COMPONENT MAINTENANCE MANUAL WITH ILLUSTRATED PARTS LIST

MID EXIT DOOR ASSEMBLY

PART NUMBER 146A6200–1

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COMPONENT MAINTENANCE MANUAL

Revision No. 5
Jul 01/2009

To: All holders of MID EXIT DOOR ASSEMBLY 52-21-03.

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.

ATTENTION

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Location of Change	Description of Change
52-21-03	
REPAIR 22-1	Changed the data in the Consumable Materials list. Changed consumable from ''DC3145 adhesive, A00281'' to ''Dow Corning 3145 RTV adhesive, A00281''
REPAIR 40-1	Changed the data in the Consumable Materials list. Changed consumable from ''lubricant, D50081'' to ''solid film lubricant, D50081''

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TEMPORARY REVISION AND SERVICE BULLETIN RECORD

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVE	DATE OF INCORPORATION INTO MANUAL
	52-4		JUL 01/07

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.

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Revision		Filed	
Number	Date	Date	Initials

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

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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.

MID EXIT DOOR ASSEMBLY - DESCRIPTION AND OPERATION

1. Description

A. The emergency exit door assembly is a hinged, plug-type door. Attached to the door are a mechanism installation (with internal and external handles, torque tube assembly with latching cranks and rollers, snubbers with release assembly, and attaching linkage), pressure relief door installation, and two support fittings for guide pins. Cabin pressure load on the door is transmitted to the fuselage at five discrete pressure stops - forward and aft. A view port lets you see the escape slide ground contact area.

2. Operation

A. The inside handle or the outside handle operates the mechanism linkage and turns the door assembly torque tube. The vent door immediately opens, to release remaining air pressure in the passenger cabin. Latch cranks on the forward and aft ends of the torque tube turn. Rollers on the latch cranks engage fittings on the fuselage, to lift the door up from the fuselage. Pawl latch mechanisms then engage to hold the door in this position. Further operation of the handle lifts the door more to let the forward and aft guide pins clear the support fittings. Manual outward force applied to the door turns it until its center of gravity is past the vertical. By its own weight, the door continues to turn out and down, until it hangs from its hinges. Two hydraulic snubbers control the rate that the door moves and they stop the door before it can hit the underside of the fuselage.

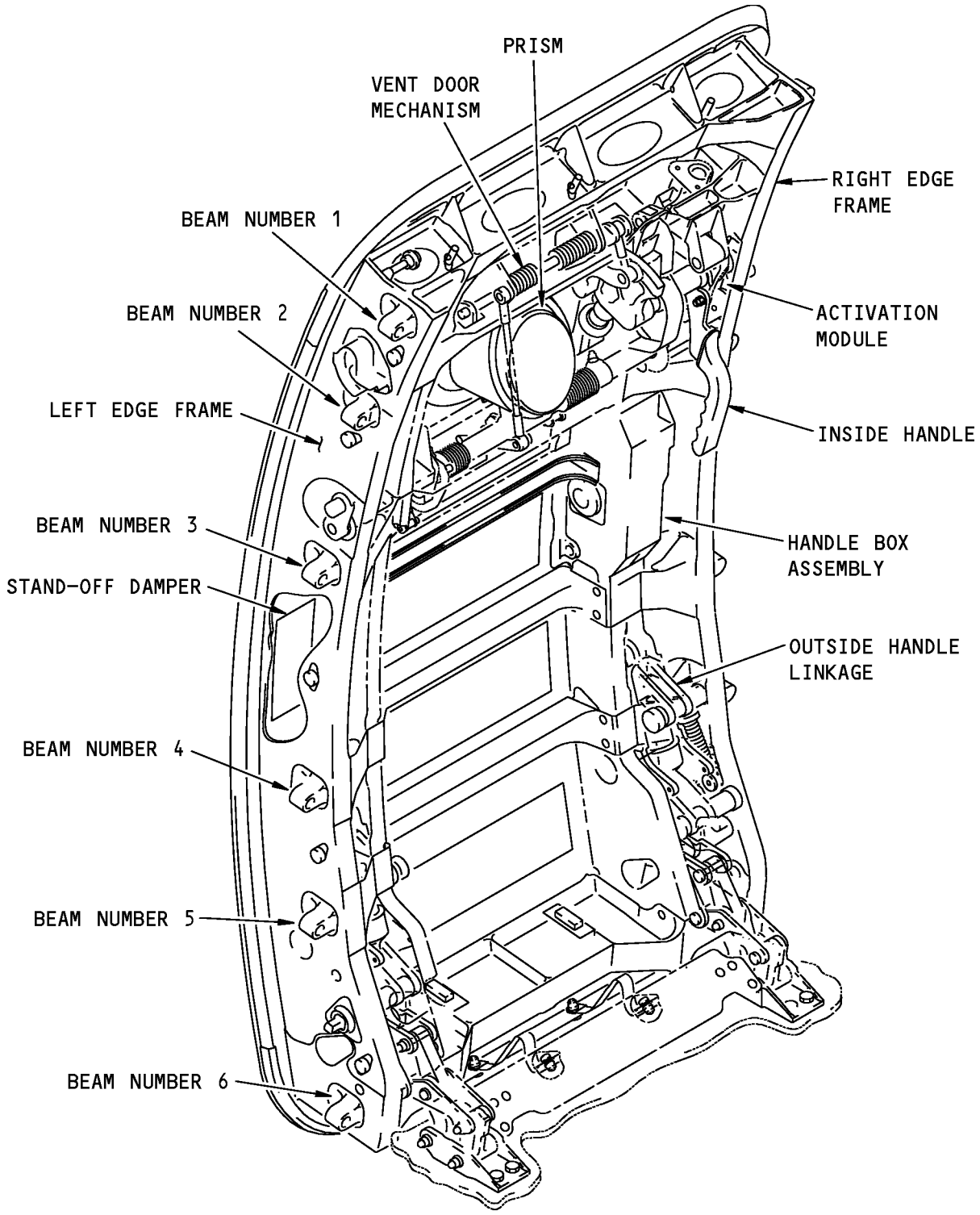
3. Leading Particulars (approximate)

A. Length - 52 inches

Width - 24 inches

Depth - 12 inches

Weight - 75 pounds



Emergency Exit Door Assembly
Figure 1

(NOT APPLICABLE)

DISASSEMBLY

1. **General**
   A. This procedure tells how to disassemble the emergency exit door unit.
   B. Disassemble this unit only sufficiently to isolate defects, to do the necessary repairs, and to put the unit back in a serviceable condition.
   C. Refer to IPL Figure 1 thru IPL Figure 4 for item numbers, as applicable.
2. **Disassembly**
   A. Special tools
      (1) Reserved.
   B. Parts Replacement

      NOTE: These parts are recommended for replacement. Replacement of other parts can be by in-service experience.

      (1) Cotter pins
      (2) Rubber parts
      (3) Rub strips
      (4) Cork parts
   C. Procedure
      (1) Use standard industry practices and these steps.
      (2) Do not disassemble these subassemblies unless necessary for repair or replacement. (Refer to REPAIR for procedures to overhaul these subassemblies.)
         (a) Activation modules (85, 90, 120, 125, IPL Figure 1)
         (b) Structure installations (150, 155, 225, 230, IPL Figure 1)
         (c) Prism assembly (180, IPL Figure 1)
         (d) Beam assemblies (335, 375, 400, 405, 425, 450, 475, IPL Figure 1)
         (e) Viewport frame assembly (520, IPL Figure 1)
         (f) Handle box assembly (575, IPL Figure 1)
         (g) Left edge frame assembly (685, IPL Figure 1)
         (h) Right edge frame assembly (765, IPL Figure 1)
         (i) Vent door mechanism assembly (55, IPL Figure 2)
         (j) Push rod assembly (90, 140, IPL Figure 2)
         (k) Bearing housing assembly (325, IPL Figure 2)
         (l) Shaft assembly (380, IPL Figure 2)
         (m) Pin assembly (480, 530, IPL Figure 2)
         (n) Link assembly (620, IPL Figure 2)
         (o) Handle assembly (635, IPL Figure 2)
         (p) Cover assembly (670, IPL Figure 2)
         (q) Clutch link assembly (780, IPL Figure 2)
         (r) Cam assembly (90, 231, IPL Figure 3)

(s) Fitting assembly (120, 129, 159, 303, IPL Figure 3)

(t) Idler assembly (288, IPL Figure 3)

(u) Link assembly (315, IPL Figure 3)

(v) Pressure lock mechanism assembly (414, IPL Figure 3)

(w) Flight lock assembly (525, IPL Figure 3)

(x) Latch shaft assembly (576, IPL Figure 3)

(y) Snubber mechanism assembly (225, 230, IPL Figure 4)

(z) Idler assembly (295, 300, 380, IPL Figure 4)

(aa) Spring assembly (330, IPL Figure 4)

(ab) Link assembly (400, 405, IPL Figure 4)

CLEANING

1. General

A. This procedure tells how to clean the specified parts.

B. Refer to the Standard Overhaul Practices Manual (SOPM) for details of the standard practices specified in the procedure.

C. Refer to IPL Figure 1 thru IPL Figure 4 for item numbers.

2. Cleaning

A. References

Reference	Title
SOPM 20-30-03	GENERAL CLEANING PROCEDURES
SOPM 20-44-02	TEMPORARY PROTECTIVE COATINGS
SOPM 20-70-01	PROTECTION, STORAGE AND HANDLING OF AIRPLANE COMPONENTS

B. Procedure

(1) Clean all parts but prism (190A, IPL Figure 1) by standard industry practices and the instructions in SOPM 20-30-03.

(2) Prism (190A, IPL Figure 1)

NOTE: The prism material is acrylic plastic per AMS-L-P-391, Grade C, Type 1.

CAUTION: DO NOT RUB SURFACES OF THE PRISM WITH ABRASIVES UNLESS AS NECESSARY DURING REPAIR. DO NOT USE ALCOHOL, KEROSENE, BENZENE, XYLENE, KETONES SUCH AS ACETONE, CARBON TETRACHLORIDE, DE-ICING FLUIDS, LACQUER THINNERS, AROMATIC HYDROCARBONS, ETHERS, GLASS CLEANING COMPOUNDS OR OTHER UNAPPROVED SOLVENTS, BECAUSE THEY WILL DAMAGE THE PRISM SURFACE.

(a) Clean the prism with lukewarm water and castile soap. Use a soft, clean chamois cloth to apply the soap solution to the prism surface.

(b) Rinse with clean water and wipe dry with a clean, damp chamois cloth.

(c) Give protection to the cleaned prism and put it away by standard industry practices and the instructions in SOPM 20-44-02 and SOPM 20-70-01.

CHECK

1. General

A. This procedure tells how to find defects in the specified parts.

B. Refer to FITS AND CLEARANCES for design dimensions and wear limits.

C. Refer to the Standard Overhaul Practices Manual (SOPM) for details of the standard practices specified in the procedure.

D. Refer to IPL Figure 1 thru IPL Figure 4 for item numbers, as applicable.

2. Check

A. References

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

B. Procedure

(1) Examine all parts for defects by standard industry practices.

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

(a) Switch actuator (145, IPL Figure 1)

(b) Push rod (105, IPL Figure 2)

(c) Stop (445, IPL Figure 2)

(d) Shafts (78, 522, 651, IPL Figure 3)

(e) Cams (99, 233, IPL Figure 3)

(f) Washer (141, IPL Figure 3)

(g) Idlers (156, 300, IPL Figure 3)

(h) Fittings (175, 207, 312, IPL Figure 3)

(i) Target (200A, IPL Figure 3)

(j) Cranks (489, 513, 618, 630, IPL Figure 3)

(k) Catches (639, 648, IPL Figure 3)

(l) Washers (365, 370, IPL Figure 4)

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

(a) Handle (115, IPL Figure 1)

(b) Springs (195, 200, 665, 642, IPL Figure 2). Be sure to extend the spring during the check to look for defects between the coils.

(c) Sleeve (205, IPL Figure 2)

(d) Door (310, IPL Figure 2)

(e) Spacers (81, 84, 87, IPL Figure 3)

(f) Fittings (126, 135, 168, 324, IPL Figure 3)

(g) Springs (138, 519, 633, IPL Figure 3). Be sure to extend the spring during the check to look for defects between the coils.

(h) Washer (141, IPL Figure 3)

(i) Link (321, IPL Figure 3)

(j) Plate (332, IPL Figure 3)

(k) Housings (459, 462, IPL Figure 3)

(l) Fittings (265, 270, 290, IPL Figure 4)

(m) Idlers (320, 325, IPL Figure 4)

(n) Spring (375, IPL Figure 4)

(o) Idler (395, IPL Figure 4)

(p) Links (415, 420, IPL Figure 4)

(4) Springs

(a) Do a load check on each spring as shown in CHECK, Figure 501 thru CHECK, Figure 506.

(5) Prism (190A, IPL Figure 1)

(a) Defect definitions (CHECK, Figure 507):

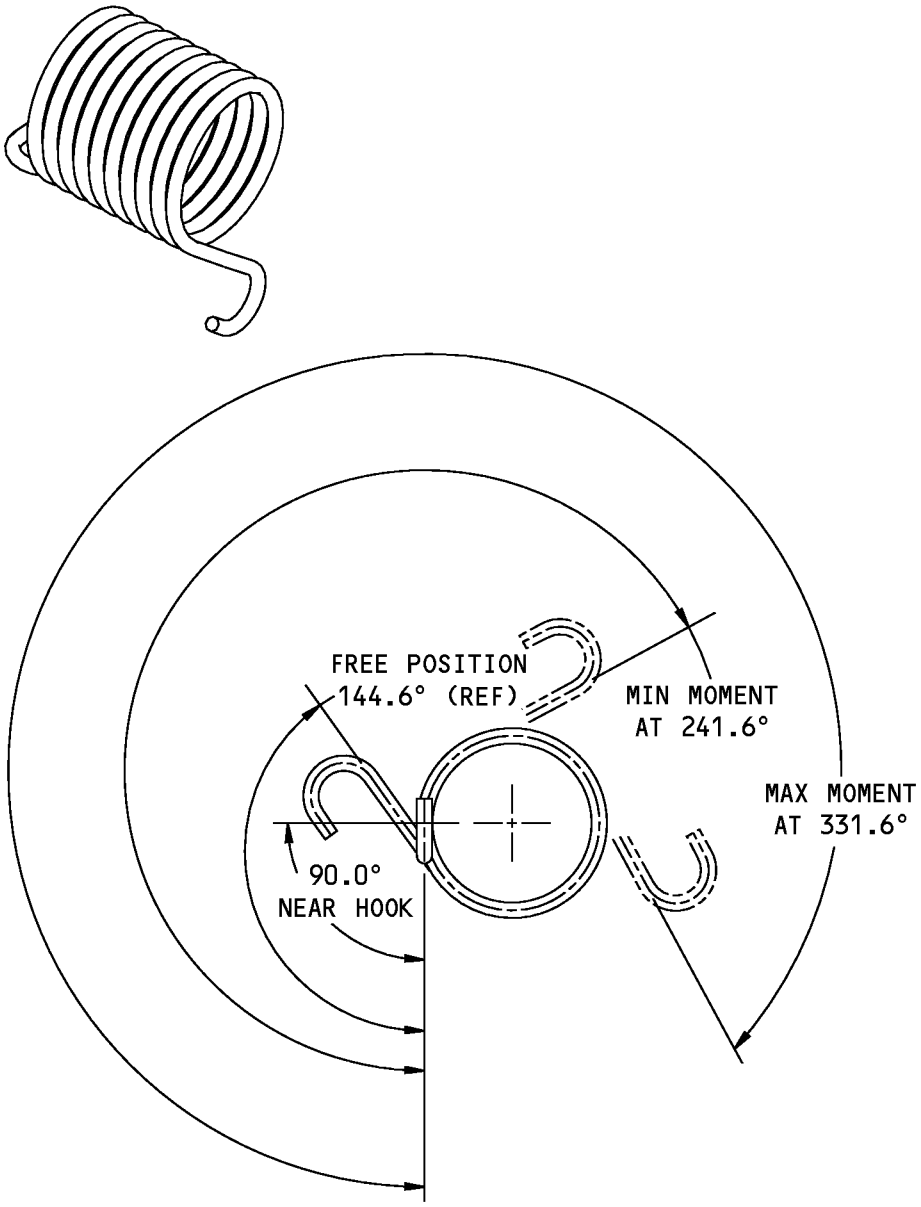
1) Cracks: Fissures with visible width when viewed parallel to the surface. A crack can grow at any angle to the surface, based on the direction of the force. A scratched or crazed surface can let the crack become longer.

2) Crazing: Very fine fissures on the surface. They have no visible depth or width. They will start to be noticeable when they are 0.002-0.004 inch deep. In dim light, and light perpendicular to the surface, they are not easy to see. But in a bright light at an angle to the surface, the surface has a frosted appearance.

3) Scratch: The removal of material from the surface, usually along a straight line or a curve. The depth of a scratch is not usually more than its width.

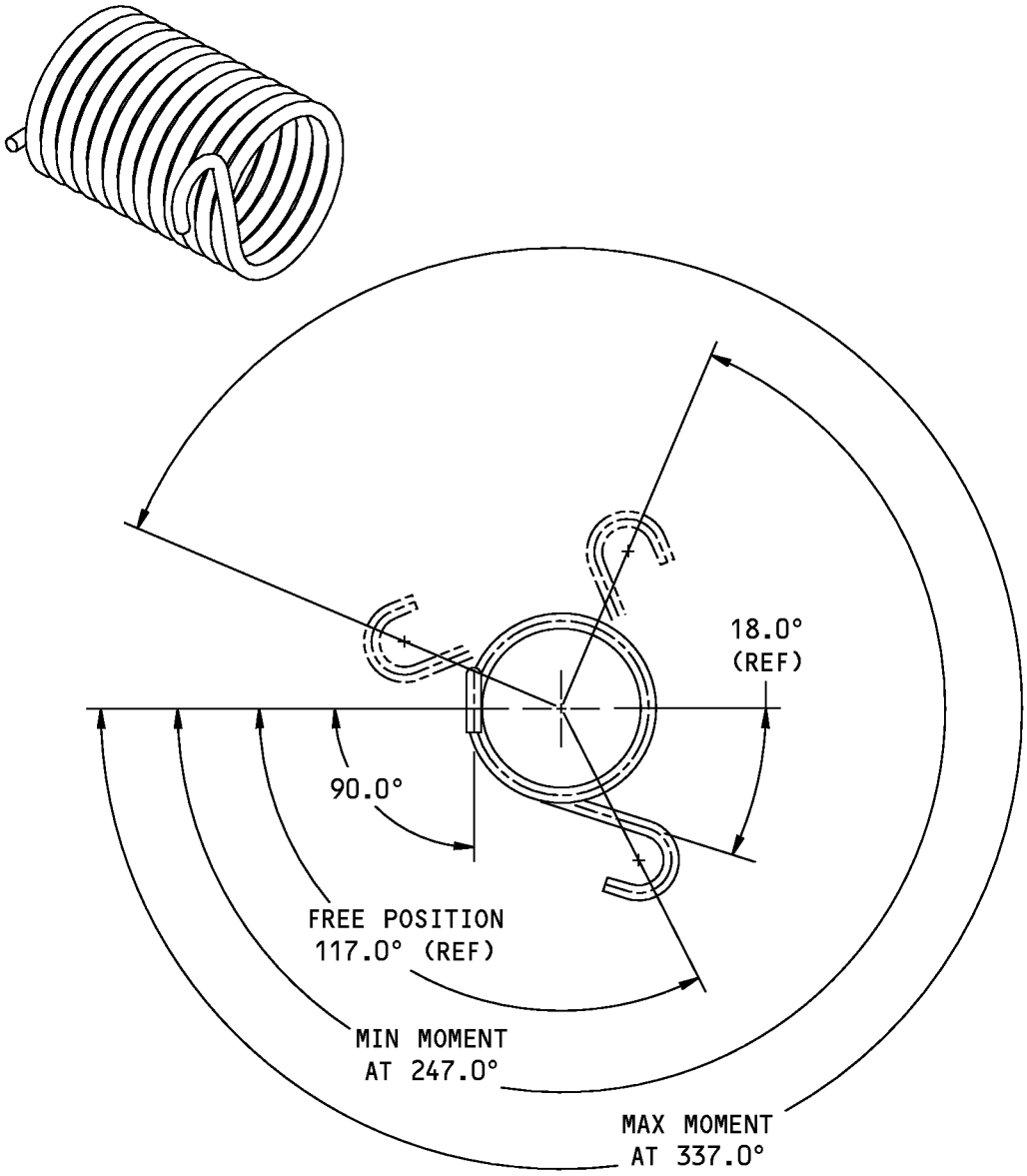
4) Chips: Pieces of material broken from the surface. Shell type chips have a curved edge with many fine hairlines or ridges that follow the outer edge and become smaller towards the center of the chip (almost the same as the growth lines on a clamshell). V-shaped chips have a sharp, narrow cross-section and become larger towards the center.

(b) Examine the prism for defects such as cracks, crazing, scratches and chips. If you find defects, refer to REPAIR 2-1 for repair instructions.



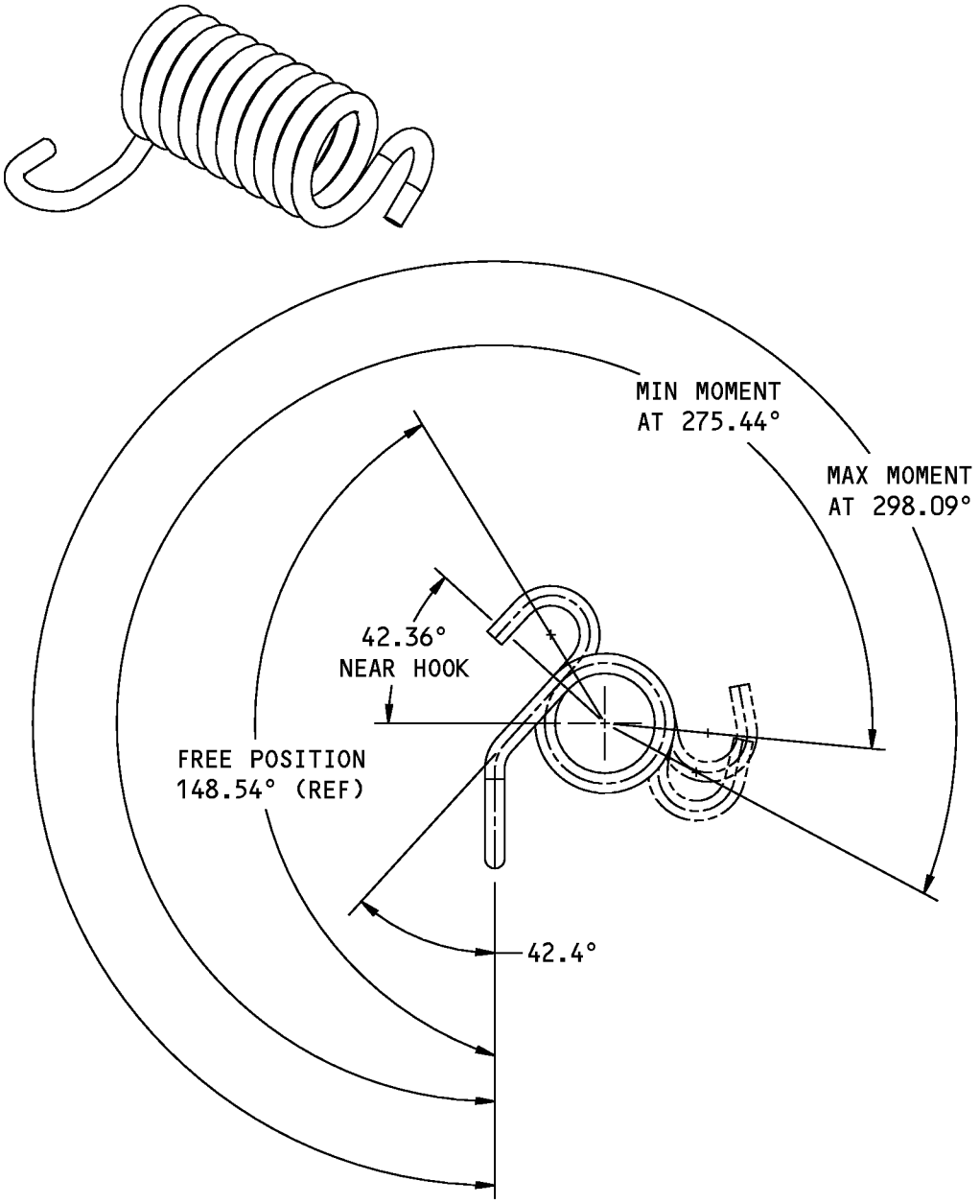
POSITION	MOMENT (INCH-POUNDS)
144.6°	0 (FREE POSITION)
241.6°	5.85-7.15
331.6°	11.25-13.75

146A6511-3 Spring Check
Figure 501



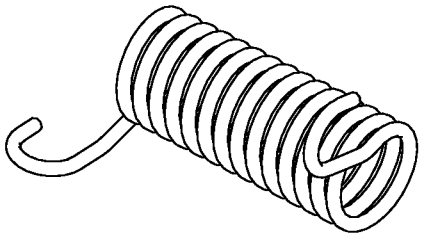
POSITION	MOMENT (INCH-POUNDS)
117.0°	0 (FREE POSITION)
247.0°	5.85-7.15
337.0°	9.90-12.10

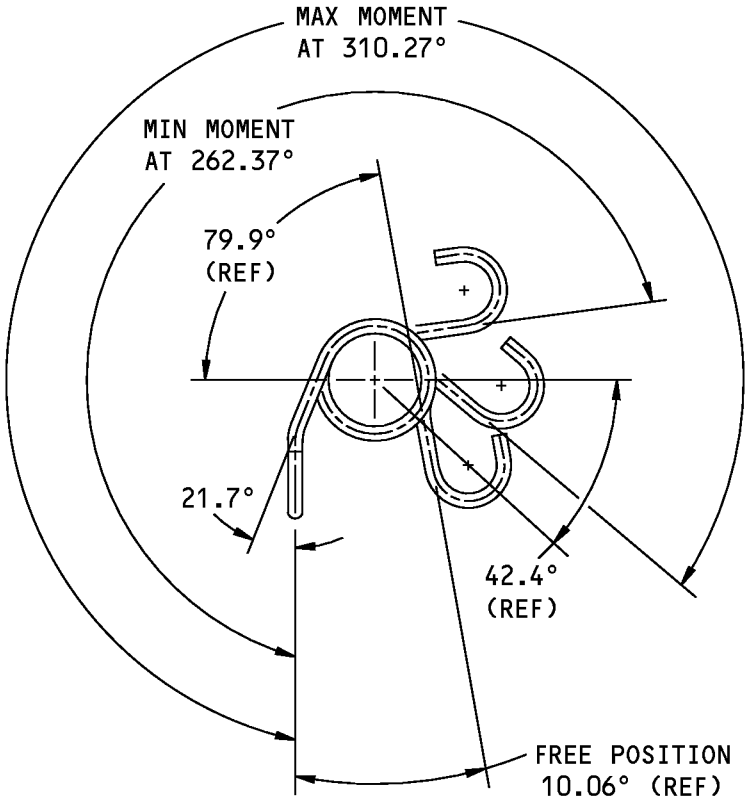
146A6511-4 Spring Check
Figure 502



POSITION	MOMENT (INCH-POUNDS)
148.54°	0 (FREE POSITION)
275.44°	36.81-44.99
298.09°	43.38-53.02

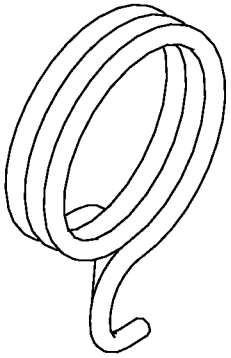
146A6511-5 Spring Check
Figure 503

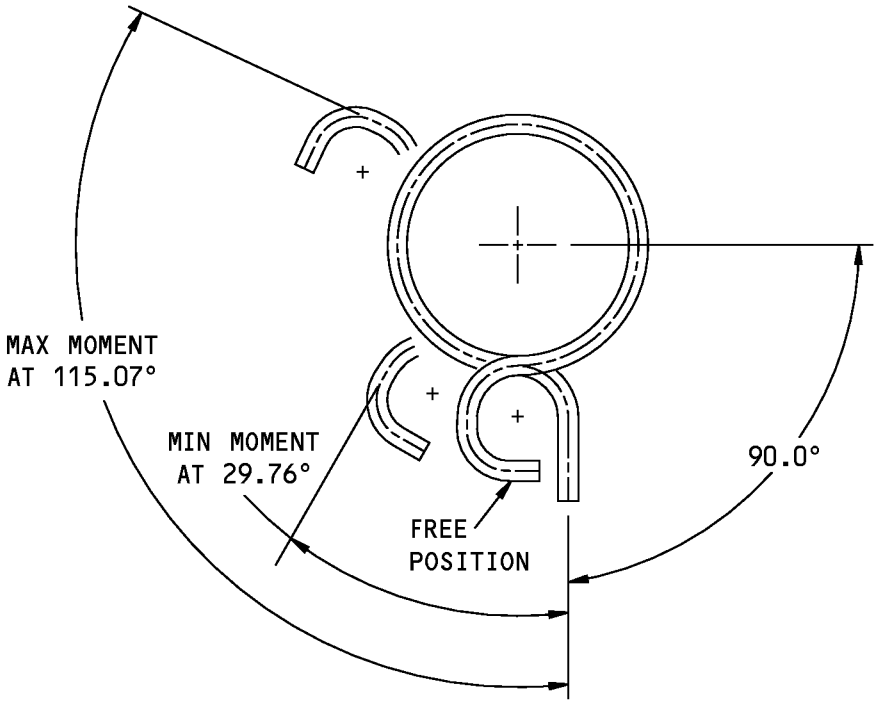




POSITION	MOMENT (INCH-POUNDS)
10.06°	0 (FREE POSITION)
262.37°	16.38-20.02
310.27°	19.26-23.54

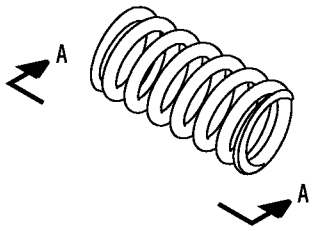
146A6511-7,-8 Spring Check
Figure 504

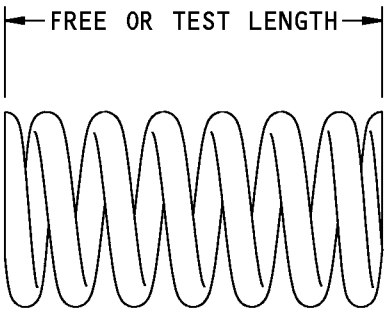




POSITION	MOMENT (INCH-POUNDS)
0°	0 (FREE POSITION)
29.76°	13.50-16.50
115.07°	52.20-63.80

146A6511-9 Spring Check
Figure 505

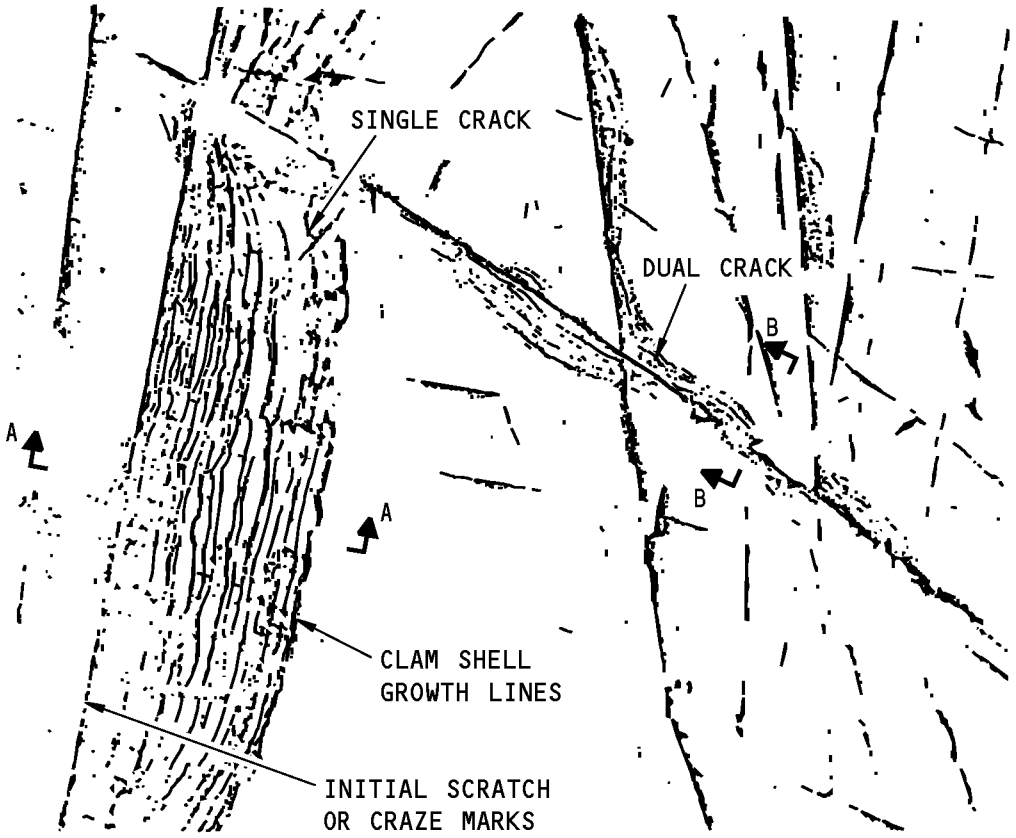




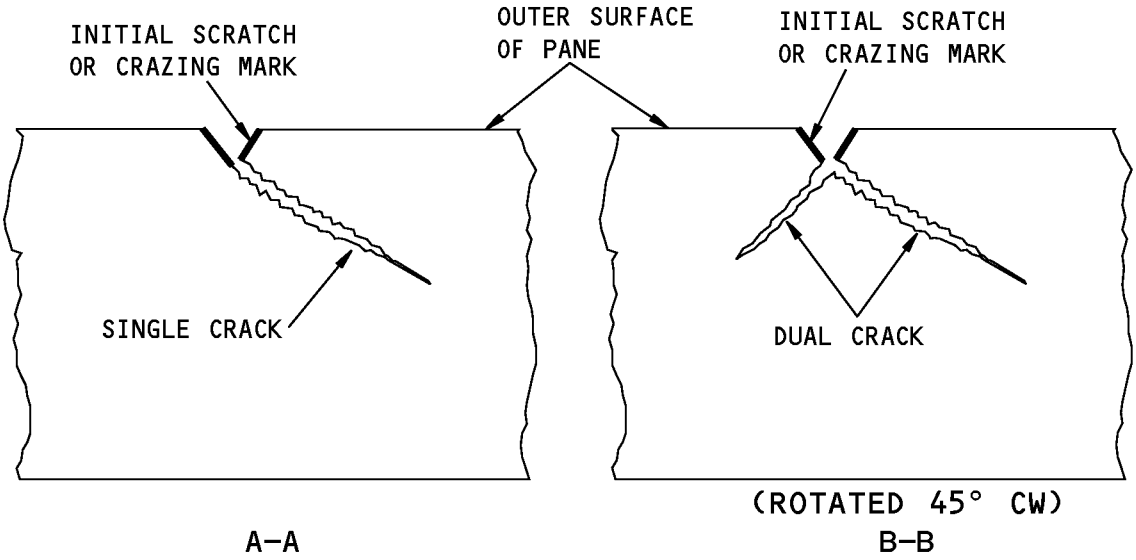
A–A

PART NUMBER	APPROXIMATE FREE LENGTH (INCHES)	TEST LENGTH (INCHES)	LOAD LIMITS (POUNDS)
146A6558–1	5.4090	2.5000 3.0470	107.00–127.00 85.00–105.00
146A6558–3	4.6677	2.5000 3.0600	193.73–237.73 144.00–176.00
146A6585–1	3.1240	1.8100 2.4000	260.00–280.00 140.00–160.00

Spring Check
Figure 506



PRISM SURFACE WITH DEFECTS



Prism Surface Defects
Figure 507

REPAIR

1. General

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

PART NUMBER	NAME	REPAIR
———	REFINISH OF OTHER PARTS	1-1
140N2035	PRISM ASSEMBLY	2-1
140N2764	PRISM	2-2
146A6251	INSIDE HANDLE	3-1
146A6421	BEAM ASSEMBLY #1	4-1, 4-2
146A6422	BEAM ASSEMBLY #2	4-1, 4-2
146A6423	BEAM ASSEMBLY #3	4-1, 4-2
146A6424	BEAM ASSEMBLY #4	4-1, 4-2
146A6425	BEAM ASSEMBLY #5	4-1, 4-2
146A6426	BEAM ASSEMBLY #6	4-1, 4-2
146A6428	VIEWPORT FRAME ASSEMBLY	5-1
146A6445	HANDLE BOX ASSEMBLY	6-1, 6-2
146A6509	PRESSURE LOCK MECHANISM ASSEMBLY	7-1
146A6510	CRANK ASSEMBLY	8-1, 8-2
146A6512	BEARING HOUSING ASSEMBLY	9-1, 9-2
146A6520	LATCH SHAFT ASSEMBLY	10-1
146A6521	SHAFT	11-1
146A6522	LATCH CRANK ASSEMBLY	12-1, 12-2
146A6524	HANDLE CRANK ASSEMBLY	13-1, 13-2
146A6526	OUTSIDE HANDLE ASSEMBLY	14-1, 14-2
146A6527	HANDLE LINK ASSEMBLY	15-1, 15-2
146A6530	PUSH ROD ASSEMBLY	16-1, 16-2
146A6532	OUTSIDE HANDLE SHAFT ASSEMBLY	17-1
146A6535	OUTSIDE CRANK ASSEMBLY	18-1, 18-2
146A6536	HANDLE LINK CRANK ASSEMBLY	19-1, 19-2
146A6537	OUTSIDE HANDLE CRANK SHAFT	20-1
146A6539	VENT DOOR MECHANISM ASSEMBLY	21-1

PART NUMBER	NAME	REPAIR
146A6540	VENT DOOR ASSEMBLY	22-1
146A6545	SHAFT	23-1
146A6546	BEARING HOUSING ASSEMBLY	24-1, 24-2
146A6547	VENT DOOR CRANK ASSEMBLY	25-1, 25-2
146A6551	SNUBBER FITTING ASSEMBLY	26-1, 26-2
146A6552	UPPER SNUBBER SUPPORT IDLER ASSEMBLY	27-1, 27-2
146A6553	LOWER SNUBBER SUPPORT IDLER ASSEMBLY	28-1, 28-2
146A6554	SNUBBER LINK ASSEMBLY	29-1, 29-2
146A6555	LIFT ASSIST FITTING ASSEMBLY	30-1, 30-2
146A6556	LIFT ASSIST SPRING ASSEMBLY	31-1
146A6557	END FITTING ASSEMBLY	32-1, 32-2
146A6562	MECHANISM SNUBBER ASSEMBLY	33-1
146A6575	LOCK SHAFT IDLER ASSEMBLY	34-1, 34-2
146A6576	LOCK FITTING ASSEMBLY	35-1, 35-2
146A6577	OVERCENTER SPRING FITTING ASSEMBLY	36-1, 36-2
146A6578	LINK ASSEMBLY	37-1, 37-2
146A6579	LOCK TARGET ASSEMBLY	38-1
146A6580	LOCK CAM ASSEMBLY	39-1
146A6581	LOCK SHAFT	40-1
146A6586	LOCK FITTING	41-1
146A6589	OUTSIDE HANDLE COVER ASSEMBLY	42-1
146A6590	OUTSIDE HANDLE CLUTCH LINK ASSEMBLY	43-1
146A6591	BEARING HOUSING ASSEMBLY	44-1, 44-2
146A6592	OUTSIDE HANDLE SUPPORT	45-1
146A6597	OUTSIDE HANDLE PIN ASSEMBLY	46-1, 46-2

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)
(ST)	STATISTICAL TOLERANCE
↔	BETWEEN
∅	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
(F)	FREE STATE
(T)	TANGENT PLANE
(M)	MAXIMUM MATERIAL CONDITION (MMC)
(L)	LEAST MATERIAL CONDITION (LMC)
(S)	REGARDLESS OF FEATURE SIZE (RFS)
(P)	PROJECTED TOLERANCE ZONE
FIM	FULL INDICATOR MOVEMENT
TIR	TOTAL INDICATOR READING

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] 0.510 (P)	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 tells how to refinish the parts which are not in the other repairs.

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

C. Refer to IPL Figure 1 thru IPL Figure 4 for item numbers, as applicable.

2. Refinish of Other Parts

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
C00802	Coating - Nylon	BAC5710, Type 49

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

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

(2) Refer to REPAIR 1-1, Table 601 for the refinish details. Refer to SOPM 20-30-02 for stripping of protective finishes. Refer to SOPM 20-41-01 for the decoding table for Boeing finish codes. Refer to SOPM 20-60-02 for finishing materials.

Table 601: Refinish Details

IPL FIG. & ITEM	MATERIAL	FINISH
IPL Fig. 1		
Switch Actuator (145)	15-5PH CRES, 180-200 ksi	Passivate (F-17.25).
Retainer (175)	Al alloy	Chemical treat (F-17.07). Apply BMS 10-11, Type 1 primer, C00259 (F-20.03).
Frames (535, 760, 905)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply BMS 10-11, Type 1 primer, C00259 (F-20.03).
Cover plate (580)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply BMS 10-11, Type 1 primer, C00259 (F-20.03).
Support (595)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply BMS 10-11, Type 1 primer, C00259 (F-20.03).

Table 601: Refinish Details (Continued)

IPL FIG. & ITEM	MATERIAL	FINISH
Retainer (855)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply BMS 10-11, Type 1 primer, C00259 (F-20.03).
IPL Fig. 2		
Springs (195, 200, 665)	Ti alloy	With the spring extended, apply primer and Type 49 coating, C00802 (F-21.14).
Sleeve (205)	15-15PH CRES, 180-200 ksi	Passivate (F-17.25).
Stop (445)	15-15PH CRES, 180-200 ksi	Cadmium plate (F-16.06). Apply BMS 10-11, Type 1 primer, C00259 (F-20.02).
Sleeve (660)	Nylon	No finish.
Sleeve (730)	17-4PH	Cadmium plate (F-15.06).
Cover (740)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply BMS 10-11, Type 1 primer, C00259 (F-20.03).
IPL Fig. 3		
Spacers (81, 84, 87)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply BMS 10-11, Type 1 primer, C00259 (F-20.03).
Springs (138, 519, 636, 642)	Ti alloy	With the spring extended, apply primer and Type 49 coating, C00802 (F-21.14).
Washer (141)	15-15PH CRES, 180-200 ksi	Passivate (F-17.25).
Target (200A)	15-15PH CRES, 180-200 ksi	Passivate (F-17.25).
Fitting (207)	15-15PH CRES, 180-200 ksi	Cadmium plate (F-15.06). Apply BMS 10-11, Type 1 primer, C00259 (F-20.03), but not on lug faces or around the large hole.
Fitting (324)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply BMS 10-11, Type 1 primer, C00259 (F-20.03).
Plate (332)	Al alloy	Chemical treat (F-17.07). Apply BMS 10-11, Type 1 primer, C00259 (F-20.03).
Sleeves (516, 633, 645)	Nylon	No finish.
Catches (639, 648)	15-15PH CRES, 180-200 ksi	Passivate (F-17.25).
IPL Fig. 4		
Washer (365, 370)	15-15PH CRES, 180-200 ksi	Passivate (F-17.25).

PRISM ASSEMBLY - REPAIR 2-1

140N2035–1

1. General

A. This procedure tells how to replace the parts of prism assembly (180).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 1 for item numbers.

2. Parts Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00027	Adhesive - Silicone Rubber, 1 Part, RTV	BAC5010, Type 60
A00923	Adhesive - Silicone	BAC5010, Type 77

B. References

Reference	Title
SOPM 20-50-12	APPLICATION OF ADHESIVES
SOPM 20-60-04	MISCELLANEOUS MATERIALS

C. Procedure (REPAIR 2-1, Figure 601)

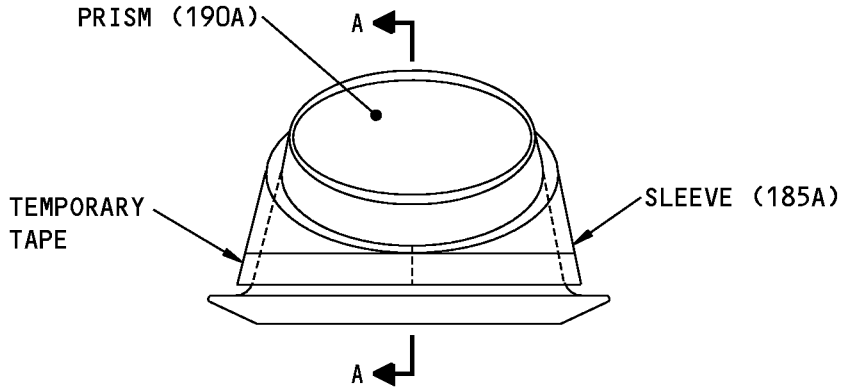
NOTE: For application of adhesives, refer to SOPM 20-50-12. For miscellaneous materials, refer to SOPM 20-60-04.

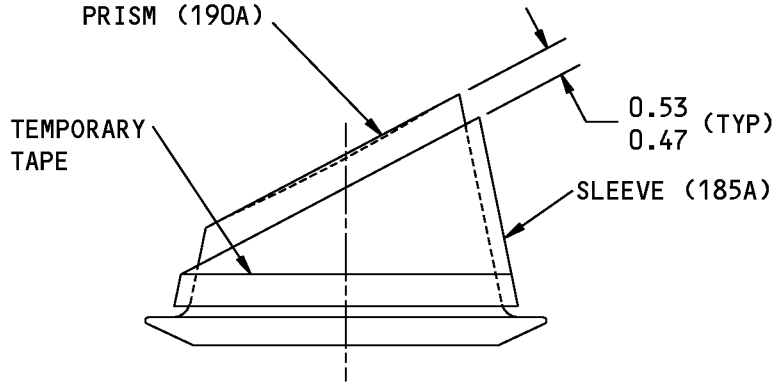
(1) Remove the old tape and sleeve from the prism.

(2) If you find defects on the prism surfaces, refer to REPAIR 2-2 for repair instructions.

(3) Install a replacement sleeve on the prism and bond it in position with a 1/4 inch wide bead of Type 60 adhesive, A00027 (SOPM 20-50-12). You can use duct tape to temporarily hold the sleeve in position until the adhesive cures.

(4) Or bond the sleeve to the prism and bond the end of the sleeve together with Type 77 adhesive, A00923 (SOPM 20-50-12). Remove unwanted adhesive from the inboard flat surface of the prism.





A–A

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

140N2035-1 Prism Assembly Parts Replacement
Figure 601

PRISM - REPAIR 2-2

140N2764–1

1. General

A. This procedure tells how to repair prism (190A).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 1 for item numbers.

2. Prism Repair

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
B00027	Compound - Buffing - Learok 884E (Formerly Learock 888)	

B. References

Reference	Title
SOPM 20-60-04	MISCELLANEOUS MATERIALS

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

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

CAUTION: MAKE SURE THE SURFACE OF THE PRISM STAYS COOL DURING REPAIR PROCEDURES. APPLY A SUFFICIENT QUANTITY OF WATER TO COOL IT DURING POLISHING OR SANDING OPERATIONS.

(1) Cover the sides of the prism with protective tape or coating.

(2) Remove small surface scratches with polish on a wet, clean cloth. Use a circular motion, start at the center, and work outward. Use clean, flannel cloth for each operation.

(3) Remove small scratches by machine polishing or buffing as follows:

(a) Buff if necessary with coarse compound (Learok S-30) on a stitched muslin wheel at a wheel surface speed of 3200 feet per minute. Be sure to keep the curvature of the surface.

(b) Polish to a high gloss with Learok 884E compound, B00027 on a loosely stitched flannel wheel at a wheel surface speed of 4200 feet per minute.

(4) Remove chips or major scratches by sanding as follows (REPAIR 2-2, Figure 601).

(a) Rub the surface of the prism with 100-grit abrasive paper, with a sanding block or a vibrating sander at 800 cpm. Remove a minimum of 0.005 inch of acrylic from the surface of the prism. Be sure to keep the curvature of the surface. Rub the surface until all surface defects are removed. Change the abrasive paper frequently.

(b) Smooth the surface with a vibrating sander with 100-grit abrasive paper. After 2 to 3 minutes, change to 200-grit abrasive paper. Then change to micromesh cloth. Start with 1600-grit micromesh cloth and go to 8000-grit micromesh cloth.

(c) Remove all unwanted material and water from the surface of the prism.

(d) Use buffing compound on a clean flannel cloth to polish the repaired surface of the prism.

(5) Examine the prism for optical quality. If the prism has unsatisfactory optical quality, replace the prism.

(6) Polish the prism with wax and apply a protective finish or protective tape.

3. Prism Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
C00566	Coating - Urethane	MIL-C-83286

B. References

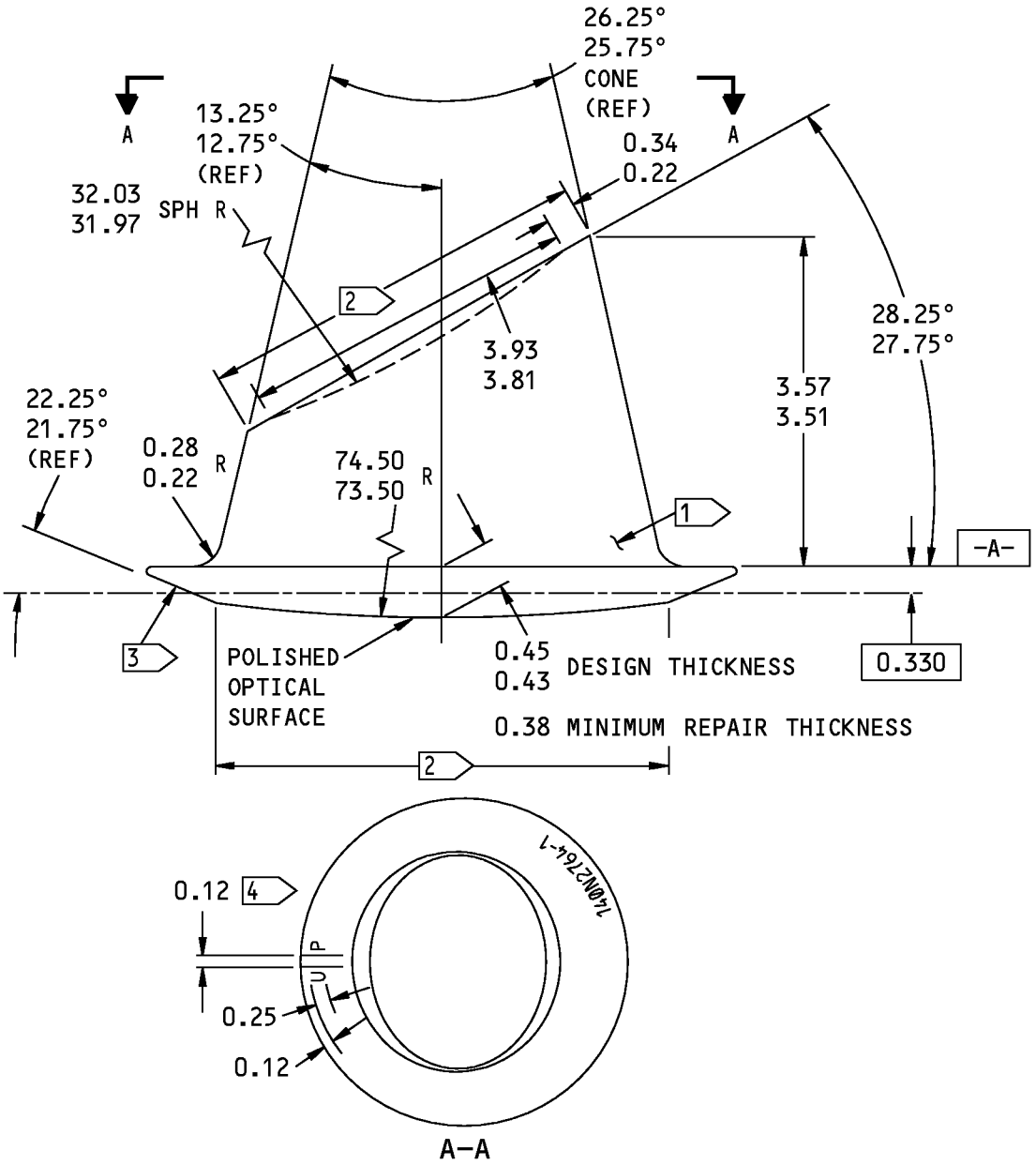
Reference	Title
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-50-10	APPLICATION OF STENCILS, INSIGNIA, SILK SCREEN, PART NUMBERING AND IDENTIFICATION MARKINGS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

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

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

(1) Apply Aquadex urethane coating, C00566 (F-30.004-701).

(2) Rubber stamp or stencil markings (SOPM 20-50-10) as shown.



1 APPLY AQUADEX URETHANE COATING COLOR BAC701 BLACK (F-30.004-701)

2 MAXIMUM DEPTH OF REPAIR 0.06 INCH. KEEP THE CURVATURE OF SURFACE DURING REPAIR

3 MAXIMUM DEPTH OF REPAIR 0.03 INCH, ON SEAL FACE

4 RUBBER STAMP OR STENCIL "UP" AND VERTICAL BAR (SOPM 20-50-10) (COLOR WHITE)

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

ALL DIMENSIONS ARE IN INCHES

140N2764-1 Prism Repair and Refinish
Figure 601

INSIDE HANDLE - REPAIR 3-1

146A6251–1

1. General

A. This procedure tells how to repair and refinish inside handle (115).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 1 for item numbers.

D. General repair details:

(1) Material: Al alloy

(2) Shot peen: not necessary

E. This handle can be seen from the airplane interior. Be careful not to damage surfaces the passengers will see.

2. Pin Repair

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

(1) Attachment holes

(a) Repair is only replacement of the original finish. Refer to REPAIR 3-1, Paragraph 3. below for details.

(b) If you think there are defects on important surfaces, see REPAIR 3-1, Figure 601 for dimension details.

(2) Handle surfaces

(a) Remove small defects by standard industry practices.

(b) Refinish as indicated.

3. Pin Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
C00040	Coating - Interior Decorative Urethane Topcoat, Semigloss	BMS10-83, 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

B. References

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

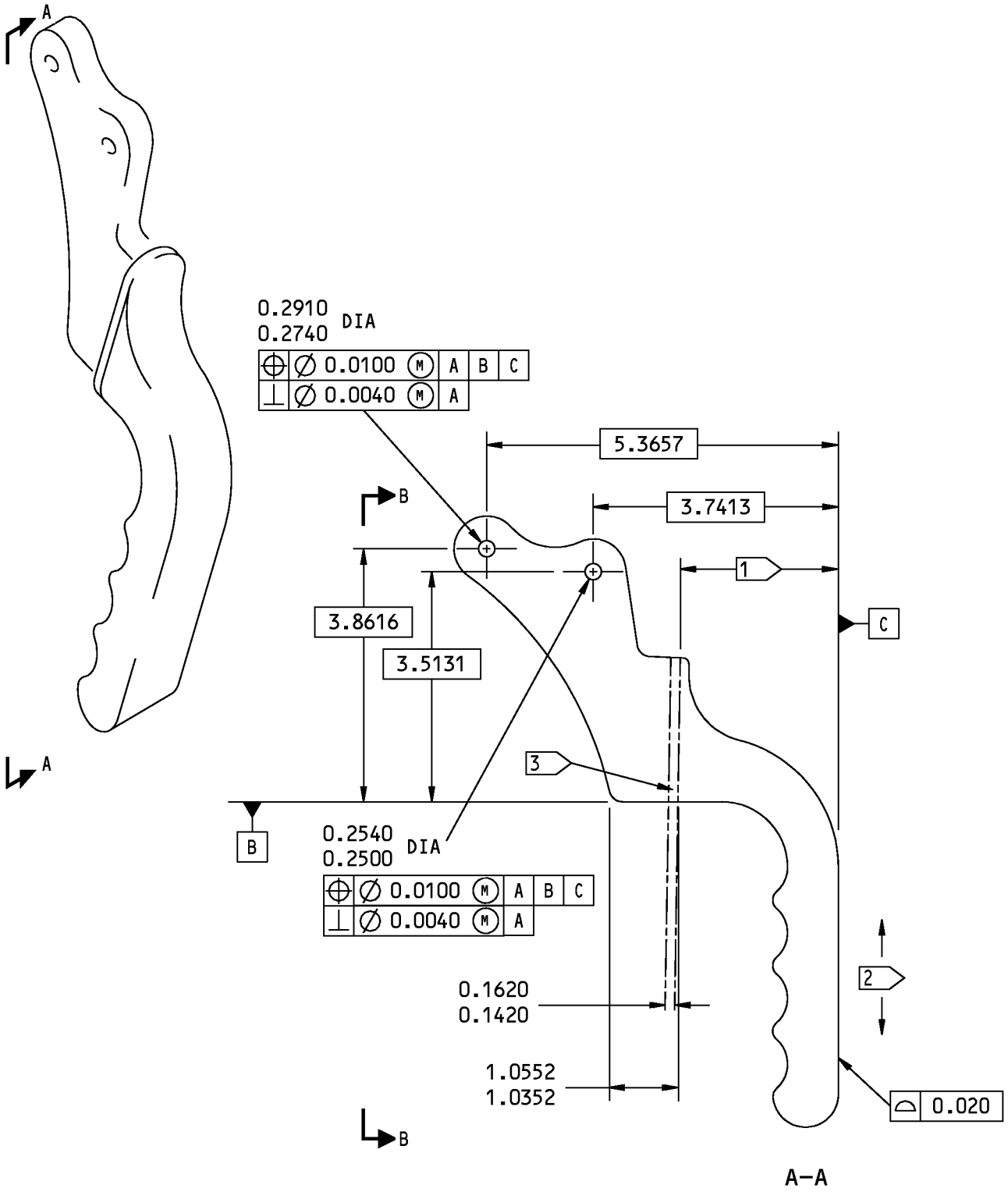
C. Procedure

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.

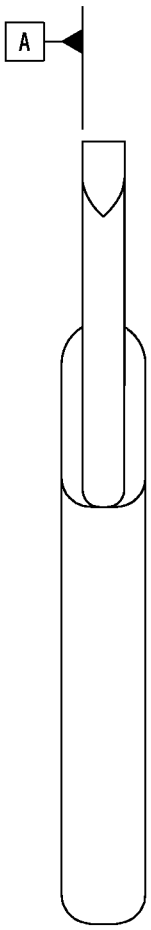
(1) Apply directional coarse grain finish and sulfuric acid anodize (F-14.29) in the areas shown.

(2) Apply BMS 10-11, Type 1 primer, C00259 all over unless shown.

(3) Apply white BMS 10-11, Type 2 coating, C00260 and red BMS 10-83, Type 2 coating, C00040 to the surfaces shown.



146A6251-1 Inside Handle Repair and Refinish
Figure 601 (Sheet 1 of 2)



B–B

1 APPLY DIRECTIONAL COARSE SATIN FINISH AND SULFURIC ACID ANODIZE (F-14.29) IN THIS AREA. NO PRIMER OR ENAMEL.

2 GRAIN DIRECTION: LONGITUDINAL

3 APPLY RED BMS 10-83 TYPE 2 ENAMEL (F-22.06-101) IN THIS AREA ONLY

146A6251-1 Inside Handle Repair and Refinish
Figure 601 (Sheet 2 of 2)

BEAM #1 THRU #6 ASSEMBLY - REPAIR 4-1

146A6421–1, 146A6422–1, –3, 146A6423–1, 146A6424–1, 146A6425–1, 146A6426–1, –3

1. General

A. This procedure tells how to replace the parts of beam assemblies (335, 375, 400, 425, 450, 475).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 1 for item numbers.

D. These beams can be seen from the airplane interior. Be careful not to damage surfaces the passengers will see.

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

C. Stop bushings (REPAIR 4-1, Figure 601 thru REPAIR 4-1, Figure 606)

(1) Remove the old bushing. It is a clearance fit, but the bushing tail was flared against the hole chamfer.

(2) If you find defects on the hole surfaces, refer to REPAIR 4-2 for repair instructions.

(3) Apply BMS 5-95 sealant, A00247 to the mating surfaces of the bushing and the lug hole, to make sure there will be a complete fay seal.

(4) Push the bushing flange tightly against the lug face, and then roller or anvil swage the bushing tail against the 45-degree countersink of the lug hole. Complete the swage during the cure time of the sealant. Be careful not to damage the lug face by the swaging operation.

(5) Immediately after the swage is complete, make sure the bushing does not turn if a maximum of 5 pound-inches torque is applied to the bushing flange.

(6) Wipe unwanted sealant from each end of the installed bushing. A small fillet of sealant can stay around the bushing flange.

D. Other bushings (REPAIR 4-1, Figure 606)

(1) Remove the old bushings.

(2) If you find defects on the hole surfaces, refer to REPAIR 4-2 for repair instructions.

(3) Install replacement bushings by the shrink fit method (SOPM 20-50-03) with BMS 5-95 sealant, A00247 as the installation finish.

3. Nutplate Replacement (REPAIR 4-1, Figure 601 thru REPAIR 4-1, Figure 606)

A. Remove the rivets and the bad nutplate.

B. Install a replacement nutplate with new rivets.

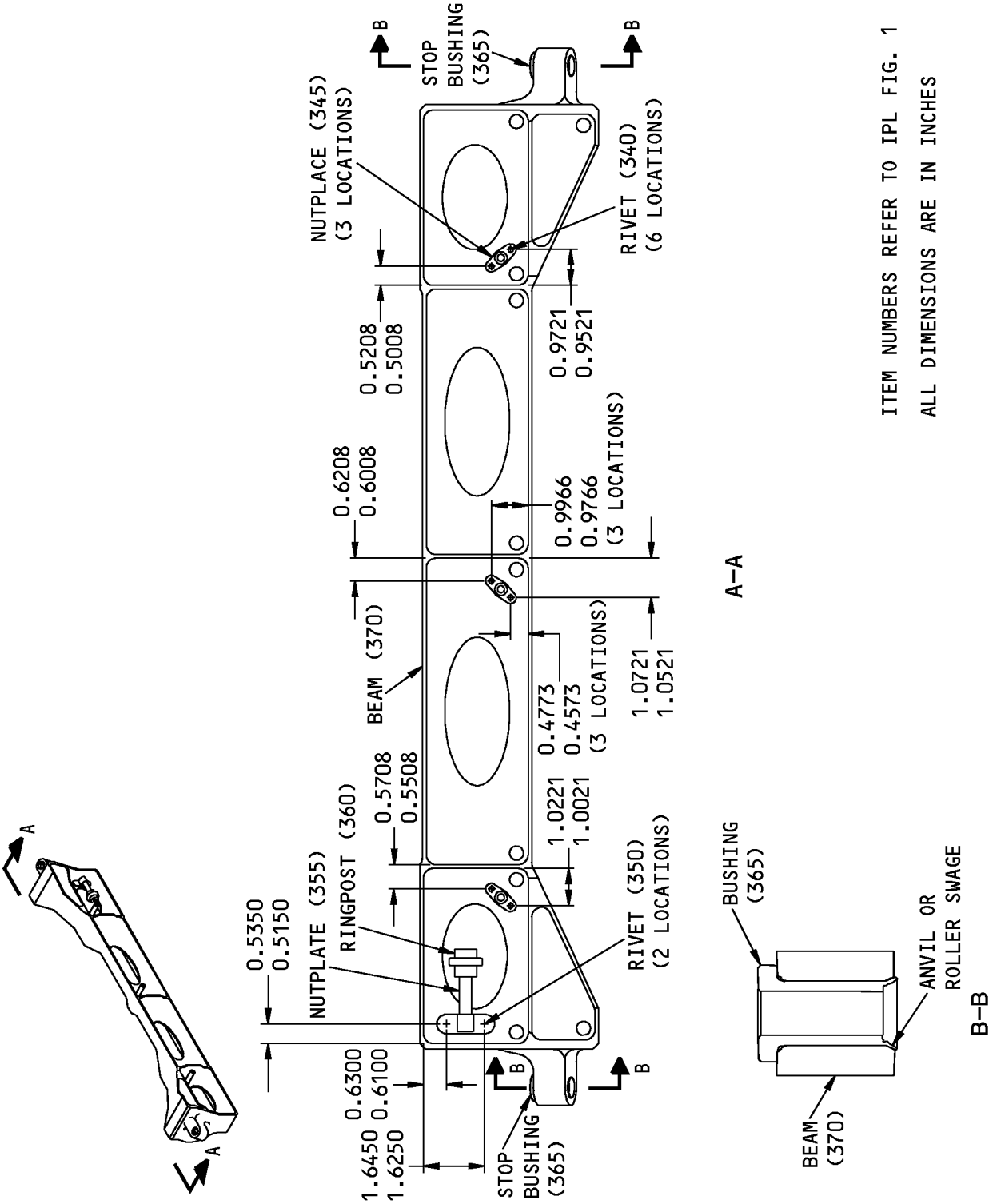
4. **Spring Retainer Hardware Replacement (REPAIR 4-1, Figure 602, REPAIR 4-1, Figure 603)**

A. Remove the old BACB30NR4K9 bolts and related fasteners from the holes.

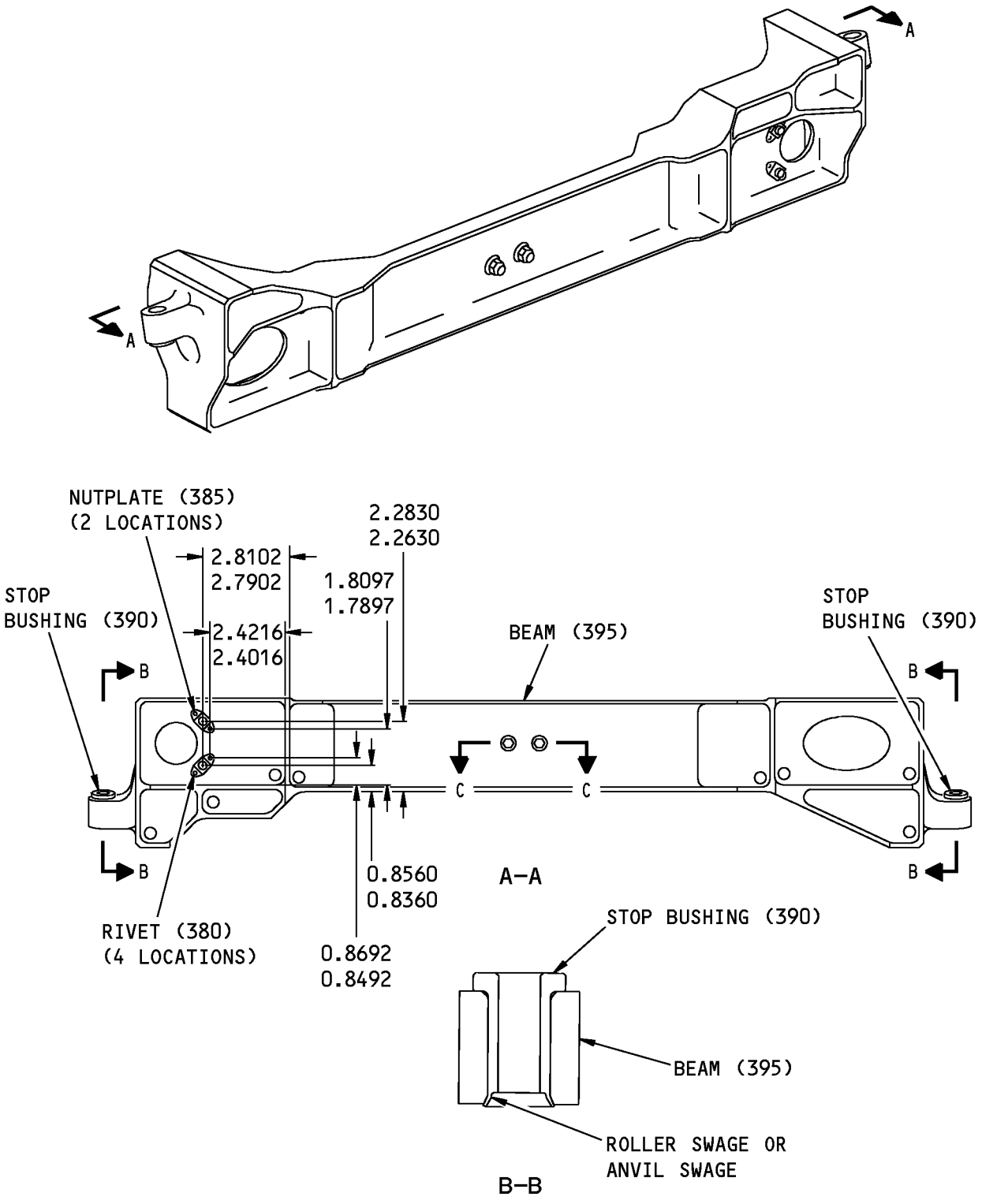
B. Remove old sealant and clean the holes.

C. Apply BMS 5-95 sealant, A00247 to the hole surfaces.

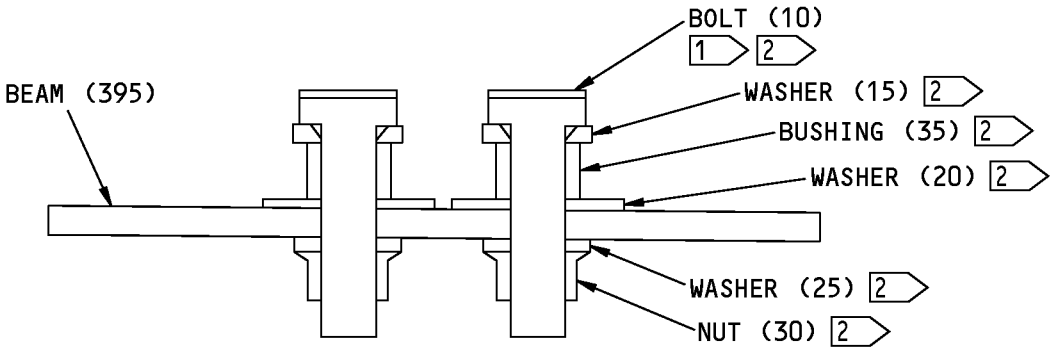
D. Install replacement bolts and related fasteners with wet BMS 5-95 sealant, A00247 (SOPM 20-50-19, Method 1).



146A6421-1 Beam #1 Assembly Parts Replacement
Figure 601



146A6422-1,-3 Beam #2 Assembly Parts Replacement
Figure 602 (Sheet 1 of 2)



C–C

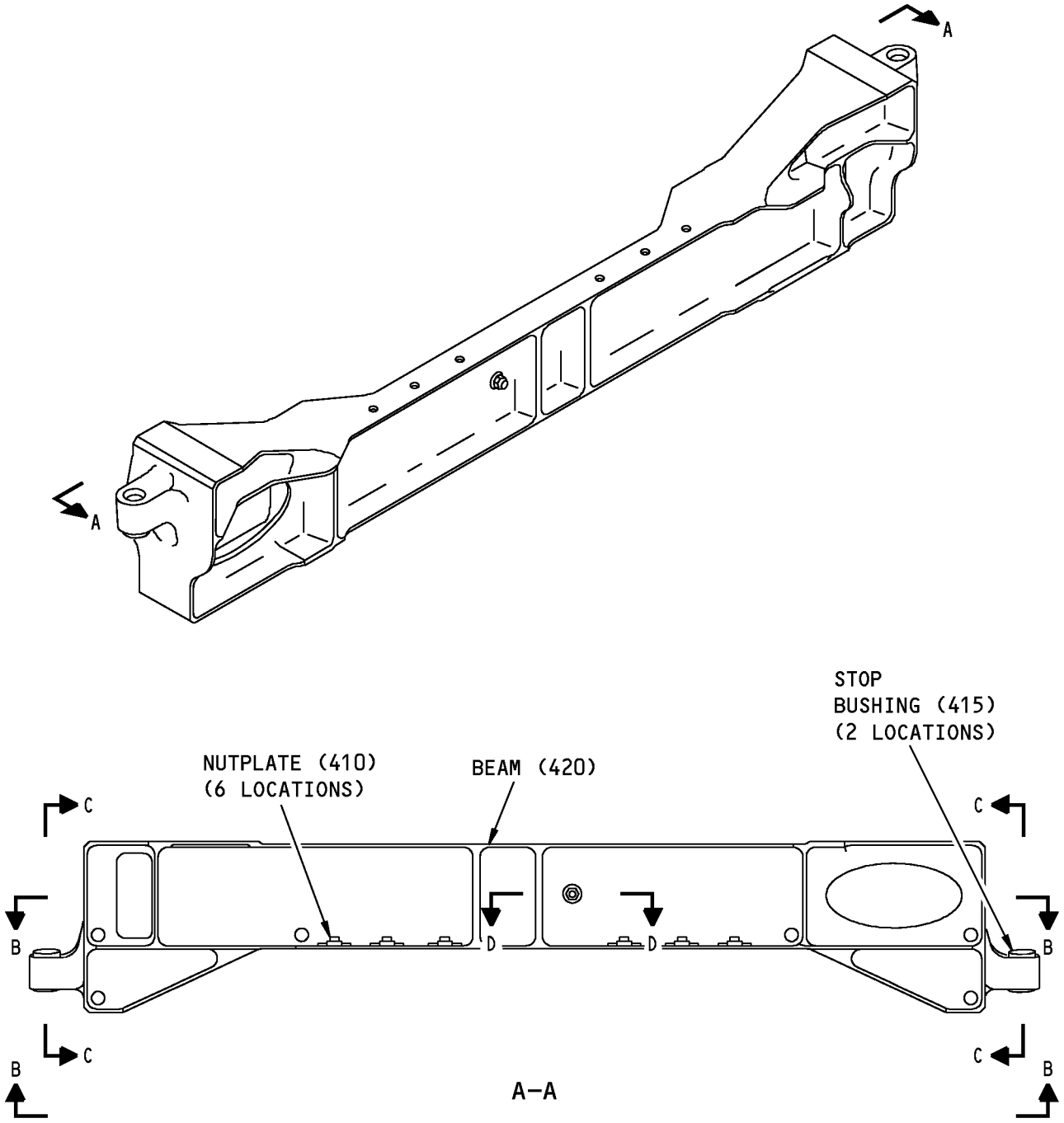
1 INSTALL THIS BOLT WITH BMS 5-95 SEALANT ON MATING SURFACES. SEE TEXT FOR PROCEDURE.

2 IPL FIG. 2

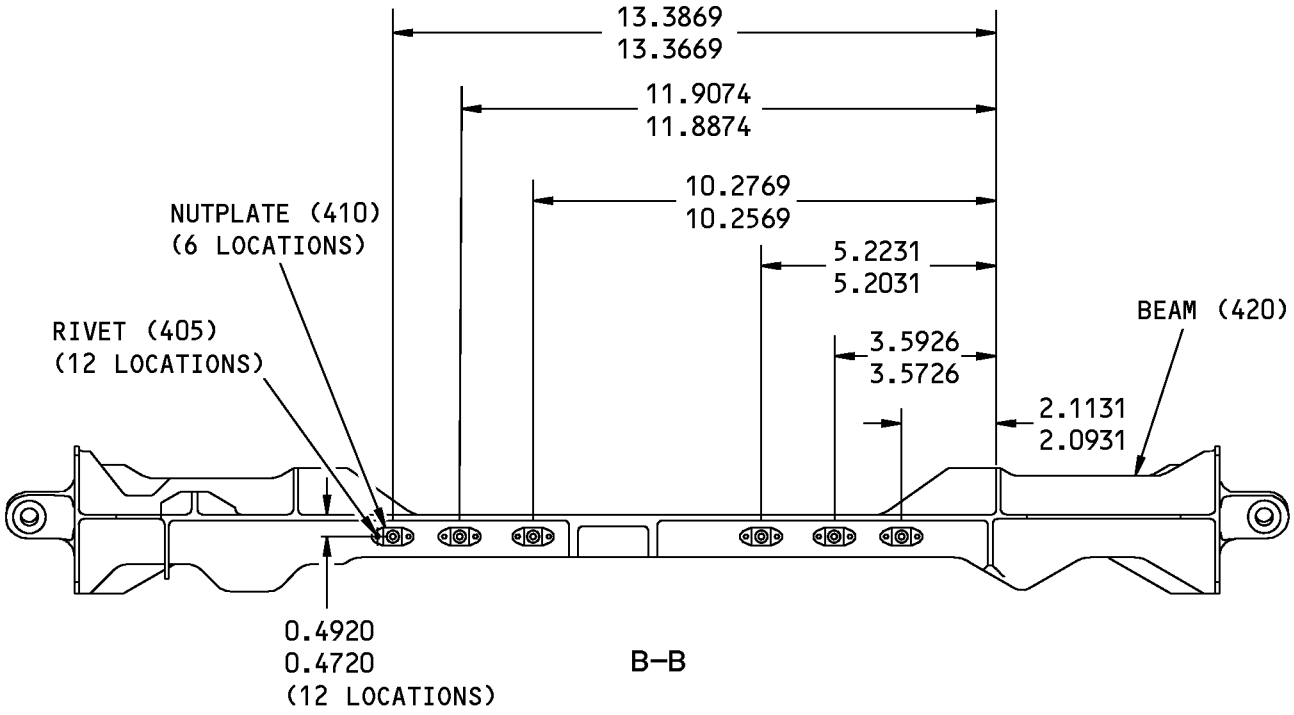
ITEM NUMBERS REFER TO IPL FIG. 1 UNLESS SHOWN BY 2

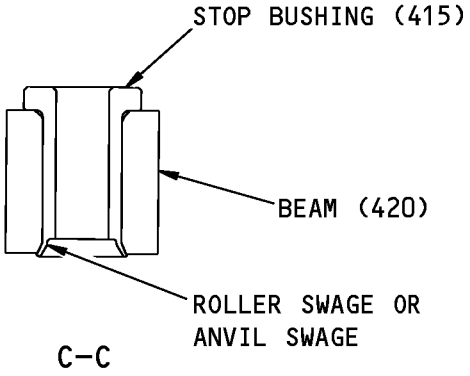
ALL DIMENSIONS ARE IN INCHES

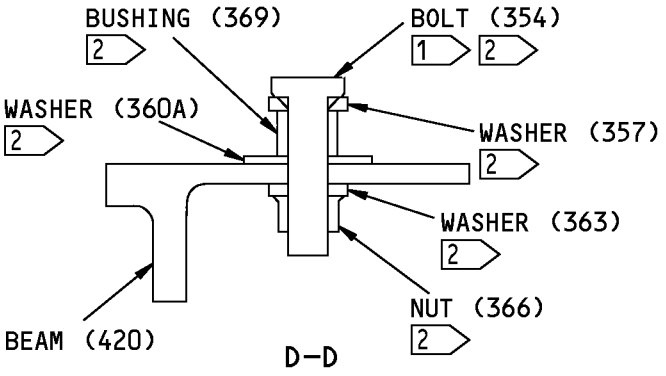
146A6422-1,-3 Beam #2 Assembly Parts Replacement
Figure 602 (Sheet 2 of 2)



146A6423-1 Beam #3 Assembly Parts Replacement
Figure 603 (Sheet 1 of 2)







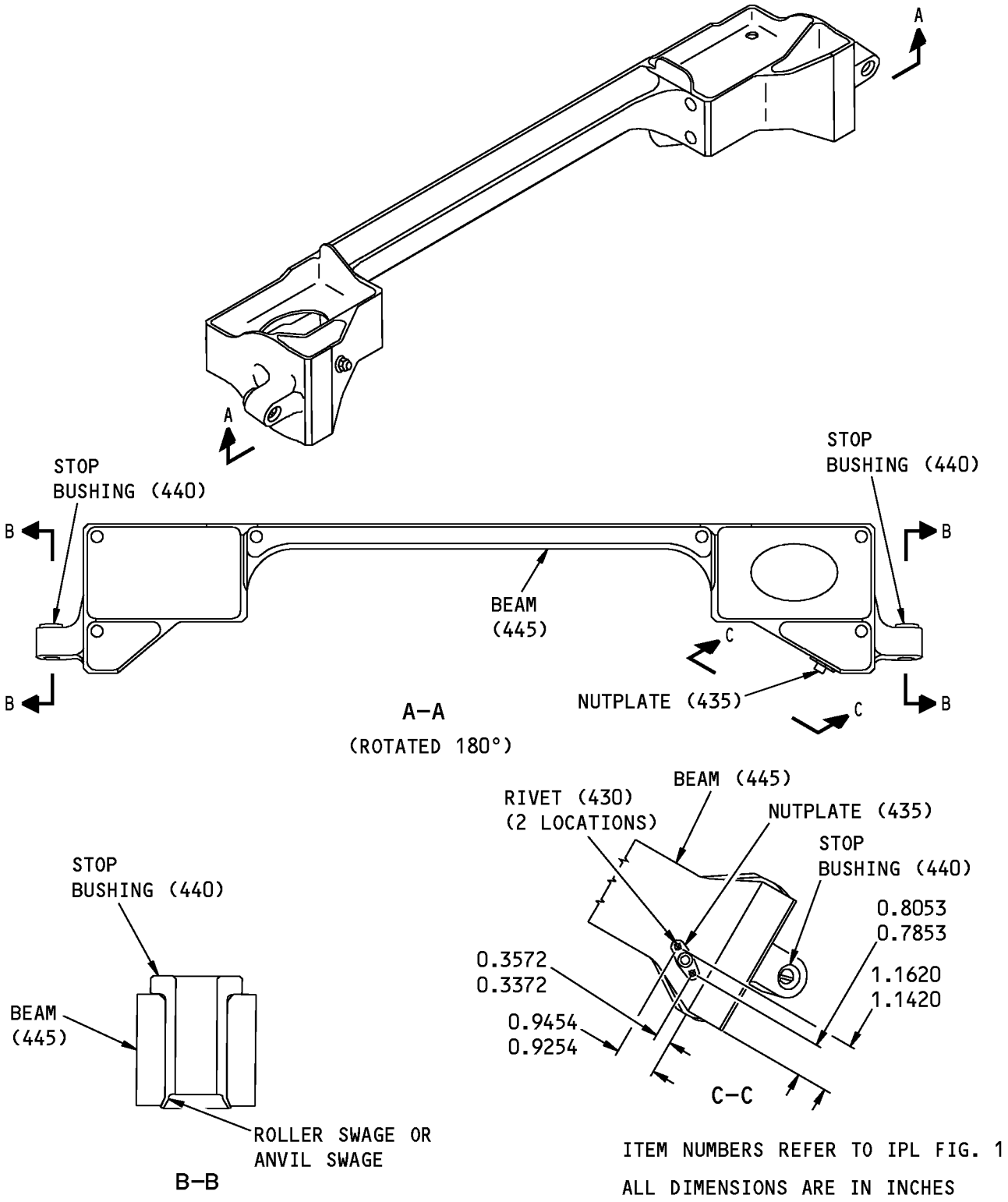
1 INSTALL THIS BOLT WITH BMS 5-95 SEALANT ON MATING SURFACES. SEE TEXT FOR PROCEDURE.

2 IPL FIG. 3

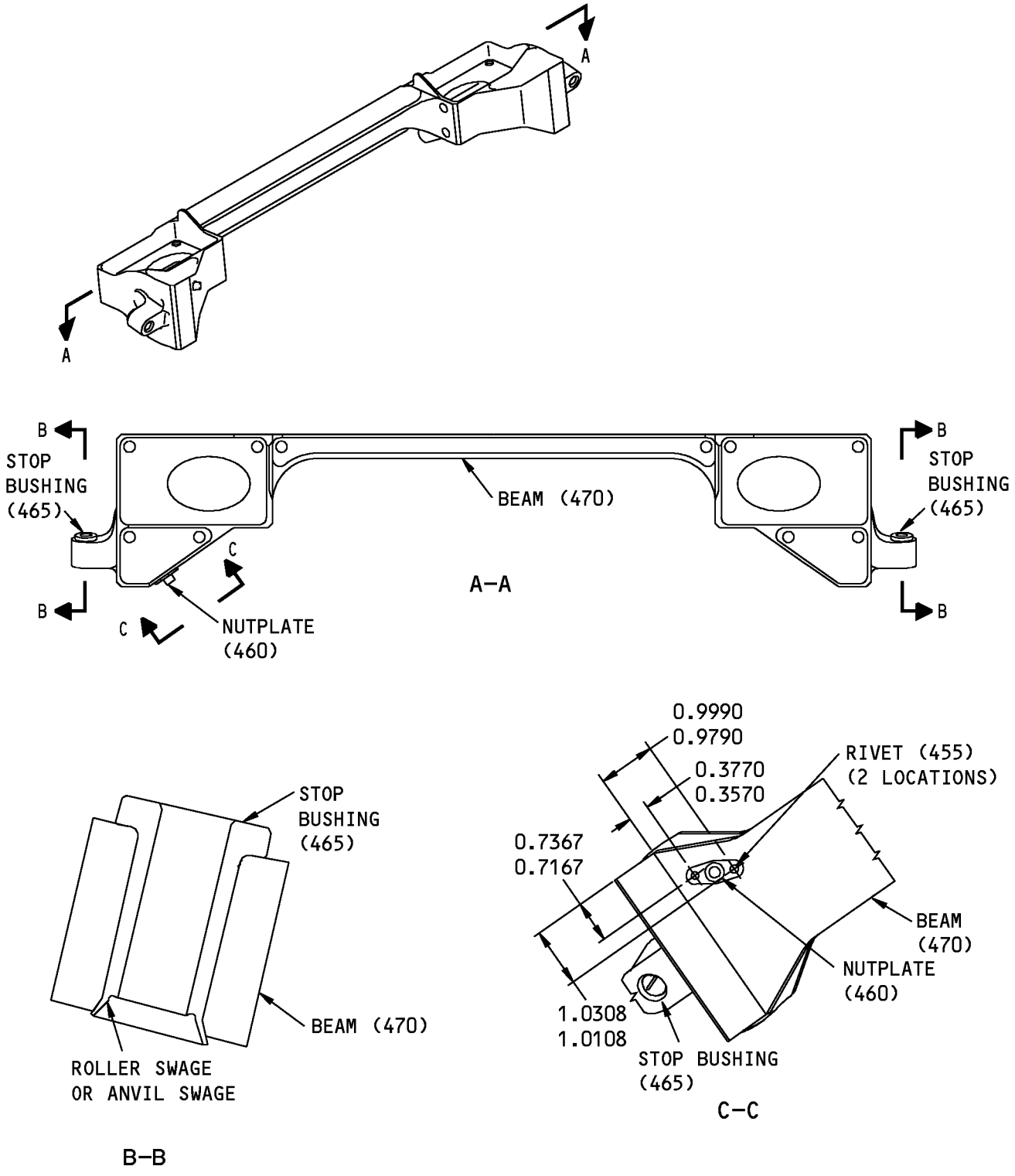
ITEM NUMBERS REFER TO IPL FIG. 1 UNLESS SHOWN BY 2

ALL DIMENSIONS ARE IN INCHES

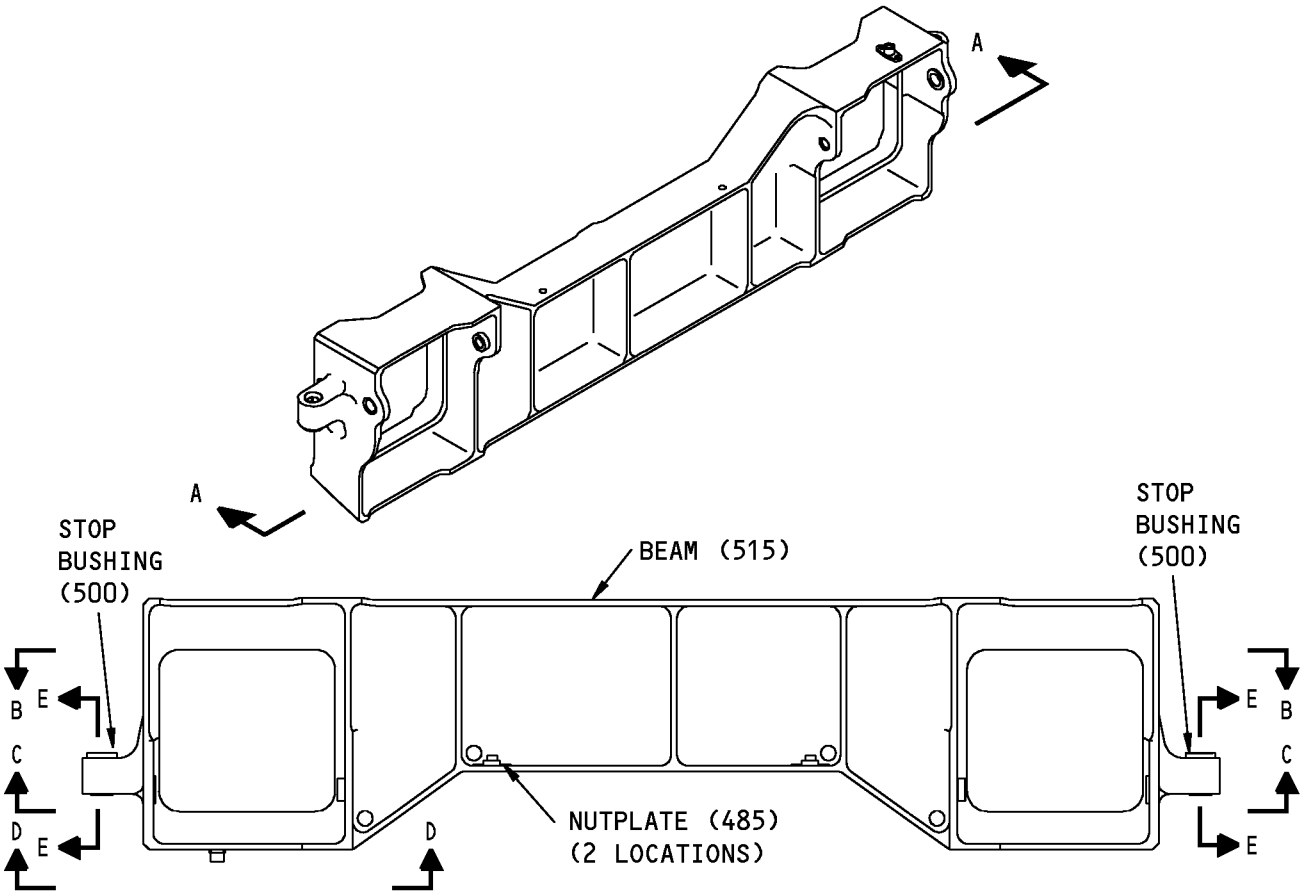
146A6423-1 Beam #3 Assembly Parts Replacement
Figure 603 (Sheet 2 of 2)



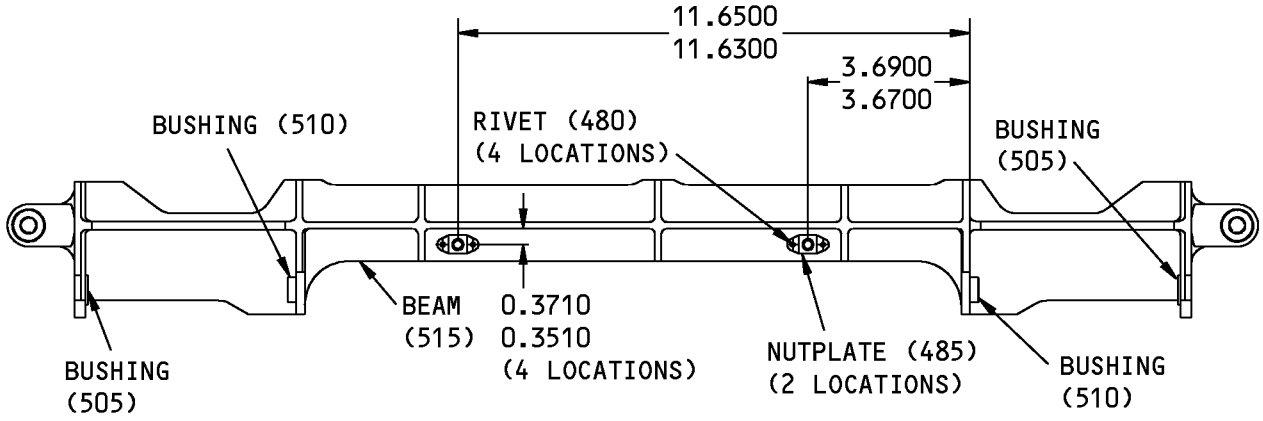
146A6424-1 Beam #4 Assembly Parts Replacement
Figure 604



146A6425-1 Beam #5 Assembly Parts Replacement
Figure 605

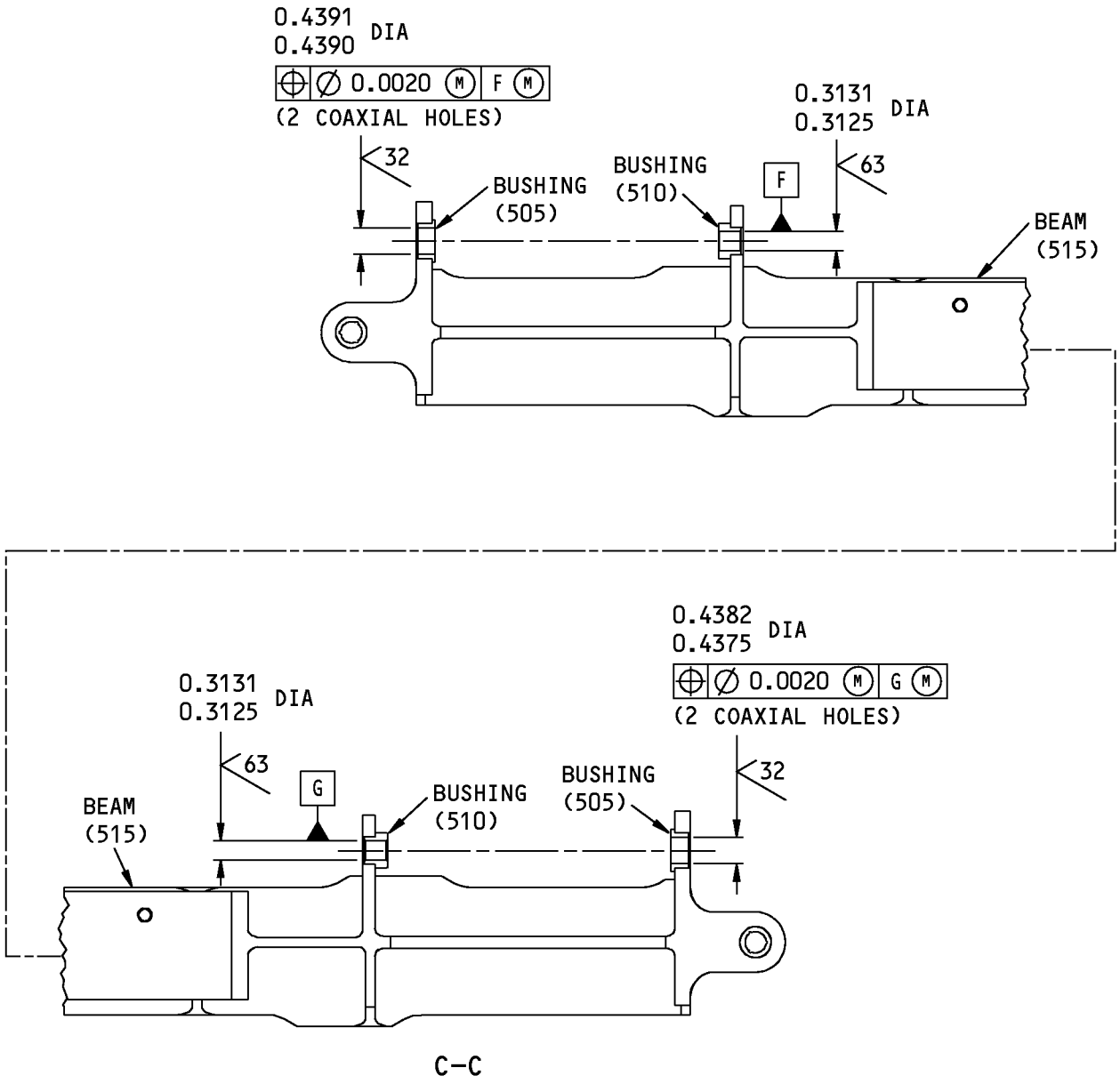


A–A
(ROTATED 180°)

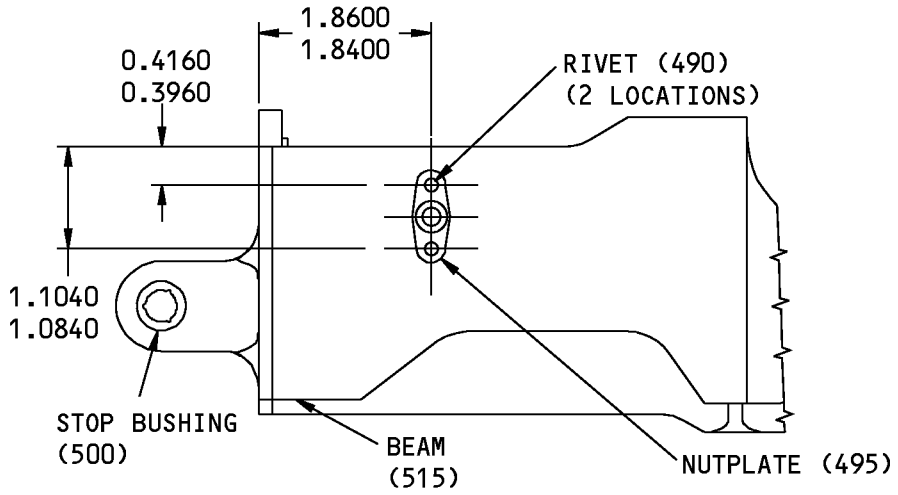


B–B

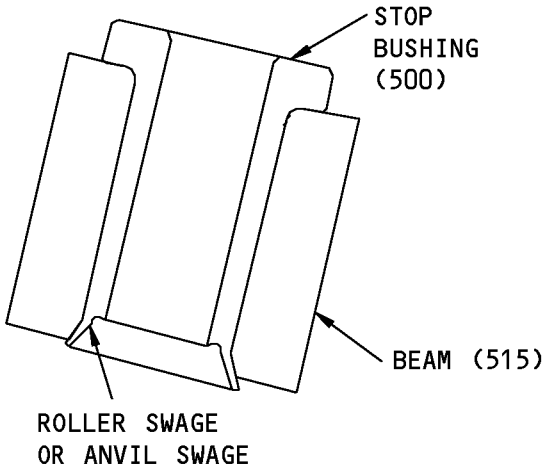
146A6426-1,-3 Beam #6 Assembly Parts Replacement
Figure 606 (Sheet 1 of 3)



146A6426-1,-3 Beam #6 Assembly Parts Replacement
Figure 606 (Sheet 2 of 3)



D–D



E–E

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

146A6426-1,-3 Beam #6 Assembly Parts Replacement
Figure 606 (Sheet 3 of 3)

BEAM - REPAIR 4-2

146A6421–101, 146A6422–101, –103, 146A6423–101, 146A6424–101, 146A6425–101, 146A6426–101, –103

1. General

A. This procedure tells how to repair and refinish beams (370, 395, 420, 445, 470, 515).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 1 for item numbers.

D. General repair details:

(1) Material: Al alloy

(2) Shot peen: not necessary

2. Beam Repair

A. Procedure

(1) Repair is only replacement of the original refinish. Refer to REPAIR 4-2, Paragraph 3. for details.

3. Beam 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

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.

(1) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31) all over.

(2) Apply BMS 10-11, Type 1 primer, C00259 (F-20.03) but not in the holes for the bushings.

VIEWPORT FRAME ASSEMBLY - REPAIR 5-1

146A6428–1

1. General

A. This procedure tells how to repair viewport frame assembly (520).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 1 for item numbers.

D. General repair details:

(1) Material: Al alloy

(2) Shot peen: not necessary

E. This frame can be seen from the airplane interior. Be careful not to damage surfaces the passengers will see.

2. Nutplate Replacement

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

(1) Remove the rivets and the bad nutplate.

(2) Install a replacement nutplate with new rivets.

3. Frame 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

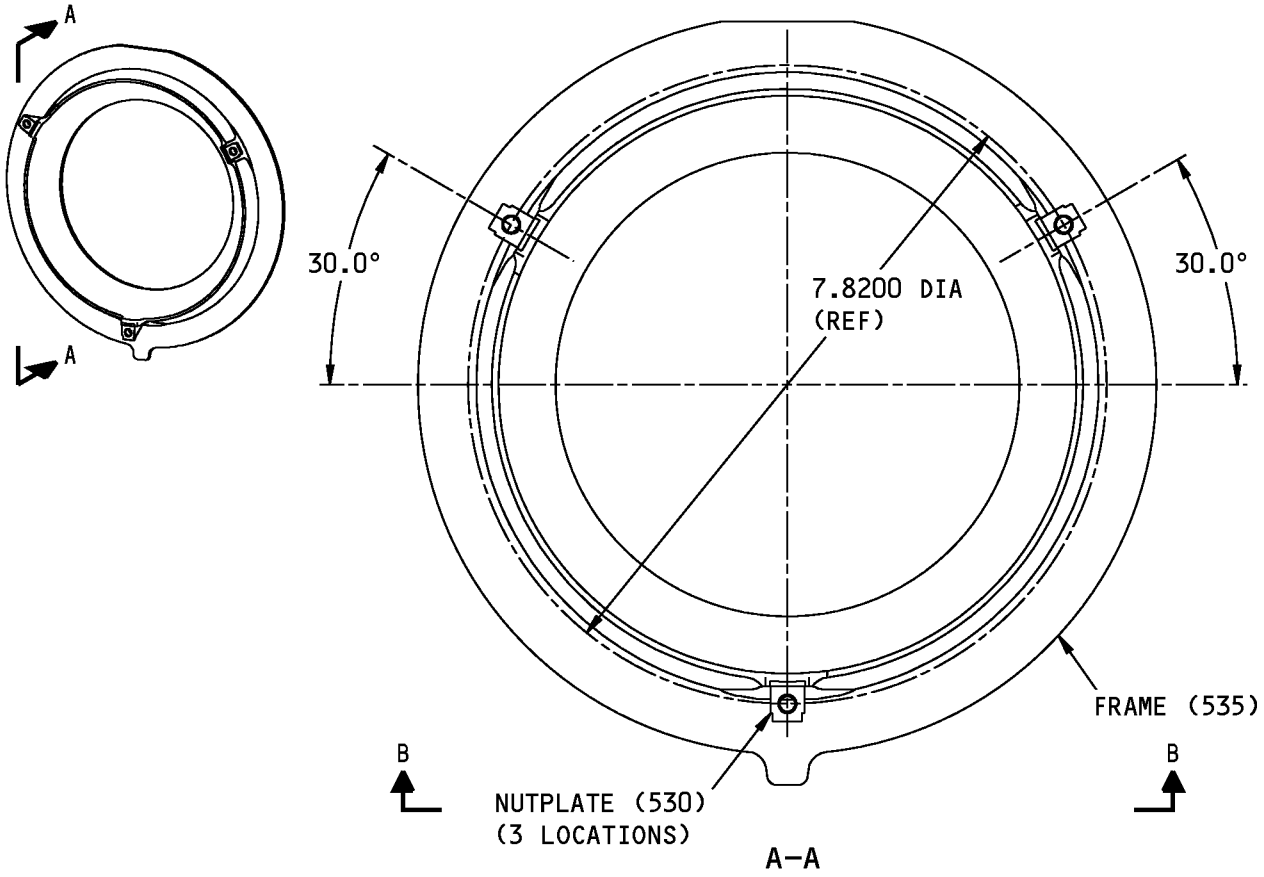
Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES

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.

(1) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31).

(2) Apply BMS 10-11, Type 1 primer, C00259 (F-20.03) all over.



146A6428-1 Viewport Frame Assembly Repair
Figure 601

HANDLE BOX ASSEMBLY - REPAIR 6-1

146A6445–1

1. General

A. This procedure tells how to replace the parts of handle box assembly (575).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 1 for item numbers.

2. Support Replacement

A. Procedure (REPAIR 6-1, Figure 601)

(1) Remove bolt (600), collar (605) and the old support (595).

(2) Refer to REPAIR 1-1 for refinish of the support.

(3) Install a replacement support with the bolts and collars.

3. 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

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

(1) Remove the old bushings.

(2) If you find defects on the hole surfaces, refer to REPAIR 6-2 for repair instructions.

(3) Install replacement bushings by the shrink fit method (SOPM 20-50-03) with BMS 5-95 sealant, A00247 as the installation finish.

4. Nutplate Replacement (REPAIR 6-1, Figure 601)

A. Remove the rivets and the bad nutplate.

B. Install a replacement nutplate with new rivets.

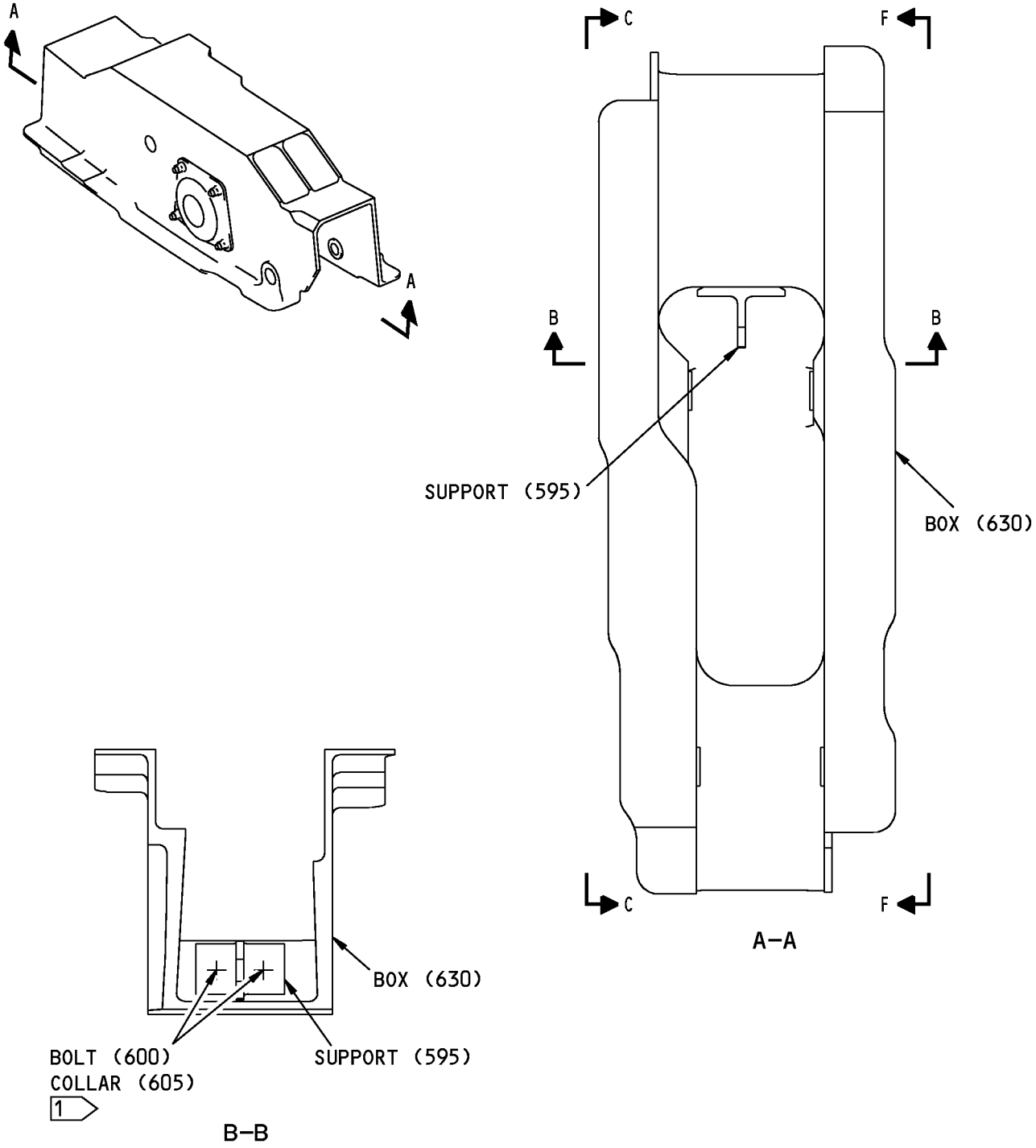
5. Cover Plate Replacement (REPAIR 6-1, Figure 601)

A. Remove bolts (585), collars (590) and the old cover plate (580).

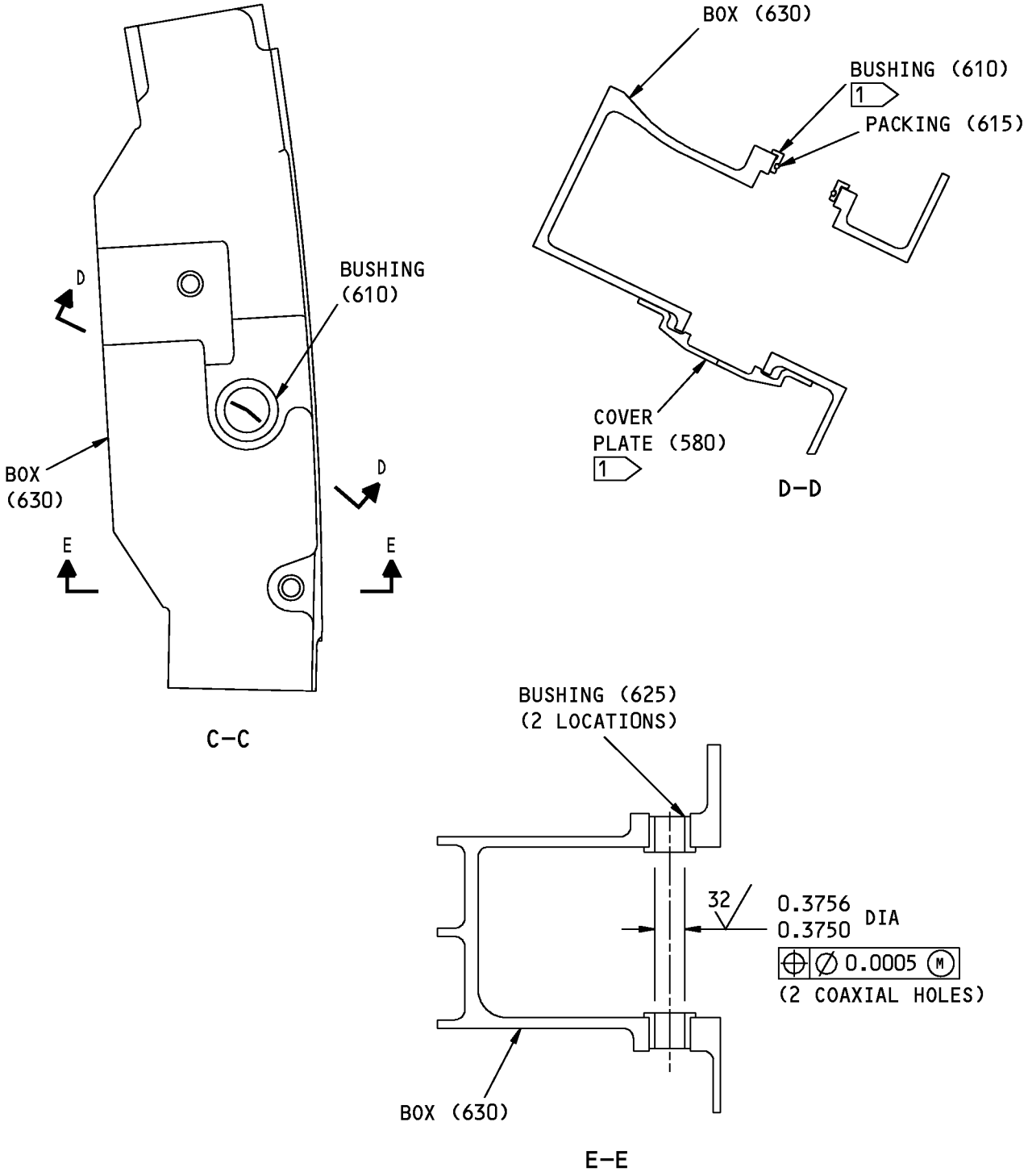
B. Refer to REPAIR 1-1 for refinish of the cover plate.

C. Install a replacement cover plate in the hole in the box, with BMS 3-38 corrosion inhibiting non-drying paste, G50136 on mating surfaces.

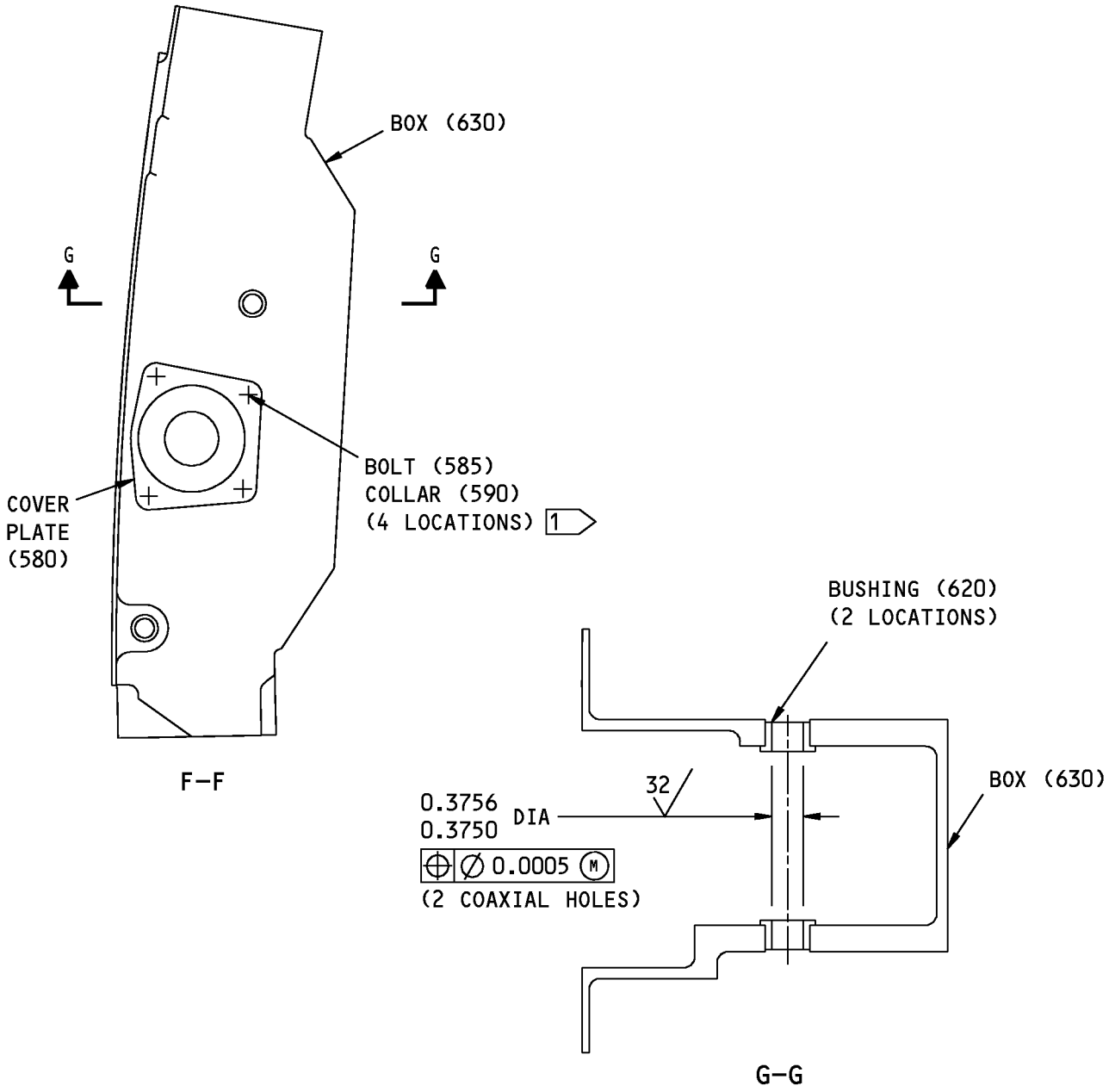
D. Install the bolts and collars, with BMS 3-38 corrosion inhibiting non-drying paste, G50136 on mating surfaces.



146A6445-1 Handle Box Assembly Parts Replacement
Figure 601 (Sheet 1 of 3)



146A6445-1 Handle Box Assembly Parts Replacement
Figure 601 (Sheet 2 of 3)



1 INSTALL WITH BMS 3-38 CORROSION PREVENTIVE COMPOUND ON MATING SURFACES

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

146A6445-1 Handle Box Assembly Parts Replacement
Figure 601 (Sheet 3 of 3)

BOEING®

COMPONENT MAINTENANCE MANUAL

HANDLE BOX - REPAIR 6-2

146A6445–101

1. General

A. This procedure tells how to repair and refinish handle box (630).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 1 for item numbers.

D. General repair details:

(1) Material: Al alloy

(2) Shot peen: not necessary

2. Handle Box Repair (REPAIR 6-2, Figure 601)

A. Procedure

(1) Repair is only replacement of the original refinish. Refer to REPAIR 6-2, Paragraph 3. for details.

(2) If you think there are defects on important surfaces, see REPAIR 6-2, Figure 601 for dimension details.

3. Handle Box Refinish (REPAIR 6-2, Figure 601)

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
C50069	Coating - Enamel, Color 702 Gloss White	BMS10-11, Type II

B. References

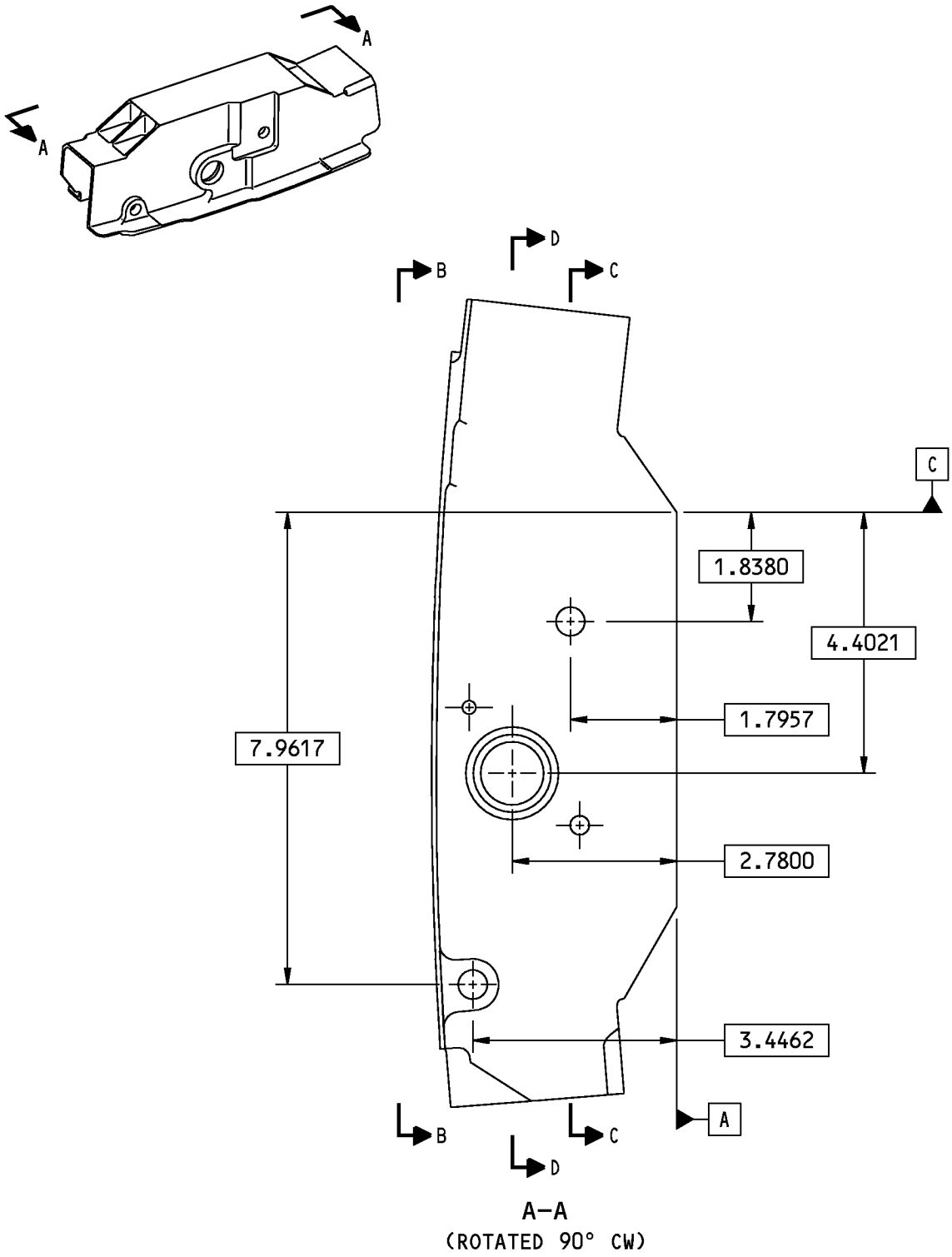
Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES

C. Procedure

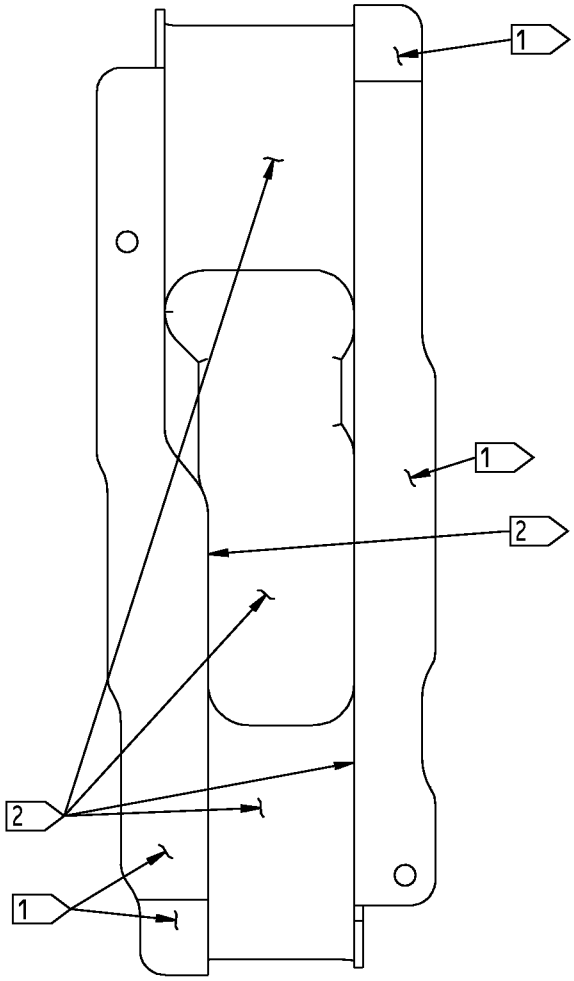
NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01.

(1) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31) all over.

(2) Apply BMS 10-11, Type 1 primer, C00259 (F-20.03) to all surfaces unless shown by flagnotes 1 and 3. Apply BMS 10-11, Type 1 primer, C00259 (F-20.02) and BMS 10-11, Type 2 coating, C50069 (F-21.02) to the areas shown by flagnote 3.

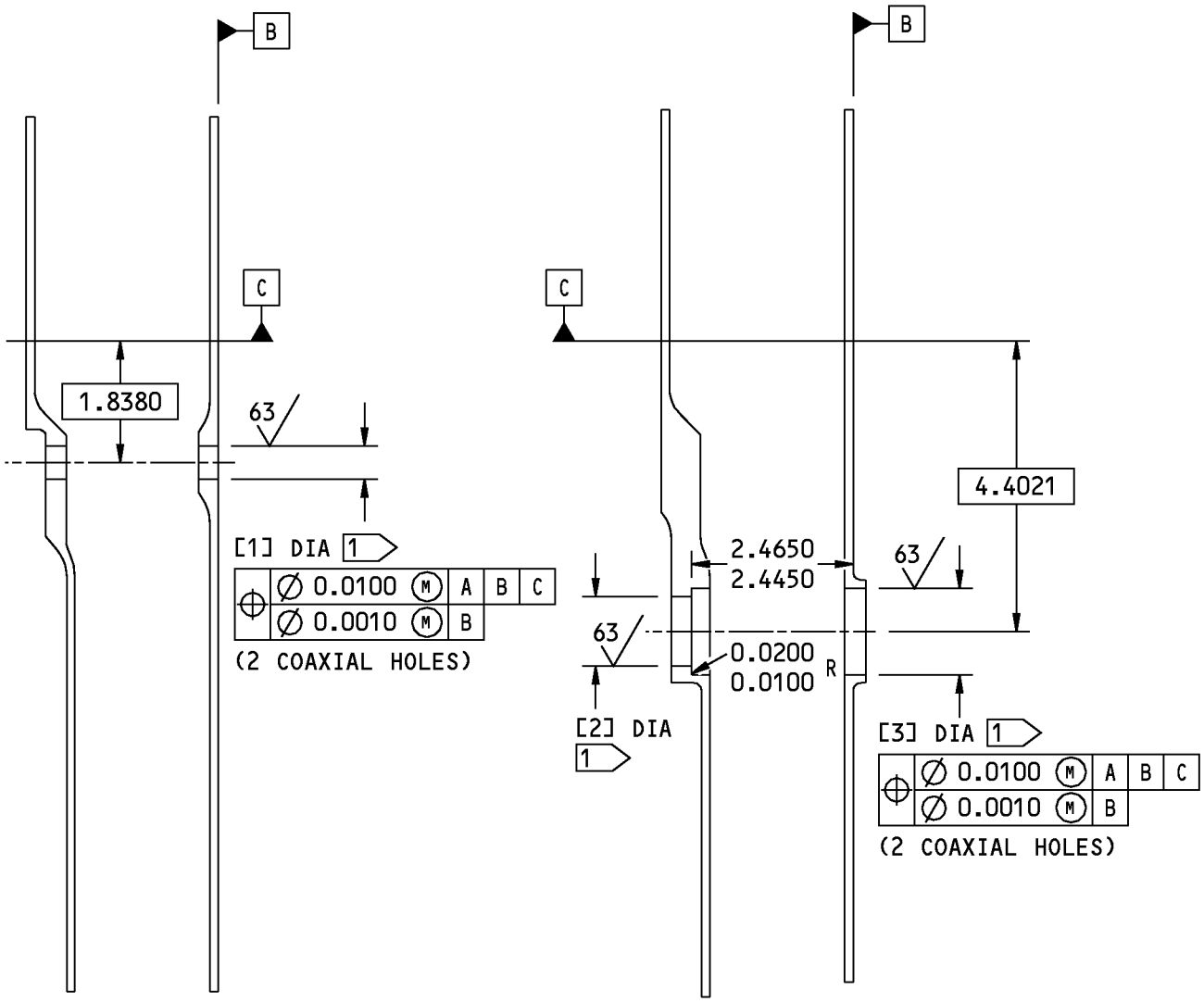


146A6445-101 Handle Box Repair and Refinish
Figure 601 (Sheet 1 of 4)



B–B

146A6445-101 Handle Box Repair and Refinish
Figure 601 (Sheet 2 of 4)



146A6445-101 Handle Box Repair and Refinish
Figure 601 (Sheet 3 of 4)

REFERENCE NUMBER	[1]	[2]	[3]
DESIGN DIMENSION	0.5006 0.5000	1.0634 1.0625	1.3135 1.3125
REPAIR LIMIT	—	—	—

1 NO PRIMER OR ENAMEL

2 APPLY BMS 10-11, TYPE 1 PRIMER (F-20.03)

3 APPLY BMS 10-11, TYPE 1 PRIMER (F-20.02) AND GRAY BMS 10-11, TYPE 2 ENAMEL (F-21.02)

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

146A6445-101 Handle Box Repair and Refinish
Figure 601 (Sheet 4 of 4)

PRESSURE LOCK MECHANISM ASSEMBLY - REPAIR 7-1

146A6509–1

1. General

A. This procedure tells how to replace the parts of pressure lock mechanism assembly (414).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices shown in the repair.

C. Refer to IPL Figure 3 for item numbers.

2. Parts Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. Procedure (REPAIR 7-1, Figure 601)

(1) Remove the sealant from the fasteners.

(2) Remove nuts (429), bolts (417, 420), washers (423, 426).

(3) Remove bearing housing assemblies (435, 438), crank assemblies (465, 492).

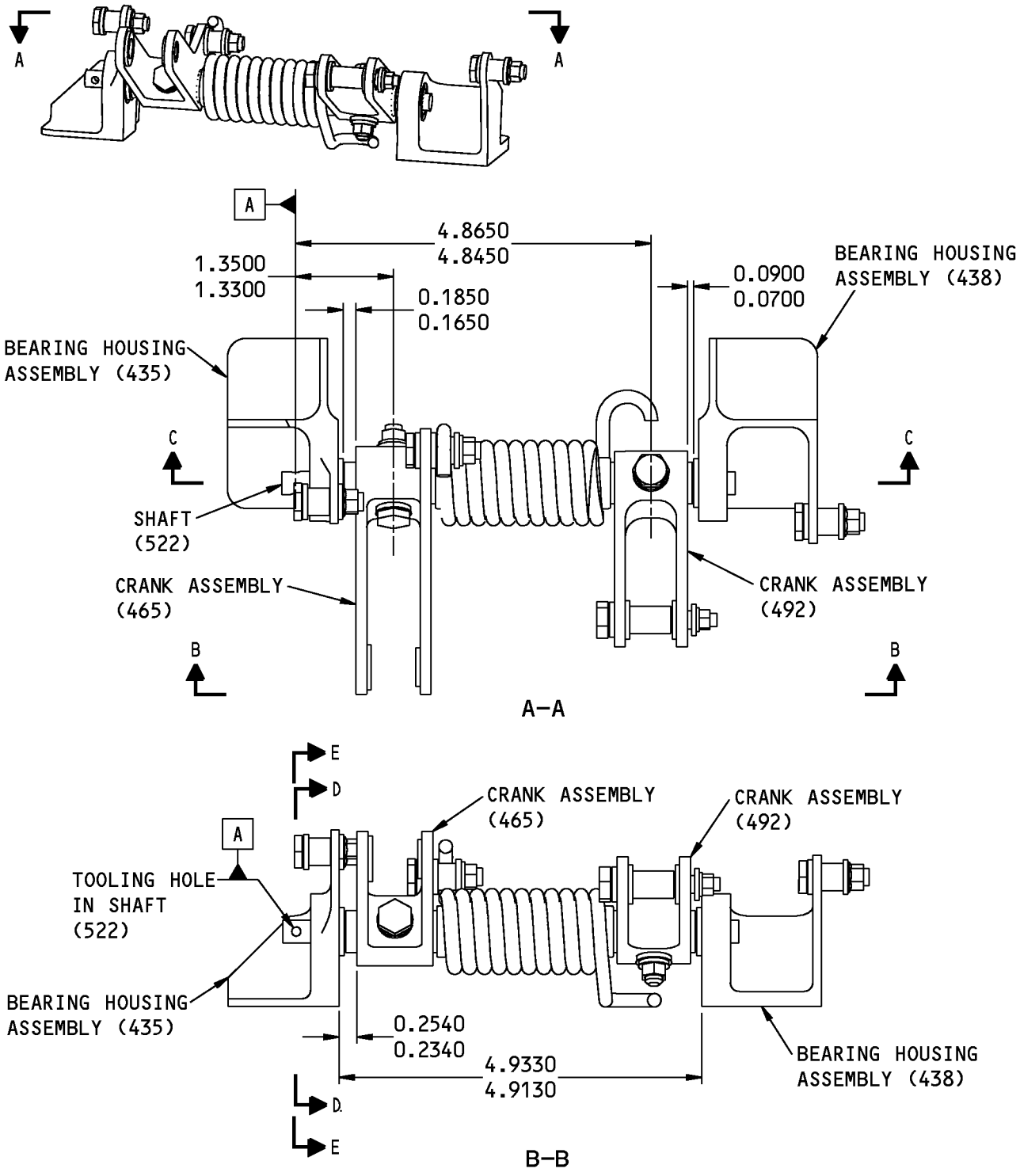
(4) Pull out shaft (522) and remove spring (519) and sleeve (516).

(5) If you find defects on the spring, sleeve, cranks, bearing housings, or shaft, refer to REPAIR 1-1, REPAIR 8-1, REPAIR 9-1 and REPAIR 23-1 for repair instructions.

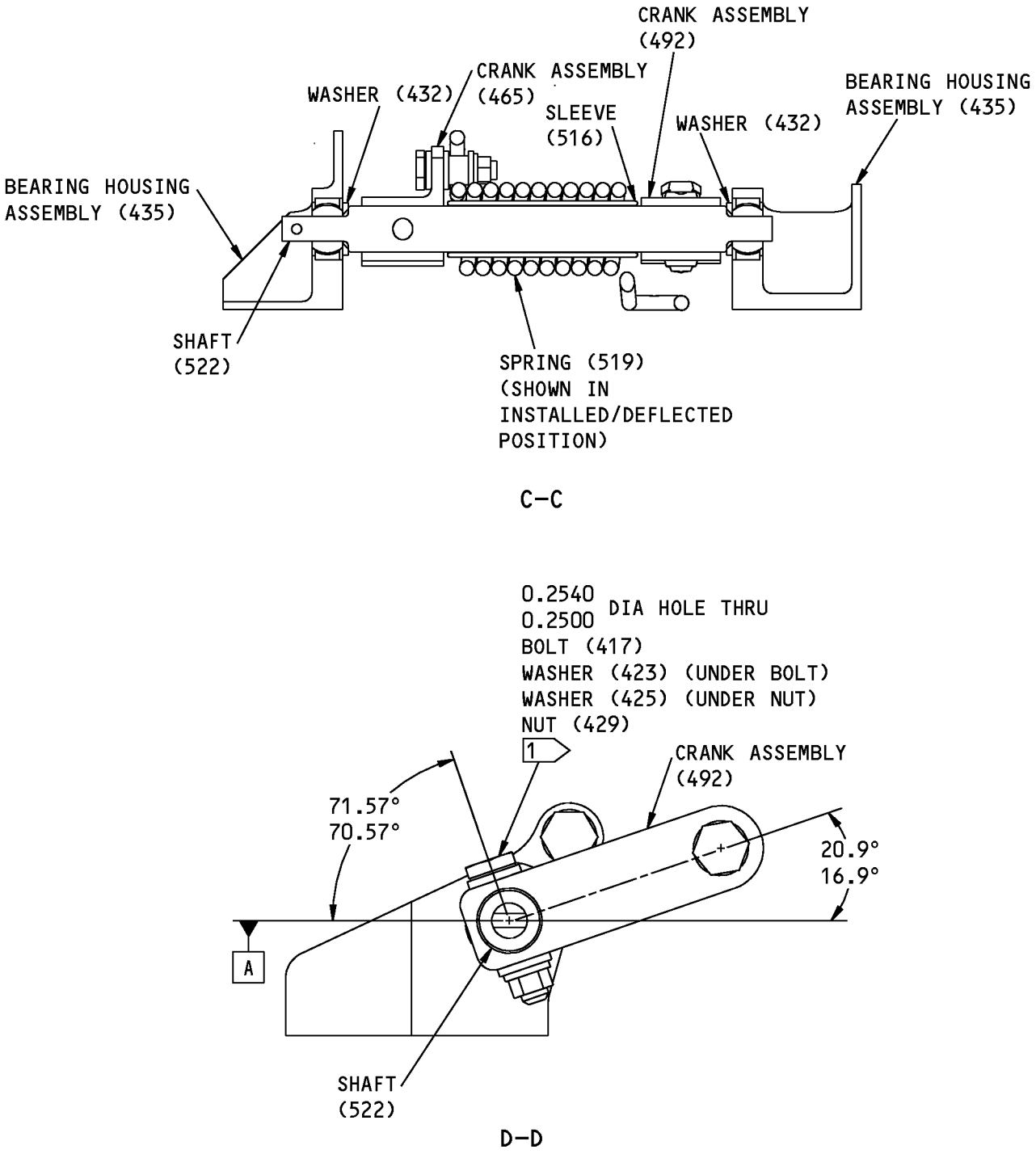
(6) Install a replacement spring (522) and sleeve (516) on the shaft.

(7) Install crank assemblies (435, 438) on the shaft with bolts (417, 420), washers (423, 426) and nuts (429) with wet BMS 5-95 sealant, A00247 on mating surfaces. If you replaced the cranks or shaft with new ones, drill holes as shown for these fasteners, because the new cranks and shaft come with only pilot holes.

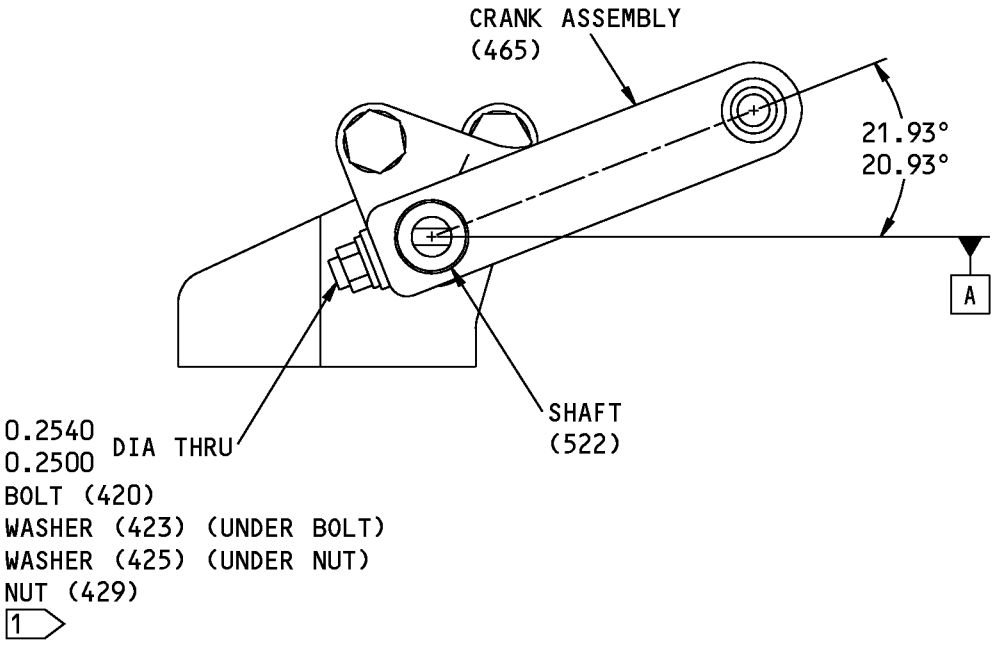
(8) With a brush, apply BMS 5-95 sealant, A00247 to the threads and the mating components.



146A6509-1 Pressure Lock Mechanism Assembly Parts Replacement
Figure 601 (Sheet 1 of 3)



146A6509-1 Pressure Lock Mechanism Assembly Parts Replacement
Figure 601 (Sheet 2 of 3)



E–E
(SOME PARTS NOT SHOWN FOR CLARITY)

1 INSTALL WITH WET BMS 5-95 SEALANT (SOPM 20-50-19 METHOD 2) THEN BRUSH SEALANT ON THREADED END OF FASTENER AND MATING COMPONENTS

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

ITEM NUMBERS REFER TO IPL FIG. 3

ALL DIMENSIONS ARE IN INCHES

146A6509-1 Pressure Lock Mechanism Assembly Parts Replacement
Figure 601 (Sheet 3 of 3)

CRANK ASSEMBLY - REPAIR 8-1

146A6510–1, –3

1. General

A. This procedure tells how to replace the parts of crank assemblies (465, 492).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 3 for item numbers.

2. Fastener Replacement

A. Procedure (REPAIR 8-1, Figure 601 or REPAIR 8-1, Figure 602)

(1) Remove the nut, washers, bushing and bolt from the lug.

(2) If you find defects on the lug surfaces, refer to REPAIR 8-2 for repair instructions.

(3) Install replacement bolt, washers, bushing and nut on the lug as shown.

3. 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

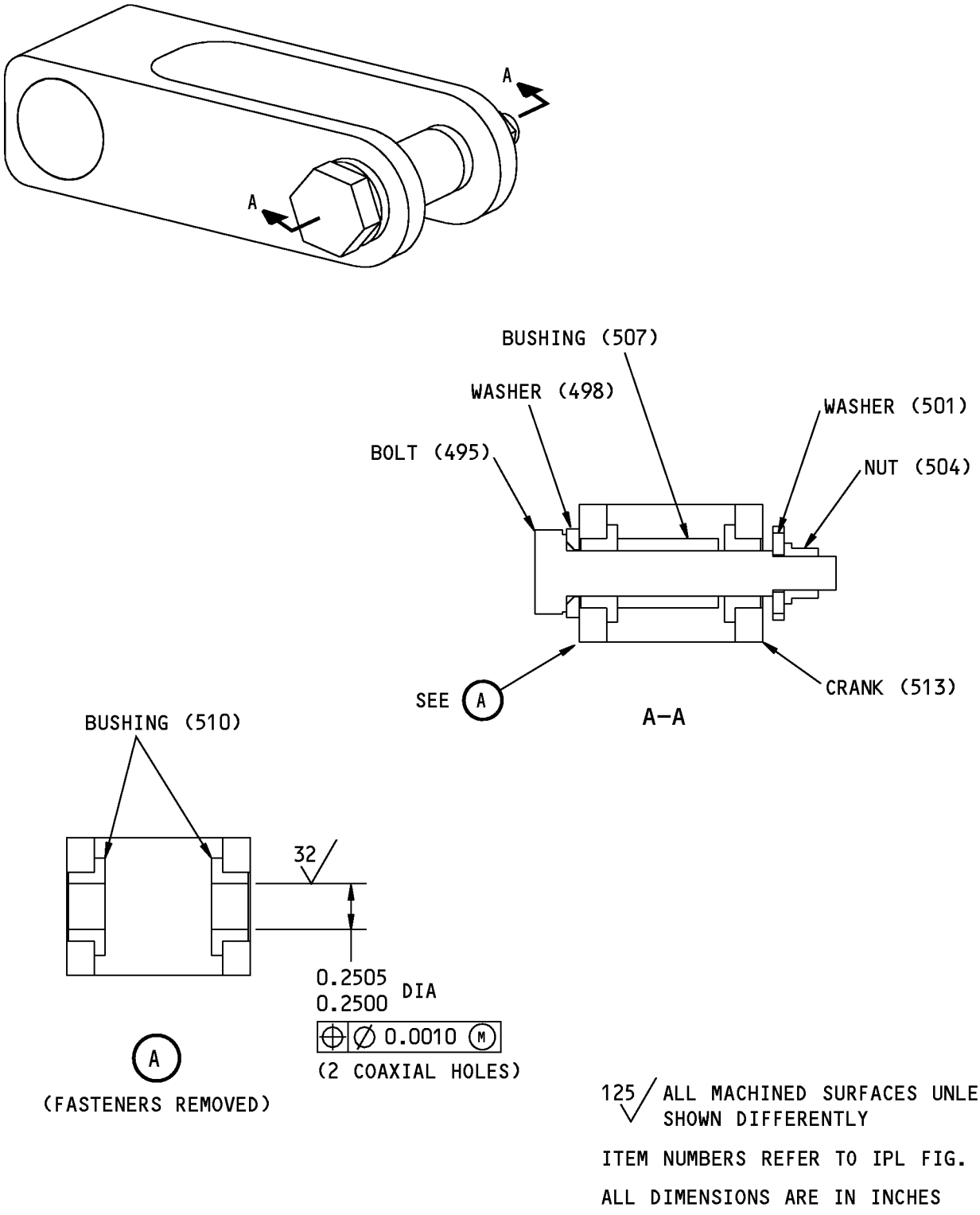
Reference	Title
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT

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

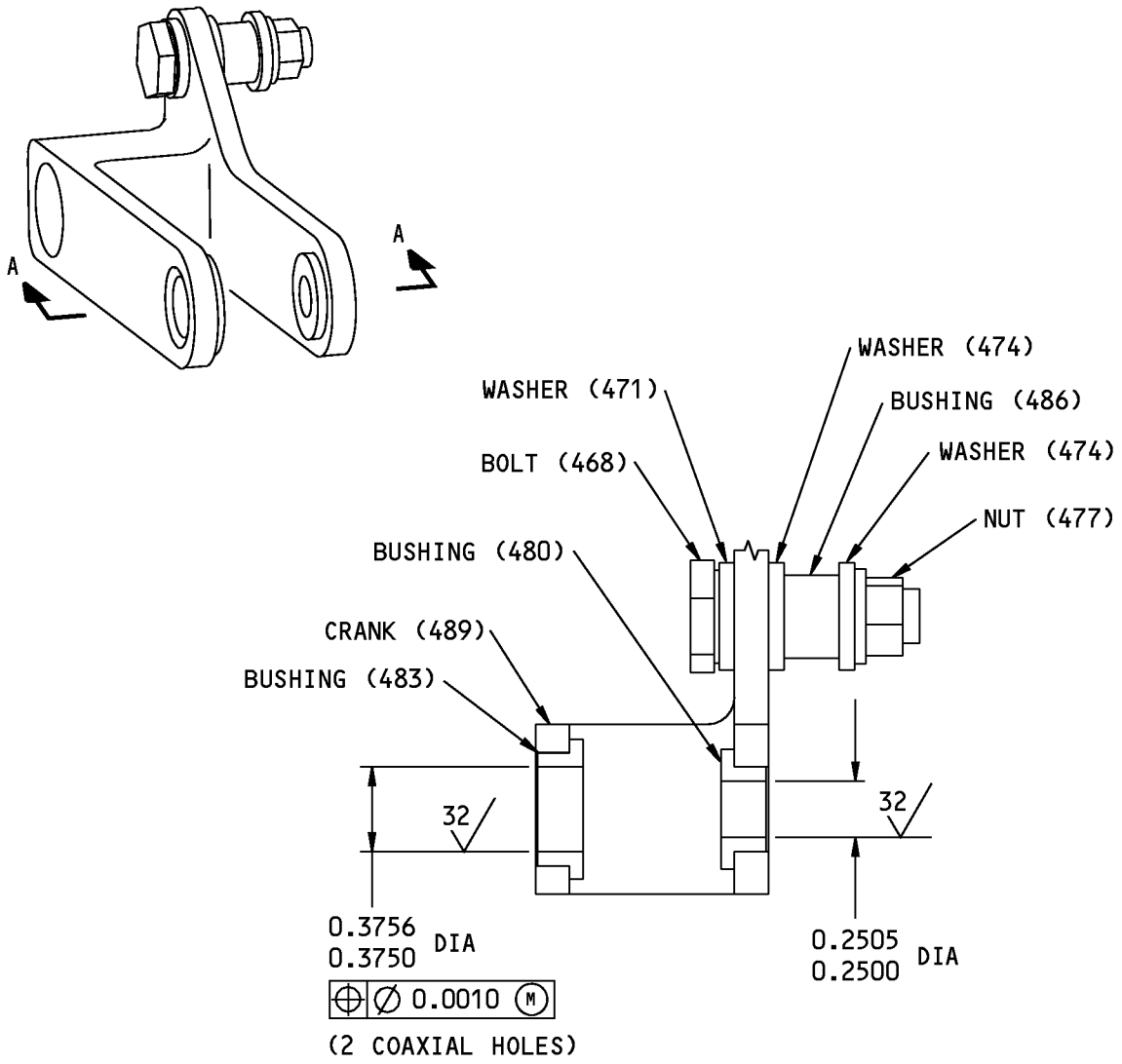
(1) Remove the old bushings.

(2) If you find defects on the hole surfaces, refer to REPAIR 8-2 for repair instructions.

(3) Install replacement bushings by the shrink fit method (SOPM 20-50-03) with BMS 5-95 sealant, A00247 as the installation finish.



