COMPONENT MAINTENANCE MANUAL WITH ILLUSTRATED PARTS LIST

FORWARD ENTRY DOOR GUIDE ARM ASSEMBLY

PART NUMBER 141A6075–2, 141A6081–2

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BOEING

COMPONENT MAINTENANCE MANUAL

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To: All holders of FORWARD ENTRY DOOR GUIDE ARM ASSEMBLY 52-17-05.

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.

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Location of Change	Description of Change
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COMPONENT MAINTENANCE MANUAL

A = Added, R = Revised, D = Deleted, O = Overflow

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COMPONENT MAINTENANCE MANUAL

TEMPORARY REVISION AND SERVICE BULLETIN RECORD

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVE	DATE OF INCORPORATION INTO MANUAL

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

Revision		Filed	
Number	Date	Date	Initials

Revision		Filed	
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Revision		Filed		Revision		Filed	
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Temporary Revision		Inserted		Removed	
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Temporary Revision		Inserted		Removed	
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INTRODUCTION

1. General

A. The instructions in this manual supply the data necessary to do the maintenance functions together with the test, fault isolation, repair, and replacement of the defective parts.

B. This manual is divided into different parts:

(1) Title Page

(2) Transmittal Letter

(3) Highlights

(4) List of Effective Pages

(5) Table of Contents

(6) Temporary Revision & Service Bulletin Record

(7) Record of Revisions

(8) Record of Temporary Revisions

(9) Introduction

(10) Procedures & IPL Sections

C. Components that can be repaired have a different repair number for each specified repair. To find the repair number location of a component, look in the Repair-General procedure at the beginning of the REPAIR section. The Repair-General procedure also has an explanation of the True Position Dimension symbols used.

D. All dimensions, measures, quantities and weights included are in English units. When metric equivalents are given they will be in the parentheses that follow the English units.

E. The introduction to the Illustrated Parts List (IPL) shows how the IPL data is used.

F. Design changes, optional parts, configuration differences and Service Bulletin modifications may cause different part numbers. These part numbers are identified in the IPL with an alphabetical letter which is added to the end of the basic item number. This new item number is referred to as an alpha-variant. Throughout the manual, IPL basic item number references also apply to alpha-variants unless shown differently.

G. The tool reference numbers found in the individual procedures and in the Special Tools, Fixtures, and Equipment section are used to identify if a tool is a standard tool (STD-XXXX), a commercial tool (COM-XXXX), or a Special Tool (SPL-XXXX). This reference number is also used to distinguish between tools with similar names in the same procedure. These reference numbers are for use in the documentation only. They are not to be used for ordering tools.

FORWARD ENTRY DOOR GUIDE ARM ASSEMBLY - DESCRIPTION AND OPERATION

1. **Description**

   A. The forward entry door guide arm assembly consists of a guide arm, a roller, entry door pin, a collar assembly, a spring, levers, links, bushings, bearings, and attaching parts.

2. **Operation**

   A. The forward entry door guide arm assembly is used to lock the entry door in the open position. The locking is accomplished by the interaction of the entry door pin, the spring, the roller and the collar assembly. Operation of the lever allows the lock to be released which enables the door to close.

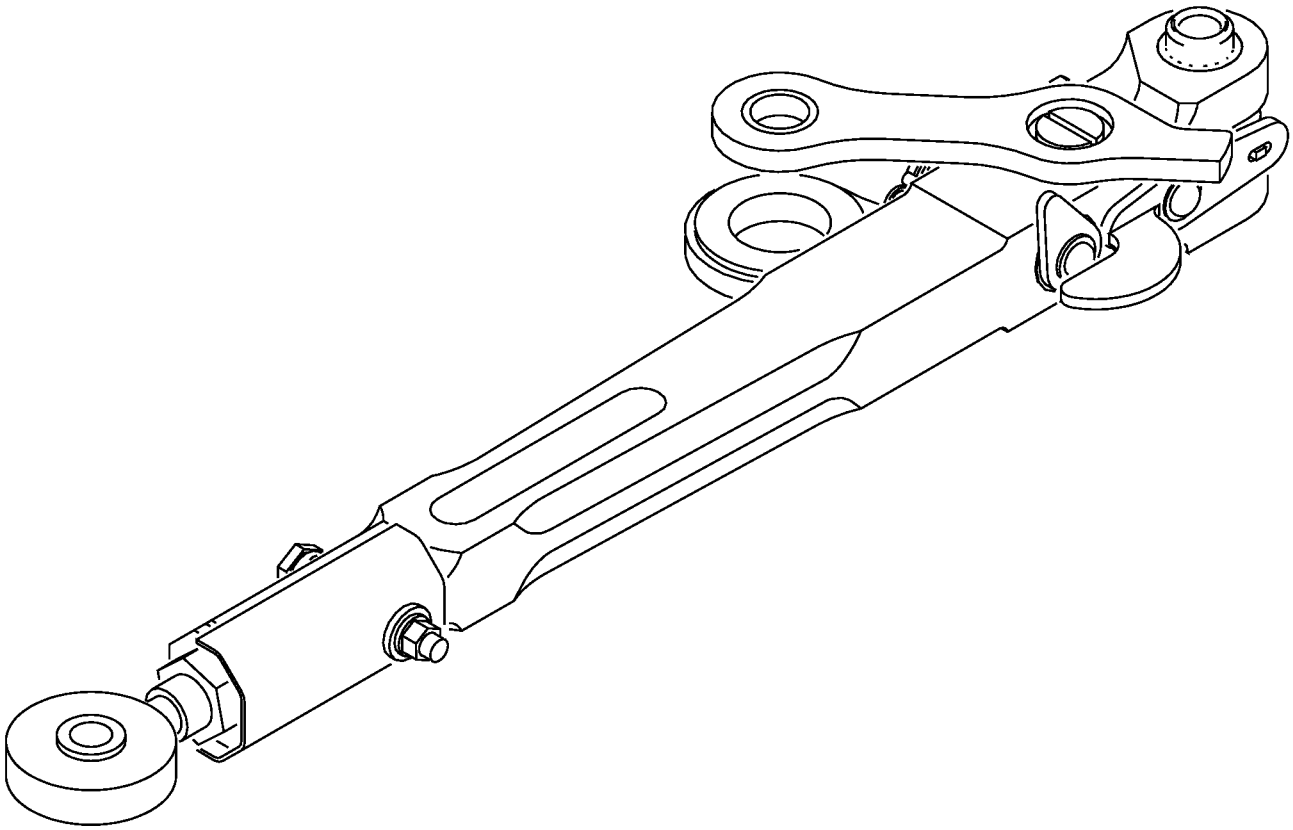
3. **Leading Particulars (Approximate)**

   A. Length – 12 inches

   B. Width – 2 inches

   C. Height – 2 inches

   D. Weight – 2 pounds



Forward Entry Door Guide Arm Assembly
Figure 1

TESTING AND FAULT ISOLATION

1. General

A. This procedure has the data necessary to do a test of the forward entry door guide arm assembly after an overhaul or for fault isolation.

