



**COMPONENT MAINTENANCE
MANUAL
WITH
ILLUSTRATED PARTS LIST**

FORWARD ENTRY DOOR ASSEMBLY

**PART NUMBER
141A6100-678, 141A6150-1, -2, -3, -4, -5, -6, -7, -8**

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COMPONENT MAINTENANCE MANUAL

Revision No. 10
Jul 01/2009

To: All holders of FORWARD ENTRY DOOR ASSEMBLY 52-16-12.

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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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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FORWARD ENTRY DOOR ASSEMBLY - DESCRIPTION AND OPERATION

1. Description

A. The forward entry door assembly provides access to the airplane passenger compartment. The door assembly is a plug-type that opens outward of the passenger compartment. The door is attached at the side edge onto the airplane structure with hinges. The door latch mechanism has a latch assembly connected to the latch rollers, the torque tube and the control rod. The door has access panels for inspection and repair of the latching mechanism.

2. Operation

A. To open the forward entry door from outside the airplane, you pull the outer handle from the spring-loaded flush position. When you turn the handle, the torque tube pulls the latch rollers from the latch fittings to let the door be swung out to side structure.

3. Leading Particulars (Approximate)

- A. Length – 45.0 inches
- B. Width – 6.0 inches
- C. Height – 77.0 inches
- D. Weight
 - (1) 141A6100-678 – 138.9 pounds
 - (2) 141A6150-1 thru -8 – 139.0 pounds

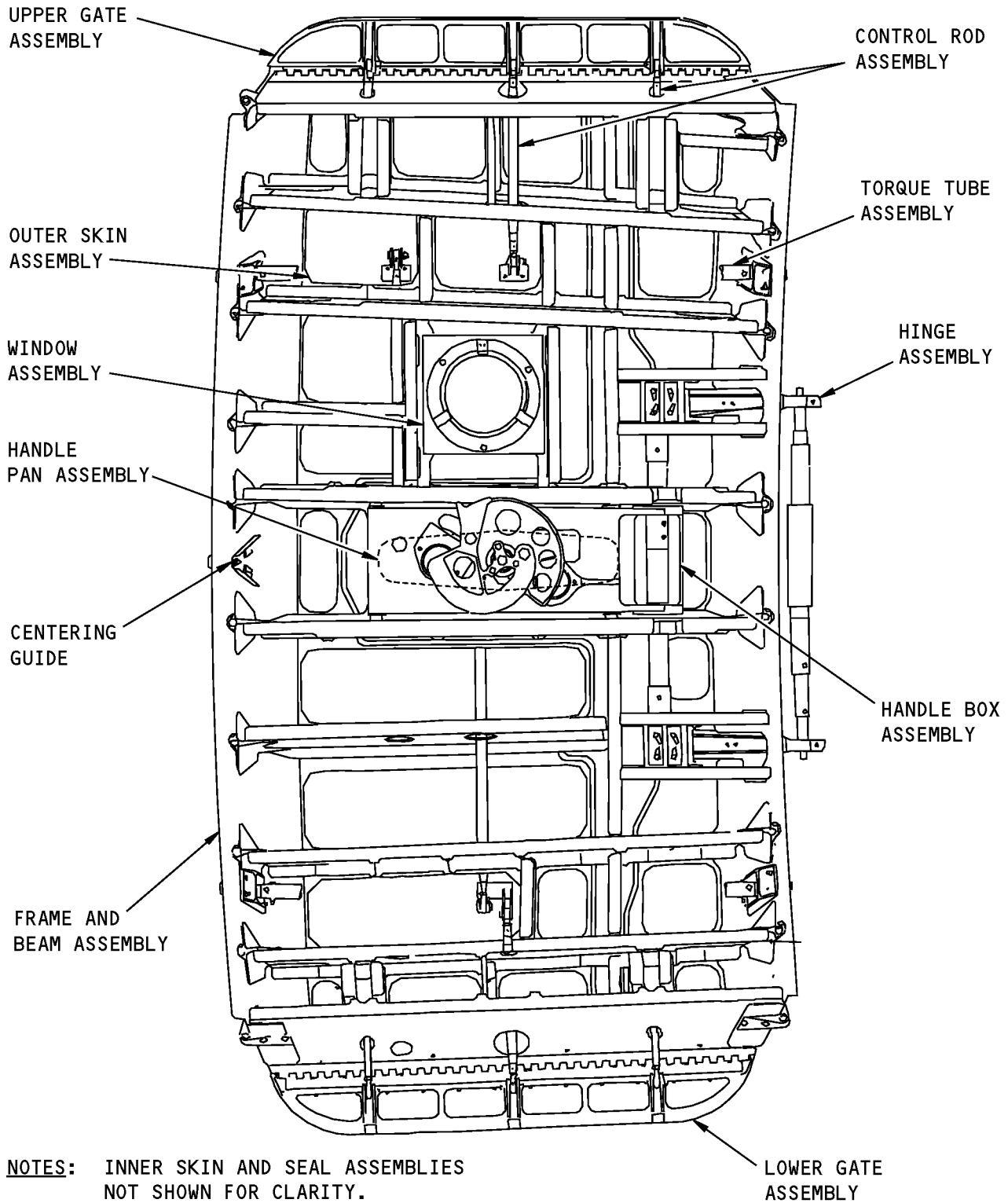
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DESCRIPTION AND OPERATION

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Forward Entry Door Assembly
Figure 1

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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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DISASSEMBLY

1. General

- A. This procedure tells how to disassemble the forward entry door assembly.
- B. Disassemble this component sufficiently to isolate the defects, do the necessary repairs, and put the component back to a serviceable condition.
- C. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- D. Refer to IPL Figure 1 - IPL Figure 16 for item numbers.

2. Disassembly

- A. Special Tools and Equipment

NOTE: Equivalent tools may be used.

- (1) F70038 – Wrench assembly
- (2) F70085 – Spanner wrench

- B. Procedure

- (1) Use standard industry procedures and steps below to disassemble this component.
- (2) Do not remove any component from the forward entry door assembly that is riveted or bonded unless replacement is necessary.
- (3) Remove the handle bracket assembly (IPL Figure 16, 15), slide support fitting (115), slide support fitting assembly (120), and the stop (170, 175) from the door structure, as follows:
 - (a) Remove the bolts (5), washers (10), and the handle bracket assembly (15) from the door structure.
 - (b) Remove the bolts (70, 75, 80), washers (85, 90), collar (95), nuts (100, 105), retainer (110), and the slide support fitting (115) from the door structure.
 - (c) Remove the bolts (75, 80), washers (85, 90), nuts (100, 105), retainer (110), and the slide support fitting assembly (120) from the door structure.
 - (d) Remove the bolts (160), nuts (165), and the stops (170, 175) from the door structure.
- (4) Remove the access panels (IPL Figure 10, 75, 80, 120, 125) and cam cover assembly (145) from the door structure, as follows:
 - (a) Remove the bolt (10), washer (25), rivets (30, 35), and the access panel (75) from the door structure.
 - (b) Remove the rivets (30, 40, 45, 50) and the access panel (80) from the door structure.
 - (c) Remove the studs (150), washers (155, 160), ring (165), and the cover (170) from the door structure.
 - (d) Remove the bolts (85, 90, 95), washers (100), and the access panel (120) from the door structure.
 - (e) Remove the bolts (85, 95), washers (100), and the access panel (125) from the door structure.
- (5) Remove the seal (IPL Figure 9, 160), seal retainers (30, 35, 40, 45, 105, 110, 115, 120, 135, 140, 145, 150), locators (50, 55, 60, 65), and the cantilever springs (95, 100) from the door structure, as follows:

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- (a) Remove the screws (5), washers (10), nuts (15, 20, 25, 27A, 28A), retainers (30, 35, 40, 45), and locators (50, 55, 60, 65) from the door structure.
 - (b) Remove the bolts (70, 75, 80), washers (85), clamp (90), cantilever springs (95, 100), and retainers (105, 110, 115, 120) from the door structure.
 - (c) Remove the screws (125), washers (130), retainers (135, 140, 145, 150), seal insert (155), and seal (160) from the door structure.
- (6) Disconnect the upper and lower gate assemblies (IPL Figure 3, 90; IPL Figure 4, 65) from the upper and lower rod assemblies (IPL Figure 14, 55, 130; IPL Figure 15, 55, 130), as follows:
- (a) Disconnect the upper gate assembly (IPL Figure 3, 90) from the upper rod assemblies (IPL Figure 14, 55, 130), as follows:
 - 1) Remove the cotter pins (IPL Figure 14, 5), bolts (10), washers (20, 25), bushing (50) to disconnect the upper gate assembly (IPL Figure 3, 90) from the upper rod assembly (55).
 - 2) Remove the cotter pin (IPL Figure 14, 85), bolt (90), washers (110, 115), bushing (125) to disconnect the upper gate assembly (IPL Figure 3, 90) from the upper pushrod assembly (130).
 - (b) Disconnect the lower gate assembly (IPL Figure 4, 65) from the lower rod assemblies (IPL Figure 15, 55, 130), as follows:
 - 1) Remove the cotter pins (IPL Figure 15, 5), bolts (10), washers (20, 25), bushing (50) to disconnect the lower gate assembly (IPL Figure 4, 65) from the lower rod assembly (55).
 - 2) Remove the cotter pin (IPL Figure 15, 85), bolt (90), washers (110, 115), bushing (125) the lower gate assembly (IPL Figure 4, 65) from the lower pushrod assembly (130).
- (7) Remove the upper and lower gate assemblies (IPL Figure 3, 90; IPL Figure 4, 65) from door structure.
- (a) Remove the upper gate assembly (IPL Figure 3,90), as follows:
 - 1) Remove the bolts (5, 10, 40), collar (45), and hinge assembly (65) from the upper gate assembly (90) and the door structure.
 - (b) Remove the upper gate assembly (IPL Figure 4, 65), as follows:
 - 1) Remove the bolts (5, 10) and hinge assembly (40) from the lower gate assembly (65) and the door structure.
- (8) Remove the upper and lower rod assemblies (IPL Figure 14, 55, 130, 135; IPL Figure 15, 55, 130) from the door structure.
- (a) Remove the upper rod assemblies (IPL Figure 14, 55, 130, 135) as follows:
 - 1) Remove the bolts (IPL Figure 14, 15), washers (30, 35), nuts (45), and the upper stop rod assemblies (55) from the door structure.
 - 2) Remove the cotter pin (85), bolt (100), washers (110, 115), nut (120), and the upper pushrod assembly (130) from the upper latch torque tube assembly (IPL Figure 13, 25) and the door structure.
 - 3) Remove the cotter pin (IPL Figure 14, 85), bolts (95, 105), washers (110, 115), nut (120), and upper pushrod assembly (135) from the upper latch torque tube assembly (IPL Figure 13, 25) and the hinge box assembly (IPL Figure 12, 170).

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DISASSEMBLY

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- (b) Remove the lower rod assemblies (IPL Figure 15, 55, 130) as follows:
 - 1) Remove the bolts (IPL Figure 15, 15), washers (30, 35), nut (45), and the lower stop rod assemblies (55) from the door structure.
 - 2) Remove the cotter pin (85), bolt (100), washers (110, 115), nut (120), and lower pushrod assembly (130) from the lower latch torque tube assembly (IPL Figure 13, 30) and the door structure.
 - 3) Remove the cotter pin (IPL Figure 15, 85), bolts (95, 105), washers (110, 115), nut (120), and lower pushrod assembly (135) from the lower latch torque tube assembly (IPL Figure 13, 30) and the hinge box assembly (IPL Figure 12, 170).
- (9) Remove the upper and lower torque tube assemblies (IPL Figure 13, 25, 30) from the door structure.
 - (a) Remove the upper torque tube assembly (IPL Figure 13, 25), as follows:
 - 1) Remove the bolts (5), washers (15), nuts (20), and latching cranks (60) from the upper tube (80).
 - 2) Remove the bolts (10), washers (15), nuts (20), and the bellcranks (65, 70) from the upper tube (80). Slide the upper tube (80) out of the door structure.
 - (b) Remove the lower torque tube assembly (IPL Figure 13, 30), as follows:
 - 1) Remove the bolts (5), washers (15), nuts (20), and latching cranks (60) from the lower tube (80).
 - 2) Remove the bolts (10), washers (15), nuts (20), and bellcrank (75) from lower tube (80). Slide the lower tube (80) out of the door structure.
- (10) Remove the support fitting assemblies (IPL Figure 8, 30 thru 45) and housing assembly (105) from the door structure, as follows:
 - (a) Remove the bolts (5, 10), washers (15), nuts (20), and the support fitting assemblies (30 thru 50) from the door structure.
 - (b) Remove the bolts (80), washers (85, 90), nuts (95), retainers (100), and the housing assemblies (105) from the door structure.
- (11) Remove the hinge assembly (IPL Figure 11, 125B) from the door structure, as follows:
 - (a) Remove the bolts (5), washers (10), nuts (15), retainers (20), and the clip assemblies (25, 30) from the hinge assembly (125B).
 - (b) Remove the bolts (70, 75), washers (90, 95), and the nuts (100, 105) from the hinge assembly (125B).
 - (c) Remove the bolts (80), washers (85, 95), and the nut (110) from the handle box assembly (IPL Figure 1, 55) and the hinge assembly (IPL Figure 11, 125B).
 - (d) Loosen the special nuts (120) located on the hinge assembly (125B).
 - (e) Remove the packing (115), special nut (120), and the hinge assembly (125B) from the door structure.
 - (f) Remove the arm assembly (135) from pin assembly (130) and arm assembly (140) from the hinge pin (132).
 - (g) Do not remove rivets (145), clips (170, 175), filler (180), rivet (160), and nutplate (165) unless replacement is necessary.
 - (h) Remove the hinge pin assembly (130) and hinge pin (132) from sleeves (195).

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- (i) Remove the sleeves (195) and the torque tube crank (200) from the torque tube (205).
- (12) Remove the hinge box assembly (IPL Figure 12, 170) from the door structure, as follows:
 - (a) Remove the bolts (130 thru 160), washers (165), and the hinge box assembly (170).
 - (b) If necessary, disassemble the hinge box assembly (170), as follows:
 - 1) Remove the cotter pin (5), nut (15), washer (10), cam plate assembly (20), and the handle assembly (60) from the housing (415).
 - 2) Remove the bolts (35), washers (40), packing (45, 50), and the housing fitting (55) from the housing (415).
 - 3) Remove pin spring (65), nut (70), spring (75), pin (80), and center shaft (85) from the sleeve (115) from the housing (415).
 - 4) Remove the bolts (90), washers (95), nuts (100), washer (105), cam (110), sleeve (115) and ring (120) from the handle (125).
 - 5) Remove the bolt (175), washer (180), and push rod assembly (185) from the door cocking crank assembly (345).
 - 6) Remove the bolt (220), washers (230, 240, 245), nut (255), and cam follower assembly (260) from the housing (415).
 - 7) Remove the bearing (300), spacer (340), and door cocking crank assembly (345) from the housing (415).
 - 8) Remove the bolt (220), washers (230, 240, 245), nut (255), and cam follower assembly (260) from the housing (415).
 - 9) Remove the bearing (300), spacer (315), and door latching crank assembly (320) from the housing (415).
 - 10) Remove bolts (210, 215), washers (225, 235), nuts (250), bearing retainers (295), and bearings (305) from the housing (415).
 - 11) Remove the ring (290) and bearings (310, 365) from the housing (415).
 - 12) Remove the cotter pins (265), nuts (275), washers (270), and bearings (280) from the crank arms (285).
- (13) Remove the upper and lower support assembly (IPL Figure 5, 45, 50) from the door structure.
 - (a) Remove the upper support assembly (IPL Figure 5, 45) as follows:
 - 1) Remove the bolts (25, 30), washers (35), nuts (40), and the upper support assembly (45) from the door structure.
 - 2) Remove the bolts (55), washers (60), and the attach fitting (75) from the support (115).
 - (b) Remove the lower support assembly (IPL Figure 5, 50), as follows:
 - 1) Remove the bolts (25, 30), washers (35), nuts (40), and the lower support assembly (50) from the door structure.
 - 2) Remove the bolts (55), washers (60), and the attach fitting (75) from the support (120).
- (14) Remove the window assembly (IPL Figure 6, 15, 100) from the door structure, as follows:
 - (a) Remove the screws (5), washers (10), and the window assembly (15, 100) from the door structure.
- (15) Remove the guide fitting assembly (IPL Figure 7, 15) and channel assembly (60) from the door structure, as follows:

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- (a) Remove the bolts (5), washers (10), and the guide fitting assembly (15) from the door structure.
 - (b) Remove the bolts (50), collars (55), and the channel assembly (60) from the door structure.
- (16) If necessary, remove the plate (IPL Figure 1, 85) and marker (90) from the door structure.

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CLEANING

1. General

- A. This procedure has the data necessary to clean the forward entry door assembly.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 8, IPL Figure 12, IPL Figure 13, IPL Figure 14 and IPL Figure 15 for item numbers.

2. Cleaning

A. References

| Reference | Title |
|---------------|-------------------------------------|
| SOPM 20-30-01 | CLEANING AND RELUBRICATING BEARINGS |
| SOPM 20-30-03 | GENERAL CLEANING PROCEDURES |

B. Procedure

- (1) Clean the bearings (IPL Figure 8, 55, 115), (IPL Figure 12, 280, 300, 305, 310, 365), (IPL Figure 13, 55), (IPL Figure 14, 70, 75, 150, 155), (IPL Figure 15, 70, 75, 150, 155) as specified in SOPM 20-30-01.
- (2) Use standard industry procedures and refer to SOPM 20-30-03 to clean all other parts.

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CLEANING

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COMPONENT MAINTENANCE MANUAL

CHECK

1. General

- A. This procedure has the data necessary to find defects in the material of the specified parts.
- B. Refer to FITS AND CLEARANCES for the design dimension 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 - IPL Figure 16 for item numbers.

2. Check

A. References

| Reference | Title |
|---------------|---------------------------------|
| 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 damage or if you suspect possible damage on the parts listed below:

(a) Do a magnetic particle check (SOPM 20-20-01) of these parts:

- 1) IPL Figure 5
 - a) Attach fitting (75)
- 2) IPL Figure 7
 - a) Ball (30)
- 3) IPL Figure 11
 - a) Hinge pin (130)
 - b) Hinge arm (185, 190)
 - c) Sleeve (195)
 - d) Crank (200)
 - e) Torque tube (205)
- 4) IPL Figure 12
 - a) Housing fitting (55)
 - b) Spring (75)
 - c) Center shaft (85)
 - d) Crank arm (285)
- 5) IPL Figure 13
 - a) Bell crank (65, 70, 75)
 - b) Tube (80)

(b) Do a penetrant check (SOPM 20-20-02) of these parts:

- 1) IPL Figure 2

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- a) Beam (35, 40, 200, 255, 310, 400, 495, 540, 595, 650, 695)
 - b) Stop fitting (60, 65, 195, 245, 250, 300, 305, 390, 395, 485, 490, 535, 585, 590, 640, 645, 685, 690)
 - c) Angle (350, 440)
 - 2) IPL Figure 3
 - a) Gate (115)
 - 3) IPL Figure 4
 - a) Gate (95)
 - 4) IPL Figure 5
 - a) Intercostal (130, 135, 140, 145)
 - 5) IPL Figure 6
 - a) Frame (95)
 - 6) IPL Figure 7
 - a) Fitting (35)
 - 7) IPL Figure 8
 - a) Fitting (60, 65, 70, 75)
 - b) Housing (120)
 - 8) IPL Figure 12
 - a) Plate (30)
 - b) Pin (80)
 - c) Sleeve (115)
 - d) Crank arm (335, 360)
 - e) Housing (415)
 - 9) IPL Figure 13
 - a) Latching crank (60)
 - 10) IPL Figure 14
 - a) Rod (160, 165)
 - 11) IPL Figure 15
 - a) Rod (160, 165)
 - 12) IPL Figure 16
 - a) Bracket (30)
 - b) Fitting (115, 135)
- (2) Use standard industry procedures to do a visual check of the springs (IPL Figure 9, 95, 100) for defects. Do the dimension check of the springs if the visual check shows possible damage or if you suspect possible damage.
- a) Check that the dimension of springs (95, 100) is as shown in CHECK, Figure 501.

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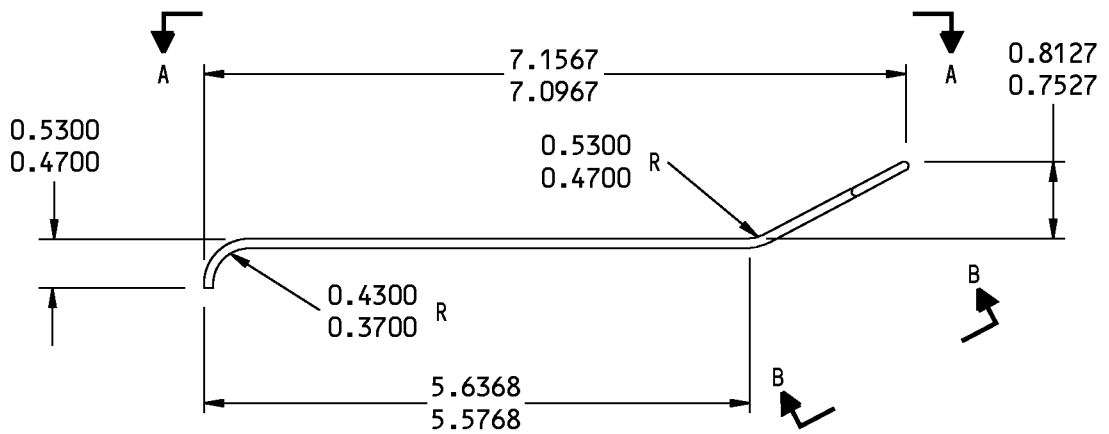
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- (3) Use standard industry procedures to do a visual check of the springs (IPL Figure 12, 75) for defects. Do the load check of the springs if the visual check shows possible damage or if you suspect possible damage on springs (IPL Figure 12, 75).
 - (a) Compress spring (75) to 2.05 inches length as shown in CHECK, Figure 502.
 - 1) Check that the maximum load on spring (75) is 5.8-7.0 pounds.
 - (b) Compress spring (75) to 3.34 inch length as shown in CHECK, Figure 502.
 - 1) Check that the minimum load on spring (75) is 3.0-3.8 pounds.

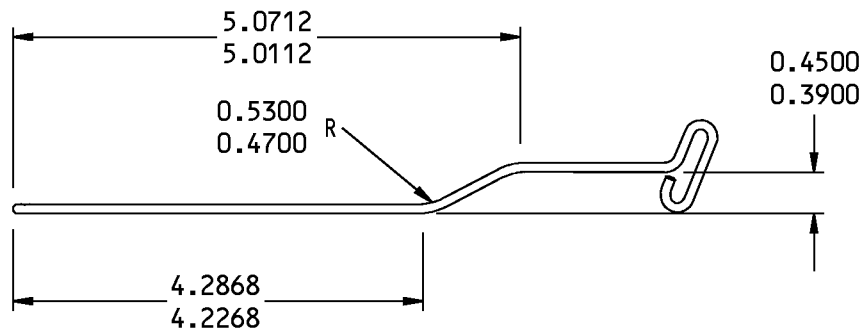
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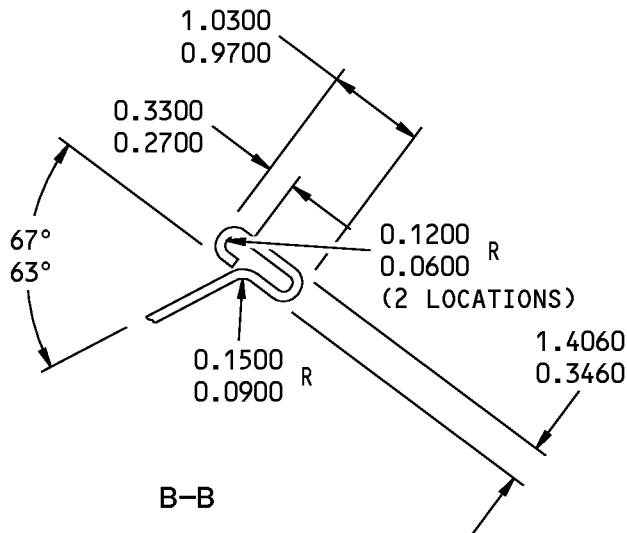
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141A6243-1 (100) SHOWN
141A6243-2 (95) OPPOSITE



A-A



B-B

ALL DIMENSIONS ARE IN INCHES

ITEM NUMBERS REFER TO IPL FIG. 9

H02644 S00041000476_V2

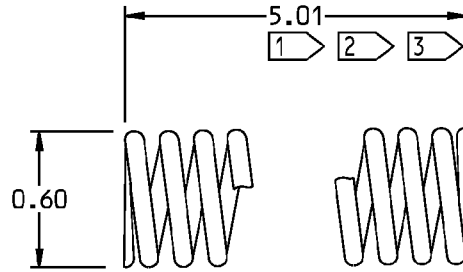
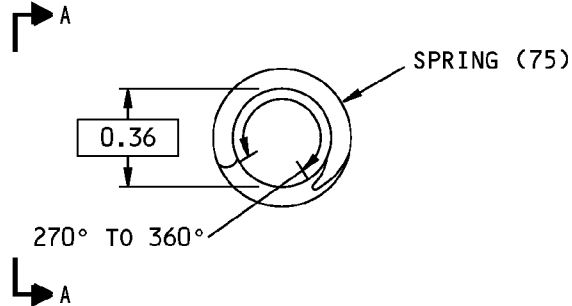
141A6243-1,-2 Cantilever Spring Check
Figure 501

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A-A

- 1 MAXIMUM CHECK LOAD IS 5.8-7.0 POUNDS AT 2.05 INCH LENGTH
- 2 MINIMUM CHECK LOAD IS 3.0-3.8 POUNDS AT 3.34 INCH LENGTH
- 3 TOTAL NUMBER OF COILS IS 28

ALL DIMENSIONS ARE IN INCHES
ITEM NUMBERS REFER TO IPL FIG. 12

63-2848 Spring Check
Figure 502

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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 |
| 141A6103 | STOP FITTING ASSEMBLY | 2-1, 2-2 |
| 141A6104 | STOP FITTING ASSEMBLY | 3-1, 3-2 |
| 141A6171 | UPPER GATE ASSEMBLY | 4-1, 4-2 |
| 141A6181 | LOWER GATE ASSEMBLY | 5-1, 5-2 |
| 141A6221 | SUPPORT FITTING ASSEMBLY | 6-1, 6-2 |
| 141A6310 | CAM PLATE ASSEMBLY | 7-1, 7-2 |
| 141A6304 | HOUSING ASSEMBLY | 8-1, 9-2 |
| 141A6306 | CAM FOLLOWER CRANK ASSY | 9-1, 9-2 |
| 141A6321, 141A6322 | TORQUE TUBE ASSEMBLY | 10-1 |
| 141A6323 | LATCHING CRANK | 10-2 |
| 60-4406 | TUBE | 10-3 |
| 141A6331 | STOP ROD ASSEMBLY | 11-1 |
| 66-2620 | STOP ROD | 11-2 |
| 65-28925 | CONTROL ROD ASSEMBLY | 12-1, 12-2 |
| 60-4455 | CENTER SHAFT | 13-1 |
| 65-2306 | HOUSING ASSEMBLY | 14-1, 14-2 |
| 65-25838 | SUPPORT ASSEMBLY | 15-1 |
| 69-22323 | SUPPORT ASSEMBLY | 16-1 |
| 69-61511 | HOUSING FITTING | 17-1 |
| 69-7208 | PUSHROD ASSY | 18-1 |

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
- ▭ 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)

- ∅ DIAMETER
- S ∅ SPHERICAL DIAMETER
- R RADIUS
- SR SPHERICAL RADIUS
- () REFERENCE
- BASIC A THEORETICALLY EXACT DIMENSION USED TO DESCRIBE SIZE, SHAPE OR LOCATION OF A FEATURE. FROM THIS FEATURE PERMISSIBLE VARIATIONS ARE ESTABLISHED BY TOLERANCES ON OTHER DIMENSIONS OR NOTES.
- DIM**
- A-** DATUM
- (M) MAXIMUM MATERIAL CONDITION (MMC)
- (L) LEAST MATERIAL CONDITION (LMC)
- (S) REGARDLESS OF FEATURE SIZE (RFS)
- (P) PROJECTED TOLERANCE ZONE
- FIM FULL INDICATOR MOVEMENT

EXAMPLES

— 0.002 STRAIGHT WITHIN 0.002

⊥ 0.002 B PERPENDICULAR TO DATUM B WITHIN 0.002

// 0.002 A PARALLEL TO DATUM 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 A

⌓ 0.020 A SURFACES MUST LIE WITHIN PARALLEL BOUNDARIES 0.020 INCH APART AND EQUALLY DISPOSED ABOUT TRUE PROFILE

◎ ∅ 0.0005 C CONCENTRIC TO DATUM C WITHIN 0.0005 DIAMETER

≡ 0.010 A SYMMETRICAL WITH DATUM A WITHIN 0.010

∠ 0.005 A ANGULAR TOLERANCE 0.005 WITH DATUM A

⊕ ∅ 0.002 (S) B LOCATED AT TRUE POSITION WITHIN 0.002 DIA RELATIVE TO DATUM B, REGARDLESS OF FEATURE SIZE

⊥ ∅ 0.010 (M) A AXIS IS TOTALLY WITHIN A CYLINDER OF 0.010 INCH DIAMETER, PERPENDICULAR TO DATUM A, AND EXTENDING 0.510 INCH ABOVE DATUM A, MAXIMUM MATERIAL CONDITION

0.510 (P)

2.000 THEORETICALLY EXACT DIMENSION IS 2.000
OR
2.000
BSC

True Position Dimensioning Symbols
Figure 601



COMPONENT MAINTENANCE MANUAL

REFINISH OF OTHER PARTS - REPAIR 1-1

1. General

- A. This procedure tells how to refinish the parts which are not given in the specified repairs.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 1 - IPL Figure 17 for the 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) |
| C00259 | Primer - Chemical And Solvent Resistant Finish, Epoxy Resin | BMS10-11, Type I |
| C00260 | Coating - Chemical And Solvent Resistant Finish, Epoxy Resin Enamel | BMS10-11, Type II |
| C50033 | Chromated Conversion Coating for Aluminum - Alodine 1200 | |
| C50111 | Coating - Exterior Protective Enamel, White Gloss | BMS10-60 Type II |
| 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 |

C. Procedure

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

- (1) Instructions for the repair of the parts identified in REPAIR 1-1, Table 601 is for repair of the initial finish.

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Table 601: Refinish Details

| IPL FIG. & ITEM | MATERIAL | FINISH |
|---|---------------|--|
| IPL Fig. 2 | | |
| Beam (35, 40, 200, 240, 255, 310, 315, 400, 405, 495, 540, 595, 650, 695) | Al alloy | Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-29.03). |
| Angle (105, 110, 115) | Al alloy | Chemical treat (F-17.07) all surfaces with coating, C00064. Apply primer, C00259 (F-20.03). |
| Angle (350, 440) | Al alloy | Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.03). |
| Bracket (697) | Al alloy | Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02). |
| Frame (700, 705) | Al alloy | Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.03). |
| IPL Fig. 3 | | |
| Filler (50, 55) | Al alloy | Boric acid sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.03). |
| Hinge half (80, 85) | Al alloy | Boric acid sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.03). Apply enamel coating, C00260 (F-21.03-702) but do not put primer, C00259 and enamel coating, C00260 in the hole for the pin. |
| IPL Fig. 4 | | |
| Hinge half (55, 60) | Al alloy | Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.03). Apply enamel coating, C00260 (F-21.02-702) but do not put primer, C00259 and enamel coating, C00260 in the holes for the pin. |
| IPL Fig. 5 | | |
| Angle (15, 20) | Al alloy | Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.03). |
| Attach fitting (75) | Steel alloy | Cadmium plate and apply primer, C00259 (F-16.02). |
| Support (115, 120) | Al alloy | Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.03). |
| Intercostal (130, 135, 140, 145) | Al alloy | Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.03). |
| IPL Fig. 6 | | |
| Clip (35, 135) | Steel alloy | Cadmium plate (F-15.06). Apply primer, C00259 (F-20.02). Apply enamel coating, C00260 (SRF-14.905-702). |
| Seal (50) | Sponge rubber | No finish (F-7.10). |
| Seal (55, 120, 125) | Rubber | No finish (F-25.01). |

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REPAIR 1-1

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Table 601: Refinish Details (Continued)

| IPL FIG. & ITEM | MATERIAL | FINISH |
|--|----------------------------------|--|
| Pane (60, 65) | Acrylic | No finish (F-6.10). |
| Retainer (70) | Al alloy | Chemical treat (F-17.07) and apply primer, C00259. Apply coating, C00033, color 702 (F-19.39-702) as specified in REPAIR 1-1, Figure 603 |
| Frame (95) | Al alloy | Boric acid-sulfuric acid anodize (F-17.29). Apply primer, C00259 (F-20.03) but not on the surfaces identified by flagnote 1 in REPAIR 1-1, Figure 601. |
| Retainer (130) | Al alloy | Chemical treat (F-17.07). Apply primer, C00259 (F-20.03). Apply enamel coating, C50111 (F-19.39-702). |
| Pane (140, 145) | Acrylic | Apply Pilkington Aerospace Inc. (PAI) SS-6782 acrylic hard coating (F-30.019) to the inner and outer surfaces (edges optional). |
| IPL Fig. 7 | | |
| Ball (30) | 15-5 PH CRES, 150- 170 ksi | Passivate (F-17.25). Cadmium plate (F-15.06). |
| Fitting (35) | Al alloy | Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.03). Apply enamel coating, C00260(F-21.02-702) but do not put primer, C00259 and enamel coating, C00260 in close tolerance hole and 0.3130-0.3170 inch diameter hole. |
| Channel (85) | Al alloy | Chemical treat (F-17.07). Apply primer, C00259 (F-20.03). |
| IPL Fig. 8 | | |
| Retainer (100) | Al alloy | Chemical treat (F-17.07). Apply primer, C00259 (F-20.03). |
| IPL Fig. 9 | | |
| Retainers (30 thru 45, 105 thru 120, 135 thru 150) | Al alloy | Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.03). Apply enamel coating, C00260(F-21.03). |
| Locators (50 thru 65) | Al alloy | Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.03). |
| IPL Fig. 10 | | |
| Access panels (75, 80, 120, 125) | Al alloy | Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.03). |
| Shockmount (140) | Al alloy | Chemical treat (F-17.10). Apply primer, C00259 (F-20.02). |
| Cover (170) | Al alloy | Chemical treat (F-17.07). Apply primer, C00259 (F-20.03). |
| IPL Fig. 11 | | |
| Hinge half (50 thru 65) | Al alloy | Chemical treat and apply primer, C00259 (F-18.06) but no primer, C00259 in the holes for the pin. |
| Filler (180) | Al alloy | Chromic acid anodize and apply primer, C00259 (F-18.13). |

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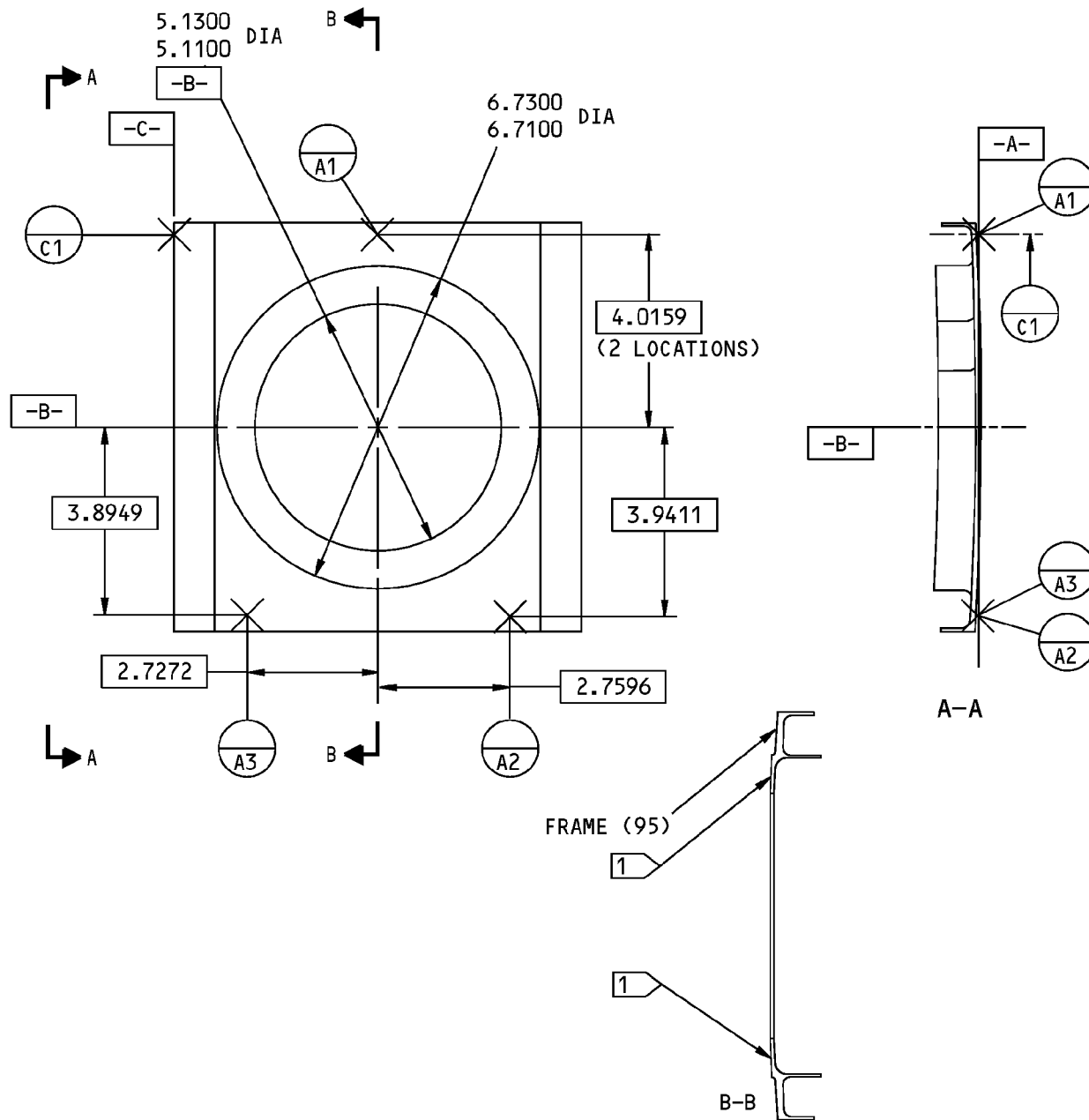
Table 601: Refinish Details (Continued)

| IPL FIG. & ITEM | MATERIAL | FINISH |
|----------------------|---------------------------------|---|
| Hinge (185, 190) | 15-5PH CRES, 180- 200 ksi | Cadmium plate and apply primer, C00259 (F-16.02) but not on the surfaces identified by flagnotes 1 and 2 in REPAIR 1-1, Figure 602. |
| Sleeve (195) | 15-5PH CRES, 180- 200 ksi | Passivate (F-17.25). |
| Crank (200) | 15-5PH CRES, 150- 170 ksi | Passivate (F-17.25). |
| Torque tube (205) | 15-5PH CRES, 180- 200 ksi | Passivate (F-17.25). |
| IPL Fig. 12 | | |
| Cam (110) | Al-Bronze | Cadmium plate (F-4.201). |
| Sleeve (115) | Al-Ni- Bronze | Apply lubricant, D00113 (F-19.10). |
| Washer (245) | Al alloy | Cadmium plate (F-15.06). Apply primer, C00259 (F-20.02). |
| Spacer (315, 340) | Al alloy | Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.03). |
| Crank arm (335, 360) | Al alloy | Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.35). Apply primer, C00259 (F-20.03). |
| IPL Fig. 13 | | |
| Bellcrank (65, 70) | 15-5PH CRES, 150- 170 ksi | Passivate (F-17.09). |
| Bellcrank (75) | Steel alloy, 125-145 ksi | Cadmium plate and apply primer, C00259 (F-16.03). |
| IPL Fig. 16 | | |
| Bracket (30, 180) | Al alloy | Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.03). |
| Shockmount (60) | Al alloy | Apply chromate primer on baseplate edges exposed after trimming or manually apply Alodine 1200 coating, C50033 on baseplate edges exposed after trimming. |
| IPL Fig. 17 | | |
| Seal Plate (10) | Al alloy | Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.03). |
| Handle Pan (15) | Al alloy | Chemical treat (F-17.07). Apply primer, C00259 (F-20.03). Apply no finish (F-25.01) to exterior surface. |

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1 DECORATIVE SURFACE NO PRIMER
OVERSPRAY ALLOWED HERE

125 ✓ ALL MACHINED SURFACES UNLESS
SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 6

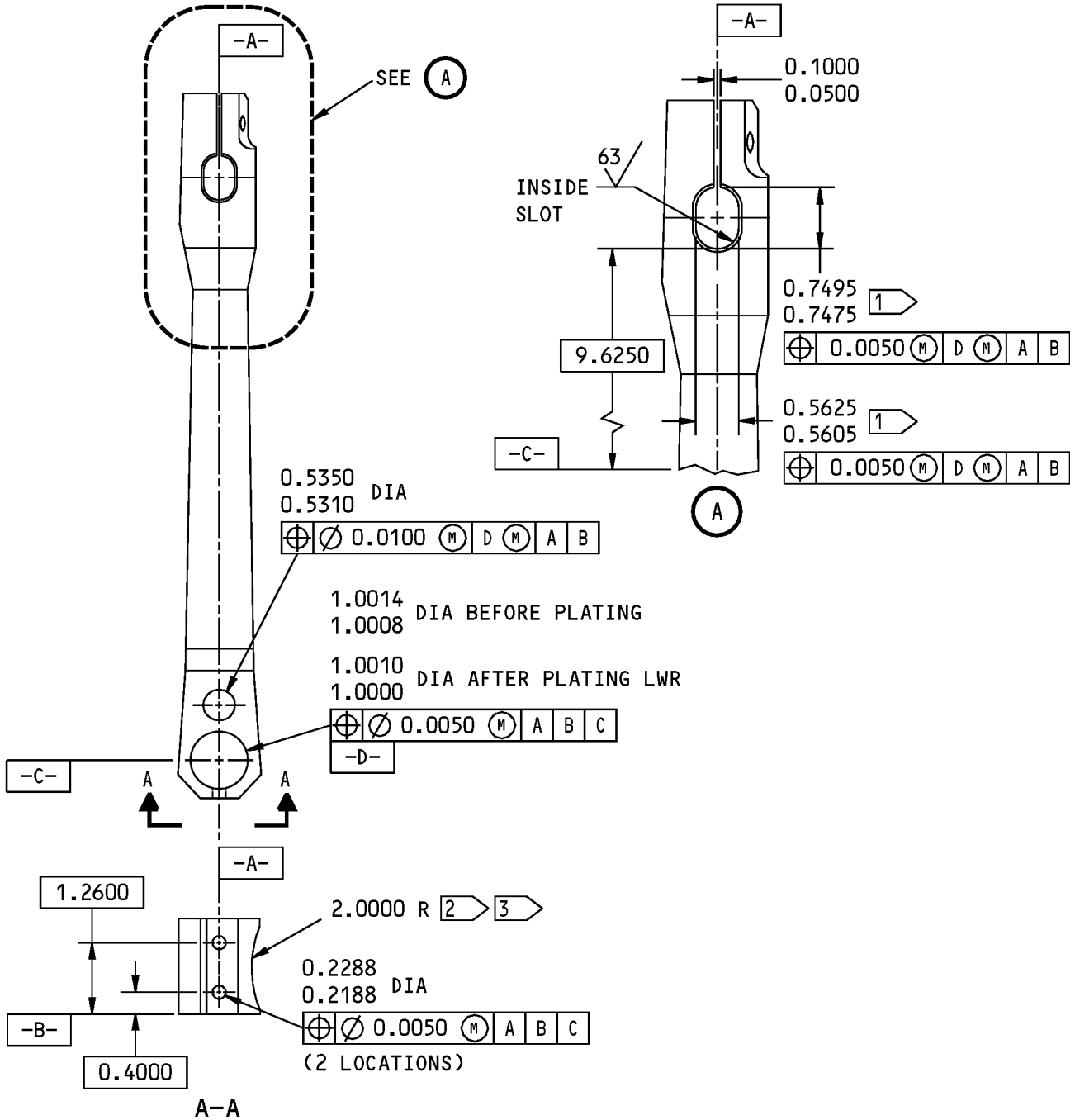
ALL DIMENSIONS ARE IN INCHES

141A6201-2 Window Frame Repair
Figure 601

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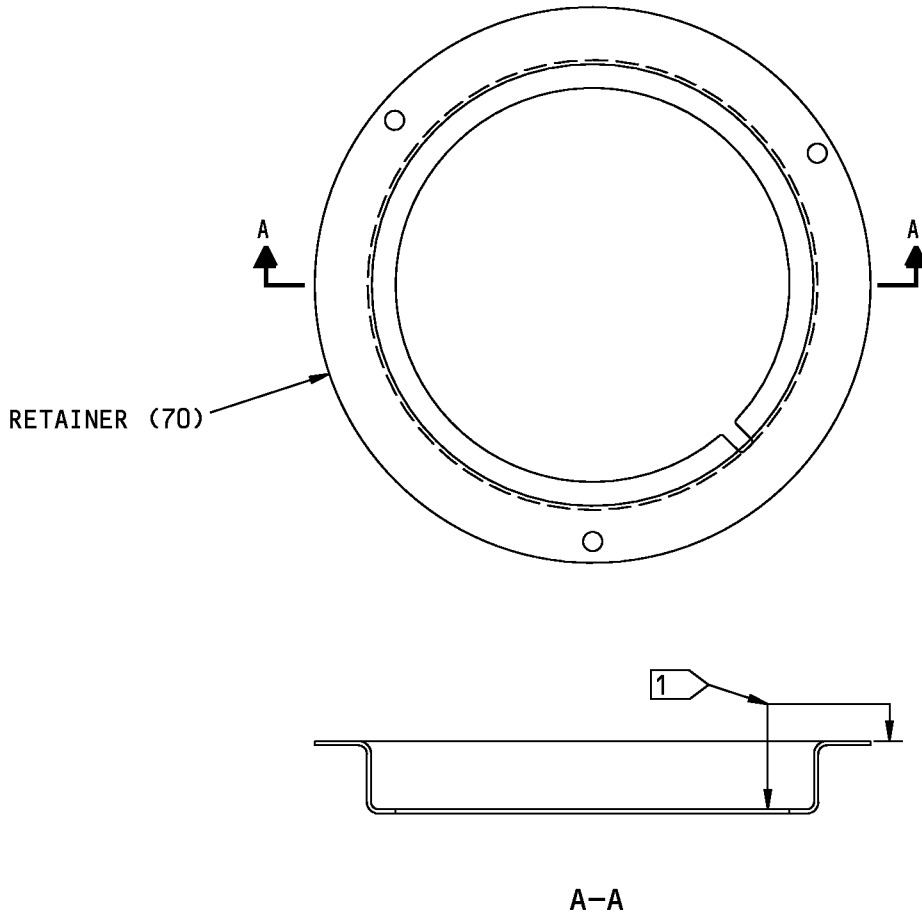


- 1 NO CADMIUM PLATE ON THIS AREA
- 2 DO NOT APPLY PAINT AND PRIMER IN THIS AREA
- 3 141A6274-3; 65-86784-16

141A6274-1,-3; 65-86784-12,-16 Hinge Arm Refinish
Figure 602

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1 APPLY BMS 10-60 ENAMEL, COLOR 702 (F-19.39-702), OVERSPRAY PERMITTED

ITEM NUMBERS REFER TO IPL FIG. 6
1555025 S0000285141_V1

69-1983-7 Window Retainer Refinish
Figure 603

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STOP FITTING ASSEMBLY - REPAIR 2-1

141A6103-1, -3, -5, -7, -9, -11, -13, -15, -17, -19, -23, -25, -27

1. General

- A. This procedure has the data necessary to repair the stop fitting assembly (45, 50, 230, 235, 285, 290, 375, 380, 470, 475, 525, 570, 575, 625, 630).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 shown in the repair.
- D. Refer to IPL Figure 2 for item numbers.

2. Bushing Replacement

- 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. Procedure (REPAIR 2-1, Figure 601 thru REPAIR 2-1, Figure 603)

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

- (1) Remove the bushings (55, 240, 295, 385, 480, 530, 580, 635) from the fittings (60, 65, 245, 250, 300, 300A, 305, 390, 395, 485, 490, 495, 535, 585, 590, 640, 645).
- (2) Install the new bushings (55, 240, 295, 385, 480, 530, 580, 675) into the fittings (60, 65, 245, 250, 300, 300A, 305, 390, 395, 485, 490, 495, 535, 585, 590, 640, 645) with sealant, A00247 by roller swage procedure as specified in SOPM 20-50-03.

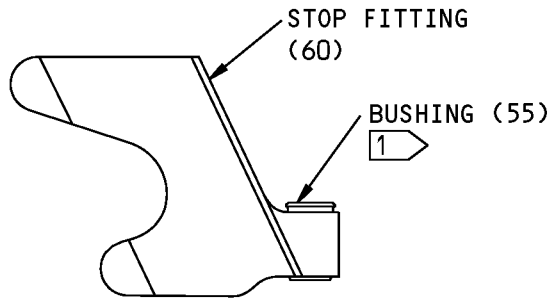
52-16-12

REPAIR 2-1

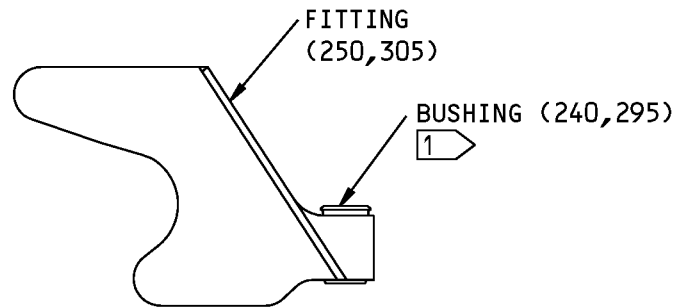
Page 601

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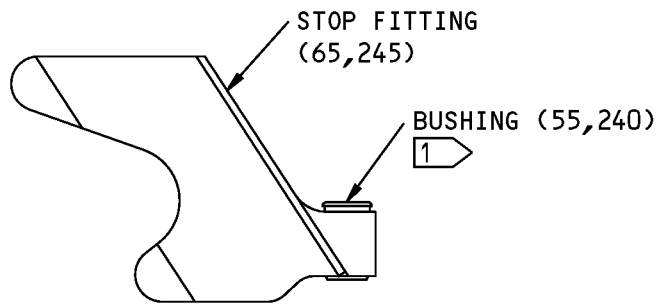
COMPONENT MAINTENANCE MANUAL



FORWARD FITTING ASSEMBLY (45)



STOP FITTING ASSEMBLY (235,290)



AFT FITTING ASSEMBLY (50,230)

1 INSTALL AND ROLLER SWAGE THIS BUSHING WITH WET BMS 5-95 SEALANT AS SPECIFIED IN SOPM 20-50-03

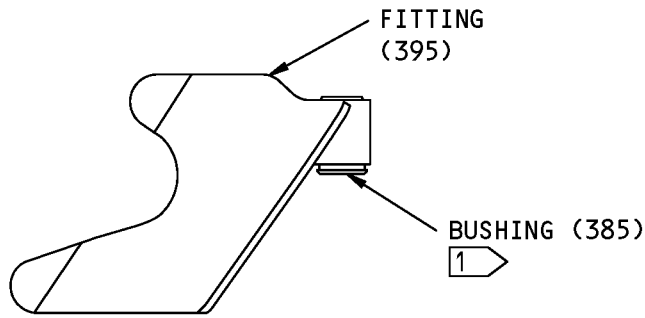
ITEM NUMBERS REFER TO IPL FIG. 2

141A6103-1,-3,-11 Stop Fitting Assembly Repair
Figure 601

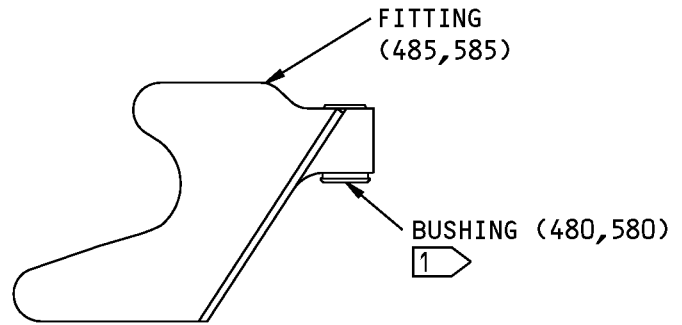
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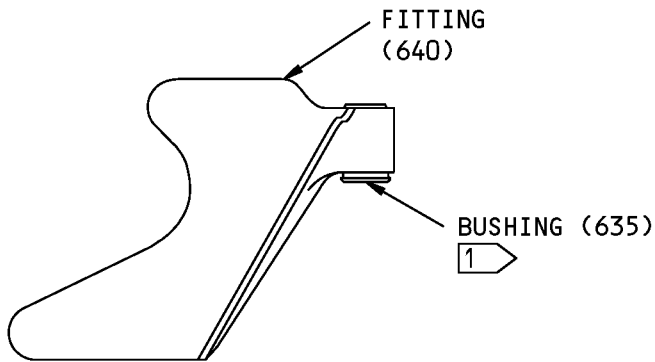
COMPONENT MAINTENANCE MANUAL



STOP FITTING ASSEMBLY (380)



STOP FITTING ASSEMBLY (470,570)



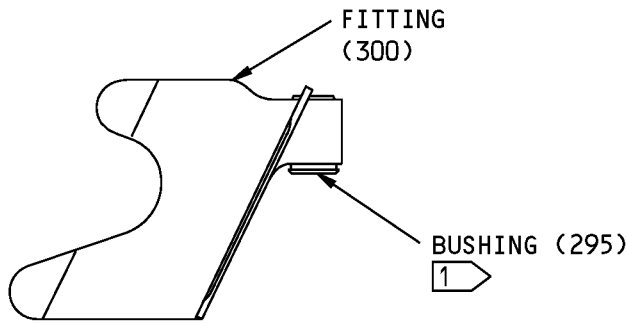
STOP FITTING ASSEMBLY (625)

141A6103-5,-7,-9,-13,-19,-25 Stop Fitting Assembly Repair
Figure 602 (Sheet 1 of 2)

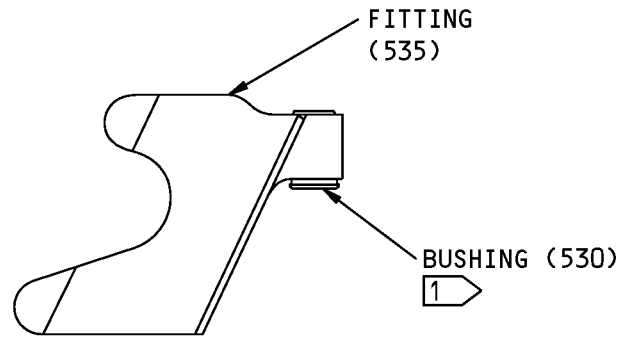
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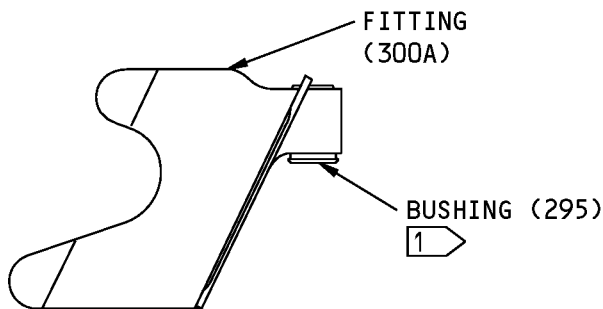
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STOP FITTING ASSEMBLY (285)



STOP FITTING ASSEMBLY (525)



STOP FITTING ASSEMBLY (285A)

1 INSTALL AND ROLLER SWAGE THIS BUSHING WITH WET BMS 5-95 SEALANT AS SPECIFIED IN SOPM 20-50-03

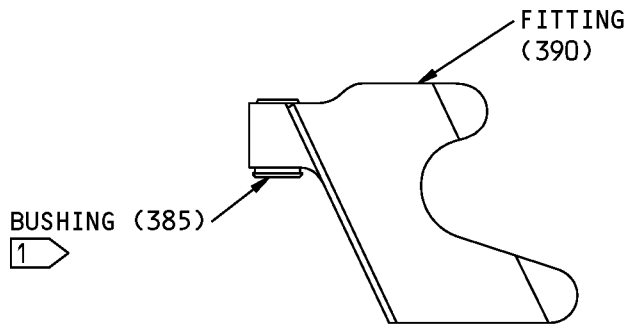
ITEM NUMBERS REFER TO IPL FIG. 2

141A6103-5,-7,-9,-13,-19,-25 Stop Fitting Assembly Repair
Figure 602 (Sheet 2 of 2)

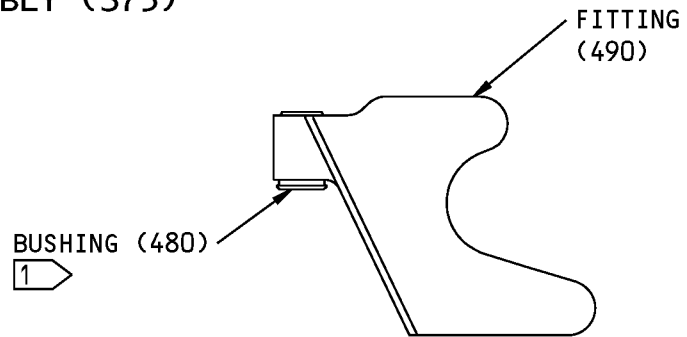
52-16-12

REPAIR 2-1
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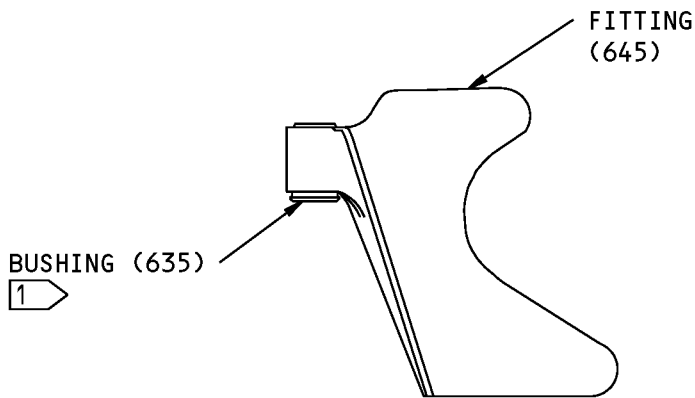
COMPONENT MAINTENANCE MANUAL



STOP FITTING ASSEMBLY (375)



STOP FITTING ASSEMBLY (475)



STOP FITTING ASSEMBLY (630)

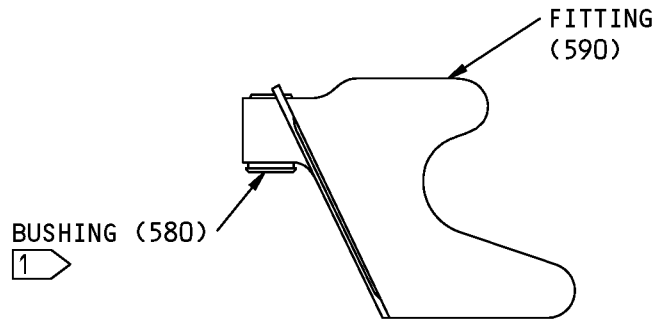
141A6103-15,-17,-23,-27 Stop Fitting Assembly Repair
Figure 603 (Sheet 1 of 2)

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REPAIR 2-1
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STOP FITTING ASSEMBLY (575)

- 1 INSTALL AND ROLLER SWAGE THIS BUSHING WITH WET BMS 5-95 SEALANT AS SPECIFIED IN SOPM 20-50-03

ITEM NUMBERS REFER TO IPL FIG. 2

141A6103-15,-17,-23,-27 Stop Fitting Assembly Repair
Figure 603 (Sheet 2 of 2)

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REPAIR 2-1
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STOP FITTING - REPAIR 2-2

141A6103-2, -4, -6, -8, -10, -12, -14, -16, -18, -20, -24, -26, -28

1. General

- A. This procedure has the data necessary to refinish the stop fittings (60, 65, 245, 250, 300, 300A, 305, 390, 395, 485, 490, 535, 585, 590, 640, 645).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 shown in the repair.
- D. Refer to IPL Figure 2 for item numbers.
- E. General repair details:
 - (1) Material: Al alloy
 - (2) Shot Peen: All outside surfaces, but not the holes
 - (a) Intensity: 0.005A-0.010A
 - (b) Coverage: 1.0 automatic, 2.0 manual

2. Fitting Refinish

- 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 |

- B. References

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

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

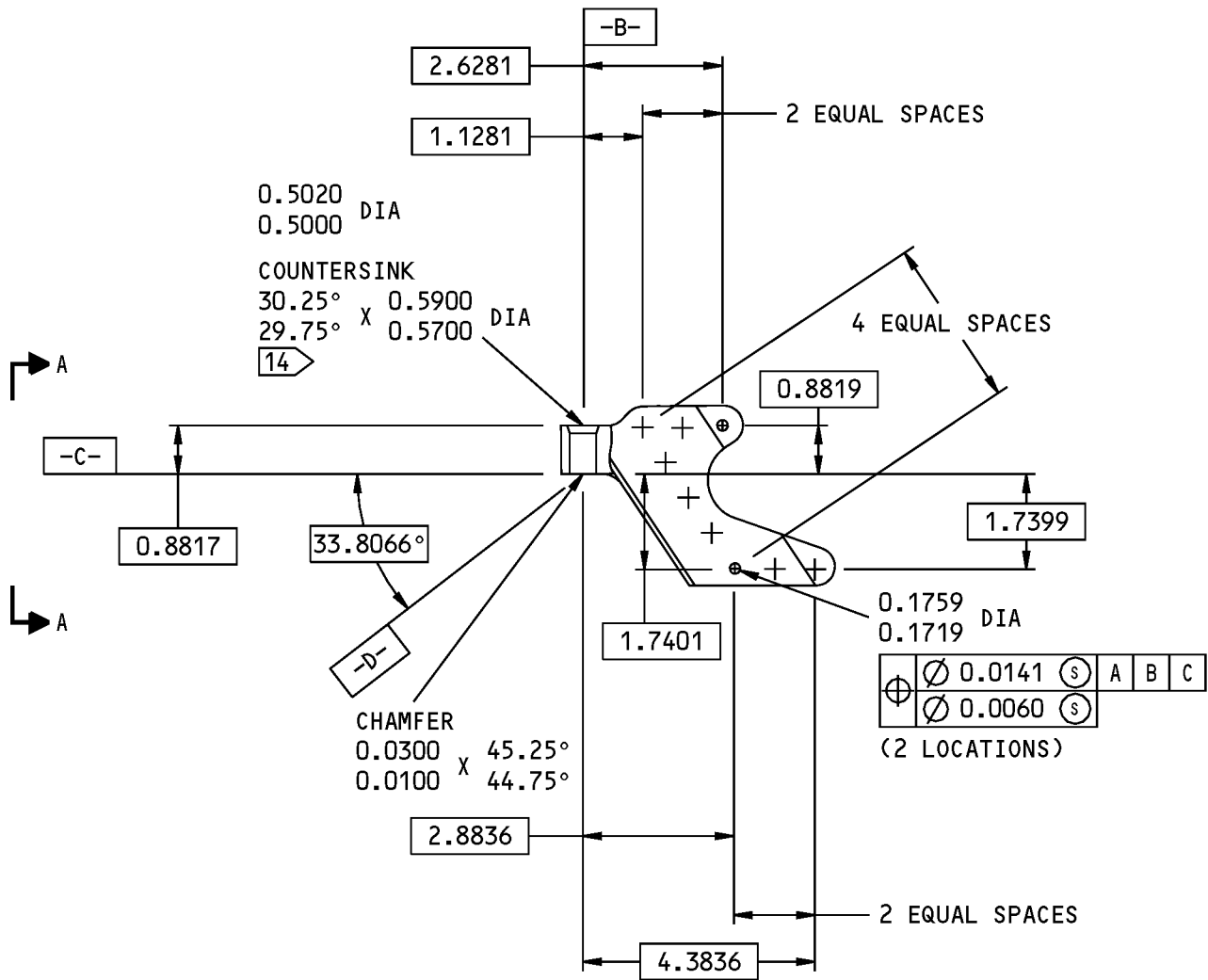
NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Prepare the surface as specified.
- (2) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31).
- (3) Apply primer, C00259 (F-20.03) to all surfaces but not the holes for the bushings.

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STOP FITTING (60) 1

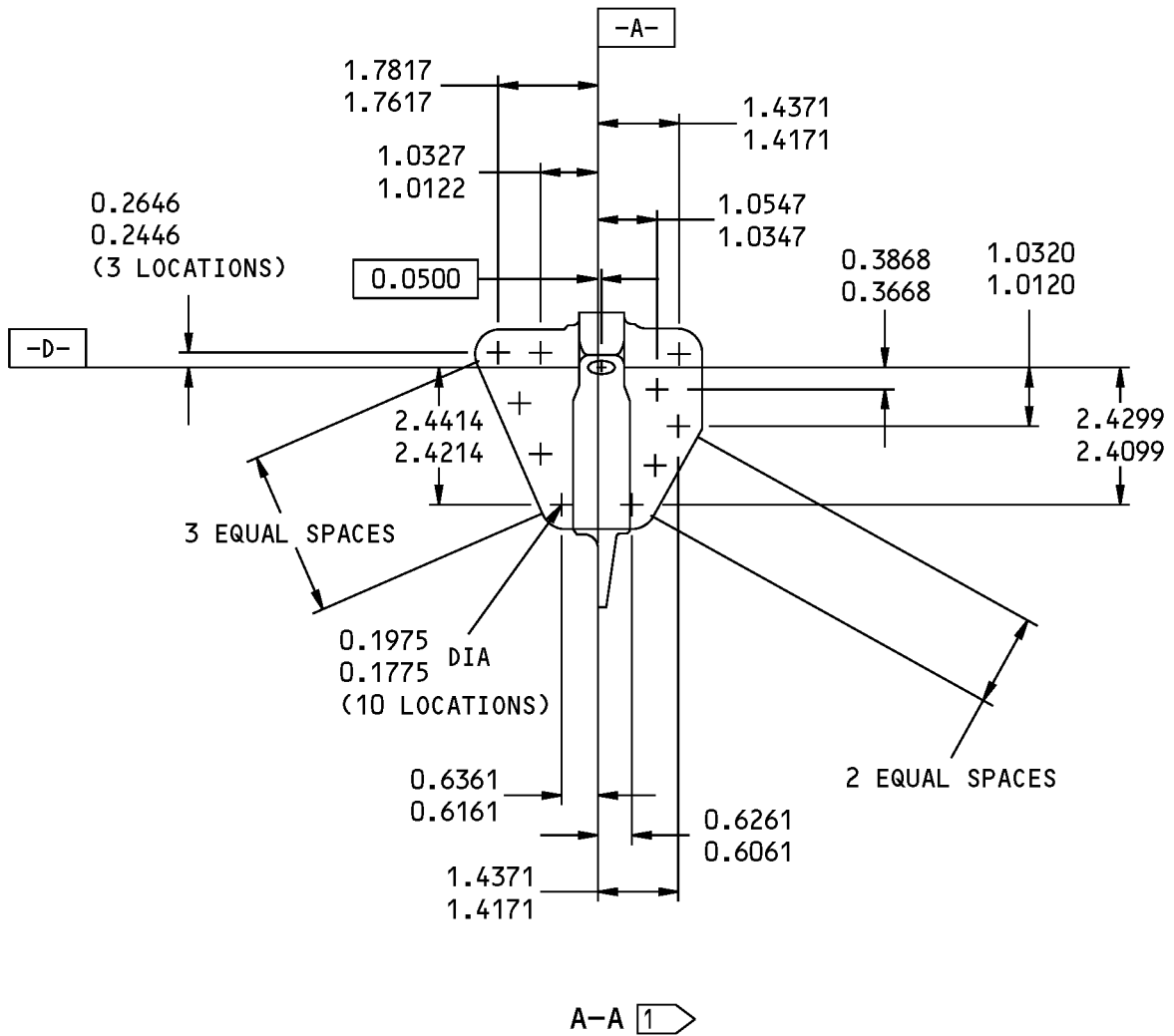
141A6103-2,-4,-6,-8,-10,-12,-14,-16,-18,-20,-24,-26,-28 Stop Fitting Repair
Figure 601 (Sheet 1 of 25)

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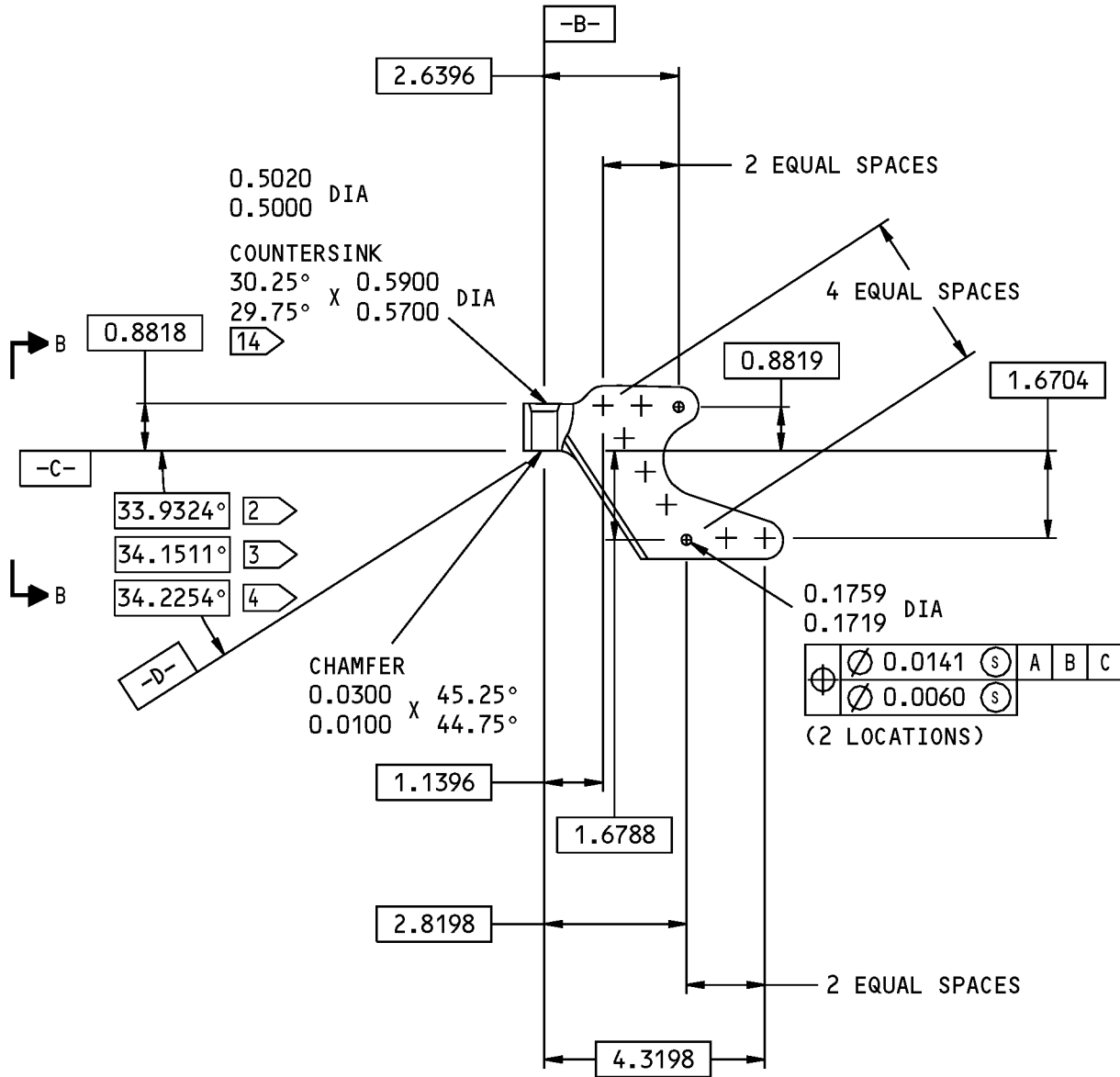


141A6103-2,-4,-6,-8,-10,-12,-14,-16,-18,-20,-24,-26,-28 Stop Fitting Repair
Figure 601 (Sheet 2 of 25)

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STOP FITTING (250,305) 2 , (395) 3 , (485,585) 4

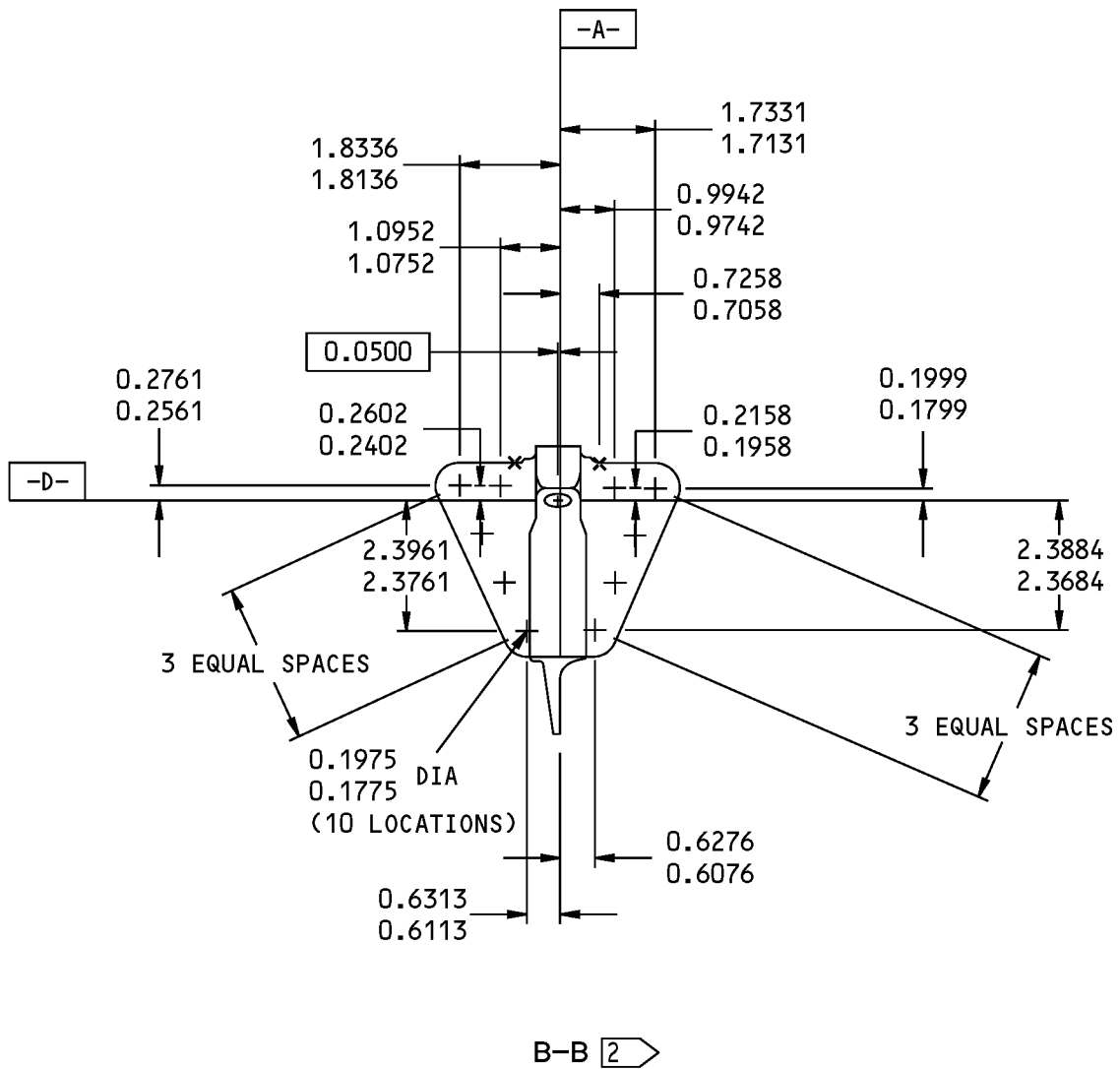
141A6103-2,-4,-6,-8,-10,-12,-14,-16,-18,-20,-24,-26,-28 Stop Fitting Repair
Figure 601 (Sheet 3 of 25)

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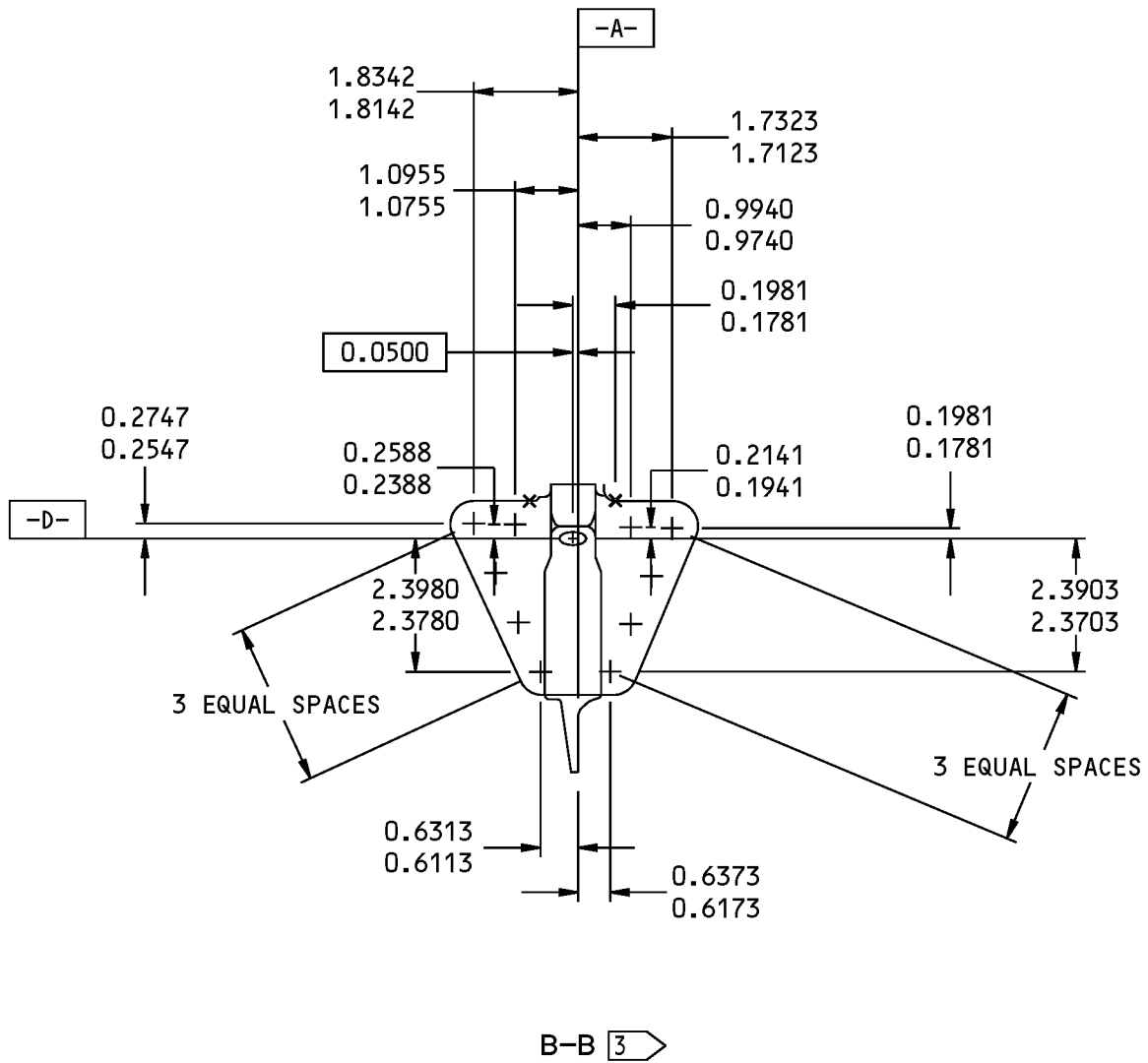
141A6103-2,-4,-6,-8,-10,-12,-14,-16,-18,-20,-24,-26,-28 Stop Fitting Repair
Figure 601 (Sheet 4 of 25)

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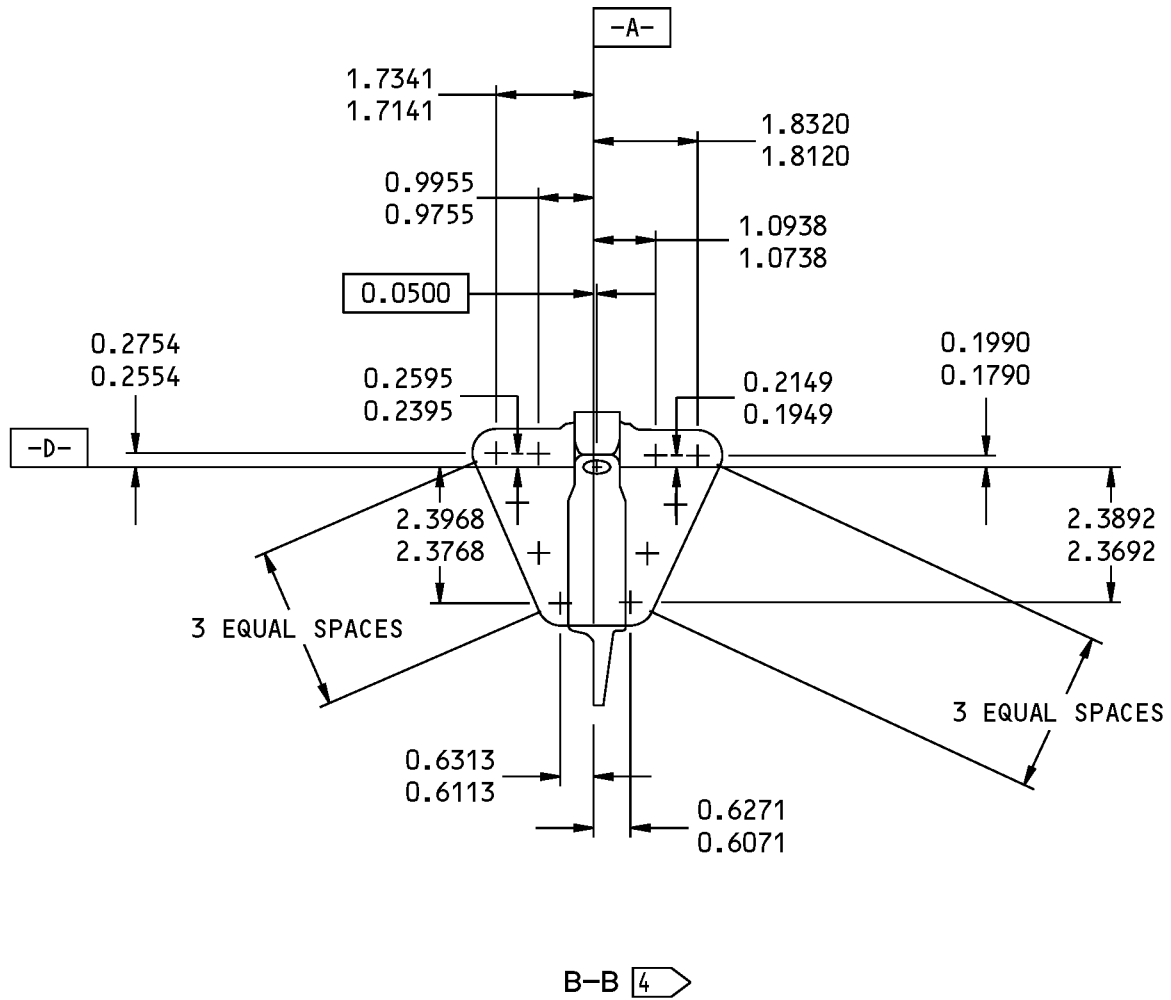
141A6103-2,-4,-6,-8,-10,-12,-14,-16,-18,-20,-24,-26,-28 Stop Fitting Repair
Figure 601 (Sheet 5 of 25)

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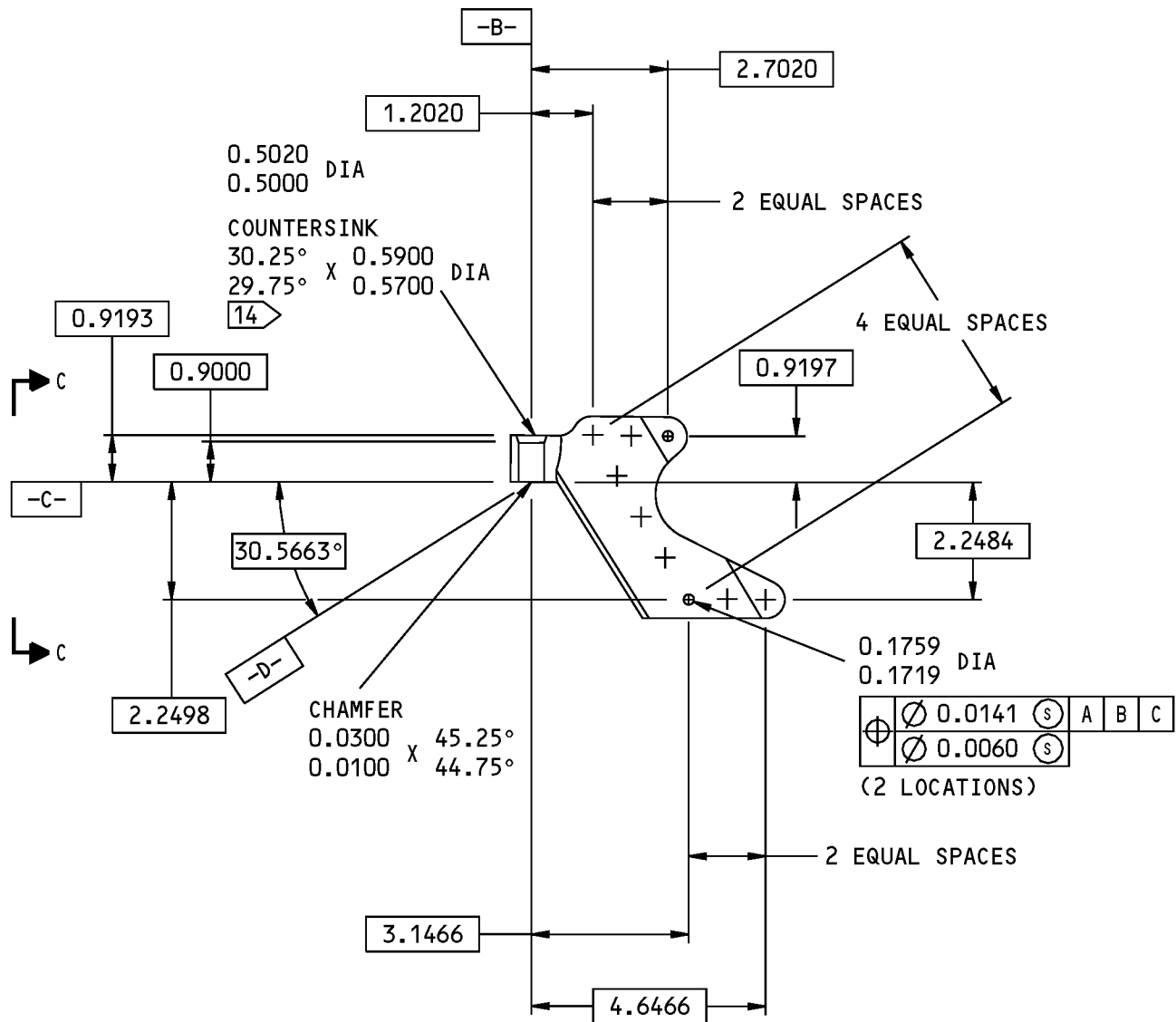


141A6103-2,-4,-6,-8,-10,-12,-14,-16,-18,-20,-24,-26,-28 Stop Fitting Repair
Figure 601 (Sheet 6 of 25)

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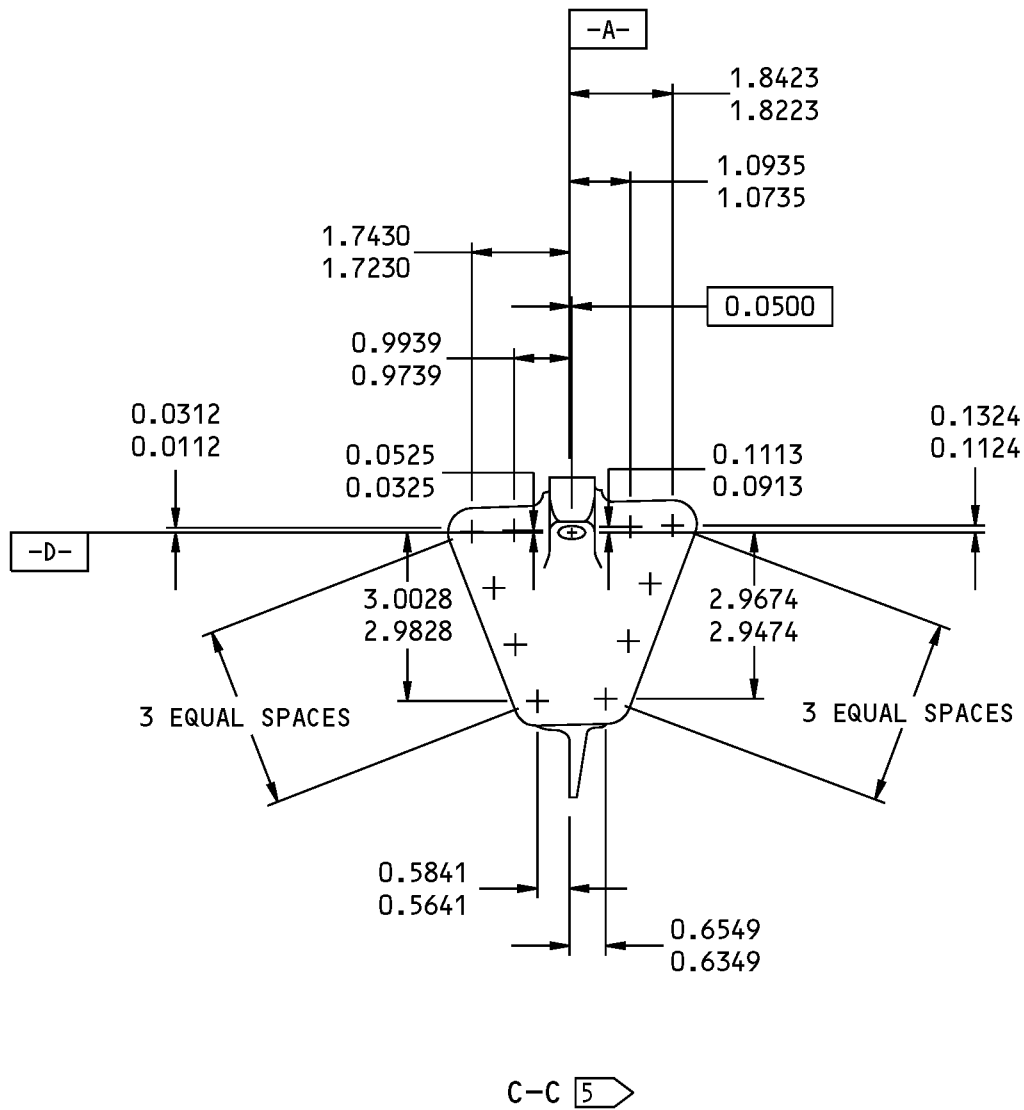
STOP FITTING (640) 5

141A6103-2,-4,-6,-8,-10,-12,-14,-16,-18,-20,-24,-26,-28 Stop Fitting Repair
Figure 601 (Sheet 7 of 25)

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141A6103-2,-4,-6,-8,-10,-12,-14,-16,-18,-20,-24,-26,-28 Stop Fitting Repair
Figure 601 (Sheet 8 of 25)

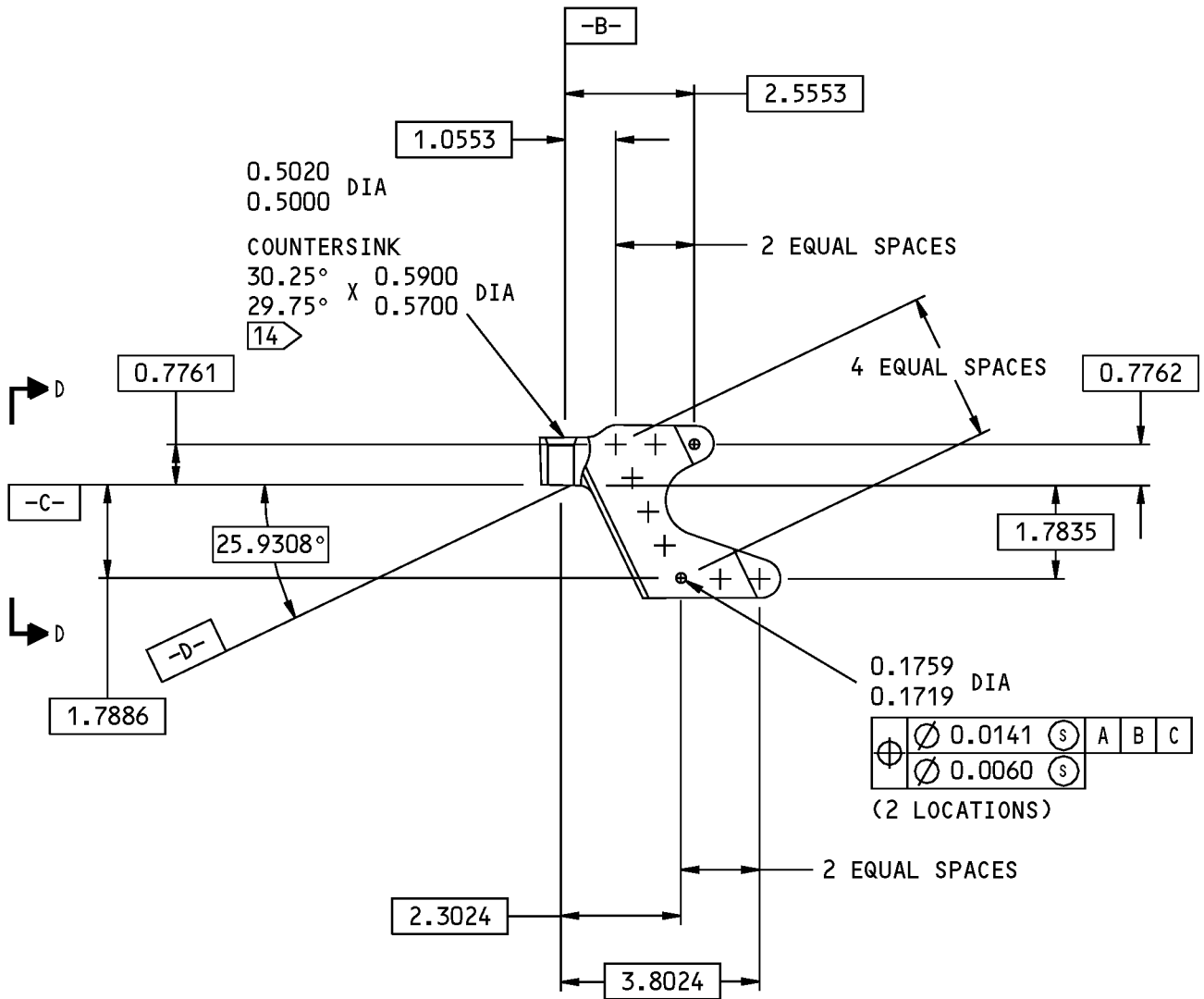
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REPAIR 2-2

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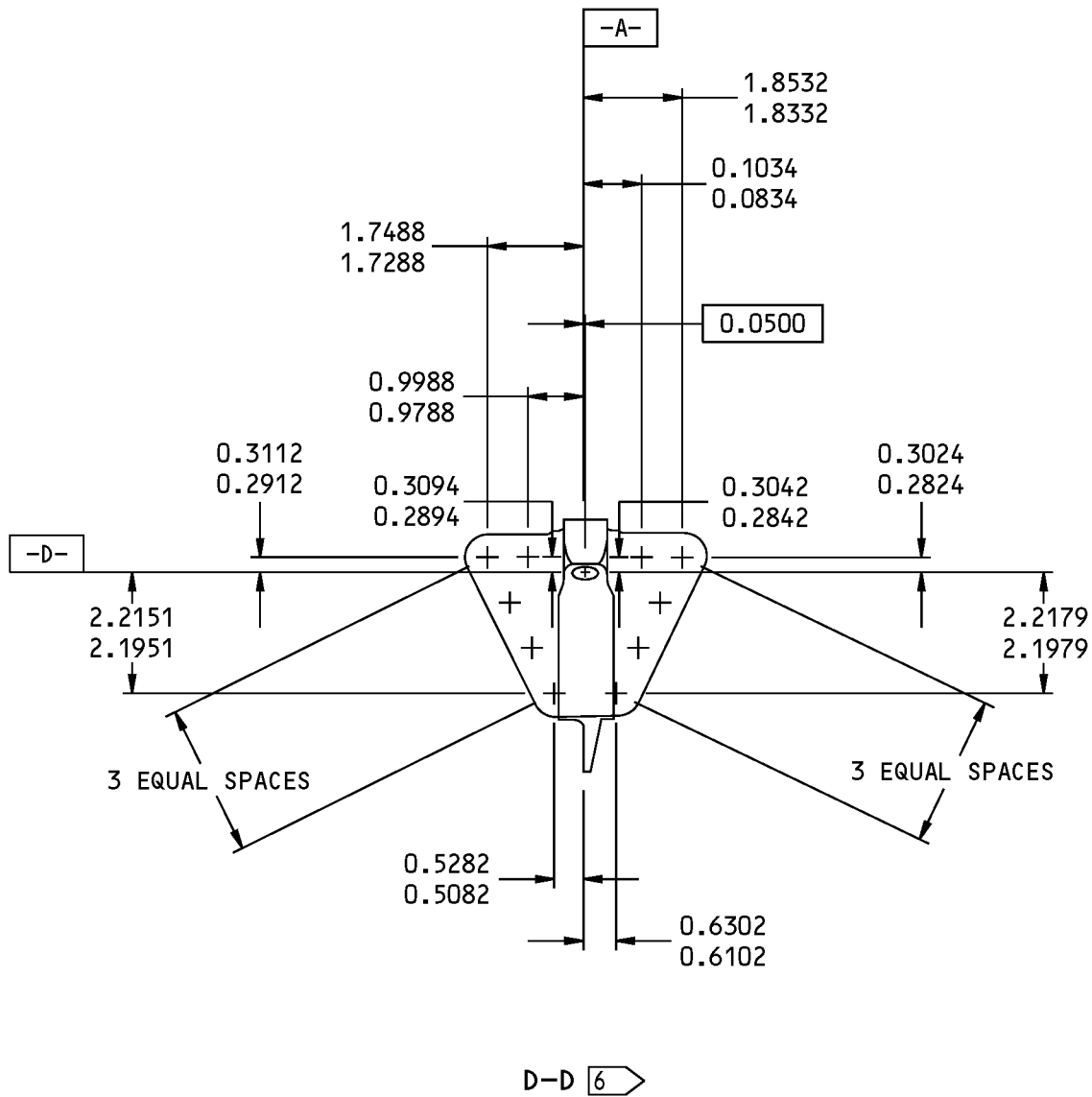
STOP FITTING (65,245) 6

141A6103-2,-4,-6,-8,-10,-12,-14,-16,-18,-20,-24,-26,-28 Stop Fitting Repair
Figure 601 (Sheet 9 of 25)

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REPAIR 2-2
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141A6103-2,-4,-6,-8,-10,-12,-14,-16,-18,-20,-24,-26,-28 Stop Fitting Repair
Figure 601 (Sheet 10 of 25)

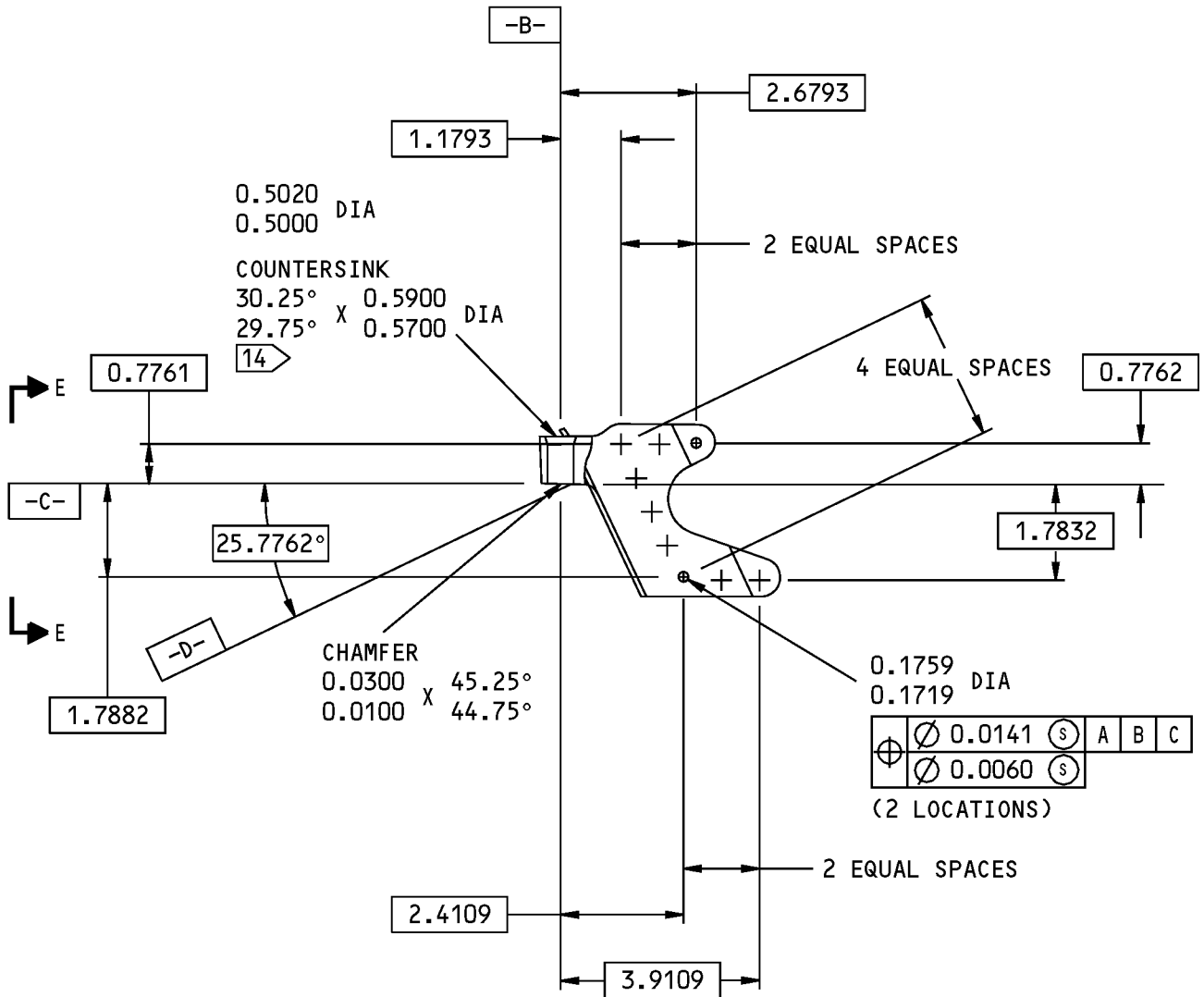
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REPAIR 2-2

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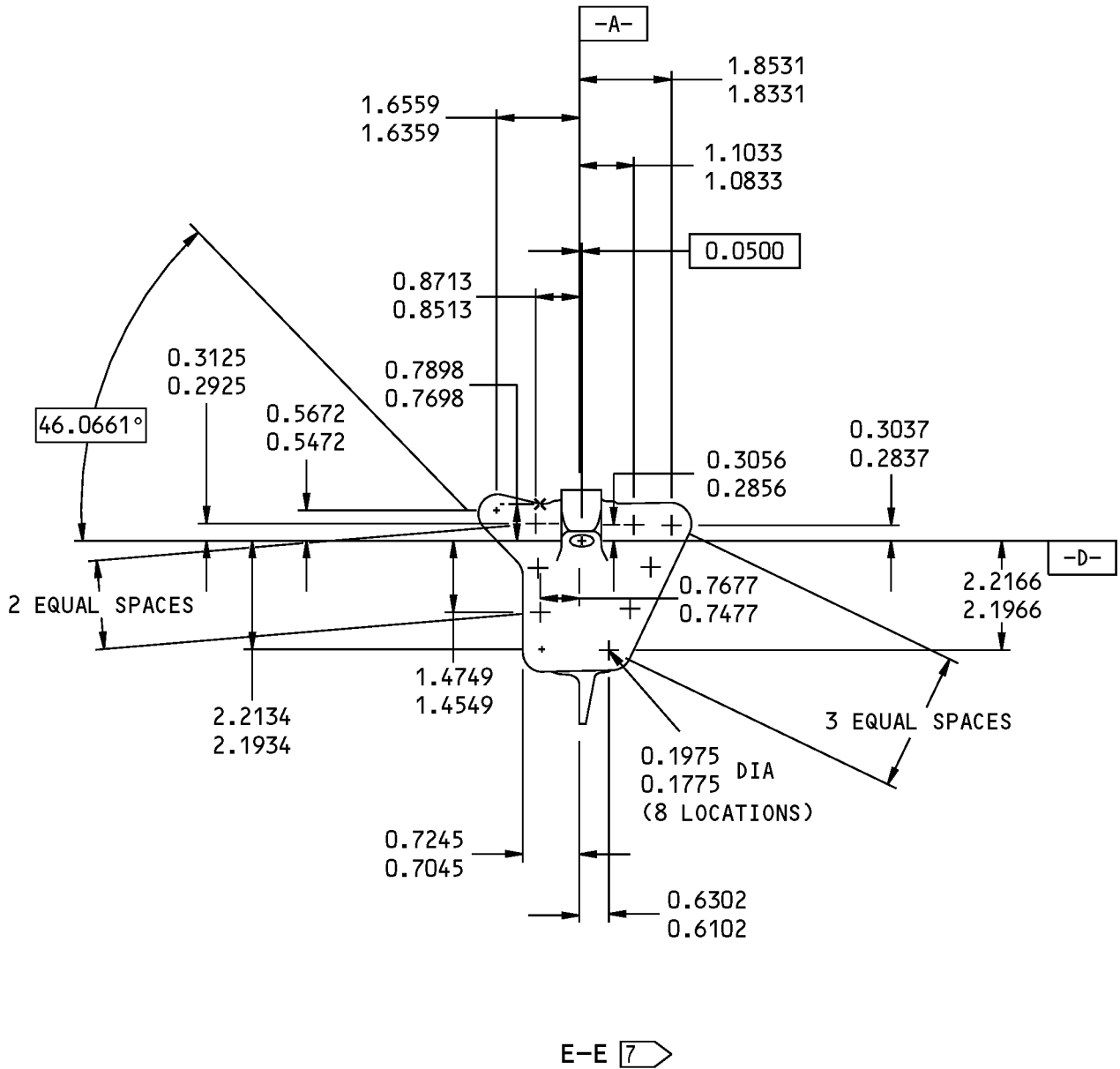
STOP FITTING (300) 7

141A6103-2,-4,-6,-8,-10,-12,-14,-16,-18,-20,-24,-26,-28 Stop Fitting Repair
Figure 601 (Sheet 11 of 25)

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REPAIR 2-2
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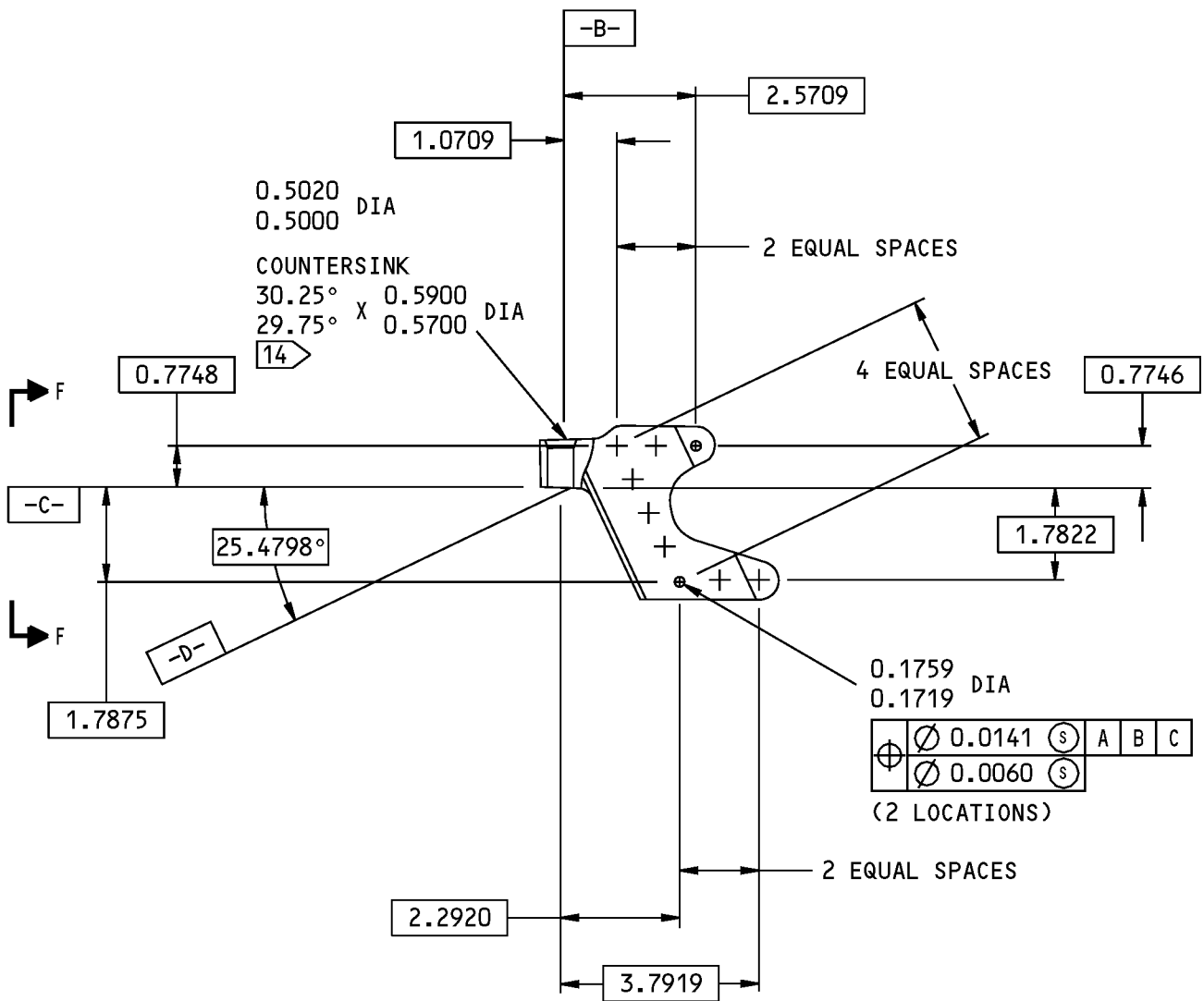


141A6103-2,-4,-6,-8,-10,-12,-14,-16,-18,-20,-24,-26,-28 Stop Fitting Repair
Figure 601 (Sheet 12 of 25)

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STOP FITTING (390) 8

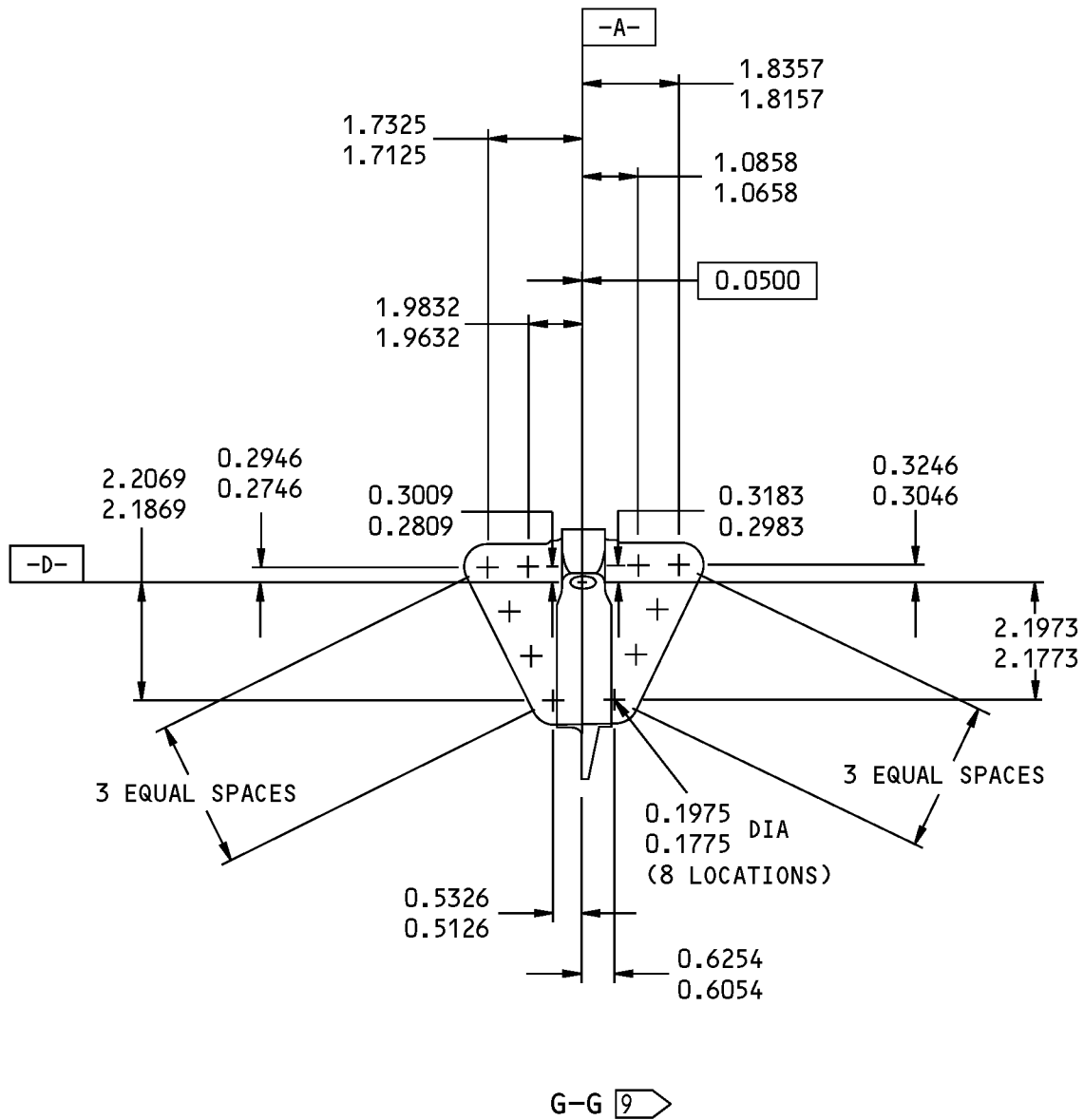
141A6103-2,-4,-6,-8,-10,-12,-14,-16,-18,-20,-24,-26,-28 Stop Fitting Repair
Figure 601 (Sheet 13 of 25)

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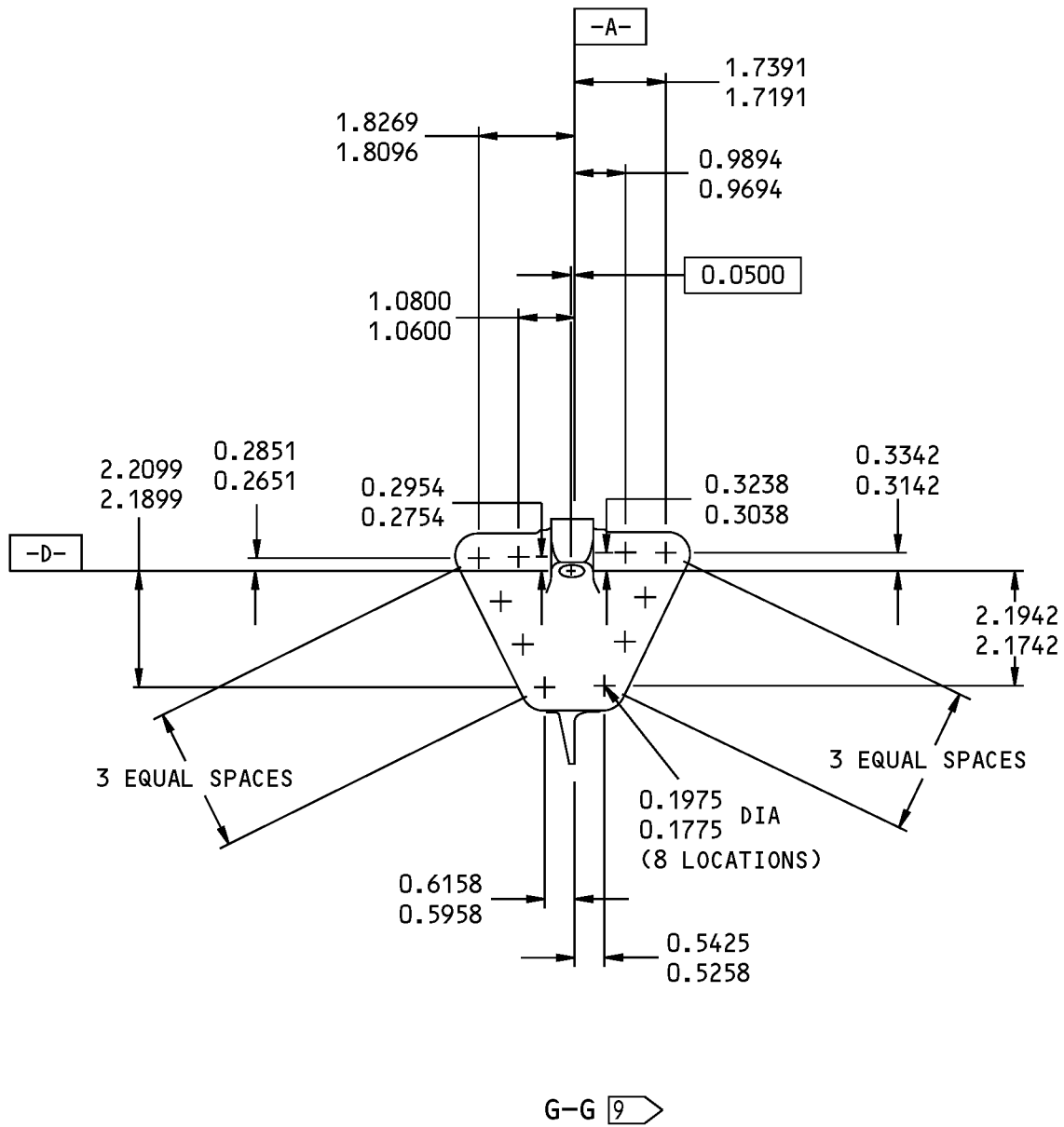


141A6103-2,-4,-6,-8,-10,-12,-14,-16,-18,-20,-24,-26,-28 Stop Fitting Repair
Figure 601 (Sheet 14 of 25)

