COMPONENT MAINTENANCE MANUAL WITH ILLUSTRATED PARTS LIST

AFT GALLEY DOOR ASSEMBLY

PART NUMBER 147A6502–1, –10, –11, –12, –13, –14, –15, –16, –17, –18, –19, –2, –20, –21, –22, –23, –24, –25, –26, –3, –4, –8, –9

PUBLISHED BY BOEING COMMERCIAL AIRPLANES GROUP, SEATTLE, WASHINGTON, USA
A DIVISION OF THE BOEING COMPANY
PAGE DATE: Jul 01/2009

BOEING®

COMPONENT MAINTENANCE MANUAL

Revision No. 8
Jul 01/2009

To: All holders of AFT GALLEY DOOR ASSEMBLY 52-41-04.

Attached is the current revision to this COMPONENT MAINTENANCE MANUAL

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

For printed manuals, changes are indicated on the List of Effective Pages (LEP). The pages which are revised will be identified on the LEP by an R (Revised), A (Added), O (Overflow, i.e. changes to the document structure and/or page layout), or D (Deleted). Each page in the LEP is identified by Chapter-Section-Subject number, page number and page date.

Pages replaced or made obsolete by this revision should be removed and destroyed.

ATTENTION

IF YOU RECEIVE PRINTED REVISIONS, PLEASE VERIFY THAT YOU HAVE RECEIVED AND FILED THE PREVIOUS REVISION. BOEING MUST BE NOTIFIED WITHIN 30 DAYS IF YOU HAVE NOT RECEIVED THE PREVIOUS REVISION. REQUESTS FOR REVISIONS OTHER THAN THE PREVIOUS REVISION WILL REQUIRE A COMPLETE MANUAL REPRINT SUBJECT TO REPRINT CHARGES SHOWN IN THE DATA AND SERVICES CATALOG.

Location of Change	Description of Change
52-41-04	
REPAIR 1-1	Changed the data in the Consumable Materials list. Changed consumable from ''lubricant, D50081'' to ''solid film lubricant, D50081''
REPAIR 21-1	Changed the data in the Consumable Materials list. Changed consumable from ''lubricant, D50081'' to ''solid film lubricant, D50081''
ASSEMBLY	Added clarifications and updated callouts.

BOEING®

COMPONENT MAINTENANCE MANUAL

Subject/Page	Date
TITLE PAGE	
O 1	Jul 01/2009
2	BLANK
52-41-04 TRANSMITTAL LETTER	
O 1	Jul 01/2009
2	BLANK
52-41-04 HIGHLIGHTS	
O 1	Jul 01/2009
2	BLANK
52-41-04 EFFECTIVE PAGES	
1 thru 4	Jul 01/2009
52-41-04 CONTENTS	
1	Nov 01/2008
2	BLANK
52-41-04 TR AND SB RECORD	
1	Mar 01/2006
2	BLANK
52-41-04 REVISION RECORD	
1	Mar 01/2006
2	Mar 01/2006
52-41-04 RECORD OF TEMPORARY REVISIONS	
1	Mar 01/2006
2	Mar 01/2006
52-41-04 INTRODUCTION	
1	Mar 01/2009
2	BLANK
52-41-04 DESCRIPTION AND OPERATION	
1	Mar 01/2006
2	Mar 01/2006
52-41-04 TESTING AND FAULT ISOLATION	
101	Mar 01/2006
102	BLANK
52-41-04 DISASSEMBLY	
301	Nov 01/2008
302	Nov 01/2008
303	Mar 01/2009
304	BLANK
52-41-04 CLEANING	
401	Mar 01/2006
402	BLANK
52-41-04 CHECK	
501	Jul 01/2006
502	Jul 01/2006
503	Jul 01/2006
504	Mar 01/2006
52-41-04 REPAIR - GENERAL	
601	Mar 01/2006
602	Mar 01/2006
603	Mar 01/2006
604	BLANK
52-41-04 REPAIR 1-1	
R 601	Jul 01/2009
602	Mar 01/2006
R 603	Jul 01/2009
604	Mar 01/2006
605	Mar 01/2006
606	Mar 01/2006
52-41-04 REPAIR 2-1	
601	Nov 01/2008
602	Mar 01/2006
52-41-04 REPAIR 3-1	
601	Nov 01/2008
602	Mar 01/2006
52-41-04 REPAIR 3-2	
601	Nov 01/2008
602	Mar 01/2006
52-41-04 REPAIR 4-1	
601	Nov 01/2008
602	Mar 01/2006
52-41-04 REPAIR 4-2	
601	Nov 01/2008
602	BLANK
52-41-04 REPAIR 5-1	
601	Nov 01/2008
602	BLANK
52-41-04 REPAIR 5-2	
601	Nov 01/2008
52-41-04 REPAIR 5-2 (cont)	
602	Mar 01/2006
52-41-04 REPAIR 6-1	
601	Nov 01/2008
602	Mar 01/2006
52-41-04 REPAIR 6-2	
601	Nov 01/2008
602	BLANK
52-41-04 REPAIR 7-1	
601	Nov 01/2008
602	Mar 01/2006
52-41-04 REPAIR 7-2	
601	Mar 01/2006
602	BLANK
52-41-04 REPAIR 8-1	
601	Nov 01/2008
602	Mar 01/2006
52-41-04 REPAIR 8-2	
601	Mar 01/2006
602	Mar 01/2006
52-41-04 REPAIR 9-1	
601	Mar 01/2006
602	BLANK
52-41-04 REPAIR 10-1	
601	Nov 01/2008
602	Mar 01/2006
603	Mar 01/2006
604	BLANK
52-41-04 REPAIR 10-2	
601	Nov 01/2008
602	Mar 01/2006
52-41-04 REPAIR 10-3	
601	Nov 01/2008
602	BLANK
52-41-04 REPAIR 10-4	
601	Mar 01/2006
602	BLANK
52-41-04 REPAIR 10-5	
601	Nov 01/2008
602	Mar 01/2006

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

Subject/Page	Date
52-41-04 REPAIR 10-6	
601	Mar 01/2006
602	BLANK
52-41-04 REPAIR 10-7	
601	Nov 01/2008
602	Mar 01/2006
52-41-04 REPAIR 11-1	
601	Nov 01/2008
602	BLANK
52-41-04 REPAIR 11-2	
601	Nov 01/2008
602	BLANK
52-41-04 REPAIR 12-1	
601	Nov 01/2008
602	Mar 01/2006
52-41-04 REPAIR 12-2	
601	Nov 01/2008
602	BLANK
52-41-04 REPAIR 13-1	
601	Nov 01/2008
602	Mar 01/2006
52-41-04 REPAIR 13-2	
601	Nov 01/2008
602	BLANK
52-41-04 REPAIR 14-1	
601	Nov 01/2008
602	Nov 01/2008
52-41-04 REPAIR 14-2	
601	Nov 01/2008
602	Mar 01/2006
52-41-04 REPAIR 14-3	
601	Nov 01/2008
602	BLANK
52-41-04 REPAIR 14-4	
601	Mar 01/2009
602	Mar 01/2006
52-41-04 REPAIR 15-1	
601	Nov 01/2008
602	Mar 01/2006
52-41-04 REPAIR 15-2	
601	Nov 01/2008
602	Mar 01/2006
52-41-04 REPAIR 15-3	
601	Nov 01/2008
602	BLANK
52-41-04 REPAIR 15-4	
601	Nov 01/2008
602	BLANK
52-41-04 REPAIR 16-1	
601	Nov 01/2008
602	BLANK
52-41-04 REPAIR 16-2	
601	Nov 01/2008
602	Mar 01/2006
52-41-04 REPAIR 16-3	
601	Nov 01/2008
602	BLANK
52-41-04 REPAIR 16-4	
601	Nov 01/2008
602	Mar 01/2006
52-41-04 REPAIR 17-1	
601	Nov 01/2008
602	BLANK
52-41-04 REPAIR 17-2	
601	Nov 01/2008
602	Nov 01/2008
52-41-04 REPAIR 18-1	
601	Nov 01/2008
602	Mar 01/2006
52-41-04 REPAIR 18-2	
601	Nov 01/2008
602	BLANK
52-41-04 REPAIR 19-1	
601	Nov 01/2008
602	Mar 01/2006
52-41-04 REPAIR 19-2	
601	Nov 01/2008
602	BLANK
52-41-04 REPAIR 19-3	
601	Nov 01/2008
602	BLANK
52-41-04 REPAIR 20-1	
601	Nov 01/2008
602	Mar 01/2006
603	Mar 01/2006
604	Mar 01/2006
605	Mar 01/2006
606	Mar 01/2006
607	Mar 01/2006
608	BLANK
52-41-04 REPAIR 20-2	
601	Nov 01/2008
602	Mar 01/2006
603	Mar 01/2006
604	Mar 01/2006
52-41-04 REPAIR 21-1	
R 601	Jul 01/2009
602	Mar 01/2006
52-41-04 REPAIR 22-1	
601	Mar 01/2006
602	BLANK
52-41-04 REPAIR 22-2	
601	Nov 01/2008
602	Mar 01/2006
603	Mar 01/2006
604	Mar 01/2006
52-41-04 ASSEMBLY	
701	Nov 01/2008
702	Nov 01/2008
703	Nov 01/2008
704	Nov 01/2008
705	Nov 01/2008
706	Nov 01/2008
707	Nov 01/2008
708	Nov 01/2008
709	Nov 01/2008
710	Mar 01/2009
R 711	Jul 01/2009

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

Subject/Page	Date
52-41-04 ASSEMBLY (cont)	
712	Nov 01/2008
52-41-04 FITS AND CLEARANCES	
801	Mar 01/2006
802	BLANK
52-41-04 SPECIAL TOOLS, FIXTURES, AND EQUIPMENT	
901	Mar 01/2009
902	BLANK
52-41-04 ILLUSTRATED PARTS LIST	
1001	Nov 01/2008
1002	Nov 01/2008
1003	Nov 01/2008
1004	Nov 01/2008
1005	Nov 01/2008
1006	Nov 01/2008
1007	Nov 01/2008
1008	Nov 01/2008
1009	Nov 01/2008
1010	Nov 01/2008
1011	Nov 01/2008
1012	Nov 01/2008
1013	Nov 01/2008
1014	Nov 01/2008
1015	Nov 01/2008
1016	Nov 01/2008
1017	Nov 01/2008
1018	Nov 01/2008
1019	Nov 01/2008
1020	Nov 01/2008
1021	Nov 01/2008
1022	Nov 01/2008
1023	Nov 01/2008
1024	Nov 01/2008
1025	Nov 01/2008
1026	Nov 01/2008
1027	Nov 01/2008
1028	Nov 01/2008
1029	Nov 01/2008
1030	Nov 01/2008
52-41-04 ILLUSTRATED PARTS LIST (cont)	
1031	Nov 01/2008
1032	Nov 01/2008
1033	Nov 01/2008
1034	Nov 01/2008
1035	Nov 01/2008
1036	Nov 01/2008
1037	Nov 01/2008
1038	Nov 01/2008
1039	Nov 01/2008
1040	Nov 01/2008
1041	Nov 01/2008
1042	Nov 01/2008
1043	Nov 01/2008
1044	Nov 01/2008
1045	Nov 01/2008
1046	Nov 01/2008
1047	Nov 01/2008
1048	Nov 01/2008
1049	Nov 01/2008
1050	Nov 01/2008
1051	Nov 01/2008
1052	Nov 01/2008
1053	Nov 01/2008
1054	Nov 01/2008
1055	Nov 01/2008
1056	Nov 01/2008
1057	Nov 01/2008
1058	Nov 01/2008
1059	Nov 01/2008
1060	Nov 01/2008
1061	Nov 01/2008
1062	Nov 01/2008
1063	Nov 01/2008
1064	Nov 01/2008
1065	Nov 01/2008
1066	Nov 01/2008
1067	Nov 01/2008
1068	Nov 01/2008
52-41-04 ILLUSTRATED PARTS LIST (cont)	
1069	Nov 01/2008
1070	Nov 01/2008
1071	Nov 01/2008
1072	Nov 01/2008
1073	Nov 01/2008
1074	Nov 01/2008
1075	Nov 01/2008
1076	Nov 01/2008
1077	Nov 01/2008
1078	Nov 01/2008
1079	Nov 01/2008
1080	Nov 01/2008
1081	Nov 01/2008
1082	Nov 01/2008
1083	Nov 01/2008
1084	Nov 01/2008
1085	Nov 01/2008
1086	Nov 01/2008
1087	Nov 01/2008
1088	Nov 01/2008
1089	Nov 01/2008
1090	Nov 01/2008
1091	Nov 01/2008
1092	Nov 01/2008
1093	Nov 01/2008
1094	Nov 01/2008
1095	Nov 01/2008
1096	Nov 01/2008
1097	Nov 01/2008
1098	Nov 01/2008
1098.1	Nov 01/2008
1098.2	Nov 01/2008
1098.3	Nov 01/2008
1098.4	Nov 01/2008
1098.5	Nov 01/2008
1098.6	Nov 01/2008
1098.7	Nov 01/2008
1098.8	Nov 01/2008

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

Subject/Page	Date
52-41-04 ILLUSTRATED PARTS LIST (cont)	
1098.9	Nov 01/2008
1098.10	Nov 01/2008
1098.11	Nov 01/2008
1098.12	Nov 01/2008
1098.13	Nov 01/2008
1098.14	Nov 01/2008
1098.15	Nov 01/2008
1098.16	Nov 01/2008
1098.17	Nov 01/2008
1098.18	Nov 01/2008
1098.19	Nov 01/2008
1098.20	Nov 01/2008
1098.21	Nov 01/2008
1098.22	Nov 01/2008
1098.23	Nov 01/2008
1098.24	Nov 01/2008
1098.25	Nov 01/2008
1098.26	Nov 01/2008
1098.27	Nov 01/2008
1098.28	Nov 01/2008
1098.29	Nov 01/2008
1098.30	Nov 01/2008
1098.31	Nov 01/2008
1098.32	Nov 01/2008
1098.33	Nov 01/2008
1098.34	Nov 01/2008
1098.35	Nov 01/2008
1098.36	Nov 01/2008
1098.37	Nov 01/2008
1098.38	Nov 01/2008
1098.39	Nov 01/2008
1098.40	Nov 01/2008
1098.41	Nov 01/2008
1098.42	Nov 01/2008
1098.43	Nov 01/2008
1098.44	Nov 01/2008
1098.45	Nov 01/2008
1098.46	Nov 01/2008
52-41-04 ILLUSTRATED PARTS LIST (cont)	
1098.47	Nov 01/2008
1098.48	Nov 01/2008
1098.49	Nov 01/2008
1098.50	Nov 01/2008
1098.51	Nov 01/2008
1098.52	Nov 01/2008
1098.53	Nov 01/2008
1098.54	Nov 01/2008
1098.55	Nov 01/2008
1098.56	Nov 01/2008
1098.57	Nov 01/2008
1098.58	Nov 01/2008
1098.59	Nov 01/2008
1098.60	Mar 01/2009
1098.61	Nov 01/2008
1098.62	BLANK

Subject/Page	Date

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

TABLE OF CONTENTS

Paragraph Title		Page
AFT GALLEY DOOR ASSEMBLY - DESCRIPTION AND OPERATION		1
TESTING AND FAULT ISOLATION	(Not Applicable)	
DISASSEMBLY		301
CLEANING		401
CHECK		501
REPAIR		601
ASSEMBLY		701
FITS AND CLEARANCES		801
SPECIAL TOOLS, FIXTURES, AND EQUIPMENT		901
ILLUSTRATED PARTS LIST		1001

BOEING®

COMPONENT MAINTENANCE MANUAL

TEMPORARY REVISION AND SERVICE BULLETIN RECORD

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

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

Revision		Filed	
Number	**Date**	**Date**	**Initials**

Revision		Filed	
Number	**Date**	**Date**	**Initials**

Revision		Filed		Revision		Filed	
Number	Date	Date	Initials	Number	Date	Date	Initials

BOEING®

COMPONENT MAINTENANCE MANUAL

All temporary revisions to this manual will be accompanied by a cover sheet bearing the temporary revision number. Enter the temporary revision number in numerical order, together with the temporary revision date, the date the temporary revision is inserted and the initials of the person filing.
When the temporary revision is incorporated or cancelled, and the pages are removed, enter the date the pages are removed and the initials of the person who removed the temporary revision.

Temporary Revision		Inserted		Removed	
Number	Date	Date	Initials	Date	Initials

Temporary Revision		Inserted		Removed	
Date	Initials	Number	Date	Date	Initials

Temporary Revision		Inserted		Removed	
Number	Date	Date	Initials	Date	Initials

Temporary Revision		Inserted		Removed	
Date	Initials	Number	Date	Date	Initials

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.

AFT GALLEY DOOR ASSEMBLY - DESCRIPTION AND OPERATION

1. Description

A. The aft galley door assembly (DESCRIPTION AND OPERATION, Figure 1) is installed on the right side of the fuselage, opposite the aft entry door. Upper and lower hinge assemblies connect the aft galley door to the fuselage at the forward edge of the door opening. The aft galley door is a plug-type door and has three primary parts: the center door assembly, upper gate and lower gate. The center door assembly has a window.

2. Operation

A. You can open and close the door from the interior or exterior of the airplane.

B. The door is manually opened. Do the steps that follow to open the door:

(1) Unlatch the door with a central control handle. When you turn the central control handle in the OPEN direction, internal mechanisms do these functions:

(a) Disengage the door roller latches from the latch fittings on the door frame.

(b) Fold the door gates inward.

(c) Tilt the door hinge edge inward to the cocked position.

(2) Then move the door to the fully open position with the offset assist handles. A lock mechanism in the upper hinge locks the door in the fully open position.

C. To close the door, first release the hinge lock and then do the open operation in the opposite sequence. A guide pin on the door and a guide pin track on the door frame center the door in the door frame as it closes.

D. The hinges hold the door when the airplane is not pressurized. When the airplane is pressurized, cabin pressure pushes the door outboard. This causes these to occur:

(1) The door seals compress.

(2) The door stop pins touch the frame stop fittings. This transmits the door pressure loads to the door frame structure.

(3) The door latches are unloaded.

E. The door structure has internal paths to drain moisture. The door sections drain into the door frame threshold. The door threshold drains overboard through bladders in the lower fuselage.

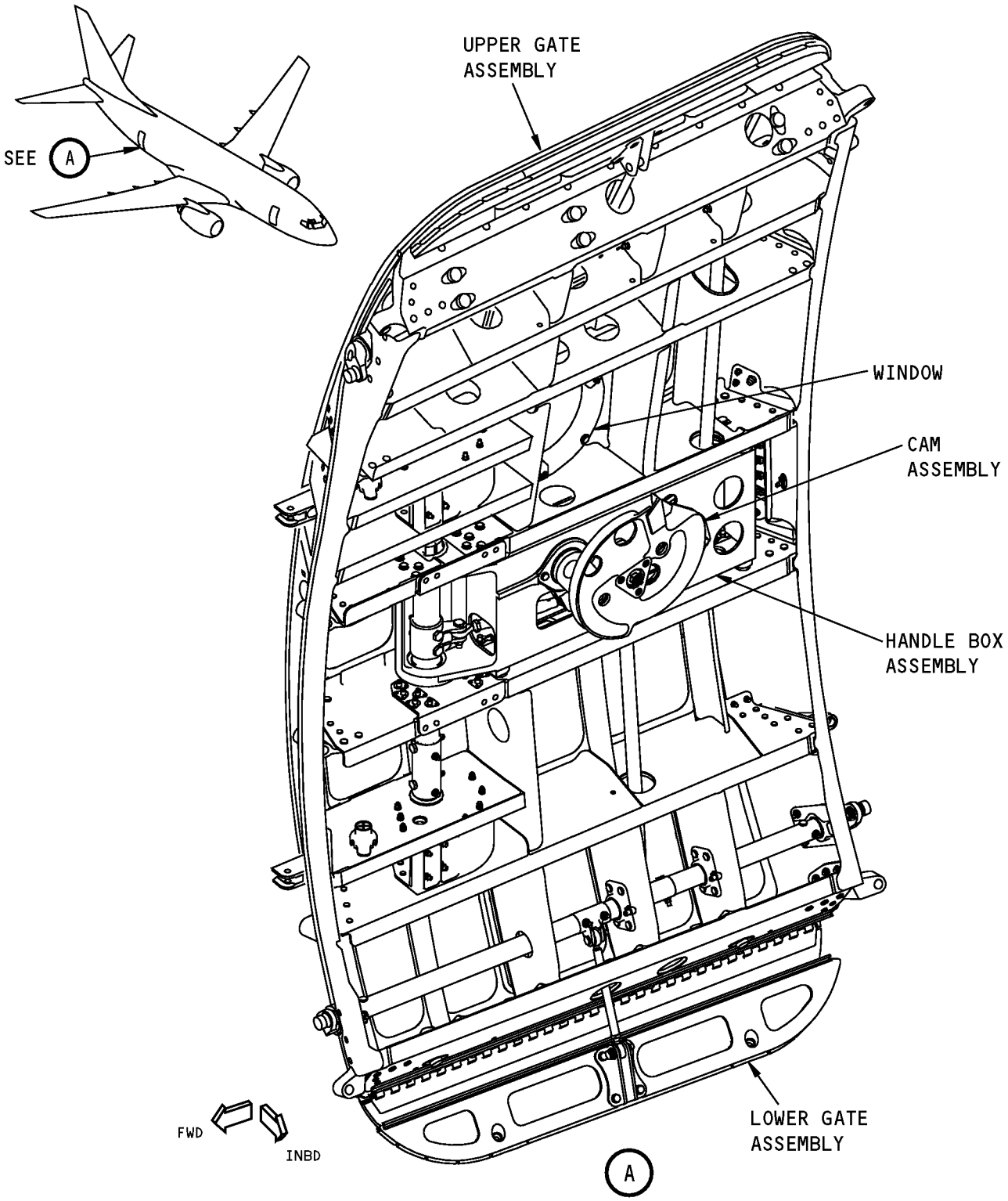
3. Leading Particulars (Approximate)

A. Height – 66 inches

B. Width – 34 inches

C. Thickness – 11 inches

D. Weight – 112 pounds



Aft Galley Door Assembly
Figure 1

(NOT APPLICABLE)

DISASSEMBLY

1. General

A. This procedure has the data necessary to disassemble the aft galley 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 7 for the item numbers.

2. Disassembly

A. Tools/Equipment

NOTE: Equivalent substitutes may be used.

Reference	Description
SPL-10293	Wrench - Door Handle Mechanism Unit (Part #: F70038, Supplier: 81205)
SPL-10295	SPANNER WRENCH - BEARING RETAINER NUT (Part #: F70085, Supplier: 81205)

B. Procedure

(1) Use standard industry procedures and the steps that follow to disassemble this component.

(2) Do not remove components from the aft galley door assembly that are riveted or bonded unless replacement is necessary.

(a) Remove the cover plates (204, 208, 212, IPL Figure 1), the retainer (248), and the stops (100, 104) from the door structure, as follows:

1) Remove the bolts (180), washers (184), and the cover plates (204) from the door structure.

2) Remove the bolts (182), washers (184), and the cover plate (208) from the door structure.

3) Remove the bolts (182), washers (184), and the cover plate (212) from the door structure.

4) Remove the studs (240), washer (244), and the retainer (248) from the door structure.

5) Remove the bolts (84), rings (88), nuts (92) and the stops (100, 104) from the door structure.

(3) Disconnect the upper and lower end gate assemblies (464, 468, IPL Figure 1) from the upper and lower control rod assemblies (420, 424, IPL Figure 1), as follows:

(a) Remove the bolt (388), washers (396, 400), bushing (416) and nut (408) to disconnect the upper control rod assembly (420) from the upper end gate assembly (464).

(b) Remove the bolt (388), washers (396, 400), bushing (416) and nut (408) to disconnect the lower control rod assembly (424) from the lower end gate assembly (468).

(4) Remove the upper and lower end gate assemblies (464, 468, IPL Figure 1) from the door structure, as follows:

(a) Remove the bolts (472, 476), washers (480) and the upper end gate assembly (464) from the door structure.

(b) Remove the bolts (472, 476), washers (480) and the lower end gate assembly (468) from the door structure.

(5) Remove the upper and lower control rod assemblies (420, 424, 532, 536, IPL Figure 1) from the door structure, as follows:

(a) Remove the bolt (392), washer (404), nut (412) and the upper control rod assembly (420) from the door structure.

(b) Remove the bolts (512, 516), washers (520, 524), nut (528) and the upper control rod assembly (532) from the door structure.

(c) Remove the bolt (392), washer (404), nut (412) and the lower control rod assembly (424) from the door structure.

(d) Remove the bolts (512, 516), washers (520, 524), nut (528) and the lower control rod assembly (536) from the door structure.

(6) Remove the upper and lower latch tube assemblies (125, 130, IPL Figure 2) from the door structure, as follows:

(a) Remove the bolts (150), washers (155), nuts (160), roller cam cranks (165), and the roller latch spacers (5) from the upper and lower tubes (200, 205).

(b) Remove the bolts (170), washers (175), nuts (180). Move the upper and lower tubes out of the door structure. Remove the latch cranks (190, 195) and the gate cranks (185) from the door structure.

(7) Remove the torque tube assembly (IPL Figure 6) from the door structure, as follows:

(a) Remove the bolt (576, IPL Figure 1), washer (580, IPL Figure 1), and nut (584, IPL Figure 1) to disconnect the rod assembly (180, IPL Figure 7) from the crank (90, IPL Figure 6).

(b) Remove the bolts (75), washers (80), and the nuts (85) from the crank (90).

(c) Remove the bolts (5) and the washers (10) from the hinge arm assemblies (15, 20).

(d) Remove the bolts (40), washers (45), and the nuts (50), from the torque tube coupling sleeves (55, 60).

(e) Loosen the special nuts (70) attached to the torque tube assembly with SPANNER WRENCH, SPL-10295.

(f) Remove the torque tube coupling sleeves (55, 60), special nuts (70), crank (90), and the tube (95) from the door structure.

(g) Remove the hinge link pins (65), the packing (564, IPL Figure 1), washer (568, IPL Figure 1), and the compression springs (572, IPL Figure 1) from the door structure.

(8) Remove the hinge support assemblies (628, 632, IPL Figure 1) from the door structure, as follows:

(a) Remove the bolts (620) and nuts (624) from the hinge support assemblies.

(b) Remove the hinge support assemblies (628, 632, IPL Figure 1), and the hinge arm assemblies (15, 20, IPL Figure 6) from the door structure.

(9) Remove the handle box assembly (612, IPL Figure 1) from the door structure, as follows:

(a) Remove the cotter pin (592).

(b) Remove the nut (40, IPL Figure 7), washers (45, 50, IPL Figure 7), control cam assembly (60, IPL Figure 7), and the exterior handle (20, IPL Figure 7) from the housing (410, IPL Figure 7).

(c) Remove the bolts (600), washers (604), fillers (608), shims (616), and the handle box assembly (612) from the door structure.

(d) If necessary, disassemble the handle box assembly (612, IPL Figure 1; 1A, IPL Figure 7), as follows:

1) Remove the bolts (90, IPL Figure 7), washers (95), packing (97), ring (120), washer (55), and the bearing (125) to remove the handle mechanism housing assembly (100) from the housing (410).

2) Remove the bolts (5), washers (10), nuts (15), spacers (25), handle sleeve (30), centering cam (35), and the shaft assembly (130) from the exterior handle (20).

3) If necessary, disassemble the shaft assembly (130) as follows:

a) Remove the spring pin (135), ring (145), washer (140), nut (150) with door handle mechanism wrench, SPL-10293, spring (155), and pin (160), from the shaft (165).

4) Remove the bolt (170) and washer (175) to remove the rod assembly (180) from the cocking crank assembly (275).

5) Remove the bolt (245), washers (255, 250) and nut (265) to remove the cam follower crank assembly (320) from the housing (410).

6) Remove the bearing (270), washer (260) and the cocking crank assembly (275) from the housing (410).

7) Remove the bolt (245), washers (255, 250), nut (265) to remove the cam follower crank assembly (325) from the housing (410).

8) Remove the bearing (270), washer (260) and the latching crank assembly (300) from the housing (410).

9) Remove the bolts (205, 210, 215, 220), washers (225), nuts (230), bearing retainers (235), bearings (240), and the spacer ring (295) from the housing (410).

10) If necessary, disassemble the cam follower crank assembly (320, 325) as follows:

a) Remove the cotter pins (330), nuts (335), washers (340), and bearings (345) from the crank arms (350, 355).

b) Make a record of the number of washers (340). This data can be used during assembly.

(10) Remove the window assembly (356, 358 IPL Figure 1) from the door structure as follows:

(a) Remove the bolts (340), washers (344), and the window assembly (356, 358) from the door structure.

(11) Remove the centering guide assembly (235, IPL Figure 2) and centering guide channel assembly (290) from the door structure as follows:

(a) Remove the bolts (210), washers (220) and the centering guide assembly (235) from the door structure.

(b) Remove the bolts (215), filler (265), serrated plate (260), and the centering guide channel assembly (290) from the door structure.

CLEANING

1. General

A. This procedure has the data necessary to clean the aft galley 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 7 for the item numbers.

2. Cleaning

A. References

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

B. Procedure

(1) Clean the bearings (432, 440, 548, 552, IPL Figure 1; 10, 115, 145, 250, IPL Figure 2; 125, 195, 240, 270, 345, 360, IPL Figure 7) as specified in SOPM 20-30-01.

(2) Use standard industry procedures and refer to SOPM 20-30-03 to clean all other parts.

CHECK

1. General

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

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

C. Refer to IPL Figure 1 thru IPL Figure 7 for the item numbers.

2. Check

A. References

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

B. Procedure

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

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

1) IPL Figure 1

a) Rod (444, 448) (Class C)

2) IPL Figure 2

a) Gate crank (185) (Class B)

b) Latch crank (190, 195) (Class B)

c) Tube (200, 205) (Class B)

d) Bushing (615, 690, 830, 885, 955) (Class B after plating)

3) IPL Figure 6

a) Hinge link pin (65) (Class A)

b) Torque tube coupling sleeve (55, 60) (Class B)

c) Crank (90) (Class B)

d) Torque tube (95) (Class B)

4) IPL Figure 7

a) Housing fitting (110) (Class C)

b) Compression Spring (155)

c) Shaft (165) (Class B)

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

1) IPL Figure 1

a) Spacer (52A, 144A)

b) Retainer (248)

c) Hinge half (500, 504, 508)

d) Rod (556, 560)

e) Attach Fitting (672, 676)

f) Support (692, 696)

g) Stub Beam (760, 764, 780)

2) IPL Figure 2

a) Fitting (60, 65, 70, 75)

b) Roller Cam Crank (165) (penetrant check machined areas only)

c) Fitting (255)

d) Channel (305)

e) Seal Plate (405)

f) Stop Fitting (620, 625, 695, 700, 835, 840, 845, 890, 895, 960, 965)

g) Beam (630, 635, 705, 850, 855, 900, 970)

3) IPL Figure 4

a) Gate (70)

4) IPL Figure 5

a) Gate (90)

5) IPL Figure 6

a) Hinge arm (30, 35)

6) IPL Figure 7

a) Handle (20)

b) Sleeve (30)

c) Hogout camplate (85A)

d) Washer (140)

e) Nut (150)

f) Pin (160)

g) Bearing Retainer (235)

h) Crank arm (290, 350, 355)

i) Crank (315)

j) Housing (410)

(2) Use standard industry procedures to do a visual check of the springs. Do the load checks that follow if the visual check shows possible damage or if you suspect possible damage.

(a) Do a load check on spring (572, IPL Figure 1) as follows:

1) Compress spring (572) to 0.20 inch length as shown in CHECK, Figure 501.

a) Make sure that the maximum load on spring (572) is 0.22 - 0.24 pound.

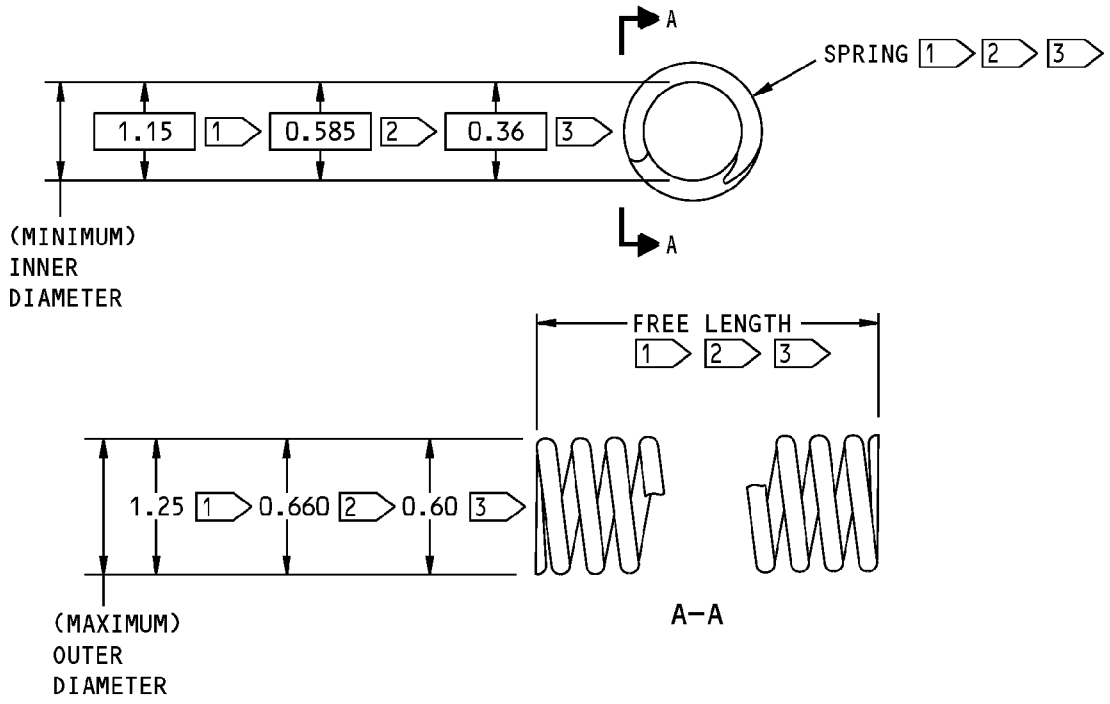
2) Compress spring (572) to 0.25 inch length as shown in CHECK, Figure 501.

a) Make sure that the minimum load on spring (572) is 0.19 - 0.21 pound.

(b) Do a load check on spring (712, IPL Figure 1) as follows:

1) Compress spring (712) to 0.22 inch length as shown in CHECK, Figure 501.
   a) Make sure that the maximum load on spring (712) is 0.39 - 0.49 pound.
2) Compress spring (712) to 0.44 inch length as shown in CHECK, Figure 501.
   a) Make sure that the minimum load on spring (712) is 0.06 - 0.14 pound.

(c) Do a load check on spring (155, IPL Figure 7) as follows:
1) Compress spring (155) to 2.05 inches length as shown in CHECK, Figure 501.
   a) Make sure that the maximum load on spring (155) is 5.8 - 7.0 pounds.
2) Compress spring (155) to 3.34 inches length as shown in CHECK, Figure 501.
   a) Make sure that the minimum load on spring (155) is 3.0 - 3.8 pounds.



SPRING ITEM NUMBER	FREE LENGTH OF SPRING (INCHES)	TEST LENGTH (INCHES)	PERMITTED LOAD LIMIT (POUNDS)
IPL FIG. 1; 572	0.88	0.20 0.25	0.22–0.24 (MAXIMUM) 0.19–0.21 (MINIMUM)
IPL FIG. 1; 712	0.54	0.22 0.44	0.39–0.49 (MAXIMUM) 0.06–0.14 (MINIMUM)
IPL FIG. 7; 155	5.01	2.05 3.34	5.8–7.0 (MAXIMUM) 3.0–3.8 (MINIMUM)

1 FOR 66-15645-1
(IPL FIG. 1; 572)

2 FOR 140N2020-1
(IPL FIG. 1; 712)

3 FOR 63-2848
(IPL FIG. 7; 155)

ALL DIMENSIONS ARE IN INCHES

63-2848; 66-15645-1; 140N2020-1 Spring Check
Figure 501

REPAIR

1. General

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

Table 601:

P/N	NAME	REPAIR
—	REFINISH OF OTHER PARTS	1-1
65-1933	COCKING CRANK ASSEMBLY	2-1
65-2306	HOUSING ASSEMBLY	3-1, 3-2
65-28925	CONTROL ROD ASSEMBLY	4-1, 4-2
65-44065	CAM ASSEMBLY	5-1, 5-2
69-18187	CONTROL ROD ASSEMBLY	6-1
66-14618	ROD	6-2
69-39176	ROD ASSEMBLY	7-1, 7-2
90-7815	CAM FOLLOWER CRANK ASSEMBLY	8-1, 8-2
140N2022	DRAIN VALVE ASSEMBLY	9-1
147A6503	TORQUE TUBE ASSEMBLY	10-1
147A6118	TORQUE TUBE	10-2
147A6119	TORQUE TUBE COUPLING	10-3
149A6110	SLEEVE	
69-17330	CRANK	10-4
66-14527	HINGE LINK PIN	10-5
65-73978	HINGE ARM ASSEMBLY	10-6, 10-7
141A6140	HINGE SUPPORT ASSEMBLY	11-1
69-70268 147A6162	ATTACH FITTING	11-2
147A6140	SUPPORT ASSEMBLY	12-1, 12-2
147A6128	STOP ASSEMBLY	13-1, 13-2
147A6514	(UPPER) END GATE ASSEMBLY	14-1
147A6144	(UPPER) CONTROL ROD CLEVIS ASSEMBLY	14-2, 14-3
147A6516	(UPPER) GATE	14-4
147A6146	(LOWER) END GATE ASSEMBLY	15-1, 15-4
147A6144	(LOWER) CONTROL ROD CLEVIS ASSEMBLY	15-2, 15-3
147A6139	LOWER AND UPPER TUBE ASSEMBLY	16-1
69-37418	ROLLER CAM CRANK	16-2
66-14531	GATE CRANK	16-3

P/N	NAME	REPAIR
60-4406	LATCH TORQUE TUBE	16-4
147A6138	LATCH SUPPORT FITTING ASSEMBLY	17-1, 17-2
147A6130	CENTERING GUIDE ASSEMBLY	18-1, 18-2
147A6137 149A6121	HANDLE RECESS PAN ASSEMBLY SEAL PLATE	19-1, 19-2 19-3
149A6107	HOUSING ASSEMBLY	20-1, 20-2
60-4455	SHAFT	21-1
149A6120	HANDLE MECHANISM HOUSING ASSEMBLY	22-1, 22-2

2. Dimensioning Symbols

A. Standard True Positioning 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 that are not given in the specified repairs.

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

C. Refer to IPL Figure 1 thru IPL Figure 7 for the item numbers.

2. Refinish of Other Parts

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
C00033	Coating - Exterior Protective Enamel, Flexibility Use	BMS10-60, Type II
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I
C50069	Coating - Enamel, Color 702 Gloss White	BMS10-11, Type II
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 20-60-02	FINISHING MATERIALS

C. Procedure

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

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

Table 601: Refinish Details

IPL FIG. & ITEM	MATERIAL	FINISH
IPL Fig. 1		
Bracket (32,72, 108,164)	Al Alloy	Chemical treat (F-17.07). Apply primer, C00259 (F-20.02).
Spacer (52A,144A)	Al Alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02). Apply enamel coating, C50069 (F-21.03) but do not put primer and enamel in the center hole.
Backplate (76,168)	Al Alloy	Chemical treat (F-17.07). Apply primer, C00259 (F-20.02).

Table 601: Refinish Details (Continued)

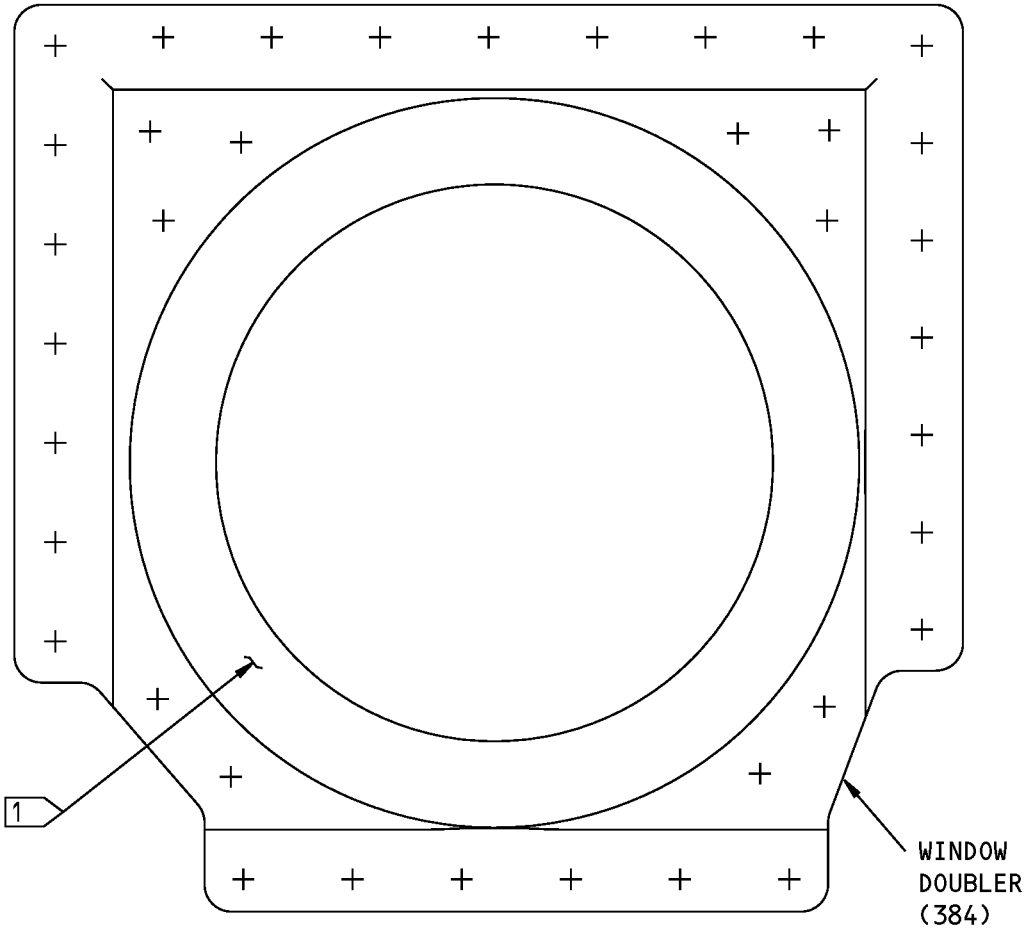
IPL FIG. & ITEM	MATERIAL	FINISH
Stop (100,104)	Nylon	No finish (F-25.01)
Plate-Cover (204, 208,212)	Al Alloy	Chemical treat (F-17.07). Apply primer, C00259 (F-20.03).
Retainer (248), Skin (300,328)	Al Alloy	Chemical treat (F-17.07). Apply primer, C00259 (F-20.03).
Window Doubler (384)	Al Alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.35). Apply primer, C00259 (F-20.03) but not to the surface shown by flagnote 1 in REPAIR 1-1, Figure 601; no overspray is permitted.
Nylon Rod (452)	Nylon	No finish (F-6.10)
Hinge Half (500, 504,508)	Al Alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.35). Apply primer, C00259 (F-20.03) but do not apply primer to the holes for the hinge pin or spring pin.
Compression Spring (572)	Spring Steel Music Wire	Cadmium-titanium plate (F-1.20).
Support (692,696)	Al Alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.35). Apply primer, C00259 (F-20.03) but do not put primer in the holes for the bushings.
Spring (712)	Stainless Type 302 Wire	Passivate (F-17.25)
Beam-Stub (760, 764,780)	Al Alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.03).
IPL Fig. 2		
Spacer (5)	301 CRES	Passivate (F-17.25)
Shim (80,85)	Al Alloy	No finish (F-25.01)
Crank-gate (185)	15-5PH CRES 150-170 ksi	Passivate (F-17.09)
Crank-latch (190, 195)	15-5PH CRES 150-170 ksi	Passivate (F-17.09)
Tube (200,205)	15-5PH CRES 150-170 ksi	Cadmium plate (F-15.06). Apply primer, C00259 (F-20.48) to the inner diameter.
Fitting (255)	Al Alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.35). Apply primer, C00259 (F-20.03) but do not put primer on serrations.
Serrated Plate (260)	Al Alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.03) but do not put primer on serrations.

Table 601: Refinish Details (Continued)

IPL FIG. & ITEM	MATERIAL	FINISH
Channel (305)	Al Alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.03).
Seal Retainer (335, 340,345,350,355, 360)	Al Alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.03).
Bushing (615,690, 830,885,955)	15-5PH CRES 150-170 ksi	Cadmium plate (F-15.06). Cadmium plate on the inner diameter is optional.
Beam (630,635,705, 850,855,900,970)	Al Alloy	Boric acid-sulfuric acid anodize or chromic anodize (F-17.31). Apply primer, C00259 (F-20.03).
Splice (740)	Al Alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.03).
Filler (750,755)	Al Alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.03).
IPL Fig. 3		
Clip (20)	301 CRES	Cadmium plate (F-15.06). Apply primer, C00259 (F-20.02). Apply enamel coating, C50069 (F-21.28-702).
Retainer (55)	Al Alloy	Chemical treat (F-17.07). Apply primer, C00259 (F-20.03). Apply coating, C00033 (F-19.39-702) to the surface identified by flagnote 1 in REPAIR 1-1, Figure 602 (overspray is permitt- ed).
IPL Fig. 4		
Retainer (50,55,60, 65)	Al Alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.03).
IPL Fig. 5		
Retainer (60,65,70, 75)	Al Alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.03).
Bushing (85)	15-5PH CRES 125-145 ksi	Cadmium plate (F-15.06). Cadmium plate on inner diameter is optional.
IPL Fig. 6		
Special Nut (70)	Al Alloy	Chromic acid anodize (F-17.04)
IPL Fig. 7		
Handle (20)	Al Alloy	Sulfuric acid anodize (F-14.2998) exterior surfaces only.
Spacer (25)	Al Alloy	Chemical treat or anodize and apply primer, C00259 (F-2.115).
Sleeve (30)	Al Alloy	Apply solid film lubricant, D50081 (F-19.10).
Centering Cam (35)	Al Alloy	Cadmium plate (F-4.201).
Washer (50)	301 CRES 180-200 ksi	Cadmium plate (F-15.06)

Table 601: Refinish Details (Continued)

IPL FIG. & ITEM	MATERIAL	FINISH
Guide (70)	Al Alloy	Chemical treat or chromic acid anodize and apply primer, C00259 (SRF-2.30).
Washer (140)	Al-Ni-Bronze AMS 4640	Cadmium plate (F-1.202).
Nut (150)	Al Alloy	Anodize (F-2.20)
Compression Spring (155)	Music Wire MIL-W-6101	Cadmium plate (F-1.32)
Pin (160)	303 CRES	No finish (F-8.05).
Bearing Retainer (235)	Al Alloy	Chemical treat or chromic acid anodize (F-17.01). Apply primer, C00259 (F-20.02).
Washer (255)	301 CRES 1/2 Hard Sheet (AMS 5518)	Cadmium plate (F-15.06). Apply primer, C00259 (F-20.02).
Spacer Ring (295)	Al Alloy	Chemical treat (F-17.07). Apply primer, C00259 (F-20.03).
Crank (315)	Al Alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02) but no primer on the splined surfaces or the 0.250-0.254-inch diameter holes.
Filler (385,390)	Al Alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.03).
Bushing (395A)	Al-Ni-Bronze AMS 4640	Cadmium plate (F-15.02). Cadmium plate in the bore is optional.

