



# **COMPONENT MAINTENANCE MANUAL WITH ILLUSTRATED PARTS LIST AFT ENTRY DOOR ASSEMBLY**

## **PART NUMBER**

**147A6116-1, -10, -11, -12, -13, -14, -15, -16, -17, -18,  
-19, -2, -20, -21, -22, -23, -24, -26, -27, -28, -29, -3,  
-4, -5**

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## COMPONENT MAINTENANCE MANUAL

Revision No. 14  
Jul 01/2009

To: All holders of AFT ENTRY DOOR ASSEMBLY 52-16-15.

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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Location of Change

Description of Change

NO HIGHLIGHTS

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Number	Date	Date	Initials	Number	Date	Date	Initials



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Date	Initials	Number	Date	Date	Initials

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RECORD OF TEMPORARY REVISION



## COMPONENT MAINTENANCE MANUAL

### INTRODUCTION

#### 1. General

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

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INTRODUCTION

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## COMPONENT MAINTENANCE MANUAL

### AFT ENTRY DOOR ASSEMBLY - DESCRIPTION AND OPERATION

#### 1. Description

A. The aft entry door assembly (DESCRIPTION AND OPERATION, Figure 1) 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 inspections and repair of the latching mechanism.

#### 2. Operation

A. To open the aft 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 move out to the side structure.

#### 3. Leading Particulars (Approximate)

- A. Length – 45.0 inches
- B. Width – 6.0 inches
- C. Height – 77.0 inches
- D. Weight – 139.0 pounds

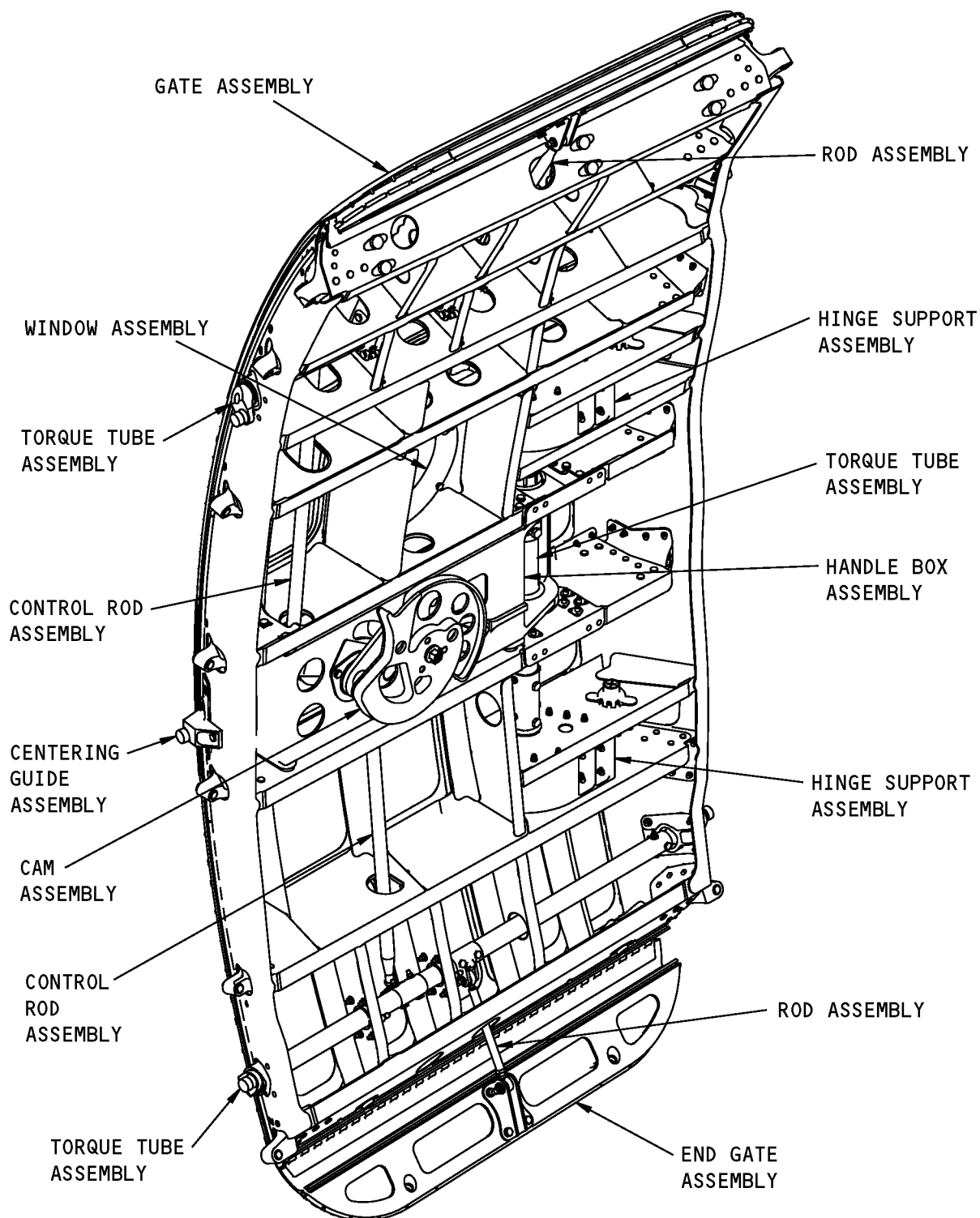
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DESCRIPTION AND OPERATION

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Aft Entry Door Assembly  
Figure 1

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**TESTING AND FAULT ISOLATION**

**(NOT APPLICABLE)**

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TESTING AND FAULT ISOLATION

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## COMPONENT MAINTENANCE MANUAL

### DISASSEMBLY

#### 1. General

- A. This procedure has the data necessary to disassemble the aft 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 2, and IPL Figure 3 for the item numbers.

#### 2. Disassembly

- A. Procedure
  - (1) Use standard industry procedures and the steps that follow to disassemble this component.
  - (2) Do not remove components from the aft entry door assembly that are riveted or bonded unless replacement is necessary.
  - (3) Remove the bracket (IPL Figure 1, 155), the bracket assembly (203), and the stops (110, 113) from the door structure, as follows:
    - (a) Remove the bolts (149), washers (152), and the bracket assembly (155) from the door structure.
    - (b) Remove the bolts (185), washers (188), and the bracket assembly (203) from the door structure.
    - (c) Remove the bolts (101), washers (104), nuts (107), and the stops (110, 113) from the door structure.
  - (4) Remove the retainer lining assembly (248) and the plate covers (IPL Figure 2, 30, 55, 75) from the door structure, as follows:
    - (a) Remove the studs (IPL Figure 1, 251), split rings (254), and the retainer lining (257) from the door structure.
    - (b) Remove the bolts (IPL Figure 2, 5), washers (10), and the plate cover (30) from the door structure.
    - (c) Remove the bolts (35), washers (40), and the plate cover (55) from the door structure.
    - (d) Remove the bolts (60), washers (65), and the plate cover (75) from the door structure.
  - (5) Remove the seal (IPL Figure 1, 50A) and nylon rod (47) from the door structure.
  - (6) Disconnect the end gate assembly (293) and the gate assembly (341) from the control rod assembly (IPL Figure 2, 230) and the rod assembly (105), as follows:
    - (a) Disconnect the end gate assembly (IPL Figure 1, 293) from the control rod assembly (IPL Figure 2, 230), as follows:
      - 1) Remove the bolts (255), washers (260, 270), bushing (265), and the nut (275) to disconnect the end gate assembly (IPL Figure 1, 293) from the control rod assembly (IPL Figure 2, 230).
    - (b) Disconnect the gate assembly (IPL Figure 1, 341) from the rod assembly (IPL Figure 2, 105), as follows:
      - 1) Remove the bolts (80), washers (85, 95), bushing (90), and the nut (100) to disconnect the gate assembly (IPL Figure 1, 341) from the rod assembly (IPL Figure 2, 105).

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- (7) Remove the end gate assembly (IPL Figure 1, 293) and the gate assembly (341) from door structure, as follows:
  - (a) Remove the bolts (260, 263), washers (266), and the hinge assembly (272) with the end gate assembly (293) from the door structure.
  - (b) Remove the bolts (260, 263), washers (266), and the hinge assembly (275) with the gate assembly (341) from the door structure.
- (8) Remove the rod assemblies (IPL Figure 2, 105, 155, 190) and the control rod assembly (230) from the door structure, as follows:
  - (a) Remove the bolt (130), washer (135), nuts (140), and the rod assembly (105) from the door structure.
  - (b) Remove the bolts (130, 145), washers (135, 150), nut (140), and the rod assembly (155) from the door structure.
  - (c) Remove the bolts (180, 215), washers (185, 220), nut (225), and the rod assembly (190) from the door structure.
  - (d) Remove the bolt (215), washer (220), nut (225), and the control rod assembly (230) from the torque tube assembly (370).
- (9) Remove the torque tube assemblies (IPL Figure 2, 310, 370) from the door structure.
  - (a) Remove the torque tube assembly (310), as follows:
    - 1) Remove the bolts (315), washers (325), nuts (330), spacers (430), bearings (435), and cranks (350) from the torque tube (365).
    - 2) Remove the bolts (320), washers (325), nuts (330), and the cranks (355, 360) from the torque tube (365). Slide the torque tube (365) out of the door structure.
    - 3) If necessary, remove the cotter pins (332), nuts (345), washers (340), and the cam follower bearings (335) from the cranks (350).
  - (b) Remove the torque tube assembly (370), as follows:
    - 1) Remove the cotter pins (392), washers (385), nuts (390), spacers (430), bearings (435), and the cranks (410) from the torque tube (425).
    - 2) Remove the bolts (380), washers (385), nuts (390), and the cranks (415, 420) from the torque tube (425). Slide the torque tube (425) out of the door structure.
    - 3) If necessary, remove the cotter pins (392), nuts (405), washers (400), and the cam follower bearings (395) from the cranks (410).
- (10) Remove the fitting assemblies (IPL Figure 2, 450, 465, 480, 495) and housing assemblies (295) from the door structure, as follows:
  - (a) Remove the bolts (IPL Figure 1, 17), washers (20), nuts (23), shims (IPL Figure 2, 440) and the fitting assemblies (450, 480, 495) from the door structure.
  - (b) Remove the bolts (IPL Figure 1, 17, 18), washers (20), nuts (23), shim (IPL Figure 2, 445), and the fitting assembly (IPL Figure 2, 465) from the door structure.
  - (c) Remove the bolts (280), washers (285), nuts (290), and the housing assemblies (295) from the door structure.
- (11) Remove the torque tube assembly (IPL Figure 2, 655) from the door structure, as follows:
  - (a) Remove the bolt (IPL Figure 2, 510), the washer (515), and the nut (520) to disconnect the rod assembly (IPL Figure 3, 340) from the torque tube assembly (IPL Figure 2, 655).

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- (b) If necessary, temporarily remove the bolts (IPL Figure 1, 478), the washers (480), the nuts (481), and the spllices (596, 656) from the beams (638, 701).
  - (c) Remove the bolts (700), the washers (705), and the nuts (710) from the torque tube (755).
  - (d) Remove the packing (640), the washers (645), and the spring (650) from the torque tube (755).
  - (e) Remove the bolts (660) and the washers (665) from the arm assemblies (670, 685).
  - (f) Remove the arm assemblies (670, 685), the pins (730), and the sleeves (735, 750) from the torque tube (755).
  - (g) Loosen the special nuts (740) located on the torque tube (755).
  - (h) Remove the special nuts (740) and the crank (745) from the torque tube (755).
  - (i) Remove the torque tube (755) from the handle box assembly (IPL Figure 2, 545) and the door structure.
- (12) Remove the handle box assembly (IPL Figure 2, 545) from the door structure, as follows:
- (a) Remove the bolts (525), washers (530), and the handle box assembly (545).
  - (b) If necessary, disassemble the handle box assembly (545), as follows:
    - 1) Remove the cotter pins (555), nut (IPL Figure 3, 30), washers (33, 35, 45), and the cam assembly (40) from the shaft assembly (100) and the housing assembly (345).
    - 2) Remove the bolts (5), washers (10), nuts (15), spacer (20), and the handle (25) from the sleeve (60) and the centering cam (65).
    - 3) Remove the sleeve (60), the centering cam (65), and the shaft assembly (100) from the housing assembly (80).
    - 4) If necessary, disassemble the shaft assembly (100) as follows:
      - a) Remove the lock ring (115) from the shaft (135).
      - b) Remove the pin (125) and associated parts from the shaft (135).
      - c) Remove the retaining pin (110) from the washer (105) and the pin (125).
      - d) Remove the nut (120) and the spring (130) from the pin (125).
    - 5) Remove the bolts (70), the washers (75), and the housing assembly (80) from the housing assembly (345).
    - 6) Remove the packing (95) from the housing assembly (80).
    - 7) Remove the bolt (330), washer (335), and the rod assembly (340) from the cocking crank assembly (280).
    - 8) Remove the bolt (180, 185), washers (190, 200), nut (195), and the cam crank assemblies (210, 240) from the housing assembly (345).
    - 9) Disassemble the crank assemblies (210, 240).
      - a) Disassemble the crank assembly (210) as follows:
        - < 1 > Remove the cotter pin (215) from the bearing (230) stud.
        - < 2 > Remove the nut (220), the washer (225), and the bearing (230) from the arm (235).
      - b) Disassemble the crank assembly (240) as follows:
        - < 1 > Remove the cotter pin (245) from the bearing (260) stud.

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- < 2 > Remove the nut (250), the washer (255), and the bearing (260) from the arm (265).
- 10) Remove the washer (275), the ring (300), and the cocking crank assembly (280) from the housing assembly (345).
- 11) Remove the washer (275), and the latching crank assembly (305) from the housing assembly (345).
- 12) Remove the bolts (140, 160, 310, 315), washers (145, 165, 320, 325), nuts (150, 170, 325), and the bearing retainers (155, 175) from the housing assembly (345).
- 13) Remove the retaining ring (50) and the bearing (555) from the housing assembly (345).
- 14) Remove the bearings (205, 270, 336) from the housing assembly (345).
- (13) Remove the upper and lower hinge support assembly (IPL Figure 2, 570, 575) from the door structure.
  - (a) Remove the upper hinge support assembly (575), as follows:
    - 1) Remove the bolts (560), nuts (565), and the upper hinge support assembly (575) from the door structure.
    - 2) Remove the bolts (595, 600), washers (585, 590, 605, 610), nuts (580, 615), and the fitting (625) from the support assembly (635).
  - (b) Remove the lower hinge support assembly (570), as follows:
    - 1) Remove the bolts (560), nuts (565), and the lower hinge support assembly (570) from the door structure.
    - 2) Remove the bolts (595, 600), washers (585, 590, 605, 610), nuts (580, 615), and the fitting (620) from the support assembly (630).
- (14) Remove the window assembly (IPL Figure 1, 827) from the door structure, as follows:
  - (a) Remove the bolts (821), washers (824), and the window assembly (827) from the door structure.
- (15) Remove the centering guide assembly (IPL Figure 1, 62) from the door structure, as follows:
  - (a) Remove the bolts (53), washers (59), and the centering guide assembly (62) from the door structure.
  - (b) Remove the nut (67), washer (55), and the bearing (65) from the fitting (68).
- (16) If necessary, remove the plate (IPL Figure 1, 872) and marker (875) from the door structure.

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### CLEANING

#### 1. General

- A. This procedure has the data necessary to clean the aft 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 2, and IPL Figure 3 for the 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 following bearings as specified in SOPM 20-30-01:
  - (a) IPL Figure 1, Bearing (65)
  - (b) IPL Figure 2, Bearings (115, 120, 165, 170, 200, 205, 240, 245, 300, 335, 395, 435)
  - (c) IPL Figure 3, Bearing (55, 205, 230, 260, 270)
- (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 2, IPL Figure 3 for the 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 practices to do a visual check of all the parts for defects. Do the penetrant or magnetic particle check on the parts that follow if a visual check shows possible damage or if you think there is possible damage:
- (2) Do a magnetic particle check (SOPM 20-20-01) of these parts:
  - (a) IPL Figure 2
    - 1) Crank (355, 360, 415, 420, 745)
    - 2) Tube (365, 425, 755)
    - 3) Sleeve (735, 750)
  - (b) IPL Figure 3
    - 1) Fitting (90)
    - 2) Shaft (135)
    - 3) Arm (235)
- (3) Do a penetrant check (SOPM 20-20-02) of these parts:
  - (a) IPL Figure 1
    - 1) Fitting (68, 502N, 502P, 502R, 533, 536, 539, 572, 575, 632, 635, 695, 698, 722, 725, 758, 761)
    - 2) Channel (83)
    - 3) Spacer (140, 209)
    - 4) Retainer (257)
    - 5) Hinge (284, 287, 290)
    - 6) Gate (338, 386)
    - 7) Beam (503, 578, 638, 701, 728, 788, 791)
  - (b) IPL Figure 2
    - 1) Rod (175, 175A, 210)

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CHECK

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- 2) Crnk (350, 410)
  - 3) Fitting (460, 475, 490, 505, 620, 625)
  - 4) Support (638, 639)
  - 5) Arm (680, 695)
- (c) IPL Figure 3
- 1) Handle (25)
  - 2) Cam Plate (42)
  - 3) Sleeve (60)
  - 4) Washer (105)
  - 5) Nut (120)
  - 6) Pin (125)
  - 7) Bearing Retainer (155, 175)
  - 8) Arm (265, 295)
  - 9) Crank (308)
  - 10) Housing (380)

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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:**

<b>PART NUMBER</b>	<b>NAME</b>	<b>REPAIR</b>
—	REFINISH OF OTHER PARTS	1-1
141A6306	CRANK ASSEMBLY	2-1, 2-2
147A6128	STOP ASSEMBLY	3-1, 3-2
147A6130	CENTERING GUIDE ASSEMBLY	4-1, 4-2
147A6139	TORQUE TUBE ASSEMBLY	5-1
69-37418	CRANK	5-2
66-14530, 66-14531	CRANK	5-3
60-4406	LATCH TORQUE TUBE	5-4
147A6140	SUPPORT ASSEMBLY	6-1, 6-2
147A6144	CLEVIS ASSEMBLY	7-1, 7-2
147A6146	GATE ASSEMBLY	8-1, 8-2
147A6107	HOUSING ASSEMBLY	9-1, 9-2
65-2306	HOUSING ASSEMBLY	10-1, 10-2
65-28925	ROD ASSEMBLY	11-1, 11-2
69-18187	CONTROL ROD ASSEMBLY	12-1, 12-2
90-7815	CAM CRANK ASSEMBLY	13-1, 13-2

#### 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
- 2.000** THEORETICALLY EXACT DIMENSION IS 2.000  
OR  
2.000  
BSC

True Position Dimensioning Symbols  
Figure 601

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REPAIR - GENERAL

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## COMPONENT MAINTENANCE MANUAL

### REFINISH OF OTHER PARTS - REPAIR 1-1

#### 1. General

- A. This procedure has the data necessary 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 2, or IPL Figure 3 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
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
C00700	Coating - Exterior Protective Enamel, Gray Gloss Enamel	BMS10-60, Type I, BAC 707
C50069	Coating - Enamel, Color 702 Gloss White	BMS10-11, 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 of 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 are for the repair of the initial finish.

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REPAIR 1-1

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## COMPONENT MAINTENANCE MANUAL

**Table 601:** Refinish Details

IPL FIG. & ITEM	MATERIAL	FINISH
IPL Fig. 1		
Seal Retainer (29,32,35,38,41,44, 320,323,326,329, 374,377,380,383)	Al Alloy	Boric acid-sulfuric acid anodize (F-17.31) and apply primer, C00259 (F-20.03).
Rod (47)	Nylon	Apply no finish (F-6.10).
Serrated Plate (71)	Al Alloy	Boric acid-sulfuric acid anodize (F-17.31) and apply primer, C00259 (F-20.03). No primer, C00259 on serrated surfaces.
Channel (83)	Al Alloy	Boric acid-sulfuric acid anodize (F-17.31) and apply primer, C00259 (F-20.03).
Stop (110,113)	Nylon	Apply no finish (F-25.01).
Bracket (119,155,182,224)	Al Alloy	Chemical treat (F-17.07) and apply primer, C00259 (F-20.02).
Spacer (140,209)	Al Alloy	Boric acid-sulfuric acid anodize (F-17.31). Apply primer, C00259 (F-20.02) and enamel coating, C00260 (F-21.03) but no primer, C00259 or paint in the inside diameter.
Back Plate (164,223)	Al Alloy, HT TR T6	Chemical treat (F-17.07) and apply primer, C00259 (F-20.02).
Collar (179)	Al Alloy or Steel Alloy, 125-145 ksi	F-18.05 for Al alloy and F-1.302 for Steel alloy.
Bracket (182)	Al Alloy	Chemical treat (F-17.07) and apply primer, C00259 (F-20.02).
Retainer (257)	Al Alloy	Chemical treat (F-17.07) and apply primer, C00259 (F-20.03).
Hinge (284,287,290)	Al Alloy	Boric acid-sulfuric acid anodize (F-17.35). Apply primer, C00259 (F-20.03) but do not put primer, C00259 in the holes for the hinge pin and the spring pin.
Plate Assembly (302)	Al Alloy	Apply no finish (F-25.01).
Plate (304,815)	Al Alloy	Boric acid-sulfuric acid anodize (F-17.31). Apply primer, C00259 (F-20.03).
End Gate (386)	Magnesium Alloy	Anodize (F-17.12), apply primer, C00259 (F-20.03), and apply enamel coating, C00700 (SRF-14.9813) on all surfaces but no on surfaces identified by flagnote 1 in REPAIR 1-1, Figure 601. Apply Type 27 abrasion resistant finish (SRF-14.9624) on those surfaces. No enamel coating, C00700 in the holes for the bolts.
Beam (503,539,578, 638,701,728,764,788,791)	Al Alloy	Boric acid-sulfuric acid anodize (F-17.31). Apply primer, C00259 (F-20.03).
Bushing (502E,530A, 569,629,692,719,755)	15-5PH CRES, 150-170 ksi	Cadmium plate (F-15.06), optional to cad plate the inside diameter of the bushing.

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REPAIR 1-1

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## COMPONENT MAINTENANCE MANUAL

**Table 601: Refinish Details (Continued)**

IPL FIG. & ITEM	MATERIAL	FINISH
Splice (596,656)	Al Alloy	Boric acid-sulfuric acid anodize (F-17.31). Apply primer, C00259 (F-20.03).
Filler (602,662)	Al Alloy	Boric acid-sulfuric acid anodize (F-17.31). Apply primer, C00259 (F-20.03).
Retainer (785), Cap (797), Plunger (800), Spring (803), Housing (806)	Plastic	No finish.
Pan (818)	Al Alloy	Chemical treat (F-17.07) and apply primer, C00259 (F-20.03) on interior surfaces. Apply no finish (F-25.01) on exterior surfaces.
Clip (839A)	Al Alloy	Cadmium plate (F-15.06) and apply primer, C00259 (F-20.02). Apply enamel coating, C50069 (F-21.28-702, which replaces SRF-14.905-702).
Clip (839B, 840)	301 CRES	Cadmium plate (F-15.06) and apply primer, C00259 (F-20.02). Apply enamel coating, C50069 (F-21.28-702).
Seal (848)	Rubber	No finish (F-7.10).
Seal (848A)	Rubber	No finish (F-25.01).
Retainer (851)	Al Alloy	Chemical treat or chromic acid anodize and apply primer, C00259 (SRF-2.30) but not on the surfaces identified by flagnote 1 in REPAIR 1-1, Figure 602.
Retainer (851A)	Al Alloy	Chemical treat (F-17.07) and apply primer, C00259 (F-20.03). Apply enamel coating, C00033 (F-19.39-702) on the surface identified in REPAIR 1-1, Figure 603.
Seal (854)	Rubber	No finish (F-25.01).
Pane (857B,860B)	Acrylic	No finish (F-6.10).
Pane (857C,860C)	Acrylic	Apply Pilkington Aerospace SS-6782 acrylic hard coating (F-30.019), edges optional. This is a vendor-proprietary coating. Only the vendor can apply it.
Doubler (869)	Al Alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.35). Apply primer, C00259 (F-20.03) but do not put primer, C00259 on the surfaces identified by flagnote 1 in REPAIR 1-1, Figure 604.
IPL Fig. 2		
Plate (30,55,75)	Al Alloy	Chemical treat (F-17.07) and apply primer, C00259 (F-20.03).
Spacer (430)	301 CRES, 150-170 ksi	Passivate (F-17.09).
Shim (440,445)	Al Alloy	Apply no finish (F-25.01).

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## COMPONENT MAINTENANCE MANUAL

**Table 601:** Refinish Details (Continued)

IPL FIG. & ITEM	MATERIAL	FINISH
Fitting (460,475,490,505)	Al Alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.35). Apply primer, C00259 (F-20.03), but not in the 1.3750 - 1.3770 inch diameter hole.
Fitting (620)	Al Alloy	Boric acid-sulfuric acid anodize (F-17.31). Apply primer, C00259 (F-20.03).
Fitting (625)	Al Alloy	Anodize and apply primer, C00259 (F-18.04).
Arm (680,680A)	Al Alloy	Chemical treat or chromic acid anodize and apply primer, C00259 (SRF-2.30). Apply enamel coating, C00260 (F-21.03).
Arm (680B)	Al Alloy	Boric acid-sulfuric acid anodize (F-17.31). Apply primer, C00259 (F-20.02). Apply enamel coating, C00260 (F-21.03).
Arm (680C)	Al Alloy	Boric acid-sulfuric acid anodize (F-17.31). Apply primer, C00259 (F-20.02) but do not put primer, C00259 in the splined hole.
Arm (695)	Al Alloy	Chemical treat or chromic acid anodize and apply primer, C00259 (F-18.05). Apply enamel coating, C00033 (F-21.25).
Sleeve (735)	15-5PH CRES 180-200 ksi	Passivate (F-17.25).
Nut (740)	Al Alloy	Chromic acid anodize (F-17.04).
Tube (755)	15-5PH CRES 180-200 ksi	Cadmium plate (F-15.02 or F-16.06) the outside diameter. Cadmium plate throw-in is permitted on the inside diameter.
IPL Fig. 3		
Spacer (20)	Al Alloy	Chemical treat or chromic acid anodize and apply primer, C00259 (F-18.05).
Handle (25)	Al Alloy	Sulfuric acid anodize (F-14.2998) the outside surface.
Washer (35)	301 CRES or 15-5PH CRES	Cadmium plate (F-15.06).
Cam Plate (42)	Al Alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.35). Apply primer, C00259 (F-20.03) but not in 0.6563-0.6578 and 0.323-0.330 inch holes.
Sleeve (60)	Al-Ni-Br	Apply lubricant, D00113 (F-19.10).
Centering Cam (65)	Al-Br	Cadmium plate (F-4.201).
Washer (105)	Al-Ni-Br	Cadmium plate (F-1.202).
Nut (120)	Al Alloy	Anodize (F-2.20).
Pin (125)	303 CRES	No finish (F-8.05).
Spring (130)	Wire, Music	Cadmium plate (F-1.1923).
Shaft (135)	15-5PH CRES 150-170 ksi	Passivate (F-17.25) and cadmium plate (F-15.06) on the smaller spline. Apply lubricant, D00113 on the larger spline.

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**Table 601:** Refinish Details (Continued)

IPL FIG. & ITEM	MATERIAL	FINISH
Bearing Retainer (155,175)	Al Alloy	Chemical treat or chromic acid anodize (F-17.01) and apply primer, C00259 primer (F-20.02).
Washer (200)	301 CRES	Cadmium plate (F-15.06) and apply primer, C00259 (F-20.02).
Arm (295)	Al Alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.35). Apply primer, C00259 (F-20.03) but not on the splined surfaces.
Crank (308)	Al Alloy	Chemical treat or chromic acid anodize and apply primer, C00259 (SRF-2.30). Do not put primer, C00259 on the splined surfaces.
Bushing (365A)	Al-Ni-Br	Cadmium plate (F-15.02); cad plate in the bore is optional.
Filler (370,375)	Al Alloy	Boric acid-sulfuric acid anodize (F-17.31). Apply primer, C00259 (F-20.02).

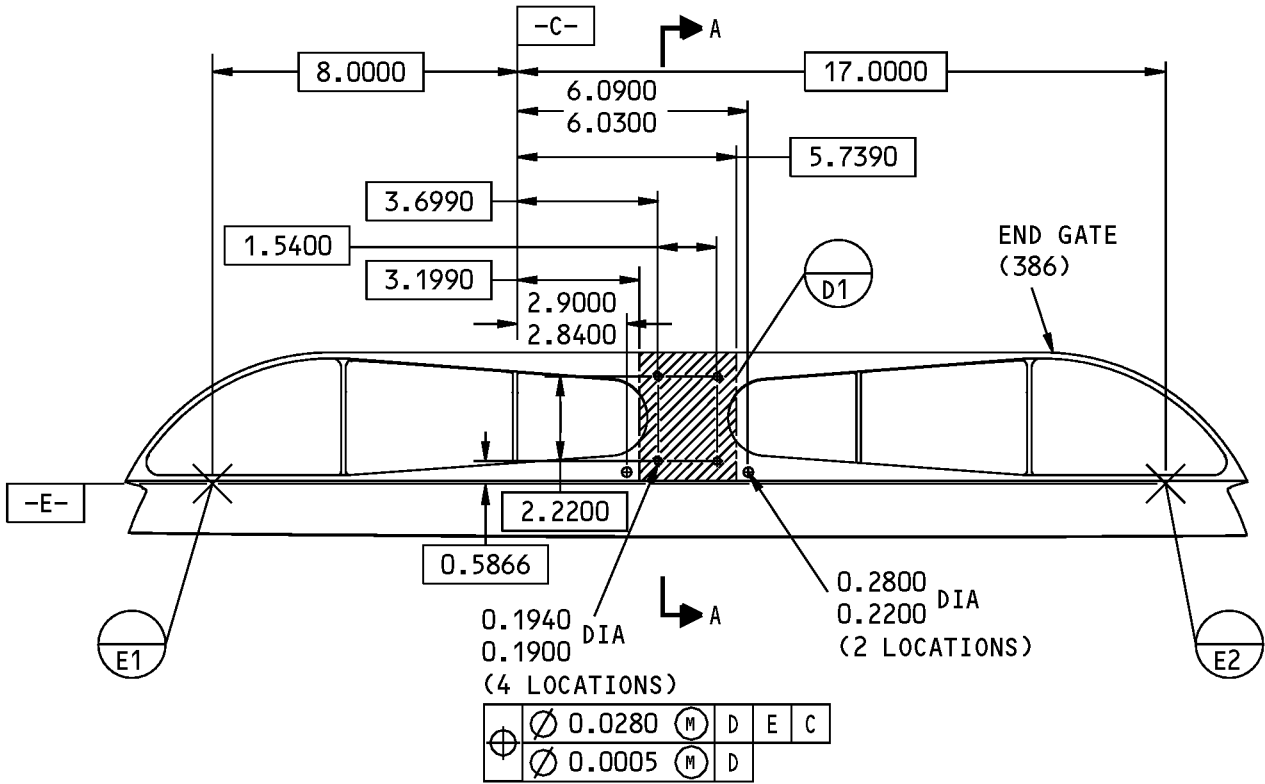
# 52-16-15

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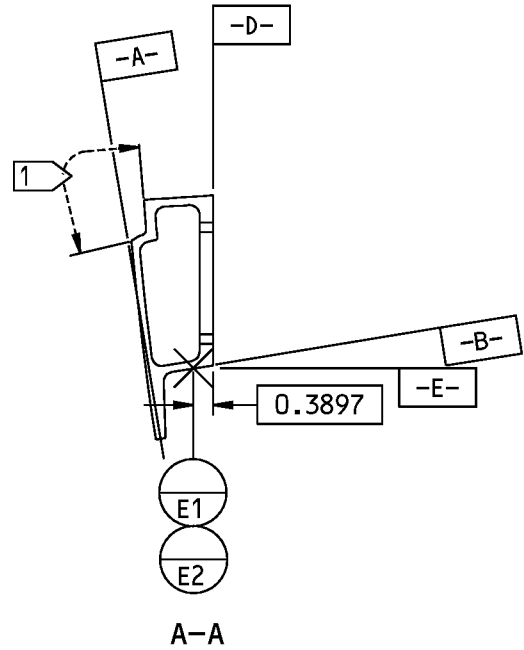
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147A6147-3 SHOWN  
 147A6147-1,-4 ALMOST THE SAME



1 APPLY TYPE 27 ABRASION RESISTANT FINISH (SRF-14.9624) ON THESE SURFACES

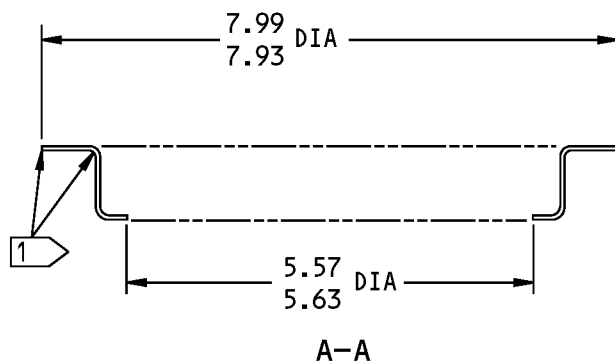
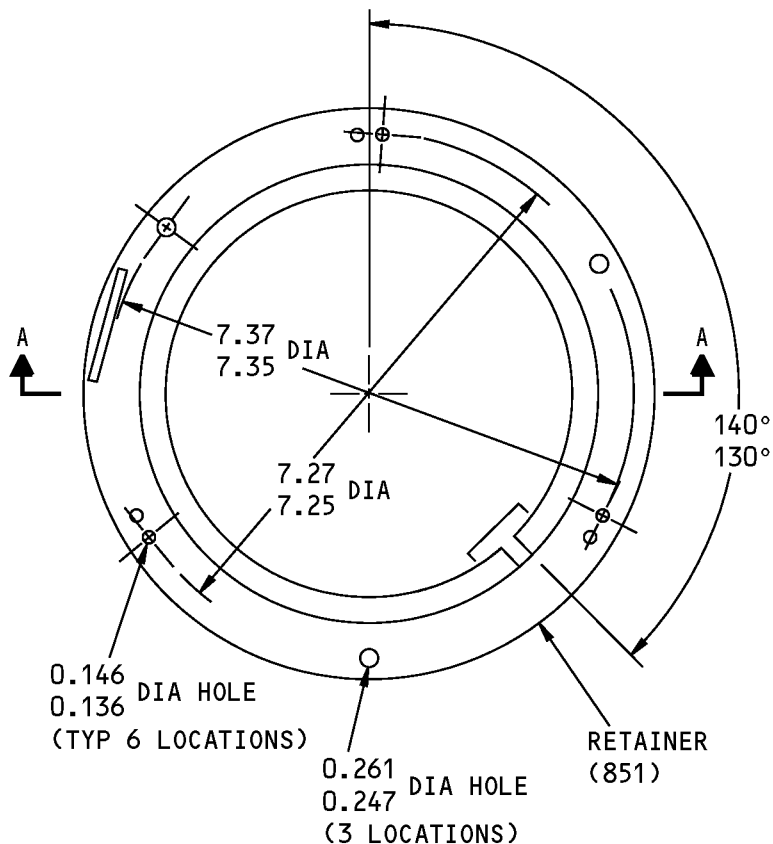
ITEM NUMBERS REFER TO IPL FIG. 1  
 ALL DIMENSIONS ARE IN INCHES

147A6147-1,-3,-4 End Gate Refinish  
 Figure 601

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DO NOT PRIME THIS SURFACE

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

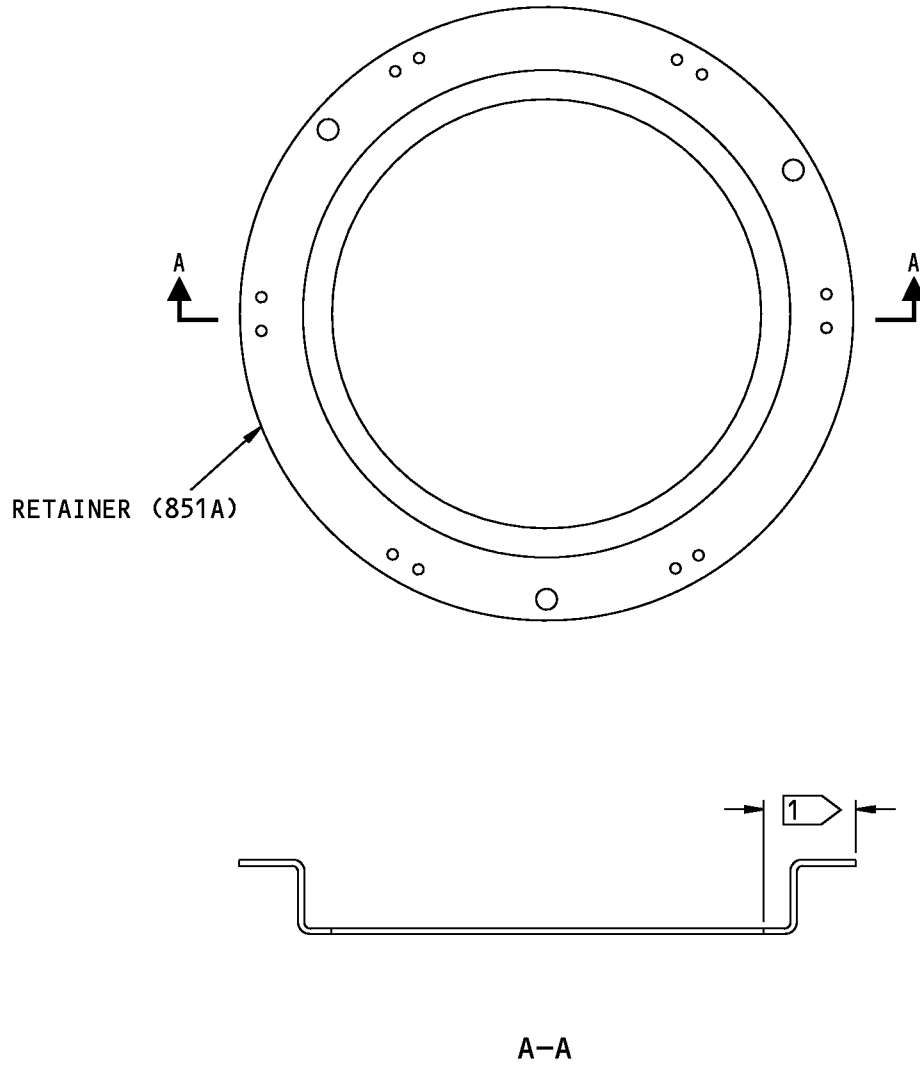
69-1983-7 Retainer Refinish  
Figure 602

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1 APPLY BMS 10-60 ENAMEL (F-19.39-702) ON THIS SURFACE

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

1632970 S0000298841\_V1

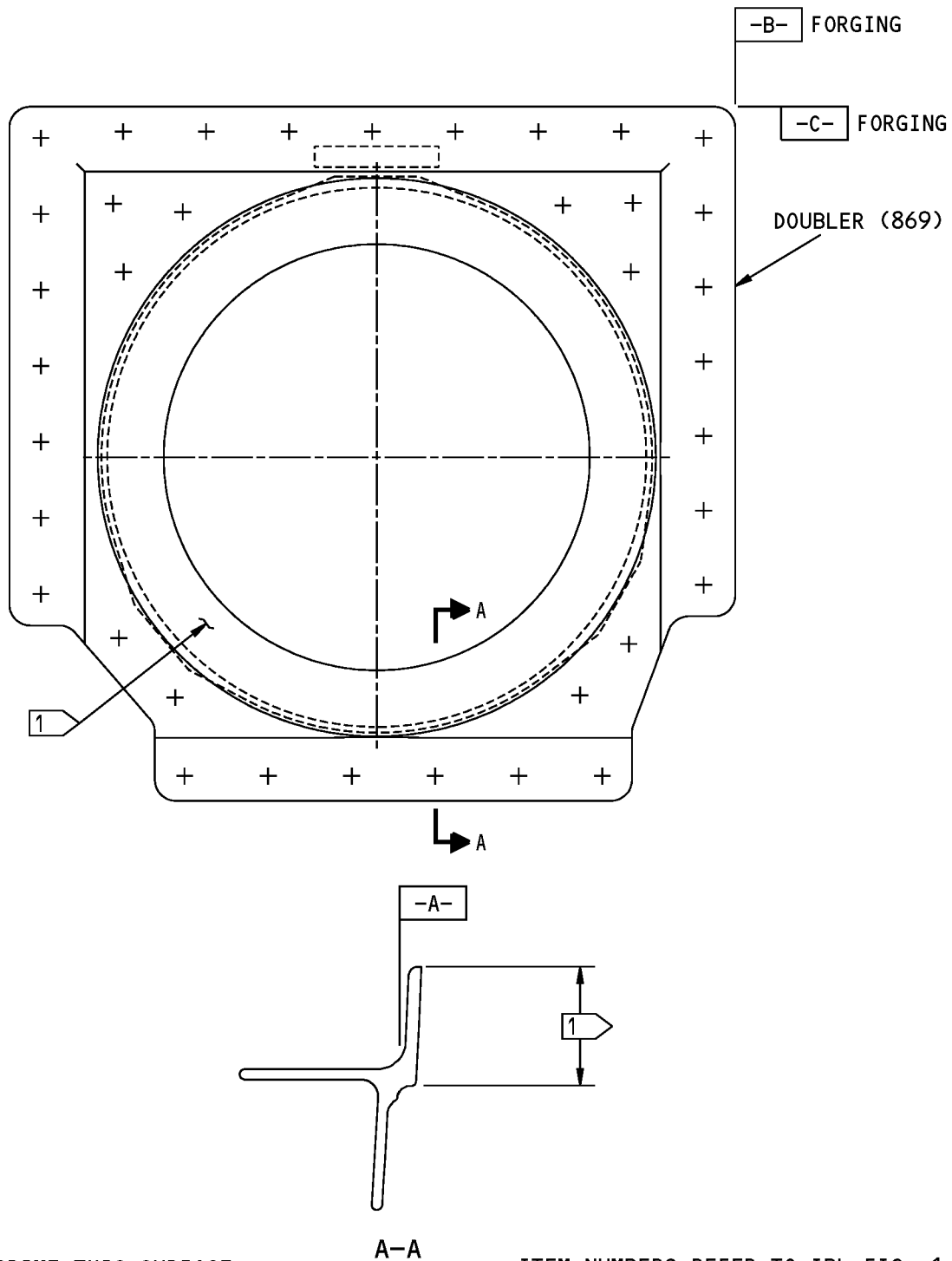
141A6572-1 Retainer Refinish  
Figure 603

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DO NOT PRIME THIS SURFACE

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

149A6112-1 Doubler Refinish  
Figure 604

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## COMPONENT MAINTENANCE MANUAL

### CRANK ASSEMBLY - REPAIR 2-1

141A6303-3

#### 1. General

- A. This procedure has the data necessary to repair the crank assembly.
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 3 for the 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 20-50-02	INSTALLATION OF SAFETYING DEVICES
SOPM 20-60-04	MISCELLANEOUS MATERIALS

- C. Procedure

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

- (1) Remove the cotter pin (215) from the nut (220) and the cam follower bearing (230) as shown in REPAIR 2-1, Figure 601.
- (2) Remove the nut (220), washer (225), and the cam follower bearing (230) from the crank arm (235).
- (3) Apply corrosion preventive compound, C00308 to the threads of the replacement cam follower bearing (230) and install it onto the crank arm (235).
- (4) Install the washer (225) and nut (220) onto the cam follower bearing (230). Tighten the nut (220) to 55 pound-inch and back the nut off to the first slot that aligns with the hole in the cam follower stud.
- (5) Install the cotter pin (215) onto the cam follower bearing (230) stud as specified in SOPM 20-50-02.

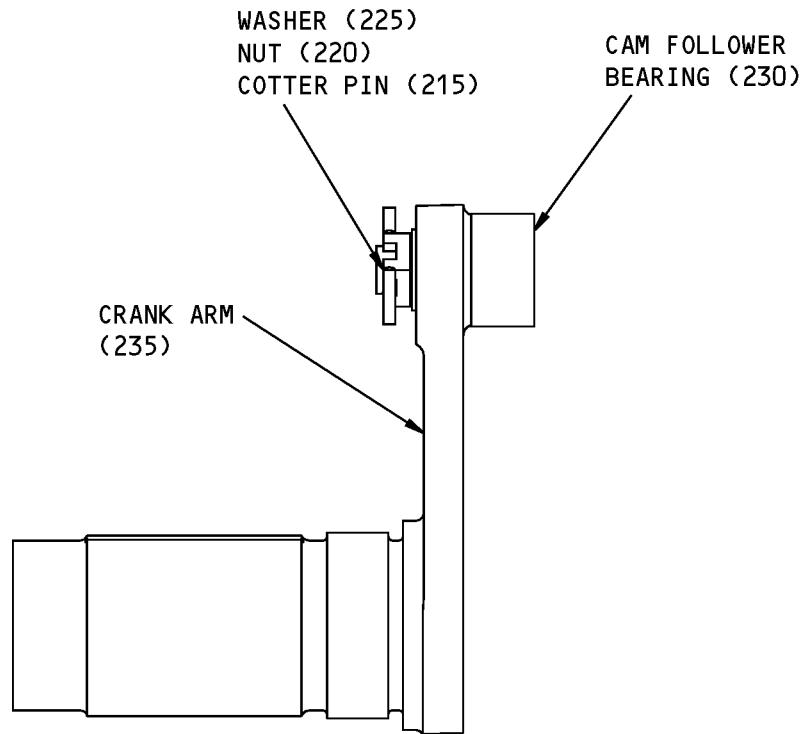
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REPAIR 2-1

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141A6306-3 Crank Assembly Repair  
Figure 601

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REPAIR 2-1

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## COMPONENT MAINTENANCE MANUAL

### CRANK ARM - REPAIR 2-2

141A6306-2

#### 1. General

- A. This procedure has the data necessary to refinish the crank arm (235).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 3 for the item numbers.
- E. General repair details:
  - (1) Material:15-5PH CRES
    - (a) 180-200 ksi

#### 2. Crank Arm Refinish

- A. Procedure

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

- (1) Passivate (F-17.25).
- (2) Apply cadmium plate (F-15.20) to the surfaces identified by flagnote 1 in REPAIR 2-2, Figure 601.

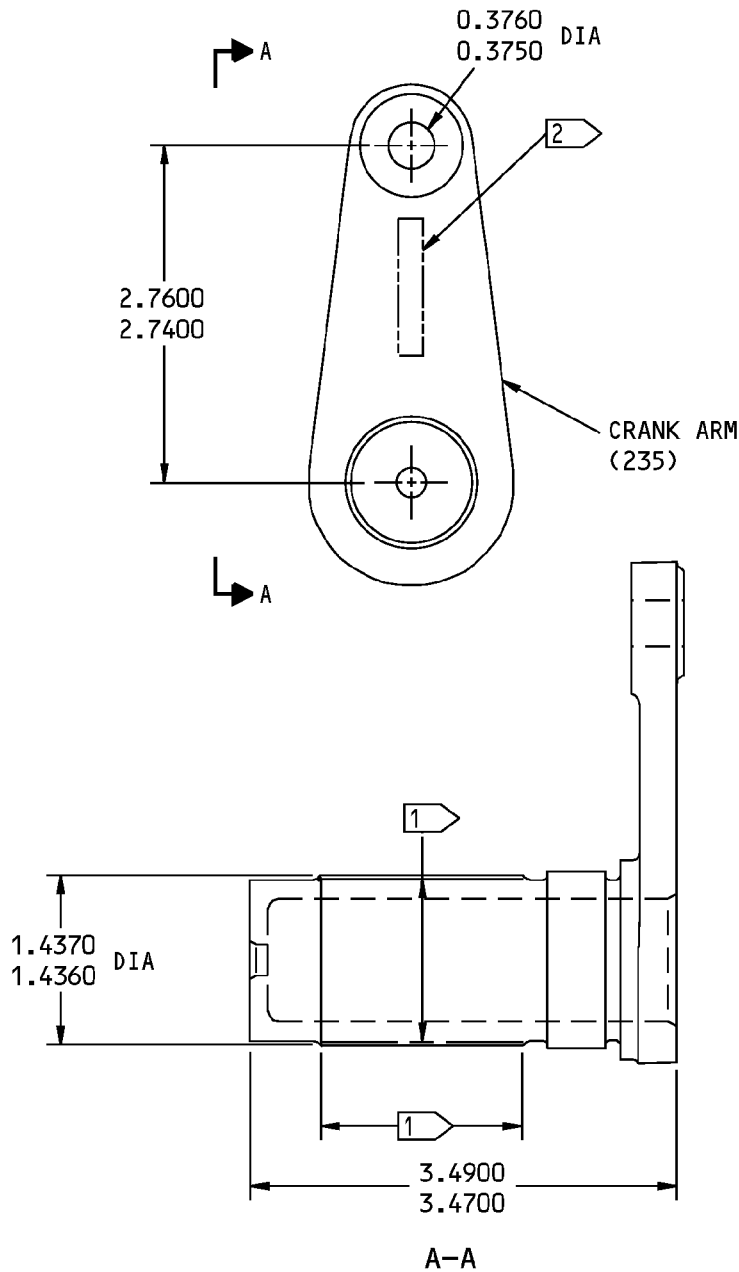
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REPAIR 2-2

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1 APPLY CADMIUM PLATE (F-15.02) ON THIS SURFACE, 0.06 INCH OVERRUN IS PERMITTED

2 PART NUMBER IS FOUND HERE

125 ✓ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 3

ALL DIMENSIONS ARE IN INCHES

141A6306-2 Crank Arm Refinish  
Figure 601

**52-16-15**

REPAIR 2-2

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## COMPONENT MAINTENANCE MANUAL

### STOP ASSEMBLY - REPAIR 3-1

147A6128-1, -3, -5, -7, -9, -11, -13, -15, -17, -19, -20, -21, -22, -49, -53

#### 1. General

- A. This procedure has the data necessary to repair the stop assembly (501, 501A, 502, 524, 527, 563, 566, 623, 626, 686, 689, 713, 716, 716A, 749, 752).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for the 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

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

- (1) Remove the bushing (502E, 530A, 569, 629, 692, 719, 755) from the fitting (502N, 502P, 502R, 533, 536, 572, 575, 632, 635, 695, 698, 722, 725, 725A, 758, 761) as shown in REPAIR 3-1, Figure 601.
- (2) Install and swage the replacement bushing (502E, 530A, 569, 629, 692, 719, 755) into the fitting (502N, 502P, 502R, 533, 536, 572, 575, 632, 635, 695, 698, 722, 725, 725A, 758, 761) with wet sealant, A00247 as specified in SOPM 20-50-03.
- (3) Fillet seal the bushing flanges with sealant, A00247 as specified in SOPM 20-50-03.

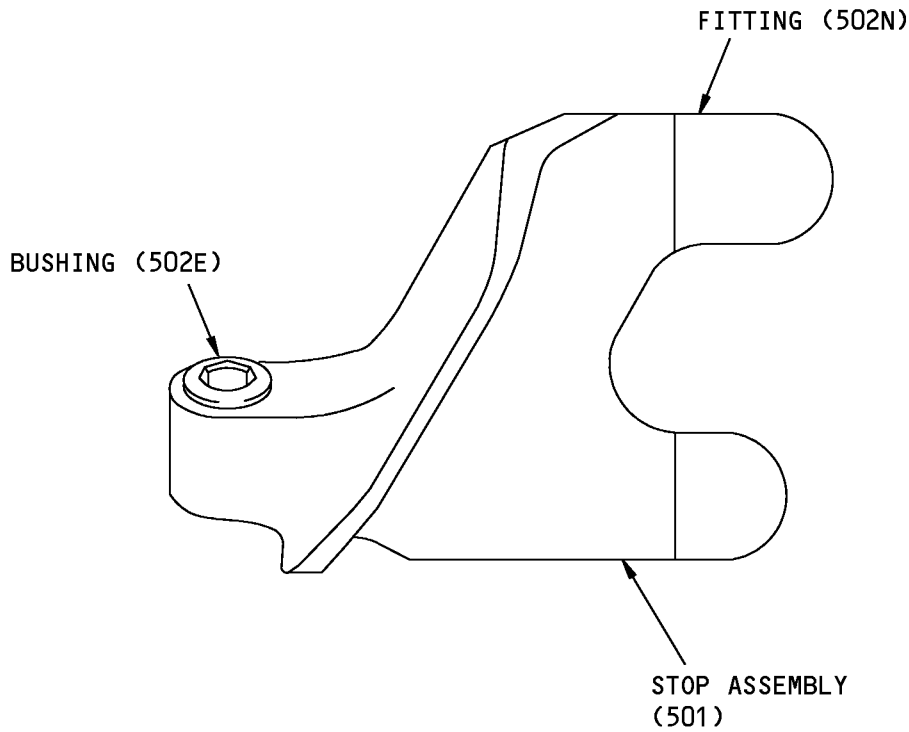
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REPAIR 3-1

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147A6128-21

**NOTE:** OTHER STOP ASSEMBLIES ARE ALMOST THE SAME.

ITEM NUMBERS REFER TO IPL FIG. 1

M05135 S00041000782\_V2

147A6128-1,-3,-5,-7,-9,-11,-13,-15,-17,-19,-20,-21,-22,-49,-53 Stop Assembly Repair  
Figure 601

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REPAIR 3-1

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## COMPONENT MAINTENANCE MANUAL

### STOP FITTING - REPAIR 3-2

147A6128-25, -27, -29, -31, -33, -35, -37, -39, -41, -43, -44, -45, -46, -51, -54

#### 1. General

- A. This procedure has the data necessary to refinish the stop fitting (502N, 502P, 502R, 533, 536, 572, 575, 632, 635, 695, 698, 722, 725, 758, 761).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for the item numbers.
- E. General repair details:
  - (1) Material: Al alloy
  - (2) Shot peen: All surfaces, but not in the bushing hole and countersink
    - (a) Intensity: 0.005A-0.010A
    - (b) Coverage: 1.0 Manual; Optional 2.0 Automatic

#### 2. 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

**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) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.35).
- (2) Apply primer, C00259 (F-20.03) but not in the hole for the bushing.

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REPAIR 3-2

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## COMPONENT MAINTENANCE MANUAL

### CENTERING GUIDE ASSEMBLY - REPAIR 4-1

147A6130-1

#### 1. General

- A. This procedure has the data necessary to repair the centering guide assembly (62).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for the item numbers.

#### 2. Bearing Replacement

##### A. References

Reference	Title
SOPM 20-50-01	BOLT AND NUT INSTALLATION

##### B. Procedure

- (1) Remove the nut (67), washer (66), and the bearing (65) from the fitting (68) as shown in REPAIR 4-1, Figure 601.
- (2) Install the replacement bearing (65) onto the fitting (68) with the washer (66).
- (3) Install the nut (67) onto the bearing (65) stud and tighten to 100-150 pound-inch as specified in SOPM 20-50-01.

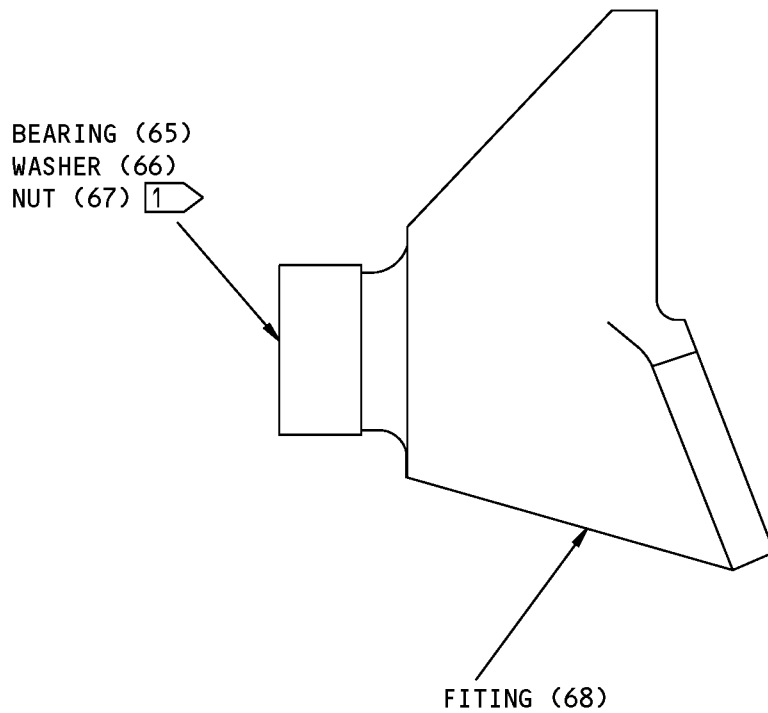
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1 TIGHTEN THIS NUT TO 100-150  
INCH-POUNDS

ITEM NUMBERS REFER TO IPL FIG. 1

147A6130-1 Centering Guide Assembly Repair  
Figure 601

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REPAIR 4-1  
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## COMPONENT MAINTENANCE MANUAL

### FITTING - REPAIR 4-2

146A6130-2

#### 1. General

- A. This procedure has the data necessary to refinish the fitting (68).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for the item numbers
- E. General repair details:
  - (1) Material: Al alloy

#### 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

**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) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.35).
- (2) Apply primer, C00259 (F-20.03) but not on the serrated surfaces.

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REPAIR 4-2

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## COMPONENT MAINTENANCE MANUAL

### TORQUE TUBE ASSEMBLY - REPAIR 5-1

147A6139-1, -3

#### 1. General

- A. This procedure has the data necessary to repair the torque tube assembly (310, 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 for the Standard True Position Dimensioning Symbols shown in this repair.
- D. Refer to IPL Figure 2 for the item numbers.

#### 2. Bearing Replacement

##### A. References

Reference	Title
SOPM 20-50-02	INSTALLATION OF SAFETYING DEVICES

##### B. Procedure

- (1) Remove the cotter pins (332, 392) from the nuts (345, 405) and cam follower bearings (335, 395).
- (2) Remove the nuts (345, 405), washers (340, 400) and cam follower bearings (335, 395) from the cranks (350, 410).
- (3) Install the cam follower bearings (335, 395), washers (340, 400), and nuts (345, 405) onto the cranks (350, 410). Install the nut (345, 405) finger-tight only; it will be tightened during installation of the door assembly in the airplane.
- (4) Install the cotter pins (332, 392) onto the cam follower bearings (335, 395) and nuts (345, 405) as specified in SOPM 20-50-02.

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REPAIR 5-1

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## COMPONENT MAINTENANCE MANUAL

### CRANK - REPAIR 5-2

69-37418-11

#### 1. General

- A. This procedure has the data necessary to refinish the crank (350, 410).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 2 for the item numbers
- E. General repair details:
  - (1) Material: Al Alloy

#### 2. 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

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

- (1) Boric acid-sulfuric acid anodize (F-17.35).
- (2) Apply primer, C00259 (F-20.03). Do not put primer, C00259 on the surfaces identified by flagnote 1 in REPAIR 5-2, Figure 601.
- (3) Apply enamel coating, C00260 (F-21.03-702). Do not put enamel coating, C00260 on the surfaces identified by flagnote 1 in REPAIR 5-2, Figure 601.
- (4) Overspray is permitted on surfaces identified by flagnote 2 in REPAIR 5-2, Figure 601.