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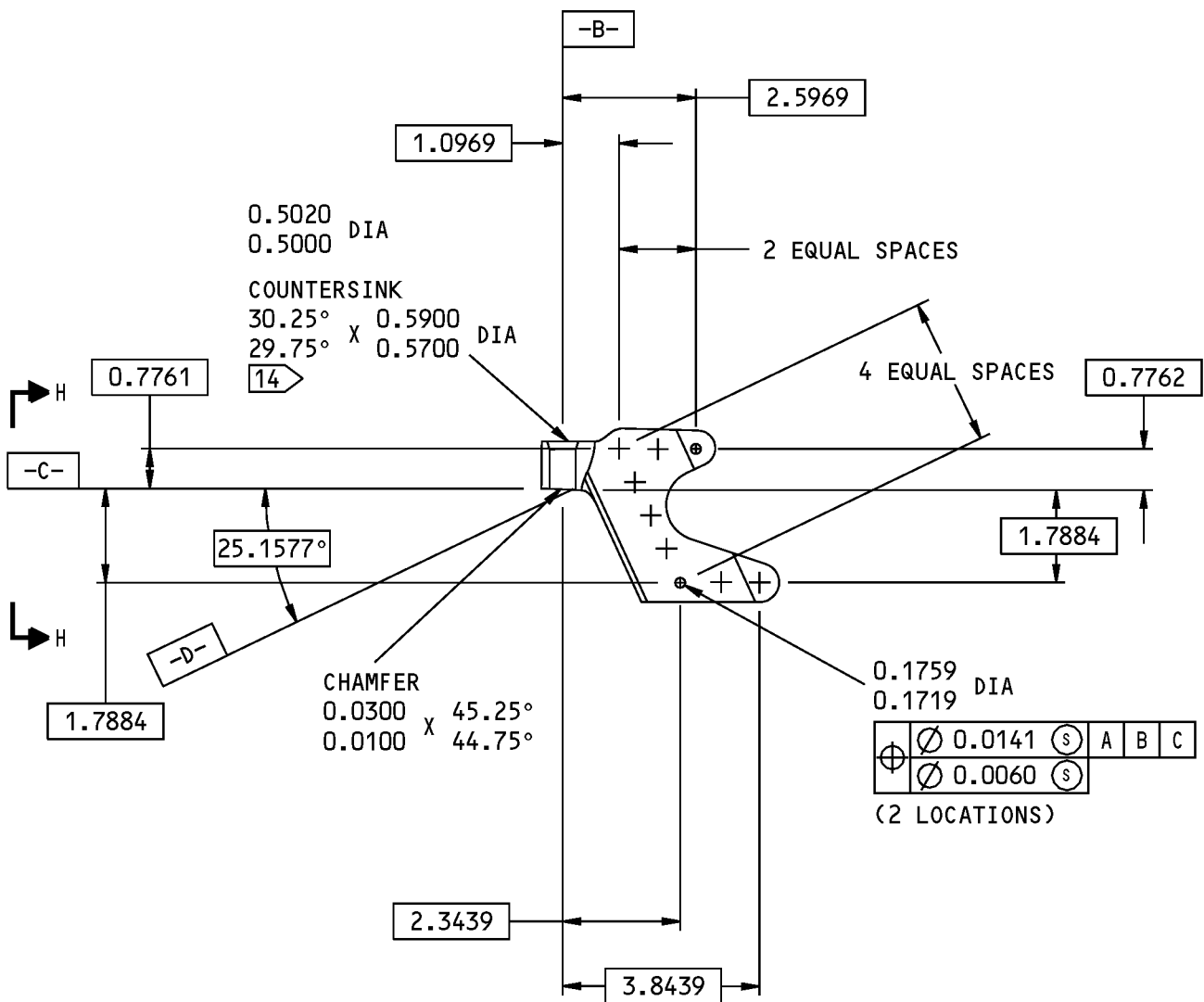


141A6103-2,-4,-6,-8,-10,-12,-14,-16,-18,-20,-24,-26,-28 Stop Fitting Repair
Figure 601 (Sheet 16 of 25)

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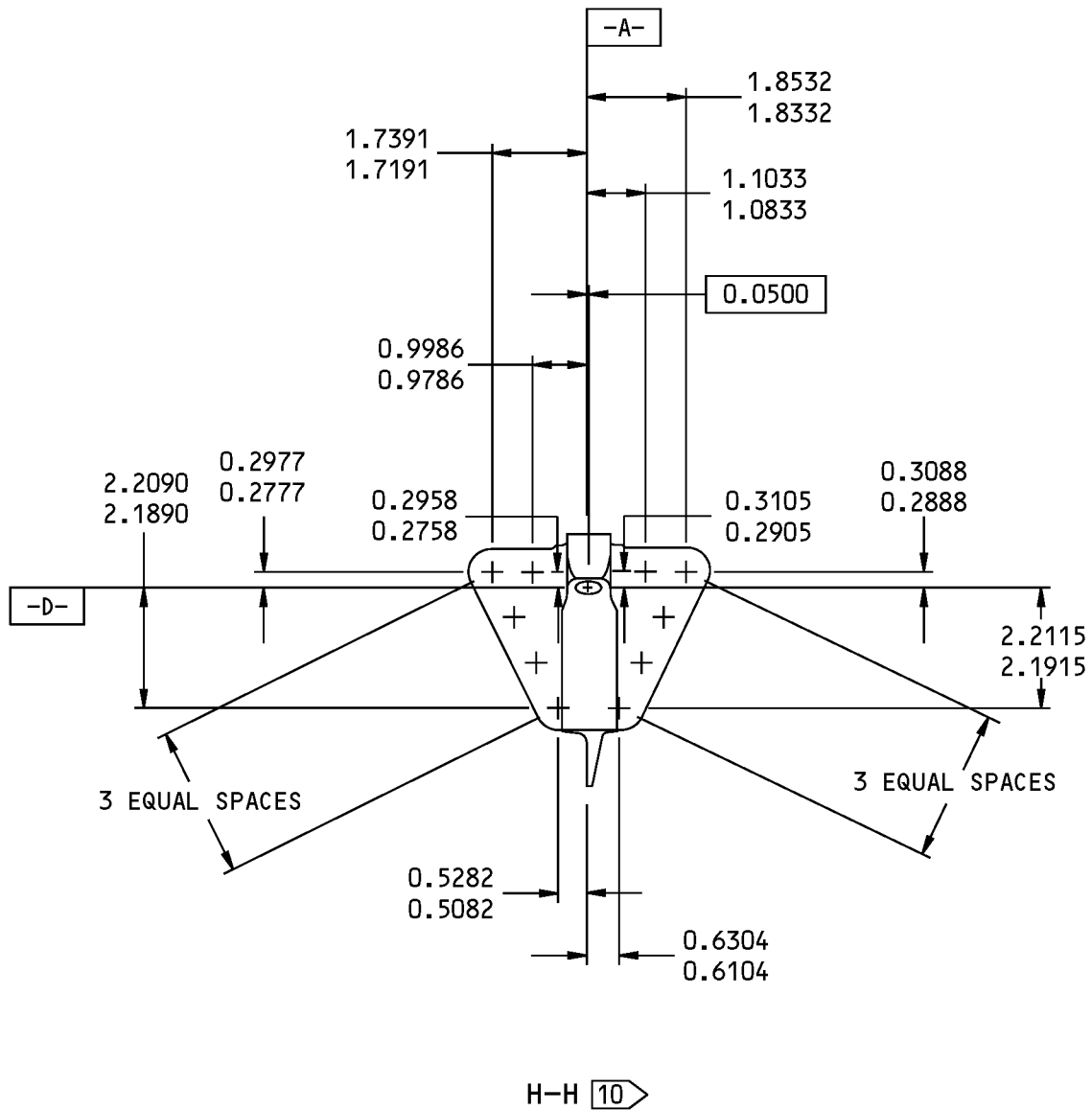
STOP FITTING (535) 10

141A6103-2,-4,-6,-8,-10,-12,-14,-16,-18,-20,-24,-26,-28 Stop Fitting Repair
Figure 601 (Sheet 17 of 25)

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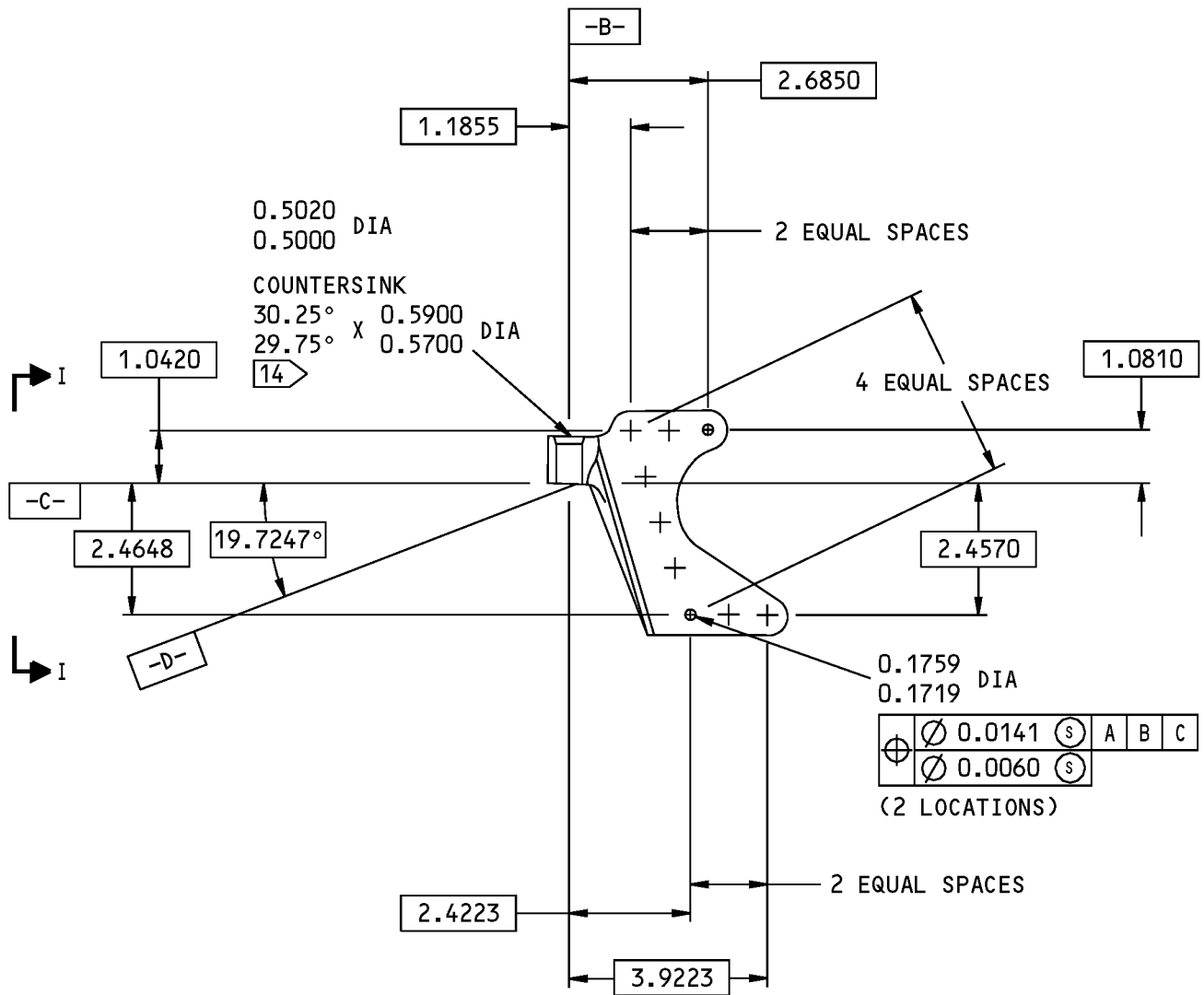


141A6103-2,-4,-6,-8,-10,-12,-14,-16,-18,-20,-24,-26,-28 Stop Fitting Repair
Figure 601 (Sheet 18 of 25)

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STOP FITTING (645) 11

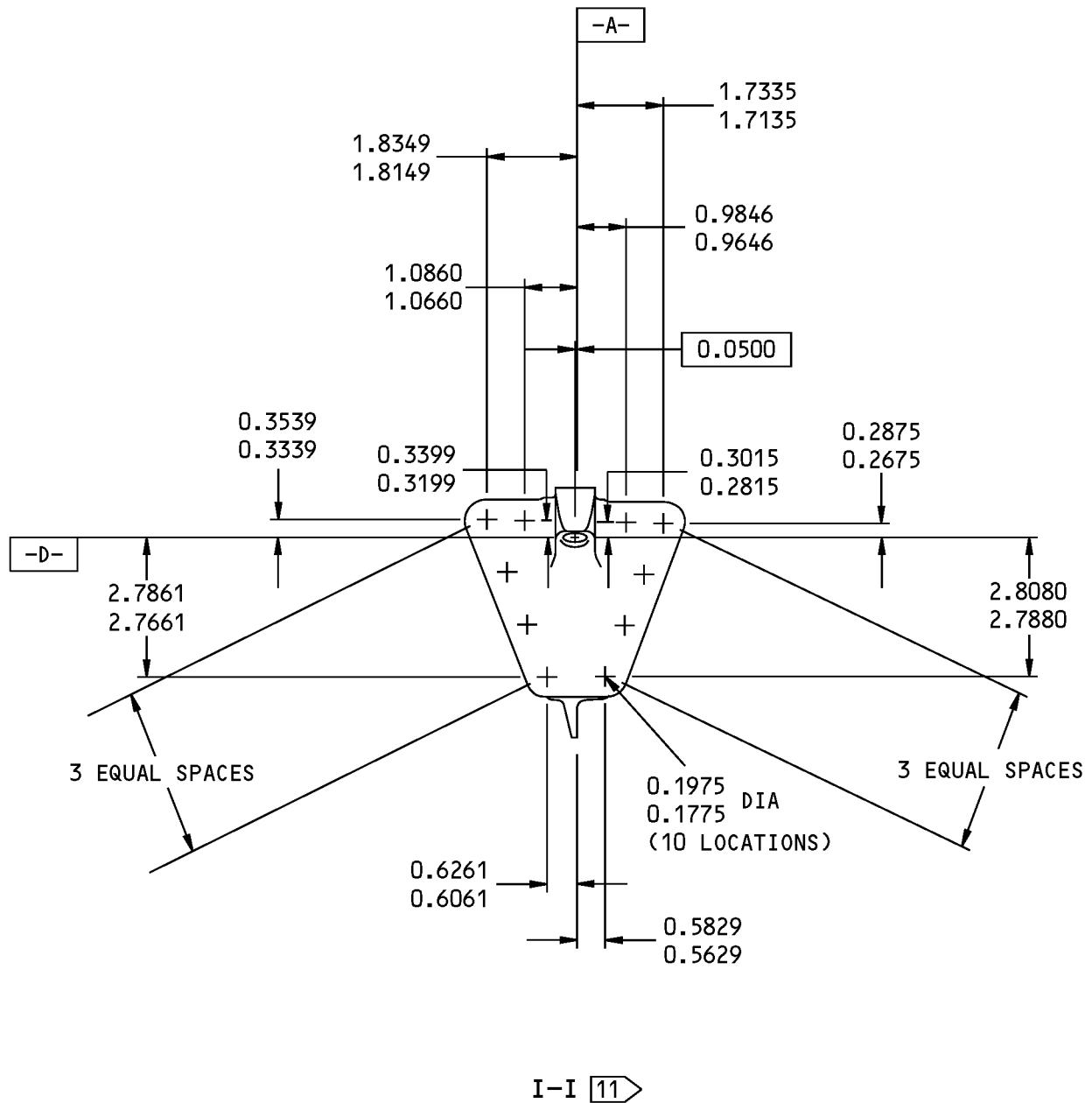
141A6103-2,-4,-6,-8,-10,-12,-14,-16,-18,-20,-24,-26,-28 Stop Fitting Repair
Figure 601 (Sheet 19 of 25)

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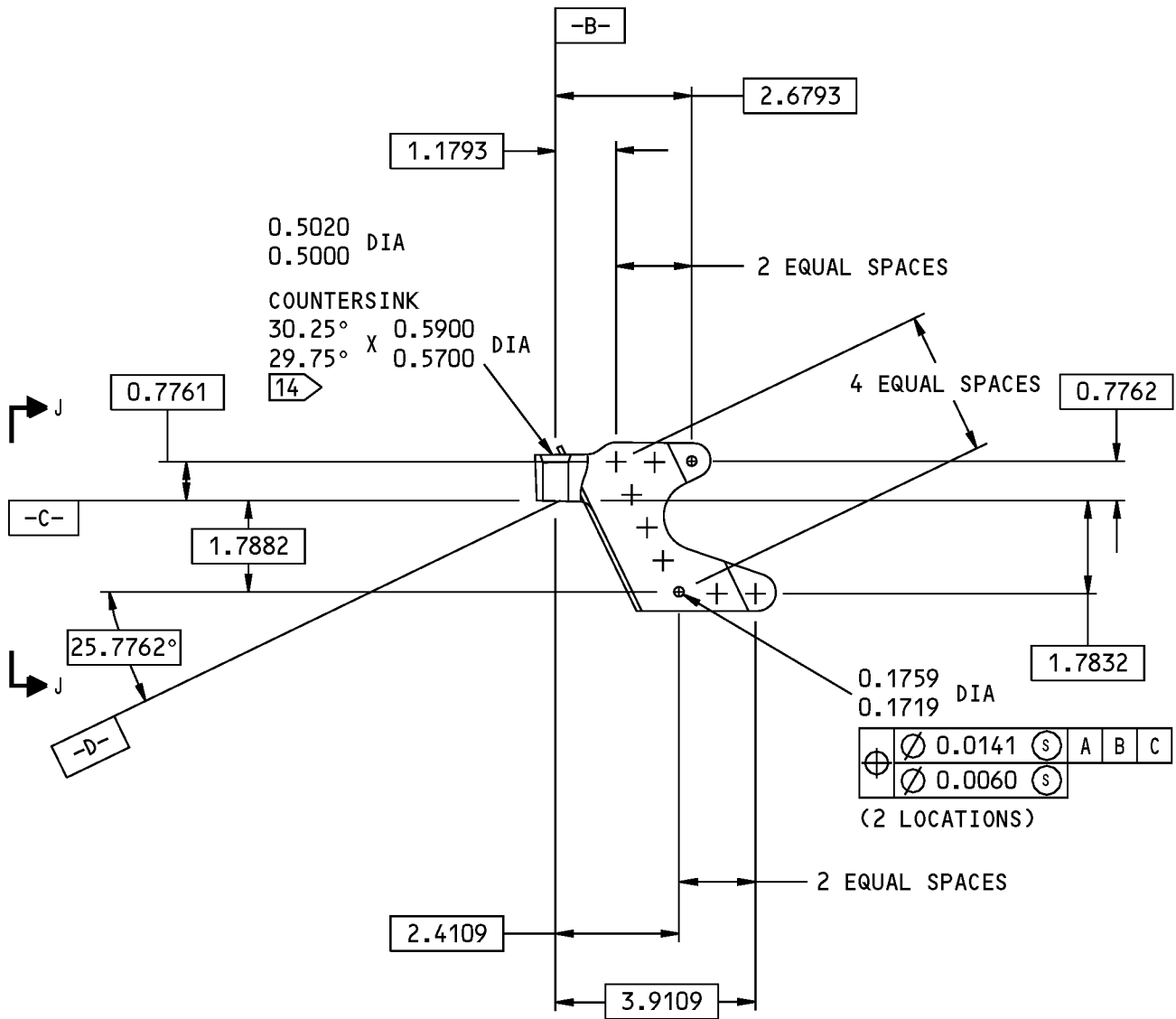


141A6103-2,-4,-6,-8,-10,-12,-14,-16,-18,-20,-24,-26,-28 Stop Fitting Repair
Figure 601 (Sheet 20 of 25)

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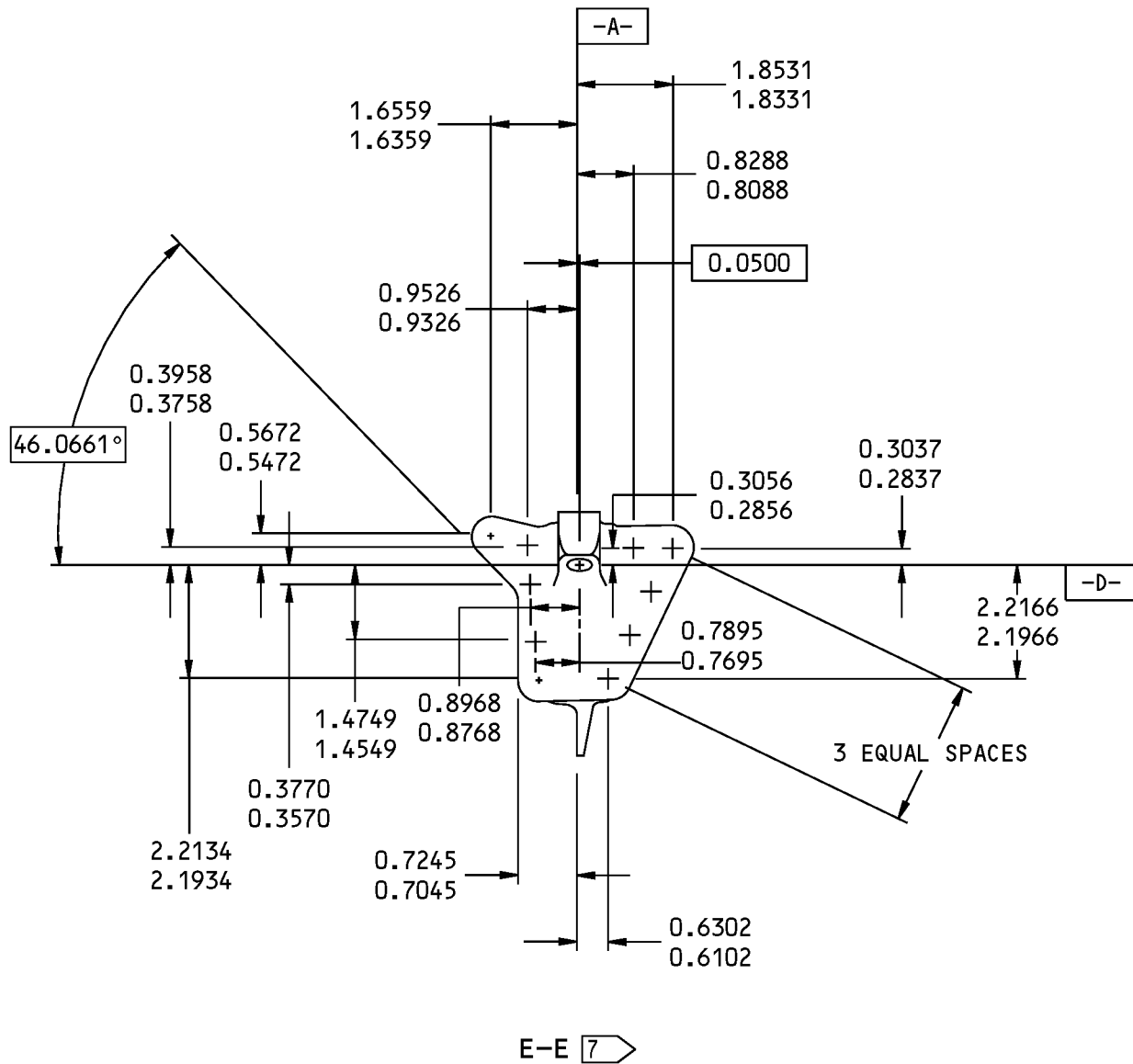
STOP FITTING (300A) 12

141A6103-2,-4,-6,-8,-10,-12,-14,-16,-18,-20,-24,-26,-28 Stop Fitting Repair
Figure 601 (Sheet 21 of 25)

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141A6103-2,-4,-6,-8,-10,-12,-14,-16,-18,-20,-24,-26,-28 Stop Fitting Repair
Figure 601 (Sheet 22 of 25)

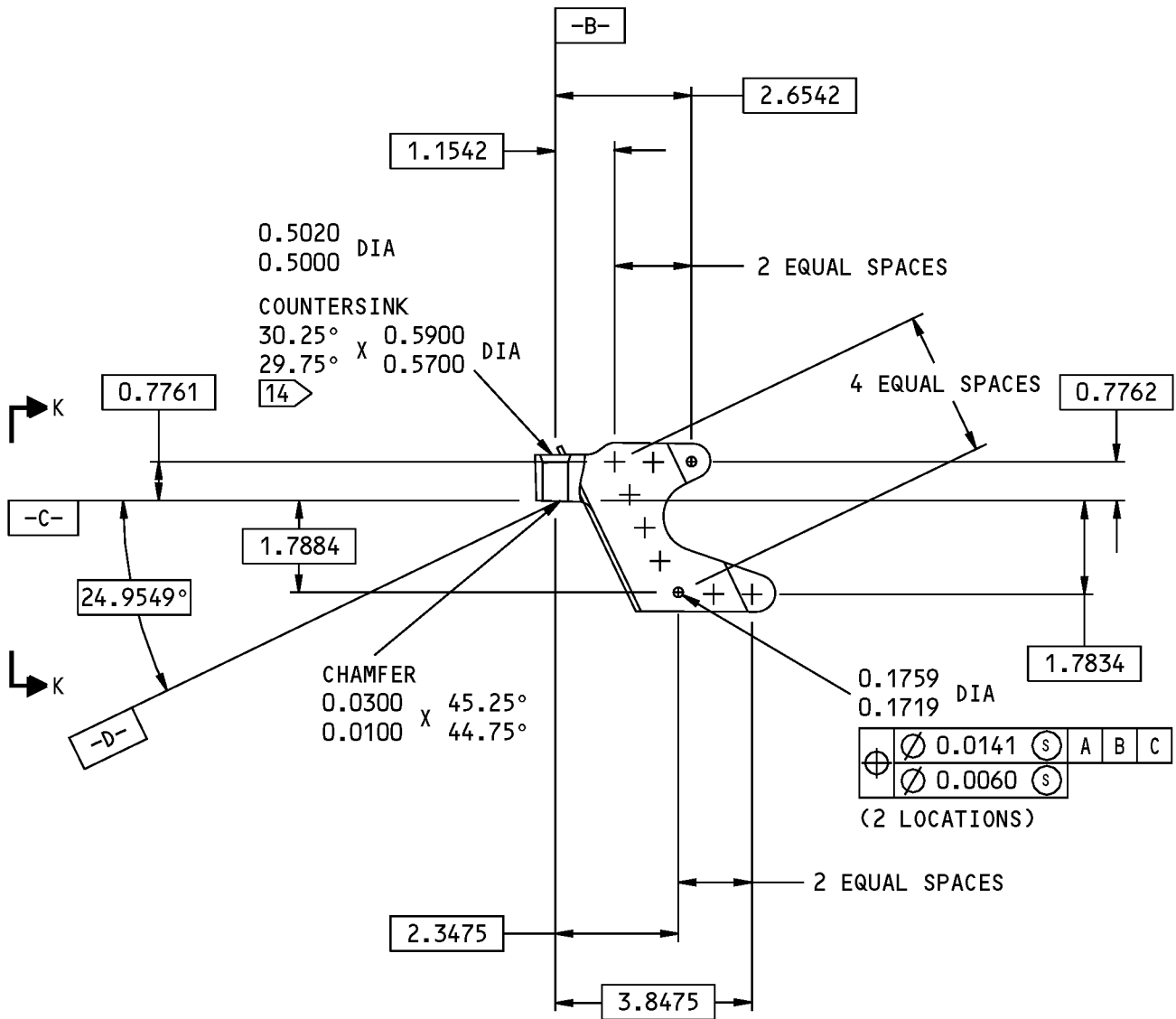
52-16-12

REPAIR 2-2

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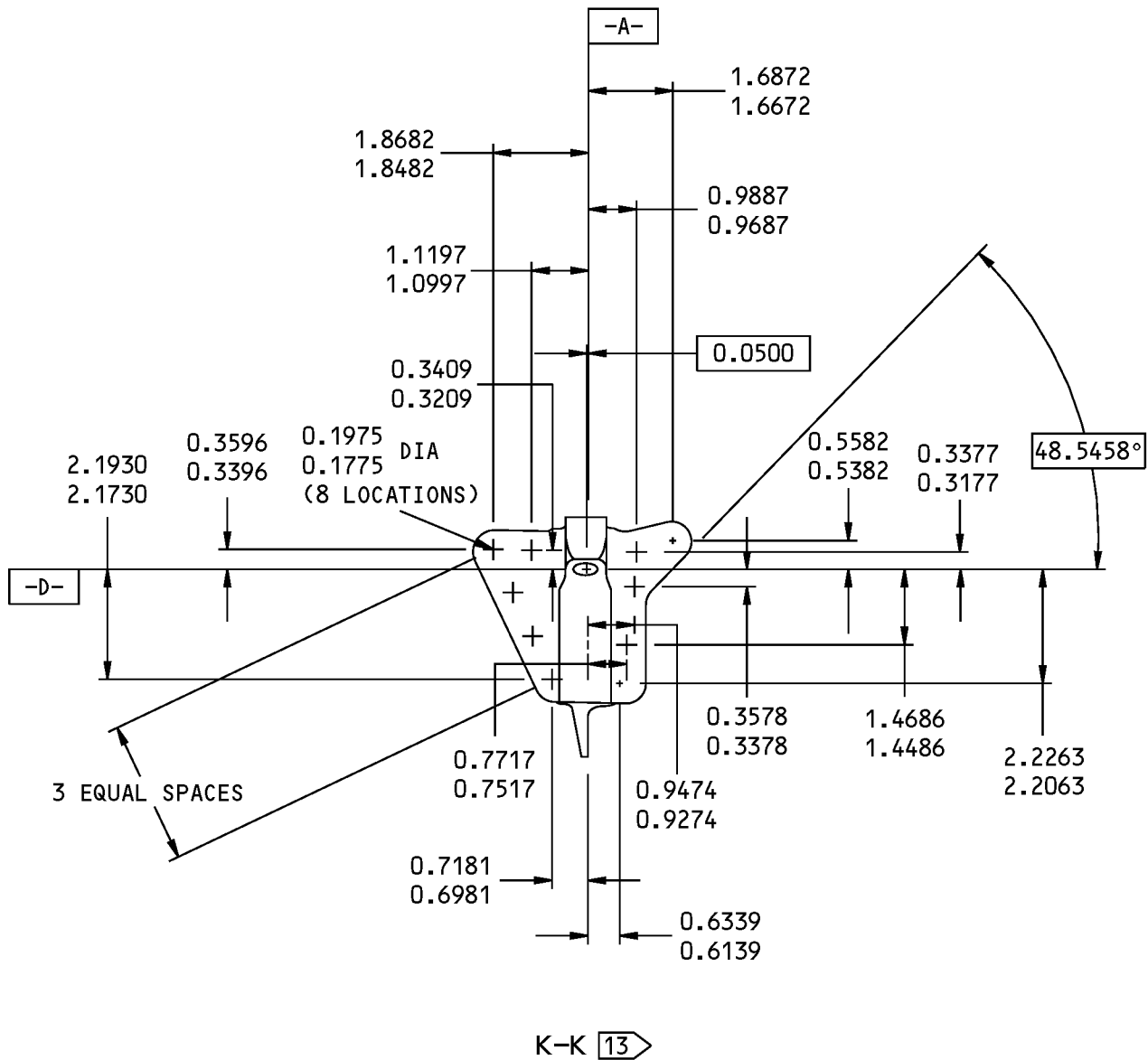
STOP FITTING (590) 13

141A6103-2,-4,-6,-8,-10,-12,-14,-16,-18,-20,-24,-26,-28 Stop Fitting Repair
Figure 601 (Sheet 23 of 25)

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141A6103-2,-4,-6,-8,-10,-12,-14,-16,-18,-20,-24,-26,-28 Stop Fitting Repair
Figure 601 (Sheet 24 of 25)

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- 1 141A6103-2
- 2 141A6103-4
- 3 141A6103-6
- 4 141A6103-8
- 5 141A6103-10
- 6 141A6103-12
- 7 141A6103-14
- 8 141A6103-16
- 9 141A6103-18
- 10 141A6103-20
- 11 141A6103-24
- 12 141A6103-26
- 13 141A6103-28
- 14 DO NOT SHOT PEEN THIS HOLE

125/ ALL MACHINED SURFACES UNLESS
√ SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBER REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

141A6103-2,-4,-6,-8,-10,-12,-14,-16,-18,-20,-24,-26,-28 Stop Fitting Repair
Figure 601 (Sheet 25 of 25)

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REPAIR 2-2

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COMPONENT MAINTENANCE MANUAL

STOP FITTING ASSEMBLY - REPAIR 3-1

141A6104-3, -5, -7, -9, -19

1. General

- A. This procedure has the data necessary to repair the stop fitting assembly (185, 670, 675).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 shown in the repair.
- D. Refer to IPL Figure 2 for item numbers.

2. Bushing Replacement

- 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. Procedure (REPAIR 3-1, Figure 601)

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

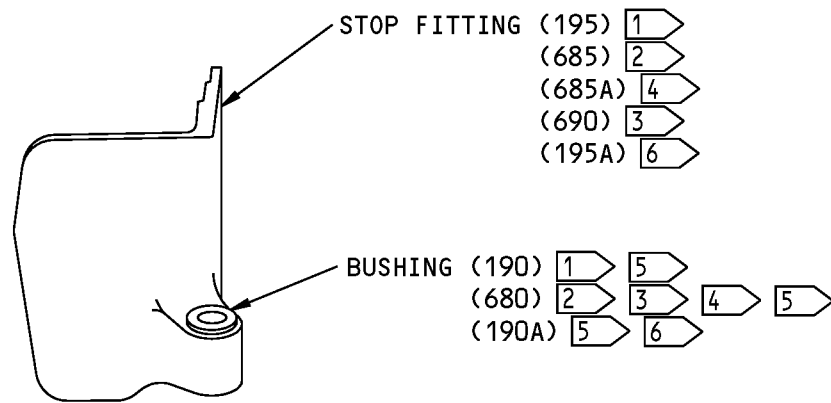
- (1) Remove the bushings (190, 680) from the fittings (195, 685, 690).
- (2) Install the new bushings (190, 680) onto the fittings (195, 685, 690) with sealant, A00247, as specified in SOPM 20-50-03.

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STOP FITTING ASSEMBLY (185) SHOWN
 STOP FITTING ASSEMBLY (185A) IS ALMOST THE SAME

- 1 141A6104-3
- 2 141A6104-5
- 3 141A6104-7
- 4 141A6104-9
- 5 INSTALL AND ROLLER SWAGE
 THIS BUSHING AS SPECIFIED IN
 SOPM 20-50-03
- 6 141A6104-19

ITEM NUMBERS REFER TO IPL FIG. 2

141A6104-3,-5,-7,-9,-19 Stop Fitting Assembly Repair
 Figure 601

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REPAIR 3-1
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COMPONENT MAINTENANCE MANUAL

STOP FITTING - REPAIR 3-2

141A6104-4, -6, -8, -10, -20

1. General

- A. This procedure tells how to refinish the stop fittings (195, 685, 690).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 shown in the repair.
- D. Refer to IPL Figure 2 for item numbers.
- E. General repair details:
 - (1) Material: Aluminum Alloy
 - (2) Shot Peen: All external surfaces, except in holes
 - (a) Intensity: 0.005A-0.010A
 - (b) Coverage: 1.0 automatic, 2.0 manual

2. Stop Fitting Refinish

- 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 |

- B. References

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

- C. Procedure (REPAIR 3-2, Figure 601 thru REPAIR 3-2, Figure 604)

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

- (1) Prepare the surface as specified in SOPM 20-30-02.
- (2) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31) and apply primer, C00259 (F-20.03).

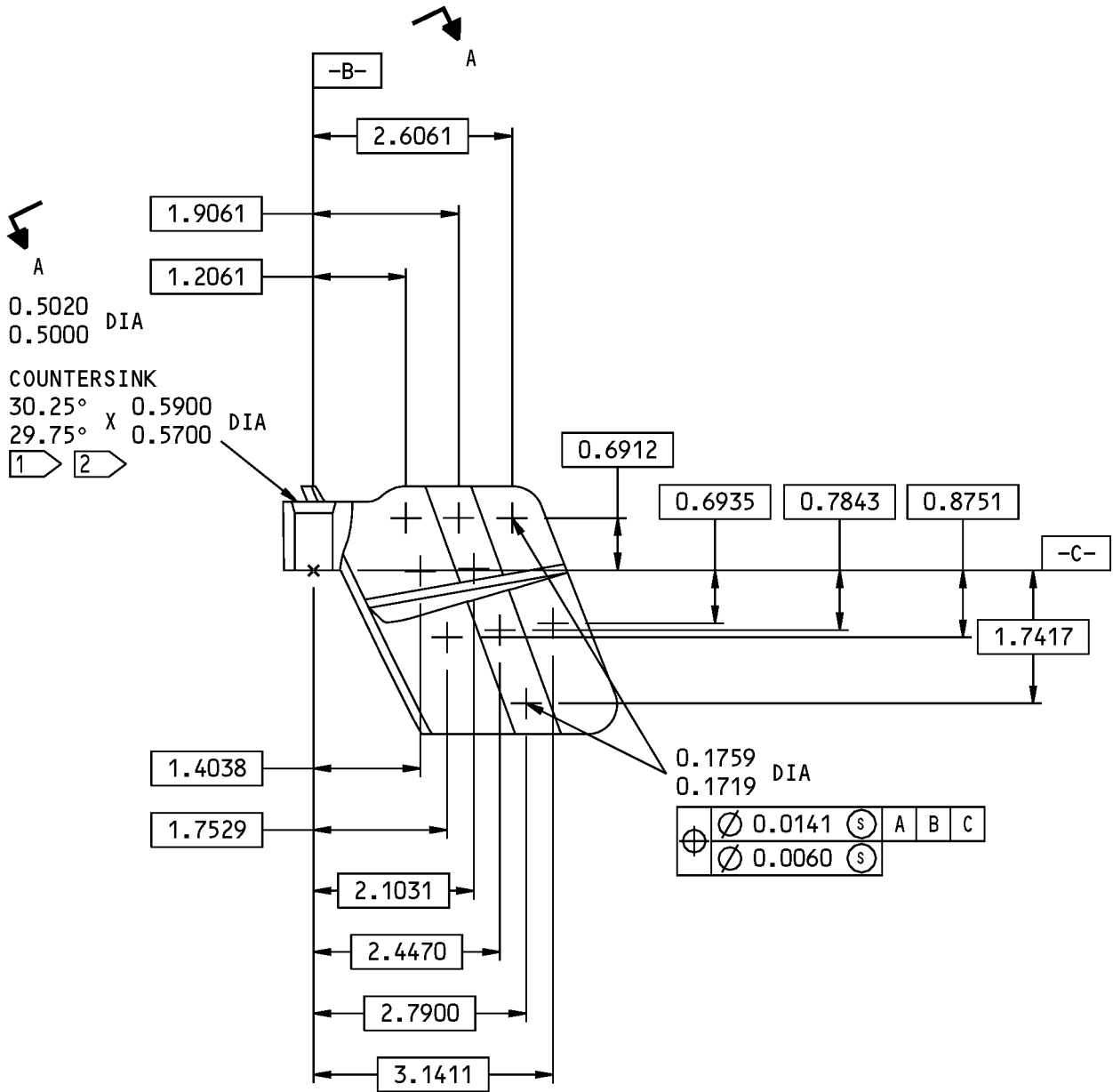
52-16-12

REPAIR 3-2

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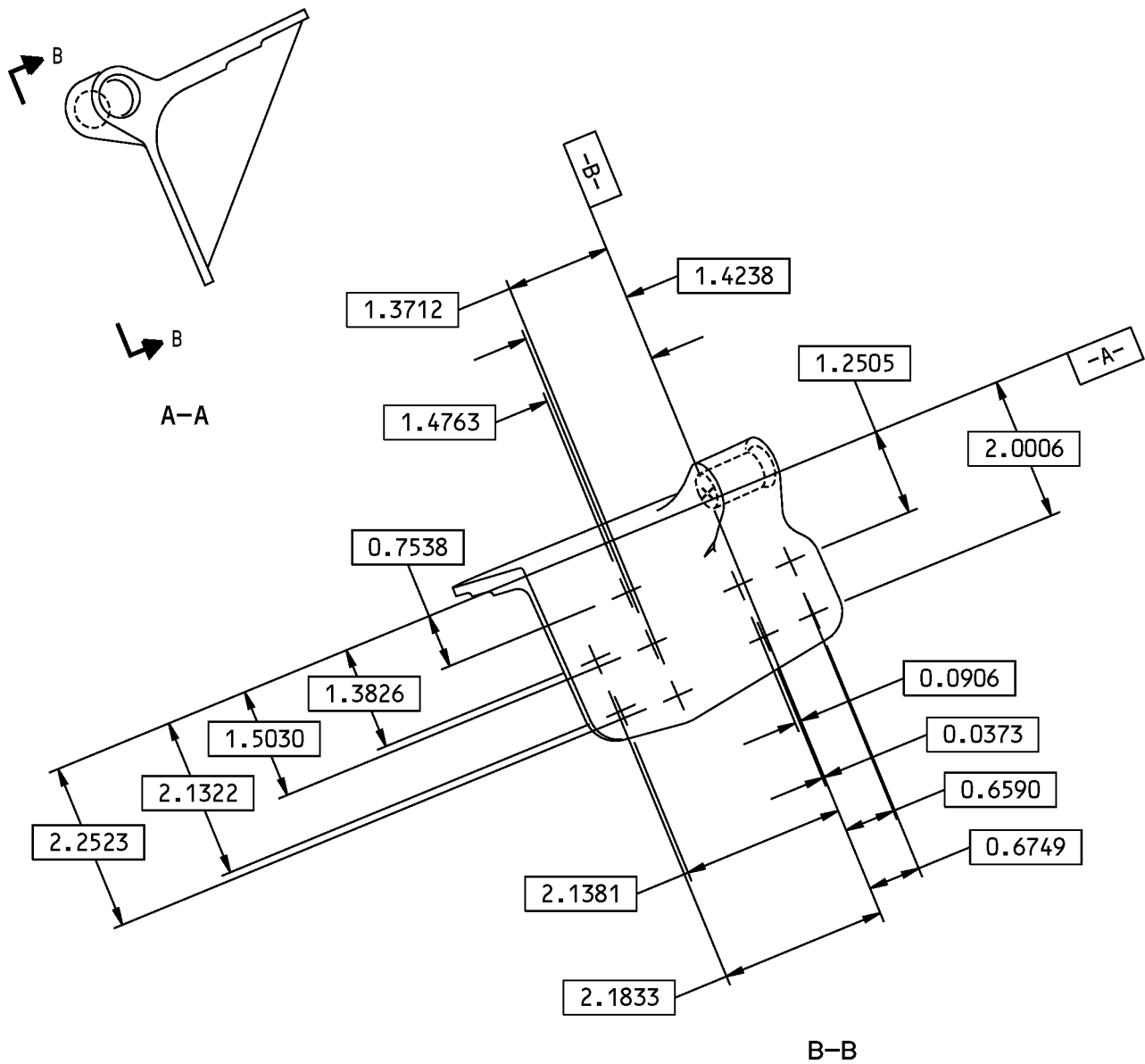
STOP FITTING (195) SHOWN
STOP FITTING (195A) IS ALMOST THE SAME

141A6104-4,-20 Stop Fitting Repair
Figure 601 (Sheet 1 of 2)

52-16-12

REPAIR 3-2
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- 1 DO NOT SHOT PEEN THIS HOLE
- 2 DO NOT PUT PRIMER IN THIS HOLE

125 ✓ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

141A6104-4,-20 Stop Fitting Repair
Figure 601 (Sheet 2 of 2)

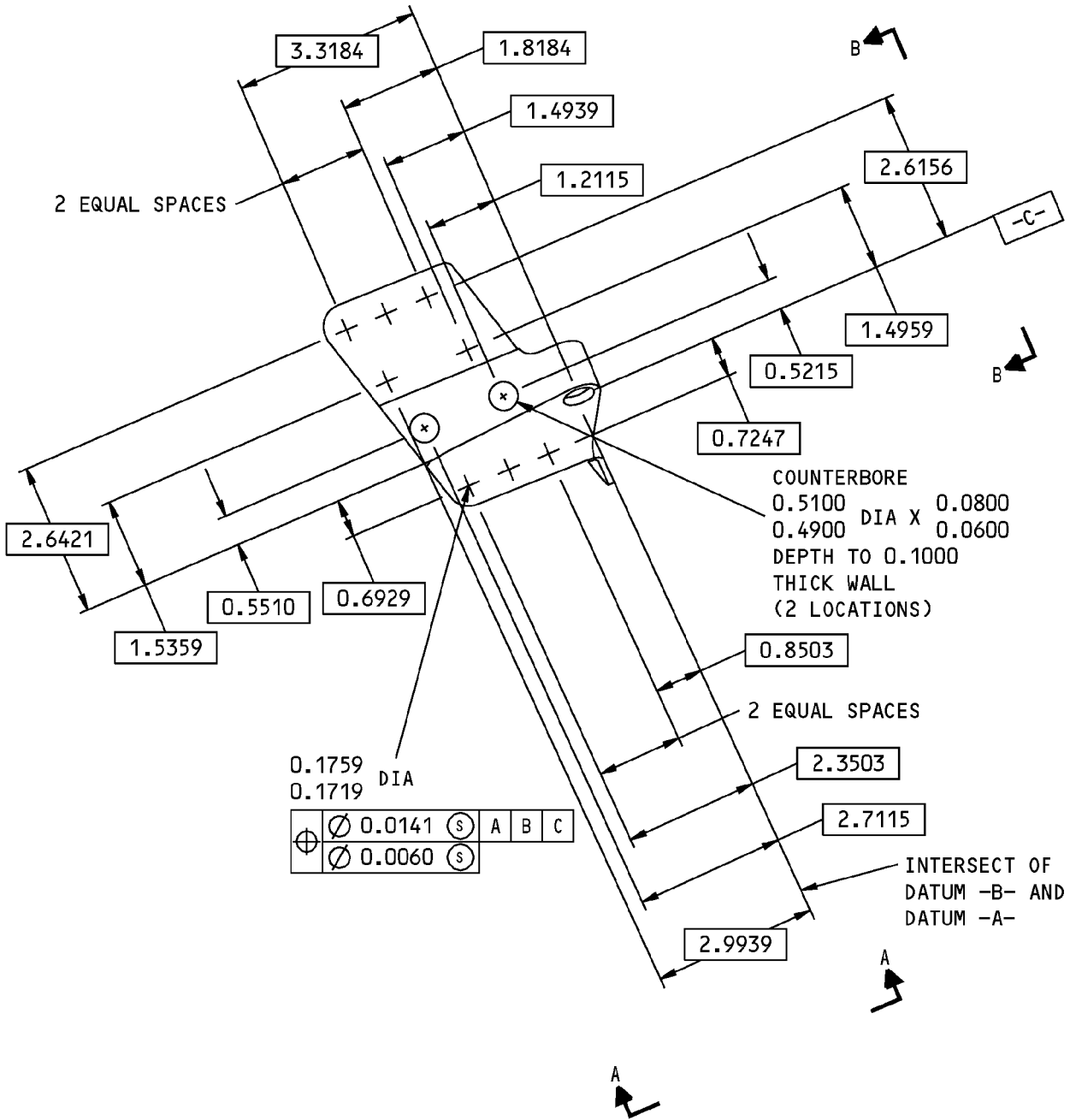
52-16-12

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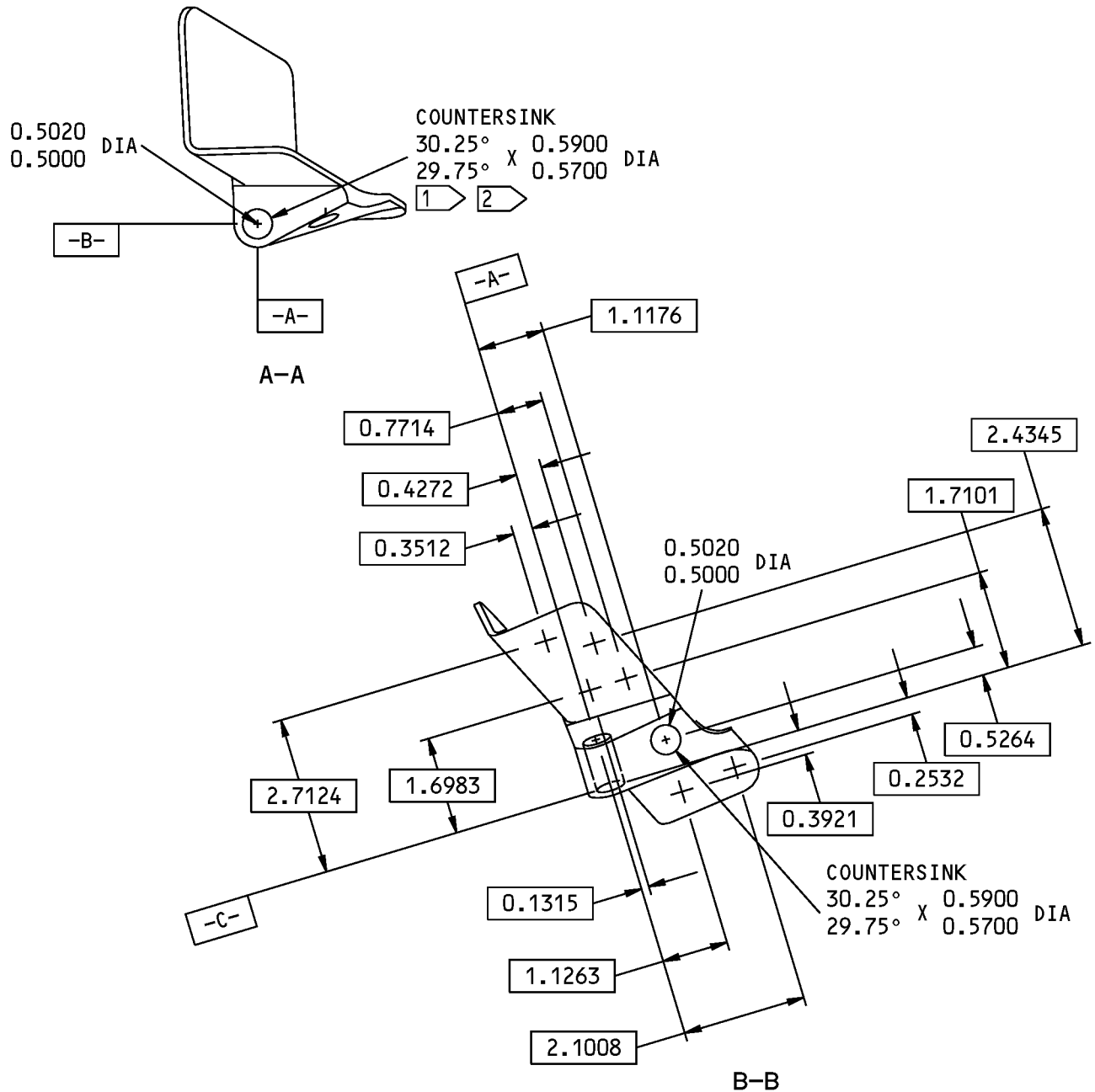
STOP FITTING (685)

141A6104-6 Stop Fitting Repair
Figure 602 (Sheet 1 of 2)

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REPAIR 3-2
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COMPONENT MAINTENANCE MANUAL



- 1 DO NOT SHOT PEEN THIS HOLE
- 2 DO NOT PUT PRIMER IN THIS HOLE

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBER REFER TO IPL FIG. 2

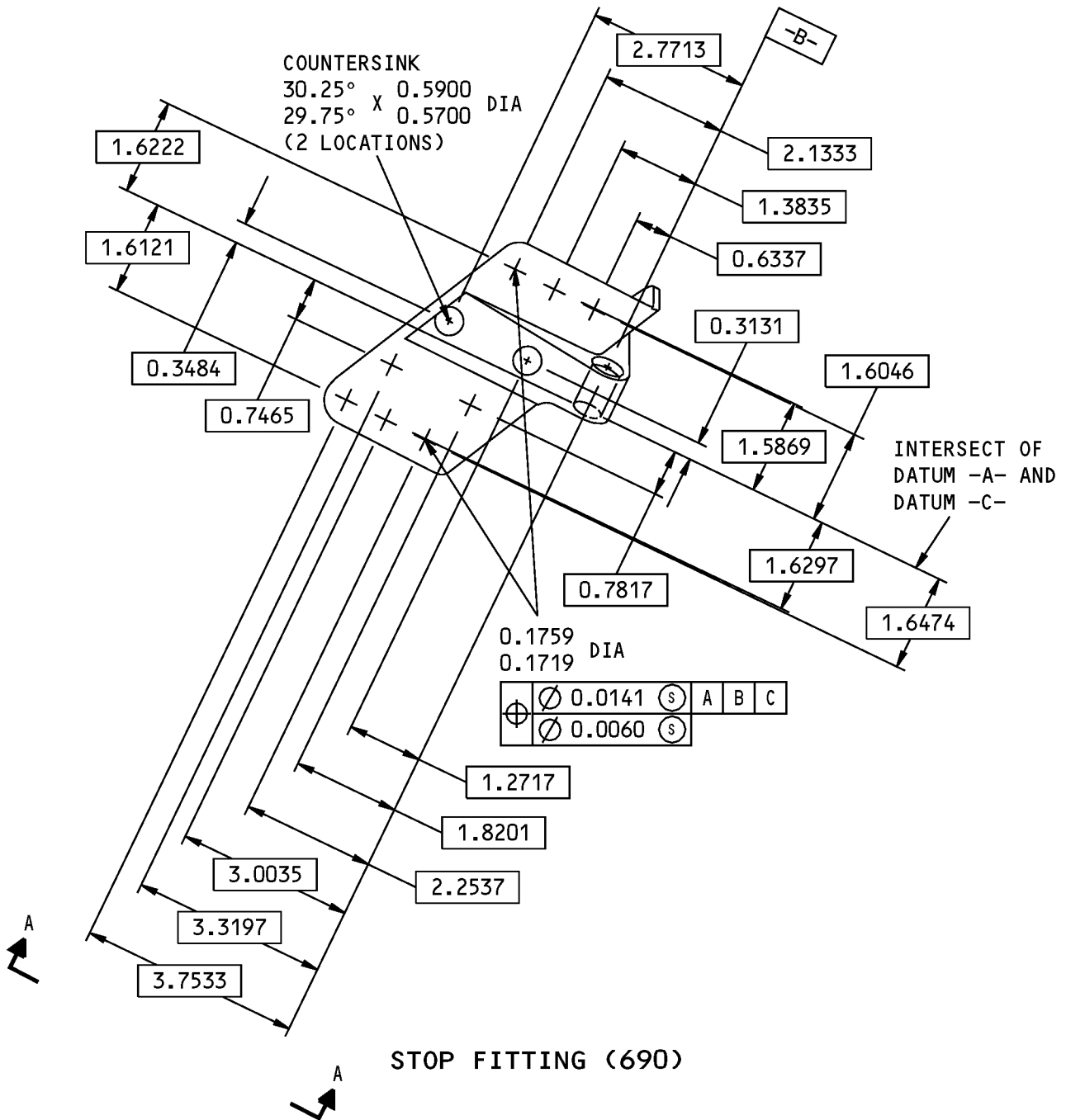
ALL DIMENSIONS ARE IN INCHES

141A6104-6 Stop Fitting Repair
Figure 602 (Sheet 2 of 2)

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REPAIR 3-2
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COMPONENT MAINTENANCE MANUAL

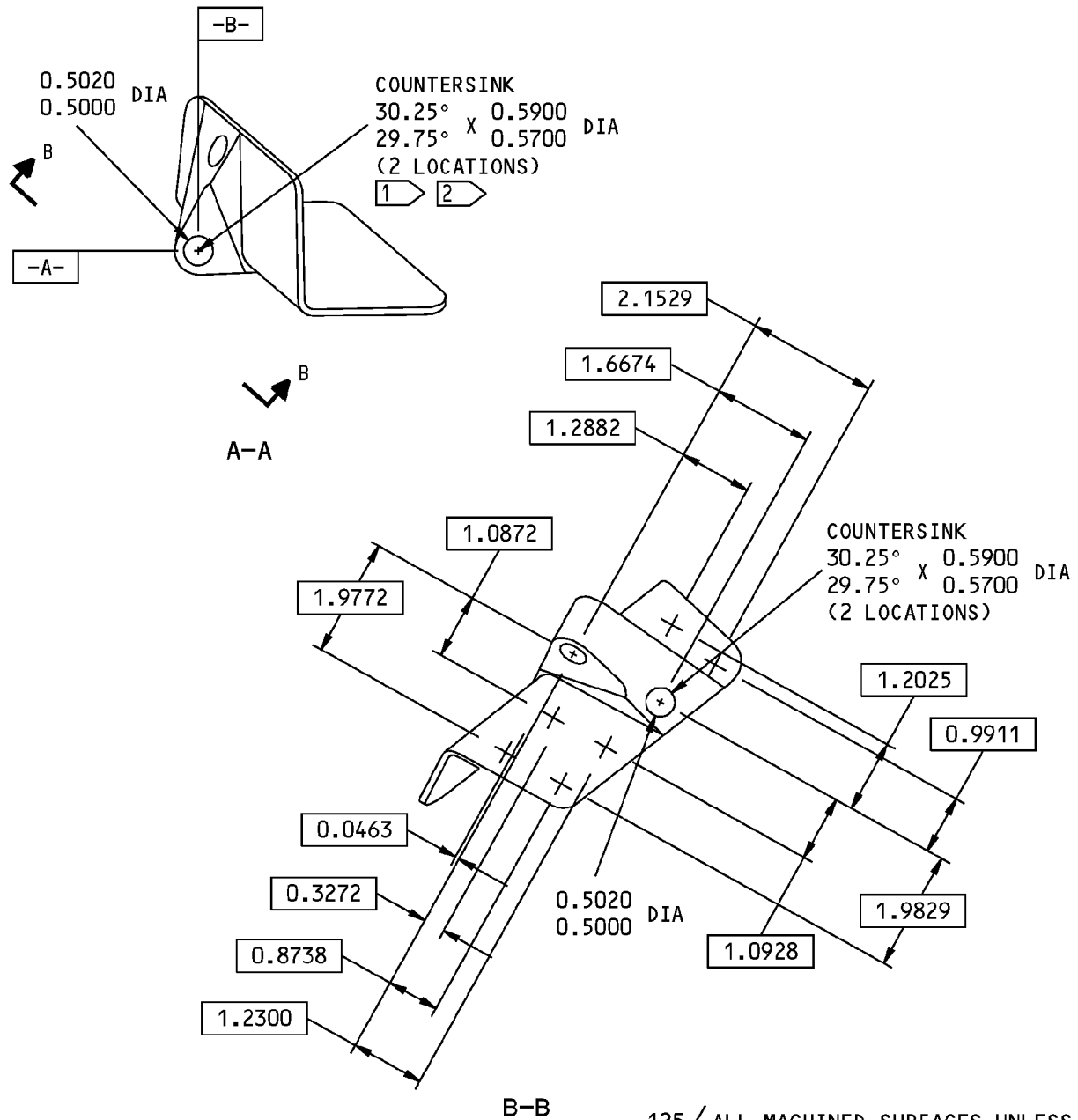


141A6104-8 Stop Fitting Repair
Figure 603 (Sheet 1 of 2)

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REPAIR 3-2
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COMPONENT MAINTENANCE MANUAL



125 ✓ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

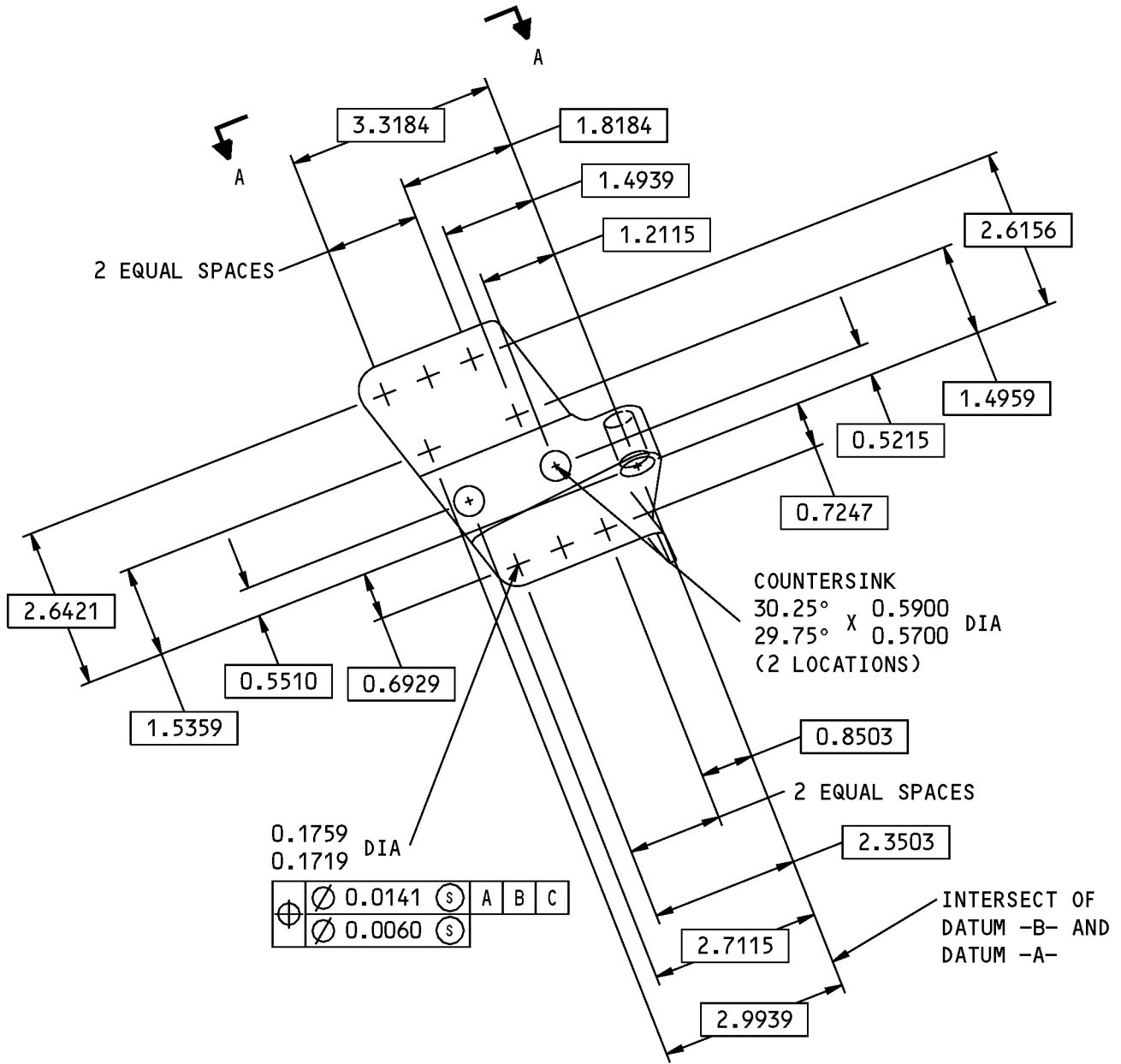
- 1 DO NOT SHOT PEEN THIS HOLE
- 2 DO NOT PUT PRIMER IN THIS HOLE

141A6104-8 Stop Fitting Repair
Figure 603 (Sheet 2 of 2)

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REPAIR 3-2
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COMPONENT MAINTENANCE MANUAL



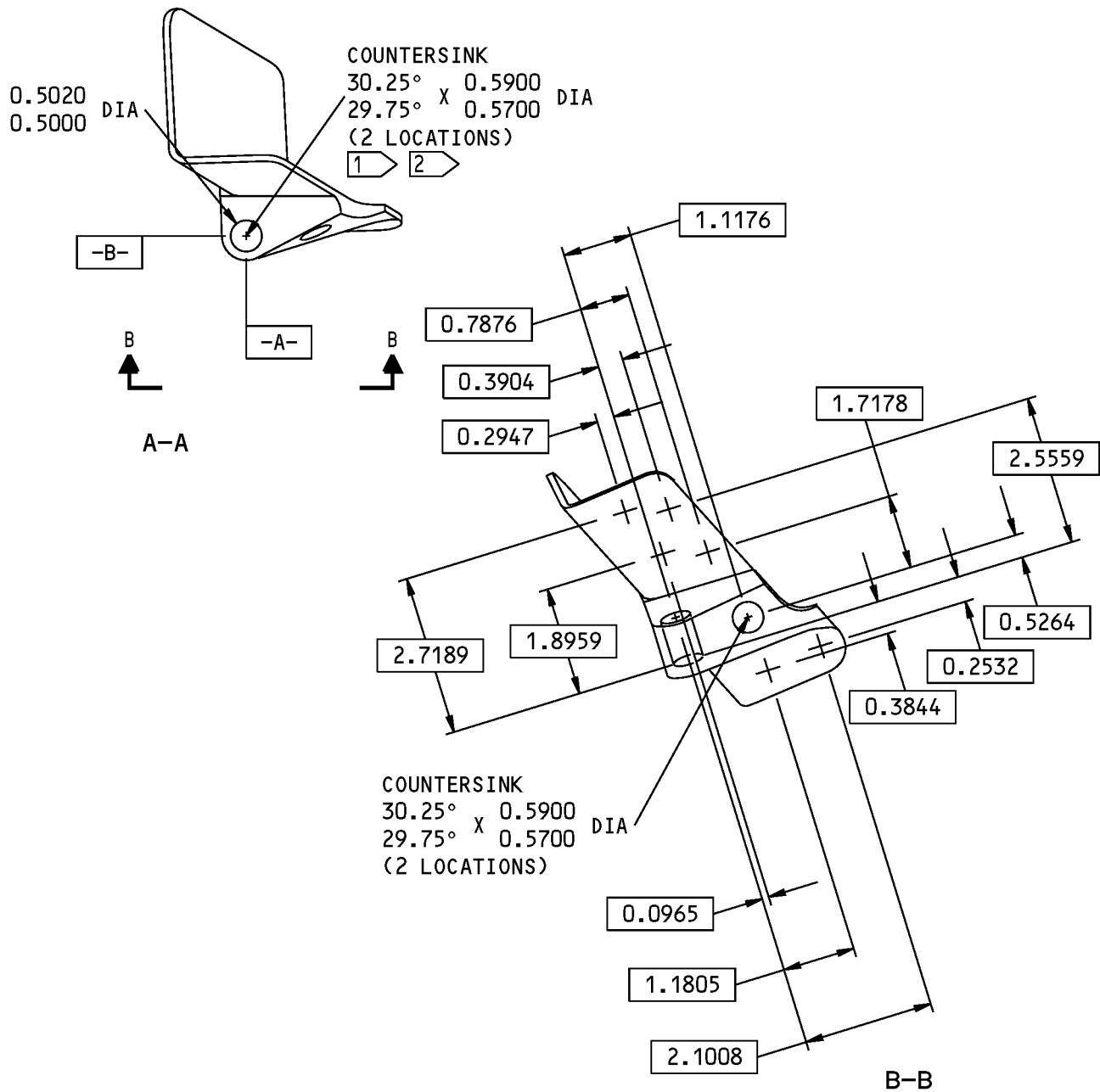
STOP FITTING (685A)

141A6104-10 Stop Fitting Repair
Figure 604 (Sheet 1 of 2)

52-16-12

REPAIR 3-2
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COMPONENT MAINTENANCE MANUAL



- 1 DO NOT SHOT PEEN THIS HOLE
- 2 DO NOT PUT PRIMER IN THIS HOLE

125 ✓ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBER REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

141A6104-10 Stop Fitting Repair
Figure 604 (Sheet 2 of 2)

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REPAIR 3-2
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COMPONENT MAINTENANCE MANUAL

UPPER GATE ASSEMBLY - REPAIR 4-1

141A6171-1, -5

1. General

- A. This procedure has the data necessary to repair the upper gate assembly (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 shown in the repair.
- D. Refer to IPL Figure 3 for item numbers.

2. Bushing Replacement

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

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

- (1) Remove the bushing(s) (95 or 100) from the upper gate (115).
- (2) Install the new bushing(s) (95 or 100) into the upper gate (115) with sealant, A00247 by the shrink-fit procedure as specified in SOPM 20-50-03.

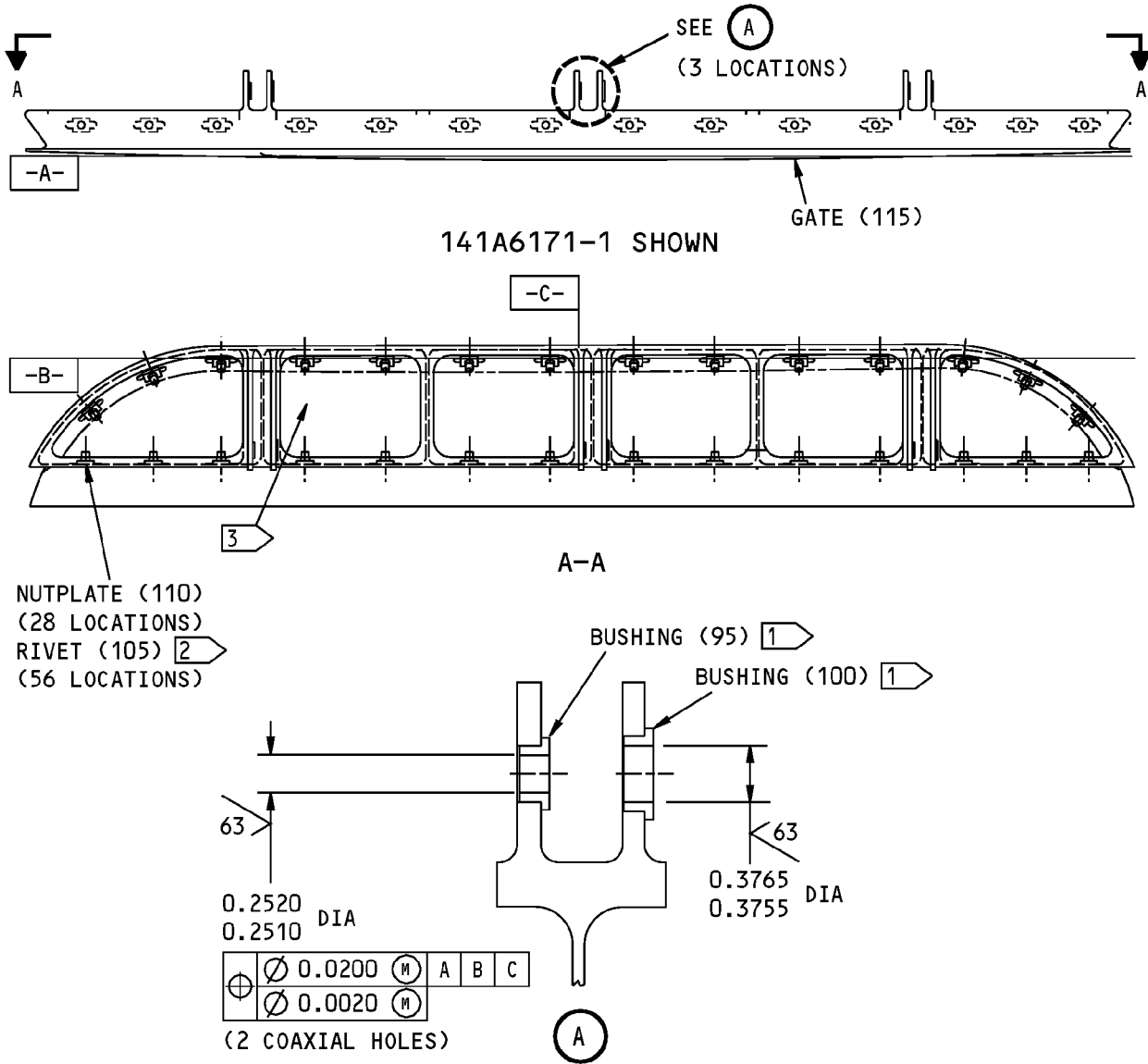
52-16-12

REPAIR 4-1

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- 1 INSTALL THIS BUSHING WITH WET BMS 5-95 SEALANT AND SHRINK-FIT PROCEDURE AS SPECIFIED IN SOPM 20-50-03
- 2 INSTALL THIS RIVET WITH BMS 5-95 SEALANT AS SPECIFIED IN SOPM 20-60-04
- 3 PART NUMBER IS FOUND HERE

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

141A6171-1,-5 Upper Gate Assembly Repair
Figure 601

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COMPONENT MAINTENANCE MANUAL

UPPER GATE - REPAIR 4-2

143A6171-2, -4

1. General

- A. This procedure has the data necessary to refinish the gate (115).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 shown in the repair.
- D. Refer to IPL Figure 3 for item numbers.
- E. General repair details:
 - (1) Material: Al alloy

2. Upper Gate Refinish

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

- B. References

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

- C. Procedure (REPAIR 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) Prepare the surface as specified in SOPM 20-30-02.
- (2) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31).
- (3) Apply primer, C00175 (F-19.66) to all surfaces but not in the holes for the bushings.

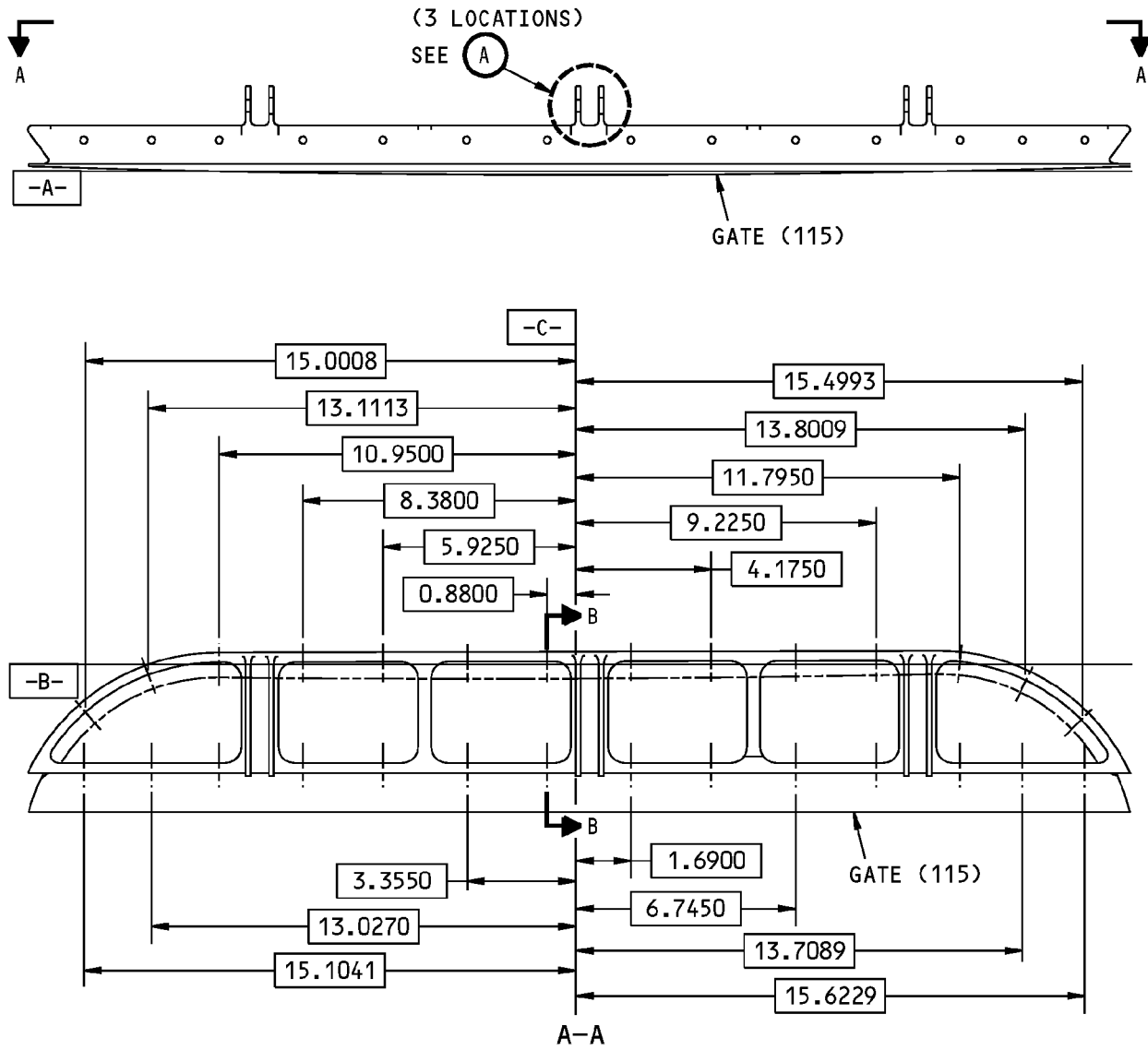
52-16-12

REPAIR 4-2

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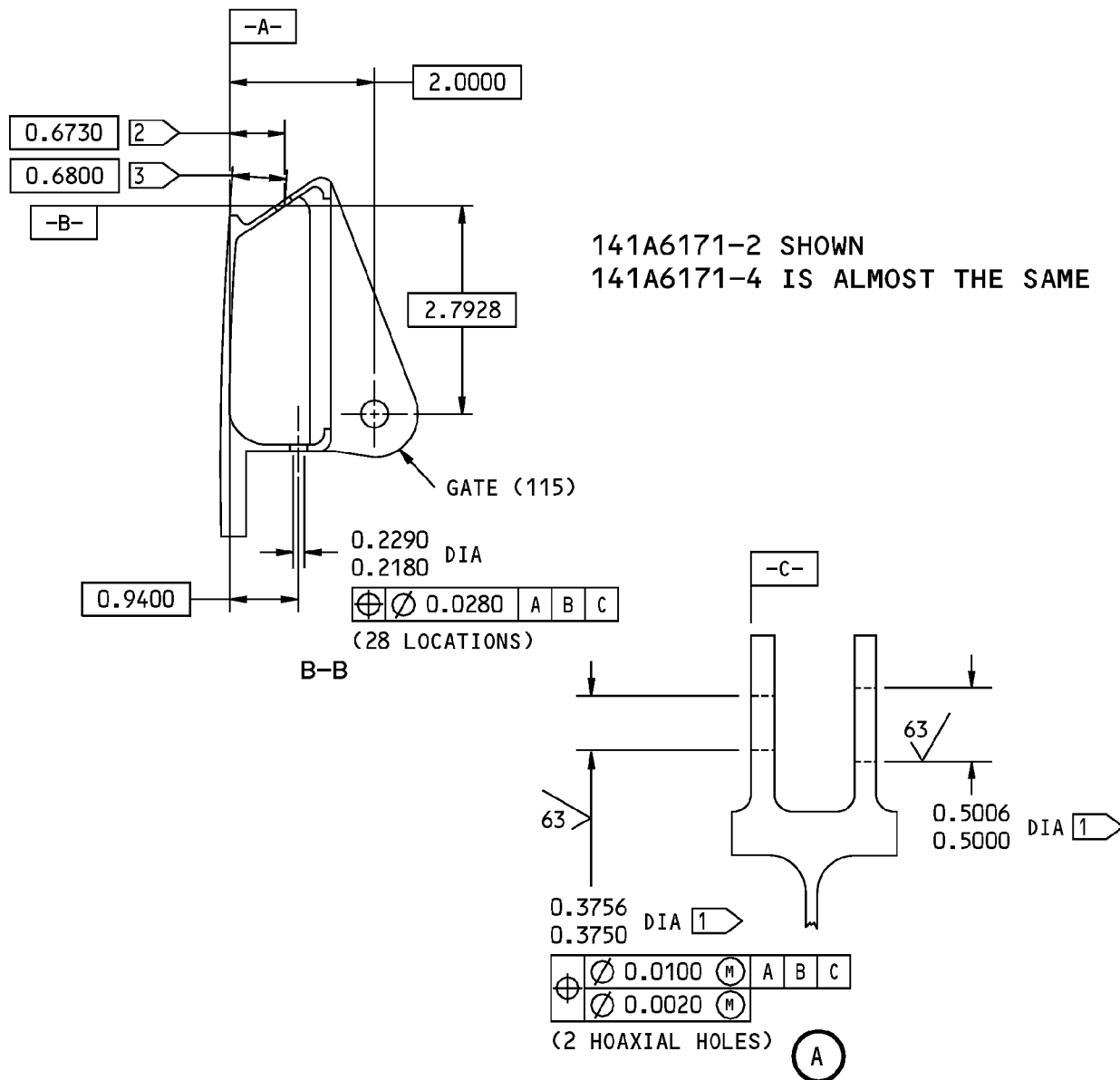


141A6171-2,-4 Gate Repair
Figure 601 (Sheet 1 of 2)

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REPAIR 4-2
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COMPONENT MAINTENANCE MANUAL



- 1 DO NOT PUT PRIMER AND ENAMEL FINISH IN THESE HOLES
- 2 141A6171-1
- 3 CONSTANT OFFSET FROM MDS 0.08 INCH OFFSET FOR 141A6171-5

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

141A6171-2,-4 Gate Repair
Figure 601 (Sheet 2 of 2)

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REPAIR 4-2
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COMPONENT MAINTENANCE MANUAL

LOWER GATE ASSEMBLY - REPAIR 5-1

141A6181-1, -5

1. General

- A. This procedure has the data necessary to repair the lower gate assembly (65).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 shown in the repair.
- D. Refer to IPL Figure 4 for item numbers.

2. Bushing Replacement

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

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

- (1) Remove the bushings (70, 75) from the lower gate (95).
- (2) Install the new bushings (70, 75) into the lower gate (95) with sealant, A00247 as specified in SOPM 20-50-03.

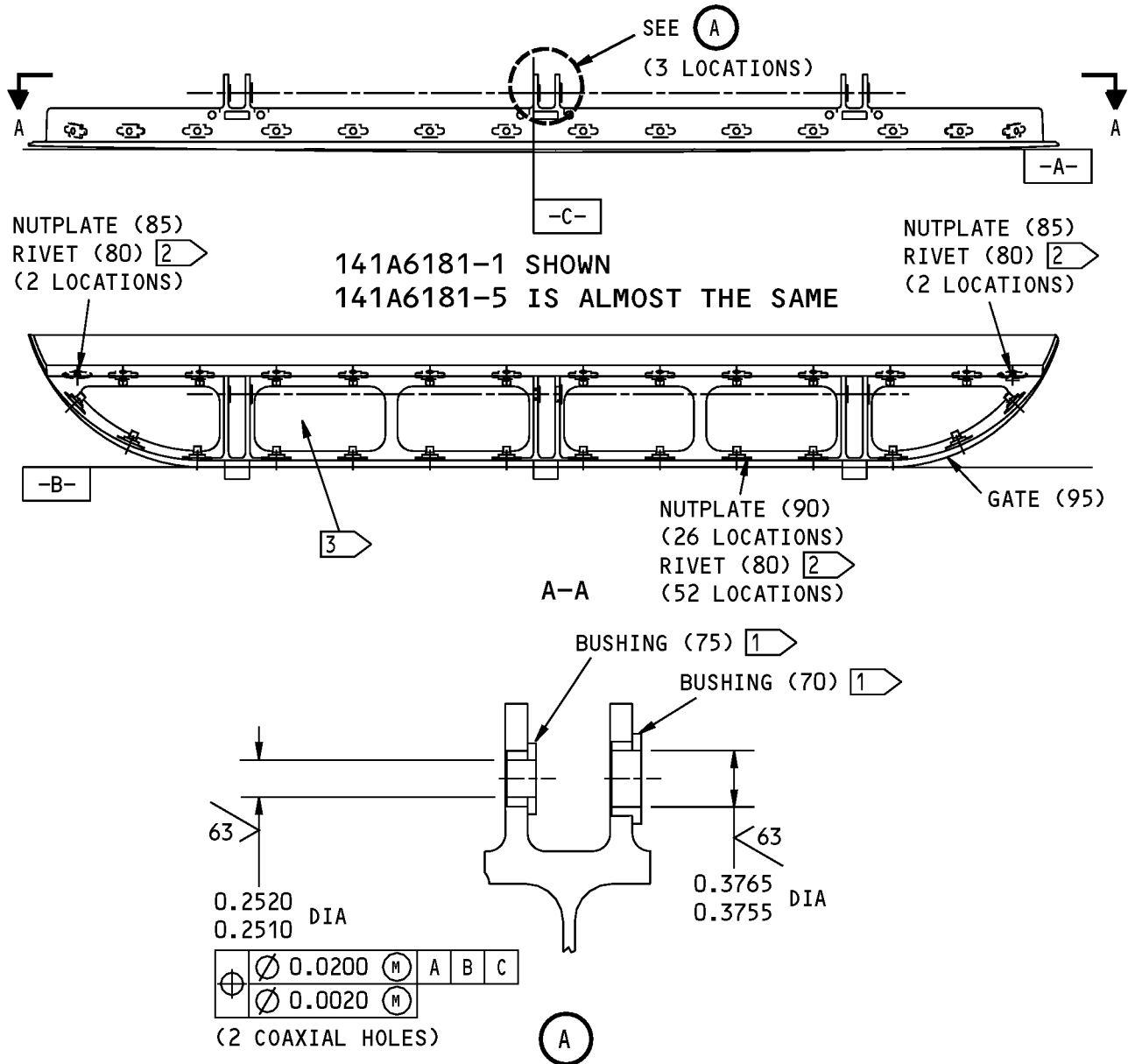
52-16-12

REPAIR 5-1

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- [1] INSTALL THIS BUSHING WITH WET BMS 5-95 SEALANT AND SHRINK-FIT PROCEDURE AS SPECIFIED IN SOPM 20-50-03
- [2] INSTALL THIS RIVET WITH BMS 5-95 SEALANT AS SPECIFIED IN SOPM 20-60-04
- [3] PART NUMBER IS FOUND HERE

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

141A6181-1,-5 Lower Gate Assembly Repair
Figure 601

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REPAIR 5-1
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COMPONENT MAINTENANCE MANUAL

LOWER GATE - REPAIR 5-2

141A6182-2, -4

1. General

- A. This procedure has the data necessary to refinish the lower gate (95).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 shown in the repair.
- D. Refer to IPL Figure 4 for item numbers.
- E. General repair details:
 - (1) Material: Al alloy

2. Lower Gate Refinish

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

- B. References

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

- C. Procedure (REPAIR 5-2, 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) Prepare the surface as specified in SOPM 20-30-02.
- (2) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31).
- (3) Apply primer, C00175 (F-19.66) to all surfaces but not in the holes for the bushings.

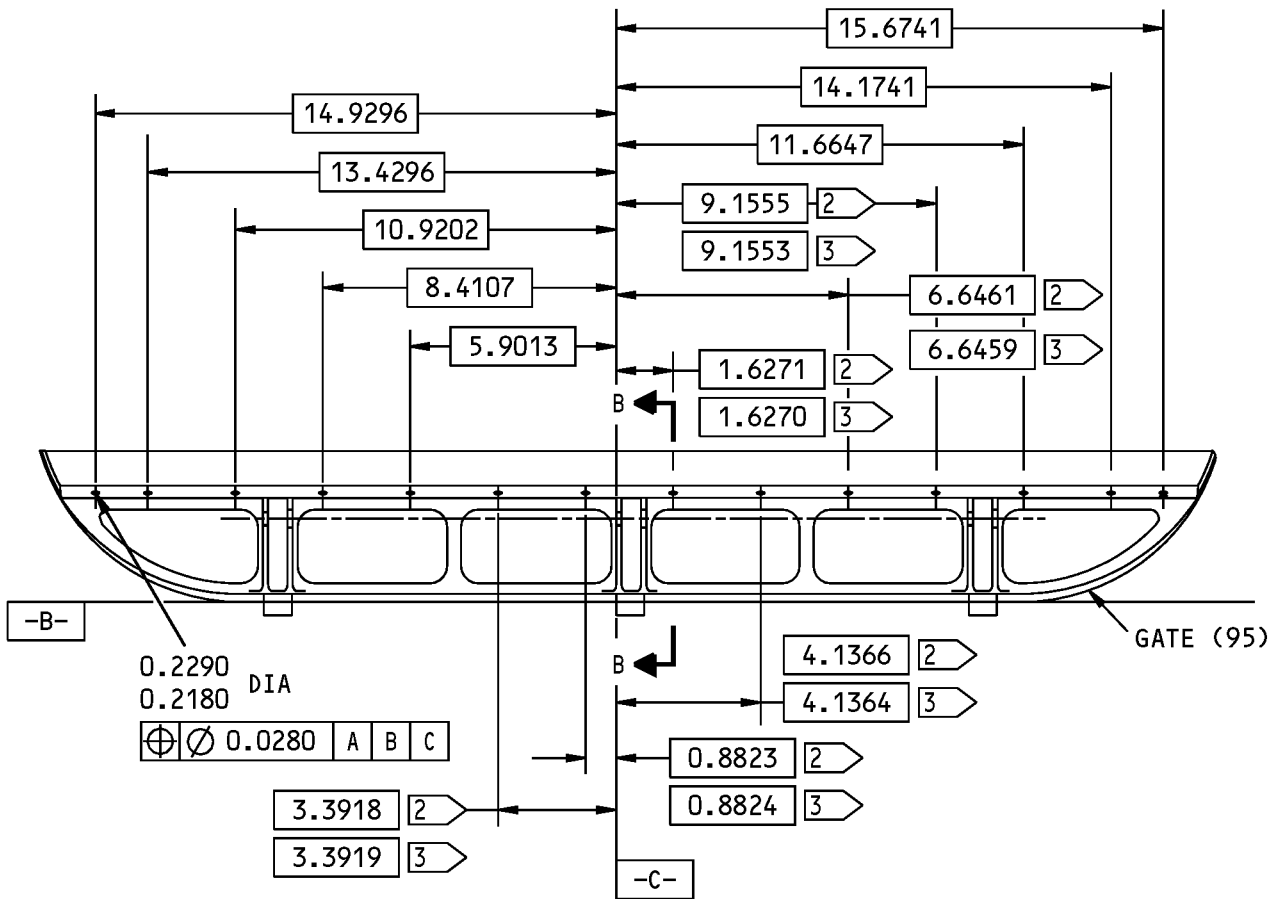
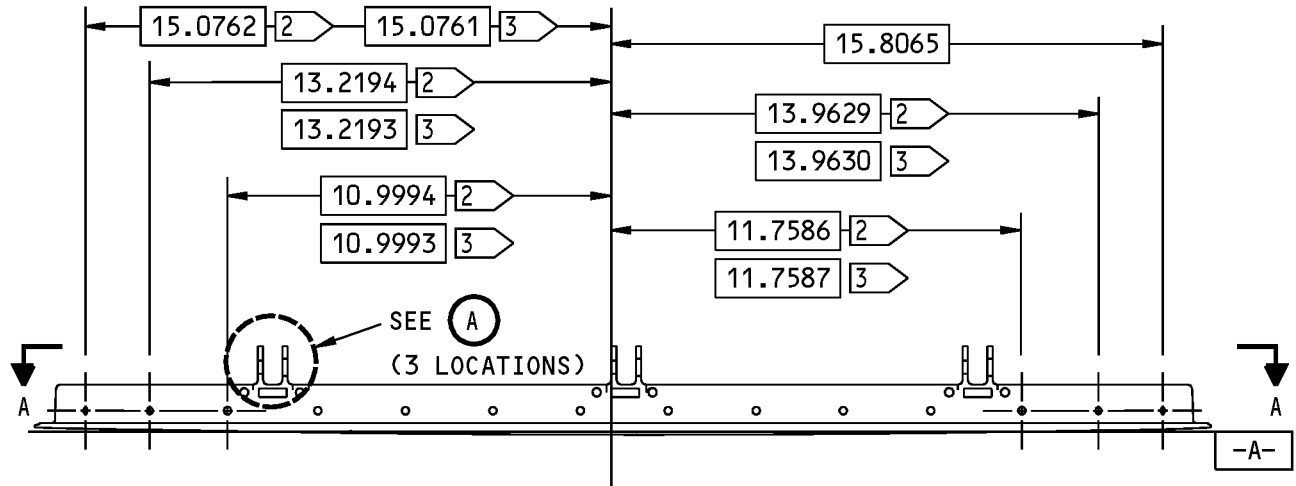
52-16-12

REPAIR 5-2

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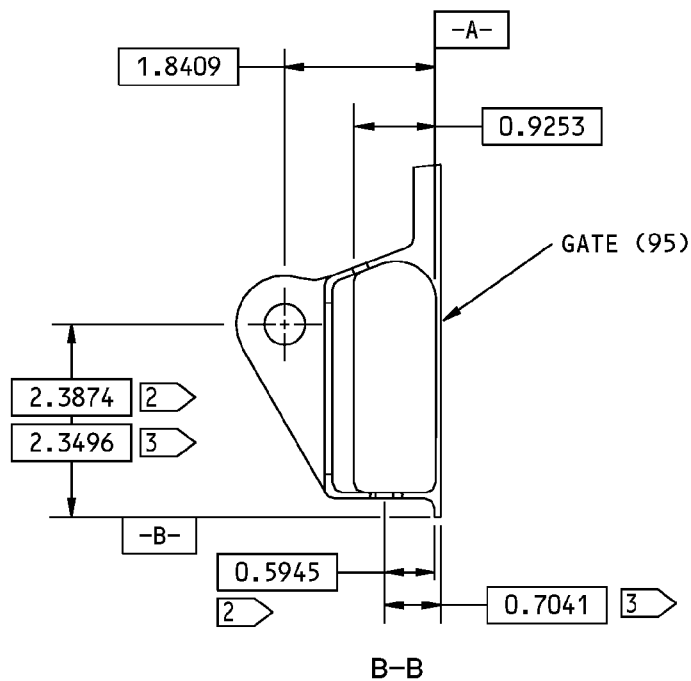
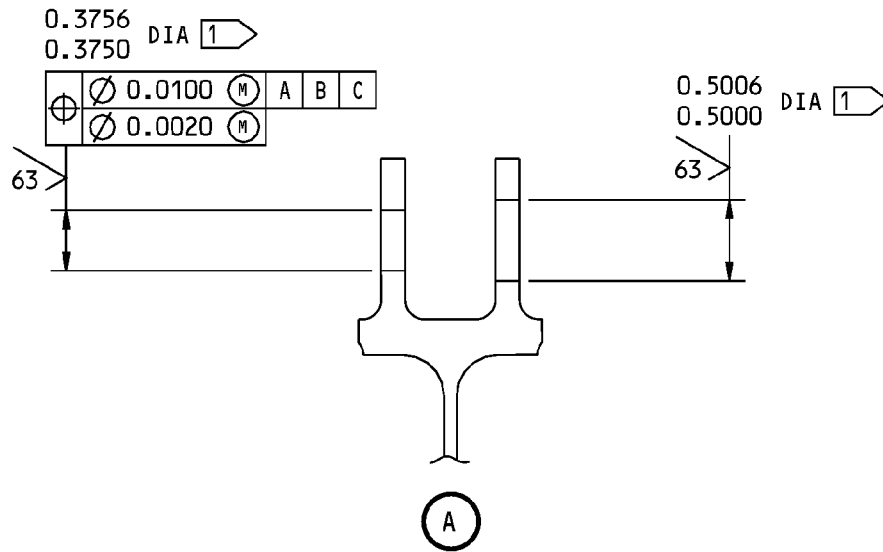
A-A

141A6181-1 SHOWN
 141A6181-5 IS ALMOST THE SAME

141A6181-1,-5 Lower Gate Repair
 Figure 601 (Sheet 1 of 2)

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COMPONENT MAINTENANCE MANUAL



- 1 DO NOT PUT ENAMEL IN THIS HOLE
- 2 141A6181-1
- 3 CONSTANT OFFSET FROM MDS 0.08 INCH OFFSET FOR 141A6181-5

125 ✓ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY
 BREAK ALL SHARP EDGES
 ITEM NUMBERS REFER TO IPL FIG. 4
 ALL DIMENSIONS ARE IN INCHES

141A6181-1,-5 Lower Gate Repair
 Figure 601 (Sheet 2 of 2)

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REPAIR 5-2
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COMPONENT MAINTENANCE MANUAL

SUPPORT FITTING ASSEMBLY - REPAIR 6-1

141A6221-1, -3, -5, -7

1. General

- A. This procedure has the data necessary to repair the support fitting assembly (30, 35, 40, 45).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 shown in the repair.
- D. Refer to IPL Figure 8 for item numbers.

2. Lube Fitting Replacement

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

| Reference | Description | Specification |
|-----------|--|---------------|
| A00247 | Sealant - Pressure And Environmental - Chromate Type | BMS 5-95 |
| D00633 | Grease - Aircraft General Purpose | BMS3-33 |

- B. References

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

- C. Procedure (REPAIR 6-1, Figure 601 and REPAIR 6-1, Figure 602)

NOTE: For lubricants, refer to SOPM 20-60-03. For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Remove the lube fitting (50) from the support fitting(s) (60, 65, 70, 75).
- (2) Install the new lube fitting (50) onto the support fitting(s) (60, 65, 70, 75) with sealant, A00247, as specified in SOPM 20-50-03.
- (3) Apply grease, D00633 into the lube fitting (50) until the grease, D00633 appears at the inside diameter of the support fitting(s) (60, 65, 70, 75) as specified in REPAIR 6-1, Figure 601 and REPAIR 6-1, Figure 602.

3. Bearing Replacement

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

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B. References

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

C. Procedure (REPAIR 6-1, Figure 601 and REPAIR 6-1, Figure 602)

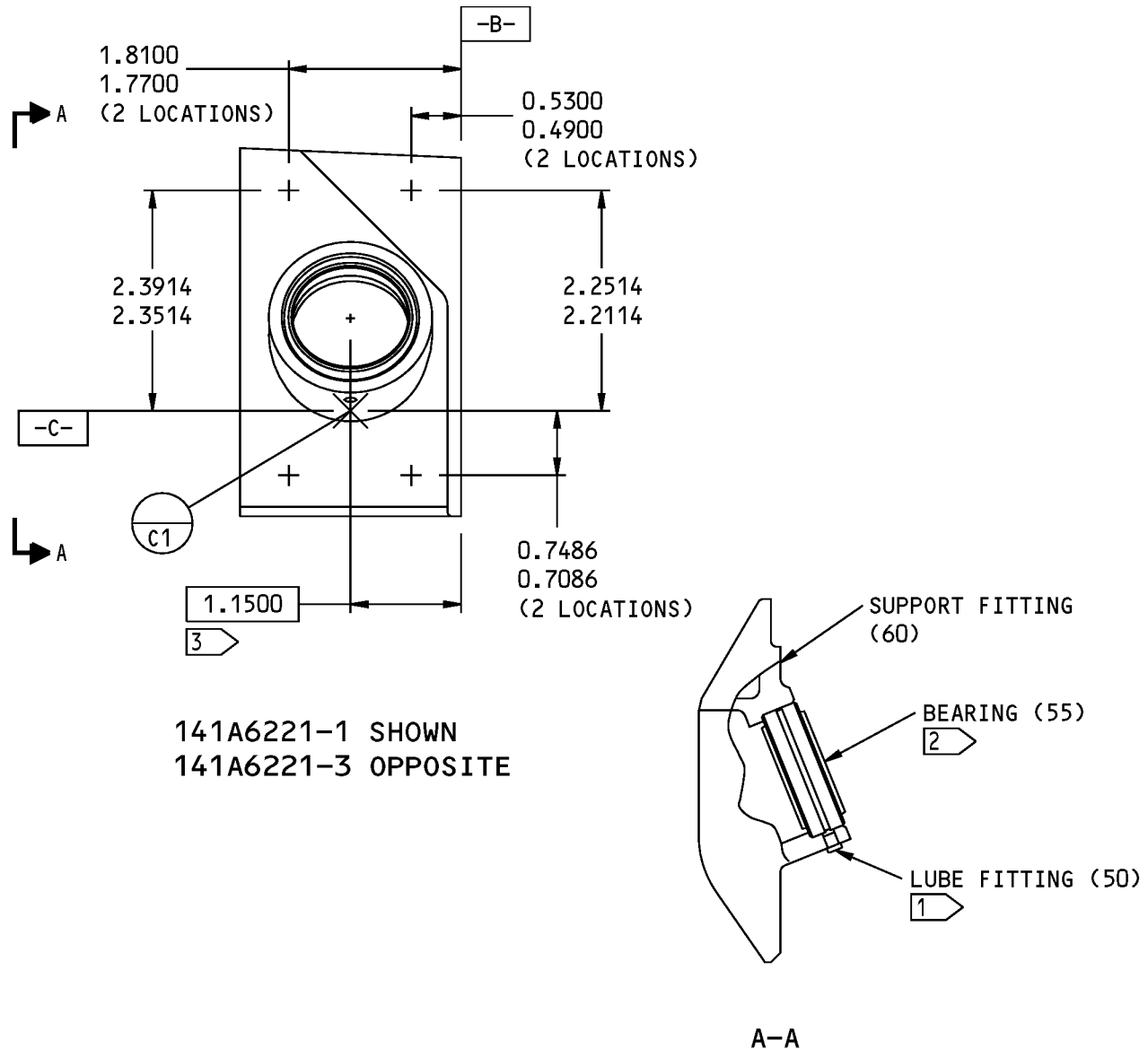
NOTE: For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Remove the bearing (55) from the support fitting(s) (60, 65, 70, 75).
- (2) Install the new bearing (55) onto the support fitting(s) (60, 65, 70, 75) with sealant, A00247, as specified in SOPM 20-50-03.

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COMPONENT MAINTENANCE MANUAL



- 1 APPLY BMS 3-33 GREASE INTO THE LUBE FITTING UNTIL GREASE APPEARS IN THE INSIDE DIAMETER OF THE SUPPORT FITTING
- 2 INSTALL THIS BEARING INTO THE SUPPORT FITTING WITH WET BMS 5-95 SEALANT AS SPECIFIED IN SOPM 20-50-03
- 3 GENERAL DIMENSION TOLERANCE DOES NOT APPLY HERE

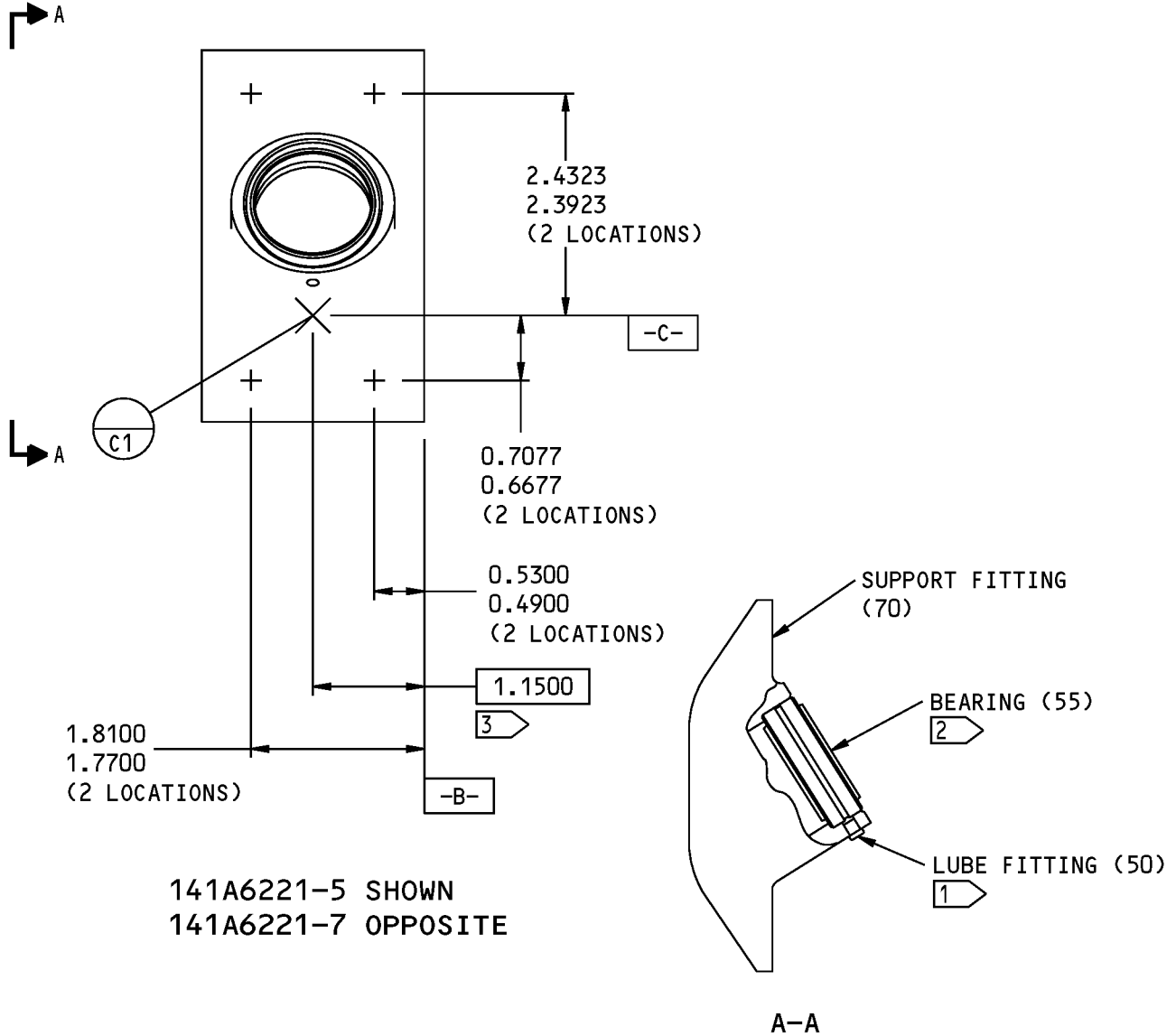
ITEM NUMBERS REFER TO IPL FIG. 8
ALL DIMENSIONS ARE IN INCHES

141A6221-1,-3 Support Fitting Assembly Repair
Figure 601

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REPAIR 6-1
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COMPONENT MAINTENANCE MANUAL



- 1 APPLY BMS 3-33 GREASE INTO THE LUBE FITTING UNTIL GREASE APPEARS IN THE INSIDE DIAMETER OF THE SUPPORT FITTING
- 2 INSTALL THIS BEARING INTO THE SUPPORT FITTING WITH WET BMS 5-95 SEALANT AS SPECIFIED IN SOPM 20-50-03
- 3 GENERAL DIMENSION TOLERANCES D0 NOT APPLY HERE

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

141A6221-5,-7 Support Fitting Assembly Repair
Figure 602

52-16-12

REPAIR 6-1
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COMPONENT MAINTENANCE MANUAL

SUPPORT FITTING - REPAIR 6-2

141A6221-2, -4, -6, -8

1. General

- A. This procedure has the data necessary to refinish the support fittings (60, 65, 70, 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 shown in the repair.
- D. Refer to IPL Figure 8 for item numbers.
- E. General repair details:
 - (1) Material: Al alloy

2. Support Fitting Refinish

- 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 |

- B. References

| Reference | Title |
|---------------|--|
| 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 20-60-02 | FINISHING MATERIALS |

- C. Procedure (REPAIR 6-2, Figure 601 thru REPAIR 6-2, Figure 604)

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) Prepare the surface as specified in SOPM 20-30-02.
- (2) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31).
- (3) Apply primer, C00259 (F-20.03) to all surfaces but not to the holes identified by flagnote 1 as specified in SOPM 20-41-02.

