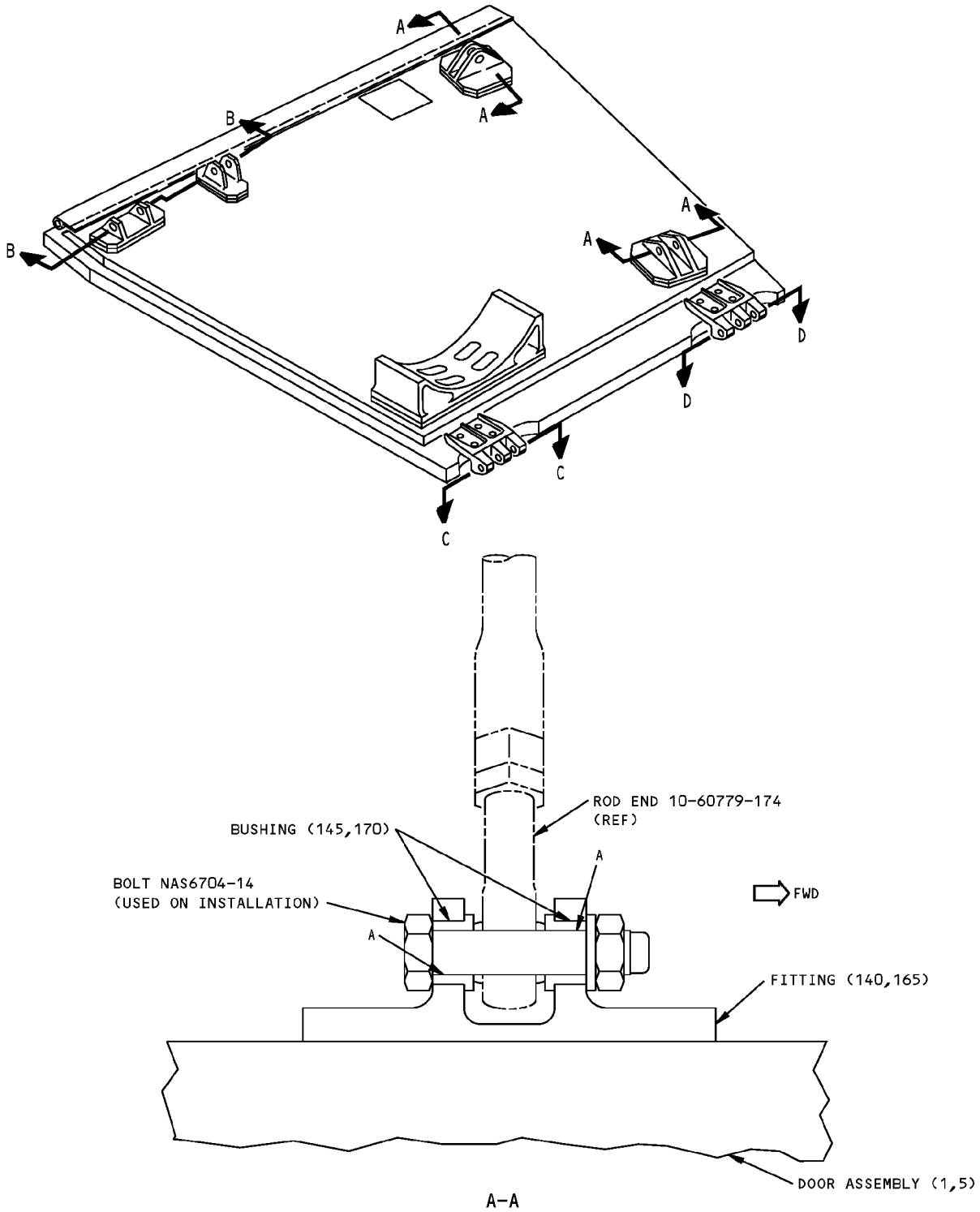
(8) Collars (40, 80, 135) – Fillet seal with sealant, A00247 per BAC 5000.