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

C. Refer to IPL Figure 1 for item numbers.

2. Testing and Fault Isolation Procedures

A. Testing

(1) Rotate the roller (235) to ensure that it rotates freely without sticking or binding.

(2) Check that the axial movement of the roller (235) does not exceed 0.01 inch.

(3) Move the lever (260, 265) and verify that the pin (245) moves easily and smoothly.

B. Fault Isolation

(1) Refer to TESTING AND FAULT ISOLATION, Table 101 for causes of the problems found and the procedures to correct them.

Table 101: Fault Isolation Chart

TROUBLE	PROBABLE CAUSE	CORRECTION
Roller (235) does not rotate freely	Pin (240) improperly installed, binding in the collar (255), or bushings (270,272) installed too tight	Reinstall the pin (240) or lightly tap the roller (235) to separate bushings
Axial movement of roller (235) exceeds 0.01 inch	Bushings (270,272) installed improperly	Reinstall bushings
Pin (245) binds	Pin (245) is bent or dirty	Clean or replace pin

DISASSEMBLY

1. General

A. This procedure has the data necessary to disassemble the forward entry door guide arm 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 for item numbers.

2. Disassembly

A. Procedure

NOTE: Do not remove bushings (80, 95, 120, 185, 270, 272, 275), roller (235), and collar (255), unless repair or replacement is necessary.

(1) Remove nut (25), washer (20), bolt (10A), and channel (30).

(2) Remove the fitting (35), nut (40), and the rod end (45).

(3) Remove the screw (65), keywasher (70), pin assembly (50), washers (85), radius links (75, 90), and bushing (100).

(4) Remove the screws (105A, 175A), washers (110, 180), trigger (115), lever (260, 265), spacer assemblies (160, 215), spring (155), cam assembly (125), link assembly (190), spring pin (150), and shafts (230).

(5) Remove the spring pin (240), pin (245), and spring (250).

(NOT APPLICABLE)

CHECK

1. General

A. This procedure has the data necessary to find defects in the material of the specified parts.

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

C. Refer to IPL Figure 1 for item numbers.

2. Check

A. References

Reference	Title
SOPM 20-20-01	MAGNETIC PARTICLE INSPECTION
SOPM 20-20-02	PENETRANT METHODS OF INSPECTION

B. Procedure

(1) Use standard industry procedures to do a visual check of all the parts for defects. Do the penetrant or magnetic particle check if the visual check shows possible damage or if you suspect possible damage on the parts listed below:

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

1) Fitting (35)

2) Pin (60)

3) Link (90)

4) Spring (155)

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

1) Lever (260, 265)

2) Arm (280)

(2) Do a spring check.

(a) Spring (250)

1) Compress the spring to a length of 1.03 inch. Check that the minimum load is 0.90-1.10 pounds.

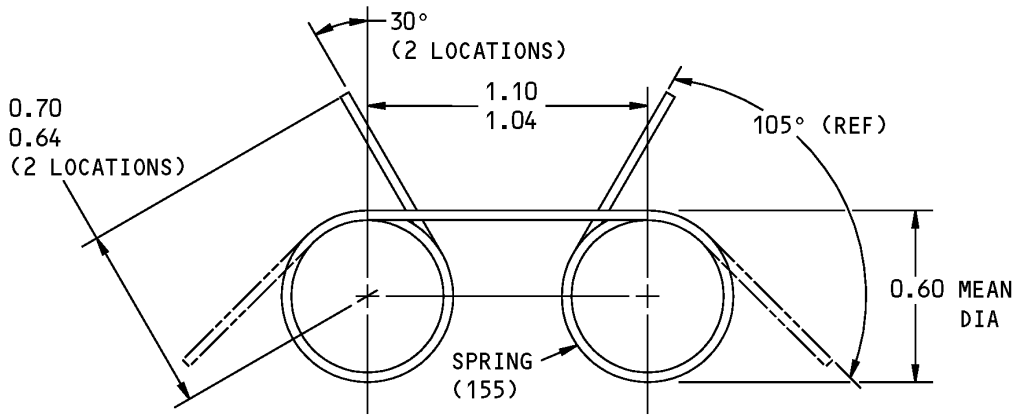
2) Compress the spring to a length of 0.68 inch. Check that the maximum load is 2.43-2.97 pounds.

(b) Spring (155) – CHECK, Figure 501

1) Deflect the spring 85 degrees and check that the minimum moment is 0.42 in-lbs.

2) Deflect the spring 105 degrees and check that the maximum moment is 0.52 in-lbs.

3) Deflect the spring a maximum of 115 degrees and check that the spring has no permanent set.



ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

Spring Check
Figure 501

REPAIR

1. General

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

Table 601:

PART NUMBER	NAME	REPAIR
—	REFINISH OF OTHER PARTS	1-1
141A6079	GUIDE ARM	2-1

2. Dimensioning Symbols

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

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

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 Ⓢ | B	LOCATED AT TRUE POSITION WITHIN 0.002 DIA RELATIVE TO DATUM B, REGARDLESS OF FEATURE SIZE
⊥ | ∅ 0.010 Ⓜ | A 0.510 Ⓟ	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] OR 2.000 BSC	THEORETICALLY EXACT DIMENSION IS 2.000

True Position Dimensioning Symbols
Figure 601

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 Practice Manual (SOPM) for the SOPM subjects identified in this procedure.

C. Refer to IPL Figure 1 for item numbers.

2. Refinish of Other Parts

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
C00037	Coating - Lacquer Camouflage	TT-L-20
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
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 20-30-03	GENERAL CLEANING PROCEDURES
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 general cleaning procedures, refer to SOPM 20-30-03. For decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

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

(2) Refer to REPAIR 1-1, Table 601 for the refinish details.

Table 601: Refinish Details

IPL FIG. & ITEM	MATERIAL	FINISH
IPL Fig. 1		
Channel (30)	17-7PH Steel 150-170 ksi	Cadmium plate (F-15.06) and apply primer, C00259 (F-20.02) and enamel coating, C00260 (F-21.03).
Fitting (35)	4340 Steel 125-145 ksi	Cadmium plate (F-15.06).