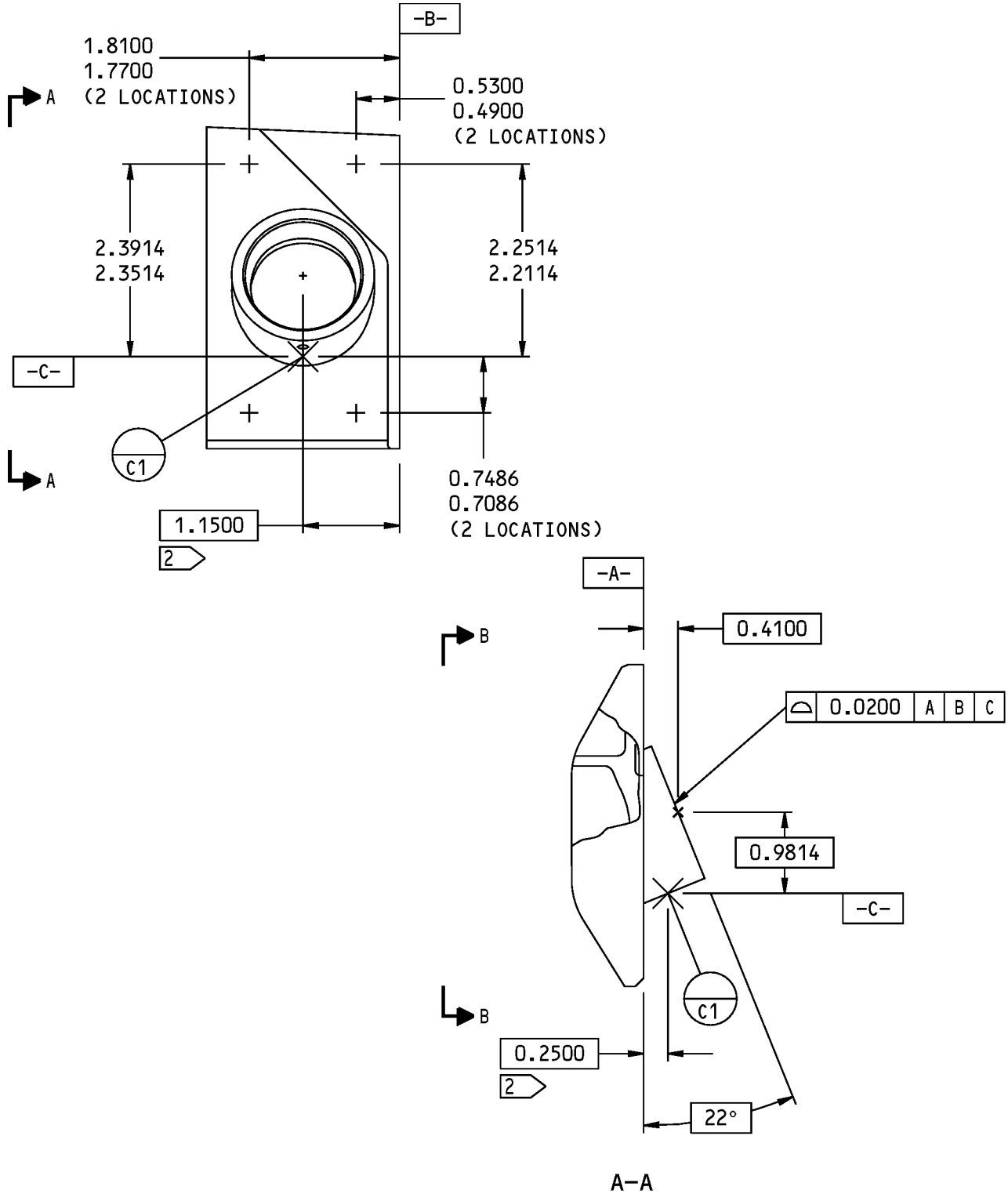
52-16-12

REPAIR 6-2

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COMPONENT MAINTENANCE MANUAL



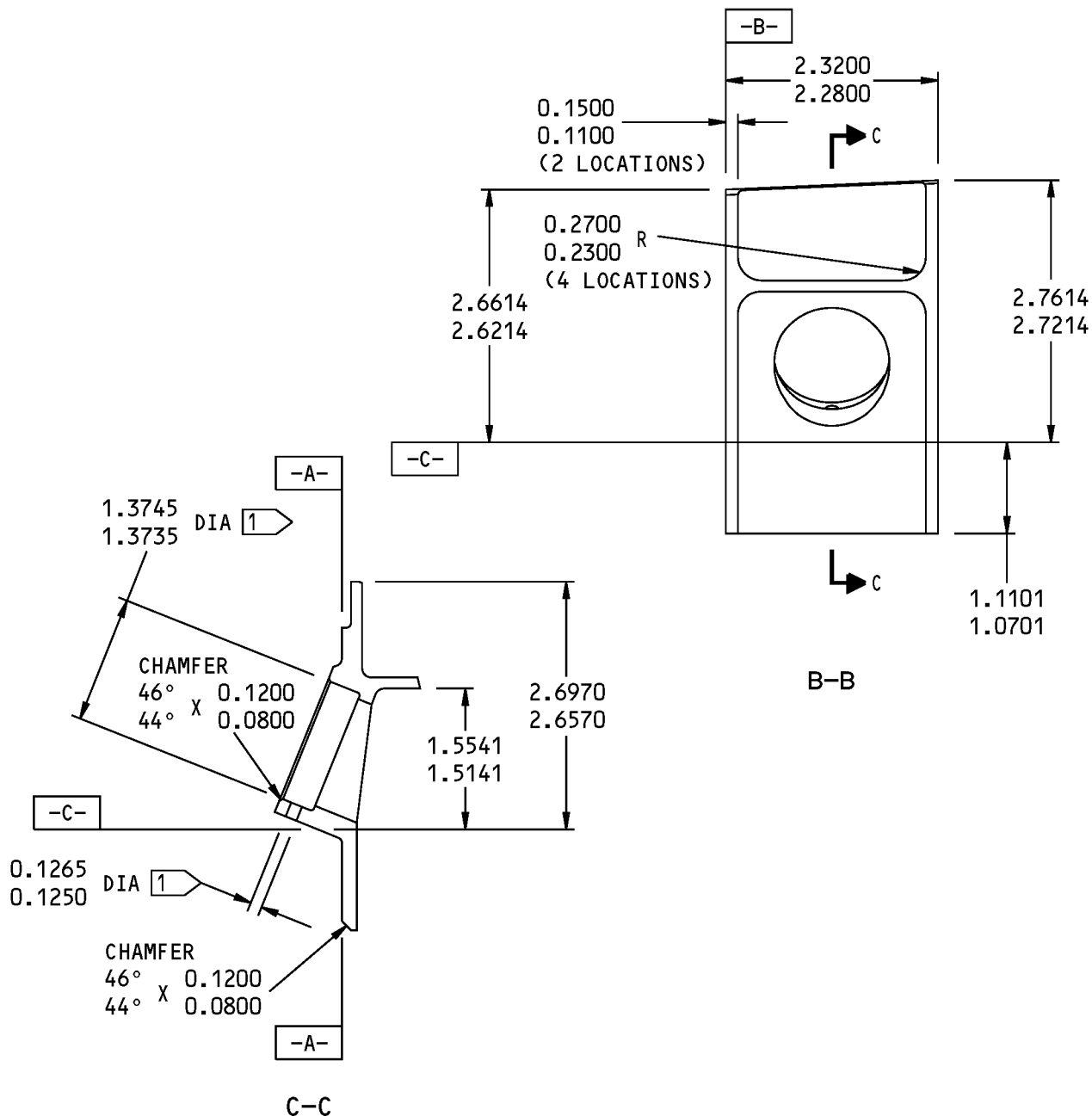
141A6221-2 Support Fitting Repair
Figure 601 (Sheet 1 of 2)

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REPAIR 6-2
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COMPONENT MAINTENANCE MANUAL



- 1 DO NOT PUT PRIMER HERE
- 2 GENERAL DIMENSION TOLERANCE DO NOT APPLY HERE

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBER REFER TO IPL FIG. 8

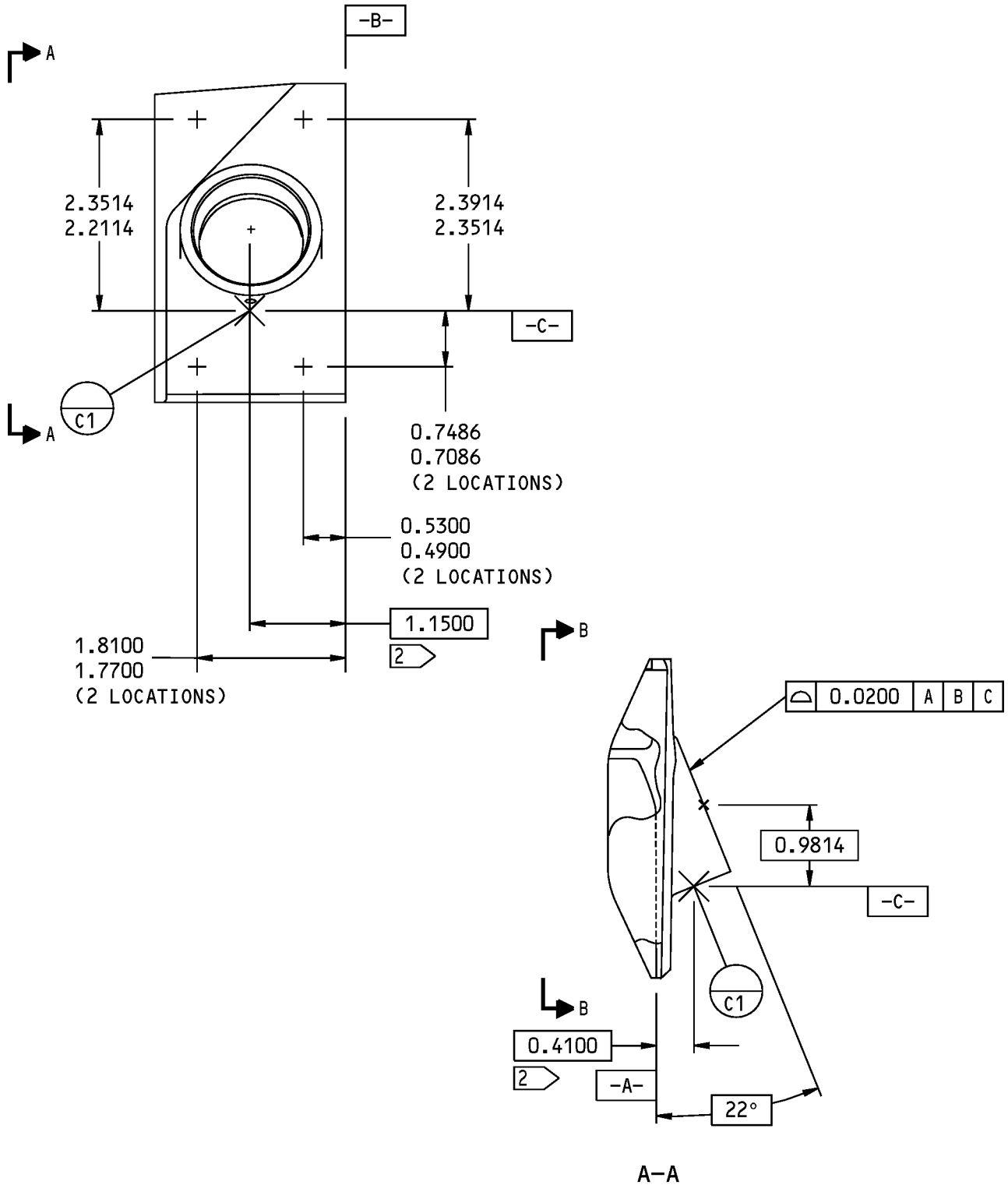
ALL DIMENSIONS ARE IN INCHES

141A6221-2 Support Fitting Repair
Figure 601 (Sheet 2 of 2)

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REPAIR 6-2
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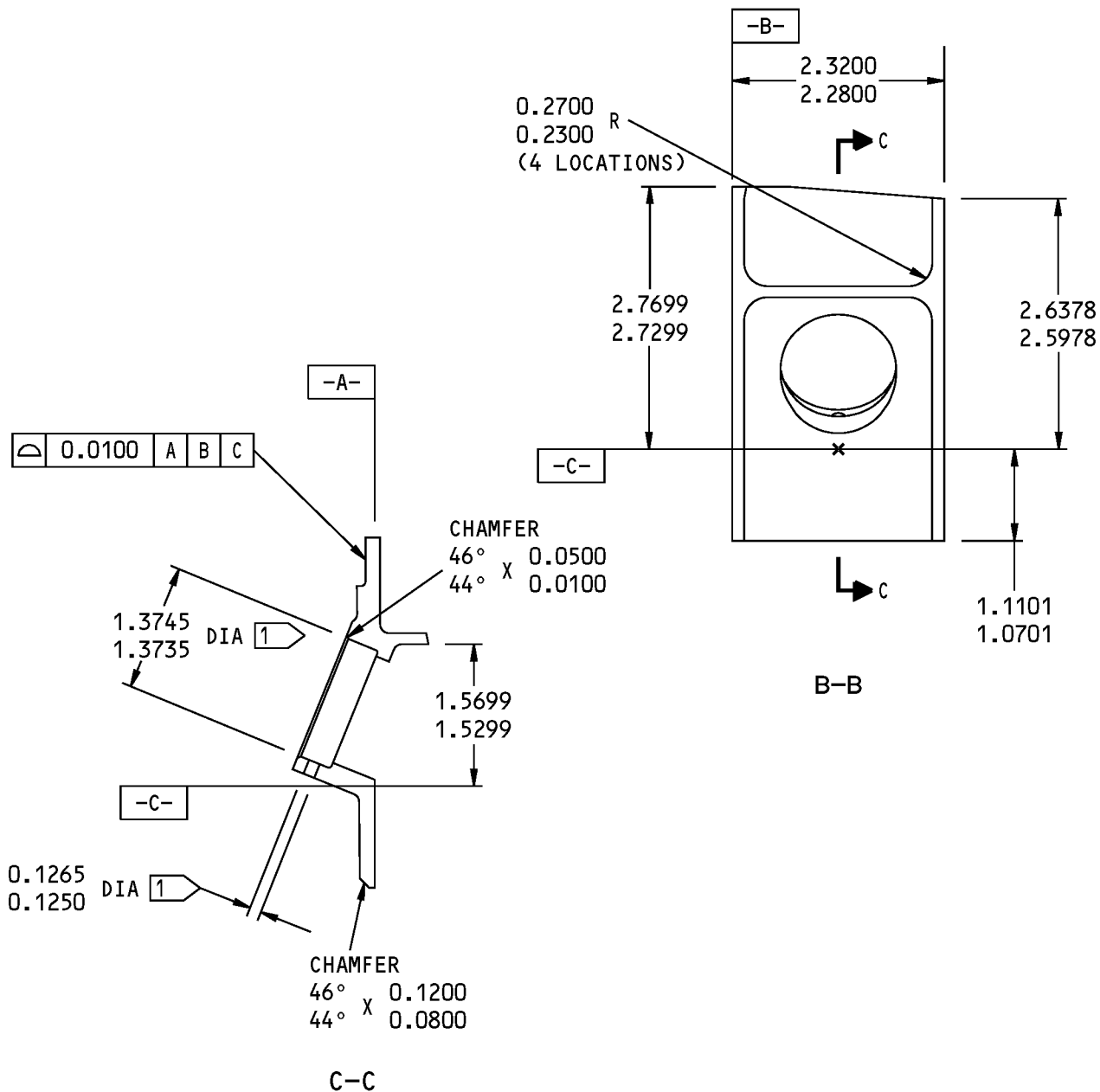


141A6221-4 Support Fitting Repair
Figure 602 (Sheet 1 of 2)

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REPAIR 6-2
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COMPONENT MAINTENANCE MANUAL



- 1 DO NOT PUT PRIMER HERE
- 2 GENERAL DIMENSION TOLERANCE DO NOT APPLY HERE

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBER REFER TO IPL FIG. 8

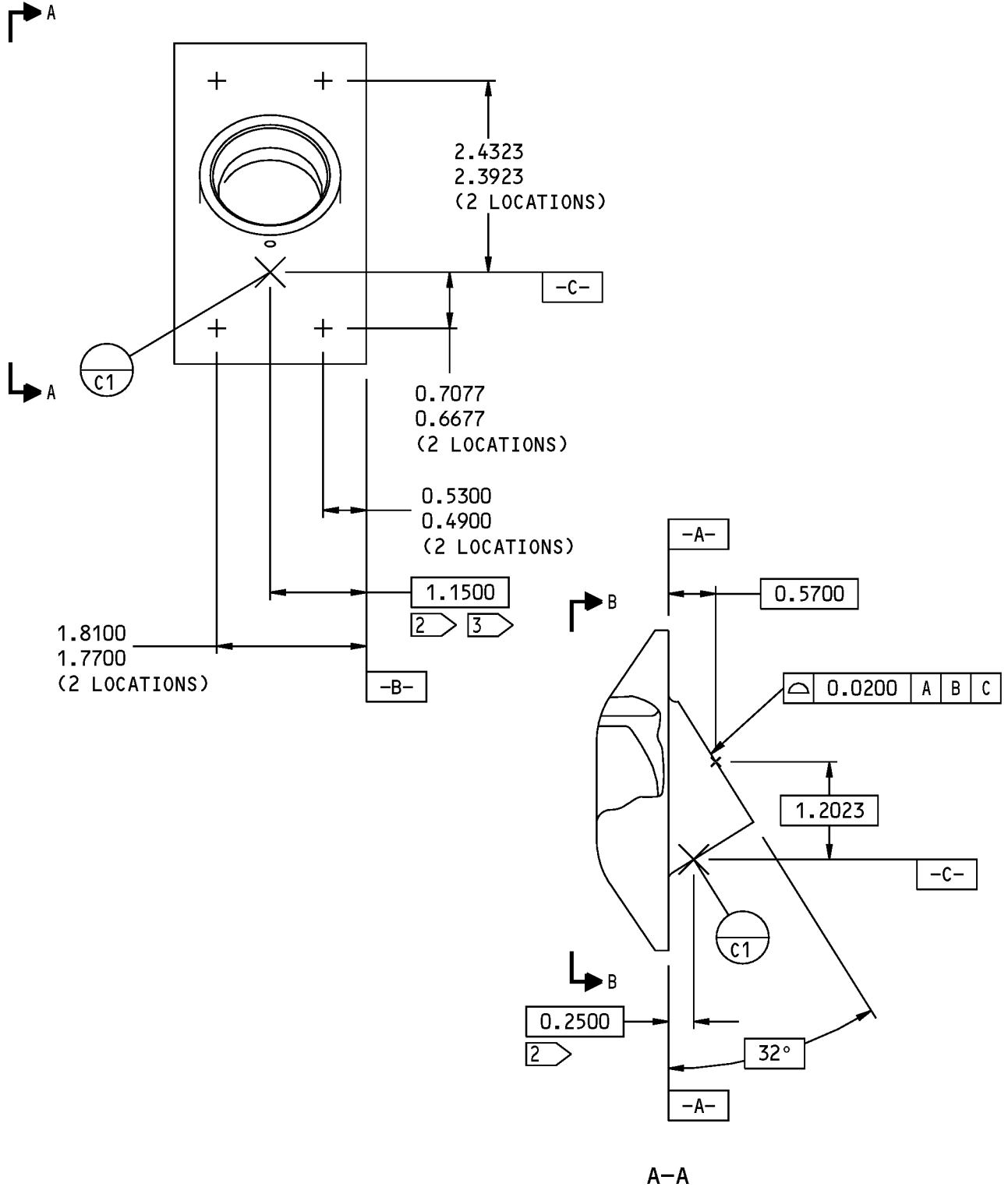
ALL DIMENSIONS ARE IN INCHES

141A6221-4 Support Fitting Repair
Figure 602 (Sheet 2 of 2)

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REPAIR 6-2
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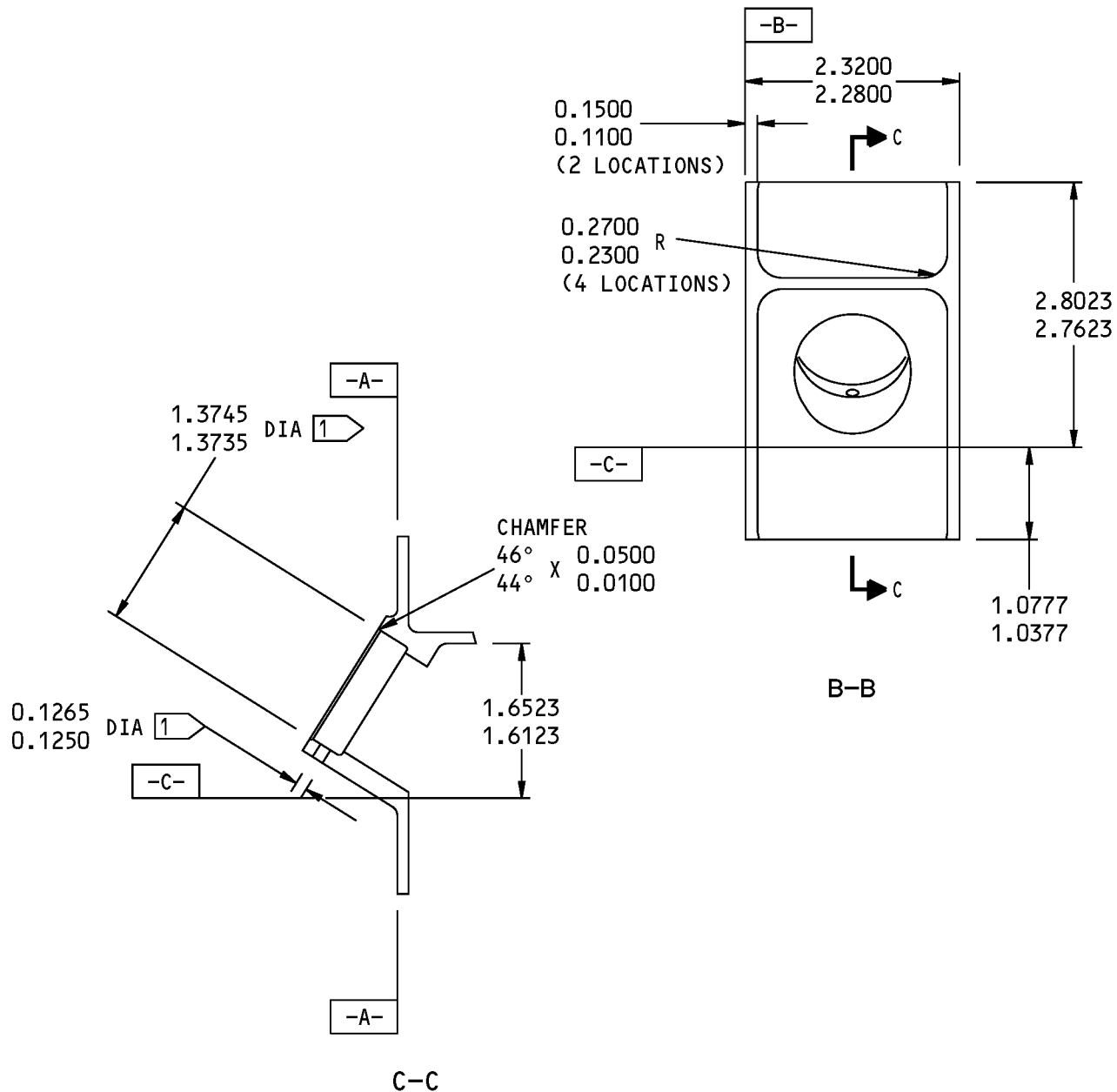
COMPONENT MAINTENANCE MANUAL



141A6221-6 Support Fitting Repair
Figure 603 (Sheet 1 of 2)

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COMPONENT MAINTENANCE MANUAL



- 1 DO NOT PUT PRIMER HERE
- 2 GENERAL DIMENSION TOLERANCE DO NOT APPLY HERE

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBER REFER TO IPL FIG. 8

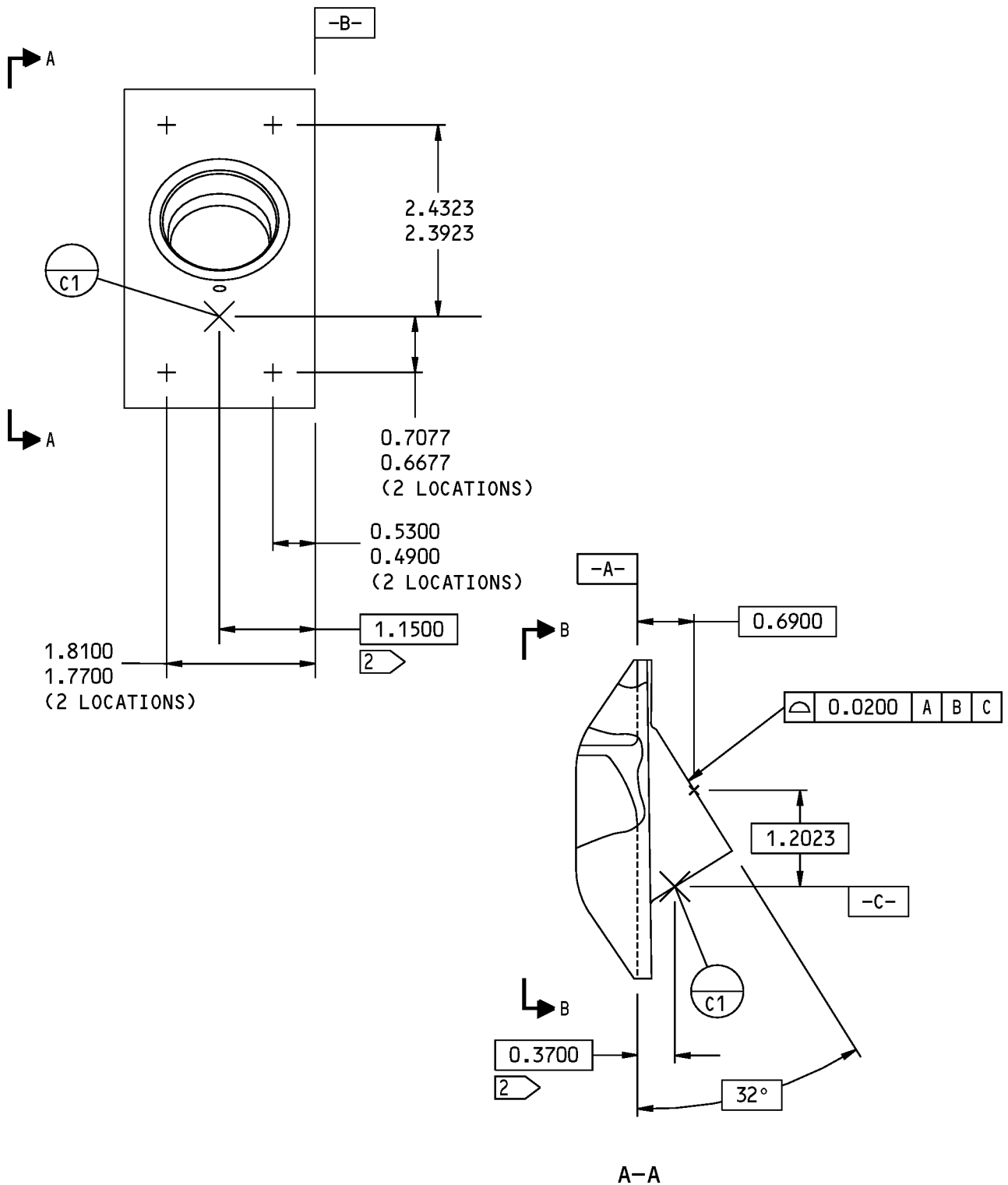
ALL DIMENSIONS ARE IN INCHES

141A6221-6 Support Fitting Repair
Figure 603 (Sheet 2 of 2)

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REPAIR 6-2
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COMPONENT MAINTENANCE MANUAL

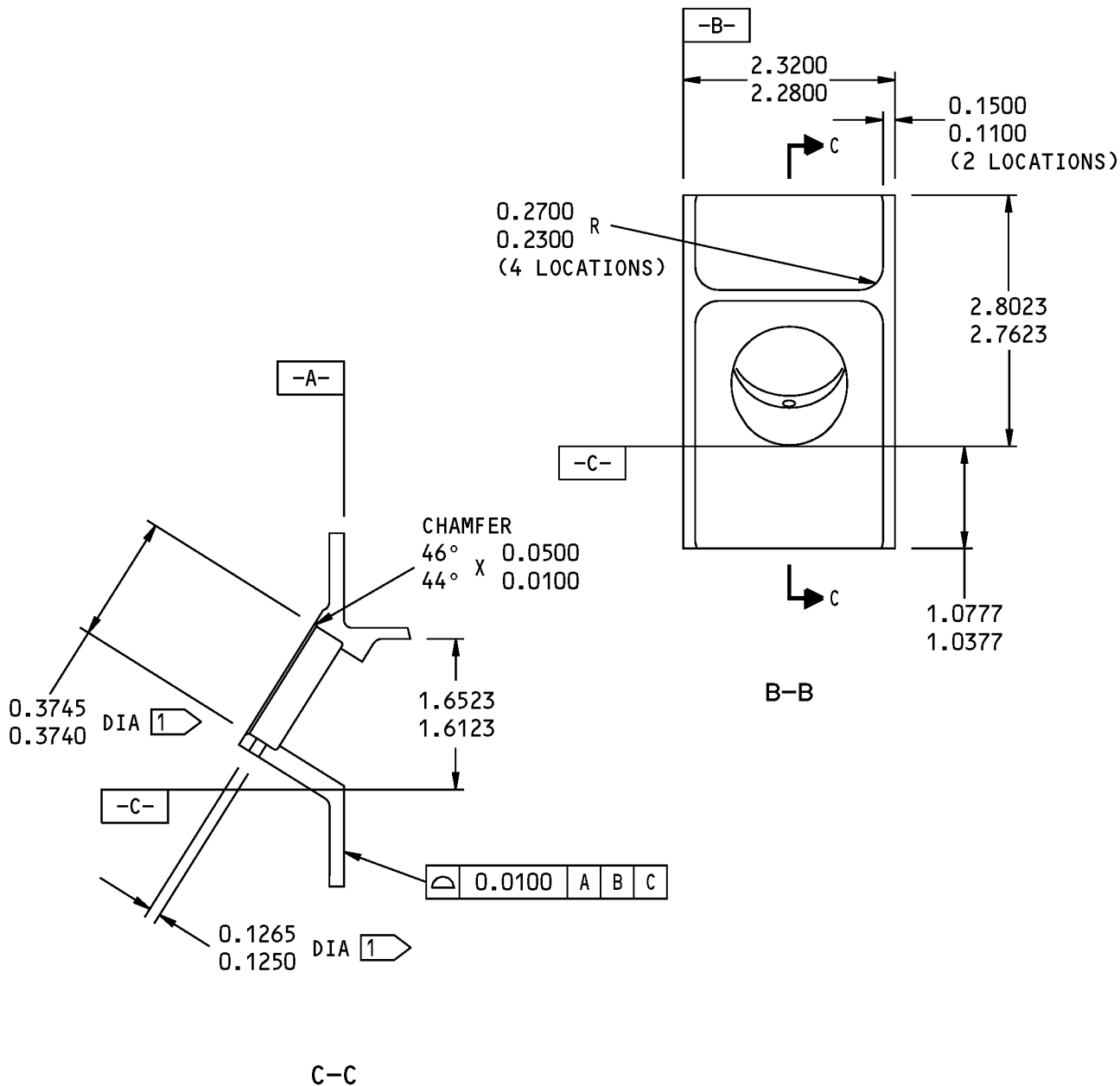


141A6221-8 Support Fitting Repair
Figure 604 (Sheet 1 of 2)

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COMPONENT MAINTENANCE MANUAL



- 1 DO NOT PUT PRIMER HERE
- 2 GENERAL DIMENSION TOLERANCE DO NOT APPLY HERE

- 125 ✓ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY
- BREAK ALL SHARP EDGES
- ITEM NUMBER REFER TO IPL FIG. 8
- ALL DIMENSIONS ARE IN INCHES

141A6221-8 Support Fitting Repair
Figure 604 (Sheet 2 of 2)

52-16-12

REPAIR 6-2
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COMPONENT MAINTENANCE MANUAL

CAM PLATE ASSEMBLY - REPAIR 7-1

141A6310-3, -5, -7

1. General

- A. This procedure tells how to repair the cam plate assembly (20).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 shown in the repair.
- D. Refer to IPL Figure 12 for item numbers.
- E. General repair details:
 - (1) Material: Aluminum Alloy

2. Insert Replacement

- 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 |

- B. References

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

- C. Procedure (REPAIR 7-1, 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) Remove the insert(s) (25) from the camplate (30).
- (2) Apply primer, C00259 (F-20.20) to all surfaces of the hole for the insert(s) as identified by flagnote 1 in REPAIR 7-1, Figure 601.
- (3) Immediately install the new insert(s) (25) onto the camplate (30).

52-16-12

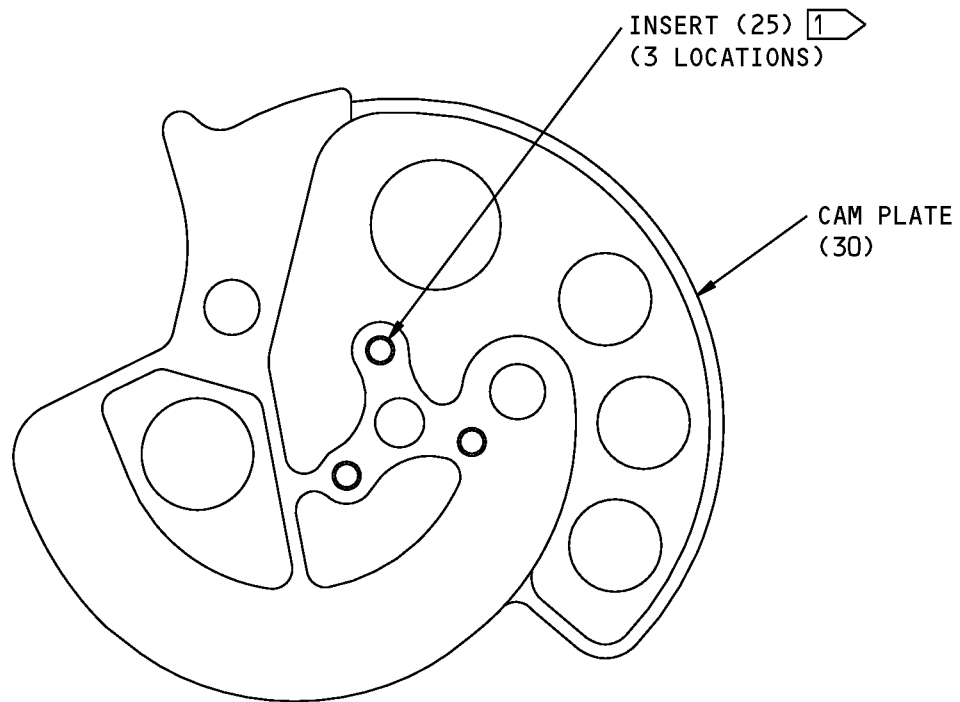
REPAIR 7-1

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COMPONENT MAINTENANCE MANUAL



1 APPLY WET BMS 10-11, TYPE 1 PRIMER (F-20.20) TO ALL AREAS OF THE HOLE. THIS INCLUDES THE COUNTERSINK, COUNTERBORE OR OTHER RECESS, AND IMMEDIATELY INSTALL THE INSERT

ITEM NUMBER REFER TO IPL FIG. 12

141A6310-3,-5,-7 Cam Plate Assembly Repair
Figure 601

52-16-12

REPAIR 7-1
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COMPONENT MAINTENANCE MANUAL

CAMPLATE - REPAIR 7-2

141A6310-4, -6, -8

1. General

- A. This procedure has the data necessary to refinish the camplate (30).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 shown in the repair.
- D. Refer to IPL Figure 12 for item numbers.
- E. General repair details:
 - (1) Material: Al alloy

2. Camplate Refinish

- 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 |

- B. References

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

- C. Procedure (REPAIR 7-2, 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) For the 141A6310-4 camplate:
 - (a) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.35) all surfaces, but not those identified by flagnote 1.
 - (b) Hard anodize (F-17.06) the surfaces identified by flagnote 1.
 - (c) Apply primer, C00259 (F-20.03) to all surfaces, but not the threaded holes, spline surfaces, or the surfaces identified by flagnotes 1 and 4.
- (2) For the 141A6310-6, -8 camplate:
 - (a) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.35) all surfaces.
 - (b) Apply primer, C00259 (F-20.03) to all surfaces but not in the threaded holes, spline surfaces, or the areas identified by flagnote 4.

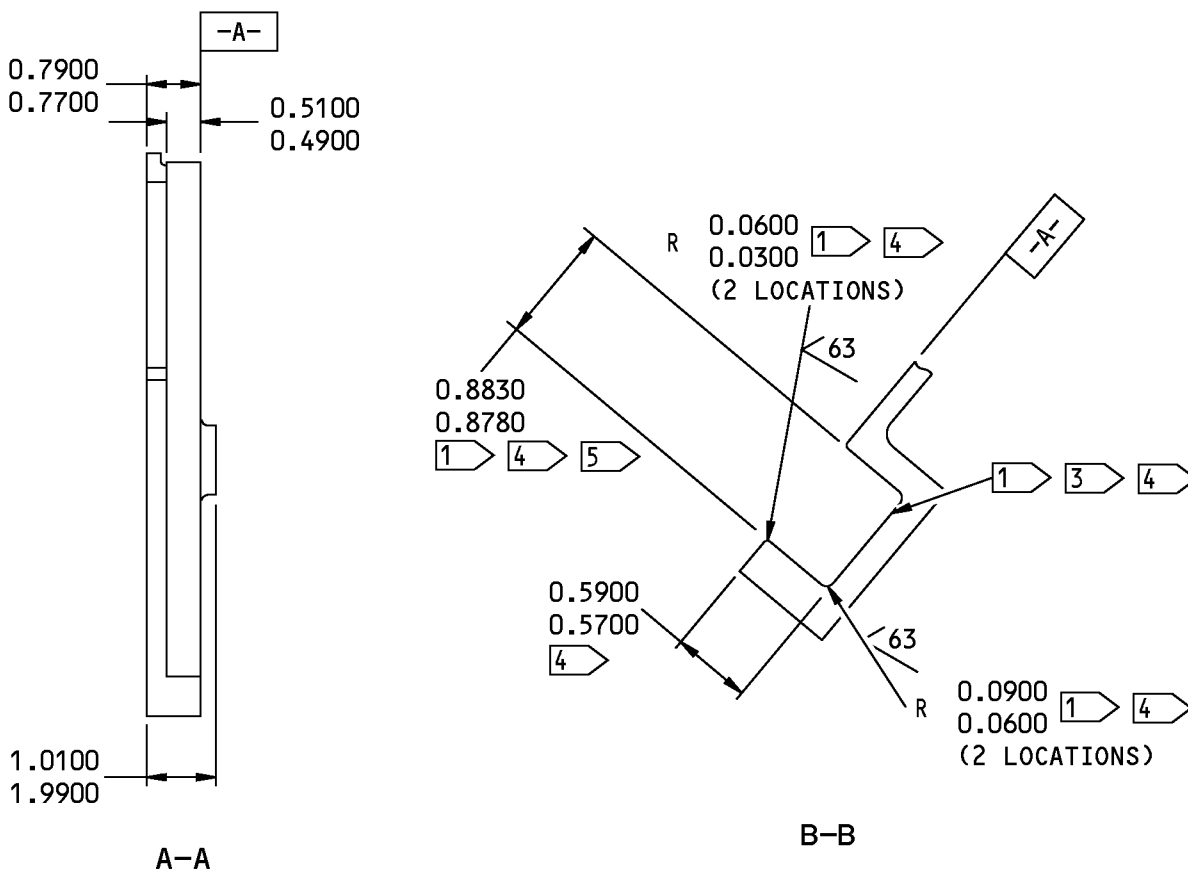
52-16-12

REPAIR 7-2

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COMPONENT MAINTENANCE MANUAL



- 1 FOR 141A6310-4 ONLY:
HARD ANODIZE (F-17.06) 0.001-0.003
INCH THICK ON THIS SURFACE
- 2 THE CENTER OF RADIUS MAY VARY
0.005 INCH FROM THE GROOVE
- 3 FOR 141A6310-4 ONLY:
AS-ANODIZED ROUGHNESS IS
ACCEPTABLE ON THIS SURFACE
- 4 NO PRIMER ON THIS SURFACE
- 5 16 FOR 141A6310-4;
32 FOR 141A6310-6,-8

125 ALL MACHINED SURFACES UNLESS
SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 12

ALL DIMENSIONS ARE IN INCHES

H04734 S00041000562_V2

141A6310-4,-6,-8 Cam Plate Repair
Figure 601 (Sheet 2 of 2)

52-16-12

REPAIR 7-2

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COMPONENT MAINTENANCE MANUAL

HOUSING ASSEMBLY - REPAIR 8-1

141A6304-1

1. General

- A. This procedure has the data necessary to repair the housing assembly (370).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 shown in the repair.
- D. Refer to IPL Figure 12 for item numbers.

2. Bushing Replacement

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

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

- (1) Remove the bushing(s) (400) from the housing (415).
- (2) Install the new bushing(s) (400) into the housing (415) with sealant, A00247 by shrink-fit procedure as specified in SOPM 20-50-03 .

3. Nutplate Replacement

- 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 20-41-01 | DECODING TABLE FOR BOEING FINISH CODES |
| SOPM 20-60-04 | MISCELLANEOUS MATERIALS |

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

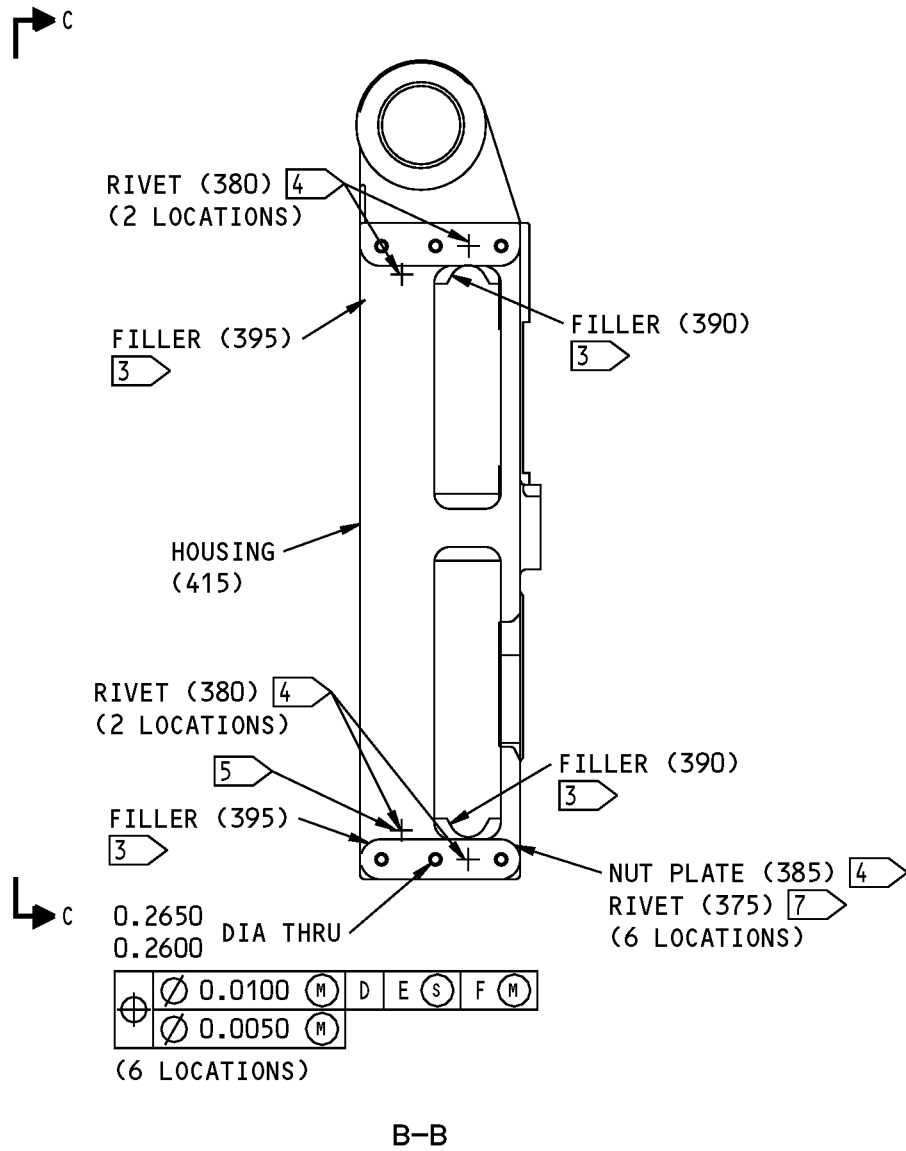
NOTE: For decoding table for Boeing finish codes, refer to SOPM 20-41-01. For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Remove the rivet(s) (375, 405) and the damaged nutplate(s) (385, 410) from the housing (415).
- (2) If necessary, replace the filler(s) (390, 395) as follows:
 - (a) Remove the rivet(s) (380) and the filler(s) (390, 395).
 - (b) Apply sealant, A00247 to the faying surface of the filler(s) (390, 395) and the housing (415) as specified by flagnote 3.
 - (c) Make sure to fill the spaces between the filler radius and the housing (415).
 - (d) Install the rivet(s) (380) with wet sealant, A00247 (F-19.48) as identified by flagnote 7.
 - (e) Obey flagnote 5.
- (3) Install the new nutplate(s) (385, 415) and the rivet(s) (375, 465) with wet sealant, A00247 (F-19.65 and F-19.48) as identified by flagnotes 4 and 7.

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REPAIR 8-1
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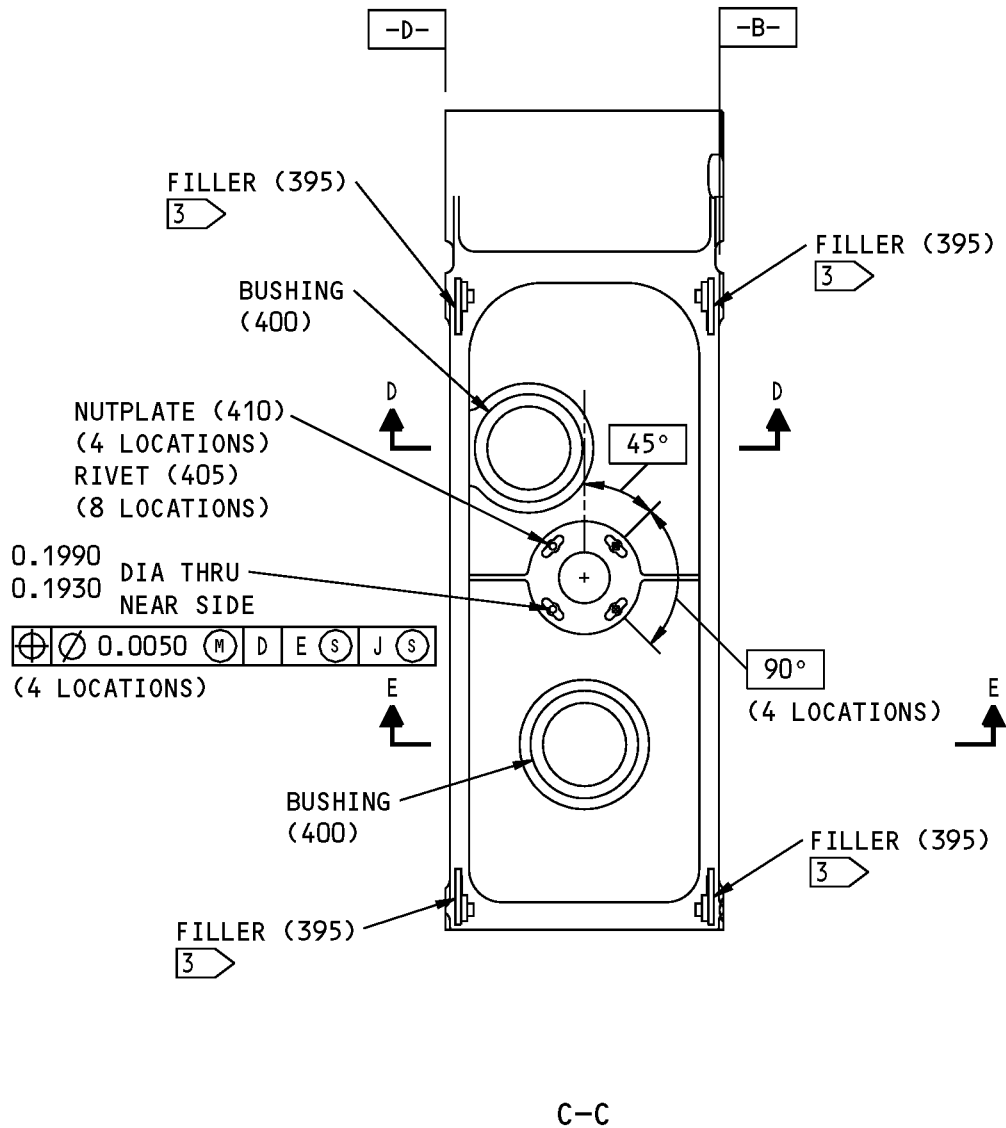


141A6304-1 Housing Assembly Repair
Figure 601 (Sheet 2 of 5)

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REPAIR 8-1
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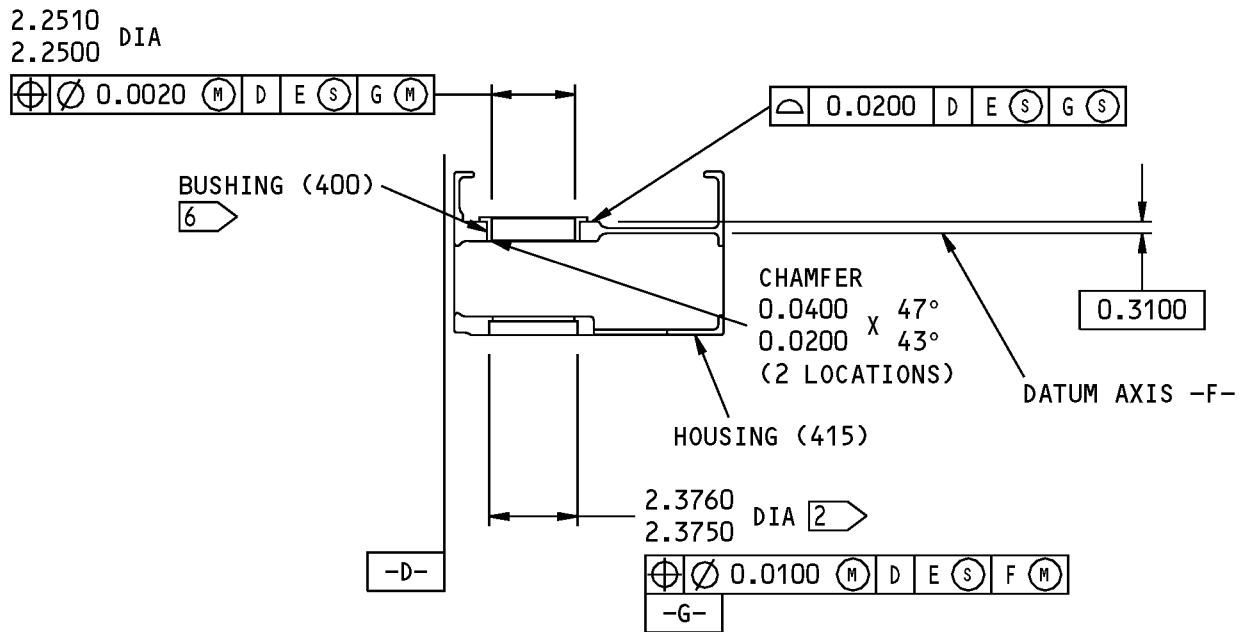


141A6304-1 Housing Assembly Repair
Figure 601 (Sheet 3 of 5)

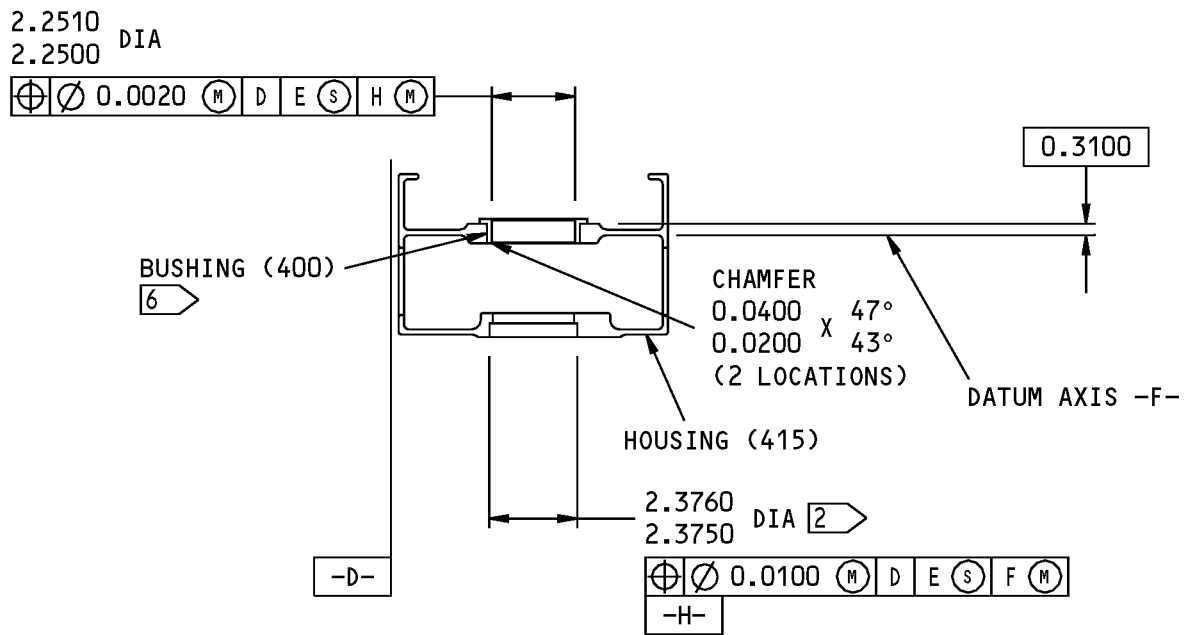
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REPAIR 8-1
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D-D



E-E

141A6304-1 Housing Assembly Repair
Figure 601 (Sheet 4 of 5)

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REPAIR 8-1
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COMPONENT MAINTENANCE MANUAL

- 1 RUBBER STAMPED LETTERS 'MAG' IS FOUND HERE
- 2 DO NOT PUT PRIMER OR ENAMEL IN THIS BEARING HOLE
- 3 INSTALL THIS FILLER WITH WET BMS 5-95 SEALANT AS SPECIFIED IN SOPM 20-60-04
- 4 INSTALL THIS NUTPLATE WITH WET BMS 5-95 SEALANT AS SPECIFIED IN SOPM 20-60-04
- 5 THIS RIVET TO BE FLUSHED WITH CASTING SURFACE TO 0.0000-0.0100 INCHES
- 6 INSTALL THIS BUSHING WITH WET BMS 5-95 SEALANT AND SHRINK FIT PROCEDURE AS SPECIFIED IN SOPM 20-60-04
- 7 INSTALL THIS RIVETS WITH WET BMS 5-95 SEALANT (F-19.48) PROCEDURE

ITEM NUMBERS REFER TO IPL FIG. 12
ALL DIMENSIONS ARE IN INCHES

141A6304-1 Housing Assembly Repair
Figure 601 (Sheet 5 of 5)

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REPAIR 8-1
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COMPONENT MAINTENANCE MANUAL

HOUSING - REPAIR 8-2

141A6304-2

1. General

- A. This procedure has the data necessary to refinish the housing (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 shown in the repair.
- D. Refer to IPL Figure 12 for item numbers.
- E. General repair details:
 - (1) Material: Magnesium alloy

2. Housing Refinish

- 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 |
| 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 20-50-10 | APPLICATION OF STENCILS, INSIGNIA, SILK SCREEN, PART NUMBERING AND IDENTIFICATION MARKINGS |
| SOPM 20-60-02 | FINISHING MATERIALS |

- C. Procedure (REPAIR 8-2, 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) Anodize (F-17.12).
- (2) Apply primer, C00259 (F-20.03) to all surfaces but not the surface identified by flagnote 2.
- (3) Apply enamel coating, C00700 (SRF-14.9813) to all surfaces but not the surface identified by flagnote 2.
- (4) Rubber stamp the letters "MAG" at the location identified by flagnote 1 as specified in SOPM 20-50-10.

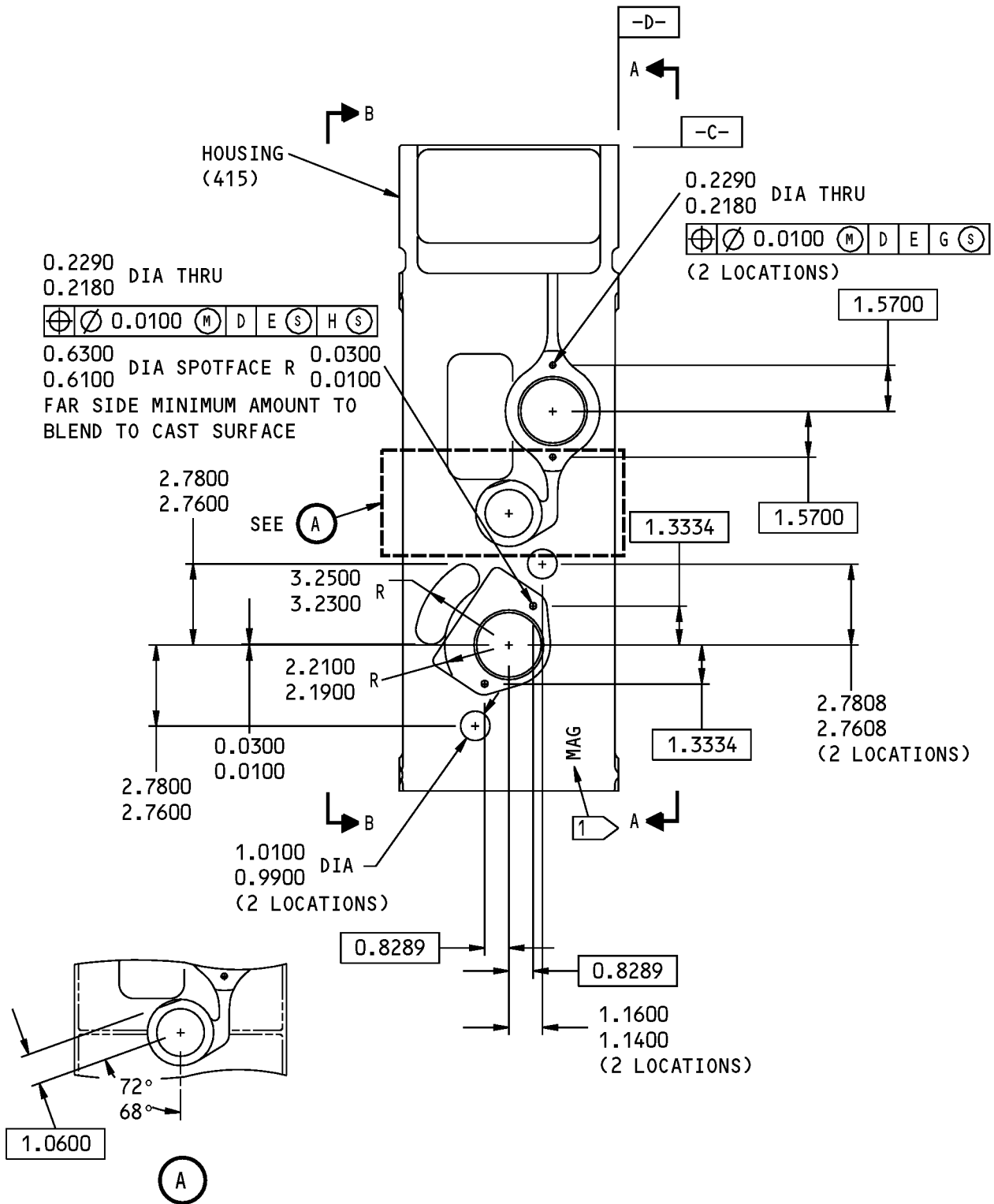
52-16-12

REPAIR 8-2

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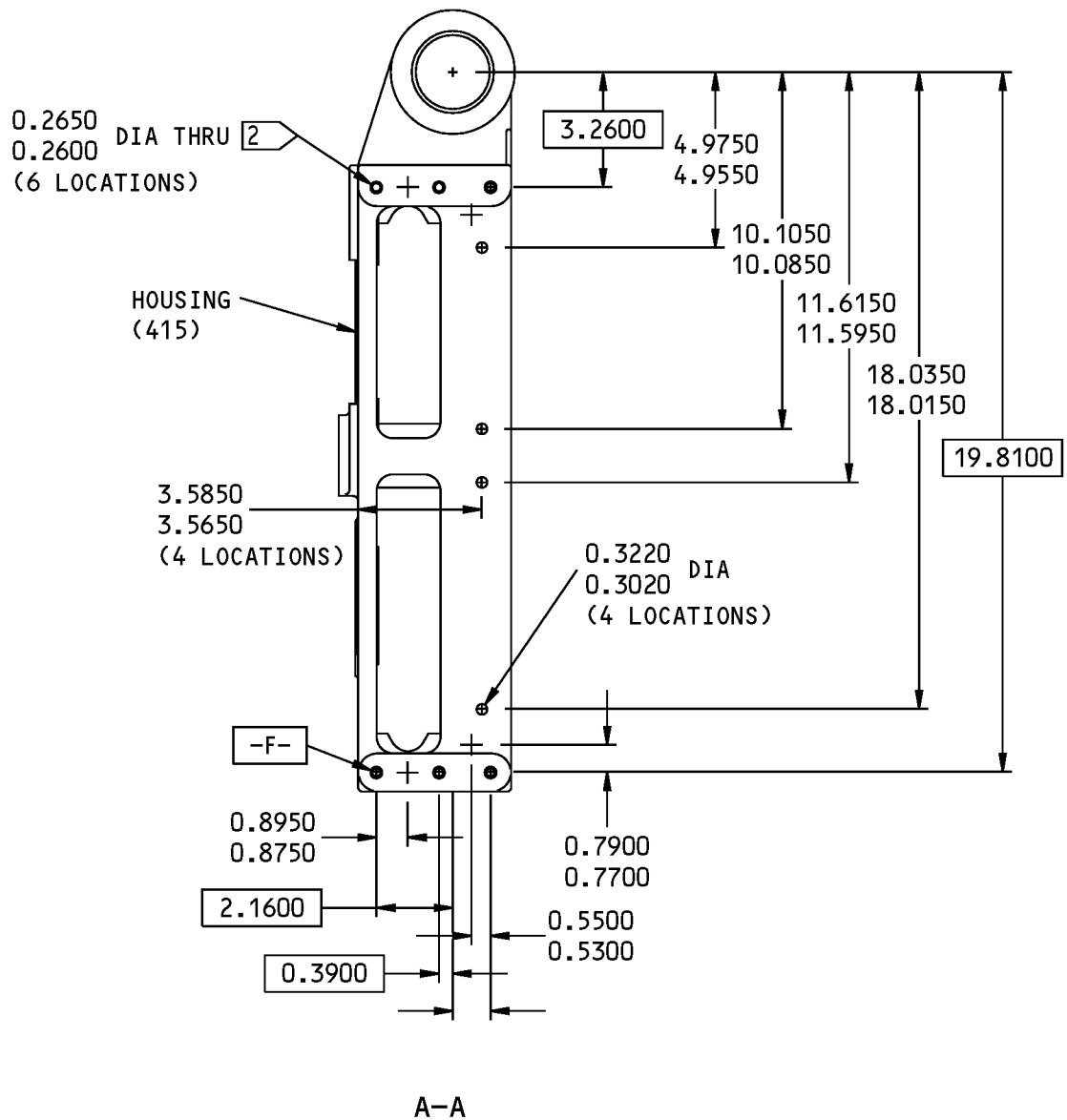


141A6304-2 Housing Repair
Figure 601 (Sheet 1 of 7)

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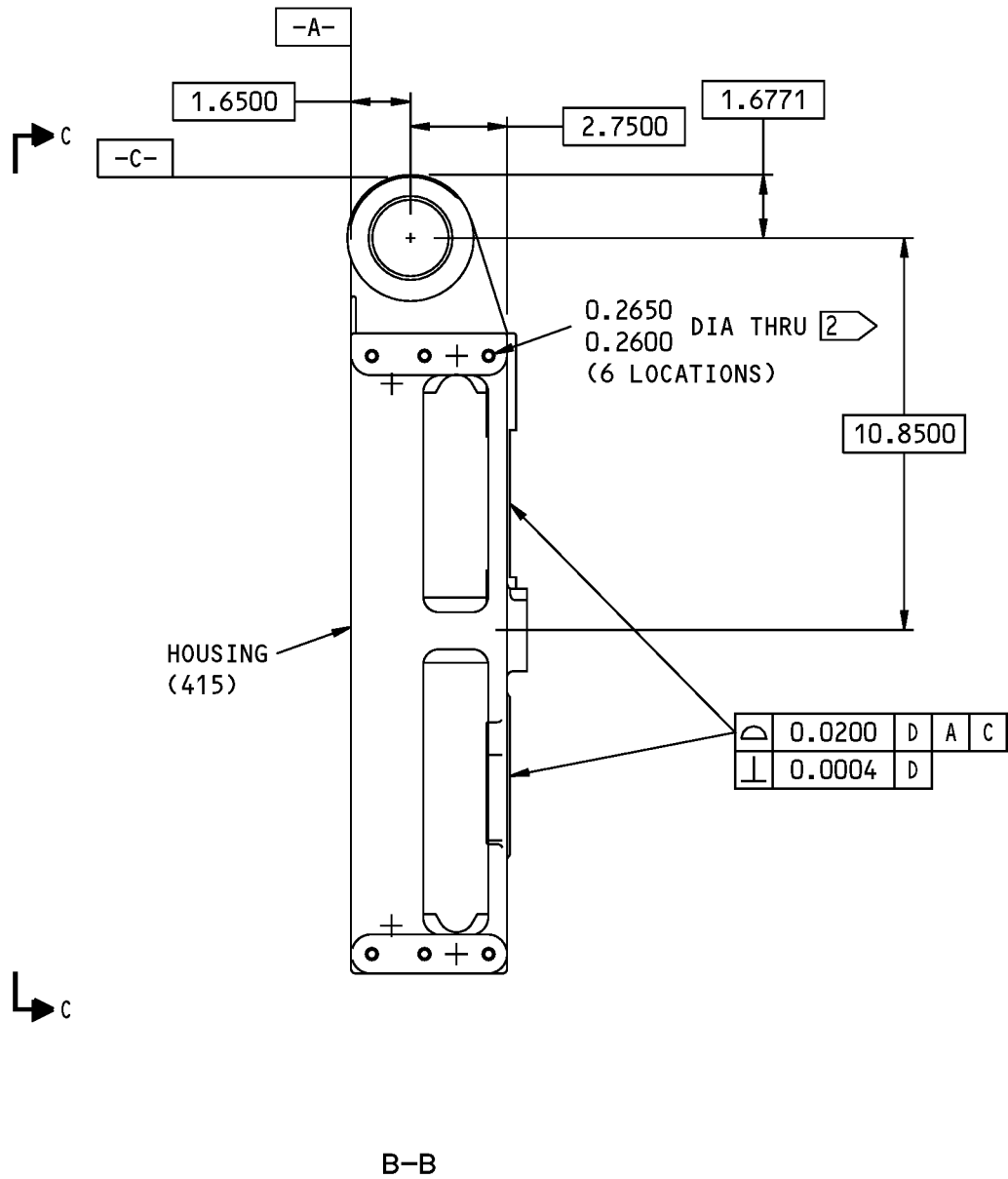


141A6304-2 Housing Repair
Figure 601 (Sheet 2 of 7)

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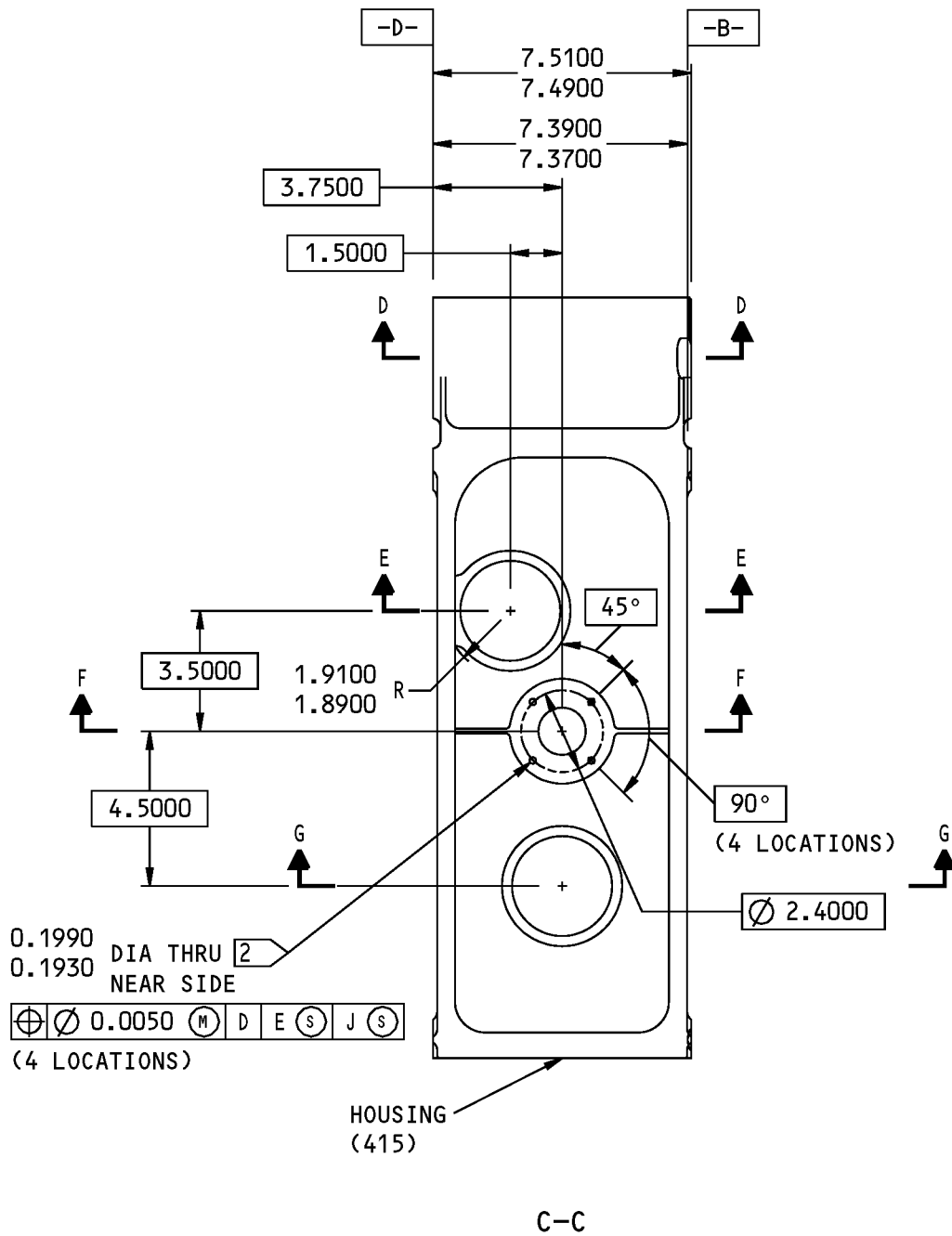


141A6304-2 Housing Repair
Figure 601 (Sheet 3 of 7)

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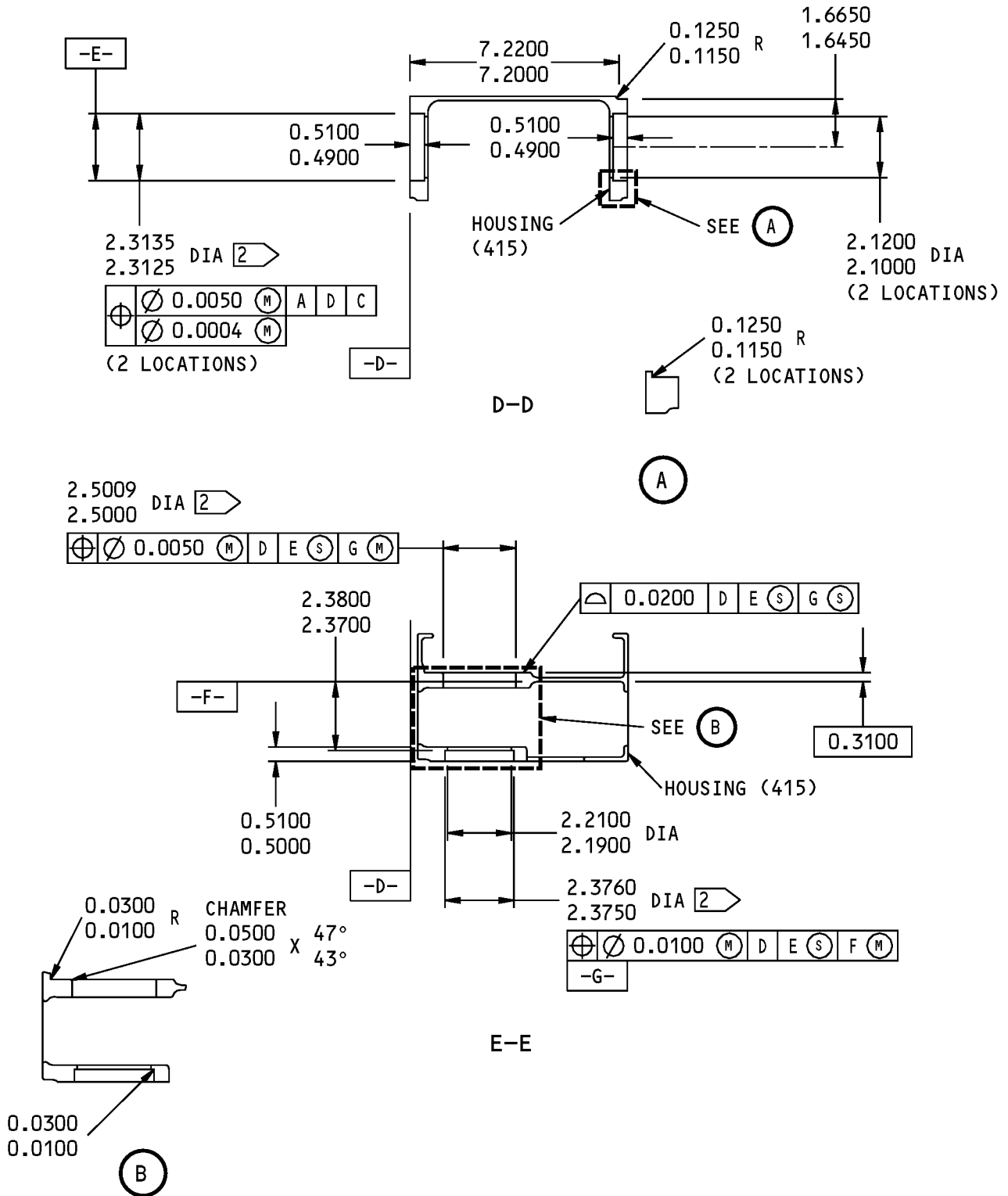


141A6304-2 Housing Repair
Figure 601 (Sheet 4 of 7)

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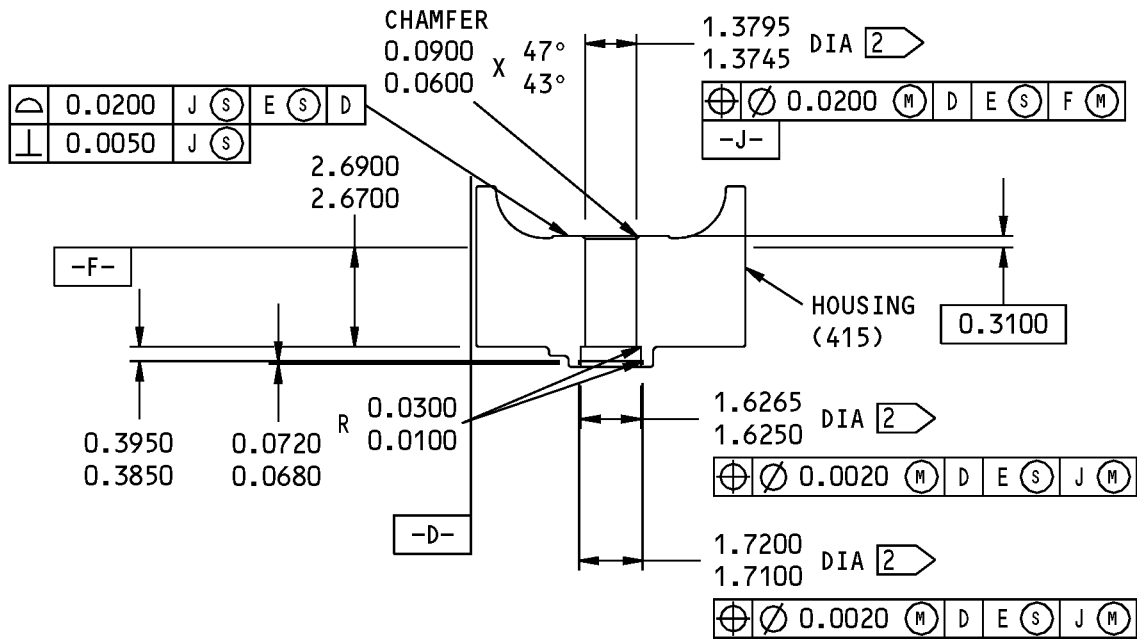


141A6304-2 Housing Repair
Figure 601 (Sheet 5 of 7)

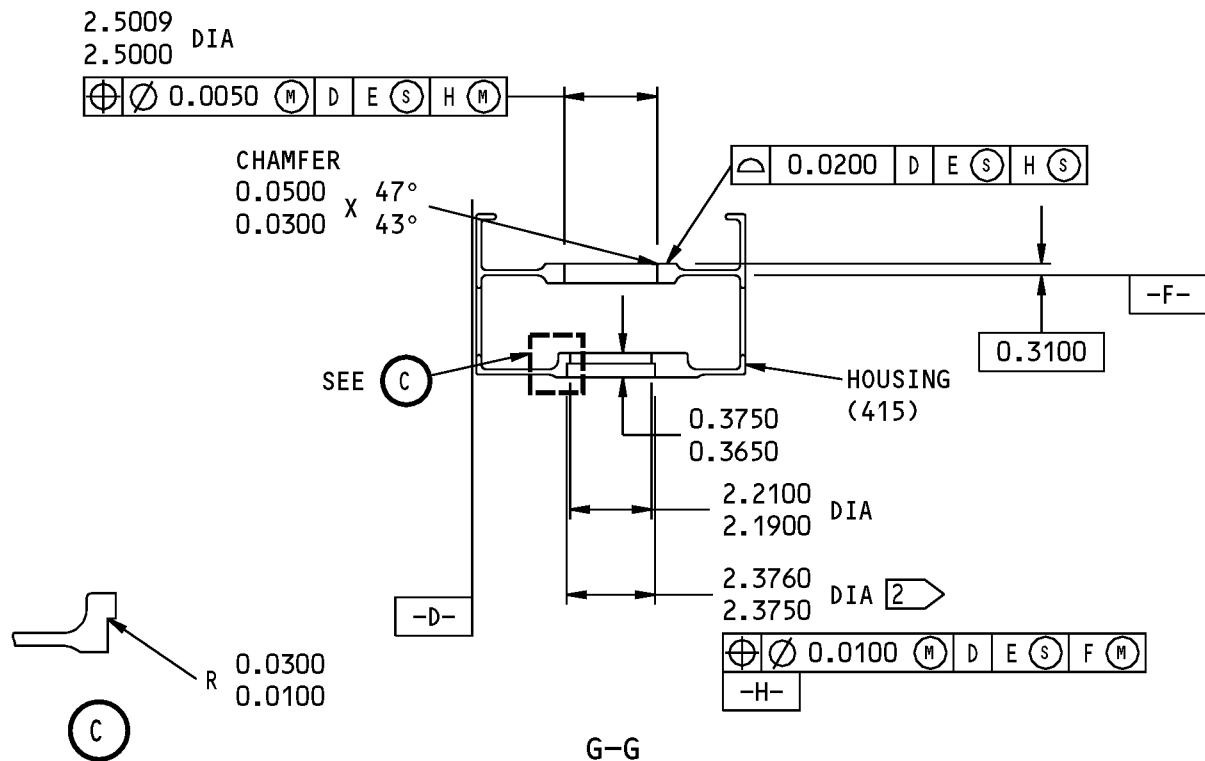
52-16-12

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COMPONENT MAINTENANCE MANUAL



F-F



G-G

141A6304-2 Housing Repair
Figure 601 (Sheet 6 of 7)

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COMPONENT MAINTENANCE MANUAL

1 RUBBER STAMP THE LETTER 'MAG'
HERE AS SPECIFIED IN SOPM 20-50-10

2 DO NOT PUT PRIMER OR ENAMEL
HERE

125/ ALL MACHINED SURFACES UNLESS
SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 12

ALL DIMENSIONS ARE IN INCHES

141A6304-2 Housing Repair
Figure 601 (Sheet 7 of 7)

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REPAIR 8-2

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COMPONENT MAINTENANCE MANUAL

CAM FOLLOWER CRANK ASSEMBLY - REPAIR 9-1

141A6306-1, -4

1. General

- A. This procedure tells how to repair the cam follower crank assembly (260).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 shown in the repair.
- D. Refer to IPL Figure 12 for item numbers.

2. Bearing Replacement

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

| Reference | Description | Specification |
|-----------|---|---------------|
| C00308 | Compound - Corrosion Preventive, Petrolatum Hot Application | MIL-C-11796 |

- B. References

| Reference | Title |
|---------------|--|
| SOPM 20-41-01 | DECODING TABLE FOR BOEING FINISH CODES |
| SOPM 20-50-02 | INSTALLATION OF SAFETYING DEVICES |

- C. Procedure (REPAIR 9-1, Figure 601)

NOTE: For the decoding table for Boeing finish codes, refer to SOPM 20-41-01.

- (1) Remove the cotter pin (265), nut (275), washer (270) and bearing (280) from the crank arm (285).
- (2) Apply corrosion preventive compound, C00308 (F-19.11) to all surfaces of the hole for the bearing. Immediately install the bearing (280) onto the crank arm (285).
- (3) Install the washer (270) and the nut (275) onto the bearing (280). Tighten the nut (275) up to 55 pounds-inch.
- (4) Install the cotter pin (265) on the bearing (280) as specified in SOPM 20-50-02.

52-16-12

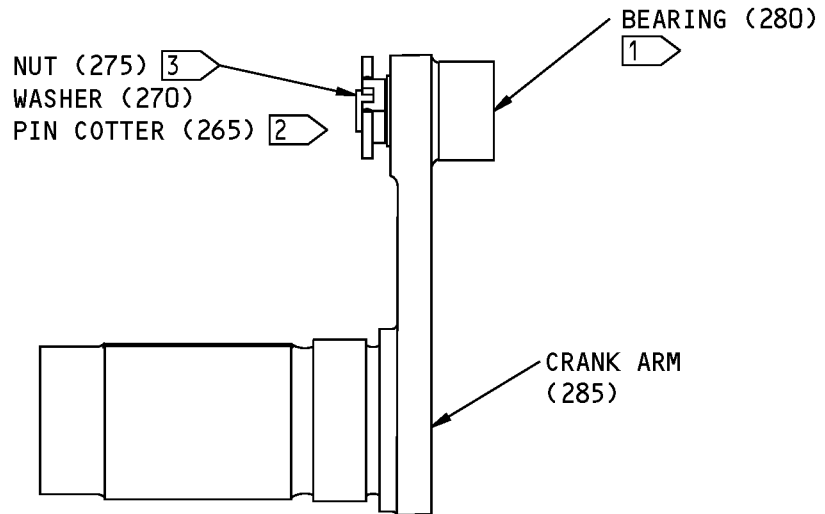
REPAIR 9-1

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COMPONENT MAINTENANCE MANUAL



- 1 INSTALL THIS BEARING WITH MIL-C-11796, CLASS 3 CORROSION PREVENTIVE COMPOUND (F-11.19) AS SPECIFIED IN SOPM 20-41-05
- 2 INSTALL THIS PIN COTTER AS SPECIFIED IN SOPM 20-50-02
- 3 TIGHTEN THIS NUT UP TO 55 IN-LBS OF TORQUE

ITEM NUMBERS REFER TO IPL FIG. 12

141A6306-1,-4 Cam Follower Crank Assembly Repair
Figure 601

52-16-12

REPAIR 9-1
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COMPONENT MAINTENANCE MANUAL

CRANK ARM - REPAIR 9-2

141A6306-2

1. General

- A. This procedure has the data necessary to refinish the crank arm (285).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 shown in the repair.
- D. Refer to IPL Figure 12 for item numbers.
- E. General repair details:
 - (1) Material: 15-5PH CRES
 - (a) 180-200 ksi

2. Crank Arm Refinish

A. References

| Reference | Title |
|---------------|--|
| SOPM 20-30-02 | STRIPPING OF PROTECTIVE FINISHES |
| SOPM 20-41-01 | DECODING TABLE FOR BOEING FINISH CODES |
| SOPM 20-42-05 | BRIGHT CADMIUM PLATING |
| SOPM 20-60-02 | FINISHING MATERIALS |

B. Procedure (REPAIR 9-2, 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) Passivate (F-17.25).
- (2) Cadmium plate (F-15.02) all surfaces identified by flagnote 1 as specified in SOPM 20-42-05.

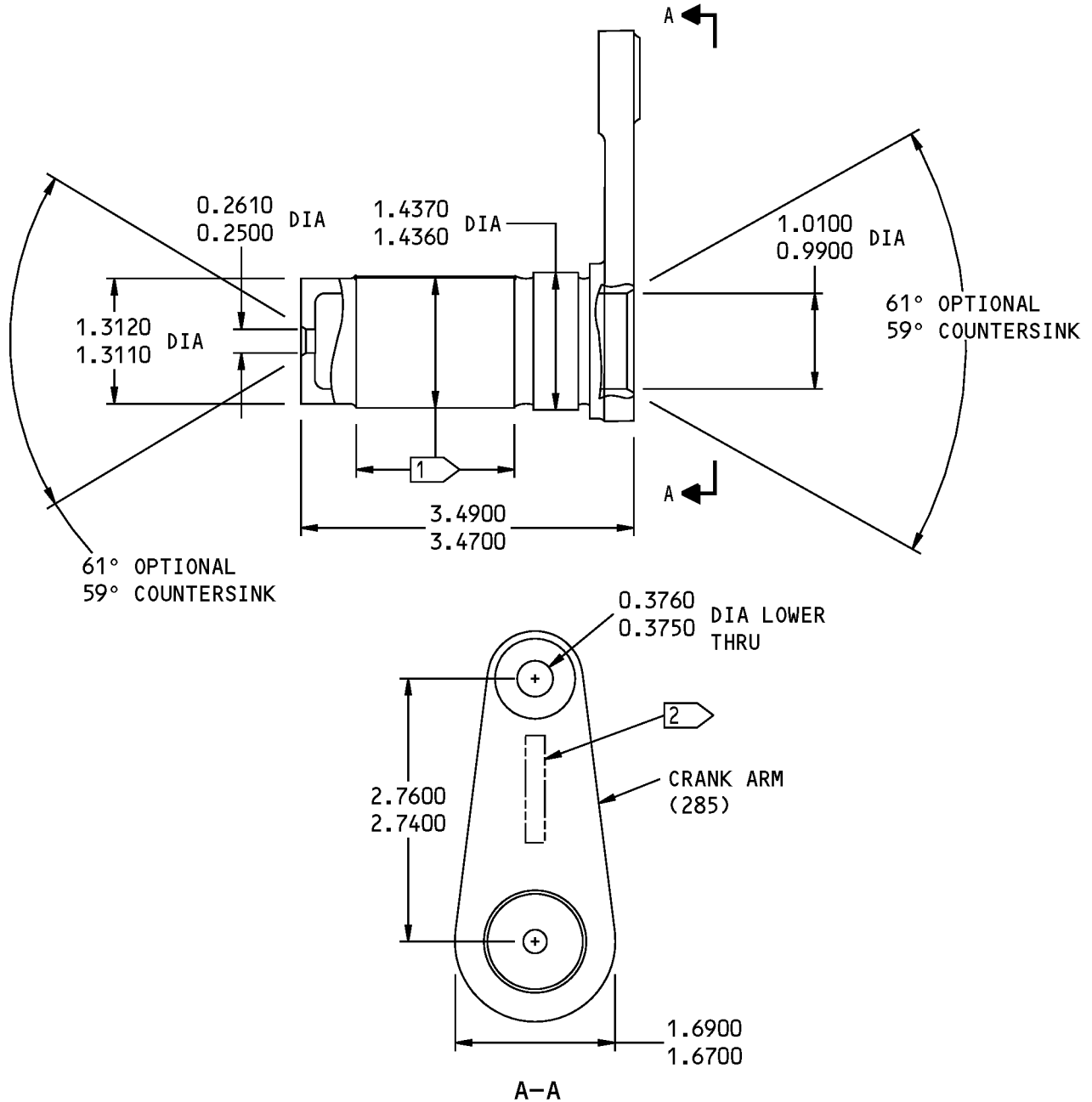
52-16-12

REPAIR 9-2

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1 CADMIUM PLATE (0.0002-0.0004 INCH THICK) TYPE 2, CLASS 3 (F-15.02) THIS AREA AS SPECIFIED IN SOPM 20-42-05

2 THE PART NUMBER IS FOUND HERE

125 ✓ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 12

ALL DIMENSIONS ARE IN INCHES

141A6306-2 Cam Arm Repair
Figure 601

52-16-12

REPAIR 9-2

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COMPONENT MAINTENANCE MANUAL

TORQUE TUBE ASSEMBLY - REPAIR 10-1

141A6321-1, -2, 141A6322-1, -2

1. General

- A. This procedure has the data necessary to repair the torque tube assembly (25, 30).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 shown in the repair.
- D. Refer to IPL Figure 13 for item numbers.

2. Bearing Replacement

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

| Reference | Description | Specification |
|-----------|---|---------------|
| C00308 | Compound - Corrosion Preventive, Petrolatum Hot Application | MIL-C-11796 |

- B. References

| Reference | Title |
|---------------|---|
| SOPM 20-41-01 | DECODING TABLE FOR BOEING FINISH CODES |
| SOPM 20-41-05 | APPLICATION OF CORROSION INHIBITING COMPOUNDS |

- C. Procedure (REPAIR 10-1, Figure 601 and REPAIR 10-1, Figure 602)

NOTE: For decoding table for Boeing finish codes, refer to SOPM 20-41-01. For application of corrosion inhibiting compound, refer to SOPM 20-41-05

- (1) Remove the cotter pins (35), nuts (40), washers (45, 50), and bearings (55) from the cranks (60).
- (2) Apply corrosion preventive compound, C00308 (F-19.11) to all surfaces of the hole for the bearing as identified by flagnote 1.
- (3) For the upper tube assembly (25), install the new bearing(s) (55) as follows (REPAIR 10-1, Figure 601):
 - (a) Install the bearing(s) (55) onto the crank(s) (60) with two washers (45) under the bearing(s) (55) as identified by flagnote 2.
 - (b) Install two washers (45) and the nut(s) (40) onto the bearing(s) (55) as identified by flagnote 3.
 - (c) Install the cotter pin(s) (35) onto the nut(s) (40) as identified by flagnote 4.
- (4) For the lower tube assembly (30), install the bearing(s) (55) as follows (REPAIR 10-1, Figure 602):
 - (a) Install the bearing (55) onto the right crank (60) with three washers (50) under the bearing (55) as identified by flagnote 2.
 - (b) Install the washer (50) and the nut (40) onto the bearing (55) as identified by flagnote 3.
 - (c) Install the bearing (55) onto the left crank (60) with the washer (50) under the bearing (55) as identified by flagnote 5.

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- (d) Install two washers (50) and the nut (40) onto the bearing (55) as identified by flagnote 6.
- (e) Install the cotter pin(s) (35) onto the nut(s) (40) as identified by flagnote 4.

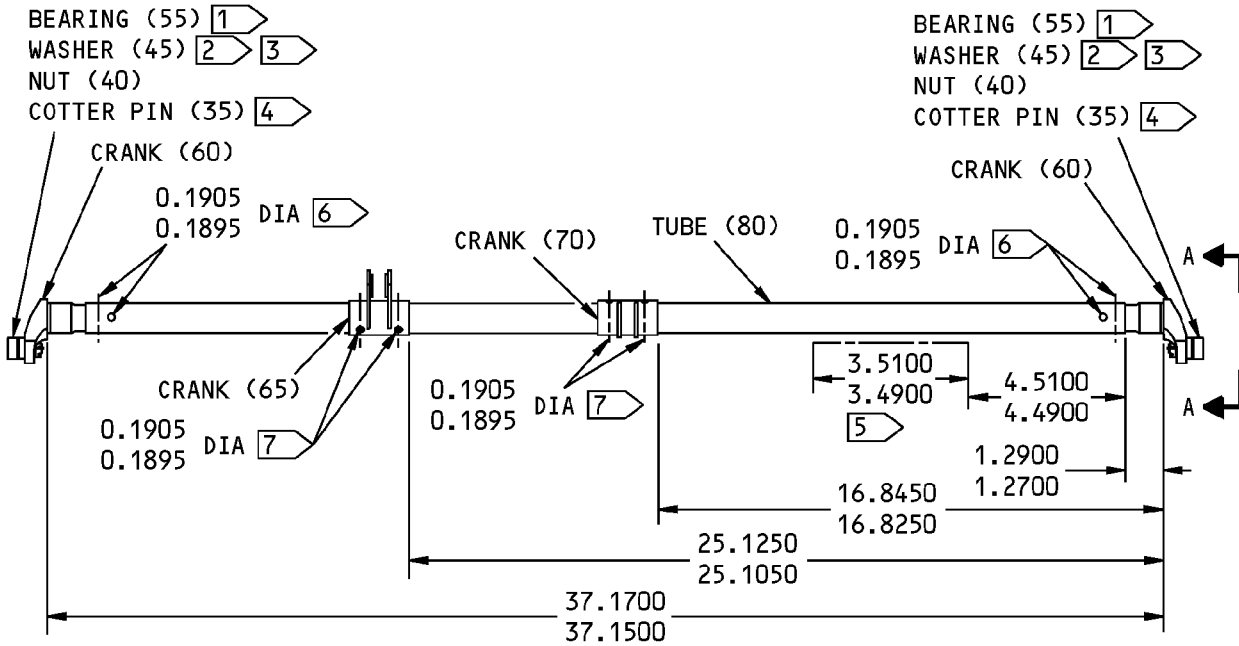
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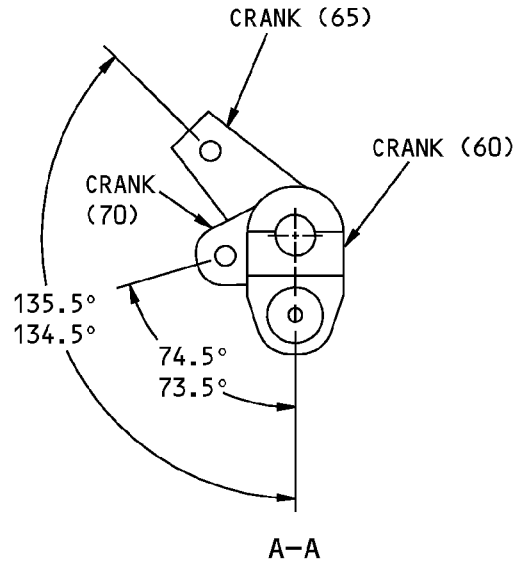
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COMPONENT MAINTENANCE MANUAL



141A6322-1 SHOWN
 141A6322-2 IS ALMOST THE SAME

- 1 INSTALL THIS BEARING WITH MIL-C-11796, CLASS 3 CORROSION PREVENTIVE COMPOUND (F-19.11) AS SPECIFIED IN SOPM 20-60-03
- 2 INSTALL TWO WASHERS UNDER THIS BEARING
- 3 INSTALL TWO WASHERS UNDER THIS NUT
- 4 INSTALL THIS COTTER PIN AS SPECIFIED IN SOPM 20-50-02
- 5 THE PART NUMBER IS FOUND HERE
- 6 LOCATE TWO 0.1895-0.1905 DIAMETER HOLE WITH TUBE HERE
- 7 LOCATE TWO 0.1895-0.1905 DIAMETER HOLE WITH CRANK HERE

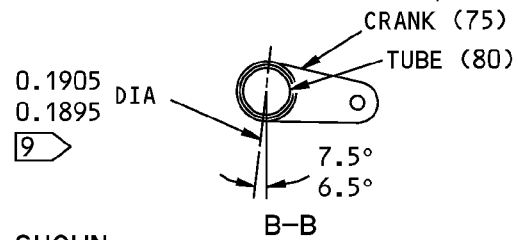
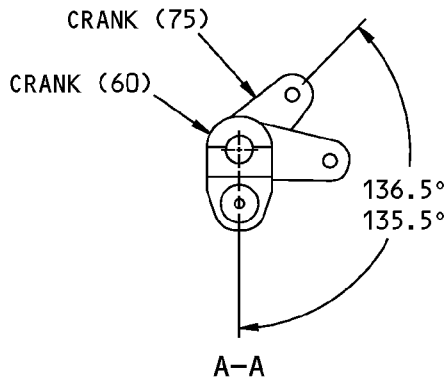
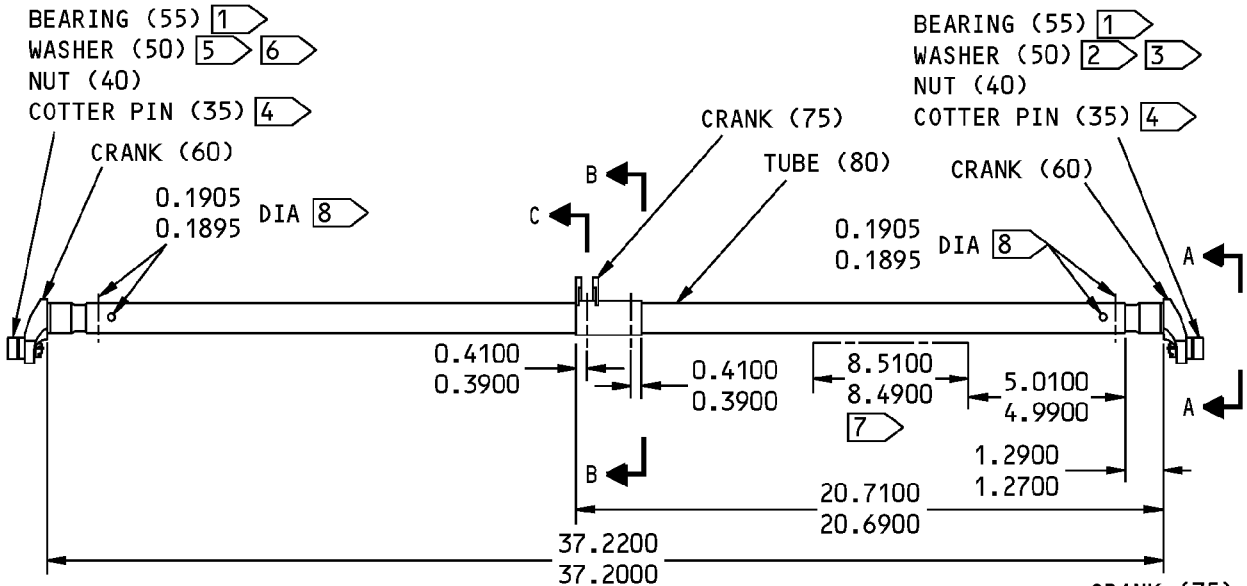


ITEM NUMBERS REFER TO IPL FIG. 13
 ALL DIMENSIONS ARE IN INCHES

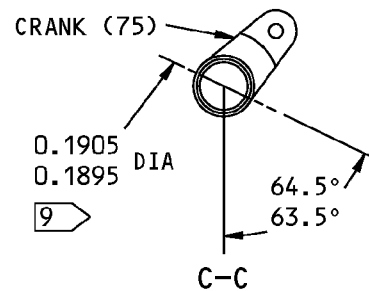
141A6322-1,-2 Torque Tube Assembly Repair
 Figure 601

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COMPONENT MAINTENANCE MANUAL



141A6321-1 SHOWN
141A6321-2 IS ALMOST THE SAME



- 1 INSTALL THIS BEARING WITH MIL-C-11796, CLASS 3 CORROSION PREVENTIVE COMPOUND (F-19.11) AS SPECIFIED IN SOPM 20-60-08
- 2 INSTALL THREE WASHERS UNDER THIS BEARING
INSTALL A WASHER UNDER THIS NUT
- 4 INSTALL THIS COTTER PIN AS SPECIFIED IN SOPM 20-50-02
- 5 INSTALL A WASHER UNDER THIS BEARING
- 6 INSTALL TWO WASHERS UNDER THIS NUT
- 7 THE PART NUMBER IS FOUND HERE

- 8 LOCATE TWO 0.1895-0.1905 DIA HOLES WITH TUBE
 - 9 LOCATE A 0.1895-0.1905 DIA HOLE WITH CRANK
- ITEM NUMBERS REFER TO IPL FIG. 13
ALL DIMENSIONS ARE IN INCHES

141A6321-1,-2 Torque Tube Assembly Repair
Figure 602

52-16-12



COMPONENT MAINTENANCE MANUAL

LATCHING CRANK - REPAIR 10-2

141A6323-1, -2

1. General

- A. This procedure has the data necessary to refinish the latching crank (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 shown in the repair.
- D. Refer to IPL Figure 13 for item numbers.
- E. General repair details:
 - (1) Material: Al alloy

2. Latching Crank Refinish

- 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 |
| C00260 | Coating - Chemical And Solvent Resistant Finish, Epoxy Resin Enamel | BMS10-11, Type II |

- B. References

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

- C. Procedure (REPAIR 10-2, Figure 601)

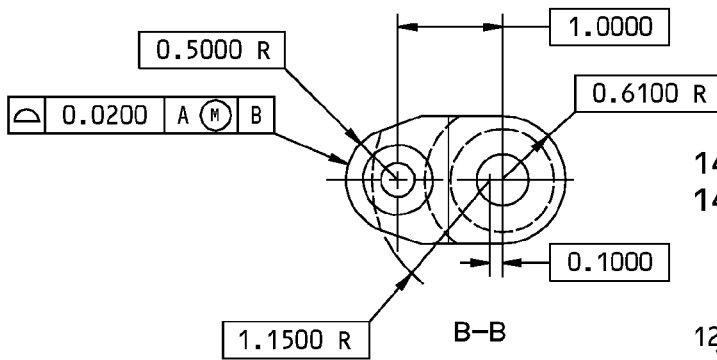
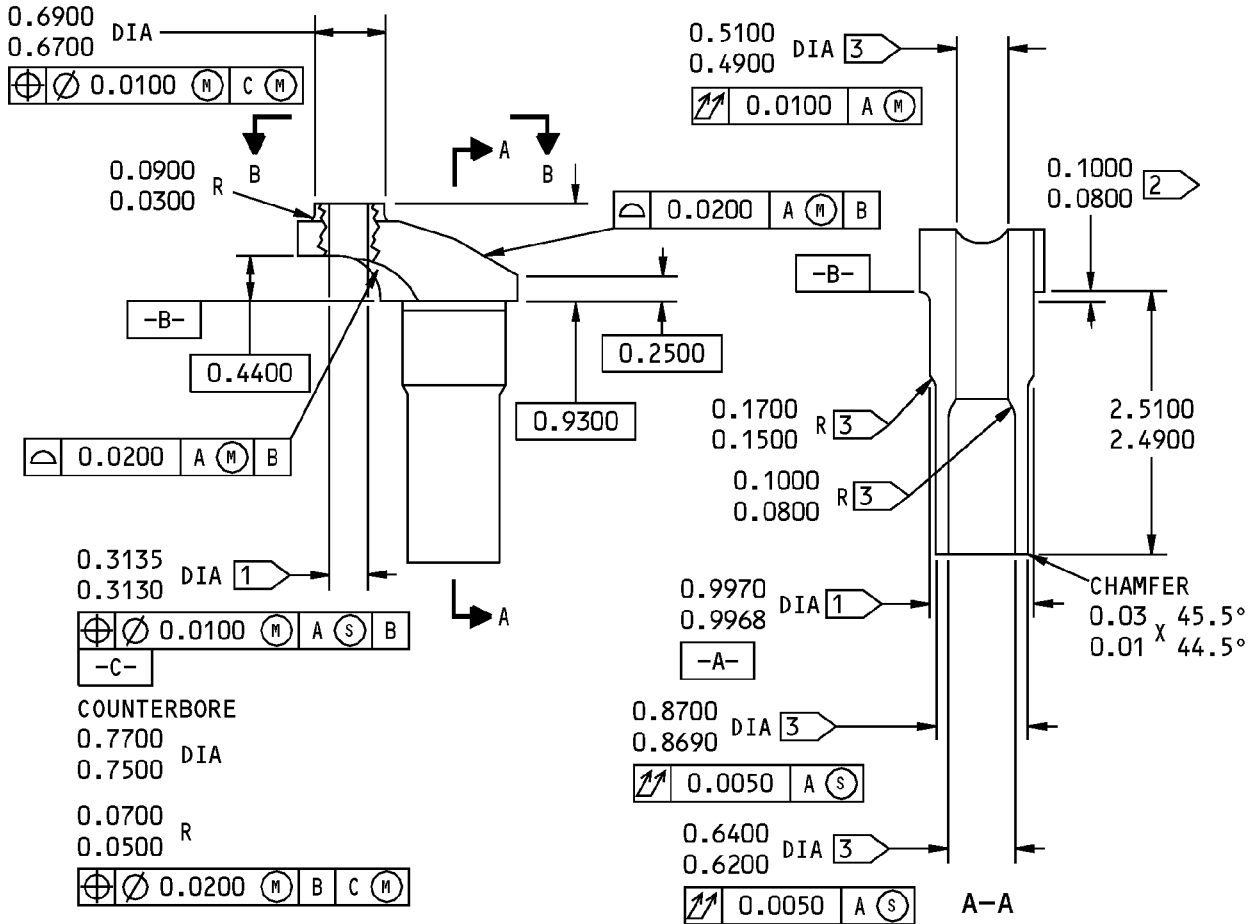
NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31).
- (2) Apply primer, C00259 (F-20.03) to all surfaces but not the surface identified by flagnote 1.
- (3) Apply enamel coating, C00260 (F-21.03.720) to all surfaces but not the surface identified by flagnote 3.

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141A6323-1 SHOWN
141A6323-2 IS ALMOST THE SAME

125 ✓ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

- [1] NO PRIMER OR ENAMEL IN THIS AREA
- [2] OVERSPRAY ALLOWED HERE
- [3] NO ENAMEL IN THIS AREA

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

141A6323-1,-2 Latching Crank Repair
Figure 601



COMPONENT MAINTENANCE MANUAL

TUBE - REPAIR 10-3

60-4406-11, -19

1. General

- A. This procedure tells how to refinish the tube (80).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 shown in the repair.
- D. Refer to IPL Figure 13 for item numbers.
- E. General repair details:
 - (1) Material: 17-7PH CRES
 - (a) 150-170 ksi

2. Tube Refinish

- 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 |

- B. References

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

- C. Procedure (REPAIR 10-3, Figure 601)

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

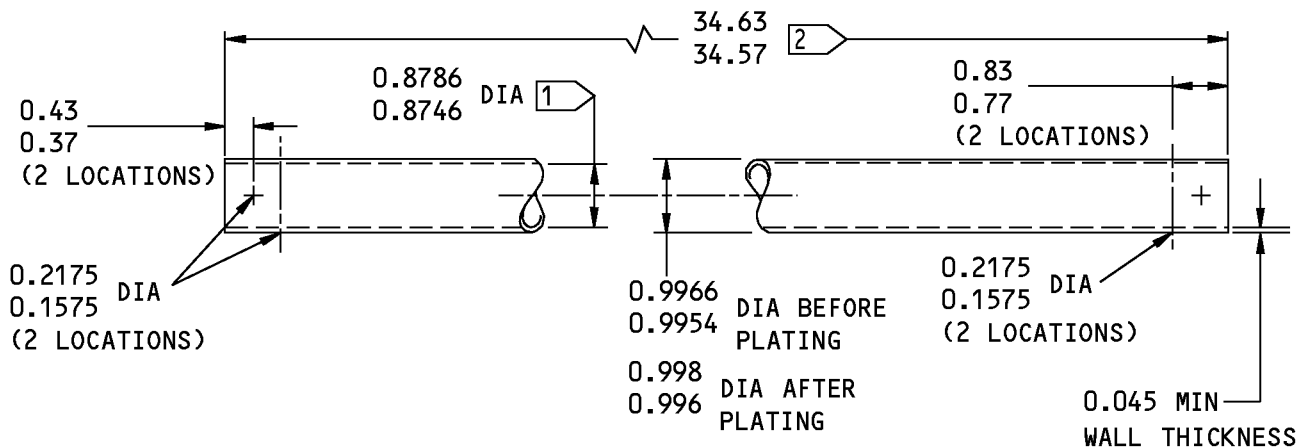
- (1) Cadmium plate (F-15.06) the surfaces identified by flagnote 1.
- (2) Apply primer, C00259 (F-20.02) to the inside surface of the tube.

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- 1 DIMENSION APPLIES FOR A DISTANCE 1.54-1.66 INCHES FROM END OF TUBE
- 2 TUBE TO BE STRAIGHT WITHIN 0.002 FOR EVERY LINEAR FOOT

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY
 BREAK ALL SHARP EDGES
 ITEM NUMBERS REFER TO IPL FIG. 13
 ALL DIMENSIONS ARE IN INCHES

H10748 S00041000589_V2

60-4406-11,-19 Torque Tube Repair
 Figure 601

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REPAIR 10-3
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COMPONENT MAINTENANCE MANUAL

STOP ROD ASSEMBLY - REPAIR 11-1

141A6331-1

1. General

- A. This procedure has the data necessary to repair the stop rod assembly (55).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 shown in the repair.
- D. Refer to IPL Figure 14 and IPL Figure 15 for item numbers.

2. Rod End Bearing Replacement

A. References

| Reference | Title |
|---------------|---------------------------------|
| SOPM 20-50-03 | BEARING AND BUSHING REPLACEMENT |

B. Procedure (REPAIR 11-1, Figure 601)

- (1) Remove the rod end bearing (70), nut (60), and washer (85) from the rod (80).
- (2) Install the washer (85), nut (60), and the new rod end bearing (70) onto the rod (80) as identified by flagnote 1 (SOPM 20-50-03).

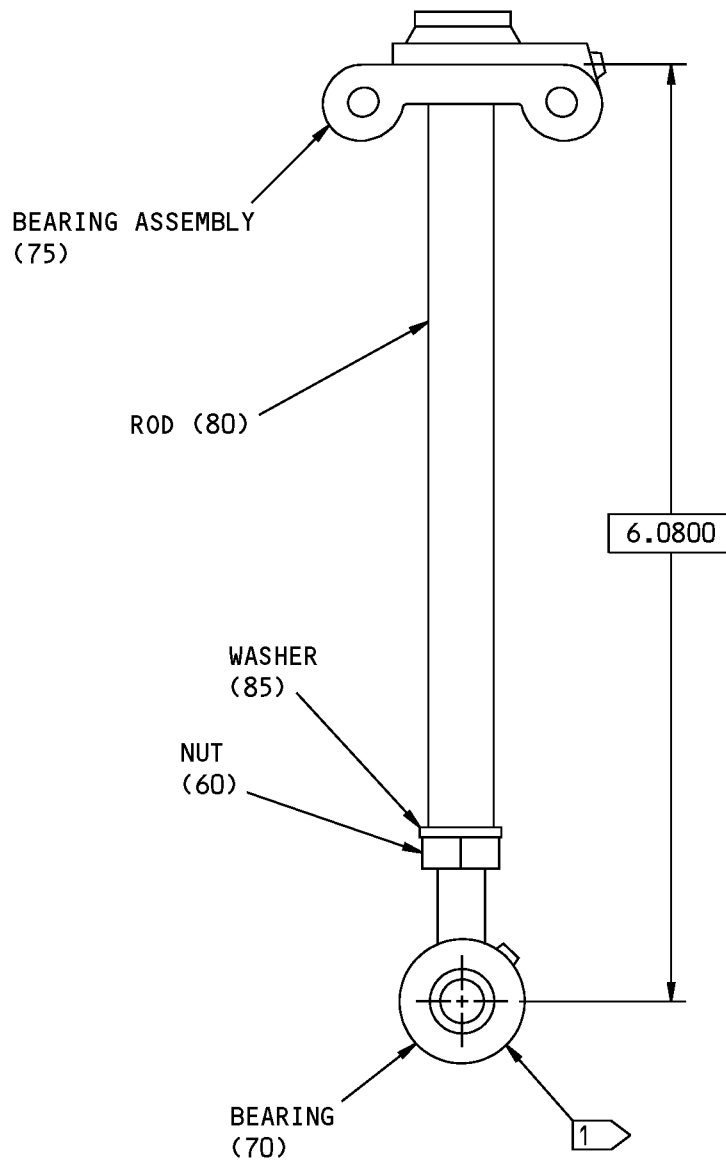
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REPAIR 11-1

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1 INSTALL THE ROD END TO COVER THE INSPECTION HOLE ON THE ROD. FINAL LENGTH AND LOCKWIRE TO BE INSTALLED AT DOOR RIG.

ITEM NUMBERS REFER TO IPL FIGS. 14,15
ALL DIMENSIONS ARE IN INCHES

141A6331-1 Stop Rod Assembly Repair
Figure 601

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REPAIR 11-1
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COMPONENT MAINTENANCE MANUAL

STOP ROD - REPAIR 11-2

66-2620-1

1. General

- A. This procedure has the data necessary to refinish the stop rod (80).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 shown in the repair.
- D. Refer to IPL Figure 14 and IPL Figure 15 for item number.
- E. General repair details:
 - (1) Material: Steel Tube

2. Stop Rod Refinish

- 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 |
| D00015 | Grease - Aircraft Bearing (Use BMS 3-24 until existing stocks are depleted, BMS 3-33 supersedes BMS 3-24) | BMS3-24 (Superseded by BMS 3-33) |
| D50108 | Lubricant - Solid Film, Air Cured, Corrosion Inhibiting | MIL-L-23398, Type 7 Class 1 |

- B. References

| Reference | Title |
|---------------|---|
| SOPM 20-30-02 | STRIPPING OF PROTECTIVE FINISHES |
| SOPM 20-30-03 | GENERAL CLEANING PROCEDURES |
| SOPM 20-41-01 | DECODING TABLE FOR BOEING FINISH CODES |
| SOPM 20-50-08 | APPLICATION OF BONDED SOLID FILM LUBRICANTS |
| SOPM 20-60-02 | FINISHING MATERIALS |
| SOPM 20-60-03 | LUBRICANTS |

- C. Procedure (REPAIR 11-2, 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 application of bonded solid film lubricant, refer to SOPM 20-50-08. For finishing materials, refer to SOPM 20-60-02. For lubricants, refer to SOPM 20-60-03.

- (1) Apply finish to the stop rod (80) as follows:
 - (a) Cadmium plate (F-1.611) all external surfaces.
 - (b) Clean the internal surfaces of the stop rod (80) as specified in SOPM 20-30-03.

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REPAIR 11-2
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COMPONENT MAINTENANCE MANUAL

- (c) Apply primer, C00259 to all internal surfaces, but not on the surfaces identified by flagnote 1.
- (2) Remove cadmium finish from the threaded surfaces (identified by flagnote 2 in REPAIR 11-2, Figure 601) as follows:
 - (a) Install the chase thread onto the threaded surfaces of the stop rod (80) to completely remove the cadmium finish from the threads.
 - (b) Remove the chase thread from the threaded end of the stop rod (80).
 - (c) Apply grease, D00015 onto the threads of the stop rod (80) as specified in SOPM 20-60-03.
- (3) Apply lubricant, D50108 to the surfaces identified by flagnote 3.

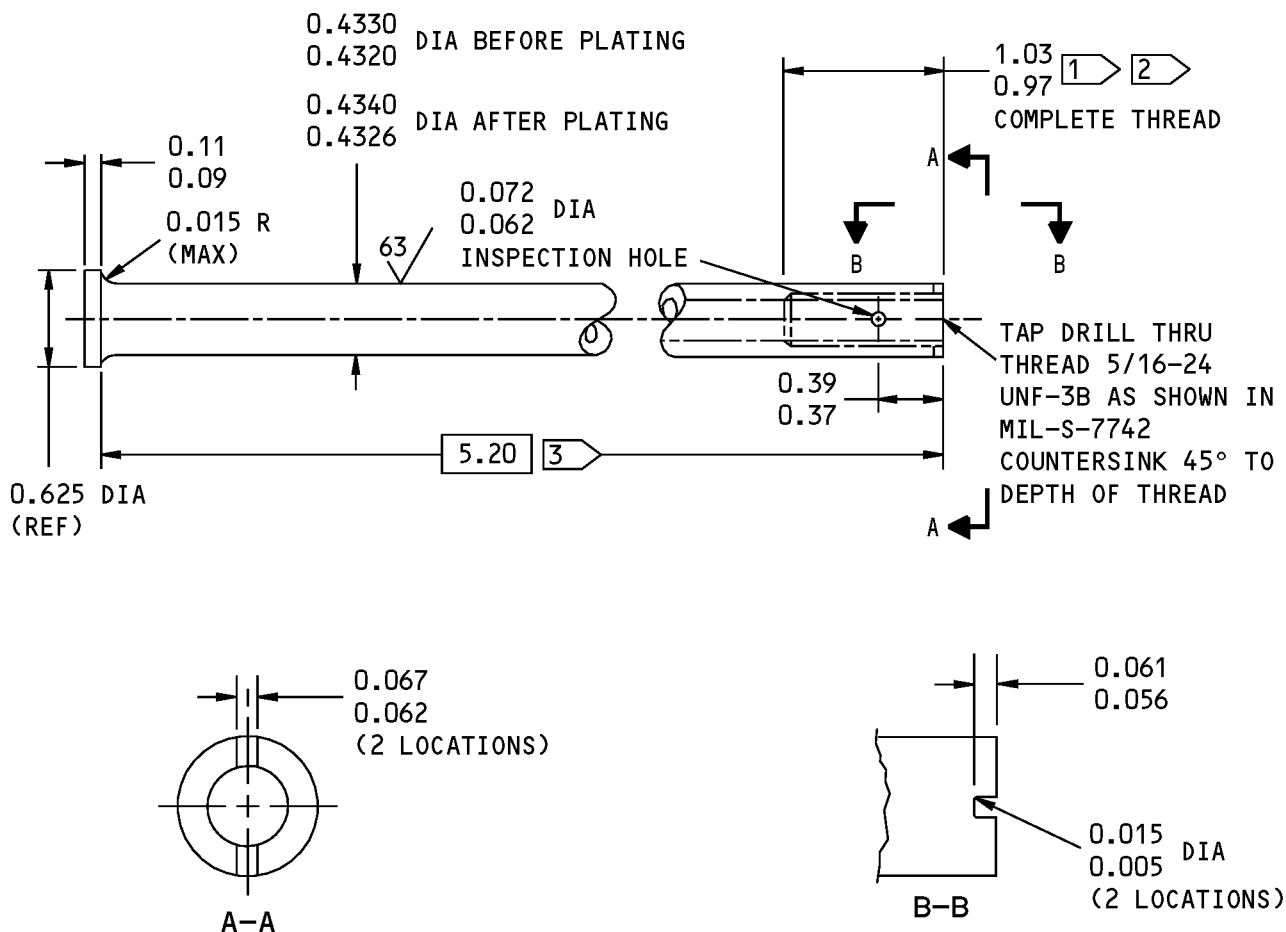
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- 1 NO PRIMER HERE
- 2 AFTER CAD FINISH (F-1.611), INSTALL CHASE THREAD TO REMOVE CAD FINISH COMPLETELY FROM THE THREAD AREA. REMOVE THE CHASE THREAD AND APPLY BMS 3-24A AS SPECIFIED IN SOPM 20-50-08
- 3 APPLY TYPE 7, CLASS 1 SOLID FILM LUBRICANT AS SPECIFIED IN SOPM 20-50-08

125 ✓ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIGS. 14,15

ALL DIMENSIONS ARE IN INCHES

66-2620-1 Stop Rod Repair
Figure 601

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COMPONENT MAINTENANCE MANUAL

CONTROL ROD ASSEMBLY - REPAIR 12-1

65-28925thru-67, -70

1. General

- A. This procedure has the data necessary to repair the control rod assembly (130, 135).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 shown in the repair.
- D. Refer to IPL Figure 14 and IPL Figure 15 for item numbers.

2. Bearing Replacement

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

| Reference | Description | Specification |
|-----------|--|---|
| B50080 | Compound - Corrosion Preventive, Solvent Cutback, Cold-Application (Grade 2 - Soft Film) | MIL-PRF-16173, Grade 2 (Supersedes MIL-C-16173, Grade 2) |

- B. References

| Reference | Title |
|---------------|---|
| SOPM 20-41-01 | DECODING TABLE FOR BOEING FINISH CODES |
| SOPM 20-41-05 | APPLICATION OF CORROSION INHIBITING COMPOUNDS |
| SOPM 20-50-03 | BEARING AND BUSHING REPLACEMENT |

- C. Procedure (REPAIR 12-1, Figure 601)

NOTE: For decoding table for Boeing finish codes, refer to SOPM 20-41-01. For application of corrosion inhibiting compounds, refer to SOPM 20-41-05.

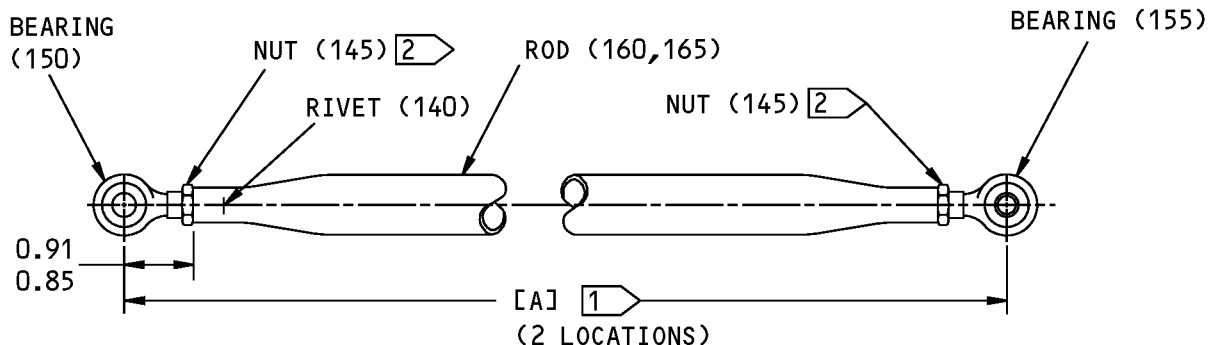
- (1) Remove the bearing(s) (150, 155) from the rod(s) (160, 165).
- (2) Remove the nut(s) (145) from the bearing(s) (150, 155).
- (3) Apply compound, B50080 (F-12.14) to the bearing(s) (150, 155) and rod(s) (160, 165) mating surfaces as identified by flagnote 2.
- (4) Install the new bearing(s) (150, 155) into the rod(s) (160, 165) to the dimensions given in REPAIR 12-1, Figure 601 (SOPM 20-50-03).
- (5) Install the nut(s) (145) onto the new bearing(s) (150, 155).
- (6) Tighten the nut(s) (145) to 60 pound-inches.

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| REF LETTER | REF IPL | DIMENSION | |
|------------|----------------------------|-----------|-------|
| | FIG. 14,15 MATING ITEM NO. | MIN | MAX |
| [A] | 14; 130 | 15.13 | 15.19 |
| | 14; 135 | 20.20 | 20.26 |
| | 15; 130 | 12.55 | 12.61 |
| | 15; 135 | 23.05 | 23.11 |

[1] APPLY A THIN LAYER OF MIL-C-16173 CORROSION PREVENTIVE COMPOUND ONTO THE BEARING AND ROD MATING THREADS

[2] APPLY 60 POUND-INCH OF TORQUE TO THIS NUT BEFORE DRILLING AND INSTALLATION OF THE RIVET

125 ✓ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIGS. 14,15

ALL DIMENSIONS ARE IN INCHES

65-28925-67 thru -70 Control Rod Assembly Repair
 Figure 601

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REPAIR 12-1
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CONTROL ROD - REPAIR 12-2

65-28925thru-13, -16

1. General

- A. This procedure has the data necessary to refinish the control rod (160, 165).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 shown in the repair.
- D. Refer to IPL Figure 14 and IPL Figure 15 for item numbers.
- E. General repair details:
 - (1) Material: Al alloy

2. Control Rod Refinish

- 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 |

- B. References

| Reference | Title |
|---------------|---|
| SOPM 20-30-02 | STRIPPING OF PROTECTIVE FINISHES |
| SOPM 20-41-01 | DECODING TABLE FOR BOEING FINISH CODES |
| SOPM 20-43-03 | CHEMICAL CONVERSION COATINGS FOR ALUMINUM |
| SOPM 20-60-02 | FINISHING MATERIALS |

- C. Procedure (REPAIR 12-2, Figure 601)

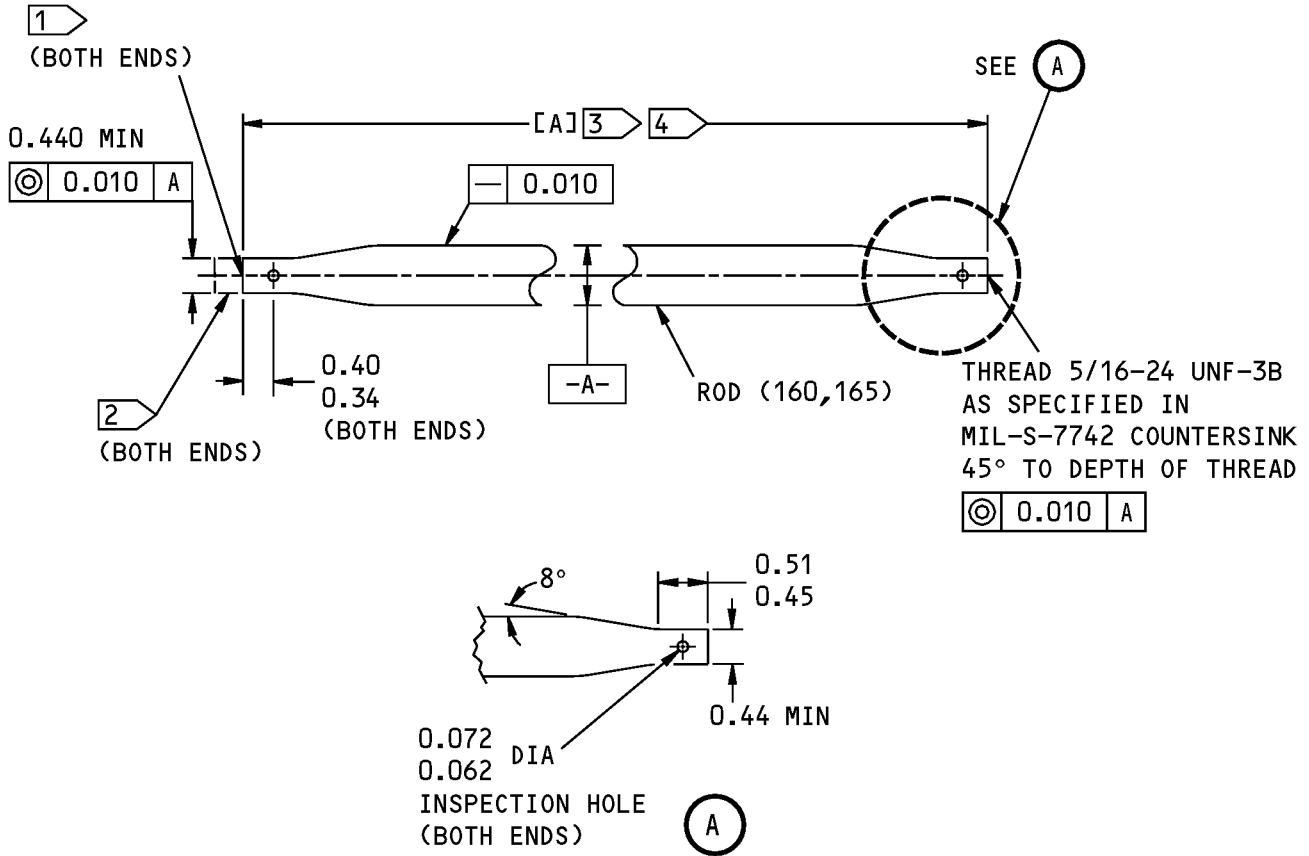
NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For decoding table for Boeing finish codes, refer to SOPM 20-41-01. For chemical conversion coatings for aluminum, refer to SOPM 20-43-03. For finishing materials, refer to SOPM 20-60-02.

- (1) Chemical treat (F-2.742) the internal and external surfaces as identified by flagnote 1.
- (2) Apply primer, C00259 (SRF-12.205) onto the external surface identified by flagnote 2.

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- 1 THE INSIDE DIMENSION OF THE SWAGED END BEFORE MACHINING IS 0.250-0.260 INCHES
- 2 THE SWAGED ENDS WILL BE TRIMMED TO 0.25-0.30 INCHES AFTER FORMING
- 3 CHEMICAL TREAT (F-2.742) THE INTERIOR AND EXTERIOR SURFACES OF THE TUBING AS SPECIFIED IN MIL-C-5541, CLASS 1A OR IN BAC5626 OR IN BAC5719
- 4 APPLY A LAYER OF BMS 10-11, TYPE 1 PRIMER (SRF-12.205) ONTO THE EXTERIOR SURFACE ONLY AS SPECIFIED IN SOPM 20-41-02

| REF LETTER | REF IPL FIG. 14,15 MATING ITEM NO. | DIMENSION | |
|------------|--|-----------|-------|
| | | MIN | MAX |
| [A] | 14; 160 | 13.37 | 13.43 |
| | 14; 165 | 18.44 | 18.50 |
| | 15; 160 | 10.79 | 10.85 |
| | 15; 165 | 21.29 | 21.35 |

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIGS. 14,15

ALL DIMENSIONS ARE IN INCHES

65-28925-13 thru -16 Control Rod Repair
Figure 601

52-16-12



COMPONENT MAINTENANCE MANUAL

CENTER SHAFT - REPAIR 13-1

60-4455-3

1. General

- A. This procedure has the data necessary to refinish the center shaft (85).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 shown in the repair.
- D. Refer to IPL Figure 12 for item numbers.
- E. General repair details:
 - (1) Material: 15-5PH CRES
 - (a) 150-170 ksi

2. Center Shaft Refinish

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

| Reference | Description | Specification |
|-----------|---|-----------------------------|
| D00113 | Lubricant - Liquid Dispersed Solid Film Lubricant | BMS3-8, BAC 5811, TYPE VIII |

- B. References

| Reference | Title |
|---------------|--|
| SOPM 20-41-01 | DECODING TABLE FOR BOEING FINISH CODES |
| SOPM 20-60-03 | LUBRICANTS |

- C. Procedure (REPAIR 13-1, Figure 601)

NOTE: For decoding table for Boeing finis codes, refer to SOPM 20-41-01 For lubricants, refer to SOPM 20-60-03.

- (1) Passivate (F-17.25).
- (2) Cadmium plate (F-15.06) on surfaces identified by flagnote 1.
- (3) Apply lubricant, D00113 on surface identified by flagnote 2.

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HOUSING ASSEMBLY - REPAIR 14-1

65-2306-7

1. General

- A. This procedure has the data necessary to repair the housing assembly (105).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer REPAIR-GENERAL, Figure 601 shown in the repair.
- D. Refer to IPL Figure 8 for item numbers.

2. Bearing Replacement

- 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. Procedure (REPAIR 14-1, Figure 601)

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

- (1) Remove the bearing (115) from the housing (120).
- (2) Install the new bearing (115) into the housing (120) with sealant, A00247, as identified by flagnote 1 (SOPM 20-50-03).

3. Fitting Replacement

- 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 20-60-04 | MISCELLANEOUS MATERIALS |

- C. Procedure (REPAIR 14-1, Figure 601)

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

- (1) Remove the fitting (110) from the housing (120).

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REPAIR 14-1

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- (2) Install the new fitting (110) onto the housing (120) with sealant, A00247, as identified by flagnote 2.

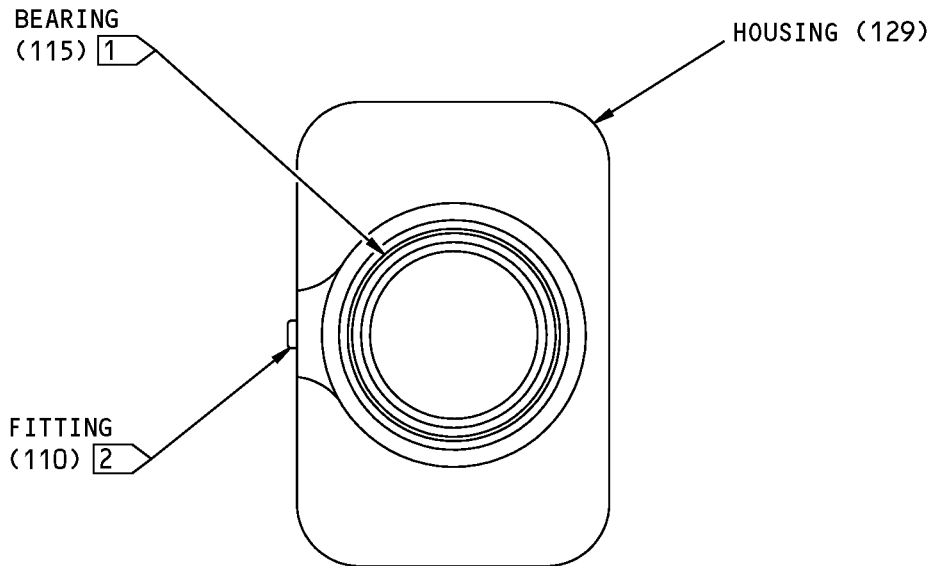
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REPAIR 14-1

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1 INSTALL THIS BEARING WITH WET
BMS 5-95 SEALANT AS SPECIFIED IN
SOPM 20-50-03

2 INSTALL THIS FITTING WITH WET
BMS 5-95 SEALANT AS SPECIFIED IN
SOPM 20-60-04

ITEM NUMBERS REFER TO IPL FIG. 8

65-2306-7 Housing Assembly Repair
Figure 601

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REPAIR 14-1
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HOUSING - REPAIR 14-2

65-2306-8

1. General

- A. This procedure has the data necessary to refinish the housing (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 shown in the repair.
- D. Refer to IPL Figure 8 for item numbers.
- E. General repair details:
 - (1) Material: Al alloy

2. Housing Refinish

- 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 |

- B. References

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

- C. Procedure (REPAIR 14-2, 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 or chromic acid anodize (F-17.31).
- (2) Apply primer, C00259 (F-20.03) to all surfaces, but not on the surfaces identified by flagnote 2.