(9) Bolts (220) – Fillet seal with sealant, A00247 per BAC 5000.

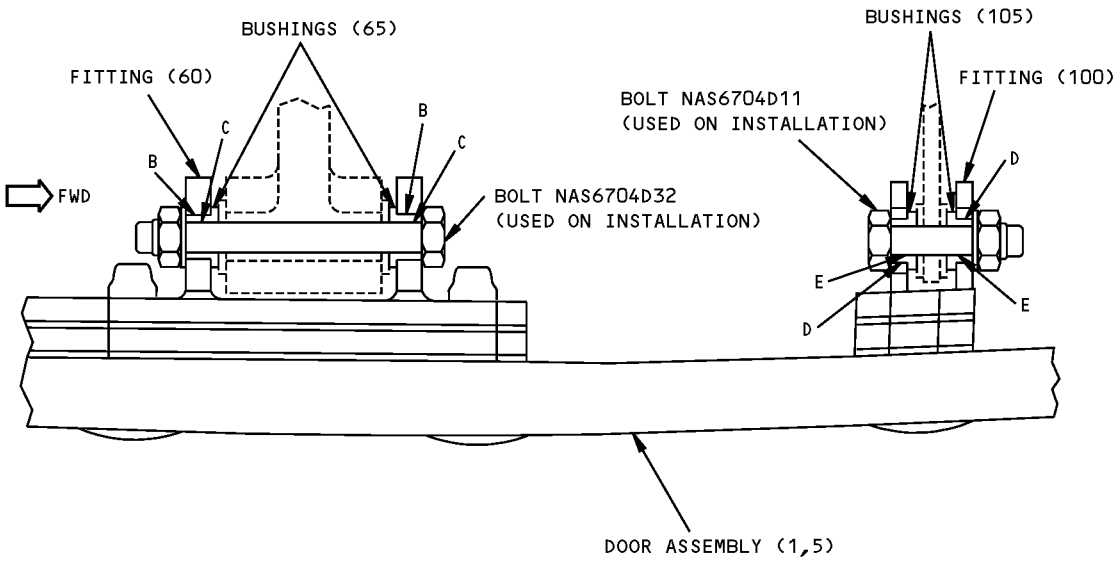


Location of Identification Plate
Figure 701

FITS AND CLEARANCES



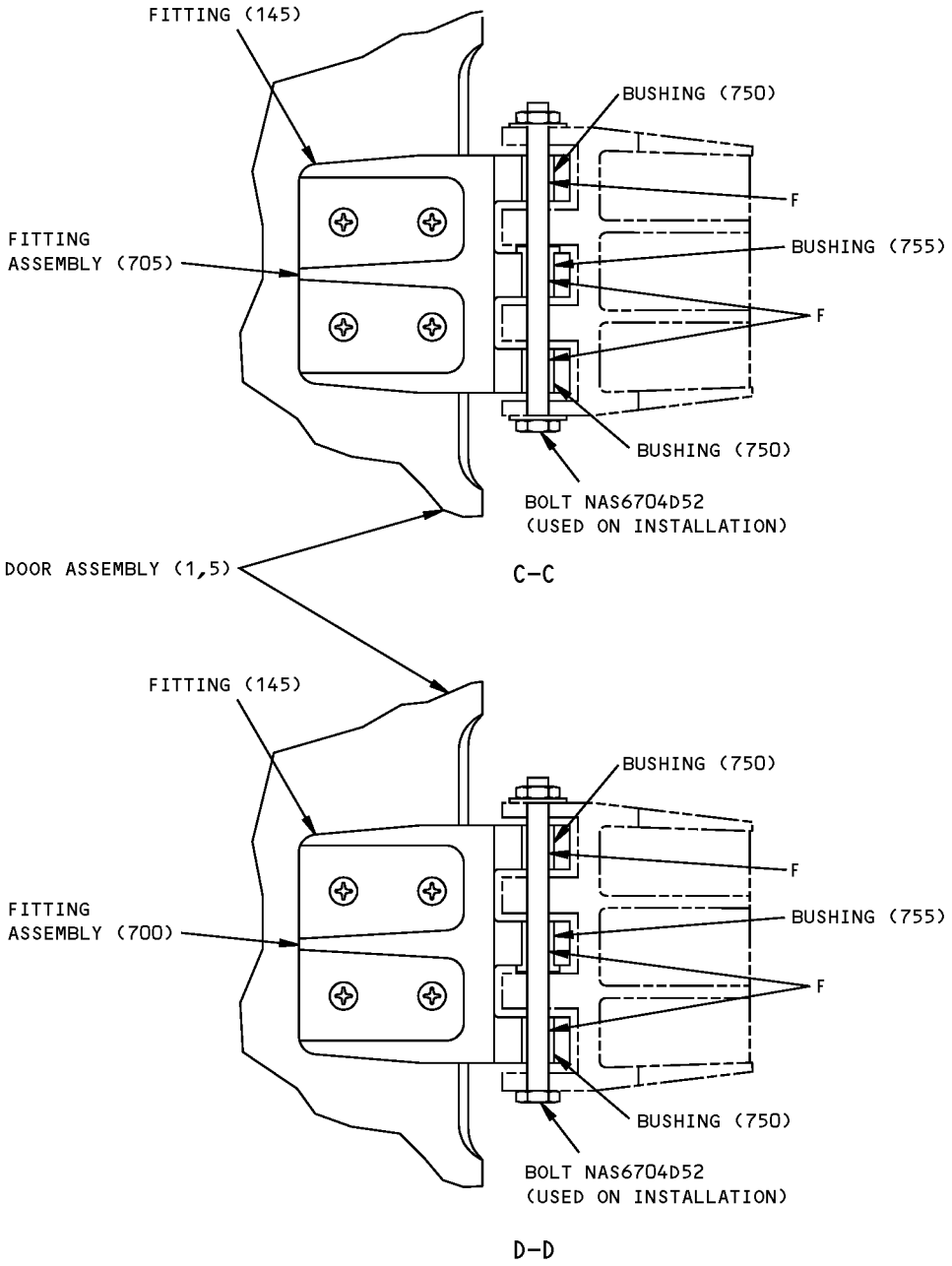
Fits and Clearances
Figure 801 (Sheet 1 of 4)



B-B

ALL ITEM NUMBERS REFER TO IPL FIG. 1

Fits and Clearances
Figure 801 (Sheet 2 of 4)



Fits and Clearances
Figure 801 (Sheet 3 of 4)

Ref Letter Fig.801	Mating Item No.	IPL Fig. No.	Design Dimension				Service Wear Limit		
			Dimensions		Assembly Clearance		Dimension Limits		Maximum Allowable Clearance
			Min	Max	Min	Max	Min	Max	
A	ID 145,170 OD ▷1◁	1	0.2500 0.2485	0.2515 0.2495	0.0005	0.0030	0.2455	0.2555	0.0050
B	ID 60 OD 65	1	0.3748 0.3757	0.3754 0.3761	-0.0013	-0.0003	0.3756	0.3755	-0.0002
C	ID 65 OD ▷2◁	1	0.2495 0.2485	0.2505 0.2495	0.0000	0.0020	0.2455	0.2535	0.0040
D	ID 100 OD 105	1	0.3748 0.3757	0.3754 0.3761	-0.0013	-0.0003	0.3756	0.3755	-0.0002
E	ID 105 OD ▷3◁	1	0.2495 0.2485	0.2505 0.2495	0.0000	0.0020	0.2455	0.2535	0.0050
F	ID 750,755 OD ▷4◁	1	0.2495 0.2485	0.2505 0.2495	0.0000	0.0020	0.2455	0.2535	0.0040