Table 601: Refinish Details (Continued)

IPL FIG. & ITEM	MATERIAL	FINISH
Pin (60)	15-5PH CRES 180-200 ksi	Cadmium plate (F-16.06).
Radius link (75), trigger (115), cam (145), link (210), collar (255)	15-5PH CRES 150-170 ksi	Cadmium plate (F-15.06).
Radius link (90)	4130 Steel 125-145 ksi	Cadmium plate (F-1.32).
Spring (155)	17-7PH CRES	Cadmium plate and apply primer, C00259 (F-16.01).
Spacer (170, 225)	Aluminum Alloy	Boric acid-sulfuric acid anodize (F-17.31) and apply primer, C00259 (F-20.03).
Shaft (230)	4130 Steel 125-145 ksi	Cadmium plate (F-1.32) and dry lubricate outside diameter with lubricant, D00113.
Spring (250)	Spring Steel	Cadmium plate (F-1.32).
Lever (260)	Aluminum Alloy	Chromic acid anodize (F-17.19) and apply primer, C00259 (F-20.02) and orange-yellow color No. 33538 Spec. 595 lacquer coating, C00037.
Lever (265)	Aluminum Alloy	Chromic acid anodize and apply primer, C00259 (F-18.13) and orange-yellow color No. 33538 Spec. 595 lacquer coating, C00037.

GUIDE ARM - REPAIR 2-1

141A6079–1

1. General

A. This procedure has the data necessary to refinish the guide arm (280).

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

C. Refer to REPAIR-GENERAL, Figure 601 True Position Dimensioning Symbols shown in the repair.

D. Refer to IPL Figure 1 for item numbers.

E. General Repair Details:

(1) Material: Aluminum Alloy

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

B. References

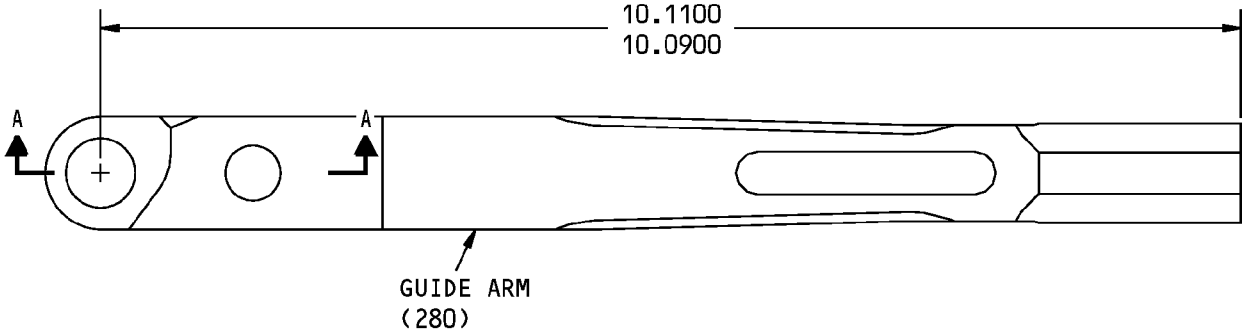
Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

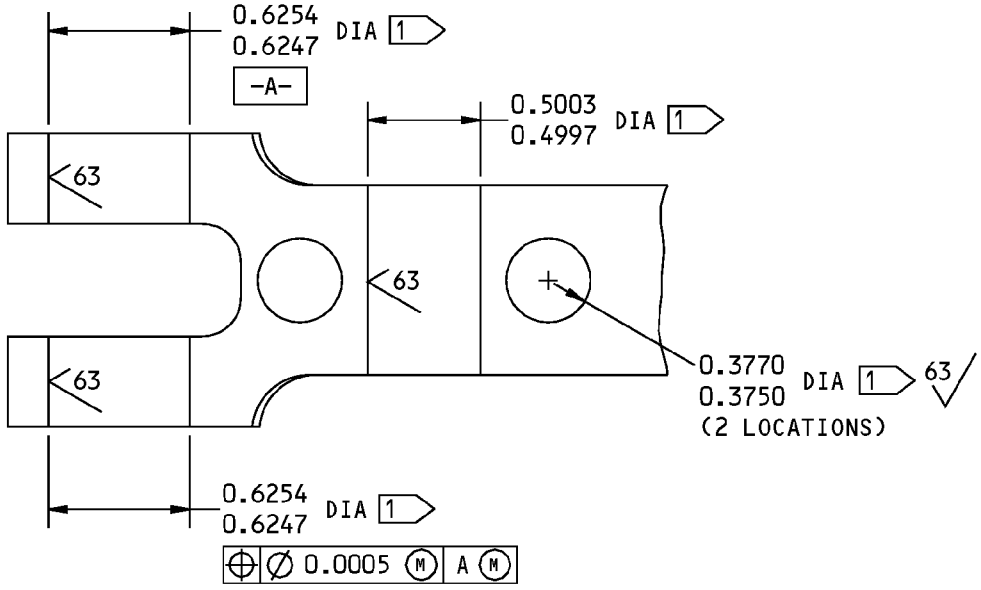
C. Procedure

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-17.31) all over.

(2) Apply primer, C00259 (F-20.02) and enamel coating, C00260 (F-21.03) except as noted in REPAIR 2-1, Figure 601.





A–A

1 NO PRIMER OR ENAMEL ON THIS SURFACE.

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

141A6079-1 Guide Arm Refinish
Figure 601

ASSEMBLY

1. General

A. This procedure has the data necessary to assemble the forward entry door guide arm.

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

C. Refer to IPL Figure 1 for item numbers.

2. Assembly

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00159	Compound - Sealing, Thread-Locking, Anaerobic, Single-Component (100-200 In-Lbs)	MIL-S-46163, Type II, Grade N
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95
C00913	Compound - Corrosion Inhibiting Material, Nondrying Resin Mix	BMS 3-27
D00633	Grease - Aircraft General Purpose	BMS3-33

B. References

Reference	Title
SOPM 20-50-01	BOLT AND NUT INSTALLATION
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-03	LUBRICANTS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

C. Procedure

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

(1) If the roller (235), collar (255), and bushings (270, 272, 275) have been removed or are being replaced, reinstall as follows:

(a) Install the bushing (270) in the guide arm (280) with sealant, A00247 using the shrink-fit method (SOPM 20-50-03).

(b) Install the bushing (275) with grease, D00633 (SOPM 20-50-03).

(c) Lubricate the roller (235) with grease, D00633.

(d) Position the collar (255) between the guide arm (280) lugs and insert the roller (235) through the collar and into the lugs of the guide arm.

(e) Install the bushing (272) in the guide arm (280) and stake (SOPM 20-50-03) as shown in ASSEMBLY, Figure 701.

(f) Install the spring (250), pin (245), and spring pin (240).

(2) Lubricate the shafts (230) with grease, D00633 and install in the guide arm (280).

(3) Install the trigger (115), latch (260, 265), cam assembly (125), and link assembly (190) on the ends of the shafts (230).

WARNING: BMS3-27COMPOUND, C00913 CONTAINS ASBESTOS, TOLUENE, XYLENE, STRONTIUM CHROMATE AND BARIUM CHROMATE. CONSULT APPLICABLE SAFETY STANDARDS PERSONS FOR THE APPROVED HANDLING PRECAUTIONS.