146A6510-1 Crank Assembly Parts Replacement
Figure 601



A–A

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

ITEM NUMBERS REFER TO IPL FIG. 3

ALL DIMENSIONS ARE IN INCHES

146A6510-3 Crank Assembly Parts Replacement
Figure 602

CRANK - REPAIR 8-2

146A6510–101, –103

1. General

A. This procedure tells how to repair and refinish cranks (489, 513).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 3 for item numbers.

D. General repair details:

(1) Material: 15-5PH CRES, 180-200 ksi

(2) Shot peen: not necessary

2. Crank Repair (REPAIR 8-2, Figure 601 or REPAIR 8-2, Figure 602)

A. Procedure

(1) Repair is only replacement of the original refinish. Refer to REPAIR 8-2, Paragraph 3. for details.

(2) If you think there are defects on important surfaces, see REPAIR 8-2, Figure 601 or REPAIR 8-2, Figure 602 for dimension details.

3. Crank Refinish (Fig 601 or 602)

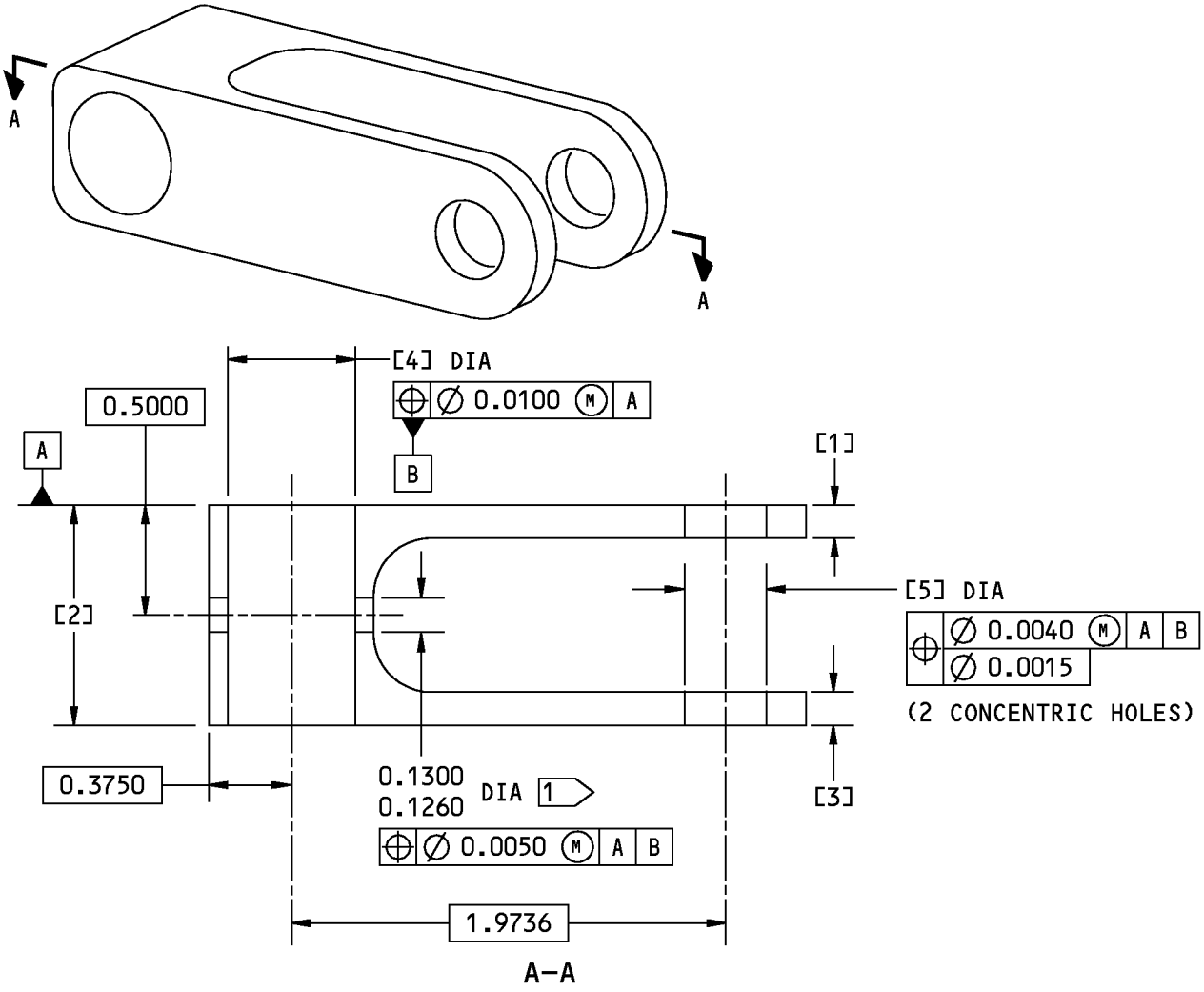
A. References

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

B. 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.

(1) Passivate (F-17.25).



REFERENCE NUMBER	[1]	[2]	[3]	[4]	[5]
DESIGN DIMENSION	0.1600 0.1400	1.0100 0.9900	0.1600 0.1400	0.5785 0.5765	0.3756 0.3750
REPAIR LIMIT	—	—	—	—	—

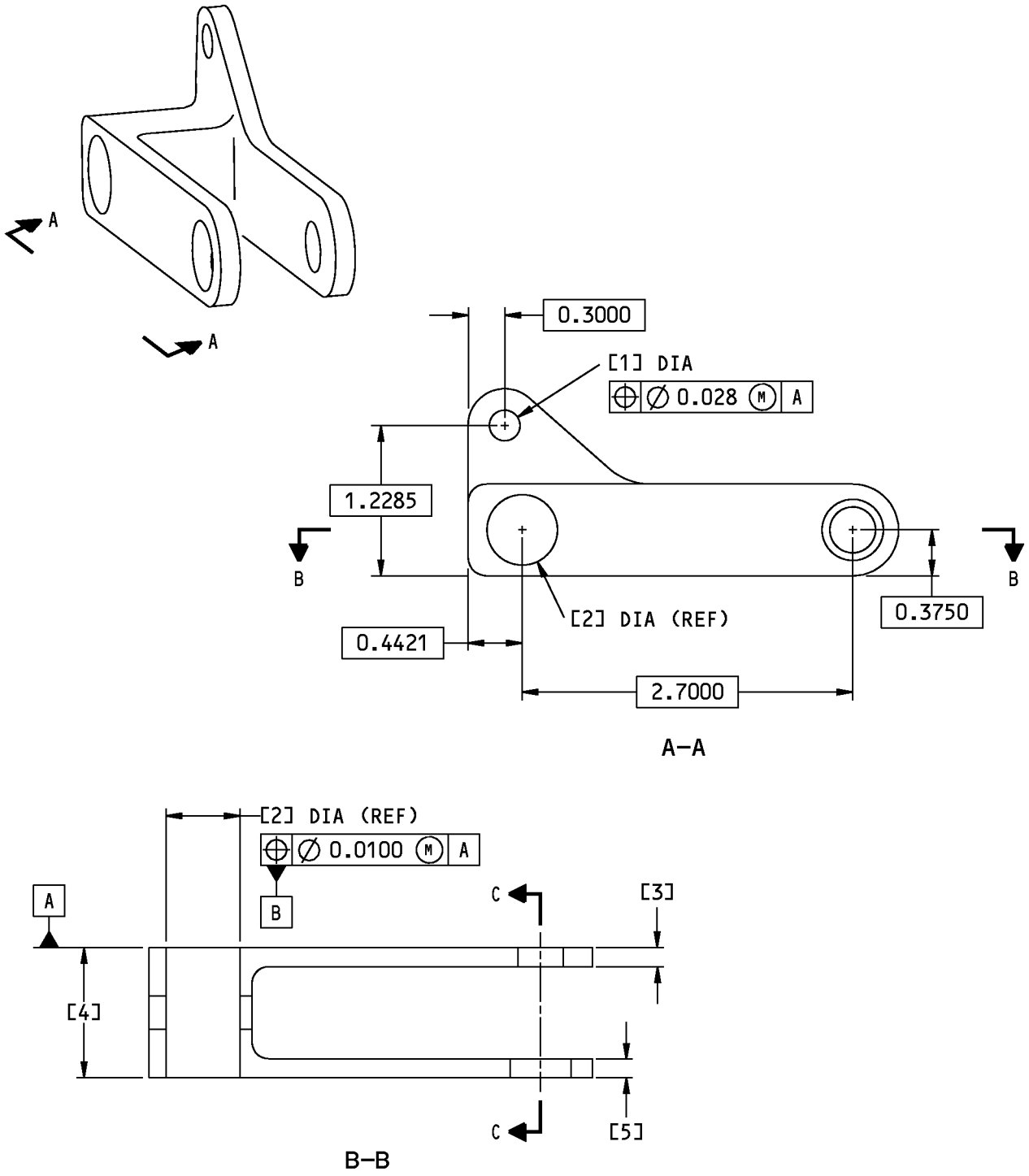
125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

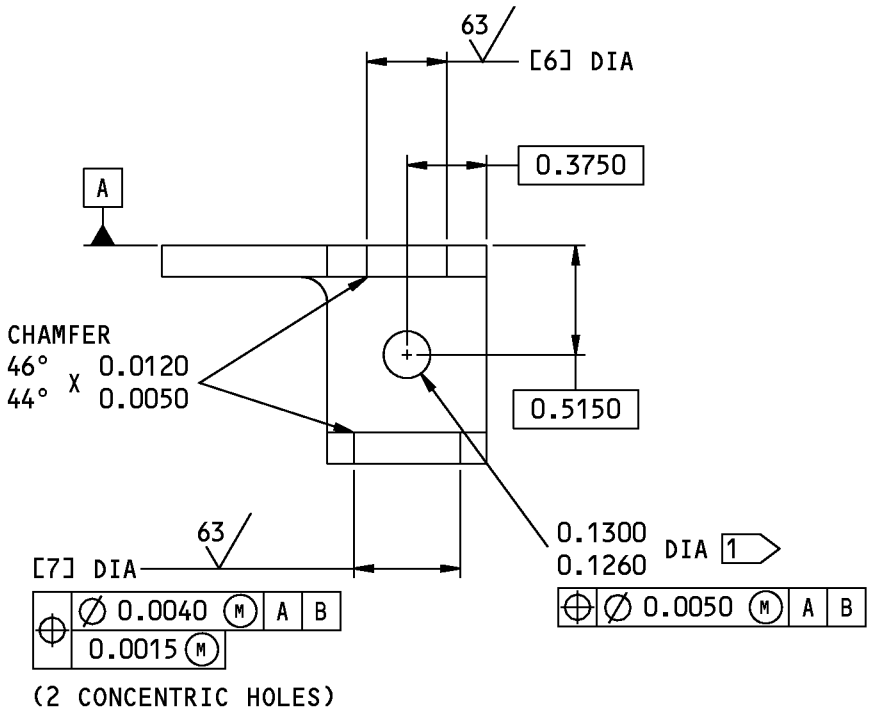
ALL DIMENSIONS ARE IN INCHES

1 PILOT HOLE ON NEW CRANKS, TO BE DRILLED TO FINAL SIZE FOR FASTENER INSTALLATION (REPAIR 7-1)

146A6510-101 Crank Repair and Refinish
Figure 601



146A6510-103 Crank Repair and Refinish
Figure 602 (Sheet 1 of 2)



C–C

REFERENCE NUMBER	[1]	[2]	[3]	[4]	[5]	[6]	[7]
DESIGN DIMENSION	0.2600 0.2500	0.5785 0.5765	0.1600 0.1400	1.0400 1.0200	0.1600 0.1400	0.3756 0.3750	0.5006 0.5000
REPAIR LIMIT	—	—	—	—	—	—	—

1 PILOT HOLE ON NEW CRANKS, TO BE DRILLED TO FINAL SIZE FOR FASTENER INSTALLATION (REPAIR 7-1)

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

146A6510-103 Crank Repair and Refinish
Figure 602 (Sheet 2 of 2)

BEARING HOUSING ASSEMBLY - REPAIR 9-1

146A6512–1, –3

1. General

A. This procedure tells how to replace the parts of bearing housing assemblies (435, 438).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 3 for item numbers.

2. Fastener Replacement

A. Procedure (REPAIR 9-1, Figure 601 or REPAIR 9-1, Figure 602)

(1) Remove the nut, washers, bushing and bolt from the lug.

(2) If you find defects on the housing surfaces, refer to REPAIR 9-2 for repair instructions.

(3) Install a replacement bolt, washers, bushing and nut on the lug as shown.

3. Bearing Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

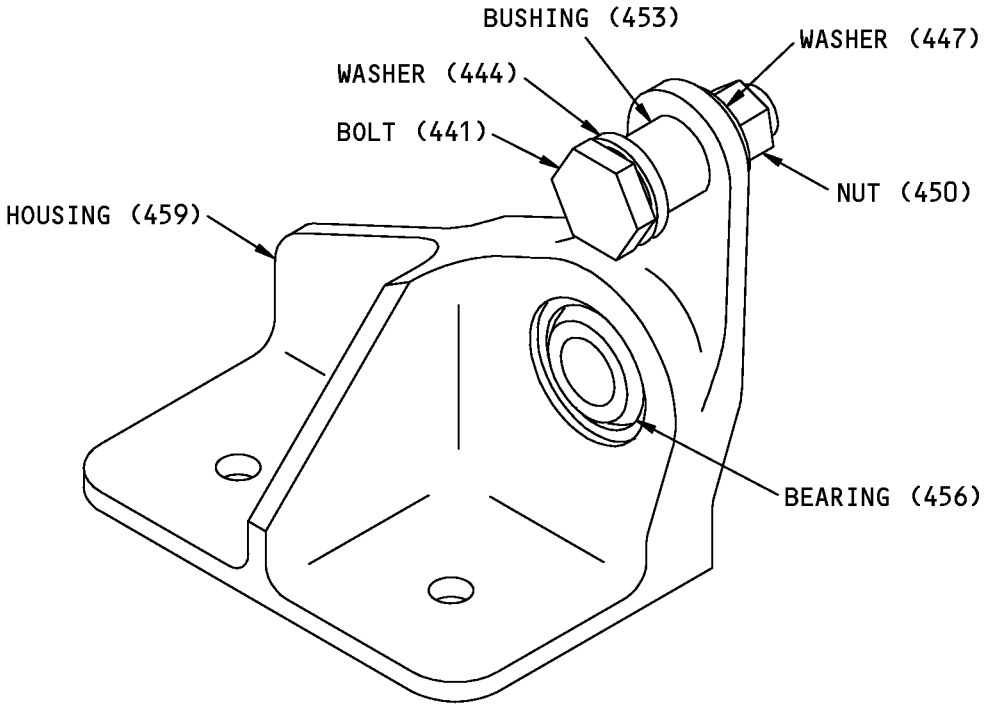
Reference	Title
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT

C. Procedure (REPAIR 9-1, Figure 601 or REPAIR 9-1, Figure 602)

(1) Remove the old bearings.

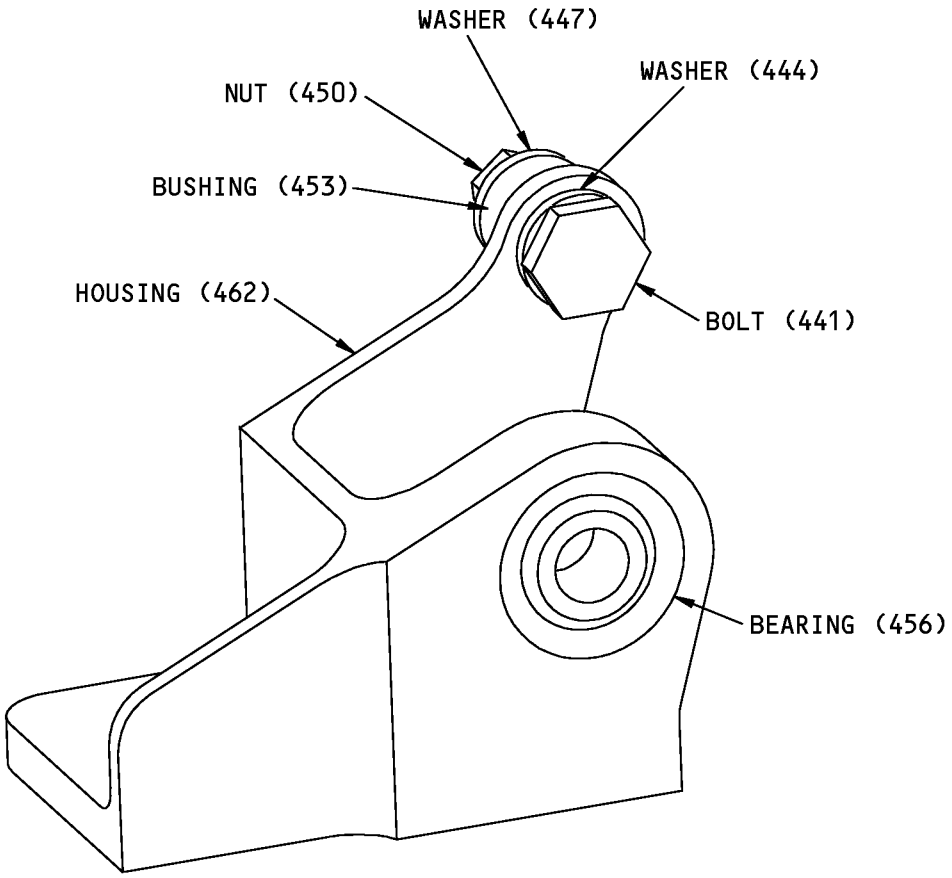
(2) If you find defects on the hole surfaces, refer to REPAIR 9-2 for repair instructions.

(3) Install replacement bearings by the press fit method (SOPM 20-50-03) with BMS 5-95 sealant, A00247 as the installation finish. Swaging is not necessary.



ITEM NUMBERS REFER TO IPL FIG. 3

146A6512-1 Bearing Housing Assembly Parts Replacement
Figure 601



ITEM NUMBERS REFER TO IPL FIG. 3

146A6512-3 Bearing Housing Assembly Parts Replacement
Figure 602

HOUSING - REPAIR 9-2

146A6512–101, –103

1. General

A. This procedure tells how to repair and refinish housing (459, 462).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 3 for item numbers.

D. General repair details:

(1) Material: Al alloy

(2) Shot peen: not necessary

2. Housing Repair

A. Procedure (REPAIR 9-2, Figure 601 or REPAIR 9-2, Figure 602)

(1) Repair is only replacement of the original refinish. Refer to REPAIR 9-2, Paragraph 3. for details.

(2) If you think there are defects on important surfaces, see REPAIR 9-2, Figure 601 or REPAIR 9-2, Figure 602 for dimension details.

3. 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

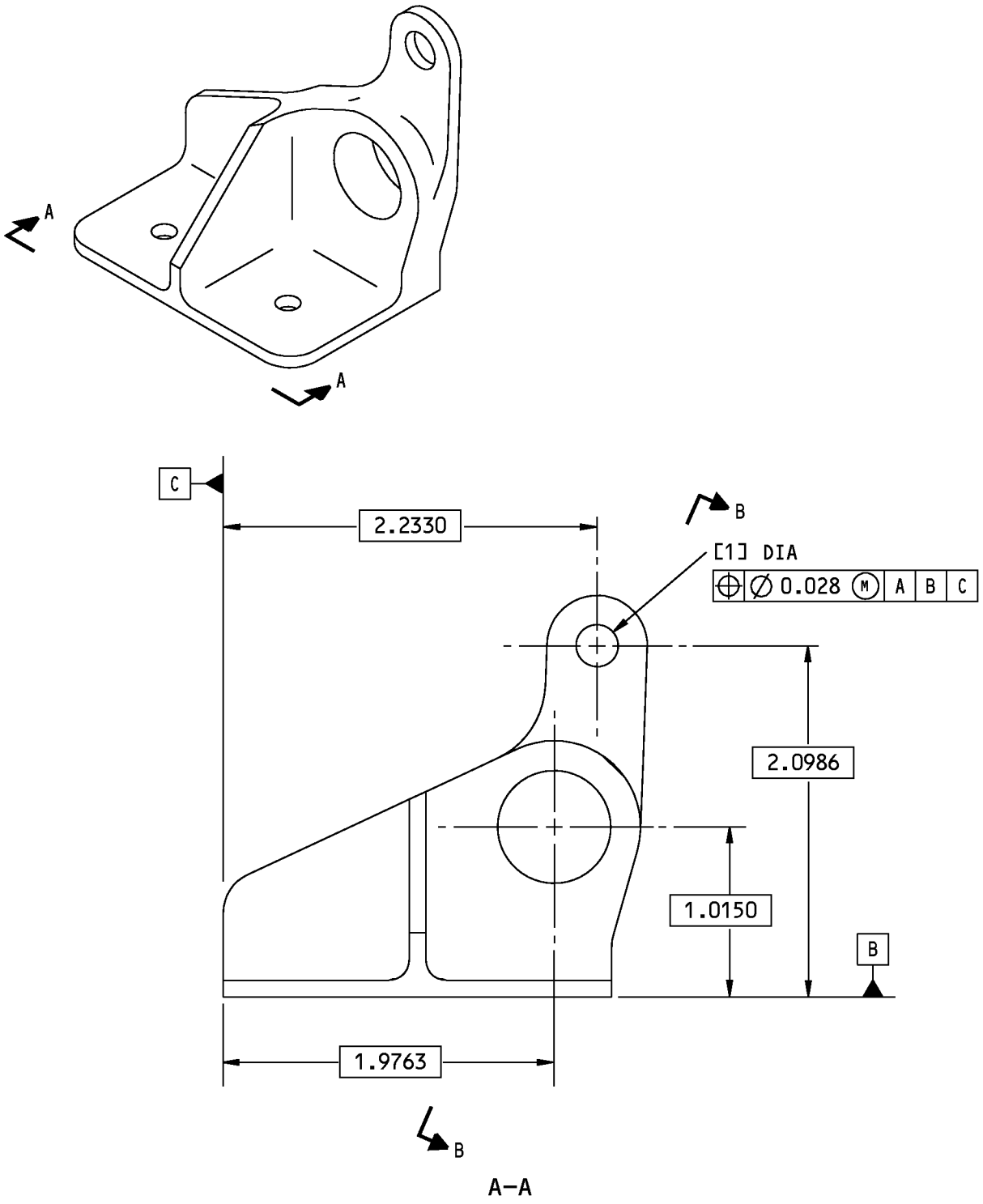
Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES

C. Procedure (REPAIR 9-2, Figure 601 or REPAIR 9-2, Figure 602)

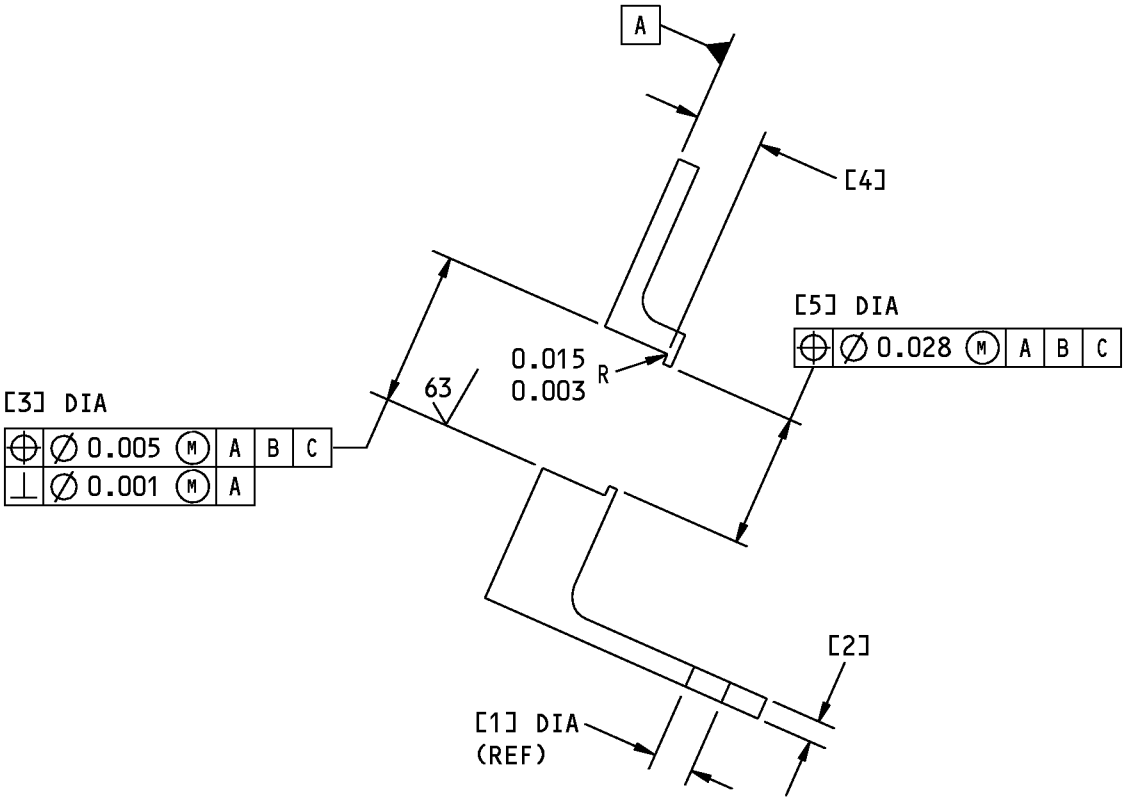
NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01.

(1) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31) all over.

(2) Apply BMS 10-11, Type 1 primer, C00259 (F-20.03) but not in the hole for the bearing.



146A6512-101 Bearing Housing Repair and Refinish
Figure 601 (Sheet 1 of 2)



B–B

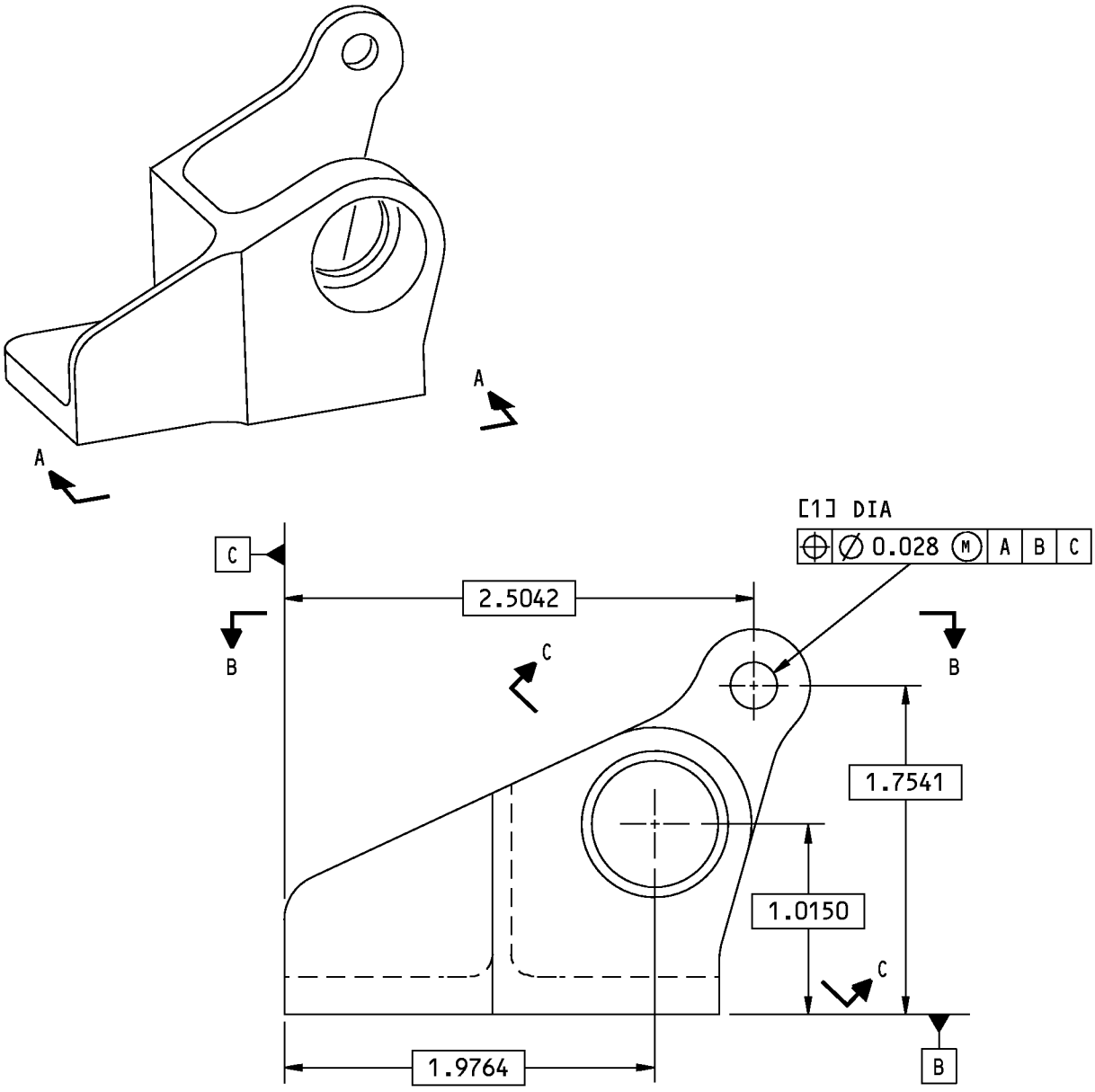
REFERENCE NUMBER	[1]	[2]	[3]	[4]	[5]
DESIGN DIMENSION	0.2600 0.2500	0.1200 0.1000	0.7823 0.7813	0.3500 0.3450	0.7000 0.6750
REPAIR LIMIT	---	---	---	---	---

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

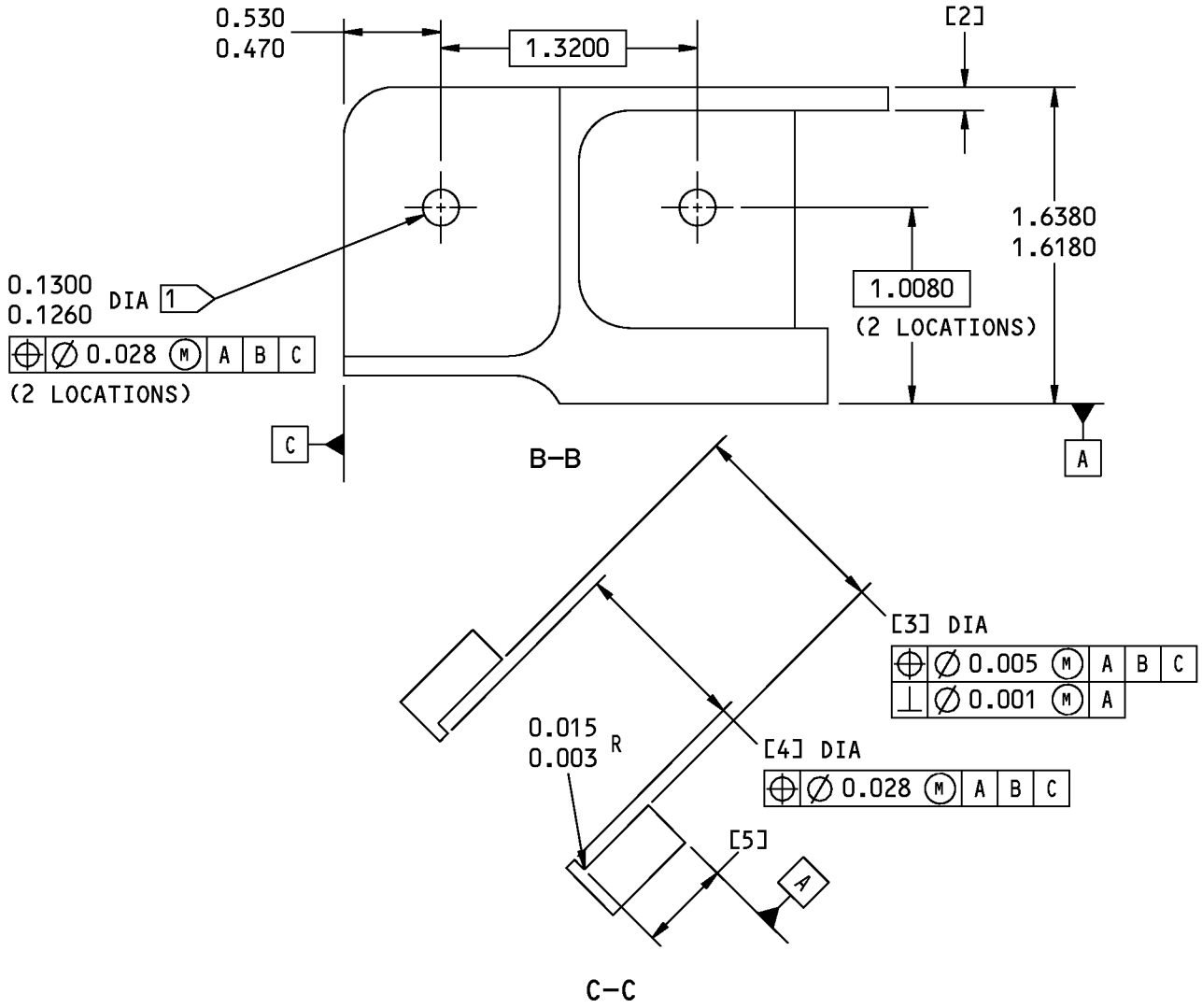
ALL DIMENSIONS ARE IN INCHES

146A6512-101 Bearing Housing Repair and Refinish
Figure 601 (Sheet 2 of 2)



A–A

146A6512-103 Bearing Housing Repair and Refinish
Figure 602 (Sheet 1 of 2)



REFERENCE NUMBER	[1]	[2]	[3]	[4]	[5]
DESIGN DIMENSION	0.2600 0.2500	1.1300 0.1100	0.7823 0.7813	0.7000 0.6750	0.3500 0.3450
REPAIR LIMIT	—	—	—	—	—

1 PILOT HOLE ON NEW HOUSINGS, TO BE DRILLED TO FINAL SIZE FOR FASTENER INSTALLATION (REPAIR 7-1)

ALL DIMENSIONS ARE IN INCHES

146A6512-103 Bearing Housing Repair and Refinish
Figure 602 (Sheet 2 of 2)

LATCH SHAFT ASSEMBLY - REPAIR 10-1

146A6520–1

1. General

A. This procedure tells how to replace the parts of latch shaft assembly (576).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices shown in the repair.

C. Refer to IPL Figure 3 for item numbers.

2. Parts Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. Procedure (REPAIR 10-1, Figure 601)

(1) Remove the sealant from the fasteners.

(2) Remove nuts (591), bolts (579, 582), washers (585, 588).

(3) Remove bearing housing assemblies (435, 438), crank assemblies (465, 492).

(4) Pull out shaft (651) and remove springs (636, 642) and sleeves (633, 645).

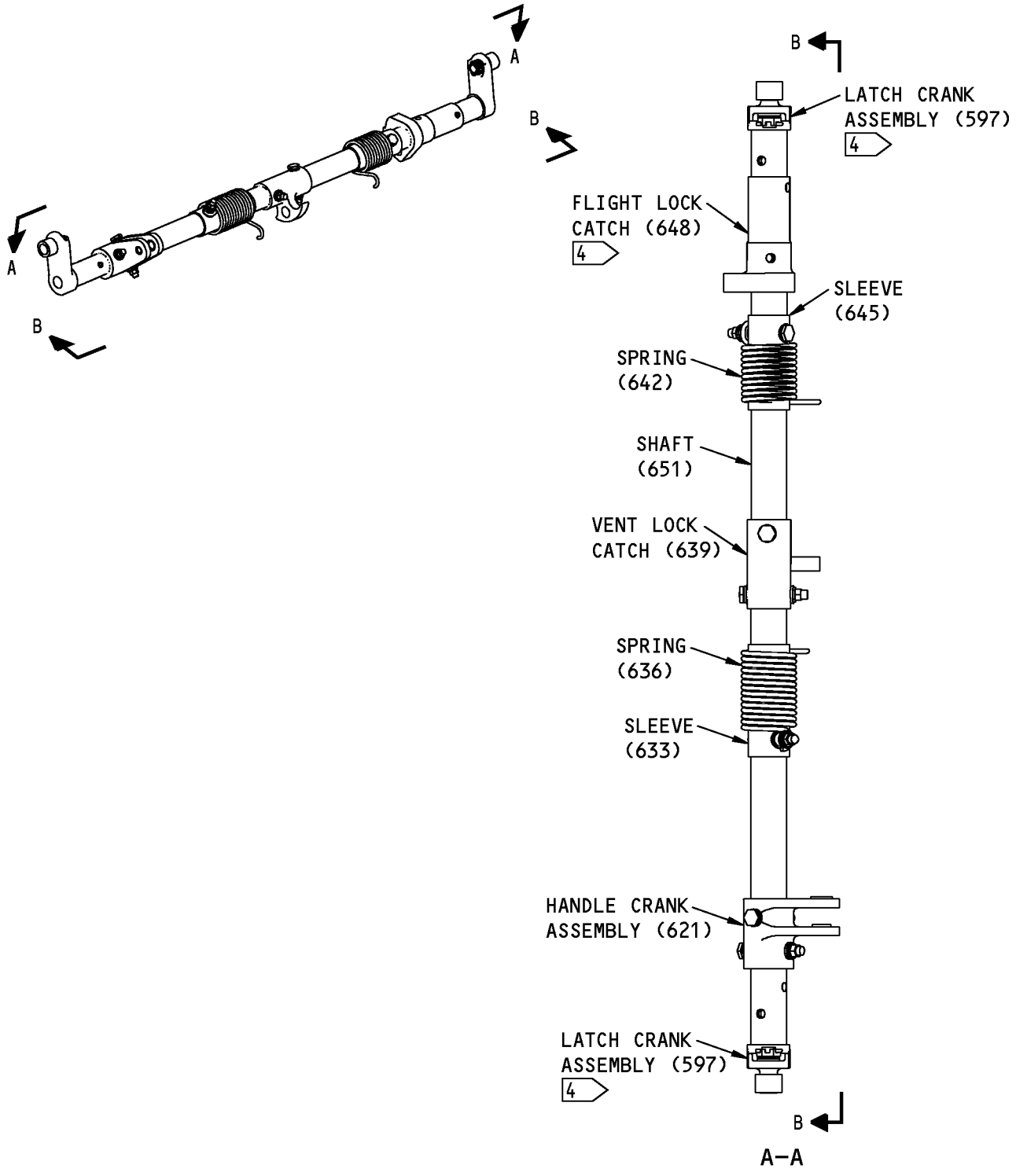
(5) If you find defects on the springs, sleeves, catches, cranks, bearing housings, or shaft, refer to REPAIR 1-1, REPAIR 11-1, REPAIR 12-1 and REPAIR 13-1 for repair instructions.

(6) Install replacement springs (636, 642) and sleeves (633, 645) on the shaft.

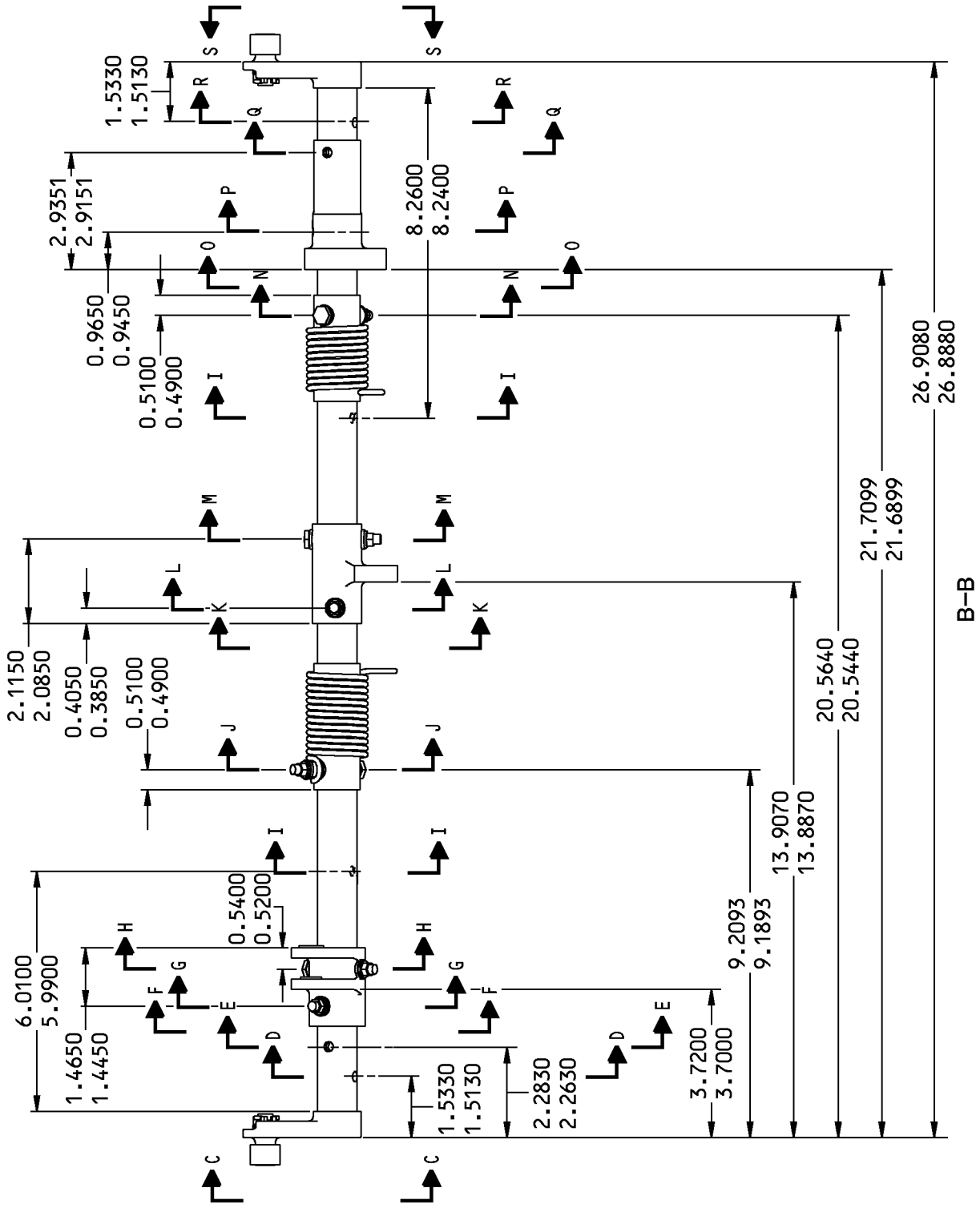
(7) Install catches (633, 648), and crank assemblies (597, 621) on the shaft with bolts (579, 582), washers (585, 588) and nuts (591) with wet BMS 5-95 sealant, A00247 on mating surfaces unless shown differently by flagnote 4. If you replaced the catches, cranks or shaft with new ones, drill holes as shown for these fasteners, because the new catches, cranks and shaft come with only pilot holes.

(8) If you replaced the shaft, also drill drain holes in the new shaft as shown, because the new shaft does not come with them.

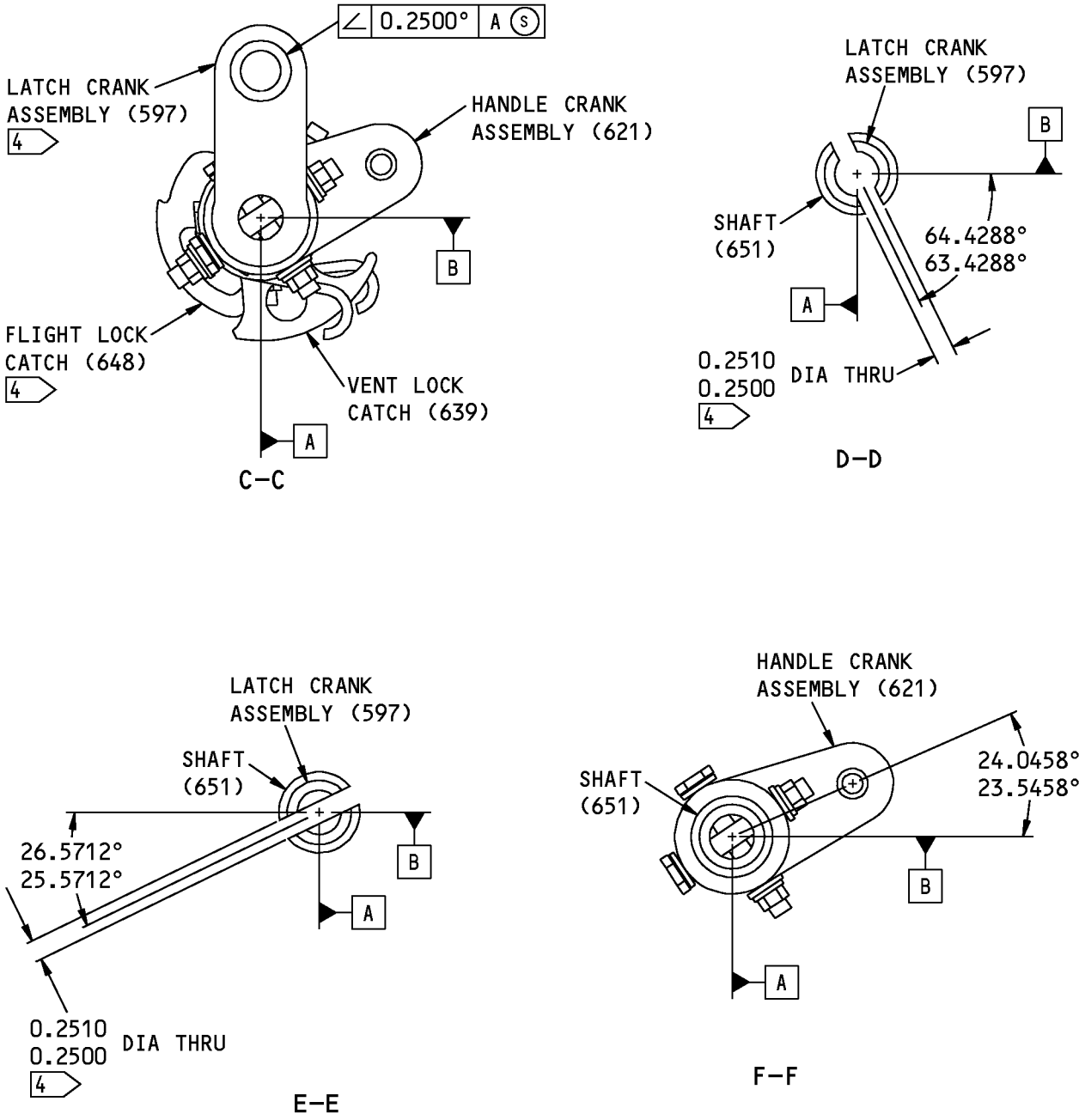
(9) With a brush, apply BMS 5-95 sealant, A00247 to the threads and the mating components.



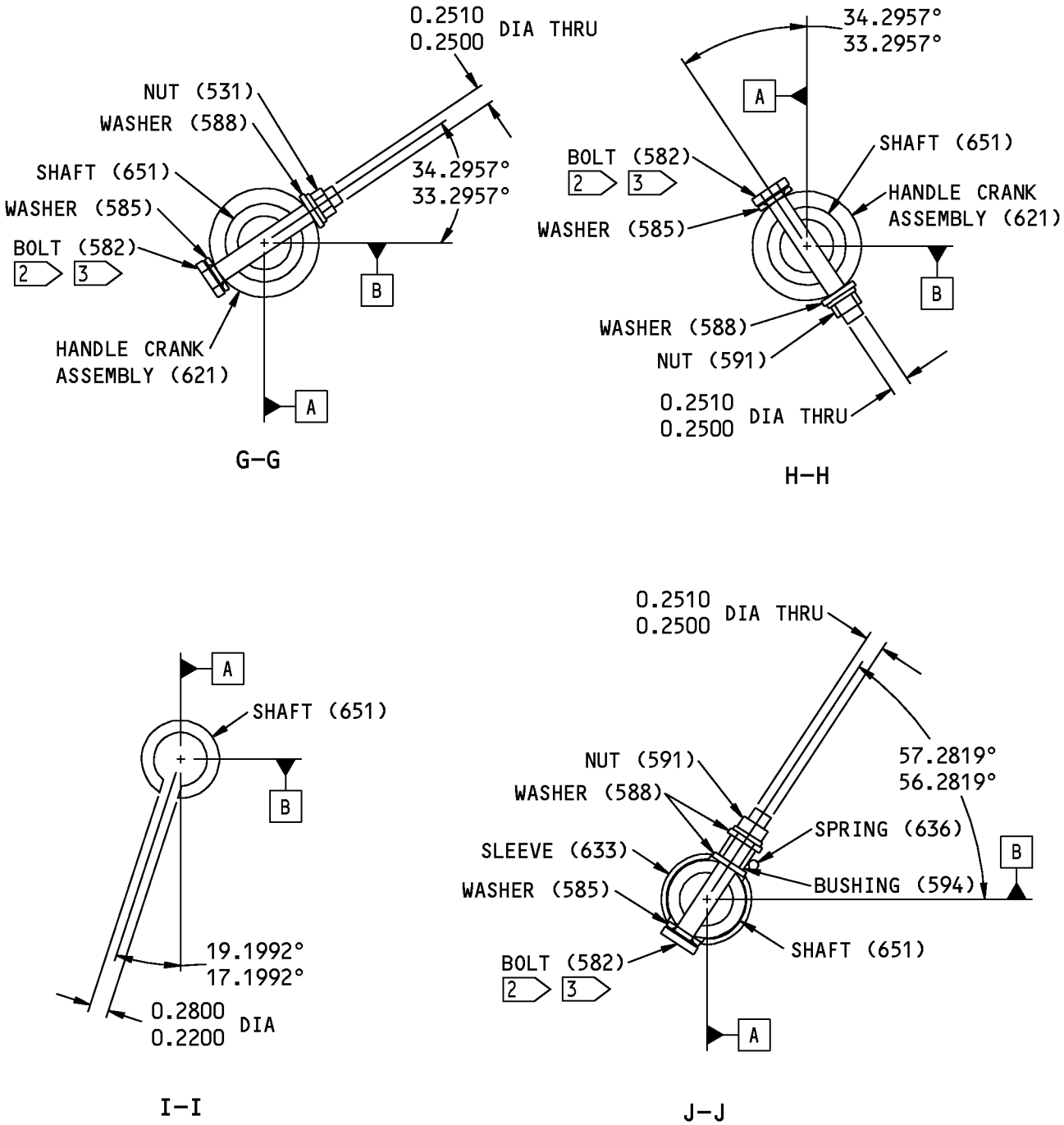
146A6520-1 Latch Shaft Assembly Parts Replacement
Figure 601 (Sheet 1 of 7)



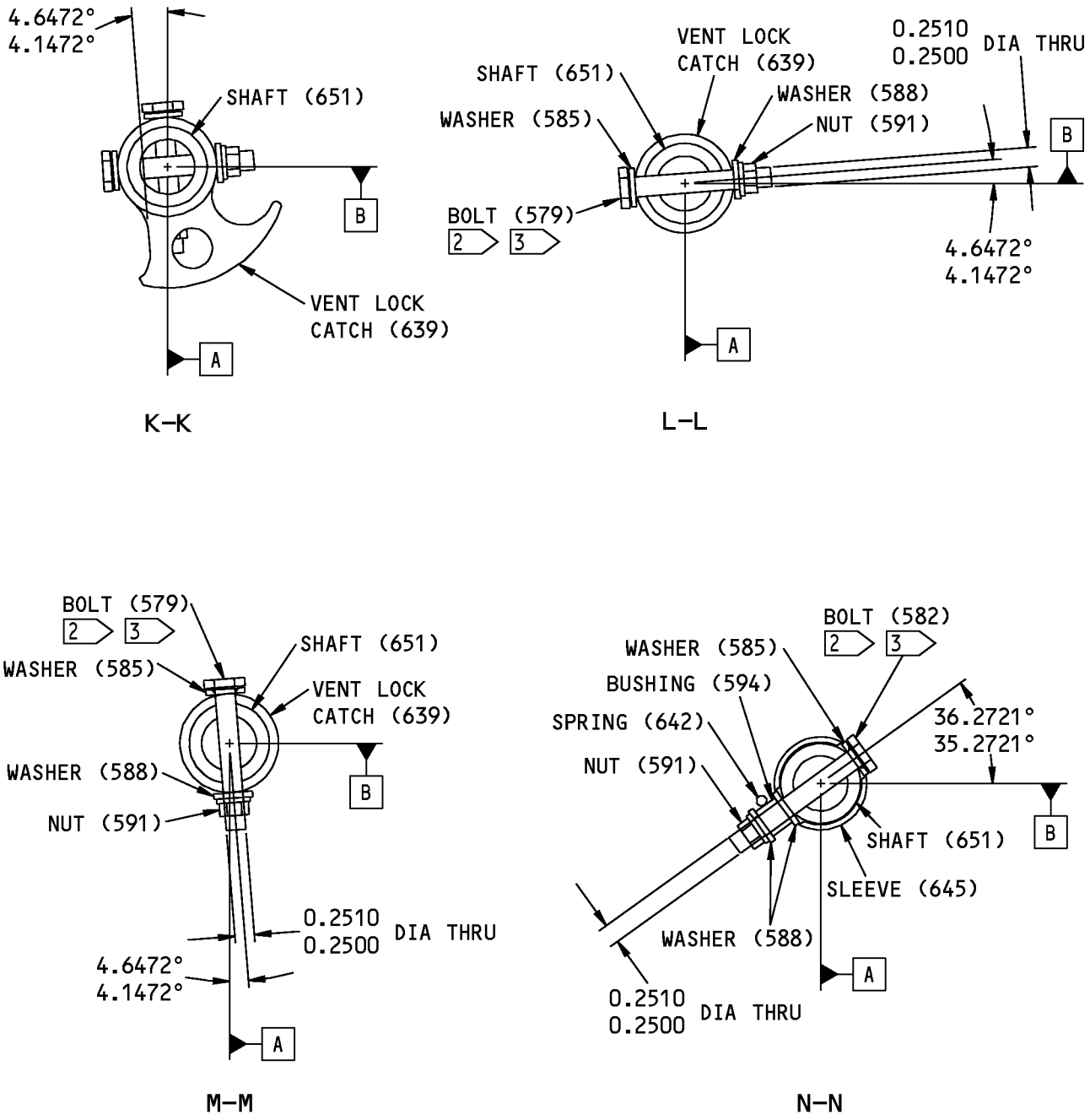
146A6520-1 Latch Shaft Assembly Parts Replacement
Figure 601 (Sheet 2 of 7)



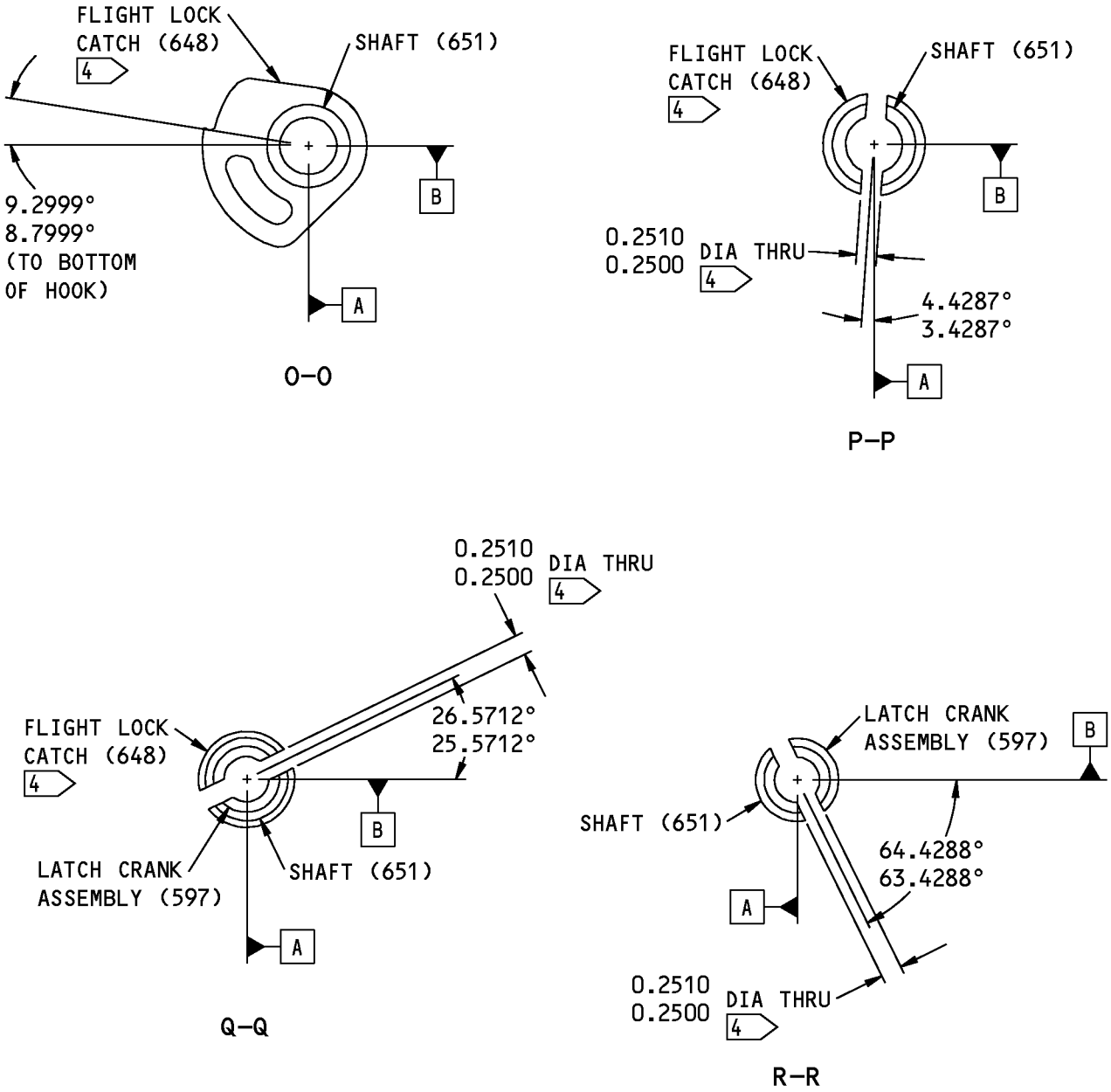
146A6520-1 Latch Shaft Assembly Parts Replacement
Figure 601 (Sheet 3 of 7)



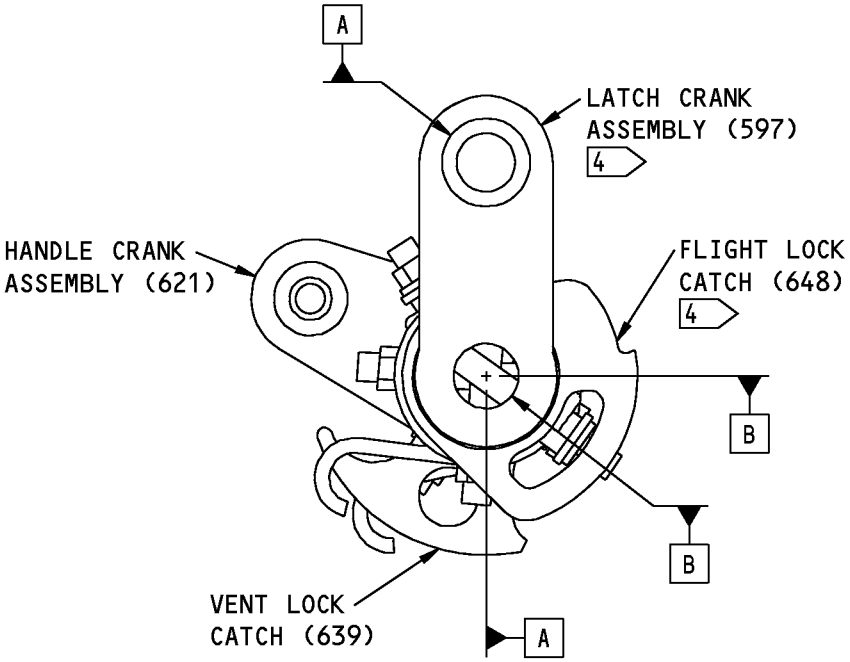
146A6520-1 Latch Shaft Assembly Parts Replacement
Figure 601 (Sheet 4 of 7)



146A6520-1 Latch Shaft Assembly Parts Replacement
Figure 601 (Sheet 5 of 7)



146A6520-1 Latch Shaft Assembly Parts Replacement
Figure 601 (Sheet 6 of 7)



S-S

1 ASSEMBLE PARTS WITH BMS 5-95 CORROSION FAYING SURFACE SEALANT (SOPM 20-50-19), BUT NOT SPRINGS OR PARTS NOTED BY 4

2 APPLY A LAYER OF BMS 5-95 SEALANT TO ALL HOLE SURFACES ON EACH SIDE BY THE BRUSH, INJECTION, OR OTHER METHODS (SOPM 20-50-19). THEN INSTALL THE FASTENER WITH WET BMS 5-95 SEALANT (SOPM 20-50-19, METHOD 1)

3 BRUSH SEAL THREADED END OF FASTENER AND MATING COMPONENTS (SOPM 20-50-19)

4 AFTER YOU DRILL THE HOLE AND REMOVE BURRS, TEMPORARILY ASSEMBLE THE COMPONENTS WITH PANDUIT STRAPS OR EQUIVALENT

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 3

ALL DIMENSIONS ARE IN INCHES

146A6520-1 Latch Shaft Assembly Parts Replacement
Figure 601 (Sheet 7 of 7)

SHAFT - REPAIR 11-1

146A6521–1

1. General

A. This procedure tells how to repair and refinish shaft (651).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 3 for item numbers.

D. General repair details:

(1) Material: 15-5PH CRES, 180-200 ksi

(2) Shot peen: not necessary

E. The engineering requirements for this shaft are controlled by sections. Note the zones in REPAIR 11-1, Figure 601.

2. Shaft Repair

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

(1) Attachment holes

(a) Repair is only replacement of the original finish. Refer to REPAIR 11-1, Paragraph 3. below for details.

(b) If you think there are defects on important surfaces, see REPAIR 11-1, Figure 601 for dimension details.

(2) Shaft surfaces

(a) Remove small defects by standard industry practices.

(b) Refinish as indicated.

3. Shaft Refinish

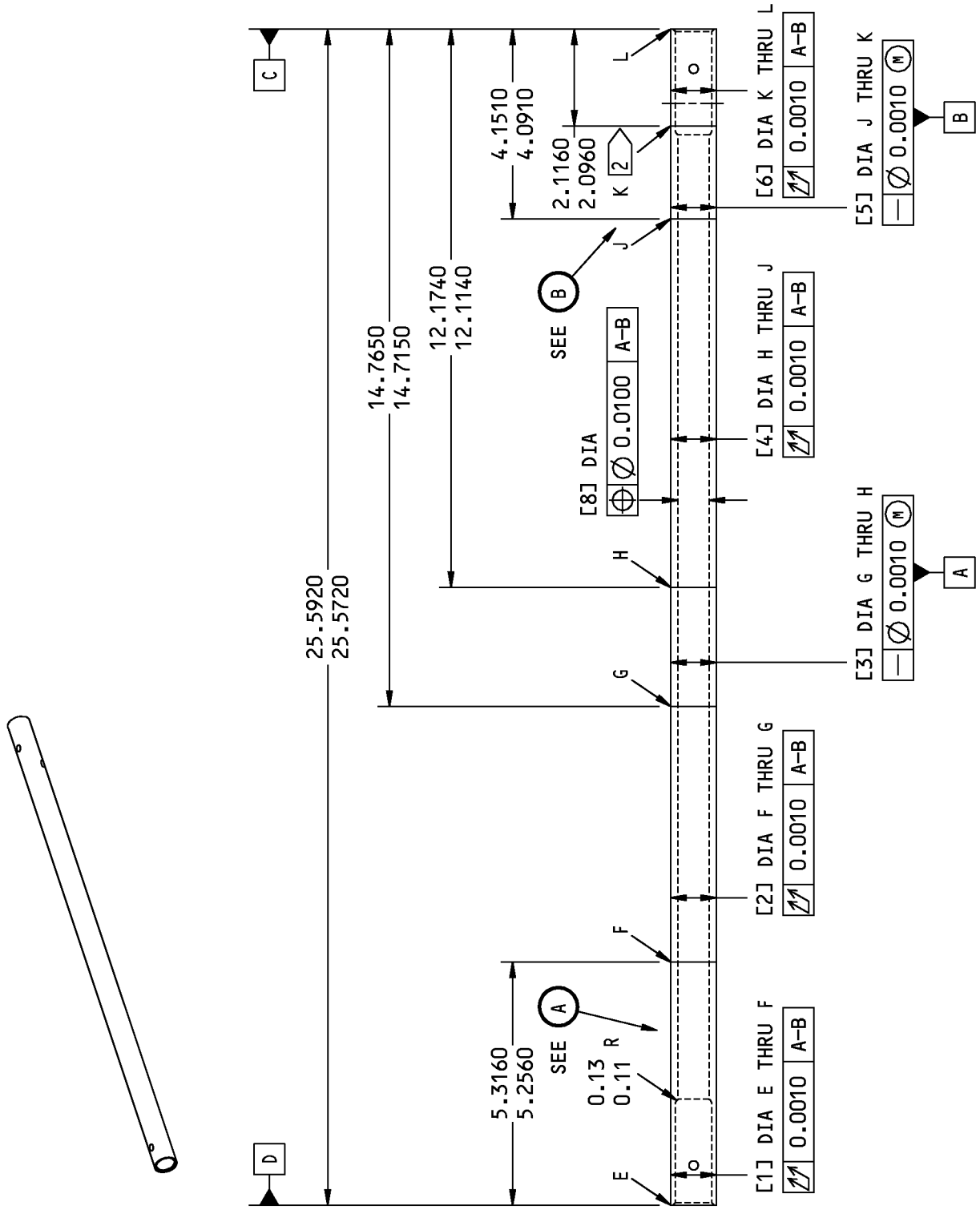
A. References

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

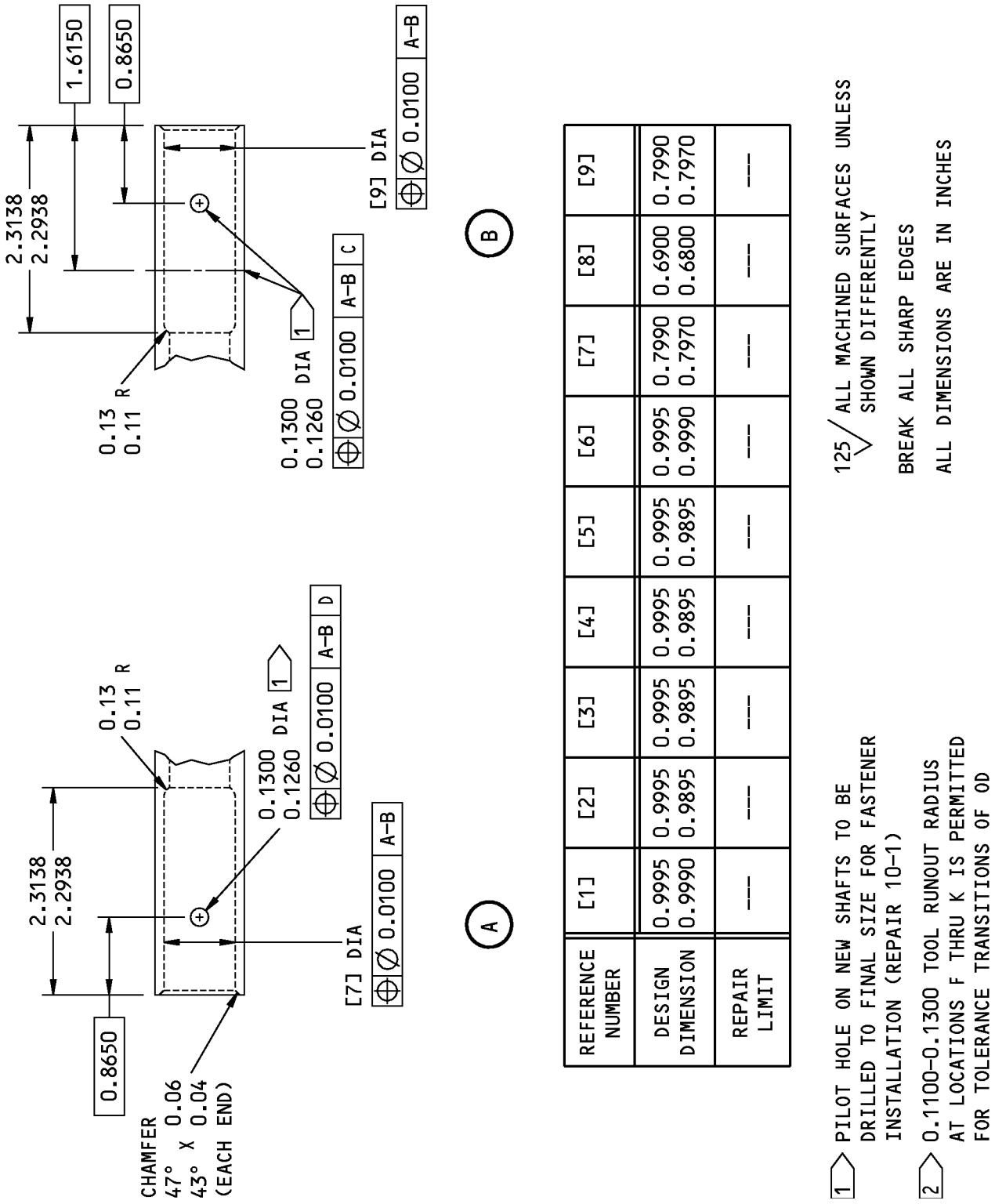
B. Procedure

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.

(1) Passivate (F-17.25).



146A6521-1 Shaft Repair and Refinish
Figure 601 (Sheet 1 of 2)



REFERENCE NUMBER	[1]	[2]	[3]	[4]	[5]	[6]	[7]	[8]	[9]
DESIGN DIMENSION	0.9995 0.9990	0.9995 0.9895	0.9995 0.9895	0.9995 0.9895	0.9995 0.9895	0.9995 0.9990	0.7990 0.7970	0.6900 0.6800	0.7990 0.7970
REPAIR LIMIT	---	---	---	---	---	---	---	---	---

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

1 PILOT HOLE ON NEW SHAFTS TO BE DRILLED TO FINAL SIZE FOR FASTENER INSTALLATION (REPAIR 10-1)

2 0.1100-0.1300 TOOL RUNOUT RADIUS AT LOCATIONS F THRU K IS PERMITTED FOR TOLERANCE TRANSITIONS OF OD

146A6521-1 Shaft Repair and Refinish
Figure 601 (Sheet 2 of 2)

LATCH CRANK ASSEMBLY - REPAIR 12-1

146A6522–1

1. General

A. This procedure tells how to replace the parts of latch crank assembly (597).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 3 for item numbers.

2. Parts Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
D00633	Grease - Aircraft General Purpose	BMS3-33

B. References

Reference	Title
SOPM 20-50-02	INSTALLATION OF SAFETYING DEVICES
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT

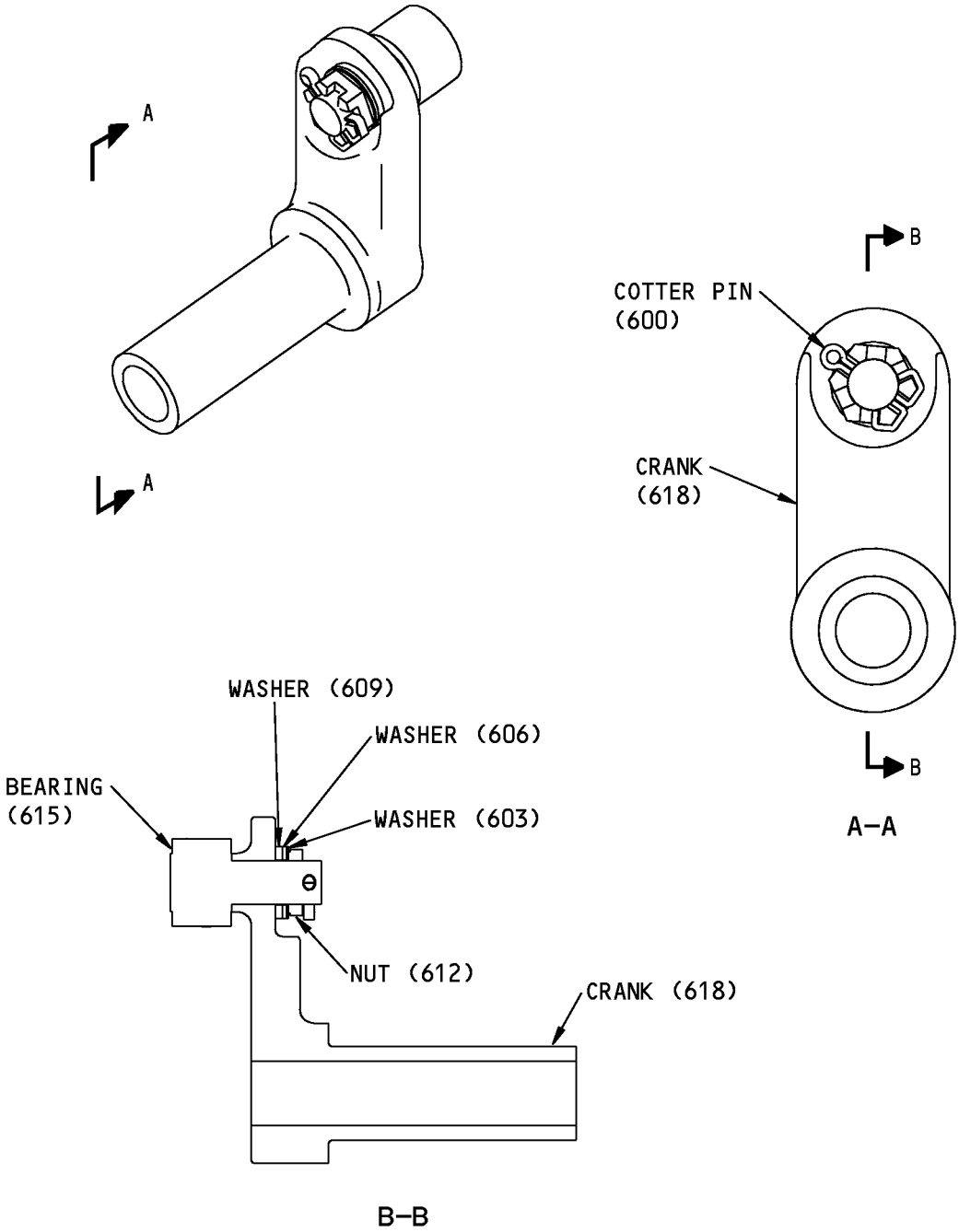
C. Procedure (REPAIR 12-1, Figure 601)

(1) Remove the cotter pin, nut, washers and bearing from the lug.

(2) If you find defects on the crank surfaces, refer to REPAIR 12-2 for repair instructions.

(3) Install a replacement bearing, washers and nut on the lug by the procedure for studded track roller bearings in SOPM 20-50-03, and as shown, with BMS 3-33 grease, D00633 on the threads.

(4) Install a new cotter pin (SOPM 20-50-02).



146A6522-1 Latch Crank Assembly Parts Replacement
Figure 601

LATCH CRANK - REPAIR 12-2

146A6522–101

1. General

A. This procedure tells how to repair and refinish latch crank (618).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 3 for item numbers.

D. General repair details:

(1) Material: 15-5PH CRES, 180-200 ksi

(2) Shot peen: not necessary

2. Latch Crank Repair

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

(1) Repair is only replacement of the original refinish. Refer to REPAIR 12-2, Paragraph 3. for details.

(2) If you think there are defects on important surfaces, see REPAIR 12-2, Figure 601 for dimension details.

3. Crank Refinish

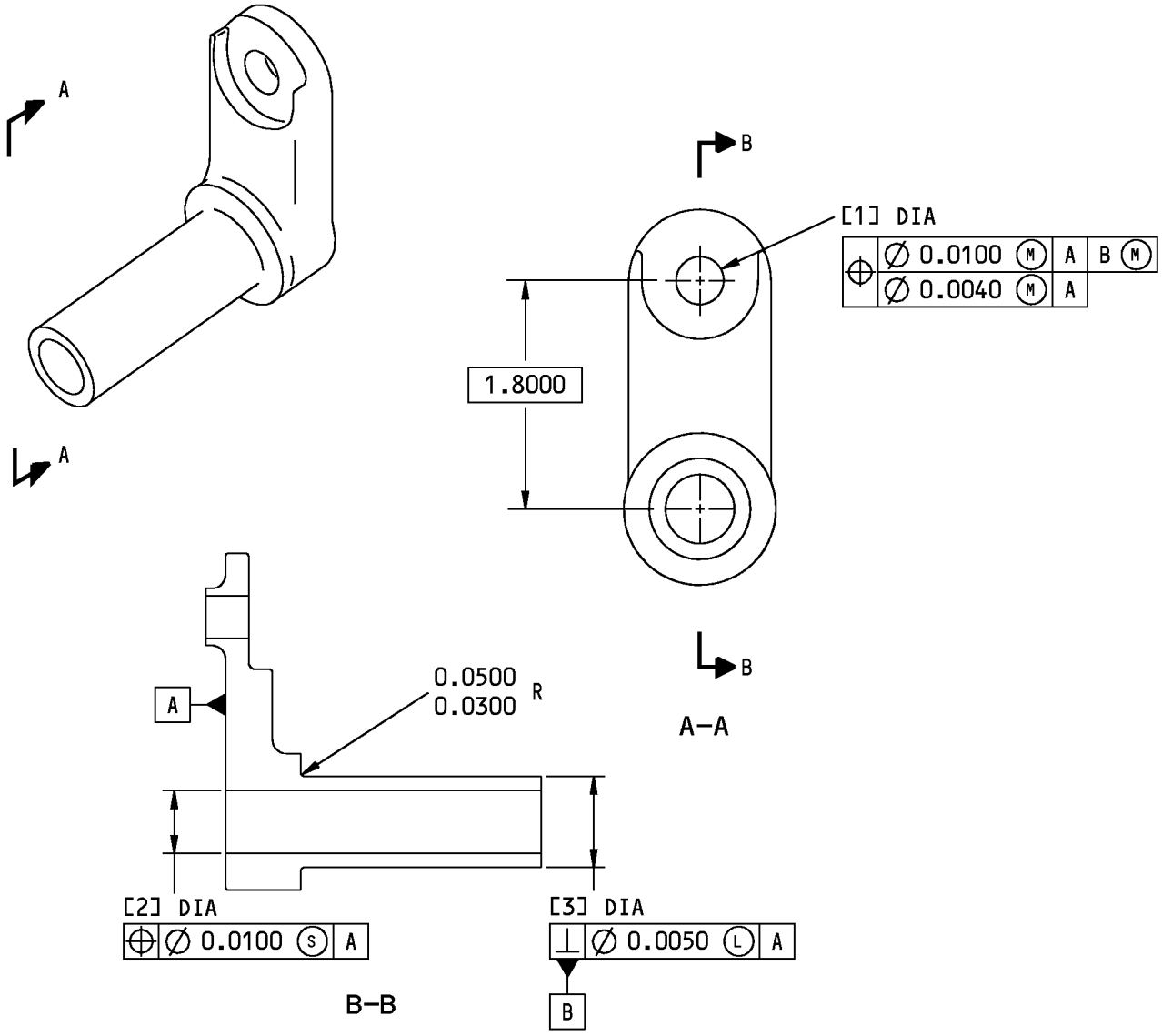
A. References

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

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

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

(1) Passivate (F-17.25).



REFERENCE NUMBER	[1]	[2]	[3]
DESIGN DIMENSION	0.3756 0.3750	0.5460 0.5410	0.7960 0.7950
REPAIR LIMIT	—	—	—

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

146A6522-101 Latch Crank Repair and Refinish
Figure 601

HANDLE CRANK ASSEMBLY - REPAIR 13-1

146A6524–1

1. General

A. This procedure tells how to replace the parts of handle crank assembly (621).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 3 for item numbers.

2. Bushing Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

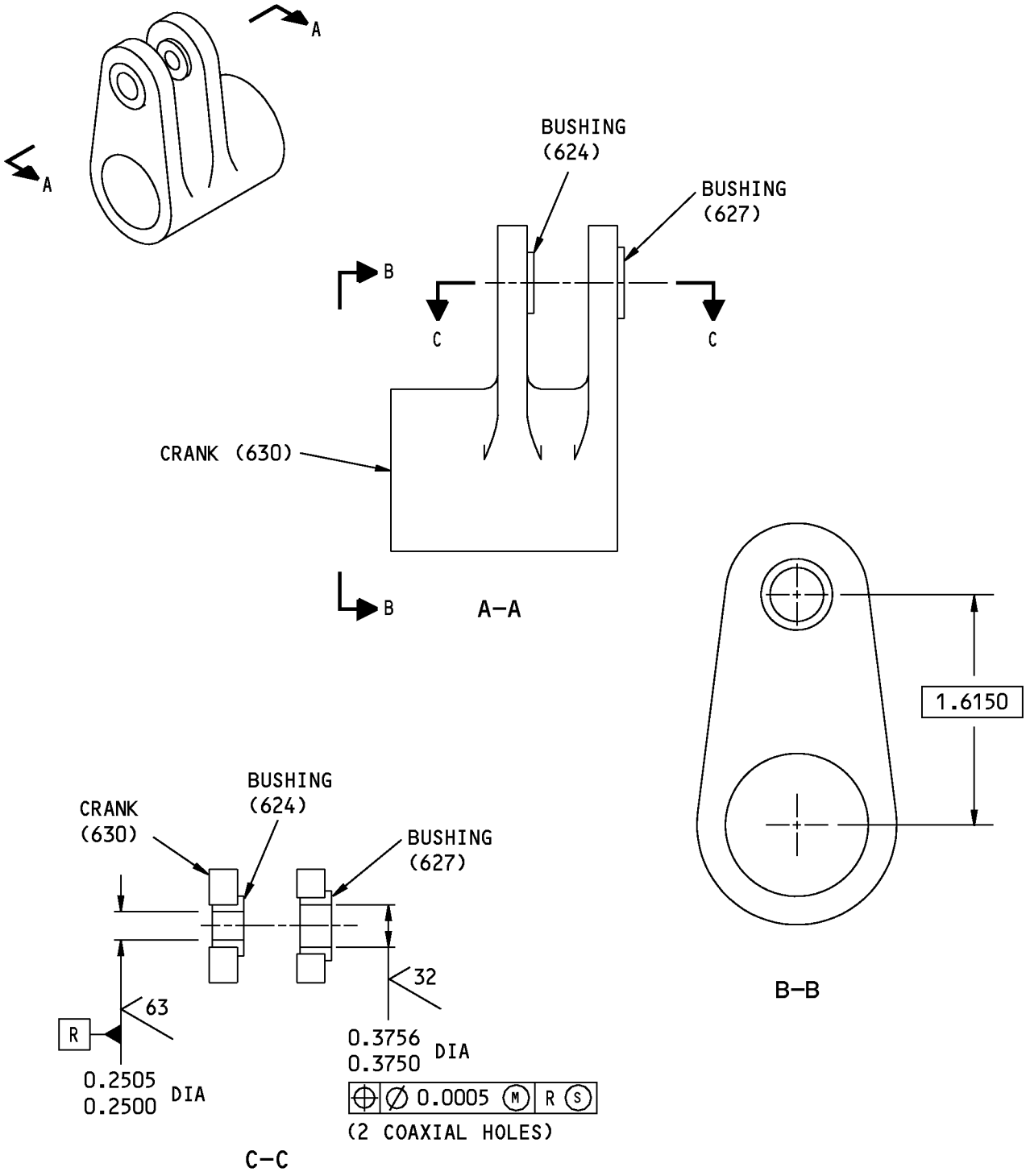
C. Procedure (REPAIR 13-1, Figure 601)

(1) Remove the old bushings.

(2) If you find defects on the crank surfaces, refer to REPAIR 13-2 for repair instructions.

(3) Install replacement bushings by the shrink fit procedure (SOPM 20-50-03) with BMS 5-95 sealant, A00247 as the installation finish.

(4) Machine the bushings to design dimensions and finish.



146A6524-1 Handle Crank Assembly Bushing Replacement
Figure 601

HANDLE CRANK - REPAIR 13-2

146A6524–101

1. General

A. This procedure tells how to repair and refinish handle crank (630).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 3 for item numbers.

D. General repair details:

(1) Material: 15-5PH CRES, 180-200 ksi

(2) Shot peen: not necessary

2. Handle Crank Repair

A. Procedure (REPAIR 13-2, Figure 601)

(1) Repair is only replacement of the original refinish. Refer to REPAIR 13-2, Paragraph 3. for details.

(2) If you think there are defects on important surfaces, see REPAIR 13-2, Figure 601 for dimension details.

3. Handle Crank Refinish

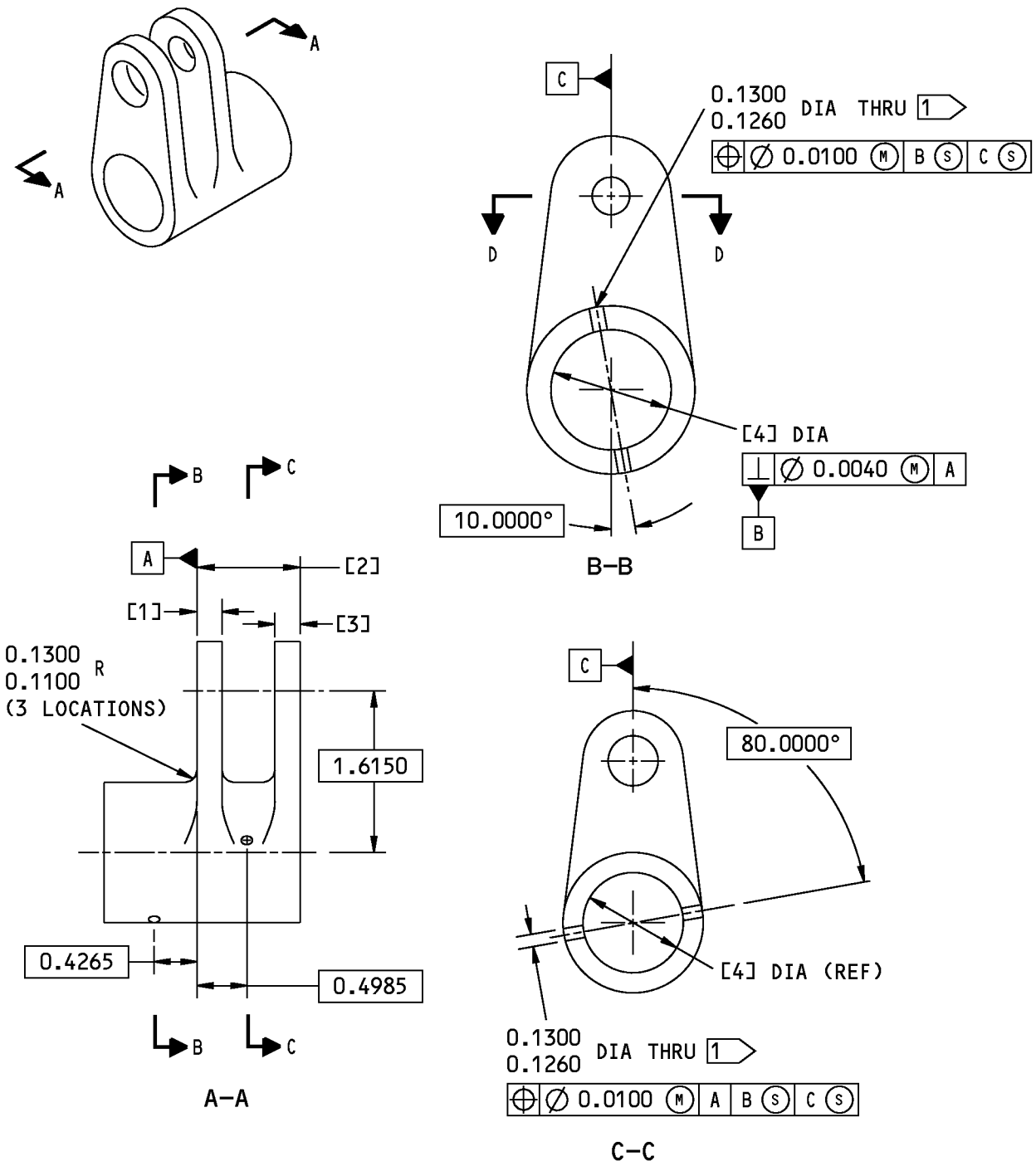
A. References

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

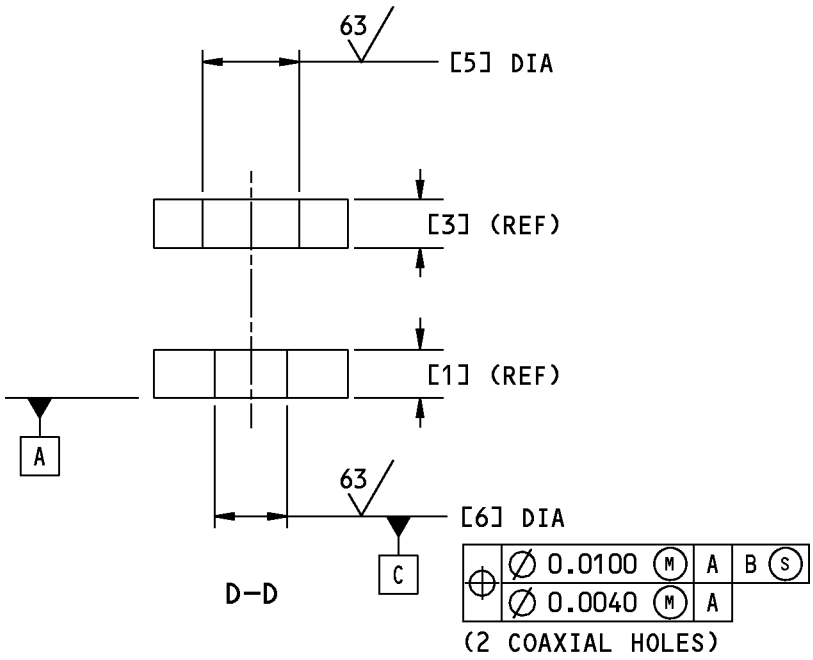
B. Procedure (REPAIR 13-2, Figure 601)

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

(1) Passivate (F-17.25).



146A6524-101 Handle Crank Repair and Refinish
Figure 601 (Sheet 1 of 2)



REFERENCE NUMBER	[1]	[2]	[3]	[4]	[5]	[6]
DESIGN DIMENSION	0.2600 0.2400	1.0385 1.0185	0.2600 0.2400	1.0035 1.0015	0.5006 0.5000	0.3756 0.3750
REPAIR LIMIT	—	—	—	—	—	—

1 PILOT HOLE ON NEW CRANKS, TO BE DRILLED TO FINAL SIZE FOR FASTENER INSTALLATION (REPAIR 10-1)

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

146A6524-101 Handle Crank Repair and Refinish
Figure 601 (Sheet 2 of 2)

BOEING®

COMPONENT MAINTENANCE MANUAL

OUTSIDE HANDLE ASSEMBLY - REPAIR 14-1

146A6526–1

1. General

A. This procedure tells how to replace the parts of outside handle assembly (635).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 2 for item numbers.

2. Bushing Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

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

(1) Remove the old bushings.

(2) If you find defects on the handle surfaces, refer to REPAIR 14-2 for repair instructions.

(3) Install replacement bushings by the shrink fit method (SOPM 20-50-03) with BMS 5-95 sealant, A00247 as the installation finish.

3. Bearing Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

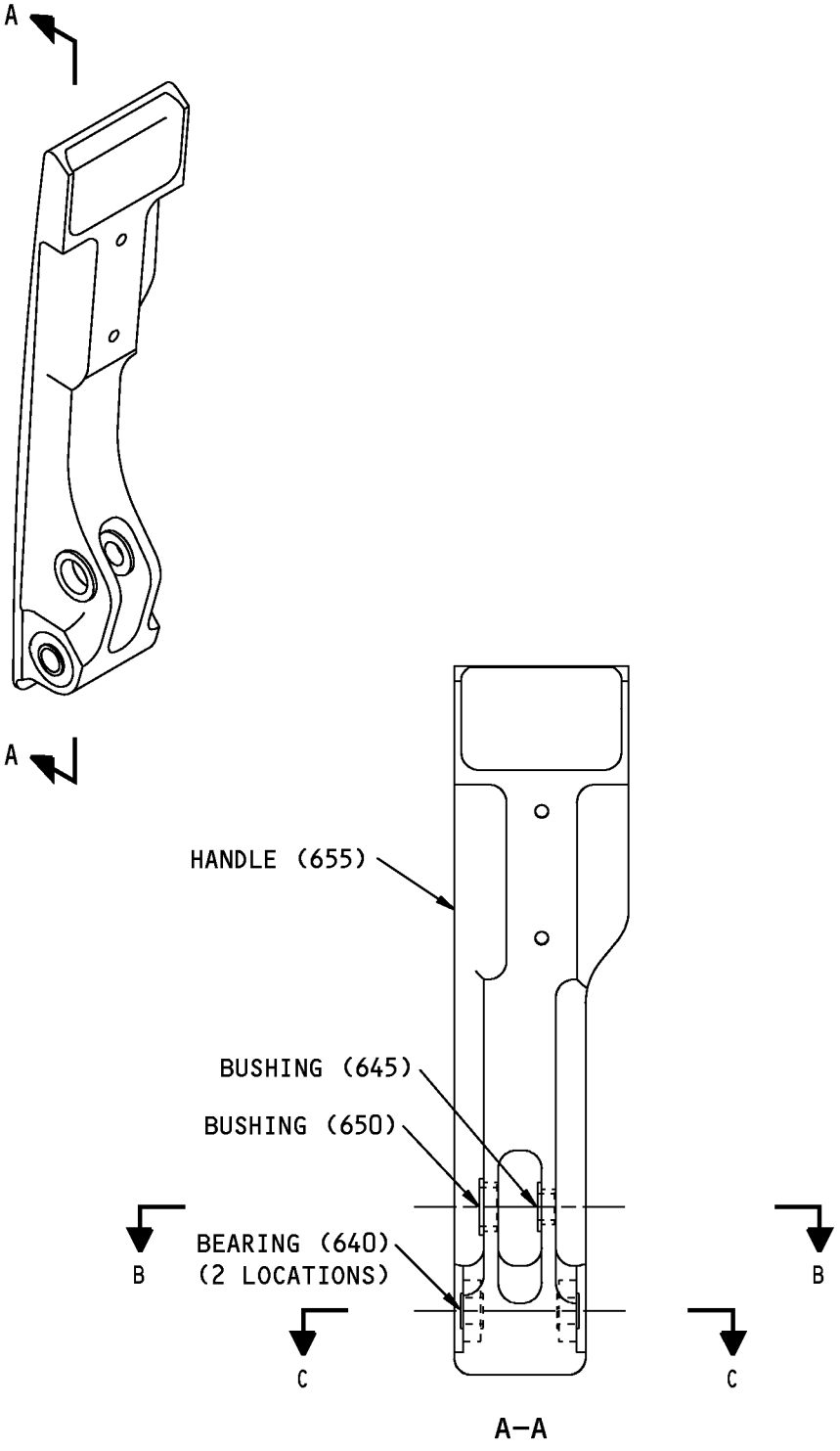
Reference	Title
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT

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

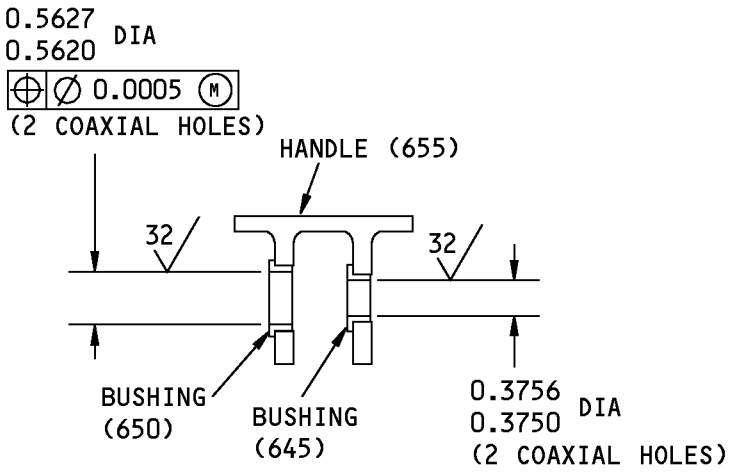
(1) Remove the old bearings.

(2) If you find defects on the handle surfaces, refer to REPAIR 14-2 for repair instructions.

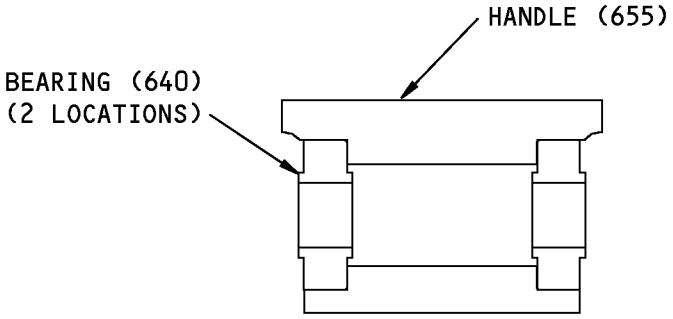
(3) Install replacement bearings by the press fit method (SOPM 20-50-03) with BMS 5-95 sealant, A00247 as the installation finish. Swaging is not necessary.



146A6526-1 Outside Handle Assembly Parts Replacement
Figure 601 (Sheet 1 of 2)



B–B



C–C

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

146A6526-1 Outside Handle Assembly Parts Replacement
Figure 601 (Sheet 2 of 2)

BOEING®

COMPONENT MAINTENANCE MANUAL

OUTSIDE HANDLE - REPAIR 14-2

146A6526–101

1. General

A. This procedure tells how to repair and refinish outside handle (655).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 2 for item numbers.

D. General repair details:

(1) Material: Al alloy

(2) Shot peen: not necessary

2. Handle Repair

A. Procedure (REPAIR 14-2, Figure 601)

(1) Repair is only replacement of the original refinish. Refer to REPAIR 14-2, Paragraph 3. for details.

(2) If you think there are defects on important surfaces, see REPAIR 14-2, Figure 601 for dimension details.

3. Handle Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
C00033	Coating - Exterior Protective Enamel, Flexibility Use	BMS10-60, Type II
C00175	Primer - Urethane Compatible, Corrosion Resistant (Less Than 1% Aromatic Amines)	BMS10-79, Type III

B. References

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

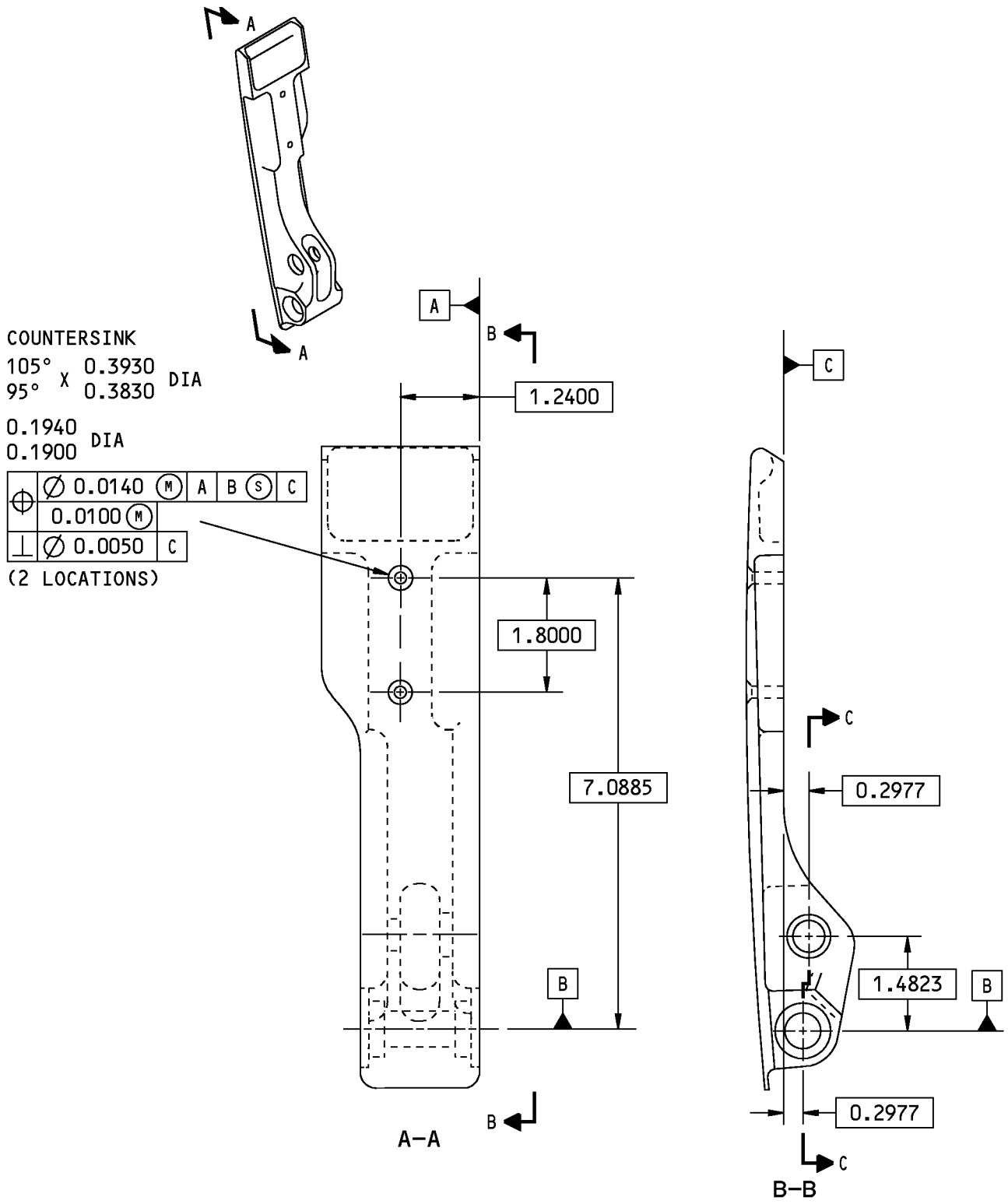
C. Procedure (REPAIR 14-2, Figure 601)

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

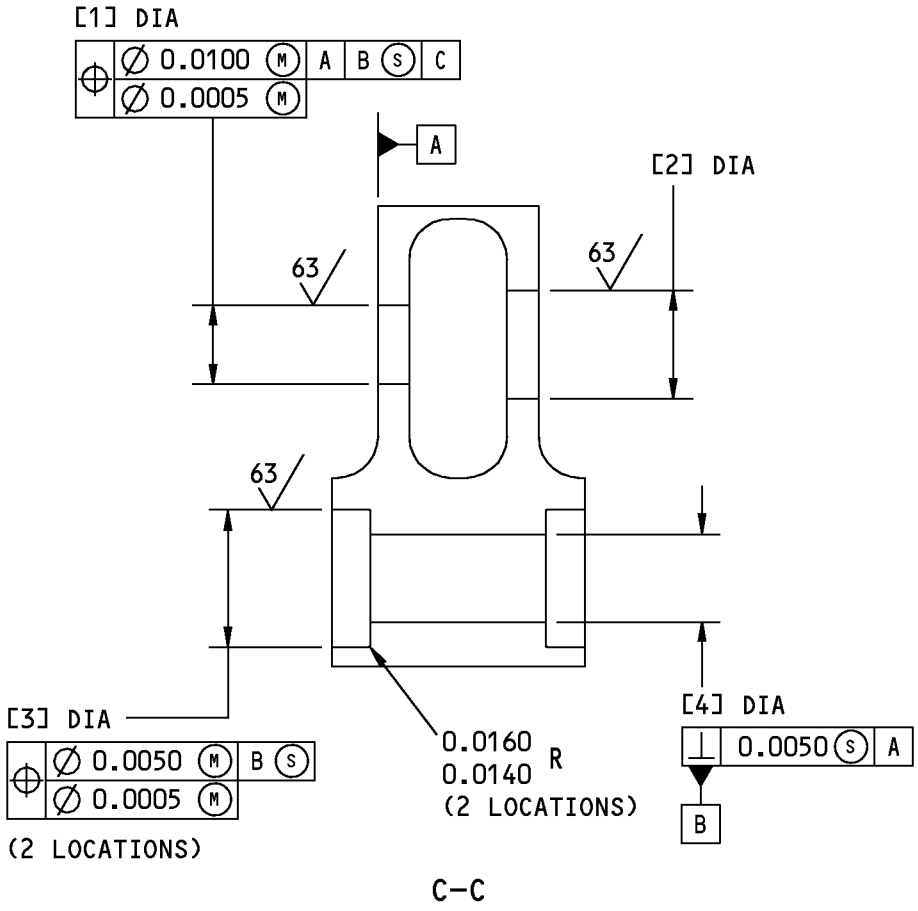
(1) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31) all over.

(2) Apply BMS 10-79, Type 3 primer, C00175 (F-19.66) but not in the holes for the bushings or bearings.

(3) Apply BMS 10-60, Type 2 coating, C00033 (F-19.39-707) but not in the holes for the bushings or bearings.



146A6526-101 Outside Handle Repair and Refinish
Figure 601 (Sheet 1 of 2)



REFERENCE NUMBER	[1]	[2]	[3]	[4]
DESIGN DIMENSION	0.6882 0.6875	0.5006 0.5000	0.8752 0.8747	0.5725 0.5525
REPAIR LIMIT	—	—	—	—

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

146A6526-101 Outside Handle Repair and Refinish
Figure 601 (Sheet 2 of 2)

HANDLE LINK ASSEMBLY - REPAIR 15-1

146A6527–1

1. General

A. This procedure tells how to replace the parts of handle link assembly (620).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 2 for item numbers.

2. Bearing Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

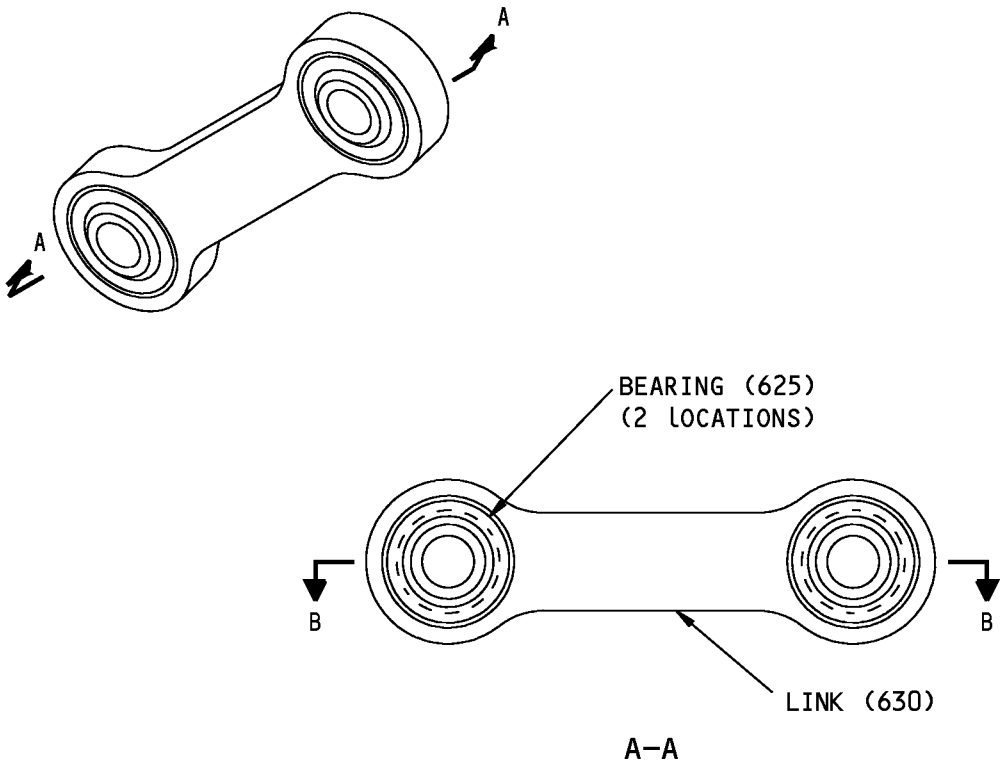
Reference	Title
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT

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

(1) Remove the old bearings.

(2) If you find defects on the link surfaces, refer to REPAIR 15-2 for repair instructions.

(3) Install replacement bearings and roller swage them (SOPM 20-50-03) with BMS 5-95 sealant, A00247 as the installation finish.



ITEM NUMBERS REFER TO IPL FIG. 2

146A6527-1 Handle Link Assembly Parts Replacement
Figure 601

HANDLE LINK - REPAIR 15-2

146A6527–101

1. General

A. This procedure tells how to repair and refinish handle link (630).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 2 for item numbers.

D. General repair details:

(1) Material: 15-5PH CRES, 180-200 ksi

(2) Shot peen: not necessary

2. Link Repair

A. Procedure (REPAIR 15-2, Figure 601)

(1) Repair is only replacement of the original refinish. Refer to REPAIR 15-2, Paragraph 3. for details.

(2) If you think there are defects on important surfaces, see REPAIR 15-2, Figure 601 for dimension details.

3. Link Refinish

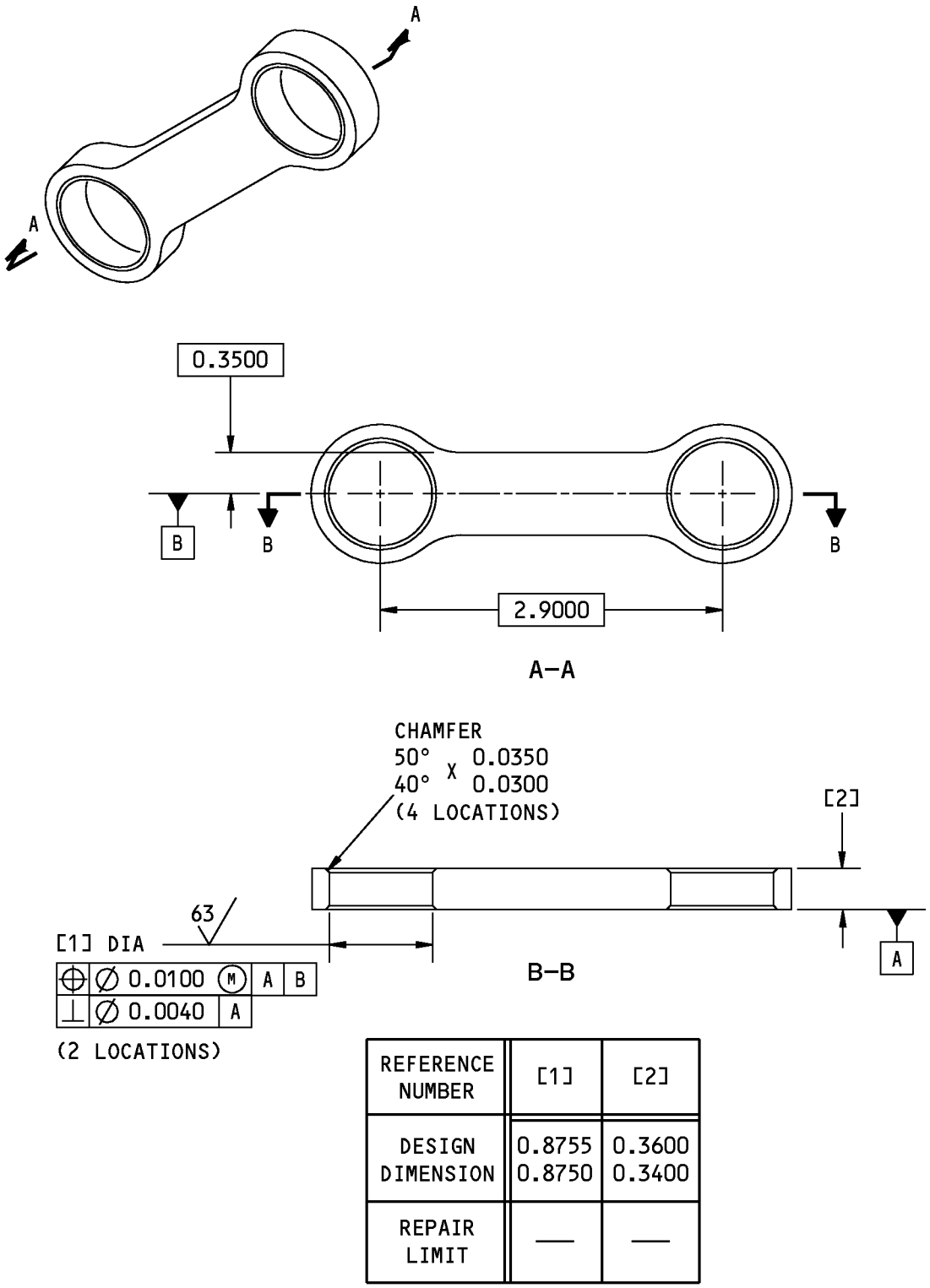
A. References

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

B. Procedure (REPAIR 15-2, Figure 601)

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

(1) Passivate (F-17.25).



REFERENCE NUMBER	[1]	[2]
DESIGN DIMENSION	0.8755 0.8750	0.3600 0.3400
REPAIR LIMIT	—	—

146A6527-101 Handle Link Repair and Refinish
Figure 601

PUSH ROD ASSEMBLY - REPAIR 16-1

146A6530–1, –2

1. General

A. This procedure tells how to replace the parts of push rod assemblies (90, 140).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices shown in the repair.

C. Refer to IPL Figure 2 for item numbers.

2. Parts Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
G50136	Paste - Corrosion Inhibiting, Non-drying	BMS 3-38

B. Procedure (REPAIR 16-1, Figure 601 or REPAIR 16-1, Figure 602)

(1) Disassemble the push rod assemblies by standard industry practices.

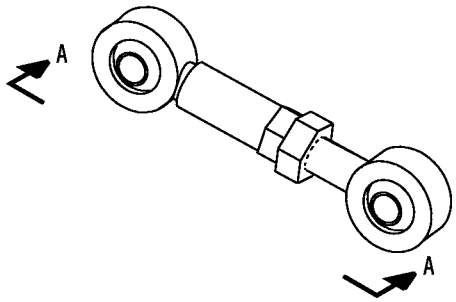
(2) Replace parts as necessary.

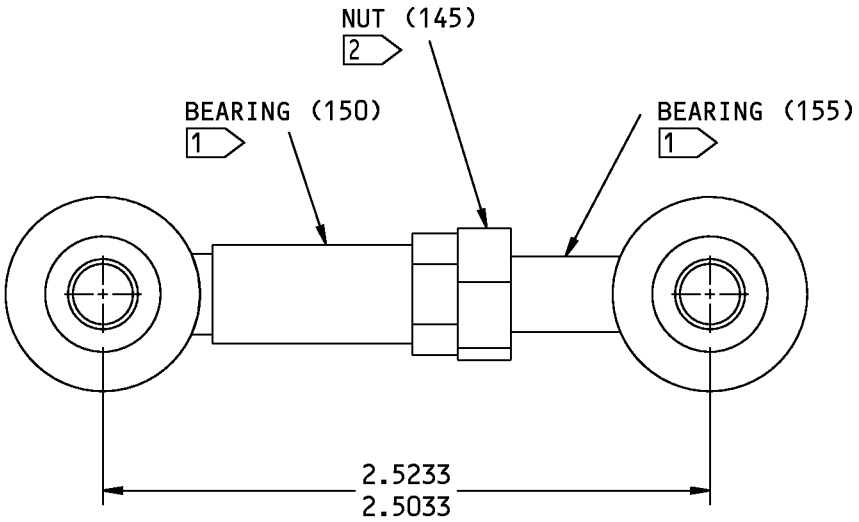
(3) If you find defects on vent door push rod (105), refer to REPAIR 16-2 for repair instructions.

(4) Assemble the parts with BMS 3-38 corrosion inhibiting non-drying paste, G50136 on the mating threads. Remove unwanted compound after assembly.

(5) Adjust the push rod assemblies to the length shown.

(6) Tighten the jam nuts only hand-tight, because the push rod assemblies will be adjusted to final length when they are installed in the door assembly.





A–A

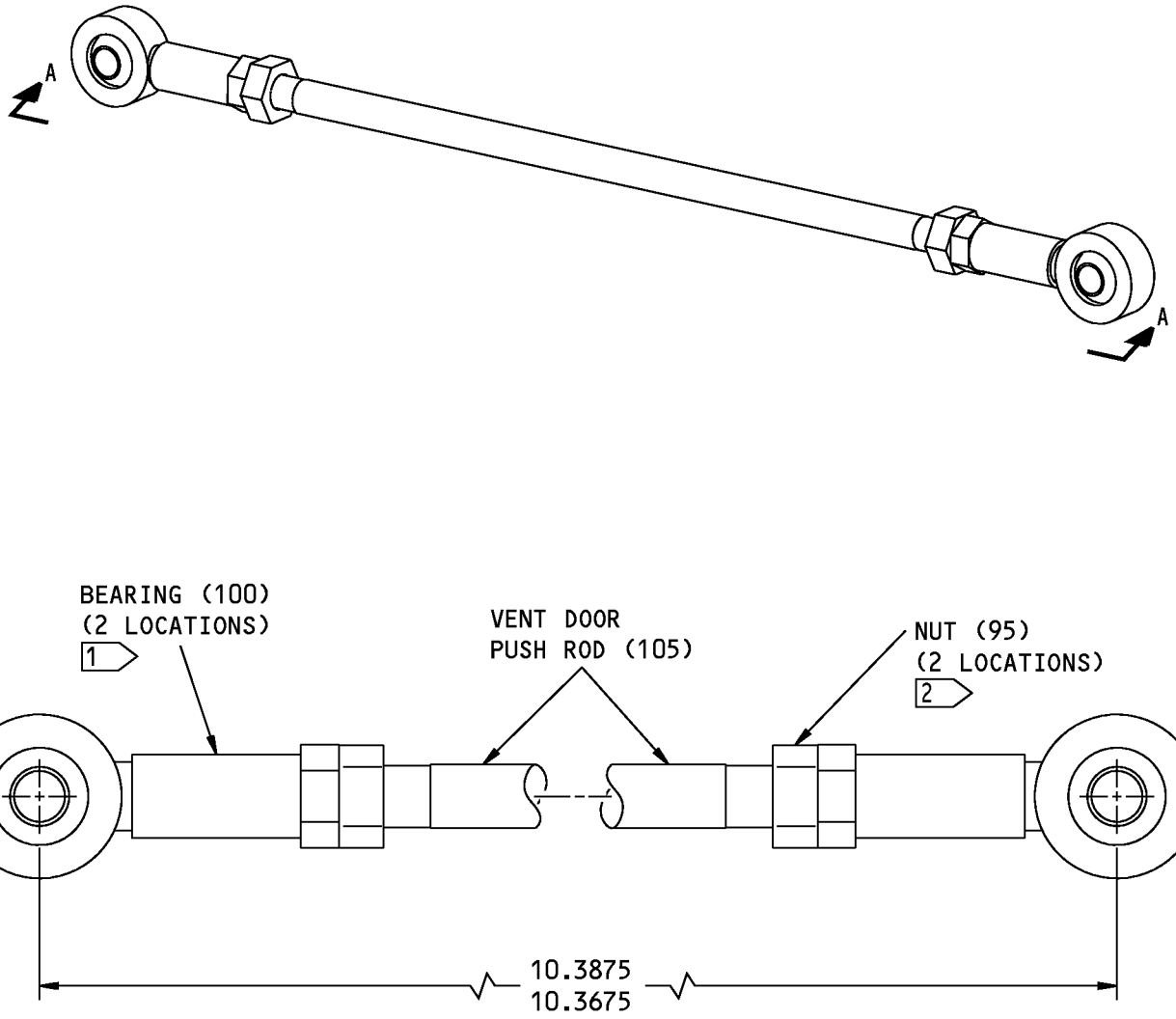
1 APPLY A THIN LAYER OF BMS 3-38 CORROSION PREVENTIVE COMPOUND TO THREADS

2 TIGHTEN HAND-TIGHT

ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

146A6530-1 Push Rod Assembly Parts Replacement
Figure 601



1 APPLY A THIN LAYER OF BMS 3-38 CORROSION PREVENTIVE COMPOUND TO THREADS

2 TIGHTEN HAND-TIGHT

ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

146A6530-2 Push Rod Assembly Parts Replacement
Figure 602

VENT DOOR PUSH ROD - REPAIR 16-2

146A6531–1

1. General

A. This procedure tells how to repair and refinish vent door push rod (105).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 2 for item numbers.

D. General repair details:

(1) Material: 15-5PH CRES, 180-200 ksi

(2) Shot peen: not necessary

2. Rod Repair

A. Procedure (REPAIR 16-2, Figure 601)

(1) Repair is only replacement of the original refinish. Refer to REPAIR 16-2, Paragraph 3. for details.

(2) If you think there are defects on important surfaces, see REPAIR 16-2, Figure 601 for dimension details.

3. Rod Refinish

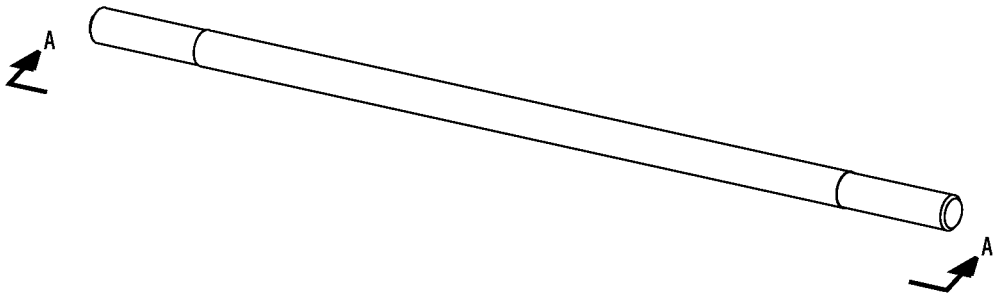
A. References

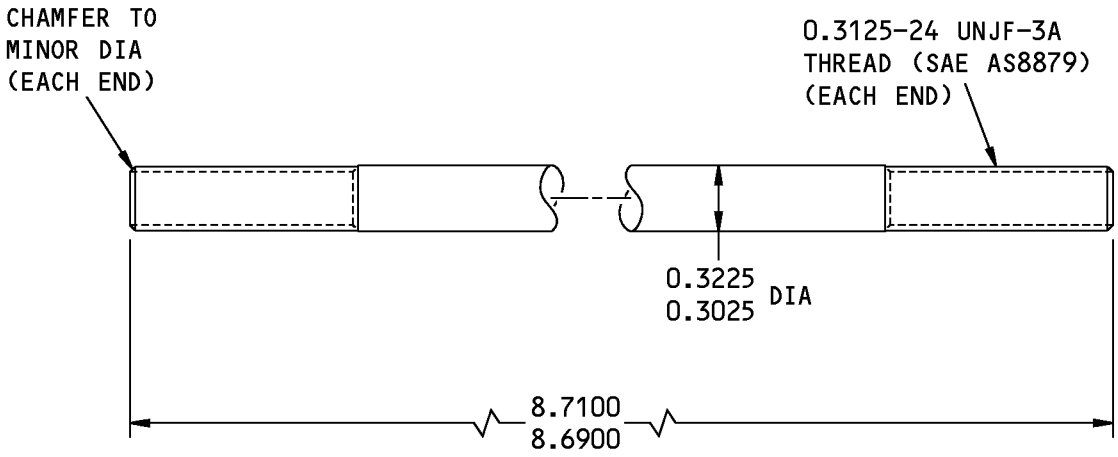
Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES

B. Procedure (REPAIR 16-2, Figure 601)

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

(1) Passivate (F-17.25).





A–A

ALL DIMENSIONS ARE IN INCHES

146A6531-1 Vent Door Push Rod Repair and Refinish
Figure 601

OUTSIDE HANDLE SHAFT ASSEMBLY - REPAIR 17-1

146A6532–1

1. General

A. This procedure tells how to replace the parts of outside handle shaft assembly (380).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices shown in the repair.

C. Refer to IPL Figure 2 for item numbers.

2. Parts Replacement

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

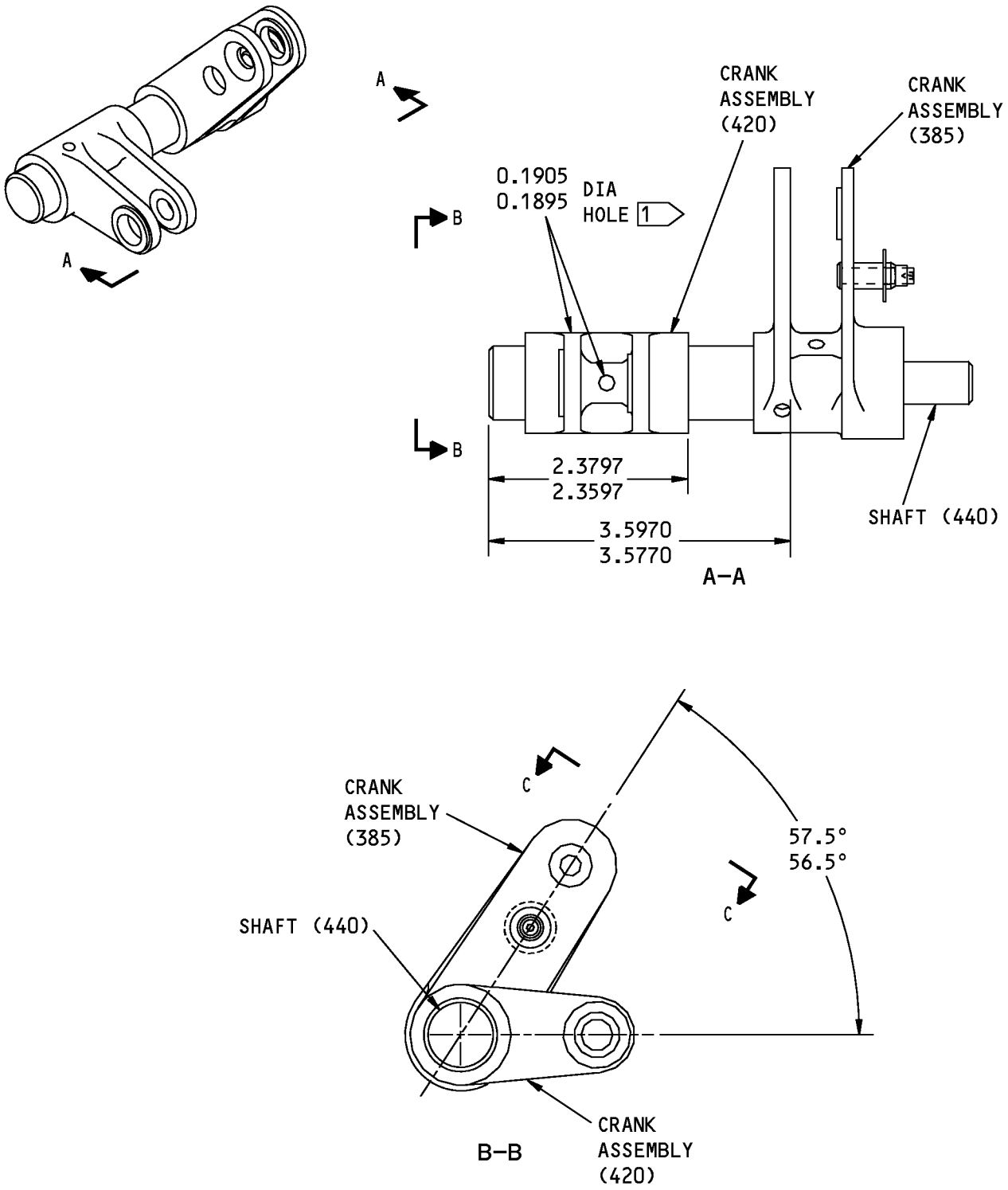
(1) Remove the fasteners if any are installed.

(2) Remove crank assemblies (385, 420) from shaft (440).

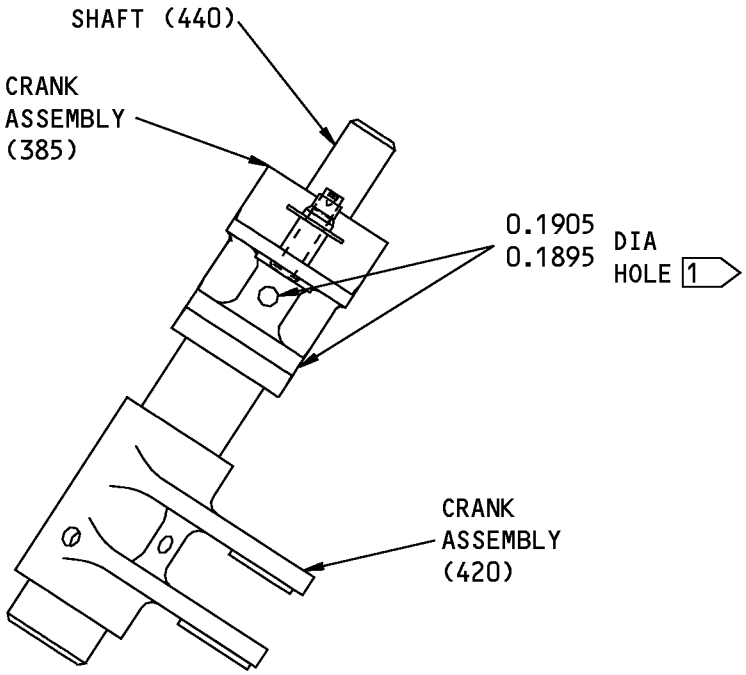
(3) If you find defects on the cranks or shaft, refer to REPAIR 18-1, REPAIR 19-1 and REPAIR 20-1 for repair instructions.

(4) Install crank assemblies (385, 420) on the shaft. If you replaced the cranks or shaft with new ones, drill holes as shown for the fasteners, because the new cranks and shaft come with only pilot holes.

(5) Temporarily hold the components together with Panduit straps or something equivalent.



146A6532-1 Outside Handle Shaft Assembly Parts Replacement
Figure 601 (Sheet 1 of 2)



C–C

1 USE THE PILOT HOLE IN THE CRANK AS A GUIDE. REMOVE THE BURRS. TEMPORARILY ASSEMBLE THE CONPONENTS WITH PANDUIT STRAPS OR EQUIVALENT.

ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

146A6532-1 Outside Handle Shaft Assembly Parts Replacement
Figure 601 (Sheet 2 of 2)

OUTSIDE HANDLE CRANK ASSEMBLY - REPAIR 18-1

146A6535–1

1. General

A. This procedure tells how to replace the parts of outside handle crank assembly (420).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 2 for item numbers.

2. Bushing Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

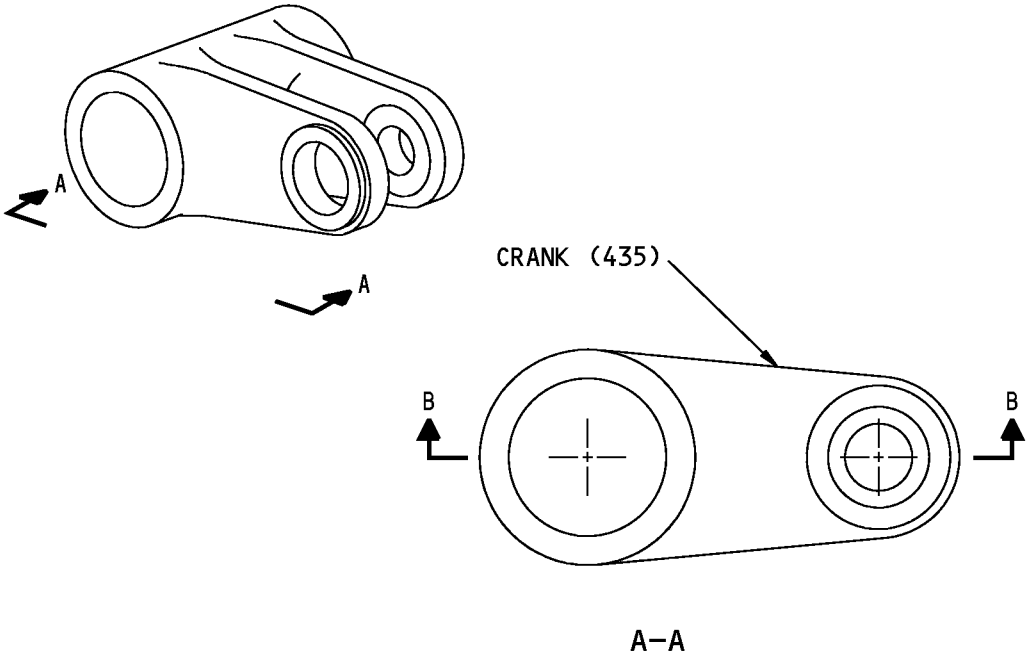
C. Procedure (REPAIR 18-1, Figure 601)

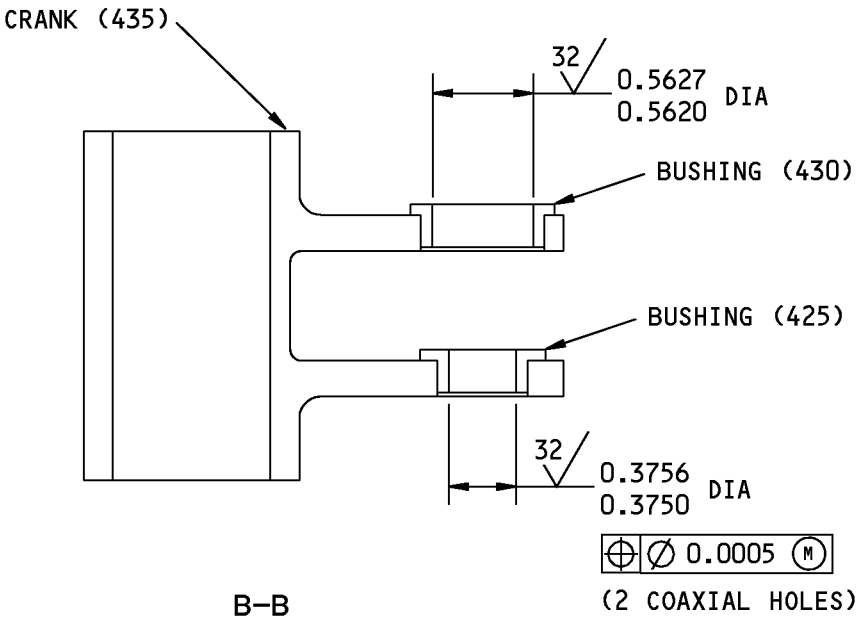
(1) Remove the old bushings.

(2) If you find defects on the hole surfaces, refer to REPAIR 18-2 for repair instructions.

(3) Install replacement bushings by the shrink fit method (SOPM 20-50-03) with BMS 5-95 sealant, A00247 as the installation finish.

(4) Machine the bushings to design dimensions and finish.





146A6535-1 Outside Handle Crank Assembly Parts Replacement
Figure 601

CRANK - REPAIR 18-2

146A6535–101

1. General

A. This procedure tells how to repair and refinish crank (435).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 2 for item numbers.

D. General repair details:

(1) Material: 15-5PH CRES, 180-200 ksi

(2) Shot peen: not necessary

2. Crank Repair

A. Procedure (REPAIR 18-2, Figure 601)

(1) Repair is only replacement of the original refinish. Refer to REPAIR 18-2, Paragraph 3. for details.

(2) If you think there are defects on important surfaces, see REPAIR 18-2, Figure 601 for dimension details.

3. Crank Refinish

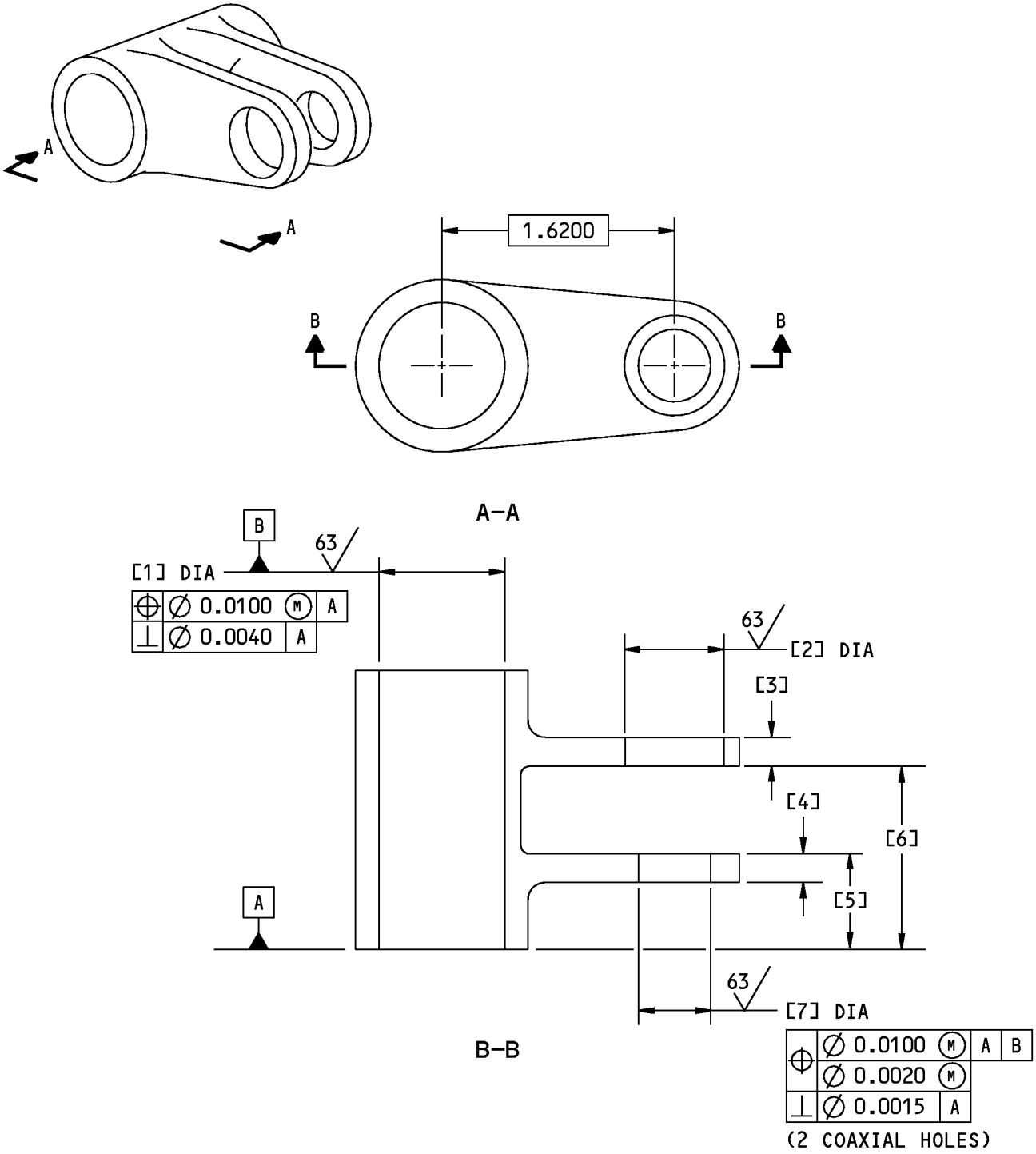
A. References

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

B. Procedure (REPAIR 18-2, Figure 601)

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

(1) Passivate (F-17.25).



146A6535-101 Outside Handle Crank Assembly Parts Replacement
Figure 601 (Sheet 1 of 2)

REFERENCE NUMBER	[1]	[2]	[3]	[4]	[5]	[6]	[7]
DESIGN DIMENSION	0.8785 0.8765	0.6882 0.6875	0.2100 0.1900	0.2100 0.1900	0.6750 0.6550	1.2850 1.2650	0.5006 0.5000
REPAIR LIMIT	—	—	—	—	—	—	—

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

146A6535-101 Outside Handle Crank Assembly Parts Replacement
Figure 601 (Sheet 2 of 2)

HANDLE LINK CRANK ASSEMBLY - REPAIR 19-1

146A6536–1

1. General

A. This procedure tells how to replace the parts of handle link crank assembly (385).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 2 for item numbers.

2. Fastener Replacement

A. Procedure (REPAIR 19-1, Figure 601)

(1) Remove the collar, bushing, washer and bolt from the lug.

(2) If you find defects on the lug surfaces, refer to REPAIR 19-2 for repair instructions.

(3) Install replacement bolt, washer, bushing and collar on the lug as shown.

3. 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

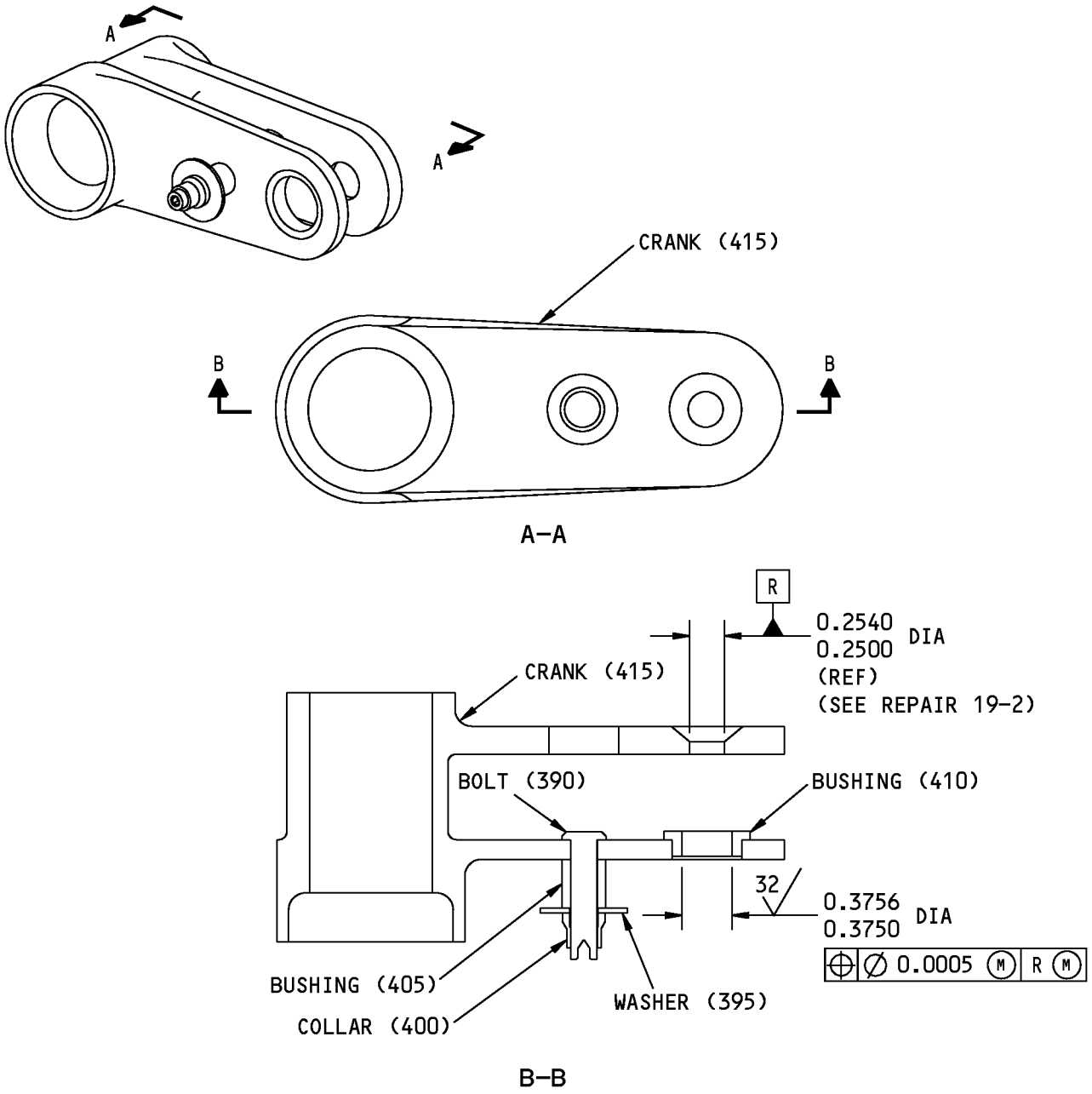
C. Procedure (REPAIR 19-1, Figure 601)

(1) Remove the old bushing.

(2) If you find defects on the hole surfaces, refer to REPAIR 19-2 for repair instructions.

(3) Install a replacement bushing by the shrink fit method (SOPM 20-50-03) with BMS 5-95 sealant, A00247 as the installation finish.

(4) Machine the bushing to design dimensions and finish.



125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

146A6536-1 Handle Link Crank Assembly Parts Replacement
Figure 601

CRANK - REPAIR 19-2

146A6536–101

1. General

A. This procedure tells how to repair and refinish crank (415).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 2 for item numbers.

D. General repair details:

(1) Material: 15-5PH CRES, 180-200 ksi

(2) Shot peen: not necessary

2. Crank Repair

A. Procedure (REPAIR 19-2, Figure 601)

(1) Repair is only replacement of the original refinish. Refer to REPAIR 19-2, Paragraph 3. for details.

(2) If you think there are defects on important surfaces, see REPAIR 19-2, Figure 601 for dimension details.

3. Crank Refinish

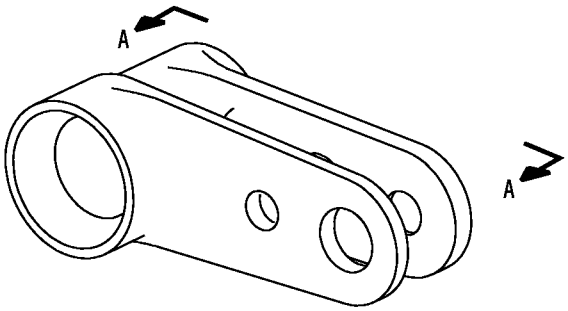
A. References

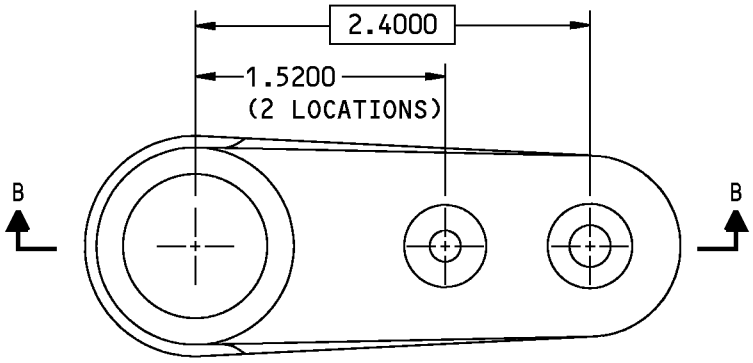
Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES

B. Procedure (REPAIR 19-2, Figure 601)

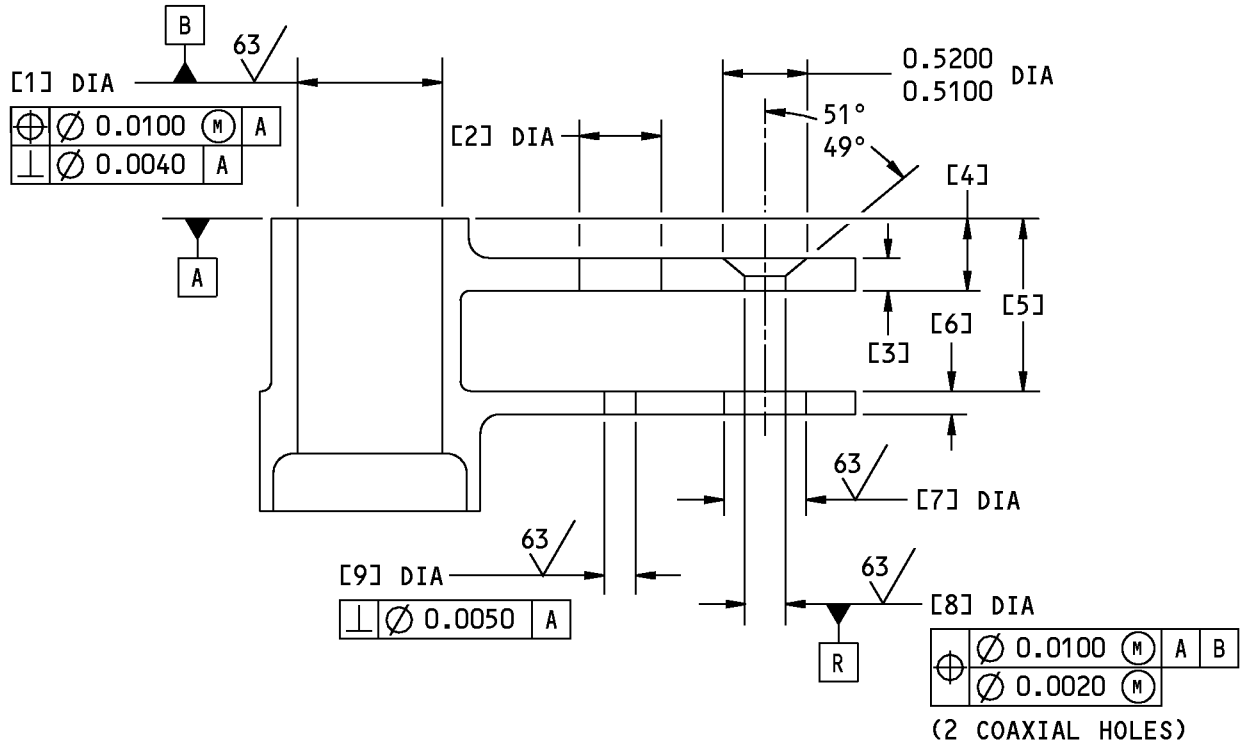
NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01.