ALL DIMENSIONS ARE IN INCHES

▷1◁ BOLT NAS6704-14 (USED ON INSTALLATION)
▷2◁ BOLT NAS6704D32 (USED ON INSTALLATION)
▷3◁ BOLT NAS6704D11 (USED ON INSTALLATION)
▷4◁ BOLT NAS6704D52 (USED ON INSTALLATION)

Fits and Clearances
Figure 801 (Sheet 4 of 4)

(NOT APPLICABLE)

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

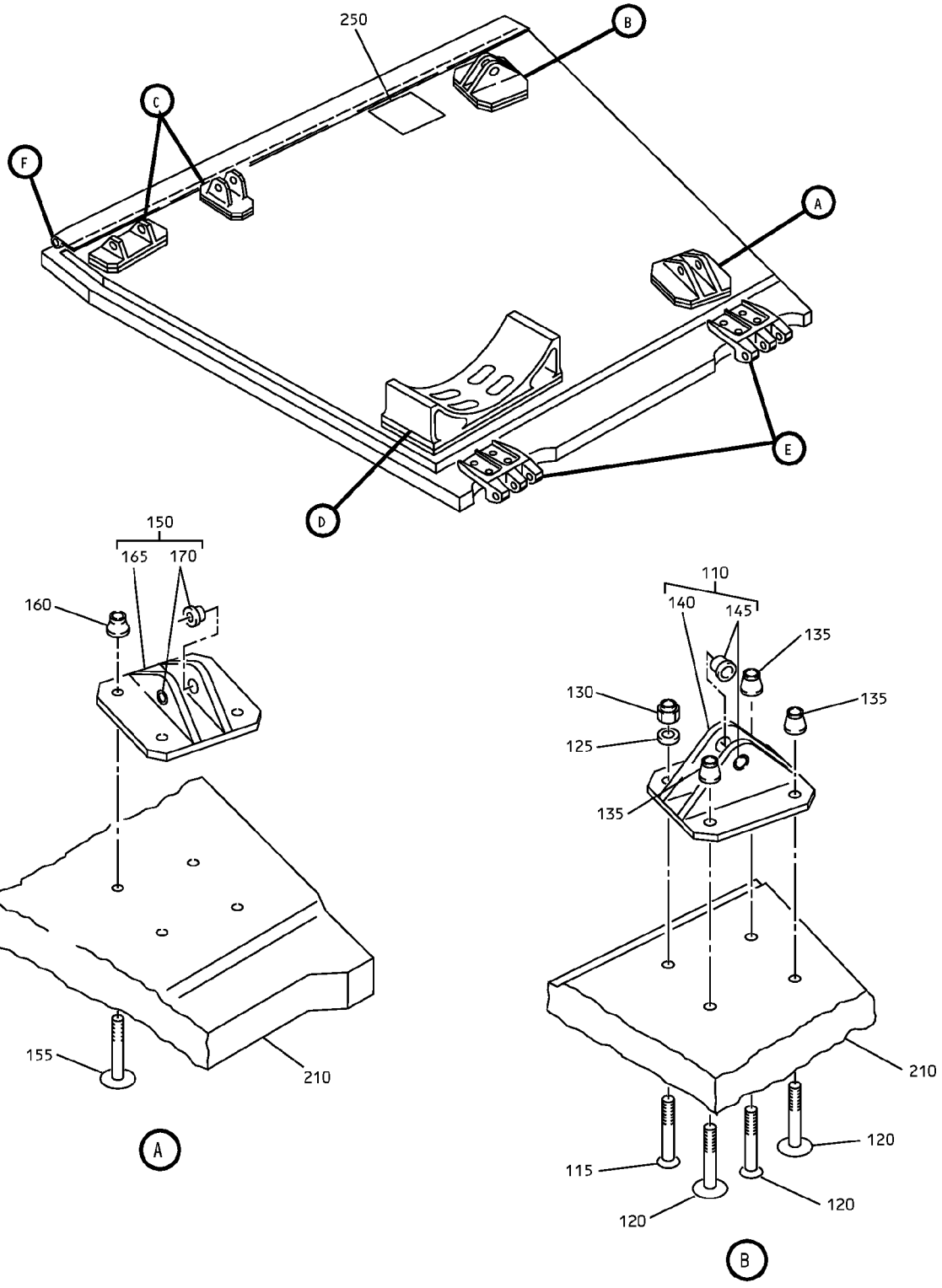
Optional (OPT)	The part is optional to and interchangeable with other parts that have the same item number.
Replaces, Replaced by and not interchangeable with (REPLACES, REPLACED BY AND NOT INTCHG/W)	The part replaces and is not interchangeable with the initial part.
Replaces, Replaced by (REPLACES,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