CAUTION: BMS COMPOUND, C00913 3-27 IS USED ONLY IN STATIC JOINTS WHERE GREASE CANNOT BE APPLIED. BMS COMPOUND, C00913 3-27 IN DYNAMIC JOINTS WILL NOT LET THEM MOVE FREELY.

(4) Apply compound, C00913 to the screws (105A, 175A) and install them with the washers (180), spring (155), and spacer assemblies (160, 215).

(5) Install the bushing (100) in the guide arm (280) (SOPM 20-50-03).

(6) Position the washers (85) and the links (75, 90) on the guide arm (280).

(7) Lubricate the pin assembly (50) with grease, D00633 and insert it through the bushing (100).

(8) Put the keywasher (70) on the pin assembly (50). Engage the key of the keywasher (70) in the keyway of the pin assembly (50) as shown in ASSEMBLY, Figure 701.

(9) Apply compound, A00159 on the screw (65) and insert with the keywasher (70) in the pin assembly (50).

WARNING: BMS3-27COMPOUND, C00913 CONTAINS ASBESTOS, TOLUENE, XYLENE, STRONTIUM CHROMATE AND BARIUM CHROMATE. CONSULT APPLICABLE SAFETY STANDARDS PERSONS FOR THE APPROVED HANDLING PRECAUTIONS.

CAUTION: BMS COMPOUND, C00913 3-27 IS USED ONLY IN STATIC JOINTS WHERE GREASE CANNOT BE APPLIED. BMS COMPOUND, C00913 3-27 IN DYNAMIC JOINTS WILL NOT LET THEM MOVE FREELY.

(10) Apply compound, C00913 to the fitting assembly (35) and install it in the guide arm (280).

WARNING: BMS3-27COMPOUND, C00913 CONTAINS ASBESTOS, TOLUENE, XYLENE, STRONTIUM CHROMATE AND BARIUM CHROMATE. CONSULT APPLICABLE SAFETY STANDARDS PERSONS FOR THE APPROVED HANDLING PRECAUTIONS.

CAUTION: BMS COMPOUND, C00913 3-27 IS USED ONLY IN STATIC JOINTS WHERE GREASE CANNOT BE APPLIED. BMS COMPOUND, C00913 3-27 IN DYNAMIC JOINTS WILL NOT LET THEM MOVE FREELY.

(11) Apply compound, C00913 to the rod end (45) threads.

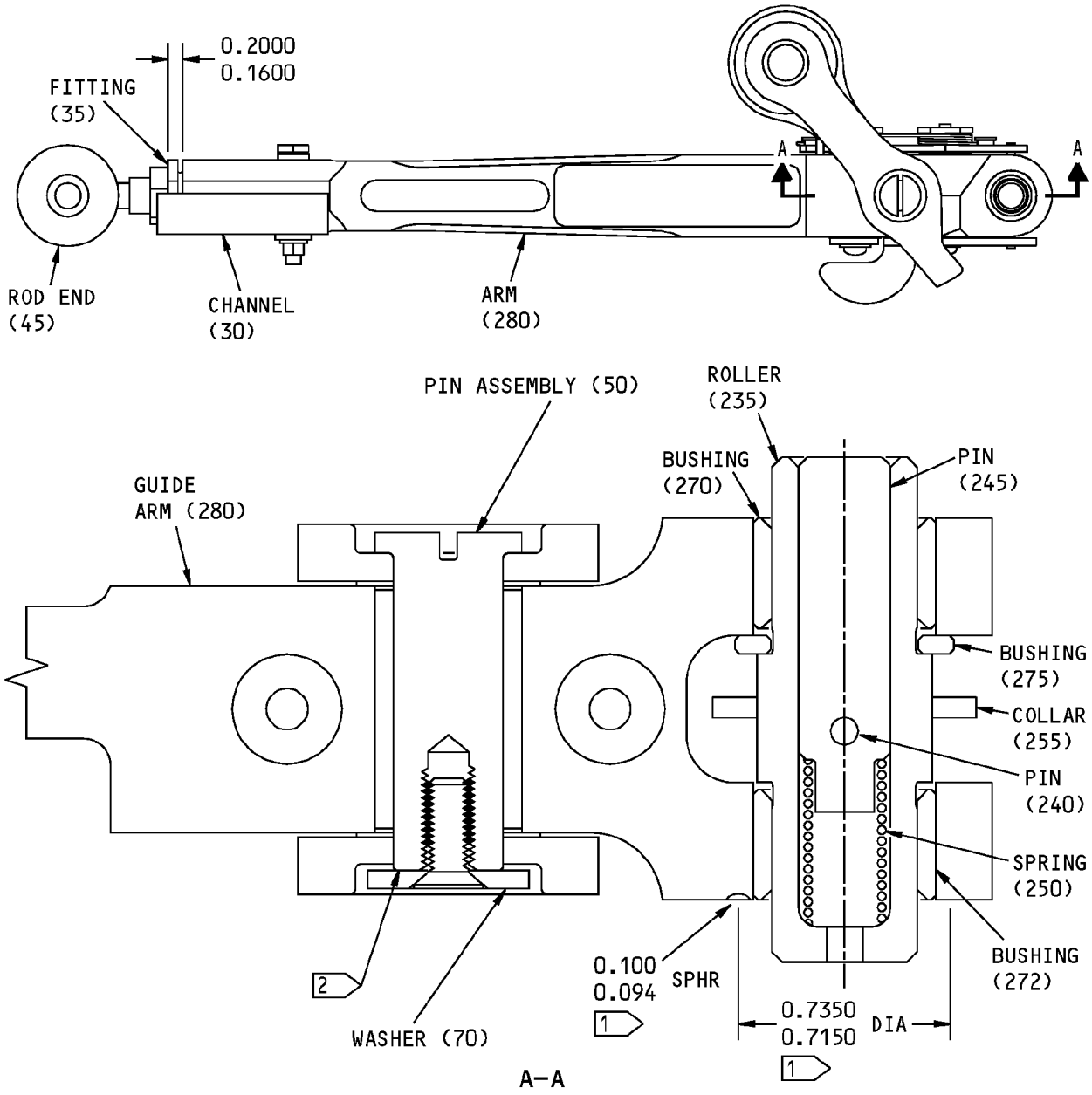
(12) Thread the nut (40) on the rod end (45) and install in the fitting assembly (35) as shown in ASSEMBLY, Figure 701.

WARNING: BMS3-27COMPOUND, C00913 CONTAINS ASBESTOS, TOLUENE, XYLENE, STRONTIUM CHROMATE AND BARIUM CHROMATE. CONSULT APPLICABLE SAFETY STANDARDS PERSONS FOR THE APPROVED HANDLING PRECAUTIONS.