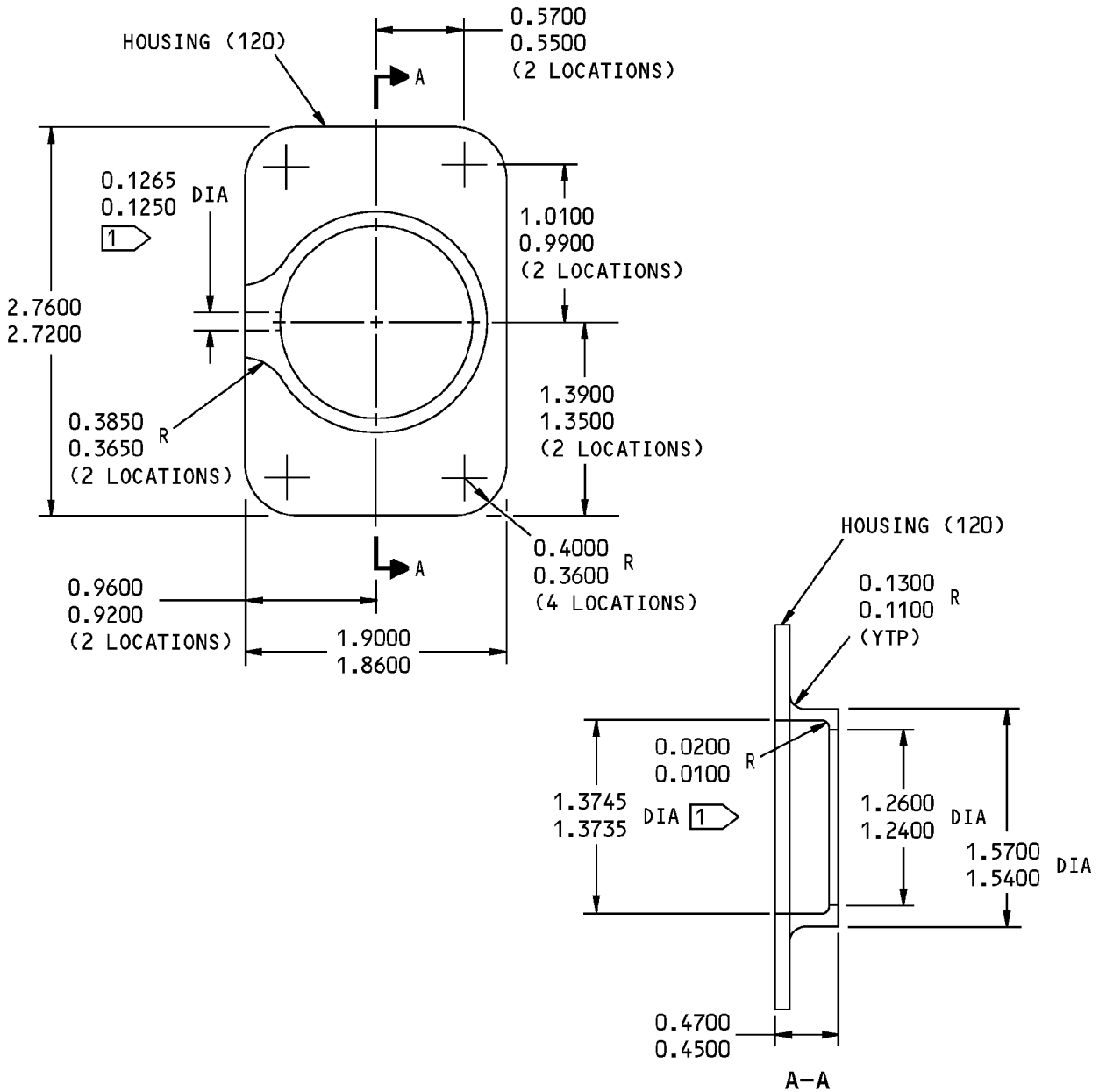
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REPAIR 14-2

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1 DO NOT PUT PRIMER AND ENAMEL HERE

125 ✓ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 8

ALL DIMENSIONS ARE IN INCHES

65-2306-8 Housing Repair
Figure 601

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REPAIR 14-2

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COMPONENT MAINTENANCE MANUAL

SUPPORT ASSEMBLY - REPAIR 15-1

65-25838-19, -24

1. General

- A. This procedure has the data necessary to repair the support assembly (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 shown in the repair.
- D. Refer to IPL Figure 5 for item numbers.

2. Bushing Replacement

- 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. Special Tools and Equipment

NOTE: Equivalent tool and equipment can be used.

- (1) F70335-1 – Line reaming tool, hinge support bushing

- D. Procedure (REPAIR 15-1, Figure 601)

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

- (1) Remove the bushings (105, 110) from the support (115, 120).
- (2) Install the new bushings (105, 110) onto the support (115, 120) with sealant, A00247 (SOPM 20-50-03).
- (3) Machine the new bushings (105, 110) in line, concentric to within 0.002 inch, as follows:
 - (a) Use the F70335-1 tool to machine the bushing (105) to a 0.6250-0.6265 inch diameter.
 - (b) Use the F70335-1 tool to machine the bushing (110) to a 1.0000-1.0015 inch diameter.

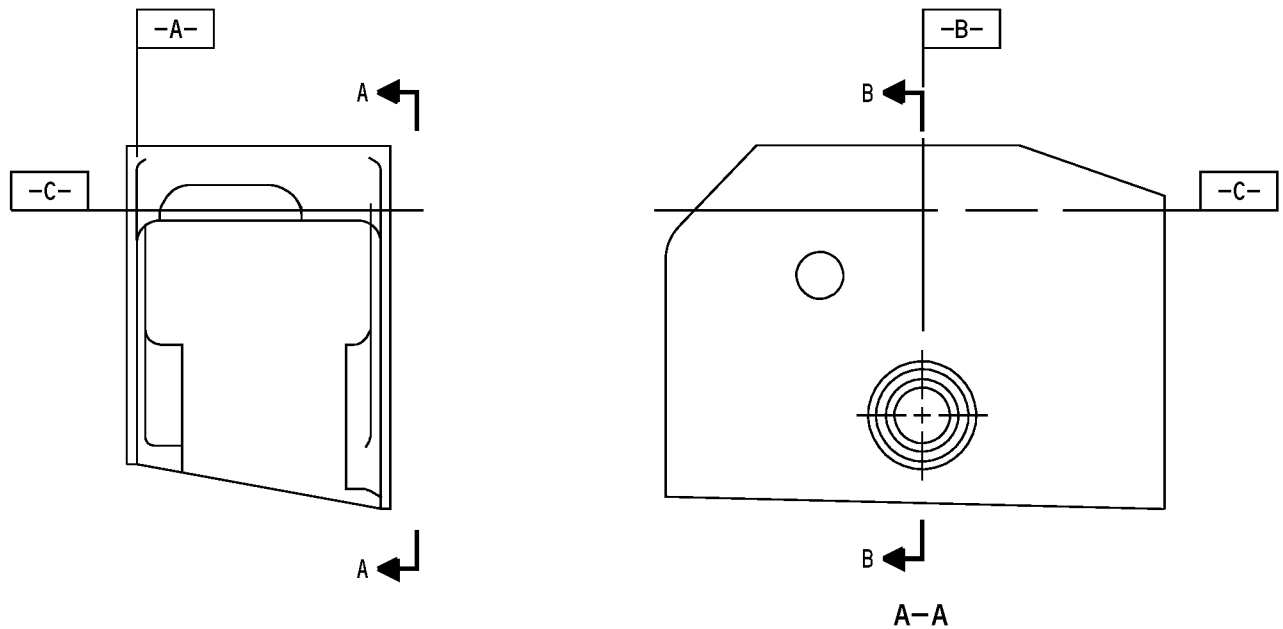
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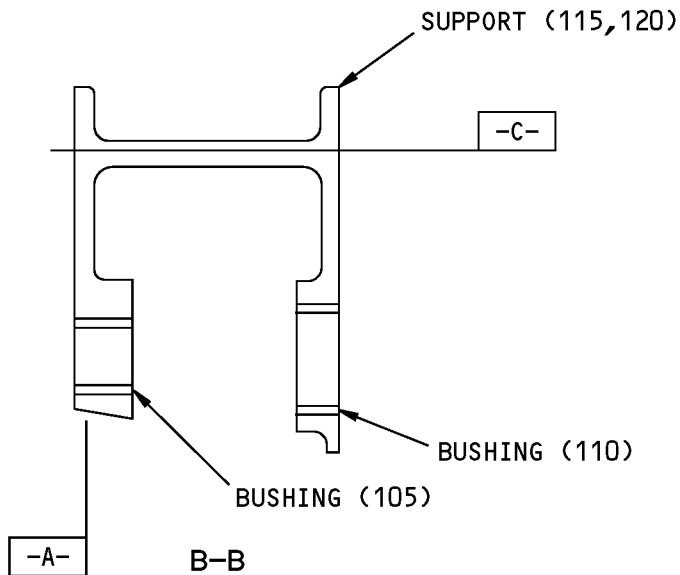
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65-25838-19 SHOWN
65-25828-24 SIMILAR



ITEM NUMBERS REFER TO IPL FIG. 5

65-25838-19,-24 Support Assembly Repair
Figure 601

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REPAIR 15-1
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SUPPORT ASSEMBLY - REPAIR 16-1

69-22323-17, -21

1. General

- A. This procedure has the data necessary to repair the support assembly (80, 85).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 shown in the repair.
- D. Refer to IPL Figure 5 for item numbers.

2. Fitting Replacement

- 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 20-60-04 | MISCELLANEOUS MATERIALS |

- C. Procedure (REPAIR 16-1, Figure 601)

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

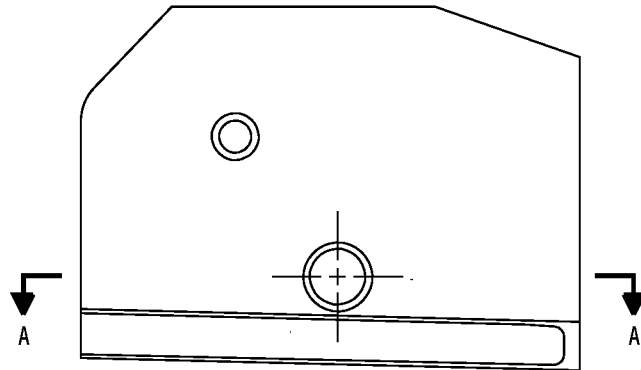
- (1) Remove the fitting (90) from the support assembly (95, 100).
- (2) Install the new fitting (90) onto the support assembly (95,100) with sealant, A00247.

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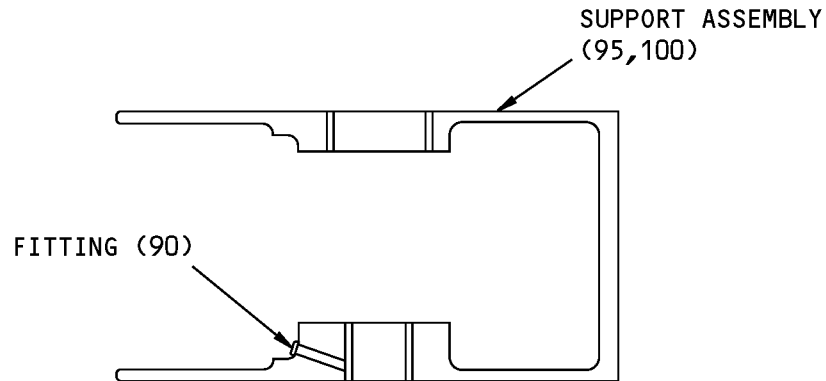
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69-22323-17 (SHOWN)
69-22323-21 (SIMILAR)



A-A

ITEM NUMBERS REFER TO IPL FIG. 5

69-22323-17,-21 Support Assembly Repair
Figure 601

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REPAIR 16-1
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COMPONENT MAINTENANCE MANUAL

HOUSE FITTING - REPAIR 17-1

69-61511-2

1. General

- A. This procedure has the data necessary to refinish the house fitting (55).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 shown in the repair.
- D. Refer to IPL Figure 12 for item numbers.
- E. General repair details:
 - (1) Material: Al alloy

2. House Fitting Refinish

- A. References

| Reference | Title |
|---------------|--|
| SOPM 20-41-01 | DECODING TABLE FOR BOEING FINISH CODES |

- B. Procedure (REPAIR 17-1, Figure 601)

NOTE: For decoding table for Boeing finish, refer to SOPM 20-41-01.

- (1) Cadmium plate (F-15-06) all surfaces identified by flagnote 2.
- (2) Chromium plate (F-15.03) all surfaces identified by flagnote 3.
- (3) Obey all other flagnotes.

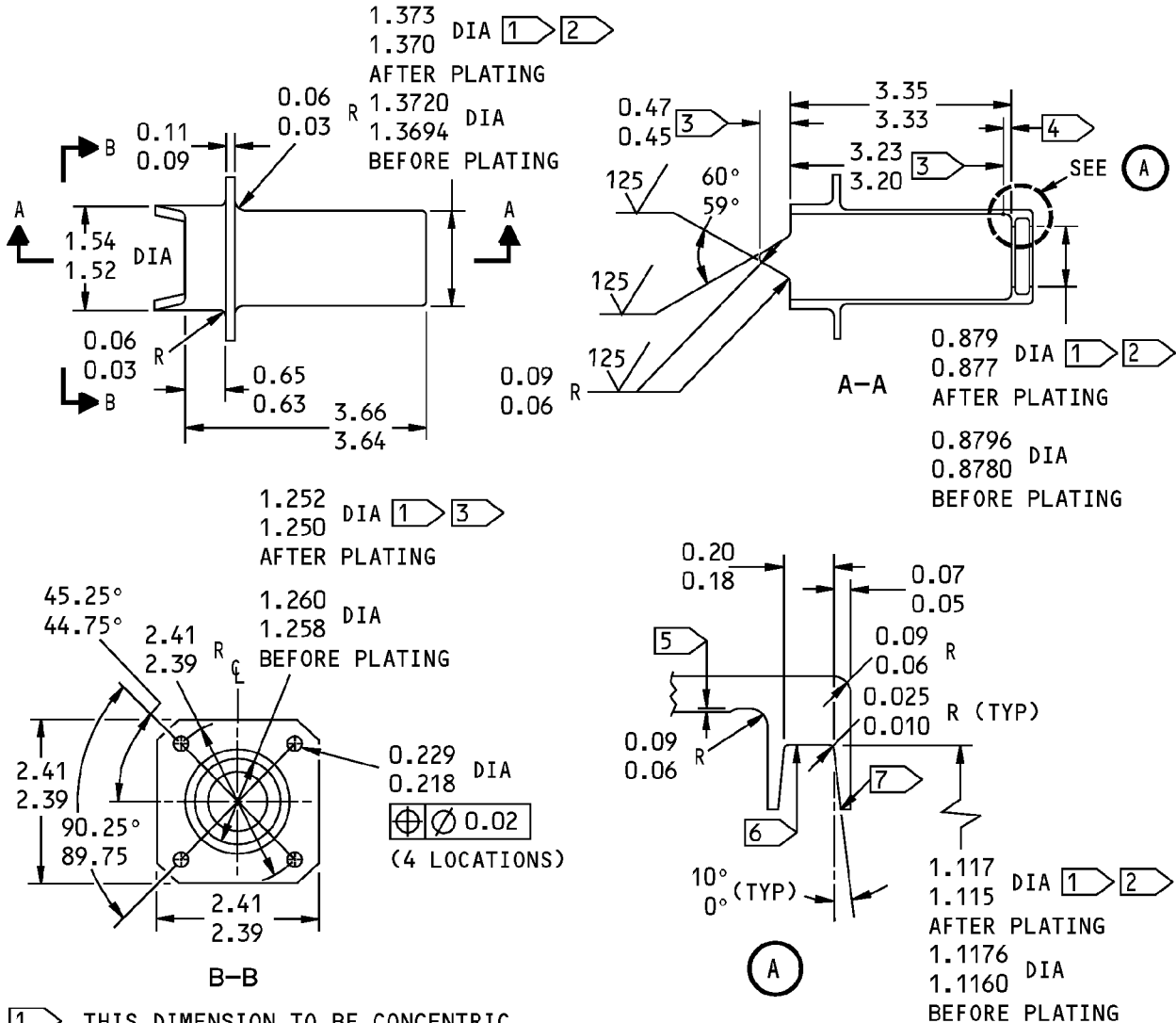
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REPAIR 17-1

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[1] THIS DIMENSION TO BE CONCENTRIC TO WITHIN 0.003 TIR HERE

[2] CADMIUM PLATE, TYPE 2, CLASS 2 (F-15.06) AS SPECIFIED IN SOPM 20-42-05 HERE

[3] CADMIUM PLATE, CLASS 2 (F-15.03) WITH 0.003 INCH MINIMUM THICKNESS AFTER GRINDING HERE

[4] CHROMIUM PLATE RUNOUT HERE

[5] 0.00-0.01 INCH MISMATCH ALLOWED HERE AFTER GRINDING

[6] TO BE 32 MICROINCHES SURFACE FINISH

[7] BREAK THIS CORNER APROXIMATELY 0.005 INCH RADIUS

250/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 12

ALL DIMENSIONS ARE IN INCHES

69-61511-2 House Fitting Repair
 Figure 601

52-16-12

REPAIR 17-1

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COMPONENT MAINTENANCE MANUAL

PUSHROD ASSEMBLY - REPAIR 18-1

60-7208-3

1. General

- A. This procedure has the data necessary to repair the pushrod assembly (185).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 shown in the repair.
- D. Refer to IPL Figure 12 for item numbers.

2. Rod End Bearing Replacement

A. References

| Reference | Title |
|---------------|---------------------------------|
| SOPM 20-50-01 | BOLT AND NUT INSTALLATION |
| SOPM 20-50-03 | BEARING AND BUSHING REPLACEMENT |

B. Procedure

NOTE: For bolt and nut installation, refer to SOPM 20-50-01.

- (1) Remove the rivet (195) from the rod (205).
- (2) Remove the rod end bearings (200) from the rod (205).
- (3) Remove the nut (190) from the rod end bearing (200).
- (4) Install the nut (190) onto the new rod end bearing (200).
- (5) Install the new rod end bearings (200) onto the rod (205) (SOPM 20-50-03).
- (6) Install the rivet (195) onto the rod (205) and through the rod end bearing (200).
- (7) Adjust the rod end bearing (200) to the dimension given in REPAIR 18-1, Figure 601. Tighten the nut (190).

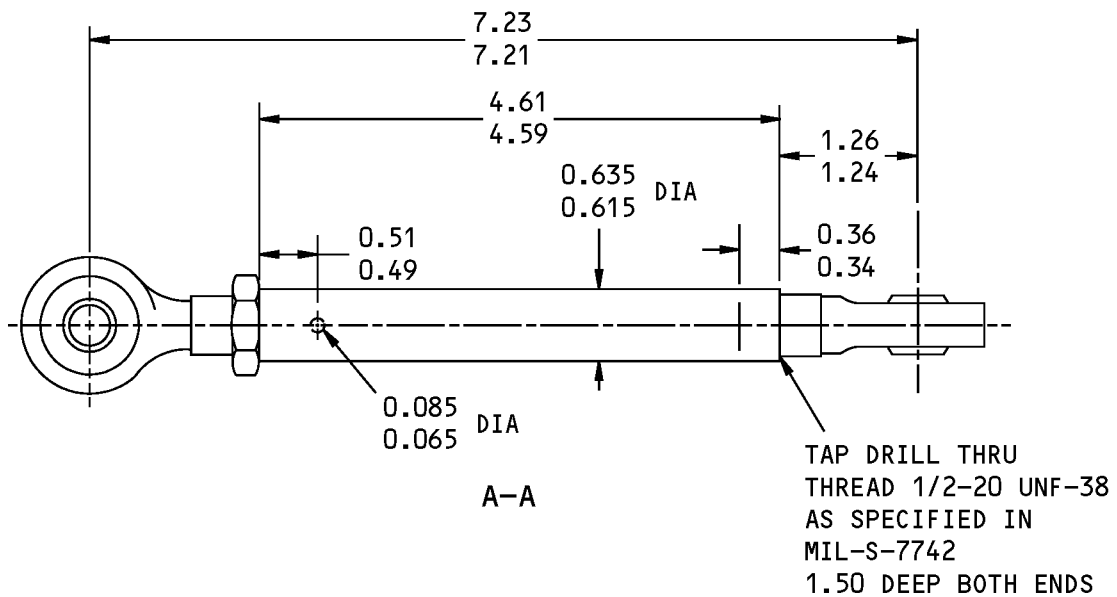
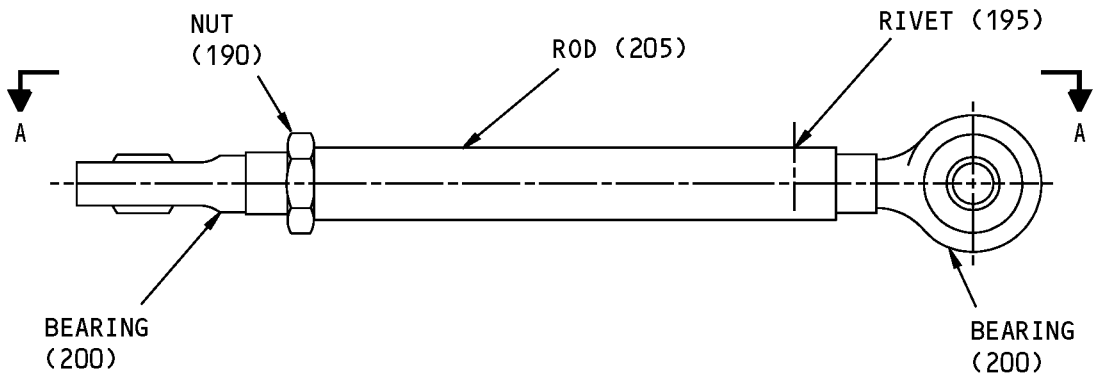
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REPAIR 18-1

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125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

60-7208-3 Push Rod Assembly Repair
Figure 601

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REPAIR 18-1

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COMPONENT MAINTENANCE MANUAL

ROD - REPAIR 18-2

60-7208-4, -5

1. General

- A. This procedure tells how to to refinish the rod (205).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 shown in the repair.
- D. Refer to IPL Figure 12 for item numbers.
- E. General repair details:
 - (1) Material: 4330M Steel Tube
 - (a) 150-170 ksi

2. Rod Refinish

- 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 |
| C00308 | Compound - Corrosion Preventive, Petrolatum Hot Application | MIL-C-11796 |

- B. References

| Reference | Title |
|---------------|--|
| SOPM 20-30-02 | STRIPPING OF PROTECTIVE FINISHES |
| SOPM 20-41-01 | DECODING TABLE FOR BOEING FINISH CODES |
| SOPM 20-41-03 | APPLICATION OF CORROSION PREVENTIVES TO INTERIOR OF CLOSED END TUBES |
| SOPM 20-41-05 | APPLICATION OF CORROSION INHIBITING COMPOUNDS |
| SOPM 20-42-05 | BRIGHT CADMIUM PLATING |
| SOPM 20-60-02 | FINISHING MATERIALS |

- C. Procedure

NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For application of corrosion inhibiting compound, refer to SOPM 20-41-05. For finishing materials, refer to SOPM 20-60-02.

- (1) Cadmium plate (F-15.06) the internal and external surfaces as specified in SOPM 20-42-05.
- (2) Apply primer, C00259 (F-20.03) to the external surfaces.
- (3) Apply corrosion preventive compound, C00308 (F-19.03) to the internal surfaces and threads, as specified in SOPM 20-41-03.

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REPAIR 18-2
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1. General

- A. This procedure tells how to assemble the forward entry 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 - IPL Figure 16 for item numbers.

2. Assembly

- A. Consumable Materials

NOTE: Equivalent substitutes may be used.

| Reference | Description | Specification |
|-----------|---|---|
| A00247 | Sealant - Pressure And Environmental - Chromate Type | BMS 5-95 |
| A02315 | Sealant - Low Density, Synthetic Rubber. 2 Part | BMS5-142 |
| C00259 | Primer - Chemical And Solvent Resistant Finish, Epoxy Resin | BMS10-11, Type I |
| C00308 | Compound - Corrosion Preventive, Petrolatum Hot Application | MIL-C-11796 |
| C00913 | Compound - Corrosion Inhibiting Material, Nondrying Resin Mix | BMS 3-27 |
| D00013 | Grease - Aircraft And Instrument Grease | MIL-PRF-23827 (NATO G-354) (Supersedes MIL-G-23827) |
| D00015 | Grease - Aircraft Bearing (Use BMS 3-24 until existing stocks are depleted, BMS 3-33 supersedes BMS 3-24) | BMS3-24 (Superseded by BMS 3-33) |
| D00633 | Grease - Aircraft General Purpose | BMS3-33 |
| G50347 | Lockwire - Nickel-copper, 0.032 inch diameter | NASM20995N~ C32 |

- B. References

| Reference | Title |
|---------------|--|
| CMM 52-11-13 | FORWARD ENTRY DOOR BODY SIDE TORQUE TUBE BUILDUP |
| SOPM 20-30-02 | STRIPPING OF PROTECTIVE FINISHES |
| SOPM 20-41-01 | DECODING TABLE FOR BOEING FINISH CODES |
| SOPM 20-41-05 | APPLICATION OF CORROSION INHIBITING COMPOUNDS |
| SOPM 20-50-01 | BOLT AND NUT INSTALLATION |
| SOPM 20-50-02 | INSTALLATION OF SAFETYING DEVICES |
| SOPM 20-50-03 | BEARING AND BUSHING REPLACEMENT |
| SOPM 20-50-05 | APPLICATION OF ALUMINUM FOIL AND OTHER MARKERS |

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| Reference | Title |
|---------------|-------------------------|
| SOPM 20-50-19 | GENERAL SEALING |
| SOPM 20-60-02 | FINISHING MATERIALS |
| SOPM 20-60-03 | LUBRICANTS |
| SOPM 20-60-04 | MISCELLANEOUS MATERIALS |

C. Procedure

NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For application of corrosion inhibiting compound, refer to SOPM 20-41-05. For bolt and nut installation, refer to SOPM 20-50-01. For finishing materials, refer to SOPM 20-60-02. For lubricants, refer to SOPM 20-60-03. For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Use standard industry procedures and steps that follow to assemble this component.
- (2) Install the channel assembly (IPL Figure 7, 60) and the guide fitting assembly (15) onto the door structure as follows:
 - (a) Apply fay surface sealant, A00247 between the mating surfaces of the channel assembly (60) and the door structure.
 - (b) Install the channel assembly (60) onto the door structure with the bolts (50) and collars (55).
 - (c) Apply fay surface sealant, A00247 between the mating surfaces of the serrated plate (45) and the guide fitting assembly (15).
 - (d) Install the guide fitting assembly (15) onto the door structure with the bolts (5) and washers (10).
- (3) Install the window assembly (IPL Figure 6, 15, 100) onto the door structure as follows:
 - (a) Apply fay surface sealant, A00247 between the mating surfaces of the window assembly (15, 100) and the door structure.
 - (b) Install the window assembly (15, 100) onto the door structure with the screws (5) and washers (10). Tighten the screws (5) to 15-20 pound-inches.
- (4) Install the upper and lower support assemblies (IPL Figure 5, 45, 50) onto the door structure.
 - (a) Install the lower support assembly (IPL Figure 5, 50) as follows:
 - 1) Install the attach fitting (75) into the support (120) with the bolts (55) and washers (60).
 - 2) Install the lower support assembly (50) into the door structure with the bolts (25, 30), washers (35), and nuts (40).
 - (b) Install the upper support assembly (IPL Figure 5, 45) as follows:
 - 1) Install the attach fitting (75) into the support (115) with the bolts (55) and washers (60).
 - 2) Install the upper support assembly (45) into the door structure with the bolts (25, 30), washers (35), and nuts (40).
- (5) Install the hinge box assembly (IPL Figure 12, 170) onto the door structure as follows:
 - (a) Assemble the handle assembly (60) as follows:
 - 1) Apply grease, D00633 to the entire length of the pin (80). Also apply a light layer of grease, D00633 onto the spring (75).

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- 2) Install the spring (75), nut (70), and washer (105) onto the pin (80). Install the washer (105) onto the pin (80) with wet primer, C00259.
- 3) Secure the washer (105) onto the pin (80) with spring pin (65). Install the spring pin (65) onto the washer (105) with corrosion preventive compound, C00308.
- 4) Apply grease, D00013 onto the splines of the center shaft (85) and sleeve (115).
- 5) Install the center shaft (85) into the sleeve (115) with ring (120).
- 6) Install the pin (80) with associated parts into the center shaft (85).
- 7) Apply sealant, A00247 onto the mating surfaces of the cam (110) and sleeve (115). Apply wet primer, C00259 onto the mating surfaces of the sleeve (115) and the external handle (125).
- 8) Install the cam (110), the sleeve (115) and the associated parts onto the external handle (125) with bolts (90), washers (95), and nuts (100).

NOTE: Install the external handle (125) fasteners with wet primer, C00259 as specified in SOPM 20-50-01.

(b) Assemble the box assembly (170) as follows:

- 1) Install the bearings (280) onto the crank arms (285) as follows:
 - a) Apply corrosion preventive compound, C00308 to the threads of the cam bearing (280).
 - b) Install the bearing (280) onto the crank arm (285) with the washer (270) and nut (275).
 - c) Tighten the nut (275) to 55 pound-inch and then back off to the next castellation.
 - d) Install the cotter pin (265) onto the bearing (280) as specified in SOPM 20-50-02.
- 2) Install the bearing (310) into the housing (415) as follows:
 - a) Apply corrosion preventive compound, C00308 on the groove in the housing (415) for the ring (290).
 - b) Install the bearing (310) as specified in SOPM 20-50-03 with corrosion preventive compound, C00308.
 - c) Secure the bearing (310) into the housing (415) with the ring (290).
- 3) Install the bearings (365) into the housing (415) as follows:
 - a) Install the bearing (365) as specified in SOPM 20-50-03 with sealant, A00247.
 - b) Fillet seal the bearing (365) faces with sealant, A02315 as specified in SOPM 20-50-19.
- 4) Install the bearings (305) into the housing (415) as follows:
 - a) Install the bearing (305) as specified in SOPM 20-50-03 with sealant, A00247.
 - b) Apply corrosion preventive compound, C00308 to the faces of the bearing retainers (295) and the threads of bolts (210, 215) and nuts (250) as specified in SOPM 20-41-05.

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- c) Install the bearing retainer (295) onto the housing (415) with bolts (210, 215), washers (225, 235), and nuts (250).

NOTE: Install the bearing retainer fasteners as specified in SOPM 20-50-01. Make sure that 1.5-3.0 threads of the bolt (210, 215) protrude from the nut (250) for the bearing retainer (295) on the latching crank assembly side of the housing (415).

- 5) Install the bearings (300) into the housing (415) as follows:

a) Install the center shaft (85) into the sleeve (115) Install the bearing (300) as specified in SOPM 20-50-03 with corrosion preventive compound, C00308, as specified in SOPM 20-41-05.

- 6) Install the door latching crank assembly (320) into the housing (415) as follows:

a) Position the door latching crank assembly (320) and spacer (315) inside the housing (415).

b) Install the cam follower assembly (260) into the housing (415) through the bearing (305), door latching crank assembly (320), spacer (315), and bearing (300).

c) Apply corrosion preventive compound, C00308 on the threads of the bolt (220) and nut (255), as specified in SOPM 20-41-05.

d) Secure the cam following assembly (260) into the housing (415) with the bolt (220), washers (230, 240, 245) and nut (255).

NOTE: Install the cam follower assembly fasteners as specified in SOPM 20-50-01. Make sure that 1.5-3.0 threads of the bolt (210, 215) protrude from the nut (255).

- 7) Install the door cocking crank assembly (345) into the housing (415) as follows:

a) Position the spacer (340), and the door cocking crank assembly (345) in the housing (415).

b) Install the cam follower assembly (260) into the housing (415) through the bearing (305), spacer (315), door cocking crank assembly (345), and bearing (300).

c) Apply corrosion preventive compound, C00308 onto the threads of the bolt (220) and nut (255).

d) Secure the cam follower assembly (260) into the housing (415) with the bolt (220), washers (230, 240, 245), and nut (255).

NOTE: Install the cam follower assembly fasteners as specified in SOPM 20-50-01. Make sure that 1.5-3.0 threads of the bolt (210, 215) protrude from the nut (255).

- 8) Install the push rod assembly (185) into the housing (415) as follows:

a) Position the push rod assembly (185) with the door cocking crank assembly (345) inside the housing (415).

b) Apply corrosion preventive compound, C00308 onto the threads of the bolt (175).

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- c) Secure the push rod assembly (185) onto the door cocking crank assembly (345) with the bolt (175) and washer (180).

NOTE: Install the push rod assembly (185) fastener as specified in SOPM 20-50-01. Make sure that 1.5-3.0 threads of the bolt (185) protrude from the locknut (355).

- d) Temporarily restrain the free end of the push rod assembly (185) for shipping storage.

- (c) Install the handle assembly (60) into the box assembly (170) as follows:

- 1) Apply grease, D00633 to the internal cavity of the housing fitting (55). Also apply a light layer of grease, D00633 onto the packing (45, 50), as specified in SOPM 20-60-03.
- 2) Install the packing (50) on the groove inside the housing fitting (55).
- 3) Install the housing fitting (55) and packing (45) into the housing (415) with the bolt (35) and washer (40). Install the housing fitting (55) fasteners with corrosion preventive compound, C00308, as specified in SOPM 20-41-05.
- 4) Slide the handle assembly (60) into the housing fitting (55).
- 5) Apply compound, C00913 onto the mating surfaces of the cam plate assembly (20) and the center shaft (85), as specified in SOPM 20-41-05.
- 6) Apply compound, C00913 onto the mating surfaces of the cam plate assembly (20) and the follower crank assembly (260), as specified in SOPM 20-60-03.
- 7) Install the cam plate assembly (20) onto the handle assembly (60) with washer (10), nut (15), and cotter pin (5). Install the cotter pin (5) as specified in SOPM 20-50-02.

- (d) Install the hinge box assembly (170) into the door structure as follows:

- 1) Apply corrosion preventive compound, C00308 onto the mating surfaces of the hinge box assembly (170), the fillers (420, 425) and the door structure, as specified in SOPM 20-41-05.
- 2) Install the hinge box assembly (170) in the door structure with the bolts (130 thru 160) and washers (165). Install the fasteners with corrosion preventive compound, C00308, as specified in SOPM 20-41-05.

- (6) Install the hinge assembly (IPL Figure 11, 125B) onto the door structure, as follows:

- (a) Refer to CMM 52-11-13 for the repair and maintenance instructions for the hinge assembly (125B).
- (b) Install the packing (115) at each end of the torque tube (205) with grease, D00013.
- (c) Apply grease, D00015 to the mating surfaces of the door structure, sleeves (195), torque tube crank (200) and the torque tube (205).
- (d) Position the torque tube crank (200) between the bearings (IPL Figure 12, 365) in the door structure. Install the torque tube (IPL Figure 11, 205) in the door structure through the bearings (IPL Figure 12, 365) and the torque tube cranks (IPL Figure 11, 200).

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- (e) Secure the torque tube crank (200) onto the torque tube (205) with bolts (75), washers (95), and nuts (105). Tighten the nuts (105) to 58-63 pound-inches.
- NOTE:** The nut (105) is to bottom out on the bolt threads to avoid clamp up. Make sure that the shank of the bolt extends beyond the coupler. The maximum gap between the torque tube (205) and the washer (95) is 0.0160 inch. The maximum of two washers (95) is allowed under the nut (105).
- (f) Apply grease, D00015 to the mating surfaces of the special nuts (120) and the torque tube (205).
- (g) Install the special nuts (120) onto the torque tube (205). Tighten the special nuts (120) to hold the torque tube crank (200) in position against the bearings (IPL Figure 12, 365).
- (h) Install the sleeves (195) onto the torque tube (205) with bolts (70), washers (90), and nuts (100). Tighten the nuts (100) to within 28-33 pound-inch.
- NOTE:** The nut (100) is to bottom out on the bolt threads to avoid clamp up. Make sure that the shank of the bolt extends beyond the coupler. The maximum gap between the torque tube (205) and the washer (95) is 0.0160 inch. The maximum of two washers (90) is allowed under the nut (100).
- (i) Apply grease, D00015 to the mating surfaces of the arm assemblies (135, 140) and the torque tube (205). Wipe off unwanted grease after assembly.
- (j) Install the arm assemblies (135, 140) into the door structure and the torque tube (205) with nuts (15) and retainers (20).
- (k) Install the clip assemblies (25, 30) onto the arm assemblies (135, 140) with the bolt (5) and washers (10). Install the clip assembly with the bolts approximately at the center of the slot. The final location will be determined at door installation on the airplane.
- (l) Apply grease, D00013 at the tip of the torque tube (205) for initial lubrication.
- (m) Adjust the special nuts (120) to make the gap equal between the hinge arm assemblies (135, 140) and the housing assembly (IPL Figure 12, 370) to 0.0100 inch.
- (7) Install the support fitting assemblies (IPL Figure 8, 30 thru 45) and the housing assembly (105) from the door structure, as follows:
- (a) Install the housing assemblies (105) and retainers (100) onto the door structure with bolts (80), washers (85, 90), and nuts (95). Locate the fasteners to match the housing assembly.
- NOTE:** Install the support fittings (30 thru 45) with the lube fittings facing inboard.
- (b) Apply sealant, A00247 fay surface sealant onto the mating surfaces of the support fittings (30 thru 45) and the door structure.
- (c) Install the support fitting assemblies (30 thru 50) onto the door structure with the bolts (5, 10), washers (15), nuts (20). Locate the fasteners to match the housing assembly.
- (8) Install the lower and upper torque tube assemblies (IPL Figure 13, 25, 30) onto the door structure.
- (a) Install the lower torque tube assembly (IPL Figure 13, 30), as follows:
- NOTE:** Refer to 737 AMM 52-11-00/501 for the latch total-end-play shimming requirements and for the latch roller engagement and the torque tube centering requirements.

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- 1) Slide the lower tube (80) into the door structure through the support fittings (IPL Figure 8, 35, 45), bell crank (IPL Figure 13, 75), and the housing assembly (IPL Figure 8, 105).
 - 2) Apply a light layer of compound, C00913 onto the mating surfaces of the lower tube (IPL Figure 13, 80) and latching cranks (60). Also apply compound, C00913 onto the shank of the bolts (5, 10) and the holes for the bolts.
 - 3) Secure the bellcrank (75) onto the lower tube (80) with the bolts (10), washers (15), and nuts (20).

NOTE: Tighten the nut (20) to within 20-25 pound-inch. The nut is intended to bottom out the bolt threads to avoid clamp up. The maximum gap permitted between the washers and the tube is 0.0160 inches. Add extra washers as necessary.
 - 4) Install the latching cranks (60) onto the lower tube (80) with the bolts (5), washers (15), and nuts (20).

NOTE: Tighten the nut (20) to within 20-25 pound-inch. The nut is intended to bottom out on the bolt threads to avoid clamp up. The maximum gap permitted between the washers and the tube is 0.0160 inches. Add extra washers as necessary.
 - 5) Apply grease, D00633 to the latching cranks (60) at the support fittings (IPL Figure 8, 35, 45).
- (b) Install the upper torque tube assembly (IPL Figure 13, 25) as follows:
- NOTE:** Refer to 737 AMM 52-11-00/501 for the latch total-end-play shimming requirements and for the latch roller engagement and the torque tube centering requirements.
- 1) Slide the upper tube (80) into the door structure through the support fittings (IPL Figure 8, 30, 40), bellcranks (IPL Figure 13, 65, 70), and the housing assemblies (IPL Figure 8, 105).
 - 2) Apply a light layer of compound, C00913 onto the mating surfaces of the lower tube (IPL Figure 13, 25) and the latching cranks (60). Also apply compound, C00913 onto the shank of the bolts (5, 10) and the holes for the bolts.
 - 3) Secure the bellcranks (65, 70) onto the upper tube (80) with the bolts (10), washers (15), and nuts (20).

NOTE: Tighten the nut (20) to within 20-25 pound-inch. The nut is intended to bottom out on the bolt threads to avoid clamp up. The maximum gap permitted between the washers and the tube is 0.0160 inches. Add extra washers as necessary.
 - 4) Install the latching cranks (60) onto the upper tube (80) with the bolts (5), washers (15), and nuts (20).

NOTE: Tighten the nut (20) to within 20-25 pound-inch. The nut is intended to bottom out on the bolt threads to avoid clamp up. The maximum gap permitted between the washers and the tube is 0.0160 inches. Add extra washers as necessary.
 - 5) Apply grease, D00633 to the latching cranks (60) at the support fittings (IPL Figure 8, 30, 40).

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- (9) Install the lower and upper gate assemblies (IPL Figure 3, 90; IPL Figure 4, 65) onto the door structure.
- (a) Install the lower gate assembly (IPL Figure 4, 65) as follows:
- 1) Apply sealant, A00247 fay surface sealant onto the mating surfaces of the hinge assembly (40) and the door structure.
 - 2) Locate and align the hinge half of the hinge assembly (40) onto the edge of the door structure beam. Locate both ends of the hinge assembly (40) with the edge of the door structure beam.
 - 3) Install the lower gate assembly (65) and hinge assembly (40) onto the door structure the bolts (5, 10). Install bolts (5, 10) with corrosion preventive compound, C00308.
- (b) Install the upper gate assembly (IPL Figure 3, 90) as follows:
- 1) Apply sealant, A00247 fay surface sealant onto the mating surfaces of the hinge assembly (65) and the door structure.
 - 2) Locate and align the hinge half of the hinge assembly (65) onto the edge of the door structure beam. Locate both ends of the hinge assembly (65) with the edge of the door structure beam.
 - 3) Install the upper gate assembly (90) and hinge assembly (65) on the door structure with the bolts (5, 10, and 40) and collar (45). Install the bolts (5, 10, and 40) with corrosion preventive compound, C00308.
- (10) Install the lower and upper rod assemblies (IPL Figure 14, 55, 130, 135; IPL Figure 15, 55, 130) onto the door structure.
- (a) Install the lower rod assemblies (IPL Figure 15, 55, 130) as follows:
- 1) Install the lower push rod assembly (135) into the door structure as follows:
 - a) Apply compound, C00913 to the bolt (95, 105) shanks.
 - b) Connect one end of the lower push rod assembly (135) onto the hinge box assembly (IPL Figure 12, 170) with the bolt (105) and washer (110). Install the washer under the bolt head.
 - c) Connect the adjustable end of the lower push rod assembly (135) onto the lower latch torque tube assembly (IPL Figure 13, 30) with the bolt (95), washers (115), and nut (120). Orient the bolt from the forward side with a washer on the head of the bolt and a washer under the nut.

NOTE: Refer to 737 AMM 52-11-00/501 for the Latch Torque Tube Clocking. Orient the rod ends with the lube fitting inboard.
 - d) Apply grease, D00633 to the adjustable end of the lower pushrod assembly (135).
 - 2) Install the lower pushrod assembly (130) into the door structure as follows:
 - a) Connect the lower pushrod assembly (130) onto the lower latch torque tube assembly (IPL Figure 13, 30) with the bolt (100), washers (110, 115), nut (120), and the cotter pin (85).
 - b) Orient the bolt from the aft side with a washer on the head of the bolt and a washer under the nut. Orient the rod ends with the lube fitting inboard.
 - c) Apply grease, D00633 to the rod end of the lower push rod assembly (130).
 - 3) Install the lower stop rod assemblies (55) into the door structure as follows:

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- a) Position the lower stop rod assemblies (55) in between the intercostal assemblies inside the door structure.
 - b) Apply compound, C00913 to the bolts (15) shanks.
 - c) If necessary, locate the holes on the side of the intercostal assemblies of the door structure and drill 0.190-0.194 inch diameter holes for the lower stop rod assembly (55) fasteners.
 - d) Install the lower stop rod assemblies (55) onto the door structure intercostal assemblies with the bolts (15), washers (30, 35), and nuts (45).

NOTE: Make sure that the lower stop rod assemblies (55) lube fittings are oriented inboard. Refer to 737 AMM 52-11-00/501 for the rod length set up and rigging requirements for gate flushness.
 - e) Apply grease, D00633 to the rod end of the lower stop rod assemblies (55).
 - f) Install the lockwire, G50347 onto the lower stop rod assemblies (55) at the adjustable rod end side after rigging, as specified in SOPM 20-50-02.
- (b) Install the upper rod assemblies (IPL Figure 14, 55, 130, 135) as follows:
- 1) Install the upper push rod assembly (135) into the door structure as follows:
 - a) Apply compound, C00913 the bolt (95, 105) shanks.
 - b) Connect one end of the upper push rod assembly (135) onto the hinge box assembly (IPL Figure 12, 170) with the bolt (IPL Figure 14, 105) and washer (110). Install the washer under the bolt head.
 - c) Connect the adjustable end of the lower push rod assembly (135) onto the upper latch torque tube assembly (IPL Figure 13, 25) with the bolt (IPL Figure 14, 95), washers (115), nut (120). Orient the bolt from the aft side with a washer on the head of the bolt and a washer under the nut.

NOTE: Refer to 737 AMM 52-11-00/501 for the Latch Torque Tube Clocking. Orient the rod ends with lube fitting inboard.
 - d) Apply grease, D00633 to the adjustable end of the upper push rod assembly (135).
 - 2) Install the upper push rod assembly (130) into the door structure as follows:
 - a) Connect the upper push rod assembly (130) onto the upper latch torque tube assembly (IPL Figure 13, 25) with the bolt (IPL Figure 14, 100), washers (110, 115), nut (120), and the cotter pin (85).
 - b) Orient the bolt from the aft side with a washer on the head of the bolt and a washer under the nut. Orient the rod ends with the lube fitting inboard.
 - c) Apply grease, D00633 to the rod end of the upper push rod assembly (130).
 - 3) Install the upper stop rod assemblies (55) into the door structure as follows:
 - a) Position the upper stop rod assemblies (55) in between the intercostal assemblies inside the door structure.
 - b) Apply compound, C00913 to the bolt (15) shanks.
 - c) If necessary, locate the holes on the side of the intercostal assemblies of the door structure and drill 0.190-0.194 inch diameter holes for the upper stop rod assembly (55) fasteners.

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- d) Install the upper stop rod assemblies (55) onto the door structure intercostal assemblies with the bolts (15), washers (30, 35), and nut (45).
- NOTE:** Make sure that the upper stop rod assembly (55) lube fittings are oriented inboard. Refer to 737 AMM 52-11-00/501 for the rod length set up and rigging requirements for gate flushness.
- e) Apply grease, D00633 to the rod end of the upper stop rod assemblies (55).
- f) Install the lockwire, G50347 onto the upper stop rod assemblies (55) at the adjustable rod end side after rigging, as specified in SOPM 20-50-02.
- (11) Connect the lower and upper gate assemblies (IPL Figure 3, 90; IPL Figure 4, 65) from the lower and upper rod assemblies (IPL Figure 14, 55, 130; IPL Figure 15, 55, 130) as follows:
- (a) Connect the lower gate assembly (IPL Figure 4, 65) to the lower rod assemblies (IPL Figure 15, 55, 130) as follows:
- 1) Connect the lower push rod assembly (130) to the lower gate assembly (IPL Figure 4, 65) with the bolt (IPL Figure 15, 90), washers (110, 115), bushing (125), nut (120), and cotter pin (85).
 - 2) Connect the lower stop rod assemblies (55) to the lower gate assembly (IPL Figure 4, 65) with the bolts (10), washers (20, 25), bushings (50), nuts (40), and cotter pin (5).
- NOTE:** Make sure that the lower stop rod assemblies (55) lube fittings are oriented inboard. Refer to 737 AMM 52-11-00/501 for the rod length set up and rigging requirements for the gate flushness.
- 3) Install the lockwire, G50347 onto the lower stop rod assemblies (55) at the adjustable rod end side after rigging, as specified in SOPM 20-50-02.
 - 4) Apply grease, D00633 to the rod ends of the upper rod assemblies (55, 130) for initial lubrication after assembly.
- (b) Connect the upper gate assembly (IPL Figure 3, 90) to the upper rod assemblies (IPL Figure 14, 55, 130) as follows:
- 1) Connect the upper push rod assembly (130) to the upper gate assembly (IPL Figure 3, 90) with the bolt (IPL Figure 14, 90), washers (110, 115), bushing (125), nut (120), and the cotter pin (85).
 - 2) Connect the upper stop rod assembly (55) to the upper gate assembly (IPL Figure 3, 90) with the bolts (IPL Figure 14, 10), washers (20, 25), bushings (50), nuts (40), and the cotter pins (5).
- NOTE:** Make sure that the upper stop rod assembly (55) lube fittings are oriented inboard. Refer to 737 AMM 52-11-00/501 for the rod length set up and rigging requirements for the gate flushness.
- 3) Install the lockwire, G50347 onto the upper stop rod assemblies (55) at the adjustable rod end side after rigging, as specified in SOPM 20-50-02.
 - 4) Apply grease, D00633 to the rod ends of the upper rod assemblies (55, 130) for initial lubrication after assembly.
- (12) Install cantilever springs (IPL Figure 9, 95, 100), locators (50, 55, 60, 65), seal retainers (30, 35, 40, 45, 105, 110, 115, 120, 135, 140, 145, 150), and seal (160) on the door structure as follows:

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- (a) Apply fay surface sealant, A00247 between the mating surfaces of retainers (135, 140, 145, 150), seal (160), and the lower and upper gate assemblies (IPL Figure 3, 90; IPL Figure 4, 65).
- (b) If necessary, punch 7/32 diameter holes through seal (IPL Figure 9, 160) to match the lower and upper gate assembly (IPL Figure 3, 90; IPL Figure 4, 65) fastener holes.
- (c) Install seal (IPL Figure 9, 160) and retainers (135, 140) onto the upper gate assembly (IPL Figure 3, 90) with screws (IPL Figure 9, 125) and washers (130). Install the fasteners with wet sealant, A00247.
- (d) Install seal (IPL Figure 9, 160), retainers (145, 150), and seal insert (155) onto the lower gate assembly (IPL Figure 4, 65) with screws (IPL Figure 9, 125) and washers (130). Install the fasteners with wet sealant, A00247.

NOTE: Position the ends of the seal insert (155) between the tangent points of the seal (160).

- (e) If necessary, punch 7/32 diameter holes through seal (160) to match the hinge assembly fastener holes for the lower and upper gate assemblies (IPL Figure 3, 90; IPL Figure 4, 65). And also punch 7/32 diameter holes through seal (IPL Figure 9, 160) to match retainer (105, 115) holes for the door structure.
- (f) Install seal (160) and retainers (105, 110) onto the upper gate assembly (IPL Figure 3, 90) and door structure with screws (IPL Figure 9, 70, 80) and washers (85). Install the fasteners with wet sealant, A00247.
- (g) Install cantilever springs (95, 100) and clamp (90) onto the upper gate assembly (IPL Figure 3, 90) with screws (IPL Figure 9, 75) and washers (85). Install the fasteners with wet sealant, A00247.

NOTE: If necessary, bend the cantilever spring (95, 100) at point "A" to the center loop between the door structure and gate assembly. Refer to 737 AMM 52-11-00/501 for point "A" location.

- (h) Install the seal (160) and retainers (115, 120) onto the lower gate assembly (IPL Figure 4, 65) and door structure with the screws (IPL Figure 9, 70, 80) and washers (85). Install the fasteners with wet sealant, A00247.
- (i) Install the cantilever springs (95, 100) and clamp (90) onto the lower gate assembly (IPL Figure 4, 65) with the screws (IPL Figure 9, 75) and washers (85). Install the fasteners with wet sealant, A00247.

NOTE: If necessary, bend the cantilever spring (95, 100) at point "A" to the center loop between the door structure and gate assembly. Refer to 737 AMM 52-11-00/501 for point "A" location.

- (j) Apply sealant, A00247 fay surface sealant between the mating surfaces of the retainers (30, 35, 40, 45), seal (160), locators (50, 55, 60, 65), and the door structure.
- (k) Position the retainers (30, 35, 40, 45) and locators (50, 55, 60, 65) onto the door structure.
- (l) Match drill 0.187-0.197 inch diameter holes through the retainers (30, 35, 40, 45), locators (50, 55, 60, 65), and door structure. If necessary, punch 3/16 inch diameter holes through the seal (160) to match the retainers (30, 35, 40, 45) and locators (50, 55, 60, 65).

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- (m) Install the seal (160), retainers (115, 120), and locators (50, 55, 60, 65) onto the door structure with the screws (5) and washers (10), and nuts (15, 20, 25, 27A, 28A). Install the nuts (15, 20, 25, 27A, 28A) through the locators. Install the fasteners with wet sealant, A00247.
- NOTE:** The constant distance from the outboard surface of the seal locators (50, 55, 60, 65), and the mold line of the seal (160) is 0.3400 inch.
- (13) Install the cam cover assembly (IPL Figure 10, 145) and the access panels (75, 80, 120, 125) onto the door structure as follows:
- Apply primer, C00259 into the fastener holes of the door structure for the access panel (120).
 - Install the access panel (120) onto the door structure with the bolts (85, 90, 95) and the washers (100). Install the bolts with corrosion preventive compound, C00308.
 - Install the cover (170) onto the door structure with the studs (150), washers (155, 160), and the ring (165).
 - Apply primer, C00259 into the fastener holes of the door structure for the access panel (120).
 - Install the access panel (125) onto the door structure with the bolts (85, 95) and the washers (100). Install the bolts with corrosion preventive compound, C00308.
 - Apply sealant, A00247 fay surface sealant onto the mating surfaces of the door structure and the access panel (80).
 - Install the access panel (80) onto the door structure with the rivets (30, 40, 45, 50). Install the rivets with wet sealant, A00247.
 - Apply sealant, A00247 fay surface sealant onto the mating surfaces of the door structure and the access panel (75). Apply primer, C00259 into the bolt hole on the door structure for the access panel (75).
 - Install the access panel (75) onto the door structure with the bolt (10), washer (25), and the rivets (30, 35). Install the bolt with corrosion preventive compound, C00308. Install the rivets with wet sealant, A00247.
- (14) Install the stop (170, 175), slide support fitting assembly (120), slide support fitting (115), and the handle bracket assembly (IPL Figure 16, 15) onto the door structure as follows:
- Install the stops (170, 175) onto the door structure with the bolt (160) and nuts (165).
 - Install the slide support fitting assembly (120) onto the door structure with the bolts (75, 80), washers (85, 90), nuts (100, 105), and retainer (110).
 - Install the slide support fitting (115) onto the door structure with bolts (70, 75, 80), washers (85, 90), collar (95), nuts (100, 105), and retainer (110). Install the bolt (70) with wet sealant, A00247.
 - Install the handle bracket assembly (15) onto the door structure with the bolt (5) and washers (10).
- (15) Adjust the door assembly mechanism as follows:
- With the push rod assemblies (IPL Figure 14, 135 and IPL Figure 15, 130) not connected onto the latching cranks (IPL Figure 13, 60), install the setting tool, F80178-1, through the holes in the door inner skin.

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- (b) Adjust the tool so that the notches in the clamp feet mate with the latching cranks on the torque tube.
 - (c) Rotate the latch torque tube assemblies (IPL Figure 13, 25, 30) so that the bearings (55) touch the setting blocks on the tool. Tighten the tool clamps with the bearing (55) in contact.
 - (d) Turn the handle assembly (IPL Figure 12, 60) to the closed position. The bearings (IPL Figure 13, 55) on the latching cranks (60) must bottom out in the cam plate assembly (IPL Figure 12, 20). Secure the handle assembly (60) in this position.
 - (e) Adjust the lengths of the push rod assemblies (IPL Figure 14, 135 and IPL Figure 15, 130) to align the rod ends with the holes in the latching cranks (IPL Figure 13, 60).
 - (f) Install the bolts (IPL Figure 14, 95; IPL Figure 15, 100), the washers (IPL Figure 14, 110, 115; IPL Figure 15, 110, 115), the nuts (IPL Figure 14, 120; IPL Figure 15, 120), and the cotter pins (IPL Figure 14, 85; IPL Figure 15, 85).
 - (g) Hold the upper and lower gates assemblies (IPL Figure 1, 10, 15) in the fared position in relation to the outer door assembly contour.
 - (h) Adjust the lengths of the push rod assemblies (IPL Figure 14, 130; IPL Figure 15, 130) to align the rod ends with the holes in the gate assemblies (IPL Figure 1, 10, 15).
 - (i) Install the bolts (IPL Figure 14, 90; IPL Figure 15, 90), the washers (IPL Figure 14, 110, 115; IPL Figure 15, 110, 115), the bushings (IPL Figure 14, 125; IPL Figure 15, 125), the nuts (IPL Figure 14, 120, IPL Figure 15, 120), and the cotter pins (IPL Figure 14, 85; IPL Figure 15, 85) onto the push rod assemblies (IPL Figure 14, 130; IPL Figure 15, 130) and the gate assemblies (IPL Figure 1, 10, 15).
 - (j) Make sure that the nuts (IPL Figure 14, 145; IPL Figure 15, 145) on the push rod assemblies (IPL Figure 14, 130; IPL Figure 15, 130) are tightened to 60 pound-inches.
 - (k) Remove the setting tool, F80178-1, from the door assembly.
 - (l) Adjust the lengths of the stop rod assemblies (IPL Figure 14, 55; IPL Figure 15, 55) so that the stop rod shoulder contacts the bearing assembly (IPL Figure 14, 75; IPL Figure 15, 75).
 - (m) Back off the stop rods to the nearest notch to position the washers (IPL Figure 14, 65; IPL Figure 15, 65) correctly. Tighten the nuts (IPL Figure 14, 60; IPL Figure 15, 60).
- (16) If necessary, install the plate (85) and the marker (90) onto the door structure as specified in SOPM 20-50-05.

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FITS AND CLEARANCES

| REF IPL | | NAME | TORQUE* | |
|----------|----------|-------|--------------|------------|
| FIG. NO. | ITEM NO. | | POUND-INCHES | POUND-FEET |
| 1 | 100 | Nut | 28-33 | |
| 1 | 105 | Nut | 58-63 | |
| 6 | 5 | Screw | 15-20 | |
| 12 | 275 | Nut | 55 | |
| 13 | 20 | Nut | 20-25 | |
| 14 | 145 | Nut | 60 Max | |
| 15 | 145 | Nut | 60 Max | |

* REFER TO SOPM 20-50-01 FOR TORQUE VALUES OF STANDARD FASTENERS.

M22702 S00041000617_V3

Torque Table
Figure 801

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SPECIAL TOOLS, FIXTURES, AND EQUIPMENT

(NOT APPLICABLE)

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SPECIAL TOOLS, FIXTURES, AND EQUIPMENT

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ILLUSTRATED PARTS LIST

1. Introduction

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

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

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

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

VENDOR CODES

| Code | Name |
|-------------|--|
| 02758 | NETWORKS ELECTRONIC CORP U S BEARING DIV 9750 DE SOTO AVENUE CHATSWORTH, CALIFORNIA 91311-4409 FORMERLY U S BEARING DIV NETWORKS ELEC CORP |
| 06710 | LAMSON AND SESSIONS CO THE VALLEY-TODECO 12975 BRADLEY AVENUE SYLMAR, CALIFORNIA 91342-3830 FORMERLY VALLEY BOLT CORP VB0097 IN NORTH HOLLYWOOD, CA |
| 06725 | AIR INDUSTRIES CORPORATION 12570 KNOTT STREET GARDEN GROVE, CALIFORNIA 92641-3932 FORMERLY AIR INDUSTRIES OF CALIF IN GARDENA, CALIF. |
| 06950 | SCREWCORP VSI AEROSPACE PRODUCTS DIV FAIRCHILD IND DIV 13001 EAST TEMPLE AVENUE PO BOX 730 CITY OF INDUSTRY, CALIFORNIA 91746-1417 FORMERLY VB0096 AND VSI CORP SCREWCORP DIV FORMERLY IN CULVER CITY, CALIFORNIA SCREW CORP SEE V.S.I. CORP SCREWCORP DIVISION |
| 07484 | ACCURATE BUSHING CO INC 443 NORTH AVENUE GARWOOD, NEW JERSEY 07027-1014 FORMERLY V83132 SMITH BRG DIV OF ACCURATE BUSHING CO |

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| Code | Name |
|-------|---|
| 09455 | RBC TRANSPORT DYNAMICS CORP 3131 W SEGERSTROM AVE SANTA ANA, CALIFORNIA 92704-5872 FORMERLY TRANSPORT DYNAMICS AEROSPACE DIV; FABROID DIV TRANSPORT DYNAMICS V17571 & LEAR SEIGLER INC TRANSPORT DIV V98076; FORMERLY BFM TRANSPORT DYNAMICS |
| 0PTK6 | 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 |
| 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 |
| 15860 | NEW HAMPSHIRE BALL BEARINGS, INC ASTRO DIVISION 155 LEXINGTON AVENUE LACONIA, NEW HAMPSHIRE 03246-2937 FORMERLY ASTRO BEARING CORP, LOS ANGELES, CALIF. |
| 16746 | SPECLINE INCORPORATED 2230 MOUTON DR CARSON CITY, NV 89706 FORMERLY IN SUN VALLEY, CAIFORNIA |
| 17446 | HUCK INTL INC AEROSPACE FASTENER DIV 900 WATSON CENTER ROAD CARSON, CALIFORNIA 90745-4201 FORMERLY V32134 REXNORD INC; FORMERLY V97928 HUCK INTL |

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| Code | Name |
|-------|--|
| 21335 | TIMKEN US CORPORATION DIV FAFNIR 336 MECHANIC STREET LEBANON, NH 03766-0267 FORMERLY FAFNIR BRG AND TEXTRON INC FAFNIR DIV IN NEW BRITAIN, CONNECTICUT ; FORMERLY TORRINGTON CO THE SPECIAL PRODUCTS DIV SUB OF THE INGERSOLL-RAND CO V8D210 FORMERLY TORRINGTON CO FAFNIR BEARING DIV IN TORRINGTON, CT |
| 21760 | SCHATZ BEARING CORP 10 FAIRVIEW AVENUE PO BOX 1191 POUGHKEEPSIE, NEW YORK 12601-1312 FORMERLY FEDERAL BRG CO AND SCHATZ MFG CO V53268 FORMERLY SCHATZ MFG CO |
| 27238 | BRISTOL INDUSTRIES 630 EAST LAMBERT ROAD PO BOX 630 BREA, CALIFORNIA 92621-4119 |
| 40920 | MPB MINIATURE PRECISION BEARING DIV PRECISION PARK PO BOX 547 KEENE, NEW HAMPSHIRE 03431 FORMERLY MPB CORP AND MINIATURE BRG DIV MPB CORP |
| 50632 | KAMATICS CORP SUB OF KAMAN CORP 1335 BLUE HILLS ROAD BLOOMFIELD, CONNECTICUT 06002-1304 |
| 52828 | REPUBLIC FASTENER MFG CORP 1300 RANCHO CONEJO BLVD NEWBURY PARK, CALIFORNIA 91320-1405 FORMERLY IN SYLMAR, CALIFORNIA |
| 53551 | ALLFAST FASTENING SYSTEMS INC 15200 EAST DON JULIAN ROAD PO BOX 3166 CITY OF INDUSTRY, CALIFORNIA 91745-1001 FORMERLY V0736B FORMERLY ALLFAST INC V5K545 |
| 56644 | AURORA BEARING CO 970 SOUTH LAKE STREET AURORA, ILLINOIS 60506-5929 |

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| Code | Name |
|-------|--|
| 56878 | SPS TECHNOLOGIES INC AEROSPACE AND INDUSTRIAL PRODUCTS DIV 301 HIGHLAND AVE JENKINTOWN, PENNSYLVANIA 19046 FORMERLY STANDARD PRESSED STEEL FORMERLY IN SALT LAKE, UTAH |
| 57606 | REXNORD CORP PSI BEARINGS DIV 2175 UNION PL SIMI VALLEY, CALIFORNIA 93065-1661 FORMERLY PSI BEARINGS |
| 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 |
| 60380 | TORRINGTON CO BEARINGS DIV SUBSIDIARY OF INGERSOLL-RAND CORP 59 FIELD STREET PO BOX 1008 TORRINGTON, CONNECTICUT 06790-1008 FORMERLY TORRINGTON BEARING COMPANY |
| 60516 | WEST COAST AEROSPACE INC 812 MIRAFLORES STREET SAN PEDRO, CALIFORNIA 90731-1439 |
| 62554 | SIMMONDS MECAERO FASTENERS INC 1734 SEQUOIA AVENUE ORANGE, CALIFORNIA 92668 |
| 71985 | DOW-ELCO INCORPORATED 1313 W OLYMPIC BOULEVARD, PO BOX 669 MONTEBELLO, CALIFORNIA 90641-5010 |
| 72962 | HARVARD INDUSTRIES INC 3 WERNER WAY SUITE 210 LEBANON, NEW JERSEY 08833 FORMERLY ESNA V7A079 FORMERLY ELASTIC STOP NUT IN UNION, NJ |

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COMPONENT MAINTENANCE MANUAL

| Code | Name |
|-------|--|
| 73134 | ROLLER BEARING COMPANY OF AMER DBA HEIM BEARINGS DIV 60 ROUND HILL RD FAIRFIELD, CONNECTICUT 06430-0000 FORMERLY INCOM INTL HEIM DIV; HEIM UNIVERSAL CORP INCOM; FORMERLY HEIM DIV INCOM INTL; IMO IND HEIM BEARINGS DIV |
| 73197 | HI-SHEAR TECHNOLOGY CORP 2600 SKYPARK DRIVE TORRANCE, CALIFORNIA 90509 |
| 77896 | REXNORD INC BEARING OPERATION 2400 CURTIS STREET DOWNERS GROVE, ILLINOIS 60515-4005 FORMERLY SHAEFER BEARING DIV REX CHAINBELT FORMERLY REX CHAINBELT INC BEARING DIV. |
| 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 |
| 81376 | SMITH ACQUISITION COMPANY 2240 BUENA VISTA BALDWIN PARK, CALIFORNIA 91706 |
| 83086 | NEW HAMPSHIRE BALL BEARING, INC HITECH DIVISION 172 JAFFREY ROAD PETERBOROUGH, NEW HAMPSHIRE 03458 |
| 92215 | FAIRCHILD IND INC FAIRCHILD AEROSPACE FASTENER DIV 3010 W LOMITA BLVD TORRANCE, CALIFORNIA 90505-5102 FORMERLY VOI-SHAN IN CULVER CITY, CALIF |
| 92563 | MCGILL MFG CO INC BEARINGS DIV 909 LAFAYETTE STREET VALPARAISO, INDIANA 46383-4210 |

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COMPONENT MAINTENANCE MANUAL

| Code | Name |
|-------|--|
| 94222 | SOUTHCO INCORPORATED 210 NORTH BRINTONLAKE RD PO BOX 116 CONCORDVILLE, PENNSYLVANIA 19331-0116 FORMERLY SOUTH CHESTER CORP. SOUTHCO DIVN V24248 FORMERLY IN LESTER, PENNSYLVANIA |
| 97393 | SHUR-LOK CORPORATION 2541 WHITE ROAD PO BOX 19584 IRVINE, CALIFORNIA 92623-9584 FORMERLY SHUR LOK CORP VB0060 FORMERLY IN SANTA ANA, CALIFORNIA 92714 |
| 97613 | SARGENT CONTROLS & AEROSPACE/KAHR BEARING DIV 5675 W BURLINGAME RD TUCSON, ARIZONA 85743 FORMERLY AETNA STEEL PROD KAHR BEARING DIV V96579 FORMERLY SARGENT IND KAHR BEARING DIV, BURBANK, CALIFORNIA |
| 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 |
| 98996 | OLYMPIC FASTENING SYSTEMS INC DOWNEY, CALIFORNIA 90241-4986 OBSOLETE RECORD |
| 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 |
| F0224 | SIMMONDS SA FAIRCHILD FASTENERS ST COSME ST COSME EN VAIRAIS F-72580, FRANCE |
| S0352 | NIPPON MINIATURE BEARING CO LTD TOKYO, JAPAN |

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NUMERICAL INDEX

| PART NUMBER | AIRLINE PART NUMBER | FIGURE | ITEM | UNITS PER ASSEMBLY |
|--------------|---------------------|--------|------|--------------------|
| 10-60779-164 | | 12 | 200 | 2 |
| 102A9201-3 | | 10 | 60 | 1 |
| 102A9201-82 | | 10 | 70 | 2 |
| 102A9207P4 | | 5 | 70 | 4 |
| 102A9212-4 | | 16 | 130 | 2 |
| | | 16 | 133 | 1 |
| 102F177-3 | | 11 | 165 | 1 |
| 102F177-4 | | 12 | 385 | 12 |
| 102F9201-3 | | 2 | 335 | 8 |
| | | 2 | 425 | 8 |
| | | 3 | 30 | 16 |
| | | 4 | 30 | 1 |
| | | 4 | 85A | 2 |
| | | 7 | 75 | 2 |
| | | 10 | 110 | 32 |
| 102F9202-3-3 | | 7 | 70 | 1 |
| 102F9206-3-3 | | 3 | 110 | 28 |
| | | 4 | 90 | 26 |
| 102F9209M3 | | 3 | 25 | 3 |
| | | 4 | 20 | 6 |
| | | 4 | 85 | 2 |
| | | 10 | 65 | 1 |
| | | 10 | 115 | 14 |
| 102F9219-3 | | 4 | 25 | 20 |
| 102LH9075-3W | | 16 | 165 | 2 |
| 10E4-116 | | 14 | 70 | 1 |
| | | 14 | 155 | 1 |
| | | 15 | 70 | 1 |
| | | 15 | 155 | 1 |
| 10E4-116NW | | 14 | 70 | 1 |
| | | 14 | 155 | 1 |
| | | 15 | 70 | 1 |
| | | 15 | 155 | 1 |
| 141A6100-678 | | 1 | 1A | RF |

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| PART NUMBER | AIRLINE PART NUMBER | FIGURE | ITEM | UNITS PER ASSEMBLY |
|-------------|---------------------|--------|------|--------------------|
| 141A6101-1 | | 1 | 5 | 1 |
| | | 2 | 1A | RF |
| 141A6101-2 | | 1 | 5A | 1 |
| | | 2 | 1B | RF |
| 141A6101-3 | | 1 | 5B | 1 |
| | | 1 | 5C | 1 |
| | | 2 | 1C | RF |
| | | 2 | 1D | RF |
| 141A6101-4 | | 1 | 5D | 1 |
| | | 2 | 1E | RF |
| 141A6101-5 | | 1 | 5E | 1 |
| | | 2 | 1F | RF |
| 141A6101-6 | | 1 | 5F | 1 |
| | | 2 | 1G | RF |
| 141A6101-7 | | 1 | 5G | 1 |
| | | 2 | 1H | RF |
| 141A6103-1 | | 2 | 45 | 1 |
| 141A6103-10 | | 2 | 640 | 1 |
| 141A6103-11 | | 2 | 50 | 1 |
| | | 2 | 230 | 1 |
| 141A6103-12 | | 2 | 65 | 1 |
| | | 2 | 245 | 1 |
| 141A6103-13 | | 2 | 285 | 1 |
| 141A6103-14 | | 2 | 300 | 1 |
| 141A6103-15 | | 2 | 375 | 1 |
| 141A6103-16 | | 2 | 390 | 1 |
| 141A6103-17 | | 2 | 475 | 1 |
| 141A6103-18 | | 2 | 490 | 1 |
| 141A6103-19 | | 2 | 525 | 1 |
| 141A6103-2 | | 2 | 60 | 1 |
| 141A6103-20 | | 2 | 535 | 1 |
| 141A6103-23 | | 2 | 630 | 1 |
| 141A6103-24 | | 2 | 645 | 1 |
| 141A6103-25 | | 2 | 285A | 1 |
| 141A6103-26 | | 2 | 300A | 1 |

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| PART NUMBER | AIRLINE PART NUMBER | FIGURE | ITEM | UNITS PER ASSEMBLY |
|-------------|---------------------|--------|------|--------------------|
| 141A6103-27 | | 2 | 575 | 1 |
| 141A6103-28 | | 2 | 590 | 1 |
| 141A6103-3 | | 2 | 235 | 1 |
| | | 2 | 290 | 1 |
| 141A6103-4 | | 2 | 250 | 1 |
| | | 2 | 305 | 1 |
| 141A6103-5 | | 2 | 380 | 1 |
| 141A6103-6 | | 2 | 395 | 1 |
| 141A6103-7 | | 2 | 470 | 1 |
| | | 2 | 570 | 1 |
| 141A6103-8 | | 2 | 485 | 1 |
| | | 2 | 585 | 1 |
| 141A6103-9 | | 2 | 625 | 1 |
| 141A6104-10 | | 2 | 685A | 1 |
| 141A6104-19 | | 2 | 185A | 1 |
| 141A6104-20 | | 2 | 195A | 1 |
| 141A6104-3 | | 2 | 185 | 1 |
| 141A6104-4 | | 2 | 195 | 1 |
| 141A6104-5 | | 2 | 670 | 1 |
| 141A6104-6 | | 2 | 685 | 1 |
| 141A6104-7 | | 2 | 675 | 1 |
| 141A6104-8 | | 2 | 690 | 1 |
| 141A6104-9 | | 2 | 670A | 1 |
| 141A6107-1 | | 2 | 350 | 1 |
| 141A6107-2 | | 2 | 440 | 1 |
| 141A6110-1 | | 2 | 700 | 1 |
| 141A6110-2 | | 2 | 705 | 1 |
| 141A6110-3 | | 2 | 705A | 1 |
| 141A6111-1 | | 1 | 80 | 1 |
| | | 1 | 80A | 1 |
| 141A6118-1 | | 2 | 697 | 1 |
| 141A6118-2 | | 2 | 697A | 1 |
| 141A6120-10 | | 2 | 155 | 1 |
| 141A6120-13 | | 2 | 655A | 1 |
| 141A6120-14 | | 2 | 260A | 1 |

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| PART NUMBER | AIRLINE PART NUMBER | FIGURE | ITEM | UNITS PER ASSEMBLY |
|-------------|---------------------|--------|------|--------------------|
| 141A6120-15 | | 2 | 545 | 1 |
| 141A6120-16 | | 2 | 315A | 1 |
| 141A6120-17 | | 2 | 405A | 1 |
| 141A6120-18 | | 2 | 155A | 1 |
| 141A6120-2 | | 2 | 205 | 1 |
| 141A6120-3 | | 2 | 260 | 1 |
| 141A6120-4 | | 2 | 315 | 1 |
| 141A6120-5 | | 2 | 405 | 1 |
| 141A6120-6 | | 2 | 500 | 1 |
| 141A6120-8 | | 2 | 600 | 1 |
| 141A6120-9 | | 2 | 655 | 1 |
| 141A6121-10 | | 2 | 695 | 1 |
| 141A6121-11 | | 2 | 35 | 1 |
| 141A6121-12 | | 2 | 695A | 1 |
| 141A6121-13 | | 2 | 200 | 1 |
| 141A6121-14 | | 2 | 310A | 1 |
| 141A6121-15 | | 2 | 595 | 1 |
| 141A6121-16 | | 2 | 400A | 1 |
| 141A6121-17 | | 2 | 495A | 1 |
| 141A6121-18 | | 2 | 200A | 1 |
| 141A6121-2 | | 2 | 255 | 1 |
| 141A6121-3 | | 2 | 310 | 1 |
| 141A6121-4 | | 2 | 40 | 1 |
| 141A6121-5 | | 2 | 400 | 1 |
| 141A6121-6 | | 2 | 495 | 1 |
| 141A6121-7 | | 2 | 540 | 1 |
| 141A6121-9 | | 2 | 650 | 1 |
| 141A6143-5 | | 5 | 130 | 1 |
| 141A6143-6 | | 5 | 135 | 1 |
| 141A6143-7 | | 5 | 140 | 1 |
| 141A6143-8 | | 5 | 145 | 1 |
| 141A6145-1 | | 5 | 15 | 2 |
| 141A6145-10 | | 2 | 115A | 1 |
| 141A6145-11 | | 2 | 105A | 1 |
| | | 2 | 105C | 1 |

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| PART NUMBER | AIRLINE PART NUMBER | FIGURE | ITEM | UNITS PER ASSEMBLY |
|-------------|---------------------|--------|------|--------------------|
| 141A6145-12 | | 2 | 105B | 1 |
| | | 2 | 105D | 1 |
| 141A6145-2 | | 5 | 20 | 2 |
| 141A6145-3 | | 2 | 105 | 1 |
| 141A6145-5 | | 8 | 100 | 3 |
| 141A6145-7 | | 2 | 110 | 1 |
| 141A6145-8 | | 2 | 115 | 1 |
| 141A6145-9 | | 2 | 110A | 1 |
| 141A6150-1 | | 1 | 3 | RF |
| 141A6150-2 | | 1 | 3A | RF |
| 141A6150-3 | | 1 | 3B | RF |
| 141A6150-4 | | 1 | 3C | RF |
| 141A6150-5 | | 1 | 3D | RF |
| 141A6150-6 | | 1 | 3E | RF |
| 141A6150-7 | | 1 | 3F | RF |
| 141A6150-8 | | 1 | 3G | RF |
| 141A6170-1 | | 1 | 10 | 1 |
| | | 3 | 1A | RF |
| 141A6170-2 | | 1 | 10A | 1 |
| | | 1 | 10B | 1 |
| | | 3 | 1B | RF |
| | | 3 | 1C | RF |
| 141A6170-3 | | 1 | 10C | 1 |
| | | 3 | 1D | RF |
| 141A6171-1 | | 3 | 90 | 1 |
| 141A6171-2 | | 3 | 115 | 1 |
| 141A6171-4 | | 3 | 115A | 1 |
| 141A6171-5 | | 3 | 90B | 1 |
| 141A6180-1 | | 1 | 15 | 1 |
| | | 4 | 1A | RF |
| 141A6180-2 | | 1 | 15A | 1 |
| | | 1 | 15B | 1 |
| | | 4 | 1B | RF |
| | | 4 | 1C | RF |
| 141A6181-1 | | 4 | 65 | 1 |

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| PART NUMBER | AIRLINE PART NUMBER | FIGURE | ITEM | UNITS PER ASSEMBLY |
|-------------|---------------------|--------|------|--------------------|
| 141A6181-2 | | 4 | 95 | 1 |
| 141A6181-4 | | 4 | 95A | 1 |
| 141A6181-5 | | 4 | 65B | 1 |
| 141A6183-1 | | 4 | 40 | 1 |
| 141A6183-2 | | 3 | 65 | 1 |
| 141A6184-1 | | 3 | 80 | 1 |
| | | 4 | 55 | 1 |
| 141A6184-2 | | 4 | 60 | 1 |
| 141A6184-3 | | 3 | 85 | 1 |
| 141A6187-1 | | 3 | 50 | 1 |
| 141A6187-2 | | 3 | 55 | 1 |
| 141A6190-1 | | 1 | 20 | 1 |
| | | 1 | 20A | 1 |
| | | 5 | 1A | RF |
| | | 5 | 1B | RF |
| 141A6200-1 | | 1 | 25 | 1 |
| | | 1 | 25A | 1 |
| | | 6 | 1A | RF |
| | | 6 | 1B | RF |
| 141A6200-2 | | 1 | 25B | 1 |
| | | 6 | 1C | RF |
| 141A6201-1 | | 6 | 80 | 1 |
| 141A6201-2 | | 6 | 95 | 1 |
| 141A6205-1 | | 1 | 30 | 1 |
| | | 1 | 30A | 1 |
| | | 7 | 1A | RF |
| | | 7 | 1B | RF |
| 141A6209-1 | | 7 | 15 | 1 |
| 141A6210-1 | | 1 | 95 | 1 |
| | | 17 | 1A | RF |
| 141A6211-1 | | 17 | 15 | 1 |
| 141A6212-1 | | 7 | 45 | 1 |
| 141A6213-1 | | 7 | 60 | 1 |
| 141A6214-1 | | 7 | 85 | 1 |
| 141A6215-1 | | 17 | 10 | 1 |

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| PART NUMBER | AIRLINE PART NUMBER | FIGURE | ITEM | UNITS PER ASSEMBLY |
|-------------|---------------------|--------|------|--------------------|
| 141A6216-1 | | 7 | 35 | 1 |
| 141A6217-1 | | 7 | 30 | 1 |
| 141A6220-1 | | 1 | 35 | 1 |
| | | 1 | 35A | 1 |
| | | 8 | 1A | RF |
| | | 8 | 1B | RF |
| 141A6221-1 | | 8 | 30 | 1 |
| 141A6221-2 | | 8 | 60 | 1 |
| 141A6221-3 | | 8 | 35 | 1 |
| 141A6221-4 | | 8 | 65 | 1 |
| 141A6221-5 | | 8 | 40 | 1 |
| 141A6221-6 | | 8 | 70 | 1 |
| 141A6221-7 | | 8 | 45 | 1 |
| 141A6221-8 | | 8 | 75 | 1 |
| 141A6240-1 | | 1 | 40 | 1 |
| | | 9 | 1A | RF |
| 141A6240-2 | | 1 | 40A | 1 |
| | | 9 | 1B | RF |
| 141A6240-3 | | 1 | 40B | 1 |
| | | 9 | 1C | RF |
| 141A6240-4 | | 1 | 40C | 1 |
| | | 1 | 40D | 1 |
| | | 9 | 1D | RF |
| | | 9 | 1E | RF |
| 141A6240-5 | | 1 | 40E | 1 |
| | | 9 | 1F | RF |
| 141A6241-1 | | 9 | 60 | 1 |
| 141A6241-10 | | 9 | 120 | 1 |
| 141A6241-11 | | 9 | 145 | 1 |
| 141A6241-12 | | 9 | 150 | 1 |
| 141A6241-13 | | 9 | 135 | 1 |
| 141A6241-14 | | 9 | 140 | 1 |
| 141A6241-15 | | 9 | 115 | 1 |
| 141A6241-16 | | 9 | 145A | 1 |
| 141A6241-17 | | 9 | 150A | 1 |

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| PART NUMBER | AIRLINE PART NUMBER | FIGURE | ITEM | UNITS PER ASSEMBLY |
|-------------|---------------------|--------|------|--------------------|
| 141A6241-18 | | 9 | 140A | 1 |
| 141A6241-19 | | 9 | 135A | 1 |
| 141A6241-2 | | 9 | 65 | 1 |
| 141A6241-20 | | 9 | 115A | 1 |
| 141A6241-21 | | 9 | 40A | 1 |
| 141A6241-22 | | 9 | 45A | 1 |
| 141A6241-3 | | 9 | 40 | 1 |
| 141A6241-4 | | 9 | 45 | 1 |
| 141A6241-5 | | 9 | 30 | 1 |
| 141A6241-6 | | 9 | 35 | 1 |
| 141A6241-7 | | 9 | 50 | 1 |
| 141A6241-8 | | 9 | 55 | 1 |
| 141A6241-9 | | 9 | 105 | 1 |
| 141A6242-1 | | 9 | 155 | 1 |
| 141A6243-1 | | 9 | 100 | 2 |
| 141A6243-2 | | 9 | 95 | 2 |
| 141A6244-1 | | 9 | 110B | 1 |
| 141A6260-1 | | 1 | 45 | 1 |
| | | 10 | 1A | RF |
| 141A6260-2 | | 1 | 45A | 1 |
| | | 1 | 45B | 1 |
| | | 10 | 1B | RF |
| | | 10 | 1C | RF |
| 141A6264-1 | | 10 | 120 | 1 |
| 141A6264-2 | | 10 | 75 | 1 |
| 141A6264-3 | | 10 | 80 | 1 |
| 141A6265-1 | | 10 | 145 | 1 |
| 141A6265-2 | | 10 | 170 | 1 |
| 141A6266-1 | | 10 | 140 | 4 |
| 141A6266-2 | | 16 | 60 | 20 |
| 141A6267-1 | | 10 | 125 | 1 |
| 141A6270-3 | | 11 | 125B | 1 |
| 141A6270-4 | | 11 | 125C | 1 |
| 141A6273-1 | | 11 | 135A | 1 |
| 141A6273-3 | | 11 | 140A | 1 |

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| PART NUMBER | AIRLINE PART NUMBER | FIGURE | ITEM | UNITS PER ASSEMBLY |
|-------------|---------------------|--------|------|--------------------|
| 141A6274-1 | | 11 | 185A | 1 |
| 141A6274-3 | | 11 | 190A | 1 |
| 141A6280-3 | | 1 | 50B | 1 |
| | | 11 | 1C | RF |
| 141A6280-4 | | 1 | 50C | 1 |
| | | 1 | 50D | 1 |
| | | 11 | 1D | RF |
| | | 11 | 1E | RF |
| 141A6301-1 | | 1 | 55 | 1 |
| | | 1 | 55A | 1 |
| | | 12 | 1A | RF |
| | | 12 | 1B | RF |
| 141A6301-2 | | 1 | 55B | 1 |
| | | 12 | 1C | RF |
| 141A6301-3 | | 1 | 55C | 1 |
| | | 12 | 1D | RF |
| 141A6303-1 | | 12 | 170 | 1 |
| 141A6303-2 | | 12 | 170A | 1 |
| 141A6304-1 | | 12 | 370 | 1 |
| 141A6304-2 | | 12 | 415 | 1 |
| 141A6305-1 | | 12 | 340 | 1 |
| 141A6305-2 | | 12 | 315 | 1 |
| 141A6306-1 | | 12 | 260 | 2 |
| 141A6306-2 | | 12 | 285 | 1 |
| 141A6306-4 | | 12 | 260A | 2 |
| 141A6306-5 | | 12 | 281 | 1 |
| 141A6310-3 | | 12 | 20 | 1 |
| 141A6310-4 | | 12 | 30 | 1 |
| 141A6310-5 | | 12 | 20A | 1 |
| 141A6310-6 | | 12 | 30A | 1 |
| 141A6310-7 | | 12 | 20B | 1 |
| 141A6310-8 | | 12 | 30B | 1 |
| 141A6320-1 | | 1 | 60 | 1 |
| | | 1 | 60A | 1 |
| | | 13 | 1A | RF |

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| PART NUMBER | AIRLINE PART NUMBER | FIGURE | ITEM | UNITS PER ASSEMBLY |
|-------------|---------------------|--------|------|--------------------|
| | | 13 | 1B | RF |
| 141A6320-2 | | 1 | 60B | 1 |
| | | 13 | 1C | RF |
| 141A6321-1 | | 13 | 30 | 1 |
| 141A6321-2 | | 13 | 30A | 1 |
| 141A6322-1 | | 13 | 25 | 1 |
| 141A6322-2 | | 13 | 25A | 1 |
| 141A6323-1 | | 13 | 60 | 2 |
| 141A6323-2 | | 13 | 60A | 2 |
| 141A6330-1 | | 1 | 65 | 1 |
| | | 1 | 65A | 1 |
| | | 14 | 1A | RF |
| | | 14 | 1B | RF |
| 141A6330-2 | | 1 | 70 | 1 |
| | | 1 | 70A | 1 |
| | | 15 | 1A | RF |
| | | 15 | 1B | RF |
| 141A6331-1 | | 14 | 55 | 2 |
| | | 15 | 55 | 2 |
| 141A6345-3 | | 16 | 15 | 1 |
| 141A6345-4 | | 16 | 30 | 1 |
| 141A6347-1 | | 16 | 180 | 1 |
| 141A6347-3 | | 16 | 150 | 2 |
| 141A6348-1 | | 16 | 155 | 1 |
| 141A6349-10 | | 16 | 137A | 1 |
| 141A6349-4 | | 16 | 115 | 1 |
| 141A6349-5 | | 16 | 120 | 1 |
| 141A6349-6 | | 16 | 135 | 1 |
| 141A6349-7 | | 16 | 122 | 1 |
| 141A6349-8 | | 16 | 137 | 1 |
| 141A6349-9 | | 16 | 122A | 1 |
| 141A6350-1 | | 1 | 75 | 1 |
| | | 16 | 1A | RF |
| 141A6350-2 | | 1 | 75A | 1 |
| | | 1 | 75B | 1 |

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| PART NUMBER | AIRLINE PART NUMBER | FIGURE | ITEM | UNITS PER ASSEMBLY |
|-------------|---------------------|--------|------|--------------------|
| | | 16 | 1B | RF |
| | | 16 | 1C | RF |
| 141A6350-3 | | 1 | 75C | 1 |
| | | 16 | 1D | RF |
| 141A6570-1 | | 6 | 100 | 1 |
| 141A6571-1 | | 6 | 140 | 1 |
| 141A6571-2 | | 6 | 145 | 1 |
| 141A6572-1 | | 6 | 130 | 1 |
| 141A6573-1 | | 6 | 135 | 6 |
| 141A6574-1 | | 6 | 120 | 1 |
| 141A6575-1 | | 6 | 125 | 1 |
| 30-3010 | | 12 | 70 | 1 |
| 30-3013-2 | | 12 | 80 | 1 |
| 30-3019-1 | | 12 | 105 | 1 |
| 30-3020-2 | | 12 | 420 | 2 |
| 30-3021-1 | | 12 | 425 | 2 |
| 3SLCC6 | | 2 | 90 | 12 |
| | | 2 | 90 | 12 |
| | | 2 | 95 | 1 |
| | | 2 | 95 | 1 |
| | | 2 | 140 | 7 |
| | | 2 | 140 | 7 |
| | | 2 | 180 | 7 |
| | | 2 | 180 | 7 |
| | | 2 | 225 | 18 |
| | | 2 | 225 | 18 |
| | | 2 | 280 | 18 |
| | | 2 | 280 | 18 |
| | | 2 | 370 | 18 |
| | | 2 | 370 | 18 |
| | | 2 | 465 | 18 |
| | | 2 | 465 | 18 |
| | | 2 | 520 | 9 |
| | | 2 | 520 | 9 |
| | | 2 | 565 | 18 |

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| PART NUMBER | AIRLINE PART NUMBER | FIGURE | ITEM | UNITS PER ASSEMBLY |
|-------------|---------------------|--------|------|--------------------|
| | | 2 | 565 | 18 |
| | | 2 | 620 | 18 |
| | | 2 | 620 | 18 |
| | | 2 | 665 | 14 |
| | | 2 | 665 | 14 |
| | | 3 | 45 | 2 |
| | | 3 | 45 | 2 |
| 50-9369-1 | | 9 | 160 | 1 |
| 51564-0402 | | 14 | 150 | 1 |
| | | 15 | 150 | 1 |
| 51588-041 | | 14 | 70 | 1 |
| | | 14 | 155 | 1 |
| | | 15 | 70 | 1 |
| | | 15 | 155 | 1 |
| 55001 | | 8 | 55 | 1 |
| | | 8 | 115 | 1 |
| 60-4366-1 | | 11 | 200 | 1 |
| 60-4405-1 | | 11 | 120 | 2 |
| 60-4406-11 | | 13 | 80 | 1 |
| 60-4406-19 | | 13 | 80A | 1 |
| 60-4409-1 | | 13 | 65 | 1 |
| 60-4431-1 | | 13 | 70 | 1 |
| 60-4455-3 | | 12 | 85 | 1 |
| 60-7208-3 | | 12 | 185 | 1 |
| 60-7208-4 | | 12 | 205 | 1 |
| 60-7208-5 | | 12 | 205A | 1 |
| 63-1478-1 | | 6 | 35 | 3 |
| 63-1692-1 | | 12 | 245 | 2 |
| 63-2848 | | 12 | 75 | 1 |
| 63-9386-1 | | 12 | 10 | 1 |
| 63-9484 | | 9 | 90 | 8 |
| 65-1933-25 | | 12 | 345 | 1 |
| 65-1933-26 | | 12 | 360 | 1 |
| 65-2306-7 | | 8 | 105 | 3 |
| 65-2306-8 | | 8 | 120 | 1 |

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| PART NUMBER | AIRLINE PART NUMBER | FIGURE | ITEM | UNITS PER ASSEMBLY |
|-------------|---------------------|--------|------|--------------------|
| 65-25838-19 | | 5 | 95 | 1 |
| 65-25838-21 | | 5 | 115 | 1 |
| 65-25838-24 | | 5 | 100 | 1 |
| 65-25838-25 | | 5 | 120 | 1 |
| 65-2863-8 | | 6 | 15 | 1 |
| 65-28925-13 | | 14 | 160 | 1 |
| 65-28925-14 | | 15 | 160 | 1 |
| 65-28925-15 | | 15 | 165 | 1 |
| 65-28925-16 | | 14 | 165 | 1 |
| 65-28925-67 | | 14 | 130 | 1 |
| 65-28925-68 | | 15 | 130 | 1 |
| 65-28925-69 | | 15 | 135 | 1 |
| 65-28925-70 | | 14 | 135 | 1 |
| 65-54013-7 | | 12 | 320 | 1 |
| 65-54013-8 | | 12 | 335 | 1 |
| 65-86784-11 | | 11 | 180 | 1 |
| 65-86784-12 | | 11 | 185 | 1 |
| 65-86784-14 | | 11 | 135 | 1 |
| 65-86784-16 | | 11 | 190 | 1 |
| 65-86784-17 | | 11 | 140 | 1 |
| 65C36793-1 | | 12 | 400 | 2 |
| 65C37129-1 | | 11 | 205 | 1 |
| 65C37130-1 | | 11 | 130 | 1 |
| 65C37130-2 | | 11 | 132 | 1 |
| 65C37150-1 | | 11 | 195 | 2 |
| 65C37361-1 | | 11 | 25 | 1 |
| 65C37361-2 | | 11 | 30 | 1 |
| 65C37361-3 | | 11 | 50 | 1 |
| 65C37361-4 | | 11 | 55 | 1 |
| 65C37361-5 | | 11 | 60 | 1 |
| 65C37361-6 | | 11 | 65 | 1 |
| 65C37364-3 | | 12 | 60 | 1 |
| 66-12688-11 | | 2 | 55 | 1 |
| | | 2 | 190 | 1 |
| | | 2 | 240 | 1 |

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| PART NUMBER | AIRLINE PART NUMBER | FIGURE | ITEM | UNITS PER ASSEMBLY |
|-------------|---------------------|--------|------|--------------------|
| | | 2 | 295 | 1 |
| | | 2 | 385 | 1 |
| | | 2 | 480 | 1 |
| | | 2 | 530 | 1 |
| | | 2 | 580 | 1 |
| | | 2 | 635 | 1 |
| | | 2 | 680 | 1 |
| 66-12688-14 | | 2 | 190A | 1 |
| 66-1921-2 | | 6 | 55 | 1 |
| 66-24273-1 | | 16 | 175 | 1 |
| 66-24273-2 | | 16 | 170 | 1 |
| 66-24884-1 | | 5 | 75 | 1 |
| 66-2620-1 | | 14 | 80 | 1 |
| | | 15 | 80 | 1 |
| 66-2646 | | 6 | 50 | 1 |
| 66014-6 | | 7 | 55 | 2 |
| 69-1083-2 | | 6 | 60 | 1 |
| 69-1084-2 | | 6 | 65 | 1 |
| 69-1983-7 | | 6 | 70 | 1 |
| 69-22323-17 | | 5 | 80 | 1 |
| 69-22323-19 | | 5 | 45 | 1 |
| 69-22323-21 | | 5 | 85 | 1 |
| 69-22323-22 | | 5 | 50 | 1 |
| 69-61511-2 | | 12 | 55 | 1 |
| 69-71372-3 | | 13 | 75 | 1 |
| 69-78694-3 | | 12 | 390 | 4 |
| 69-78694-4 | | 12 | 395 | 4 |
| 69-78705-1 | | 11 | 150 | 1 |
| 69-78705-2 | | 11 | 155 | 1 |
| 69-78705-3 | | 11 | 170 | 1 |
| 69-78705-4 | | 11 | 175 | 1 |
| 69B10068-5 | | 12 | 295 | 2 |
| 77266 | | 12 | 200 | 2 |
| 81668V6K6 | | 2 | 175 | 1 |
| 81669V5K6 | | 2 | 160 | 2 |

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| PART NUMBER | AIRLINE PART NUMBER | FIGURE | ITEM | UNITS PER ASSEMBLY |
|--------------|---------------------|--------|------|--------------------|
| | | 2 | 460 | 1 |
| | | 3 | 40 | 1 |
| | | 3 | 43 | 1 |
| 81669V6K3 | | 2 | 70 | 6 |
| | | 2 | 660 | 14 |
| 81669V6K4 | | 2 | 75 | 6 |
| | | 2 | 80 | 1 |
| | | 2 | 125 | 7 |
| | | 2 | 220 | 2 |
| | | 2 | 275 | 4 |
| | | 2 | 365 | 2 |
| | | 2 | 455 | 3 |
| | | 2 | 515 | 2 |
| | | 2 | 560 | 4 |
| | | 2 | 615 | 2 |
| | | 2 | 660A | 14 |
| 81669V6K5 | | 2 | 170 | 1 |
| | | 2 | 215 | 6 |
| | | 2 | 270 | 4 |
| | | 2 | 360 | 6 |
| | | 2 | 450 | 4 |
| | | 2 | 510 | 2 |
| | | 2 | 555 | 4 |
| | | 2 | 610 | 6 |
| 81669V6K6 | | 2 | 165 | 3 |
| | | 2 | 210 | 10 |
| | | 2 | 265 | 10 |
| | | 2 | 355 | 10 |
| | | 2 | 445 | 10 |
| | | 2 | 505 | 5 |
| | | 2 | 550 | 10 |
| | | 2 | 605 | 10 |
| 81669V6K8 | | 3 | 43A | 1 |
| 82-99-341-22 | | 10 | 150 | 4 |
| 90-7809-20 | | 9 | 110 | 1 |

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| PART NUMBER | AIRLINE PART NUMBER | FIGURE | ITEM | UNITS PER ASSEMBLY |
|-----------------|---------------------|--------|------|--------------------|
| | | 9 | 110A | 1 |
| 90-7811 | | 12 | 110 | 1 |
| 90-7821-1 | | 12 | 115 | 1 |
| 90-7879-7 | | 12 | 125 | 1 |
| AB4E27FN | | 14 | 150 | 1 |
| | | 15 | 150 | 1 |
| ABW16-101 | | 8 | 55 | 1 |
| | | 8 | 115 | 1 |
| ACMKP12AP510Y19 | | 12 | 310 | 1 |
| ACMKP21BSP510LY | | 12 | 300 | 2 |
| ACMKP23BSP510LY | | 12 | 305 | 2 |
| ACMKP25BP26LY19 | | 12 | 365 | 2 |
| ACMKP25BP510LY1 | | 12 | 365 | 2 |
| ACMKP25P26LY198 | | 12 | 365 | 2 |
| AF3253-6-2B | | 10 | 135 | 2 |
| AF3253-6-3B | | 10 | 50 | 5 |
| AF5141-3C | | 10 | 55 | 8 |
| | | 10 | 105 | 92 |
| AF5141-3C2 | | 2 | 330 | 16 |
| | | 2 | 420 | 16 |
| | | 3 | 105 | 56 |
| | | 4 | 80 | 56 |
| AF5141-3C3 | | 3 | 15 | 38 |
| | | 4 | 15 | 54 |
| AF5141-3C4 | | 3 | 20 | 6 |
| AHRSC4CFR6 | | 12 | 280A | 1 |
| AHRSC4CFR8 | | 12 | 283 | 1 |
| AN316-5R | | 14 | 145 | 2 |
| | | 15 | 145 | 2 |
| AN316-8R | | 12 | 190 | 1 |
| AN996-14 | | 12 | 120 | 1 |
| AR4E4FN | | 14 | 150 | 1 |
| | | 15 | 150 | 1 |
| AR4E7AFNW | | 14 | 70 | 1 |
| | | 14 | 155 | 1 |

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| PART NUMBER | AIRLINE PART NUMBER | FIGURE | ITEM | UNITS PER ASSEMBLY |
|----------------|---------------------|--------|------|--------------------|
| | | 15 | 70 | 1 |
| | | 15 | 155 | 1 |
| ARB4E60FNW | | 14 | 70 | 1 |
| | | 14 | 155 | 1 |
| | | 15 | 70 | 1 |
| | | 15 | 155 | 1 |
| ART5E108 | | 12 | 200 | 2 |
| ASM4F6 | | 14 | 150 | 1 |
| | | 15 | 150 | 1 |
| ASMK4F1 | | 14 | 70 | 1 |
| | | 14 | 155 | 1 |
| | | 15 | 70 | 1 |
| | | 15 | 155 | 1 |
| ASSB16-19 | | 8 | 55 | 1 |
| | | 8 | 115 | 1 |
| BAC27DBY191 | | 1 | 90 | 1 |
| BACB10A187L | | 14 | 150 | 1 |
| | | 15 | 150 | 1 |
| BACB10A397GCM2 | | 8 | 55 | 1 |
| | | 8 | 115 | 1 |
| BACB10FK6F6HS | | 12 | 280 | 1 |
| BACB10FR25 | | 12 | 365 | 2 |
| BACB10FS12 | | 12 | 310 | 1 |
| BACB10FV21 | | 12 | 300 | 2 |
| BACB10FV23 | | 12 | 305 | 2 |
| BACB10GS06FJ6 | | 12 | 280A | 1 |
| BACB10GS06FJ8 | | 12 | 283 | 1 |
| BACB10Y4 | | 14 | 70 | 1 |
| | | 14 | 155 | 1 |
| | | 15 | 70 | 1 |
| | | 15 | 155 | 1 |
| BACB28AK04-032 | | 14 | 125 | 1 |
| | | 15 | 125 | 1 |
| BACB28AP04P014 | | 3 | 95 | 3 |
| | | 4 | 70 | 3 |

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|-----------------|---------------------|--------|------|--------------------|
| BACB28AT06B014C | | 3 | 100 | 3 |
| | | 4 | 75 | 3 |
| BACB30LH3-7 | | 12 | 90 | 4 |
| BACB30LJ4-13 | | 14 | 105 | 1 |
| | | 15 | 105 | 1 |
| BACB30MR4K20 | | 12 | 130 | 4 |
| BACB30NM3K10 | | 7 | 5 | 3 |
| | | 9 | 70 | 1 |
| BACB30NM3K11 | | 12 | 35 | 4 |
| | | 12 | 35 | 4 |
| | | 12 | 215 | 2 |
| | | 12 | 215 | 2 |
| BACB30NM3K13 | | 9 | 70A | 1 |
| BACB30NM3K17 | | 13 | 5 | 8 |
| BACB30NM3K19 | | 13 | 10 | 6 |
| BACB30NM3K22 | | 14 | 15 | 4 |
| | | 15 | 15 | 4 |
| BACB30NM3K4 | | 2 | 320 | 8 |
| | | 2 | 410 | 8 |
| | | 5 | 25 | 28 |
| | | 8 | 80 | 12 |
| | | 16 | 5 | 4 |
| BACB30NM3K5 | | 5 | 30 | 2 |
| | | 9 | 80 | 46 |
| | | 16 | 75 | 5 |
| BACB30NM3K6 | | 12 | 210 | 2 |
| | | 16 | 80 | 2 |
| BACB30NM3K7 | | 9 | 75 | 9 |
| BACB30NM4DK13 | | 14 | 100 | 1 |
| BACB30NM4DK14 | | 14 | 95 | 1 |
| | | 15 | 95 | 1 |
| BACB30NM4DK17 | | 14 | 10 | 2 |
| | | 14 | 90 | 1 |
| | | 15 | 10 | 2 |
| | | 15 | 90 | 1 |

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|---------------|---------------------|--------|------|--------------------|
| BACB30NM4K14 | | 12 | 140 | 1 |
| BACB30NM4K15 | | 12 | 135 | 1 |
| BACB30NM4K16 | | 12 | 150 | 2 |
| BACB30NM4K17 | | 12 | 145 | 1 |
| BACB30NM4K18 | | 12 | 155 | 2 |
| BACB30NM4K19 | | 12 | 160 | 1 |
| BACB30NN3K2 | | 2 | 340 | 3 |
| | | 2 | 430 | 3 |
| BACB30NN3K3 | | 3 | 10 | 12 |
| BACB30NN3K4 | | 4 | 10 | 11 |
| BACB30NN3K6 | | 4 | 5 | 2 |
| BACB30NN3K7 | | 3 | 5 | 1 |
| BACB30NN3K8 | | 3 | 5A | 1 |
| BACB30NR4DK12 | | 15 | 100 | 1 |
| BACB30NR4K24 | | 11 | 5 | 4 |
| BACB30NR4K26 | | 11 | 70 | 8 |
| BACB30NR4K4 | | 12 | 220 | 2 |
| BACB30NR4K7 | | 5 | 55 | 4 |
| BACB30NR5DK14 | | 11 | 80 | 1 |
| BACB30NR5K16 | | 12 | 175 | 1 |
| BACB30NR5K29 | | 11 | 75 | 2 |
| BACB30NT2K2 | | 10 | 15 | 1 |
| BACB30NT2K3 | | 10 | 10 | 1 |
| BACB30NT3K16 | | 16 | 160 | 2 |
| BACB30NT3K2 | | 10 | 95 | 17 |
| BACB30NT3K3 | | 10 | 90 | 7 |
| BACB30NT3K4 | | 10 | 5 | 2 |
| | | 10 | 85 | 18 |
| BACB30NW6K | | 7 | 50 | 2 |
| BACB30NX5K4 | | 16 | 70 | 1 |
| BACB30VF3K2 | | 2 | 340A | 3 |
| | | 2 | 430A | 3 |
| BACB30VF3K4 | | 8 | 10 | 12 |
| BACB30VF3K5 | | 8 | 5 | 2 |
| BACB30VM6K6 | | 2 | 175 | 1 |

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|-------------|---------------------|--------|------|--------------------|
| BACB30VN6K3 | | 2 | 70 | 6 |
| | | 2 | 660 | 14 |
| BACB30VN6K4 | | 2 | 75 | 6 |
| | | 2 | 80 | 1 |
| | | 2 | 125 | 7 |
| | | 2 | 220 | 2 |
| | | 2 | 275 | 4 |
| | | 2 | 365 | 2 |
| | | 2 | 455 | 3 |
| | | 2 | 515 | 2 |
| | | 2 | 560 | 4 |
| | | 2 | 615 | 2 |
| | | 2 | 660A | 14 |
| BACB30VN6K5 | | 2 | 170 | 1 |
| | | 2 | 215 | 6 |
| | | 2 | 270 | 4 |
| | | 2 | 360 | 6 |
| | | 2 | 450 | 4 |
| | | 2 | 510 | 2 |
| | | 2 | 555 | 4 |
| BACB30VN6K6 | | 2 | 610 | 6 |
| | | 2 | 165 | 3 |
| | | 2 | 210 | 10 |
| | | 2 | 265 | 10 |
| | | 2 | 355 | 10 |
| | | 2 | 445 | 10 |
| | | 2 | 505 | 5 |
| | | 2 | 550 | 10 |
| BACB30VN6K7 | | 2 | 605 | 10 |
| | | 2 | 160 | 2 |
| | | 2 | 460 | 1 |
| BACB30VN6K9 | | 3 | 40 | 1 |
| | | 3 | 43 | 1 |
| | | 3 | 43A | 1 |
| BACB30VT6K3 | | 2 | 120 | 10 |

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|-----------------|---------------------|--------|------|--------------------|
| BACB30VT6K4 | | 2 | 5 | 4 |
| | | 2 | 80A | 1 |
| | | 2 | 85 | 1 |
| BACB30VT6K5 | | 2 | 10 | 4 |
| BACB30VT6K6 | | 2 | 15 | 10 |
| BACB30VU6K3 | | 2 | 130 | 2 |
| BACB30XT6K6 | | 2 | 175A | 1 |
| BACB30YP6K3 | | 2 | 130A | 2 |
| BACC30BH5 | | 16 | 95 | 1 |
| BACC30BK6 | | 2 | 90 | 12 |
| | | 2 | 95 | 1 |
| | | 2 | 140 | 7 |
| | | 2 | 180 | 7 |
| | | 2 | 225 | 18 |
| | | 2 | 280 | 18 |
| | | 2 | 370 | 18 |
| | | 2 | 465 | 18 |
| | | 2 | 520 | 9 |
| | | 2 | 565 | 18 |
| | | 2 | 620 | 18 |
| | | 2 | 665 | 14 |
| | | 3 | 45 | 2 |
| BACC30BL6 | | 2 | 95A | 1 |
| | | 2 | 100 | 1 |
| | | 2 | 135 | 12 |
| BACC30BQ6 | | 2 | 20 | 18 |
| BACC30M6 | | 7 | 55 | 2 |
| BACF3F008E008NN | | 16 | 65 | 1 |
| BACF3H08RF011HN | | 7 | 80 | 2 |
| BACN10JA3CD | | 11 | 165 | 1 |
| BACN10JA4CD | | 12 | 385 | 12 |
| BACN10JC3CD | | 16 | 165 | 2 |
| BACN10JD105CD | | 13 | 40 | 2 |
| BACN10JD106ASU | | 12 | 275 | 1 |
| BACN10JD4CD | | 14 | 40 | 2 |

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| PART NUMBER | AIRLINE PART NUMBER | FIGURE | ITEM | UNITS PER ASSEMBLY |
|----------------|---------------------|--------|------|--------------------|
| | | 14 | 120 | 3 |
| | | 15 | 40 | 2 |
| | | 15 | 120 | 3 |
| BACN10JD5CD | | 11 | 110 | 1 |
| BACN10JP3ACD | | 12 | 410 | 4 |
| BACN10JP5C | | 12 | 355A | 1 |
| BACN10JP5CCD | | 12 | 355 | 1 |
| BACN10JR08CD | | 10 | 70 | 2 |
| BACN10JR3CD | | 10 | 60 | 1 |
| BACN10JR3CFD | | 2 | 335 | 8 |
| | | 2 | 425 | 8 |
| | | 3 | 30 | 16 |
| | | 4 | 30 | 1 |
| | | 4 | 85A | 2 |
| | | 7 | 75 | 2 |
| | | 10 | 110 | 32 |
| BACN10JS3A3CD | | 3 | 110 | 28 |
| | | 4 | 90 | 26 |
| BACN10JS3B3CD | | 7 | 70 | 1 |
| BACN10JZ3A2CDM | | 4 | 25 | 20 |
| BACN10KB4CD | | 5 | 70 | 4 |
| BACN10KE4ACD | | 16 | 130 | 2 |
| | | 16 | 133 | 1 |
| BACN10KE4DCD | | 16 | 25 | 2 |
| | | 16 | 132 | 1 |
| BACN10KF3CD | | 11 | 40 | 1 |
| BACN10KF4 | | 12 | 330 | 2 |
| BACN10KH3CD | | 3 | 25 | 3 |
| | | 4 | 20 | 6 |
| | | 4 | 85 | 2 |
| | | 10 | 65 | 1 |
| | | 10 | 115 | 14 |
| BACN10MK3-45 | | 6 | 90 | 3 |
| BACN10YR04CD | | 6 | 30 | 6 |
| | | 6 | 115 | 12 |

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| PART NUMBER | AIRLINE PART NUMBER | FIGURE | ITEM | UNITS PER ASSEMBLY |
|----------------|---------------------|-------------|------|--------------------|
| BACN10YR3CD | | 2 | 345 | 3 |
| | | 2 | 435 | 3 |
| | | 5 | 40 | 30 |
| | | 8 | 20 | 14 |
| | | 8 | 95 | 12 |
| | | 12 | 100 | 4 |
| | | 12 | 250 | 4 |
| | | 14 | 45 | 4 |
| | | 15 | 45 | 4 |
| | | BACN10YR3CM | | 13 |
| BACN10YR4CD | | 11 | 100 | 8 |
| | | 12 | 255 | 2 |
| BACN10YR5CD | | 7 | 20 | 1 |
| | | 11 | 105 | 2 |
| BACN11N6CD | | 12 | 15 | 1 |
| BACN28AK04-032 | | 14 | 50 | 2 |
| | | 15 | 50 | 2 |
| BACP18BC02A05P | | 14 | 5 | 2 |
| | | 14 | 85 | 3 |
| | | 15 | 5 | 2 |
| | | 15 | 85 | 3 |
| | | 13 | 35 | 2 |
| BACP18BC02A06P | | 12 | 5 | 1 |
| BACP18BC03A08P | | 12 | 265 | 1 |
| BACP18BC03A10P | | 10 | 165 | 4 |
| BACR12AG2C | | 11 | 35 | 2 |
| BACR15BA3AD | | 12 | 375 | 24 |
| | | 12 | 405 | 8 |
| | | 16 | 20 | 4 |
| | | 16 | 125 | 4 |
| | | 2 | 330A | 16 |
| | | 2 | 420A | 16 |
| BACR15BA4AD | | 6 | 85 | 6 |
| BACR15BA4D | | 12 | 350 | 2 |
| BACR15CE3D | | 7 | 65 | 6 |

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| PART NUMBER | AIRLINE PART NUMBER | FIGURE | ITEM | UNITS PER ASSEMBLY |
|--------------|---------------------|--------|------|--------------------|
| BACR15CE5D | | 11 | 160 | 2 |
| | | 7 | 40 | 3 |
| | | 12 | 380 | 8 |
| BACR15DR3AC | | 10 | 55 | 8 |
| | | 10 | 105 | 92 |
| BACR15DR3AC2 | | 2 | 330 | 16 |
| | | 2 | 420 | 16 |
| | | 3 | 105 | 56 |
| | | 4 | 80 | 56 |
| BACR15DR3AC3 | | 3 | 15 | 38 |
| | | 4 | 15 | 54 |
| BACR15DR3AC4 | | 3 | 20 | 6 |
| BACR15FR4E2 | | 16 | 185 | 24 |
| BACR15FR6E2 | | 16 | 35 | 24 |
| BACR15FR6E2R | | 10 | 135 | 2 |
| BACR15FR6E3 | | 16 | 40 | 7 |
| | | 16 | 145 | 6 |
| BACR15FR6E3R | | 10 | 50 | 5 |
| BACR15FR6E4 | | 16 | 45 | 4 |
| BACR15FR6E5 | | 16 | 50 | 4 |
| | | 16 | 140 | 4 |
| BACR15FT5D | | 10 | 40 | 3 |
| | | 11 | 145 | 2 |
| BACR15FT6D | | 2 | 25 | 16 |
| | | 2 | 145 | 100 |
| | | 5 | 5 | 20 |
| | | 5 | 125 | 20 |
| | | 8 | 25 | 2 |
| BACR15GF5D | | 3 | 60 | 32 |
| | | 4 | 35 | 32 |
| | | 6 | 75 | 48 |
| | | 10 | 45 | 2 |
| | | 10 | 130 | 6 |
| | | 17 | 5 | 44 |
| BACR15GF6D | | 2 | 30 | 4 |

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| PART NUMBER | AIRLINE PART NUMBER | FIGURE | ITEM | UNITS PER ASSEMBLY |
|-----------------|---------------------|--------|------|--------------------|
| | | 2 | 150 | 28 |
| | | 5 | 10 | 12 |
| BACR16F08C106 | | 9 | 20B | 50 |
| BACR16F08C201 | | 9 | 27A | 4 |
| BACR16F08C241 | | 9 | 28A | 3 |
| BACR16F08C281 | | 9 | 15B | 1 |
| BACS12HJ04K8 | | 6 | 105 | 12 |
| BACS12HJ3K9 | | 6 | 5A | 3 |
| BACS14K1 | | 16 | 190 | 12 |
| BACS21AP220RP | | 10 | 150 | 4 |
| BACS40R007B007F | | 6 | 40 | AR |
| | | 6 | 150 | AR |
| BACS40R007C007F | | 6 | 45 | AR |
| | | 6 | 155 | AR |
| BACS40R008B041F | | 12 | 167 | AR |
| BACW10BN4AC | | 5 | 60 | 4 |
| BACW10BP3CD | | 2 | 325 | 8 |
| | | 2 | 415 | 8 |
| | | 7 | 10 | 3 |
| | | 8 | 85 | 12 |
| | | 12 | 40 | 4 |
| | | 12 | 225 | 4 |
| | | 14 | 30 | 4 |
| | | 15 | 30 | 4 |
| | | 16 | 10 | 4 |
| | | 16 | 85 | 7 |
| BACW10BP3DP | | 14 | 35 | 4 |
| | | 15 | 35 | 4 |
| | | 16 | 90 | 7 |
| BACW10BP4ACU | | 11 | 10 | 4 |
| BACW10BP4CD | | 12 | 165 | 10 |
| | | 12 | 230 | 2 |
| | | 14 | 20 | 2 |
| | | 14 | 110 | 4 |
| | | 15 | 20 | 2 |

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| PART NUMBER | AIRLINE PART NUMBER | FIGURE | ITEM | UNITS PER ASSEMBLY |
|--------------|---------------------|--------|------|--------------------|
| BACW10BP4DP | | 15 | 110 | 4 |
| | | 14 | 25 | 2 |
| | | 14 | 115 | 3 |
| | | 15 | 25 | 2 |
| | | 15 | 115 | 3 |
| BACW10BP5ACU | | 11 | 85 | 1 |
| BACW10BP5CD | | 12 | 180 | 1 |
| BH00312-04 | | 6 | 30 | 6 |
| BLN16385GC | | 8 | 55 | 1 |
| | | 8 | 115 | 1 |
| BR1000C4D | | 5 | 70 | 4 |
| BR2000C08D | | 10 | 70 | 2 |
| BR2000C3D | | 10 | 60 | 1 |
| BR3000A4 | | 12 | 330 | 2 |
| BR3000C3D | | 11 | 40 | 1 |
| BRE4140L | | 14 | 150 | 1 |
| | | 15 | 150 | 1 |
| BRES4-2236L2 | | 14 | 70 | 1 |
| | | 14 | 155 | 1 |
| | | 15 | 70 | 1 |
| | | 15 | 155 | 1 |
| BRF110C3D | | 11 | 165 | 1 |
| BRF110C4D | | 12 | 385 | 12 |
| BRF120C3-3D | | 7 | 70 | 1 |
| BRF170C3D | | 11 | 165 | 1 |
| BRF170C4D | | 12 | 385 | 12 |
| BRF200C3D | | 2 | 335 | 8 |
| | | 2 | 425 | 8 |
| | | 3 | 30 | 16 |
| | | 4 | 30 | 1 |
| | | 4 | 85A | 2 |
| | | 7 | 75 | 2 |
| | | 10 | 110 | 32 |
| BRF220C3-3D | | 3 | 110 | 28 |
| | | 4 | 90 | 26 |

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| PART NUMBER | AIRLINE PART NUMBER | FIGURE | ITEM | UNITS PER ASSEMBLY |
|---------------|---------------------|--------|------|--------------------|
| BRFR220C4-10 | | 16 | 130 | 2 |
| | | 16 | 133 | 1 |
| BRH10C3D | | 16 | 165 | 2 |
| CCR264CS3-2IT | | 2 | 330 | 16 |
| | | 2 | 420 | 16 |
| | | 3 | 105 | 56 |
| | | 4 | 80 | 56 |
| CCR264CS3-3IT | | 3 | 15 | 38 |
| | | 4 | 15 | 54 |
| CCR264CS3-4IT | | 3 | 20 | 6 |
| CF2903 | | 12 | 283A | 1 |
| CHRS4CFR6 | | 12 | 280 | 1 |
| | | 12 | 280 | 1 |
| CR3253-6-2 | | 10 | 135 | 2 |
| CR3253-6-3 | | 10 | 50 | 5 |
| DE685-10 | | 16 | 190 | 12 |
| DREM5-023 | | 12 | 200 | 2 |
| F51636-3 | | 11 | 165 | 1 |
| F51636-4 | | 12 | 385 | 12 |
| | | 12 | 385 | 12 |
| | | 12 | 385 | 12 |
| F51643-3BAC | | 4 | 25 | 20 |
| F51747-4-1CD | | 16 | 130 | 2 |
| | | 16 | 133 | 1 |
| F51753-4CD | | 16 | 25 | 2 |
| | | 16 | 132 | 1 |
| F51849-3-3BAC | | 7 | 70 | 1 |
| F51900-3-3BAC | | 3 | 110 | 28 |
| | | 4 | 90 | 26 |
| | | 3 | 25 | 3 |
| FS1651-3 | | 4 | 20 | 6 |
| | | 4 | 85 | 2 |
| | | 10 | 65 | 1 |
| | | 10 | 115 | 14 |
| H51650-3BAC | | 16 | 165 | 2 |
| H52732-04CD | | 6 | 30 | 6 |

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| PART NUMBER | AIRLINE PART NUMBER | FIGURE | ITEM | UNITS PER ASSEMBLY | | |
|-------------|---------------------|------------|------|--------------------|-----|----|
| H52732-3CD | | 6 | 115 | 12 | | |
| | | 2 | 345 | 3 | | |
| | | 2 | 435 | 3 | | |
| | | 5 | 40 | 30 | | |
| | | 8 | 20 | 14 | | |
| | | 8 | 95 | 12 | | |
| | | 12 | 100 | 4 | | |
| | | 12 | 250 | 4 | | |
| | | 14 | 45 | 4 | | |
| | | 15 | 45 | 4 | | |
| | | H52732-3CM | | 13 | 20 | 14 |
| | | | | | | |
| | | H52732-4CD | | 11 | 100 | 8 |
| | | | | 12 | 255 | 2 |
| H52732-5CD | | 7 | 20 | 1 | | |
| | | 11 | 105 | 2 | | |
| HB4E135 | | 14 | 150 | 1 | | |
| | | 15 | 150 | 1 | | |
| HB4E212K | | 14 | 70 | 1 | | |
| | | 14 | 155 | 1 | | |
| | | 15 | 70 | 1 | | |
| | | 15 | 155 | 1 | | |
| HGL16-102 | | 8 | 55 | 1 | | |
| | | 8 | 115 | 1 | | |
| HL1012AZ5-4 | | 16 | 70 | 1 | | |
| | | 16 | 70 | 1 | | |
| | | 16 | 70 | 1 | | |
| | | 16 | 70 | 1 | | |
| | | 16 | 70 | 1 | | |
| | | 16 | 70 | 1 | | |
| | | 16 | 70 | 1 | | |
| | | 16 | 70 | 1 | | |
| | | 16 | 70 | 1 | | |
| | | 16 | 70 | 1 | | |
| HL1087-5 | | 16 | 95 | 1 | | |
| | | 16 | 95 | 1 | | |
| | | 16 | 95 | 1 | | |
| HL12VAZ5-4 | | 16 | 70 | 1 | | |