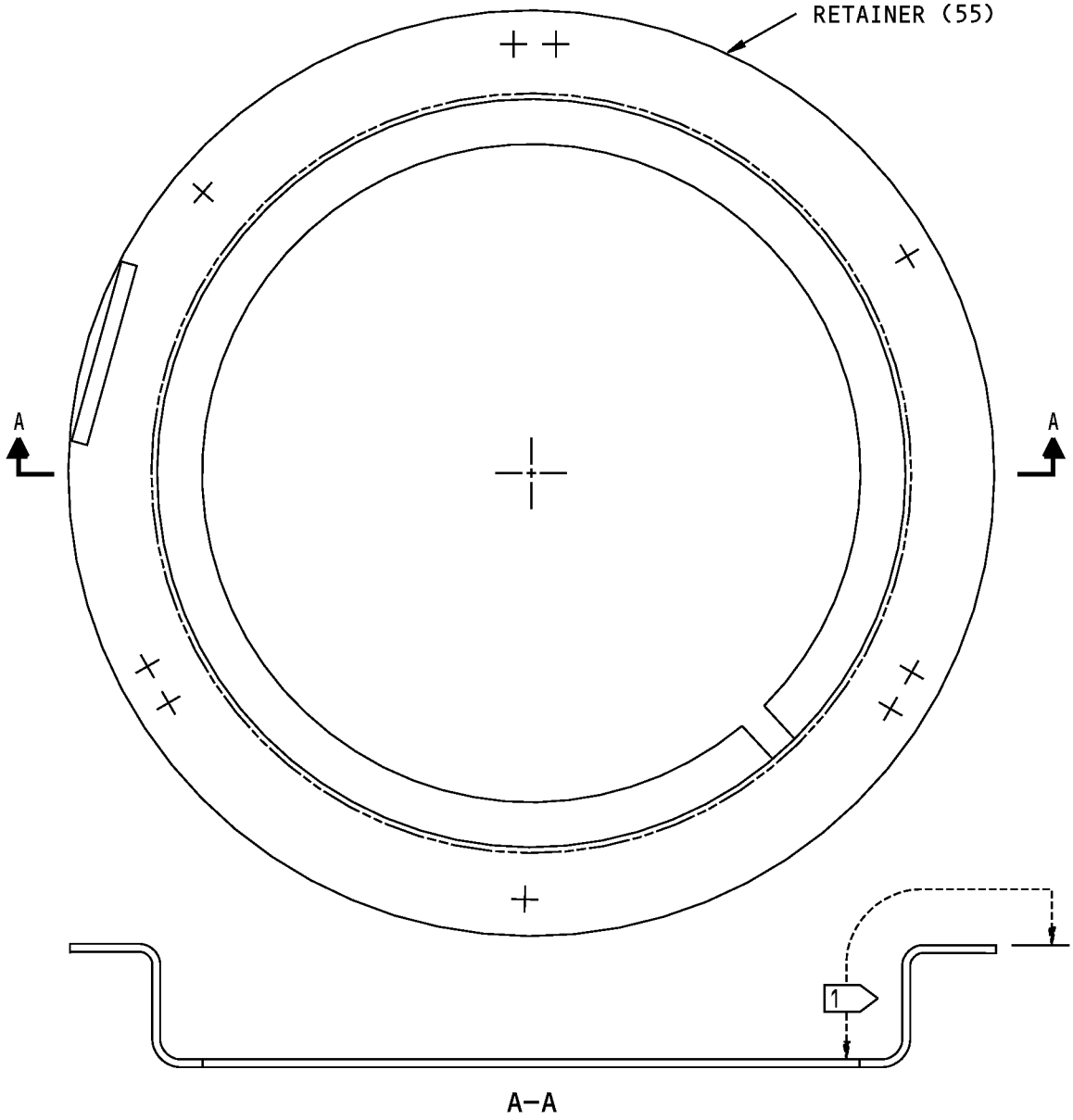


REFINISH

1 NO PRIMER IN THIS AREA. NO OVERSPRAY IS PERMITTED

ITEM NUMBERS REFER TO IPL FIG. 1

149A6112-2 Window Doubler
Figure 601



REFINISH

1 APPLY ENAMEL TO THIS AREA.
OVERSPRAY IS PERMITTED

ITEM NUMBERS REFER TO IPL FIG. 3

69-1983-7 Retainer Repair
Figure 602

COCKING CRANK ASSEMBLY - REPAIR 2-1

65-1933–23

1. General

A. This procedure has the data necessary to repair the cocking crank assembly (275).

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

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

D. Refer to IPL Figure 7 for the item numbers.

E. General repair details:

(1) Material: Aluminum Alloy

2. Nutplate (285) Replacement (REPAIR 2-1, Figure 601)

A. Procedure

(1) Remove the nutplate (285)

(2) Install the nutplate (285) with rivets (280)

3. Crank Arm (290) Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

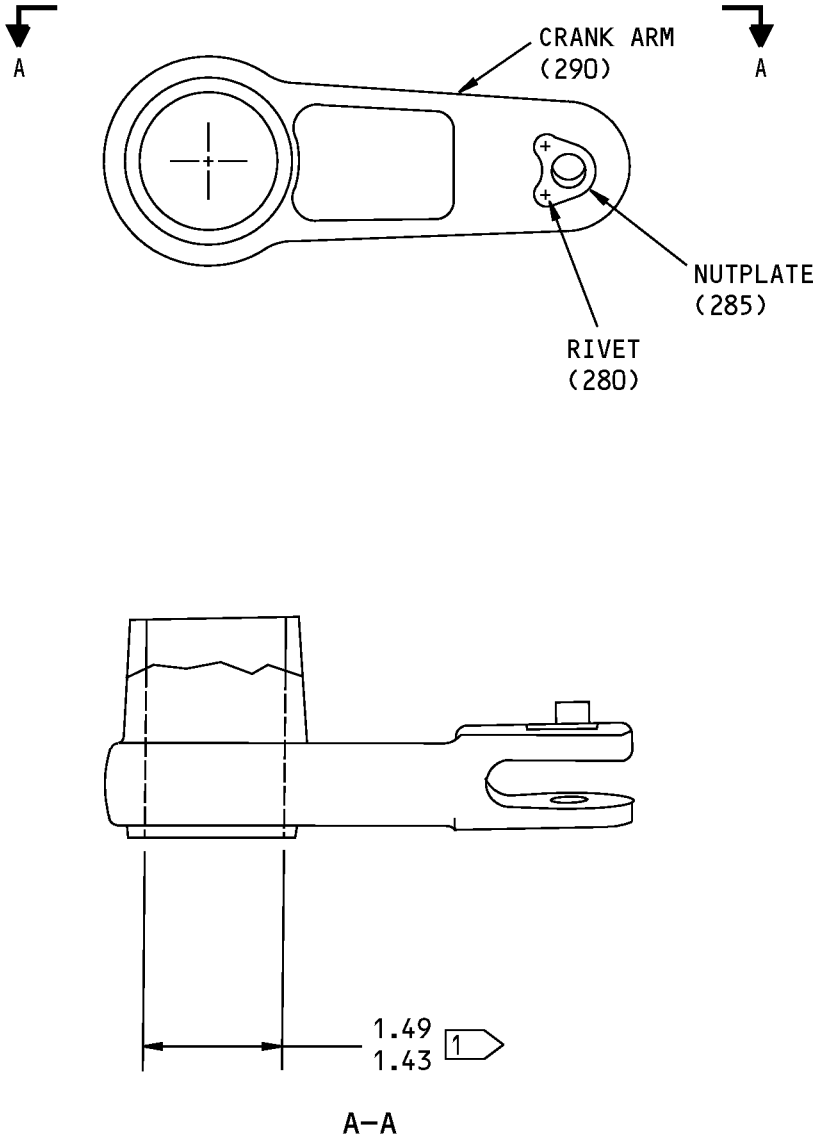
Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

C. Procedure

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

(1) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.35).

(2) Apply primer, C00259 (F-20.03), but not on the splined surface shown by flagnote 1 in REPAIR 2-1, Figure 601.



1 APPLY PRIMER TO ALL SURFACES BUT NOT ON THE SPLINED SURFACE SHOWN BY FLAG NOTE 1

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 7

ALL DIMENSIONS ARE IN INCHES

65-1933-23 Cocking Crank Assembly - Repair
Figure 601

HOUSING ASSEMBLY - REPAIR 3-1

65-2306–9

1. General

A. This procedure has the data necessary to repair the housing assembly (105).

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

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

D. Refer to IPL Figure 2 for the item numbers.

2. Fitting Replacement

A. Procedure

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

(2) Install the replacement fitting (110) in the housing (120) as shown in REPAIR 3-1, Figure 601.

3. Bearing Replacement (REPAIR 3-1, Figure 601)

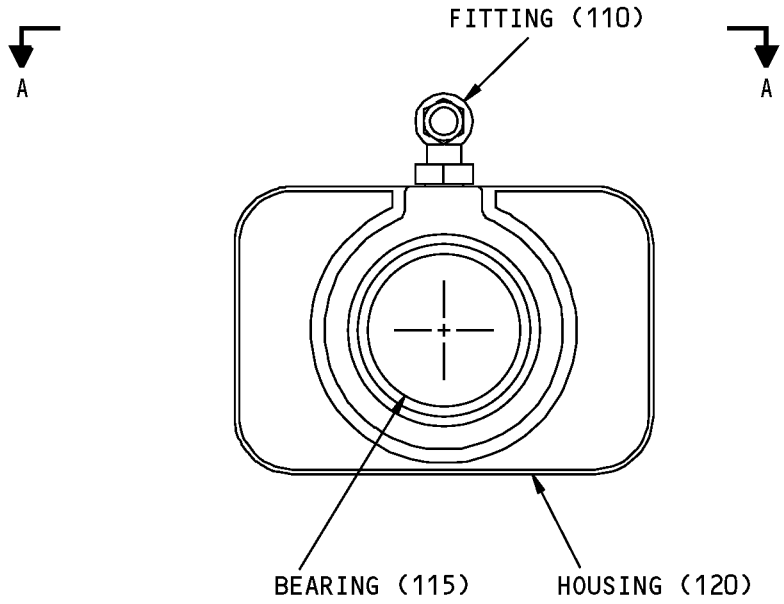
A. References

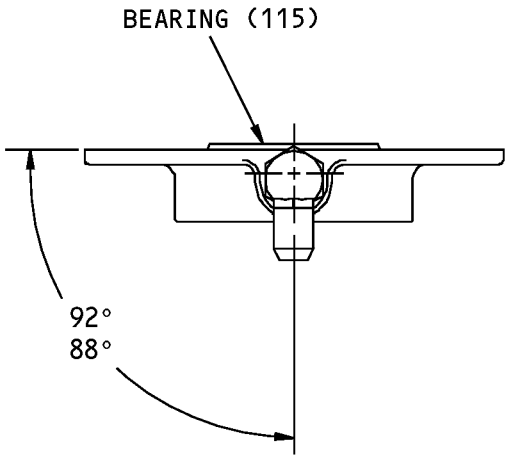
Reference	Title
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT

B. Procedure

(1) Remove the bearing (115) from the housing (120).

(2) Install the replacement bearing (115) into the housing (120) as specified in SOPM 20-50-03.





A–A

ITEM NUMBERS REFER TO IPL FIG. 2

65-2306-9 Housing Assembly Repair
Figure 601

HOUSING - REPAIR 3-2

65-2306–10

1. General

A. This procedure has the data necessary to repair the housing (120).

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

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

D. Refer to IPL Figure 2 for the item numbers.

E. General repair details:

(1) Material: Aluminum Alloy

2. Housing Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

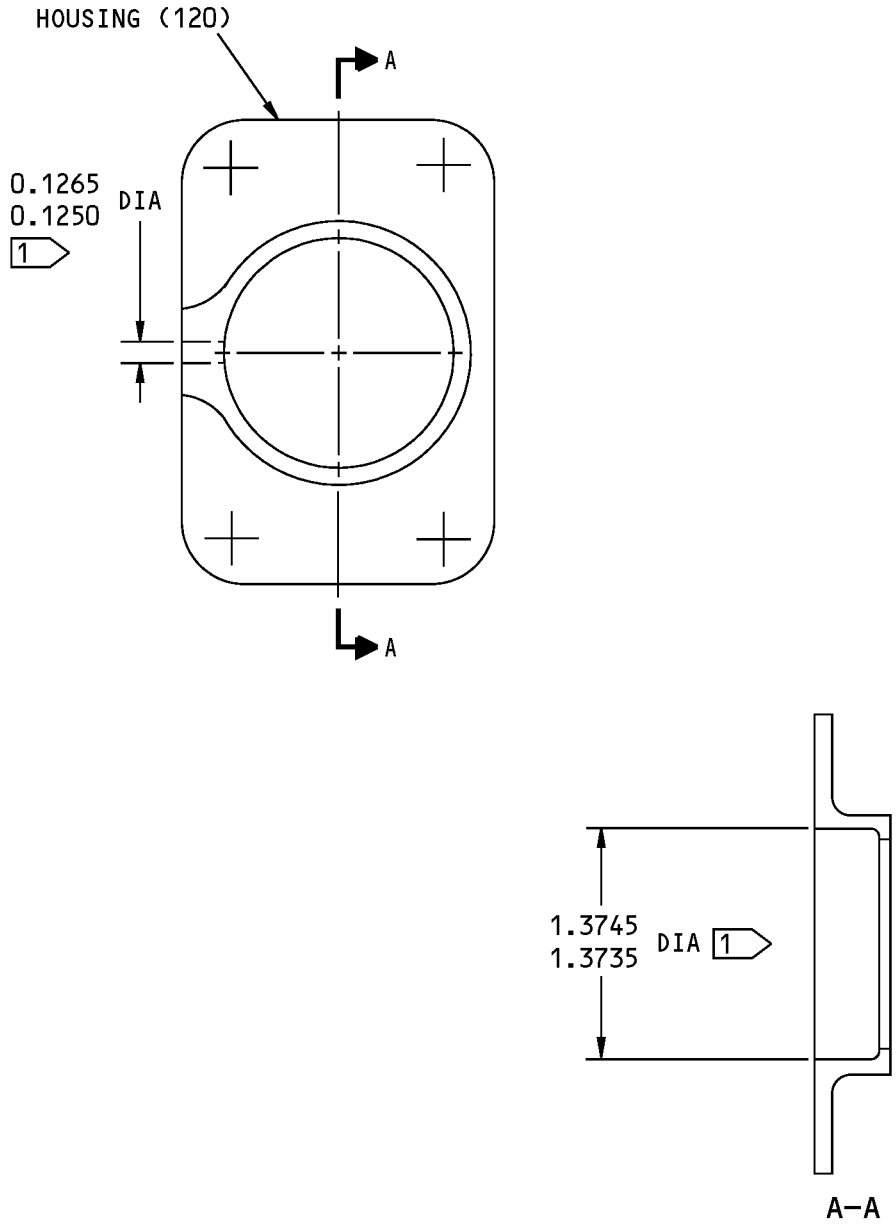
Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

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

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

(1) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.35).

(2) Apply primer, C00259 (F-20.03) to all surfaces, but do not put primer in the holes for the bearing or the fitting (see REPAIR 3-2, Figure 601).



1 DO NOT PUT PRIMER IN THE HOLES FOR THE BEARING OR THE FITTING

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

65-2306-10 Housing Repair
Figure 601

CONTROL ROD ASSEMBLY - REPAIR 4-1

65-28925–85, –86, –100, –101

1. General

A. This procedure has the data necessary to repair the control rod assembly (532, 536).

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

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

D. Refer to IPL Figure 1 for the item numbers.

2. Bearing (548, 552) Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. Procedure (Fig. 601)

(1) Remove the bearings (548, 552) from the rods (556, 560).

(2) Remove the nuts (544) from the bearings (548, 552).

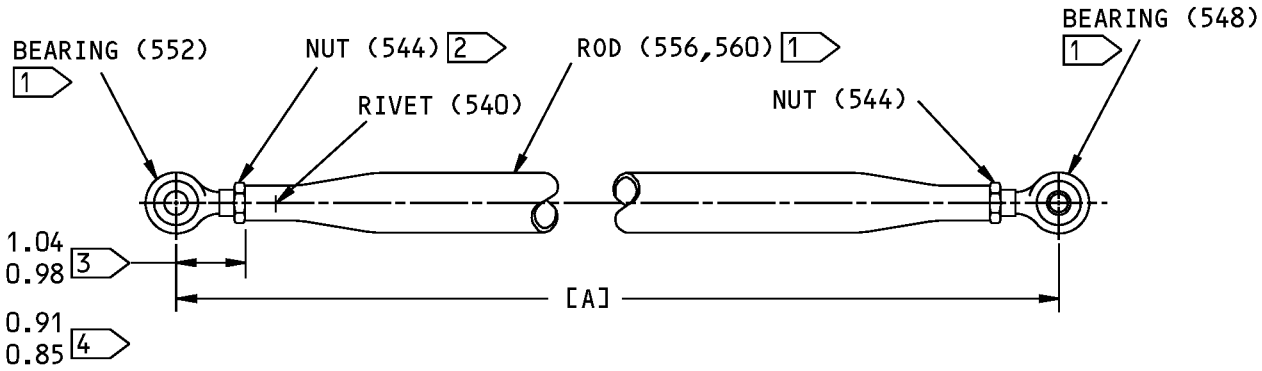
(3) Apply MIL-C-16173 compound, B50080 (F-12.14) to the mating threads of the bearings (548, 552) and rods (556, 560) as identified by flagnote 1 in REPAIR 4-1, Figure 601.

(4) Install the nuts (544) on the new bearings (548, 552).

(5) Install the new bearings (548, 552) into the rods (556, 560) to get the dimensions given in REPAIR 4-1, Figure 601.

(6) Tighten the nut (544) identified by flagnote 2 to 60 pound-inches.

(7) Install the rivet (540).



REF LETTER	IPL FIG. 1 ITEM NO.	DIMENSION	
		MIN	MAX
[A]	532	23.47	23.53
	536	21.63	21.69

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

2 TIGHTEN THIS NUT TO 60 POUND-INCHES BEFORE YOU DRILL AND INSTALL THE RIVET

2 FOR 65-28925-100,-101

2 FOR 65-28925-85,-86

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

65-28925-85,-86,-100,-101 Control Rod Assembly - Repair
Figure 601

CONTROL ROD - REPAIR 4-2

65-28925–47, –48, –104, –105

1. General

A. This procedure has the data necessary to refinish the control rod (556, 560).

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

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

D. Refer to IPL Figure 1 for the item numbers.

E. General repair details:

(1) Material: Aluminum Alloy

2. Control Rod (556, 560) Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

C. Procedure

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

(1) Finish the 65-28925-47 and -48 control rods as follows:

(a) Chemical treat (F-2.742) the internal and external surfaces.

(b) Apply primer, C00259 (SRF-12.205) to the external surface.

(2) Finish the 65-28925-104 and -105 control rods as follows:

(a) Chemical treat (F-17.08) the internal and external surfaces.

(b) Apply primer, C00259 (F-20.55) to the external surface.

CAM ASSEMBLY - REPAIR 5-1

65-44065–11

1. General

A. This procedure has the data necessary to repair the cam assembly (75).

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

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

D. Refer to IPL Figure 7 for the item numbers.

2. Insert (80) Replacement

A. References

Reference	Title
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-50-22	HOW TO INSTALL THREADED INSERTS

B. Procedure

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

(1) Remove the inserts (80) from the cam plate (85).

(2) Install the new inserts (80) into the cam plate (85) as specified in SOPM 20-50-22.

CAMPLATE - REPAIR 5-2

65-44065–12, –13

1. General

A. This procedure has the data necessary to repair the control camplate (85).

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

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

D. Refer to IPL Figure 7 for the item numbers.

E. General repair details:

(1) Material: Aluminum Alloy

2. Camplate Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

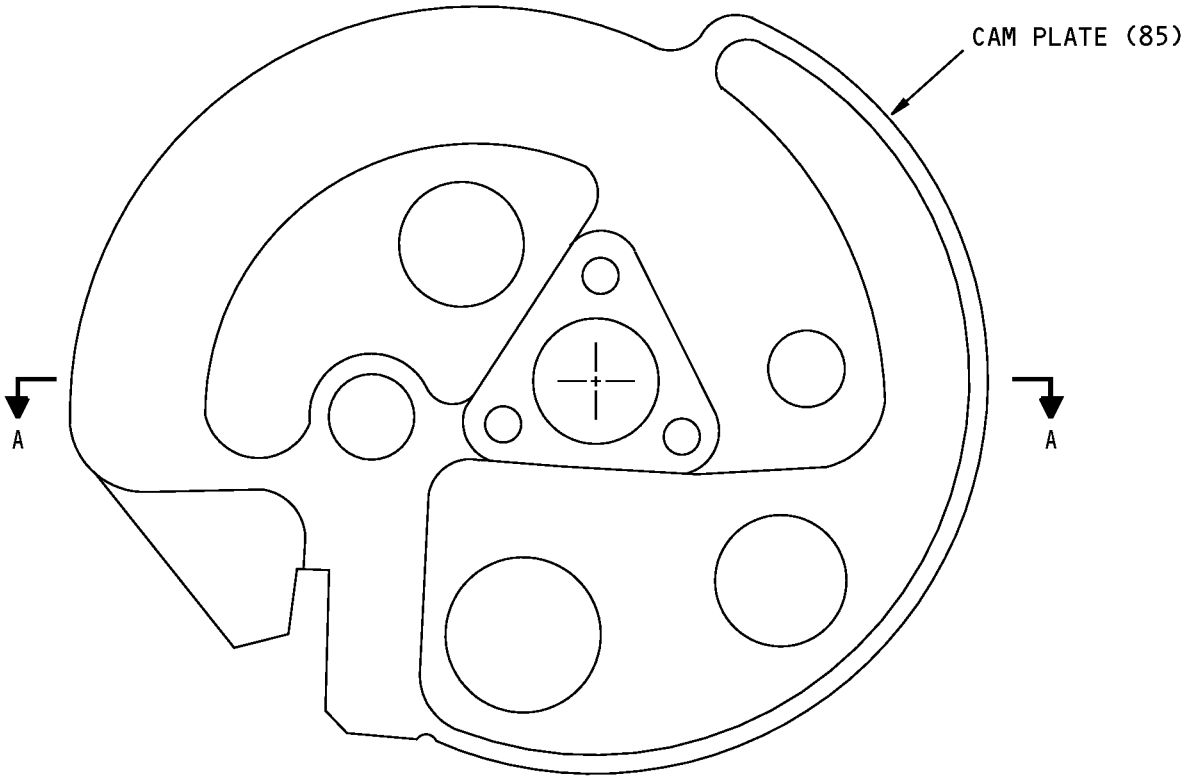
Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

C. Procedure (REPAIR 5-2, Figure 601)

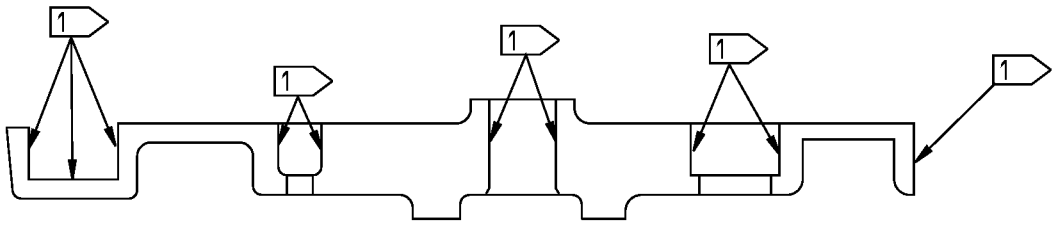
NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

(1) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.35) all surfaces.

(2) Apply primer, C00259 (F-20.03) to all surfaces but not in the splines, threaded holes or surfaces identified by flagnote 1.



65-44065-12 SHOWN
65-44065-13 IS ALMOST THE SAME



A-A

1 APPLY BMS 10-11, TYPE 1 PRIMER (F-20.03) TO ALL SURFACES BUT NOT IN THE SPLINES, THREADED HOLES OR SURFACES AS SHOWN BY FLAG NOTE 1

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 7

ALL DIMENSIONS ARE IN INCHES

65-44065-12,-13 Cam Plate Repair
Figure 601

CONTROL ROD ASSEMBLY - REPAIR 6-1

69-18187–25, –26

1. General

A. This procedure has the data necessary to repair the control rod assembly (420, 424).

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

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

D. Refer to IPL Figure 1 for the item numbers.

2. Rod End Bearing Replacement

A. References

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

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

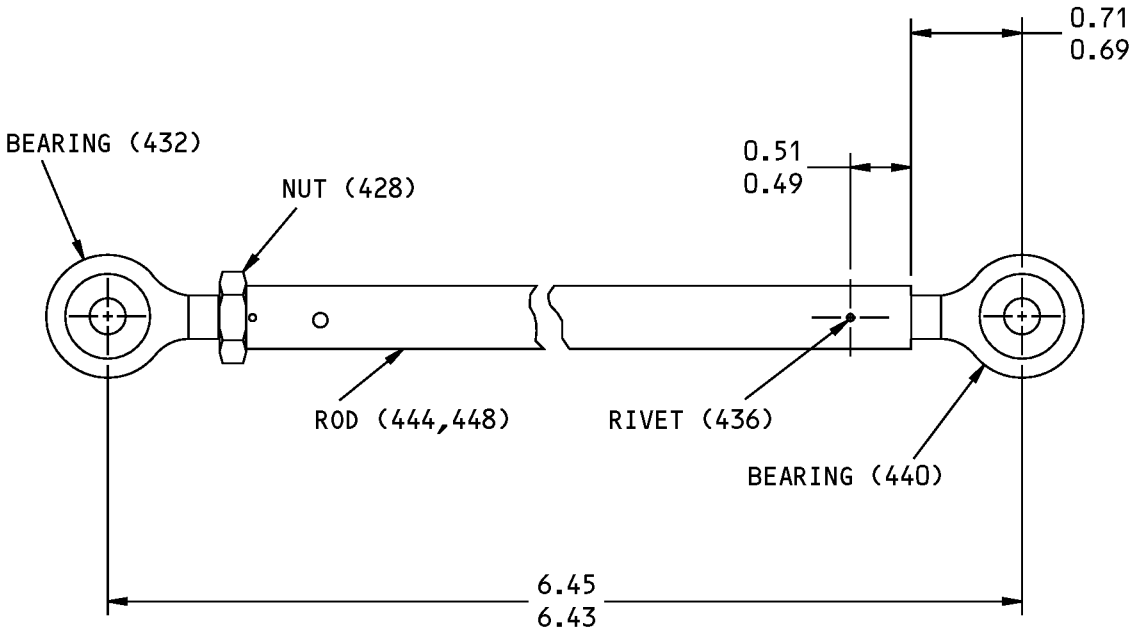
NOTE: For bolt and nut installation, refer to SOPM 20-50-01. For bearing and bushing replacement, refer to SOPM 20-50-03.

(1) Loosen the nut (428) on the rod end bearings (432).

(2) Remove the rivet (436) and the rod end bearings (440) from the rod(s) (444, 448) as shown in REPAIR 6-1, Figure 601.

(3) Install the replacement rod end bearings (440).

(4) Install the rivet (436) and nut (428) onto the rod(s) (444, 448) to the dimensions shown in REPAIR 6-1, Figure 601.



ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

69-18187-25,-26 Control Rod Assembly Repair
Figure 601

CONTROL ROD - REPAIR 6-2

66-14618–6, –7

1. General

A. This procedure has the data necessary to refinish the control rod (444, 448).

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

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

D. Refer to IPL Figure 1 for the item numbers.

E. General repair details:

(1) Material: (444) - 4130 Steel 150-170 ksi; 15-5PH CRES Optional 170-190 ksi (448) - 4130 Steel (8630 Steel Optional) 150-170 ksi

2. Rod Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

C. Procedure for rod (444)

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) For the 4130 steel rods: Cadmium plate (F-16.06) and apply primer, C00259 (F-20.02).

(2) For the 15-5PH CRES rods: Passivate (F-17.25). primer, C00259 (F-20.02) is optional.

D. Procedure for rod (448)

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

ROD ASSEMBLY - REPAIR 7-1

69-39176–1

1. General

A. This procedure has the data necessary to repair the control rod assembly (180).

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

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

D. Refer to IPL Figure 7 for the item numbers.

2. Rod End Bearing (195) Replacement

A. References

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

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

NOTE: For bolt and nut installation, refer to SOPM 20-50-01. For bearing and bushing replacement, refer to SOPM 20-50-03.

(1) Remove the rivet (185) from the rod (200).

(2) Remove the rod end bearings (195) from the rod (200).

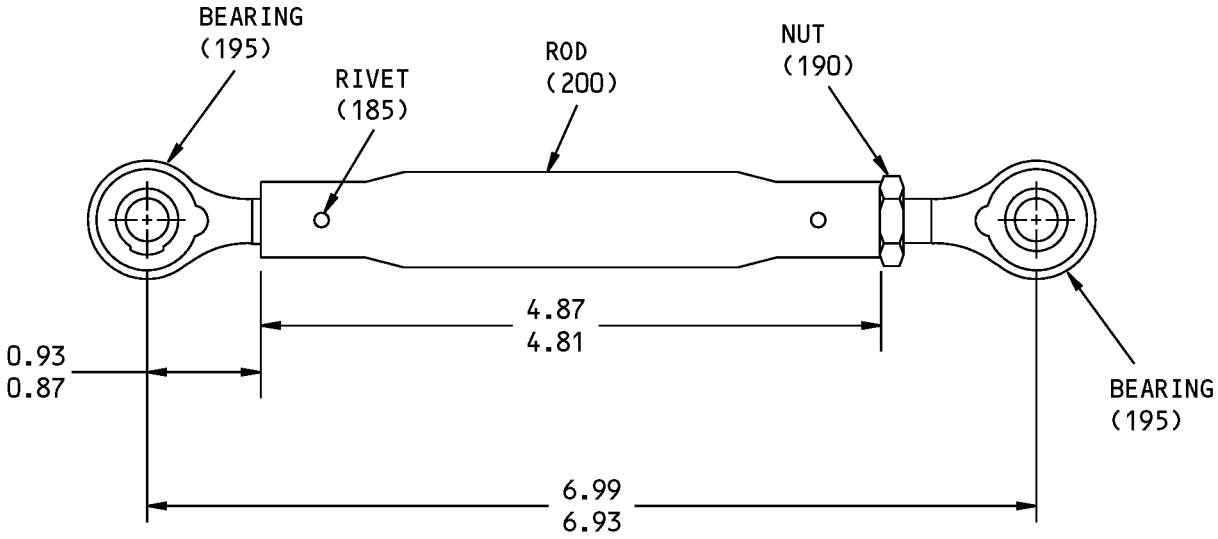
(3) Remove the nut (190) from the rod end bearing (195).

(4) Install the nut (190) onto the new rod end bearing (195).

(5) Install the new rod end bearings (195) onto the rod (200).

(6) Adjust the rod end bearing (195) to the dimension given in REPAIR 7-1, Figure 601 and install the rivet (185) through the rod (200) and the rod end bearing (195).

(7) Adjust the rod end bearing (195) to the dimension given in REPAIR 7-1, Figure 601. Tighten the nut (190).



ITEM NUMBERS REFER TO IPL FIG. 7

ALL DIMENSIONS ARE IN INCHES

69-39176-1 Rod Assembly Repair
Figure 601

ROD - REPAIR 7-2

69-39176–2

1. General

A. This procedure has the data necessary to refinish the rod (200).

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

C. Refer to IPL Figure 7 for the item numbers.

D. General repair details:

(1) Material:

- 8630 or 4130 Steel Tube
- 150-170 ksi

2. Rod Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
C50001	Compound - Corrosion Preventive, Petroleum Hot Application (Hard Film)	MIL-C-11796, Class I

B. References

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

C. Procedure

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

(1) Cadmium plate (F-1.32) the external surface. Plating throw-in is permitted on the interior surface.

(2) Apply compound, C50001 (F-1.73) onto the internal surfaces.

CAM FOLLOWER CRANK ASSEMBLY - REPAIR 8-1

90-7815–25, –26

1. General

A. This procedure has the data necessary to repair the cam follower crank assembly (320, 325).

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

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

D. Refer to IPL Figure 7 for the item numbers.

2. Bearing (345) 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 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-50-02	INSTALLATION OF SAFETYING DEVICES
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-04	MISCELLANEOUS MATERIALS

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

NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For miscellaneous materials, refer to SOPM 20-60-04.

(1) Remove the cotter pin (330), nut (335), washers (340) and bearing (345) from the crank arm (350, 355).

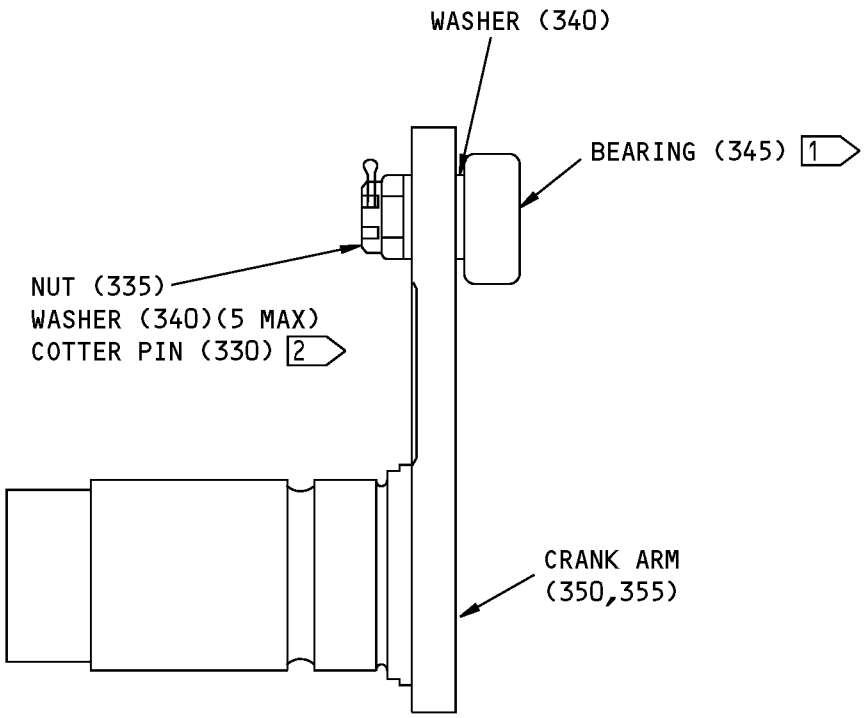
(2) Install a washer (340) on the bearing (345).

(3) Install the bearing (345) and washer (340) into the crank arm (350, 355) with wet sealant, A00247 as specified in SOPM 20-50-03.

(4) Install a maximum of five washers (340) and the nut (335) on the bearing (345) with wet sealant, A00247 as specified in SOPM 20-50-03.

(a) Install a maximum of five washers to permit the nut to be tightened correctly and the cotter pin to be installed correctly.

(5) Install the cotter pin (330) as specified in SOPM 20-50-02.



1 INSTALL THE BEARING WITH WET BMS 5-95 SEALANT

2 INSTALL THE COTTER PIN AS SPECIFIED IN SOPM 20-50-02

ITEM NUMBERS REFER TO IPL FIG. 7

90-7815-25,-26 Cam Follower Crank Assembly Repair
Figure 601

CRANK ARM - REPAIR 8-2

90-7815–29, –30

1. General

A. This procedure has the data necessary to refinish the crank arm (350, 355).

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

C. Refer to IPL Figure 7 for the item numbers.

D. General repair details:

(1) Material: Aluminum Alloy

2. Crank Arm Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

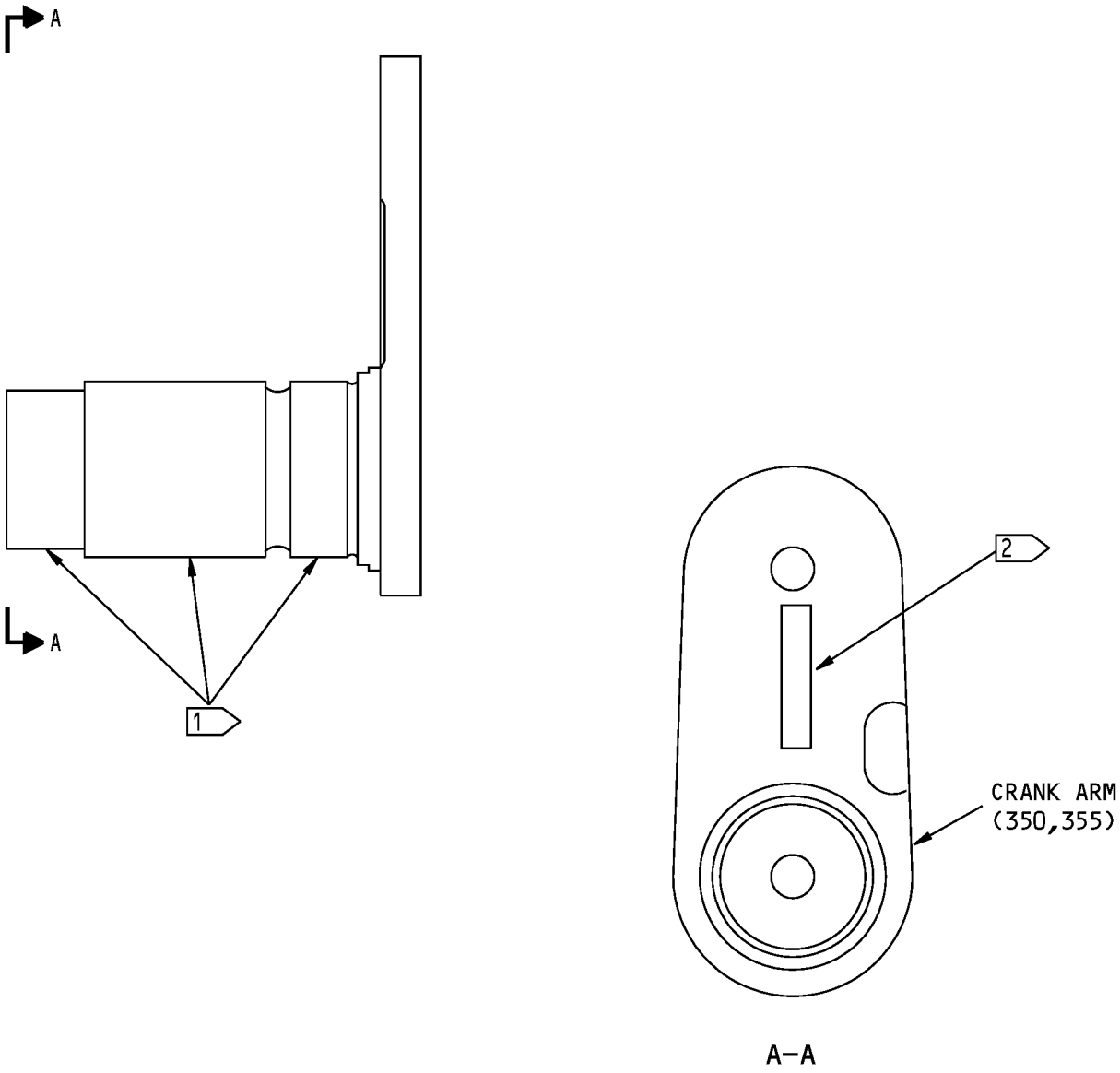
Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

C. Procedure

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

(1) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.35).

(2) Apply primer, C00259 (F-20.03) but not on the splined surfaces and surfaces identified by flagnote 1 in REPAIR 8-2, Figure 601.



1 DO NOT PUT PRIMER ON THIS SURFACE

2 THE PART NUMBER IS FOUND HERE

ITEM NUMBERS REFER TO IPL FIG. 7

90-7815-29,-30 Crank Arm Refinish
Figure 601

DRAIN VALVE ASSEMBLY - REPAIR 9-1

140N2022–1

1. General

A. This procedure has the data necessary to repair the drain valve assembly (700).

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

C. Refer to IPL Figure 1 for the item numbers.

2. Drain Valve Assembly Replacement

A. Procedure

(1) Remove the rivets (752) and the drain valve retainer (756) from the stub beam (748, 768).

(2) Remove the drain valve assembly (700) from the drain valve retainer (756).

(3) Install the new drain valve assembly (700) into the drain valve retainer (756).

(a) Tighten the valve assembly housing (716) to 10-15 pound-inches.

(4) Attach the drain valve retainer (756) to the stub beam (748, 768) with rivets (752).

TORQUE TUBE ASSEMBLY - REPAIR 10-1

147A6503–1, –2, –3, –4

1. General

A. This procedure has the data necessary to repair the torque tube assembly (588, IPL Figure 1).

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

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

D. Refer to IPL Figure 6 for the item numbers.

2. Torque Tube Assembly Repair

A. References

Reference	Title
SOPM 20-10-02	MACHINING OF ALLOY STEEL
SOPM 20-50-01	BOLT AND NUT INSTALLATION

B. Procedure

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

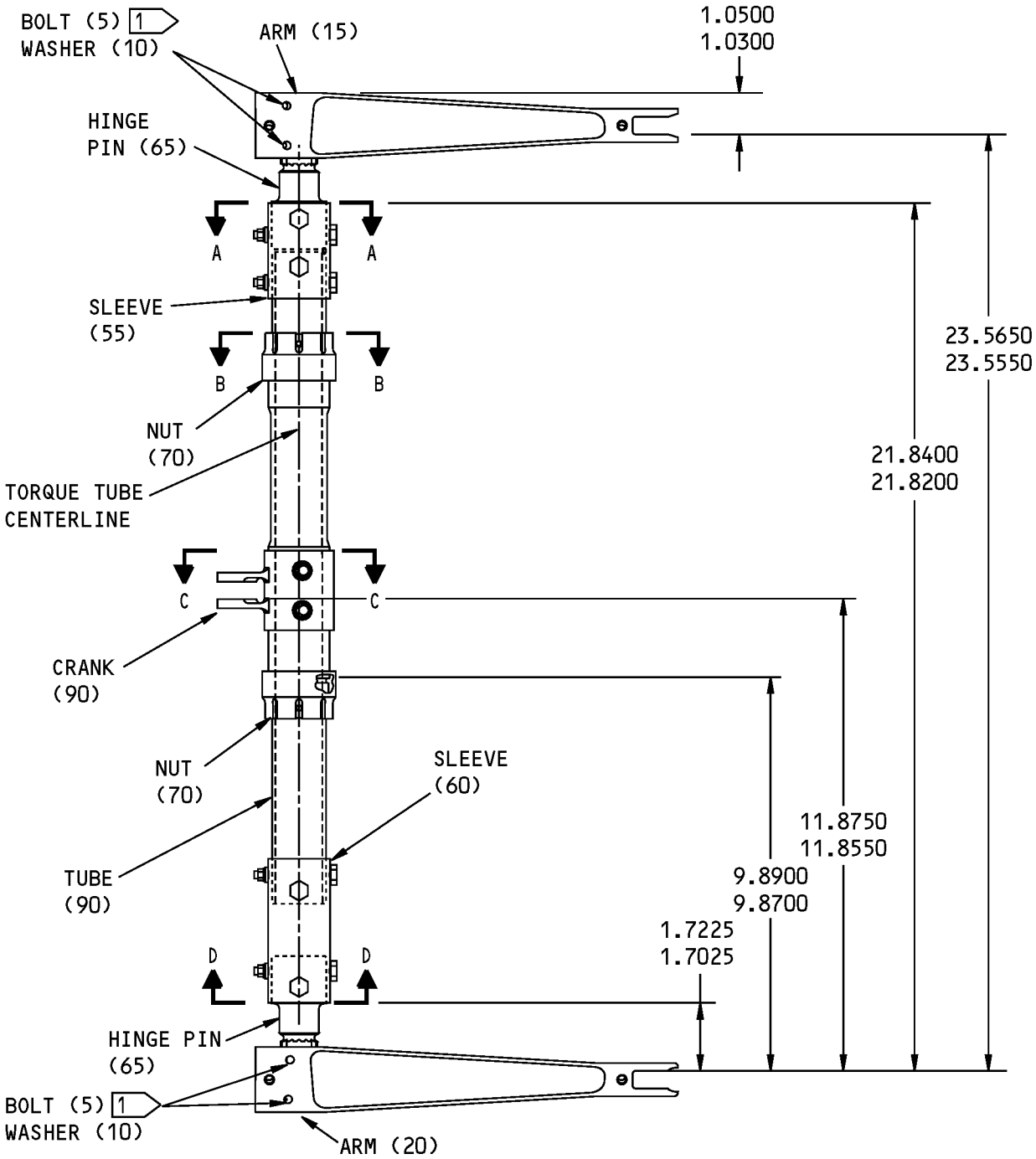
(1) Torque bolts (5) to 25 - 30 pound-inches before drilling a hole.

NOTE: The torque tube assembly contains match drilled parts. The torque tube assembly must be kept together until installed in the next assembly.

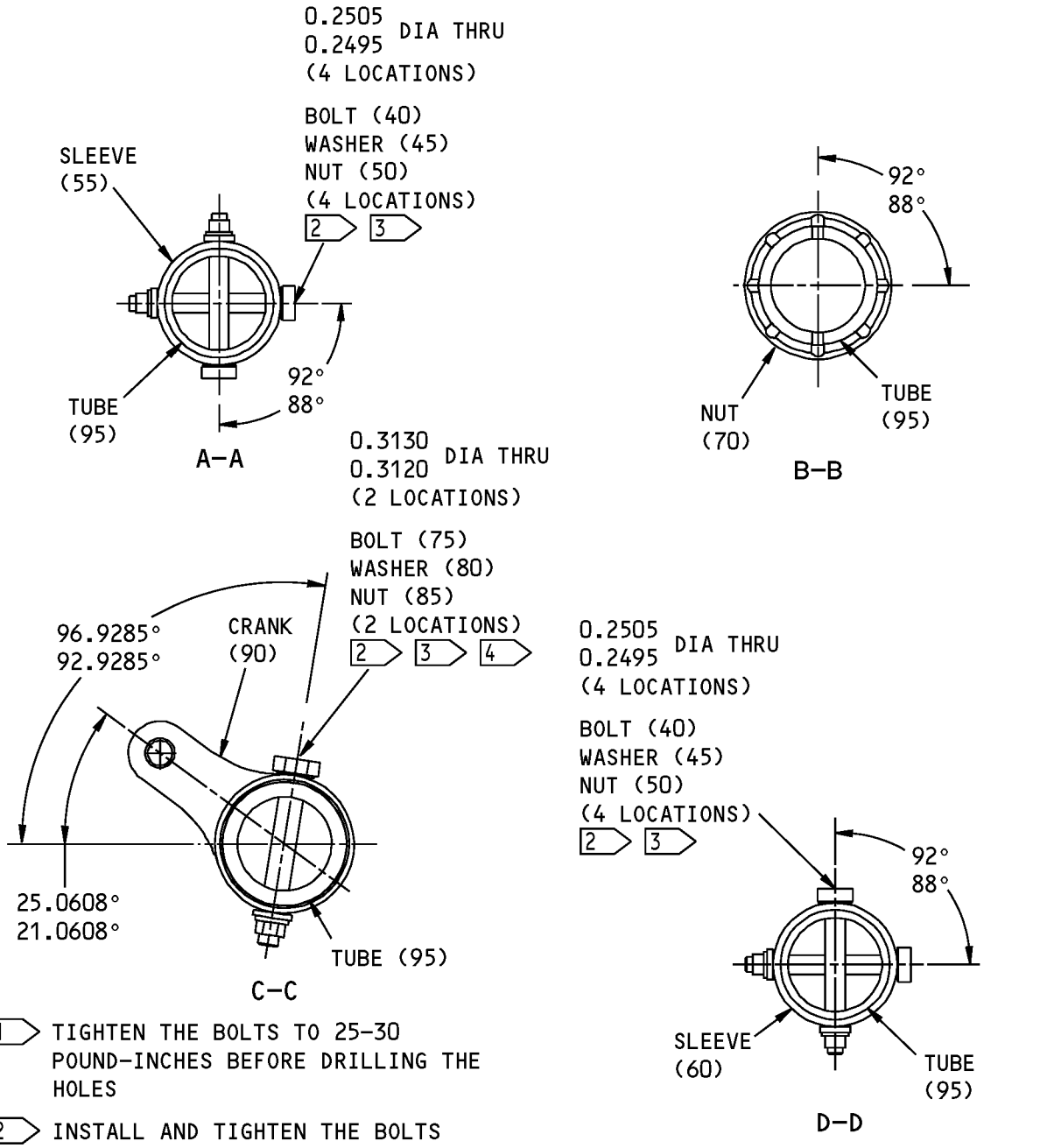
(2) Drill and deburr the holes for the sleeves (55, 60) and the crank (90) as specified in SOPM 20-10-02 and as shown in REPAIR 10-1, Figure 601.

(3) Install the bolts (40) finger-tight only with the heads as shown in REPAIR 10-1, Figure 601.

(4) Install the bolts (75) finger-tight with the heads as shown in REPAIR 10-1, Figure 601.