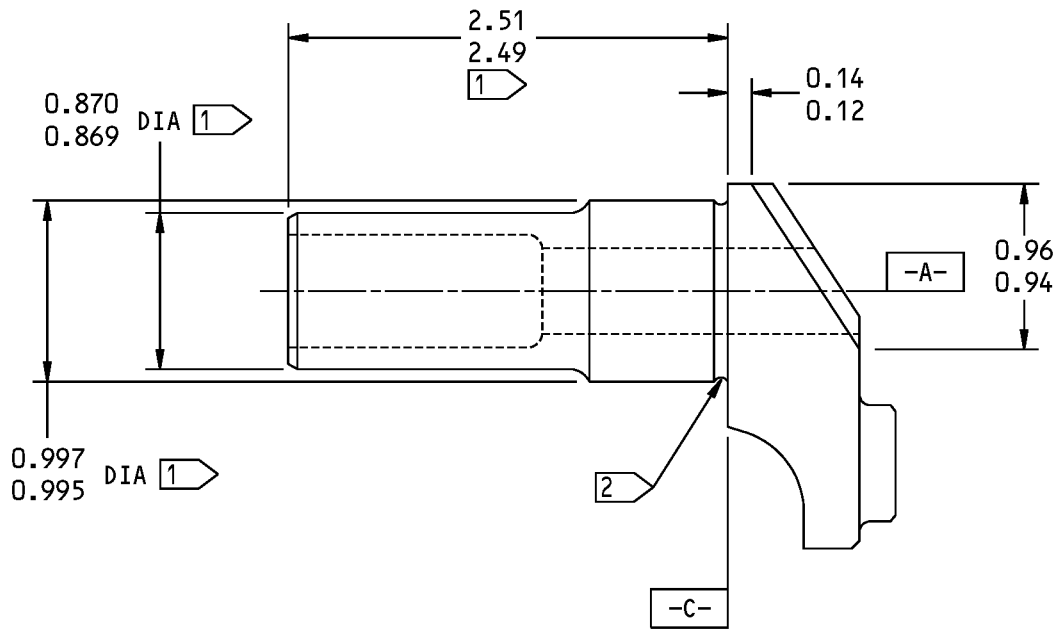
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1 DO NOT PUT PRIMER OR ENAMEL ON THIS SURFACE

2 OVERSPRAY IS PERMITTED ON THIS SURFACE

125 ✓ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

69-37418-11 Crank Refinish  
Figure 601

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REPAIR 5-2

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## COMPONENT MAINTENANCE MANUAL

### CRANK - REPAIR 5-3

66-14530-5, 66-14531-12, -13

#### 1. General

- A. This procedure has the data necessary to refinish the crank (355, 360, 415, 420).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 2 for the item numbers.
- E. General repair details:
  - (1) Material: 15-5PH CRES
    - (a) 150-170 ksi

#### 2. Crank Refinish

##### A. References

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

##### B. Procedure

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

- (1) Passivate (F-17.09) cranks.

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REPAIR 5-3

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## COMPONENT MAINTENANCE MANUAL

### LATCH TORQUE TUBE - REPAIR 5-4

60-4406-16, -17

#### 1. General

- A. This procedure has the data necessary to refinish the latch torque tube (365, 425).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to the REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 2 for item numbers.
- E. General repair details:
  - (1) Material: 15-5PH CRES
    - (a) 150-170 ksi

#### 2. Latch Torque 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

**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) Cadmium plate (F-15.06) the internal and external surfaces of the torque tubes to the dimensions shown in REPAIR 5-4, Figure 601.
- (2) Apply primer, C00259 (F-20.48) on the internal surface only.

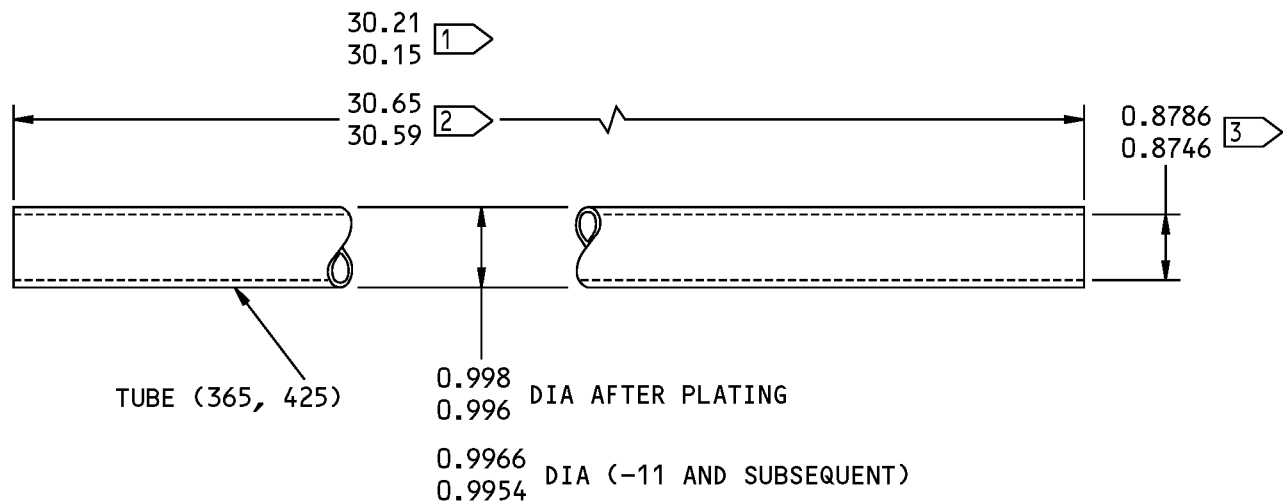
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- 1 60-4406-16
- 2 60-4406-17
- 3 DIMENSION APPLIES FOR A DISTANCE OF 1.54-1.66 INCHES FROM EACH END OF THE TUBE

125 ✓ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

60-4406-16,-17 Torque Tube Refinish  
Figure 601

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REPAIR 5-4

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## COMPONENT MAINTENANCE MANUAL

### SUPPORT ASSEMBLY - REPAIR 6-1

147A6140-5, -6

#### 1. General

- A. This procedure has the data necessary to repair the support assembly (630, 635).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 2 for the 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

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

- (1) Remove the bushing (637) from the support (638, 639) as shown in REPAIR 6-1, Figure 601 .
- (2) Install the replacement bushing (637) into the support (638, 639). Use the shrink-fit procedure as specified in SOPM 20-50-03 with sealant, A00247.
- (3) Make sure that the bushing (637) is installed flush with the support (638, 639).

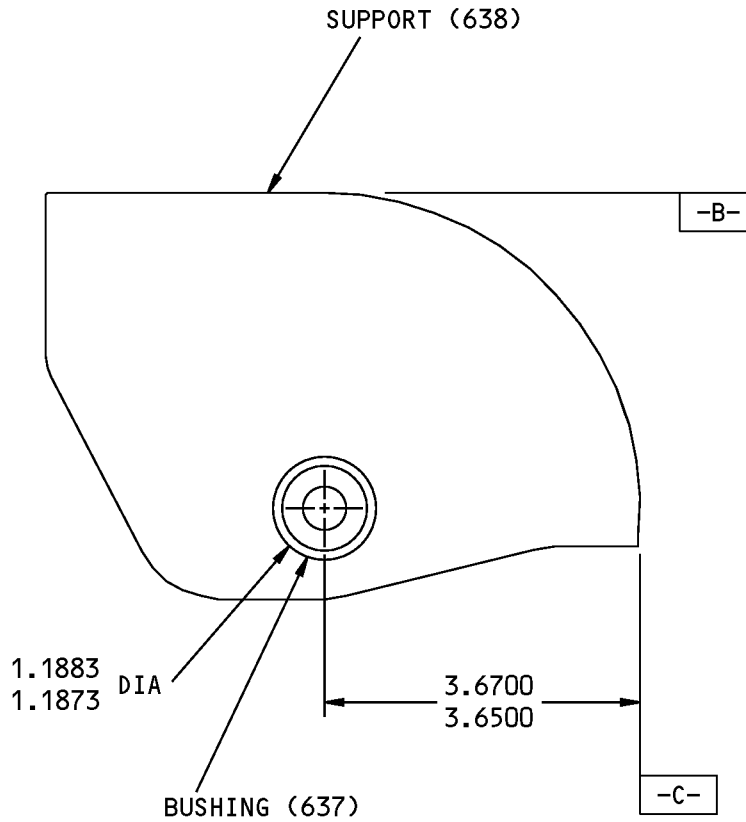
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147A6140-5 SHOWN  
147A6140-6 OPPOSITE

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

147A6140-5,6 Support Assembly Repair  
Figure 601

**52-16-15**

REPAIR 6-1  
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## COMPONENT MAINTENANCE MANUAL

### SUPPORT - REPAIR 6-2

147A6140-7, -8

#### 1. General

- A. This procedure has the data necessary to refinish the support (638, 639).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 2 for the item numbers.
- E. General repair details:
  - (1) Material: Al alloy

#### 2. Support 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

**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-17.35).
- (2) Apply primer, C00259 (F-20.03) but not in the hole for the bushing.

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REPAIR 6-2

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## COMPONENT MAINTENANCE MANUAL

### CLEVIS ASSEMBLY - REPAIR 7-1

147A6144-1, -2

#### 1. General

- A. This procedure has the data necessary to repair the clevis assembly (305, 356).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for the 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

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

- (1) Remove the bushings (308, 311, 359, 365) from the clevis (314, 368) as shown in REPAIR 7-1, Figure 601.
- (2) Install the replacement bushings (308, 311, 359, 365) into the clevis (314, 368) with sealant, A00247 as specified in SOPM 20-50-03.
- (3) Fillet seal each end of the bushings (308, 311, 359, 365) with sealant, A00247 as specified in SOPM 20-60-04.

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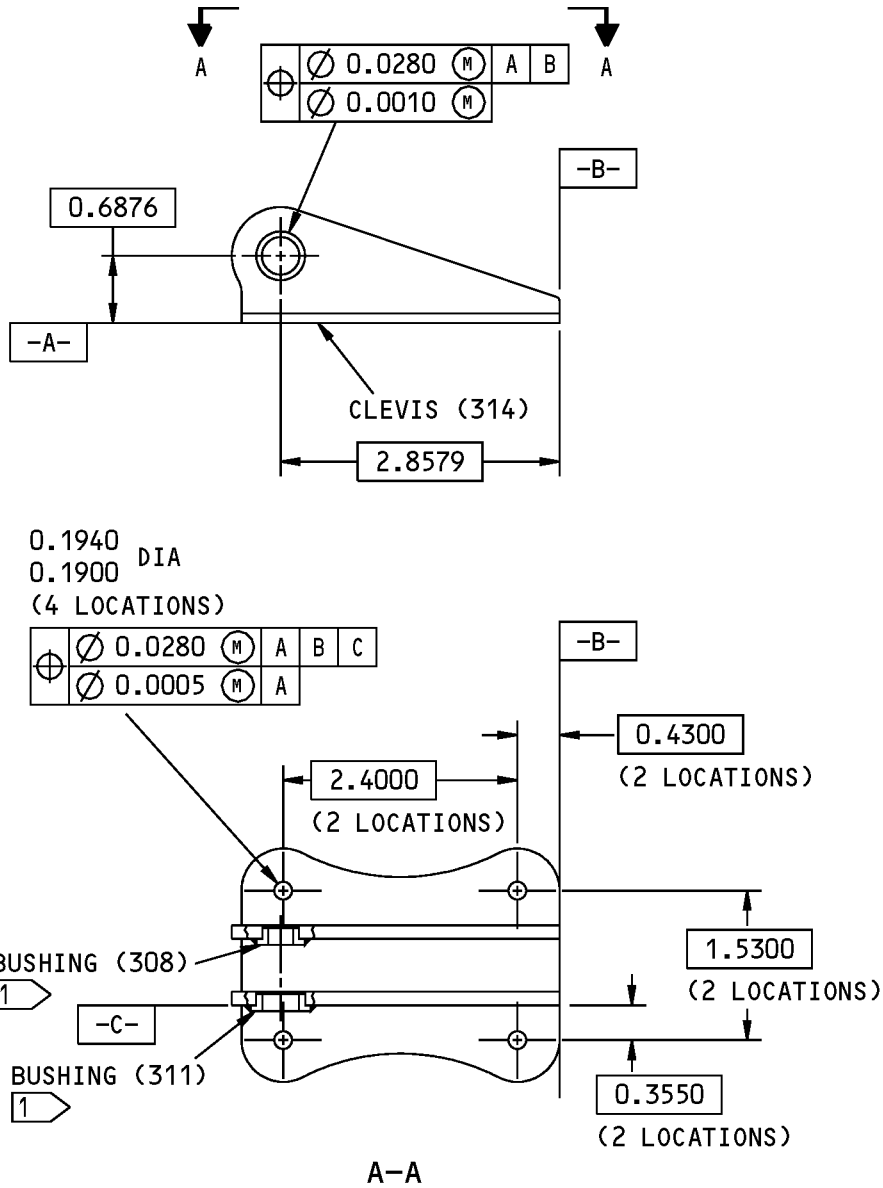
REPAIR 7-1

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1 INSTALL ALL BUSHINGS WITH BMS 5-95 AS SHOWN IN SOPM 20-50-03, FILLET SEAL BOTH ENDS

125 ✓ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

147A6144-1 Clevis Assembly Repair  
Figure 601

**52-16-15**

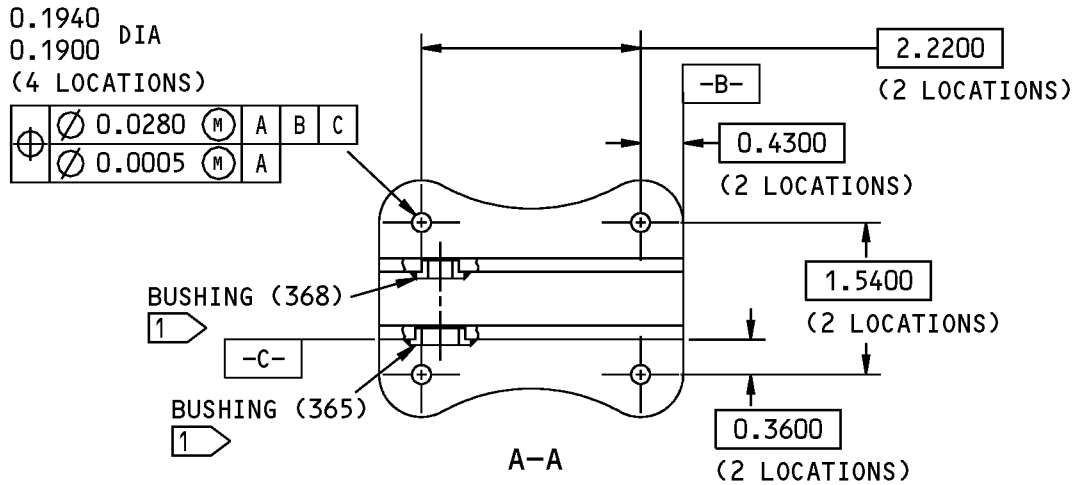
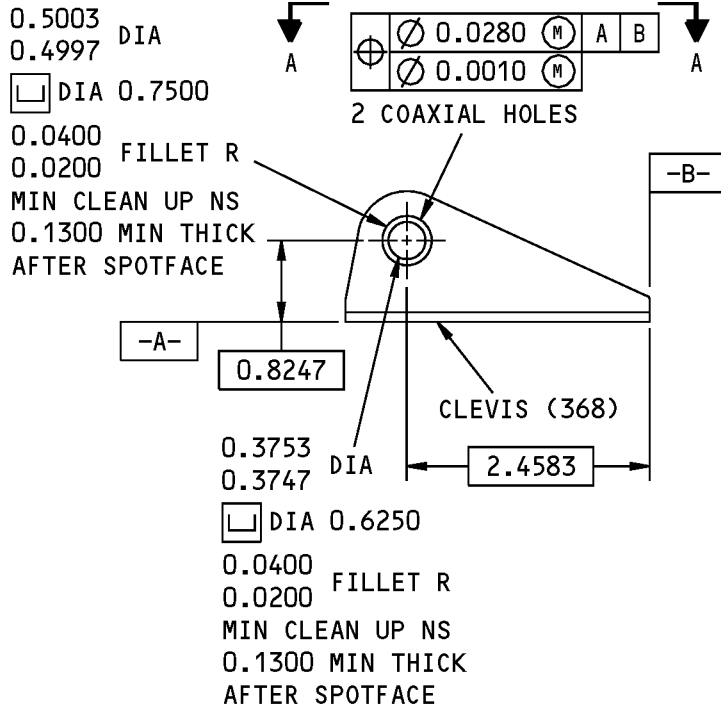
REPAIR 7-1

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1 INSTALL ALL BUSHINGS WITH BMS 5-95 AS SHOWN IN SOPM 20-50-03, FILLET SEAL BOTH ENDS

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

147A6144-2 Clevis Assembly Repair  
Figure 602

**52-16-15**





## COMPONENT MAINTENANCE MANUAL

### CLEVIS - REPAIR 7-2

147A6144-3, -4

#### 1. General

- A. This procedure has the data necessary to refinish the clevis (314, 368).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for the item numbers.
- E. General repair details:
  - (1) Material: Al alloy

#### 2. Clevis 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

**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-17.35).
- (2) Apply primer, C00259 (F-20.03) as specified in SOPM 20-60-02 but not in the holes for the bushings.

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REPAIR 7-2

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## COMPONENT MAINTENANCE MANUAL

### GATE ASSEMBLY - REPAIR 8-1

147A6146-1, -7, -11

#### 1. General

- A. This procedure has the data necessary to repair the gate assembly (332, 332A, and 332B).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for the 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

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

- (1) Remove the bushings (335) from the gate (338) as shown in REPAIR 8-1, Figure 601.
- (2) Install the replacement bushings (335) into the gate (338) with sealant, A00247 as specified in SOPM 20-50-03.
- (3) Flare the bushings (335) 10-15 degrees and then fillet seal each end with sealant, A00247.
- (4) After the bushings are flared, they must be flush with the faying surfaces.

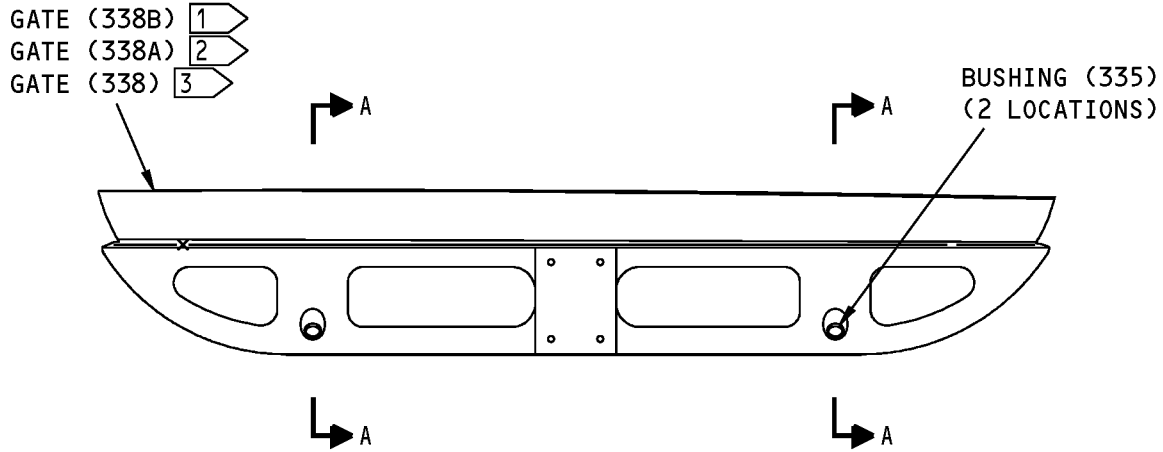
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A-A

147A6146-1 SHOWN  
 147A6146-7,-11 ALMOST THE SAME

- 1 147A6146-1
- 2 147A6146-7
- 3 147A6146-11

ITEM NUMBERS REFER TO IPL FIG. 1

147A6146-1,-7,-11 Gate Assembly Repair  
 Figure 601

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## COMPONENT MAINTENANCE MANUAL

### GATE - REPAIR 8-2

147A6146-3, -9, -13

#### 1. General

- A. This procedure has the data necessary to refinish the gate (338).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 1 for the item numbers.
- E. General repair details:
  - (1) Material Magnesium alloy

#### 2. Gate Refinish

- A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

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

- B. References

Reference	Title
SOPM 20-30-02	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 decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Dow 17 anodize (F-17.12).
- (2) Apply primer, C00259 (F-20.03).
- (3) Apply enamel coating, C00032 (SRF-14.9813). Internal surfaces can be finished by the fill and drain procedure. Do not put enamel coating, C00032 in the holes for the bushings and the bolts.

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## COMPONENT MAINTENANCE MANUAL

### HOUSING ASSEMBLY - REPAIR 9-1

149A6107-2

#### 1. General

- A. This procedure has the data necessary to repair and refinish the housing assembly (345).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 3 for the item numbers.

#### 2. Bushing Replacement

##### A. References

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

##### B. Procedure

- (1) Remove the bushing (365A) from the housing (380).
- (2) Install the replacement bushing (365A) into the housing (380) as specified in SOPM 20-50-03.

#### 3. Housing Refinish

##### A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
C00032	Coating - Exterior Protective Enamel, General Use	BMS10-60, Type I

##### B. References

Reference	Title
SOPM 20-60-02	FINISHING MATERIALS

##### C. Procedure

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

- (1) Apply enamel coating, C00032 (SRF-14.9813) but not in the bushing or close toleranced bores or the holes common to the nutplates (16 locations).

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## COMPONENT MAINTENANCE MANUAL

### HOUSING - REPAIR 9-2

149A6107-5

#### 1. General

- A. This procedure has the data necessary to refinish the housing (380).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 2 for the 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

**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-17.35).
- (2) Apply primer, C00259 (F-20.03) but do not put primer, C00259 in the holes for the bearing or the fitting.

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REPAIR 9-2

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## COMPONENT MAINTENANCE MANUAL

### HOUSING ASSEMBLY - REPAIR 10-1

65-2306-9

#### 1. General

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

#### 2. Fitting Replacement

- A. Procedure
  - (1) Remove the fitting (297) from the housing (305).
  - (2) Install the replacement fitting (297) in the housing (305) as shown in REPAIR 10-1, Figure 601.

#### 3. Bearing Replacement

##### A. References

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

##### B. Procedure

- (1) Remove the bearing (300) from the housing (305).
- (2) Install the replacement bearing (300) into the housing (305) as specified in SOPM 20-50-03.

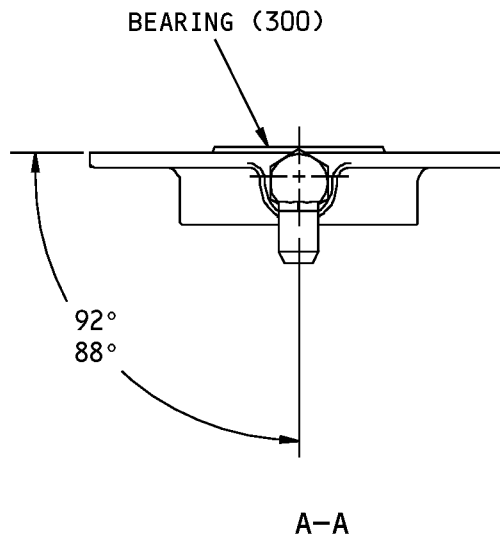
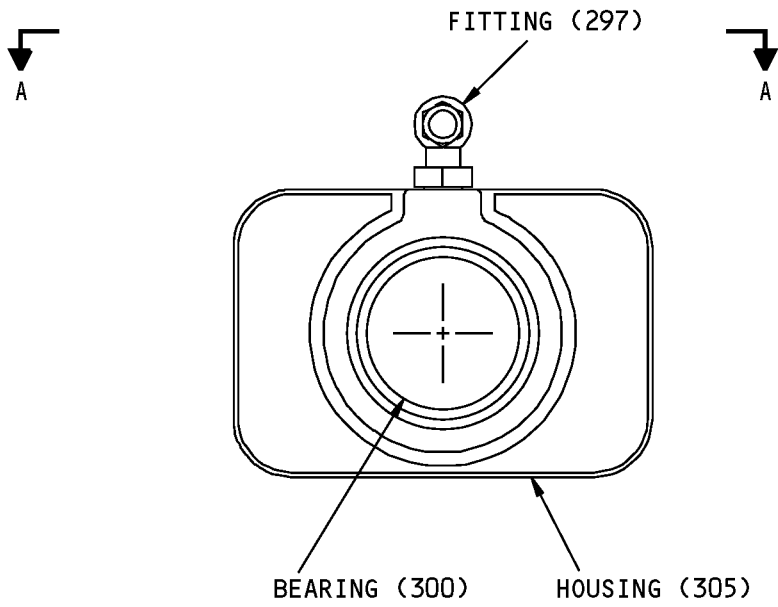
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ITEM NUMBERS REFER TO IPL FIG. 2

65-2306-9 Housing Assembly Repair  
Figure 601

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## COMPONENT MAINTENANCE MANUAL

### HOUSING - REPAIR 10-2

65-2306-10

#### 1. General

- A. This procedure has the data necessary to refinish the housing (305).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 2 for the 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

**NOTE:** For stripping of protective finishes, refer to SOPM 20-30-02. For decoding table of 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-17.35).
- (2) Apply primer, C00259 (F-20.03) but do not put primer, C00259 in the holes for the bearing or the fitting.

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## COMPONENT MAINTENANCE MANUAL

### ROD ASSEMBLY - REPAIR 11-1

65-28925-85, -86, -87, -100, -101

#### 1. General

- A. This procedure has the data necessary to repair the rod assembly (105, 155, 190).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 2 for the item numbers.

#### 2. Rod End 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)

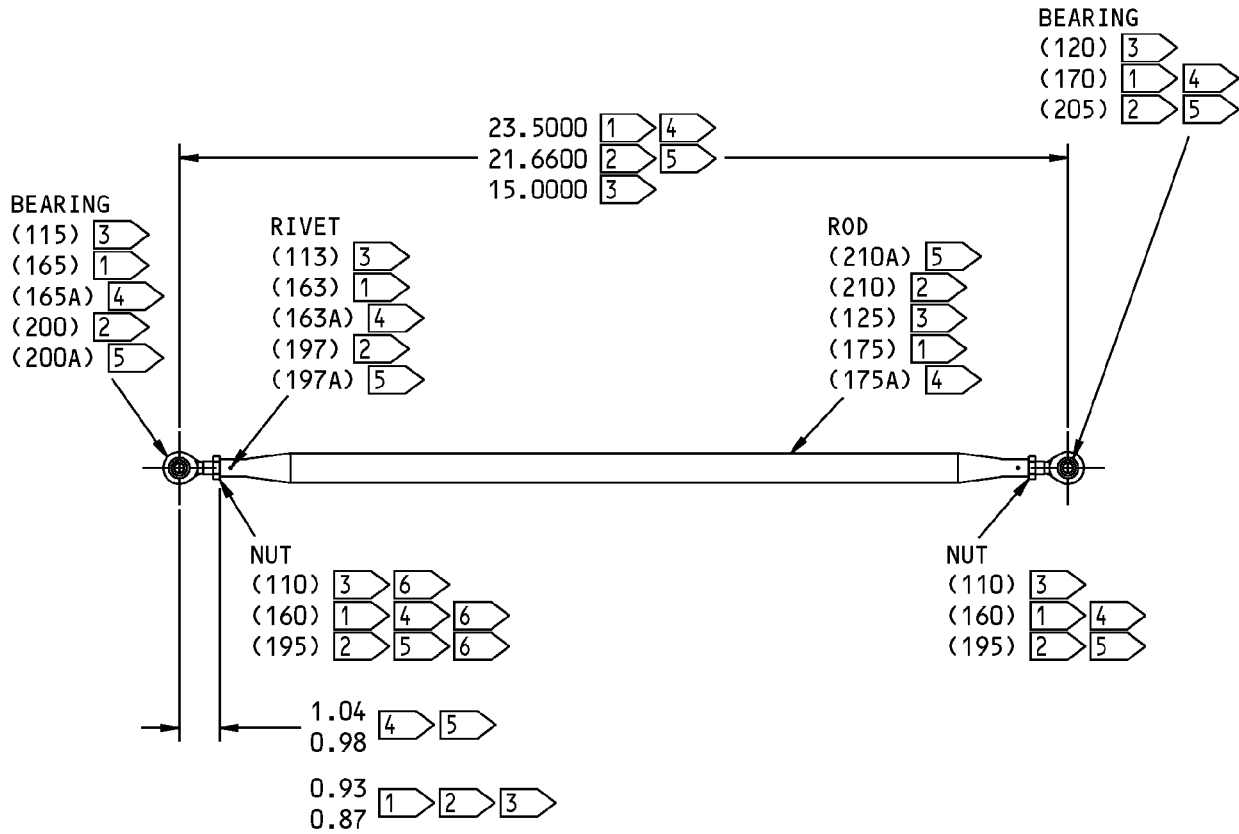
- B. Procedure

- (1) Loosen the nut (110, 160, 195) on the rod end bearings (115, 120, 165, 170, 200, 205).
- (2) Remove the rivet (113, 163, 197) and the rod end bearings (115, 120, 165, 170, 200, 205) from the rod (125, 175, 210) as shown in REPAIR 11-1, Figure 601.
- (3) Apply compound, B50080 to the threads of the replacement rod end bearings (115, 120, 165, 170, 200, 205).
- (4) Install the rod end bearings (115, 120, 165, 170, 200, 205) and the nut (110, 160, 195) on the rod (125, 175, 210) to the dimension shown in REPAIR 11-1, Figure 601. Tighten the nut (125, 175, 210) to 60 pounds-inch.
- (5) Drill through the inspection hole on the rod (125, 175, 210) and install the rivet (113, 163, 197).

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- 1 65-28925-85
- 2 65-28925-86
- 3 65-28925-87
- 4 65-28925-100
- 5 65-28925-101
- 6 TIGHTEN THIS NUT TO 60 INCH-POUNDS BEFORE INSTALLATION OF RIVET

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

65-2895-85,-86,-87,-100,-101 Rod Assembly Repair  
 Figure 601

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## COMPONENT MAINTENANCE MANUAL

### ROD - REPAIR 11-2

65-28925-47, -48, -58, -104, -105

#### 1. General

- A. This procedure has the data necessary to refinish the rod (125, 175, 210).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 2 for the item numbers.
- E. General repair details:
  - (1) Material: Al alloy

#### 2. Rod Refinish

- A. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
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

- 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 decoding table of Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Chemical treat with coating, C00064 (F-2.742).
- (2) Apply primer, C00259 (SRF-12.205) to the external surfaces only.

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REPAIR 11-2

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## COMPONENT MAINTENANCE MANUAL

### CONTROL ROD ASSEMBLY - REPAIR 12-1

69-18187-26

#### 1. General

- A. This procedure has the data necessary to repair the control rod assembly (230).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 2 for the item numbers.

#### 2. Rod End Bearing Replacement

- A. Procedure
  - (1) Loosen the nut (235A) on the rod end bearings (240).
  - (2) Remove the rivet (237) and the rod end bearings (240, 245) from the rod (250) as shown in REPAIR 12-1, Figure 601.
  - (3) Install the replacement rod end bearings (240, 245), rivet (237), and nut (235A) onto the rod (250) to the dimensions shown in REPAIR 12-1, Figure 601.

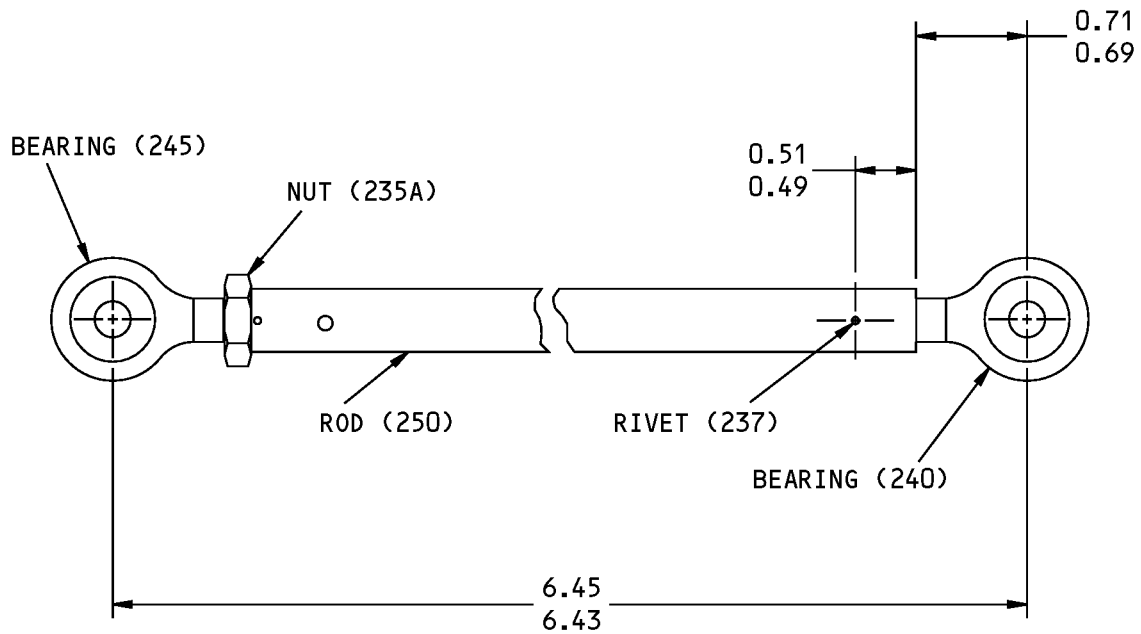
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ITEM NUMBERS REFER TO IPL FIG. 2  
ALL DIMENSIONS ARE IN INCHES

69-18187-26 Control Rod Assembly Repair  
Figure 601

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REPAIR 12-1  
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## COMPONENT MAINTENANCE MANUAL

### ROD REPAIR - 12-2

66-14618-7

#### 1. General

- A. This procedure has the data necessary to refinish the rod (250).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 2 for the item numbers.
- E. General repair details:
  - (1) Material: 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

- 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 decoding table of Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Cadmium plate and apply primer, C00259 (F-16.01). Do not put primer, C00259 on the threads.

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REPAIR 12-2

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## COMPONENT MAINTENANCE MANUAL

### CAM CRANK ASSEMBLY - REPAIR 13-1

90-7815-25

#### 1. General

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

#### 2. Cam Follower 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 20-50-02	INSTALLATION OF SAFETYING DEVICES
SOPM 20-60-04	MISCELLANEOUS MATERIALS

- C. Procedure

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

- (1) Remove the cotter pin (245) from the cam follower bearing (260) stud as shown in REPAIR 13-1, Figure 601.
- (2) Remove the nut (250), washers (255), and cam follower bearing (260) from the arm (265).
- (3) Install the replacement cam follower bearing (260) and a washer (255) onto the arm (265).
- (4) Install the washer (255) and nut (250) onto the cam follower bearing (260) stud. Install a maximum of five washers under the nut.
- (5) Install the cotter pin (245) onto the cam follower bearing (260) stud with wet sealant, A00247 as specified in SOPM 20-50-02.

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REPAIR 13-1

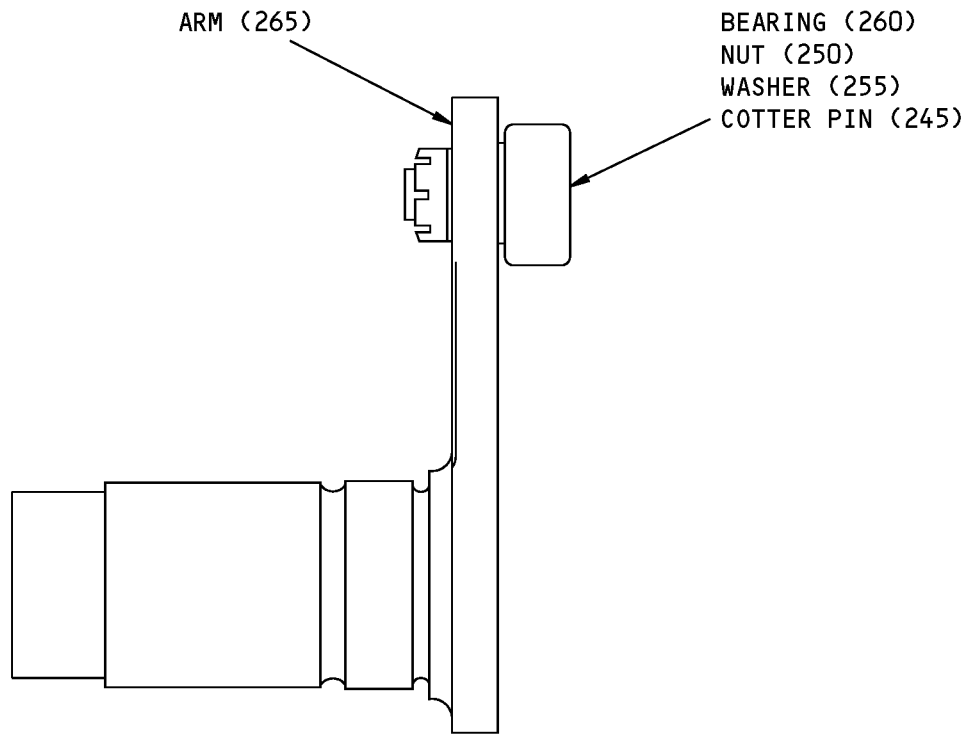
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ITEM NUMBERS REFER TO IPL FIG. 2

90-7815-25 Cam Follower Crank Assembly Repair  
Figure 601

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## COMPONENT MAINTENANCE MANUAL

### CRANK ARM - REPAIR 13-2

90-7815-29

#### 1. General

- A. This procedure has the data necessary to refinish the crank arm (265).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the Standard True Position Dimensioning Symbols shown in the repair.
- D. Refer to IPL Figure 2 for the item numbers.
- E. General repair details:
  - (1) Material: Al alloy

#### 2. Crank Arm 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

**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-17.35).
- (2) Apply primer, C00259 (F-20.03) but not on the splined surfaces.

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REPAIR 13-2

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## COMPONENT MAINTENANCE MANUAL

### ASSEMBLY

#### 1. General

- A. This procedure has the data necessary to assemble the aft 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 2, IPL Figure 3 for the item numbers.

#### 2. Assembly

##### A. Tools/Equipment

**NOTE:** Equivalent substitutes may be used.

Reference	Description
SPL-1981	Tool - Installation, Door Seal (Part #: B52004-1, Supplier: 81205) (Part #: K52011-1, Supplier: 81205)

##### B. Consumable Materials

**NOTE:** Equivalent substitutes may be used.

Reference	Description	Specification
A00119	Adhesive - Synthetic Rubber Cement, Naphtha Soluble	BMS5-55
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95
A50113	Adhesive - BMS 5-30	BAC5010 Type 48
B50080	Compound - Corrosion Preventive, Solvent Cutback, Cold-Application (Grade 2 - Soft Film)	MIL-PRF-16173, Grade 2 (Supersedes MIL-C-16173, Grade 2)
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I
C00308	Compound - Corrosion Preventive, Petrolatum Hot Application	MIL-C-11796
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)

##### C. References

Reference	Title
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

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Reference	Title
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-50-05	APPLICATION OF ALUMINUM FOIL AND OTHER MARKERS
SOPM 20-50-06	INSTALLATION OF O-RINGS AND TEFLON SEALS
SOPM 20-50-07	LUBRICATION
SOPM 20-50-12	APPLICATION OF ADHESIVES
SOPM 20-50-20	HOW TO MAKE AND INSTALL RESIN BOND LAMINATED SHIMS AND SOLID FILLERS
SOPM 20-60-03	LUBRICANTS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

### D. Procedure

**NOTE:** For bolt and nut installation, refer to SOPM 20-50-01. For lubrication, refer to SOPM 20-50-07. For lubricants, refer to SOPM 20-60-03. For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Use standard industry procedures and the steps below to assemble this component.
- (2) Install the centering guide assembly (IPL Figure 1, 62) onto the door structure, as follows:
  - (a) Install the bearing (65) onto the fitting (68) with the washer (66) and the nut (65). Tighten the nut (65) to 100-150 pound-inch.
  - (b) Install the centering guide assembly (62) onto the serrated plate (71) with the washers (59) and the bolts (53).
- (3) Assemble and install the window assembly (IPL Figure 1, 827) onto the door structure, as follows:
  - (a) Assemble the window assembly (IPL Figure 1, 827) as follows:
    - 1) Put the sponge rubber seal (848) on the retainer (851). Cement the seal (848), as shown in ASSEMBLY, Figure 701, flagnote 1, with adhesive, A00119 or adhesive, A50113 as specified in SOPM 20-50-12.
    - 2) Put the inner pane (860B) into the new seal (854).

**CAUTION:** PUT THE ASSEMBLY WITH THE CURVATURE OF THE WINDOW PANES AND THE MOUNTING HOLES AS SHOWN.

- 3) Put the seal (854) and the inner pane (860B) into the retainer (851) with the pane marking as shown in ASSEMBLY, Figure 701. Make sure that the hole in the seal (854) aligns with the slot in the retainer (851) as shown in ASSEMBLY, Figure 701.
- 4) Put the new outer pane (857B) into the seal (854) with the pane marking as shown in ASSEMBLY, Figure 701.
- 5) Install the shims (842, 845), clips (839A, 840), screws (829, 830), washers (833, 834), and nuts (836, 837) on the retainer (851) as specified in SOPM 20-50-01.
  - a) Adjust the thickness of the shims (842, 845) to give a maximum compression of 0.03 inch of the seal (854), as specified in ASSEMBLY, Figure 701.
  - b) Apply primer, C00259 to the shims (842, 845) when you get the correct thickness and before installation.

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- (b) Install the window assembly (IPL Figure 1, 827) onto the door structure with the washers (824) and the bolts (821).

**NOTE:** The outer pane of the window can be 0.0500 inch out or 0.0300 inch inside of the outer surface of the doubler around the periphery of the window.

- (4) Install the upper and lower hinge support assembly (IPL Figure 2, 570, 575) onto the door structure.
- (a) Install the lower hinge support assembly (570) as follows:
- 1) Apply sealant, A00247 fay surface sealant to the mating surfaces of the fitting (620) and support assembly (630).
  - 2) Install the fitting (620) onto the support assembly (630) with the bolts (595, 600), washers (585, 590, 605, 610), and nuts (580, 615). Install the fasteners with sealant, A00247.
  - 3) Apply sealant, A00247 fay surface sealant to the mating surfaces of the upper hinge support assembly (570) and the door structure.
  - 4) Install the lower hinge support assembly (570) onto the door structure with the bolts (560) and nuts (565). Install the fastener with sealant, A00247.
- (b) Install the upper hinge support assembly (575) as follows:
- 1) Apply sealant, A00247 fay surface sealant to the mating surfaces of the fitting (625) and support assembly (635).
  - 2) Install the fitting (625) onto the support assembly (635) with the bolts (595, 600), washers (585, 590, 605, 610), and nuts (580, 615). Install the fasteners with sealant, A00247.
  - 3) Apply sealant, A00247 fay surface sealant to the mating surfaces of the upper hinge support assembly (575) and the door structure.
  - 4) Install the upper hinge support assembly (575) onto the door structure with the bolts (560) and nuts (565). Install the fasteners with sealant, A00247.
- (5) Install the handle box assembly (IPL Figure 2, 545) onto the door structure, as follows:
- (a) If necessary, assemble the handle box assembly (IPL Figure 2, 545), as follows:
- 1) Install the bearings (IPL Figure 3, 205, 270, 336) into the housing assembly (345) with wet sealant, A00247 as specified in SOPM 20-50-03 . Fillet seal each end of the bearings (205, 270, 336) with sealant, A00247.
  - 2) Install the bearing (55) into the housing assembly (345) with wet sealant, A00247 as specified in SOPM 20-50-03.
  - 3) Install the retaining ring (50) into the housing assembly (345) with grease, D00015 as specified in SOPM 20-50-07.
  - 4) Install the bearing retainers (155, 175) onto the housing assembly (345) with the bolts (140, 160, 310, 315), washers (145, 165, 320, 325), and nuts (150, 170, 325). Install the bearing retainer fasteners with wet sealant, A00247.
  - 5) If necessary, assemble the crank assemblies (210, 240).
    - a) Assemble the crank assembly (210) as follows:
      - < 1 > Apply corrosion preventive compound, C00308 to the bearing (230) stud as specified in SOPM 20-41-05.
      - < 2 > Install the bearing (230) in the arm (235) with the washer (225) and nut (220).

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- < 3 > Tighten the nut (220) to 55 pound-inch. Then back off the nut to the first slot that aligns with the hole in the bearing (230) stud.
  - < 4 > Install the cotter pin (215) into the bearing (230) stud as specified in SOPM 20-50-02.
- b) Assemble the crank assembly (240) as follows:
- < 1 > Apply wet sealant, A00247 to the bearing (260) stud.
  - < 2 > Install the bearing (260) onto the arm (265) with the washer (255) and nut (250). Install a washer (255) under the bearing and a maximum of five washers (255) under the nut (250).
  - < 3 > Tighten the nut (250) to 45-85 pound-inch. Then back off the nut to the first slot that aligns with the hole in the bearing (230) stud.
  - < 4 > Install the cotter pin (245) into the bearing (260) stud as specified in SOPM 20-50-02.
- 6) Apply compound, B50080 to the splines of the crank assemblies (210, 240), cocking crank assembly (280), and latching crank assembly (305).
- 7) Install the crank assembly (210), ring (300), cocking crank assembly (280), and washer (275) into the housing assembly (345).
- 8) Install the crank assembly (240), latching crank assembly (305), and washer (275) into the housing assembly (345).
- 9) Secure the crank assemblies (210, 240), onto the housing assembly (345) with bolts (180, 185), washers (190), and nuts (195).
- NOTE:** Install the bolts (180, 185) with grease, D00015 as specified in SOPM 20-50-07 . Install the washer (190) with primer, C00259.
- 10) Install the rod assembly (340) onto the cocking crank assembly (280) with the bolt (330) and washer (335).
- NOTE:** Install the bolts (330) and the rod assembly (340) with grease, D00015 as specified in SOPM 20-50-07. Install the washer (335) with primer, C00259.
- 11) Install the packing (95) into the housing assembly (80) groove as specified in SOPM 20-50-06.
- 12) Install the housing assembly (80) onto the housing assembly (345) with the bolts (70) and washers (75). Install the housing assembly with grease, D00015 as specified in SOPM 20-50-07. Install the bolt (70) finger tight only.
- NOTE:** Make sure that the lube fitting faces forward or aft.
- 13) If necessary, assemble the shaft assembly (100) as follows:
- a) Install the spring (130) onto the pin (125) with the nut (120).
  - b) Install the washer (105) onto the pin (125) with retaining pin (110). Make sure that the retaining holes on the washer (105) and the pin (125) are aligned. Install the washer (105) with grease, D00015 as specified in SOPM 20-50-07.
  - c) Install the pin (125) and associated parts into the shaft (135). Make sure that the nut (120) is flush with the base of the shaft (135) and that the hole in the slot of the shaft (135) is aligned with the nut (120).
  - d) Install the lock ring (115) onto the shaft (135) and the nut (120).

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- 14) Apply compound, B50080 to the mating surfaces of the sleeve (60) and the housing assembly (80).
  - 15) Install the sleeve (60), the centering cam (65), and the shaft assembly (100) into the housing assembly (80).
  - 16) Install the handle (25) onto the sleeve (60) and the centering cam (65) with the bolts (5), washers (10), nuts (15), and spacer (20). Install the handle so it will engage when pulled straight out of the recess position. Install the bolt (5) finger tight only.
  - 17) Apply grease, D00015 to the mating surfaces of the shaft assembly (100) and the cam assembly (40).
  - 18) Install the shaft assembly (100) onto the housing assembly (345) with the washer (45), cam assembly (40), washers (33, 35), and nut (30). Install the nut (30) finger tight only. Install the washer (33) only if necessary.
  - 19) Install the cotter pin (IPL Figure 2, 555) thru the shaft assembly (IPL Figure 3, 100) as specified in SOPM 20-50-02.
- (b) Apply sealant, A00247 to the mating surfaces of the handle box assembly (IPL Figure 2, 545), the shims (IPL Figure 2, 540) and the door structure.
- 1) Install shims (IPL Figure 2, 540) as specified in SOPM 20-50-20, if and as necessary, to decrease the clearance between the handle box assembly and the door structure. The shims must be parallel to the handle box assembly and the door structure. The maximum permitted clearance is 0.0100 inch.
- (c) Install the handle box assembly (545) into the door structure with the bolts (525) and washers (530). Install the bolts (525) with wet sealant, A00247.
- (6) Install the torque tube assembly (IPL Figure 2, 655) in the door structure, as follows:
- (a) Apply a light layer of grease, D00015 to the packing (640).
  - (b) Install the packing (640), washers (645), and spring (650) onto the pins (730).
  - (c) Apply a light layer of grease, D00015 onto the threads and mating surfaces of the pins (730), crank (745), special nuts (740), the sleeves (735, 750).
  - (d) Apply a sufficient amount of grease, D00015 to the mating surfaces of the arm assemblies (670, 685) and pins (730). Fill the voids with grease, D00015 after assembly.
  - (e) Position the arm assemblies (670, 685) and pins (730) into the handle box assembly (545).
  - (f) Slide the crank (745), special nuts (740), and sleeves (735, 750) onto the torque tube (755).
  - (g) Position the torque tube (IPL Figure 2, 755) with the crank (745) and the special nuts (740) into the handle box assembly (545) and the door structure.
  - (h) Tighten the special nuts (740) onto the torque tube (755).
  - (i) Install the bolts (660) and washers (665) onto the arm assemblies (670, 685) with grease, D00015. Install the bolts (660) finger tight only; the final torque value to be applied at door installation on the airplane.
  - (j) Secure the crank (745) onto the torque tube (755) with the bolts (715), washers (720), and nuts (735).

**NOTE:** Bolt grip length substitution is not permitted. Pay attention to the bolt direction to prevent interference with other components.

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- (k) Secure the pins (730) and the sleeves (735, 750) onto the torque tube (755) with the bolts (700), washers (705), and nuts (710). Tighten the nuts (710) to 30-40 pound-inch. The nut is intended to bottom out on the bolt threads to prevent clamp up. The maximum space between the torque tube (755) and the washer (705) is 0.016 inch. Install additional washers as necessary.

**NOTE:** Bolt grip length substitution is not permitted. Pay attention to the bolt direction to prevent interference with other components.

- (l) Install the bolts (IPL Figure 1, 478), washers (480), nuts (481), and splices (596, 656) onto the beams (638, 701).

**NOTE:** Removal and installation of the splices (IPL Figure 1, 596, 656) and fasteners are necessary to install the handle box assembly (IPL Figure 2, 545) and the torque tube assembly (655).

- (m) Connect the rod assembly (IPL Figure 3, 340) onto the torque tube assembly (IPL Figure 2, 655) with the bolt (510), washer (515), and nut (520). Install the washer (515) under the nut (520).

**NOTE:** Pay attention to the bolt direction to prevent interference with other components.

- (7) Install the housing assemblies (IPL Figure 2, 295) and the fitting assemblies (450, 465, 480, 495) onto the door structure, as follows:
- (a) Install the housing assemblies (295) onto the door structure with the bolts (280), washers (285), and nuts (290).
  - (b) If necessary, remove 0.003 inch of lamination from the shim (IPL Figure 2, 445). The maximum gap before fastener pull down must be 0.0100. Apply sealant, A00247 fay surface sealant to each side of the shim (445) and the mating surfaces of the fitting assembly (465).
  - (c) Install the fitting assembly (465) and the shim (445) onto the door structure with the bolts (IPL Figure 1, 17, 18), washers (20), and nuts (23).
  - (d) If necessary, remove 0.003 inch of lamination from the shim (IPL Figure 2, 440). The maximum gap before fastener pull down must be 0.010. Apply sealant, A00247 fay surface sealant to each side of the shim (440) and the mating surfaces of the fitting assemblies (450, 480, 495).
  - (e) Install the fitting assemblies (IPL Figure 2, 450, 480, 495) and the shims (440) onto the door structure with the bolts (IPL Figure 1, 17), washers (20), and nuts (23).
- (8) Install the torque tube assemblies (IPL Figure 2, 310, 370) onto the door structure.
- (a) Install the torque tube assembly (370), as follows:
    - 1) If necessary, install the cam follower bearings (395) onto the cranks (410) with the washers (400), nuts (405), and cotter pins (392). Install the cotter pins (392) as specified in SOPM 20-50-02.
    - 2) Slide the torque tube (425) with the cranks (415, 420) into the door structure through the housing and fitting assemblies. Secure the cranks (415, 420) onto the torque tube (425) with the bolts (380), washers (385) and nuts (390).

**NOTE:** Pay attention to the bolt direction during installation to prevent interference with other components.

    - 3) Apply grease, D00015 to the inside diameter of the bearings (435).

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- 4) Install the bearings (435), spacers (430) and the cranks (410) onto the door structure and the torque tube (425). Install the spacer (430) as necessary with a nominal quantity of five.
- 5) Secure the crank (410) onto the torque tube (425) with the bolts (375), washers (385), and nuts (390). Tighten the nut (390) to 35-45 pound-inch. The nut is intended to bottom up to prevent clamp up. The maximum gap between the tube (425) and the washer (385) is 0.016 inch. Install additional washers (385) as necessary.

**NOTE:** Pay attention to the bolt direction during installation to prevent interference with other components.

- (b) Install the torque tube assembly (310), as follows:

- 1) If necessary, install the cam follower bearings (335) onto the cranks (350) with the washers (340), nuts (345), and cotter pins (332). Install the cotter pins (332) as specified in SOPM 20-50-02.
- 2) Slide the torque tube (365) with the cranks (355, 360) into the door structure through the housing and fitting assemblies. Secure the cranks (355, 360) onto the torque tube (365) with the bolts (320), washers (325), and nuts (320).

**NOTE:** Pay attention to the bolt direction during installation to prevent interference with other components.

- 3) Apply grease, D00015 to the inside diameter of the bearings (435).
- 4) Install the bearings (435), spacers (430) and cranks (350) onto the door structure and the torque tube (365). Install the spacer (430) as necessary with a nominal quantity of five.
- 5) Secure the crank (350) onto the torque tube (365) with the bolts (315), washers (325), and nuts (330). Tighten the nut (330) to 35-45 pound-inch. The nut is intended to bottom up to prevent clamp up. The maximum gap between the tube (365) and the washer (325) is 0.016 inch. Install additional washers (325) as necessary.

**NOTE:** Pay attention to the bolt direction during installation to prevent interference with other components.

- (9) Install the control rod assembly (IPL Figure 2, 230) and the rod assemblies (105, 155, 190) onto the door structure, as follows:

- (a) Install the control rod assembly (230) onto the torque tube assembly (370) with the bolt (215), washer (220), and nut (225).
- (b) Install a rig pin in the index holes on the upper and lower latches. With the handle in the closed position, adjust the length of the rod assembly (190) to allow the installation of the bolts (180, 215) through the rod ends.
- (c) Install the rod assembly (190) onto the box handle assembly (545) and the torque tube assembly (370) with the bolts (180, 215), washers (185, 220), and nuts (225).
- (d) Install a rig pin in the index holes on the upper and lower latches. With the handle in the closed position, adjust the length of the rod assembly (155) to allow the installation of the bolts (130, 145) through the rod ends.
- (e) Install the rod assembly (155) onto the box handle assembly (545) and the torque tube assembly (310) with the bolts (130, 145), washers (135, 150), and nuts (140).

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- (f) Install the rod assembly (105) onto the torque tube assembly (310) with the bolt (130), washer (135), and nut (140).
- (10) Install the gate assembly (IPL Figure 1, 341) and the end gate assembly (293) onto the door structure, as follows:
- CAUTION:** NO BURRS ARE PERMITTED ON THE BOLT (260, 263) HEADS AFTER INSTALLATION OF THE HINGE ASSEMBLY (275) TO PREVENT DAMAGE TO THE SEAL (50A).
- (a) Apply sealant, A00247 fay surface sealant onto the mating surfaces of the hinge assembly (275) and the door structure.
  - (b) Install the hinge assembly (275) with the gate assembly (341) onto the door structure with the bolts (260, 263) and washers (266).
- CAUTION:** NO BURRS ARE PERMITTED ON THE BOLT (260, 263) HEADS AFTER INSTALLATION OF THE HINGE ASSEMBLY (275) TO PREVENT DAMAGE TO THE SEAL (50A).
- (c) Apply sealant, A00247 fay surface sealant onto the mating surfaces of the hinge assembly (272) and the door structure.
  - (d) Install the hinge assembly (272) with the end gate assembly (293) onto the door structure with the bolts (260, 263) and washers (266).
- (11) Use door seal installation tool, SPL-1981, to install the seal (IPL Figure 1, 50A) and nylon rod (47) onto the door structure, as follows:
- (a) Install the seal (50A) with soap lubricant as specified in SOPM 20-50-07. Install the seal with the label TOP on the top side of the door and the label BOTTOM on the bottom side of the door. Install the seal evenly around the periphery of the door structure.
  - (b) Install the seal (50A) and the nylon rod (47) onto the hinge assembly (272, 275) with soap lubricant as specified in SOPM 20-50-07. Install the nylon rod (47) at each end of the hinge assembly (272, 275) to form a butt-fit at the center of the door structure. If necessary, trim the unwanted nylon rod (47).
- (12) Connect the gate assembly (IPL Figure 1, 341) and the end gate assembly (293) onto the rod assembly (IPL Figure 2, 105) and the control rod assembly (230), as follows:
- (a) Connect the gate assembly (IPL Figure 1, 341) with the rod assembly (IPL Figure 2, 105), as follows:
    - 1) Install the bolt (80), washers (85, 95), bushing (90), and nut (100) onto the gate assembly (IPL Figure 1, 341) and rod assembly (IPL Figure 2, 105). Install the bushing (90) with sealant, A00247 as specified in SOPM 20-50-03.
  - (b) Connect the end gate assembly (IPL Figure 1, 293) with the control rod assembly (IPL Figure 2, 230), as follows:
    - 1) Install the bolt (255), washers (260, 270), bushing (265), and nut (275) onto the end gate assembly (IPL Figure 1, 293) and the control rod assembly (IPL Figure 2, 230). Install the bushing (265) with sealant, A00247 as specified in SOPM 20-50-03.
- (13) Install the coverplates (IPL Figure 2, 30, 55, 75) and the retainer lining assembly (IPL Figure 1, 248) onto the door structure, as follows:
- (a) Install the coverplate (IPL Figure 2, 75) onto the door structure with the washers (65) and bolts (60).

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- (b) Install the coverplate (55) onto the door structure with the washers (40) and bolts (35).
  - (c) Apply a parting agent to the mating surfaces of the coverplates (30). Apply sealant, A00247 fay surface sealant to the mating surfaces of the coverplates (30) and the door structure.
  - (d) Install the coverplates (30) onto the door structure with the washers (10) and the bolts (5).
  - (e) Install the retainer lining (IPL Figure 1, 257) onto the door structure with the split rings (254) and the studs (251).
- (14) Install the stops (IPL Figure 1, 110, 113), the bracket assembly (203), and the bracket (155) onto the door structure, as follows:
- (a) Install the stops (110, 113) onto the door structure with the bolts (101), washers (104), and nuts (107).
  - (b) Install the bracket assembly (203) onto the door structure with the bolts (185) and washers (188).
  - (c) Install the bracket assembly (155) onto the door structure with the bolts (149) and washers (152).
- (15) If necessary, install the plate (IPL Figure 1, 872) and the marker (875) onto the door structure, as follows:
- (a) Install the plate (872) onto the door structure as specified in SOPM 20-50-05.
  - (b) Install the marker (875) and edge seal onto the door structure as specified in SOPM 20-50-05.