(1) Passivate (F-17.25).





A–A



B–B

146A6536-101 Handle Link Crank Repair and Refinish
Figure 601 (Sheet 1 of 2)

REFERENCE NUMBER	[1]	[2]	[3]	[4]	[5]	[6]	[7]	[8]	[9]
DESIGN DIMENSION	0.8785 0.8765	0.5100 0.4900	0.2100 0.1900	0.4500 0.4300	1.0600 1.0400	0.1500 0.1300	0.5006 0.5000	0.2540 0.2500	0.1920 0.1890
REPAIR LIMIT	—	—	—	—	—	—	—	—	—

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

146A6536-101 Handle Link Crank Repair and Refinish
Figure 601 (Sheet 2 of 2)

OUTSIDE HANDLE CRANK SHAFT - REPAIR 20-1

146A6537–1

1. General

A. This procedure tells how to repair and refinish shaft (440).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 2 for item numbers.

D. General repair details:

(1) Material: 15-5PH CRES, 180-200 ksi

(2) Shot peen: not necessary

2. Shaft Repair

A. Procedure (REPAIR 20-1, Figure 601)

(1) Repair is only replacement of the original refinish. Refer to REPAIR 20-1, Paragraph 3. for details.

(2) If you think there are defects on important surfaces, see REPAIR 20-1, Figure 601 for dimension details.

3. Shaft Refinish

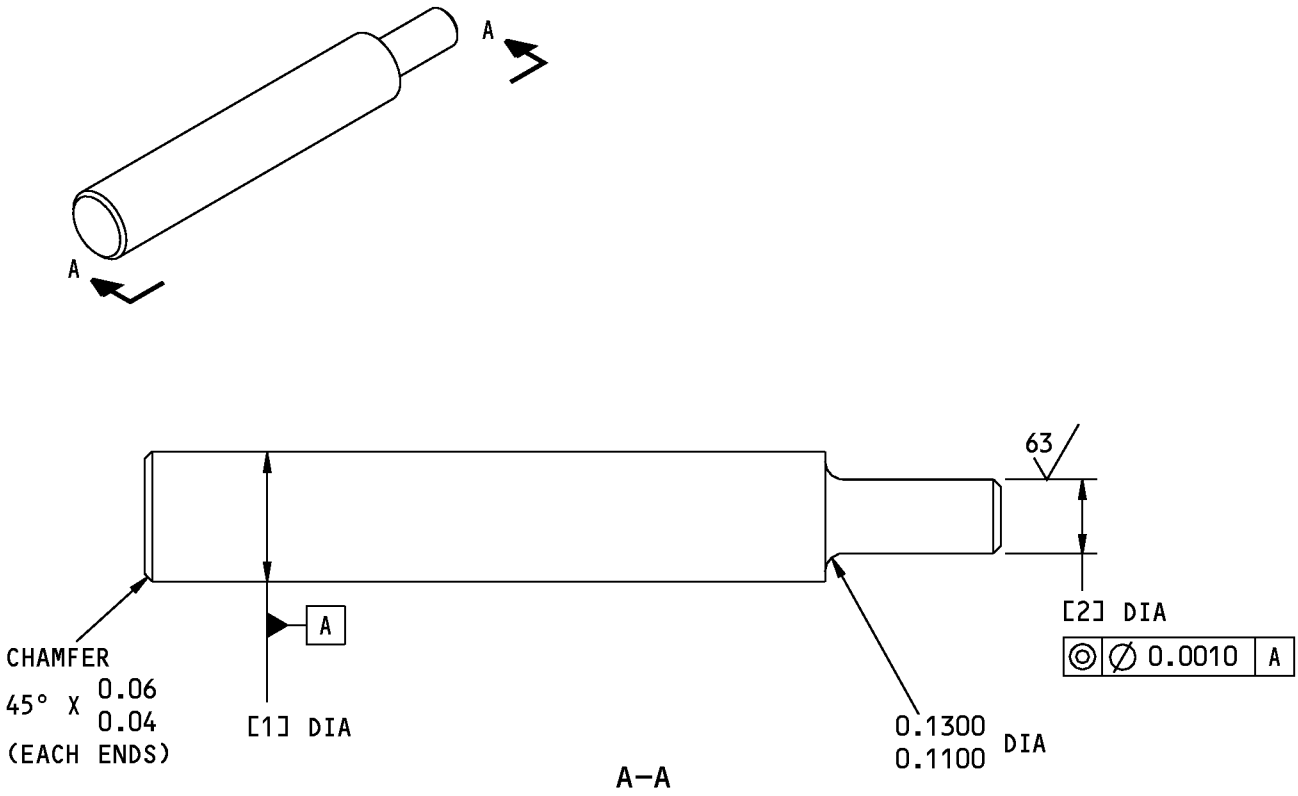
A. References

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

B. Procedure (REPAIR 20-1, Figure 601)

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

(1) Passivate (F-17.25).



REFERENCE NUMBER	[1]	[2]
DESIGN DIMENSION	0.8745 0.8735	0.4995 0.4985
REPAIR LIMIT	—	—

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

146A6537-1 Outside Handle Crank Shaft Repair and Refinish
Figure 601

BOEING®

COMPONENT MAINTENANCE MANUAL

VENT DOOR MECHANISM ASSEMBLY - REPAIR 21-1

146A6539–1, –3

1. General

A. This procedure tells how to replace the parts of vent door mechanism assembly (55).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices shown in the repair.

C. Refer to IPL Figure 2 for item numbers.

2. Parts 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 20-50-19	GENERAL SEALING

C. Procedure (REPAIR 21-1, Figure 601)

(1) Remove the sealant from the fasteners.

(2) Remove cotter pins (60, 110), nuts (80, 130), bolts (65, 115), washers (70, 75, 120, 125), bushings (85, 135) and push rod assemblies (90, 140).

(3) Remove bearing housing assemblies (210, 215).

(4) Remove door fasteners and crank assembly (235). Put the door fasteners back on the lugs of the door.

(5) Pull out shaft (255) and remove springs (195, 200), washers (175, 180, 185, 190) and sleeve (205).

(6) If you find defects on the push rods (90, 140), springs (195, 200), bearing housings (210, 215), cranks (235), shaft (255), or vent door (260), refer to REPAIR 16-1, REPAIR 21-1, REPAIR 22-1, REPAIR 23-1, REPAIR 24-1 and REPAIR 25-1 for repair instructions.

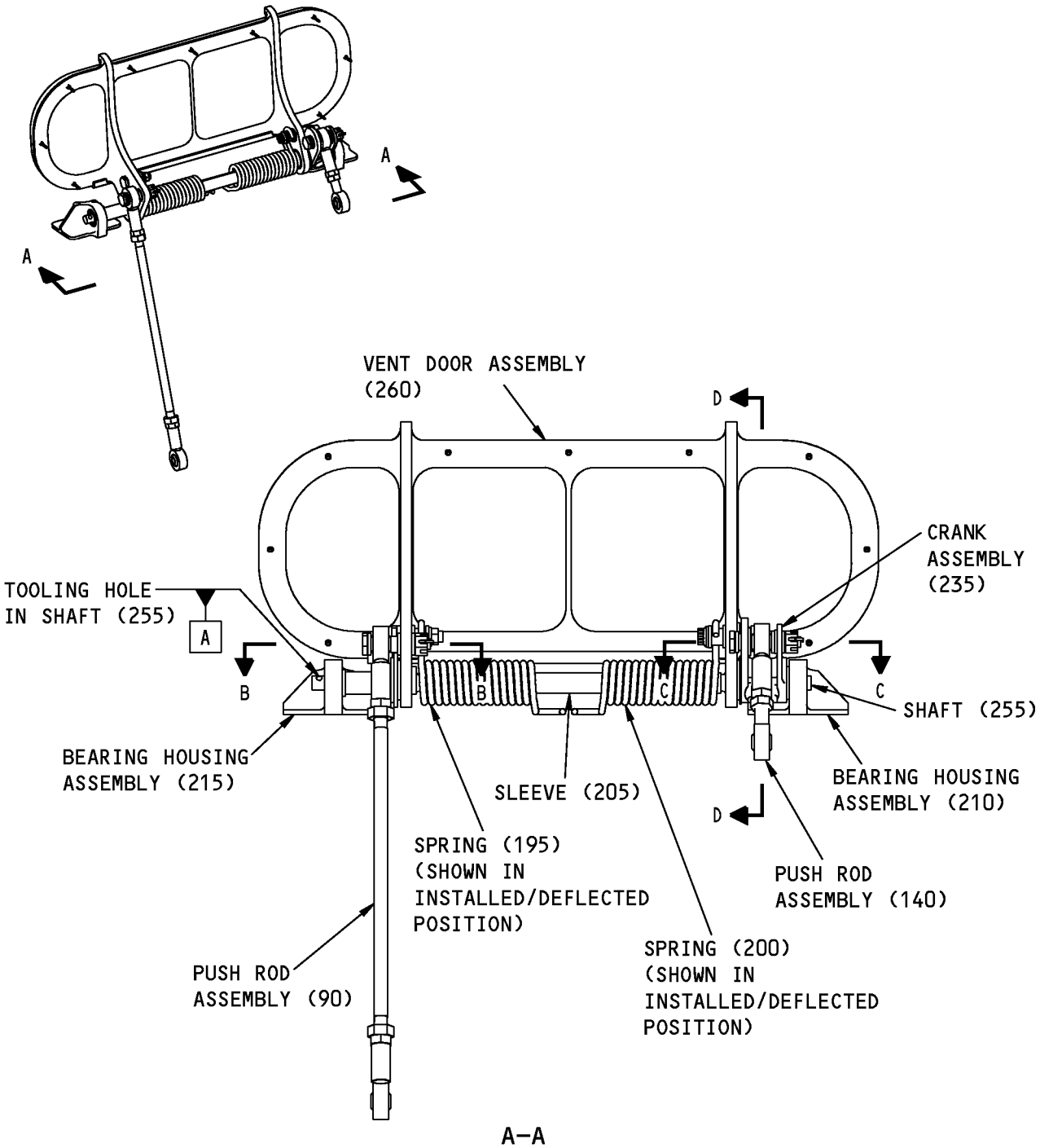
(7) Install replacement springs (195, 200), and sleeve (205) with washers (175, 180, 185, 190) on the shaft.

(8) Install crank assembly (235) on the shaft with the door fasteners.

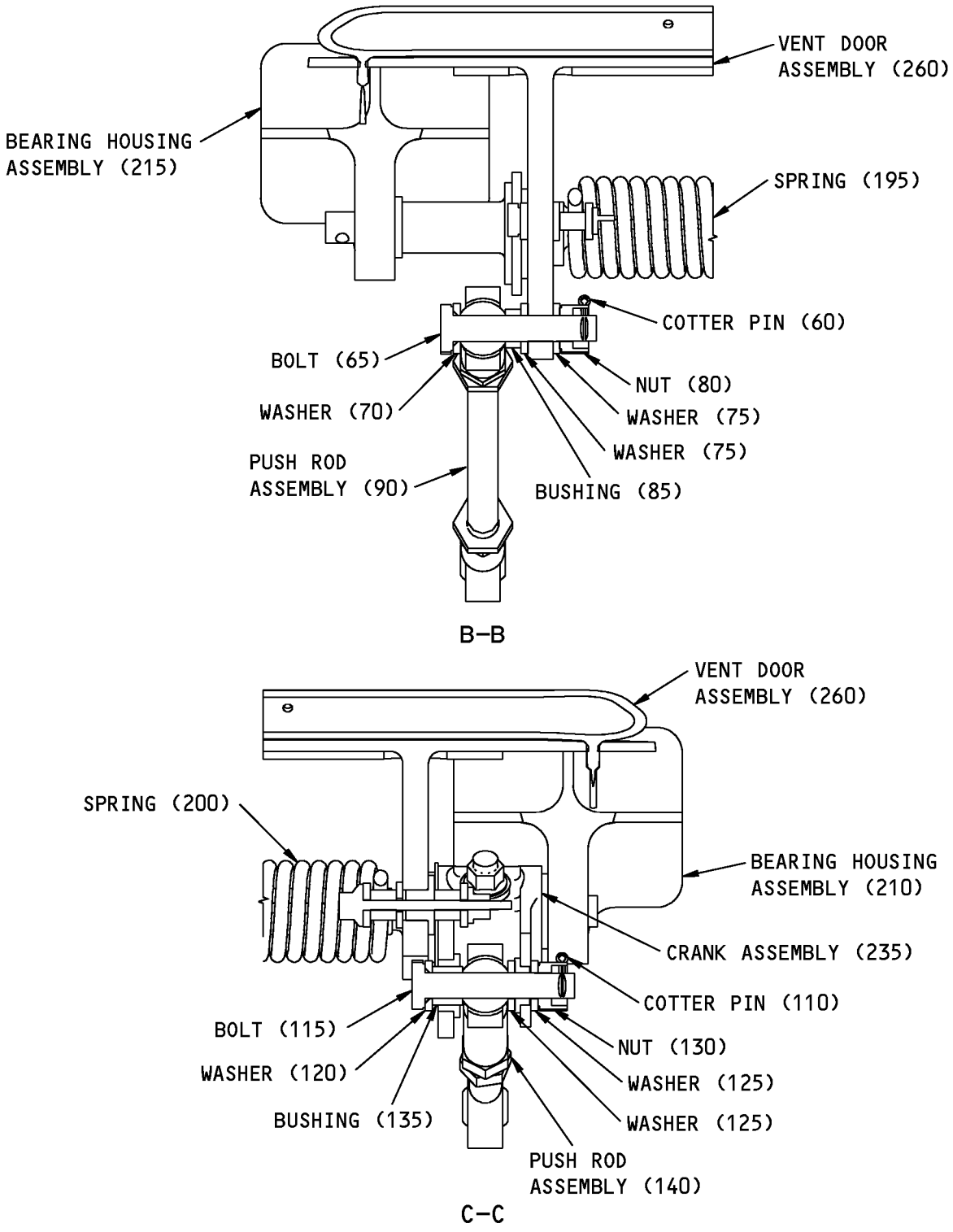
(9) Install bearing housing assemblies (210, 215) on the ends of the shaft.

(10) Install push rod assemblies (90, 140) with bolts (65, 115), washers (70, 75, 120, 125), bushings (85, 135) and nuts (80, 130). Install the fasteners with wet BMS 5-95 sealant, A00247 on mating surfaces (SOPM 20-50-19, Method 2). If you replaced the crank or shaft with new ones, drill holes as shown for these fasteners, because the new cranks and shaft come with only pilot holes. But before you drill holes in a new shaft, be sure the shaft lobes are in the positions shown.

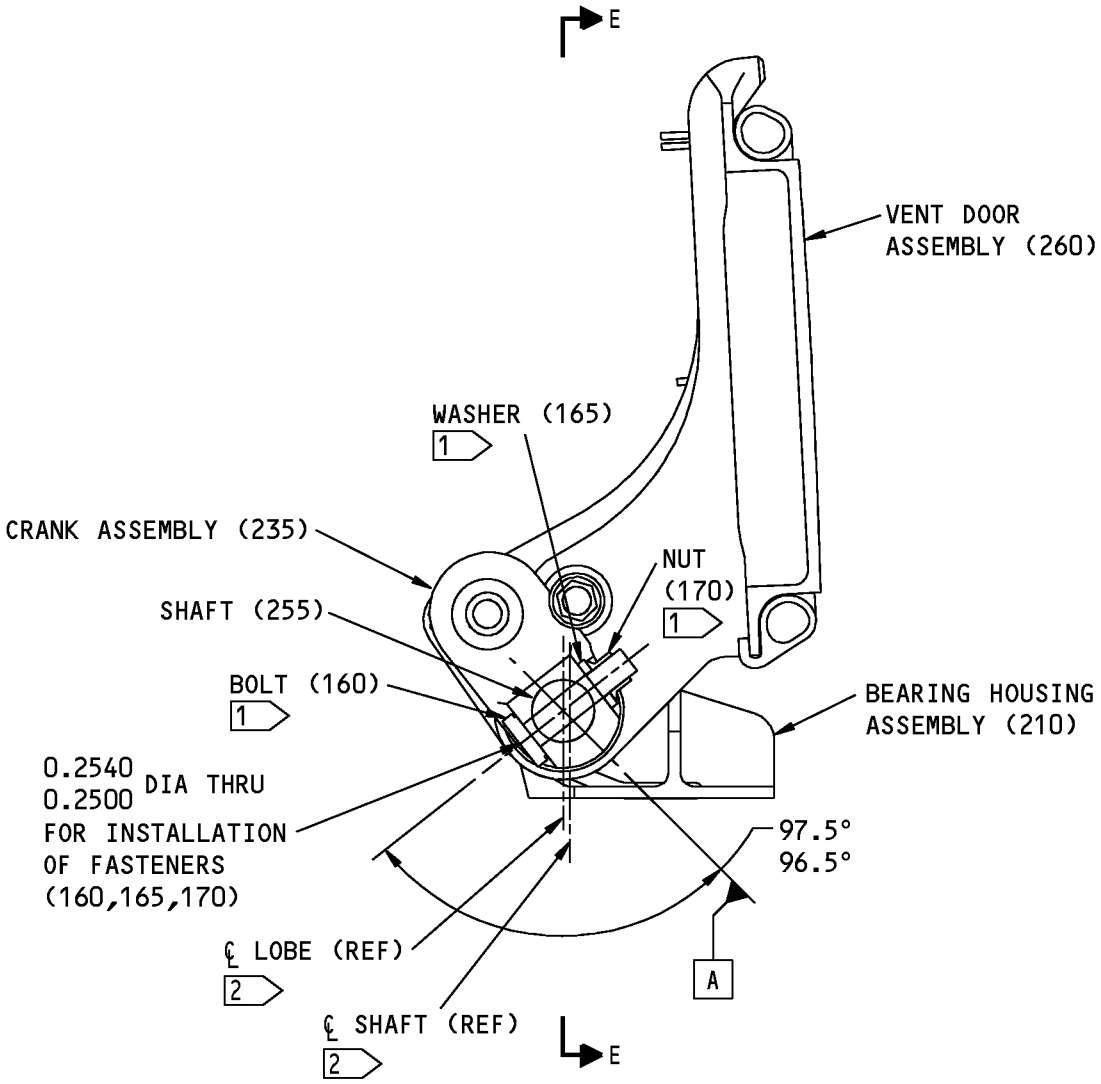
(11) With a brush, apply BMS 5-95 sealant, A00247 to the threads and the mating components.



146A6539-1,-3 Vent Door Mechanism Assembly Parts Replacement
Figure 601 (Sheet 1 of 4)

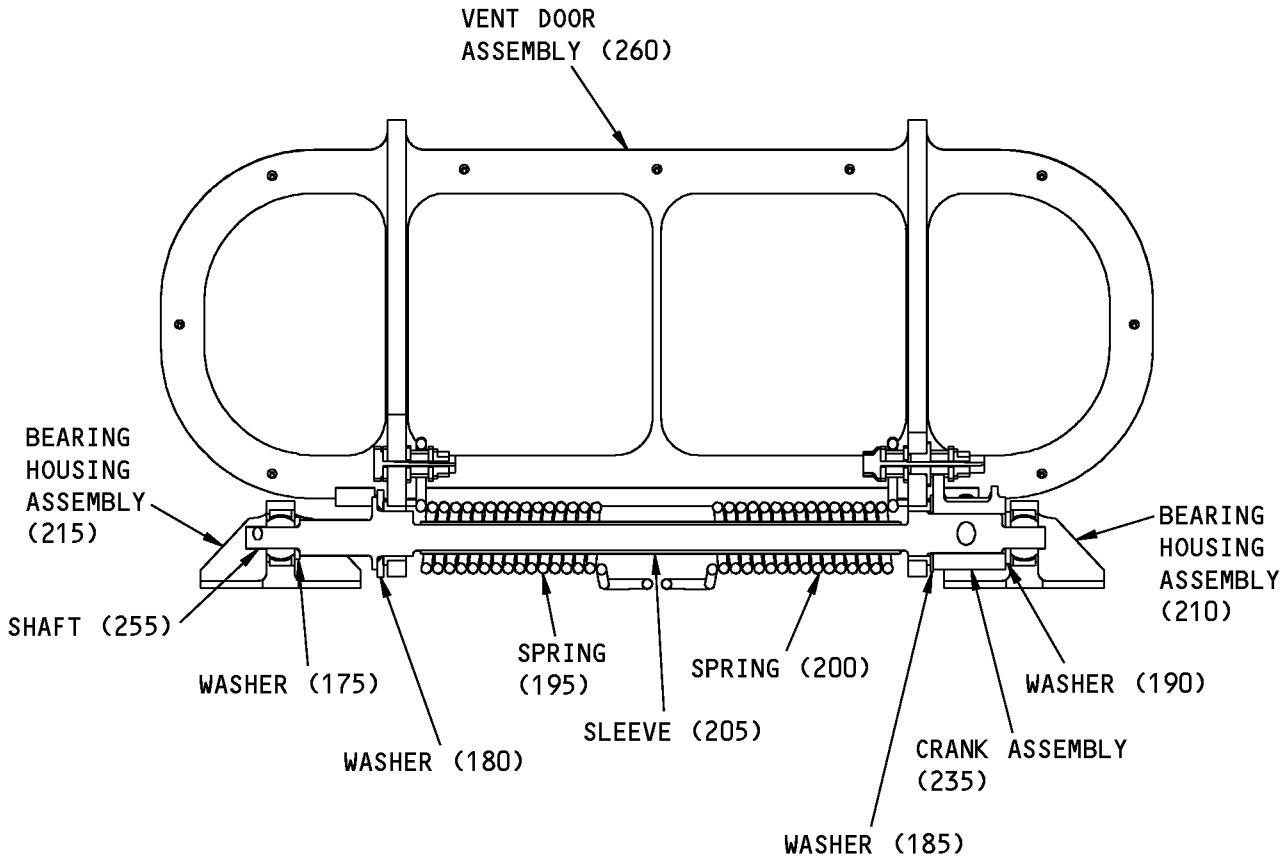


146A6539-1,-3 Vent Door Mechanism Assembly Parts Replacement
Figure 601 (Sheet 2 of 4)



D–D
(PUSH RODS NOT SHOWN FOR CLARITY)

146A6539-1,-3 Vent Door Mechanism Assembly Parts Replacement
Figure 601 (Sheet 3 of 4)



E–E

1 INSTALL WITH WET BMS 5-95 SEALANT (SOPM 20-50-19 METHOD 2) THEN BRUSH SEALANT ON THREADED END OF FASTENER AND MATING COMPONENTS

2 BE SURE THE SHAFT LOBES ARE IN THIS POSITION BEFORE YOU DRILL HOLES FOR FASTENERS

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

146A6539-1,-3 Vent Door Mechanism Assembly Parts Replacement
Figure 601 (Sheet 4 of 4)

VENT DOOR ASSEMBLY - REPAIR 22-1

146A6540–1

1. General

A. This procedure tells how to replace the parts of vent door assembly (260).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 2 for item numbers.

2. Fastener Replacement

A. References

Reference	Title
SOPM 20-50-19	GENERAL SEALING

B. Procedure (REPAIR 22-1, Figure 601)

(1) Remove the nuts, bushings, washers and bolts from the lugs.

(2) If you find defects on the lug surfaces, refer to REPAIR 22-2 for repair instructions.

(3) Install replacement bolts, washers, bushings and nuts on the lug with BMS 5-95 sealant (SOPM 20-50-19) as shown.

(4) With a brush, apply BMS 5-45, Class A sealant (SOPM 20-50-19) to the fasteners as shown.

3. 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

C. Procedure (REPAIR 22-1, Figure 601)

(1) Remove the old bushings.

(2) If you find defects on the hole surfaces, refer to REPAIR 22-2 for repair instructions.

(3) Install replacement bushings by the shrink fit method (SOPM 20-50-03) with BMS 5-95 sealant, A00247 as the installation finish.

(4) Machine the indicated bushings to design dimensions and finish.

4. Seal Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00027	Adhesive - Silicone Rubber, 1 Part, RTV	BAC5010, Type 60
A00281	Adhesive - Dow Corning 3145 RTV	MIL-A-46146 (BAC5010, Type 79)

B. References

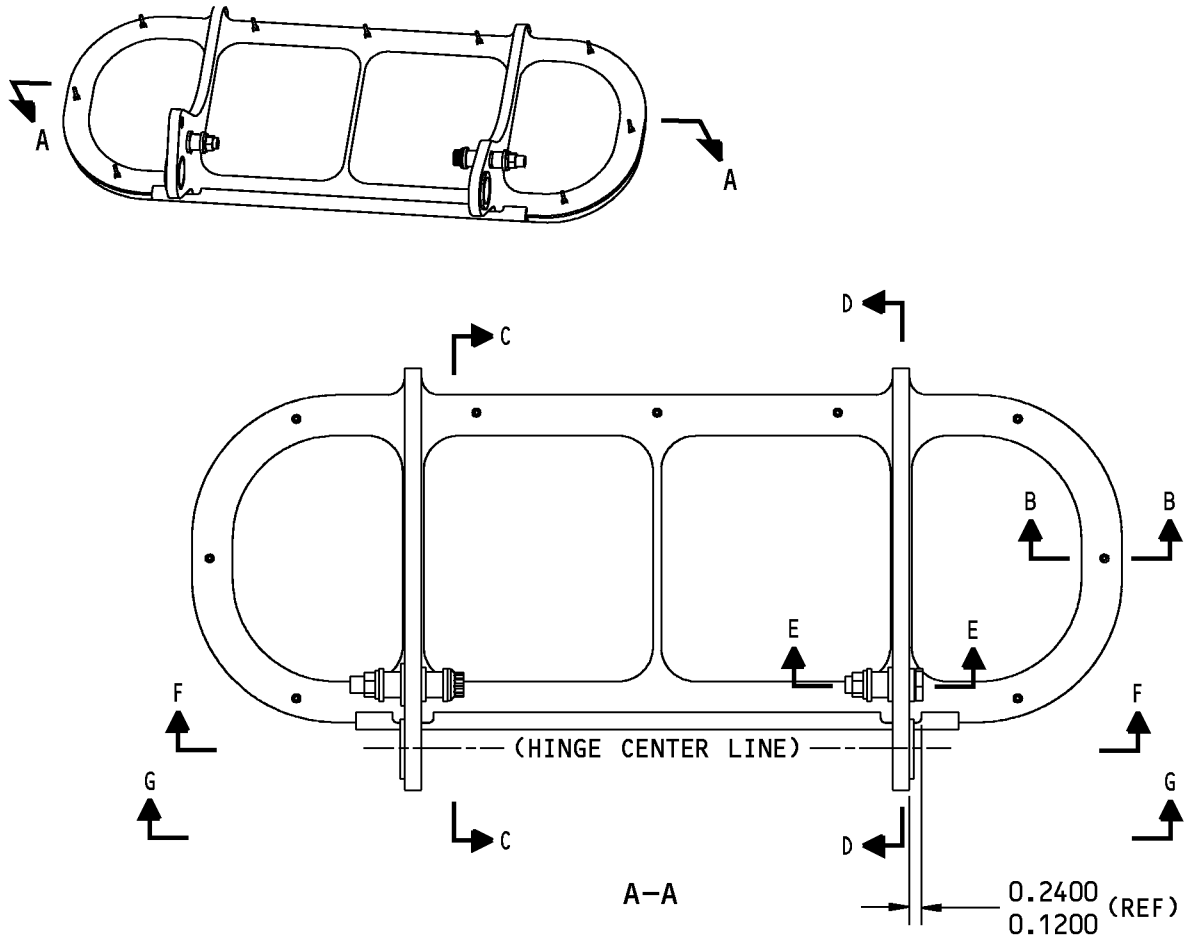
Reference	Title
SOPM 20-50-12	APPLICATION OF ADHESIVES

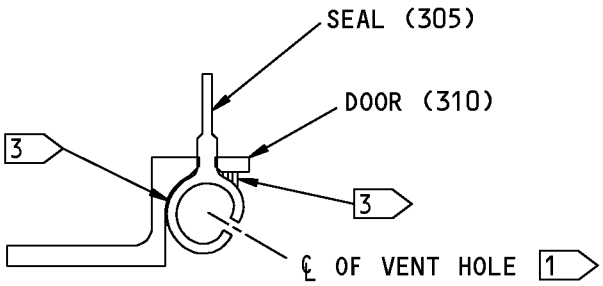
C. Procedure (REPAIR 22-1, Figure 601)

(1) Remove the old seal (305).

(2) If you find defects on the door surfaces, refer to REPAIR 22-2 for repair instructions.

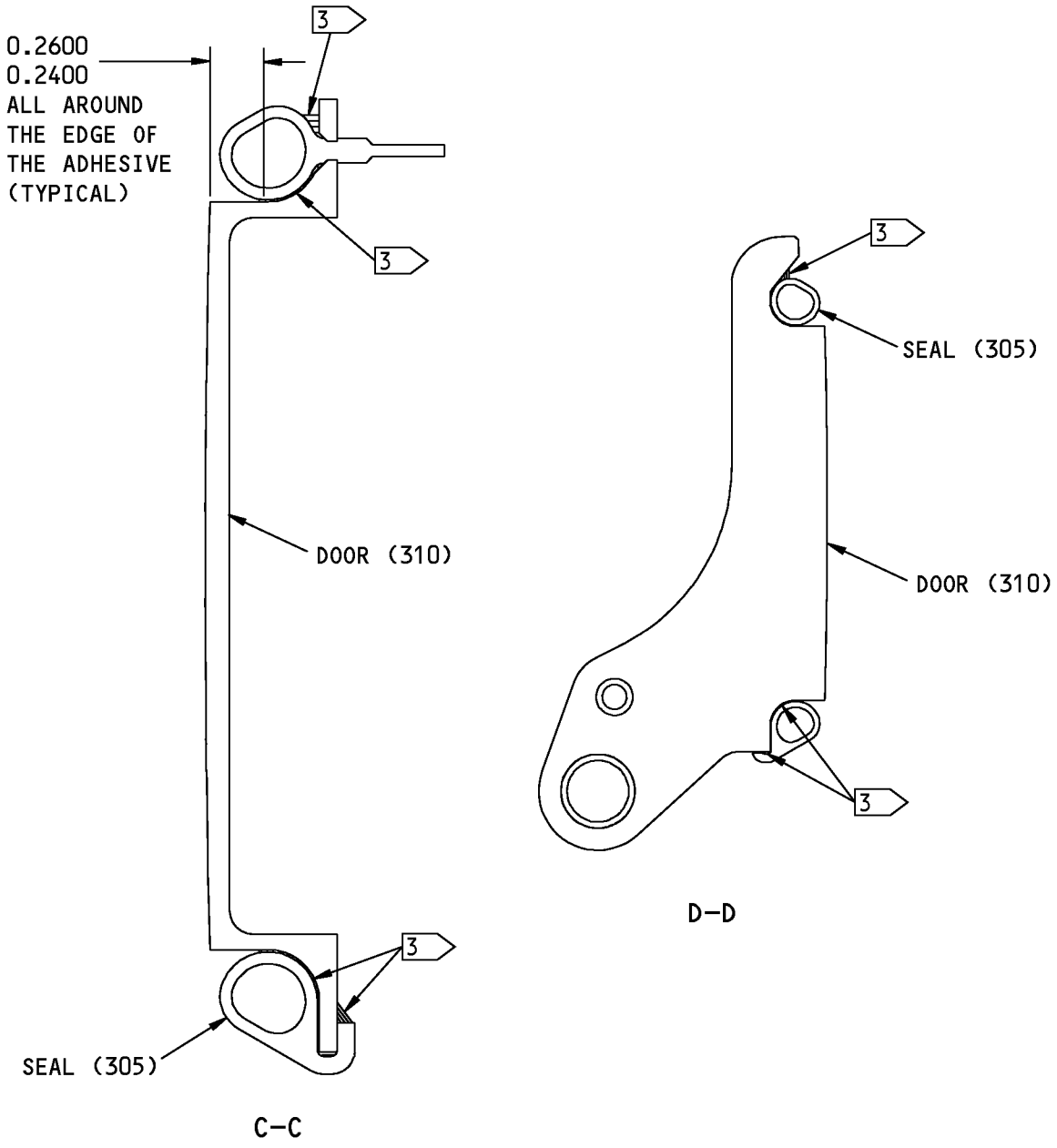
(3) Install a replacement seal as shown with Type 60 adhesive, A00027 or Type 79 Dow Corning 3145 RTV adhesive, A00281 (SOPM 20-50-12). Be careful to keep the vent holes open.



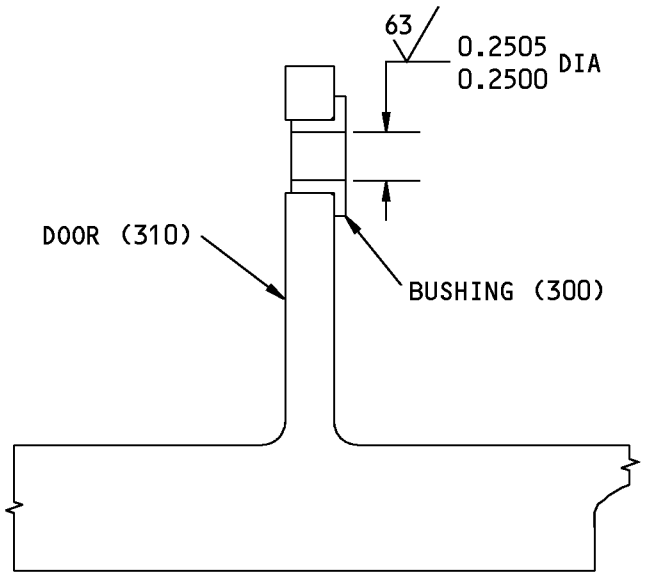


B–B

146A6540-1,-3 Vent Door Assembly Parts Replacement
Figure 601 (Sheet 1 of 4)



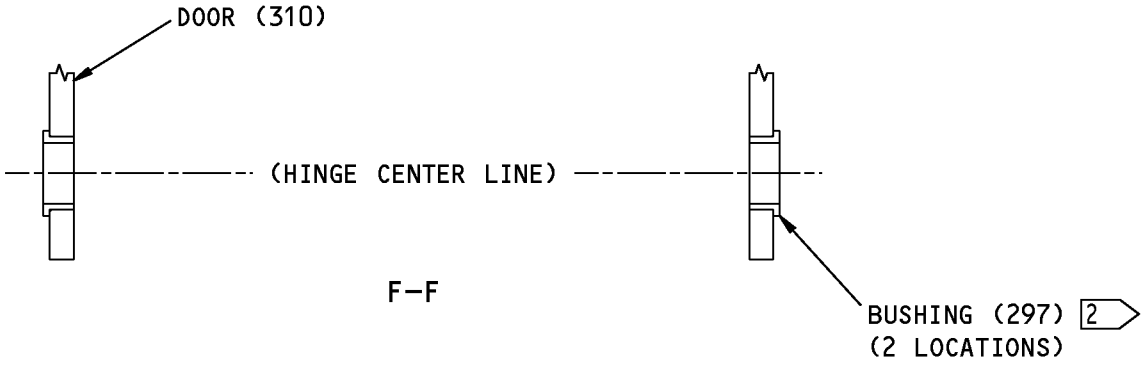
146A6540-1,-3 Vent Door Assembly Parts Replacement
Figure 601 (Sheet 2 of 4)



E–E

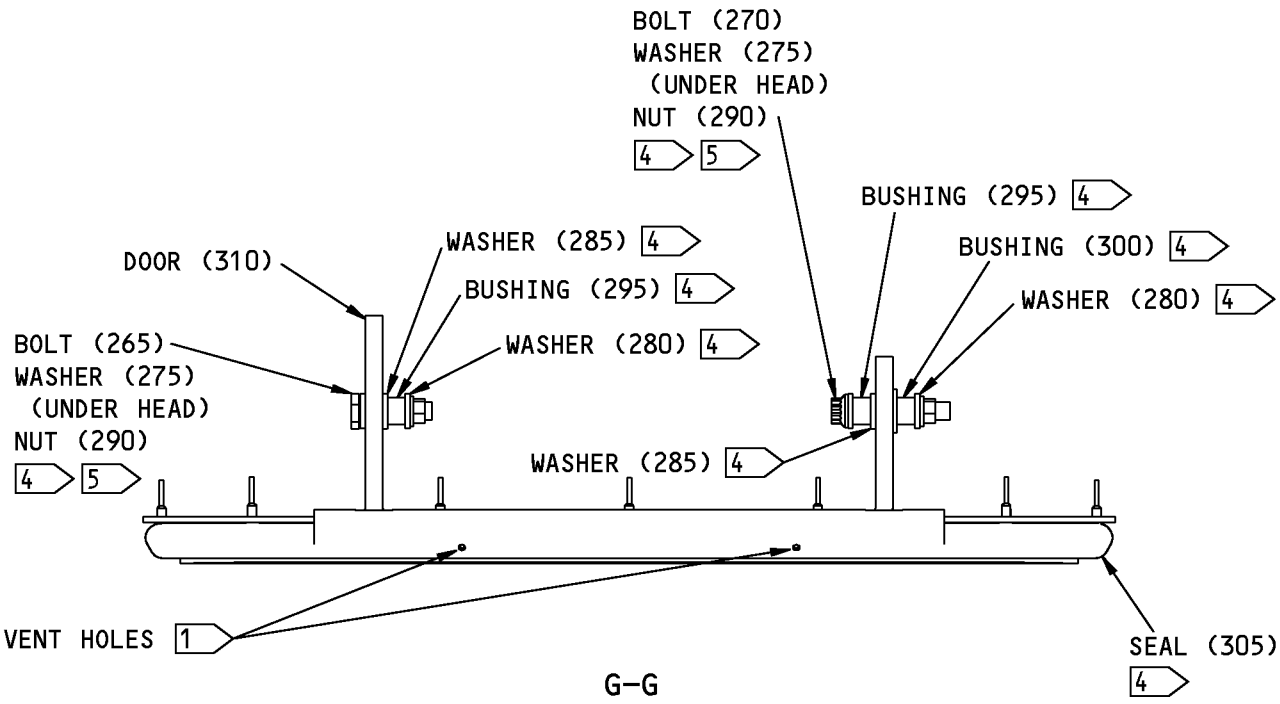
FASTENERS NOT SHOWN FOR CLARITY

(SEE VIEW G–G FOR FASTENERS)



F–F

146A6540-1,-3 Vent Door Assembly Parts Replacement
Figure 601 (Sheet 3 of 4)



G–G

BUSHINGS (297) NOT SHOWN FOR CLARITY

(SEE VIEW E–E FOR BUSHINGS)

1 MAKE SURE VENT HOLES ARE NOT CLOGGED WITH ADHESIVE

2 ADJUSTMENT OF BUSHING BORES NOT NECESSARY AFTER INSTALLATION

3 PUT SEAL TABS INTO DOOR AND BOND SEAL WITH TYPE 60 OR 79 ADHESIVE (SOPM 20–50–12)

4 INSTALL BUSHINGS AND FASTENERS WITH BMS 5–95 SEALANT (SOPM 20–50–19 METHOD 2)

5 BRUSH SEAL HEAD SIDE OF FASTENER AND MATING COMPONENTS WITH BMS 5–45 CLASS A SEALANT (SOPM 20–50–19)

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

146A6540-1,-3 Vent Door Assembly Parts Replacement
Figure 601 (Sheet 4 of 4)

BOEING®

COMPONENT MAINTENANCE MANUAL

VENT DOOR - REPAIR 22-2

146A6540–101

1. General

A. This procedure tells how to repair and refinish vent door (310).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 2 for item numbers.

D. General repair details:

(1) Material: Al alloy

(2) Shot peen: not necessary

2. Housing Repair

A. Procedure (REPAIR 22-2, Figure 601)

(1) Repair is only replacement of the original refinish. Refer to REPAIR 22-2, Paragraph 3. for details.

(2) If you think there are defects on important surfaces, see REPAIR 22-2, Figure 601 for dimension details.

3. Housing Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
C00033	Coating - Exterior Protective Enamel, Flexibility Use	BMS10-60, Type II
C00175	Primer - Urethane Compatible, Corrosion Resistant (Less Than 1% Aromatic Amines)	BMS10-79, Type III

B. References

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

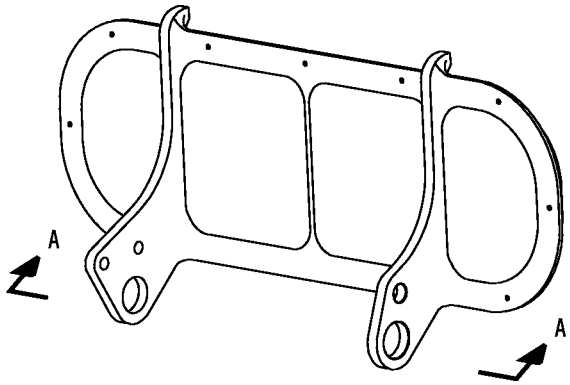
C. Procedure (REPAIR 22-2, Figure 601)

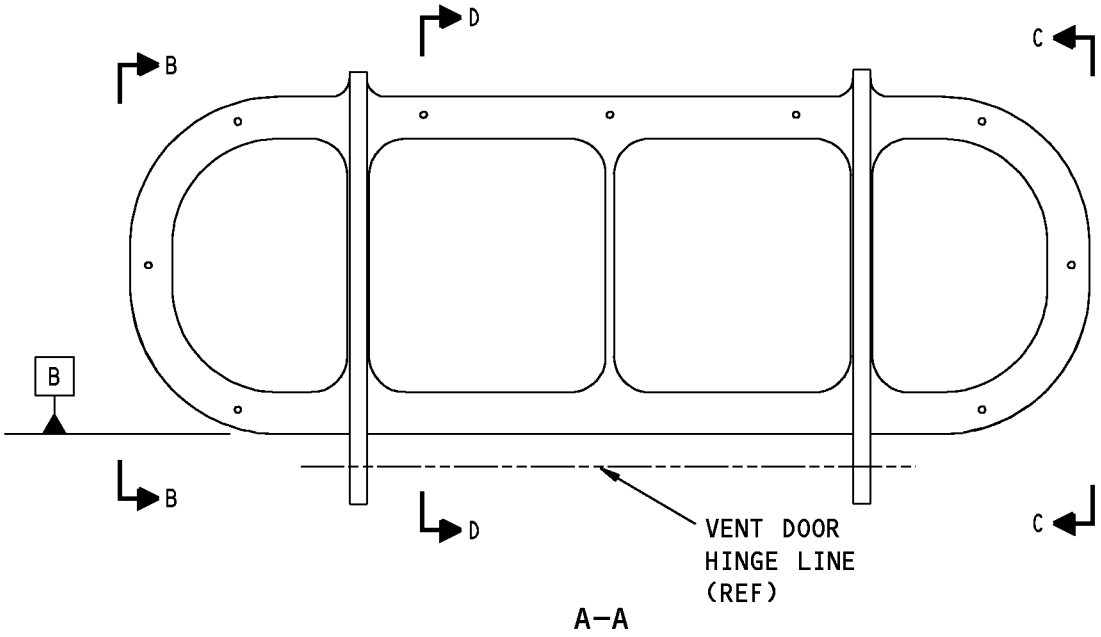
NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01.

(1) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31) all over.

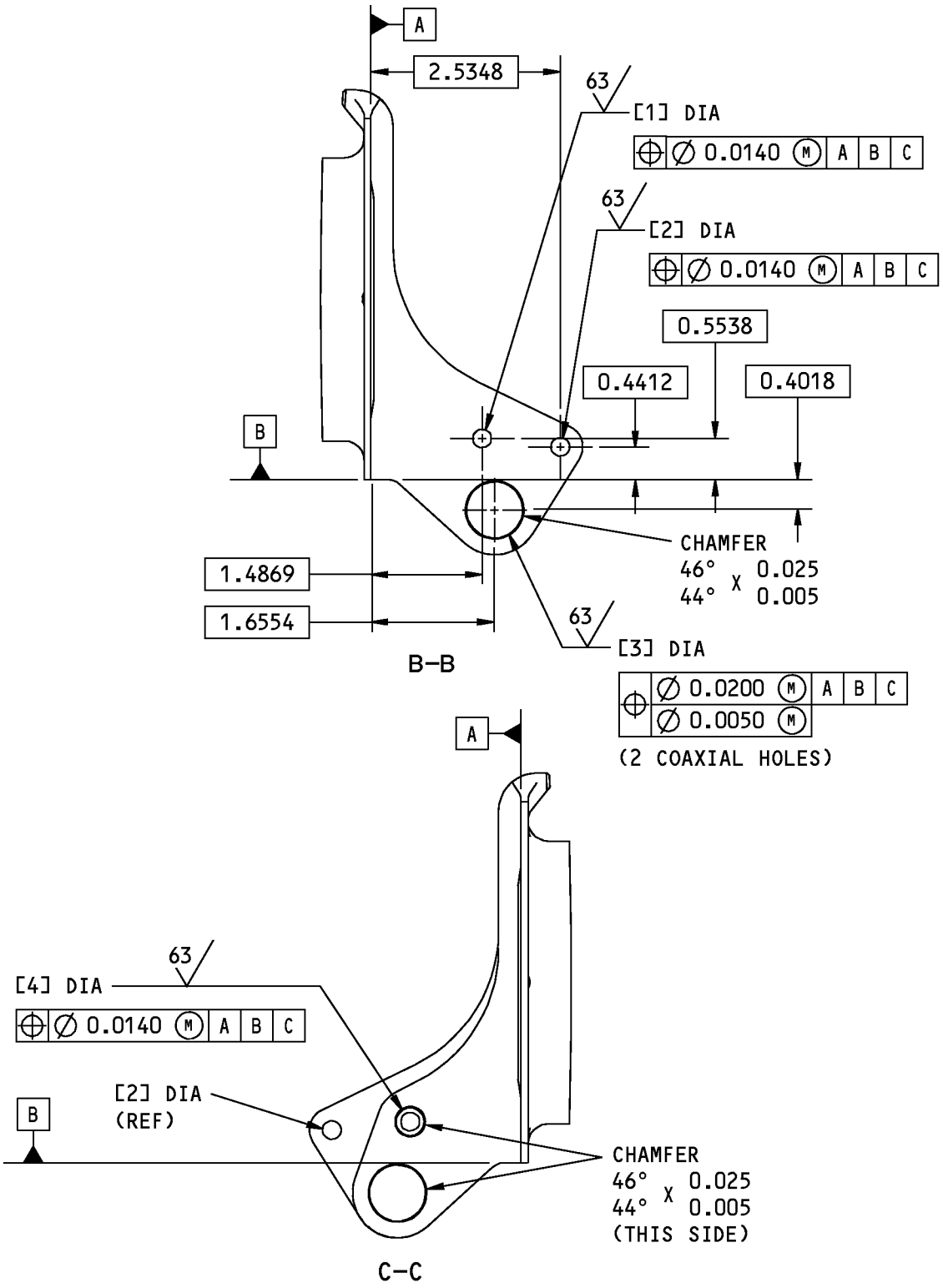
(2) Apply BMS 10-79, Type 3 primer, C00175 (F-19.66) but not in the holes.

(3) Apply BMS 10-60, Type 2 coating, C00033 (F-19.39-707) to the surfaces shown.

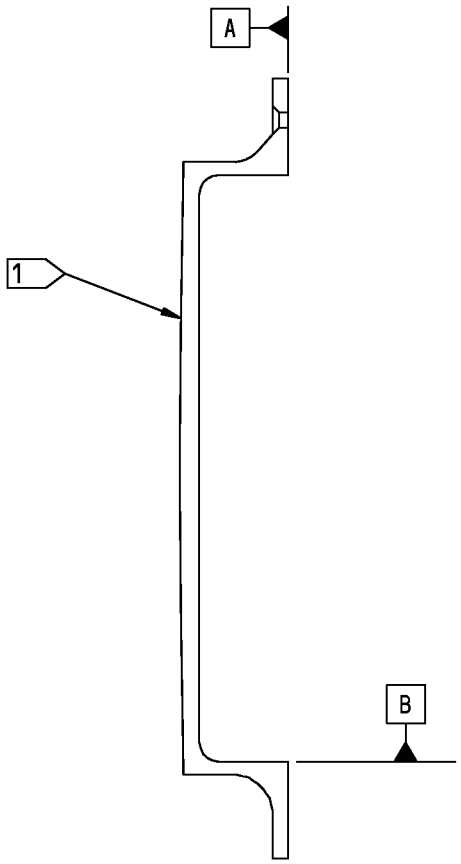




146A6540-101 Vent Door Repair and Refinish
Figure 601 (Sheet 1 of 3)



146A6540-101 Vent Door Repair and Refinish
Figure 601 (Sheet 2 of 3)



D–D

REFERENCE NUMBER	[1]	[2]	[3]	[4]
DESIGN DIMENSION	0.2540 0.2500	0.2540 0.2500	0.7509 0.7500	0.3756 0.3750
REPAIR LIMIT	—	—	—	—

1 THIS IS AN EXTERIOR AERODYNAMIC SURFACE. APPLY BMS 10-60, TYPE 2 ENAMEL (F-19.39-707) TO THIS SURFACE. APPROXIMATELY ONE INCH OVERSPRAY IS PERMITTED.

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

146A6540-101 Vent Door Repair and Refinish
Figure 601 (Sheet 3 of 3)

SHAFT - REPAIR 23-1

146A6545–1, –3

1. General

A. This procedure tells how to repair and refinish shaft (255, IPL Figure 2; 522, IPL Figure 3).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 2 or IPL Figure 3 for item numbers.

D. General repair details:

(1) Material: 15-5PH CRES, 180-200 ksi

(2) Shot peen: not necessary

2. Shaft Repair

A. Procedure (REPAIR 23-1, Figure 601 or REPAIR 23-1, Figure 602)

(1) Repair is only replacement of the original finish. Refer to REPAIR 23-1, Paragraph 3. below for details.

(2) If you think there are defects on important surfaces, see REPAIR 23-1, Figure 601 or REPAIR 23-1, Figure 602 for dimension details.

3. Shaft Refinish

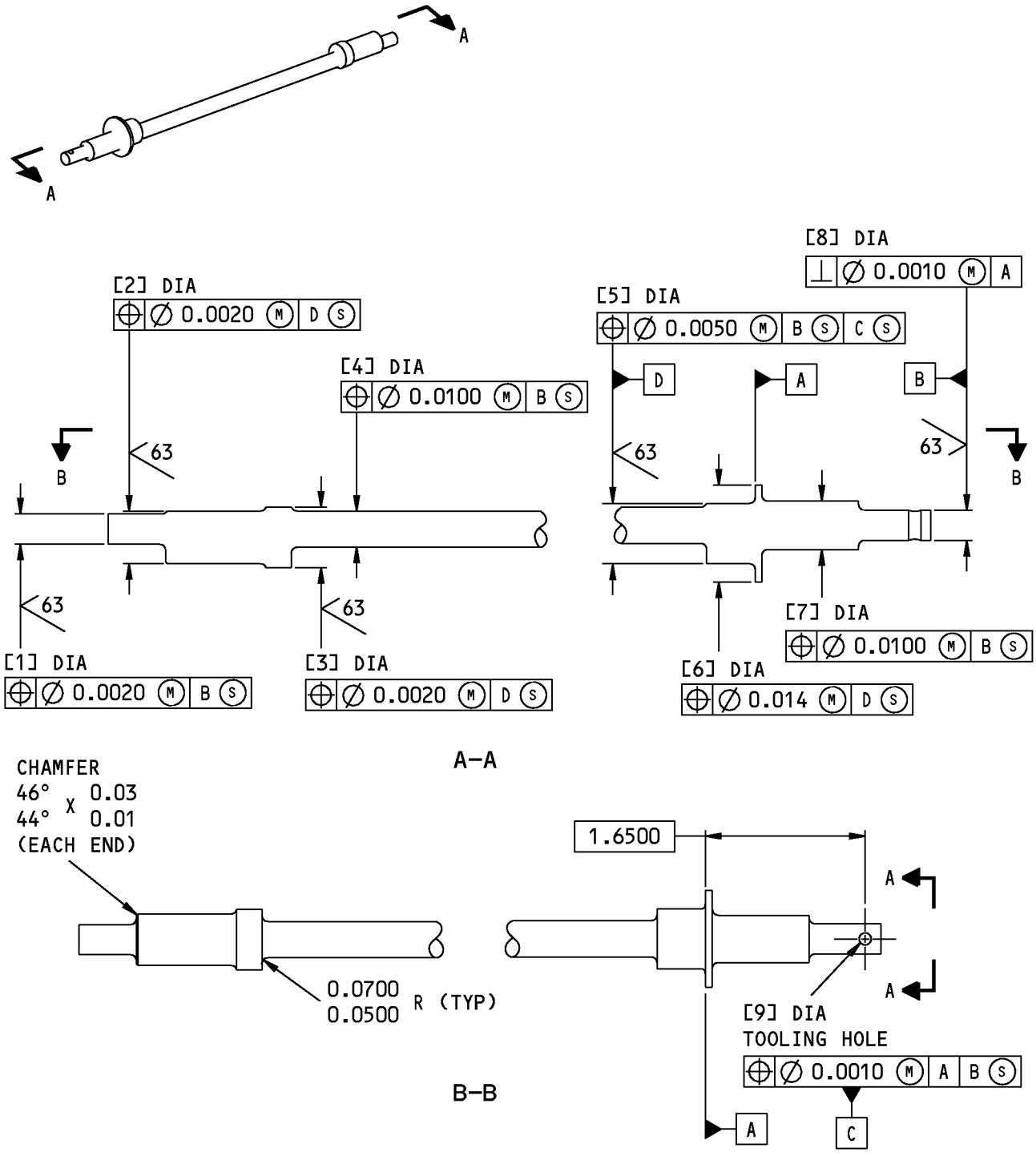
A. References

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

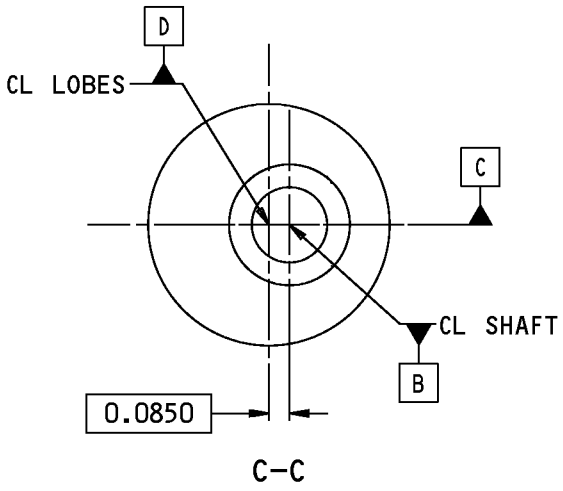
B. Procedure

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.

(1) Passivate (F-17.25).



146A6545-1 Shaft Repair and Refinish
Figure 601



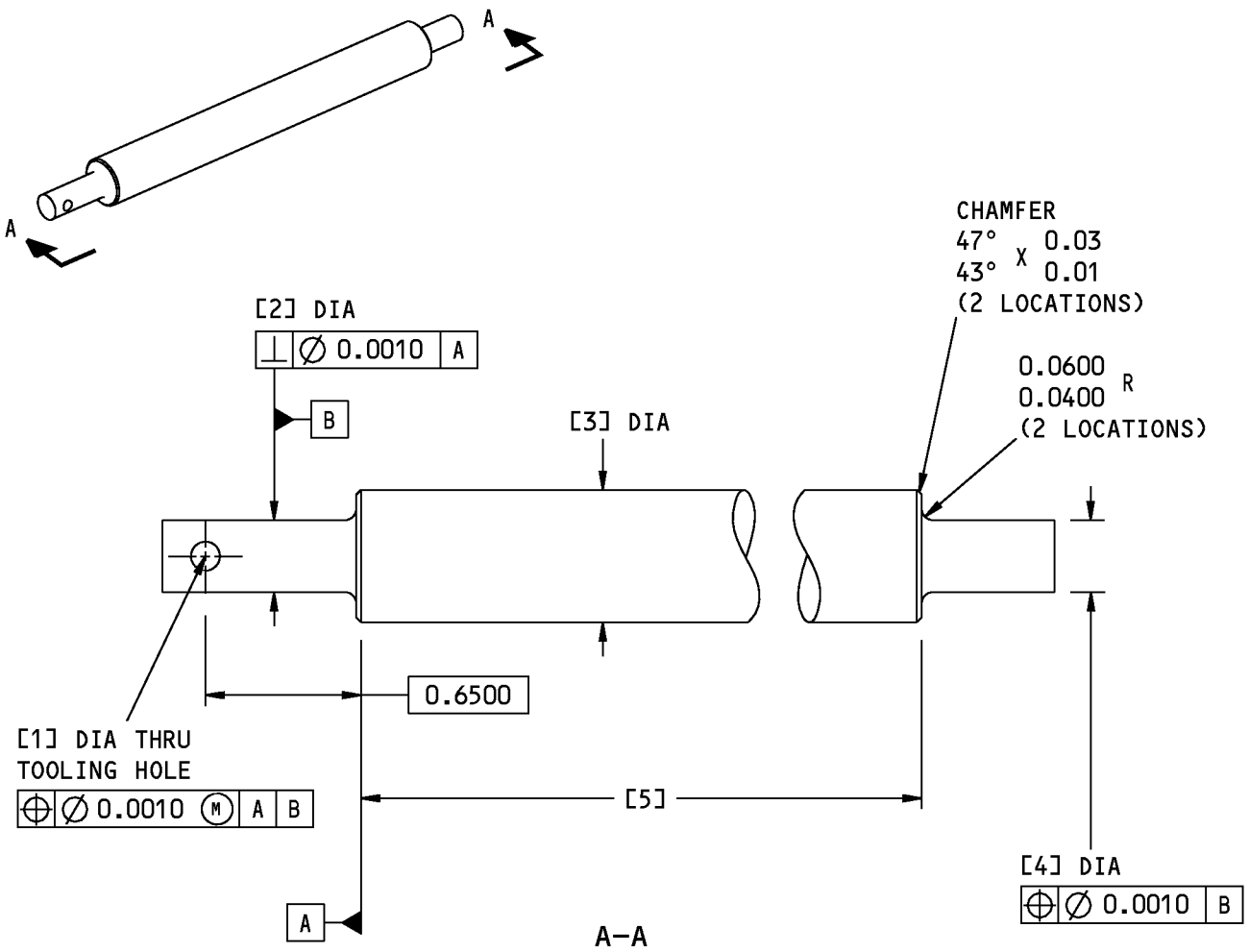
REFERENCE NUMBER	[1]	[2]	[3]	[4]	[5]	[6]	[7]	[8]	[9]
DESIGN DIMENSION	0.3120 0.3115	0.5455 0.5450	0.6245 0.6235	0.3800 0.3650	0.6245 0.6235	1.0300 0.9700	0.5050 0.4900	0.3120 0.3115	0.1260 0.1250
REPAIR LIMIT	—	—	—	—	—	—	—	—	—

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

146A6545-1 Shaft Repair and Refinish
Figure 602



REFERENCE NUMBER	[1]	[2]	[3]	[4]	[5]
DESIGN DIMENSION	0.1260 0.1250	0.3130 0.3120	0.5755 0.5745	0.3130 0.3120	4.7900 4.7800
REPAIR LIMIT	—	—	—	—	—

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

146A6545-3 Shaft Repair and Refinish
Figure 603

BEARING HOUSING ASSEMBLY - REPAIR 24-1

146A6546–1, –2

1. General

A. This procedure tells how to replace the parts of bearing housing assemblies (210, 215).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 2 for item numbers.

2. Bearing Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

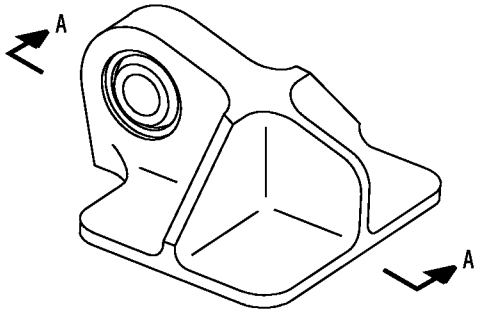
Reference	Title
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT

C. Procedure (REPAIR 24-1, Figure 601)

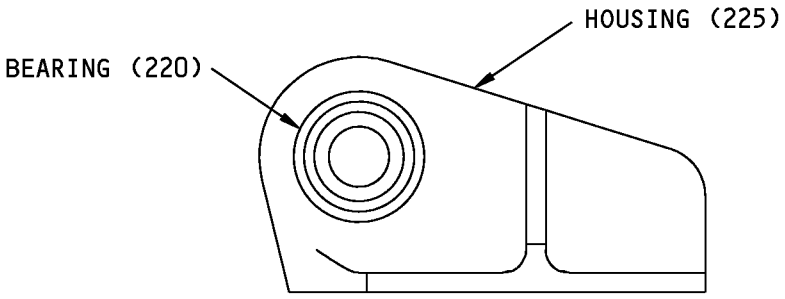
(1) Remove the old bearing.

(2) If you find defects on the hole surfaces, refer to REPAIR 24-2 for repair instructions.

(3) Install a replacement bearing by the press fit method (SOPM 20-50-03) with BMS 5-95 sealant, A00247 as the installation finish. Swaging is not necessary.



146A6546-1 SHOWN
146A6546-2 OPPOSITE



A-A

ITEM NUMBERS REFER TO IPL FIG. 2

146A6546-1,-2 Bearing Housing Assembly Parts Replacement
Figure 601

HOUSING - REPAIR 24-2

146A6546–101, –102

1. General

A. This procedure tells how to repair and refinish housing (225, 230).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 2 for item numbers.

D. General repair details:

(1) Material: Al alloy

(2) Shot peen: not necessary

2. Housing Repair

A. Procedure (REPAIR 24-2, Figure 601)

(1) Repair is only replacement of the original refinish. Refer to REPAIR 24-2, Paragraph 3. for details.

(2) If you think there are defects on important surfaces, see REPAIR 24-2, Figure 601 for dimension details.

3. 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

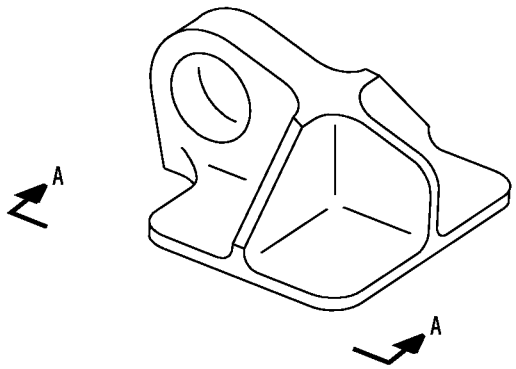
Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES

C. Procedure (REPAIR 24-2, Figure 601)

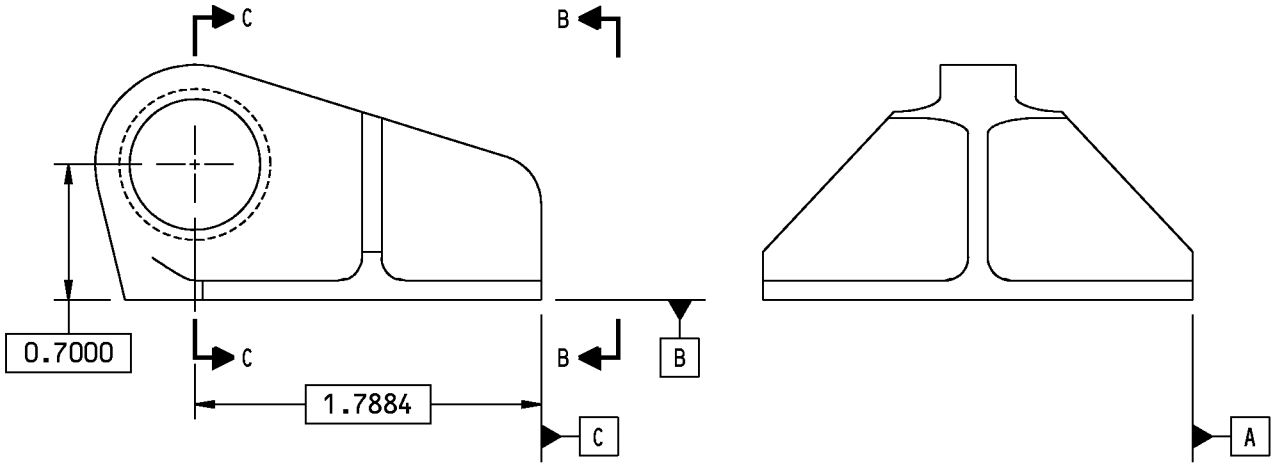
NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01.

(1) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31) all over.

(2) Apply BMS 10-11, Type 1 primer, C00259 (F-20.03) but not in the hole for the bearing.

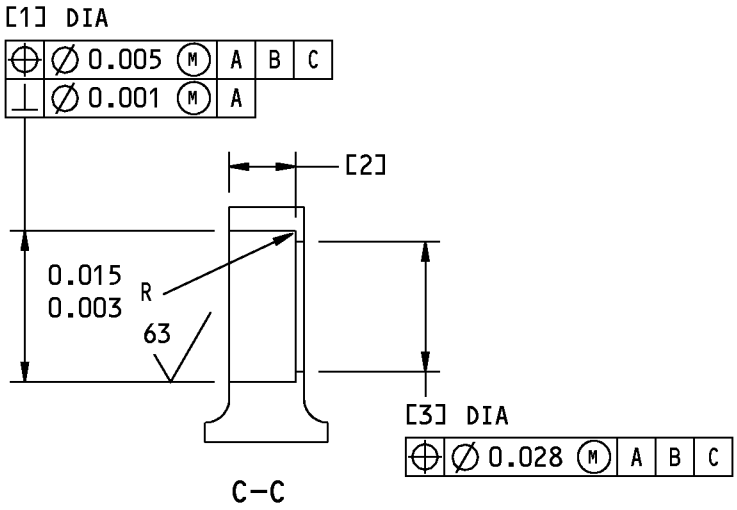


146A6546-101 SHOWN
146A6546-102 OPPOSITE



A–A B–B

146A6546-101,-102 Bearing Housing Repair and Refinish
Figure 601 (Sheet 1 of 2)



REFERENCE NUMBER	[1]	[2]	[3]
DESIGN DIMENSION	0.7823 0.7813	0.350 0.345	0.700 0.675
REPAIR LIMIT	—	—	—

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

146A6546-101,-102 Bearing Housing Repair and Refinish
Figure 601 (Sheet 2 of 2)

VENT DOOR CRANK ASSEMBLY - REPAIR 25-1

146A6547–1

1. General

A. This procedure tells how to replace the parts of vent door crank assembly (235).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 2 for item numbers.

2. Bushing Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

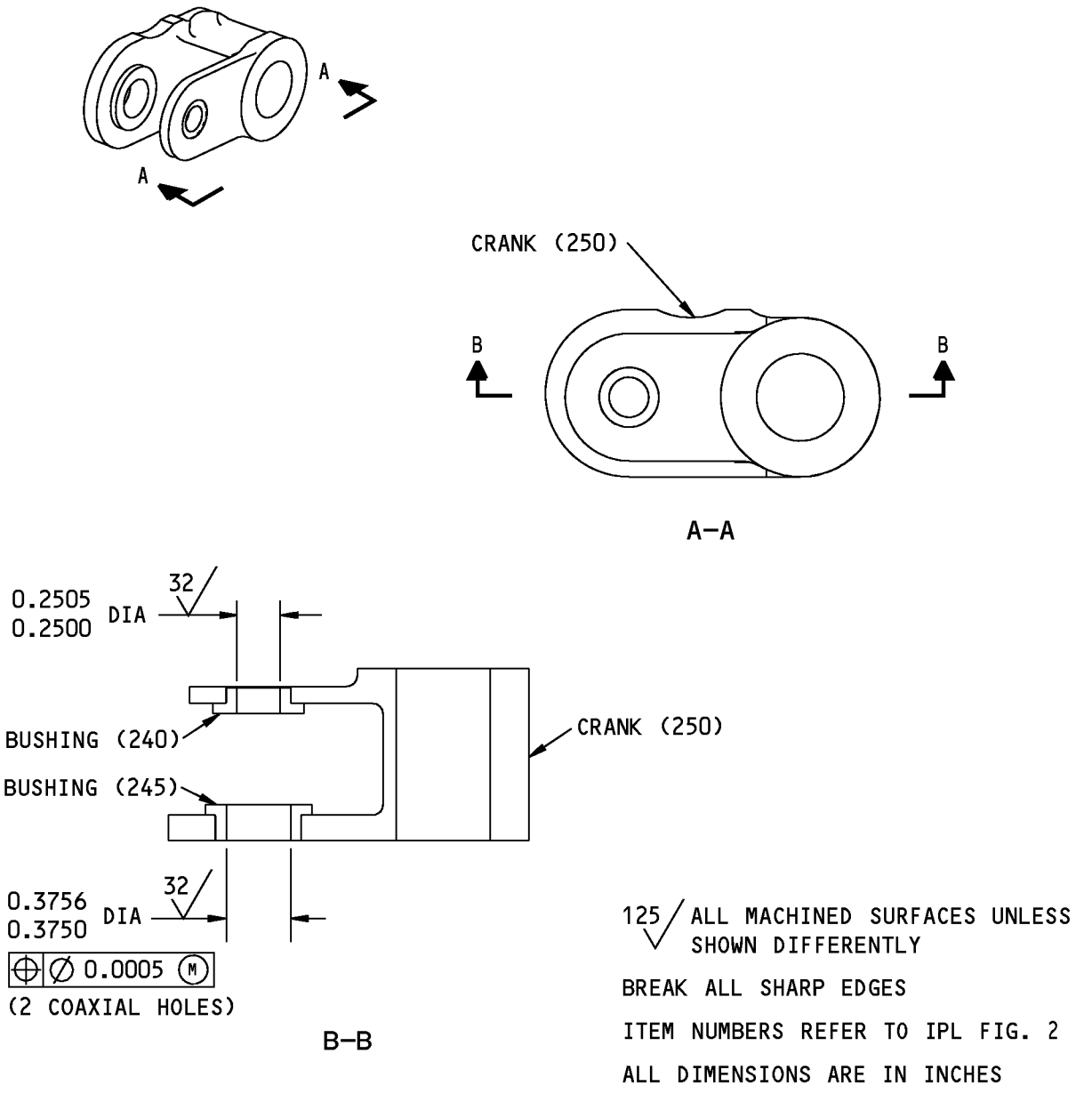
C. Procedure (REPAIR 25-1, Figure 601)

(1) Remove the old bushings.

(2) If you find defects on the hole surfaces, refer to REPAIR 25-2 for repair instructions.

(3) Install replacement bushings by the shrink fit method (SOPM 20-50-03) with BMS 5-95 sealant, A00247 as the installation finish.

(4) Machine the bushings to design dimensions and finish.



146A6547-1 Vent Door Crank Assembly Parts Replacement
Figure 601

CRANK - REPAIR 25-2

146A6547–101

1. General

A. This procedure tells how to repair and refinish crank (250).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 2 for item numbers.

D. General repair details:

(1) Material: 15-5PH CRES, 180-200 ksi

(2) Shot peen: not necessary

2. Crank Repair

A. Procedure (REPAIR 25-2, Figure 601)

(1) Repair is only replacement of the original refinish. Refer to REPAIR 25-2, Paragraph 3. for details.

(2) If you think there are defects on important surfaces, see REPAIR 25-2, Figure 601 for dimension details.

3. Crank Refinish

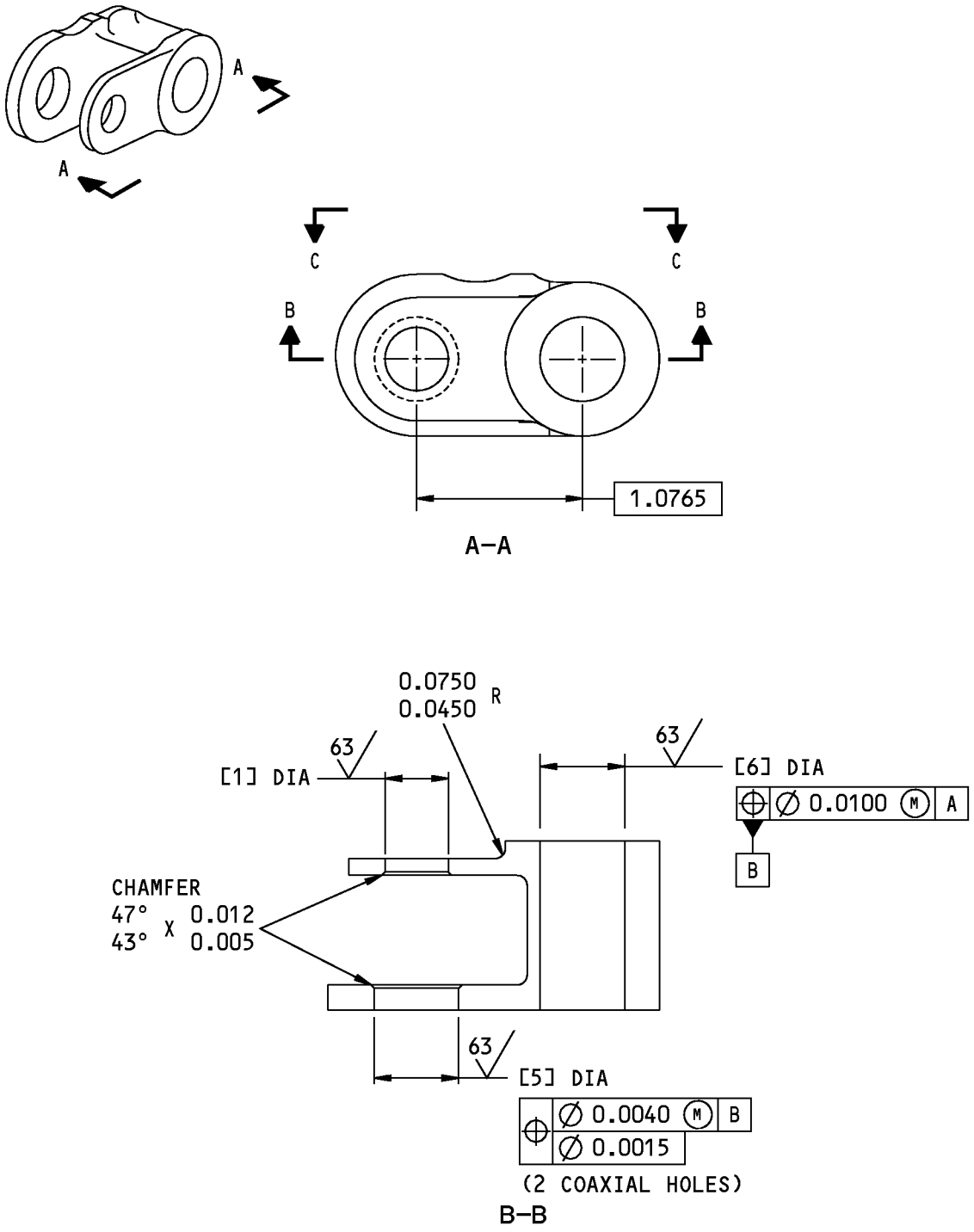
A. References

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

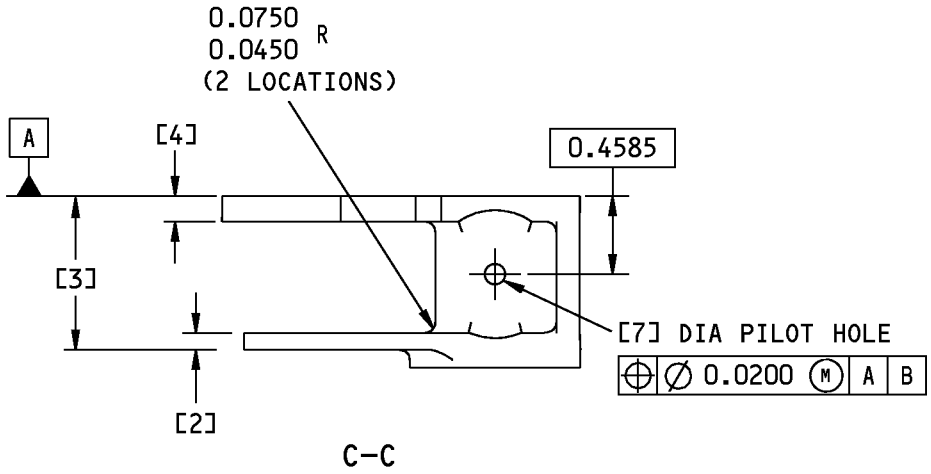
B. Procedure (REPAIR 25-2, Figure 601)

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

(1) Passivate (F-17.25).



146A6547-101 Vent Door Crank Repair and Refinish
Figure 601 (Sheet 1 of 2)



REFERENCE NUMBER	[1]	[2]	[3]	[4]	[5]	[6]	[7]
DESIGN DIMENSION	0.3756 0.3750	0.1100 0.0900	0.9100 0.8900	0.1600 0.1400	0.5006 0.5000	0.5485 0.5465	0.1300 0.1260
REPAIR LIMIT	—	—	—	—	—	—	—

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

146A6547-101 Vent Door Crank Repair and Refinish
Figure 601 (Sheet 2 of 2)

SNUBBER FITTING ASSEMBLY - REPAIR 26-1

146A6551–1

1. General

A. This procedure tells how to replace the parts of snubber fitting assembly (275).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 4 for item numbers.

2. Bushing Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

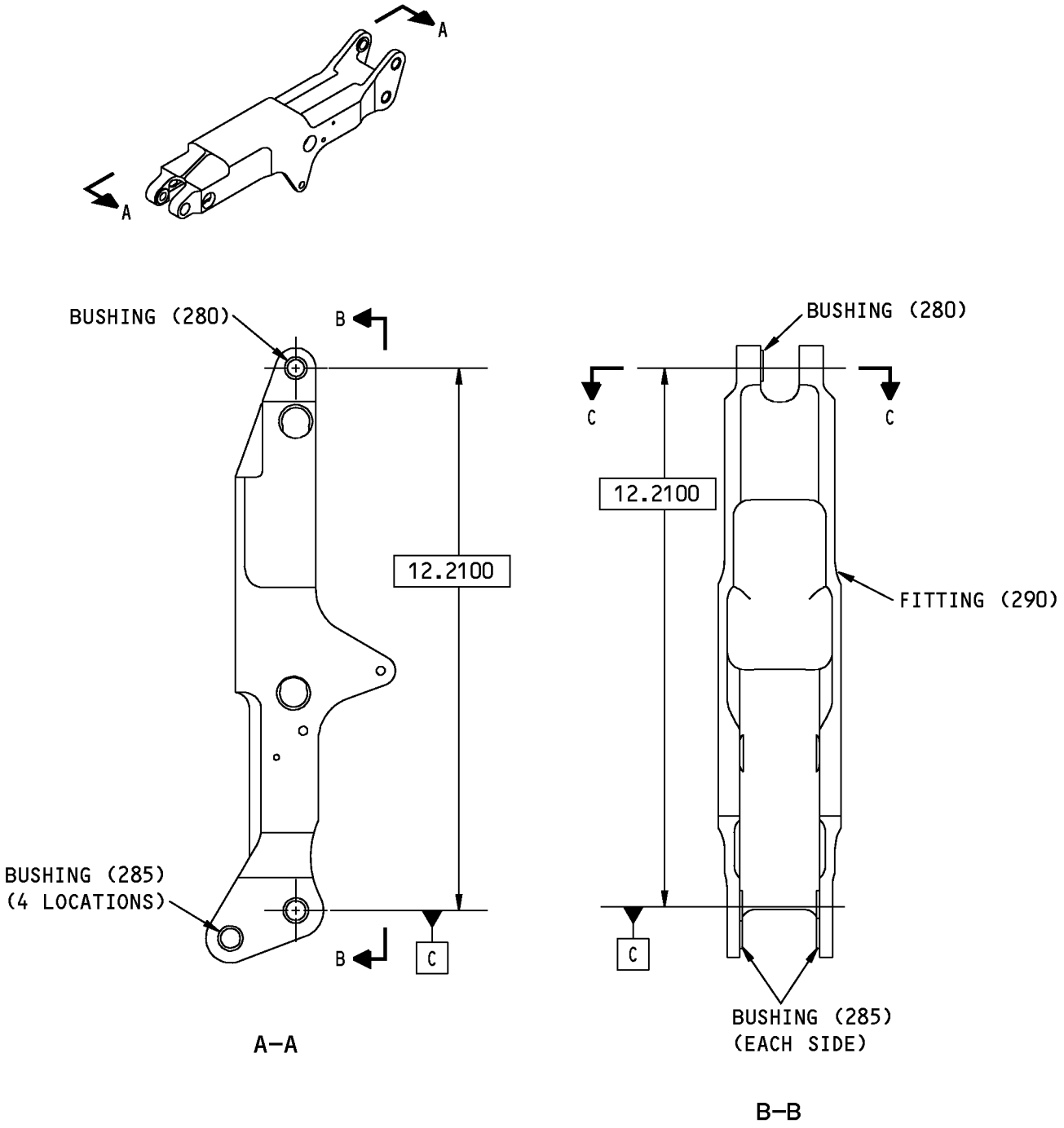
C. Procedure (REPAIR 26-1, Figure 601)

(1) Remove the old bushings.

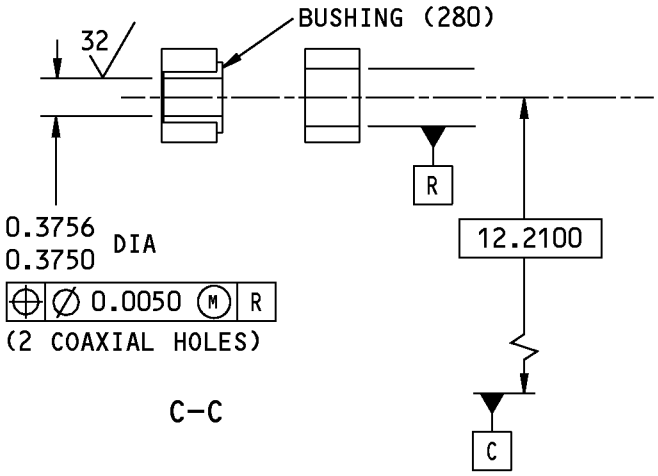
(2) If you find defects on the hole surfaces, refer to REPAIR 26-2 for repair instructions.

(3) Install replacement bushings by the shrink fit method (SOPM 20-50-03) with BMS 5-95 sealant, A00247 as the installation finish.

(4) Machine only bushing (280) to design dimensions and finish. Do not machine bushings (285), because they have a self-lubricated liner and flange face and are made to give final dimensions after installation without adjustment.



146A6551-1 Snubber Fitting Assembly Bushing Replacement
Figure 601 (Sheet 1 of 2)



125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 4

ALL DIMENSIONS ARE IN INCHES

146A6551-1 Snubber Fitting Assembly Bushing Replacement
Figure 601 (Sheet 2 of 2)

SNUBBER FITTING - REPAIR 26-2

146A6551–101

1. General

A. This procedure tells how to repair and refinish snubber fitting (290).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 4 for item numbers.

D. General repair details:

(1) Material: Al alloy

(2) Shot peen: not necessary

2. Fitting Repair

A. Procedure (REPAIR 26-2, Figure 601)

(1) Repair is only replacement of the original refinish. Refer to REPAIR 26-2, Paragraph 3. for details.

(2) If you think there are defects on important surfaces, see REPAIR 26-2, Figure 601 for dimension details.

3. 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

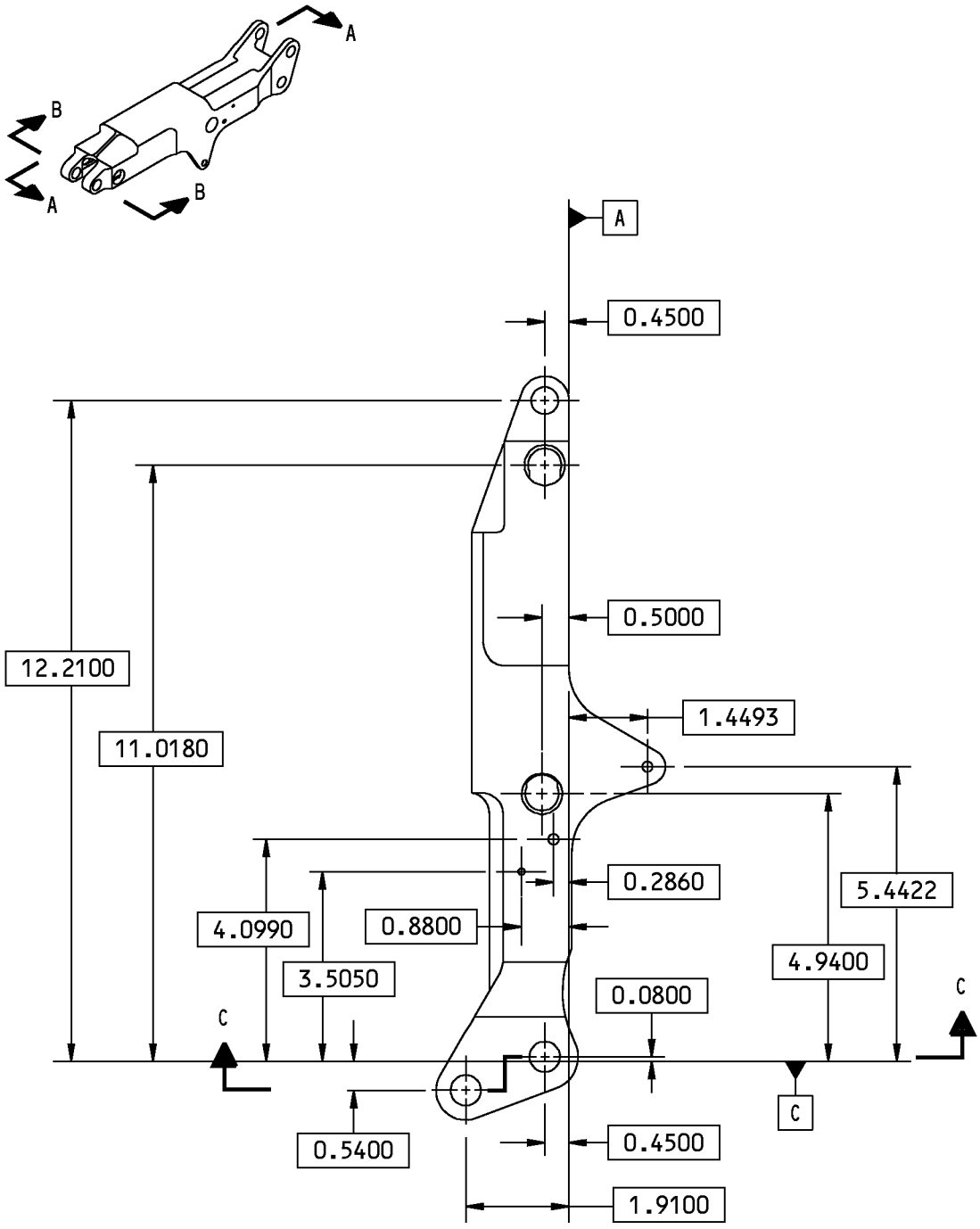
Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES

C. Procedure (REPAIR 26-2, Figure 601)

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

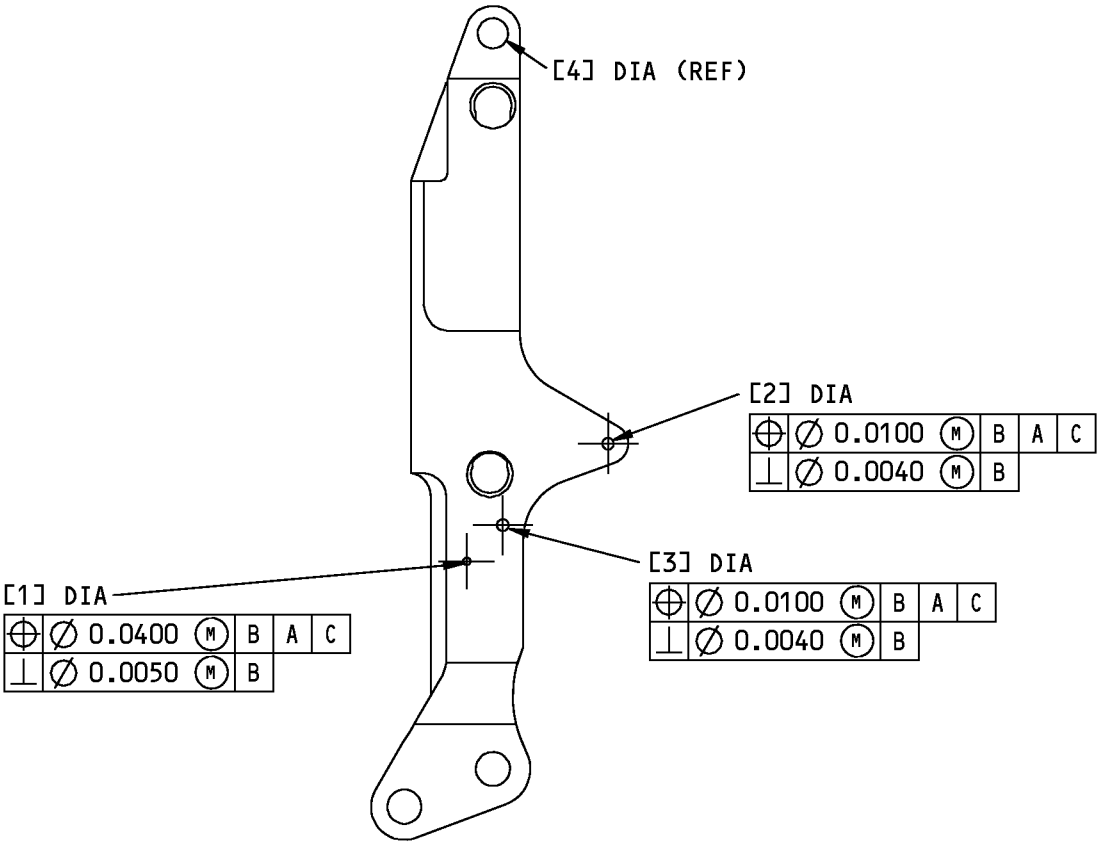
(1) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31) all over.

(2) Apply BMS 10-11, Type 1 primer, C00259 (F-20.03) but not in the hole for the bearing.



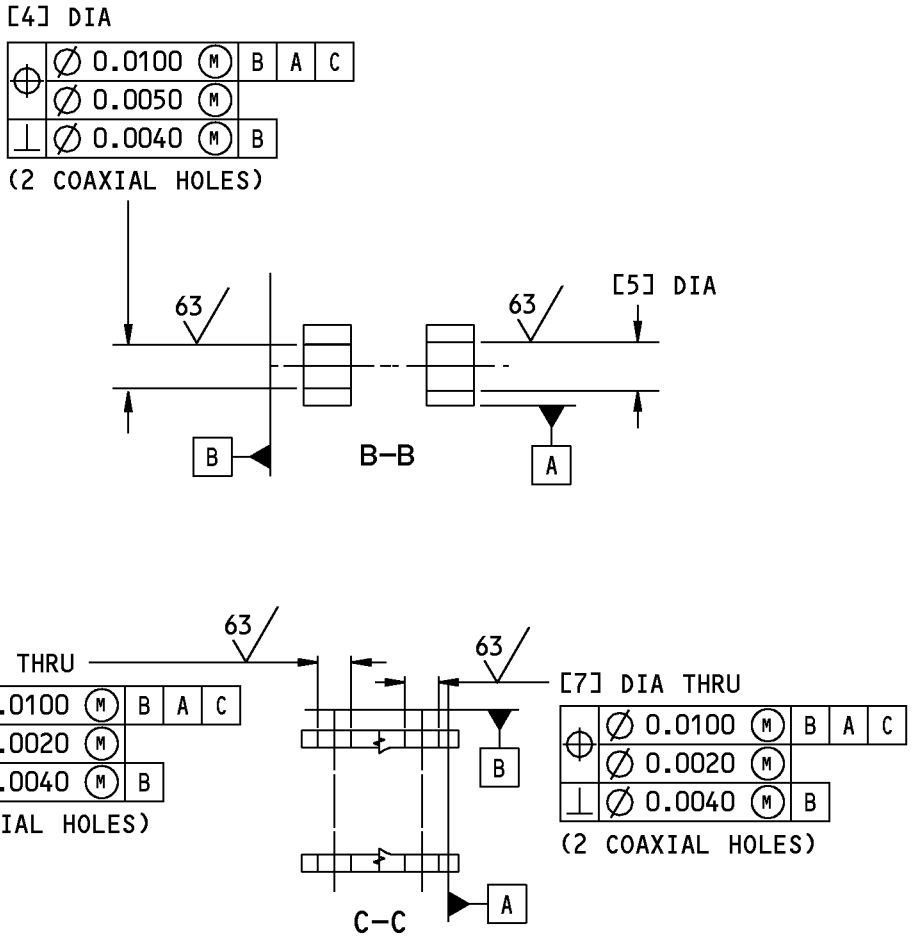
A–A
(BASIC DIMENSIONS)

146A6551-101 Snubber Fitting Repair and Refinish
Figure 601 (Sheet 1 of 3)



A–A
(REPAIR DIMENSIONS)

146A6551-101 Snubber Fitting Repair and Refinish
Figure 601 (Sheet 2 of 3)



REFERENCE NUMBER	[1]	[2]	[3]	[4]	[5]	[6]	[7]
DESIGN DIMENSION	0.1300 0.1200	0.1940 0.1900	0.1940 0.1900	0.5006 0.5000	0.5627 0.5620	0.5631 0.5625	0.5631 0.5625
REPAIR LIMIT	—	—	—	—	—	—	—

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

146A6551-101 Snubber Fitting Repair and Refinish
Figure 601 (Sheet 3 of 3)

UPPER SNUBBER SUPPORT IDLER ASSEMBLY - REPAIR 27-1

146A6552–1, –2

1. General

A. This procedure tells how to replace the parts of upper snubber support idler assemblies (295, 300).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 4 for item numbers.

2. Bearing (305) Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
D00633	Grease - Aircraft General Purpose	BMS3-33

B. References

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

C. Procedure (REPAIR 27-1, Figure 601)

(1) Remove the old bearings (305) and the bushing (315) between them.

(2) If you find defects on the hole surfaces, refer to REPAIR 27-2 for repair instructions.

(3) Install replacement bearings (305), with bushing (315) between them, by the press fit method (SOPM 20-50-03) with BMS 3-33 grease, D00633 as the installation finish. Swaging is not necessary.

3. Bearing (310) Replacement

A. References

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

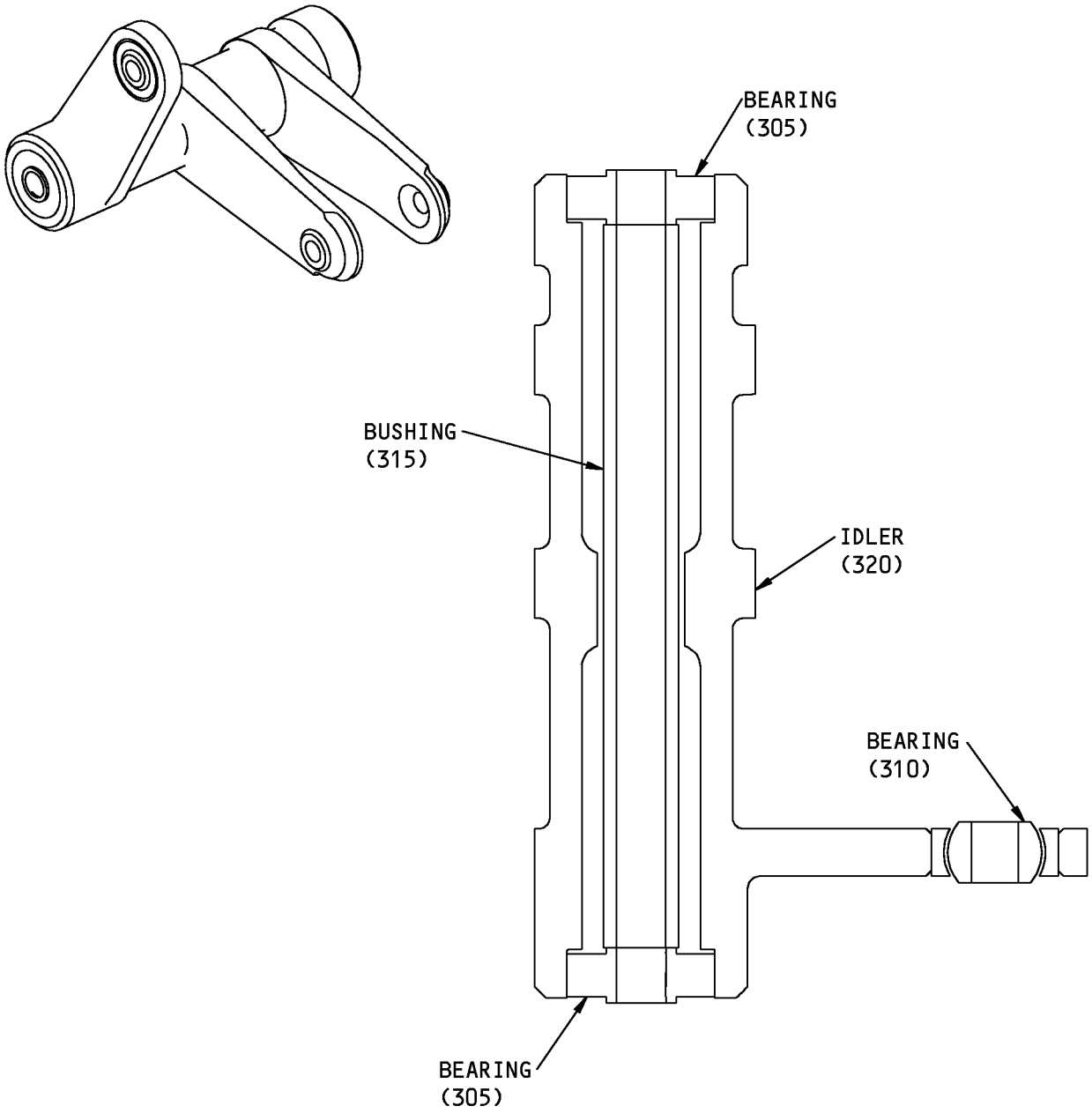
B. Procedure (REPAIR 27-1, Figure 601)

(1) Remove the old bearing.

(2) If you find defects on the hole surfaces, refer to REPAIR 27-2 for repair instructions.

(3) Install a replacement bearing and roller swage it (SOPM 20-50-03).

(4) Give the bearing an 1150-pound push-out proof load test.



146A6552-1,-2 Upper Snubber Support Idler Assembly Parts Replacement
Figure 601

UPPER SNUBBER SUPPORT IDLER - REPAIR 27-2

146A6552–101, –102

1. General

A. This procedure tells how to repair and refinish upper snubber support idler (320, 325).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 4 for item numbers.

D. General repair details:

(1) Material: Al alloy

(2) Shot peen: not necessary

2. Idler Repair

A. Procedure (REPAIR 27-2, Figure 601)

(1) Repair is only replacement of the original refinish. Refer to REPAIR 27-2, Paragraph 3. for details.

(2) If you think there are defects on important surfaces, see REPAIR 27-2, Figure 601 for dimension details.

3. Idler 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

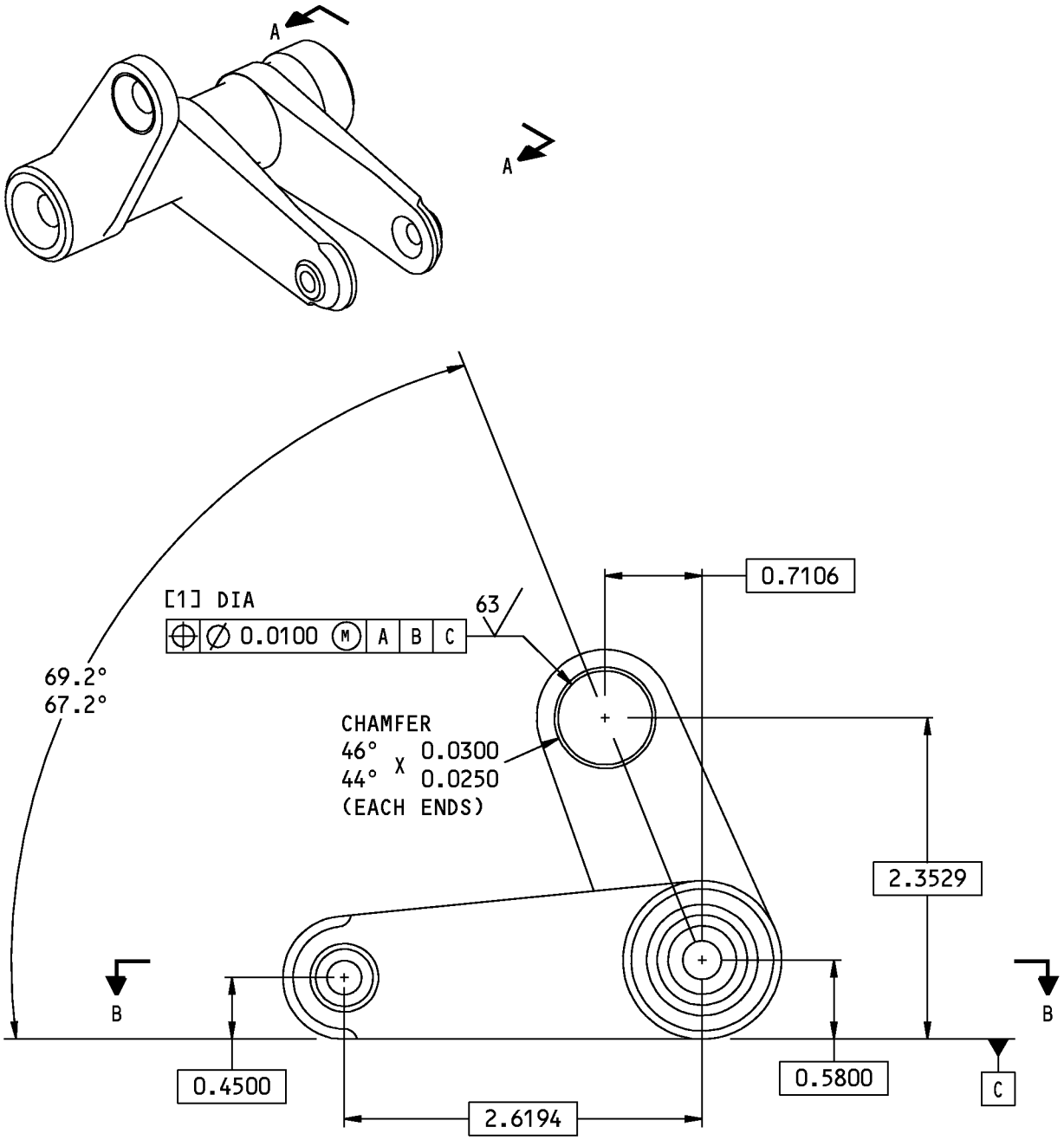
Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES

C. Procedure (REPAIR 27-2, Figure 601)

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

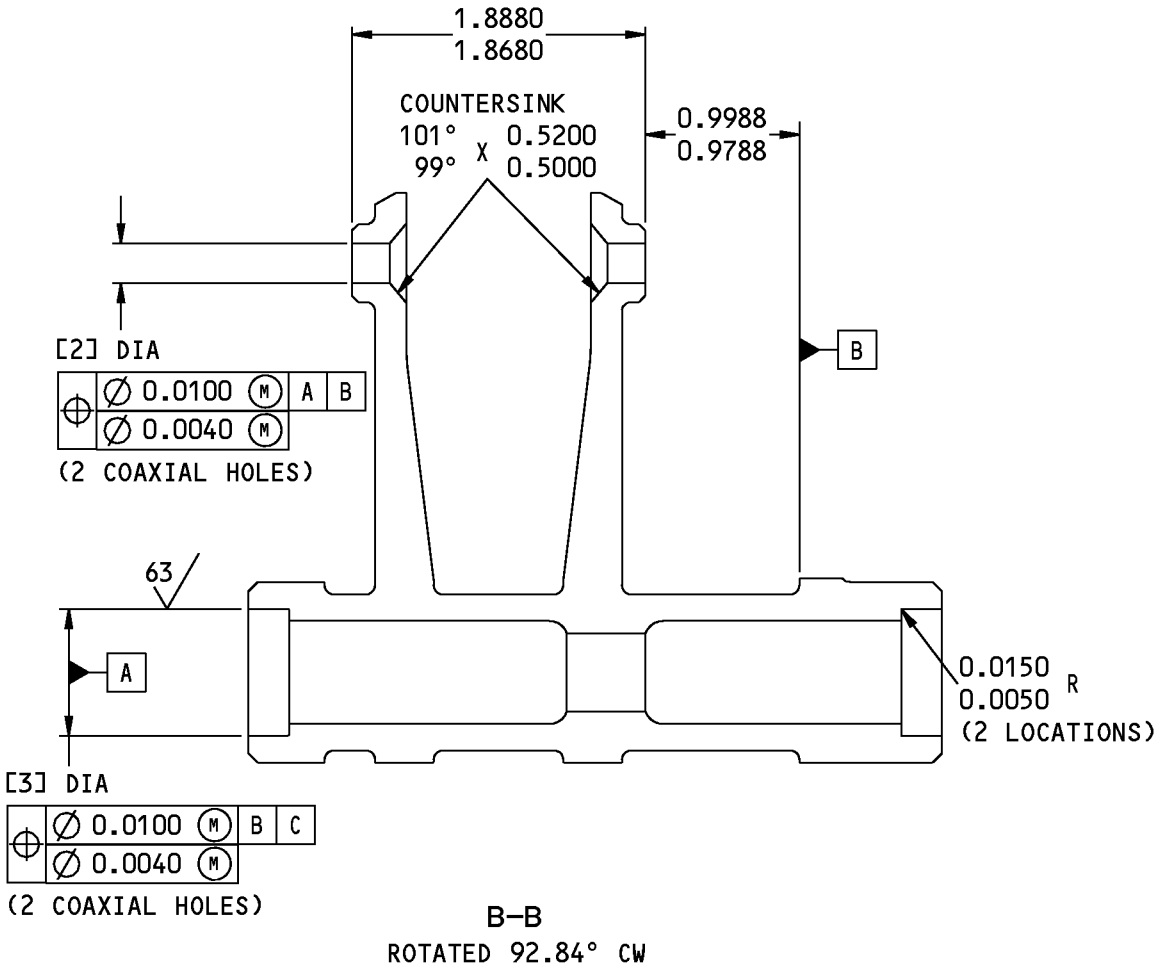
(1) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31) all over.

(2) Apply BMS 10-11, Type 1 primer, C00259 (F-20.03) but not in the hole for the bearing.



A-A
146A6552-101 SHOWN
146A6552-1022 OPPOSITE

146A6552-101,-102 Upper Snubber Support Idler Repair and Refinish
Figure 601 (Sheet 1 of 2)



B–B
ROTATED 92.84° CW

REFERENCE NUMBER	[1]	[2]	[3]
DESIGN DIMENSION	0.6885 0.6875	0.2540 0.2500	0.8135 0.8125
REPAIR LIMIT	---	---	---

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

146A6552-101,-102 Upper Snubber Support Idler Repair and Refinish
Figure 601 (Sheet 2 of 2)

LOWER SNUBBER SUPPORT IDLER ASSEMBLY - REPAIR 28-1

146A6553–1

1. General

A. This procedure tells how to replace the parts of lower snubber support idler assembly (380).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 4 for item numbers.

2. Bearing (385) Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
D00633	Grease - Aircraft General Purpose	BMS3-33

B. References

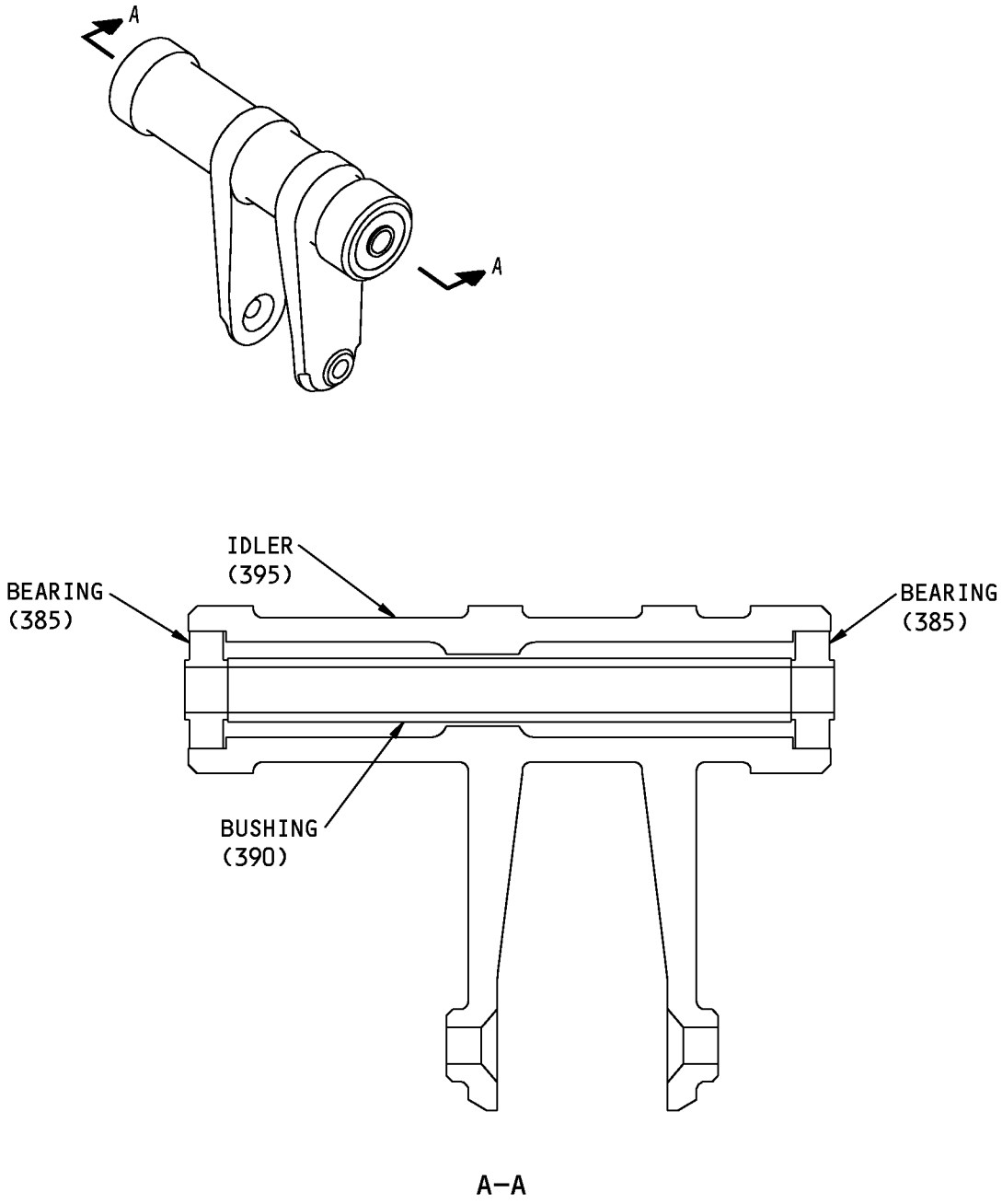
Reference	Title
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT

C. Procedure (REPAIR 28-1, Figure 601)

(1) Remove the old bearings (385) and the bushing (390) between them.

(2) If you find defects on the hole surfaces, refer to REPAIR 28-2 for repair instructions.

(3) Install replacement bearings (385), with bushing (390) between them, by the press fit method (SOPM 20-50-03) with BMS 3-33 grease, D00633 as the installation finish. Swaging is not necessary.



A–A

ITEM NUMBERS REFER TO IPL FIG. 4

146A6553-1 Lower Snubber Support Idler Assembly Parts Replacement
Figure 601

LOWER SNUBBER SUPPORT IDLER - REPAIR 28-2

146A6553–101

1. General

A. This procedure tells how to repair and refinish lower snubber support idler (395).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 4 for item numbers.

D. General repair details:

(1) Material: Al alloy

(2) Shot peen: not necessary

2. Idler Repair

A. Procedure (REPAIR 28-2, Figure 601)

(1) Repair is only replacement of the original refinish. Refer to REPAIR 28-2, Paragraph 3. for details.

(2) If you think there are defects on important surfaces, see REPAIR 28-2, Figure 601 for dimension details.

3. Idler 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

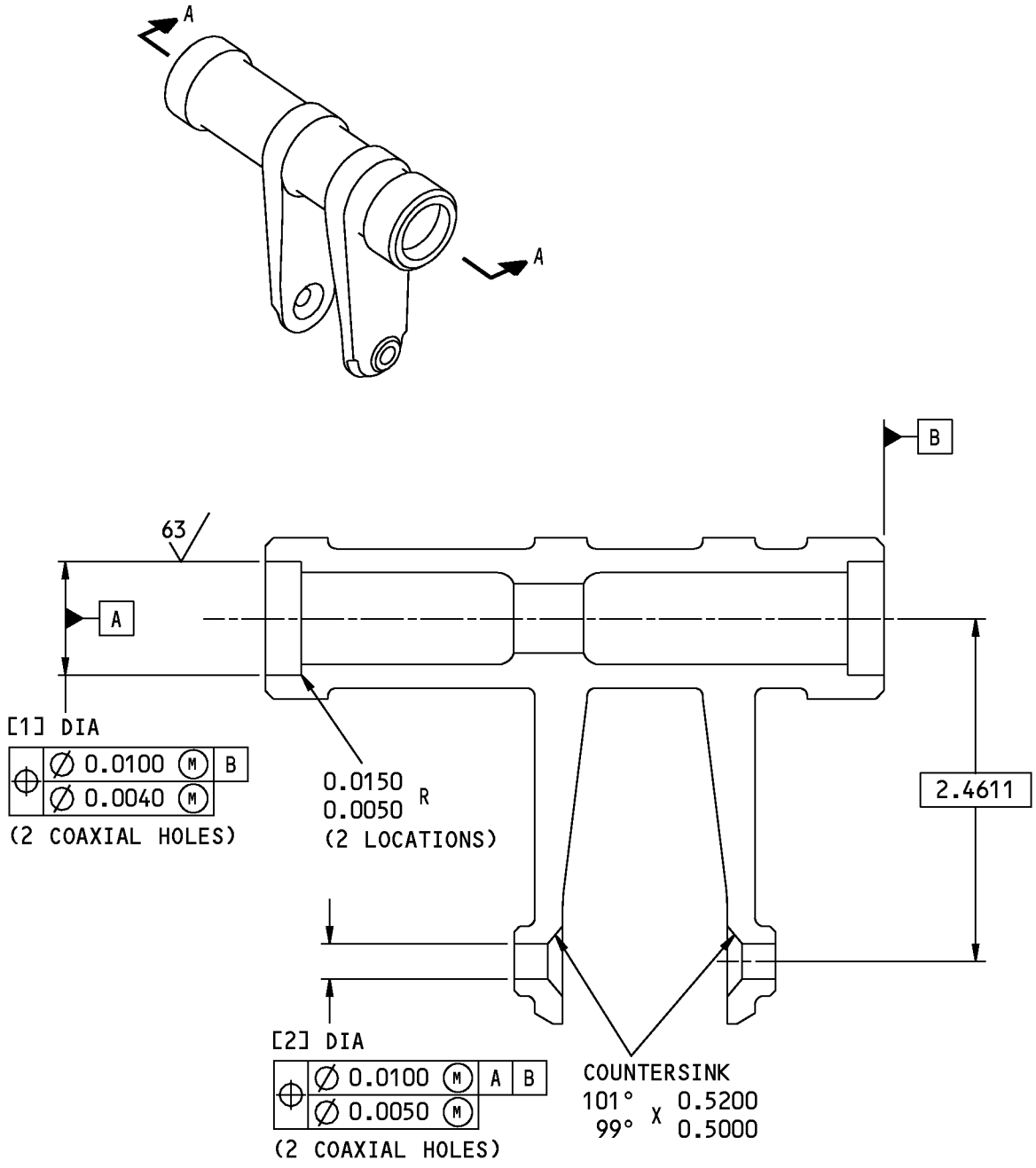
Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES

C. Procedure (REPAIR 28-2, Figure 601)

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

(1) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31) all over.

(2) Apply BMS 10-11, Type 1 primer, C00259 (F-20.03) but not in the hole for the bearing.



A–A

146A6553-101 Lower Snubber Support Idler Repair and Refinish
Figure 601 (Sheet 1 of 2)

REFERENCE NUMBER	[1]	[2]
DESIGN DIMENSION	0.8135 0.8125	0.2540 0.2500
REPAIR LIMIT	---	---

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

146A6553-101 Lower Snubber Support Idler Repair and Refinish
Figure 601 (Sheet 2 of 2)

SNUBBER LINK ASSEMBLY - REPAIR 29-1

146A6554–1, –2

1. General

A. This procedure tells how to replace the parts of snubber link assemblies (400, 405).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 4 for item numbers.

2. Bushing Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

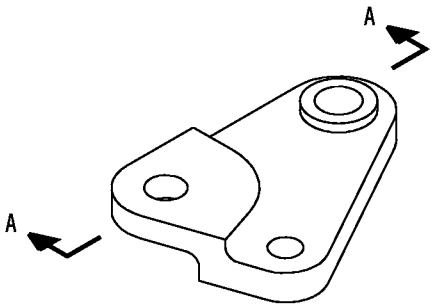
C. Procedure (REPAIR 29-1, Figure 601)

(1) Remove the old bushing.

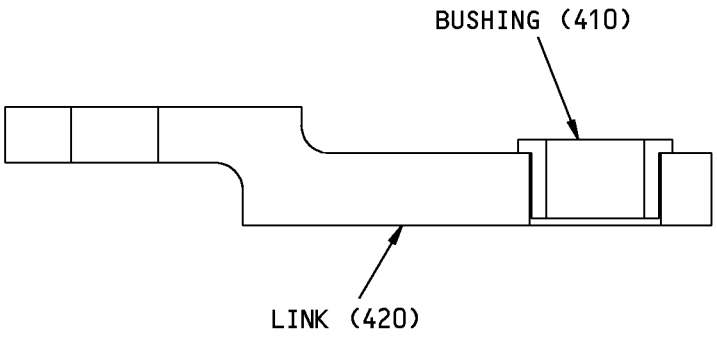
(2) If you find defects on the hole surfaces, refer to REPAIR 29-2 for repair instructions.

(3) Install a replacement bushing by the shrink fit method (SOPM 20-50-03) with BMS 5-95 sealant, A00247 as the installation finish.

(4) Do not machine this bushing, because it has a self-lubricated liner and flange face and is made to give final dimensions after installation without adjustment.



146A6554-1 SHOWN
146A6554-2 OPPOSITE



A-A

ITEM NUMBERS REFER TO IPL FIG. 4

146A6554-1,-2 Snubber Link Assembly Bushing Replacement
Figure 601

SNUBBER LINK - REPAIR 29-2

146A6554–101, –102

1. General

A. This procedure tells how to repair and refinish snubber links (415, 420).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 4 for item numbers.

D. General repair details:

(1) Material: Al alloy

(2) Shot peen: not necessary

2. Link Repair

A. Procedure (REPAIR 29-2, Figure 601)

(1) Repair is only replacement of the original refinish. Refer to REPAIR 29-2, Paragraph 3. for details.

(2) If you think there are defects on important surfaces, see REPAIR 29-2, Figure 601 for dimension details.

3. Link 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

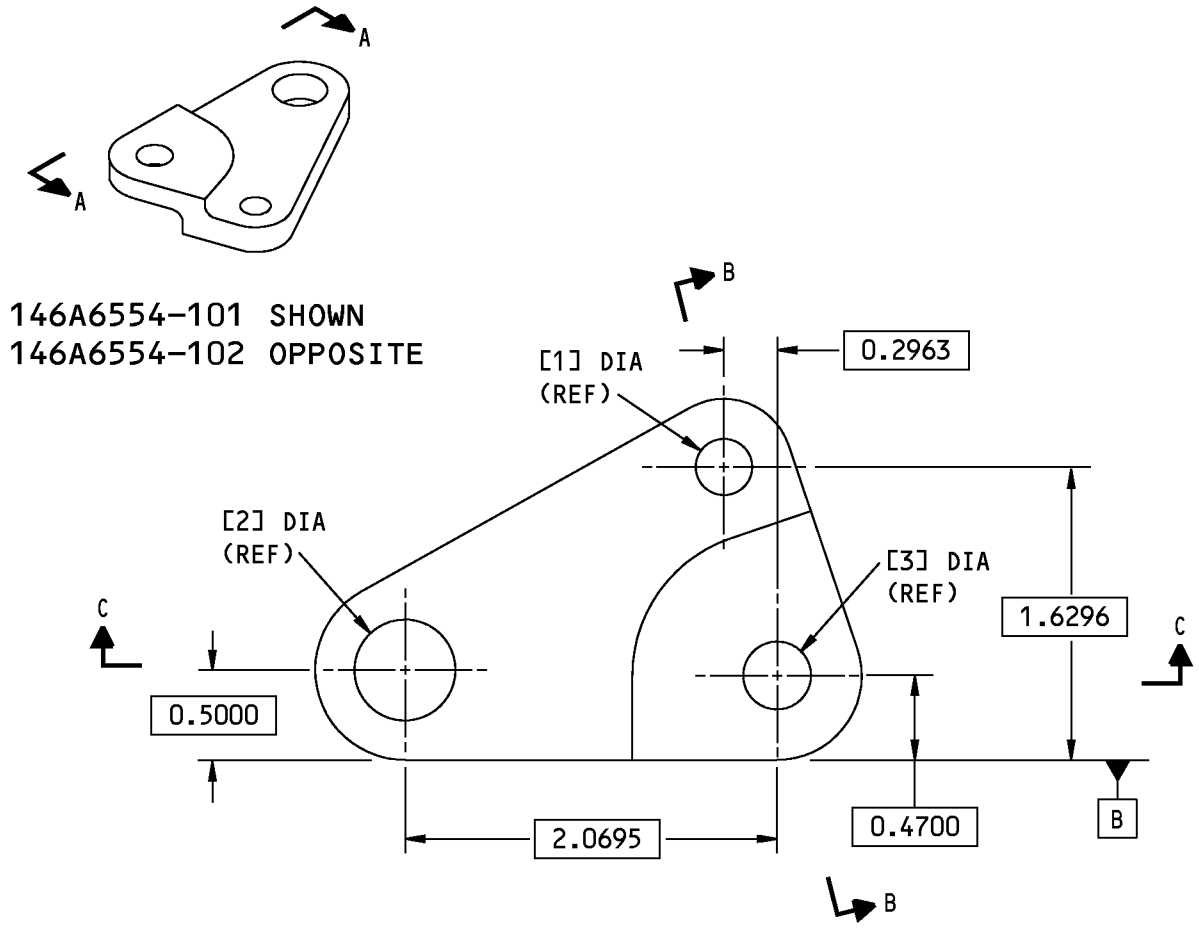
Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES

C. Procedure (REPAIR 29-2, Figure 601)

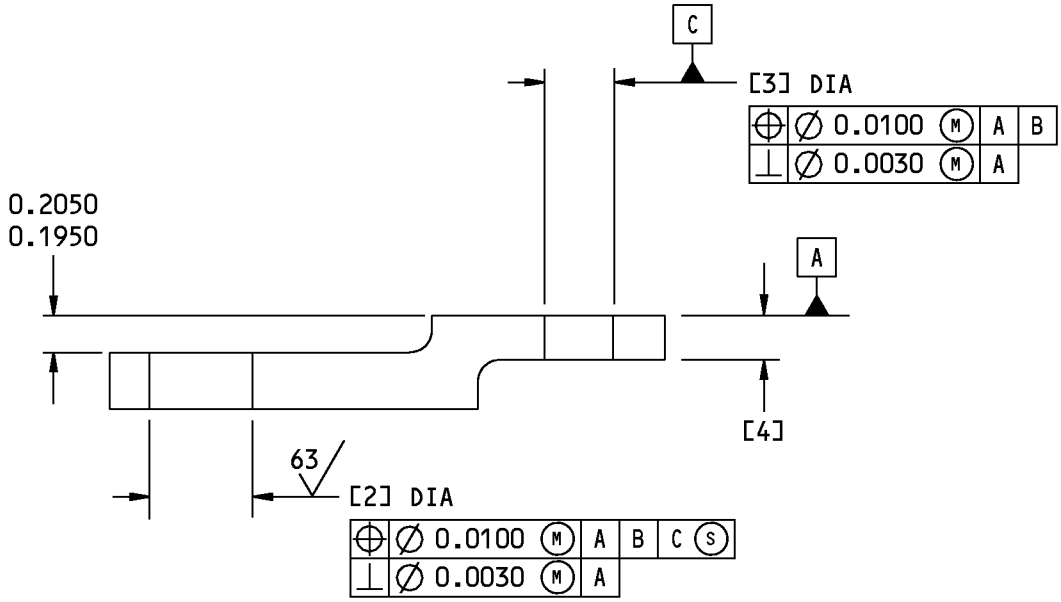
NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01.

(1) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31) all over.

(2) Apply BMS 10-11, Type 1 primer, C00259 (F-20.03) but not in the holes.



146A6554-101,-102 Snubber Link Repair and Refinish
Figure 601 (Sheet 1 of 2)



C–C

REFERENCE NUMBER	[1]	[2]	[3]	[4]
DESIGN DIMENSION	0.3160 0.3120	0.5631 0.5625	0.3790 0.3750	0.2500 0.2300
REPAIR LIMIT	---	---	---	---

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

146A6554-101,-102 Snubber Link Repair and Refinish
Figure 601 (Sheet 2 of 2)

LIFT ASSIST FITTING ASSEMBLY - REPAIR 30-1

146A6555–1, –2

1. General

A. This procedure tells how to replace the parts of lift assist fitting assemblies (250, 255).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 4 for item numbers.

2. Bearing Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

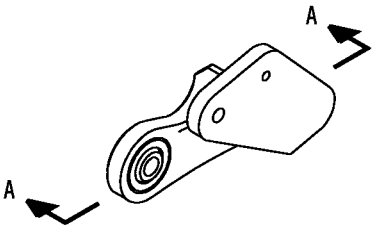
C. Procedure (REPAIR 30-1, Figure 601)

(1) Remove the old bearing.

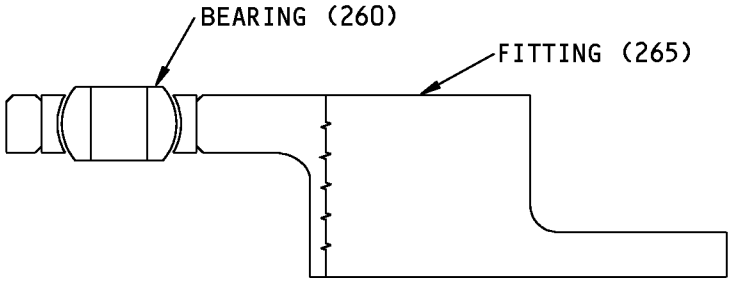
(2) If you find defects on the hole surfaces, refer to REPAIR 30-2 for repair instructions.

(3) Install a replacement bearing and roller swage it (SOPM 20-50-03) with BMS 5-95 sealant, A00247 as the installation finish.

(4) Give the bearing an 1150-pound push-out proof load test.



146A6555-1 SHOWN
146A6555-2 OPPOSITE



A-A

ITEM NUMBERS REFER TO IPL FIG. 4

146A6555-1,-2 Lift Assist Fitting Assembly Bearing Replacement
Figure 601

LIFT ASSIST FITTING - REPAIR 30-2

146A6555–101, –102

1. General

A. This procedure tells how to repair and refinish lift assist fitting (265, 270).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 4 for item numbers.

D. General repair details:

(1) Material: Al alloy

(2) Shot peen: not necessary

2. Fitting Repair

A. Procedure (REPAIR 30-2, Figure 601)

(1) Repair is only replacement of the original refinish. Refer to REPAIR 30-2, Paragraph 3. for details.

(2) If you think there are defects on important surfaces, see REPAIR 30-2, Figure 601 for dimension details.

3. 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

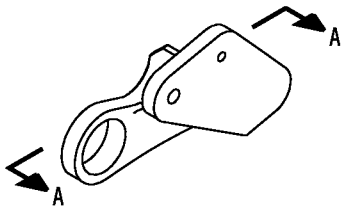
Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES

C. Procedure (REPAIR 30-2, Figure 601)

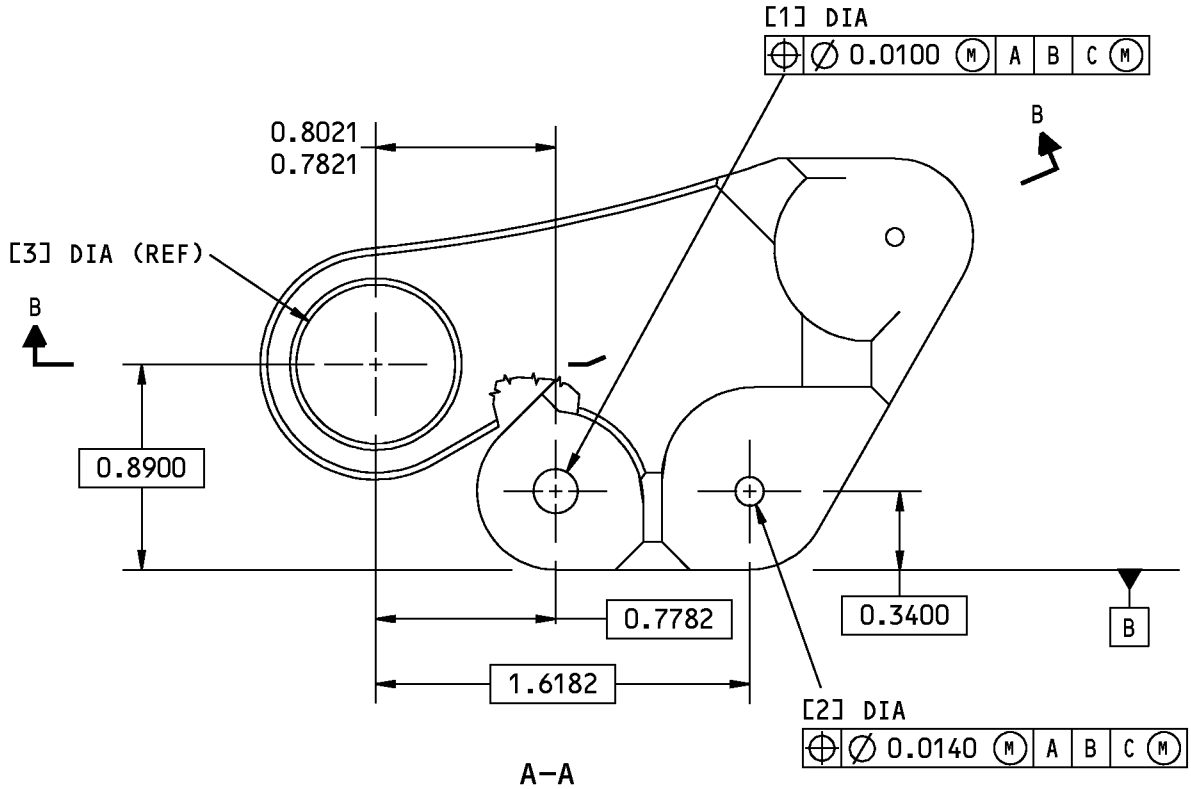
NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01.

(1) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31) all over.

(2) Apply BMS 10-11, Type 1 primer, C00259 (F-20.03) but not in the hole for the bearing.

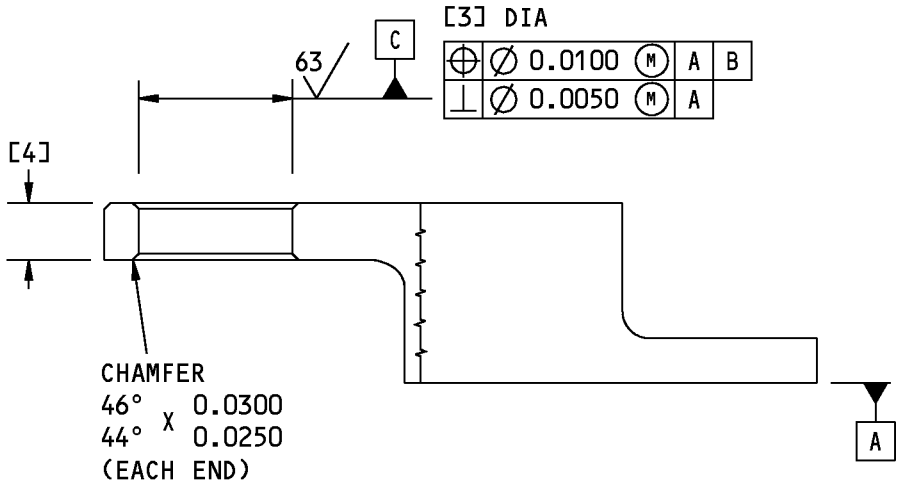


146A6555-101 SHOWN
146A6555-102 OPPOSITE



A–A
(ROTATED 180°)

146A6555-101,-102 Lift Assist Fitting Repair and Refinish
Figure 601 (Sheet 1 of 2)



B–B

REFERENCE NUMBER	[1]	[2]	[3]	[4]
DESIGN DIMENSION	0.1940 0.1900	0.1300 0.1200	0.6885 0.6875	0.2600 0.2500
REPAIR LIMIT	—	—	—	—

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

146A6555-101,-102 Lift Assist Fitting Repair and Refinish
Figure 601 (Sheet 2 of 2)

LIFT ASSIST SPRING ASSEMBLY - REPAIR 31-1

146A6556–1, –3

1. General

A. This procedure tells how to replace the parts of lift assist spring assembly (330).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices shown in the repair.

C. Refer to IPL Figure 4 for item numbers.

2. Parts Replacement

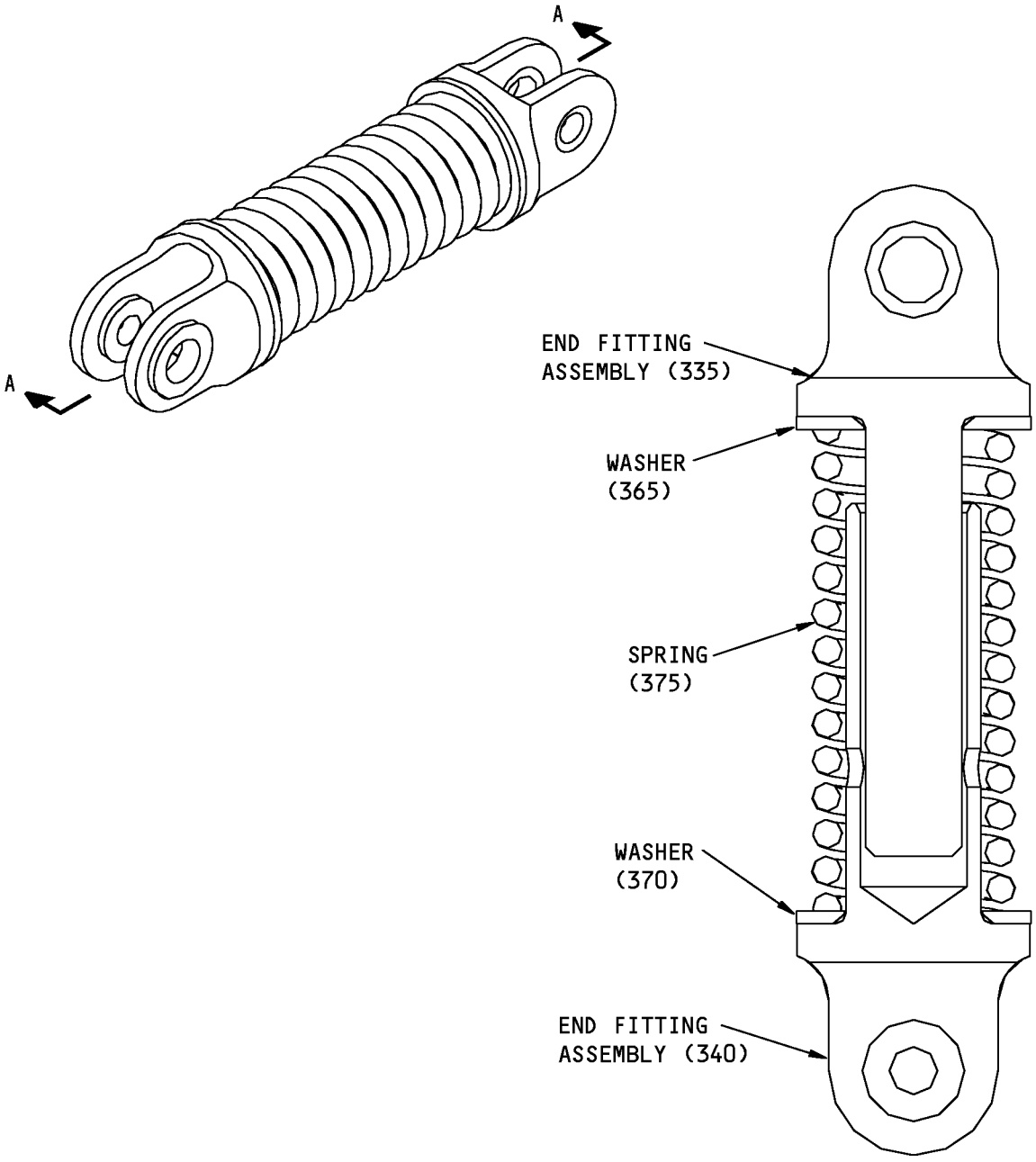
A. Procedure (REPAIR 31-1, Figure 601)

(1) Pull the assembly apart.

(2) If you find defects on the spring, washers or end fittings, refer to REPAIR 1-1 and REPAIR 32-1 for repair instructions.

(3) Install a replacement spring and washers on the end fitting assemblies and put them together as shown.

(4) Use something to tie the parts together until the unit can be installed in the door linkage.



ITEM NUMBERS REFER TO IPL FIG. 4

146A6556-1,-3 Lift Assist Spring Assembly Parts Replacement
Figure 601

END FITTING ASSEMBLY - REPAIR 32-1

146A6557–1, –2

1. General

A. This procedure tells how to replace the parts of end fitting assembly (335, 340).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 4 for item numbers.

2. Bushing Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

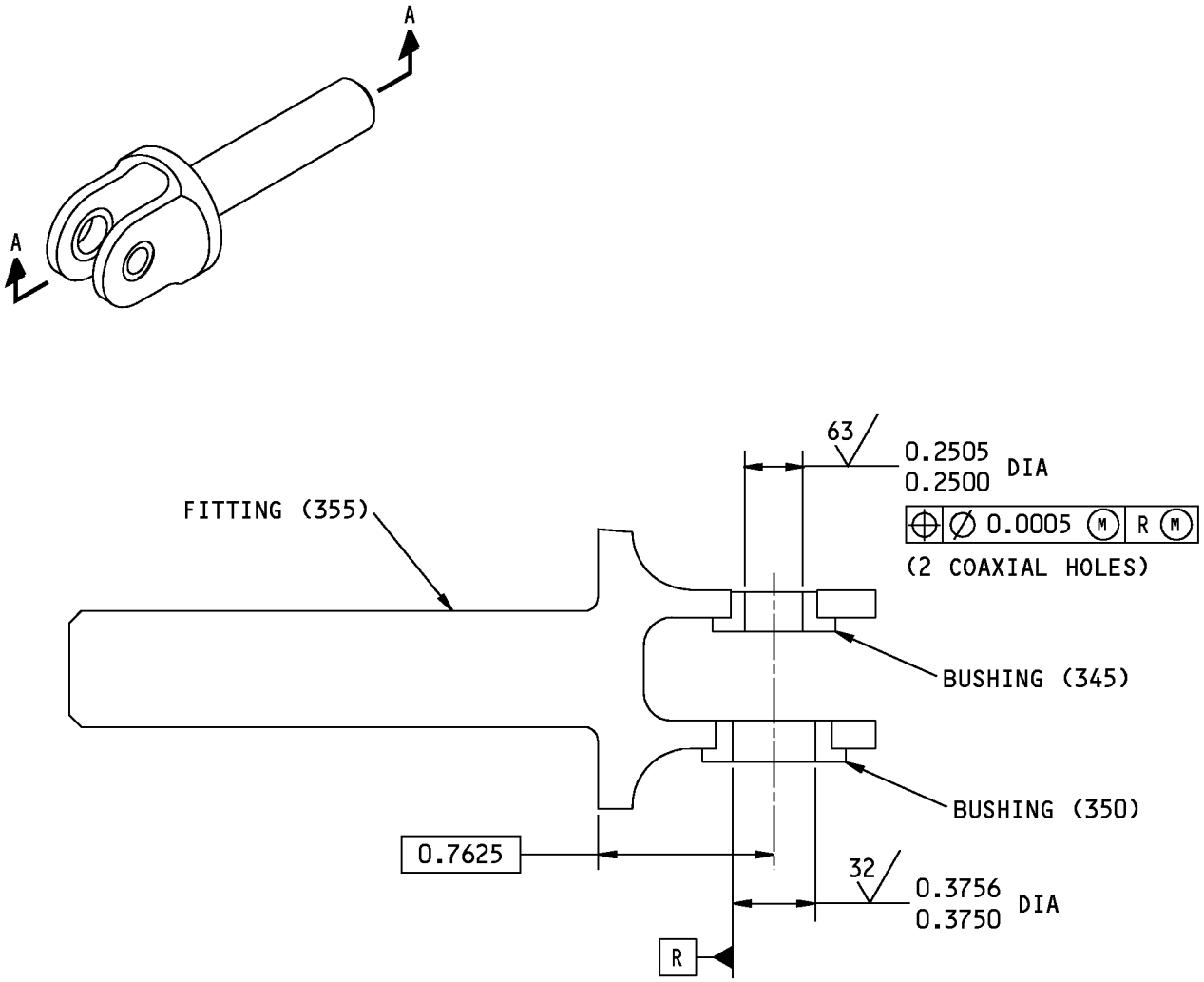
C. Procedure (REPAIR 32-1, Figure 601 or REPAIR 32-1, Figure 602)

(1) Remove the old bushings.

(2) If you find defects on the hole surfaces, refer to REPAIR 32-2 for repair instructions.

(3) Install replacement bushings by the shrink fit method (SOPM 20-50-03) with BMS 5-95 sealant, A00247 as the installation finish.

(4) Machine the bushings to design dimensions and finish.



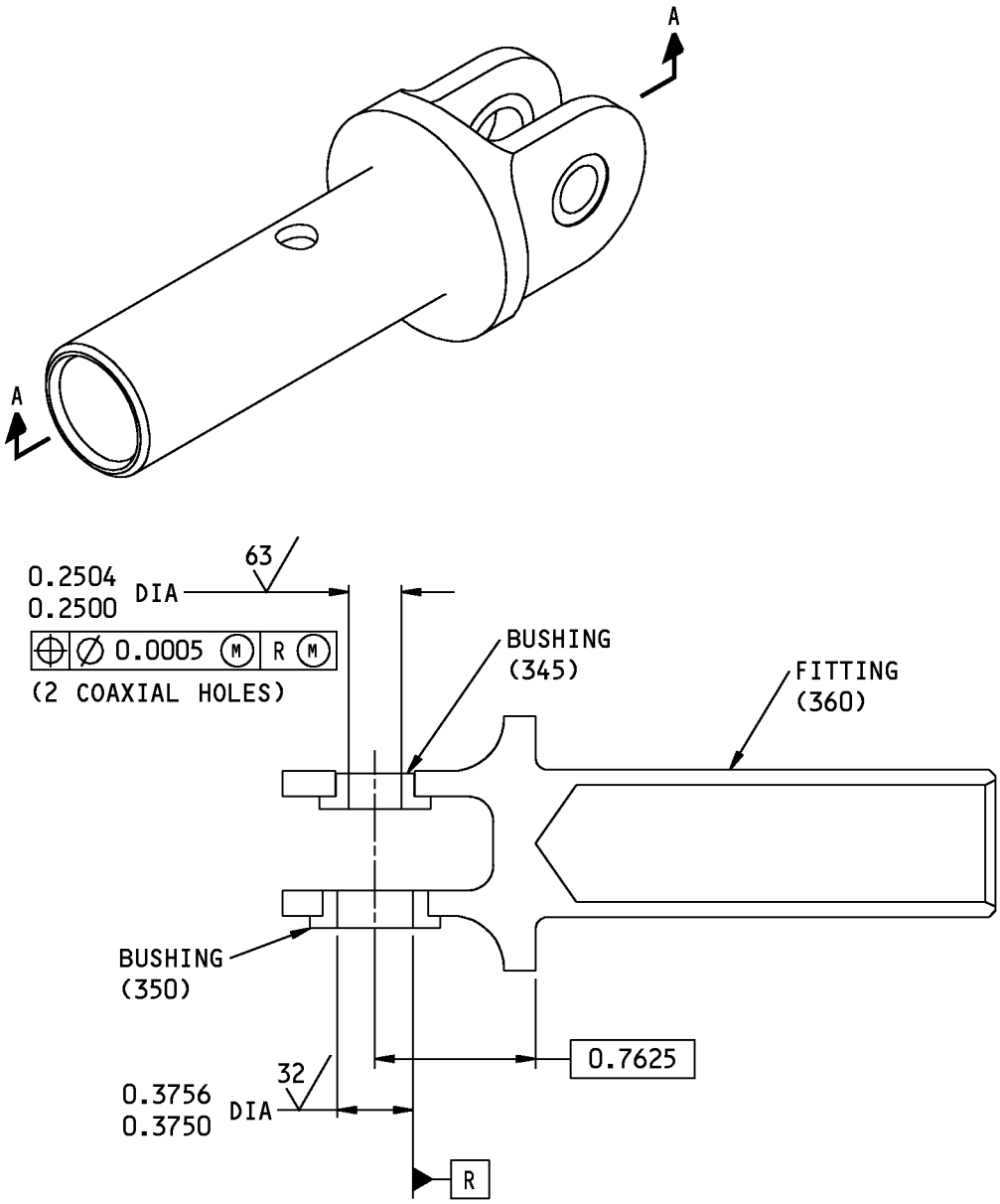
125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 4

ALL DIMENSIONS ARE IN INCHES

146A6557-1 End Fitting Assembly Bushing Replacement
Figure 601



A–A

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 4

ALL DIMENSIONS ARE IN INCHES

146A6557-2 End Fitting Assembly Bushing Replacement
Figure 602

END FITTING - REPAIR 32-2

146A6557–101, –102

1. General

A. This procedure tells how to repair and refinish end fittings (355, 360).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 4 for item numbers.