147A6503-1,-2,-3,-4 Torque Tube Assembly
Figure 601 (Sheet 1 of 2)



1 TIGHTEN THE BOLTS TO 25–30 POUND–INCHES BEFORE DRILLING THE HOLES

2 INSTALL AND TIGHTEN THE BOLTS WITH YOUR FINGERS

3 INSTALL THE BOLT AS SHOWN. THE BOLT DIRECTION IS IMPORTANT TO PREVENT INTERFERENCE

4 GRIP LENGTH SUBSTITUTION IS NOT PERMITTED

ITEM NUMBERS REFER TO IPL FIG. 6

ALL DIMENSIONS ARE IN INCHES

147A6503-1,-2,-3,-4 Torque Tube Assembly
Figure 601 (Sheet 2 of 2)

TORQUE TUBE - REPAIR 10-2

147A6118–2, –4

1. General

A. This procedure has the data necessary to refinish the torque tube (95).

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

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

D. Refer to IPL Figure 6 for the item numbers.

E. General repair details:

(1) Material:

- 15-5PH CRES
- 180-200 ksi

2. Torque Tube Refinish

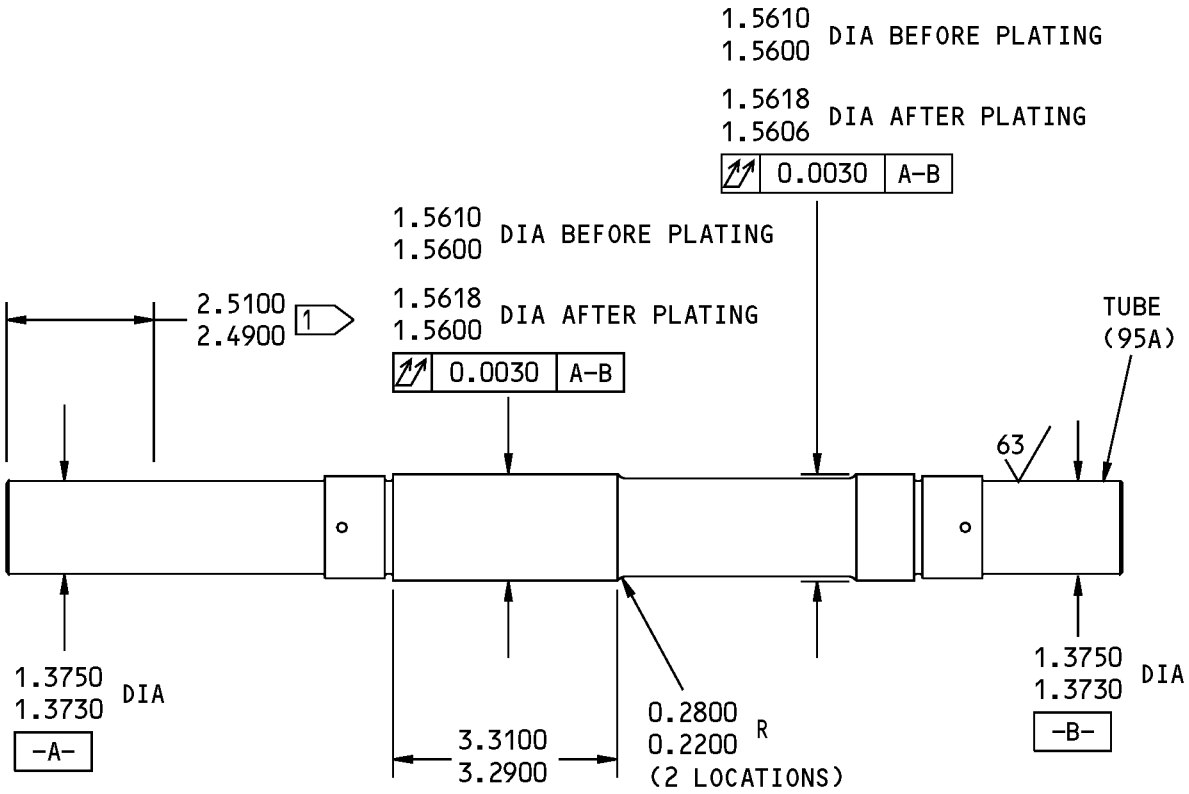
A. References

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

B. Procedure

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

(1) Cadmium plate (F-15.06) outer surface only. Cadmium throw-in is permitted on the inner surface.



147A6118-4 SHOWN
147A6118-2 SIMILAR

1 MARK THE PART NUMBER IN THIS AREA

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 6

ALL DIMENSIONS ARE IN INCHES

147A6118-2,-4 Torque Tube Repair
Figure 601

TORQUE TUBE COUPLING SLEEVE - REPAIR 10-3

147A6119 149A6110–1, –1

1. General

A. This procedure has the data necessary to refinish the torque tube coupling sleeve (55, 60).

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

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

D. Refer to IPL Figure 6 for the item numbers.

E. General repair details:

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

2. Torque Tube Coupling Sleeve Refinish

A. References

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

B. Procedure

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

(1) Passivate (F-17.25).

CRANK - REPAIR 10-4

69-17330–6

1. General

A. This procedure has the data necessary to refinish the crank (90).

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

C. Refer to IPL Figure 6 for the item numbers.

D. General repair details:

(1) Material: 15-5PH CRES, 150-170 ksi

2. Crank Refinish

A. References

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

B. Procedure

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

(1) Passivate (F-17.25).

HINGE LINK PIN - REPAIR 10-5

66-14527–8

1. General

A. This procedure has the data necessary to refinish the hinge link pin (65).

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

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

D. Refer to IPL Figure 6 for the item numbers.

E. General repair details:

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

2. Crank Refinish (REPAIR 10-5, Figure 601)

A. References

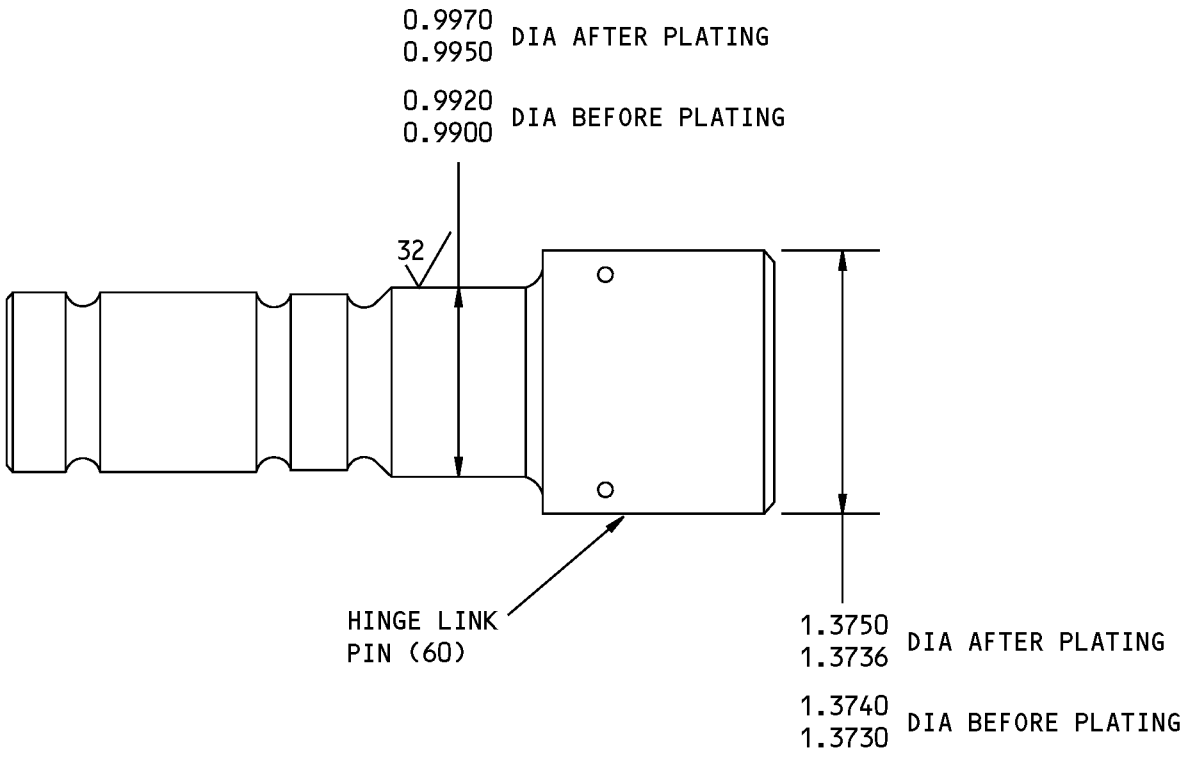
Reference	Title
SOPM 20-20-01	MAGNETIC PARTICLE INSPECTION
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES

B. Procedure

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

(1) Cadmium Plate (F-15.06).

(2) Do a Class B magnetic particle inspection as specified in SOPM 20-20-01.



250 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 6

ALL DIMENSIONS ARE AFTER PLATING UNLESS SHOWN DIFFERENTLY

ALL DIMENSIONS ARE IN INCHES

66-14527-8 Hinge Link Pin Refinish
Figure 601

HINGE ARM ASSEMBLY - REPAIR 10-6

65-73978–2, –7, –16, –20

1. General

A. This procedure has the data necessary to repair the hinge arm assembly (15, 20).

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

C. Refer to IPL Figure 6 for the item numbers.

2. Insert (25) Replacement

A. References

Reference	Title
SOPM 20-50-22	HOW TO INSTALL THREADED INSERTS

B. Procedure

NOTE: For instuctions on how to install threaded inserts, refer to SOPM 20-50-22.

(1) Remove the inserts (25) from the hinge arms (30, 35).

(2) Install the new inserts (25) into the hinge arms (30, 35).

(a) Install inserts (25) 1/4 to 1-1/2 turns below the start of the first thread.

(b) Remove the tang of the insert.

HINGE ARM - REPAIR 10-7

65-73978–4, –9, –11, –14, –18, –22

1. General

A. This procedure has the data necessary to refinish the hinge arm (30, 35).

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

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

D. Refer to IPL Figure 6 for the item numbers.

E. General repair details:

(1) Material: Aluminum Alloy

2. Hinge Arm (30, 35) 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
C50069	Coating - Enamel, Color 702 Gloss White	BMS10-11, Type II

B. References

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

C. Procedure

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

(1) Hinge Arm (30) refinish.

(a) Chemical treat or chromic acid anodize and apply primer, C00259 (F-18.05). Do not put primer in the splined hole.

(b) Apply enamel coating, C50069 (F-21.25).

(2) Hinge arm (35, 35A) refinish:

(a) Chemical treat or chromic acid anodize and apply primer, C00259 (F-2.30). Do not put primer in the splined hole.

(b) Apply enamel coating, C50069 (F-21.03).

(3) Hinge arm (358) refinish:

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

(b) Apply primer, C00259 (F-20.02). Do not put primer in the splined hole.

(c) Apply enamel coating, C50069 (F-21.03).

(4) Hinge arm (35C) refinish:

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

(b) Apply primer, C00259 (F-20.02). Do not put primer in the splined hole.

HINGE SUPPORT ASSEMBLY - REPAIR 11-1

147A6140–2, –4

1. General

A. This procedure has the data necessary to repair the hinge support assembly (628, 632).

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

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

D. Refer to IPL Figure 1 for the item numbers.

2. Fitting Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-50-19	GENERAL SEALING

C. Procedure

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

(1) Remove the bolts (640, 644), washers (652, 656, 660), nuts (664, 668), and the fittings (672, 676) from the support assemblies (680, 684).

(2) Remove the washers (636) from the fitting (676).

(3) Apply a corrosion protection fay surface seal with sealant, A00247 between the surfaces as specified in SOPM 20-50-19.

(4) Install the bolts (640, 644), fittings (672, 676), washers (652, 656, 660), and nuts (664, 668) onto the support assembly(s) (680, 684).

(5) Bond the washers (636) to the fitting (676) with sealant, A00247 (F-19.48) as specified in SOPM 20-50-19, Method 2. Ensure that no sealant is in the holes of the fitting and the washers do not obstruct the holes.

ATTACH FITTING - REPAIR 11-2

69-70268 147A6162–2, –1

1. General

A. This procedure has the data necessary to repair the attach fitting (672, 676).

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

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

D. Refer to IPL Figure 1 for the item numbers.

E. General repair details:

(1) Material: Aluminum Alloy

2. Fitting Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

C. Procedure

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

(1) Anodize and apply primer, C00259 (F-18.04)

SUPPORT ASSEMBLY - REPAIR 12-1

147A6140–5, –6

1. General

A. This procedure has the data necessary to repair the support assembly (680, 684).

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

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

D. Refer to IPL Figure 1 for the item numbers.

2. Bushing Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

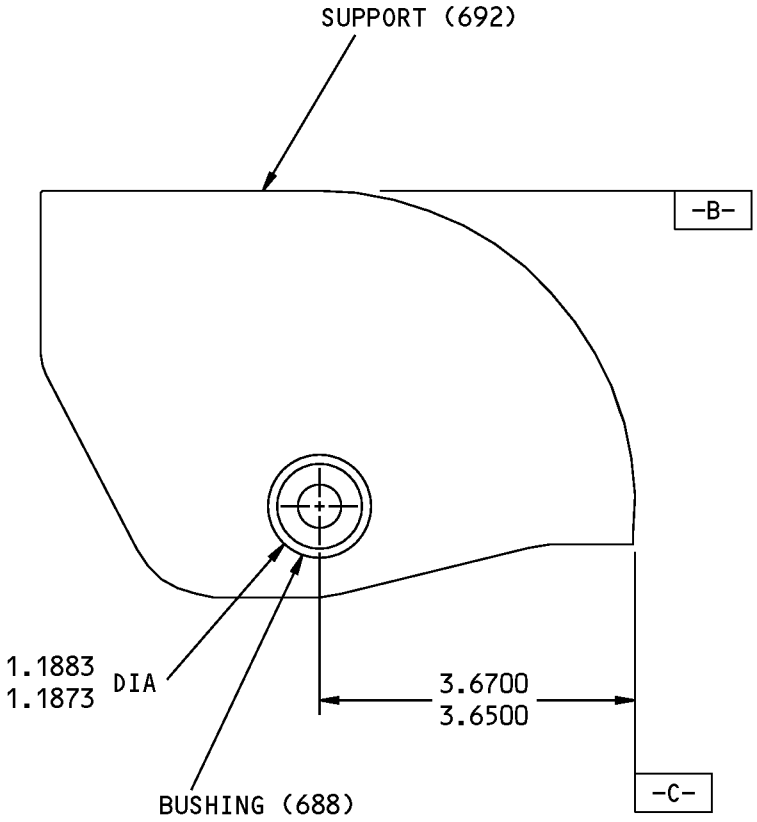
C. Procedure

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

(1) Remove the bushing(s) (688) from the support (692, 696).

(2) Install the replacement bushing(s) (688) into the support (692, 696). Use the shrink-fit procedure as specified in SOPM 20-50-03 with sealant, A00247.

(3) Make sure that the bushing(s) (688) is installed flush with the support surface (692, 696).



147A6140-5 SHOWN
147A6140-6 OPPOSITE

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

147A6140-5,-6 Support Assembly Repair
Figure 601

HINGE SUPPORT - REPAIR 12-2

147A6140–7, –8

1. General

A. This procedure has the data necessary to repair the hinge support (692, 696).

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

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

D. Refer to IPL Figure 1 for the item numbers.

E. General repair details:

(1) Material: Aluminum Alloy

2. Hinge Support Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

C. Procedure

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

(1) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.35).

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

STOP ASSEMBLY - REPAIR 13-1

147A6128–6, –8, –10, –12, –14, –16, –18, –23, –24, –50

1. General

A. This procedure has the data necessary to repair the stop assembly(s) (605, 610, 680, 685, 815, 820, 825, 875, 880).

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

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

D. Refer to IPL Figure 2 for the item numbers.

2. Bushing Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

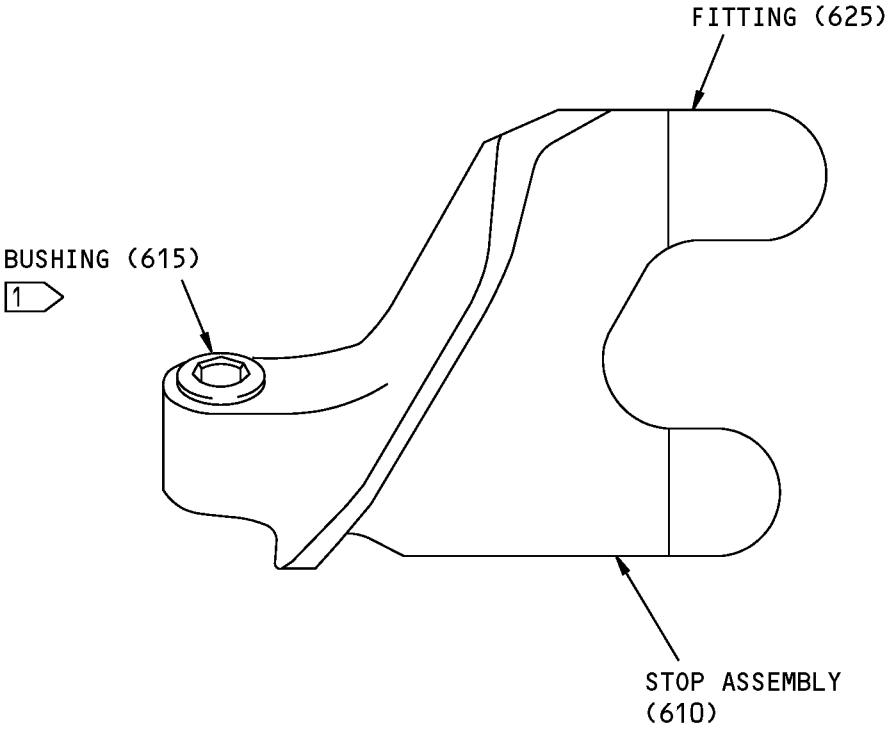
C. Procedure

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

(1) Remove the bushing(s) (615, 690, 830, 885, 955) from the stop fitting(s) (620, 625, 695, 700, 835, 840, 845, 890, 895A, 960, 965) as shown in REPAIR 13-1, Figure 601.

(2) Install the new bushing(s) (615, 690, 830, 885, 955) into the stop fitting(s) (620, 625, 695, 700, 835, 840, 845, 890, 895A, 960, 965) with sealant, A00247 by roller swage procedure as specified in SOPM 20-50-03.

(3) Fillet seal the bushing flanges with sealant, A00247 as specified in SOPM 20-50-03.



147A6128-23

NOTE: OTHER STOP ASSEMBLIES ARE ALMOST THE SAME.

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

ITEM NUMBERS REFER TO IPL FIG. 2

147A6128-6,-8,-10,-12,-14,-16,-18,-23,-24,-50 Stop Assembly Repair
Figure 601

STOP FITTING - REPAIR 13-2

147A6128–26, –28, –30, –32, –34, –36, –38, –40, –42, –47, –48, –52

1. General

A. This procedure has the data necessary to repair the stop fitting(s) (620, 625, 695, 700, 835, 840, 845, 890, 895, 960, 965).

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

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

D. Refer to IPL Figure 2 for item numbers.

E. General repair details:

(1) Material: Aluminum Alloy

(2) Shot Peen: All outside surfaces, but not the holes. Intensity: 0.005A-0.010A Coverage: 1.0 Automatic; Optional 2.0 Manual

2. Stop Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

C. Procedure

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

(1) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.35).

(2) Apply primer, C00259 (F-20.03) to all surfaces but not in the holes for the bushings.

(UPPER) END GATE ASSEMBLY - REPAIR 14-1

147A6514–1, –2, –3, –4

1. General

A. This procedure has the data necessary to repair the upper end gate assemblies (464, IPL Figure 1; 1A, IPL Figure 4).

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

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

D. Refer to IPL Figure 4 for the item numbers.

2. Retainer Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

Reference	Title
SOPM 20-50-19	GENERAL SEALING
SOPM 20-60-04	MISCELLANEOUS MATERIALS

C. Procedure

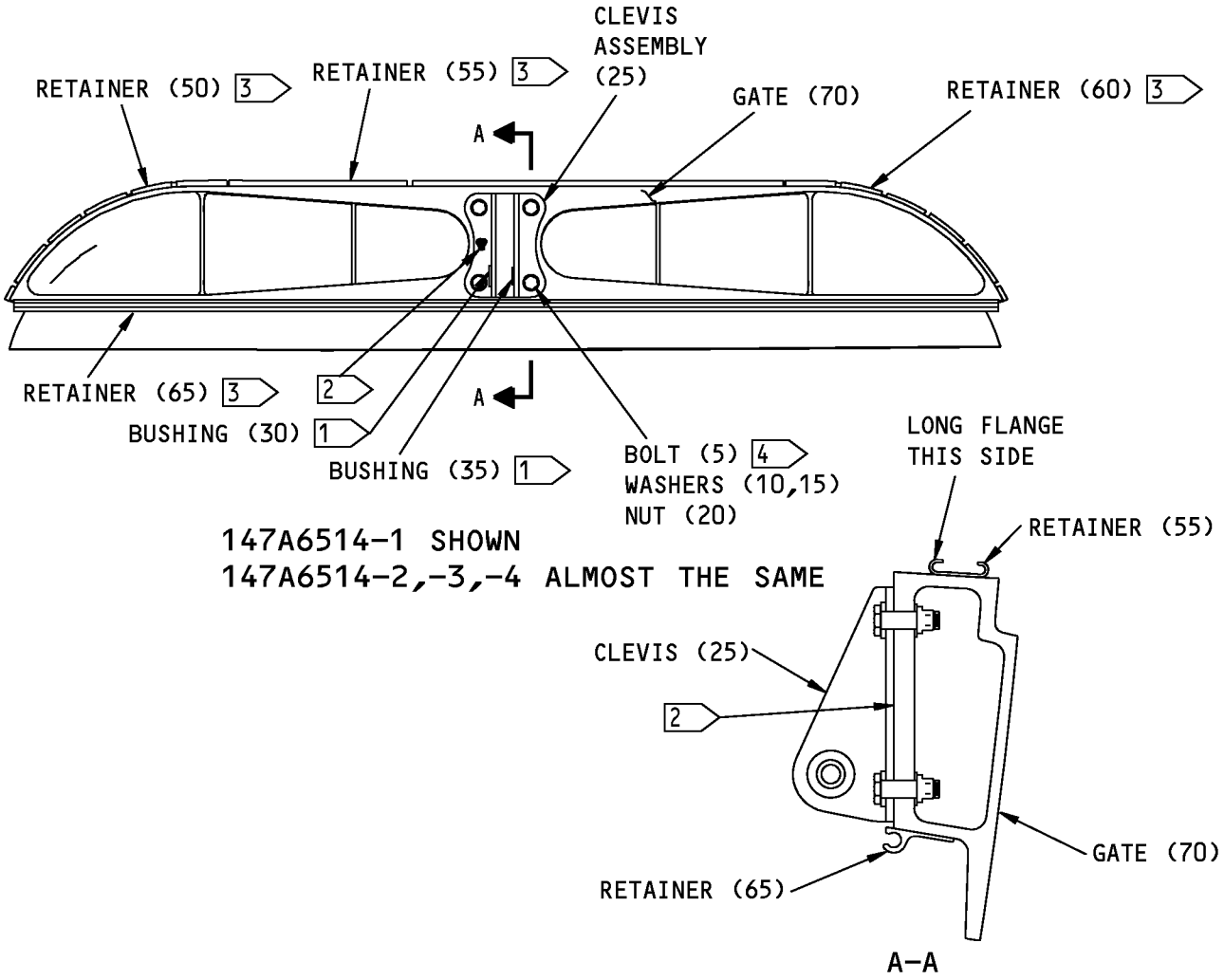
NOTE: For miscellaneous materials, refer to SOPM 20-60-04.

(1) Remove the rivets (45) and the retainers (50, 55, 60, 65) from the gate (70).

(2) Remove the bolts (5), washers (10, 15), nuts (20) and the clevis assembly (25) from the gate (70).

(3) Install the retainers (50, 55, 60, 65) and rivets (45) onto the gate (70) with sealant, A00247 as shown by flagnote 3 in REPAIR 14-1, Figure 601 and as specified in SOPM 20-50-19.

(4) Install the bolts (5), washers (10, 15), nuts (20) and the clevis assembly (25) onto the gate (70) with sealant, A00247 as shown by flagnotes 2 and 4 in REPAIR 14-1, Figure 601 and as specified in SOPM 20-50-19.



147A6514-1 SHOWN
147A6514-2,-3,-4 ALMOST THE SAME

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

2 APPLY CORROSION PROTECTION FAY SURFACE SEAL WITH BMS 5-95 BETWEEN INDICATED SURFACES AS SPECIFIED IN SOPM 20-50-19

3 APPLY PRESSURE FAY SURFACE SEAL WITH BMS 5-95 BETWEEN RETAINERS AND END GATE, EXCEPT AS NOTED. DO NOT ALLOW EXCESSIVE SQUEEZE OUT IN SLOTTED AREAS OF SEAL RETAINER

4 INSTALL FASTENERS WET WITH BMS 5-95, TIGHTEN BOLTS TO 25-30 POUND-INCHES. ENCAPSULATE NUTS, COLLARS AND WASHERS WITH BMS 5-95 AS SPECIFIED IN SOPM 20-50-19

ITEM NUMBERS REFER TO IPL FIG. 4

ALL DIMENSIONS ARE IN INCHES

W79902 S00041001986_V2

147A6514-1,-2,-3,-4 End Gate Assembly
Figure 601

(UPPER) CONTROL ROD CLEVIS ASSEMBLY - REPAIR 14-2

147A6144–2

1. General

A. This procedure has the data necessary to repair the upper clevis assembly (25).

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

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

D. Refer to IPL Figure 4 for the item numbers.

2. Bushing Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

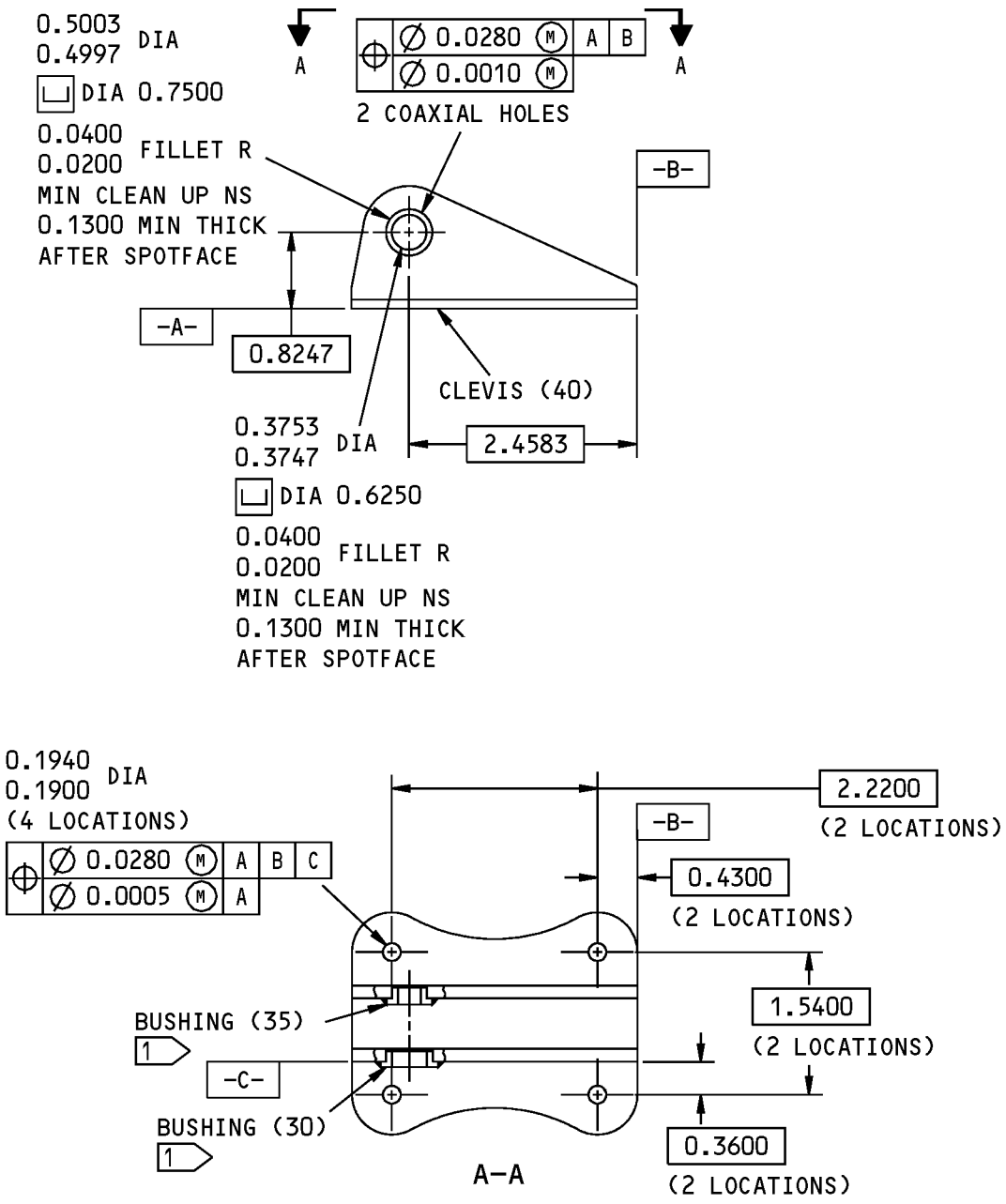
Reference	Title
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT

C. Procedure

(1) Remove the bushings (30, 35) from the clevis (40) as shown in REPAIR 14-2, Figure 601.

(2) Install the replacement bushings (30, 35) into the clevis (40) with sealant, A00247 as specified in SOPM 20-50-03.

(3) Fillet seal each end of the bushings (30, 35) with sealant, A00247.



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

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 4

ALL DIMENSIONS ARE IN INCHES

147A6144-2 (Upper) Clevis Repair
Figure 601

(UPPER) CLEVIS - REPAIR 14-3

147A6144–4

1. General

A. This procedure has the data necessary to repair the (upper) clevis (40).

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

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

D. Refer to IPL Figure 4 for the item numbers.

E. General repair details:

(1) Material: Aluminum Alloy

2. Upper Clevis Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

C. Procedure

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

(1) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.35).

(2) Apply primer, C00259 (F-20.03) but not in the holes for the bushings.

(UPPER) GATE - REPAIR 14-4

147A6516–1, –3, –4

1. General

A. This procedure has the data necessary to refinish the end gate (70).

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

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

D. Refer to IPL Figure 4 for the item numbers.

E. General repair details:

(1) Material: Magnesium Alloy

2. Gate Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
C00032	Coating - Exterior Protective Enamel, General Use	BMS10-60, Type I
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I
C00304	Coating - Teflon Filled, Non Decorative, Sprayable Material	BMS 10-86 Type I

B. References

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

C. Procedure

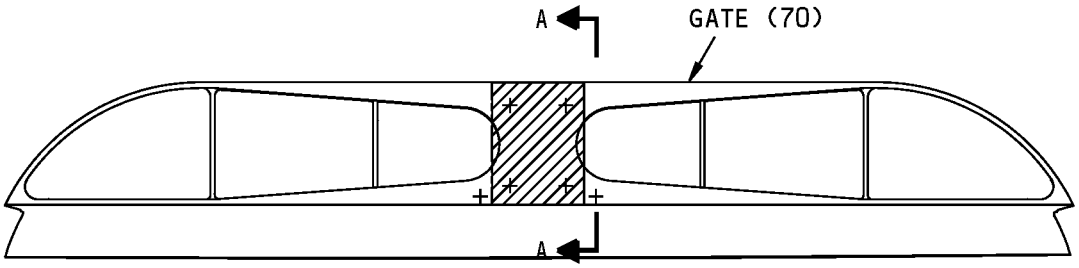
NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

(1) Anodize (F-17.12).

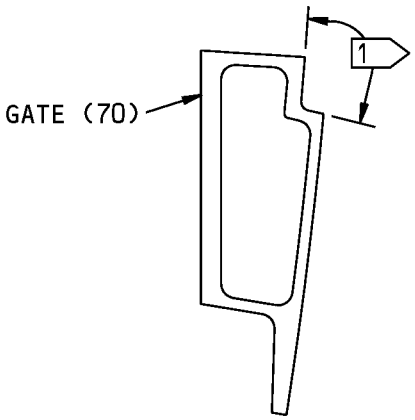
(2) Apply primer, C00259 (F-20.03).

(3) Apply enamel coating, C00032 (F-14.9813) but not in the bolt holes or in the area identified by flagnote 1.

(4) Apply coating, C00304 (F-14.9624) to the area identified by flagnote 1 in REPAIR 14-4, Figure 601 for the length of the gate (70).



147A6516-1 SHOWN
147A6516-3,-4 ALMOST THE SAME



A-A

1 APPLY BMS 10-86 TEFLON COATING TO THIS AREA FOR THE LENGTH OF THE GATE. DO NOT APPLY ENAMEL

ITEM NUMBERS REFER TO IPL FIG. 4

ALL DIMENSIONS ARE IN INCHES

147A6516-1,-3,-4 (Upper) Gate Refinish
Figure 601

(LOWER) END GATE ASSEMBLY - REPAIR 15-1

147A6146–2, –8, –12

1. General

A. This procedure has the data necessary to repair the end gate assemblies (80, IPL Figure 5).

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

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

D. Refer to IPL Figure 5 for the item numbers.

2. Bushing Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

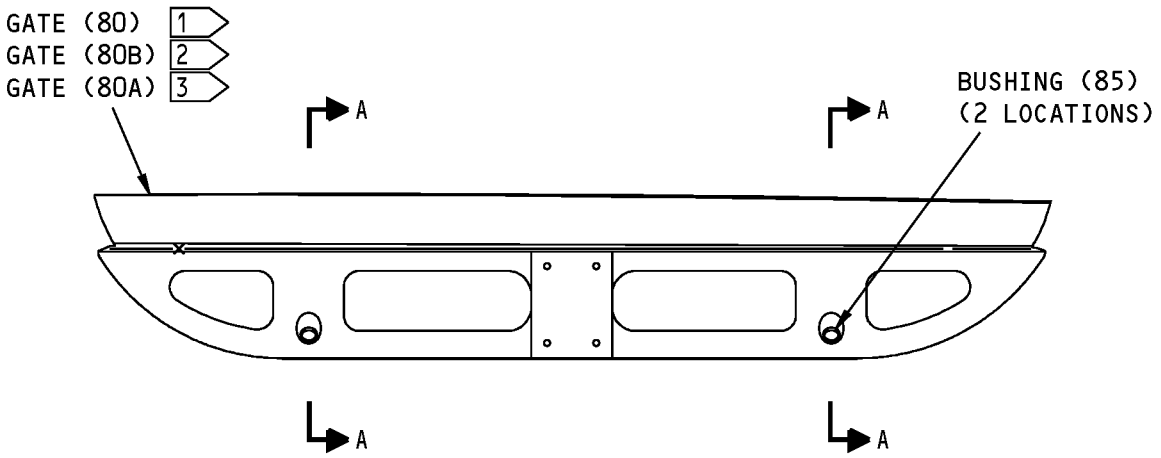
C. Procedure (REPAIR 15-1, Figure 601)

(1) Remove the bushings (85) from the gate (80) as specified in SOPM 20-50-03.

(2) Install the new bushings (85) into the gate (80) with sealant, A00247 as specified in SOPM 20-50-03.

(3) Flare the bushings (85) 10-15 degrees and then fillet seal each end with sealant, A00247 (SOPM 20-60-04).

(4) After the bushings (85) are flared, they must be flush with the faying surfaces.



147A6146-2 SHOWN
147A6146-8,-12 ALMOST THE SAME

A-A

1 FOR 147A6146-2

2 FOR 147A6146-12

3 FOR 147A6146-8

ITEM NUMBERS REFER TO IPL FIG. 5

147A6146-2,-8,-12 End Gate Assembly
Figure 601

(LOWER) CONTROL ROD CLEVIS ASSEMBLY - REPAIR 15-2

147A6144–1

1. General

A. This procedure has the data necessary to repair the (lower) control rod assembly (15).

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

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

D. Refer to IPL Figure 5 for the item numbers.

2. Bushing Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

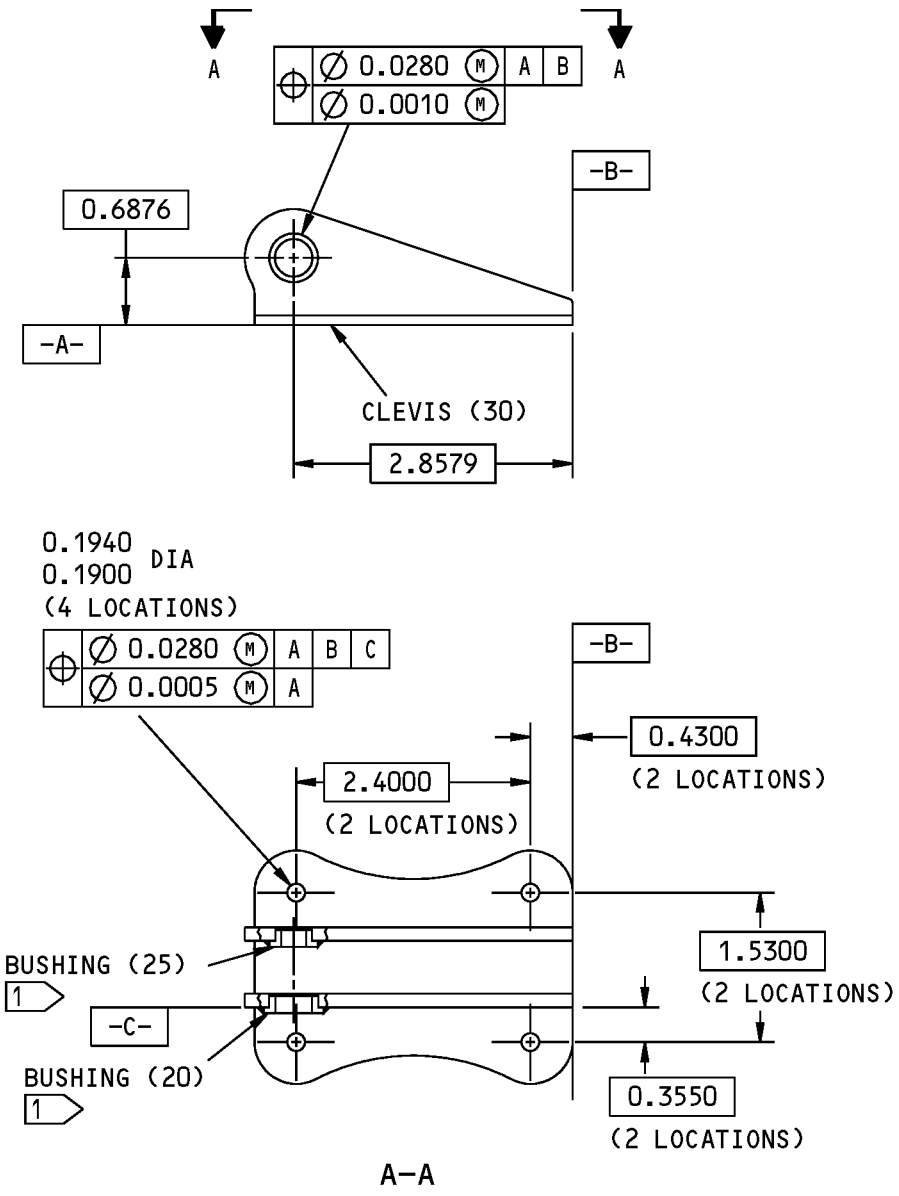
Reference	Title
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-50-19	GENERAL SEALING

C. Procedure

(1) Remove the bushings (20, 25) from the clevis (30) as shown in REPAIR 15-2, Figure 601.

(2) Install the replacement bushings (20, 25) into the clevis (30) with sealant, A00247 as specified in SOPM 20-50-03.

(3) Fillet seal each end of the bushings (20, 25) with sealant, A00247 as specified in SOPM 20-50-19.



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

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 4

ALL DIMENSIONS ARE IN INCHES

147A6144-1 Clevis Assembly Repair
Figure 601

(LOWER) CLEVIS - REPAIR 15-3

147A6144–3

1. General

A. This procedure has the data necessary to repair the (lower) clevis (30).

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

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

D. Refer to IPL Figure 5 for the item numbers.

E. General repair details:

(1) Material: Aluminum Alloy

2. Clevis Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

C. Procedure

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

(1) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.35).

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

(LOWER) GATE - REPAIR 15-4

147A6146–4, –10, –14

1. General

A. This procedure has the data necessary to repair the (lower) gate (90).

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

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

D. Refer to IPL Figure 5 for the item numbers.

E. General repair details:

(1) Material: Magnesium Alloy

2. Gate Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

C. Procedure

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

(1) Anodize (F-17.12).

(2) Apply primer, C00259 (SOPM 20-60-02) (F-20.03).

(3) Apply enamel coating, C00032 (SOPM 20-60-02) (SRF-14.9813). Internal surfaces can be finished by the fill and drain procedure. Do not put enamel in the holes for the bushings and bolts.

LOWER AND UPPER TUBE ASSEMBLY - REPAIR 16-1

147A6139–2, –4

1. General

A. This procedure has the data necessary to repair the lower and upper tube assembly (125, 130).

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

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

D. Refer to IPL Figure 5 for the item numbers.

2. Bearing Replacement

A. References

Reference	Title
SOPM 20-50-01	BOLT AND NUT INSTALLATION
SOPM 20-50-02	INSTALLATION OF SAFETYING DEVICES
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT

B. Procedure

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

(1) Remove the cotter pins (132) from the nuts (135) and cam follower bearings (145).

(2) Remove the nuts (135), washers (140), and cam follower bearings (145) from the cranks (165).

(3) Install the cam follower bearings (145), washers (140) and nuts (135) onto the cranks (165).

(4) Tighten the nuts (135) to 65 - 90 pound-inches. Install the cotter pins (132) onto the cam follower bearings (145) (SOPM 20-50-03) and nuts (135) as specified in SOPM 20-50-02.

ROLLER CAM CRANK - REPAIR 16-2

69-37418–11

1. General

A. This procedure has the data necessary to refinish the roller cam crank (165).

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

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

D. Refer to IPL Figure 5 for the item numbers.

E. General repair details:

(1) Material: Aluminum Alloy

2. Roller Cam Crank (165) 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

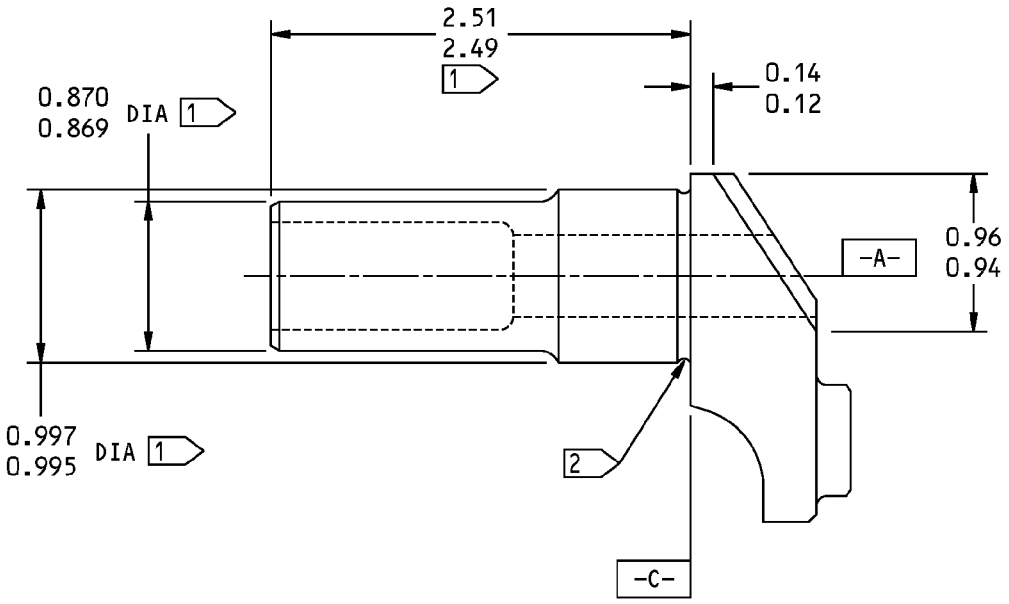
NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01.

(1) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.35).

(2) Apply primer, C00259 (SOPM 20-60-02) (F-20.02). Do not put primer on the surfaces identified by flagnote 1 in REPAIR 16-2, Figure 601.

(3) Apply enamel coating, C00260 (F-21.03). Do not put primer on the surfaces identified by flagnote 1 in REPAIR 16-2, Figure 601.

(a) Overspray is permitted on surfaces identified by flagnote 2 in REPAIR 16-2, Figure 601.



1 DO NOT PUT PRIMER OR ENAMEL ON THIS SURFACE

2 OVERSPRAY IS PERMITTED ON THIS SURFACE

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

69-37418-11 Roller Cam Crank Refinish
Figure 601

GATE CRANK - REPAIR 16-3

66-14531–12

1. General

A. This procedure has the data necessary to refinish the gate crank (185).

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

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

D. Refer to IPL Figure 5 for the item numbers.

E. General repair details:

(1) Material: 15-5PH CRES, 150-170 ksi

2. Crank Refinish

A. References

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

B. Procedure

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

(1) Passivate (F-17.09) crank.

LATCH TORQUE TUBE - REPAIR 16-4

60-4406–16, –17

1. General

A. This procedure has the data necessary to refinish the latch torque tube (200, 205).

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

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

D. Refer to IPL Figure 5 for the item numbers.

E. General repair details:

(1) Material: 15-5PH CRES, 150-170 ksi

2. Latch Torque Tube Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

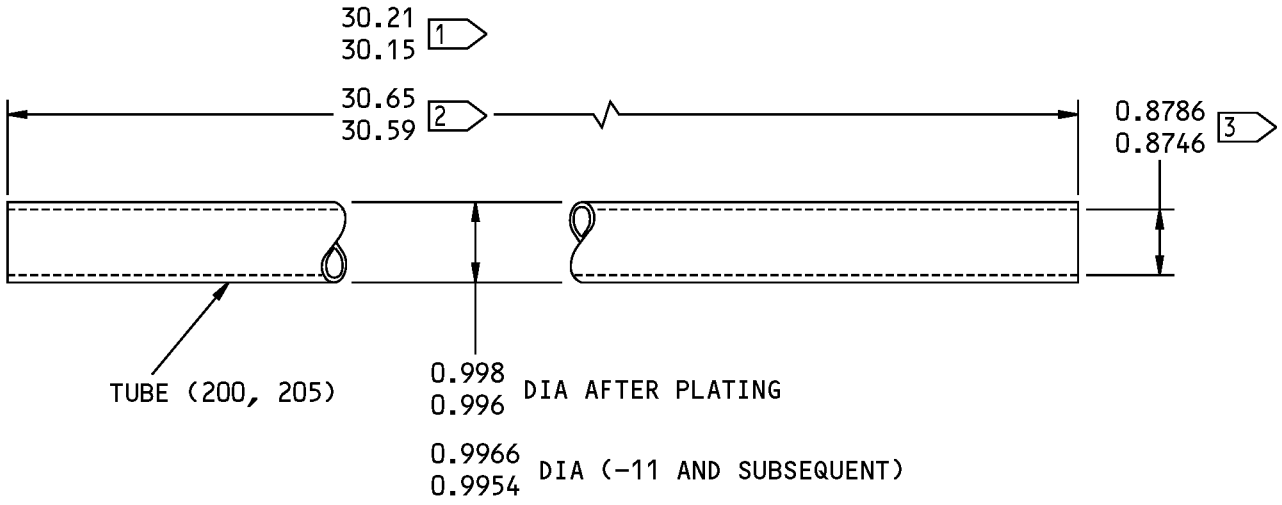
Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES

C. Procedure

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

(1) Cadmium plate (F-15.06) the internal and external surfaces of the torque tubes to the dimensions shown in REPAIR 16-4, Figure 601.

(2) Apply primer, C00259 (F-20.48) to the internal surface only.



1 FOR 60-4406-16

2 FOR 60-4406-17

3 DIMENSION APPLIES FOR A DISTANCE OF 1.54-1.66 INCHES FROM EACH END OF THE TUBE

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 3

ALL DIMENSIONS ARE IN INCHES

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

LATCH SUPPORT FITTING ASSEMBLY - REPAIR 17-1

147A6138–2, –4, –6, –8, –20, –24, –28, –32

1. General

A. This procedure has the data necessary to repair the latch support fitting assembly (35, 40, 45, 50).

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

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

D. Refer to IPL Figure 2 for the item numbers.

2. Lube Fitting Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

Reference	Title
SOPM 20-60-04	MISCELLANEOUS MATERIALS

C. Procedure

(1) Remove the lube fitting (55) from the support fitting (60, 65, 70, 75).

(2) Install the new lube fitting (55) into the support fitting (60, 65, 70, 75) with sealant, A00247 (SOPM 20-60-04).