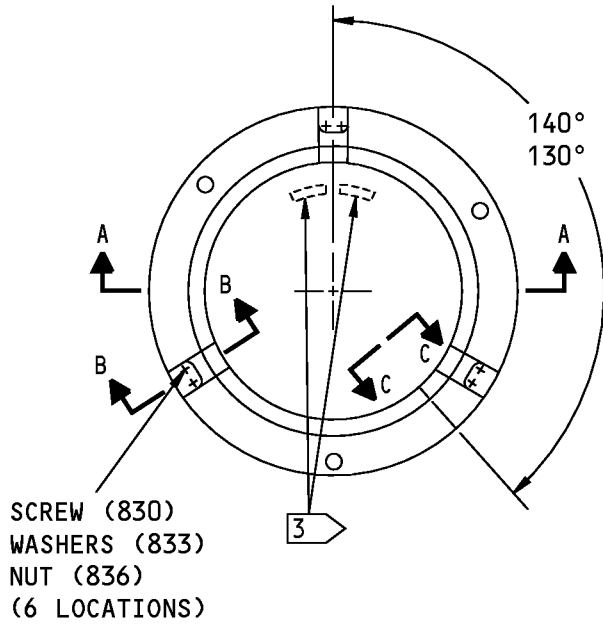
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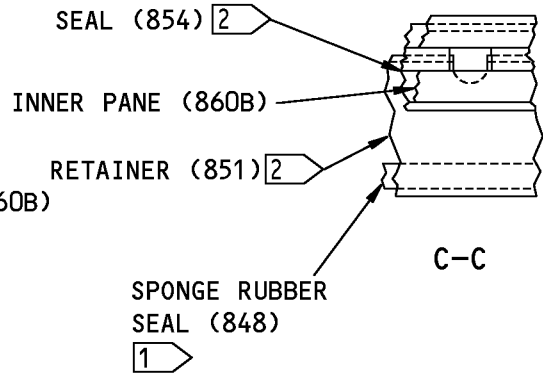
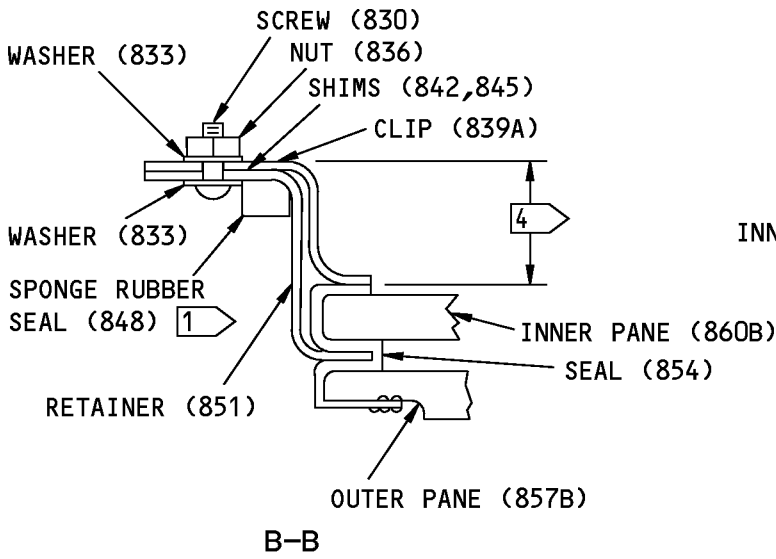
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65-2863-8



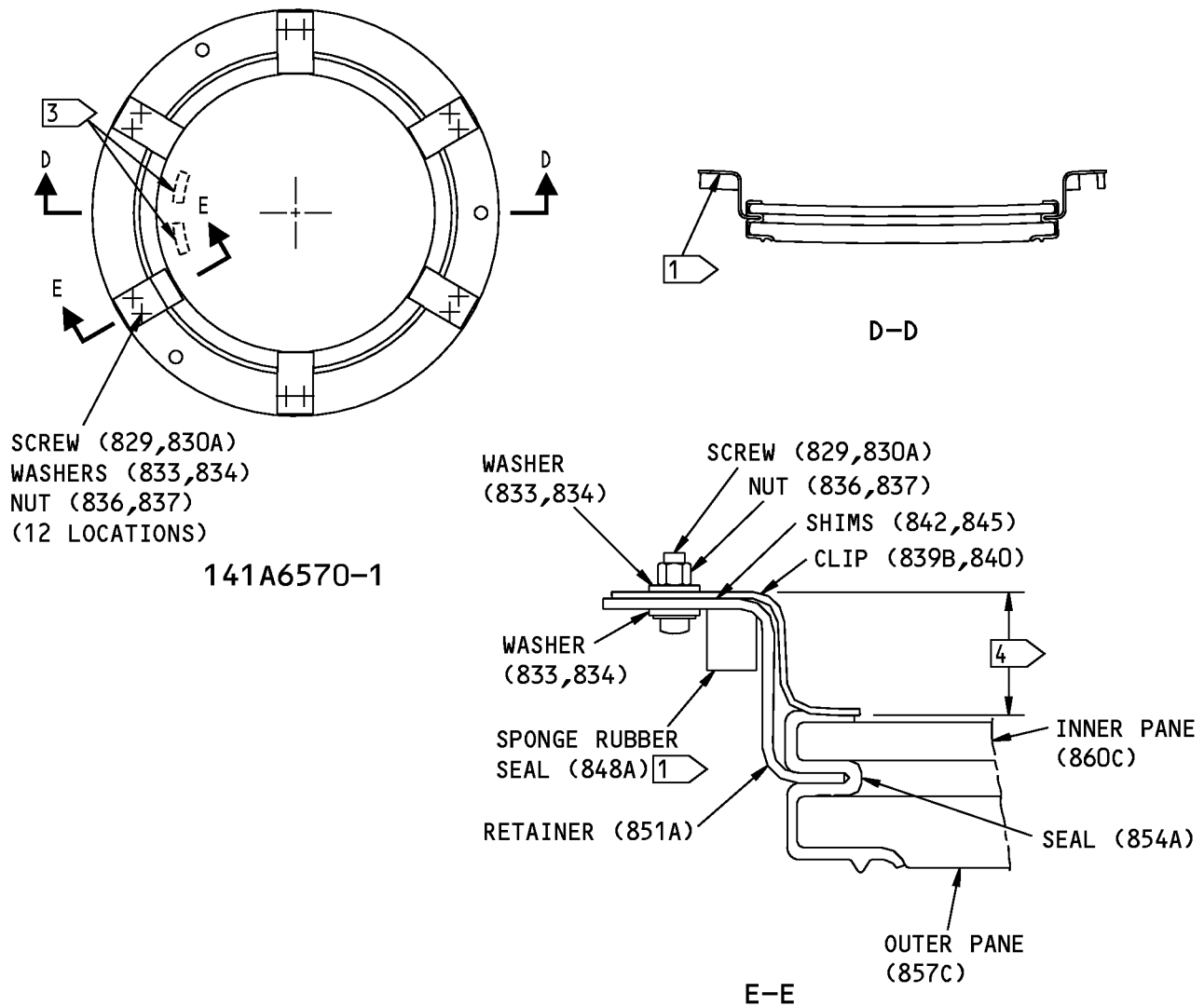
1632524 S0000298833\_V1

Observation Window Assembly  
Figure 701 (Sheet 1 of 2)

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- 1 ATTACH THE SEAL (848,848A) WITH BMS 5-55 OR BMS 5-30
- 2 ALIGN THE HOLE IN THE SEAL WITH THE SLOT IN THE RETAINER
- 3 INSTALL THE WINDOW PANES WITH THE MARKINGS IN THIS POSITION
- 4 ADD SHIMS (842,845) AS NECESSARY FOR A MAXIMUM COMPRESSION OF 0.03 INCH OF THE SEAL (854,854A)

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

1632483 S0000298834\_V1

Observation Window Assembly  
Figure 701 (Sheet 2 of 2)

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**FITS AND CLEARANCES**

**(NOT APPLICABLE)**

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FITS AND CLEARANCES

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## COMPONENT MAINTENANCE MANUAL

### SPECIAL TOOLS, FIXTURES, AND EQUIPMENT

#### 1. General

A. This section lists the special tools, fixtures, and equipment necessary for maintenance.

**NOTE:** Equivalent substitutes may be used.

#### Special Tools

Reference	Description	Part Number	Supplier
SPL-1981	Tool - Installation, Door Seal	B52004-1	81205
		K52011-1	81205

#### Tool Supplier Information

CAGE Code	Supplier Name	Supplier Address
81205	THE BOEING COMPANY	17930 INTERNATIONAL BLVD. SOUTH SEATAC, WA 98188-4321 Telephone: 206-662-6650 Facsimile: 206-662-7145

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SPECIAL TOOLS, FIXTURES, AND EQUIPMENT

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## COMPONENT MAINTENANCE MANUAL

### ILLUSTRATED PARTS LIST

#### 1. Introduction

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

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

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

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ILLUSTRATED PARTS LIST

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## COMPONENT MAINTENANCE MANUAL

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

### VENDOR CODES

Code	Name
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.
07484	ACCURATE BUSHING CO INC 443 NORTH AVENUE GARWOOD, NEW JERSEY 07027-1014 FORMERLY V83132 SMITH BRG DIV OF ACCURATE BUSHING CO
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
0HDW7	HUCK MFG CO 3724 EAST COLUMBIA STREET TUCSON, ARIZONA 85714

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ILLUSTRATED PARTS LIST

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## COMPONENT MAINTENANCE MANUAL

Code	Name
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
15656	NATIONAL-STANDARD CO PERFORATED METALS PLANT 166 DUNDAFF ST, PO DRAWER 507 CARBONDALE, PENNSYLVANIA 18407-1565 FORMERLY NATIONAL-STANDARD CO CROSS PERFORATED METALS PLANT
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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## COMPONENT MAINTENANCE MANUAL

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
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
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

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## COMPONENT MAINTENANCE MANUAL

Code	Name
75345	KIRKHILL RUBBER CO 300 EAST CYPRESS STREET BREA, CALIFORNIA 92821-4097 FORMERLY L.A. STANDARD RUBBER CO V84914
76005	LORD CORP AEROSPACE PRODUCTS DIV 1635 WEST 12TH STREET, PO BOX 10039 ERIE, PENNSYLVANIA 16514 FORMERLY LORD MANUFACTURING COMPANY FORMERLY LORD CORP LORD KINEMATICS
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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<b>Code</b>	<b>Name</b>
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
S0352	NIPPON MINIATURE BEARING CO LTD TOKYO, JAPAN

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
10-60476-5		1	50A	1
10-60779-112		3	343	1
102A9213-2-3		1	80	4
		1	194	7
		2	25	15
		2	53	2
		1	89	1
102A9213-4-3		1	89	1
102F177-3		1	303	2
102F177-4		3	360	12
102F9201-4		1	146	1
		1	177	2
		1	215	1
102F9216-2-3		2	20	1
		2	50	2
		2	70	6
102F9219-3		1	464	12
102F9220-3		1	458	7
10E4-116		2	120	1
		2	165A	1
		2	170	1
		2	200A	1
		2	205	1
		2	245	1
10E4-116NW		2	120	1
		2	165A	1
		2	170	1
		2	200A	1
		2	205	1
		2	245	1
140N2020-1		1	803	1
140N2021-1		1	785	1
140N2022-1		1	794	2
140N2022-2		1	806	1
140N2022-3		1	800	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
140N2022-4		1	797	1
141A6306-2		3	235	1
141A6306-3		3	210	1
141A6553-2		2	55	1
141A6553-3		2	75	1
141A6553-4		2	30	2
141A6570-1		1	827A	1
141A6571-1		1	857C	1
141A6571-2		1	860C	1
141A6572-1		1	851A	1
141A6573-1		1	839B	3
		1	840	3
141A6574-1		1	854A	1
141A6575-1		1	848A	1
147A6116-1		1	1A	RF
		2	1	RF
147A6116-10		1	1H	RF
		2	1G	RF
147A6116-11		1	1J	RF
		2	1H	RF
147A6116-12		1	1M	RF
		2	1L	RF
147A6116-13		1	1N	RF
		2	1M	RF
147A6116-14		1	1P	RF
		2	1N	RF
147A6116-15		1	1Q	RF
		2	1P	RF
147A6116-16		1	1R	RF
		2	1Q	RF
147A6116-17		1	1S	RF
		2	1R	RF
147A6116-18		1	1T	RF
		2	1S	RF
147A6116-19		1	1U	RF

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		2	1T	RF
147A6116-2		1	1B	RF
		2	1A	RF
147A6116-20		1	1V	RF
		2	1U	RF
147A6116-21		1	1W	RF
		2	1V	RF
147A6116-22		1	1X	RF
		2	1W	RF
147A6116-23		1	1Y	RF
		2	1X	RF
147A6116-24		1	1Z	RF
		2	1Y	RF
147A6116-26		1	2	RF
		2	1Z	RF
147A6116-27		1	2A	RF
		2	2	RF
147A6116-28		1	2B	RF
		2	2A	RF
147A6116-29		1	2C	RF
		2	2B	RF
147A6116-3		1	1C	RF
		2	1B	RF
147A6116-4		1	1K	RF
		2	1J	RF
147A6116-5		1	1L	RF
		2	1K	RF
147A6117-1		2	655	1
147A6117-2		2	655A	1
147A6117-3		2	655B	1
147A6117-4		2	655C	1
147A6118-1		2	755	1
147A6118-3		2	755A	1
147A6119-1		2	750	1
147A6120-1		2	440	3

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
147A6120-2		2	445	1
147A6121-2		2	545	1
		3	1	RF
147A6125-13		1	506	1
147A6125-15		1	482	1
147A6125-17		1	731	1
147A6125-19		1	704	1
147A6125-21		1	704A	1
147A6125-23		1	731A	1
147A6125-27		1	482A	1
147A6125-5		1	641	1
147A6125-7		1	581	1
147A6125-9		1	542	1
147A6126-21		1	764	1
147A6126-25		1	701	1
147A6126-27		1	638	1
147A6126-29		1	578	1
147A6126-33		1	539	1
147A6126-35		1	503	1
147A6126-37		1	728	1
147A6126-39		1	764A	1
147A6128-1		1	749	1
147A6128-11		1	689	1
147A6128-13		1	626	1
147A6128-15		1	563	1
147A6128-17		1	566	1
147A6128-19		1	524	1
147A6128-20		1	527	1
147A6128-21		1	501	1
147A6128-22		1	502	1
147A6128-25		1	758	1
147A6128-27		1	761	1
147A6128-29		1	725	1
147A6128-3		1	752	1
147A6128-31		1	722	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
147A6128-33		1	632	1
		1	695	1
147A6128-35		1	698	1
147A6128-37		1	635	1
147A6128-39		1	572	1
147A6128-41		1	575	1
147A6128-43		1	533	1
147A6128-44		1	536	1
147A6128-45		1	502N	1
147A6128-46		1	502R	1
147A6128-49		1	716A	1
147A6128-5		1	716	1
147A6128-51		1	725A	1
147A6128-53		1	501A	1
147A6128-54		1	502P	1
147A6128-7		1	713	1
147A6128-9		1	623	1
		1	686	1
147A6130-1		1	62	1
147A6130-2		1	68	1
147A6131-1		1	74	1
147A6131-3		1	83	1
147A6133-1		1	71	1
147A6134-1		1	272	1
147A6134-3		1	275	1
147A6134-5		1	284	1
147A6134-7		1	287	1
147A6134-9		1	290	1
147A6137-3		1	809	1
147A6137-5		1	818	1
147A6138-1		2	480	1
147A6138-11		2	475	1
147A6138-13		2	505	1
147A6138-15		2	460	1
147A6138-17		2	475A	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
147A6138-19		2	465A	1
147A6138-21		2	460A	1
147A6138-23		2	450A	1
147A6138-25		2	475B	1
147A6138-27		2	465B	1
147A6138-29		2	460B	1
147A6138-3		2	465	1
147A6138-31		2	450B	1
147A6138-5		2	495	1
147A6138-7		2	450	1
147A6138-9		2	490	1
147A6139-1		2	370	1
147A6139-3		2	310	1
147A6140-1		2	570	1
147A6140-3		2	575	1
147A6140-5		2	630	1
147A6140-6		2	635	1
147A6140-7		2	638	1
147A6140-8		2	639	1
147A6143-1		1	293	1
147A6143-11		1	293C	1
147A6143-13		1	341C	1
147A6143-3		1	341	1
147A6143-4		1	341A	1
147A6143-5		1	293A	1
147A6143-7		1	341B	1
147A6143-9		1	293B	1
147A6144-1		1	305	1
147A6144-2		1	356	1
147A6144-3		1	314	1
147A6144-4		1	368	1
147A6145-10		1	383	1
147A6145-11		1	374	1
147A6145-13		1	29	1
147A6145-15		1	32	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
147A6145-17		1	35	1
147A6145-19		1	323	1
147A6145-21		1	326	1
147A6145-22		1	320	1
147A6145-23		1	329	1
147A6145-25		1	38	1
147A6145-27		1	44	1
147A6145-28		1	383A	1
147A6145-29		1	320A	1
147A6145-3		1	41	1
147A6145-7		1	380	1
147A6145-9		1	377	1
147A6146-1		1	332	1
147A6146-11		1	332B	1
147A6146-13		1	338B	1
147A6146-3		1	338	1
147A6146-7		1	332A	1
147A6146-9		1	338A	1
147A6147-1		1	386	1
147A6147-3		1	386A	1
147A6147-4		1	386B	1
147A6149-1		1	776	1
147A6149-3		1	779	1
147A6149-5		1	788	1
147A6149-7		1	791	1
147A6161-1		1	248	1
147A6161-3		1	257	1
147A6162-1		2	620	1
149A6101-1		2	430B	4
149A6107-2		3	345	1
149A6107-5		3	380	1
149A6109-1		3	100	1
149A6110-1		2	735	1
149A6112-1		1	869	1
149A6113-2		1	302	2

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
149A6113-4		1	304	1
149A6114-1		1	596	1
		1	656	1
149A6116-1		1	662	2
149A6116-2		1	602	2
149A6120-1		3	80	1
149A6120-2		3	90	1
149A6121-1		1	815	1
149A9480-20		1	119	1
149A9480-22		1	155	1
149A9480-23		1	223	1
149A9480-24		1	224	1
149A9480-38		1	113	1
149A9480-48		1	110	1
149A9480-49		1	182	1
149A9480-5		1	98	1
149A9480-59		1	164	1
149A9480-67		1	134	1
149A9480-69		1	203	1
149A9480-71		1	209	1
149A9480-72		1	140	1
149A9480-8		1	173	1
30-3010		3	120	1
30-3013-2		3	125	1
30-3019-1		3	105	1
3SLCC6		1	748L	4
		1	748L	4
3SLCC8		1	748A	6
		1	748A	6
51564-0402		2	115	1
		2	165	1
		2	200	1
		2	240	1
51588-041		2	120	1
		2	165A	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		2	170	1
		2	200A	1
		2	205	1
		2	245	1
5164-0402DD		2	240A	1
55001		2	300	1
		2	435	4
60-4405-1		2	740	2
60-4406-16		2	365	1
60-4406-17		2	425	1
60-4455-3		3	135	1
63-1478-1		1	839A	3
63-1692-1		3	200	2
63-2848		3	130	1
63-9386-1		3	35	1
65-1933-23		3	280	1
65-1933-24		3	295	1
65-2306-10		2	305	1
65-2306-9		2	295	4
65-2863-8		1	827	1
65-28925-100		2	155A	1
65-28925-101		2	190A	1
65-28925-104		2	175A	1
65-28925-105		2	210A	1
65-28925-47		2	175	1
65-28925-48		2	210	1
65-28925-58		2	125	1
65-28925-85		2	155	1
65-28925-86		2	190	1
65-28925-87		2	105	1
65-45871-504		1	47	8
65-51687-7		3	40	1
65-51687-8		3	42	1
65-51687-9		3	42A	1
65-54013-502		3	308	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
65-54013-503		3	305	1
65-73978-1		2	670	1
65-73978-10		2	695	1
65-73978-12		2	695A	1
65-73978-13		2	680A	1
65-73978-15		2	670A	1
65-73978-17		2	680B	1
65-73978-19		2	670B	1
65-73978-21		2	680C	1
65-73978-23		2	677	1
65-73978-3		2	680	1
65-73978-8		2	685	1
65-8795-501		3	300	1
65C36793-1		3	365A	2
66-12688-11		1	502E	1
		1	530A	1
		1	569	1
		1	629	1
		1	692	1
		1	719	1
		1	755	1
66-14527-8		2	730	2
66-14530-5		2	360	1
66-14531-12		2	355	1
		2	415	1
66-14531-13		2	420	1
66-14618-7		2	250	1
66-15332-1		2	430	4
		2	430A	4
66-15645-1		2	650	2
66-1921-2		1	854	1
66-24986-1		3	20	1
66-2646		1	848	1
66-9776		1	179	2
69-1083-2		1	860B	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
69-1084-2		1	857B	1
69-17330-6		2	745	1
69-18187-26		2	230	1
69-1983-7		1	851	1
69-37418-11		2	350	2
		2	410	2
69-39176-3		3	340	1
69-39176-4		3	344	1
69-41720-3		1	335	2
69-70268-2		2	625	1
69-78694-3		3	370	4
69-78694-4		3	375	4
69B10068-3		3	155	1
		3	175	1
77253		3	343	1
81669V5K6		1	518	4
		1	557	3
		1	611	4
		1	680	1
81669V6K4		1	548	3
		1	707	15
81669V6K5		1	677	1
81669V6K6		1	494	4
		1	617	2
		1	674	4
		1	743	4
81669V8K4		1	515	1
		1	545	2
		1	614	1
		1	671	1
81669V8K5		1	497	1
		1	551	1
		1	668	1
		1	746	1
81669V8K6		1	491	5

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	512	2
		1	554	1
		1	608	2
		1	665	2
		1	740	5
81669V8K7		1	509	2
		1	605	1
82-99-341-18		1	251	4
8675-5		1	50A	1
90-7811		3	65	1
90-7815-25		3	240	1
90-7815-29		3	265	1
90-7821-1		3	60	1
90-7879-7		3	25	1
AB4E27FN		2	115	1
		2	165	1
		2	200	1
		2	240	1
AB4E27FN12		2	240A	1
ABW16-101		2	300	1
		2	435	4
ACMKP12AP510Y19		3	55	1
ACMKP21BSP510LY		3	205	2
ACMKP23BSP510LY		3	270	2
ACMKP25BP26LY19		3	336	2
ACMKP25BP510LY1		3	336	2
ACMKP25P26LY198		3	336	2
ADNE5-202		3	343	1
AF3253-4-3B		1	317	28
AF3253-4-4B		1	371	30
AN316-5R		2	110	2
		2	160	2
		2	195	2
		2	235A	1
AN316-6R		3	342	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
AN996-14		3	115	1
AR4E4FN		2	115	1
		2	165	1
		2	200	1
		2	240	1
AR4E4FN12		2	240A	1
AR4E7AFNW		2	120	1
		2	165A	1
		2	170	1
		2	200A	1
		2	205	1
		2	245	1
ARB4E60FNW		2	120	1
		2	165A	1
		2	170	1
		2	200A	1
		2	205	1
		2	245	1
ARHT5E102		3	343	1
ASM4F6		2	115	1
		2	165	1
		2	200	1
		2	240	1
ASM4F6DM		2	240A	1
ASMK4F1		2	120	1
		2	165A	1
		2	170	1
		2	200A	1
		2	205	1
		2	245	1
ASSB16-19		2	300	1
		2	435	4
BAC27DBY191		1	875	1
BACB10A187L		2	115	1
		2	165	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		2	200	1
		2	240	1
BACB10A187M2L		2	240A	1
BACB10A397GCM2		2	300	1
		2	435	4
BACB10FK5F9HS		1	65	1
		2	335	2
		2	395	2
BACB10FR25		3	336	2
BACB10FS12		3	55	1
BACB10FV21		3	205	2
BACB10FV23		3	270	2
BACB10NM3K4		1	590	10
BACB10Y4		2	120	1
		2	165A	1
		2	170	1
		2	200A	1
		2	205	1
		2	245	1
BACB28AK04-030		2	90	1
		2	265	1
BACB28X4M014		1	308	1
		1	359	1
BACB28X6M014		1	311	1
		1	365	1
BACB30NM3K11		2	595	2
		2	595	2
		2	660	4
		2	660	4
BACB30NM3K13		3	5	4
		3	70	4
BACB30NM3K17		2	315	4
		2	375	4
BACB30NM3K19		2	320	4
		2	380	4

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACB30NM3K3		1	821	3
		2	280	16
BACB30NM3K4		1	650	10
BACB30NM3K7		3	160	1
BACB30NM3K8		1	296	4
		1	344	4
BACB30NM3K9		1	53	3
BACB30NM4K11		2	600	2
BACB30NM4K13		2	130	2
		2	215	2
BACB30NM4K17		2	80	1
		2	255	1
BACB30NM4K19		2	525	12
BACB30NM5K16		2	510	1
BACB30NR4K12		2	145	1
		2	180	1
BACB30NR4K4		3	180	1
BACB30NR4K6		3	185	1
BACB30NR5K17		3	330	1
BACB30NT3K1		1	149	3
		1	218	3
BACB30NT3K16		1	101	2
BACB30NT3K3		1	185	7
		2	5	24
		2	35	4
BACB30NT3K4		2	60	6
		1	185A	7
		2	5A	24
		2	35A	4
BACB30NT3K5		2	60A	6
		1	263	16
BACB30NT3K6		1	260	3
BACB30PU4-25		2	700	8
BACB30PU5-28		2	715	2
BACB30VF3K11		3	140	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		3	310	1
BACB30VF3K3		1	18	1
BACB30VF3K4		1	17	15
		1	56	2
		1	478	4
BACB30VF3K7		3	315	1
BACB30VN6K4		1	548	3
		1	707	15
BACB30VN6K5		1	677	1
BACB30VN6K6		1	494	4
		1	617	2
		1	674	4
		1	743	4
BACB30VN6K7		1	518	4
		1	557	3
		1	611	4
		1	680	1
BACB30VN8K4		1	515	1
		1	545	2
		1	614	1
		1	671	1
BACB30VN8K5		1	497	1
		1	551	1
		1	668	1
		1	746	1
BACB30VN8K6		1	491	5
		1	512	2
		1	554	1
		1	608	2
		1	665	2
		1	740	5
BACB30VN8K7		1	509	2
		1	605	1
BACB30VT6K3		1	407	28
BACB30VT6K4		1	401	12

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		2	560	26
BACB30VT6K5		1	398	2
BACB30VT6K6		1	416	2
BACB30VT8K3		1	404	8
BACB30VT8K4		1	413	4
BACB30VT8K5		1	412	3
BACB30VT8K6		1	411	5
BACB30VT8K7		1	414	6
BACB30VU5K5		1	410	6
BACB30VU6K3		1	395	38
BACB30VU6K4		1	392	68
BACB30VU6K5		1	8	4
		1	389	24
BACB30VU6K6		1	5	4
BACB30VU8K5		1	470	4
BACB30VU8K6		1	467	4
BACC30BK		1	500	10
		1	521	9
		1	560	10
		1	620	10
		1	683	10
		1	710	14
BACC30BK6		1	748L	4
BACC30BK8		1	748A	6
BACC30BL		1	419	156
BACC30BQ		1	11	8
		1	425	29
BACF3H06JK006HN		2	535	6
BACF3H12JF007HN		1	461	3
BACF3T01E05-04B		1	443A	2
BACF3T01E5-4B		1	443	2
BACN10JA3CD		1	303	2
BACN10JA4CD		3	360	12
BACN10JD105CD		2	345	2
		2	405	2

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACN10JD106ASU		3	220	1
		3	250	1
BACN10JD106CD		3	220A	1
BACN10JD6CD		3	30	1
BACN10JP3ACD		3	355	4
BACN10JP5C		3	290A	1
BACN10JP5CCD		3	290	1
BACN10JR4CFD		1	146	1
		1	177	2
		1	215	1
BACN10JZ3A2CDM		1	464	12
BACN10JZ3B2CDM		1	458	7
BACN10KE3B2CD		1	80	4
		1	194	7
		2	25	15
		2	53	2
BACN10KE3B4CD		1	89	1
BACN10KE3DCD		1	587	10
		1	647	10
BACN10KE3E2CD		2	20	1
		2	50	2
		2	70	6
BACN10MK3-45		1	866	3
BACN10YR04CD		1	836	6
		1	837	6
BACN10YR3CD		1	23	16
		1	107	2
		1	353	4
		1	481	4
		2	290	16
		3	15	4
		3	150	1
		3	170	1
		3	325	2
BACN10YR3CM		2	330	8

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		2	390	8
		2	710	8
BACN10YR4CD		2	100	1
		2	275	1
		3	195	2
BACN10YR4CM		2	140	2
		2	225	2
		2	725	2
BACN10YR5CD		1	67	1
BACN10YR5CM		2	520	1
BACN10ZV		1	422	26
		2	565	26
BACP18BC02A06P		2	332	2
		2	392	2
BACP18BC03A08P		2	555	1
BACP18BC03A10P		3	215	1
BACR12AG2C		1	254	4
BACR15A3AD		1	303N	4
BACR15BA3AD		1	77	8
		1	86	2
		1	455	38
		1	584	20
		1	644	20
		1	659	4
		2	73	12
		3	350	32
BACR15BA3D		1	143	2
		1	176	4
		1	212	2
BACR15BA4D		1	158	6
		1	227	6
		3	285	2
BACR15BA5AD		1	599	4
BACR15BA5B		1	269	60
BACR15BA5D		1	137	2

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	206	2
BACR15BB3DC		2	197A	1
BACR15BB4AD		1	782	2
BACR15BB4D		1	26	8
		1	239	8
		1	485	12
		1	734	4
BACR15DR3AD		1	584A	20
		1	644A	20
BACR15FR4E3R		1	317	28
BACR15FR4E4R		1	371	30
BACR15FT5D		1	116	4
		1	773	6
BACR15FT6D		1	770	12
BACR15GE3CW2		1	191	14
		2	15	32
		2	45	8
BACR15GF4D		1	863	6
BACR15GF5D		1	440	279
		1	807	40
		1	812	2
		3	352	8
BACR15GF6D		1	428	40
BACR15GJ5E3		1	245	4
BACR15GK4E2		1	14	41
BACR15GK6E		1	233	8
BACR15GK6E3		1	95	2
		1	122	4
		1	167	2
		1	434	115
BACR15GK6E4		1	92	4
		1	170	3
		1	437	21
BACR15GK6E5		1	128	1
BACS12HJ04K8		1	829	6

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	830A	6
BACS14K1		1	236	4
		1	488	6
BACS14K2		1	161	3
BACS14K3		1	737	2
BACS14K4		1	230	3
BACS14K7		1	242	4
BACS21AP180RP		1	251	4
BACS40R007B007F		1	842	1
BACS40R007B008F		1	131	1
		1	449	27
BACS40R007B017F		1	446	5
BACS40R007C007F		1	845	1
BACS40R008C008F		1	452	10
BACS40R008C030F		1	197	1
BACS40R008C037F		1	200	1
BACS40R008C042F		2	540	2
BACW10BN3AC		1	59	3
		1	299	4
		1	347	4
		1	824	3
		3	75	4
BACW10BN4AC		2	85	1
		2	150	1
		2	185	1
		2	260	1
		2	530	6
		2	605	2
BACW10BN4AP		2	610	2
BACW10BP3APU		2	705	8
BACW10BP3CD		2	665	4
BACW10BP4APU		2	720	2
BACW10CT6J		1	188	7
		1	266	19
		2	10	24

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		2	40	4
		2	65	6
		2	590	2
BACW10P148AL		3	45	1
BH00312-04		1	836	6
BLN16385GC		2	300	1
		2	435	4
BRE4140L		2	115	1
		2	165	1
		2	200	1
		2	240	1
BRE4795L		2	240A	1
BRES4-2236L2		2	120	1
		2	165A	1
		2	170	1
		2	200A	1
		2	205	1
		2	245	1
BRF110C3D		1	303	2
BRF110C4D		3	360	12
BRF170C3D		1	303	2
BRF170C4D		3	360	12
BRF200C4D		1	146	1
		1	177	2
		1	215	1
BRFR120C3-2D		2	20	1
		2	50	2
		2	70	6
BRFR220C3-2D		1	80	4
		1	194	7
		2	25	15
		2	53	2
BRFR220C3-4D		1	89	1
CHRS3CFR9		1	65	1
		1	65	1

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		2	335	2
		2	335	2
		2	395	2
		2	395	2
CR3253-4-3		1	317	28
CR3253-4-4		1	371	30
DE586		1	242	4
DE675-10		1	230	3
DE676-10		1	737	2
DE679-10		1	161	3
DE685-10		1	236	4
		1	488	6
DREM5-019		3	343	1
F51636-3		1	303	2
F51636-4		3	360	12
		3	360	12
F51643-3BAC		1	464	12
F51646-3BAC		1	458	7
F51747-3-2CD		1	80	4
		1	194	7
		2	25	15
		2	53	2
F51747-3-4CD		1	89	1
F51751-3-2CD		2	20	1
		2	50	2
		2	70	6
F51753-3DC		1	587	10
		1	647	10
H52732-04CD		1	836	6
		1	837	6
H52732-3CD		1	23	16
		1	107	2
		1	353	4
		1	481	4
		2	290	16

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		3	15	4
		3	150	1
		3	170	1
		3	325	2
H52732-3CM		2	330	8
		2	390	8
		2	710	8
H52732-4CD		2	100	1
		2	275	1
		3	195	2
H52732-4CM		2	140	2
		2	225	2
		2	725	2
H52732-5CD		1	67	1
H52732-5CM		2	520	1
HB4E135		2	115	1
		2	165	1
		2	200	1
		2	240	1
HB4E140		2	240A	1
HB4E212K		2	120	1
		2	165A	1
		2	170	1
		2	200A	1
		2	205	1
		2	245	1
HGL16-102		2	300	1
		2	435	4
HR3253-4-4		1	371	30
HR3253-5-3		1	245	4
HRSC3CFR9		1	65	1
		2	335	2
		2	395	2
HST10AG6-3		1	407	28
		1	407	28

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HST10AG6-4		1	407	28
		1	407	28
		1	401	12
		1	401	12
		1	401	12
		1	401	12
		2	560	26
		2	560	26
HST10AG6-5		2	560	26
		2	560	26
		1	398	2
		1	398	2
HST10AG6-6		1	398	2
		1	398	2
		1	416	2
		1	416	2
HST10AG8-3		1	416	2
		1	416	2
		1	404	8
		1	404	8
HST10AG8-4		1	404	8
		1	404	8
		1	413	4
		1	413	4
HST10AG8-5		1	413	4
		1	413	4
		1	412	3
		1	412	3
HST10AG8-6		1	412	3
		1	412	3
		1	411	5
		1	411	5
HST10AG8-7		1	411	5
		1	411	5
		1	414	6

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HST11AG5-5		1	414	6
		1	414	6
		1	414	6
		1	410	6
		1	410	6
		1	410	6
HST11AG6-3		1	410	6
		1	395	38
		1	395	38
		1	395	38
HST11AG6-4		1	395	38
		1	392	68
		1	392	68
		1	392	68
HST11AG6-5		1	392	68
		1	8	4
		1	8	4
		1	8	4
		1	8	4
		1	389	24
		1	389	24
		1	389	24
HST11AG6-6		1	389	24
		1	5	4
		1	5	4
		1	5	4
HST11AG8-5		1	5	4
		1	470	4
		1	470	4
		1	470	4
HST11AG8-6		1	470	4
		1	467	4
		1	467	4
		1	467	4

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
J7444-11		1	242	4
K51602-4BAC		1	146	1
		1	177	2
		1	215	1
		2	240A	1
KB4ESSD6FN		2	240A	1
KB4ESSFN		2	115	1
		2	165	1
		2	200	1
		2	240	1
KBDE5-14		3	343	1
KBE4-150AFNW		2	120	1
		2	165A	1
		2	170	1
		2	200A	1
		2	205	1
		2	245	1
KRP141500VT6-6		3	230	1
		3	260	1
KSSB16-5		2	300	1
		2	435	4
LGPL2SPV6-4AC		1	548	3
		1	548	3
		1	548	3
		1	707	15
		1	707	15
		1	707	15
LGPL2SPV6-5AC		1	677	1
		1	677	1
		1	677	1
LGPL2SPV6-6AC		1	494	4
		1	494	4
		1	494	4
		1	617	2
		1	617	2
		1	617	2

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COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
LGPL2SPV6-7AC		1	674	4
		1	674	4
		1	674	4
		1	743	4
		1	743	4
		1	743	4
		1	518	4
		1	518	4
		1	518	4
		1	557	3
		1	557	3
		1	557	3
		1	611	4
		1	611	4
		1	611	4
LGPL2SPV8-4AC		1	680	1
		1	680	1
		1	680	1
		1	515	1
		1	515	1
		1	515	1
		1	545	2
		1	545	2
		1	545	2
		1	614	1
LGPL2SPV8-5AC		1	614	1
		1	614	1
		1	671	1
		1	671	1
		1	671	1
		1	497	1
		1	497	1
	1	497	1	
	1	551	1	
	1	551	1	

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PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
LGPL2SPV8-6AC		1	551	1
		1	668	1
		1	668	1
		1	668	1
		1	746	1
		1	746	1
		1	746	1
		1	491	5
		1	491	5
		1	491	5
		1	512	2
		1	512	2
		1	512	2
		1	554	1
		1	554	1
		1	554	1
		1	608	2
		1	608	2
		1	608	2
	LGPL2SPV8-7AC		1	665
		1	665	2
		1	665	2
		1	740	5
		1	740	5
		1	740	5
		1	509	2
		1	509	2
		1	509	2
		1	605	1
	1	605	1	
	1	605	1	
M83461-1-212		3	95	1
M83461-1-214		2	640	2
M83461-1-325		2	550	1
MK3000-5BAC		3	290A	1

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## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
MS15001-4		2	297	1
MS16625-4162		3	50	1
MS20253P2-2910		1	281	1
MS20426D4		3	306	4
MS20470D3		2	113	1
		2	163	1
		2	197	1
MS20470D5		2	237	1
MS20615-5M10		3	341	1
MS21141U6P4		1	431	14
MS2114U6P4		1	125	1
MS21209F5-20		3	41	3
MS24665-283		3	245	1
MS27253F1		1	872	1
MS39086-111		3	110	1
MS39086-125		1	278	2
MSSK4ASFG		2	120	1
		2	165A	1
		2	170	1
		2	200A	1
		2	205	1
		2	245	1
MSSR56-14BAC		3	343	1
MXJ45-14BFG		2	115	1
		2	165	1
		2	200	1
		2	240	1
MXJ45-14BFG2		2	240A	1
NAS1149C0332R		2	325	8
		2	385	8
NAS1149C0632B		3	255	1
NAS1149C1790R		2	645	2
NAS1149D0332J		1	20	16
		1	152	3
		1	221	3

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## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		2	285	16
		3	145	2
		3	165	2
		3	320	2
NAS1149D0363J		1	104	2
		1	350	4
		1	480	4
		1	593	10
		1	653	10
		3	10	4
NAS1149D0432J		3	190	2
NAS1149D0463J		2	95	1
		2	270	1
NAS1149D0516J		2	340	16
		2	400	16
NAS1149D0532J		1	66	1
NAS1149D0563J		3	335	1
NAS1149D0632J		3	33	1
NAS1149D2190J		3	275	2
NAS1149DN432J		1	833	12
		1	834	12
NAS1149E0432R		2	135	2
		2	220	2
NAS1149E0563R		2	515	1
NAS1149E0632R		3	225	1
NAS1399CW3		1	584B	20
		1	644B	20
NAS1805-3L		2	580	2
NAS1805-4L		2	615	2
NAS516-1A		2	455	1
		2	470	1
		2	485	1
		2	500	1
		3	85	1
NAS620A10L		2	585	2

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## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
NAS69BA4		3	307	2
NAS76A16-016P		2	637	1
NAS8200A8		1	829A	6
		1	830	6
		1	830B	6
NASM21209F1-15		2	675A	4
		2	690A	4
NB12BGCM2		2	300	1
		2	435	4
NB16BM2		2	300	1
		2	435	4
NC16-4		2	300	1
		2	435	4
NHNE5-202		3	343	1
NS103199-054		3	290A	1
NS202476-048		1	146	1
		1	177	2
		1	215	1
NS202484-02		1	303	2
NS202492-02		1	464	12
NS202493-02-2		1	80	4
		1	194	7
		2	25	15
		2	53	2
NS202493-02-4		1	89	1
NS202494-02-2		2	20	1
		2	50	2
		2	70	6
NS202495-02		1	587	10
		1	647	10
PACMKP12AA3908		3	55	1
PACMKP12AFS428		3	55	1
PACMKP21BSA3908		3	205	2
PACMKP21BSFS428		3	205	2
PACMKP23BSA3908		3	270	2

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## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
PACMKP23BSFS428		3	270	2
PACMKP25BA3908		3	336	2
PACMKP25BFS428		3	336	2
PLH504CD		1	837	6
PLH53CD		1	23	16
		1	107	2
		1	353	4
		1	481	4
		2	290	16
		3	15	4
		3	150	1
		3	170	1
		3	325	2
PLH53CM		2	330	8
		2	390	8
		2	710	8
PLH54CD		2	100	1
		2	275	1
		3	195	2
PLH54CM		2	140	2
		2	225	2
		2	725	2
PLH55CD		1	67	1
PLH55CM		2	520	1
REM10ATC12-2		3	343	1
RMA9205M5		3	290A	1
S14162-5		1	50A	1
SL2509		1	242	4
SL2750		1	230	3
SL2751-3S		1	737	2
SL2752-3		1	161	3
SL2808-3		1	236	4
		1	488	6
SSMKP12AP		3	55	1
SSMKP12ASD705		3	55	1

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## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
SSMKP21BSSD705		3	205	2
		3	270	2
SSMKP23BSSD705		3	270	2
SSMKP25BSD703		3	336	2
T8059S1032B1		1	866	3
		1	866	3
T8078S524		3	290A	1
T8092C428CD		1	146	1
		1	177	2
		1	215	1
TFM5C		3	343	1
WC10K6-3		1	407	28
WC10K6-5		1	398	2
WC10K6-6		1	416	2
WC10K8-3		1	404	8
WC10K8-4		1	413	4
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WC10K8-6		1	411	5
WC10K8-7		1	414	6

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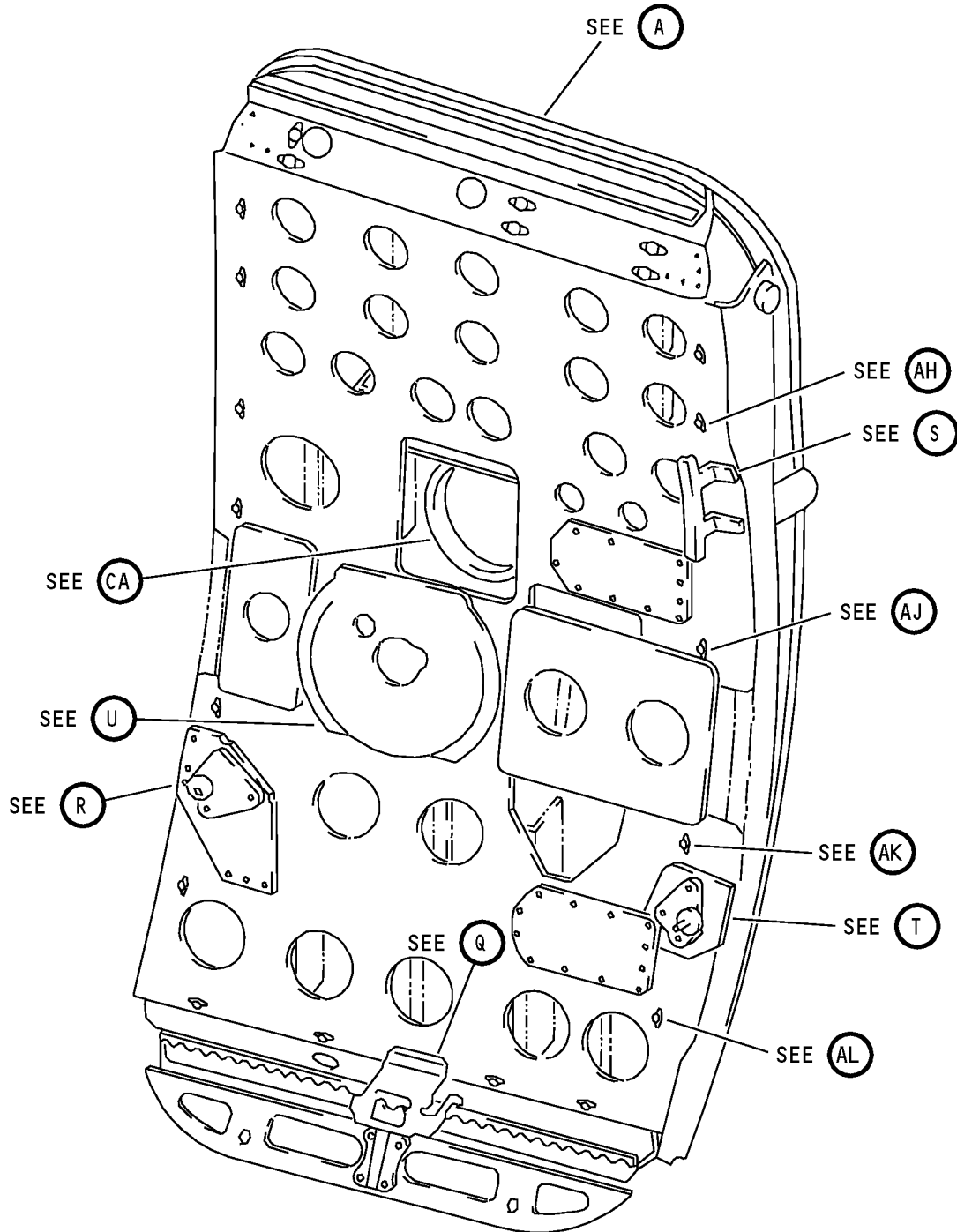
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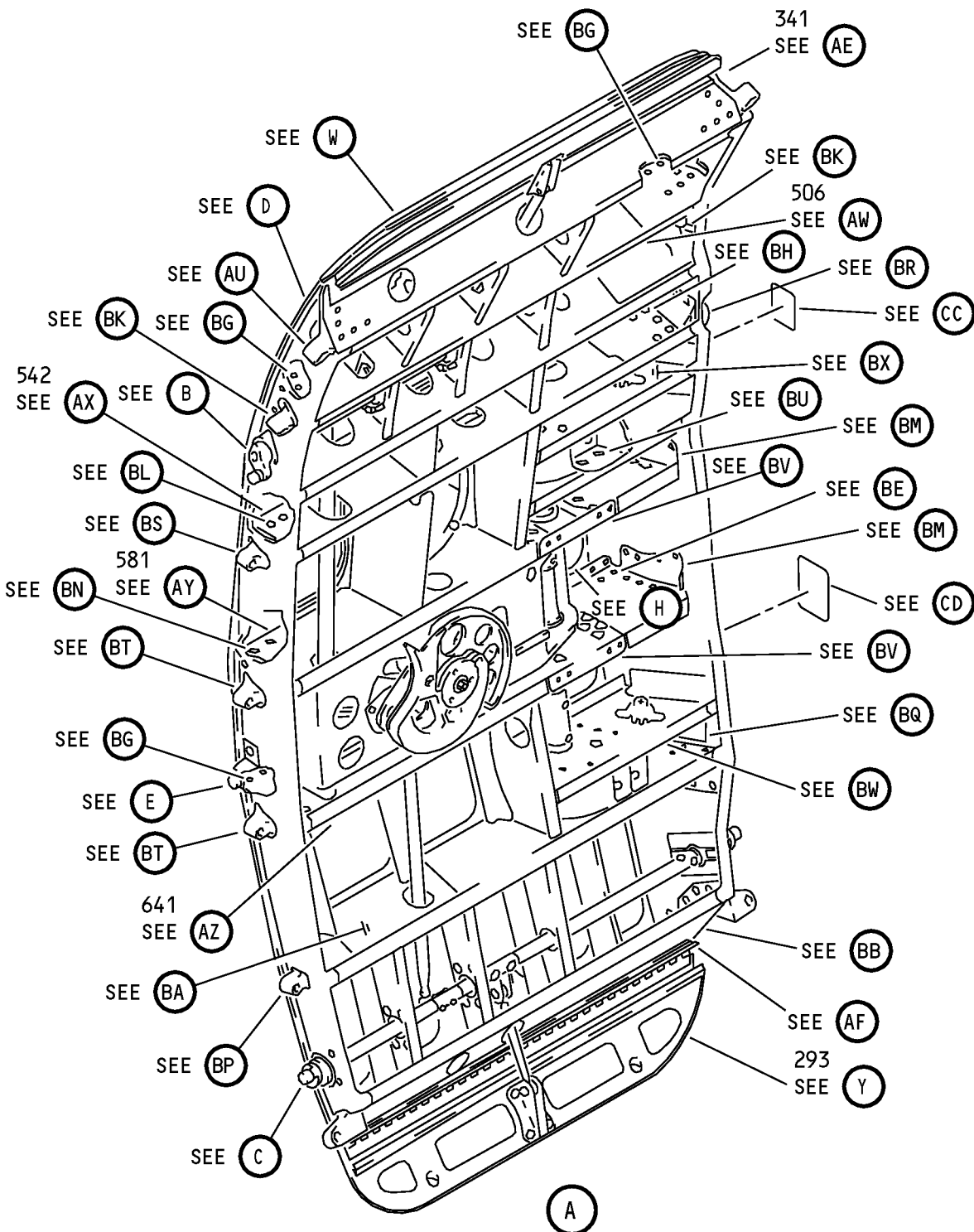


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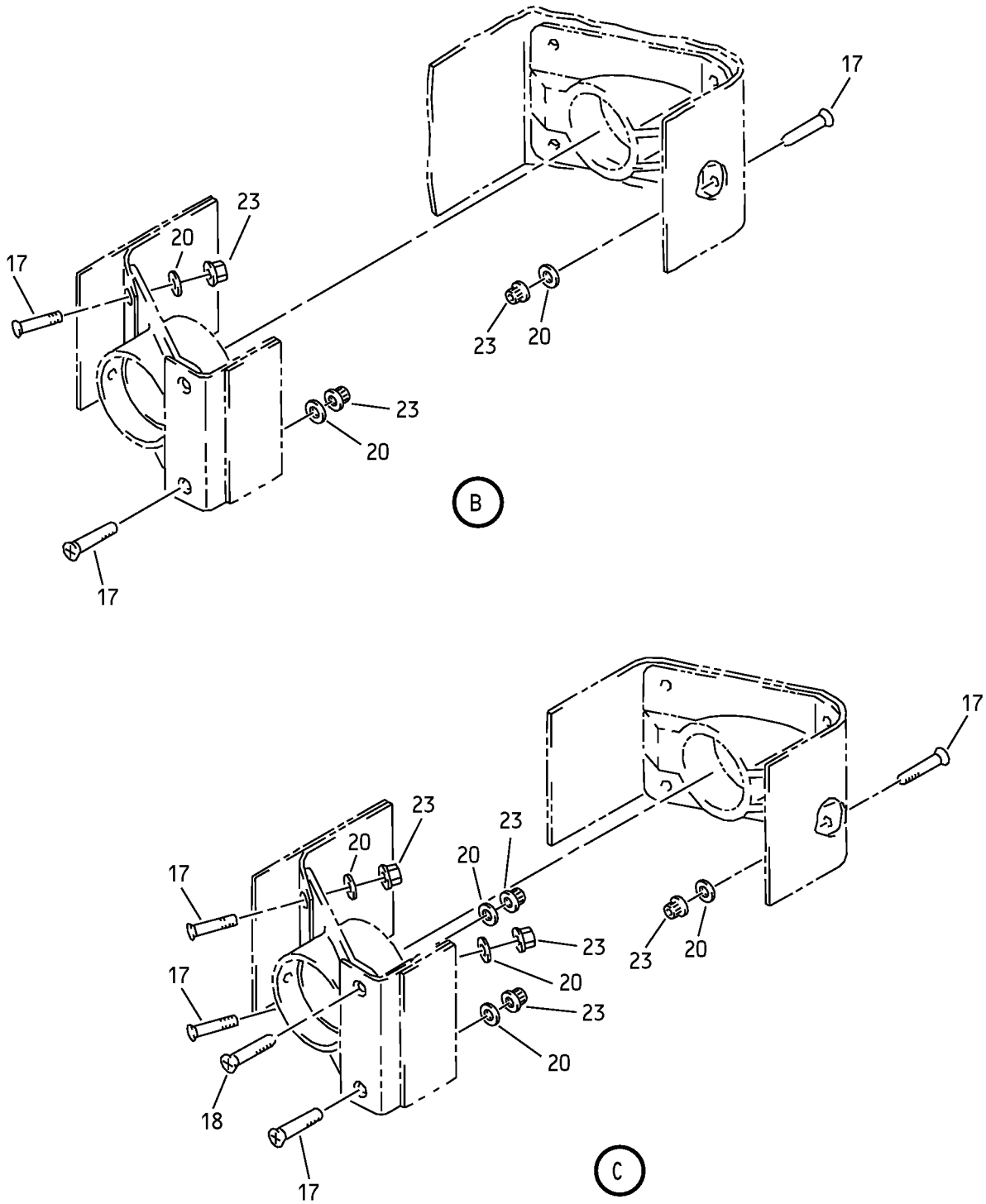
Aft Entry Door Assembly  
IPL Figure 1 (Sheet 1 of 42)

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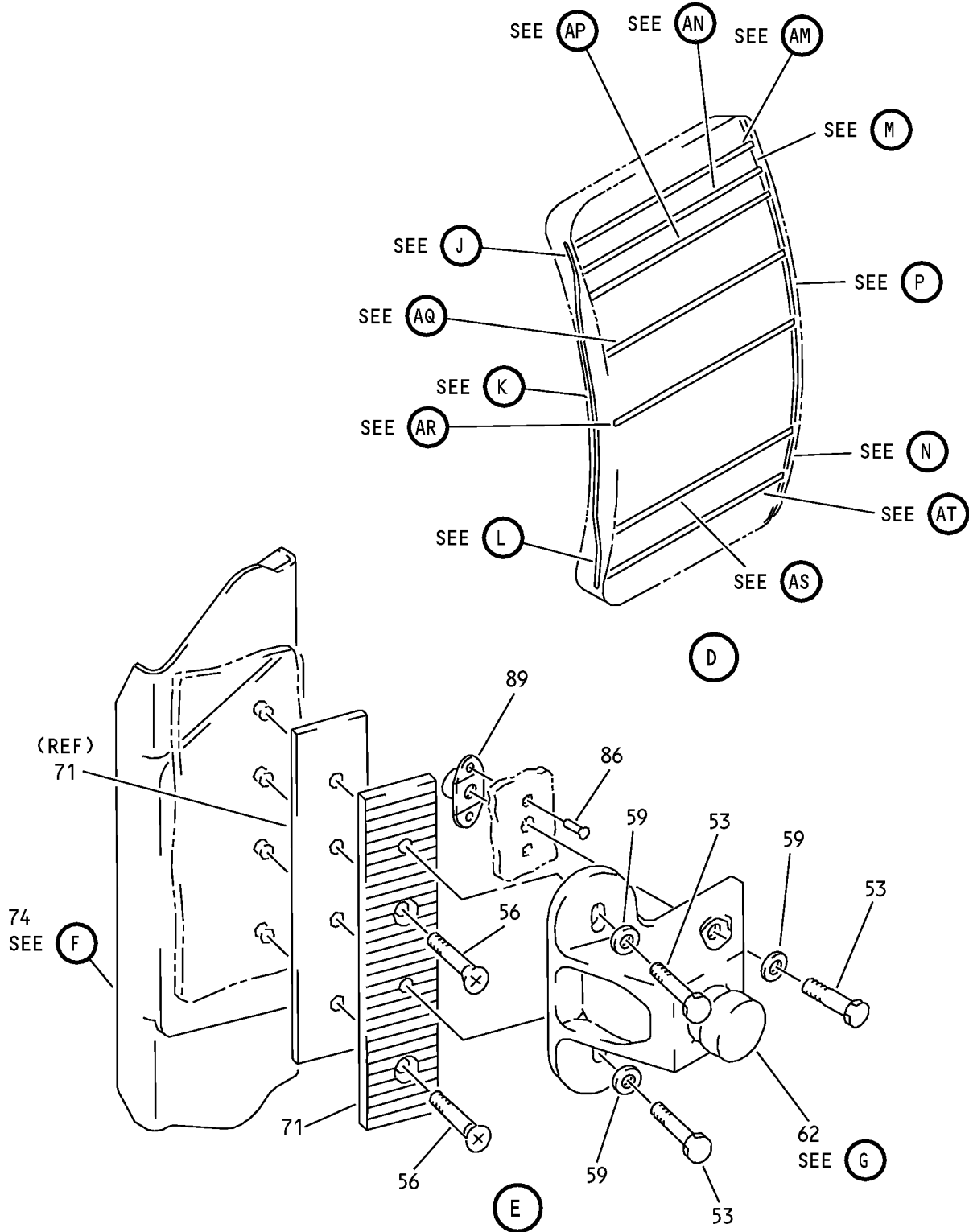
Aft Entry Door Assembly  
IPL Figure 1 (Sheet 2 of 42)

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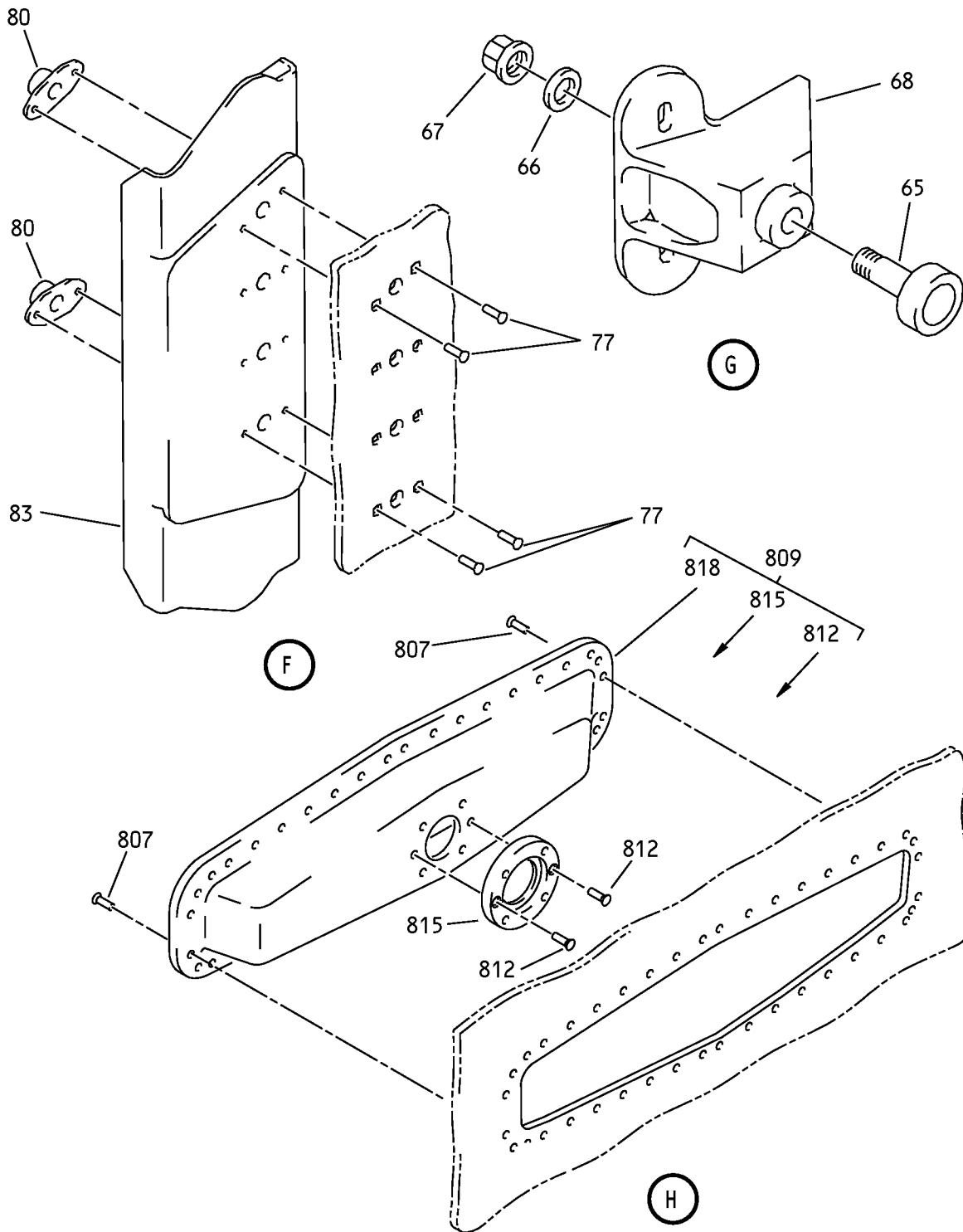
Aft Entry Door Assembly  
IPL Figure 1 (Sheet 3 of 42)