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| PART NUMBER | AIRLINE PART NUMBER | FIGURE | ITEM | UNITS PER ASSEMBLY |
|-------------|---------------------|--------|------|--------------------|
| HL79-6 | | 16 | 70 | 1 |
| | | 16 | 70 | 1 |
| | | 16 | 70 | 1 |
| | | 7 | 55 | 2 |
| | | 7 | 55 | 2 |
| | | 7 | 55 | 2 |
| | | 7 | 55 | 2 |
| HRSC4CFR6 | | 12 | 280 | 1 |
| HST10AG6-3 | | 2 | 120 | 10 |
| | | 2 | 120 | 10 |
| | | 2 | 120 | 10 |
| | | 2 | 120 | 10 |
| HST10AG6-4 | | 2 | 5 | 4 |
| | | 2 | 5 | 4 |
| | | 2 | 5 | 4 |
| | | 2 | 5 | 4 |
| | | 2 | 80A | 1 |
| | | 2 | 80A | 1 |
| | | 2 | 80A | 1 |
| | | 2 | 80A | 1 |
| | | 2 | 85 | 1 |
| | | 2 | 85 | 1 |
| | | 2 | 85 | 1 |
| | | 2 | 85 | 1 |
| HST10AG6-5 | | 2 | 10 | 4 |
| | | 2 | 10 | 4 |
| | | 2 | 10 | 4 |
| | | 2 | 10 | 4 |
| HST10AG6-6 | | 2 | 15 | 10 |
| | | 2 | 15 | 10 |
| | | 2 | 15 | 10 |
| | | 2 | 15 | 10 |
| HST11AG6-3 | | 2 | 130 | 2 |
| | | 2 | 130 | 2 |
| | | 2 | 130 | 2 |

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| PART NUMBER | AIRLINE PART NUMBER | FIGURE | ITEM | UNITS PER ASSEMBLY |
|--------------|---------------------|--------|------|--------------------|
| HST79-6 | | 2 | 130 | 2 |
| | | 2 | 95A | 1 |
| | | 2 | 100 | 1 |
| | | 2 | 135 | 12 |
| HST79CY6 | | 2 | 95A | 1 |
| | | 2 | 95A | 1 |
| | | 2 | 95A | 1 |
| | | 2 | 100 | 1 |
| | | 2 | 100 | 1 |
| | | 2 | 100 | 1 |
| | | 2 | 135 | 12 |
| | | 2 | 135 | 12 |
| | | 2 | 135 | 12 |
| | | 2 | 135 | 12 |
| HST826AW | | 2 | 20 | 18 |
| | | 2 | 20 | 18 |
| | | 2 | 20 | 18 |
| HST82CY6APBW | | 2 | 20 | 18 |
| | | 2 | 20 | 18 |
| K3000-4BAC | | 12 | 330 | 2 |
| K51595-4 | | 5 | 70 | 4 |
| K51598-3BAC | | 11 | 40 | 1 |
| K51601-08BAC | | 10 | 70 | 2 |
| K51601-3BAC | | 10 | 60 | 1 |
| K51602-3BAC | | 2 | 335 | 8 |
| | | 2 | 425 | 8 |
| KB4ESSFN | | 3 | 30 | 16 |
| | | 4 | 30 | 1 |
| | | 4 | 85A | 2 |
| | | 7 | 75 | 2 |
| | | 10 | 110 | 32 |
| | | 14 | 150 | 1 |
| | | 15 | 150 | 1 |
| KBDE5-15 | | 12 | 200 | 2 |
| KBE4-150AFNW | | 14 | 70 | 1 |
| | | 14 | 155 | 1 |

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| PART NUMBER | AIRLINE PART NUMBER | FIGURE | ITEM | UNITS PER ASSEMBLY |
|---------------|---------------------|--------|------|--------------------|
| | | 15 | 70 | 1 |
| | | 15 | 155 | 1 |
| KRP178905VT | | 13 | 55 | 2 |
| KSSB16-5 | | 8 | 55 | 1 |
| | | 8 | 115 | 1 |
| L802-5K4 | | 16 | 70 | 1 |
| LGPL2SCV6-6AC | | 2 | 175 | 1 |
| | | 2 | 175 | 1 |
| LGPL2SPV6-3AC | | 2 | 70 | 6 |
| | | 2 | 70 | 6 |
| | | 2 | 70 | 6 |
| | | 2 | 660 | 14 |
| | | 2 | 660 | 14 |
| | | 2 | 660 | 14 |
| LGPL2SPV6-4AC | | 2 | 75 | 6 |
| | | 2 | 75 | 6 |
| | | 2 | 75 | 6 |
| | | 2 | 80 | 1 |
| | | 2 | 80 | 1 |
| | | 2 | 80 | 1 |
| | | 2 | 125 | 7 |
| | | 2 | 125 | 7 |
| | | 2 | 125 | 7 |
| | | 2 | 220 | 2 |
| | | 2 | 220 | 2 |
| | | 2 | 220 | 2 |
| | | 2 | 275 | 4 |
| | | 2 | 275 | 4 |
| | | 2 | 275 | 4 |
| | | 2 | 365 | 2 |
| | | 2 | 365 | 2 |
| | | 2 | 365 | 2 |
| | | 2 | 455 | 3 |
| | | 2 | 455 | 3 |
| | | 2 | 455 | 3 |

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| PART NUMBER | AIRLINE PART NUMBER | FIGURE | ITEM | UNITS PER ASSEMBLY |
|---------------|---------------------|--------|------|--------------------|
| LGPL2SPV6-5AC | | 2 | 515 | 2 |
| | | 2 | 515 | 2 |
| | | 2 | 515 | 2 |
| | | 2 | 560 | 4 |
| | | 2 | 560 | 4 |
| | | 2 | 560 | 4 |
| | | 2 | 615 | 2 |
| | | 2 | 615 | 2 |
| | | 2 | 615 | 2 |
| | | 2 | 660A | 14 |
| | | 2 | 660A | 14 |
| | | 2 | 660A | 14 |
| | | 2 | 170 | 1 |
| | | 2 | 170 | 1 |
| | | 2 | 170 | 1 |
| | | 2 | 215 | 6 |
| | | 2 | 215 | 6 |
| | | 2 | 215 | 6 |
| | | 2 | 270 | 4 |
| | | 2 | 270 | 4 |
| | | 2 | 270 | 4 |
| | | 2 | 360 | 6 |
| | | 2 | 360 | 6 |
| | | 2 | 360 | 6 |
| | | 2 | 450 | 4 |
| | | 2 | 450 | 4 |
| | | 2 | 450 | 4 |
| | | 2 | 510 | 2 |
| | | 2 | 510 | 2 |
| | | 2 | 510 | 2 |
| | 2 | 555 | 4 | |
| | 2 | 555 | 4 | |
| | 2 | 555 | 4 | |
| | 2 | 610 | 6 | |
| | 2 | 610 | 6 | |

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| PART NUMBER | AIRLINE PART NUMBER | FIGURE | ITEM | UNITS PER ASSEMBLY | |
|---------------|---------------------|--------|------|--------------------|---|
| LGPL2SPV6-6AC | | 2 | 610 | 6 | |
| | | 2 | 165 | 3 | |
| | | 2 | 165 | 3 | |
| | | 2 | 165 | 3 | |
| | | 2 | 210 | 10 | |
| | | 2 | 210 | 10 | |
| | | 2 | 210 | 10 | |
| | | 2 | 265 | 10 | |
| | | 2 | 265 | 10 | |
| | | 2 | 265 | 10 | |
| | | 2 | 355 | 10 | |
| | | 2 | 355 | 10 | |
| | | 2 | 355 | 10 | |
| | | 2 | 445 | 10 | |
| | | 2 | 445 | 10 | |
| | | 2 | 445 | 10 | |
| | | 2 | 505 | 5 | |
| | | 2 | 505 | 5 | |
| | | 2 | 505 | 5 | |
| | | 2 | 550 | 10 | |
| | | 2 | 550 | 10 | |
| | | 2 | 550 | 10 | |
| | | 2 | 605 | 10 | |
| | | 2 | 605 | 10 | |
| | | 2 | 605 | 10 | |
| | LGPL2SPV6-7AC | | 2 | 160 | 2 |
| | | | 2 | 160 | 2 |
| | | | 2 | 160 | 2 |
| | | 2 | 460 | 1 | |
| | | 2 | 460 | 1 | |
| | | 2 | 460 | 1 | |
| | | 3 | 40 | 1 | |
| | 3 | 40 | 1 | | |
| | 3 | 40 | 1 | | |
| | 3 | 43 | 1 | | |

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| PART NUMBER | AIRLINE PART NUMBER | FIGURE | ITEM | UNITS PER ASSEMBLY |
|----------------|---------------------|--------|------|--------------------|
| | | 3 | 43 | 1 |
| | | 3 | 43 | 1 |
| LGPL2SPV6-8AC | | 3 | 43A | 1 |
| LGPL2SPV6-9AC | | 3 | 43A | 1 |
| | | 3 | 43A | 1 |
| M83461-1-210 | | 11 | 115 | 2 |
| M83461-1-212 | | 12 | 50 | 1 |
| M83461-1-325 | | 12 | 45 | 1 |
| MK3000-5BAC | | 12 | 355A | 1 |
| MS14144L6 | | 12 | 15A | 1 |
| MS16625-4162 | | 12 | 290 | 1 |
| MS20253-2-150 | | 11 | 45 | 1 |
| MS20253P2-3240 | | 3 | 75 | 1 |
| | | 4 | 50 | 1 |
| MS20426A3 | | 5 | 65 | 8 |
| MS20470D3 | | 14 | 140 | 1 |
| | | 15 | 140 | 1 |
| MS20470D3-4 | | 12 | 325 | 4 |
| MS21063L3-10-4 | | 3 | 35 | 2 |
| MS21141U5P1 | | 10 | 35 | 3 |
| MS21141U5P2 | | 10 | 30 | 46 |
| MS21141U5P3 | | 16 | 55 | 1 |
| MS21209F5-20 | | 12 | 25 | 3 |
| MS27253F1 | | 1 | 85 | 1 |
| MS39086-111 | | 12 | 65 | 1 |
| MSSK4ASFG | | 14 | 70 | 1 |
| | | 14 | 155 | 1 |
| | | 15 | 70 | 1 |
| | | 15 | 155 | 1 |
| MSSR58-14BAC | | 12 | 200 | 2 |
| MXJ45-14BFG | | 14 | 150 | 1 |
| | | 15 | 150 | 1 |
| NAS1149C0432R | | 11 | 90 | 8 |
| | | 12 | 240 | 2 |
| NAS1149C0532R | | 11 | 95 | 3 |

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|----------------|---------------------|--------|------|--------------------|
| NAS1149D0316J | | 9 | 130 | 28 |
| NAS1149D0332J | | 5 | 35 | 60 |
| | | 6 | 10 | 3 |
| | | 9 | 85 | 56 |
| | | 10 | 20 | 2 |
| | | 10 | 100 | 42 |
| NAS1149D0363J | | 8 | 15 | 14 |
| | | 8 | 90 | 12 |
| | | 12 | 235 | 4 |
| NAS1149D0416J | | 10 | 160 | 4 |
| NAS1149D0432J | | 10 | 155 | 4 |
| NAS1149D0516J | | 13 | 45 | 8 |
| | | 13 | 50 | 7 |
| NAS1149D0563J | | 7 | 25 | 1 |
| NAS1149DN432J | | 6 | 25 | 12 |
| | | 6 | 110 | 24 |
| NAS1149DN816J | | 9 | 10 | 58 |
| NAS1149DN832J | | 10 | 25 | 2 |
| NAS1149E0316R | | 13 | 15A | AR |
| NAS1149E0332R | | 13 | 15 | AR |
| NAS1149E0363R | | 12 | 95 | 4 |
| NAS1149E0632R | | 12 | 270 | 1 |
| NAS1149E0663R | | 12 | 282 | 2 |
| NAS1330C08-106 | | 9 | 20 | 50 |
| NAS1330C08-161 | | 9 | 25 | 7 |
| NAS1330C08-241 | | 9 | 15 | 1 |
| NAS1352N06LB4P | | 3 | 70 | 2 |
| | | 4 | 45 | 2 |
| NAS1805-3L | | 16 | 100 | 7 |
| NAS508M6 | | 12 | 195 | 1 |
| NAS509-5 | | 14 | 60 | 1 |
| | | 15 | 60 | 1 |
| NAS513-5 | | 14 | 65 | 1 |
| | | 15 | 65 | 1 |
| NAS516-1A | | 5 | 90 | 1 |

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| PART NUMBER | AIRLINE PART NUMBER | FIGURE | ITEM | UNITS PER ASSEMBLY |
|---------------|---------------------|--------|------|--------------------|
| | | 8 | 50 | 1 |
| | | 8 | 110 | 1 |
| NAS537B10P066 | | 5 | 105 | 1 |
| NAS537B16P044 | | 5 | 110 | 1 |
| NAS577B4A | | 11 | 15 | 4 |
| | | 16 | 105 | 2 |
| NAS578-4B | | 11 | 20 | 4 |
| | | 16 | 110 | 2 |
| NAS8200A8 | | 6 | 20 | 6 |
| | | 6 | 105A | 12 |
| NAS8202A10 | | 9 | 5 | 58 |
| NAS8203A10 | | 9 | 125 | 28 |
| NAS8203A8 | | 6 | 5 | 3 |
| NB12BGCM2 | | 8 | 55 | 1 |
| | | 8 | 115 | 1 |
| NB16BM2 | | 8 | 55 | 1 |
| | | 8 | 115 | 1 |
| NC16-4 | | 8 | 55 | 1 |
| | | 8 | 115 | 1 |
| NHNE5-208 | | 12 | 200 | 2 |
| NS103195-048 | | 12 | 330 | 2 |
| NS103199-054 | | 12 | 355A | 1 |
| NS202439-02 | | 10 | 60 | 1 |
| NS202439-82 | | 10 | 70 | 2 |
| NS202440-048 | | 5 | 70 | 4 |
| NS202441-02 | | 11 | 40 | 1 |
| NS202476-02 | | 2 | 335 | 8 |
| | | 2 | 425 | 8 |
| | | 3 | 30 | 16 |
| | | 4 | 30 | 1 |
| | | 4 | 85A | 2 |
| | | 7 | 75 | 2 |
| | | 10 | 110 | 32 |
| NS202484-02 | | 11 | 165 | 1 |
| NS202486-02 | | 16 | 165 | 2 |

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COMPONENT MAINTENANCE MANUAL

| PART NUMBER | AIRLINE PART NUMBER | FIGURE | ITEM | UNITS PER ASSEMBLY |
|-----------------|---------------------|--------|------|--------------------|
| NS202492-02 | | 4 | 25 | 20 |
| NS202493-048-1 | | 16 | 130 | 2 |
| | | 16 | 133 | 1 |
| NS202495-048 | | 16 | 25 | 2 |
| | | 16 | 132 | 1 |
| NS202496-02 | | 3 | 25 | 3 |
| | | 4 | 20 | 6 |
| | | 4 | 85 | 2 |
| | | 10 | 65 | 1 |
| | | 10 | 115 | 14 |
| NS202562-3-3 | | 3 | 110 | 28 |
| | | 4 | 90 | 26 |
| NS202563-3-3 | | 7 | 70 | 1 |
| P37100 | | 14 | 75 | 1 |
| | | 15 | 75 | 1 |
| PACMKP12AA3908 | | 12 | 310 | 1 |
| PACMKP12AFS428 | | 12 | 310 | 1 |
| PACMKP21BSA3908 | | 12 | 300 | 2 |
| PACMKP21BSFS428 | | 12 | 300 | 2 |
| PACMKP23BSA3908 | | 12 | 305 | 2 |
| PACMKP23BSFS428 | | 12 | 305 | 2 |
| PACMKP25BA3908 | | 12 | 365 | 2 |
| PACMKP25BFS428 | | 12 | 365 | 2 |
| PHCR56CDBACN | | 12 | 15 | 1 |
| PLH504CD | | 6 | 115 | 12 |
| PLH53CD | | 2 | 345 | 3 |
| | | 2 | 435 | 3 |
| | | 5 | 40 | 30 |
| | | 8 | 20 | 14 |
| | | 8 | 95 | 12 |
| | | 12 | 100 | 4 |
| | | 12 | 250 | 4 |
| | | 14 | 45 | 4 |
| | | 15 | 45 | 4 |
| PLH53CM | | 13 | 20 | 14 |

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| PART NUMBER | AIRLINE PART NUMBER | FIGURE | ITEM | UNITS PER ASSEMBLY |
|----------------|---------------------|--------|------|--------------------|
| PLH54CD | | 11 | 100 | 8 |
| | | 12 | 255 | 2 |
| PLH55CD | | 7 | 20 | 1 |
| | | 11 | 105 | 2 |
| REM10ATC16-2 | | 12 | 200 | 2 |
| RMA9205-4 | | 12 | 330 | 2 |
| RMA9205M5 | | 12 | 355A | 1 |
| RV541A3C2 | | 2 | 330 | 16 |
| | | 2 | 420 | 16 |
| | | 3 | 105 | 56 |
| | | 4 | 80 | 56 |
| RV541A3C3 | | 3 | 15 | 38 |
| | | 4 | 15 | 54 |
| RV541A3C4 | | 3 | 20 | 6 |
| SL2808-3 | | 16 | 190 | 12 |
| SSMKP12AP | | 12 | 310 | 1 |
| SSMKP12ASD705 | | 12 | 310 | 1 |
| SSMKP21BSSD705 | | 12 | 300 | 2 |
| | | 12 | 305 | 2 |
| SSMKP23BSSD705 | | 12 | 305 | 2 |
| SSMKP25BSD703 | | 12 | 365 | 2 |
| T6C1032JCD | | 16 | 165 | 2 |
| T8059S1032B1 | | 6 | 90 | 3 |
| | | 6 | 90 | 3 |
| T8078S524 | | 12 | 355A | 1 |
| T8092C1032CD | | 2 | 335 | 8 |
| | | 2 | 425 | 8 |
| | | 3 | 30 | 16 |
| | | 4 | 30 | 1 |
| | | 4 | 85A | 2 |
| | | 7 | 75 | 2 |
| | | 10 | 110 | 32 |
| T8118S4 | | 12 | 330 | 2 |
| TFM105A | | 12 | 200 | 2 |
| VN103A1-048 | | 12 | 330 | 2 |

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**COMPONENT MAINTENANCE MANUAL**

| PART NUMBER | AIRLINE PART NUMBER | FIGURE | ITEM | UNITS PER ASSEMBLY |
|--------------------|----------------------------|---------------|-------------|---------------------------|
| WC331K6-3 | | 2 | 130A | 2 |

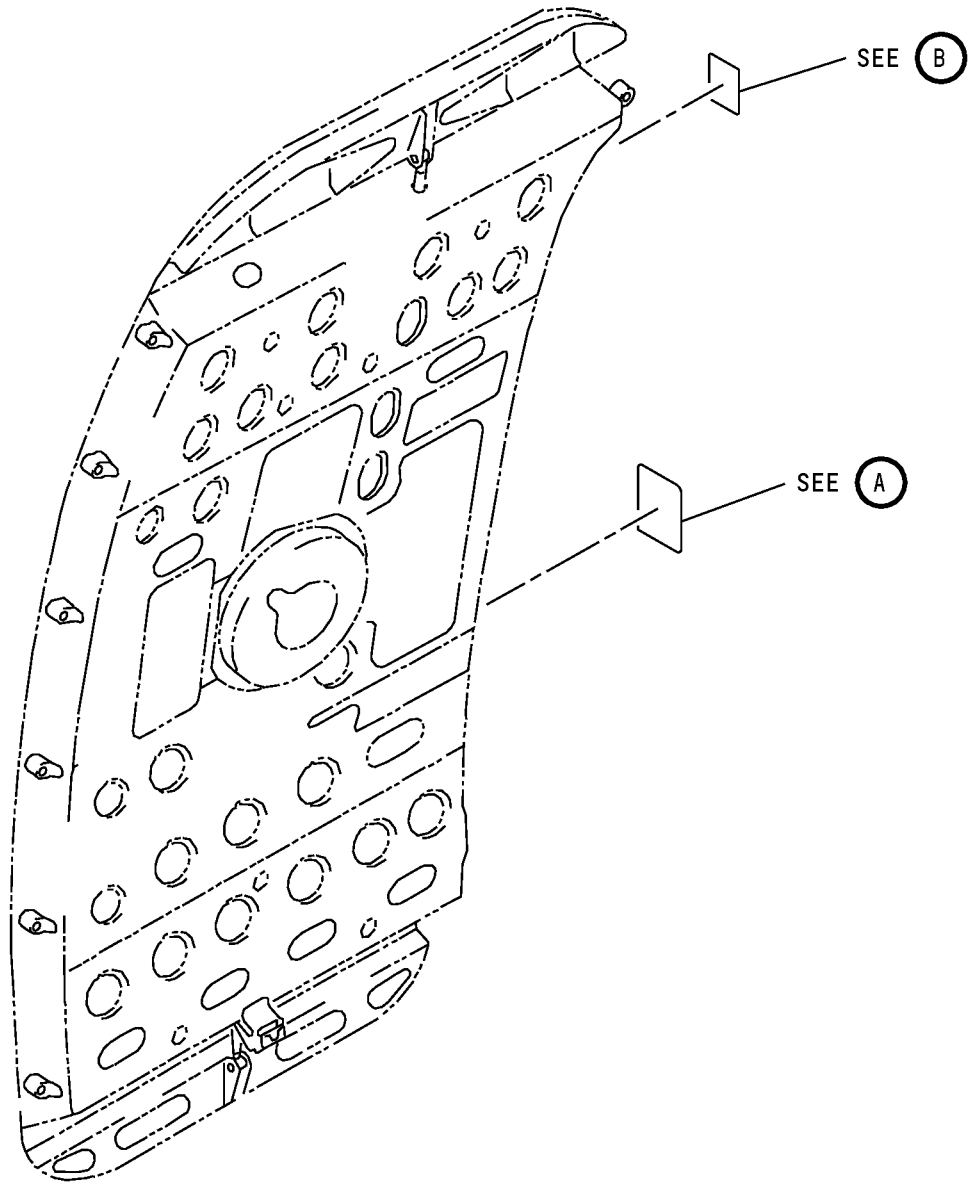
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Forward Entry Door Assembly
IPL Figure 1 (Sheet 1 of 2)

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○ AIRCRAFT MOD.
MFR. CODE
PART NO.
CONT NO.
SERIAL NO.

CONT. CUST.

INSP. INSP.

MODIFICATION INCORPORATED

(A)

DOOR CYCLE LOG

| AIRPLANE SERIAL NO. | AIRPLANE FLIGHT CYCLES AT INSTL | AIRPLANE FLIGHT CYCLES AT REMOVAL |
|------------------------|---------------------------------------|---|
| <input type="text"/> | <input type="text"/> | <input type="text"/> |
| <input type="text"/> | <input type="text"/> | <input type="text"/> |
| <input type="text"/> | <input type="text"/> | <input type="text"/> |
| <input type="text"/> | <input type="text"/> | <input type="text"/> |
| <input type="text"/> | <input type="text"/> | <input type="text"/> |
| <input type="text"/> | <input type="text"/> | <input type="text"/> |
| <input type="text"/> | <input type="text"/> | <input type="text"/> |

(B)

Forward Entry Door Assembly
IPL Figure 1 (Sheet 2 of 2)



COMPONENT MAINTENANCE MANUAL

| FIG/ ITEM | PART NUMBER | AIRLINE PART NUMBER | NOMENCLATURE | | | | | | | USAGE CODE | UNITS PER ASSY |
|--------------|--------------|---------------------------|--------------|---|---|---|---|---|---|---------------|----------------------|
| | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | | |
| 1- | | | | | | | | | | | |
| -1A | 141A6100-678 | | | | | | | | | A | RF |
| -3 | 141A6150-1 | | | | | | | | | B | RF |
| -3A | 141A6150-2 | | | | | | | | | C | RF |
| -3B | 141A6150-3 | | | | | | | | | D | RF |
| -3C | 141A6150-4 | | | | | | | | | E | RF |
| -3D | 141A6150-5 | | | | | | | | | F | RF |
| -3E | 141A6150-6 | | | | | | | | | G | RF |
| -3F | 141A6150-7 | | | | | | | | | H | RF |
| -3G | 141A6150-8 | | | | | | | | | J | RF |
| -5 | 141A6101-1 | | | | | | | | | A | 1 |
| | | | | | | | | | | | |
| -5A | 141A6101-2 | | | | | | | | | A | 1 |
| | | | | | | | | | | | |
| -5B | 141A6101-3 | | | | | | | | | A | 1 |
| | | | | | | | | | | | |
| -5C | 141A6101-3 | | | | | | | | | B, C | 1 |
| | | | | | | | | | | | |
| -5D | 141A6101-4 | | | | | | | | | D | 1 |
| | | | | | | | | | | | |
| -5E | 141A6101-5 | | | | | | | | | E, F | 1 |
| | | | | | | | | | | | |
| -5F | 141A6101-6 | | | | | | | | | G, H | 1 |
| | | | | | | | | | | | |
| -5G | 141A6101-7 | | | | | | | | | J | 1 |
| | | | | | | | | | | | |
| -10 | 141A6170-1 | | | | | | | | | A | 1 |
| | | | | | | | | | | | |
| -10A | 141A6170-2 | | | | | | | | | A | 1 |
| | | | | | | | | | | | |

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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- | | | | | | | | | | | |
| -10B | 141A6170-2 | | . | GATE | INSTL-UPR | | | | | B, C | 1 |
| | | | | | | | | | | | |
| | | | | | | | | | | | |
| -10C | 141A6170-3 | | . | GATE | ASSY-UPR | | | | | D-J | 1 |
| | | | | | | | | | | | |
| | | | | | | | | | | | |
| -15 | 141A6180-1 | | . | GATE | INSTL-LWR | | | | | A | 1 |
| | | | | | | | | | | | |
| | | | | | | | | | | | |
| -15A | 141A6180-2 | | . | GATE | INSTL-LWR | | | | | A | 1 |
| | | | | | | | | | | | |
| | | | | | | | | | | | |
| -15B | 141A6180-2 | | . | GATE | INSTL-LWR | | | | | B-J | 1 |
| | | | | | | | | | | | |
| | | | | | | | | | | | |
| -20 | 141A6190-1 | | . | SUPPORT | INSTL-HINGE | | | | | A | 1 |
| | | | | | | | | | | | |
| | | | | | | | | | | | |
| -20A | 141A6190-1 | | . | SUPPORT | INSTL-HINGE | | | | | B-J | 1 |
| | | | | | | | | | | | |
| | | | | | | | | | | | |
| -25 | 141A6200-1 | | . | WINDOW | INSTL | | | | | A | 1 |
| | | | | | | | | | | | |
| | | | | | | | | | | | |
| -25A | 141A6200-1 | | . | WINDOW | INSTL | | | | | B-G | 1 |
| | | | | | | | | | | | |
| | | | | | | | | | | | |
| -25B | 141A6200-2 | | . | WINDOW | ASSY | | | | | H, J | 1 |
| | | | | | | | | | | | |
| | | | | | | | | | | | |
| -30 | 141A6205-1 | | . | GUIDE | INSTL-CENTERING | | | | | A | 1 |
| | | | | | | | | | | | |
| | | | | | | | | | | | |
| -30A | 141A6205-1 | | . | GUIDE | INSTL-CENTERING | | | | | B-J | 1 |
| | | | | | | | | | | | |
| | | | | | | | | | | | |
| -35 | 141A6220-1 | | . | HOUSING | INSTL-LATCH TORQUE TUBE | | | | | A | 1 |
| | | | | | | | | | | | |
| | | | | | | | | | | | |
| -35A | 141A6220-1 | | . | HOUSING | INSTL-LATCH TORQUE TUBE | | | | | B-J | 1 |
| | | | | | | | | | | | |
| | | | | | | | | | | | |
| -40 | 141A6240-1 | | . | SEAL | INSTL-PRESSURE | | | | | A | 1 |
| | | | | | | | | | | | |
| | | | | | | | | | | | |
| -40A | 141A6240-2 | | . | SEAL | INSTL-PRESSURE | | | | | A | 1 |
| | | | | | | | | | | | |
| | | | | | | | | | | | |

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| FIG/ ITEM | PART NUMBER | AIRLINE PART NUMBER | NOMENCLATURE | USAGE CODE | UNITS PER ASSY |
|--------------|-------------|---------------------------|--|---------------|----------------------|
| | | | | | |
| 1- | | | | | |
| -40B | 141A6240-3 | | . SEAL INSTL-PRESSURE (LIMITED USAGE) (FOR DETAILS SEE FIG. 9) | A | 1 |
| -40C | 141A6240-4 | | . SEAL INSTL-PRESSURE (LIMITED USAGE) (FOR DETAILS SEE FIG. 9) | A | 1 |
| -40D | 141A6240-4 | | . SEAL INSTL-PRESSURE (FOR DETAILS SEE FIG. 9) | B, C | 1 |
| -40E | 141A6240-5 | | . SEAL ASSY-PRESSURE (FOR DETAILS SEE FIG. 9) | D-J | 1 |
| -45 | 141A6260-1 | | . SKIN INSTL-INNER (LIMITED USAGE) (FOR DETAILS SEE FIG. 10) | A | 1 |
| -45A | 141A6260-2 | | . SKIN INSTL-INNER (LIMITED USAGE) (FOR DETAILS SEE FIG. 10) | A | 1 |
| -45B | 141A6260-2 | | . SKIN INSTL-INNER (FOR DETAILS SEE FIG. 10) | B-J | 1 |
| -50 | 141A6280-1 | | DELETED | | |
| -50A | 141A6280-2 | | DELETED | | |
| -50B | 141A6280-3 | | . HINGE INSTL (LIMITED USAGE) (FOR DETAILS SEE FIG. 11) | A | 1 |
| -50C | 141A6280-4 | | . HINGE INSTL (LIMITED USAGE) (FOR DETAILS SEE FIG. 11) | A | 1 |
| -50D | 141A6280-4 | | . HINGE INSTL (FOR DETAILS SEE FIG. 11) | B-J | 1 |
| -55 | 141A6301-1 | | . BOX INSTL-HANDLE (LIMITED USAGE) (FOR DETAILS SEE FIG. 12) | A | 1 |
| -55A | 141A6301-1 | | . BOX INSTL-HANDLE (FOR DETAILS SEE FIG. 12) | B-D | 1 |
| -55B | 141A6301-2 | | . BOX ASSY-HANDLE (FOR DETAILS SEE FIG. 12) | E | 1 |
| -55C | 141A6301-3 | | . BOX ASSY-HANDLE (FOR DETAILS SEE FIG. 12) | F-J | 1 |

-Item not Illustrated

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| FIG/ ITEM | PART NUMBER | AIRLINE PART NUMBER | NOMENCLATURE | USAGE CODE | UNITS PER ASSY |
|--------------|-------------|---------------------------|---|---------------|----------------------|
| | | | | | |
| 1- | | | | | |
| -60 | 141A6320-1 | | . TUBE INSTL-LATCH TORQUE (LIMITED USAGE) (FOR DETAILS SEE FIG. 13) | A | 1 |
| -60A | 141A6320-1 | | . TUBE INSTL-LATCH TORQUE (FOR DETAILS SEE FIG. 13) | B | 1 |
| -60B | 141A6320-2 | | . TUBE ASSY-LATCH TORQUE (FOR DETAILS SEE FIG. 13) | C-J | 1 |
| -65 | 141A6330-1 | | . ROD INSTL-UPR (LIMITED USAGE) (FOR DETAILS SEE FIG. 14) | A | 1 |
| -65A | 141A6330-1 | | . ROD INSTL-UPR (FOR DETAILS SEE FIG. 14) | B-J | 1 |
| -70 | 141A6330-2 | | . ROD INSTL-LWR (LIMITED USAGE) (FOR DETAILS SEE FIG. 15) | A | 1 |
| -70A | 141A6330-2 | | . ROD INSTL-LWR (FOR DETAILS SEE FIG. 15) | B-J | 1 |
| -75 | 141A6350-1 | | . SUPPORT INSTL-INTR (LIMITED USAGE) (FOR DETAILS SEE FIG. 16) | A | 1 |
| -75A | 141A6350-2 | | . SUPPORT ASSY-INTR (LIMITED USAGE) (FOR DETAILS SEE FIG. 16) | A | 1 |
| -75B | 141A6350-2 | | . SUPPORT ASSY-INTR (FOR DETAILS SEE FIG. 16) | B | 1 |
| -75C | 141A6350-3 | | . SUPPORT ASSY-INTR (FOR DETAILS SEE FIG. 16) | C-J | 1 |
| -80 | 141A6111-1 | | . MARKER INSTL (LIMITED USAGE) | A | 1 |
| -80A | 141A6111-1 | | . MARKER INSTL | B-J | 1 |
| 85 | MS27253F1 | | . . PLATE | | 1 |
| 90 | BAC27DBY191 | | . . MARKER-ALUMINUM FOIL | | 1 |
| -95 | 141A6210-1 | | . MINOR ASSY-HANDLE PAN (FOR DETAILS SEE FIG. 17) | | 1 |

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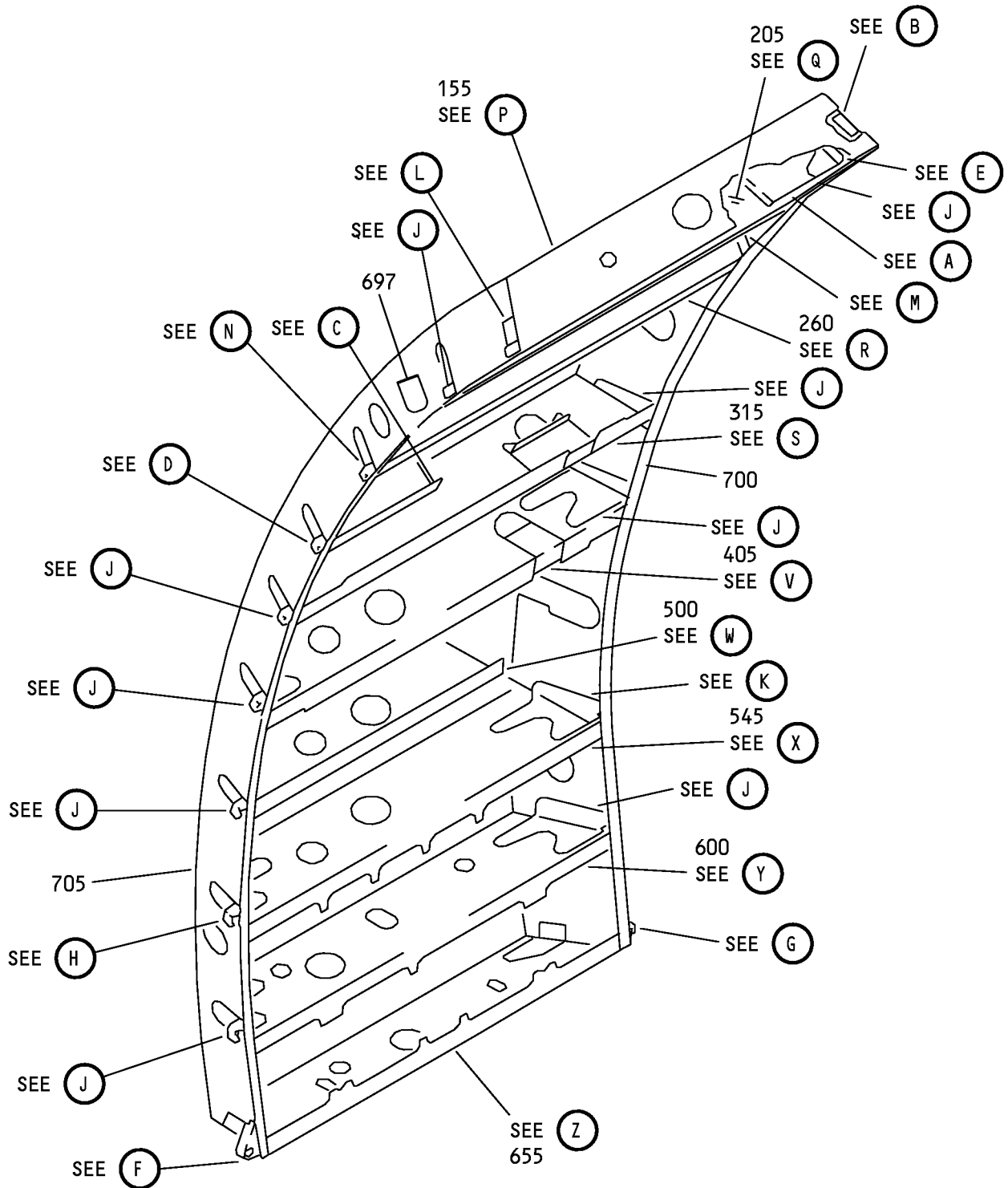
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G97825 S00041000625_V2

Frame and Beam Installation
IPL Figure 2 (Sheet 1 of 17)

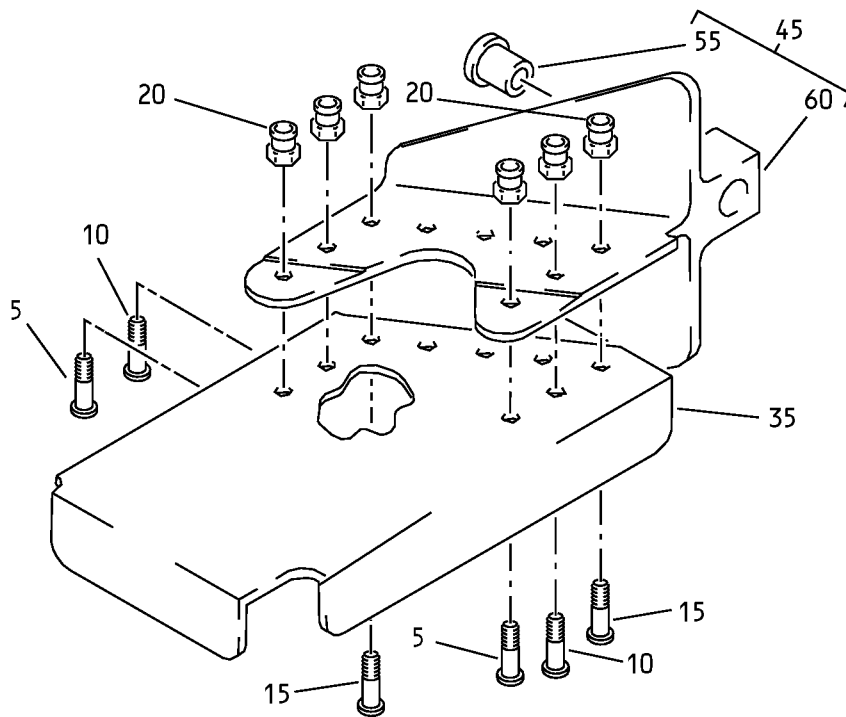
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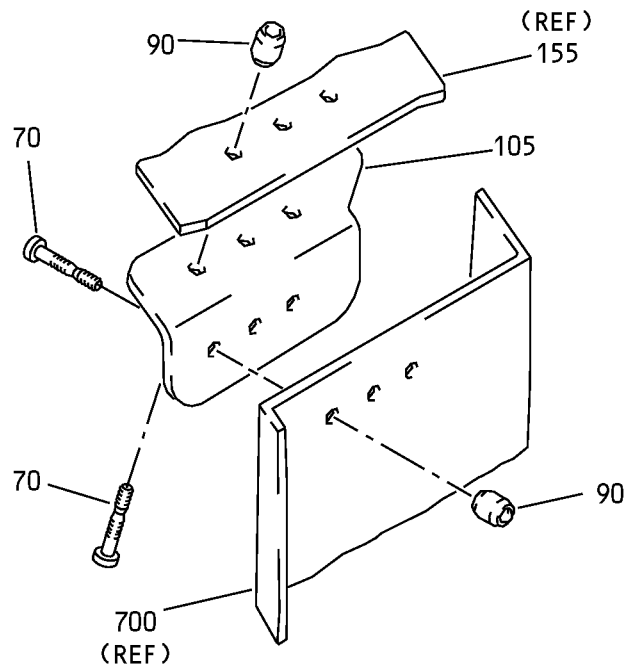
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(A)



(B)

Frame and Beam Installation
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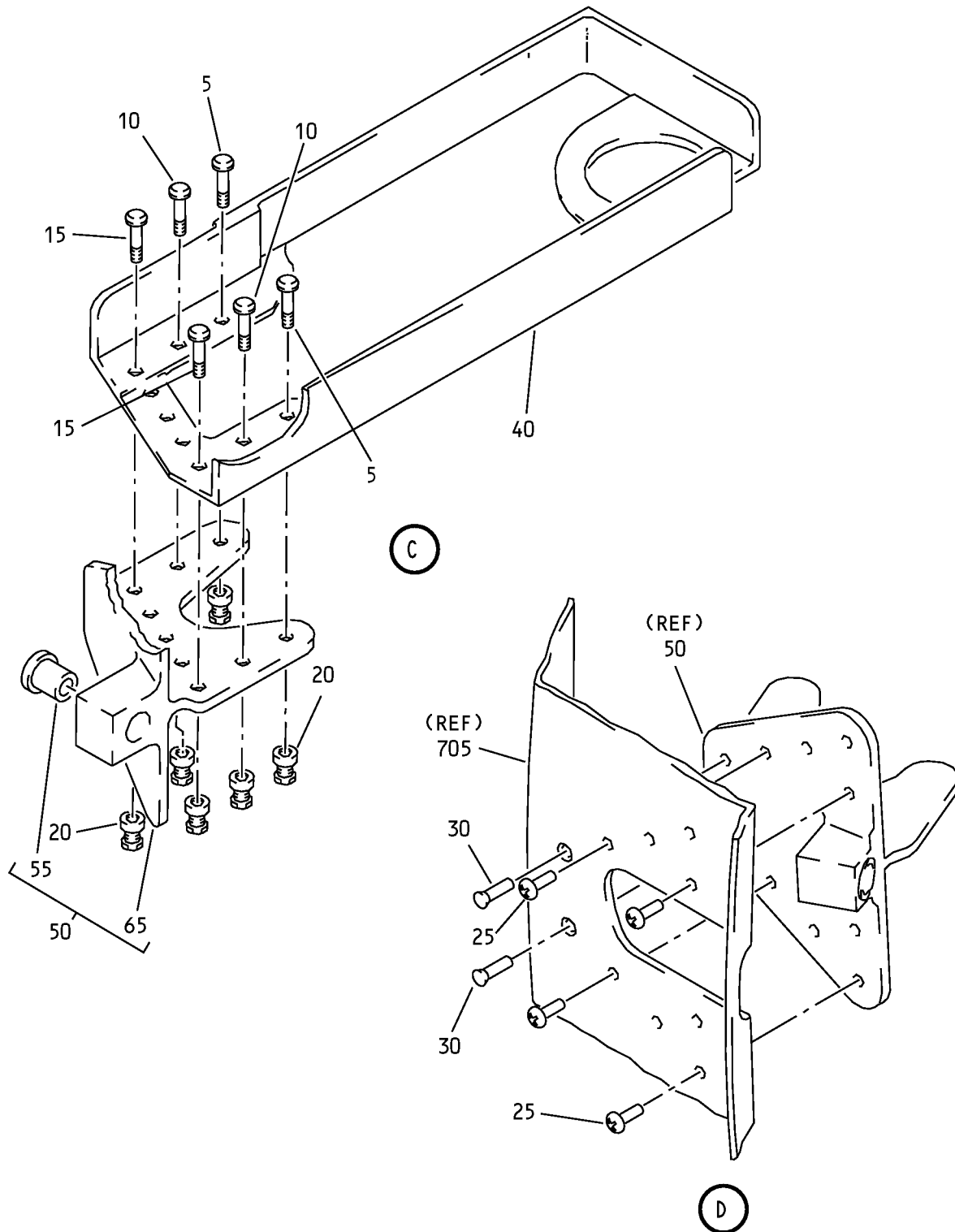
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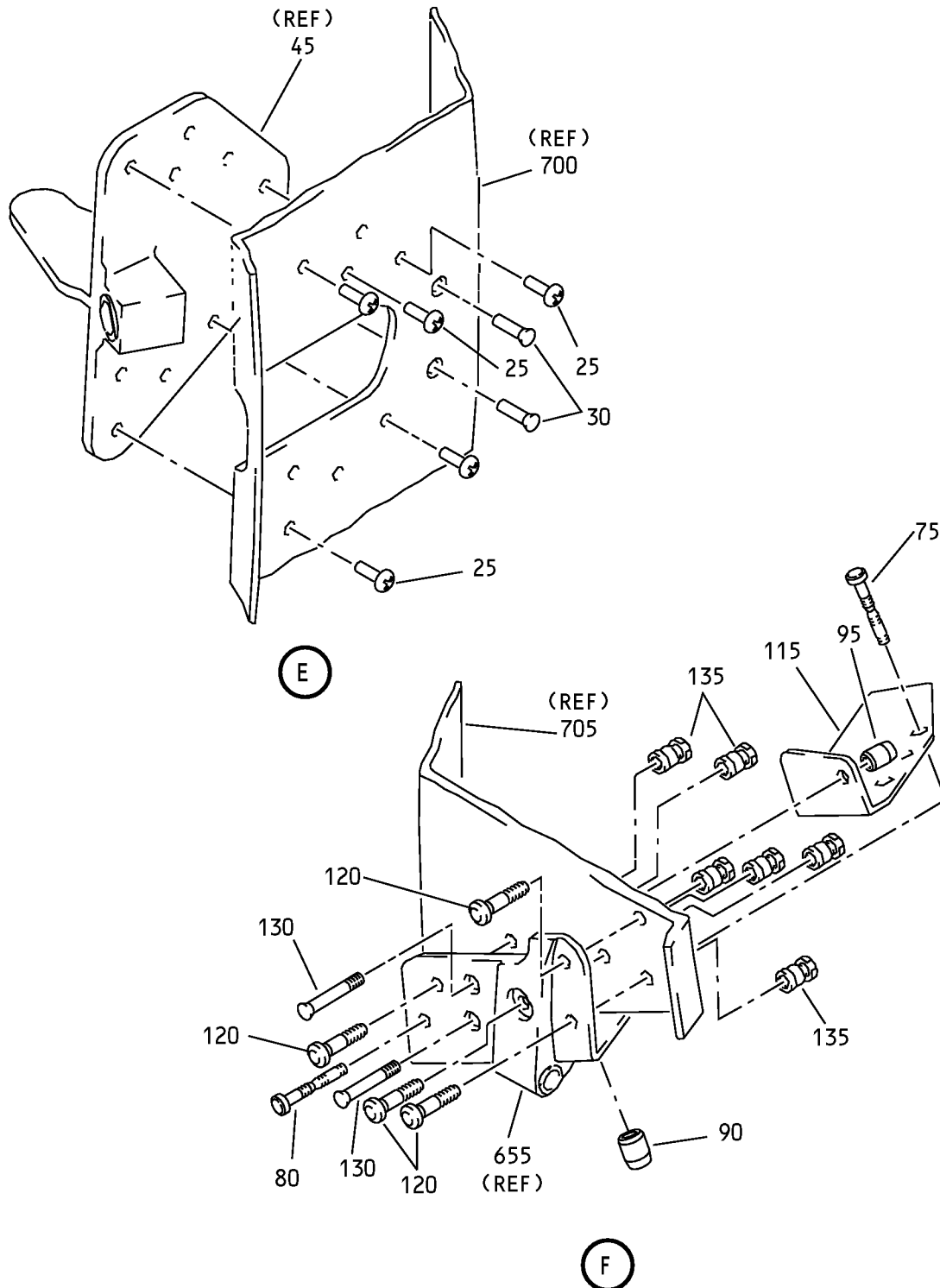
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COMPONENT MAINTENANCE MANUAL



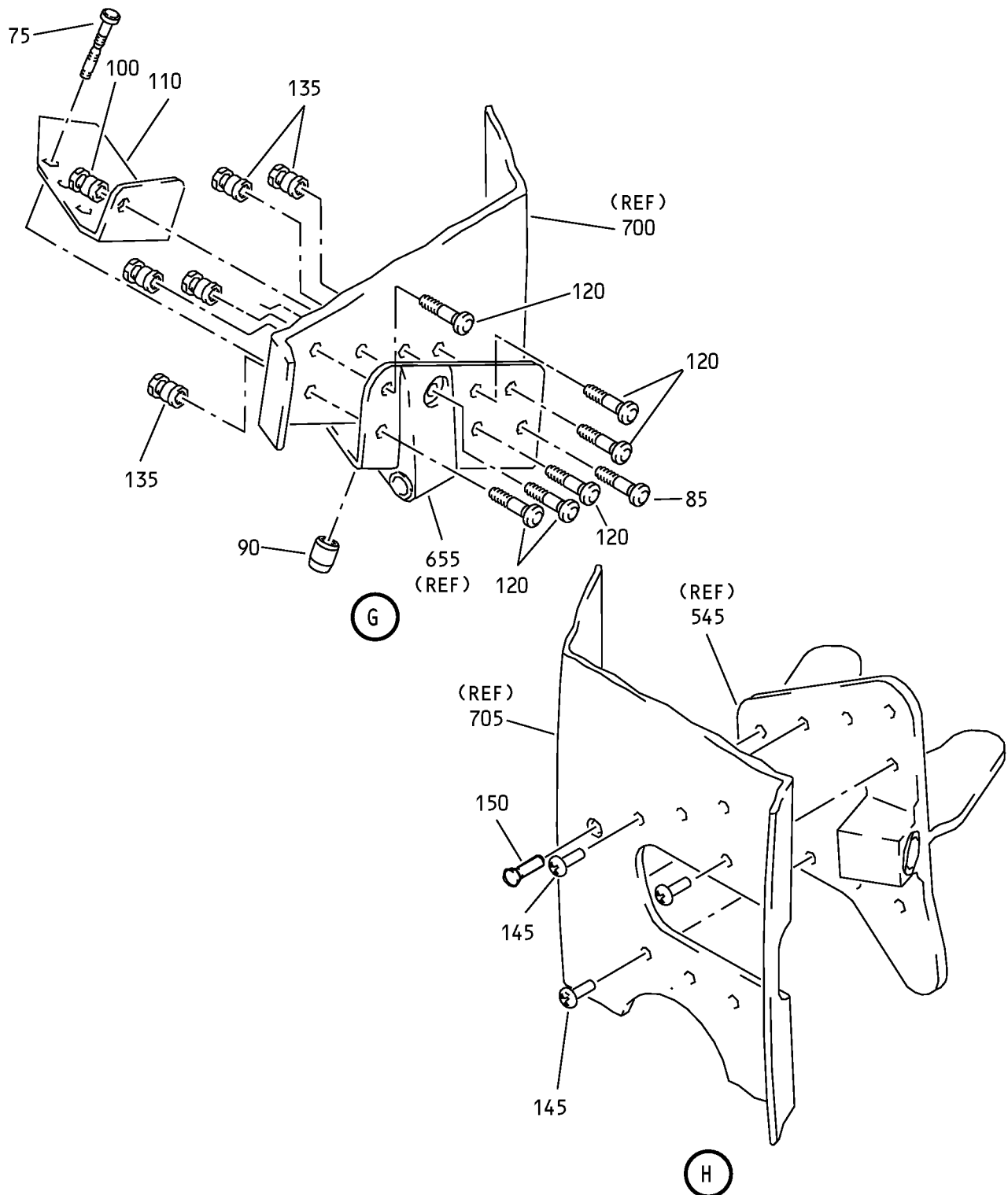
Frame and Beam Installation
IPL Figure 2 (Sheet 3 of 17)

COMPONENT MAINTENANCE MANUAL



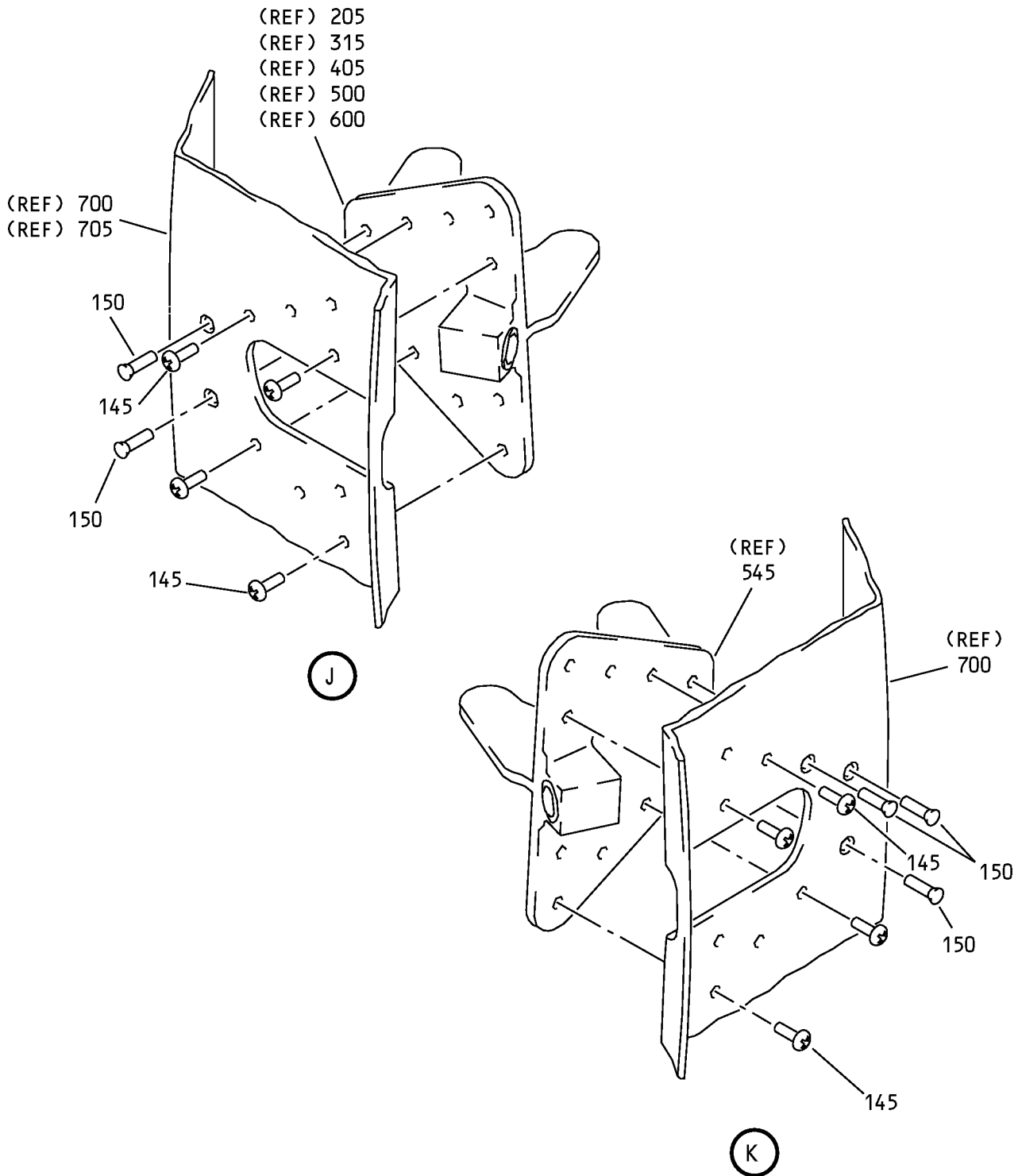
Frame and Beam Installation
IPL Figure 2 (Sheet 4 of 17)

COMPONENT MAINTENANCE MANUAL



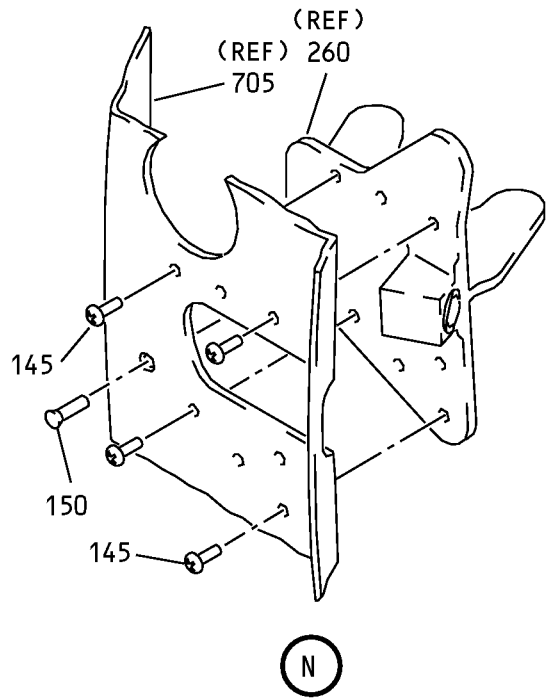
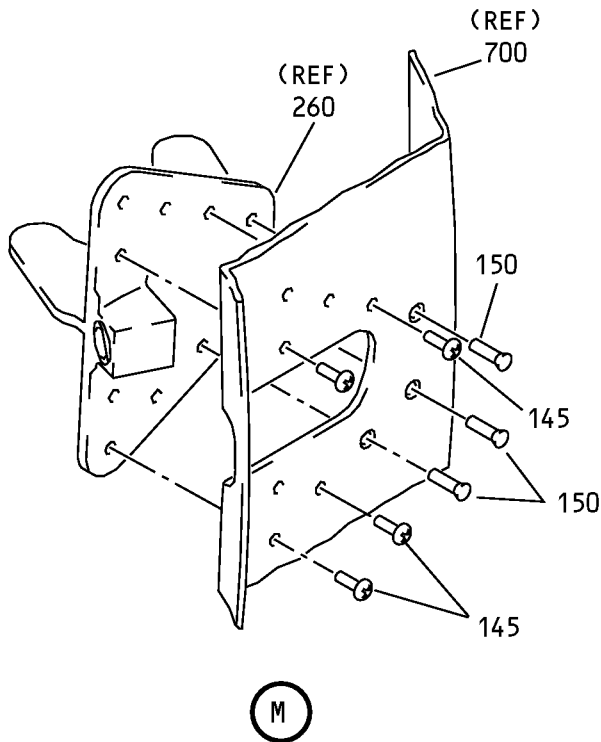
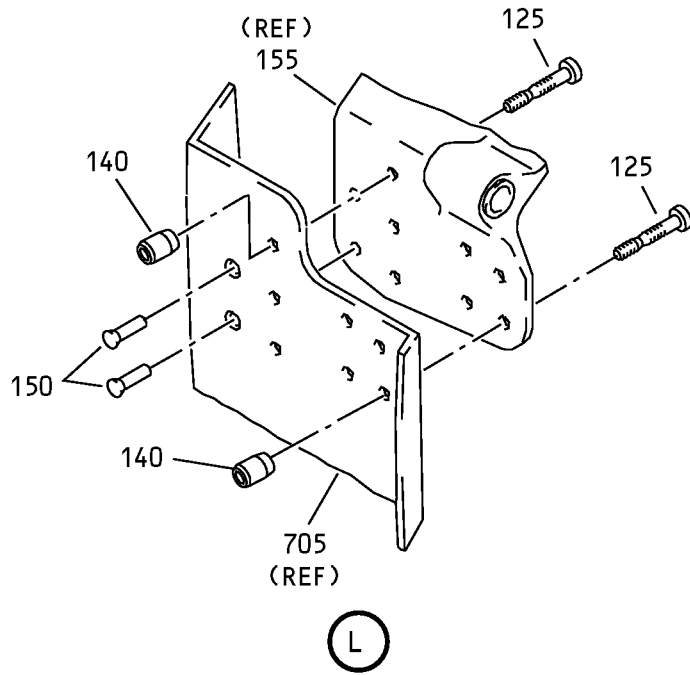
Frame and Beam Installation
IPL Figure 2 (Sheet 5 of 17)

COMPONENT MAINTENANCE MANUAL



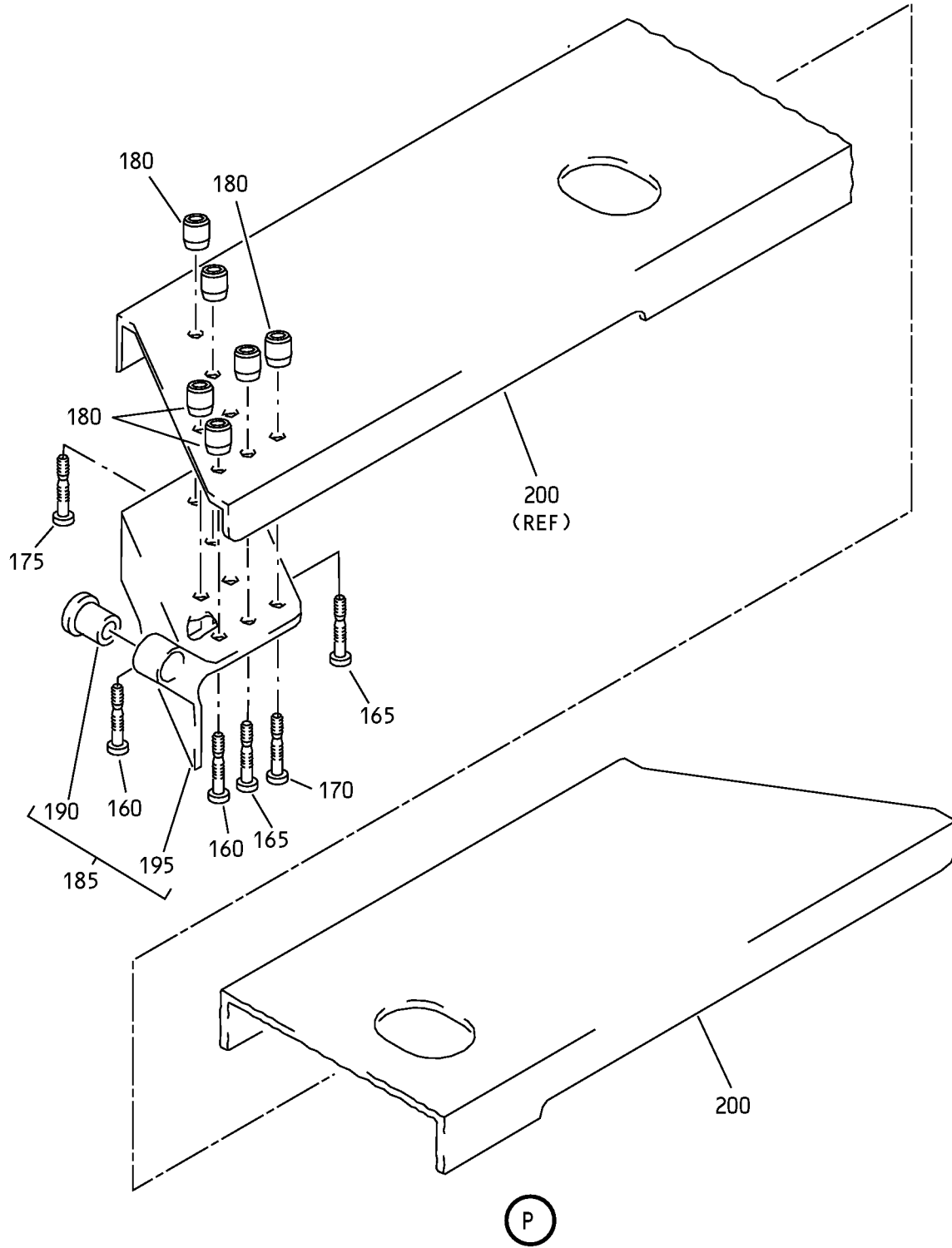
Frame and Beam Installation
IPL Figure 2 (Sheet 6 of 17)

COMPONENT MAINTENANCE MANUAL



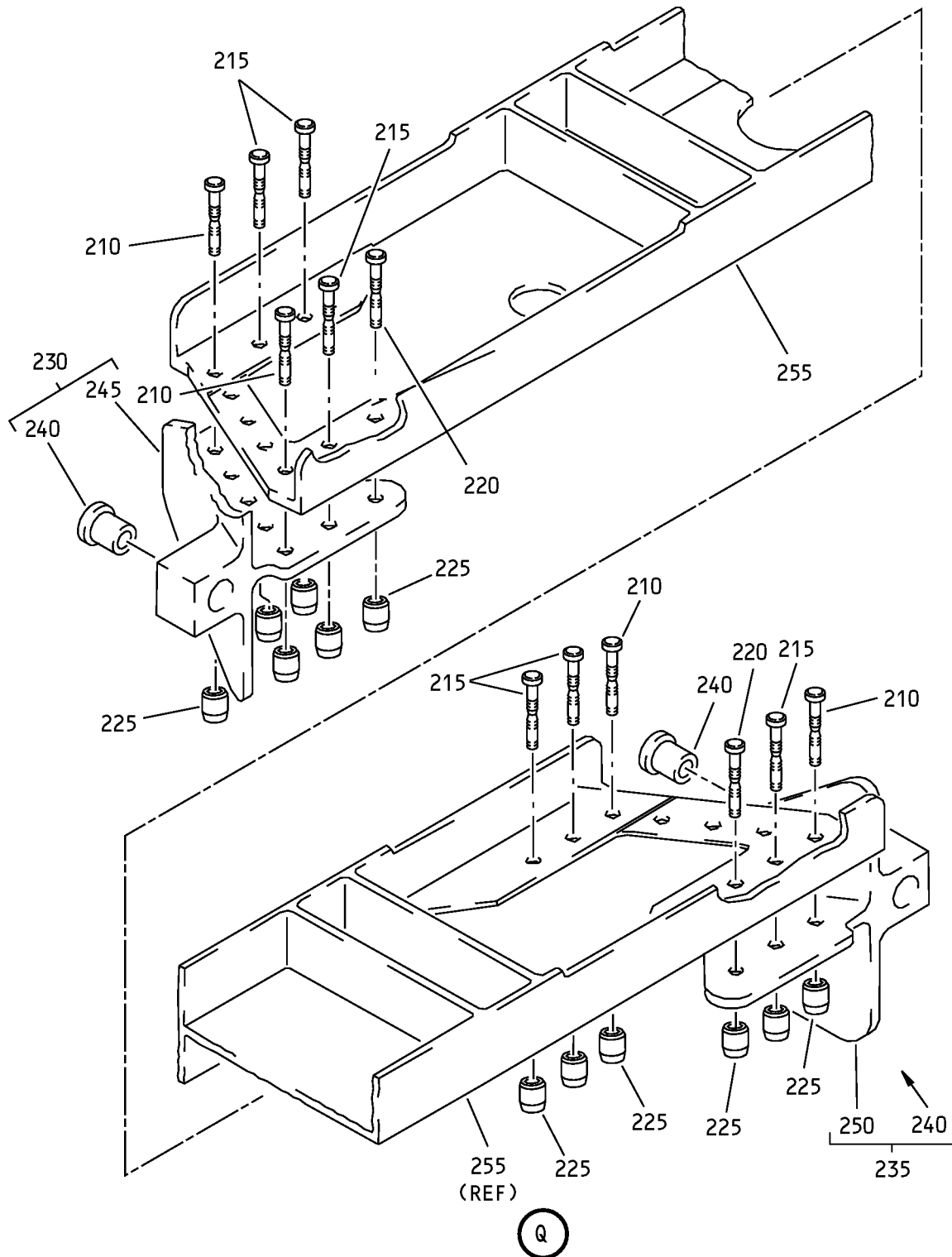
Frame and Beam Installation
IPL Figure 2 (Sheet 7 of 17)

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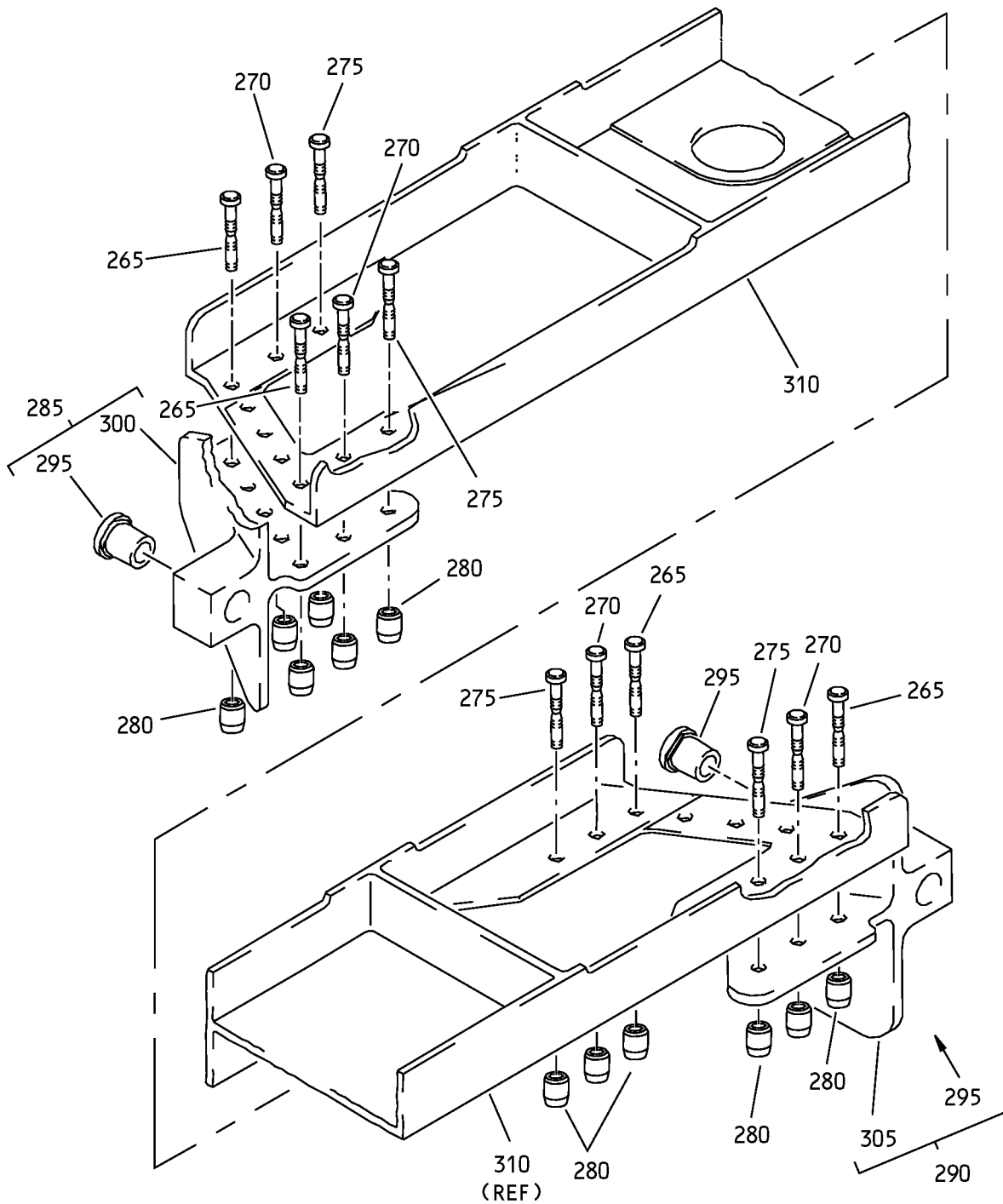
Frame and Beam Installation
IPL Figure 2 (Sheet 8 of 17)

COMPONENT MAINTENANCE MANUAL



Frame and Beam Installation
IPL Figure 2 (Sheet 9 of 17)

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(R)

Frame and Beam Installation
IPL Figure 2 (Sheet 10 of 17)

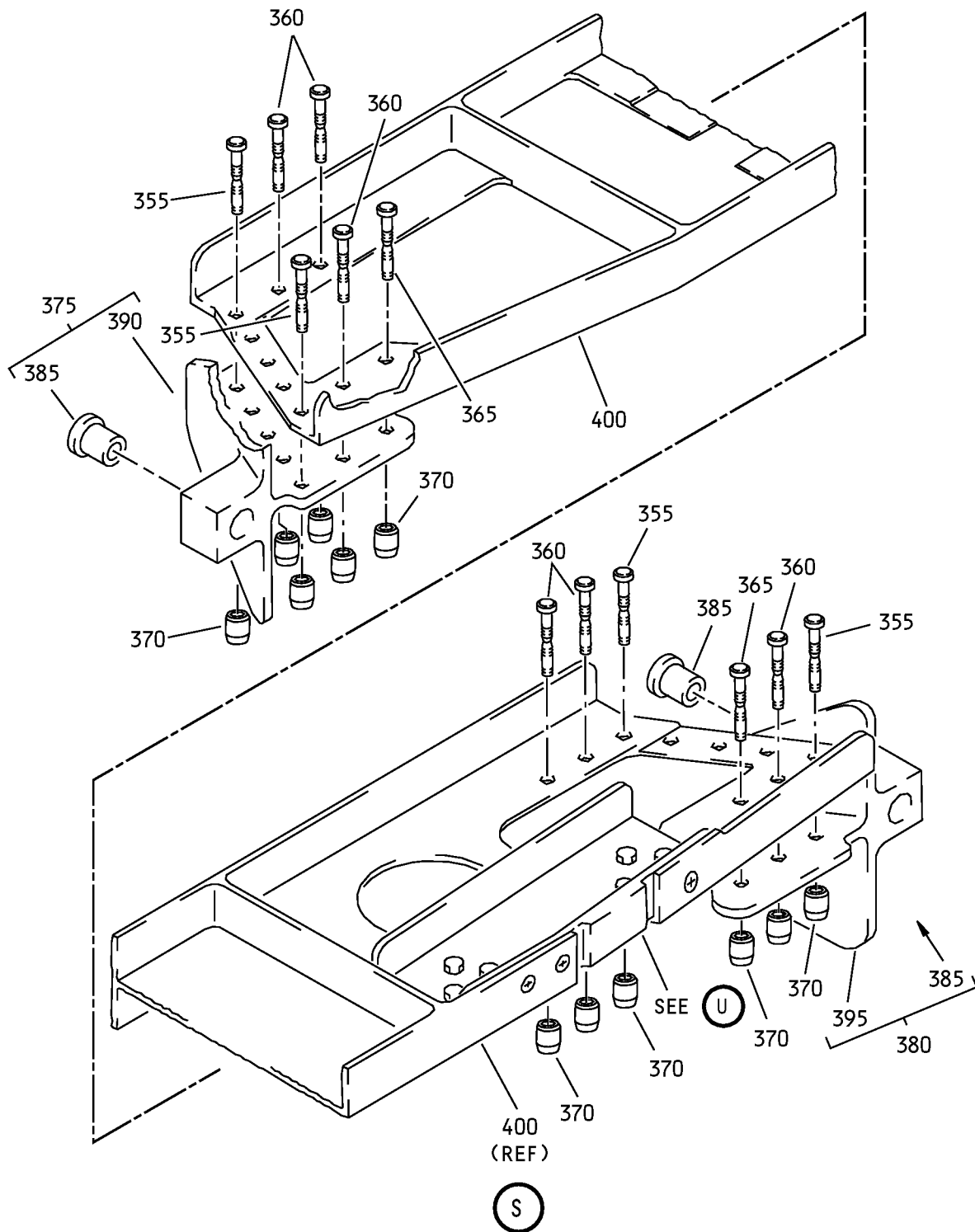
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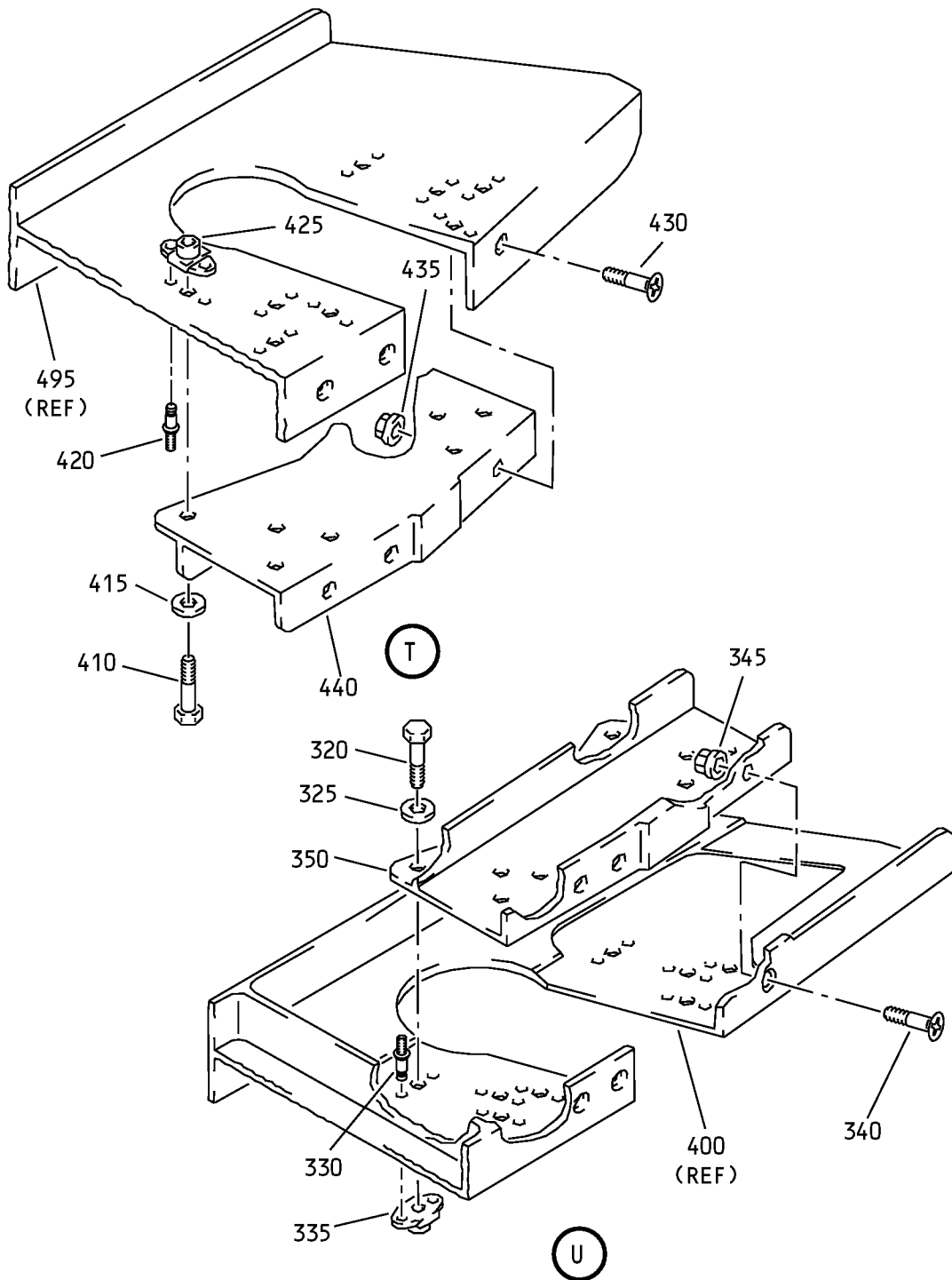
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COMPONENT MAINTENANCE MANUAL



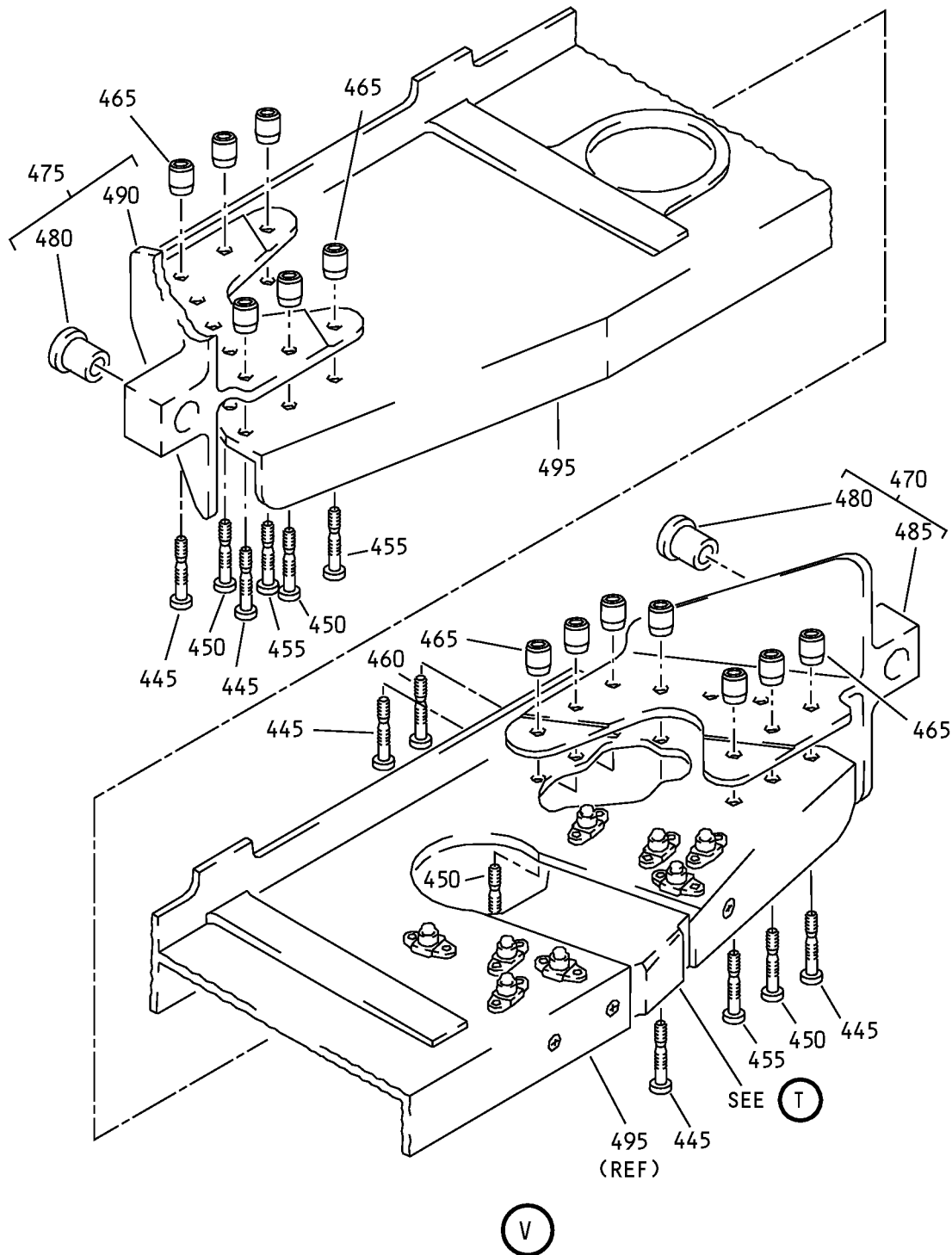
Frame and Beam Installation
IPL Figure 2 (Sheet 11 of 17)

COMPONENT MAINTENANCE MANUAL



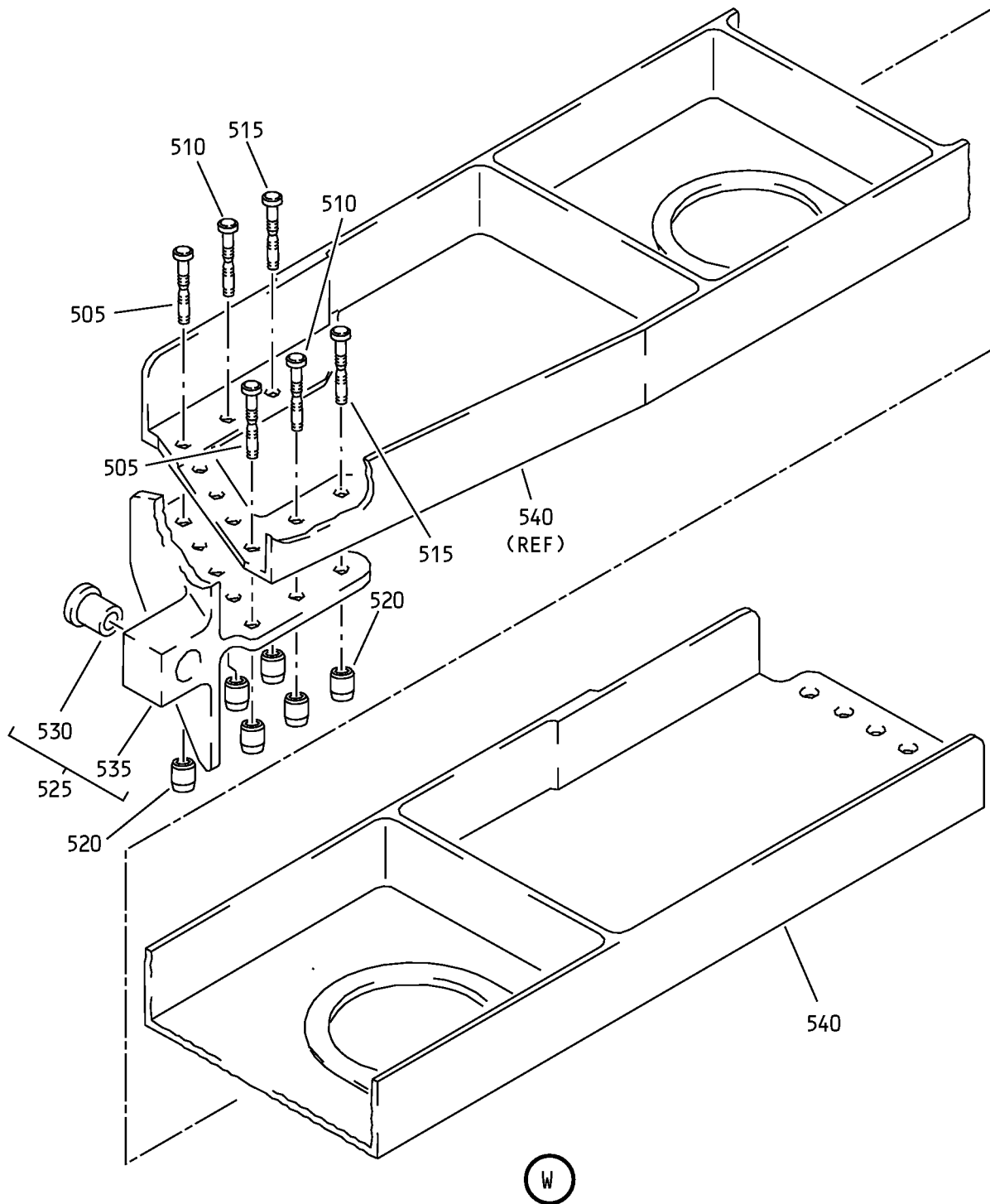
Frame and Beam Installation
IPL Figure 2 (Sheet 12 of 17)

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Frame and Beam Installation
IPL Figure 2 (Sheet 13 of 17)

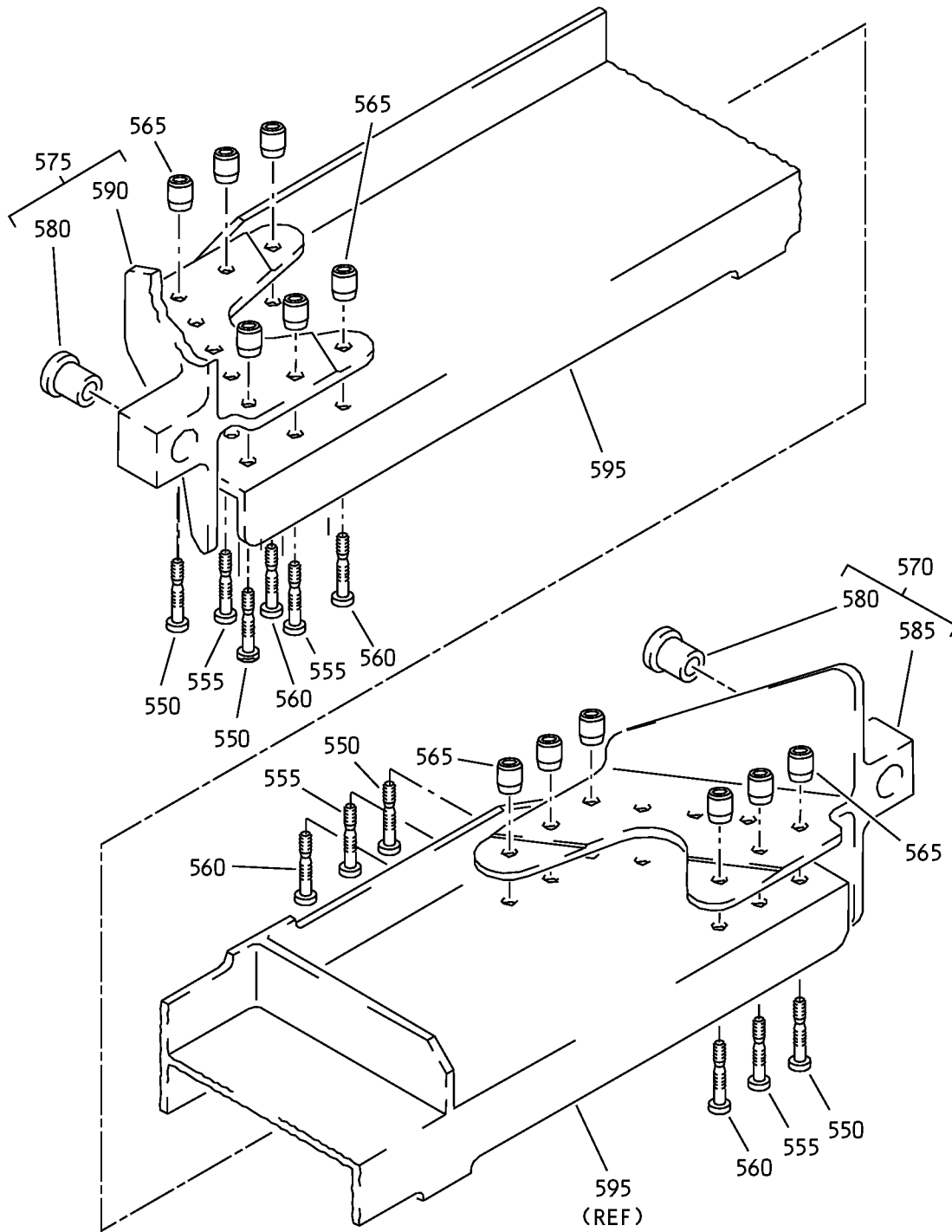
COMPONENT MAINTENANCE MANUAL



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Frame and Beam Installation
IPL Figure 2 (Sheet 14 of 17)

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Frame and Beam Installation
IPL Figure 2 (Sheet 15 of 17)

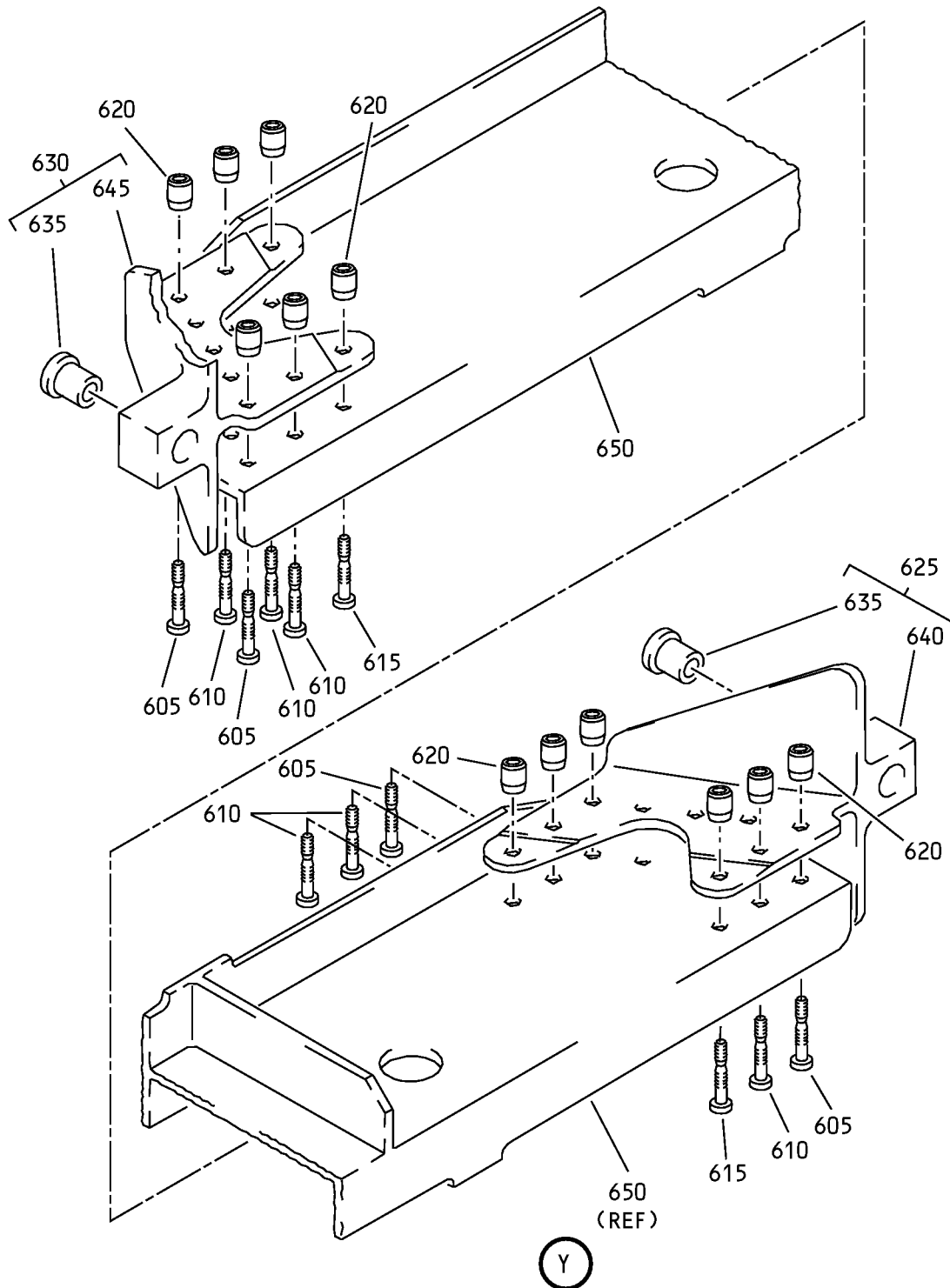
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Frame and Beam Installation
IPL Figure 2 (Sheet 16 of 17)



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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- | | | | | | | | | | | |
| -1A | 141A6101-1 | | | | | | | | | A | RF |
| -1B | 141A6101-2 | | | | | | | | | A | RF |
| -1C | 141A6101-3 | | | | | | | | | A | RF |
| -1D | 141A6101-3 | | | | | | | | | B, C | RF |
| -1E | 141A6101-4 | | | | | | | | | D | RF |
| -1F | 141A6101-5 | | | | | | | | | E, F | RF |
| -1G | 141A6101-6 | | | | | | | | | G, H | RF |
| -1H | 141A6101-7 | | | | | | | | | J | RF |
| 5 | HST10AG6-4 | | | | | | | | | | 4 |
| | | | | | | | | | | | |
| 10 | HST10AG6-5 | | | | | | | | | | 4 |
| | | | | | | | | | | | |
| 15 | HST10AG6-6 | | | | | | | | | | 10 |
| | | | | | | | | | | | |
| 20 | HST826AW | | | | | | | | | | 18 |
| | | | | | | | | | | | |
| 25 | BACR15FT6D | | | | | | | | | | 16 |
| | | | | | | | | | | | |

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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- | | | | | | | | | | | |
| 30 | BACR15GF6D | | . | RIVET | | | | | | | 4 |
| | | | | (SIZE DETERMINED ON INST) | | | | | | | |
| 35 | 141A6121-11 | | . | BEAM | | | | | | | 1 |
| 40 | 141A6121-4 | | . | BEAM | | | | | | | 1 |
| 45 | 141A6103-1 | | . | FITTING ASSY-STOP | | | | | | | 1 |
| 50 | 141A6103-11 | | . | FITTING ASSY-STOP | | | | | | | 1 |
| 55 | 66-12688-11 | | . | BUSHING | | | | | | | 1 |
| 60 | 141A6103-2 | | . | FITTING | | | | | | | 1 |
| | | | | (USED ON ITEM 45) | | | | | | | |
| 65 | 141A6103-12 | | . | FITTING | | | | | | | 1 |
| | | | | (USED ON ITEM 50) | | | | | | | |
| 70 | LGPL2SPV6-3AC | | . | BOLT | | | | | | | 6 |
| | | | | (V17446) | | | | | | | |
| | | | | (SPEC BACB30VN6K3) | | | | | | | |
| | | | | (OPT LGPL2SPV6-3AC (V92215)) | | | | | | | |
| | | | | (OPT 81669V6K3 (V56878)) | | | | | | | |
| | | | | (OPT LGPL2SPV6-3AC (V56878)) | | | | | | | |
| 75 | LGPL2SPV6-4AC | | . | BOLT | | | | | | | 6 |
| | | | | (V17446) | | | | | | | |
| | | | | (SPEC BACB30VN6K4) | | | | | | | |
| | | | | (OPT LGPL2SPV6-4AC (V92215)) | | | | | | | |
| | | | | (OPT 81669V6K4 (V56878)) | | | | | | | |
| | | | | (OPT LGPL2SPV6-4AC (V56878)) | | | | | | | |
| 80 | LGPL2SPV6-4AC | | . | BOLT | | | | | A | | 1 |
| | | | | (V17446) | | | | | | | |
| | | | | (SPEC BACB30VN6K4) | | | | | | | |
| | | | | (OPT LGPL2SPV6-4AC (V92215)) | | | | | | | |
| | | | | (OPT 81669V6K4 (V56878)) | | | | | | | |
| | | | | (OPT LGPL2SPV6-4AC (V56878)) | | | | | | | |
| | | | | (USED ON ITEMS 1A, 1E, 1F, 1G, 1H) | | | | | | | |
| -80A | HST10AG6-4 | | . | BOLT | | | | | | | 1 |
| | | | | (V06725) | | | | | | | |
| | | | | (SPEC BACB30VT6K4) | | | | | | | |
| | | | | (OPT HST10AG6-4 (V73197)) | | | | | | | |
| | | | | (OPT HST10AG6-4 (V56878)) | | | | | | | |
| | | | | (OPT HST10AG6-4 (V0PTK6)) | | | | | | | |
| | | | | (USED ON ITEMS 1B, 1C, 1D) | | | | | | | |

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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- 85 | HST10AG6-4 | | . | BOLT | | | | | | | 1 |
| | | | | (V06725) | | | | | | | |
| | | | | (SPEC BACB30VT6K4) | | | | | | | |
| | | | | (OPT HST10AG6-4 (V73197)) | | | | | | | |
| | | | | (OPT HST10AG6-4 (V56878)) | | | | | | | |
| | | | | (OPT HST10AG6-4 (V0PTK6)) | | | | | | | |
| 90 | 3SLCC6 | | . | COLLAR | | | | | | | 12 |
| | | | | (V17446) | | | | | | | |
| | | | | (SPEC BACC30BK6) | | | | | | | |
| | | | | (OPT 3SLCC6 (V92215)) | | | | | | | |
| 95 | 3SLCC6 | | . | COLLAR | | | | | A | | 1 |
| | | | | (V17446) | | | | | | | |
| | | | | (SPEC BACC30BK6) | | | | | | | |
| | | | | (OPT 3SLCC6 (V92215)) | | | | | | | |
| | | | | (USED ON ITEMS 1A, 1E, 1F, 1G, 1H) | | | | | | | |
| | | | | (USED WITH ITEM 80) | | | | | | | |
| -95A | HST79CY6 | | . | COLLAR | | | | | | | 1 |
| | | | | (V73197) | | | | | | | |
| | | | | (SPEC BACC30BL6) | | | | | | | |
| | | | | (OPT HST79-6 (V92215)) | | | | | | | |
| | | | | (OPT HST79CY6 (V56878)) | | | | | | | |
| | | | | (OPT HST79CY6 (V5M902)) | | | | | | | |
| | | | | (USED ON ITEMS 1B, 1C, 1D) | | | | | | | |
| | | | | (USED WITH ITEM 80A) | | | | | | | |
| 100 | HST79CY6 | | . | COLLAR | | | | | | | 1 |
| | | | | (V73197) | | | | | | | |
| | | | | (SPEC BACC30BL6) | | | | | | | |
| | | | | (OPT HST79-6 (V92215)) | | | | | | | |
| | | | | (OPT HST79CY6 (V56878)) | | | | | | | |
| | | | | (OPT HST79CY6 (V5M902)) | | | | | | | |
| 105 | 141A6145-3 | | . | ANGLE-FWD, UPR | | | | | A | | 1 |
| | | | | (USED ON ITEMS 1A, 1B) | | | | | | | |
| -105A | 141A6145-11 | | . | ANGLE-FWD, UPR | | | | | A-D | | 1 |
| | | | | (USED ON ITEMS 1C, 1D) | | | | | | | |
| -105B | 141A6145-12 | | . | ANGLE-FWD, UPR | | | | | E-J | | 1 |
| -105C | 141A6145-11 | | . | ANGLE-FWD, UPR | | | | | D | | 1 |
| | | | | (OPT ITEM 105D) | | | | | | | |
| -105D | 141A6145-12 | | . | ANGLE-FWD, UPR | | | | | D | | 1 |
| | | | | (OPT ITEM 105C) | | | | | | | |
| 110 | 141A6145-7 | | . | ANGLE-FWD, LWR | | | | | A | | 1 |
| | | | | (USED ON ITEM 1A) | | | | | | | |

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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- -110A | 141A6145-9 | | . | | | | | | | | 1 |
| | | | | | | | | | | | |
| 115 | 141A6145-8 | | . | | | | | | | A | 1 |
| | | | | | | | | | | | |
| -115A | 141A6145-10 | | . | | | | | | | | 1 |
| | | | | | | | | | | | |
| 120 | HST10AG6-3 | | . | | | | | | | | 10 |
| | | | | | | | | | | | |
| 125 | LGPL2SPV6-4AC | | . | | | | | | | | 7 |
| | | | | | | | | | | | |
| 130 | HST11AG6-3 | | . | | | | | | | A-D | 2 |
| | | | | | | | | | | | |
| -130A | WC331K6-3 | | . | | | | | | | E-J | 2 |
| | | | | | | | | | | | |
| 135 | HST79CY6 | | . | | | | | | | | 12 |
| | | | | | | | | | | | |
| 140 | 3SLCC6 | | . | | | | | | | | 7 |
| | | | | | | | | | | | |
| 145 | BACR15FT6D | | . | | | | | | | | 100 |
| | | | | | | | | | | | |

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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- | | | | | | | | | | | |
| 150 | BACR15GF6D | | . | RIVET | | | | | | | 28 |
| | | | | (SIZE DETERMINED ON INST) | | | | | | | |
| 155 | 141A6120-10 | | . | BEAM ASSY-UPR | | | | | A-C | | 1 |
| -155A | 141A6120-18 | | . | BEAM ASSY-UPR | | | | | D-J | | 1 |
| 160 | LGPL2SPV6-7AC | | .. | BOLT | | | | | | | 2 |
| | | | | (V17446) | | | | | | | |
| | | | | (SPEC BACB30VN6K7) | | | | | | | |
| | | | | (OPT LGPL2SPV6-7AC (V92215)) | | | | | | | |
| | | | | (OPT 81669V5K6 (V56878)) | | | | | | | |
| | | | | (OPT LGPL2SPV6-7AC (V56878)) | | | | | | | |
| 165 | LGPL2SPV6-6AC | | .. | BOLT | | | | | | | 3 |
| | | | | (V17446) | | | | | | | |
| | | | | (SPEC BACB30VN6K6) | | | | | | | |
| | | | | (OPT LGPL2SPV6-6AC (V92215)) | | | | | | | |
| | | | | (OPT 81669V6K6 (V56878)) | | | | | | | |
| | | | | (OPT LGPL2SPV6-6AC (V56878)) | | | | | | | |
| 170 | LGPL2SPV6-5AC | | .. | BOLT | | | | | | | 1 |
| | | | | (V17446) | | | | | | | |
| | | | | (SPEC BACB30VN6K5) | | | | | | | |
| | | | | (OPT LGPL2SPV6-5AC (V92215)) | | | | | | | |
| | | | | (OPT 81669V6K5 (V56878)) | | | | | | | |
| | | | | (OPT LGPL2SPV6-5AC (V56878)) | | | | | | | |
| 175 | LGPL2SCV6-6AC | | .. | BOLT | | | | | A-C | | 1 |
| | | | | (V17446) | | | | | | | |
| | | | | (SPEC BACB30VM6K6) | | | | | | | |
| | | | | (OPT LGPL2SCV6-6AC (V92215)) | | | | | | | |
| | | | | (OPT 81668V6K6 (V56878)) | | | | | | | |
| -175A | BACB30XT6K6 | | .. | BOLT | | | | | D-J | | 1 |
| 180 | 3SLCC6 | | .. | COLLAR | | | | | | | 7 |
| | | | | (V17446) | | | | | | | |
| | | | | (SPEC BACC30BK6) | | | | | | | |
| | | | | (OPT 3SLCC6 (V92215)) | | | | | | | |
| 185 | 141A6104-3 | | .. | FITTING ASSY-STOP | | | | | A-C | | 1 |
| -185A | 141A6104-19 | | .. | FITTING ASSY-STOP | | | | | D-J | | 1 |
| 190 | 66-12688-11 | | ... | BUSHING | | | | | A-C | | 1 |
| -190A | 66-12688-14 | | ... | BUSHING | | | | | D-J | | 1 |
| 195 | 141A6104-4 | | ... | FITTING | | | | | A-C | | 1 |
| -195A | 141A6104-20 | | ... | FITTING | | | | | D-J | | 1 |
| 200 | 141A6121-13 | | .. | BEAM | | | | | A-C | | 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- | | | | | | | | | | | |
| -200A | 141A6121-18 | | | | | | | | | D-J | 1 |
| 205 | 141A6120-2 | | | | | | | | | | 1 |
| 210 | LGPL2SPV6-6AC | | | | | | | | | | 10 |
| | | | | | | | | | | | |
| 215 | LGPL2SPV6-5AC | | | | | | | | | | 6 |
| | | | | | | | | | | | |
| 220 | LGPL2SPV6-4AC | | | | | | | | | | 2 |
| | | | | | | | | | | | |
| 225 | 3SLCC6 | | | | | | | | | | 18 |
| | | | | | | | | | | | |
| 230 | 141A6103-11 | | | | | | | | | | 1 |
| 235 | 141A6103-3 | | | | | | | | | | 1 |
| 240 | 66-12688-11 | | | | | | | | | | 1 |
| 245 | 141A6103-12 | | | | | | | | | | 1 |
| | | | | | | | | | | | |
| 250 | 141A6103-4 | | | | | | | | | | 1 |
| | | | | | | | | | | | |
| 255 | 141A6121-2 | | | | | | | | | | 1 |
| 260 | 141A6120-3 | | | | | | | | | A | 1 |
| -260A | 141A6120-14 | | | | | | | | | | 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- | | | | | | | | | | | |
| 265 | LGPL2SPV6-6AC | | . . | BOLT | | | | | | | 10 |
| | | | | (V17446) | | | | | | | |
| | | | | (SPEC BACB30VN6K6) | | | | | | | |
| | | | | (OPT LGPL2SPV6-6AC (V92215)) | | | | | | | |
| | | | | (OPT 81669V6K6 (V56878)) | | | | | | | |
| | | | | (OPT LGPL2SPV6-6AC (V56878)) | | | | | | | |
| 270 | LGPL2SPV6-5AC | | . . | BOLT | | | | | | | 4 |
| | | | | (V17446) | | | | | | | |
| | | | | (SPEC BACB30VN6K5) | | | | | | | |
| | | | | (OPT LGPL2SPV6-5AC (V92215)) | | | | | | | |
| | | | | (OPT 81669V6K5 (V56878)) | | | | | | | |
| | | | | (OPT LGPL2SPV6-5AC (V56878)) | | | | | | | |
| 275 | LGPL2SPV6-4AC | | . . | BOLT | | | | | | | 4 |
| | | | | (V17446) | | | | | | | |
| | | | | (SPEC BACB30VN6K4) | | | | | | | |
| | | | | (OPT LGPL2SPV6-4AC (V92215)) | | | | | | | |
| | | | | (OPT 81669V6K4 (V56878)) | | | | | | | |
| | | | | (OPT LGPL2SPV6-4AC (V56878)) | | | | | | | |
| 280 | 3SLCC6 | | . . | COLLAR | | | | | | | 18 |
| | | | | (V17446) | | | | | | | |
| | | | | (SPEC BACC30BK6) | | | | | | | |
| | | | | (OPT 3SLCC6 (V92215)) | | | | | | | |
| 285 | 141A6103-13 | | . . | FITTING ASSY-STOP | | | | | A | | 1 |
| | | | | (USED ON ITEM 260) | | | | | | | |
| -285A | 141A6103-25 | | . . | FITTING ASSY-STOP | | | | | | | 1 |
| | | | | (USED ON ITEM 260A) | | | | | | | |
| 290 | 141A6103-3 | | . . | FITTING ASSY-STOP | | | | | | | 1 |
| 295 | 66-12688-11 | | . . . | BUSHING | | | | | | | 1 |
| 300 | 141A6103-14 | | . . . | FITTING | | | | | A | | 1 |
| | | | | (USED ON ITEM 285) | | | | | | | |
| -300A | 141A6103-26 | | . . . | FITTING | | | | | | | 1 |
| | | | | (USED ON ITEM 285A) | | | | | | | |
| 305 | 141A6103-4 | | . . . | FITTING | | | | | | | 1 |
| | | | | (USED ON ITEM 290) | | | | | | | |
| 310 | 141A6121-3 | | . . | BEAM | | | | | A | | 1 |
| | | | | (USED ON ITEM 260) | | | | | | | |
| -310A | 141A6121-14 | | . . | BEAM | | | | | | | 1 |
| | | | | (USED ON ITEM 260A) | | | | | | | |
| 315 | 141A6120-4 | | . . | BEAM ASSY-NO. 11 | | | | | A | | 1 |
| | | | | (USED ON ITEM 1A) | | | | | | | |

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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- | | | | | | | | | | | |
| -315A | 141A6120-16 | | | | | | | | . BEAM ASSY-NO. 11 (USED ON ITEMS 1B, 1C, 1D, 1E, 1F, 1G, 1H) | | 1 |
| 320 | BACB30NM3K4 | | | | | | | | . . BOLT | | 8 |
| 325 | BACW10BP3CD | | | | | | | | . . WASHER | | 8 |
| 330 | AF5141-3C2 | | | | | | | | . . RIVET (V53551) (SPEC BACR15DR3AC2) (OPT CCR264CS3-2IT (V11815)) (OPT RV541A3C2 (V98996)) (OPT ITEM 330A) | | 16 |
| -330A | BACR15BA3AD2C | | | | | | | | . . RIVET (OPT ITEM 330) | | 16 |
| 335 | BRF200C3D | | | | | | | | . . NUTPLATE (V52828) (SPEC BACN10JR3CFD) (OPT K51602-3BAC (V15653)) (OPT NS202476-02 (V80539)) (OPT 102F9201-3 (V72962)) (OPT T8092C1032CD (V11815)) | | 8 |
| 340 | BACB30NN3K2 | | | | | | | | . . BOLT (USED ON ITEM 315) | A | 3 |
| -340A | BACB30VF3K2 | | | | | | | | . . BOLT (USED ON ITEM 315A) | | 3 |
| 345 | H52732-3CD | | | | | | | | . . NUT (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554)) | | 3 |
| 350 | 141A6107-1 | | | | | | | | . . ANGLE-REINFORCING | | 1 |
| 355 | LGPL2SPV6-6AC | | | | | | | | . . BOLT (V17446) (SPEC BACB30VN6K6) (OPT LGPL2SPV6-6AC (V92215)) (OPT 81669V6K6 (V56878)) (OPT LGPL2SPV6-6AC (V56878)) | | 10 |
| 360 | LGPL2SPV6-5AC | | | | | | | | . . BOLT (V17446) (SPEC BACB30VN6K5) (OPT LGPL2SPV6-5AC (V92215)) (OPT 81669V6K5 (V56878)) (OPT LGPL2SPV6-5AC (V56878)) | | 6 |

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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- | | | | | | | | | | | |
| 365 | LGPL2SPV6-4AC | | . . | BOLT | | | | | | | 2 |
| | | | | (V17446) | | | | | | | |
| | | | | (SPEC BACB30VN6K4) | | | | | | | |
| | | | | (OPT LGPL2SPV6-4AC (V92215)) | | | | | | | |
| | | | | (OPT 81669V6K4 (V56878)) | | | | | | | |
| | | | | (OPT LGPL2SPV6-4AC (V56878)) | | | | | | | |
| 370 | 3SLCC6 | | . . | COLLAR | | | | | | | 18 |
| | | | | (V17446) | | | | | | | |
| | | | | (SPEC BACC30BK6) | | | | | | | |
| | | | | (OPT 3SLCC6 (V92215)) | | | | | | | |
| 375 | 141A6103-15 | | . . | FITTING ASSY-STOP | | | | | | | 1 |
| 380 | 141A6103-5 | | . . | FITTING ASSY-STOP | | | | | | | 1 |
| 385 | 66-12688-11 | | . . . | BUSHING | | | | | | | 1 |
| 390 | 141A6103-16 | | . . . | FITTING | | | | | | | 1 |
| | | | | (USED ON ITEM 375) | | | | | | | |
| 395 | 141A6103-6 | | . . . | FITTING | | | | | | | 1 |
| | | | | (USED ON ITEM 380) | | | | | | | |
| 400 | 141A6121-5 | | . . | BEAM | | | | | A | | 1 |
| | | | | (USED ON ITEM 315) | | | | | | | |
| -400A | 141A6121-16 | | . . | BEAM | | | | | | | 1 |
| | | | | (USED ON ITEM 315A) | | | | | | | |
| 405 | 141A6120-5 | | . BEAM ASSY-NO. 12 | | | | | | A | | 1 |
| | | | | (USED ON ITEM 1A) | | | | | | | |
| -405A | 141A6120-17 | | . BEAM ASSY-NO. 12 | | | | | | | | 1 |
| | | | | (USED ON ITEMS 1B, 1C, 1D, 1E, 1F, 1G, 1H) | | | | | | | |
| 410 | BACB30NM3K4 | | . . | BOLT | | | | | | | 8 |
| 415 | BACW10BP3CD | | . . | WASHER | | | | | | | 8 |
| 420 | AF5141-3C2 | | . . | RIVET | | | | | | | 16 |
| | | | | (V53551) | | | | | | | |
| | | | | (SPEC BACR15DR3AC2) | | | | | | | |
| | | | | (OPT CCR264CS3-2IT (V11815)) | | | | | | | |
| | | | | (OPT RV541A3C2 (V98996)) | | | | | | | |
| | | | | (OPT ITEM 420A) | | | | | | | |
| -420A | BACR15BA3AD2C | | . . | RIVET | | | | | | | 16 |
| | | | | (OPT ITEM 420) | | | | | | | |

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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- 425 | BRF200C3D | | . | . | | | | | | | 8 |
| | | | | | | | | | | | |
| 430 | BACB30NN3K2 | | . | . | | | | | | A | 3 |
| | | | | | | | | | | | |
| -430A | BACB30VF3K2 | | . | . | | | | | | | 3 |
| | | | | | | | | | | | |
| 435 | H52732-3CD | | . | . | | | | | | | 3 |
| | | | | | | | | | | | |
| 440 | 141A6107-2 | | . | . | | | | | | | 1 |
| 445 | LGPL2SPV6-6AC | | . | . | | | | | | | 10 |
| | | | | | | | | | | | |
| 450 | LGPL2SPV6-5AC | | . | . | | | | | | | 4 |
| | | | | | | | | | | | |
| 455 | LGPL2SPV6-4AC | | . | . | | | | | | | 3 |
| | | | | | | | | | | | |
| 460 | LGPL2SPV6-7AC | | . | . | | | | | | | 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- | | | | | | | | | | | |
| 535 | 141A6103-20 | | | | | | | | . . . FITTING | | 1 |
| 540 | 141A6121-7 | | | | | | | | . . BEAM | | 1 |
| 545 | 141A6120-15 | | | | | | | | . BEAM ASSY-NO. 14 | | 1 |
| 550 | LGPL2SPV6-6AC | | | | | | | | . . BOLT (V17446) (SPEC BACB30VN6K6) (OPT LGPL2SPV6-6AC (V92215)) (OPT 81669V6K6 (V56878)) (OPT LGPL2SPV6-6AC (V56878)) | | 10 |
| 555 | LGPL2SPV6-5AC | | | | | | | | . . BOLT (V17446) (SPEC BACB30VN6K5) (OPT LGPL2SPV6-5AC (V92215)) (OPT 81669V6K5 (V56878)) (OPT LGPL2SPV6-5AC (V56878)) | | 4 |
| 560 | LGPL2SPV6-4AC | | | | | | | | . . BOLT (V17446) (SPEC BACB30VN6K4) (OPT LGPL2SPV6-4AC (V92215)) (OPT 81669V6K4 (V56878)) (OPT LGPL2SPV6-4AC (V56878)) | | 4 |
| 565 | 3SLCC6 | | | | | | | | . . COLLAR (V17446) (SPEC BACC30BK6) (OPT 3SLCC6 (V92215)) | | 18 |
| 570 | 141A6103-7 | | | | | | | | . . FITTING ASSY-STOP | | 1 |
| 575 | 141A6103-27 | | | | | | | | . . FITTING ASSY-STOP | | 1 |
| 580 | 66-12688-11 | | | | | | | | . . . BUSHING | | 1 |
| 585 | 141A6103-8 | | | | | | | | . . . FITTING (USED ON ITEM 570) | | 1 |
| 590 | 141A6103-28 | | | | | | | | . . . FITTING (USED ON ITEM 575) | | 1 |
| 595 | 141A6121-15 | | | | | | | | . . BEAM | | 1 |
| 600 | 141A6120-8 | | | | | | | | . BEAM ASSY-NO. 15 | | 1 |
| 605 | LGPL2SPV6-6AC | | | | | | | | . . BOLT (V17446) (SPEC BACB30VN6K6) (OPT LGPL2SPV6-6AC (V92215)) (OPT 81669V6K6 (V56878)) (OPT LGPL2SPV6-6AC (V56878)) | | 10 |

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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- 610 | LGPL2SPV6-5AC | | . . | BOLT (V17446) (SPEC BACB30VN6K5) (OPT LGPL2SPV6-5AC (V92215)) (OPT 81669V6K5 (V56878)) (OPT LGPL2SPV6-5AC (V56878)) | | | | | | | 6 |
| 615 | LGPL2SPV6-4AC | | . . | BOLT (V17446) (SPEC BACB30VN6K4) (OPT LGPL2SPV6-4AC (V92215)) (OPT 81669V6K4 (V56878)) (OPT LGPL2SPV6-4AC (V56878)) | | | | | | | 2 |
| 620 | 3SLCC6 | | . . | COLLAR (V17446) (SPEC BACC30BK6) (OPT 3SLCC6 (V92215)) | | | | | | | 18 |
| 625 | 141A6103-9 | | . . | FITTING ASSY-STOP | | | | | | | 1 |
| 630 | 141A6103-23 | | . . | FITTING ASSY-STOP | | | | | | | 1 |
| 635 | 66-12688-11 | | . . . | BUSHING | | | | | | | 1 |
| 640 | 141A6103-10 | | . . . | FITTING (USED ON ITEM 625) | | | | | | | 1 |
| 645 | 141A6103-24 | | . . . | FITTING (USED ON ITEM 630) | | | | | | | 1 |
| 650 | 141A6121-9 | | . . | BEAM | | | | | | | 1 |
| 655 | 141A6120-9 | | . BEAM ASSY-LWR (USED ON ITEM 1A) | | | | | | A | | 1 |
| -655A | 141A6120-13 | | . BEAM ASSY-LWR (USED ON ITEMS 1B, 1C, 1D, 1E, 1F, 1G, 1H) | | | | | | | | 1 |
| 660 | LGPL2SPV6-3AC | | . . | BOLT (V17446) (SPEC BACB30VN6K3) (OPT LGPL2SPV6-3AC (V92215)) (OPT 81669V6K3 (V56878)) (OPT LGPL2SPV6-3AC (V56878)) (USED ON ITEM 655) | | | | | A | | 14 |

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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- -660A | LGPL2SPV6-4AC | | . . | | | | | | | | | 14 |
| | | | | | | | | | | | | |
| 665 | 3SLCC6 | | . . | | | | | | | | | 14 |
| | | | | | | | | | | | | |
| 670 | 141A6104-5 | | . . | | | | | | | A | | 1 |
| | | | | | | | | | | | | |
| -670A | 141A6104-9 | | . . | | | | | | | | | 1 |
| | | | | | | | | | | | | |
| 675 | 141A6104-7 | | . . | | | | | | | | | 1 |
| | | | | | | | | | | | | |
| 680 | 66-12688-11 | | . . . | | | | | | | | | 1 |
| | | | | | | | | | | | | |
| 685 | 141A6104-6 | | . . . | | | | | | | A | | 1 |
| | | | | | | | | | | | | |
| -685A | 141A6104-10 | | . . . | | | | | | | | | 1 |
| | | | | | | | | | | | | |
| 690 | 141A6104-8 | | . . . | | | | | | | | | 1 |
| | | | | | | | | | | | | |
| 695 | 141A6121-10 | | . . | | | | | | | A | | 1 |
| | | | | | | | | | | | | |
| -695A | 141A6121-12 | | . . | | | | | | | | | 1 |
| | | | | | | | | | | | | |
| 697 | 141A6118-1 | | . BRACKET-SWITCH DEPRESSOR | | | | | | | G, H | | 1 |
| | | | (USED ON ITEM 1G) | | | | | | | | | |
| -697A | 141A6118-2 | | . BRACKET-SWITCH DEPRESSOR | | | | | | | J | | 1 |
| | | | (USED ON ITEM 1H) | | | | | | | | | |
| 700 | 141A6110-1 | | . FRAME-FWD | | | | | | | | | 1 |
| | | | | | | | | | | | | |
| 705 | 141A6110-2 | | . FRAME-AFT | | | | | | | A-H | | 1 |
| | | | | | | | | | | | | |
| -705A | 141A6110-3 | | . FRAME-AFT | | | | | | | J | | 1 |
| | | | | | | | | | | | | |

