COMPONENT MAINTENANCE MANUAL WITH ILLUSTRATED PARTS LIST

AUTOMATIC OVERWING EXIT DOOR ASSEMBLY

PART NUMBER 144A6505–1, –10, –2, –3, –4, –5, –6, –7, –8, –9

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COMPONENT MAINTENANCE MANUAL

Revision No. 14
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To: All holders of AUTOMATIC OVERWING EXIT DOOR ASSEMBLY 52-26-07.

Attached is the current revision to this COMPONENT MAINTENANCE MANUAL

The COMPONENT MAINTENANCE MANUAL is furnished either as a printed manual, on microfilm, or digital products, or any combination of the three. This revision replaces all previous microfilm cartridges or digital products. All microfilm and digital products are reissued with all obsolete data deleted and all updated pages added.

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Location of Change	Description of Change
52-26-07	
REPAIR 1-1	Changed the data in the Consumable Materials list. Changed consumable from ''lubricant, D50081'' to ''solid film lubricant, D50081''
PGBLK 52-26-07-8	Removed 52-26-07-8, FITS AND CLEARANCES.
PGBLK 52-26-07-8	Added 52-26-07-8, FITS AND CLEARANCES.

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TEMPORARY REVISION AND SERVICE BULLETIN RECORD

BOEING SERVICE BULLETIN	BOEING TEMPOR˜ ARY REVISION	OTHER DIRECTIVE	DATE OF INCORPORATION INTO MANUAL
		PRR 38130	MAR 01/98
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COMPONENT MAINTENANCE MANUAL

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

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

1. General

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

B. This manual is divided into different parts:

(1) Title Page

(2) Transmittal Letter

(3) Highlights

(4) List of Effective Pages

(5) Table of Contents

(6) Temporary Revision & Service Bulletin Record

(7) Record of Revisions

(8) Record of Temporary Revisions

(9) Introduction

(10) Procedures & IPL Sections

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

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

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

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

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

AUTOMATIC OVERWING EXIT DOOR ASSEMBLY - DESCRIPTION AND OPERATION

1. Description

A. The Automatic Overwing Exit Door Assembly (DESCRIPTION AND OPERATION, Figure 1) is made up of a metal frame and skin with horizontal pressure beams. The door assembly attaches to the aircraft through a hinge assembly on the upper sill.

2. Operation

A. The Automatic Overwing Exit Door Assembly is operated initially with a handle from inside the aircraft. Once the door is unlocked, it automatically rotates outward and up due to the spring force of the counterbalance assemblies.

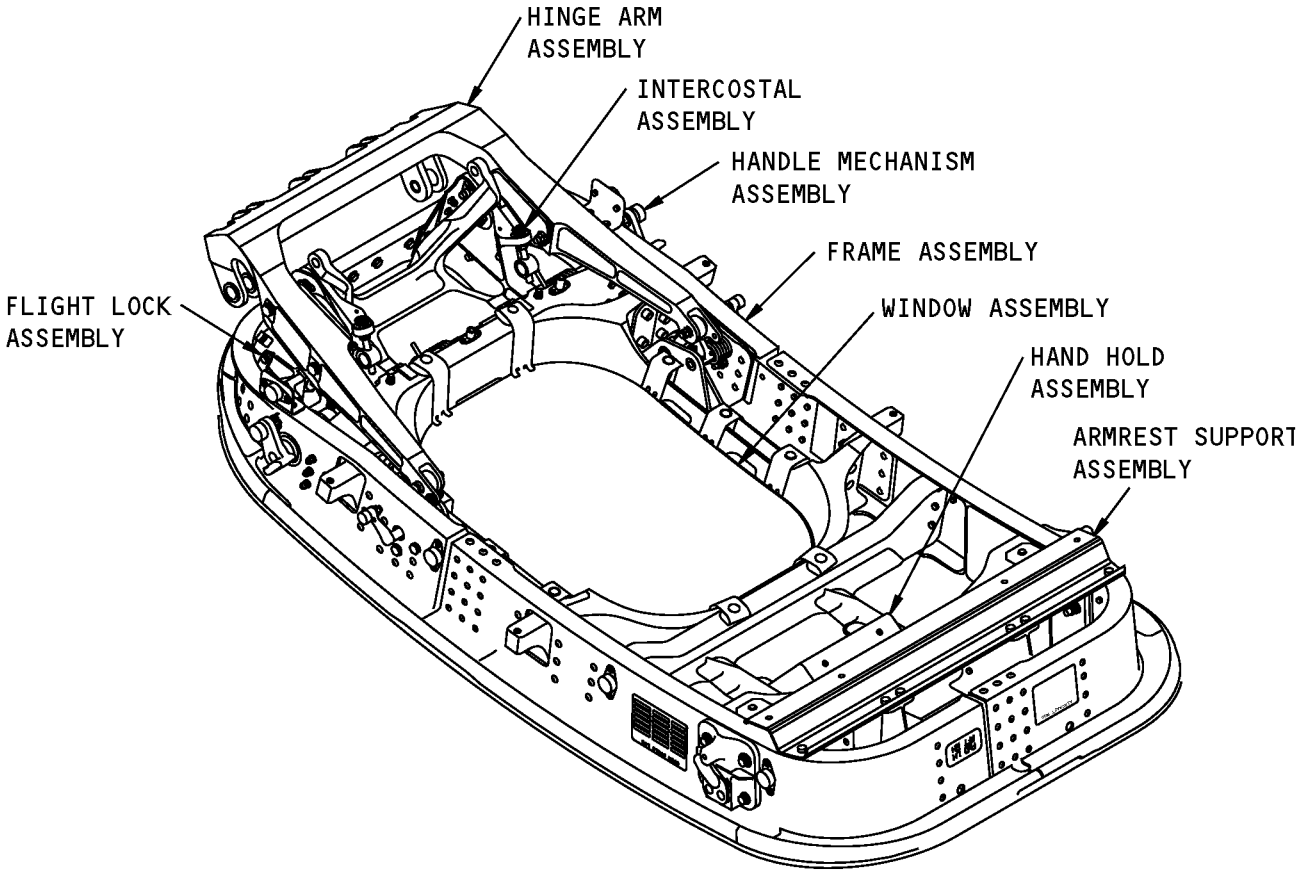
3. Leading Particulars (Approximate)

A. Length – 40.0 inches

B. Width – 21.0 inches

C. Height – 4.0 inches

D. Weight – 50 pounds



Automatic Overwing Exit Door Assembly
Figure 1

(NOT APPLICABLE)

DISASSEMBLY

1. General

A. This procedure tells how to disassemble the automatic overwing exit door assembly.

B. Disassemble this component sufficiently to isolate the defects, do the necessary repairs, and put the component back to a serviceable condition.

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

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

2. Diassembly

A. References

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

B. Procedure

(1) Use standard industry procedures and these steps.

(2) If necessary, remove the arm assembly (IPL Figure 1; 615) from the door assembly.

(a) See IPL Figure 1 for item numbers unless specified differently.

(b) Remove the bolt (620), the washers (625, 630), and the nut (635), then disconnect the jumper (640) from the arm assembly.

(c) At two locations, remove the bolt (505), washers (515, 520), bushings (540, 545) (SOPM 20-50-03), and nut (535) to disconnect the link assembly (670) from the door assembly.

(d) Remove the arm assembly (615) from the door assembly.

(3) If necessary, disassemble the arm assembly (615) as follows:

(a) Remove the bolts (685, 690), the washers (695, 700), and the nuts (705), then remove the shims (605, 610, 720, 725) and the latch receiver (710, 715) from the arm assembly (730).

NOTE: Record the location and thickness of shims to help during assembly.

(4) Remove the bolt (645), the washers (650, 655), the bushing (665) (SOPM 20-50-03), and the nut (660), then remove the link assembly (670) from the arm assembly (730).

(5) If necessary, remove the handle mechanism assembly (310) from the door assembly.

CAUTION: THE SPRINGS (395A) ARE UNDER LOAD. WHEN YOU REMOVE THE BOLTS (320) THE TORQUE TUBE (490) WILL TURN. DO NOT LET IT TURN FREELY. HOLD THE TORQUE TUBE AT EACH END AND LET IT TURN SLOWLY TO A FREE POSITION.

(a) Remove the bolts (320) and the nutplate strap assembly (470) from the mechanism assembly (415).

(b) Remove the bolts (315A, 325, 330), the washers (335, 340, 345, 350, 355), the bushings (365) (SOPM 20-50-03), and the nuts (360) from the mechanism assembly (415).

(c) If necessary, remove the bearings (385) from the door assembly (SOPM 20-50-03).

(d) Remove the door lock crank assemblies (420, 425) and the shims (370, 375, 380) from the door assembly.

NOTE: Record the location and thickness of shims to help during assembly.

(e) Remove the remaining components of the handle mechanism assembly (310) from the door assembly.

(6) If necessary, remove the lock assembly (IPL Figure 2; 75).

(a) See IPL Figure 2 for item numbers unless specified differently.

(b) Remove the bolt (5) and the washer (15), then remove the lock assembly (75) from the door assembly.

NOTE: If the torque tube (IPL Figure 1; 490) is not removed, then remove it before or when you remove the lock assembly (75).

(c) If necessary, disassemble the lock assembly (75).

1) Remove the spring (120) from the lock assembly (75).

2) Remove the bolt (90), washers (105, 110), bushing (95) (SOPM 20-50-03), nut (115), and spring retainer (125).

3) Remove the pins (80, 85) and unscrew the nut, then remove the solenoid (185).

4) Remove the bolt (140), the washers (150, 155), and the nut (165), then remove the pawl shaft (190) and the bushings (170) (SOPM 20-50-03) from the cradle assembly (195).

5) Remove the bolts (130, 135), the washers (145), and the nuts (160), then remove the switch (180A) from the cradle assembly (195).

6) Remove the bearings (175) from the cradle assembly (195) (SOPM 20-50-03).

(7) If necessary, remove the plate assembly (IPL Figure 3; 140, 145).

(a) See IPL Figure 3 for item numbers unless specified differently.

(b) Remove the bolts (90, 95, 100), washers (105, 110, 115), bushing (135) (SOPM 20-50-03), and nuts (120, 125, 130), then remove the roller plate assembly (140, 145) from the door assembly.

CLEANING

1. General

A. This procedure tells how to clean the parts of the automatic overwing exit door assembly.

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

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

2. Cleaning

A. References

Reference	Title
SOPM 20-30-03	GENERAL CLEANING PROCEDURES

B. Procedure

(1) Clean all parts by standard industry procedures and the instructions in SOPM 20-30-03.

CHECK

1. General

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

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

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

2. Check

A. References

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

B. Procedure

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

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

1) See IPL Figure 1 for item numbers.

a) Spacer (390)

b) Crank (450, 455, 585)

c) Stop tube (460)

d) Torque tube (490)

e) Bushing (545)

f) Pawl (575, 580)

g) Spring (590, 595)

h) Latch receiver (710, 715)

2) See IPL Figure 2 for item numbers.

a) Torque link (35, 55)

b) Spring retainer (125)

c) Pawl shaft (190)

3) See IPL Figure 3 for item numbers.

a) Plate (185, 190)

4) See IPL Figure 4 for item numbers.

a) Bearing plate (165)

b) Lower stop fitting (395)

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

1) See IPL Figure 1 for item numbers.

a) Clip (135, 140A, 145A, 150A, 155A)

b) Frame (305, 805, 810, 815, 825, 830, 835)

c) Spring (395A)

d) Hinge (765)

2) See IPL Figure 2 for item numbers.

a) Fitting (70)

b) Cradle (215)

3) See IPL Figure 3 for item numbers.

a) Tee (35, 40)

b) Bolt (90A)

c) Intercostal (255, 260)

4) See IPL Figure 4 for item numbers.

a) Beam (110, 315, 430)

b) Fitting (180, 185, 250, 255)

c) Window frame (435)

(2) Do a check of the spring (IPL Figure 1; 395A) as shown in CHECK, Figure 501.

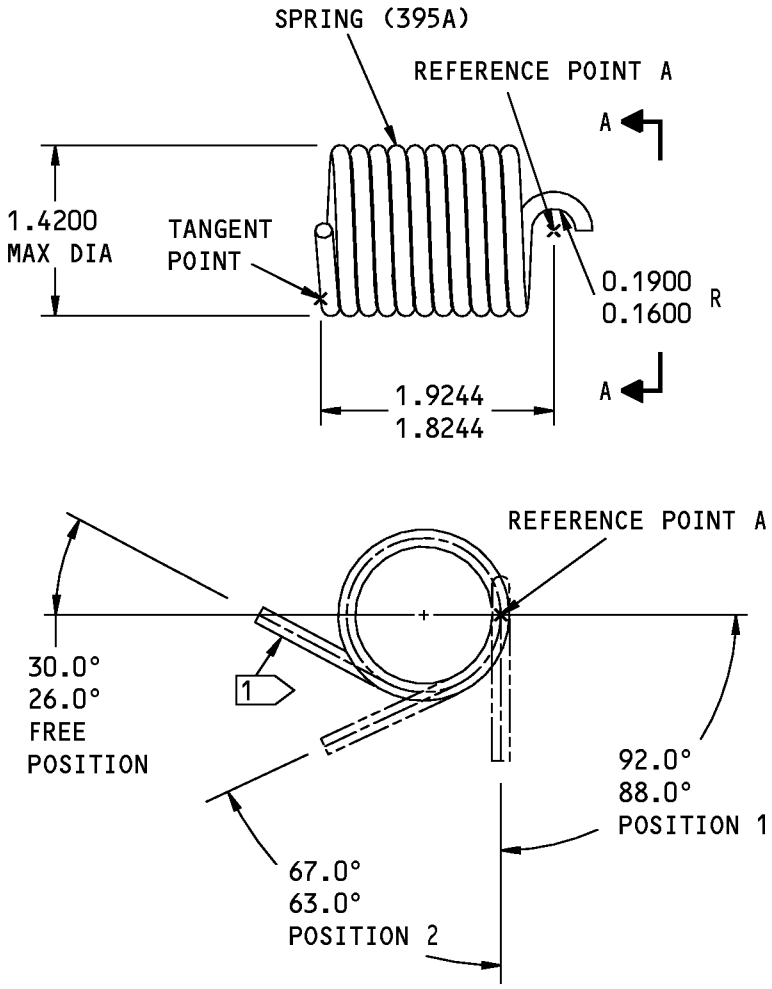
(a) Make sure the spring (395A) has a rotational moment of 25.7-31.4 pound-inches when it is deflected to 240-244 degrees.

(b) Make sure the spring (395A) has a rotational moment of 32.6-39.8 pound-inches when it is deflected to 305-309 degrees.

(3) Do a check of the spring (IPL Figure 1; 590, 595) as shown in CHECK, Figure 502.

(a) Make sure the spring (590, 595) has a rotational moment of 7.0-11.0 pound-inches when it is deflected to 28.0-32.0 degrees.

(b) Make sure the spring (590, 595) has a rotational moment of 12.5-17.5 pound-inches when it is deflected to 48.0-52.0



A–A

TEST DEFLECTION (DEGREES FROM FREE POSITION)	ROTATIONAL MOMENT LIMITS (POUND–INCHES)
240–244	25.7–31.4
305–309	32.6–39.8

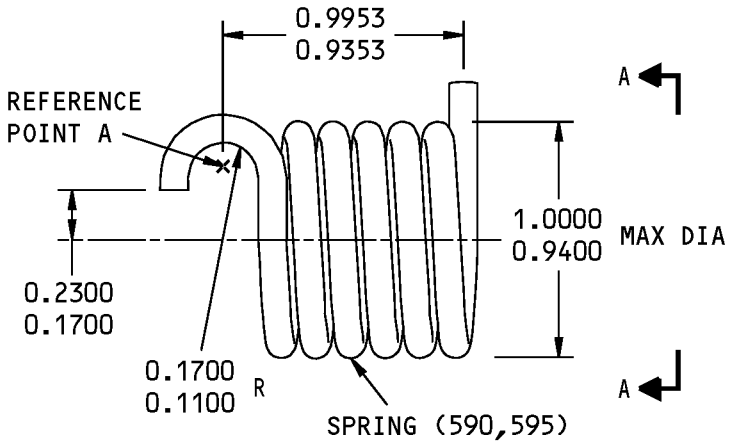
ITEM NUMBERS REFER TO IPL FIG. 1

1 ROTATE CLOCKWISE FOR CHECK

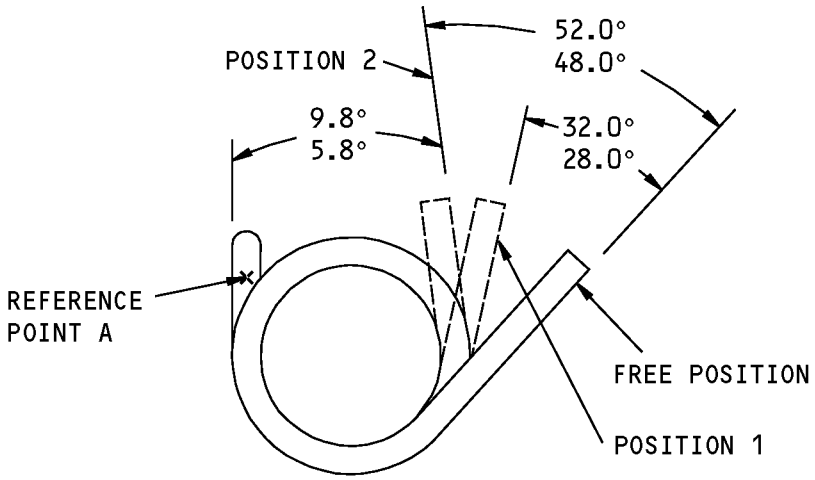
ALL DIMENSIONS ARE IN INCHES

H90551 S00041000939_V2

144A6603-5 Spring Check
Figure 501



144A6644-1 SHOWN
144A6644-2 OPPOSITE



A-A

TEST DEFLECTION (DEGREES FROM FREE POSITION)	ROTATIONAL MOMENT LIMITS (POUNDS-INCHES)
28.0-32.0	7.0-11.0
48.0-52.0	12.5-17.5

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

144A6644-1,-2 Spring Check
Figure 502

REPAIR

1. General

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

Table 601:

PART NUMBER	NAME	REPAIR
—	REFINISH OF OTHER PARTS	1-1
144A6505	DOOR ASSEMBLY	2-1
144A6544	PLATE ASSEMBLY	3-1
144A6612	ARM ASSEMBLY	4-1, 4-2
144A6615	LINK ASSEMBLY	5-1, 5-2
144A6616	LINK ASSEMBLY	5-1, 5-2
258A4702	CRADLE ASSEMBLY	6-1, 6-2
144A6530	DAMPENER ASSEMBLY	7-1

2. Dimensioning Symbols

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

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

EXAMPLES

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

True Position Dimensioning Symbols
Figure 601

REFINISH OF OTHER PARTS - REPAIR 1-1

1. General

A. This procedure has the data necessary to refinish the parts which are not given in the 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.

2. Refinish of Other Parts

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
C00033	Coating - Exterior Protective Enamel, Flexibility Use	BMS10-60, Type II
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I
C00802	Coating - Nylon	BAC5710, Type 49
C50072	Primer - Duralon EF	
C50144	Coating - Melt-Mixed Nylon Powder, Corvel 70-7001 Grey	
C50145	Coating - Melt-Mixed Nylon Powder, Corvel 70-5001 Blue	
C50146	Coating - Melt-Mixed Nylon Powder, Corvel 70-7002 Black	
C50147	Coating - Thermoset Epoxy Powder, Corvel 13-7004 Zinc Rich Gray	
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
SOPM 20-50-08	APPLICATION OF BONDED SOLID FILM LUBRICANTS
SOPM 20-60-02	FINISHING MATERIALS
SOPM 20-60-03	LUBRICANTS

C. Procedure

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

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

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

Table 601: Refinish Details

IPL FIG. & ITEM	MATERIAL	FINISH
IPL Fig. 1		
Angle (30)	Al alloy	Anodize (F-17.31) all surfaces. Apply primer, C00259 (F-20.03).
Depressor (70,75, 85,90,95,100)	Al alloy	Anodize (F-17.31) all surfaces. Apply primer, C00259 (F-20.03).
Window Clip (135)	301 CRES	Apply Corvel 13-7004 Zinc Rich Grey Epoxy Powder Coating, C50147 with Corvel 70-7001 Grey Nylon Powder Coating, C50144. Optional: Apply primer, C50072 and medium grey coating, C00802 (F-21.14) 0.006-0.012 inch thick.
Window Clip (135A)	301 CRES	Apply primer, C50072 and medium grey coating, C00802 (F-21.14) 0.006-0.012 inch thick.
Window Clip (140)	301 CRES	Apply primer, C50072 and white coating, C00802 (F-21.14) 0.006-0.012 inch thick.
Window Clip (145)	301 CRES	Apply Corvel 13-7004 Zinc Rich Grey Epoxy Powder Coating, C50147 with Corvel 70-5001 Blue Nylon Powder Coating, C50145 (or similar). Optional: Apply primer, C50072 and iron blue coating, C00802 (F-21.14) 0.006-0.012 inch thick.
Window Clip (145A)	301 CRES	Apply primer, C50072 and iron blue coating, C00802 (F-21.14) 0.006-0.012 inch thick.
Window Clip (150)	301 CRES	Apply primer, C50072 and brown coating, C00802 (F-21.14) 0.006-0.012 inch thick.
Window Clip (155)	301 CRES	Apply Corvel 13-7004 Zinc Rich Grey Epoxy Powder Coating, C50147 with Corvel 70-7002 Black Nylon Powder Coating, C50146. Optional: Apply primer, C50072 and black coating, C00802 (F-21.14) 0.006-0.012 inch thick.
Window Clip (155A)	301 CRES	Apply primer, C50072 and black coating, C00802 (F-21.14) 0.006-0.012 inch thick.
Stiffener (200)	Al alloy	Anodize (F-17.31) all surfaces. Apply primer, C00259 (F-20.03).
Shim (205)	Al alloy	Anodize (F-17.31) all surfaces. Apply primer, C00259 (F-20.03).
Support (210)	Al alloy	Chemical treat (F-17.07) all surfaces. Apply primer, C00259 (F-20.03).
Tee (240)	Al alloy	Anodize (F-17.31) all surfaces. Apply primer, C00259 (F-20.03).
Channel (280)	Al alloy	Anodize (F-17.31) all surfaces. Apply primer, C00259 (F-20.03).
Seal retainer (295)	Al alloy	Chemical treat or chromic acid anodize, then apply primer, C00259 (SRF-2.30).
Frame (305)	Al alloy	Anodize (F-17.31) all surfaces. Apply primer, C00259 (F-20.03).
Shim (370,375,380)	4130 Steel	Cadmium plate (F-15.06).

Table 601: Refinish Details (Continued)

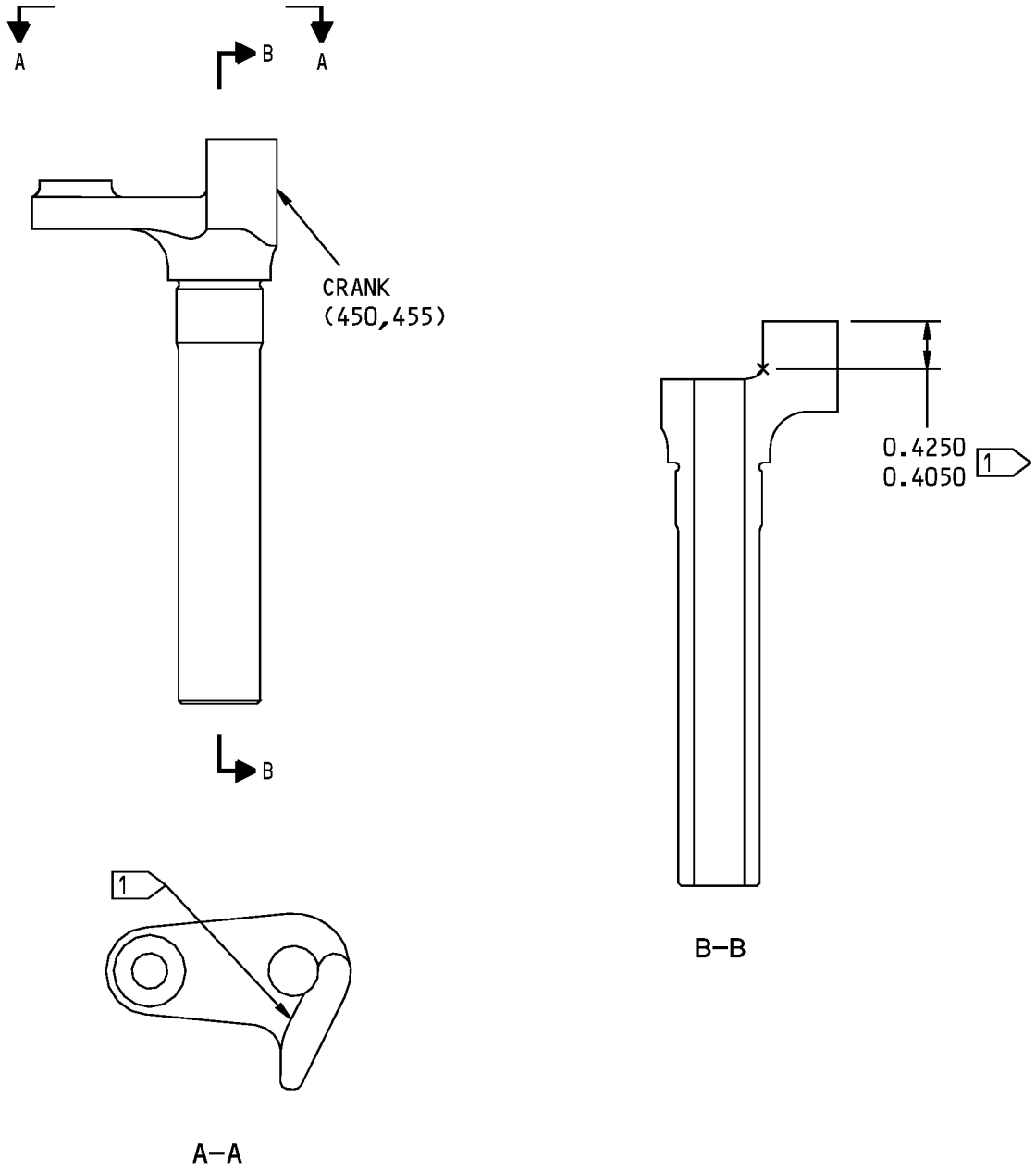
IPL FIG. & ITEM	MATERIAL	FINISH
Spacer (390)	15-5PH CRES 180-200 ksi	Passivate (F-17.25) all surfaces.
Crank (450,455)	15-5PH CRES 180-200 ksi	Passivate (F-17.25) all surfaces. Apply solid film lubricant, D50081 (F-19.10) to the area shown in REPAIR 1-1, Figure 601 (SOPM 20-50-08).
Stop tube (460)	15-5PH CRES 180-200 ksi	Passivate (F-17.25) all surfaces.
Handle (465)	Al alloy	Anodize (F-17.31) all surfaces. Apply primer, C00259 (F-20.02) to all surfaces. Apply coating, C00033 enamel (F-14.9813, which replaces SRF-14.9813) to all surfaces, but do not apply enamel in the holes.
Strap (485)	Al alloy	Chemical treat (F-17.07) all surfaces. Apply primer, C00259 (F-20.03) to all surfaces.
Torque tube (490)	15-5PH CRES 180-200 ksi	Passivate (F-17.25, which replaces F-17.09) all surfaces. Cadmium plate (F-16.06) and apply primer, C00259 (F-20.02) as shown in REPAIR 1-1, Figure 602.
Bushing (545)	15-5PH CRES 180-200 ksi	Passivate (F-17.25) all surfaces.
Pawl (575,580)	15-5PH CRES 180-200 ksi	Passivate (F-17.25) all surfaces.
Crank (585)	15-5PH CRES 180-200 ksi	Passivate (F-17.25) all surfaces.
Spring (590,595)	17-7PH CRES CH900	Passivate (F-17.25) all surfaces.
Shim (605,610,720, 725)	Al alloy	Chemical treat (F-17.07) all surfaces. Apply primer, C00259 (F-20.02).
Latch receiver (710,715)	15-5PH CRES 180-200 ksi	Passivate (F-17.25) all surfaces. Cadmium plate (F-16.06) and apply primer, C00259 (F-20.02) as shown in REPAIR 1-1, Figure 603.
Frame (805,810,815, 830,835)	Al Alloy	Anodize (F-17.31) all surfaces. Apply primer, C00259 (F-20.03).
Frame (825)	Al alloy	Anodize (F-17.31) all surfaces. Apply primer, C00259 (F-20.03), but not in the holes.
IPL Fig. 2		

Table 601: Refinish Details (Continued)

IPL FIG. & ITEM	MATERIAL	FINISH
Torque link (35,55)	15-5PH CRES 180-200 ksi	Passivate (F-17.25) all surfaces.
Fitting (70)	Al alloy	Anodize (F-17.31) all surfaces. Apply primer, C00259 (F-20.03), but not in the bearing holes.
Spring retainer (125)	15-5PH CRES 180-200 ksi	Cadmium plate (F-15.06).
Pawl shaft (190)	15-5PH CRES 180-200 ksi	Passivate (F-17.25) all surfaces.
IPL Fig. 3		
Angle (10,15,75)	Al alloy	Anodize (F-17.31) all surfaces. Apply primer, C00259 (F-20.03).
Intercostal (20,25)	Al alloy	Anodize (F-17.31) all surfaces. Apply primer, C00259 (F-20.03).
Tee (35,40)	Al alloy	Anodize (F-17.31) all surfaces. Apply primer, C00259 (F-20.03).
Angle (75)	Al Alloy	Anodize (F-17.31) all surfaces. Apply primer, C00259 (F-20.03).
Bolt (90A)	A286 CRES	Cadmium plate (F-15.06).
Plate (185,190)	15-5PH CRES 180-200 ksi	Cadmium plate (F-16.06). Apply primer, C00259 (F-20.02).
Intercostal (255, 260)	Al alloy	Anodize (F-17.31) all surfaces. Apply primer, C00259 (F-20.03).
IPL Fig. 4		
Beam end (50,55)	Al alloy	Anodize (F-17.31) all surfaces. Apply primer, C00259 (F-20.03).
Beam (110)	Al alloy	Anodize (F-17.31) all surfaces. Apply primer, C00259 (F-20.03).
Radius filler (135,140)	Al alloy	Anodize (F-17.31) all surfaces. Apply primer, C00259 (F-20.03).
Bearing plate (165)	15-5PH CRES 150-170 ksi	Thin dense chrome plate (F-15.43), 0.0007 - 0.0010 inch thick the area shown in REPAIR 1-1, Figure 606. Cadmium plate (F-15.06) and apply primer, C00259 (F-20.02) on other areas.
Fitting (180,185)	Al alloy	Anodize (F-17.31) all surfaces. Apply primer, C00259 (F-20.03).
Fitting (250,255)	Al alloy	Anodize (F-17.31) all surfaces. Apply primer, C00259 (F-20.03), but not in the bushing holes.
Beam end (295)	Al Alloy	Anodize (F-17.31) all surfaces. Apply primer, C00259 (F-20.03).
Beam (315)	Al alloy	Anodize (F-17.31) all surfaces. Apply primer, C00259 (F-20.03).
Bracket (375)	Al alloy	Anodize (F-17.31) all surfaces. Apply primer, C00259 (F-20.03).
Shim (380)	Al alloy	Anodize (F-17.31) all surfaces. Apply primer, C00259 (F-20.03).

Table 601: Refinish Details (Continued)

IPL FIG. & ITEM	MATERIAL	FINISH
Lower stop fitting (395)	15-5PH CRES 180-200 ksi	Thin dense chrome plate (F-15.43), 0.0003 - 0.0005 inch thick, the area shown in REPAIR 1-1, Figure 605. Cadmium plate (F-16.06) and apply primer, C00259 (F-20.02) on other areas.
Clip (425)	Al alloy	Anodize (F-17.31) all surfaces. Apply primer, C00259 (F-20.03).
		Apply primer, C00259 (F-20.03).
Window frame (435)	Al alloy	Anodize (F-17.35) all surfaces. Apply primer, C00259 (F-20.03), but not on the surfaces shown in REPAIR 1-1, Figure 604. Apply enamel coating, C00033 (F-14.9817, which replaces SRF-14.9817) as shown in REPAIR 1-1, Figure 604. Overspray of enamel is permitted, but not on surfaces without primer.
Beam (430)	Al alloy	Anodize (F-17.31) all surfaces. Apply primer, C00259 (F-20.03).

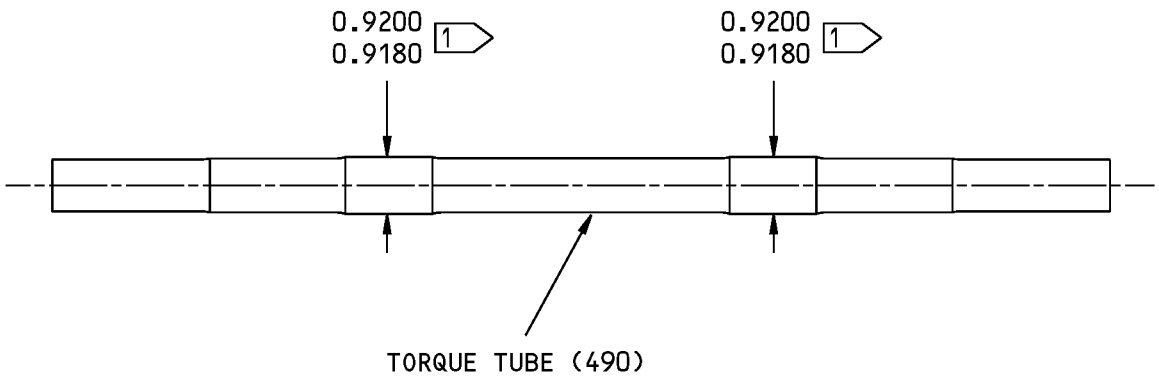


1 APPLY BMS 3-8 LUBRICANT (F-19.10) TO THIS SURFACE. OVERSPRAY IS ALLOWED

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

144A6602-4,-6 Crank Refinish
Figure 601

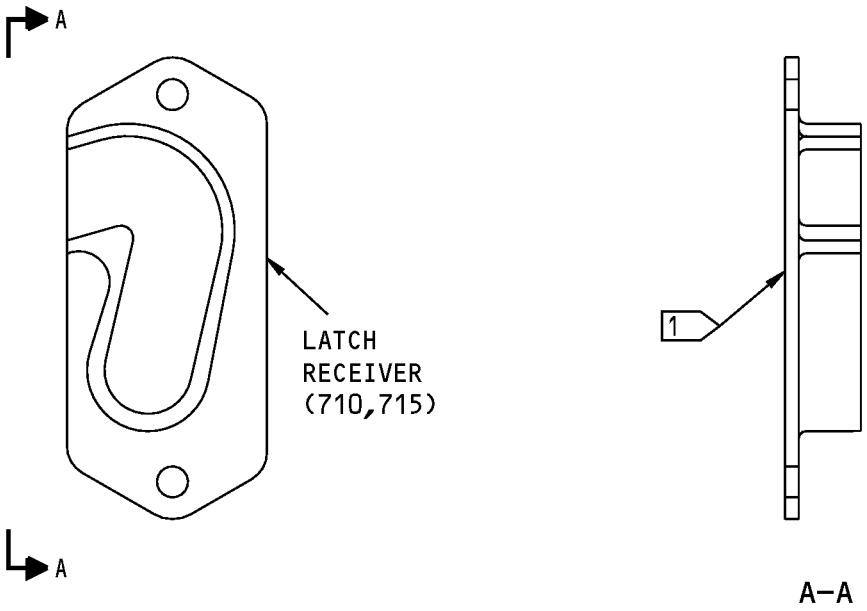


1 APPLY CADMIUM PLATE (F-16.06) TO THE DIAMETER, THEN APPLY PRIMER (F-20.02). OVERSPRAY IS ALLOWED

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

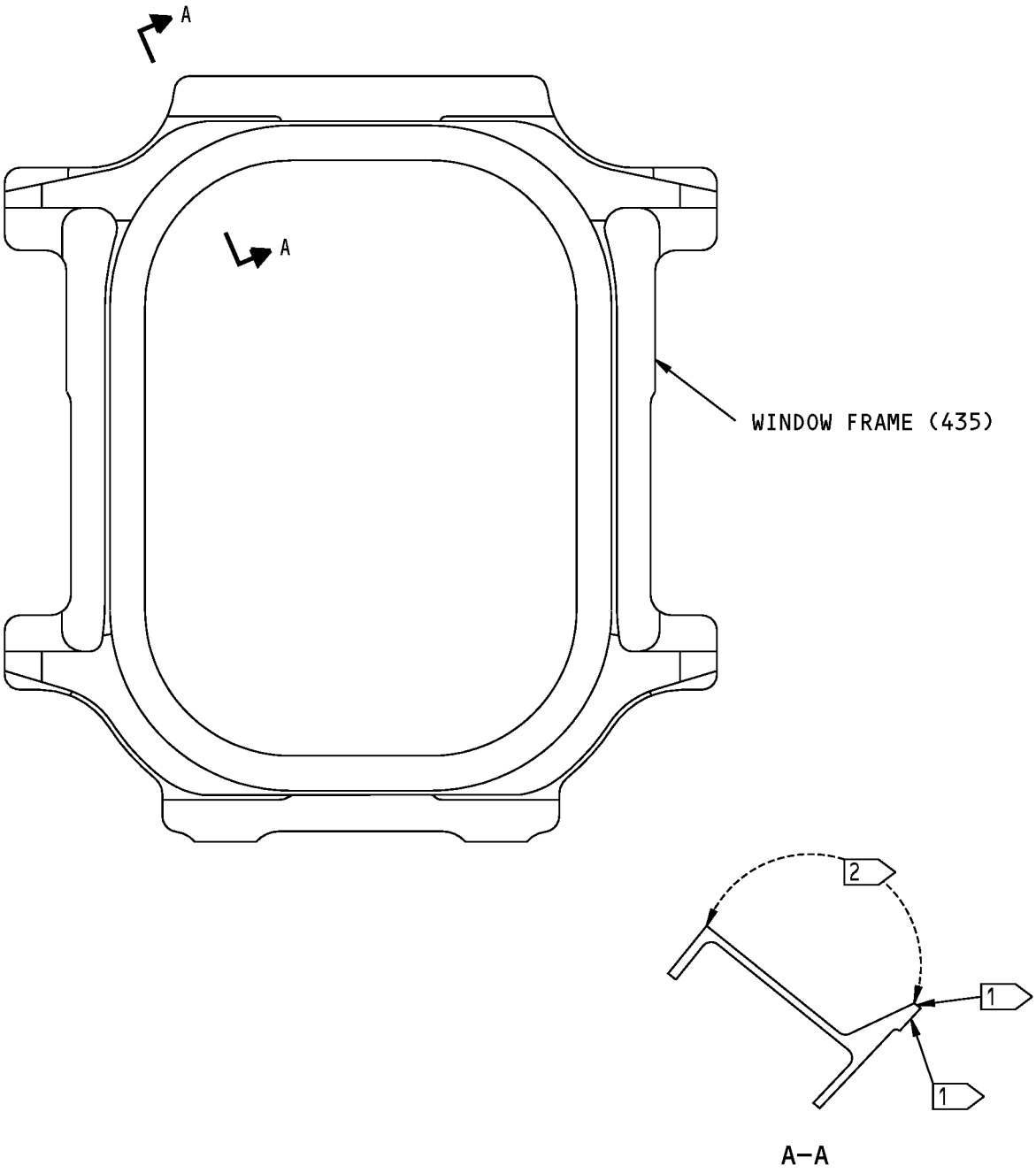
144A6604-2 Torque Tube Refinish
Figure 602



1 CADMIUM PLATE (F-16.06) AND APPLY PRIMER (F-20.02) TO THIS SURFACE

ITEM NUMBERS REFER TO IPL FIG. 1

144A6613-1,-2 Latch Receiver Refinish
Figure 603

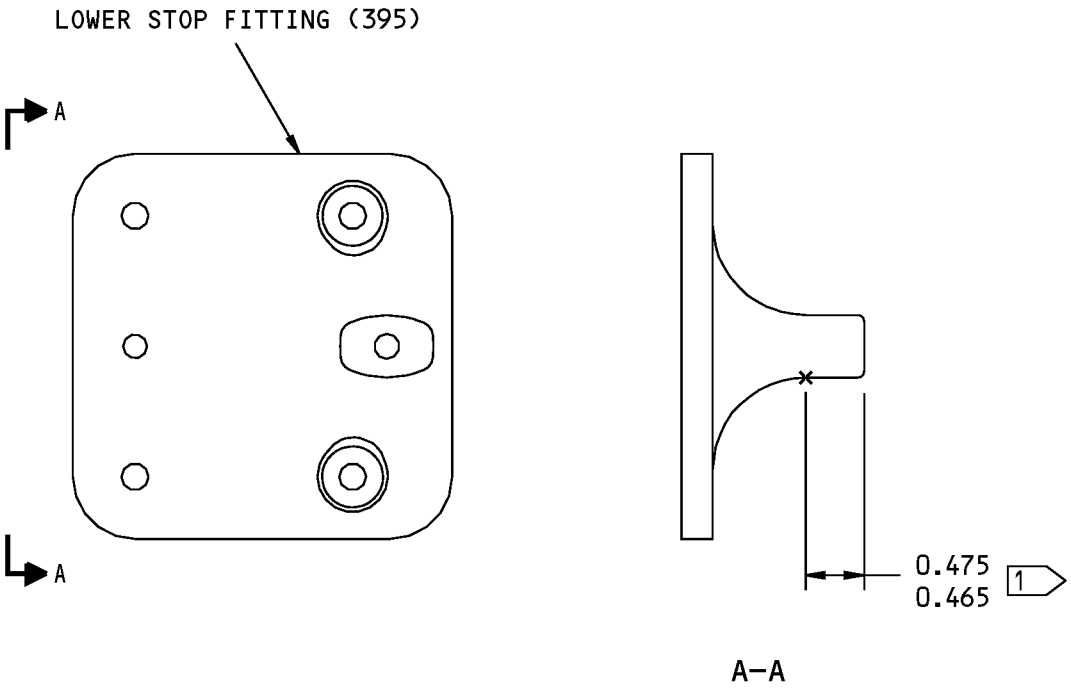


ITEM NUMBERS REFER TO IPL FIG. 4

1 NO PRIMER (F-20.03) ALLOWED ON THIS SURFACE

2 APPLY BMS 10-60 BLACK ENAMEL ON THIS SURFACE

144A6524-2 Window Frame Refinish
Figure 604

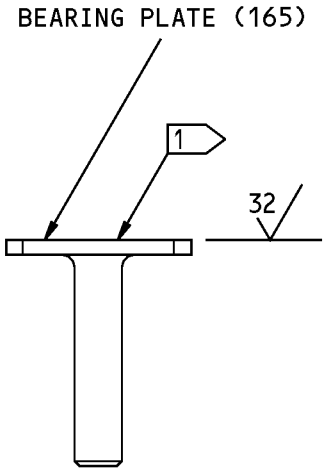


1 DO NOT APPLY CADMIUM PLATE (F-16.06) OR PRIMER (F-20.02) IN THIS AREA. CHROME PLATE (F-15.43) 0.0003-0.0005 THICK

ITEM NUMBERS REFER TO IPL FIG. 4

ALL DIMENSIONS ARE IN INCHES

144A6526-1 Lower Stop Fitting Refinish
Figure 605



1 DO NOT APPLY CADMIUM PLATE (F-15.06) OR PRIMER (F-20.02) IN THIS AREA. CHROME PLATE (F-15.43) 0.0007-0.0010 THICK

ITEM NUMBERS REFER TO IPL FIG. 4

ALL DIMENSIONS ARE IN INCHES

144A6527-1 Bearing Plate Refinish
Figure 606

BOEING®

COMPONENT MAINTENANCE MANUAL

DOOR ASSEMBLY - REPAIR 2-1

144A6505–1, –2, –3, –4, –5, –6, –7, –8, –9, –10

1. General

A. This procedure has the data necessary to replace the important parts of the automatic overwing exit door assembly.

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

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

2. Door Assembly Repair Procedures

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00028	Adhesive - Modified Epoxy For Rigid PVC, Foam Cored Sandwiches	BAC5010, Type 70 (BMS5-92, Type 1)
A00279	Adhesive - Fast-Setting Epoxy	BMS5-123 or BAC5010, Type 71
B00083	Solvent - Aliphatic Naphtha (For Acrylic Plastics)	TT-N-95 Type II, ASTM D-3735 Type III
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I
C50069	Coating - Enamel, Color 702 Gloss White	BMS10-11, Type II
G00034	Cotton Wiper - Process Cleaning Absorbent Wiper (Cheesecloth, Gauze)	BMS15-5
G01989	Soap - Castile	

B. References

Reference	Title
BAC 5038	Processing of Acrylic Plastics
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-41-02	APPLICATION OF CHEMICAL AND SOLVENT RESISTANT FINISHES
SOPM 20-50-01	BOLT AND NUT INSTALLATION
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-50-12	APPLICATION OF ADHESIVES
SOPM 20-60-01	CLEANING MATERIALS

Reference	Title
SOPM 20-60-02	FINISHING MATERIALS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

C. Door Assembly Refinish

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

(1) Apply primer, C00259 (F-14.9962) to outer surfaces of frame as shown in REPAIR 2-1, Figure 602 (SOPM 20-41-02).

(2) Apply enamel coating, C50069 (F-21.17) to outer surfaces of frame as shown in REPAIR 2-1, Figure 602 (SOPM 20-41-02).

NOTE: Apply primer and enamel prior to assembly of handle seal assembly, window assembly, handle mechanism assembly, hinge arm assembly and flight lock assembly and after post assembly sealing. Refer to ASSEMBLY, Paragraph 2.D.(2). Full coverage not required on inside surface of seal depressors. No overspray allowed on outer surface of skin, outboard surface of stop pads, bushings, bearings, lower stop fittings or lower stop rub plates.

D. Window Seal, Outer Pane, Middle Pane Replacement

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

(1) See IPL Figure 1 for item numbers unless specified differently.

(2) For all steps of this procedure, clean and handle the window panes as specified by BAC 5038.

(3) Remove the screws (110, 115, 120), the retainer clips (135, 140, 145, 150, 155), and the bushings (125, 130) (SOPM 20-50-03) from the door assembly.

(4) Remove the window assembly (160) from the door assembly.

CAUTION: BE CAREFUL WHEN YOU HANDLE THE MIDDLE AND OUTER WINDOW PANES. THEY CAN BE DAMAGED EASILY.

(5) If necessary, remove the seal (165A) from the window assembly (160).

(6) Replace the seal (165A), the outer pane (170), and the middle pane (175) as necessary.