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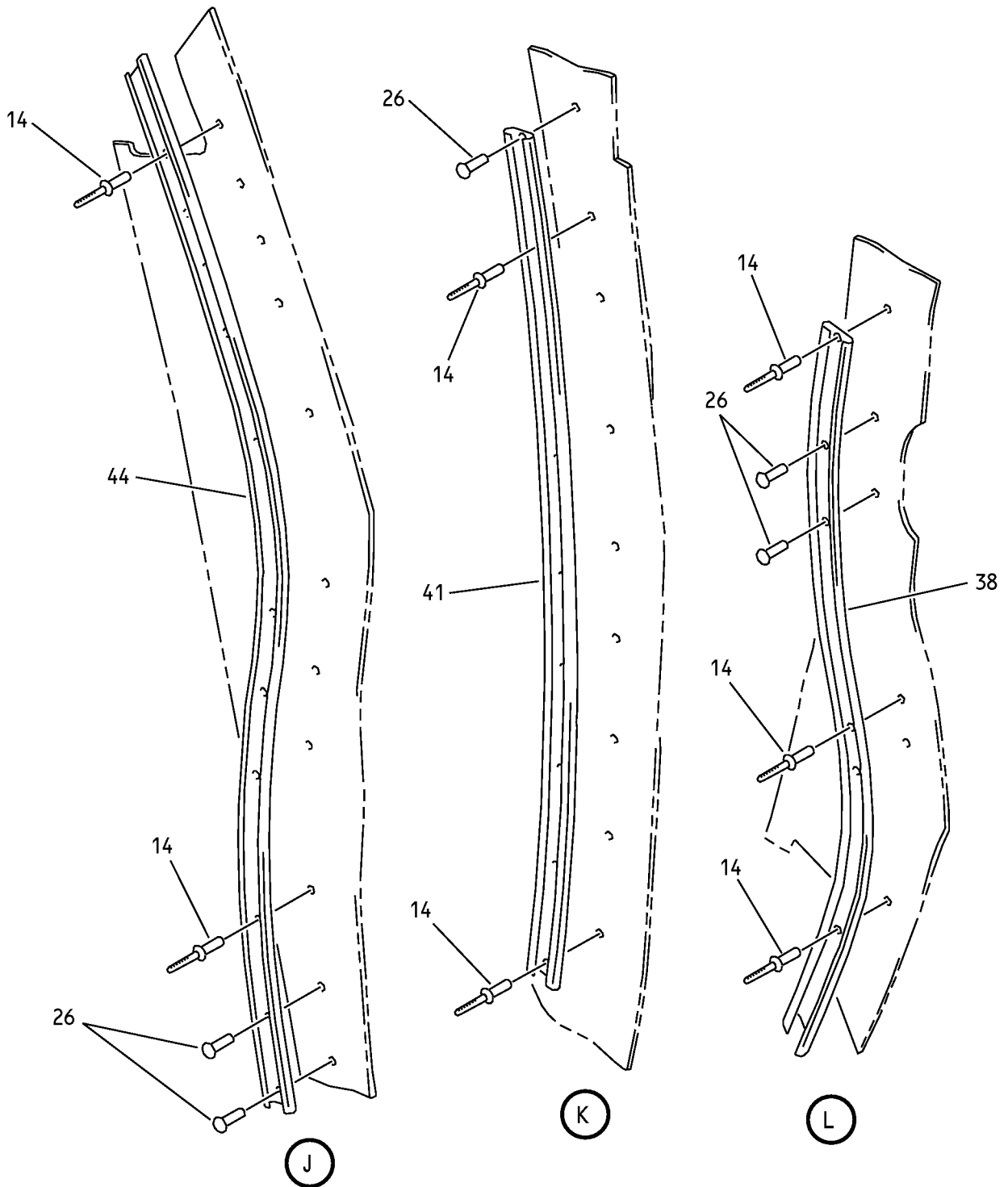
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IPL Figure 1 (Sheet 4 of 42)

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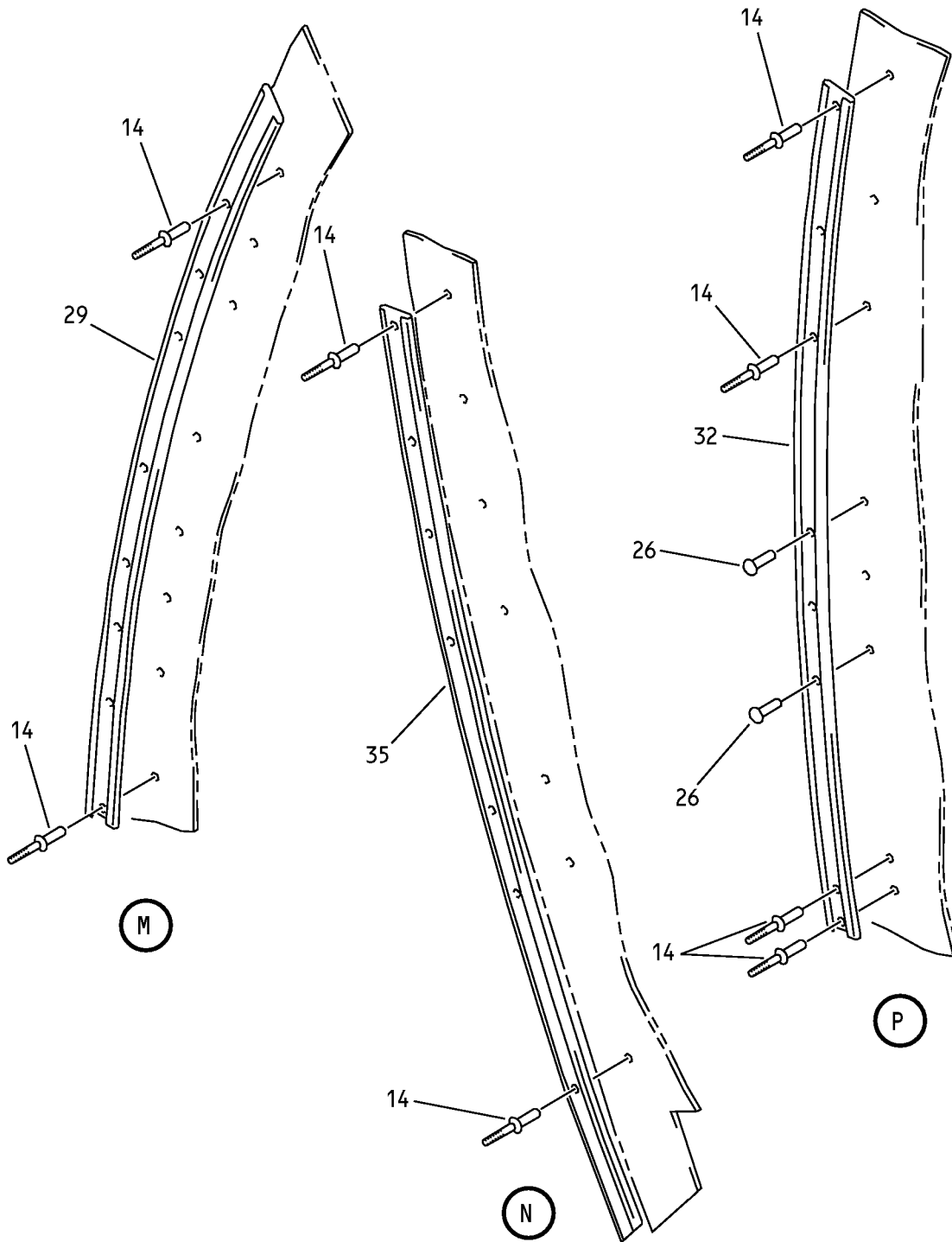
Aft Entry Door Assembly  
IPL Figure 1 (Sheet 5 of 42)

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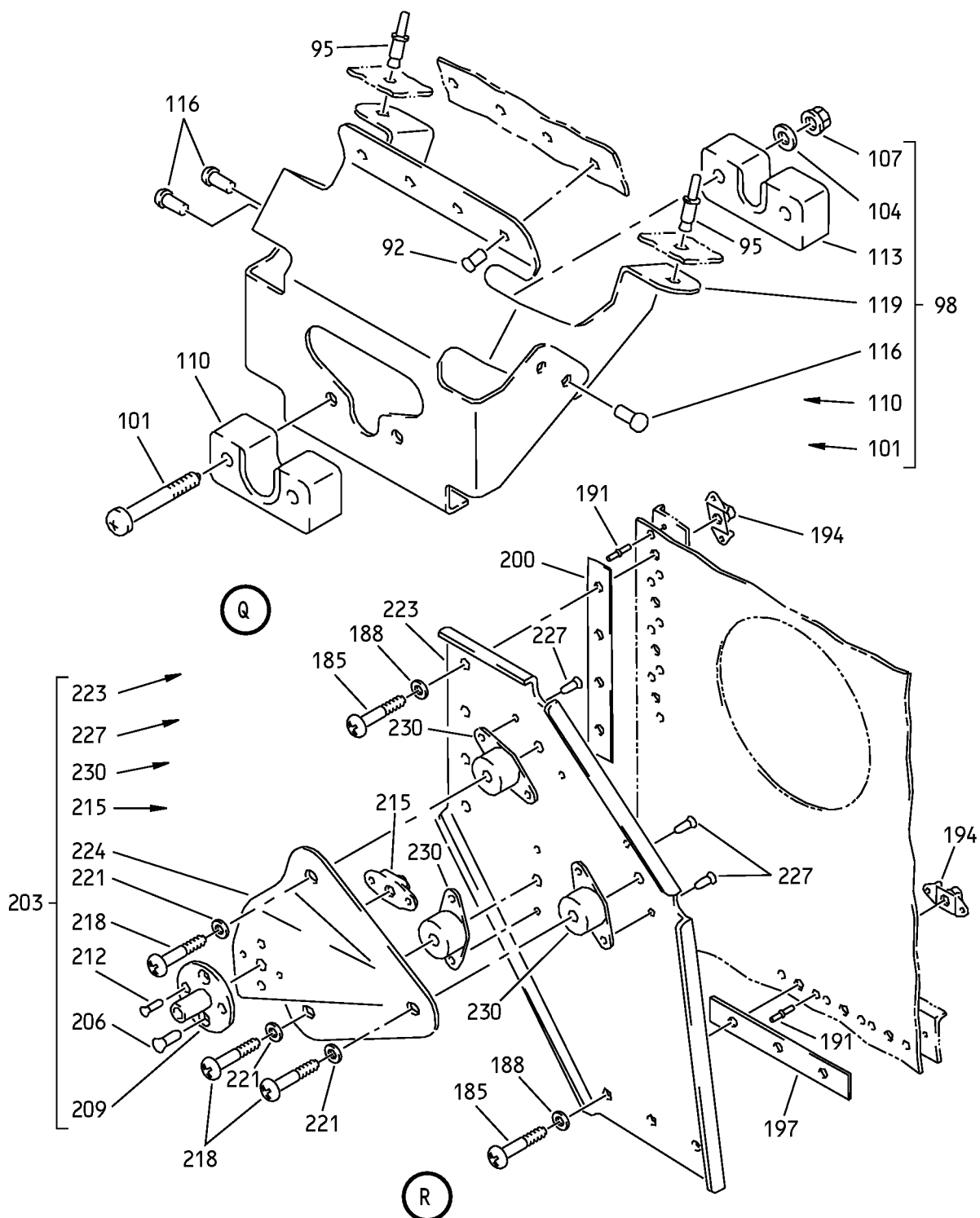
Aft Entry Door Assembly  
IPL Figure 1 (Sheet 6 of 42)

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Aft Entry Door Assembly  
IPL Figure 1 (Sheet 7 of 42)

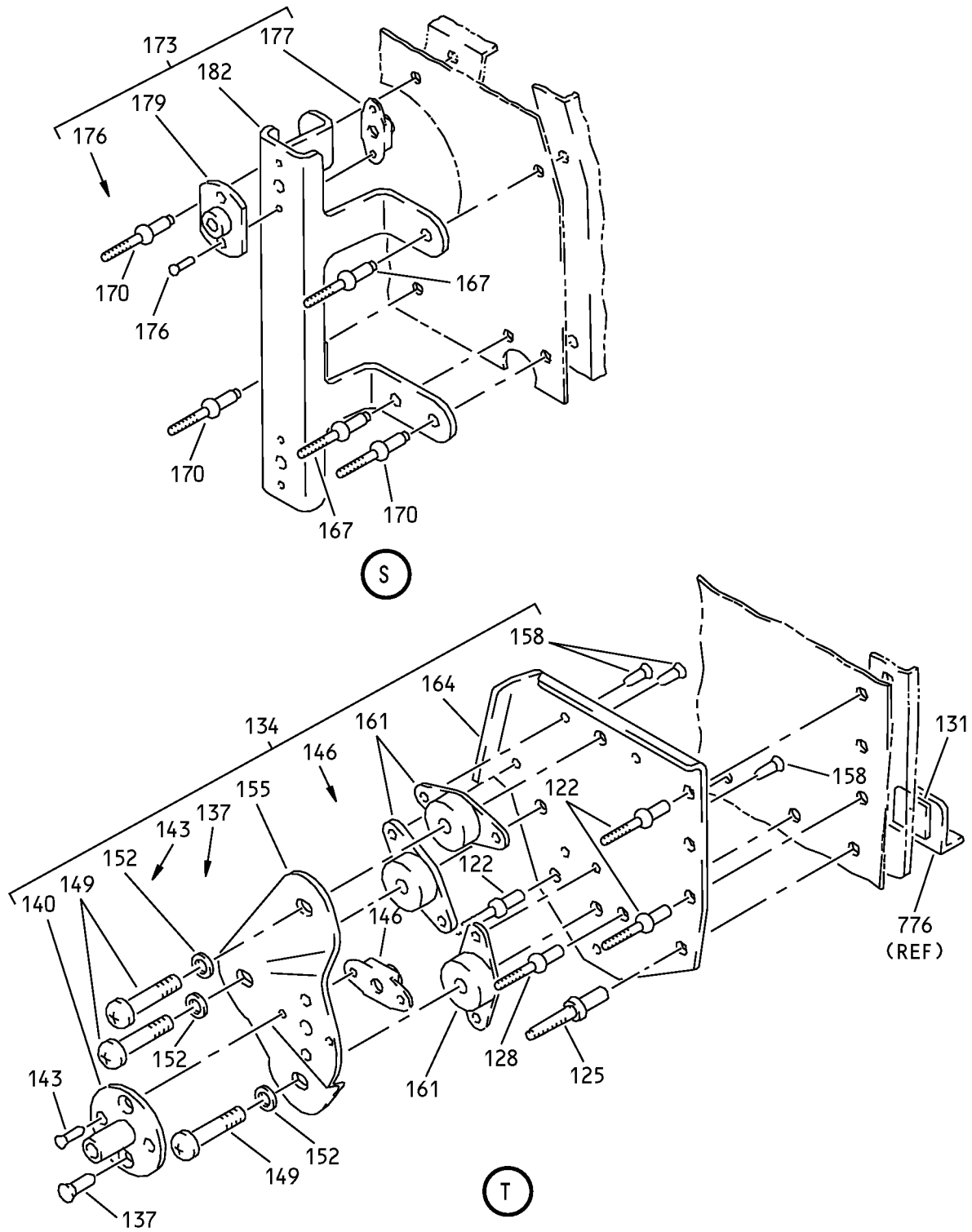
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Aft Entry Door Assembly  
IPL Figure 1 (Sheet 8 of 42)

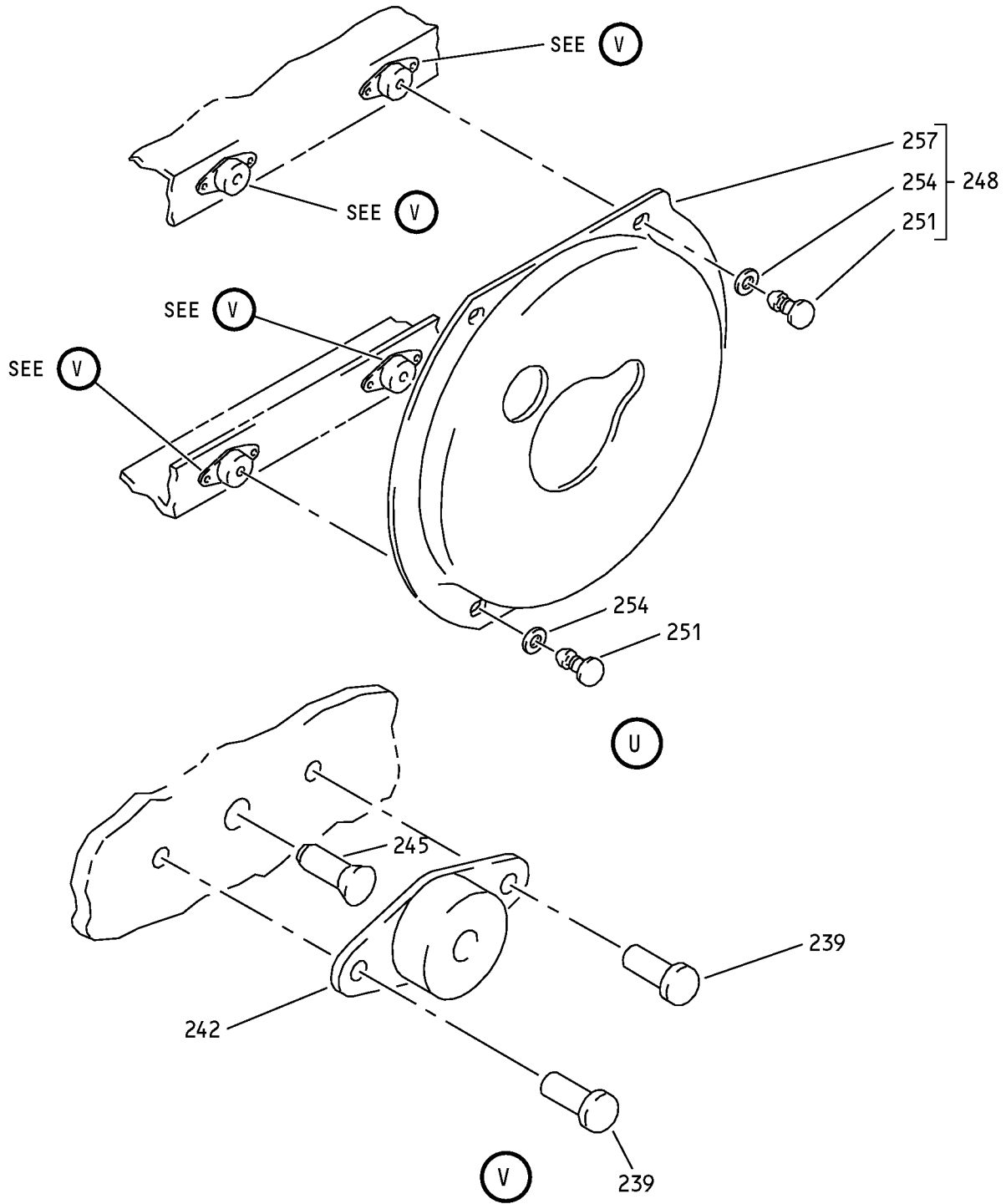


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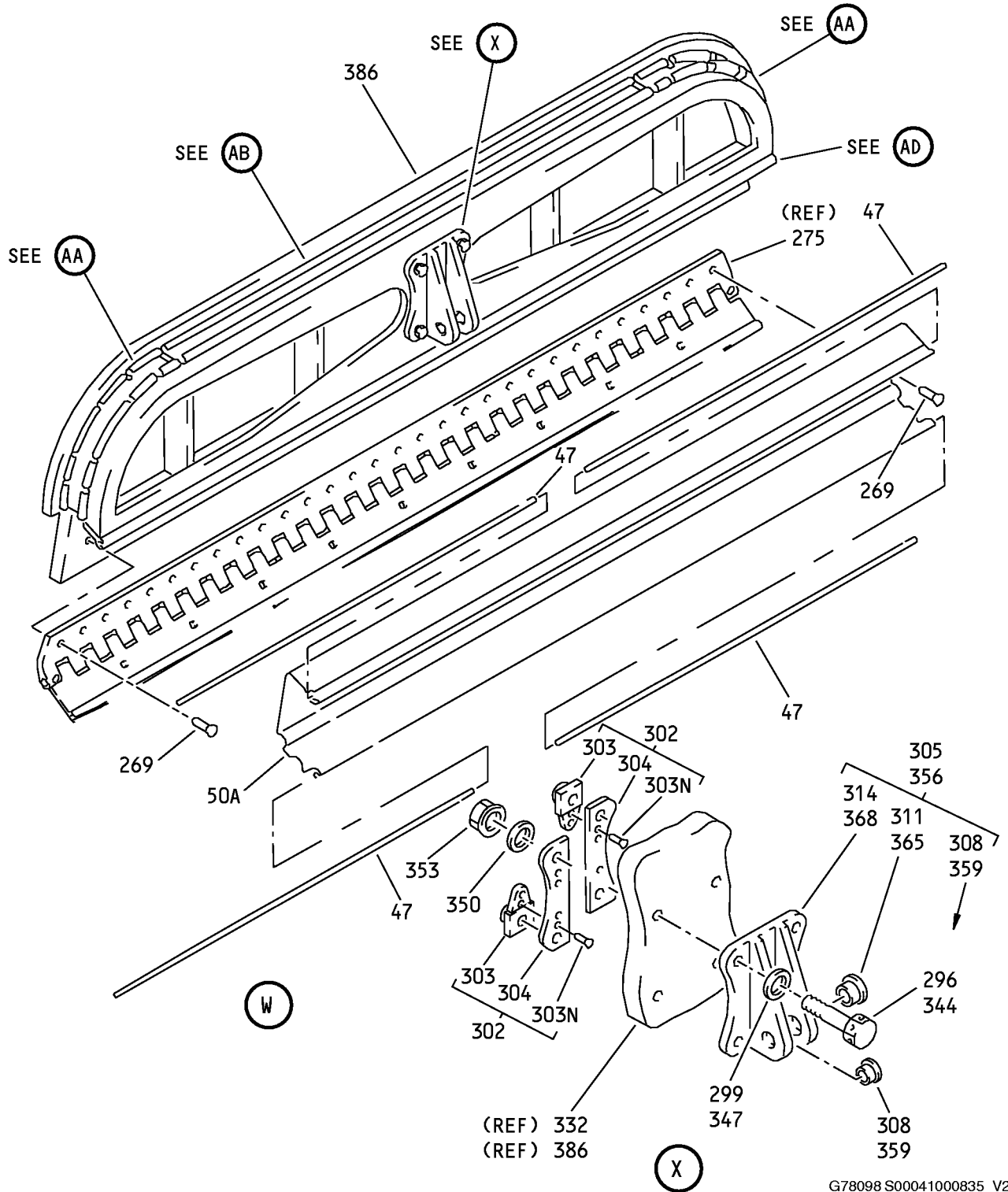
Aft Entry Door Assembly  
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Aft Entry Door Assembly  
IPL Figure 1 (Sheet 10 of 42)

COMPONENT MAINTENANCE MANUAL

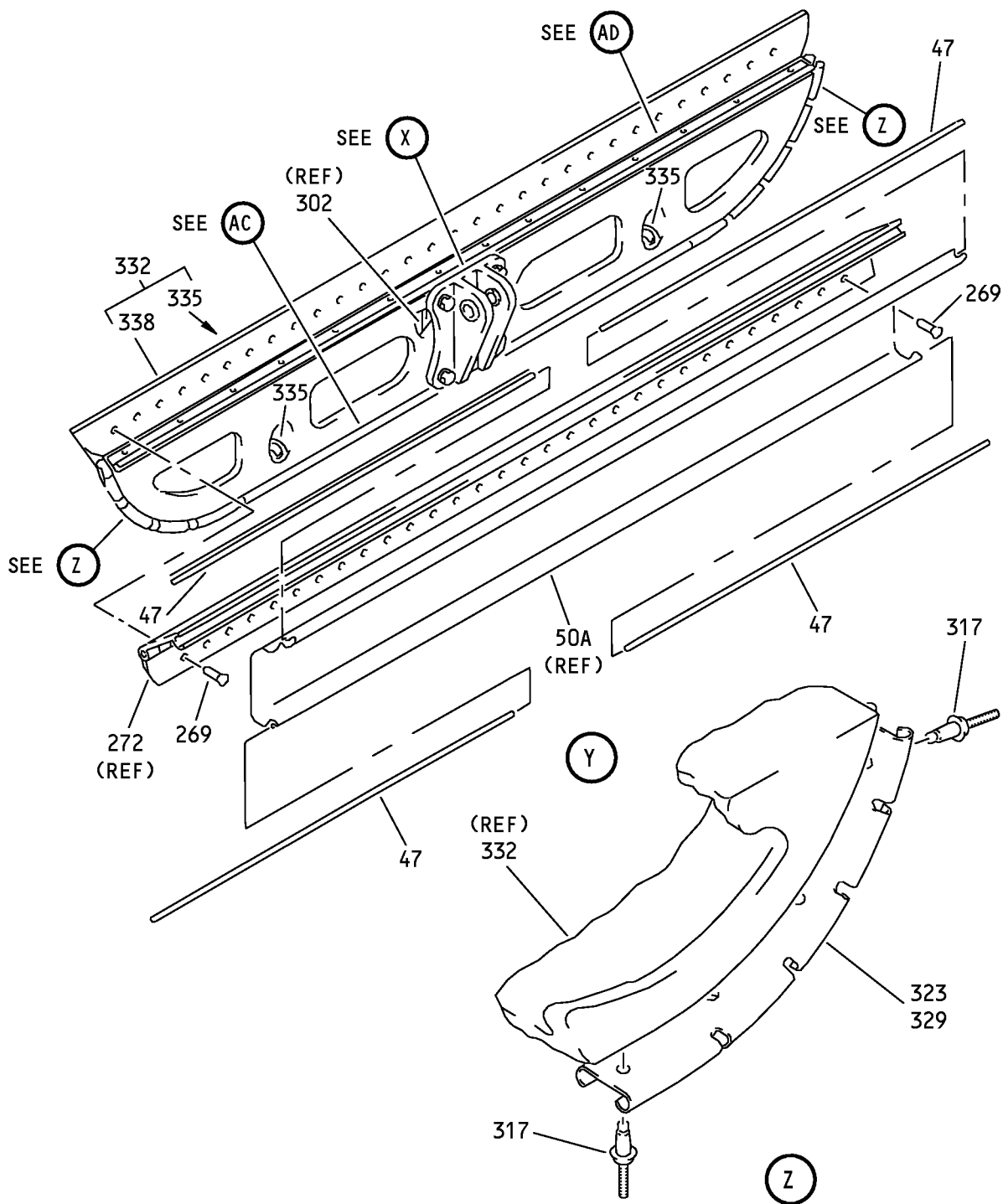


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Aft Entry Door Assembly  
IPL Figure 1 (Sheet 11 of 42)

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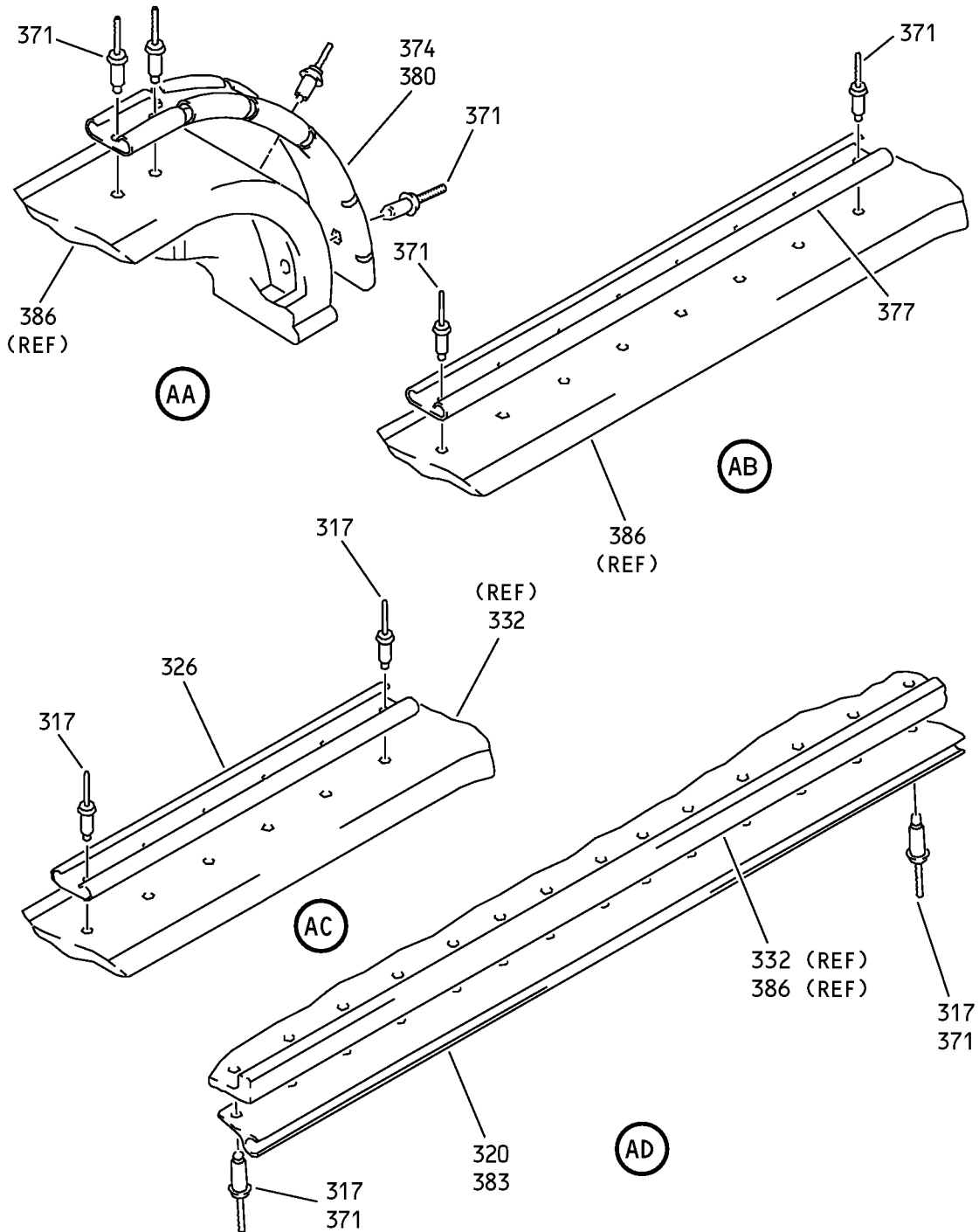


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Aft Entry Door Assembly  
IPL Figure 1 (Sheet 12 of 42)

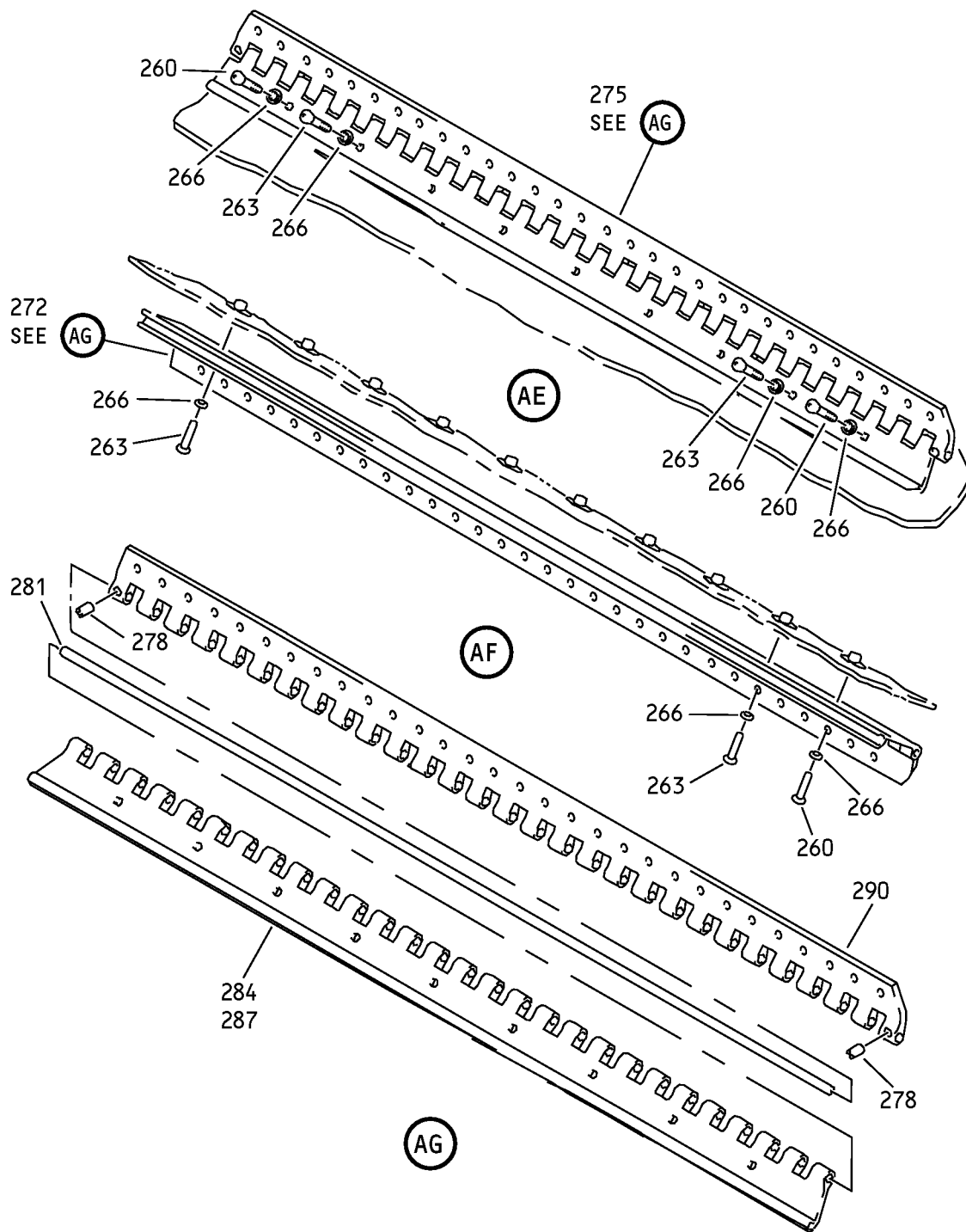
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Aft Entry Door Assembly  
IPL Figure 1 (Sheet 13 of 42)

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Aft Entry Door Assembly  
IPL Figure 1 (Sheet 14 of 42)

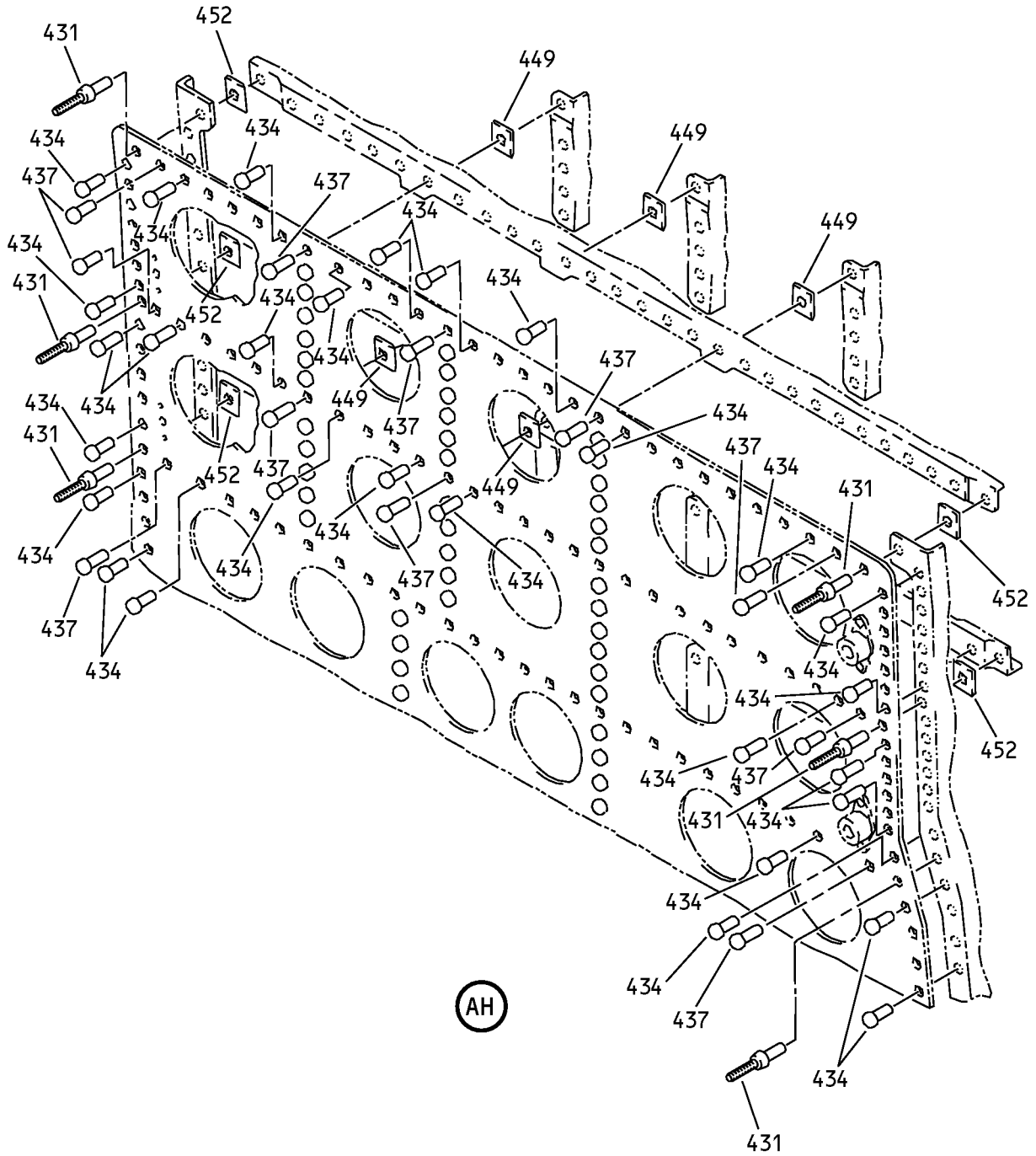
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Aft Entry Door Assembly  
IPL Figure 1 (Sheet 15 of 42)

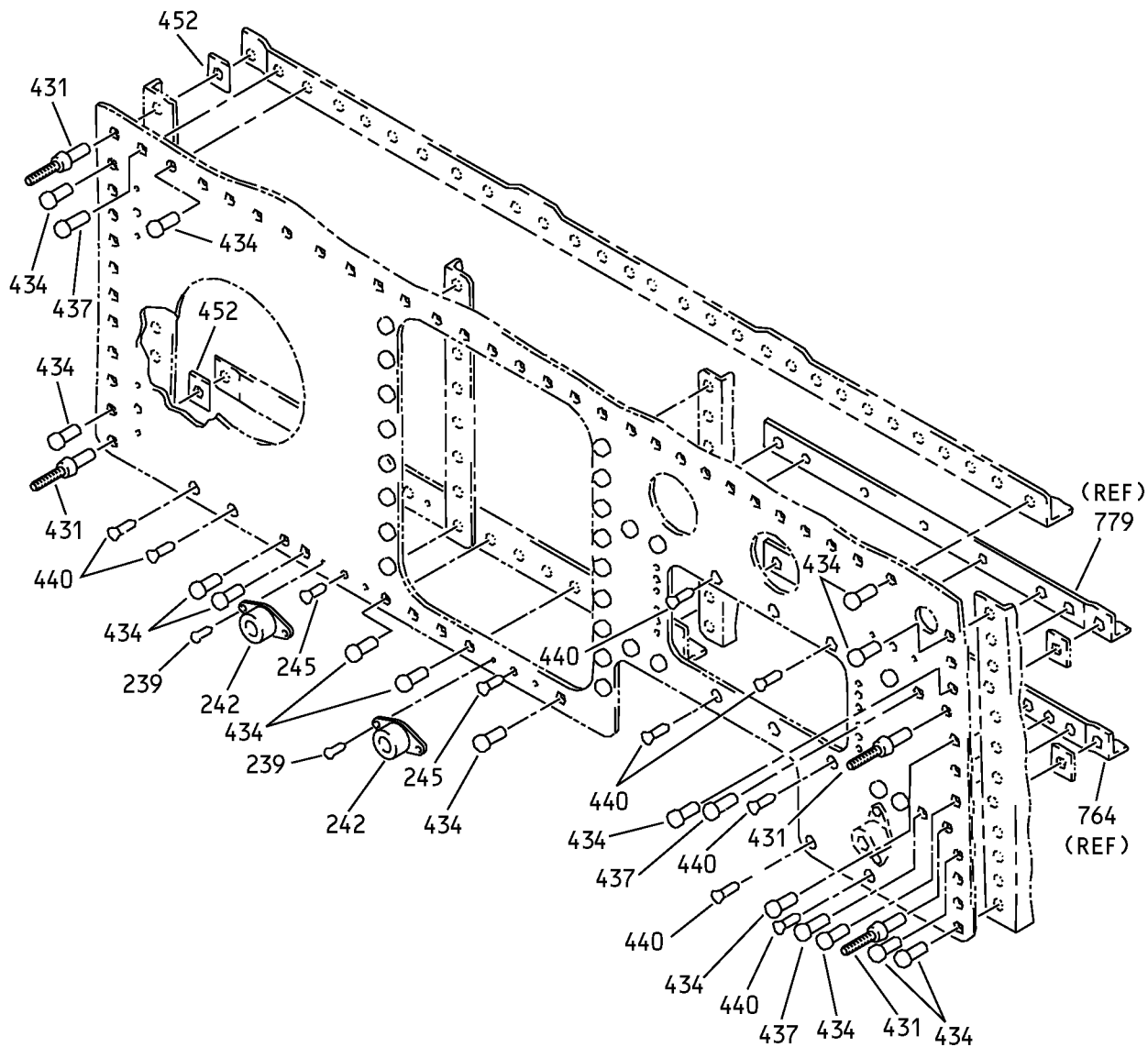
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Aft Entry Door Assembly  
IPL Figure 1 (Sheet 16 of 42)

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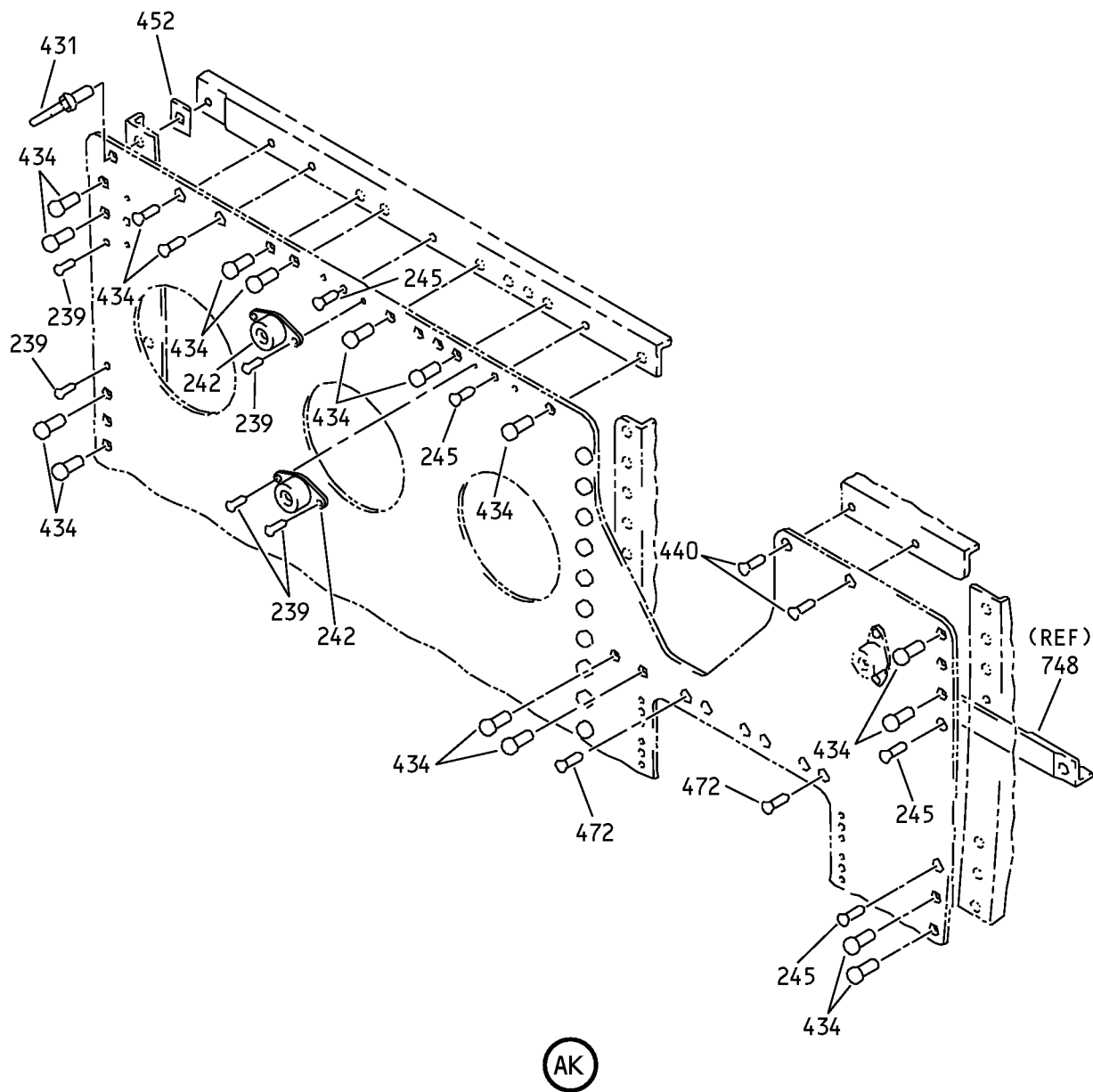
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Aft Entry Door Assembly  
IPL Figure 1 (Sheet 17 of 42)

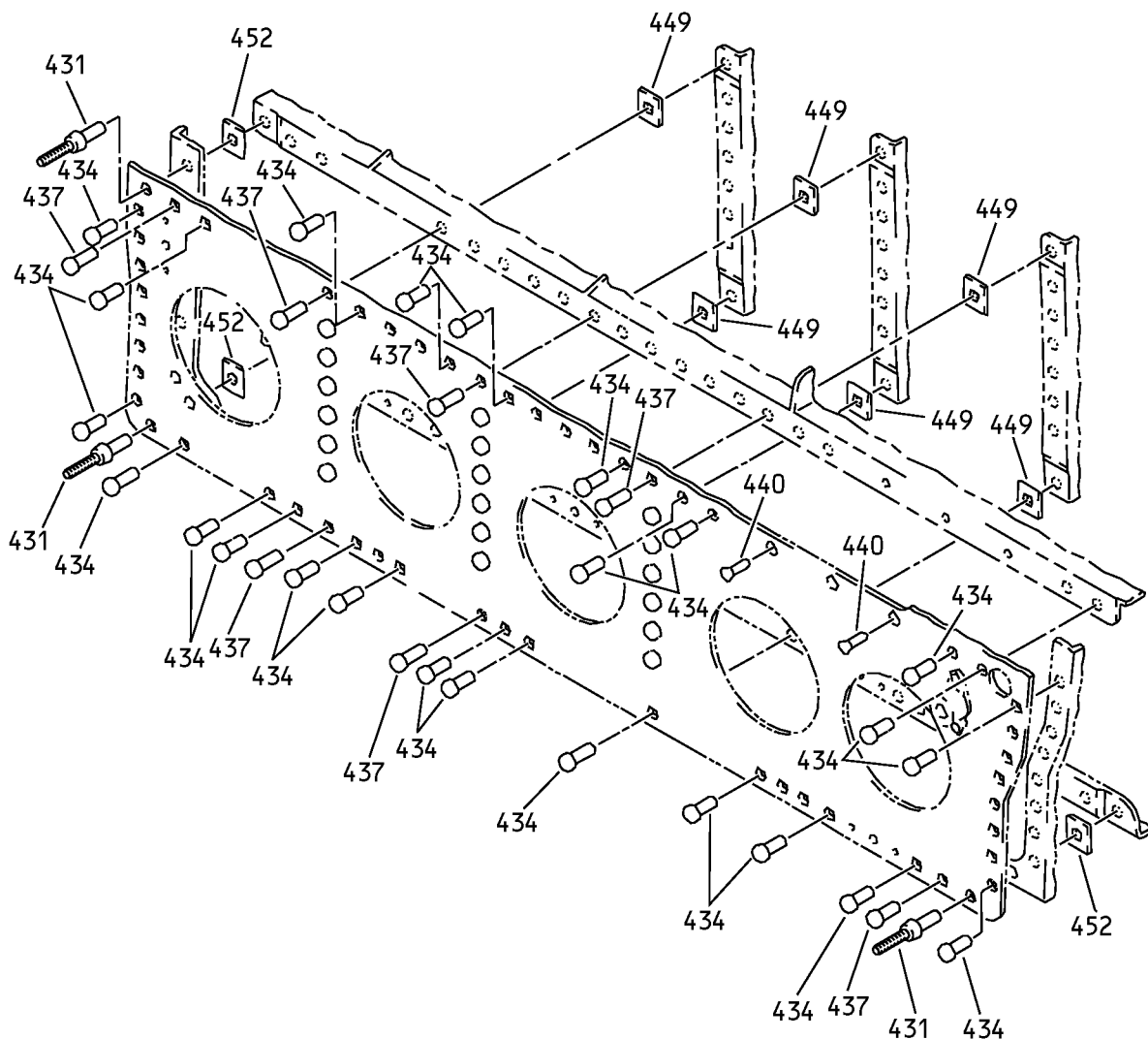
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Aft Entry Door Assembly  
IPL Figure 1 (Sheet 18 of 42)

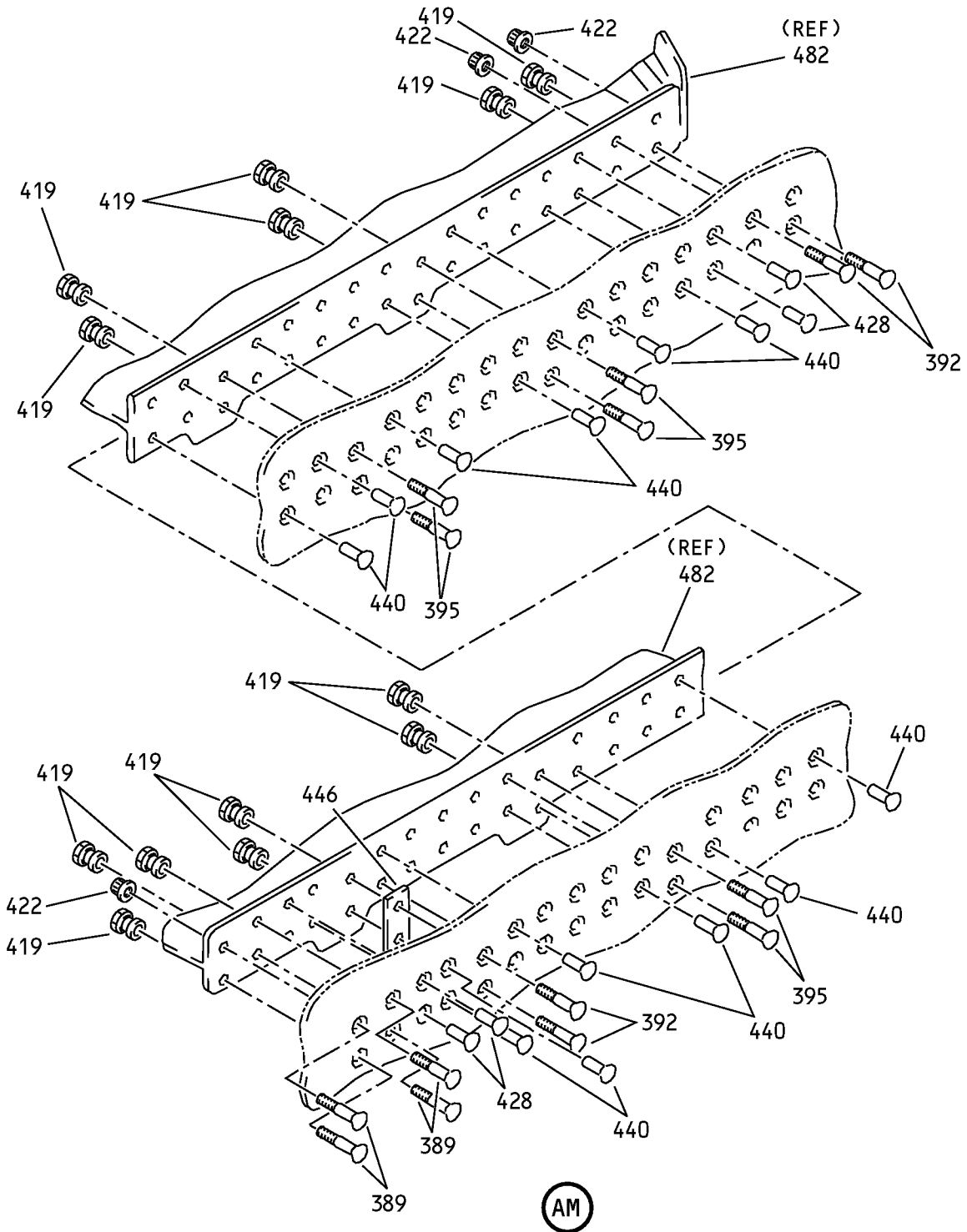
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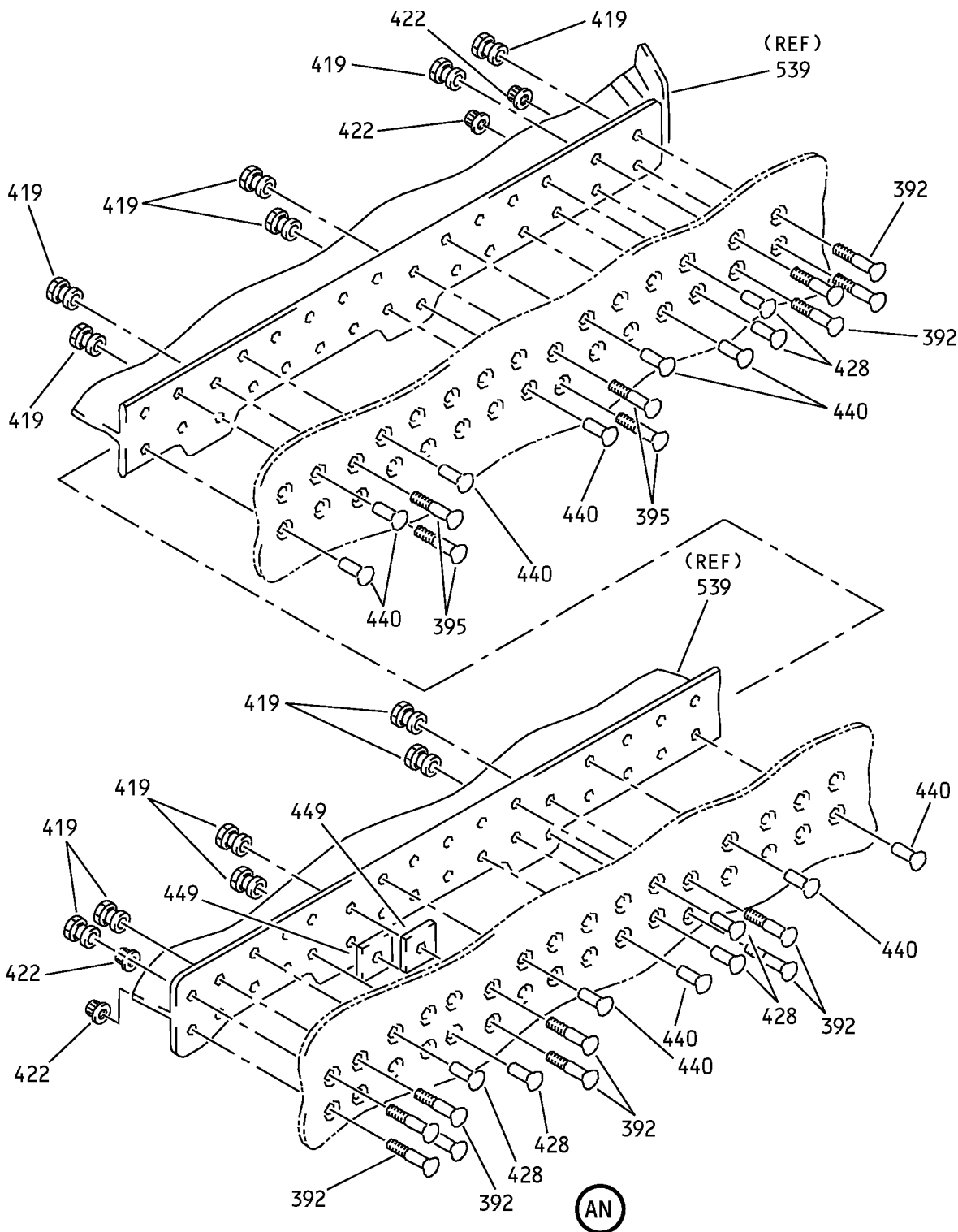
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Aft Entry Door Assembly  
IPL Figure 1 (Sheet 19 of 42)