LATCH SUPPORT FITTING - REPAIR 17-2

147A6138–10, –12, –14, –16, –18, –22, –26, –30

1. General

A. This procedure has the data necessary to repair the latch support fitting (60, 65, 70, 75).

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

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

D. Refer to IPL Figure 2 for the item numbers.

E. General repair details:

(1) Material: Aluminum Alloy

2. Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

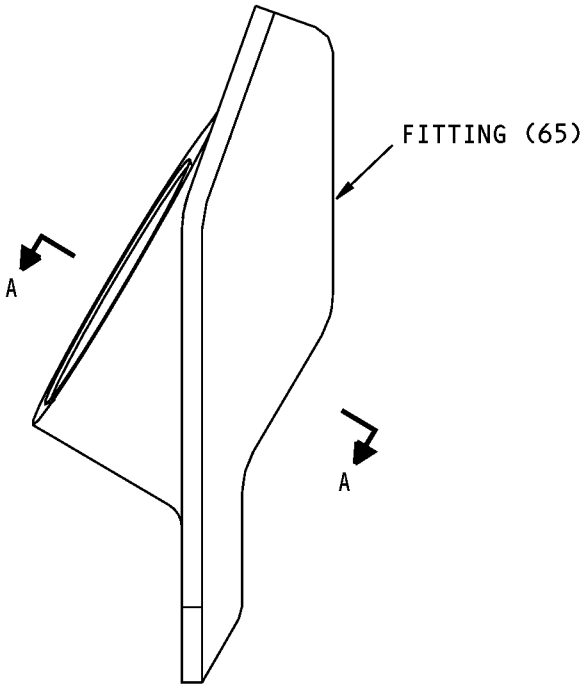
Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES

C. Procedure

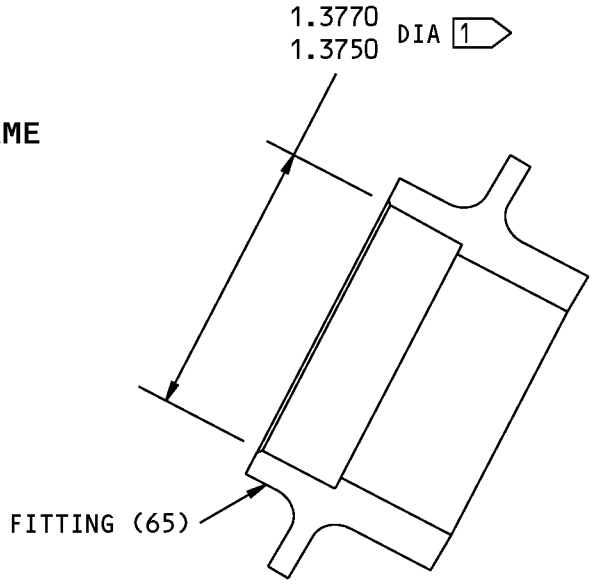
NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01.

(1) Boric acid-sulfuric-acid anodize or chromic acid anodize (F-17.35) all surfaces.

(2) Apply primer, C00259 (F-20.03) to all surfaces but not in the area identified by flagnote 1 in REPAIR 17-2, Figure 601.



FITTING (65) SHOWN
FITTING (60,70,75) ALMOST THE SAME



A–A

1 DO NOT APPLY PRIMER OR PAINT IN THIS AREA

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

147A6138-10,-12,-14,-16,-18,-22,-26,-30 Latch Support Fitting Refinish
Figure 601

CENTERING GUIDE ASSEMBLY - REPAIR 18-1

147A6130–1

1. General

A. This procedure has the data necessary to repair the centering guide assembly (235).

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

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

D. Refer to IPL Figure 5 for the item numbers.

2. Bearing Replacement (REPAIR 18-1, Figure 601)

A. References

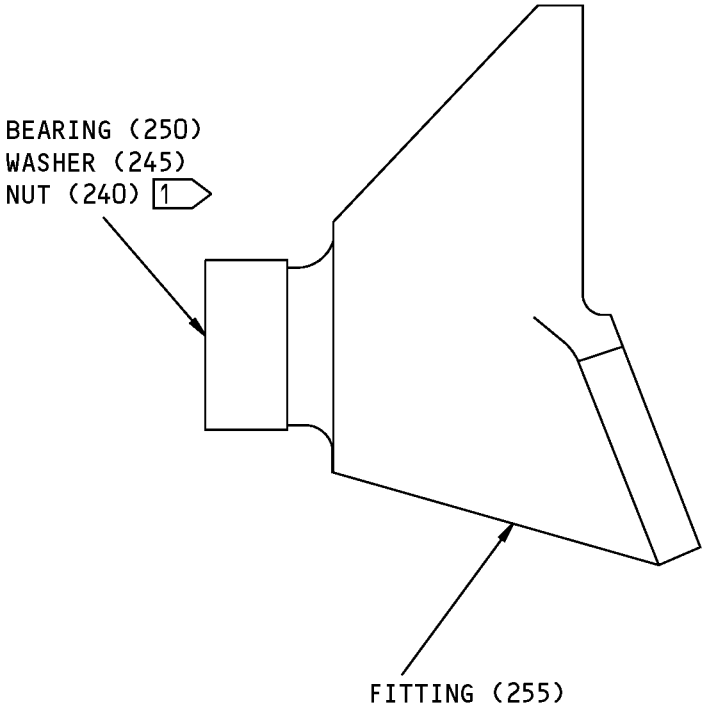
Reference	Title
SOPM 20-50-01	BOLT AND NUT INSTALLATION
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT

B. Procedure

(1) Remove the nut (240), washer (245), and bearing (250) from the fitting (255).

(2) Install the replacement bearing (250), washer (245), and nut (240) onto the fitting (255) as specified in SOPM 20-50-03.

(a) Tighten the nut to 100 to 150 pound-inches as specified in SOPM 20-50-01.



1 TIGHTEN THIS NUT TO 100-150 POUND-INCHES

ITEM NUMBERS REFER TO IPL FIG. 2

147A6130-1 Centering Guide Assembly Repair
Figure 601

FITTING - REPAIR 18-2

147A6130–2

1. General

A. This procedure has the data necessary to repair the fitting (255).

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

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

D. Refer to IPL Figure 5 for the item numbers.

E. General repair details:

(1) Material: Aluminum Alloy

2. Fitting Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

C. Procedure

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

(1) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.35) all surfaces.

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

HANDLE RECESS PAN ASSEMBLY - REPAIR 19-1

147A6137–4

1. General

A. This procedure has the data necessary to repair the handle recess pan assembly (390).

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

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

D. Refer to IPL Figure 5 for the item numbers.

2. Seal Plate (405) Replacement (REPAIR 19-1, Figure 601)

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 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-60-02	FINISHING MATERIALS

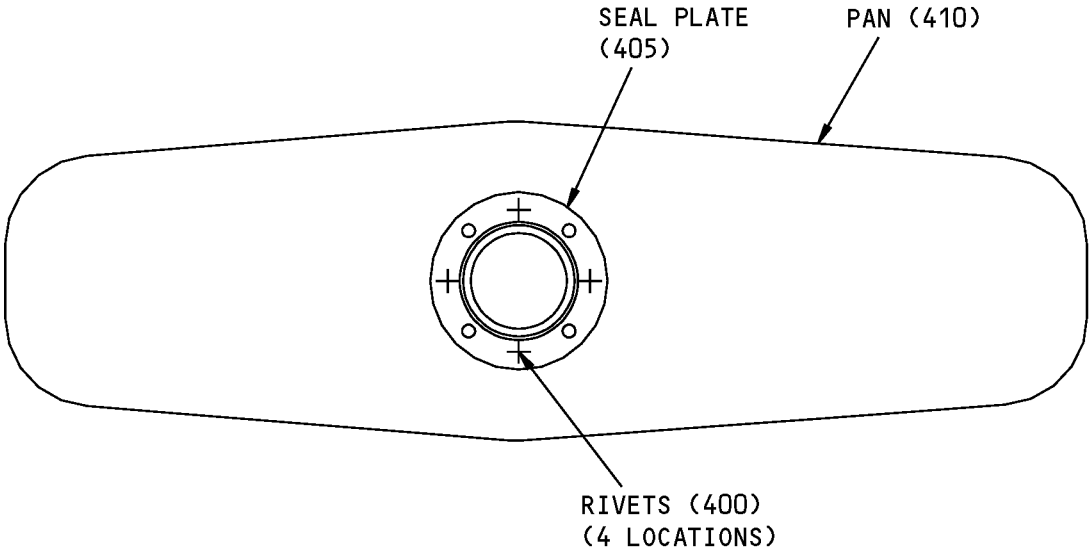
C. Procedure

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

(1) Remove the seal plate (405) from the pan (410).

(2) Apply a pressure fay surface seal with sealant, A00247 (SOPM 20-60-02) between the surfaces of the seal plate (405) and the pan (410).

(3) Attach the seal plate (405) to the pan (410) with rivets (400).



ITEM NUMBERS REFER TO IPL FIG. 2

147A6137-4 Handle Recess Pan Assembly Repair
Figure 601

EXTERNAL HANDLE PAN - REPAIR 19-2

147A6137–6

1. General

A. This procedure has the data necessary to repair the external handle pan (410).

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

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

D. Refer to IPL Figure 5 for the item numbers.

E. General repair details:

(1) Material: Aluminum Alloy

2. Exterior Handle Pan Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

C. Procedure

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

(1) Chemical treat (F-17.07).

(2) Apply primer, C00259 (F-20.03).

SEAL PLATE - REPAIR 19-3

149A6121–1

1. General

A. This procedure has the data necessary to refinish the seal plate (405).

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

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

D. Refer to IPL Figure 5 for the item numbers.

E. General repair details:

(1) Material: Aluminum Alloy

2. Seal Plate Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

C. Procedure

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

(1) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31) all surfaces of the seal plate (405).

(2) Apply primer, C00259 (SOPM 20-60-02) (F-20.03) to all surfaces of the seal plate (405).

HOUSING ASSEMBLY - REPAIR 20-1

149A6107–3

1. General

A. This procedure has the data necessary to repair the housing assembly (365).

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

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

D. Refer to IPL Figure 5 for the item numbers.

2. Bushing (395) Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

C. Procedure

(1) Remove the bushings (395) from the housing (410).

(2) Install the new bushings (395) into the housing (410) with wet sealant, A00247 (SOPM 20-60-04) as specified in SOPM 20-50-03.

(3) Machine the bushing inner diameter to the dimension shown in REPAIR 20-1, Figure 601.

3. Nutplate (380, 405) Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

Reference	Title
SOPM 20-50-19	GENERAL SEALING

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

(1) Remove the rivets (375, 400) and damaged nutplates (380, 405) from the housing (410).

(2) If necessary, replace the fillers (385, 390) as follows:

(a) Remove the rivets (370) and the fillers (385, 390).

(b) Install the fillers (385, 390) with wet sealant, A00247 as specified in SOPM 20-50-19.

1) Make sure to fill the spaces between the filler and the housing (410).

2) Put sealant, A00247 on the shank of rivets (370) and install the rivets (370) (see flagnote 8).

(3) Install the new nutplates (380, 405) as follows:

(a) Install the nutplates with wet sealant, A00247 faying surface sealant as specified in SOPM 20-50-19 (see flagnote 4).

(b) Install the rivets (375, 400) with wet sealant, A00247 as specified in SOPM 20-50-19, method 2.

1) Put sealant, A00247 on the shank of rivets (375, 400) before insertion.

2) Make sure the rivets (375) are flush (+0.0000/-0.0100 inch) with fillers (385, 390) (see flagnote 5).

4. Housing Assembly (365) Refinish

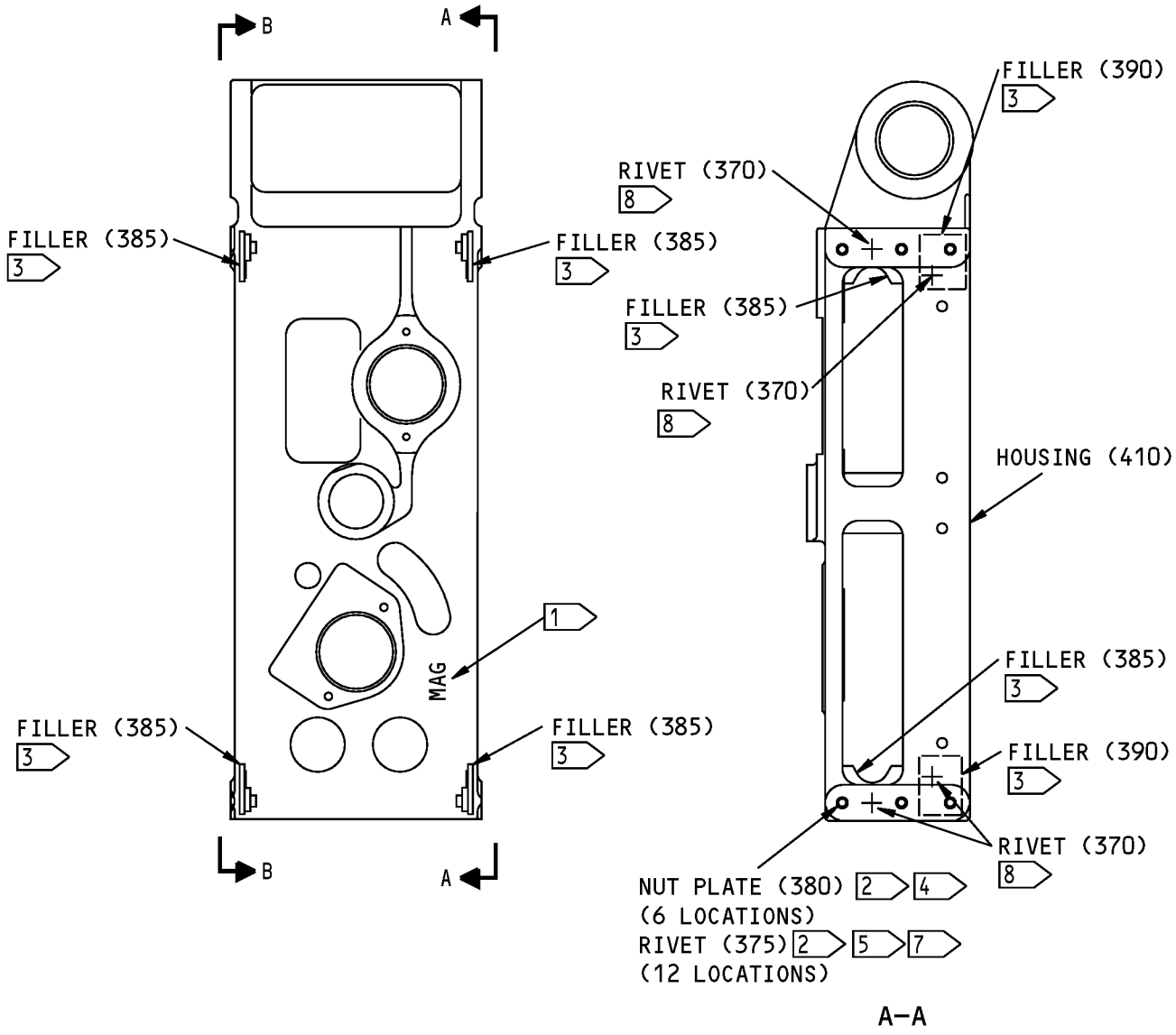
A. Apply enamel coating, C00032 (F-14.9813) after the bushings have been installed but do not put enamel in the locations that follow:

(1) The inner diameters of the bushings.

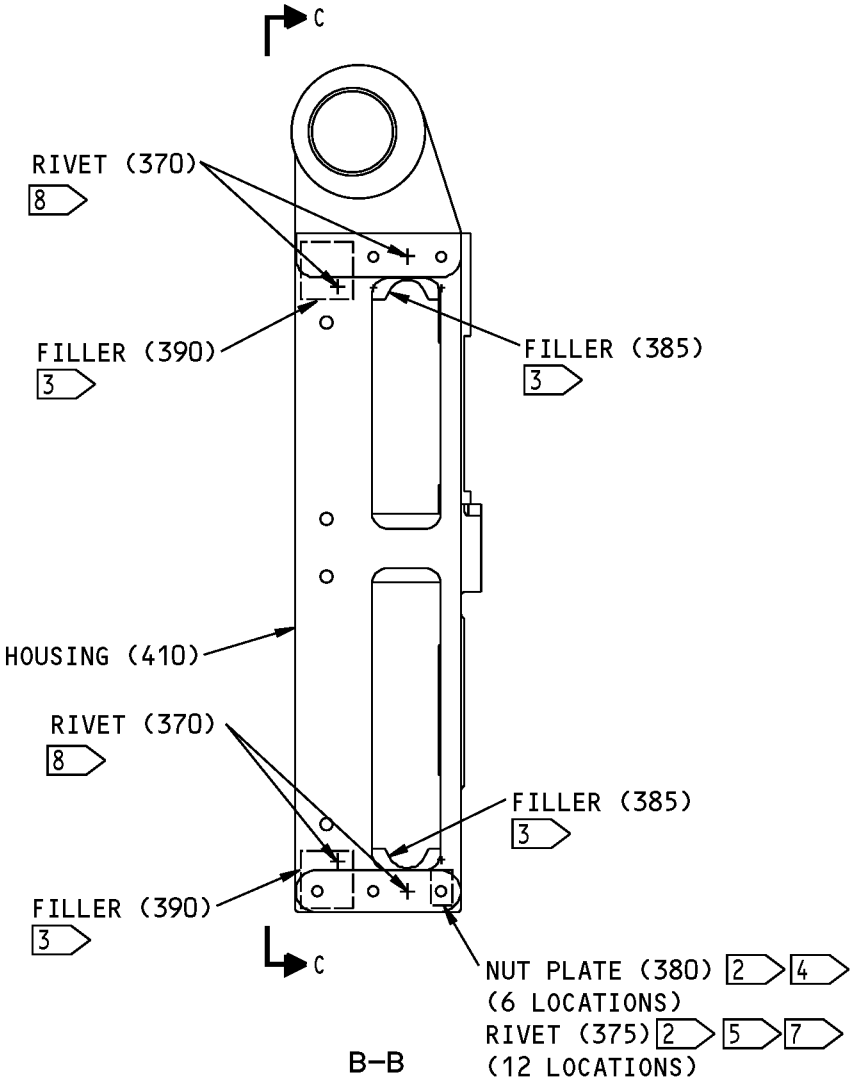
(2) The 1.3775, 1.6258, 2.3130 or 2.3750 inch diameter holes.

(3) The holes for the nutplates (16 locations).

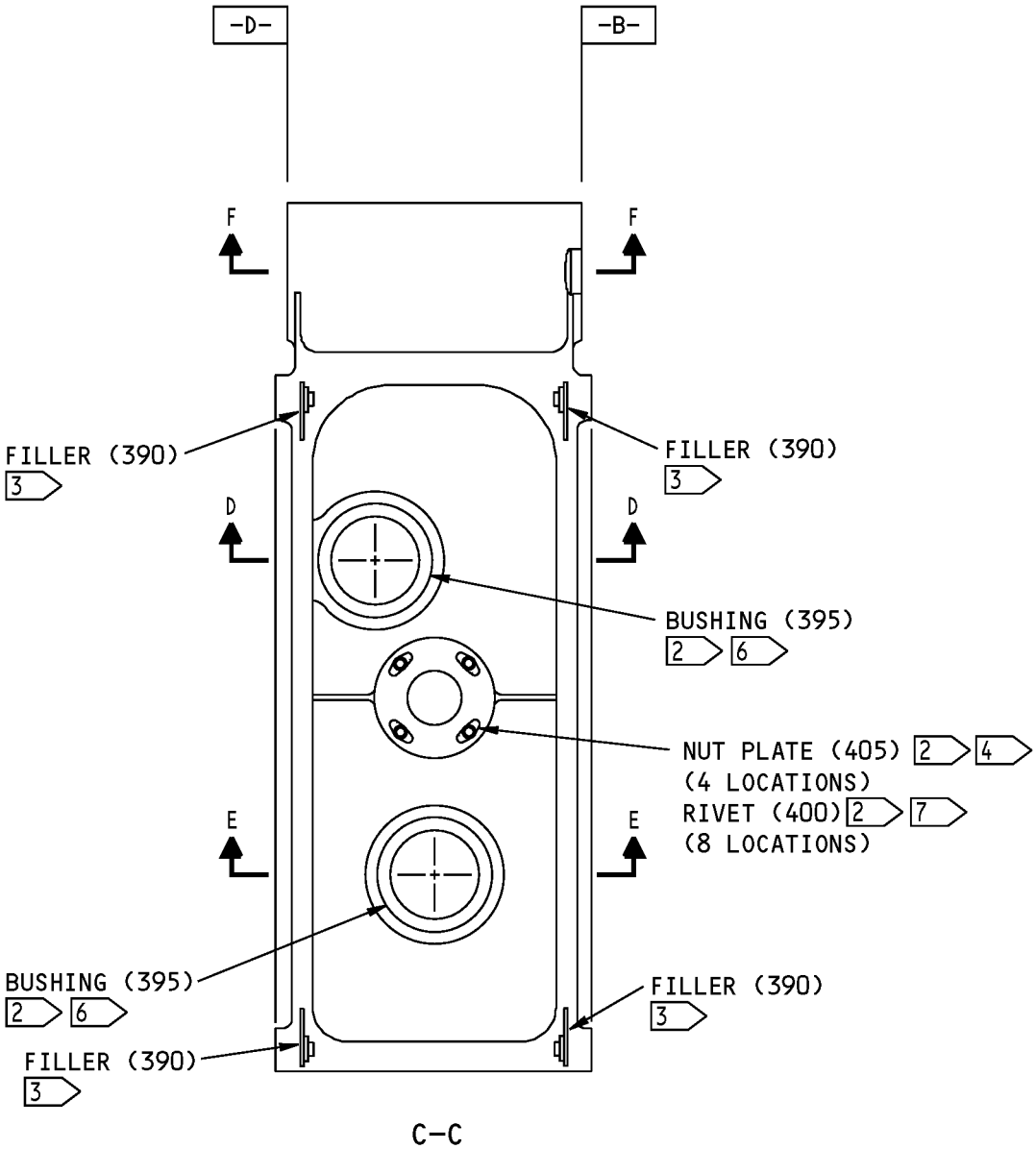
B. Rubber stamp the letters "MAG" to the surface shown in REPAIR 20-1, Figure 601 as specified in SOPM 20-50-10. Make the letters 0.3800 inch minimum.



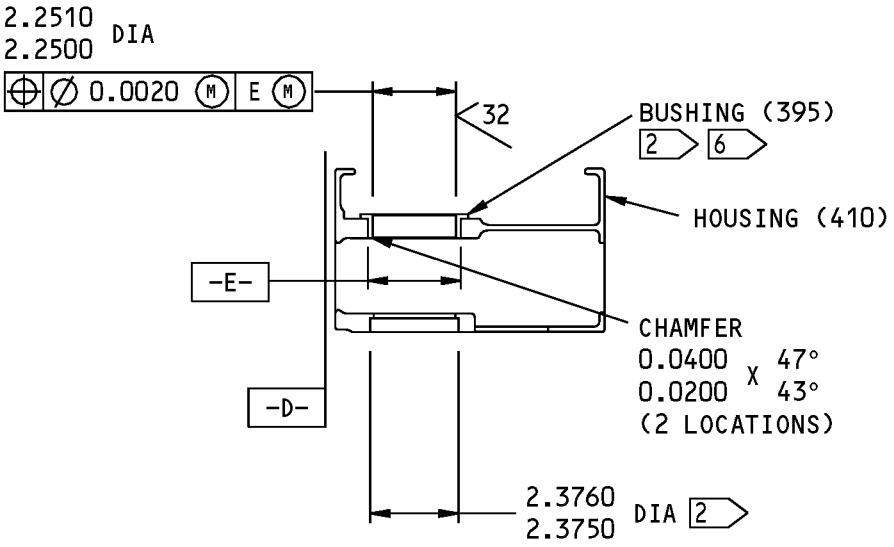
149A6107-3 Housing Assembly
Figure 601 (Sheet 1 of 5)



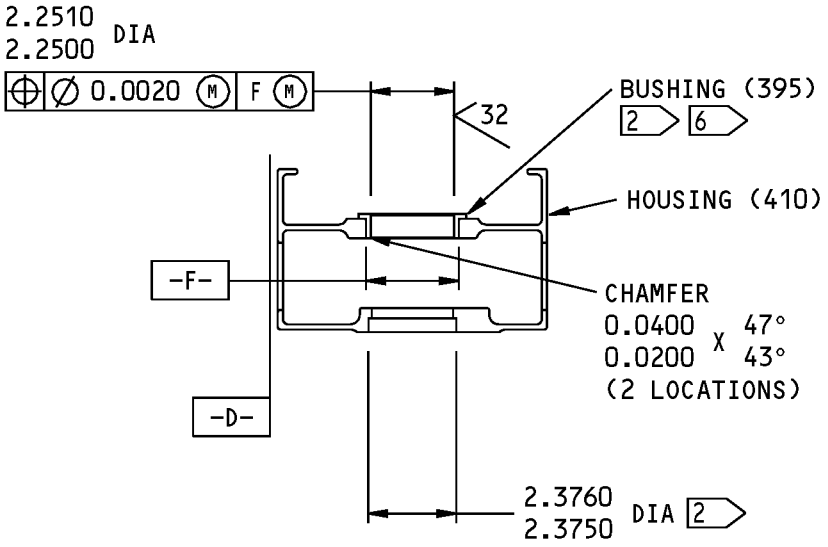
149A6107-3 Housing Assembly
Figure 601 (Sheet 2 of 5)



149A6107-3 Housing Assembly
Figure 601 (Sheet 3 of 5)

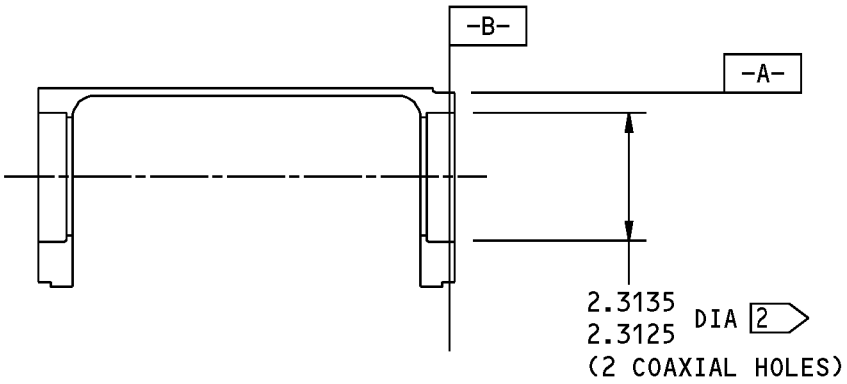


D-D



E-E

149A6107-3 Housing Assembly
Figure 601 (Sheet 4 of 5)



F-F

1 RUBBER STAMP LETTERS 'MAG' HERE

2 DO NOT PUT ENAMEL IN THIS HOLE

3 INSTALL THIS FILLER WITH WET BMS 5-95 SEALANT AS SPECIFIED IN SOPM 20-50-19

4 INSTALL THIS NUTPLATE WITH WET BMS 5-95 FAYING SURFACE SEALANT AS SPECIFIED IN SOPM 20-50-19

5 THIS RIVET IS TO BE FLUSH (+0.0000 TO -0.0100 INCHES) WITH THE FILLER

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

7 INSTALL THIS RIVET WITH WET BMS 5-95 SEALANT AS SPECIFIED IN SOPM 20-50-19, METHOD 2

8 PUT BMS 5-95 SEALANT ON THE SHANK OF THE RIVET BEFORE INSERTION

ITEM NUMBERS REFER TO IPL FIG. 7

ALL DIMENSIONS ARE IN INCHES

149A6107-3 Housing Assembly
Figure 601 (Sheet 5 of 5)

HOUSING - REPAIR 20-2

149A6107–6

1. General

A. This procedure has the data necessary to refinish the housing (410).

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

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

D. Refer to IPL Figure 5 for the item numbers.

E. General repair details:

(1) Material: Magnesium alloy

2. Housing (410) Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

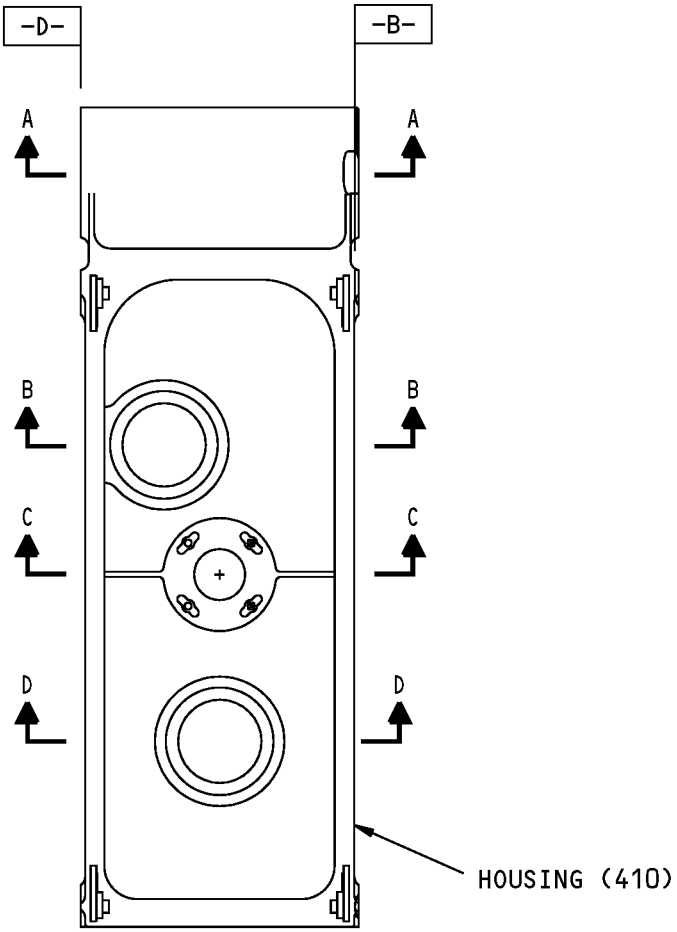
Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

C. Procedure (REPAIR 20-2, Figure 601)

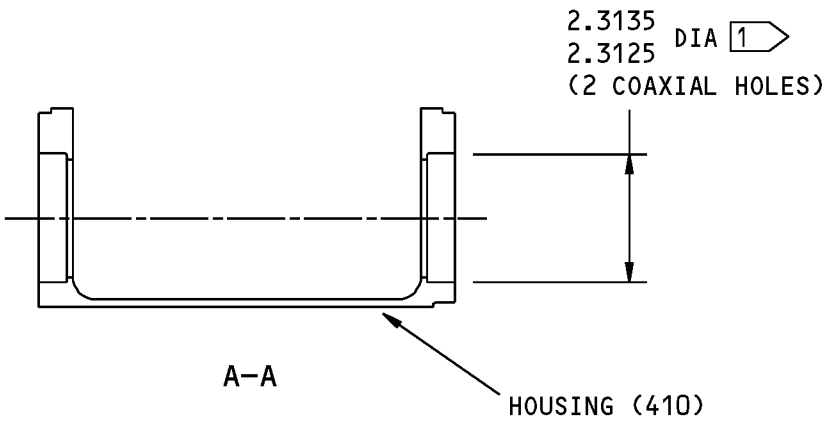
NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For the decoding table for Boeing finish codes, refer to SOPM 20-41-01.

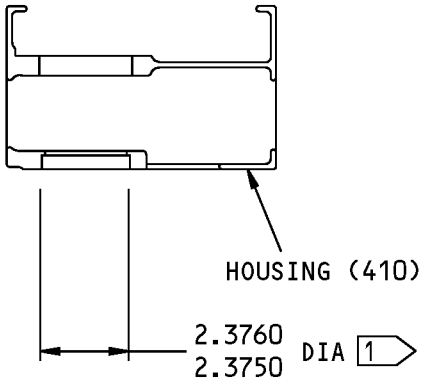
(1) Anodize (F-17.12).

(2) Apply primer, C00259 (SOPM 20-60-02) (F-20.03) to all surfaces but only one layer to the surfaces identified by flagnote 1.

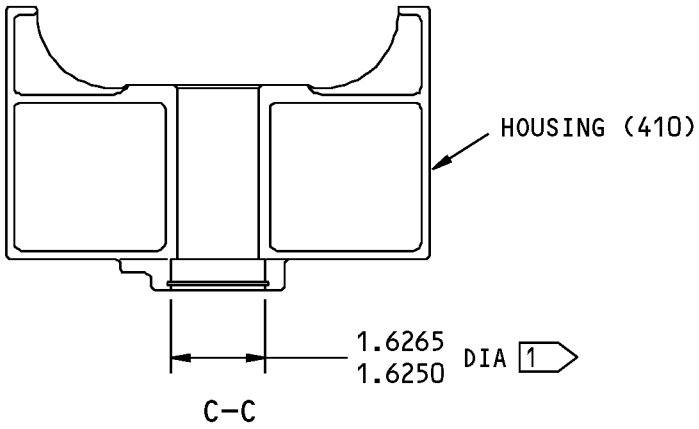


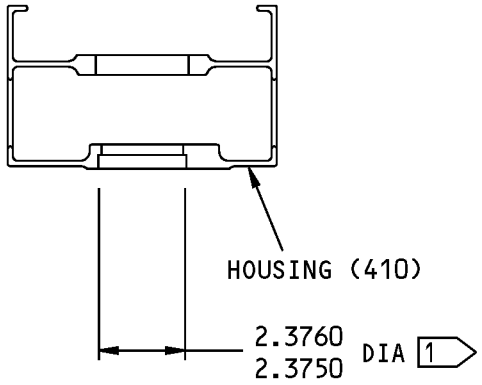
149A6107-6 Housing Assembly
Figure 601 (Sheet 1 of 3)





149A6107-6 Housing Assembly
Figure 601 (Sheet 2 of 3)





1 APPLY ONLY ONE LAYER OF PRIMER TO THESE SURFACES

ITEM NUMBERS REFER TO IPL FIG. 8

ALL DIMENSIONS ARE IN INCHES

149A6107-6 Housing Assembly
Figure 601 (Sheet 3 of 3)

SHAFT - REPAIR 21-1

60-4455–3

1. General

A. This procedure has the data necessary to refinish the shaft (165).

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

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

D. Refer to IPL Figure 5 for the item numbers.

E. General repair details:

(1) Material: 15-5PH CRES, 150-170 ksi

2. Shaft (165) Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
D50081	Lubricant - Solid Film Lubricant, Liquid Dispersed	BMS 3-8

B. References

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

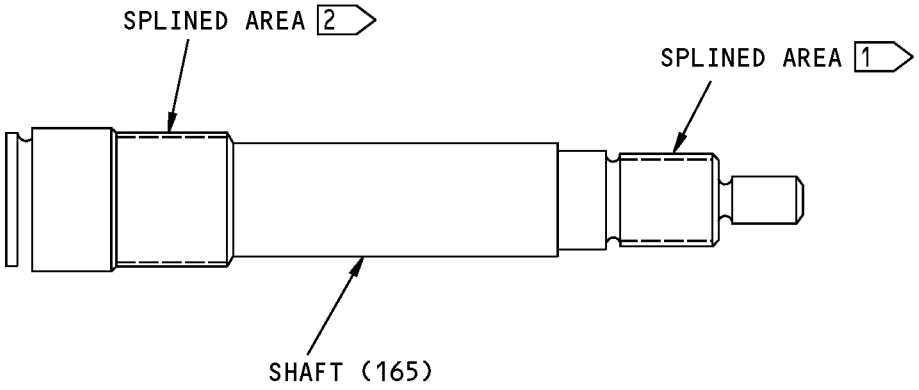
C. Procedure

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

(1) Passivate (F-17.25) all surfaces.

(2) Cadmium plate (F-15.06) on the smaller diameter splined surface shown by flagnote 1 in (REPAIR 21-1, Figure 601).

(3) Apply solid film lubricant, D50081 (SOPM 20-60-03) as specified in SOPM 20-50-08, Type VIII, on the larger diameter splined surface shown by flagnote 2 in (REPAIR 21-1, Figure 601).



1 CADMIUM PLATE (F-15.06) THIS SPLINED AREA

2 APPLY BMS 3-8 SOLID FILM LUBRICANT, AS SPECIFIED IN SOPM 20-50-08 TYPE VIII, ON THIS SPLINED AREA

ITEM NUMBERS REFER TO IPL FIG. 7

ALL DIMENSIONS ARE IN INCHES

60-4455-3 Shaft Refinish
Figure 601

HANDLE MECHANISM HOUSING ASSEMBLY - REPAIR 22-1

149A6120–1

1. General

A. This procedure has the data necessary to repair the handle mechanism housing assembly (100).

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

C. Refer to IPL Figure 7 for the item numbers.

2. Fitting (105) Replacement

A. Procedure

(1) Remove the fitting (105) from the housing fitting (110).

(2) Install the new fitting (105) into the housing fitting (110).

(HANDLE MECHANISM) HOUSING FITTING - REPAIR 22-2

149A6120–2

1. General

A. This procedure has the data necessary to refinish the (handle mechanism) housing fitting (110).

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

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

D. Refer to IPL Figure 7 for the item numbers.

E. General repair details:

(1) Material: 4340 Steel, 125-145 ksi

2. Fitting (110) Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

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

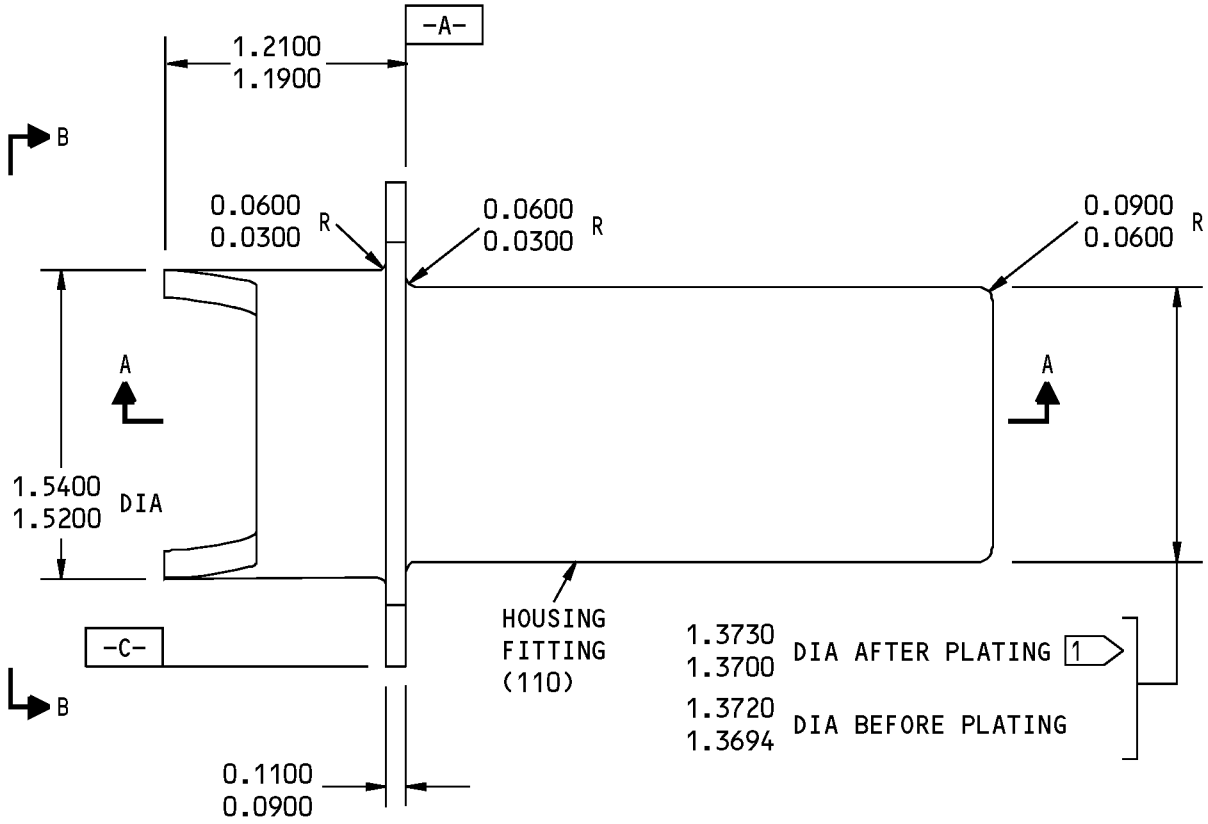
C. Procedure (REPAIR 22-2, Figure 601)

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

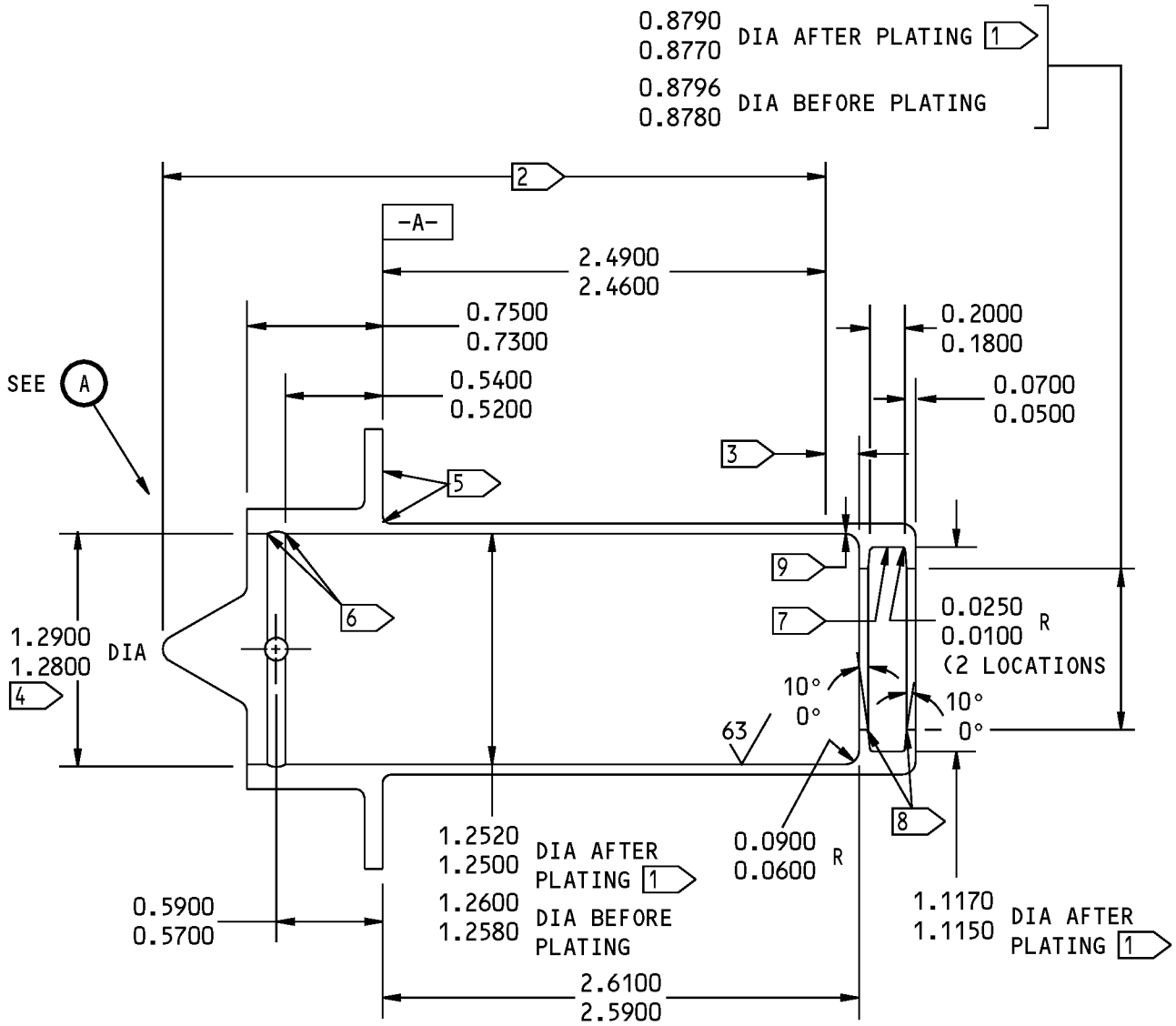
(1) Cadmium plate (F-15.06) but not in the areas shown by flagnote 2.

(2) Chromium plate (F-15.03) in the areas shown by flagnote 2.

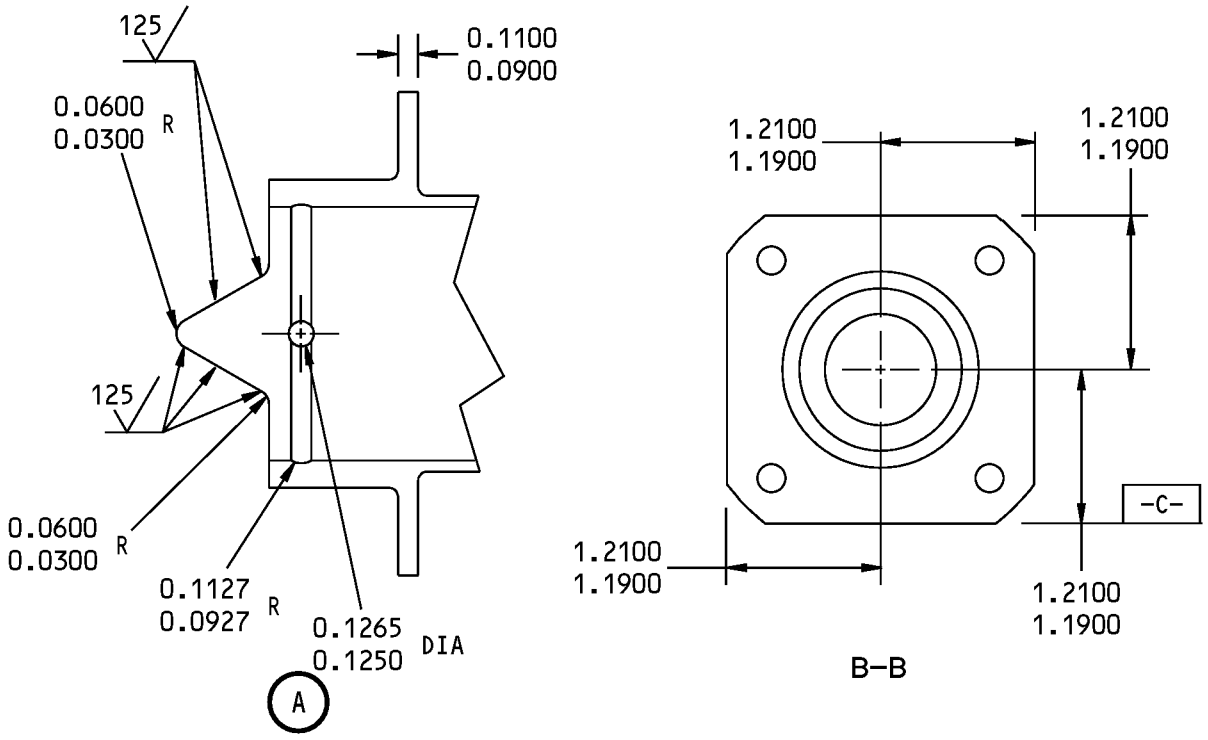
(3) Apply primer, C00259 (SOPM 20-60-02) (F-20.03) in the areas shown by flagnote 5.



149A6120-2 Handle Mechanism Housing Fitting Refinish
Figure 601 (Sheet 1 of 3)



149A6120-2 Handle Mechanism Housing Fitting Refinish
Figure 601 (Sheet 2 of 3)



1 THESE DIAMETERS MUST BE CONCENTRIC WITHIN 0.003 TIR

2 CHROMIUM PLATE THE INNER DIAMETER IN THIS AREA

3 CHROMIUM PLATE RUNOUT IN THE INNER DIAMETER IS PERMITTED IN THIS AREA

4 CUT A GROOVE AFTER THE CHROMIUM PLATE IS APPLIED

5 APPLY BMS 10-11, TYPE 1 PRIMER (F-20.03) TO THIS SURFACE

6 BREAK EDGES OF CHROME PLATE RADIUS 0.0200

7 ALL GROOVE SURFACE 32 MICROINCHES

8 BREAK EDGE RADIUS 0.0050

9 0.0000-0.0100 MISMATCH ALLOWED IN THIS AREA AFTER GRINDING

250 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 7

ALL DIMENSIONS ARE IN INCHES

149A6120-2 Handle Mechanism Housing Fitting Refinish
Figure 601 (Sheet 3 of 3)

ASSEMBLY

1. General

A. This procedure has the data necessary to assemble the aft galley door.

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 8 for the item numbers.