NUMERICAL INDEX

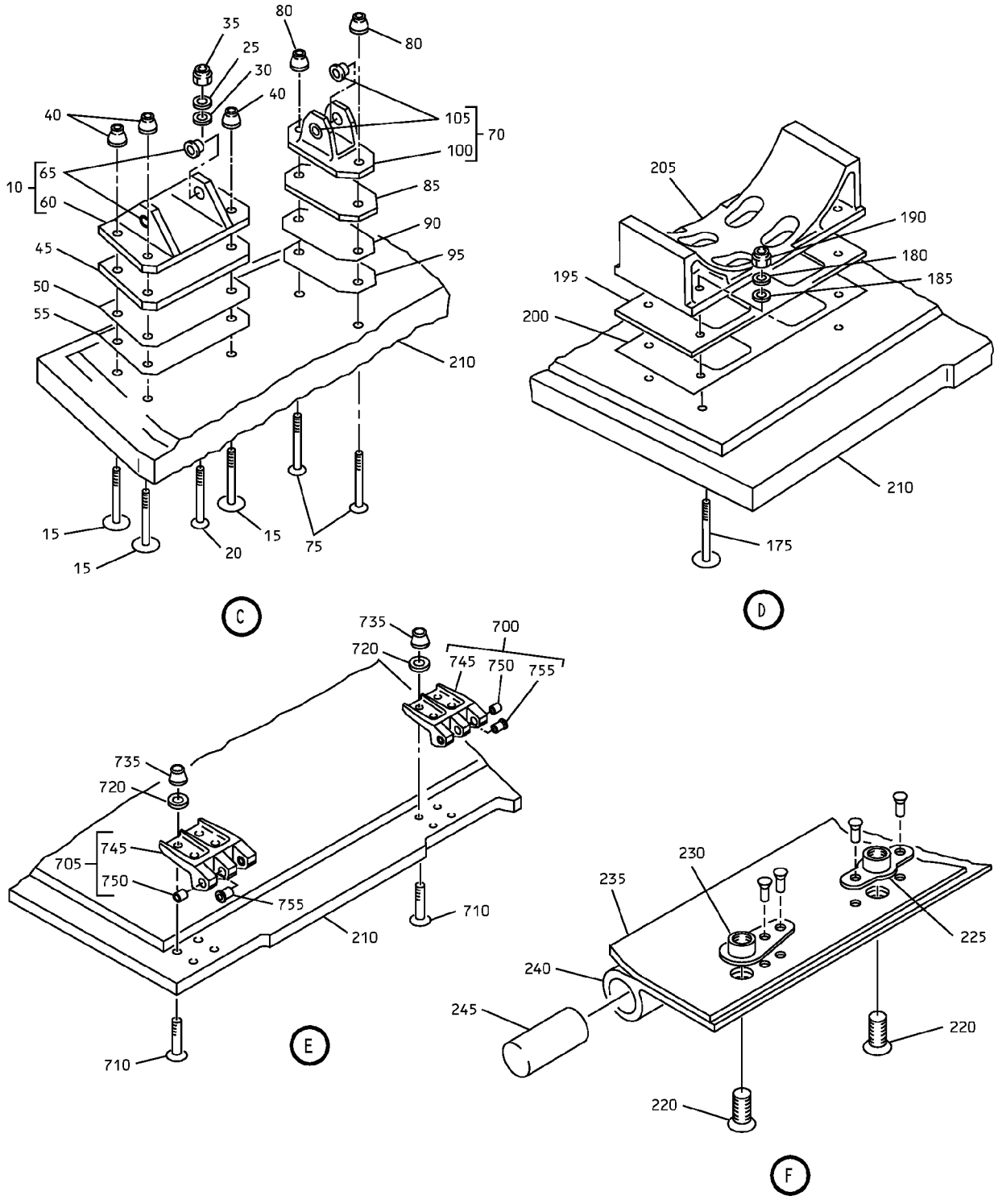
PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
10-60754-482		1	240	1
65C30882-1		1	700	1
65C30882-2		1	705	1
65C30882-3		1	745	1
65C33219-1		1	1	RF
65C33219-10		1	235B	1
65C33219-2		1	5	RF
65C33219-3		1	235	1
65C33219-4		1	245	2
65C33219-7		1	1A	RF
65C33219-8		1	5A	RF
65C33219-9		1	235A	1
65C33220-23		1	210	1
65C33220-24		1	215	1
65C33220-35		1	210A	1
65C33220-36		1	215A	1
69-37867-20		1	105	1
69-37867-23		1	65	2
69-42372-10		1	140	1
69-42372-9		1	110	1
69-42374-7		1	150	1
69-42374-8		1	165	1
69-77211-1		1	10	1
69-77211-2		1	60	1
69-77212-1		1	205A	1
69-77212-3		1	205	1
69-77213-1		1	70	1
69-77213-2		1	100	1
69-77326-1		1	195	1
69-77326-2		1	200	1
69-77326-3		1	45	1
69-77326-4		1	50	1
69-77326-5		1	55	1