(WARNING PRECEDES)

CAUTION: BMS COMPOUND, C00913 3-27 IS USED ONLY IN STATIC JOINTS WHERE GREASE CANNOT BE APPLIED. BMS COMPOUND, C00913 3-27 IN DYNAMIC JOINTS WILL NOT LET THEM MOVE FREELY.

(13) Apply compound, C00913 to the bolt (10A), washer (20), and nut (25) and fasten the channel (30) to the guide arm (280).



1 BALL STAKE 5 POINTS OF EQUAL DISTANCE AROUND THE DIAMETER SHOWN.

2 ENGAGE THE KEY OF THE WASHER (70) IN THE KEYWAY OF THE PIN ASSEMBLY (50)

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

Assembly Details
Figure 701

BOEING®

COMPONENT MAINTENANCE MANUAL

FITS AND CLEARANCES

(NOT APPLICABLE)

(NOT APPLICABLE)

ILLUSTRATED PARTS LIST

1. Introduction

A. The Illustrated Parts List (IPL) contains an illustration and a list of component parts you can repair or replace. The Illustrated Parts Catalog (IPC) shows how to use the Boeing part number system.

B. This shows how parts are related: The relation of each item to its next higher assembly (NHA) is shown in the NOMENCLATURE column. Use the indenture system that follows:

1 2 3 4 5 6 7

. Assembly

. Attaching parts for assembly

. . Detail parts for assembly

. . Subassembly

. . Attaching parts for subassembly

. . . Detail parts for subassembly

. . . Sub-subassembly

. . . Attaching parts for subassembly

. . . . . Details parts for sub-subassembly

Detail Installation Parts (Included only if installation parts may be sent to the shop as part of assembly)

C. Each top assembly is given one use code letter (A, B, C, etc.) in the USAGE CODE column. All subsequent component parts in the list can have one or more of the use code letters to show effectivity to top assemblies. A component part without a use code applies to all top assemblies.

D. An alphabetical letter is added after the item number for optional parts, parts changed by a Service Bulletin, configuration differences (except left-handed and right-handed parts), last engineering releases, and parts added between item numbers in a sequence. The alphabetical letter will not be shown on the illustration for equivalent parts of the same part number.

E. Color-coded parts are identified with a single digit alpha following the dash number or with ''SP'' suffix. If the ''SP'' suffix is used, it represents consolidation of all color codes applicable for a given usage which are not separately listed. Orders for color-coded parts should include the registry number of the airplane for which the parts are ordered.

F. If a part number is 15 characters long but will not fit in the part number column, the part number will be displayed with a ''~'' at the end of the line and will be continued on the next line. The ''~'' denotes that the part number continues on the next line.

G. Parts changed by a Service Bulletin are shown by PRE SB XXXX and POST SB XXXX added to the NOMENCLATURE column.

(1) When a new top assembly is added by a Service Bulletin, PRE SB XXXX and POST SB XXXX will be added at the top assembly level only. The configuration differences at the detail part level are shown by use code letters.

(2) When the top assembly part number is not changed by the Service Bulletin, PRE SB XXXX and POST SB XXXX will be added at the detail level.

H. Interchangeable Parts

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

VENDOR CODES

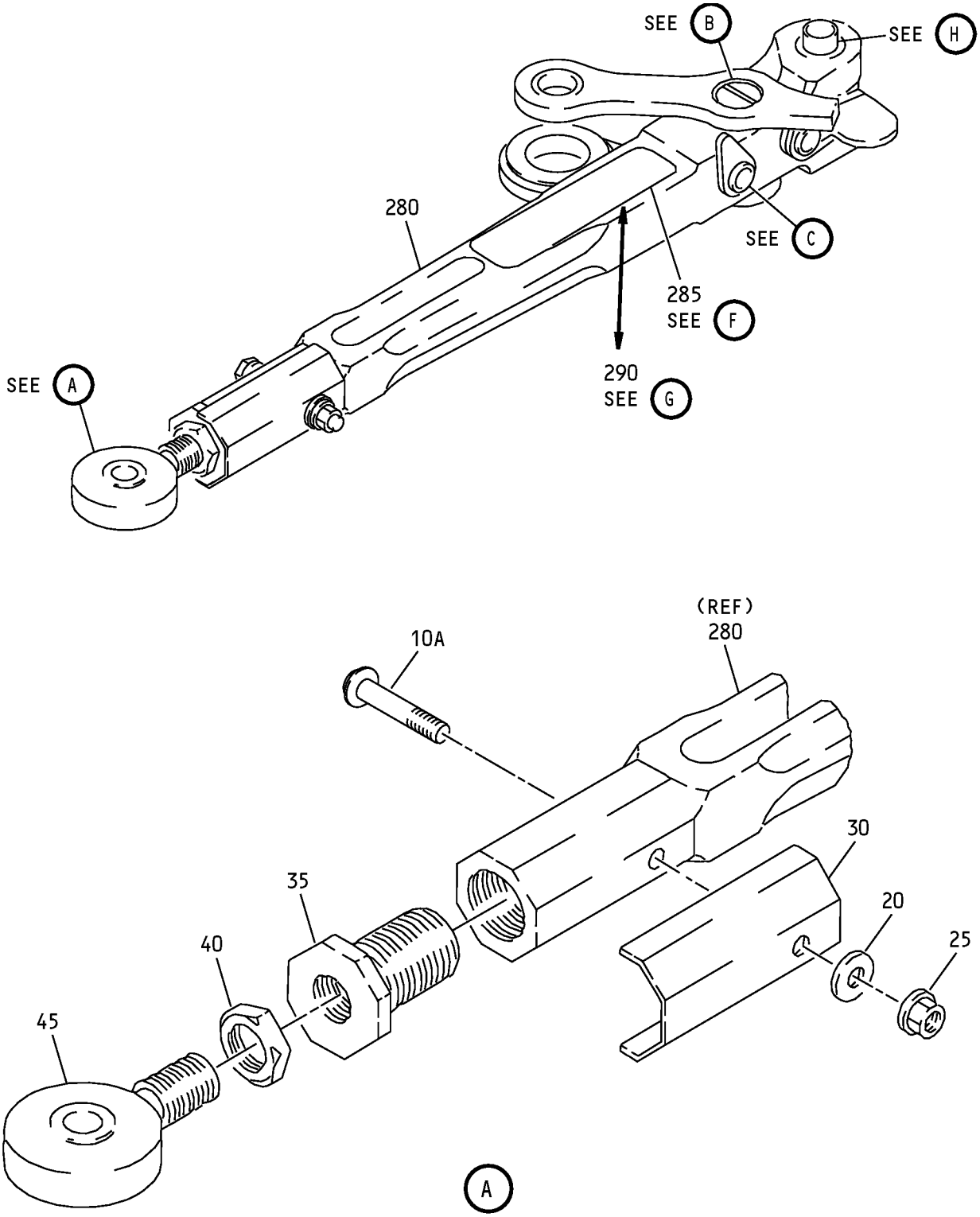
Code	Name
00481	ASCO SINTERING COMPANY COMMERCE, CALIFORNIA 90040 BUSINESS DISCONTINUED
06725	AIR INDUSTRIES CORPORATION 12570 KNOTT STREET GARDEN GROVE, CALIFORNIA 92641-3932 FORMERLY AIR INDUSTRIES OF CALIF IN GARDENA, CALIF.
0PTK6	SPS TECHNOLOGIES INC AEROSPACE PRODUCTS DIV 5195 W 4700 SALT LAKE CITY, UTAH 94118 SEE V56878 SPS TECHNOLOGIES INC
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
50294	NEW HAMPSHIRE BALL BEARINGS, INC PRECISION DIVISION 9700 INDEPENDENCE AVENUE CHATSWORTH, CALIFORNIA 91311 FORMERLY NIPPON MINATURE BEARING CORP V23589 AND NMB AMERICA INC AND NMB INC
56878	SPS TECHNOLOGIES INC AEROSPACE AND INDUSTRIAL PRODUCTS DIV 301 HIGHLAND AVE JENKINTOWN, PENNSYLVANIA 19046 FORMERLY STANDARD PRESSED STEEL FORMERLY IN SALT LAKE, UTAH