(7) Use solvent, B00083 to clean the window opening of the door assembly.

(8) Use a clean, dry cotton wiper, G00034 to remove the solvent, B00083 from the window opening before the solvent, B00083 dries.

CAUTION: DO NOT RUB THE WINDOW PANES (170, 175) WITH A DRY CLOTH. THIS CAN CAUSE SCRATCHES AND MAKE AN ELECTROSTATIC CHARGE WHICH CAN CAUSE DUST PARTICLES TO BOND TO THE WINDOW SURFACES.

(9) Clean the outer pane (170) and the middle pane (175) as specified by BAC 5038.

(10) If the seal (165A), the outer pane (170), and the middle pane (175) were disassembled, then assemble them as follows:

NOTE: Make sure that the serial numbers of the panes are at the top of the assembly and that the seal part number is on the right hand side of the concave surface of the window panes.

(a) Install the seal (165A) around the outer pane (170).

(b) Install the middle pane (175) into the seal (165A) so that the seal is around the edges and also between the two panes.

(c) Make sure that the tabs on the top and bottom of the window assembly (160) are within 0.10 inch of the center of the window panes.

(11) Install the window assembly (160) into the window frame as follows:

(a) Align the window assembly (160) with the window frame in the door assembly.

(b) Push at the edges on opposite sides of the window assembly (160) to move it into position in the door assembly.

NOTE: If the window assembly (160) will not slide into the window frame, then apply a castile soap, G01989 and water solution to the outer edges of the window assembly.

(c) Make sure that the window assembly (160) is aligned in the center of the window frame.

(d) Install the retainer clips (135, 155) at four locations with the bushings (125) (SOPM 20-50-03) and the screws (110). Snug the screws (110), but do not tighten them.

(e) Install the retainer clips (140, 145, 150) at six locations with the bushings (125, 130) (SOPM 20-50-03) and the screws (115, 120), then tighten the screws until the retainer clips touch the window.

(f) Tighten the screws (110, 115, 120) in the sequence specified by REPAIR 2-1, Figure 601, until the retainer clips (135, 140, 145, 150, 155) clamp up against the bushings (125, 130).

(g) Tighten all the screws (110, 115, 120) to 27 - 38 pound-inches.

(h) Make sure all of the retainer clips (135, 140, 145, 150, 155) are tight. If you find a loose retainer clip, then remove the screw and increase the length of the bushing by 0.03 inch maximum. A NAS1149D0332J washer can be added instead of increasing the length of the bushing.

E. Handle Seal and Handle Seal Retainer Replacement

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

(1) See IPL Figure 1 for item numbers unless otherwise specified.

(2) Remove the worn or damaged seal (290) and/or the retainer (295) from the door assembly.

(3) Clean the surface of the door assembly where the old retainer (295) was.

(4) If necessary, install the new retainer (295) onto the door assembly with adhesive, A00028 or adhesive, A00279 as specified by SOPM 20-50-12.

(5) If necessary, install the seal (290) into the retainer.

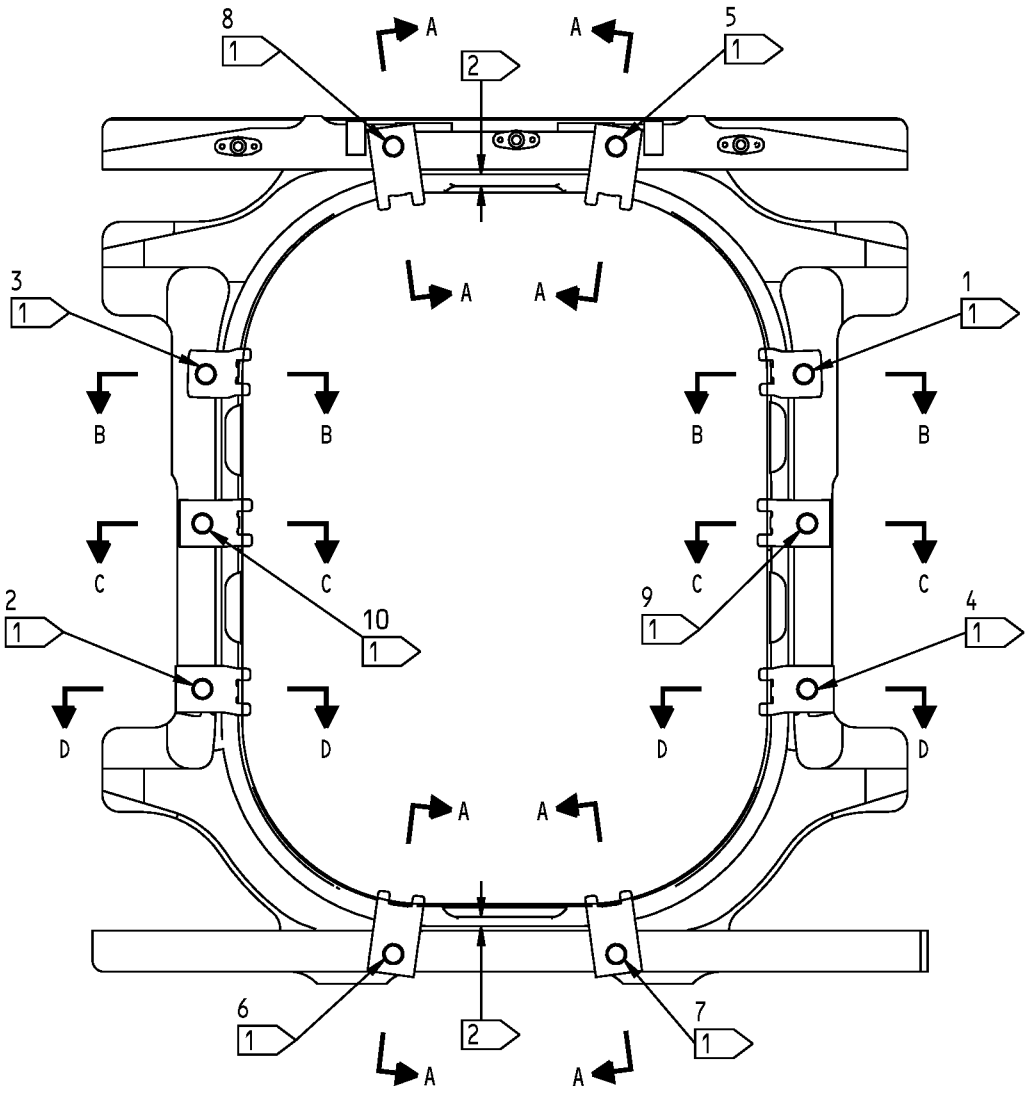
F. Centering Block Replacement

(1) See IPL Figure 4 for item numbers unless otherwise specified.

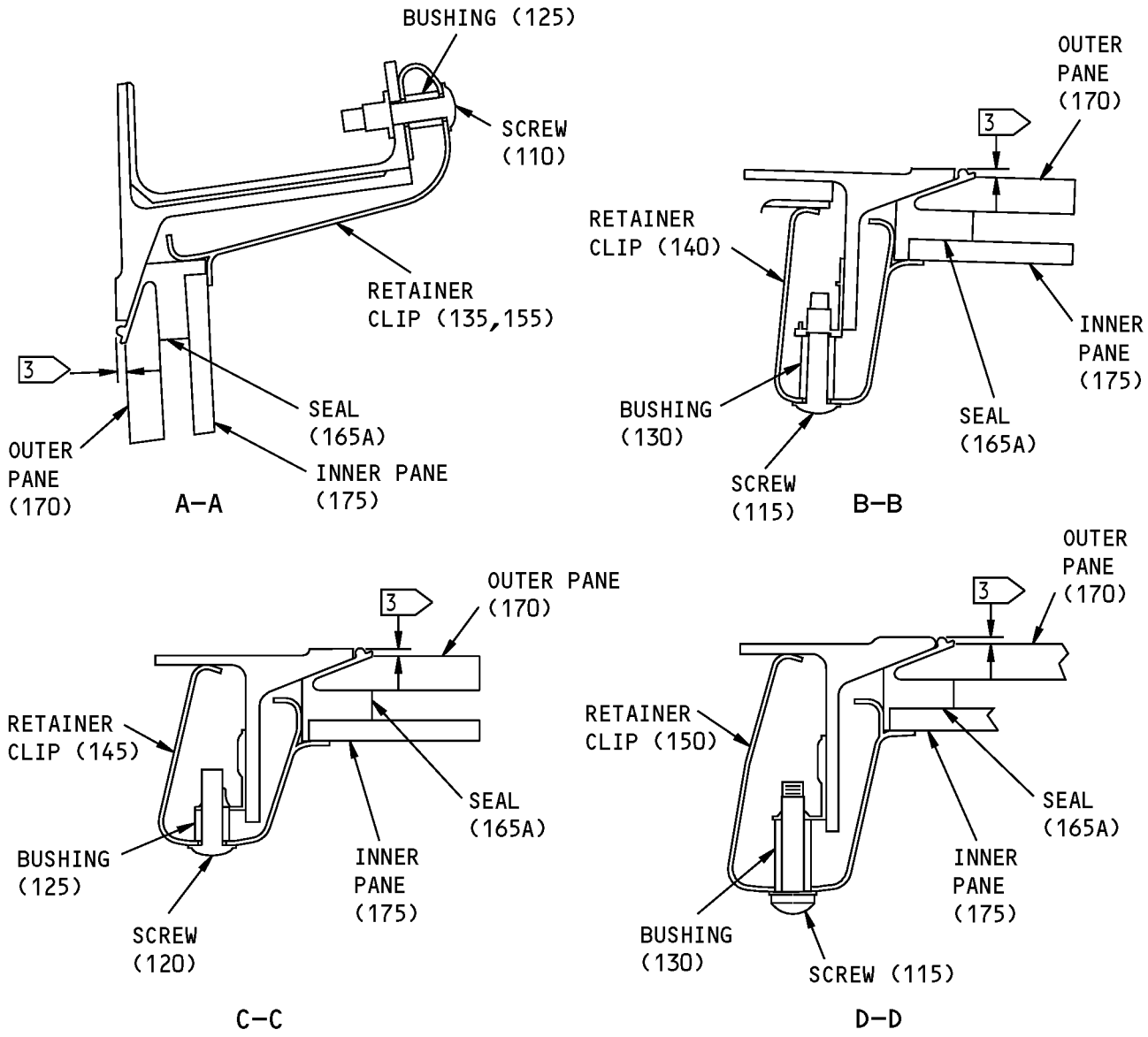
(2) Remove the screws (355), then remove the old centering block (385, 390) and shims (380) from the door assembly.

(3) Replace the shims (380) if they have corrosion or other defects.

(4) Install a replacement centering block (385, 390) on the door assembly with the screws (355). Tighten the screws to standard torque (SOPM 20-50-01).



144A6555-1, -2 Window Seal - Outer Pane - Middle Pane Replacement
Figure 601 (Sheet 1 of 2)



1 TIGHTENING SEQUENCE

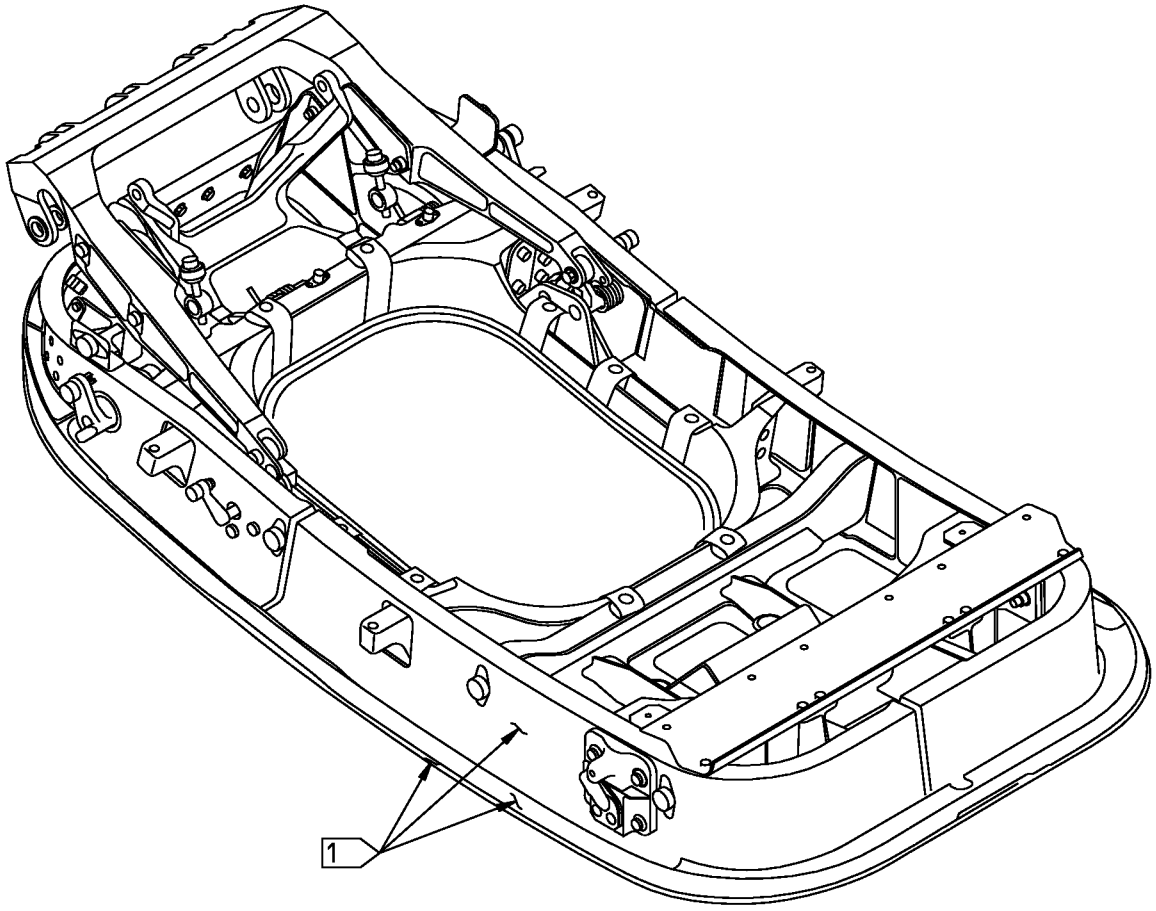
2 MAKE SURE THE SPACE AROUND THE WINDOW ASSEMBLY IS EQUAL ALL AROUND WITHIN 0.03 INCH

3 MAKE SURE THE OUTER SURFACE OF THE WINDOW ASSEMBLY IS FLUSH WITH THE OUTER SURFACE OF THE SKIN +0.03/–0.10 INCH

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

144A6555-1, -2 Window Seal - Outer Pane - Middle Pane Replacement
Figure 601 (Sheet 2 of 2)



144A6505-1 THRU -10

1 APPLY BMS 10-11, TYPE 1 PRIMER (F-14.9962) AND BMS 10-11, TYPE 2 (F-21.17) TO THIS SURFACE

1665449 S0000305054_V1

Automatic Overwing Exit, Door Assembly - Refinish
Figure 602

PLATE ASSEMBLY - REPAIR 3-1

144A6544–1, –2

1. General

A. This procedure has the data necessary to replace parts of the plate assembly IPL Figure 3; 140, 145).

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

C. Refer to IPL Figure 3 for item numbers.

2. Plate Assembly Procedures

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

Reference	Title
SOPM 20-20-01	MAGNETIC PARTICLE INSPECTION
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-50-01	BOLT AND NUT INSTALLATION
SOPM 20-50-02	INSTALLATION OF SAFETYING DEVICES
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-04	MISCELLANEOUS MATERIALS

C. Bearing Replacement

(1) Remove the nut (155) and the washers (160) from the plate assembly (140, 145).

(2) Remove the old bearing (165) (SOPM 20-50-03).

(3) Install a replacement bearing (165) (SOPM 20-50-03) and the washers (160), then install the nut (155) and tighten it to standard torque (SOPM 20-50-01).

(4) Install the cotter pin (150) (SOPM 20-50-02).

D. Bushing Replacement

NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For miscellaneous materials, refer to SOPM 20-60-04.

(1) Remove the old bushing (180) from the plate assembly (140, 145) (SOPM 20-50-03).

(2) Do a magnetic particle check of the bushing hole (SOPM 20-20-01).

(3) Use the shrink-fit method to install a replacement bushing (180) with sealant, A00247 (SOPM 20-50-03).

(4) Machine the bushing bore to 0.3750-0.3756 inch diameter and a 63 microinch surface finish.

ARM ASSEMBLY - REPAIR 4-1

144A6612–3

1. General

A. This procedure has the data necessary to replace parts of the arm assembly (IPL Figure 1; 730).

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

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

D. Refer to IPL Figure 1 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 20-20-02	PENETRANT METHODS OF INSPECTION
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-04	MISCELLANEOUS MATERIALS

C. Procedure

NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For miscellaneous finishes, refer to SOPM 20-60-04.

(1) Remove the old bushings (735, 740, 745, 750, 755, 760) from the hinge (765) (SOPM 20-50-03).

(2) Make sure that the hole for the bushing (740, 760) is 0.3752-0.3758 inch in diameter and has no defects.

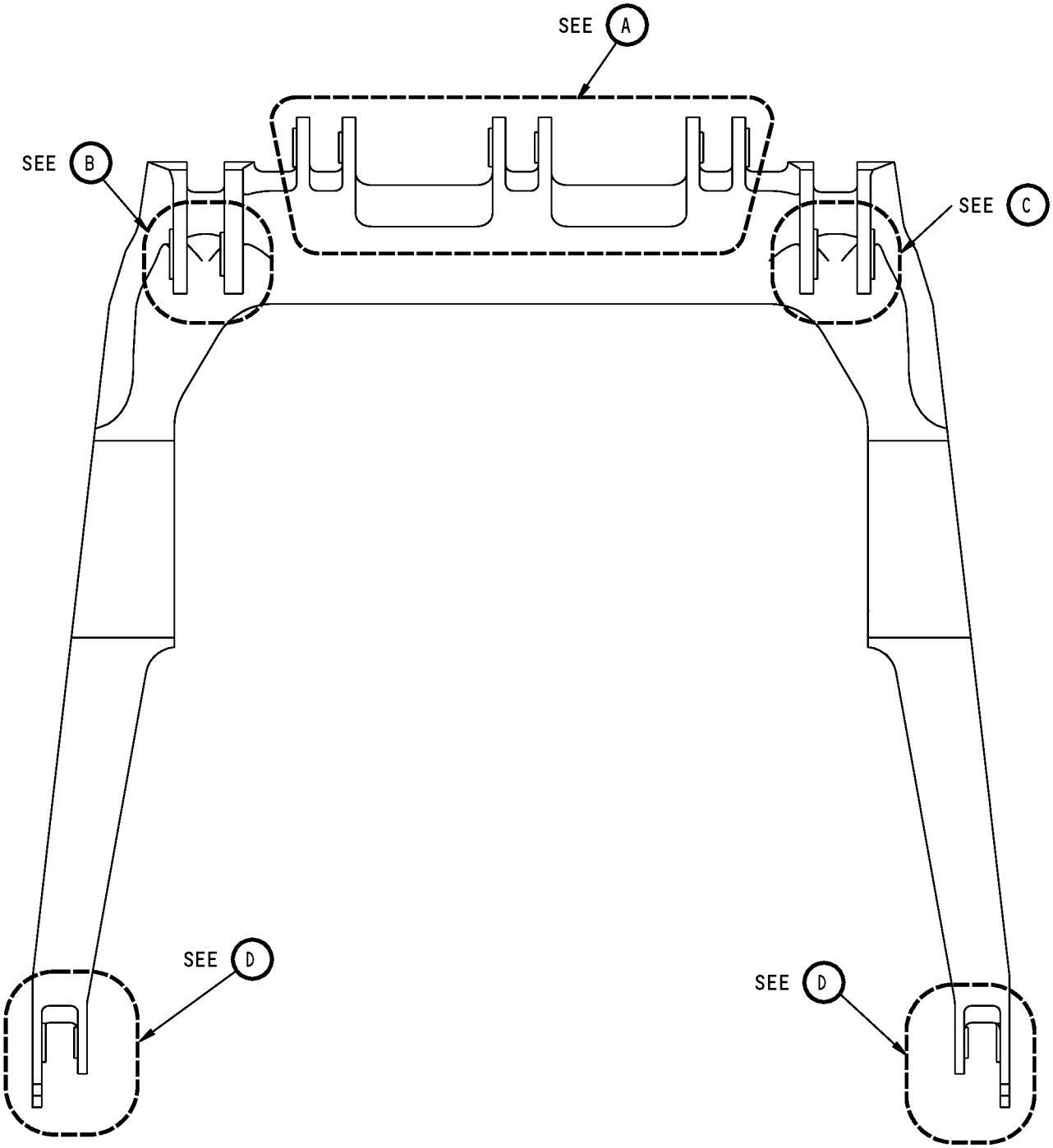
(3) Make sure that the hole for the bushing (735, 750, 755) is 0.5000-0.5006 inch in diameter and has no defects.

(4) Make sure that the hole for the bushing (745) is 0.6875-0.6882 inch in diameter and has no defects.

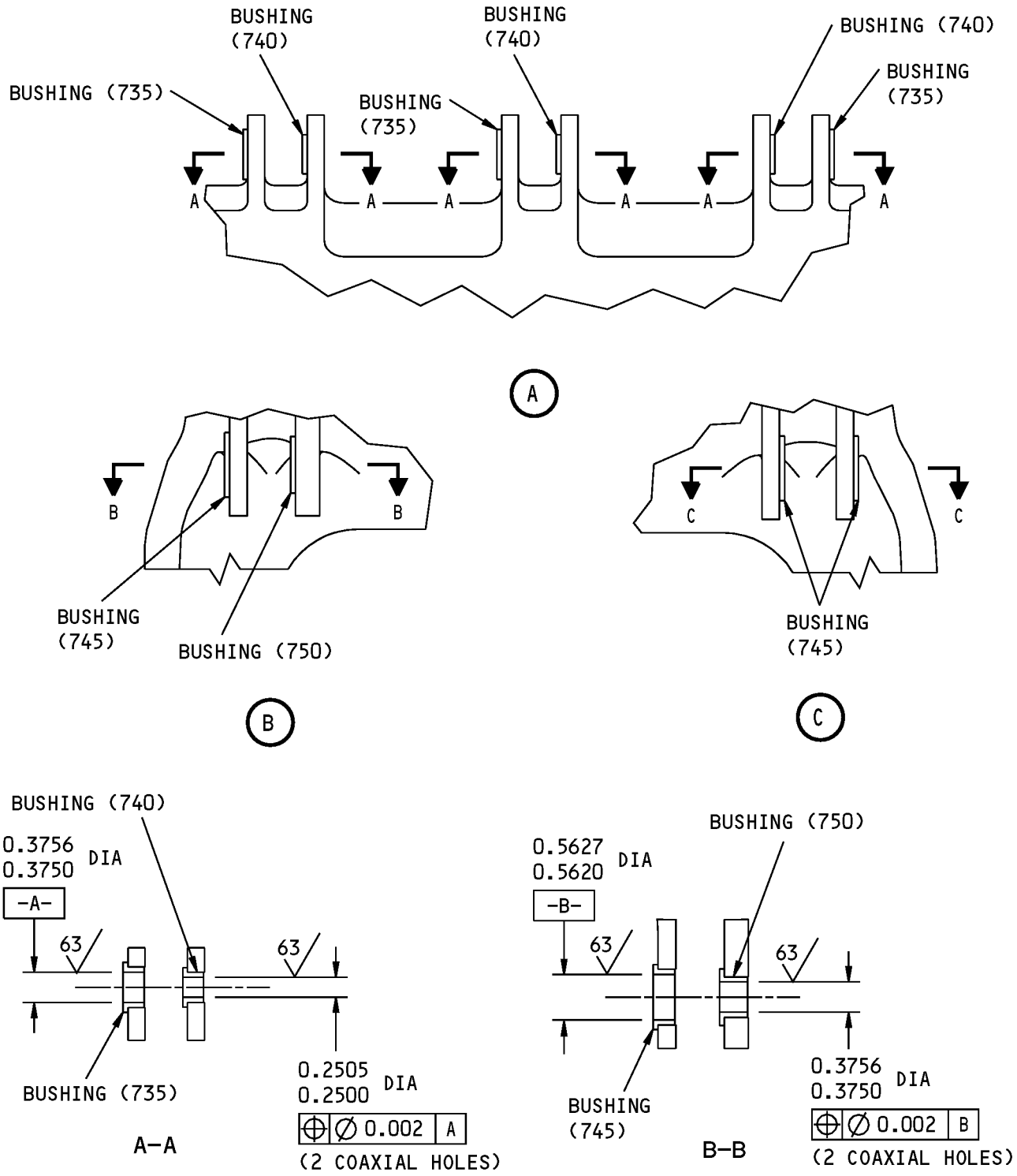
(5) Do a penetrant check of the bushing holes (SOPM 20-20-02).

(6) Use the shrink-fit method to install replacement bushings (735, 740, 745, 750, 755, 760) with sealant, A00247 (SOPM 20-50-03).

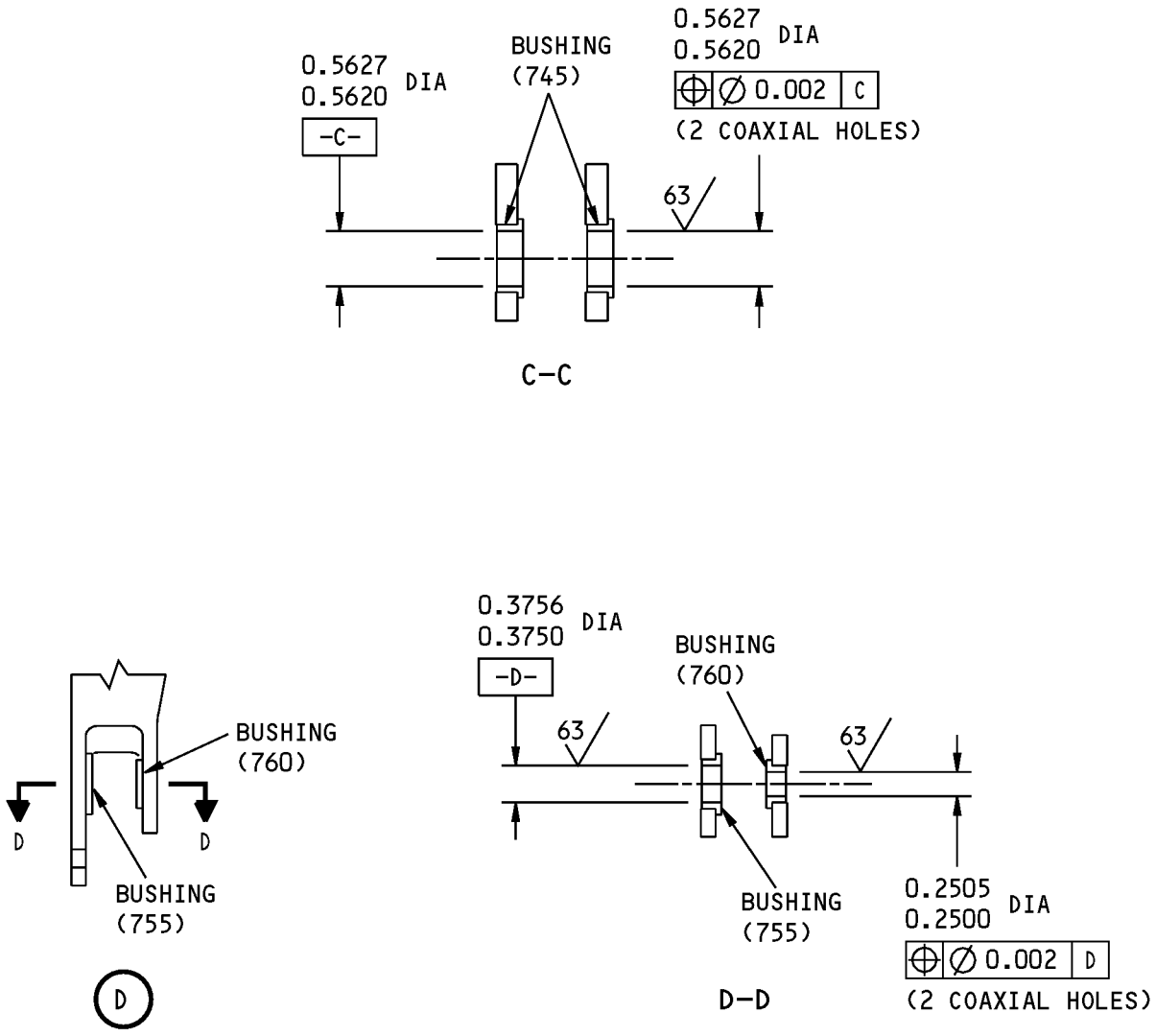
(7) Machine the bushing bores to design dimensions and finish (REPAIR 4-1, Figure 601).



144A6612-3 Hinge Arm Assembly Repair
Figure 601 (Sheet 1 of 3)



144A6612-3 Hinge Arm Assembly Repair
Figure 601 (Sheet 2 of 3)



125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

144A6612-3 Hinge Arm Assembly Repair
Figure 601 (Sheet 3 of 3)

HINGE - REPAIR 4-2

144A6612–1

1. General

A. This procedure has the data necessary to refinish the hinge (IPL Figure 1; 765).

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

C. Refer to IPL Figure 1 for item numbers.

2. Hinge Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I
C00260	Coating - Chemical And Solvent Resistant Finish, Epoxy Resin Enamel	BMS10-11, Type II

B. References

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

C. Procedure

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

(1) Remove the old finish from the hinge (765) (SOPM 20-30-02).

(2) Anodize (F-17.31) all surfaces.

(3) Apply primer, C00259 (F-20.02) to all surfaces, but not in the bushing holes.

(4) Apply enamel coating, C00260 (F-21.03) to all surfaces, but not in the holes.

LINK ASSEMBLY - REPAIR 5-1

144A6615–1

1. General

A. This procedure tells how to replace parts of the link assembly (IPL Figure 1; 670).

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

C. Refer to IPL Figure 1 for item numbers.

2. 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 20-20-02	PENETRANT METHODS OF INSPECTION
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT

C. Procedure

(1) Remove the old bearing (675) from the link (680) (SOPM 20-50-03).

(2) Make sure that the hole for the bearing (675) is 0.6250-0.6260 inch in diameter and has no defects.

(3) Do a penetrant check of the bearing hole (SOPM 20-20-02).

(4) Install a replacement bearing (675) with sealant, A00247 into the link and swage each side (SOPM 20-50-03).

LINK - REPAIR 5-2

144A6616–1

1. General

A. This procedure tells how to refinish the link (IPL Figure 1; 680).

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

C. Refer to IPL Figure 1 for item numbers.

2. Link (680) Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I

B. References

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

C. Procedure

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

(1) Remove the old finish from the link (680).

(2) Anodize (F-17.31) all surfaces.

(3) Apply primer, C00259 (F-20.03), but not in the bearing holes.

CRADLE ASSEMBLY - REPAIR 6-1

258A4702–3

1. General

A. This procedure tells how to replace parts of the cradle assembly (IPL Figure 2; 195).

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

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

D. Refer to IPL Figure 2 for item numbers.

2. Repair Procedures

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

Reference	Title
SOPM 20-20-02	PENETRANT METHODS OF INSPECTION
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-04	MISCELLANEOUS MATERIALS

C. Bushing Replacement

NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For miscellaneous materials, refer to SOPM 20-60-04.

(1) Remove the old bushings (205, 210) from the cradle (215) (SOPM 20-50-03).

(2) Make sure that the hole for the bushing (205) is 1.1875-1.1882 inches in diameter and has no defects.

(3) Make sure that the hole for the bushing (210) is 1.0000-1.0007 inches in diameter and has no defects.

(4) Do a penetrant check of the bushing holes (SOPM 20-20-02).

(5) Install replacement bushings (205, 210) by the shrink-fit procedure (SOPM 20-50-03) with sealant, A00247.

(6) Machine the bushings to design dimensions and finish (REPAIR 6-1, Figure 601).

D. Bearing Replacement

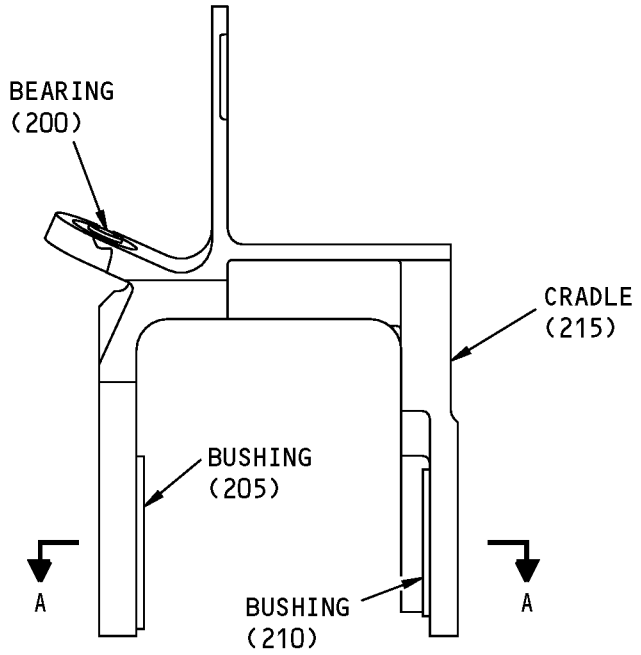
NOTE: For miscellaneous materials, refer to SOPM 20-60-04.

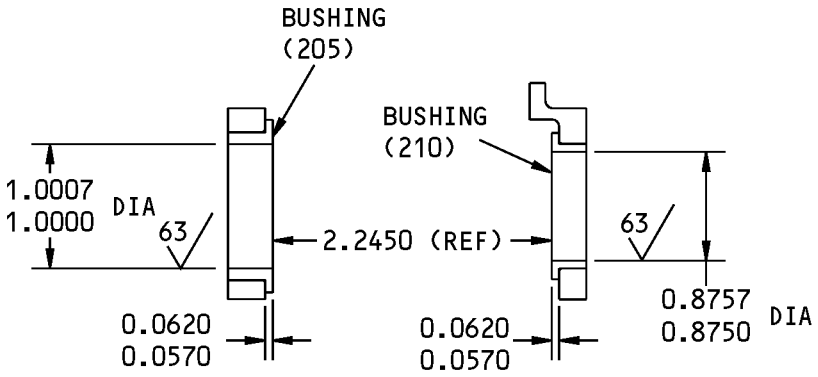
(1) Remove the old bearing (200) from the cradle (215) (SOPM 20-50-03).

(2) Make sure that the hole for the bearing (200) is 0.5625-0.5635 inch in diameter and has no defects.

(3) Do a penetrant check of the bearing hole (SOPM 20-20-02).

(4) Install a replacement bearing (200) with sealant, A00247 and ball stake the bearing at five equally spaced locations on each side (SOPM 20-50-03), but make the ball stakes 0.0050-0.0100 inch deep.





A–A

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

258A4702-3 Cradle Assembly Repair
Figure 601

CRADLE - REPAIR 6-2

258A4702–4

1. General

A. This procedure tells how to refinish the cradle (IPL Figure 2; 215).

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

C. Refer to IPL Figure 2 for item numbers.

2. Cradle Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I

B. References

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

C. Procedure

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

(1) Remove the old finish from the cradle (215) (SOPM 20-30-02).

(2) Anodize (F-17.31) all surfaces.

(3) Apply primer, C00259 (F-20.03), but not in the holes.

DAMPENER ASSEMBLY - REPAIR 7-1

144A6531–1, –2, –3, –4, –5, –6, –7

1. General

A. This procedure tells how to replace the damper (IPL Figure 1; 860, 865, 870, 875, 880, 885, 890).

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

C. Refer to IPL Figure 1 for item numbers.

2. Damper Replacement

A. References

Reference	Title
SOPM 20-30-03	GENERAL CLEANING PROCEDURES

B. Procedure

(1) Remove the stand-off damper and clean off remaining adhesive on the metal surface with solvent (SOPM 20-30-03).

(2) Do not let solvents touch plastics, lubricated areas, plastic decals, paints or markings that are not resistant to hydraulic fluid. If solvent gets on such surfaces, then reject the parts.

(3) Solvent clean surfaces mating with the stand-off damper within 1 hour before you apply the stand-off damper.

(4) Put the replacement stand-off damper in position and remove the release paper.

(5) Carefully press the central area into place. Then press the stand-off damper from the center towards the edges.

(6) Make sure there is no visible crushing of the semi-rigid foam core. All channels around the edge of the part must stay open.

ASSEMBLY

1. General

A. This procedure tells how to assemble the automatic overwing exit door assembly.

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

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

2. Assembly

A. Tools/Equipment

NOTE: Equivalent substitutes may be used.

Reference	Description
STD-405	Gauge - Feeler
STD-4529	Meter - OHM

B. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95
A00279	Adhesive - Fast-Setting Epoxy	BMS5-123 or BAC5010, Type 71
A01024	Compound - Fairing - 3M EC-3587B	BAC5530
A50009	Sealant - Low Density, Chromate Type Synthetic Rubber	BMS5-142, Class B-1/2
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I
C00528	Compound - Corrosion Preventive, Petroleum Hot Application (Soft Film)	MIL-C-11796, Class III
C00913	Compound - Corrosion Inhibiting Material, Nondrying Resin Mix	BMS 3-27
C50069	Coating - Enamel, Color 702 Gloss White	BMS10-11, Type II
C50148	Compound - Corrosion Preventative, Ardrox AV 30 (Formally Dinitrol AV 30)	BMS 3-29
D00015	Grease - Aircraft Bearing (Use BMS 3-24 until existing stocks are depleted, BMS 3-33 supersedes BMS 3-24)	BMS3-24 (Superseded by BMS 3-33)
D00633	Grease - Aircraft General Purpose	BMS3-33
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23

Reference	Description	Specification
G02409	Compound - Corrosion Inhibiting, Ardrox AV 8 (Formally Dinitrol AV 8)	BMS 3-23

C. References

Reference	Title
SOPM 20-11-03	REPAIR OF ELECTRICAL TERMINATIONS AND ELECTRICAL BONDING AREAS
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-41-05	APPLICATION OF CORROSION INHIBITING COMPOUNDS
SOPM 20-50-01	BOLT AND NUT INSTALLATION
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-50-11	APPLICATION OF AERODYNAMIC SMOOTHING SEALANT
SOPM 20-50-19	GENERAL SEALING
SOPM 20-60-02	FINISHING MATERIALS
SOPM 20-60-03	LUBRICANTS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

D. Procedure

CAUTION: DO NOT APPLY CORROSION INHIBITING COMPOUNDS TO THE FLIGHT LOCK SOLENOID OR OTHER PARTS THAT MOVE. IF YOU APPLY SUCH COMPOUNDS ON THE FLIGHT LOCK SOLENOID, IT IS POSSIBLE THAT THE DOOR WILL NOT LOCK IN THE CLOSED POSITION.

NOTE: For repair of electrical terminations and electrical bonding areas, refer to SOPM 20-11-03. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For bolt and nut installation, refer to SOPM 20-50-01. For finishing materials, refer to SOPM 20-60-02. For lubricants, refer to SOPM 20-60-03. For miscellaneous materials, refer to SOPM 20-60-04.

(1) Use standard industry procedures and these steps.

(2) Apply post assembly sealant to the automatic overwing exit door assembly as follows:

(a) Apply 3M EC-3587B compound, A01024 or optional adhesive, A00279 as shown by flagnote 2 in ASSEMBLY, Figure 706 (SOPM 20-50-19).

1) No voids, ripples or bumps allowed in compound.

2) Surface to be equivalent to 125AA micro inches finish.

(b) Apply an aerodynamic seal as shown by flagnote 1 in ASSEMBLY, Figure 706 (SOPM 20-50-11). Exterior gap must be flush with skin surface.

(c) Fill gaps using injection or prepack method with sealant, A00247 as shown by flagnote 3 in ASSEMBLY, Figure 706 (SOPM 20-50-19).

(d) Apply fillet seal using sealant, A00247 or sealant, A50009 as shown by flagnote 4 in ASSEMBLY, Figure 706 (SOPM 20-50-19).

NOTE: When applying fillet seal to cavity common to lower edge of handle assembly and handle frame, use parting agent on surface of handle assembly.

(e) Sealant to be cured before applying primer.

(f) Apply primer, C00259 (F-14.9962) and enamel coating, C50069 (F-21.17) as shown in REPAIR 2-1.

CAUTION: AVOID ACCUMULATIONS OF CORROSION INHIBITING COMPOUND THAT CAUSE DIFFICULTY FOR IN-SERVICE INSPECTION OF UNDERLYING STRUCTURE.

(g) Apply corrosion inhibiting compound, G00009 (Ardrox AV 8 compound, G02409 or Ardrox AV 30 compound, C50148 optional) (F-19.26) as shown in ASSEMBLY, Figure 707 (SOPM 20-41-05)

NOTE: Corrosion inhibiting compound shall not be applied to surfaces that subsequently will be painted or sealed. Take precautions to prevent contamination of such areas when applying to adjoining areas.

(3) If necessary, install the plate assembly (IPL Figure 3; 140, 145) onto the door assembly.

(a) See IPL Figure 3 for item numbers unless specified differently.

(b) Install the plate assembly (140, 145) with the bolts (90, 95, 100), the washers (105, 110, 115), the bushing (135) (SOPM 20-50-03), and the nuts (120, 125, 130).

(c) Adjust the roller plate assembly (140, 145) until the dimension between the washer (105) and the edge of the slot is 0.020 inch on each side of the bolt (95) as shown in ASSEMBLY, Figure 701.

(d) Tighten the bolts (95) to 65-100 pound-inches.

(4) If necessary, assemble the lock assembly (IPL Figure 2; 75).

(a) See IPL Figure 2 for item numbers unless specified differently.

(b) Press the bearings (175) into the cradle assembly (195) with grease, D00633 (SOPM 20-50-03).

(c) Install the pawl shaft (190), the bushings (170) (SOPM 20-50-03), the washers (150, 155), the nut (165), and the bolt (140).

(d) Tighten the nut (165) to 90-125 pound-inches.

(e) Use the steps shown below to adjust the flight lock switch (180A) (ASSEMBLY, Figure 705).

(f) Install the switch (180A) with the bolts (130, 135), the washers (145), and the nuts (160).

(g) Install the solenoid (185) into the cradle assembly (195) as shown in ASSEMBLY, Figure 702.

NOTE: If the plunger of the replacement solenoid has a rubber stop, washer, and C-clip on it, remove and discard them before you install the solenoid into the cradle assembly.

(h) Install the solenoid washer with wet primer, C00259, then install the solenoid nut and tighten it to 125-150 pound-inches.

(i) Turn the stop tube (460) so that the pawl stop is 0.09-0.29 inch from the pawl (IPL Figure 1; 575, 580) and pawl (IPL Figure 1; 575, 580) touches along the outer surface of the stop tube (460).

NOTE: After the switch (180A) is adjusted, these parts are a matched set with this door and must be installed only in this door.

(j) Push pawl (IPL Figure 1; 575, 580) against the pawl stop until the pawl (IPL Figure 1; 575, 580) touches the outer surface of the stop tube (460).

(k) Make sure the clearance between the rigging edge of the switch (180A) and the pawl (IPL Figure 1; 575, 580) is 0.016 inch.

NOTE: Do not measure the clearance at the radius of the pawl.

(l) Adjust the clearance between pawl (IPL Figure 1; 575, 580) and the edge of switch (180A).

NOTE: The switch roller will be compressed by the pawl (IPL Figure 1; 575, 580).

1) Move the feeler gauge, STD-405 gently between the switch roller and the pawl (IPL Figure 1; 575, 580).
2) Push the feeler gauge, STD-405 to the edge of the switch (180A).

NOTE: The pawl must not touch the switch (180A).

3) Tighten the switch mounting bolts (130, 135) evenly and remove the feeler gauge, STD-405.

(m) Do these steps to make sure the minimum clearance is correct:

1) Use the feeler gauge, STD-405 to measure the clearance between the pawl (IPL Figure 1; 575, 580) and the edge of the switch (180A).
2) Move the feeler gauge, STD-405 gently between the switch edge and the pawl (IPL Figure 1; 575, 580).
3) Push the feeler gauge, STD-405 to the edge of the switch (180A).
4) Make sure a 0.011 inch feeler gauge, STD-405 will move between the edge of the switch (180A) and the pawl (IPL Figure 1; 575, 580).

NOTE: Do not measure the clearance at the radius of the pawl (IPL Figure 1; 575, 580).

NOTE: Do the clearance adjustment of 0.016 inch again if the 0.011 inch feeler gage does not move between the pawl (IPL Figure 1; 575, 580) and the switch (180A).

(n) Do these steps to make sure the minimum clearance is correct:

1) Use feeler gauge, STD-405 to measure the clearance between the pawl (IPL Figure 1; 575, 580) and the rigging edge of the switch (180A).

NOTE: The switch roller will be compressed by the pawl (IPL Figure 1; 575, 580).

2) Move the feeler gauge, STD-405 gently between the switch roller and the pawl (IPL Figure 1; 575, 580).
3) Push the feeler gauge, STD-405 to the rigging edge of the switch (180A).

4) Make sure a 0.021 inch feeler gauge, STD-405 will move between the rigging edge of the switch (180A) and the pawl (IPL Figure 1; 575, 580).

NOTE: Do not measure the clearance at the radius of the pawl (IPL Figure 1; 575, 580).

NOTE: Do the clearance adjustment of 0.016 inch again if the feeler gage does not move between the pawl (IPL Figure 1; 575, 580) and the switch (180A).

(o) Release the pawl shaft from stop tube (460) and connect the leads of the switch to the OHM meter, STD-4529.

(p) Slowly turn the pawl shaft (push near the stop tube) until pawl (IPL Figure 1; 575, 580) touches the stop tube (460).

1) Make sure the OHM meter, STD-4529 shows continuity across the switch (180A).

(q) Install the pin (85), the washer (100), and cotter pin (80).

(r) Install the bolt (90), the washers (105, 110), the bushing (95) (SOPM 20-50-03), the spring retainer (125), and the nut (115), then install the spring (120).

NOTE: Align the spring retainer (125) with the spring (120) as shown in ASSEMBLY, Figure 702.

(5) If necessary, install the lock assembly (IPL Figure 2; 75) onto the door assembly.

NOTE: See IPL Figure 2 for item numbers unless specified differently.

(a) Install the lock assembly (75) with the bolt (5), and the washer (15).

(6) If necessary, install the handle mechanism assembly (IPL Figure 1; 310) onto the door assembly.

NOTE: See IPL Figure 1 for item numbers unless specified differently.

(a) Apply a thin layer of grease, D00633 or grease, D00015 to the mating surfaces of springs, torque tube (490), stop tube (460) and door lock crank assemblies (420,425).