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Aft Entry Door Assembly  
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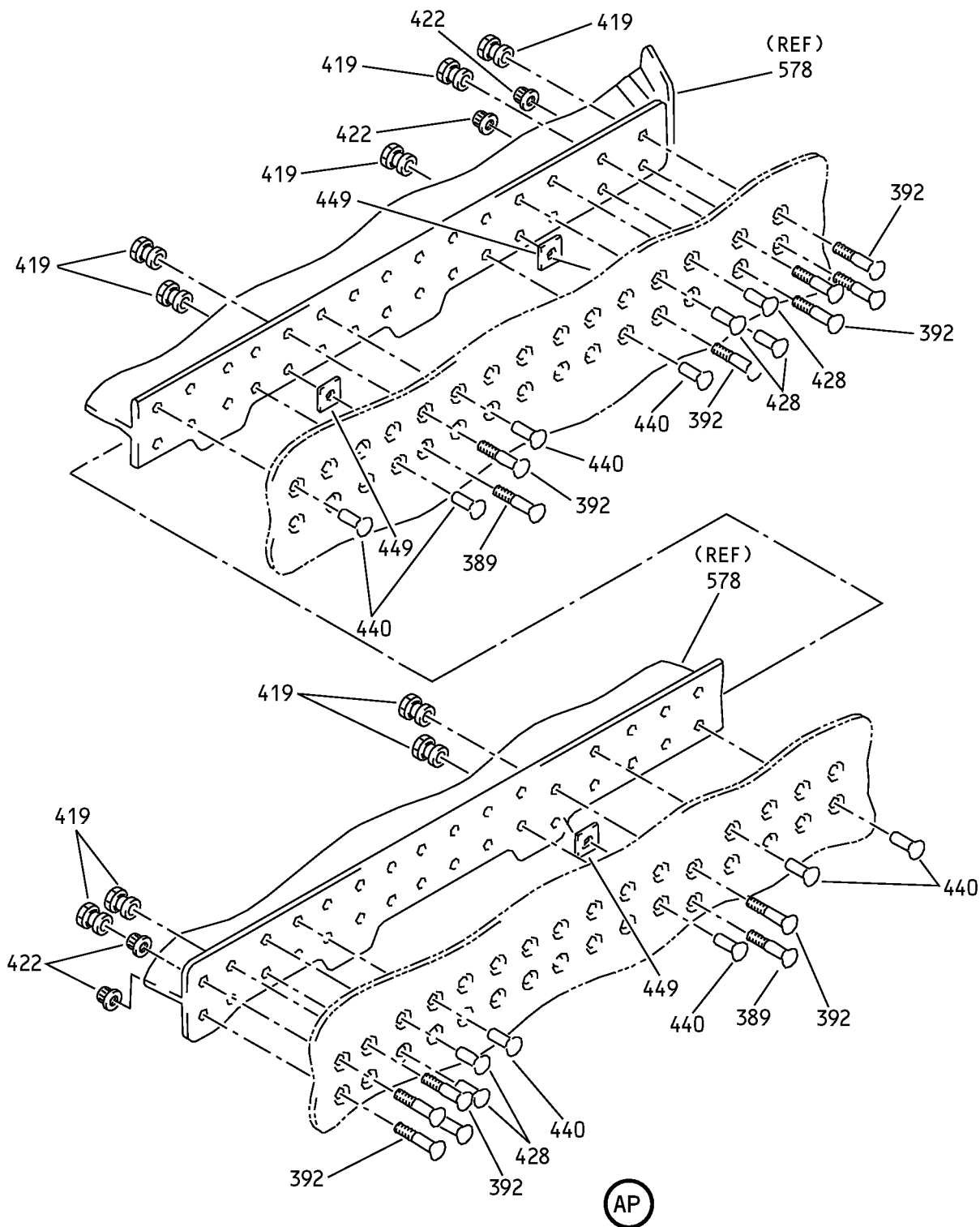
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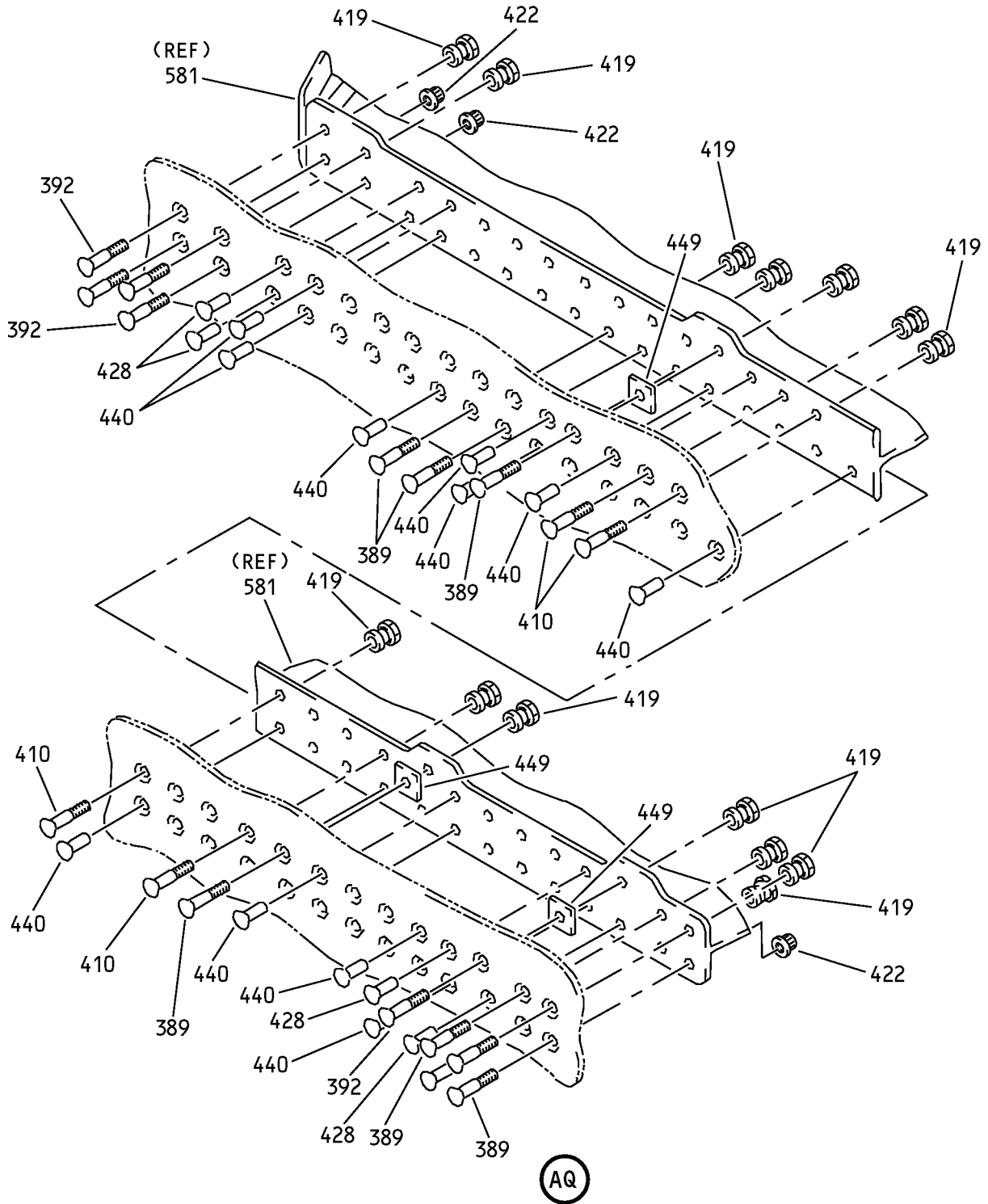
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Aft Entry Door Assembly  
IPL Figure 1 (Sheet 21 of 42)

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Aft Entry Door Assembly  
IPL Figure 1 (Sheet 22 of 42)

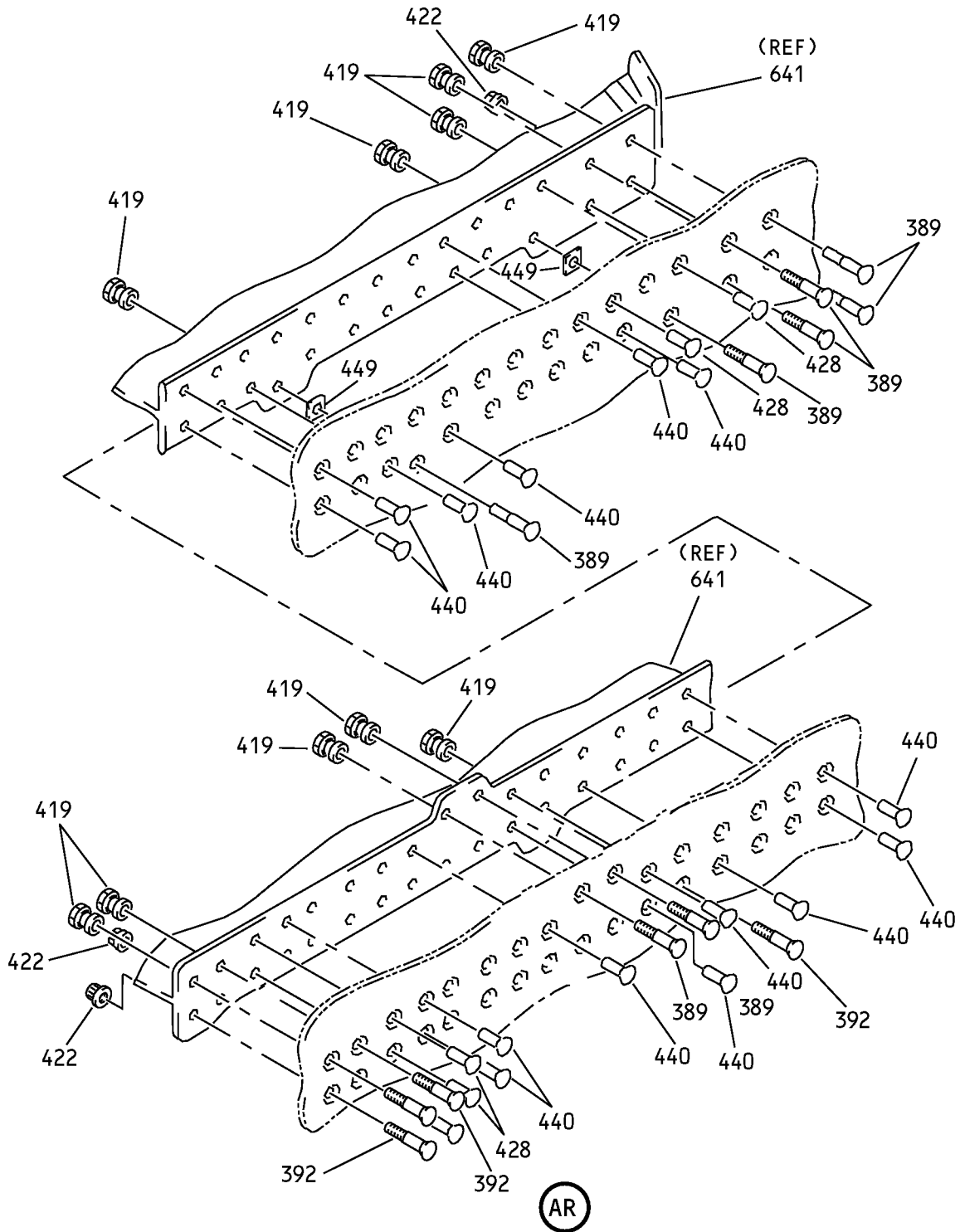
**52-16-15**

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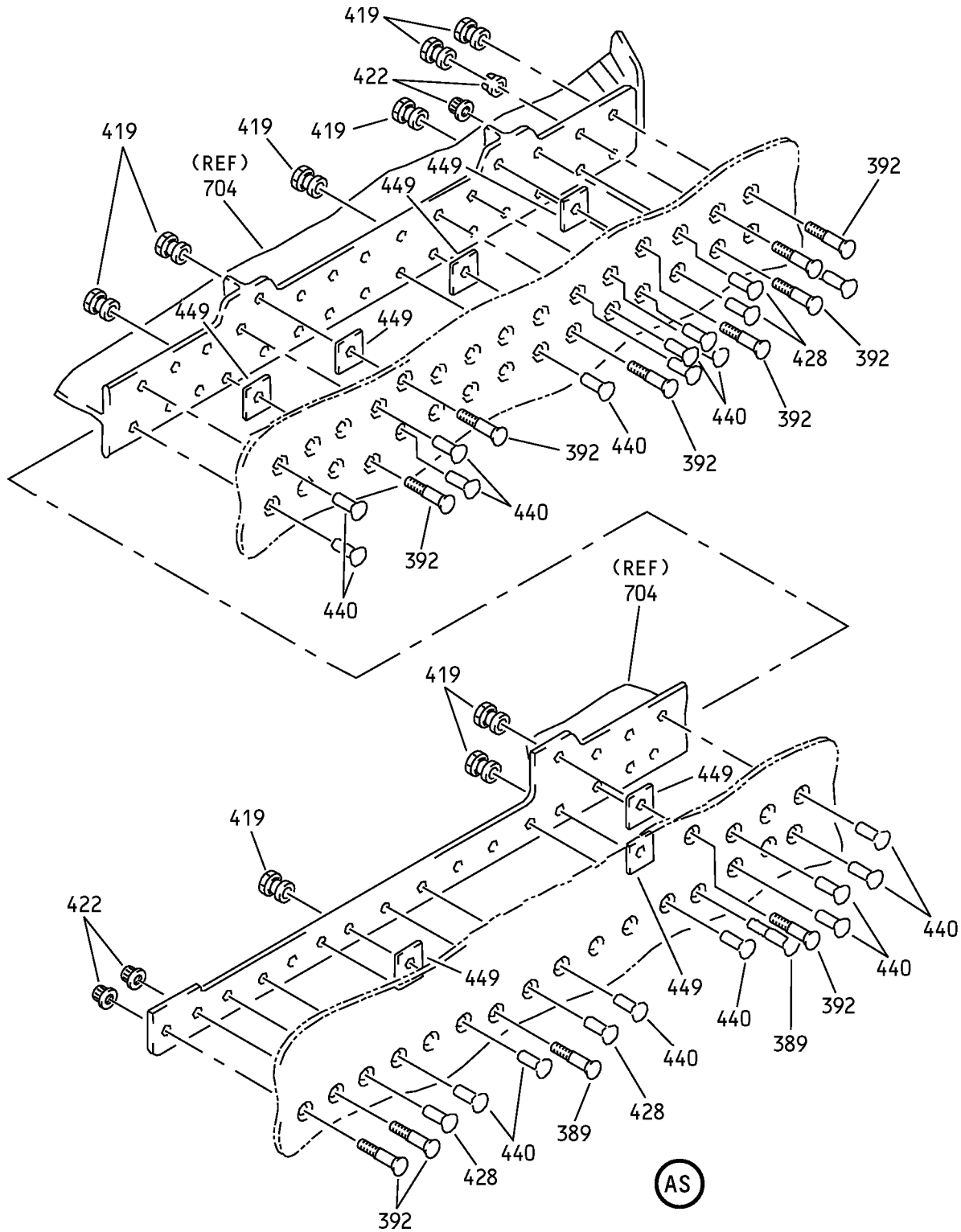
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Aft Entry Door Assembly  
IPL Figure 1 (Sheet 23 of 42)

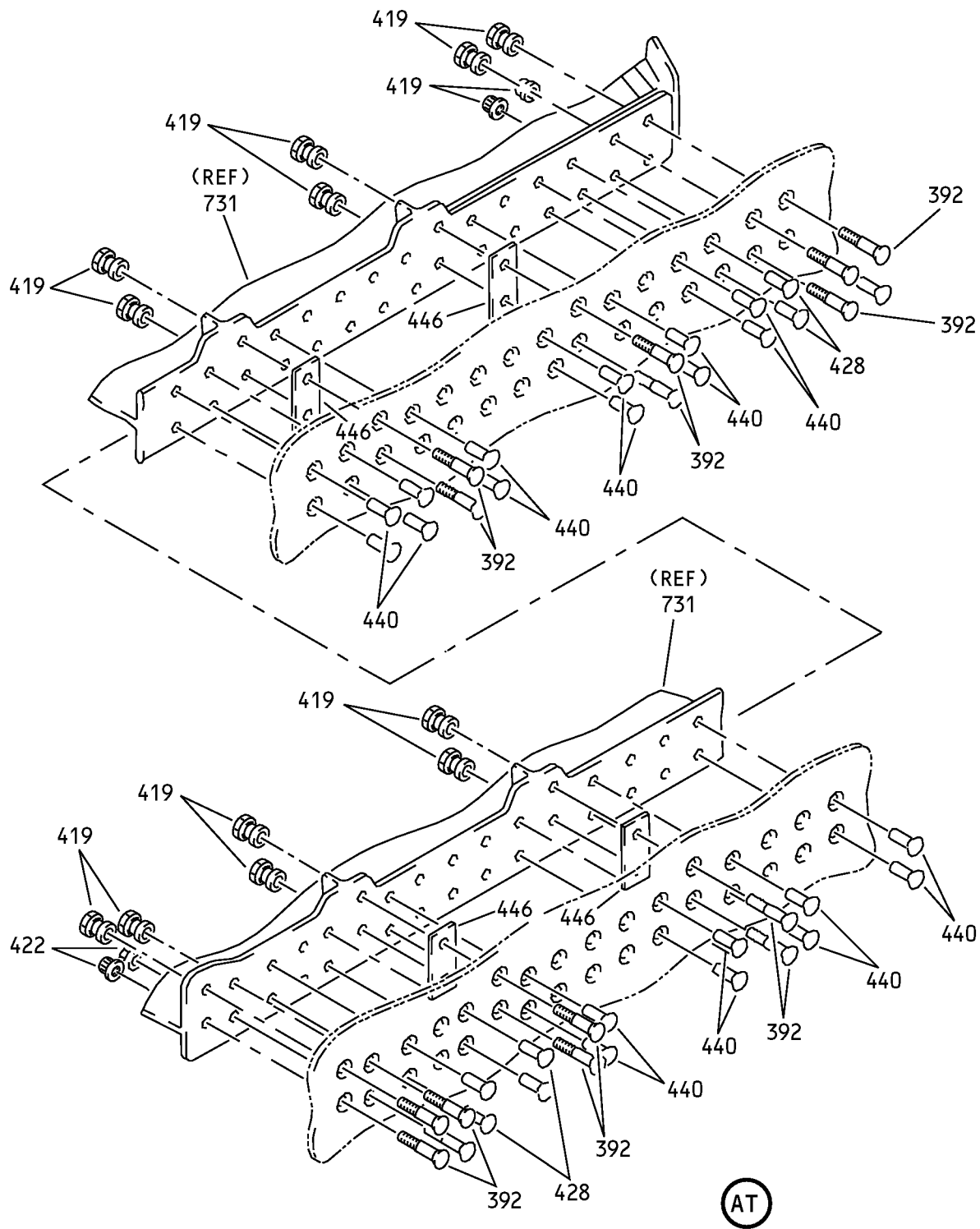
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Aft Entry Door Assembly  
IPL Figure 1 (Sheet 24 of 42)



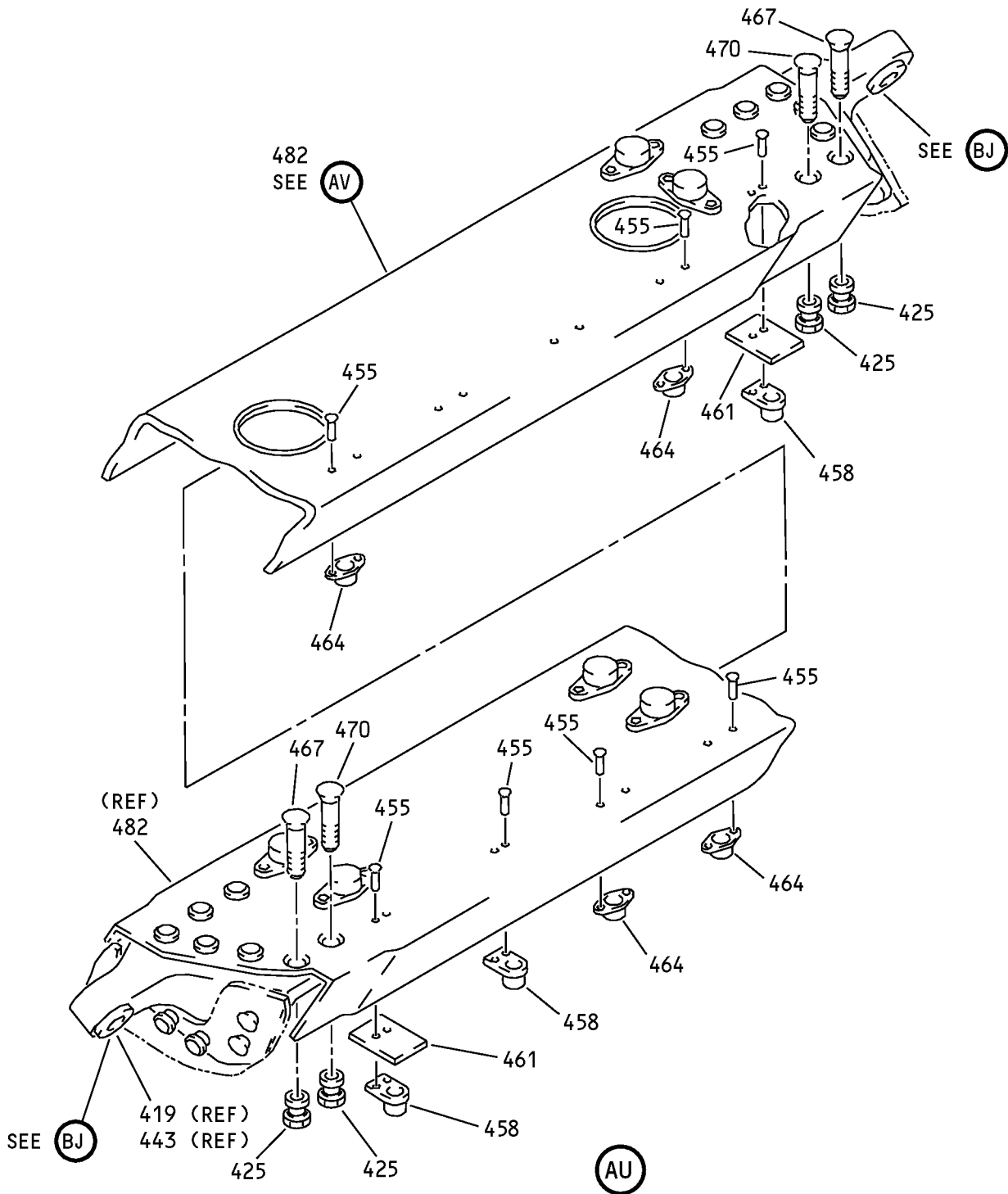
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Aft Entry Door Assembly  
IPL Figure 1 (Sheet 25 of 42)

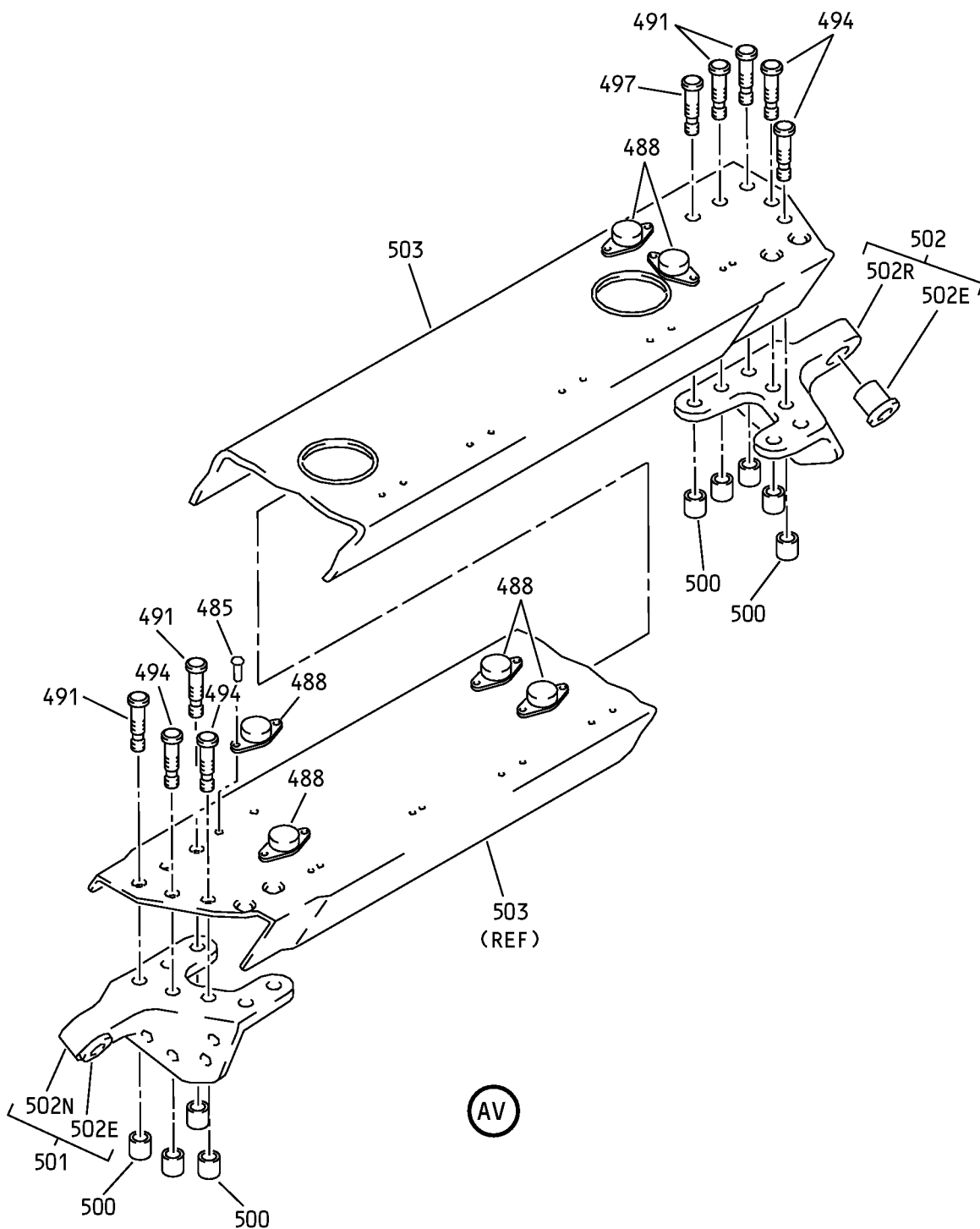
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Aft Entry Door Assembly  
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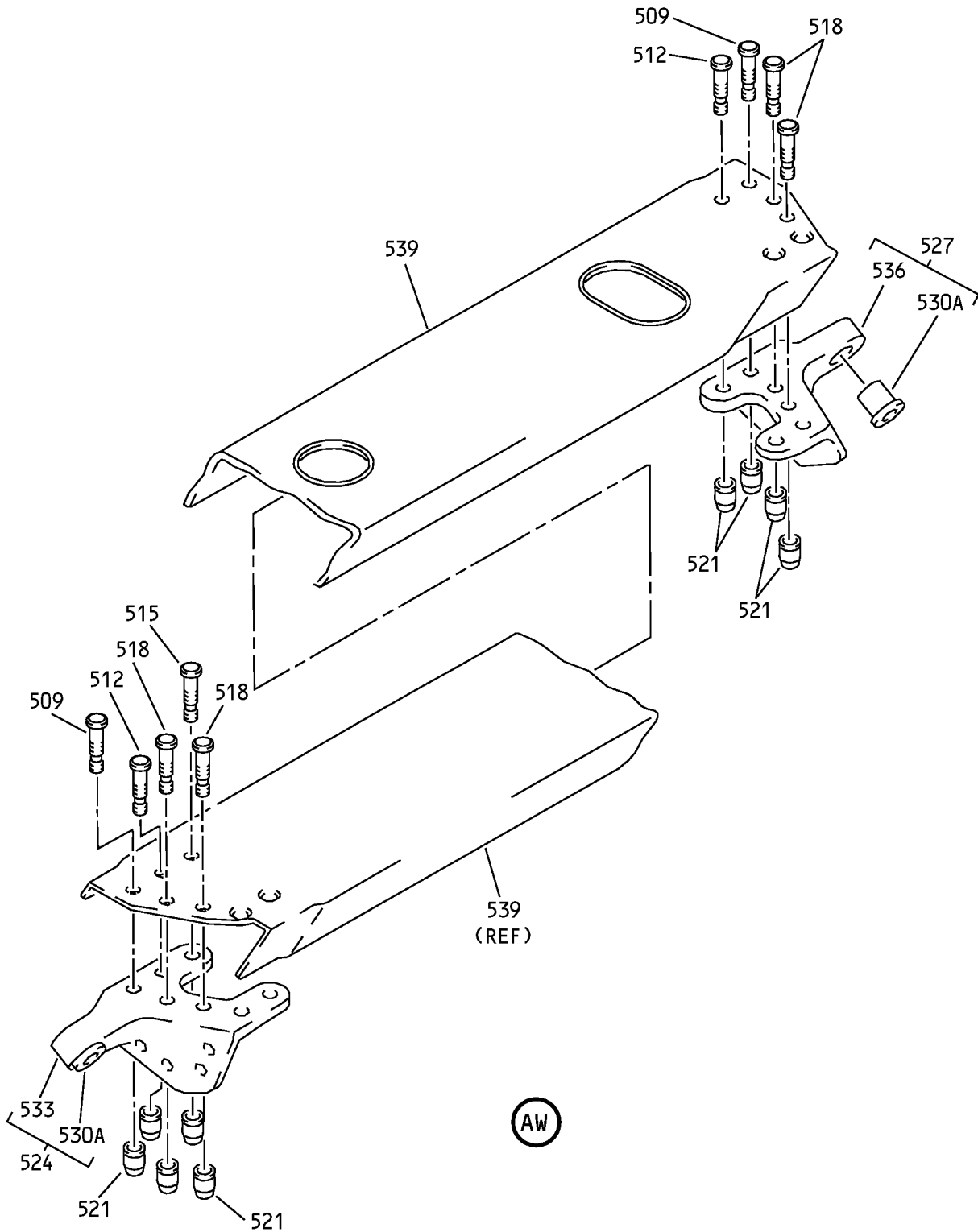
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Aft Entry Door Assembly  
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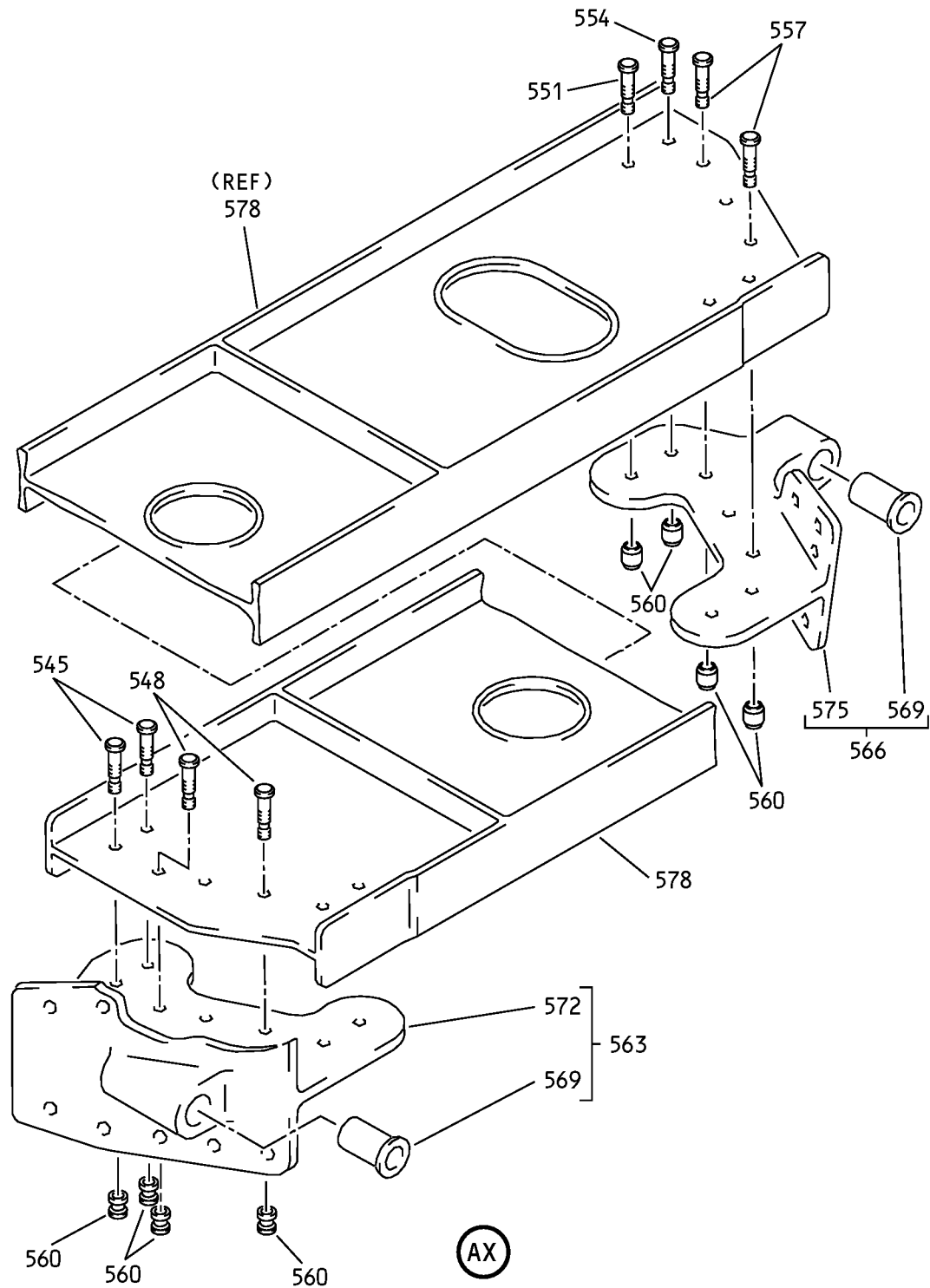
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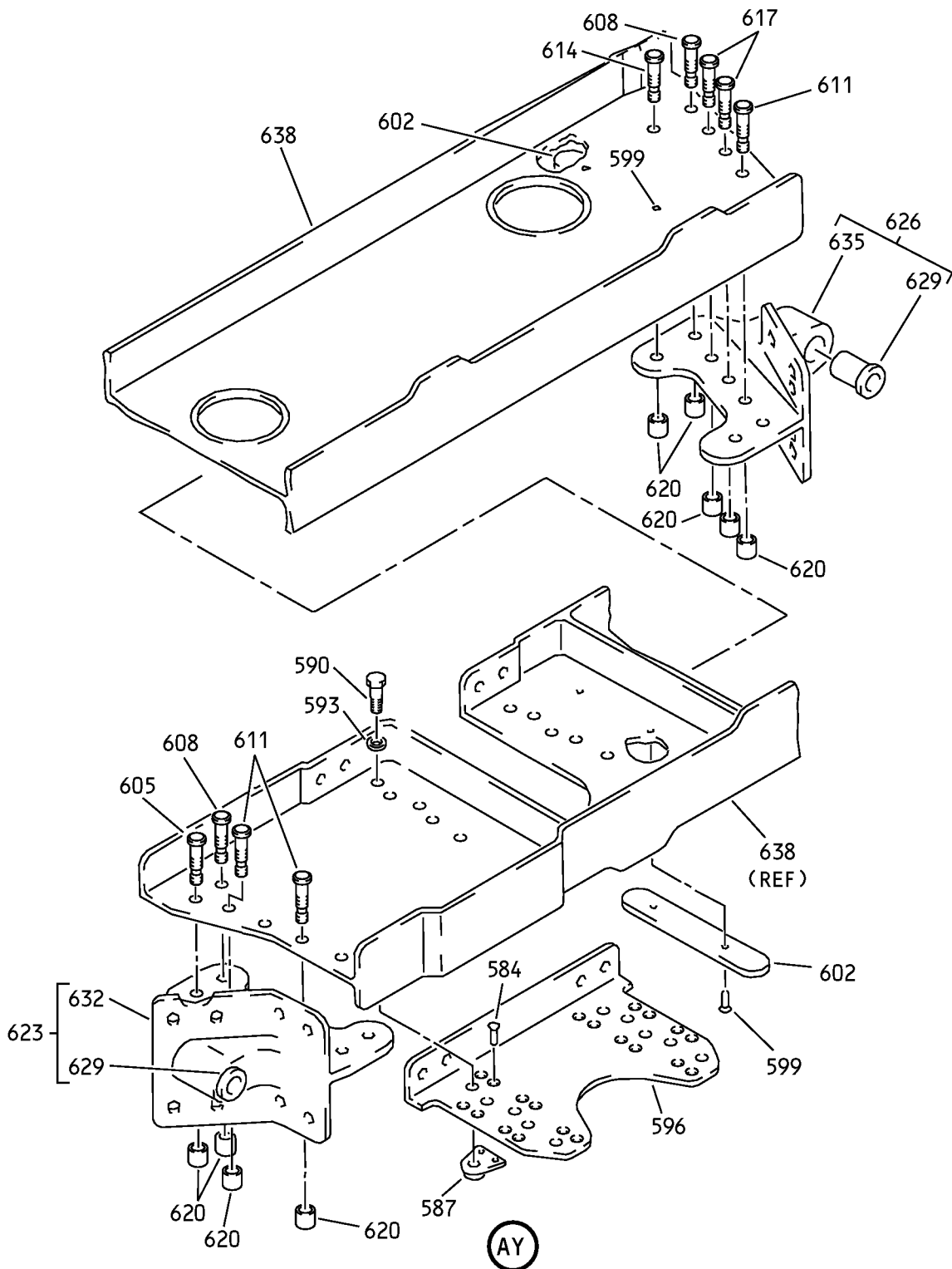
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Aft Entry Door Assembly  
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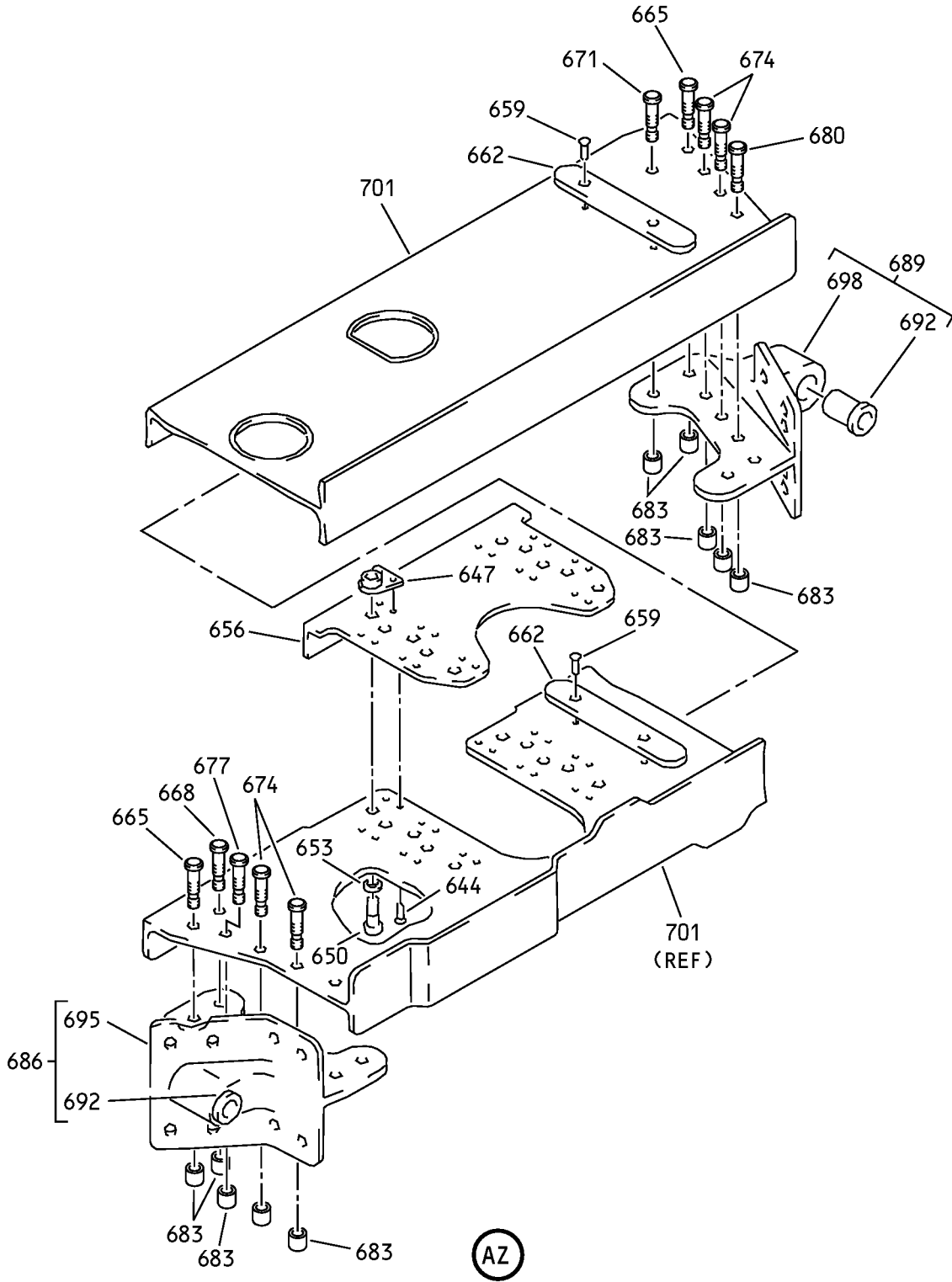
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Aft Entry Door Assembly  
IPL Figure 1 (Sheet 31 of 42)

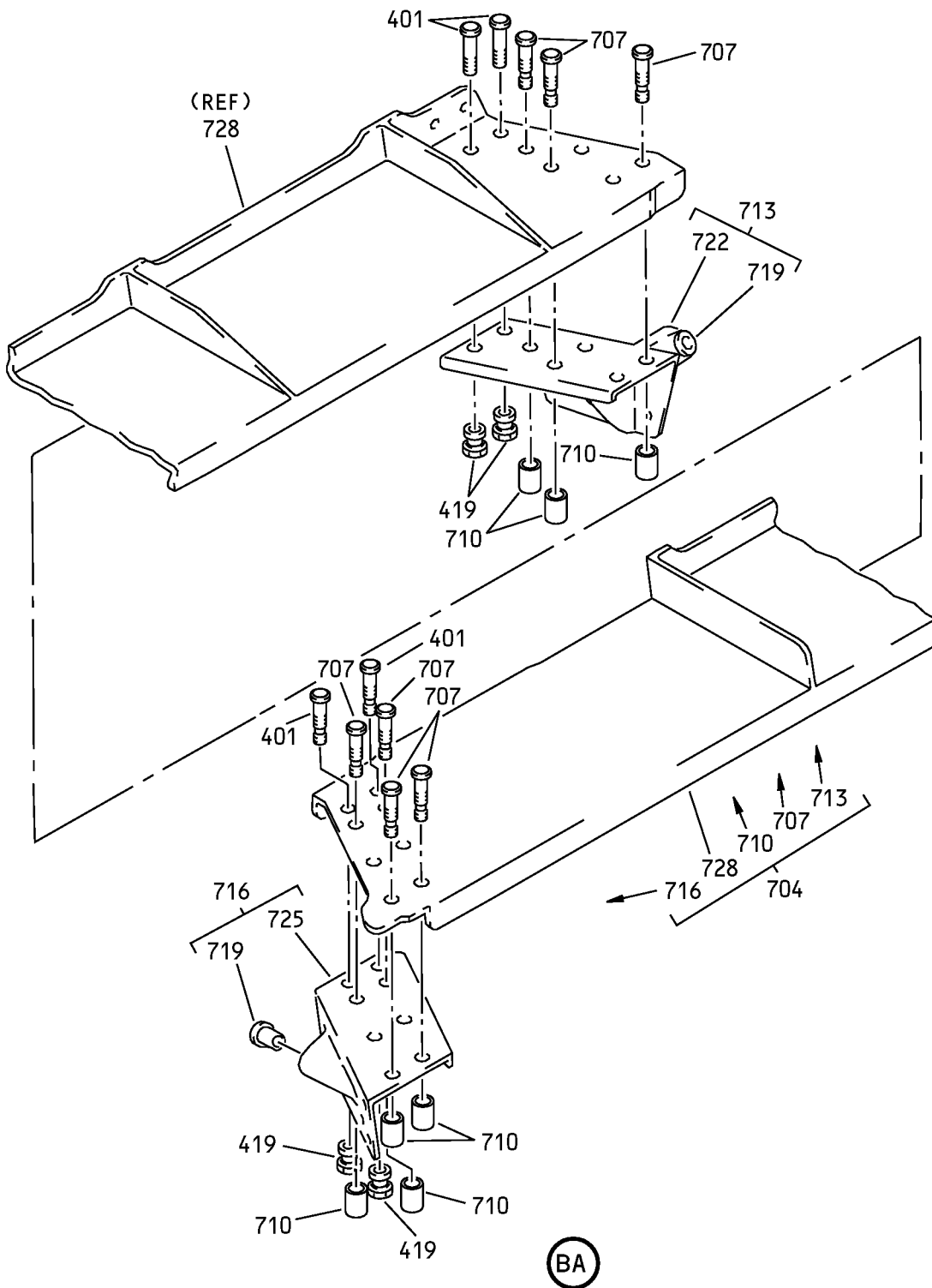
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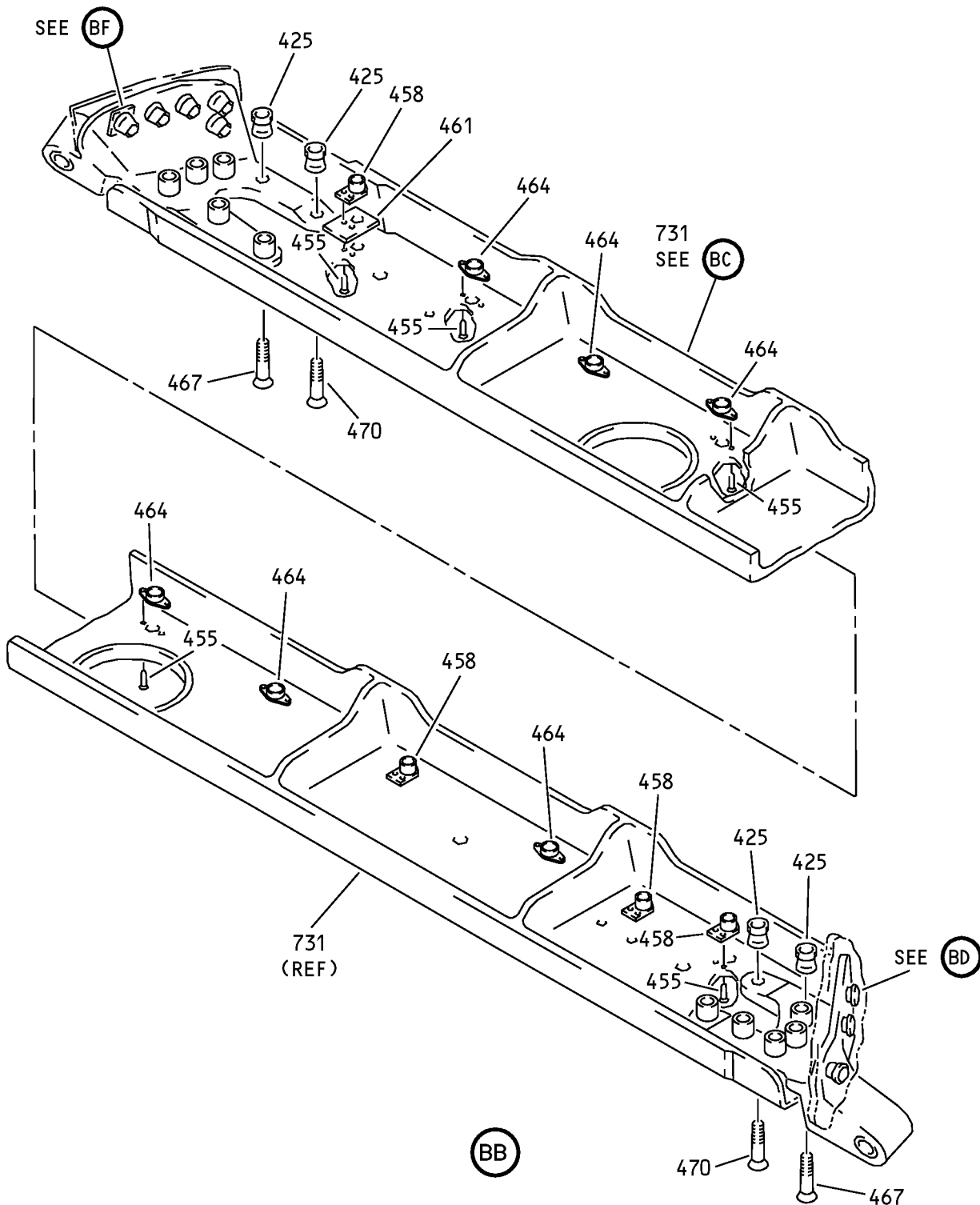
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Aft Entry Door Assembly  
IPL Figure 1 (Sheet 32 of 42)

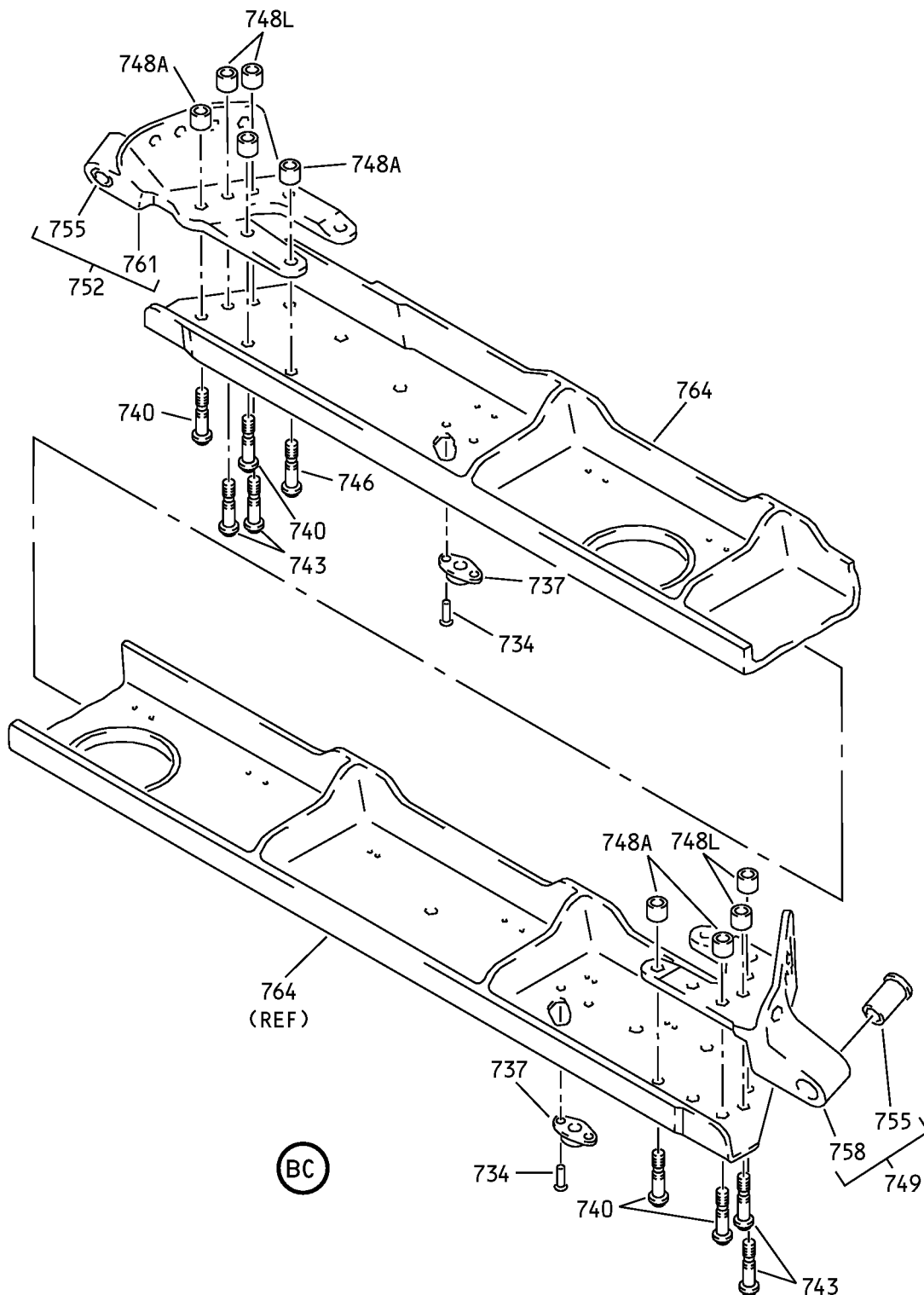


COMPONENT MAINTENANCE MANUAL



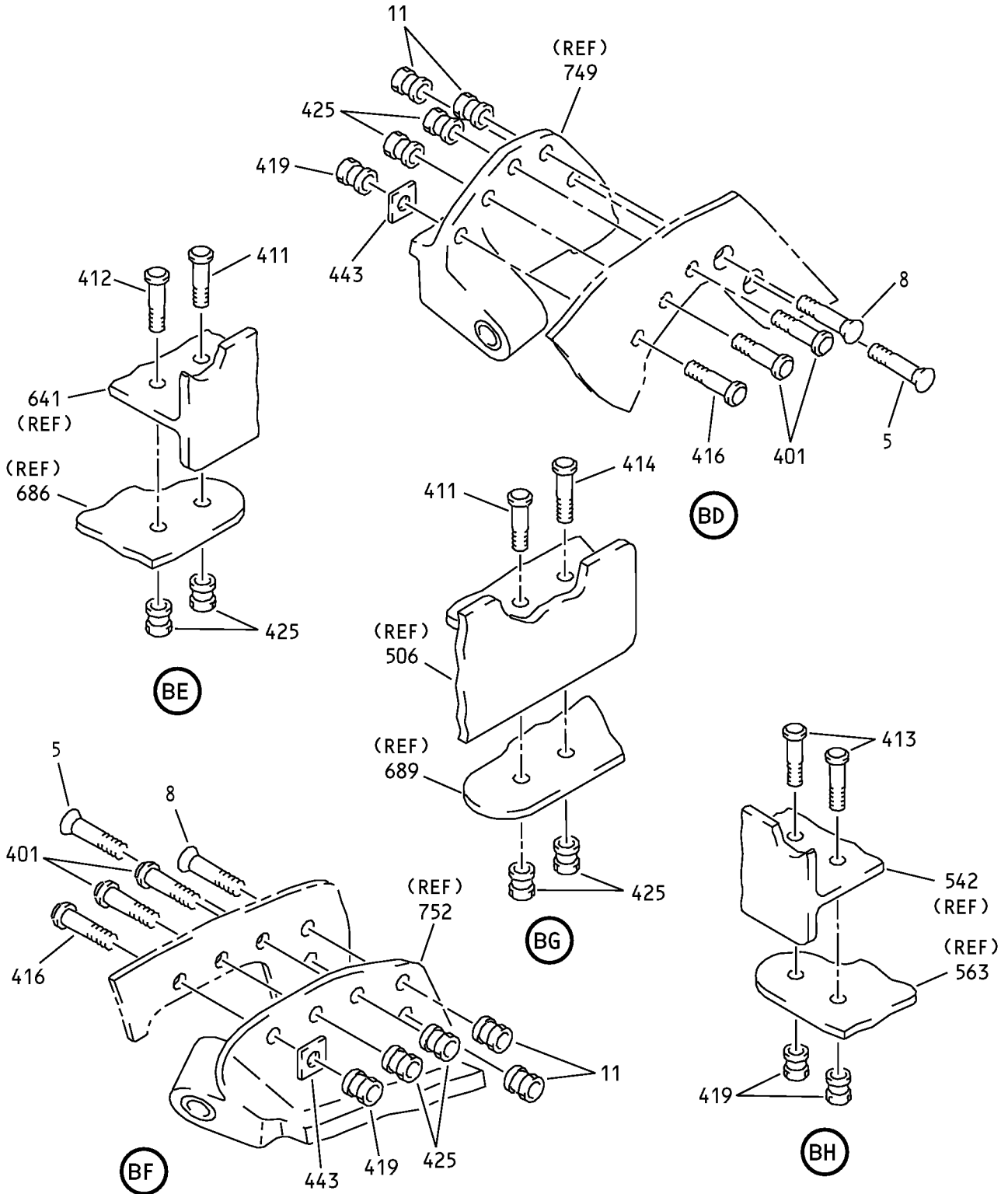
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Aft Entry Door Assembly  
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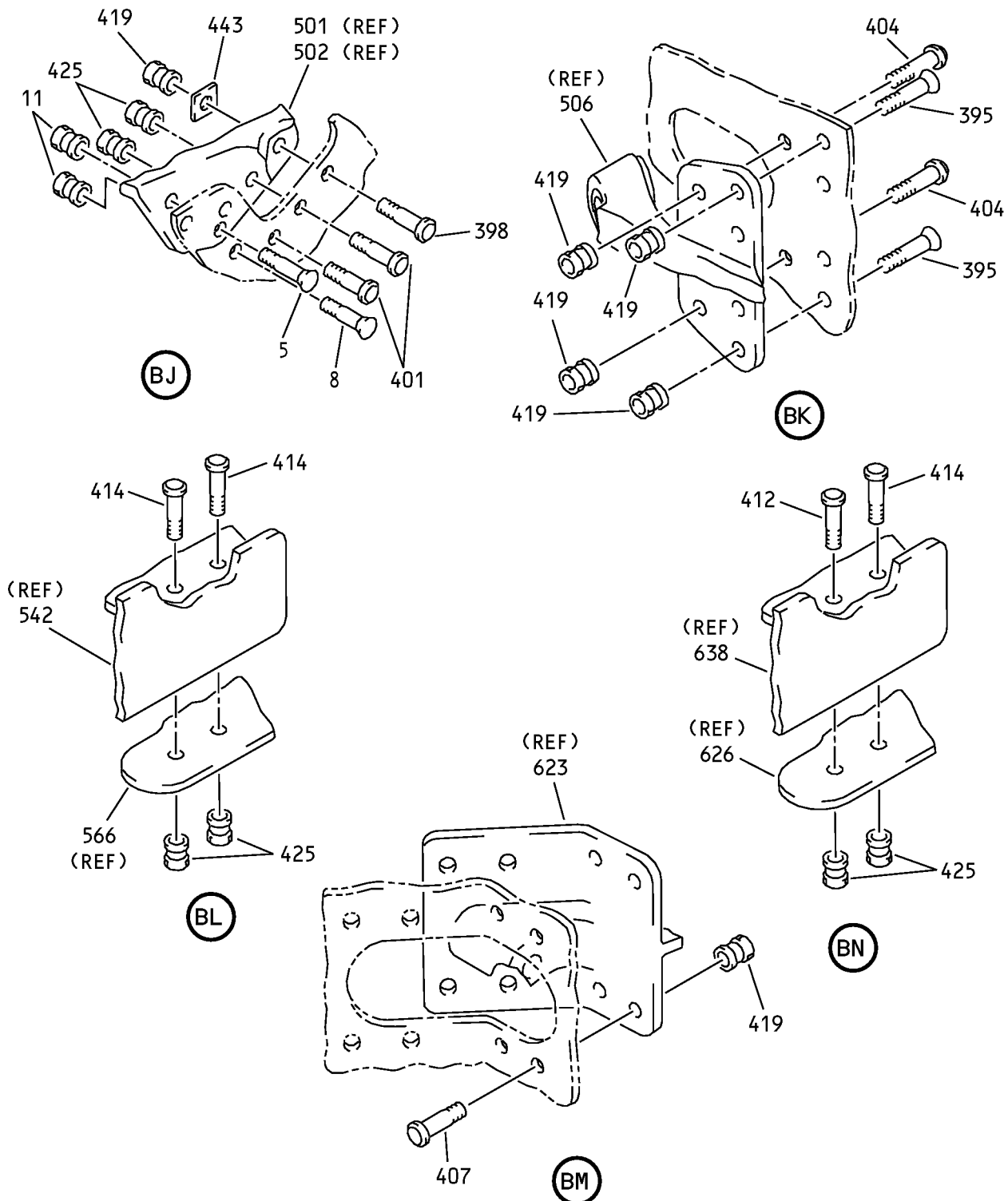
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Aft Entry Door Assembly  
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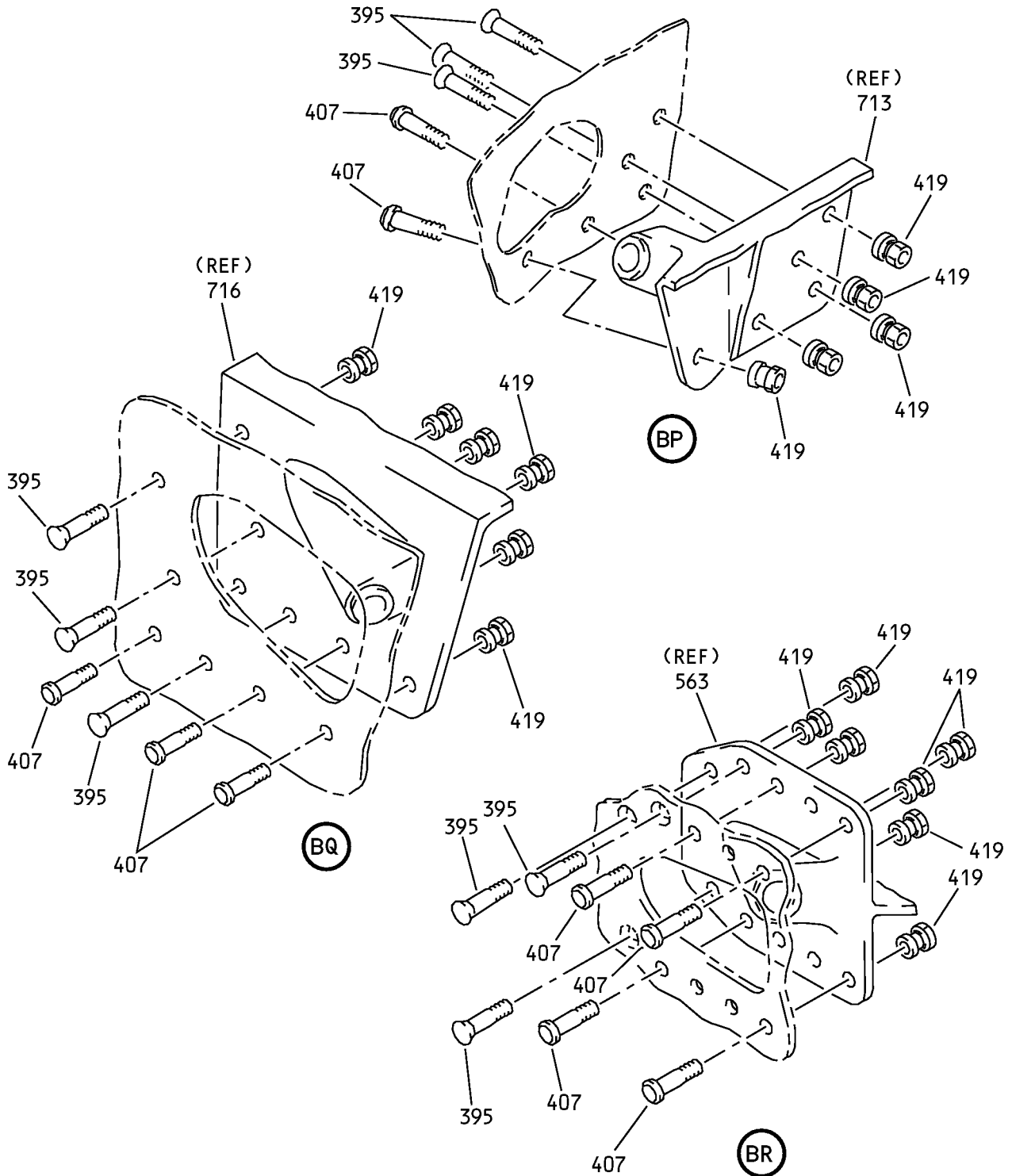
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Aft Entry Door Assembly  
IPL Figure 1 (Sheet 37 of 42)