Code	Name
62554	SIMMONDS MECAERO FASTENERS INC 1734 SEQUOIA AVENUE ORANGE, CALIFORNIA 92668
70417	CHRYSLER CORP AMPLEX DIV 6565 EAST EIGHT MILE ROAD WARREN, MICHIGAN 48091-2949 FORMERLY AMPLEX MFG CO V90646
71129	BOUND BROOK BEARING CO PO BOX 57 AUBURN, PENNSYLVANIA 17922-0057 FORMERLY IN BOUND BROOK, NEW JERSEY
73197	HI-SHEAR TECHNOLOGY CORP 2600 SKYPARK DRIVE TORRANCE, CALIFORNIA 90509
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

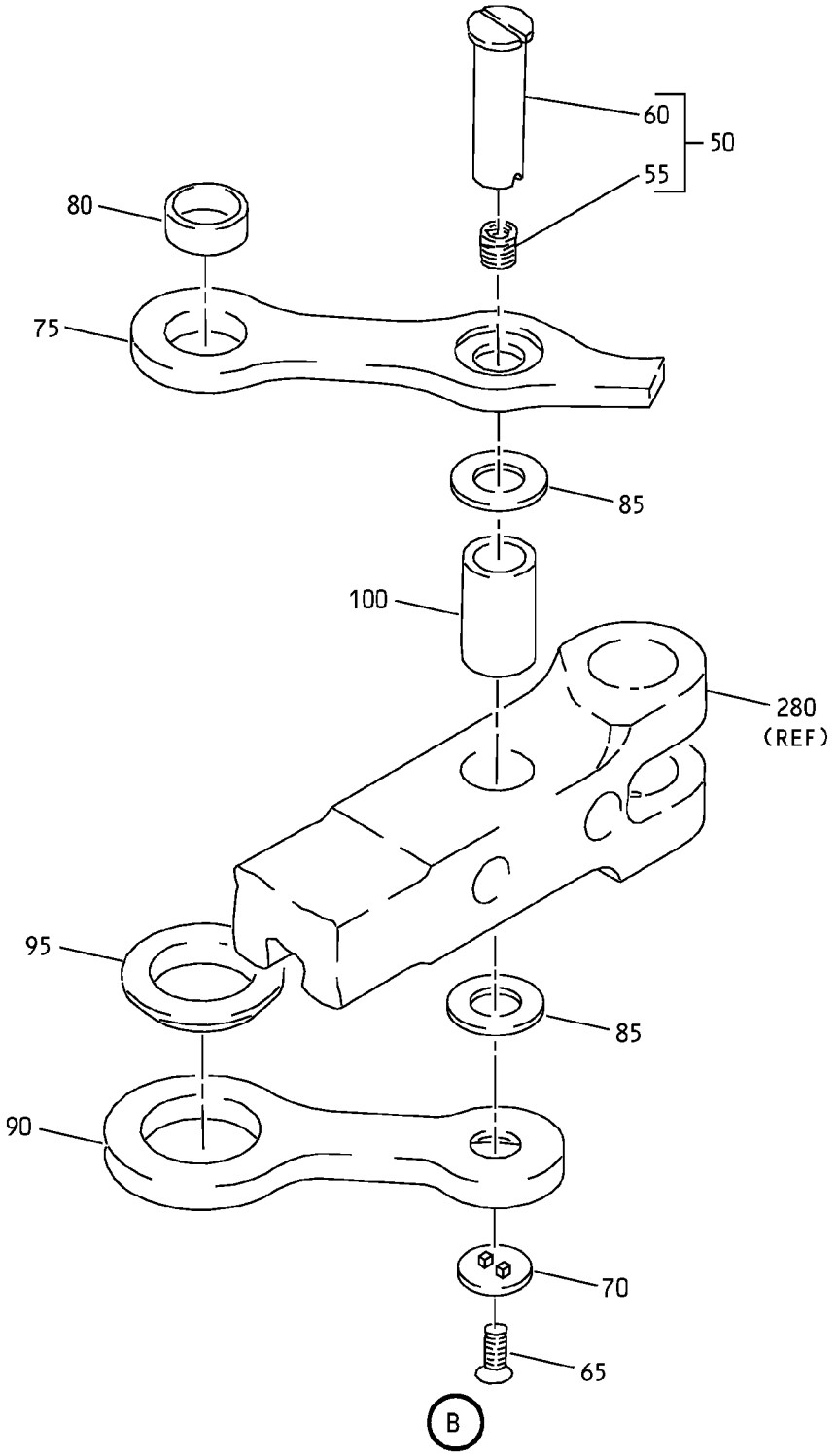
NUMERICAL INDEX

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
141A6075-2		1	1B	RF
141A6076-1		1	50	1
141A6076-2		1	60	1
141A6077-1		1	70	1
141A6078-1		1	160	1
		1	215	1
141A6078-2		1	170	1
		1	225	1
141A6079-1		1	280	1
141A6081-2		1	5A	RF
141A6082-1		1	30	1
63-2539-1		1	245	1
63-2552		1	230	2
63-2554		1	250	1
66-18315-1		1	90	1
66-18573-2		1	260	1
66-4727-3		1	235	1
69-76554-1		1	75	1
69-76555-1		1	255	1
69-76556-1		1	190	1
69-76556-2		1	210	1
69-76557-1		1	125	1
69-76557-2		1	145	1
69-76558-1		1	115	1
69-76559-1		1	265	1
69-76561-1		1	155	1
69-78241-1		1	35	1
AN316-7R		1	40	1
AN960D3		1	140	1
		1	205	1
AR5E6FN		1	45	1
BAC27DBY0167		1	290	1
BAC27DBY0168		1	285	1
BACB10D67T		1	275	1