(b) If necessary, remove one of the bearings (385) from the side of the door assembly and install the torque tube (490) with the handle (465), stop tube (460), spacer (390), springs (395A), flight lock assembly (770), and sleeves (400, 405, 410) into the door assembly.

(c) Install bearings (385) into the door assembly with sealant, A00247 (SOPM 20-50-03).

(d) Install the door lock crank assemblies (420, 425) and shims (370, 375, 380) into the door assembly with the bolts (315A, 330), the washers (335, 345, 350, 355), and nuts (360).

NOTE: You can use any combination of shims (370, 375, 380) to make the gaps equal on each side between the handle (465) and the skin cutout as shown in ASSEMBLY, Figure 703. Make sure the end play is not more than 0.02 inch.

(e) Install bolts (325), washers (340, 345), bushings (365) and nuts (360) through the sleeves (405, 415) and adjacent to the springs (395A).

(f) Apply primer, C00259 (SRF-14.06) to the holes.

(g) Turn the torque tube (490) 217 degrees to load the springs (395A), then install the nutplate strap assembly (470) with sealant, A00247 (SOPM 20-50-19) and the bolts (320) with compound, C00528 (F-19.11).

(h) Measure the handle force. To do this, pull the handle (465) towards the inner flange of the door frame at the bottom center of the door. The force must be 12.0 - 18.0 lbs.

(i) Remove unwanted grease, D00633 or grease, D00015 from the torque tube (490), stop tube (460) and door lock crank assemblies (420, 425).

(7) If necessary, assemble the arm assembly (IPL Figure 1; 615).

NOTE: See IPL Figure 1 for item numbers unless specified differently.

(a) Install the link assembly (670) with the bolt (645), the washers (650, 655), the bushing (665) (SOPM 20-50-03), and the nut (660).

(b) Loosely install the shims (605, 610, 720, 725) and the latch receiver (710, 715) onto the arm assembly with the bolts (685, 690), the washers (695, 700), and the nuts (705).

NOTE: The shims and latch receiver will be tightened when the arm assembly (615) is installed onto the door assembly.

(c) Connect the jumpers (640) with the bolts (620), washers (625, 630) and nut (635) as specified in SOPM 20-11-03.

(8) If necessary, install the arm assembly (IPL Figure 1, 615) onto the door assembly.

NOTE: See IPL Figure 1 for the item numbers unless specified differently.

(a) Install the arm assembly (615) with the bolts (505), washers (515, 520), bushings (540, 545) (SOPM 20-50-03) and nuts (535).

(b) Connect the jumpers (640) to the door structure with bolts (510), washers (515, 525), and nuts (535) as specified in SOPM 20-11-03.

(9) If necessary, install the hinge arm assembly (IPL Figure 1; 495) onto the door assembly.

NOTE: See IPL Figure 1 for the item numbers unless specified differently.

(a) Install the lock crank assembly (550, 555), the spring (590, 595), the sleeve (600), and the washers (530, 532) with the pins (500) as shown in ASSEMBLY, Figure 704.

NOTE: Use washers (530, 530A) as necessary for free operation of the pawl (575, 580). Add one NAS1149E0616 washer (532) if necessary to remove end play of the pawl (575, 580) that is more than 0.016 inch.

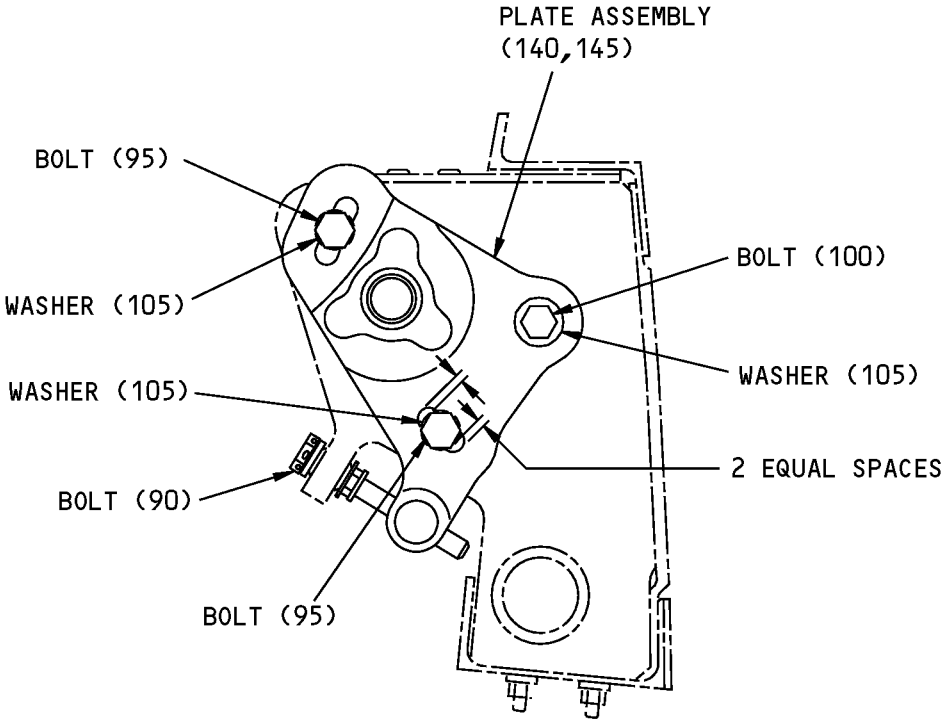
(b) Adjust the shims (605, 610, 720, 725) to get the end play as shown in ASSEMBLY, Figure 704.

1) Add or remove shims (605, 610, 720, 725) in any combination until the end play at the forward end of the door assembly plus the end play at the aft end of the door assembly equals 0.02-0.06 inch. The maximum stack up of shims is 0.160 inch at each location.

NOTE: This is a preliminary setting. The final end play will be set at door installation.

WARNING: BMS 3-27 CORROSION PREVENTIVE COMPOUND CONTAINS ASBESTOS, TOLUENE, XYLENE, STRONTIUM CHROMATE AND BARIUM CHROMATE. SPEAK TO THE APPLICABLE SAFETY-STANDARDS PERSONS FOR APPROVED HANDLING PRECAUTIONS.

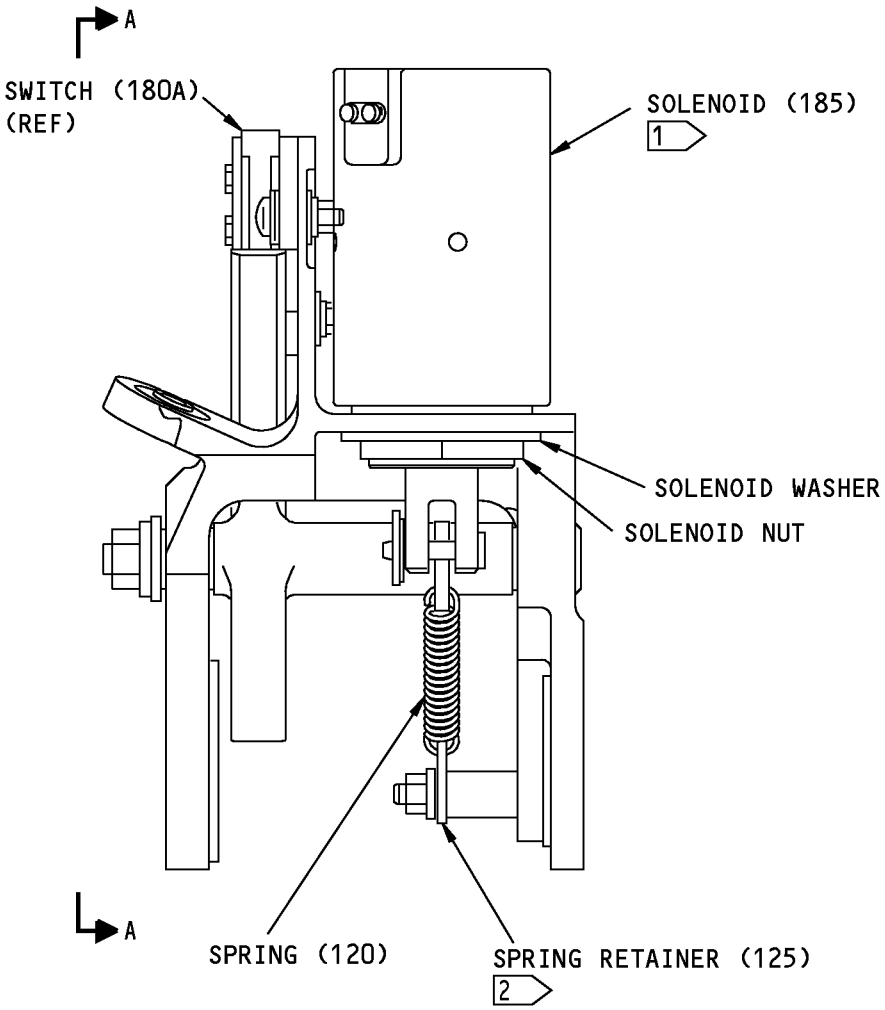
(c) After the end play is adjusted, apply compound, C00913 to each side of all the shims (605, 610, 720, 725) and to the bolts (685, 690). Then install the shims (605, 610, 720, 725) and the latch receivers (710, 715) with the bolts (685, 690), washers (695, 700), and nuts (705).



ITEM NUMBERS REFER TO IPL FIG. 3

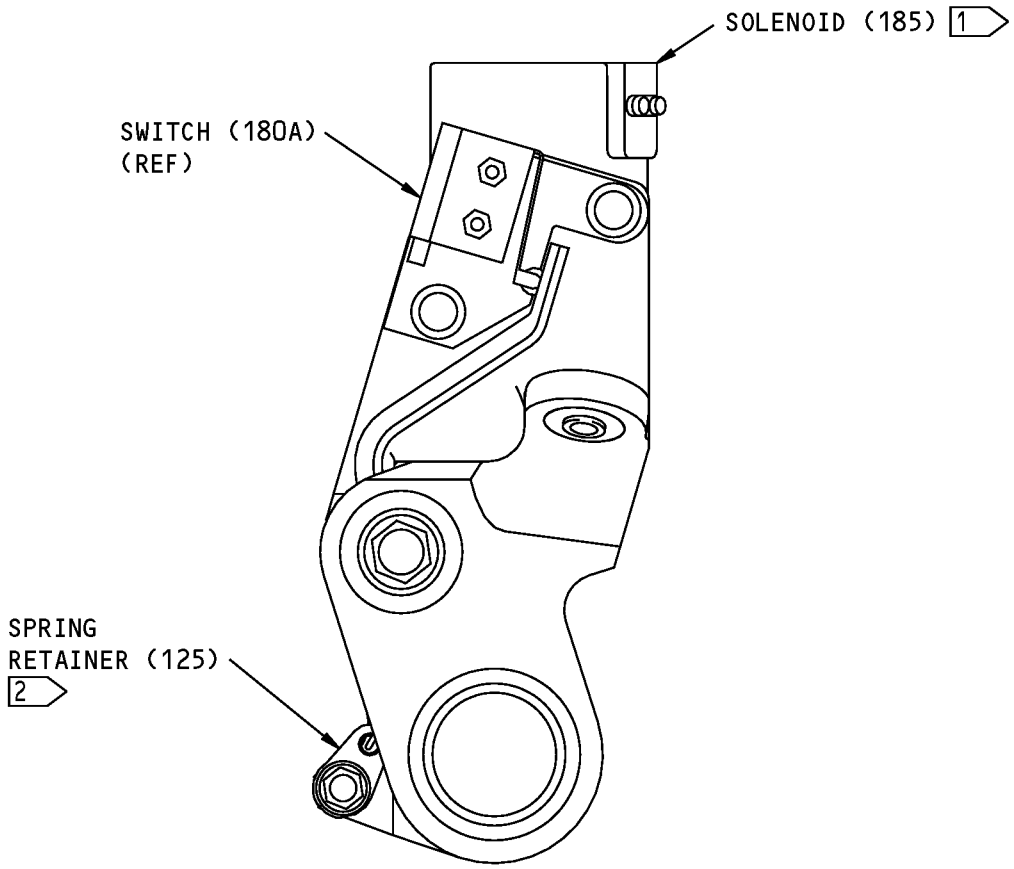
ALL DIMENSIONS ARE IN INCHES

Plate Assembly
Figure 701



K03725 S00041000976_V2

Flight Lock Assembly
Figure 702 (Sheet 1 of 2)

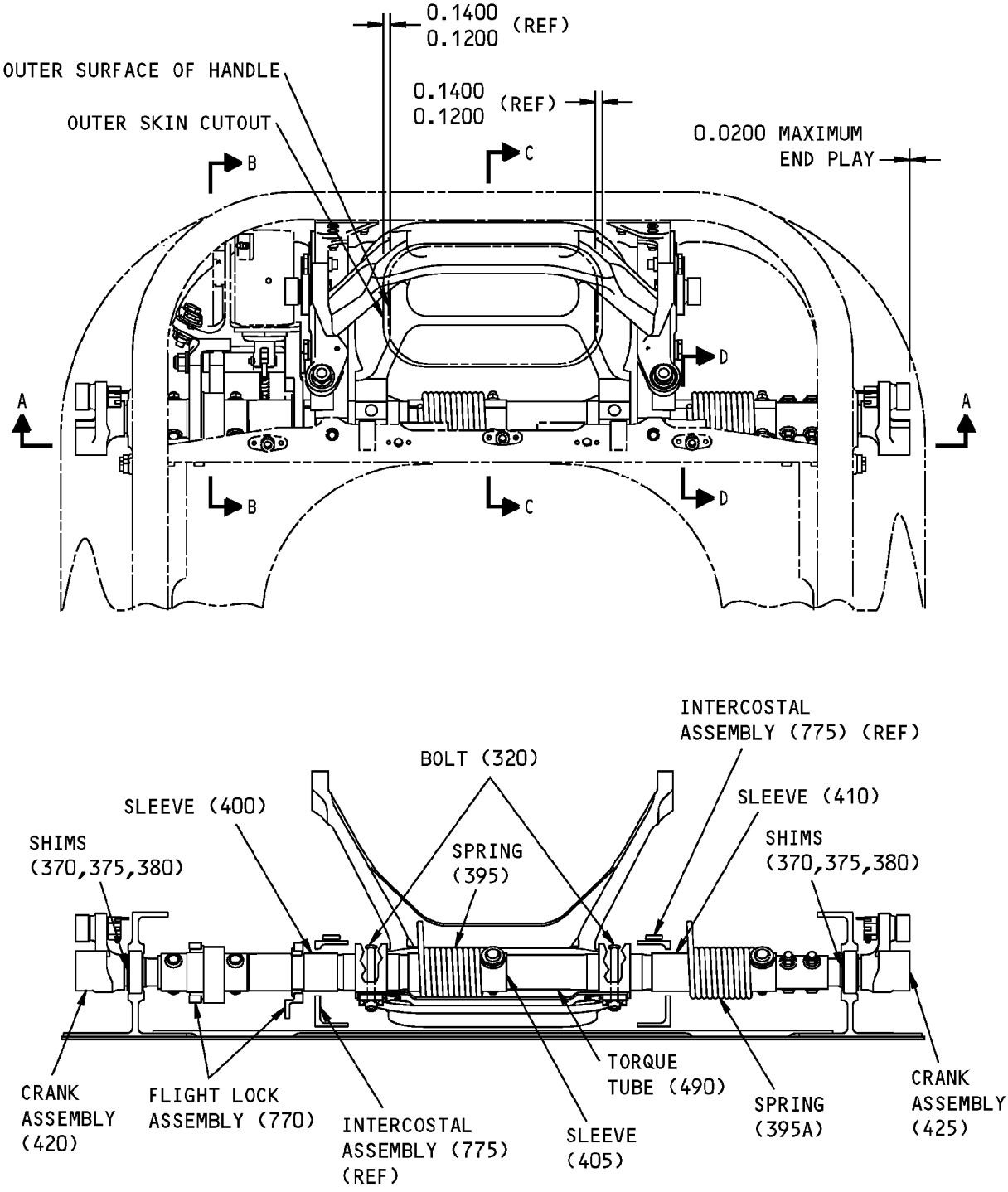


1 PUT THE SOLENOID IN THE POSITION SHOWN

2 ALIGN THE SPRING RETAINER WITH THE SPRING ±5°

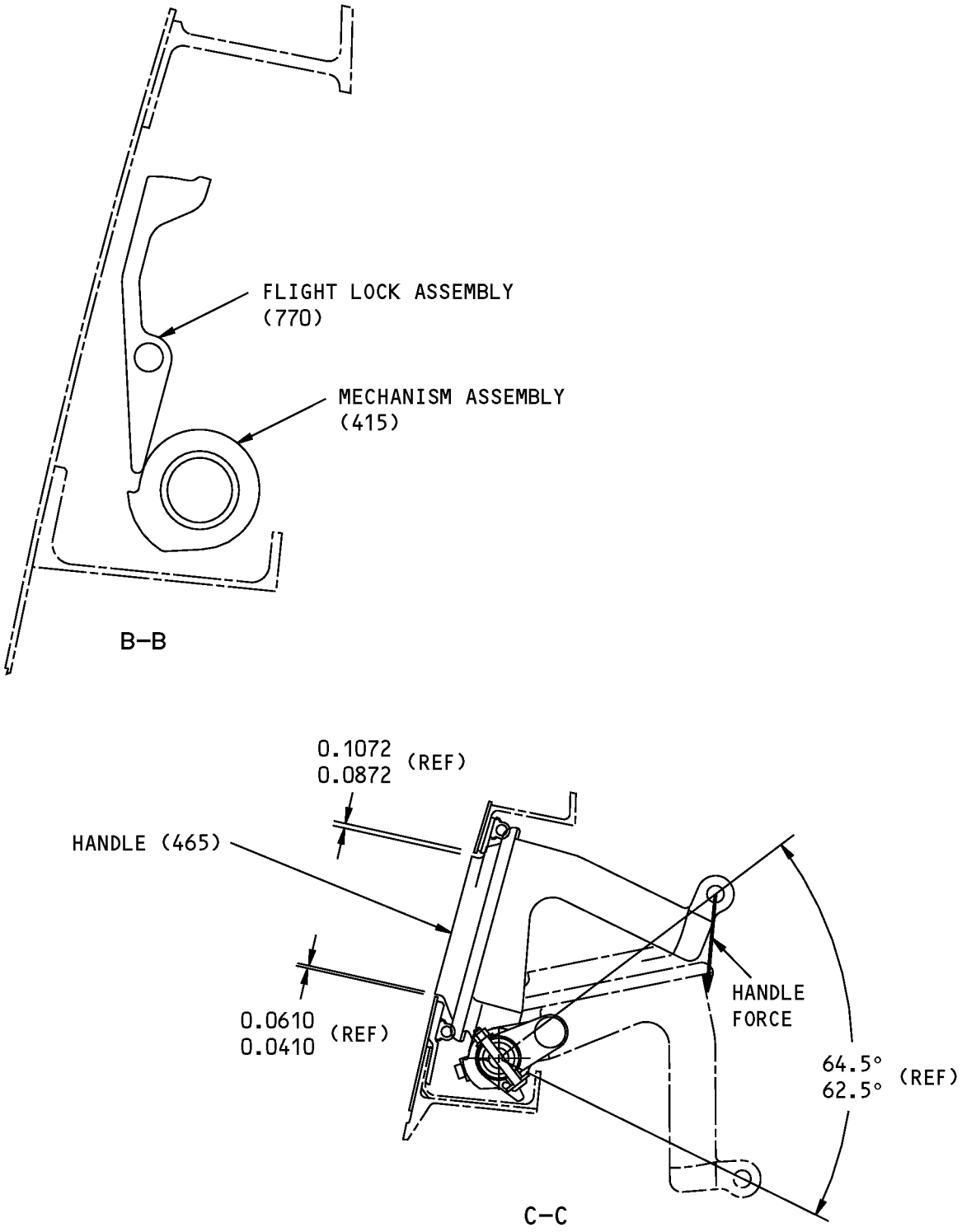
ITEM NUMBERS REFER TO IPL FIG. 2

Flight Lock Assembly
Figure 702 (Sheet 2 of 2)

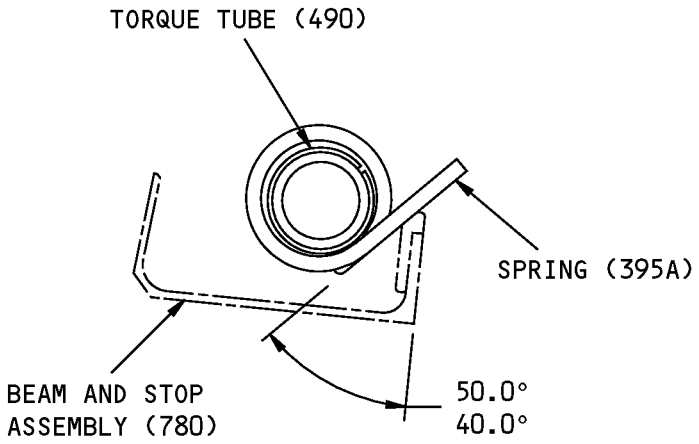


A–A

Handle Mechanism Assembly
Figure 703 (Sheet 1 of 3)



Handle Mechanism Assembly
Figure 703 (Sheet 2 of 3)

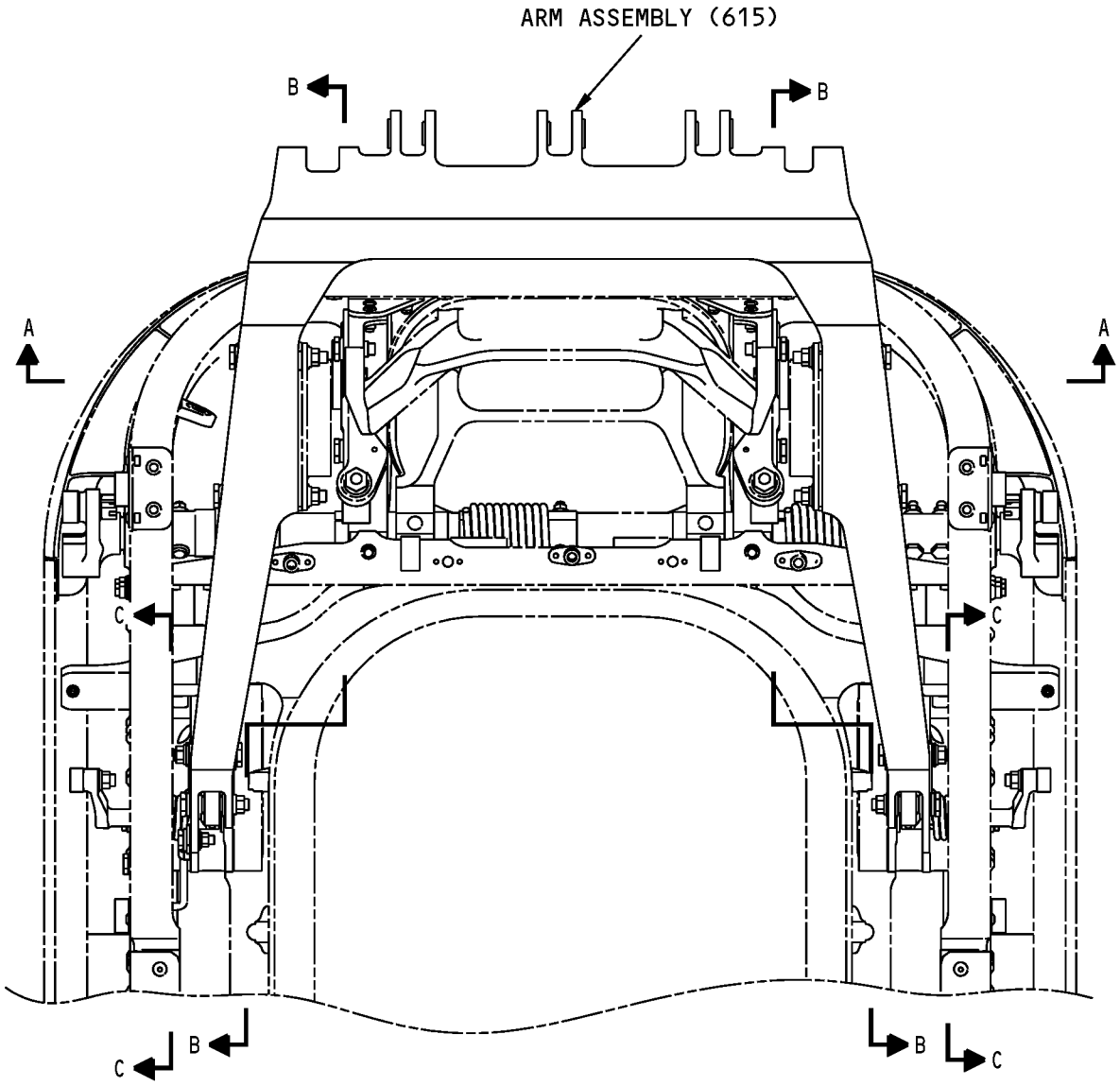


D–D

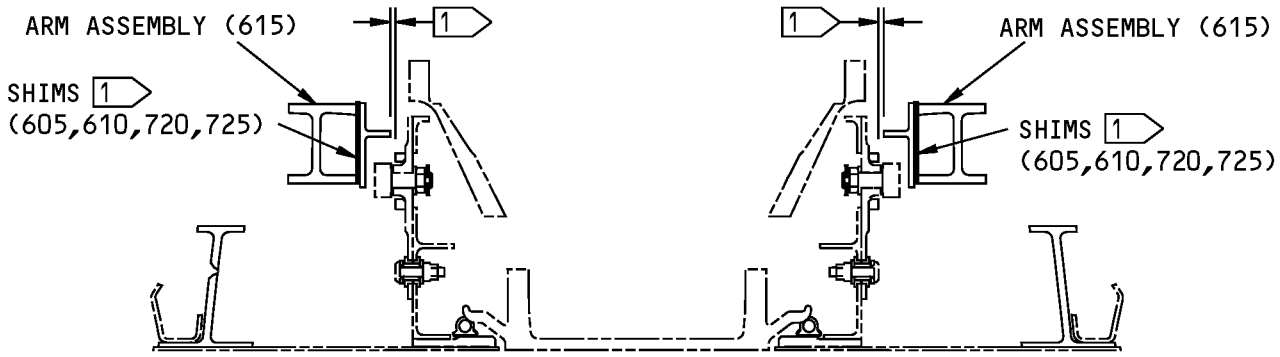
ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

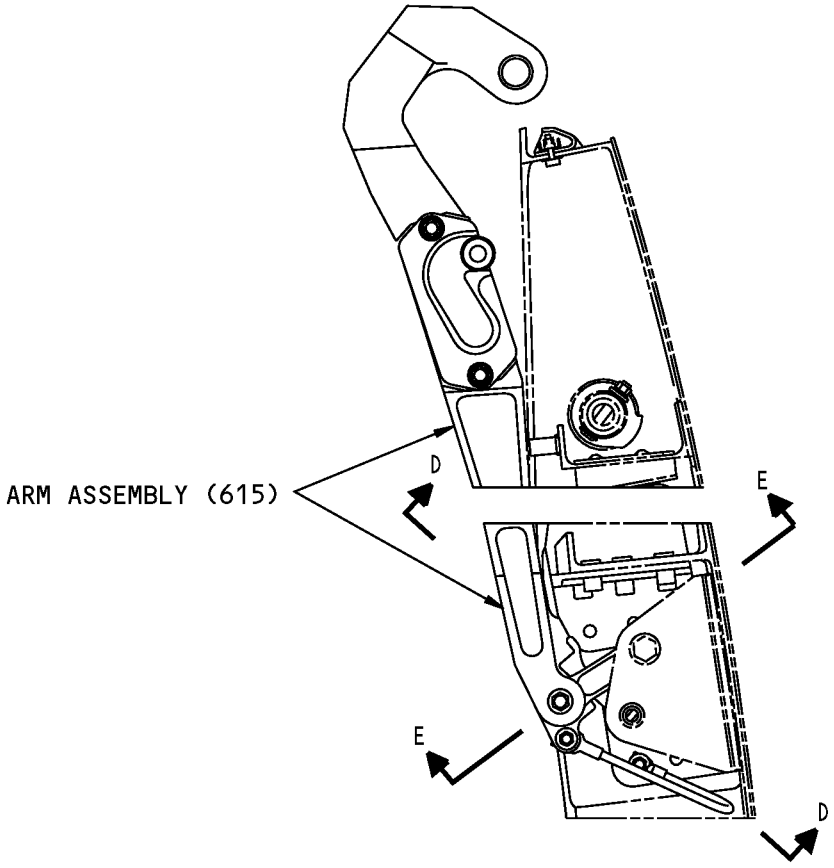
Handle Mechanism Assembly
Figure 703 (Sheet 3 of 3)



Hinge Arm Assembly
Figure 704 (Sheet 1 of 4)

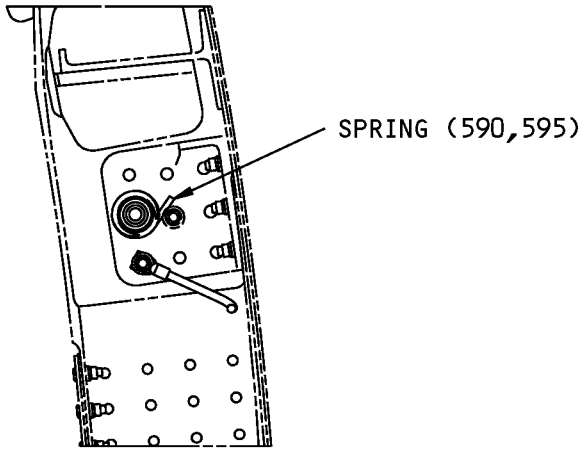


A–A

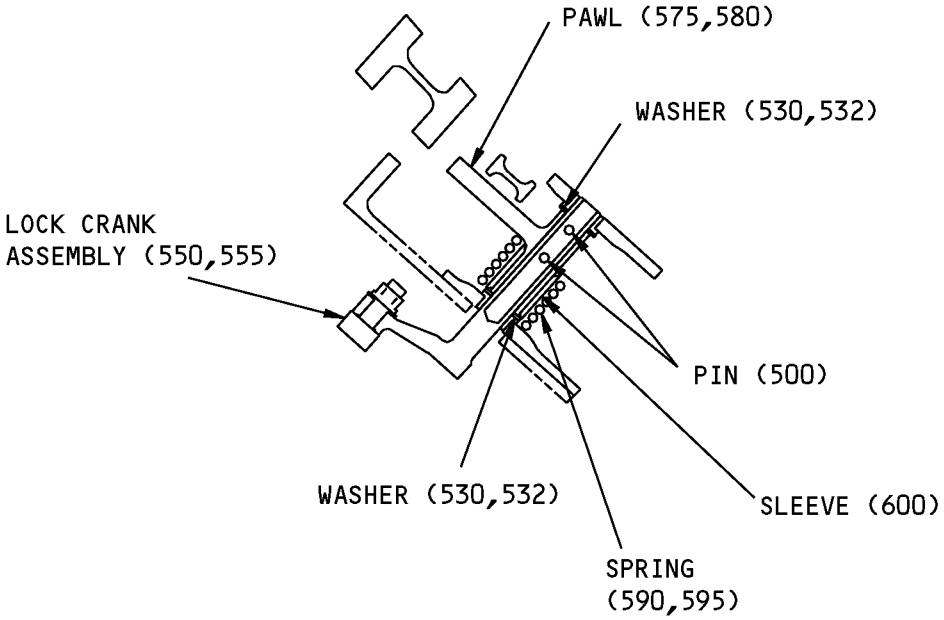


B–B

Hinge Arm Assembly
Figure 704 (Sheet 2 of 4)

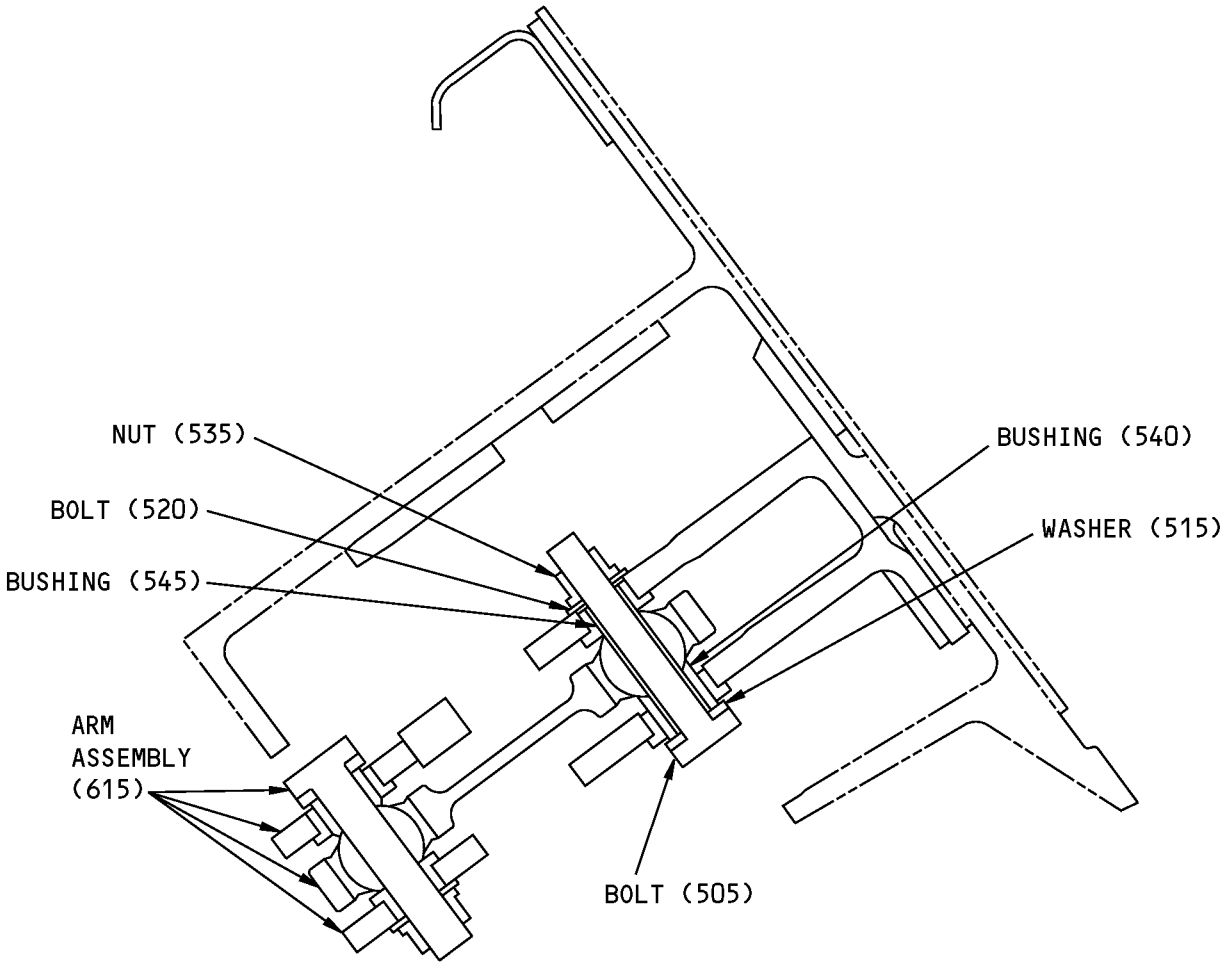


C–C



D–D

Hinge Arm Assembly
Figure 704 (Sheet 3 of 4)

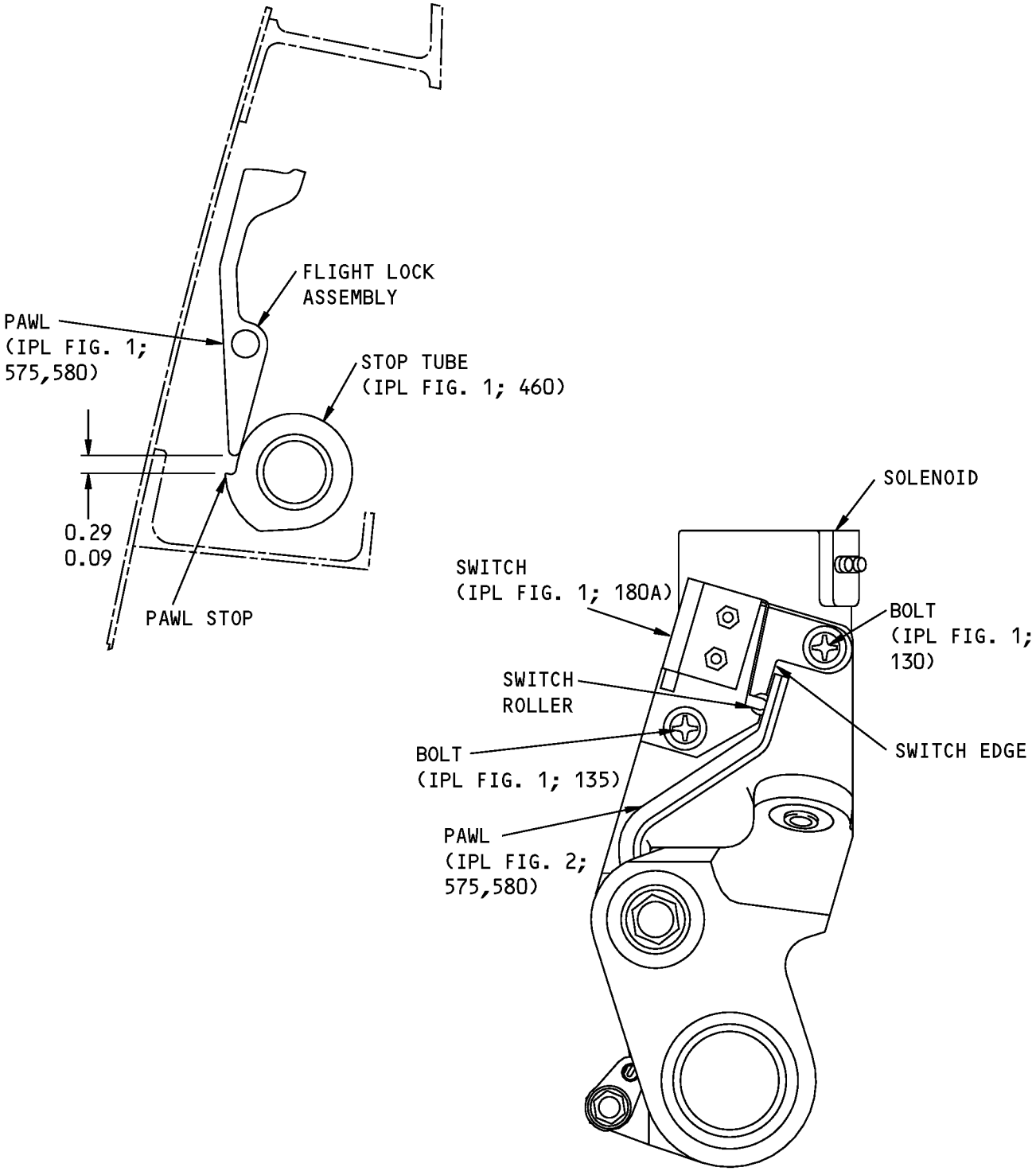


1 TOTAL END PLAY AT EACH LOCATION MUST BE 0.02-0.06 INCH. ADJUST THE SHIMS AS NECESSARY TO GET THIS END PLAY

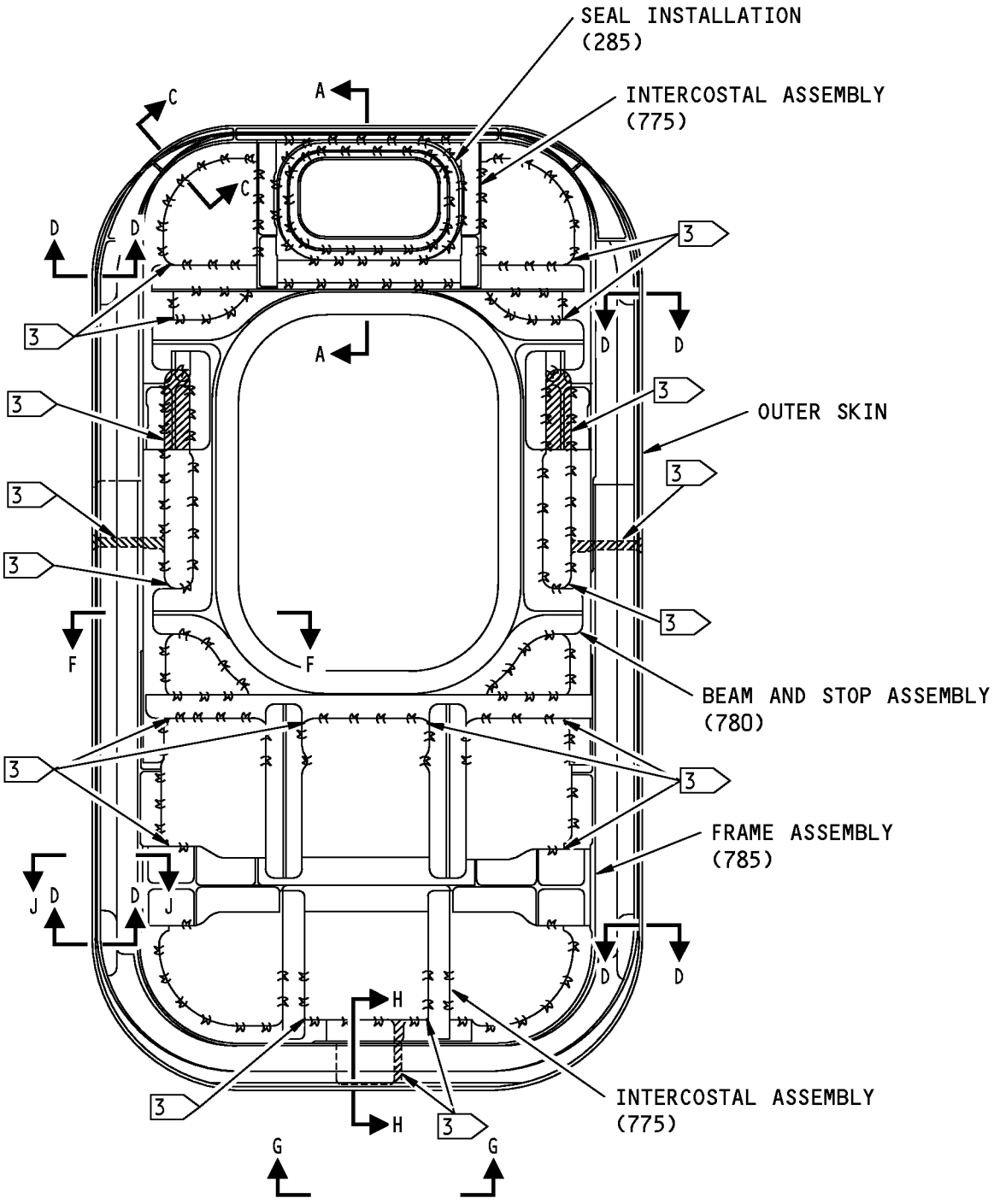
ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

Hinge Arm Assembly
Figure 704 (Sheet 4 of 4)