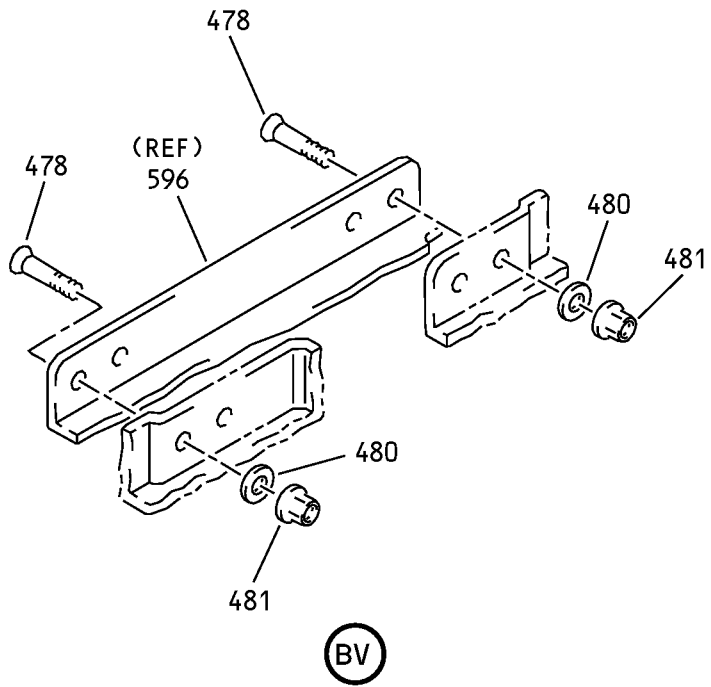
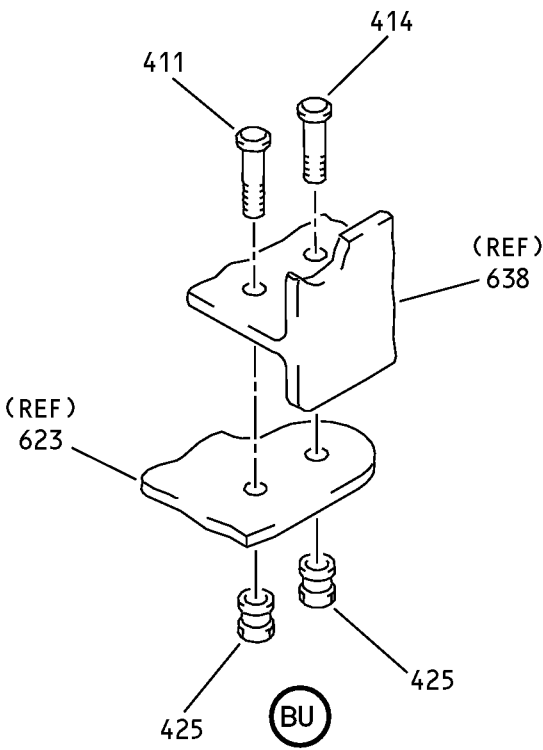
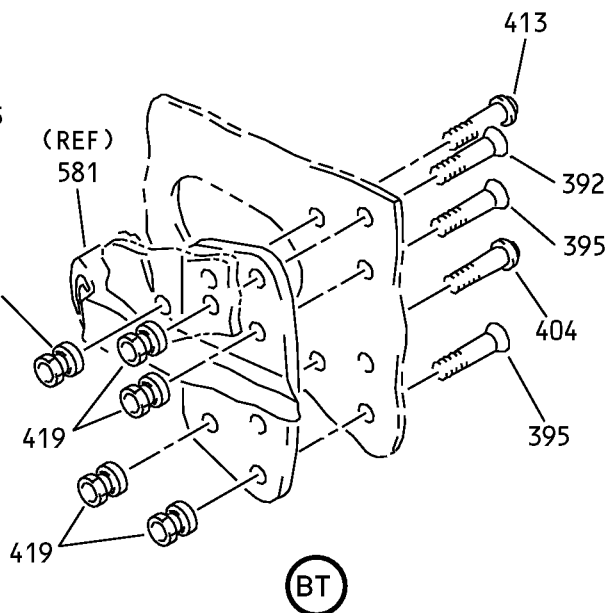
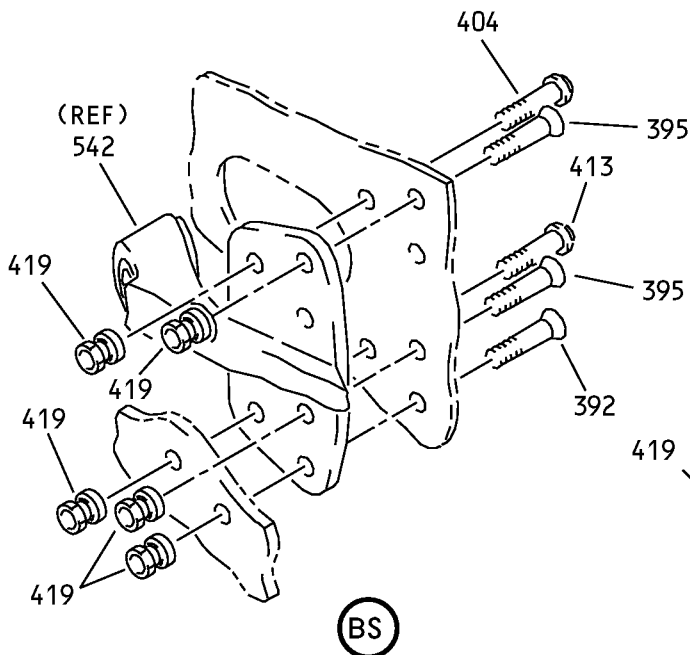
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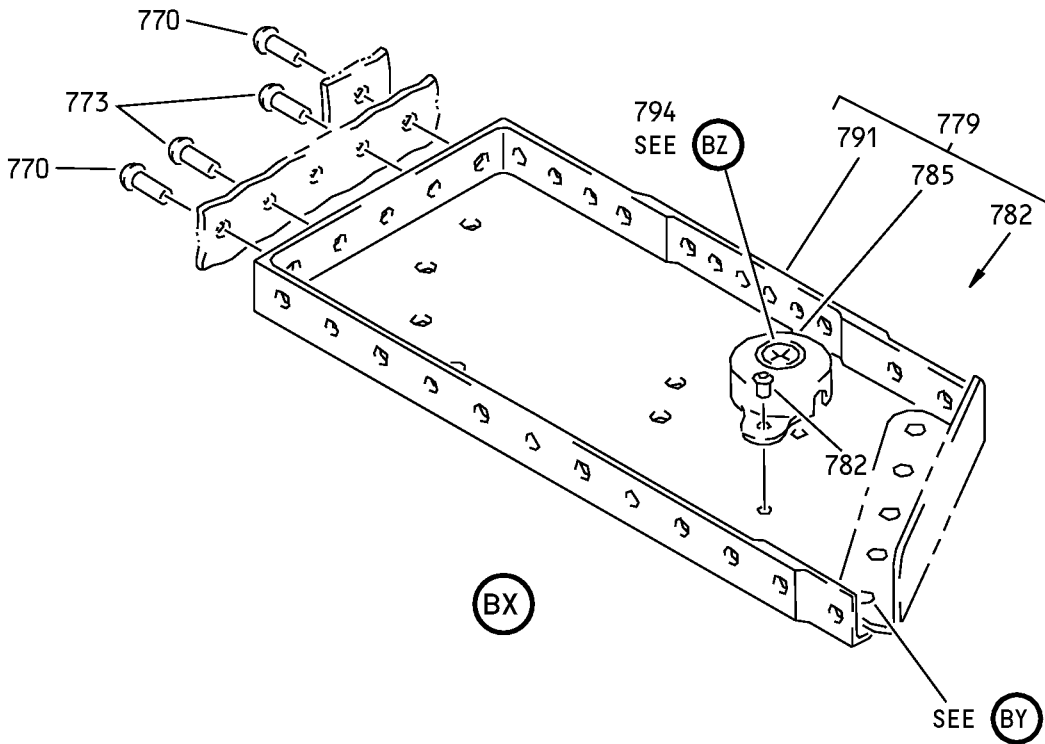
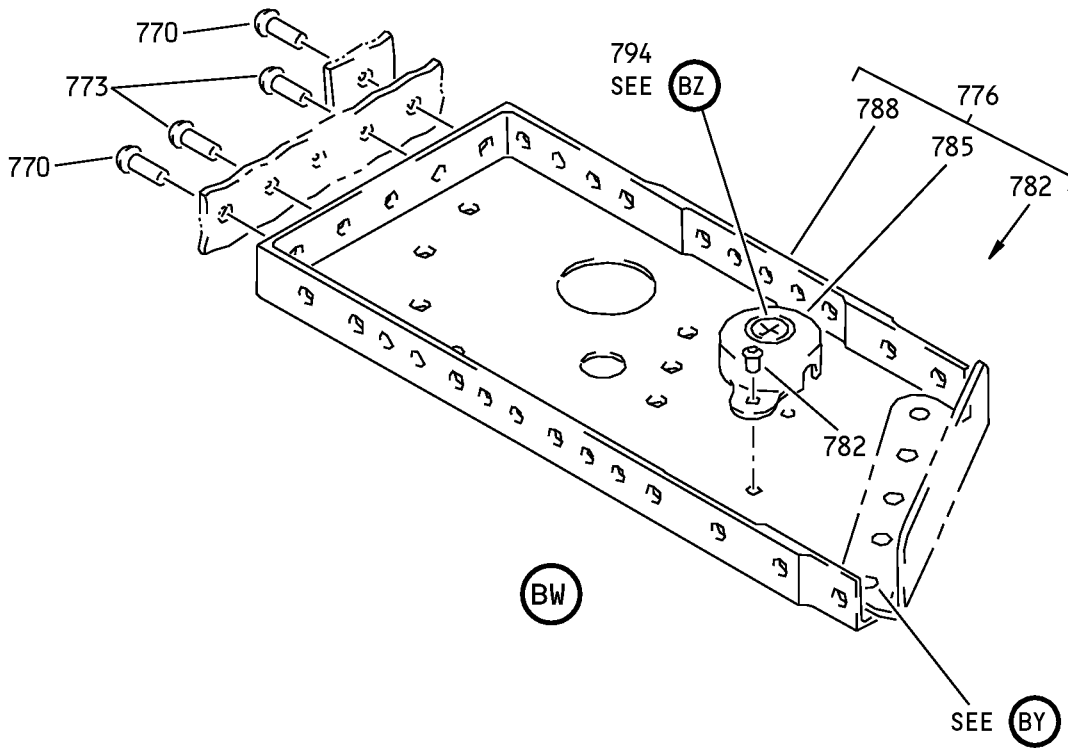
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Aft Entry Door Assembly  
IPL Figure 1 (Sheet 38 of 42)

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Aft Entry Door Assembly  
IPL Figure 1 (Sheet 39 of 42)

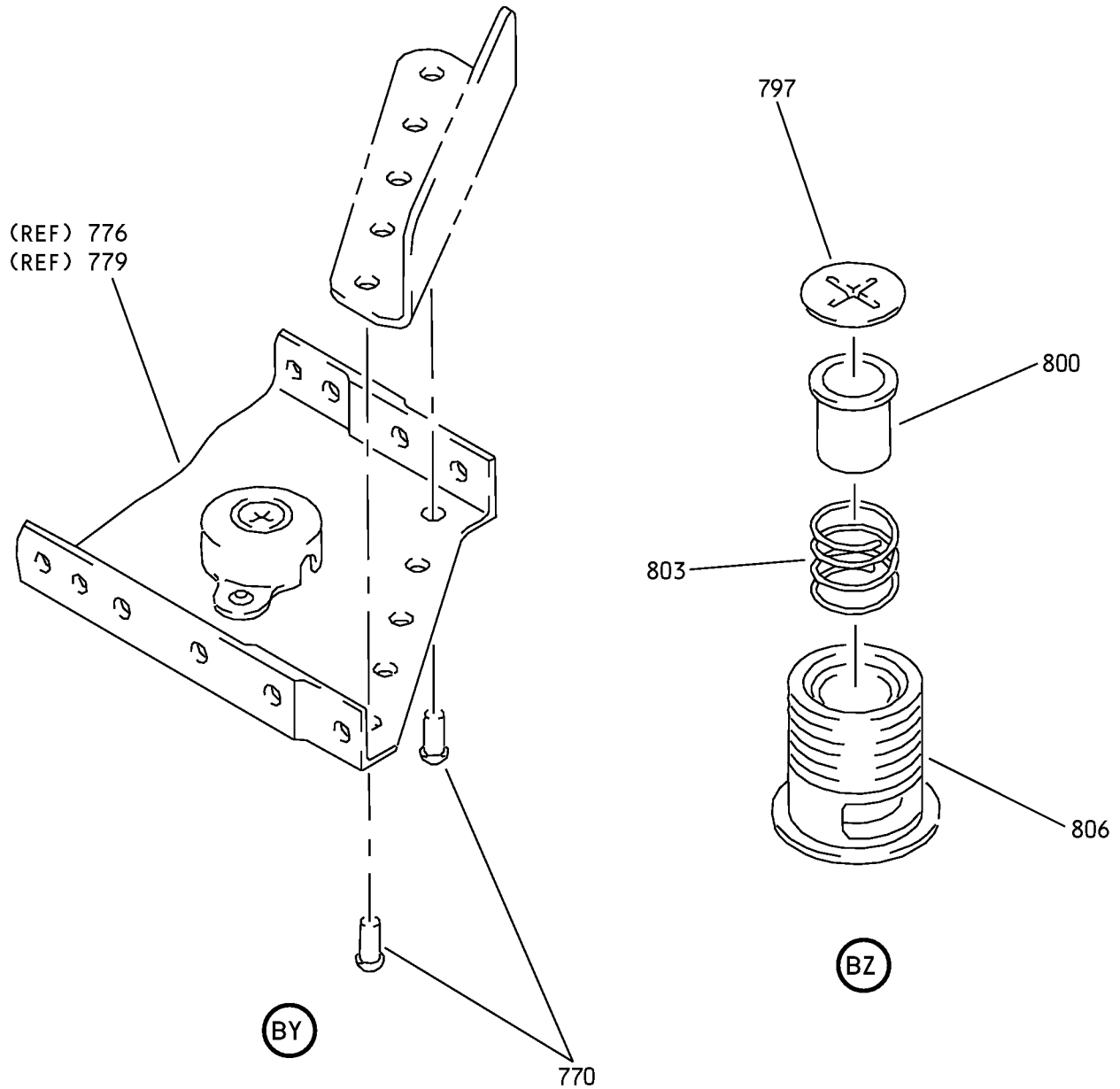
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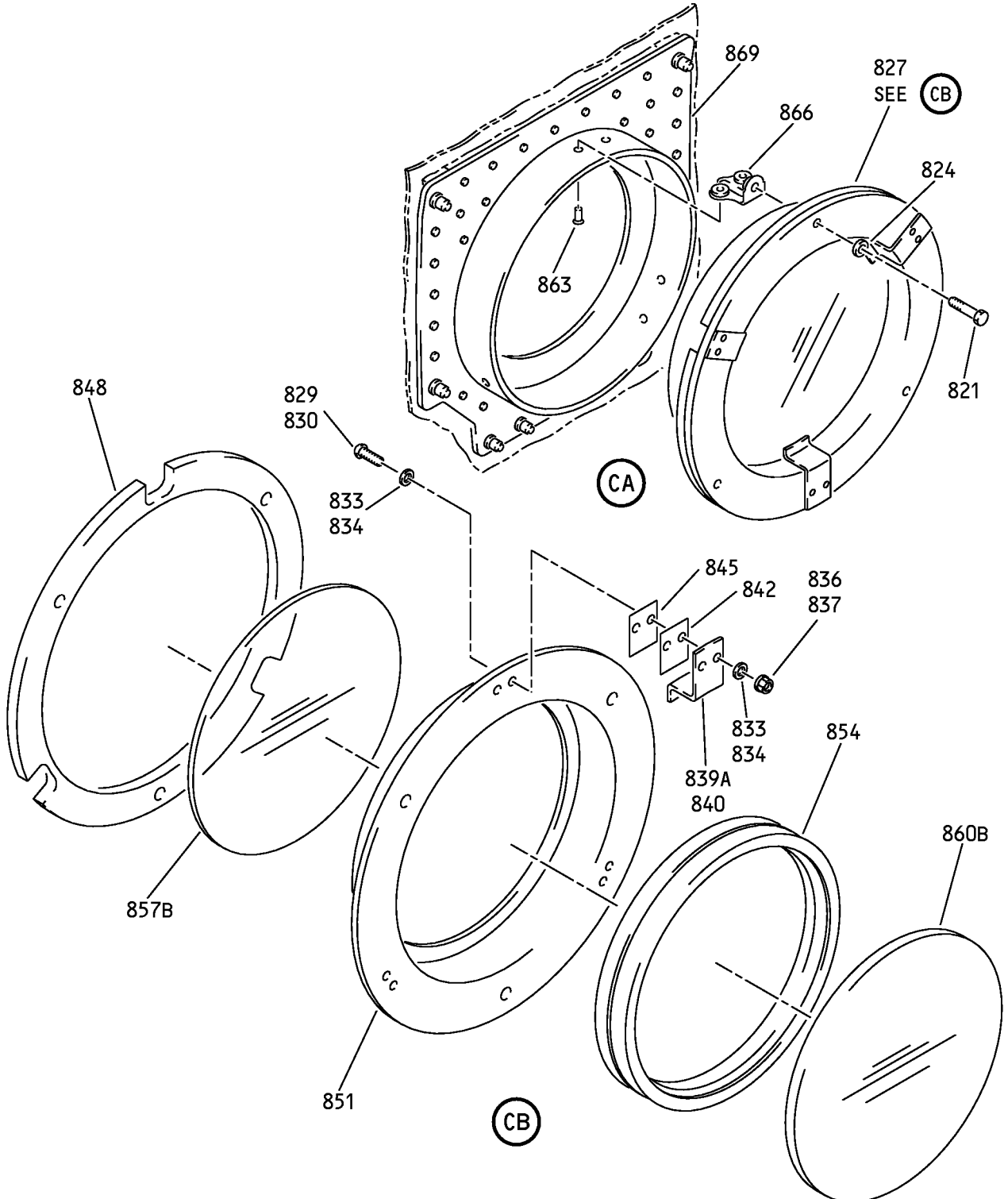
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Aft Entry Door Assembly  
IPL Figure 1 (Sheet 40 of 42)



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G79820 S00041000865\_V3

Aft Entry Door Assembly  
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DOOR CYCLE LOG

AIRPLANE SERIAL NO.	AIRPLANE FLIGHT CYCLES AT INSTL	AIRPLANE FLIGHT CYCLES AT REMOVAL

(CC)

872

AIRCRAFT MOD MFR. CODE PART NO. CONT. NO. SERIAL NO. CONT. <input style="width: 30px; height: 15px;" type="text"/> INSP.	CUST. INSP.
MODIFICATION INCORPORATED	

(CD)

Aft Entry Door Assembly  
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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-1A	147A6116-1									A	RF
-1B	147A6116-2									B	RF
-1C	147A6116-3									C	RF
-1D	147A6116-6										
-1E	147A6116-7										
-1F	147A6116-8										
-1G	147A6116-9										
-1H	147A6116-10									H	RF
-1J	147A6116-11									J	RF
-1K	147A6116-4									K	RF
-1L	147A6116-5									L	RF
-1M	147A6116-12									M	RF
-1N	147A6116-13									N	RF
-1P	147A6116-14									D	RF
-1Q	147A6116-15									E	RF

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-1R	147A6116-16									F	RF
-1S	147A6116-17									G	RF
-1T	147A6116-18									P	RF
-1U	147A6116-19									Q	RF
-1V	147A6116-20									R	RF
-1W	147A6116-21									S	RF
-1X	147A6116-22									T	RF
-1Y	147A6116-23									U	RF
-1Z	147A6116-24									V	RF
-2	147A6116-26									W	RF
-2A	147A6116-27									X	RF
-2B	147A6116-28									Y	RF
-2C	147A6116-29									Z	RF

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
5	HST11AG6-6		.	BOLT							4
				(V06725)							
				(SPEC BACB30VU6K6)							
				(OPT HST11AG6-6 (V73197))							
				(OPT HST11AG6-6 (V56878))							
				(OPT HST11AG6-6 (V0PTK6))							
8	HST11AG6-5		.	BOLT							4
				(V06725)							
				(SPEC BACB30VU6K5)							
				(OPT HST11AG6-5 (V73197))							
				(OPT HST11AG6-5 (V56878))							
				(OPT HST11AG6-5 (V0PTK6))							
11	BACC30BQ		.	COLLAR							8
14	BACR15GK4E2		.	RIVET							41
17	BACB30VF3K4		.	BOLT							15
18	BACB30VF3K3		.	BOLT							1
20	NAS1149D0332J		.	WASHER							16
23	H52732-3CD		.	NUT							16
				(V15653)							
				(SPEC BACN10YR3CD)							
				(OPT PLH53CD (V62554))							
26	BACR15BB4D		.	RIVET							8
				(SIZE DETERMINED ON INST)							
29	147A6145-13		.	RETAINER-SEAL							1
32	147A6145-15		.	RETAINER-SEAL							1
35	147A6145-17		.	RETAINER-SEAL							1
38	147A6145-25		.	RETAINER-SEAL							1
41	147A6145-3		.	RETAINER-SEAL							1
44	147A6145-27		.	RETAINER-SEAL							1
47	65-45871-504		.	ROD-NYLON							8
-50	S14162-5			DELETED							
50A	8675-5		.	SEAL-DOOR							1
				(V75345)							
				(SPEC 10-60476-5)							
				(OPT S14162-5 (V75345))							
53	BACB30NM3K9		.	BOLT							3
56	BACB30VF3K4		.	BOLT							2

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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-											
59	BACW10BN3AC		.								3
62	147A6130-1		.								1
65	HRSC3CFR9		..								1
66	NAS1149D0532J		..								1
67	H52732-5CD		..								1
68	147A6130-2		..								1
71	147A6133-1		.								1
74	147A6131-1		.								1
77	BACR15BA3AD		..								8
80	NS202493-02-2		..								4
83	147A6131-3		..								1
86	BACR15BA3AD		.								2
89	NS202493-02-4		.								1
92	BACR15GK6E4		.								4
95	BACR15GK6E3		.								2
98	149A9480-5		.								1
101	BACB30NT3K16		..								2
104	NAS1149D0363J		..								2

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
107	H52732-3CD		. .	NUT							2
				(V15653)							
				(SPEC BACN10YR3CD)							
				(OPT PLH53CD (V62554))							
110	149A9480-48		. .	STOP							1
113	149A9480-38		. .	STOP							1
116	BACR15FT5D		. .	RIVET							4
				(SIZE DETERMINED ON INST)							
119	149A9480-20		. .	BRACKET							1
122	BACR15GK6E3		.	RIVET							4
125	MS2114U6P4		.	RIVET							1
128	BACR15GK6E5		.	RIVET							1
131	BACS40R007B008F		.	SHIM							1
134	149A9480-67		.	BRACKET ASSY							1
137	BACR15BA5D		. .	RIVET							2
				(SIZE DETERMINED ON INST)							
140	149A9480-72		. .	SPACER							1
143	BACR15BA3D		. .	RIVET							2
				(SIZE DETERMINED ON INST)							
146	BRF200C4D		. .	NUTPLATE							1
				(V52828)							
				(SPEC BACN10JR4CFD)							
				(OPT K51602-4BAC (V15653))							
				(OPT NS202476-048 (V80539))							
				(OPT 102F9201-4 (V72962))							
				(OPT T8092C428CD (V11815))							
149	BACB30NT3K1		. .	SCREW							3
152	NAS1149D0332J		. .	WASHER							3
155	149A9480-22		. .	BRACKET							1
158	BACR15BA4D		. .	RIVET							6
				(SIZE DETERMINED ON INST)							
161	SL2752-3		. .	MOUNT-ISOLATOR							3
				(V97393)							
				(SPEC BACS14K2)							
				(OPT DE679-10 (V71985))							
164	149A9480-59		. .	BACKPLATE							1
167	BACR15GK6E3		.	RIVET							2

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
170	BACR15GK6E4		.								3
173	149A9480-8		.								1
176	BACR15BA3D		..								4
177	BRF200C4D		..								2
179	66-9776		..								2
182	149A9480-49		..								1
185	BACB30NT3K3		.						A-S		7
-185A	BACB30NT3K4		.						T-Z		7
188	BACW10CT6J		.								7
191	BACR15GE3CW2		.								14
194	NS202493-02-2		.								7
197	BACS40R008C030F		.								1
200	BACS40R008C037F		.								1
203	149A9480-69		.								1
206	BACR15BA5D		..								2
209	149A9480-71		..								1
212	BACR15BA3D		..								2
215	BRF200C4D		..								1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
218	BACB30NT3K1		.	.	SCREW						3
221	NAS1149D0332J		.	.	WASHER						3
223	149A9480-23		.	.	BRACKET						1
224	149A9480-24		.	.	BRACKET						1
227	BACR15BA4D		.	.	RIVET						6
					(SIZE DETERMINED ON INST)						
230	SL2750		.	.	ISOLATOR						3
					(V97393)						
					(SPEC BACS14K4)						
					(OPT DE675-10 (V71985))						
233	BACR15GK6E		.		RIVET						8
236	SL2808-3		.		SHOCKMOUNT						4
					(V97393)						
					(SPEC BACS14K1)						
					(OPT DE685-10 (V71985))						
239	BACR15BB4D		.		RIVET						8
					(SIZE DETERMINED ON INST)						
242	SL2509		.		SHOCKMOUNT						4
					(V97393)						
					(SPEC BACS14K7)						
					(OPT J7444-11 (V76005))						
					(OPT DE586 (V71985))						
245	HR3253-5-3		.		RIVET						4
					(V0HDW7)						
					(SPEC BACR15GJ5E3)						
248	147A6161-1		.		LINING ASSY-RETAINER						1
251	82-99-341-18		.	.	STUD						4
					(V94222)						
					(SPEC BACS21AP180RP)						
254	BACR12AG2C		.	.	RING-SPLIT						4
257	147A6161-3		.	.	RETAINER						1
260	BACB30NT3K6		.		BOLT						3
263	BACB30NT3K5		.		BOLT						16
266	BACW10CT6J		.		WASHER						19
269	BACR15BA5B		.		RIVET						60
					(SIZE DETERMINED ON INST)						
272	147A6134-1		.		HINGE ASSY						1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
275	147A6134-3		.								1
278	MS39086-125		.	.							2
281	MS20253P2-2910		.	.							1
284	147A6134-5		.	.							1
											(USED ON ITEM 272)
287	147A6134-7		.	.							1
											(USED ON ITEM 275)
290	147A6134-9		.	.							1
293	147A6143-1		.							A-C, H-L, N	1
-293A	147A6143-5		.							D-G, M	1
-293B	147A6143-9		.							P-X	1
-293C	147A6143-11		.							Y, Z	1
296	BACB30NM3K8		.	.							4
299	BACW10BN3AC		.	.							4
302	149A6113-2		.	.							2
303	F51636-3		.	.	.						2
											(V15653)
											(SPEC BACN10JA3CD)
											(OPT 102F177-3 (V72962))
											(OPT BRF110C3D (V52828))
											(OPT BRF170C3D (V52828))
											(OPT NS202484-02 (V80539))
303N	BACR15A3AD		.	.	.						4
304	149A6113-4		.	.	.						1
305	147A6144-1		.	.							1
308	BACB28X4M014		.	.	.						1
311	BACB28X6M014		.	.	.						1
314	147A6144-3		.	.	.						1
317	AF3253-4-3B		.	.							28
											(V53551)
											(SPEC BACR15FR4E3R)
											(OPT CR3253-4-3 (V11815))

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
320	147A6145-22		.	.	RETAINER-SEAL (MAKE FROM ROLLED SECTION ALUMINUM BAC1520-584 X 29.1 2024-T3511 AL EXTRU QQ-A-200/3)					A-X	1
-320A	147A6145-29		.	.	RETAINER-SEAL					Y, Z	1
323	147A6145-19		.	.	RETAINER (MAKE FROM ROLLED SECTION ALUMINUM BAC1494-171 X 9.3 6061-0 AL SH QQ-A-250/11)						1
326	147A6145-21		.	.	RETAINER (MAKE FROM ROLLED SECTION ALUMINUM BAC1494-171 X 13.2 6061-T42 AL SH QQ-A-250/11)						1
329	147A6145-23		.	.	RETAINER (MAKE FROM ROLLED SECTION ALUM1NUM BAC1494-171 X 9.5 6061-0 AL SH QQ-A-250/11)						1
332	147A6146-1		.	.	GATE ASSY					A-C, H-L, N	1
-332A	147A6146-7		.	.	GATE ASSY					D-G, M	1
-332B	147A6146-11		.	.	GATE ASSY					P-Z	1
335	69-41720-3		.	.	BUSHING						2
338	147A6146-3		.	.	GATE					A-C, H-L, N	1
-338A	147A6146-9		.	.	GATE					D-G, M	1
-338B	147A6146-13		.	.	GATE					P-Z	1
341	147A6143-3		.		GATE ASSY-END					A-C, H-L, N	1
-341A	147A6143-4		.		GATE ASSY-END					D-G, M	1
-341B	147A6143-7		.		GATE ASSY-END					P-X	1
-341C	147A6143-13		.		GATE ASSY-END					Y, Z	1
344	BACB30NM3K8		.	.	BOLT						4
347	BACW10BN3AC		.	.	WASHER						4
350	NAS1149D0363J		.	.	WASHER						4
353	H52732-3CD		.	.	NUT (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))						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										
1-																			
356	147A6144-2		.	.	C	L	E	V	I	S	A	S	S	1					
359	BACB28X4M014		.	.	.	B	U	S	H	I	N	G		1					
365	BACB28X6M014		.	.	.	B	U	S	H	I	N	G		1					
368	147A6144-4		.	.	.	C	L	E	V	I	S			1					
371	AF3253-4-4B		.	.	R	I	V	E	T					30					
					(V53551)														
					(SPEC BACR15FR4E4R)														
					(OPT CR3253-4-4 (V11815))														
					(OPT HR3253-4-4 (V0HDW7))														
374	147A6145-11		.	.	R	E	T	A	I	N	E	R	-	S	E	A	L		1
					(MAKE FROM ROLLED SECTION														
					ALUMINUM BAC1494-171 X 7.8														
					6061-0 AL SH PER QQ-A-250/11)														
377	147A6145-9		.	.	R	E	T	A	I	N	E	R	-	S	E	A	L		1
					(MAKE FROM ROLLED SECTION														
					ALUMINUM BAC1494-171 X 16.5														
					6061-T42 AL SH QQ-A-250/11)														
380	147A6145-7		.	.	R	E	T	A	I	N	E	R	-	S	E	A	L		1
					(MAKE FROM ROLLED SECTION														
					ALUMINUM BAC1494-171 X 7.8														
					6061-0 AL SH PER QQ-A-250/11)														
383	147A6145-10		.	.	R	E	T	A	I	N	E	R	-	S	E	A	L		1
					(MAKE FROM EXTRUSION														
					ALUMINUM BAC1520-584 X 29.2														
					2024-T3511 AL EXTRU PER														
					QQ-A-200/3)								A-X						
-383A	147A6145-28		.	.	R	E	T	A	I	N	E	R	-	S	E	A	L		1
					(MAKE FROM ROLLED SECTION														
					ALUMINUM BAC1494-171 X 7.8														
					6061-0 AL SH PER QQ-A-250/11)														
386	147A6147-1		.	.	G	A	T	E	-	E	N	D							1
					(MAKE FROM ROLLED SECTION														
					ALUMINUM BAC1494-171 X 7.8														
					6061-0 AL SH PER QQ-A-250/11)														
-386A	147A6147-3		.	.	G	A	T	E	-	E	N	D							1
					(MAKE FROM ROLLED SECTION														
					ALUMINUM BAC1494-171 X 7.8														
					6061-0 AL SH PER QQ-A-250/11)														
-386B	147A6147-4		.	.	G	A	T	E											1
					(MAKE FROM ROLLED SECTION														
					ALUMINUM BAC1494-171 X 7.8														
					6061-0 AL SH PER QQ-A-250/11)														
389	HST11AG6-5		.	B	O	L	T												24
					(V06725)														
					(SPEC BACB30VU6K5)														
					(OPT HST11AG6-5 (V73197))														
					(OPT HST11AG6-5 (V56878))														
					(OPT HST11AG6-5 (V0PTK6))														

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1- 392	HST11AG6-4		.	BOLT							68
				(V06725)							
				(SPEC BACB30VU6K4)							
				(OPT HST11AG6-4 (V73197))							
				(OPT HST11AG6-4 (V0PTK6))							
				(OPT HST11AG6-4 (V56878))							
395	HST11AG6-3		.	BOLT							38
				(V06725)							
				(SPEC BACB30VU6K3)							
				(OPT HST11AG6-3 (V73197))							
				(OPT HST11AG6-3 (V56878))							
				(OPT HST11AG6-3 (V0PTK6))							
398	HST10AG6-5		.	BOLT							2
				(V0PTK6)							
				(SPEC BACB30VT6K5)							
				(OPT HST10AG6-5 (V06725))							
				(OPT HST10AG6-5 (V56878))							
				(OPT HST10AG6-5 (V73197))							
				(OPT WC10K6-5 (V60516))							
401	HST10AG6-4		.	BOLT							12
				(V06725)							
				(SPEC BACB30VT6K4)							
				(OPT HST10AG6-4 (V73197))							
				(OPT HST10AG6-4 (V56878))							
				(OPT HST10AG6-4 (V0PTK6))							
404	HST10AG8-3		.	BOLT							8
				(V0PTK6)							
				(SPEC BACB30VT8K3)							
				(OPT HST10AG8-3 (V06725))							
				(OPT HST10AG8-3 (V56878))							
				(OPT HST10AG8-3 (V73197))							
				(OPT WC10K8-3 (V60516))							
407	HST10AG6-3		.	BOLT							28
				(V0PTK6)							
				(SPEC BACB30VT6K3)							
				(OPT HST10AG6-3 (V06725))							
				(OPT HST10AG6-3 (V56878))							
				(OPT HST10AG6-3 (V73197))							
				(OPT WC10K6-3 (V60516))							

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
410	HST11AG5-5		.	BOLT							6
				(V06725)							
				(SPEC BACB30VU5K5)							
				(OPT HST11AG5-5 (V73197))							
				(OPT HST11AG5-5 (V0PTK6))							
				(OPT HST11AG5-5 (V56878))							
411	HST10AG8-6		.	BOLT							5
				(V0PTK6)							
				(SPEC BACB30VT8K6)							
				(OPT HST10AG8-6 (V06725))							
				(OPT HST10AG8-6 (V56878))							
				(OPT HST10AG8-6 (V73197))							
				(OPT WC10K8-6 (V60516))							
412	HST10AG8-5		.	BOLT							3
				(V0PTK6)							
				(SPEC BACB30VT8K5)							
				(OPT HST10AG8-5 (V06725))							
				(OPT HST10AG8-5 (V56878))							
				(OPT HST10AG8-5 (V73197))							
				(OPT WC10K8-5 (V60516))							
413	HST10AG8-4		.	BOLT							4
				(V0PTK6)							
				(SPEC BACB30VT8K4)							
				(OPT HST10AG8-4 (V06725))							
				(OPT HST10AG8-4 (V56878))							
				(OPT HST10AG8-4 (V73197))							
				(OPT WC10K8-4 (V60516))							
414	HST10AG8-7		.	BOLT							6
				(V0PTK6)							
				(SPEC BACB30VT8K7)							
				(OPT HST10AG8-7 (V06725))							
				(OPT HST10AG8-7 (V56878))							
				(OPT HST10AG8-7 (V73197))							
				(OPT WC10K8-7 (V60516))							
416	HST10AG6-6		.	BOLT							2
				(V0PTK6)							
				(SPEC BACB30VT6K6)							
				(OPT HST10AG6-6 (V06725))							
				(OPT HST10AG6-6 (V56878))							
				(OPT HST10AG6-6 (V73197))							
				(OPT WC10K6-6 (V60516))							
419	BACC30BL		.	COLLAR							156
422	BACN10ZV		.	NUT							26

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
425	BACC30BQ		.								29
428	BACR15GF6D		.								40
431	MS21141U6P4		.								14
434	BACR15GK6E3		.								115
437	BACR15GK6E4		.								21
440	BACR15GF5D		.								279
443	BACF3T01E5-4B		.							A-X	2
-443A	BACF3T01E05-04B		.							Y, Z	2
446	BACS40R007B017F		.								5
449	BACS40R007B008F		.								27
452	BACS40R008C008F		.								10
455	BACR15BA3AD		.								38
458	F51646-3BAC		.								7
461	BACF3H12JF007HN		.								3
464	F51643-3BAC		.								12
467	HST11AG8-6		.								4
470	HST11AG8-5		.								4
-473	BACB30VU8K7										DELETED

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-476	BACB30VU8K4							DELETED			
478	BACB30VF3K4							. BOLT			4
-479	BACC30BD							DELETED			
480	NAS1149D0363J							. WASHER			4
481	H52732-3CD							. NUT (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))			4
482	147A6125-15							. BEAM ASSY	A-V		1
-482A	147A6125-27							. BEAM ASSY	W-Z		1
485	BACR15BB4D							. . RIVET (SIZE DETERMINED ON INST)			12
488	SL2808-3							. . SHOCKMOUNT (V97393) (SPEC BACS14K1) (OPT DE685-10 (V71985))			6
491	LGPL2SPV8-6AC							. . BOLT (V17446) (SPEC BACB30VN8K6) (OPT LGPL2SPV8-6AC (V92215)) (OPT 81669V8K6 (V56878)) (OPT LGPL2SPV8-6AC (V56878))			5
494	LGPL2SPV6-6AC							. . BOLT (V17446) (SPEC BACB30VN6K6) (OPT LGPL2SPV6-6AC (V92215)) (OPT 81669V6K6 (V56878)) (OPT LGPL2SPV6-6AC (V56878))			4
497	LGPL2SPV8-5AC							. . BOLT (V17446) (SPEC BACB30VN8K5) (OPT LGPL2SPV8-5AC (V92215)) (OPT 81669V8K5 (V56878)) (OPT LGPL2SPV8-5AC (V56878))			1
500	BACC30BK							. . COLLAR			10
501	147A6128-21							. . STOP ASSY	A-V		1
-501A	147A6128-53							. . STOP ASSY	W-Z		1
502	147A6128-22							. . STOP ASSY	A-Z		1
-502D	66-12688-1							DELETED			

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
502E	66-12688-11										1
502N	147A6128-45									A-V	1
-502P	147A6128-54									W-Z	1
502R	147A6128-46									A-Z	1
503	147A6126-35										1
506	147A6125-13										1
509	LGPL2SPV8-7AC										2
512	LGPL2SPV8-6AC										2
515	LGPL2SPV8-4AC										1
518	LGPL2SPV6-7AC										4
521	BACC30BK										9
524	147A6128-19										1
527	147A6128-20										1
-530	66-12688-1										
530A	66-12688-11										1
533	147A6128-43										1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE	USAGE CODE	UNITS PER ASSY
1-					
536	147A6128-44		. . . FITTING (USED ON ITEM 527)		1
539	147A6126-33		. . BEAM		1
542	147A6125-9		. BEAM ASSY		1
545	LGPL2SPV8-4AC		. . BOLT (V17446) (SPEC BACB30VN8K4) (OPT LGPL2SPV8-4AC (V92215)) (OPT 81669V8K4 (V56878)) (OPT LGPL2SPV8-4AC (V56878))		2
548	LGPL2SPV6-4AC		. . BOLT (V17446) (SPEC BACB30VN6K4) (OPT LGPL2SPV6-4AC (V92215)) (OPT 81669V6K4 (V56878)) (OPT LGPL2SPV6-4AC (V56878))		3
551	LGPL2SPV8-5AC		. . BOLT (V17446) (SPEC BACB30VN8K5) (OPT LGPL2SPV8-5AC (V92215)) (OPT 81669V8K5 (V56878)) (OPT LGPL2SPV8-5AC (V56878))		1
554	LGPL2SPV8-6AC		. . BOLT (V17446) (SPEC BACB30VN8K6) (OPT LGPL2SPV8-6AC (V92215)) (OPT 81669V8K6 (V56878)) (OPT LGPL2SPV8-6AC (V56878))		1
557	LGPL2SPV6-7AC		. . BOLT (V17446) (SPEC BACB30VN6K7) (OPT LGPL2SPV6-7AC (V92215)) (OPT 81669V5K6 (V56878)) (OPT LGPL2SPV6-7AC (V56878))		3
560	BACC30BK		. . COLLAR		10
563	147A6128-15		. . STOP ASSY		1
566	147A6128-17		. . STOP ASSY		1
569	66-12688-11		. . . BUSHING		1
572	147A6128-39		. . . FITTING (USED ON ITEM 563)		1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
575	147A6128-41								. . . FITTING (USED ON ITEM 566)		1
578	147A6126-29								. . BEAM		1
581	147A6125-7								. BEAM ASSY		1
584	BACR15BA3AD								. . RIVET (SIZE DETERMINED ON INST) (OPT ITEM 584A, 584B)		20
-584A	BACR15DR3AD								. . RIVET (SIZE DETERMINED ON INST) (OPT ITEM 584, 584B)		20
-584B	NAS1399CW3								. . RIVET (SIZE DETERMINED ON INST) (OPT ITEM 584, 584A)		20
587	NS202495-02								. . NUTPLATE (V80539) (SPEC BACN10KE3DCD) (OPT F51753-3DC (V15656))		10
590	BACB10NM3K4								. . BOLT		10
593	NAS1149D0363J								. . WASHER		10
596	149A6114-1								. . SPLICE		1
599	BACR15BA5AD								. . RIVET (SIZE DETERMINED ON INST)		4
602	149A6116-2								. . FILLER		2
605	LGPL2SPV8-7AC								. . BOLT (V17446) (SPEC BACB30VN8K7) (OPT LGPL2SPV8-7AC (V92215)) (OPT 81669V8K7 (V56878)) (OPT LGPL2SPV8-7AC (V56878))		1
608	LGPL2SPV8-6AC								. . BOLT (V17446) (SPEC BACB30VN8K6) (OPT LGPL2SPV8-6AC (V92215)) (OPT 81669V8K6 (V56878)) (OPT LGPL2SPV8-6AC (V56878))		2

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
611	LGPL2SPV6-7AC		. .	BOLT							4
				(V17446)							
				(SPEC BACB30VN6K7)							
				(OPT LGPL2SPV6-7AC (V92215))							
				(OPT 81669V5K6 (V56878))							
				(OPT LGPL2SPV6-7AC (V56878))							
614	LGPL2SPV8-4AC		. .	BOLT							1
				(V17446)							
				(SPEC BACB30VN8K4)							
				(OPT LGPL2SPV8-4AC (V92215))							
				(OPT 81669V8K4 (V56878))							
				(OPT LGPL2SPV8-4AC (V56878))							
617	LGPL2SPV6-6AC		. .	BOLT							2
				(V17446)							
				(SPEC BACB30VN6K6)							
				(OPT LGPL2SPV6-6AC (V92215))							
				(OPT 81669V6K6 (V56878))							
				(OPT LGPL2SPV6-6AC (V56878))							
620	BACC30BK		. .	COLLAR							10
623	147A6128-9		. .	STOP ASSY							1
626	147A6128-13		. .	STOP ASSY							1
629	66-12688-11		. . .	BUSHING							1
632	147A6128-33		. . .	FITTING							1
				(USED ON ITEM 623)							
635	147A6128-37		. . .	FITTING							1
				(USED ON ITEM 626)							
638	147A6126-27		. .	BUSHING							1
641	147A6125-5		. .	BEAM ASSY							1
644	BACR15BA3AD		. .	RIVET							20
				(SIZE DETERMINED ON INST)							
				(OPT ITEM 644A, 644B)							
-644A	BACR15DR3AD		. .	RIVET							20
				(SIZE DETERMINED ON INST)							
				(OPT ITEM 644, 644B)							
-644B	NAS1399CW3		. .	RIVET							20
				(SIZE DETERMINED ON INST)							
				(OPT ITEM 644, 644A)							

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
1-												
647	NS202495-02											10
650	BACB30NM3K4											10
653	NAS1149D0363J											10
656	149A6114-1											1
659	BACR15BA3AD											4
662	149A6116-1											2
665	LGPL2SPV8-6AC											2
668	LGPL2SPV8-5AC											1
671	LGPL2SPV8-4AC											1
674	LGPL2SPV6-6AC											4
677	LGPL2SPV6-5AC											1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
680	LGPL2SPV6-7AC		. .	BOLT							1
				(V17446)							
				(SPEC BACB30VN6K7)							
				(OPT LGPL2SPV6-7AC (V92215))							
				(OPT 81669V5K6 (V56878))							
				(OPT LGPL2SPV6-7AC (V56878))							
683	BACC30BK		. .	COLLAR							10
686	147A6128-9		. .	STOP ASSY							1
689	147A6128-11		. .	STOP ASSY							1
692	66-12688-11		. . .	BUSHING							1
695	147A6128-33		. . .	FITTING							1
				(USED ON ITEM 686)							
698	147A6128-35		. . .	FITTING							1
				(USED ON ITEM 689)							
701	147A6126-25		. .	BEAM							1
704	147A6125-19		. .	BEAM ASSY					A		1
-704A	147A6125-21		. .	BEAM ASSY					B-Z		1
707	LGPL2SPV6-4AC		. .	BOLT							15
				(V17446)							
				(SPEC BACB30VN6K4)							
				(OPT LGPL2SPV6-4AC (V92215))							
				(OPT 81669V6K4 (V56878))							
				(OPT LGPL2SPV6-4AC (V56878))							
710	BACC30BK		. .	COLLAR							14
713	147A6128-7		. .	STOP ASSY							1
716	147A6128-5		. .	STOP ASSY					A		1
-716A	147A6128-49		. .	STOP ASSY					B-Z		1
719	66-12688-11		. . .	BUSHING							1
722	147A6128-31		. . .	FITTING							1
				(USED ON ITEM 713)							
725	147A6128-29		. . .	FITTING					A		1
				(USED ON ITEM 716)							
-725A	147A6128-51		. . .	FITTING					B-Z		1
				(USED ON ITEM 716A)							
728	147A6126-37		. .	BEAM							1
731	147A6125-17		. .	BEAM ASSY					A-C, J-L, N		1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-731A	147A6125-23		.	BEAM	ASSY					D-H, M, P-Z	1
734	BACR15BB4D		..	RIVET							4
					(SIZE DETERMINED ON INST)						
737	SL2751-3S		..	SHOCKMOUNT							2
					(V97393)						
					(SPEC BACS14K3)						
					(OPT DE676-10 (V71985))						
740	LGPL2SPV8-6AC		..	BOLT							5
					(V17446)						
					(SPEC BACB30VN8K6)						
					(OPT LGPL2SPV8-6AC (V92215))						
					(OPT 81669V8K6 (V56878))						
					(OPT LGPL2SPV8-6AC (V56878))						
743	LGPL2SPV6-6AC		..	BOLT							4
					(V17446)						
					(SPEC BACB30VN6K6)						
					(OPT LGPL2SPV6-6AC (V92215))						
					(OPT 81669V6K6 (V56878))						
					(OPT LGPL2SPV6-6AC (V56878))						
745	BACS40R007C007F			DELETED							
746	LGPL2SPV8-5AC		..	BOLT							1
					(V17446)						
					(SPEC BACB30VN8K5)						
					(OPT LGPL2SPV8-5AC (V92215))						
					(OPT 81669V8K5 (V56878))						
					(OPT LGPL2SPV8-5AC (V56878))						
-748	BACC30BK			DELETED							
748A	3SLCC8		..	COLLAR							6
					(V17446)						
					(SPEC BACC30BK8)						
					(OPT 3SLCC8 (V92215))						
748L	3SLCC6		..	COLLAR							4
					(V17446)						
					(SPEC BACC30BK6)						
					(OPT 3SLCC6 (V92215))						
749	147A6128-1		..	STOP	ASSY						1
752	147A6128-3		..	STOP	ASSY						1
755	66-12688-11		...	BUSHING							1
758	147A6128-25		...	FITTING							1
					(USED ON ITEM 749)						

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
761	147A6128-27		. . .								1
764	147A6126-21		. .							A-C, J-L, N	1
-764A	147A6126-39		. .							D-H, M, P-Z	1
-767	BACR15GF6D		DELETED								
770	BACR15FT6D		. RIVET								12
773	BACR15FT5D		. RIVET								6
776	147A6149-1		. BEAM ASSY-STUB								1
779	147A6149-3		. BEAM ASSY-STUB								1
782	BACR15BB4AD		. . RIVET								2
785	140N2021-1		. . RETAINER								1
788	147A6149-5		. . BEAM ASSY								1
791	147A6149-7		. . BEAM ASSY								1
794	140N2022-1		. VALVE ASSY								2
797	140N2022-4		. . CAP								1
800	140N2022-3		. . PLUNGER								1
803	140N2020-1		. . SPRING								1
806	140N2022-2		. . HOUSING								1
807	BACR15GF5D		. RIVET								40
809	147A6137-3		. HANDLE PAN-ASSY								1
812	BACR15GF5D		. . RIVET								2
815	149A6121-1		. . PLATE-SEAL								1
818	147A6137-5		. . PAN								1
821	BACB30NM3K3		. BOLT								3
824	BACW10BN3AC		. WASHER								3
827	65-2863-8		. WINDOW ASSY							A-U	1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-827A	141A6570-1		.	.	.	.	.	.	.	V-Z	1
829	BACS12HJ04K8		.	.	.	.	.	.	.	V-Z	6
-829A	NAS8200A8		.	.	.	.	.	.	.	V-Z	6
830	NAS8200A8		.	.	.	.	.	.	.	A-U	6
-830A	BACS12HJ04K8		.	.	.	.	.	.	.	V-Z	6
-830B	NAS8200A8		.	.	.	.	.	.	.	V-Z	6
833	NAS1149DN432J		.	.	.	.	.	.	.		12
834	NAS1149DN432J		.	.	.	.	.	.	.	V-Z	12
836	H52732-04CD		.	.	.	.	.	.	.		6
837	PLH504CD		.	.	.	.	.	.	.	V-Z	6
-839	63-4178-1		DELETED								
839A	63-1478-1		.	.	.	.	.	.	.	A-U	3
-839B	141A6573-1		.	.	.	.	.	.	.	V-Z	3
840	141A6573-1		.	.	.	.	.	.	.	V-Z	3
842	BACS40R007B007F		.	.	.	.	.	.	.		1
845	BACS40R007C007F		.	.	.	.	.	.	.		1
848	66-2646		.	.	.	.	.	.	.	A-U	1
-848A	141A6575-1		.	.	.	.	.	.	.	V-Z	1
851	69-1983-7		.	.	.	.	.	.	.	A-U	1
-851A	141A6572-1		.	.	.	.	.	.	.	V-Z	1
854	66-1921-2		.	.	.	.	.	.	.	A-U	1
-854A	141A6574-1		.	.	.	.	.	.	.	V-Z	1
-857	69-10284-2		DELETED								
-857A	69-1284-2		DELETED								
857B	69-1084-2		.	.	.	.	.	.	.	A-U	1

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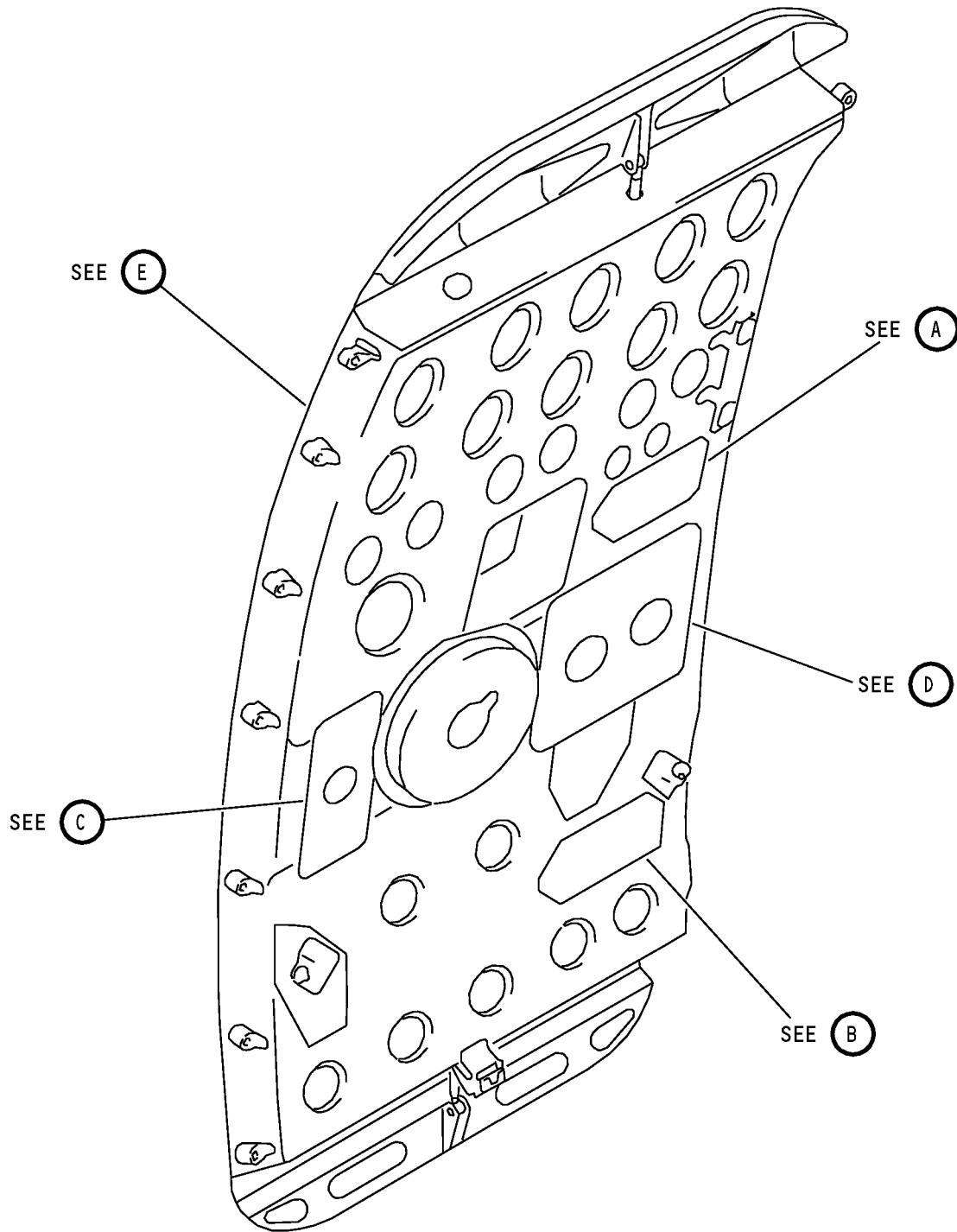
## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-857C	141A6571-1								. . PANE-OUTER	V-Z	1
-860	69-10283-2								DELETED		
-860A	69-1283-2								DELETED		
860B	69-1083-2								. . PANE-INNER	A-U	1
-860C	141A6571-2								. . PANE-INNER	V-Z	1
863	BACR15GF4D								. RIVET		6
866	T8059S1032B1								. NUTPLATE (V52828) (SPEC BACN10MK3-45) (OPT T8059S1032B1 (V11815))		3
869	149A6112-1								. DOUBLER-WINDOW		1
872	MS27253F1								. PLATE-ID	A	1
875	BAC27DBY191								. MARKER	A-S	1
									DELETED		