69-77326-6		1	85	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
69-77326-7		1	90	1
69-77326-8		1	95	1
AN960JD416		1	125	1
		1	720	4
BACB20NN5K22		1	175	4
BACB28U4B048		1	750	2
BACB28W4B046		1	755	1
BACB28X4M014		1	145	2
BACB28X4M019		1	170	2
BACB30LR4-13		1	115	1
BACB30LR4-20		1	20	1
BACB30NN3K13		1	220	16
BACB30VG8K12		1	120	3
BACB30VG8K18		1	155	4
BACB30VG8K19		1	15	3
		1	75	2
BACB30VGBK12		1	710	4
BACC30AG8		1	40	3
		1	80	2
		1	135	3
		1	160	4
BACC30M8		1	735	4
BACN10JD4ASU		1	730	1
BACN10JN3CD		1	225	14
BACN10KB3CFD		1	230	2
BACW104DP		1	725	1
BACW10CA104CC		1	25	1
BACW10CA104CV		1	30	1
BACW10CA5CC		1	180	4
BACW10CA5CV		1	185	4
MS24665-153		1	740	1
MS27253-1		1	250A	1
MS27253-C1		1	250	1
NAS1805-4L		1	35	1
		1	130	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
NAS1805-5L		1	190	4
NAS6704D52		1	715	1