Flight Lock Switch Rigging
Figure 705

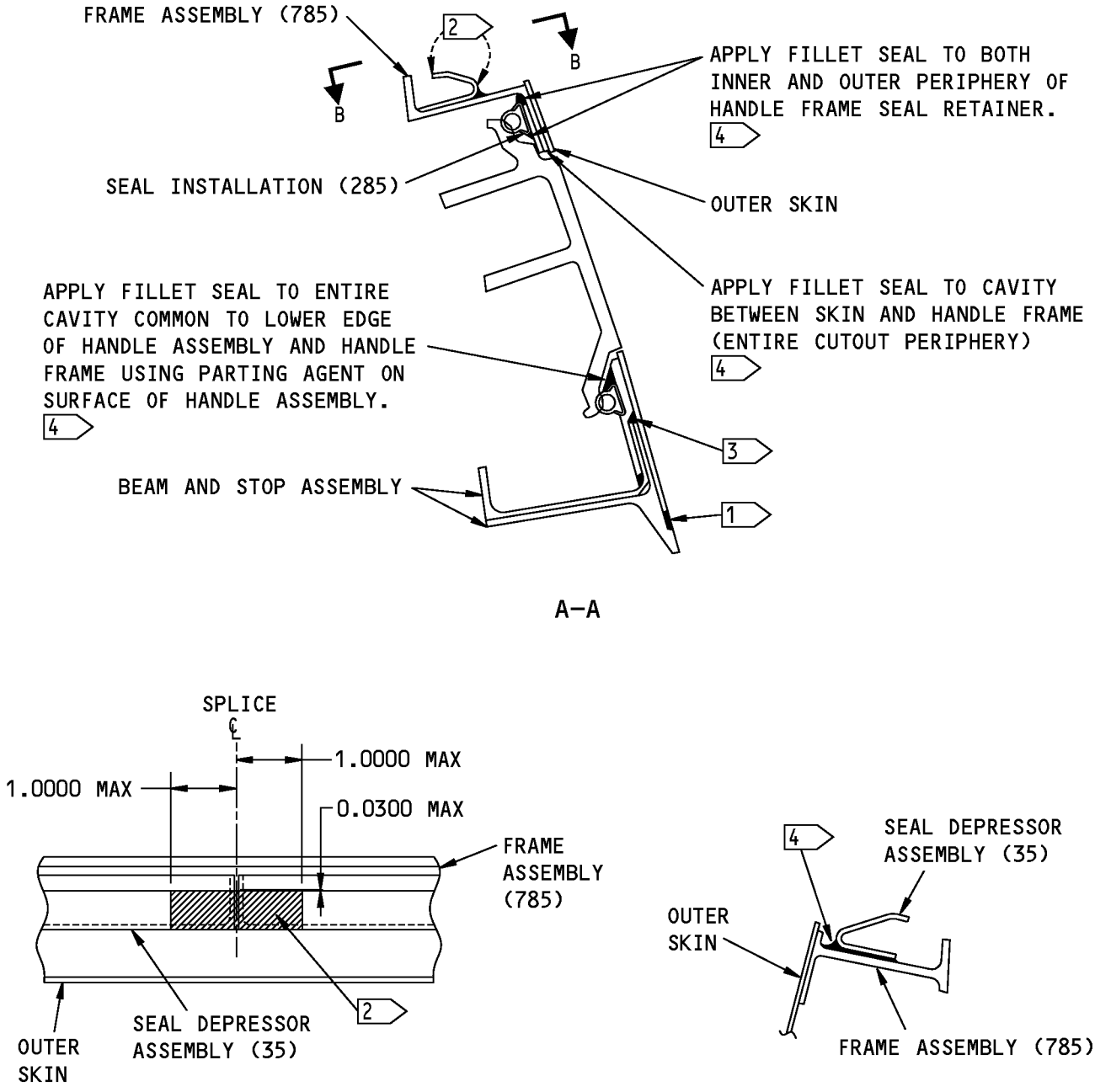


144A6505-1 THRU -10

W PRESSURE FILLET SEAL

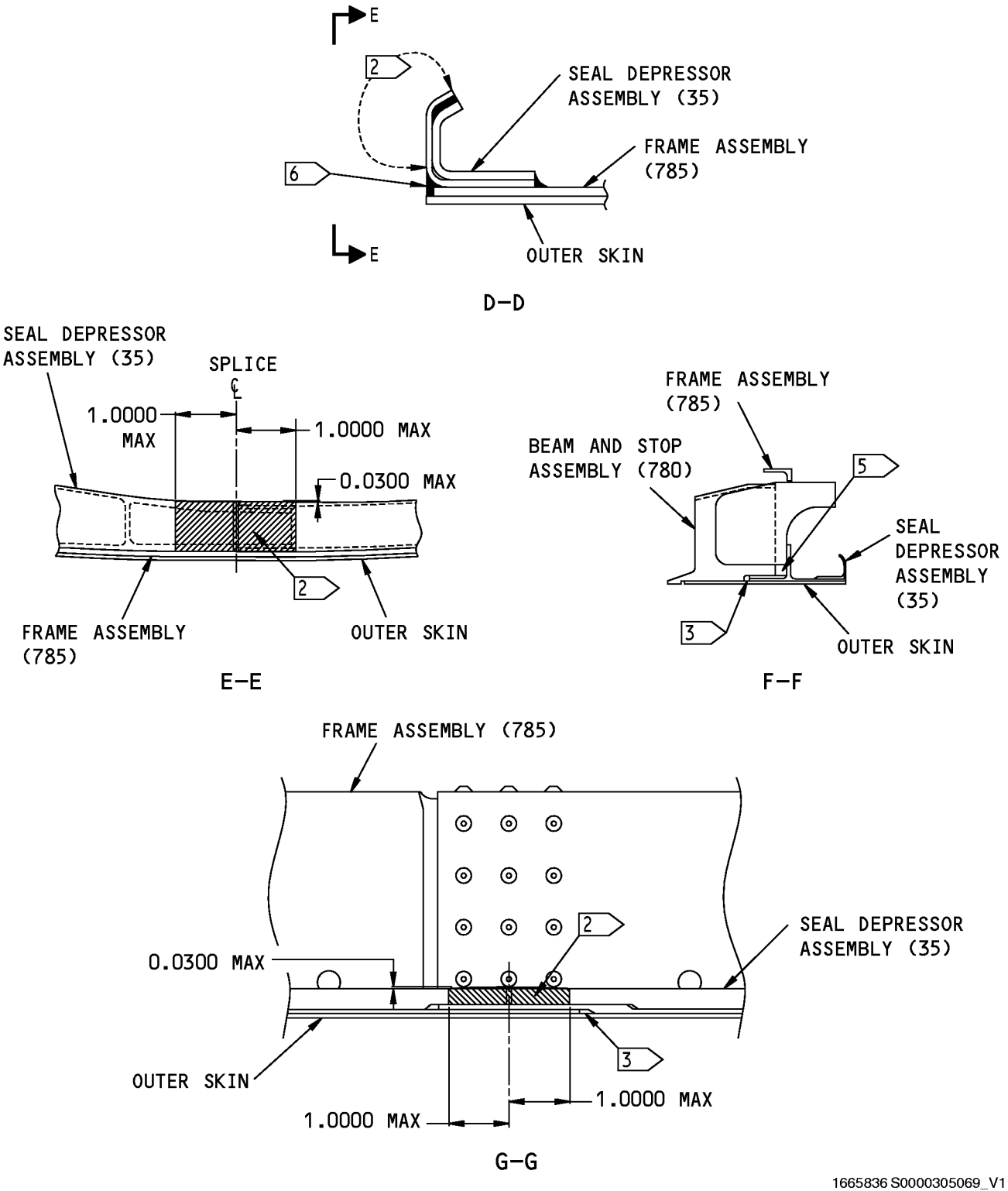
1665742 S0000305067_V1

Automatic Overwing Exit, Door Assembly - Seal Application
Figure 706 (Sheet 1 of 4)



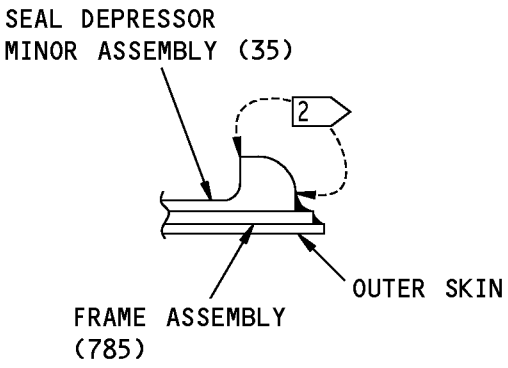
1665797 S0000305068_V1

Automatic Overwing Exit, Door Assembly - Seal Application
Figure 706 (Sheet 2 of 4)

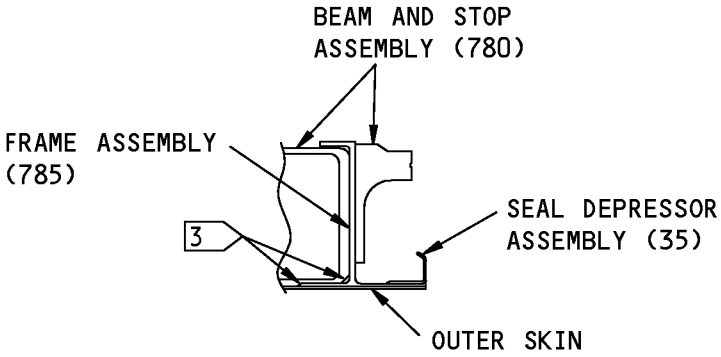


1665836 S0000305069_V1

Automatic Overwing Exit, Door Assembly - Seal Application
Figure 706 (Sheet 3 of 4)



H–H



J–J

1> APPLY AERODYNAMIC SEAL AS SPECIFIED IN SOPM 20-50-11. EXTERIOR GAP MUST BE FLUSH WITH SKIN SURFACE

2> APPLY BMS 5-142 SEALANT OR OPTIONAL BMS 5-123 ADHESIVE TO THESE SURFACES

3> APPLY BMS 5-95 SEALANT USING SEAL INJECTION OR PREPACK (LEAVE SUFFICIENT EXTRUSION FOR FILLET SEAL CONTACT)

4> APPLY FILLET SEAL USING BMS 5-95 OR BMS 5-142 SEALANT

5> DO NOT APPLY SEALANT TO THIS SURFACE

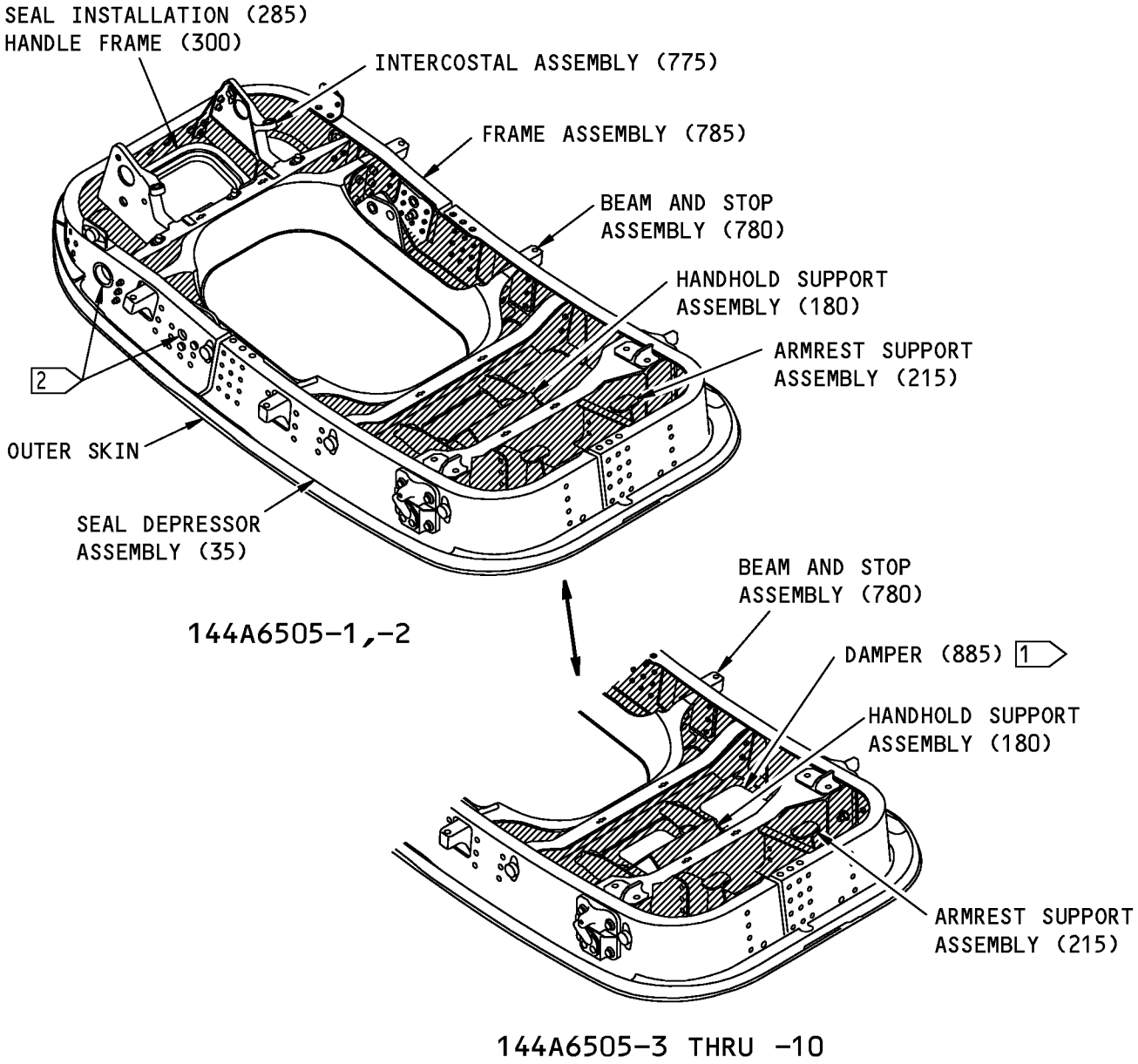
6> FILL GAP AS SHOWN WITH BMS 5-95 SEALANT ALONG FORWARD AND AFT EDGE OF DOOR FOR 3.00 ±1.00 INCHES AROUND CORNER BEYOND SPLICE. PRESSURE FILLET SEAL REMAINDER OF PERIPHERY.

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

1665837 S0000305303_V1

Automatic Overwing Exit, Door Assembly - Seal Application
Figure 706 (Sheet 4 of 4)



APPLY BMS 3-23 CORROSION INHIBITING COMPOUND (ARDROX AV 8, ADROX AV 30 OPTIONAL) TO ALL ACCESSIBLE SURFACES WITHIN AREAS INDICATED, EXCEPT AS NOTED

1 DO NOT APPLY CORROSION INHIBITING COMPOUND TO PANELS OR PLUG DRAINAGE PATHS ON EDGES OF PANELS

2 DO NOT APPLY CORROSION INHIBITING COMPOUND TO ANY MOVING PARTS, BUSHINGS, BEARINGS OR GROUND STRAP STUDS

1665845 S0000305070_V1

Automatic Overwing Exit - Corrosion Inhibiting Compound Application
Figure 707

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
04169	WESTERN SKY INDUSTRIES A DIVISION OF ATLAS CORPORATION 1280 SAN LUIS OBISPO STREET HAYWARD, CALIFORNIA 94544-7916 FORMERLY WESTERN SKY IND VB0008
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
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

Code	Name
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.
17446	HUCK INTL INC AEROSPACE FASTENER DIV 900 WATSON CENTER ROAD CARSON, CALIFORNIA 90745-4201 FORMERLY V32134 REXNORD INC; FORMERLY V97928 HUCK INTL
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
32388	HONEYWELL INC MICRO SWITCH DIV 830 EAST ARAPAHO ROAD RICHARDSON, TEXAS 75081-2241 FORMERLY SPECTRONICS, HONEYWELL OPTOELECTRONICS

Code	Name
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
53551	ALLFAST FASTENING SYSTEMS INC 15200 EAST DON JULIAN ROAD PO BOX 3166 CITY OF INDUSTRY, CALIFORNIA 91745-1001 FORMERLY V0736B FORMERLY ALLFAST INC V5K545
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

Code	Name
62554	SIMMONDS MECAERO FASTENERS INC 1734 SEQUOIA AVENUE ORANGE, CALIFORNIA 92668
71985	DOW-ELCO INCORPORATED 1313 W OLYMPIC BOULEVARD, PO BOX 669 MONTEBELLO, CALIFORNIA 90641-5010
72962	HARVARD INDUSTRIES INC 3 WERNER WAY SUITE 210 LEBANON, NEW JERSEY 08833 FORMERLY ESNA V7A079 FORMERLY ELASTIC STOP NUT IN UNION, NJ
73134	ROLLER BEARING 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
73197	HI-SHEAR TECHNOLOGY CORP 2600 SKYPARK DRIVE TORRANCE, CALIFORNIA 90509
73949	GUARDIAN ELECTRIC MFG CO 1425 LAKE AVENUE WOODSTOCK, ILLINOIS 60098 FORMERLY IN CHICAGO, ILLINOIS
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
81205	BOEING CO THE 7755 EAST MARGINAL WAY PO BOX 3707 SEATTLE, WASHINGTON 98124
81376	SMITH ACQUISITION COMPANY 2240 BUENA VISTA BALDWIN PARK, CALIFORNIA 91706

Code	Name
83086	NEW HAMPSHIRE BALL BEARING, INC HITECH DIVISION 172 JAFFREY ROAD PETERBOROUGH, NEW HAMPSHIRE 03458
92215	FAIRCHILD IND INC FAIRCHILD AEROSPACE FASTENER DIV 3010 W LOMITA BLVD TORRANCE, CALIFORNIA 90505-5102 FORMERLY VOI-SHAN IN CULVER CITY, CALIF
97393	SHUR-LOK CORPORATION 2541 WHITE ROAD PO BOX 19584 IRVINE, CALIFORNIA 92623-9584 FORMERLY SHUR LOK CORP VB0060 FORMERLY IN SANTA ANA, CALIFORNIA 92714
97613	SARGENT CONTROLS & AEROSPACE/KAHR BEARING DIV 5675 W BURLINGAME RD TUCSON, ARIZONA 85743 FORMERLY AETNA STEEL PROD KAHR BEARING DIV V96579 FORMERLY SARGENT IND KAHR BEARING DIV, BURBANK, CALIFORNIA
97928	Replaced: [V97928] SEE V17446 HUCK INTL by Code: Name and Address below 17446: HUCK INTL INC AEROSPACE FASTENER DIV 900 WATSON CENTER ROAD CARSON, CALIFORNIA 90745-4201 FORMERLY V32134 REXNORD INC; FORMERLY V97928 HUCK INTL
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
03-823-12E017		1	385	2
10-60545-97A		1	385	2
102F177-3		1	480	2
102F177-4		3	240	2
102F9201M3		1	60	4
		1	195	2
		4	80	2
		4	310	2
		4	370	2
		4	410	2
102F9201M4		1	270	4
		1	272	2
102F9209M3		1	55	2
109F9209M3		2	50	1
140N2138-1		1	170	1
140N2138-2		1	170A	1
140N2139-2		1	160	1
140N2139-5		1	160A	1
144A6391-1		1	185	1
144A6391-2		1	210	1
144A6391-3		1	200	1
144A6391-4		1	205	4
144A6442-3		3	35	1
144A6442-4		3	40	1
144A6505-1		1	1A	RF
144A6505-10		1	1K	RF
144A6505-2		1	1B	RF
144A6505-3		1	1C	RF
144A6505-4		1	1D	RF
144A6505-5		1	1E	RF
144A6505-6		1	1F	RF
144A6505-7		1	1G	RF
144A6505-8		1	1H	RF
144A6505-9		1	1J	RF

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
144A6510-1		1	785	1
144A6510-2		1	785A	1
144A6511-1		1	825	1
144A6512-1		1	830	1
144A6512-2		1	830A	1
144A6513-1		1	835	1
144A6513-2		1	835A	1
144A6514-1		1	805	1
144A6514-2		1	810	1
144A6514-3		1	815	1
144A6515-1		2	60	1
144A6515-2		2	70	1
144A6516-1		1	180	1
144A6518-1		1	5	1
144A6520-1		1	780	1
		4	1A	RF
144A6520-2		1	780A	1
		4	1B	RF
144A6520-3		1	780B	1
		4	1C	RF
144A6520-4		1	780C	1
		4	1D	RF
144A6521-1		4	400	1
144A6521-2		4	300	1
144A6521-3		4	60	1
144A6521-4		4	300A	1
144A6521-5		4	60A	1
144A6521-6		4	60B	1
144A6522-1		4	430	1
144A6522-2		4	315	1
144A6522-3		4	110	1
144A6522-4		4	315A	1
144A6522-5		4	110A	1
144A6522-6		4	110B	1
144A6523-1		4	55	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
144A6523-2		4	50	1
144A6523-3		4	295	1
144A6524-2		4	435	1
144A6525-10		4	150	1
144A6525-11		4	170	1
144A6525-12		4	175	1
144A6525-5		4	155	1
144A6525-6		4	160	1
144A6525-7		4	180	1
144A6525-8		4	185	1
144A6525-9		4	145	1
144A6526-1		4	395	2
144A6527-1		4	165	1
144A6528-2		4	95	1
144A6528-3		4	100	1
144A6528-4		4	105	1
144A6529-1		4	135	1
144A6529-2		4	140	1
144A6530-1		1	855	1
144A6531-1		1	875	1
144A6531-2		1	865	1
144A6531-3		1	890	1
144A6531-4		1	880	1
144A6531-5		1	870	1
144A6531-6		1	885	1
144A6531-7		1	860	1
144A6535-1		1	285	1
144A6540-1		1	300	1
144A6541-1		1	305	1
144A6542-1		3	90	2
144A6542-2		3	90A	2
144A6544-1		3	140	1
144A6544-2		3	145	1
144A6545-1		1	775	1
		3	1A	RF

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
144A6545-2		1	775A	1
		3	1B	RF
144A6546-1		3	225	1
144A6546-2		3	230	1
144A6546-3		3	255	1
144A6546-4		3	260	1
144A6548-1		3	185	1
144A6548-2		3	190	1
144A6549-1		3	175	1
144A6553-1		3	15	1
144A6553-2		3	10	1
144A6553-3		3	75	2
144A6553-4		1	30	2
144A6554-1		3	20	1
144A6554-2		3	25	1
144A6555-1		1	105	1
144A6555-2		1	105A	1
144A6560-1		1	35	1
144A6561-1		1	70	1
144A6561-2		1	75	1
144A6562-1		1	95	1
144A6562-2		1	100	1
144A6562-3		1	85	1
144A6562-4		1	90	1
144A6585-1		1	215	1
144A6585-2		1	215A	1
144A6586-3		1	260	1
144A6586-4		1	280	1
144A6586-5		1	260A	1
144A6586-6		1	280A	1
144A6586-7		1	260B	1
144A6586-8		1	280B	1
144A6587-3		1	230	6
144A6588-1		4	425	2
144A6595-1		4	345	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
144A6595-2		4	350	1
144A6596-1		4	360	1
144A6596-2		4	375	1
144A6597-1		4	385	1
144A6597-2		4	390	1
144A6598-1		4	380	5
144A6600-1		1	310	1
144A6601-2		1	415	1
144A6602-2		1	420	1
144A6602-4		1	450	1
144A6602-5		1	425	1
144A6602-6		1	455	1
144A6603-5		1	395A	2
144A6604-2		1	490	1
144A6605-1		1	465	1
144A6607-3		1	470	1
144A6607-4		1	485	1
144A6610-1		1	495	1
144A6611-1		1	615	1
144A6612-1		1	765	1
144A6612-3		1	730	1
144A6613-1		1	710	1
144A6613-2		1	715	1
144A6615-1		1	670	2
144A6616-1		1	680	1
144A6617-1		1	545	2
144A6618-1		1	605	AR
		1	720	6
144A6618-2		1	610	AR
		1	725	2
144A6621-1		4	225	1
144A6621-2		4	230	1
144A6621-3		4	250	1
144A6621-4		4	255	1
144A6641-1		1	580	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
144A6641-2		1	575	1
144A6642-1		1	555	1
144A6642-2		1	550	1
144A6643-1		1	585	1
144A6644-1		1	595	1
144A6644-2		1	590	1
144A6645-1		1	600	2
144A6695-1		1	770	1
		2	1A	RF
144A6695-2		1	770A	1
		2	1B	RF
258A4701-2		2	75	1
258A4701-3		2	75A	1
258A4702-3		2	195	1
258A4702-4		2	215	1
258A4703-2		2	125	1
258A4704-1		2	190	1
258A4705-1		1	460	1
258A4706-2		2	35	1
		2	55	1
258A4706-3		2	40	1
258A4707-1		1	390	1
38HM65A		2	180A	1
3SLCC8		4	125	20
		4	125	20
65-45792-4		1	175	1
65-45792-6		1	175A	1
65-45792-7		1	175B	1
65-76765-11		1	165A	1
65-76765-12		1	165B	1
65C35013-7		1	240	2
65C35017-1		1	145	2
65C35017-10		1	140A	2
65C35017-2		1	155	2
65C35017-3		1	150	2

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
65C35017-4		1	135	2
65C35017-5		1	140	2
65C35017-6		1	145A	2
65C35017-7		1	155A	2
65C35017-8		1	150A	2
65C35017-9		1	135A	2
65C36528-3		1	405	1
65C36528-4		1	410	1
65C36528-5		1	400	1
66-8712-1		1	290	1
69-70353-1		1	370	AR
69-70353-2		1	375	AR
69-70353-3		1	380	AR
69-8857		1	295	1
81669V8K5		4	120	4
81669V8K7		4	115	16
A420-066923-00		2	185A	1
A420-066923-01		2	185	1
A420-066923-02		2	185B	1
		2	185C	1
ACMKP05JAP510LY		2	175	2
ADB12-4005		1	385	2
ADW4VNC		1	675	2
		3	250	1
AF5141-3C		1	50	12
		3	235	4
BAC27DBY191		1	900	1
BACB10FE04C		1	675	2
		3	250	1
BACB10FS05J		2	175	2
BACB28AK03-015		4	220	2
BACB28AK03-020		1	365	2
BACB28AK03-031		1	125	6
BACB28AK03-060		1	130	4
BACB28AK04-026		1	665	2

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACB28AK04-032		1	540	2
BACB28AK04-033		3	135	2
BACB28AK05-006		2	170	2
BACB28AP04P014		1	760	2
BACB28AP04P015		4	245	1
BACB28AP04P020		1	740	3
BACB28AP06P029		1	750	1
BACB28AT06B007C		3	245	1
BACB28AT06B009C		3	180	1
BACB28AT06B014C		1	755	2
BACB28AT06B015C		4	240	1
BACB28AT06B020C		1	735	3
BACB28AT09B021C		1	745	3
BACB28AT14B022C		2	210	1
BACB28AT16B030C		2	205	1
BACB28AY06A018CG		4	235	2
BACB30LE4K11		4	325	4
BACB30LE4K12		4	320	4
BACB30NM3K10		2	90	1
		4	190	2
BACB30NM3K14		1	330	2
BACB30NM3K5		1	620	1
		3	195	4
BACB30NM3K7		1	510	1
		2	5	2
BACB30NM4K5		3	95	4
BACB30NM4K7		3	100	2
BACB30NR4K15		1	645	2
BACB30NR4K25		1	685	2
BACB30NR4K30		1	690	2
BACB30NT06K3		2	130	1
BACB30NT06K4		2	135	1
BACB30NX5HK4		1	790A	9
BACB30NX6K19		1	325	2
BACB30UU3K17		1	505	2

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACB30VF3K22		1	320	2
BACB30VN8K5		4	120	4
BACB30VN8K7		4	115	16
BACB30VT10K45		2	140	1
BACB30VT5HK3		3	60A	4
BACB30VT5HK4		4	25A	6
BACB30VT6K16		1	315A	2
BACB30VT6K3		4	30	8
		4	275	4
		4	415	4
BACB30VT6K4		3	200	2
		4	270	5
BACB30VT6K5		4	195A	11
BACB30VT6K6		4	197	2
BACB30YP6K4		3	55	4
		4	280A	1
BACB30YP6K5		2	10	4
BACB30YP6K6		3	50	4
BACC30BH5		1	795	9
BACC30BK8		4	125	20
BACC30BL5		3	70	4
		4	35	6
BACC30BL6		3	65	8
		3	220	2
		4	40	8
		4	215	13
		4	285	10
		4	420	4
BACC30BQ6		2	30	4
BACF3F010G010AN		1	275	4
		1	277	2
BACF3H06JF040AN		4	260	2
BACF3H08BA040AN		4	265A	AR
BACF3H08DA040AN		4	265B	AR
BACF3H08EA040AN		4	265	AR

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACF3H08GA040AN		4	265C	AR
BACF3T01E06-08		1	80	4
BACF3T01H08-15		3	45	2
BACF3T01J09-08		3	30	1
BACG20ZC000060		4	90A	2
BACJ40A20-6		1	640	1
BACM10A11-48J		1	905	1
BACN10JA3CD		1	480	2
BACN10JA4CD		3	240	2
BACN10JD5AU		1	435	1
BACN10JD5CD		3	155	1
BACN10JN3CD		1	60	4
		1	195	2
		4	80	2
		4	310	2
		4	370	2
		4	410	2
BACN10JN4CD		1	270	4
		1	272	2
BACN10KH3CD		1	55	2
BACN10KH3CM		2	50	1
BACN10KJ3CD		4	15	2
BACN10MK3-45		4	20	4
BACN10TL3-4		4	85	1
BACN10TL3-6		4	75	2
BACN10YR06CM		2	160	2
BACN10YR3CD		1	535	3
		1	635	1
		3	215	4
		4	210	2
BACN10YR3CM		1	360	6
		2	25	1
		2	115	1
BACN10YR4CD		1	560	1
		1	660	2

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	705	4
BACN10YR5CM		2	165	1
BACN11N104CD		3	120	2
BACN11U4CD2N		3	120A	2
BACN11Z4CD		3	125A	2
BACP18BC01A04P		2	80	1
BACP18BC02A06P		1	430	1
		3	85	2
BACP18BC02A10P		3	150	1
BACP18BD1A17		2	85A	1
BACR15BA3AD		1	190	4
		4	305	4
		4	405	4
BACR15BA3AD5C		4	70B	5
BACR15BA3ADC		1	265A	8
		1	267A	4
		4	67B	1
		4	70A	5
		4	365A	4
BACR15BA5AD9C		3	170	3
BACR15BB3AD5C		4	65B	4
BACR15BB3AD7C		4	67A	1
		4	68	1
BACR15BB3ADC		4	65A	4
BACR15BB3D		4	5	4
BACR15BB4D		4	10	8
BACR15CE3D		1	475	4
BACR15CE3M		2	45	2
BACR15DR3AC		1	50	12
		3	235	4
BACR15FR4ER		1	10A	16
BACR15FR5ER		1	15A	4
		1	255A	4
BACR15FT5D		1	235	4
		3	5	20

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACR15FT5D6		1	800A	36
BACR15FT6D		4	45	10
		4	130	24
		4	290	10
BACR15FT6D4		1	245A	4
BACR15GF4D		1	65	4
BACR15GF6D4		1	250A	4
BACS12ER3K9		4	355	2
BACS12FA3K11		1	120	2
BACS12FA3K15		1	110	4
BACS12FA3K16		1	115	4
BACS12GU3K8		1	40	6
BACS14K2		1	25	1
BACS40R008C008F		3	265	2
BACS40R008C023F		1	820	3
BACS40R016C016F		3	80	2
BACW10BN3AC		1	625	1
BACW10BN4AC		1	695	4
BACW10BP3ACU		1	345	2
BACW10BP3CD		1	515	3
		2	15	2
		3	205	4
		4	200	2
BACW10BP3DP		3	210	4
BACW10BP3NDP		2	110	1
BACW10BP4CD		1	650	2
		3	105	8
		4	330	8
BACW10BP4DP		4	335	8
BACW10BP5DP		2	155	1
BACW10DS3S		2	105	1
BACW10DS3U		1	335	2
BACW10DS5S		2	150	1
BCREFA0961		4	235	2
BRF110C3D		1	480	2

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BRF110C4D		3	240	2
BRF170C3D		1	480	2
BRF170C4D		3	240	2
BRFM20C3D		1	60	4
		1	195	2
		4	80	2
		4	310	2
		4	370	2
		4	410	2
BRFM20C4D		1	270	4
		1	272	2
DE679-10		1	25	1
DE847		1	20A	7
F29779-01-3		2	50	1
F51636-3		1	480	2
F51636-4		3	240	2
		3	240	2
F51652-3		4	15	2
FS1651-3		1	55	2
H52732-06CM		2	160	2
H52732-3CD		1	535	3
		1	635	1
		3	215	4
		4	210	2
H52732-3CM		1	360	6
		2	25	1
		2	115	1
H52732-4CD		1	560	1
		1	660	2
		1	705	4
H52732-5CM		2	165	1
HL1012AZ5-4		1	790A	9
HL1012AZ6-19		1	325	2
		1	325	2
		1	325	2

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	325	2
		1	325	2
		1	325	2
		1	325	2
		1	325	2
HL1087-5		1	795	9
		1	795	9
		1	795	9
HL12VAZ6-19		1	325	2
		1	325	2
		1	325	2
		1	325	2
HST10AG10-45		2	140	1
		2	140	1
		2	140	1
		2	140	1
HST10AG6-16		1	315A	2
		1	315A	2
		1	315A	2
		1	315A	2
HST10AG6-3		4	30	8
		4	30	8
		4	30	8
		4	30	8
		4	275	4
		4	275	4
		4	275	4
		4	275	4
		4	415	4
		4	415	4
		4	415	4
		4	415	4
HST10AG6-4		3	200	2
		3	200	2
		3	200	2

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		3	200	2
		4	270	5
		4	270	5
		4	270	5
		4	270	5
HST10AG6-5		4	195A	11
		4	195A	11
		4	195A	11
		4	195A	11
HST10AG6-6		4	197	2
		4	197	2
		4	197	2
		4	197	2
HST79-5		3	70	4
		4	35	6
HST79-6		3	65	8
		3	220	2
		4	40	8
		4	215	13
		4	285	10
		4	420	4
HST79CY5		3	70	4
		3	70	4
		3	70	4
		4	35	6
		4	35	6
		4	35	6
HST79CY6		3	65	8
		3	65	8
		3	65	8
		3	220	2
		3	220	2
		3	220	2
		4	40	8
		4	40	8

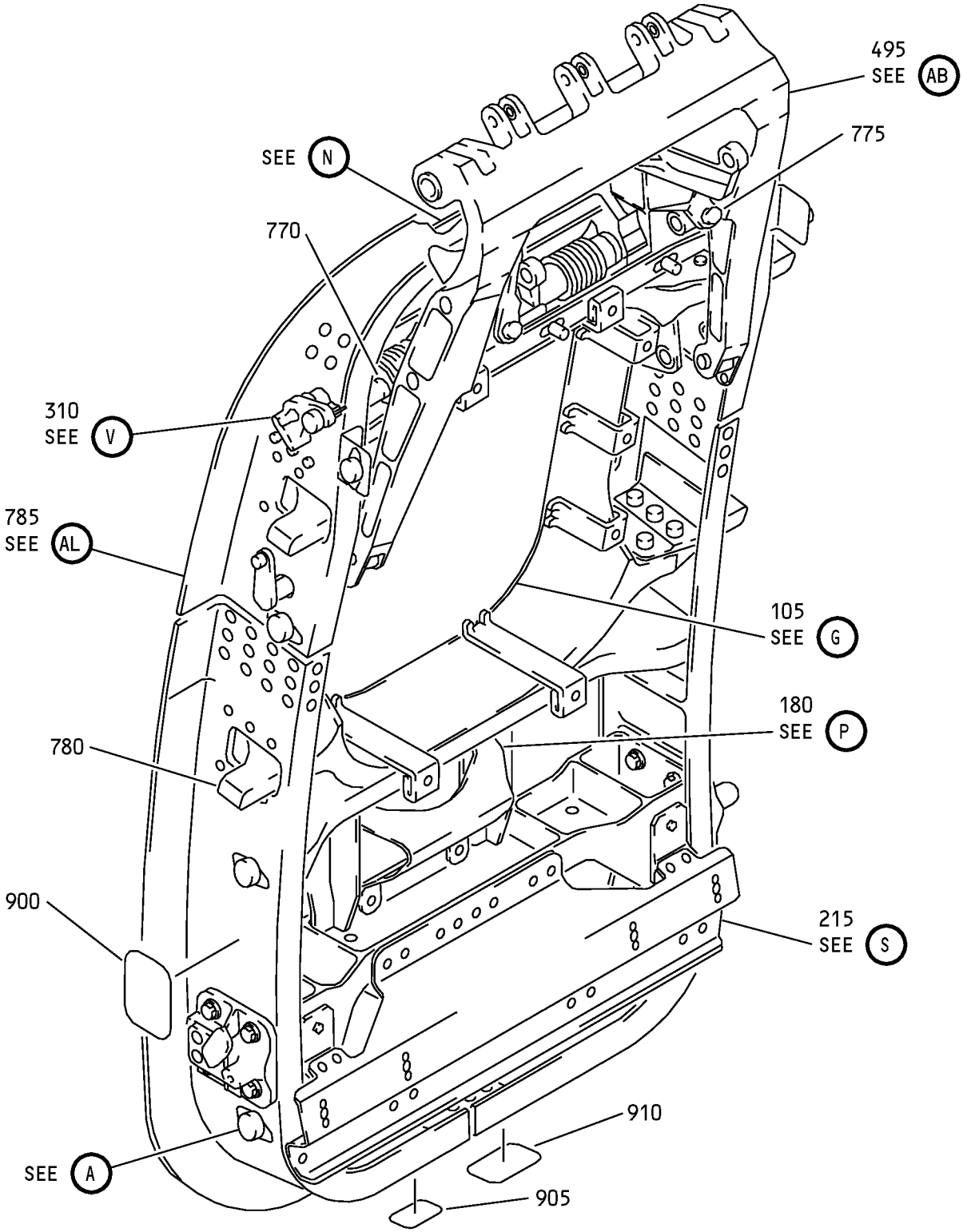
PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		4	40	8
		4	215	13
		4	215	13
		4	215	13
		4	285	10
		4	285	10
		4	285	10
		4	420	4
		4	420	4
		4	420	4
HST826AW		2	30	4
		2	30	4
		2	30	4
HST82CY6APBW		2	30	4
		2	30	4
KR4CWGBZC		1	675	2
		3	250	1
KRP146004BT		1	570	1
KRP178905VT		1	445	1
		3	165	1
KWDB4-39		1	675	2
		3	250	1
L802-6K19		1	325	2
LGPL2SPV8-5AC		4	120	4
		4	120	4
		4	120	4
LGPL2SPV8-7AC		4	115	16
		4	115	16
		4	115	16
MF51637-3		1	60	4
		1	195	2
		4	80	2
		4	310	2
		4	370	2
		4	410	2

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
MF51637-4		1	270	4
		1	272	2
MF53050-3CD		1	60	4
		1	195	2
		4	80	2
		4	310	2
		4	370	2
		4	410	2
MF53050-4CD		1	270	4
		1	272	2
MS14103-4P		1	675A	2
		3	250A	1
MS14104-3P		2	65	1
		2	200	1
MS15795-848		1	340	2
MS16562-221		1	500	4
MS20392-1A17		2	85	1
MS21141U0603P		1	225	4
MS21141U0604P		1	220	2
MS24586C59		2	120	1
MS27111-1		3	110A	2
MS27253F1		1	910	1
NAS1149D0332H		1	525	2
NAS1149D0332J		1	45	6
		1	630	2
NAS1149D0432J		1	700	4
NAS1149DN332H		4	72	2
NAS1149E0332P		1	520	2
		4	205	4
NAS1149E0332R		1	355	4
NAS1149E0363R		1	350	2
		2	20	1
NAS1149E0416P		3	110	2
		3	113	2
NAS1149E0432P		1	565	1

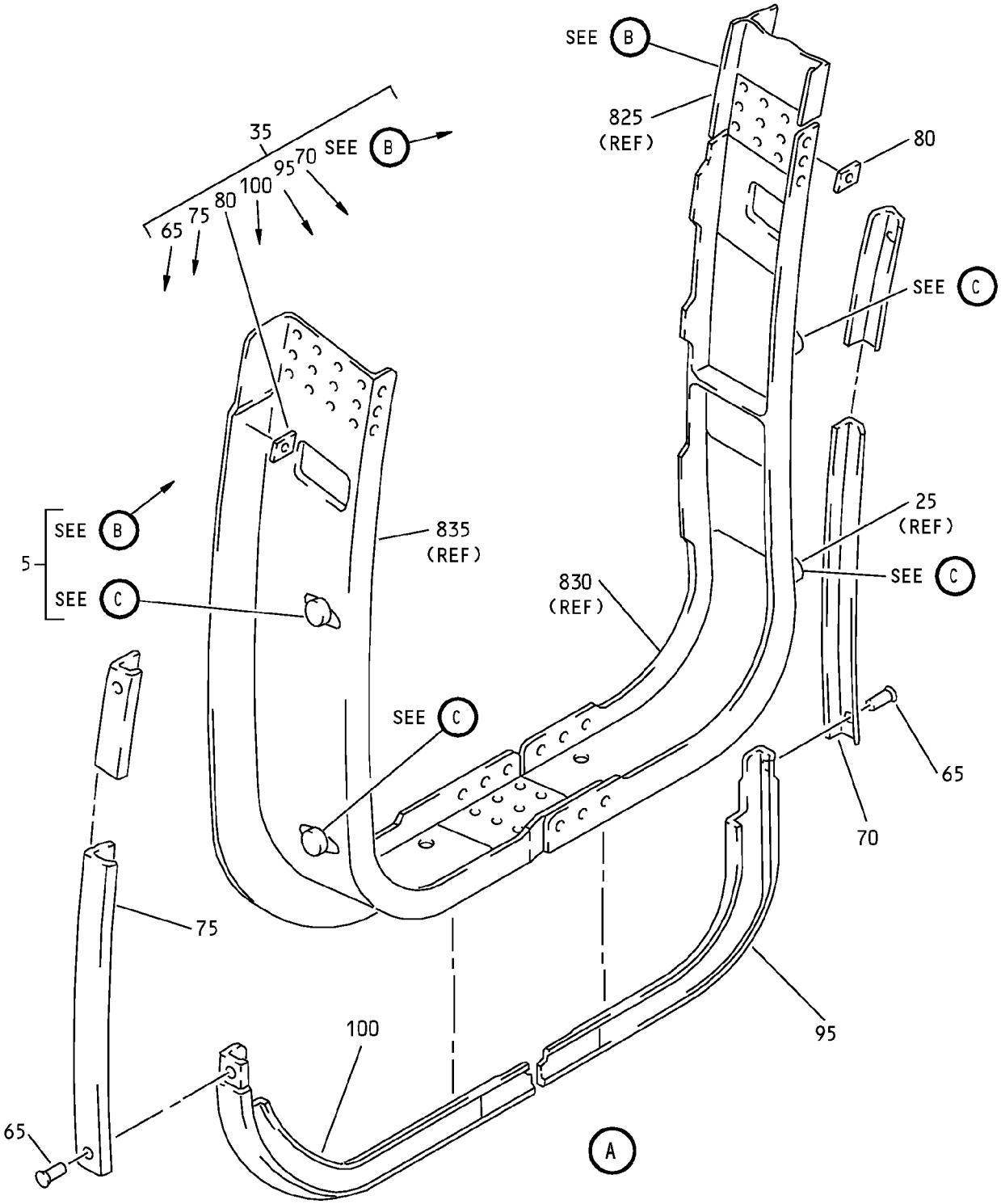
PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	655	2
NAS1149E0463P		3	115	2
NAS1149E0532P		3	160	3
NAS1149E0532R		1	440	AR
NAS1149E0616		1	532	AR
NAS1149E0616P		1	530A	AR
NAS1149E0632P		1	530	AR
NAS1149EN632P		2	145	5
NAS1149FN516P		2	100	1
NAS1805-4L		3	125	2
		4	340	8
NAS43DD3-31FC		2	95	1
NE12BA		1	385	2
NS103225SE02		2	50	1
NS202484-02		1	480	2
NS202487-02		1	60	4
		1	195	2
		4	80	2
		4	310	2
		4	370	2
		4	410	2
NS202487-048		1	270	4
		1	272	2
NS202496-02		1	55	2
PACMKP05JAA3908		2	175	2
PACMKP5AFS428		2	175	2
PLH506CM		2	160	2
PLH53CD		1	535	3
		1	635	1
		3	215	4
		4	210	2
PLH53CM		1	360	6
		2	25	1
		2	115	1
PLH54CD		1	560	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	660	2
		1	705	4
PLH55CM		2	165	1
S411T100-1010		1	20	7
SL2752-3		1	25	1
SL4165		3	130	2
SSMKP05JAP		2	175	2
SSMKP05JASD705		2	175	2
SSMKP5ASD524		2	175	2
SWKN12-153		1	385	2
T8059S1032B1		4	20	4
		4	20	4
T8301C428CD		1	270	4
		1	272	2
VL310AG5-3		3	60A	4
		3	60A	4
		3	60A	4
VL310AG5-4		4	25A	6
		4	25A	6
		4	25A	6
WC10K10-45		2	140	1
WC10K5-3		3	60A	4
WC10K5-4		4	25A	6
WC10K6-16		1	315A	2
WC10K6-3		4	30	8
		4	275	4
		4	415	4
WC10K6-5		4	195A	11
WC10K6-6		4	197	2
WC331K6-4		3	55	4
		4	280A	1
WC331K6-5		2	10	4
WC331K6-6		3	50	4
WES04B10GC		1	675	2
		3	250	1

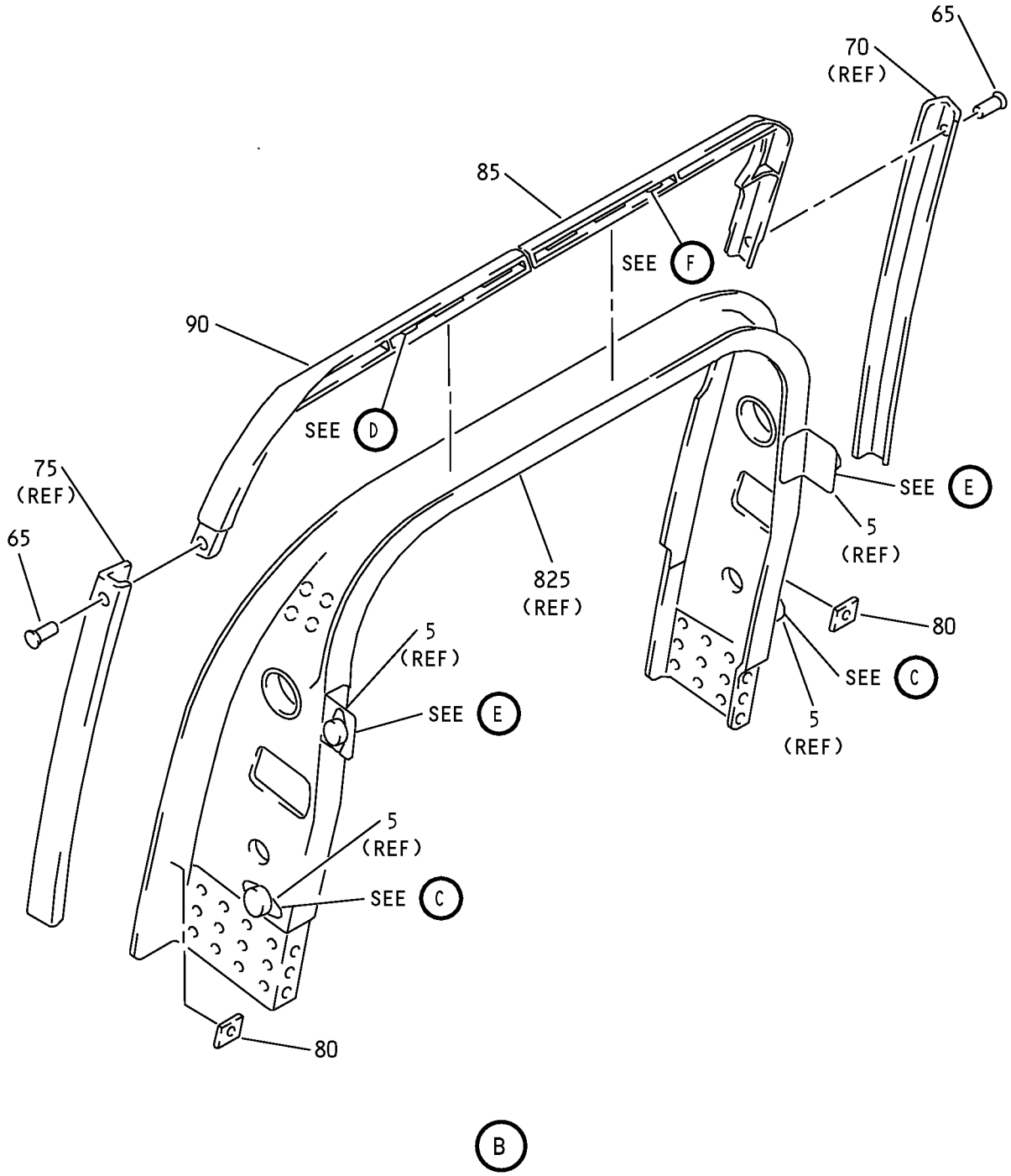
PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
WHT04VSBC		1	675	2
		3	250	1
WRRS04B10GC		1	675	2
		3	250	1
WSI4-4		4	85	1
WSI4-6		4	75	2