2. Assembly

A. Tools/Equipment

NOTE: Equivalent substitutes may be used.

Reference	Description
SPL-1981	Tool - Installation, Door Seal (Part #: B52004-1, Supplier: 81205) (Part #: K52011-1, Supplier: 81205)
SPL-10299	Setting Tool - Fwd Entry Door Latch Rollers (Part #: F80178-1, Supplier: 81205)

B. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00119	Adhesive - Synthetic Rubber Cement, Naphtha Soluble	BMS5-55
A00153	Adhesive - Low Odor, Synthetic Rubber, 1 Part	BMS 5-30
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95
B50080	Compound - Corrosion Preventive, Solvent Cutback, Cold-Application (Grade 2 - Soft Film)	MIL-PRF-16173, Grade 2 (Supersedes MIL-C-16173, Grade 2)
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I
D00015	Grease - Aircraft Bearing (Use BMS 3-24 until existing stocks are depleted, BMS 3-33 supersedes BMS 3-24)	BMS3-24 (Superseded by BMS 3-33)

C. References

Reference	Title
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-41-02	APPLICATION OF CHEMICAL AND SOLVENT RESISTANT FINISHES
SOPM 20-41-05	APPLICATION OF CORROSION INHIBITING COMPOUNDS
SOPM 20-50-01	BOLT AND NUT INSTALLATION

Reference	Title
SOPM 20-50-02	INSTALLATION OF SAFETYING DEVICES
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-50-05	APPLICATION OF ALUMINUM FOIL AND OTHER MARKERS
SOPM 20-50-06	INSTALLATION OF O-RINGS AND TEFLON SEALS
SOPM 20-50-07	LUBRICATION
SOPM 20-50-08	APPLICATION OF BONDED SOLID FILM LUBRICANTS
SOPM 20-50-12	APPLICATION OF ADHESIVES
SOPM 20-50-19	GENERAL SEALING
SOPM 20-50-20	HOW TO MAKE AND INSTALL RESIN BOND LAMINATED SHIMS AND SOLID FILLERS
SOPM 20-50-22	HOW TO INSTALL THREADED INSERTS
SOPM 20-60-02	FINISHING MATERIALS
SOPM 20-60-03	LUBRICANTS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

D. Procedure

NOTE: For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For application of corrosion inhibiting compounds, refer to SOPM 20-41-05. For application of solid-film lubricant, refer to SOPM 20-50-08.

(1) Use standard industry procedures and the steps that follow to assemble this component.

(2) Install the centering channel assembly (290, IPL Figure 2) and the centering guide assembly (235) on the door structure, as follows:

(a) Apply sealant, A00247 (SOPM 20-60-04) between the mating surfaces of the channel assembly (305), fillers (265), and the door structure.

(b) If not done, countersink the holes in the serrated plate (260) to be flush (±0.0050) with the bottom of the counterbore.

(c) Install the channel assembly (290), filler (265), and serrated plate (260) on the door structure with the bolts (215).

(d) Install the centering guide assembly (235) on the door structure with the bolts (210) and washers (220).

(3) Assemble and install the window assembly (356, 358, IPL Figure 1; 1A, IPL Figure 3; 1A, IPL Figure 8) on the door structure, as follows:

(a) Assemble the window assembly (1A, IPL Figure 3) as follows:

1) Put the sponge rubber seal (35) on the retainer (55). Cement the seal (35), as shown in ASSEMBLY, Figure 701, flagnote 1, with adhesive, A00119 or adhesive, A00153 as specified in SOPM 20-50-12.

2) Put the inner pane (45) into the new seal (40).

3) Put the seal (40) and the inner pane (45) into the retainer (55) with the pane marking as shown by flagnote 3 of ASSEMBLY, Figure 701. Make sure that the hole in the seal (40) aligns with the slot in the retainer (55) as shown in flagnote 2 of ASSEMBLY, Figure 701.

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

4) Put the new outer pane (50) into the seal (40) with the pane marking as shown by flagnote 3 of ASSEMBLY, Figure 701.

5) Install the shims (25, 30), clips (20), screws (5), washers (10), and nuts (15) on the retainer as specified in SOPM 20-50-01.

a) Adjust the thickness of the shims (25, 30) to give a maximum compression of 0.03 inch of the seal (40) (see flagnote 4 in ASSEMBLY, Figure 701).

b) Apply primer, C00259 (SOPM 20-60-02) to the shims when you get the correct thickness and before installation.

(b) Assemble the window assembly (1A, IPL Figure 8) as follows:

1) Put the sponge rubber seal (35) on the retainer (40). Cement the seal (35), as shown in ASSEMBLY, Figure 702, flagnote 1, with adhesive, A00119 or adhesive, A00153 as specified in SOPM 20-50-12.

2) Put the inner pane (55) into the new seal (45).

3) Put the seal (45) and the inner pane (55) into the retainer (40) with the pane marking as shown by flagnote 2 of ASSEMBLY, Figure 702.

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

4) Put the new outer pane (50) into the seal (45) with the pane marking as shown by flagnote 2 of ASSEMBLY, Figure 702.

5) Install the shims (20, 25), clips (30), screws (5), washers (10), and nuts (15) on the retainer as specified in SOPM 20-50-01.

a) Adjust the thickness of the shims (20, 25) to give a maximum compression of 0.03 inch of the seal (45) (see flagnote 3 in ASSEMBLY, Figure 702).

b) Apply primer, C00259 (SOPM 20-60-02) to the shims (20, 25) when you get the correct thickness and before installation.

(c) Install the window assembly (356, 358, IPL Figure 1) on the door structure with the bolts (340) and the washers (344).

(d) The outer pane of the window assembly (356, 358) can be 0.0500 inch in or 0.0300 inch out from the outer surface of the doubler (384).

(4) Install the handle box assembly (612, IPL Figure 1; 1A, IPL Figure 7) on the door structure, as follows:

(a) Assemble the external handle (20, IPL Figure 7) and shaft assembly (130), as follows:

1) Assemble the external handle (20), shims (25), sleeve (30), and centering cam (35) with the bolts (5), washers (10), and nuts (15).

2) Assemble the shaft assembly (130) as follows:

a) Install the pin (160) through the compression spring (155), and the nut (150) and into the washer (140). Make sure that the holes in the pin (160) and the holes in the washer (140) are aligned.

b) Install the retaining pin (135) into the holes in the washer (140) and the pin (160).

c) Apply grease, D00015 (SOPM 20-60-03) to the threads of the nut (150).

d) Install the nut (150) into the shaft (165). Make sure that the groove in the nut (150) is aligned with the hole in the shaft (165). Make sure that the nut recess in the shaft is not more than 1/2 of the turn.

e) Install the lock ring (145) on the shaft (165).

3) Put the shaft assembly (130) into the sleeve (30) with the washer (140) against the handle (20).

(b) Assemble the housing assembly (365) as follows:

1) Refer to REPAIR 8-1 for the instructions to install the bearings (345) on the crank arms (350, 355).

2) Install the bearing (125) into the housing (410) as follows:

a) Install the bearing (125) as specified in SOPM 20-50-03 with sealant, A00247.

b) Fillet seal each end of the bearing.

c) Safety the bearing in the housing (410) with the ring (120).

3) Install the bearings (360) into the housing (410) as follows:

a) Install the bearings (360) as specified in SOPM 20-50-03 with sealant, A00247.

b) Fillet seal each end of the bearing.

4) Install the bearings (240) into the housing (410) as follows:

a) Install the bearings (240) as specified in SOPM 20-50-03 with sealant, A00247.

b) Fillet seal each end of the bearing.

c) Install the bearing retainers (235) with the bolts (205, 210, 215, 220), washers (225) and nuts (230).

d) Install the bolts (205, 210, 215, 220), washers (225) and nuts (230) with wet sealant, A00247 as specified in SOPM 20-50-19.

5) Install the bearings (270) into the housing (410) as follows:

a) Install the bearings (270) as specified in SOPM 20-50-03 with sealant, A00247.

b) Fillet seal each end of the bearing.

6) Install the door latching crank assembly (300) into the housing (410) as follows:

a) Apply a thin layer of compound, B50080 to the mating surfaces of the door latching crank assembly (300) and the cam follower assembly (325).

b) Put the door latching crank assembly (300) and the washer (260) in the housing (410).

c) Put the cam follower assembly (325) into the housing (410) through the bearing (240), door latching assembly (300), washer (260), and bearing (270).

d) Apply grease, D00015 (F-19.16) to the bolt (245).

e) Apply primer, C00259 (F-20.201) as specified in SOPM 20-41-02 to all areas of the hole of the washer (250).

f) Install the cam follower assembly (325) in the housing (410) with the bolt (245), washers (250, 255), and nut (265).

7) Install the door cocking crank assembly (275) into the housing (410) as follows:

a) Apply a thin layer of compound, B50080 to the mating surfaces of the door cocking crank assembly (275) and the cam follower assembly (320).

b) Put the door cocking crank assembly (275), washer (260), and spacer ring (295) in the housing (410).

c) Put the cam follower assembly (320) into the housing (410) through the bearing (240), spacer ring (295), door cocking assembly (275), washer (260), and bearing (270).

d) Apply grease, D00015 (F-19.16) to the bolt (245).

e) Apply primer, C00259 (F-20.201) as specified in SOPM 20-41-02 to all areas of the hole of the washer (250).

f) Install the cam follower assembly (320) in the housing (410) with the bolt (245), washers (250, 255), and nut (265).

8) Install the push rod assembly (180) into the housing (410) as follows:

a) Lubricate the rod ends (195) with grease, D00015 as specified in SOPM 20-50-07.

b) Apply grease, D00015 (F-19.16) to the bolt (170).

c) Apply primer, C00259 (F-20.201) to all areas of the hole of the washer (175) as specified in SOPM 20-41-02.

d) Attach the push rod assembly (180) to the door cocking crank assembly (275) with the bolt (170) and the washer (175).

(c) Install the handle box assembly (612, IPL Figure 1) into the door structure as follows:

1) Apply a corrosion preventive fay surface seal with sealant, A00247 as specified in SOPM 20-50-19 to the mating surfaces of the handle box assembly (612, IPL Figure 1), the shims (616, IPL Figure 1), and the door structure.

a) Install shims (616, IPL Figure 1) as specified in SOPM 20-50-20, if and as necessary, to decrease the clearance between the handle box assembly and the door structure. The shims must be parallel to the handle box assembly and the door structure. The maximum permitted clearance is 0.0100 inch.

2) Install the handle box assembly (612, IPL Figure 1) in the door structure with the bolts (600, IPL Figure 1) and the washers (608, IPL Figure 1).

a) Install the bolts (600, IPL Figure 1) and the washers (608, IPL Figure 1) with sealant, A00247 as specified in SOPM 20-50-19.

(d) Install the external handle (20, IPL Figure 7) and shaft assembly (130) as follows:

1) Apply compound, B50080 to the mating surfaces of the handle mechanism housing assembly (100) and the handle mechanism sleeve (30).

2) Lubricate and install the packing (115) into the groove in the housing assembly (100) as specified in SOPM 20-50-06.

3) Put the housing assembly (100), with the lube fitting (105) pointed forward or aft, through the door structure and into the housing (410).

4) Attach the housing assembly (100) with the bolts (90), washers (95) and packing (97).

a) Install the bolts (90) finger tight.

b) Install the housing assembly (100) with grease, D00015 on all surfaces.

5) Move the external handle (20) and attached components into the handle mechanism housing assembly (100).

6) Apply grease, D00015 to the mating surfaces of the control cam assembly (60) and the shaft (165).

a) Also put some grease, D00015 in the recessed area at the end of the shaft (165).

7) Install the control cam assembly (60) to the shaft (165) with the washers (45, 50, 55) and the nut (40).

a) Install the nut (40) finger tight.

8) Tighten the nut (40) to 93-110 pound-inches to align the nut clevis to the hole in the shaft (165).

9) Install the cotter pin (592, IPL Figure 1) as specified in SOPM 20-50-02.

(5) Install the hinge support assemblies (628, 632, IPL Figure 1) as follows:

(a) If necessary, install the fitting (672, 676) as specified in REPAIR 11-1.

(b) Apply a pressure fay surface seal with sealant, A00247 as specified in SOPM 20-50-19 to the mating surfaces of the door structure and the hinge support assemblies (628, 632).

(c) Install the hinge support assemblies (628, 632) with bolts (620) and nuts (624).

(6) Install the torque tube assembly (1A, IPL Figure 6) to the door structure, as follows:

(a) Apply grease, D00015 to the packing (564, IPL Figure 1).

(b) Apply a thin layer of grease, D00015 to all mating surfaces and threads of the door structure, crank (90), and torque tube (95).

(c) Put the crank (90) between the bearings (360, IPL Figure 7) in the door structure. Install the torque tube (95) in the door structure through the bearings (360, IPL Figure 7) and the crank (90).

(d) Attach the crank (90) to the torque tube (95) with the bolts (75), washers (80) and nuts (85).

1) The bolt direction is important to prevent interference. The bolt head must be on the inboard side of the door. Make sure that the bolts do not touch the door structure.

2) Substitution of the bolt (75) grip length is not permitted.

(e) Apply a thin layer of grease, D00015 to the mating surfaces and threads of the special nuts (70) and the torque tube (95).

(f) Install the special nuts (70) on the torque tube (95). Tighten the special nuts (70) to hold the crank (90) in its position between the bearings (360, IPL Figure 7).

(g) Appy a thin layer of grease, D00015 to the mating surfaces and threads of the sleeves (55, 60) hinge link pins (65), and the torque tube (95).

(h) Install a compression spring (572, IPL Figure 1), washer (568, IPL Figure 1), and packing (564, IPL Figure 1) on each hinge link pin (65).

(i) Put the sleeves (55, 60) on the torque tube (95).

(j) Put the hinge link pins (65) through the bushings (688, IPL Figure 1) in the door structure.

(k) Attach the sleeves (55, 60) and the hinge link pins (65) with the bolts (40), washers (45), and nuts (50). Tighten the nuts (50) to 30 to 40 pound-inches.

NOTE: The nut (50) is to tighten on the bolt (40) threads to prevent clamp up. The maximum distance between the sleeve (55, 60) and the washer (45) is 0.0160 inch. Install more washers if necessary.

(l) Apply a thick layer of grease, D00015 to the mating surfaces of the arm assemblies (15, 20) and the hinge link pins (65). When the installation is complete, fill the area between the arm assemblies (15, 20) and the hinge support assemblies (628, 632, IPL Figure 1) with grease, D00015.

(m) Install the arm assemblies (15, 20) on the hinge link pins (65) with the bolts (5) and washers (10). Install the bolts as specified in SOPM 20-50-01 with grease, D00015 on all surfaces.

(7) Install the lower and upper tube assemblies (125, 130, IPL Figure 2) into the door structure.

(a) Install the lower tube assembly (130, IPL Figure 2), as follows:

1) Move the lower tube (205) into the door structure through the support fitting assemblies (45, 50), housing assemblies (105), latch crank (195), and gate crank (185).

2) Attach the latch crank (195) to the tube assembly (205) with the bolts (170), washers (175), and nuts (180).

3) Attach the gate crank (185) to the tube assembly (205) with the bolts (170), washers (175), and nuts (180).

4) Install the bearings (10) with grease, D00015 as specified in SOPM 20-50-03.

NOTE: To keep a maximum of 0.015 inch total end play, install an equal number of spacers (5) at each end of the tube (205). It is permitted to have one extra spacer on one end of the tube (205) to stay in the tolerance.

5) Move the roller cam cranks (165) through the latch roller spacers (5) and the bearing (10) and into the tube (205).

6) Attach the roller cam cranks (165) with the bolts (150), washers (155), and nuts (160). Tighten the nuts (160) to 35-45 pound-inches.

NOTE: The nut (160) is to tighten on the bolt (150) threads to prevent clamp up. The maximum distance between the tube (205) and the washer (155) is 0.0160 inch. Install more washers if necessary.

(b) Install the upper tube assembly (125, IPL Figure 2), as follows:

1) Move the upper tube (200) into the door structure through the support fitting assemblies (35, 45), housing assemblies (105), latch crank (190), and gate crank (185).

2) Attach the latch crank (190) to the tube assembly (200) with the bolts (170), washers (175), and nuts (180).

3) Attach the gate crank (185) to the tube assembly (200) with the bolts (170), washers (175), and nuts (180).

4) Install the bearings (10) with grease, D00015 as specified in SOPM 20-50-03.

NOTE: To keep a maximum of 0.015 inch total end play, install an equal number of spacers (5) at each end of the tube (200). It is permitted to have one extra spacer on one end of the tube (200) to stay in the tolerance.

5) Move the roller cam cranks (165) through the latch roller spacers (5) and the bearing (10) and into the tube (200).

6) Attach the roller cam cranks (165) with the bolts (150), washers (155), and nuts (160). Tighten the nuts to 35-45 pound-inches.

NOTE: The nut (160) is to tighten on the bolt threads to prevent clamp up. The maximum distance between the tube (200) and the washer (155) is 0.0160 inch. Install more washers if necessary.

(8) Install the upper and lower control rod assemblies (532, 536, IPL Figure 1) to the door structure, as follows:

NOTE: The length of the control rod assemblies (532, 536) will be adjusted in the door assembly adjustment instructions (par. 2.D(12)).

(a) Put the control rod assembly (532) between the clevis of the latching crank assembly (300, IPL Figure 7) and the clevis of the latch crank (190, IPL Figure 2).

(b) Attach the control rod assembly (532) with the bolts (512, 516), washer (520, 524) and nut (528).

(c) Put the control rod assembly (536) between the clevis of the latching crank assembly (300, IPL Figure 7) and the clevis of the latch crank (185, IPL Figure 2).

(d) Attach the control rod assembly (536) with the bolts (512, 516), washers (520, 524) and nut (528).

(9) Install the upper and lower end gate assemblies (464, 468, IPL Figure 1) to the door structure:

(a) Install the upper end gate assembly (464, IPL Figure 1) to the door structure, as follows:

1) Apply sealant, A00247 as specified in SOPM 20-50-19 to the mating surfaces of the hinge assembly (484) and the door structure.

2) Put and align the hinge half (500) of the hinge assembly (484) on the edge of the door structure beam.

CAUTION: THERE CAN BE NO BURRS ON THE BOLT HEADS (472, 476) AFTER INSTALLATION.

3) Install the upper gate assembly (464, IPL Figure 1) on the door structure with the bolts (472, 476) and the washers (480).

(b) Install the lower end gate assembly (468, IPL Figure 1) on the door structure, as follows:

1) Apply sealant, A00247 as specified in SOPM 20-50-19 to the mating surfaces of the hinge assembly (488) and the door structure.

2) Put and align the hinge half (504) of the hinge assembly (488) on the edge of the door structure beam.

CAUTION: THERE CAN BE NO BURRS ON THE BOLT HEADS (472, 476) AFTER INSTALLATION.

3) Install the lower gate assembly (468, IPL Figure 1) on the door structure with the bolts (472, 476) and the washers (480).

(10) Use door seal installation tool, SPL-1981, to install the seal (456, IPL Figure 1) and nylon rod (452) onto the door structure, as follows:

(a) Install the seal (456) with soap lubricant as specified in SOPM 20-50-07. Install the seal with the label TOP on the top side of the door and the label BOTTOM on the bottom side of the door. Install the seal evenly around the periphery of the door structure.

(b) Install the seal (456) and the nylon rod (452) onto the hinge assembly (484, 488) with soap lubricant as specified in SOPM 20-50-07. Install the nylon rod (452) at each end of the hinge assembly (484, 488) to form a butt-fit at the center of the door structure. If necessary, trim the unwanted nylon rod (452).

(11) Install the upper and lower control rod assemblies (420, 424, IPL Figure 1) on the door structure, as follows:

(a) Put the control rod assembly (420) between the clevis of the upper end gate assembly (464, IPL Figure 1) and the arm of the gate crank assembly (185, IPL Figure 2).

(b) Attach the control rod assembly (420) with the bolts (388, 392), washer (396, 400, 404), bushing (416), and nuts (408, 412).

(c) Put the control rod assembly (424) between the clevis of the lower end gate assembly (468, IPL Figure 1) and the clevis of the gate crank (195, IPL Figure 2).

(d) Attach the control rod assembly (424) with the bolts (388, 392), washers (396, 400, 404), bushing (416) and nuts (408, 412).

(12) Install the cover plates (204, 208, 212, IPL Figure 1), the retainer (248), and the stops (100, 104) on the door structure, as follows:

(a) Install the cover plate (204) as follows:

1) Apply a parting agent to the mating surfaces of the cover plate (204) as specified in SOPM 20-50-19.

2) Apply a pressure fay surface seal with sealant, A00247 as specified in SOPM 20-50-19 between the mating surfaces of the cover plate and the inner skin.

3) Install the cover plate (204) onto the door structure with the bolts (180) and the washers (184).

NOTE: Grip length is important. It is not permitted to use a bolt with a grip length different than bolt (180).

(b) Install the cover plate (208) onto the door structure with the bolts (182) and the washers (184).

NOTE: Grip length is important. It is not permitted to use a bolt with a grip length different than bolt (182).

(c) Install the cover plate (212) on the door structure with the bolts (182) and the washers (184).

NOTE: Grip length is important. It is not permitted to use a bolt with a grip length different than bolt (182).

(d) Install the retainer (248) on the door structure as specified in SOPM 20-50-22 with the studs (240) and washers (244).

(e) Install the stops (100, 104) on the door structure with the bolts (84), washers (88), and nuts (92).

(13) Adjust the door assembly mechanism as follows:

(a) With the control rod assemblies (532, 536, IPL Figure 1) not connected to the cranks (190, 195, IPL Figure 2), install the latch roller setting tool, SPL-10299 through the holes in the door inner skin.

(b) Adjust the tool until the notches in the clamp feet engage the latching cranks on the torque tube.

(c) Turn the torque tube assemblies (125, 130, IPL Figure 2) until the bearings (145) touch the setting blocks on the tool. Tighten the tool clamps. Make sure that the bearings (145) touch the blocks on the tool.

(d) Turn the handle (20, IPL Figure 7) to the closed position. The bearing (345, IPL Figure 7) on the latching crank assembly (300, IPL Figure 7) must bottom out in the cam plate assembly (85, IPL Figure 7). Secure the handle (20, IPL Figure 7) in this position.

(e) Adjust the lengths of the control rod assemblies (532, 536, IPL Figure 1) to align the rod ends with the holes in the latching cranks (190, 195, IPL Figure 2).

(f) Attach the control rod assemblies (532, 536, IPL Figure 1) to the latching cranks (190, 195, IPL Figure 2) with the bolts (516, IPL Figure 1), washers (524, IPL Figure 1), and nuts (528, IPL Figure 1).

(g) With the control rod assemblies (420, 424, IPL Figure 1) not connected to the clevis assemblies (25, IPL Figure 4; 30, IPL Figure 5), hold the upper and lower gate assemblies (464, 468, IPL Figure 1) in the faired position in relation to the outer door assembly contour.

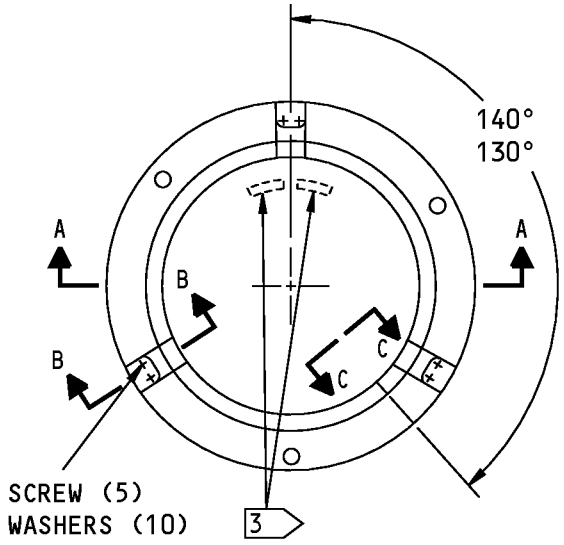
(h) Adjust the lengths of the control rod assemblies (420, 424, IPL Figure 1) to align the rod ends with the holes in the clevis assemblies (25, IPL Figure 4; 30, IPL Figure 5).

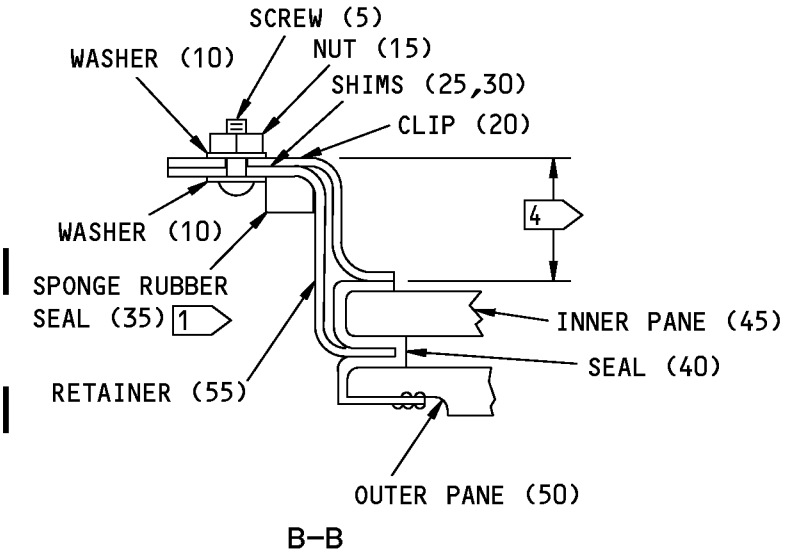
(i) Attach the control rod assemblies (420, 424, IPL Figure 1) to the clevis assemblies (25, IPL Figure 4; 30, IPL Figure 5) with the bolts (388, IPL Figure 1), washers (396, 400, IPL Figure 1), bushings (416, IPL Figure 1), and nuts (408, IPL Figure 1).

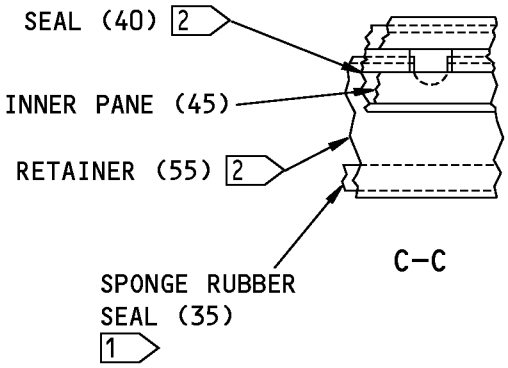
(j) Tighten the nuts (448, 544, IPL Figure 1) on the control rod assemblies (420, 424, 532, 536, IPL Figure 1) as specified in SOPM 20-50-01.

(k) Remove the latch roller setting tool, SPL-10299 from the door assembly.

(14) If necessary, install the plate (990, IPL Figure 2) and the marker (985, IPL Figure 2) to the door structure as specified in SOPM 20-50-05.







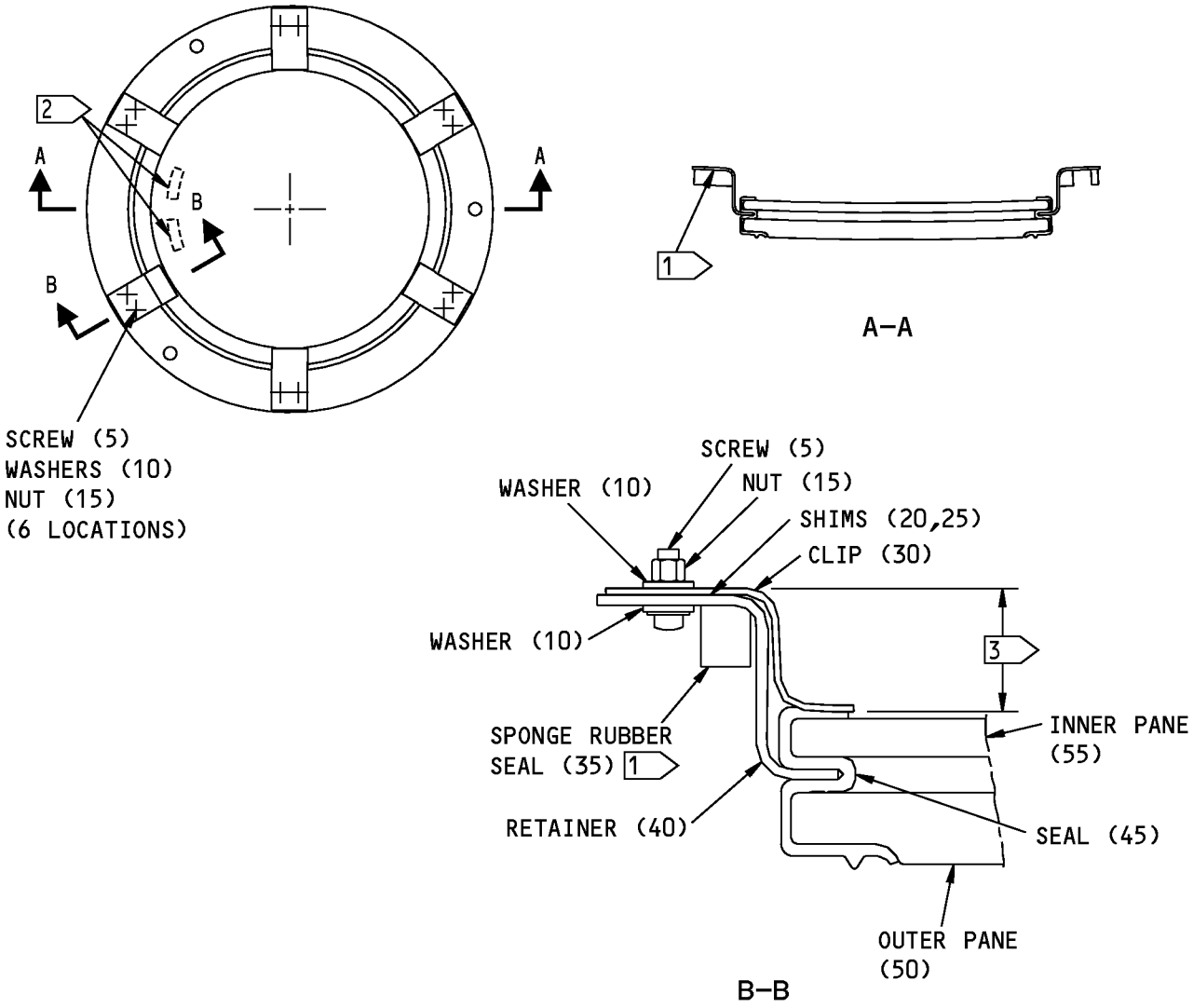
1. ATTACH THE SEAL (35) WITH BMS 5-55 OR BMS 5-30
2. ALIGN THE HOLE IN THE SEAL WITH THE SLOT IN THE RETAINER
3. INSTALL THE WINDOW PANES WITH THE MARKINGS IN THIS POSITION
4. ADD SHIMS (25,30) AS NECESSARY FOR A MAXIMUM COMPRESSION OF 0.03 INCH OF THE SEAL (40)

ITEM NUMBERS REFER TO IPL FIG. 3

ALL DIMENSIONS ARE IN INCHES

W60850 S00041002032_V2

65-2863-8 Observation Window Assembly
Figure 701



1 ATTACH THE SEAL (35) WITH BMS 5-55 OR BMS 5-30

2 INSTALL THE WINDOW PANES WITH THE MARKINGS IN THIS POSITION

3 ADD SHIMS (20,25) AS NECESSARY FOR A MAXIMUM COMPRESSION OF 0.03 INCH OF THE SEAL (45)

ITEM NUMBERS REFER TO IPL FIG. 8

ALL DIMENSIONS ARE IN INCHES

1632437 S0000299923_V1

141A6570-1 Observation Window Assembly
Figure 702

FITS AND CLEARANCES

REF IPL		NAME	TORQUE*	
FIG. NO.	ITEM NO.		POUND-INCHES	POUND-FEET
1	428	Nut	60 MAX	
1	544	Nut	60 MAX	
2	135	Nut	65-90	
2	160	Nut	35-45	
2	240	Nut	100-150	
4	20	Nut	25-30	
5	5	Bolt	25-30	
6	50	Nut	30-40	
7	40	Nut	93-110	

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

Torque Table
Figure 801

SPECIAL TOOLS, FIXTURES, AND EQUIPMENT

1. General

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

NOTE: Equivalent substitutes may be used.

Special Tools

Reference	Description	Part Number	Supplier
SPL-1981	Tool - Installation, Door Seal	B52004-1 K52011-1	81205 81205
SPL-10293	Wrench - Door Handle Mechanism Unit	F70038	81205
SPL-10295	SPANNER WRENCH - BEARING RETAINER NUT	F70085	81205
SPL-10299	Setting Tool - Fwd Entry Door Latch Rollers	F80178-1	81205

Tool Supplier Information

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

ILLUSTRATED PARTS LIST

1. Introduction

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

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

1 2 3 4 5 6 7

. Assembly

. Attaching parts for assembly

. . Detail parts for assembly

. . Subassembly

. . Attaching parts for subassembly

. . . Detail parts for subassembly

. . . Sub-subassembly

. . . Attaching parts for subassembly

. . . . . Details parts for sub-subassembly

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

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

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

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

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

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

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

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

H. Interchangeable Parts

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

VENDOR CODES

Code	Name
02758	NETWORKS ELECTRONIC CORP U S BEARING DIV 9750 DE SOTO AVENUE CHATSWORTH, CALIFORNIA 91311-4409 FORMERLY U S BEARING DIV NETWORKS ELEC CORP
06710	LAMSON AND SESSIONS CO THE VALLEY-TODECO 12975 BRADLEY AVENUE SYLMAR, CALIFORNIA 91342-3830 FORMERLY VALLEY BOLT CORP VB0097 IN NORTH HOLLYWOOD, CA
06725	AIR INDUSTRIES CORPORATION 12570 KNOTT STREET GARDEN GROVE, CALIFORNIA 92641-3932 FORMERLY AIR INDUSTRIES OF CALIF IN GARDENA, CALIF.
07484	ACCURATE BUSHING CO INC 443 NORTH AVENUE GARWOOD, NEW JERSEY 07027-1014 FORMERLY V83132 SMITH BRG DIV OF ACCURATE BUSHING CO
09455	RBC TRANSPORT DYNAMICS CORP 3131 W SEGERSTROM AVE SANTA ANA, CALIFORNIA 92704-5872 FORMERLY TRANSPORT DYNAMICS AEROSPACE DIV; FABROID DIV TRANSPORT DYNAMICS V17571 & LEAR SEIGLER INC TRANSPORT DIV V98076; FORMERLY BFM TRANSPORT DYNAMICS
0HDW7	HUCK MFG CO 3724 EAST COLUMBIA STREET TUCSON, ARIZONA 85714

Code	Name
0PTK6	SPS TECHNOLOGIES INC AEROSPACE PRODUCTS DIV 5195 W 4700 SALT LAKE CITY, UTAH 94118 SEE V56878 SPS TECHNOLOGIES INC
11815	CHERRY AEROSPACE FASTENERS DIV OF TEXTRON 1224 EAST WARNER AVENUE PO BOX 2157 SANTA ANA, CALIFORNIA 92707-0157 FORMERLY IN LOS ANGELES, CALIF , FORMERLY CHERRY FASTENERS TOWNSEND DIV OF TEXTRON INC V71087
15653	ALCOA GLOBAL FASTENERS INC DIV KAYNAR PRODUCTS 800 S STATE COLLEGE BLVD FULLERTON, CALIFORNIA 92831-3001 FORMERLY VK6405 MICRODOT AEROSP LTD; FORMERLY KAYNAR TECH FORMERLY FAIRCHILD FASTENERS KAYNAR DIV
15860	NEW HAMPSHIRE BALL BEARINGS, INC ASTRO DIVISION 155 LEXINGTON AVENUE LACONIA, NEW HAMPSHIRE 03246-2937 FORMERLY ASTRO BEARING CORP, LOS ANGELES, CALIF.
16746	SPECLINE INCORPORATED 2230 MOUTON DR CARSON CITY, NV 89706 FORMERLY IN SUN VALLEY, CAIFORNIA
17446	HUCK INTL INC AEROSPACE FASTENER DIV 900 WATSON CENTER ROAD CARSON, CALIFORNIA 90745-4201 FORMERLY V32134 REXNORD INC; FORMERLY V97928 HUCK INTL
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

Code	Name
21760	SCHATZ BEARING CORP 10 FAIRVIEW AVENUE PO BOX 1191 POUGHKEEPSIE, NEW YORK 12601-1312 FORMERLY FEDERAL BRG CO AND SCHATZ MFG CO V53268 FORMERLY SCHATZ MFG CO
27238	BRISTOL INDUSTRIES 630 EAST LAMBERT ROAD PO BOX 630 BREA, CALIFORNIA 92621-4119
40920	MPB MINIATURE PRECISION BEARING DIV PRECISION PARK PO BOX 547 KEENE, NEW HAMPSHIRE 03431 FORMERLY MPB CORP AND MINIATURE BRG DIV MPB CORP
50632	KAMATICS CORP SUB OF KAMAN CORP 1335 BLUE HILLS ROAD BLOOMFIELD, CONNECTICUT 06002-1304
52828	REPUBLIC FASTENER MFG CORP 1300 RANCHO CONEJO BLVD NEWBURY PARK, CALIFORNIA 91320-1405 FORMERLY IN SYLMAR, CALIFORNIA
53551	ALLFAST FASTENING SYSTEMS INC 15200 EAST DON JULIAN ROAD PO BOX 3166 CITY OF INDUSTRY, CALIFORNIA 91745-1001 FORMERLY V0736B FORMERLY ALLFAST INC V5K545
56644	AURORA BEARING CO 970 SOUTH LAKE STREET AURORA, ILLINOIS 60506-5929
56878	SPS TECHNOLOGIES INC AEROSPACE AND INDUSTRIAL PRODUCTS DIV 301 HIGHLAND AVE JENKINTOWN, PENNSYLVANIA 19046 FORMERLY STANDARD PRESSED STEEL FORMERLY IN SALT LAKE, UTAH

Code	Name
5M902	ALCOA GLOBAL FASTENERS INC, DIV OF VOI-SHAN PRODUCTS 3000 W LOMITA BLVD TORRANCE, CALIFORNIA 90505-5103 FORMERLY FAIRCHILD INC INC FAIRCHILD AEROSPACE FASTENERS DIV
60380	TORRINGTON CO BEARINGS DIV SUBSIDIARY OF INGERSOLL-RAND CORP 59 FIELD STREET PO BOX 1008 TORRINGTON, CONNECTICUT 06790-1008 FORMERLY TORRINGTON BEARING COMPANY
60516	WEST COAST AEROSPACE INC 812 MIRAFLORES STREET SAN PEDRO, CALIFORNIA 90731-1439
62554	SIMMONDS MECAERO FASTENERS INC 1734 SEQUOIA AVENUE ORANGE, CALIFORNIA 92668
71985	DOW-ELCO INCORPORATED 1313 W OLYMPIC BOULEVARD, PO BOX 669 MONTEBELLO, CALIFORNIA 90641-5010
72962	HARVARD INDUSTRIES INC 3 WERNER WAY SUITE 210 LEBANON, NEW JERSEY 08833 FORMERLY ESNA V7A079 FORMERLY ELASTIC STOP NUT IN UNION, NJ
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

Code	Name
75345	KIRKHILL RUBBER CO 300 EAST CYPRESS STREET BREA, CALIFORNIA 92821-4097 FORMERLY L.A. STANDARD RUBBER CO V84914
76005	LORD CORP AEROSPACE PRODUCTS DIV 1635 WEST 12TH STREET, PO BOX 10039 ERIE, PENNSYLVANIA 16514 FORMERLY LORD MANUFACTURING COMPANY FORMERLY LORD CORP LORD KINEMATICS
77896	REXNORD INC BEARING OPERATION 2400 CURTIS STREET DOWNERS GROVE, ILLINOIS 60515-4005 FORMERLY SHAEFER BEARING DIV REX CHAINBELT FORMERLY REX CHAINBELT INC BEARING DIV.
80539	SPS TECHNOLOGIES INC DIV AERPSOACE - SANTA ANA 2701 SOUTH HARBOR BOULEVARD SANTA ANA, CALIFORNIA 92704-5803 FORMERLY NUTT-SHEL DIV OF SPC WESTERN CO V80539 AND STANDARD PRESSED STEEL WESTERN DIV V17279
81376	SMITH ACQUISITION COMPANY 2240 BUENA VISTA BALDWIN PARK, CALIFORNIA 91706
83086	NEW HAMPSHIRE BALL BEARING, INC HITECH DIVISION 172 JAFFREY ROAD PETERBOROUGH, NEW HAMPSHIRE 03458
92215	FAIRCHILD IND INC FAIRCHILD AEROSPACE FASTENER DIV 3010 W LOMITA BLVD TORRANCE, CALIFORNIA 90505-5102 FORMERLY VOI-SHAN IN CULVER CITY, CALIF
92563	MCGILL MFG CO INC BEARINGS DIV 909 LAFAYETTE STREET VALPARAISO, INDIANA 46383-4210

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

NUMERICAL INDEX

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
10-60476-4		1	456	1
		1	456A	1
10-60779-112		7	195	2
102A9213-2-3		1	124	7
		1	196	17
		2	300	4
102A9213-4-3		2	230	1
102F177-3		5	45	2
102F177-4		7	380	12
102F9201-4		1	24	2
		1	48	1
		1	140	1
102F9216-2-3		1	200	9
102F9219-3		1	284	4
		1	312	4
		2	375	12
102F9220-3		2	370	7
10E4-116		1	432	1
		1	548A	1
		1	552	1
10E4-116NW		1	432	1
		1	548A	1
		1	552	1
140N2020-1		1	712	1
140N2021-1		1	756	1
		1	776	1
140N2022-1		1	700	2
140N2022-2		1	716	1
140N2022-3		1	708	1
140N2022-4		1	704	1
141A6553-2		1	212	1
141A6553-3		1	208	1
141A6553-4		1	204	2
141A6570-1		1	358	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		8	1A	RF
141A6571-1		8	50	1
141A6571-2		8	55	1
141A6572-1		8	40	1
141A6573-1		8	30	6
141A6574-1		8	45	1
141A6575-1		8	35	1
147A6118-2		6	95	1
147A6118-4		6	95A	1
147A6119-1		6	60	1
147A6120-1		2	80	AR
147A6120-2		2	85	AR
147A6125-10		2	640	1
147A6125-14		2	565	1
147A6125-18		2	905	1
147A6125-20		2	860	1
147A6125-22		2	860A	1
147A6125-24		2	905A	1
147A6125-6		2	715	1
147A6125-8		2	710	1
147A6126-22		2	970	1
147A6126-26		2	855	1
147A6126-28		2	850	1
147A6126-30		2	705	1
147A6126-32		2	635	1
147A6126-34		2	630	1
147A6126-38		2	900	1
147A6126-40		2	970A	1
147A6128-10		2	815	1
147A6128-12		2	825	1
147A6128-14		2	820	1
147A6128-16		2	680	1
147A6128-18		2	685	1
147A6128-2		2	945	1
147A6128-23		2	610	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
147A6128-24		2	605	1
147A6128-26		2	960	1
147A6128-28		2	965	1
147A6128-30		2	895	1
147A6128-32		2	890	1
147A6128-34		2	835	1
147A6128-36		2	845	1
147A6128-38		2	840	1
147A6128-4		2	950	1
147A6128-40		2	695	1
147A6128-42		2	700	1
147A6128-47		2	625	1
147A6128-48		2	620	1
147A6128-50		2	880A	1
147A6128-52		2	895A	1
147A6128-6		2	880	1
147A6128-8		2	875	1
147A6130-1		2	235	1
147A6130-2		2	255	1
147A6131-2		2	290	1
147A6131-4		2	305	1
147A6133-1		2	260	1
147A6134-2		1	488	1
147A6134-4		1	484	1
147A6134-7		1	504A	1
147A6134-8		1	500	1
147A6134-9		1	508	1
147A6137-4		2	390	1
147A6137-6		2	410	1
147A6138-10		2	65	1
147A6138-12		2	75	1
147A6138-14		2	60	1
147A6138-16		2	70	1
147A6138-18		2	75A	1
147A6138-2		2	40	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
147A6138-20		2	50A	1
147A6138-22		2	70A	1
147A6138-24		2	45A	1
147A6138-26		2	75B	1
147A6138-28		2	50B	1
147A6138-30		2	70B	1
147A6138-32		2	45B	1
147A6138-4		2	50	1
147A6138-6		2	35	1
147A6138-8		2	45	1
147A6139-2		2	130	1
147A6139-4		2	125	1
147A6140-2		1	632	1
147A6140-4		1	628	1
147A6140-5		1	680	1
147A6140-6		1	684	1
147A6140-7		1	692	1
147A6140-8		1	696	1
147A6143-10		1	468B	1
		5	1C	RF
147A6143-12		1	468C	1
		5	1D	RF
147A6143-2		1	468	1
		5	1A	RF
147A6143-6		1	468A	1
		5	1B	RF
147A6144-1		5	15	1
147A6144-2		4	25	1
147A6144-3		5	30	1
147A6144-4		4	40	1
147A6145-10		4	65	1
147A6145-12		4	60	1
147A6145-14		2	350	1
147A6145-16		2	355	1
147A6145-18		2	360	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
147A6145-20		5	65	1
147A6145-21		5	70	1
147A6145-22		5	60	1
147A6145-24		5	75	1
147A6145-26		2	345	1
147A6145-28		4	65A	1
147A6145-29		5	60A	1
147A6145-4		2	340	1
147A6145-6		2	335	1
147A6145-8		4	50	1
147A6145-9		4	55	1
147A6146-10		5	90A	1
147A6146-12		5	80B	1
147A6146-14		5	90B	1
147A6146-2		5	80	1
147A6146-4		5	90	1
147A6146-8		5	80A	1
147A6149-10		1	764	1
147A6149-2		1	748	1
147A6149-4		1	768	1
147A6149-6		1	760	1
147A6149-8		1	780	1
147A6152-12		1	304A	1
147A6152-14		1	304B	1
147A6152-16		1	276A	1
147A6152-2		1	304	1
147A6152-4		1	276	1
147A6152-6		1	328	1
147A6152-8		1	300	1
147A6161-2		1	236	1
147A6161-4		1	248	1
147A6162-1		1	676	1
147A6502-1		1	1A	RF
		2	1A	RF
147A6502-10		1	1K	RF

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		2	1K	RF
147A6502-11		1	1L	RF
		2	1L	RF
147A6502-12		1	1M	RF
		2	1M	RF
147A6502-13		1	1N	RF
		2	1N	RF
147A6502-14		1	1P	RF
		2	1P	RF
147A6502-15		1	1Q	RF
		2	1Q	RF
147A6502-16		1	1R	RF
		2	1R	RF
147A6502-17		1	1S	RF
		2	1S	RF
147A6502-18		1	1T	RF
		2	1T	RF
147A6502-19		1	1U	RF
		2	1U	RF
147A6502-2		1	1G	RF
		2	1G	RF
147A6502-20		1	1V	RF
		2	1V	RF
147A6502-21		1	1W	RF
		2	1W	RF
147A6502-22		1	1X	RF
		2	1X	RF
147A6502-23		1	1Y	RF
		2	1Y	RF
147A6502-24		1	1Z	RF
		2	1Z	RF
147A6502-25		1	2	RF
		2	2	RF
147A6502-26		1	2A	RF
		2	2A	RF

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
147A6502-3		1	1H	RF
		2	1H	RF
147A6502-4		1	1J	RF
		2	1J	RF
147A6502-8		1	1E	RF
		2	1E	RF
147A6502-9		1	1F	RF
		2	1F	RF
147A6503-1		1	588	1
		6	1A	RF
147A6503-2		1	588A	1
		6	1B	RF
147A6503-3		1	588B	1
		6	1C	RF
147A6503-4		1	588C	1
		6	1D	RF
147A6505-2		1	612	1
		7	1A	RF
147A6514-1		1	464	1
		4	1A	RF
147A6514-2		1	464A	1
		4	1B	RF
147A6514-3		1	464B	1
		4	1C	RF
147A6514-4		1	464C	1
		4	1D	RF
147A6516-1		4	70	1
147A6516-3		4	70A	1
147A6516-4		4	70B	1
149A6101-1		2	5B	AR
149A6107-3		7	365	1
149A6107-6		7	410	1
149A6109-1		7	130	1
149A6110-1		6	55	1
149A6112-2		1	384	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
149A6113-2		5	35	2
149A6113-4		5	50	1
149A6114-1		2	740	1
149A6116-4		2	755	2
149A6116-5		2	750	2
149A6120-1		7	100	1
149A6120-2		7	110	1
149A6121-1		2	405	1
149A9480-12		1	16	1
149A9480-28		1	72	1
149A9480-29		1	168	1
149A9480-38		1	104	1
149A9480-48		1	100	1
149A9480-50		1	32	1
149A9480-52		1	108	1
149A9480-56		1	164	1
149A9480-60		1	76	1
149A9480-68		1	36A	1
149A9480-70		1	128A	1
149A9480-72		1	144A	1
149A9480-73		1	52A	1
149A9480-77		1	80A	1
149A9480-78		1	108A	1
149A9480-79		1	80B	1
149A9480-80		1	108B	1
149A9480-9		1	80	1
30-3010		7	150	1
30-3013-2		7	160	1
30-3019-1		7	140	1
3SLCC6		2	600	4
		2	600	4
		2	675	6
		2	675	6
		2	810	6
		2	810	6