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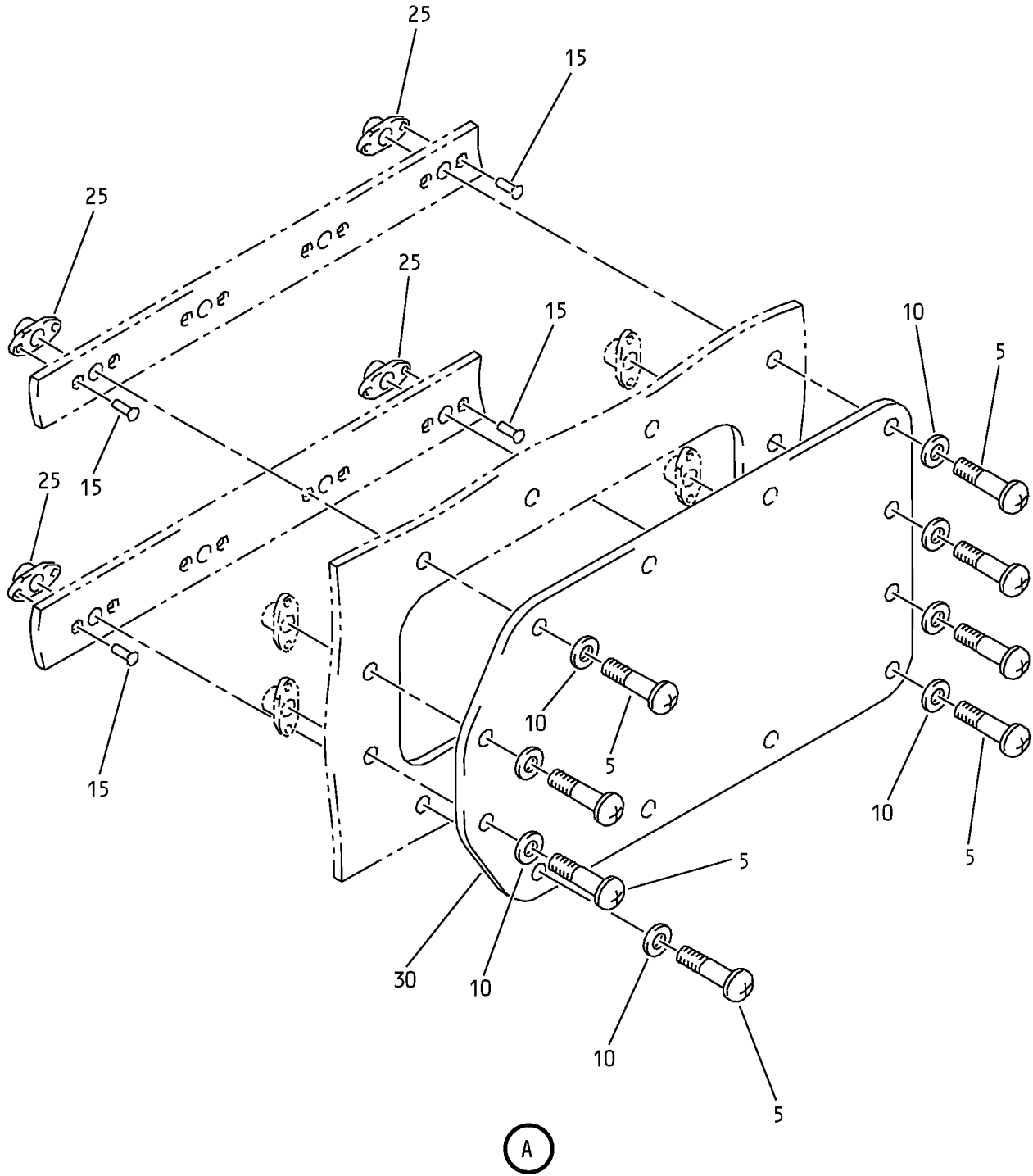
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Aft Entry Door Assembly  
IPL Figure 2 (Sheet 1 of 19)

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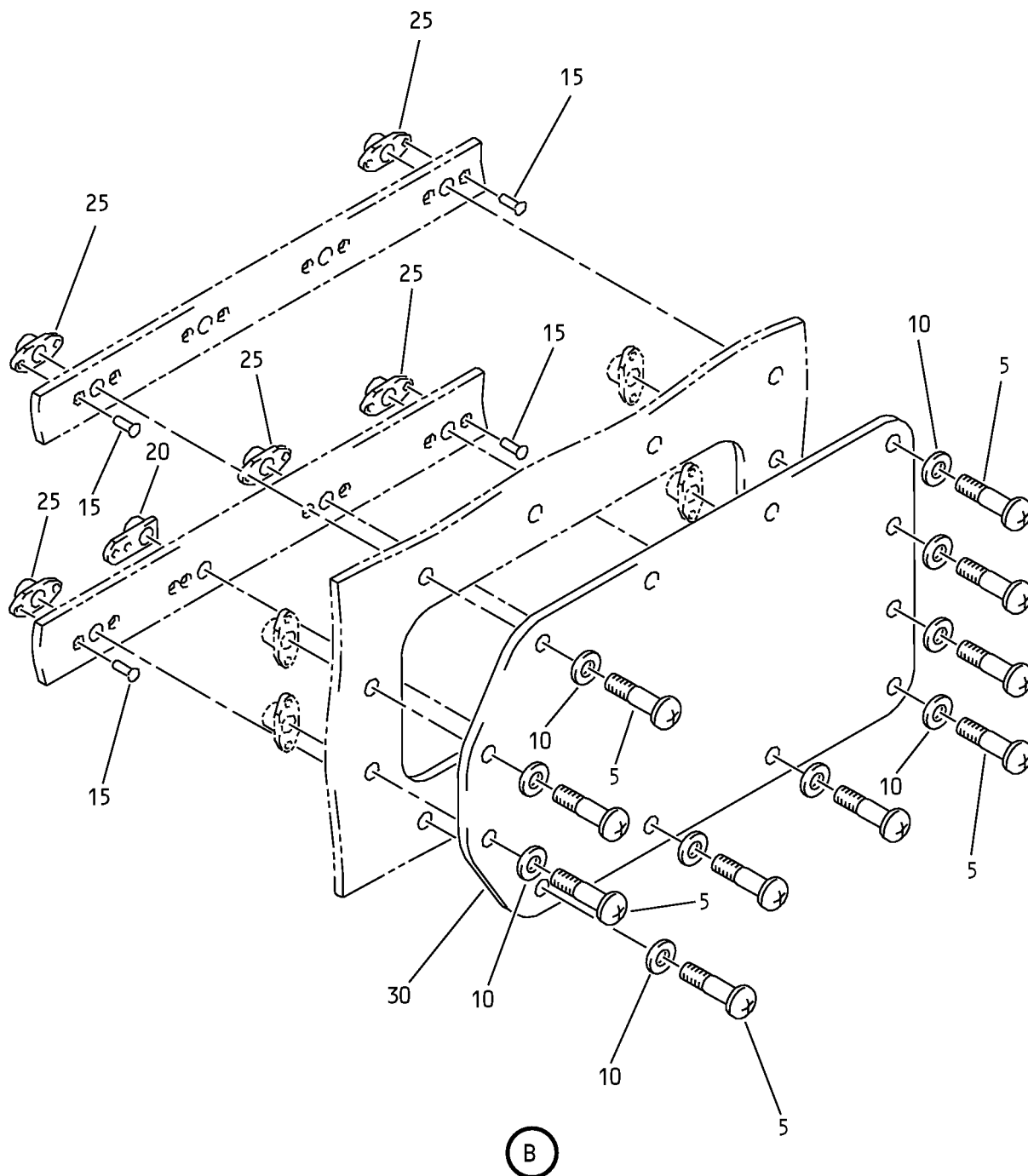
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Aft Entry Door Assembly  
IPL Figure 2 (Sheet 2 of 19)

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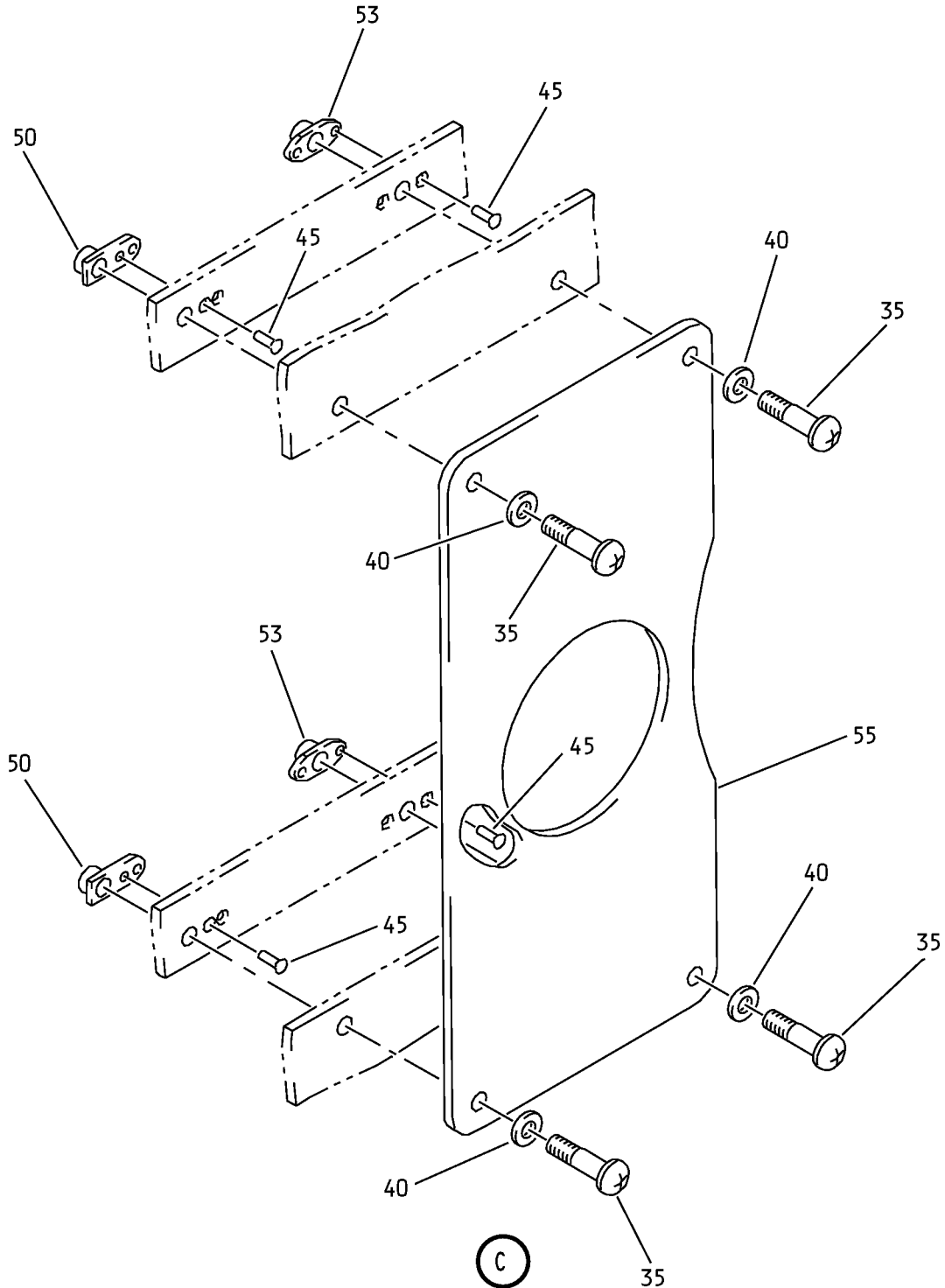
COMPONENT MAINTENANCE MANUAL



Aft Entry Door Assembly  
IPL Figure 2 (Sheet 3 of 19)

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Aft Entry Door Assembly  
IPL Figure 2 (Sheet 4 of 19)

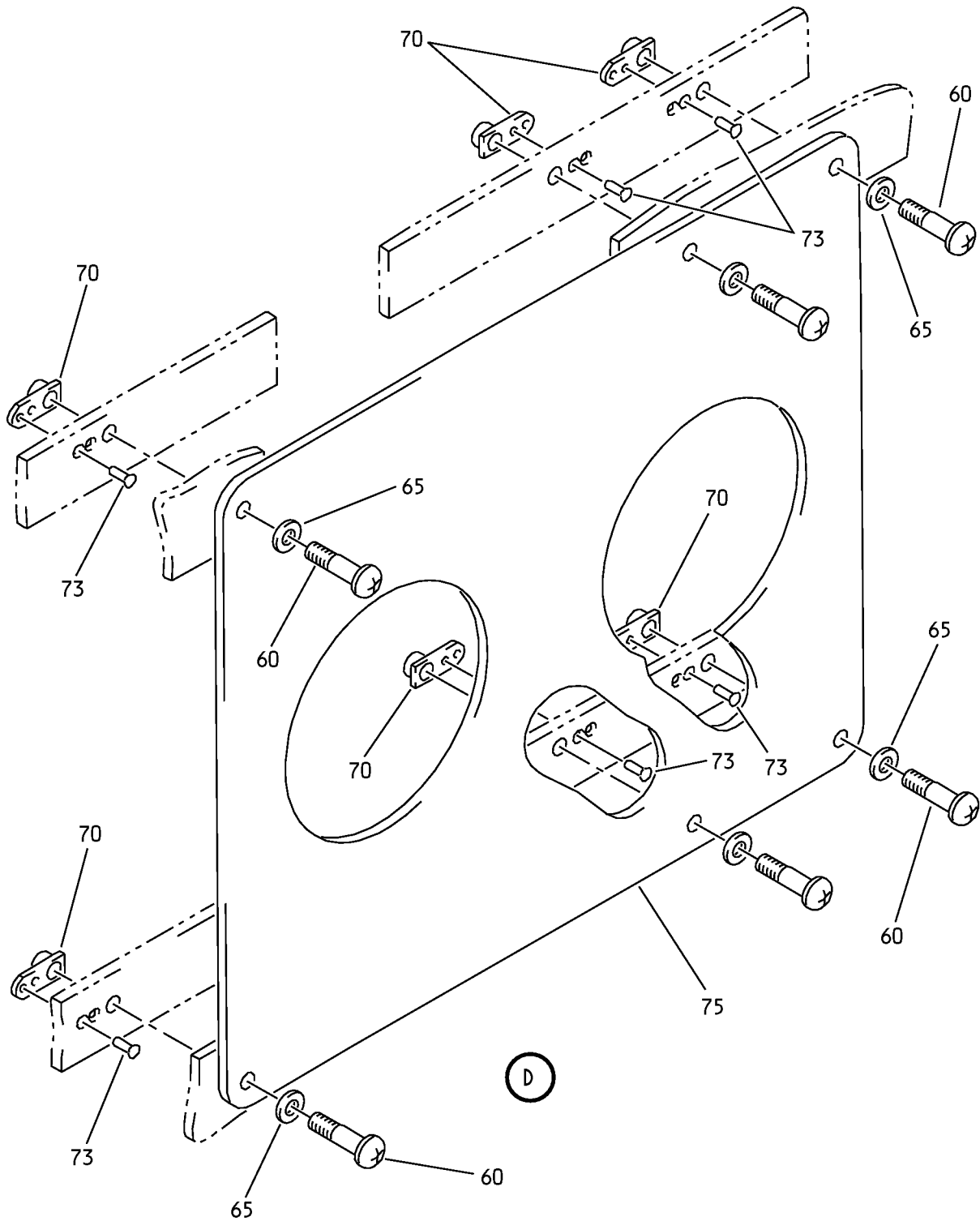
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Aft Entry Door Assembly  
IPL Figure 2 (Sheet 5 of 19)

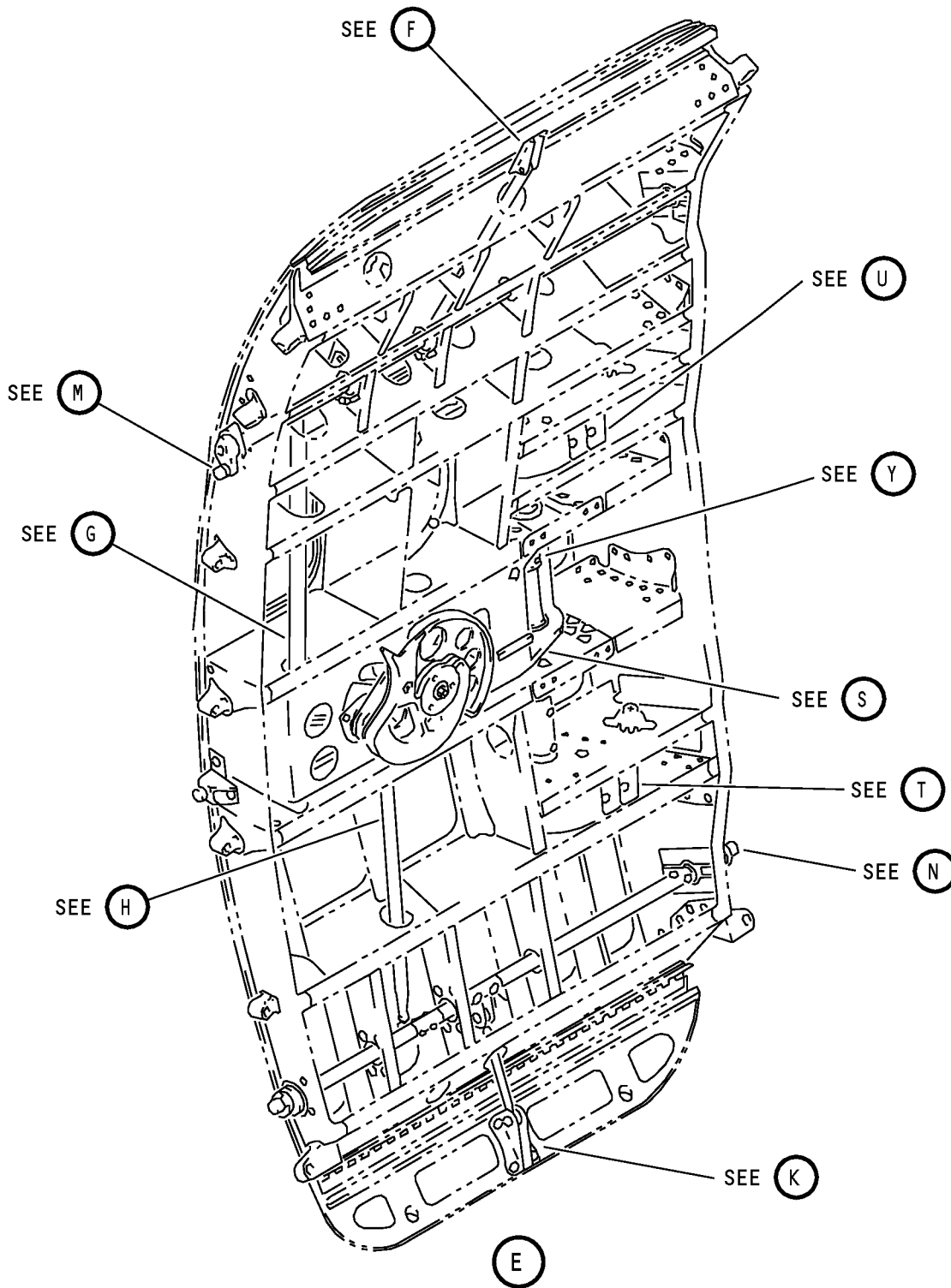
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Aft Entry Door Assembly  
IPL Figure 2 (Sheet 6 of 19)

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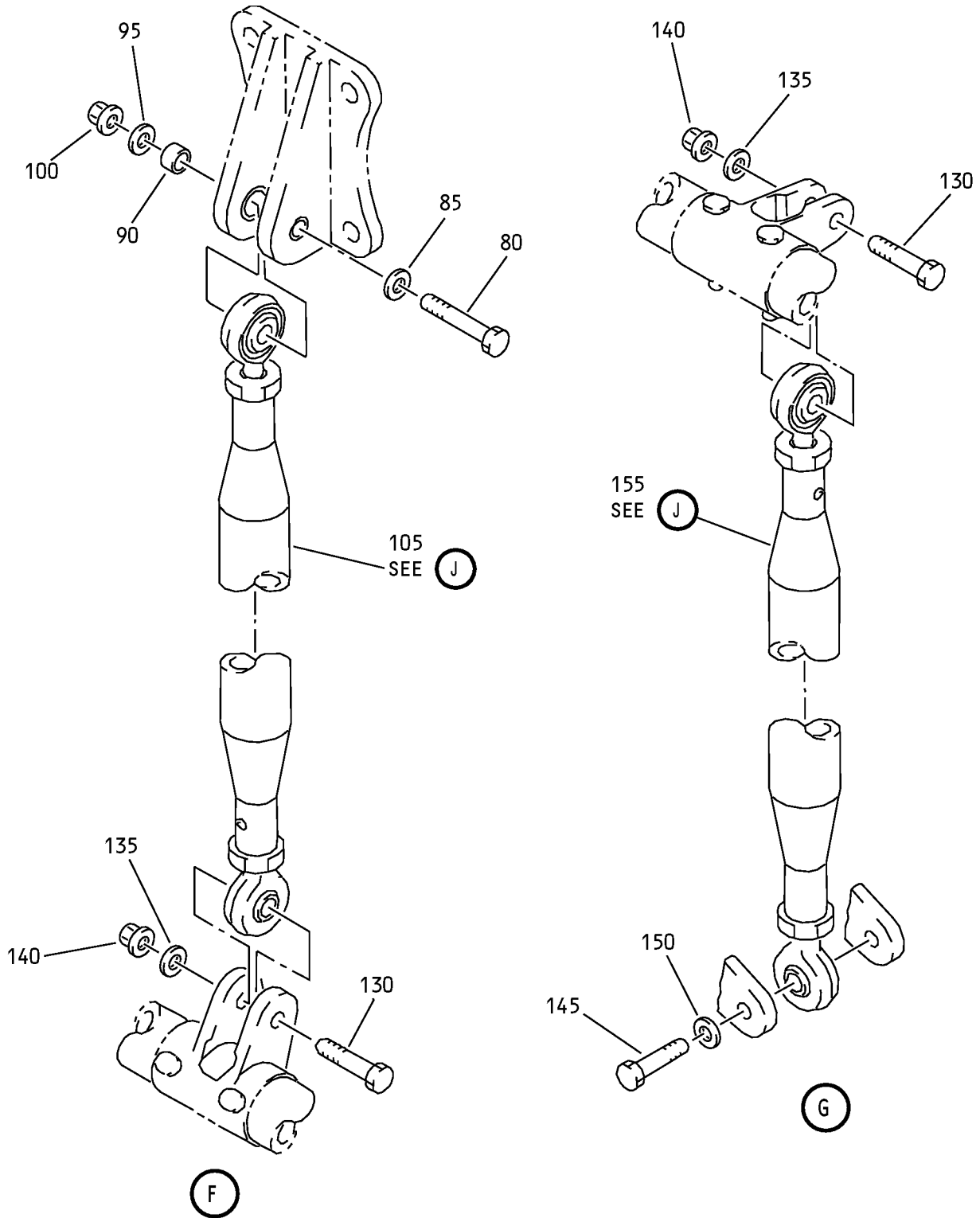
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Aft Entry Door Assembly  
IPL Figure 2 (Sheet 7 of 19)

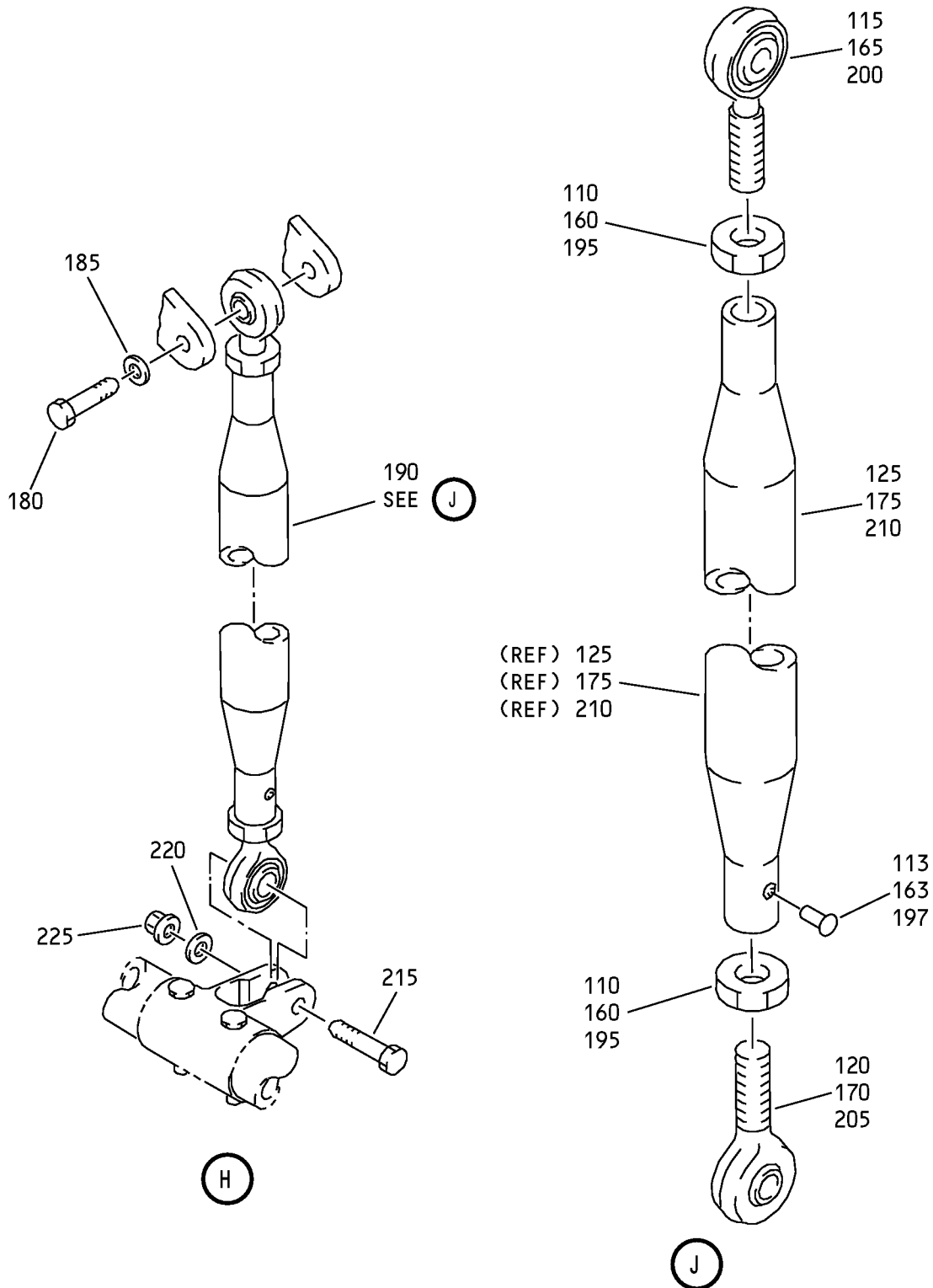
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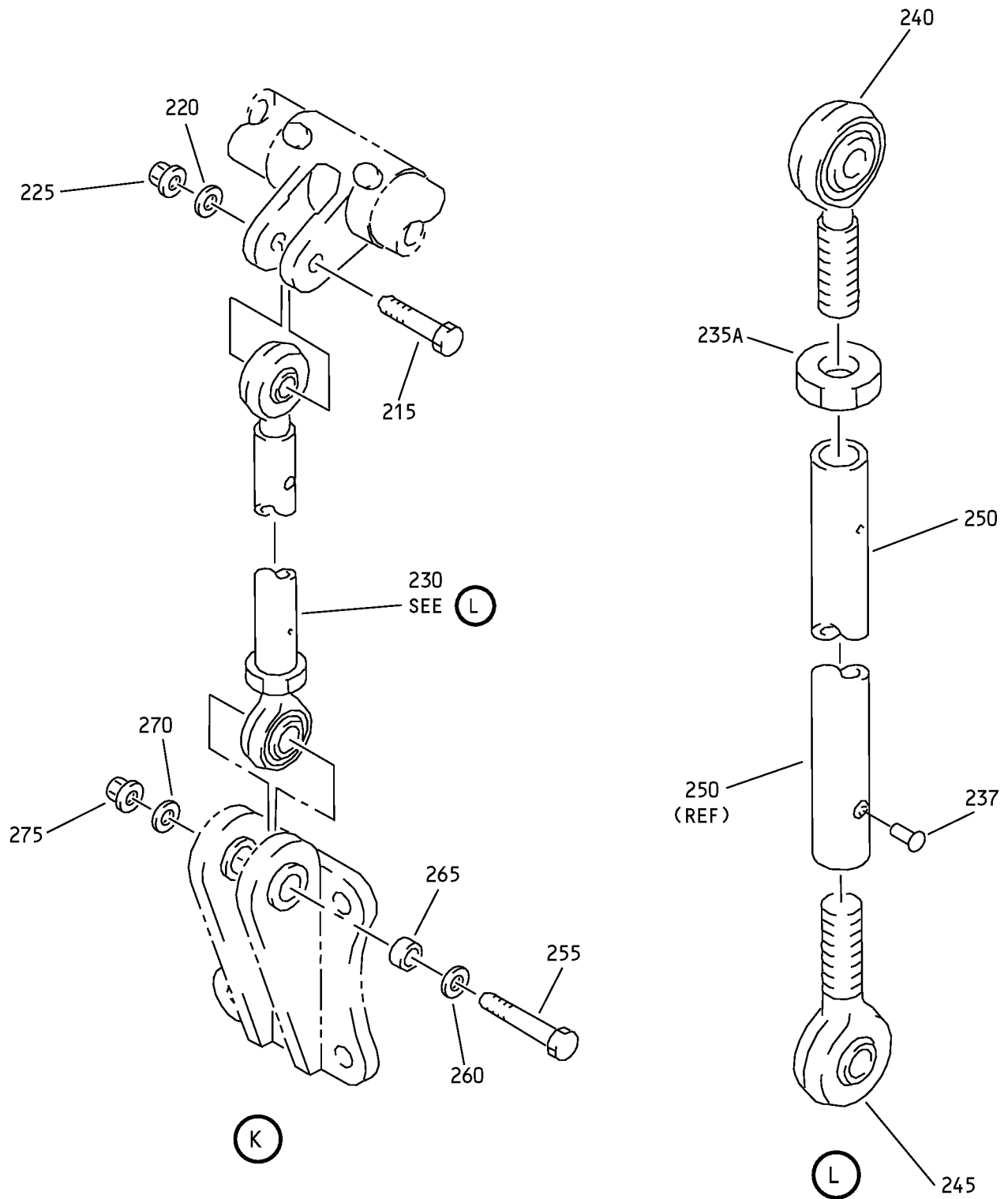
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Aft Entry Door Assembly  
IPL Figure 2 (Sheet 8 of 19)

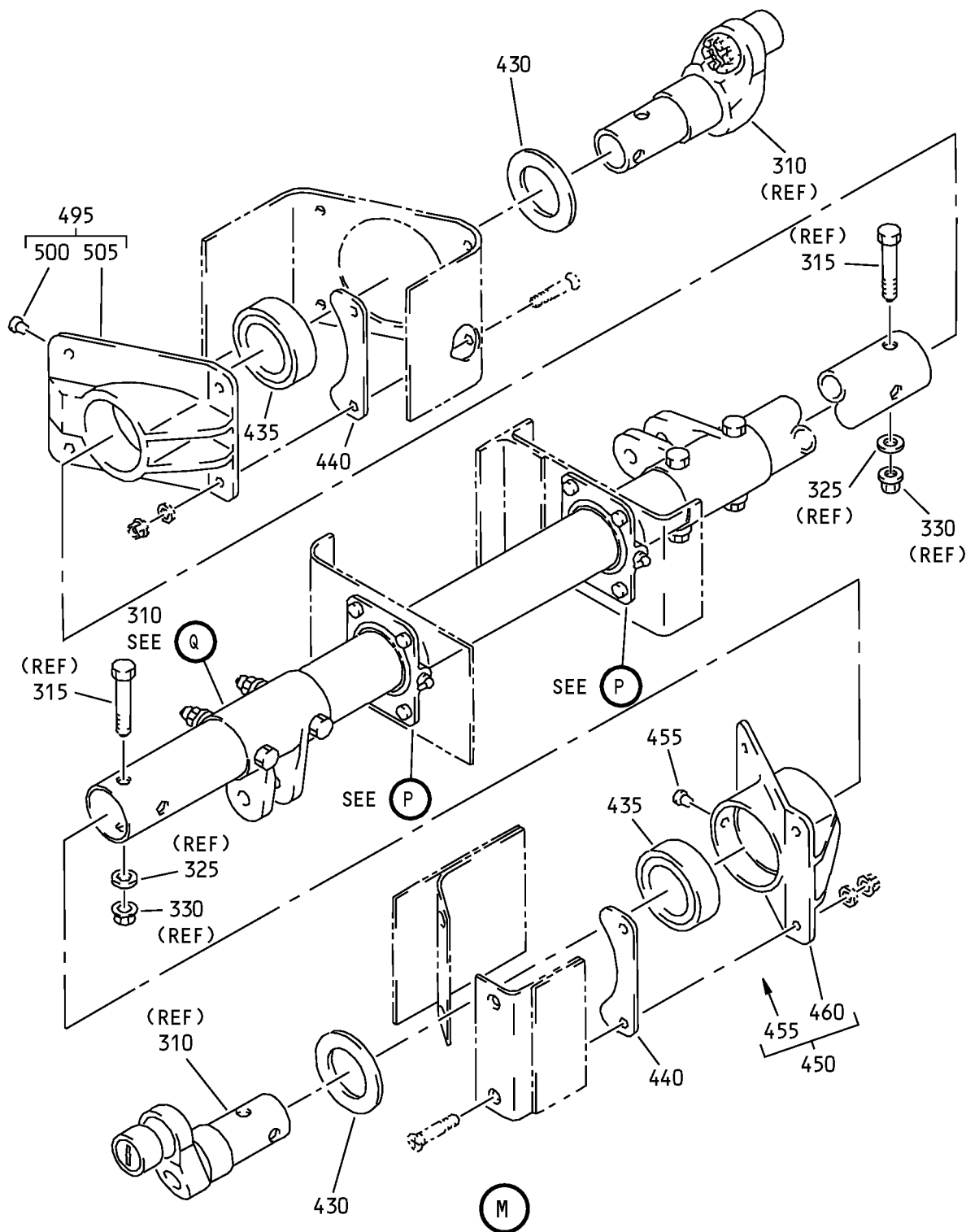
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Aft Entry Door Assembly  
IPL Figure 2 (Sheet 9 of 19)

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Aft Entry Door Assembly  
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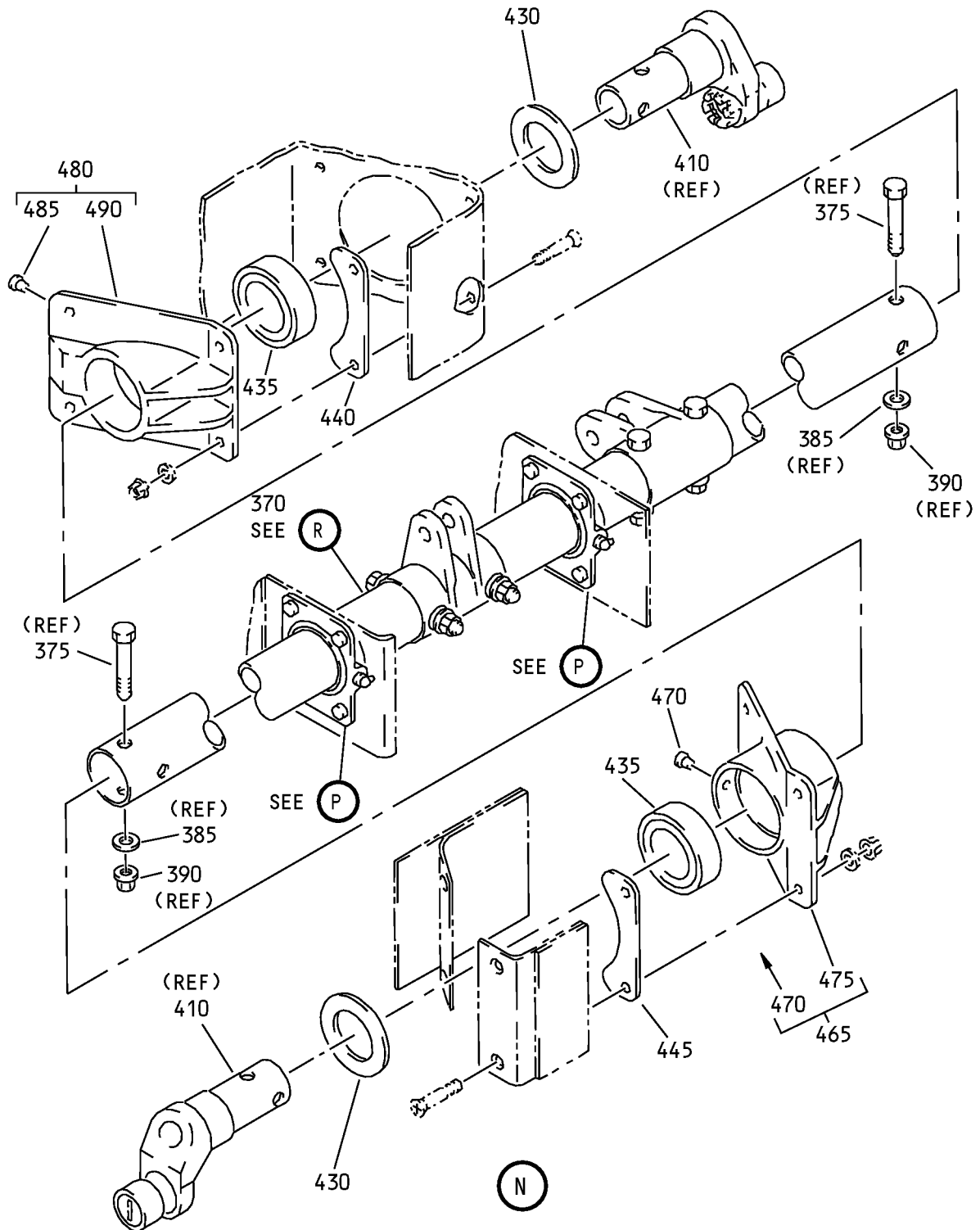
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Aft Entry Door Assembly  
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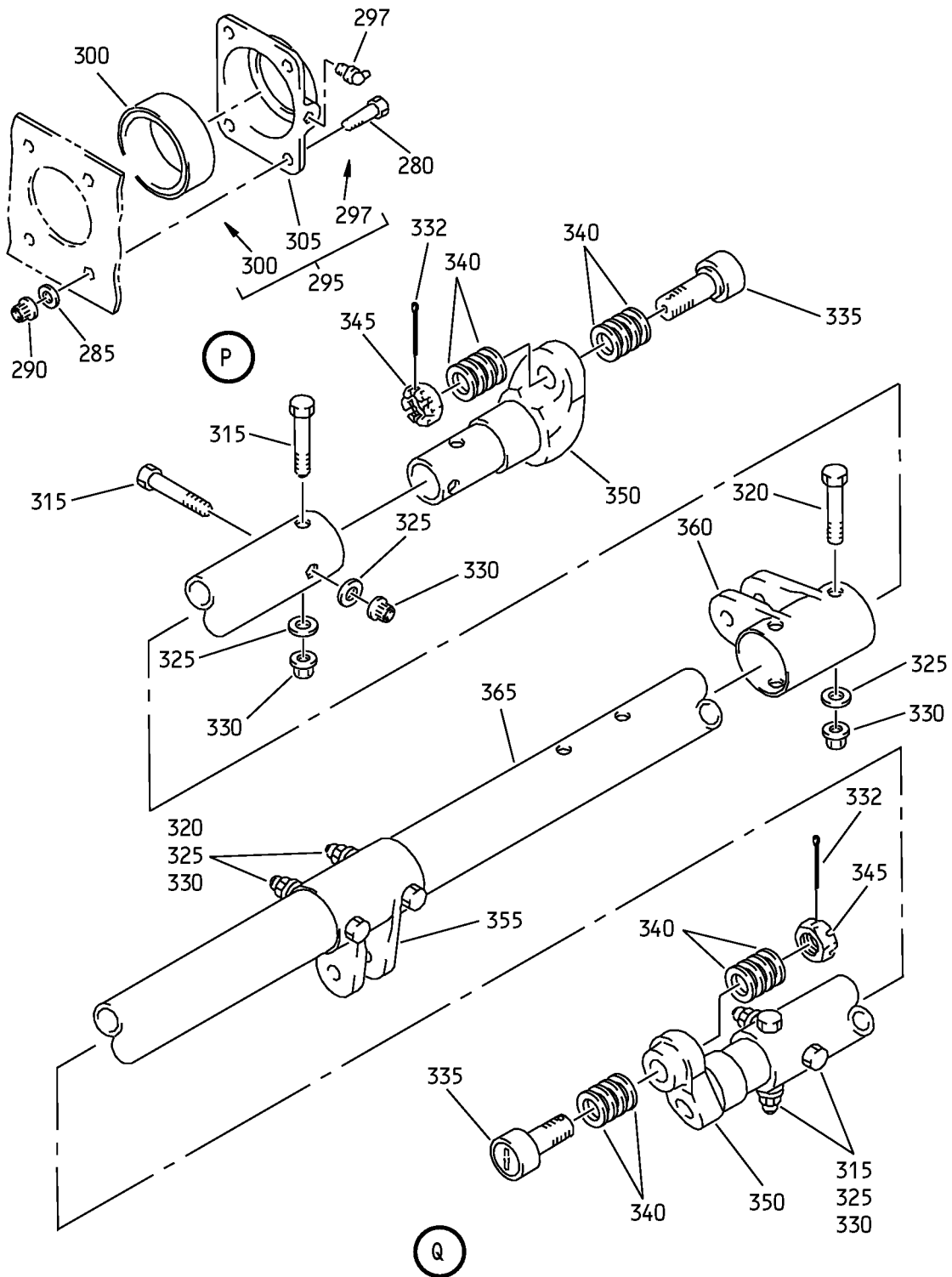
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Aft Entry Door Assembly  
IPL Figure 2 (Sheet 12 of 19)

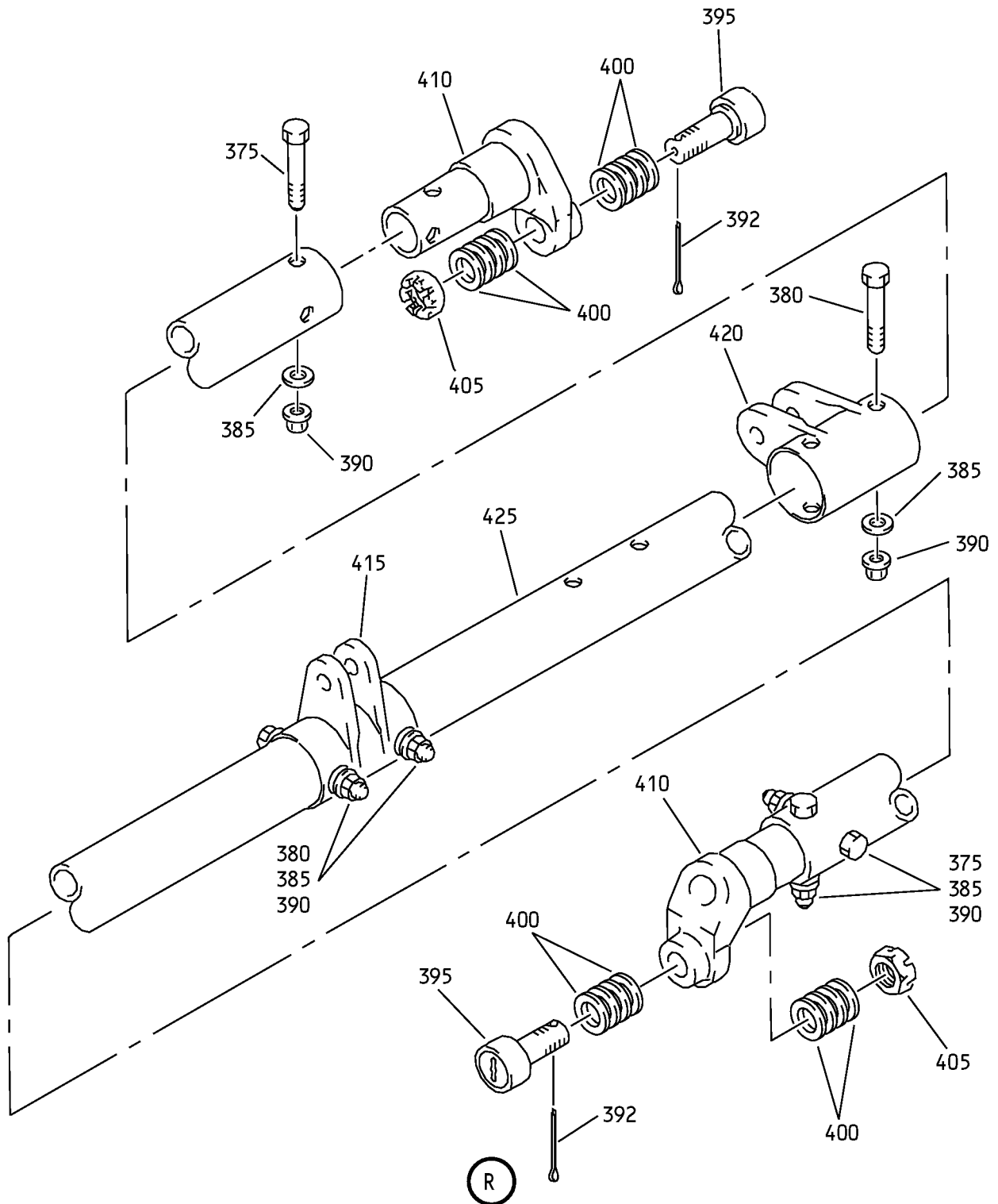
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Aft Entry Door Assembly  
IPL Figure 2 (Sheet 13 of 19)

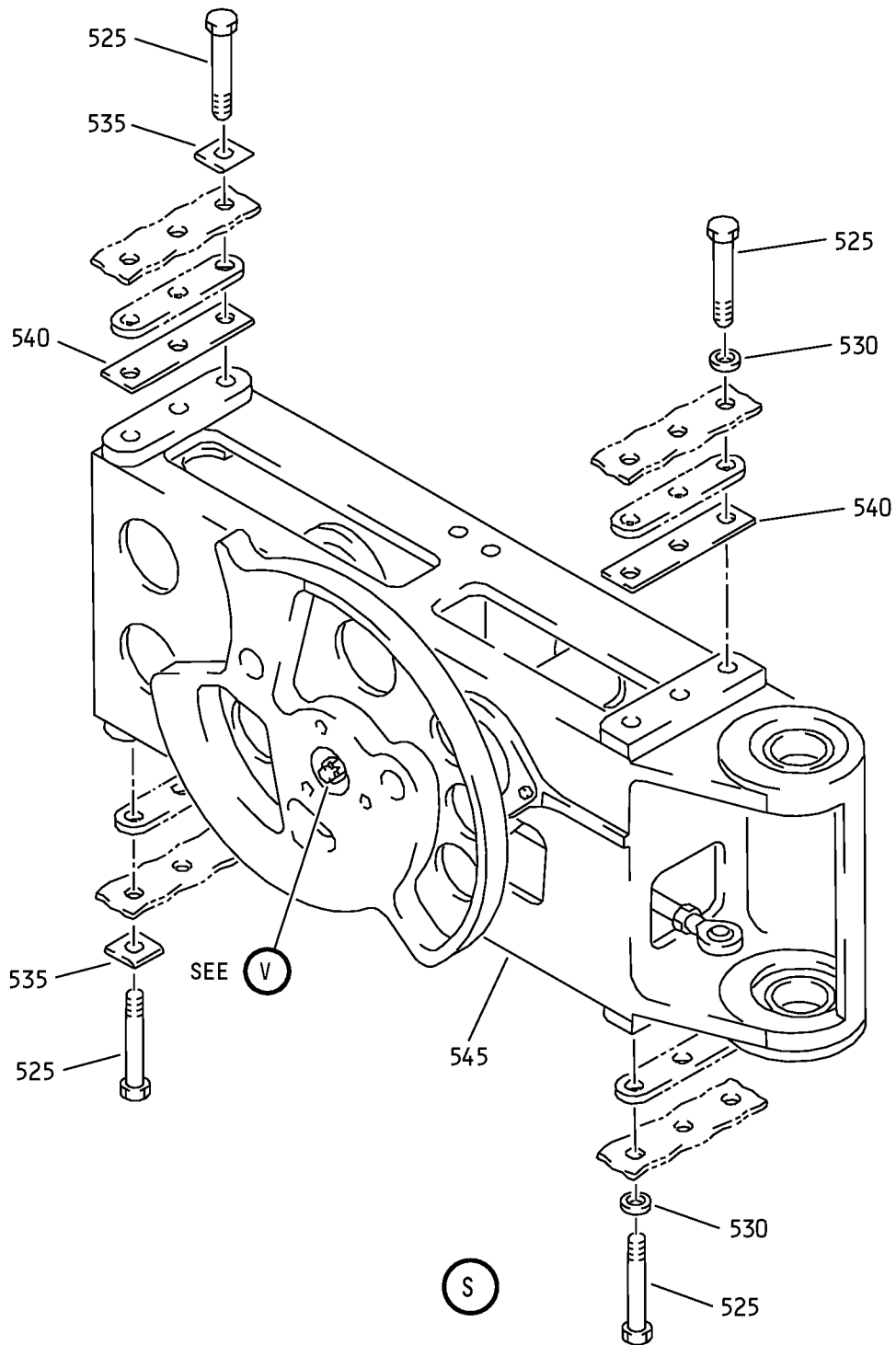
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Aft Entry Door Assembly  
IPL Figure 2 (Sheet 14 of 19)

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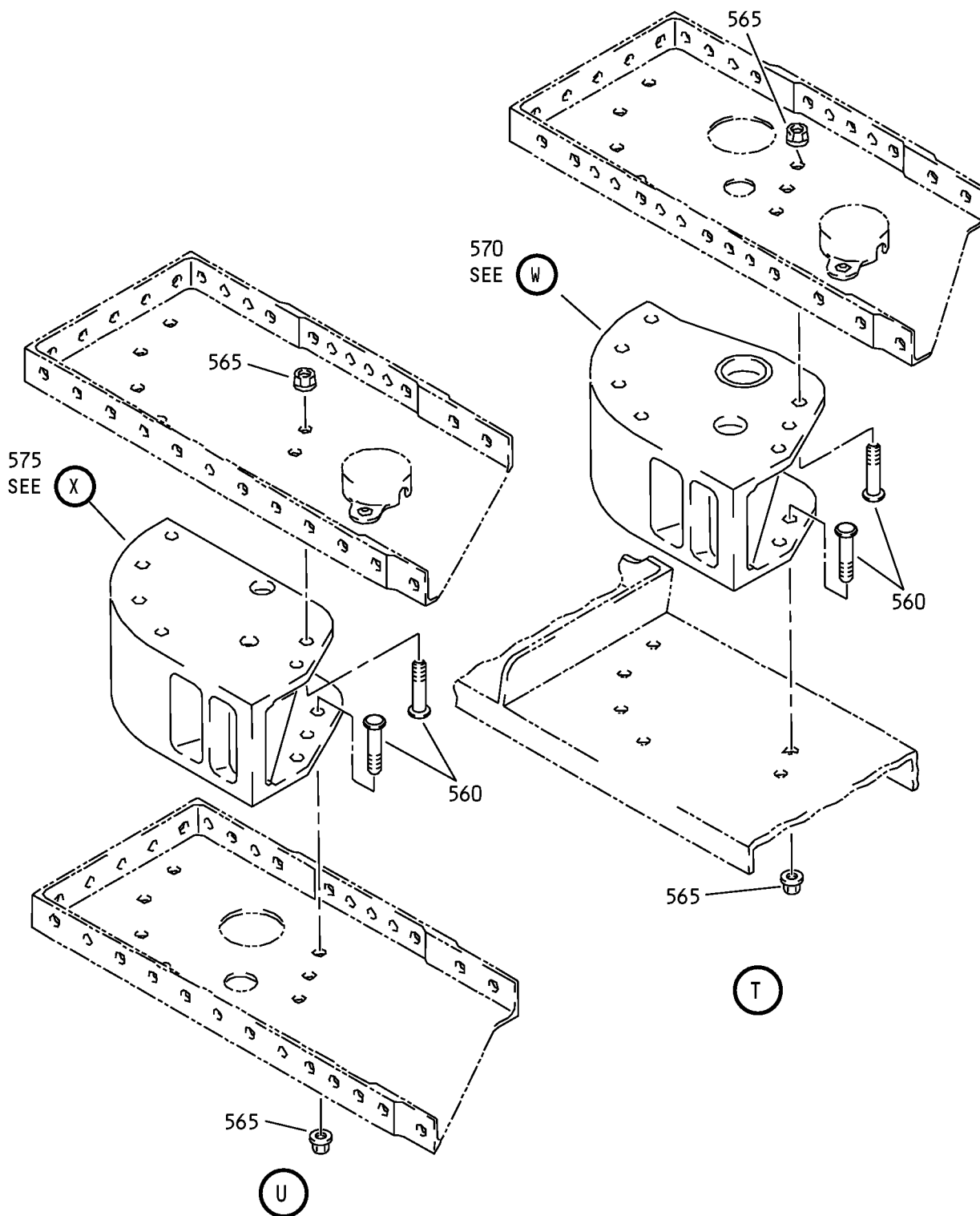
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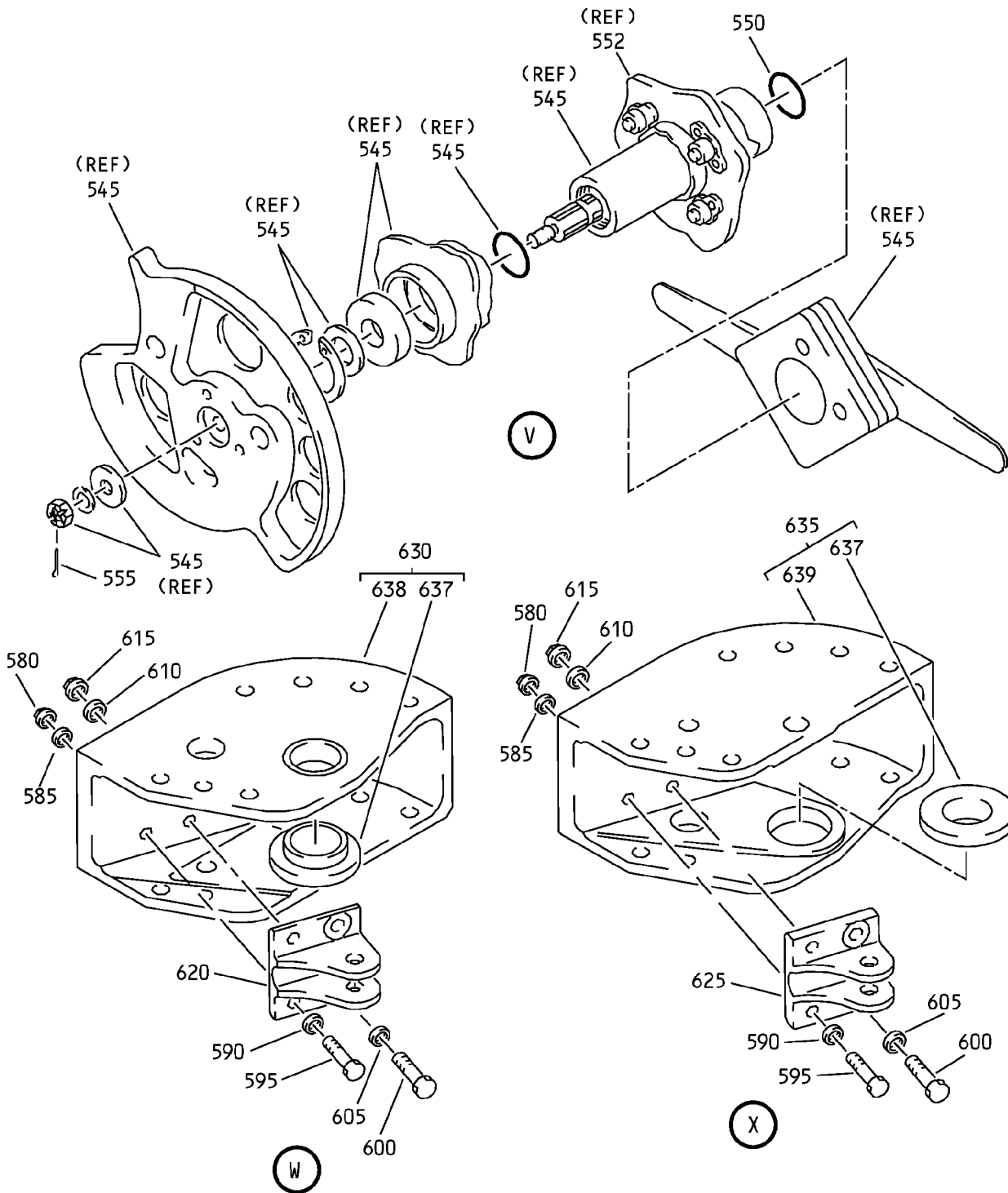


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Aft Entry Door Assembly  
IPL Figure 2 (Sheet 15 of 19)

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Aft Entry Door Assembly  
IPL Figure 2 (Sheet 16 of 19)