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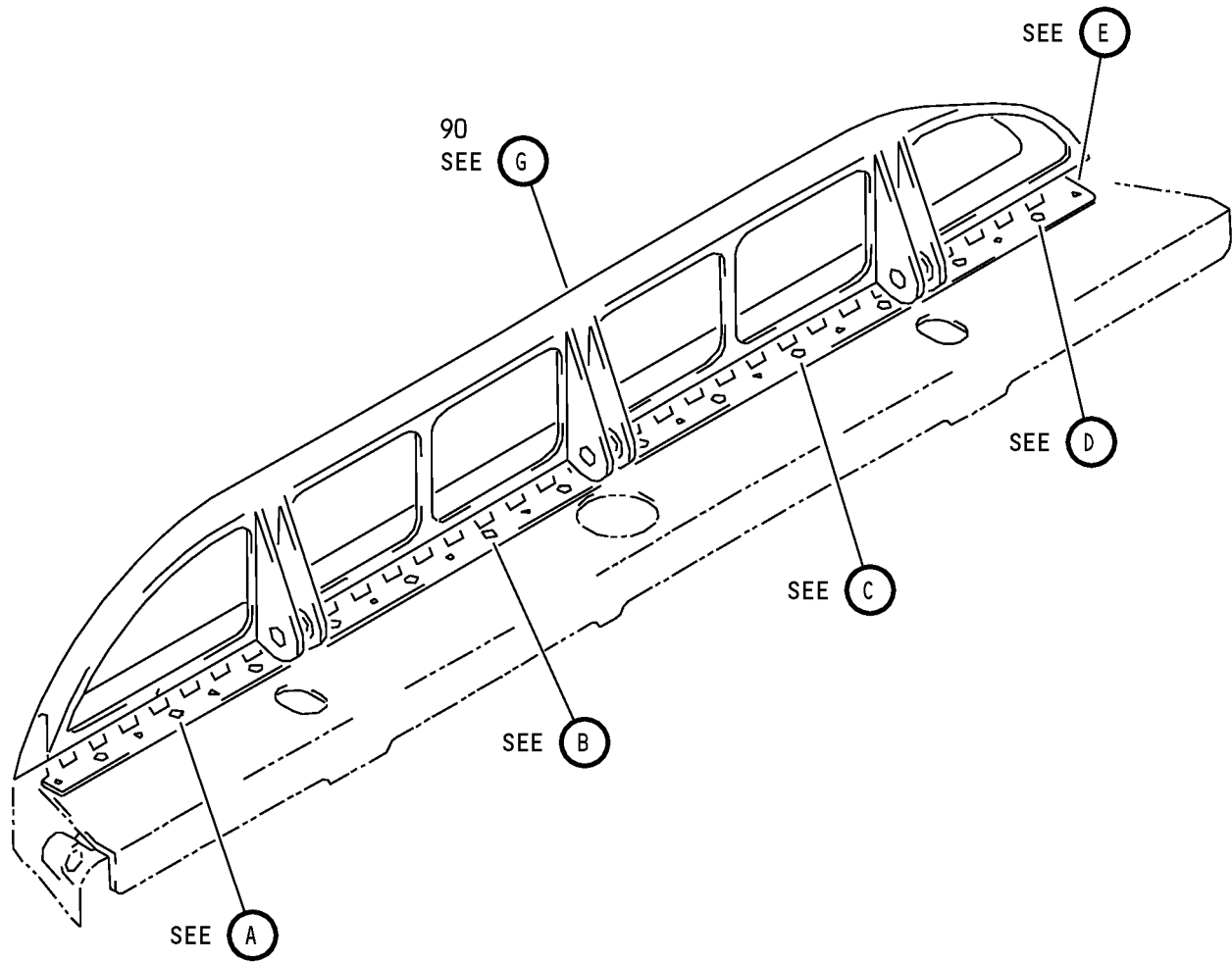
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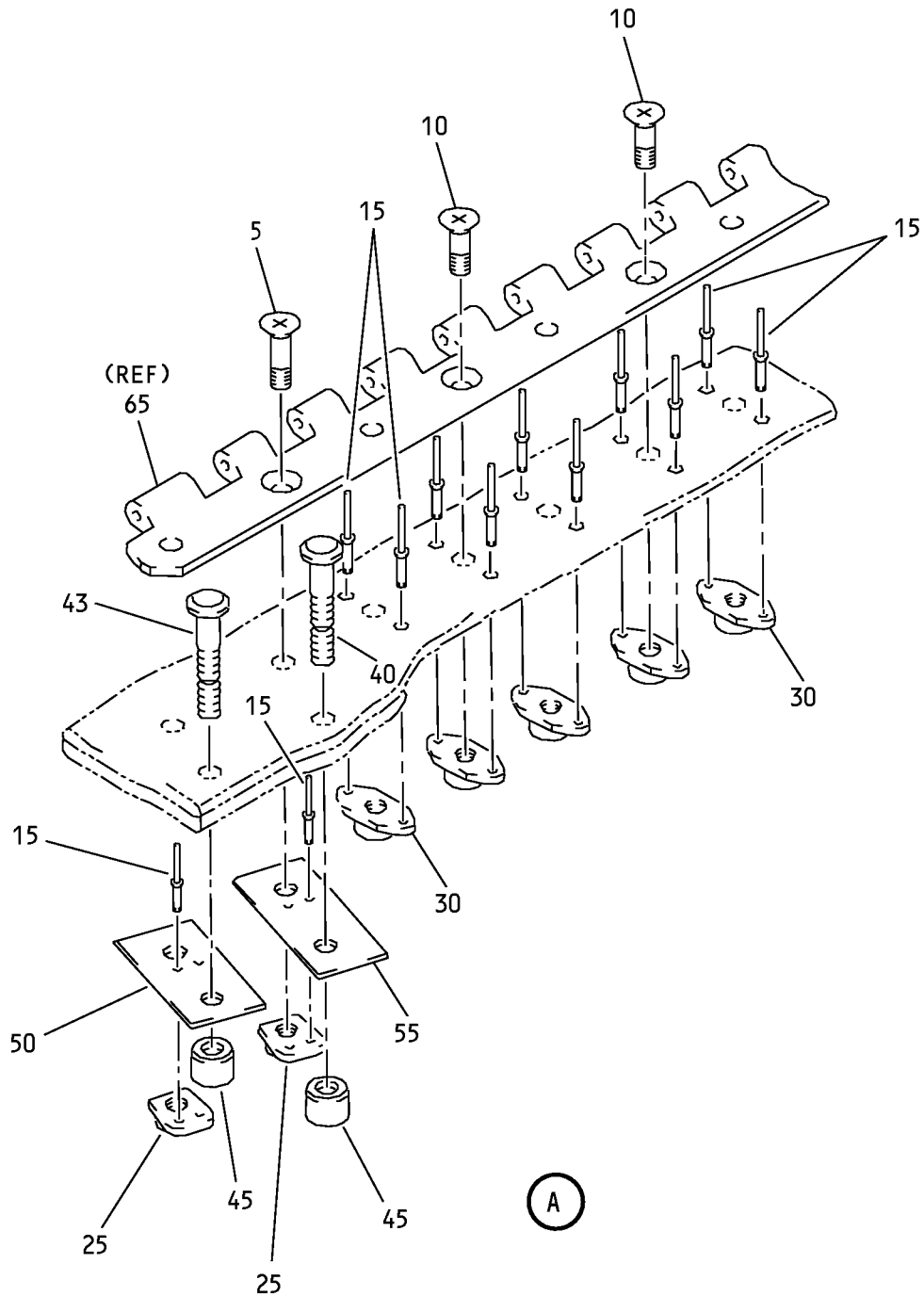
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Upper Gate Installation
IPL Figure 3 (Sheet 1 of 7)

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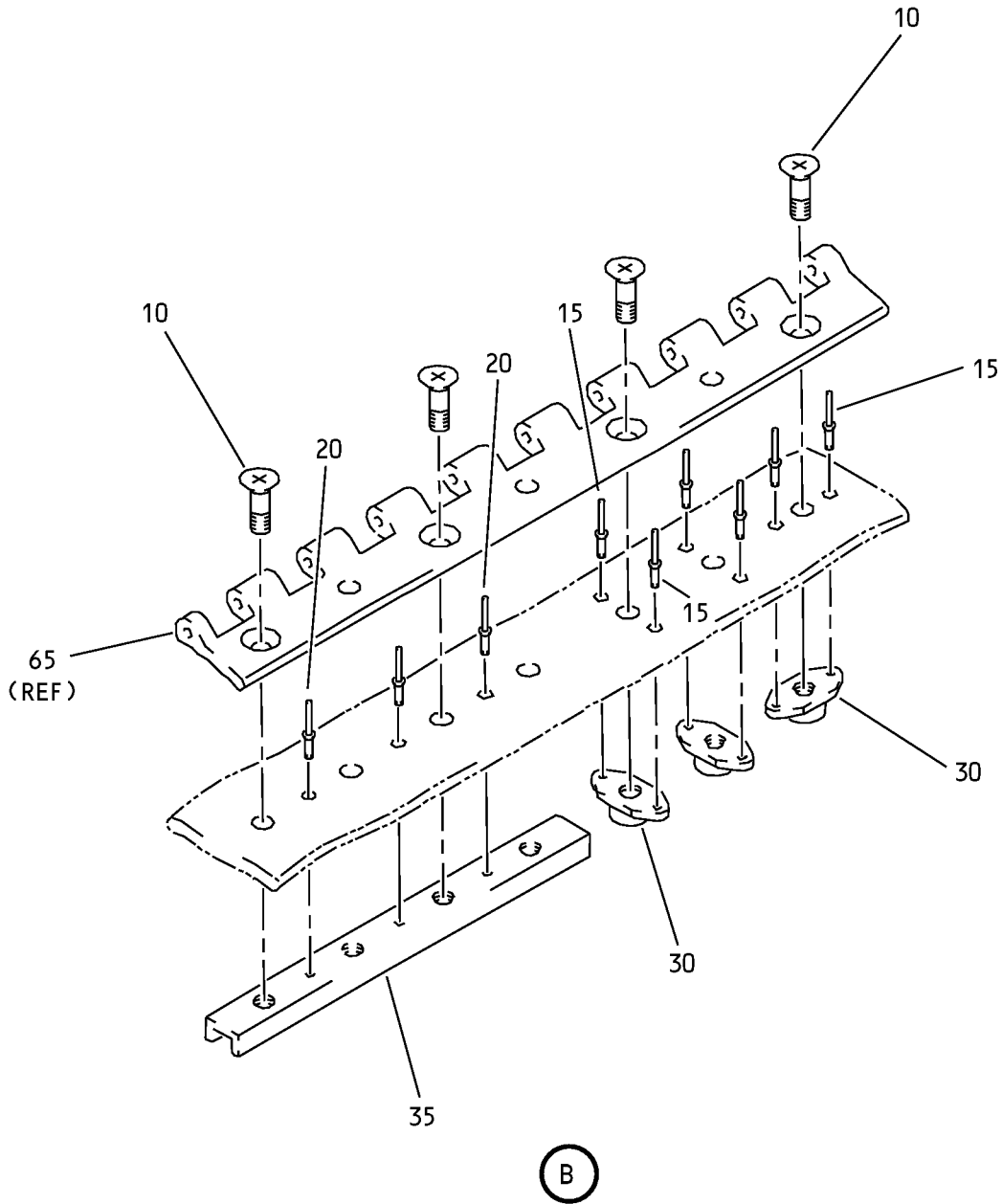


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Upper Gate Installation
IPL Figure 3 (Sheet 2 of 7)

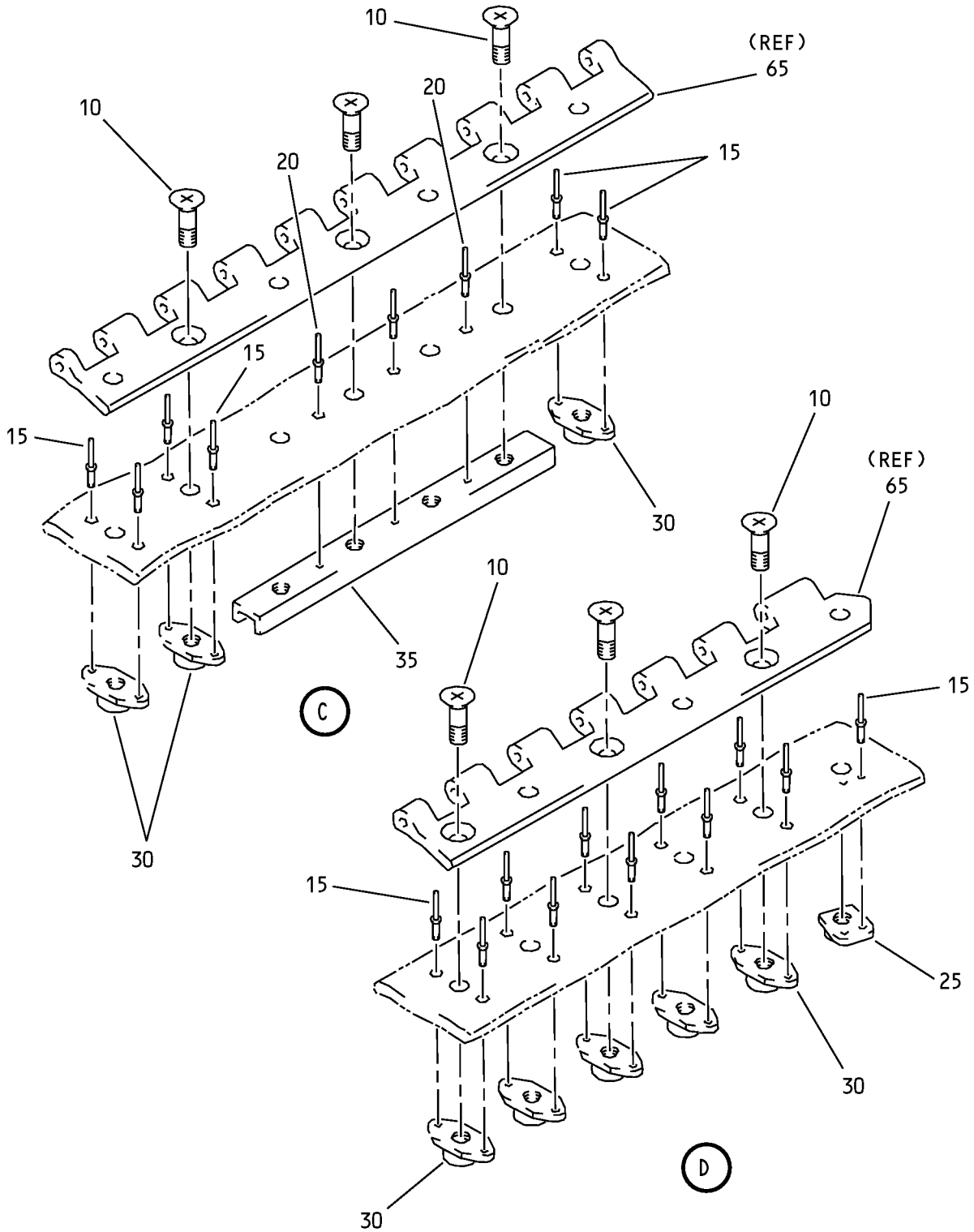
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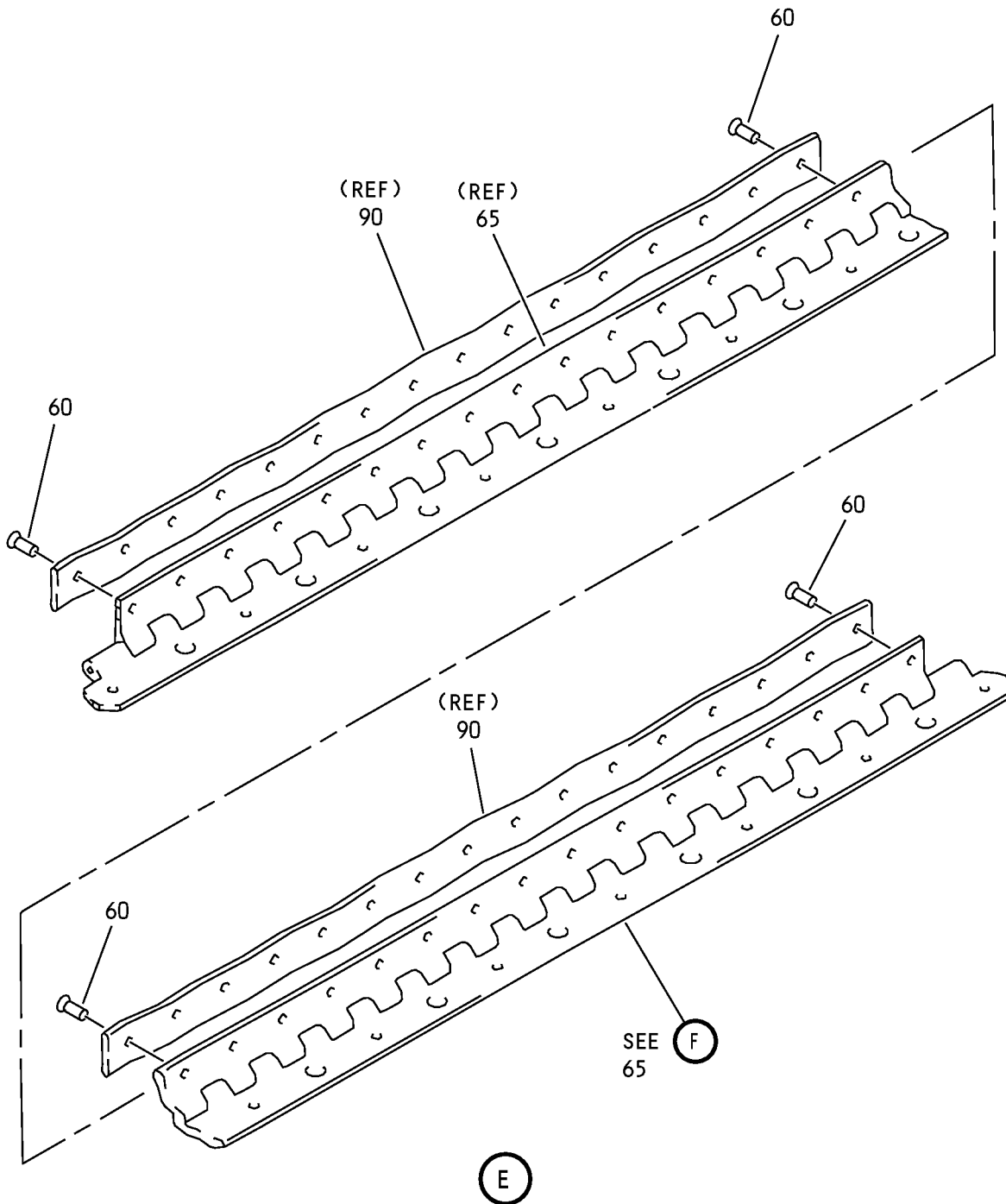
Upper Gate Installation
IPL Figure 3 (Sheet 3 of 7)

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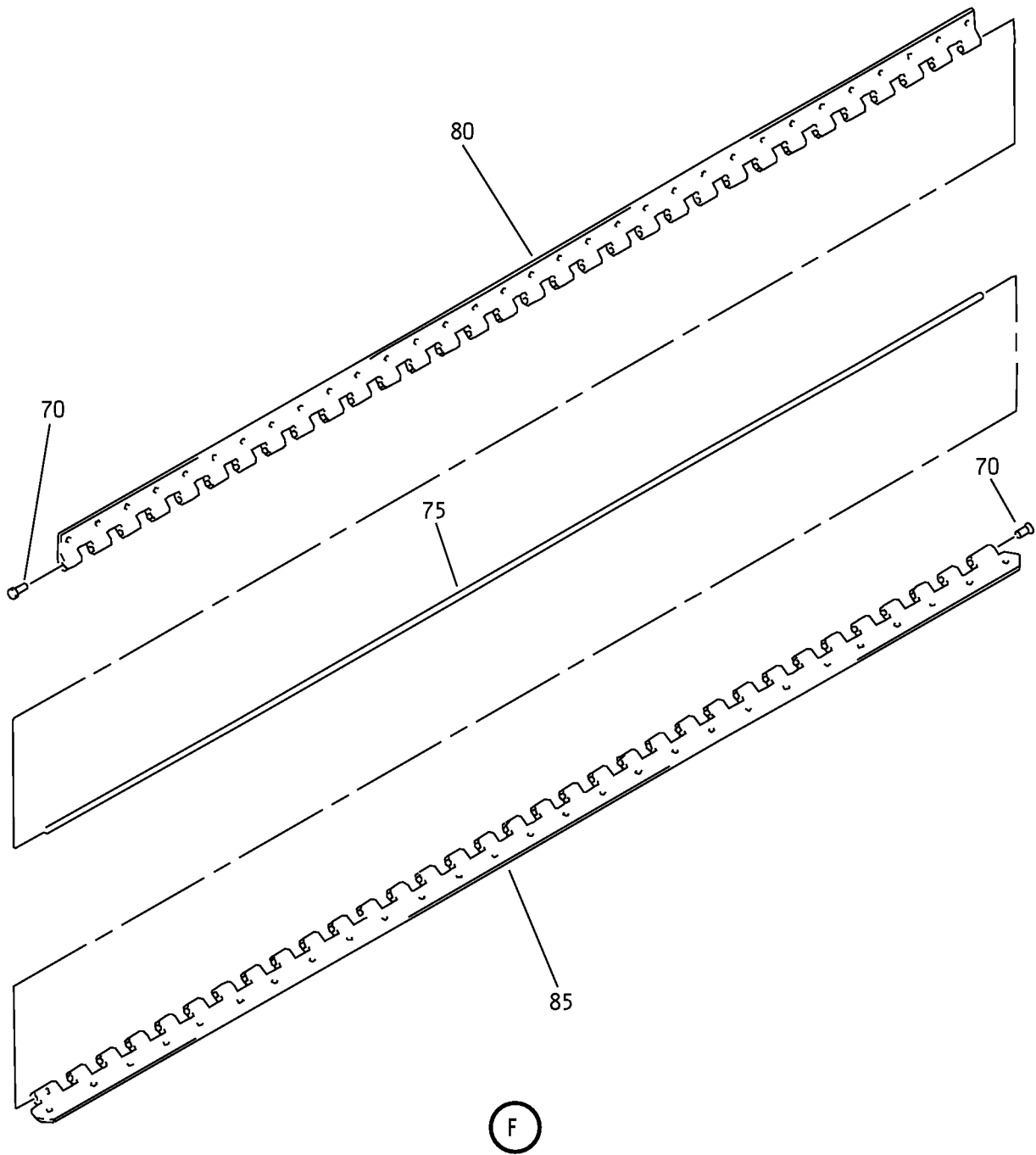
Upper Gate Installation
IPL Figure 3 (Sheet 4 of 7)

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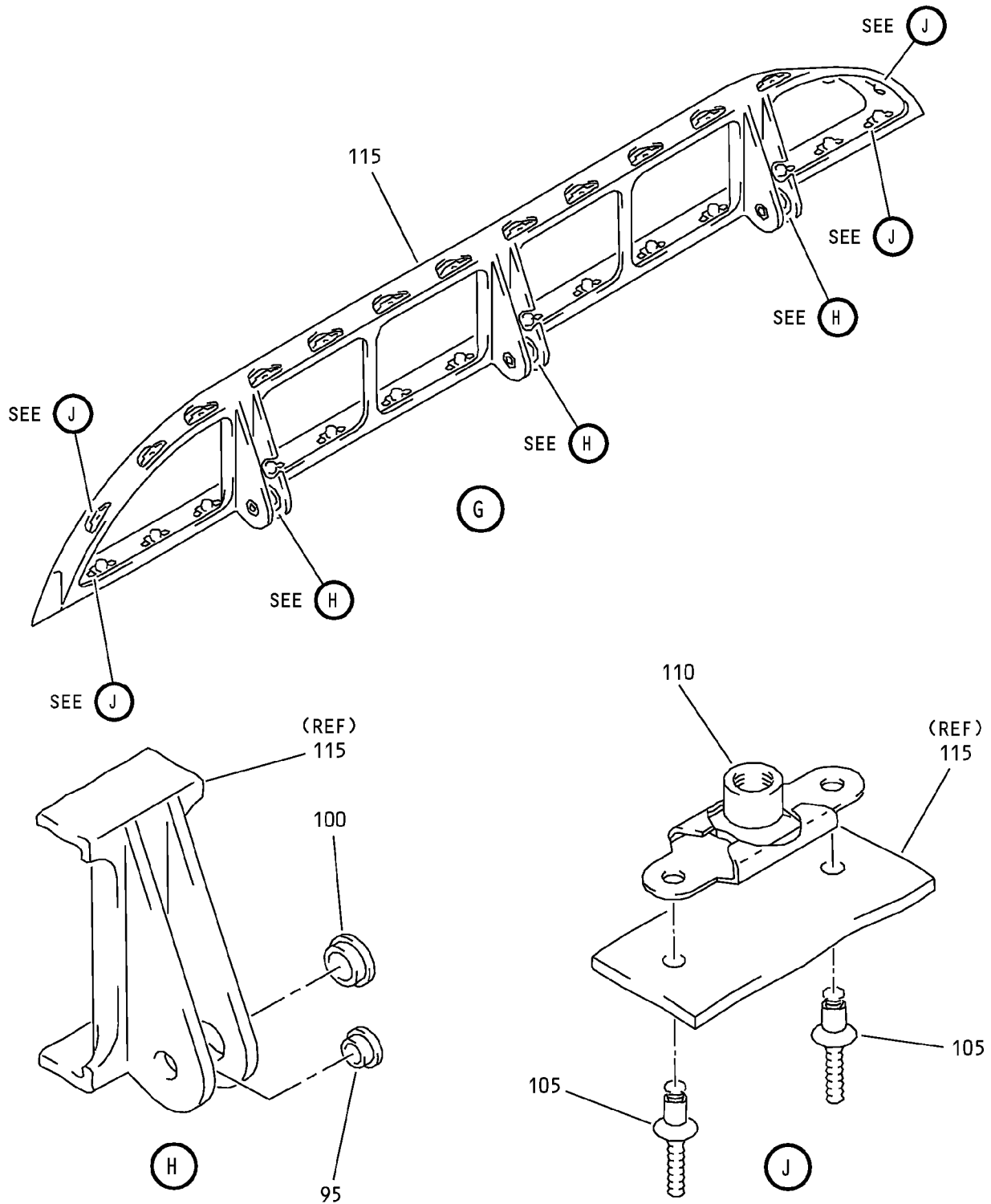
Upper Gate Installation
IPL Figure 3 (Sheet 5 of 7)

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Upper Gate Installation
IPL Figure 3 (Sheet 6 of 7)

COMPONENT MAINTENANCE MANUAL



Upper Gate Installation
IPL Figure 3 (Sheet 7 of 7)



COMPONENT MAINTENANCE MANUAL

| FIG/ ITEM | PART NUMBER | AIRLINE PART NUMBER | NOMENCLATURE | | | | | | | USAGE CODE | UNITS PER ASSY |
|--------------|----------------|---------------------------|--------------|---|---|---|---|---|---|---------------|----------------------|
| | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | | |
| 3- | | | | | | | | | | | |
| -1A | 141A6170-1 | | | | | | | | | A | RF |
| -1B | 141A6170-2 | | | | | | | | | A | RF |
| -1C | 141A6170-2 | | | | | | | | | B, C | RF |
| -1D | 141A6170-3 | | | | | | | | | D-J | RF |
| 5 | BACB30NN3K7 | | | | | | | | | A-C | 1 |
| -5A | BACB30NN3K8 | | | | | | | | | D-J | 1 |
| 10 | BACB30NN3K3 | | | | | | | | | | 12 |
| 15 | AF5141-3C3 | | | | | | | | | | 38 |
| | | | | | | | | | | | |
| 20 | AF5141-3C4 | | | | | | | | | | 6 |
| | | | | | | | | | | | |
| 25 | 102F9209M3 | | | | | | | | | | 3 |
| | | | | | | | | | | | |
| 30 | BRF200C3D | | | | | | | | | | 16 |
| | | | | | | | | | | | |
| 35 | MS21063L3-10-4 | | | | | | | | | | 2 |
| 40 | LGPL2SPV6-7AC | | | | | | | | | | 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 | | |
| 3- | | | | | | | | | | | |
| 43 | LGPL2SPV6-7AC | | . | BOLT | | | | | | A-C | 1 |
| | | | | (V17446) | | | | | | | |
| | | | | (SPEC BACB30VN6K7) | | | | | | | |
| | | | | (OPT LGPL2SPV6-7AC (V92215)) | | | | | | | |
| | | | | (OPT 81669V5K6 (V56878)) | | | | | | | |
| | | | | (OPT LGPL2SPV6-7AC (V56878)) | | | | | | | |
| -43A | LGPL2SPV6-9AC | | . | BOLT | | | | | | D-J | 1 |
| | | | | (V17446) | | | | | | | |
| | | | | (SPEC BACB30VN6K9) | | | | | | | |
| | | | | (OPT LGPL2SPV6-8AC (V92215)) | | | | | | | |
| | | | | (OPT 81669V6K8 (V56878)) | | | | | | | |
| | | | | (OPT LGPL2SPV6-9AC (V56878)) | | | | | | | |
| 45 | 3SLCC6 | | . | COLLAR | | | | | | | 2 |
| | | | | (V17446) | | | | | | | |
| | | | | (SPEC BACC30BK6) | | | | | | | |
| | | | | (OPT 3SLCC6 (V92215)) | | | | | | | |
| 50 | 141A6187-1 | | . | FILLER | | | | | | | 1 |
| 55 | 141A6187-2 | | . | FILLER | | | | | | | 1 |
| 60 | BACR15GF5D | | . | RIVET | | | | | | | 32 |
| | | | | (SIZE DETERMINED ON INST) | | | | | | | |
| 65 | 141A6183-2 | | . | HINGE ASSY | | | | | | | 1 |
| 70 | NAS1352N06LB4P | | . | SCREW | | | | | | | 2 |
| 75 | MS20253P2-3240 | | . | PIN-HINGE | | | | | | | 1 |
| 80 | 141A6184-1 | | . | HINGE HALF | | | | | | | 1 |
| 85 | 141A6184-3 | | . | HINGE HALF | | | | | | | 1 |
| 90 | 141A6171-1 | | . | GATE ASSY | | | | | A | | 1 |
| | | | | (USED ON ITEM 1A) | | | | | | | |
| -90A | 141A6171-3 | | | DELETED | | | | | | | |
| -90B | 141A6171-5 | | . | GATE ASSY | | | | | | | 1 |
| | | | | (USED ON ITEMS 1B, 1C, 1D) | | | | | | | |
| 95 | BACB28AP04P014 | | . | BUSHING | | | | | | | 3 |
| 100 | BACB28AT06B014C | | . | BUSHING | | | | | | | 3 |
| 105 | AF5141-3C2 | | . | RIVET | | | | | | | 56 |
| | | | | (V53551) | | | | | | | |
| | | | | (SPEC BACR15DR3AC2) | | | | | | | |
| | | | | (OPT CCR264CS3-2IT (V11815)) | | | | | | | |
| | | | | (OPT RV541A3C2 (V98996)) | | | | | | | |

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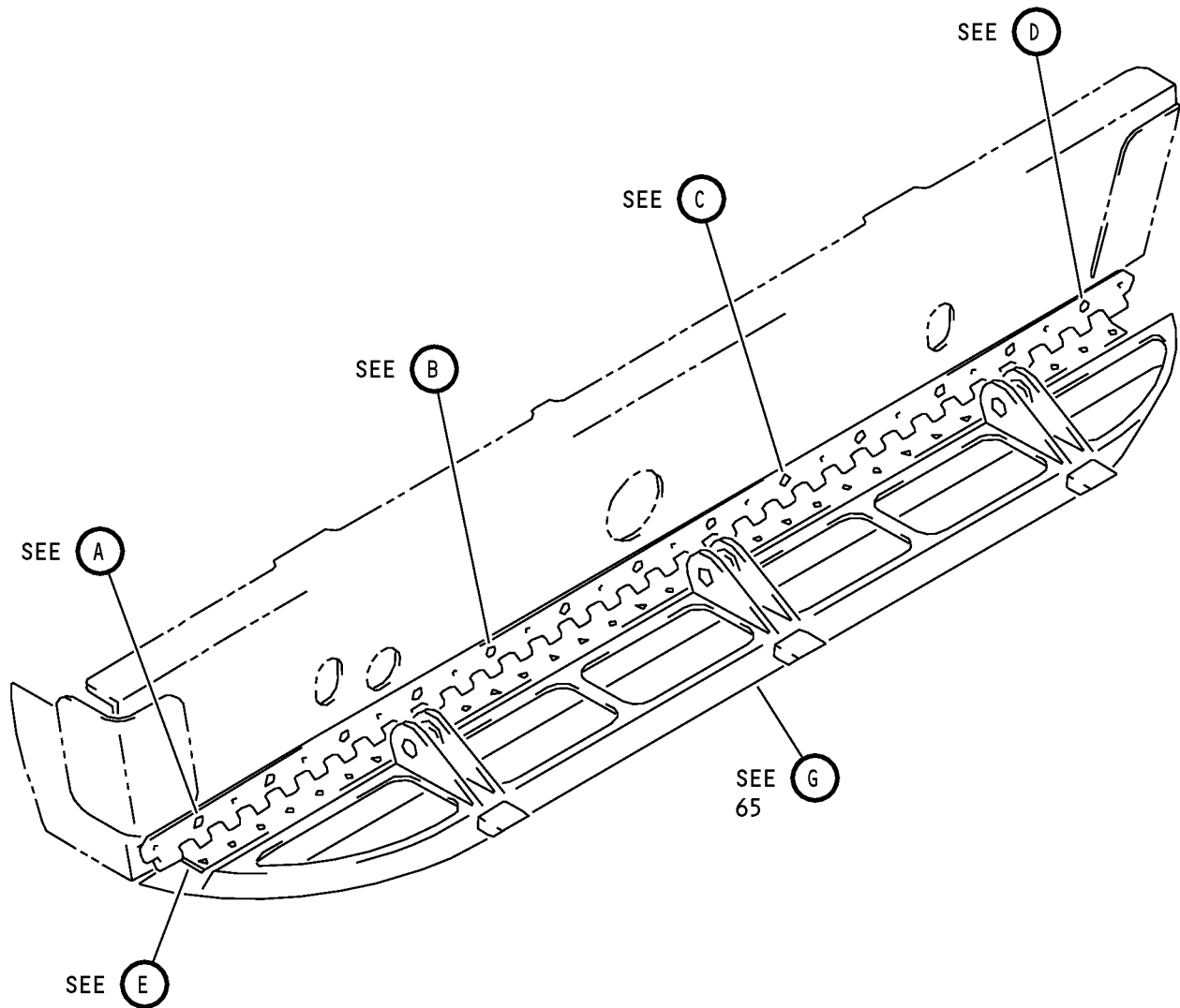


COMPONENT MAINTENANCE MANUAL

| FIG/ ITEM | PART NUMBER | AIRLINE PART NUMBER | NOMENCLATURE | | | | | | | USAGE CODE | UNITS PER ASSY | |
|--------------|-------------|---------------------------|--------------|---|--|---|---|---|---|---------------|----------------------|----|
| | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | | | |
| 3- 110 | BRF220C3-3D | | . | . | NUTPLATE (V52828) (SPEC BACN10JS3A3CD) (OPT F51900-3-3BAC (V15653)) (OPT NS202562-3-3 (V80539)) (OPT 102F9206-3-3 (V72962)) | | | | | | | 28 |
| 115 | 141A6171-2 | | . | . | GATE (USED ON ITEM 90) | | | | | A | | 1 |
| -115A | 141A6171-4 | | . | . | GATE (USED ON ITEM 90B) | | | | | | | 1 |

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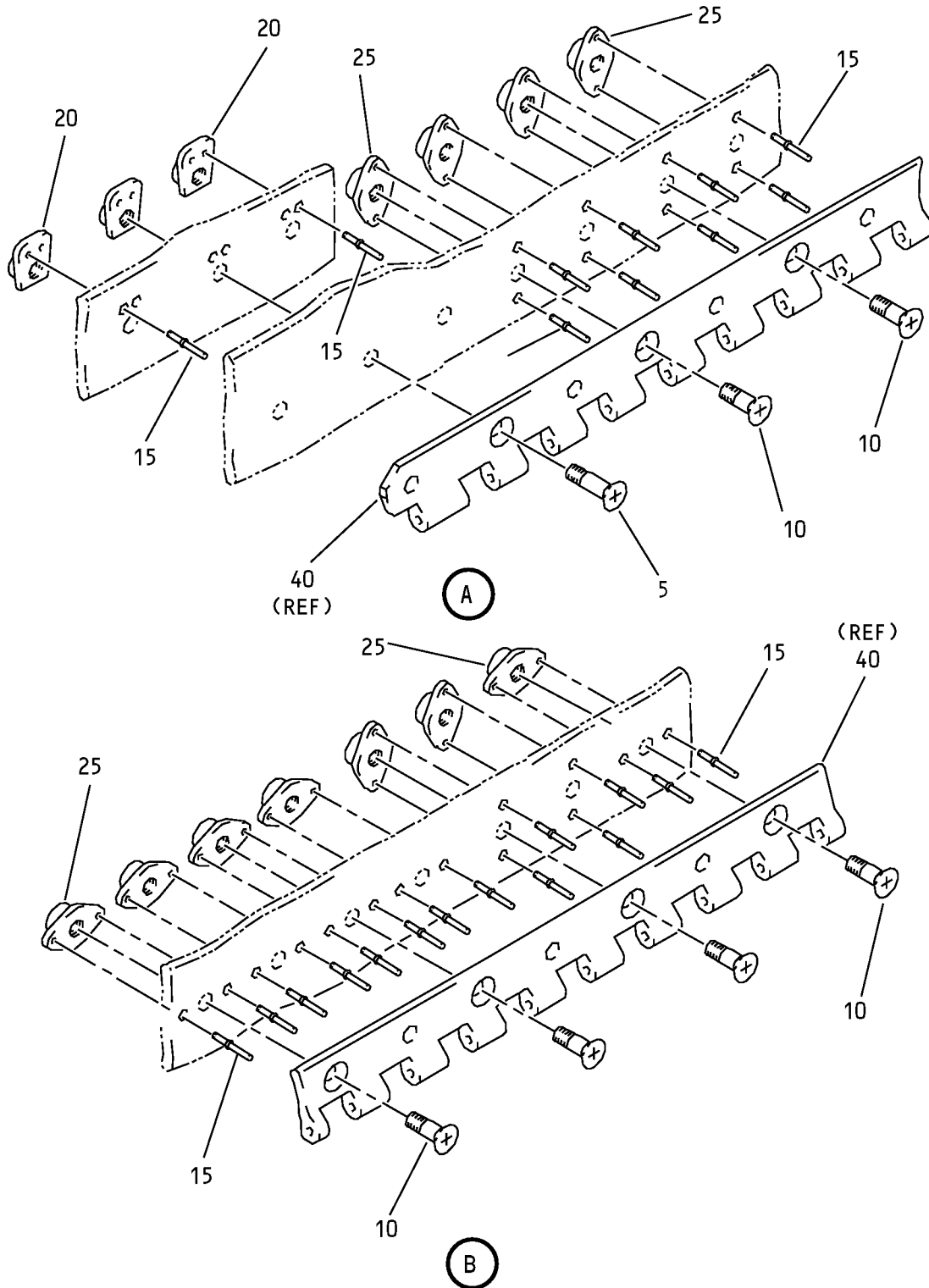
COMPONENT MAINTENANCE MANUAL



Lower Gate Installation
IPL Figure 4 (Sheet 1 of 7)

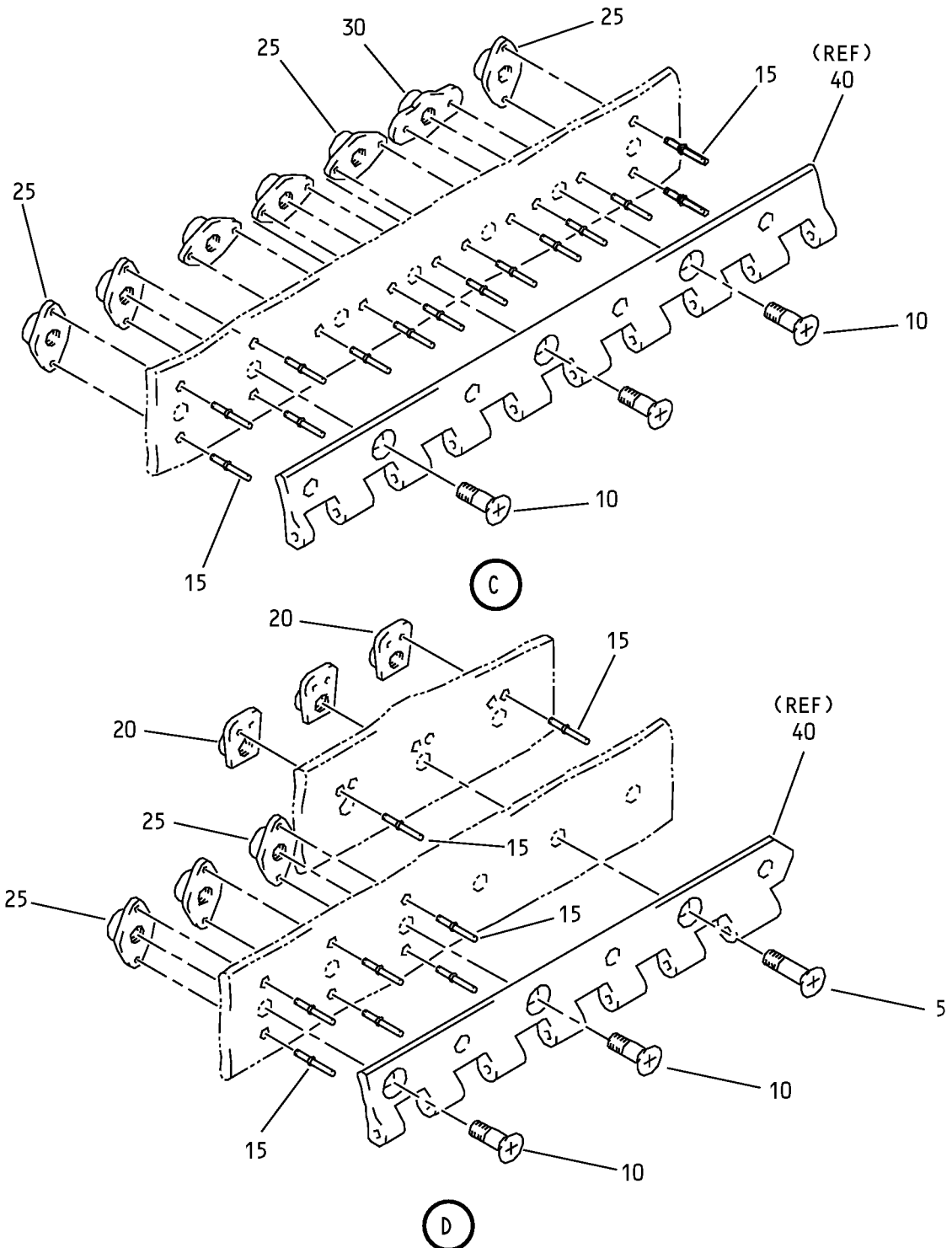
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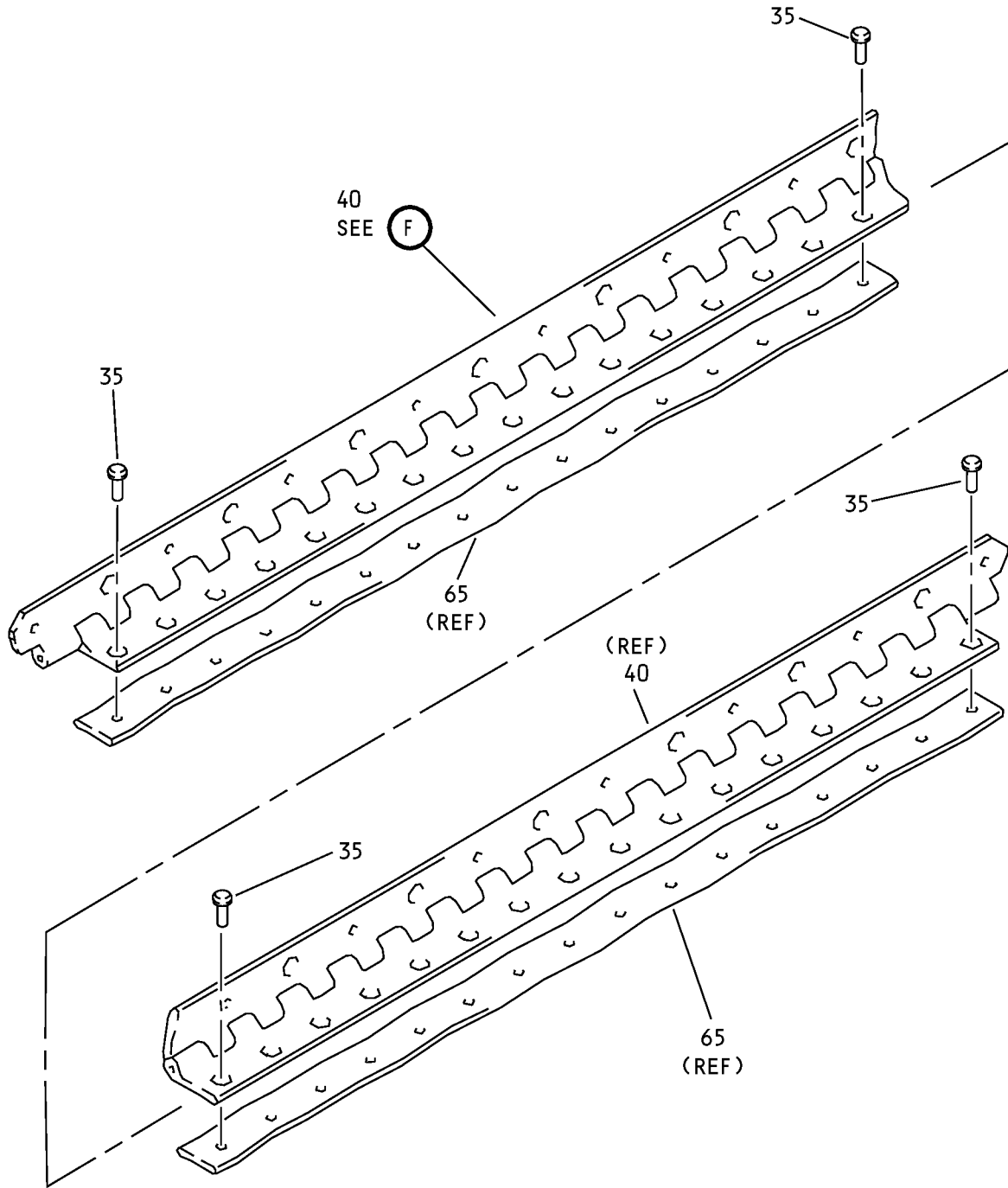
Lower Gate Installation
IPL Figure 4 (Sheet 2 of 7)

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Lower Gate Installation
IPL Figure 4 (Sheet 3 of 7)

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(E)

Lower Gate Installation
IPL Figure 4 (Sheet 4 of 7)

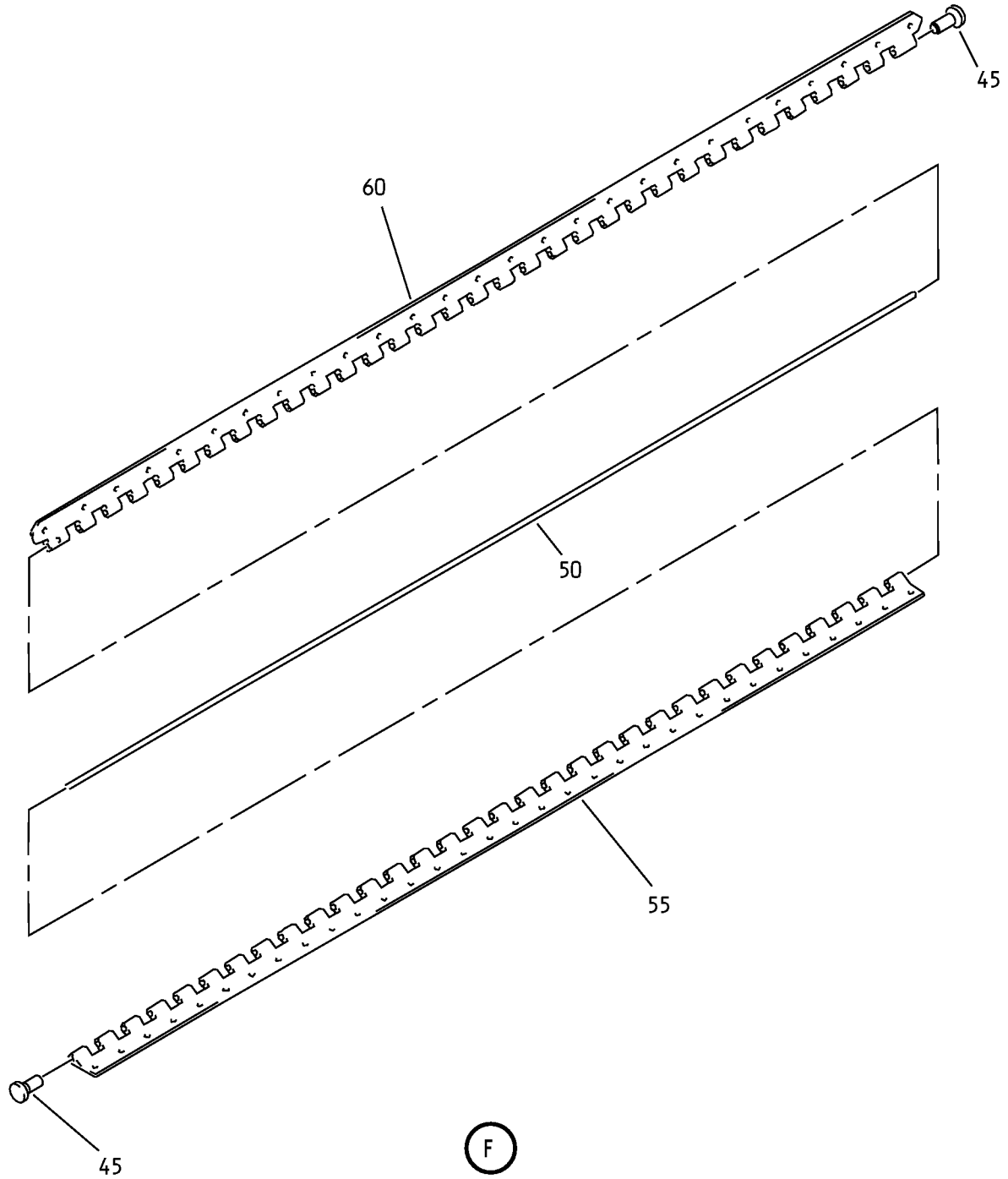
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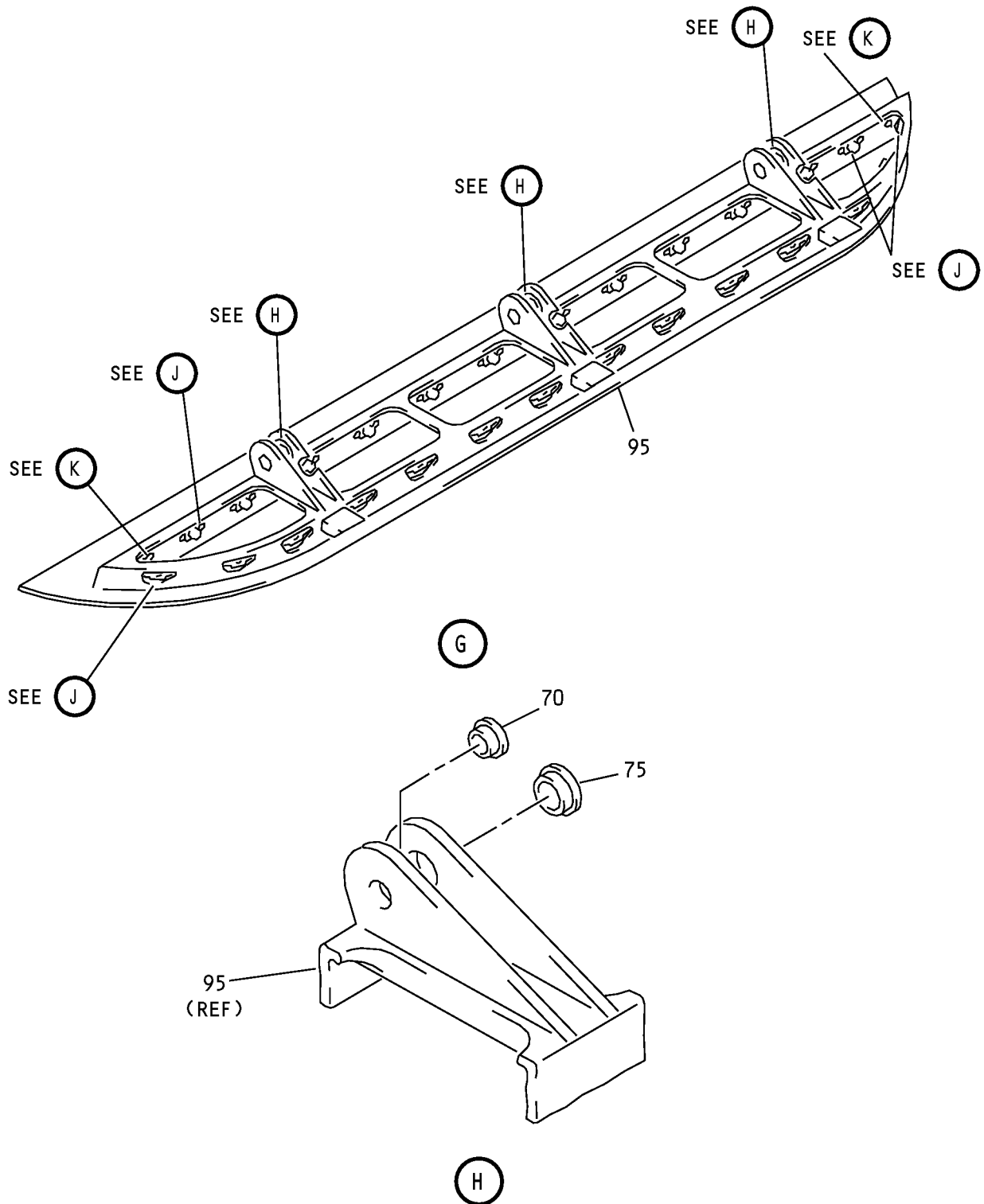
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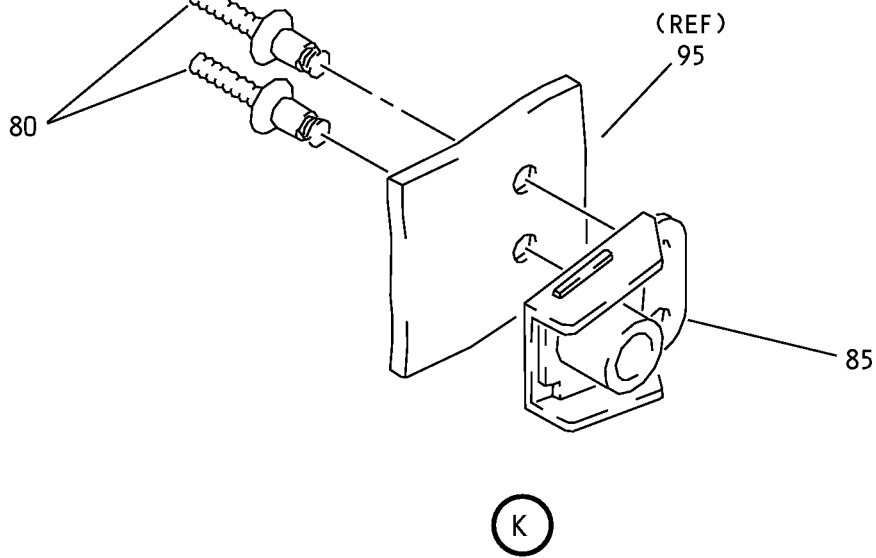
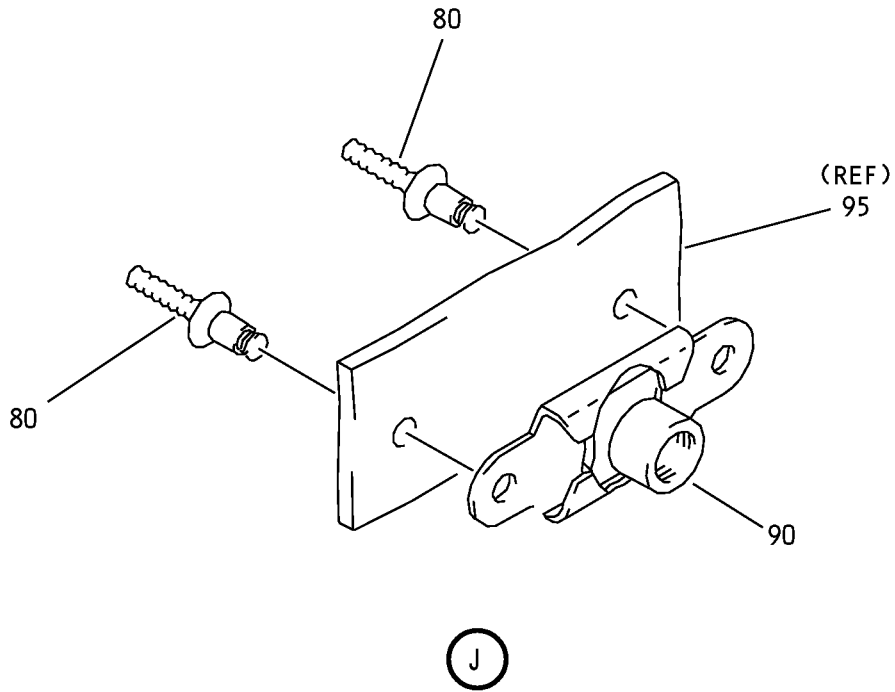
Lower Gate Installation
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Lower Gate Installation
IPL Figure 4 (Sheet 6 of 7)

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Lower Gate Installation
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| FIG/ ITEM | PART NUMBER | AIRLINE PART NUMBER | NOMENCLATURE | | | | | | | USAGE CODE | UNITS PER ASSY |
|--------------|----------------|---------------------------|--------------|---|---|---|---|---|---|---------------|----------------------|
| | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | | |
| 4- | | | | | | | | | | | |
| -1A | 141A6180-1 | | | | | | | | | A | RF |
| -1B | 141A6180-2 | | | | | | | | | A | RF |
| -1C | 141A6180-2 | | | | | | | | | B-J | RF |
| 5 | BACB30NN3K6 | | | | | | | | | | 2 |
| 10 | BACB30NN3K4 | | | | | | | | | | 11 |
| 15 | AF5141-3C3 | | | | | | | | | | 54 |
| | | | | | | | | | | | |
| 20 | 102F9209M3 | | | | | | | | | | 6 |
| | | | | | | | | | | | |
| 25 | F51643-3BAC | | | | | | | | | | 20 |
| | | | | | | | | | | | |
| 30 | BRF200C3D | | | | | | | | | | 1 |
| | | | | | | | | | | | |
| 35 | BACR15GF5D | | | | | | | | | | 32 |
| | | | | | | | | | | | |
| 40 | 141A6183-1 | | | | | | | | | | 1 |
| 45 | NAS1352N06LB4P | | | | | | | | | | 2 |
| 50 | MS20253P2-3240 | | | | | | | | | | 1 |
| 55 | 141A6184-1 | | | | | | | | | | 1 |
| 60 | 141A6184-2 | | | | | | | | | | 1 |

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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- | | | | | | | | | | | |
| 65 | 141A6181-1 | | | | | | | | | A | 1 |
| | | | | | | | | | | | |
| -65A | 141A6181-3 | | | | | | | | | | |
| -65B | 141A6181-5 | | | | | | | | | | |
| | | | | | | | | | | | |
| 70 | BACB28AP04P014 | | | | | | | | | | 3 |
| 75 | BACB28AT06B014C | | | | | | | | | | 3 |
| 80 | AF5141-3C2 | | | | | | | | | | 56 |
| | | | | | | | | | | | |
| 85 | 102F9209M3 | | | | | | | | | A | 2 |
| | | | | | | | | | | | |
| -85A | BRF200C3D | | | | | | | | | | 2 |
| | | | | | | | | | | | |
| 90 | BRF220C3-3D | | | | | | | | | | 26 |
| | | | | | | | | | | | |
| 95 | 141A6181-2 | | | | | | | | | A | 1 |
| -95A | 141A6181-4 | | | | | | | | | | 1 |

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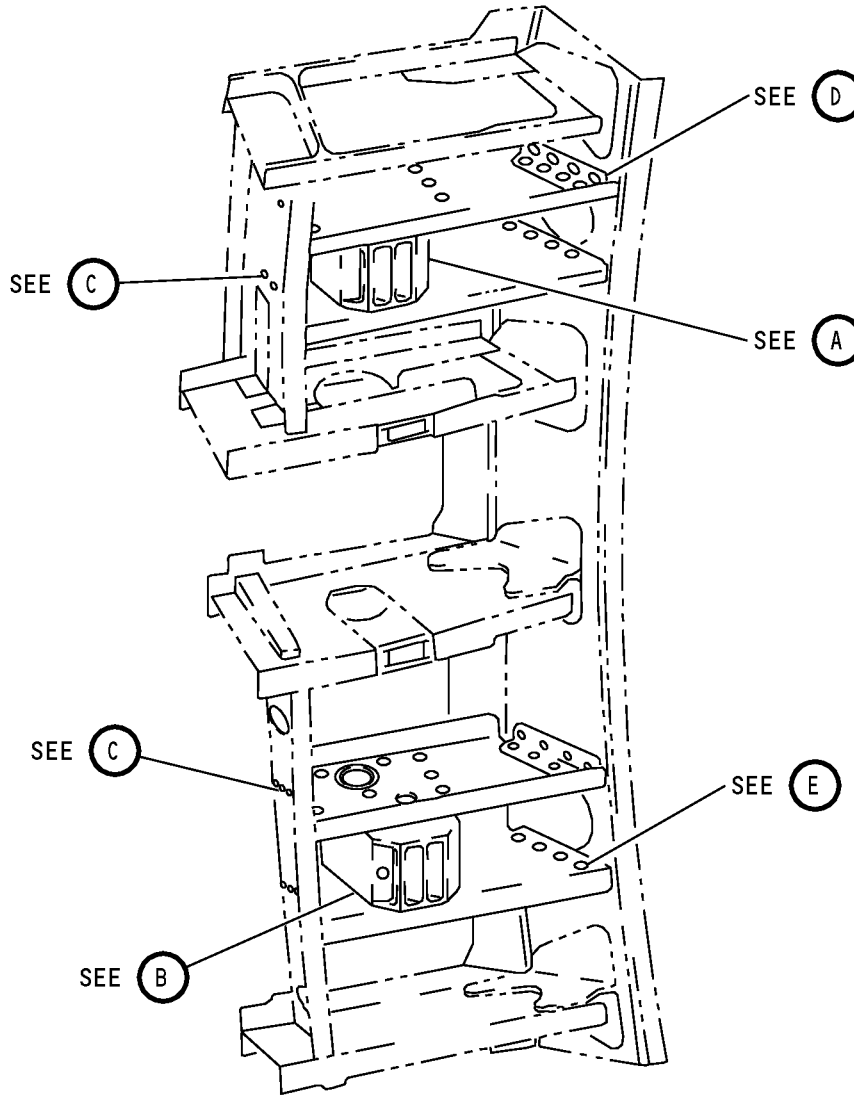
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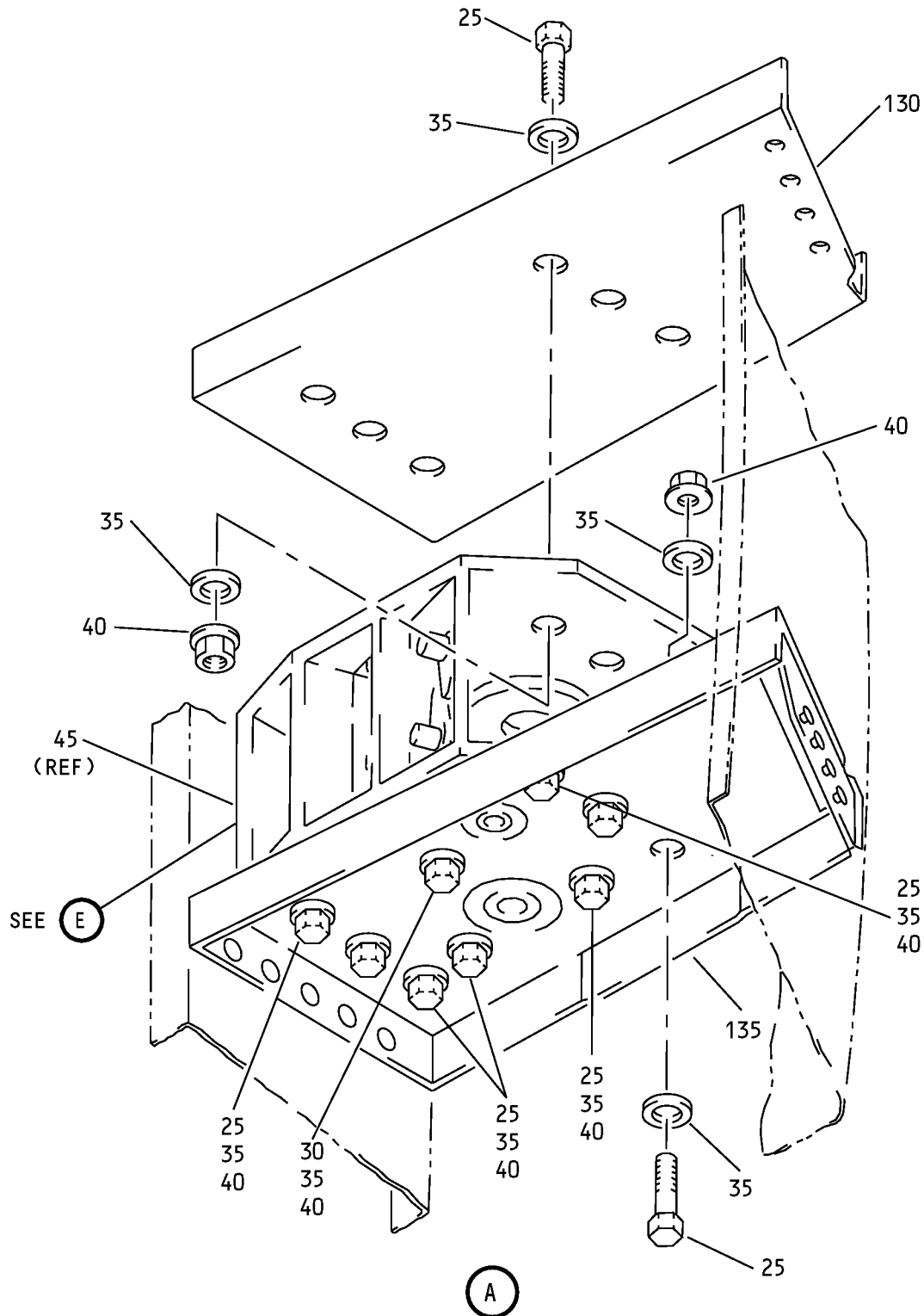


Hinge Support Assembly
IPL Figure 5 (Sheet 1 of 5)

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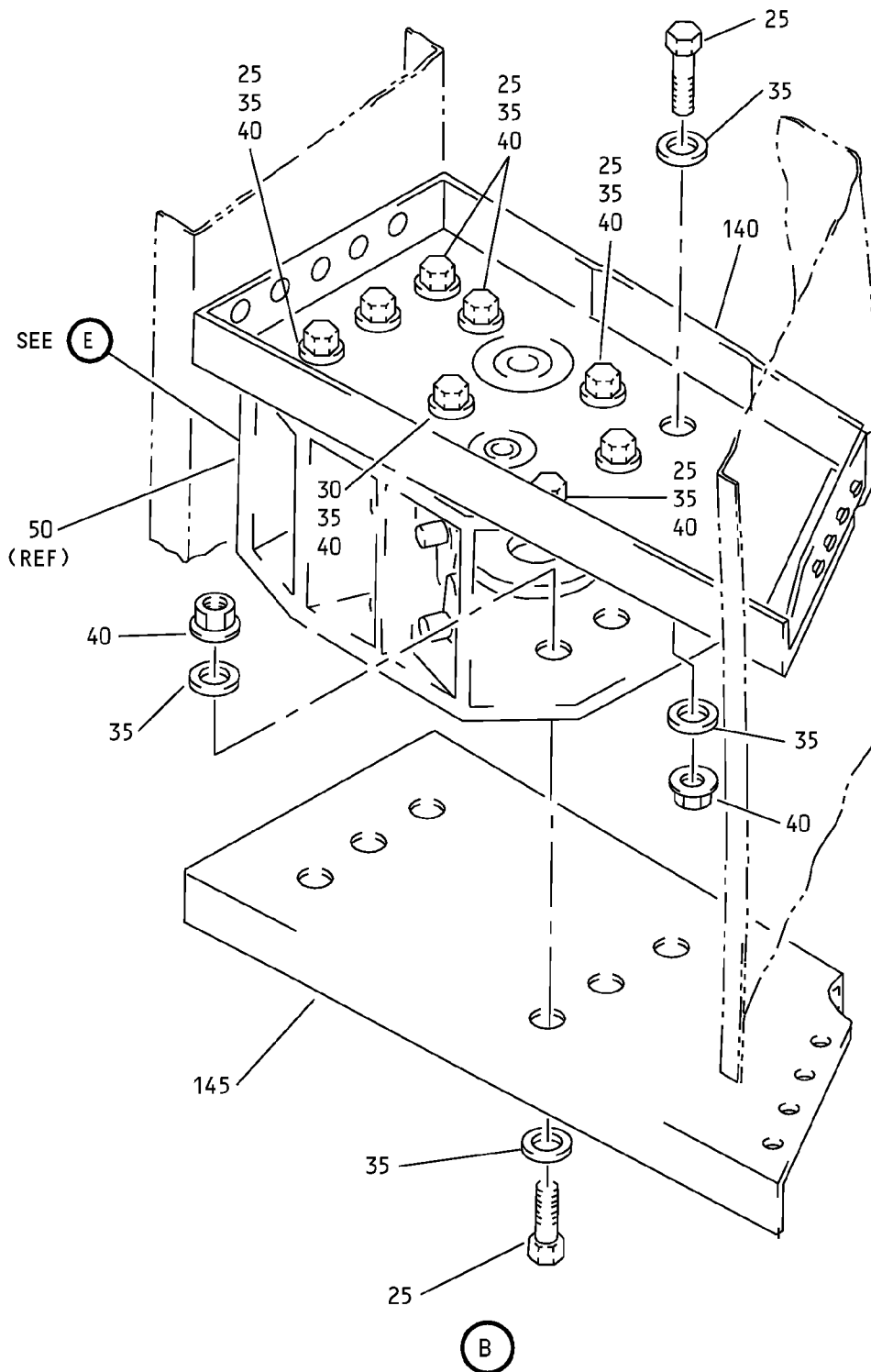
COMPONENT MAINTENANCE MANUAL



Hinge Support Assembly
IPL Figure 5 (Sheet 2 of 5)

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Hinge Support Assembly
IPL Figure 5 (Sheet 3 of 5)

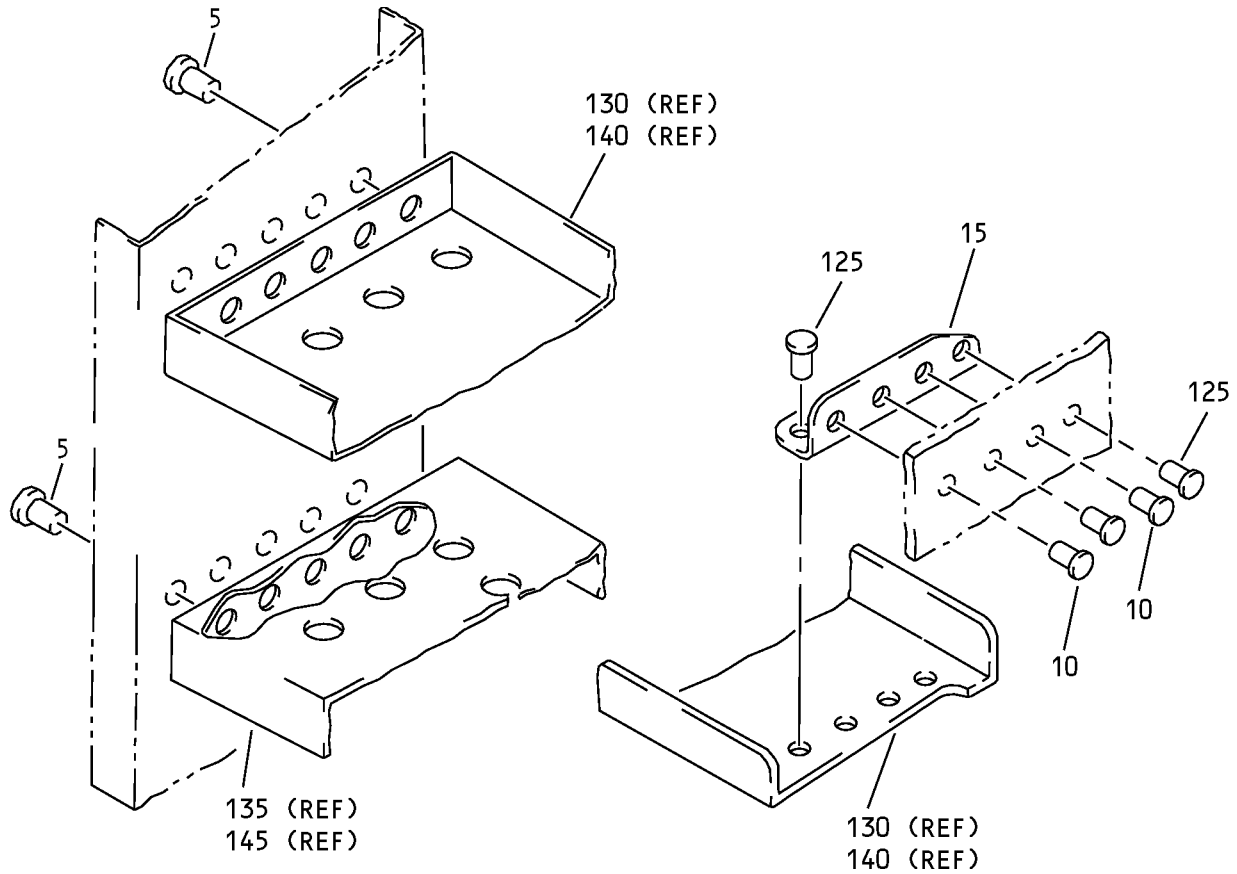
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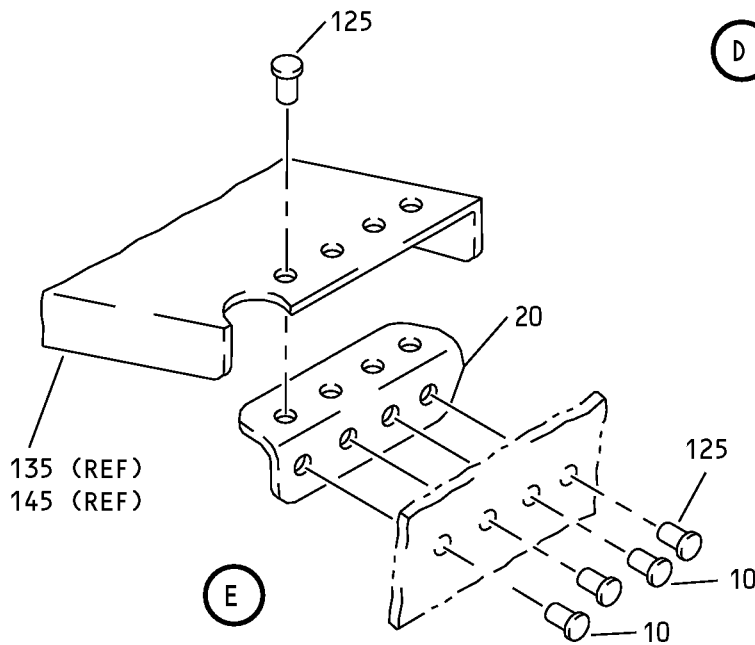
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(C)

(D)



(E)

Hinge Support Assembly
IPL Figure 5 (Sheet 4 of 5)

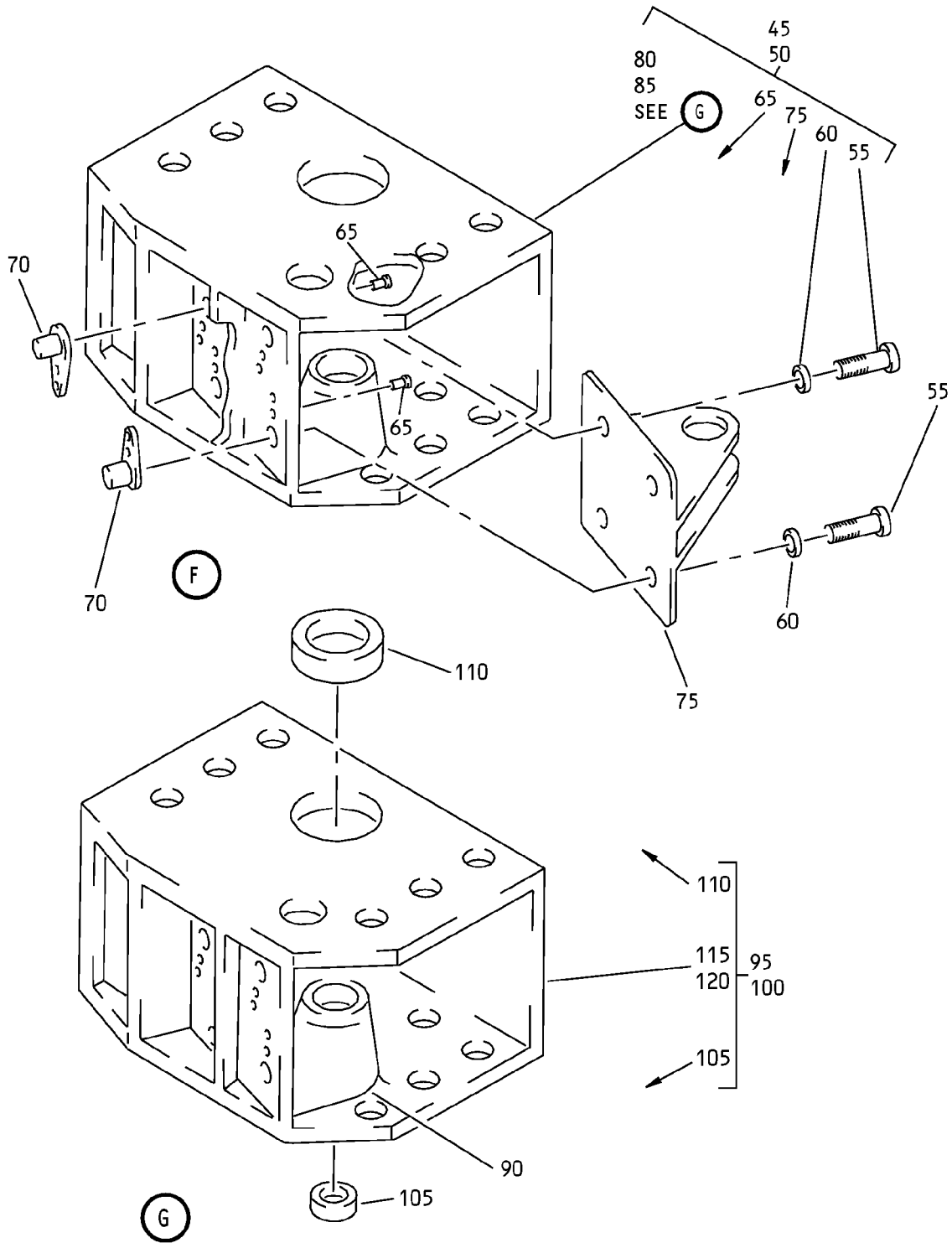
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Hinge Support Assembly
IPL Figure 5 (Sheet 5 of 5)



COMPONENT MAINTENANCE MANUAL

| FIG/ ITEM | PART NUMBER | AIRLINE PART NUMBER | NOMENCLATURE | | | | | | | USAGE CODE | UNITS PER ASSY |
|--------------|---------------|---------------------------|--------------|---|---|---|---|---|---|---------------|----------------------|
| | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | | |
| 5- | | | | | | | | | | | |
| -1A | 141A6190-1 | | | | | | | | | A | RF |
| -1B | 141A6190-1 | | | | | | | | | B-J | RF |
| 5 | BACR15FT6D | | | | | | | | | | 20 |
| 10 | BACR15GF6D | | | | | | | | | | 12 |
| 15 | 141A6145-1 | | | | | | | | | | 2 |
| 20 | 141A6145-2 | | | | | | | | | | 2 |
| 25 | BACB30NM3K4 | | | | | | | | | | 28 |
| 30 | BACB30NM3K5 | | | | | | | | | | 2 |
| 35 | NAS1149D0332J | | | | | | | | | | 60 |
| 40 | H52732-3CD | | | | | | | | | | 30 |
| 45 | 69-22323-19 | | | | | | | | | | 1 |
| 50 | 69-22323-22 | | | | | | | | | | 1 |
| 55 | BACB30NR4K7 | | | | | | | | | | 4 |
| 60 | BACW10BN4AC | | | | | | | | | | 4 |
| 65 | MS20426A3 | | | | | | | | | | 8 |
| 70 | NS202440-048 | | | | | | | | | | 4 |
| 75 | 66-24884-1 | | | | | | | | | | 1 |
| 80 | 69-22323-17 | | | | | | | | | | 1 |
| 85 | 69-22323-21 | | | | | | | | | | 1 |
| 90 | NAS516-1A | | | | | | | | | | 1 |
| 95 | 65-25838-19 | | | | | | | | | | 1 |

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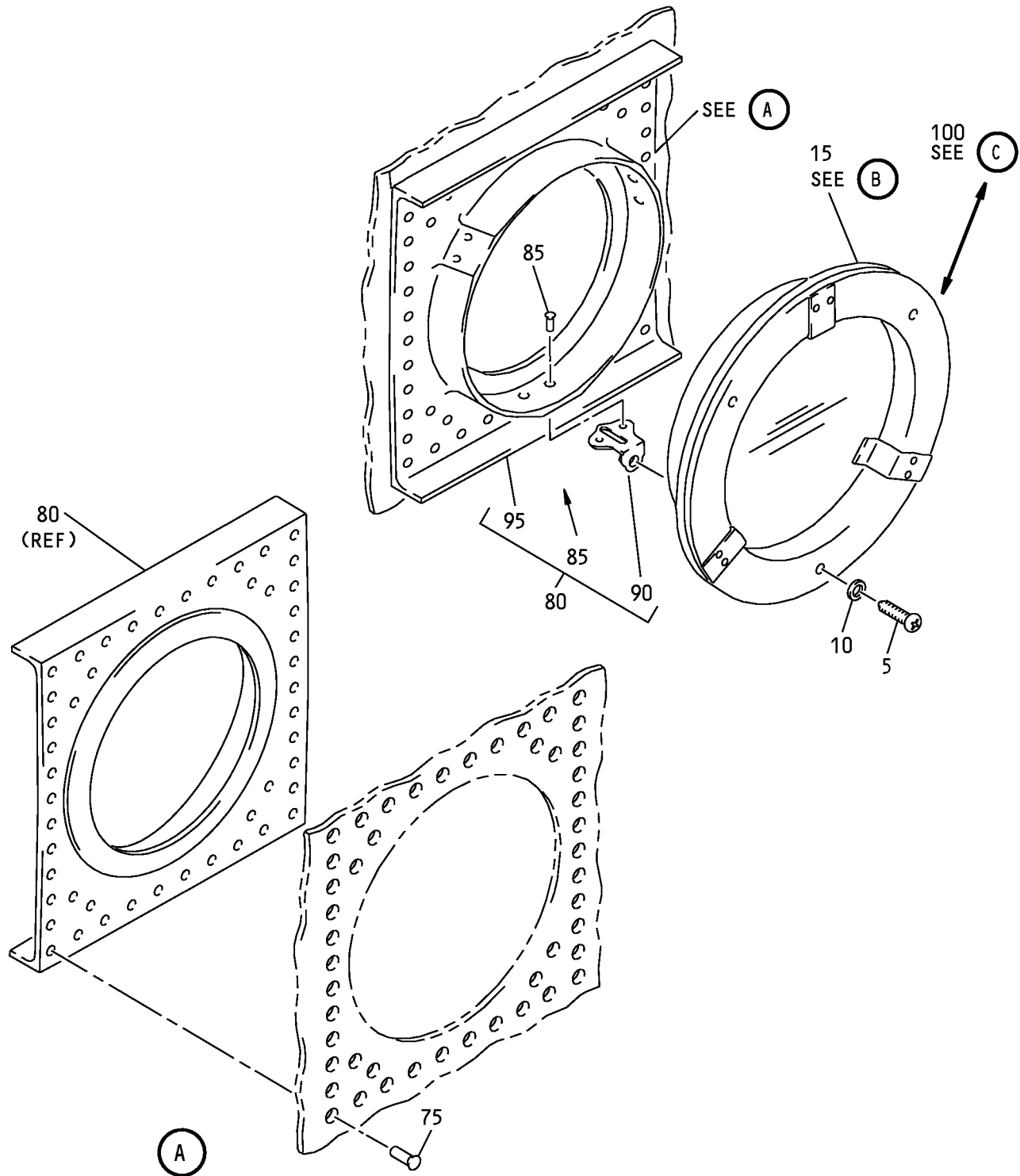


COMPONENT MAINTENANCE MANUAL

| FIG/ ITEM | PART NUMBER | AIRLINE PART NUMBER | NOMENCLATURE | | | | | | | USAGE CODE | UNITS PER ASSY |
|--------------|---------------|---------------------------|--------------|---|---|---|---|---|---|---------------|----------------------|
| | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | | |
| 5- | | | | | | | | | | | |
| 100 | 65-25838-24 | | | | | | | | . . . SUPPORT ASSY (USED ON ITEM 85) | | 1 |
| 105 | NAS537B10P066 | | | | | | | | BUSHING | | 1 |
| 110 | NAS537B16P044 | | | | | | | | BUSHING | | 1 |
| 115 | 65-25838-21 | | | | | | | | SUPPORT (USED ON ITEM 95) | | 1 |
| 120 | 65-25838-25 | | | | | | | | SUPPORT (USED ON ITEM 100) | | 1 |
| 125 | BACR15FT6D | | | | | | | | . RIVET (SIZE DETERMINED ON INST) | | 20 |
| 130 | 141A6143-5 | | | | | | | | . INTERCOSTAL | | 1 |
| 135 | 141A6143-6 | | | | | | | | . INTERCOSTAL | | 1 |
| 140 | 141A6143-7 | | | | | | | | . INTERCOSTAL | | 1 |
| 145 | 141A6143-8 | | | | | | | | . INTERCOSTAL | | 1 |

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COMPONENT MAINTENANCE MANUAL

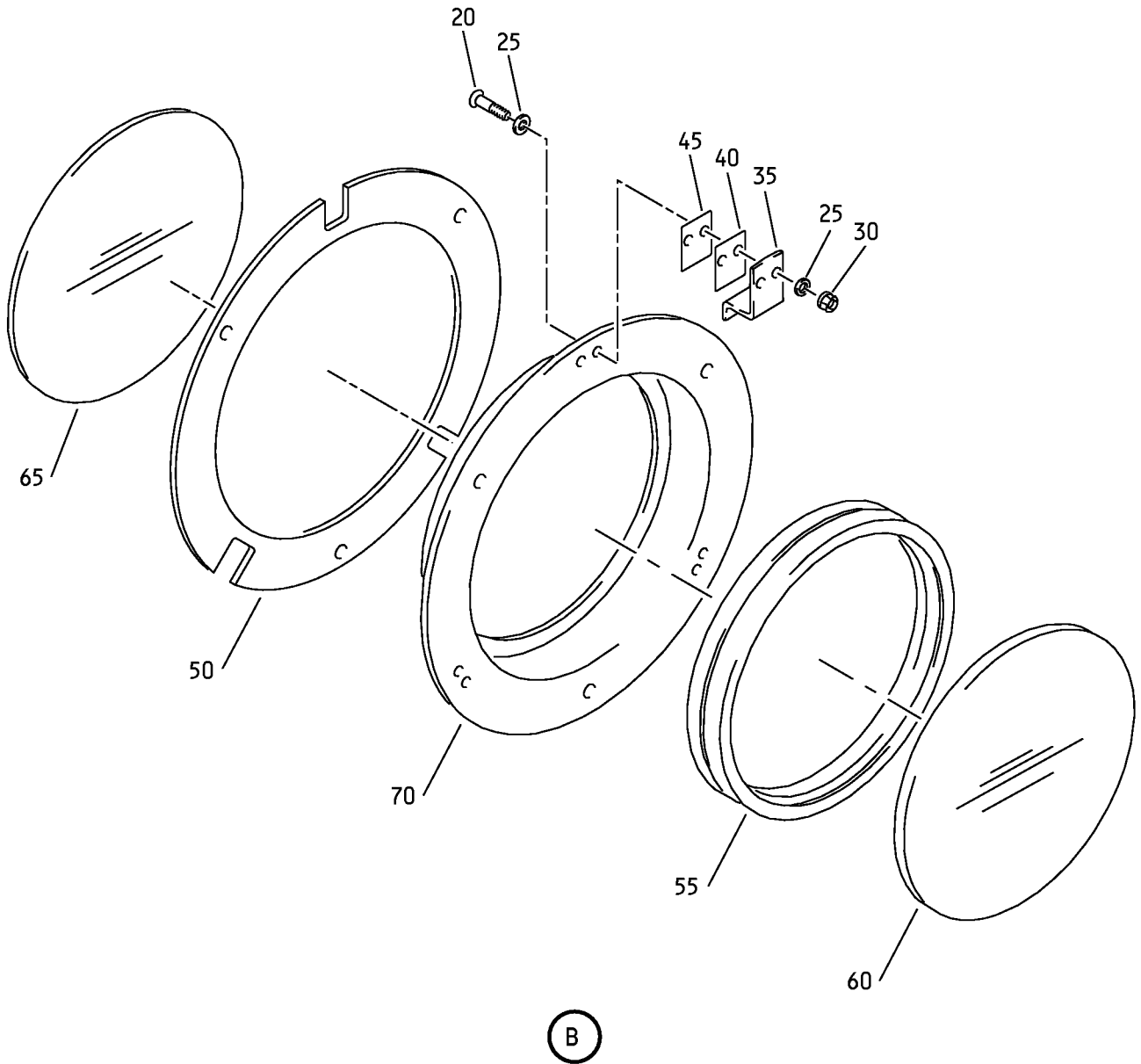


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Window Assembly
IPL Figure 6 (Sheet 1 of 3)

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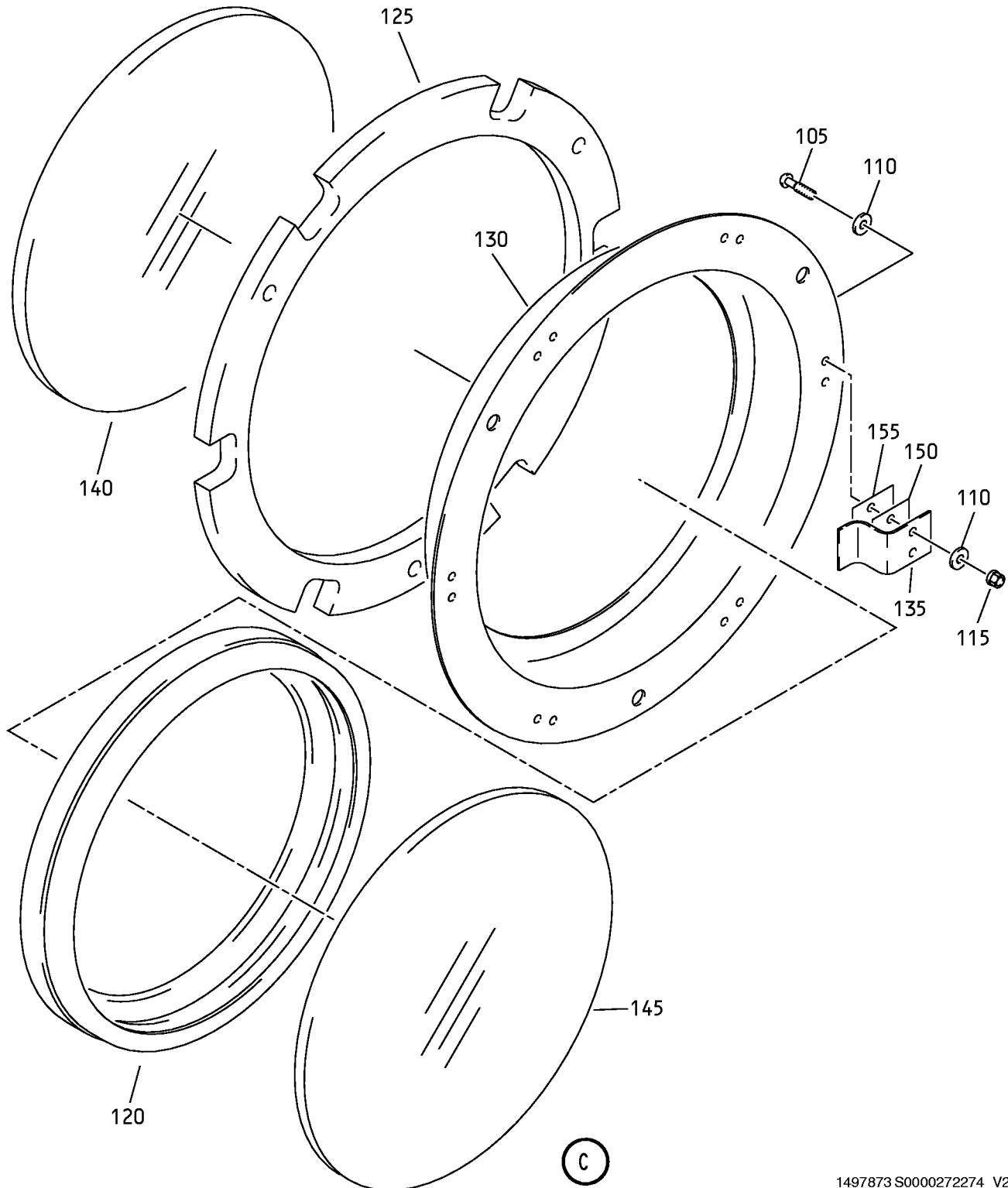


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Window Assembly
IPL Figure 6 (Sheet 2 of 3)

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Window 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 | | |
| 6- | | | | | | | | | | | |
| -1A | 141A6200-1 | | | | | | | | | A | RF |
| -1B | 141A6200-1 | | | | | | | | | B-G | RF |
| -1C | 141A6200-2 | | | | | | | | | H, J | RF |
| 5 | NAS8203A8 | | | | | | | | | A-G | 3 |
| -5A | BACS12HJ3K9 | | | | | | | | | H, J | 3 |
| 10 | NAS1149D0332J | | | | | | | | | | 3 |
| 15 | 65-2863-8 | | | | | | | | | A-G | 1 |
| 20 | NAS8200A8 | | | | | | | | | A-G | 6 |
| 25 | NAS1149DN432J | | | | | | | | | A-G | 12 |
| 30 | H52732-04CD | | | | | | | | | A-G | 6 |
| | | | | | | | | | | | |
| 35 | 63-1478-1 | | | | | | | | | A-G | 3 |
| 40 | BACS40R007B007F | | | | | | | | | A-G | AR |
| 45 | BACS40R007C007F | | | | | | | | | A-G | AR |
| 50 | 66-2646 | | | | | | | | | A-G | 1 |
| 55 | 66-1921-2 | | | | | | | | | A-G | 1 |
| 60 | 69-1083-2 | | | | | | | | | A-G | 1 |
| 65 | 69-1084-2 | | | | | | | | | A-G | 1 |
| 70 | 69-1983-7 | | | | | | | | | A-G | 1 |
| 75 | BACR15GF5D | | | | | | | | | | 48 |
| | | | | | | | | | | | |
| 80 | 141A6201-1 | | | | | | | | | | 1 |
| 85 | BACR15BA4AD | | | | | | | | | | 6 |
| | | | | | | | | | | | |
| 90 | T8059S1032B1 | | | | | | | | | | 3 |
| | | | | | | | | | | | |
| 95 | 141A6201-2 | | | | | | | | | | 1 |
| 100 | 141A6570-1 | | | | | | | | | H, J | 1 |

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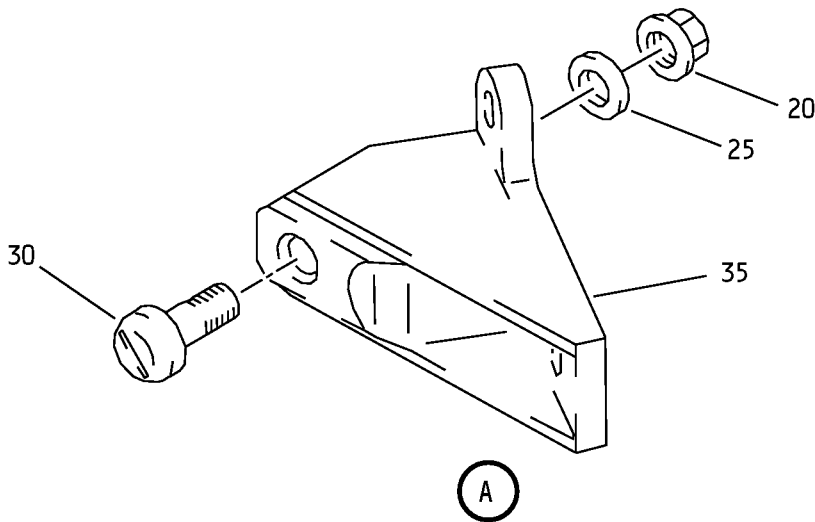
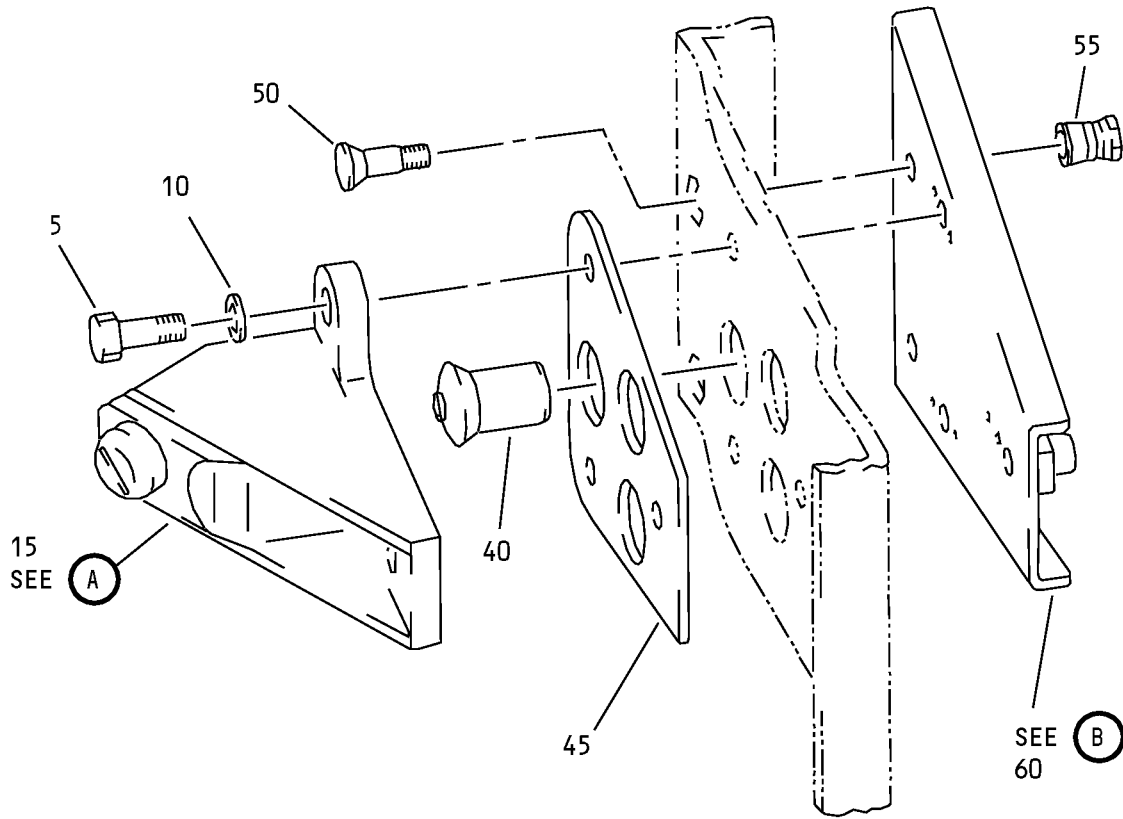
COMPONENT MAINTENANCE MANUAL

| FIG/ ITEM | PART NUMBER | AIRLINE PART NUMBER | NOMENCLATURE | | | | | | | USAGE CODE | UNITS PER ASSY |
|--------------|-----------------|---------------------------|--------------|---|--|---|---|---|---|---------------|----------------------|
| | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | | |
| 6- | | | | | | | | | | | |
| 105 | BACS12HJ04K8 | | . | . | SCREW (OPT ITEM 105A) | | | | | H, J | 12 |
| -105A | NAS8200A8 | | . | . | SCREW (OPT ITEM 105) | | | | | H, J | 12 |
| 110 | NAS1149DN432J | | . | . | WASHER | | | | | H, J | 24 |
| 115 | PLH504CD | | . | . | NUT (V62554) (SPEC BACN10YR04CD) (OPT H52732-04CD (V15653)) | | | | | H, J | 12 |
| 120 | 141A6574-1 | | . | . | SEAL | | | | | H, J | 1 |
| 125 | 141A6575-1 | | . | . | SEAL | | | | | H, J | 1 |
| 130 | 141A6572-1 | | . | . | RETAINER | | | | | H, J | 1 |
| 135 | 141A6573-1 | | . | . | CLIP | | | | | H, J | 6 |
| 140 | 141A6571-1 | | . | . | PANE-OUTER | | | | | H, J | 1 |
| 145 | 141A6571-2 | | . | . | PANE-INNER | | | | | H, J | 1 |
| 150 | BACS40R007B007F | | . | . | SHIM | | | | | H, J | AR |
| 155 | BACS40R007C007F | | . | . | SHIM | | | | | H, J | AR |

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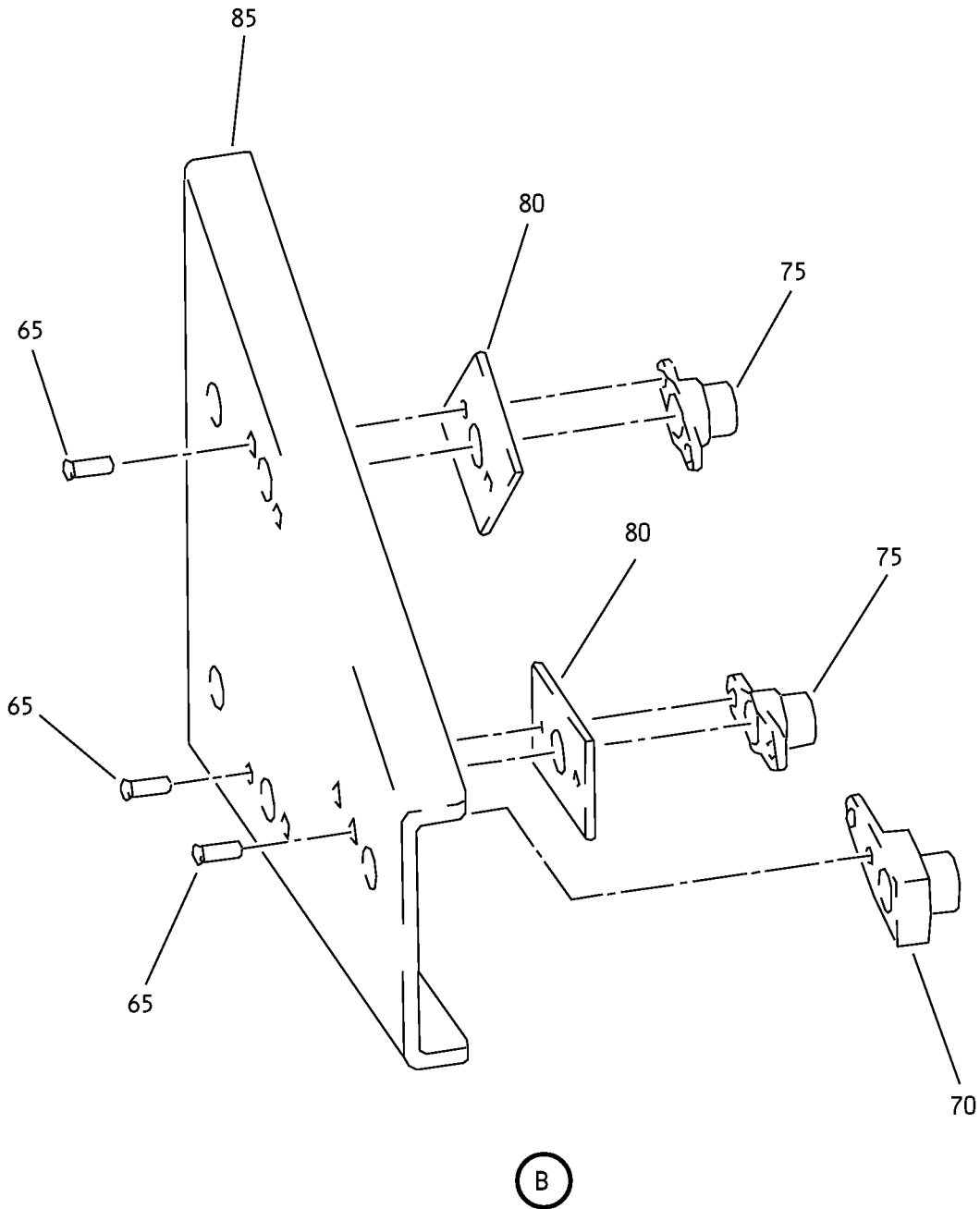
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Centering Guide Installation
IPL Figure 7 (Sheet 1 of 2)

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Centering Guide Installation
IPL Figure 7 (Sheet 2 of 2)



COMPONENT MAINTENANCE MANUAL

| FIG/ ITEM | PART NUMBER | AIRLINE PART NUMBER | NOMENCLATURE | | | | | | | USAGE CODE | UNITS PER ASSY |
|--------------|---------------|---------------------------|--------------|---|---|---|---|---|---|---------------|----------------------|
| | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | | |
| 7- | | | | | | | | | | | |
| -1A | 141A6205-1 | | | | | | | | | A | RF |
| -1B | 141A6205-1 | | | | | | | | | B-J | RF |
| 5 | BACB30NM3K10 | | | | | | | | | | 3 |
| 10 | BACW10BP3CD | | | | | | | | | | 3 |
| 15 | 141A6209-1 | | | | | | | | | | 1 |
| 20 | H52732-5CD | | | | | | | | | | 1 |
| | | | | | | | | | | | |
| 25 | NAS1149D0563J | | | | | | | | | | 1 |
| 30 | 141A6217-1 | | | | | | | | | | 1 |
| 35 | 141A6216-1 | | | | | | | | | | 1 |
| 40 | BACR15CE5D | | | | | | | | | | 3 |
| 45 | 141A6212-1 | | | | | | | | | | 1 |
| 50 | BACB30NW6K | | | | | | | | | | 2 |
| 55 | HL79-6 | | | | | | | | | | 2 |
| | | | | | | | | | | | |
| 60 | 141A6213-1 | | | | | | | | | | 1 |
| 65 | BACR15CE3D | | | | | | | | | | 6 |
| 70 | BRF120C3-3D | | | | | | | | | | 1 |
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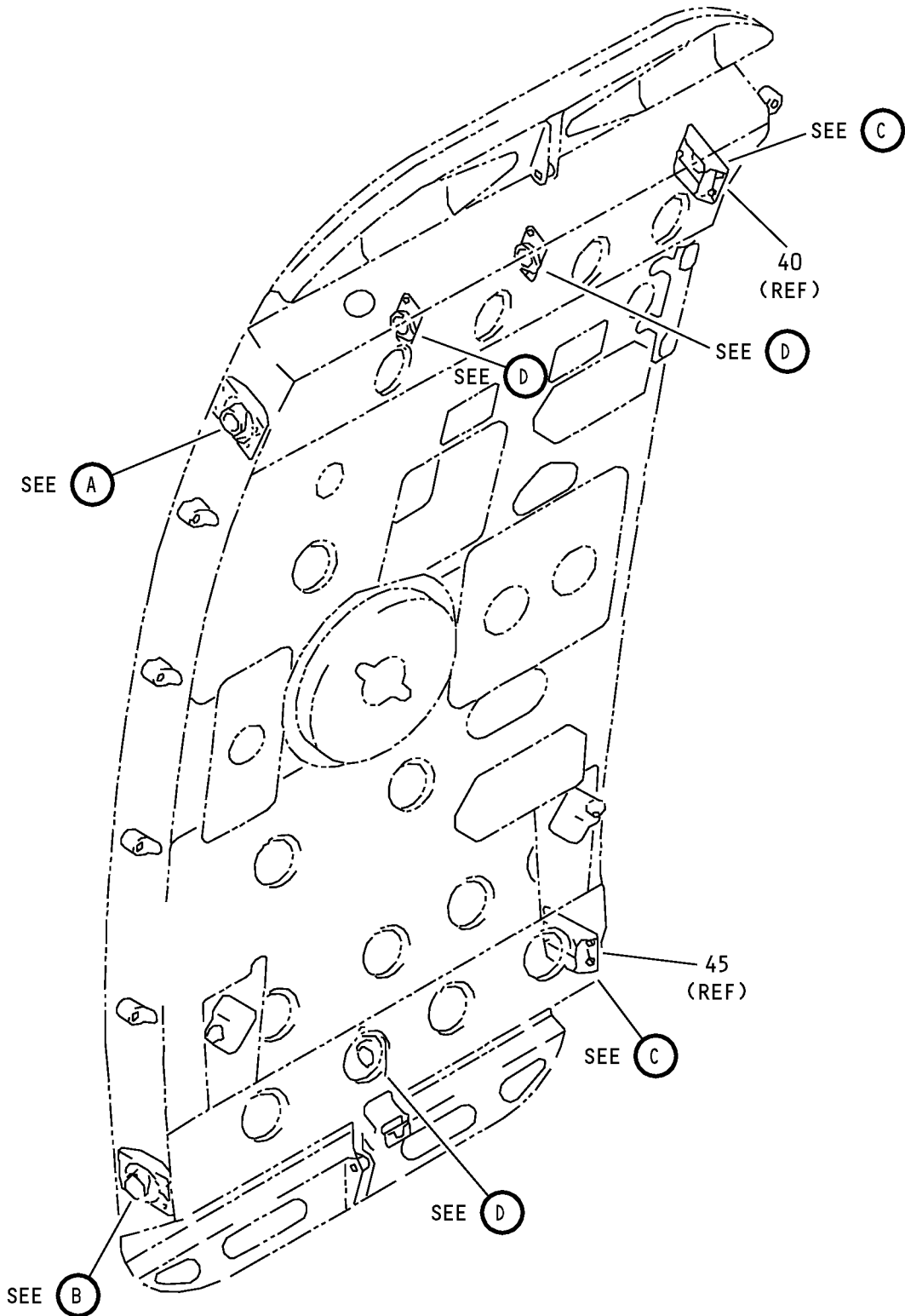
COMPONENT MAINTENANCE MANUAL

| FIG/ ITEM | PART NUMBER | AIRLINE PART NUMBER | NOMENCLATURE | | | | | | | USAGE CODE | UNITS PER ASSY |
|--------------|-----------------|---------------------------|--------------|---|---|---|---|---|---|---------------|----------------------|
| | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | | |
| 7- | | | | | | | | | | | |
| 75 | BRF200C3D | | . | . | NUTPLATE (V52828) (SPEC BACN10JR3CFD) (OPT K51602-3BAC (V15653)) (OPT NS202476-02 (V80539)) (OPT 102F9201-3 (V72962)) (OPT T8092C1032CD (V11815)) | | | | | | 2 |
| 80 | BACF3H08RF011HN | | . | . | FILLER | | | | | | 2 |
| 85 | 141A6214-1 | | . | . | CHANNEL | | | | | | 1 |

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Latch Torque Tube Housing Installation
IPL Figure 8 (Sheet 1 of 4)

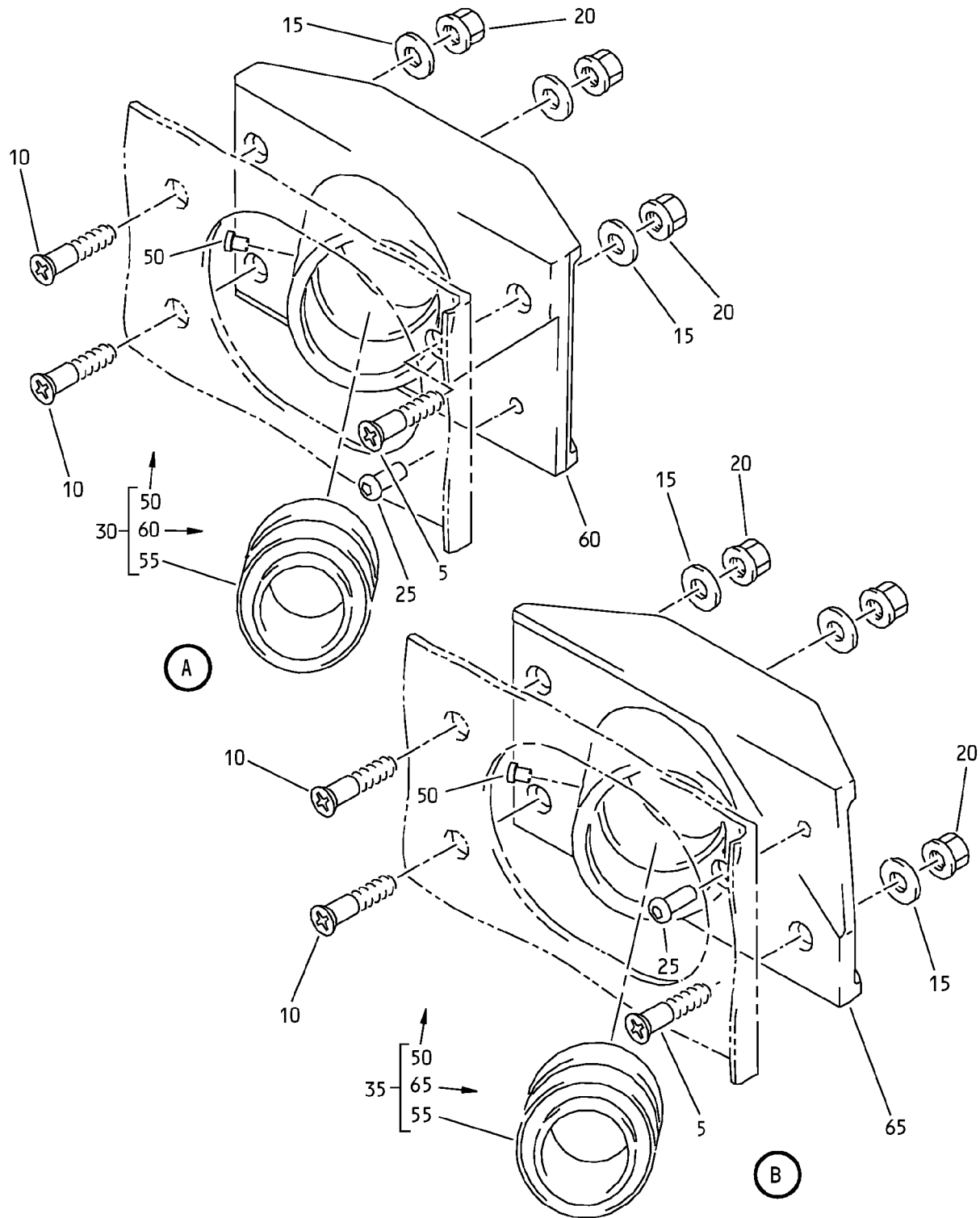
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Latch Torque Tube Housing Installation
IPL Figure 8 (Sheet 2 of 4)

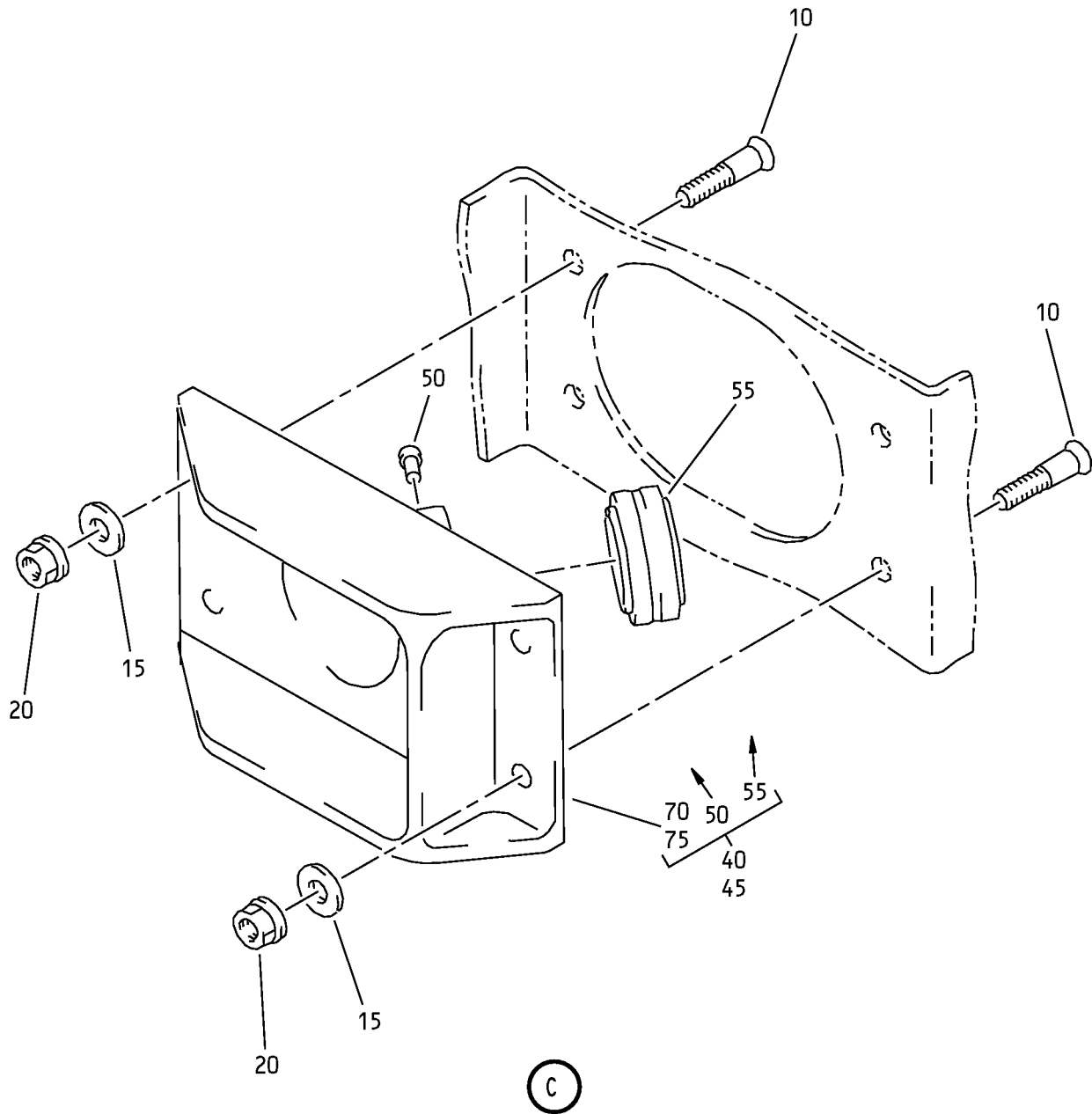
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Latch Torque Tube Housing Installation
IPL Figure 8 (Sheet 3 of 4)