D. General repair details:

(1) Material: Al-Ni-Bronze

(2) Shot peen: not necessary

2. Fitting Repair

A. Procedure (REPAIR 32-2, Figure 601 or REPAIR 32-2, Figure 602)

(1) Repair is only replacement of the original refinish. Refer to REPAIR 32-2, Paragraph 3. for details.

(2) If you think there are defects on important surfaces, see REPAIR 32-2, Figure 601 or REPAIR 32-2, Figure 602 for dimension details.

3. Fitting Refinish

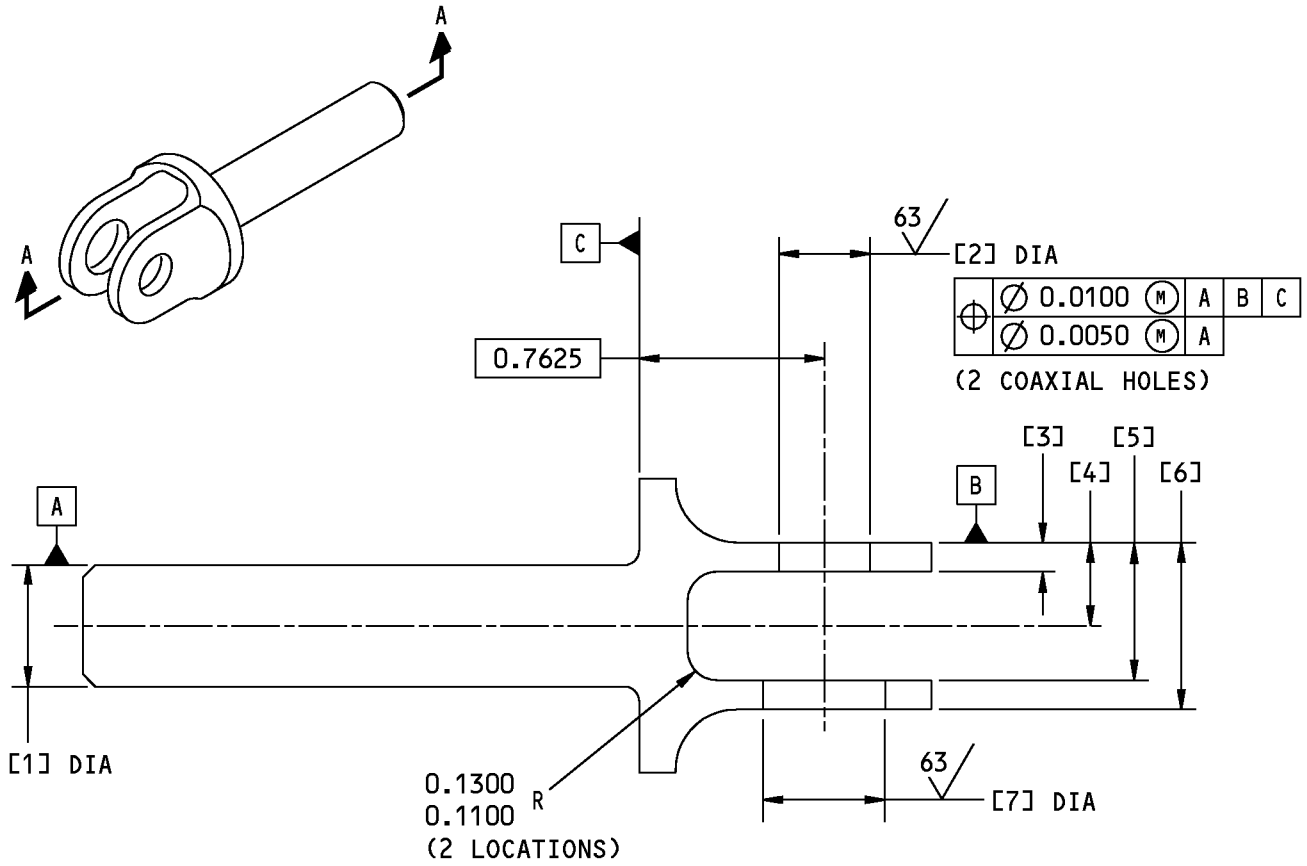
A. References

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

B. Procedure (REPAIR 32-2, Figure 601 or REPAIR 32-2, Figure 602)

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.

(1) Apply no finish (F-25.01).



A–A

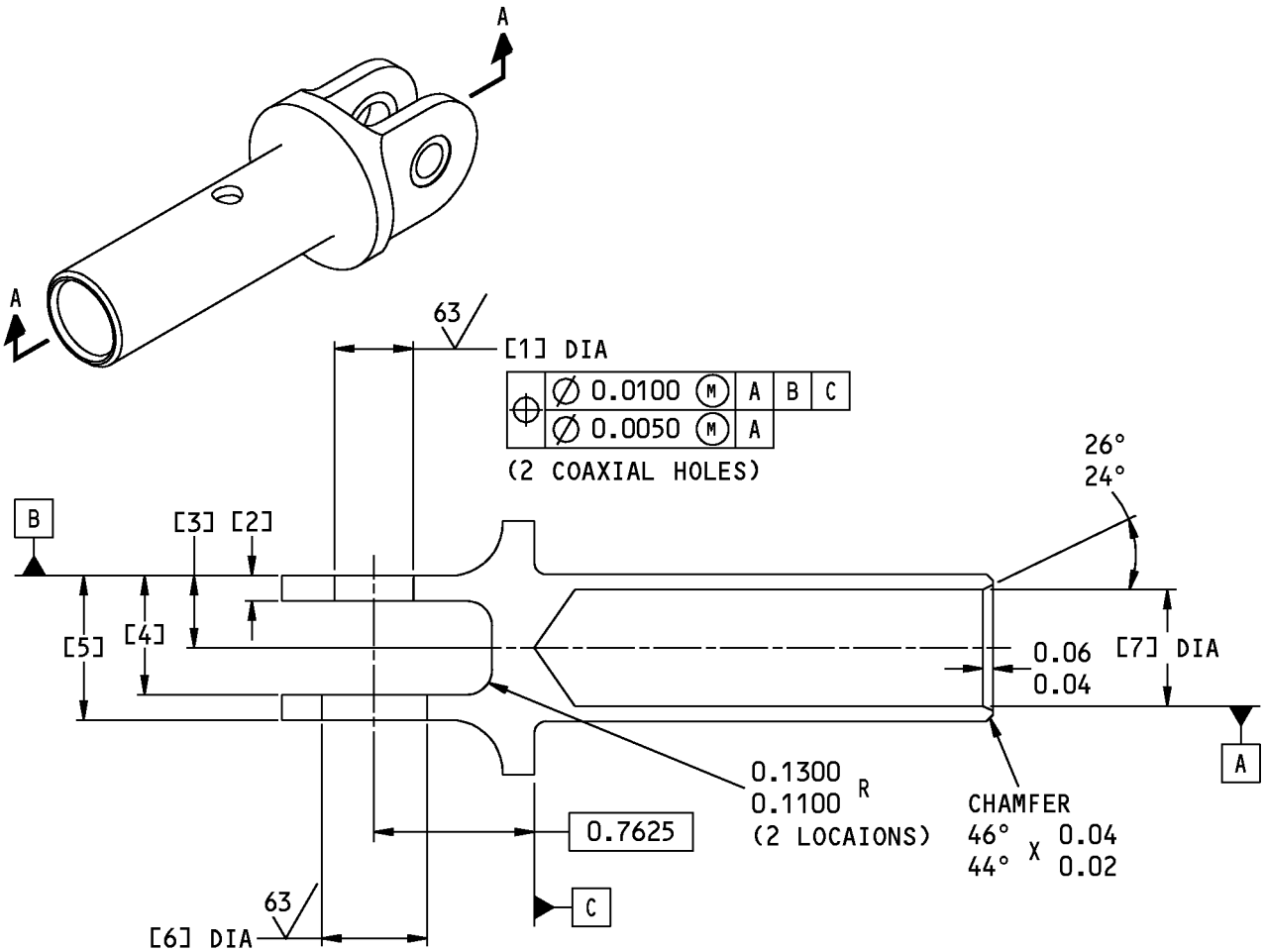
REFERENCE NUMBER	[1]	[2]	[3]	[4]	[5]	[6]	[7]
DESIGN DIMENSION	0.5100 0.4800	0.3756 0.3750	0.1300 0.1100	0.3536 0.3336	0.5770 0.5570	0.6970 0.6770	0.5006 0.5000
REPAIR LIMIT	—	—	—	—	—	—	—

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

146A6557-101 End Fitting Repair and Refinish
Figure 601



A–A

REFERENCE NUMBER	[1]	[2]	[3]	[4]	[5]	[6]	[7]
DESIGN DIMENSION	0.3756 0.3750	0.1300 0.1100	0.3445 0.3425	0.5770 0.5570	0.6970 0.6770	0.5006 0.5000	0.5500 0.5300
REPAIR LIMIT	---	---	---	---	---	---	---

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

146A6557-102 End Fitting Repair and Refinish
Figure 602

BOEING®

COMPONENT MAINTENANCE MANUAL

SNUBBER MECHANISM ASSEMBLY - REPAIR 33-1

146A6562–1, –2

1. General

A. This procedure tells how to replace the parts of snubber mechanism assemblies (225, 230).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices shown in the repair

C. Refer to IPL Figure 4for item numbers.

2. Parts 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 20-50-19	GENERAL SEALING

C. Procedure (REPAIR 33-1, Figure 601)

(1) Remove the sealant from the fasteners.

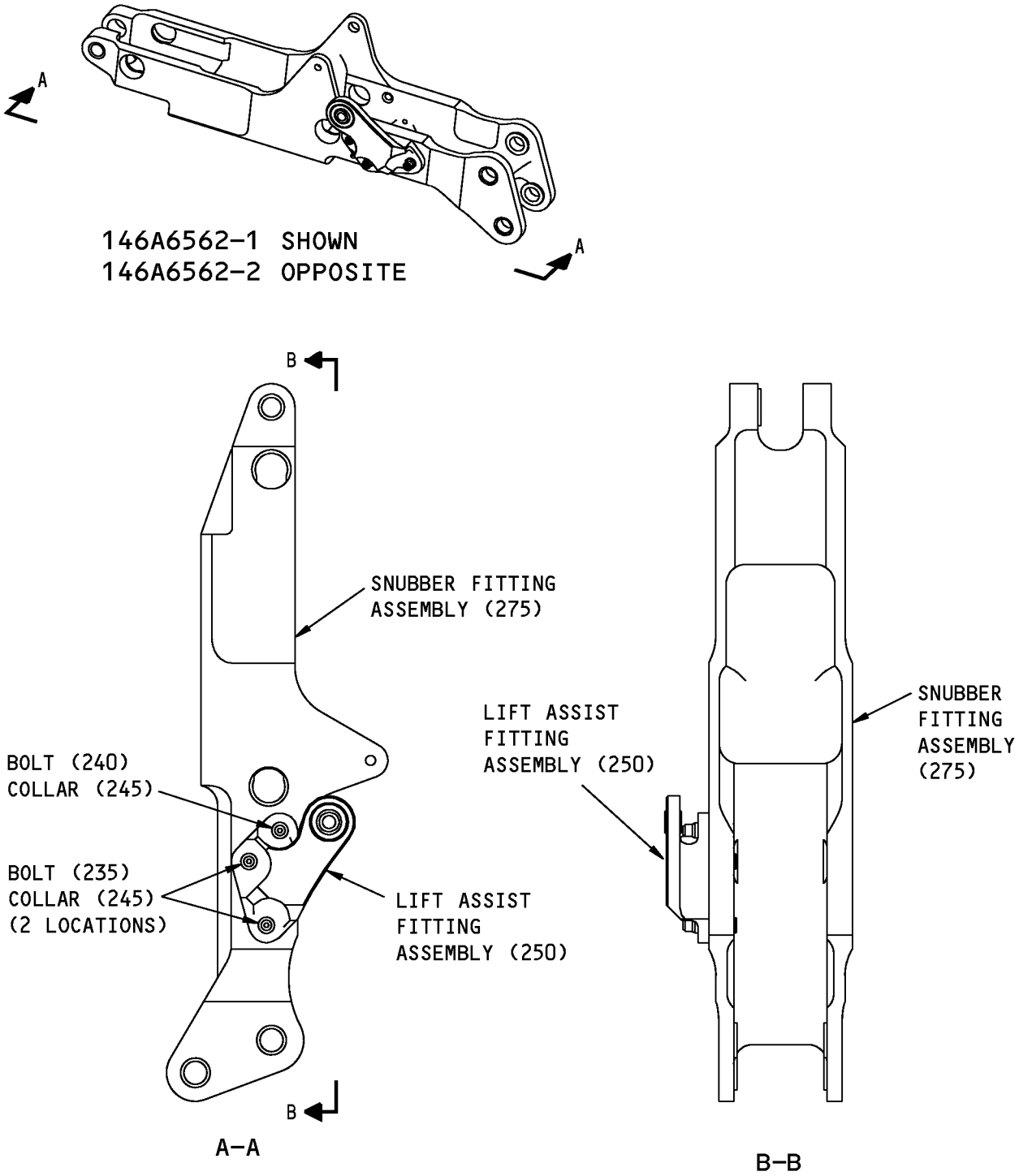
(2) Remove collars (245) and bolts (235, 240).

(3) Remove lift assist fitting assembly (250 or 255) from snubber fitting assembly (275).

(4) If you find defects on the fitting assemblies, refer to REPAIR 26-1 and REPAIR 30-1 for repair instructions.

(5) Install a replacement lift assist fitting assembly (250 or 255) on the snubber fitting assembly (275).

(6) Install bolts (235, 240) and collars (245) with BMS 5-95 sealant, A00247 on mating surfaces (SOPM 20-50-19, Method 2).



146A6562-1,-2 Snubber Mechanism Assembly Parts Replacement
Figure 601

LOCK SHAFT IDLER ASSEMBLY - REPAIR 34-1

146A6575–1, –3

1. General

A. This procedure tells how to replace the parts of lock shaft idler assemblies (144, 288).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 3 for item numbers.

2. Bushing Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

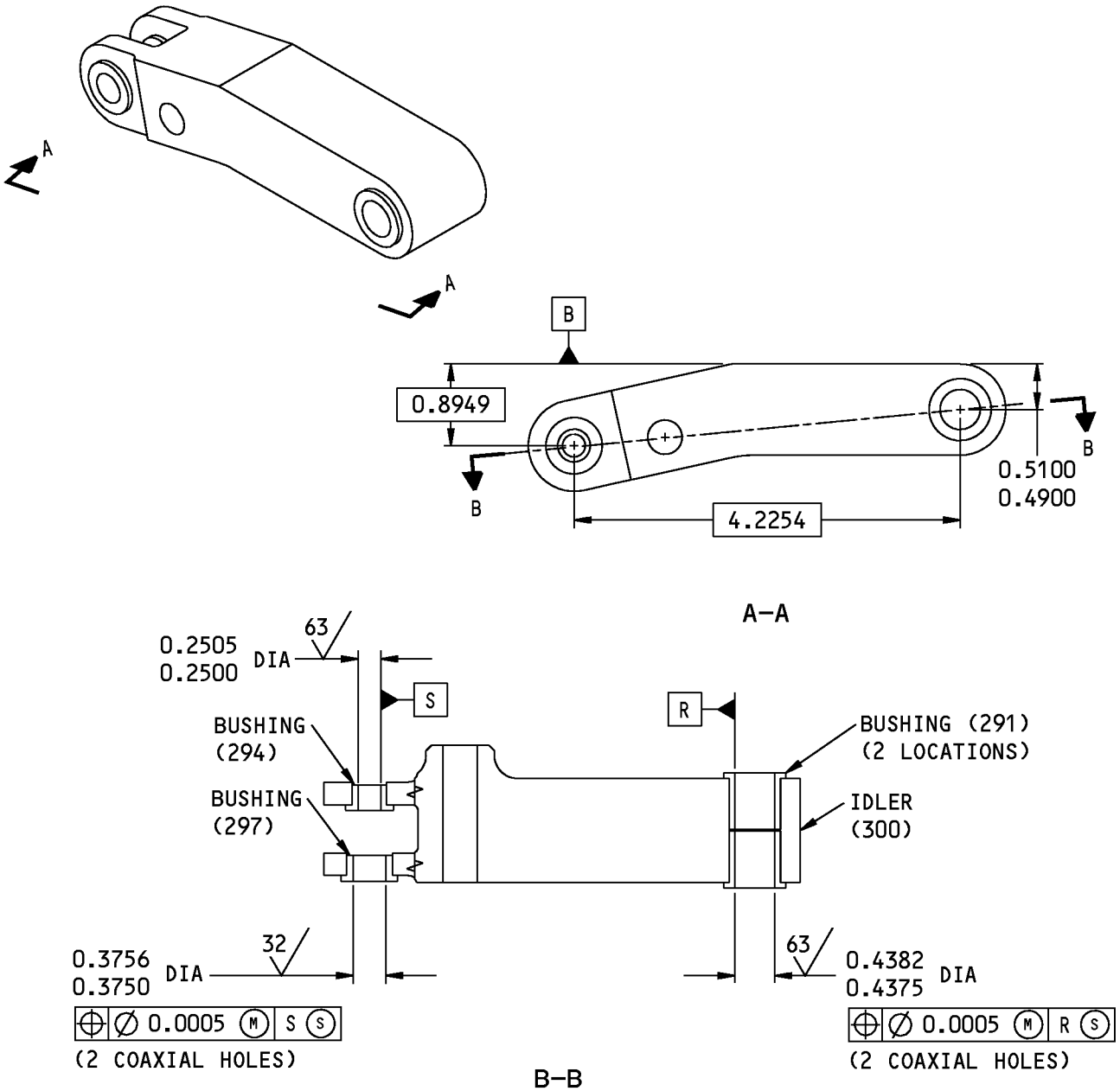
C. Procedure (REPAIR 34-1, Figure 601 or REPAIR 34-1, Figure 602)

(1) Remove the old bushings.

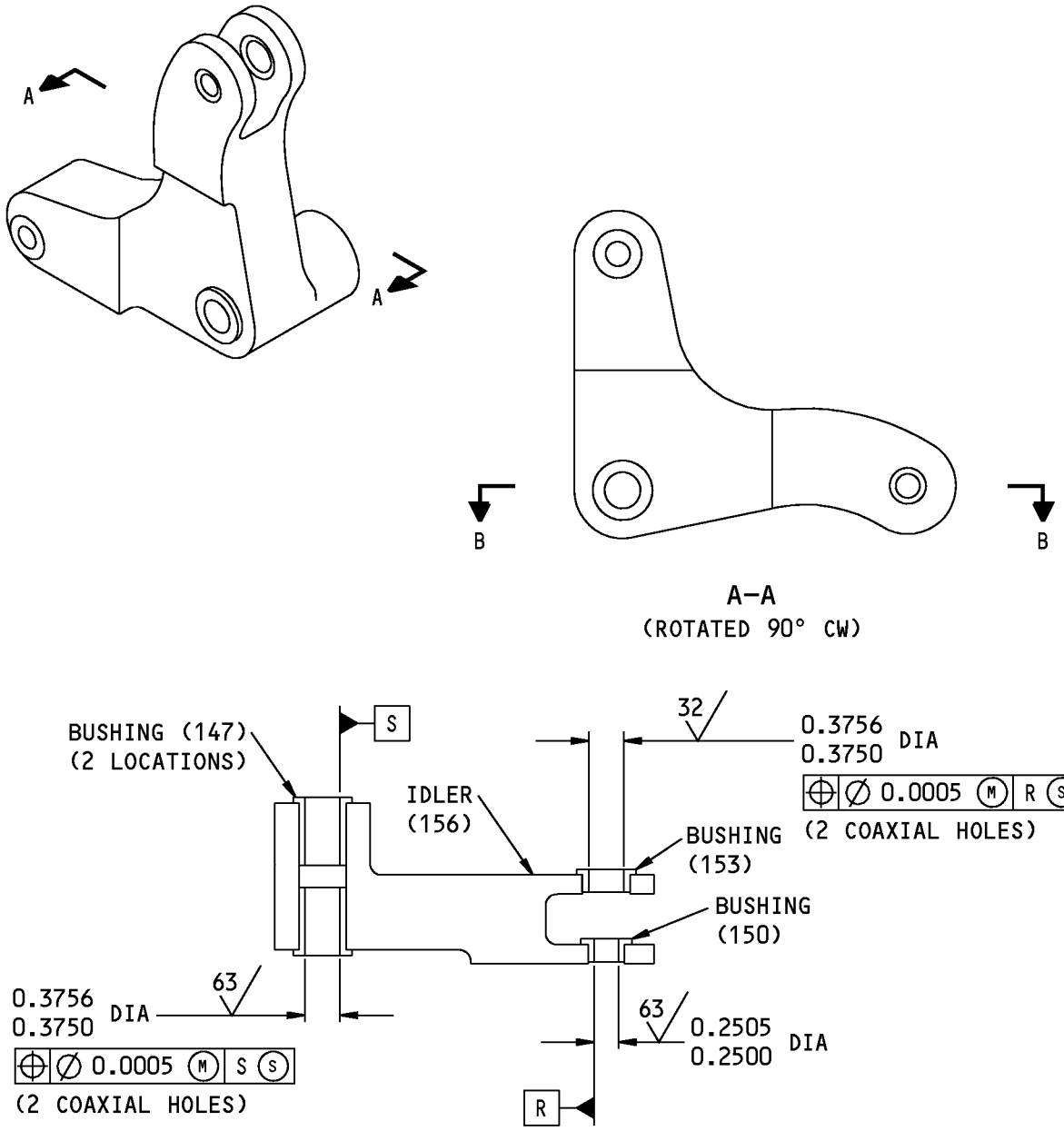
(2) If you find defects on the hole surfaces, refer to REPAIR 34-2 for repair instructions.

(3) Install replacement bushings by the shrink fit method (SOPM 20-50-03) with BMS 5-95 sealant, A00247 as the installation finish.

(4) Machine the bushings to design dimensions and finish.



146A6575-1 Lock Shaft Idler Assembly Bushing Replacement
Figure 601



146A6575-3 Lock Shaft Idler Assembly Bushing Replacement
Figure 602

LOCK SHAFT IDLER - REPAIR 34-2

146A6575–101, –103

1. General

A. This procedure tells how to repair and refinish idlers (156, 300).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 3 for item numbers.

D. General repair details:

(1) Material: 15-5PH CRES, 180-200 ksi

(2) Shot peen: not necessary

2. Idler Repair

A. Procedure (REPAIR 34-2, Figure 601 or REPAIR 34-2, Figure 602))

(1) Repair is only replacement of the original finish. Refer to REPAIR 34-2, Paragraph 3. below for details.

(2) If you think there are defects on important surfaces, see REPAIR 34-2, Figure 601 or REPAIR 34-2, Figure 602 for dimension details.

3. Idler Refinish

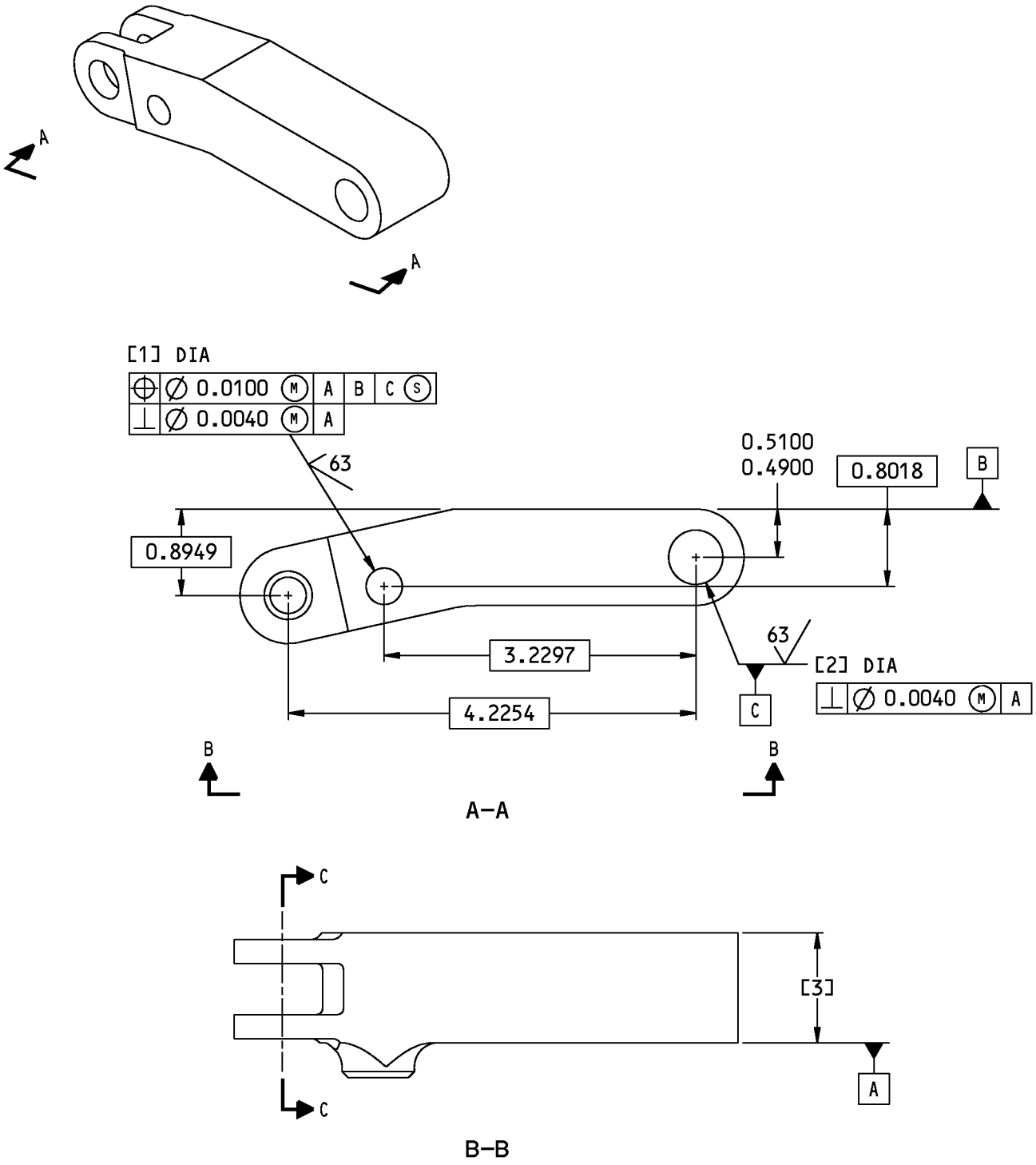
A. References

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

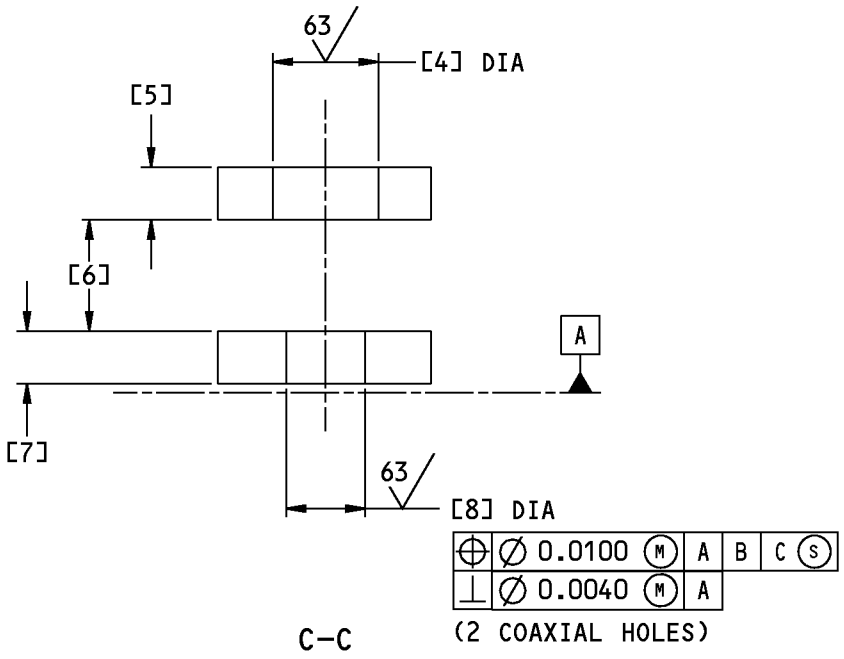
B. Procedure

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.

(1) Passivate (F-17.25).



146A6575-101 Lock Shaft Idler Repair and Refinish
Figure 601 (Sheet 1 of 2)



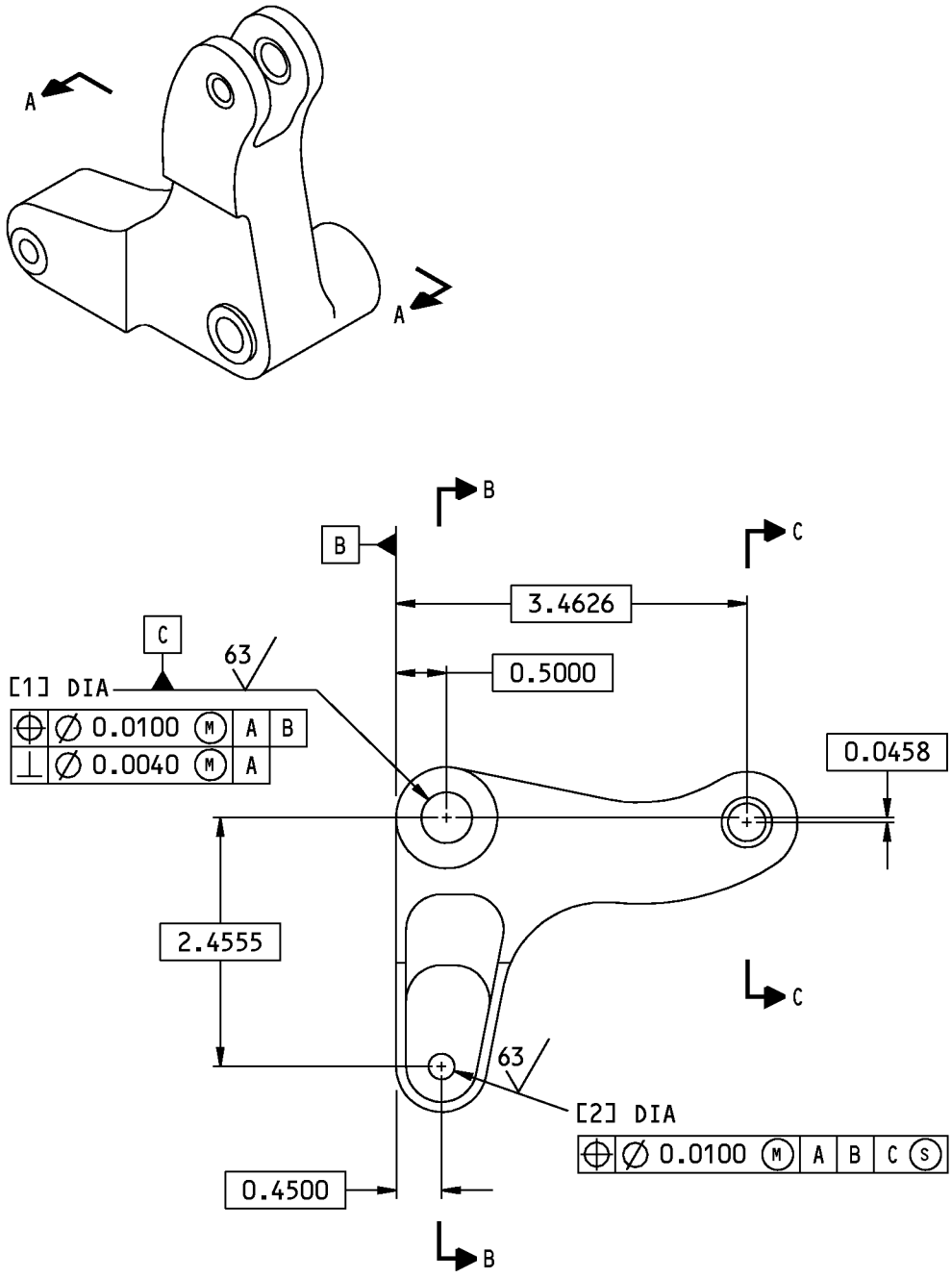
REFERENCE NUMBER	[1]	[2]	[3]	[4]	[5]	[6]	[7]	[8]
DESIGN DIMENSION	0.3773 0.3767	0.5631 0.5625	1.1500 1.1300	0.5006 0.5000	0.2600 0.2400	0.5370 0.5170	0.2600 0.2400	0.3756 0.3750
REPAIR LIMIT	---	---	---	---	---	---	---	---

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

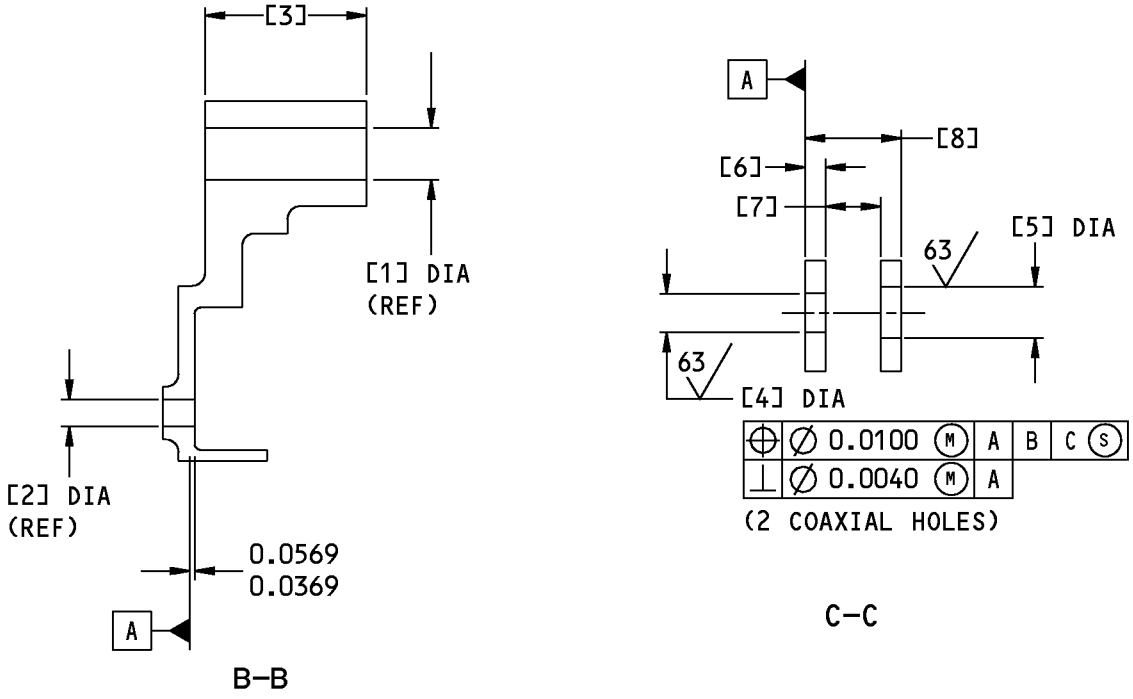
BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

146A6575-101 Lock Shaft Idler Repair and Refinish
Figure 601 (Sheet 2 of 2)



146A6575-103 Lock Shaft Idler Repair and Refinish
Figure 602 (Sheet 1 of 2)



REFERENCE NUMBER	[1]	[2]	[3]	[4]	[5]	[6]	[7]	[8]
DESIGN DIMENSION	0.5006 0.5000	0.2540 0.2500	1.5400 1.5200	0.3756 0.3750	0.5006 0.5000	0.2100 0.1900	0.5370 0.5170	0.9370 0.9170
REPAIR LIMIT	---	---	---	---	---	---	---	---

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

146A6575-103 Lock Shaft Idler Repair and Refinish
Figure 602 (Sheet 2 of 2)

LOCK FITTING ASSEMBLY - REPAIR 35-1

146A6576–1, –3

1. General

A. This procedure tells how to replace the parts of lock fitting assemblies (159, 303).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 3 for item numbers.

2. Bushing Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

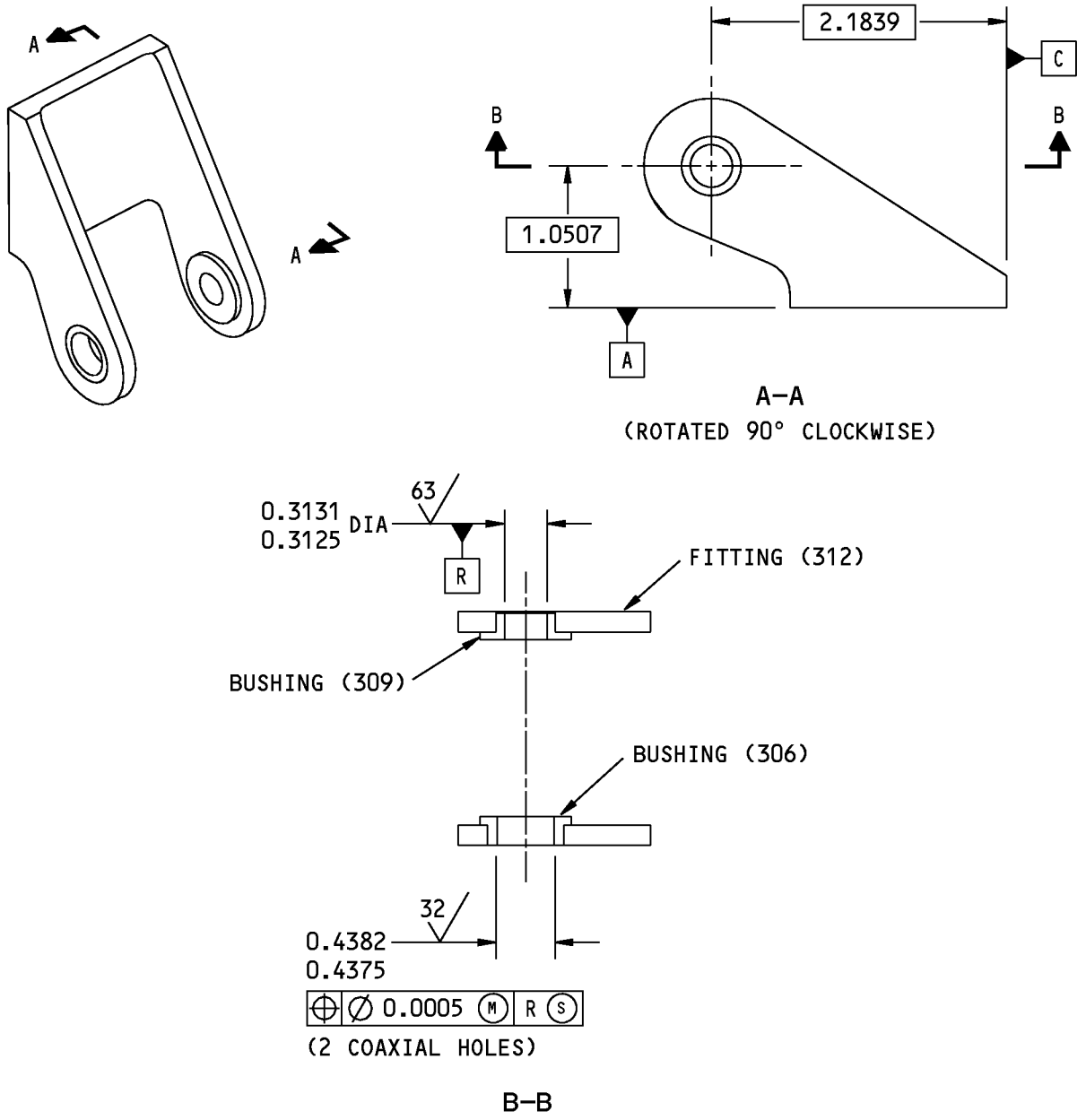
C. Procedure (REPAIR 35-1, Figure 601 or REPAIR 35-1, Figure 602)

(1) Remove the old bushings.

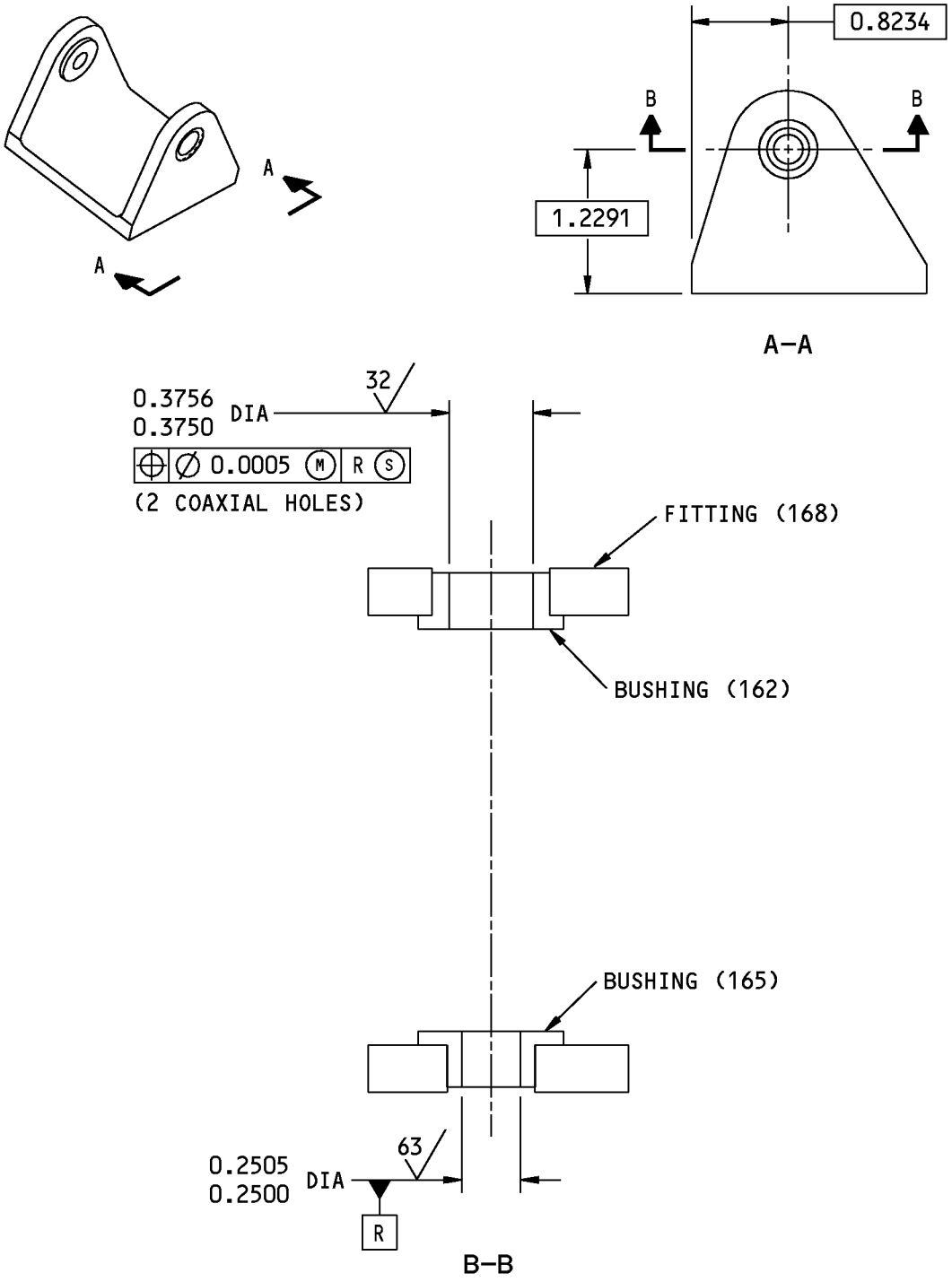
(2) If you find defects on the hole surfaces, refer to REPAIR 35-2 for repair instructions.

(3) Install replacement bushings by the shrink fit method (SOPM 20-50-03) with BMS 5-95 sealant, A00247 as the installation finish.

(4) Machine the bushings to design dimensions and finish.



146A6576-1 Lock Fitting Assembly Bushing Replacement
Figure 601



146A6576-3 Lock Fitting Assembly Bushing Replacement
Figure 602

LOCK FITTING - REPAIR 35-2

146A6576–101, –103

1. General

A. This procedure tells how to repair and refinish fittings (168, 312).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 3 for item numbers.

D. General repair details:

(1) Material: 15-5PH CRES, 180-200 ksi

(2) Shot peen: not necessary

2. Fitting Repair

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

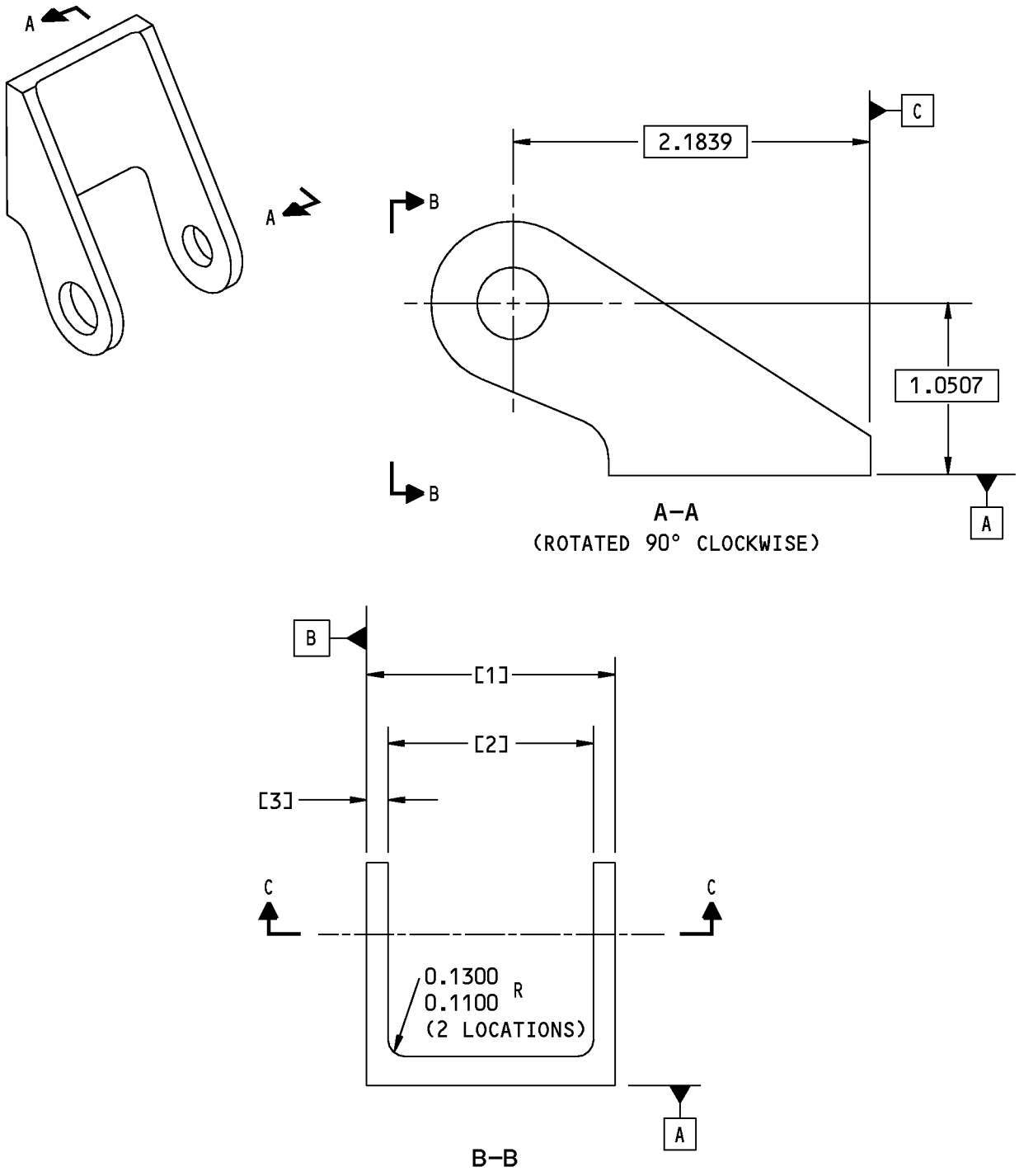
Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES

C. Procedure (REPAIR 35-2, Figure 601 or REPAIR 35-2, Figure 602)

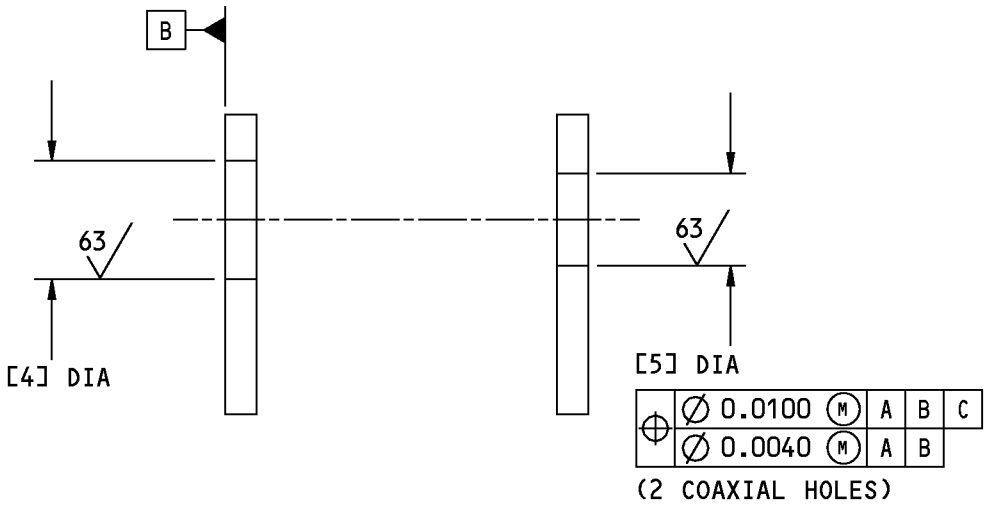
NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01.

(1) (1) Cadmium plate (F-16.06), but not in holes for bushings.

(2) (2) Apply BMS 10-11, Type 1 primer, C00259 (F-20.03), but not in holes for bushings.



146A6576-101 Lock Fitting Repair and Refinish
Figure 601 (Sheet 1 of 2)



C–C

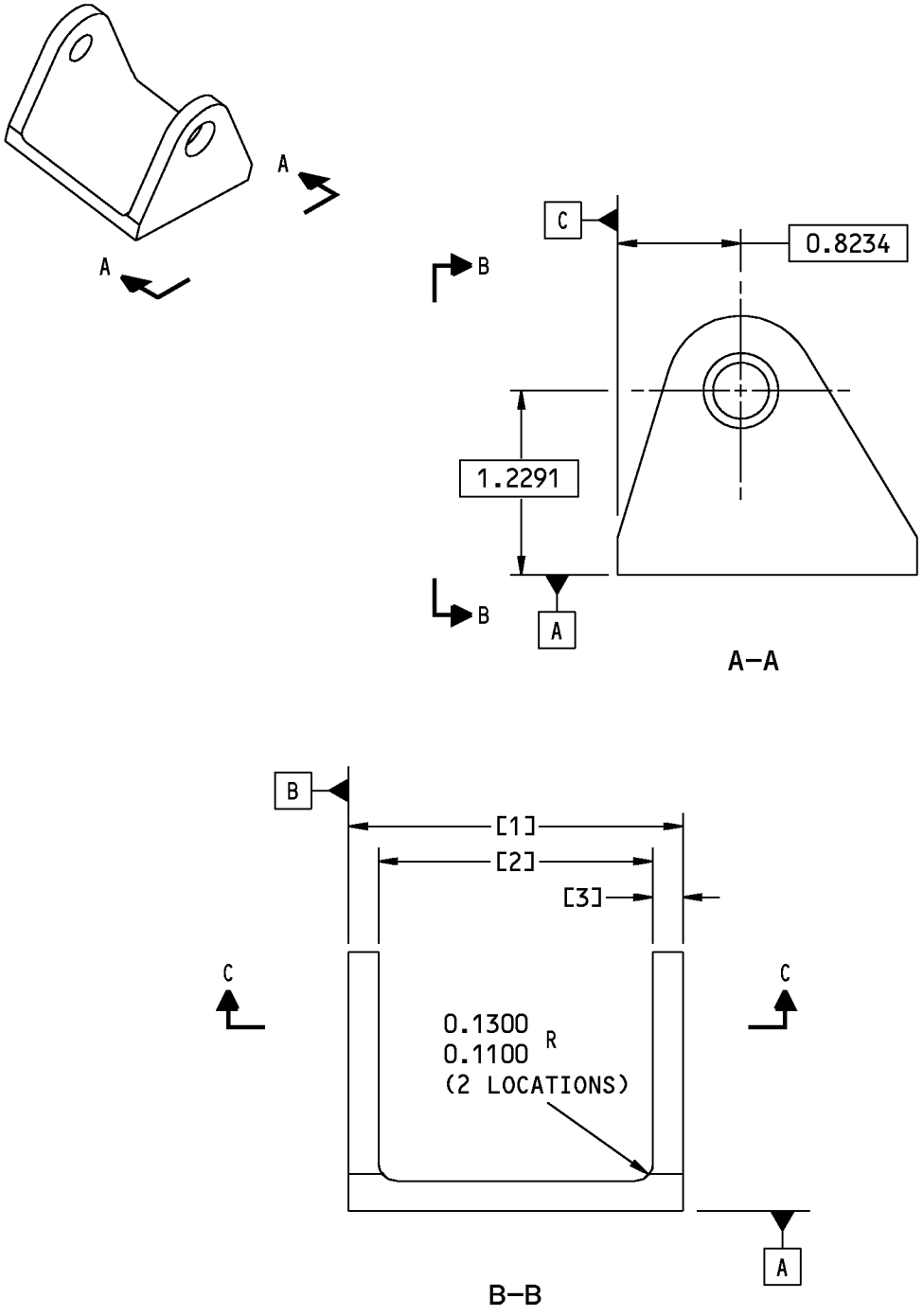
REFERENCE NUMBER	[1]	[2]	[3]	[4]	[5]
DESIGN DIMENSION	1.7400 1.7200	1.4400 1.4200	0.1600 0.1400	0.5631 0.5625	0.4381 0.4375
REPAIR LIMIT	---	---	---	---	---

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

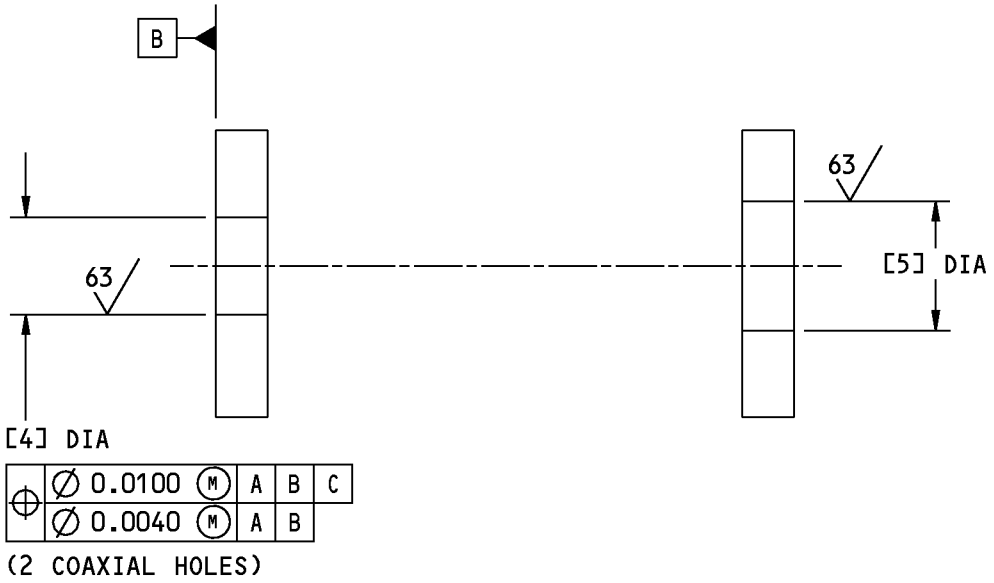
BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

146A6576-101 Lock Fitting Repair and Refinish
Figure 601 (Sheet 2 of 2)



146A6576-103 Lock Fitting Repair and Refinish
Figure 602 (Sheet 1 of 2)



C–C

REFERENCE NUMBER	[1]	[2]	[3]	[4]	[5]
DESIGN DIMENSION	2.2400 2.2200	1.8400 1.8200	0.2100 0.1900	0.3756 0.3750	0.5006 0.5000
REPAIR LIMIT	---	---	---	---	---

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

146A6576-103 Lock Fitting Repair and Refinish
Figure 602 (Sheet 2 of 2)

OVERCENTER SPRING FITTING ASSEMBLY - REPAIR 36-1

146A6577–1, –3

1. General

A. This procedure tells how to replace the parts of lift assist fitting assemblies (120, 129).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 3 for item numbers.

2. Bearing Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

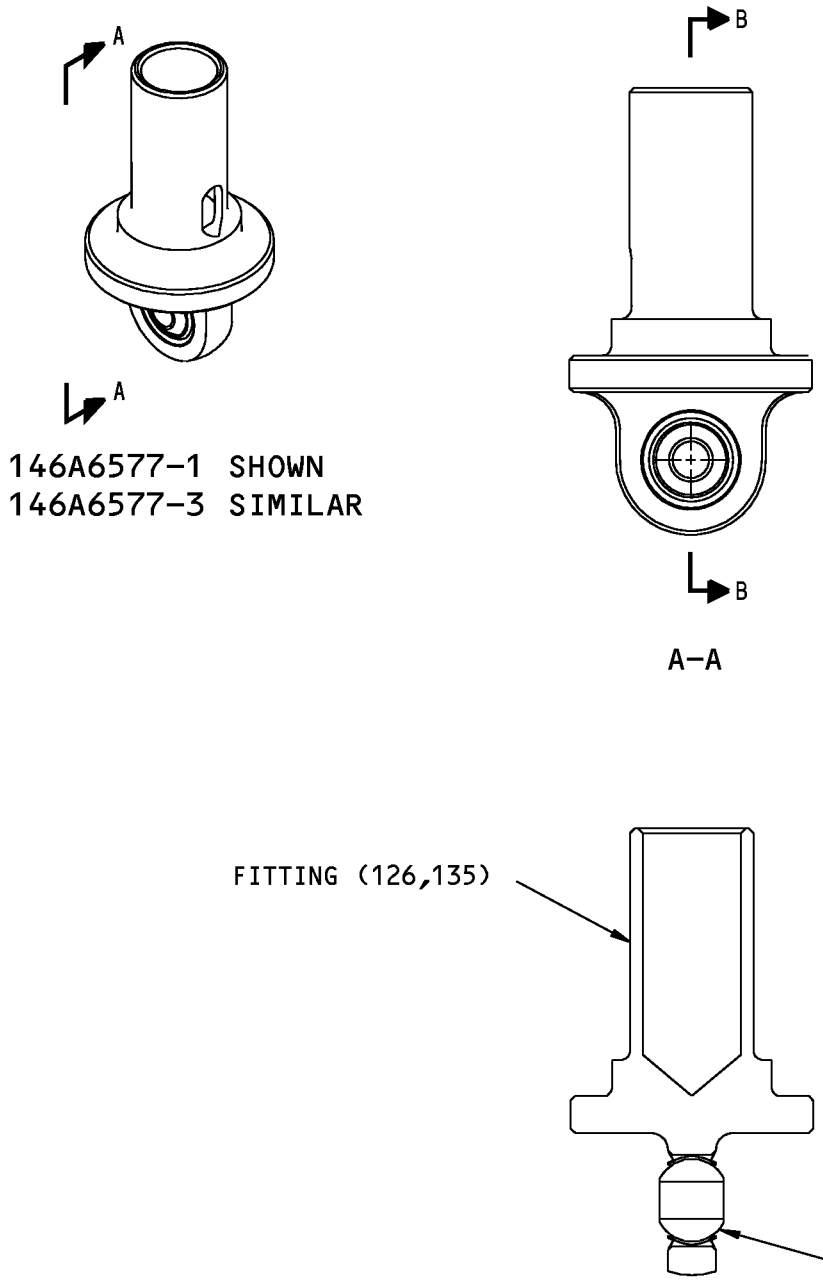
C. Procedure (REPAIR 36-1, Figure 601)

(1) Remove the old bearing.

(2) If you find defects on the hole surfaces, refer to REPAIR 36-2 for repair instructions.

(3) Install a replacement bearing and roller swage it (SOPM 20-50-03) with BMS 5-95 sealant, A00247 as the installation finish.

(4) Give the bearing an 1150-pound push-out proof load test.



ITEM NUMBERS REFER TO IPL FIG. 3

146A6577-1,-3 Overcenter Spring Fitting Assembly Bearing Replacement
Figure 601

OVERCENTER SPRING FITTING - REPAIR 36-2

146A6577–101, –103

1. General

A. This procedure tells how to repair and refinish fittings (126, 135).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 3 for item numbers.

D. General repair details:

(1) Material (146A6577-101): 15-5PH CRES, 180-200 ksi

(2) Material (146A6577-103): Al-Ni-Bronze

(3) Shot peen: not necessary

2. Fitting Repair

A. Procedure (REPAIR 36-2, Figure 601 or REPAIR 36-2, Figure 602)

(1) Repair is only replacement of the original finish. Refer to REPAIR 36-2, Paragraph 3. below for details.

(2) If you think there are defects on important surfaces, see REPAIR 36-2, Figure 601 or REPAIR 36-2, Figure 602 for dimension details.

3. Fitting Refinish

A. References

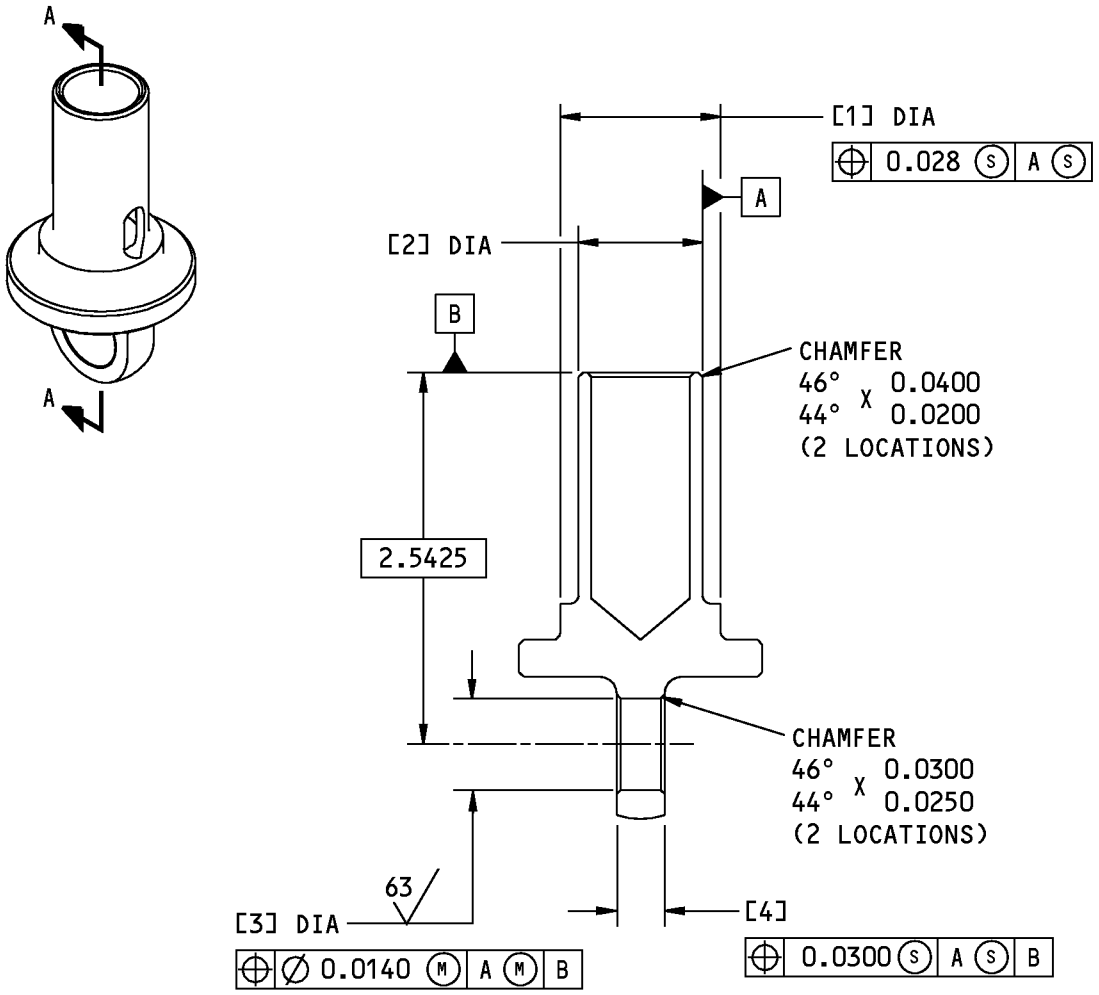
Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES

B. Procedure (REPAIR 36-2, Figure 601 or REPAIR 36-2, Figure 602)

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.

(1) 146A6577-101: No finish (F-25.01).

(2) 146A6577-103: Passivate (F-17.25).



A–A

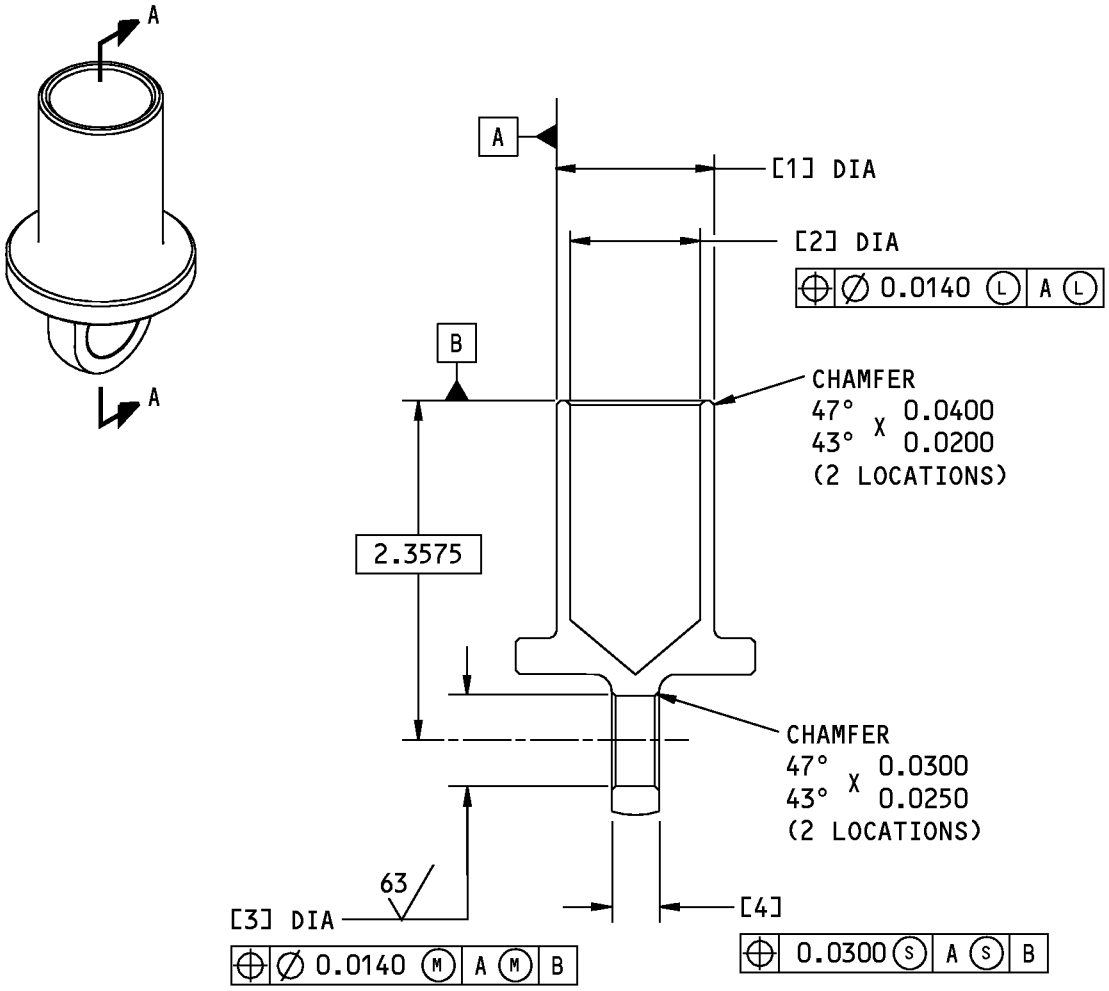
REFERENCE NUMBER	[1]	[2]	[3]	[4]
DESIGN DIMENSION	1.0950 1.0700	0.8450 0.8200	0.6260 0.6250	0.3270 0.3170
REPAIR LIMIT	—	—	—	—

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

146A6577-101 Overcenter Spring Fitting Repair and Refinish
Figure 601



A–A

REFERENCE NUMBER	[1]	[2]	[3]	[4]
DESIGN DIMENSION	1.0950 1.0700	0.9000 0.8750	0.6260 0.6250	0.3270 0.3170
REPAIR LIMIT	—	—	—	—

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

146A6577-103 Overcenter Spring Fitting Repair and Refinish
Figure 602

LINK ASSEMBLY - REPAIR 37-1

146A6578–1

1. General

A. This procedure tells how to replace the parts of link assembly (315).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 3 for item numbers.

2. Bearing Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

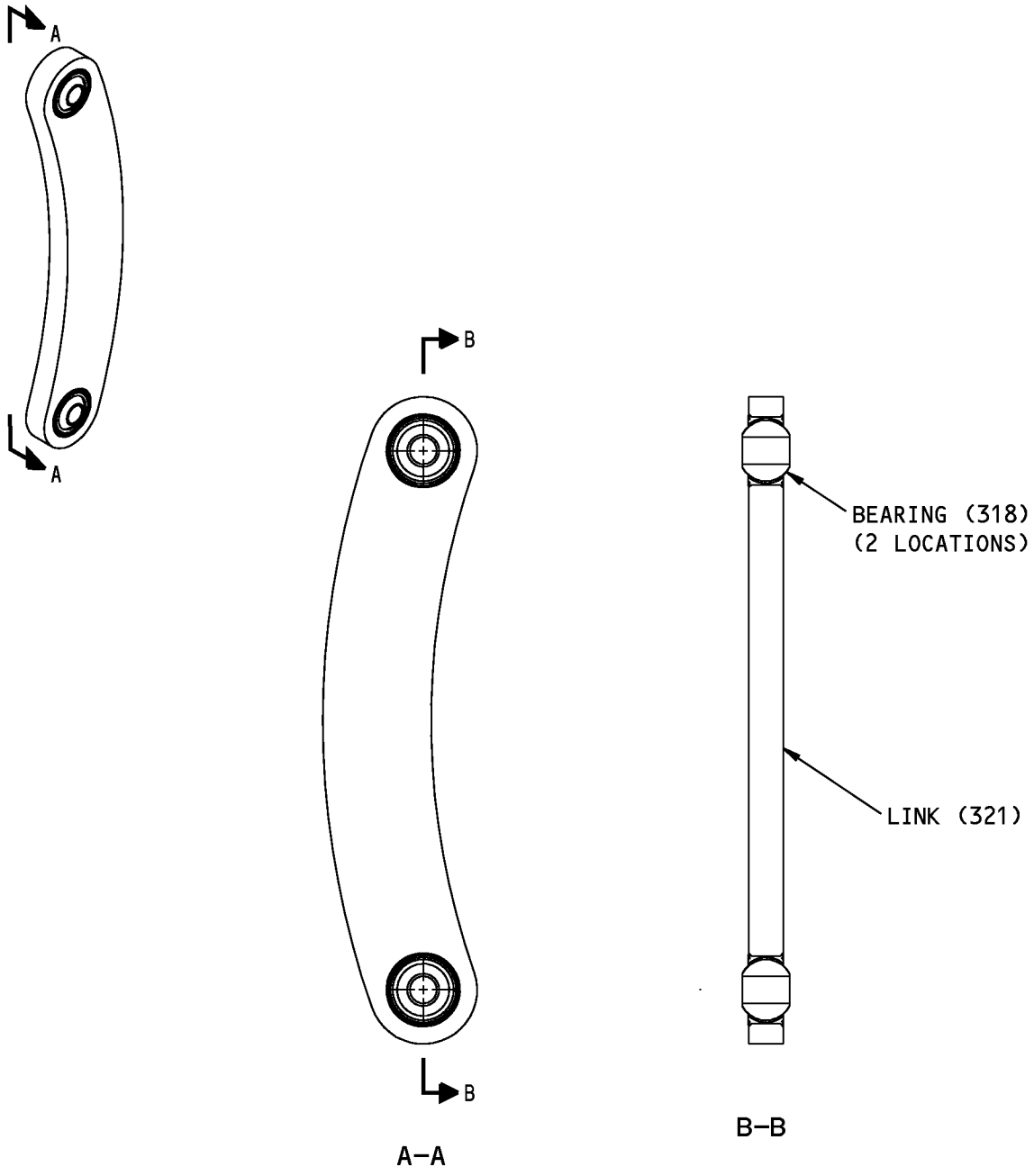
C. Procedure (REPAIR 37-1, Figure 601)

(1) Remove the old bearing.

(2) If you find defects on the hole surfaces, refer to REPAIR 37-2 for repair instructions.

(3) Install a replacement bearing and roller swage it (SOPM 20-50-03) with BMS 5-95 sealant, A00247 as the installation finish.

(4) Give the bearing a 1050-pound push-out proof load test.



ITEM NUMBERS REFER TO IPL FIG. 3

146A6578-1 Link Assembly Bearing Replacement
Figure 601

LINK - REPAIR 37-2

146A6578–101

1. General

A. This procedure tells how to repair and refinish link (321).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 3 for item numbers.

D. General repair details:

(1) Material: Al alloy

(2) Shot peen: not necessary

2. Link Repair

A. Procedure (REPAIR 37-2, Figure 601)

(1) Repair is only replacement of the original refinish. Refer to REPAIR 37-2, Paragraph 3. for details.

(2) If you think there are defects on important surfaces, see REPAIR 37-2, Figure 601 for dimension details.

3. Link 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

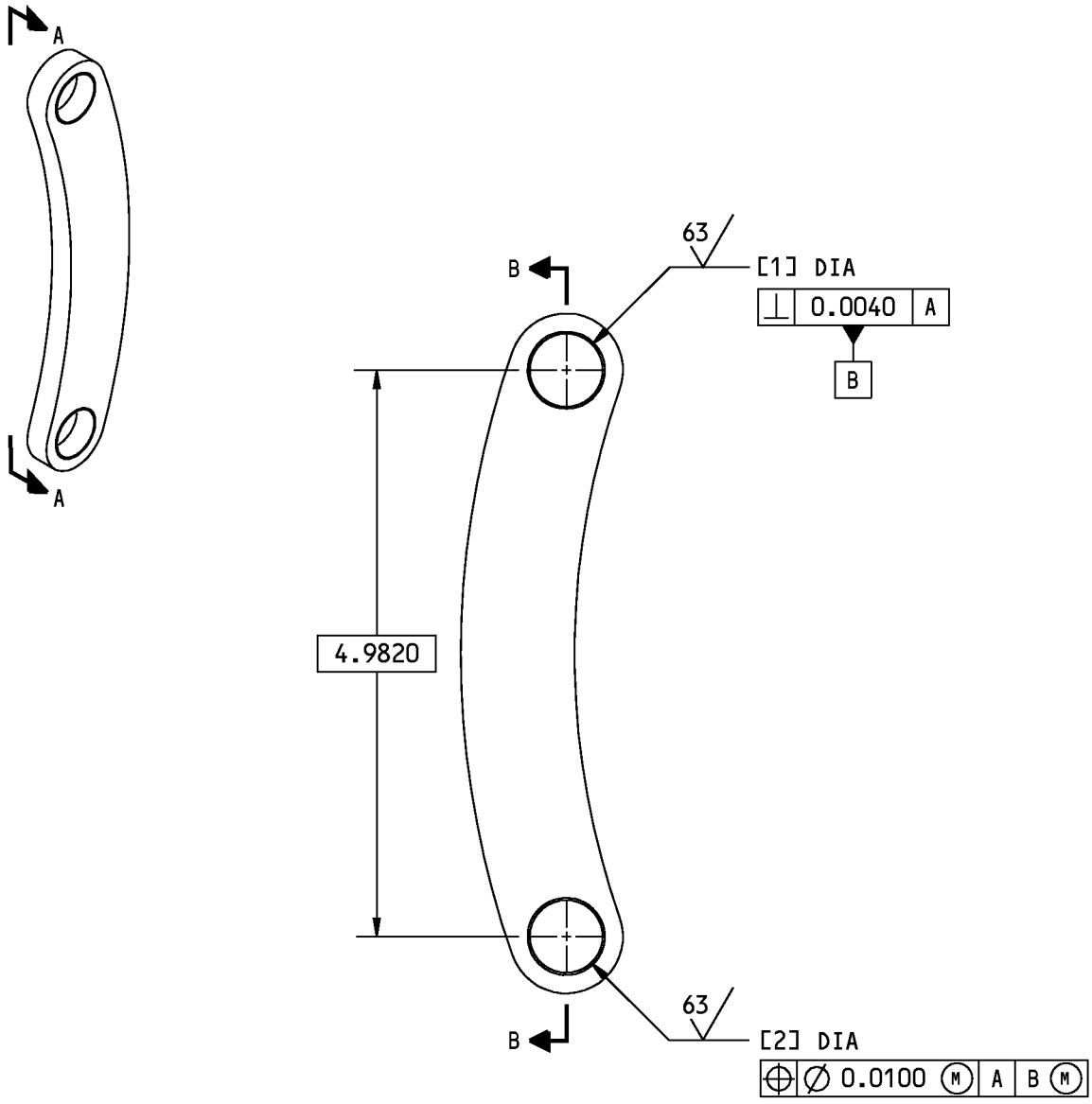
Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES

C. Procedure (REPAIR 37-2, Figure 601)

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

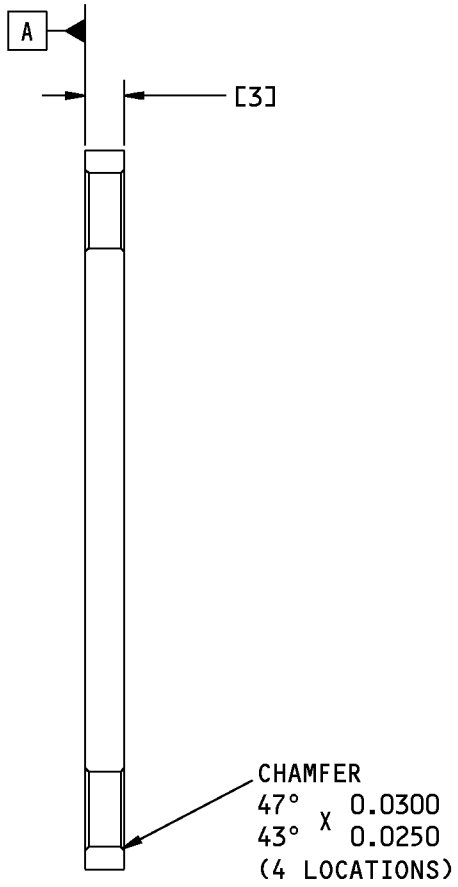
(1) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31) all over.

(2) Apply BMS 10-11, Type 1 primer, C00259 (F-20.03) but not in the holes for the bearings.



A–A

146A6578-101 Link Repair and Refinish
Figure 601 (Sheet 1 of 2)



B–B

REFERENCE NUMBER	[1]	[2]	[3]
DESIGN DIMENSION	0.6260 0.6250	0.6260 0.6250	0.3270 0.3170
REPAIR LIMIT	—	—	—

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

146A6578-101 Link Repair and Refinish
Figure 601 (Sheet 2 of 2)

LOCK TARGET ASSEMBLY - REPAIR 38-1

146A6579–1

1. General

A. This procedure tells how to replace the parts of lock target assembly (199).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 3 for item numbers.

2. Bushing Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

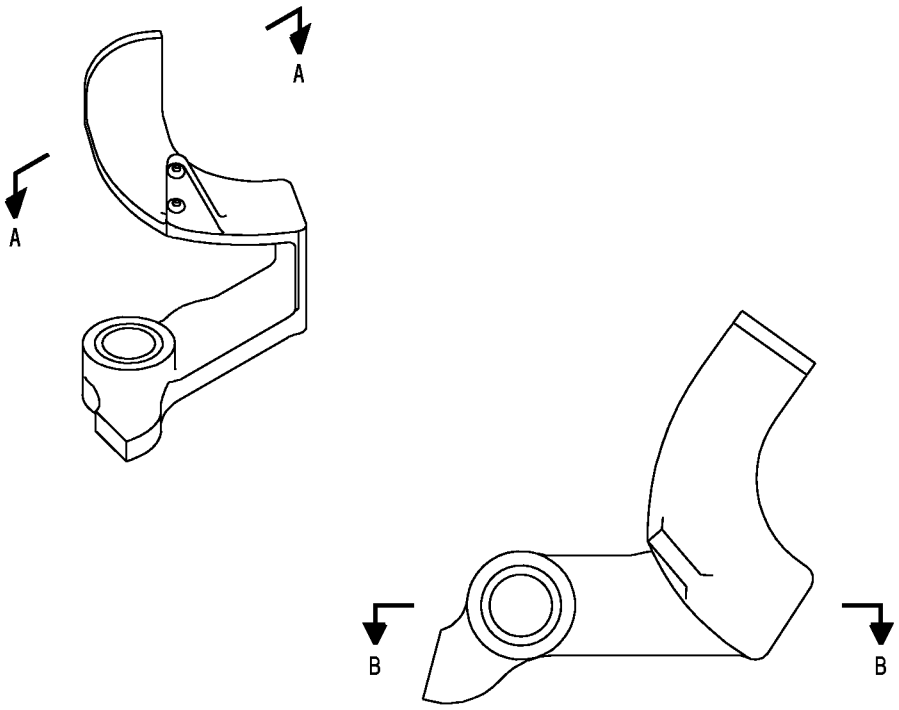
C. Procedure (REPAIR 38-1, Figure 601)

(1) Remove the old bushing.

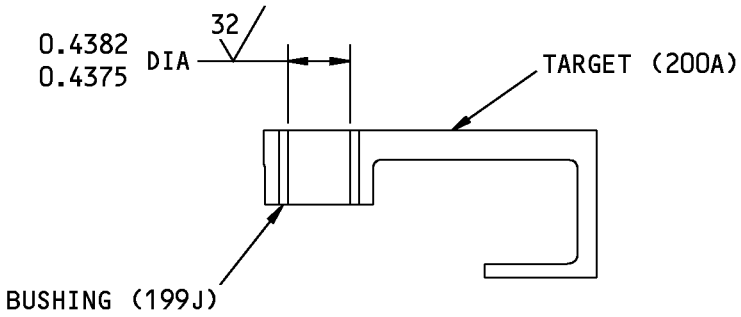
(2) If you find defects on the hole surfaces, refer to REPAIR 38-2 for repair instructions.

(3) Install a replacement bushing by the shrink fit method (SOPM 20-50-03) with BMS 5-95 sealant, A00247 as the installation finish

(4) Machine the bushing to design dimensions and finish. Be careful, because this bushing has a self-lubricating liner.



A–A



B–B

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 3

ALL DIMENSIONS ARE IN INCHES

146A6579-1 Lock Target Assembly Bushing Replacement
Figure 601

LOCK TARGET - REPAIR 38-2

146A6579–101

1. General

A. This procedure tells how to repair and refinish lock target (200A).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 3 for item numbers.

D. General repair details:

(1) Material: 15-5PH CRES, 180-200 ksi

(2) Shot peen: not necessary

2. Target Repair

A. Procedure (REPAIR 38-2, Figure 601)

(1) Repair is only replacement of the original finish. Refer to REPAIR 38-2, Paragraph 3. below for details.

(2) If you think there are defects on important surfaces, see REPAIR 38-2, Figure 601 for dimension details.

3. Target Refinish

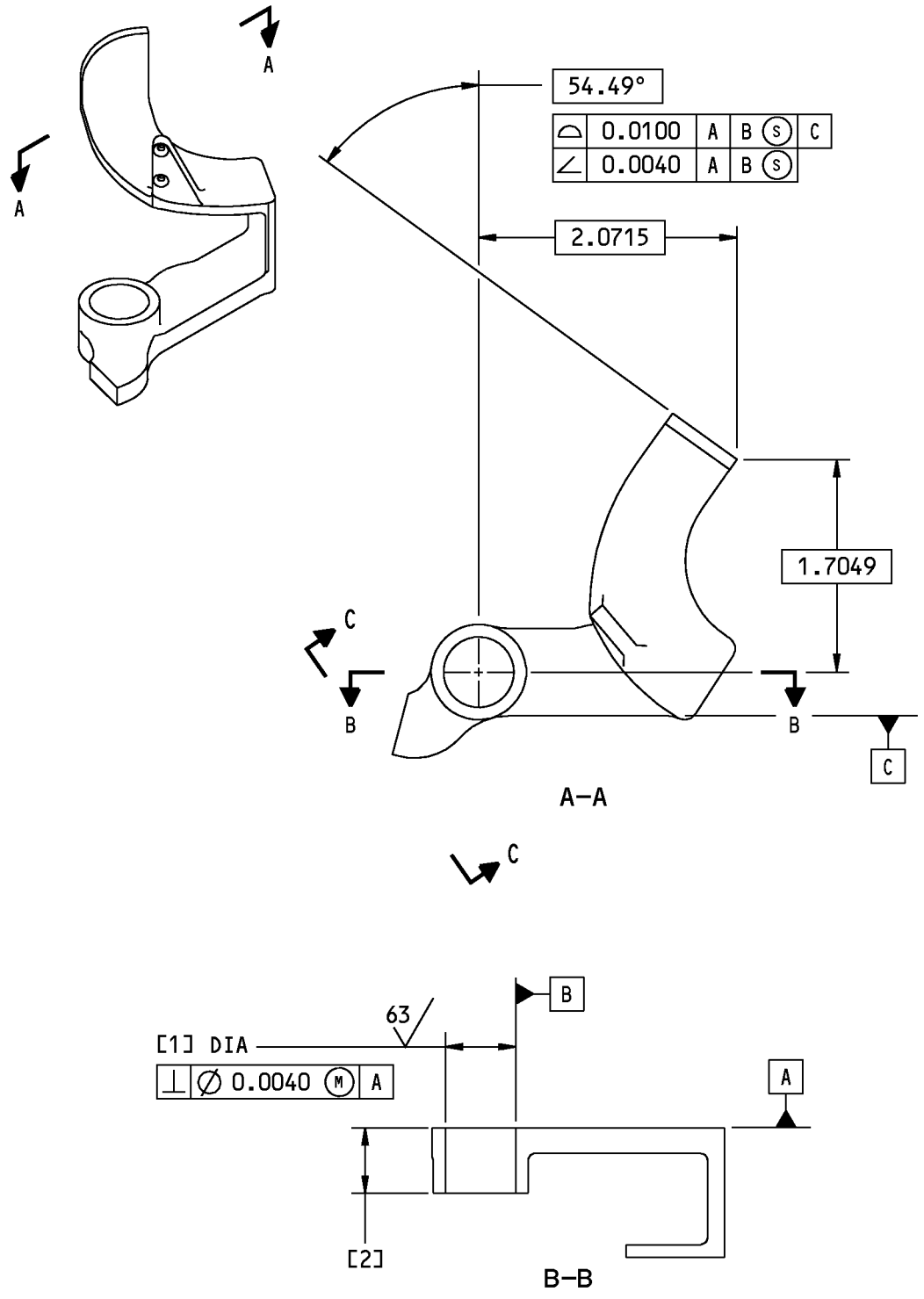
A. References

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

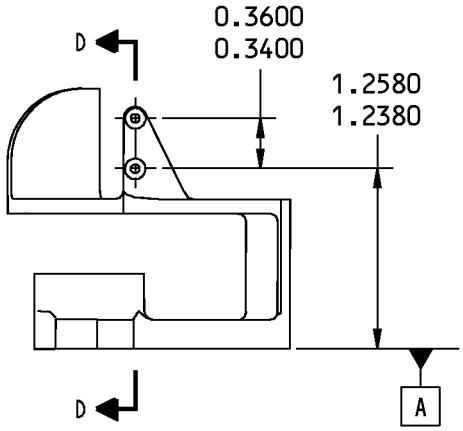
B. Procedure

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.

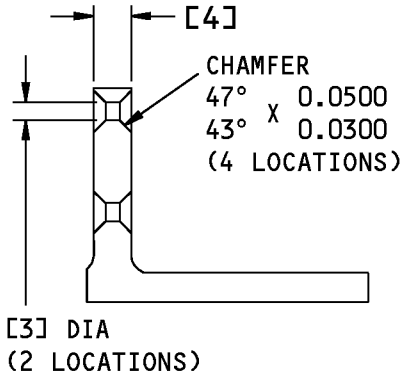
(1) Passivate (F-17.25).



146A6579-101 Lock Target Repair and Refinish
Figure 601 (Sheet 1 of 2)



C–C



D–D

REFERENCE NUMBER	[1]	[2]	[3]	[4]
DESIGN DIMENSION	0.5631 0.5625	0.5300 0.5100	0.0730 0.0530	0.1400 0.1200
REPAIR LIMIT	—	—	—	—

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

146A6579-101 Lock Target Repair and Refinish
Figure 601 (Sheet 2 of 2)

LOCK CAM ASSEMBLY - REPAIR 39-1

146A6580–1, –3

1. General

A. This procedure tells how to replace the parts of lock cam assemblies (90, 231).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 3 for item numbers.

2. Bushing Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

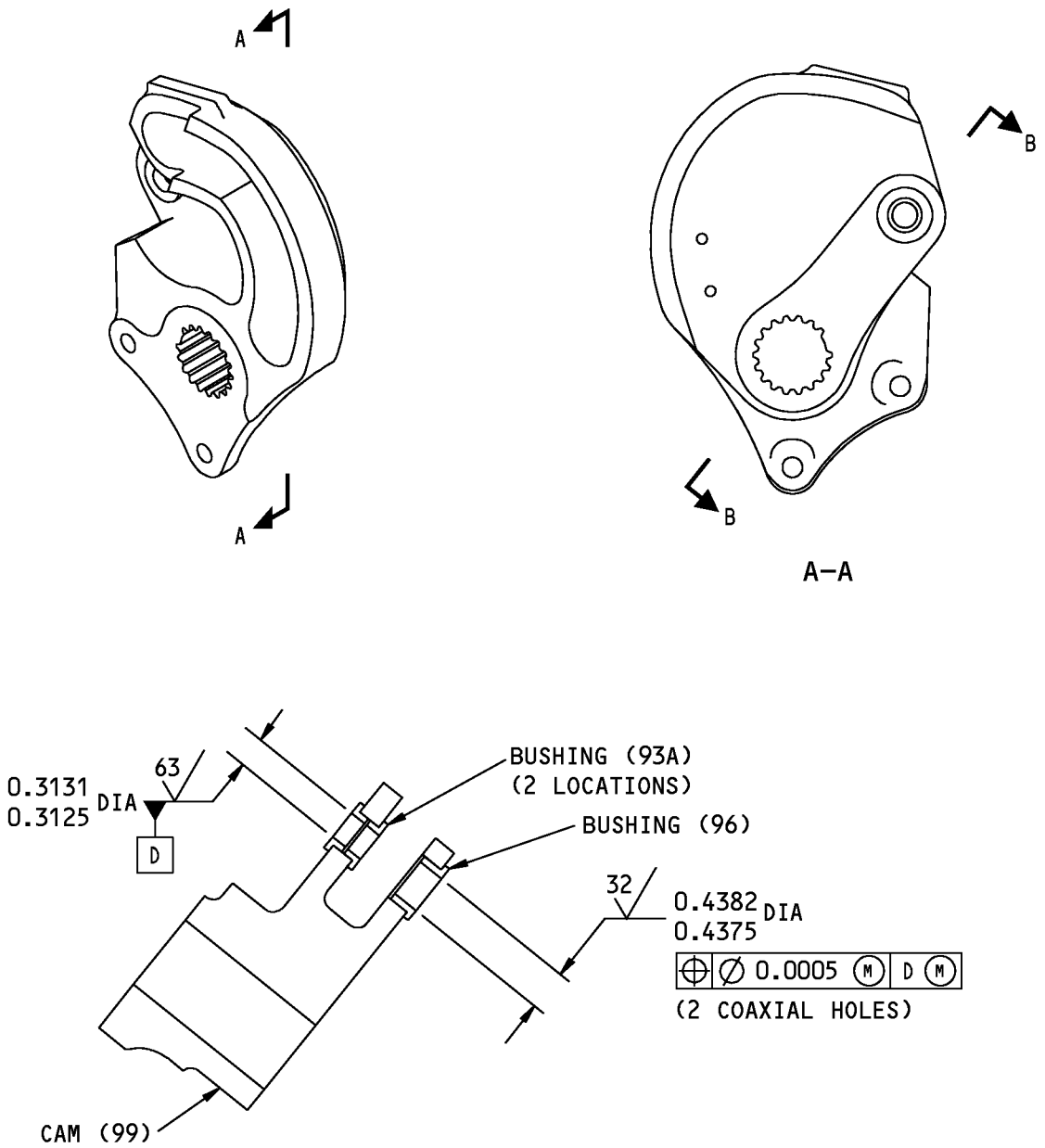
C. Procedure (REPAIR 39-1, Figure 601 or REPAIR 39-1, Figure 602)

(1) Remove the old bushings.

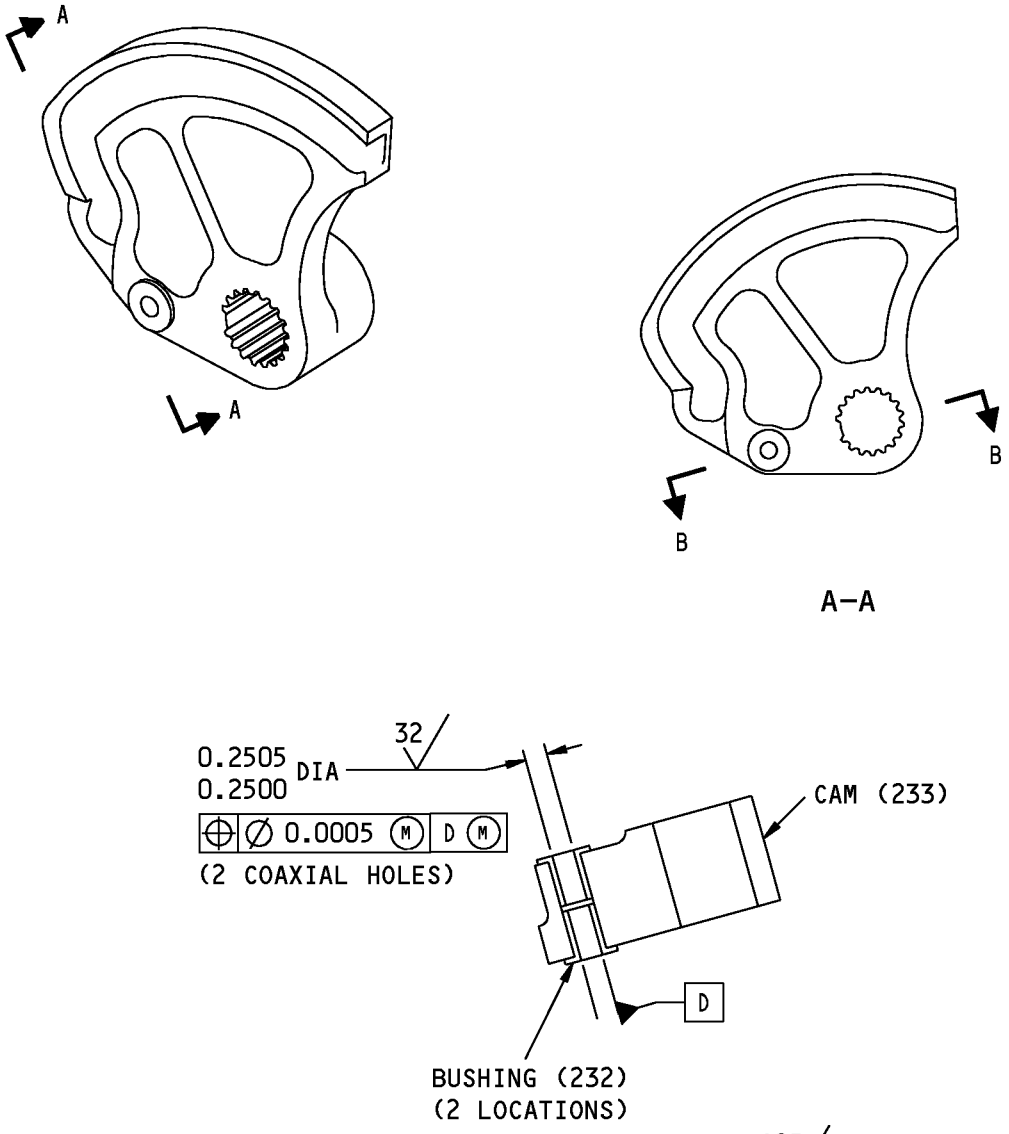
(2) If you find defects on the hole surfaces, refer to REPAIR 39-2 for repair instructions.

(3) Install replacement bushings by the shrink fit method (SOPM 20-50-03) with BMS 5-95 sealant, A00247 as the installation finish.

(4) Machine the bushings to design dimensions and finish.



146A6580-1 Lock Cam Assembly Bushing Replacement
Figure 601



146A6580-3 Lock Cam Assembly Bushing Replacement
Figure 602

LOCK CAM - REPAIR 39-2

146A6580–101, –103

1. General

A. This procedure tells how to repair and refinish lock cams (99, 233).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 3 for item numbers.

D. General repair details:

(1) Material: 15-5PH CRES, 180-200 ksi

(2) Shot peen: not necessary

2. Cam Repair

A. Procedure (REPAIR 39-2, Figure 601 or REPAIR 39-2, Figure 602)

(1) Repair is only replacement of the original finish. Refer to REPAIR 39-2, Paragraph 3. below for details.

(2) If you think there are defects on important surfaces, see REPAIR 39-2, Figure 601 or REPAIR 39-2, Figure 602 for dimension details.

3. Cam Refinish

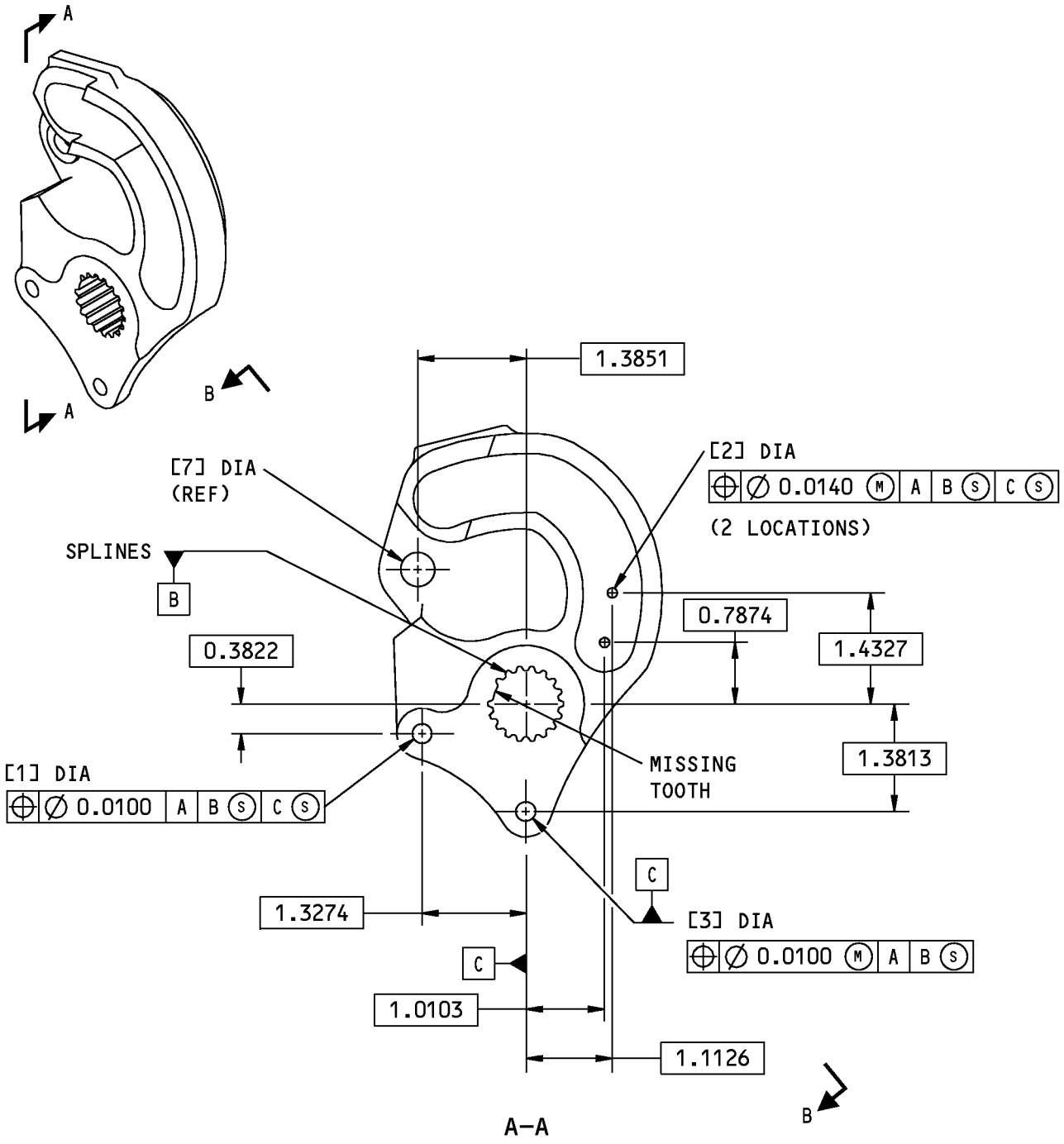
A. References

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

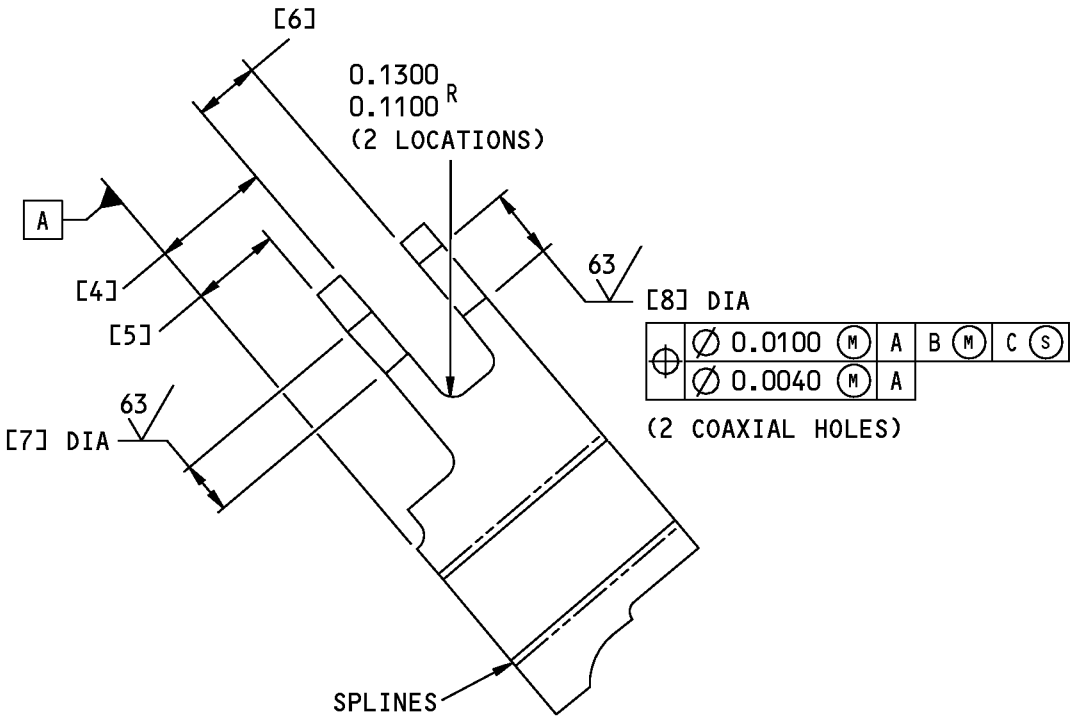
B. Procedure

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.

(1) Passivate (F-17.25).



146A6580-101 Lock Cam Repair and Refinish
Figure 601 (Sheet 1 of 2)



B–B

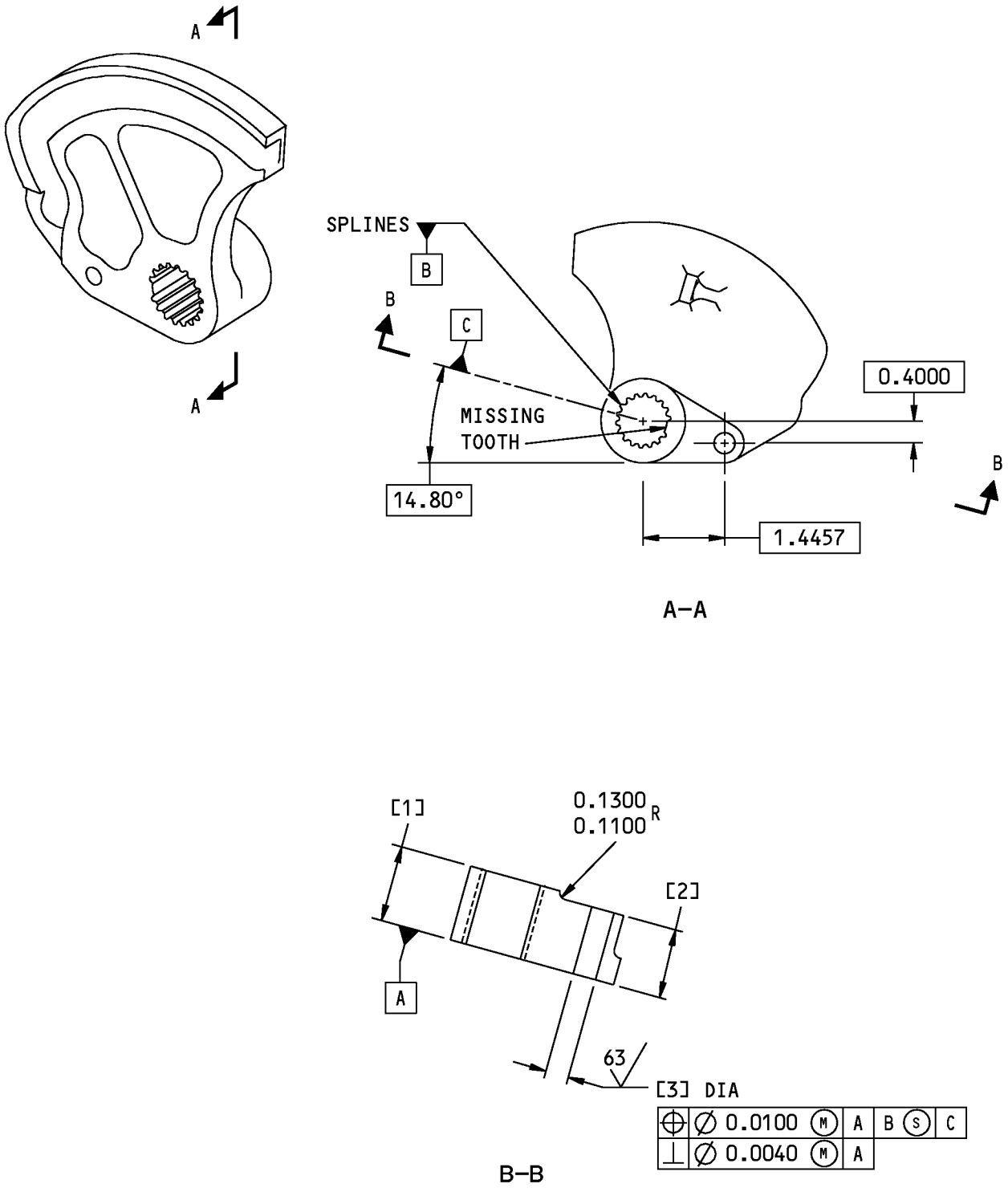
REFERENCE NUMBER	[1]	[2]	[3]	[4]	[5]	[6]	[7]	[8]
DESIGN DIMENSION	0.2540 0.2500	0.1300 0.1260	0.2540 0.2500	0.9665 0.9465	0.7165 0.6965	0.5321 0.5221	0.4381 0.4375	0.5631 0.5625
REPAIR LIMIT	—	—	—	—	—	—	—	—

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

146A6580-101 Lock Cam Repair and Refinish
Figure 601 (Sheet 2 of 2)



146A6580-103 Lock Cam Repair and Refinish
Figure 602 (Sheet 1 of 2)

REFERENCE NUMBER	[1]	[2]	[3]
DESIGN DIMENSION	1.2386 1.2286	1.1310 1.1110	0.3756 0.3750
REPAIR LIMIT	—	—	—

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

146A6580-103 Lock Cam Repair and Refinish
Figure 602 (Sheet 2 of 2)

LOCK SHAFT - REPAIR 40-1

146A6581–1

1. General

A. This procedure tells how to repair and refinish lock shaft (78, IPL Figure 3).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 3 for item numbers.

D. General repair details:

(1) Material: 15-5PH CRES, 180-200 ksi

(2) Shot peen: not necessary

2. Shaft Repair

A. Procedure (REPAIR 40-1, Figure 601)

(1) Repair is only replacement of the original finish. Refer to REPAIR 40-1, Paragraph 3. below for details.

(2) If you think there are defects on important surfaces, see REPAIR 40-1, Figure 601 for dimension details.

3. Shaft Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
D50081	Lubricant - Solid Film Lubricant, Liquid Dispersed	BMS 3-8

B. References

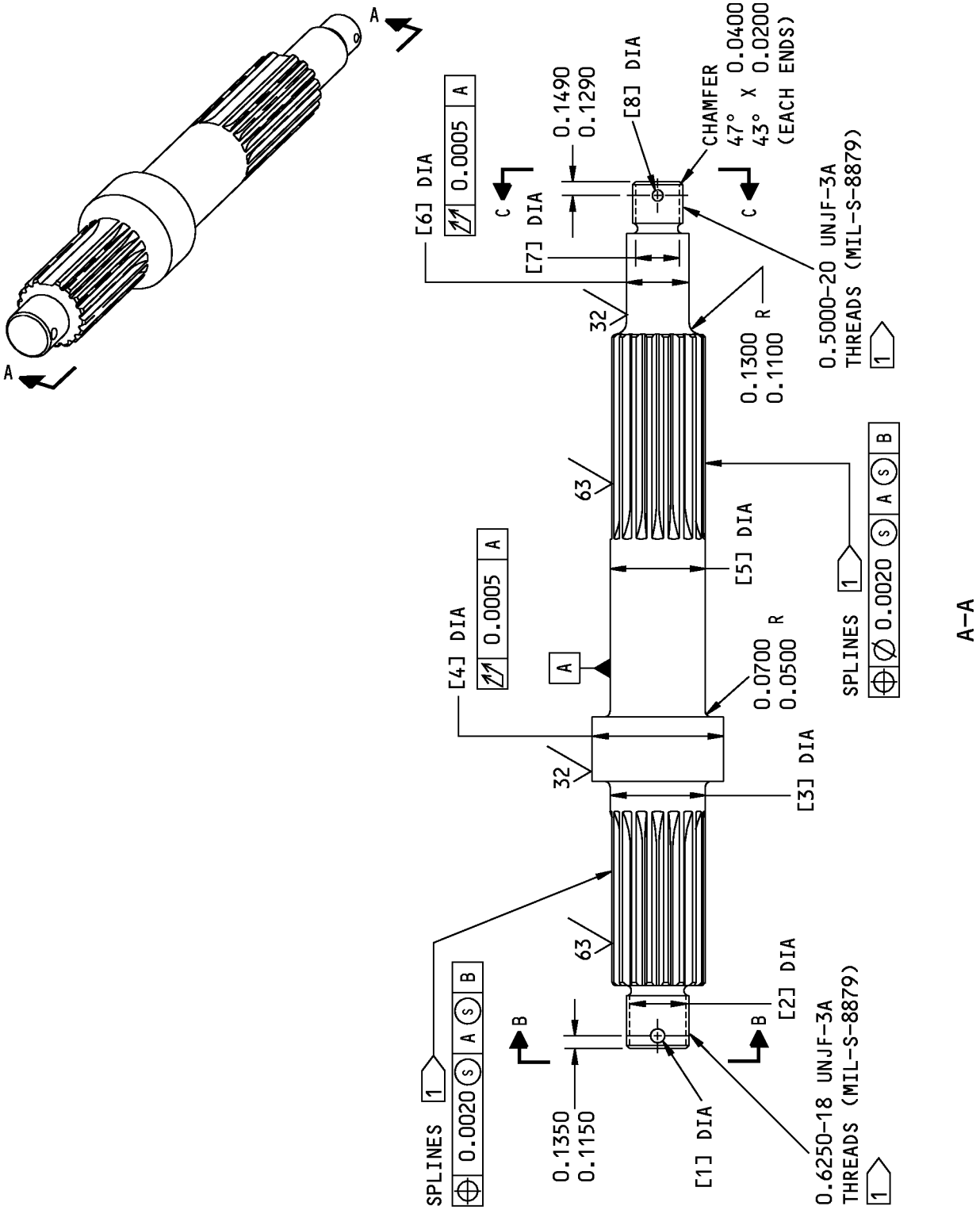
Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES

C. Procedure

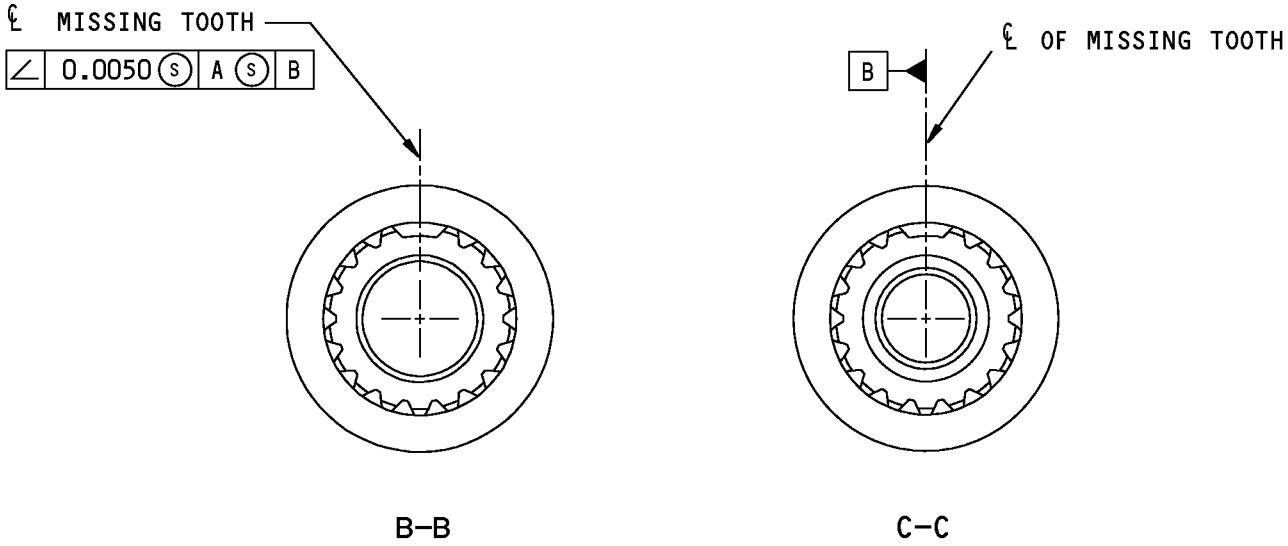
NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01.

(1) Passivate (F-17.25).

(2) Apply BMS 3-8 solid film solid film lubricant, D50081 (F-19.10) to the surfaces shown.



146A6581-1 Lock Shaft Repair and Refinish
Figure 601 (Sheet 1 of 2)



REFERENCE NUMBER	[1]	[2]	[3]	[4]	[5]	[6]	[7]	[8]
DESIGN DIMENSION	0.1510 0.1310	0.5350 0.5150	0.9500 0.9450	1.3120 1.3110	0.9500 0.9450	0.6245 0.6235	0.4100 0.3900	0.1190 0.0990
REPAIR LIMIT	—	—	—	—	—	—	—	—

1 APPLY BMS 3-8 SOLID FILM LUBRICANT (F-19.10), 0.0002-0.0005 THICK

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

146A6581-1 Lock Shaft Repair and Refinish
Figure 601 (Sheet 2 of 2)

LOCK FITTING - REPAIR 41-1

146A6586–1, –3

1. General

A. This procedure tells how to repair and refinish lock fittings (175, 207).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 3 for item numbers.

D. General repair details:

(1) Material: 15-5PH CRES, 180-200 ksi

(2) Shot peen: not necessary

2. Fitting Repair

A. Procedure (REPAIR 41-1, Figure 601 or REPAIR 41-1, Figure 602)

(1) Repair is only replacement of the original finish. Refer to REPAIR 41-1, Paragraph 3. below for details.

(2) If you think there are defects on important surfaces, see REPAIR 41-1, Figure 601 or REPAIR 41-1, Figure 602 for dimension details.

3. 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

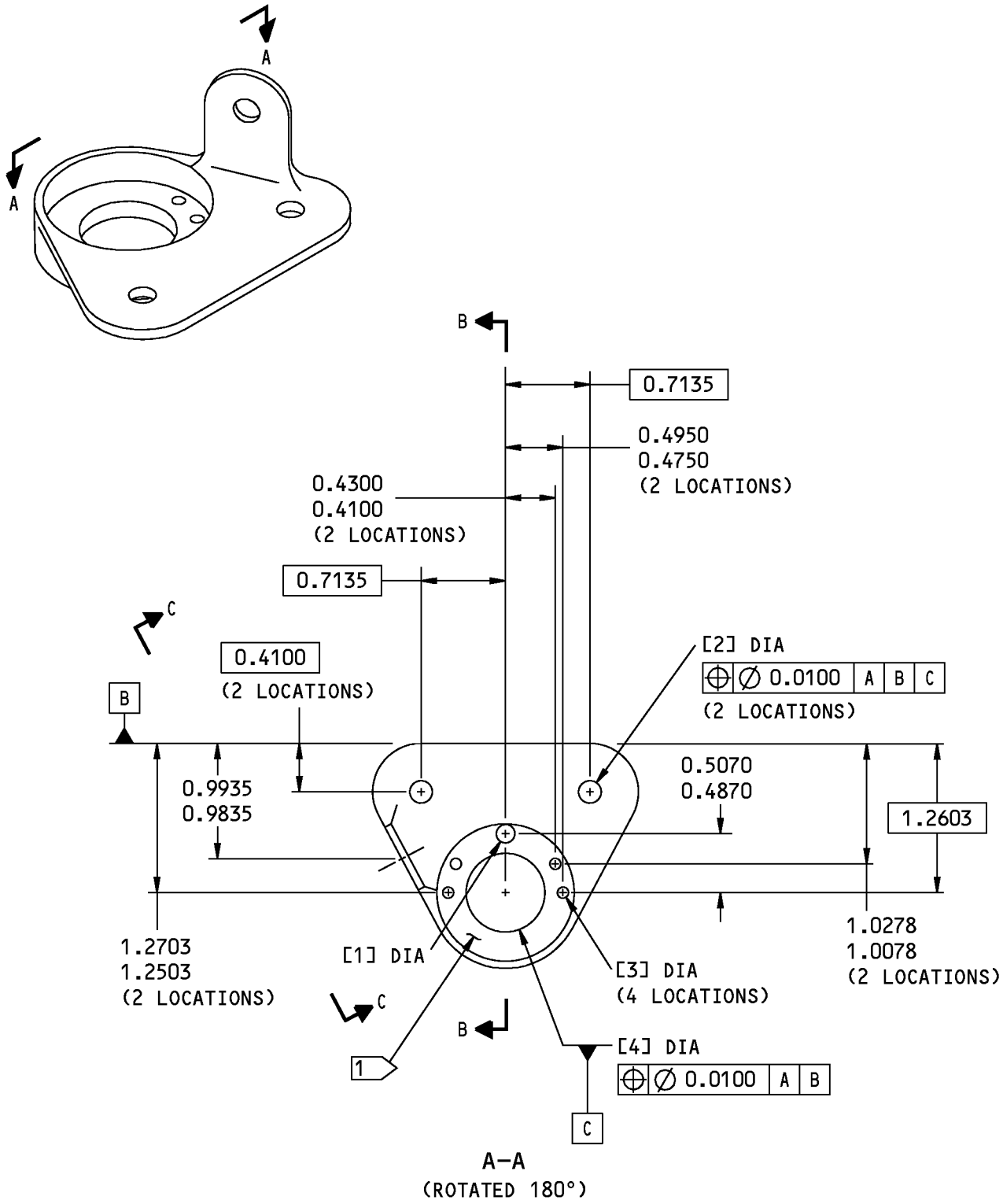
Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES

C. Procedure (REPAIR 41-1, Figure 601 or REPAIR 41-1, Figure 602)

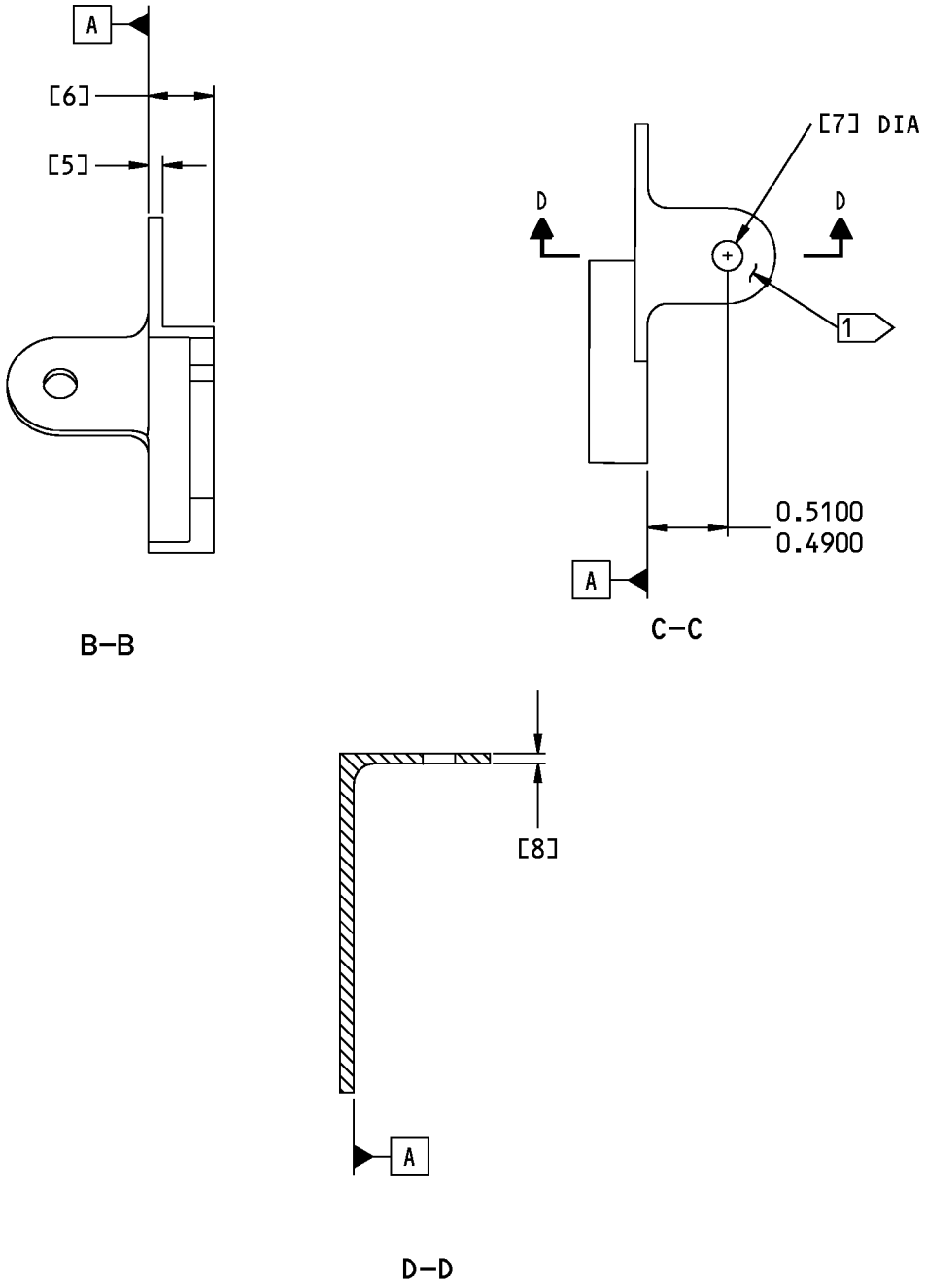
NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01.

(1) 146A6586-1: Cadmium plate (F-15.06). Apply BMS 10-11, Type 1 primer, C00259 (F-20.03) unless shown differently.

(2) 146A6586-3: Passivate (F-17.25).



146A6586-1 Lock Fitting Repair and Refinish
Figure 601 (Sheet 1 of 3)



146A6586-1 Lock Fitting Repair and Refinish
Figure 601 (Sheet 2 of 3)

REFERENCE NUMBER	[1]	[2]	[3]	[4]	[5]	[6]	[7]	[8]
DESIGN DIMENSION	0.1663 0.1463	0.1990 0.1900	0.9500 0.9300	0.6750 0.6550	0.0900 0.0700	0.3780 0.3580	0.1990 0.1900	0.0700 0.0500
REPAIR LIMIT	---	---	---	---	---	---	---	---

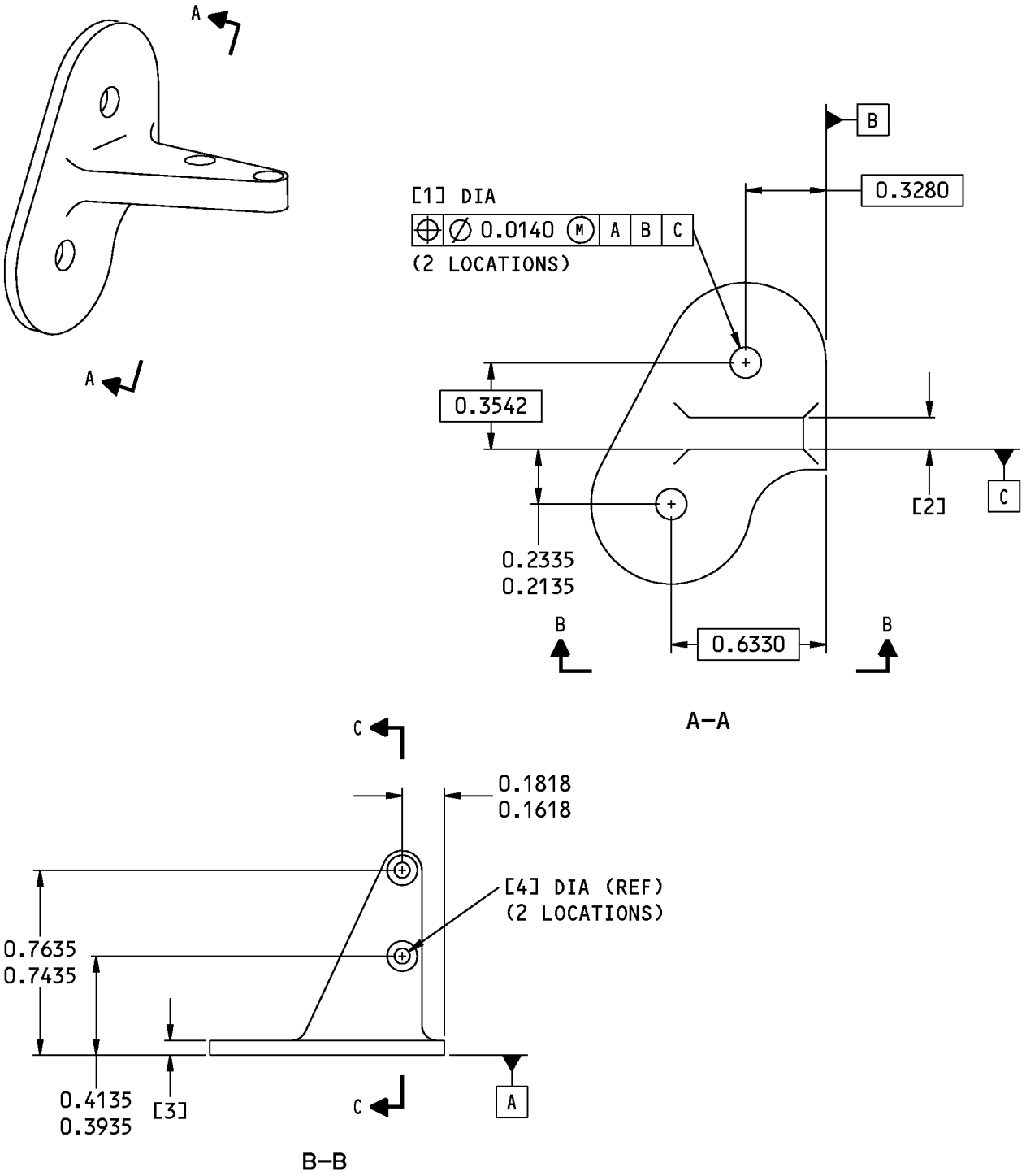
1 NO PRIMER ON THE TWO FACES OF THIS AREA

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

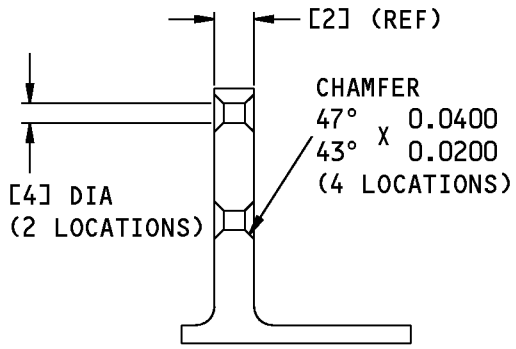
BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

146A6586-1 Lock Fitting Repair and Refinish
Figure 601 (Sheet 3 of 3)



146A6586-3 Lock Fitting Repair and Refinish
Figure 602 (Sheet 1 of 2)



C–C

REFERENCE NUMBER	[1]	[2]	[3]	[4]
DESIGN DIMENSION	0.1300 0.1260	0.1310 0.1290	0.0700 0.0500	0.0730 0.0530
REPAIR LIMIT	---	---	---	---

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

146A6586-3 Lock Fitting Repair and Refinish
Figure 602 (Sheet 2 of 2)

OUTSIDE HANDLE COVER ASSEMBLY - REPAIR 42-1

146A6589–1

1. General

A. This procedure tells how to replace the parts of outside handle cover assembly (670).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices shown in the repair.

C. Refer to IPL Figure 2 for item numbers.

2. Parts Replacement

A. Procedure (REPAIR 42-1, Figure 601)

(1) Remove the fasteners and the spring from the holes.

(2) Replace parts as necessary. Replace bushings (735) per REPAIR 42-1, Paragraph 3. below.

(3) If you find defects on the sleeve or the cover, refer to REPAIR 1-1 and REPAIR 42-2 for repair instructions.

(4) Install a replacement spring and fasteners on the cover as shown.

(5) Use something to tie the parts together until the unit can be installed in the door linkage.

3. Bushing (735) 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

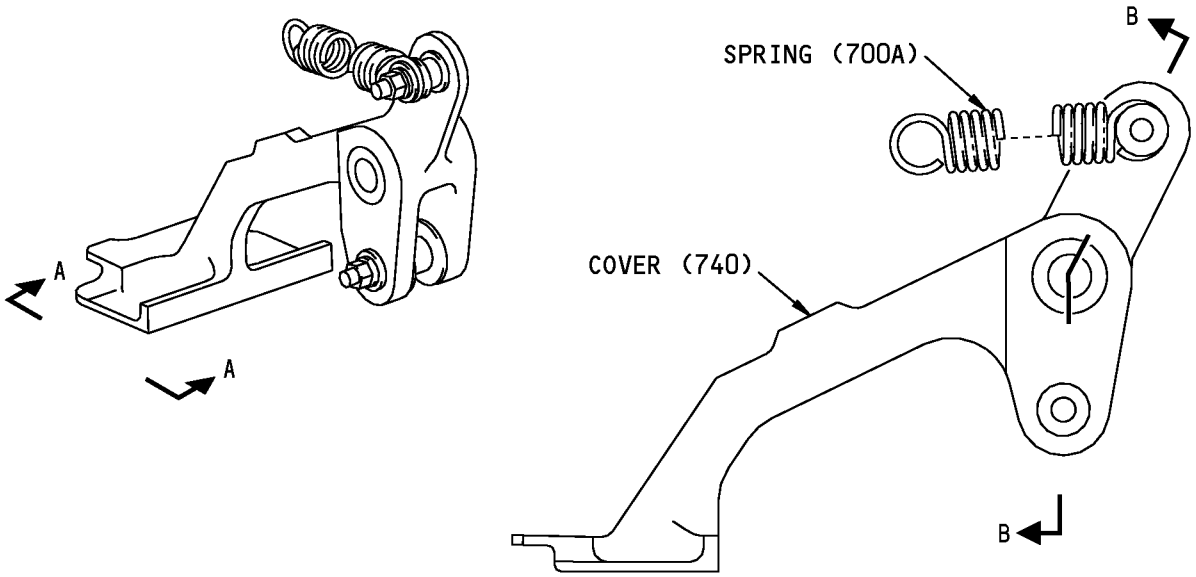
C. Procedure (REPAIR 42-1, Figure 601)

(1) Remove the old bushings.

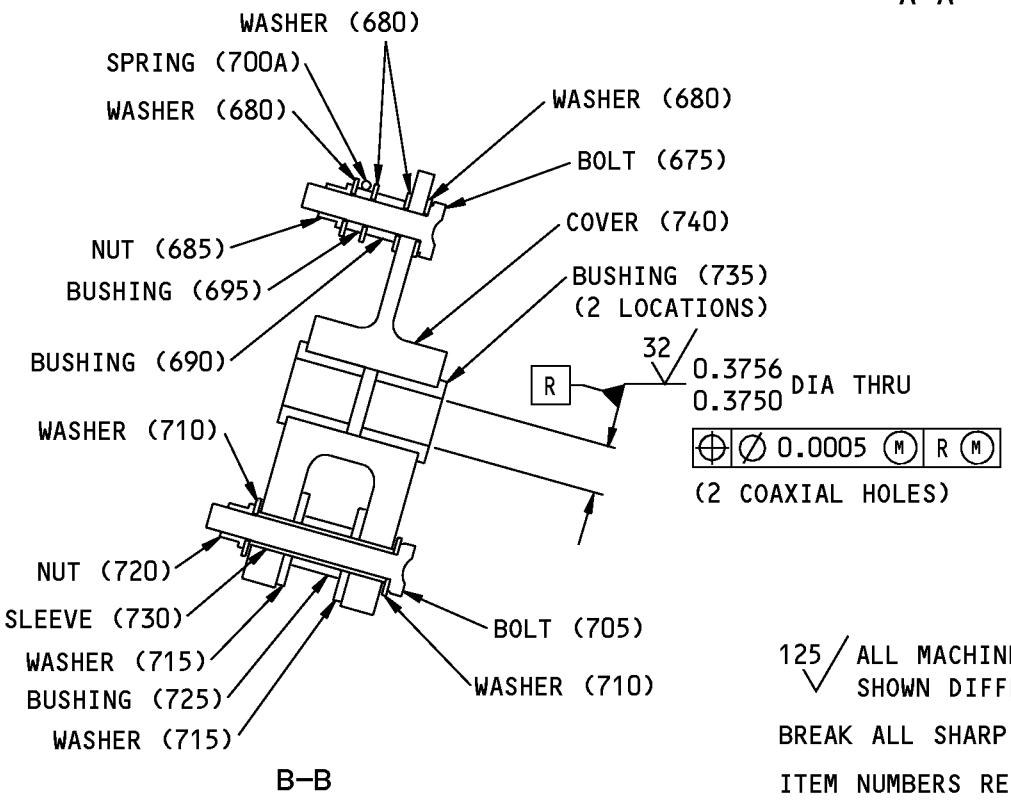
(2) If you find defects on the cover surfaces, refer to REPAIR 42-2 for repair instructions.

(3) Install replacement bushings by the shrink fit method (SOPM 20-50-03) with BMS 5-95 sealant, A00247 as the installation finish.

(4) Machine the bushings to design dimensions and finish.



A–A



B–B

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

146A6589-1 Outside Handle Cover Assembly Parts Replacement
Figure 601

OUTSIDE HANDLE COVER - REPAIR 42-2

146A6589–101

1. General

A. This procedure tells how to repair and refinish outside handle cover (740).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 2 for item numbers.

D. General repair details:

(1) Material: Al alloy

(2) Shot peen: not necessary

2. Cover Repair

A. Procedure (REPAIR 42-2, Figure 601)

(1) Repair is only replacement of the original refinish. Refer to REPAIR 42-2, Paragraph 3. for details.

(2) If you think there are defects on important surfaces, see REPAIR 42-2, Figure 601 for dimension details.

3. Cover Refinis

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

B. References

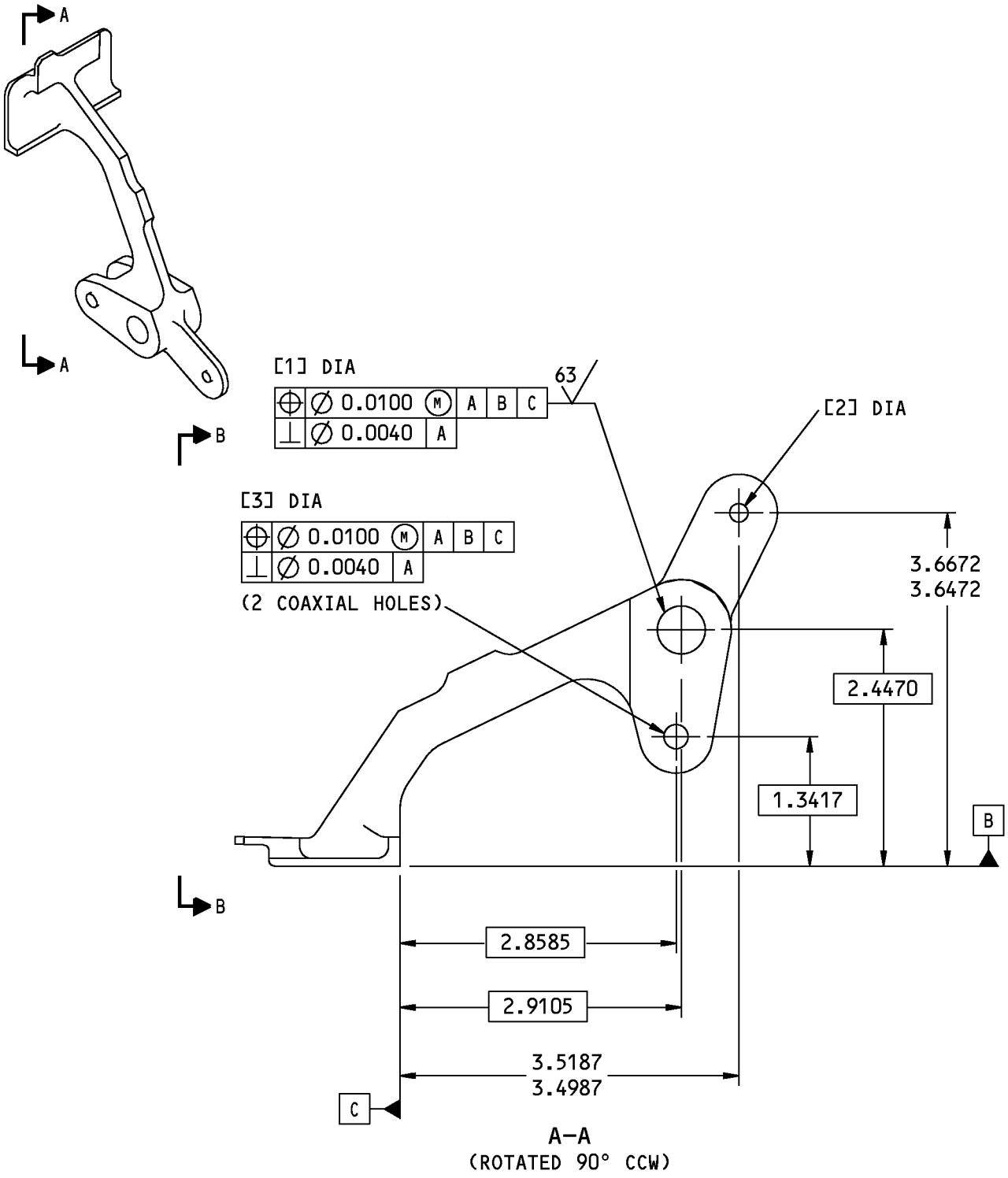
Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES

C. Procedure (REPAIR 42-2, Figure 601)

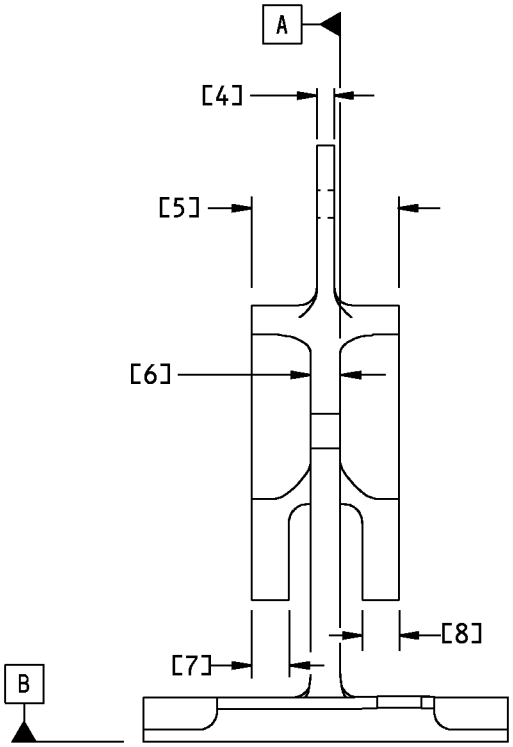
NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01.

(1) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31) all over.

(2) Apply BMS 10-11, Type 1 primer, C00259 (F-20.03) and BMS 10-60, Type 2 coating, C00033 (F-19.39-701) but not in the holes for the bushings.



146A6589-101 Outside Handle Cover Repair and Refinish
Figure 601 (Sheet 1 of 2)



B–B

REFERENCE NUMBER	[1]	[2]	[3]	[4]	[5]	[6]	[7]	[8]
DESIGN DIMENSION	0.5006 0.5006	0.1940 0.1900	0.2540 0.2500	0.1300 0.1100	1.0100 0.9900	0.2100 0.1900	0.2600 0.2400	0.2600 0.2400
REPAIR LIMIT	---	---	---	---	---	---	---	---

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

146A6589-101 Outside Handle Cover Repair and Refinish
Figure 601 (Sheet 2 of 2)

CLUTCH LINK ASSEMBLY - REPAIR 43-1

146A6590–1

1. General

A. This procedure tells how to replace the parts of clutch link assembly (780).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 2 for item numbers.

2. Bearing Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

C. Procedure (REPAIR 43-1, Figure 601)

(1) Remove the old bearing.

(2) If you find defects on the hole surfaces, refer to REPAIR 43-2 for repair instructions.

(3) Install a replacement bearing and roller swage it (SOPM 20-50-03) with BMS 5-95 sealant, A00247 as the installation finish.

(4) Give the bearing an 1150-pound push-out proof load test.

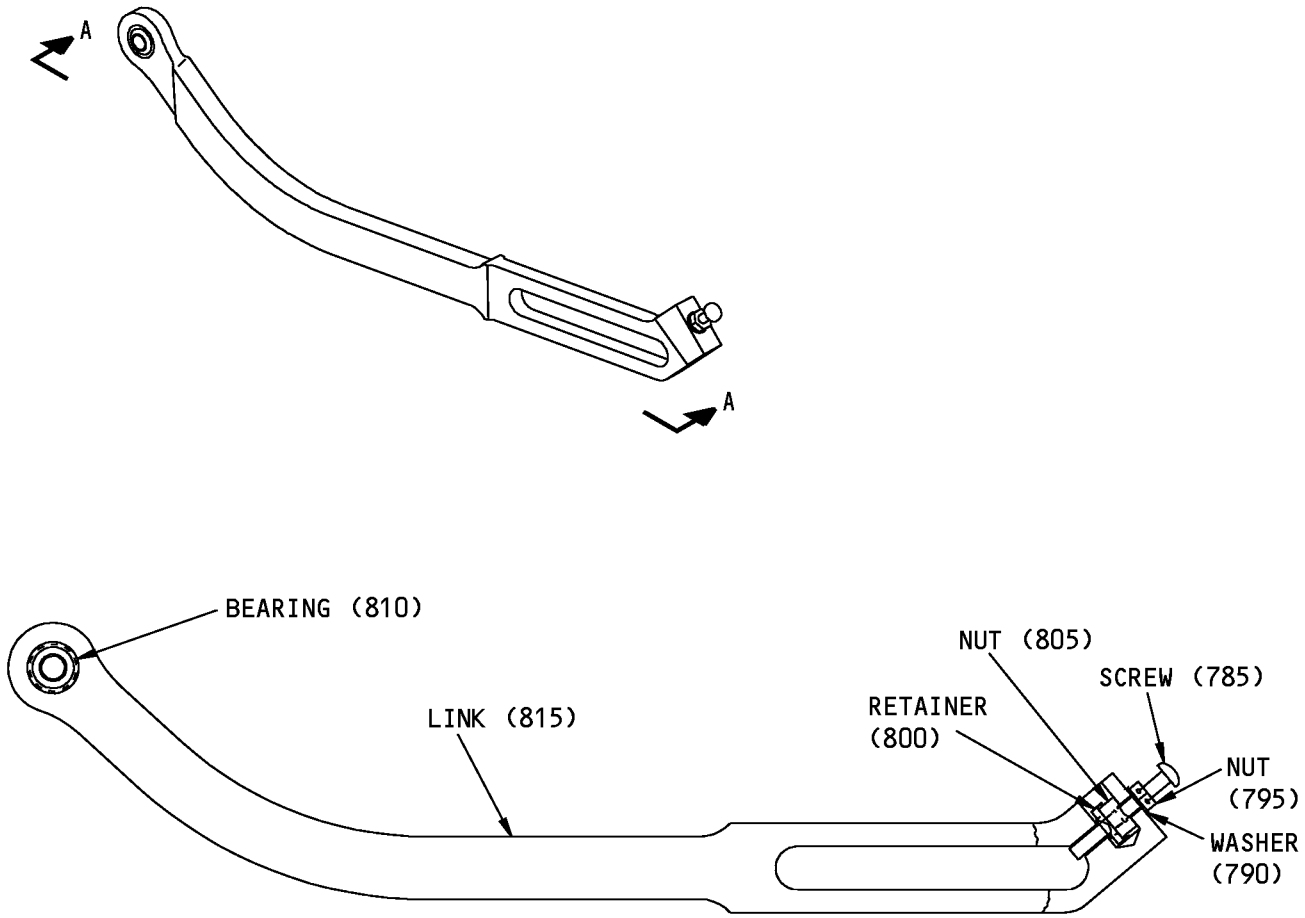
3. Fastener Replacement

A. Procedure (REPAIR 43-1, Figure 601)

(1) Remove the retainer and loosen the nuts.

(2) Remove the screw and the other fasteners.

(3) Install replacements by standard industry practices.



A–A

ITEM NUMBERS REFER TO IPL FIG. 2

146A6590-1 Clutch Link Assembly Parts Replacement
Figure 601

CLUTCH LINK - REPAIR 43-2

146A6590–101

1. General

A. This procedure tells how to repair and refinish clutch link (815).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 2 for item numbers.