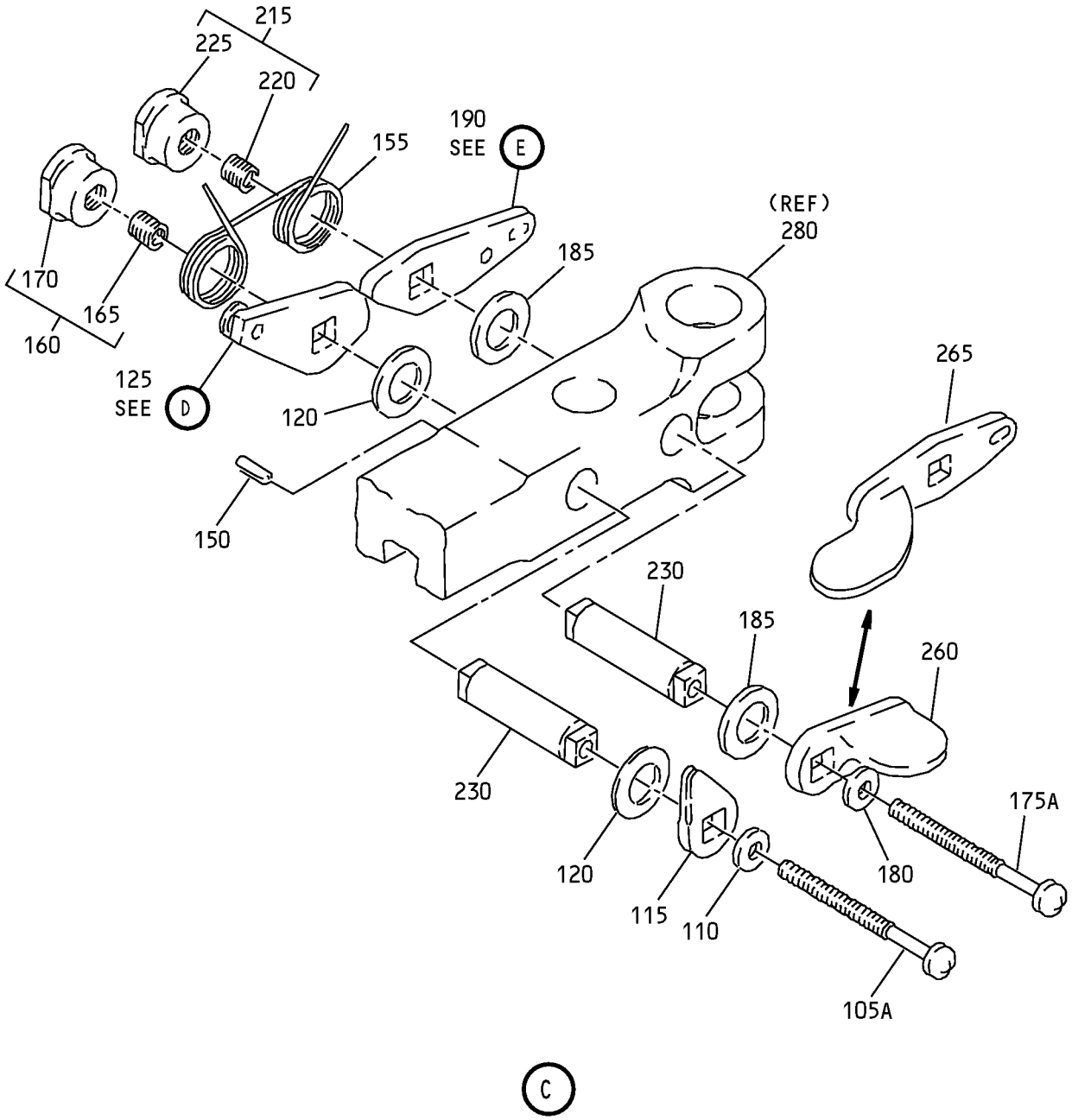
PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACB30VT6K15		1	10A	1
BACN10YR3CD		1	25	1
BACR15CE3D		1	130	1
		1	195	1
BACS12ER06K6		1	65	1
CW507-0063		1	275	1
H52732-3CD		1	25	1
HST10AG6-15		1	10A	1
		1	10A	1
		1	10A	1
		1	10A	1
KBE5-13SSFN		1	45A	1
MS16562-216		1	240	1
MS16562-23		1	150	1
MS21209C0610P		1	165	1
		1	220	1
MS21209C0615L		1	55	1
NAS1149CN632R		1	110	1
NAS1149D0363J		1	20	1
NAS1149D0616J		1	85	2
		1	120	2
		1	185	2
NAS1149DN616J		1	180	1
NAS42DD3-4		1	135	1
		1	200	1
NAS601-24P		1	105A	1
		1	175A	1
NAS76A6-026		1	100	1
NAS76A7-006P		1	80	1
NAS76A8-012		1	270	1
		1	272	1
NAS77A12-019P		1	95	1
PLH53CD		1	25	1
T5707-750-4		1	275	1
T706		1	275	1