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| FIG/ ITEM | PART NUMBER | AIRLINE PART NUMBER | NOMENCLATURE | | | | | | | USAGE CODE | UNITS PER ASSY |
|--------------|---------------|---------------------------|--------------|---|---|---|---|---|---|---------------|----------------------|
| | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | | |
| 8- | | | | | | | | | | | |
| -1A | 141A6220-1 | | | | | | | | | A | RF |
| -1B | 141A6220-1 | | | | | | | | | B-J | RF |
| 5 | BACB30VF3K5 | | | | | | | | | | 2 |
| 10 | BACB30VF3K4 | | | | | | | | | | 12 |
| 15 | NAS1149D0363J | | | | | | | | | | 14 |
| 20 | H52732-3CD | | | | | | | | | | 14 |
| | | | | | | | | | | | |
| 25 | BACR15FT6D | | | | | | | | | | 2 |
| 30 | 141A6221-1 | | | | | | | | | | 1 |
| 35 | 141A6221-3 | | | | | | | | | | 1 |
| 40 | 141A6221-5 | | | | | | | | | | 1 |
| 45 | 141A6221-7 | | | | | | | | | | 1 |
| 50 | NAS516-1A | | | | | | | | | | 1 |
| 55 | ASSB16-19 | | | | | | | | | | 1 |
| | | | | | | | | | | | |
| 60 | 141A6221-2 | | | | | | | | | | 1 |
| 65 | 141A6221-4 | | | | | | | | | | 1 |
| 70 | 141A6221-6 | | | | | | | | | | 1 |
| 75 | 141A6221-8 | | | | | | | | | | 1 |
| 80 | BACB30NM3K4 | | | | | | | | | | 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 | | |
| 8- | | | | | | | | | | | |
| 85 | BACW10BP3CD | | | | | | | | . WASHER | | 12 |
| 90 | NAS1149D0363J | | | | | | | | . WASHER | | 12 |
| 95 | H52732-3CD | | | | | | | | . NUT (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554)) | | 12 |
| 100 | 141A6145-5 | | | | | | | | . RETAINER | | 3 |
| 105 | 65-2306-7 | | | | | | | | . HOUSING ASSY | | 3 |
| 110 | NAS516-1A | | | | | | | | . . FITTING | | 1 |
| 115 | ASSB16-19 | | | | | | | | . . BEARING (V15860) (SPEC BACB10A397GCM2) (OPT BLN16385GC (V81376)) (OPT KSSB16-5 (V97613)) (OPT NB16BM2 (V73134)) (OPT 55001 (V09455)) (OPT ABW16-101 (VS0352)) (OPT HGL16-102 (V02758)) (OPT NB12BGCM2 (V73134)) (OPT NC16-4 (V56644)) | | 1 |
| 120 | 65-2306-8 | | | | | | | | . . HOUSING | | 1 |

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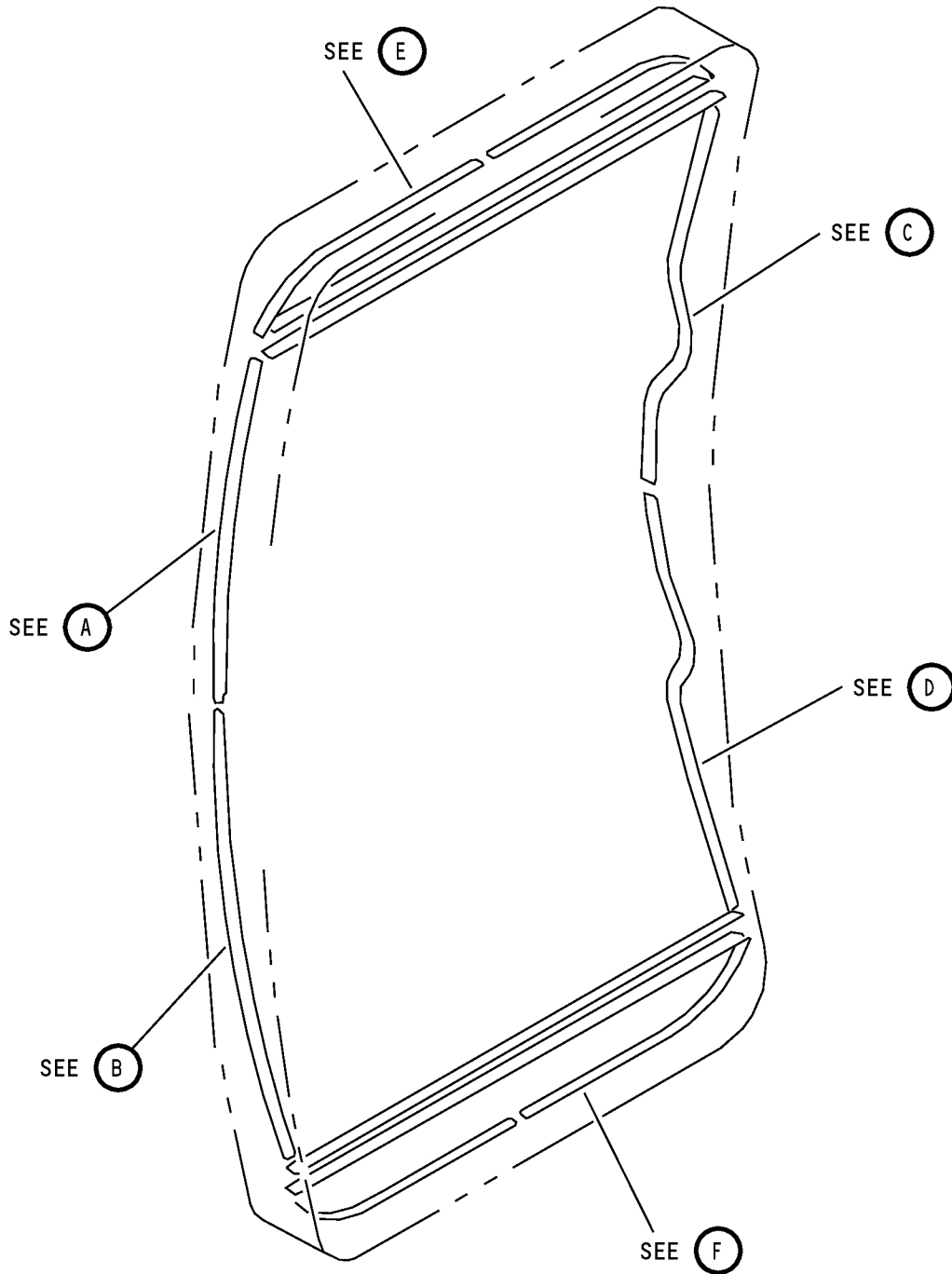
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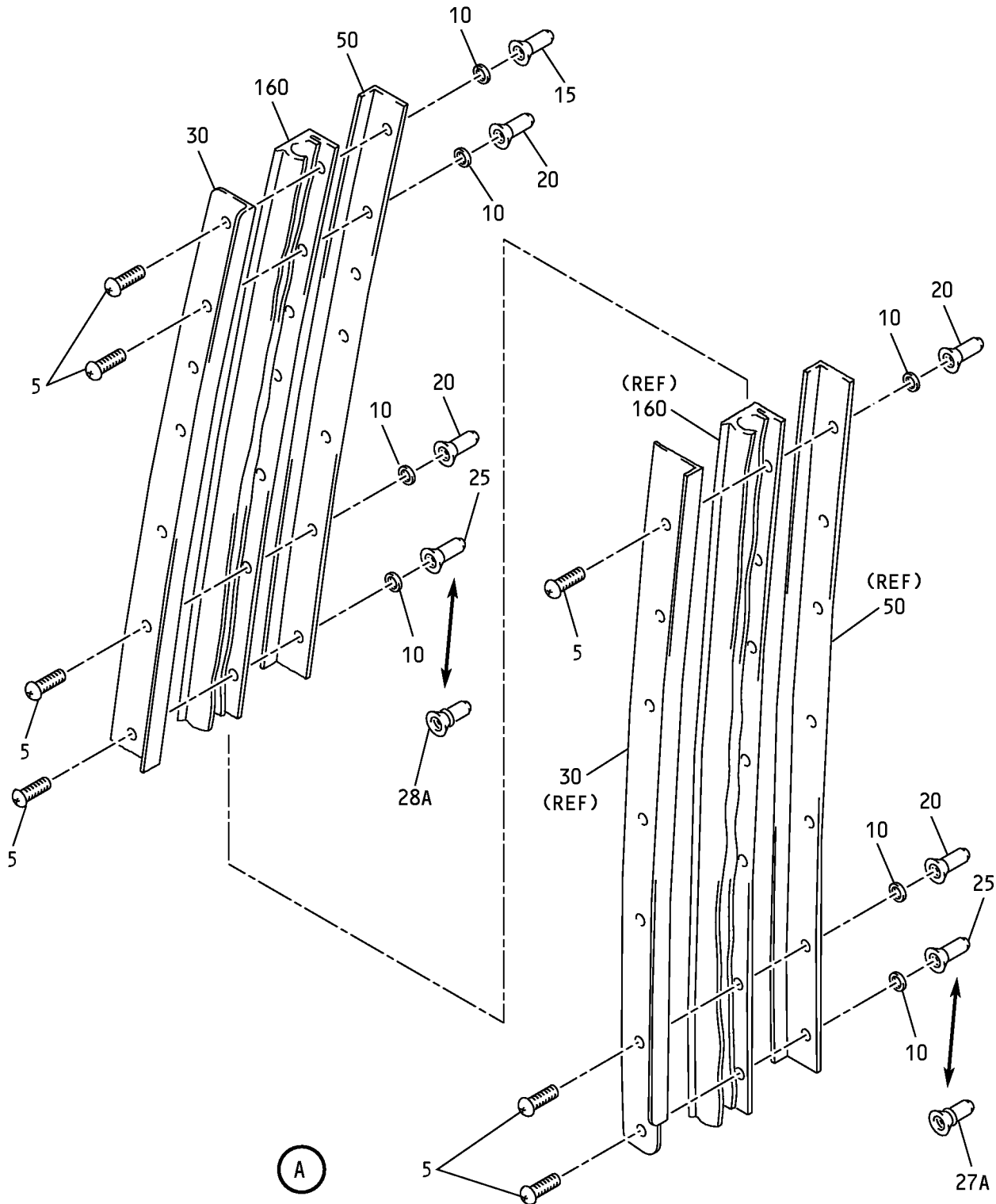
COMPONENT MAINTENANCE MANUAL



Pressure Seal Installation
IPL Figure 9 (Sheet 1 of 7)

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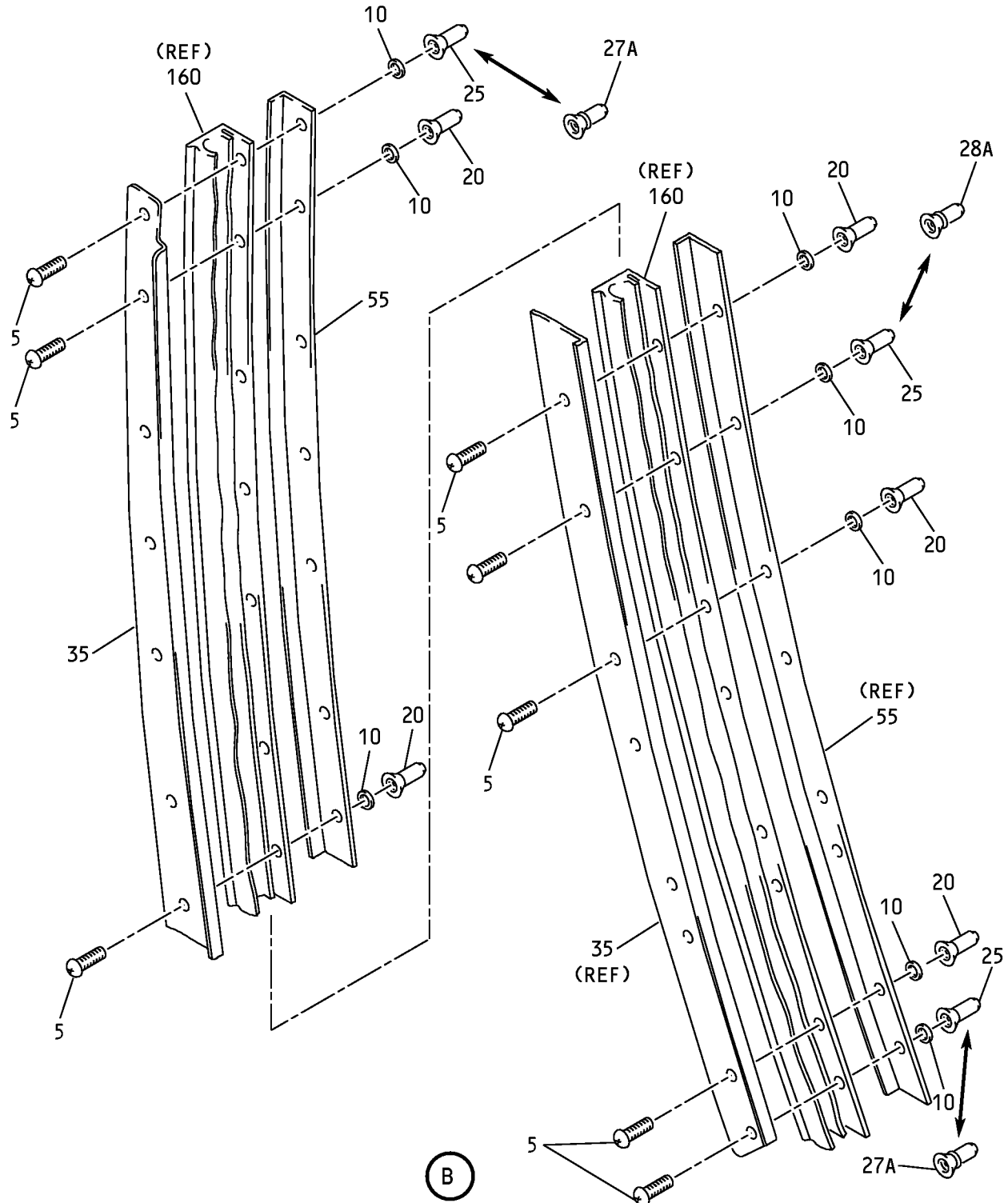


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Pressure Seal Installation
IPL Figure 9 (Sheet 2 of 7)

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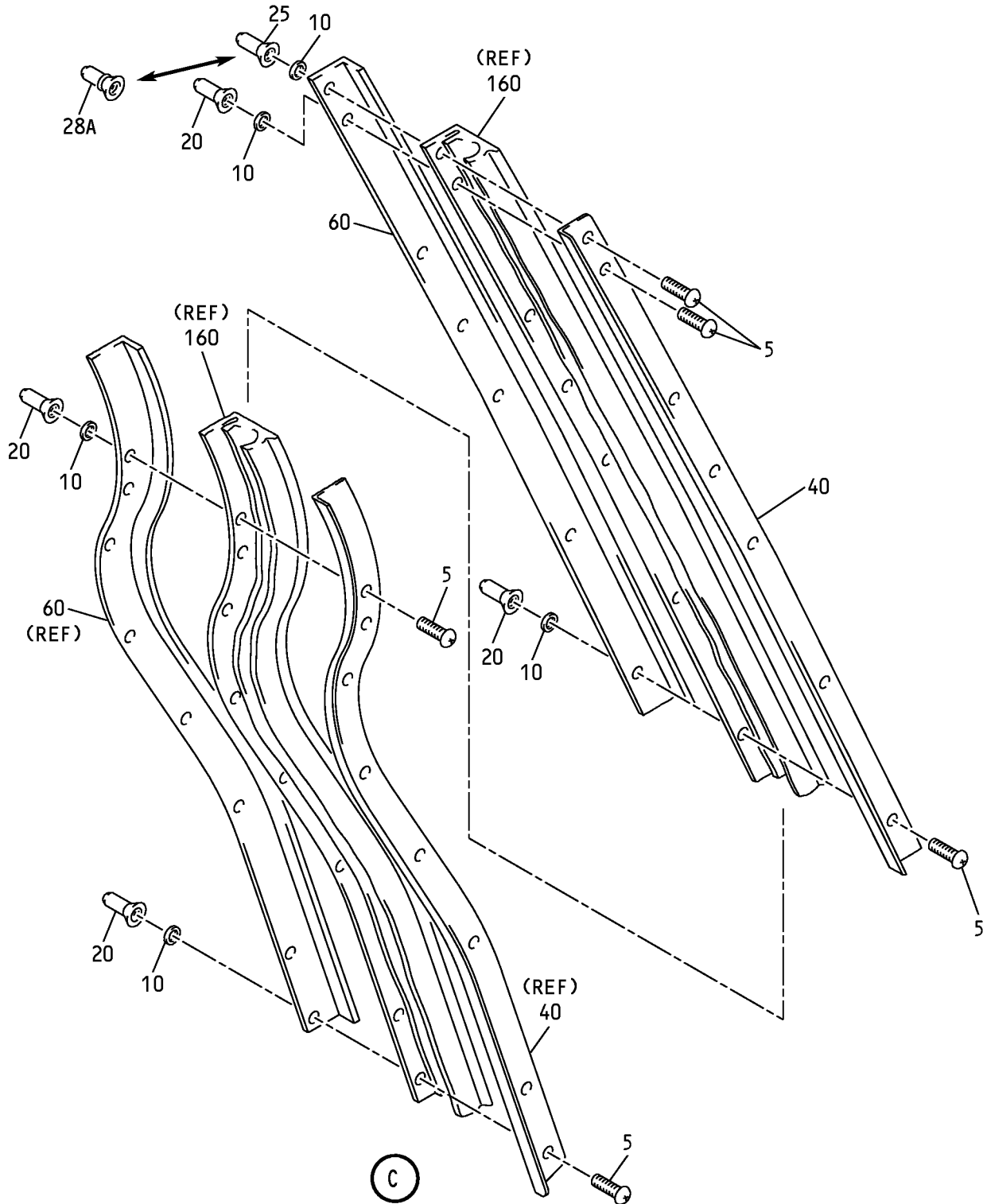


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Pressure Seal Installation
IPL Figure 9 (Sheet 3 of 7)

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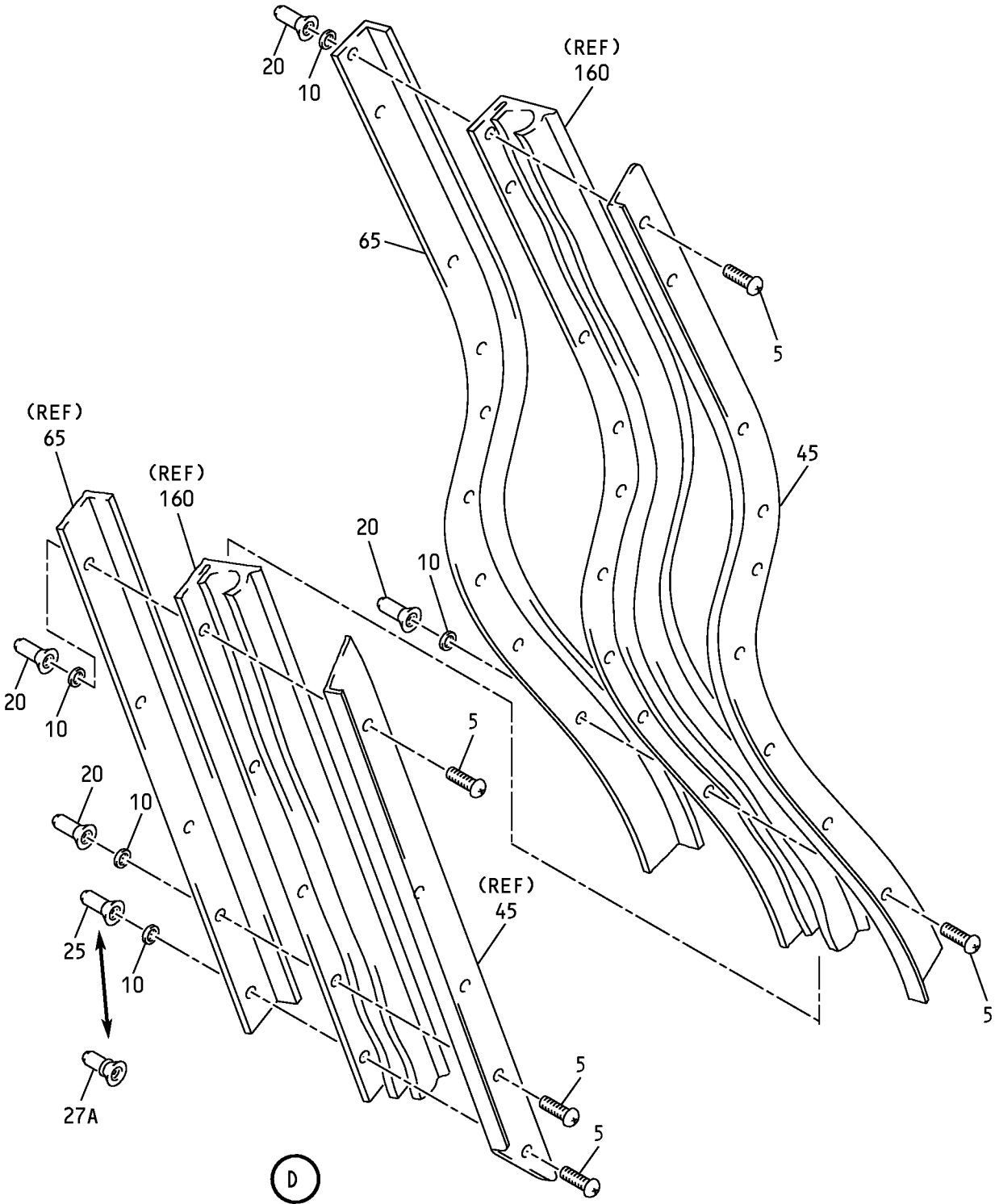


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Pressure Seal Installation
IPL Figure 9 (Sheet 4 of 7)

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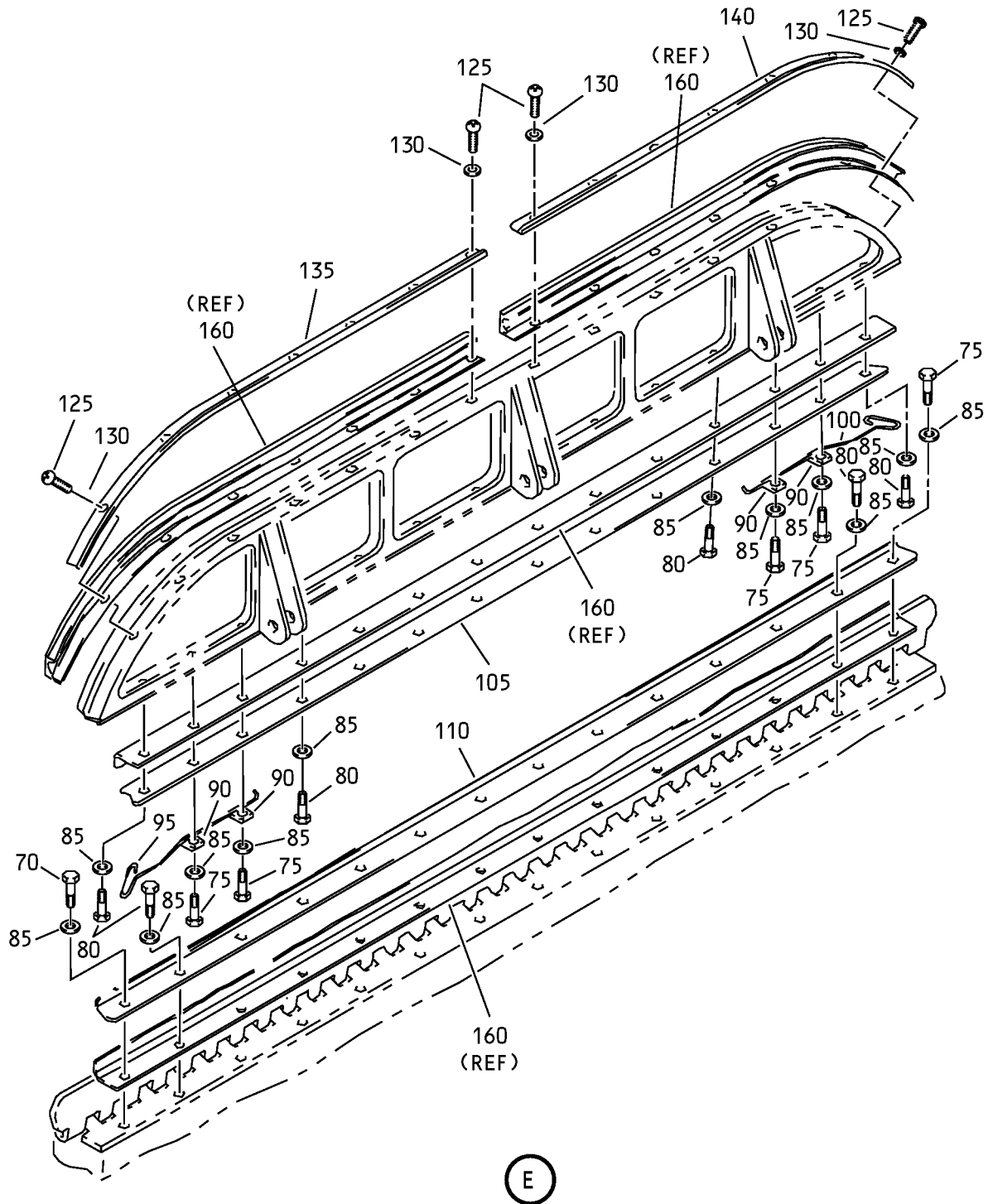


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Pressure Seal Installation
IPL Figure 9 (Sheet 5 of 7)

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Pressure Seal Installation
IPL Figure 9 (Sheet 6 of 7)

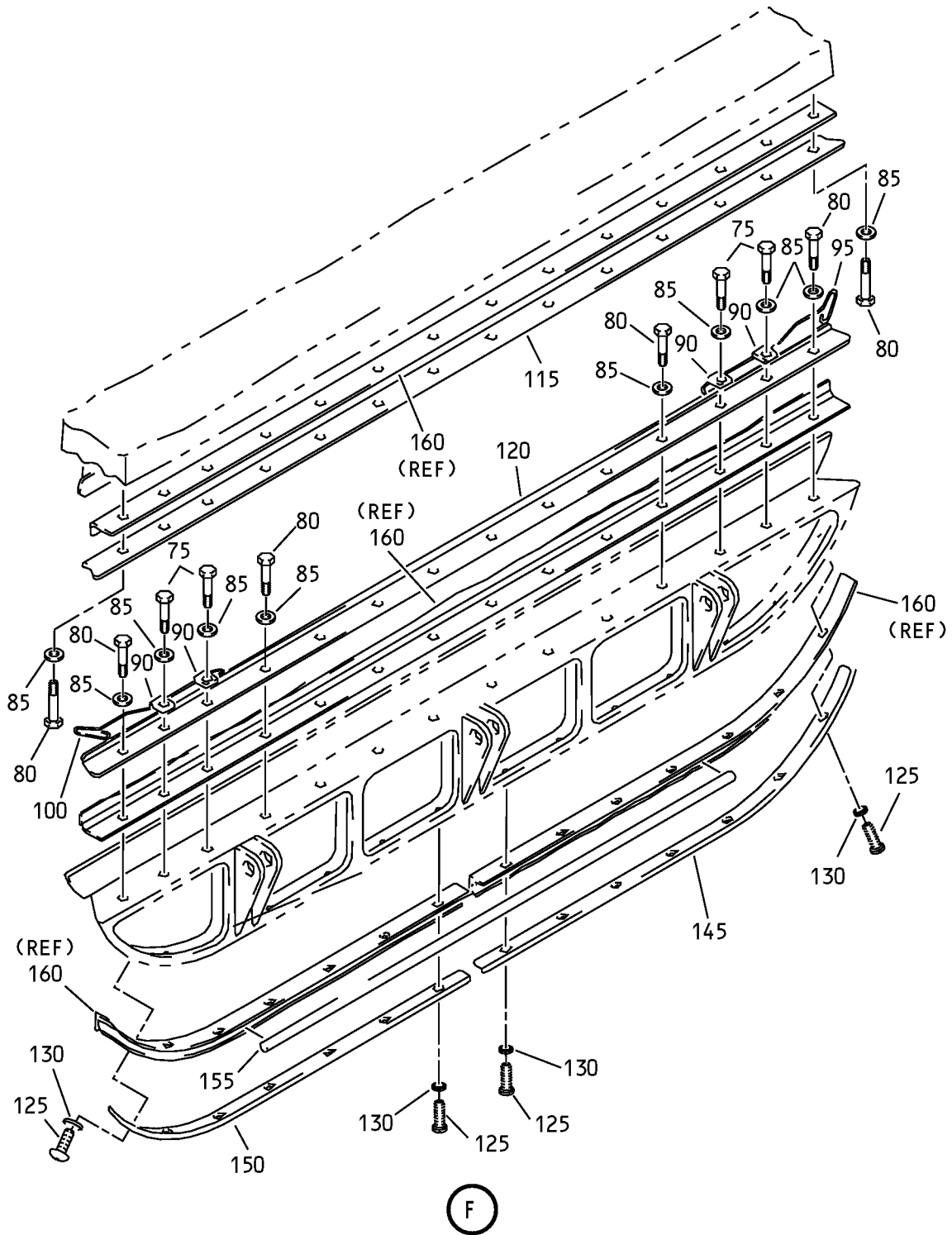
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Pressure Seal Installation
IPL Figure 9 (Sheet 7 of 7)

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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 | | |
| 9- | | | | | | | | | | | |
| -1A | 141A6240-1 | | | | | | | | | A | RF |
| -1B | 141A6240-2 | | | | | | | | | A | RF |
| -1C | 141A6240-3 | | | | | | | | | A | RF |
| -1D | 141A6240-4 | | | | | | | | | A | RF |
| -1E | 141A6240-4 | | | | | | | | | B, C | RF |
| -1F | 141A6240-5 | | | | | | | | | D-J | RF |
| 5 | NAS8202A10 | | | | | | | | | | 58 |
| 10 | NAS1149DN816J | | | | | | | | | | 58 |
| 15 | NAS1330C08-241 | | | | | | | | | A-C | 1 |
| -15B | BACR16F08C281 | | | | | | | | | D-J | 1 |
| 20 | NAS1330C08-106 | | | | | | | | | A-C | 50 |
| -20B | BACR16F08C106 | | | | | | | | | D-J | 50 |
| 25 | NAS1330C08-161 | | | | | | | | | A-C | 7 |
| -27 | BACR16C08-201 | | | | | | | | | | |
| 27A | BACR16F08C201 | | | | | | | | | D-J | 4 |
| 28A | BACR16F08C241 | | | | | | | | | D-J | 3 |
| 30 | 141A6241-5 | | | | | | | | | | 1 |
| 35 | 141A6241-6 | | | | | | | | | | 1 |
| 40 | 141A6241-3 | | | | | | | | | A | 1 |
| -40A | 141A6241-21 | | | | | | | | | | 1 |
| 45 | 141A6241-4 | | | | | | | | | A | 1 |
| -45A | 141A6241-22 | | | | | | | | | | 1 |
| 50 | 141A6241-7 | | | | | | | | | | 1 |
| 55 | 141A6241-8 | | | | | | | | | | 1 |
| 60 | 141A6241-1 | | | | | | | | | | 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 | | |
| 9- | | | | | | | | | | | |
| 65 | 141A6241-2 | | . | | | | | | | | 1 |
| 70 | BACB30NM3K10 | | . | | | | | | | A-C | 1 |
| -70A | BACB30NM3K13 | | . | | | | | | | D-J | 1 |
| 75 | BACB30NM3K7 | | . | | | | | | | | 9 |
| 80 | BACB30NM3K5 | | . | | | | | | | | 46 |
| 85 | NAS1149D0332J | | . | | | | | | | | 56 |
| 90 | 63-9484 | | . | | | | | | | | 8 |
| 95 | 141A6243-2 | | . | | | | | | | | 2 |
| 100 | 141A6243-1 | | . | | | | | | | | 2 |
| 105 | 141A6241-9 | | . | | | | | | | | 1 |
| 110 | 90-7809-20 | | . | | | | | | | A | 1 |
| | | | | | | | | | | | |
| -110A | 90-7809-20 | | . | | | | | | | | 1 |
| | | | | | | | | | | | |
| -110B | 141A6244-1 | | . | | | | | | | | 1 |
| | | | | | | | | | | | |
| 115 | 141A6241-15 | | . | | | | | | | A | 1 |
| -115A | 141A6241-20 | | . | | | | | | | | 1 |
| | | | | | | | | | | | |
| 120 | 141A6241-10 | | . | | | | | | | | 1 |
| 125 | NAS8203A10 | | . | | | | | | | | 28 |
| 130 | NAS1149D0316J | | . | | | | | | | | 28 |
| 135 | 141A6241-13 | | . | | | | | | | A | 1 |
| -135A | 141A6241-19 | | . | | | | | | | | 1 |
| | | | | | | | | | | | |
| 140 | 141A6241-14 | | . | | | | | | | A | 1 |
| -140A | 141A6241-18 | | . | | | | | | | | 1 |
| | | | | | | | | | | | |
| 145 | 141A6241-11 | | . | | | | | | | A | 1 |

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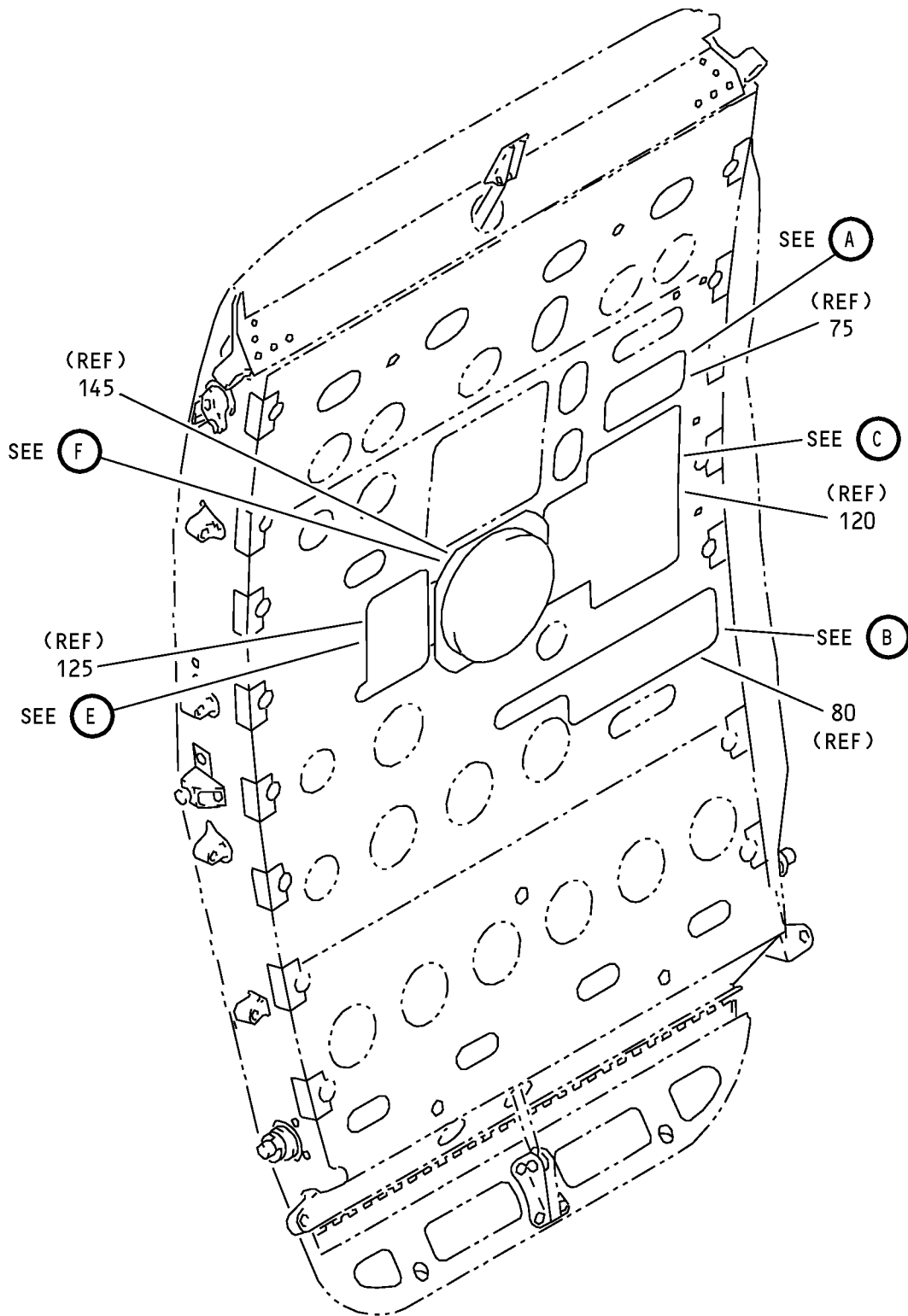
COMPONENT MAINTENANCE MANUAL

| FIG/ ITEM | PART NUMBER | AIRLINE PART NUMBER | NOMENCLATURE | | | | | | | USAGE CODE | UNITS PER ASSY |
|--------------|-------------|---------------------------|--------------|---|---|---|---|---|---|---------------|----------------------|
| | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | | |
| 9- | | | | | | | | | | | |
| -145A | 141A6241-16 | | | | | | | | | | 1 |
| 150 | 141A6241-12 | | | | | | | | | A | 1 |
| -150A | 141A6241-17 | | | | | | | | | | 1 |
| 155 | 141A6242-1 | | | | | | | | | | 1 |
| 160 | 50-9369-1 | | | | | | | | | | 1 |

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Inner Skin Installation
IPL Figure 10 (Sheet 1 of 7)

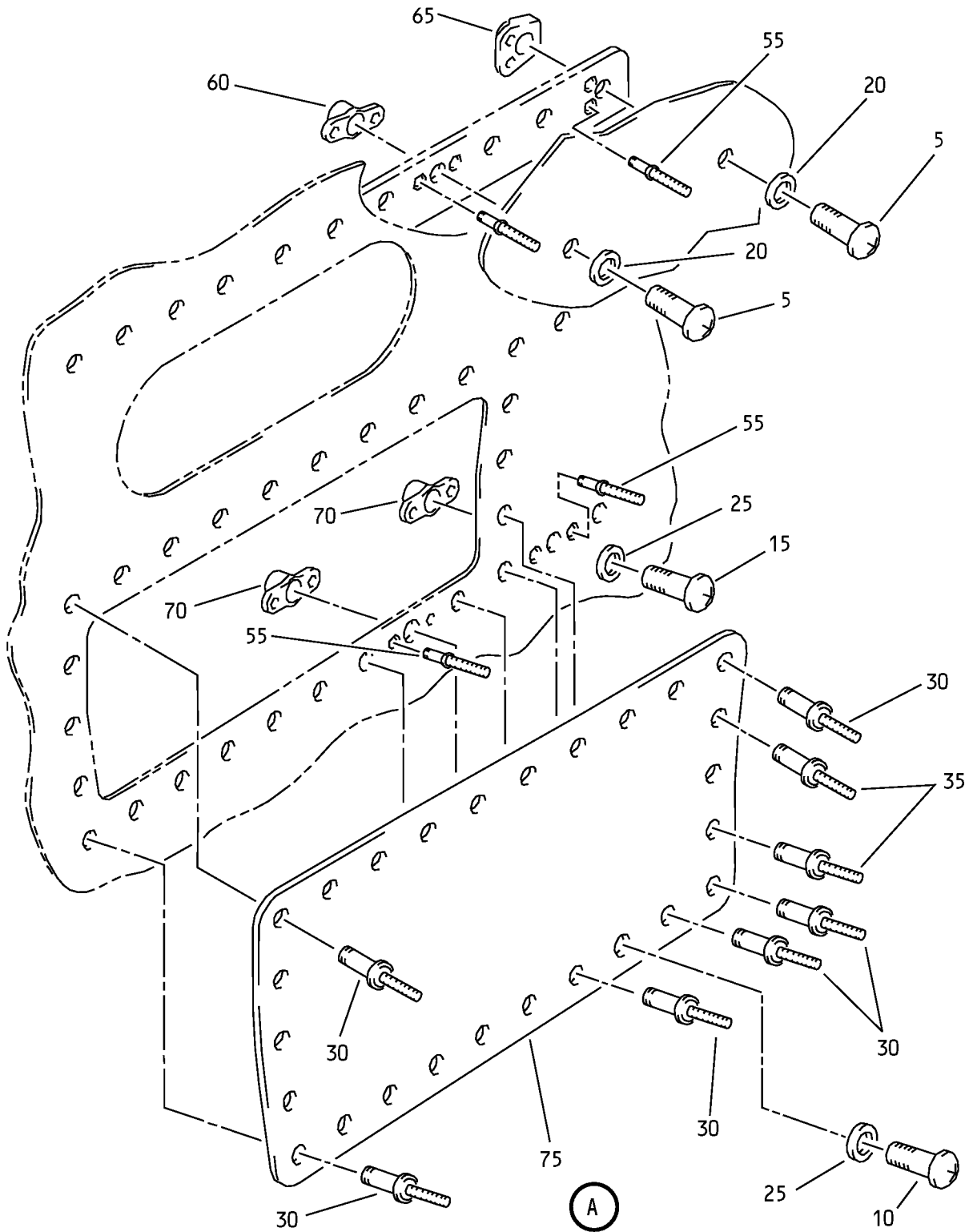
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Inner Skin Installation
IPL Figure 10 (Sheet 2 of 7)

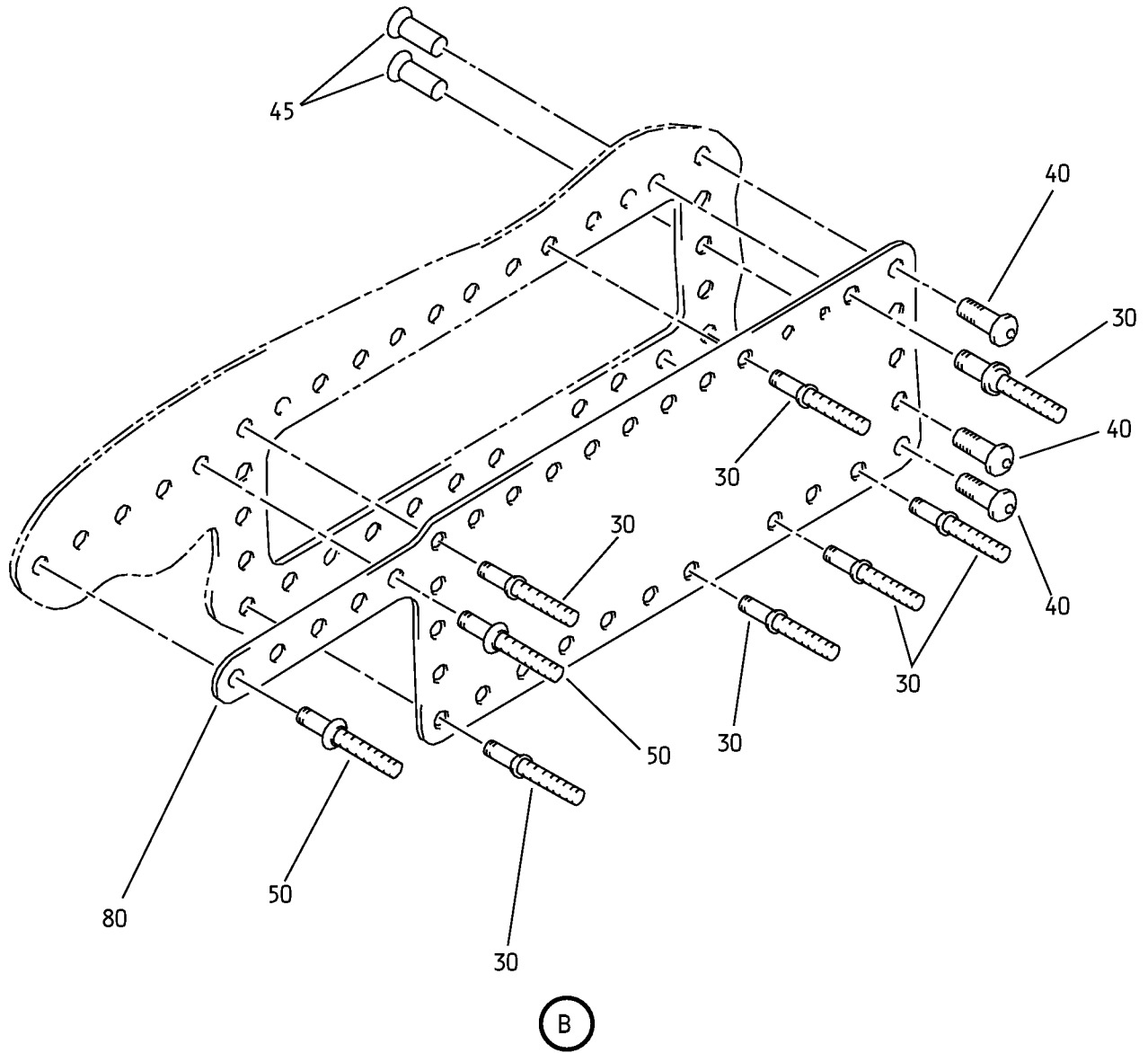
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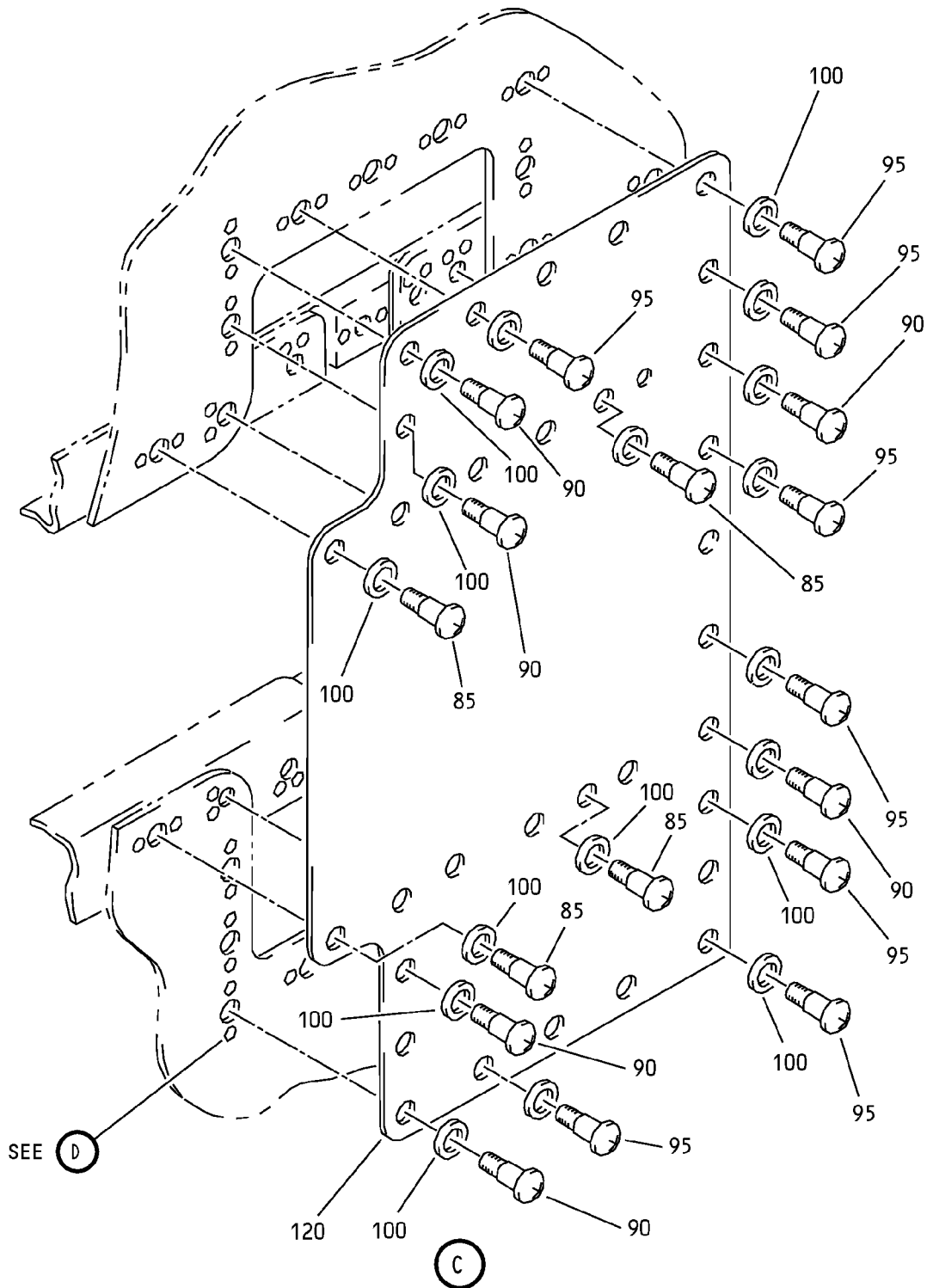
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Inner Skin Installation
IPL Figure 10 (Sheet 3 of 7)

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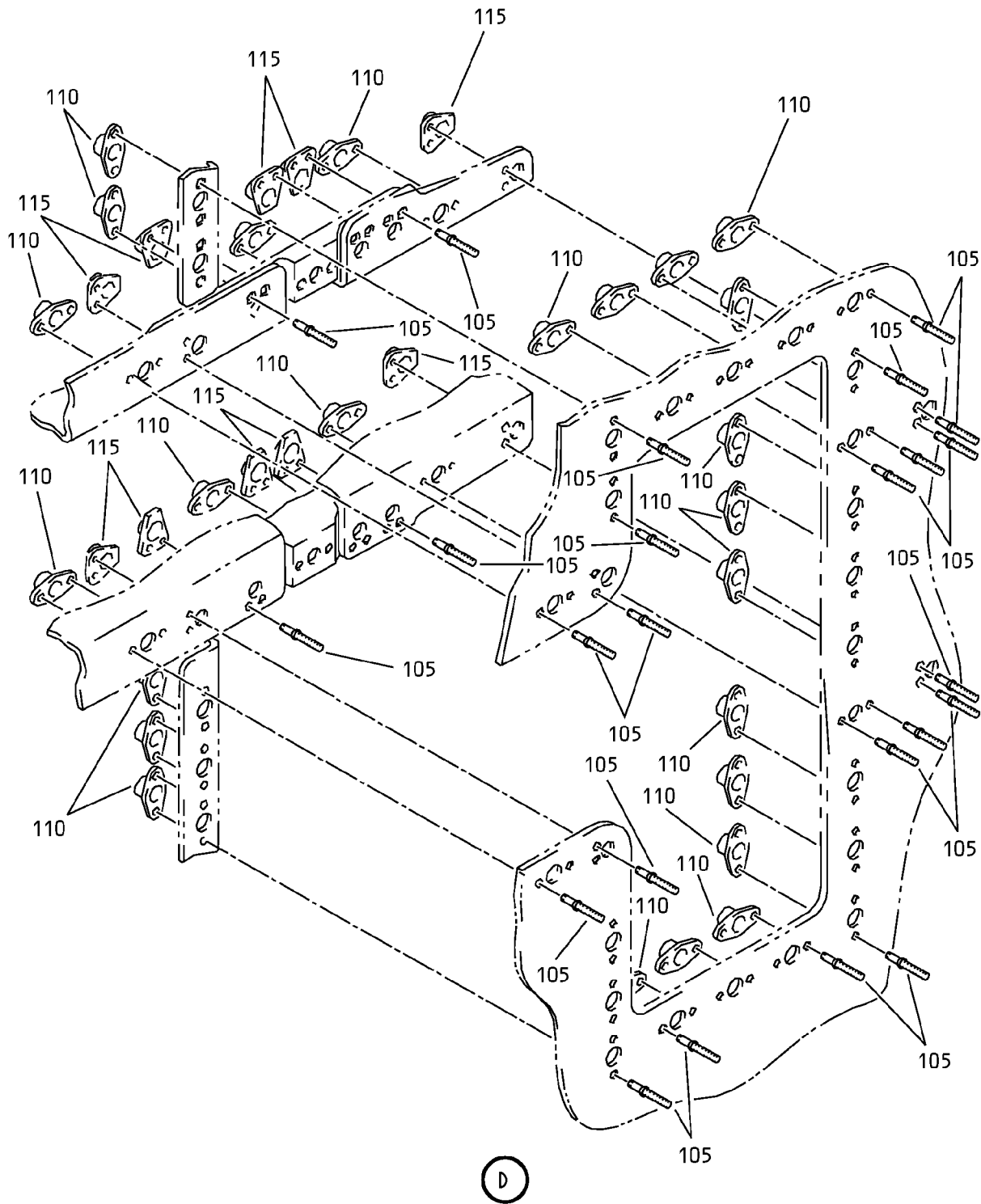
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Inner Skin Installation
IPL Figure 10 (Sheet 4 of 7)

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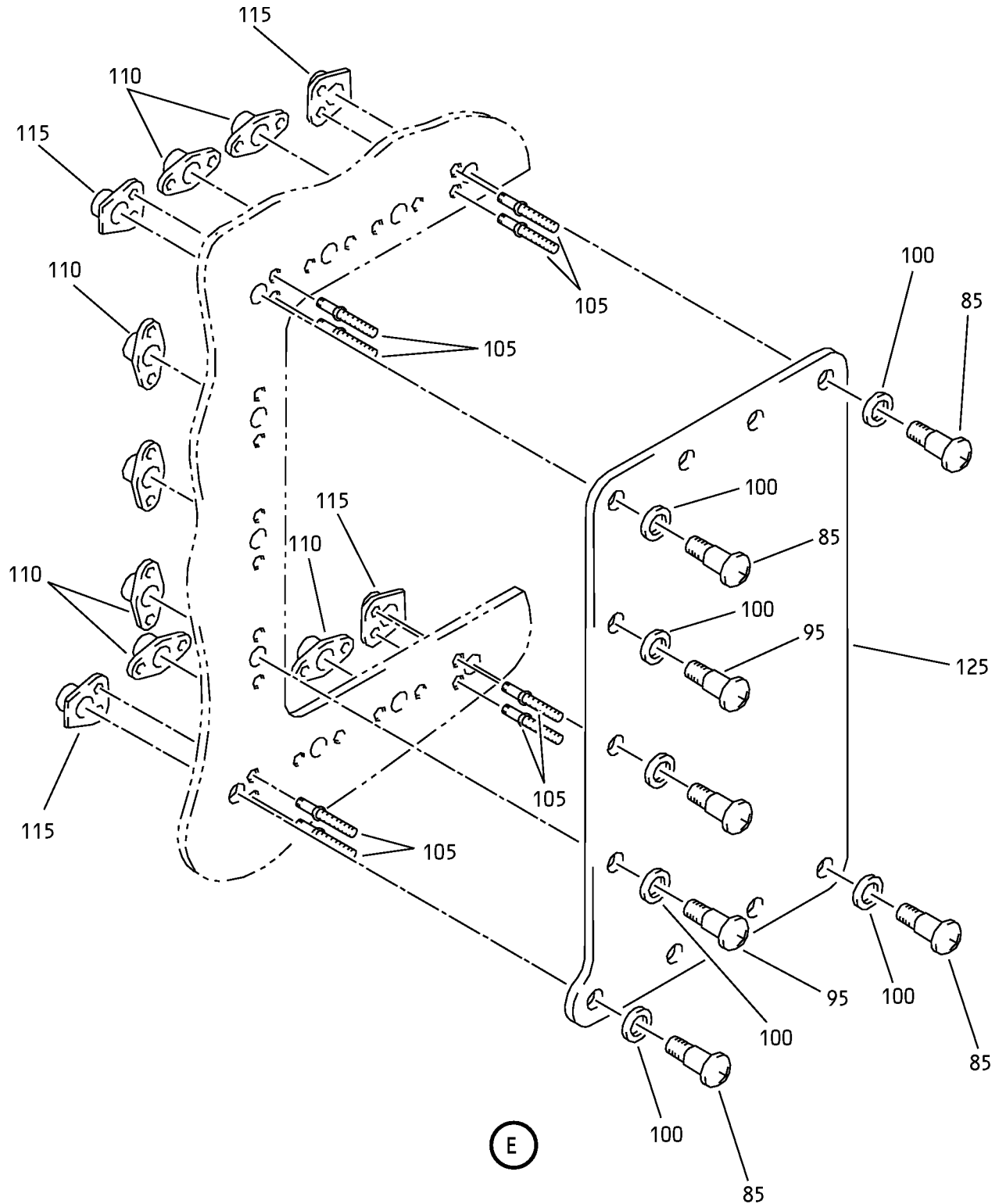
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Inner Skin Installation
IPL Figure 10 (Sheet 5 of 7)

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Inner Skin Installation
IPL Figure 10 (Sheet 6 of 7)

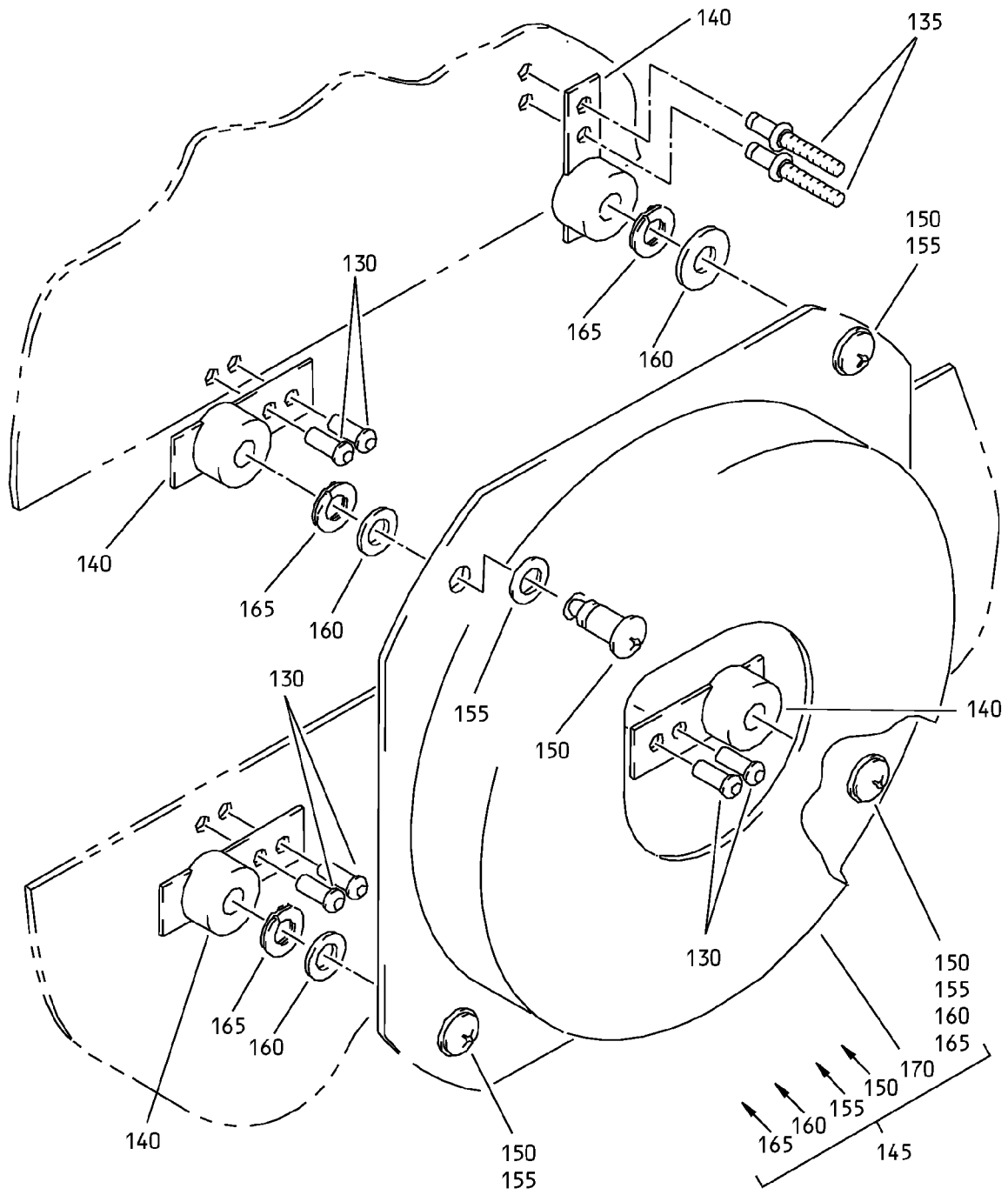
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Inner Skin Installation
IPL Figure 10 (Sheet 7 of 7)

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| FIG/ ITEM | PART NUMBER | AIRLINE PART NUMBER | NOMENCLATURE | | | | | | | USAGE CODE | UNITS PER ASSY |
|--------------|---------------|---------------------------|--------------|---|---|---|---|---|---|---------------|----------------------|
| | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | | |
| 10- | | | | | | | | | | | |
| -1A | 141A6260-1 | | | | | | | | | A | RF |
| -1B | 141A6260-2 | | | | | | | | | A | RF |
| -1C | 141A6260-2 | | | | | | | | | B-J | RF |
| 5 | BACB30NT3K4 | | | | | | | | | | 2 |
| 10 | BACB30NT2K3 | | | | | | | | | | 1 |
| 15 | BACB30NT2K2 | | | | | | | | | | 1 |
| 20 | NAS1149D0332J | | | | | | | | | | 2 |
| 25 | NAS1149DN832J | | | | | | | | | | 2 |
| 30 | MS21141U5P2 | | | | | | | | | | 46 |
| 35 | MS21141U5P1 | | | | | | | | | | 3 |
| 40 | BACR15FT5D | | | | | | | | | | 3 |
| 45 | BACR15GF5D | | | | | | | | | | 2 |
| 50 | AF3253-6-3B | | | | | | | | | | 5 |
| 55 | AF5141-3C | | | | | | | | | | 8 |
| 60 | BR2000C3D | | | | | | | | | | 1 |
| 65 | 102F9209M3 | | | | | | | | | | 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 | | |
| 10- 70 | K51601-08BAC | | . | NUTPLATE (V15653) (SPEC BACN10JR08CD) (OPT NS202439-82 (V80539)) (OPT 102A9201-82 (V72962)) (OPT BR2000C08D (V52828)) | | | | | | | 2 |
| 75 | 141A6264-2 | | . | PANEL-ACCESS | | | | | | | 1 |
| 80 | 141A6264-3 | | . | PANEL-ACCESS | | | | | | | 1 |
| 85 | BACB30NT3K4 | | . | BOLT | | | | | | | 18 |
| 90 | BACB30NT3K3 | | . | BOLT | | | | | | | 7 |
| 95 | BACB30NT3K2 | | . | BOLT | | | | | | | 17 |
| 100 | NAS1149D0332J | | . | WASHER | | | | | | | 42 |
| 105 | AF5141-3C | | . | RIVET (V53551) (SPEC BACR15DR3AC) (SIZE DETERMINED ON INST) | | | | | | | 92 |
| 110 | BRF200C3D | | . | NUTPLATE (V52828) (SPEC BACN10JR3CFD) (OPT K51602-3BAC (V15653)) (OPT NS202476-02 (V80539)) (OPT 102F9201-3 (V72962)) (OPT T8092C1032CD (V11815)) | | | | | | | 32 |
| 115 | 102F9209M3 | | . | NUTPLATE (V72962) (SPEC BACN10KH3CD) (OPT FS1651-3 (V15653)) (OPT NS202496-02 (V80539)) | | | | | | | 14 |
| 120 | 141A6264-1 | | . | PANEL-ACCESS | | | | | | | 1 |
| 125 | 141A6267-1 | | . | PANEL-ACCESS | | | | | | | 1 |
| 130 | BACR15GF5D | | . | RIVET (SIZE DETERMINED ON INST) | | | | | | | 6 |
| 135 | AF3253-6-2B | | . | RIVET (V53551) (SPEC BACR15FR6E2R) (OPT CR3253-6-2 (V11815)) | | | | | | | 2 |
| 140 | 141A6266-1 | | . | SHOCKMOUNT | | | | | | | 4 |
| 145 | 141A6265-1 | | . | COVER ASSY-CAM | | | | | | | 1 |

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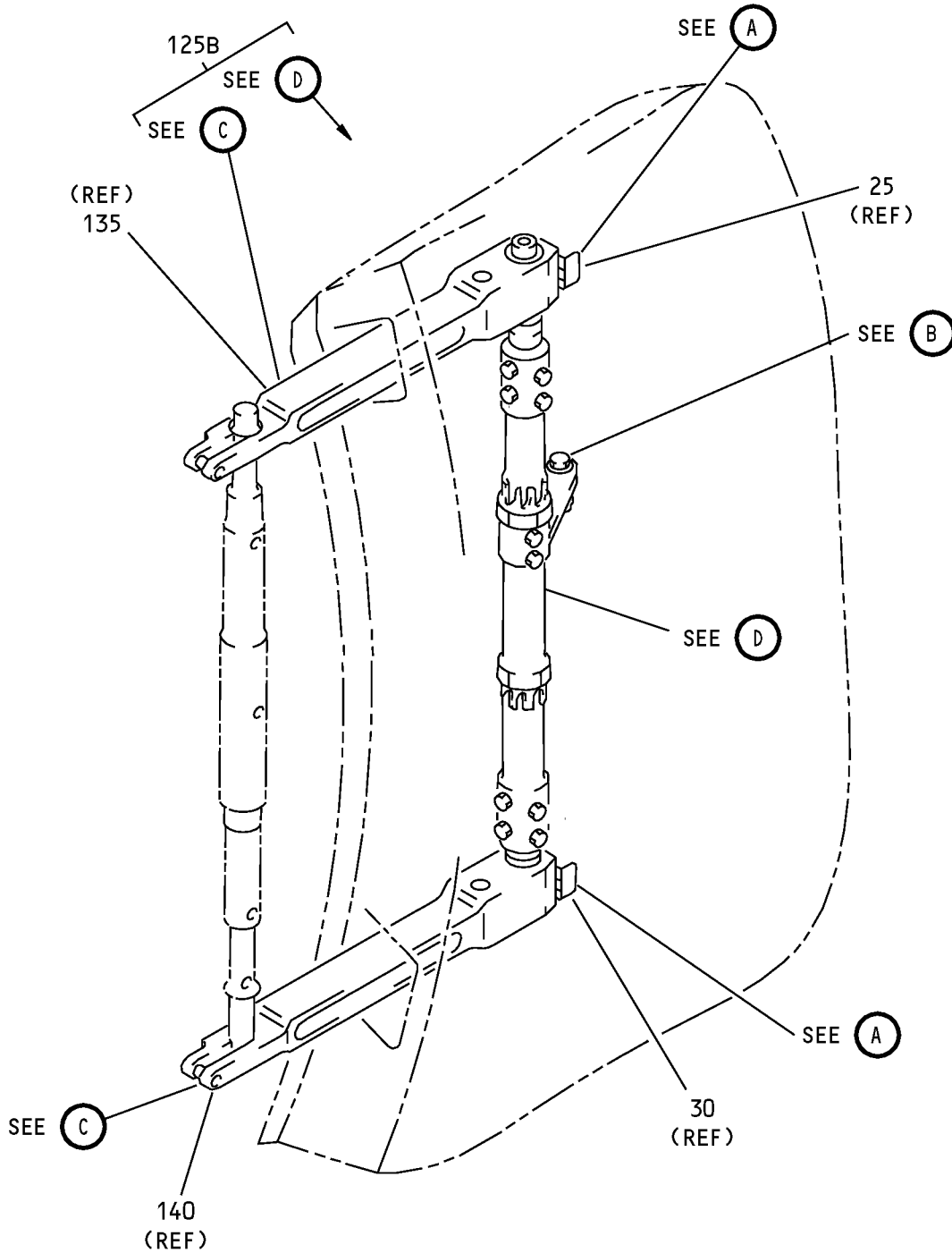
COMPONENT MAINTENANCE MANUAL

| FIG/ ITEM | PART NUMBER | AIRLINE PART NUMBER | NOMENCLATURE | | | | | | | USAGE CODE | UNITS PER ASSY |
|--------------|---------------|---------------------------|--------------|---|---|---|---|---|--|---------------|----------------------|
| | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | | |
| 10- 150 | 82-99-341-22 | | | | | | | | . . STUD (V94222) (SPEC BACS21AP220RP) | | 4 |
| 155 | NAS1149D0432J | | | | | | | | . . WASHER | | 4 |
| 160 | NAS1149D0416J | | | | | | | | . . WASHER | | 4 |
| 165 | BACR12AG2C | | | | | | | | . . RING | | 4 |
| 170 | 141A6265-2 | | | | | | | | . . COVER | | 1 |

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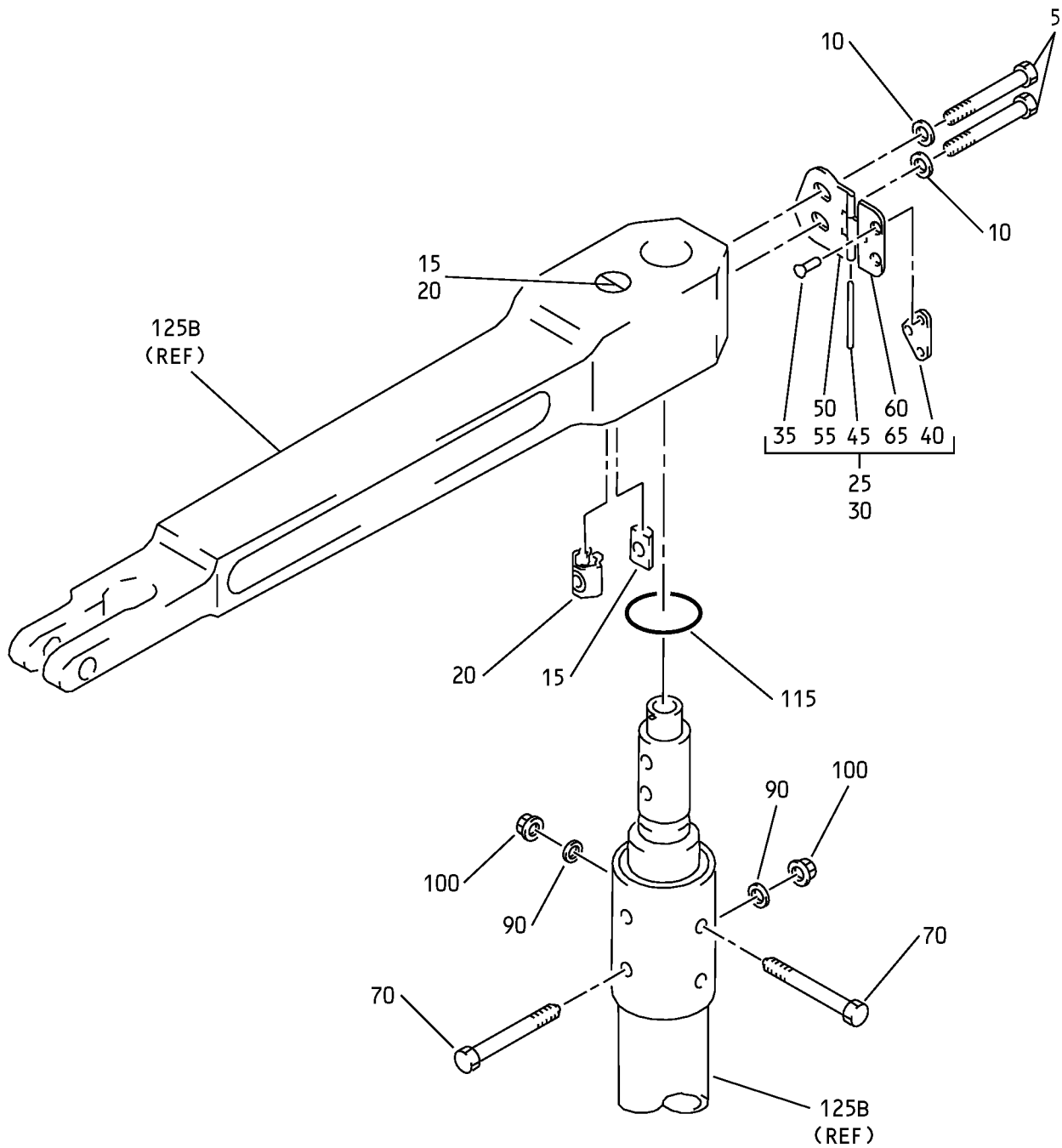
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Hinge Assembly
IPL Figure 11 (Sheet 1 of 5)

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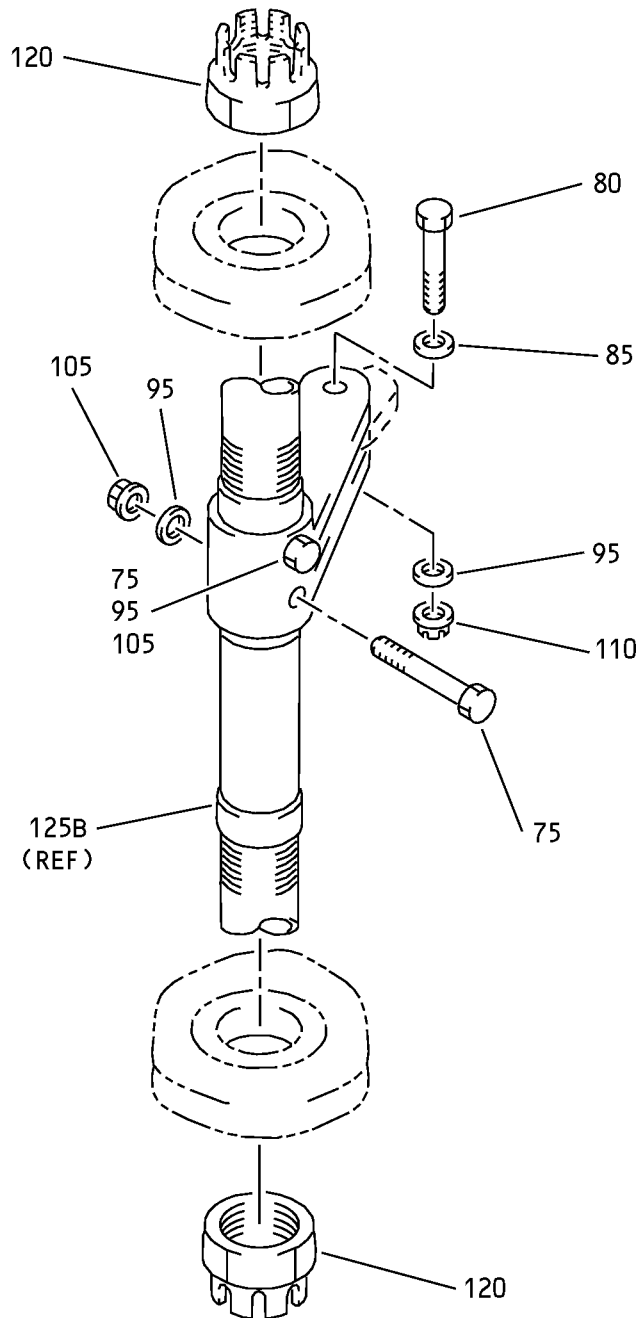


A

Hinge Assembly
IPL Figure 11 (Sheet 2 of 5)

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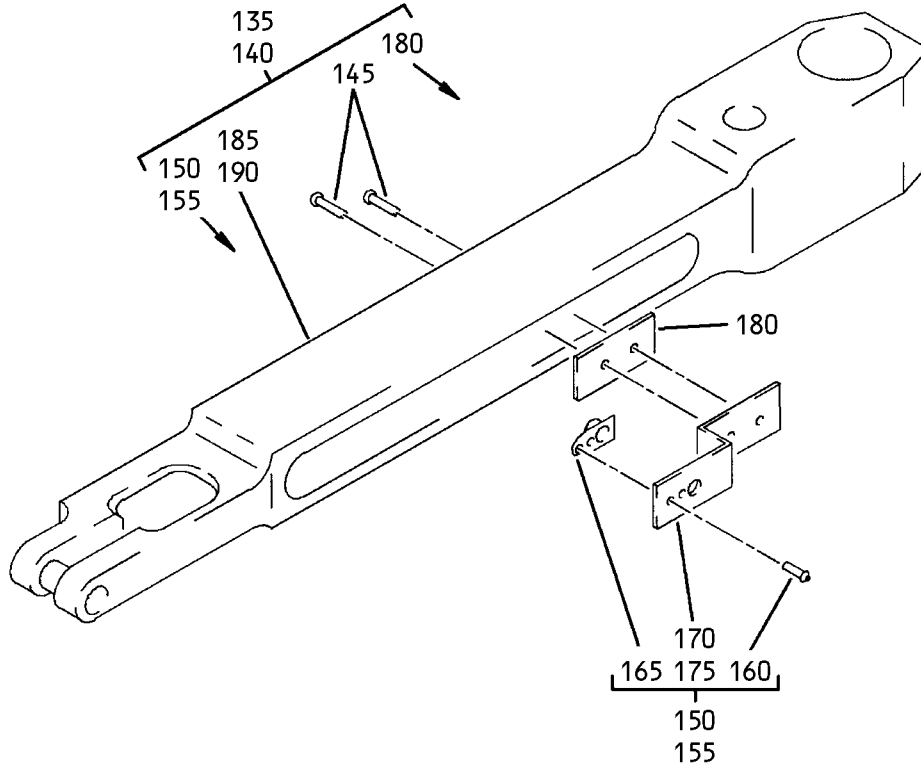
COMPONENT MAINTENANCE MANUAL



B

Hinge Assembly
IPL Figure 11 (Sheet 3 of 5)

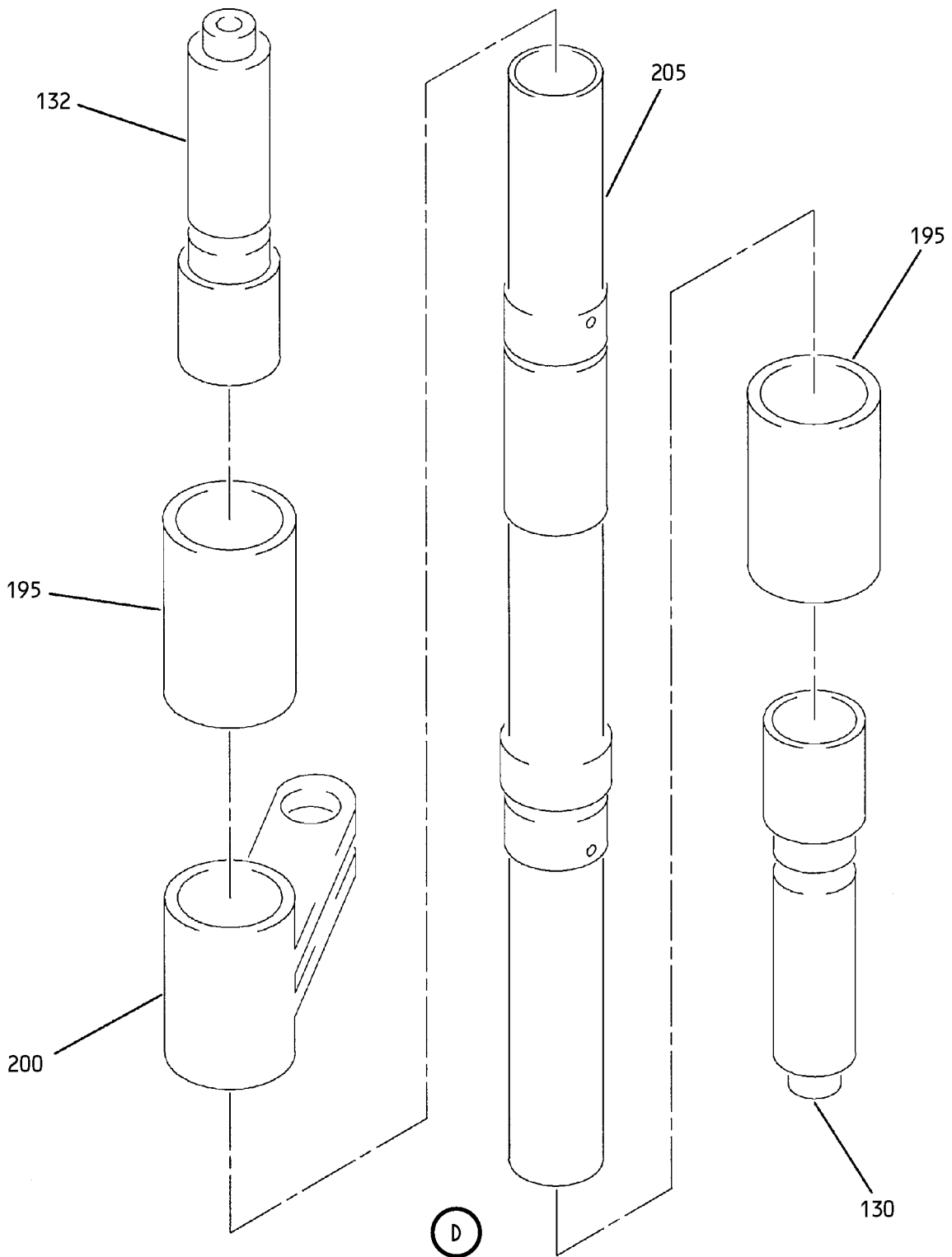
COMPONENT MAINTENANCE MANUAL



(C)

Hinge Assembly
IPL Figure 11 (Sheet 4 of 5)

COMPONENT MAINTENANCE MANUAL



Hinge Assembly
IPL Figure 11 (Sheet 5 of 5)

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| FIG/ ITEM | PART NUMBER | AIRLINE PART NUMBER | NOMENCLATURE | | | | | | | USAGE CODE | UNITS PER ASSY |
|--------------|---------------|---------------------------|--------------|---|---|---|---|---|-----|---------------|----------------------|
| | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | | |
| 11- | | | | | | | | | | | |
| -1A | 141A6280-1 | | | | | | | | | | |
| -1B | 141A6280-2 | | | | | | | | | | |
| -1C | 141A6280-3 | | | | | | | | A | RF | |
| -1D | 141A6280-4 | | | | | | | | A | RF | |
| -1E | 141A6280-4 | | | | | | | | B-J | RF | |
| 5 | BACB30NR4K24 | | | | | | | | | 4 | |
| 10 | BACW10BP4ACU | | | | | | | | | 4 | |
| 15 | NAS577B4A | | | | | | | | | 4 | |
| 20 | NAS578-4B | | | | | | | | | 4 | |
| 25 | 65C37361-1 | | | | | | | | | 1 | |
| 30 | 65C37361-2 | | | | | | | | | 1 | |
| 35 | BACR15BA3AD | | | | | | | | | 2 | |
| 40 | BR3000C3D | | | | | | | | | 1 | |
| 45 | MS20253-2-150 | | | | | | | | | 1 | |
| 50 | 65C37361-3 | | | | | | | | | 1 | |
| 55 | 65C37361-4 | | | | | | | | | 1 | |
| 60 | 65C37361-5 | | | | | | | | | 1 | |
| 65 | 65C37361-6 | | | | | | | | | 1 | |
| 70 | BACB30NR4K26 | | | | | | | | | 8 | |
| 75 | BACB30NR5K29 | | | | | | | | | 2 | |
| 80 | BACB30NR5DK14 | | | | | | | | | 1 | |
| 85 | BACW10BP5ACU | | | | | | | | | 1 | |
| 90 | NAS1149C0432R | | | | | | | | | 8 | |

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| FIG/ ITEM | PART NUMBER | AIRLINE PART NUMBER | NOMENCLATURE | | | | | | | USAGE CODE | UNITS PER ASSY |
|--------------|---------------|---------------------------|--------------|-------------------------------|---|---|---|---|---|---------------|----------------------|
| | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | | |
| 11- | | | | | | | | | | | |
| 95 | NAS1149C0532R | | . | W | A | S | H | E | R | | 3 |
| 100 | H52732-4CD | | . | N | | | | | | | 8 |
| | | | | (V15653) | | | | | | | |
| | | | | (SPEC BACN10YR4CD) | | | | | | | |
| | | | | (OPT PLH54CD (V62554)) | | | | | | | |
| 105 | H52732-5CD | | . | N | | | | | | | 2 |
| | | | | (V15653) | | | | | | | |
| | | | | (SPEC BACN10YR5CD) | | | | | | | |
| | | | | (OPT PLH55CD (V62554)) | | | | | | | |
| 110 | BACN10JD5CD | | . | N | | | | | | | 1 |
| 115 | M83461-1-210 | | . | P | A | C | K | I | N | | 2 |
| 120 | 60-4405-1 | | . | N | | S | P | E | C | | 2 |
| -125 | 141A6270-1 | | | D | E | L | E | T | E | | |
| -125A | 141A6270-2 | | | D | E | L | E | T | E | | |
| 125B | 141A6270-3 | | . | H | I | N | G | E | A | S | 1 |
| | | | | (THE 141A6270-XX HINGE ASSY'S | | | | | | | |
| | | | | CONTAIN COMPONENTS USED ON | | | | | | | |
| | | | | THE BODY OF THE AIRPLANE AND | | | | | | | |
| | | | | THE FORWARD ENTRY DOOR | | | | | | | |
| | | | | ASSEMBLY. THE BODY | | | | | | | |
| | | | | COMPONENTS ARE INCLUDED IN | | | | | | | |
| | | | | CMM 52-11-13 AND THE FORWARD | | | | | | | |
| | | | | ENTRY DOOR COMPONENTS ARE | | | | | | | |
| | | | | INCLUDED IN CMM 52-16-12.) | | | | | | | |
| | | | | (USED ON ITEM 1C) | | | | | | | |
| -125C | 141A6270-4 | | . | H | I | N | G | E | A | S | 1 |
| | | | | (THE 141A6270-XX HINGE ASSY'S | | | | | | | |
| | | | | CONTAIN COMPONENTS USED ON | | | | | | | |
| | | | | THE BODY OF THE AIRPLANE AND | | | | | | | |
| | | | | THE FORWARD ENTRY DOOR | | | | | | | |
| | | | | ASSEMBLY. THE BODY | | | | | | | |
| | | | | COMPONENTS ARE INCLUDED IN | | | | | | | |
| | | | | CMM 52-11-13 AND THE FORWARD | | | | | | | |
| | | | | ENTRY DOOR COMPONENTS ARE | | | | | | | |
| | | | | INCLUDED IN CMM 52-16-12.) | | | | | | | |
| | | | | (USED ON ITEM 1D, 1E) | | | | | | | |
| 130 | 65C37130-1 | | . | P | I | N | A | S | S | | 1 |
| | | | | (FOR SPARES PROCURE | | | | | | | |
| | | | | 65C37130Y1) | | | | | | | |
| 132 | 65C37130-2 | | . | P | I | N | | | | | 1 |

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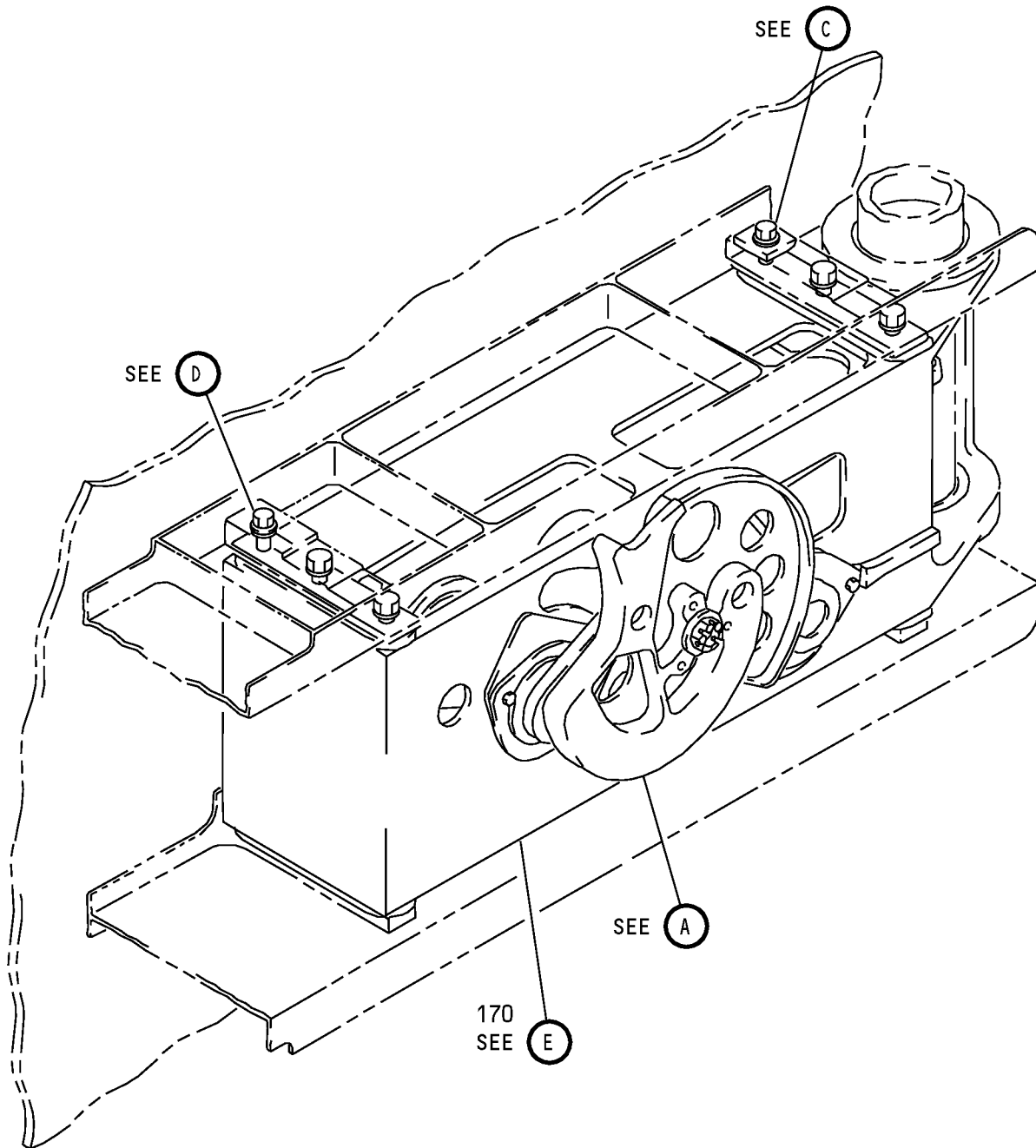


COMPONENT MAINTENANCE MANUAL

| FIG/ ITEM | PART NUMBER | AIRLINE PART NUMBER | NOMENCLATURE | | | | | | | USAGE CODE | UNITS PER ASSY |
|--------------|-------------|---------------------------|--------------|---|---|---|---|---|---|---------------|----------------------|
| | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | | |
| 11- 205 | 65C37129-1 | | | | | | | | | | 1 |

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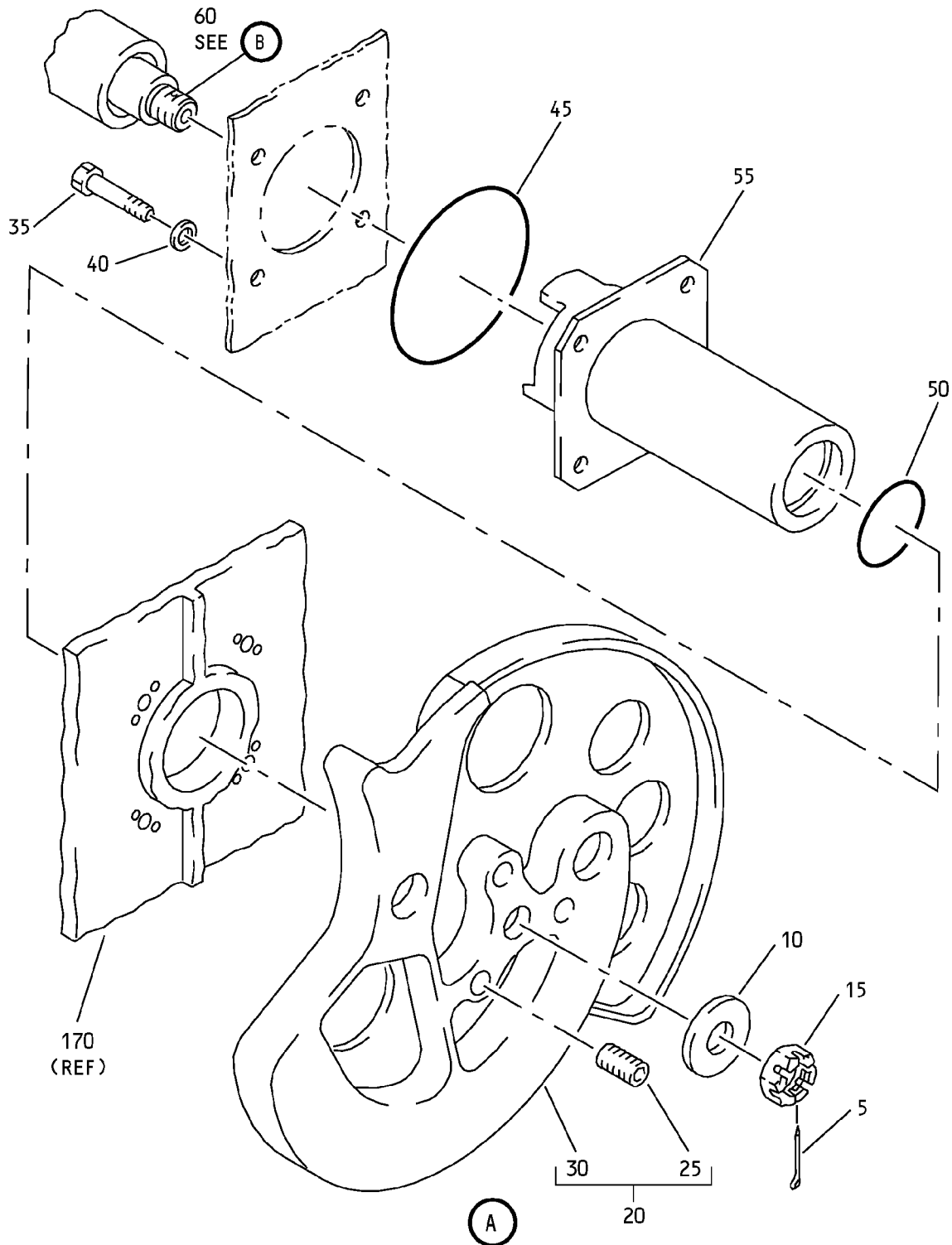
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Hinge Box Assembly
IPL Figure 12 (Sheet 1 of 9)

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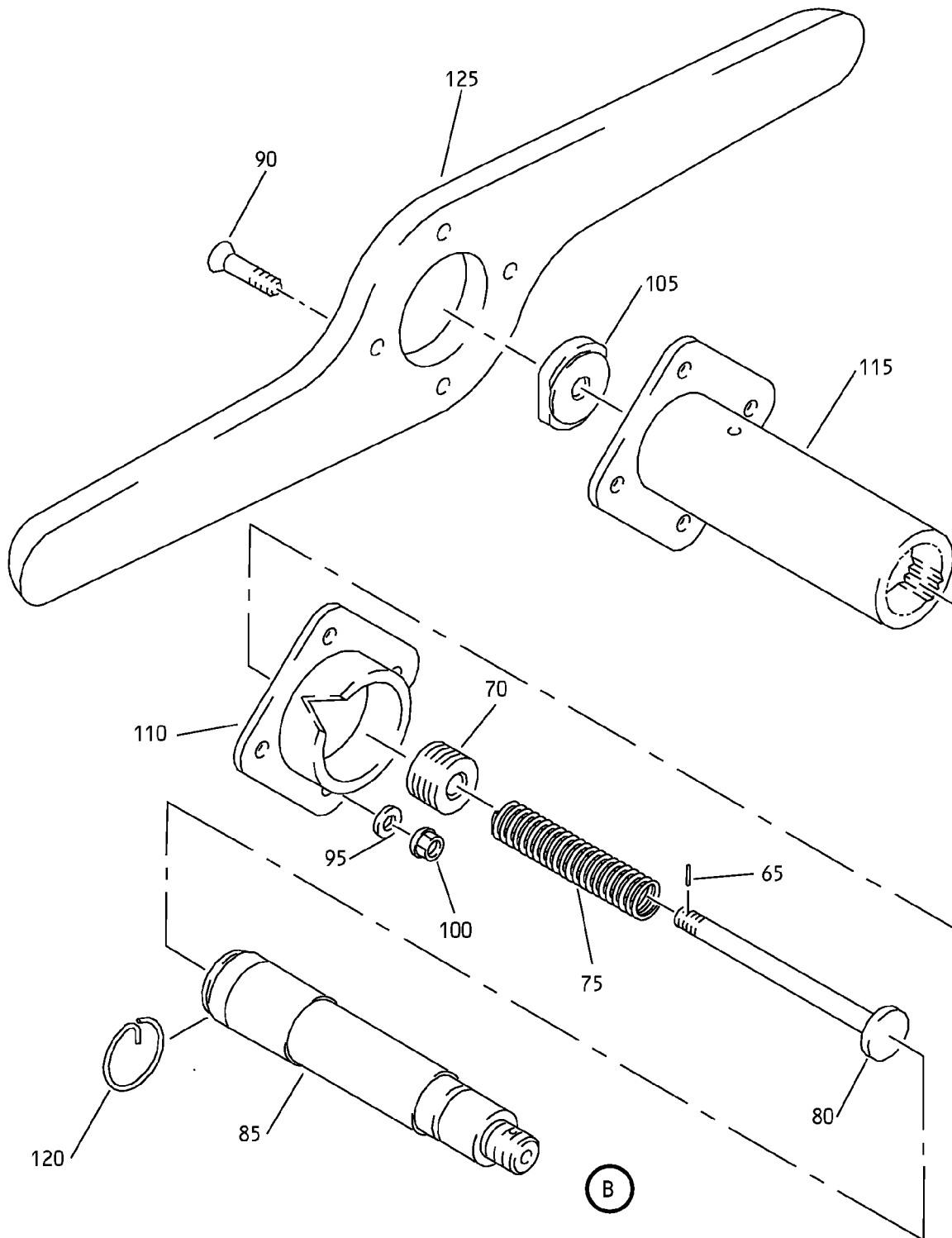
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Hinge Box Assembly
IPL Figure 12 (Sheet 2 of 9)

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Hinge Box Assembly
IPL Figure 12 (Sheet 3 of 9)

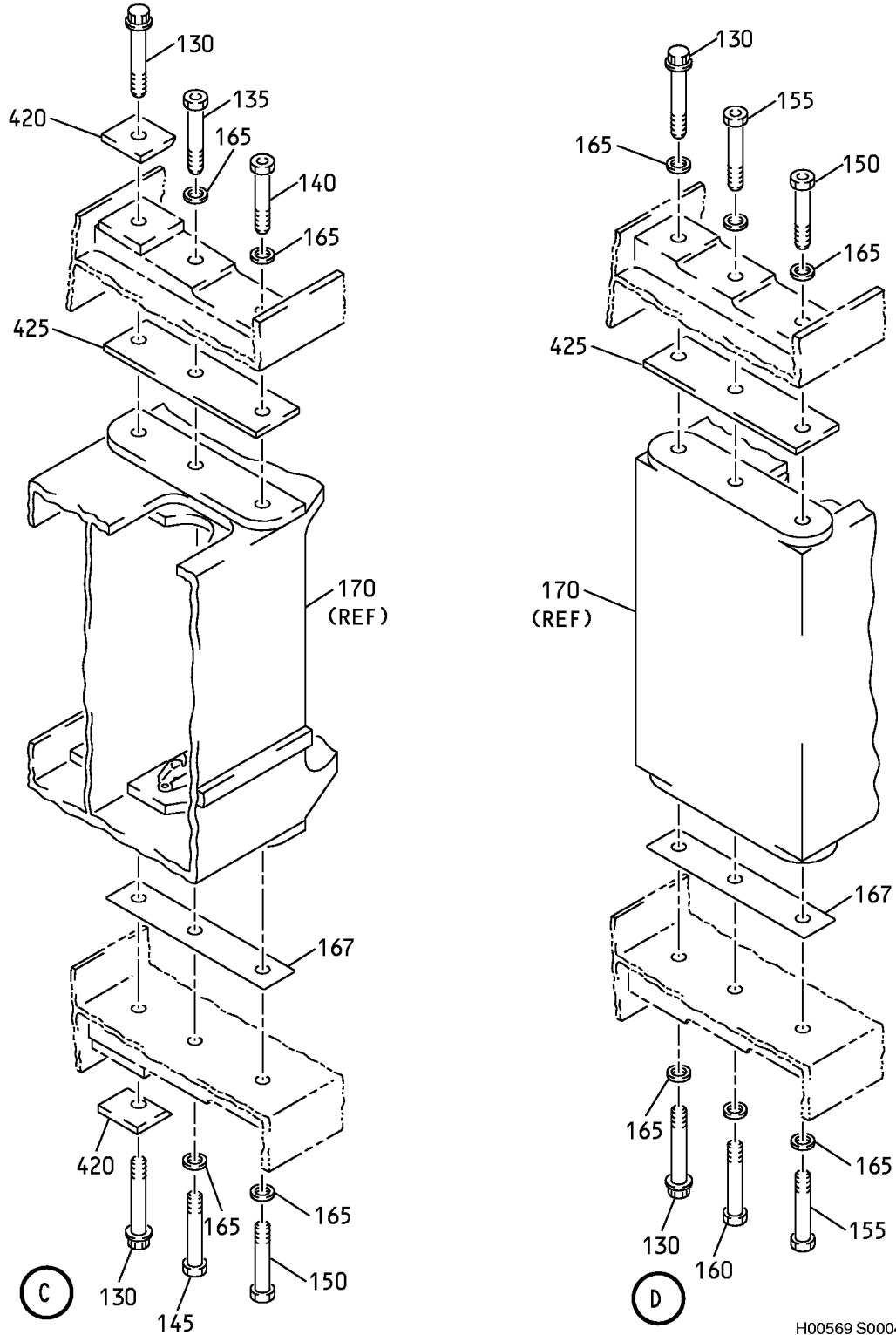
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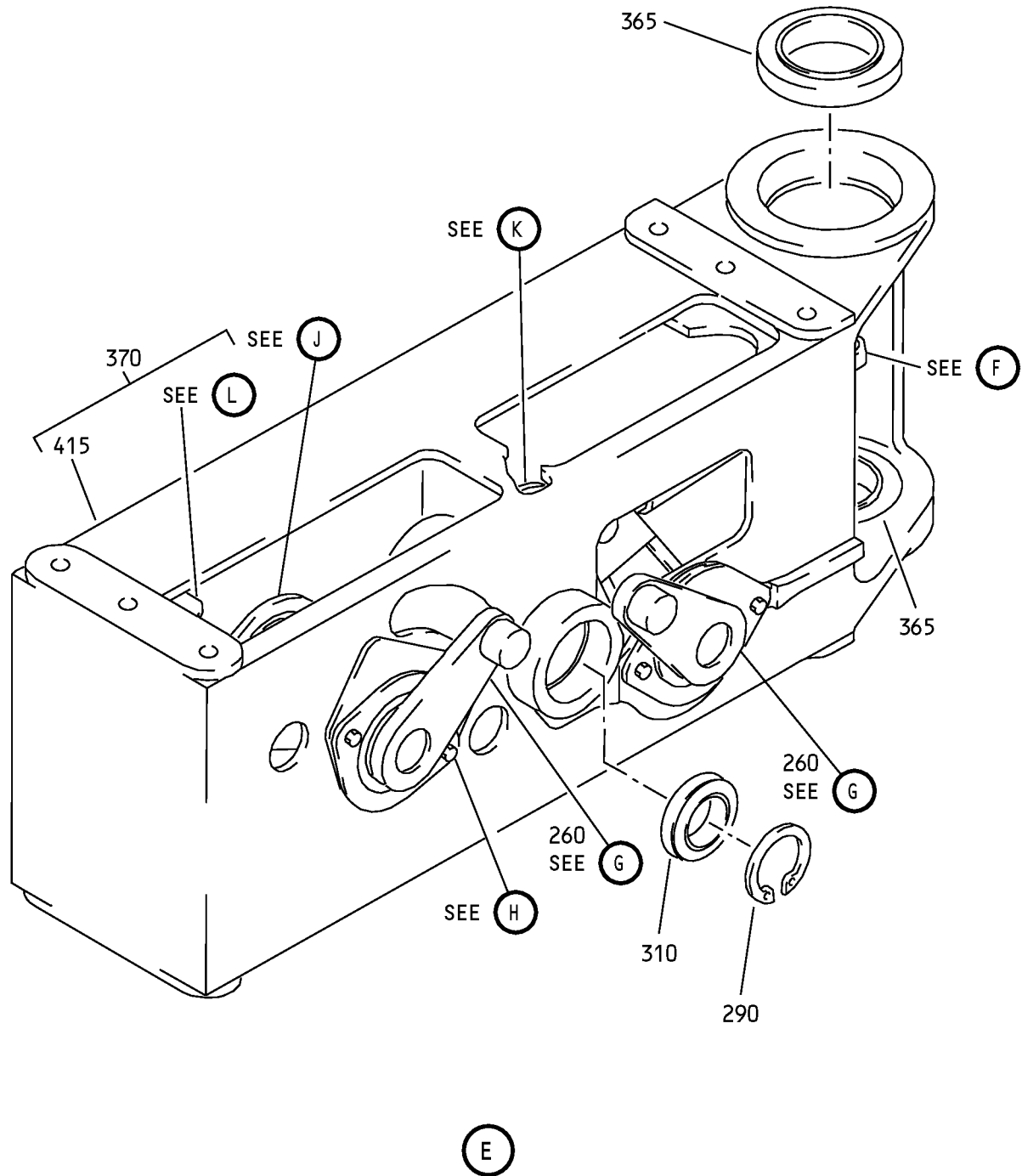


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Hinge Box Assembly
 IPL Figure 12 (Sheet 4 of 9)

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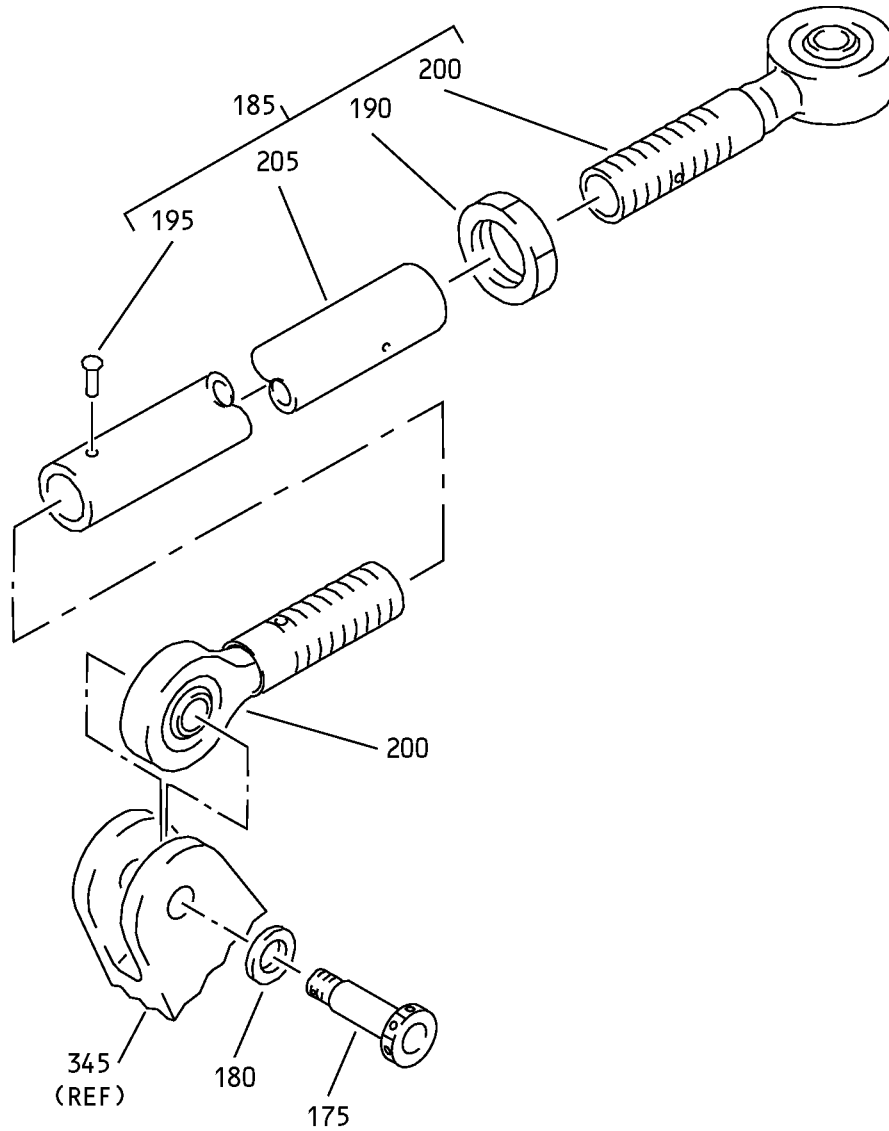
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Hinge Box Assembly
IPL Figure 12 (Sheet 5 of 9)

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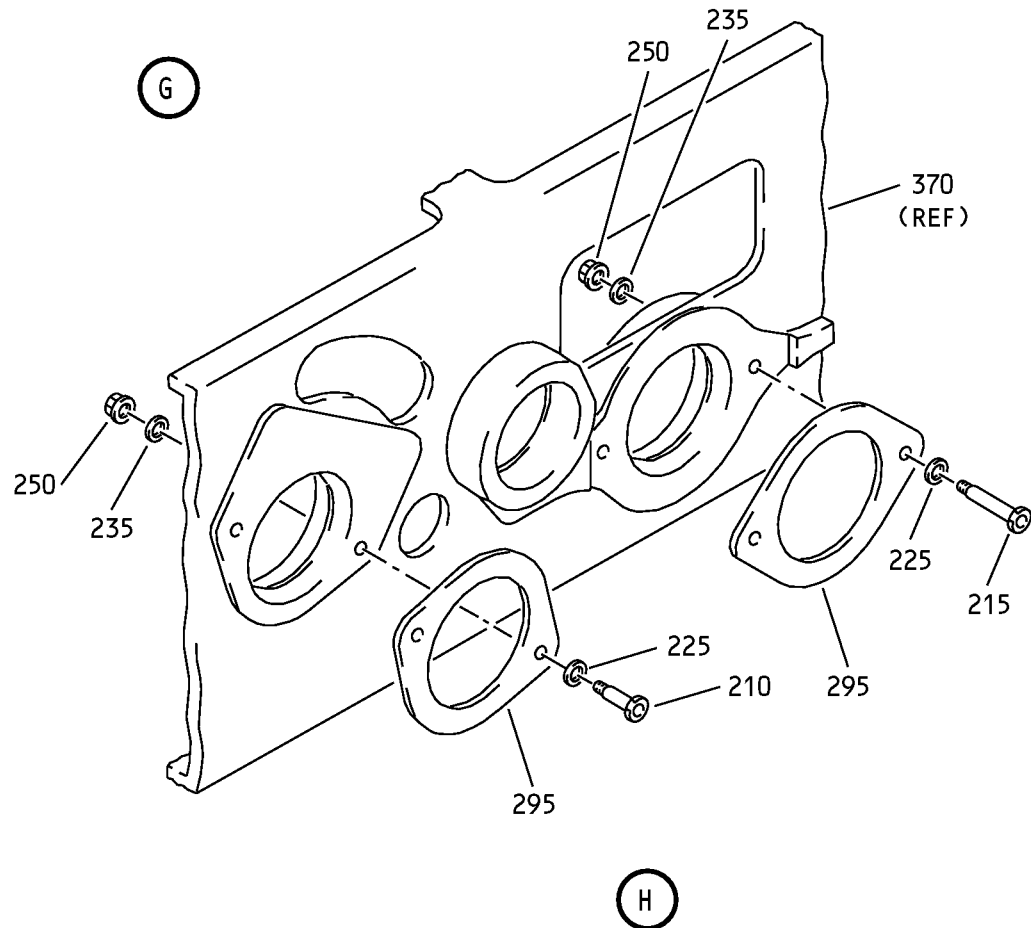
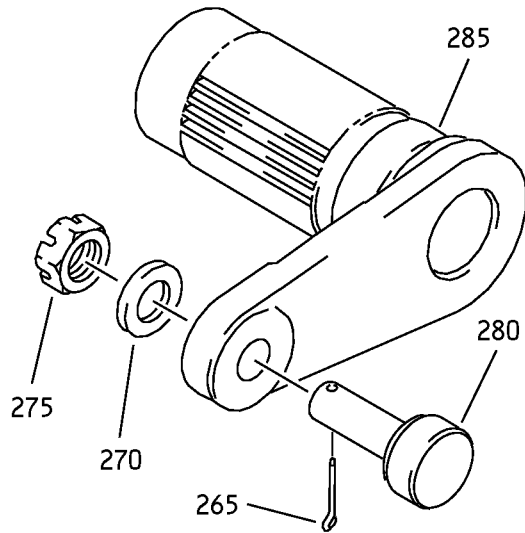
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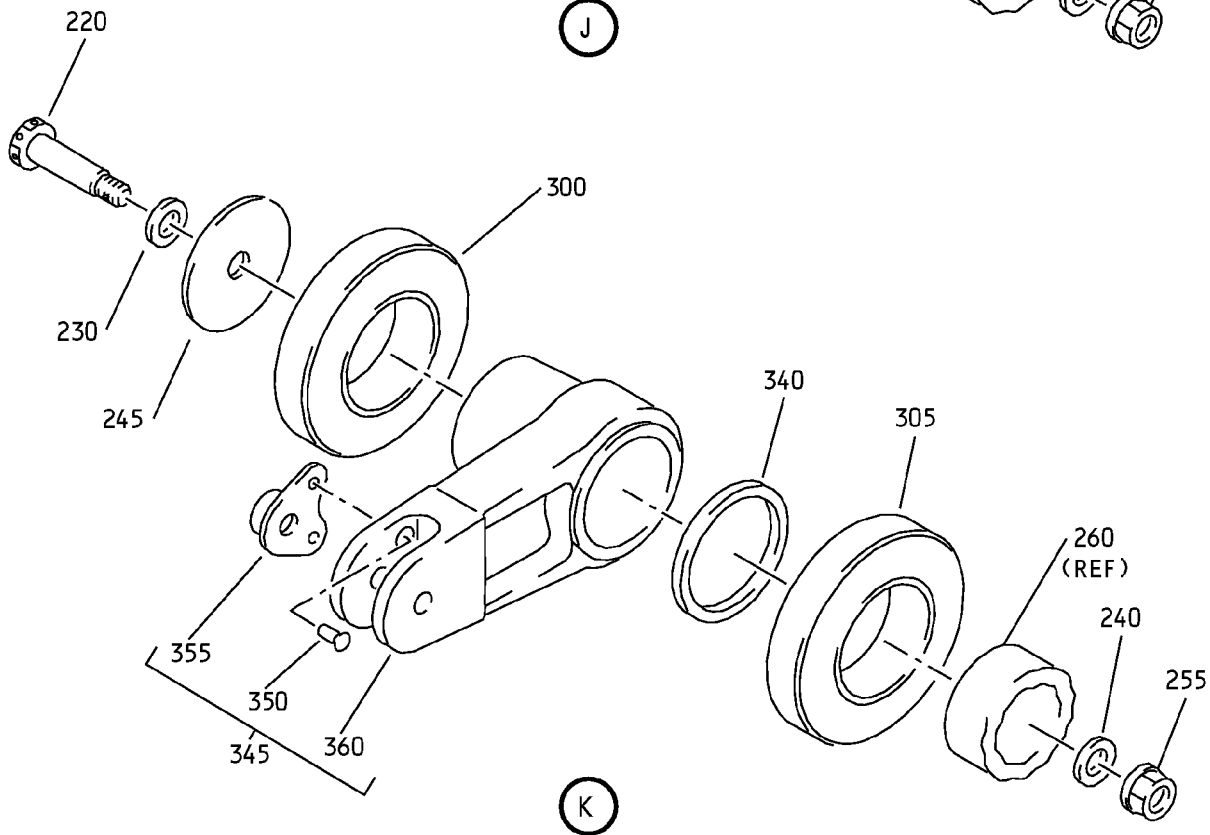
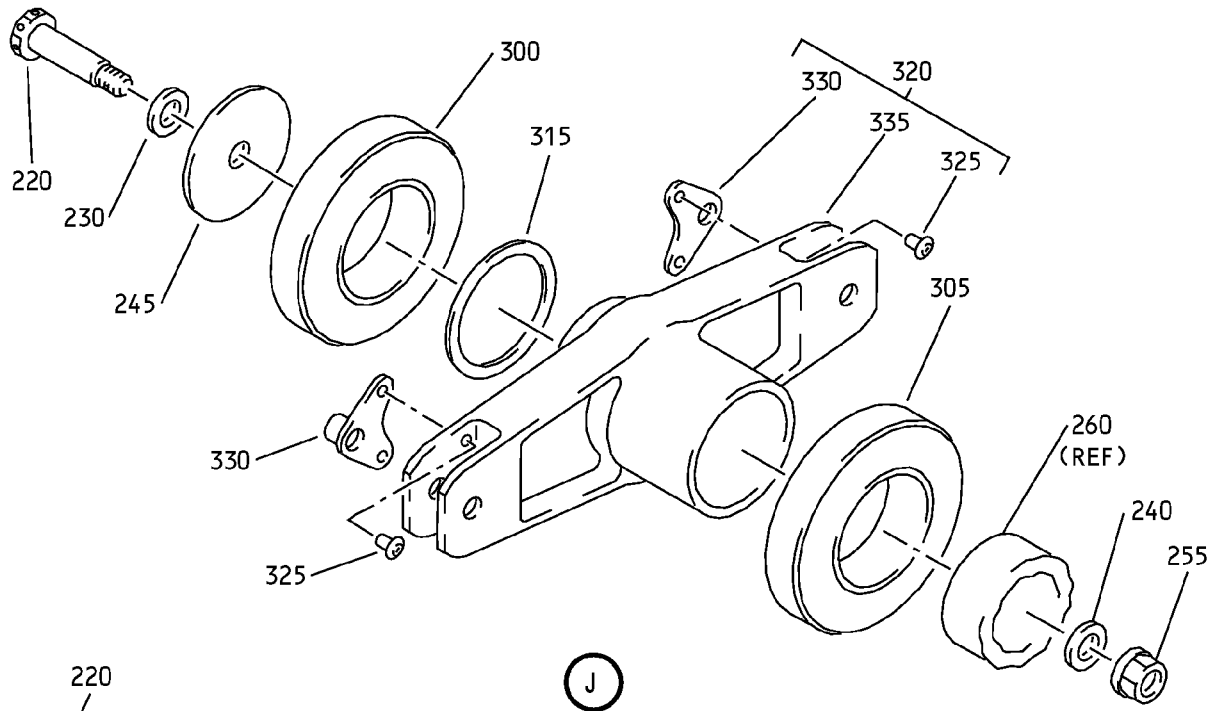
Hinge Box Assembly
IPL Figure 12 (Sheet 6 of 9)

COMPONENT MAINTENANCE MANUAL



Hinge Box Assembly
IPL Figure 12 (Sheet 7 of 9)

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Hinge Box Assembly
IPL Figure 12 (Sheet 8 of 9)