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



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

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
1	65C33219-1		DOOR ASSY, CENTER, MAIN LANDING GEAR (LH)	A	RF
1A	65C33219-7		DOOR ASSY, CENTER, MAIN LANDING GEAR (LH)	C	RF
–5	65C33219-2		DOOR ASSY, CENTER, MAIN LANDING GEAR (RH)	B	RF
5A	65C33219-8		DOOR ASSY, CENTER, MAIN LANDING GEAR (RH)	D	RF
10	69-77211-1		. FITTING ASSY		1
			ATTACHING PARTS		
15	BACB30VG8K19		. BOLT		3
20	BACB30LR4-20		. BOLT		1
25	BACW10CA104CC		. WASHER		1
30	BACW10CA104CV		. WASHER		1
35	NAS1805-4L		. NUT		1
40	BACC30AG8		. COLLAR		3
45	69-77326-3		. SHIM		1
50	69-77326-4		. SHIM		
55	69-77326-5		. SHIM		1
			- - - - - - - * - - - - - - - -		
60	69-77211-2		. . FITTING		1
65	69-37867-23		. . BUSHING		2
70	69-77213-1		. ATTACH FITTING ASSY		1
			ATTACHING PARTS		
75	BACB30VG8K19		. BOLT		2
80	BACC30AG8		. COLLAR		2
85	69-77326-6		. SHIM		1
90	69-77326-7		. SHIM		1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
95	69-77326-8		. SHIM		1
			- - - - - - - * - - - - - - -		
100	69-77213-2		. . FITTING		1
105	69-37867-20		. . BUSHING		
110	69-42372-9		. BRACKET ASSY, CRADLE SUPPT ATTACHING PART		1
115	BACB30LR4-13		. BOLT		1
120	BACB30VG8K12		. BOLT		3
125	AN960JD416		. WASHER		1
130	NAS1805-4L		. NUT		1
135	BACC30AG8		. COLLAR		3
140	69-42372-10		. . FITTING		1
145	BACB28X4M014		. . BUSHING		2
150	69-42374-7		. BRACKET ASSY		1
			ATTACHING PARTS		
155	BACB30VG8K18		. BOLT		4
160	BACC30AG8		. COLLAR		4
			- - - - - - - * - - - - - - -		
165	69-42374-8		. . FITTING		1
170	BACB28X4M019		. . BUSHING		2
175	BACB20NN5K22		. BOLT		4
180	BACW10CA5CC		. WASHER		4
185	BACW10CA5CV		. WASHER		4
190	NAS1805-5L		. NUT		4
195	69-77326-1		. SHIM		1
200	69-77326-2		. SHIM		1
205	69-77212-3		. CRADLE-FITTING		1
–205A	69-77212-1		. CRADLE-FITTING (OPT ITEM 205)		1
210	65C33220-23		. BOND ASSY	A	1
210A	65C33220-35		. BOND ASSY	C	1
215	65C33220-24		. BOND ASSY	B	1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
215A	65C33220-36		. BOND ASSY	D	1
220	BACB30NN3K13		. BOLT		16
225	BACN10JN3CD		. NUTPLATE		14
230	BACN10KB3CFD		. NUTPLATE		2
235	65C33219-3		. SEAL RETAINER	A, B	1
235A	65C33219-9		. SEAL RETAINER	C	1
235B	65C33219-10		. SEAL RETAINER	D	1
240	10-60754-482		. SEAL		1
245	65C33219-4		. SEAL PLUG		2
250	MS27253-C1		. ID PLATE (OPT ITEM 250A)	A, B	1
250A	MS27253-1		. ID PLATE	C, D	1
			INSTALLATION PARTS		
700	65C30882-1		HINGE ASSY (USER WITH MLG INNER DOOR ASSEMBLY 65C28178-29 AND -30) (REFER TO CMM 32-16-12)		1
705	65C30882-2		HINGE ASSY (USER WITH MLG INNER DOOR ASSEMBLY 65C28178-29 AND -30) (REFER TO CMM 32-16-12)		1
			ATTACHING PARTS		
710	BACB30VGBK12		BOLT		4
715	NAS6704D52		BOLT		1
720	AN960JD416		WASHER		4
725	BACW104DP		WASHER		1
730	BACN10JD4ASU		NUT		1
735	BACC30M8		COLLAR		4
740	MS24665-153		COTTER PIN		1
			- - - - - - - * - - - - - - - -		
745	65C30882-3		. FITTING (USED ON ITEMS 700,705)		1
750	BACB28U4B048		. BUSHING		2
755	BACB28W4B046		. BUSHING		1

–Item not Illustrated