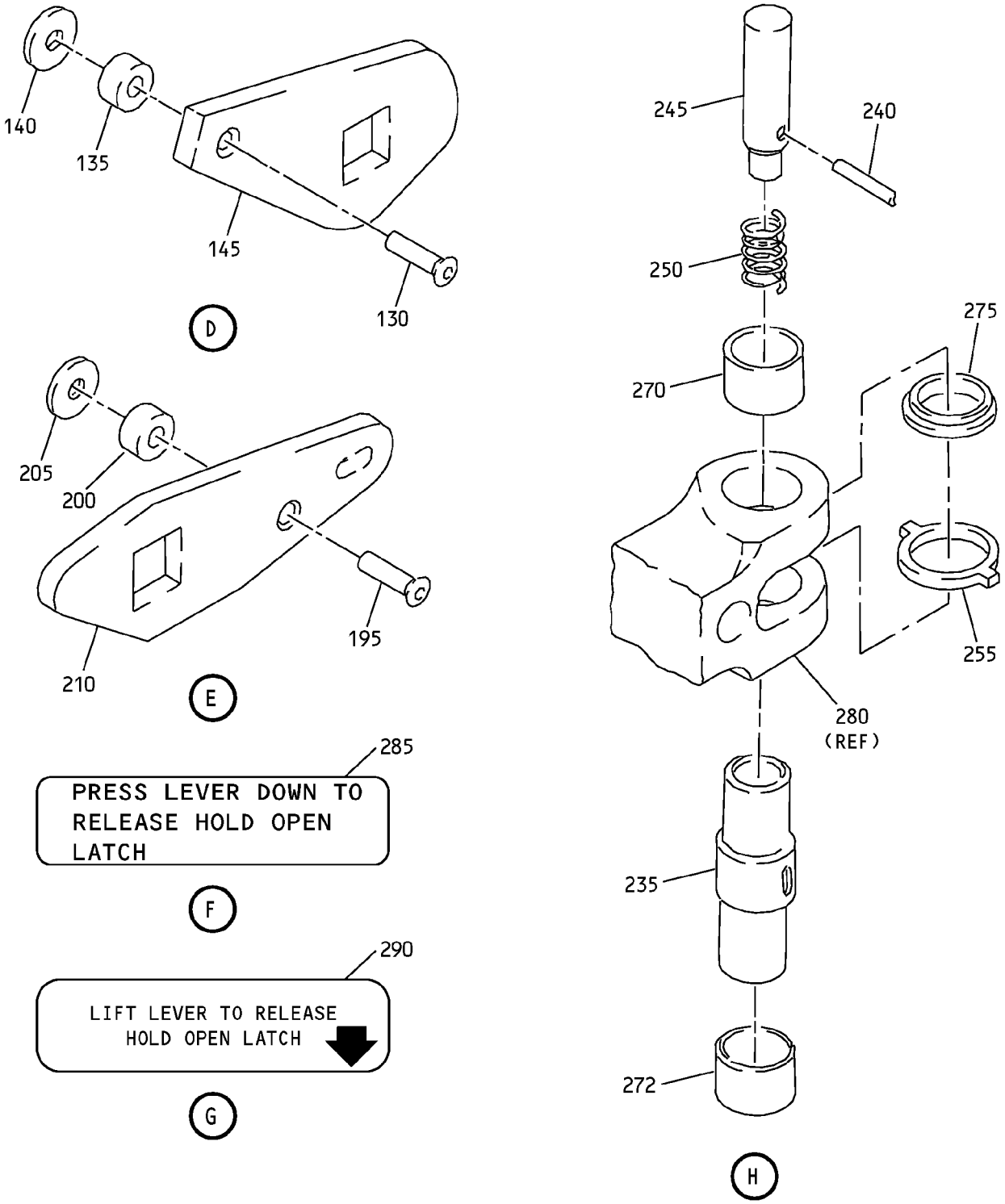
Forward Entry Door Guide Arm Assembly
IPL Figure 1 (Sheet 1 of 4)



Forward Entry Door Guide Arm Assembly
IPL Figure 1 (Sheet 2 of 4)



Forward Entry Door Guide Arm Assembly
IPL Figure 1 (Sheet 3 of 4)



Forward Entry Door Guide Arm Assembly
IPL Figure 1 (Sheet 4 of 4)

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
–1A	141A6075-1		DELETED		
–1B	141A6075-2		ARM ASSY-GUIDE, FWD ENTRY DOOR	C	RF
–5	141A6081-1		DELETED		
–5A	141A6081-2		ARM ASSY-GUIDE, FWD ENTRY DOOR	D	RF
10	BACB30NM3K16		DELETED		
10A	HST10AG6-15		. BOLT (V0PTK6) (SPEC BACB30VT6K15) (OPT HST10AG6-15 (V06725)) (OPT HST10AG6-15 (V56878)) (OPT HST10AG6-15 (V73197))		1
15	BACW10BP3CD		DELETED		
20	NAS1149D0363J		. WASHER		1
25	H52732-3CD		. NUT (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))		1
30	141A6082-1		. CHANNEL		1
35	69-78241-1		. FITTING-ADJUSTMENT		1
40	AN316-7R		. NUT		1
45	AR5E6FN		. BEARING-ROD END (V50294) (OPT ITEM 45A)		1
–45A	KBE5-13SSFN		. BEARING-ROD END (V97613) (OPT ITEM 45)		1
50	141A6076-1		. PIN ASSY		1
55	MS21209C0615L		. . INSERT		1
60	141A6076-2		. . PIN		1
65	BACS12ER06K6		. SCREW		1
70	141A6077-1		. WASHER-KEY		1
75	69-76554-1		. LINK-RADIUS		1
80	NAS76A7-006P		. BUSHING		1
85	NAS1149D0616J		. WASHER		2
90	66-18315-1		. LINK-LWR RADIUS		1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
95	NAS77A12-019P		. BUSHING		1
100	NAS76A6-026		. BUSHING		1
105	BACS12CK06U24		DELETED		
105A	NAS601-24P		. SCREW		1
110	NAS1149CN632R		. WASHER		1
115	69-76558-1		. TRIGGER		1
120	NAS1149D0616J		. WASHER		2
125	69-76557-1		. CAM ASSY		1
130	BACR15CE3D		. . RIVET (SIZE DETERMINED ON INST)		1
135	NAS42DD3-4		. . SPACER		1
140	AN960D3		. . WASHER		1
145	69-76557-2		. . CAM		1
150	MS16562-23		. PIN-SPR		1
155	69-76561-1		. SPRING		1
160	141A6078-1		. SPACER ASSY		1
165	MS21209C0610P		. . INSERT		1
170	141A6078-2		. . SPACER		1
175	BACS12CK06U24		DELETED		
175A	NAS601-24P		. SCREW		1
180	NAS1149DN616J		. WASHER		1
185	NAS1149D0616J		. WASHER		2
190	69-76556-1		. LINK ASSY		1
195	BACR15CE3D		. . RIVET (SIZE DETERMINED ON INST)		1
200	NAS42DD3-4		. . SPACER		1
205	AN960D3		. . WASHER		1
210	69-76556-2		. . LINK		1
215	141A6078-1		. SPACER ASSY		1
220	MS21209C0610P		. . INSERT		1
225	141A6078-2		. . SPACER		1
230	63-2552		. SHAFT		2

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
235	66-4727-3		. ROLLER		1
240	MS16562-216		. PIN-SPR		1
245	63-2539-1		. PIN		1
250	63-2554		. SPRING		1
255	69-76555-1		. COLLAR		1
260	66-18573-2		. LEVER-STOWING LATCH	C	1
265	69-76559-1		. LEVER-HOLD OPEN LATCH	D	1
270	NAS76A8-012		. BUSHING		1
272	NAS76A8-012		. BUSHING		1
275	T706		. BUSHING (V70417) (SPEC BACB10D67T) (OPT T5707-750-4 (V00481)) (OPT CW507-0063 (V71129))		1
280	141A6079-1		. ARM		1
285	BAC27DBY0168		. MARKER-ALUMINUM FOIL PRESS LEVER DOWN TO RELEASE HOLD OPEN LATCH	C	1
290	BAC27DBY0167		. MARKER-ALUMINUM FOIL LIFT LEVER TO RELEASE HOLD OPEN LATCH	D	1

–Item not Illustrated