D. General repair details:

(1) Material: 15-5PH CRES, 180-200 ksi

(2) Shot peen: not necessary

2. Link Repair

A. Procedure (REPAIR 43-2, Figure 601)

(1) Repair is only replacement of the original finish. Refer to REPAIR 43-2, Paragraph 3. below for details.

(2) If you think there are defects on important surfaces, seeREPAIR 43-2, Figure 601 for dimension details.

3. Link Refinish

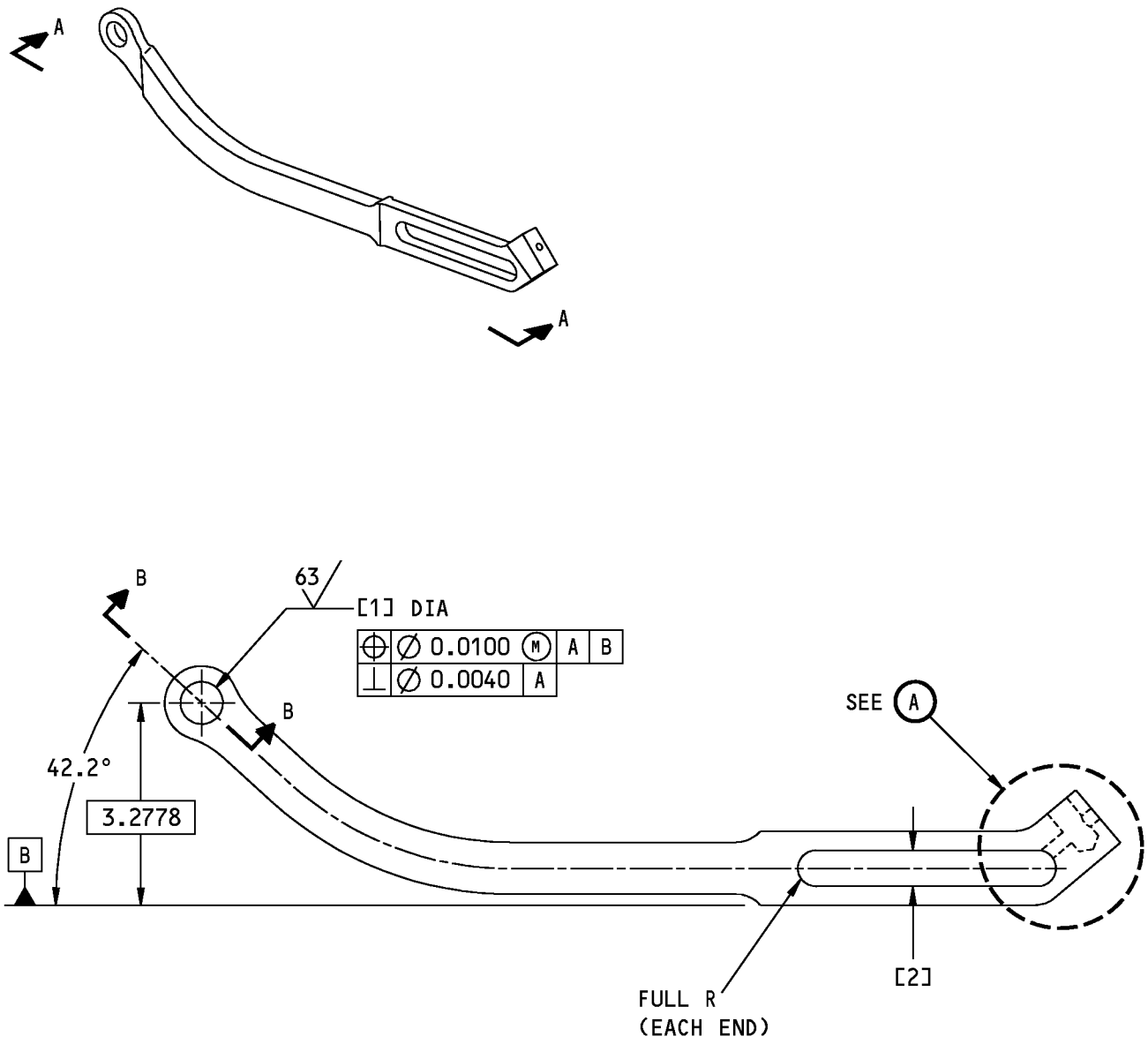
A. References

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

B. Procedure

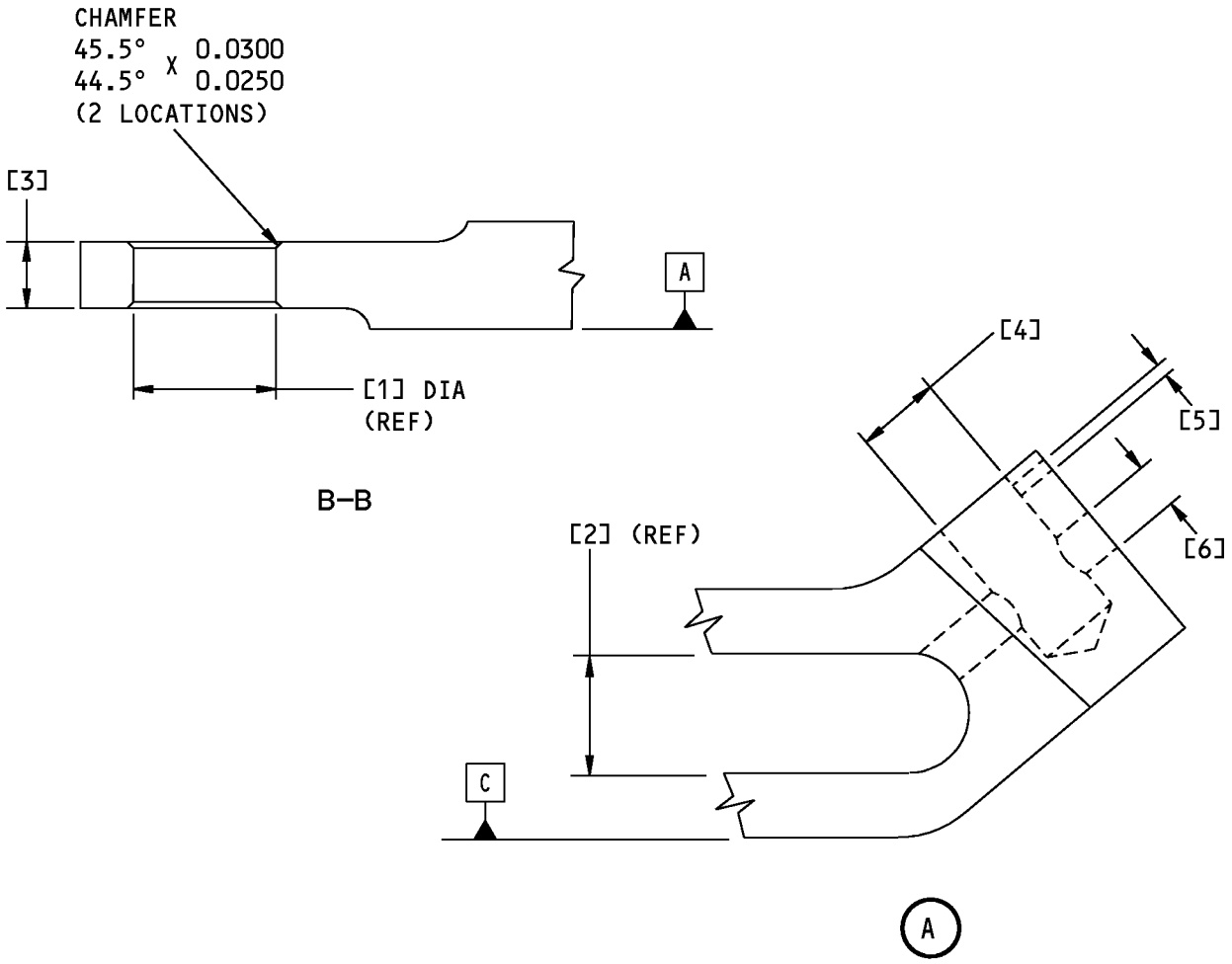
NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01.

(1) Passivate (F-17.25).



A–A

146A6590-101 Clutch Link Repair and Refinish
Figure 601 (Sheet 1 of 2)



REFERENCE NUMBER	[1]	[2]	[3]	[4]	[5]	[6]
DESIGN DIMENSION	0.6880 0.6875	0.5910 0.5765	0.3270 0.3170	0.4090 0.4050	0.0670 0.0620	0.2290 0.2180
REPAIR LIMIT	—	—	—	—	—	—

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

146A6590-101 Clutch Link Repair and Refinish
Figure 601 (Sheet 2 of 2)

OUTSIDE HANDLE BEARING HOUSING ASSEMBLY - REPAIR 44-1

146A6591–1

1. General

A. This procedure tells how to replace the parts of outside handle bearing housing assembly (325).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 2 for item numbers.

2. Bearing Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

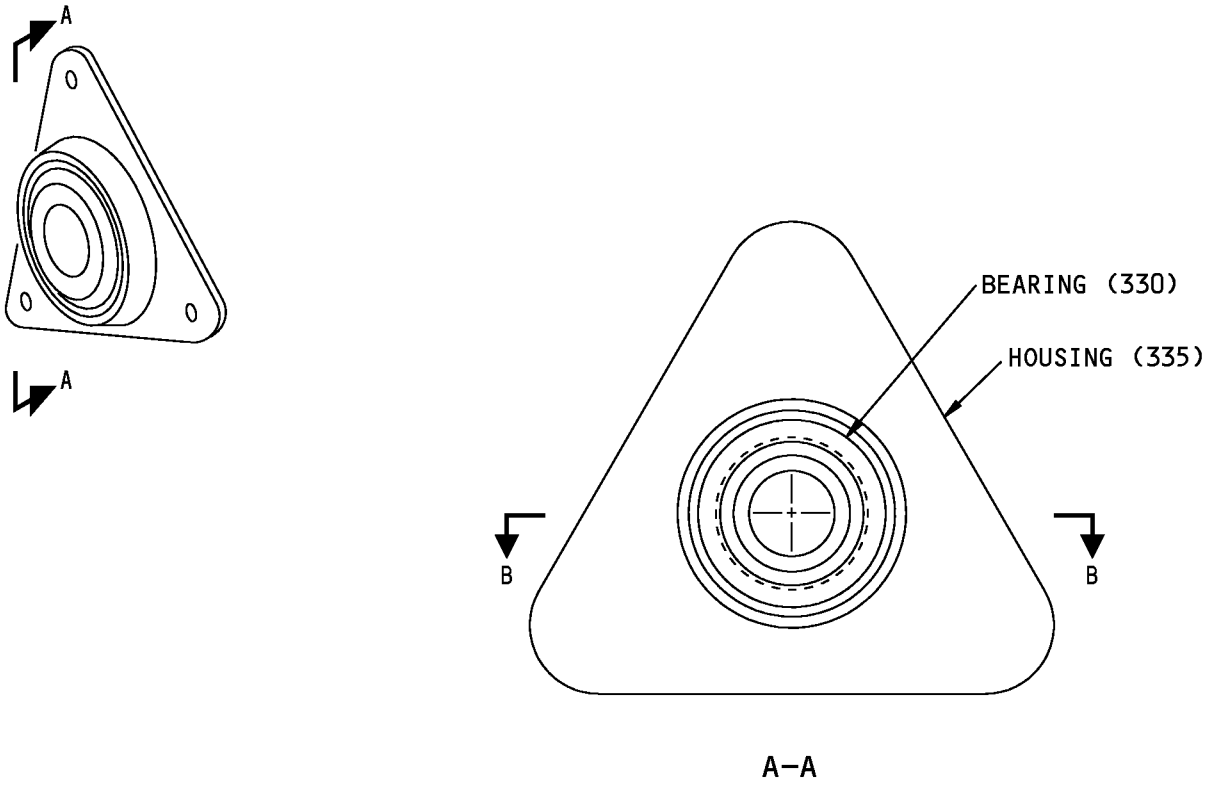
C. Procedure (REPAIR 44-1, Figure 601)

(1) Remove the old bearing.

(2) If you find defects on the hole surfaces, refer to REPAIR 44-2 for repair instructions.

(3) Install a replacement bearing and roller swage it (SOPM 20-50-03) with BMS 5-95 sealant, A00247 as the installation finish.

(4) Give the bearing a 2555-pound push-out proof load test.



ITEM NUMBERS REFER TO IPL FIG. 2

146A6591-1 Outside Handle Bearing Housing Assembly Bearing Replacement
Figure 601

BEARING HOUSING - REPAIR 44-2

146A6591–101

1. General

A. This procedure tells how to repair and refinish bearing housing (335).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 2 for item numbers.

D. General repair details:

(1) Material: Al alloy

(2) Shot peen: not necessary

2. Bearing Housing Repair

A. Procedure (REPAIR 44-2, Figure 601)

(1) Repair is only replacement of the original finish. Refer to REPAIR 44-2, Paragraph 3. below for details.

(2) If you think there are defects on important surfaces, see REPAIR 44-2, Figure 601 for dimension details.

3. Bearing 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

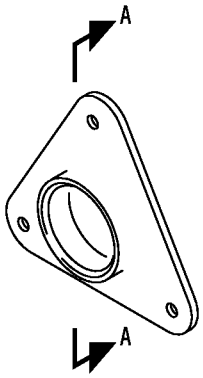
Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES

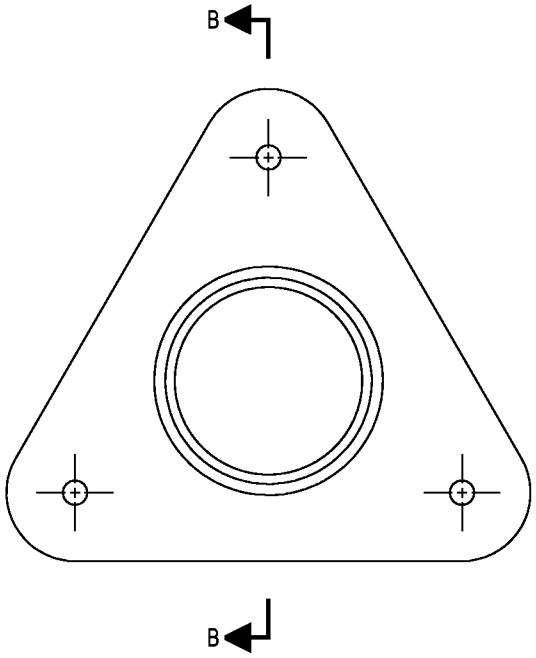
C. Procedure

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.

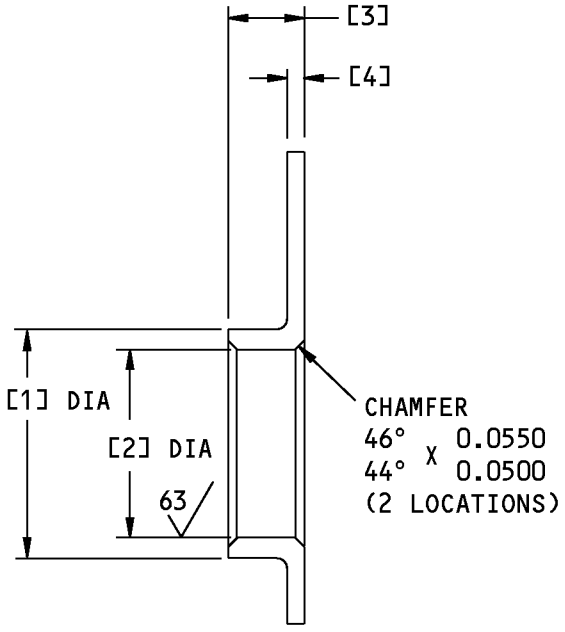
(1) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31).

(2) Apply BMS 10-11, Type 1 primer, C00259 (F-20.03) all over, but not on bore surfaces.





A–A



REFERENCE NUMBER	[1]	[2]	[3]	[4]
DESIGN DIMENSION	1.3438 1.3238	1.0943 1.0938	0.4490 0.4390	0.1100 0.0900
REPAIR LIMIT	—	—	—	—

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

146A6591-101 Outside Handle Bearing Housing Repair and Refinish
Figure 601

OUTSIDE HANDLE SUPPORT - REPAIR 45-1

146A6592–1

1. General

A. This procedure tells how to repair and refinish outside handle support (595).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 1 for item numbers.

D. General repair details:

(1) Material: Al alloy

(2) Shot peen: not necessary

2. Support Repair

A. Procedure (REPAIR 45-1, Figure 601)

(1) Repair is only replacement of the original finish. Refer to REPAIR 45-1, Paragraph 3. below for details.

(2) If you think there are defects on important surfaces, see (REPAIR 45-1, Figure 601) for dimension details.

3. 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

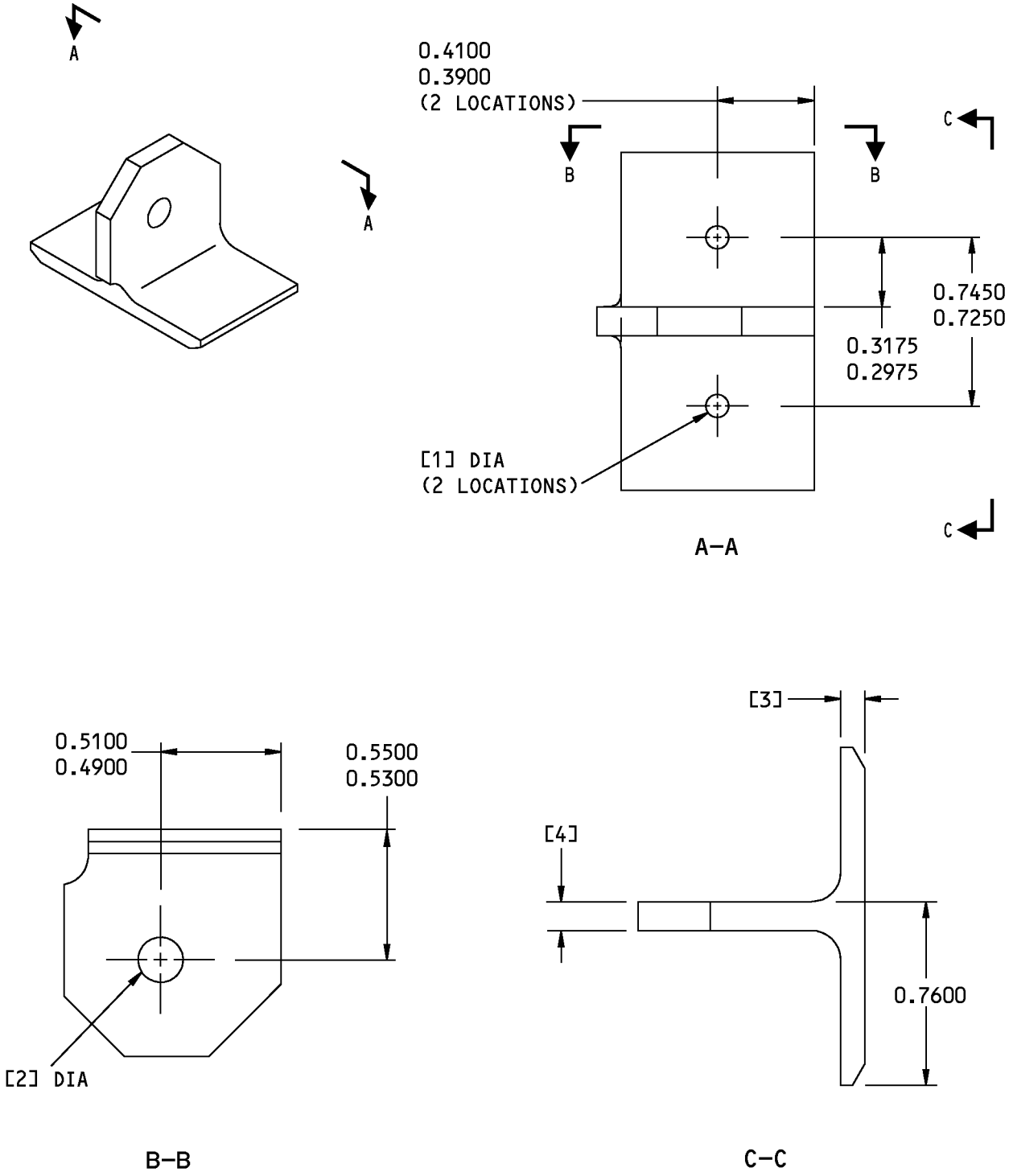
Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES

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.

(1) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31).

(2) Apply BMS 10-11, Type 1 primer, C00259 (F-20.03) all over, but not on bore surfaces.



146A6592-1 Outside Handle Support Repair and Refinish
Figure 601 (Sheet 1 of 2)

REFERENCE NUMBER	[1]	[2]	[3]	[4]
DESIGN DIMENSION	0.1300 0.1260	0.1940 0.1900	0.1100 0.0900	0.1300 0.1100
REPAIR LIMIT	—	—	—	—

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

146A6592-1 Outside Handle Support Repair and Refinish
Figure 601 (Sheet 2 of 2)

OUTSIDE HANDLE PIN ASSEMBLY - REPAIR 46-1

146A6597–1, –2

1. General

A. This procedure tells how to replace the parts of outside handle pin assembly (480. 530).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 2 for item numbers.

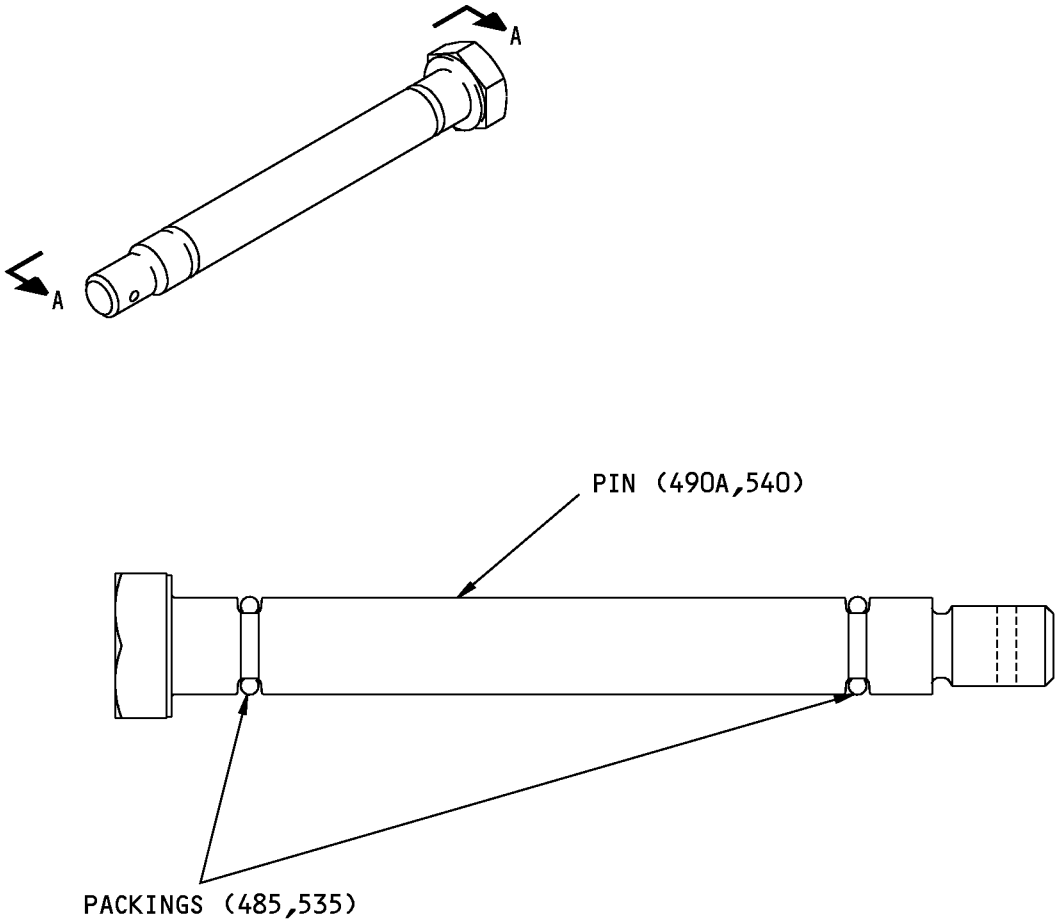
2. Packing Replacement

A. Procedure (REPAIR 46-1, Figure 601)

(1) Remove the old packings.

(2) If you find defects on the pin surfaces, refer to REPAIR 46-2 for repair instructions.

(3) Install replacement packings in the pin grooves.



ITEM NUMBERS REFER TO IPL FIG. 2

146A6597-1,-2 Outside Handle Pin Assembly Parts Replacement
Figure 601

OUTSIDE HANDLE PIN - REPAIR 46-2

146A6597–101, –102

1. General

A. This procedure tells how to repair and refinish outside handle pins (490A, 530).

B. Refer to the Standard Overhaul Practices Manual (SOPM) for the standard practices specified in the procedure.

C. Refer to IPL Figure 2 for item numbers.

D. General repair details:

(1) Material: A286 CRES, 180-200 ksi

(2) Shot peen: not necessary

2. Pin Repair

A. Procedure (REPAIR 46-2, Figure 601)

(1) Repair is only replacement of the original finish. Refer to REPAIR 46-2, Paragraph 3. below for details.

(2) If you think there are defects on important surfaces, see REPAIR 46-2, Figure 601 for dimension details.

3. Pin Refinish

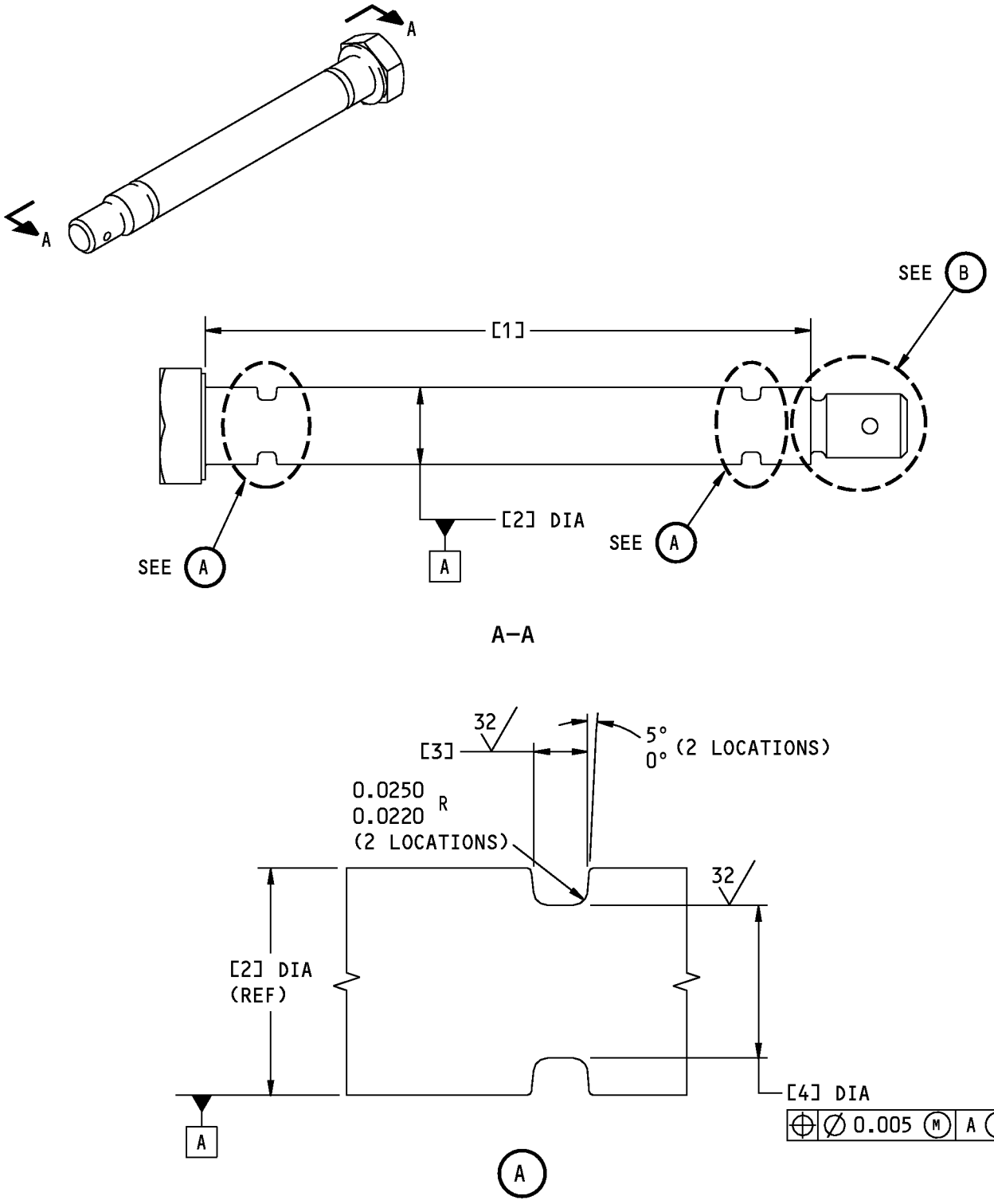
A. References

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

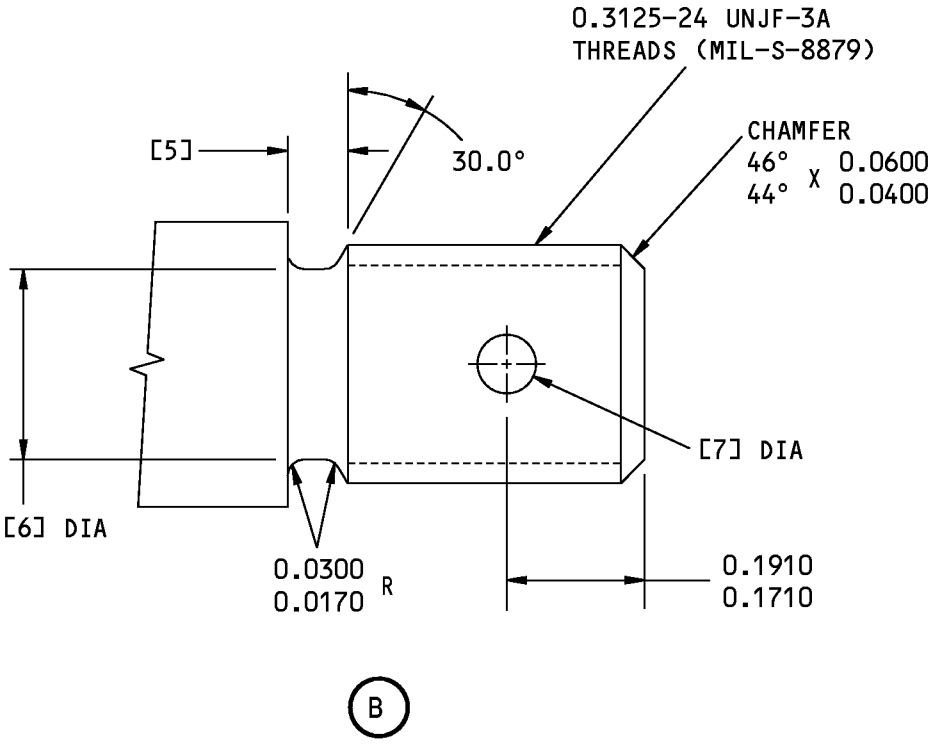
B. Procedure

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.

(1) Cadmium plate (F-15.06).



146A6597-101,-102 Outside Handle Pin Repair and Refinish
Figure 601 (Sheet 1 of 2)



REFERENCE NUMBER	[1] 1	[1] 2	[2]	[3]	[4]	[5]	[6]	[7]
DESIGN DIMENSION	2.9525 2.9225	2.7025 2.6725	0.3745 0.3740	0.880 0.820	0.2540 0.2510	0.0830 0.0420	0.2520 0.2470	0.0770 0.0760
REPAIR LIMIT	—	—	—	—	—	—	—	—

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

1 146A6597-101
2 146A6597-102

146A6597-101,-102 Outside Handle Pin Repair and Refinish
Figure 601 (Sheet 2 of 2)

ASSEMBLY

1. General

A. This procedure tells how to assemble the emergency exit door unit.

B. Refer to the Standard Overhaul Practices Manual (SOPM) for details of the standard practices specified in the procedure.

C. Refer to IPL Figure 1 thru IPL Figure 4 for item numbers, as applicable.

2. Assembly

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95
A02315	Sealant - Low Density, Synthetic Rubber. 2 Part	BMS5-142
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23
G50136	Paste - Corrosion Inhibiting, Non-drying	BMS 3-38

B. 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
SOPM 20-50-12	APPLICATION OF ADHESIVES
SOPM 20-50-19	GENERAL SEALING
SOPM 20-60-02	FINISHING MATERIALS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

C. Application of primer, sealant and corrosion inhibiting compound (ASSEMBLY, Figure 701)

NOTE: This procedure starts with the basic door structure. If this was not disassembled, and the paint, sealant and compound on the structure are serviceable, go to ASSEMBLY, Paragraph 2.D. to install the mechanical parts.

NOTE: Some of these steps apply sealant and compound to mechanical parts after they are installed. Then the subsequent procedures that install those parts will refer to the applicable steps in this paragraph.

NOTE: For finishing materials, refer to SOPM 20-60-02. For miscellaneous materials, refer to SOPM 20-60-04.

(1) Use standard industry practices and these steps.

(2) Put the door unit in an assembly cradle or fixture

(3) Inject BMS 5-142 sealant, A02315 (SOPM 20-50-19) as shown (flagnote 5).

(4) Fillet seal around the parts with BMS 5-142 sealant, A02315 (SOPM 20-50-19) as shown (flagnote 1). Make a smooth joint with the injection seals that could be around the same part.

(5) Fill all gaps and fillet seal all seams on the inside handle box assembly (575, IPL Figure 1) with BMS 5-142 sealant, A02315 (SOPM 20-50-19) as shown (flagnote 7). To get at the lower corners, release the handle as necessary.

(6) Fill and make smooth with BMS 5-142 sealant, A02315 (SOPM 20-50-19) all along the interface between the door skin seal and the seal depressor as shown (flagnote 6). Make a smooth joint with the injection seals that could be around the same part.

(7) Fill the gaps between the seal depressors with BMS 5-142 sealant, A02315 as shown (flagnote 8). Make sure the sealant is flush, to help prevent air leaks through the pressure seal.

(8) Aerodynamic seal with BMS 5-142 sealant, A02315 between the view port or prism assembly (180, IPL Figure 1) and the upper seal depressor (flagnote 2). Make a smooth joint with the injection seals that could be around the same part.

(9) Mask the rub strips, bushings, bearings, and ground strap studs as shown (flagnote 4).

(10) Touch up with primer as necessary. Let the primer cure for a minimum of 1 hour before you apply the corrosion inhibiting compound.

(11) Apply BMS 3-23, Type 2 (such as Ardrox AV8) corrosion inhibiting compound, G00009 (SOPM 20-41-05) to all accessible internal surfaces of the door structure (flagnote 4).

D. Mechanical Parts - - General (ASSEMBLY, Figure 702 thru ASSEMBLY, Figure 707)

(1) Use standard industry practices and these steps.

(2) Some parts have holes which are machined at assembly to the sizes shown, or are adjusted to give dimensions shown. If you replaced these parts with new ones, the new parts could have only pilot holes or no holes at all. Then be sure to machine the holes as shown. Otherwise, if you use the old parts, it is not necessary to machine the holes or parts if these parts, when assembled, give the dimensions shown.

(3) Install the noted fasteners with BMS 3-38 corrosion inhibiting non-drying paste, G50136 (SOPM 20-60-02).

(4) Tighten the noted fasteners and install cotter pins (SOPM 20-50-02).

E. Exterior Door Handle Mechanism in Handle Box (ASSEMBLY, Figure 702)

(1) Install the bolts, bushings and springs of handle cover assembly (670, IPL Figure 2) on the outside handle support (595, IPL Figure 1), with the handle laying loose in the box.

(2) Make sure the spring is between the washers (flagnote 5). Apply a thin layer of BMS 3-38 corrosion inhibiting non-drying paste, G50136 to the mating surfaces of the washers (flagnote 11).

(3) Remove the Panduit straps from shaft assembly (380, IPL Figure 2). Remove crank shaft (440,IPL Figure 2) and lubricate the shaft with BMS 3-33 grease.

(4) Install bearings (378, IPL Figure 2) and washers (377, IPL Figure 2) in the handle box. Use the crankshaft to put the washers in position and adjust the washers for end play (flagnote 3).

(5) Apply sealant to the bearings and let it cure.

(6) Install handle cover (670, IPL Figure 2) on the handle box with bolts (480, 530, IPL Figure 2), bushings and washers as necessary for a good fit (flagnote 3).

(7) Install link (620, IPL Figure 2) between crank (420, IPL Figure 2) and handle (635, IPL Figure 2) with the bolts, washers, bushing, nut and cotter pin.

(8) Install handle link (620, IPL Figure 2), shaft assembly (380, IPL Figure 2), and handle assembly (635, IPL Figure 2) with bolts (480, 530, IPL Figure 2). Use washers as necessary for a good fit (flagnote 2).

(9) Install crank assembly (420, IPL Figure 2) inside the box with its fasteners.

(10) Loosely install catch stop (445,IPL Figure 2) with shim (460, IPL Figure 2) as supplied. Make a check for a good aerodynamic fit with a shim as skin thickness against the flange of the box. Adjust the thickness of shim (460) for a good aerodynamic fit (flagnote 4).

F. Vent Door (ASSEMBLY, Figure 703)

(1) Get vent door mechanism assembly (55, IPL Figure 2) and remove the two end fittings.

(2) Install the two end fittings and lock fittings (159, 303, IPL Figure 3) on the #2 stop beam (375, IPL Figure 1).

(3) If necessary, drill the holes for fasteners for the tension springs (ASSEMBLY, Figure 702, View F-F).

(4) Now install the mechanism on the #2 beam with the fasteners as shown (ASSEMBLY, Figure 702, Views C-C, D-D; ASSEMBLY, Figure 703, Views R-R, X-X). Adjust the shim thickness and install with fasteners, with wet BMS 5-95 sealant, A00247 (flagnotes 10, 11). Fay surface seal (ASSEMBLY, Figure 701).

(5) Install fasteners, bushings and washers for the springs (ASSEMBLY, Figure 702, View F-F).

G. Retention Plate (ASSEMBLY, Figure 703)

(1) Install retention plate (332, IPL Figure 3) with a fay surface seal (SOPM 20-50-19) of BMS 5-95 sealant on mating surfaces (ASSEMBLY, Figure 703, View K-K).

(2) Install bolts (333) and collars (336) with BMS 5-95 sealant, A00247.

H. Activation Module and Inside Door Handle (ASSEMBLY, Figure 706 ASSEMBLY, Figure 705, ASSEMBLY, Figure 705) (IPL Figure 1)

(1) Install the activation module deep details as shown in ASSEMBLY, Figure 705. Install bolt (130) with ASTM D 5363 AN0313 or MIL-S-46163, Type 2, Grade M retaining compound by the BAC5011 Procedure for Application of Retaining Compounds in SOPM 20-50-12.

(2) Connect inside door handle (115, IPL Figure 1) to lock cam (90, 231, IPL Figure 3) on lock shaft assembly (78, IPL Figure 3) with the hardware (ASSEMBLY, Figure 706, Views B-B, C-C).

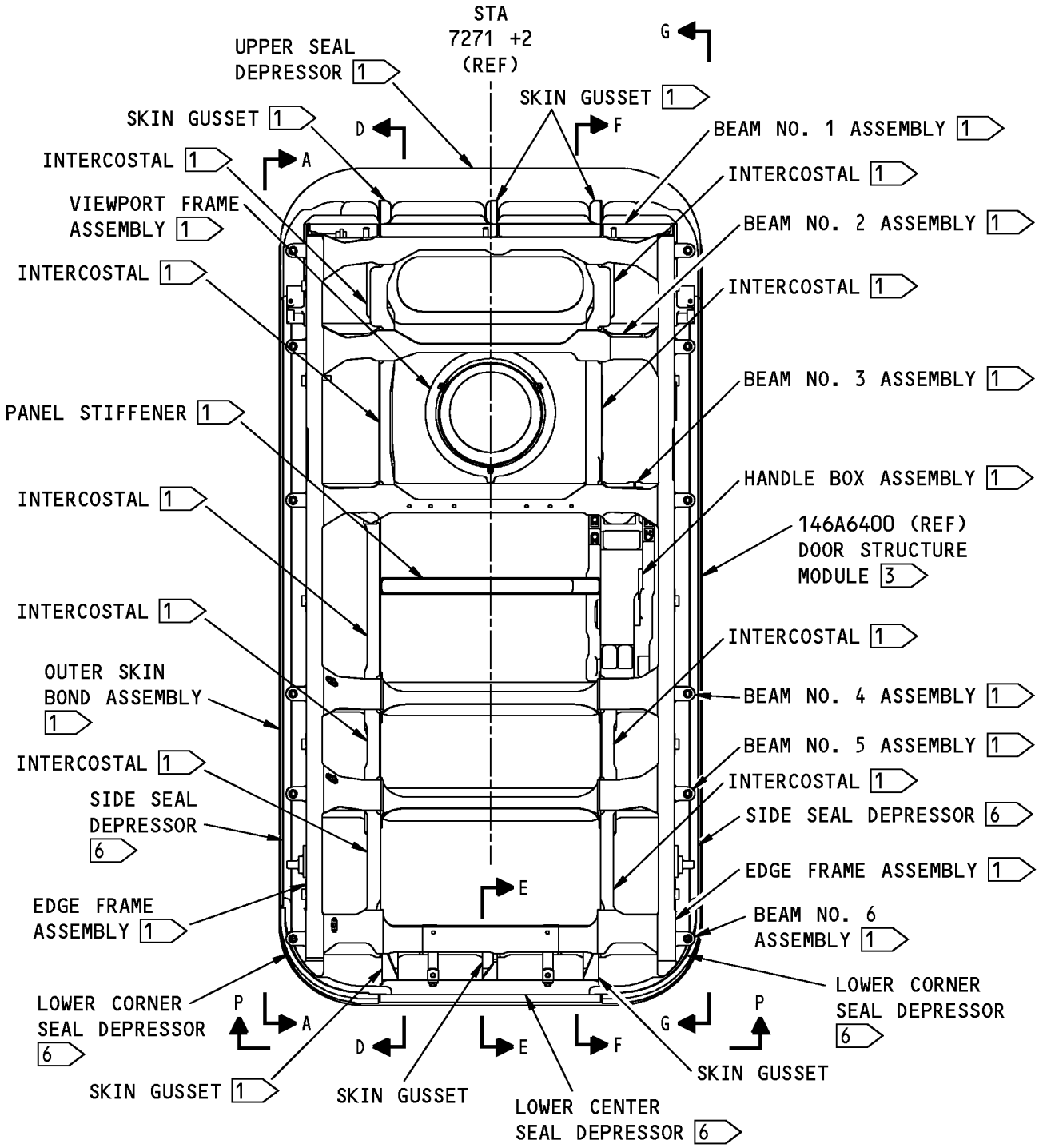
(3) If this is an activated door, install screws in the nutplates with wet BMS 5-95 sealant, A00247 (ASSEMBLY, Figure 706, View D-D).

I. Viewport Prism (ASSEMBLY, Figure 707)

(1) Install prism assembly (180, IPL Figure 1) with seal (195, IPL Figure 1) and retainer (175, IPL Figure 1).

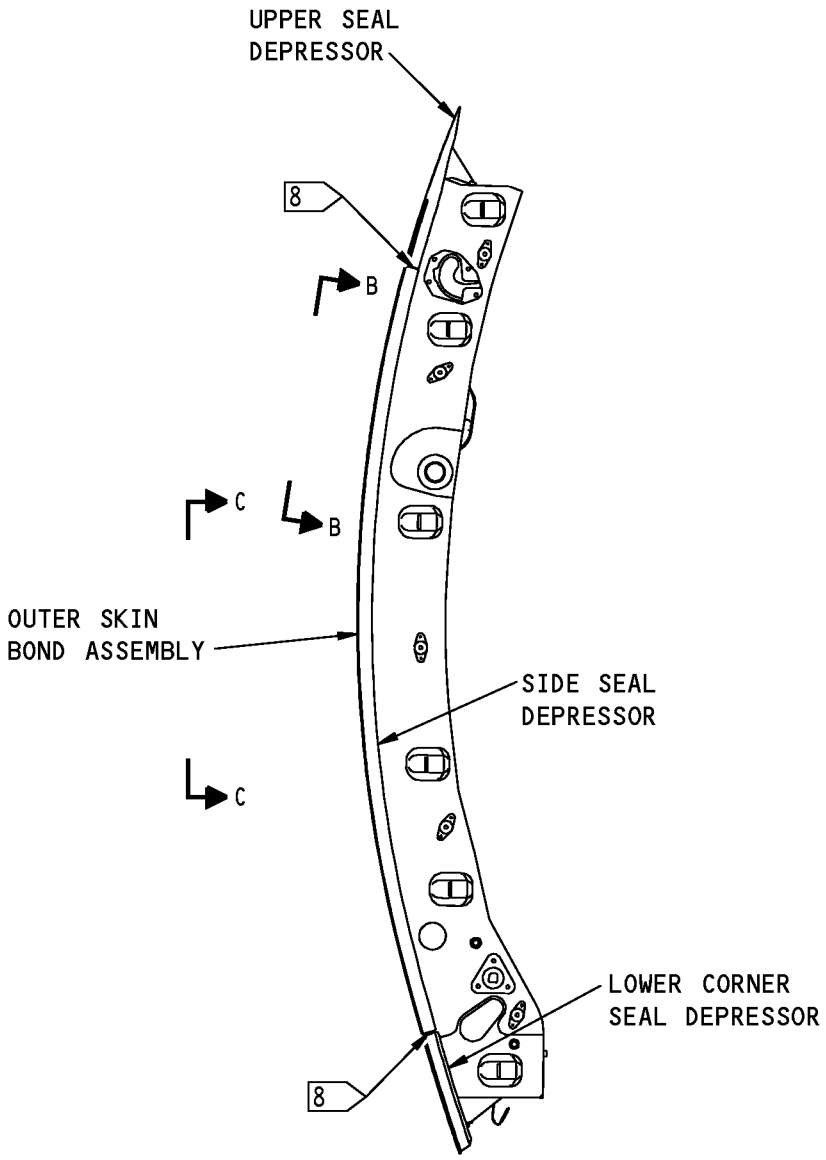
(2) Push the retainer tightly against the seal and make sure there is the pull-up gap between the retainer and each of the nutplates, as shown. To adjust the gap, use washers (165, 170) as necessary between the retainer and the nutplate.

(3) Then install the bolts and tighten them to standard torque (SOPM 20-50-01).

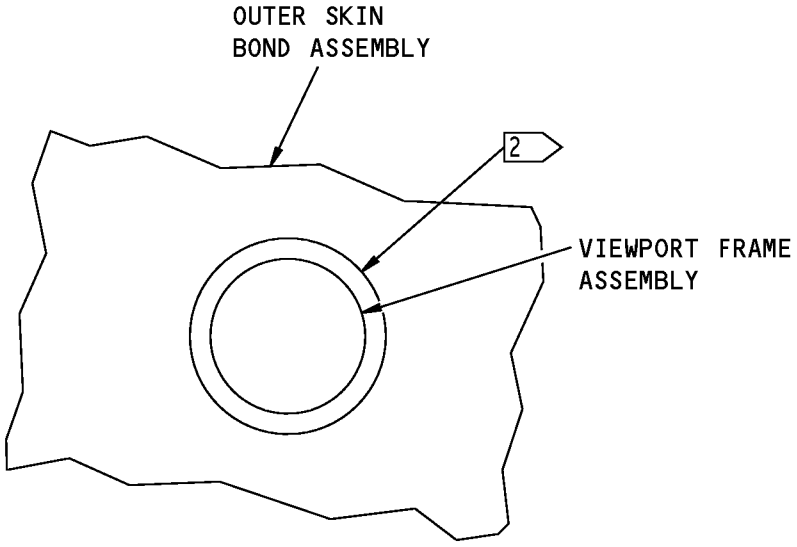


LEFT SIDE SEAL APPLICATION SHOWN 4
RIGHT SIDE SAME

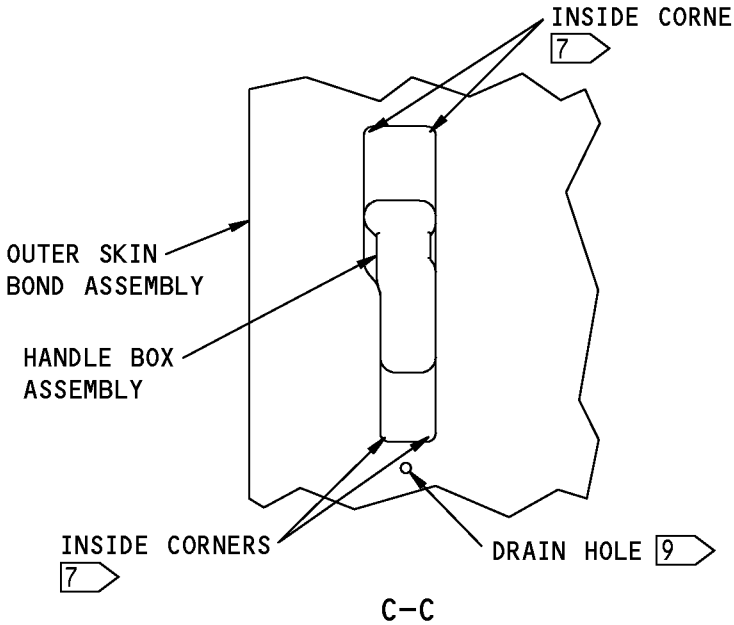
Emergency Exit Door Prmer, Sealant and Corrosion Inhibiting Compound Detaills
Figure 701 (Sheet 1 of 14)



Emergency Exit Door Prmer, Sealant and Corrosion Inhibiting Compound Detaills
Figure 701 (Sheet 2 of 14)

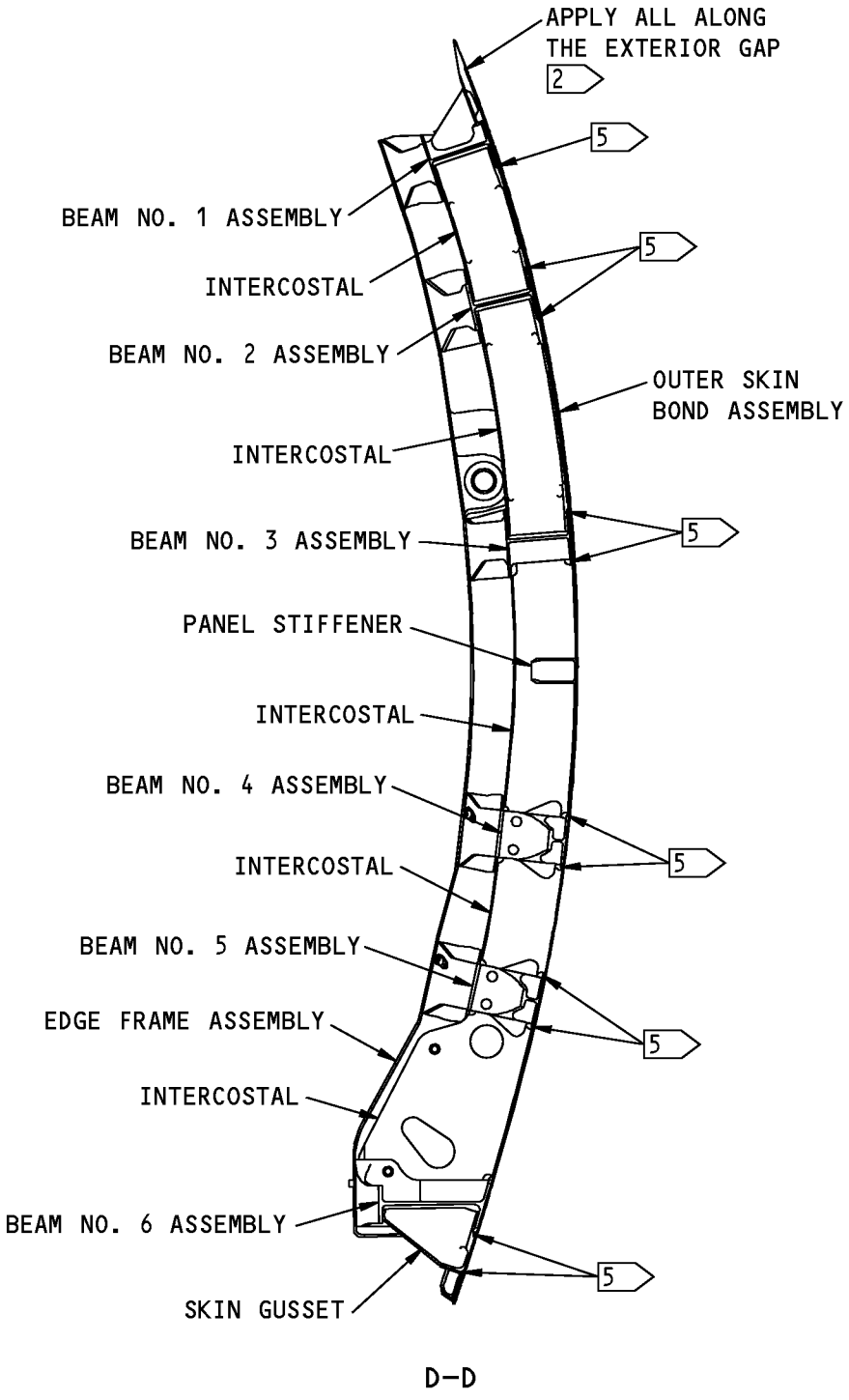


B–B

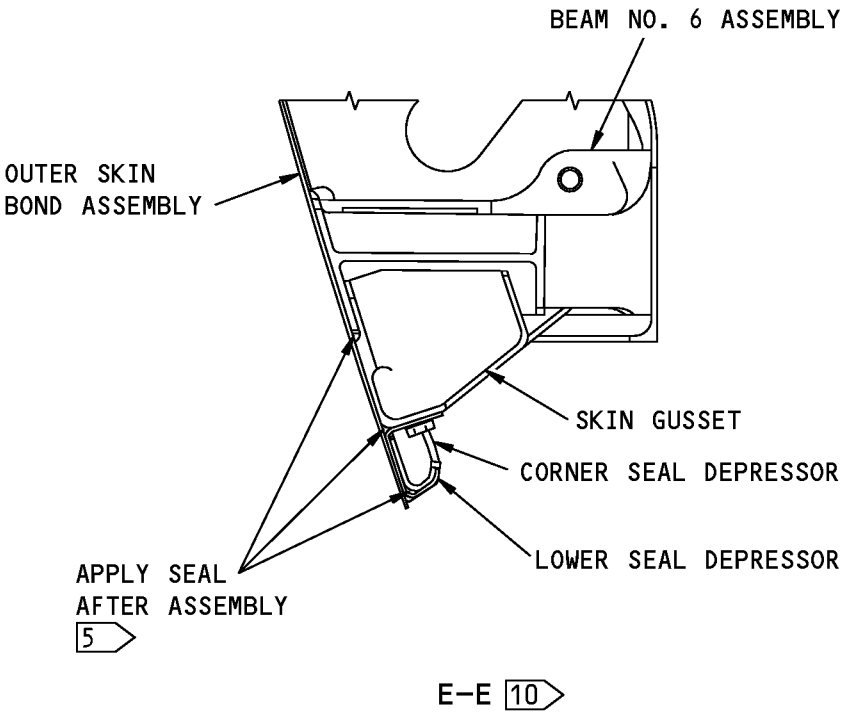


C–C

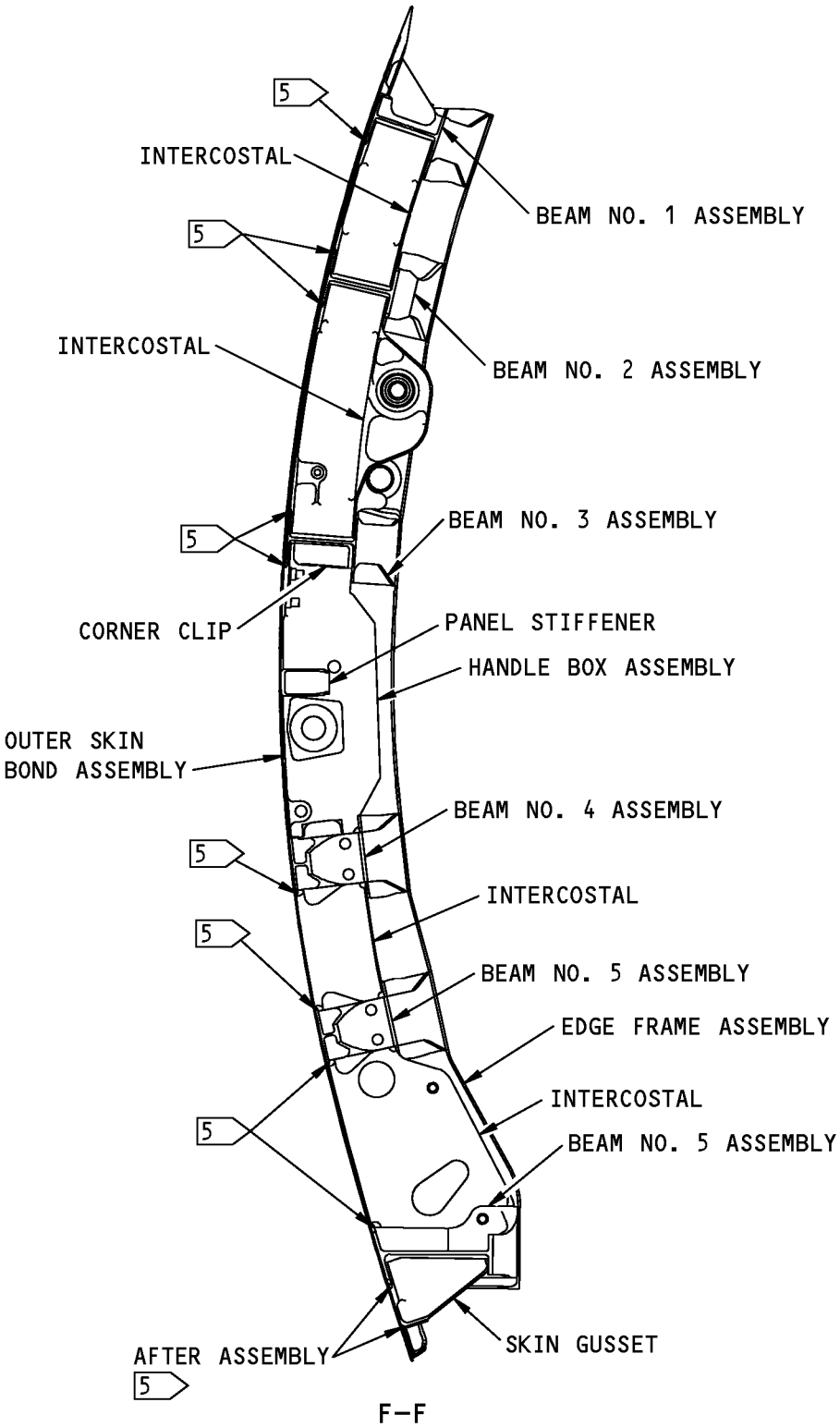
Emergency Exit Door Prmer, Sealant and Corrosion Inhibiting Compound Detaills
Figure 701 (Sheet 3 of 14)



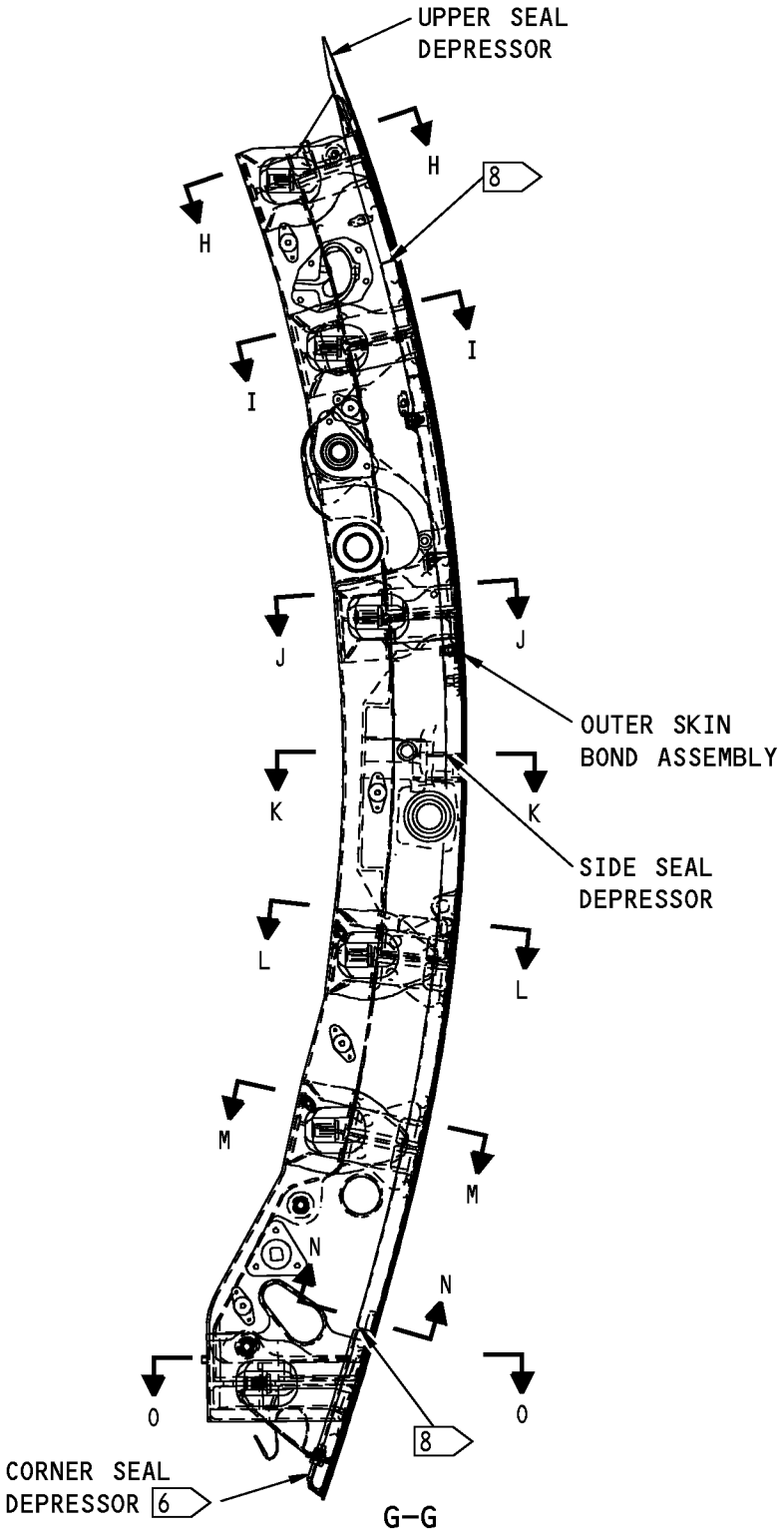
Emergency Exit Door Prmer, Sealant and Corrosion Inhibiting Compound Detaills
Figure 701 (Sheet 4 of 14)



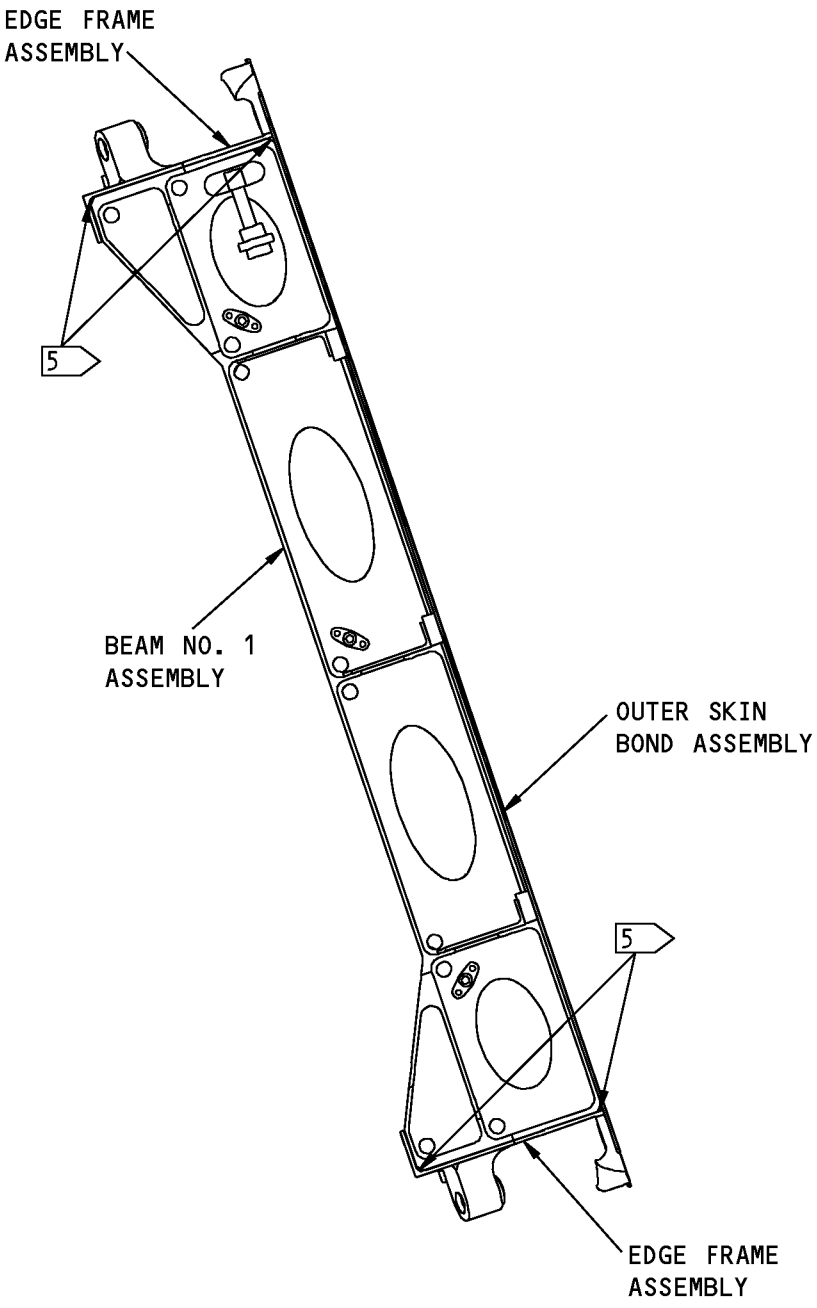
Emergency Exit Door Prmer, Sealant and Corrosion Inhibiting Compound Detaills
Figure 701 (Sheet 5 of 14)



Emergency Exit Door Prmer, Sealant and Corrosion Inhibiting Compound Detaills
Figure 701 (Sheet 6 of 14)

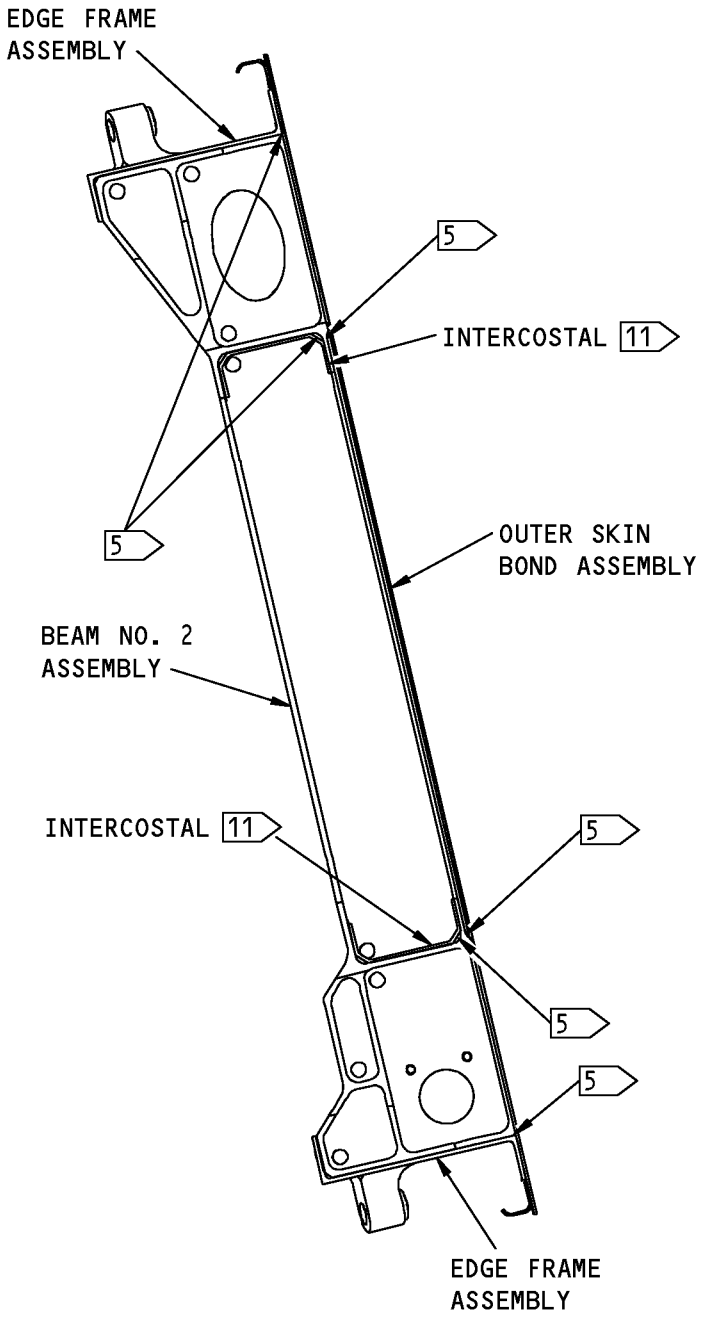


Emergency Exit Door Prmer, Sealant and Corrosion Inhibiting Compound Detaills
Figure 701 (Sheet 7 of 14)



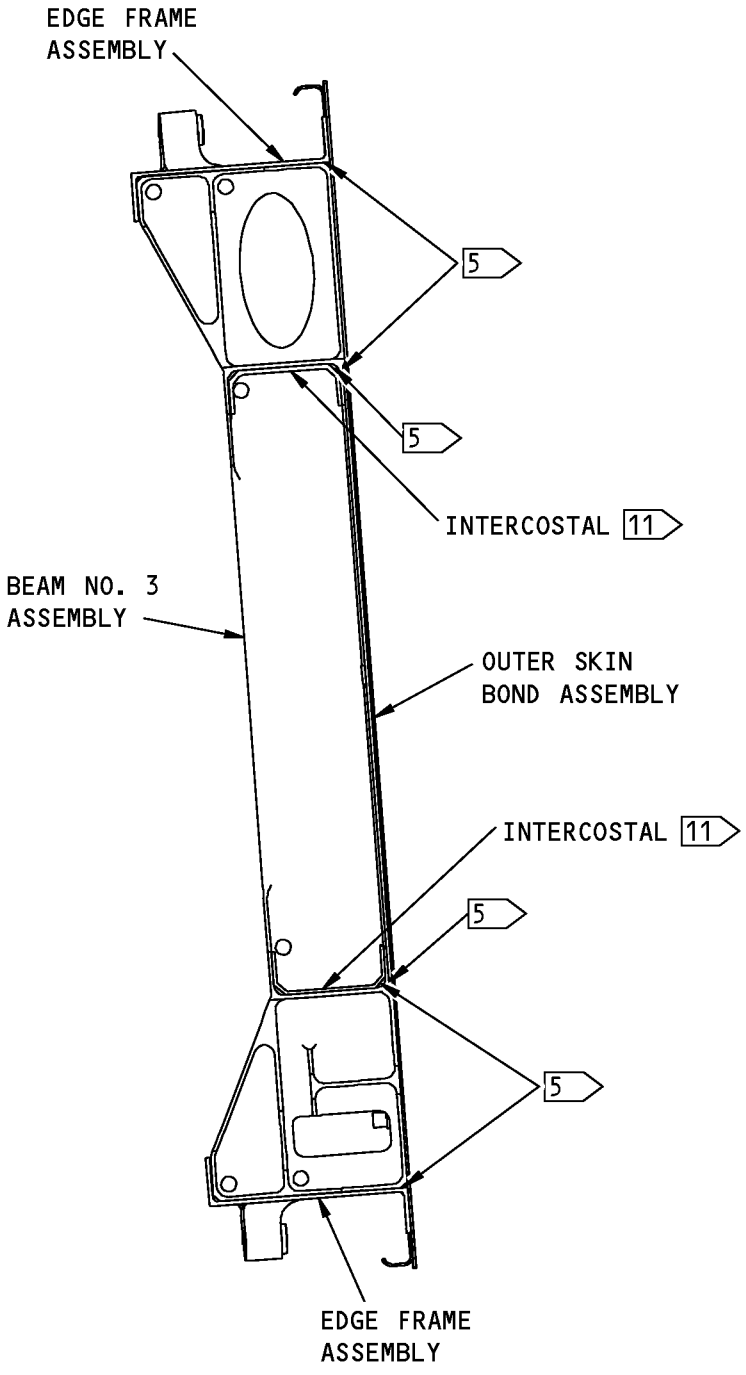
H–H

Emergency Exit Door Prmer, Sealant and Corrosion Inhibiting Compound Detaills
Figure 701 (Sheet 8 of 14)

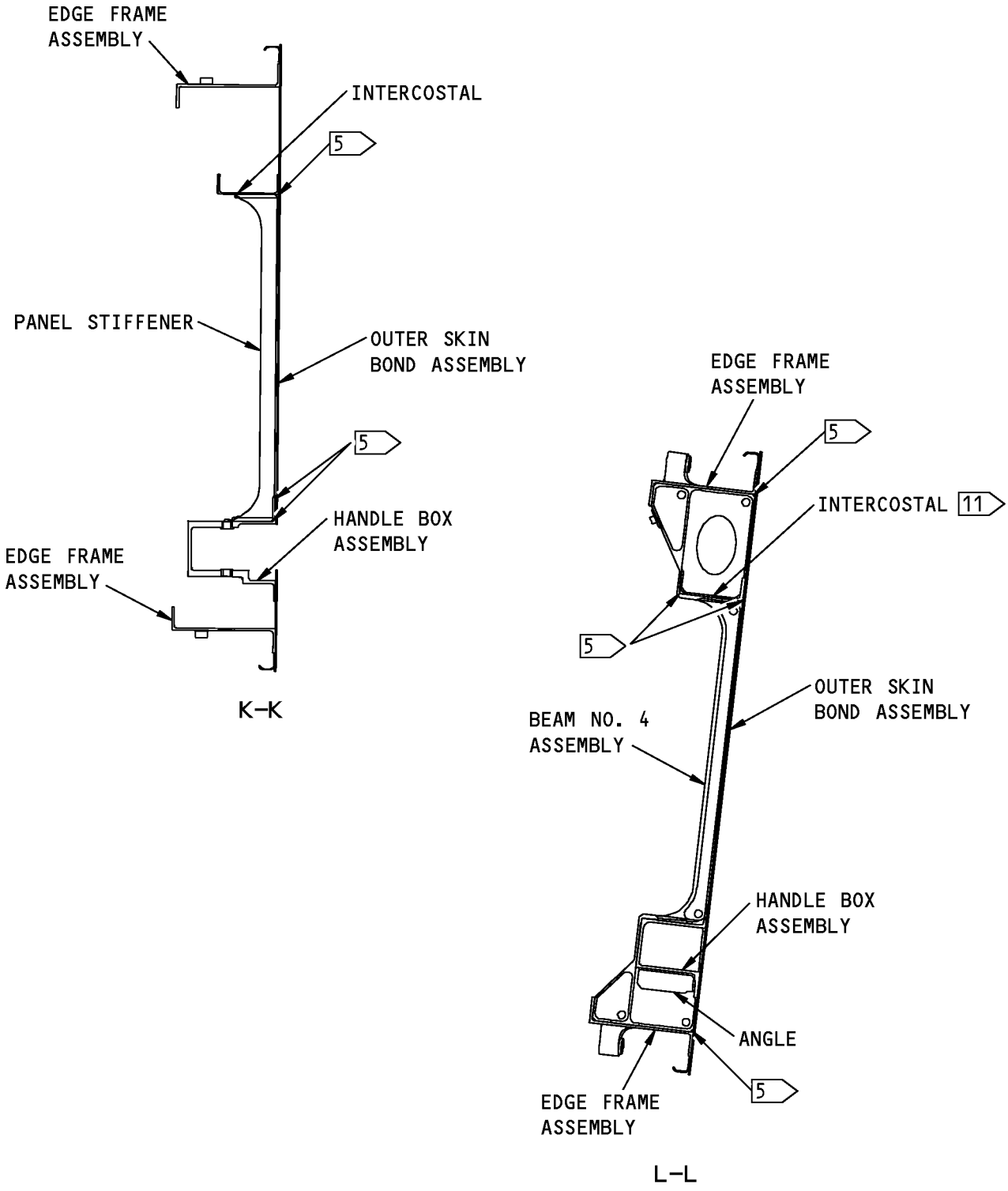


I-I

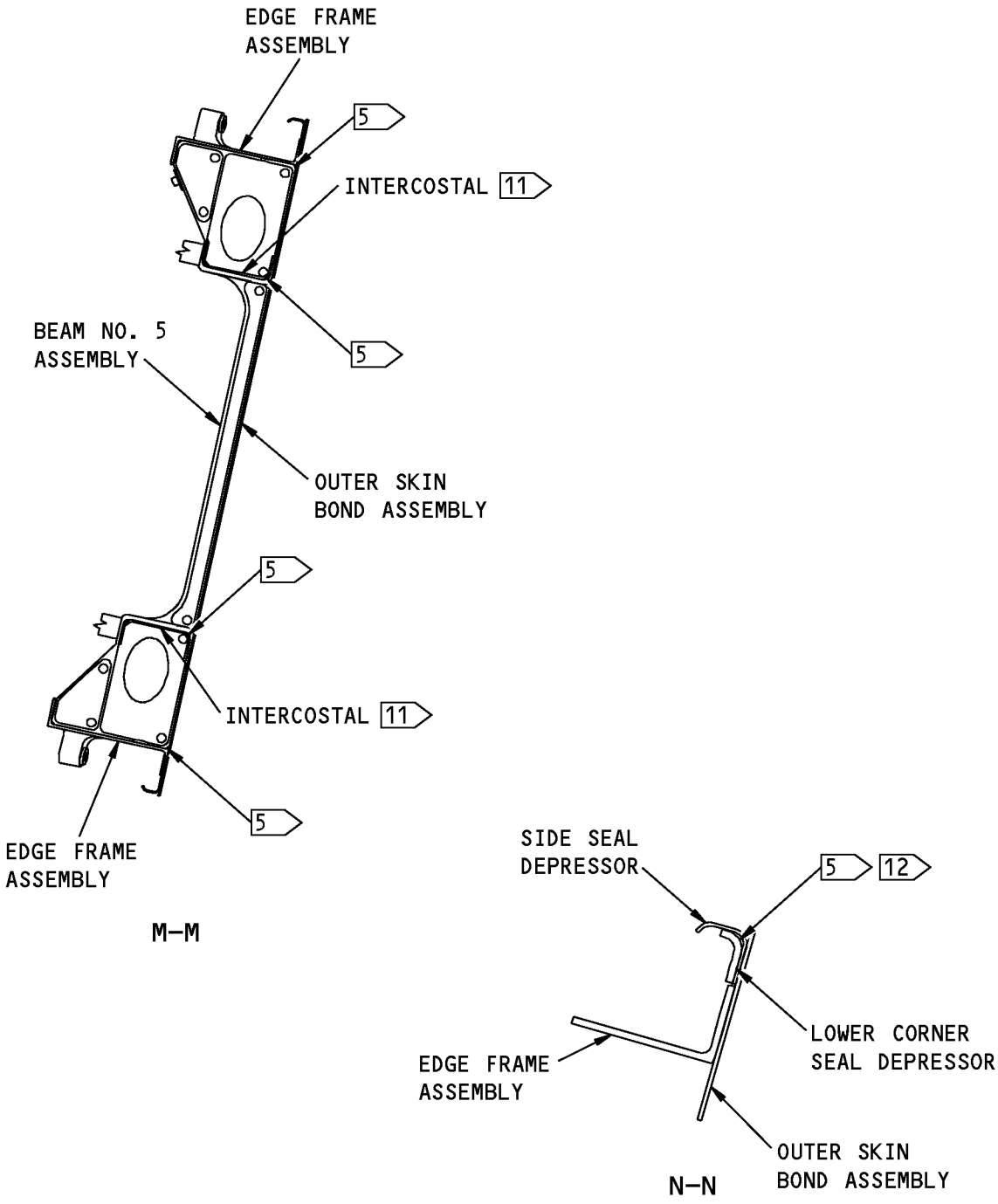
Emergency Exit Door Prmer, Sealant and Corrosion Inhibiting Compound Detaills
Figure 701 (Sheet 9 of 14)



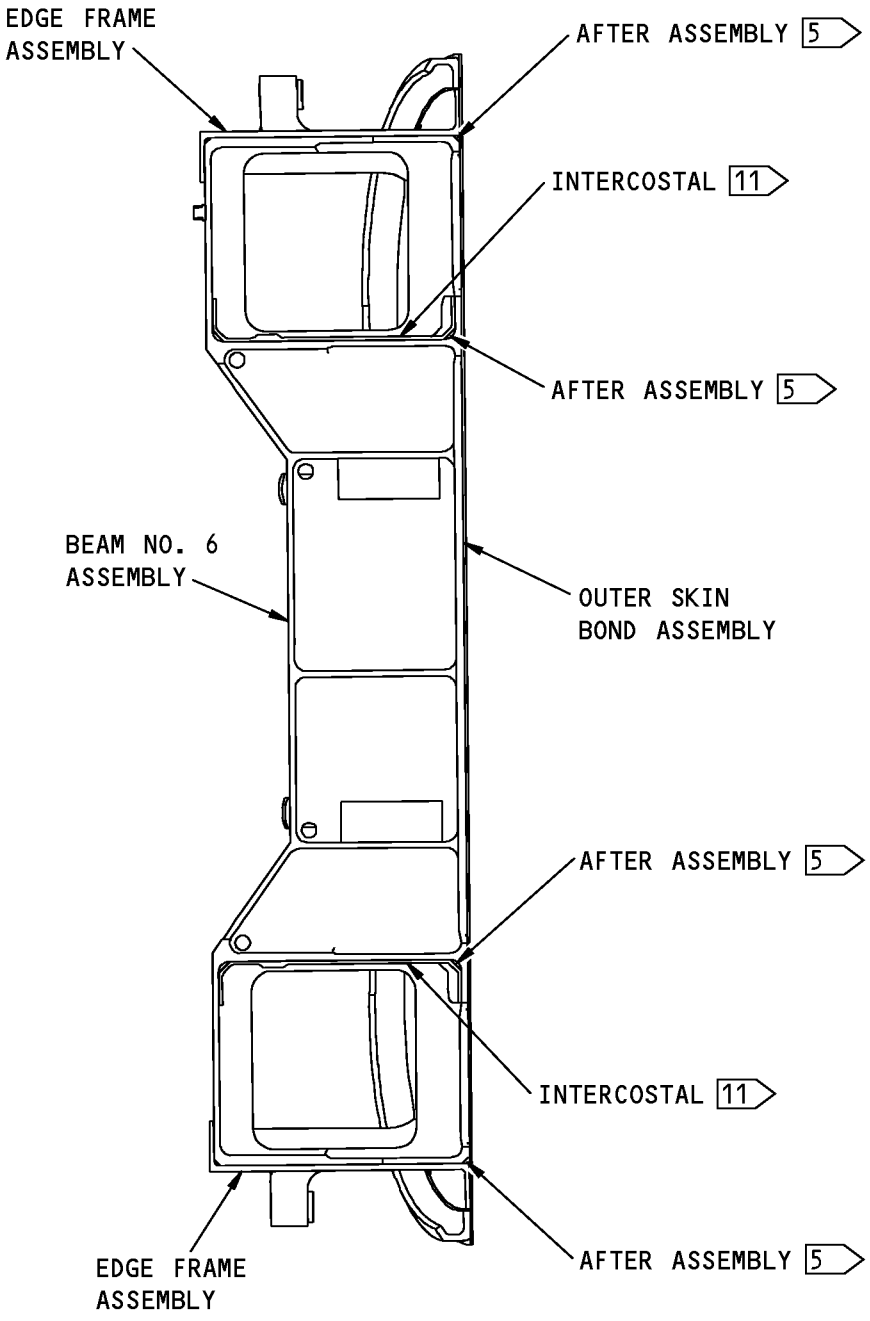
Emergency Exit Door Prmer, Sealant and Corrosion Inhibiting Compound Detaills
Figure 701 (Sheet 10 of 14)



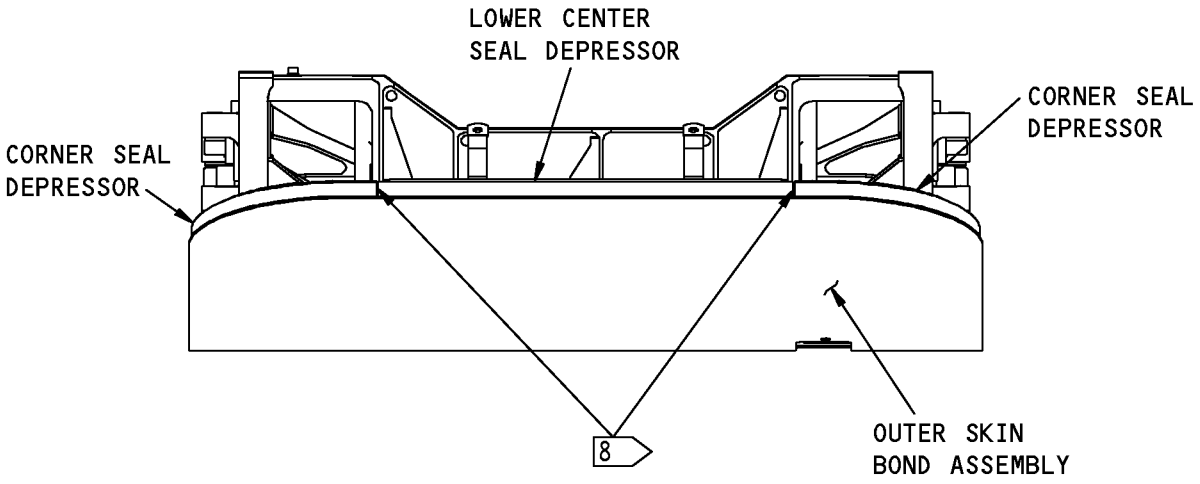
Emergency Exit Door Prmer, Sealant and Corrosion Inhibiting Compound Detaills
Figure 701 (Sheet 11 of 14)



Emergency Exit Door Prmer, Sealant and Corrosion Inhibiting Compound Detaills
Figure 701 (Sheet 12 of 14)



Emergency Exit Door Prmer, Sealant and Corrosion Inhibiting Compound Detaills
Figure 701 (Sheet 13 of 14)



P–P

1 FILLET SEAL AROUND THE INTERFACE BETWEEN THIS PART AND THE DOOR SKIN BOND ASSEMBLY WITH BMS 5-142 SEALANT (SOPM 20-50-19). MAKE A SMOOTH JOINT WITH INJECTION SEALS THAT COULD BE AROUND THIS SAME PART

2 MAKE AN AERODYNAMIC QUALITY SEAL. FILL THE GAP WITH BMS 5-142 SEALANT, AND MAKE IT SMOOTH WITH THE ADJACENT SURFACES. MAKE A SMOOTH JOINT WITH INJECTION SEALS THAT COULD BE AROUND THIS SAME PART

3 FAY SURFACE SEAL (SOPM 20-50-19) DURING ASSEMBLY

4 APPLY BMS 3-23 TYPE 2 CORROSION INHIBITING COMPOUND (SOPM 20-41-05) TO ALL ACCESSIBLE INTERNAL SURFACES OF THE DOOR STRUCTURE

5 INJECTION SEAL THE CHAMFER OR FILLET WITH BMS 5-142 SEALANT (SOPM 20-50-19)

6 FILL WITH BMS 5-142 SEALANT ALL ALONG THE INTERFACE BETWEEN THE SEAL DEPRESSOR AND THE DOOR SKIN, AND MAKE IT SMOOTH WITH THE ADJACENT SURFACES

7 SEAL THE INSIDE CORNERS OF THE HANDLE BOX. FILL ALL GAPS AND FILLET SEAL ALL SEAMS IN THIS AREA WITH BMS 5-142 SEALANT (SOPM 20-50-19)

8 FILL THE GAP BETWEEN THE SEAL DEPRESSOR WITH BMS 5-142 SEALANT. REMOVE THE SEALANT FROM THE EXTERIOR SURFACES OF THE SEAL DEPRESSORS. MAKE SURE THE SEALANT IS FLUSH, TO HELP PREVENT AIR LEAKS THROUGH THE PRESSURE SEAL

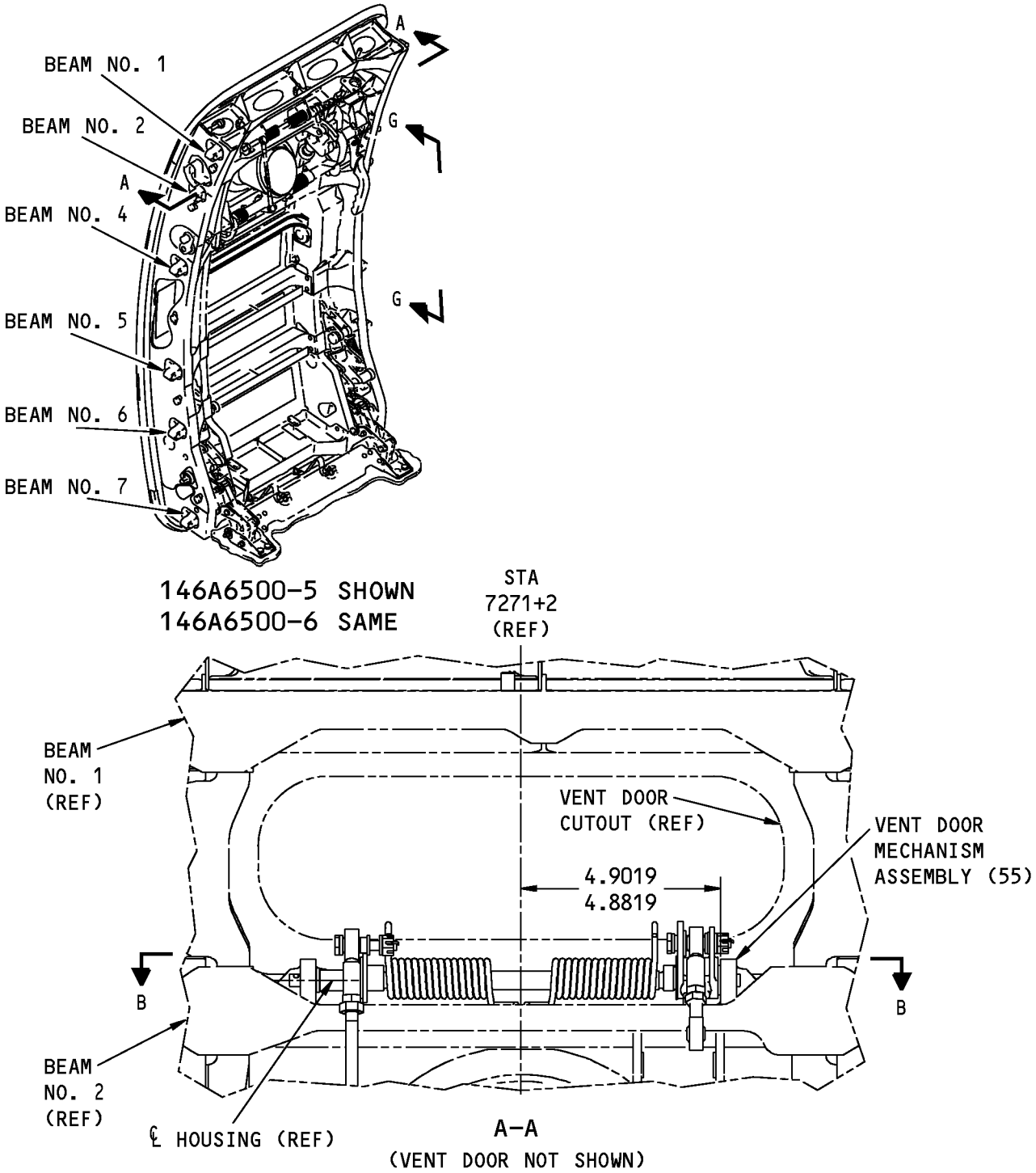
9 KEEP THE DRAIN HOLE OPEN. DO NOT LET SEALANT CAUSE A BLOCKAGE

10 SEAL INSTRUCTIONS ARE TYPICAL FOR EACH END OF THE CENTER AND LOWER SEAL DEPRESSORS

11 SEAL INSTRUCTIONS ARE TYPICAL FOR EACH END OF THE INTERCOSTAL

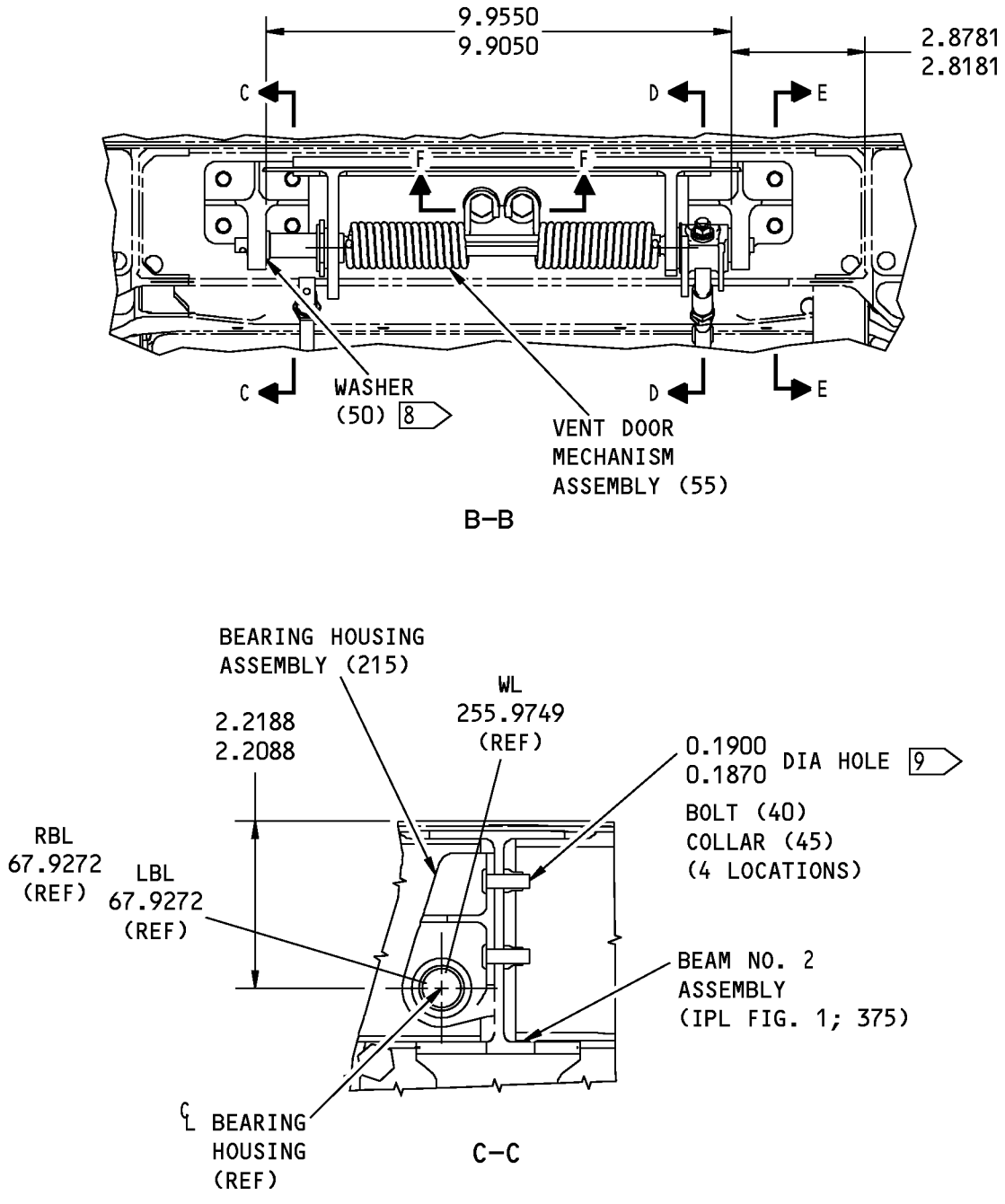
12 TYPICAL FOR LAP AREAS BETWEEN THE SIDE AND LOWER CORNER SEAL DEPRESSORS

Emergency Exit Door Prmer, Sealant and Corrosion Inhibiting Compound Detaills
Figure 701 (Sheet 14 of 14)

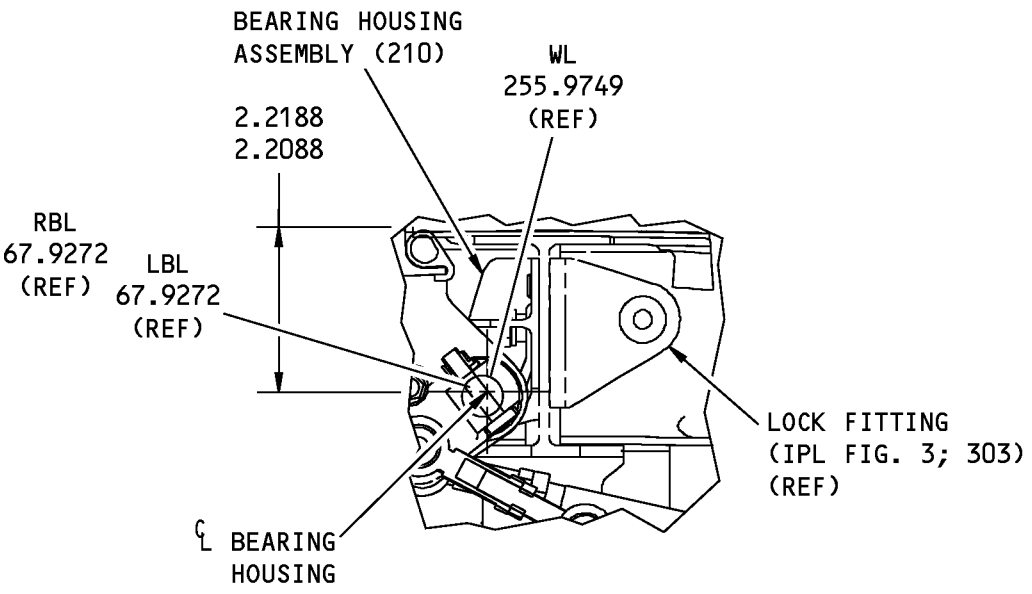


NOTE: MECHANISM SHOWN IN CLOSED, LATCHED, LOCKED POSITION UNLESS SHOWN DIFFERENTLY.

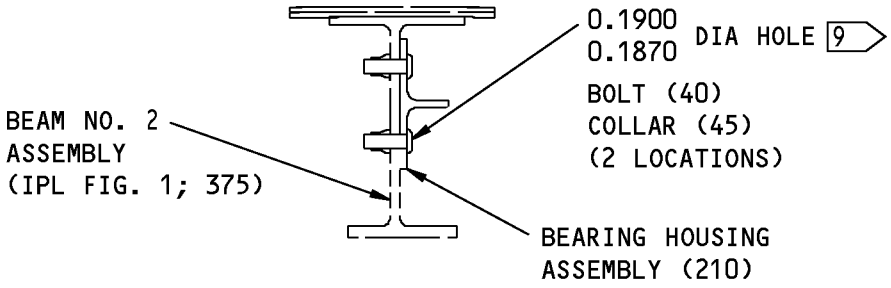
146A6500-5,-6 Door Upper Region Mechanism Installation Details
Figure 702 (Sheet 1 of 12)



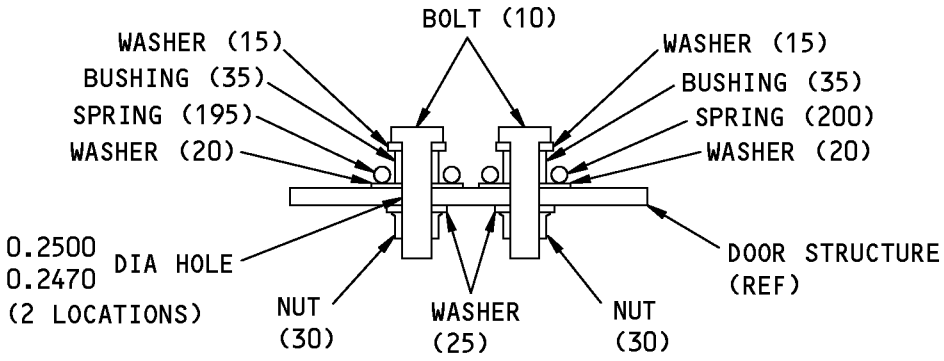
146A6500-5,-6 Door Upper Region Mechanism Installation Details
Figure 702 (Sheet 2 of 12)



D–D

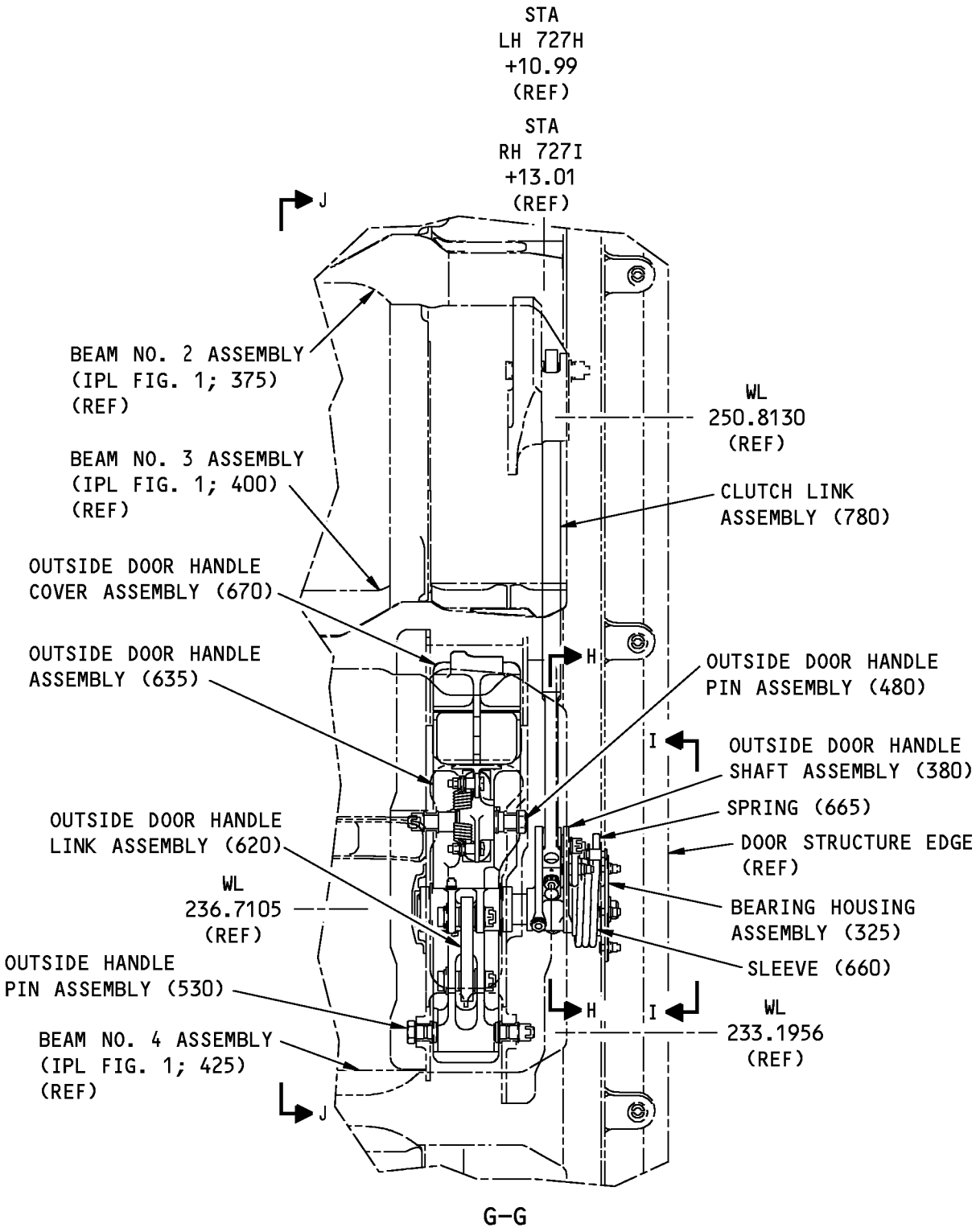


E–E

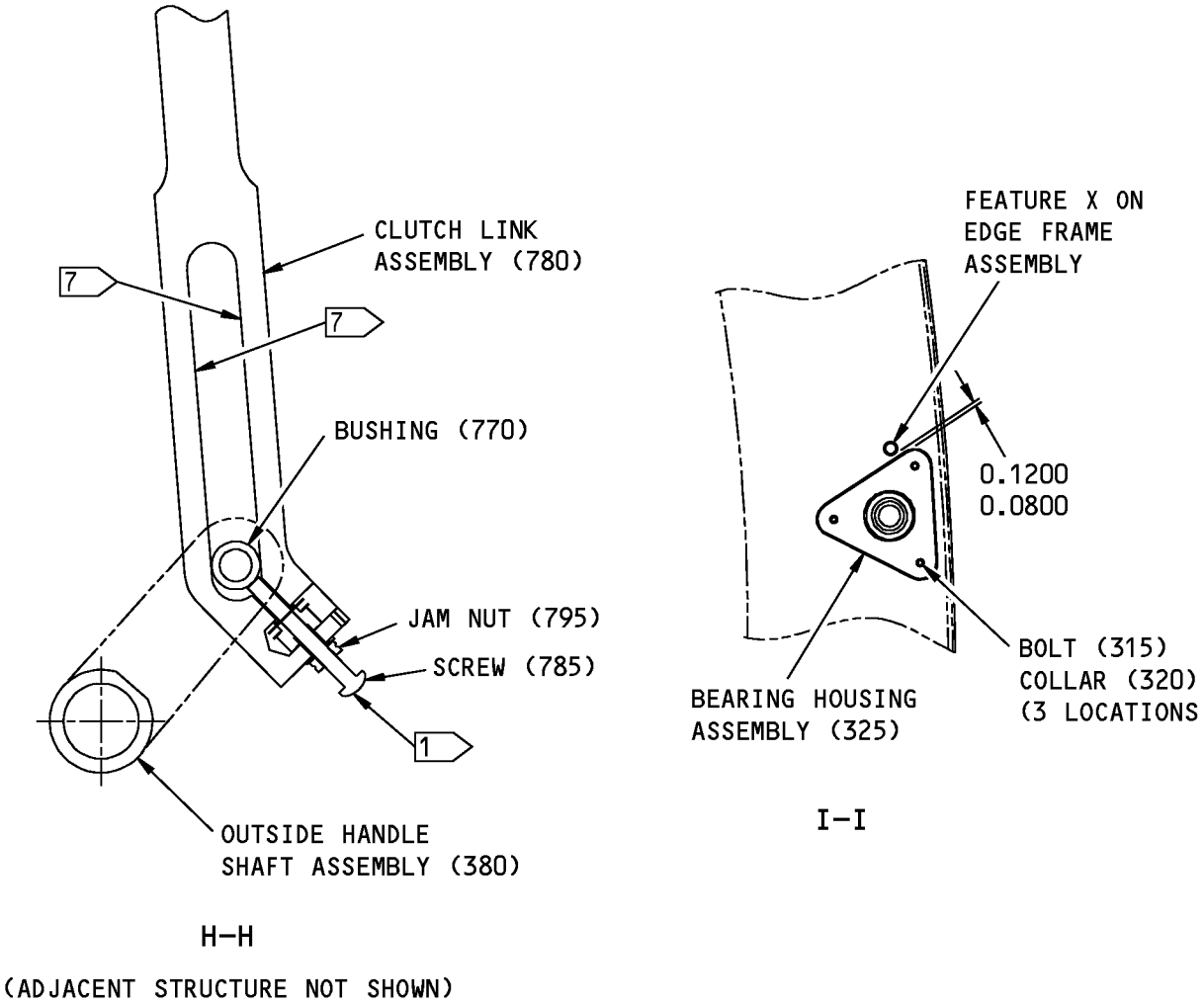


F–F

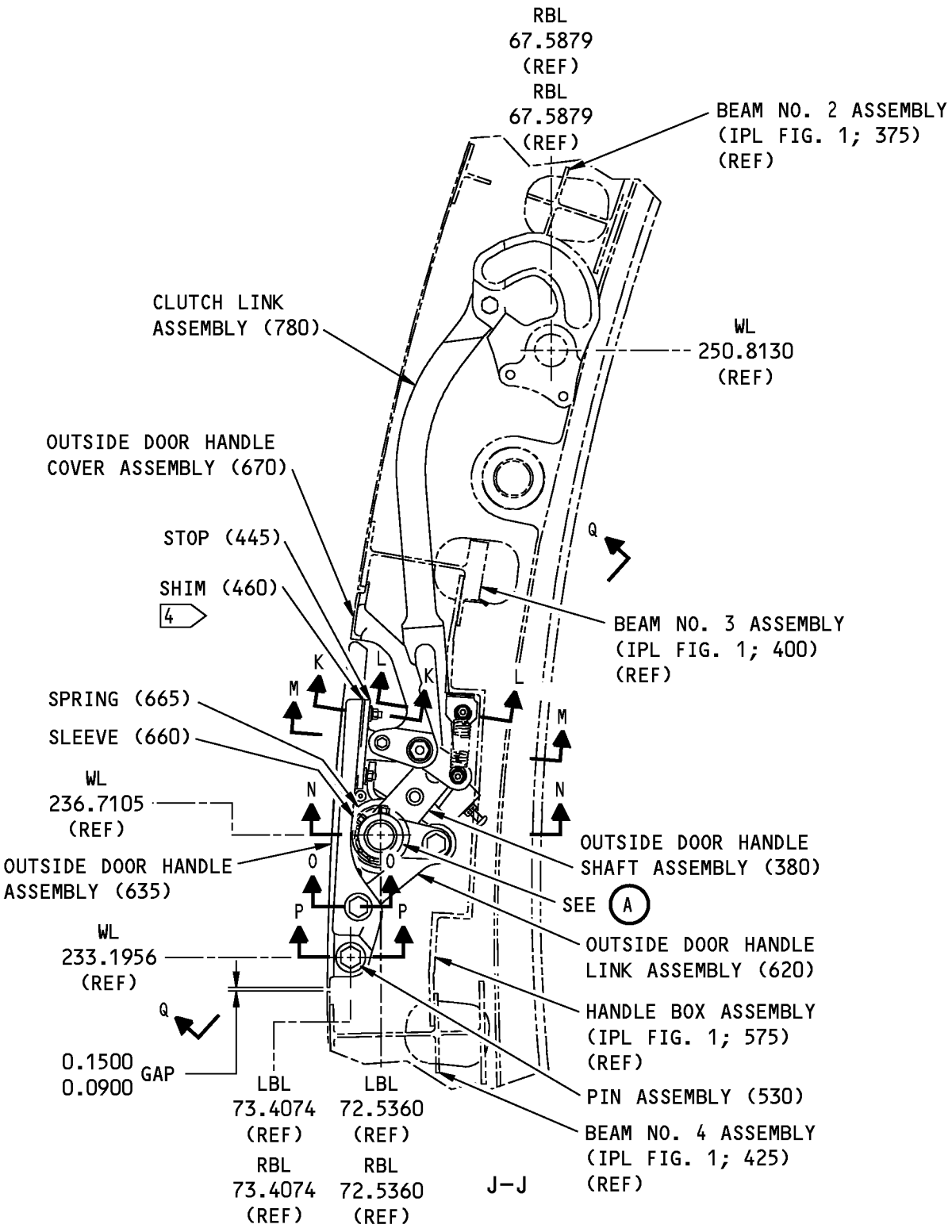
146A6500-5,-6 Door Upper Region Mechanism Installation Details
Figure 702 (Sheet 3 of 12)



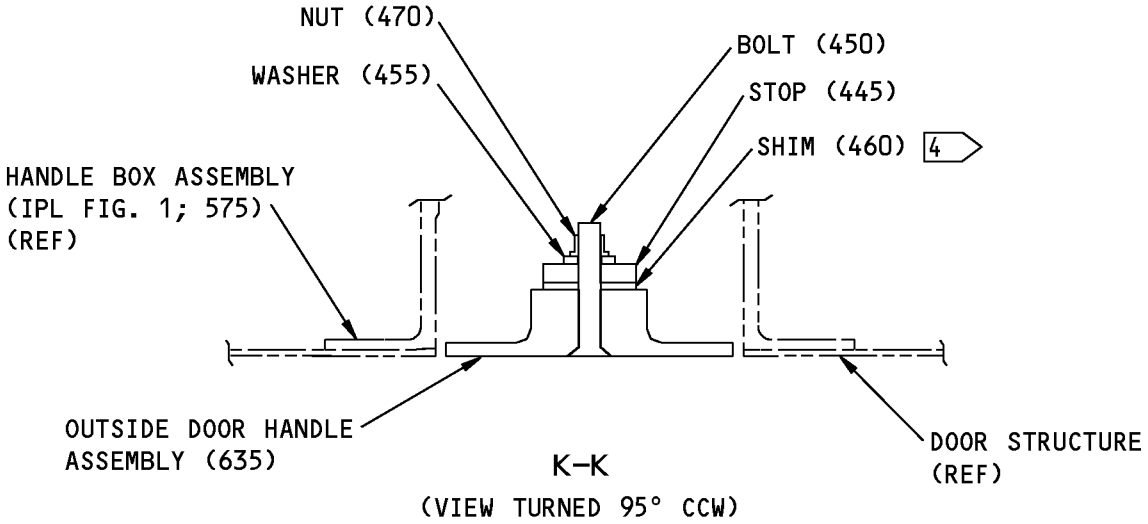
146A6500-5,-6 Door Upper Region Mechanism Installation Details
Figure 702 (Sheet 4 of 12)



146A6500-5,-6 Door Upper Region Mechanism Installation Details
Figure 702 (Sheet 5 of 12)

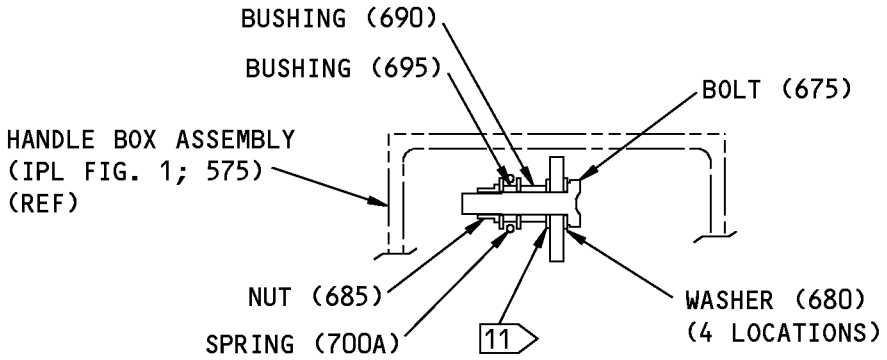


146A6500-5,-6 Door Upper Region Mechanism Installation Details
Figure 702 (Sheet 6 of 12)



K–K

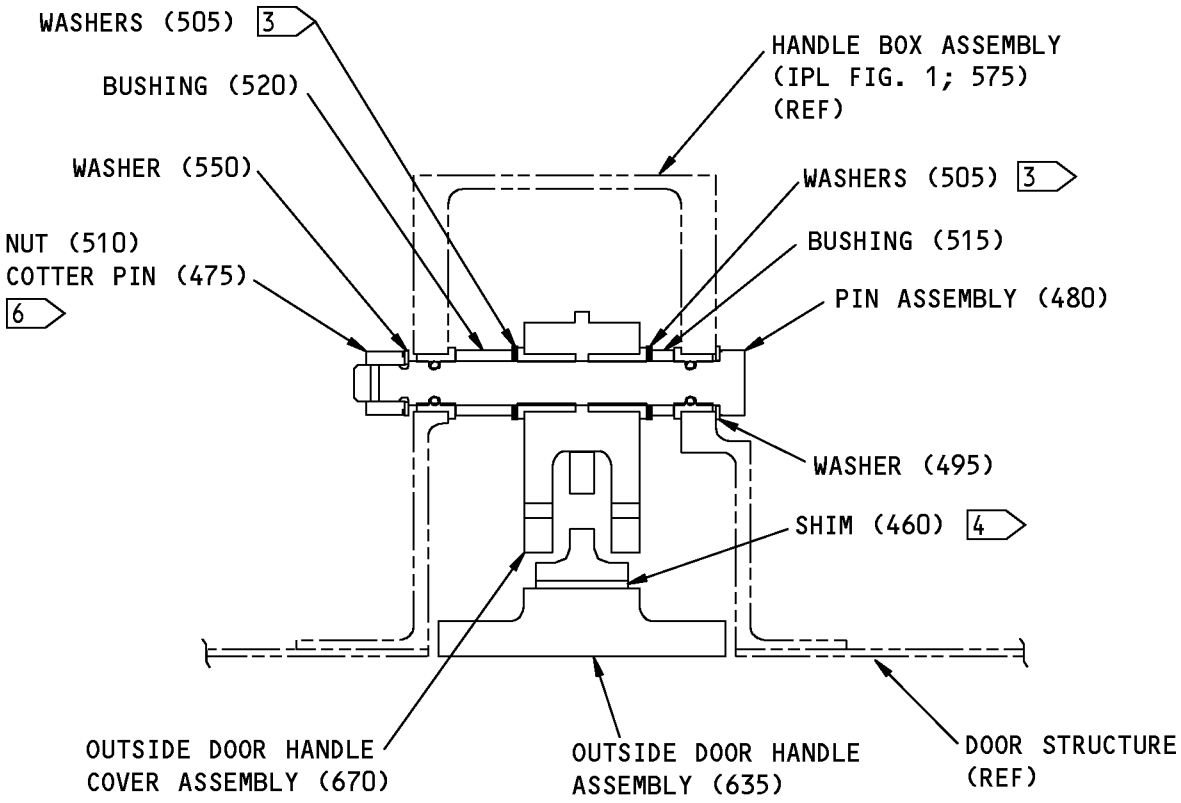
(VIEW TURNED 95° CCW)



L–L

(VIEW TURNED 93.5° CCW)

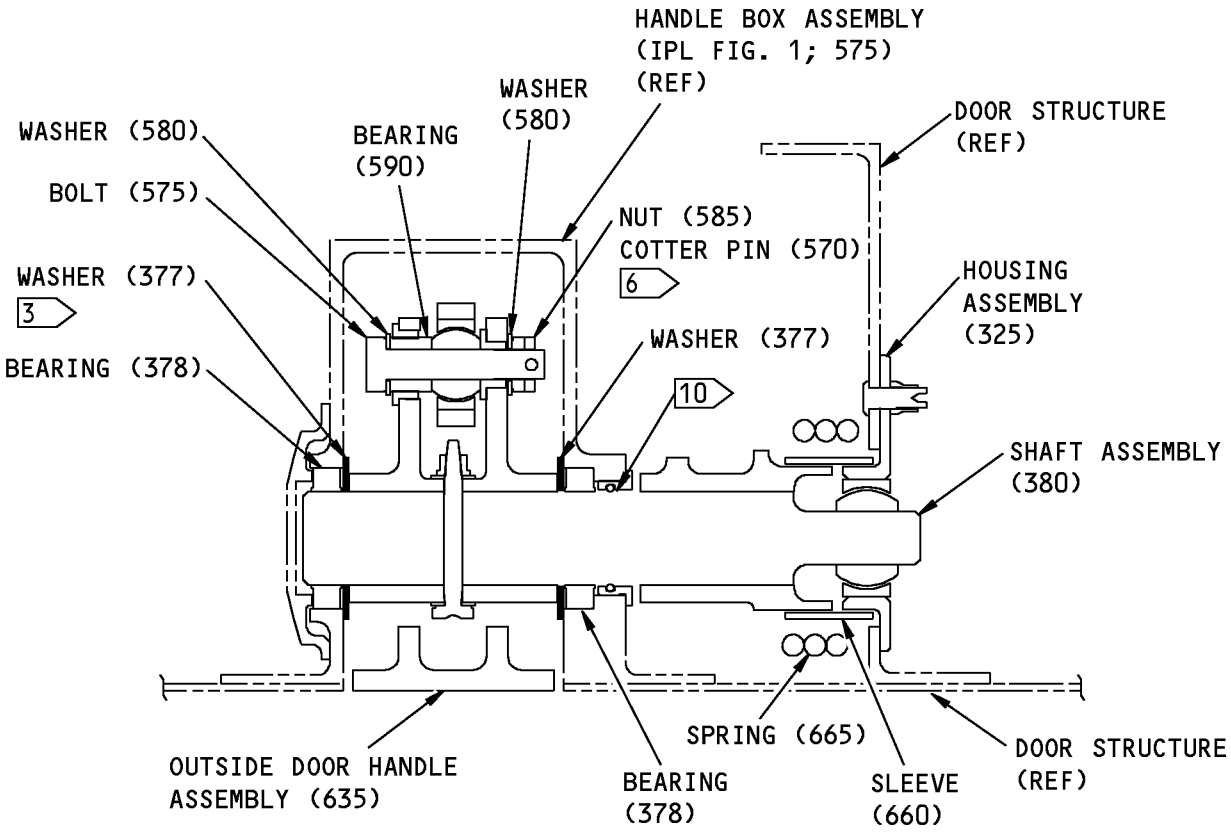
146A6500-5,-6 Door Upper Region Mechanism Installation Details
Figure 702 (Sheet 7 of 12)



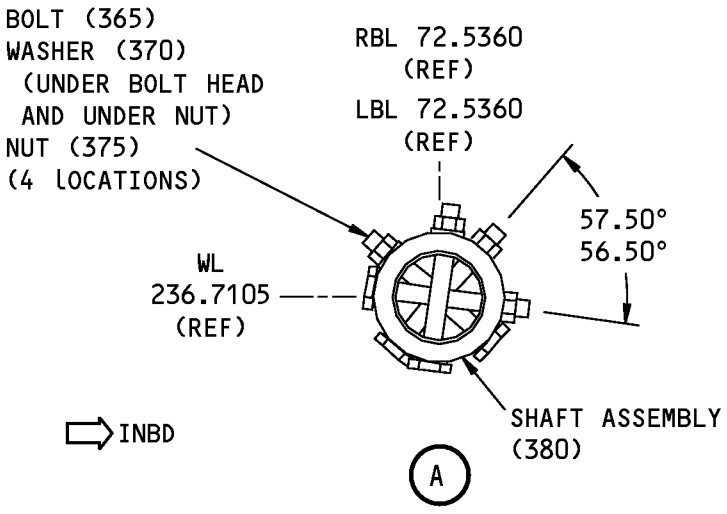
M–M

(VIEW TURNED 93° CCW)

146A6500-5,-6 Door Upper Region Mechanism Installation Details
Figure 702 (Sheet 8 of 12)

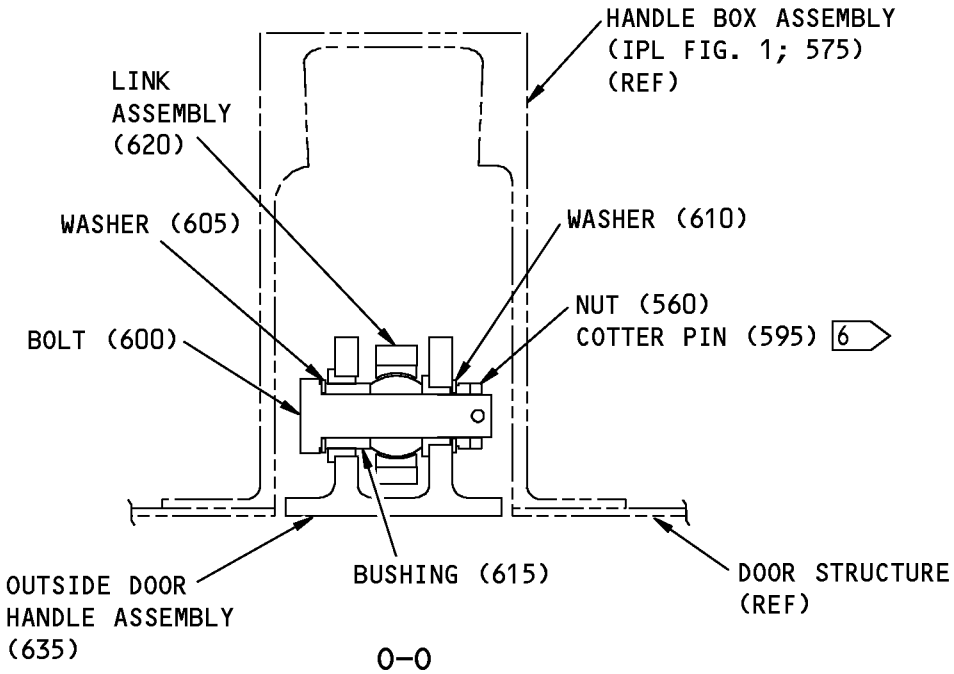


N-N



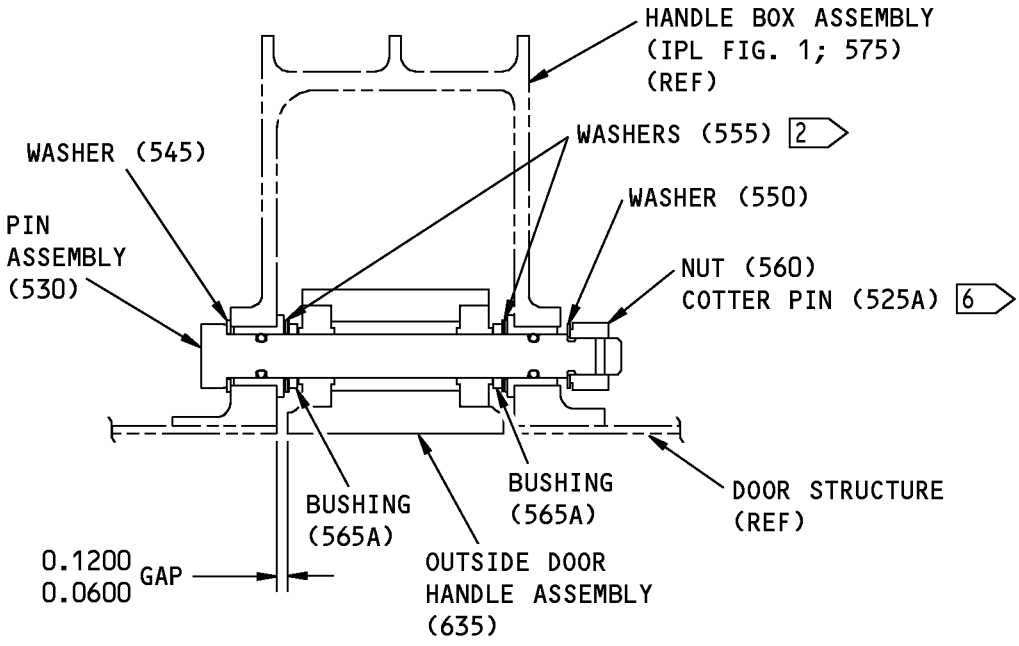
(ADJACENT STRUCTURE NOT SHOWN)

146A6500-5,-6 Door Upper Region Mechanism Installation Details
Figure 702 (Sheet 9 of 12)



O–O

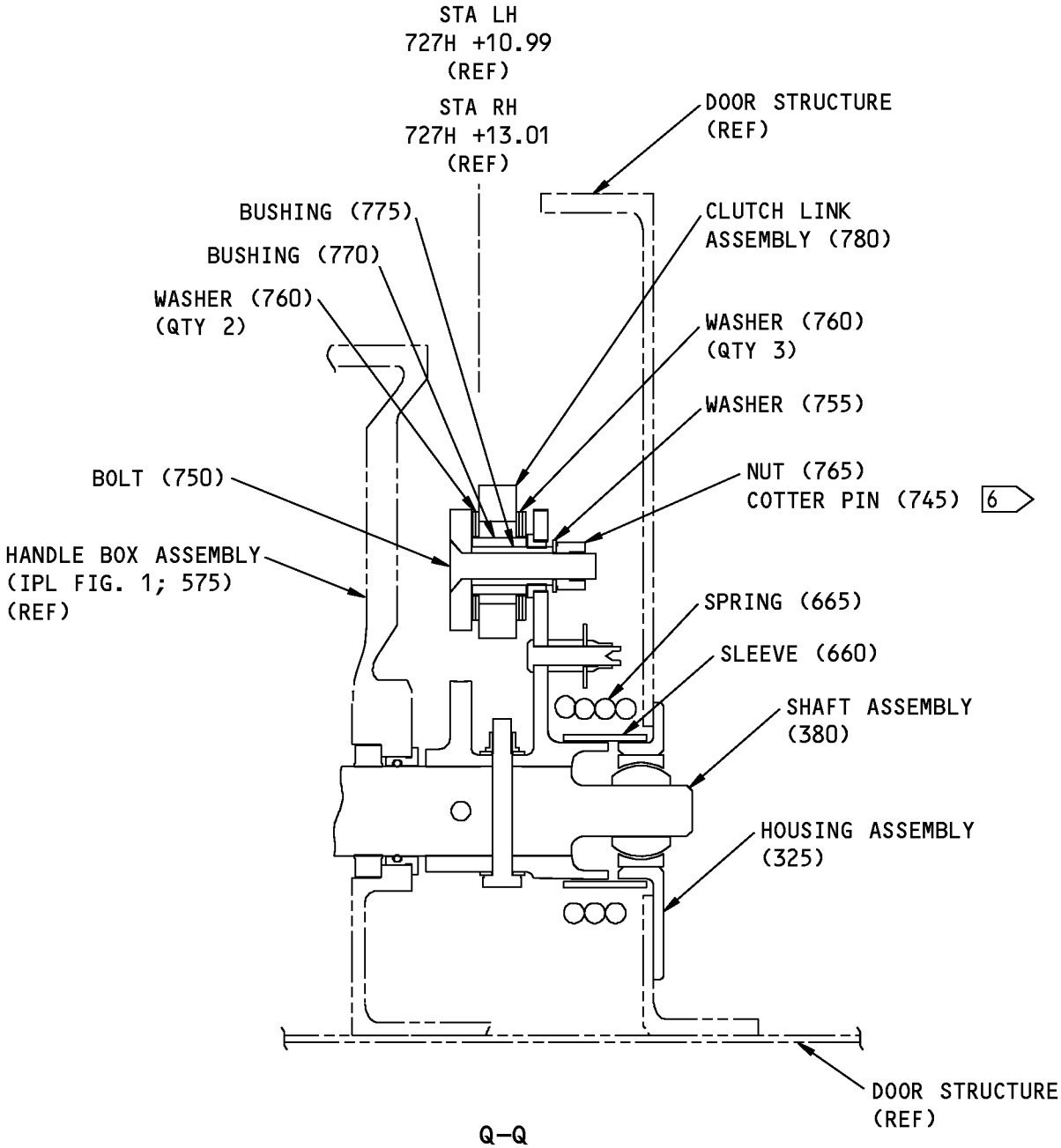
(VIEW TURNED 92° CCW)



P–P

(VIEW TURNED 90° CCW)

146A6500-5,-6 Door Upper Region Mechanism Installation Details
Figure 702 (Sheet 10 of 12)



146A6500-5,-6 Door Upper Region Mechanism Installation Details
Figure 702 (Sheet 11 of 12)

1 > BEFORE INSTALLATION, BACK OFF THIS SCREW TO REMOVE INTERFERENCE WITH RIGGING OF OUTSIDE HANDLE OR ITS COVER. AFTER RIGGING IS COMPLETE, TIGHTEN THIS SCREW TO 10 POUND-INCHES MAXIMUM, THEN BACK IT OFF 1/2 TURN AND LOCK IT DOWN WITH THE JAM NUT. LOCKWIRE THE JAM NUT (SOPM 20-50-02).

2 > INSTALL WASHERS AS NECESSARY TO GET 0.0010-0.0160 INCH SIDE FREE PLAY AT THE HANDLE AND TO GET THE GAP SHOWN AT THE OUTSIDE HANDLE. THE SIDE GAPS MUST BE MORE THAN 0.0300 INCH DIFFERENT.

3 > INSTALL THESE WASHERS AS NECESSARY, MINIMUM OF ONE PER SIDE, TO GET 0.0100-0.0300 INCH PLAY.

4 > REMOVE 0.003-INCH LAMINATIONS FROM THE SHIM AS NECESSARY TO MAKE THE SURFACE OF THE OUTSIDE DOOR HANDLE SMOOTH WITH THE DOOR OUTSIDE SKIN SURFACE WITHIN 0.030 INCH. FAY SURFACE SEAL ALL OF THE SHIM MATING SURFACES WITH BMS 5-95 SEALANT (SOPM 20-50-19)

5 > BE SURE THE SPRING HOOKS ARE BETWEEN THE ADJACENT WASHERS AT EACH END, AS SHOWN.

6 > INSTALL THE COTTER PIN (SOPM 20-50-02)

7 > APPLY BMS 3-8 SOLID FILM LUBRICANT (F-19.10) ALL AROUND THIS SURFACE.

8 > USE THESE WASHERS AS NECESSARY TO GET THE DIMENSIONS SHOWN, WITH 0.0010-0.0160 INCH FREEPLAY.

9 > USE THE PILOT HOLES IN THE BEARING HOUSING ASSEMBLY.

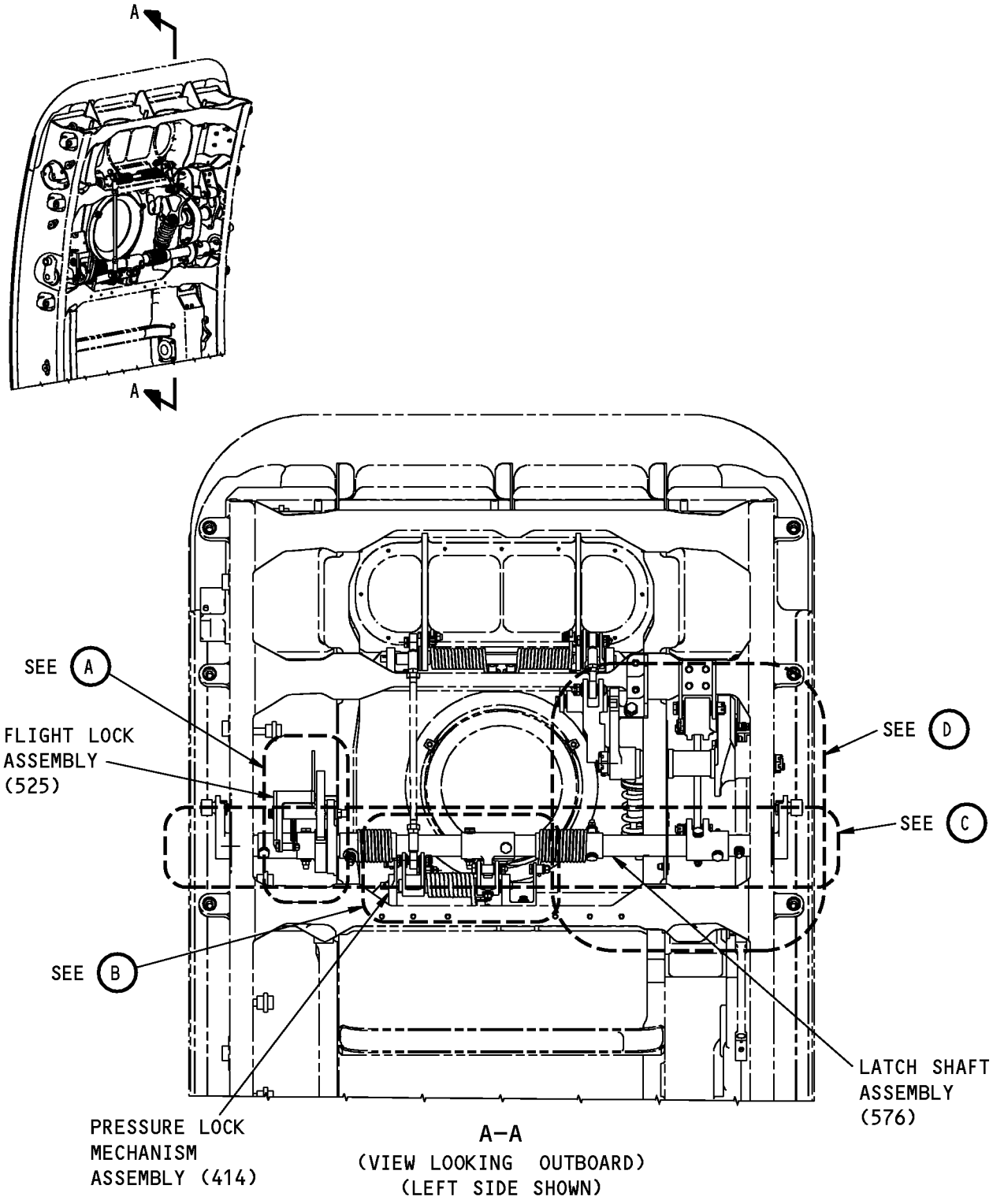
10 > APPLY BMS 3-33 GREASE TO THE SHAFT AS NECESSARY TO BE SURE THERE IS A LAYER OF GREASE AT THE O-RING.

11 > APPLY A THIN LAYER OF BMS 3-38 CORROSION PREVENTITIVE COMPOUND TO THE MATING SURFACES OF THIS WASHER BEFORE YOU INSTALL IT.