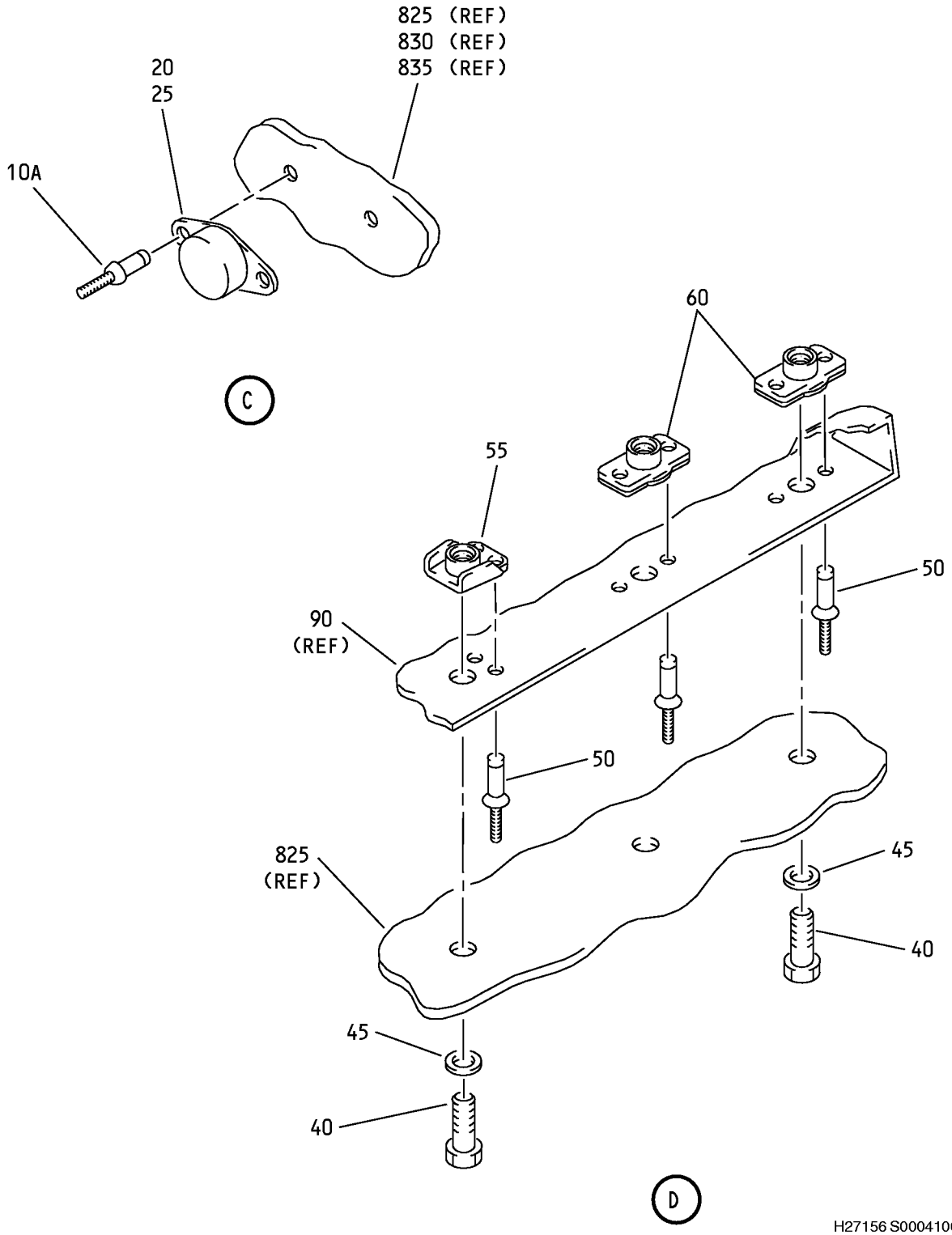
Automatic Overwing Exit Door Assembly
IPL Figure 1 (Sheet 1 of 24)



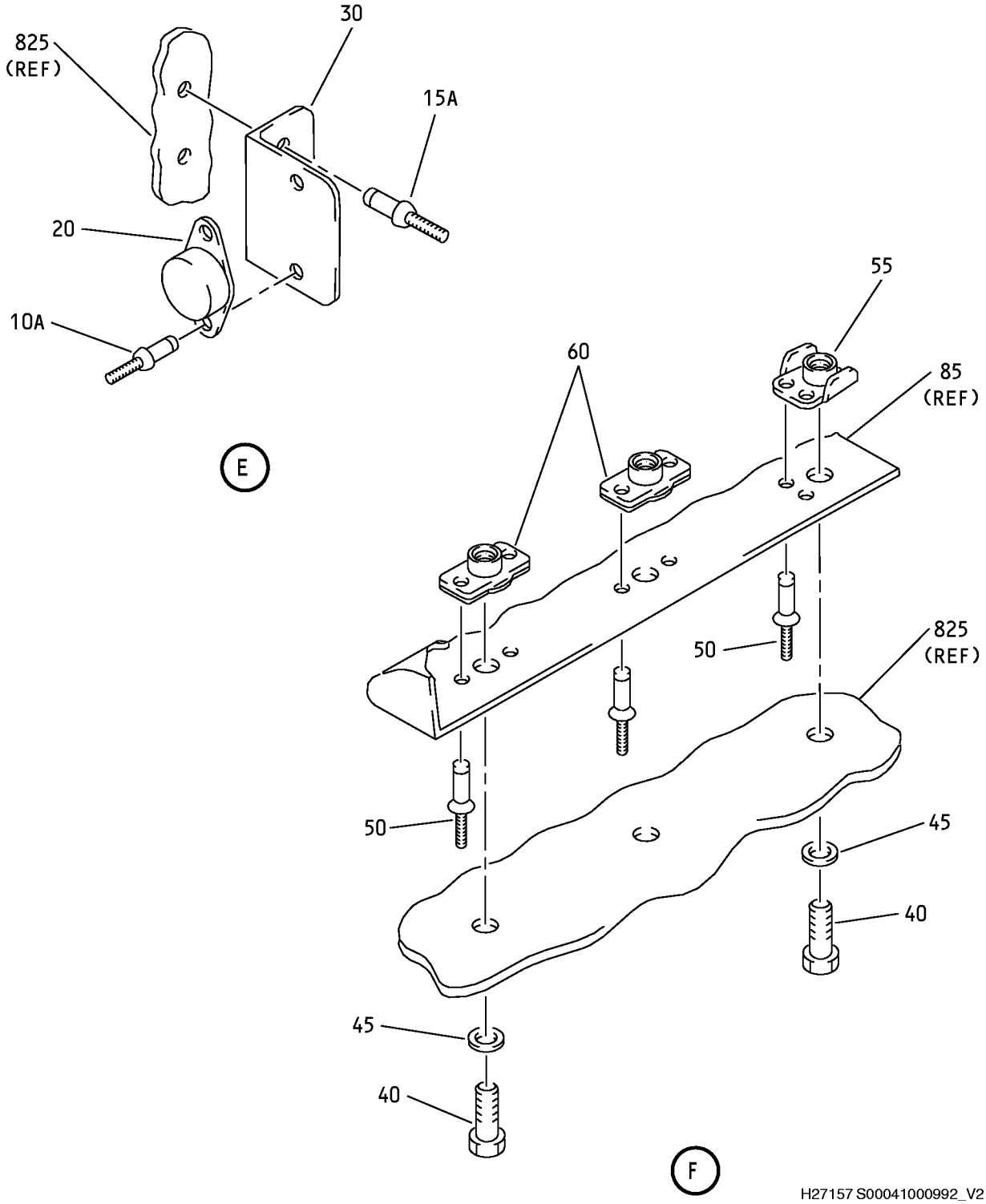
Automatic Overwing Exit Door Assembly
IPL Figure 1 (Sheet 2 of 24)



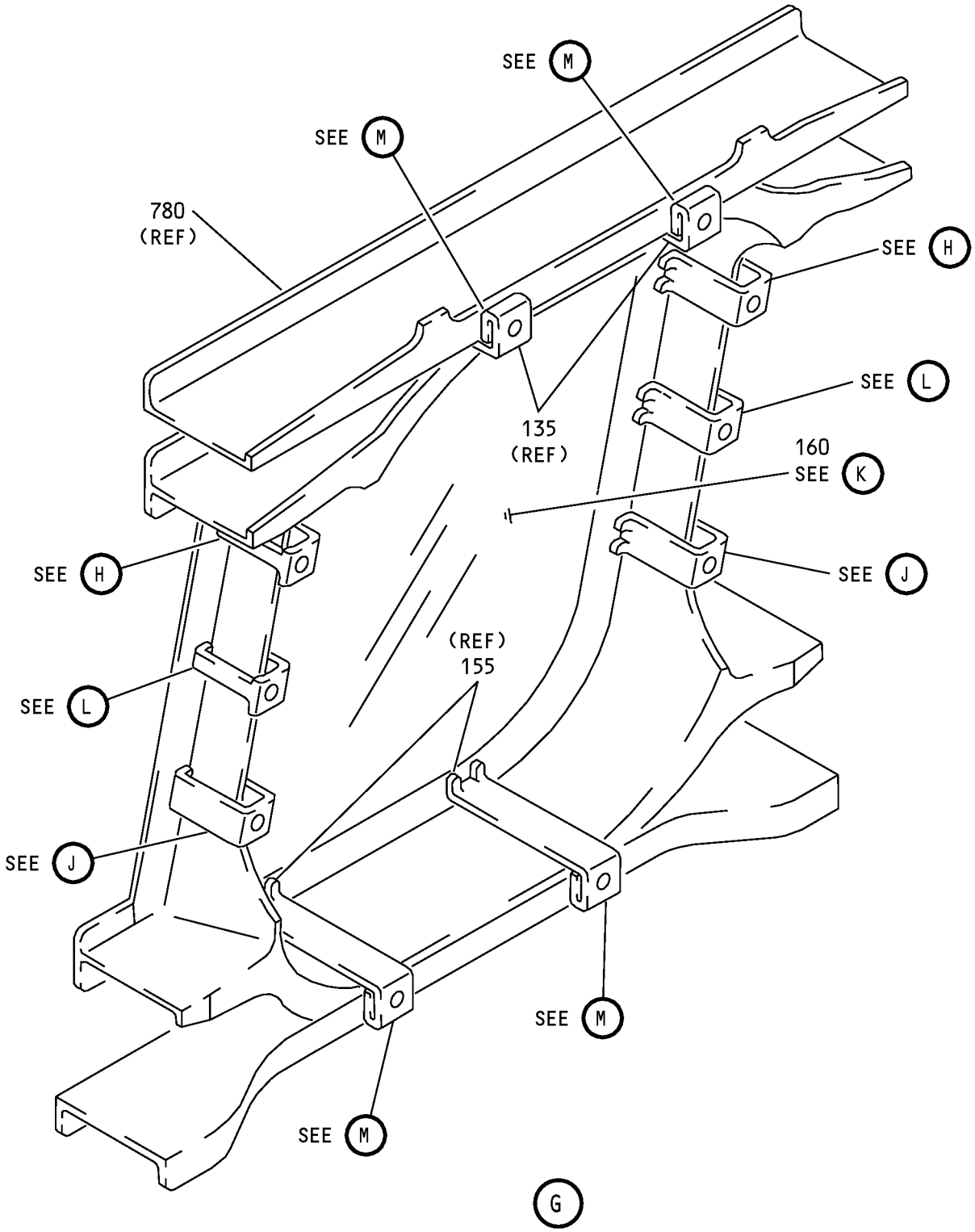
Automatic Overwing Exit Door Assembly
IPL Figure 1 (Sheet 3 of 24)



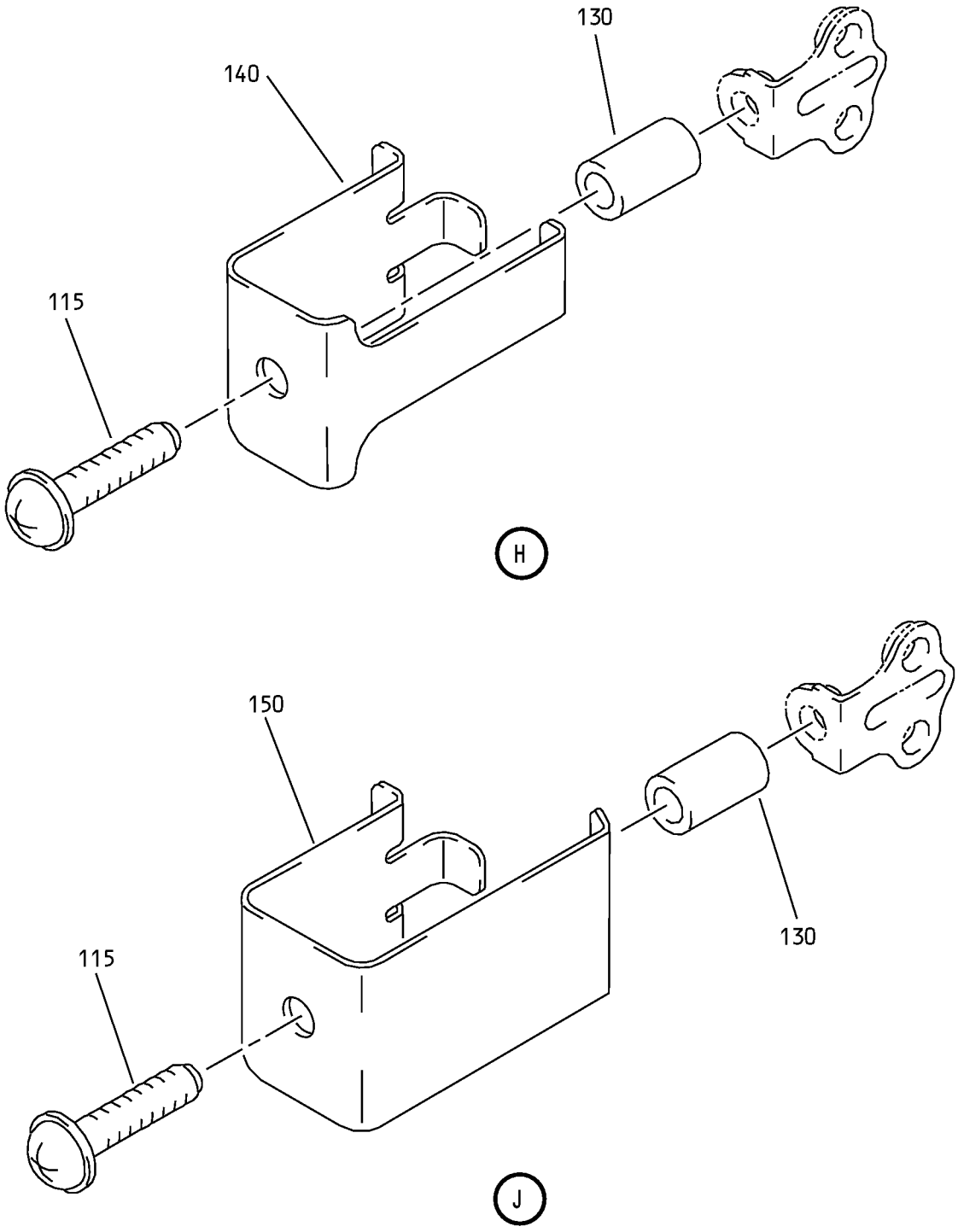
Automatic Overwing Exit Door Assembly
IPL Figure 1 (Sheet 4 of 24)



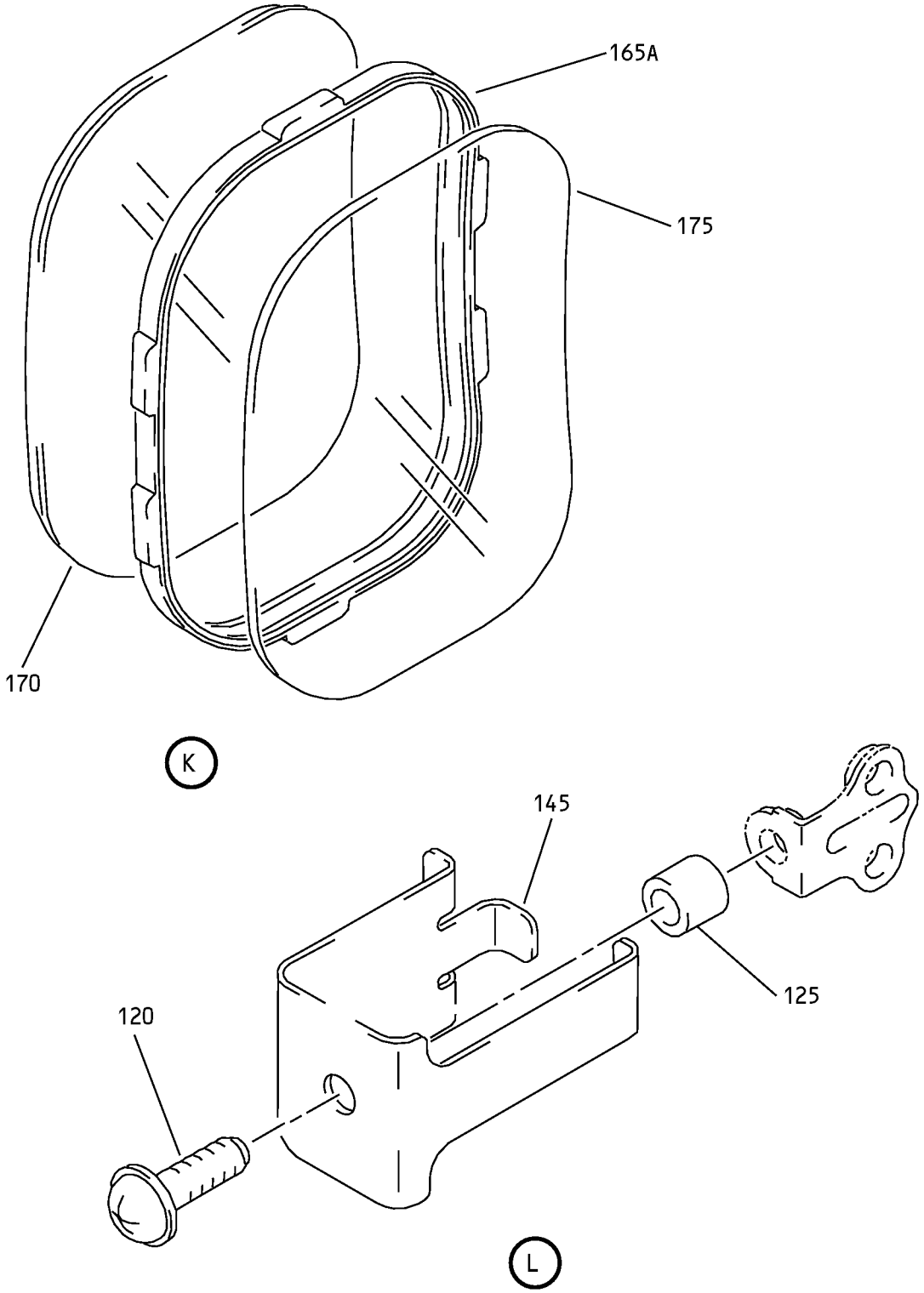
Automatic Overwing Exit Door Assembly
IPL Figure 1 (Sheet 5 of 24)



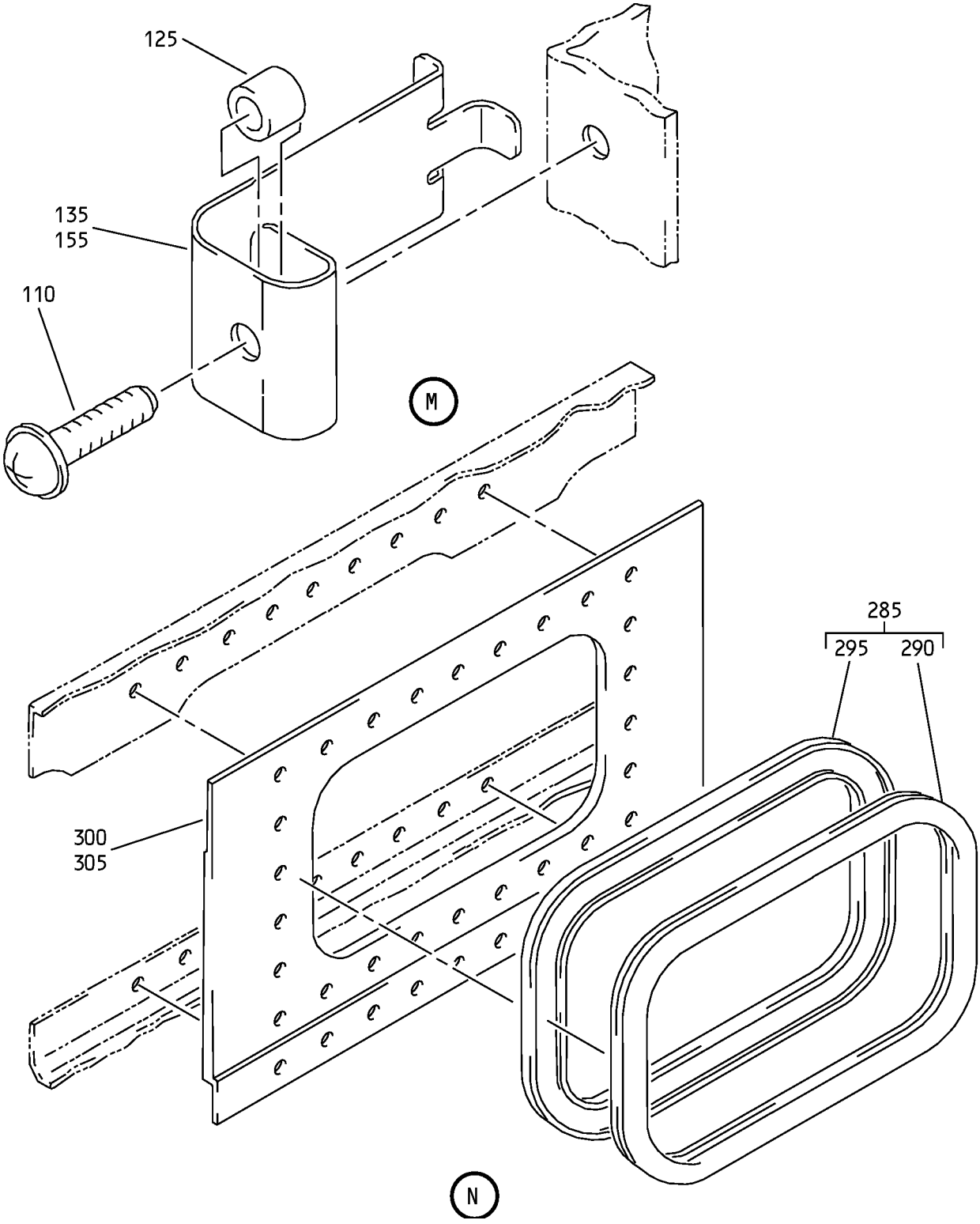
Automatic Overwing Exit Door Assembly
IPL Figure 1 (Sheet 6 of 24)



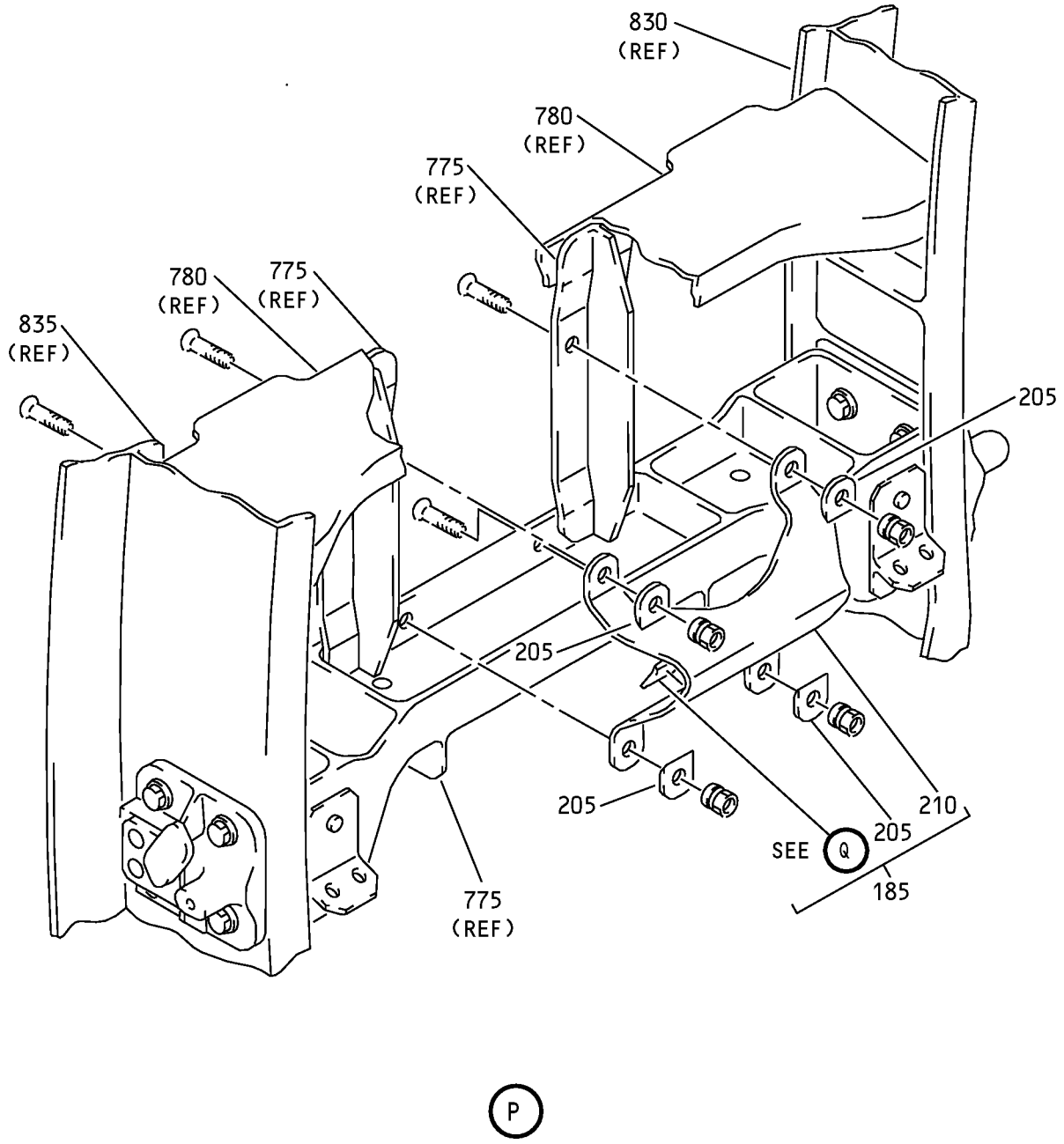
Automatic Overwing Exit Door Assembly
IPL Figure 1 (Sheet 7 of 24)



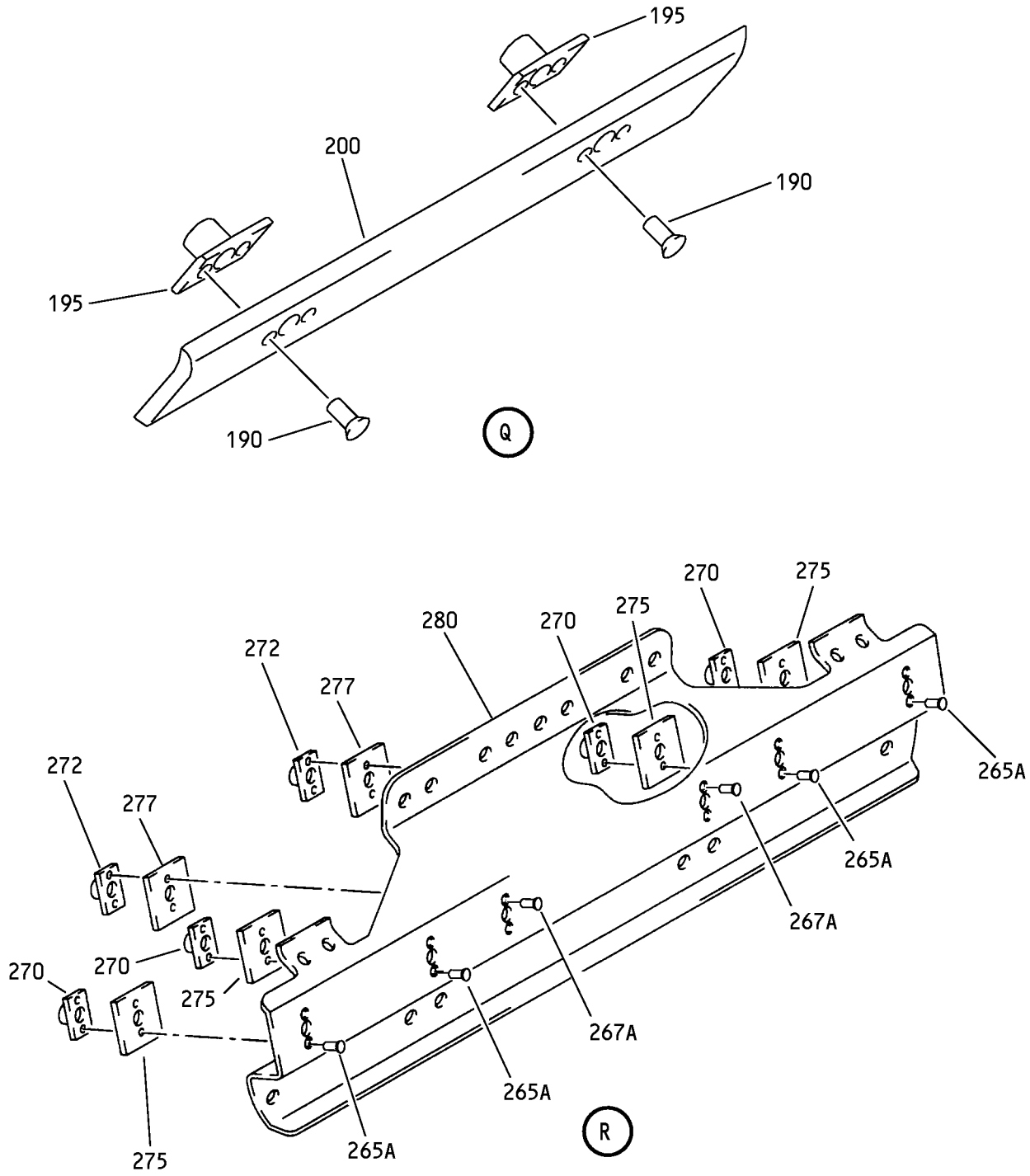
Automatic Overwing Exit Door Assembly
IPL Figure 1 (Sheet 8 of 24)



Automatic Overwing Exit Door Assembly
IPL Figure 1 (Sheet 9 of 24)



Automatic Overwing Exit Door Assembly
IPL Figure 1 (Sheet 10 of 24)



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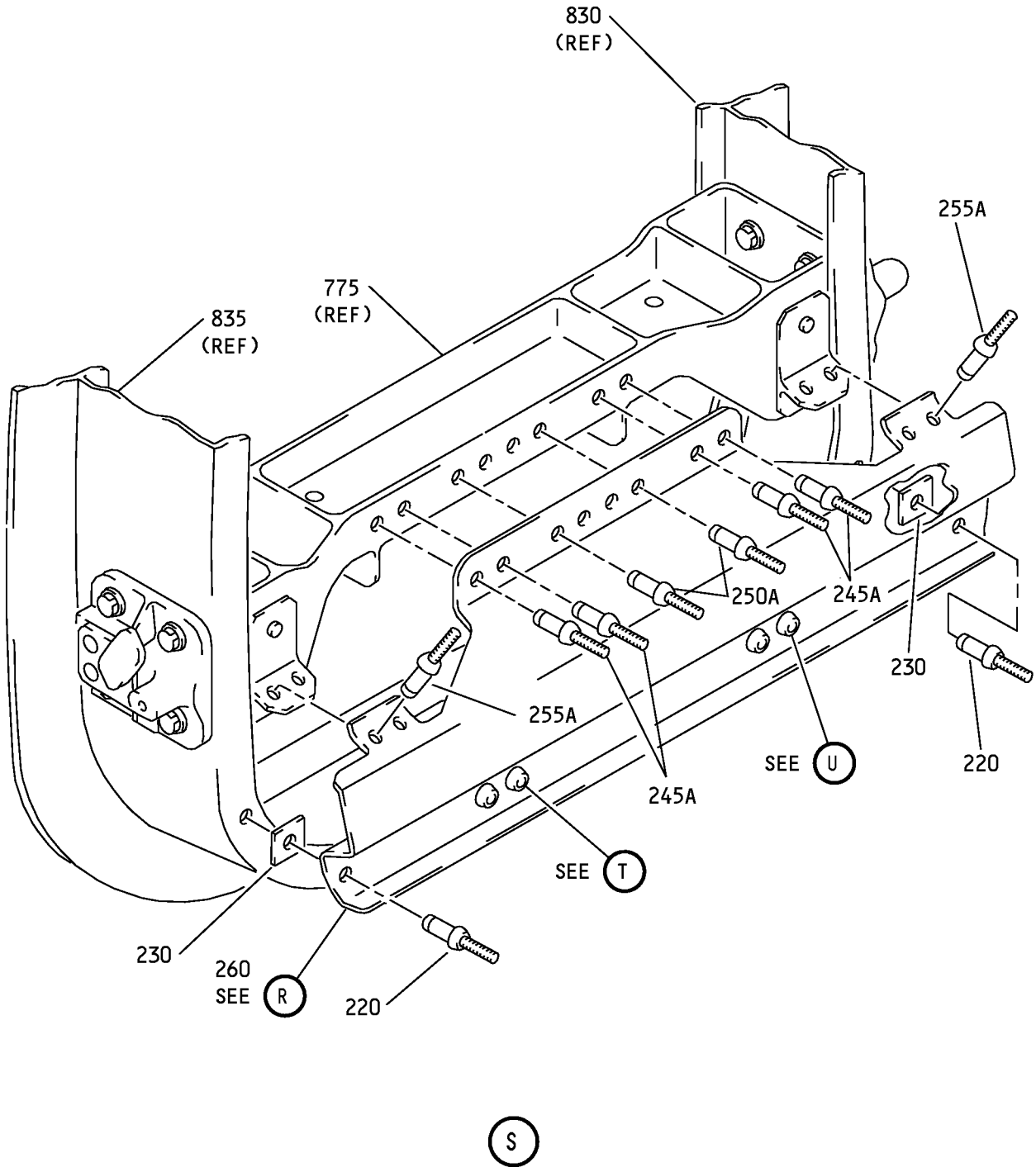
Automatic Overwing Exit Door Assembly
IPL Figure 1 (Sheet 11 of 24)



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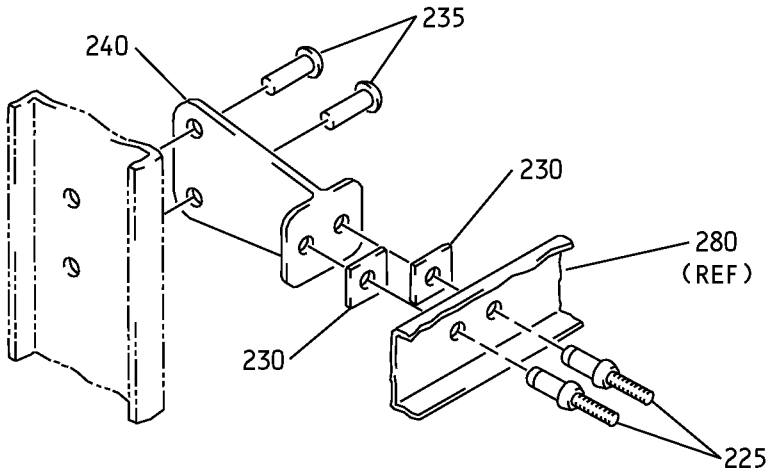
Automatic Overwing Exit Door Assembly
IPL Figure 1 (Sheet 12 of 24)



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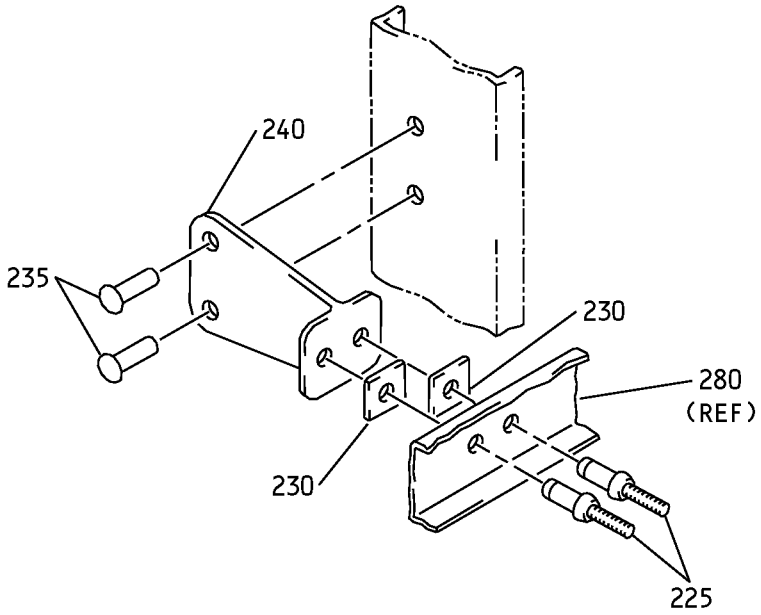

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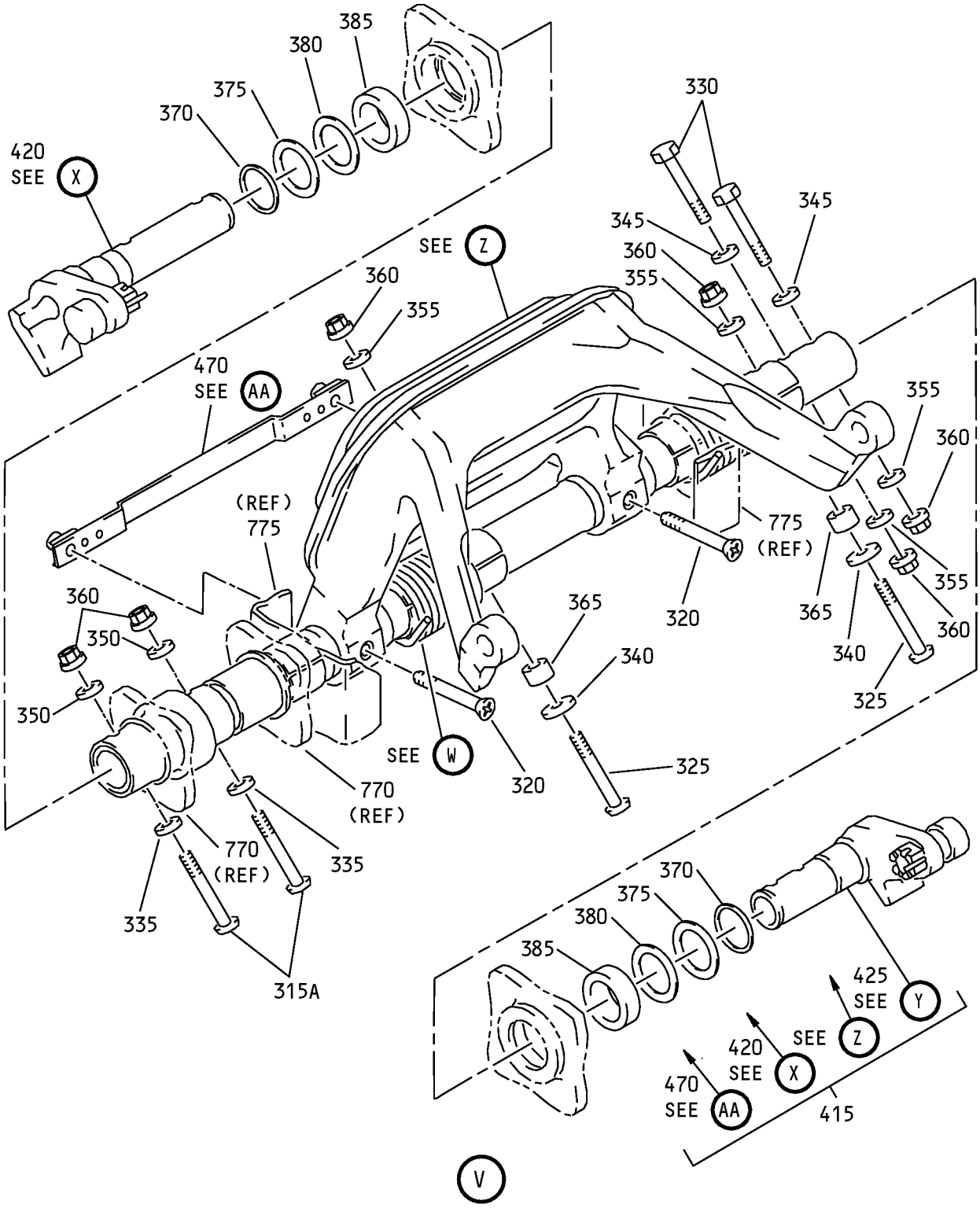
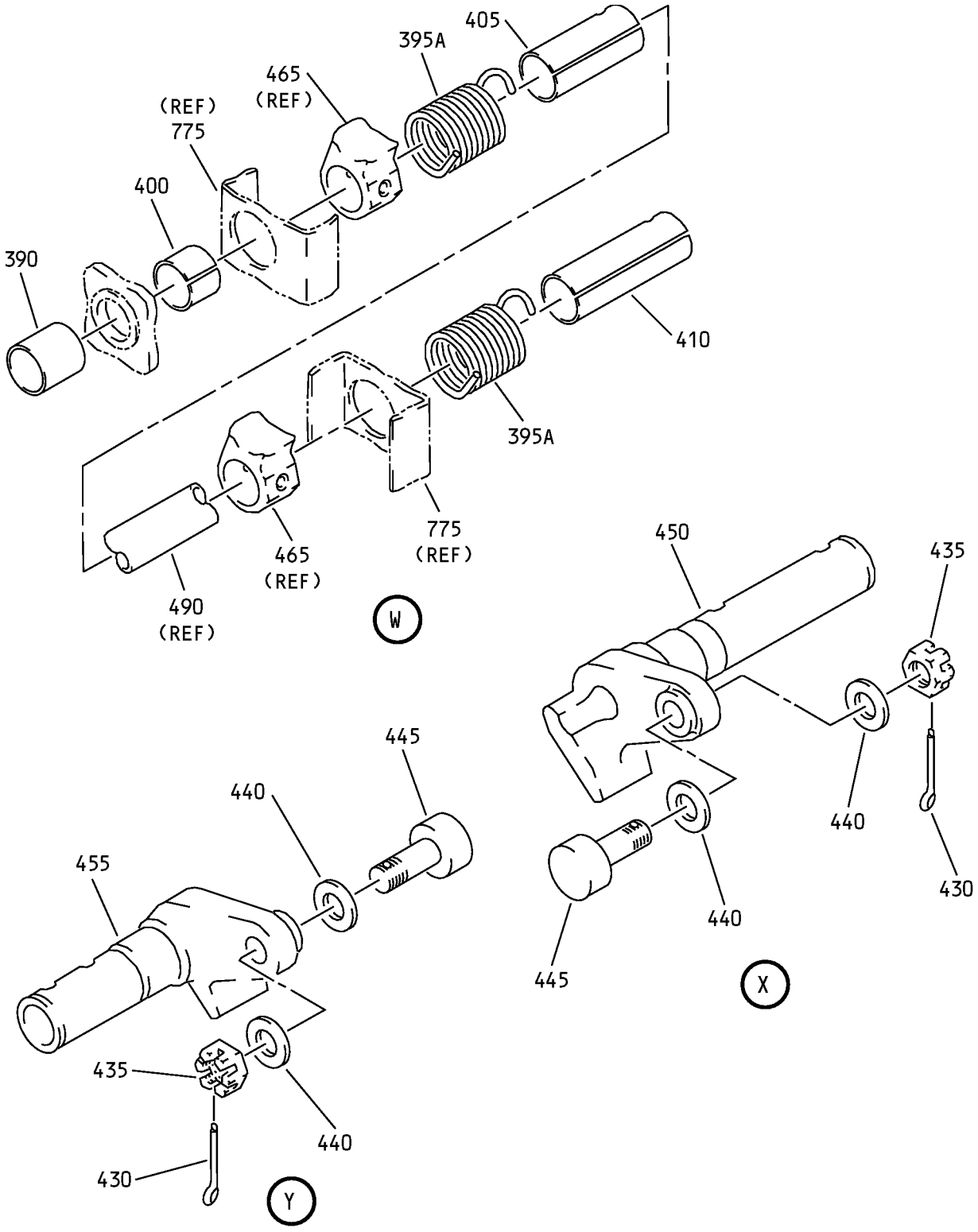
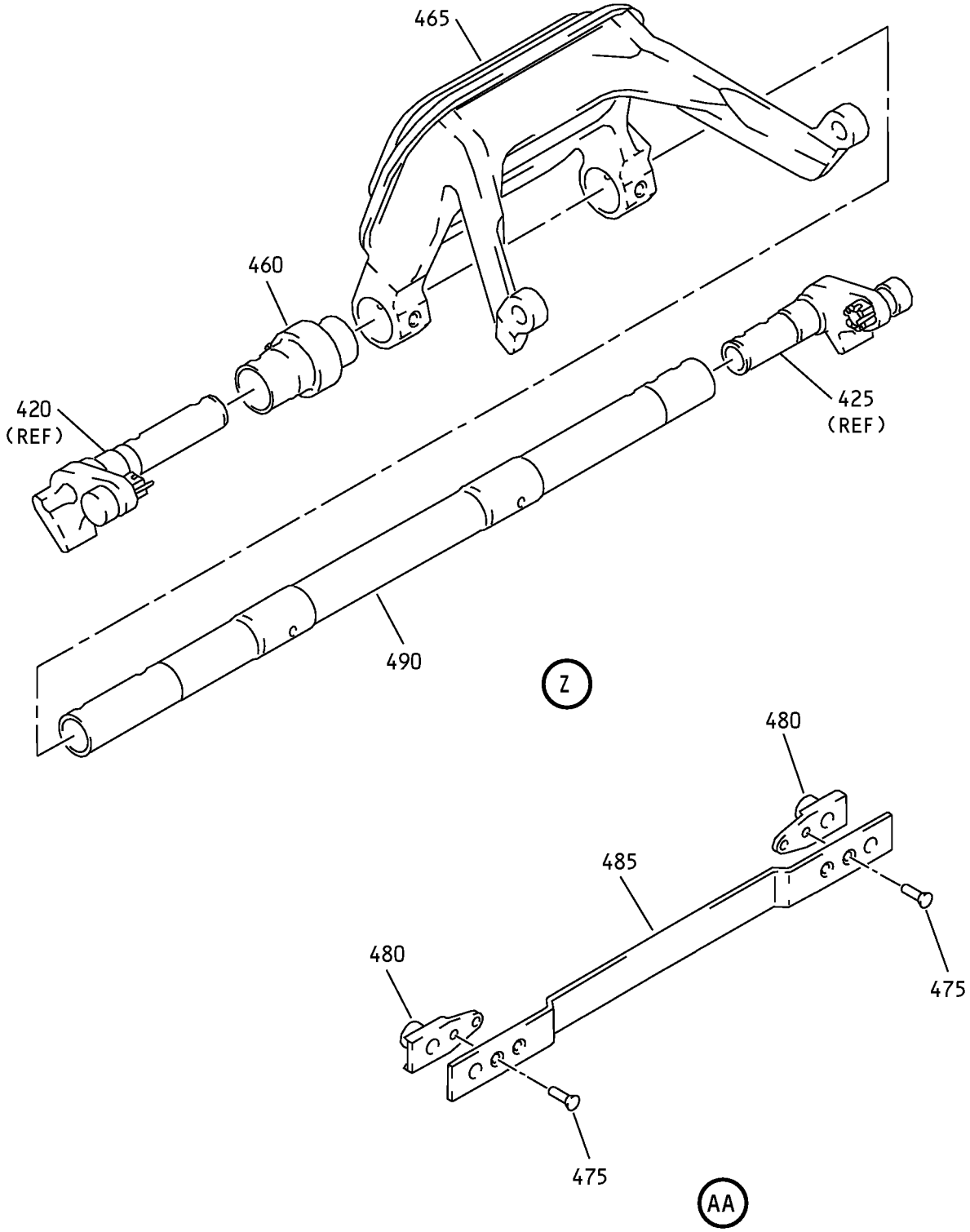
Automatic Overwing Exit Door Assembly
IPL Figure 1 (Sheet 13 of 24)