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		2	870	11
		2	870	11
		2	940	4
		2	940	4
3SLCC8		2	595	6
		2	595	6
		2	670	4
		2	670	4
		2	805	4
		2	805	4
		2	935	6
		2	935	6
51564-0402		1	440A	1
		1	548	1
51588-041		1	432	1
		1	548A	1
		1	552	1
5164-0402DD		1	440	1
55001		2	10	4
		2	115	1
60-4405-1		6	70	2
60-4406-16		2	200	1
60-4406-17		2	205	1
60-4455-3		7	165	1
63-1478-1		3	20	3
63-1692-1		7	255	2
63-2848		7	155	1
63-9386-1		7	50	1
65-1933-23		7	275	1
65-1933-24		7	290	1
65-2306-10		2	120	1
65-2306-9		2	105	4
65-2863-8		1	356	1
		3	1A	RF
65-28925-100		1	532A	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
65-28925-101		1	536A	1
65-28925-104		1	556A	1
65-28925-105		1	560A	1
65-28925-47		1	556	1
65-28925-48		1	560	1
65-28925-85		1	532	1
65-28925-86		1	536	1
65-44065-11		7	75	1
65-44065-12		7	85	1
65-44065-13		7	85A	1
65-45871-504		1	452	8
65-54013-502		7	315	1
65-54013-503		7	300	1
65-73978-11		6	30A	1
65-73978-14		6	35A	1
65-73978-16		6	20A	1
65-73978-18		6	35B	1
65-73978-2		6	20	1
65-73978-20		6	20B	1
65-73978-22		6	35C	1
65-73978-23		6	27	1
65-73978-4		6	35	1
65-73978-7		6	15	1
65-73978-9		6	30	1
65-8795-501		7	295	1
65C36793-1		7	395A	2
66-12688-11		2	615	1
		2	690	1
		2	830	1
		2	885	1
		2	955	1
66-14527-8		6	65	2
66-14530-6		2	190	1
66-14531-12		2	185	1
66-14531-13		2	195	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
66-14618-6		1	444	1
66-14618-7		1	448	1
66-15332-1		2	5	AR
		2	5A	AR
66-15645-1		1	572	2
66-1921-2		3	40	1
66-24986-1		7	25	1
66-2646		3	35	1
66-9776		1	28	2
69-1083-2		3	45	1
69-1084-2		3	50	1
69-17330-6		6	90	1
69-18187-25		1	420	1
69-18187-26		1	424	1
69-1983-7		3	55	1
69-34971-11		7	60	1
69-34971-2		7	70	1
69-37418-11		2	165	2
69-39176-1		7	180	1
69-39176-2		7	200	1
69-41720-3		5	85	2
69-70268-2		1	672	1
69-78694-3		7	385	4
69-78694-4		7	390	4
69B10068-3		7	235	2
77253		7	195	2
81669V5K6		2	665	3
		2	780	4
		2	785	1
81669V6K4		2	660	3
		2	865	11
81669V6K5		2	800	1
81669V6K6		2	590	4
		2	790	2
		2	795	4

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		2	930	4
81669V8K4		2	645	2
		2	775	1
81669V8K5		2	585	1
		2	650	1
		2	765	1
		2	925	1
81669V8K6		2	580	5
		2	655	1
		2	770	2
		2	920	5
81669V8K7		2	760	1
82-99-341-18		1	240	4
8675-4		1	456	1
		1	456A	1
90-7811		7	35	1
90-7815-25		7	320	1
90-7815-26		7	325	1
90-7815-29		7	350	1
90-7815-30		7	355	1
90-7821-1		7	30	1
90-7879-10		7	20	1
AB4E27FN		1	440A	1
		1	548	1
AB4E27FN12		1	440	1
ABW16-101		2	10	4
		2	115	1
ACMKP12AP510Y198		7	125	1
ACMKP21BSP510LY19		7	270	2
ACMKP23BSP510LY		7	240	2
ACMKP25BP26LY198		7	360	2
ACMKP25BP510LY198		7	360	2
ACMKP25P26LY198		7	360	2
ADNE5-202		7	195	2
AF3253-4-3B		5	55	28

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
AF3253-4-4B		4	45	30
AF5141-3C		2	730A	20
AN316-5R		1	428	1
		1	544	2
AN316-6R		7	190	1
AN996-14		7	145	1
AR4E4FN		1	440A	1
		1	548	1
AR4E4FN12		1	440	1
AR4E7AFNW		1	432	1
		1	548A	1
		1	552	1
ARB4E60FNW		1	432	1
		1	548A	1
		1	552	1
ARHT5E102		7	195	2
ASM4F6		1	440A	1
		1	548	1
ASM4F6DM		1	440	1
ASMK4F1		1	432	1
		1	548A	1
		1	552	1
ASSB16-19		2	10	4
		2	115	1
BAC27DBY191		2	985	1
BACB10A187L		1	440A	1
		1	548	1
BACB10A187M2L		1	440	1
BACB10A397GCM2		2	10	4
		2	115	1
BACB10FK5F9HS		2	145	2
		2	250	1
BACB10FR25		7	360	2
BACB10FS12		7	125	1
BACB10FV21		7	270	2

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACB10FV23		7	240	2
BACB10Y4		1	432	1
		1	548A	1
		1	552	1
BACB28AK04-030		1	416	2
BACB28X4M014		4	35	1
		5	25	1
BACB28X6M014		4	30	1
		5	20	1
BACB30NM3K11		1	644	2
		1	644	2
		6	5	4
		6	5	4
		7	205	1
		7	205	1
BACB30NM3K13		7	90	4
BACB30NM3K17		2	150	4
BACB30NM3K19		2	170	4
BACB30NM3K3		1	340	3
		2	90	16
BACB30NM3K4		2	720	10
BACB30NM3K7		7	220	1
BACB30NM3K8		4	5	4
		5	5	4
BACB30NM3K9		2	210	3
BACB30NM4K11		1	640	2
BACB30NM4K13		1	392	2
		1	516	2
BACB30NM4K17		1	388	2
BACB30NM4K19		1	600	12
BACB30NM5K16		1	576	1
BACB30NN3K12		7	5	4
BACB30NR4K12		1	512	2
BACB30NR4K6		7	245	2
BACB30NR5K17		7	170	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACB30NT3K1		1	56	3
		1	148	3
BACB30NT3K16		1	84	2
BACB30NT3K3		1	112	7
		1	180	24
		1	182	10
BACB30NT3K4		1	112A	7
		1	182A	10
BACB30NT3K5		1	476	16
BACB30NT3K6		1	472	3
BACB30PU4-25		6	40	8
BACB30PU5-28		6	75	2
BACB30VF3K11		7	210	1
BACB30VF3K3		2	20	1
BACB30VF3K4		2	15	15
		2	215	2
		2	415	8
BACB30VF3K7		7	215	1
BACB30VN6K4		2	660	3
		2	865	11
BACB30VN6K5		2	800	1
BACB30VN6K6		2	590	4
		2	790	2
		2	795	4
		2	930	4
BACB30VN6K7		2	665	3
		2	780	4
		2	785	1
BACB30VN8K4		2	645	2
		2	775	1
BACB30VN8K5		2	585	1
		2	650	1
		2	765	1
		2	925	1
BACB30VN8K6		2	580	5

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		2	655	1
		2	770	2
		2	920	5
BACB30VN8K7		2	760	1
BACB30VT6K3		2	490	28
BACB30VT6K4		1	620	26
		2	460	4
		2	500	6
BACB30VT6K5		2	480	4
BACB30VT6K6		2	495	2
BACB30VT8K3		2	505	4
BACB30VT8K4		2	270	2
		2	435	2
BACB30VT8K5		2	455	3
BACB30VT8K6		2	445	3
BACB30VT8K7		2	450	4
BACB30VU5K5		1	364	6
BACB30VU6K3		1	720	4
		2	485	19
		2	535	4
BACB30VU6K4		1	724	2
		2	275	2
		2	530	72
BACB30VU6K5		1	360	4
		2	315	4
		2	540	22
BACB30VU6K6		2	310	4
BACB30VU8K5		2	440	4
BACB30VU8K6		2	430	4
BACC30BK6		2	600	4
		2	675	6
		2	810	6
		2	870	11
		2	940	4
BACC30BK8		2	595	6

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		2	670	4
		2	805	4
		2	935	6
BACC30BL5		1	372	6
BACC30BL6		1	368	4
		1	728	6
		2	285	2
		2	475	4
		2	510	50
		2	550	76
BACC30BL8		2	280	2
		2	465	6
		2	520	4
BACC30BQ6		2	320	8
		2	515	9
BACC30BQ8		2	470	14
BACF3H06JK006HN		1	608	6
BACF3H12JF007HN		2	380	3
BACF3T01A13-12		2	265	1
BACF3T02E4-4B		2	525	3
BACN10JA3CD		5	45	2
BACN10JA4CD		7	380	12
BACN10JD105CD		2	135	2
BACN10JD106ASU		7	335	1
BACN10JD6CD		7	40	1
BACN10JP3ACD		7	405	4
BACN10JP5C		7	285A	1
BACN10JP5CCD		7	285	1
BACN10JR4CFD		1	24	2
		1	48	1
		1	140	1
BACN10JZ3A2CDM		1	284	4
		1	312	4
		2	375	12
BACN10JZ3A2CDMU		1	284A	4

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	312A	4
BACN10JZ3B2CDM		2	370	7
BACN10KE3B2CD		1	124	7
		1	196	17
		2	300	4
BACN10KE3B4CD		2	230	1
BACN10KE3DCD		2	735	10
BACN10KE3E2CD		1	200	9
BACN10KF4		7	310	2
BACN10MK3-45		1	352	3
BACN10YR04CD		3	15	6
		8	15	12
BACN10YR3CD		1	92	2
		2	30	16
		2	100	16
		2	425	8
		4	20	4
		7	15	4
		7	230	4
BACN10YR3CM		2	160	4
		2	180	4
		6	50	8
BACN10YR4CD		1	408	2
		7	265	2
BACN10YR4CM		1	412	2
		1	528	2
		6	85	2
BACN10YR5CD		2	240	1
BACN10YR5CM		1	584	1
BACN10ZV3		1	624	26
		2	545	22
BACP18BC02A06P		2	132	2
BACP18BC03A08P		1	592	1
BACR12AG2C		1	244	4
BACR15BA3AD		1	192	12

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	280	8
		1	308	8
		2	225	2
		2	295	8
		2	365	38
		2	730	20
		5	40	4
		7	375	24
		7	400	8
BACR15BA3D		1	20	4
		1	40	2
		1	132	2
BACR15BA4D		1	64	6
		1	156	6
		7	280	2
BACR15BA5AD		2	745	4
BACR15BA5B		1	460	60
BACR15BA5D		1	44	2
		1	136	2
BACR15BB4AD		1	752	2
BACR15BB4D		1	228	8
		1	772	2
		2	330	8
		2	570	12
		2	910	4
BACR15CTE3CW3		1	120	14
BACR15DR3AC		2	730A	20
BACR15FR4E3R		5	55	28
BACR15FR4E4R		4	45	30
BACR15FT5D		1	96	4
		1	288	12
		1	316	8
		1	744	9
BACR15FT6D		1	740	6
BACR15GE3CW3		1	120A	14

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	188	40
BACR15GF4D		1	348	6
BACR15GF5D		1	272	25
		1	380	17
		1	736	19
		2	385	40
		2	400	2
		2	560	273
		7	370	8
BACR15GF6D		1	376	10
		1	732	9
		2	555	37
BACR15GJ5E3		1	224	4
		1	264	4
BACR15GK4E2		2	325	34
BACR15GK6E2		1	260	65
BACR15GK6E3		1	4	9
		1	252	183
BACR15GK6E4		1	8	7
		1	216	8
		1	256	18
BACS12HJ04K8		8	5	12
BACS14K1		1	220	4
		1	296	6
		1	324	4
		2	575	6
BACS14K2		1	68	3
BACS14K3		2	915	2
BACS14K4		1	160	3
BACS14K7		1	232	4
BACS21AP180RP		1	240	4
BACS40R007B007F		3	25	AR
		8	20	AR
BACS40R007B008F		1	336	AR
		2	975	AR

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACS40R007B017F		2	980	AR
BACS40R007C007F		3	30	AR
		8	25	AR
BACS40R008C008F		1	332	AR
BACS40R008C030F		1	172	AR
BACS40R008C037F		1	176	AR
BACS40R008C042F		1	616	AR
BACW10BN3AC		1	344	3
		2	220	3
		4	10	4
		5	10	4
		7	95	4
BACW10BN4AC		1	396	2
		1	520	2
		1	604	6
		1	648	2
BACW10BN4AP		1	656	2
BACW10BP3APU		6	45	8
BACW10BP3CD		6	10	4
BACW10BP4APU		6	80	2
BACW10CT6J		1	116	7
		1	184	34
		1	480	19
		1	652	2
BACW10P148AL		7	55	1
BACW10P182AL		1	292	12
		1	320	8
BH00312-04		3	15	6
BLN16385GC		2	10	4
		2	115	1
BR3000A4		7	310	2
BRE4140L		1	440A	1
		1	548	1
BRE4795L		1	440	1
BRES4-2236L2		1	432	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	548A	1
		1	552	1
BRF110C3D		5	45	2
BRF110C4D		7	380	12
BRF170C3D		5	45	2
BRF170C4D		7	380	12
BRF200C4D		1	24	2
		1	48	1
		1	140	1
BRFR120C3-2D		1	200	9
BRFR220C3-2D		1	124	7
		1	196	17
		2	300	4
BRFR220C3-4D		2	230	1
CHRS3CFR9		2	145	2
		2	145	2
		2	250	1
		2	250	1
CR3253-4-3		5	55	28
CR3253-4-4		4	45	30
CR6551-3		1	624	26
		2	545	22
DE586		1	232	4
DE675-10		1	160	3
DE676-10		2	915	2
DE679-10		1	68	3
DE685-10		1	220	4
		1	296	6
		1	324	4
		2	575	6
DREM5-019		7	195	2
F51636-3		5	45	2
F51636-4		7	380	12
		7	380	12
F51643-3BAC		1	284	4

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	312	4
		2	375	12
F51646-3BAC		2	370	7
F51747-3-2CD		1	124	7
		1	196	17
		2	300	4
F51747-3-4CD		2	230	1
F51751-3-2CD		1	200	9
F51753-3CD		2	735	10
H52732-04CD		3	15	6
		8	15	12
H52732-3CD		1	92	2
		2	30	16
		2	100	16
		2	425	8
		4	20	4
		7	15	4
		7	230	4
H52732-3CM		2	160	4
		2	180	4
		6	50	8
H52732-4CD		1	408	2
		7	265	2
H52732-4CM		1	412	2
		1	528	2
		6	85	2
H52732-5CD		2	240	1
H52732-5CM		1	584	1
HB4E135		1	440A	1
		1	548	1
HB4E140		1	440	1
HB4E212K		1	432	1
		1	548A	1
		1	552	1
HGL16-102		2	10	4

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		2	115	1
HR3253-4-4		4	45	30
HR3253-5-3		1	224	4
		1	264	4
HRSC3CFR9		2	145	2
		2	250	1
HST10AG6-3		2	490	28
		2	490	28
		2	490	28
		2	490	28
HST10AG6-4		1	620	26
		1	620	26
		1	620	26
		1	620	26
		2	460	4
		2	460	4
		2	460	4
		2	460	4
		2	500	6
		2	500	6
		2	500	6
		2	500	6
HST10AG6-5		2	480	4
		2	480	4
		2	480	4
		2	480	4
HST10AG6-6		2	495	2
		2	495	2
		2	495	2
		2	495	2
HST10AG8-3		2	505	4
		2	505	4
		2	505	4
		2	505	4
HST10AG8-4		2	270	2

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		2	270	2
		2	270	2
		2	270	2
		2	435	2
		2	435	2
		2	435	2
		2	435	2
HST10AG8-5		2	455	3
		2	455	3
		2	455	3
		2	455	3
HST10AG8-6		2	445	3
		2	445	3
		2	445	3
		2	445	3
HST10AG8-7		2	450	4
		2	450	4
		2	450	4
		2	450	4
HST11AG5-5		1	364	6
		1	364	6
		1	364	6
		1	364	6
HST11AG6-3		1	720	4
		1	720	4
		1	720	4
		1	720	4
		2	485	19
		2	485	19
		2	485	19
		2	485	19
		2	535	4
		2	535	4
		2	535	4
		2	535	4

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HST11AG6-4		1	724	2
		1	724	2
		1	724	2
		1	724	2
		2	275	2
		2	275	2
		2	275	2
		2	275	2
		2	530	72
		2	530	72
		2	530	72
		2	530	72
HST11AG6-5		1	360	4
		1	360	4
		1	360	4
		1	360	4
		2	315	4
		2	315	4
		2	315	4
		2	315	4
		2	540	22
		2	540	22
		2	540	22
		2	540	22
HST11AG6-6		2	310	4
		2	310	4
		2	310	4
		2	310	4
HST11AG8-5		2	440	4
		2	440	4
		2	440	4
		2	440	4
HST11AG8-6		2	430	4
		2	430	4
		2	430	4

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		2	430	4
HST79-5		1	372	6
		1	372	6
		1	372	6
HST79-6		1	368	4
		1	368	4
		1	368	4
		1	728	6
		1	728	6
		1	728	6
		2	285	2
		2	285	2
		2	285	2
		2	475	4
		2	475	4
		2	475	4
		2	510	50
		2	510	50
		2	510	50
		2	550	76
		2	550	76
		2	550	76
HST79-8		2	280	2
		2	280	2
		2	280	2
		2	465	6
		2	465	6
		2	465	6
		2	520	4
		2	520	4
		2	520	4
HST79CY5		1	372	6
HST79CY6		1	368	4
		1	728	6
		2	285	2

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		2	475	4
		2	510	50
		2	550	76
HST79CY8		2	280	2
		2	465	6
		2	520	4
HST826AW		2	320	8
		2	320	8
		2	320	8
		2	515	9
		2	515	9
		2	515	9
HST828AW		2	470	14
		2	470	14
		2	470	14
HST82CY6APBW		2	320	8
		2	320	8
		2	515	9
		2	515	9
HST82CY8APBW		2	470	14
		2	470	14
J7444-11		1	232	4
K3000-4BAC		7	310	2
K51602-4BAC		1	24	2
		1	48	1
		1	140	1
KB4ESSD6FN		1	440	1
KB4ESSFN		1	440A	1
		1	548	1
KBDE5-14		7	195	2
KBE4-150AFNW		1	432	1
		1	548A	1
		1	552	1
KRP141500VT6-6		7	345	1
KSSB16-5		2	10	4

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		2	115	1
LGPL2SPV6-4AC		2	660	3
		2	660	3
		2	660	3
		2	865	11
		2	865	11
		2	865	11
LGPL2SPV6-5AC		2	800	1
		2	800	1
		2	800	1
LGPL2SPV6-6AC		2	590	4
		2	590	4
		2	590	4
		2	790	2
		2	790	2
		2	790	2
		2	795	4
		2	795	4
		2	795	4
		2	930	4
		2	930	4
		2	930	4
LGPL2SPV6-7AC		2	665	3
		2	665	3
		2	665	3
		2	780	4
		2	780	4
		2	780	4
		2	785	1
		2	785	1
		2	785	1
LGPL2SPV8-4AC		2	645	2
		2	645	2
		2	645	2
		2	775	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		2	775	1
		2	775	1
LGPL2SPV8-5AC		2	585	1
		2	585	1
		2	585	1
		2	650	1
		2	650	1
		2	650	1
		2	765	1
		2	765	1
		2	765	1
		2	925	1
		2	925	1
		2	925	1
LGPL2SPV8-6AC		2	580	5
		2	580	5
		2	580	5
		2	655	1
		2	655	1
		2	655	1
		2	770	2
		2	770	2
		2	770	2
		2	920	5
		2	920	5
		2	920	5
LGPL2SPV8-7AC		2	760	1
		2	760	1
		2	760	1
M83461-1-212		7	115	1
M83461-1-214		1	564	2
M83461-1-325		1	596	1
MK3000-5BAC		7	285A	1
MS15001-4		2	110	1
MS16625-4162		7	120	1

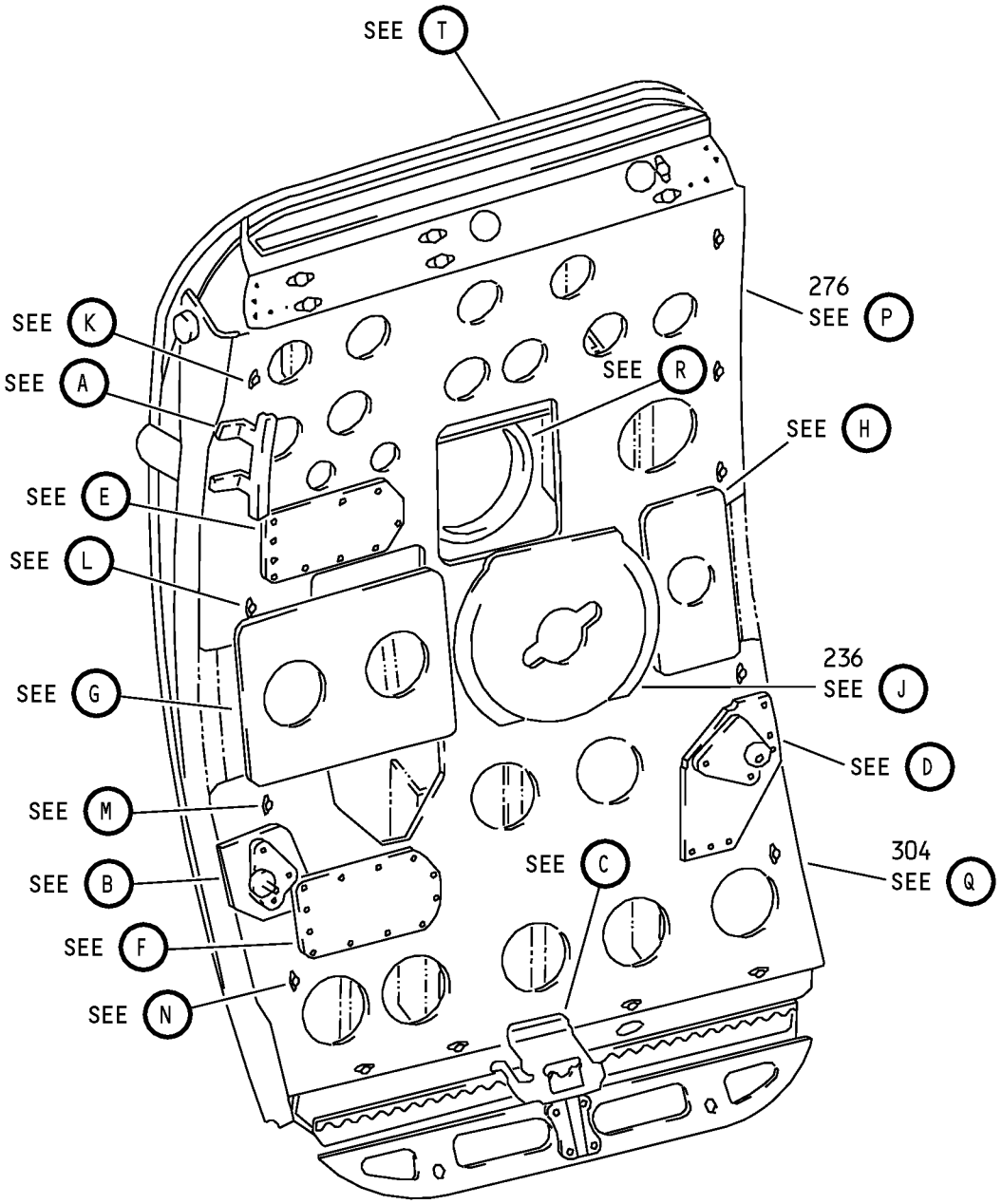
PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
MS20253P2-2910		1	496	1
MS20426D5		7	65	3
MS20470D3		1	540	1
MS20470D3-4		7	305	4
MS20470D5		1	436	1
MS20615-5M10		7	185	1
MS21141U6P4		1	12	1
		1	268	12
MS21209F5-15P		7	80	3
MS24665-283		7	330	1
MS27253F1		2	990	1
MS39086-111		7	135	1
MS39086-125		1	492	2
MSSK4ASFG		1	432	1
		1	548A	1
		1	552	1
MSSR56-14BAC		7	195	2
MXJ45-14BFG		1	440A	1
		1	548	1
MXJ45-14BFG2		1	440	1
NAS1149C0332R		2	155	4
		2	175	4
NAS1149C0632B		7	340	AR
NAS1149C1790R		1	568	2
NAS1149D0332J		1	60	3
		1	152	3
		2	25	16
		2	95	16
		7	225	6
NAS1149D0363J		1	88	2
		2	420	8
		2	725	10
		4	15	4
		7	10	4
NAS1149D0432J		7	250	2

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
NAS1149D0463J		1	400	2
NAS1149D0516J		1	636A	AR
		2	140	16
NAS1149D0532J		1	636	AR
		2	245	1
NAS1149D0563J		7	175	1
NAS1149D0632J		7	45	AR
NAS1149D2190J		7	260	2
NAS1149DN432J		3	10	12
		8	10	24
NAS1149E0432R		1	404	2
		1	524	2
NAS1149E0563R		1	580	1
NAS1399CW3		2	730B	20
NAS1523C3R		7	97	4
NAS1805-3L		1	668	2
NAS1805-4L		1	664	2
NAS463XDD10H		1	285	4
		1	313	4
NAS516-1A		2	55	1
		7	105	1
NAS620A10L		1	660	2
NAS76A16-016P		1	688	1
NAS8200A8		3	5	6
		8	5A	12
NASM21209F1-15		6	25A	4
NB12BGCM2		2	10	4
		2	115	1
NB16BM2		2	10	4
		2	115	1
NC16-4		2	10	4
		2	115	1
NHNE5-202		7	195	2
NS103195-048		7	310	2
NS103199-054		7	285A	1

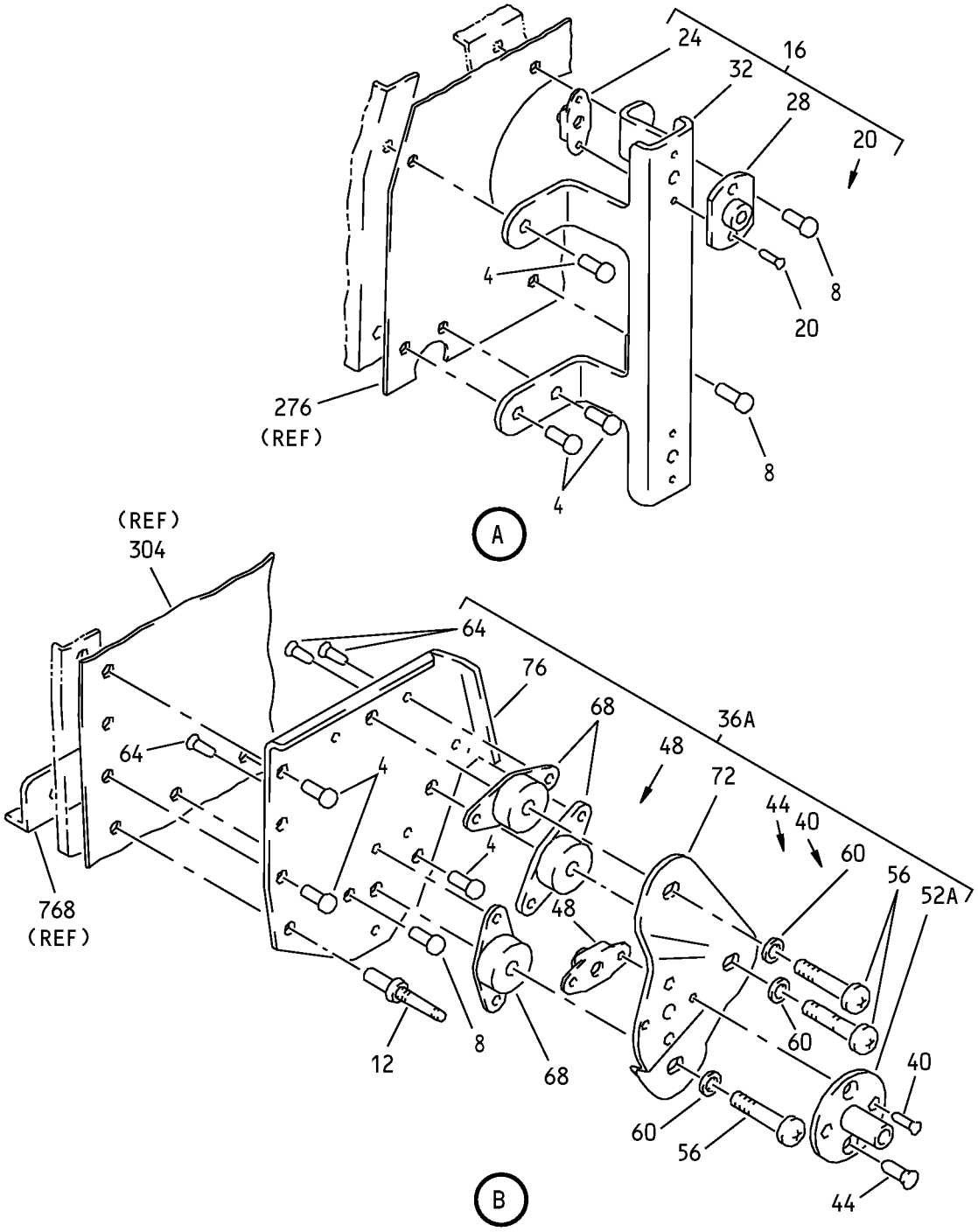
PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
NS202476-048		1	24	2
		1	48	1
		1	140	1
NS202484-02		5	45	2
NS202492-02		1	284	4
		1	312	4
		2	375	12
NS202493-02-2		1	124	7
		1	196	17
		2	300	4
NS202493-02-4		2	230	1
NS202494-02-2		1	200	9
NS202495-02		2	735	10
PACMKP12AA3908		7	125	1
PACMKP12AFS428		7	125	1
PACMKP21BSA3908		7	270	2
PACMKP21BSFS428		7	270	2
PACMKP23BSA3908		7	240	2
PACMKP23BSFS428		7	240	2
PACMKP25BA3908		7	360	2
PACMKP25BFS428		7	360	2
PLH504CD		8	15	12
PLH53CD		1	92	2
		2	30	16
		2	100	16
		2	425	8
		4	20	4
		7	15	4
		7	230	4
PLH53CM		2	160	4
		2	180	4
		6	50	8
PLH54CD		1	408	2
		7	265	2
PLH54CM		1	412	2

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	528	2
		6	85	2
PLH55CD		2	240	1
PLH55CM		1	584	1
REM10ATC12-2		7	195	2
RMA9205-4		7	310	2
RMA9205M5		7	285A	1
S14162-4		1	456	1
		1	456A	1
SL2509		1	232	4
SL2750		1	160	3
SL2751-3S		2	915	2
SL2752-3		1	68	3
SL2808-3		1	220	4
		1	296	6
		1	324	4
		2	575	6
SSMKP12AP		7	125	1
SSMKP12ASD705		7	125	1
SSMKP21BSSD705		7	240	2
		7	270	2
SSMKP23BSSD705		7	240	2
SSMKP25BSD703		7	360	2
T8059S1032B1		1	352	3
		1	352	3
T8078S524		7	285A	1
T8092C428CD		1	24	2
		1	48	1
		1	140	1
T8118S4		7	310	2
TFM5C		7	195	2
VN103A1-048		7	310	2
WC10K6-3		2	490	28
WC10K6-5		2	480	4
WC10K6-6		2	495	2

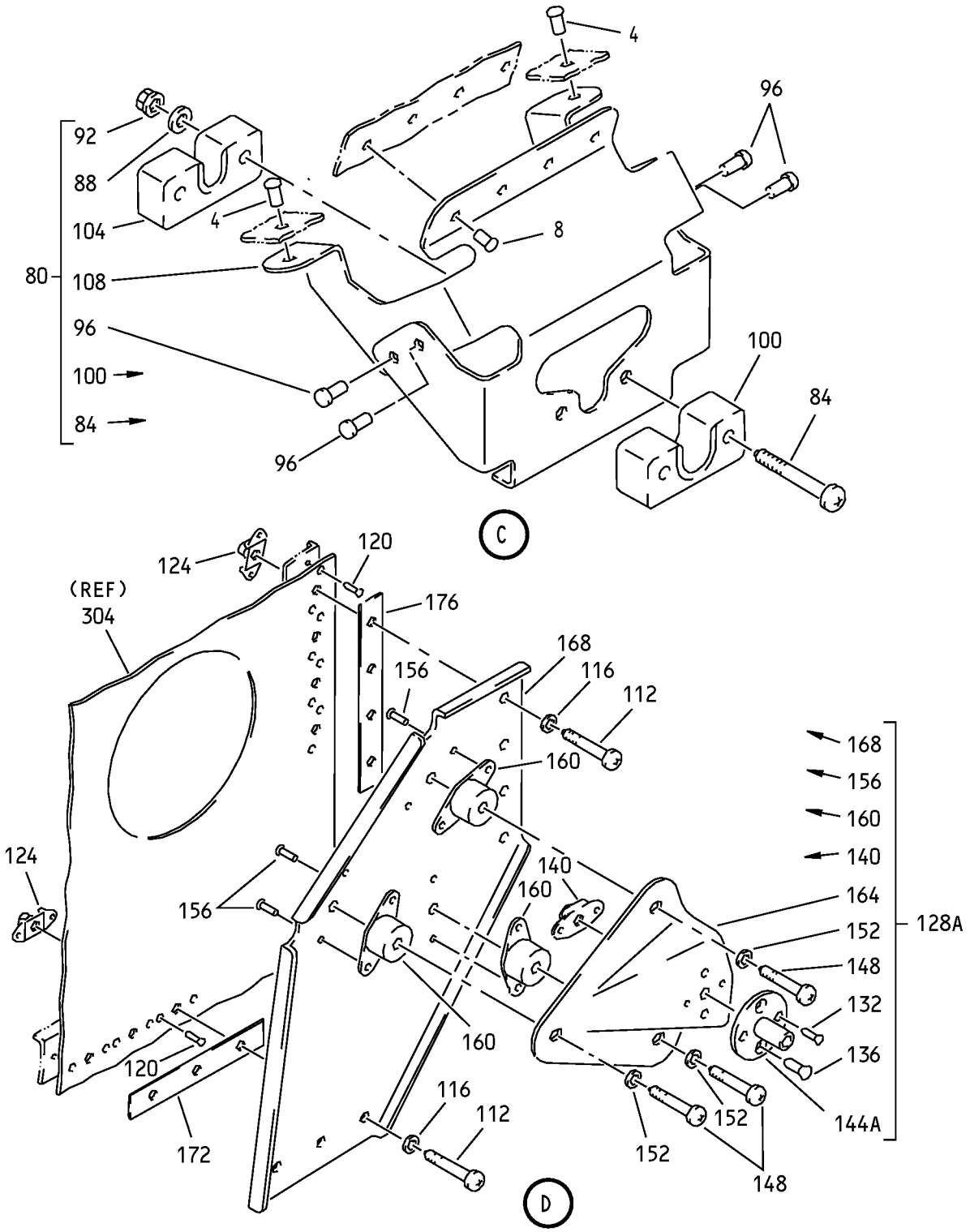
PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
WC10K8-3		2	505	4
WC10K8-4		2	270	2
		2	435	2
WC10K8-5		2	455	3
WC10K8-6		2	445	3
WC10K8-7		2	450	4



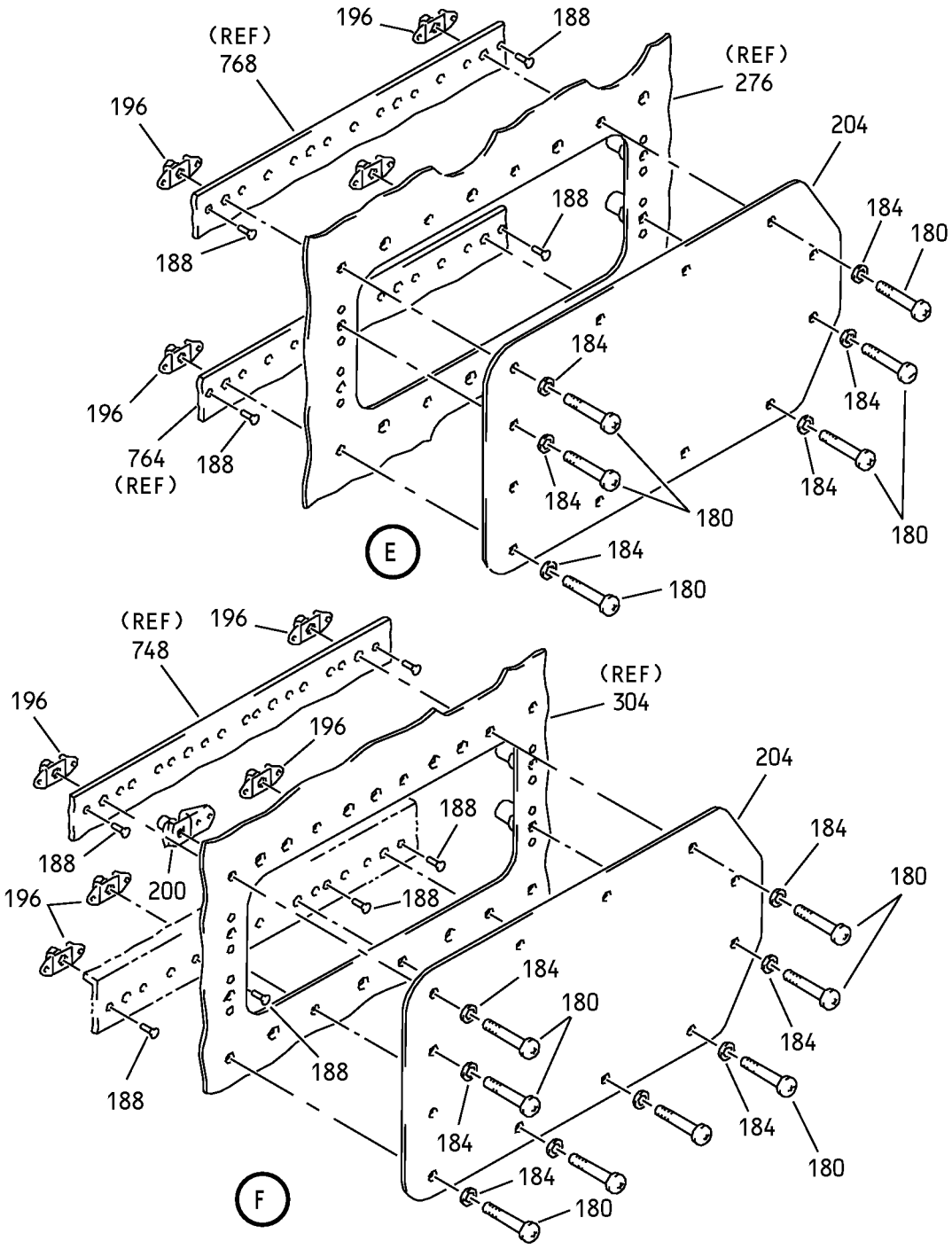
Aft Galley Door Assembly
IPL Figure 1 (Sheet 1 of 24)



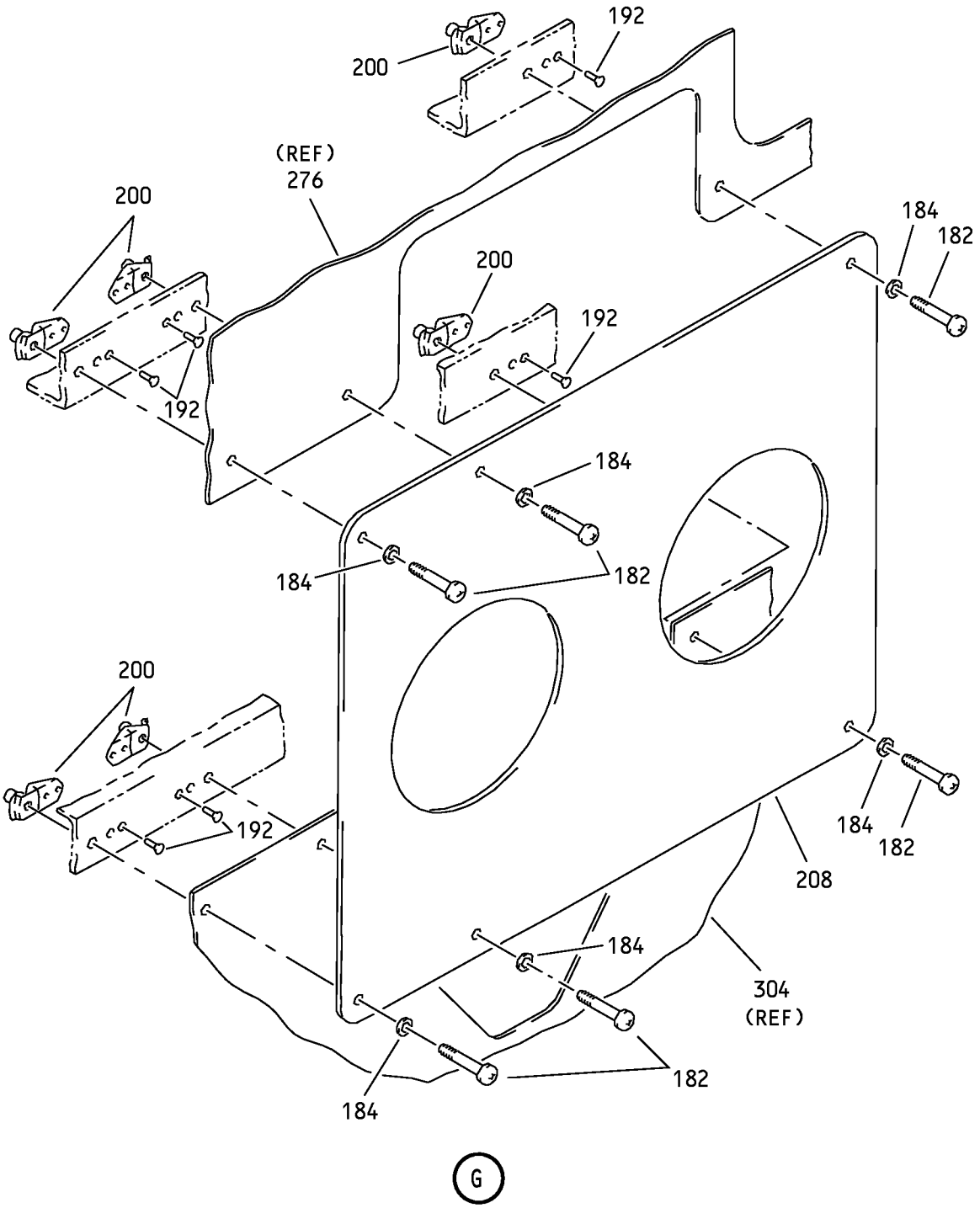
Aft Galley Door Assembly
IPL Figure 1 (Sheet 2 of 24)



Aft Galley Door Assembly
IPL Figure 1 (Sheet 3 of 24)

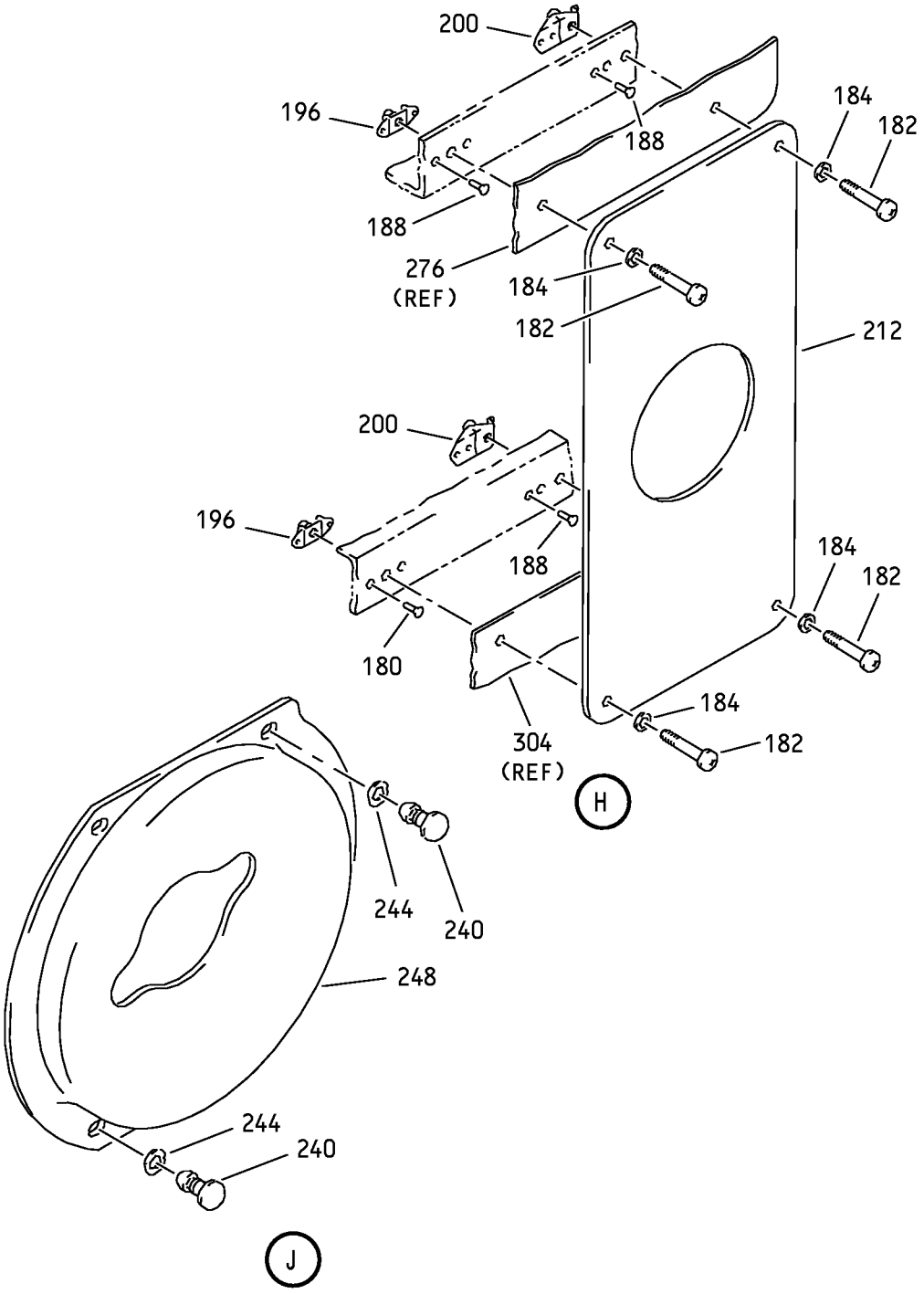


Aft Galley Door Assembly
IPL Figure 1 (Sheet 4 of 24)