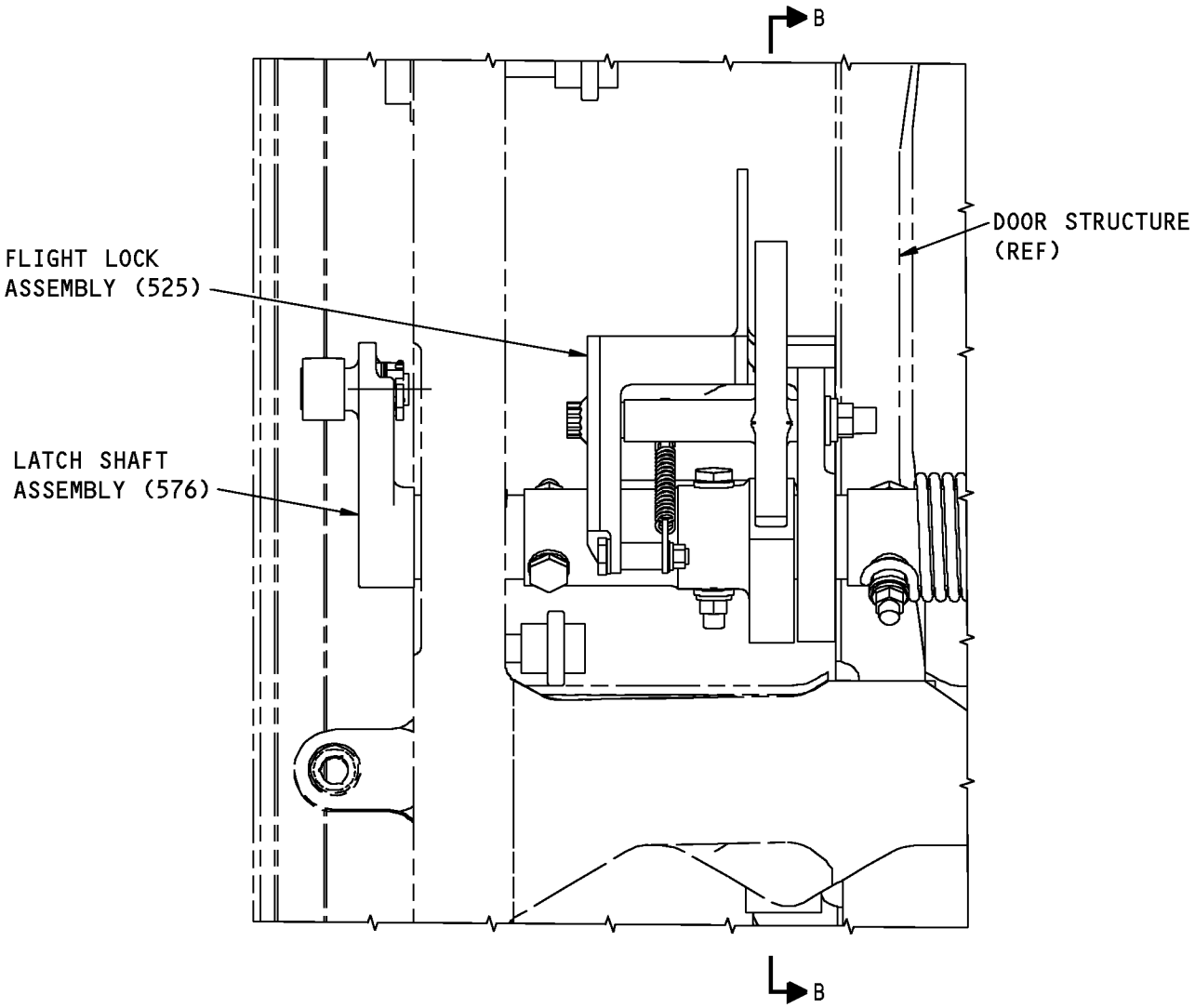
ITEM NUMBERS REFER TO IPL FIG. 2 UNLESS SHOWN DIFFERENTLY

ALL DIMENSIONS ARE IN INCHES

146A6500-5,-6 Door Upper Region Mechanism Installation Details
Figure 702 (Sheet 12 of 12)



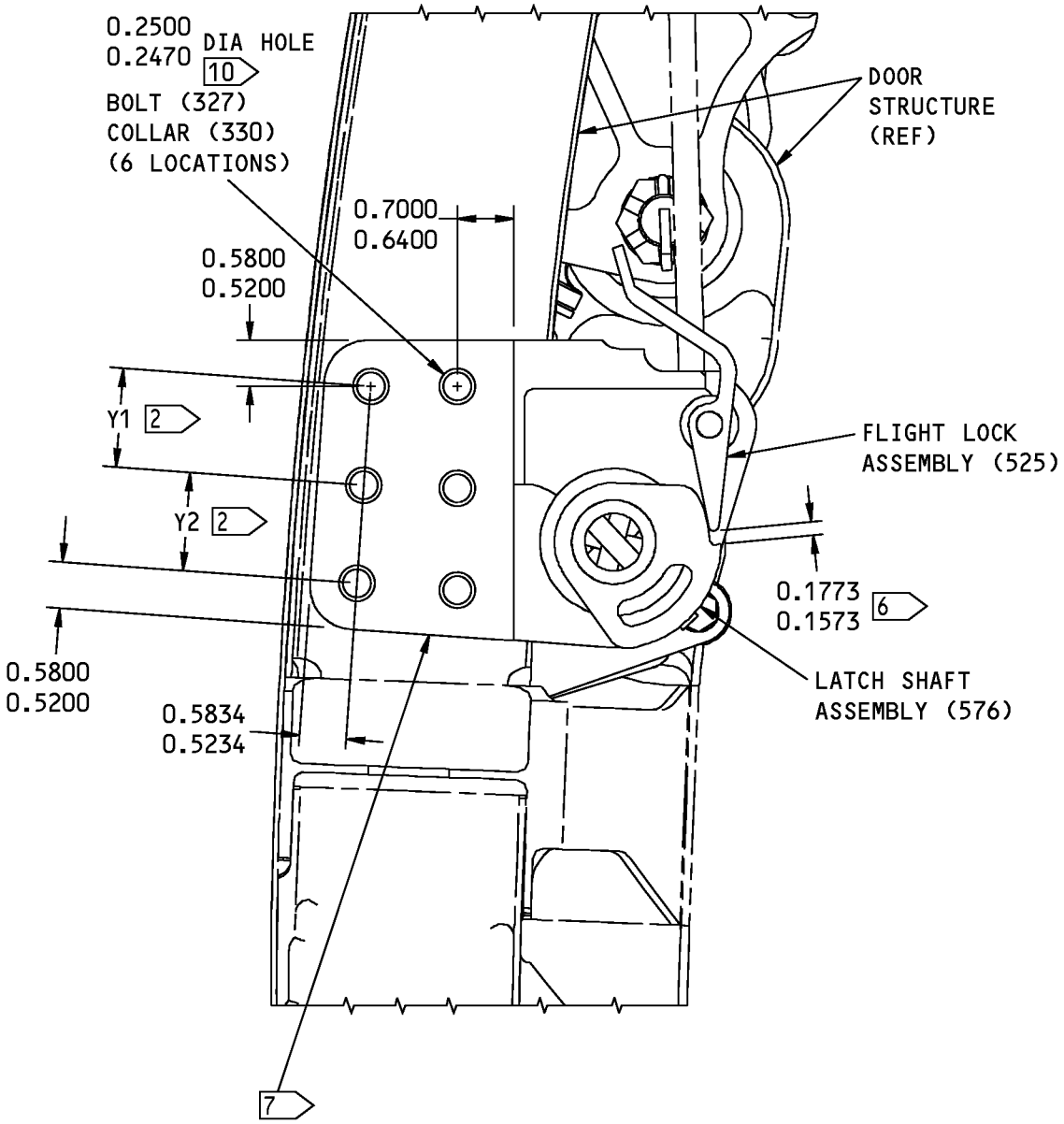
146A6500-3,-4 More Door Upper Region Mechanism Installation Details
Figure 703 (Sheet 1 of 23)



FLIGHT LOCK ASSEMBLY

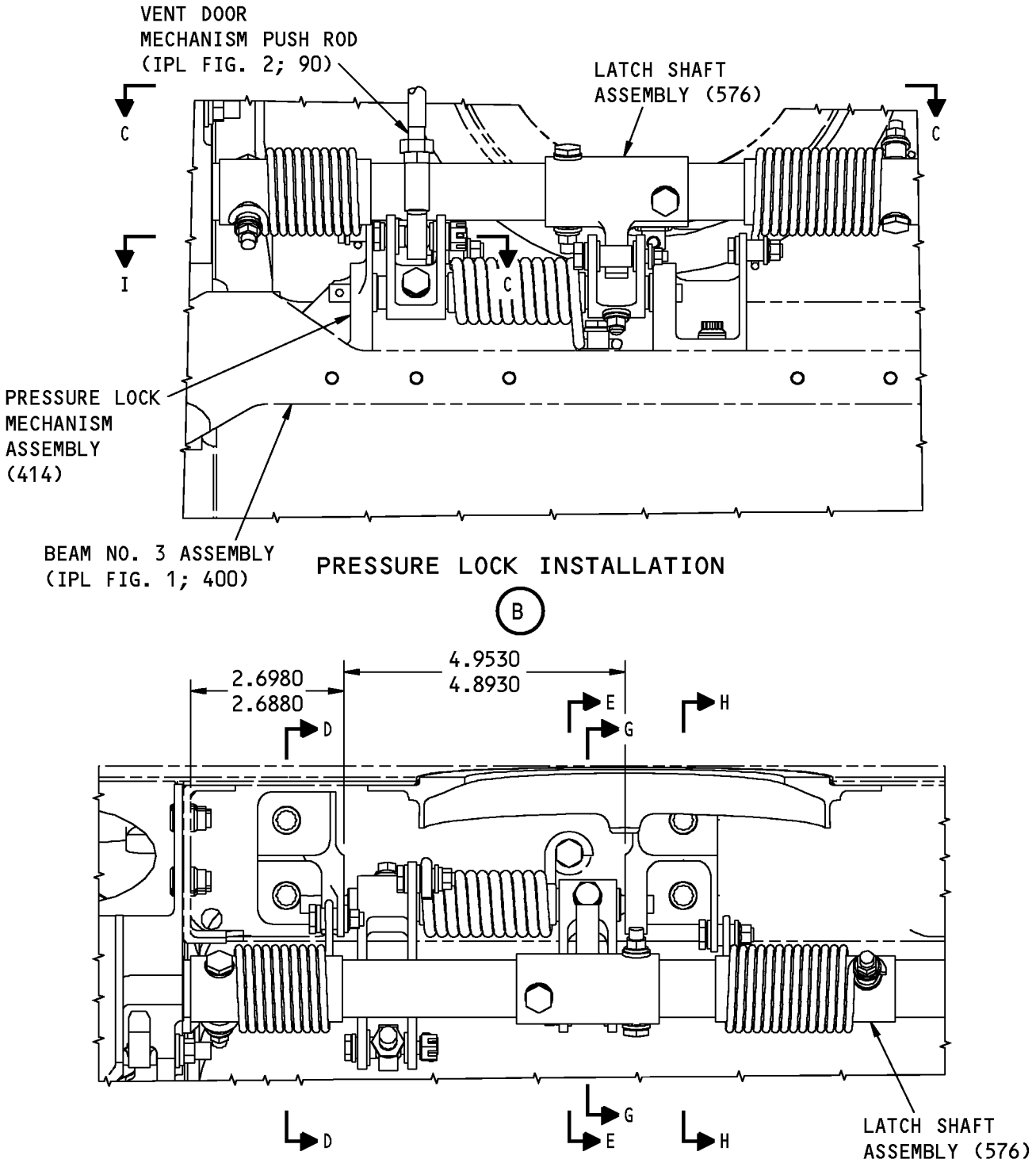
(A)

146A6500-3,-4 More Door Upper Region Mechanism Installation Details
Figure 703 (Sheet 2 of 23)

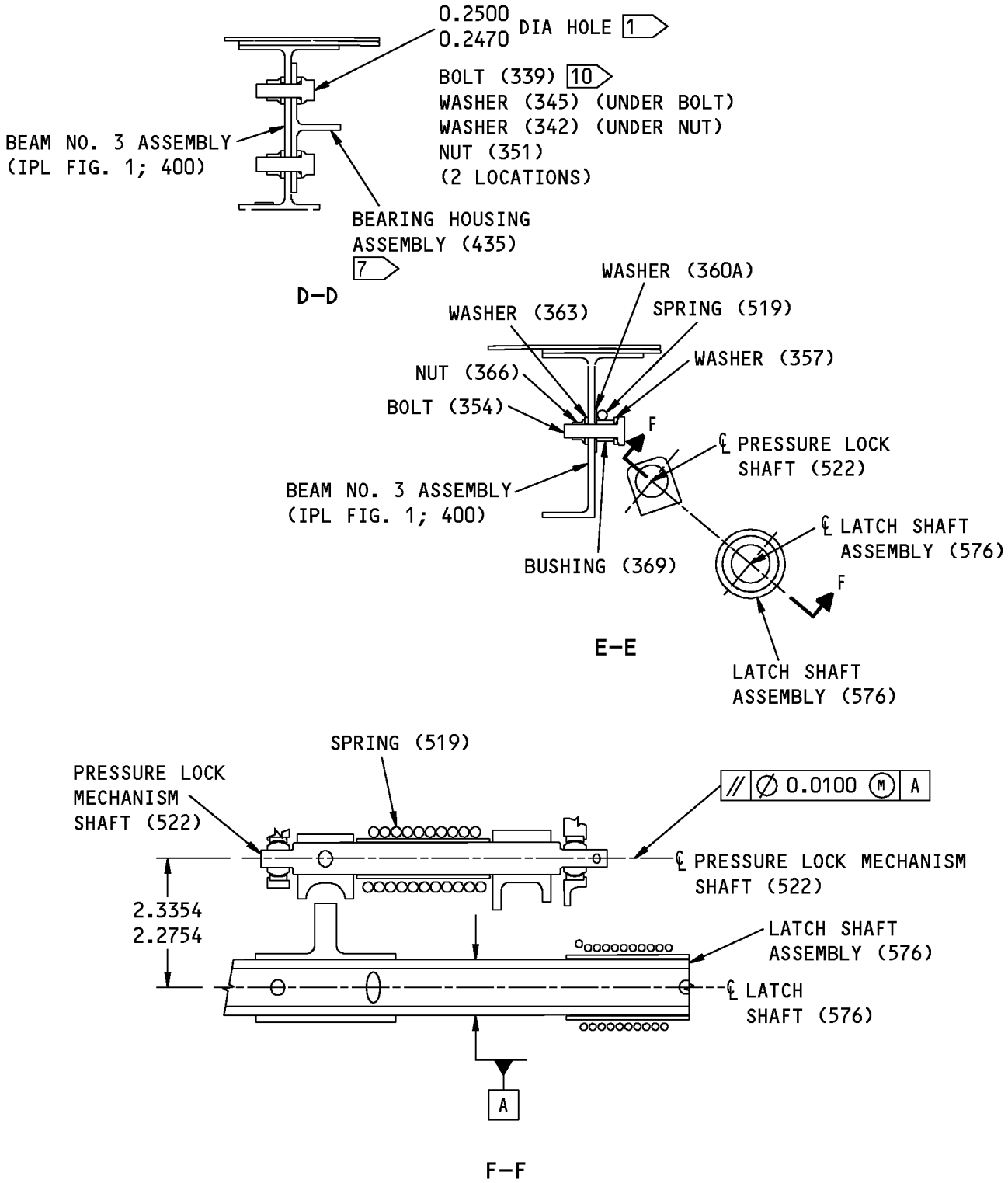


B–B

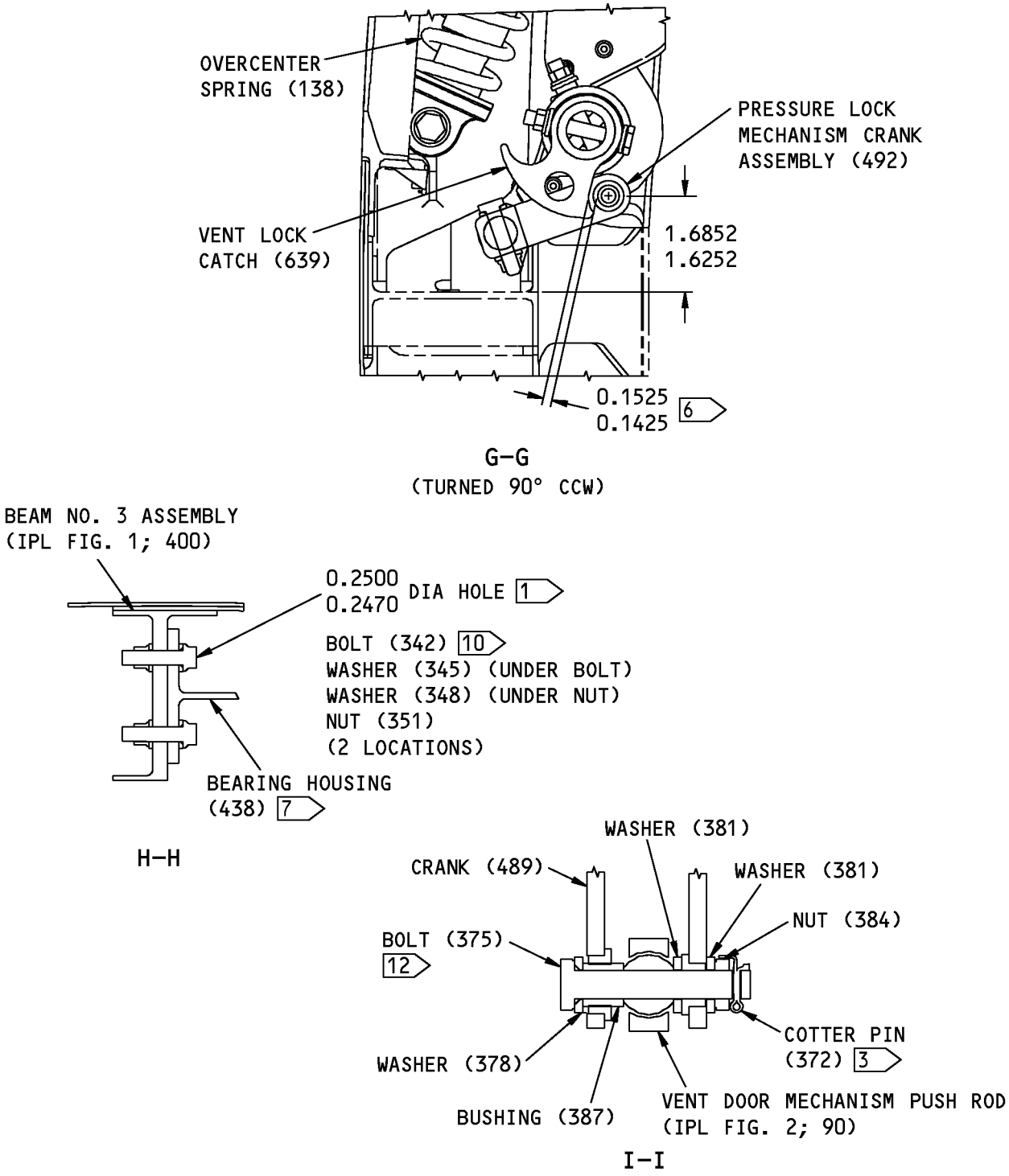
146A6500-3,-4 More Door Upper Region Mechanism Installation Details
Figure 703 (Sheet 3 of 23)



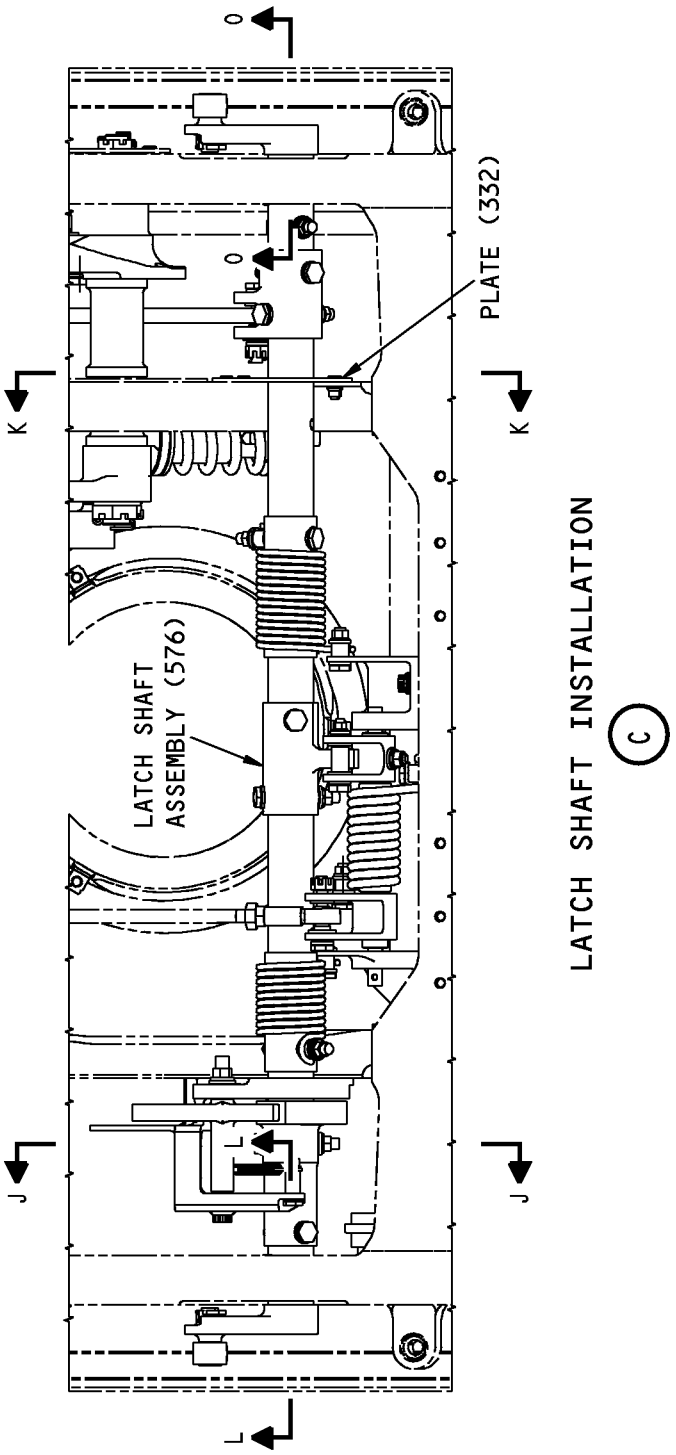
146A6500-3,-4 More Door Upper Region Mechanism Installation Details
Figure 703 (Sheet 4 of 23)



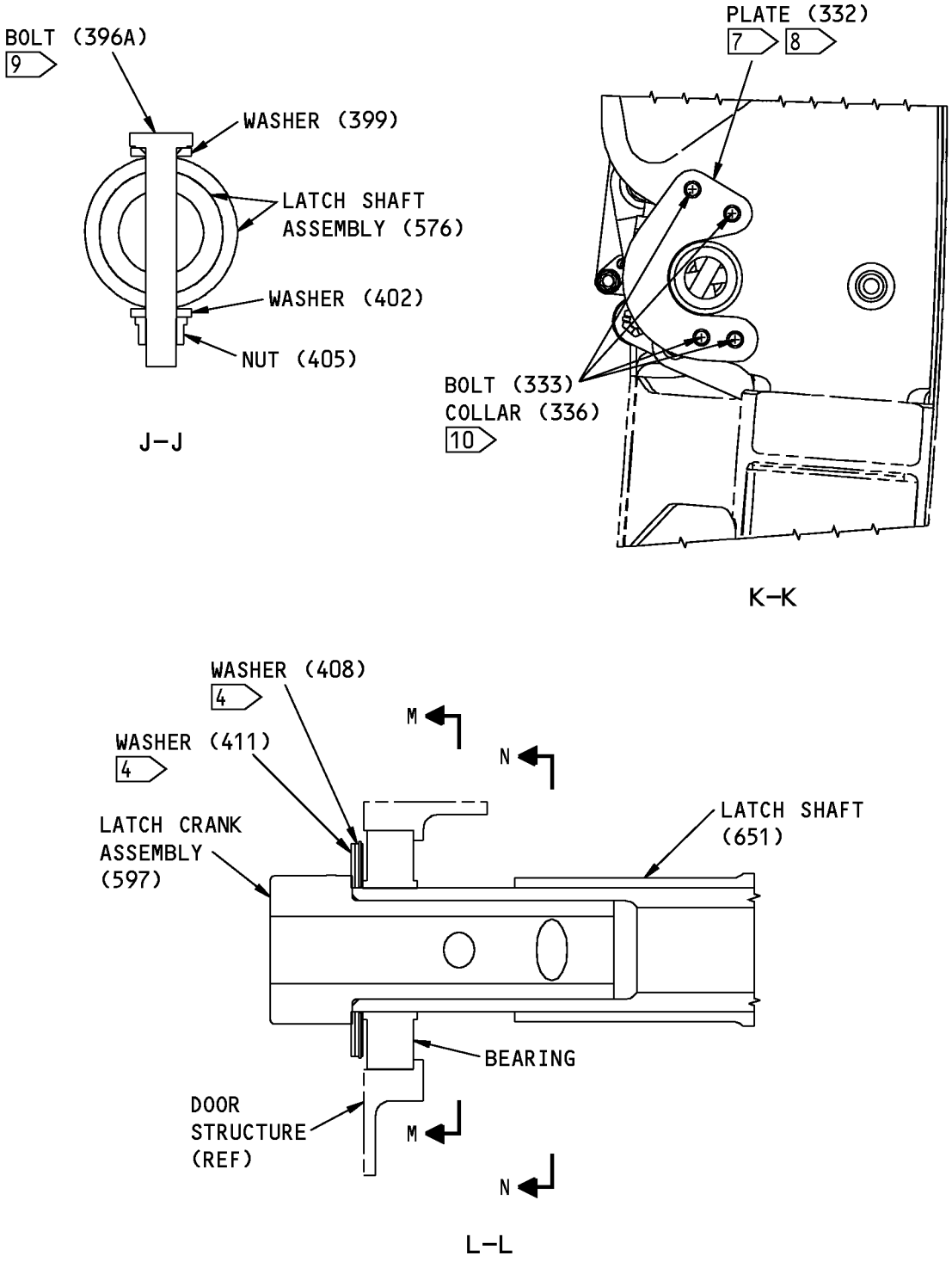
146A6500-3,-4 More Door Upper Region Mechanism Installation Details
Figure 703 (Sheet 5 of 23)



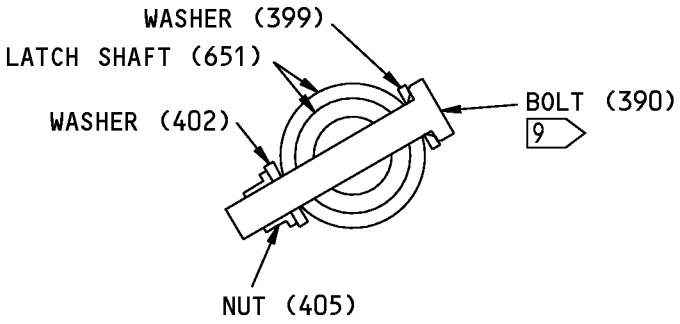
146A6500-3,-4 More Door Upper Region Mechanism Installation Details
Figure 703 (Sheet 6 of 23)



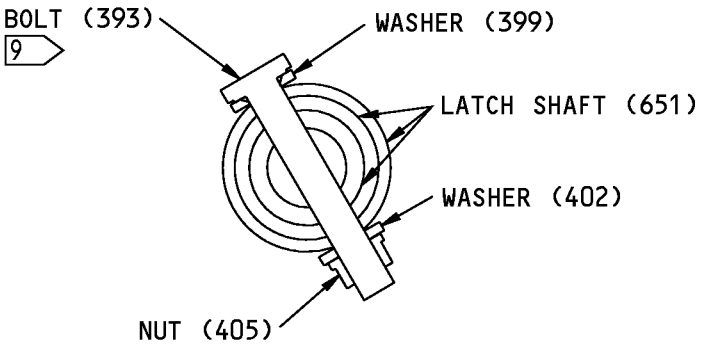
146A6500-3,-4 More Door Upper Region Mechanism Installation Details
Figure 703 (Sheet 7 of 23)



146A6500-3,-4 More Door Upper Region Mechanism Installation Details
Figure 703 (Sheet 8 of 23)

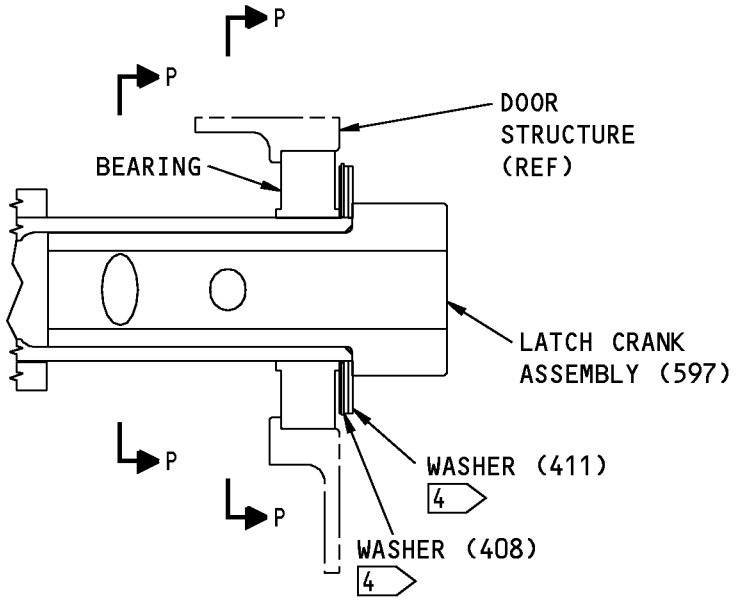


M–M

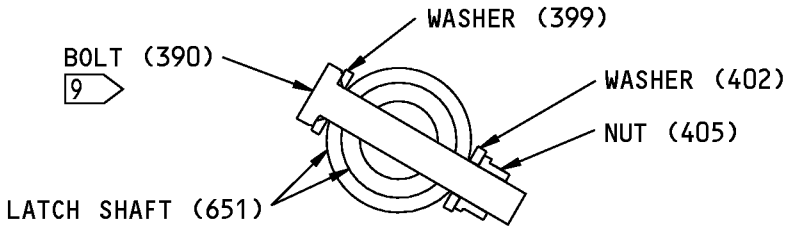


N–N

146A6500-3,-4 More Door Upper Region Mechanism Installation Details
Figure 703 (Sheet 9 of 23)

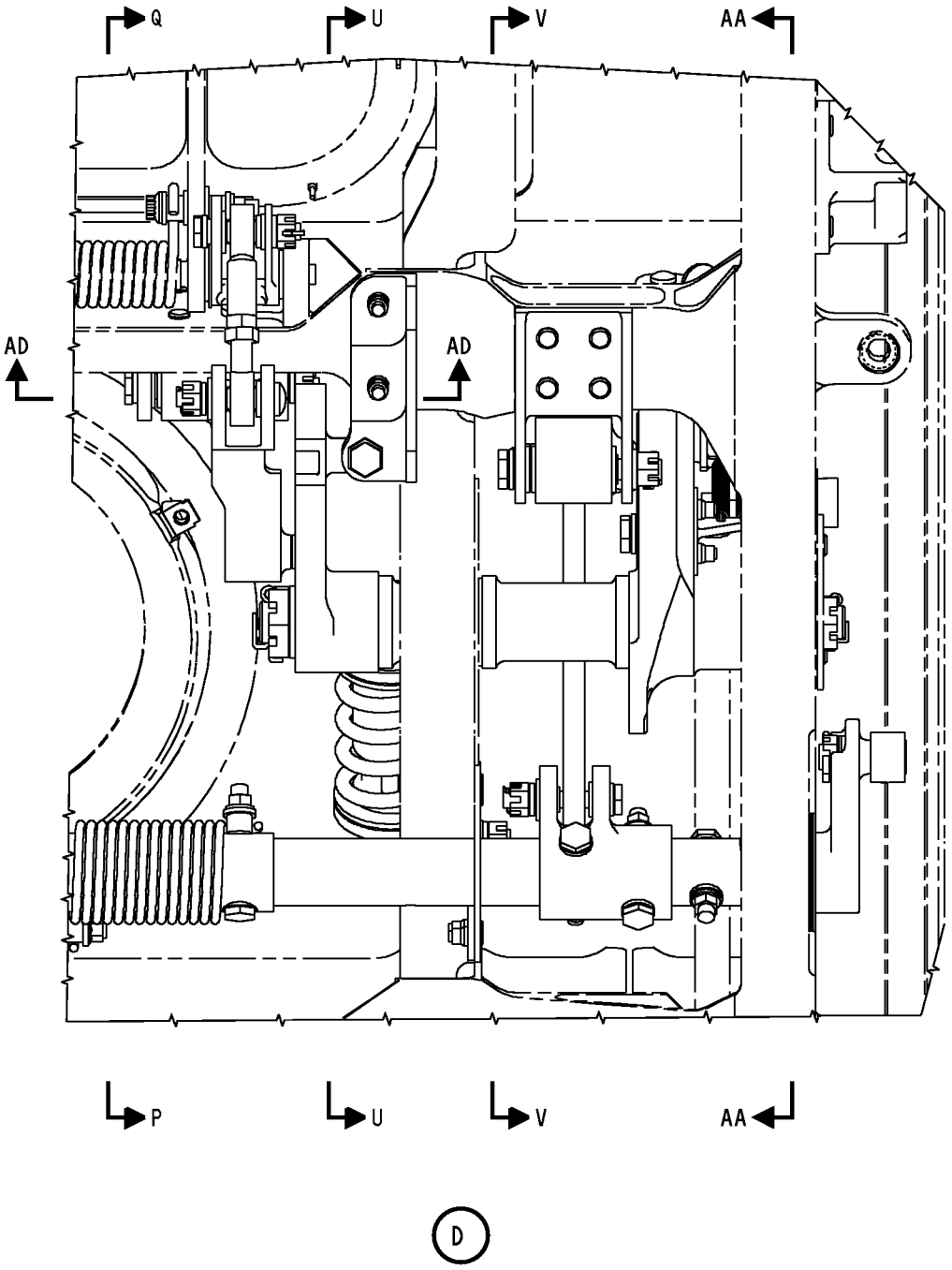


O–O

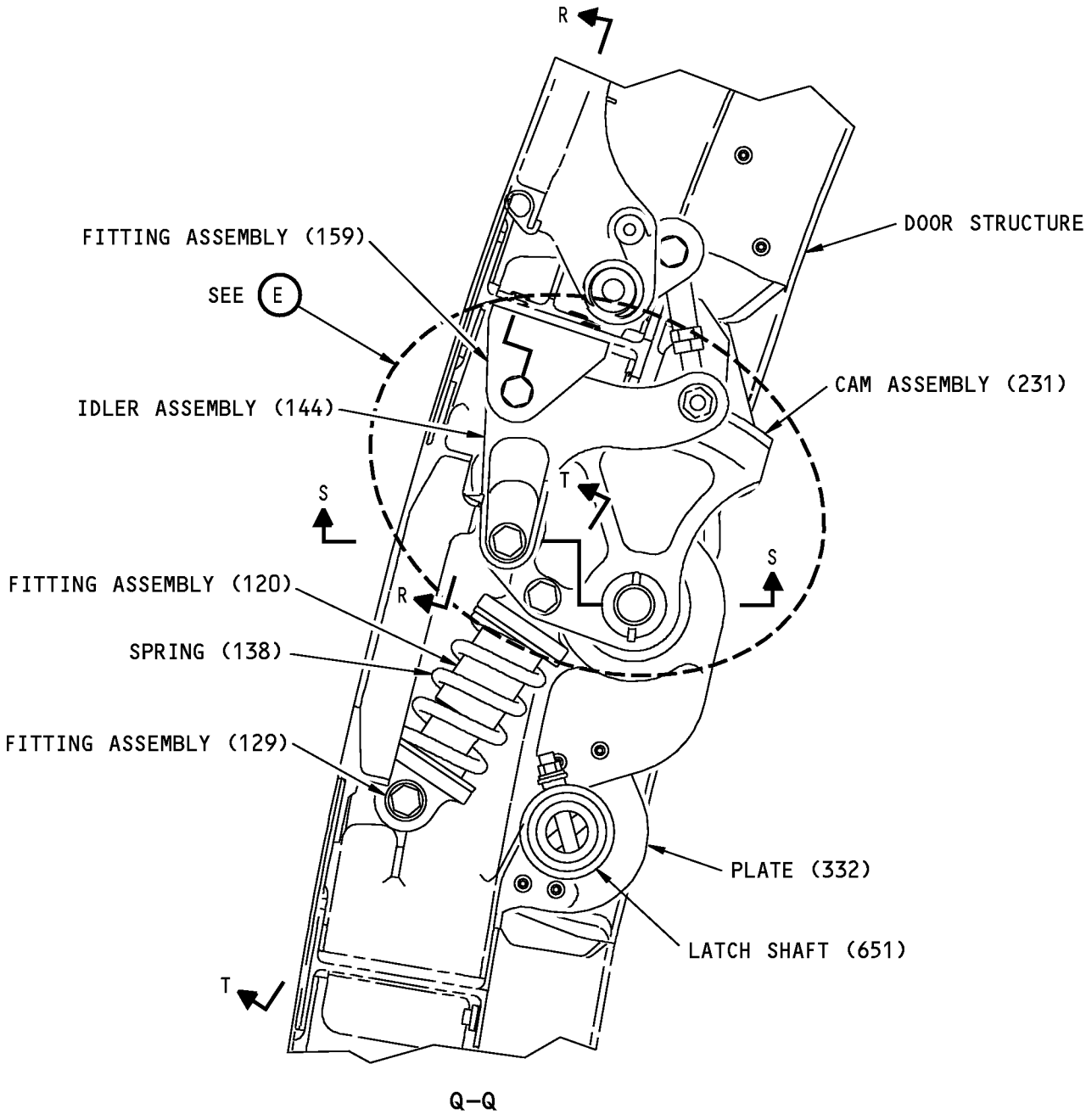


P–P

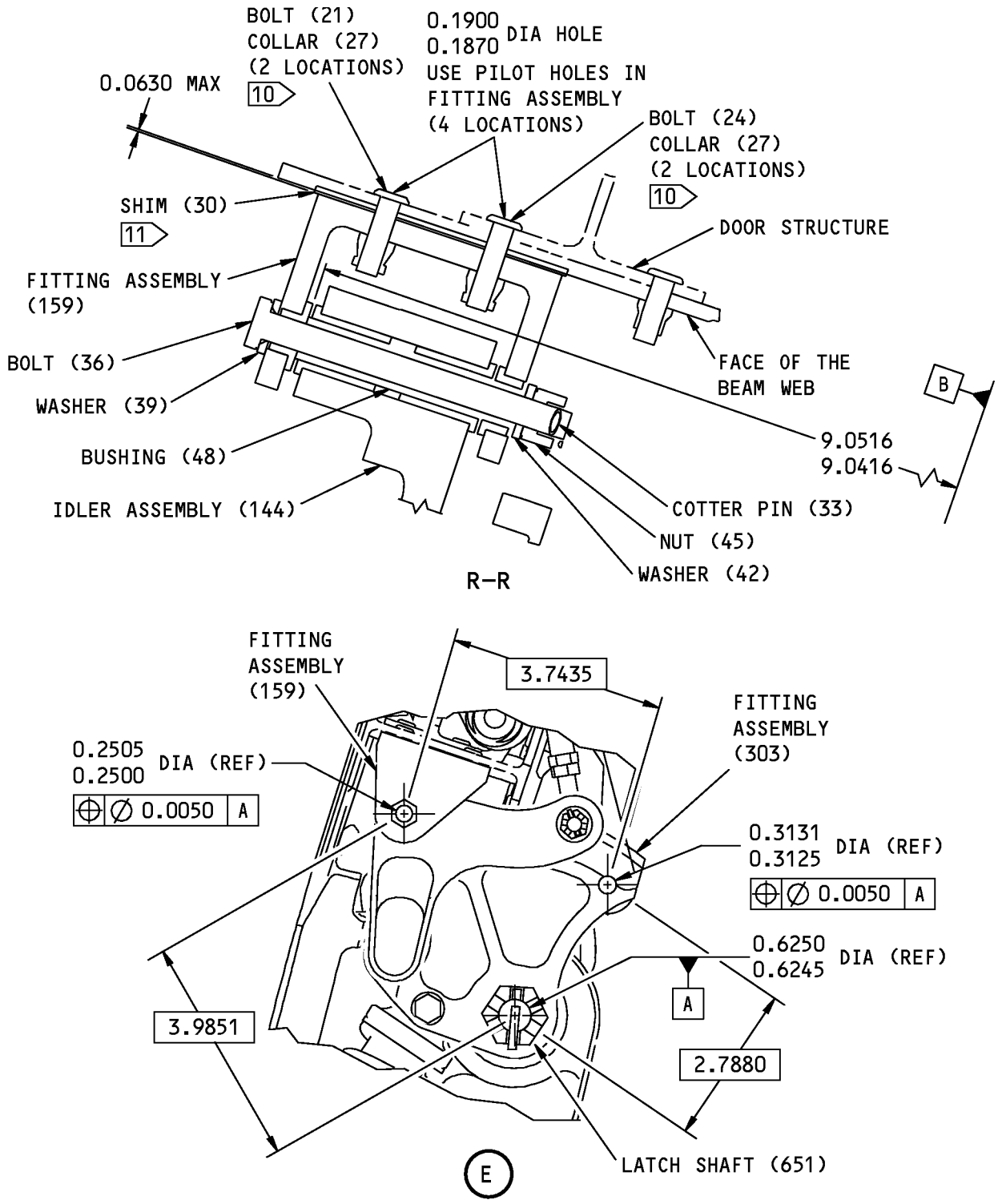
146A6500-3,-4 More Door Upper Region Mechanism Installation Details
Figure 703 (Sheet 10 of 23)



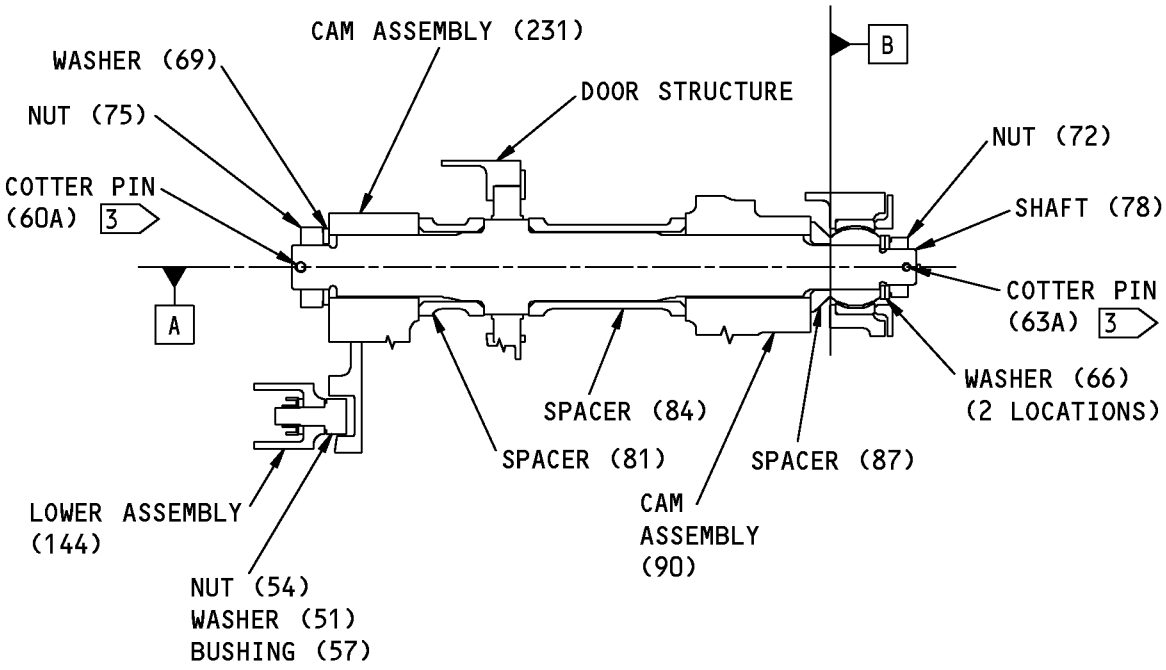
146A6500-3,-4 More Door Upper Region Mechanism Installation Details
Figure 703 (Sheet 11 of 23)



146A6500-3,-4 More Door Upper Region Mechanism Installation Details
Figure 703 (Sheet 12 of 23)

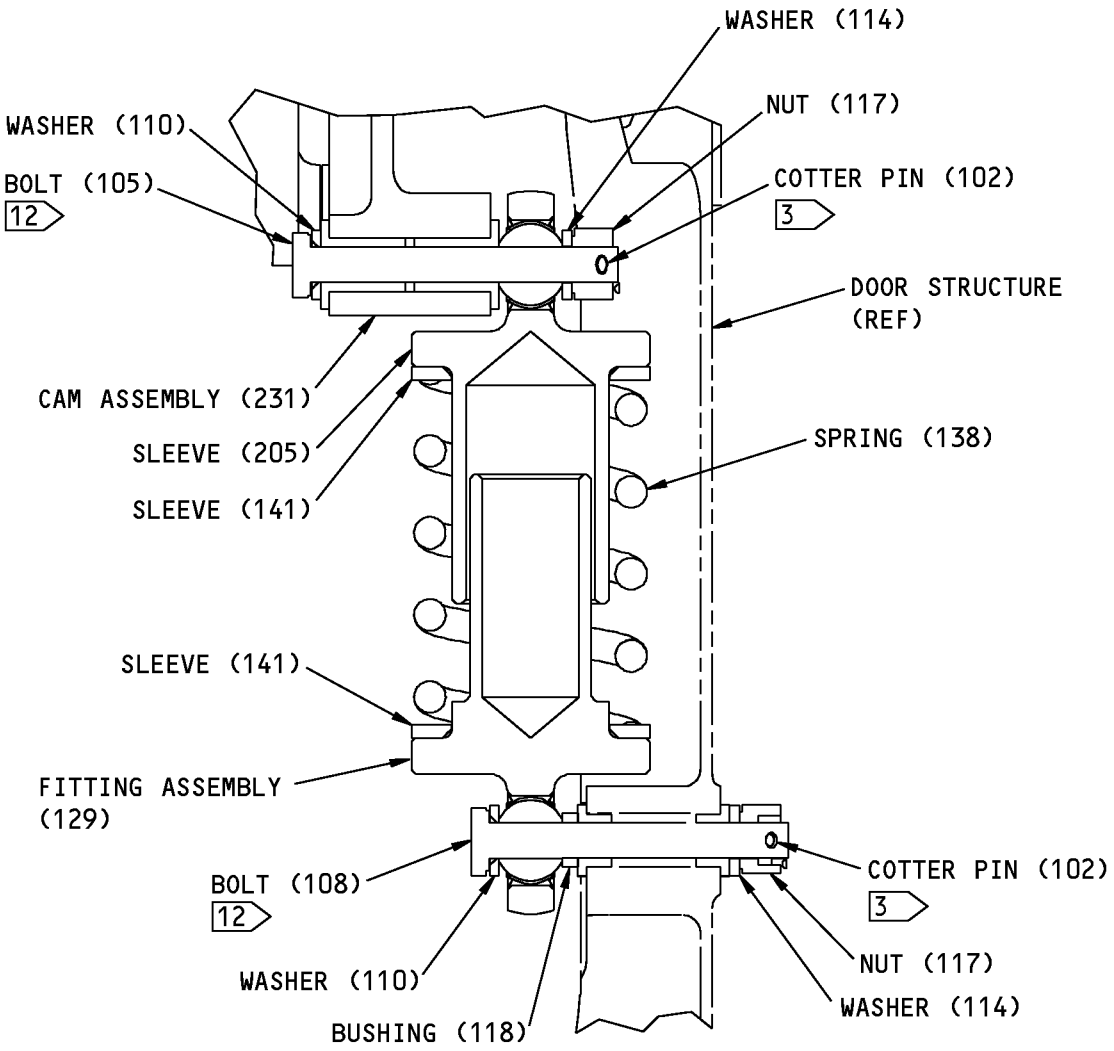


146A6500-3,-4 More Door Upper Region Mechanism Installation Details
Figure 703 (Sheet 13 of 23)



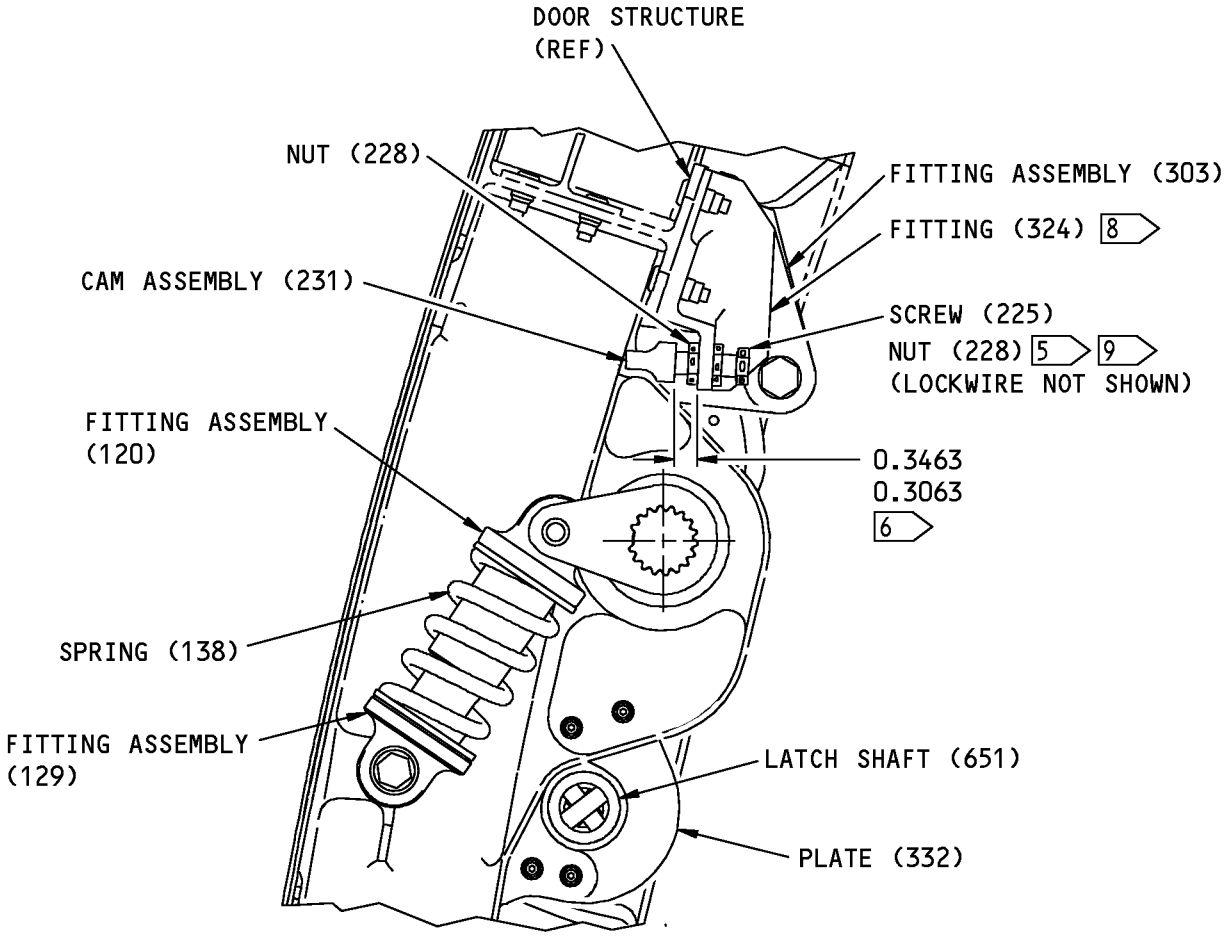
S-S

146A6500-3,-4 More Door Upper Region Mechanism Installation Details
Figure 703 (Sheet 14 of 23)

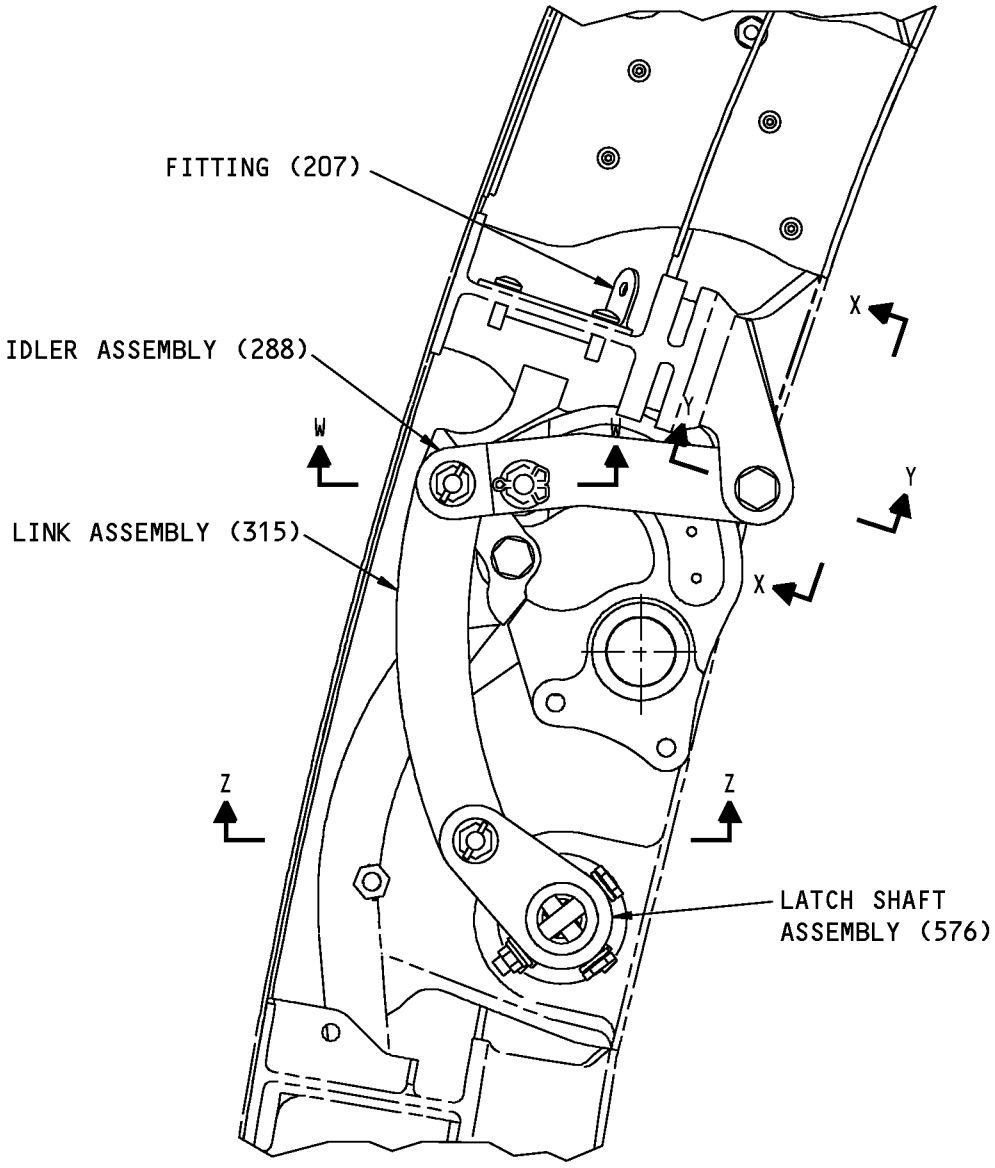


T–T

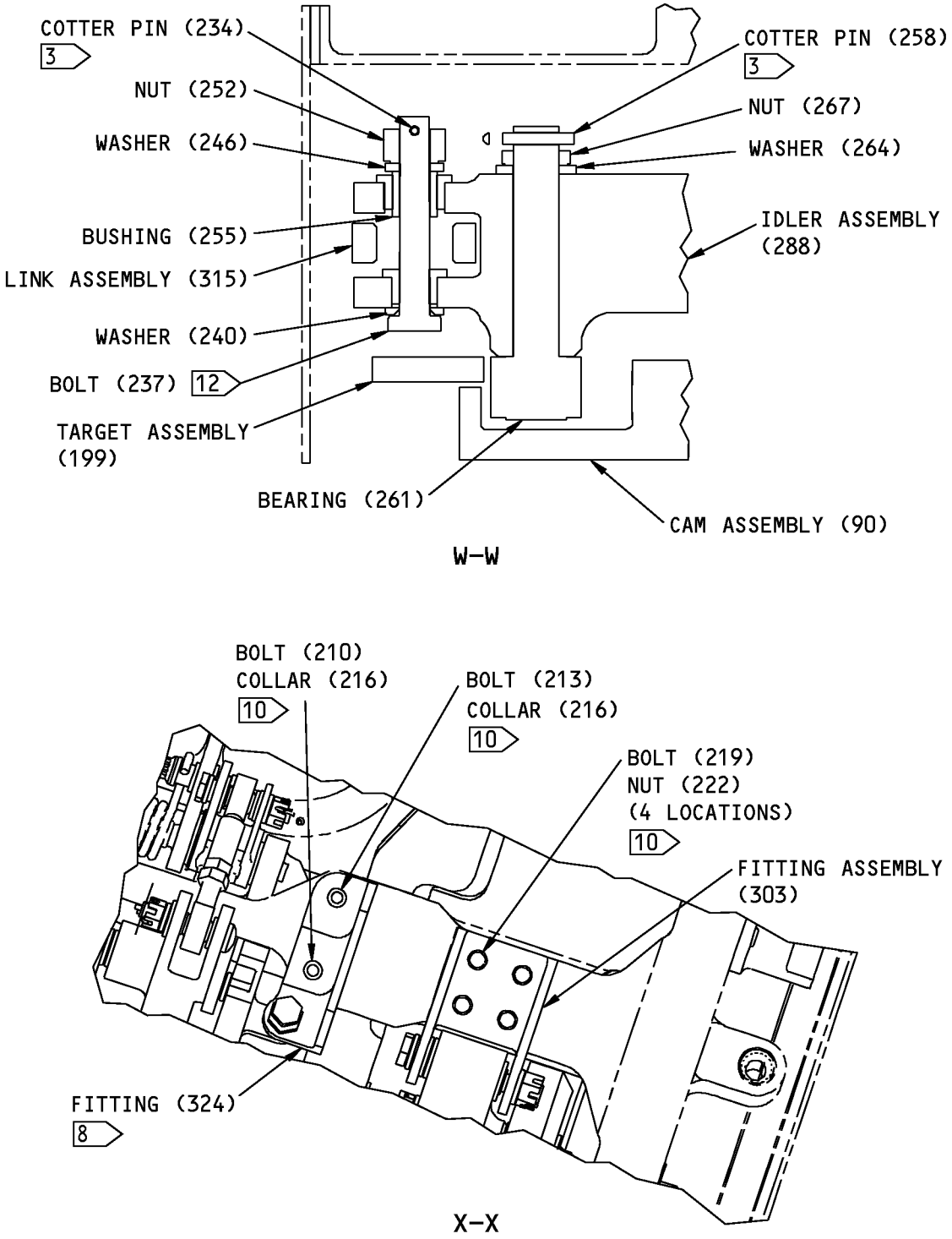
146A6500-3,-4 More Door Upper Region Mechanism Installation Details
Figure 703 (Sheet 15 of 23)



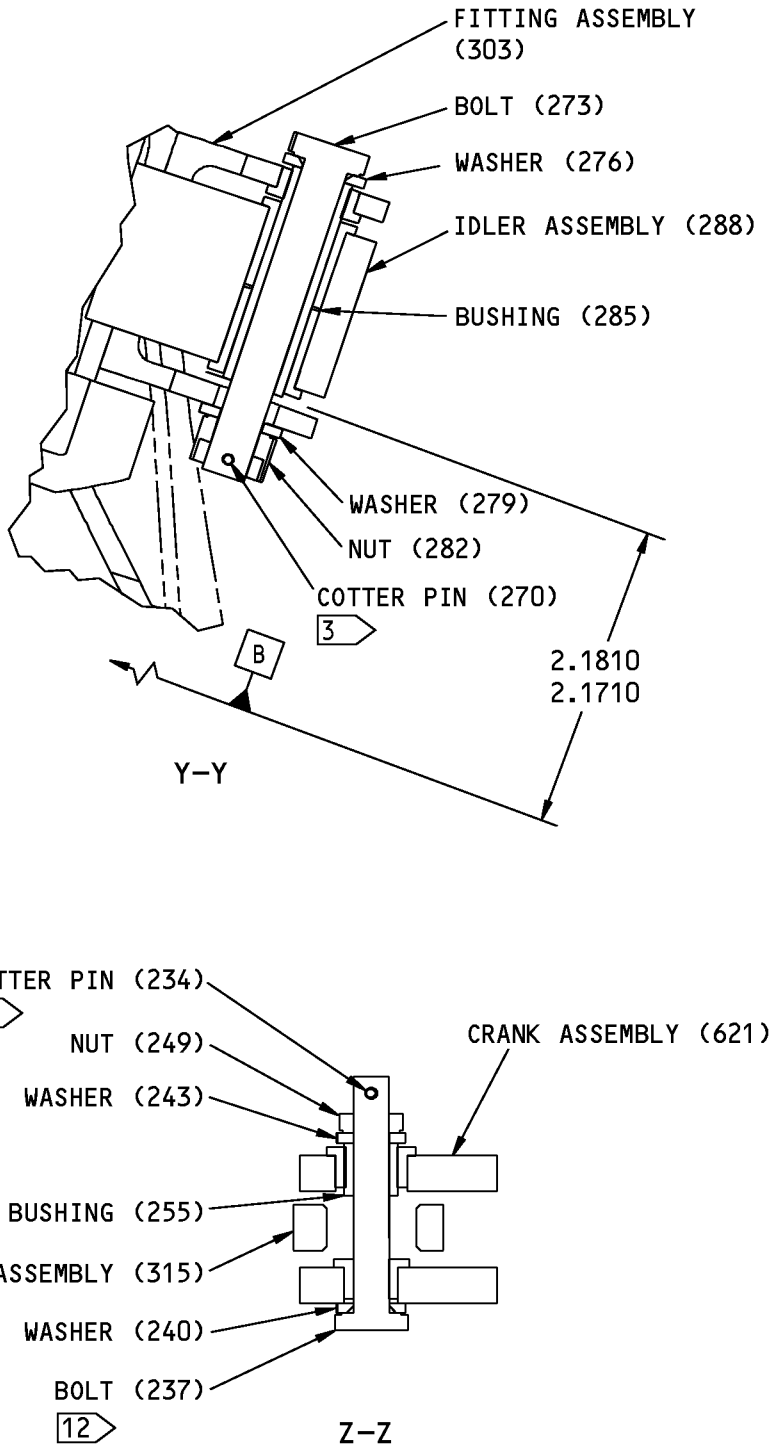
146A6500-3,-4 More Door Upper Region Mechanism Installation Details
Figure 703 (Sheet 16 of 23)



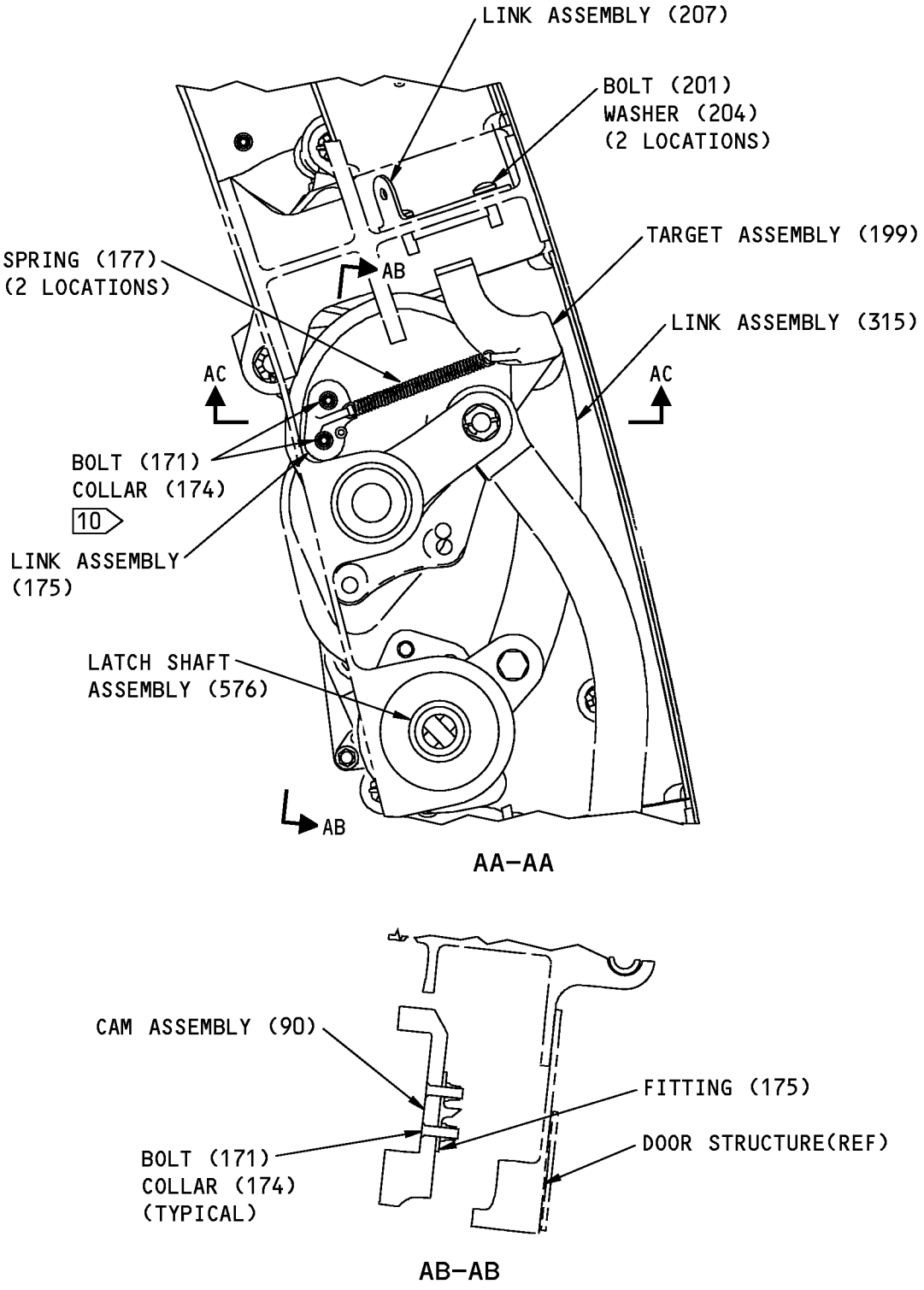
146A6500-3,-4 More Door Upper Region Mechanism Installation Details
Figure 703 (Sheet 17 of 23)



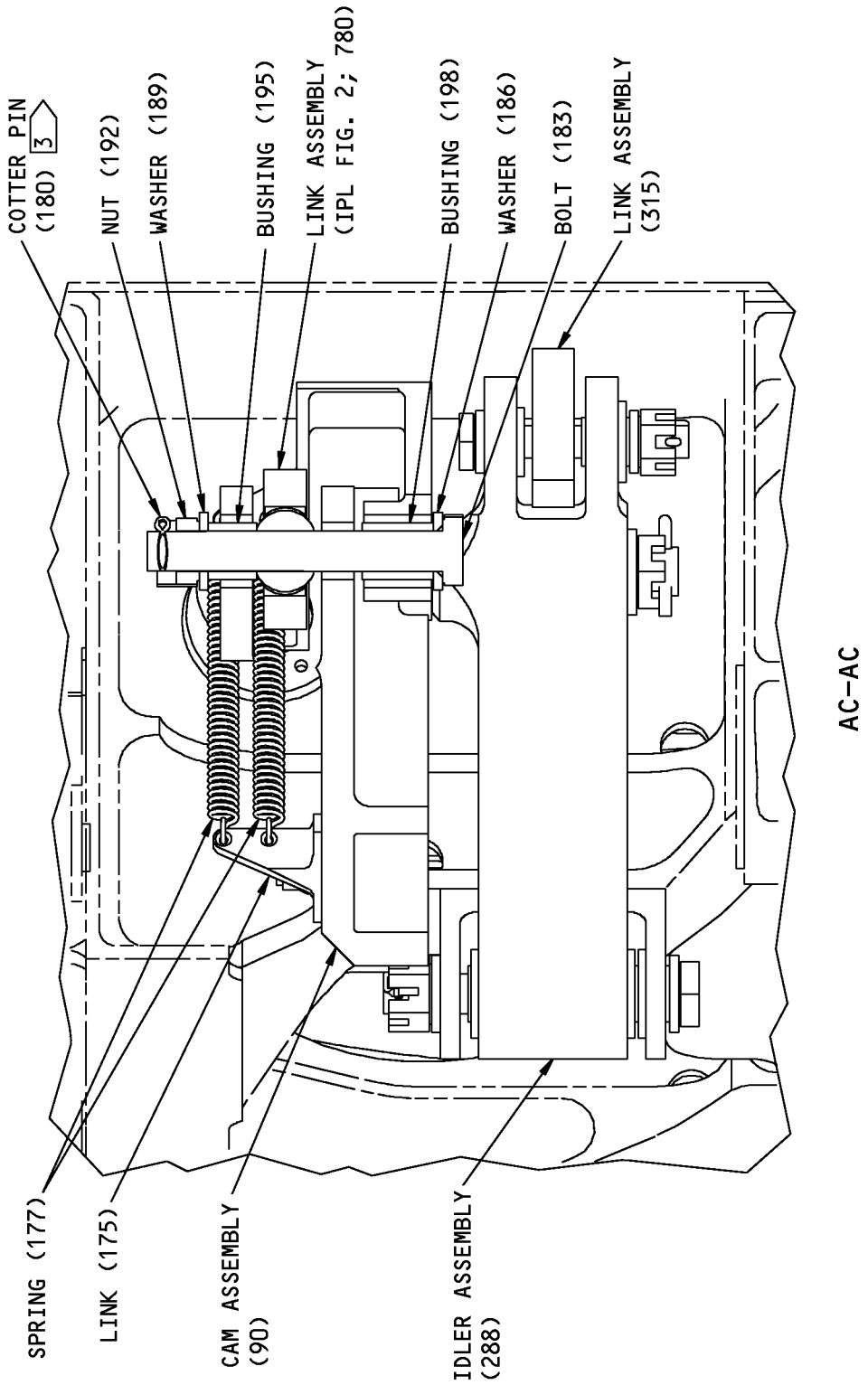
146A6500-3,-4 More Door Upper Region Mechanism Installation Details
Figure 703 (Sheet 18 of 23)



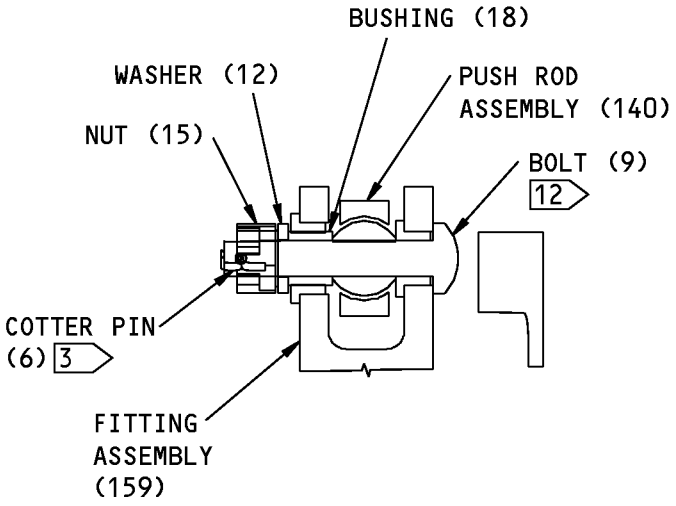
146A6500-3,-4 More Door Upper Region Mechanism Installation Details
Figure 703 (Sheet 19 of 23)



146A6500-3,-4 More Door Upper Region Mechanism Installation Details
Figure 703 (Sheet 20 of 23)



146A6500-3,-4 More Door Upper Region Mechanism Installation Details
Figure 703 (Sheet 21 of 23)



AD–AD

146A6500-3,-4 More Door Upper Region Mechanism Installation Details
Figure 703 (Sheet 22 of 23)

1> USE THE PILOT HOLES IN THE BEARING HOUSING ASSEMBLY

2> THESE DIMENSIONS MUST BE EQUAL WITHIN 0.01 INCH

3> INSTALL THE COTTER PIN (SOPM 20-50-02)

4> INSTALL WASHERS AS NECESSARY TO GET 0.015-0.031 INCH SIDE-TO-SIDE FREE PLAY. USE THE SAME NUMBER OF EACH WASHER SIZE ON EACH SIDE OF THE LATCH SHAFT, BUT YOU CAN INSTALL ONE MORE 0.016-THICK WASHER ON ONE SIDE OR THE OTHER IF EQUAL NUMBERS DO NOT GIVE THE SPECIFIED FREE PLAY

5> ADJUST THIS SCREW TO GET THE DIMENSION SHOWN. TIGHTEN THE NUTS TO STANDARD TORQUE (SOPM 20-50-01). LOCKWIRE THE SCREW HEAD AND THE TWO NUTS (SOPM 20-50-02)

6> HOLD THESE DIMENSIONS FOR THE FIRST SETUP TO BE SURE YOU CAN RIG AND SET RELATIVE LINKS DURING LATER ASSEMBLY PROCEDURES. GET THE DIMENSION SHOWN IN VIEW U-U (REF 5>) BEFORE YOU GET THE DIMENSIONS FOR THE FLIGHT LOCK (VIEW B-B) AND THE PRESSURE LOCK (VIEW G-G)

7> FAY SURFACE SEAL WITH BMS 5-95 SEALANT (SOPM 20-50-19)

8> IF YOU INSTALL REPLACEMENT PARTS, USE THE PILOT HOLES TO PUT THE PARTS IN POSITION

9> IF YOU ADJUST THIS FASTENER AFTER THE FIRST SETUP, YOU COULD CHANGE THE POSITION SHOWN IN VIEW G-G

10> APPLY A LAYER OF BMS 5-95 SEALANT TO ALL HOLE SURFACES ON EACH SIDE. THEN INSTALL THE FASTENERS WITH WET BMS 5-95 SEALANT (SOPM 20-50-19 METHOD 1)

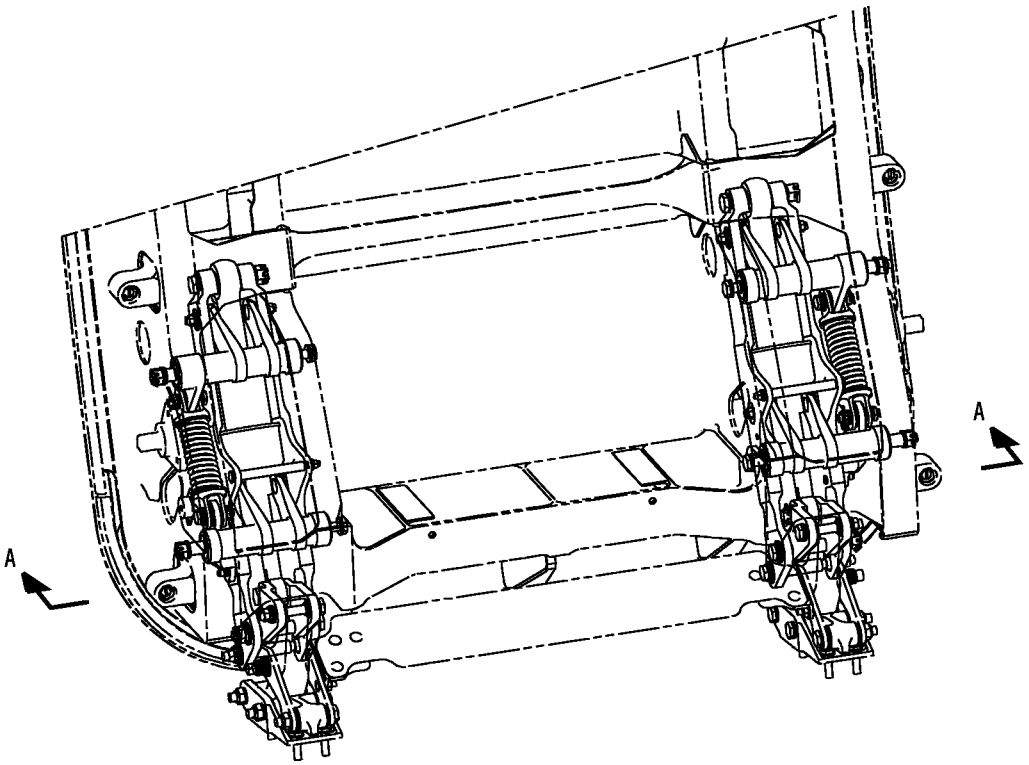
11> REMOVE 0.003 INCH LAMINATIONS FROM THE SHIM AS NECESSARY. FAY SURFACE SEAL ALL OF THE SHIM MATING SURFACES WITH BMS 5-95 SEALANT (SOPM 20-50-19)

12> USE A THIN LAYER OF BMS 3-33 GREASE AS THE INSTALLATION FINISH

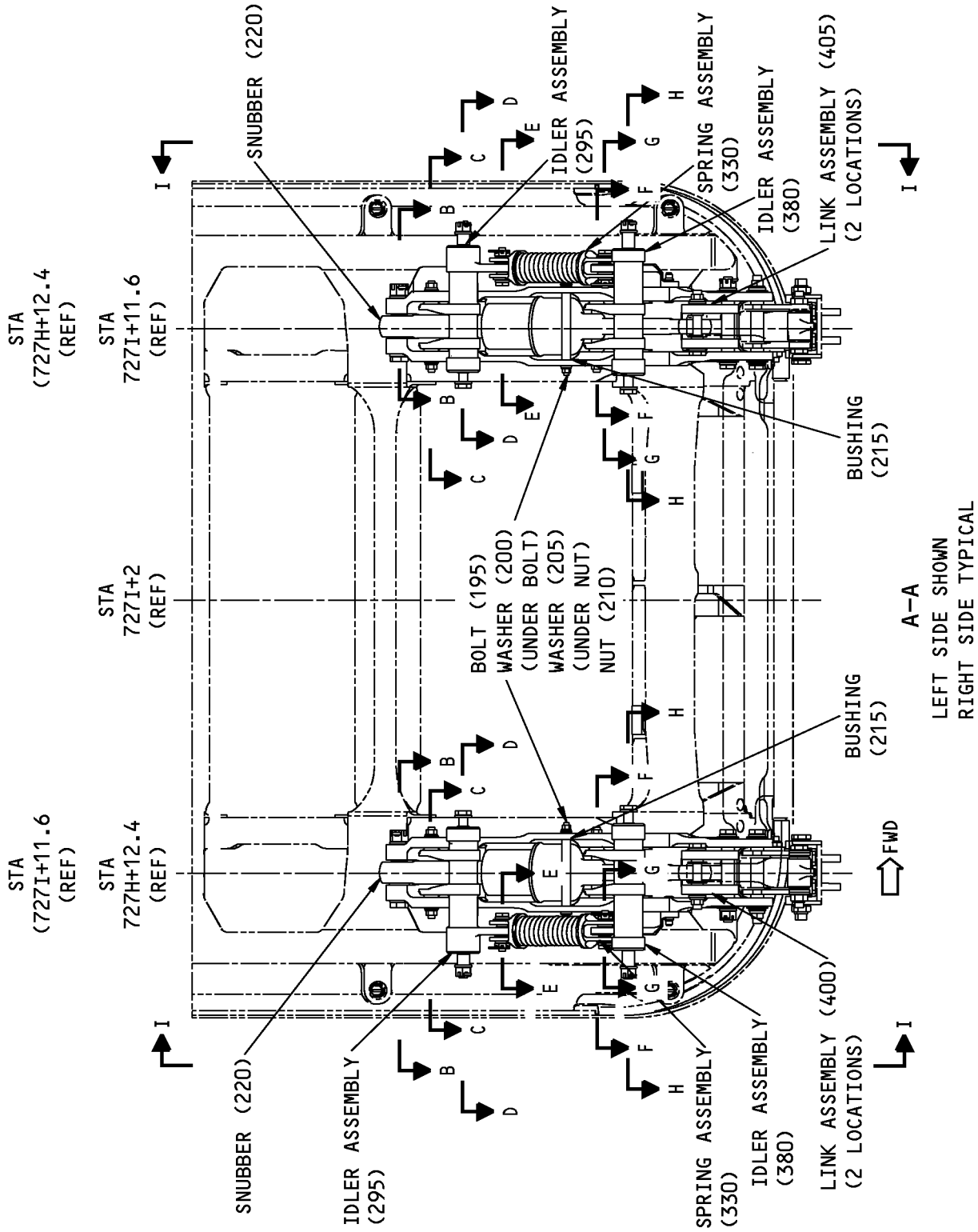
ITEM NUMBERS REFER TO IPL FIG. 3 UNLESS SHOWN DIFFERENTLY

ALL DIMENSIONS ARE IN INCHES

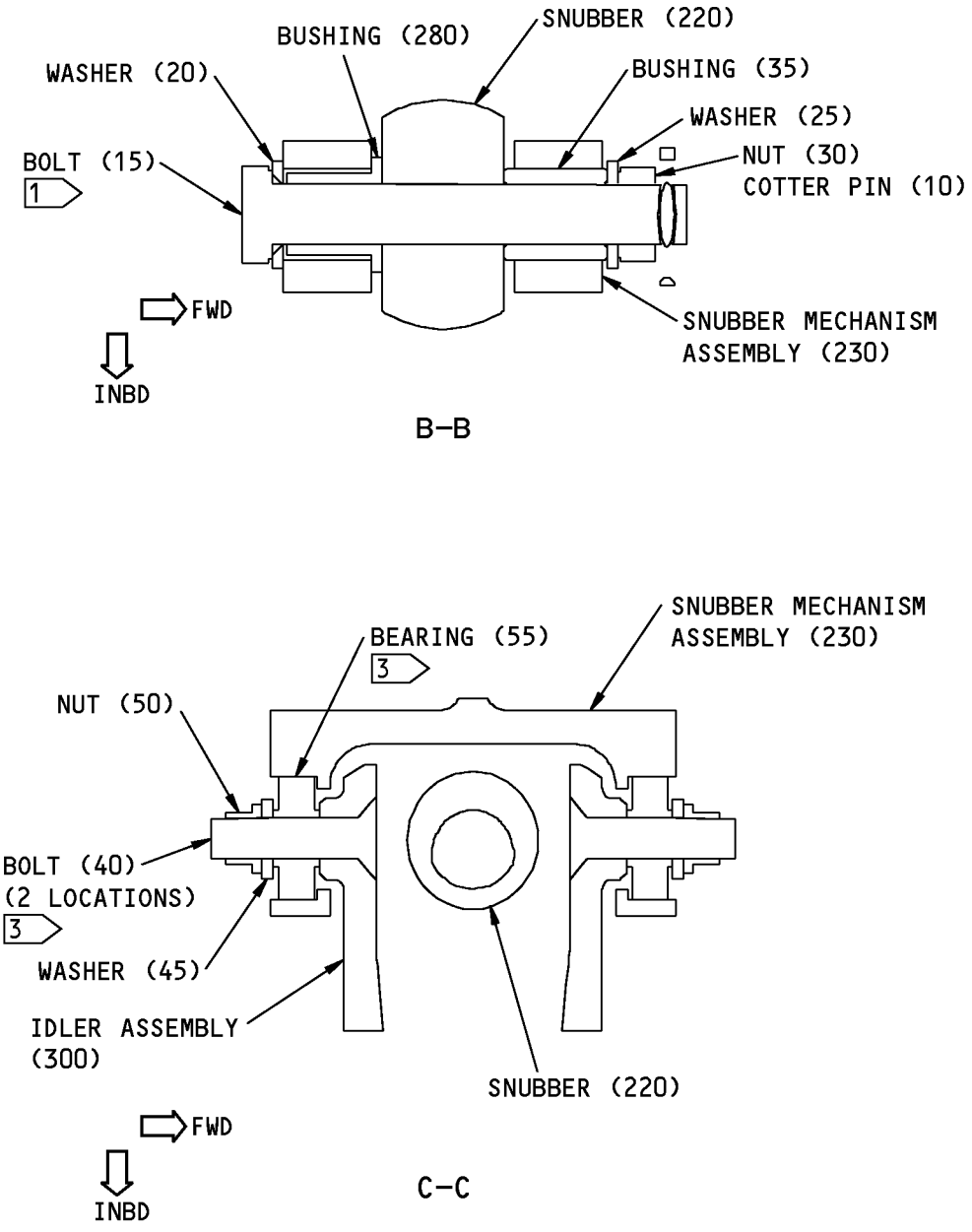
146A6500-3,-4 More Door Upper Region Mechanism Installation Details
Figure 703 (Sheet 23 of 23)



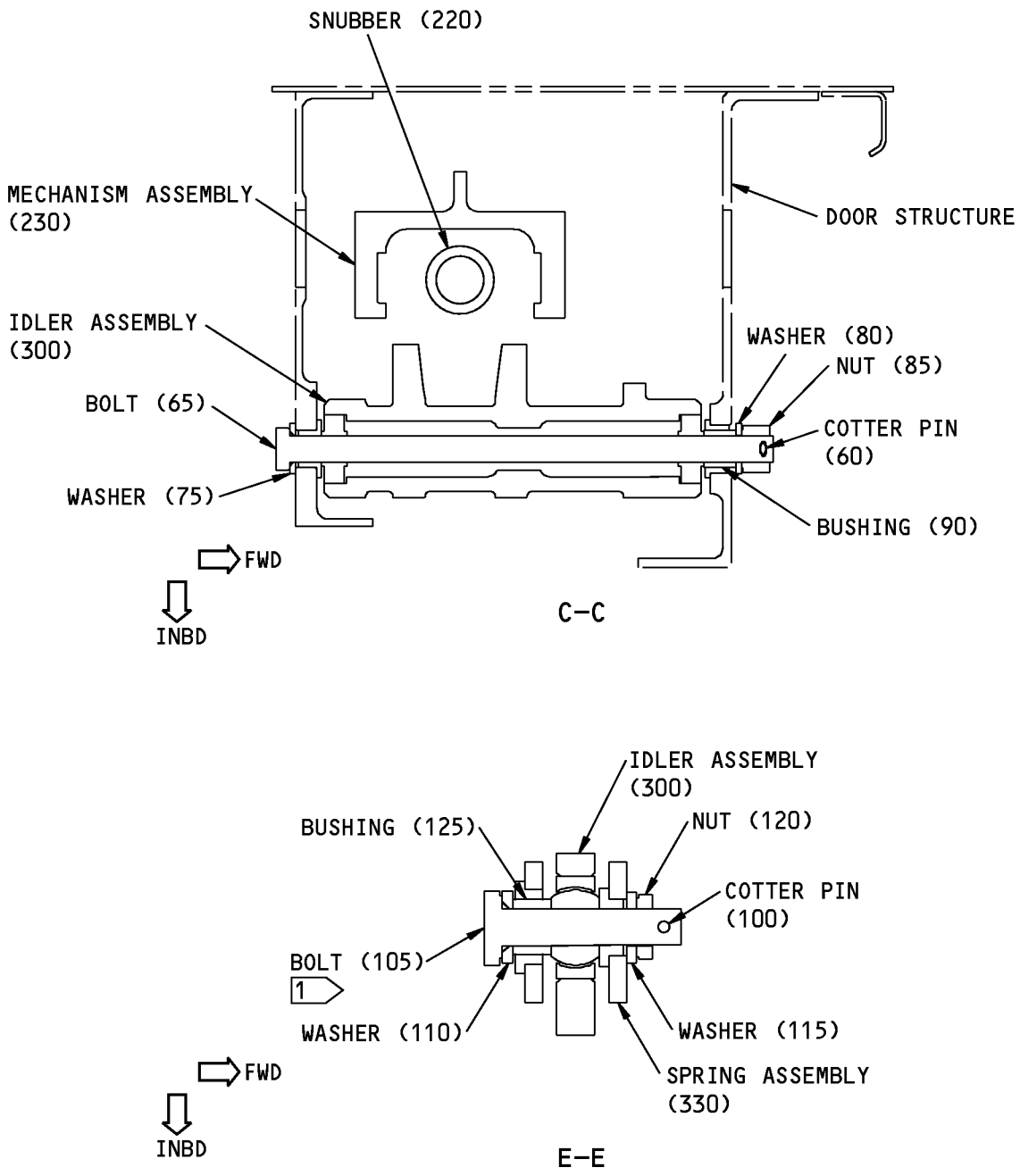
146A6500-1,-2 Door Lower Region Mechanism Installation Details
Figure 704 (Sheet 1 of 9)



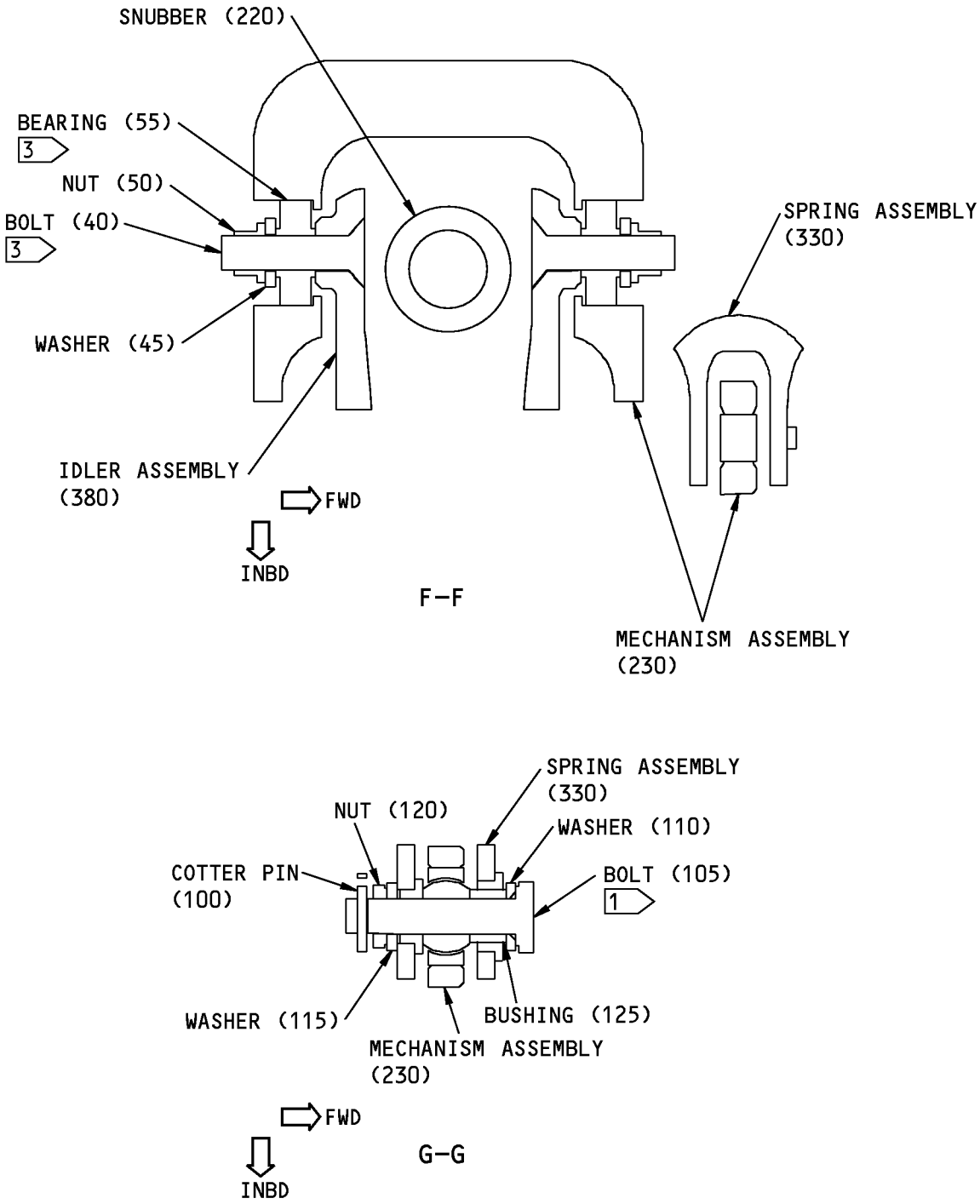
146A6500-1,-2 Door Lower Region Mechanism Installation Details
Figure 704 (Sheet 2 of 9)



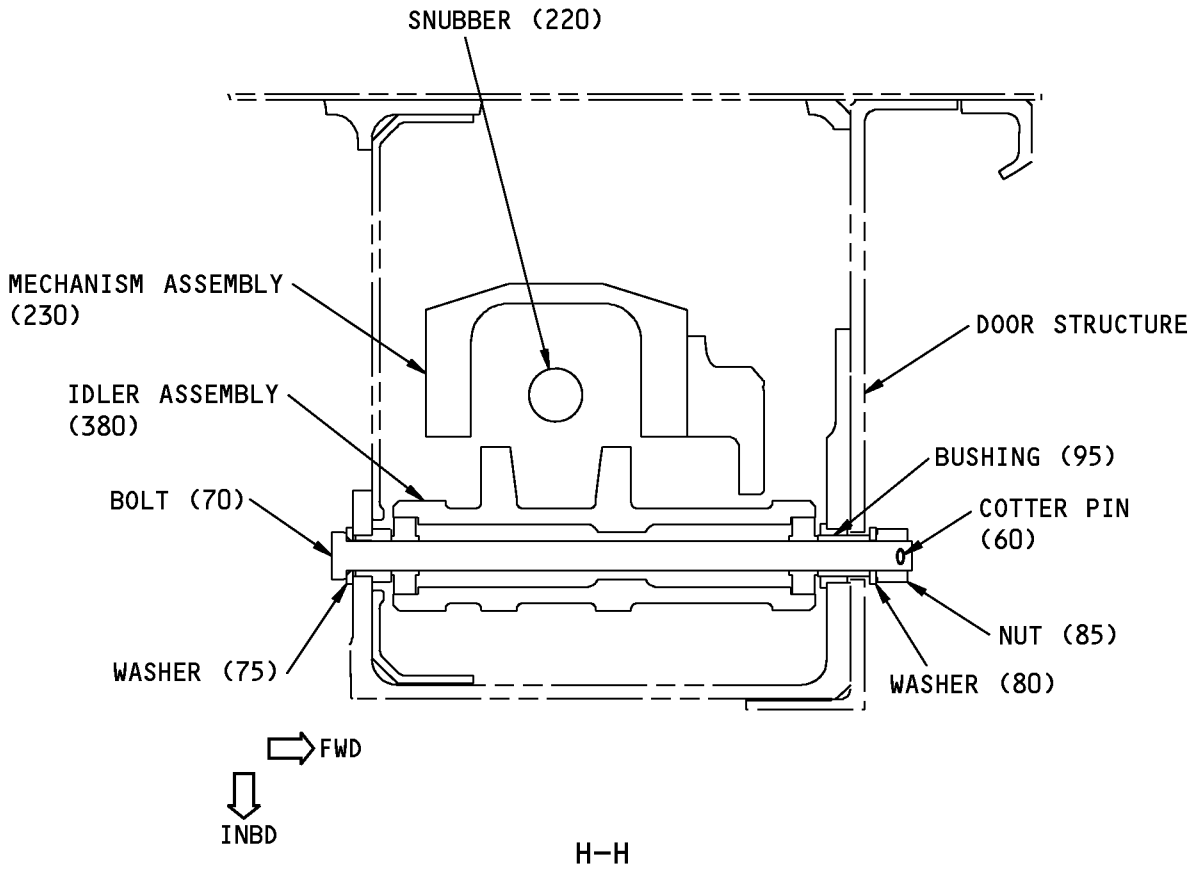
146A6500-1,-2 Door Lower Region Mechanism Installation Details
Figure 704 (Sheet 3 of 9)



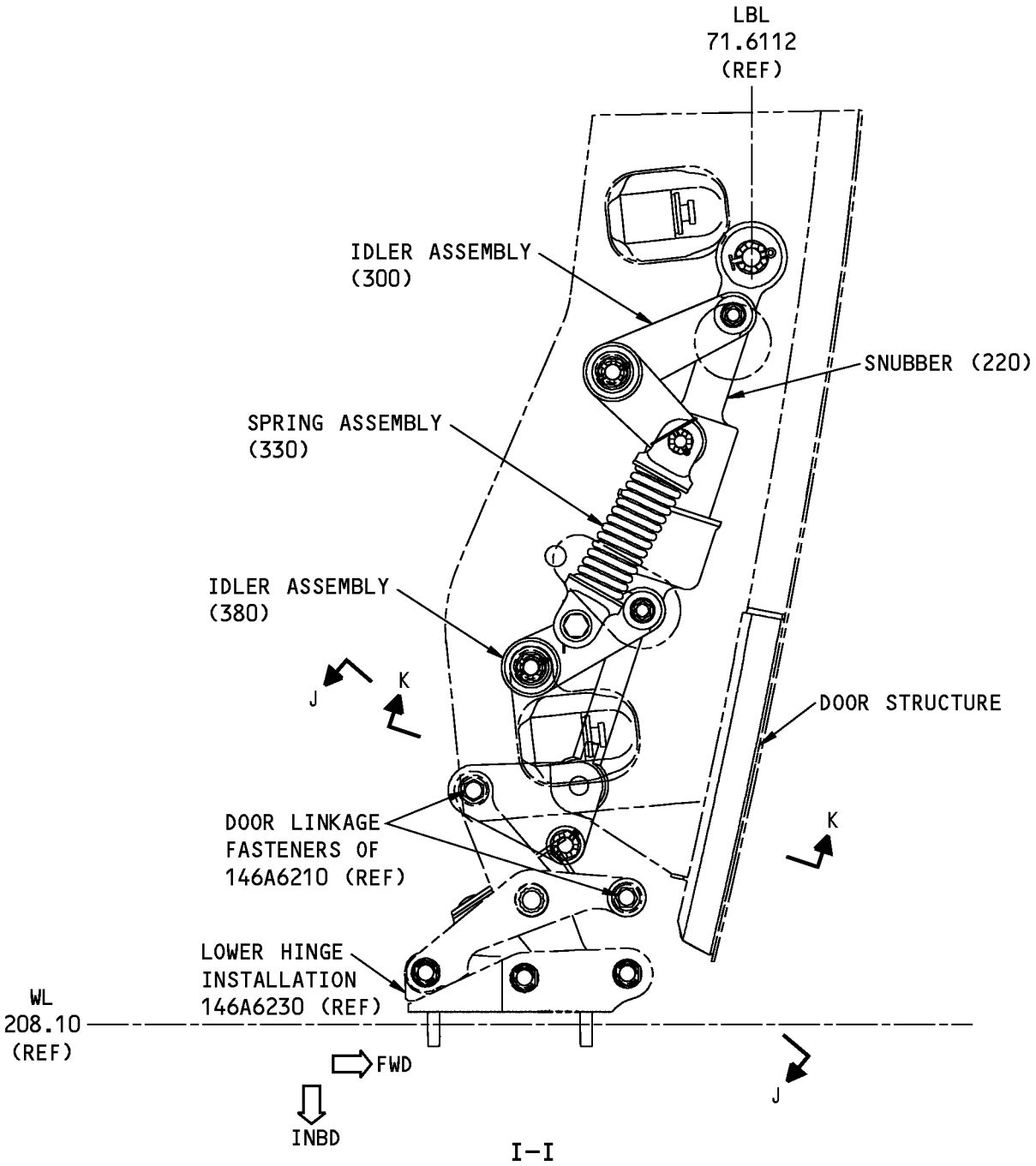
146A6500-1,-2 Door Lower Region Mechanism Installation Details
Figure 704 (Sheet 4 of 9)



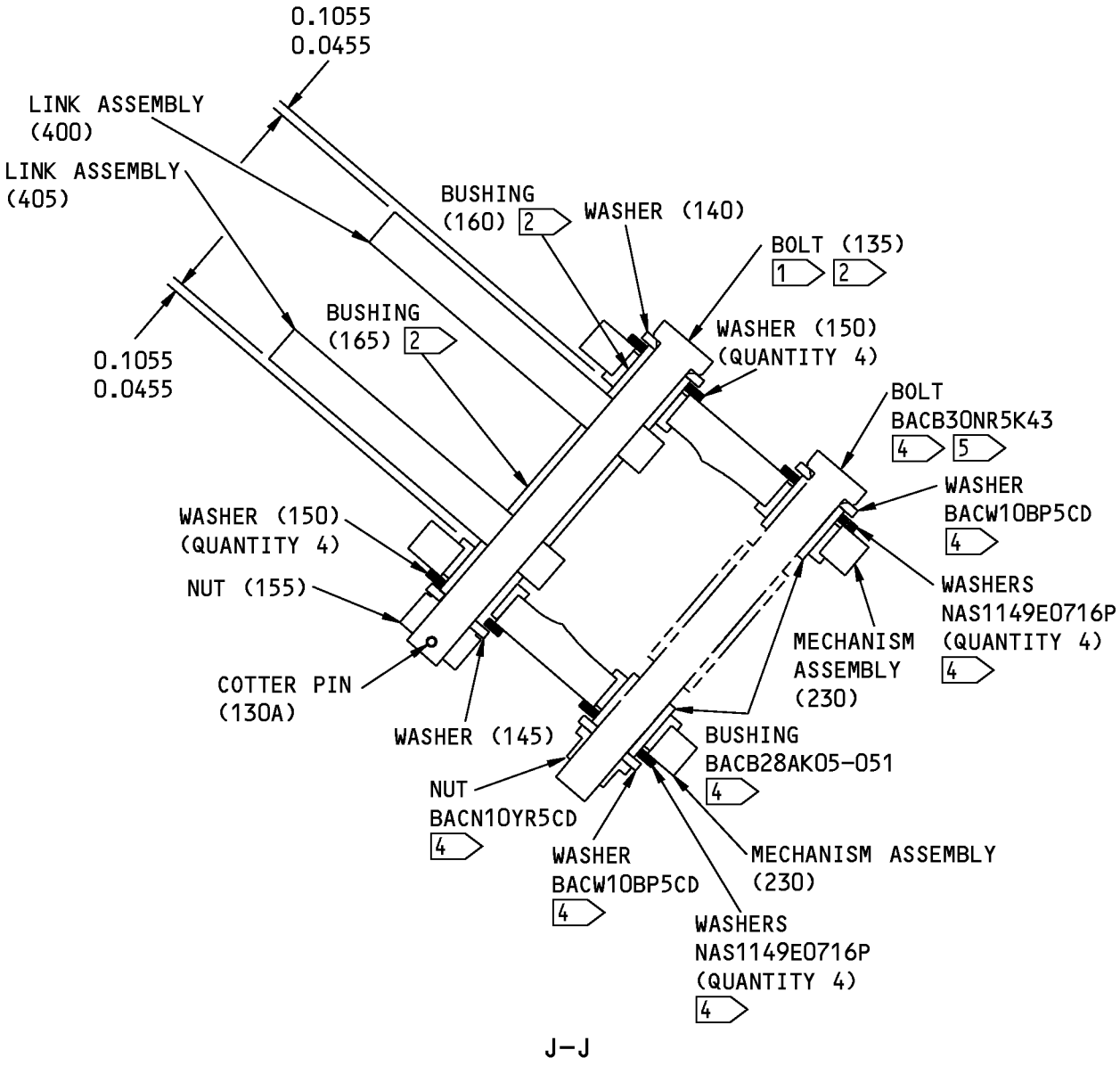
146A6500-1,-2 Door Lower Region Mechanism Installation Details
Figure 704 (Sheet 5 of 9)



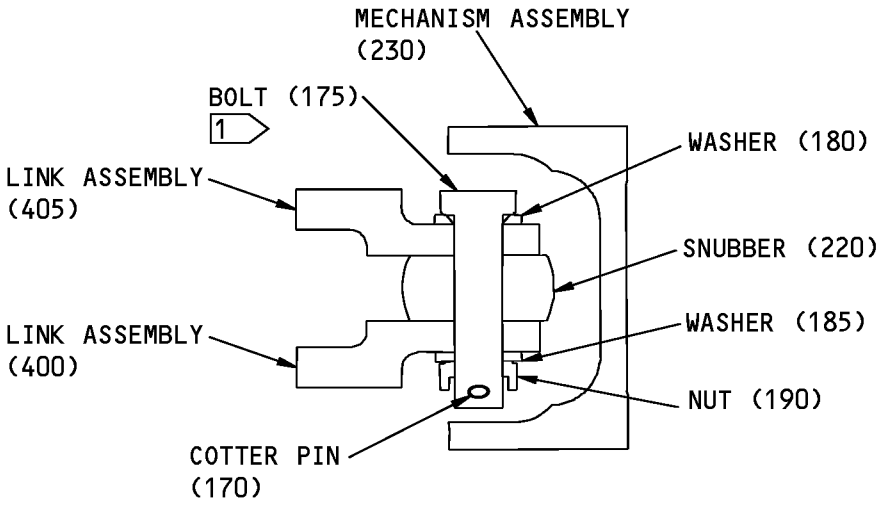
146A6500-1,-2 Door Lower Region Mechanism Installation Details
Figure 704 (Sheet 6 of 9)



146A6500-1,-2 Door Lower Region Mechanism Installation Details
Figure 704 (Sheet 7 of 9)



146A6500-1,-2 Door Lower Region Mechanism Installation Details
Figure 704 (Sheet 8 of 9)



K–K

1 INSTALL THE BOLT WITH ITS HEAD IN THE DIRECTION SHOWN

2 APPLY A THIN LAYER OF BMS 3–38 CORROSION PREVENTIVE COMPOUND TO THE MATING SURFACES OF BUSHINGS AND BOLTS BEFORE INSTALLATION

3 USE BMS 3–33 GREASE AS THE INSTALLATION FINISH ON THE BEARING OD, THE HOUSING ID, AND THE MATING BOLT

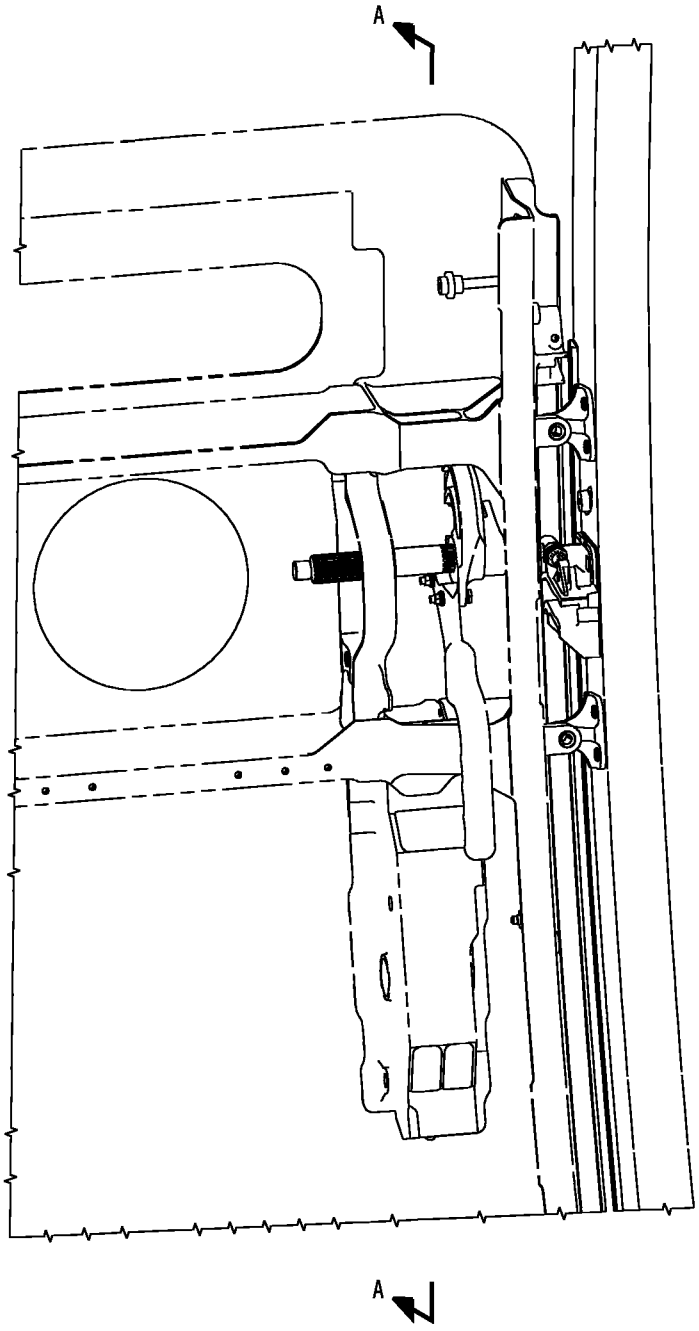
4 PARTS OF DOOR INSTALLATION 146A6210

5 APPLY A THIN LAYER OF BMS 3–33 GREASE AT ASSEMBLY

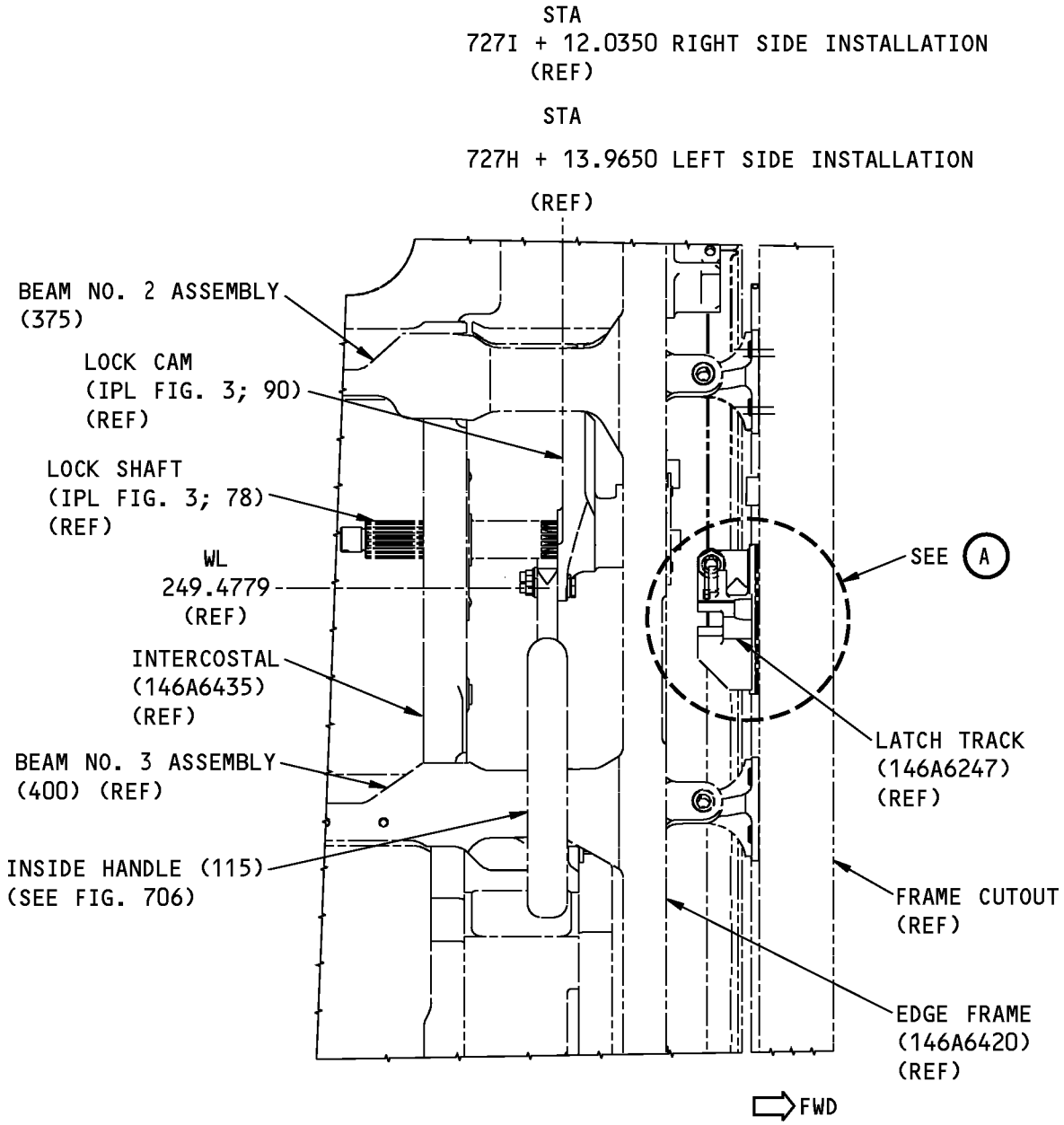
ITEM NUMBERS REFER TO IPL FIG. 4 UNLESS SHOWN DIFFERENTLY

ALL DIMENSIONS ARE IN INCHES

146A6500-1,-2 Door Lower Region Mechanism Installation Details
Figure 704 (Sheet 9 of 9)



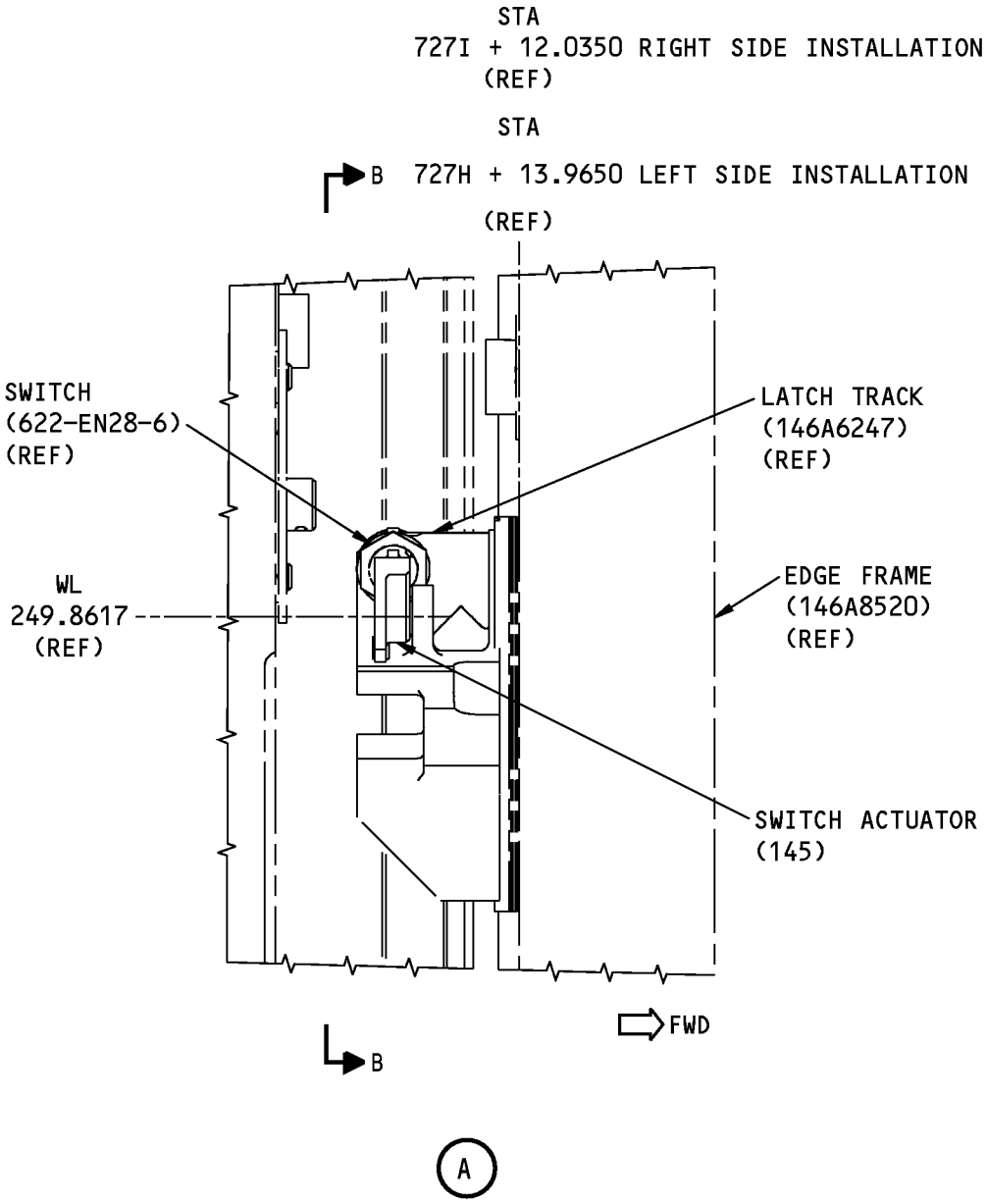
Activation Module Deep Details
Figure 705 (Sheet 1 of 4)



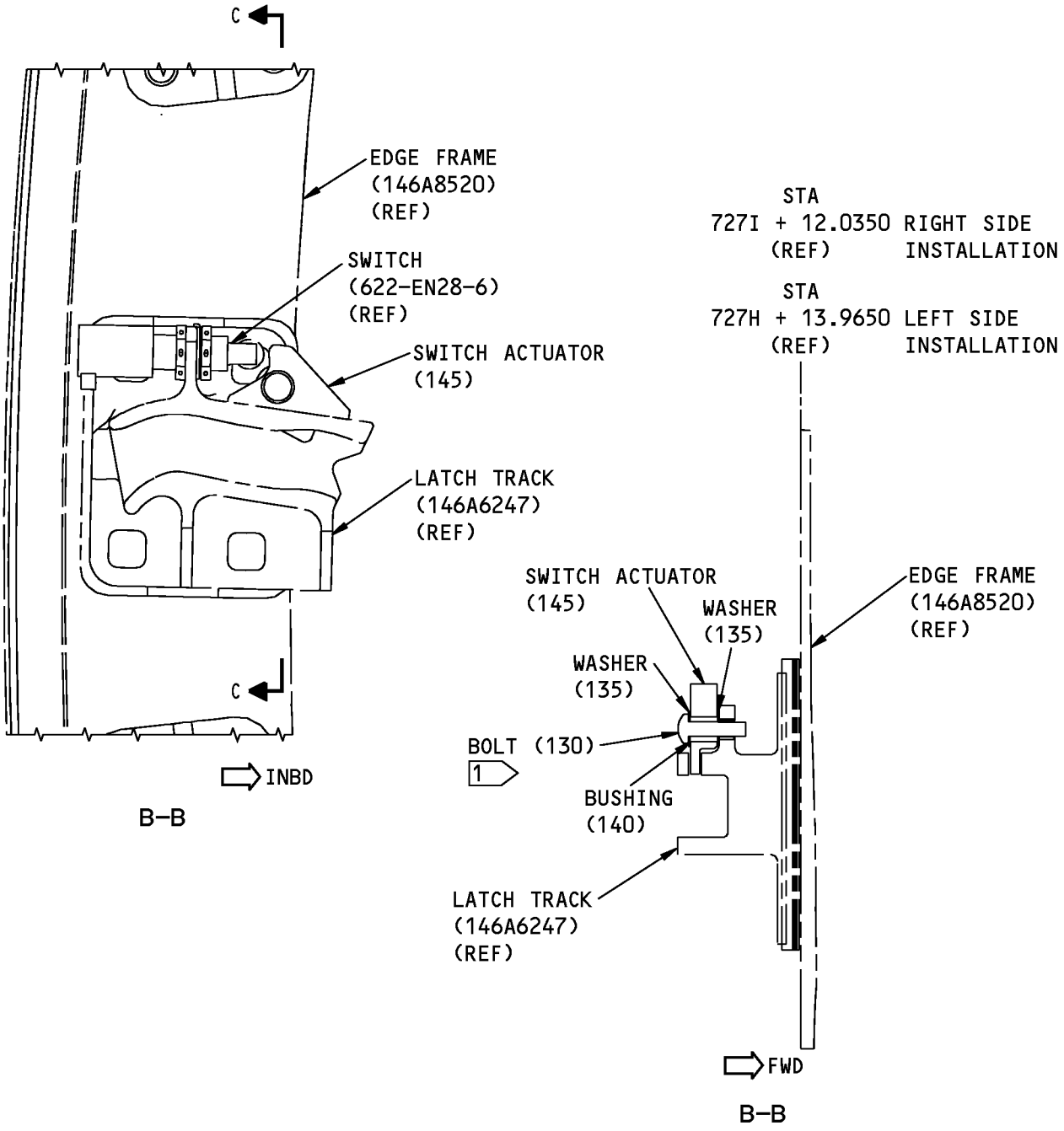
A–A

LEFT SIDE INSTALLATION SHOWN
RIGHT SIDE INSTALLATION SIMILAR
(SOME MECHANISM PARTS NOT SHOWN)

Activation Module Deep Details
Figure 705 (Sheet 2 of 4)



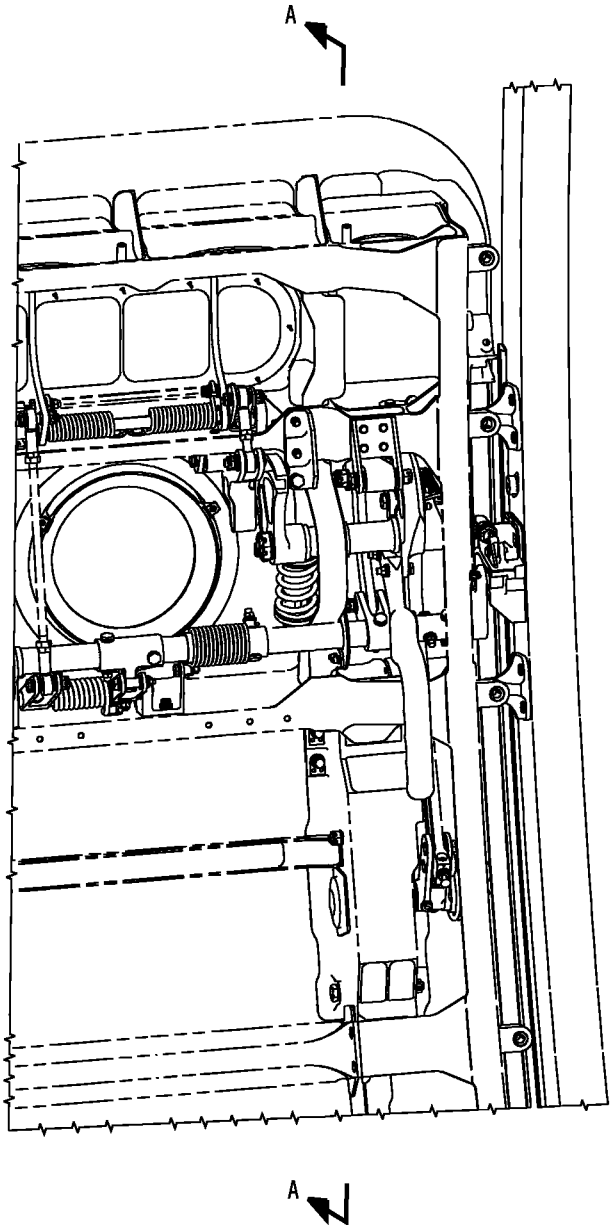
Activation Module Deep Details
Figure 705 (Sheet 3 of 4)



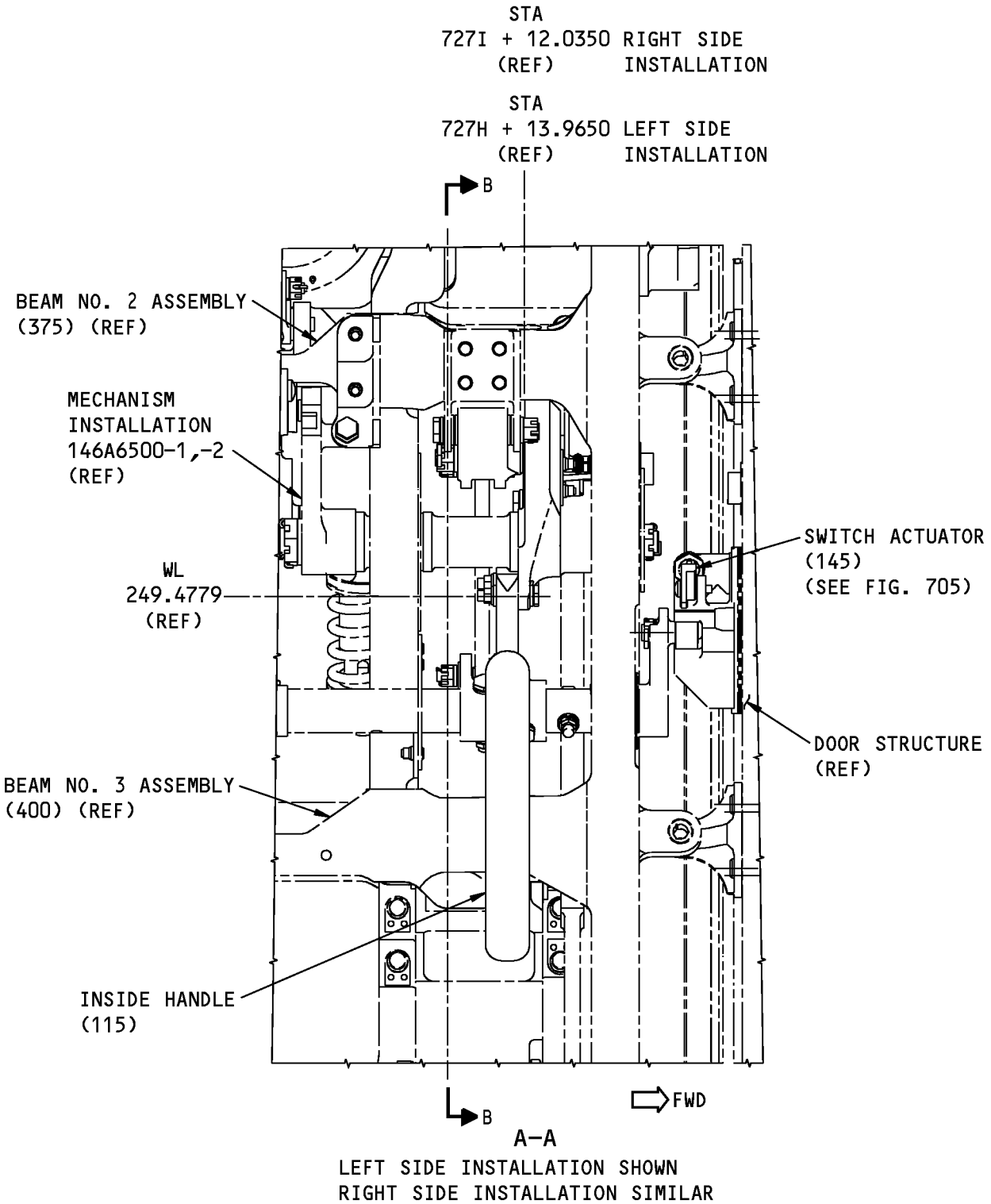
1 INSTALL THIS BOLT WITH ASTM D5363 AN0311 OR MIL-S-46163 TYPE 2, GRADE M COMPOUND (SOPM 20-50-12)

ITEM NUMBERS REFER TO IPL FIG. 1 UNLESS SHOWN DIFFERENTLY

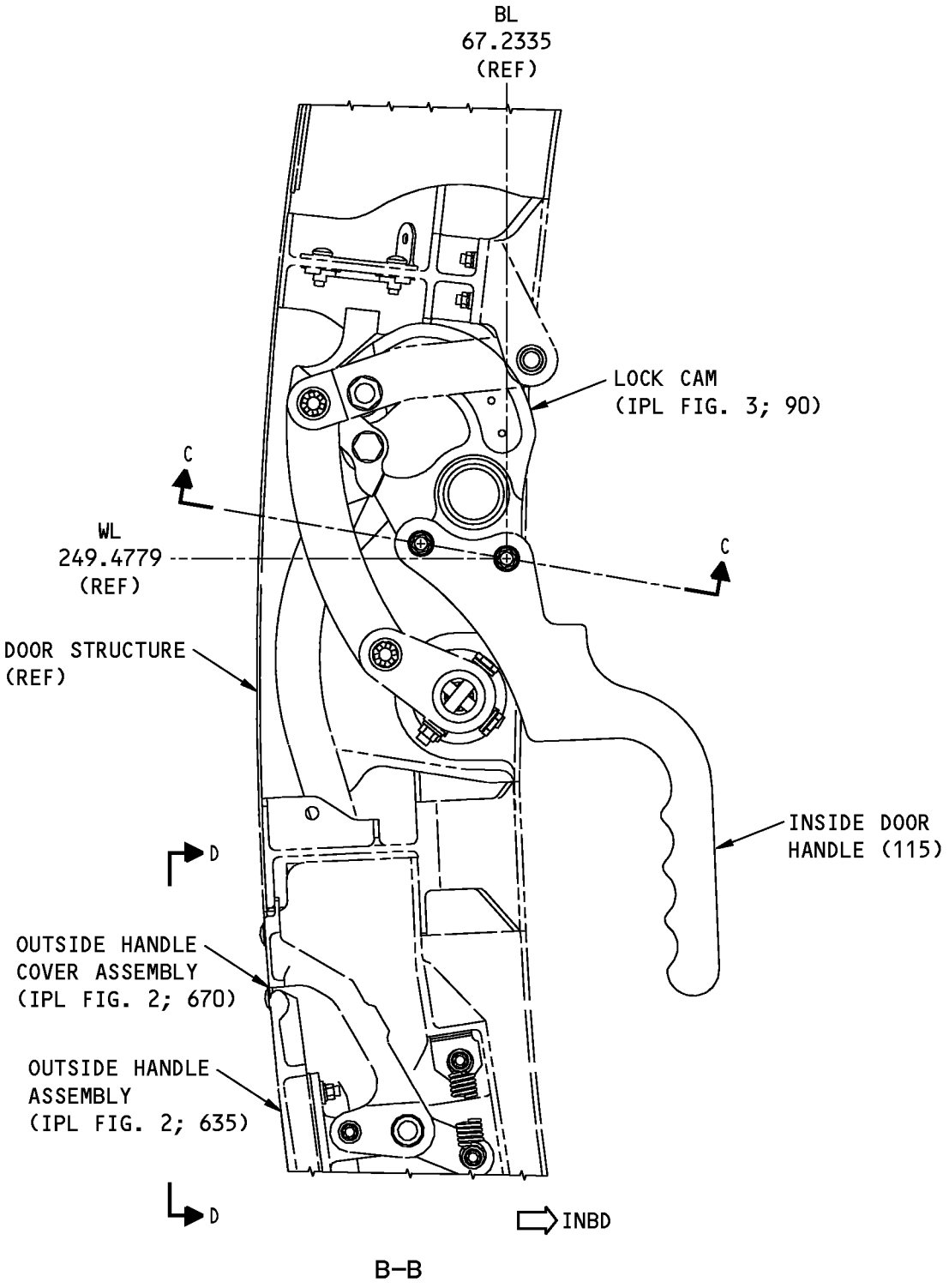
Activation Module Deep Details
Figure 705 (Sheet 4 of 4)



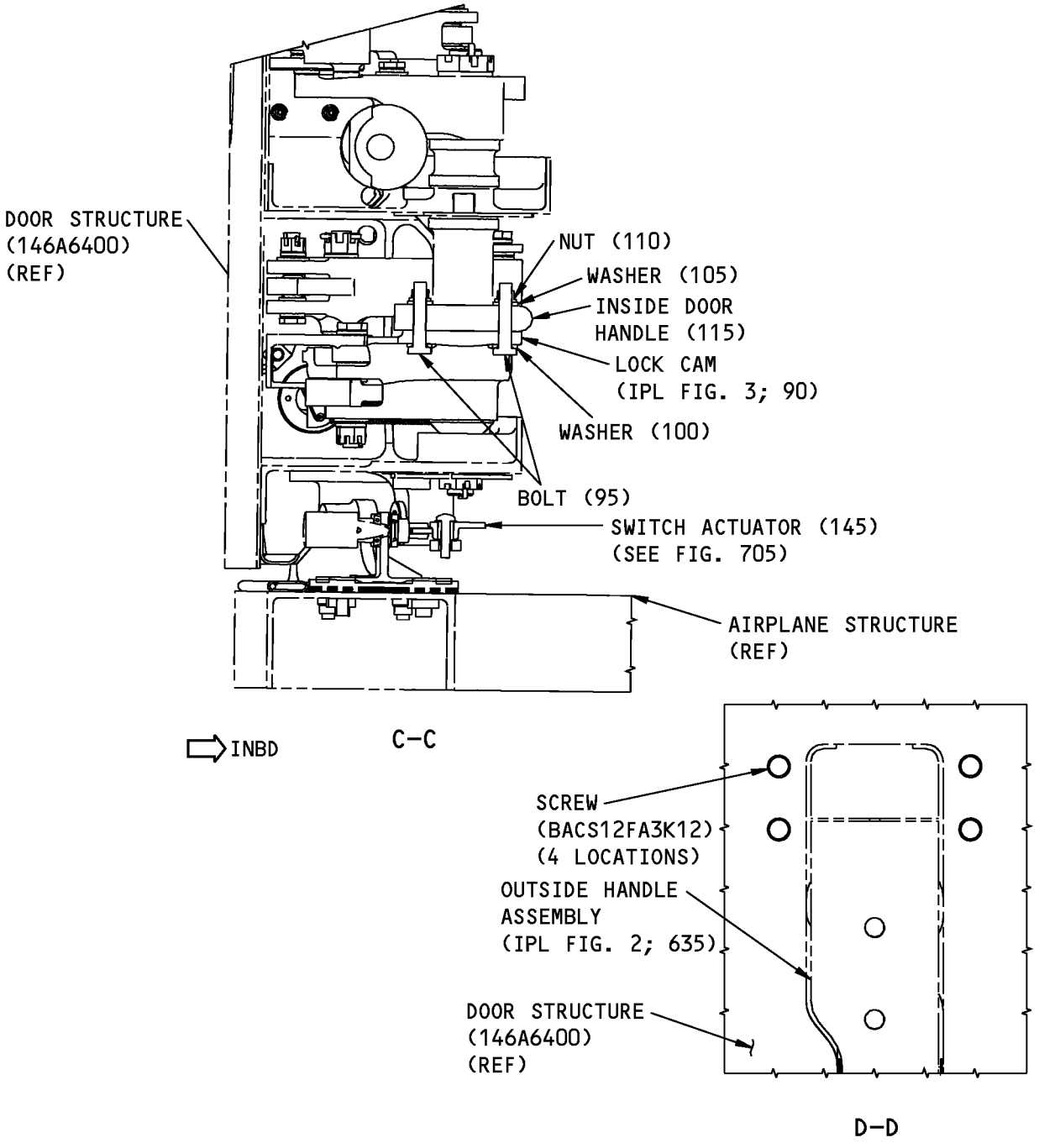
Inside Door Handle Installation Details
Figure 706 (Sheet 1 of 4)



Inside Door Handle Installation Details
Figure 706 (Sheet 2 of 4)



Inside Door Handle Installation Details
Figure 706 (Sheet 3 of 4)

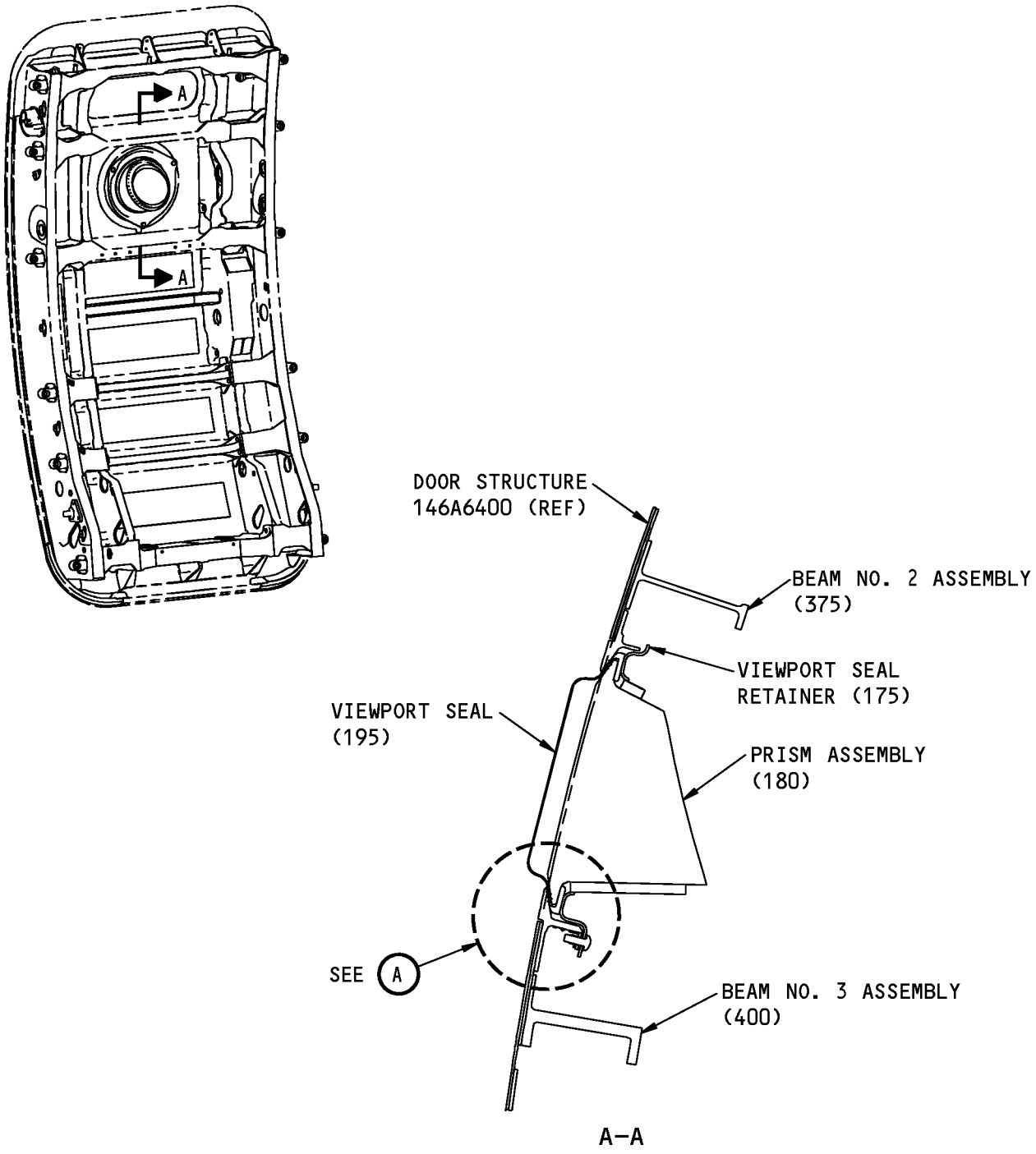


1 INSTALL WITH WET BMS 5-95 SEALANT (SOPM 20-50-19, METHOD 2)

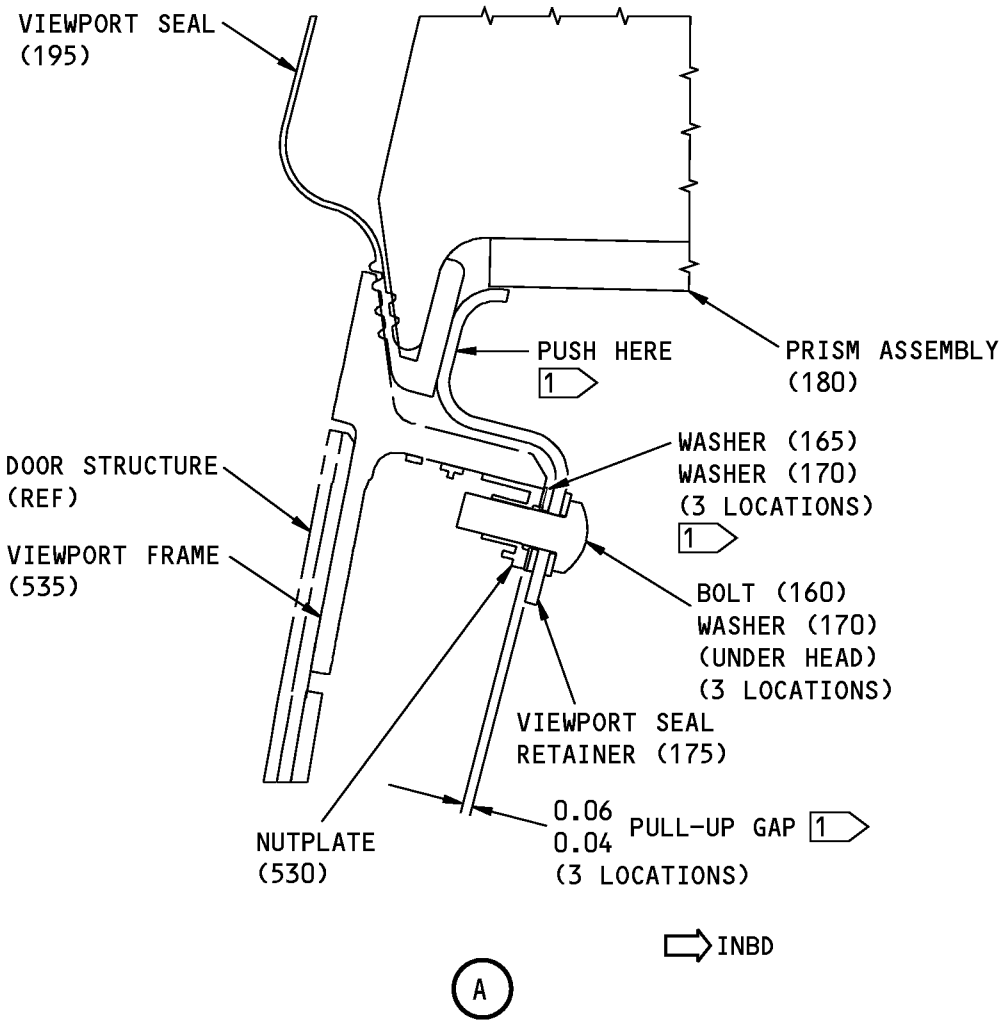
ITEM NUMBERS REFER TO IPL FIG. 1 UNLESS SHOWN DIFFERENTLY

ALL DIMENSIONS ARE IN INCHES

Inside Door Handle Installation Details
Figure 706 (Sheet 4 of 4)



Inside Door Handle Installation Details
Figure 707 (Sheet 1 of 2)



1 MEASURE THIS GAP WITH THE RETAINER PUSHED AGAINST THE SEAL. USE WASHERS (165,170) AS NECESSARY BETWEEN RETAINER AND NUTPLATE TO GET THIS GAP

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

Inside Door Handle Installation Details
Figure 707 (Sheet 2 of 2)

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
02758	NETWORKS ELECTRONIC CORP U S BEARING DIV 9750 DE SOTO AVENUE CHATSWORTH, CALIFORNIA 91311-4409 FORMERLY U S BEARING DIV NETWORKS ELEC CORP
04169	WESTERN SKY INDUSTRIES A DIVISION OF ATLAS CORPORATION 1280 SAN LUIS OBISPO STREET HAYWARD, CALIFORNIA 94544-7916 FORMERLY WESTERN SKY IND VB0008
06144	INDUSTRIAL TECTONICS BEARING CORP 18301 SOUTH SANTA FE AVENUE RANCHO DOMINGUEZ, CALIFORNIA 90221 FORMERLY IN COMPTON, CALIFORNIA
06725	AIR INDUSTRIES CORPORATION 12570 KNOTT STREET GARDEN GROVE, CALIFORNIA 92641-3932 FORMERLY AIR INDUSTRIES OF CALIF IN GARDENA, CALIF.
06950	SCREWCORP VSI AEROSPACE PRODUCTS DIV FAIRCHILD IND DIV 13001 EAST TEMPLE AVENUE PO BOX 730 CITY OF INDUSTRY, CALIFORNIA 91746-1417 FORMERLY VB0096 AND VSI CORP SCREWCORP DIV FORMERLY IN CULVER CITY, CALIFORNIA SCREW CORP SEE V.S.I. CORP SCREWCORP DIVISION

Code	Name
09455	RBC TRANSPORT DYNAMICS CORP 3131 W SEGERSTROM AVE SANTA ANA, CALIFORNIA 92704-5872 FORMERLY TRANSPORT DYNAMICS AEROSPACE DIV; FABROID DIV TRANSPORT DYNAMICS V17571 & LEAR SEIGLER INC TRANSPORT DIV V98076; FORMERLY BFM TRANSPORT DYNAMICS
0PTK6	SPS TECHNOLOGIES INC AEROSPACE PRODUCTS DIV 5195 W 4700 SALT LAKE CITY, UTAH 94118 SEE V56878 SPS TECHNOLOGIES INC
11815	CHERRY AEROSPACE FASTENERS DIV OF TEXTRON 1224 EAST WARNER AVENUE PO BOX 2157 SANTA ANA, CALIFORNIA 92707-0157 FORMERLY IN LOS ANGELES, CALIF , FORMERLY CHERRY FASTENERS TOWNSEND DIV OF TEXTRON INC V71087
15653	ALCOA GLOBAL FASTENERS INC DIV KAYNAR PRODUCTS 800 S STATE COLLEGE BLVD FULLERTON, CALIFORNIA 92831-3001 FORMERLY VK6405 MICRODOT AEROSP LTD; FORMERLY KAYNAR TECH FORMERLY FAIRCHILD FASTENERS KAYNAR DIV
15860	NEW HAMPSHIRE BALL BEARINGS, INC ASTRO DIVISION 155 LEXINGTON AVENUE LACONIA, NEW HAMPSHIRE 03246-2937 FORMERLY ASTRO BEARING CORP, LOS ANGELES, CALIF.
16746	SPECLINE INCORPORATED 2230 MOUTON DR CARSON CITY, NV 89706 FORMERLY IN SUN VALLEY, CAIFORNIA
17446	HUCK INTL INC AEROSPACE FASTENER DIV 900 WATSON CENTER ROAD CARSON, CALIFORNIA 90745-4201 FORMERLY V32134 REXNORD INC; FORMERLY V97928 HUCK INTL

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
29666	HUCK MANUFACTURING CO SUB OF FEDERAL-MOGUL CORP 6 THOMAS IRVINE, CALIFORNIA 92714 FORMERLY HUCK MFG CO VB0016 IN DETROIT, MICHIGAN
40920	MPB MINIATURE PRECISION BEARING DIV PRECISION PARK PO BOX 547 KEENE, NEW HAMPSHIRE 03431 FORMERLY MPB CORP AND MINIATURE BRG DIV MPB CORP
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
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
56644	AURORA BEARING CO 970 SOUTH LAKE STREET AURORA, ILLINOIS 60506-5929

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
5M902	ALCOA GLOBAL FASTENERS INC, DIV OF VOI-SHAN PRODUCTS 3000 W LOMITA BLVD TORRANCE, CALIFORNIA 90505-5103 FORMERLY FAIRCHILD INC INC FAIRCHILD AEROSPACE FASTENERS DIV
60516	WEST COAST AEROSPACE INC 812 MIRAFLORES STREET SAN PEDRO, CALIFORNIA 90731-1439
62554	SIMMONDS MECAERO FASTENERS INC 1734 SEQUOIA AVENUE ORANGE, CALIFORNIA 92668
71895	DELAVAN INC GAS TURBINE PRODUCTS DIV 811 4TH ST PO BOX 65100 WEST DES MOINES, IOWA 50265-0100
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 COMPANYOF 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

Code	Name
73197	HI-SHEAR TECHNOLOGY CORP 2600 SKYPARK DRIVE TORRANCE, CALIFORNIA 90509
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
91812	ESTERLINE MASON 13955 BALVOA ROAD SYLMAR, CALIFORNIA 91342 FORMERLY JANCO CORPORATION
92215	FAIRCHILD IND INC FAIRCHILD AEROSPACE FASTENER DIV 3010 W LOMITA BLVD TORRANCE, CALIFORNIA 90505-5102 FORMERLY VOI-SHAN IN CULVER CITY, CALIF
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
97415	SMITHS AEROSPACE ACTUATION SYSTEMS-YAKIMA 2720 W WASHINGTON AVE YAKIMA, WASHINGTON 98909-0907 FORMERLY DECOTO AIRCRAFT AND DOWTY DECOTO; FORMERLY DOWTY AEROSPACE YAKIMA

Code	Name
97613	SARGENT CONTROLS & AEROSPACE/KAHR BEARING DIV 5675 W BURLINGAME RD TUCSON, ARIZONA 85743 FORMERLY AETNA STEEL PROD KAHR BEARING DIV V96579 FORMERLY SARGENT IND KAHR BEARING DIV, BURBANK, CALIFORNIA
97928	Replaced: [V97928] SEE V17446 HUCK INTL by Code: Name and Address below 17446: HUCK INTL INC AEROSPACE FASTENER DIV 900 WATSON CENTER ROAD CARSON, CALIFORNIA 90745-4201 FORMERLY V32134 REXNORD INC; FORMERLY V97928 HUCK INTL
9N513	VOI SHAN/CHATSWORTH DIV OF VSI CORP SUB OF FAIRCHILD IND CHATSWORTH, CALIFORNIA 91311-5013 COMPANY NO LONGER WISHES TO BE CONSIDERED FOR FED CONTRCTG
S0352	NIPPON MINIATURE BEARING CO LTD TOKYO, JAPAN

NUMERICAL INDEX

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
102B13171-3		2	805	1
102F9201-3		1	385	2
		1	410	6
		1	485	2
102F9220-3		1	565	4
109LH9075-4W		3	54	1
10E4-116M		2	155	1
12E4-117M		2	100	2
		2	150	1
140N2035-1		1	180	1
140N2036-1		1	185A	1
140N2612-3		1	195	1
140N2623-7		1	365	2
		1	390	2
		1	415	2
		1	440	2
		1	465	2
		1	500	2
140N2764-1		1	190A	1
146A6200-1		1	1A	RF
146A6200-2		1	5	RF
146A6210-1REVA		1	10	1
146A6210-1REVB		1	10A	1
146A6210-1REVC		1	10B	1
146A6210-2REVA		1	15	1
146A6210-2REVB		1	15A	1
146A6210-2REVC		1	15B	1
146A6249-1		1	145	1
146A6250-1REVA		1	85	1
146A6250-2REVA		1	90	1
146A6250-3REVA		1	120	1
146A6250-4REVA		1	125	1
146A6251-1		1	115	1
146A6400-3REVA		1	225	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
146A6400-3REVB		1	225A	1
146A6400-3REVC		1	225B	1
146A6400-4REVA		1	230	1
146A6400-4REVB		1	230A	1
146A6400-4REVC		1	230B	1
146A6400-5REVA		1	150	1
146A6400-6REVA		1	155	1
146A6418-1		1	510	2
146A6418-3		1	610	1
146A6420-1		1	765	1
146A6420-101		1	905	1
146A6420-103		1	760	1
146A6420-105		1	850	1
146A6420-107		1	905A	1
146A6420-3		1	685	1
146A6420-7		1	765A	1
146A6421-1		1	335	1
146A6421-101		1	370	1
146A6422-1		1	375	1
146A6422-101		1	395	1
146A6423-1		1	400	1
146A6423-101		1	420	1
146A6424-1		1	425	1
146A6424-101		1	445	1
146A6425-1		1	450	1
146A6425-101		1	470	1
146A6426-1		1	475	1
146A6426-101		1	515	1
146A6428-1		1	520	1
146A6428-101		1	535	1
146A6431-1		1	640	1
146A6431-2		1	645	1
146A6432-1		1	635	1
146A6433-1		1	650	1
146A6433-2		1	655	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
146A6434-1		1	660	1
146A6435-105		3	332	1
146A6439-1		1	570	1
146A6439-3		1	675	1
146A6439-4		1	680	1
146A6445-1		1	575	1
146A6445-101		1	630	1
146A6445-103		1	580	1
146A6447-1		1	815	1
146A6447-2		1	700	1
146A6449-1		1	900	1
146A6449-2		1	755	1
146A6454-1		1	215	2
146A6454-3		1	220	2
146A6456-1		1	175	1
146A6500-1REVA		1	930	1
		4	1A	RF
146A6500-2REVA		1	935	1
		4	5	RF
146A6500-3REVA		1	920	1
		3	1A	RF
146A6500-3REVB		1	920A	1
		3	1B	RF
146A6500-3REVC		1	920B	1
		3	1C	RF
146A6500-4REVA		1	925	1
		3	3	RF
146A6500-4REVB		1	925A	1
		3	3A	RF
146A6500-4REVC		1	925B	1
		3	3B	RF
146A6500-5REVA		1	910	1
		2	1A	RF
146A6500-5REVB		1	910A	1
		2	1B	RF

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
146A6500-6REVA		1	915	1
		2	5	RF
146A6500-6REVB		1	915A	1
		2	5A	RF
146A6509-1		3	414	1
146A6510-1		3	492	1
146A6510-101		3	513	1
146A6510-103		3	489	1
146A6510-3		3	465	1
146A6511-3		3	642	1
146A6511-4		3	636	1
146A6511-5		3	519	1
146A6511-7		2	195	1
146A6511-8		2	200	1
146A6511-9		2	665	1
146A6512-1		3	435	1
146A6512-101		3	459	1
146A6512-103		3	462	1
146A6512-3		3	438	1
146A6516-1		3	525	1
146A6520-1		3	576	1
146A6521-1		3	651	1
146A6522-1		3	597	2
146A6522-101		3	618	1
146A6523-1		3	639	1
146A6523-3		3	648	1
146A6524-1		3	621	1
146A6524-101		3	630	1
146A6526-1		2	635	1
146A6526-101		2	655	1
146A6527-1		2	620	1
146A6527-101		2	630	1
146A6529-1		2	445	1
146A6530-1		2	140	1
146A6530-2		2	90	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
146A6531-1		2	105	1
146A6532-1		2	380	1
146A6535-1		2	420	1
146A6535-101		2	435	1
146A6536-1		2	385	1
146A6536-101		2	415	1
146A6537-1		2	440	1
146A6539-1		2	55	1
146A6540-1		2	260	1
146A6540-101		2	310	1
146A6542-1		2	305	1
146A6545-1		2	255	1
146A6545-3		3	522	1
146A6546-1		2	210	1
146A6546-101		2	225	1
146A6546-102		2	230	1
146A6546-2		2	215	1
146A6547-1		2	235	1
146A6547-101		2	250	1
146A6551-1		4	275	1
146A6551-101		4	290	1
146A6552-1		4	295	1
146A6552-101		4	320	1
146A6552-102		4	325	1
146A6552-2		4	300	1
146A6553-1		4	380	2
146A6553-101		4	395	1
146A6554-1		4	400	2
146A6554-101		4	415	1
146A6554-102		4	420	1
146A6554-2		4	405	2
146A6555-1		4	250	1
146A6555-101		4	265	1
146A6555-102		4	270	1
146A6555-2		4	255	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
146A6556-1		4	330	2
146A6556-3		4	330A	1
146A6557-1		4	335	1
146A6557-101		4	355	1
146A6557-102		4	360	1
146A6557-2		4	340	1
146A6558-1		4	375A	1
146A6558-3		4	375B	1
146A6559-1		4	365	1
146A6559-2		4	370	1
146A6562-1		4	225	1
146A6562-2		4	230	1
146A6568-1		3	645	1
146A6568-2		3	633	1
146A6568-4		2	660	1
146A6568-5		3	516	1
146A6575-1		3	288	1
146A6575-101		3	300	1
146A6575-103		3	156	1
146A6575-3		3	144	1
146A6576-1		3	303	1
146A6576-101		3	312	1
146A6576-103		3	168	1
146A6576-3		3	159	1
146A6577-1		3	129	1
146A6577-101		3	135	1
146A6577-103		3	126	1
146A6577-3		3	120	1
146A6578-1		3	315	1
146A6578-101		3	321	1
146A6579-1		3	199	1
146A6579-101		3	200A	1
146A6580-1		3	90	1
146A6580-101		3	99	1
146A6580-103		3	233	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
146A6580-3		3	231	1
146A6581-1		3	78	1
146A6582-1		3	81	1
146A6582-3		3	84	1
146A6582-5		3	87	1
146A6583-1		3	141	2
146A6583-3		2	205	1
146A6585-1		3	138	1
146A6586-1		3	207	1
146A6586-3		3	175	1
146A6587-1		3	324	1
146A6589-1		2	670	1
146A6589-101		2	740	1
146A6590-1		2	780	1
146A6590-101		2	815	1
146A6591-1		2	325	1
146A6591-101		2	335	1
146A6592-1		1	595	1
146A6597-1		2	530	1
146A6597-101		2	540	1
146A6597-102		2	490A	1
146A6597-2		2	480	1
2-7892-2		4	220	2
51588-041DD		2	155	1
51589-041DD		2	100	2
		2	150	1
69-47407-3		2	730	1
740C14-6		1	80	2
		1	555	2
92834-1032CD		2	805	1
97E48		3	54	1
ACMKP04JAP510LY		4	55	8
ACMKP05JAP510LY		4	305	2
		4	385	2
ACMKP06JAP510LY		2	640	2

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
ACMKP3AFS428		4	55	8
ADB06V301NC		2	625	2
ADB08V301NC		2	330	1
ADW4VNC		3	123A	1
		3	318	2
ADW5VNC		2	810	1
AMB540DDNJC		2	378	2
AMKP16BSNJC		1	715	1
		1	860	1
AR4-7W13		2	100	2
		2	150	1
AR4E7W13		2	155	1
ARB4-61MW		2	100	2
		2	150	1
ARB4E60MW		2	155	1
ASMK4-1DM		2	155	1
ASWK4-1DM		2	100	2
		2	150	1
BACB10ES04GC		4	260	1
		4	310	1
BACB10ES10C		1	855A	1
BACB10FB05C		2	220	1
		3	456	1
BACB10FB06GC		2	625	2
BACB10FB08GC		2	330	1
BACB10FB10C		1	855	1
BACB10FE04C		3	123A	1
		3	318	2
BACB10FE05C		2	810	1
BACB10FE4C		3	132	1
BACB10FS04J		4	55	8
BACB10FS05J		4	305	2
		4	385	2
BACB10FS06J		2	640	2
BACB10FU14J		2	378	2