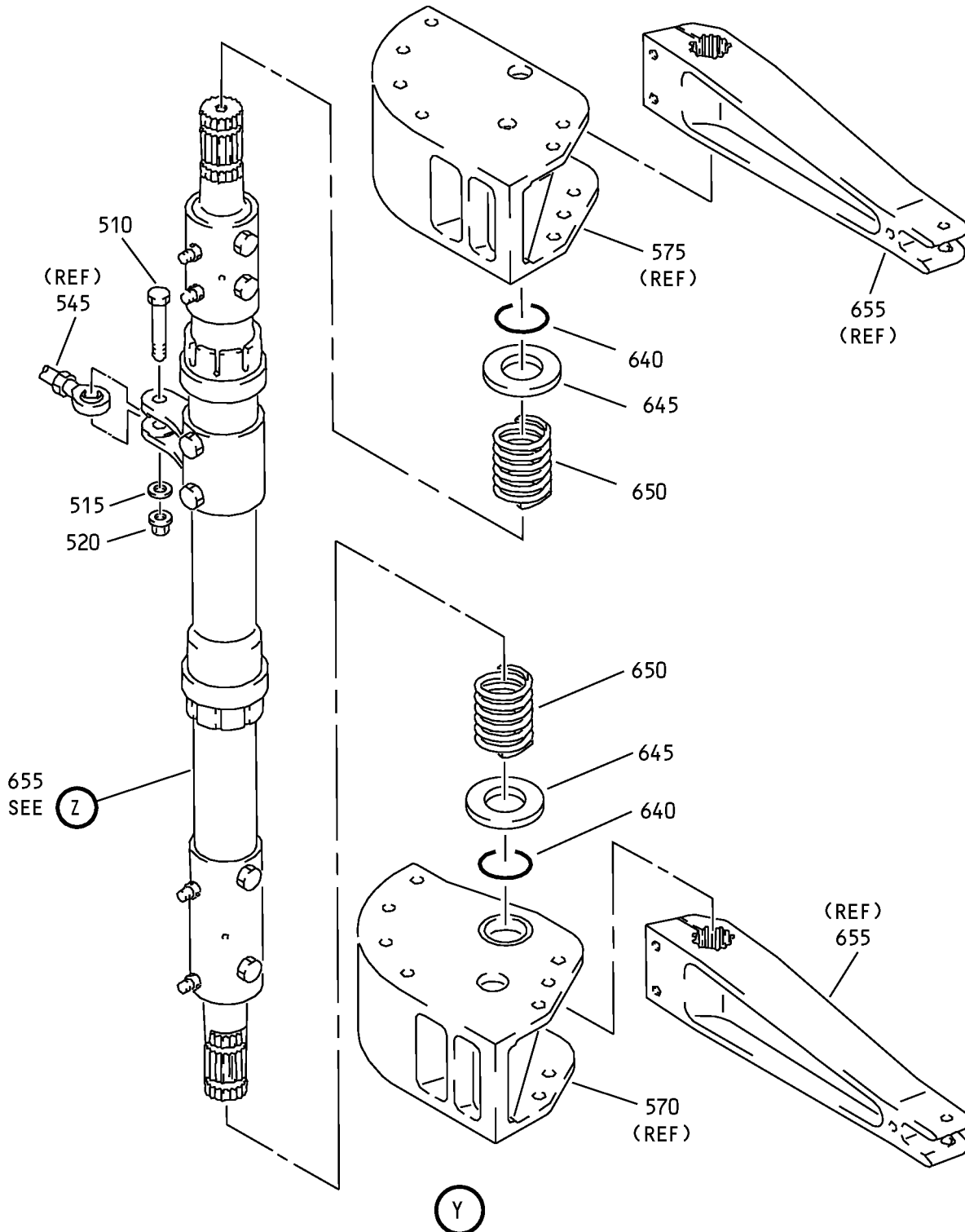
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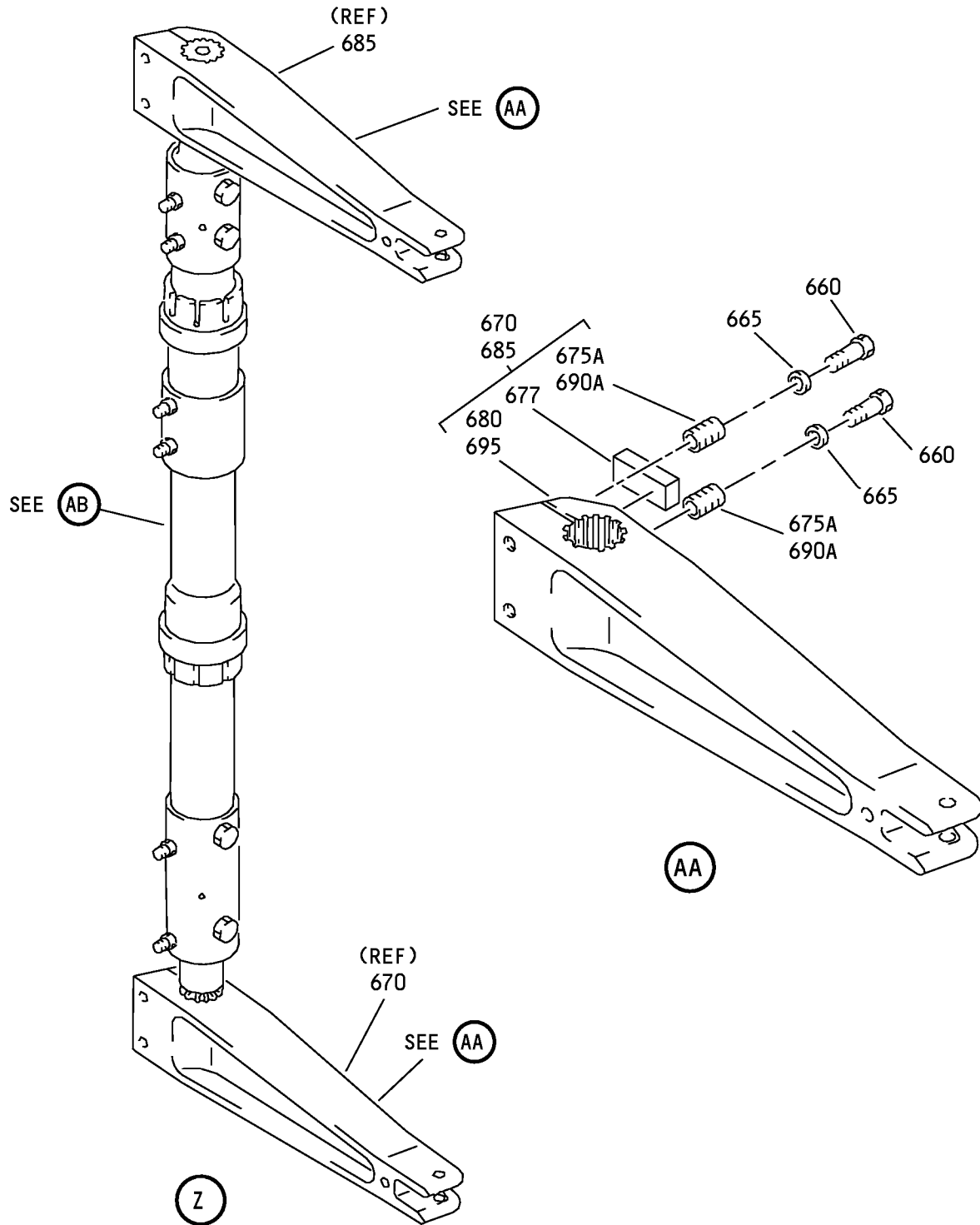
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Aft Entry Door Assembly  
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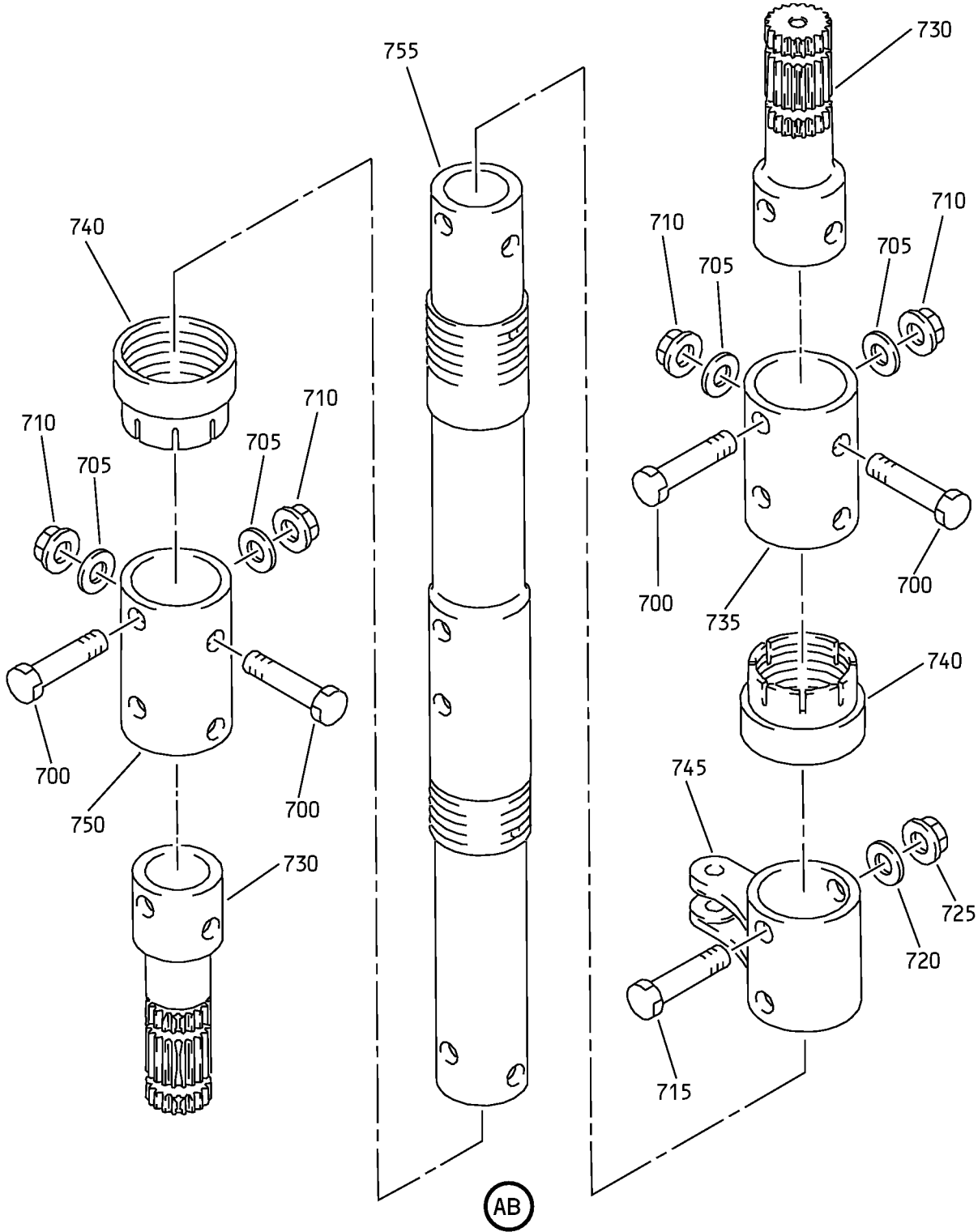


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Aft Entry Door Assembly  
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Aft Entry Door Assembly  
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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
2-											
-1	147A6116-1									A	RF
-1A	147A6116-2									B	RF
-1B	147A6116-3									C	RF
-1C	147A6116-6										
-1D	147A6116-7										
-1E	147A6116-8										
-1F	147A6116-9										
-1G	147A6116-10									H	RF
-1H	147A6116-11									J	RF
-1J	147A6116-4									K	RF
-1K	147A6116-5									L	RF
-1L	147A6116-12									M	RF
-1M	147A6116-13									N	RF
-1N	147A6116-14									D	RF
-1P	147A6116-15									E	RF

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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		
2-											
-1Q	147A6116-16									F	RF
-1R	147A6116-17									G	RF
-1S	147A6116-18									P	RF
-1T	147A6116-19									Q	RF
-1U	147A6116-20									R	RF
-1V	147A6116-21									S	RF
-1W	147A6116-22									T	RF
-1X	147A6116-23									U	RF
-1Y	147A6116-24									V	RF
-1Z	147A6116-26									W	RF
-2	147A6116-27									X	RF
-2A	147A6116-28									Y	RF
-2B	147A6116-29									Z	RF
5	BACB30NT3K3									A-S	24

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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-											
-5A	BACB30NT3K4		.	B	O	L	T			T-Z	24
10	BACW10CT6J		.	W	A	S	H	E	R		24
15	BACR15GE3CW2		.	R	I	V	E	T			32
20	NS202494-02-2		.	N	U	T	P	L	A		1
				(V80539)							
				(SPEC BACN10KE3E2CD)							
				(OPT 102F9216-2-3 (V72962))							
				(OPT F51751-3-2CD (V15653))							
				(OPT BRFR120C3-2D (V52828))							
25	NS202493-02-2		.	N	U	T	P	L	A		15
				(V80539)							
				(SPEC BACN10KE3B2CD)							
				(OPT F51747-3-2CD (V15653))							
				(OPT 102A9213-2-3 (V72962))							
				(OPT BRFR220C3-2D (V52828))							
30	141A6553-4		.	P	L	A	T	E	-	C	2
35	BACB30NT3K3		.	B	O	L	T			A-S	4
-35A	BACB30NT3K4		.	B	O	L	T			T-Z	4
40	BACW10CT6J		.	W	A	S	H	E	R		4
45	BACR15GE3CW2		.	R	I	V	E	T			8
50	NS202494-02-2		.	N	U	T	P	L	A		2
				(V80539)							
				(SPEC BACN10KE3E2CD)							
				(OPT 102F9216-2-3 (V72962))							
				(OPT F51751-3-2CD (V15653))							
				(OPT BRFR120C3-2D (V52828))							
53	NS202493-02-2		.	N	U	T	P	L	A		2
				(V80539)							
				(SPEC BACN10KE3B2CD)							
				(OPT F51747-3-2CD (V15653))							
				(OPT 102A9213-2-3 (V72962))							
				(OPT BRFR220C3-2D (V52828))							
55	141A6553-2		.	P	L	A	T	E	-	C	1
60	BACB30NT3K3		.	B	O	L	T			A-S	6
-60A	BACB30NT3K4		.	B	O	L	T			T-Z	6
65	BACW10CT6J		.	W	A	S	H	E	R		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- 70	NS202494-02-2		.	NUTPLATE							6
				(V80539)							
				(SPEC BACN10KE3E2CD)							
				(OPT 102F9216-2-3 (V72962))							
				(OPT F51751-3-2CD (V15653))							
				(OPT BRFR120C3-2D (V52828))							
73	BACR15BA3AD		.	RIVET							12
				(SIZE DETERMINED ON INST)							
75	141A6553-3		.	PLATE-COVER							1
80	BACB30NM4K17		.	BOLT							1
85	BACW10BN4AC		.	WASHER							1
90	BACB28AK04-030		.	BUSHING							1
95	NAS1149D0463J		.	WASHER							1
100	H52732-4CD		.	NUT							1
				(V15653)							
				(SPEC BACN10YR4CD)							
				(OPT PLH54CD (V62554))							
105	65-28925-87		.	ROD ASSY							1
110	AN316-5R		. .	NUT-CHECK							2
113	MS20470D3		. .	RIVET							1
				(SIZE DETERMINED ON INST)							
115	AB4E27FN		. .	BEARING							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))							

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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-											
120	10E4-116NW		. . BEARING (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))							1	
125	65-28925-58		. . ROD								1
130	BACB30NM4K13		. BOLT								2
135	NAS1149E0432R		. WASHER								2
140	H52732-4CM		. NUT (V15653) (SPEC BACN10YR4CM) (OPT PLH54CM (V62554))								2
145	BACB30NR4K12		. BOLT								1
150	BACW10BN4AC		. WASHER								1
155	65-28925-85		. ROD ASSY						A-C, E, F, H-N		1
-155A	65-28925-100		. ROD ASSY						D, G, P-Z		1
160	AN316-5R		. . NUT-CHECK								2
163	MS20470D3		. . RIVET (SIZE DETERMINED ON INST)								1
165	AB4E27FN		. . BEARING (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))						A-C, E, F, H-N		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- -165A	10E4-116NW		.	.						D, G, P-Z	1
170	10E4-116NW		.	.							1
175	65-28925-47		.	.						A-C, E, F, H-N	1
-175A	65-28925-104		.	.						D, G, P-Z	1
180	BACB30NR4K12		.								1
185	BACW10BN4AC		.								1
190	65-28925-86		.							A-C, E, F, H-N	1
-190A	65-28925-101		.							D, G, P-Z	1
195	AN316-5R		.	.							2
197	MS20470D3		.	.						A-C, E, F, H-N	1
-197A	BACR15BB3DC		.	.						D, G, P-Z	1

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FIG/ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE	USAGE CODE	UNITS PER ASSY	
						1
2-200	AB4E27FN		. . BEARING (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))	A-C, E, F, H-N	1	
-200A	10E4-116NW		. . BEARING (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))	D, G, P-Z	1	
205	10E4-116NW		. . BEARING (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))		1	
210	65-28925-48		. . ROD	A-C, E, F, H-N	1	
-210A	65-28925-105		. . ROD	D, G, P-Z	1	
215	BACB30NM4K13		. BOLT		2	
220	NAS1149E0432R		. WASHER		2	
225	H52732-4CM		. NUT (V15653) (SPEC BACN10YR4CM) (OPT PLH54CM (V62554))		2	

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
2-											
230	69-18187-26								. ROD ASSY-CONT		1
235	AN316-54								DELETED		
235A	AN316-5R								. . NUT-CHECK		1
237	MS20470D5								. . RIVET (SIZE DETERMINED ON INST)		1
240	AB4E27FN								. . BEARING-ROD END (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)) (OPT ITEM 240A)		1
-240A	AB4E27FN12								. . BEARING (V15860) (SPEC BACB10A187M2L) (OPT BRE4795L (V81376)) (OPT HB4E140 (V02758)) (OPT KB4ESSD6FN (V97613)) (OPT MXJ45-14BFG2 (V73134)) (OPT 5164-0402DD (V09455)) (OPT AR4E4FN12 (VS0352)) (OPT ASM4F6DM (V56644)) (OPT ITEM 240)		1
245	10E4-116NW								. . BEARING (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))		1
250	66-14618-7								. . ROD		1
255	BACB30NM4K17								. BOLT		1
260	BACW10BN4AC								. WASHER		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	BACB28AK04-030		.	BUSHING							1
270	NAS1149D0463J		.	WASHER							1
275	H52732-4CD		.	NUT							1
				(V15653)							
				(SPEC BACN10YR4CD)							
				(OPT PLH54CD (V62554))							
280	BACB30NM3K3		.	BOLT							16
285	NAS1149D0332J		.	WASHER							16
290	H52732-3CD		.	NUT							16
				(V15653)							
				(SPEC BACN10YR3CD)							
				(OPT PLH53CD (V62554))							
295	65-2306-9		.	HOUSING ASSY							4
297	MS15001-4		. .	FITTING							1
300	ASSB16-19		. .	BEARING							1
				(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))							
305	65-2306-10		. .	HOUSING							1
310	147A6139-3		.	TUBE ASSY-TORQUE							1
315	BACB30NM3K17		. .	BOLT							4
320	BACB30NM3K19		. .	BOLT							4
325	NAS1149C0332R		. .	WASHER							8
330	H52732-3CM		. .	NUT							8
				(V15653)							
				(SPEC BACN10YR3CM)							
				(OPT PLH53CM (V62554))							
332	BACP18BC02A06P		. .	PIN-COTTER							2

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
2-											
335	HRSC3CFR9		. .	BEARING							2
				(V60380)							
				(SPEC BACB10FK5F9HS)							
				(OPT CHRS3CFR9 (V92563))							
				(OPT CHRS3CFR9 (V07484))							
340	NAS1149D0516J		. .	WASHER							16
345	BACN10JD105CD		. .	NUT							2
350	69-37418-11		. .	CRANK							2
355	66-14531-12		. .	CRANK-LWR UPR GATE							1
360	66-14530-5		. .	CRANK-UPR LATCH							1
365	60-4406-16		. .	TUBE-LATCH TORQUE							1
370	147A6139-1		. .	TUBE ASSY-TORQUE							1
375	BACB30NM3K17		. .	BOLT							4
380	BACB30NM3K19		. .	BOLT							4
-380C	65-73978-21			DELETED							
385	NAS1149C0332R		. .	WASHER							8
390	H52732-3CM		. .	NUT							8
				(V15653)							
				(SPEC BACN10YR3CM)							
				(OPT PLH53CM (V62554))							
392	BACP18BC02A06P		. .	PIN-COTTER							2
395	HRSC3CFR9		. .	BEARING							2
				(V60380)							
				(SPEC BACB10FK5F9HS)							
				(OPT CHRS3CFR9 (V92563))							
				(OPT CHRS3CFR9 (V07484))							
400	NAS1149D0516J		. .	WASHER							16
405	BACN10JD105CD		. .	NUT							2
410	69-37418-11		. .	CRANK							2
415	66-14531-12		. .	CRANK-LWR UPR GATE							1
420	66-14531-13		. .	CRANK-LWR LATCH							1
425	60-4406-17		. .	TUBE-LATCH TORQUE							1
430	66-15332-1		. .	SPACER-ROLLER LATCH					A-Q		4
-430A	66-15332-1		. .	SPACER-ROLLER LATCH					R-Z		4
				(OPT ITEM 430B)							

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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-											
-430B	149A6101-1		.	SPACER-ROLLER LATCH (OPT ITEM 430A)					R-Z		4
435	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))							4
440	147A6120-1		.	SHIM							3
445	147A6120-2		.	SHIM							1
450	147A6138-7		.	FITTING ASSY					A-C, K, L		1
-450A	147A6138-23		.	FITTING ASSY					D-J, M-X		1
-450B	147A6138-31		.	FITTING ASSY					Y, Z		1
455	NAS516-1A		. .	FITTING-GREASE							1
460	147A6138-15		. .	FITTING					A-C, K, L		1
-460A	147A6138-21		. .	FITTING					D-J, M-X		1
-460B	147A6138-29		. .	FITTING					Y, Z		1
465	147A6138-3		.	FITTING ASSY					A-C, K, L		1
-465A	147A6138-19		.	FITTING ASSY					D-J, M-X		1
-465B	147A6138-27		.	FITTING ASSY					Y, Z		1
470	NAS516-1A		. .	FITTING-GREASE							1
475	147A6138-11		. .	FITTING					A-C, K, L		1
-475A	147A6138-17		. .	FITTING					D-J, M-X		1
-475B	147A6138-25		. .	FITTING					Y, Z		1
480	147A6138-1		.	FITTING ASSY							1
485	NAS516-1A		. .	FITTING							1
490	147A6138-9		. .	FITTING							1
495	147A6138-5		.	FITTING ASSY							1
500	NAS516-1A		. .	FITTING-GREASE							1
505	147A6138-13		. .	FITTING							1

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2-					
510	BACB30NM5K16		. BOLT		1
515	NAS1149E0563R		. WASHER		1
520	H52732-5CM		. NUT (V15653) (SPEC BACN10YR5CM) (OPT PLH55CM (V62554))		1
525	BACB30NM4K19		. BOLT		12
530	BACW10BN4AC		. WASHER		6
535	BACF3H06JK006HN		. FILLER		6
540	BACS40R008C042F		. SHIM		2
545	147A6121-2		. BOX ASSY-HANDLE (FOR DETAILS SEE FIG. 3)		1
550	M83461-1-325		. PACKING		1
555	BACP18BC03A08P		. PIN-COTTER		1
560	HST10AG6-4		. BOLT (V06725) (SPEC BACB30VT6K4) (OPT HST10AG6-4 (V73197)) (OPT HST10AG6-4 (V56878)) (OPT HST10AG6-4 (V0PTK6))		26
565	BACN10ZV		. NUT		26
570	147A6140-1		. SUPPORT ASSY-HINGE		1
575	147A6140-3		. SUPPORT ASSY-HINGE		1
580	NAS1805-3L		. . NUT		2
585	NAS620A10L		. . WASHER		2
590	BACW10CT6J		. . WASHER		2
595	BACB30NM3K11		. . BOLT (V06710) (SPEC BACB30NM3K11)		2
600	BACB30NM4K11		. . BOLT		2
605	BACW10BN4AC		. . WASHER		2
610	BACW10BN4AP		. . WASHER		2
615	NAS1805-4L		. . NUT		2
620	147A6162-1		. . FITTING (USED ON ITEM 570)		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-											
625	69-70268-2			. .	FITTING						1
					(FOR SPARES PROCURE 69-70268U2)						
					(USED ON ITEM 575)						
630	147A6140-5			. .	SUPPORT ASSY						1
					(USED ON ITEM 570)						
635	147A6140-6			. .	SUPPORT ASSY						1
					(USED ON ITEM 575)						
637	NAS76A16-016P			. . .	BUSHING						1
638	147A6140-7			. . .	SUPPORT						1
					(USED ON ITEM 630)						
639	147A6140-8			. . .	SUPPORT						1
					(USED ON ITEM 635)						
640	M83461-1-214			. .	PACKING						2
645	NAS1149C1790R			. .	WASHER						2
650	66-15645-1			. .	SPRING-COMPRESSION						2
655	147A6117-1			. .	TUBE ASSY-TORQUE				A, B		1
-655A	147A6117-2			. .	TUBE ASSY-TORQUE				C		1
-655B	147A6117-3			. .	TUBE ASSY-TORQUE				J-L		1
-655C	147A6117-4			. .	TUBE ASSY-TORQUE				D-H, M-Z		1
660	BACB30NM3K11			. .	BOLT						4
					(V06710)						
					(SPEC BACB30NM3K11)						
665	BACW10BP3CD			. .	WASHER						4
670	65-73978-1			. .	ARM ASSY				A-C		1
-670A	65-73978-15			. .	ARM ASSY				J-L		1
-670B	65-73978-19			. .	ARM ASSY				D-H, M-Z		1
-675	BACS13W3CN3				DELETED						
675A	NASM21209F1-15			. . .	INSERT						4
677	65-73978-23			. . .	FILLER				D-H, M-Z		1
680	65-73978-3			. . .	ARM				A-C		1
					(OPT ITEM 680A)						
-680A	65-73978-13			. . .	ARM				A-C		1
					(OPT ITEM 680)						
-680B	65-73978-17			. . .	ARM				J-L		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-											
-680C	65-73978-21								. . . ARM	D-H, M-Z	1
685	65-73978-8								. . ARM ASSY (FOR SPARES PROCURE 65-99909- 2174)		1
-690	BACS13W3CN3								DELETED		
690A	NASM21209F1-15								. . . INSERT		4
695	65-73978-10								. . . ARM (OPT ITEM 695A)		1
-695A	65-73978-12								. . . ARM (OPT ITEM 695)		1
700	BACB30PU4-25								. . BOLT		8
705	BACW10BP3APU								. . WASHER		8
710	H52732-3CM								. . NUT (V15653) (SPEC BACN10YR3CM) (OPT PLH53CM (V62554))		8
715	BACB30PU5-28								. . BOLT		2
720	BACW10BP4APU								. . WASHER		2
725	H52732-4CM								. . NUT (V15653) (SPEC BACN10YR4CM) (OPT PLH54CM (V62554))		2
730	66-14527-8								. . PIN		2
735	149A6110-1								. . SLEEVE		1
740	60-4405-1								. . NUT		2
745	69-17330-6								. . CRANK		1
750	147A6119-1								. . SLEEVE		1
755	147A6118-1								. . TUBE	A, B	1
-755A	147A6118-3								. . TUBE	C-Z	1

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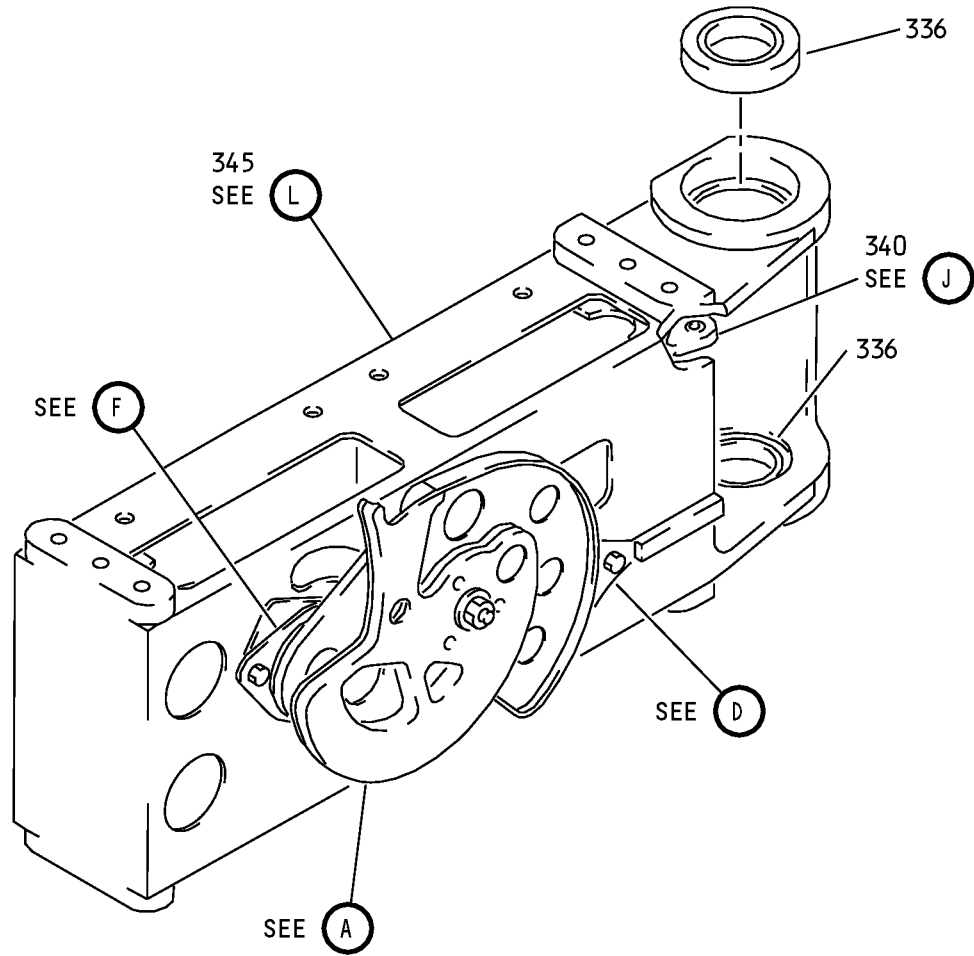
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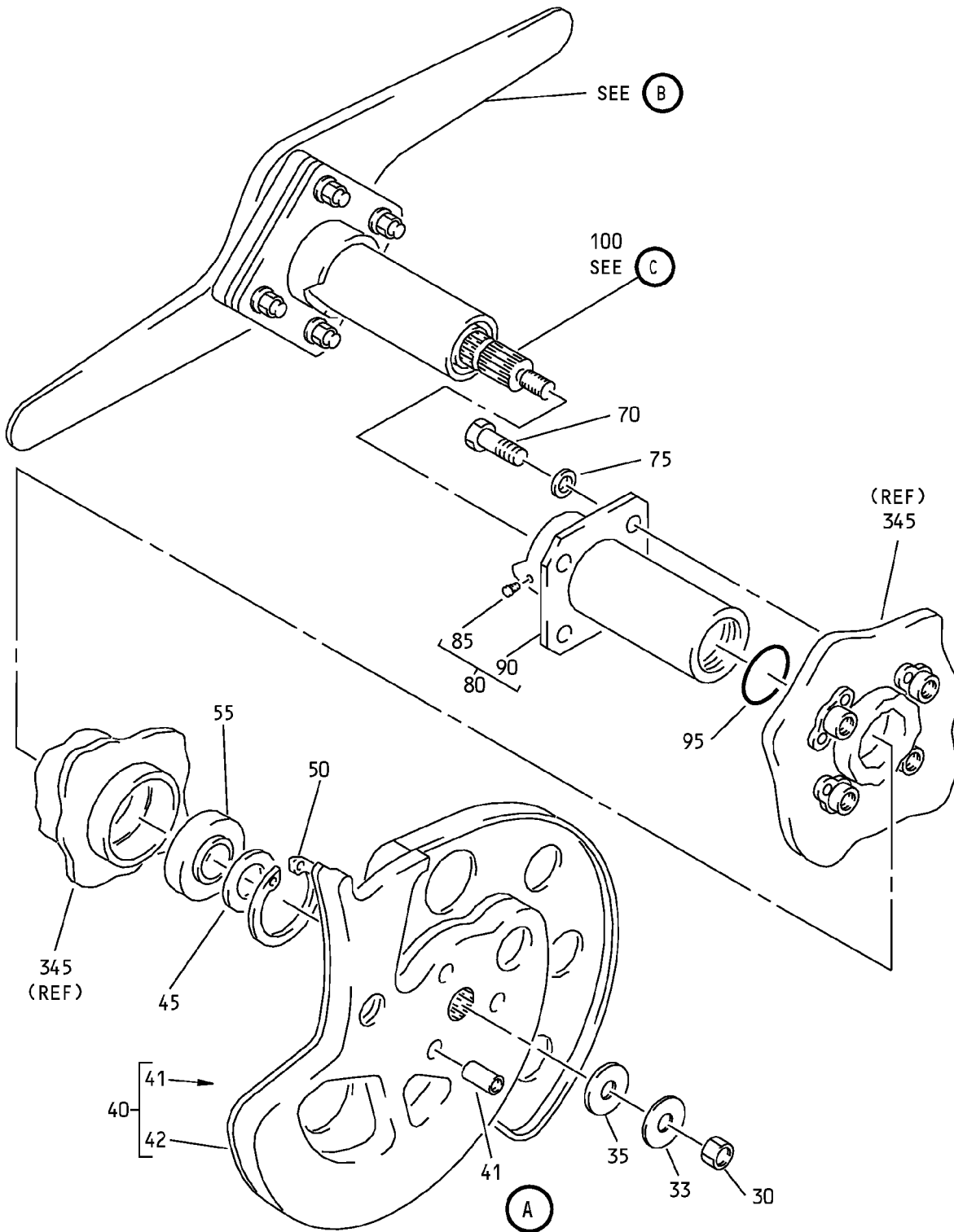
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Handle Box Assembly  
IPL Figure 3 (Sheet 1 of 8)

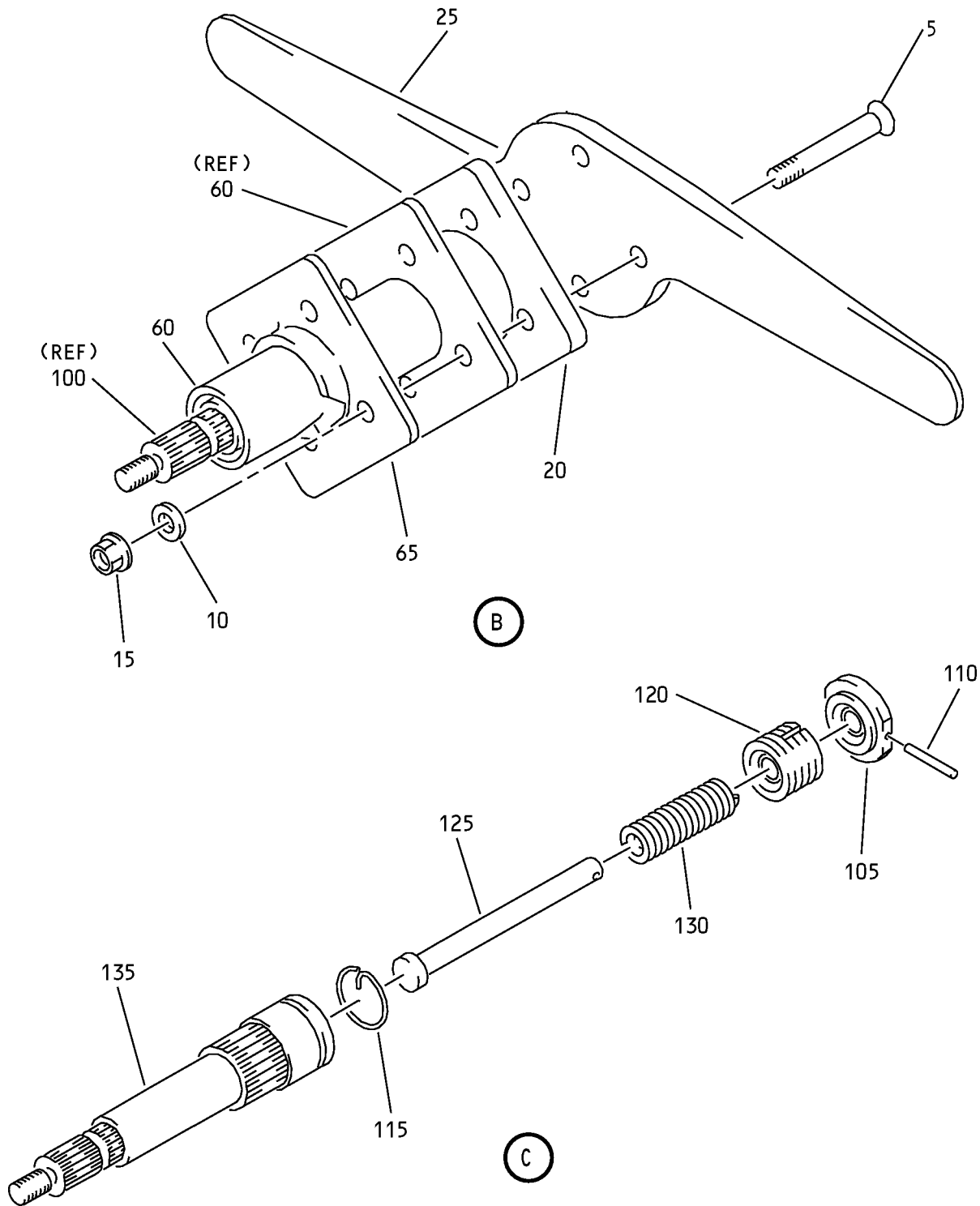
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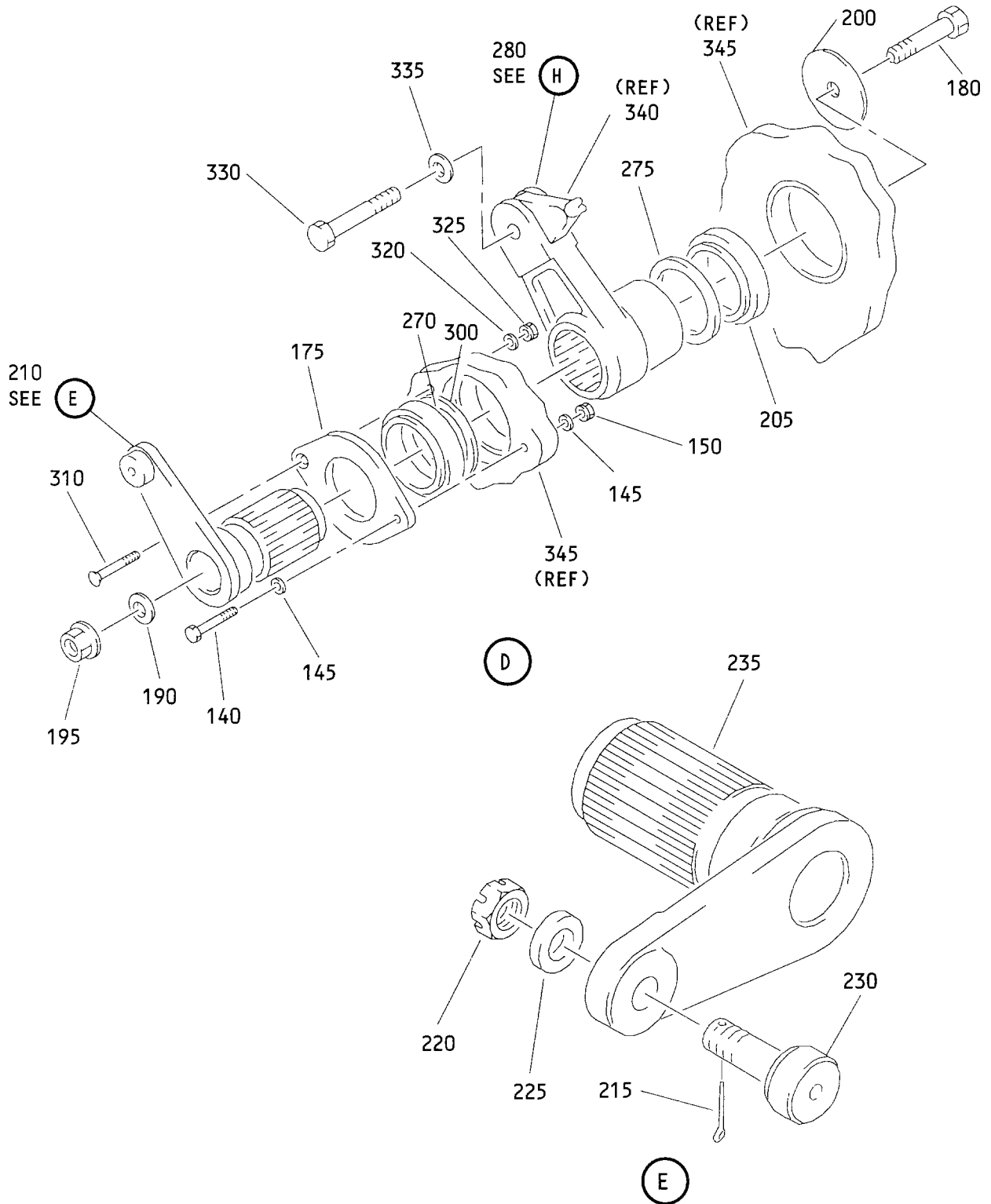
Handle Box Assembly  
IPL Figure 3 (Sheet 2 of 8)

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Handle Box Assembly  
IPL Figure 3 (Sheet 3 of 8)

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Handle Box Assembly  
IPL Figure 3 (Sheet 4 of 8)

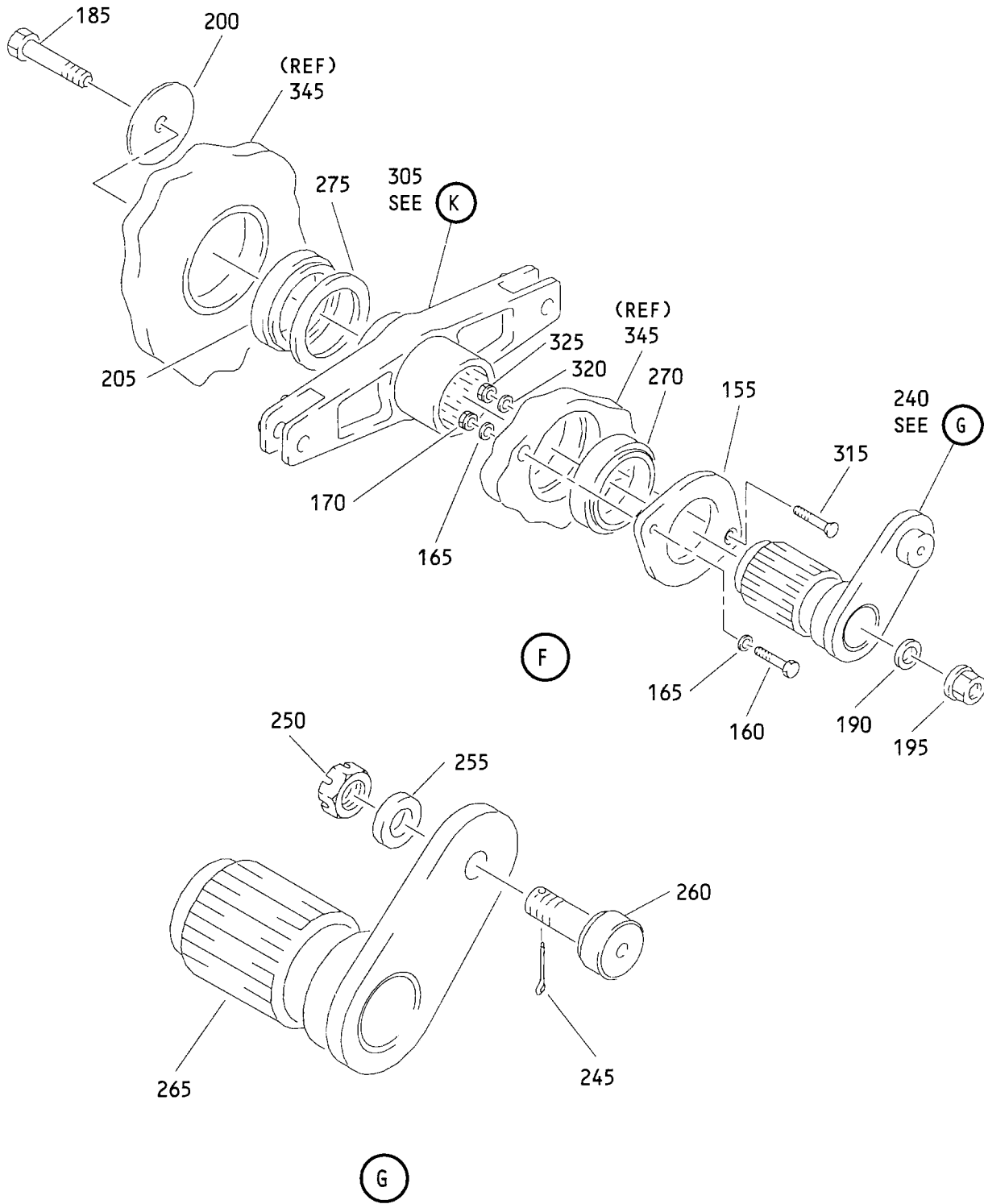
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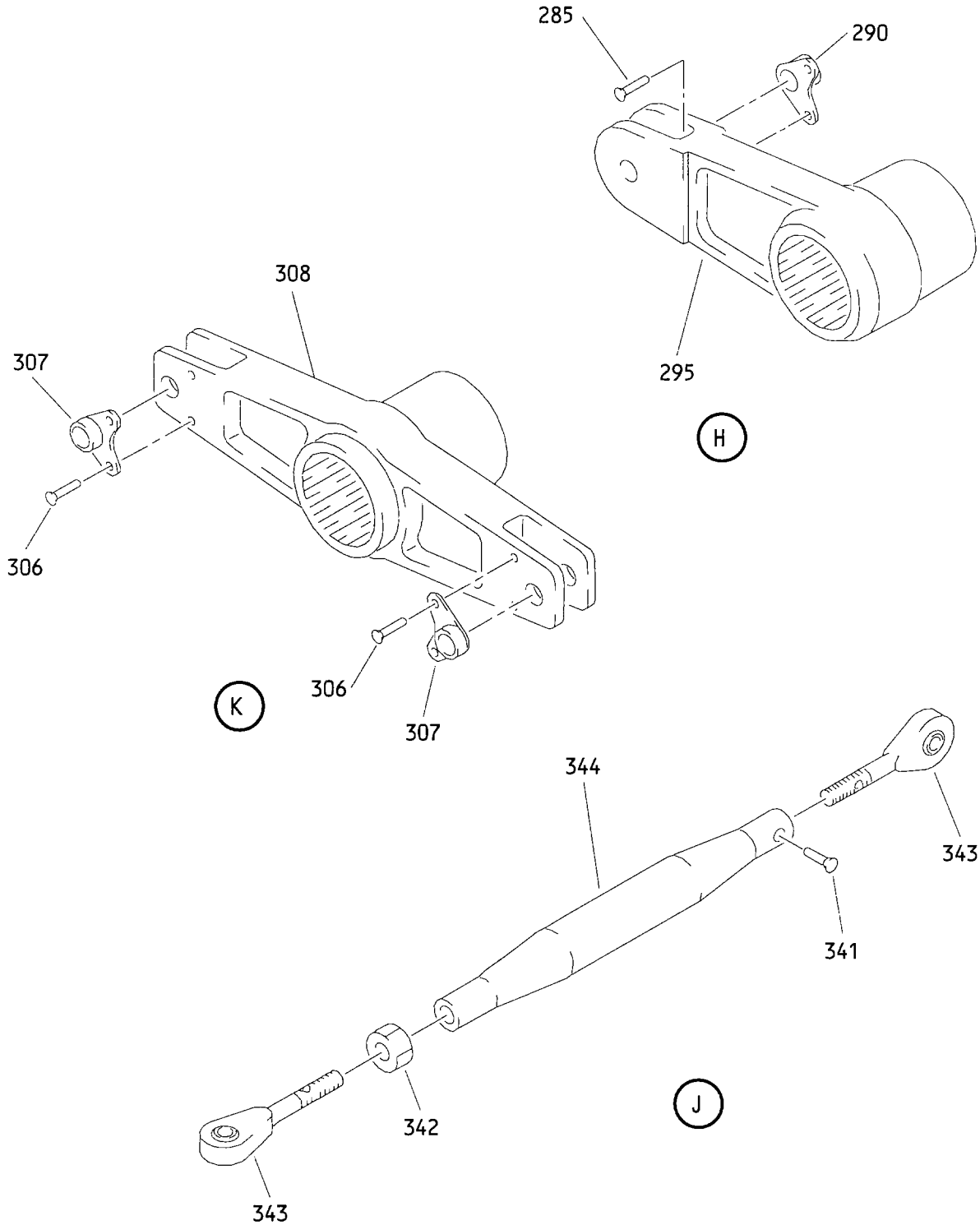


Handle Box Assembly  
IPL Figure 3 (Sheet 5 of 8)

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Handle Box Assembly  
IPL Figure 3 (Sheet 6 of 8)

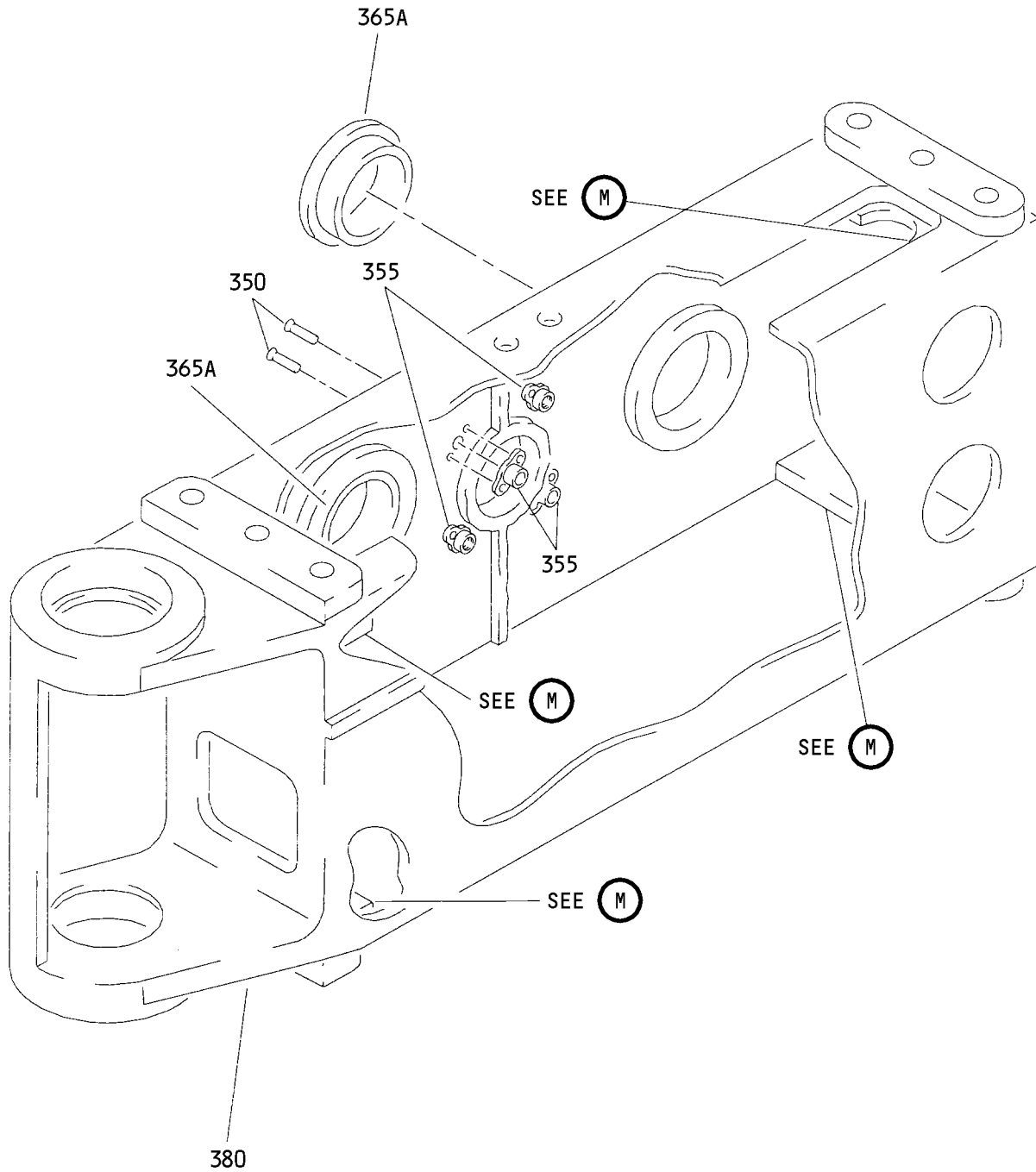
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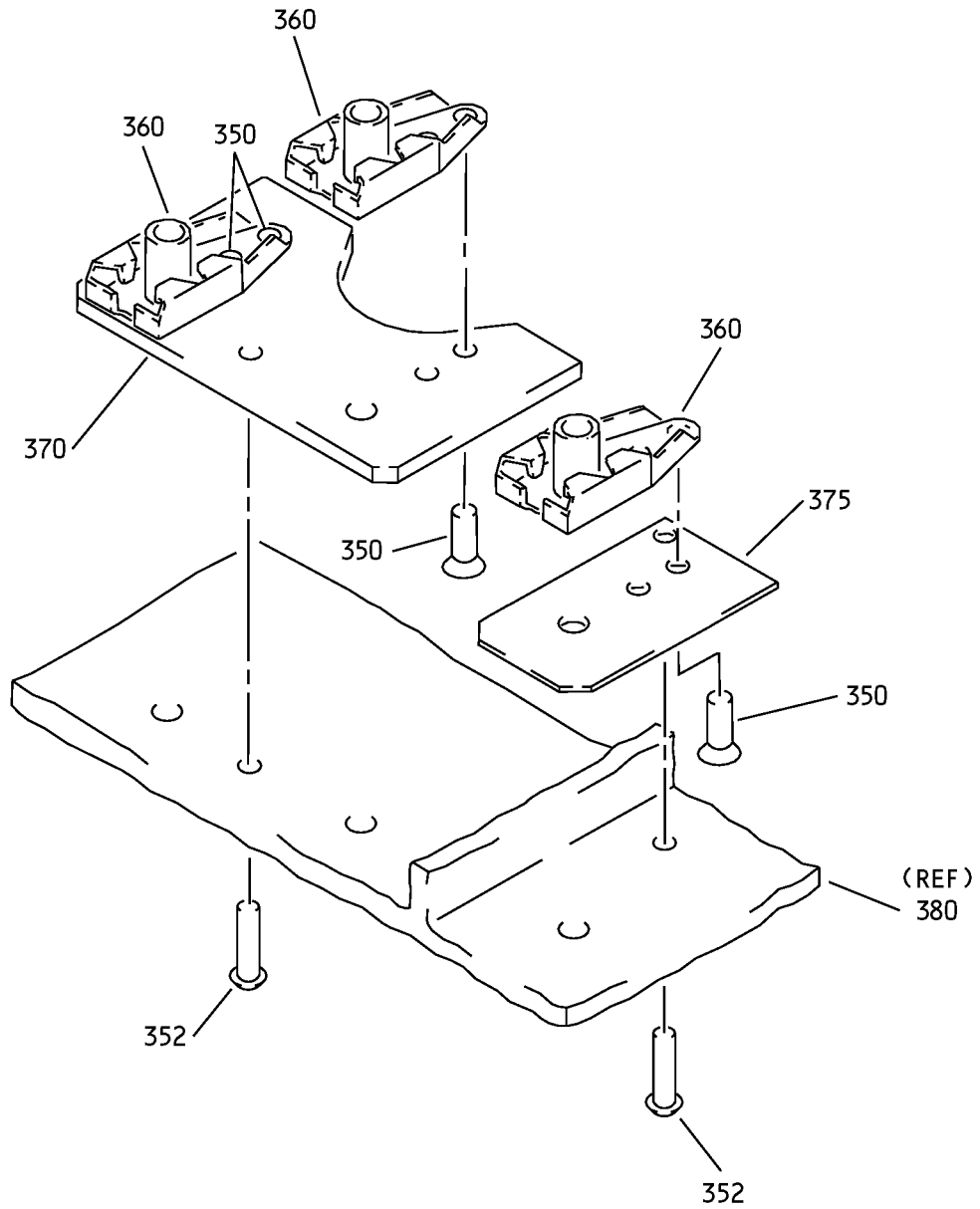
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(L)

Handle Box Assembly  
IPL Figure 3 (Sheet 7 of 8)

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Handle Box Assembly  
IPL Figure 3 (Sheet 8 of 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		
3-											
-1	147A6121-2										RF
5	BACB30NM3K13										4
10	NAS1149D0363J										4
15	H52732-3CD										4
20	66-24986-1										1
25	90-7879-7										1
30	BACN10JD6CD										1
33	NAS1149D0632J										1
35	63-9386-1										1
40	65-51687-7										1
41	MS21209F5-20										3
42	65-51687-8										1
-42A	65-51687-9										1
45	BACW10P148AL										1
50	MS16625-4162										1
55	PACMKP12AFS428										1
60	90-7821-1										1
65	90-7811										1
70	BACB30NM3K13										4
75	BACW10BN3AC										4
80	149A6120-1										1
85	NAS516-1A										1
90	149A6120-2										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-											
95	M83461-1-212								. PACKING		1
100	149A6109-1								. SHAFT ASSY		1
105	30-3019-1								. . WASHER		1
110	MS39086-111								. . PIN-RETAINING		1
115	AN996-14								. . RING-LOCK		1
120	30-3010								. . NUT		1
125	30-3013-2								. . PIN		1
130	63-2848								. . SPRING		1
135	60-4455-3								. . SHAFT		1
140	BACB30VF3K11								. BOLT		1
145	NAS1149D0332J								. WASHER		2
150	H52732-3CD								. NUT (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))		1
155	69B10068-3								. RETAINER-BEARING		1
160	BACB30NM3K7								. BOLT		1
165	NAS1149D0332J								. WASHER		2
170	H52732-3CD								. NUT (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))		1
175	69B10068-3								. RETAINER-BEARING		1
180	BACB30NR4K4								. BOLT		1
185	BACB30NR4K6								. BOLT		1
190	NAS1149D0432J								. WASHER		2
195	H52732-4CD								. NUT (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))		2
200	63-1692-1								. WASHER		2

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FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
3-											
205	PACMKP21BSF~ S428		.								2
210	141A6306-3		.								1
215	BACP18BC03A10P		.	.							1
220	BACN10JD106ASU		.	.							1
220A	BACN10JD106CD		.	.							1
225	NAS1149E0632R		.	.							1
230	KRP141500VT6-6		.	.							1
235	141A6306-2		.	.							1
240	90-7815-25		.								1
245	MS24665-283		.	.							1
250	BACN10JD106ASU		.	.							1
255	NAS1149C0632B		.	.							1
260	KRP141500VT6-6		.	.							1
265	90-7815-29		.	.							1
270	PACMKP23BSF~ S428		.								2
275	NAS1149D2190J		.								2
280	65-1933-23		.								1
285	BACR15BA4D		.	.							2
290	BACN10JP5CCD		.	.							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- -290A	MK3000-5BAC		.	.							1
295	65-1933-24		.	.							1
300	65-8795-501		.								1
305	65-54013-503		.								1
306	MS20426D4		.	.							4
307	NAS69BA4		.	.							2
308	65-54013-502		.	.							1
310	BACB30VF3K11		.								1
315	BACB30VF3K7		.								1
320	NAS1149D0332J		.								2
325	H52732-3CD		.								2
330	BACB30NR5K17		.								1
335	NAS1149D0563J		.								1
336	ACMKP25P26LY198		.								2
340	69-39176-3		.								1
341	MS20615-5M10		.	.							1
342	AN316-6R		.	.							1

-Item not Illustrated

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ILLUSTRATED PARTS LIST

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