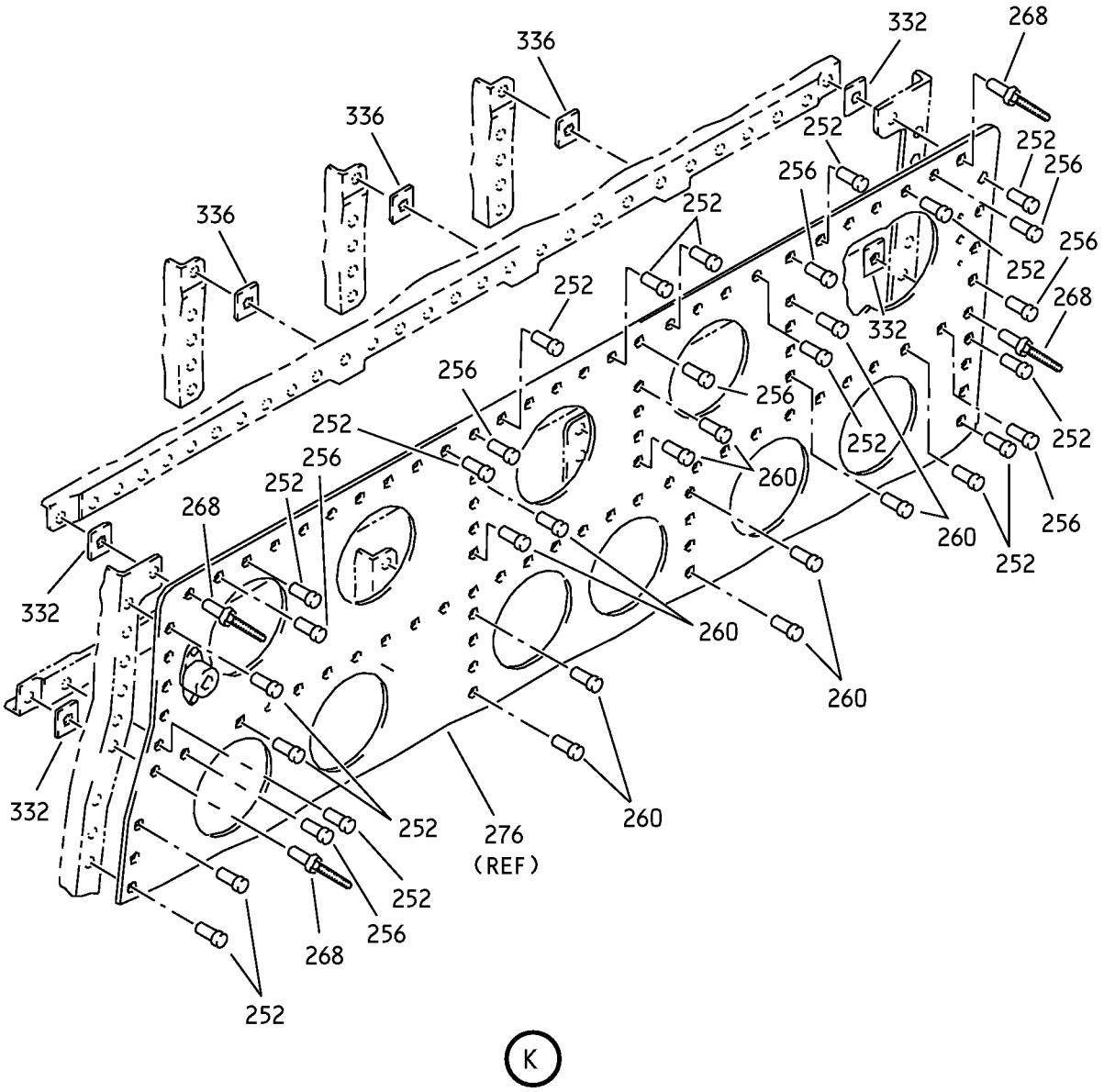
G56495 S00041002042_V2

Aft Galley Door Assembly
IPL Figure 1 (Sheet 5 of 24)

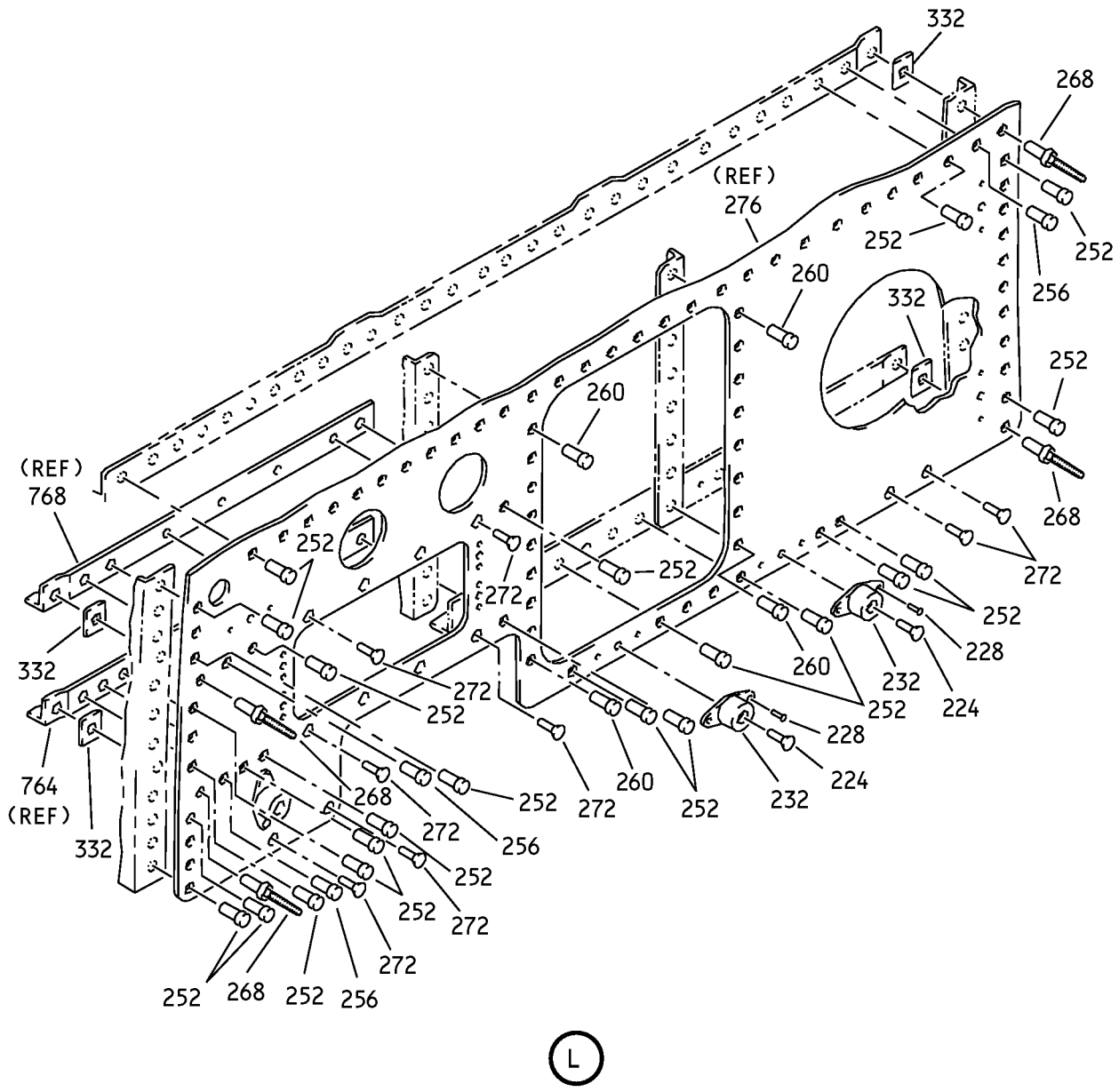


G56511 S00041002043_V2

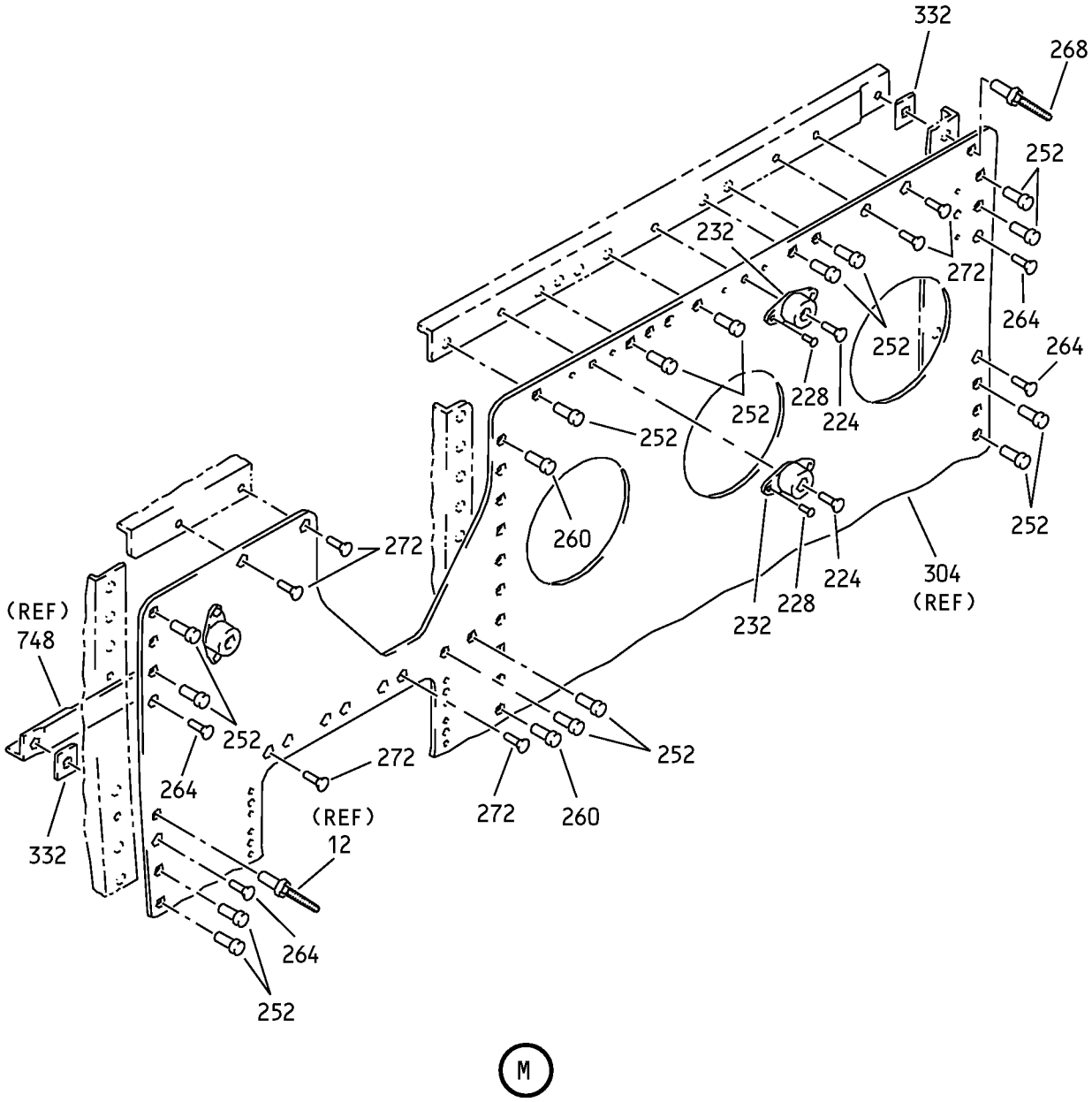
Aft Galley Door Assembly
IPL Figure 1 (Sheet 6 of 24)



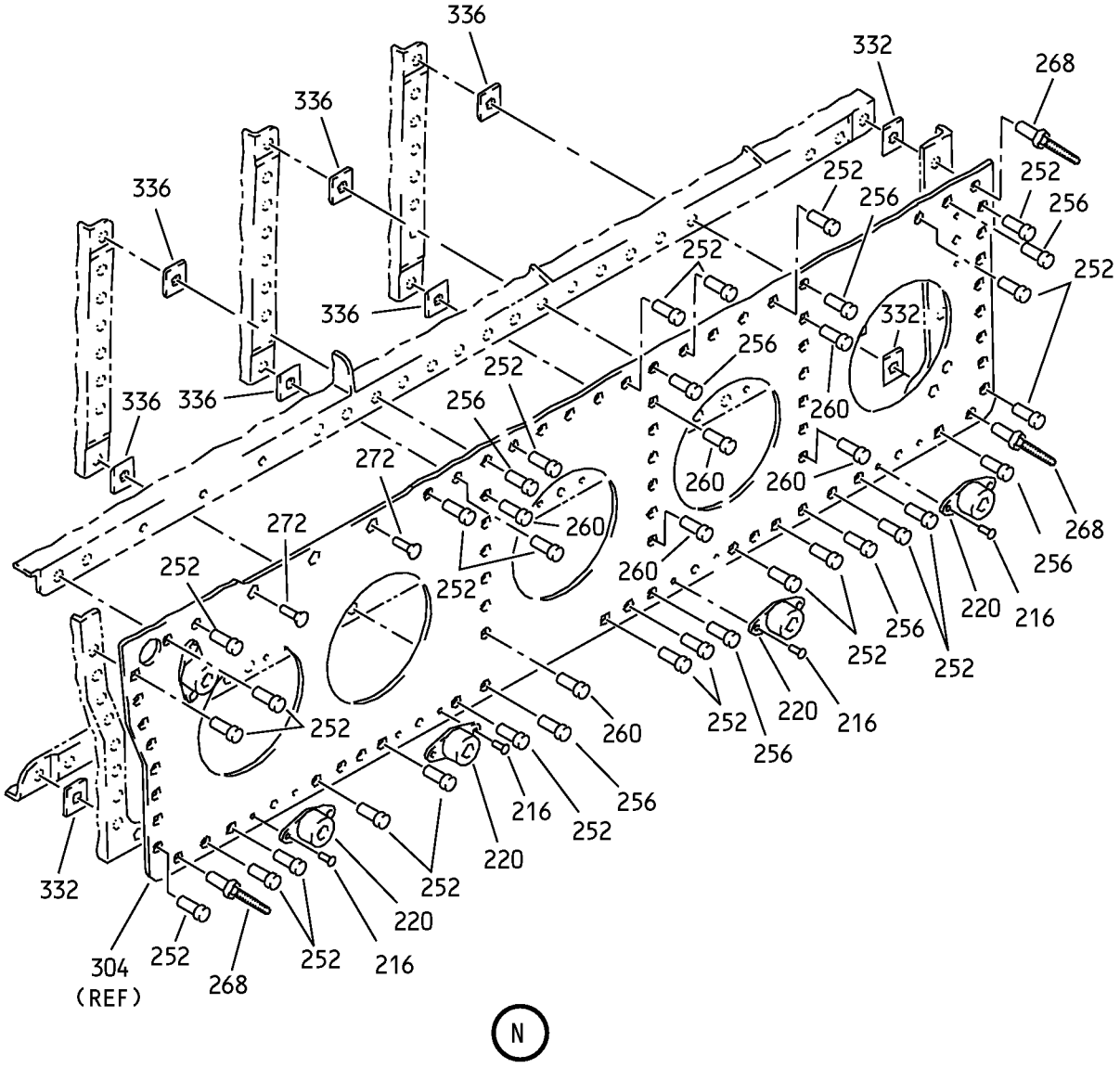
Aft Galley Door Assembly
IPL Figure 1 (Sheet 7 of 24)



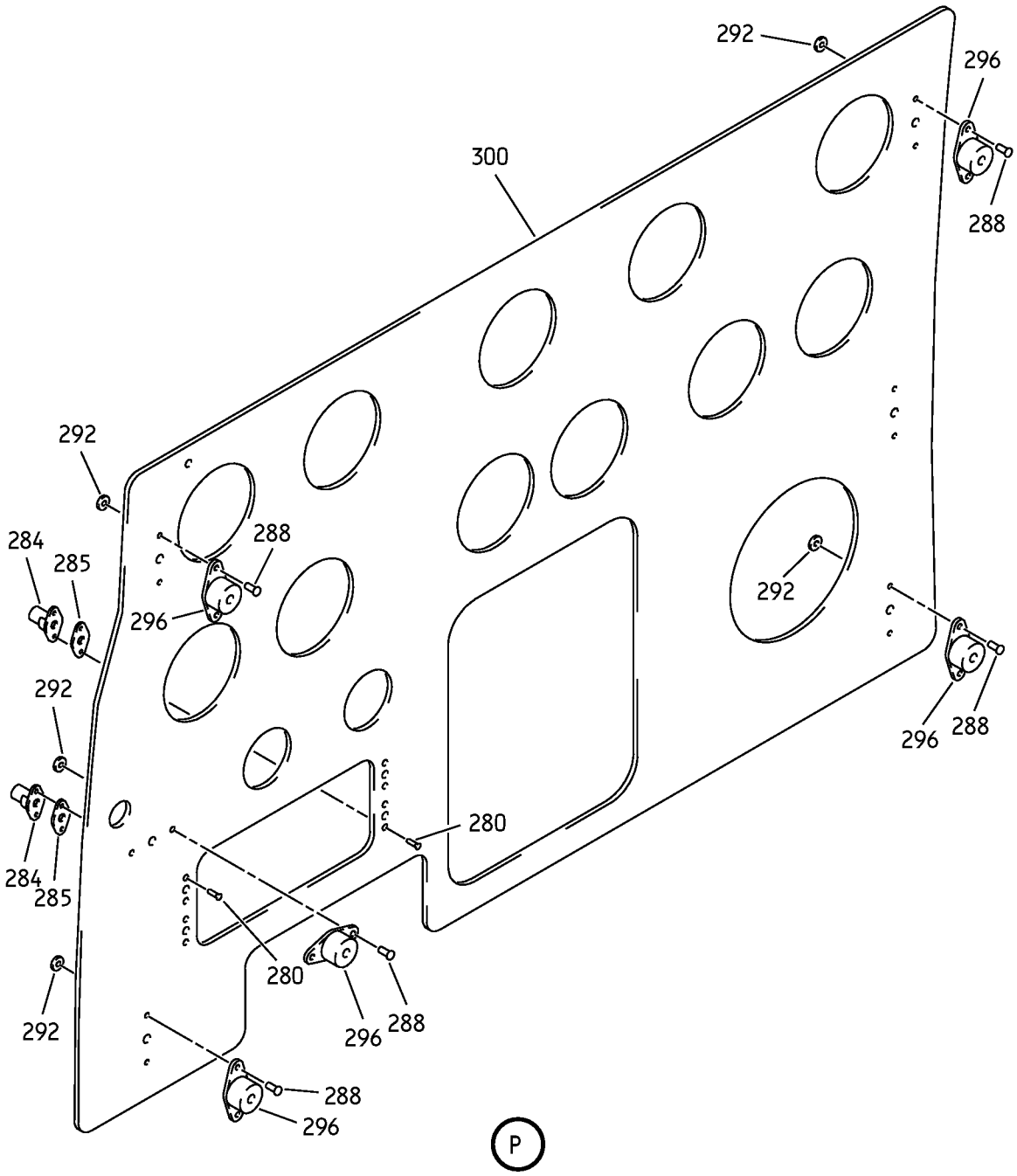
Aft Galley Door Assembly
IPL Figure 1 (Sheet 8 of 24)



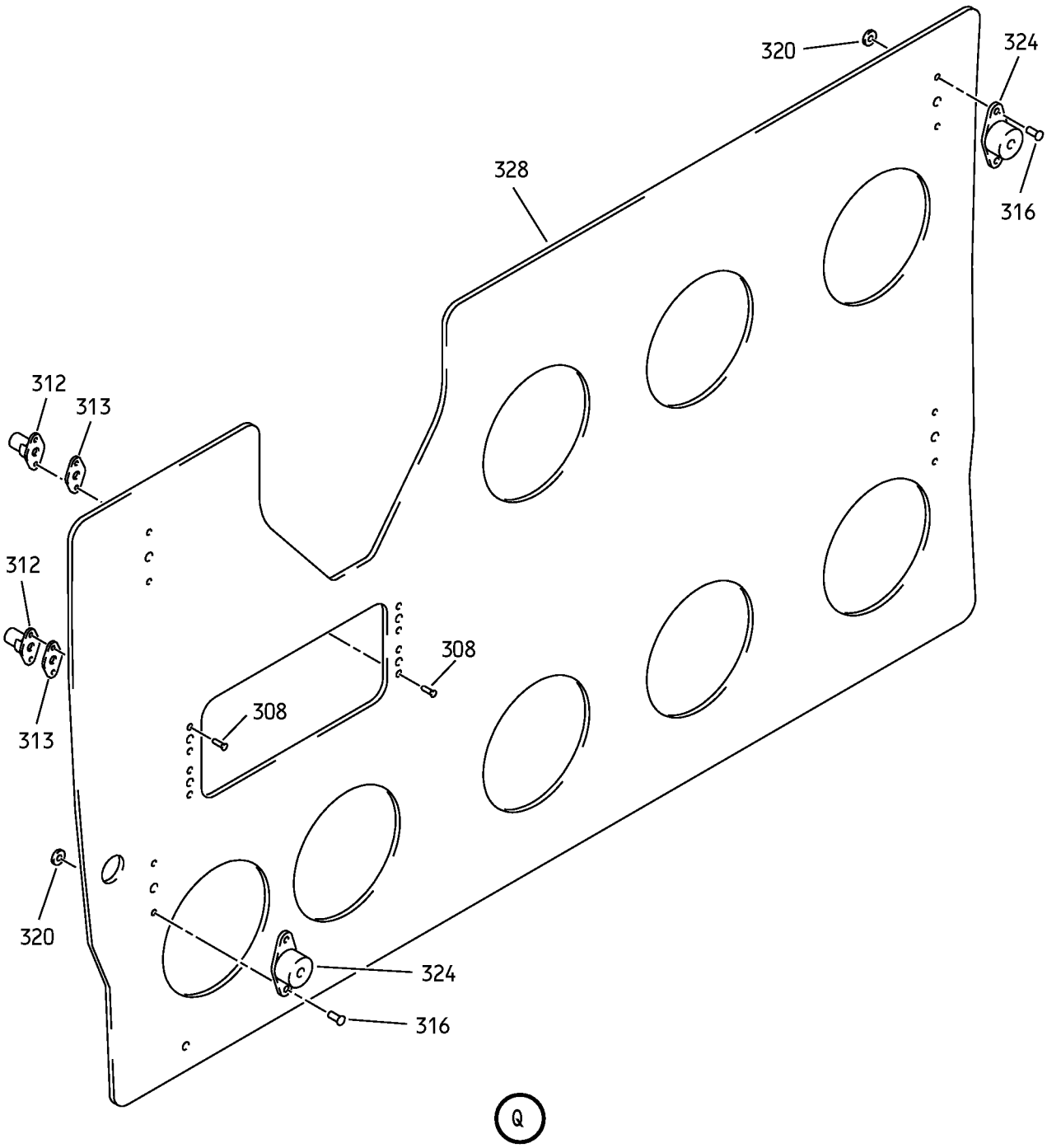
Aft Galley Door Assembly
IPL Figure 1 (Sheet 9 of 24)



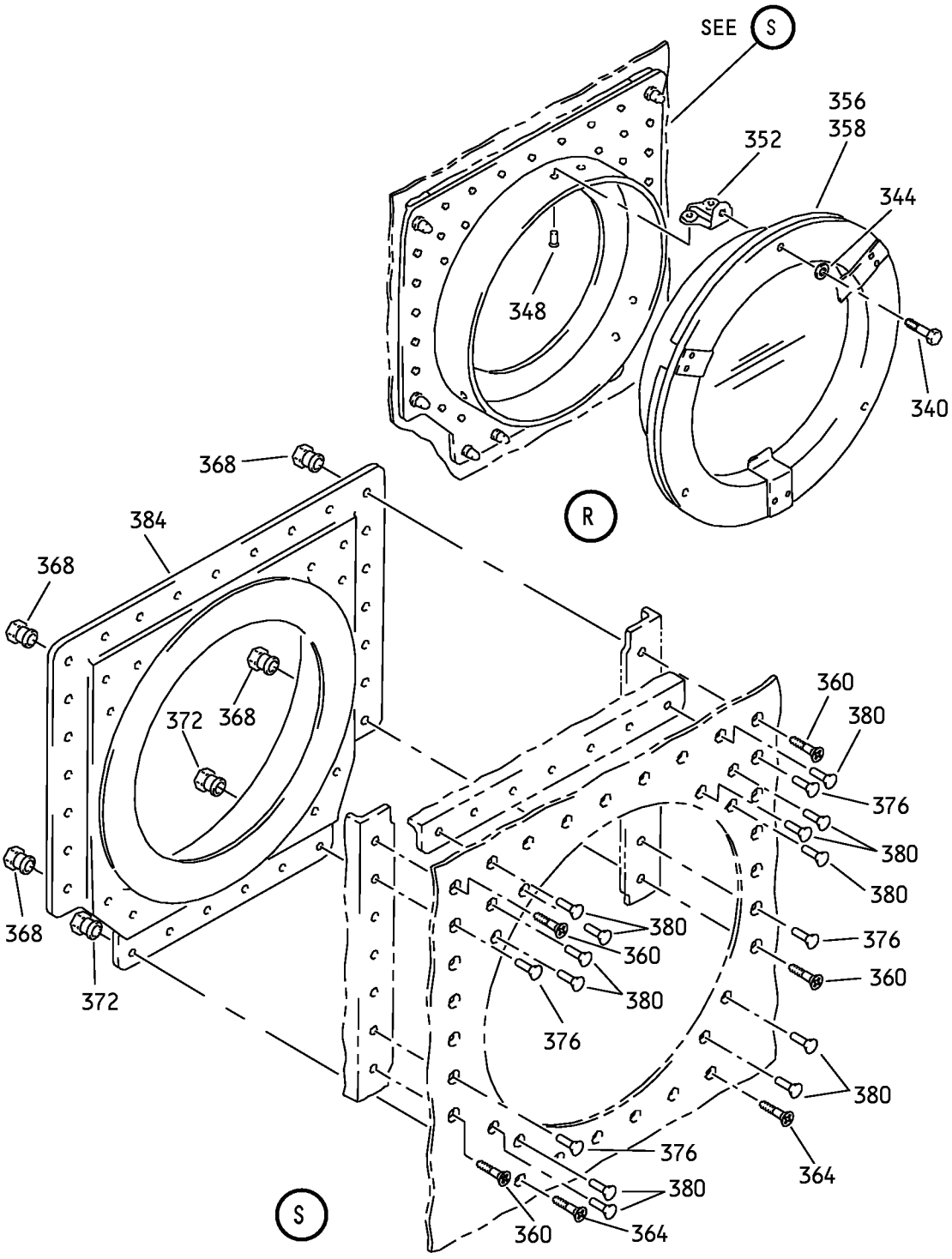
Aft Galley Door Assembly
IPL Figure 1 (Sheet 10 of 24)



Aft Galley Door Assembly
IPL Figure 1 (Sheet 11 of 24)

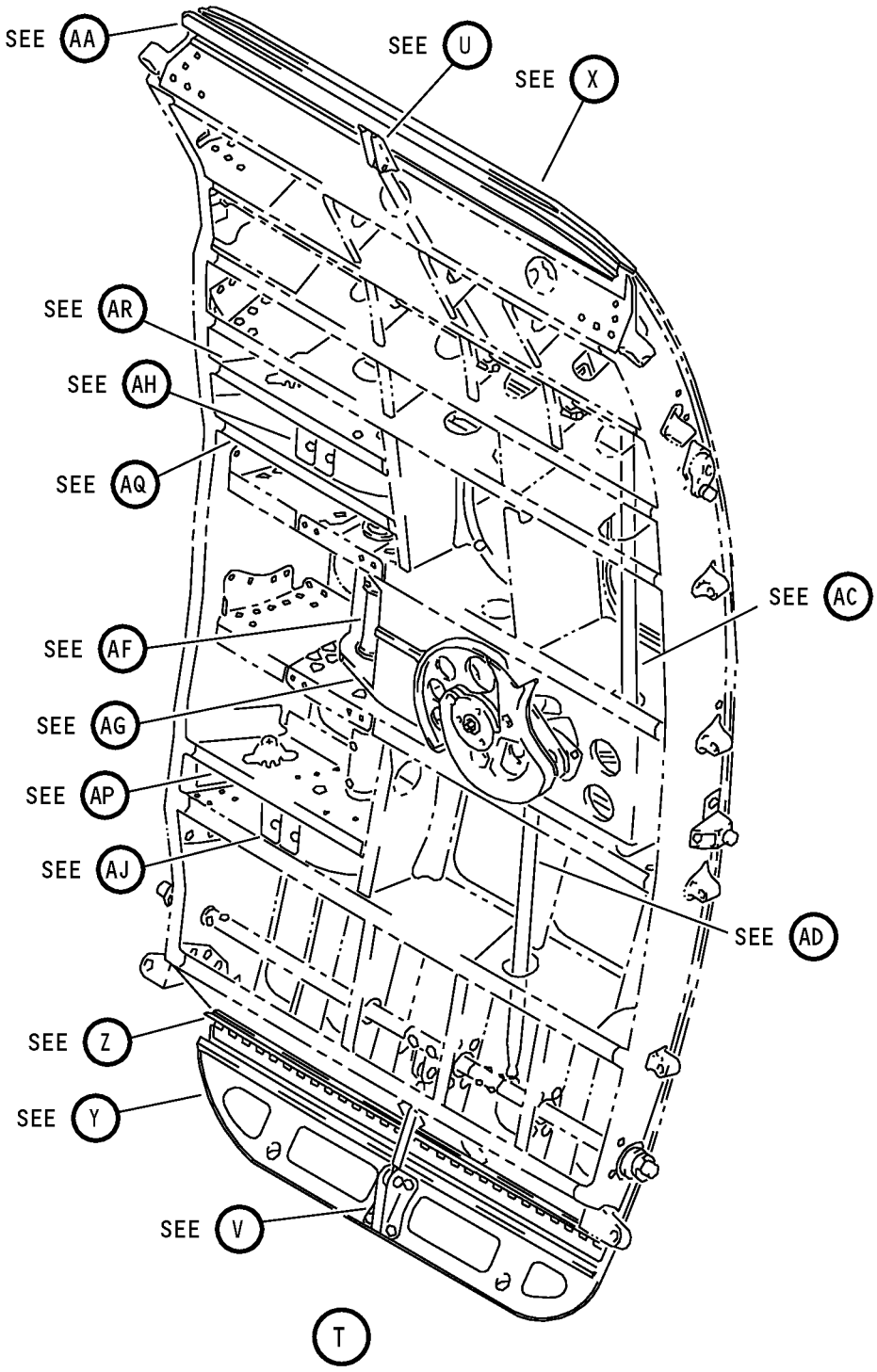


Aft Galley Door Assembly
IPL Figure 1 (Sheet 12 of 24)

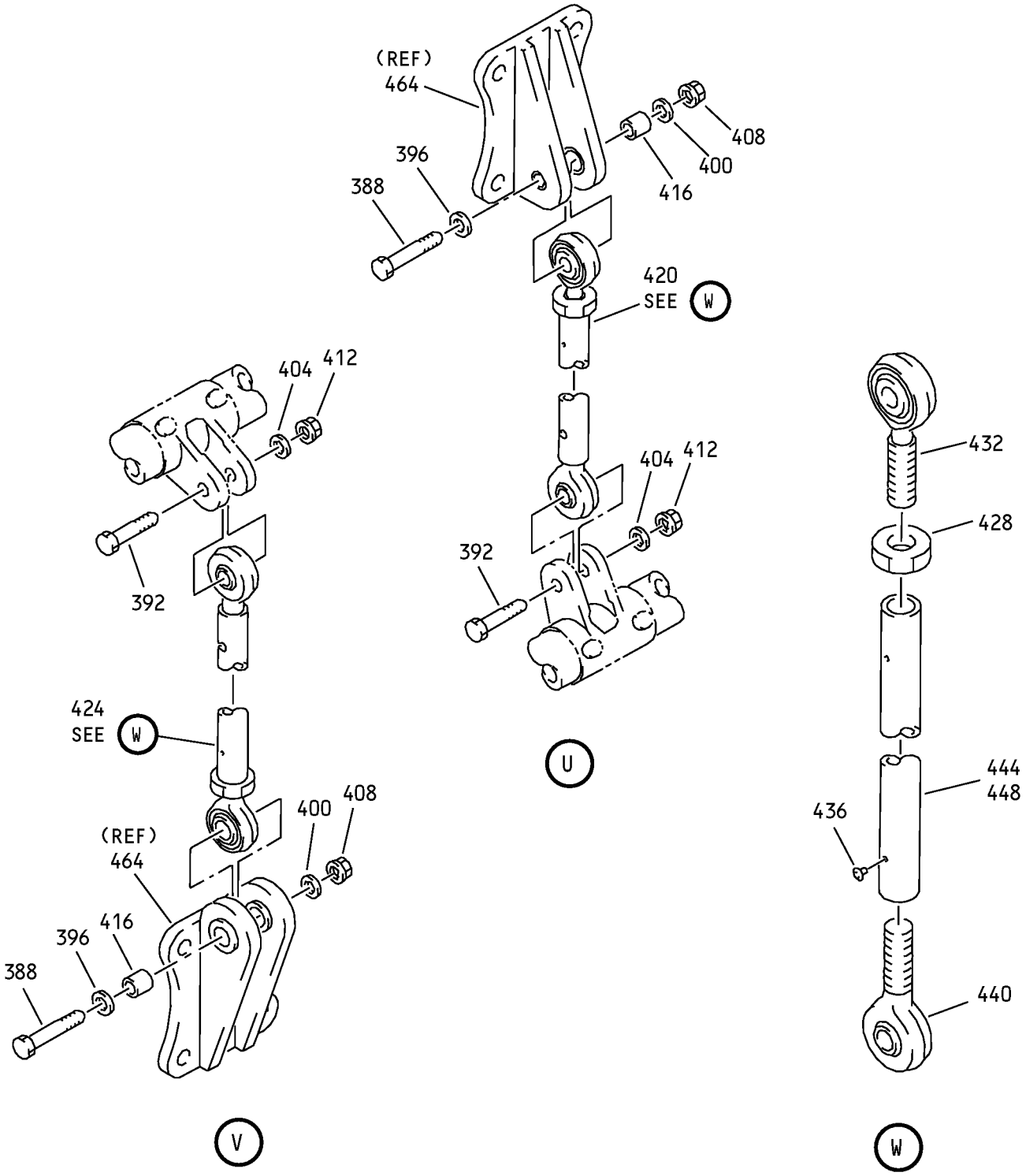


G56725 S00041002050_V2

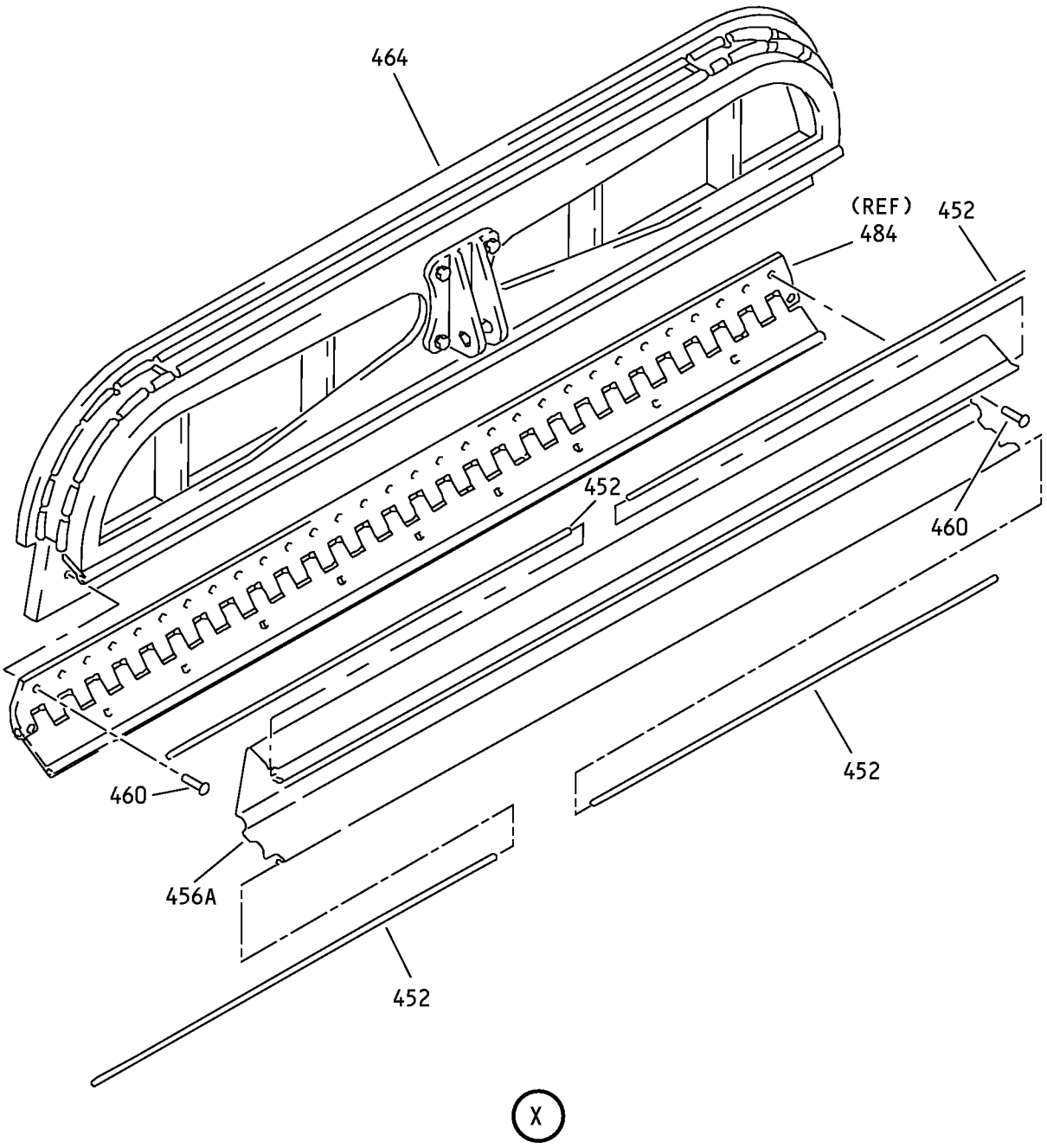
Aft Galley Door Assembly
IPL Figure 1 (Sheet 13 of 24)



Aft Galley Door Assembly
IPL Figure 1 (Sheet 14 of 24)

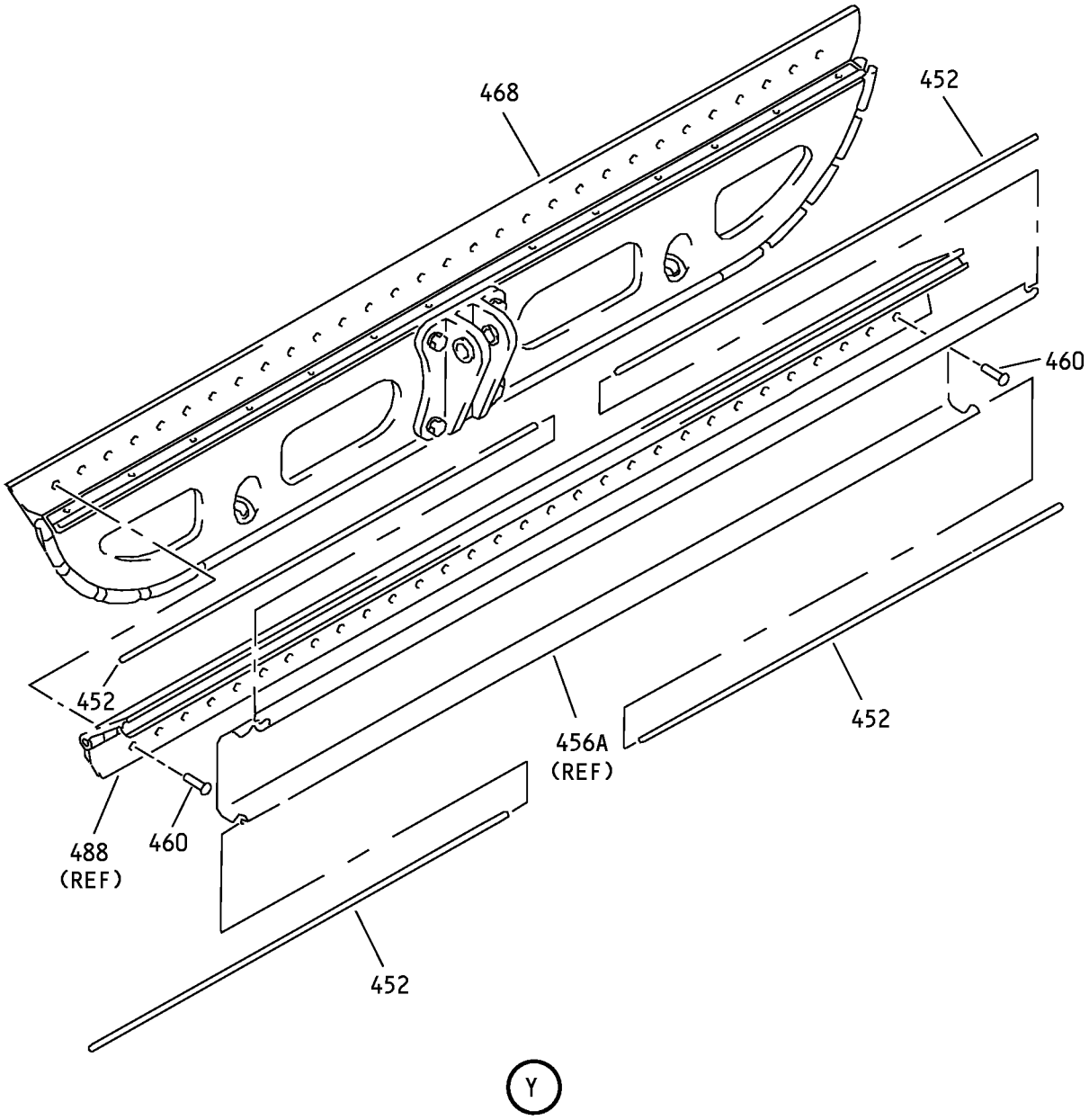


Aft Galley Door Assembly
IPL Figure 1 (Sheet 15 of 24)



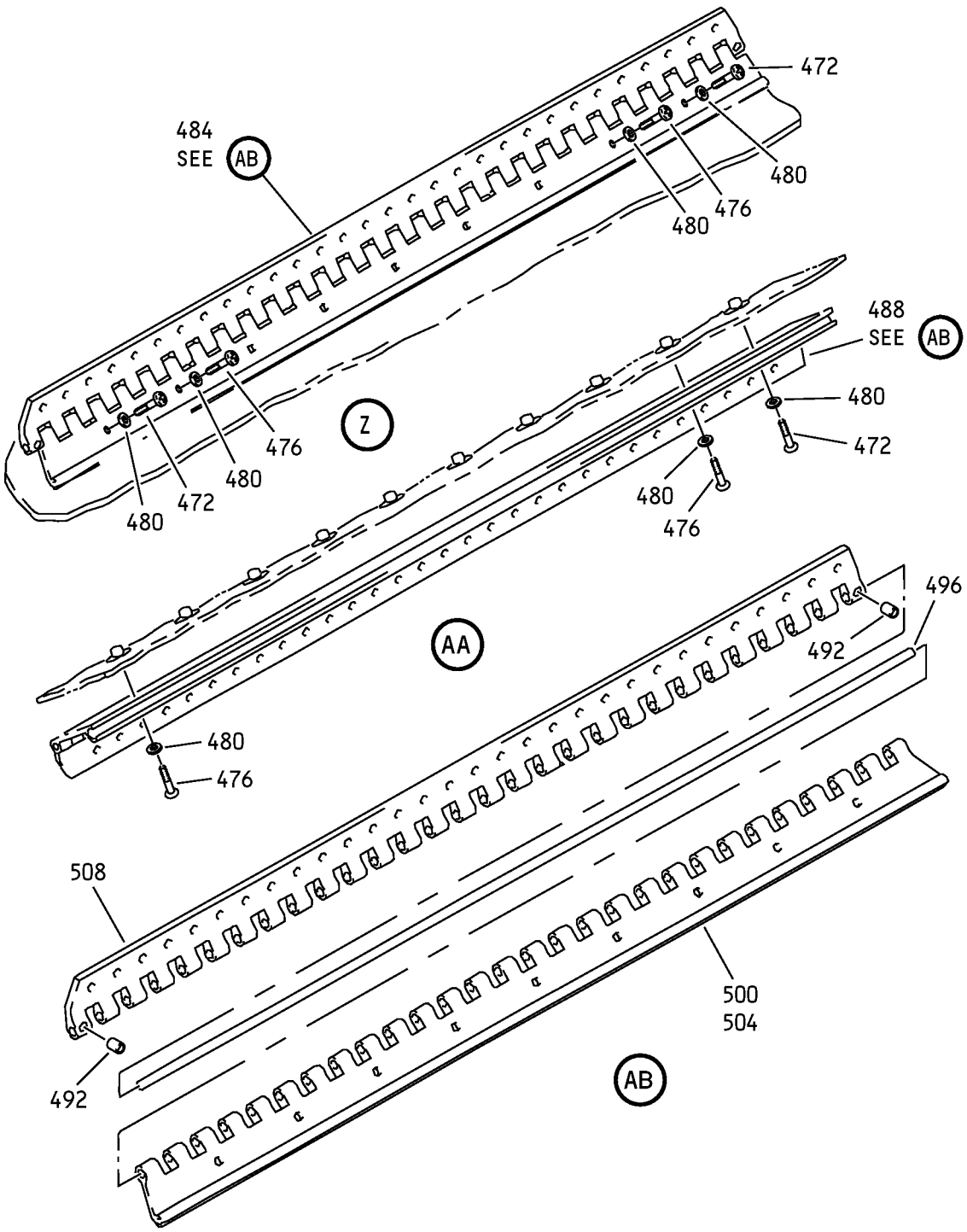
G56805 S00041002053_V2

Aft Galley Door Assembly
IPL Figure 1 (Sheet 16 of 24)