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACB10FV16J		1	715	1
		1	860	1
BACB10HS06ARBSP2		3	261	1
BACB10HS06ARNSP6		3	615	1
BACB10Y4M		2	155	1
BACB10Z4M		2	100	2
		2	150	1
BACB28AK03-012		2	355	1
		2	695	1
BACB28AK03-022		2	360	1
		2	690	1
BACB28AK03-035		1	880	1
		2	405	1
BACB28AK03-258		4	215	2
BACB28AK04-011		3	118	1
BACB28AK04-015		2	85	1
BACB28AK04-025		2	295	3
		3	486	1
BACB28AK04-026		4	125	4
BACB28AK04-027		2	35	2
BACB28AK04-030		2	135	1
		3	369	1
		3	453	1
		3	594	2
BACB28AK04-031		3	18	1
BACB28AK04-035		3	387	1
BACB28AK04-037		3	255	2
BACB28AK04-055		3	507	1
BACB28AK04-080		2	775	1
BACB28AK04-200		3	48	1
BACB28AK05-037		3	195	1
BACB28AK05-038		4	90	2
BACB28AK05-051		1	65	4
		4	160	4
BACB28AK05-055		3	198	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		4	95	2
BACB28AK05-090		4	165	2
BACB28AK05-120		1	70	2
BACB28AK05-155		3	285	1
BACB28AK05-42		1	60	4
BACB28AK06-007		2	565A	2
BACB28AK06-018		2	515	1
BACB28AK06-039		2	590	1
		2	615	1
BACB28AK06-048		2	520	1
BACB28AK06-053		2	770	1
BACB28AP04-009		2	240	1
BACB28AP04-011		4	345	1
BACB28AP04-014		3	480	1
		3	510	2
BACB28AP04-018		3	150	1
BACB28AP04-022		3	294	1
		3	624	1
BACB28AP05-011		3	93A	2
BACB28AP06P018		2	425	1
		2	645	1
BACB28AP06P052		4	280	1
BACB28AT06B012A		2	410	1
		4	350	1
BACB28AT06B014A		3	483	1
BACB28AT06B015A		2	245	1
BACB28AT06B018A		3	153	1
BACB28AT06B018C		3	162	1
BACB28AT06B022A		3	297	1
		3	627	1
BACB28AT06B027C		1	620	2
BACB28AT06B037C		1	625	2
BACB28AT06B045C		2	735	2
BACB28AT07B022C		1	505	2
		1	720	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	885	1
		3	96	1
BACB28AT07C015A		3	306	1
BACB28AT09B018A		2	430	1
BACB28AT09B018C		2	650	1
BACB28AX04B053		3	232	2
BACB28AX04C018		3	165	1
BACB28AX04C022		2	300	1
BACB28AX05B014		3	309	1
BACB28AX05C014		3	309A	1
BACB28AY07A026C		4	285	4
BACB28AY07A028C		4	410	1
BACB28AY10A025C		2	297	2
BACB28AZ06A065B		3	147	2
BACB28AZ07A056B		3	291	2
BACB28BC07A052B		3	199J	1
BACB28BG06A06381		4	35	2
BACB28Y3M035		1	140	1
BACB28Y4C035		2	725	1
BACB28Y5C390		4	315	1
		4	390	1
BACB30LE4U16		2	270	1
BACB30LH3-13		2	450	2
BACB30LH4-10		4	40	8
BACB30LM3-17		2	705	1
BACB30LM3-19		2	365	4
BACB30LM3-9		2	340	1
		2	675	1
BACB30LR4D16		2	750	1
BACB30MR4A10		3	342	2
BACB30MR4A6		3	339	2
BACB30NR4DK13		4	105	4
BACB30NR4DK16		2	65	1
BACB30NR4DK17		2	115	1
BACB30NR4DK18		3	375	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACB30NR4DK20		3	237	2
BACB30NR4DK27		3	108	1
BACB30NR4DK28		3	105	1
BACB30NR4DK38		3	36	1
BACB30NR4K10		2	265	1
BACB30NR4K11		2	160	1
BACB30NR4K13		3	417	1
BACB30NR4K14		1	95	2
		3	420	1
BACB30NR4K18		3	390	3
BACB30NR4K20		3	393	1
BACB30NR4K22		3	396A	1
		3	579	2
BACB30NR4K24		3	582	4
BACB30NR4K7		3	441	1
BACB30NR4K8		3	468	1
BACB30NR4K9		2	10	2
		3	354	1
BACB30NR5DK29		3	183	1
		3	273	1
BACB30NR5DK42		4	135	2
BACB30NR5DK84		4	65	2
BACB30NR5DK88		4	70	2
BACB30NR5K27		1	20	2
BACB30NR5K43		1	25	2
BACB30NR6DK16		2	575	1
		2	600	1
		4	175	2
BACB30NR6DK33		4	15	2
BACB30NT3K3		1	160	3
BACB30NT3K4		3	201	2
BACB30NT3K6		1	130	1
BACB30NT4DK17		3	9	1
BACB30NX6K5		3	213	1
BACB30NX6K7		3	210	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACB30PW4U18		3	495	1
BACB30VT5HK4		1	585	4
		1	600	2
		1	835	1
BACB30VT5HK6		1	830	1
BACB30VT5K3		3	333	4
BACB30VT5K4		1	665	6
BACB30VT6K11		4	235	2
BACB30VT6K3		1	235	29
BACB30VT6K4		1	240	162
		1	835A	1
		2	315	3
BACB30VT6K5		1	245	40
		1	705	4
		1	820	4
BACB30VT6K6		1	250	4
		1	745	3
		1	830A	1
		1	890	3
BACB30VT6K7		1	255	5
BACB30VT6K8		1	865	1
BACB30VT6K9		2	390	1
BACB30VT8K5		3	327	6
BACB30YL6K4		2	40	6
BACB30YL6K6		3	21	2
		3	219	4
BACB30YL6K7		3	24	2
BACB30YP5K3		1	262	2
BACB30YP5K4		1	264	6
BACB30YP5K5		3	171	2
BACB30YP6K11		4	240	1
BACB30YP6K4		1	265	2
BACB30YP6K5		1	270	2
BACB30YP6K7		1	275	2
BACB30YP6K8		1	277	6

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACB31A3-46		4	195	2
BACC30BH6S		3	216	2
BACC30BL5		1	282	4
		1	590	4
		1	605	2
		1	670	6
		1	840	2
		3	174	2
		3	336	4
BACC30BL6		1	260	240
		1	280	12
		1	710	4
		1	750	3
		1	825	4
		1	840A	2
		2	320	3
		4	245	3
BACC30BL8		3	330	6
BACC30BS6S		1	875	1
		2	400	1
BACC30CP6C		2	45	6
BACC30CQ6CR		3	27	4
BACC30L6		1	895	3
BACG20ZB001510		1	200	2
BACJ40CG6G		1	80	2
		1	555	2
BACN10BP6CD		4	30	2
BACN10GH3A10		1	355	1
BACN10JC4CM		3	54	1
BACN10JD104CD		4	120	4
BACN10JD106AU		3	612	1
BACN10JD106CD		2	585	1
		2	610	1
		4	190	2
BACN10JD108ASU		3	72	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACN10JD110ASU		3	75	1
BACN10JD4ASU		2	130	1
BACN10JD4AU		3	249	1
BACN10JD4CD		2	80	1
		2	765	1
		3	15	1
		3	45	1
		3	117	2
		3	252	1
		3	384	1
BACN10JD5ASU		2	510	1
		2	560	1
		3	192	1
BACN10JD5CD		3	282	1
		4	85	4
		4	155	2
BACN10JD6CD		3	267	1
BACN10JR3CFD		1	385	2
		1	410	6
		1	485	2
BACN10JZ3B2CDM		1	565	4
BACN10KJ3CD		1	530	3
BACN10TL3A12		1	345	3
		1	735	3
BACN10TL3A16		1	740	1
		1	800	1
BACN10TL3A3		1	435	1
		1	460	1
		1	495	1
BACN10YR3CD		2	350	1
		2	375	4
		2	470	2
		2	685	1
		2	720	1
		4	210	2

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACN10YR3CM		3	504	1
BACN10YR4CD		1	110	2
		2	30	2
		3	366	1
		3	450	1
		4	50	8
BACN10YR4CM		2	170	1
		2	290	2
		3	405	5
		3	429	2
		3	477	1
		3	591	6
BACN10YR5CD		1	40	4
		1	55	2
		1	550	2
BACN10YT3CD		3	222	4
BACN10ZC3CD		2	805	1
BACN11U3CM1		2	795	1
BACN11U5CD2		3	228	2
BACN11U5CM1N		2	95	2
		2	145	1
BACN11Z4CD		3	351	4
BACP18BC02A03P		4	100	4
BACP18BC02A04P		4	60	4
		4	130A	2
BACP18BC02A05P		3	6	1
		3	33	1
		3	102	2
		3	234	2
		3	372	1
BACP18BC02A06P		2	60	1
		2	110	1
		2	475	1
		2	525A	1
		3	180	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		3	270	1
BACP18BC03A04P		3	63A	1
BACP18BC03A05P		4	10	2
		4	170	2
BACP18BC03A08P		2	570	1
		2	595	1
BACP18BC03A10P		3	258	1
		3	600	1
BACP18BC04A08P		3	60A	1
BACP18C02A06P		2	745	1
BACR10AL3A		2	800	1
BACR15BA3AD2C		1	525A	6
BACR15BA3ADC		1	380	4
		1	405	12
		1	480	4
BACR15BA4ADC		1	560	8
BACR15BB3ADC		1	340	6
		1	805	10
BACR15BB4ADC		1	350	2
		1	430	2
		1	455	2
		1	490	2
		1	690	10
		1	730	8
		1	795	2
BACR15GF5D		1	632	144
BACR15GF6D		1	634	65
BACS12CK3U26		2	785	1
BACS12HN3-12		1	770	1
BACS12HN5-10		1	540	2
BACS12HN5-12		1	45	2
BACS12HN5-14D		3	225	1
BACS31H1B		1	360	1
		1	725	4
		1	790	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACS40R008A017F		1	320	3
BACS40R008E026F		2	460	1
BACS40R009A009F		1	285	16
BACS40R009A017F		1	315	1
BACS40R009A028F		1	325	2
BACS40R009A029F		1	305	2
BACS40R009A033F		1	290	2
BACS40R009A034F		1	295	6
BACS40R010A016F		1	310	1
BACS40R012A022F		1	330	1
BACS40R015A022F		1	300	1
BACS40R020Y023P		3	30	1
BACS40U3L3		1	845	2
BACW10BN10AC		2	180	1
BACW10BN4AP		2	25	2
		2	75	2
		3	363	1
BACW10BN5AC		2	175	1
BACW10BP10APU		3	69	1
BACW10BP3CD		4	200	2
BACW10BP3DP		4	205	2
BACW10BP3NAPU		3	204	2
BACW10BP4AC		3	357	1
		3	378	1
BACW10BP4ACU		1	100	2
		2	15	2
		2	70	1
		2	120	1
		2	275	2
		3	39	1
		3	111	2
		3	240	2
		3	399	5
		3	423	2
		3	444	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		3	471	1
		3	498	1
		3	585	6
		4	110	4
BACW10BP4AP		3	381	2
BACW10BP4APU		2	125	2
		2	165	1
		2	280	2
		3	51	1
		3	243	1
		3	402	5
		3	426	2
		3	447	1
		3	474	2
		3	588	8
		4	115	4
BACW10BP4CD		3	345	4
		4	45	8
BACW10BP4DP		1	105	2
		3	12	1
		3	42	1
		3	114	2
		3	246	1
		3	348	4
BACW10BP5ACU		3	186	1
		3	276	1
BACW10BP5APU		3	189	1
		3	279	1
BACW10BP5CD		1	30	8
		4	75	4
		4	140	2
BACW10BP5DP		4	80	4
		4	145	2
BACW10BP6ACU		3	432	2
BACW10BP6CD		4	20	2

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		4	180	2
BACW10BP6DP		3	264	1
		4	25	2
		4	185	2
BACW10EC3S		1	775	1
BACW10P271TF		2	715	2
BACW10P399CD		2	190	1
BACW10P435CG		2	20	2
		3	360A	1
BACW10P5CC		1	870	1
		2	395	1
BCREF50875		3	615	1
BCREF51111		4	35	2
BCREF51180		3	261	1
BRES4-2236M1		2	155	1
BRES4-2242M1		2	100	2
		2	150	1
BRF200C3D		1	385	2
		1	410	6
		1	485	2
BRH10C4M		3	54	1
DCM6E		1	895	3
		1	895	3
DE847		1	695	5
		1	810	5
F51646-3BAC		1	565	4
F51652-3		1	530	3
FSSK4AS1		2	100	2
		2	150	1
H01-4BAC		3	54	1
H52732-3CD		2	350	1
		2	375	4
		2	470	2
		2	685	1
		2	720	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		4	210	2
H52732-3CM		3	504	1
H52732-4CD		1	110	2
		2	30	2
		3	366	1
		3	450	1
		4	50	8
H52732-4CM		2	170	1
		2	290	2
		3	405	5
		3	429	2
		3	477	1
		3	591	6
H52732-5CD		1	40	4
		1	55	2
		1	550	2
HB4-201KM		2	100	2
		2	150	1
HB4E212KM		2	155	1
HL1012AZ6-5		3	213	1
		3	213	1
		3	213	1
		3	213	1
		3	213	1
		3	213	1
		3	213	1
		3	213	1
		3	213	1
HL1012AZ6-7		3	210	1
		3	210	1
		3	210	1
		3	210	1
		3	210	1
		3	210	1
		3	210	1
		3	210	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HL1087DU6		3	216	2
		3	216	2
		3	216	2
		3	216	2
HL12VAZ6-5		3	213	1
		3	213	1
		3	213	1
		3	213	1
HL12VAZ6-7		3	210	1
		3	210	1
		3	210	1
		3	210	1
HLT420AP6-4		2	40	6
		2	40	6
		2	40	6
HST1094DU6		1	875	1
		2	400	1
HST10AG5-3		3	333	4
		3	333	4
		3	333	4
		3	333	4
HST10AG5-4		1	665	6
		1	665	6
		1	665	6
		1	665	6
HST10AG6-11		4	235	2
		4	235	2
		4	235	2
		4	235	2
HST10AG6-3		1	235	29
		1	235	29
		1	235	29
		1	235	29
HST10AG6-4		1	240	162
		1	240	162

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	240	162
		1	240	162
		1	835A	1
		1	835A	1
		1	835A	1
		1	835A	1
		2	315	3
		2	315	3
		2	315	3
		2	315	3
HST10AG6-5		1	245	40
		1	245	40
		1	245	40
		1	245	40
		1	705	4
		1	705	4
		1	705	4
		1	705	4
		1	820	4
		1	820	4
		1	820	4
		1	820	4
HST10AG6-6		1	250	4
		1	250	4
		1	250	4
		1	250	4
		1	745	3
		1	745	3
		1	745	3
		1	745	3
		1	830A	1
		1	830A	1
		1	830A	1
		1	830A	1
		1	890	3

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	890	3
		1	890	3
		1	890	3
HST10AG6-7		1	255	5
		1	255	5
		1	255	5
		1	255	5
HST10AG6-8		1	865	1
		1	865	1
		1	865	1
		1	865	1
HST10AG6-9		2	390	1
		2	390	1
		2	390	1
		2	390	1
HST10AG8-5		3	327	6
		3	327	6
		3	327	6
		3	327	6
HST79-5		1	282	4
		1	590	4
		1	605	2
		1	670	6
		1	840	2
		3	174	2
		3	336	4
HST79-6		1	260	240
		1	280	12
		1	710	4
		1	750	3
		1	825	4
		1	840A	2
		2	320	3
		4	245	3
HST79-8		3	330	6

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HST79CY5		1	282	4
		1	282	4
		1	282	4
		1	590	4
		1	590	4
		1	590	4
		1	605	2
		1	605	2
		1	605	2
		1	670	6
		1	670	6
		1	670	6
		1	840	2
		1	840	2
		1	840	2
		3	174	2
		3	174	2
		3	174	2
		3	336	4
		3	336	4
		3	336	4
HST79CY6		1	260	240
		1	260	240
		1	260	240
		1	280	12
		1	280	12
		1	280	12
		1	710	4
		1	710	4
		1	710	4
		1	750	3
		1	750	3
		1	750	3
		1	825	4
		1	825	4

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	825	4
		1	840A	2
		1	840A	2
		1	840A	2
		2	320	3
		2	320	3
		2	320	3
		4	245	3
		4	245	3
		4	245	3
HST79CY8		3	330	6
		3	330	6
		3	330	6
HTES04VC		4	260	1
		4	310	1
HTFB06GC		2	625	2
HTFB08GC		2	330	1
K0540-075		1	205	1
K0540-125		1	210	4
K51602-3BAC		1	385	2
		1	410	6
		1	485	2
KB4-150WD5		2	100	2
		2	150	1
KBE4-150WD5		2	155	1
KNDB06-70		2	625	2
KNDB08-70		2	330	1
KPD4434		1	75	12
KR4CWGBZC		3	123A	1
		3	318	2
KR5CWGBZC		2	810	1
KRP146004BT		3	57	1
KSC145700BZ06GC		2	625	2
KSC145700BZ08GC		2	330	1
KWDB4-39		3	123A	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		3	318	2
KWDB5-39		2	810	1
L802-6K5		3	213	1
L802-6K7		3	210	1
M0DREF284105		1	85	1
M0DREF284106		1	90	1
M0DREF284107		1	120	1
M0DREF284108		1	125	1
M0DREF284217		1	225	1
M0DREF284218		1	230	1
M0DREF284219		1	150	1
M0DREF284220		1	155	1
M0DREF285799		1	10	1
M0DREF285800		1	15	1
M0DREF287697		1	930	1
		4	1A	RF
M0DREF287698		1	935	1
		4	5	RF
M0DREF287699		1	920	1
		1	925	1
		3	1A	RF
		3	3	RF
M0DREF287701		1	910	1
		2	1A	RF
M0DREF287702		1	915	1
		2	5	RF
M0DREF291630		1	10A	1
M0DREF291631		1	15A	1
M0DREF292663		1	225A	1
M0DREF292664		1	230A	1
M0DREF294875		1	10B	1
M0DREF294876		1	15B	1
M0DREF295479		1	920A	1
		3	1B	RF
M0DREF295480		1	925A	1

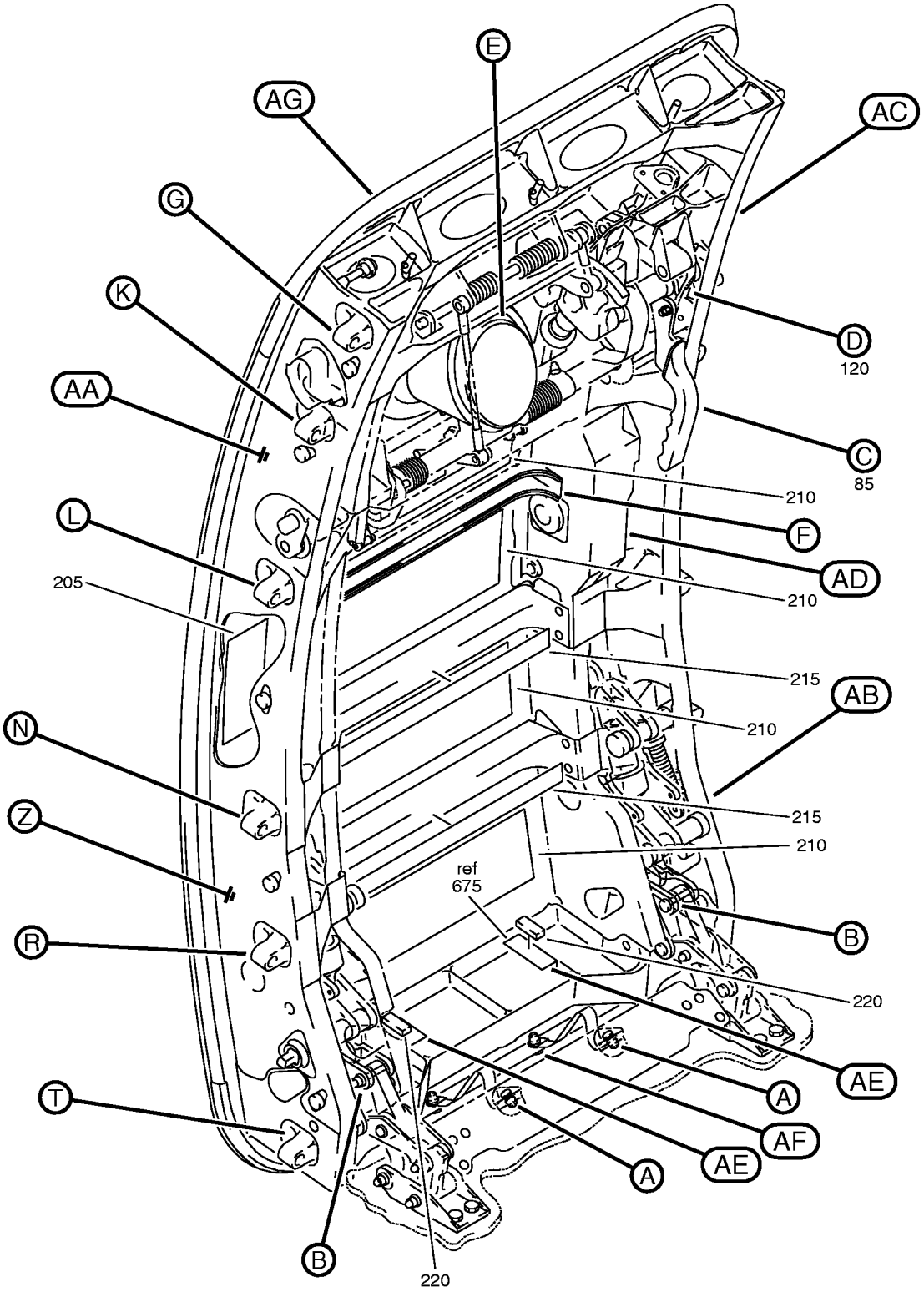
PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		3	3A	RF
M0DREF297445		1	920B	1
		3	1C	RF
M0DREF297446		1	925B	1
		3	3B	RF
M0DREF297447		1	910A	1
		2	1B	RF
M0DREF297448		1	915A	1
		2	5A	RF
M0DREF304975		1	225B	1
M0DREF304976		1	230B	1
MS24586C201		2	700A	1
MS24586C65		3	177	2
MS29513-010		2	485	2
		2	535	2
MS29513-020		1	615	1
MS35650-305T		1	785	1
MSSK4AS1		2	155	1
NAS1149C0332R		2	790	1
NAS1149C1616R		3	408	2
NAS1149C1632R		3	411	2
NAS1149D0316H		1	780	2
NAS1149D0463J		2	285	2
NAS1149D0516H		1	50	6
		1	545	6
NAS1149E0316P		1	165	6
NAS1149E0316R		1	135	2
NAS1149E0332P		1	170	9
		2	345	4
		2	370	8
		2	680	4
		2	710	2
NAS1149E0363P		2	455	2
NAS1149E0363R		3	501	1
NAS1149E0416P		2	377	2

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
NAS1149E0432P		2	755	1
NAS1149E0516P		2	50	AR
NAS1149E0532P		2	500	1
		2	550	1
NAS1149E0616P		2	505	2
		2	555	2
NAS1149E0616R		3	603	1
NAS1149E0632P		2	495	1
		2	545	1
		2	580	2
		2	605	2
NAS1149E0632R		3	606	1
NAS1149E0663R		3	609	1
NAS1149E0716P		1	35	AR
		4	150	16
NAS1149E0863R		3	66	2
NAS1149E0932P		2	760	5
NAS1149V0932M		2	185	1
NC04TG5C		4	260	1
		4	310	1
NES06FBGC		2	625	2
NES08FBGC		2	330	1
NS202101SE048		3	54	1
NS202476-02		1	385	2
		1	410	6
		1	485	2
PACMB540DDFS428		2	378	2
PACMKP04JAA3908		4	55	8
PACMKP04JAFS428		4	55	8
PACMKP05JAA3908		4	305	2
		4	385	2
PACMKP06JAA3908		2	640	2
PACMKP06JAFS428		2	640	2
PACMKP16BSFS428		1	715	1
		1	860	1

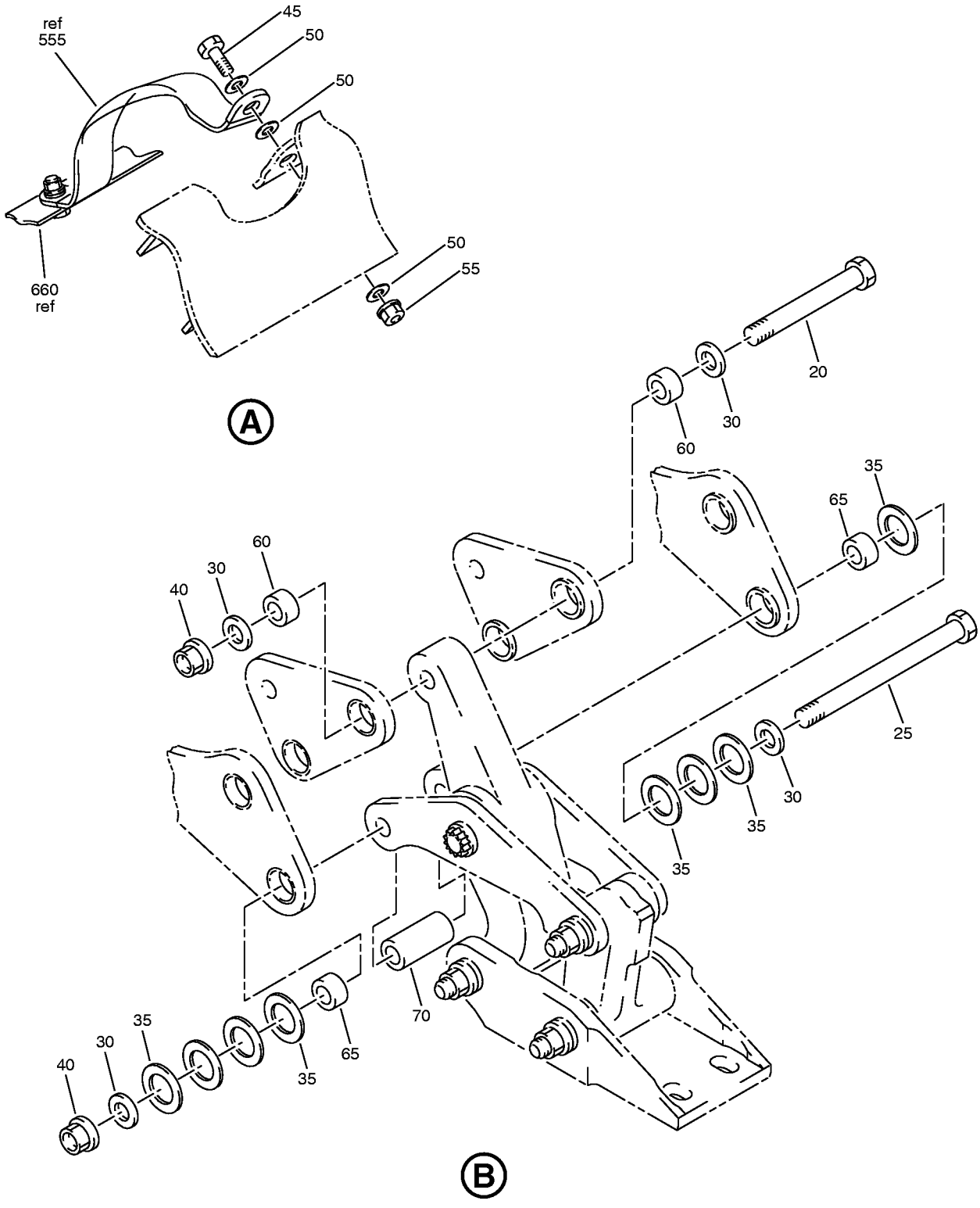
PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
PACMKP5AFS428		4	305	2
		4	385	2
PACMKP6AFS428		2	640	2
PLH53CD		2	350	1
		2	375	4
		2	470	2
		2	685	1
		2	720	1
		4	210	2
PLH53CM		3	504	1
PLH54CD		1	110	2
		2	30	2
		3	366	1
		3	450	1
		4	50	8
PLH54CM		2	170	1
		2	290	2
		3	405	5
		3	429	2
		3	477	1
		3	591	6
PLH55CD		1	40	4
		1	55	2
		1	550	2
S411T100-1010		1	695	5
		1	810	5
SL4113-3CDBAC		2	805	1
SLR4001-3A		2	800	1
SLR50-3A		2	800	1
SSMB540DDSD624		2	378	2
SSMKP04AP		4	55	8
SSMKP04JASD705		4	55	8
SSMKP05AP		4	305	2
		4	385	2
SSMKP05JAP		4	305	2

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		4	385	2
SSMKP05JASD705		4	305	2
		4	385	2
SSMKP06AP		2	640	2
SSMKP06JAP		2	640	2
SSMKP06JASD705		2	640	2
SSMKP4ASD524		4	55	8
SSMKP5ASD524		4	305	2
		4	385	2
SSMKP6ASD524		2	640	2
T6C428JM		3	54	1
T8092C1032CD		1	385	2
		1	410	6
		1	485	2
VL310AG5-4		1	585	4
		1	585	4
		1	585	4
		1	600	2
		1	600	2
		1	600	2
		1	835	1
		1	835	1
		1	835	1
VL310AG5-6		1	830	1
		1	830	1
		1	830	1
VN303D048		3	54	1
WC331K5-3		1	262	2
WC331K5-4		1	264	6
WC331K5-5		3	171	2
WC331K6-11		4	240	1
WC331K6-4		1	265	2
WC331K6-5		1	270	2
WC331K6-7		1	275	2
WC331K6-8		1	277	6

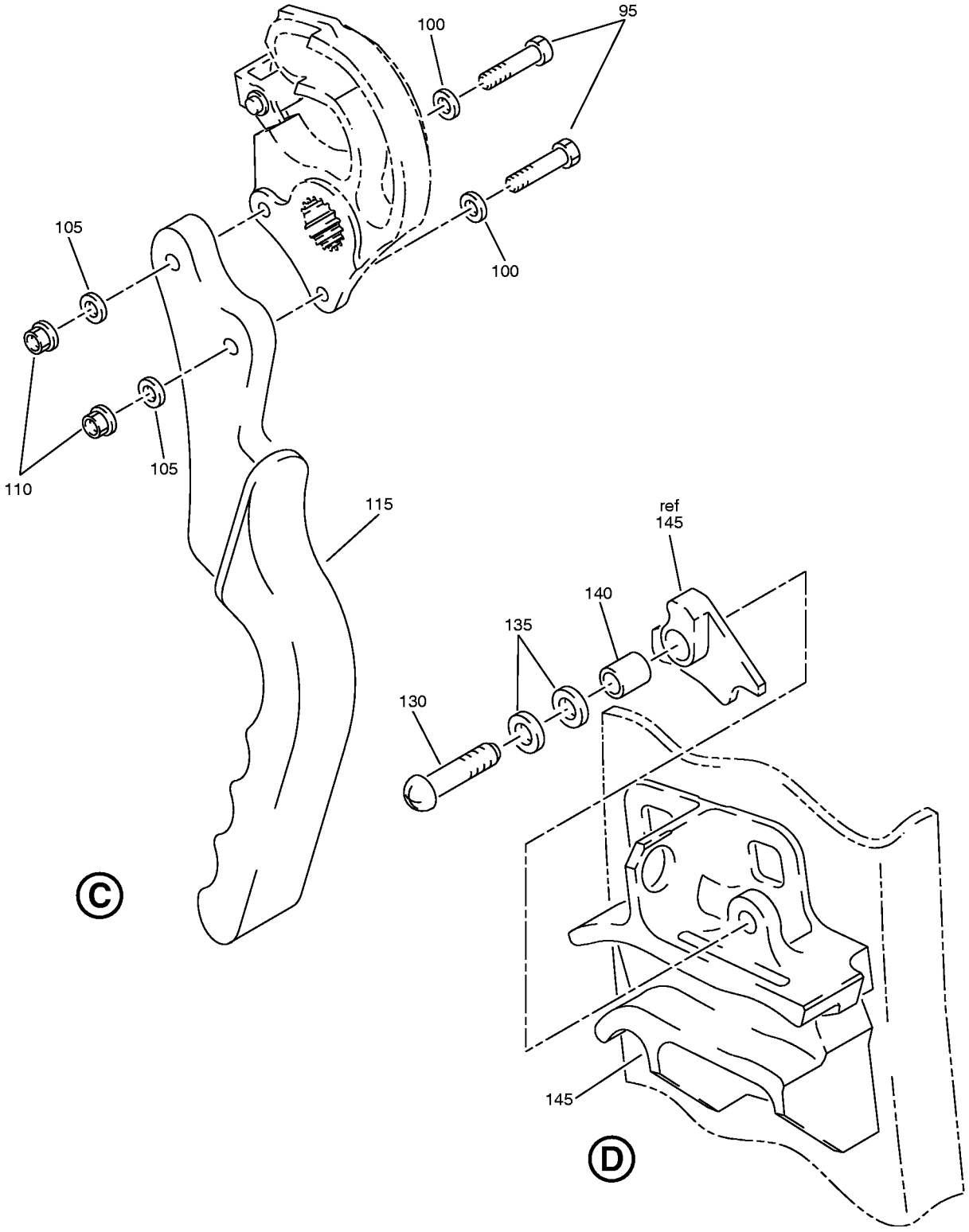
PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
WES04B10GC		3	123A	1
		3	318	2
WES05B10GC		2	810	1
WHT04VSBC		3	123A	1
		3	318	2
WHT05VSBC		2	810	1
WRRS04B10GC		3	123A	1
		3	318	2
WRRS05B10GC		2	810	1
WS1-332A10		1	355	1
WS14A12		1	345	3
		1	735	3
WSI4A16		1	740	1
		1	800	1



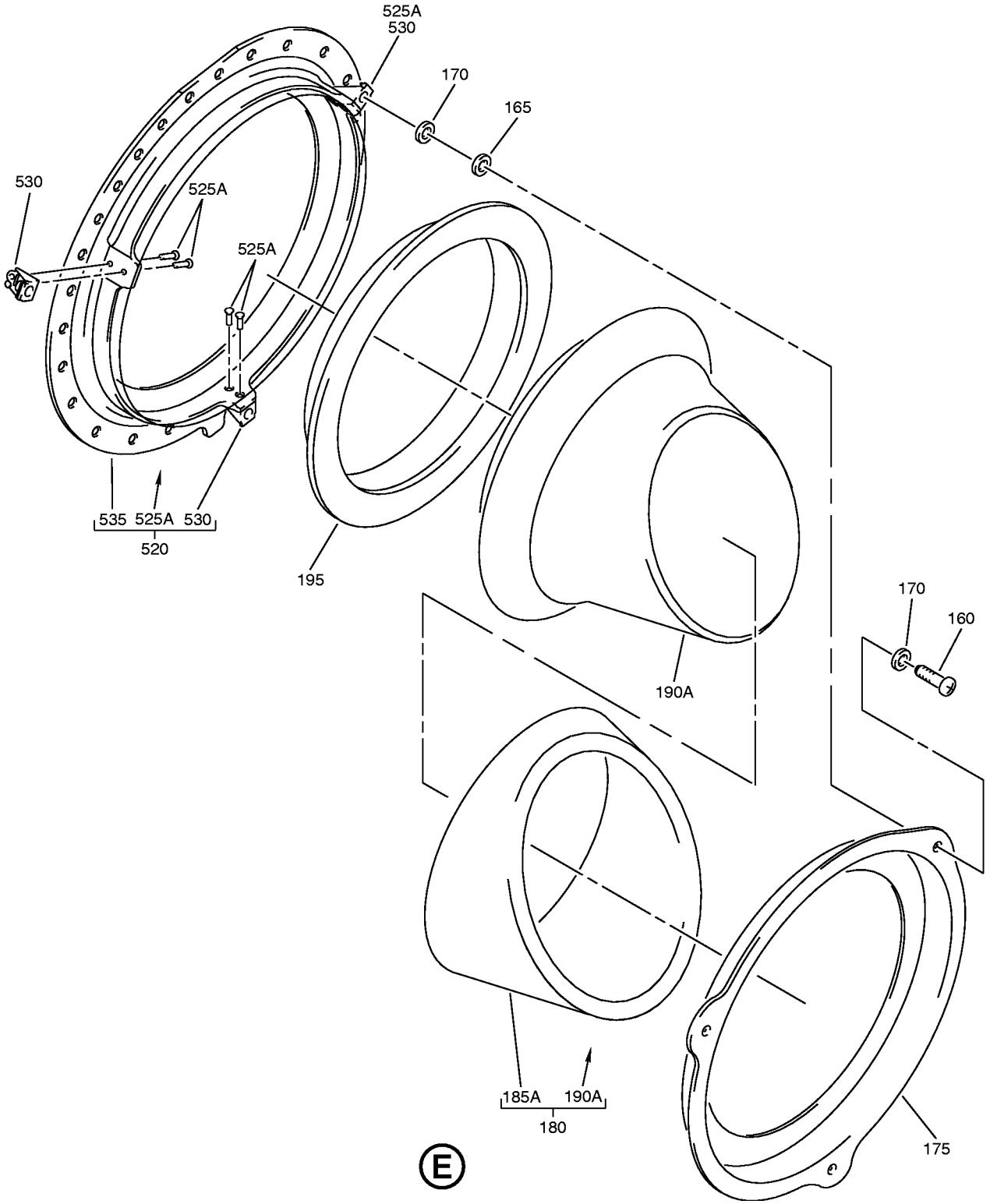
Emergency Exit Door Assembly
IPL Figure 1 (Sheet 1 of 21)



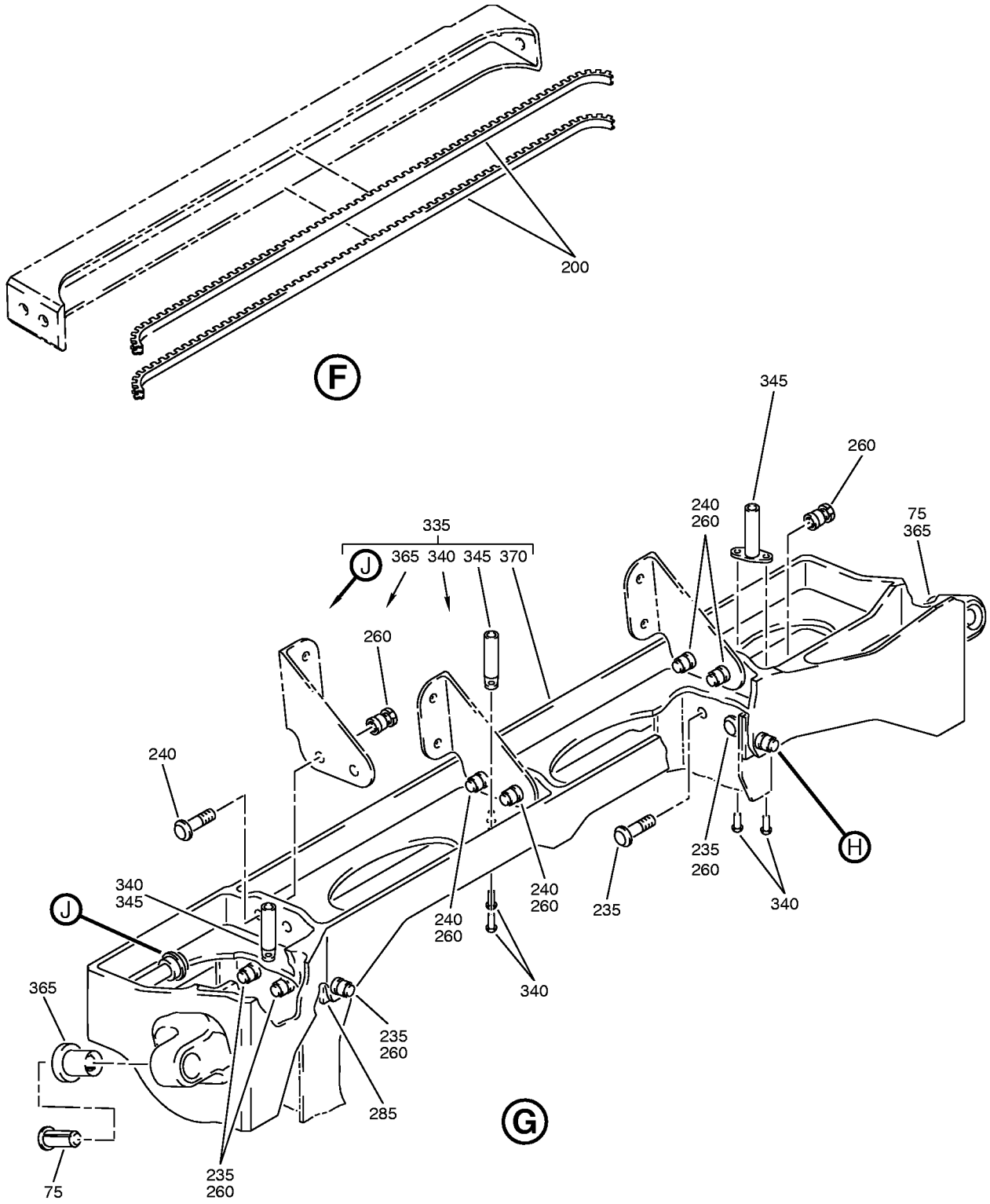
Emergency Exit Door Assembly
IPL Figure 1 (Sheet 2 of 21)



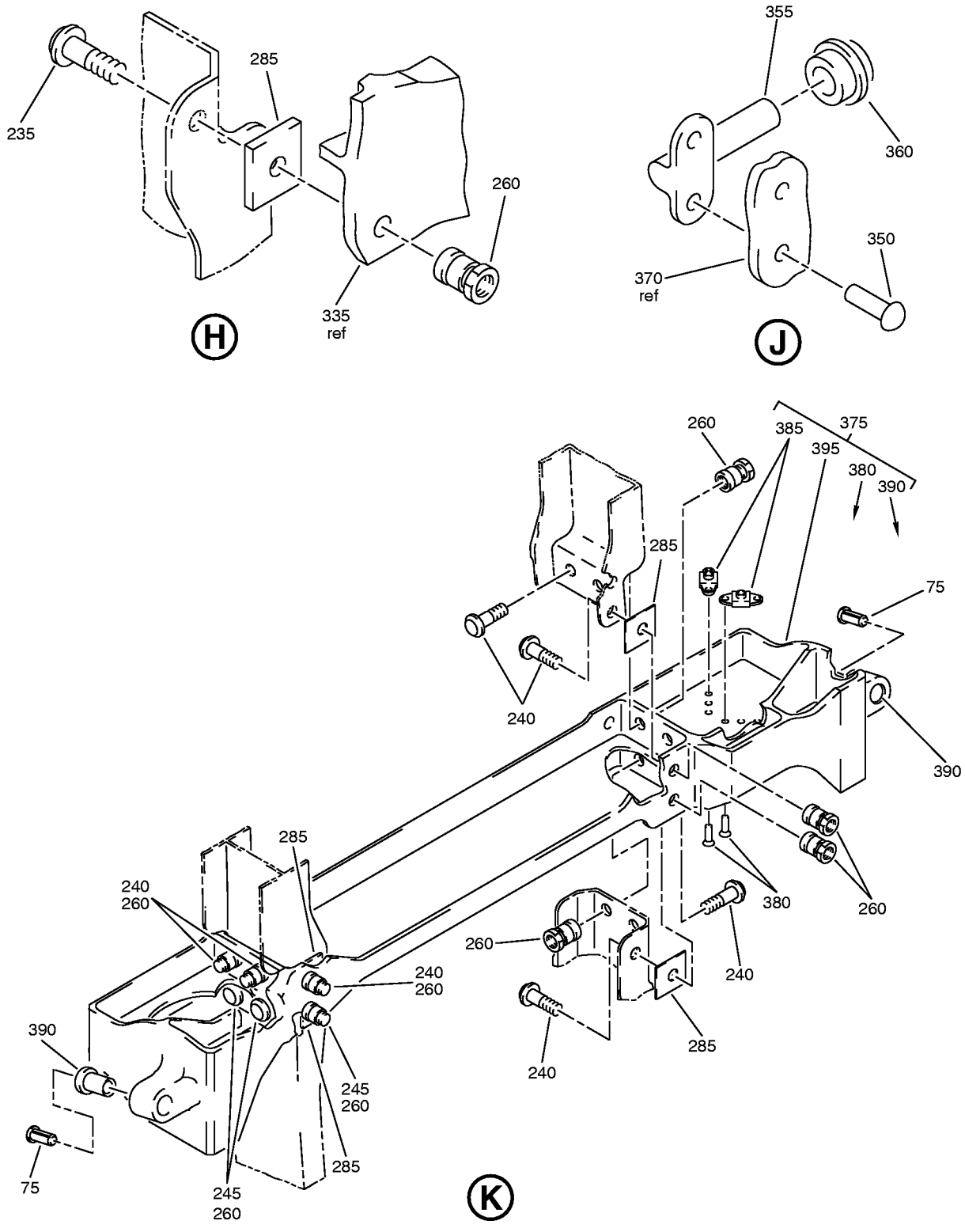
Emergency Exit Door Assembly
IPL Figure 1 (Sheet 3 of 21)



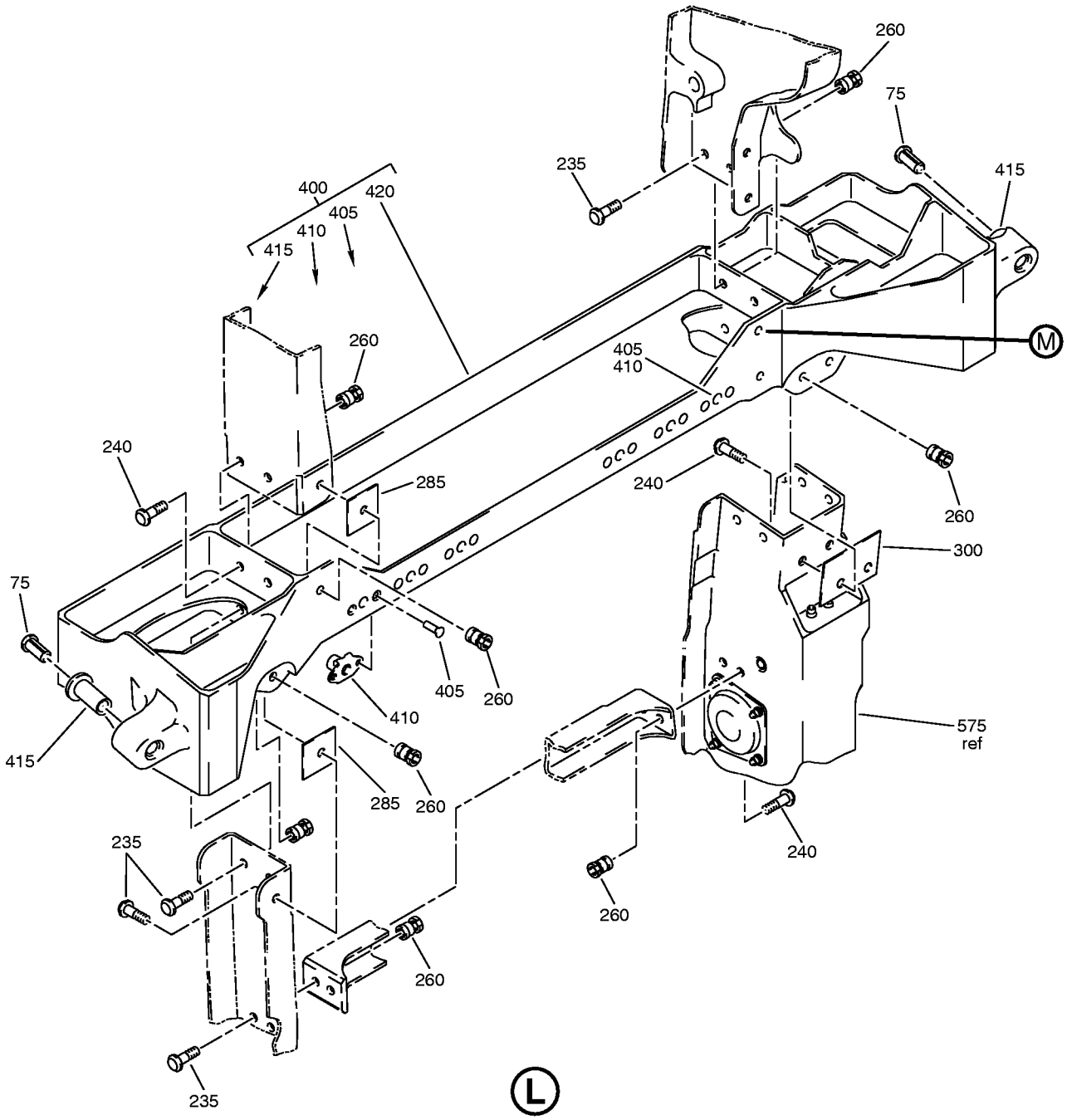
Emergency Exit Door Assembly
IPL Figure 1 (Sheet 4 of 21)



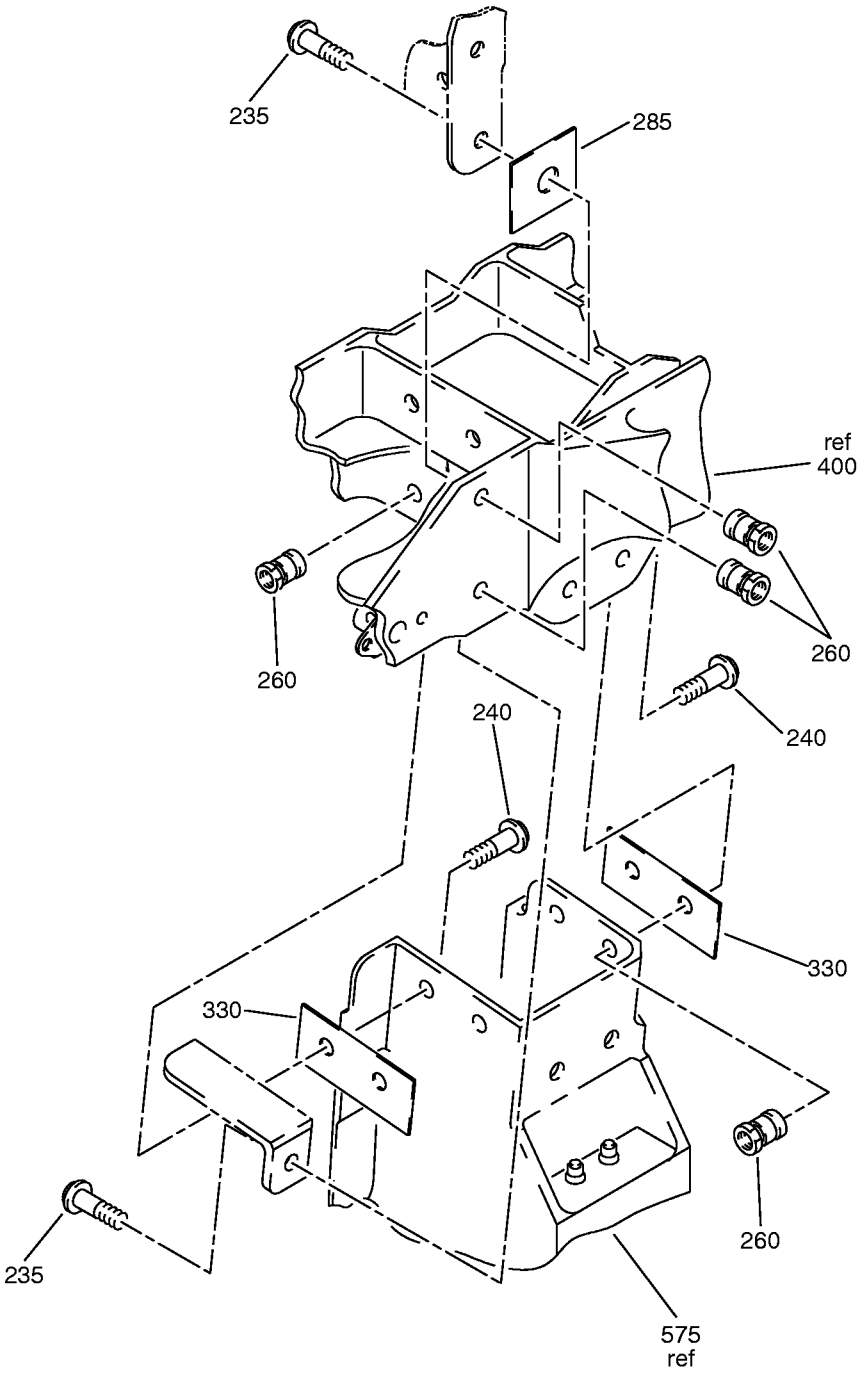
Emergency Exit Door Assembly
IPL Figure 1 (Sheet 5 of 21)



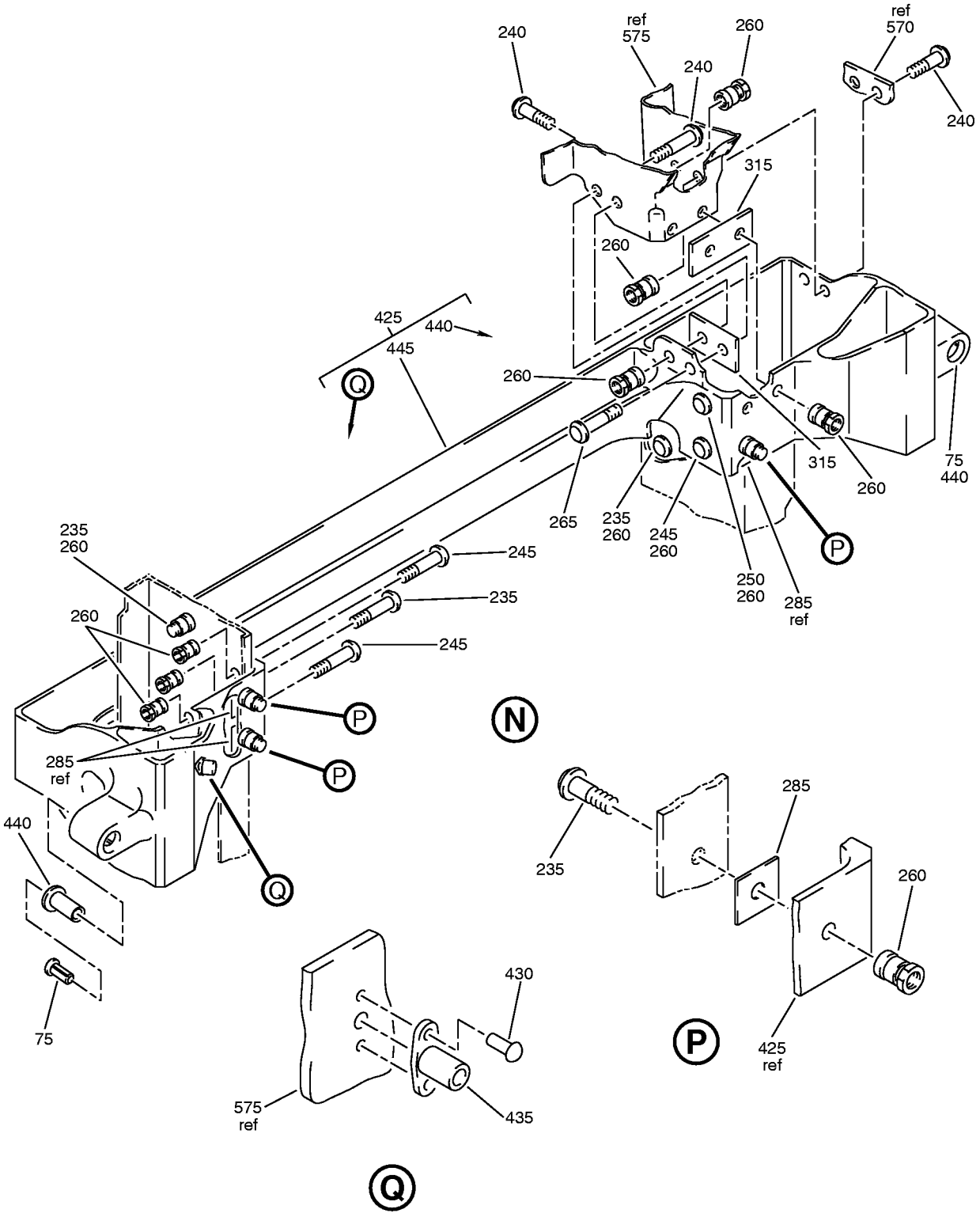
Emergency Exit Door Assembly
IPL Figure 1 (Sheet 6 of 21)



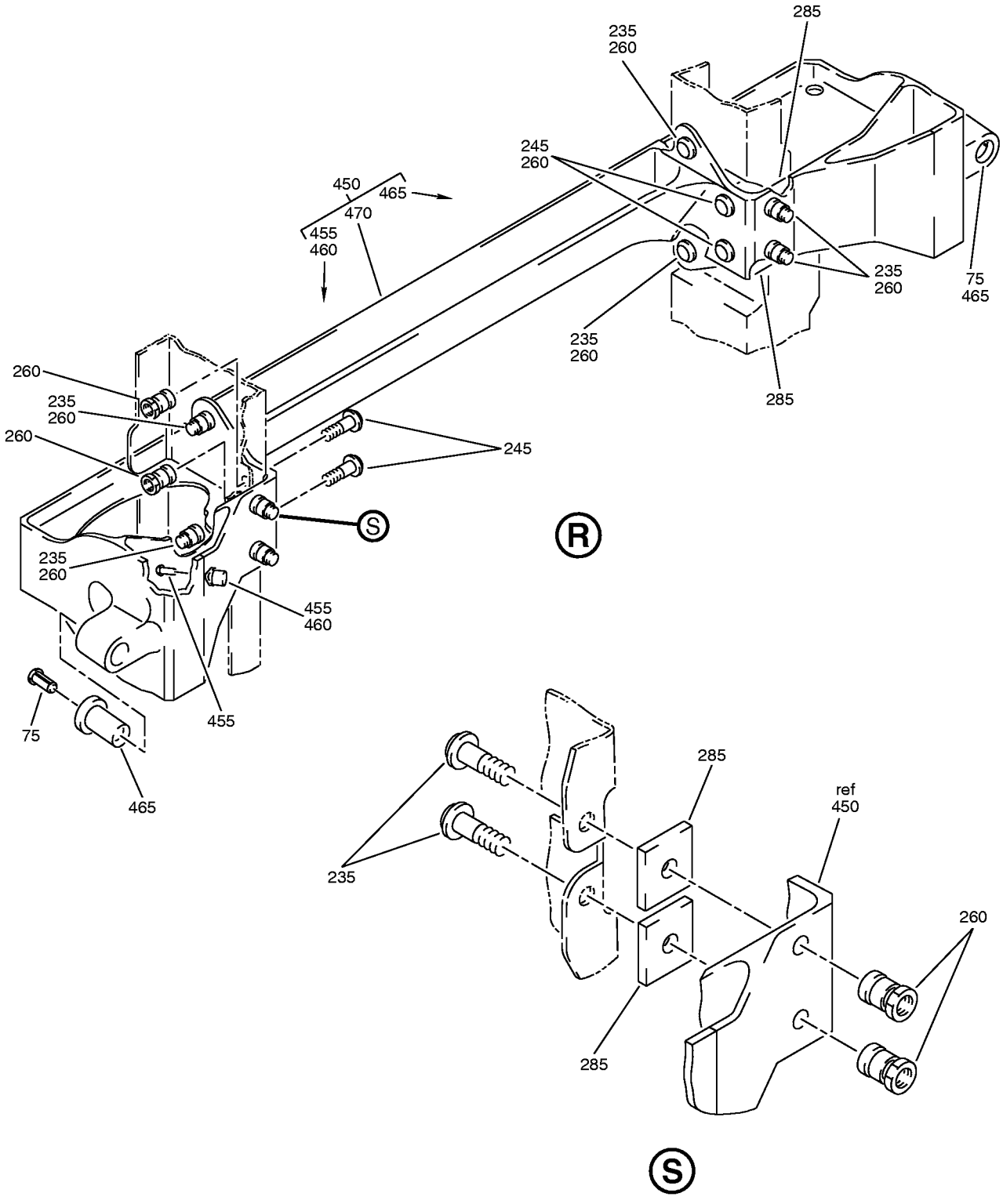
Emergency Exit Door Assembly
IPL Figure 1 (Sheet 7 of 21)



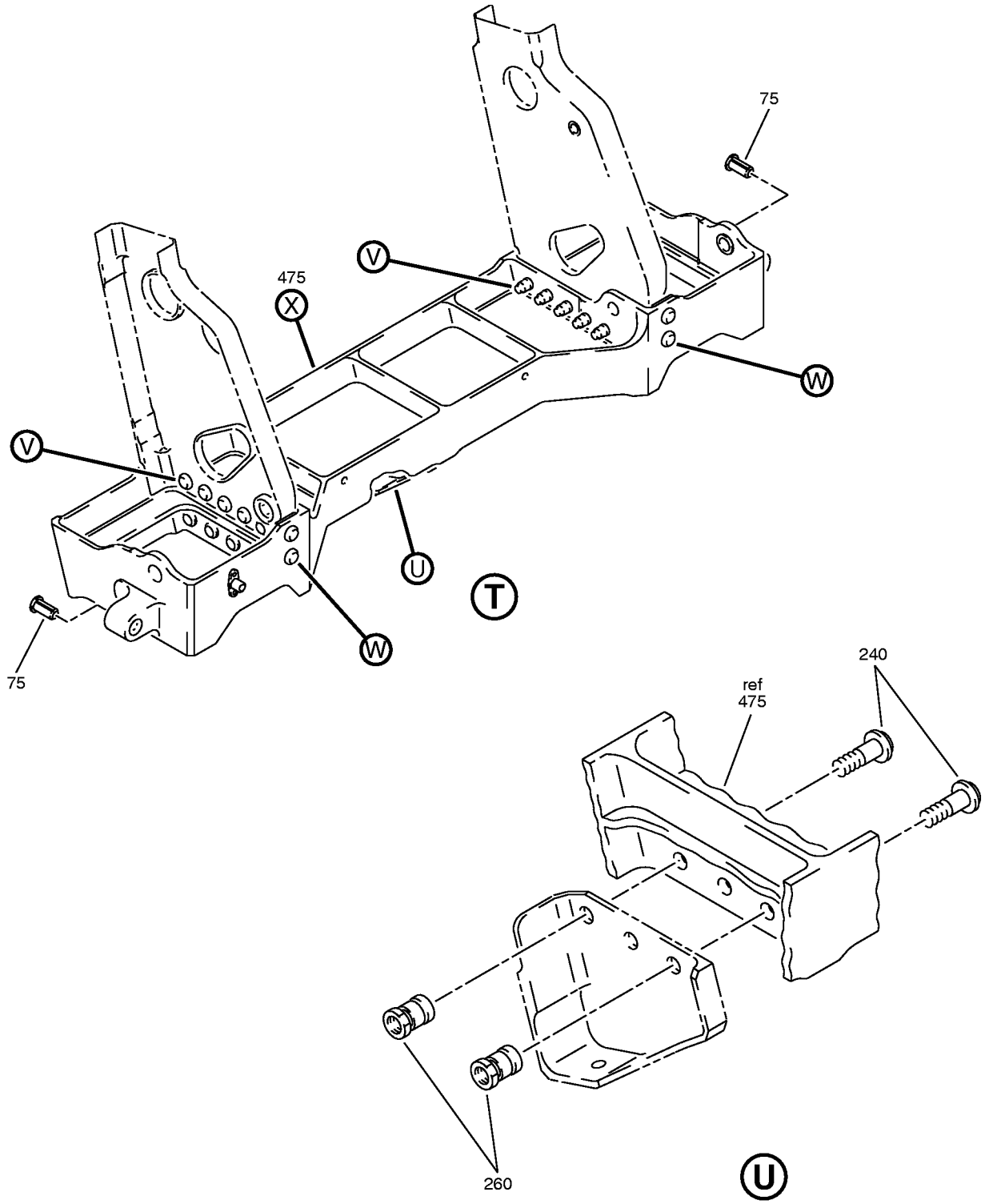
Emergency Exit Door Assembly
IPL Figure 1 (Sheet 8 of 21)



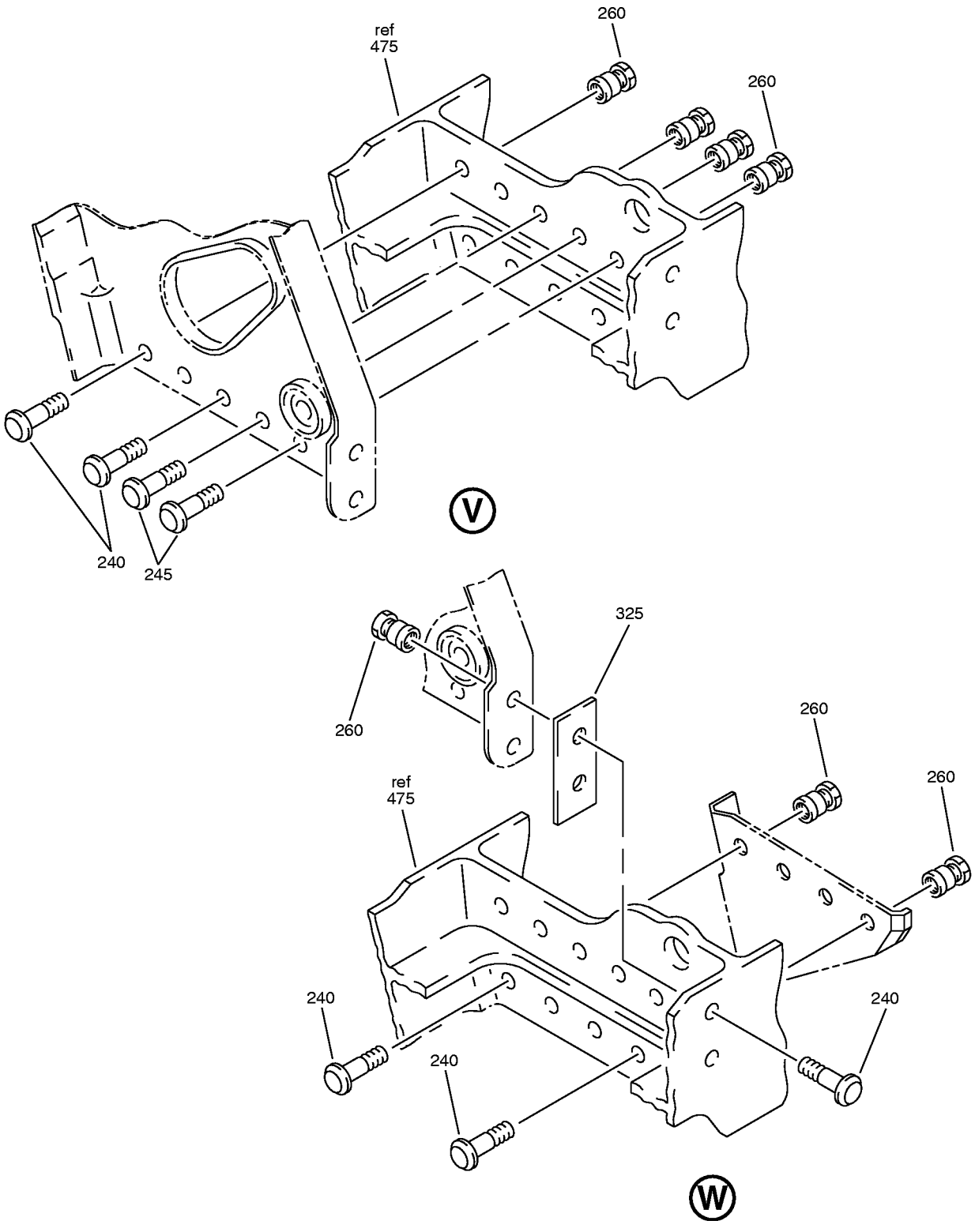
Emergency Exit Door Assembly
IPL Figure 1 (Sheet 9 of 21)



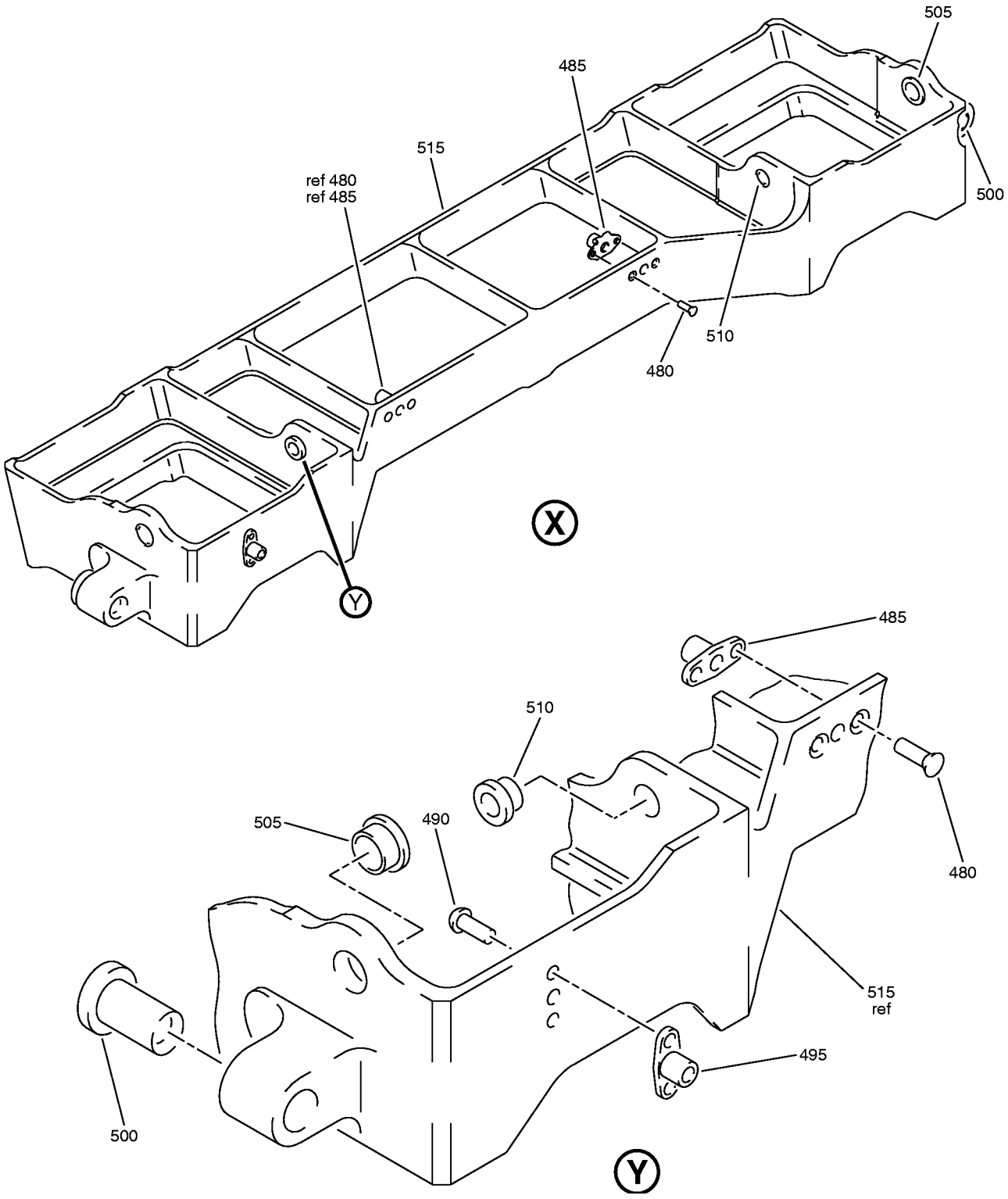
Emergency Exit Door Assembly
IPL Figure 1 (Sheet 10 of 21)



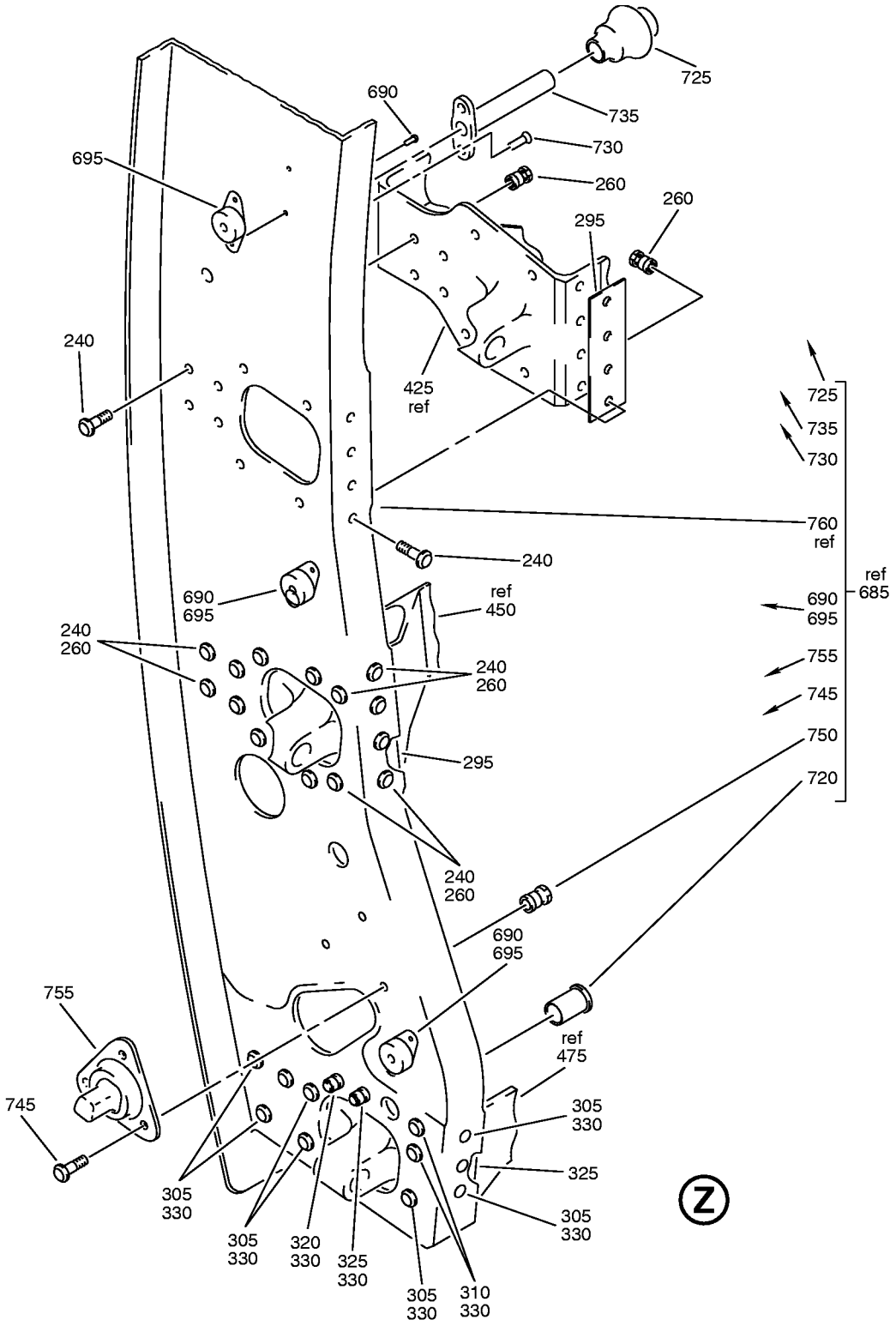
Emergency Exit Door Assembly
IPL Figure 1 (Sheet 11 of 21)



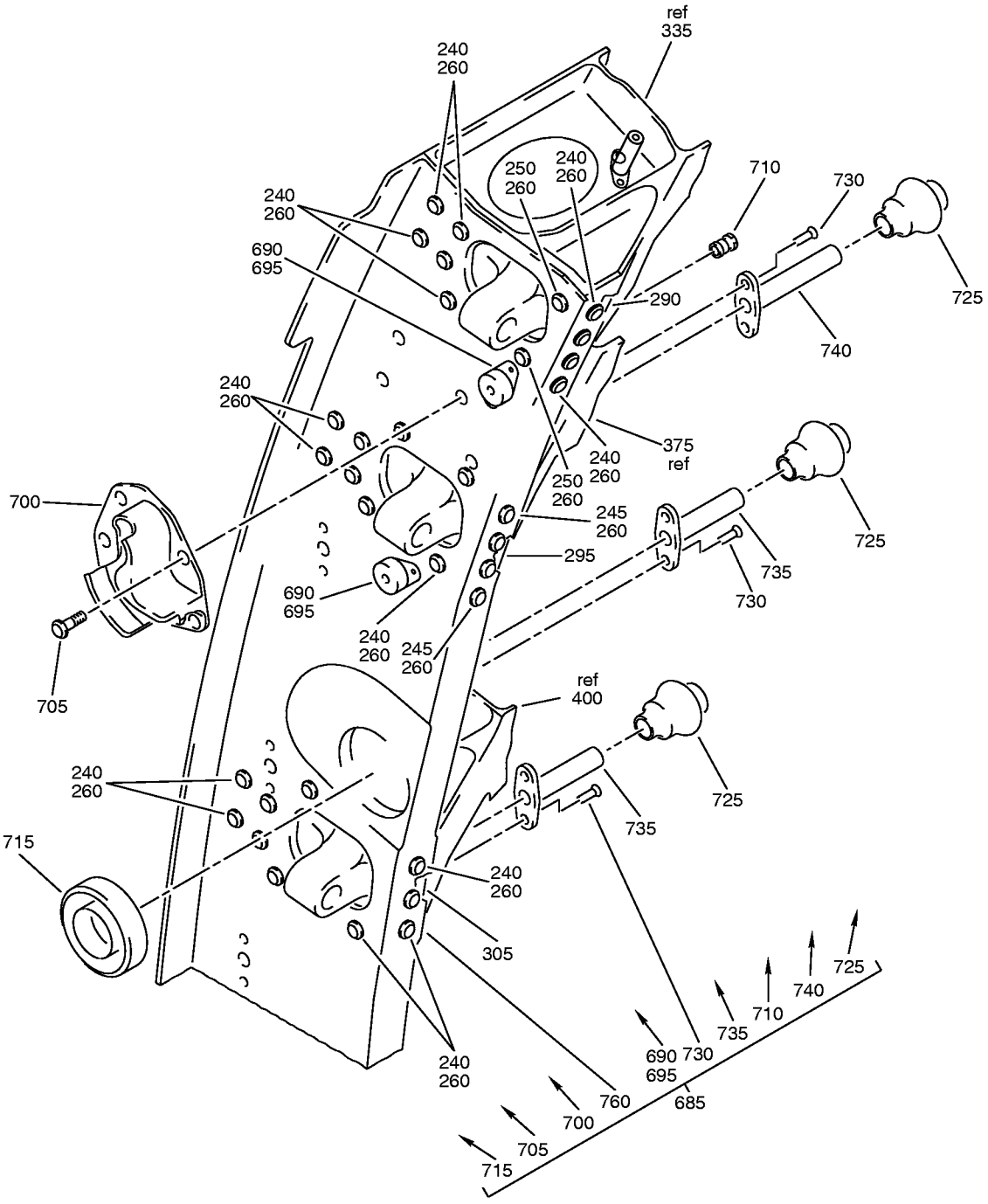
Emergency Exit Door Assembly
IPL Figure 1 (Sheet 12 of 21)



Emergency Exit Door Assembly
IPL Figure 1 (Sheet 13 of 21)

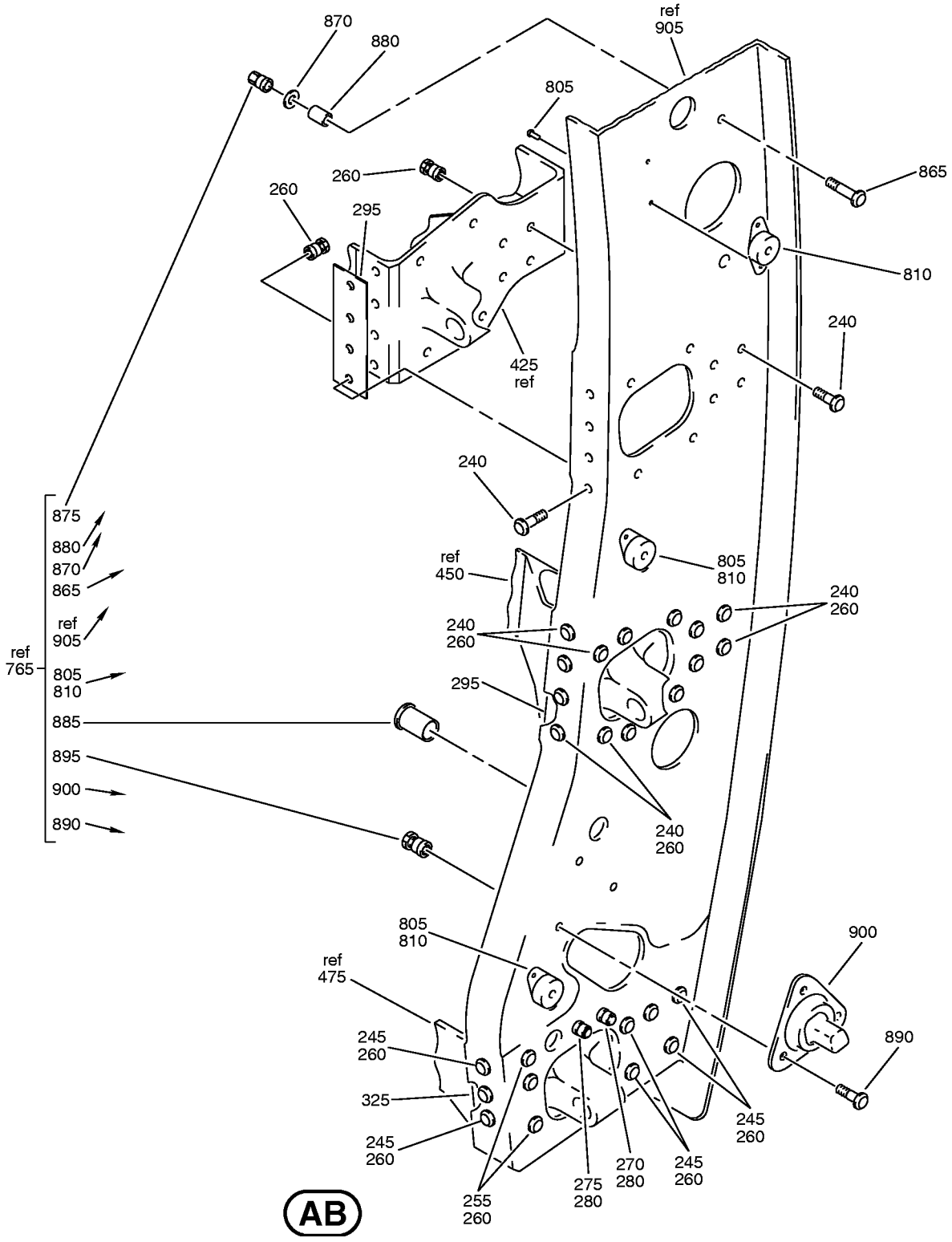


Emergency Exit Door Assembly
IPL Figure 1 (Sheet 14 of 21)

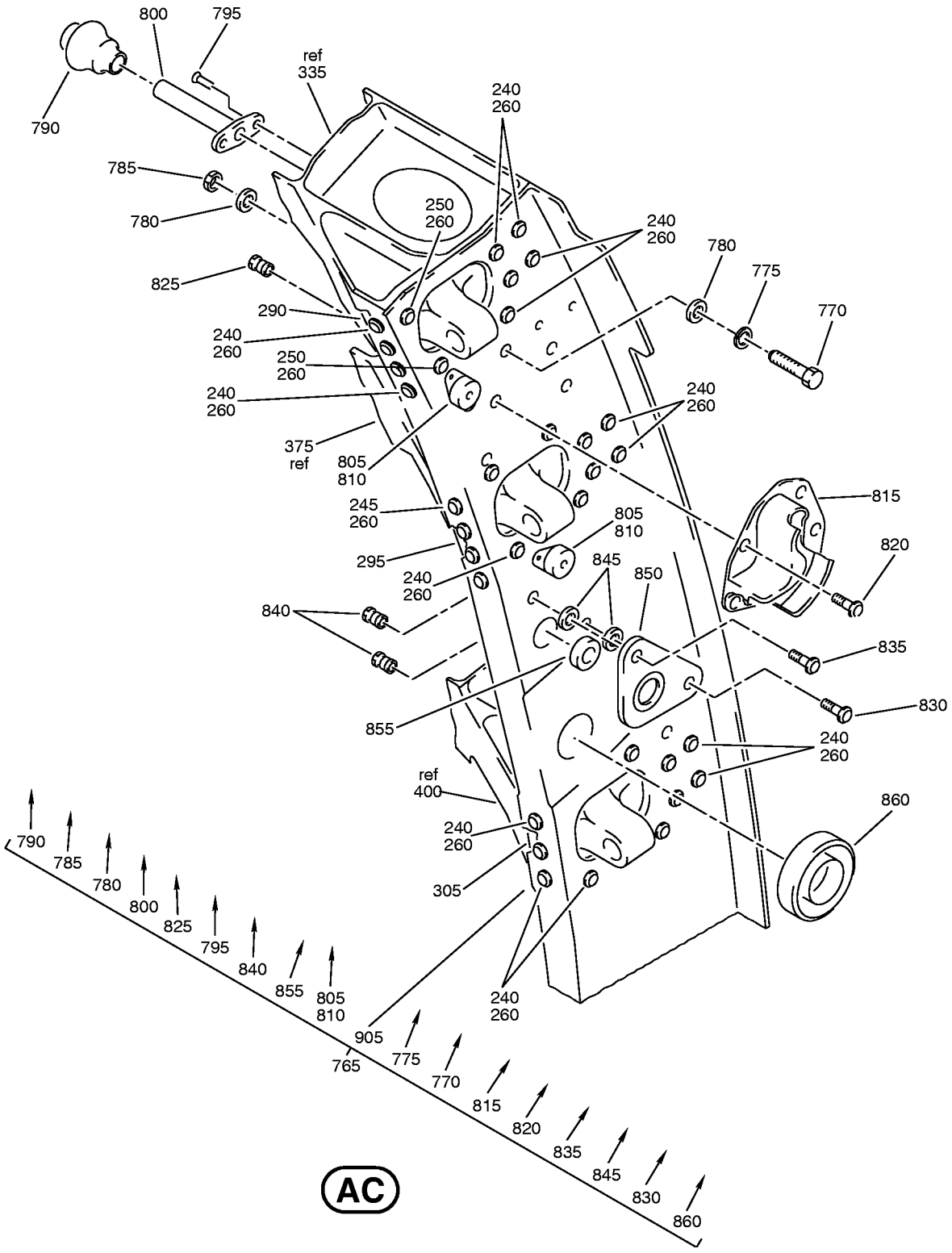


AA

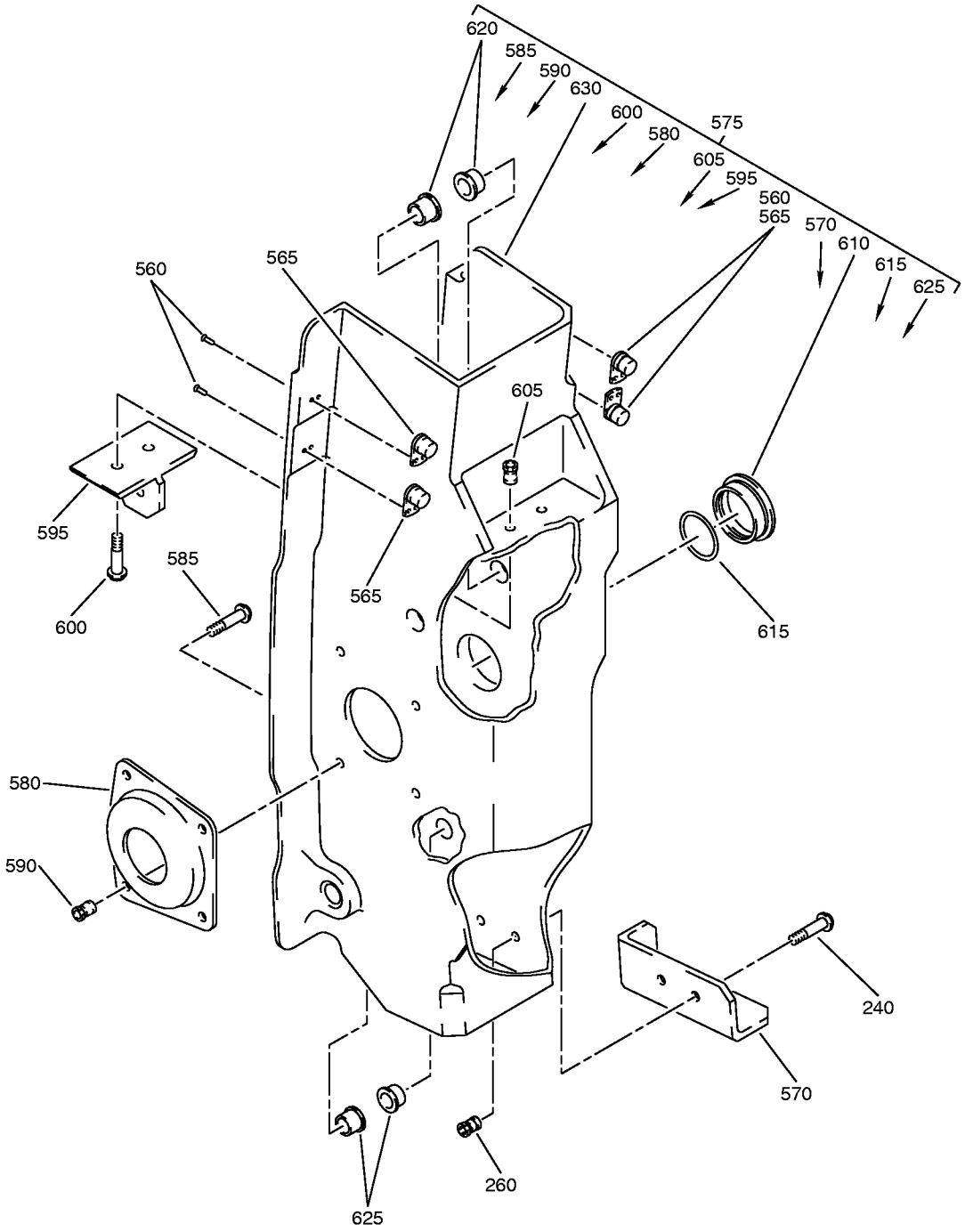
Emergency Exit Door Assembly
IPL Figure 1 (Sheet 15 of 21)



Emergency Exit Door Assembly
IPL Figure 1 (Sheet 16 of 21)

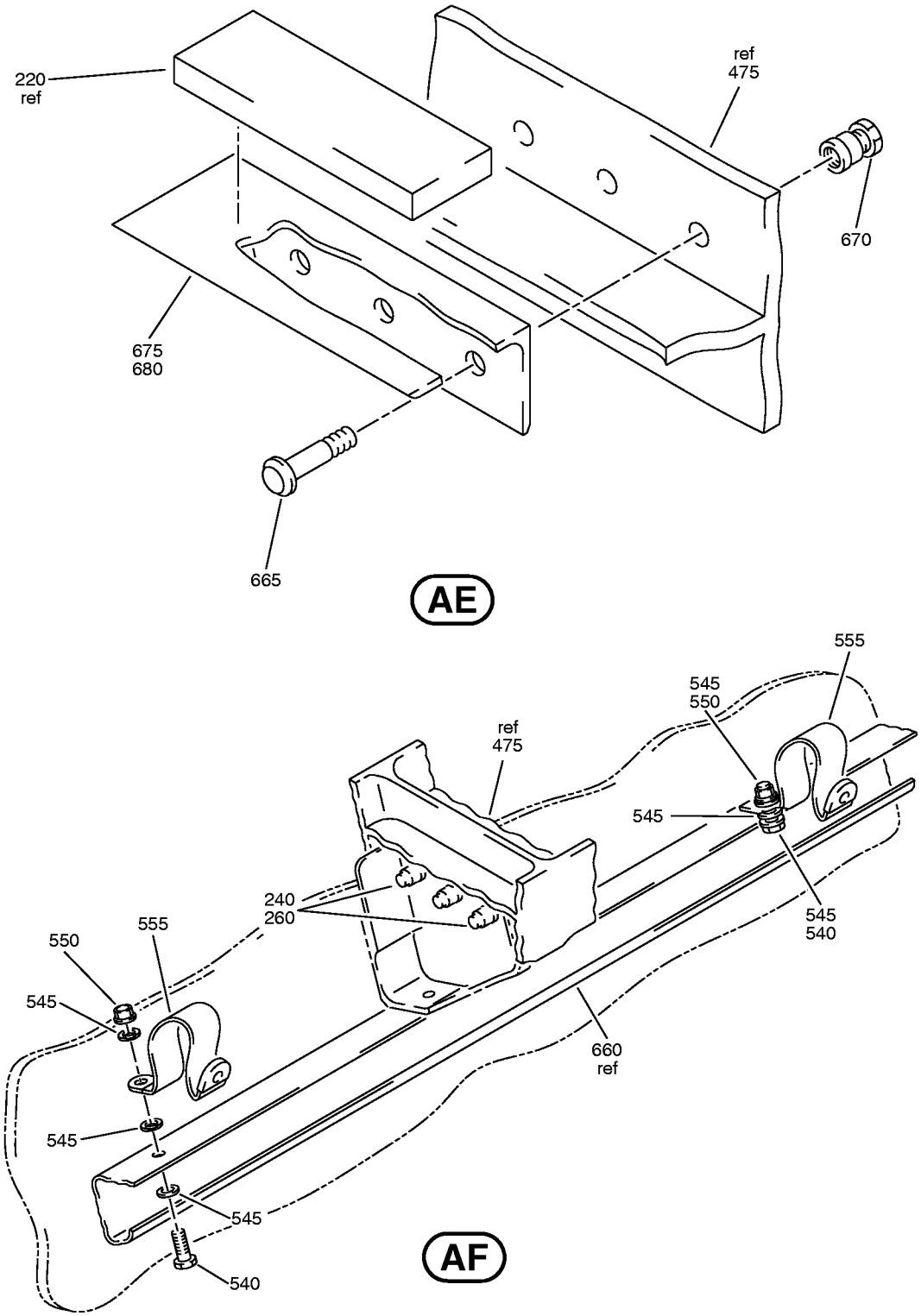


Emergency Exit Door Assembly
IPL Figure 1 (Sheet 17 of 21)

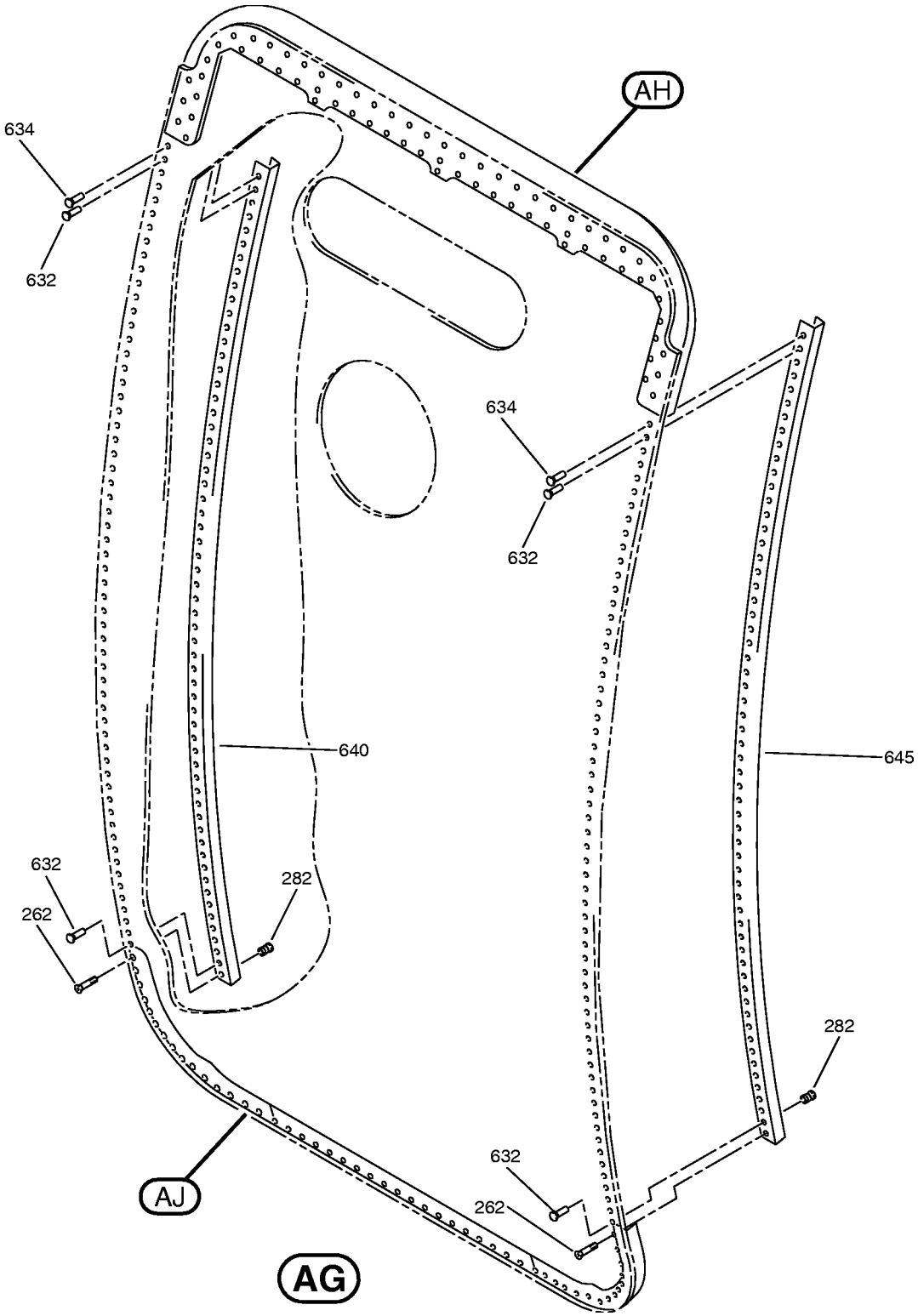


AD

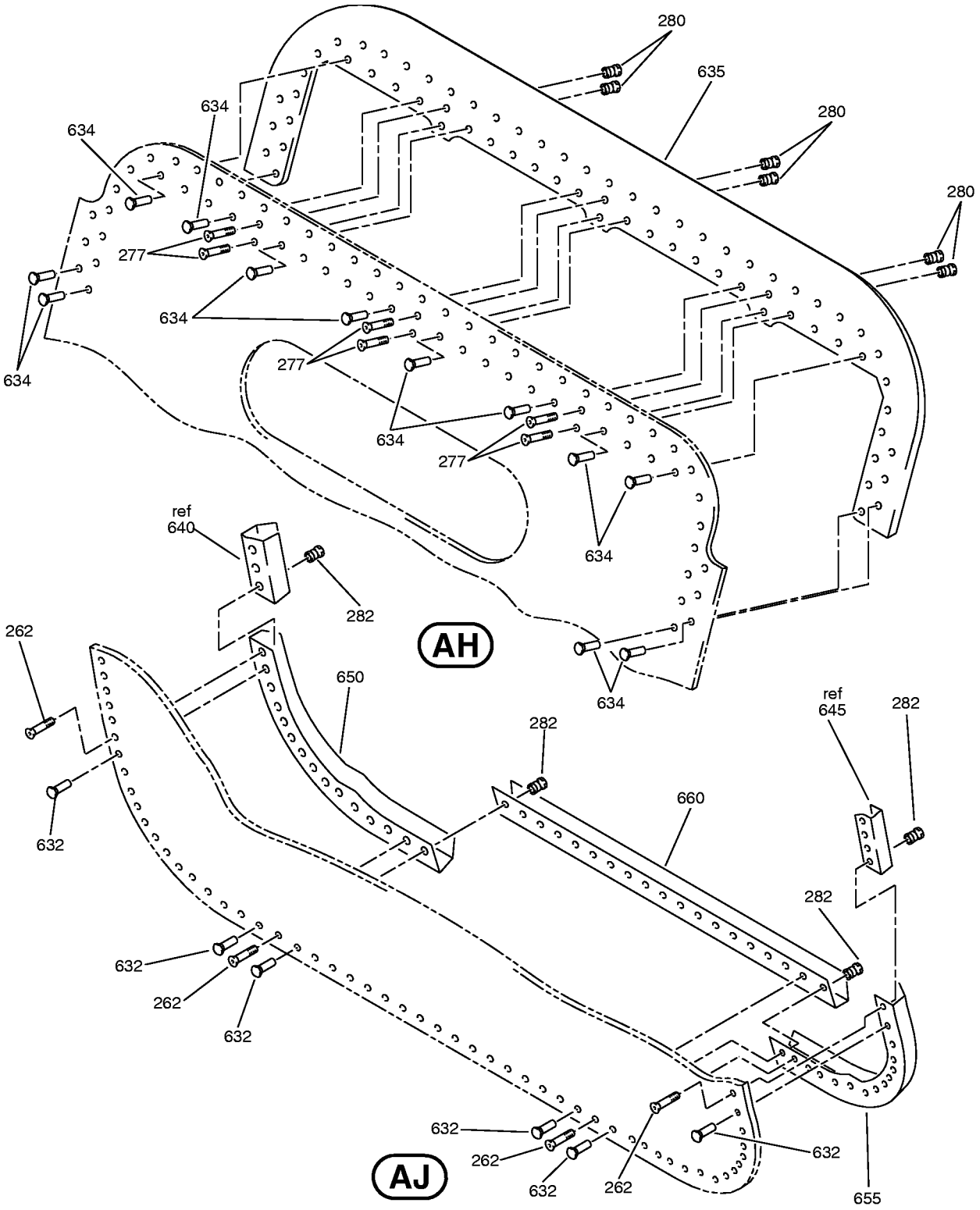
Emergency Exit Door Assembly
IPL Figure 1 (Sheet 18 of 21)



Emergency Exit Door Assembly
IPL Figure 1 (Sheet 19 of 21)



Emergency Exit Door Assembly
IPL Figure 1 (Sheet 20 of 21)



Emergency Exit Door Assembly
IPL Figure 1 (Sheet 21 of 21)

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
–1A	146A6200-1		DOOR ASSY-EMERGENCY EXIT	A	RF
–5	146A6200-2		DOOR ASSY-EMERGENCY EXIT	B	RF
–10	M0DREF285799		. DOOR INSTL-MID EXIT (LIMITED USAGE) (146A6210-1REVA)	A	1
–10A	M0DREF291630		. DOOR INSTL-MID EXIT (LIMITED USAGE) (146A6210-1REVB)	A	1
–10B	M0DREF294875		. DOOR INSTL-MID EXIT (LIMITED USAGE) (146A6210-1REVC)	A	1
–15	M0DREF285800		. DOOR INSTL-MID EXIT (LIMITED USAGE) (146A6210-2REVA)	B	1
–15A	M0DREF291631		. DOOR INSTL-MID EXIT (LIMITED USAGE) (146A6210-2REVB)	B	1
–15B	M0DREF294876		. DOOR INSTL-MID EXIT (LIMITED USAGE) (146A6210-2REVC)	B	1
20	BACB30NR5K27		. . BOLT		2
25	BACB30NR5K43		. . BOLT		2
30	BACW10BP5CD		. . WASHER		8
35	NAS1149E0716P		. . WASHER		AR
40	PLH55CD		. . NUT (V62554) (SPEC BACN10YR5CD) (OPT H52732-5CD (V15653))		4
45	BACS12HN5-12		. . SCREW (USED ON ITEMS 10A, 10B, 15A, 15B)		2
50	NAS1149D0516H		. . WASHER (USED ON ITEMS 10A, 10B, 15A, 15B)		6
55	PLH55CD		. . NUT (V62554) (SPEC BACN10YR5CD) (OPT H52732-5CD (V15653))		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–					
60	BACB28AK05-42		. . BUSHING		4
65	BACB28AK05-051		. . BUSHING		4
70	BACB28AK05-120		. . BUSHING		2
75	KPD4434		. . PIN-SELF ALIGNING (V50632)		12
–80	740C14-6		. . JUMPER-BONDING (V91812) (SPEC BACJ40CG6G) (USED ON ITEMS 10A, 15A)		2
85	M0DREF284105		. ACTIVATION MODULE-L SIDE (146A6250-1REVA)	A	1
–90	M0DREF284106		. ACTIVATION MODULE-R SIDE (146A6250-2REVA)	B	1
95	BACB30NR4K14		. . BOLT		2
100	BACW10BP4ACU		. . WASHER		2
105	BACW10BP4DP		. . WASHER		2
110	PLH54CD		. . NUT (V62554) (SPEC BACN10YR4CD) (OPT H52732-4CD (V15653))		2
115	146A6251-1		. . HANDLE-INSIDE		1
120	M0DREF284107		. ACTIVATION MODULE-L SIDE (146A6250-3REVA)	A	1
–125	M0DREF284108		. ACTIVATION MODULE-R SIDE (146A6250-4REVA)	B	1
130	BACB30NT3K6		. . BOLT		1
135	NAS1149E0316R		. . WASHER		2
140	BACB28Y3M035		. . BUSHING		1
145	146A6249-1		. . ACTUATOR-SWITCH		1
–150	M0DREF284219		. STRUCTURE INSTL-POST DRIVEMATIC, L SIDE (146A6400-5REVA)	A	1
–155	M0DREF284220		. STRUCTURE INSTL-POST DRIVEMATIC, R SIDE (146A6400-6REVA)	B	1
160	BACB30NT3K3		. . BOLT		3

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
165	NAS1149E0316P		. . WASHER		6
170	NAS1149E0332P		. . WASHER		9
175	146A6456-1		. . RETAINER-VIEWPORT SEAL		1
180	140N2035-1		. . PRISM ASSY		1
185A	140N2036-1		. . . SLEEVE-INSULATION		1
190A	140N2764-1		. . . PRISM		1
195	140N2612-3		. . SEAL-VIEWPORT		1
200	BACG20ZB001510		. . GROMMET		2
205	K0540-075		. . DAMPER-STAND-OFF		1
210	K0540-125		. . DAMPER-STAND-OFF		4
215	146A6454-1		. . STRIP-RUB, ESCAPE SLIDE		2
220	146A6454-3		. . STRIP-RUB, ESCAPE SLIDE		2
–225	M0DREF284217		. STRUCTURE INSTL (LIMITED USAGE) (146A6400-3REVA)	A	1
–225A	M0DREF292663		. STRUCTURE INSTL (LIMITED USAGE) (146A6400-3REVB)	A	1
–225B	M0DREF304975		. STRUCTURE INSTL (LIMITED USAGE) (146A6400-3REVC)	A	1
–230	M0DREF284218		. STRUCTURE INSTL (LIMITED USAGE) (146A6400-4REVA)	B	1
–230A	M0DREF292664		. STRUCTURE INSTL (LIMITED USAGE) (146A6400-4REVB)	B	1
–230B	M0DREF304976		. STRUCTURE INSTL (LIMITED USAGE) (146A6400-4REVC)	B	1
235	HST10AG6-3		. . BOLT (V0PTK6) (SPEC BACB30VT6K3) (OPT HST10AG6-3 (V06725)) (OPT HST10AG6-3 (V56878)) (OPT HST10AG6-3 (V73197))		29

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
240	HST10AG6-4		. . BOLT (V06725) (SPEC BACB30VT6K4) (OPT HST10AG6-4 (V73197)) (OPT HST10AG6-4 (V56878)) (OPT HST10AG6-4 (V0PTK6))		162
245	HST10AG6-5		. . BOLT (V0PTK6) (SPEC BACB30VT6K5) (OPT HST10AG6-5 (V06725)) (OPT HST10AG6-5 (V56878)) (OPT HST10AG6-5 (V73197))		40
250	HST10AG6-6		. . BOLT (V0PTK6) (SPEC BACB30VT6K6) (OPT HST10AG6-6 (V06725)) (OPT HST10AG6-6 (V56878)) (OPT HST10AG6-6 (V73197))		4
255	HST10AG6-7		. . BOLT (V0PTK6) (SPEC BACB30VT6K7) (OPT HST10AG6-7 (V06725)) (OPT HST10AG6-7 (V56878)) (OPT HST10AG6-7 (V73197))		5
260	HST79CY6		. . COLLAR (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V92215)) (OPT HST79CY6 (V56878)) (OPT HST79CY6 (V5M902))		240
262	WC331K5-3		. . BOLT (V60516) (SPEC BACB30YP5K3)		2
264	WC331K5-4		. . BOLT (V60516) (SPEC BACB30YP5K4)		6
265	WC331K6-4		. . BOLT (V60516) (SPEC BACB30YP6K4)		2
270	WC331K6-5		. . BOLT (V60516) (SPEC BACB30YP6K5)		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–					
275	WC331K6-7		. . BOLT (V60516) (SPEC BACB30YP6K7)		2
277	WC331K6-8		. . BOLT (V60516) (SPEC BACB30YP6K8)		6
280	HST79CY6		. . COLLAR (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V92215)) (OPT HST79CY6 (V56878)) (OPT HST79CY6 (V5M902))		12
282	HST79CY5		. . COLLAR (V73197) (SPEC BACC30BL5) (OPT HST79-5 (V92215)) (OPT HST79CY5 (V56878)) (OPT HST79CY5 (V5M902))		4
285	BACS40R009A009F		. . SHIM		16
290	BACS40R009A033F		. . SHIM		2
295	BACS40R009A034F		. . SHIM		6
300	BACS40R015A022F		. . SHIM		1
305	BACS40R009A029F		. . SHIM		2
310	BACS40R010A016F		. . SHIM		1
315	BACS40R009A017F		. . SHIM		1
320	BACS40R008A017F		. . SHIM		3
325	BACS40R009A028F		. . SHIM		2
330	BACS40R012A022F		. . SHIM		1
335	146A6421-1		. . BEAM ASSY-#1		1
340	BACR15BB3ADC		. . . RIVET (SIZE DETERMINED ON INST)		6
345	WS14A12		. . . NUTPLATE (V04169) (SPEC BACN10TL3A12)		3
350	BACR15BB4ADC		. . . RIVET (SIZE DETERMINED ON INST)		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–					
355	WS1-332A10		. . . NUTPLATE (V04169) (SPEC BACN10GH3A10)		1
360	BACS31H1B		. . . RINGPOST		1
365	140N2623-7		. . . BUSHING-STOP		2
370	146A6421-101		. . . BEAM-STOP		1
375	146A6422-1		. . BEAM ASSY-#2		1
380	BACR15BA3ADC		. . . RIVET (SIZE DETERMINED ON INST)		4
385	BRF200C3D		. . . NUTPLATE (V52828) (SPEC BACN10JR3CFD) (OPT K51602-3BAC (V15653)) (OPT NS202476-02 (V80539)) (OPT 102F9201-3 (V72962)) (OPT T8092C1032CD (V11815))		2
390	140N2623-7		. . . BUSHING-STOP		2
395	146A6422-101		. . . BEAM		1
400	146A6423-1		. . BEAM ASSY-#3		1
405	BACR15BA3ADC		. . . RIVET (SIZE DETERMINED ON INST)		12
410	BRF200C3D		. . . NUTPLATE (V52828) (SPEC BACN10JR3CFD) (OPT K51602-3BAC (V15653)) (OPT NS202476-02 (V80539)) (OPT 102F9201-3 (V72962)) (OPT T8092C1032CD (V11815))		6
415	140N2623-7		. . . BUSHING-STOP		2
420	146A6423-101		. . . BEAM		1
425	146A6424-1		. . BEAM ASSY-#4		1
430	BACR15BB4ADC		. . . RIVET (SIZE DETERMINED ON INST)		2
435	BACN10TL3A3		. . . NUTPLATE-SPACER		1
440	140N2623-7		. . . BUSHING-STOP		2
445	146A6424-101		. . . BEAM		1
450	146A6425-1		. . BEAM ASSY-#5		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–					
455	BACR15BB4ADC		. . . RIVET (SIZE DETERMINED ON INST)		2
460	BACN10TL3A3		. . . NUTPLATE		1
465	140N2623-7		. . . BUSHING-STOP		2
470	146A6425-101		. . . BEAM		1
475	146A6426-1		. . BEAM ASSY-#6		1
480	BACR15BA3ADC		. . . RIVET (SIZE DETERMINED ON INST)		4
485	BRF200C3D		. . . NUTPLATE (V52828) (SPEC BACN10JR3CFD) (OPT K51602-3BAC (V15653)) (OPT NS202476-02 (V80539)) (OPT 102F9201-3 (V72962)) (OPT T8092C1032CD (V11815))		2
490	BACR15BB4ADC		. . . RIVET (SIZE DETERMINED ON INST)		2
495	BACN10TL3A3		. . . NUTPLATE		1
500	140N2623-7		. . . BUSHING-STOP		2
505	BACB28AT07B022C		. . . BUSHING		2
510	146A6418-1		. . . BUSHING		2
515	146A6426-101		. . . BEAM		1
520	146A6428-1		. . FRAME ASSY-VIEWPORT		1
525A	BACR15BA3AD2C		. . . RIVET		6
530	F51652-3		. . . NUTPLATE (V15653) (SPEC BACN10KJ3CD)		3
535	146A6428-101		. . . FRAME		1
540	BACS12HN5-10		. . SCREW (USED ON ITEMS 225A, 225B, 230A, 230B)		2
545	NAS1149D0516H		. . WASHER (USED ON ITEMS 225A, 225B, 230A, 230B)		6

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
550	PLH55CD		. . NUT (V62554) (SPEC BACN10YR5CD) (OPT H52732-5CD (V15653)) (USED ON ITEMS 225A, 225B, 230A, 230B)		2
555	740C14-6		. . JUMPER (V91812) (SPEC BACJ40CG6G) (USED ON ITEMS 225A, 225B, 230A, 230B)		2
560	BACR15BA4ADC		. . RIVET (SIZE DETERMINED ON INST)		8
565	F51646-3BAC		. . NUTPLATE (V15653) (SPEC BACN10JZ3B2CDM) (OPT 102F9220-3 (V72962))		4
570	146A6439-1		. . ANGLE-HANDLE BOX		1
575	146A6445-1		. . BOX ASSY-HANDLE		1
580	146A6445-103		. . . PLATE-COVER		1
			ATTACHING PARTS		
585	VL310AG5-4		. . . BOLT (V06950) (SPEC BACB30VT5HK4) (OPT VL310AG5-4 (V9N513)) (OPT VL310AG5-4 (V97928))		4
590	HST79CY5		. . . COLLAR (V73197) (SPEC BACC30BL5) (OPT HST79-5 (V92215)) (OPT HST79CY5 (V56878)) (OPT HST79CY5 (V5M902))		4
			- - - - - - - * - - - - - - -		
595	146A6592-1		. . . SUPPORT-OUTSIDE HANDLE		1
			ATTACHING PARTS		
600	VL310AG5-4		. . . BOLT (V06950) (SPEC BACB30VT5HK4) (OPT VL310AG5-4 (V9N513)) (OPT VL310AG5-4 (V97928))		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–					
605	HST79CY5		. . . COLLAR (V73197) (SPEC BACC30BL5) (OPT HST79-5 (V92215)) (OPT HST79CY5 (V56878)) (OPT HST79CY5 (V5M902)) - - - - - - - * - - - - - - -		2
610	146A6418-3		. . . BUSHING		1
615	MS29513-020		. . . PACKING		1
620	BACB28AT06B027C		. . . BUSHING-FLANGED		2
625	BACB28AT06B037C		. . . BUSHING-FLANGED		2
630	146A6445-101		. . . BOX		1
632	BACR15GF5D		. . RIVET (SIZE DETERMINED ON INST) (FOR NHA SEE 146A6400)		144
634	BACR15GF6D		. . RIVET (SIZE DETERMINED ON INST) (FOR NHA SEE 146A6400)		65
635	146A6432-1		. . DEPRESSOR-SEAL, UPR		1
640	146A6431-1		. . DEPRESSOR-SEAL, SIDE		1
645	146A6431-2		. . DEPRESSOR-SEAL, SIDE		1
650	146A6433-1		. . DEPRESSOR-SEAL, LWR CORNER		1
655	146A6433-2		. . DEPRESSOR-SEAL, LWR CORNER		1
660	146A6434-1		. . DEPRESSOR-SEAL, LWR CENTER		1
665	HST10AG5-4		. . BOLT (V0PTK6) (SPEC BACB30VT5K4) (OPT HST10AG5-4 (V06725)) (OPT HST10AG5-4 (V56878)) (OPT HST10AG5-4 (V73197))		6
670	HST79CY5		. . COLLAR (V73197) (SPEC BACC30BL5) (OPT HST79-5 (V92215)) (OPT HST79CY5 (V56878)) (OPT HST79CY5 (V5M902))		6
675	146A6439-3		. . ANGLE-ESCAPE SLIDE SPRT		1
680	146A6439-4		. . ANGLE-ESCAPE SLIDE SPRT		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–					
685	146A6420-3		. . FRAME ASSY-LEFT EDGE		1
690	BACR15BB4ADC		. . . RIVET (SIZE DETERMINED ON INST)		10
695	DE847		. . . MOUNT-SHOCK (V71895) (SPEC S411T100-1010)		5
700	146A6447-2		. . . TRACK-GUIDE, UPR		1
			ATTACHING PARTS		
705	HST10AG6-5		. . . BOLT (V0PTK6) (SPEC BACB30VT6K5) (OPT HST10AG6-5 (V06725)) (OPT HST10AG6-5 (V56878)) (OPT HST10AG6-5 (V73197))		4
710	HST79CY6		. . . COLLAR (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V92215)) (OPT HST79CY6 (V56878)) (OPT HST79CY6 (V5M902))		4
			- - - - - - - * - - - - - - -		
715	PACMKP16BSF˜ S428		. . . BEARING (V21335) (SPEC BACB10FV16J) (OPT AMKP16BSNJC (V06144))		1
720	BACB28AT07B022C		. . . BUSHING		1
725	BACS31H1B		. . . RINGPOST		4
730	BACR15BB4ADC		. . . RIVET (SIZE DETERMINED ON INST)		8
735	WS14A12		. . . NUTPLATE (V04169) (SPEC BACN10TL3A12)		3
740	WSI4A16		. . . NUTPLATE (V04169) (SPEC BACN10TL3A16)		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–					
745	HST10AG6-6		. . . BOLT (V0PTK6) (SPEC BACB30VT6K6) (OPT HST10AG6-6 (V06725)) (OPT HST10AG6-6 (V56878)) (OPT HST10AG6-6 (V73197))		3
750	HST79CY6		. . . COLLAR (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V92215)) (OPT HST79CY6 (V56878)) (OPT HST79CY6 (V5M902))		3
755	146A6449-2		. . . PIN-GUIDE, LWR		1
760	146A6420-103		. . . FRAME		1
765	146A6420-1		. . FRAME ASSY-R EDGE (USED ON ITEMS 225, 225A, 230, 230A)		1
–765A	146A6420-7		. . FRAME ASSY-R EDGE (USED ON ITEMS 225B, 230B)		1
770	BACS12HN3-12		. . . SCREW		1
775	BACW10EC3S		. . . WASHER		1
780	NAS1149D0316H		. . . WASHER		2
785	MS35650-305T		. . . NUT		1
790	BACS31H1B		. . . RINGPOST		1
795	BACR15BB4ADC		. . . RIVET (SIZE DETERMINED ON INST)		2
800	WSI4A16		. . . NUTPLATE (V04169) (SPEC BACN10TL3A16)		1
805	BACR15BB3ADC		. . . RIVET (SIZE DETERMINED ON INST)		10
810	DE847		. . . MOUNT-SHOCK (V71985) (SPEC S411T100-1010)		5
815	146A6447-1		. . . TRACK-GUIDE, UPR		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–			ATTACHING PARTS		
820	HST10AG6-5		. . . BOLT (V0PTK6) (SPEC BACB30VT6K5) (OPT HST10AG6-5 (V06725)) (OPT HST10AG6-5 (V56878)) (OPT HST10AG6-5 (V73197))		4
825	HST79CY6		. . . COLLAR (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V92215)) (OPT HST79CY6 (V56878)) (OPT HST79CY6 (V5M902)) - - - - - - - * - - - - - - -		4
830	VL310AG5-6		. . . BOLT (V06950) (SPEC BACB30VT5HK6) (OPT VL310AG5-6 (V9N513)) (OPT VL310AG5-6 (V97928)) (USED ON ITEM 765)		1
–830A	HST10AG6-6		. . . BOLT (V0PTK6) (SPEC BACB30VT6K6) (OPT HST10AG6-6 (V06725)) (OPT HST10AG6-6 (V56878)) (OPT HST10AG6-6 (V73197)) (USED ON ITEM 765A)		1
835	VL310AG5-4		. . . BOLT (V06950) (SPEC BACB30VT5HK4) (OPT VL310AG5-4 (V9N513)) (OPT VL310AG5-4 (V97928)) (USED ON ITEM 765)		1
–835A	HST10AG6-4		. . . BOLT (V06725) (SPEC BACB30VT6K4) (OPT HST10AG6-4 (V73197)) (OPT HST10AG6-4 (V56878)) (OPT HST10AG6-4 (V0PTK6)) (USED ON ITEM 765A)		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–					
840	HST79CY5		. . . COLLAR (V73197) (SPEC BACC30BL5) (OPT HST79-5 (V92215)) (OPT HST79CY5 (V56878)) (OPT HST79CY5 (V5M902)) (USED ON ITEM 765)		2
–840A	HST79CY6		. . . COLLAR (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V92215)) (OPT HST79CY6 (V56878)) (OPT HST79CY6 (V5M902)) (USED ON ITEM 765A)		2
845	BACS40U3L3		. . . SHIM		2
850	146A6420-105		. . . RETAINER-LOCK SHAFT		1
855	BACB10FB10C		. . . BEARING (USED ON ITEM 765)		1
–855A	BACB10ES10C		. . . BEARING (USED ON ITEM 765A)		1
860	PACMKP16BSF˜ S428		. . . BEARING (V21335) (SPEC BACB10FV16J) (OPT AMKP16BSNJC (V06144))		1
865	HST10AG6-8		. . . BOLT (V0PTK6) (SPEC BACB30VT6K8) (OPT HST10AG6-8 (V06725)) (OPT HST10AG6-8 (V56878)) (OPT HST10AG6-8 (V73197))		1
870	BACW10P5CC		. . . WASHER		1
875	HST1094DU6		. . . COLLAR (V73197) (SPEC BACC30BS6S)		1
880	BACB28AK03-035		. . . BUSHING		1
885	BACB28AT07B022C		. . . BUSHING		1

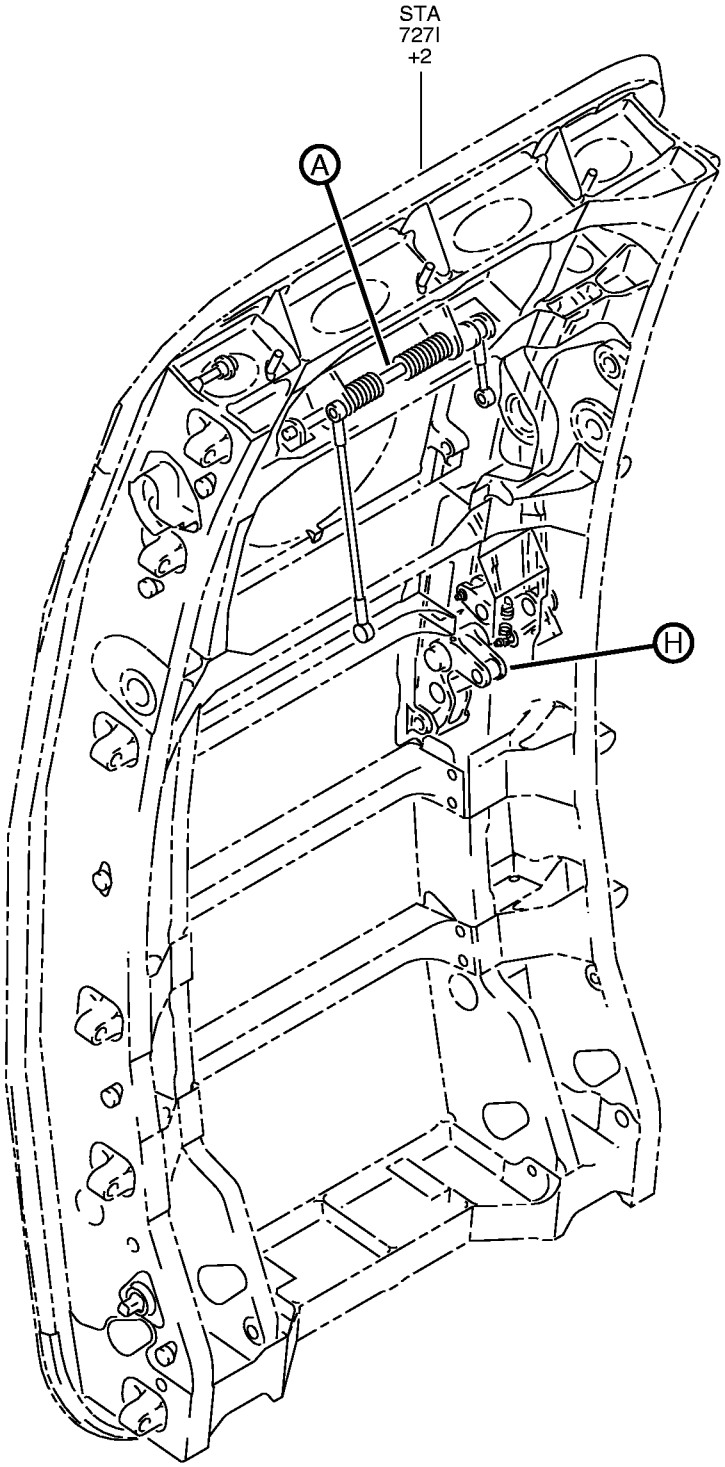
–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
890	HST10AG6-6		. . . BOLT (V0PTK6) (SPEC BACB30VT6K6) (OPT HST10AG6-6 (V06725)) (OPT HST10AG6-6 (V56878)) (OPT HST10AG6-6 (V73197))		3
895	DCM6E		. . . COLLAR (V11815) (SPEC BACC30L6) (OPT DCM6E (V29666))		3
900	146A6449-1		. . . PIN-GUIDE, LWR		1
905	146A6420-101		. . . FRAME (USED ON ITEM 765)		1
–905A	146A6420-107		. . . FRAME (USED ON ITEM 765A)		1
–910	M0DREF287701		. MECHANICAL INSTL (LIMITED USAGE) (146A6500-5REVA) (FOR DETAILS SEE FIG. 2)	A	1
–910A	M0DREF297447		. MECHANICAL INSTL (LIMITED USAGE) (146A6500-5REVB) (FOR DETAILS SEE FIG. 2)	A	1
–915	M0DREF287702		. MECHANICAL INSTL (LIMITED USAGE) (146A6500-6REVA) (FOR DETAILS SEE FIG. 2)	B	1
–915A	M0DREF297448		. MECHANICAL INSTL (LIMITED USAGE) (146A6500-6REVB) (FOR DETAILS SEE FIG. 2)	B	1
–920	M0DREF287699		. MECHANICAL INSTL (LIMITED USAGE) (146A6500-3REVA) (FOR DETAILS SEE FIG. 3)	A	1
–920A	M0DREF295479		. MECHANICAL INSTL (LIMITED USAGE) (146A6500-3REVB) (FOR DETAILS SEE FIG. 3)	A	1

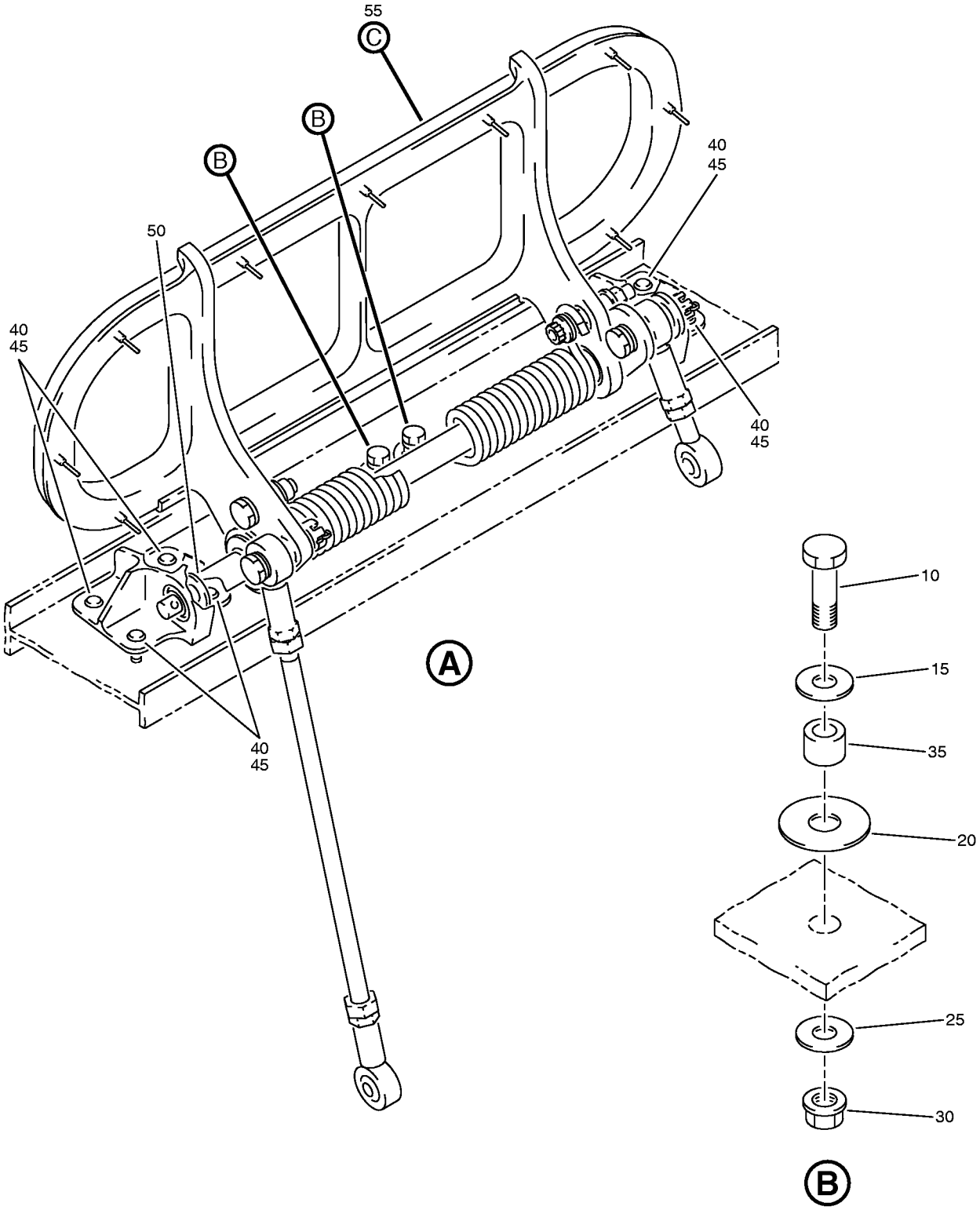
–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
–920B	M0DREF297445		. MECHANICAL INSTL (LIMITED USAGE) (146A6500-3REVC) (FOR DETAILS SEE FIG. 3)	A	1
–925	M0DREF287699		. MECHANICAL INSTL (LIMITED USAGE) (146A6500-4REVA) (FOR DETAILS SEE FIG. 3)	B	1
–925A	M0DREF295480		. MECHANICAL INSTL (LIMITED USAGE) (146A6500-4REVB) (FOR DETAILS SEE FIG. 3)	B	1
–925B	M0DREF297446		. MECHANICAL INSTL (LIMITED USAGE) (146A6500-4REVC) (FOR DETAILS SEE FIG. 3)	B	1
–930	M0DREF287697		. MECHANICAL INSTL (146A6500-1REVA) (FOR DETAILS SEE FIG. 4)	A	1
–935	M0DREF287698		. MECHANICAL INSTL (146A6500-2REVA) (FOR DETAILS SEE FIG. 4)	B	1

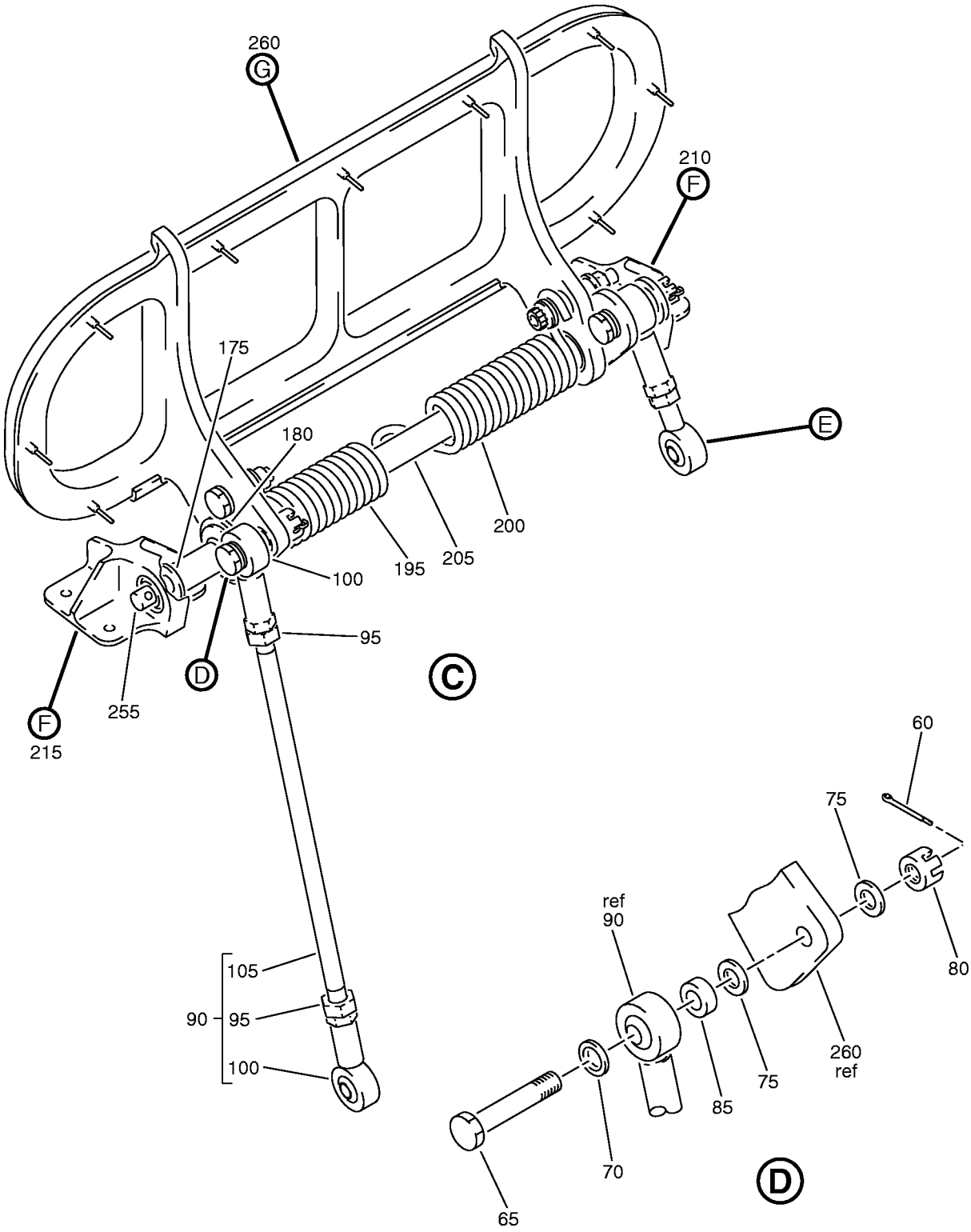
–Item not Illustrated



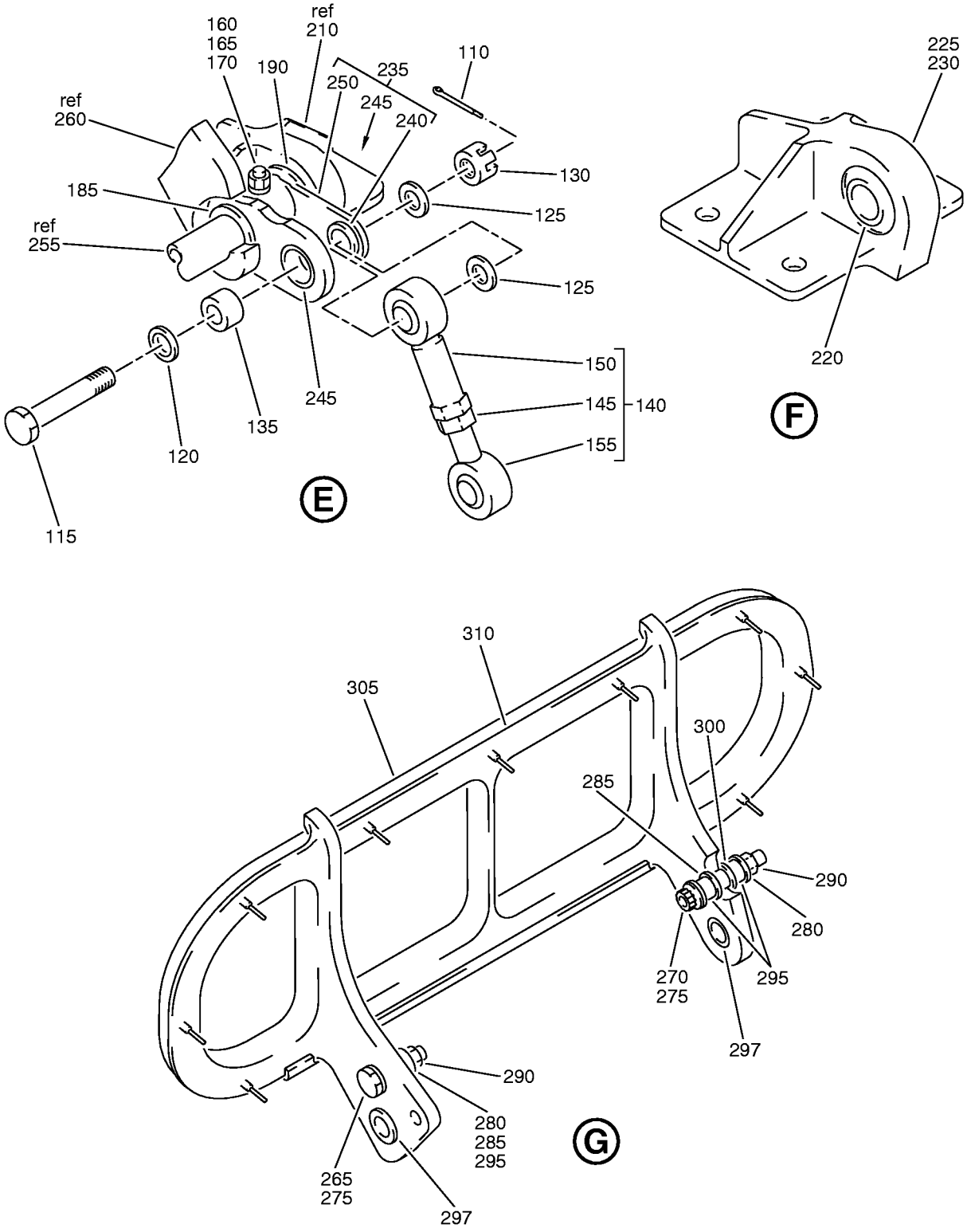
Mechanical Installation
IPL Figure 2 (Sheet 1 of 11)



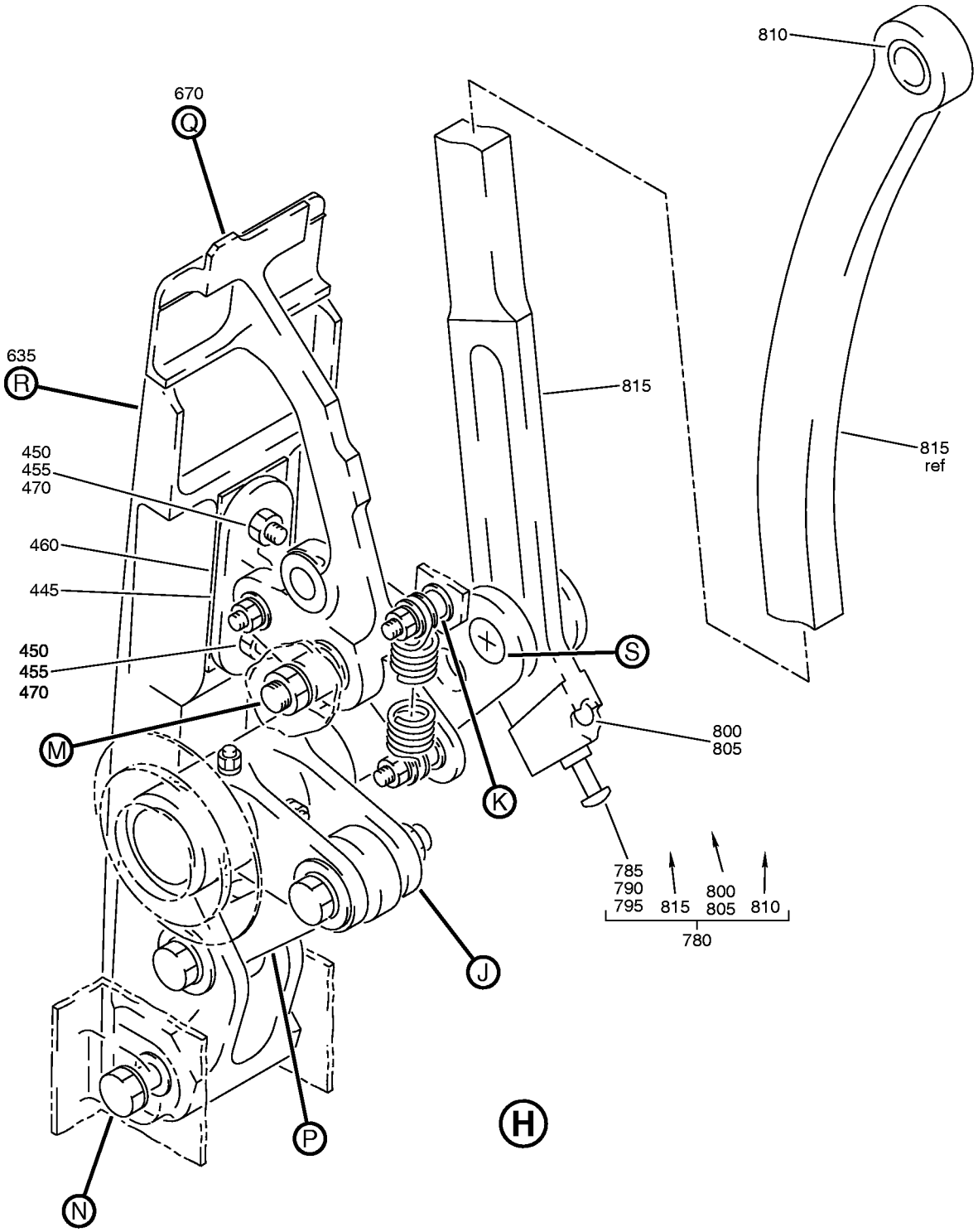
Mechanical Installation
IPL Figure 2 (Sheet 2 of 11)



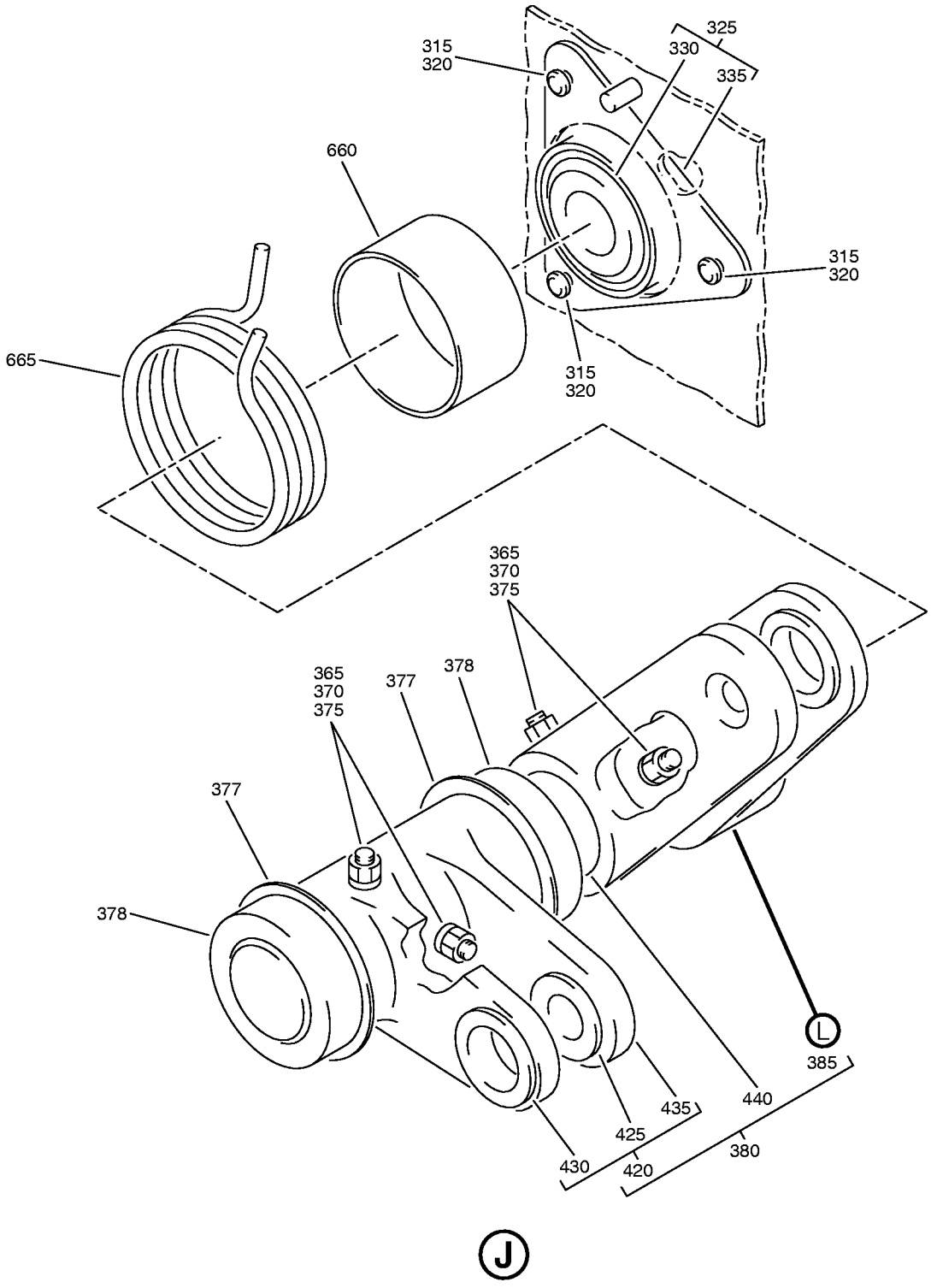
Mechanical Installation
IPL Figure 2 (Sheet 3 of 11)