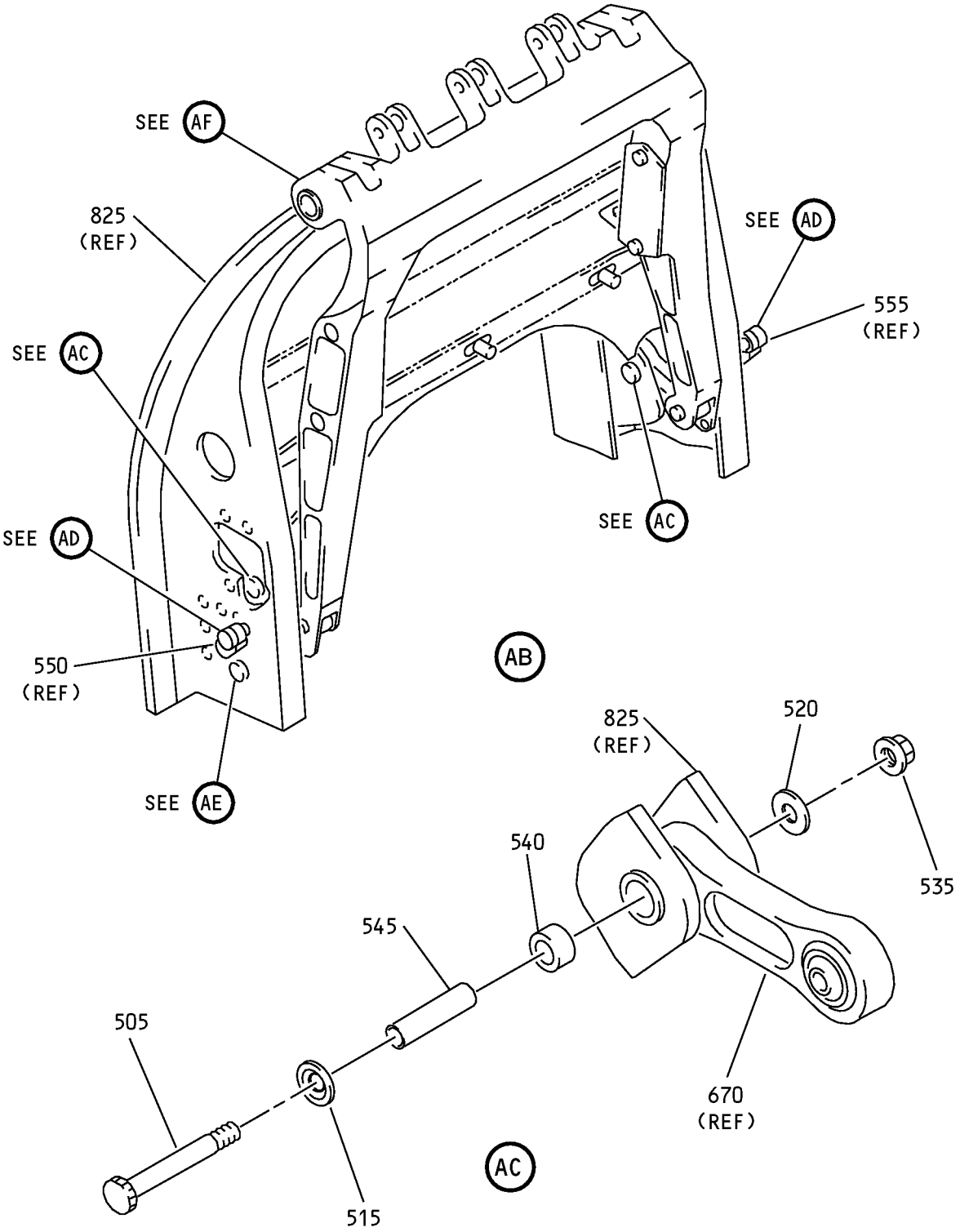
Automatic Overwing Exit Door Assembly
IPL Figure 1 (Sheet 14 of 24)



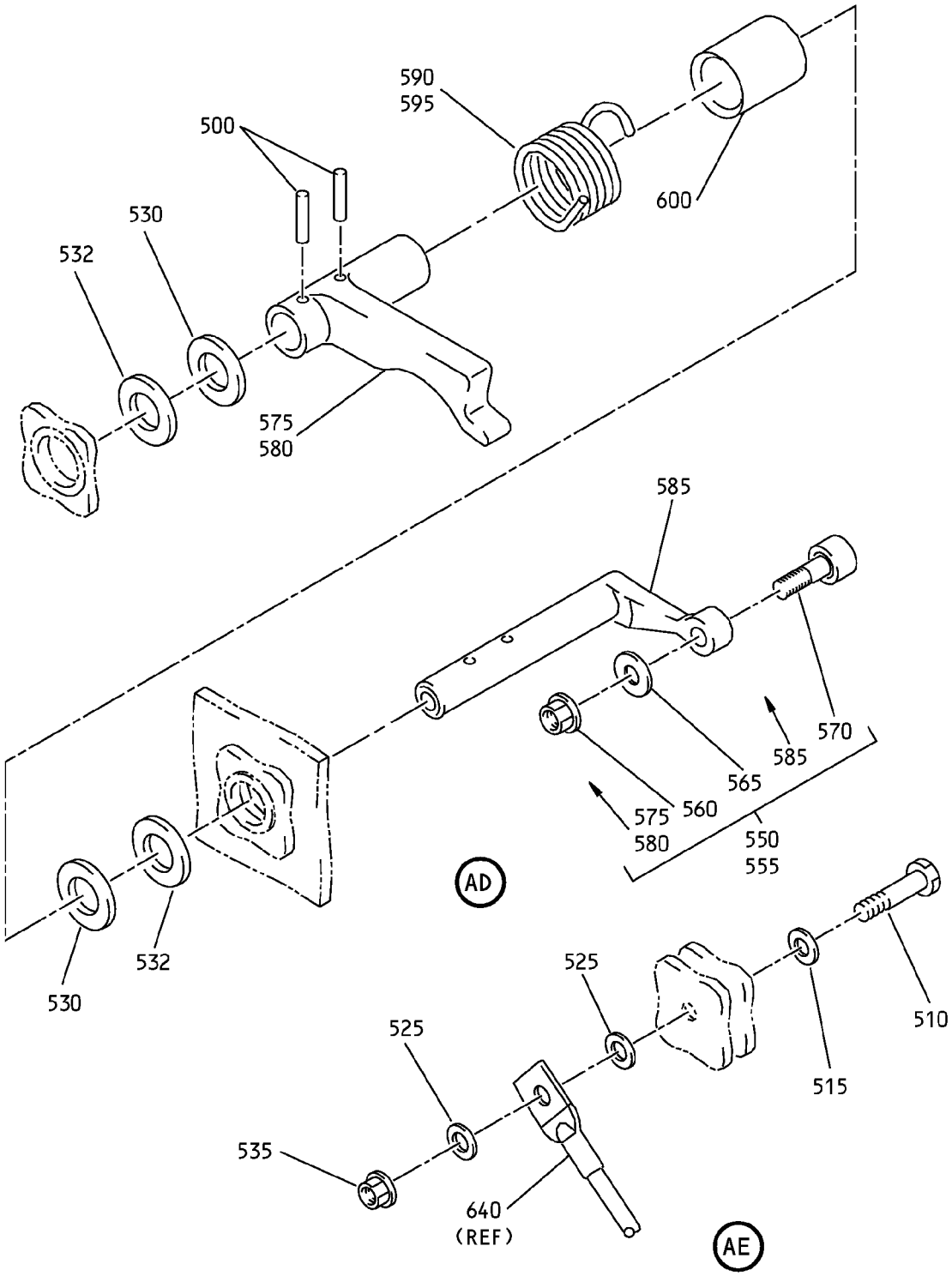
Automatic Overwing Exit Door Assembly
IPL Figure 1 (Sheet 15 of 24)



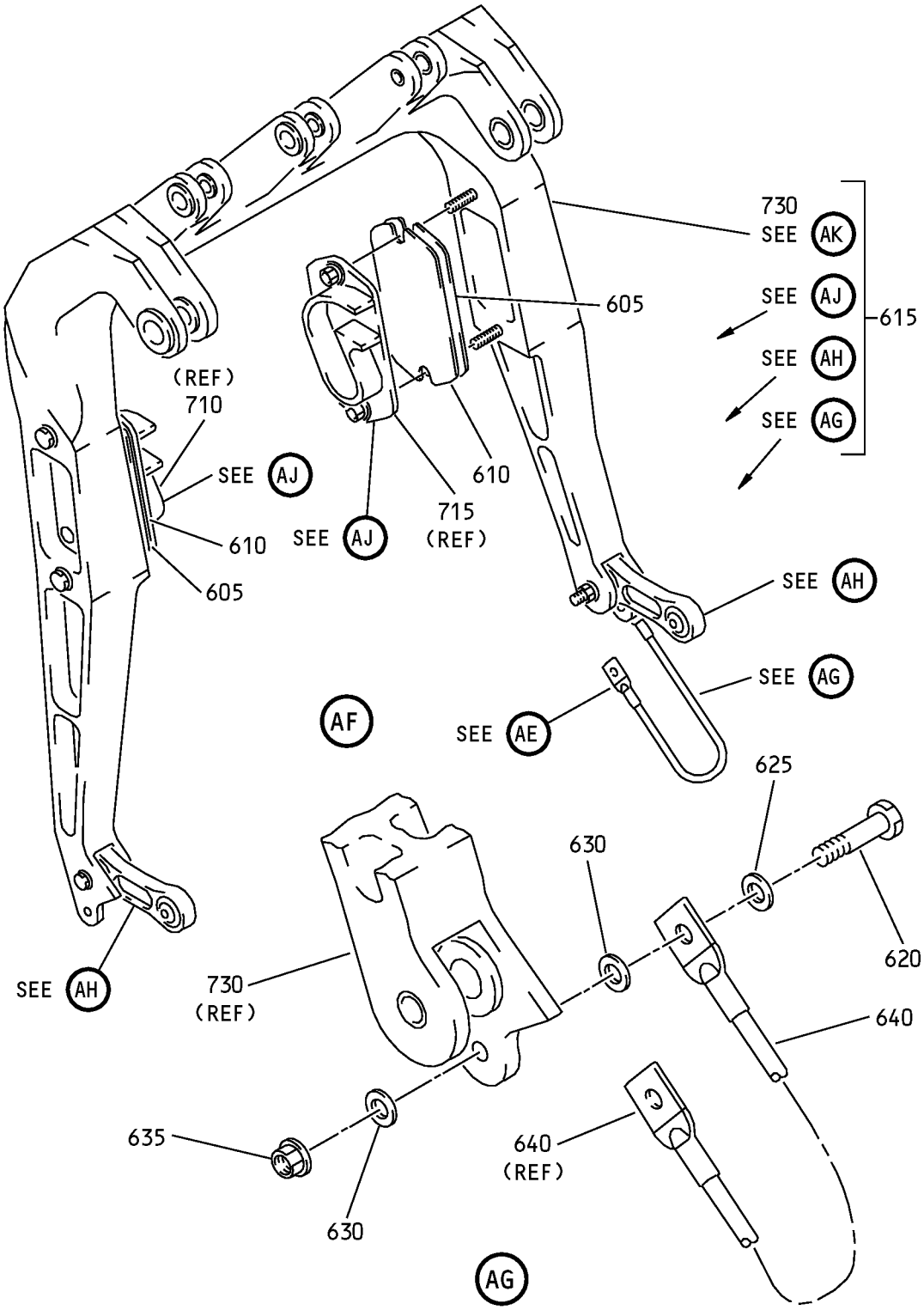
Automatic Overwing Exit Door Assembly
IPL Figure 1 (Sheet 16 of 24)



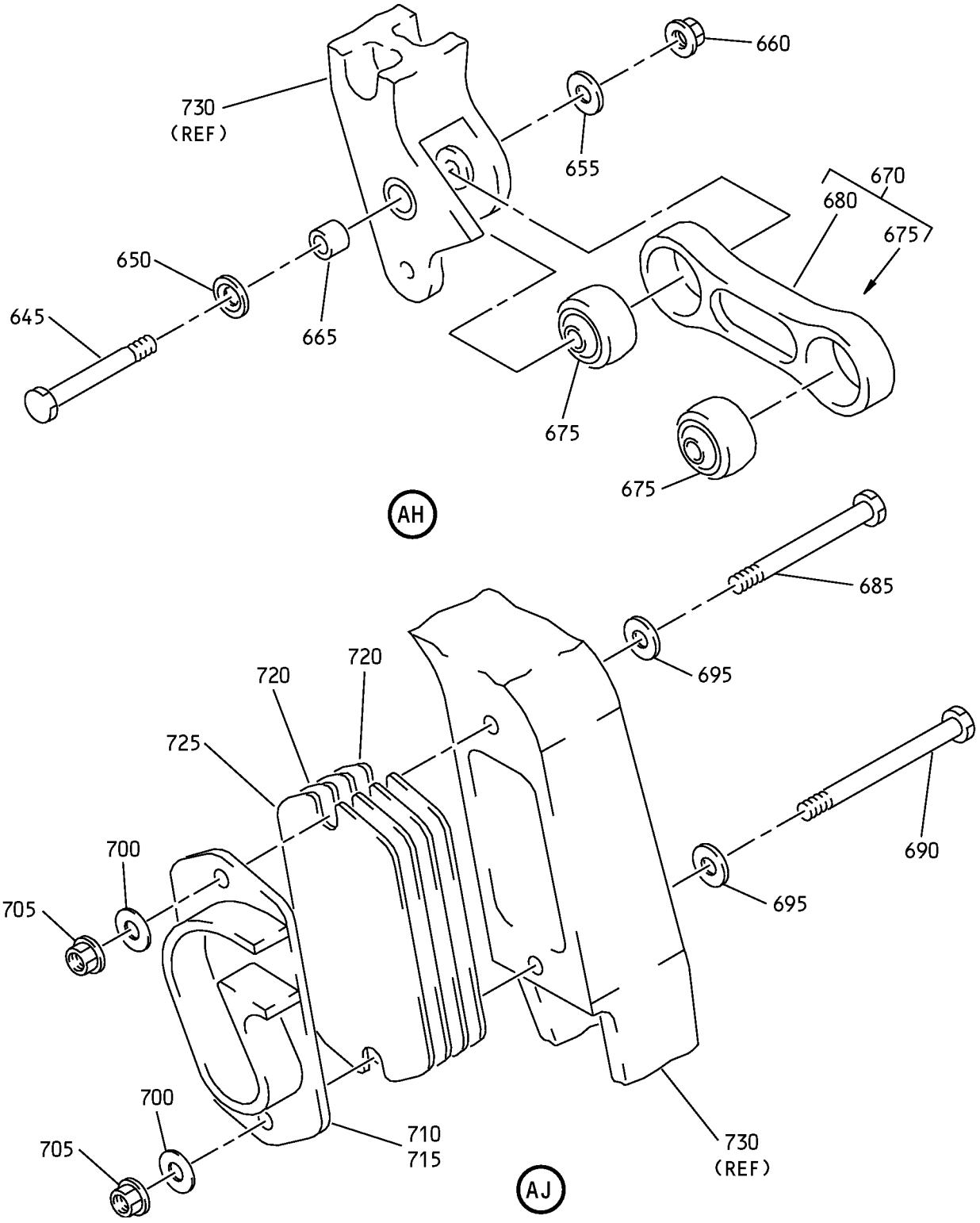
Automatic Overwing Exit Door Assembly
IPL Figure 1 (Sheet 17 of 24)



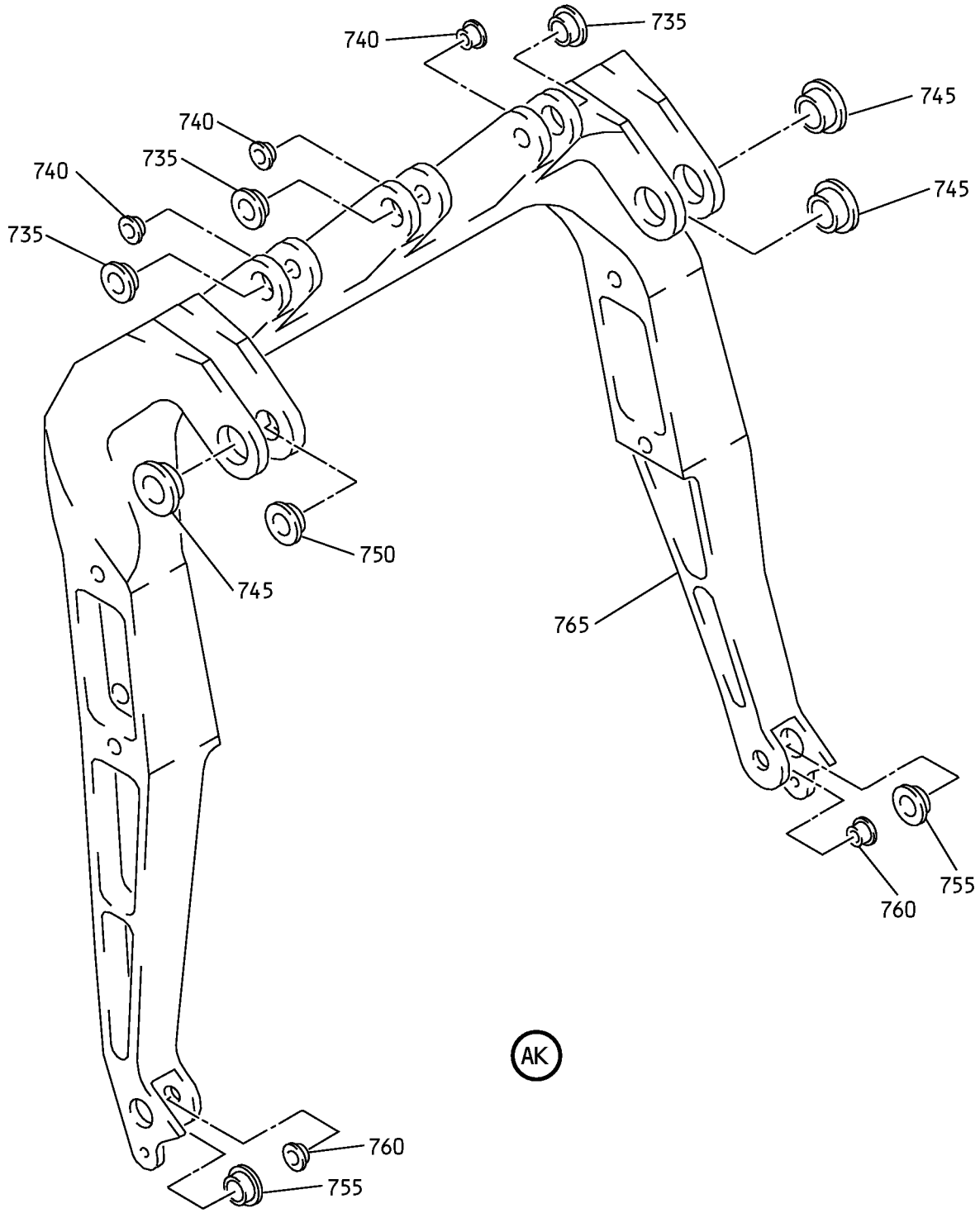
Automatic Overwing Exit Door Assembly
IPL Figure 1 (Sheet 18 of 24)



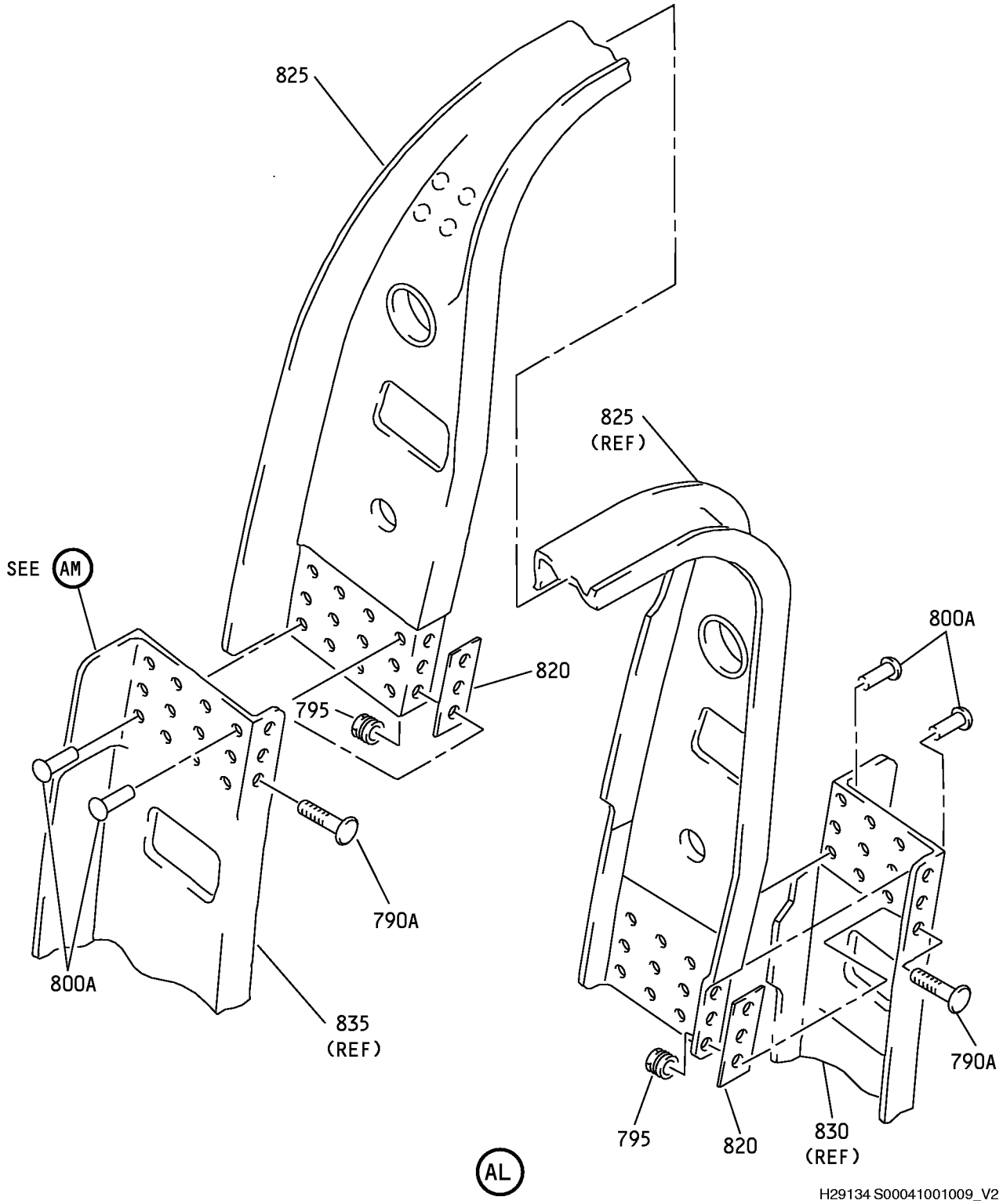
Automatic Overwing Exit Door Assembly
IPL Figure 1 (Sheet 19 of 24)



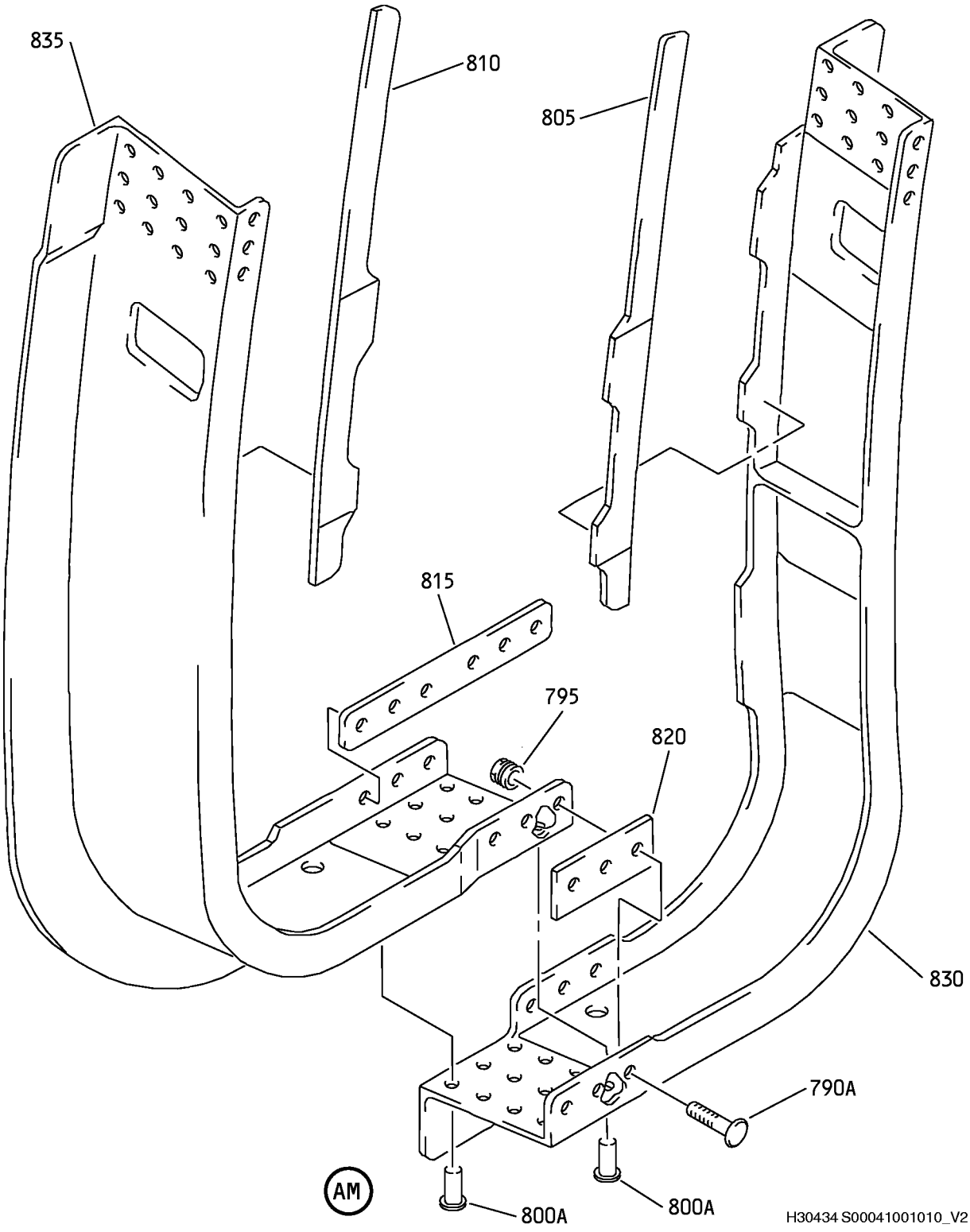
Automatic Overwing Exit Door Assembly
IPL Figure 1 (Sheet 20 of 24)



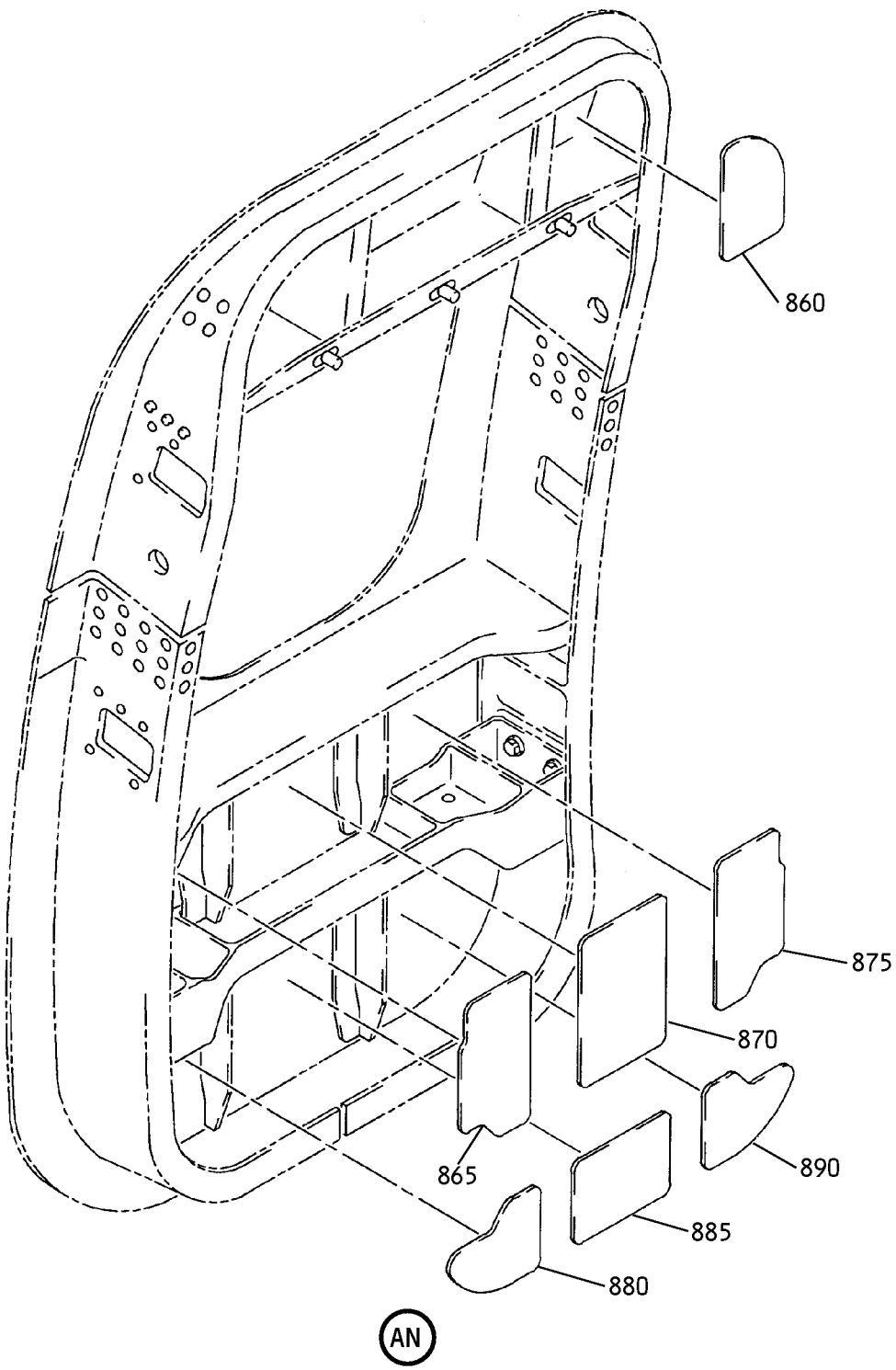
Automatic Overwing Exit Door Assembly
IPL Figure 1 (Sheet 21 of 24)



Automatic Overwing Exit Door Assembly
IPL Figure 1 (Sheet 22 of 24)



Automatic Overwing Exit Door Assembly
IPL Figure 1 (Sheet 23 of 24)



Automatic Overwing Exit Door Assembly
IPL Figure 1 (Sheet 24 of 24)

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
–1A	144A6505-1		DOOR ASSY-AUTO OVERWING EXIT (PRE SB 737-52-1135)	A	RF
–1B	144A6505-2		DOOR ASSY-AUTO OVERWING EXIT (PRE SB 737-52-1135)	B	RF
–1C	144A6505-3		DOOR ASSY-AUTO OVERWING EXIT (POST SB 737-52-1135)	C	RF
–1D	144A6505-4		DOOR ASSY-AUTO OVERWING EXIT (POST SB 737-52-1135)	D	RF
–1E	144A6505-5		DOOR ASSY-AUTO OVERWING EXIT	E	RF
–1F	144A6505-6		DOOR ASSY-AUTO OVERWING EXIT	F	RF
–1G	144A6505-7		DOOR ASSY-AUTO OVERWING EXIT	G	RF
–1H	144A6505-8		DOOR ASSY-AUTO OVERWING EXIT	H	RF
–1J	144A6505-9		DOOR ASSY-AUTO OVERWING EXIT	J	RF
–1K	144A6505-10		DOOR ASSY-AUTO OVERWING EXIT	K	RF
5	144A6518-1		. SUPPORT ASSY-PAYLOADS		1
–10	BACR15FR4E		DELETED		
10A	BACR15FR4ER		. . RIVET (SIZE DETERMINED ON INST)		16
–15	BACR15FR5E		DELETED		
15A	BACR15FR5ER		. . RIVET (SIZE DETERMINED ON INST)		4
20	S411T100-1010		. . SHOCKMOUNT (OPT ITEM 20A)		7
–20A	DE847		. . MOUNT (V71985) (OPT ITEM 20)		7
25	SL2752-3		. . MOUNT (V97393) (SPEC BACS14K2) (OPT DE679-10 (V71985))		1
30	144A6553-4		. . ANGLE		2
35	144A6560-1		. DEPRESSOR ASSY-SEAL		1
40	BACS12GU3K8		. . SCREW		6
45	NAS1149D0332J		. . WASHER		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–					
50	AF5141-3C		. . RIVET (V53551) (SPEC BACR15DR3AC) (SIZE DETERMINED ON INST)		12
55	102F9209M3		. . NUTPLATE (V72962) (SPEC BACN10KH3CD) (OPT FS1651-3 (V15653)) (OPT NS202496-02 (V80539))		2
60	BRFM20C3D		. . NUTPLATE (V52828) (SPEC BACN10JN3CD) (OPT 102F9201M3 (V72962)) (OPT NS202487-02 (V80539)) (OPT MF51637-3 (V15653)) (OPT MF53050-3CD (V15653))		4
65	BACR15GF4D		. . RIVET (SIZE DETERMINED ON INST)		4
70	144A6561-1		. . DEPRESSOR		1
75	144A6561-2		. . DEPRESSOR		1
80	BACF3T01E06-08		. . FILLER		4
85	144A6562-3		. . DEPRESSOR		1
90	144A6562-4		. . DEPRESSOR		1
95	144A6562-1		. . DEPRESSOR		1
100	144A6562-2		. . DEPRESSOR		1
105	144A6555-1		. WINDOW ASSY	A-H	1
–105A	144A6555-2		. WINDOW ASSY	J, K	1
110	BACS12FA3K15		. . SCREW		4
115	BACS12FA3K16		. . SCREW		4
120	BACS12FA3K11		. . SCREW		2
125	BACB28AK03-031		. . BUSHING		6
130	BACB28AK03-060		. . BUSHING		4
135	65C35017-4		. . RETAINER-CLIP	A-H	2
–135A	65C35017-9		. . RETAINER-CLIP	J, K	2
140	65C35017-5		. . RETAINER-CLIP	A-H	2
–140A	65C35017-10		. . RETAINER-CLIP	J, K	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–					
145	65C35017-1		. . RETAINER-CLIP	A-H	2
–145A	65C35017-6		. . RETAINER-CLIP	J, K	2
150	65C35017-3		. . RETAINER-CLIP	A-H	2
–150A	65C35017-8		. . RETAINER-CLIP	J, K	2
155	65C35017-2		. . RETAINER-CLIP	A-H	2
–155A	65C35017-7		. . RETAINER-CLIP	J, K	2
160	140N2139-2		. . WINDOW ASSY-CLIP	A-H	1
–160A	140N2139-5		. . WINDOW ASSY-CLIP	J, K	1
–165	65-76765-10		DELETED		
165A	65-76765-11		. . . SEAL	A-H	1
–165B	65-76765-12		. . . SEAL	J, K	1
170	140N2138-1		. . . PANE-OUTER	A-H	1
–170A	140N2138-2		. . . PANE-OUTER	J, K	1
175	65-45792-4		. . . PANE-MIDDLE (OPT ITEM 175A)	A-H	1
–175A	65-45792-6		. . . PANE-MIDDLE (OPT ITEM 175)	A-H	1
–175B	65-45792-7		. . . PANE-MIDDLE	J, K	1
180	144A6516-1		. SUPPORT ASSY-HANDFOLD		1
185	144A6391-1		. . SUPPORT ASSY		1
190	BACR15BA3AD		. . . RIVET (SIZE DETERMINED ON INST)		4
195	BRFM20C3D		. . . NUTPLATE (V52828) (SPEC BACN10JN3CD) (OPT 102F9201M3 (V72962)) (OPT NS202487-02 (V80539)) (OPT MF51637-3 (V15653)) (OPT MF53050-3CD (V15653))		2
200	144A6391-3		. . . STIFFENER		1
205	144A6391-4		. . . SHIM		4
210	144A6391-2		. . . SUPPORT		1
215	144A6585-1		. SUPPORT ASSY-ARMREST	A, C	1
–215A	144A6585-2		. SUPPORT ASSY-ARMREST	B, D-K	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–					
220	MS21141U0604P		. . FASTENER		2
225	MS21141U0603P		. . FASTENER		4
230	144A6587-3		. . ISOLATOR-THRM		6
235	BACR15FT5D		. . RIVET (SIZE DETERMINED ON INST)		4
240	65C35013-7		. . TEE		2
–245	AF3253-5-4B		DELETED		
245A	BACR15FT6D4		. . RIVET		4
–250	CR3252-5-4		DELETED		
250A	BACR15GF6D4		. . RIVET		4
–255	BACR15FR5E		DELETED		
255A	BACR15FR5ER		. . RIVET (SIZE DETERMINED ON INST)		4
260	144A6586-3		. . SUPPORT ASSY (PRE SB 737-25-1369)	A, C	1
–260A	144A6586-5		. . SUPPORT ASSY	B, D-K	1
–260B	144A6586-7		. . SUPPORT ASSY (POST SB 737-25-1369)	A, C	1
–265	BACR15BA3AD		DELETED		
265A	BACR15BA3ADC		. . . RIVET (SIZE DETERMINED ON INST)		8
–267	BACR15BA3AD		DELETED		
267A	BACR15BA3ADC		. . . RIVET (USED ON ITEMS 260A, 260B) (SIZE DETERMINED ON INST)		4
270	BRFM20C4D		. . . NUTPLATE (V52828) (SPEC BACN10JN4CD) (OPT T8301C428CD (V11815)) (OPT 102F9201M4 (V72962)) (OPT NS202487-048 (V80539)) (OPT MF51637-4 (V15653)) (OPT MF53050-4CD (V15653))		4

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
272	BRFM20C4D		. . . NUTPLATE (V52828) (SPEC BACN10JN4CD) (OPT T8301C428CD (V11815)) (OPT 102F9201M4 (V72962)) (OPT NS202487-048 (V80539)) (OPT MF51637-4 (V15653)) (OPT MF53050-4CD (V15653)) (USED ON ITEMS 260A, 260B)		2
275	BACF3F010G010AN		. . . FILLER		4
277	BACF3F010G010AN		. . . FILLER (USED ON ITEMS 260A, 260B)		2
280	144A6586-4		. . . CHANNEL (USED ON ITEM 260)	A, C	1
–280A	144A6586-6		. . . CHANNEL	B, D-K	1
–280B	144A6586-8		. . . CHANNEL (USED ON ITEM 260B)	A, C	1
285	144A6535-1		. SEAL ASSY-HANDLE		1
290	66-8712-1		. . SEAL		1
295	69-8857		. . RETAINER-SEAL		1
300	144A6540-1		. FRAME ASSY-HANDLE		1
305	144A6541-1		. . FRAME		1
310	144A6600-1		. MECHANISM ASSY-HANDLE		1
315	HST10AG6-15		DELETED		
315A	HST10AG6-16		. . BOLT (V0PTK6) (SPEC BACB30VT6K16) (OPT HST10AG6-16 (V06725)) (OPT HST10AG6-16 (V56878)) (OPT HST10AG6-16 (V73197)) (OPT WC10K6-16 (V60516))		2
320	BACB30VF3K22		. . BOLT		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–					
325	HL1012AZ6-19		. . BOLT (V97928) (SPEC BACB30NX6K19) (OPT HL12VAZ6-19 (V73197)) (OPT HL12VAZ6-19 (V92215)) (OPT HL12VAZ6-19 (V97928)) (OPT L802-6K19 (V06725)) (OPT HL12VAZ6-19 (V56878)) (OPT HL1012AZ6-19 (V0PTK6)) (OPT HL1012AZ6-19 (V06725)) (OPT HL1012AZ6-19 (V06950)) (OPT HL1012AZ6-19 (V17446)) (OPT HL1012AZ6-19 (V56878)) (OPT HL1012AZ6-19 (V60516)) (OPT HL1012AZ6-19 (V73197))		2
330	BACB30NM3K14		. . BOLT		2
335	BACW10DS3U		. . WASHER		2
340	MS15795-848		. . WASHER		2
345	BACW10BP3ACU		. . WASHER		2
350	NAS1149E0363R		. . WASHER		2
355	NAS1149E0332R		. . WASHER		4
360	H52732-3CM		. . NUT (V15653) (SPEC BACN10YR3CM) (OPT PLH53CM (V62554))		6
365	BACB28AK03-020		. . BUSHING		2
370	69-70353-1		. . SHIM		AR
375	69-70353-2		. . SHIM		AR
380	69-70353-3		. . SHIM		AR
385	ADB12-4005		. . BEARING (V15860) (SPEC 10-60545-97A) (OPT 03-823-12E017 (V09455)) (OPT NE12BA (V73134)) (OPT SWKN12-153 (V81376))		2
–385A	SWKN12-153		DELETED		
390	258A4707-1		. . SPACER		1
395	144A6603-4		DELETED		
395A	144A6603-5		. . SPRING		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–					
400	65C36528-5		. . SLEEVE		1
405	65C36528-3		. . SLEEVE		1
410	65C36528-4		. . SLEEVE		1
415	144A6601-2		. . MECHANISM ASSY		1
420	144A6602-2		. . . CRANK ASSY-DOOR LOCK		1
425	144A6602-5		. . . CRANK ASSY-DOOR LOCK		1
430	BACP18BC02A06P		. . . . PIN-COTTER		1
435	BACN10JD5AU		. . . . NUT		1
440	NAS1149E0532R		. . . . WASHER		AR
445	KRP178905VT		. . . . BEARING (V50632)		1
450	144A6602-4		. . . . CRANK (USED ON ITEM 420)		1
455	144A6602-6		. . . . CRANK (USED ON ITEM 425)		1
460	258A4705-1		. . . TUBE-STOP		1
465	144A6605-1		. . . HANDLE		1
470	144A6607-3		. . . STRAP ASSY-NUTPLATE		1
475	BACR15CE3D		. . . . RIVET (SIZE DETERMINED ON INST)		4
480	F51636-3		. . . . NUTPLATE (V15653) (SPEC BACN10JA3CD) (OPT 102F177-3 (V72962)) (OPT BRF110C3D (V52828)) (OPT BRF170C3D (V52828)) (OPT NS202484-02 (V80539))		2
485	144A6607-4		. . . . STRAP		1
490	144A6604-2		. . . TUBE-TORQUE		1
495	144A6610-1		. ARM ASSY-HINGE		1
500	MS16562-221		. . PIN-SPR		4
505	BACB30UU3K17		. . BOLT		2
510	BACB30NM3K7		. . BOLT		1
515	BACW10BP3CD		. . WASHER		3
520	NAS1149E0332P		. . WASHER		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–					
525	NAS1149D0332H		. . WASHER		2
530	NAS1149E0632P		. . WASHER (SELECT FROM)		AR
–530A	NAS1149E0616P		. . WASHER (SELECT FROM)		AR
532	NAS1149E0616		. . WASHER		AR
535	H52732-3CD		. . NUT (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))		3
540	BACB28AK04-032		. . BUSHING		2
545	144A6617-1		. . BUSHING		2
550	144A6642-2		. . CRANK ASSY-LOCK		1
555	144A6642-1		. . CRANK ASSY-LOCK		1
560	H52732-4CD		. . . NUT (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))		1
565	NAS1149E0432P		. . . WASHER		1
570	KRP146004BT		. . . BEARING (V50632)		1
575	144A6641-2		. . . PAWL (USED ON ITEM 550)		1
580	144A6641-1		. . . PAWL (USED ON ITEM 555)		1
585	144A6643-1		. . . CRANK		1
590	144A6644-2		. . SPRING-TORSION		1
595	144A6644-1		. . SPRING-TORSION		1
600	144A6645-1		. . SLEEVE		2
605	144A6618-1		. . SHIM		AR
610	144A6618-2		. . SHIM		AR
615	144A6611-1		. . ARM ASSY		1
620	BACB30NM3K5		. . . BOLT		1
625	BACW10BN3AC		. . . WASHER		1
630	NAS1149D0332J		. . . WASHER		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–					
635	H52732-3CD		. . . NUT (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))		1
640	BACJ40A20-6		. . . JUMPER		1
645	BACB30NR4K15		. . . BOLT		2
650	BACW10BP4CD		. . . WASHER		2
655	NAS1149E0432P		. . . WASHER		2
660	H52732-4CD		. . . NUT (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))		2
665	BACB28AK04-026		. . . BUSHING		2
670	144A6615-1		. . . LINK ASSY		2
675	WES04B10GC		. . . . BEARING (V73134) (SPEC BACB10FE04C) (OPT ADW4VNC (V15860)) (OPT KR4CWGBZC (V50632)) (OPT KWDB4-39 (V97613)) (OPT WRRS04B10GC (V73134)) (OPT WHT04VSBC (VS0352)) (OPT ITEM 675A)		2
–675A	MS14103-4P		. . . . BEARING (OPT ITEM 675)		2
680	144A6616-1		. . . . LINK		1
685	BACB30NR4K25		. . . BOLT		2
690	BACB30NR4K30		. . . BOLT		2
695	BACW10BN4AC		. . . WASHER		4
700	NAS1149D0432J		. . . WASHER		4
705	H52732-4CD		. . . NUT (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))		4
710	144A6613-1		. . . RECEIVER-LATCH		1
715	144A6613-2		. . . RECEIVER-LATCH		1
720	144A6618-1		. . . SHIM		6
725	144A6618-2		. . . SHIM		2