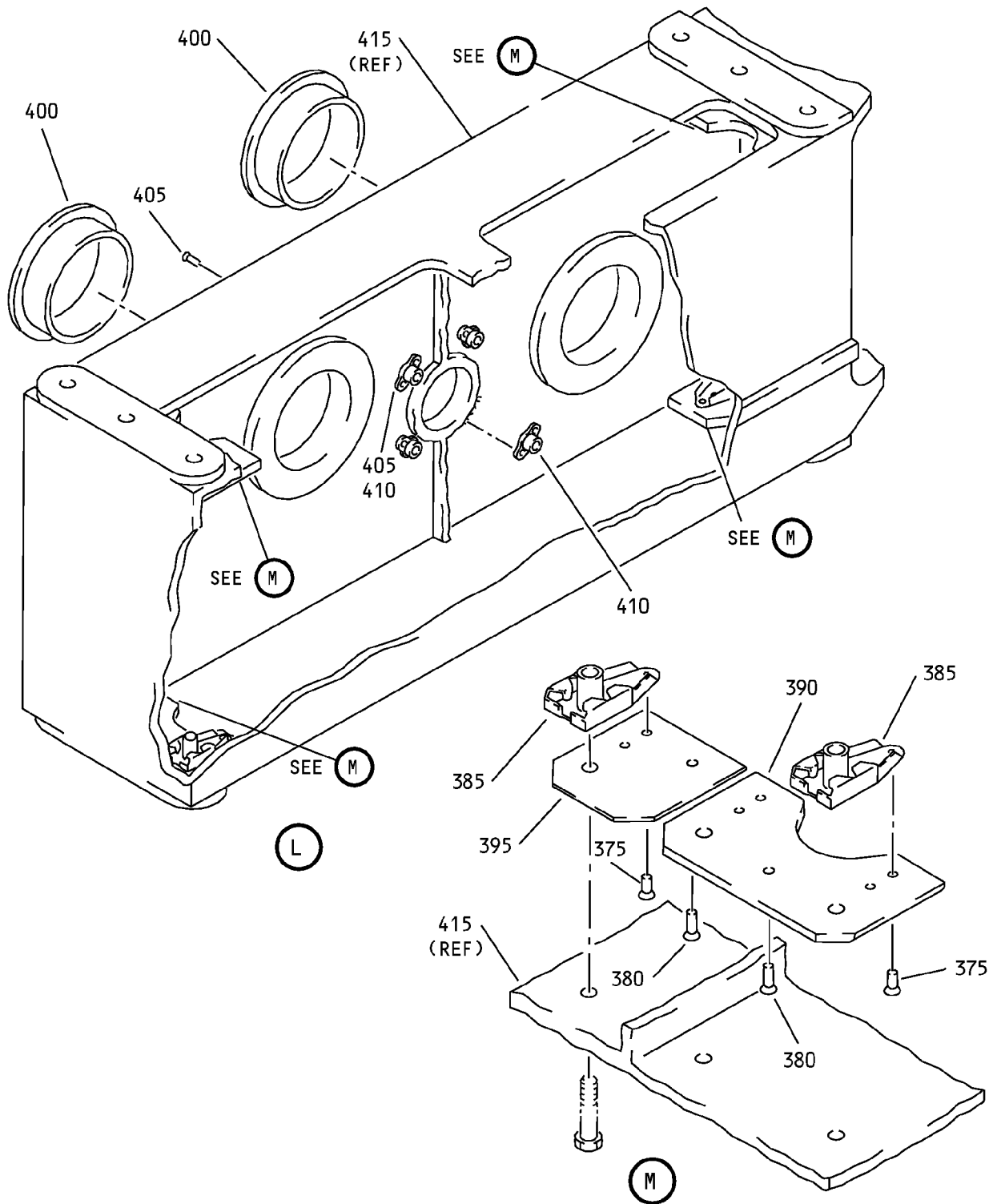
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Hinge Box Assembly
IPL Figure 12 (Sheet 9 of 9)

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| FIG/ ITEM | PART NUMBER | AIRLINE PART NUMBER | NOMENCLATURE | | | | | | | USAGE CODE | UNITS PER ASSY |
|--------------|----------------|---------------------------|--------------|---|---|---|---|---|---|---------------|----------------------|
| | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | | |
| 12- | | | | | | | | | | | |
| -1A | 141A6301-1 | | | | | | | | | A | RF |
| -1B | 141A6301-1 | | | | | | | | | B-D | RF |
| -1C | 141A6301-2 | | | | | | | | | E | RF |
| -1D | 141A6301-3 | | | | | | | | | F-J | RF |
| 5 | BACP18BC03A08P | | | | | | | | | | 1 |
| 10 | 63-9386-1 | | | | | | | | | | 1 |
| 15 | PHCR56CDBACN | | | | | | | | | | 1 |
| -15A | MS14144L6 | | | | | | | | | | 1 |
| 20 | 141A6310-3 | | | | | | | | | A-D | 1 |
| -20A | 141A6310-5 | | | | | | | | | E | 1 |
| -20B | 141A6310-7 | | | | | | | | | F-J | 1 |
| 25 | MS21209F5-20 | | | | | | | | | | 3 |
| 30 | 141A6310-4 | | | | | | | | | A-D | 1 |
| -30A | 141A6310-6 | | | | | | | | | E | 1 |
| -30B | 141A6310-8 | | | | | | | | | F-J | 1 |
| 35 | BACB30NM3K11 | | | | | | | | | | 4 |
| 40 | BACW10BP3CD | | | | | | | | | | 4 |
| 45 | M83461-1-325 | | | | | | | | | | 1 |
| 50 | M83461-1-212 | | | | | | | | | | 1 |
| 55 | 69-61511-2 | | | | | | | | | | 1 |
| 60 | 65C37364-3 | | | | | | | | | | 1 |
| 65 | MS39086-111 | | | | | | | | | | 1 |
| 70 | 30-3010 | | | | | | | | | | 1 |
| 75 | 63-2848 | | | | | | | | | | 1 |
| 80 | 30-3013-2 | | | | | | | | | | 1 |
| 85 | 60-4455-3 | | | | | | | | | | 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 | | |
| 12- | | | | | | | | | | | |
| 90 | BACB30LH3-7 | | . | . | | | | | | | 4 |
| 95 | NAS1149E0363R | | . | . | | | | | | | 4 |
| 100 | H52732-3CD | | . | . | | | | | | | 4 |
| | | | | | | | | (V15653) | | | |
| | | | | | | | | (SPEC BACN10YR3CD) | | | |
| | | | | | | | | (OPT PLH53CD (V62554)) | | | |
| 105 | 30-3019-1 | | . | . | | | | | | | 1 |
| 110 | 90-7811 | | . | . | | | | | | | 1 |
| 115 | 90-7821-1 | | . | . | | | | | | | 1 |
| 120 | AN996-14 | | . | . | | | | | | | 1 |
| 125 | 90-7879-7 | | . | . | | | | | | | 1 |
| 130 | BACB30MR4K20 | | . | | | | | | | | 4 |
| 135 | BACB30NM4K15 | | . | | | | | | | | 1 |
| 140 | BACB30NM4K14 | | . | | | | | | | | 1 |
| 145 | BACB30NM4K17 | | . | | | | | | | | 1 |
| 150 | BACB30NM4K16 | | . | | | | | | | | 2 |
| 155 | BACB30NM4K18 | | . | | | | | | | | 2 |
| 160 | BACB30NM4K19 | | . | | | | | | | | 1 |
| 165 | BACW10BP4CD | | . | | | | | | | | 10 |
| 167 | BACS40R008B041F | | . | | | | | | | F-J | AR |
| 170 | 141A6303-1 | | . | | | | | | | A-D | 1 |
| -170A | 141A6303-2 | | . | | | | | | | E-J | 1 |
| 175 | BACB30NR5K16 | | . | . | | | | | | | 1 |
| 180 | BACW10BP5CD | | . | . | | | | | | | 1 |
| 185 | 60-7208-3 | | . | . | | | | | | | 1 |
| 190 | AN316-8R | | . | . | . | | | | | | 1 |
| 195 | NAS508M6 | | . | . | . | | | | | | 1 |
| | | | | | | | | | | | (SIZE DETERMINED ON INST) |

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| FIG/ ITEM | PART NUMBER | AIRLINE PART NUMBER | NOMENCLATURE | | | | | | | USAGE CODE | UNITS PER ASSY |
|--------------|----------------|---------------------------|--------------|---|---|---|---|---|-----|---------------|----------------------|
| | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | | |
| 12- 200 | KBDE5-15 | | . . . | BEARING-ROD END (V97613) (SPEC 10-60779-164) (OPT TFM105A (V77896)) (OPT DREM5-023 (V81376)) (OPT REM10ATC16-2 (V21335)) (OPT 77266 (V09455)) (OPT NHNE5-208 (V15860)) (OPT MSSR58-14BAC (V73134)) (OPT ART5E108 (VS0352)) | | | | | | | 2 |
| 205 | 60-7208-4 | | . . . | ROD (OPT ITEM 205A) | | | | | | | 1 |
| -205A | 60-7208-5 | | . . . | ROD (OPT ITEM 205) | | | | | | | 1 |
| 210 | BACB30NM3K6 | | . . | BOLT | | | | | | | 2 |
| 215 | BACB30NM3K11 | | . . | BOLT (V06710) (SPEC BACB30NM3K11) | | | | | | | 2 |
| 220 | BACB30NR4K4 | | . . | BOLT | | | | | | | 2 |
| 225 | BACW10BP3CD | | . . | WASHER | | | | | | | 4 |
| 230 | BACW10BP4CD | | . . | WASHER | | | | | | | 2 |
| 235 | NAS1149D0363J | | . . | WASHER | | | | | | | 4 |
| 240 | NAS1149C0432R | | . . | WASHER | | | | | | | 2 |
| 245 | 63-1692-1 | | . . | WASHER-BRG RTNR | | | | | | | 2 |
| 250 | H52732-3CD | | . . | NUT (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554)) | | | | | | | 4 |
| 255 | H52732-4CD | | . . | NUT (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554)) | | | | | | | 2 |
| 260 | 141A6306-1 | | . . | CRANK ASSY-CAM FOLLOWER | | | | | A-D | | 2 |
| -260A | 141A6306-4 | | . . | CRANK ASSY-CAM FOLLOWER | | | | | E-J | | 2 |
| 265 | BACP18BC03A10P | | . . . | PIN-COTTER | | | | | | | 1 |
| 270 | NAS1149E0632R | | . . . | WASHER | | | | | | | 1 |
| 275 | BACN10JD106ASU | | . . . | NUT | | | | | | | 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 | | | |
| 12- 280 | HRSC4CFR6 | | . . . | BEARING | | | | | | | A-D | 1 |
| | | | | (V60380) | | | | | | | | |
| | | | | (SPEC BACB10FK6F6HS) | | | | | | | | |
| | | | | (OPT CHRS4CFR6 (V92563)) | | | | | | | | |
| | | | | (OPT CHRS4CFR6 (V07484)) | | | | | | | | |
| -280A | AHRSC4CFR6 | | . . . | BEARING | | | | | | | C-J | 1 |
| | | | | (V60380) | | | | | | | | |
| | | | | (SPEC BACB10GS06FJ6) | | | | | | | | |
| | | | | (OPT ITEM 281) | | | | | | | | |
| -281 | 141A6306-5 | | . . . | BEARING ASSY-KIT | | | | | | | E-J | 1 |
| | | | | (OPT ITEM 280A) | | | | | | | | |
| -282 | NAS1149E0663R | | | WASHER | | | | | | | E-J | 2 |
| -283 | AHRSC4CFR8 | | | BEARING | | | | | | | E-J | 1 |
| | | | | (V60380) | | | | | | | | |
| | | | | (SPEC BACB10GS06FJ8) | | | | | | | | |
| | | | | (OPT ITEM 283A) | | | | | | | | |
| -283A | CF2903 | | | CAM FOLLOWER | | | | | | | E-J | 1 |
| | | | | (V92563) | | | | | | | | |
| | | | | (OPT ITEM 283) | | | | | | | | |
| 285 | 141A6306-2 | | . . . | ARM-CRANK | | | | | | | | 1 |
| 290 | MS16625-4162 | | . . | RING | | | | | | | | 1 |
| 295 | 69B10068-5 | | . . | RETAINER-BRG | | | | | | | | 2 |
| 300 | PACMKP21BSF~ S428 | | . . | BEARING | | | | | | | | 2 |
| | | | | (V21335) | | | | | | | | |
| | | | | (SPEC BACB10FV21) | | | | | | | | |
| | | | | (OPT ACMKP21BSP510LY (V40920)) | | | | | | | | |
| | | | | (OPT SSMKP21BSSD705 (V83086)) | | | | | | | | |
| | | | | (OPT PACMKP21BSA3908 (V21335)) | | | | | | | | |
| 305 | PACMKP23BSF~ S428 | | . . | BEARING | | | | | | | | 2 |
| | | | | (V21335) | | | | | | | | |
| | | | | (SPEC BACB10FV23) | | | | | | | | |
| | | | | (OPT SSMKP21BSSD705 (V83086)) | | | | | | | | |
| | | | | (OPT ACMKP23BSP510LY (V40920)) | | | | | | | | |
| | | | | (OPT SSMKP23BSSD705 (V83086)) | | | | | | | | |
| | | | | (OPT PACMKP23BSA3908 (V21335)) | | | | | | | | |
| 310 | PACMKP12AFS428 | | . . | BEARING | | | | | | | | 1 |
| | | | | (V21335) | | | | | | | | |
| | | | | (SPEC BACB10FS12) | | | | | | | | |
| | | | | (OPT SSMKP12ASD705 (V83086)) | | | | | | | | |
| | | | | (OPT ACMKP12AP510Y19 (V40920)) | | | | | | | | |
| | | | | (OPT PACMKP12AA3908 (V21335)) | | | | | | | | |
| | | | | (OPT SSMKP12AP (V21760)) | | | | | | | | |

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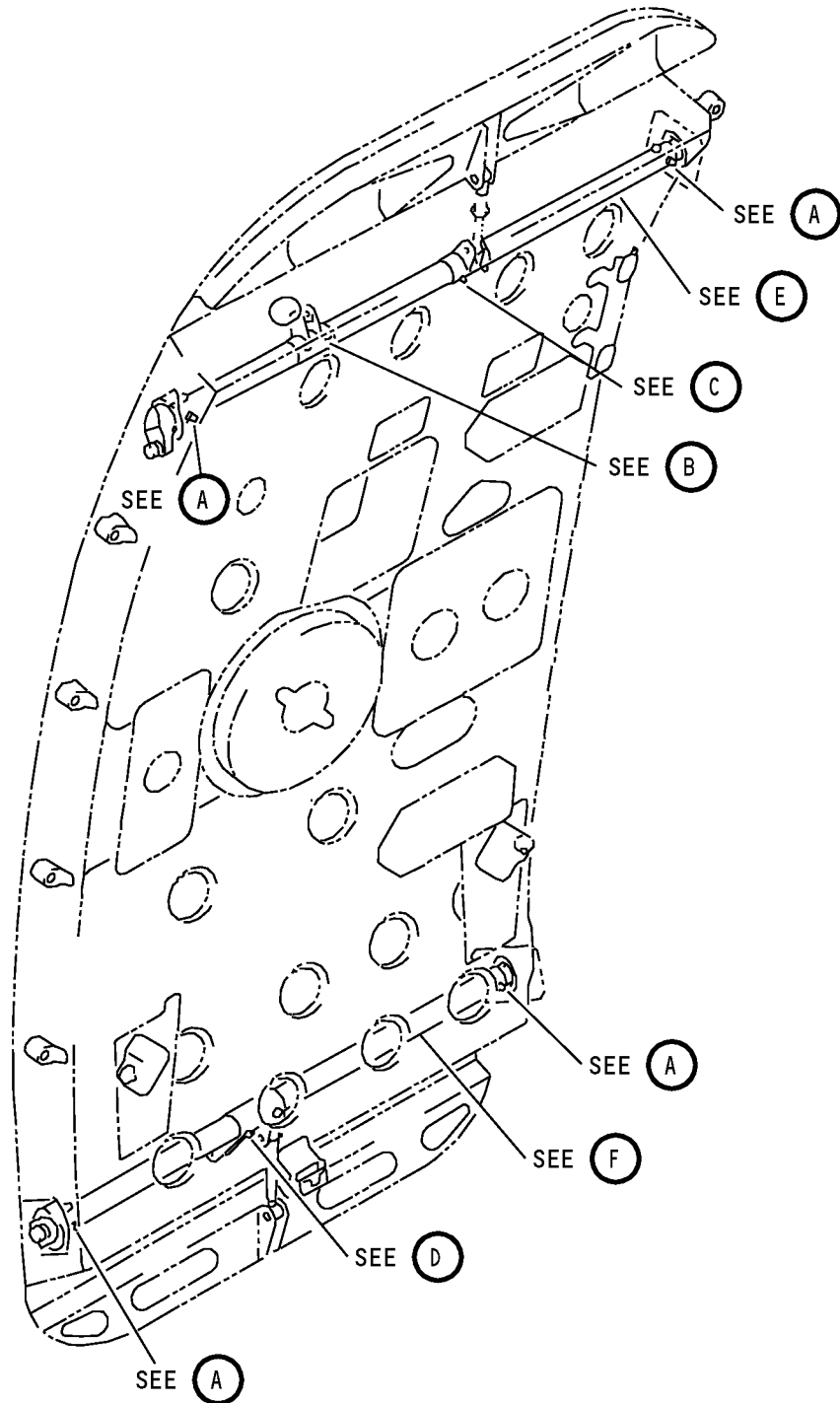
COMPONENT MAINTENANCE MANUAL

| FIG/ ITEM | PART NUMBER | AIRLINE PART NUMBER | NOMENCLATURE | | | | | | | USAGE CODE | UNITS PER ASSY | |
|--------------|--------------|---------------------------|--------------|---|---|---|---|---|---|---------------|----------------------|----|
| | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | | | |
| 12- 385 | F51636-4 | | . | . | . | NUTPLATE (V15653) (SPEC BACN10JA4CD) (OPT 102F177-4 (V72962)) (OPT BRF110C4D (V52828)) (OPT BRF170C4D (V52828)) (OPT F51636-4 (V15653)) | | | | | | 12 |
| 390 | 69-78694-3 | | . | . | . | FILLER-RADIUS | | | | | | 4 |
| 395 | 69-78694-4 | | . | . | . | FILLER-RADIUS | | | | | | 4 |
| 400 | 65C36793-1 | | . | . | . | BUSHING | | | | | | 2 |
| 405 | BACR15BA3AD | | . | . | . | RIVET (SIZE DETERMINED ON INST) | | | | | | 8 |
| 410 | BACN10JP3ACD | | . | . | . | NUTPLATE (SIZE DETERMINED ON INST) | | | | | | 4 |
| 415 | 141A6304-2 | | . | . | . | HOUSING | | | | | | 1 |
| 420 | 30-3020-2 | | . | | | FILLER | | | | | | 2 |
| 425 | 30-3021-1 | | . | | | SHIM | | | | | | 2 |

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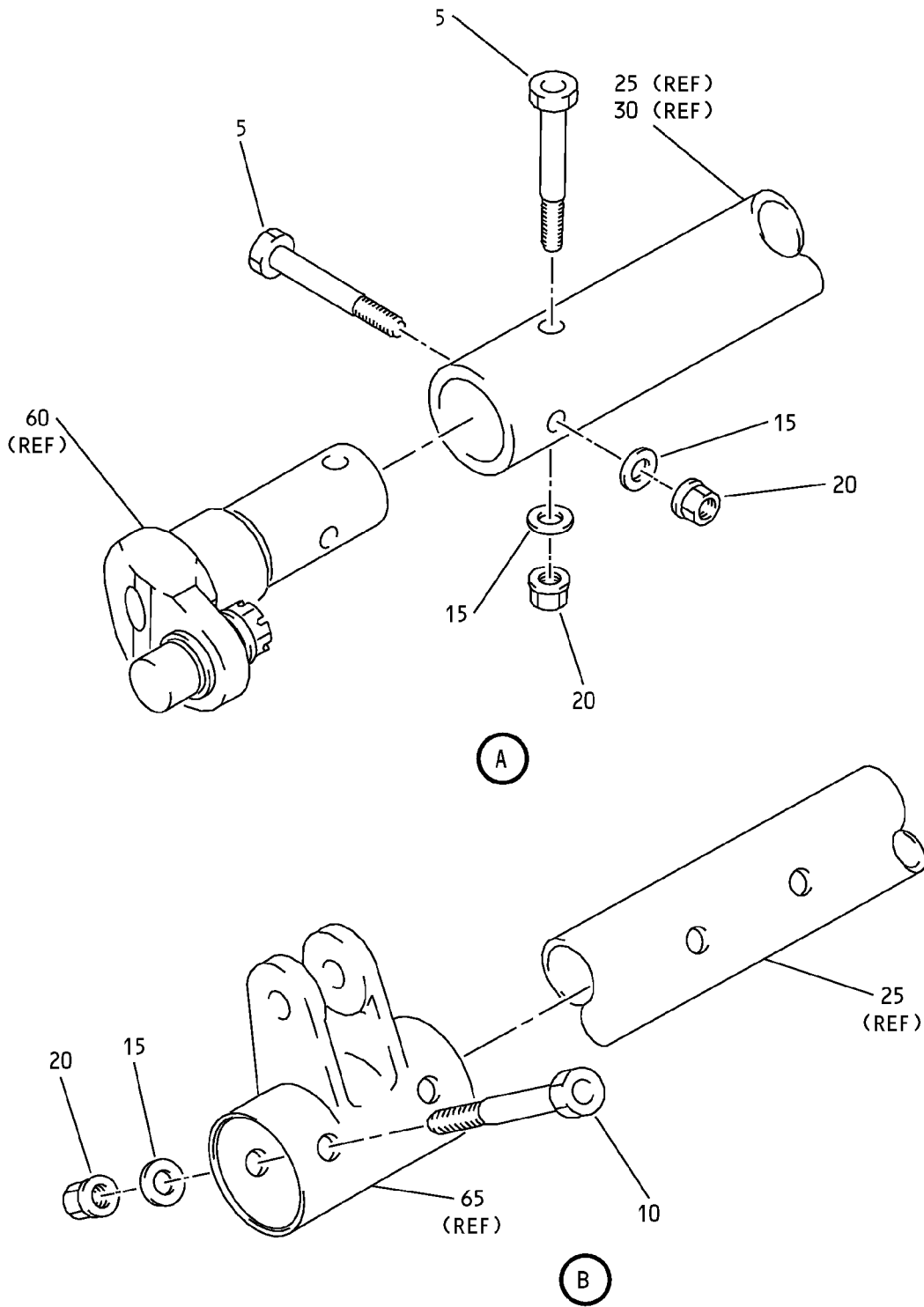
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Latch Torque Tube Assembly
IPL Figure 13 (Sheet 1 of 5)

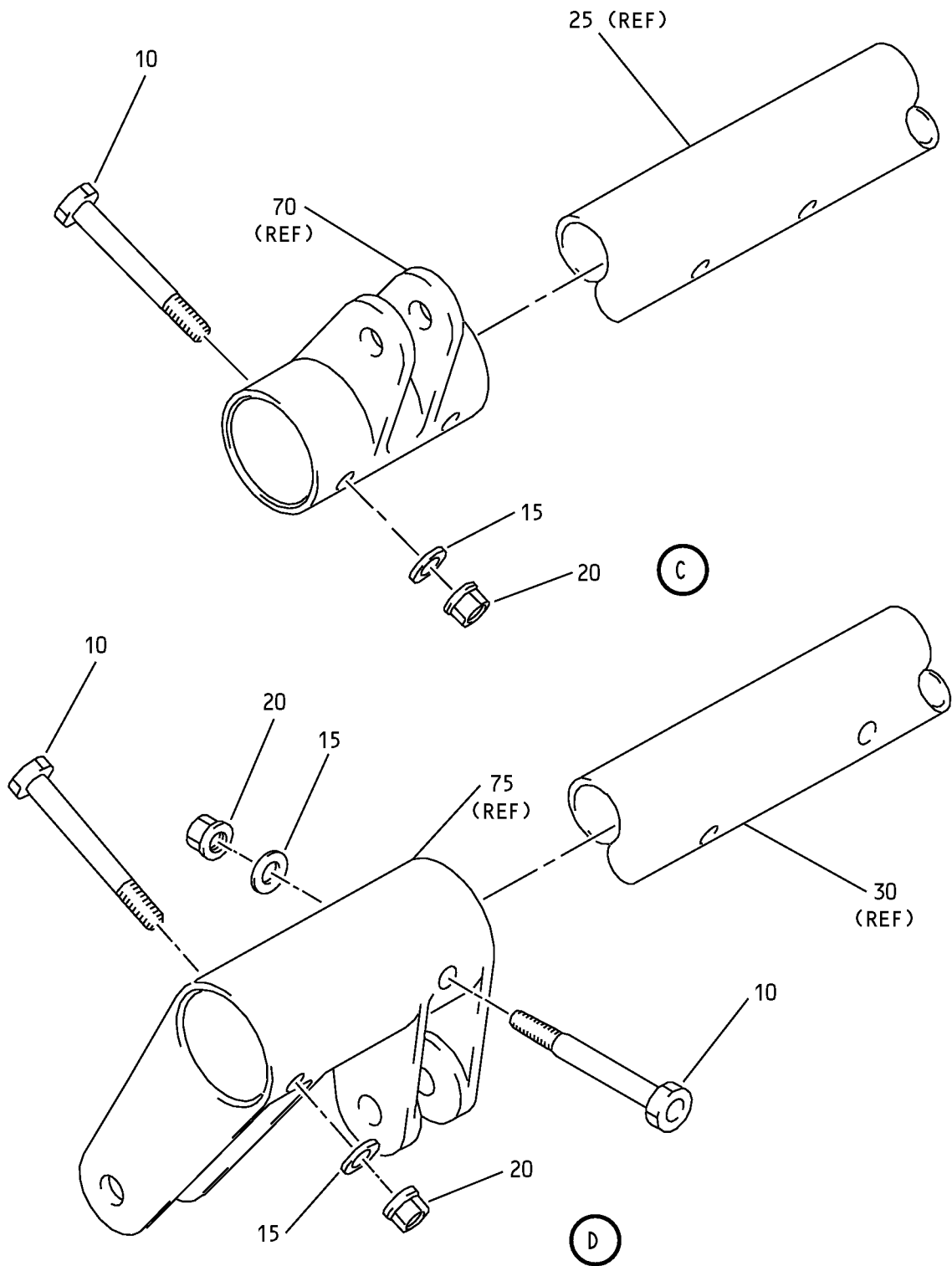
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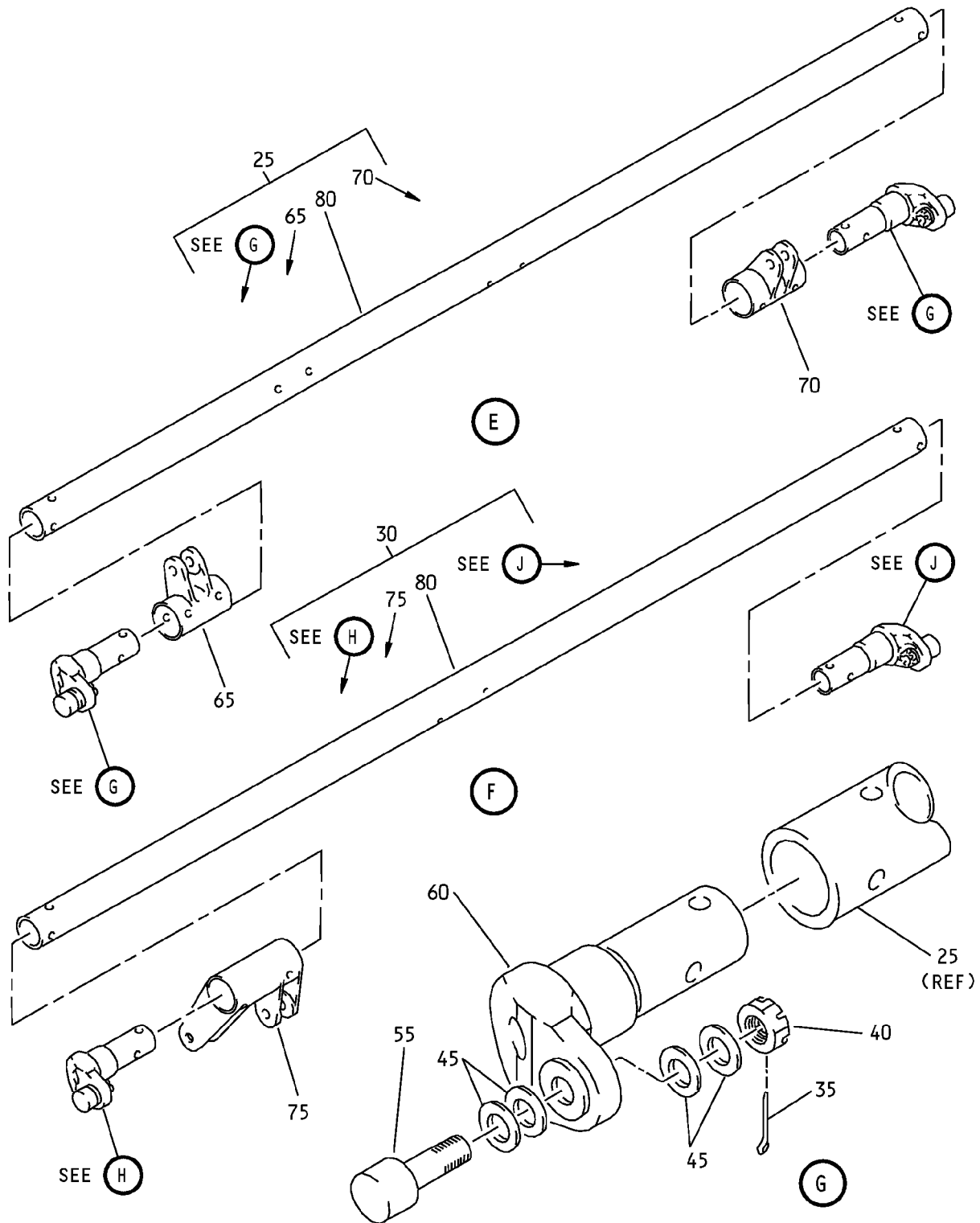
Latch Torque Tube Assembly
 IPL Figure 13 (Sheet 2 of 5)

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Latch Torque Tube Assembly
IPL Figure 13 (Sheet 3 of 5)

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Latch Torque Tube Assembly
IPL Figure 13 (Sheet 4 of 5)

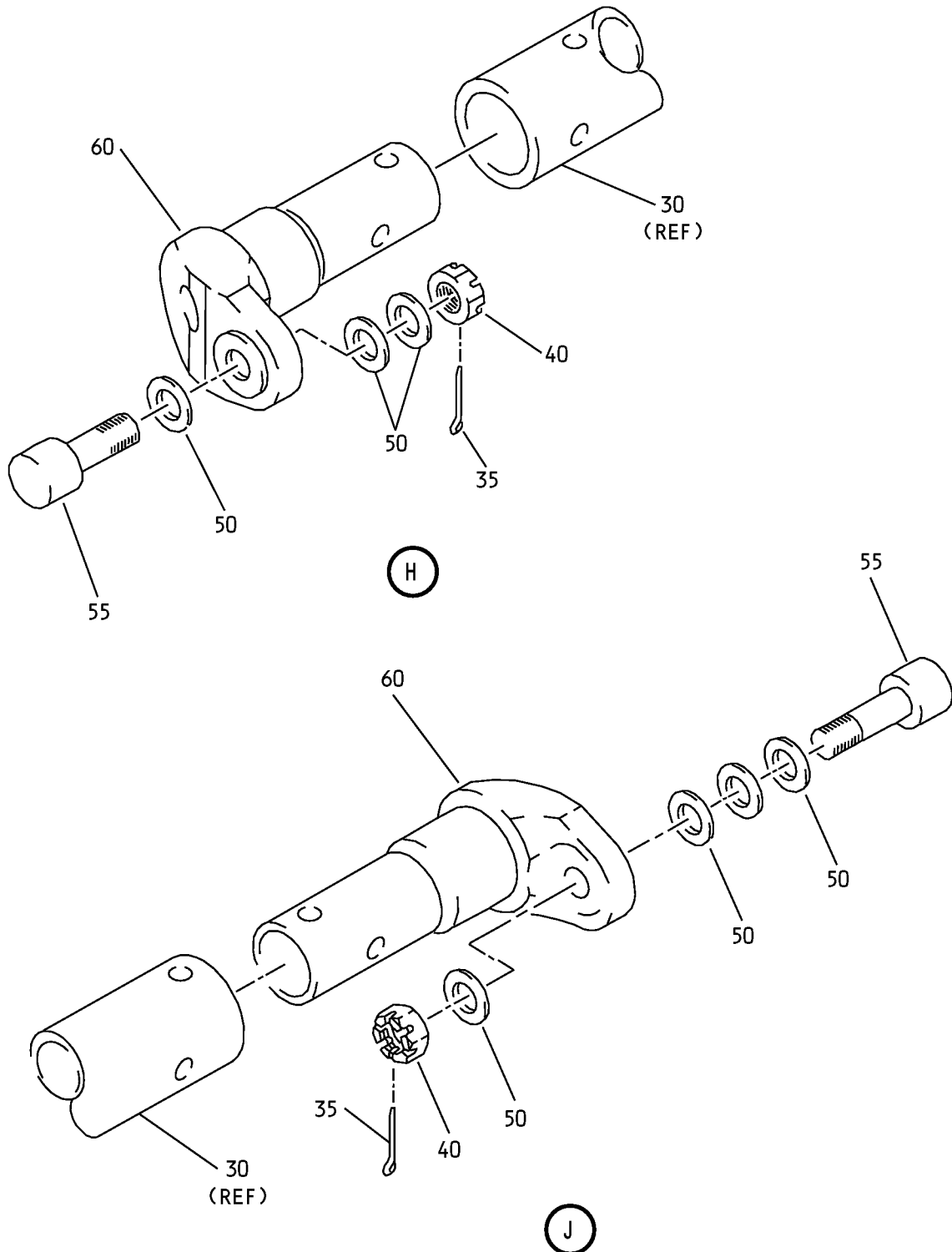
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Latch Torque Tube Assembly
IPL Figure 13 (Sheet 5 of 5)



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| FIG/ ITEM | PART NUMBER | AIRLINE PART NUMBER | NOMENCLATURE | | | | | | | USAGE CODE | UNITS PER ASSY |
|--------------|----------------|---------------------------|--------------|---|---|---|---|---|---|---------------|----------------------|
| | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | | |
| 13- | | | | | | | | | | | |
| -1A | 141A6320-1 | | | | | | | | | A | RF |
| -1B | 141A6320-1 | | | | | | | | | B | RF |
| -1C | 141A6320-2 | | | | | | | | | C-J | RF |
| 5 | BACB30NM3K17 | | | | | | | | | | 8 |
| 10 | BACB30NM3K19 | | | | | | | | | | 6 |
| 15 | NAS1149E0332R | | | | | | | | | | AR |
| -15A | NAS1149E0316R | | | | | | | | | | AR |
| 20 | H52732-3CM | | | | | | | | | | 14 |
| 25 | 141A6322-1 | | | | | | | | | A, B | 1 |
| -25A | 141A6322-2 | | | | | | | | | C-J | 1 |
| 30 | 141A6321-1 | | | | | | | | | A, B | 1 |
| -30A | 141A6321-2 | | | | | | | | | C-J | 1 |
| 35 | BACP18BC02A06P | | | | | | | | | | 2 |
| 40 | BACN10JD105CD | | | | | | | | | | 2 |
| 45 | NAS1149D0516J | | | | | | | | | | 8 |
| 50 | NAS1149D0516J | | | | | | | | | | 7 |
| 55 | KRP178905VT | | | | | | | | | | 2 |
| 60 | 141A6323-1 | | | | | | | | | A, B | 2 |
| -60A | 141A6323-2 | | | | | | | | | C-J | 2 |
| 65 | 60-4409-1 | | | | | | | | | | 1 |
| 70 | 60-4431-1 | | | | | | | | | | 1 |

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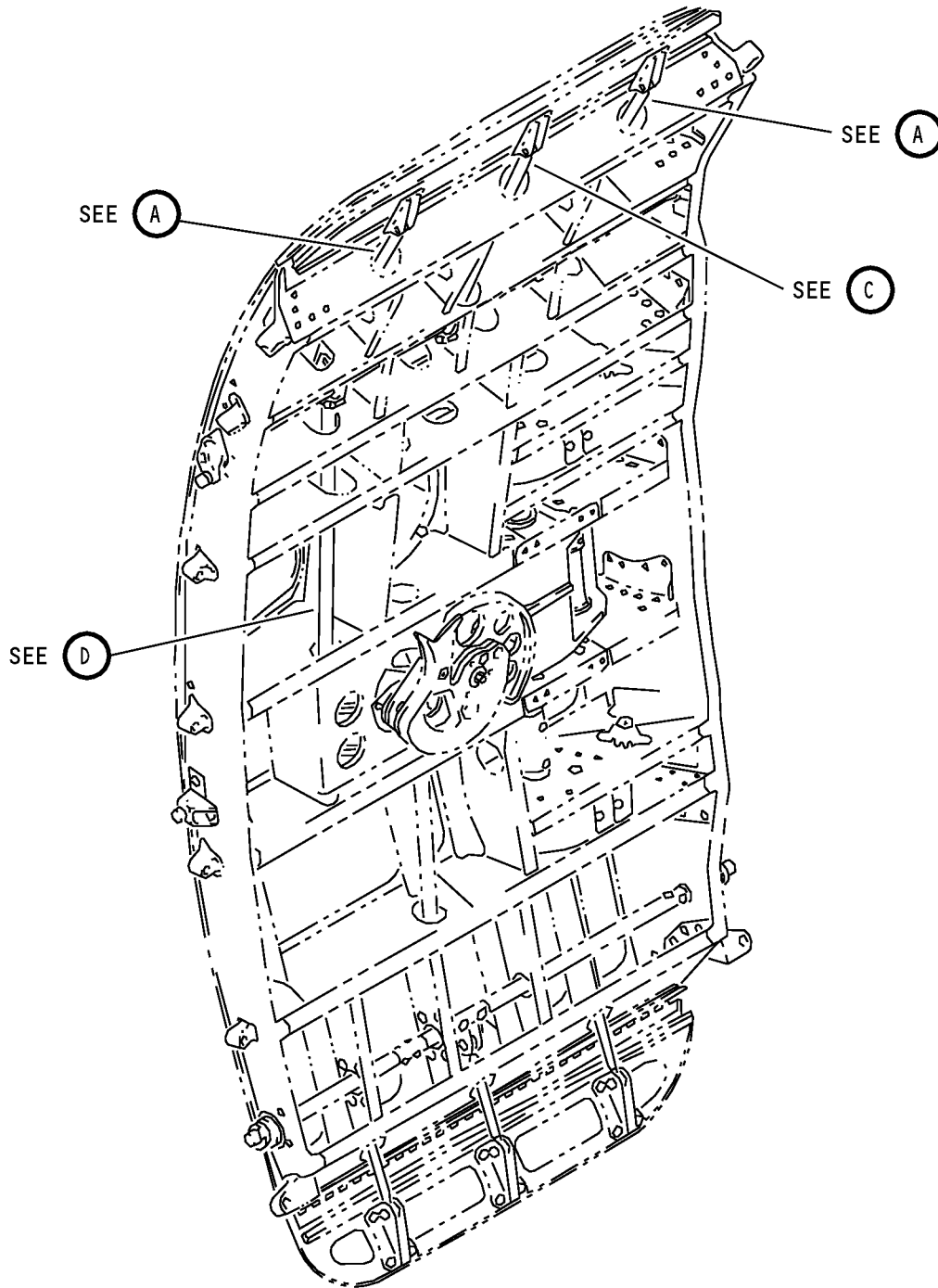
COMPONENT MAINTENANCE MANUAL

| FIG/ ITEM | PART NUMBER | AIRLINE PART NUMBER | NOMENCLATURE | | | | | | | USAGE CODE | UNITS PER ASSY |
|--------------|-------------|---------------------------|--------------|---|---------------------------------------|---|---|---|---|---------------|----------------------|
| | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | | |
| 13- 75 | 69-71372-3 | | . | . | CRANK-BELL (USED ON ITEMS 30, 30A) | | | | | | 1 |
| 80 | 60-4406-11 | | . | . | TUBE (USED ON ITEMS 25, 30) | | | | | A, B | 1 |
| -80A | 60-4406-19 | | . | . | TUBE (USED ON ITEMS 25A, 30A) | | | | | C-J | 1 |

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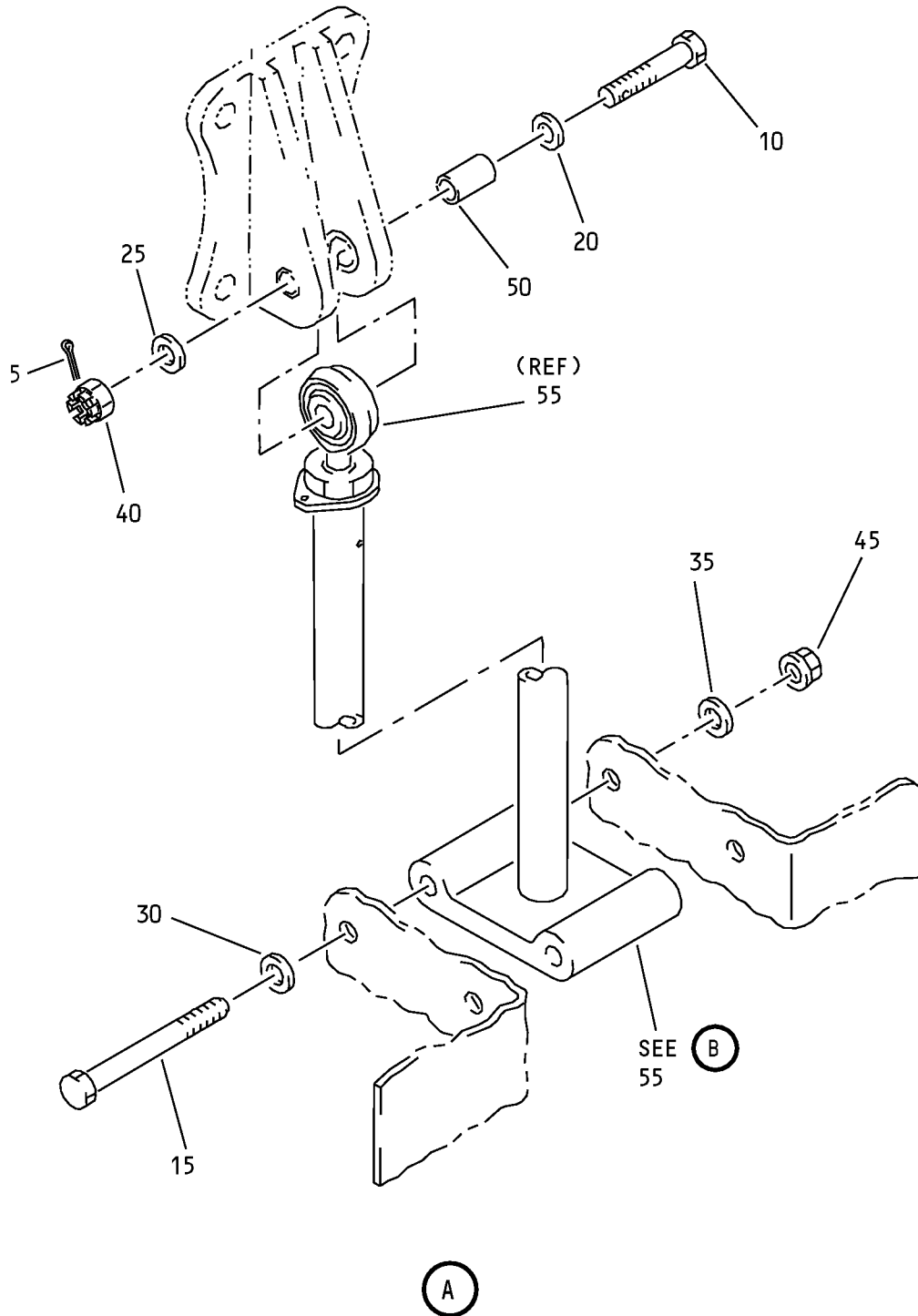
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Upper Rod Installation
IPL Figure 14 (Sheet 1 of 6)

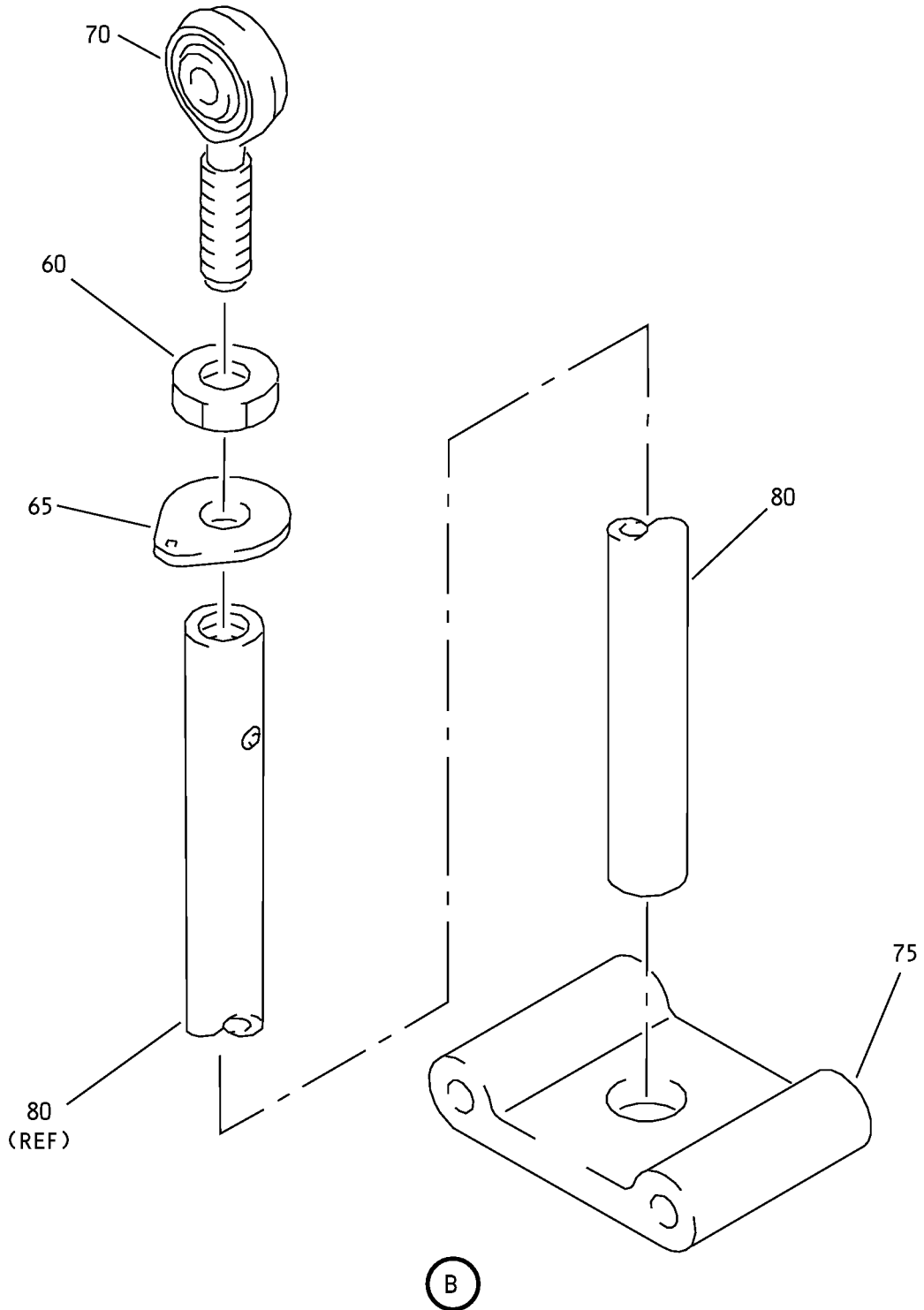
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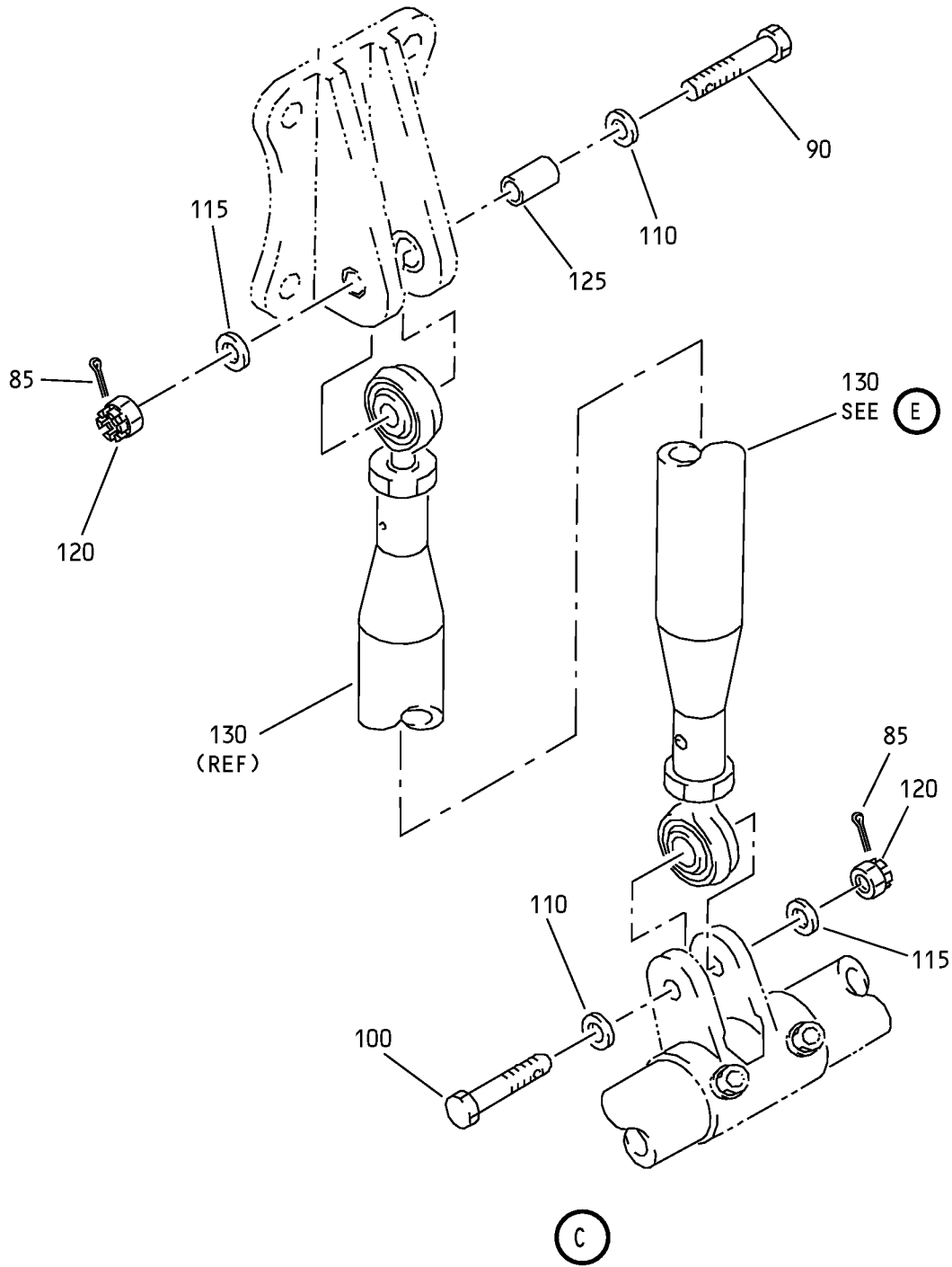
Upper Rod Installation
IPL Figure 14 (Sheet 2 of 6)

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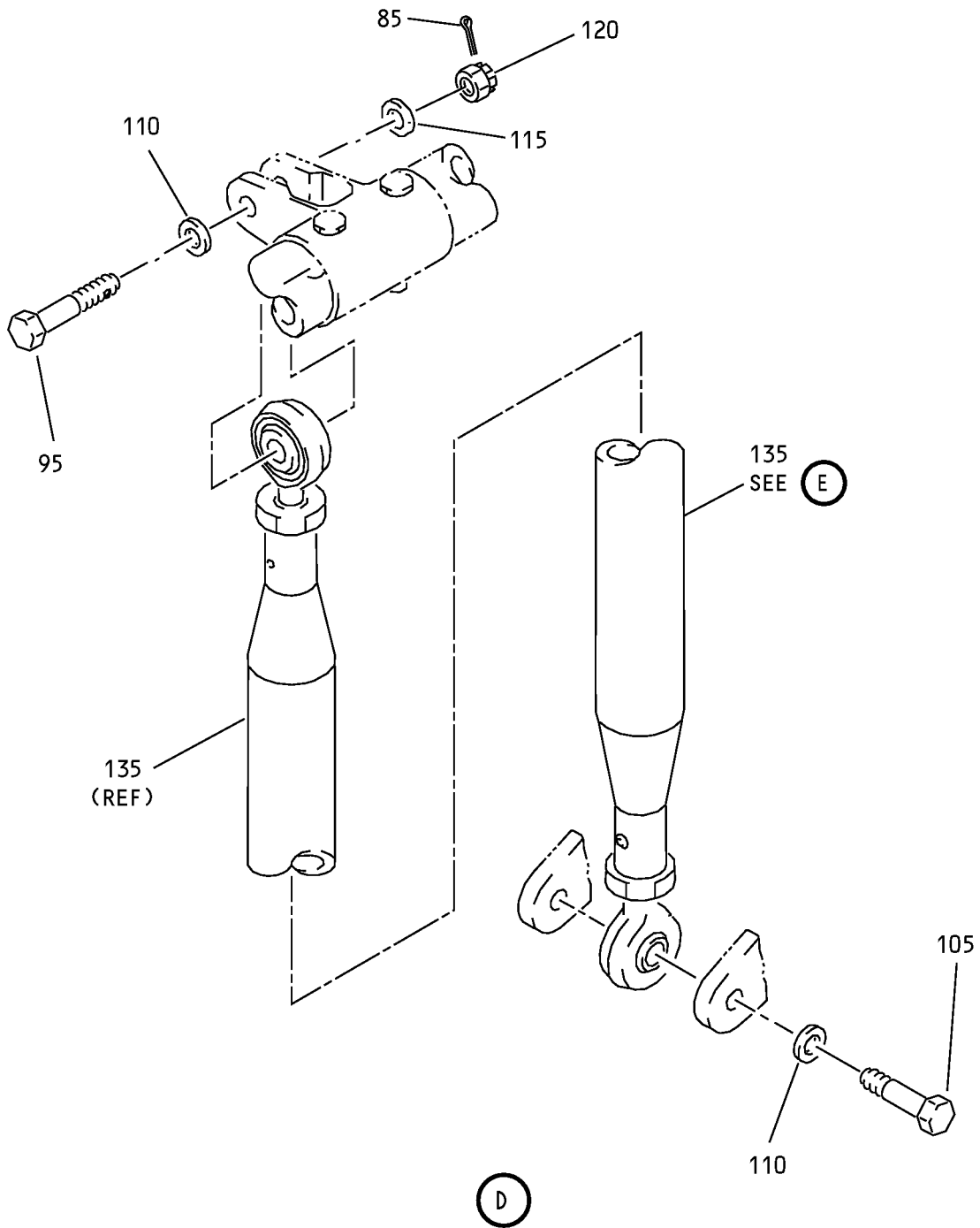
Upper Rod Installation
IPL Figure 14 (Sheet 3 of 6)

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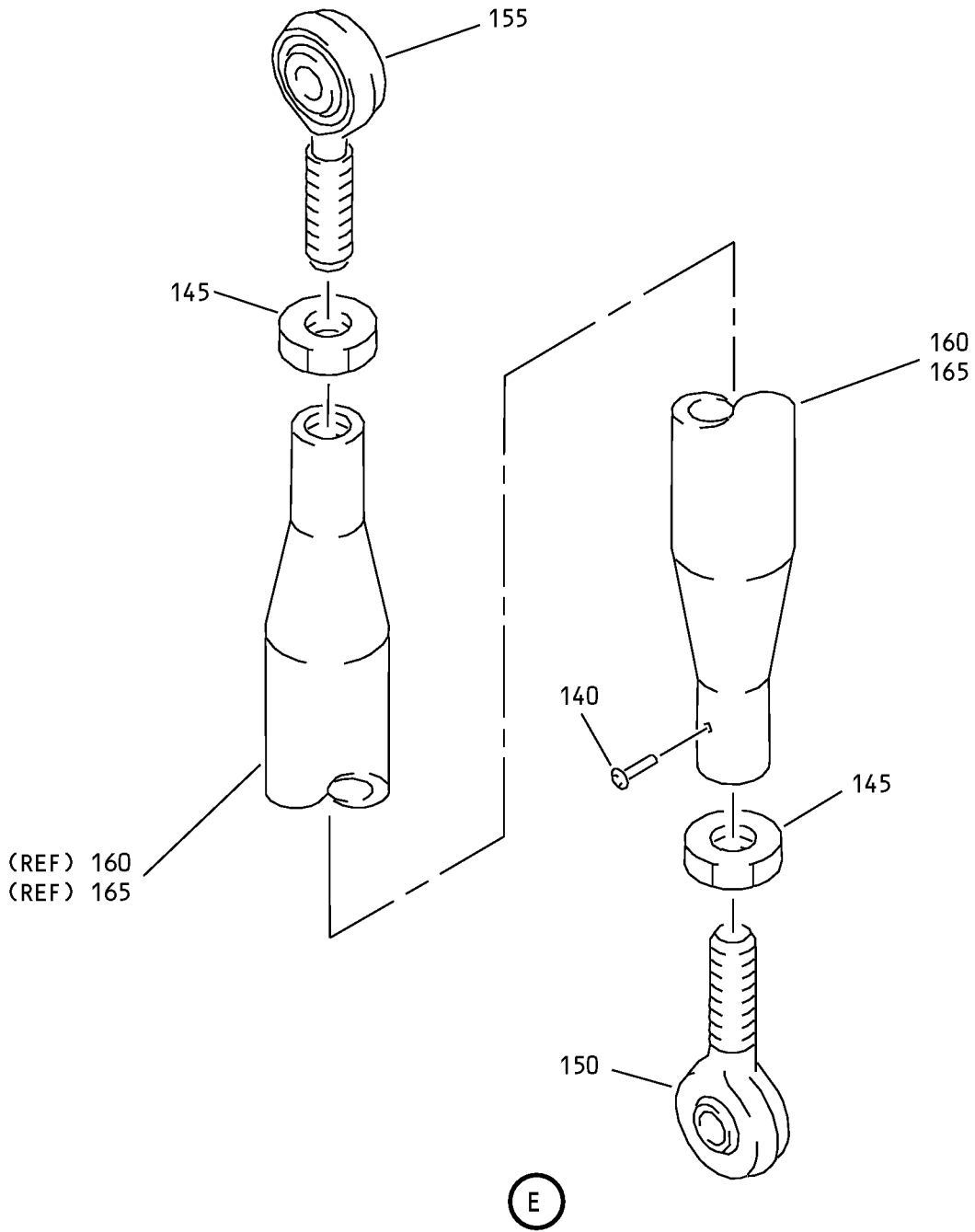
Upper Rod Installation
IPL Figure 14 (Sheet 4 of 6)

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Upper Rod Installation
IPL Figure 14 (Sheet 5 of 6)

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Upper Rod Installation
IPL Figure 14 (Sheet 6 of 6)



COMPONENT MAINTENANCE MANUAL

| FIG/ ITEM | PART NUMBER | AIRLINE PART NUMBER | NOMENCLATURE | | | | | | | USAGE CODE | UNITS PER ASSY | | | | | |
|--------------|----------------|---------------------------|--------------|---|---|---|---|---|---|---------------|-----------------------------|---|---|---|---|---|
| | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | | | | | | | |
| 14- | | | | | | | | | | | | | | | | |
| 95 | BACB30NM4DK14 | | . | B | O | L | T | | | | 1 | | | | | |
| 100 | BACB30NM4DK13 | | . | B | O | L | T | | | | 1 | | | | | |
| 105 | BACB30LJ4-13 | | . | B | O | L | T | | | | 1 | | | | | |
| 110 | BACW10BP4CD | | . | W | A | S | H | E | R | | 4 | | | | | |
| 115 | BACW10BP4DP | | . | W | A | S | H | E | R | | 3 | | | | | |
| 120 | BACN10JD4CD | | . | N | U | T | | | | | 3 | | | | | |
| 125 | BACB28AK04-032 | | . | B | U | S | H | I | N | G | 1 | | | | | |
| 130 | 65-28925-67 | | . | R | O | D | A | S | S | Y | - | P | U | S | H | 1 |
| 135 | 65-28925-70 | | . | R | O | D | A | S | S | Y | - | P | U | S | H | 1 |
| 140 | MS20470D3 | | .. | R | I | V | E | T | | | 1 | | | | | |
| | | | | | | | | | | | (SIZE DETERMINED ON INST) | | | | | |
| 145 | AN316-5R | | .. | N | U | T | | | | | 2 | | | | | |
| 150 | AB4E27FN | | .. | B | E | A | R | I | N | G | 1 | | | | | |
| | | | | | | | | | | | (V15860) | | | | | |
| | | | | | | | | | | | (SPEC BACB10A187L) | | | | | |
| | | | | | | | | | | | (OPT BRE4140L (V81376)) | | | | | |
| | | | | | | | | | | | (OPT HB4E135 (V02758)) | | | | | |
| | | | | | | | | | | | (OPT KB4ESSFN (V97613)) | | | | | |
| | | | | | | | | | | | (OPT MXJ45-14BFG (V73134)) | | | | | |
| | | | | | | | | | | | (OPT 51564-0402 (V09455)) | | | | | |
| | | | | | | | | | | | (OPT AR4E4FN (VS0352)) | | | | | |
| | | | | | | | | | | | (OPT ASM4F6 (V56644)) | | | | | |
| 155 | 10E4-116NW | | .. | B | E | A | R | I | N | G | 1 | | | | | |
| | | | | | | | | | | | (V16746) | | | | | |
| | | | | | | | | | | | (SPEC BACB10Y4) | | | | | |
| | | | | | | | | | | | (OPT BRES4-2236L2 (V81376)) | | | | | |
| | | | | | | | | | | | (OPT HB4E212K (V02758)) | | | | | |
| | | | | | | | | | | | (OPT KBE4-150AFNW (V97613)) | | | | | |
| | | | | | | | | | | | (OPT 51588-041 (V09455)) | | | | | |
| | | | | | | | | | | | (OPT MSSK4ASFG (V73134)) | | | | | |
| | | | | | | | | | | | (OPT ASMK4F1 (V56644)) | | | | | |
| | | | | | | | | | | | (OPT AR4E7AFNW (VS0352)) | | | | | |
| | | | | | | | | | | | (OPT 10E4-116 (V16746)) | | | | | |
| | | | | | | | | | | | (OPT ARB4E60FNW (V15860)) | | | | | |
| 160 | 65-28925-13 | | .. | R | O | D | | | | | 1 | | | | | |
| | | | | | | | | | | | (USED ON ITEM 130) | | | | | |
| 165 | 65-28925-16 | | .. | R | O | D | | | | | 1 | | | | | |
| | | | | | | | | | | | (USED ON ITEM 135) | | | | | |

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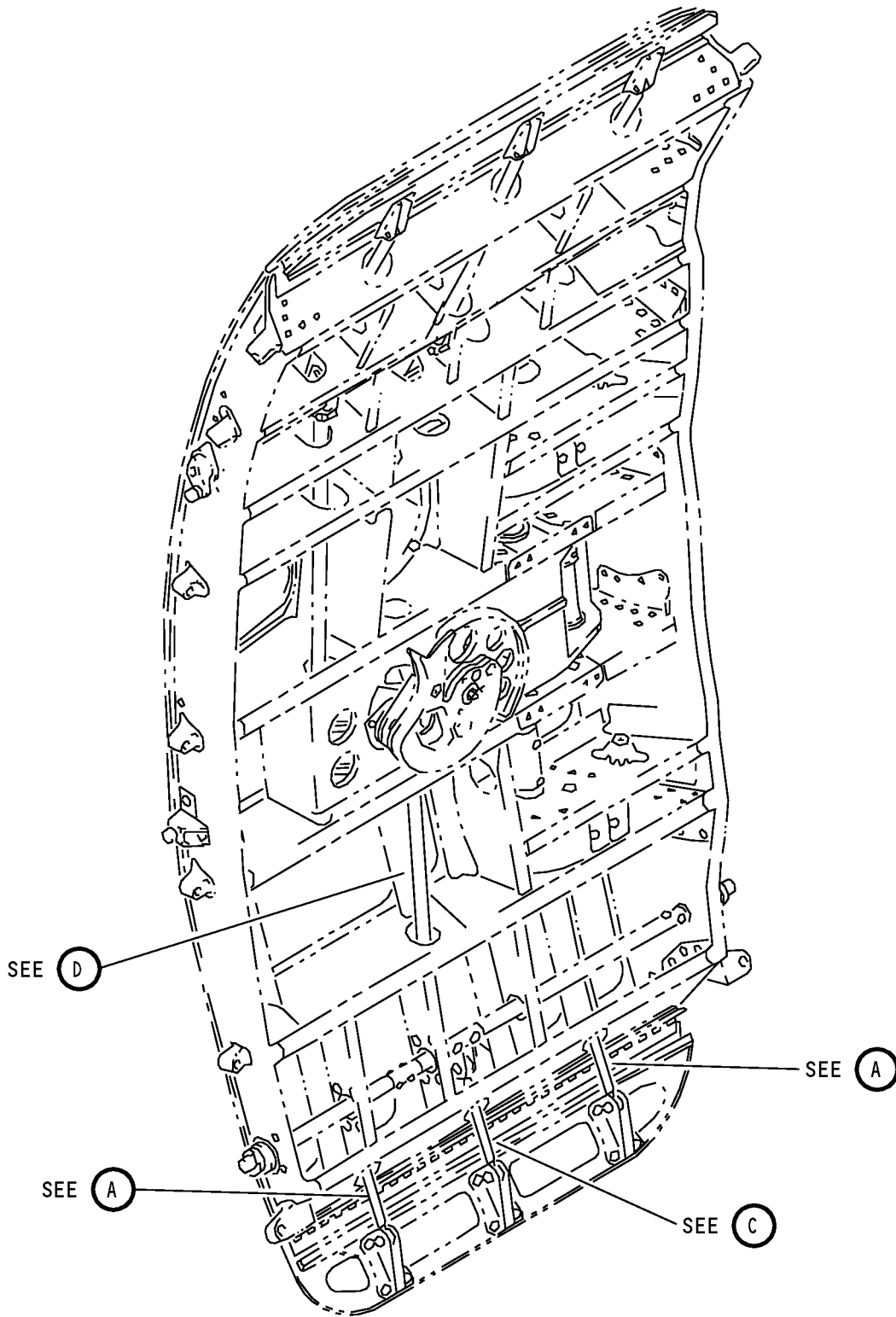
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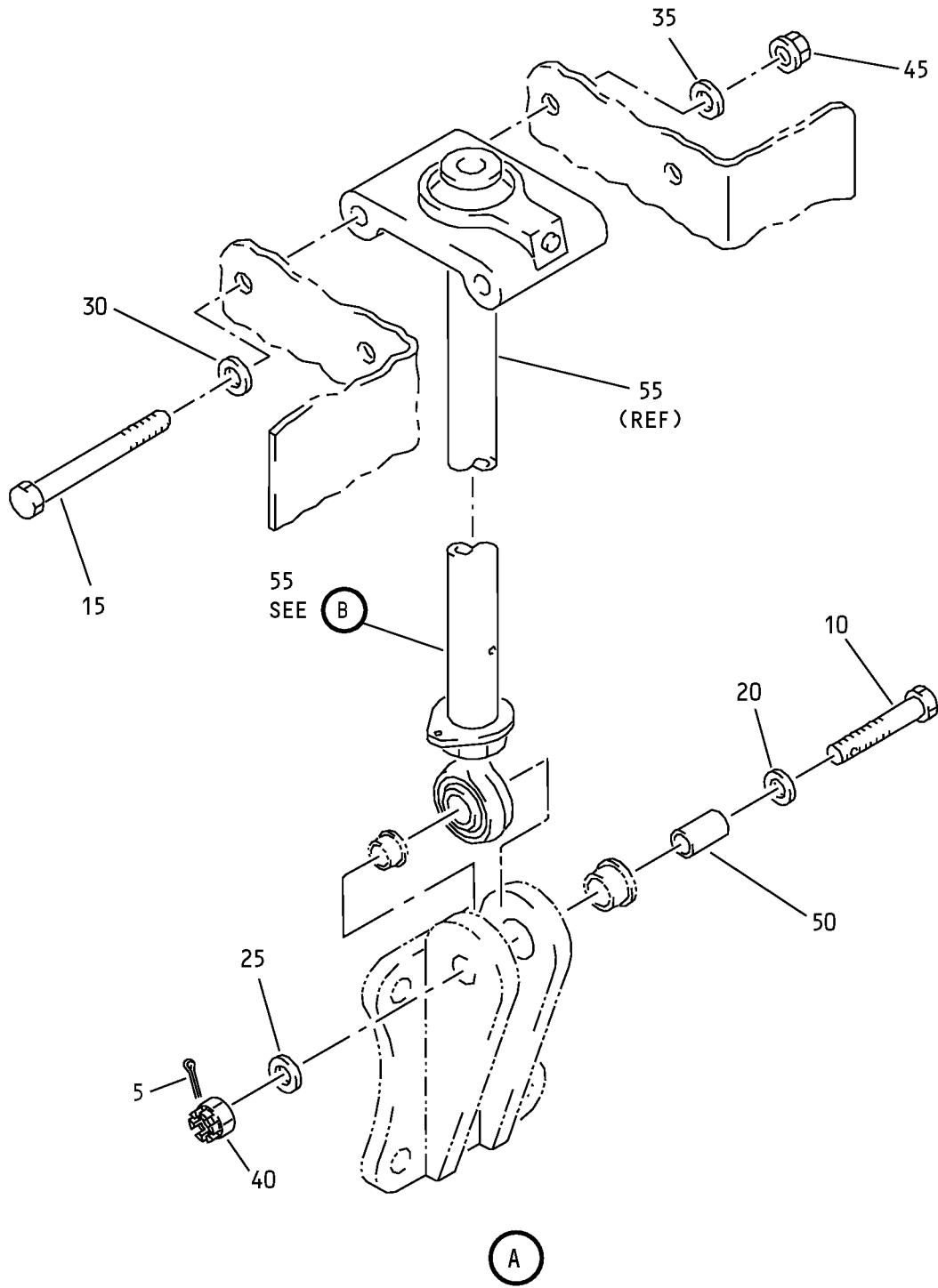
COMPONENT MAINTENANCE MANUAL



Lower Rod Installation
IPL Figure 15 (Sheet 1 of 6)

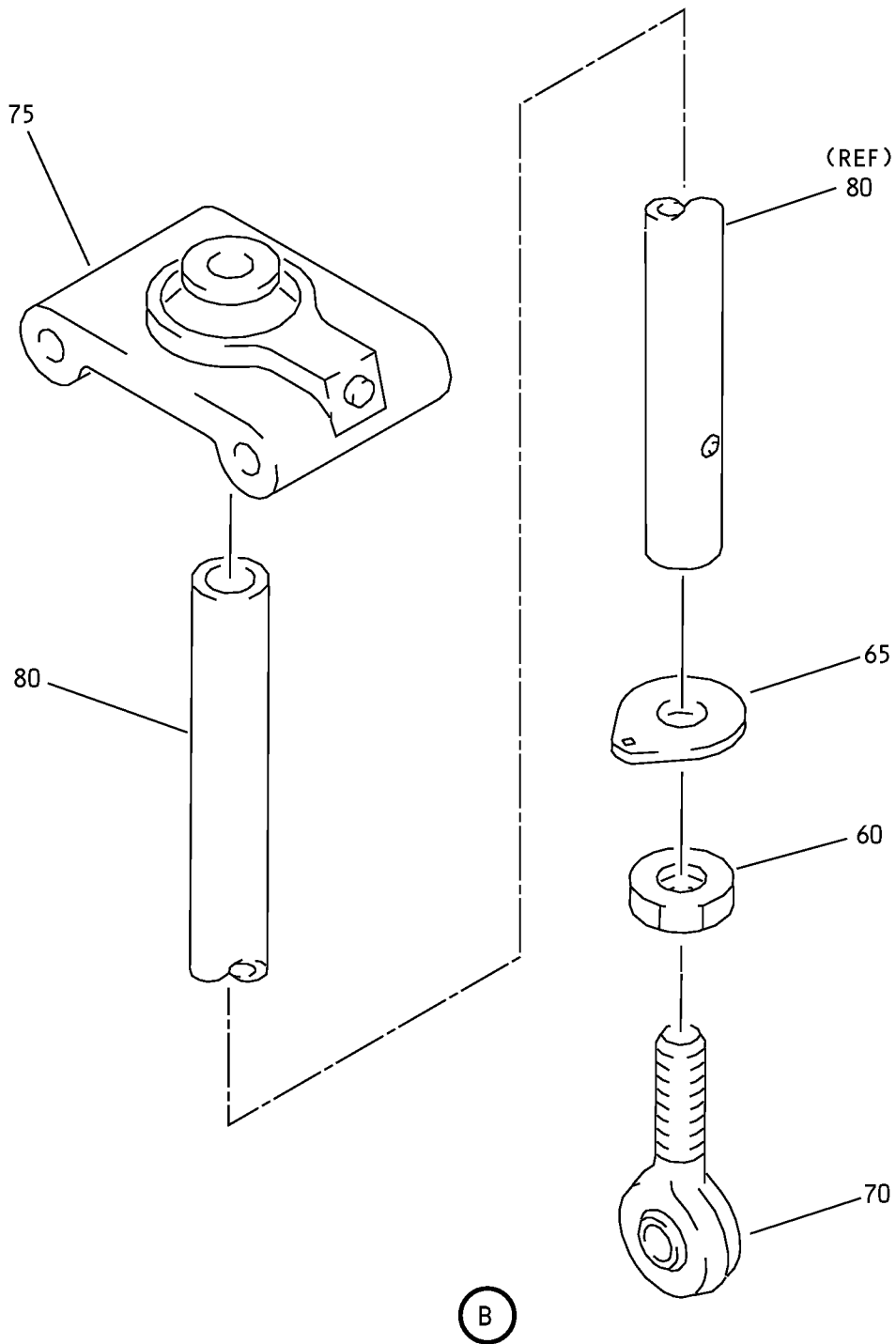
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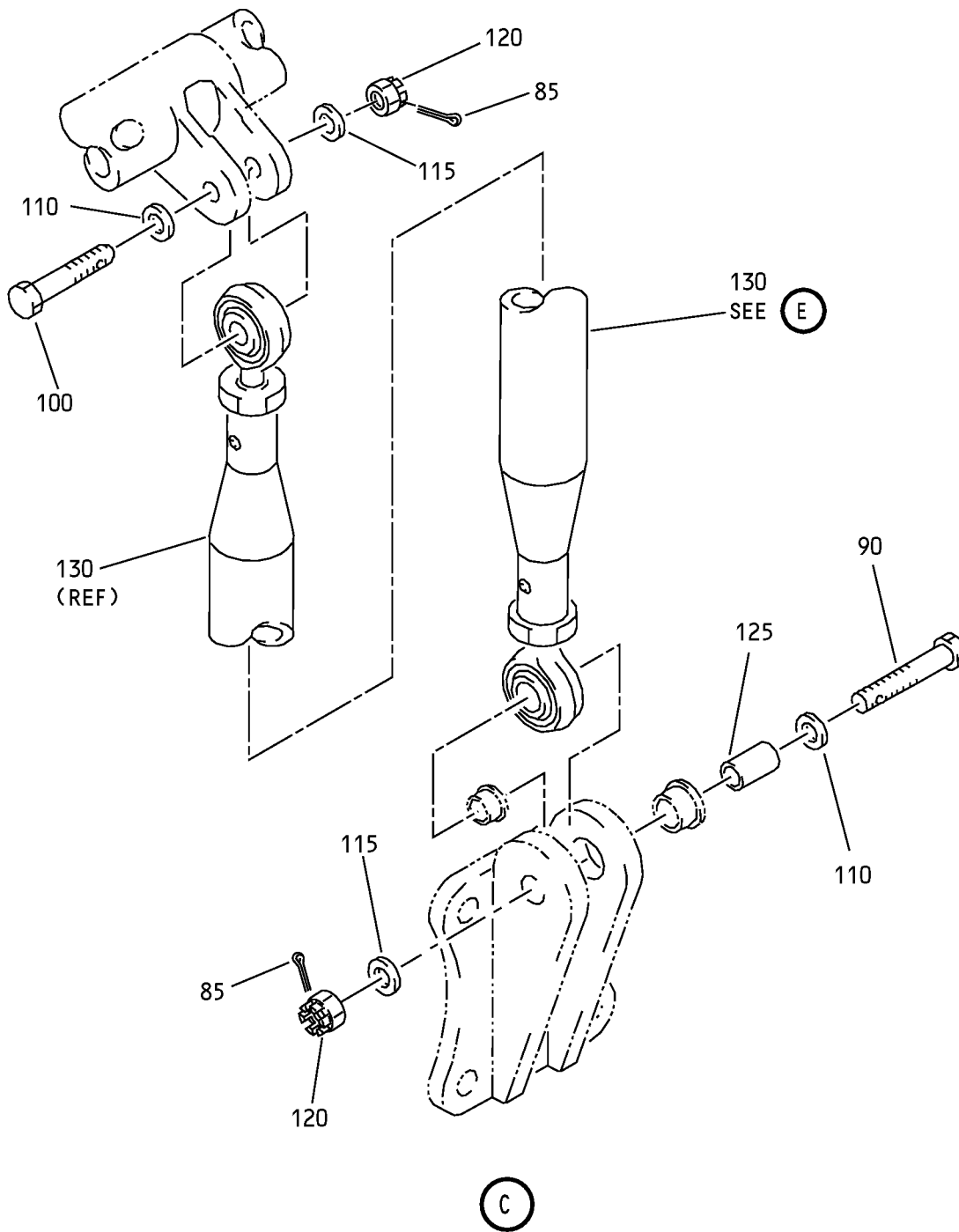
Lower Rod Installation
IPL Figure 15 (Sheet 2 of 6)

COMPONENT MAINTENANCE MANUAL



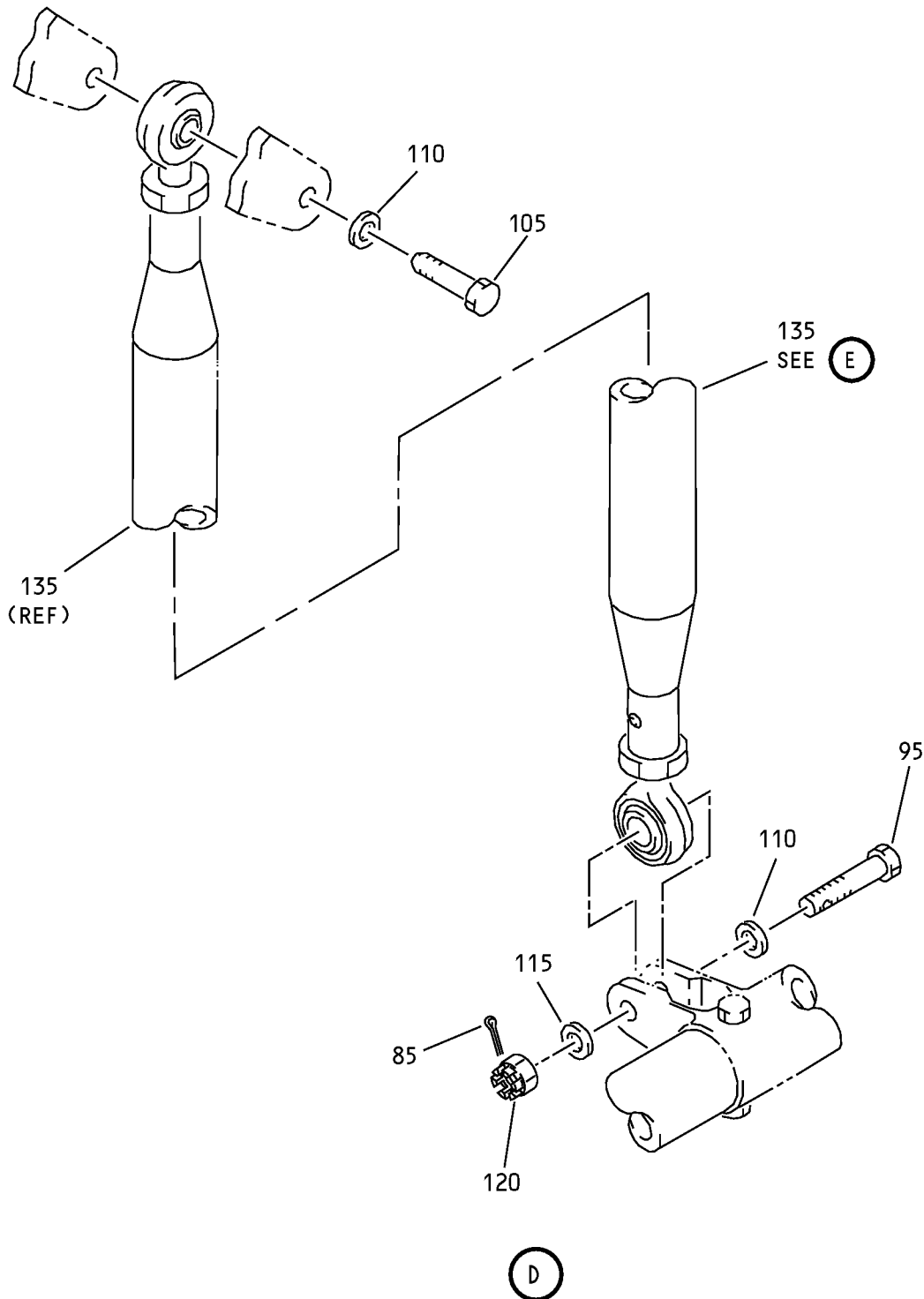
Lower Rod Installation
IPL Figure 15 (Sheet 3 of 6)

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Lower Rod Installation
IPL Figure 15 (Sheet 4 of 6)

COMPONENT MAINTENANCE MANUAL



Lower Rod Installation
IPL Figure 15 (Sheet 5 of 6)

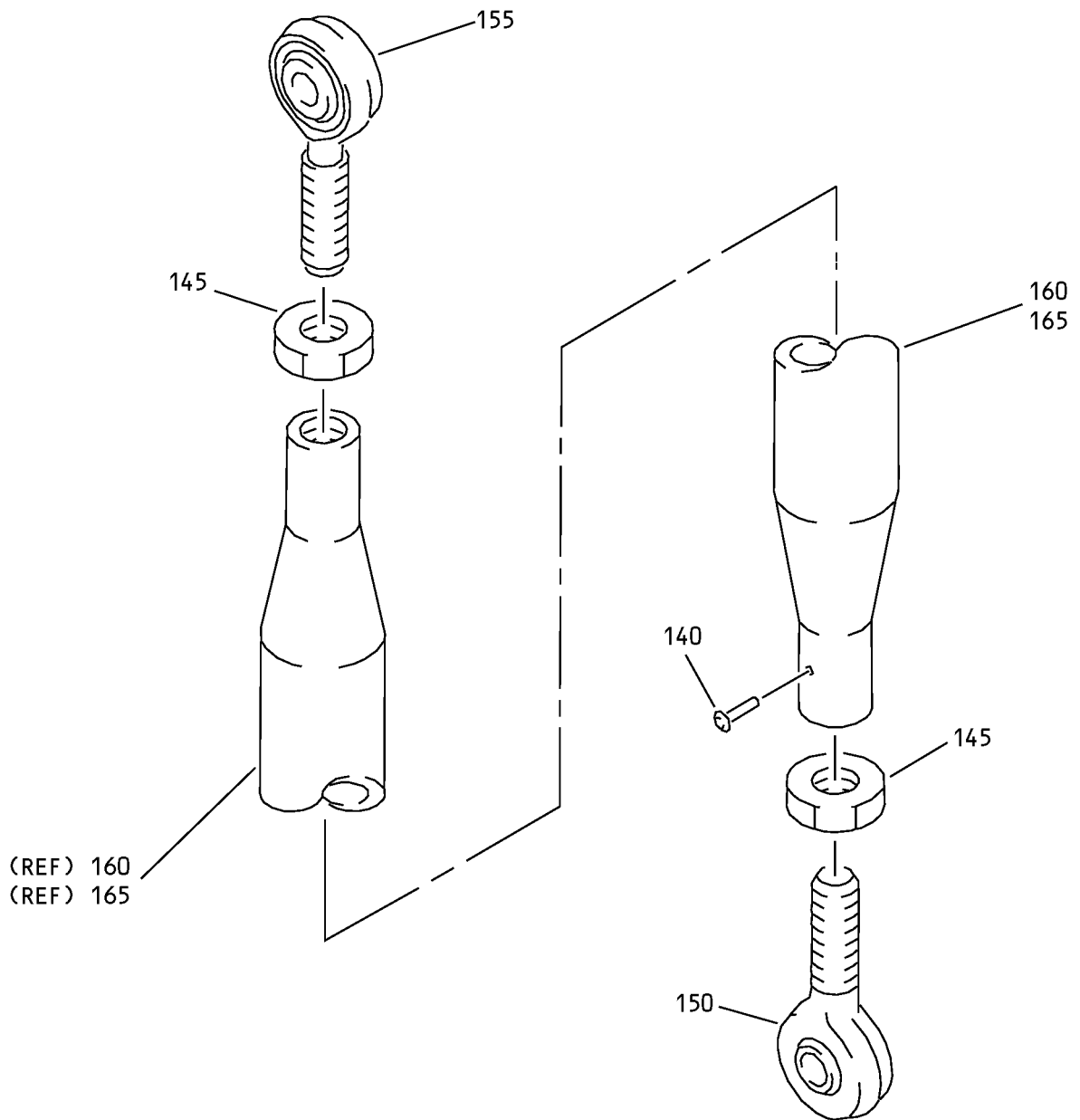
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E

Lower Rod Installation
IPL Figure 15 (Sheet 6 of 6)

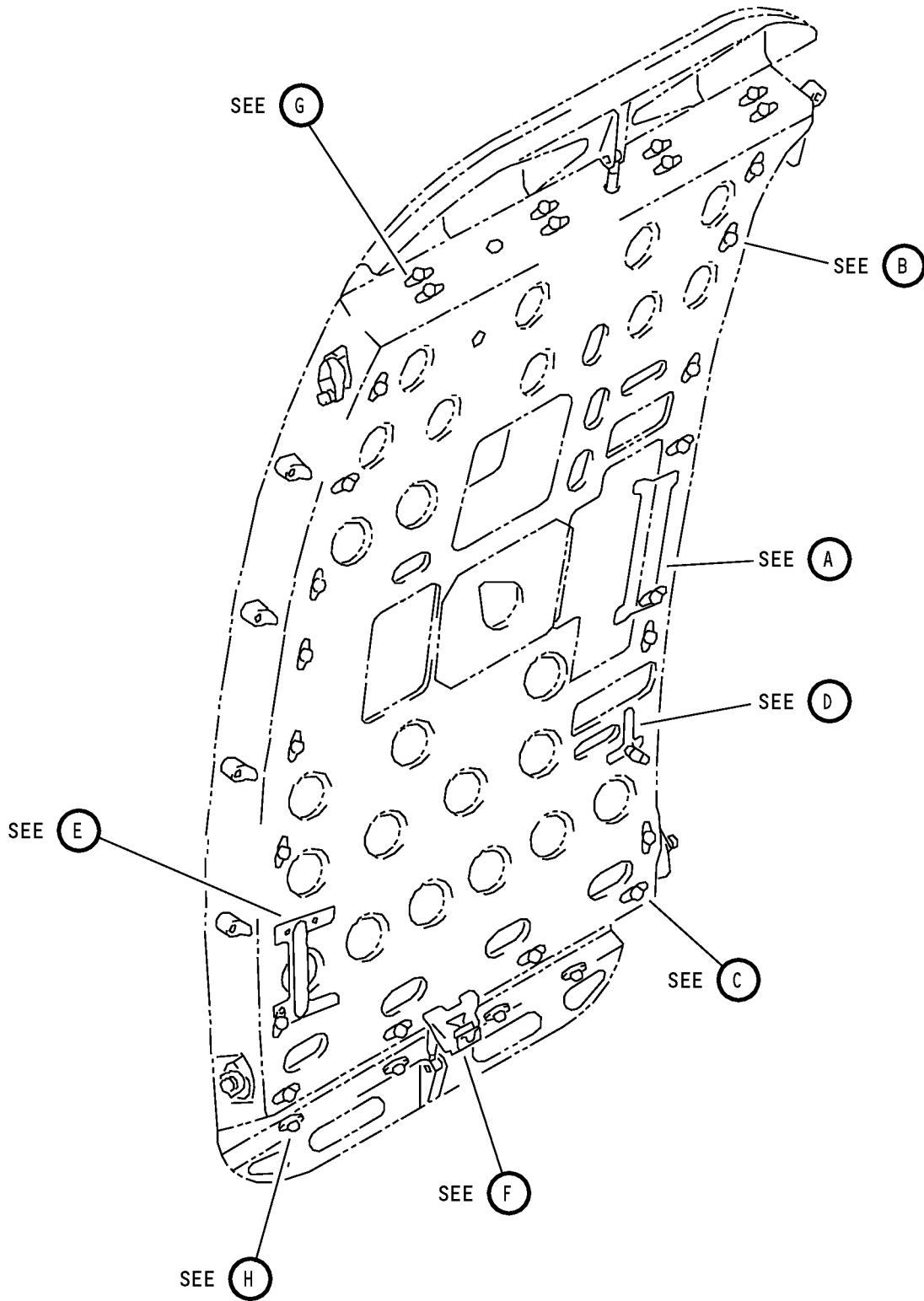
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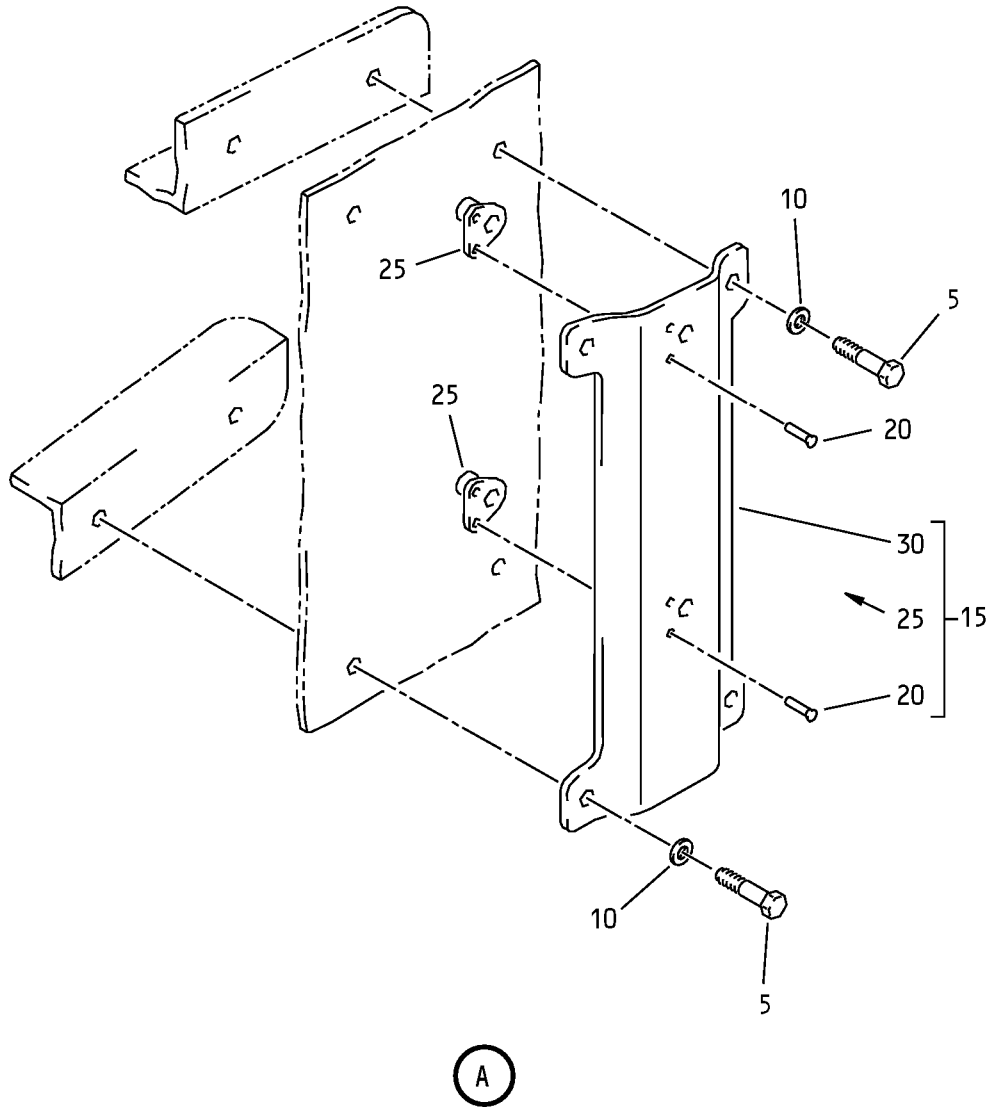
COMPONENT MAINTENANCE MANUAL



Interiors Support Installation
IPL Figure 16 (Sheet 1 of 9)

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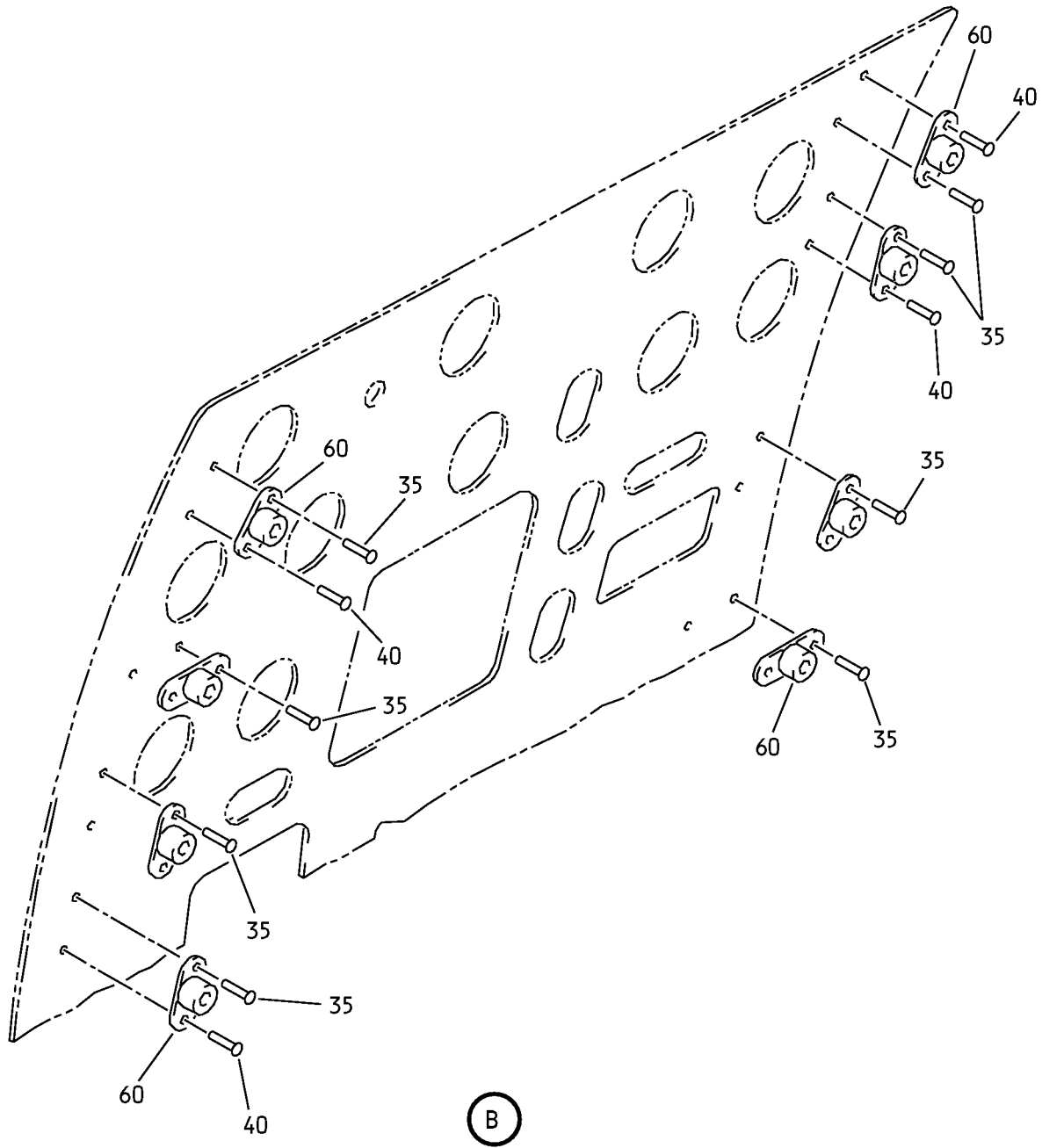


A

Interiors Support Installation
IPL Figure 16 (Sheet 2 of 9)

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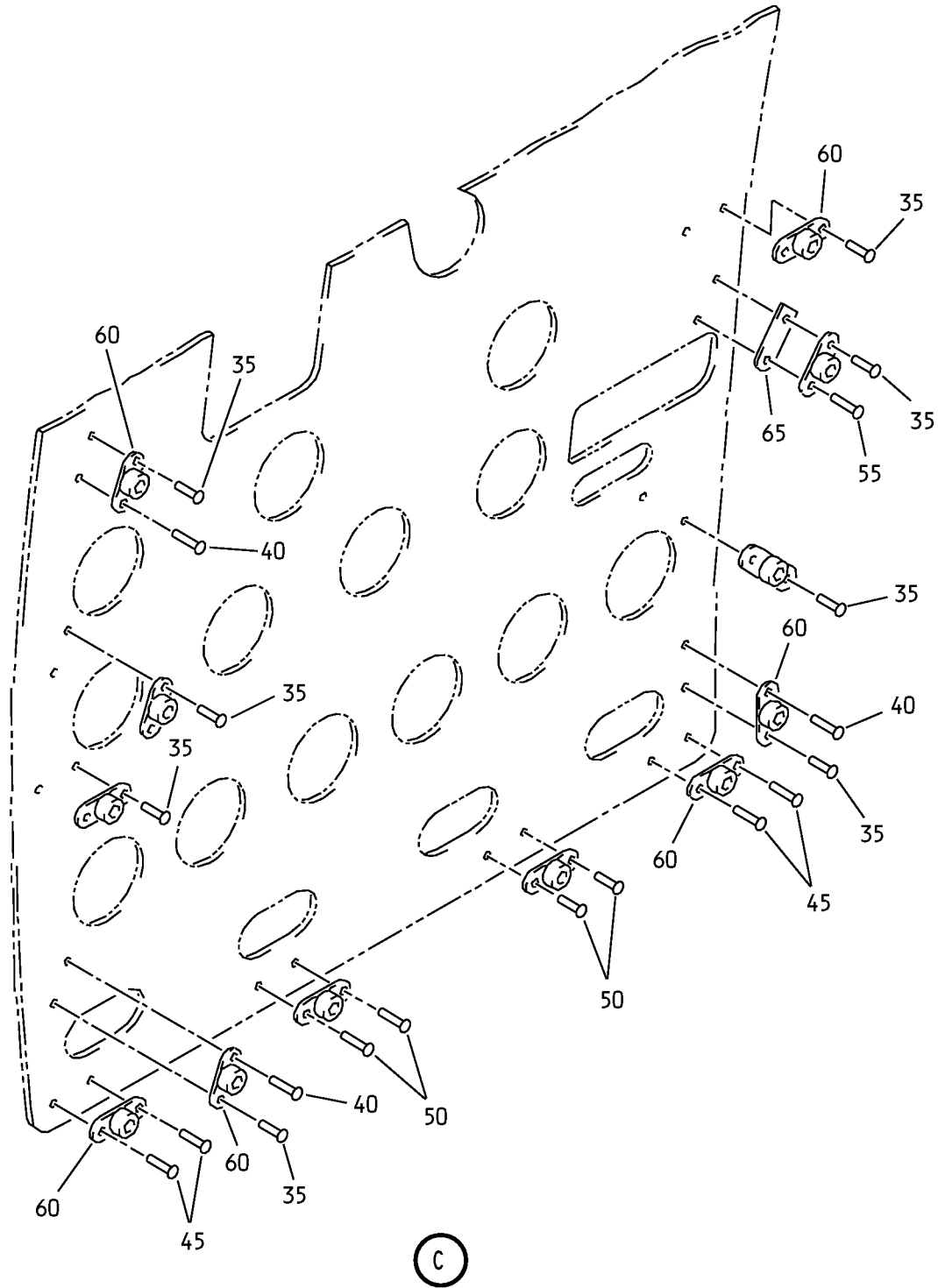
COMPONENT MAINTENANCE MANUAL



Interiors Support Installation
IPL Figure 16 (Sheet 3 of 9)

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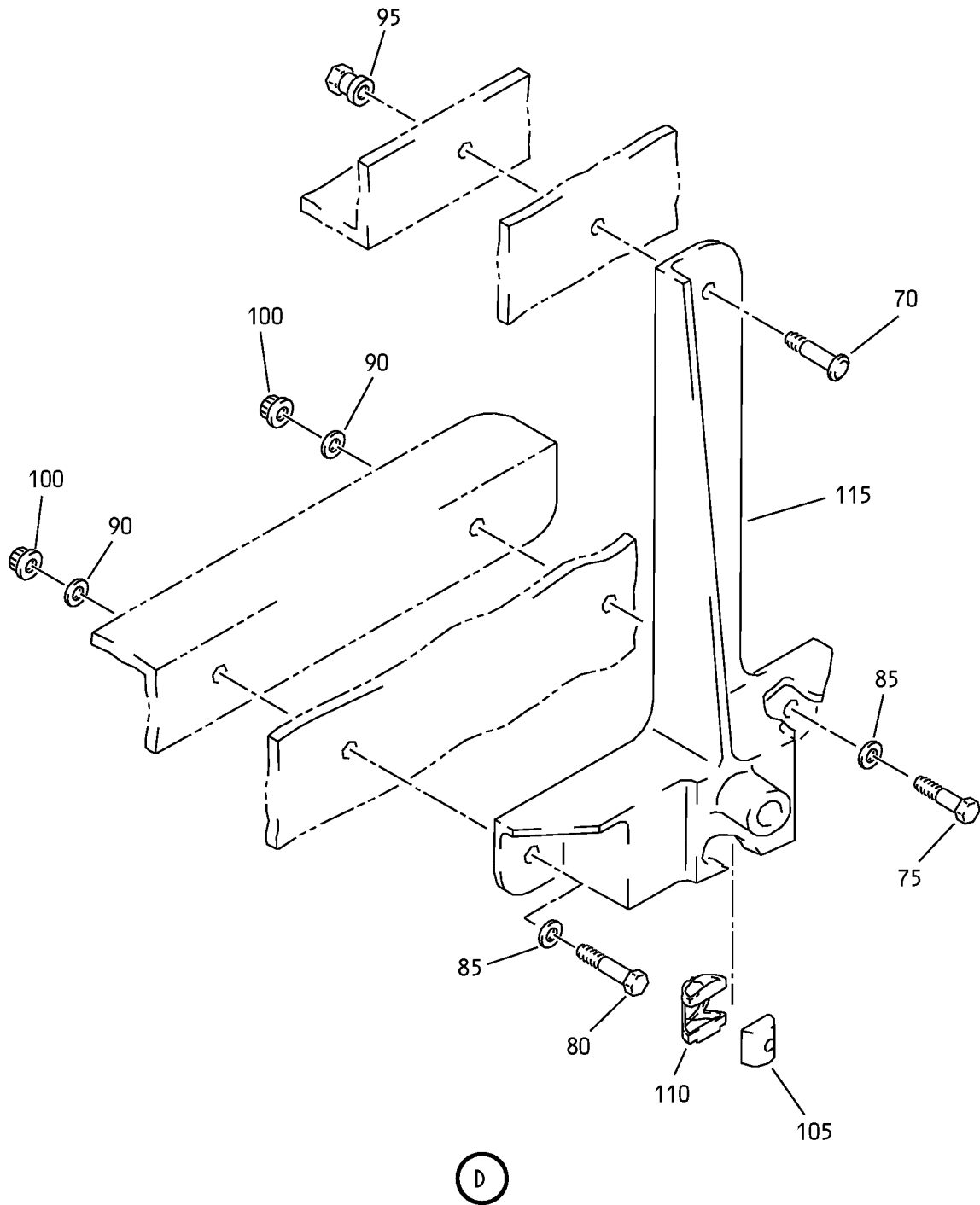
COMPONENT MAINTENANCE MANUAL



Interiors Support Installation
IPL Figure 16 (Sheet 4 of 9)

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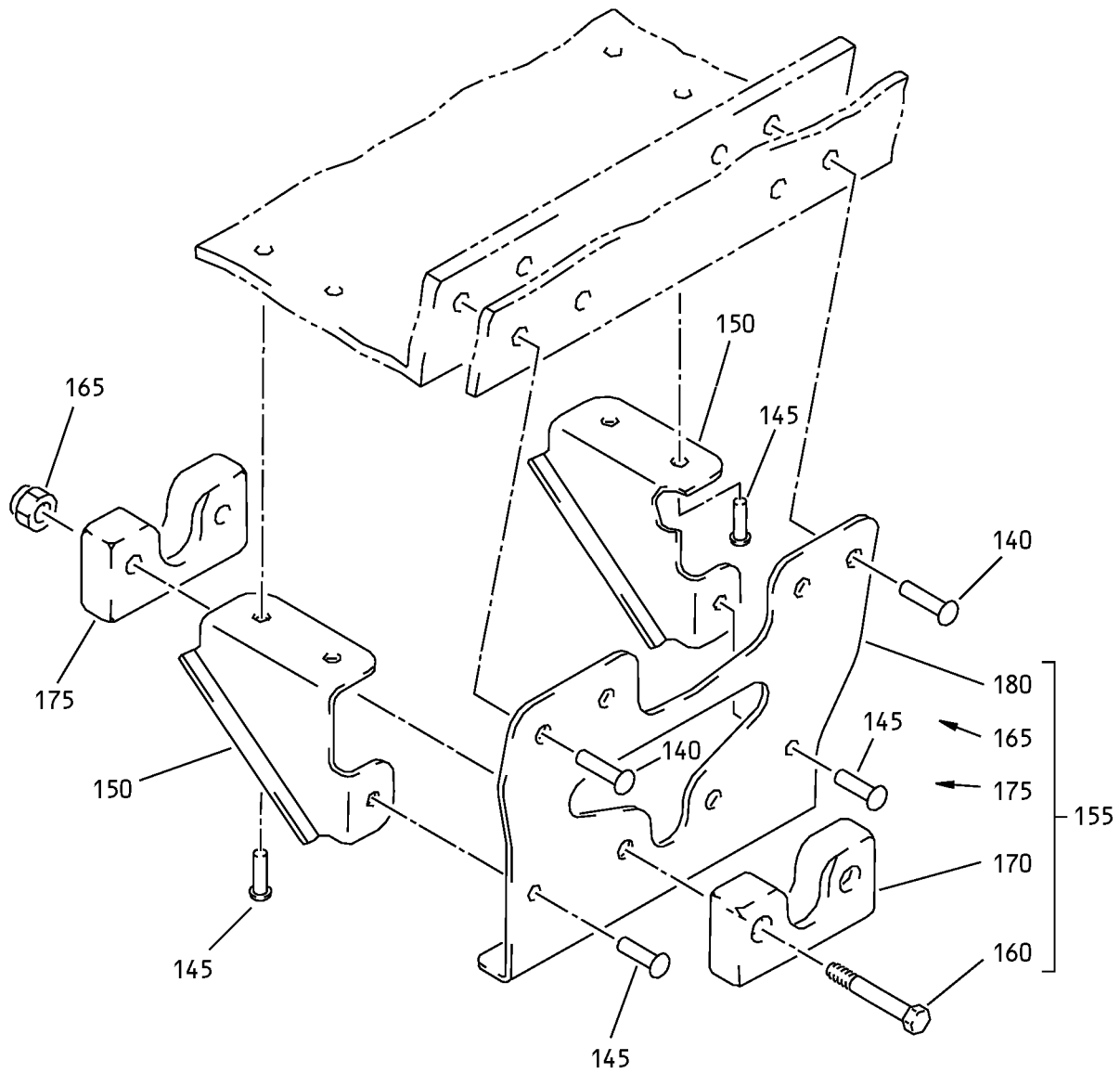
COMPONENT MAINTENANCE MANUAL



Interiors Support Installation
IPL Figure 16 (Sheet 5 of 9)

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F

Interiors Support Installation
IPL Figure 16 (Sheet 7 of 9)

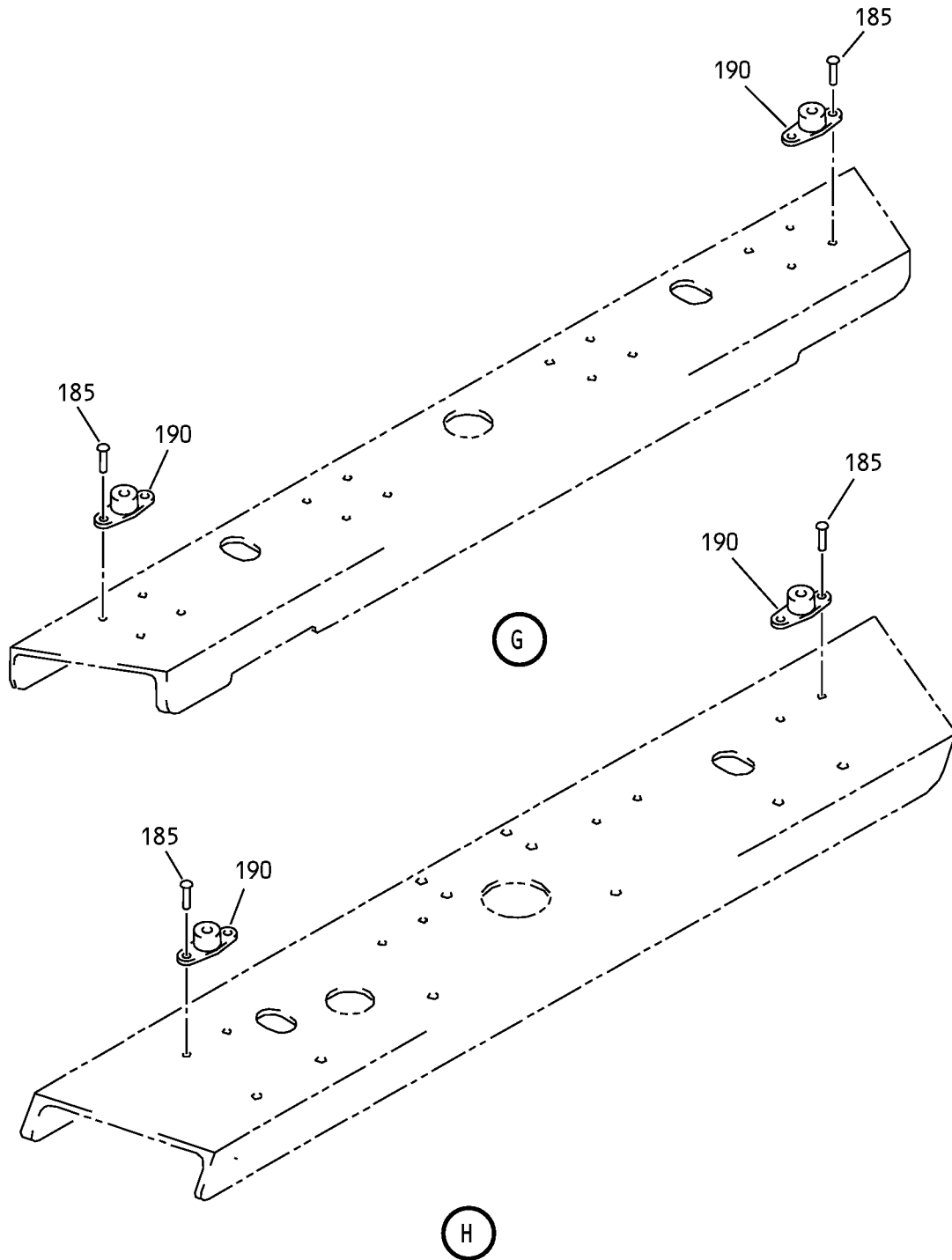
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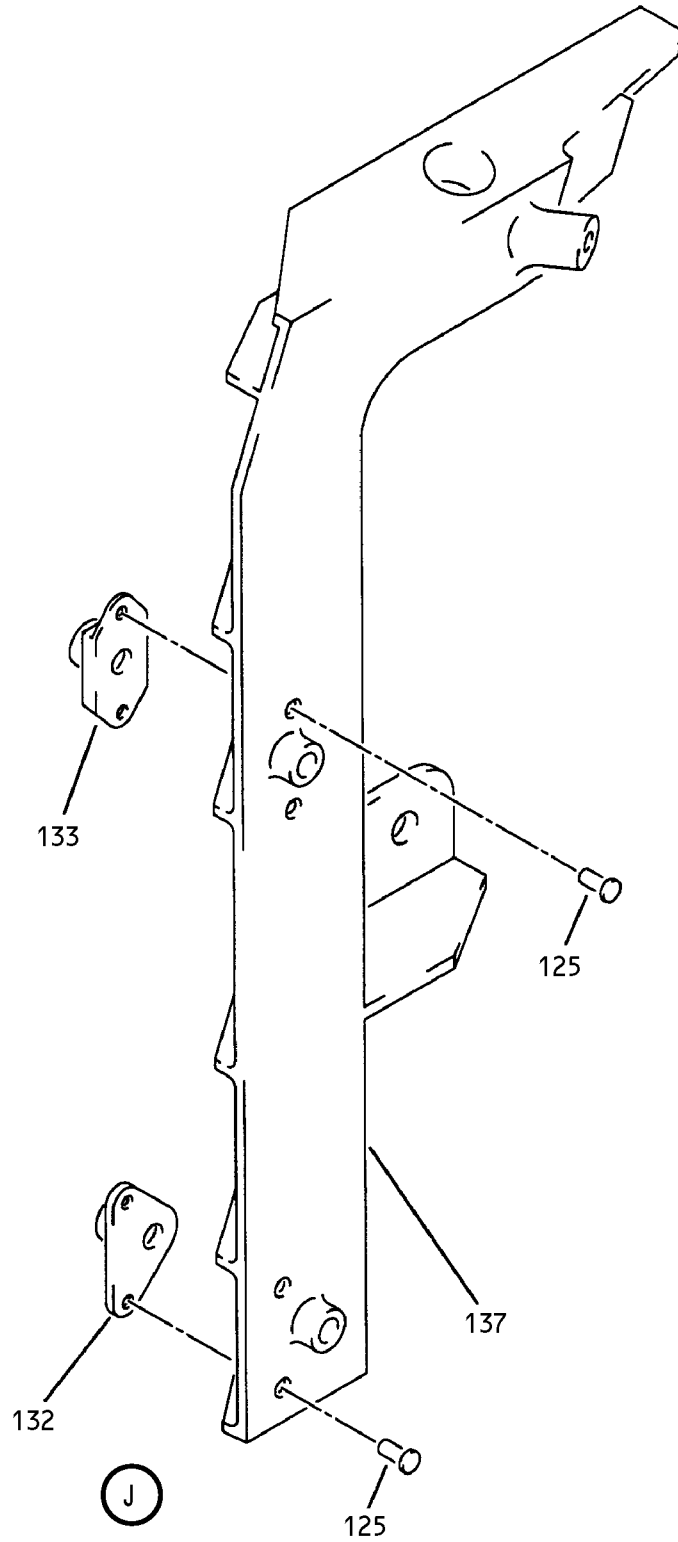
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Interiors Support Installation
IPL Figure 16 (Sheet 8 of 9)

COMPONENT MAINTENANCE MANUAL



Interiors Support Installation
IPL Figure 16 (Sheet 9 of 9)



COMPONENT MAINTENANCE MANUAL

| FIG/ ITEM | PART NUMBER | AIRLINE PART NUMBER | NOMENCLATURE | | | | | | | USAGE CODE | UNITS PER ASSY |
|--------------|-----------------|---------------------------|--------------|---|---|---|---|---|---|---------------|----------------------|
| | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | | |
| 16- | | | | | | | | | | | |
| -1A | 141A6350-1 | | | | | | | | | A | RF |
| -1B | 141A6350-2 | | | | | | | | | A | RF |
| -1C | 141A6350-2 | | | | | | | | | B | RF |
| -1D | 141A6350-3 | | | | | | | | | C-J | RF |
| 5 | BACB30NM3K4 | | | | | | | | | | 4 |
| 10 | BACW10BP3CD | | | | | | | | | | 4 |
| 15 | 141A6345-3 | | | | | | | | | | 1 |
| 20 | BACR15BA3AD | | | | | | | | | | 4 |
| 25 | NS202495-048 | | | | | | | | | | 2 |
| 30 | 141A6345-4 | | | | | | | | | | 1 |
| 35 | BACR15FR6E2 | | | | | | | | | | 24 |
| 40 | BACR15FR6E3 | | | | | | | | | | 7 |
| 45 | BACR15FR6E4 | | | | | | | | | | 4 |
| 50 | BACR15FR6E5 | | | | | | | | | | 4 |
| 55 | MS21141U5P3 | | | | | | | | | | 1 |
| 60 | 141A6266-2 | | | | | | | | | | 20 |
| 65 | BACF3F008E008NN | | | | | | | | | | 1 |

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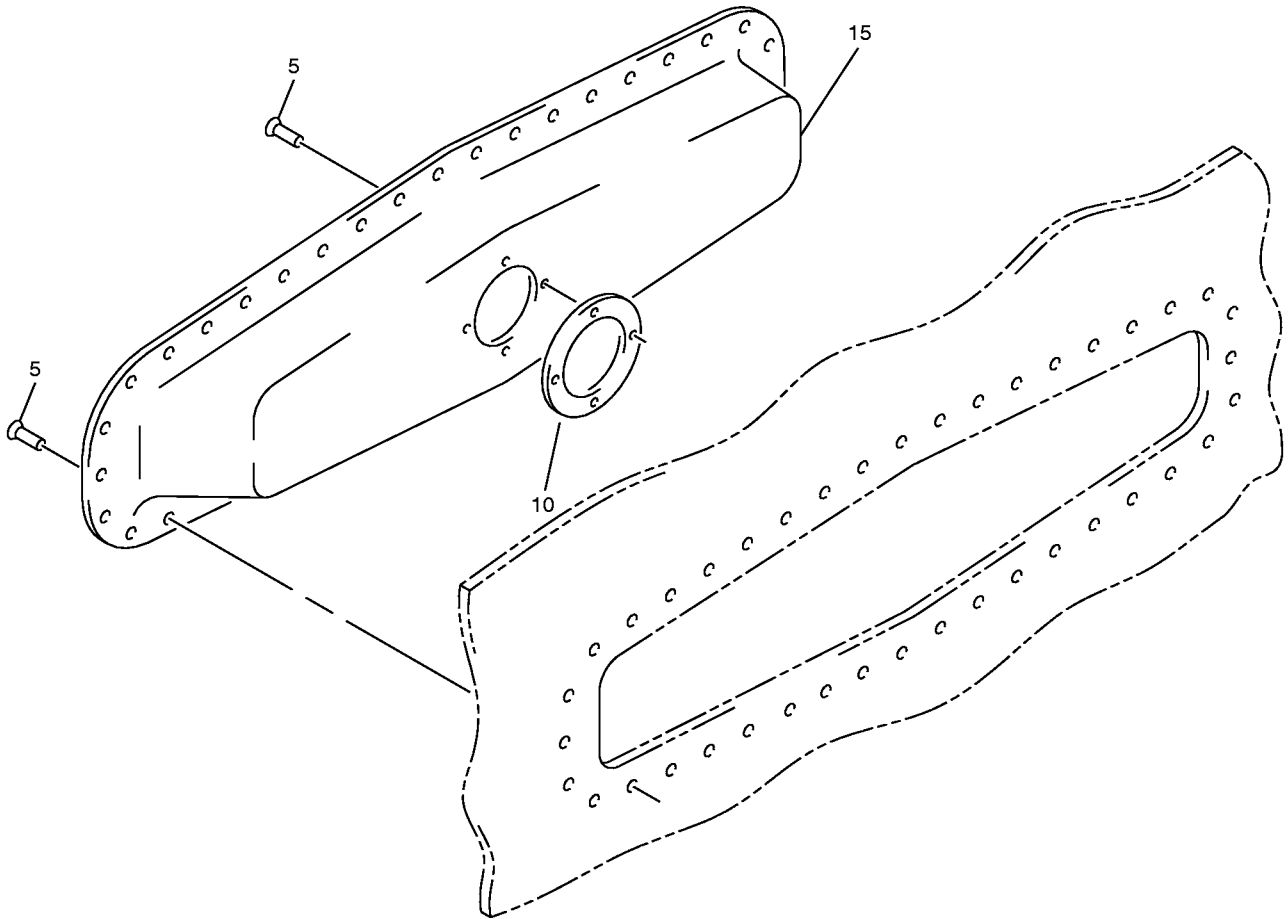
COMPONENT MAINTENANCE MANUAL

| FIG/ ITEM | PART NUMBER | AIRLINE PART NUMBER | NOMENCLATURE | | | | | | | USAGE CODE | UNITS PER ASSY | |
|--------------|-------------|---------------------------|--------------|---|---|---|---|---|---|---------------|----------------------|----|
| | | | 1 | 2 | 3 | 4 | 5 | 6 | 7 | | | |
| 16- 190 | SL2808-3 | | | | | | | | | | | 12 |

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Handle Pan Minor Assembly
IPL Figure 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 | | |
| 17- | | | | | | | | | | | |
| -1A | 141A6210-1 | | | | | | | | | A-J | RF |
| 5 | BACR15GF5D | | | | | | | | | | 44 |
| 10 | 141A6215-1 | | | | | | | | | | 1 |
| 15 | 141A6211-1 | | | | | | | | | | 1 |

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