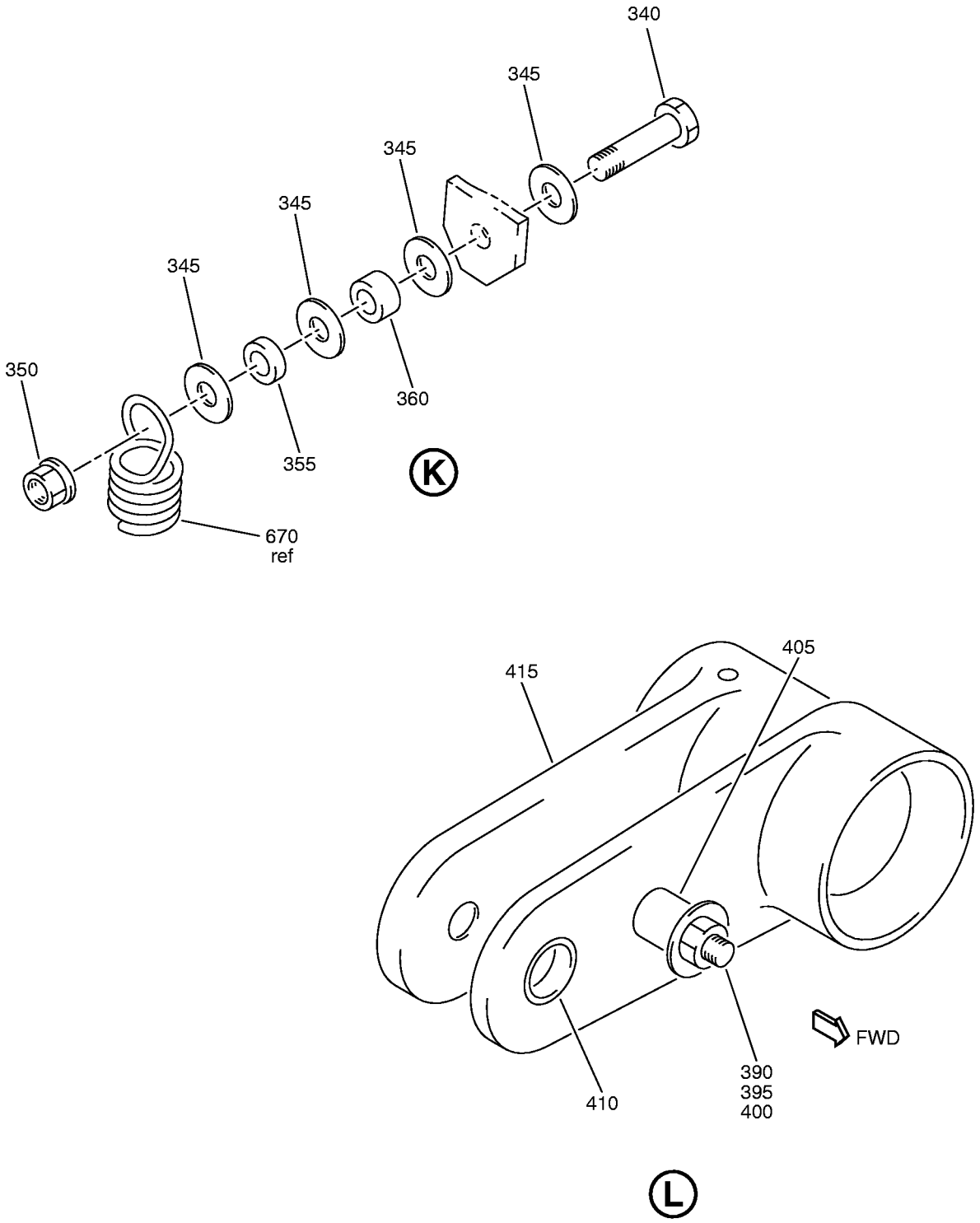
Mechanical Installation
IPL Figure 2 (Sheet 4 of 11)



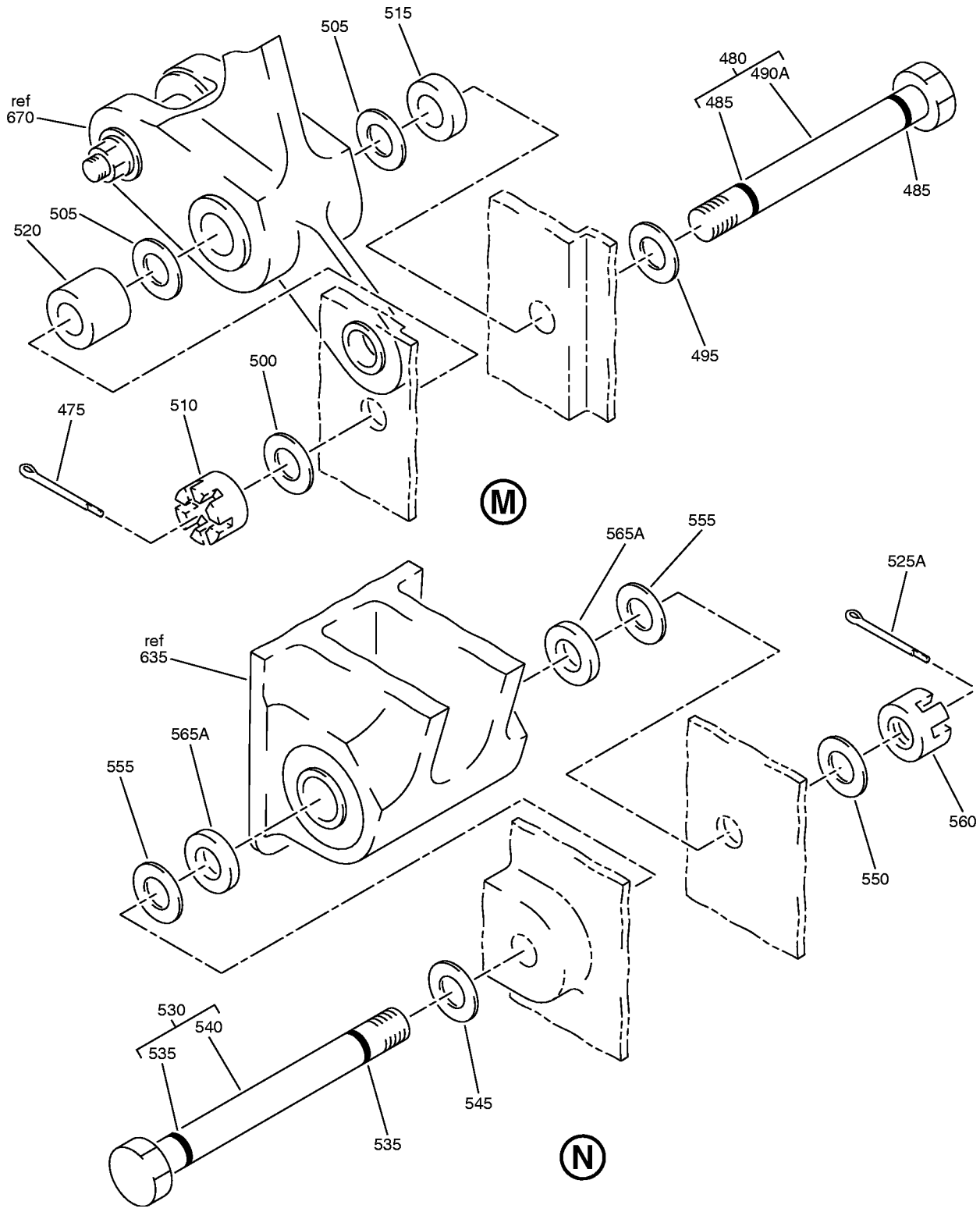
Mechanical Installation
IPL Figure 2 (Sheet 5 of 11)



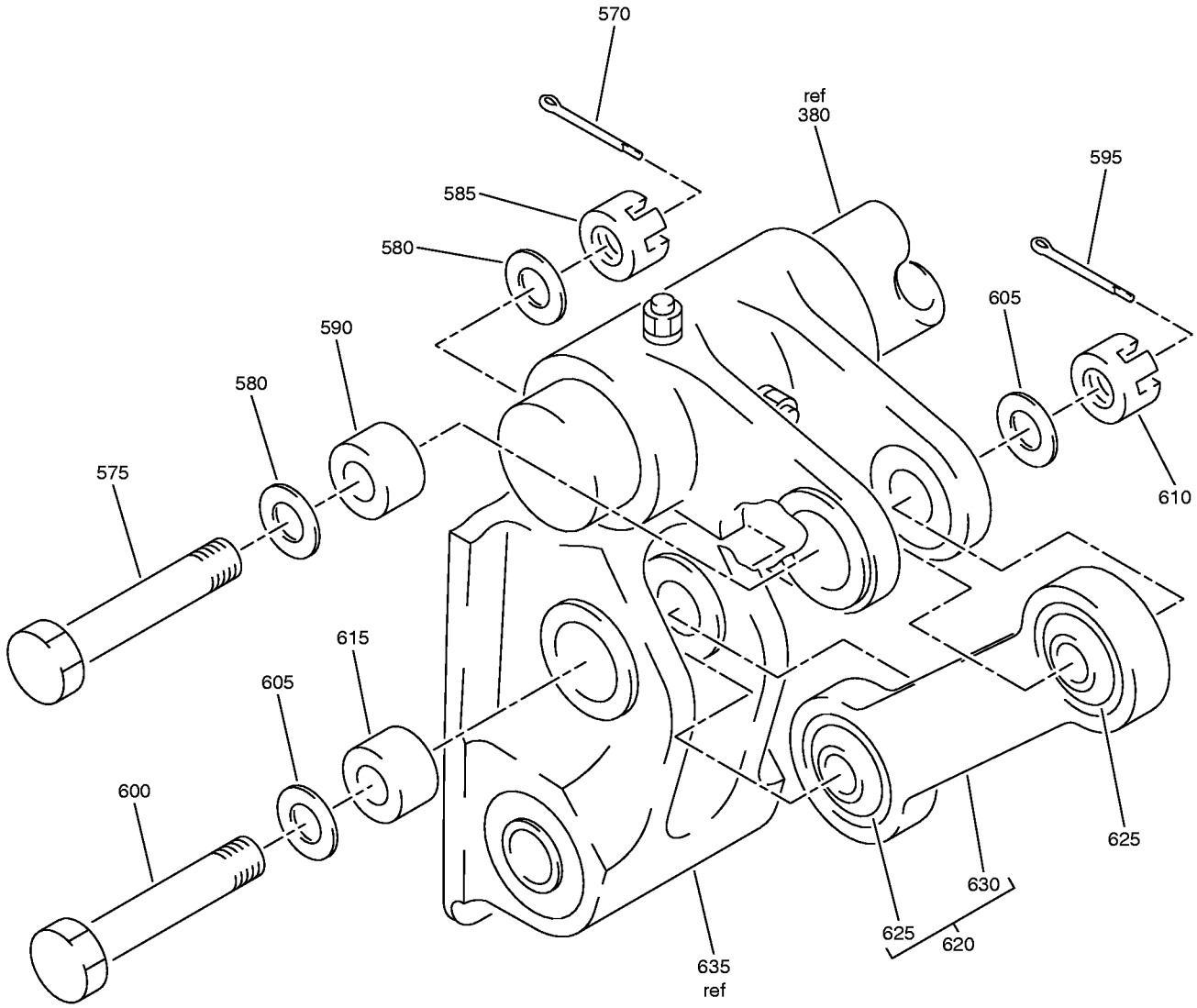
Mechanical Installation
IPL Figure 2 (Sheet 6 of 11)



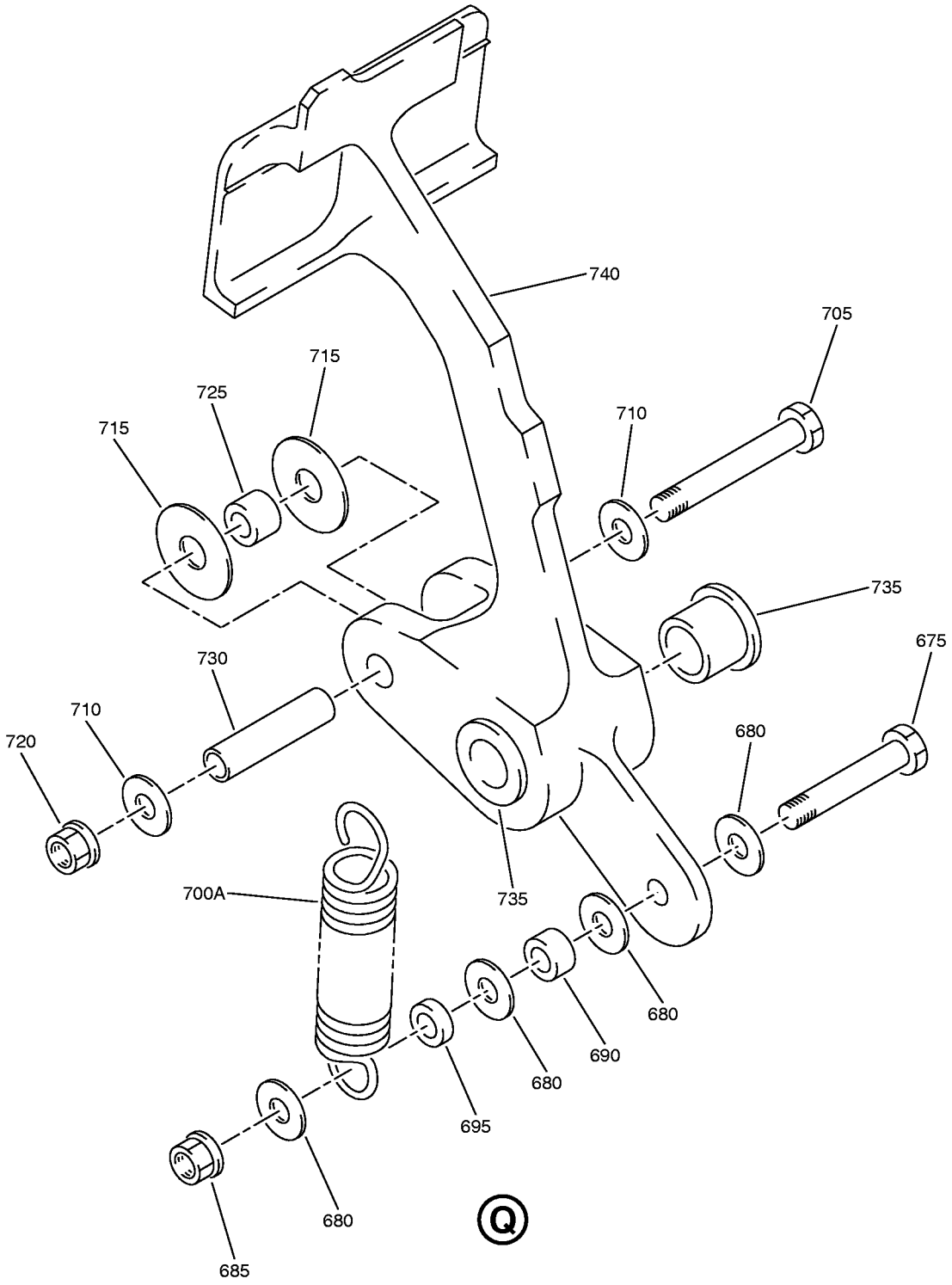
Mechanical Installation
IPL Figure 2 (Sheet 7 of 11)



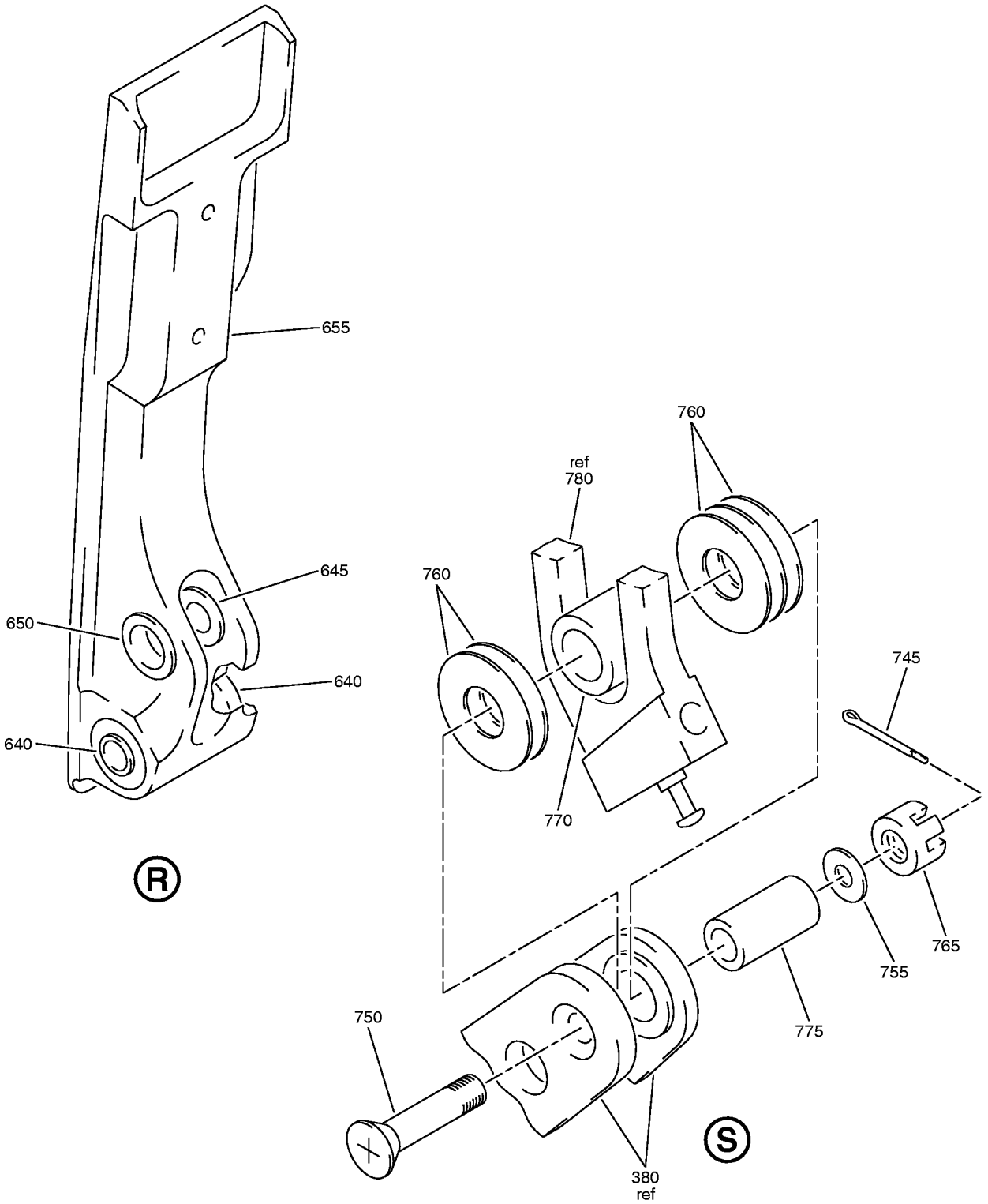
Mechanical Installation
IPL Figure 2 (Sheet 8 of 11)



Mechanical Installation
IPL Figure 2 (Sheet 9 of 11)



Mechanical Installation
IPL Figure 2 (Sheet 10 of 11)



Mechanical Installation
IPL Figure 2 (Sheet 11 of 11)

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
–1A	M0DREF287701		MECHANICAL INSTL (LIMITED USAGE) (146A6500-5REVA)	A	RF
–1B	M0DREF297447		MECHANICAL INSTL (LIMITED USAGE) (146A6500-5REVB)	A	RF
–5	M0DREF287702		MECHANICAL INSTL (LIMITED USAGE) (146A6500-6REVA)	B	RF
–5A	M0DREF297448		MECHANICAL INSTL (LIMITED USAGE) (146A6500-6REVB)	B	RF
10	BACB30NR4K9		. BOLT		2
15	BACW10BP4ACU		. WASHER		2
20	BACW10P435CG		. WASHER		2
25	BACW10BN4AP		. WASHER		2
30	PLH54CD		. NUT (V62554) (SPEC BACN10YR4CD) (OPT H52732-4CD (V15653))		2
35	BACB28AK04-027		. BUSHING		2
40	HLT420AP6-4		. BOLT (V60516) (SPEC BACB30YL6K4) (OPT HLT420AP6-4 (V97928)) (OPT HLT420AP6-4 (V06725))		6
45	BACC30CP6C		. COLLAR		6
50	NAS1149E0516P		. WASHER		AR
55	146A6539-1		. MECHANISM ASSY-VENT DOOR		1
60	BACP18BC02A06P		. . PIN		1
65	BACB30NR4DK16		. . BOLT		1
70	BACW10BP4ACU		. . WASHER		1
75	BACW10BN4AP		. . WASHER		2
80	BACN10JD4CD		. . NUT		1
85	BACB28AK04-015		. . BUSHING		1
90	146A6530-2		. . ROD ASSY-PUSH		1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
95	BACN11U5CM1N		. . . NUT-JAM		2
100	12E4-117M		. . . BEARING (V16746) (SPEC BACB10Z4M) (OPT BRES4-2242M1 (V81376)) (OPT FSSK4AS1 (V73134)) (OPT HB4-201KM (V02758)) (OPT KB4-150WD5 (V97613)) (OPT 51589-041DD (V09455)) (OPT ASWK4-1DM (V56644)) (OPT AR4-7W13 (VS0352)) (OPT ARB4-61MW (V15860))		2
105	146A6531-1		. . . ROD		1
110	BACP18BC02A06P		. . PIN-COTTER		1
115	BACB30NR4DK17		. . BOLT		1
120	BACW10BP4ACU		. . WASHER		1
125	BACW10BP4APU		. . WASHER		2
130	BACN10JD4ASU		. . NUT		1
135	BACB28AK04-030		. . BUSHING		1
140	146A6530-1		. . ROD ASSY-PUSH		1
145	BACN11U5CM1N		. . . NUT		1
150	12E4-117M		. . . BEARING (V16746) (SPEC BACB10Z4M) (OPT BRES4-2242M1 (V81376)) (OPT FSSK4AS1 (V73134)) (OPT HB4-201KM (V02758)) (OPT KB4-150WD5 (V97613)) (OPT 51589-041DD (V09455)) (OPT ASWK4-1DM (V56644)) (OPT AR4-7W13 (VS0352)) (OPT ARB4-61MW (V15860))		1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
155	10E4-116M		. . . BEARING (V16746) (SPEC BACB10Y4M) (OPT BRES4-2236M1 (V81376)) (OPT HB4E212KM (V02758)) (OPT KBE4-150WD5 (V97613)) (OPT MSSK4AS1 (V73134)) (OPT 51588-041DD (V09455)) (OPT ASMK4-1DM (V56644)) (OPT AR4E7W13 (VS0352)) (OPT ARB4E60MW (V15860))		1
160	BACB30NR4K11		. . BOLT		1
165	BACW10BP4APU		. . WASHER		1
170	PLH54CM		. . NUT (V62554) (SPEC BACN10YR4CM) (OPT H52732-4CM (V15653))		1
175	BACW10BN5AC		. . WASHER		1
180	BACW10BN10AC		. . WASHER		1
185	NAS1149V0932M		. . WASHER		1
190	BACW10P399CD		. . WASHER		1
195	146A6511-7		. . SPRING-TORSION		1
200	146A6511-8		. . SPRING-TORSION		1
205	146A6583-3		. . SLEEVE-TORSION SPRING		1
210	146A6546-1		. . HOUSING ASSY-BEARING		1
215	146A6546-2		. . HOUSING ASSY-BEARING		1
220	BACB10FB05C		. . . BEARING		1
225	146A6546-101		. . . HOUSING (USED ON ITEM 210)		1
230	146A6546-102		. . . HOUSING (USED ON ITEM 215)		1
235	146A6547-1		. . CRANK ASSY-VENT DOOR		1
240	BACB28AP04-009		. . . BUSHING		1
245	BACB28AT06B015A		. . . BUSHING		1
250	146A6547-101		. . . CRANK		1
255	146A6545-1		. . SHAFT-UPR MECHANISM		1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
260	146A6540-1		. . DOOR ASSY-VENT		1
265	BACB30NR4K10		. . . BOLT		1
270	BACB30LE4U16		. . . BOLT		1
275	BACW10BP4ACU		. . . WASHER		2
280	BACW10BP4APU		. . . WASHER		2
285	NAS1149D0463J		. . . WASHER		2
290	PLH54CM		. . . NUT (V62554) (SPEC BACN10YR4CM) (OPT H52732-4CM (V15653))		2
295	BACB28AK04-025		. . . BUSHING		3
297	BACB28AY10A025C		. . . BUSHING		2
300	BACB28AX04C022		. . . BUSHING		1
305	146A6542-1		. . . SEAL		1
310	146A6540-101		. . . DOOR		1
315	HST10AG6-4		. BOLT (V06725) (SPEC BACB30VT6K4) (OPT HST10AG6-4 (V73197)) (OPT HST10AG6-4 (V56878)) (OPT HST10AG6-4 (V0PTK6))		3
320	HST79CY6		. COLLAR (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V92215)) (OPT HST79CY6 (V56878)) (OPT HST79CY6 (V5M902))		3
325	146A6591-1		. HOUSING ASSY-BEARING		1
330	ADB08V301NC		. . BEARING (V15860) (SPEC BACB10FB08GC) (OPT HTFB08GC (VS0352)) (OPT KNDB08-70 (V97613)) (OPT KSC145700BZ08GC (V50632)) (OPT NES08FBGC (V73134))		1
335	146A6591-101		. . HOUSING		1
340	BACB30LM3-9		. BOLT		1
345	NAS1149E0332P		. WASHER		4

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
350	PLH53CD		. NUT (V62554) (SPEC BACN10YR3CD) (OPT H52732-3CD (V15653))		1
355	BACB28AK03-012		. BUSHING		1
360	BACB28AK03-022		. BUSHING		1
365	BACB30LM3-19		. BOLT		4
370	NAS1149E0332P		. WASHER		8
375	PLH53CD		. NUT (V62554) (SPEC BACN10YR3CD) (OPT H52732-3CD (V15653))		4
377	NAS1149E0416P		. WASHER		2
378	SSMB540DDSD624		. BEARING (V83086) (SPEC BACB10FU14J) (OPT PACMB540DDFS428 (V21335)) (OPT AMB540DDNJC (V06144))		2
380	146A6532-1		. SHAFT ASSY-OUTSIDE HANDLE		1
385	146A6536-1		. . CRANK ASSY		1
390	HST10AG6-9		. . . BOLT (V0PTK6) (SPEC BACB30VT6K9) (OPT HST10AG6-9 (V06725)) (OPT HST10AG6-9 (V56878)) (OPT HST10AG6-9 (V73197))		1
395	BACW10P5CC		. . . WASHER		1
400	HST1094DU6		. . . COLLAR (V73197) (SPEC BACC30BS6S)		1
405	BACB28AK03-035		. . . BUSHING		1
410	BACB28AT06B012A		. . . BUSHING		1
415	146A6536-101		. . . CRANK		1
420	146A6535-1		. . CRANK ASSY		1
425	BACB28AP06P018		. . . BUSHING		1
430	BACB28AT09B018A		. . . BUSHING		1
435	146A6535-101		. . . CRANK		1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
440	146A6537-1		. . SHAFT		1
445	146A6529-1		. STOP-CATCH		1
			ATTACHING PARTS		
450	BACB30LH3-13		. BOLT		2
455	NAS1149E0363P		. WASHER		2
460	BACS40R008E026F		. SHIM		1
470	PLH53CD		. NUT (V62554) (SPEC BACN10YR3CD) (OPT H52732-3CD (V15653))		2
			- - - - - - - * - - - - - - -		
475	BACP18BC02A06P		. PIN-COTTER		1
480	146A6597-2		. PIN ASSY-OUTSIDE HANDLE		1
485	MS29513-010		. . PACKING		2
490	146A6597-101		DELETED		
490A	146A6597-102		. . PIN		1
495	NAS1149E0632P		. WASHER		1
500	NAS1149E0532P		. WASHER		1
505	NAS1149E0616P		. WASHER		2
510	BACN10JD5ASU		. NUT		1
515	BACB28AK06-018		. BUSHING		1
520	BACB28AK06-048		. BUSHING		1
525	BACP18BC02A026P		DELETED		
525A	BACP18BC02A06P		. PIN-COTTER		1
530	146A6597-1		. PIN ASSY		1
535	MS29513-010		. . PACKING		2
540	146A6597-101		. . PIN		1
545	NAS1149E0632P		. WASHER		1
550	NAS1149E0532P		. WASHER		1
555	NAS1149E0616P		. WASHER		2
560	BACN10JD5ASU		. NUT		1
565A	BACB28AK06-007		. BUSHING		2

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
570	BACP18BC03A08P		. PIN-COTTER		1
575	BACB30NR6DK16		. BOLT		1
580	NAS1149E0632P		. WASHER		2
585	BACN10JD106CD		. NUT		1
590	BACB28AK06-039		. BUSHING		1
595	BACP18BC03A08P		. PIN-COTTER		1
600	BACB30NR6DK16		. BOLT		1
605	NAS1149E0632P		. WASHER		2
610	BACN10JD106CD		. NUT		1
615	BACB28AK06-039		. BUSHING		1
620	146A6527-1		. LINK ASSY-HANDLE		1
625	ADB06V301NC		. . BEARING (V15860) (SPEC BACB10FB06GC) (OPT HTFB06GC (VS0352)) (OPT KNDB06-70 (V97613)) (OPT KSC145700BZ06GC (V50632)) (OPT NES06FBGC (V73134))		2
630	146A6527-101		. . LINK		1
635	146A6526-1		. HANDLE ASSY-OUTSIDE		1
640	SSMKP6ASD524		. . BEARING (V50294) (SPEC BACB10FS06J) (OPT PACMKP06JAA3908 (V21335)) (OPT SSMKP06JASD705 (V83086)) (OPT PACMKP6AFS428 (V21335)) (OPT ACMKP06JAP510LY (V40920)) (OPT PACMKP06JAFS428 (V21335)) (OPT SSMKP06JAP (V21760)) (OPT SSMKP06AP (V21760))		2
645	BACB28AP06P018		. . BUSHING		1
650	BACB28AT09B018C		. . BUSHING		1
655	146A6526-101		. . HANDLE		1
660	146A6568-4		. SLEEVE-TORSION SPRING		1
665	146A6511-9		. SPRING-TORSION		1
670	146A6589-1		. COVER ASSY-HANDLE		1

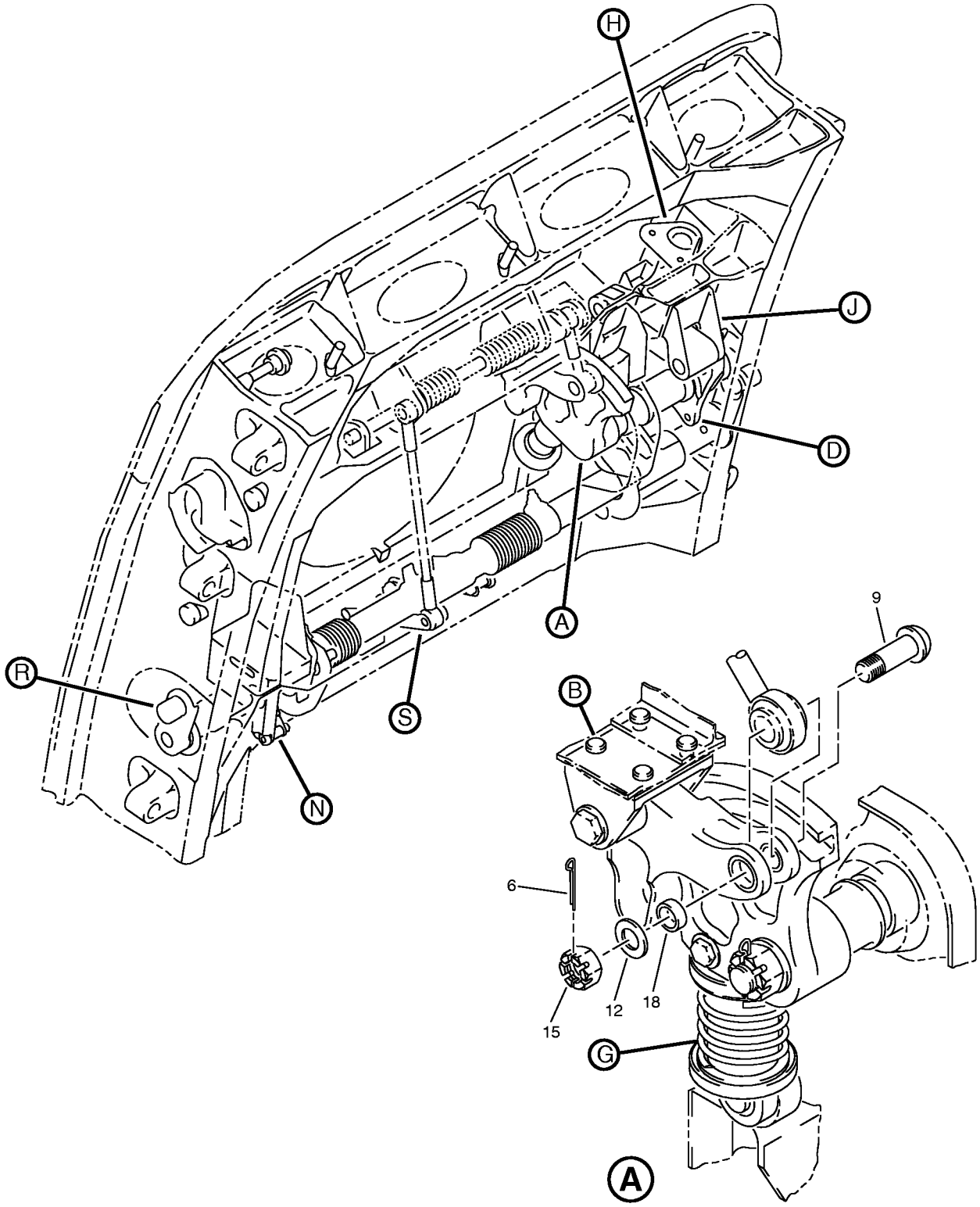
–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
675	BACB30LM3-9		. . BOLT		1
680	NAS1149E0332P		. . WASHER		4
685	PLH53CD		. . NUT (V62554) (SPEC BACN10YR3CD) (OPT H52732-3CD (V15653))		1
690	BACB28AK03-022		. . BUSHING		1
695	BACB28AK03-012		. . BUSHING		1
700A	MS24586C201		. . SPRING		1
705	BACB30LM3-17		. . BOLT		1
710	NAS1149E0332P		. . WASHER		2
715	BACW10P271TF		. . WASHER		2
720	PLH53CD		. . NUT (V62554) (SPEC BACN10YR3CD) (OPT H52732-3CD (V15653))		1
725	BACB28Y4C035		. . BUSHING		1
730	69-47407-3		. . SLEEVE		1
735	BACB28AT06B045C		. . BUSHING		2
740	146A6589-101		. . COVER		1
745	BACP18C02A06P		. PIN-COTTER		1
750	BACB30LR4D16		. BOLT		1
755	NAS1149E0432P		. WASHER		1
760	NAS1149E0932P		. WASHER		5
765	BACN10JD4CD		. NUT		1
770	BACB28AK06-053		. BUSHING		1
775	BACB28AK04-080		. BUSHING		1
780	146A6590-1		. LINK ASSY-CLUTCH		1
785	BACS12CK3U26		. . SCREW		1
790	NAS1149C0332R		. . WASHER		1
795	BACN11U3CM1		. . NUT		1

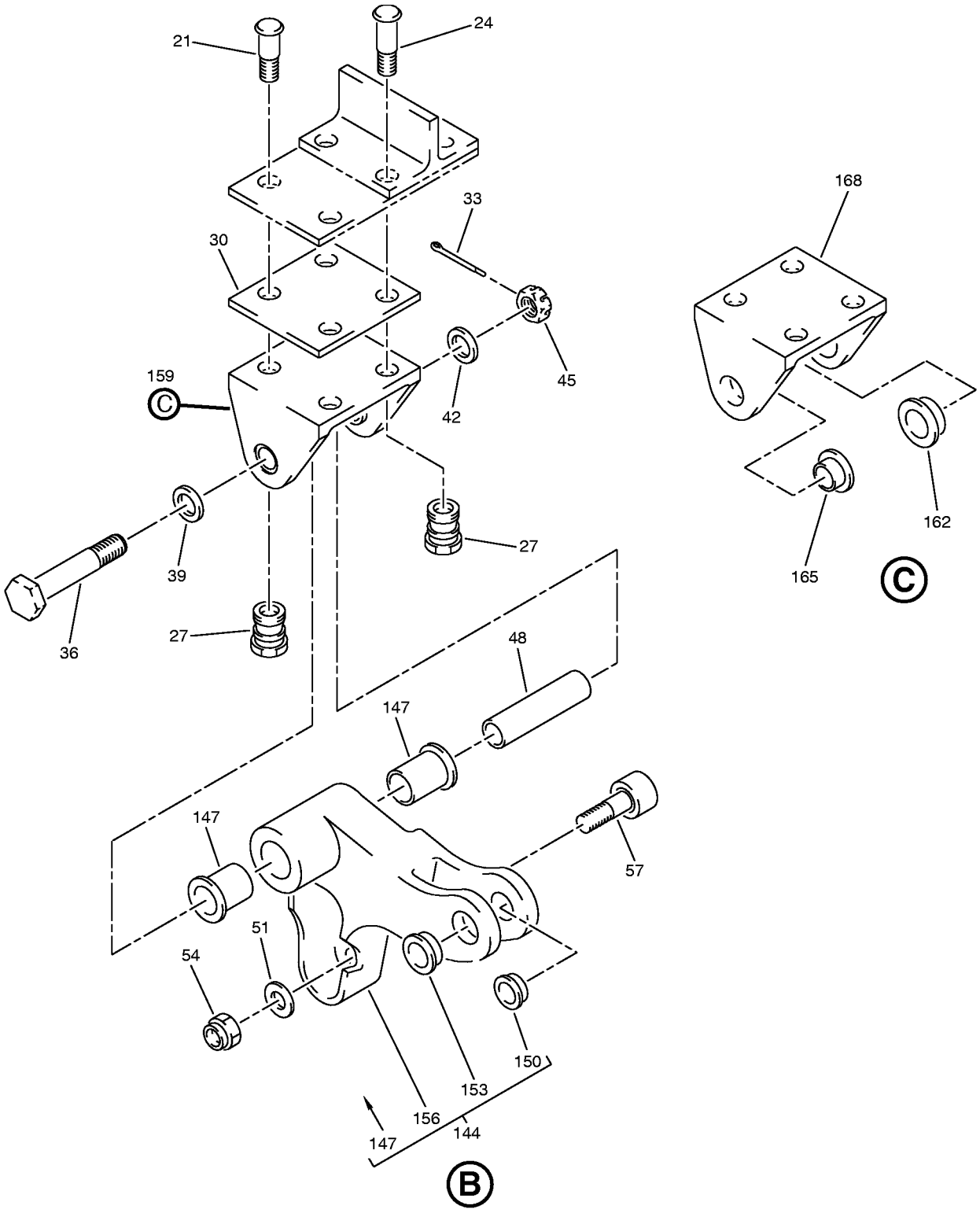
–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
800	SLR4001-3A		. . RETAINER (V97393) (SPEC BACR10AL3A) (OPT SLR50-3A (V97393))		1
805	SL4113-3CDBAC		. . NUT (V97393) (SPEC BACN10ZC3CD) (OPT 102B13171-3 (V72962)) (OPT 92834-1032CD (V56878))		1
810	WES05B10GC		. . BEARING (V73134) (SPEC BACB10FE05C) (OPT ADW5VNC (V15860)) (OPT KR5CWGBZC (V50632)) (OPT KWDB5-39 (V97613)) (OPT WRRS05B10GC (V73134)) (OPT WHT05VSBC (VS0352))		1
815	146A6590-101		. . LINK		1

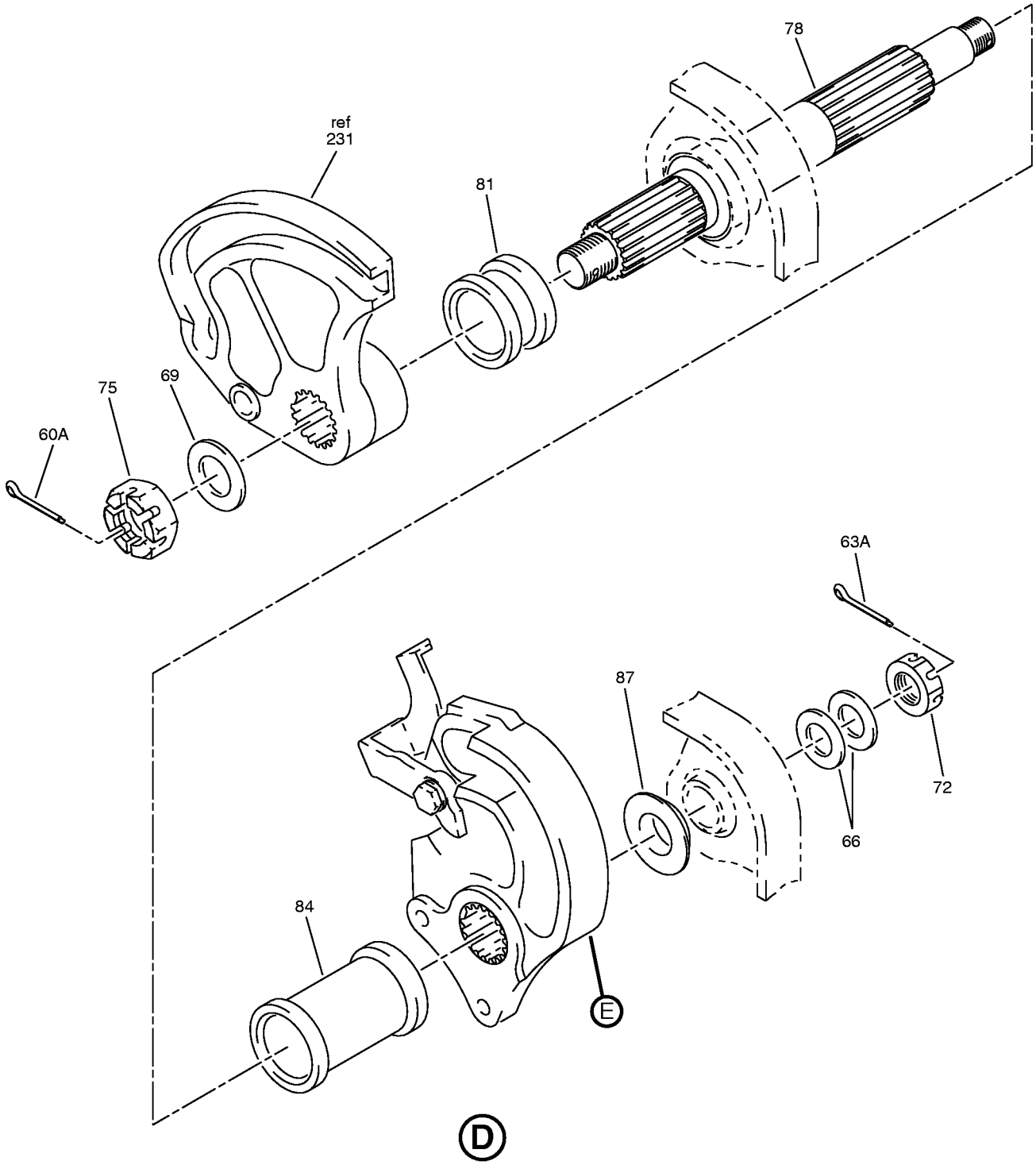
–Item not Illustrated



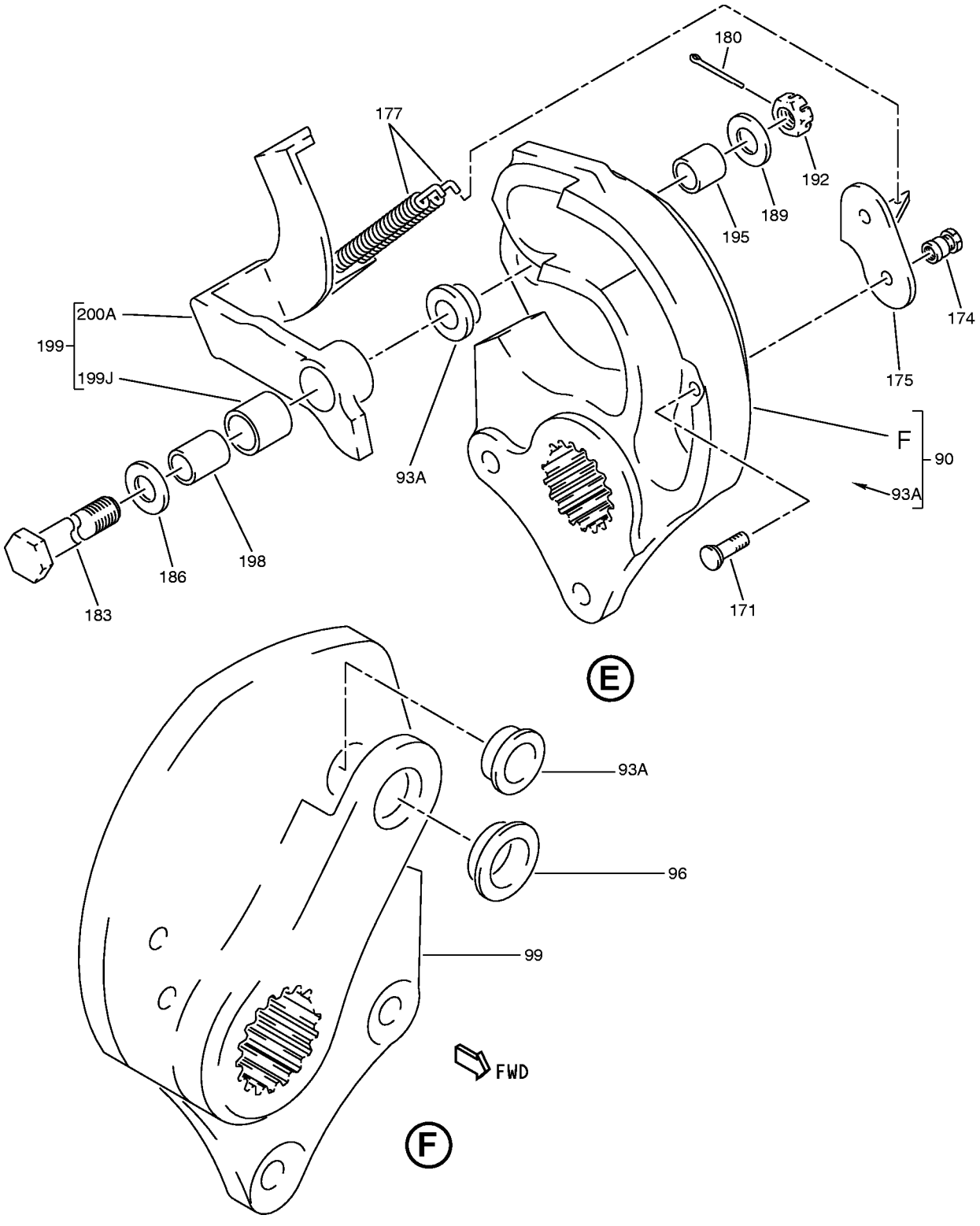
Mechanical Installation
IPL Figure 3 (Sheet 1 of 18)



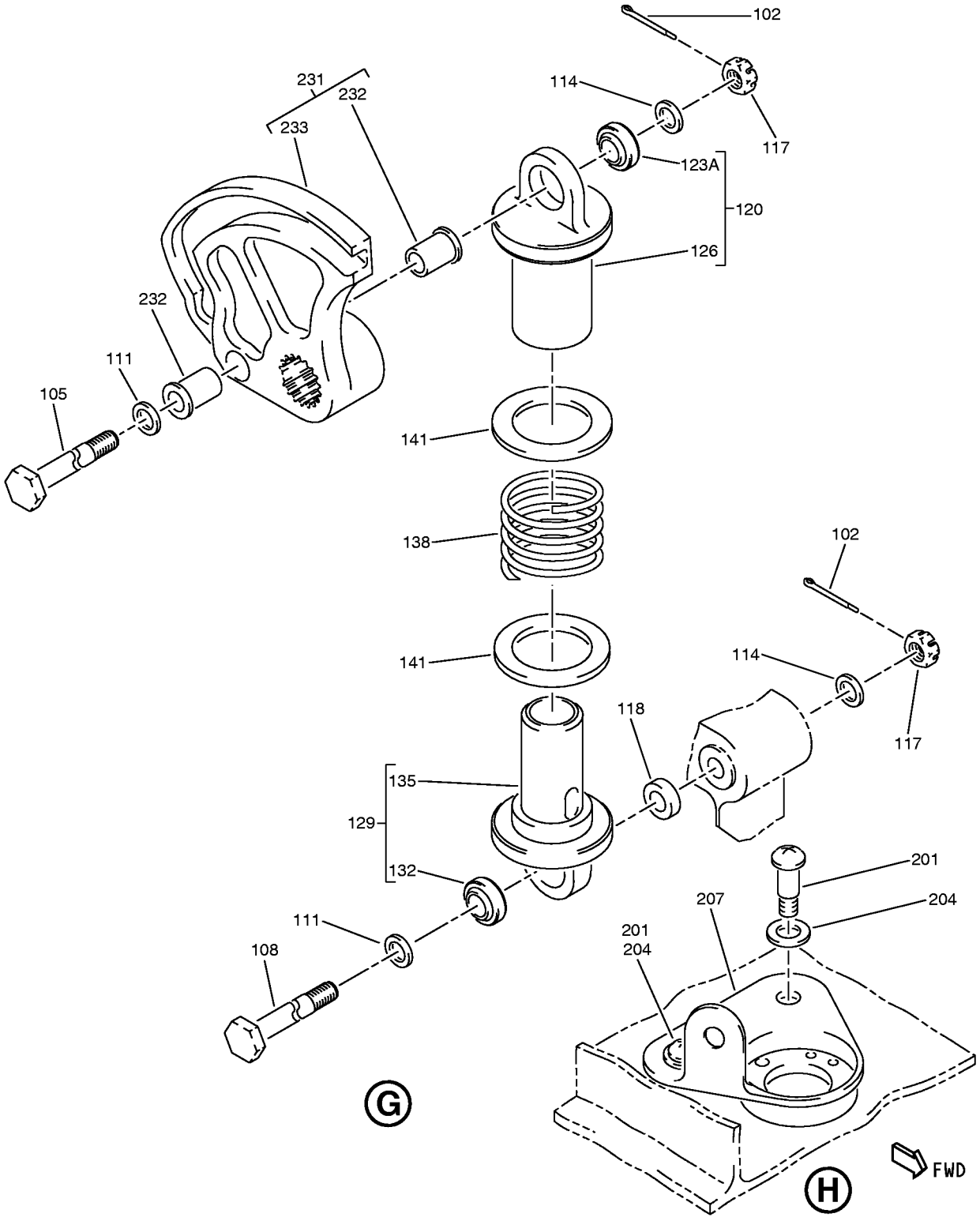
Mechanical Installation
IPL Figure 3 (Sheet 2 of 18)



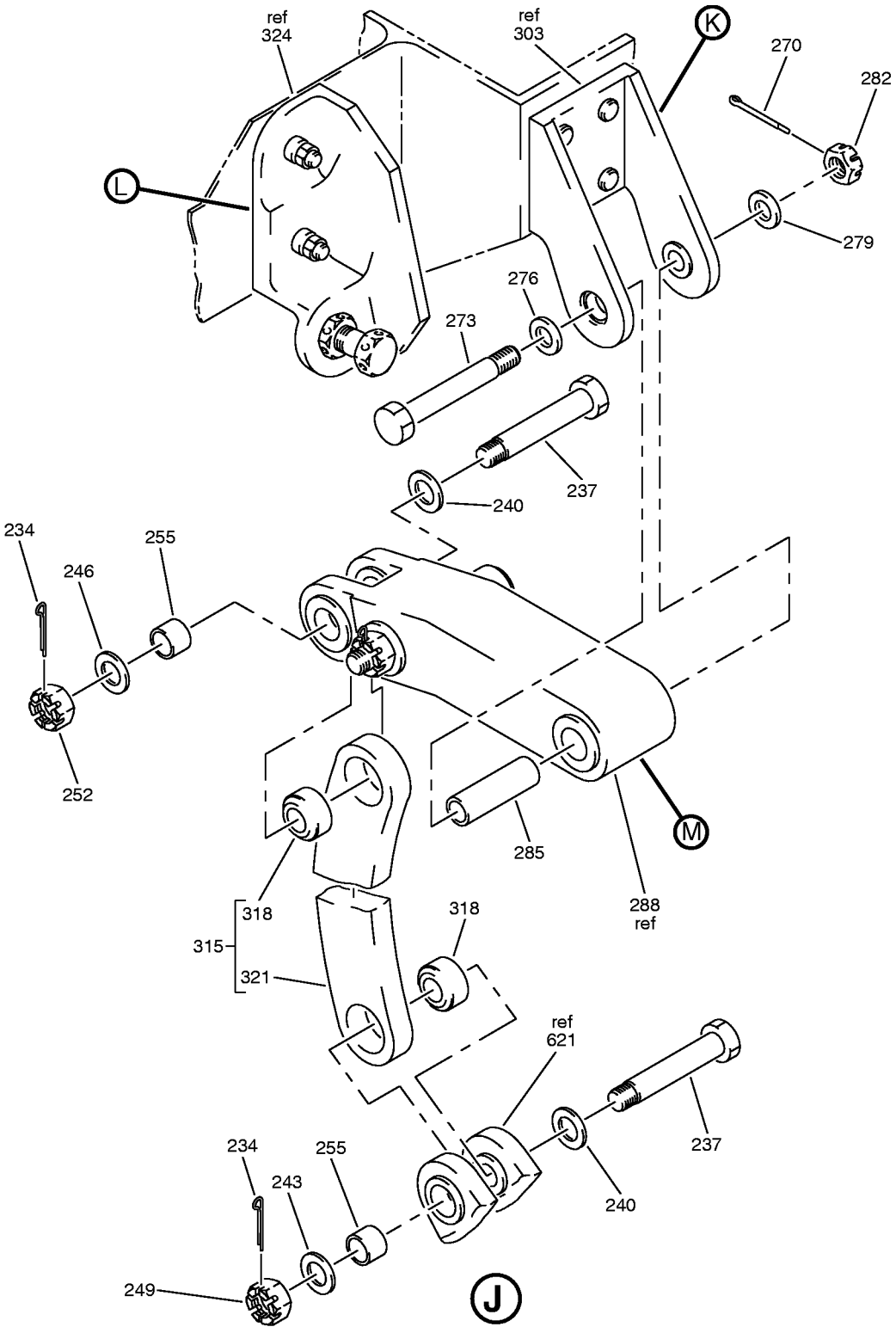
Mechanical Installation
IPL Figure 3 (Sheet 3 of 18)



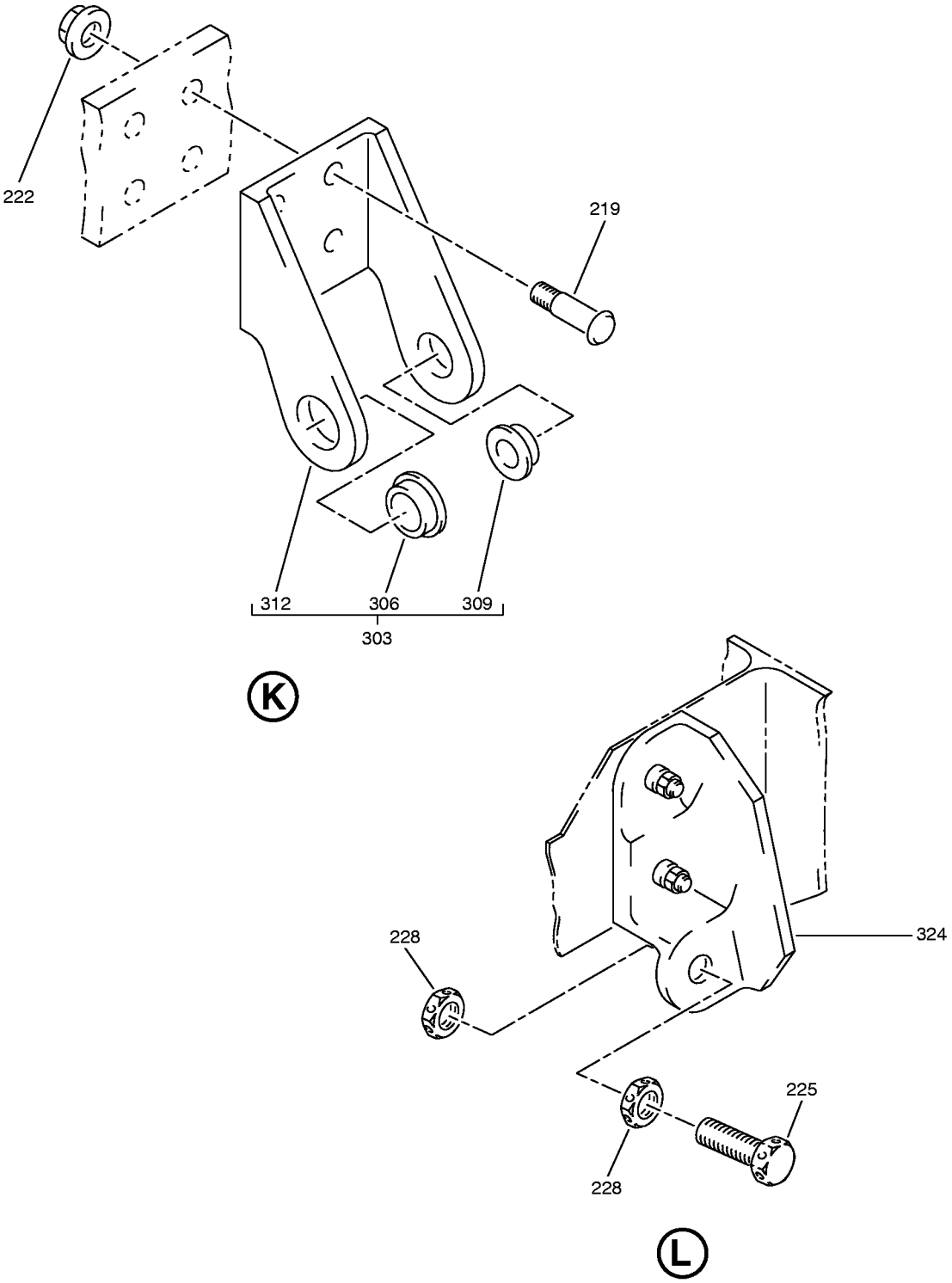
Mechanical Installation
IPL Figure 3 (Sheet 4 of 18)



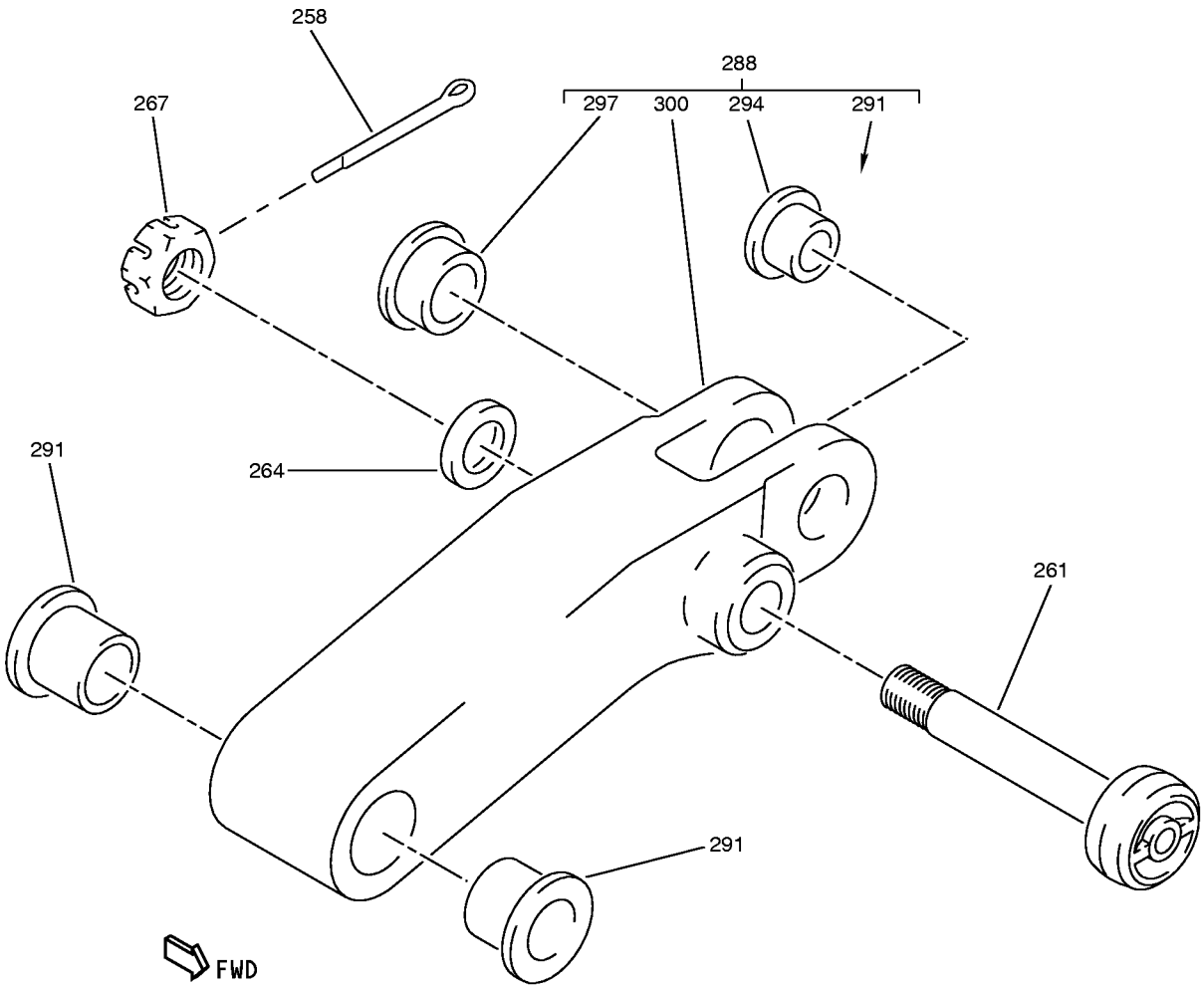
Mechanical Installation
IPL Figure 3 (Sheet 5 of 18)



Mechanical Installation
IPL Figure 3 (Sheet 6 of 18)



Mechanical Installation
IPL Figure 3 (Sheet 7 of 18)



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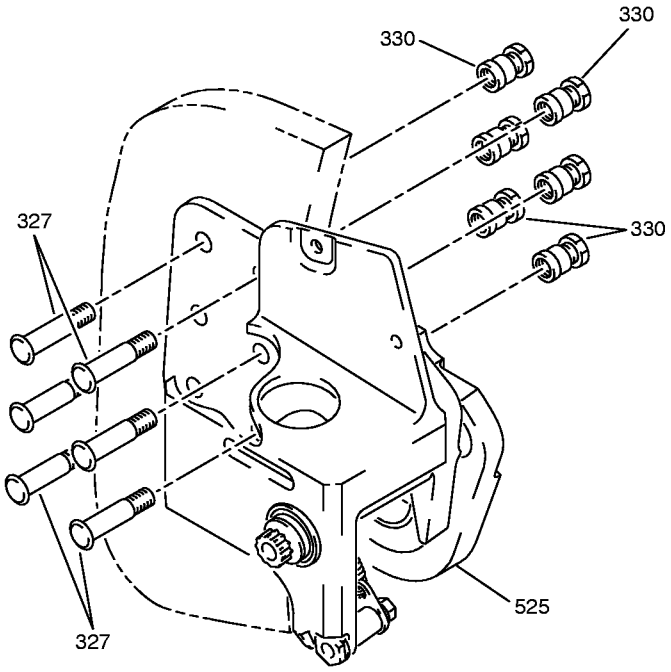
Mechanical Installation
IPL Figure 3 (Sheet 8 of 18)



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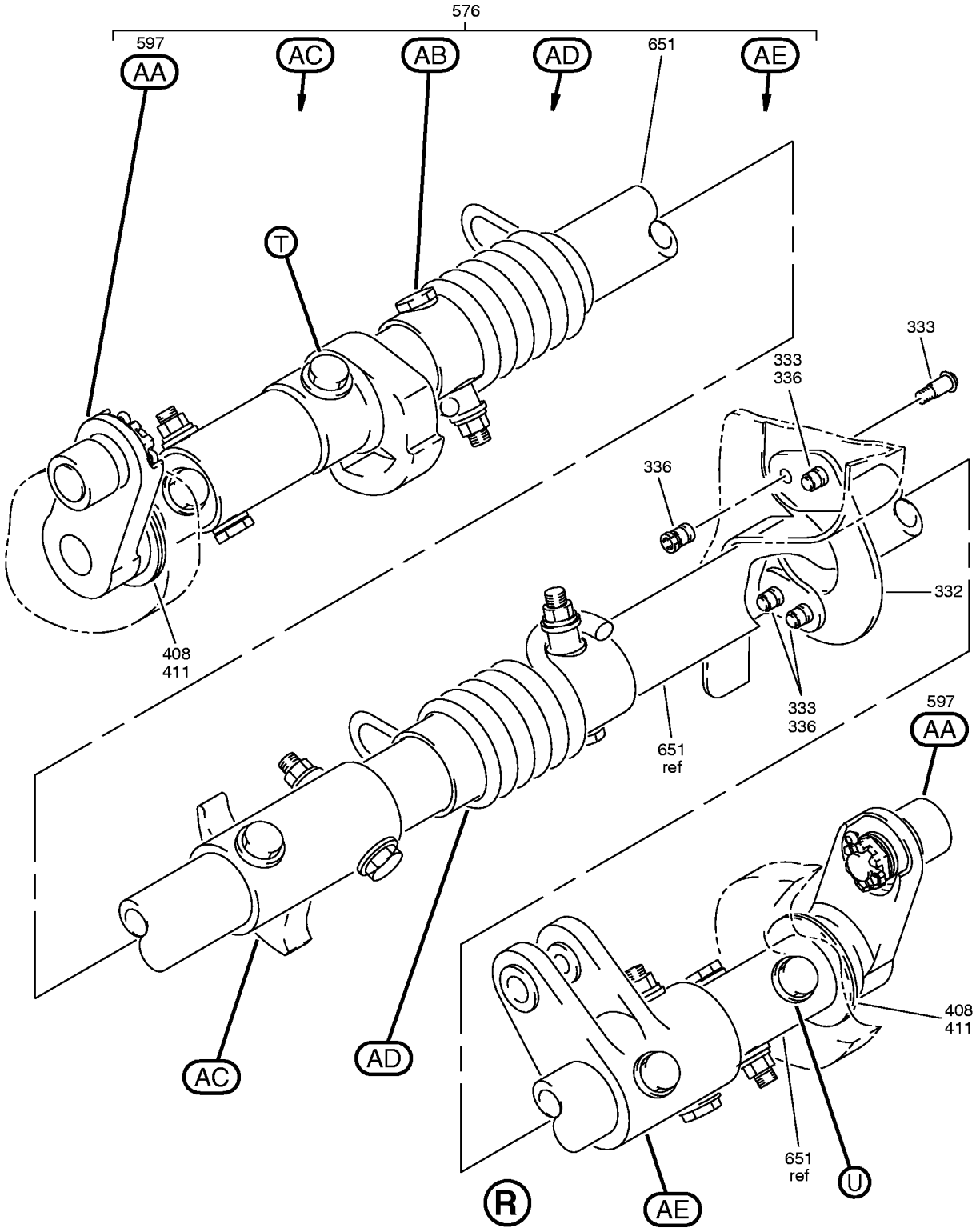
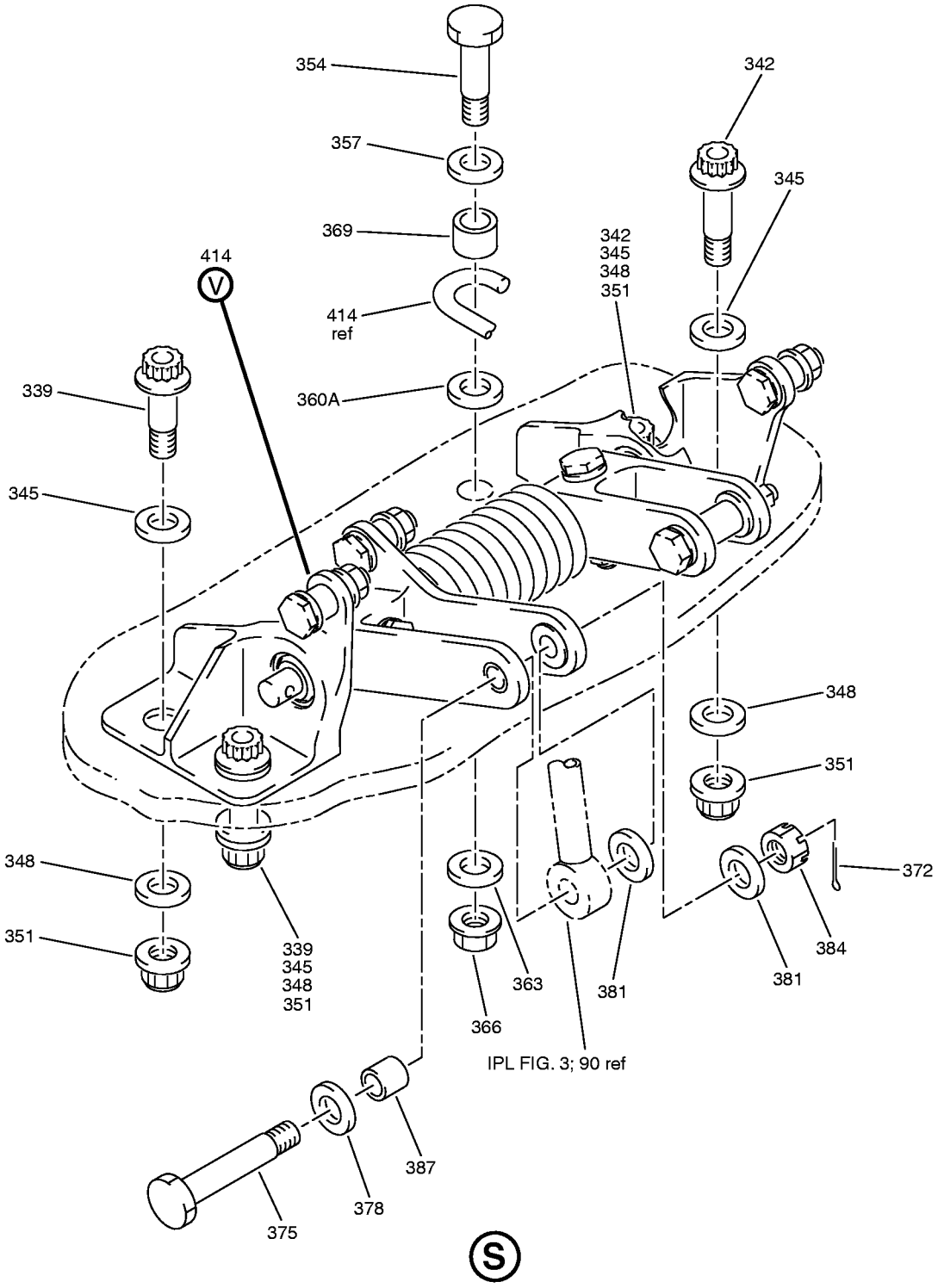
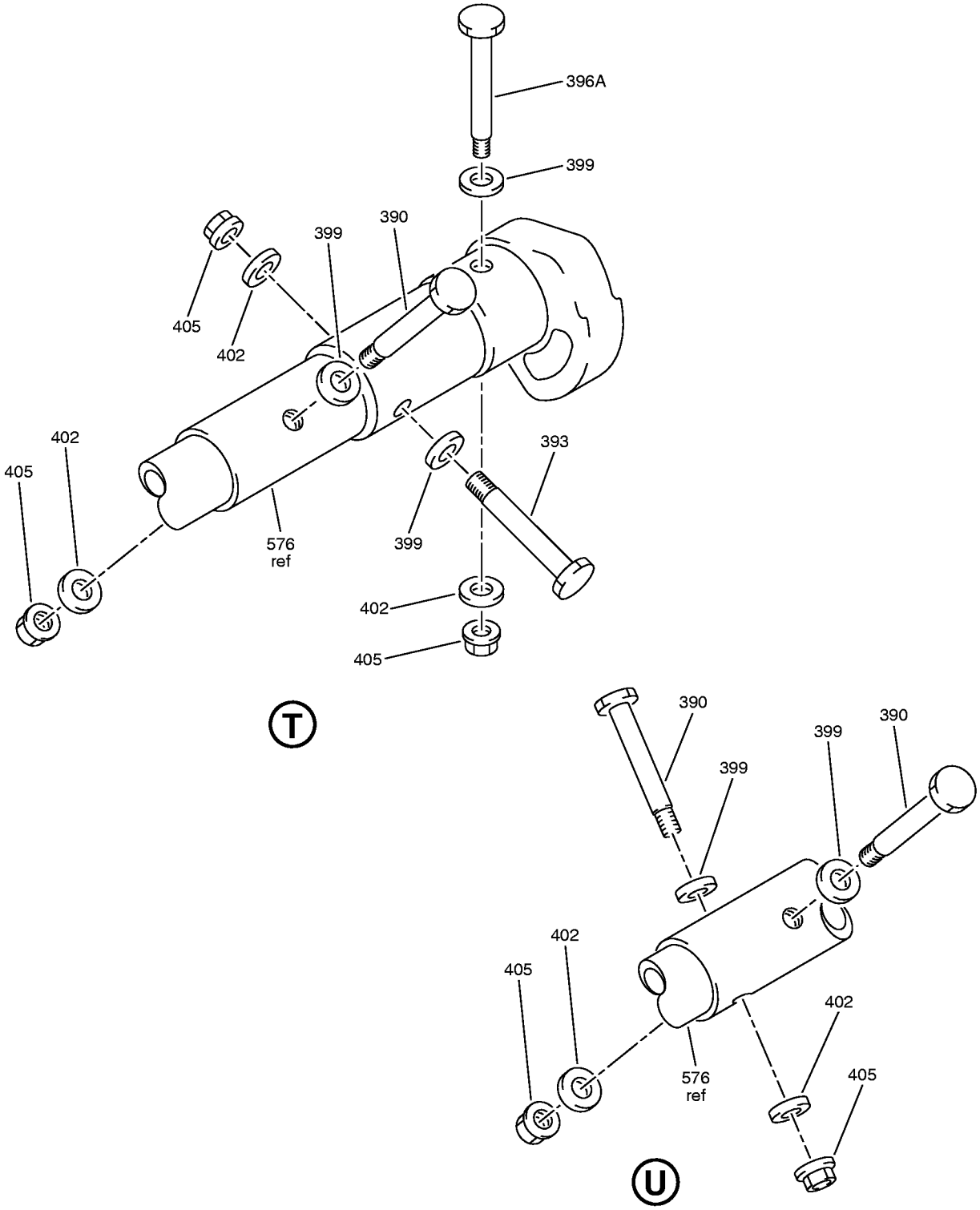
Mechanical Installation
IPL Figure 3 (Sheet 9 of 18)



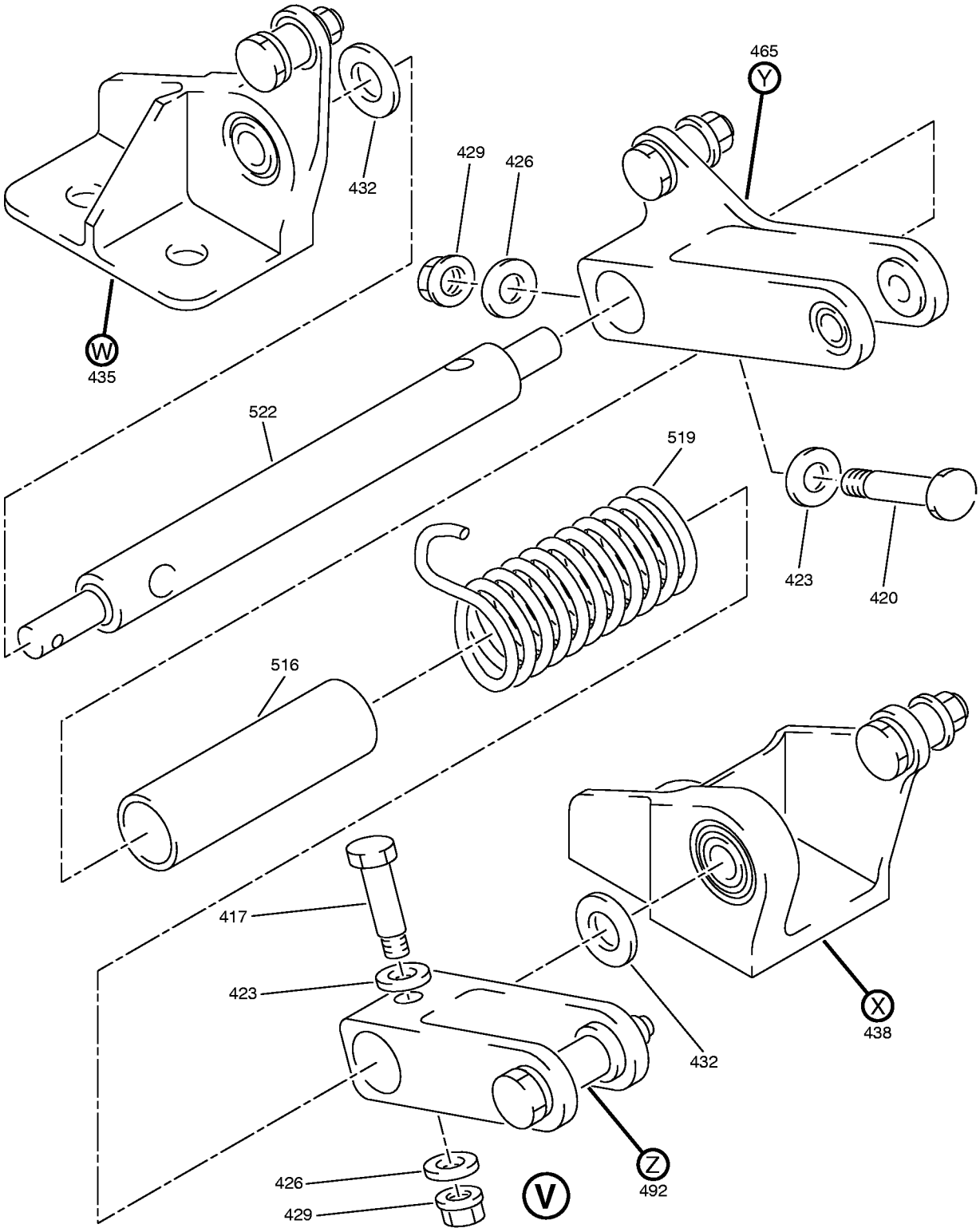
Mechanical Installation
IPL Figure 3 (Sheet 10 of 18)



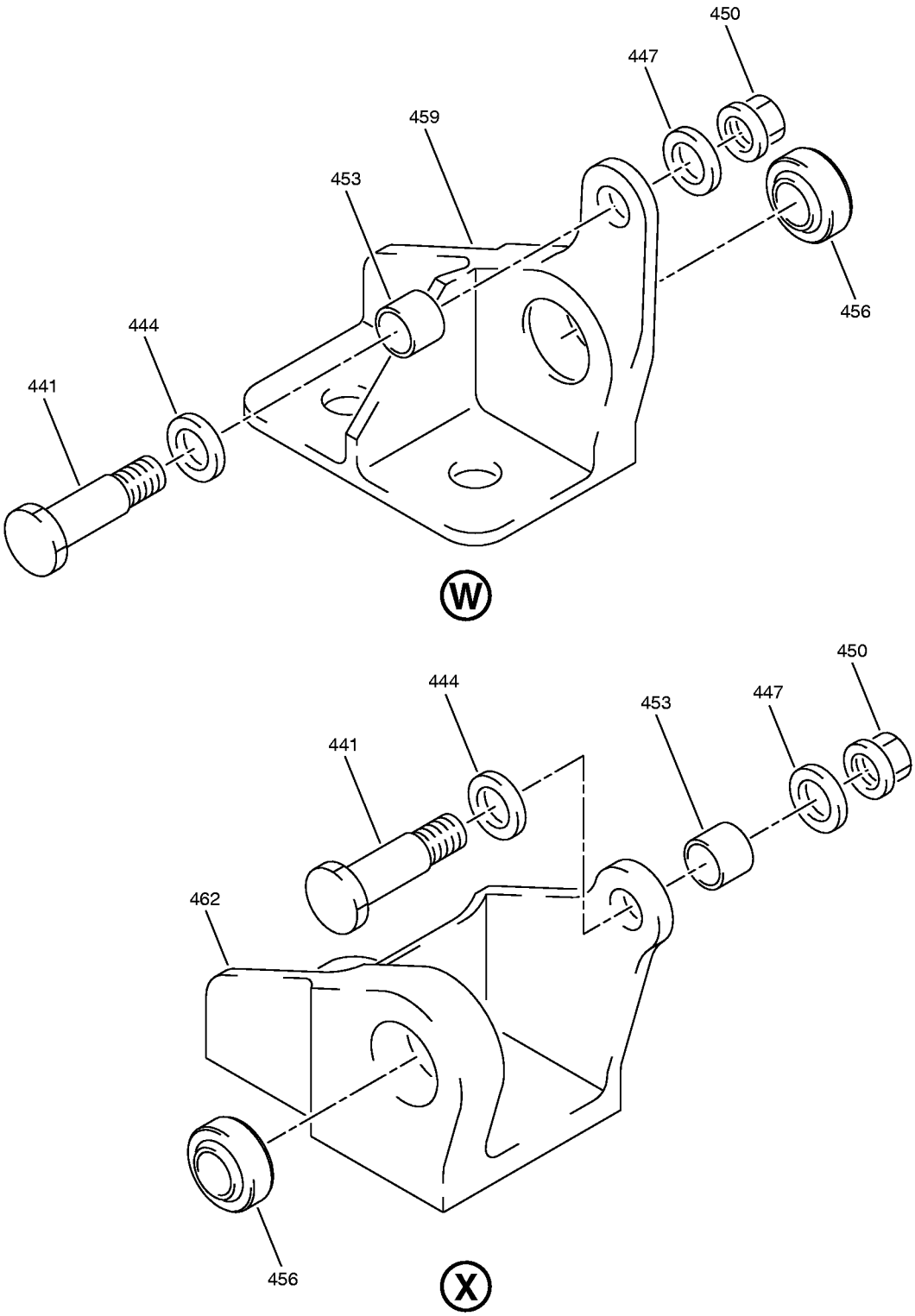
Mechanical Installation
IPL Figure 3 (Sheet 11 of 18)



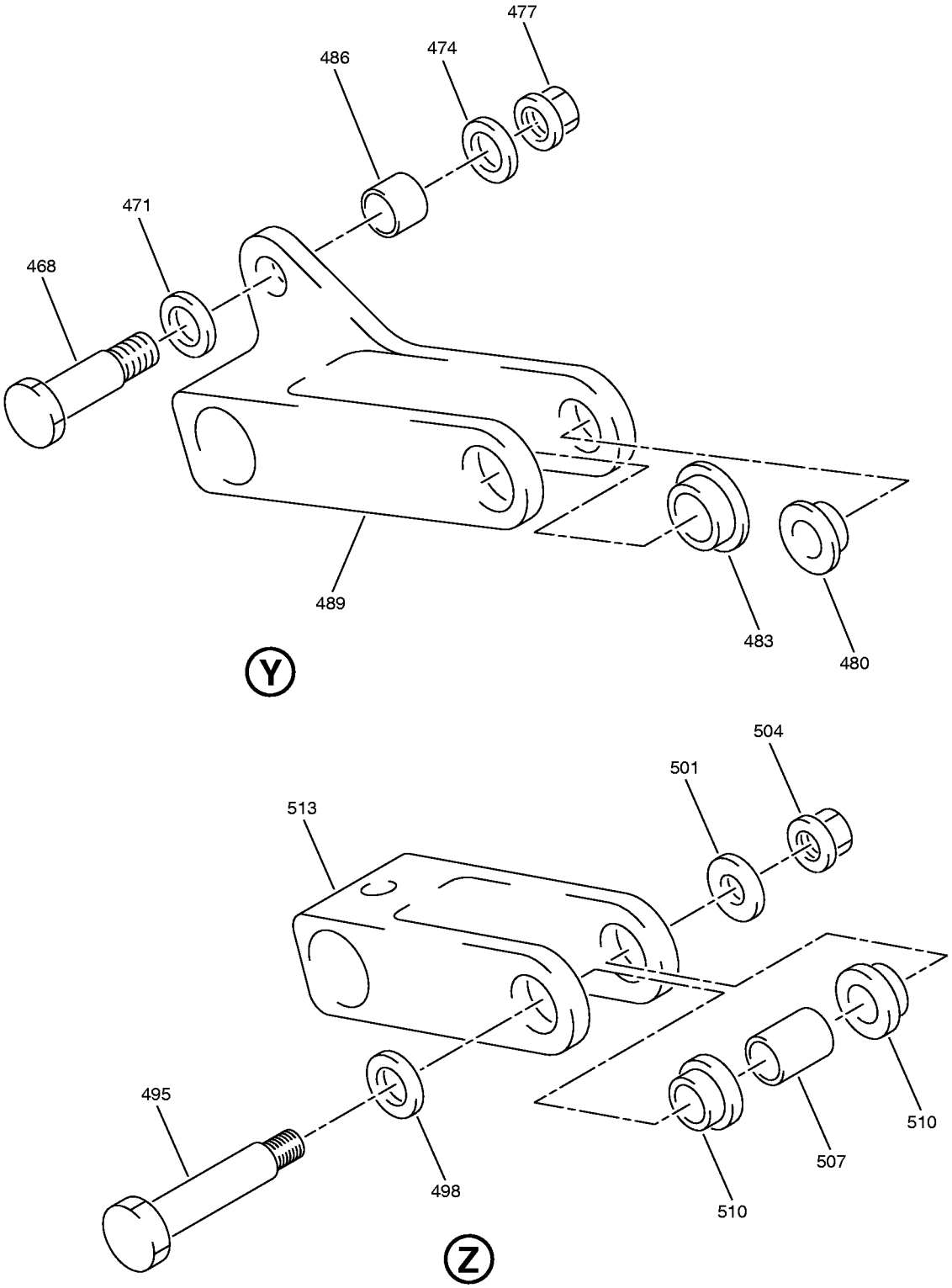
Mechanical Installation
IPL Figure 3 (Sheet 12 of 18)



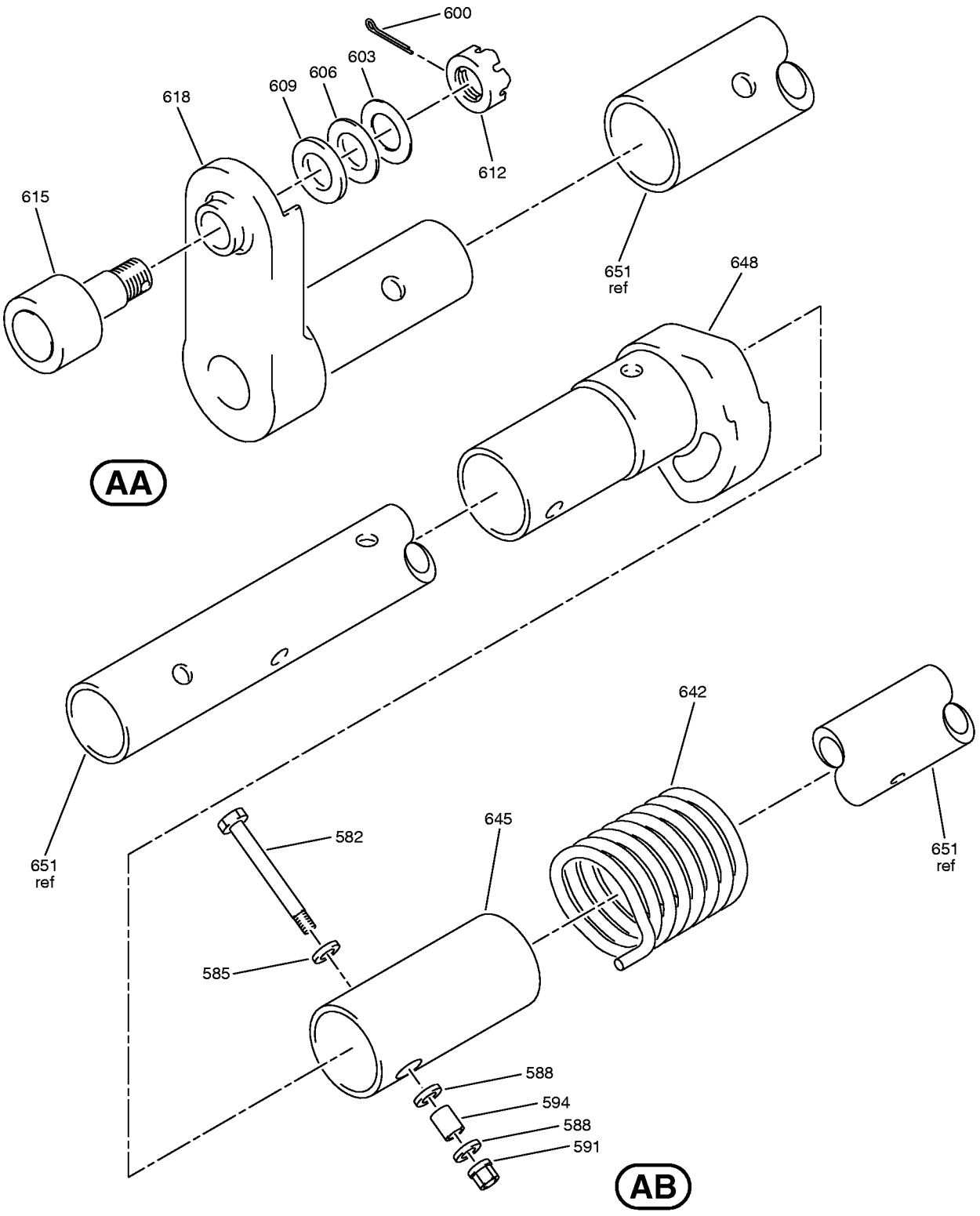
Mechanical Installation
IPL Figure 3 (Sheet 13 of 18)



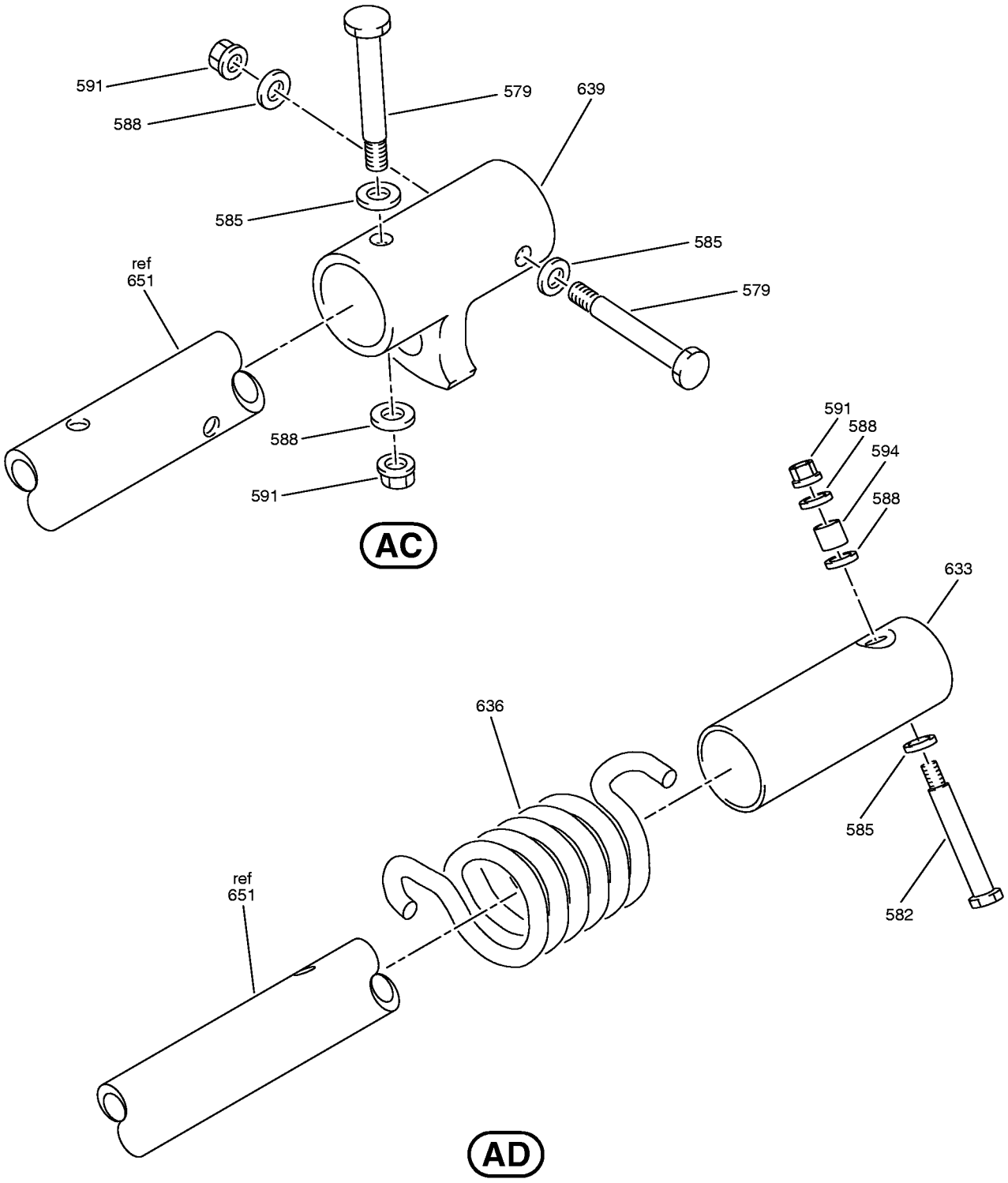
Mechanical Installation
IPL Figure 3 (Sheet 14 of 18)



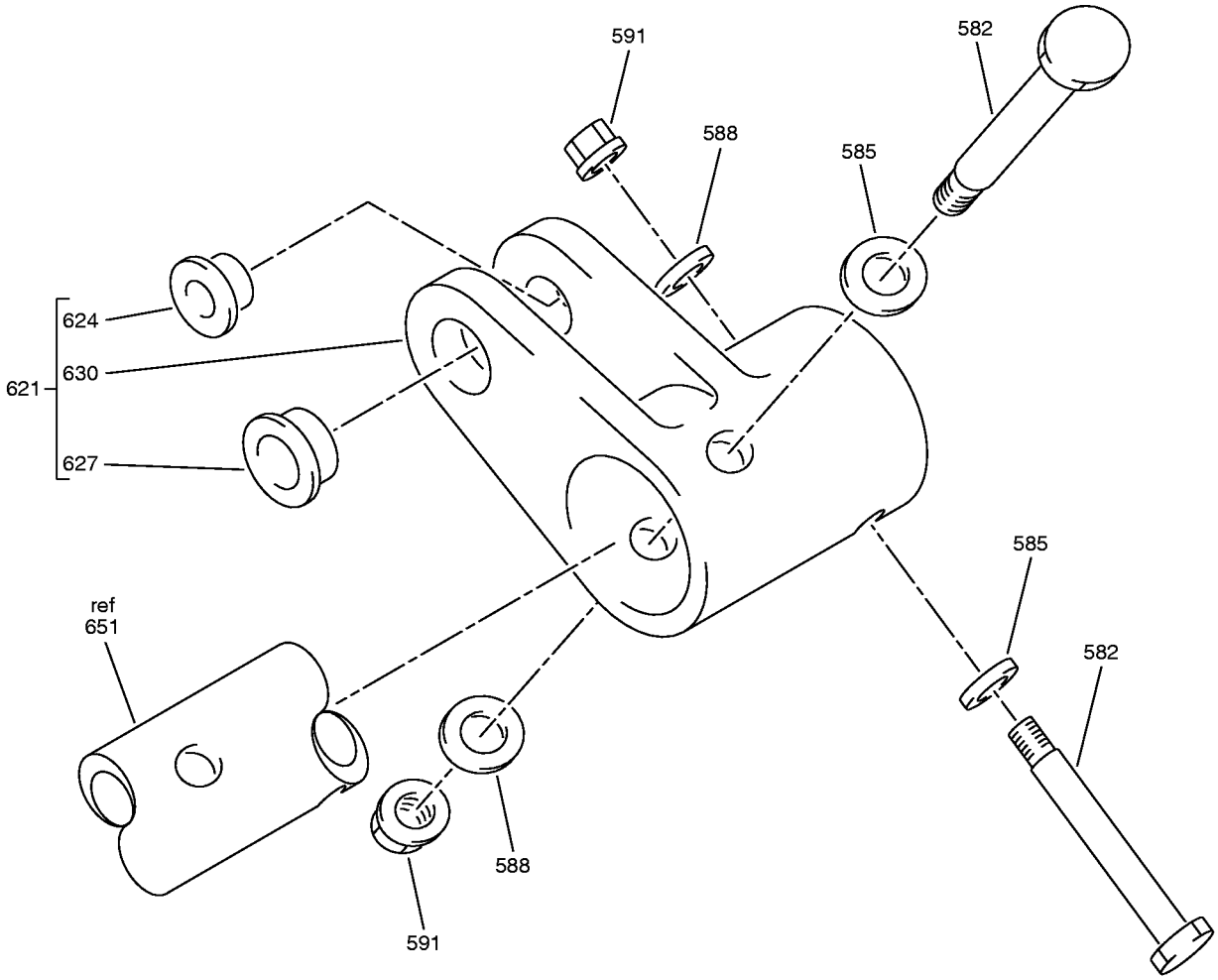
Mechanical Installation
IPL Figure 3 (Sheet 15 of 18)



Mechanical Installation
IPL Figure 3 (Sheet 16 of 18)



Mechanical Installation
IPL Figure 3 (Sheet 17 of 18)



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Mechanical Installation
IPL Figure 3 (Sheet 18 of 18)

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
3–					
–1A	M0DREF287699		MECHANICAL INSTL (LIMITED USAGE) (146A6500-3REVA)	A	RF
–1B	M0DREF295479		MECHANICAL INSTL (LIMITED USAGE) (146A6500-3REVB)	A	RF
–1C	M0DREF297445		MECHANICAL INSTL (LIMITED USAGE) (146A6500-3REVC)	A	RF
–3	M0DREF287699		MECHANICAL INSTL (LIMITED USAGE) (146A6500-4REVA)	B	RF
–3A	M0DREF295480		MECHANICAL INSTL (LIMITED USAGE) (146A6500-4REVB)	B	RF
–3B	M0DREF297446		MECHANICAL INSTL (LIMITED USAGE) (146A6500-4REVC)	B	RF
6	BACP18BC02A05P		. PIN-COTTER		1
9	BACB30NT4DK17		. BOLT		1
12	BACW10BP4DP		. WASHER		1
15	BACN10JD4CD		. NUT		1
18	BACB28AK04-031		. BUSHING		1
21	BACB30YL6K6		. BOLT		2
24	BACB30YL6K7		. BOLT		2
27	BACC30CQ6CR		. COLLAR		4
30	BACS40R020Y023P		. SHIM		1
33	BACP18BC02A05P		. PIN-COTTER		1
36	BACB30NR4DK38		. BOLT		1
39	BACW10BP4ACU		. WASHER		1
42	BACW10BP4DP		. WASHER		1
45	BACN10JD4CD		. NUT		1
48	BACB28AK04-200		. BUSHING		1
51	BACW10BP4APU		. WASHER		1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
3–					
54	BRH10C4M		. NUT (V52828) (SPEC BACN10JC4CM) (OPT T6C428JM (V11815)) (OPT 97E48 (V80539)) (OPT 109LH9075-4W (V72962)) (OPT VN303D048 (V92215)) (OPT H01-4BAC (V15653)) (OPT NS202101SE048 (V80539))		1
57	KRP146004BT		. BEARING (V50632)		1
60A	BACP18BC04A08P		. PIN-COTTER		1
63A	BACP18BC03A04P		. PIN-COTTER		1
66	NAS1149E0863R		. WASHER		2
69	BACW10BP10APU		. WASHER		1
72	BACN10JD108ASU		. NUT		1
75	BACN10JD110ASU		. NUT		1
78	146A6581-1		. SHAFT-LOCK		1
81	146A6582-1		. SPACER-LOCK SHAFT ASSY		1
84	146A6582-3		. SPACER-LOCK SHAFT ASSY		1
87	146A6582-5		. SPACER-LOCK SHAFT ASSY		1
90	146A6580-1		. CAM ASSY-LOCK		1
93A	BACB28AP05-011		. . BUSHING		2
96	BACB28AT07B022C		. . BUSHING		1
99	146A6580-101		. . CAM		1
102	BACP18BC02A05P		. PIN-COTTER		2
105	BACB30NR4DK28		. BOLT		1
108	BACB30NR4DK27		. BOLT		1
111	BACW10BP4ACU		. WASHER		2
114	BACW10BP4DP		. WASHER		2
117	BACN10JD4CD		. NUT		2
118	BACB28AK04-011		. BUSHING		1
120	146A6577-3		. FITTING ASSY-OVERCENTER SPRING		1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
3–					
123A	WES04B10GC		. . BEARING (V73134) (SPEC BACB10FE04C) (OPT ADW4VNC (V15860)) (OPT KR4CWGBZC (V50632)) (OPT KWDB4-39 (V97613)) (OPT WRRS04B10GC (V73134)) (OPT WHT04VSBC (VS0352))		1
126	146A6577-103		. . FITTING		1
129	146A6577-1		. FITTING ASSY-OVERCENTER SPRING		1
132	BACB10FE4C		. . BEARING		1
135	146A6577-101		. . FITTING		1
138	146A6585-1		. SPRING-OVERCENTER		1
141	146A6583-1		. WASHER		2
144	146A6575-3		. IDLER ASSY-LOCK SHAFT		1
147	BACB28AZ06A065B		. . BUSHING-FLANGED		2
150	BACB28AP04-018		. . BUSHING		1
153	BACB28AT06B018A		. . BUSHING-FLANGED		1
156	146A6575-103		. . IDLER		1
159	146A6576-3		. FITTING ASSY-LOCK		1
162	BACB28AT06B018C		. . BUSHING		1
165	BACB28AX04C018		. . BUSHING		1
168	146A6576-103		. . FITTING		1
171	WC331K5-5		. BOLT (V60516) (SPEC BACB30YP5K5)		2
174	HST79CY5		. COLLAR (V73197) (SPEC BACC30BL5) (OPT HST79-5 (V92215)) (OPT HST79CY5 (V56878)) (OPT HST79CY5 (V5M902))		2
175	146A6586-3		. FITTING-LOCK		1
177	MS24586C65		. SPRING		2
180	BACP18BC02A06P		. PIN		1
183	BACB30NR5DK29		. BOLT		1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
3–					
186	BACW10BP5ACU		. WASHER		1
189	BACW10BP5APU		. WASHER		1
192	BACN10JD5ASU		. NUT		1
195	BACB28AK05-037		. BUSHING		1
198	BACB28AK05-055		. BUSHING		1
199	146A6579-1		. TARGET ASSY-LOCK		1
199J	BACB28BC07A052B		. . BUSHING		1
200A	146A6579-101		. . TARGET		1
201	BACB30NT3K4		. BOLT		2
204	BACW10BP3NAPU		. WASHER		2
207	146A6586-1		. FITTING-LOCK		1
–210	HL1012AZ6-7		. BOLT (V97928) (SPEC BACB30NX6K7) (OPT HL12VAZ6-7 (V73197)) (OPT HL12VAZ6-7 (V92215)) (OPT HL12VAZ6-7 (V97928)) (OPT L802-6K7 (V06725)) (OPT HL12VAZ6-7 (V56878)) (OPT HL1012AZ6-7 (V0PTK6)) (OPT HL1012AZ6-7 (V06725)) (OPT HL1012AZ6-7 (V06950)) (OPT HL1012AZ6-7 (V17446)) (OPT HL1012AZ6-7 (V56878)) (OPT HL1012AZ6-7 (V60516)) (OPT HL1012AZ6-7 (V73197))		1
–213	HL1012AZ6-5		. BOLT (V97928) (SPEC BACB30NX6K5) (OPT HL12VAZ6-5 (V73197)) (OPT HL12VAZ6-5 (V92215)) (OPT HL12VAZ6-5 (V97928)) (OPT L802-6K5 (V06725)) (OPT HL12VAZ6-5 (V56878)) (OPT HL1012AZ6-5 (V0PTK6)) (OPT HL1012AZ6-5 (V06725)) (OPT HL1012AZ6-5 (V06950)) (OPT HL1012AZ6-5 (V17446)) (OPT HL1012AZ6-5 (V56878)) (OPT HL1012AZ6-5 (V60516)) (OPT HL1012AZ6-5 (V73197))		1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
3–					
–216	HL1087DU6		. COLLAR (V9N513) (SPEC BACC30BH6S) (OPT HL1087DU6 (V92215)) (OPT HL1087DU6 (V73197)) (OPT HL1087DU6 (V56878))		2
219	BACB30YL6K6		. BOLT		4
222	BACN10YT3CD		. NUT		4
225	BACS12HN5-14D		. SCREW		1
228	BACN11U5CD2		. NUT		2
231	146A6580-3		. CAM ASSY-LOCK		1
232	BACB28AX04B053		. . BUSHING-FLANGED		2
233	146A6580-103		. . CAM		1
234	BACP18BC02A05P		. PIN-COTTER		2
237	BACB30NR4DK20		. BOLT		2
240	BACW10BP4ACU		. WASHER		2
243	BACW10BP4APU		. WASHER		1
246	BACW10BP4DP		. WASHER		1
249	BACN10JD4AU		. NUT		1
252	BACN10JD4CD		. NUT		1
255	BACB28AK04-037		. BUSHING		2
258	BACP18BC03A10P		. PIN-COTTER		1
261	BCREF51180		. BEARING (BACB10HS06ARBSP2)		1
264	BACW10BP6DP		. WASHER		1
267	BACN10JD6CD		. NUT		1
270	BACP18BC02A06P		. PIN-COTTER		1
273	BACB30NR5DK29		. BOLT		1
276	BACW10BP5ACU		. WASHER		1
279	BACW10BP5APU		. WASHER		1
282	BACN10JD5CD		. NUT		1
285	BACB28AK05-155		. BUSHING		1
288	146A6575-1		. IDLER ASSY		1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
3–					
291	BACB28AZ07A056B		. . BUSHING		2
294	BACB28AP04-022		. . BUSHING		1
297	BACB28AT06B022A		. . BUSHING		1
300	146A6575-101		. . IDLER		1
303	146A6576-1		. FITTING ASSY		1
306	BACB28AT07C015A		. . BUSHING		1
309	BACB28AX05B014		. . BUSHING (OPT ITEM 309A)		1
–309A	BACB28AX05C014		. . BUSHING (OPT ITEM 309)		1
312	146A6576-101		. . FITTING		1
315	146A6578-1		. LINK ASSY		1
318	WES04B10GC		. . BEARING (V73134) (SPEC BACB10FE04C) (OPT ADW4VNC (V15860)) (OPT KR4CWGBZC (V50632)) (OPT KWDB4-39 (V97613)) (OPT WRRS04B10GC (V73134)) (OPT WHT04VSBC (VS0352))		2
321	146A6578-101		. . LINK		1
324	146A6587-1		. FITTING-STOP		1
327	HST10AG8-5		. BOLT (V0PTK6) (SPEC BACB30VT8K5) (OPT HST10AG8-5 (V06725)) (OPT HST10AG8-5 (V56878)) (OPT HST10AG8-5 (V73197))		6
330	HST79CY8		. COLLAR (V73197) (SPEC BACC30BL8) (OPT HST79-8 (V92215)) (OPT HST79CY8 (V56878)) (OPT HST79CY8 (V5M902))		6
332	146A6435-105		. PLATE-SHAFT RETENTION		1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
3–			ATTACHING PARTS		
333	HST10AG5-3		. BOLT (V0PTK6) (SPEC BACB30VT5K3) (OPT HST10AG5-3 (V06725)) (OPT HST10AG5-3 (V56878)) (OPT HST10AG5-3 (V73197))		4
336	HST79CY5		. COLLAR (V73197) (SPEC BACC30BL5) (OPT HST79-5 (V92215)) (OPT HST79CY5 (V56878)) (OPT HST79CY5 (V5M902)) - - - - - - - * - - - - - - -		4
339	BACB30MR4A6		. BOLT		2
342	BACB30MR4A10		. BOLT		2
345	BACW10BP4CD		. WASHER		4
348	BACW10BP4DP		. WASHER		4
351	BACN11Z4CD		. NUT		4
354	BACB30NR4K9		. BOLT		1
357	BACW10BP4AC		. WASHER		1
360A	BACW10P435CG		. WASHER		1
363	BACW10BN4AP		. WASHER		1
366	PLH54CD		. NUT (V62554) (SPEC BACN10YR4CD) (OPT H52732-4CD (V15653))		1
369	BACB28AK04-030		. BUSHING		1
372	BACP18BC02A05P		. PIN-COTTER		1
375	BACB30NR4DK18		. BOLT		1
378	BACW10BP4AC		. WASHER		1
381	BACW10BP4AP		. WASHER		2
384	BACN10JD4CD		. NUT		1
387	BACB28AK04-035		. BUSHING		1
390	BACB30NR4K18		. BOLT		3
393	BACB30NR4K20		. BOLT		1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
3–					
396A	BACB30NR4K22		. BOLT		1
399	BACW10BP4ACU		. WASHER		5
402	BACW10BP4APU		. WASHER		5
405	PLH54CM		. NUT (V62554) (SPEC BACN10YR4CM) (OPT H52732-4CM (V15653))		5
408	NAS1149C1616R		. WASHER		2
411	NAS1149C1632R		. WASHER		2
414	146A6509-1		. MECHANISM ASSY-PRESSURE LOCK		1
417	BACB30NR4K13		. . BOLT		1
420	BACB30NR4K14		. . BOLT		1
423	BACW10BP4ACU		. . WASHER		2
426	BACW10BP4APU		. . WASHER		2
429	PLH54CM		. . NUT (V62554) (SPEC BACN10YR4CM) (OPT H52732-4CM (V15653))		2
432	BACW10BP6ACU		. . WASHER		2
435	146A6512-1		. . HOUSING ASSY-BEARING		1
438	146A6512-3		. . HOUSING ASSY-BEARING		1
441	BACB30NR4K7		. . . BOLT		1
444	BACW10BP4ACU		. . . WASHER		1
447	BACW10BP4APU		. . . WASHER		1
450	PLH54CD		. . . NUT (V62554) (SPEC BACN10YR4CD) (OPT H52732-4CD (V15653))		1
453	BACB28AK04-030		. . . BUSHING		1
456	BACB10FB05C		. . . BEARING		1
459	146A6512-101		. . . HOUSING (USED ON ITEM 435)		1
462	146A6512-103		. . . HOUSING (USED ON ITEM 438)		1
465	146A6510-3		. . CRANK ASSY		1

–Item not Illustrated

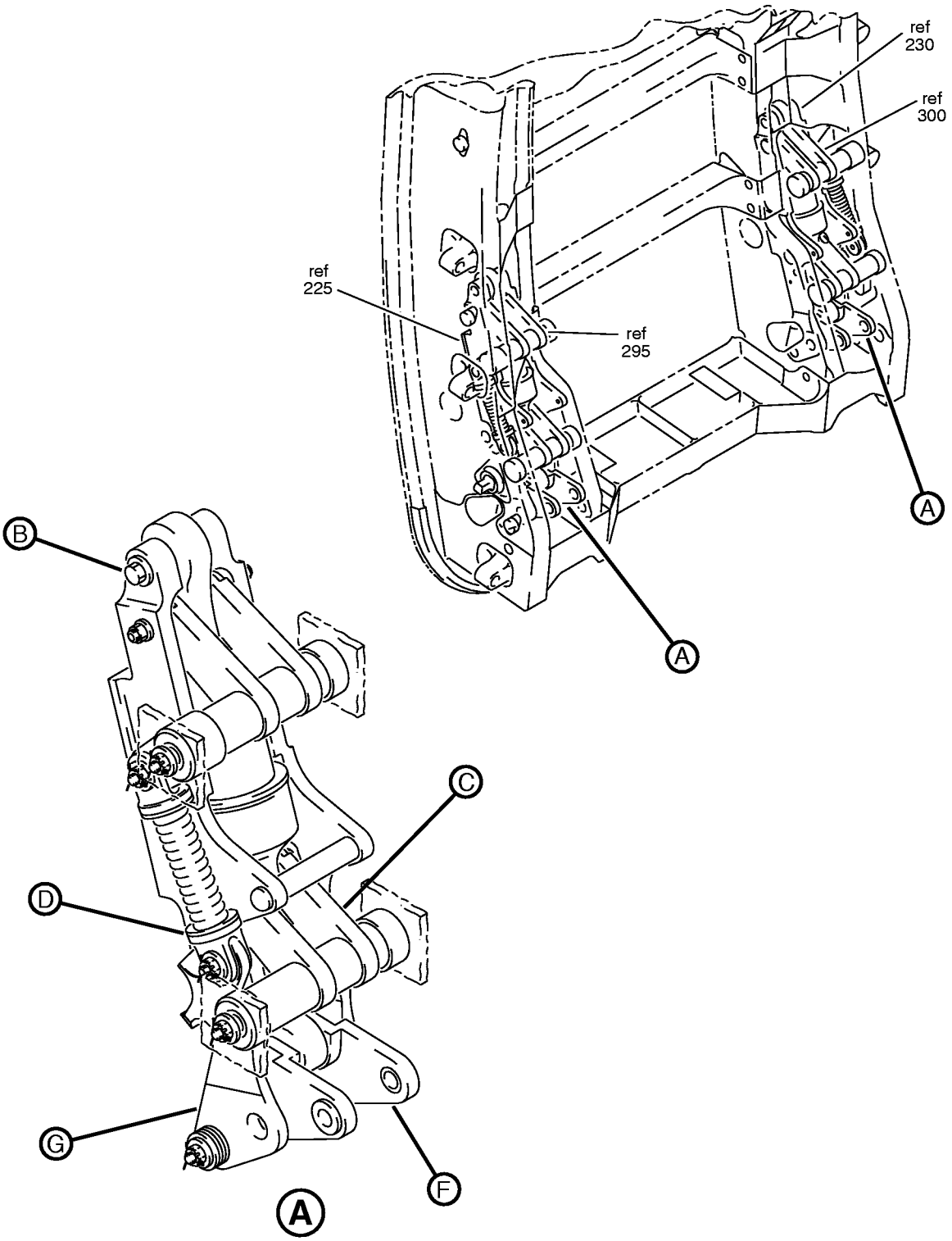
FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
3–					
468	BACB30NR4K8		. . . BOLT		1
471	BACW10BP4ACU		. . . WASHER		1
474	BACW10BP4APU		. . . WASHER		2
477	PLH54CM		. . . NUT (V62554) (SPEC BACN10YR4CM) (OPT H52732-4CM (V15653))		1
480	BACB28AP04-014		. . . BUSHING		1
483	BACB28AT06B014A		. . . BUSHING		1
486	BACB28AK04-025		. . . BUSHING		1
489	146A6510-103		. . . CRANK		1
492	146A6510-1		. . CRANK ASSY		1
495	BACB30PW4U18		. . . BOLT		1
498	BACW10BP4ACU		. . . WASHER		1
501	NAS1149E0363R		. . . WASHER		1
504	PLH53CM		. . . NUT (V62554) (SPEC BACN10YR3CM) (OPT H52732-3CM (V15653))		1
507	BACB28AK04-055		. . . BUSHING		1
510	BACB28AP04-014		. . . BUSHING		2
513	146A6510-101		. . . CRANK		1
516	146A6568-5		. . SLEEVE-TORSION SPRING		1
519	146A6511-5		. . SPRING-TORSION		1
522	146A6545-3		. . SHAFT		1
525	146A6516-1		. LOCK ASSY-FLIGHT (FOR DETAILS SEE CMM 52-21-04)		1
528	BACB30LE5K45		DELETED		
531	BACW10DS5S		DELETED		
534	BACW10BP5DP		DELETED		
537	PLH55CD		DELETED		
540	SSMKP5ASD524		DELETED		
543	BACB30NM3K10		DELETED		
546A	BACW10DS3S		DELETED		

–Item not Illustrated

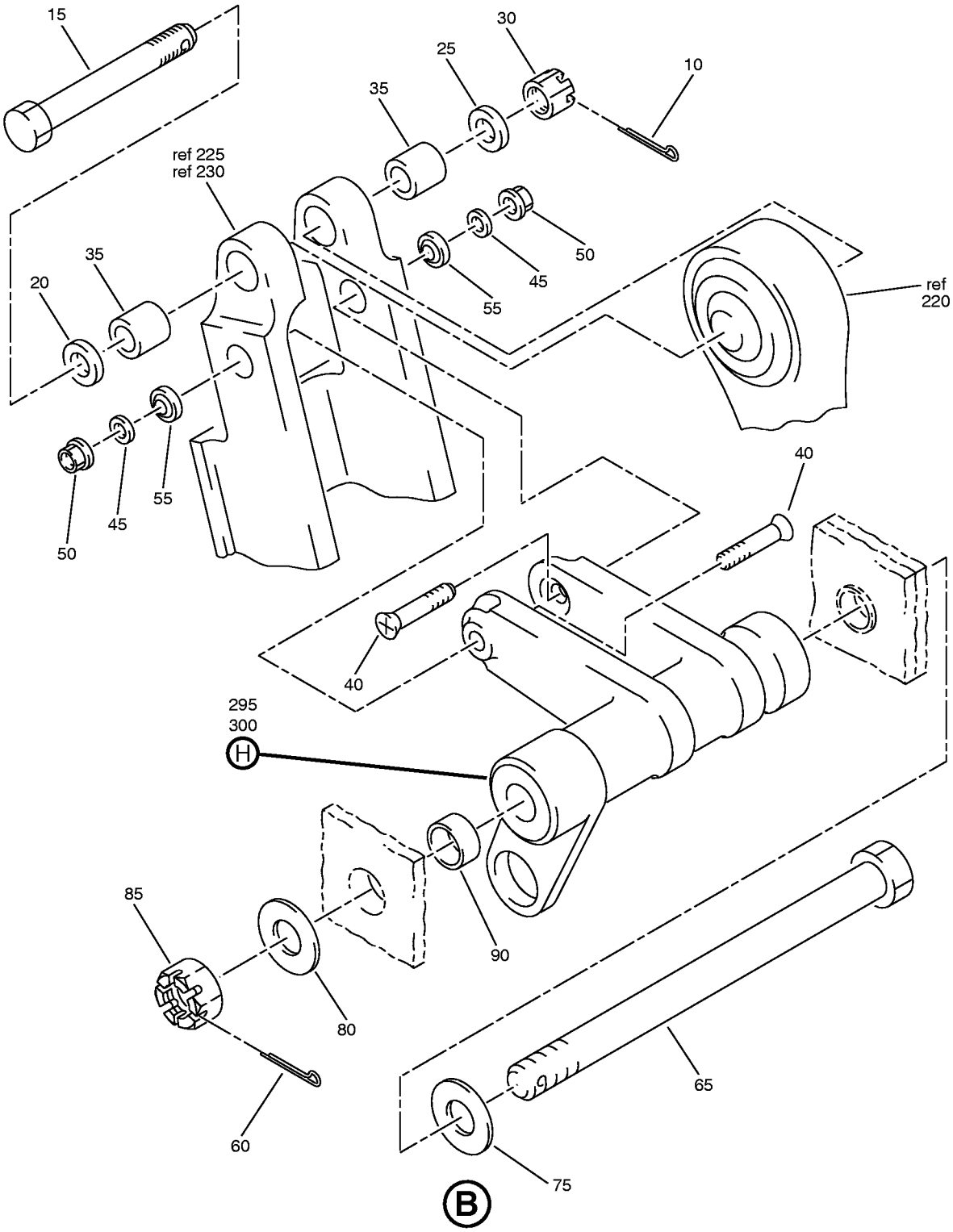
FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
3–					
549	BACW10BP3NDP		DELETED		
552	NAS43DD3-32FC		DELETED		
555	PLH53CD		DELETED		
558	MS24586C59		DELETED		
561	258A4704-1		DELETED		
564	BACB28AK05-006		DELETED		
567	258A4703-2		DELETED		
570	PACMKP16BSF˜ S428		DELETED		
573	146A6517-1		DELETED		
576	146A6520-1		. SHAFT ASSY-LATCH		1
579	BACB30NR4K22		. . BOLT		2
582	BACB30NR4K24		. . BOLT		4
585	BACW10BP4ACU		. . WASHER		6
588	BACW10BP4APU		. . WASHER		8
591	PLH54CM		. . NUT (V62554) (SPEC BACN10YR4CM) (OPT H52732-4CM (V15653))		6
594	BACB28AK04-030		. . BUSHING		2
597	146A6522-1		. . CRANK ASSY-LATCH		2
600	BACP18BC03A10P		. . . PIN-COTTER		1
603	NAS1149E0616R		. . . WASHER		1
606	NAS1149E0632R		. . . WASHER		1
609	NAS1149E0663R		. . . WASHER		1
612	BACN10JD106AU		. . . NUT		1
615	BCREF50875		. . . BEARING (BACB10HS06ARNSP6)		1
618	146A6522-101		. . . CRANK		1
621	146A6524-1		. . CRANK ASSY-HANDLE		1
624	BACB28AP04-022		. . . BUSHING		1
627	BACB28AT06B022A		. . . BUSHING		1
630	146A6524-101		. . . CRANK		1

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
3–					
633	146A6568-2		. . SLEEVE-TORSION SPRING		1
636	146A6511-4		. . SPRING-TORSION		1
639	146A6523-1		. . CATCH-VENT LOCK		1
642	146A6511-3		. . SPRING-TORSION		1
645	146A6568-1		. . SLEEVE-TORSION SPRING		1
648	146A6523-3		. . CATCH-FLIGHT LOCK		1
651	146A6521-1		. . SHAFT		1

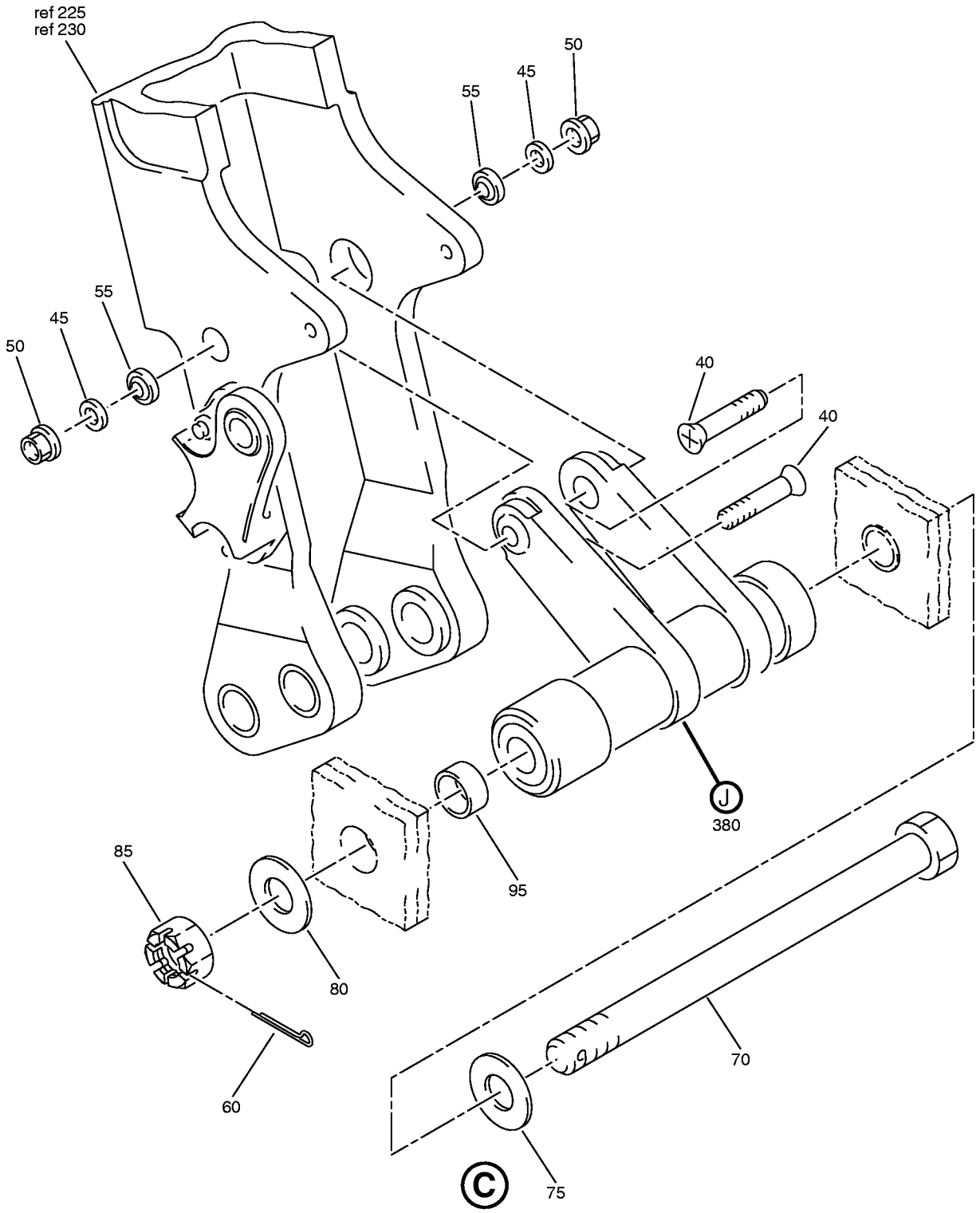
–Item not Illustrated



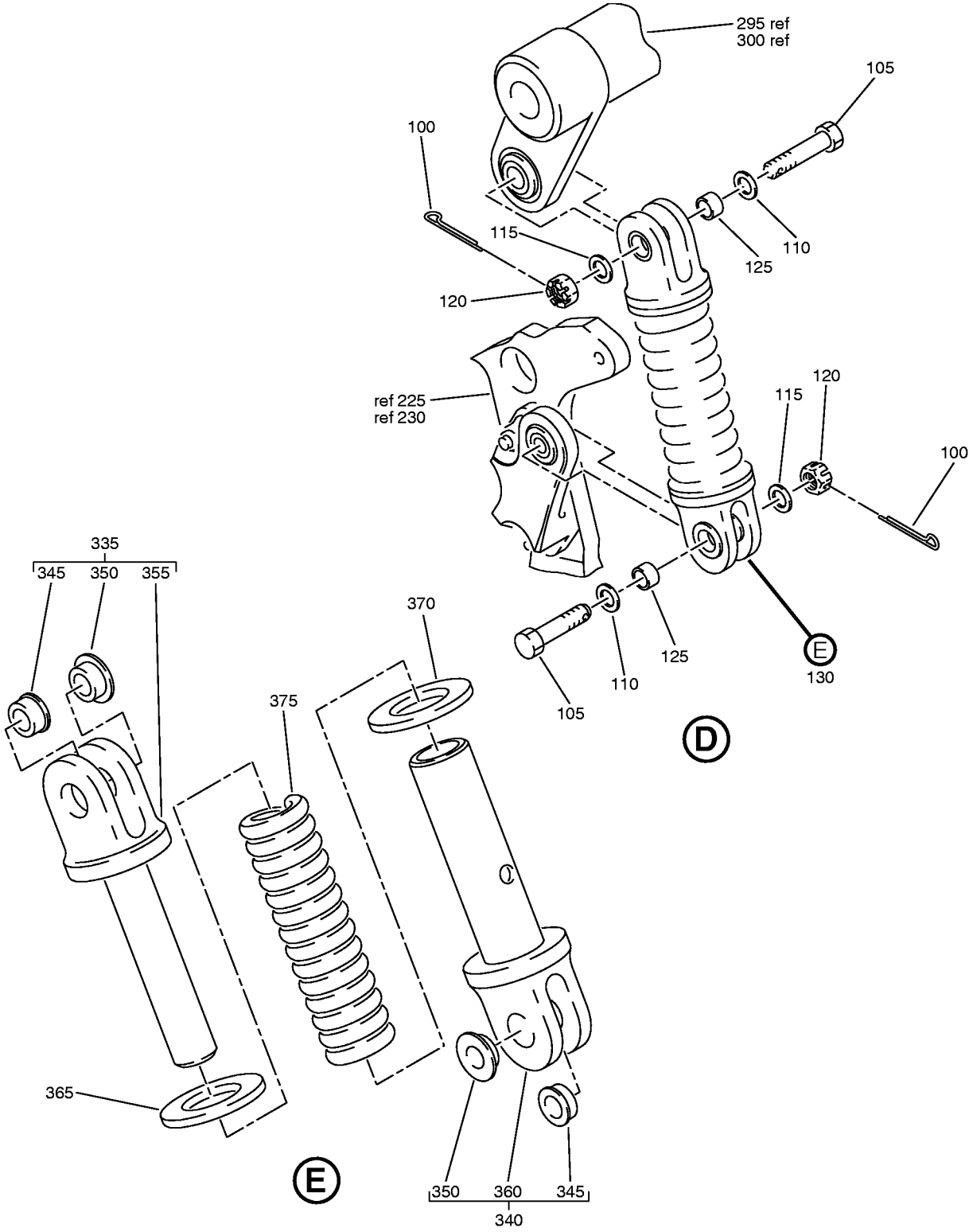
Mechanical Installation
IPL Figure 4 (Sheet 1 of 7)



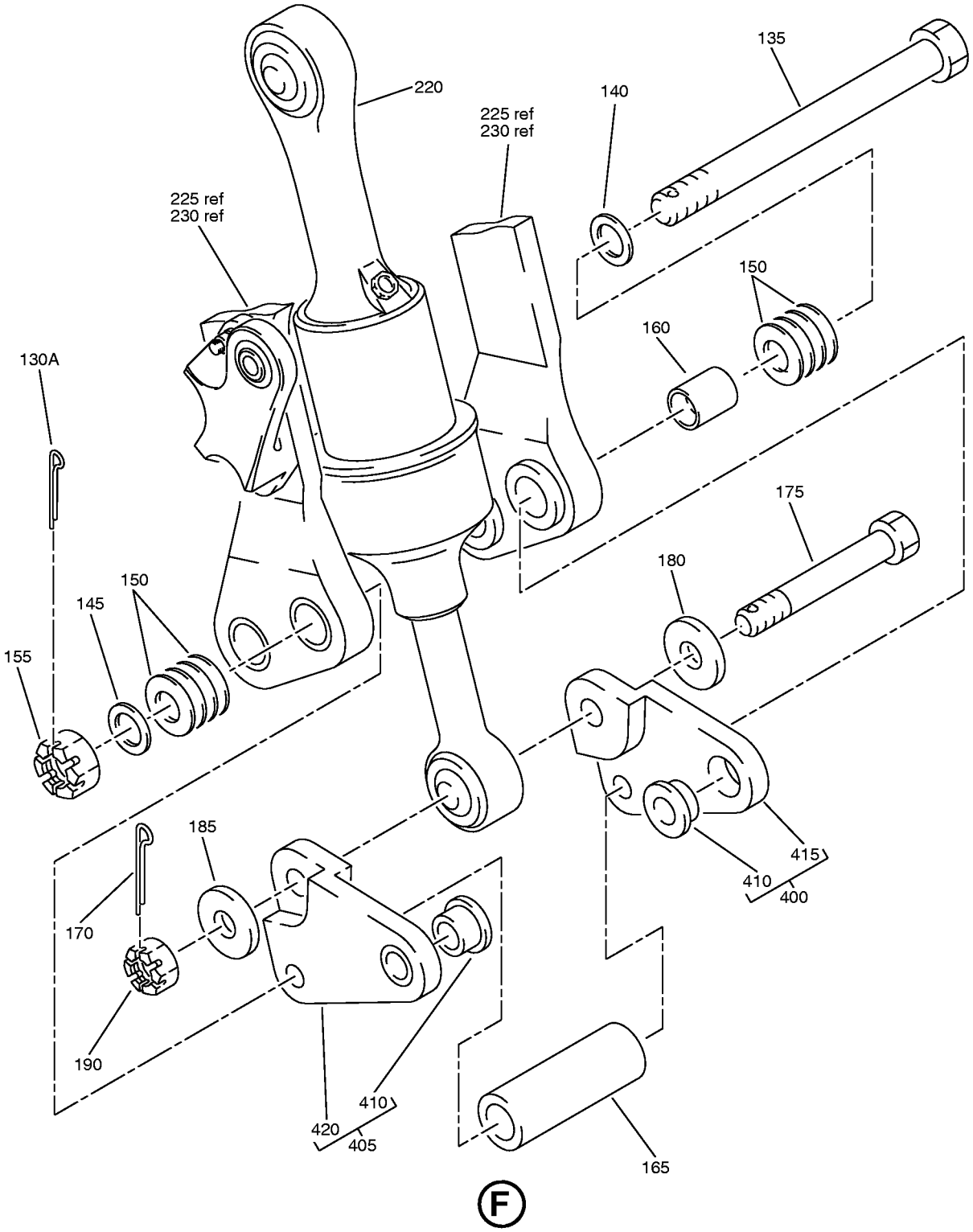
Mechanical Installation
IPL Figure 4 (Sheet 2 of 7)



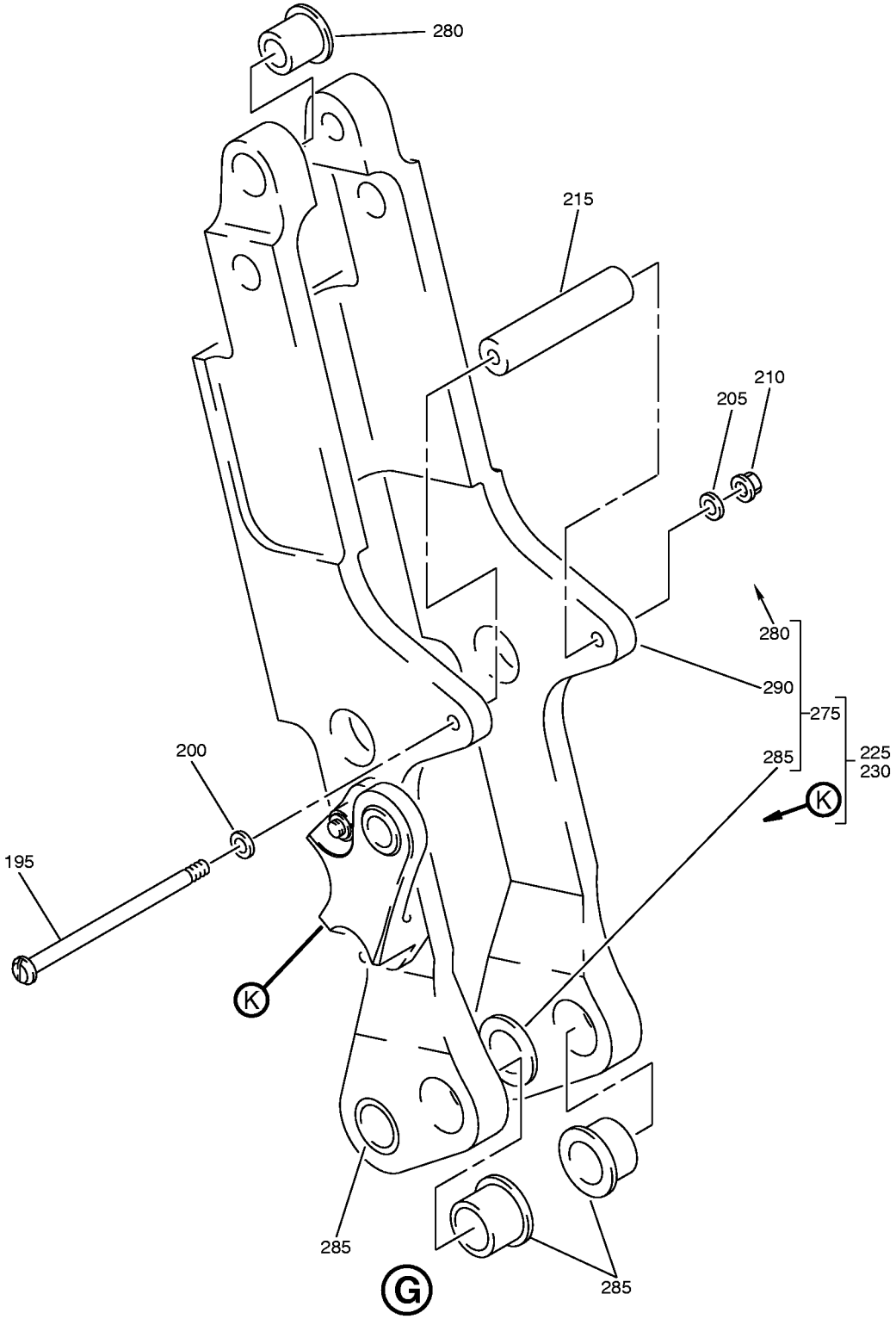
Mechanical Installation
IPL Figure 4 (Sheet 3 of 7)



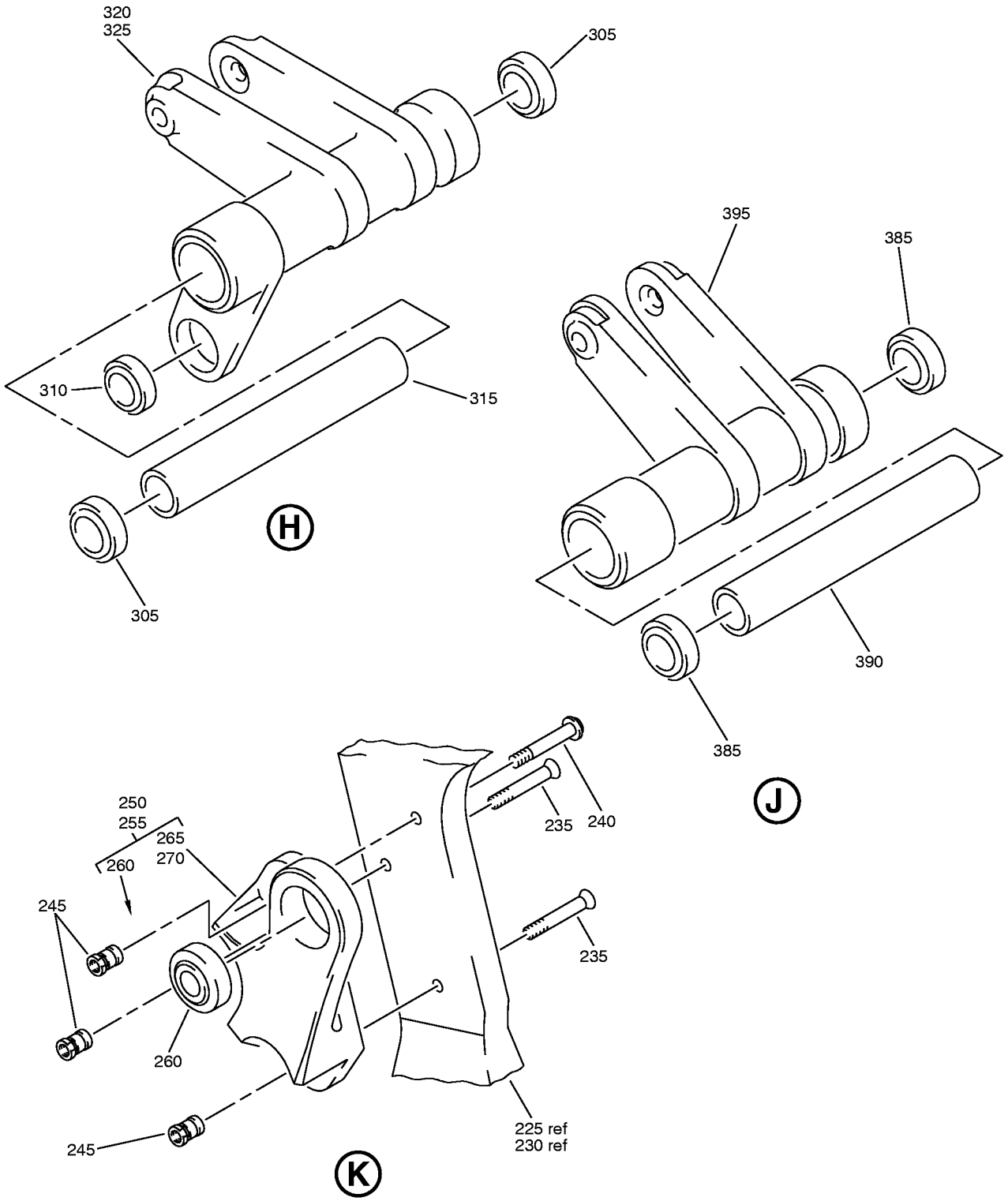
Mechanical Installation
IPL Figure 4 (Sheet 4 of 7)



Mechanical Installation
IPL Figure 4 (Sheet 5 of 7)



Mechanical Installation
IPL Figure 4 (Sheet 6 of 7)



Mechanical Installation
IPL Figure 4 (Sheet 7 of 7)

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
4–					
–1A	M0DREF287697		MECHANICAL INSTL (146A6500-1REVA)	A	RF
–5	M0DREF287698		MECHANICAL INSTL (146A6500-2REVA)	B	RF
10	BACP18BC03A05P		. PIN-COTTER		2
15	BACB30NR6DK33		. BOLT		2
20	BACW10BP6CD		. WASHER		2
25	BACW10BP6DP		. WASHER		2
30	BACN10BP6CD		. NUT		2
35	BCREF51111		. BUSHING (BACB28BG06A06381)		2
40	BACB30LH4-10		. BOLT		8
45	BACW10BP4CD		. WASHER		8
50	PLH54CD		. NUT (V62554) (SPEC BACN10YR4CD) (OPT H52732-4CD (V15653))		8
55	ACMKP3AFS428		. BEARING (V21335) (SPEC BACB10FS04J) (OPT PACMKP04JAA3908 (V21335)) (OPT SSMKP04JASD705 (V83086)) (OPT SSMKP4ASD524 (V50294)) (OPT SSMKP04AP (V21760)) (OPT PACMKP04JAFS428 (V21335)) (OPT ACMKP04JAP510LY (V40920))		8
60	BACP18BC02A04P		. PIN-COTTER		4
65	BACB30NR5DK84		. BOLT		2
70	BACB30NR5DK88		. BOLT		2
75	BACW10BP5CD		. WASHER		4
80	BACW10BP5DP		. WASHER		4
85	BACN10JD5CD		. NUT		4
90	BACB28AK05-038		. BUSHING		2
95	BACB28AK05-055		. BUSHING		2
100	BACP18BC02A03P		. PIN-COTTER		4

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
4–					
105	BACB30NR4DK13		. BOLT		4
110	BACW10BP4ACU		. WASHER		4
115	BACW10BP4APU		. WASHER		4
120	BACN10JD104CD		. NUT		4
125	BACB28AK04-026		. BUSHING		4
130A	BACP18BC02A04P		. PIN-COTTER		2
135	BACB30NR5DK42		. BOLT		2
140	BACW10BP5CD		. WASHER		2
145	BACW10BP5DP		. WASHER		2
150	NAS1149E0716P		. WASHER		16
155	BACN10JD5CD		. NUT		2
160	BACB28AK05-051		. BUSHING		4
165	BACB28AK05-090		. BUSHING		2
170	BACP18BC03A05P		. PIN-COTTER		2
175	BACB30NR6DK16		. BOLT		2
180	BACW10BP6CD		. WASHER		2
185	BACW10BP6DP		. WASHER		2
190	BACN10JD106CD		. NUT		2
195	BACB31A3-46		. BOLT		2
200	BACW10BP3CD		. WASHER		2
205	BACW10BP3DP		. WASHER		2
210	PLH53CD		. NUT (V62554) (SPEC BACN10YR3CD) (OPT H52732-3CD (V15653))		2
215	BACB28AK03-258		. BUSHING		2
220	2-7892-2		. SNUBBER (V97415)		2
225	146A6562-1		. MECHANISM ASSY-SNUBBER		1
230	146A6562-2		. MECHANISM ASSY-SNUBBER		1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
4–					
235	HST10AG6-11		. . BOLT (V0PTK6) (SPEC BACB30VT6K11) (OPT HST10AG6-11 (V06725)) (OPT HST10AG6-11 (V56878)) (OPT HST10AG6-11 (V73197))		2
240	WC331K6-11		. . BOLT (V60516) (SPEC BACB30YP6K11)		1
245	HST79CY6		. . COLLAR (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V92215)) (OPT HST79CY6 (V56878)) (OPT HST79CY6 (V5M902))		3
250	146A6555-1		. . FITTING ASSY (USED ON ITEM 225)		1
255	146A6555-2		. . FITTING ASSY (USED ON ITEM 230)		1
260	HTES04VC		. . . BEARING (VS0352) (SPEC BACB10ES04GC) (OPT NC04TG5C (V56644))		1
265	146A6555-101		. . . FITTING (USED ON ITEM 250)		1
270	146A6555-102		. . . FITTING (USED ON ITEM 255)		1
275	146A6551-1		. . FITTING ASSY-SNUBBER		1
280	BACB28AP06P052		. . . BUSHING		1
285	BACB28AY07A026C		. . . BUSHING		4
290	146A6551-101		. . . FITTING		1
295	146A6552-1		. IDLER ASSY		1
300	146A6552-2		. IDLER ASSY		1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
4–					
305	SSMKP5ASD524		. . BEARING (V50294) (SPEC BACB10FS05J) (OPT PACMKP05JAA3908 (V21335)) (OPT SSMKP05JASD705 (V83086)) (OPT PACMKP5AFS428 (V21335)) (OPT ACMKP05JAP510LY (V40920)) (OPT SSMKP05JAP (V21760)) (OPT SSMKP05AP (V21760))		2
310	HTES04VC		. . BEARING (VS0352) (SPEC BACB10ES04GC) (OPT NC04TG5C (V56644))		1
315	BACB28Y5C390		. . BUSHING		1
320	146A6552-101		. . IDLER (USED ON ITEM 295)		1
325	146A6552-102		. . IDLER (USED ON ITEM 300)		1
330	146A6556-1		. SPRING ASSY-LIFT ASSIST		2
–330A	146A6556-3		. SPRING ASSY-LIFT ASSIST		1
335	146A6557-1		. . FITTING ASSY-END		1
340	146A6557-2		. . FITTING ASSY-END		1
345	BACB28AP04-011		. . . BUSHING		1
350	BACB28AT06B012A		. . . BUSHING		1
355	146A6557-101		. . . FITTING (USED ON ITEM 335)		1
360	146A6557-102		. . . FITTING (USED ON ITEM 340)		1
365	146A6559-1		. . WASHER		1
370	146A6559-2		. . WASHER		1
375	146A3558-1		DELETED		
–375A	146A6558-1		. . SPRING (USED ON ITEM 330)		1
–375B	146A6558-3		. . SPRING (USED ON ITEM 330A)		1
380	146A6553-1		. IDLER ASSY-SNUBBER SPRT		2

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
4–					
385	SSMKP5ASD524		. . BEARING (V50294) (SPEC BACB10FS05J) (OPT PACMKP05JAA3908 (V21335)) (OPT SSMKP05JASD705 (V83086)) (OPT PACMKP5AFS428 (V21335)) (OPT ACMKP05JAP510LY (V40920)) (OPT SSMKP05JAP (V21760)) (OPT SSMKP05AP (V21760))		2
390	BACB28Y5C390		. . BUSHING		1
395	146A6553-101		. . IDLER		1
400	146A6554-1		. LINK ASSY-SNUBBER		2
405	146A6554-2		. LINK ASSY-SNUBBER		2
410	BACB28AY07A028C		. . BUSHING		1
415	146A6554-101		. . LINK (USED ON ITEM 400)		1
420	146A6554-102		. . LINK (USED ON ITEM 405)		1

–Item not Illustrated