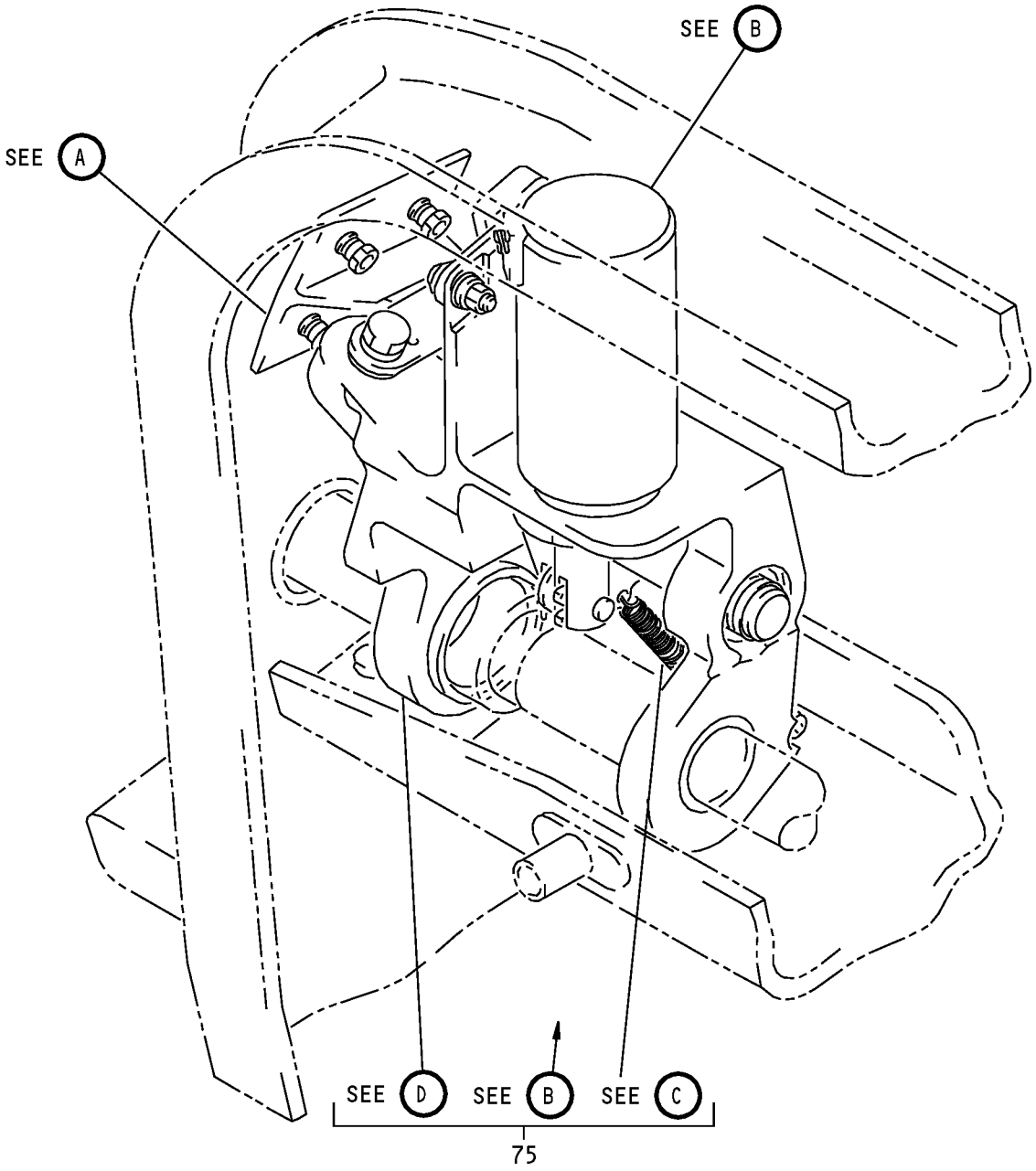
–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
730	144A6612-3		. . . ARM ASSY		1
735	BACB28AT06B020C		. . . . BUSHING		3
740	BACB28AP04P020		. . . . BUSHING		3
745	BACB28AT09B021C		. . . . BUSHING		3
750	BACB28AP06P029		. . . . BUSHING		1
755	BACB28AT06B014C		. . . . BUSHING		2
760	BACB28AP04P014		. . . . BUSHING		2
765	144A6612-1		. . . . HINGE		1
770	144A6695-1		. LOCK ASSY-FLIGHT (FOR DETAILS SEE FIG. 2)	A-E	1
–770A	144A6695-2		. LOCK ASSY-FLIGHT (FOR DETAILS SEE FIG. 2)	F-K	1
775	144A6545-1		. INTERCOSTAL ASSY (FOR DETAILS SEE FIG. 3)	A-J	1
–775A	144A6545-2		. INTERCOSTAL ASSY (FOR DETAILS SEE FIG. 3)	K	1
780	144A6520-1		. BEAM AND STOP ASSY (FOR DETAILS SEE FIG. 4)	A-D	1
–780A	144A6520-2		. BEAM AND STOP ASSY (FOR DETAILS SEE FIG. 4)	E, F	1
–780B	144A6520-3		. BEAM AND STOP ASSY (FOR DETAILS SEE FIG. 4)	G	1
–780C	144A6520-4		. BEAM AND STOP ASSY (FOR DETAILS SEE FIG. 4)	H-K	1
785	144A6510-1		. FRAME ASSY	A-F	1
–785A	144A6510-2		. FRAME ASSY	G, J, K	1
–790	HL1012AZ5-4		DELETED		
790A	HL1012AZ5-4		. . BOLT (V60516) (SPEC BACB30NX5HK4)		9
795	HL1087-5		. . COLLAR (V73197) (SPEC BACC30BH5) (OPT HL1087-5 (V56878)) (OPT HL1087-5 (V9N513))		9
–800	BACR15FT5D		DELETED		

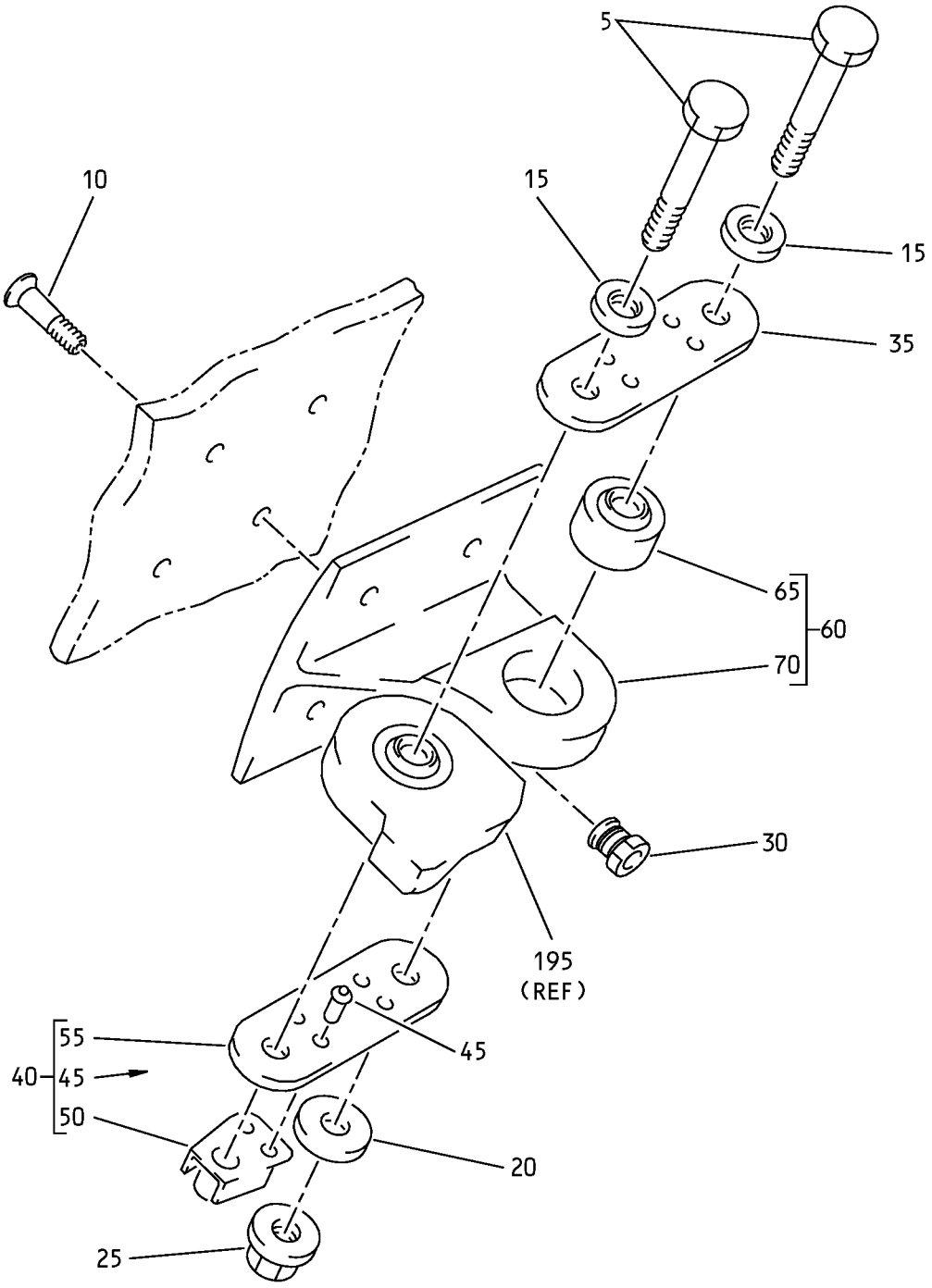
–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
800A	BACR15FT5D6		. . RIVET		36
805	144A6514-1		. . SPLICE-FRAME		1
810	144A6514-2		. . SPLICE-FRAME		1
815	144A6514-3		. . SPLICE-FRAME		1
820	BACS40R008C023F		. . SHIM		3
825	144A6511-1		. . FRAME-UPR		1
830	144A6512-1		. . FRAME-LWR FWD	A-F	1
–830A	144A6512-2		. . FRAME-LWR FWD	G-J	1
835	144A6513-1		. . FRAME-LWR AFT	A-F	1
–835A	144A6513-2		. . FRAME-LWR AFT	G-J	1
840	BAC27DBY191		DELETED		
845	BACM10A11-48T		DELETED		
845A	BACM10A11-48J		DELETED		
850	MS27253F1		DELETED		
855	144A6530-1		. DAMPENER ASSY	C-K	1
860	144A6531-7		. . DAMPER-STAND-OFF	C-K	1
865	144A6531-2		. . DAMPER-STAND-OFF	C-K	1
870	144A6531-5		. . DAMPER-STAND-OFF	C-K	1
875	144A6531-1		. . DAMPER-STAND-OFF	C-K	1
880	144A6531-4		. . DAMPER-STAND-OFF	C-K	1
885	144A6531-6		. . DAMPER-STAND-OFF	C-K	1
890	144A6531-3		. . DAMPER-STAND-OFF	C-K	1
900	BAC27DBY191		. MARKER-ALUMINUM FOIL		1
905	BACM10A11-48J		. MARKER-FWD LH AFT RH		1
910	MS27253F1		. PLATE-IDENT		1
			DELETED		

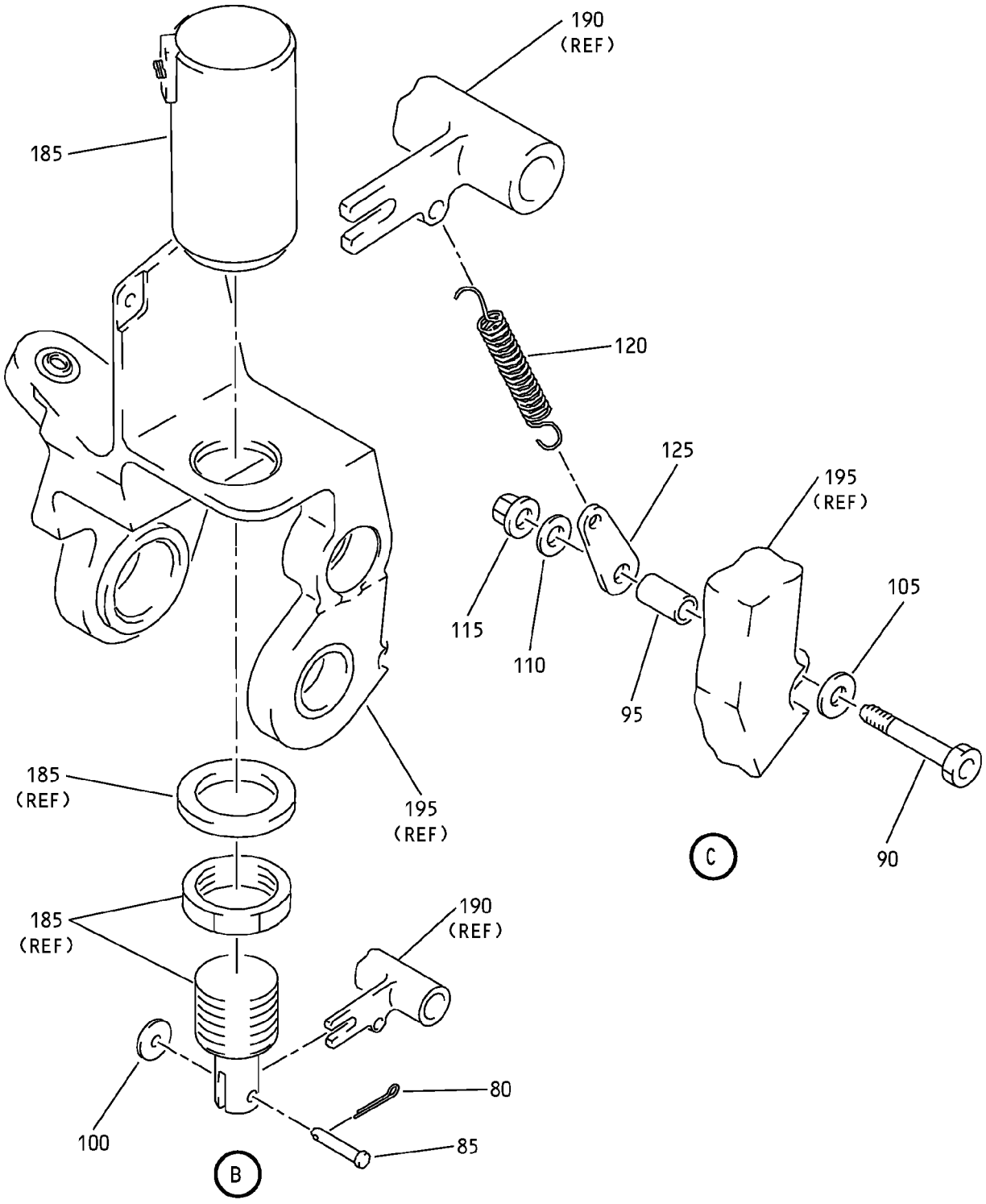
–Item not Illustrated



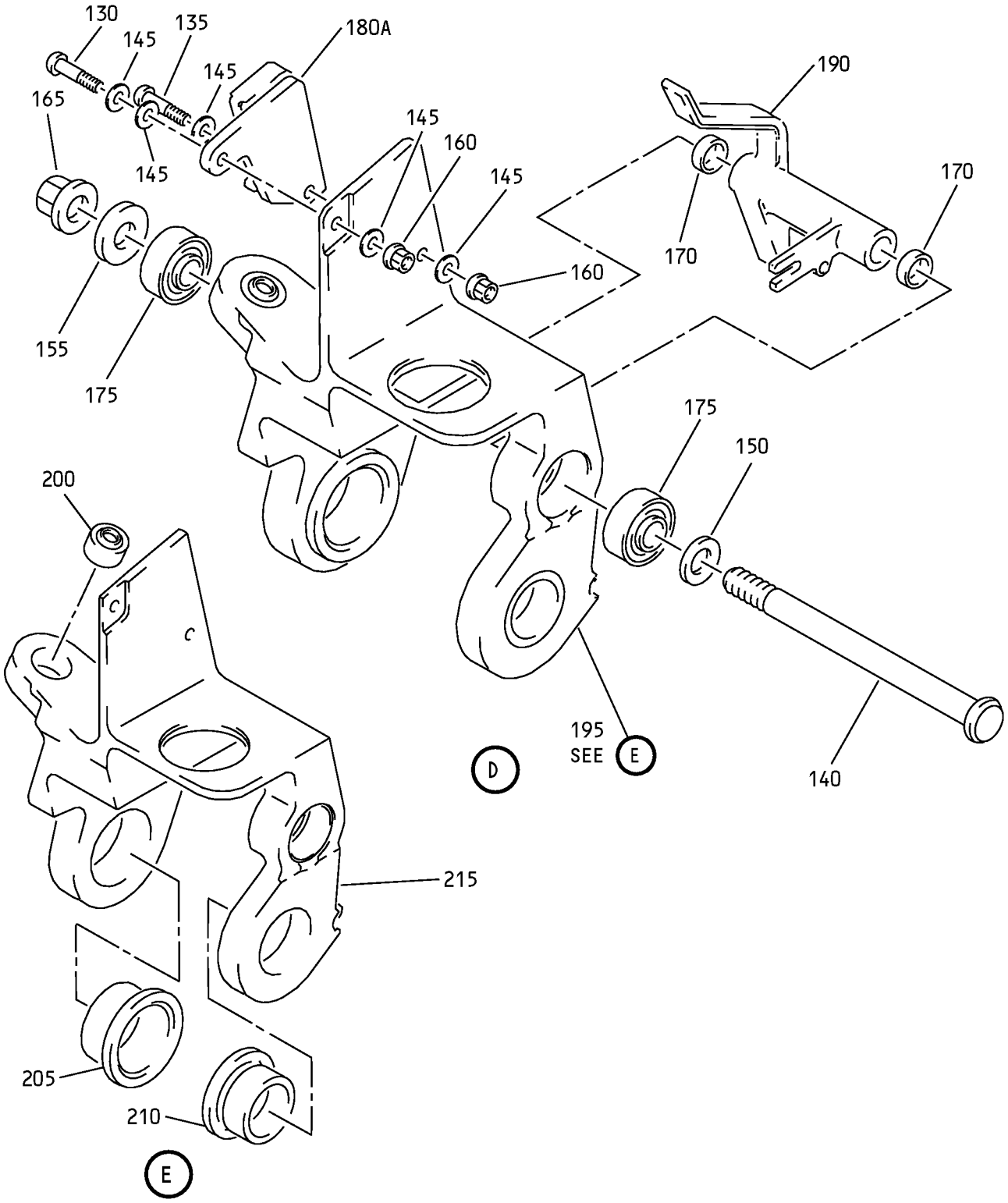
Automatic Overwing Exit Door Assembly
IPL Figure 2 (Sheet 1 of 4)



Automatic Overwing Exit Door Assembly
IPL Figure 2 (Sheet 2 of 4)



Automatic Overwing Exit Door Assembly
IPL Figure 2 (Sheet 3 of 4)



Automatic Overwing Exit Door Assembly
IPL Figure 2 (Sheet 4 of 4)

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
–1A	144A6695-1		LOCK ASSY-FLIGHT	A-E	RF
–1B	144A6695-2		LOCK ASSY-FLIGHT	F-J	RF
5	BACB30NM3K7		. BOLT		2
10	WC331K6-5		. BOLT (V60516) (SPEC BACB30YP6K5)		4
15	BACW10BP3CD		. WASHER		2
20	NAS1149E0363R		. WASHER		1
25	H52732-3CM		. NUT (V15653) (SPEC BACN10YR3CM) (OPT PLH53CM (V62554))		1
30	HST826AW		. COLLAR (V5M902) (SPEC BACC30BQ6) (OPT HST826AW (V56878)) (OPT HST826AW (V73197)) (OPT HST82CY6APBW (V73197)) (OPT HST82CY6APBW (V56878))		4
35	258A4706-2		. LINK-TORQUE		1
40	258A4706-3		. LINK ASSY-TORQUE		1
45	BACR15CE3M		. . RIVET (SIZE DETERMINED ON INST)		2
50	NS103225SE02		. . NUTPLATE (V80539) (SPEC BACN10KH3CM) (OPT 109F9209M3 (V72962)) (OPT F29779-01-3 (V15653))		1
55	258A4706-2		. . LINK		1
60	144A6515-1		. FITTING ASSY-SPRT		1
65	MS14104-3P		. . BEARING		1
70	144A6515-2		. . FITTING		1
75	258A4701-2		. LOCK ASSY	A-E	1
–75A	258A4701-3		. LOCK ASSY	F-K	1
80	BACP18BC01A04P		. . PIN-COTTER		1
85	MS20392-1A17		. . PIN-DRILLED SHANK	A-E	1

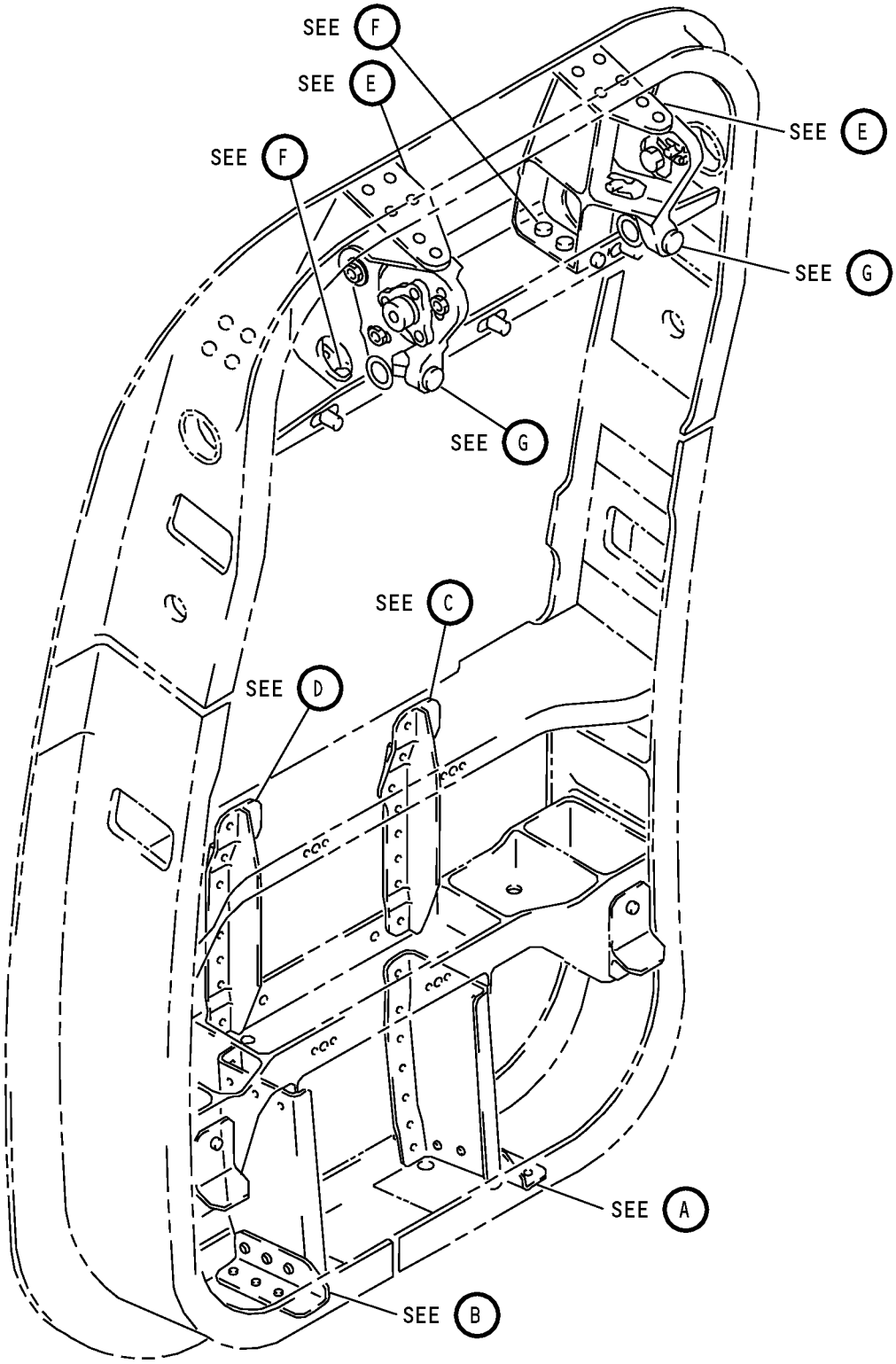
–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
–85A	BACP18BD1A17		. . PIN-DRILLED SHANK	F-K	1
90	BACB30NM3K10		. . BOLT		1
95	NAS43DD3-31FC		. . SPACER		1
100	NAS1149FN516P		. . WASHER		1
105	BACW10DS3S		. . WASHER		1
110	BACW10BP3NDP		. . WASHER		1
115	H52732-3CM		. . NUT (V15653) (SPEC BACN10YR3CM) (OPT PLH53CM (V62554))		1
120	MS24586C59		. . SPRING		1
125	258A4703-2		. . RETAINER-SPR		1
130	BACB30NT06K3		. . BOLT		1
135	BACB30NT06K4		. . BOLT		1
140	HST10AG10-45		. . BOLT (V0PTK6) (SPEC BACB30VT10K45) (OPT HST10AG10-45 (V06725)) (OPT HST10AG10-45 (V56878)) (OPT HST10AG10-45 (V73197)) (OPT WC10K10-45 (V60516))		1
145	NAS1149EN632P		. . WASHER		5
150	BACW10DS5S		. . WASHER		1
155	BACW10BP5DP		. . WASHER		1
160	H52732-06CM		. . NUT (V15653) (SPEC BACN10YR06CM) (OPT PLH506CM (V62554))		2
165	H52732-5CM		. . NUT (V15653) (SPEC BACN10YR5CM) (OPT PLH55CM (V62554))		1
170	BACB28AK05-006		. . BUSHING		2

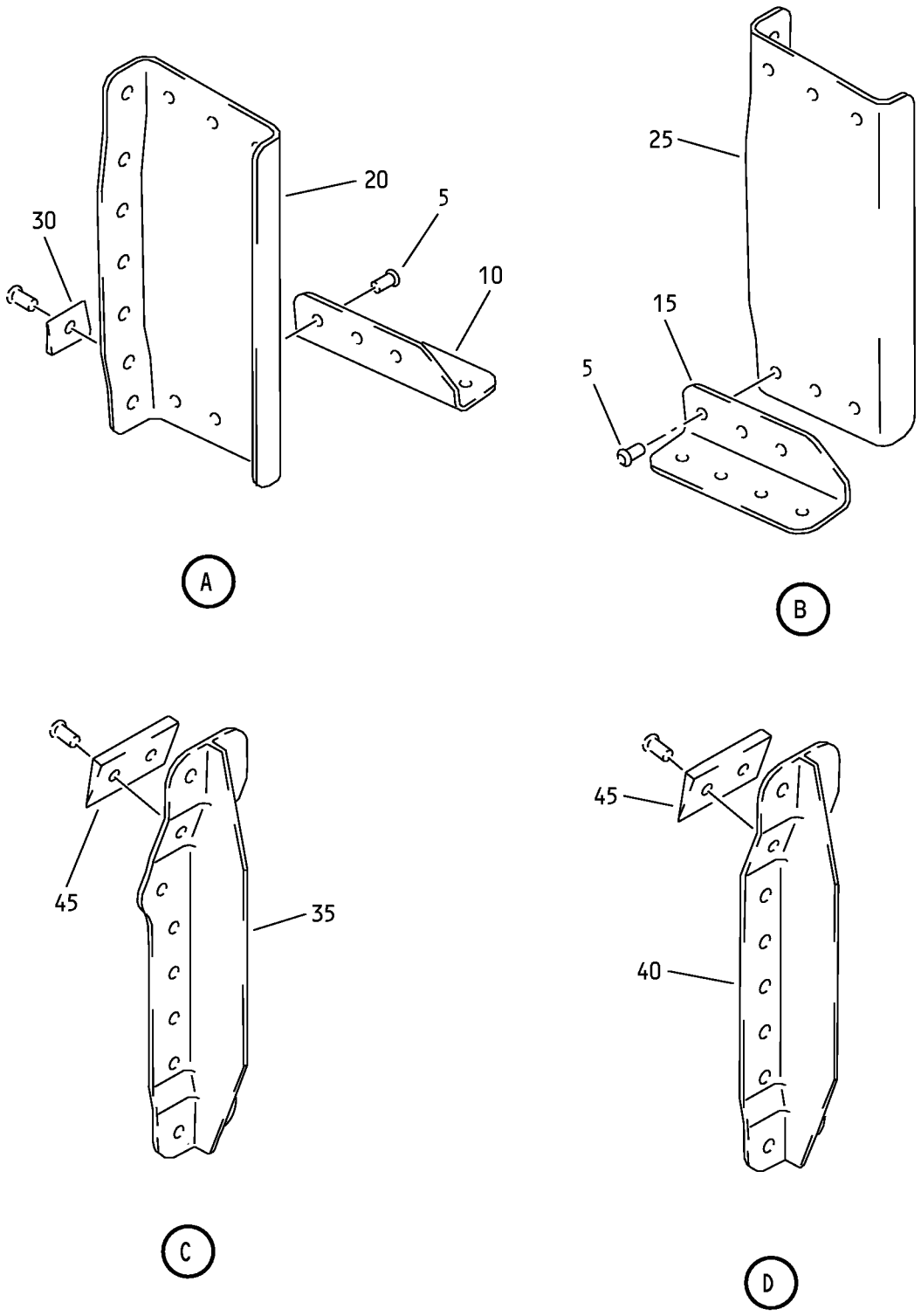
–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
175	SSMKP5ASD524		. . BEARING (V50294) (SPEC BACB10FS05J) (OPT PACMKP05JAA3908 (V21335)) (OPT SSMKP05JASD705 (V83086)) (OPT PACMKP5AFS428 (V21335)) (OPT ACMKP05JAP510LY (V40920)) (OPT SSMKP05JAP (V21760))		2
180	38HM65		DELETED		
180A	38HM65A		. . SWITCH (V32388)		1
185	A420-066923-01		. . SOLENOID (REPLACED BY ITEM 185C) (V73949) (OPT ITEM 185A) (PRE COMPONENT SB 737-SL-52-025)	A-E	1
–185A	A420-066923-00		. . SOLENOID (REPLACED BY ITEM 185C) (V73949) (OPT ITEM 185) (PRE COMPONENT SB 737-SL-52-025)	A-E	1
–185B	A420-066923-02		. . SOLENOID (V73949)	F-K	1
–185C	A420-066923-02		. . SOLENOID (REPLACES ITEMS 185, 185A) (V73949) (POST COMPONENT SB 737-SL-52-025)	A-E	1
190	258A4704-1		. . SHAFT-PAWL		1
195	258A4702-3		. . CRADLE ASSY		1
200	MS14104-3P		. . . BEARING		1
205	BACB28AT16B030C		. . . BUSHING		1
210	BACB28AT14B022C		. . . BUSHING		1
215	258A4702-4		. . . CRADLE		1

–Item not Illustrated

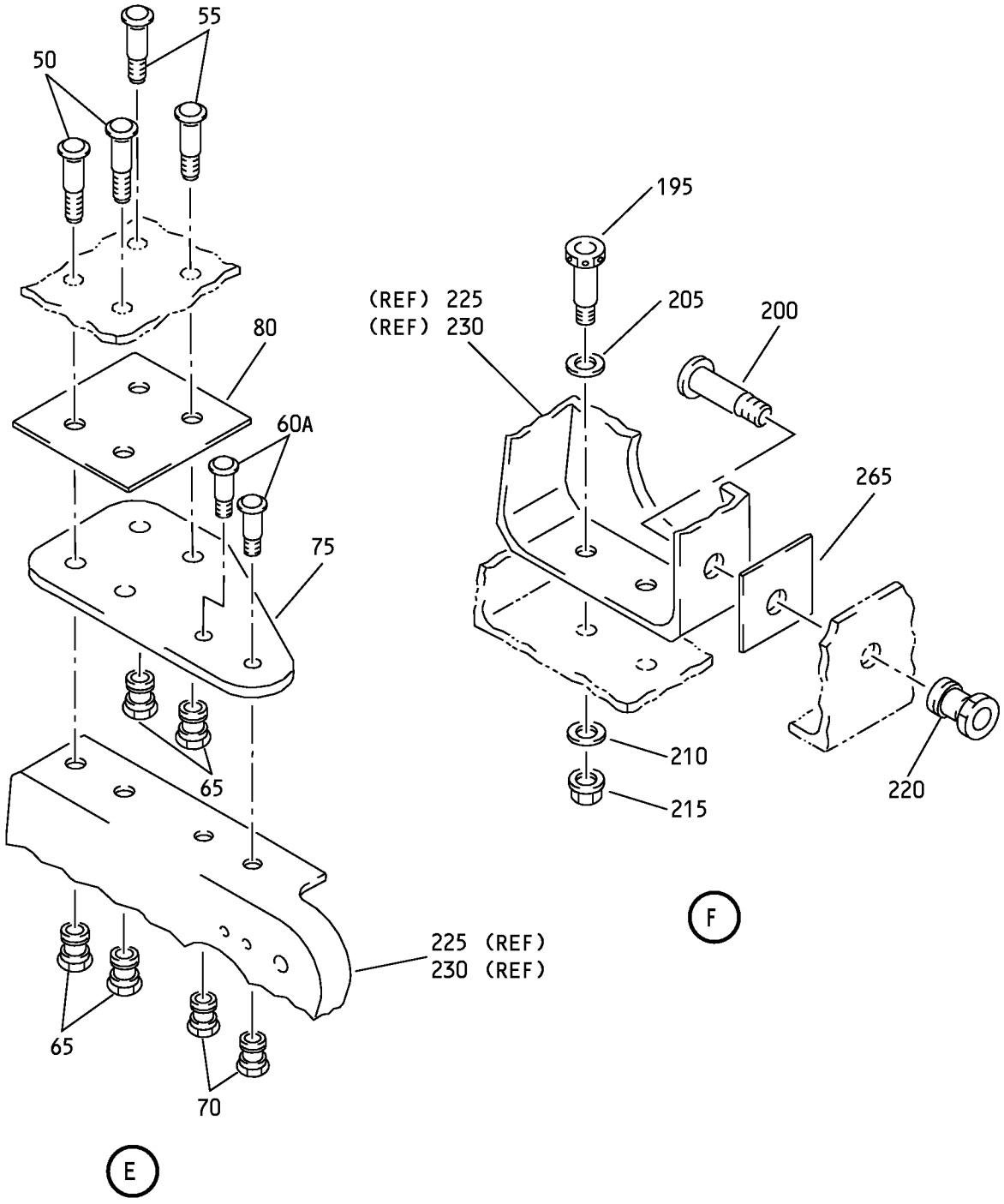


Automatic Overwing Exit Door Assembly
IPL Figure 3 (Sheet 1 of 5)



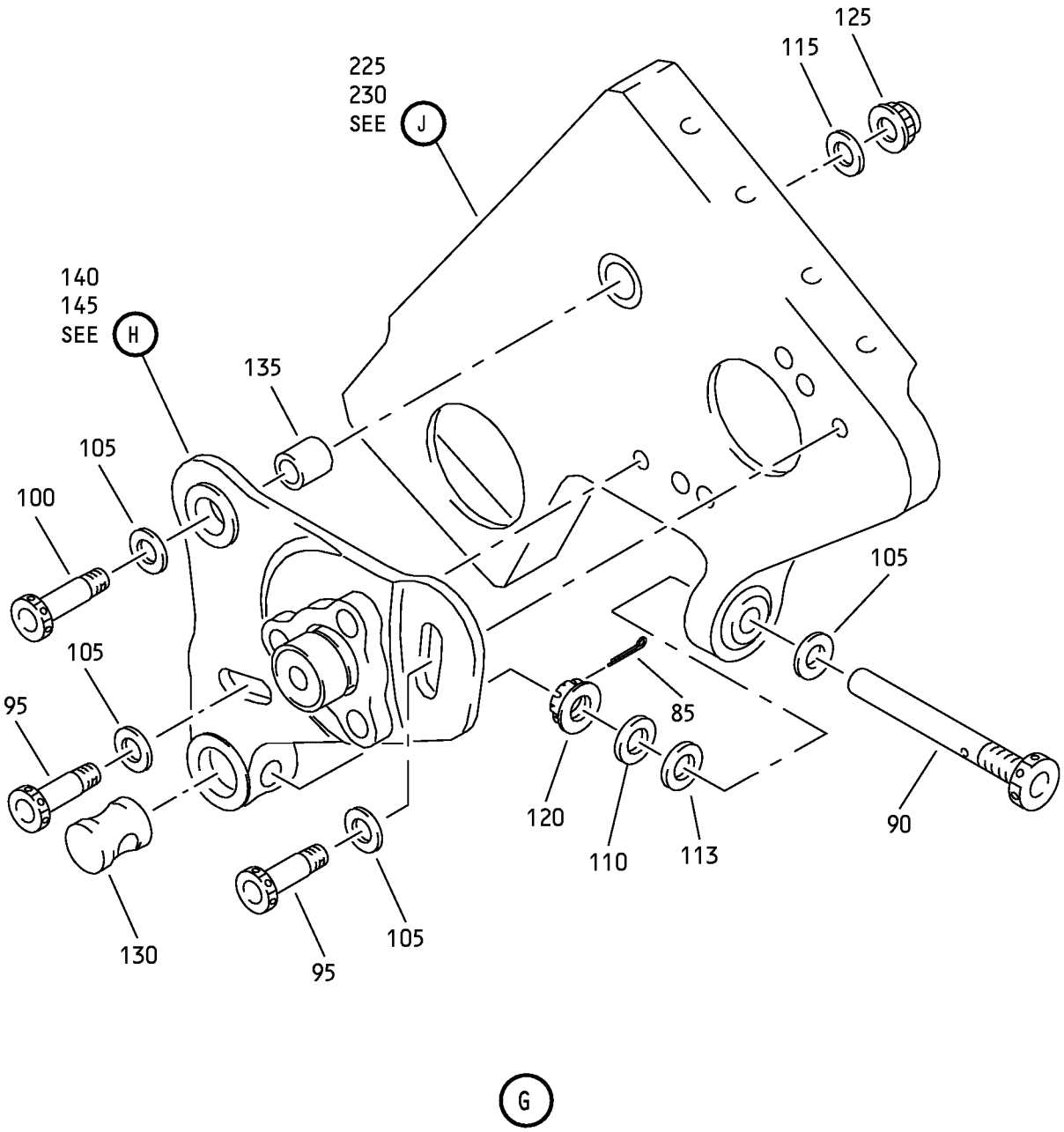
H32256 S00041001021_V2

Automatic Overwing Exit Door Assembly
IPL Figure 3 (Sheet 2 of 5)



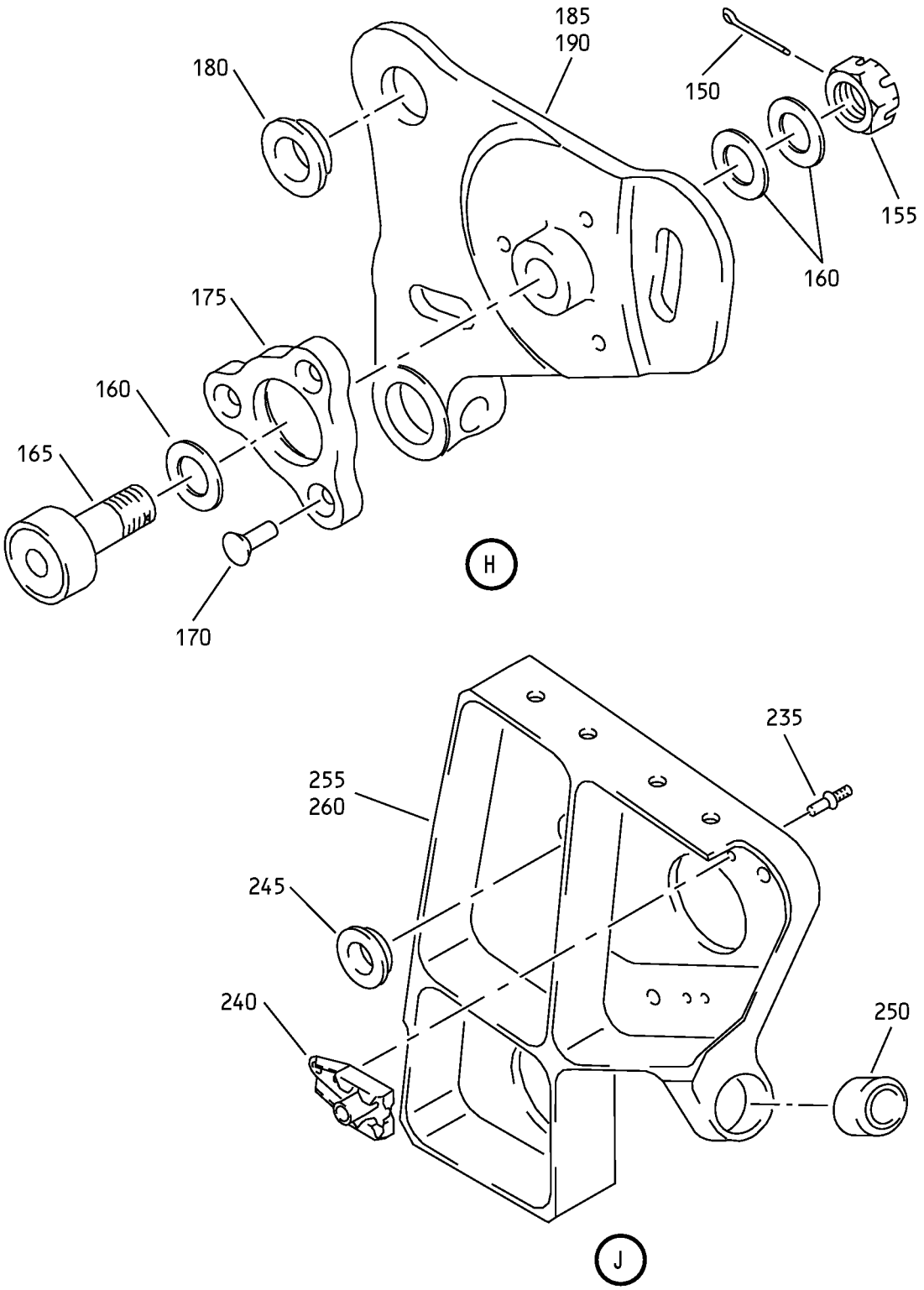
H32295 S00041001022_V2

Automatic Overwing Exit Door Assembly
IPL Figure 3 (Sheet 3 of 5)



H32385 S00041001023_V2

Automatic Overwing Exit Door Assembly
IPL Figure 3 (Sheet 4 of 5)



Automatic Overwing Exit Door Assembly
IPL Figure 3 (Sheet 5 of 5)

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
3–					
–1A	144A6545-1		INTERCOSTAL ASSY	A-J	RF
–1B	144A6545-2		INTERCOSTAL ASSY	K	RF
5	BACR15FT5D		. RIVET (SIZE DETERMINED ON INST)		20
10	144A6553-2		. ANGLE		1
15	144A6553-1		. ANGLE		1
20	144A6554-1		. INTERCOSTAL		1
25	144A6554-2		. INTERCOSTAL		1
30	BACF3T01J09-08		. FILLER		1
35	144A6442-3		. TEE-LWR		1
40	144A6442-4		. TEE-LWR		1
45	BACF3T01H08-15		. FILLER		2
50	WC331K6-6		. BOLT (V60516) (SPEC BACB30YP6K6)		4
55	WC331K6-4		. BOLT (V60516) (SPEC BACB30YP6K4)		4
–60	HST10AG5-3		DELETED		
60A	VL310AG5-3		. BOLT (V06950) (SPEC BACB30VT5HK3) (OPT VL310AG5-3 (V9N513)) (OPT VL310AG5-3 (V97928)) (OPT WC10K5-3 (V60516))		4
65	HST79CY6		. COLLAR (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V92215)) (OPT HST79CY6 (V56878)) (OPT HST79CY6 (V5M902))		8
70	HST79CY5		. COLLAR (V73197) (SPEC BACC30BL5) (OPT HST79-5 (V92215)) (OPT HST79CY5 (V56878)) (OPT HST79CY5 (V5M902))		4

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
3–					
75	144A6553-3		. ANGLE		2
80	BACS40R016C016F		. SHIM		2
85	BACP18BC02A06P		. PIN-COTTER	A-J	2
90	144A6542-1		. BOLT	A-J	2
–90A	144A6542-2		. BOLT	K	2
95	BACB30NM4K5		. BOLT		4
100	BACB30NM4K7		. BOLT		2
105	BACW10BP4CD		. WASHER		8
110	NAS1149E0416P		. WASHER	A-J	2
–110A	MS27111-1		. WASHER	K	2
113	NAS1149E0416P		. WASHER	A-J	2
115	NAS1149E0463P		. WASHER		2
120	BACN11N104CD		. NUT	A-J	2
–120A	BACN11U4CD2N		. NUT	K	2
125	NAS1805-4L		. NUT	A-J	2
–125A	BACN11Z4CD		. NUT	K	2
130	SL4165		. NUT-BARREL (V97393)		2
135	BACB28AK04-033		. BUSHING		2
140	144A6544-1		. PLATE ASSY-ROLLER ADJUSTMENT		1
145	144A6544-2		. PLATE ASSY-ROLLER ADJUSTMENT		1
150	BACP18BC02A10P		. . PIN-COTTER		1
155	BACN10JD5CD		. . NUT		1
160	NAS1149E0532P		. . WASHER		3
165	KRP178905VT		. . BEARING (V50632)		1
170	BACR15BA5AD9C		. . RIVET		3
175	144A6549-1		. . PAD-RUB		1
180	BACB28AT06B009C		. . BUSHING		1
185	144A6548-1		. . PLATE (USED ON ITEM 140)		1
190	144A6548-2		. . PLATE (USED ON ITEM 145)		1

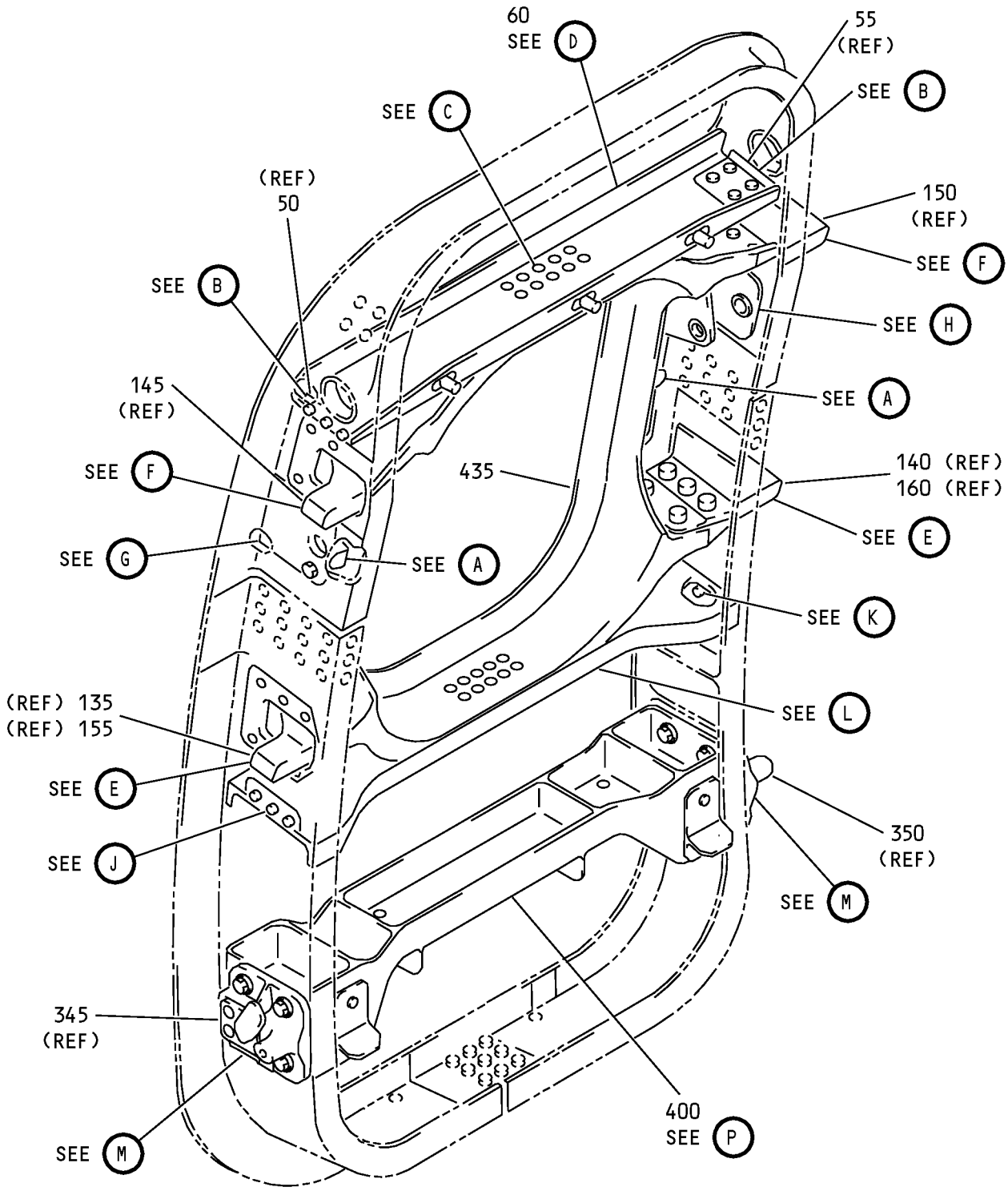
–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
3–					
195	BACB30NM3K5		. BOLT		4
200	HST10AG6-4		. BOLT (V06725) (SPEC BACB30VT6K4) (OPT HST10AG6-4 (V73197)) (OPT HST10AG6-4 (V56878)) (OPT HST10AG6-4 (V0PTK6))		2
205	BACW10BP3CD		. WASHER		4
210	BACW10BP3DP		. WASHER		4
215	H52732-3CD		. NUT (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))		4
220	HST79CY6		. COLLAR (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V92215)) (OPT HST79CY6 (V56878)) (OPT HST79CY6 (V5M902))		2
225	144A6546-1		. INTERCOSTAL ASSY		1
230	144A6546-2		. INTERCOSTAL ASSY		1
235	AF5141-3C		. . RIVET (V53551) (SPEC BACR15DR3AC) (SIZE DETERMINED ON INST)		4
240	F51636-4		. . NUTPLATE (V15653) (SPEC BACN10JA4CD) (OPT 102F177-4 (V72962)) (OPT BRF110C4D (V52828)) (OPT BRF170C4D (V52828)) (OPT F51636-4 (V15653))		2
245	BACB28AT06B007C		. . BUSHING		1
250	WES04B10GC		. . BEARING (V73134) (SPEC BACB10FE04C) (OPT ADW4VNC (V15860)) (OPT KR4CWGBZC (V50632)) (OPT KWDB4-39 (V97613)) (OPT WRRS04B10GC (V73134)) (OPT WHT04VSBC (VS0352)) (OPT ITEM 250A)		1

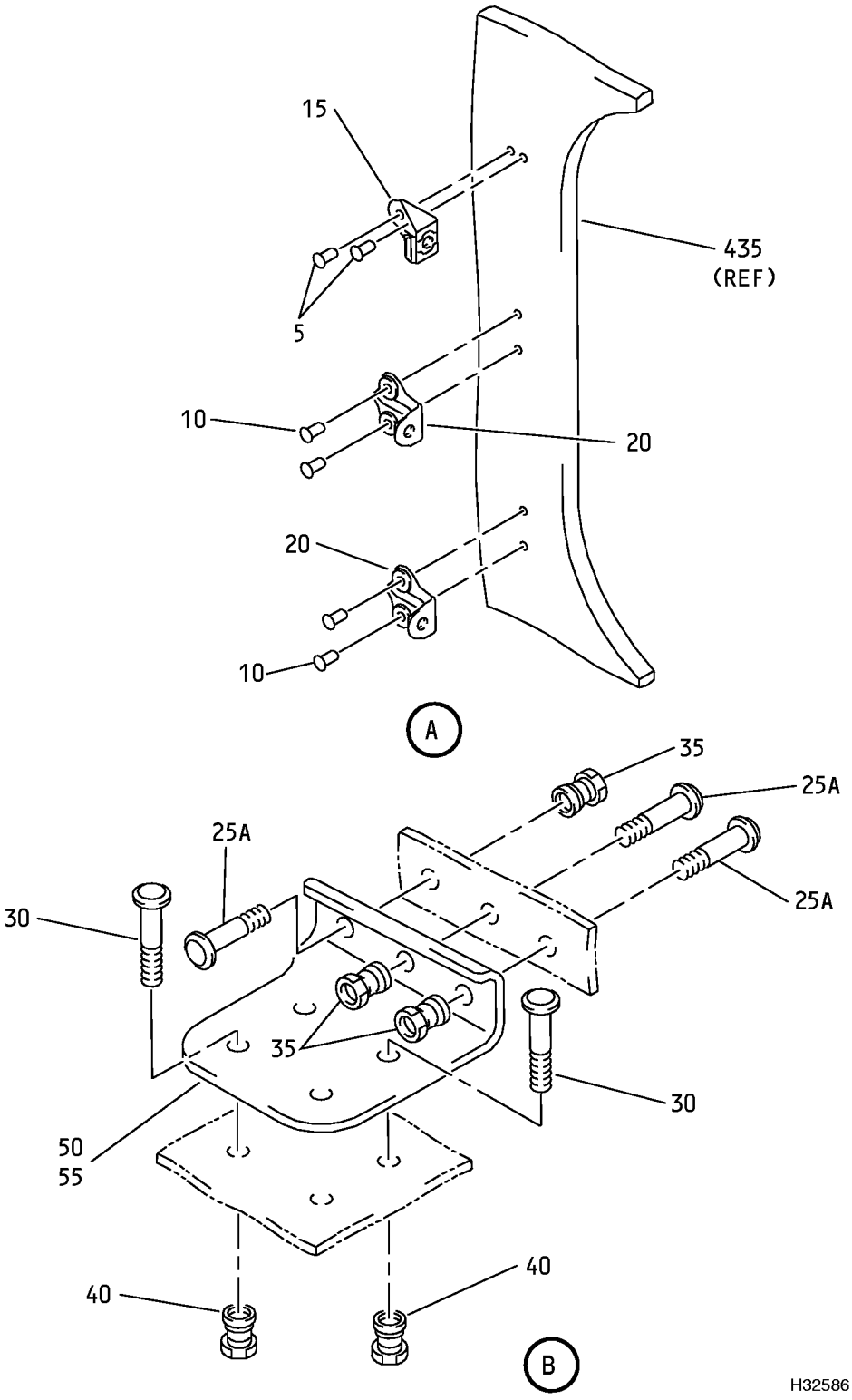
–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
3–					
–250A	MS14103-4P		. . BEARING (OPT ITEM 250)		1
255	144A6546-3		. . INTERCOSTAL (USED ON ITEM 225)		1
260	144A6546-4		. . INTERCOSTAL (USED ON ITEM 230)		1
265	BACS40R008C008F		. SHIM		2

–Item not Illustrated

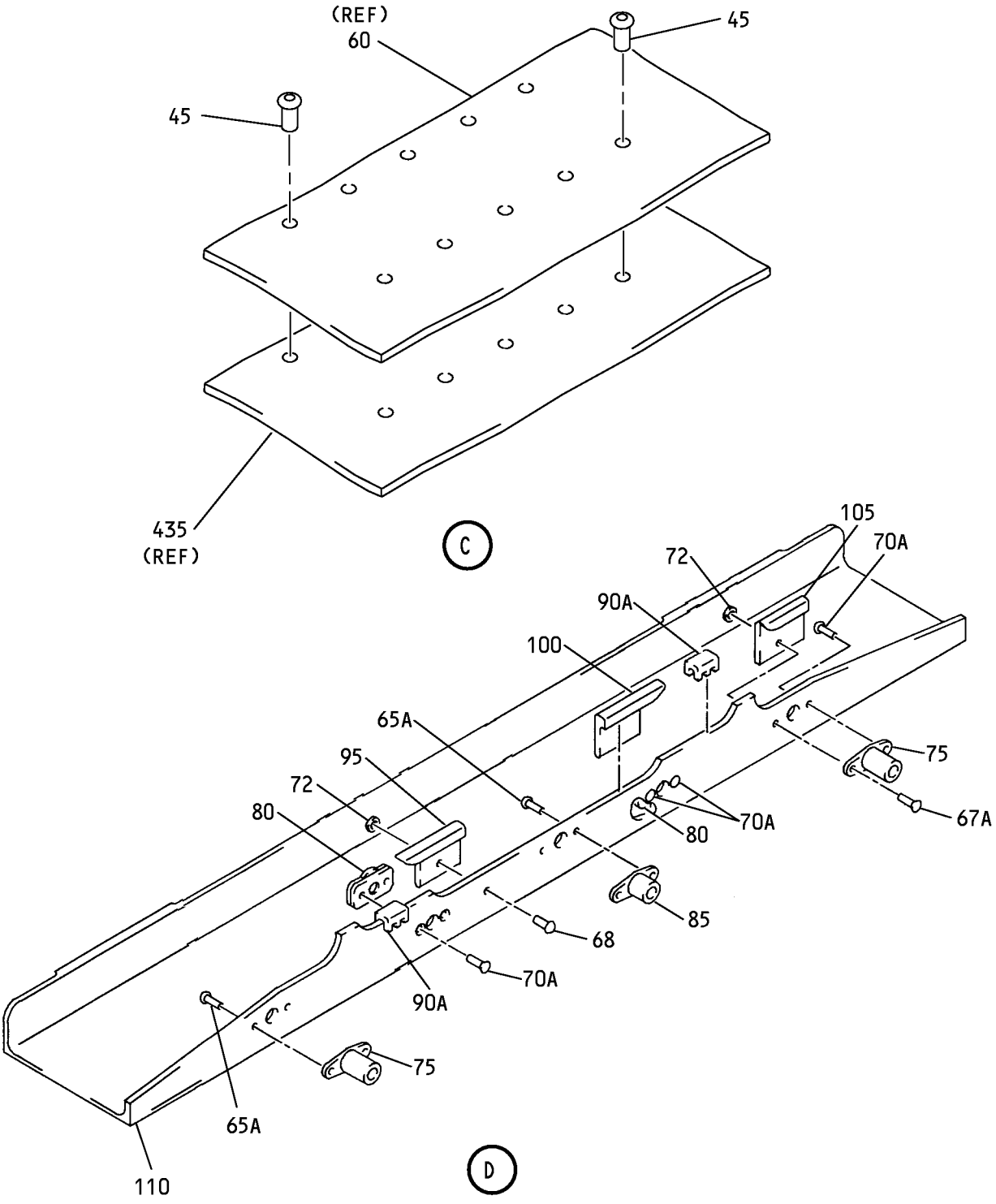


Automatic Overwing Exit Door Assembly
IPL Figure 4 (Sheet 1 of 9)



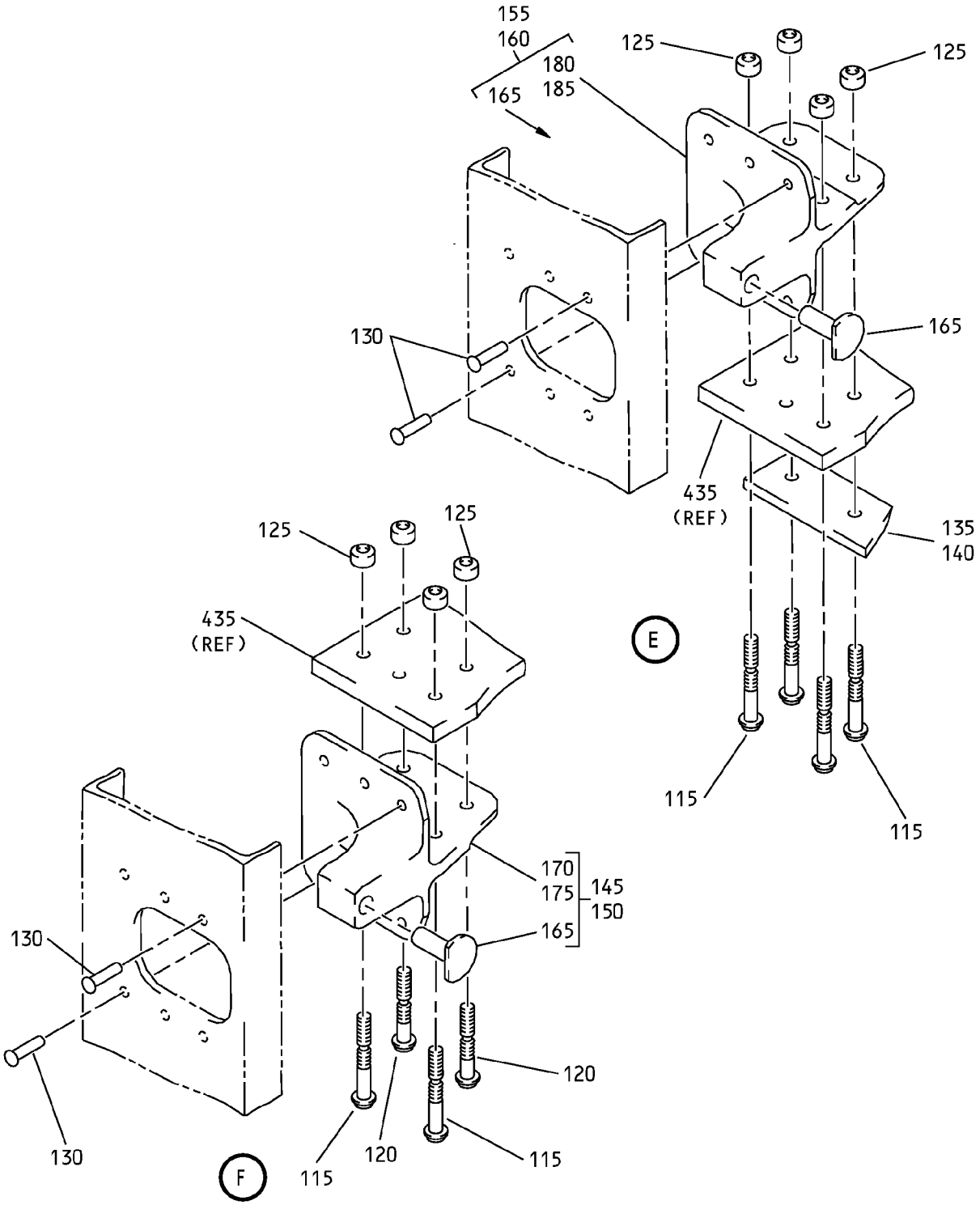
H32586 S00041001028_V2

Automatic Overwing Exit Door Assembly
IPL Figure 4 (Sheet 2 of 9)

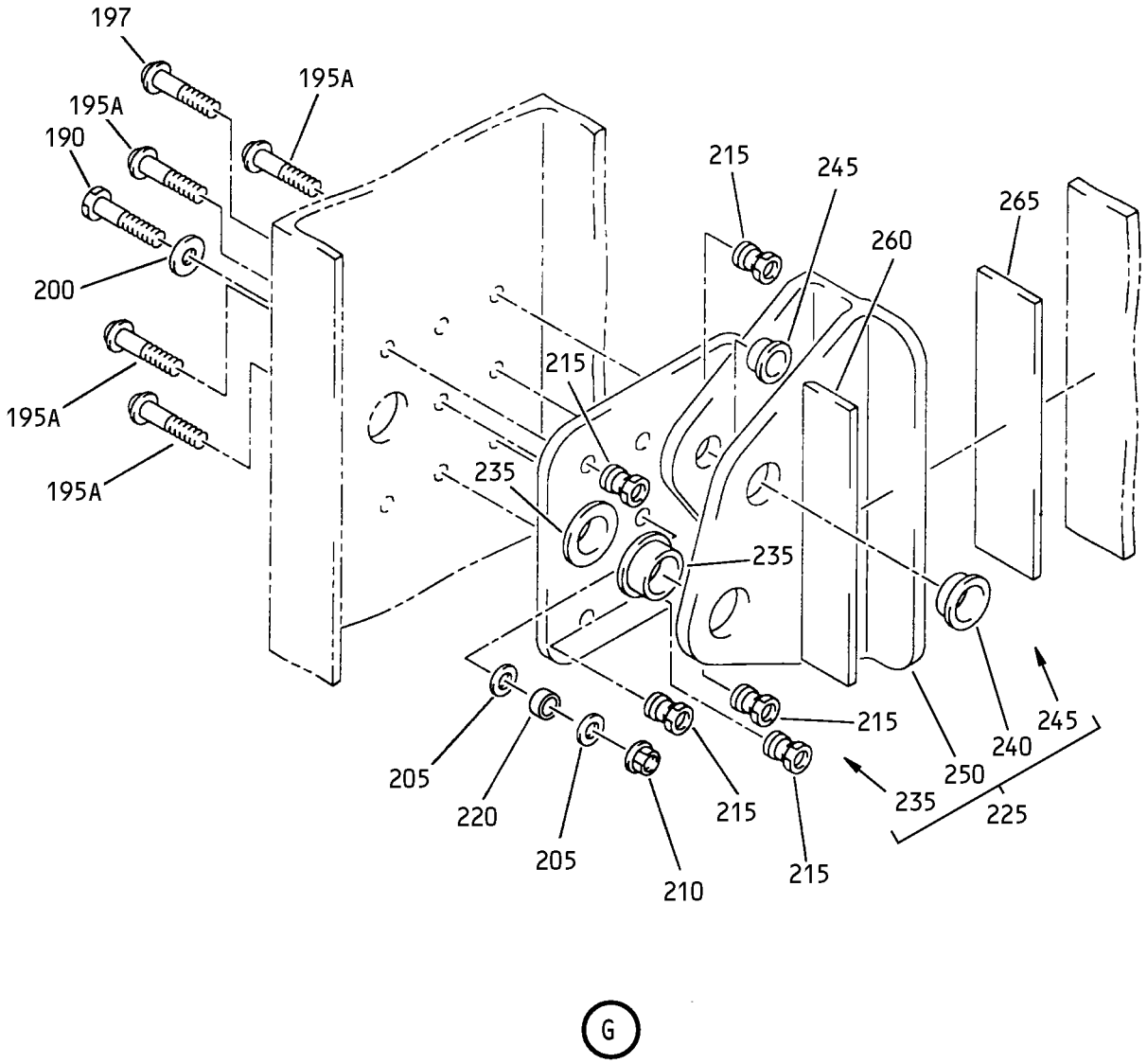


H32607 S00041001029_V2

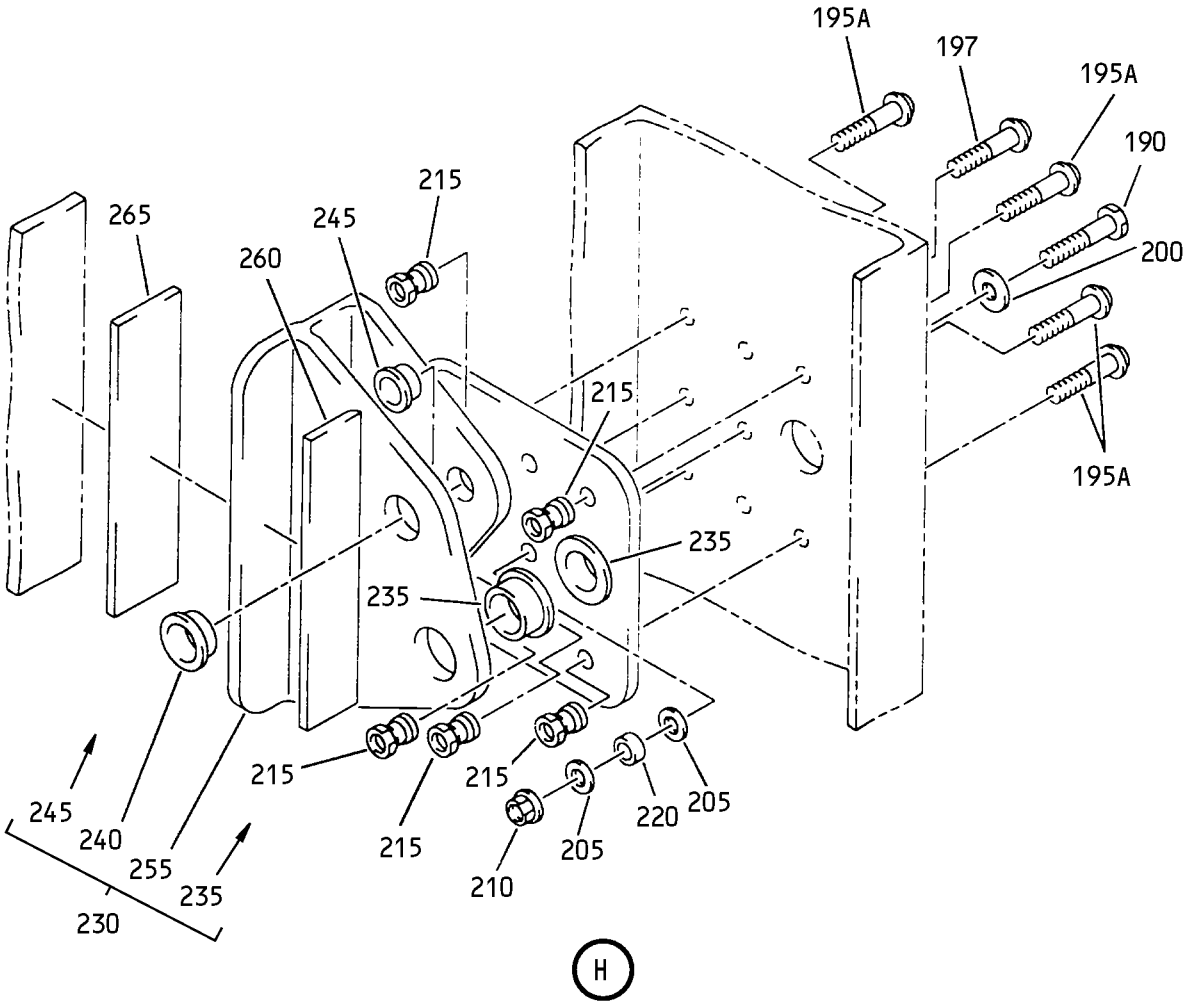
Automatic Overwing Exit Door Assembly
IPL Figure 4 (Sheet 3 of 9)



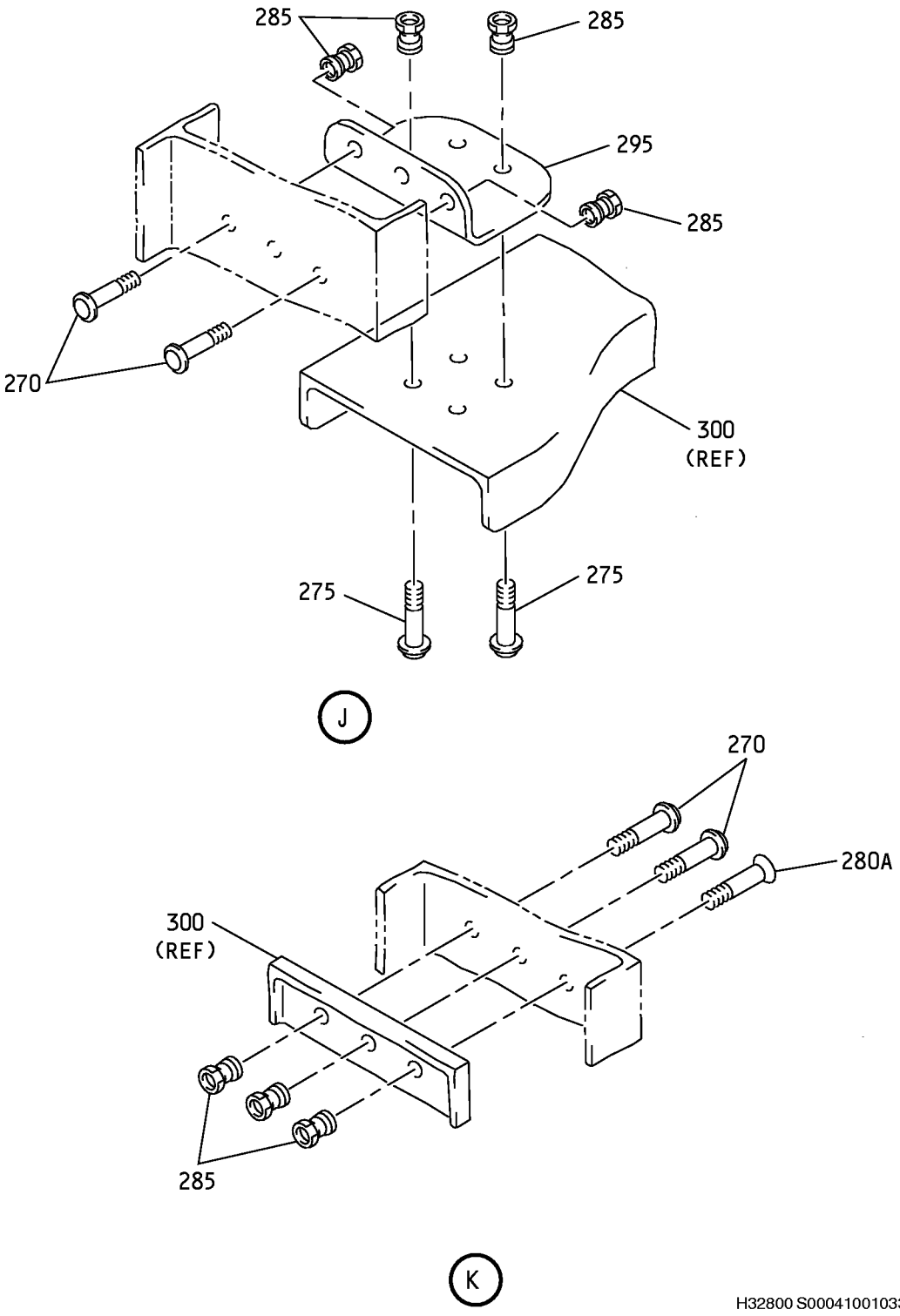
Automatic Overwing Exit Door Assembly
IPL Figure 4 (Sheet 4 of 9)



Automatic Overwing Exit Door Assembly
IPL Figure 4 (Sheet 5 of 9)

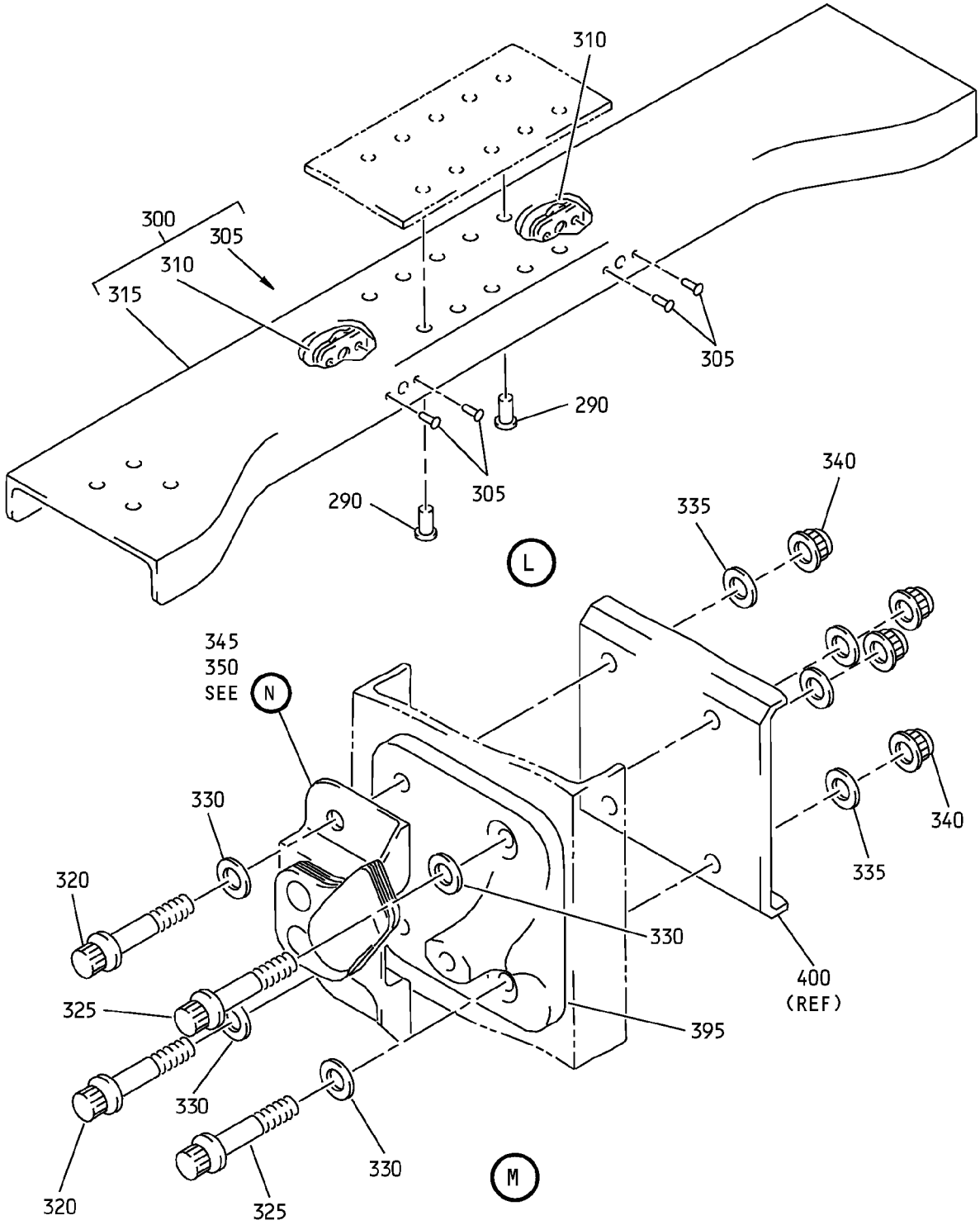


Automatic Overwing Exit Door Assembly
IPL Figure 4 (Sheet 6 of 9)

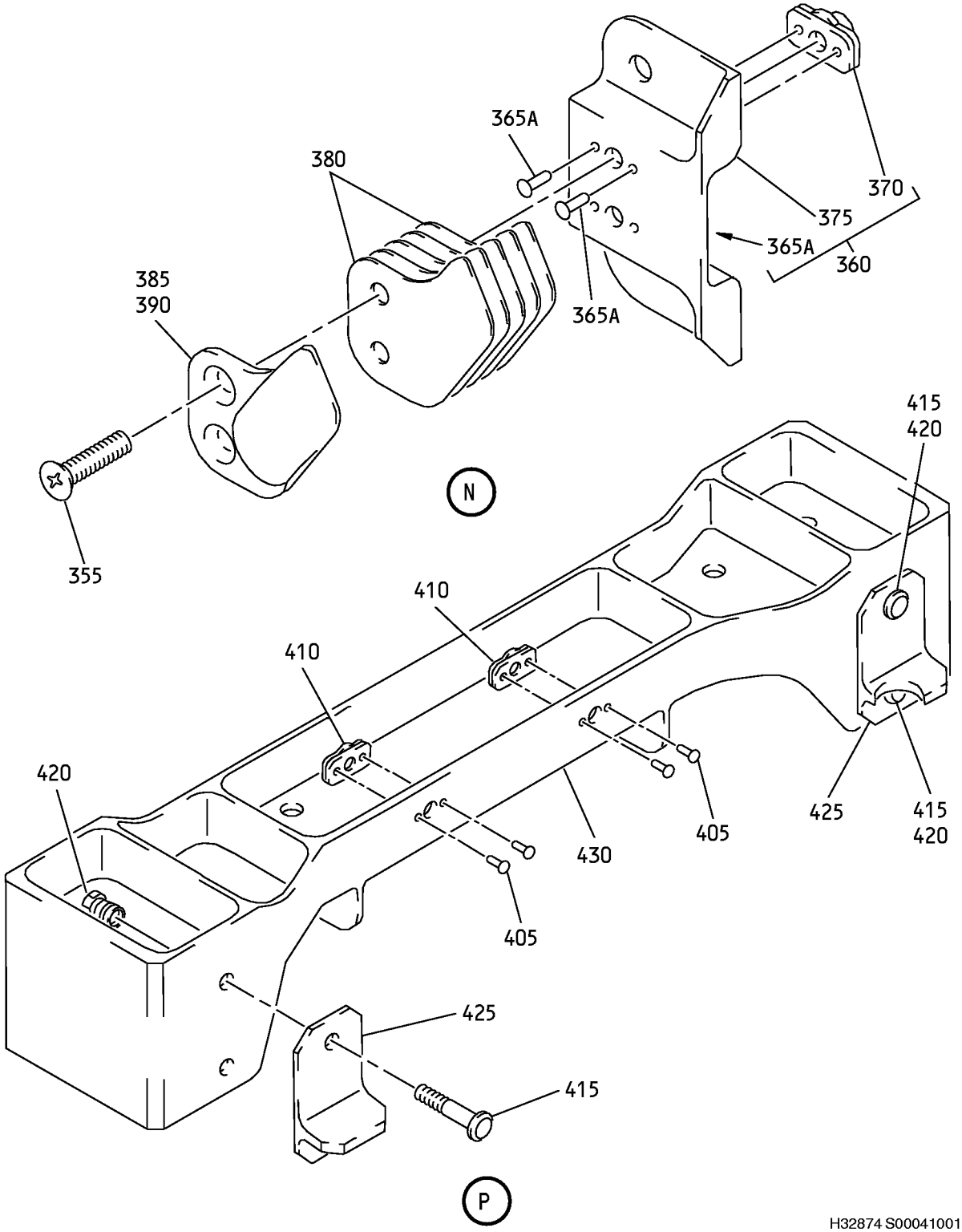


H32800 S00041001033_V2

Automatic Overwing Exit Door Assembly
IPL Figure 4 (Sheet 7 of 9)



Automatic Overwing Exit Door Assembly
IPL Figure 4 (Sheet 8 of 9)



H32874 S00041001035_V2

Automatic Overwing Exit Door Assembly
IPL Figure 4 (Sheet 9 of 9)

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
4–					
–1A	144A6520-1		BEAM AND STOP ASSY	A-D	RF
–1B	144A6520-2		BEAM AND STOP ASSY	E, F	RF
–1C	144A6520-3		BEAM AND STOP ASSY	G	RF
–1D	144A6520-4		BEAM AND STOP ASSY	H-K	RF
5	BACR15BB3D		. RIVET (SIZE DETERMINED ON INST)		4
10	BACR15BB4D		. RIVET (SIZE DETERMINED ON INST)		8
15	F51652-3		. NUTPLATE (V15653) (SPEC BACN10KJ3CD)		2
20	T8059S1032B1		. NUTPLATE (V52828) (SPEC BACN10MK3-45) (OPT T8059S1032B1 (V11815))		4
–25	HST10AG5-4		DELETED		
25A	VL310AG5-4		. BOLT (V06950) (SPEC BACB30VT5HK4) (OPT VL310AG5-4 (V9N513)) (OPT VL310AG5-4 (V97928)) (OPT WC10K5-4 (V60516))		6
30	HST10AG6-3		. BOLT (V0PTK6) (SPEC BACB30VT6K3) (OPT HST10AG6-3 (V06725)) (OPT HST10AG6-3 (V56878)) (OPT HST10AG6-3 (V73197)) (OPT WC10K6-3 (V60516))		8
35	HST79CY5		. COLLAR (V73197) (SPEC BACC30BL5) (OPT HST79-5 (V92215)) (OPT HST79CY5 (V56878)) (OPT HST79CY5 (V5M902))		6

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
4–					
40	HST79CY6		. COLLAR (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V92215)) (OPT HST79CY6 (V56878)) (OPT HST79CY6 (V5M902))		8
45	BACR15FT6D		. RIVET (SIZE DETERMINED ON INST)		10
50	144A6523-2		. BEAM END-UPR		1
55	144A6523-1		. BEAM END-UPR		1
60	144A6521-3		. BEAM ASSY-UPR	A-F	1
–60A	144A6521-5		. BEAM ASSY-UPR	G	1
–60B	144A6521-6		. BEAM ASSY-UPR	H-K	1
–65	BACR15BB3AD		DELETED		
65A	BACR15BB3ADC		. . RIVET (SIZE DETERMINED ON INST)	A-F	4
–65B	BACR15BB3AD5C		. . RIVET	G-K	4
–67	BACR15BA3AD		DELETED		
67A	BACR15BB3AD7C		. . RIVET	G-K	1
–67B	BACR15BA3ADC		. . RIVET (SIZE DETERMINED ON INST)	A-F	1
68	BACR15BB3AD7C		. . RIVET	G-K	1
–70	BACR15BA3AD		DELETED		
70A	BACR15BA3ADC		. . RIVET (SIZE DETERMINED ON INST)	A-F	5
–70B	BACR15BA3AD5C		. . RIVET	G-K	5
72	NAS1149DN332H		. . WASHER	G-K	2
75	WSI4-6		. . NUTPLATE (V04169) (SPEC BACN10TL3-6)		2
80	BRFM20C3D		. . NUTPLATE (V52828) (SPEC BACN10JN3CD) (OPT 102F9201M3 (V72962)) (OPT NS202487-02 (V80539)) (OPT MF51637-3 (V15653)) (OPT MF53050-3CD (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
4–					
85	WSI4-4		. . NUTPLATE (V04169) (SPEC BACN10TL3-4)		1
90	144A6528-1		DELETED		
90A	BACG20ZC000060		. . GROMMET		2
95	144A6528-2		. . STRIP-RUB		1
100	144A6528-3		. . STRIP-RUB	A-F	1
105	144A6528-4		. . STRIP-RUB		1
110	144A6522-3		. . BEAM	A-F	1
–110A	144A6522-5		. . BEAM	G	1
–110B	144A6522-6		. . BEAM	H-K	1
115	LGPL2SPV8-7AC		. BOLT (V17446) (SPEC BACB30VN8K7) (OPT LGPL2SPV8-7AC (V92215)) (OPT 81669V8K7 (V56878)) (OPT LGPL2SPV8-7AC (V56878))		16
120	LGPL2SPV8-5AC		. BOLT (V17446) (SPEC BACB30VN8K5) (OPT LGPL2SPV8-5AC (V92215)) (OPT 81669V8K5 (V56878)) (OPT LGPL2SPV8-5AC (V56878))		4
125	3SLCC8		. COLLAR (V17446) (SPEC BACC30BK8) (OPT 3SLCC8 (V92215))		20
130	BACR15FT6D		. RIVET (SIZE DETERMINED ON INST)		24
135	144A6529-1		. FILLER-RADIUS		1
140	144A6529-2		. FILLER-RADIUS		1
145	144A6525-9		. STOP ASSY-DOOR, UPR		1
150	144A6525-10		. STOP ASSY-DOOR, UPR		1
155	144A6525-5		. STOP ASSY-DOOR, MID		1
160	144A6525-6		. STOP ASSY-DOOR, MID		1
165	144A6527-1		. . PLATE-BRG		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–					
170	144A6525-11		. . FITTING (USED ON ITEM 145)		1
175	144A6525-12		. . FITTING (USED ON ITEM 150)		1
180	144A6525-7		. . FITTING (USED ON ITEM 155)		1
185	144A6525-8		. . FITTING (USED ON ITEM 160)		1
190	BACB30NM3K10		. BOLT		2
195	HST10AG6-4		DELETED		
195A	HST10AG6-5		. BOLT (V0PTK6) (SPEC BACB30VT6K5) (OPT HST10AG6-5 (V06725)) (OPT HST10AG6-5 (V56878)) (OPT HST10AG6-5 (V73197)) (OPT WC10K6-5 (V60516))		11
197	HST10AG6-6		. BOLT (V0PTK6) (SPEC BACB30VT6K6) (OPT HST10AG6-6 (V06725)) (OPT HST10AG6-6 (V56878)) (OPT HST10AG6-6 (V73197)) (OPT WC10K6-6 (V60516))		2
200	BACW10BP3CD		. WASHER		2
205	NAS1149E0332P		. WASHER		4
210	H52732-3CD		. NUT (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))		2
215	HST79CY6		. COLLAR (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V92215)) (OPT HST79CY6 (V56878)) (OPT HST79CY6 (V5M902))		13
220	BACB28AK03-015		. BUSHING		2
225	144A6621-1		. FITTING ASSY-SPRT		1
230	144A6621-2		. FITTING ASSY-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
4–					
235	BCREFA0961		. . BUSHING (V81205) (BACB28AY06A018CG)		2
240	BACB28AT06B015C		. . BUSHING		1
245	BACB28AP04P015		. . BUSHING		1
250	144A6621-3		. . FITTING (USED ON ITEM 225)		1
255	144A6621-4		. . FITTING (USED ON ITEM 230)		1
260	BACF3H06JF040AN		. FILLER		2
265	BACF3H08EA040AN		. FILLER (SELECT FROM)		AR
–265A	BACF3H08˜ BA040AN		. FILLER (SELECT FROM)		AR
–265B	BACF3H08˜ DA040AN		. FILLER (SELECT FROM)		AR
–265C	BACF3H08˜ GA040AN		. FILLER (SELECT FROM)		AR
270	HST10AG6-4		. BOLT (V06725) (SPEC BACB30VT6K4) (OPT HST10AG6-4 (V73197)) (OPT HST10AG6-4 (V56878)) (OPT HST10AG6-4 (V0PTK6))		5
275	HST10AG6-3		. BOLT (V0PTK6) (SPEC BACB30VT6K3) (OPT HST10AG6-3 (V06725)) (OPT HST10AG6-3 (V56878)) (OPT HST10AG6-3 (V73197)) (OPT WC10K6-3 (V60516))		4
–280	BACB30YP6K		DELETED		
280A	WC331K6-4		. BOLT (V60516) (SPEC BACB30YP6K4)		1

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
4–					
285	HST79CY6		. COLLAR (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V92215)) (OPT HST79CY6 (V56878)) (OPT HST79CY6 (V5M902))		10
290	BACR15FT6D		. RIVET (SIZE DETERMINED ON INST)		10
295	144A6523-3		. BEAM END-MID		1
300	144A6521-2		. BEAM ASSY-MID	A-D	1
–300A	144A6521-4		. BEAM ASSY-MID	E-K	1
305	BACR15BA3AD		. . RIVET (SIZE DETERMINED ON INST)		4
310	BRFM20C3D		. . NUTPLATE (V52828) (SPEC BACN10JN3CD) (OPT 102F9201M3 (V72962)) (OPT NS202487-02 (V80539)) (OPT MF51637-3 (V15653)) (OPT MF53050-3CD (V15653))		2
315	144A6522-2		. . BEAM	A-D	1
–315A	144A6522-4		. . BEAM	E-K	1
320	BACB30LE4K12		. BOLT		4
325	BACB30LE4K11		. BOLT		4
330	BACW10BP4CD		. WASHER		8
335	BACW10BP4DP		. WASHER		8
340	NAS1805-4L		. NUT		8
345	144A6595-1		. BLOCK ASSY-CENTERING		1
350	144A6595-2		. BLOCK ASSY-CENTERING		1
355	BACS12ER3K9		. . SCREW		2
360	144A6596-1		. . BRACKET ASSY		1
–365	BACR15BA3AD		DELETED		
365A	BACR15BA3ADC		. . . RIVET (SIZE DETERMINED ON INST)		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–					
370	BRFM20C3D		. . . NUTPLATE (V52828) (SPEC BACN10JN3CD) (OPT 102F9201M3 (V72962)) (OPT NS202487-02 (V80539)) (OPT MF51637-3 (V15653)) (OPT MF53050-3CD (V15653))		2
375	144A6596-2		. . . BRACKET		1
380	144A6598-1		. . SHIM		5
385	144A6597-1		. . BLOCK (USED ON ITEM 345)		1
390	144A6597-2		. . BLOCK (USED ON ITEM 350)		1
395	144A6526-1		. FITTING-STOP, LWR		2
400	144A6521-1		. BEAM ASSY-LWR		1
405	BACR15BA3AD		. . RIVET (SIZE DETERMINED ON INST)		4
410	BRFM20C3D		. . NUTPLATE (V52828) (SPEC BACN10JN3CD) (OPT 102F9201M3 (V72962)) (OPT NS202487-02 (V80539)) (OPT MF51637-3 (V15653)) (OPT MF53050-3CD (V15653))		2
415	HST10AG6-3		. . BOLT (V0PTK6) (SPEC BACB30VT6K3) (OPT HST10AG6-3 (V06725)) (OPT HST10AG6-3 (V56878)) (OPT HST10AG6-3 (V73197)) (OPT WC10K6-3 (V60516))		4
420	HST79CY6		. . COLLAR (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V92215)) (OPT HST79CY6 (V56878)) (OPT HST79CY6 (V5M902))		4
425	144A6588-1		. . CLIP		2
430	144A6522-1		. . BEAM		1
435	144A6524-2		. FRAME-WINDOW		1

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