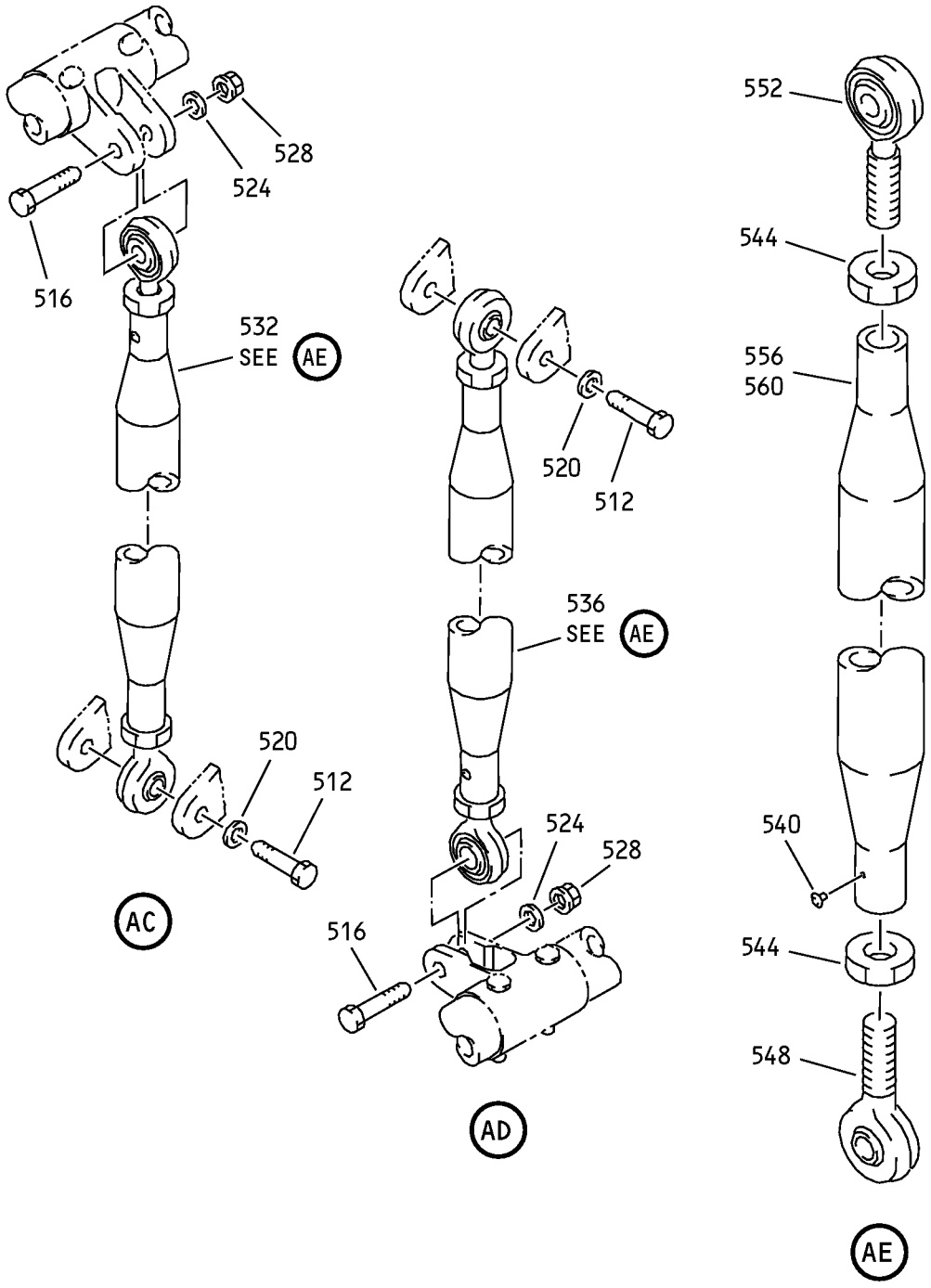


G56822 S00041002054_V2

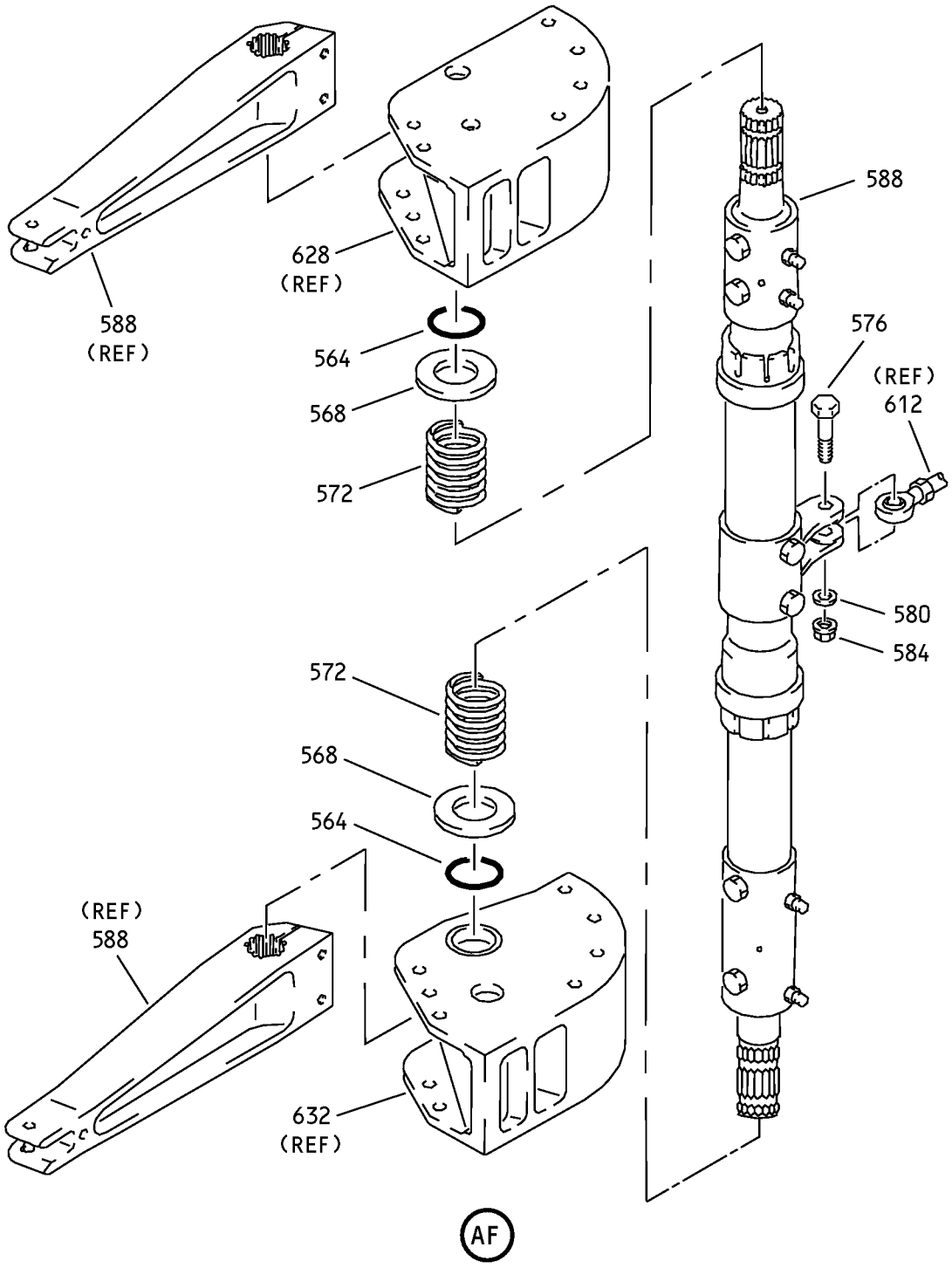
Aft Galley Door Assembly
IPL Figure 1 (Sheet 17 of 24)



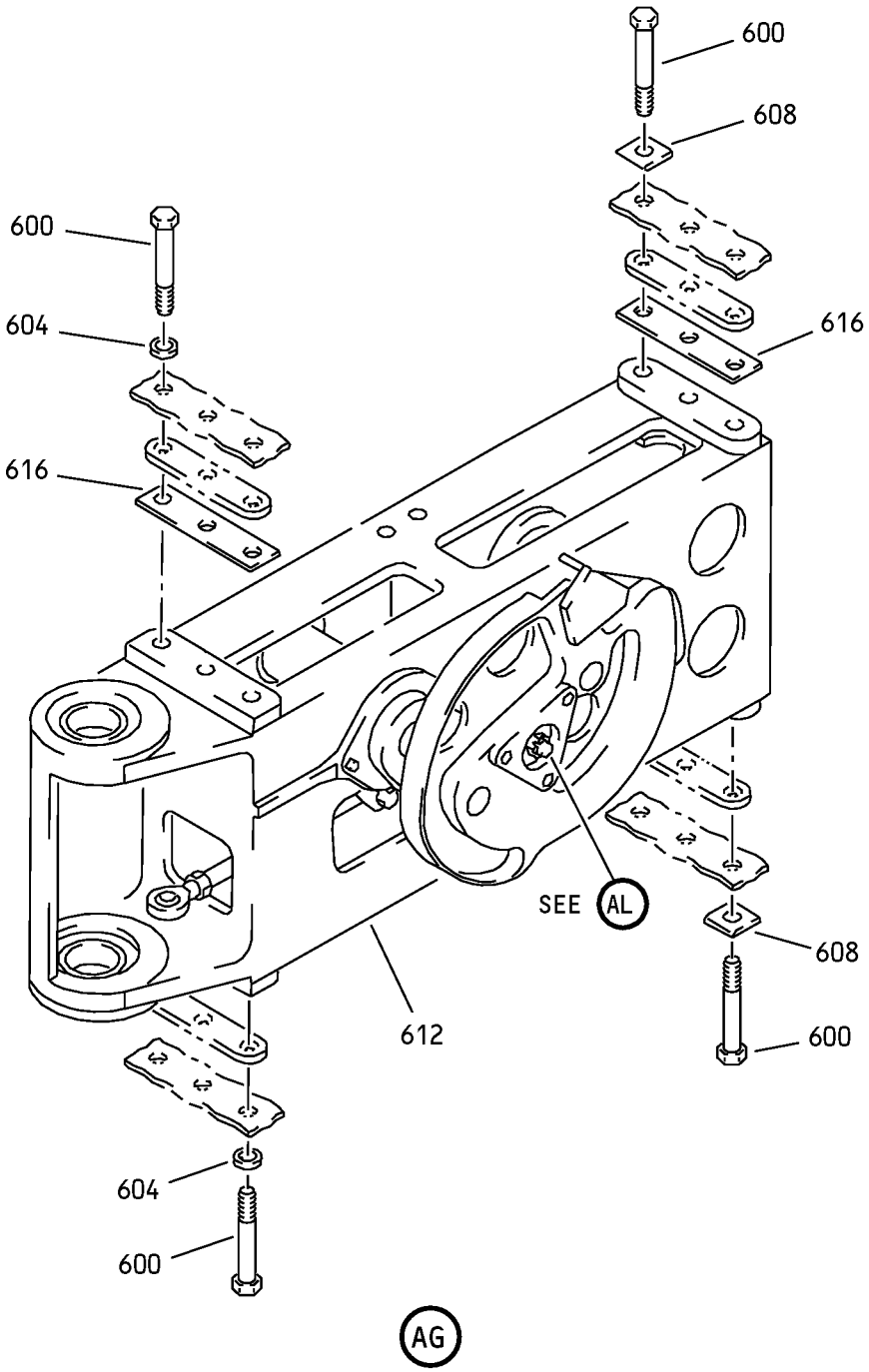
Aft Galley Door Assembly
IPL Figure 1 (Sheet 18 of 24)



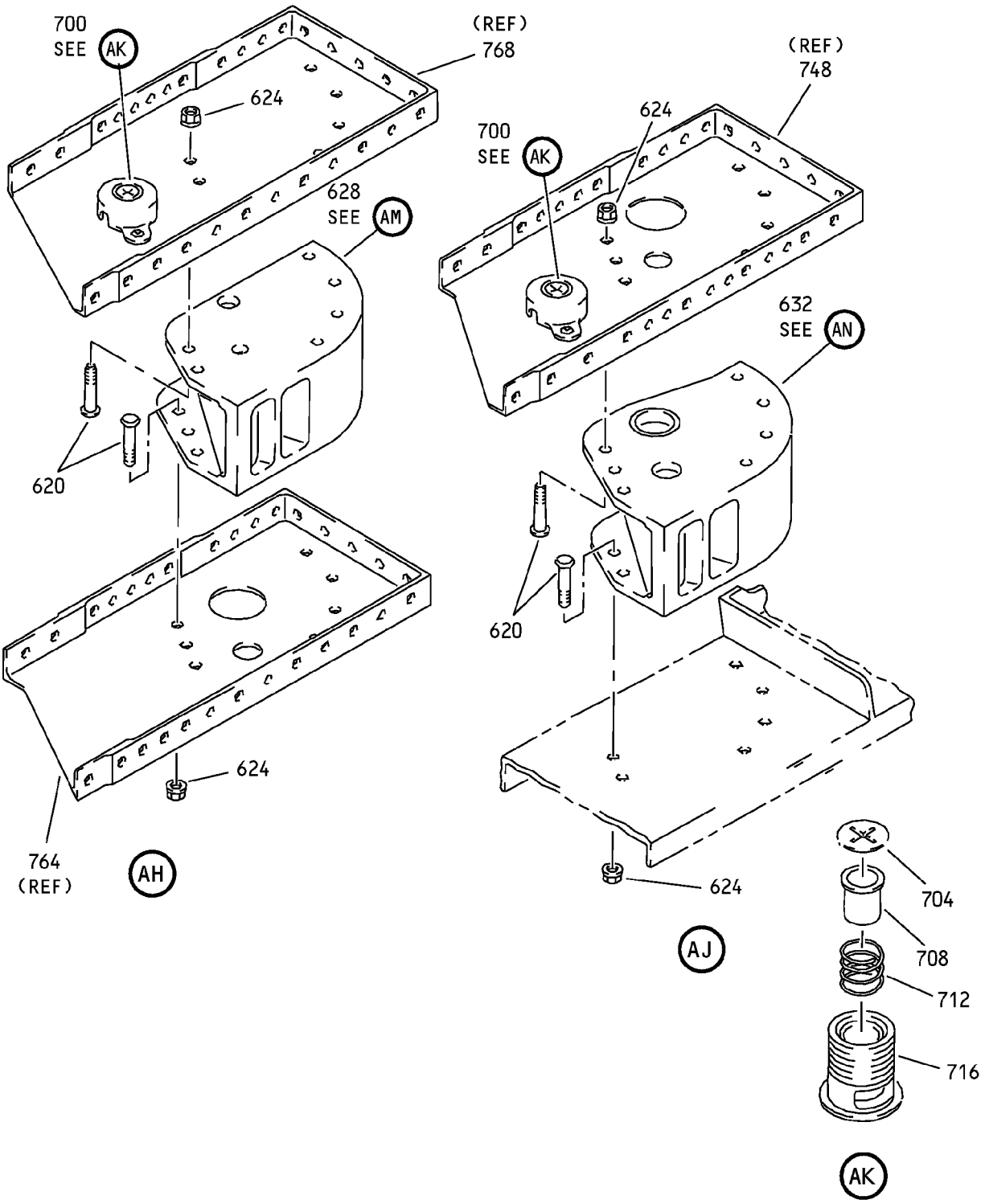
Aft Galley Door Assembly
IPL Figure 1 (Sheet 19 of 24)



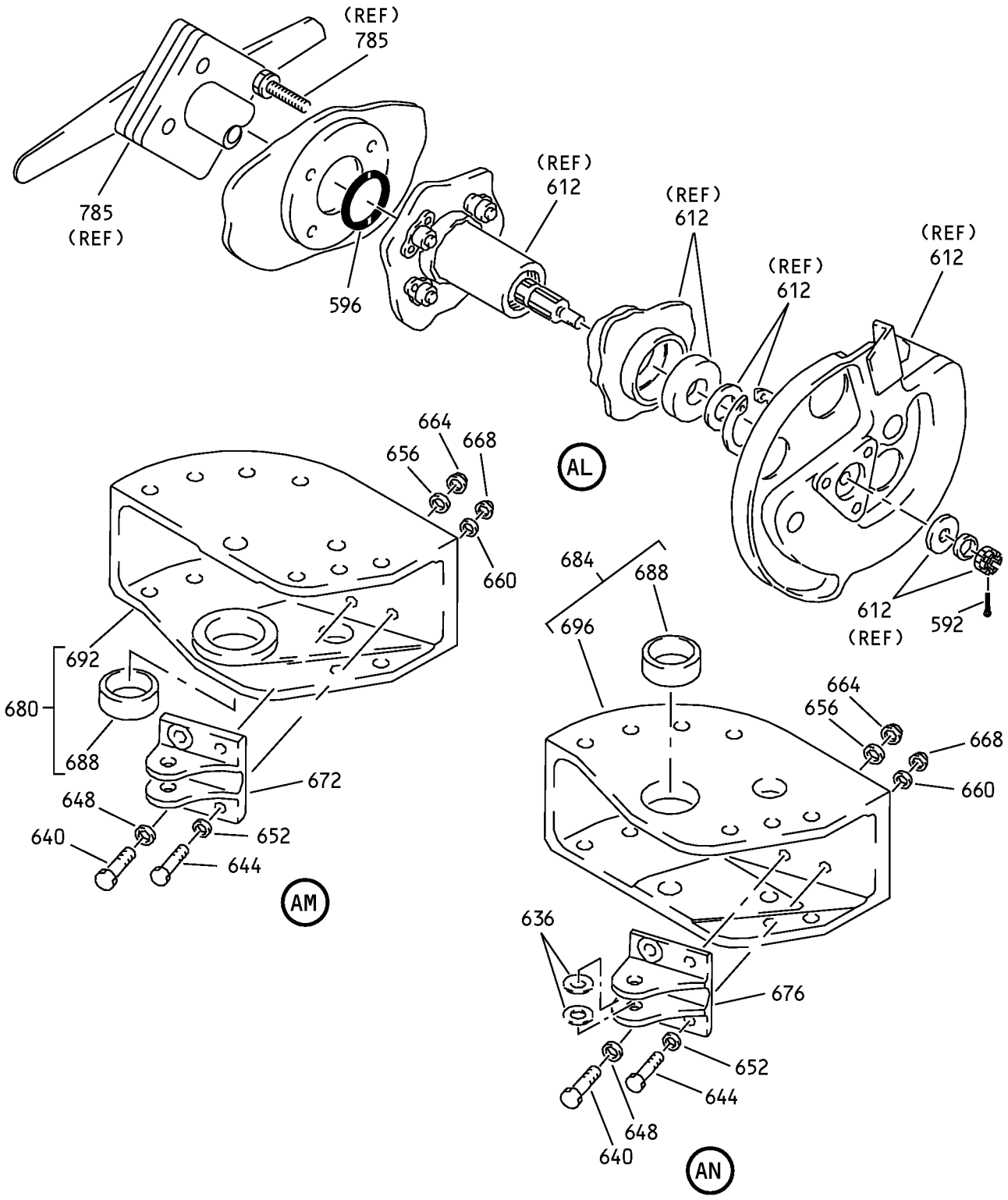
Aft Galley Door Assembly
IPL Figure 1 (Sheet 20 of 24)



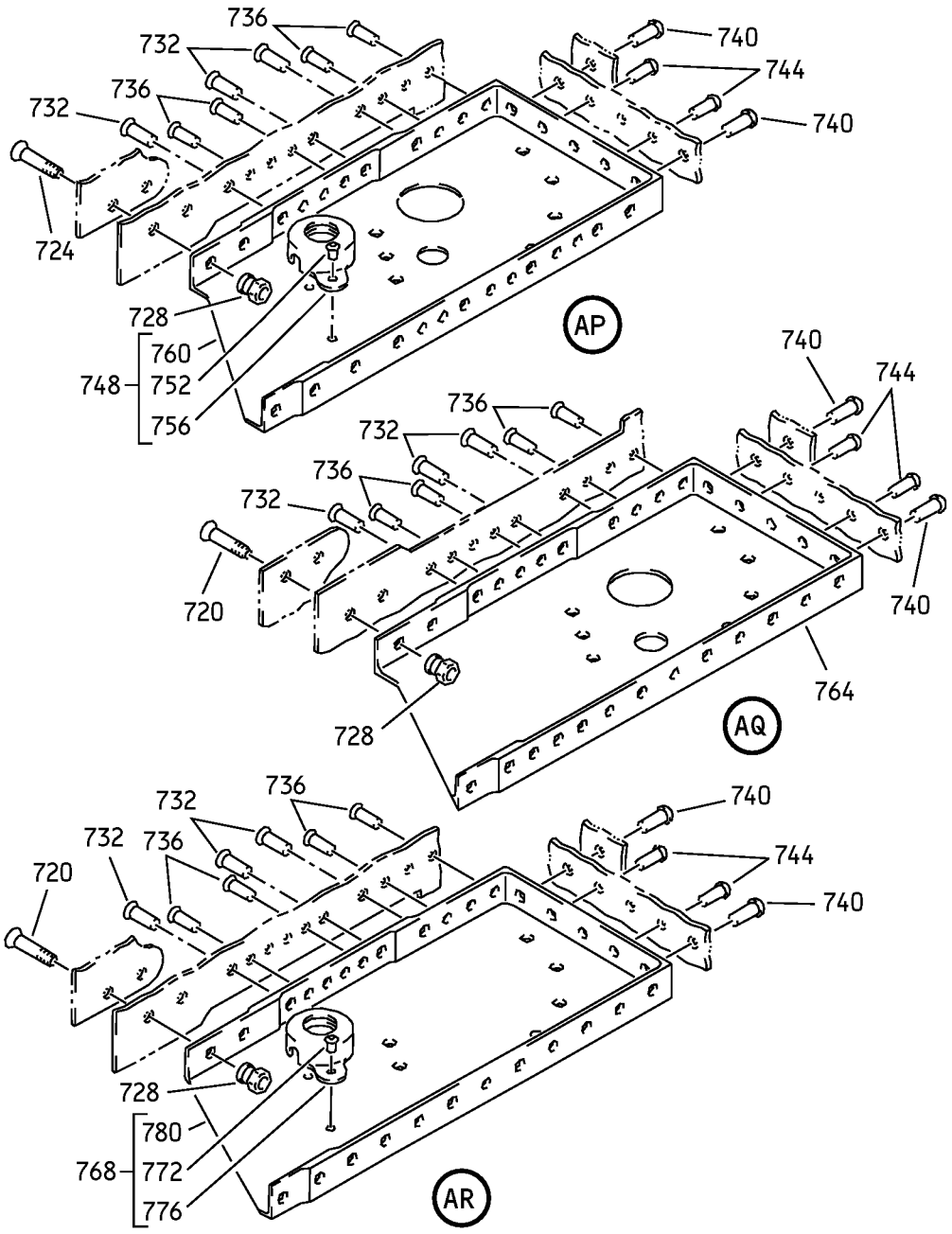
Aft Galley Door Assembly
IPL Figure 1 (Sheet 21 of 24)



Aft Galley Door Assembly
IPL Figure 1 (Sheet 22 of 24)



Aft Galley Door Assembly
IPL Figure 1 (Sheet 23 of 24)



Aft Galley 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	147A6502-1		DOOR ASSY-AFT GALLEY (FOR ADDITIONAL DETAILS SEE FIG. 2)	F	RF
–1B	147A6502-5		DELETED		
–1C	147A6502-6		DELETED		
–1D	147A6502-7		DELETED		
–1E	147A6502-8		DOOR ASSY-AFT GALLEY (FOR ADDITIONAL DETAILS SEE FIG. 2)	D	RF
–1F	147A6502-9		DOOR ASSY-AFT GALLEY (FOR ADDITIONAL DETAILS SEE FIG. 2)	E	RF
–1G	147A6502-2		DOOR ASSY-AFT GALLEY (FOR ADDITIONAL DETAILS SEE FIG. 2)	G	RF
–1H	147A6502-3		DOOR ASSY-AFT GALLEY (FOR ADDITIONAL DETAILS SEE FIG. 2)	H	RF
–1J	147A6502-4		DOOR ASSY-AFT GALLEY (FOR ADDITIONAL DETAILS SEE FIG. 2)	J	RF
–1K	147A6502-10		DOOR ASSY-AFT GALLEY (FOR ADDITIONAL DETAILS SEE FIG. 2)	K	RF
–1L	147A6502-11		DOOR ASSY-AFT GALLEY (FOR ADDITIONAL DETAILS SEE FIG. 2)	L	RF
–1M	147A6502-12		DOOR ASSY-AFT GALLEY (FOR ADDITIONAL DETAILS SEE FIG. 2)	A	RF
–1N	147A6502-13		DOOR ASSY-AFT GALLEY (FOR ADDITIONAL DETAILS SEE FIG. 2)	B	RF
–1P	147A6502-14		DOOR ASSY-AFT GALLEY (FOR ADDITIONAL DETAILS SEE FIG. 2)	C	RF
–1Q	147A6502-15		DOOR ASSY-AFT GALLEY (FOR ADDITIONAL DETAILS SEE FIG. 2)	M	RF

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
–1R	147A6502-16		DOOR ASSY-AFT GALLEY (FOR ADDITIONAL DETAILS SEE FIG. 2)	N	RF
–1S	147A6502-17		DOOR ASSY-AFT GALLEY (FOR ADDITIONAL DETAILS SEE FIG. 2)	P	RF
–1T	147A6502-18		DOOR ASSY-AFT GALLEY (FOR ADDITIONAL DETAILS SEE FIG. 2)	Q	RF
–1U	147A6502-19		DOOR ASSY-AFT GALLEY (FOR ADDITIONAL DETAILS SEE FIG. 2)	R	RF
–1V	147A6502-20		DOOR ASSY-AFT GALLEY (FOR ADDITIONAL DETAILS SEE FIG. 2)	S	RF
–1W	147A6502-21		DOOR ASSY-AFT GALLEY (FOR ADDITIONAL DETAILS SEE FIG. 2)	T	RF
–1X	147A6502-22		DOOR ASSY-AFT GALLEY (FOR ADDITIONAL DETAILS SEE FIG. 2)	U	RF
–1Y	147A6502-23		DOOR ASSY-AFT GALLEY (FOR ADDITIONAL DETAILS SEE FIG. 2)	V	RF
–1Z	147A6502-24		DOOR ASSY-AFT GALLEY (FOR ADDITIONAL DETAILS SEE FIG. 2)	W	RF
–2	147A6502-25		DOOR ASSY-AFT GALLEY (FOR ADDITIONAL DETAILS SEE FIG. 2)	X	RF
–2A	147A6502-26		DOOR ASSY-AFT GALLEY (FOR ADDITIONAL DETAILS SEE FIG. 2)	Y	RF
4	BACR15GK6E3		. RIVET		9
8	BACR15GK6E4		. RIVET		7
12	MS21141U6P4		. BOLT		1
16	149A9480-12		. HANDLE ASSY-ASSIST		1
20	BACR15BA3D		. . 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
1–					
24	BRF200C4D		. . NUTPLATE (V52828) (SPEC BACN10JR4CFD) (OPT K51602-4BAC (V15653)) (OPT NS202476-048 (V80539)) (OPT 102F9201-4 (V72962)) (OPT T8092C428CD (V11815))		2
28	66-9776		. . COLLAR		2
32	149A9480-50		. . BRACKET-HANDLE		1
–36	149A9480-10		DELETED		
36A	149A9480-68		. BRACKET ASSY		1
–36B	149A9480-74		DELETED		
40	BACR15BA3D		. . RIVET (SIZE DETERMINED ON INST)		2
44	BACR15BA5D		. . RIVET (SIZE DETERMINED ON INST)		2
48	BRF200C4D		. . NUTPLATE (V52828) (SPEC BACN10JR4CFD) (OPT K51602-4BAC (V15653)) (OPT NS202476-048 (V80539)) (OPT 102F9201-4 (V72962)) (OPT T8092C428CD (V11815))		1
–52	149A9480-53		DELETED		
52A	149A9480-73		. . SPACER		1
–52B	149A9480-71		DELETED		
56	BACB30NT3K1		. . SCREW		3
60	NAS1149D0332J		. . WASHER		3
64	BACR15BA4D		. . RIVET (SIZE DETERMINED ON INST)		6
68	SL2752-3		. . MOUNT (V97393) (SPEC BACS14K2) (OPT DE679-10 (V71985))		3
72	149A9480-28		. . BRACKET		1
76	149A9480-60		. . BACKPLATE		1
80	149A9480-9		. BRACKET ASSY	A, D-L	1
–80A	149A9480-77		. BRACKET ASSY	C, M	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–					
–80B	149A9480-79		. BRACKET ASSY	B, N-Y	1
84	BACB30NT3K16		. . BOLT		2
88	NAS1149D0363J		. . WASHER		2
92	H52732-3CD		. . NUT (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))		2
96	BACR15FT5D		. . RIVET (SIZE DETERMINED ON INST)		4
100	149A9480-48		. . STOP		1
104	149A9480-38		. . STOP		1
108	149A9480-52		. . BRACKET	A, D-L	1
–108A	149A9480-78		. . BRACKET	C, M	1
–108B	149A9480-80		. . BRACKET	B, N-Y	1
112	BACB30NT3K3		. BOLT	A-S, V-Y	7
–112A	BACB30NT3K4		. BOLT	T, U	7
116	BACW10CT6J		. WASHER		7
120	BACR15CTE3CW3		. RIVET	A-U	14
–120A	BACR15GE3CW3		. RIVET	V-Y	14
124	NS202493-02-2		. NUTPLATE (V80539) (SPEC BACN10KE3B2CD) (OPT BRFR220C3-2D (V52828)) (OPT F51747-3-2CD (V15653)) (OPT 102A9213-2-3 (V72962))		7
–128	149A9480-11		DELETED		
128A	149A9480-70		. BRACKET ASSY		1
–128B	149A9480-75		DELETED		
132	BACR15BA3D		. . RIVET (SIZE DETERMINED ON INST)		2
136	BACR15BA5D		. . RIVET (SIZE DETERMINED ON INST)		2

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
140	BRF200C4D		. . NUTPLATE (V52828) (SPEC BACN10JR4CFD) (OPT K51602-4BAC (V15653)) (OPT NS202476-048 (V80539)) (OPT 102F9201-4 (V72962)) (OPT T8092C428CD (V11815))		1
–144	149A9480-33		DELETED		
144A	149A9480-72		. . SPACER		1
–144B	149A9480-76		DELETED		
148	BACB30NT3K1		. . SCREW		3
152	NAS1149D0332J		. . WASHER		3
156	BACR15BA4D		. . RIVET (SIZE DETERMINED ON INST)		6
160	SL2750		. . ISOLATOR (V97393) (SPEC BACS14K4) (OPT DE675-10 (V71985))		3
164	149A9480-56		. . BRACKET		1
168	149A9480-29		. . BACKPLATE		1
172	BACS40R008C030F		. SHIM	F, V-Y	AR
176	BACS40R008C037F		. SHIM	F, V-Y	AR
180	BACB30NT3K3		. BOLT		24
–180A	BACB30NT3K4		DELETED		
182	BACB30NT3K3		. BOLT	A-S	10
–182A	BACB30NT3K4		. BOLT	T-Y	10
184	BACW10CT6J		. WASHER		34
188	BACR15GE3CW3		. RIVET		40
192	BACR15BA3AD		. RIVET (SIZE DETERMINED ON INST)		12
196	NS202493-02-2		. NUTPLATE (V80539) (SPEC BACN10KE3B2CD) (OPT BRFR220C3-2D (V52828)) (OPT F51747-3-2CD (V15653)) (OPT 102A9213-2-3 (V72962))		17

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
200	NS202494-02-2		. NUTPLATE (V80539) (SPEC BACN10KE3E2CD) (OPT 102F9216-2-3 (V72962)) (OPT F51751-3-2CD (V15653)) (OPT BRFR120C3-2D (V52828))		9
204	141A6553-4		. PLATE-COVER		2
208	141A6553-3		. PLATE-COVER		1
212	141A6553-2		. PLATE-COVER		1
216	BACR15GK6E4		. RIVET		8
220	SL2808-3		. SHOCKMOUNT (V97393) (SPEC BACS14K1) (OPT DE685-10 (V71985))		4
224	HR3253-5-3		. RIVET (V0HDW7) (SPEC BACR15GJ5E3)		4
228	BACR15BB4D		. RIVET (SIZE DETERMINED ON INST)		8
232	SL2509		. SHOCKMOUNT (V97393) (SPEC BACS14K7) (OPT J7444-11 (V76005)) (OPT DE586 (V71985))		4
236	147A6161-2		. LINING ASSY-RTNR		1
240	82-99-341-18		. . STUD (V94222) (SPEC BACS21AP180RP)		4
244	BACR12AG2C		. . RING		4
248	147A6161-4		. . RETAINER		1
252	BACR15GK6E3		. RIVET		183
256	BACR15GK6E4		. RIVET		18
260	BACR15GK6E2		. RIVET		65
264	HR3253-5-3		. RIVET (V0HDW7) (SPEC BACR15GJ5E3)		4
268	MS21141U6P4		. BOLT		12

–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	BACR15GF5D		. RIVET (SIZE DETERMINED ON INST)		25
276	147A6152-4		. SKIN ASSY-UPR	A-S	1
–276A	147A6152-16		. SKIN ASSY-UPR	T-Y	1
280	BACR15BA3AD		. . RIVET (SIZE DETERMINED ON INST)		8
284	F51643-3BAC		. . NUTPLATE (V15653) (SPEC BACN10JZ3A2CDM) (OPT 102F9219-3 (V72962)) (OPT NS202492-02 (V80539))	A-S	4
–284A	BACN10JZ3A2CD˜MU		. . NUTPLATE	T-Y	4
285	NAS463XDD10H		. . SPACER	T-Y	4
288	BACR15FT5D		. . RIVET (SIZE DETERMINED ON INST)		12
292	BACW10P182AL		. . WASHER		12
296	SL2808-3		. . SHOCKMOUNT (V97393) (SPEC BACS14K1) (OPT DE685-10 (V71985))		6
300	147A6152-8		. . SKIN		1
304	147A6152-2		. SKIN ASSY	D-J, L	1
–304A	147A6152-12		. SKIN ASSY	A-C, K, M-S	1
–304B	147A6152-14		. SKIN ASSY	T-Y	1
308	BACR15BA3AD		. . RIVET (SIZE DETERMINED ON INST)		8
312	F51643-3BAC		. . NUTPLATE (V15653) (SPEC BACN10JZ3A2CDM) (OPT 102F9219-3 (V72962)) (OPT NS202492-02 (V80539))	A-S	4
–312A	BACN10JZ3A2CD˜MU		. . NUTPLATE	T-Y	4
313	NAS463XDD10H		. . SPACER	T-Y	4
316	BACR15FT5D		. . RIVET (SIZE DETERMINED ON INST)		8

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
320	BACW10P182AL		. . WASHER		8
324	SL2808-3		. . SHOCKMOUNT (V97393) (SPEC BACS14K1) (OPT DE685-10 (V71985))		4
328	147A6152-6		. . SKIN		1
332	BACS40R008C008F		. SHIM	F, V-Y	AR
336	BACS40R007B008F		. SHIM	F, V-Y	AR
340	BACB30NM3K3		. BOLT		3
344	BACW10BN3AC		. WASHER		3
348	BACR15GF4D		. RIVET (SIZE DETERMINED ON INST)		6
352	T8059S1032B1		. NUTPLATE (V52828) (SPEC BACN10MK3-45) (OPT T8059S1032B1 (V11815))		3
356	65-2863-8		. WINDOW ASSY-OBSV (FOR DETAILS SEE FIG. 3)	A-U	1
358	141A6570-1		. WINDOW ASSY-OBSV (FOR DETAILS SEE FIG. 8)	V-Y	1
360	HST11AG6-5		. BOLT (V06725) (SPEC BACB30VU6K5) (OPT HST11AG6-5 (V73197)) (OPT HST11AG6-5 (V56878)) (OPT HST11AG6-5 (V0PTK6))		4
364	HST11AG5-5		. BOLT (V06725) (SPEC BACB30VU5K5) (OPT HST11AG5-5 (V73197)) (OPT HST11AG5-5 (V0PTK6)) (OPT HST11AG5-5 (V56878))		6
368	HST79CY6		. COLLAR (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V56878)) (OPT HST79-6 (V92215)) (OPT HST79-6 (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
1–					
372	HST79CY5		. COLLAR (V73197) (SPEC BACC30BL5) (OPT HST79-5 (V92215)) (OPT HST79-5 (V56878)) (OPT HST79-5 (V5M902))		6
376	BACR15GF6D		. RIVET (SIZE DETERMINED ON INST)		10
380	BACR15GF5D		. RIVET (SIZE DETERMINED ON INST)		17
384	149A6112-2		. DOUBLER-WINDOW		1
388	BACB30NM4K17		. BOLT		2
392	BACB30NM4K13		. BOLT		2
396	BACW10BN4AC		. WASHER		2
400	NAS1149D0463J		. WASHER		2
404	NAS1149E0432R		. WASHER		2
408	H52732-4CD		. NUT (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))		2
412	H52732-4CM		. NUT (V15653) (SPEC BACN10YR4CM) (OPT PLH54CM (V62554))		2
416	BACB28AK04-030		. BUSHING		2
420	69-18187-25		. ROD ASSY-CONT		1
424	69-18187-26		. ROD ASSY-CONT		1
428	AN316-5R		. . NUT		1
432	10E4-116NW		. . BEARING (V16746) (SPEC BACB10Y4) (OPT BRES4-2236L2 (V81376)) (OPT HB4E212K (V02758)) (OPT KBE4-150AFNW (V97613)) (OPT 51588-041 (V09455)) (OPT MSSK4ASFG (V73134)) (OPT ASMK4F1 (V56644)) (OPT AR4E7AFNW (VS0352)) (OPT 10E4-116 (V16746)) (OPT ARB4E60FNW (V15860))		1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
436	MS20470D5		. . RIVET (SIZE DETERMINED ON INST)		1
440	AB4E27FN12		. . BEARING (V15860) (SPEC BACB10A187M2L) (OPT BRE4795L (V81376)) (OPT HB4E140 (V02758)) (OPT KB4ESSD6FN (V97613)) (OPT MXJ45-14BFG2 (V73134)) (OPT 5164-0402DD (V09455)) (OPT AR4E4FN12 (VS0352)) (OPT ASM4F6DM (V56644)) (OPT ITEM 440A)		1
–440A	AB4E27FN		. . BEARING (V15860) (SPEC BACB10A187L) (OPT ASM4F6 (V56644)) (OPT BRE4140L (V81376)) (OPT HB4E135 (V02758)) (OPT KB4ESSFN (V97613)) (OPT MXJ45-14BFG (V73134)) (OPT 51564-0402 (V09455)) (OPT AR4E4FN (VS0352)) (OPT ITEM 440)		1
444	66-14618-6		. . ROD (USED ON ITEM 420)		1
448	66-14618-7		. . ROD (USED ON ITEM 424)		1
452	65-45871-504		. ROD-NYLON (MAKE FROM ROD NYLON PER MILP20693A TYPE I NAT COLOR OPT MAT LP410A NYLON 6/6 COMMERCIAL GRADE 1.28 FT .094 IN DIA 15.3 IN LG)		8
456	S14162-4		. SEAL-DOOR (V75345) (SPEC 10-60476-4) (OPT 8675-4 (V75345))		1
–456A	8675-4		. SEAL-DOOR (V75345) (SPEC 10-60476-4) (OPT S14162-4 (V75345))		1

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
460	BACR15BA5B		. RIVET (SIZE DETERMINED ON INST)		60
464	147A6514-1		. GATE ASSY-UPR END (FOR DETAILS SEE FIG. 4)	D-J, L	1
–464A	147A6514-2		. GATE ASSY-UPR END (FOR DETAILS SEE FIG. 4)	A-C, K, M, N	1
–464B	147A6514-3		. GATE ASSY-UPR END (FOR DETAILS SEE FIG. 4)	P-W	1
–464C	147A6514-4		. GATE ASSY-UPR END (FOR DETAILS SEE FIG. 4)	X, Y	1
468	147A6143-2		. GATE ASSY-LWR END (FOR DETAILS SEE FIG. 5)	D-J, L	1
–468A	147A6143-6		. GATE ASSY-LWR END (FOR DETAILS SEE FIG. 5)	A-C, K, M, N	1
–468B	147A6143-10		. GATE ASSY-LWR END (FOR DETAILS SEE FIG. 5)	P-W	1
–468C	147A6143-12		. GATE ASSY-LWR END (FOR DETAILS SEE FIG. 5)	X, Y	1
472	BACB30NT3K6		. BOLT		3
476	BACB30NT3K5		. BOLT		16
480	BACW10CT6J		. WASHER		19
484	147A6134-4		. HINGE ASSY-GATE		1
488	147A6134-2		. HINGE ASSY-GATE		1
492	MS39086-125		. . PIN-SPR		2
496	MS20253P2-2910		. . PIN-HINGE		1
500	147A6134-8		. . HINGE-HALF (USED ON ITEM 484)		1
504	147A6134-6		DELETED		
504A	147A6134-7		. . HINGE-HALF (USED ON ITEM 488)		1
508	147A6134-9		. . HINGE-HALF		1
512	BACB30NR4K12		. BOLT		2
516	BACB30NM4K13		. BOLT		2
520	BACW10BN4AC		. WASHER		2
524	NAS1149E0432R		. 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–					
528	H52732-4CM		. NUT (V15653) (SPEC BACN10YR4CM) (OPT PLH54CM (V62554))		2
532	65-28925-85		. ROD ASSY-CONT	A, C-M	1
–532A	65-28925-100		. ROD ASSY-CONT	B, N-Y	1
536	65-28925-86		. ROD ASSY-CONT	A, C-M	1
–536A	65-28925-101		. ROD ASSY-CONT	B, N-Y	1
540	MS20470D3		. . RIVET (SIZE DETERMINED ON INST)		1
544	AN316-5R		. . NUT		2
548	AB4E27FN		. . BEARING (V15860) (SPEC BACB10A187L) (OPT ASM4F6 (V56644)) (OPT BRE4140L (V81376)) (OPT HB4E135 (V02758)) (OPT KB4ESSFN (V97613)) (OPT MXJ45-14BFG (V73134)) (OPT 51564-0402 (V09455)) (OPT AR4E4FN (VS0352))	A, C-M	1
–548A	10E4-116NW		. . BEARING (V16746) (SPEC BACB10Y4) (OPT BRES4-2236L2 (V81376)) (OPT HB4E212K (V02758)) (OPT KBE4-150AFNW (V97613)) (OPT 51588-041 (V09455)) (OPT MSSK4ASFG (V73134)) (OPT ASMK4F1 (V56644)) (OPT AR4E7AFNW (VS0352)) (OPT 10E4-116 (V16746)) (OPT ARB4E60FNW (V15860))	B, N-Y	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–					
552	10E4-116NW		. . BEARING (V16746) (SPEC BACB10Y4) (OPT BRES4-2236L2 (V81376)) (OPT HB4E212K (V02758)) (OPT KBE4-150AFNW (V97613)) (OPT 51588-041 (V09455)) (OPT MSSK4ASFG (V73134)) (OPT ASMK4F1 (V56644)) (OPT AR4E7AFNW (VS0352)) (OPT 10E4-116 (V16746)) (OPT ARB4E60FNW (V15860))		1
556	65-28925-47		. . ROD (USED ON ITEM 532)	A, C-M	1
–556A	65-28925-104		. . ROD (USED ON ITEM 532A)	B, N-Y	1
560	65-28925-48		. . ROD (USED ON ITEM 536)	A, C-M	1
–560A	65-28925-105		. . ROD (USED ON ITEM 536A)	B, N-Y	1
564	M83461-1-214		. PACKING		2
568	NAS1149C1790R		. WASHER		2
572	66-15645-1		. SPRING-CPRSN		2
576	BACB30NM5K16		. BOLT		1
580	NAS1149E0563R		. WASHER		1
584	H52732-5CM		. NUT (V15653) (SPEC BACN10YR5CM) (OPT PLH55CM (V62554))		1
588	147A6503-1		. TUBE ASSY-TORQUE (FOR DETAILS SEE FIG. 6)	F, G	1
–588A	147A6503-2		. TUBE ASSY-TORQUE (FOR DETAILS SEE FIG. 6)	H	1
–588B	147A6503-3		. TUBE ASSY-TORQUE (FOR DETAILS SEE FIG. 6)	E, J	1
–588C	147A6503-4		. TUBE ASSY-TORQUE (FOR DETAILS SEE FIG. 6)	A-D, K-Y	1
592	BACP18BC03A08P		. PIN-COTTER		1
596	M83461-1-325		. PACKING		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–					
600	BACB30NM4K19		. BOLT		12
604	BACW10BN4AC		. WASHER		6
608	BACF3H06JK006HN		. FILLER	F	6
612	147A6505-2		. BOX ASSY-HANDLE (FOR DETAILS SEE FIG. 7)		1
616	BACS40R008C042F		. SHIM	F	AR
620	HST10AG6-4		. BOLT (V06725) (SPEC BACB30VT6K4) (OPT HST10AG6-4 (V73197)) (OPT HST10AG6-4 (V56878)) (OPT HST10AG6-4 (V0PTK6))		26
624	CR6551-3		. NUT (VF0224) (SPEC BACN10ZV3)		26
628	147A6140-4		. SUPPORT ASSY-UPR HINGE		1
632	147A6140-2		. SUPPORT ASSY-LWR HINGE		1
636	NAS1149D0532J		. . WASHER (SELECT FROM) (USED ON ITEM 632)		AR
–636A	NAS1149D0516J		. . WASHER (SELECT FROM) (USED ON ITEM 632)		AR
640	BACB30NM4K11		. . BOLT		2
644	BACB30NM3K11		. . BOLT (V06710) (SPEC BACB30NM3K11)		2
648	BACW10BN4AC		. . WASHER		2
652	BACW10CT6J		. . WASHER		2
656	BACW10BN4AP		. . WASHER		2
660	NAS620A10L		. . WASHER		2
664	NAS1805-4L		. . NUT		2
668	NAS1805-3L		. . NUT		2
672	69-70268-2		. . FITTING-ATTACH (FOR SPARES PROCURE 69-70268U2) (USED ON ITEM 628)		1

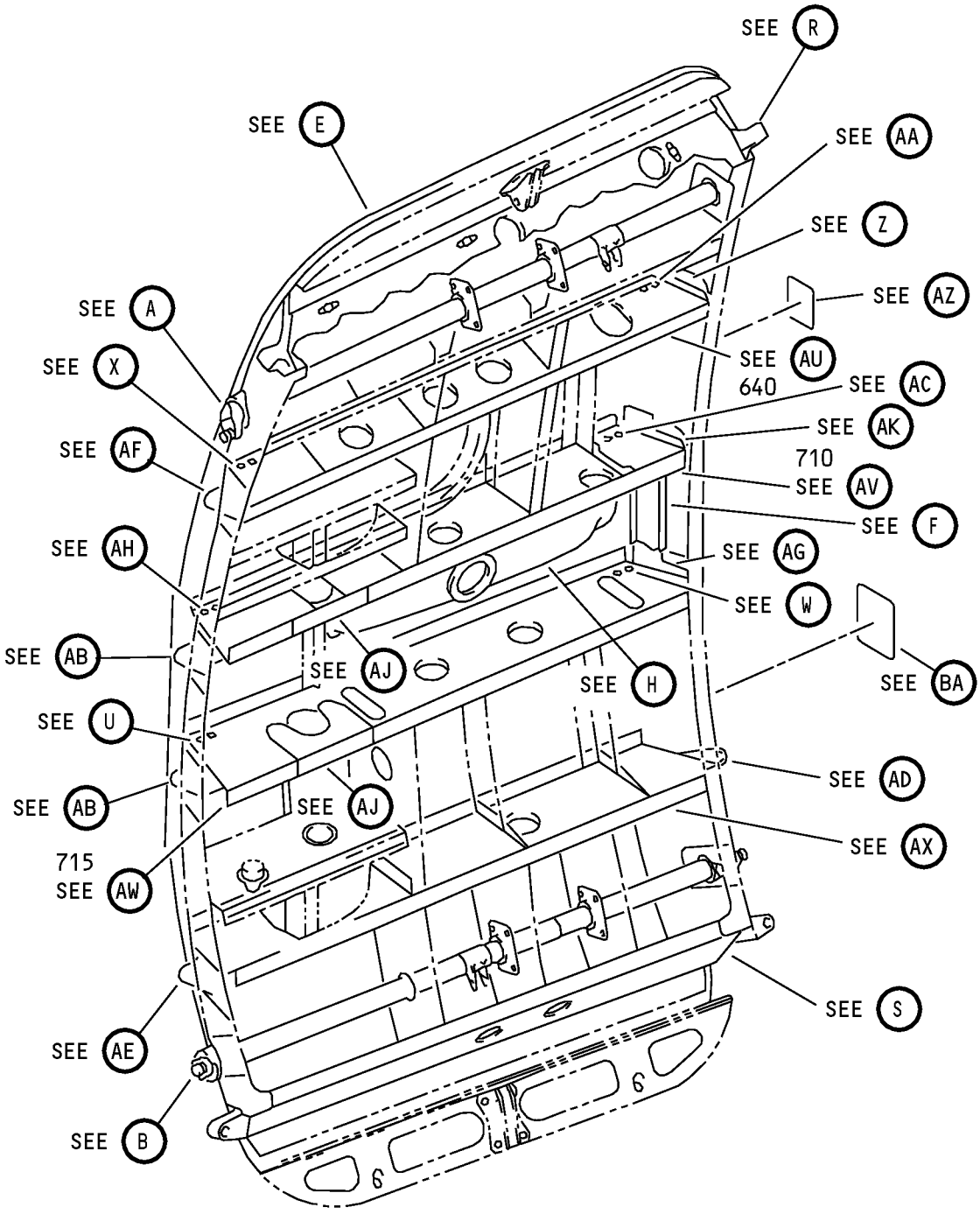
–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
676	147A6162-1		. . FITTING-ATTACH (USED ON ITEM 632)		1
680	147A6140-5		. . SUPPORT ASSY (USED ON ITEM 628)		1
684	147A6140-6		. . SUPPORT ASSY (USED ON ITEM 632)		1
688	NAS76A16-016P		. . . BUSHING		1
692	147A6140-7		. . . SUPPORT (USED ON ITEM 680)		1
696	147A6140-8		. . . SUPPORT (USED ON ITEM 684)		1
700	140N2022-1		. VALVE ASSY-DRAIN		2
704	140N2022-4		. . CAP		1
708	140N2022-3		. . PLUNGER		1
712	140N2020-1		. . SPRING		1
716	140N2022-2		. . HOUSING		1
720	HST11AG6-3		. BOLT (V06725) (SPEC BACB30VU6K3) (OPT HST11AG6-3 (V73197)) (OPT HST11AG6-3 (V56878)) (OPT HST11AG6-3 (V0PTK6))		4
724	HST11AG6-4		. BOLT (V06725) (SPEC BACB30VU6K4) (OPT HST11AG6-4 (V73197)) (OPT HST11AG6-4 (V56878)) (OPT HST11AG6-4 (V0PTK6))		2
728	HST79CY6		. COLLAR (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V56878)) (OPT HST79-6 (V92215)) (OPT HST79-6 (V5M902))		6
732	BACR15GF6D		. RIVET (SIZE DETERMINED ON INST)		9
736	BACR15GF5D		. RIVET (SIZE DETERMINED ON INST)		19

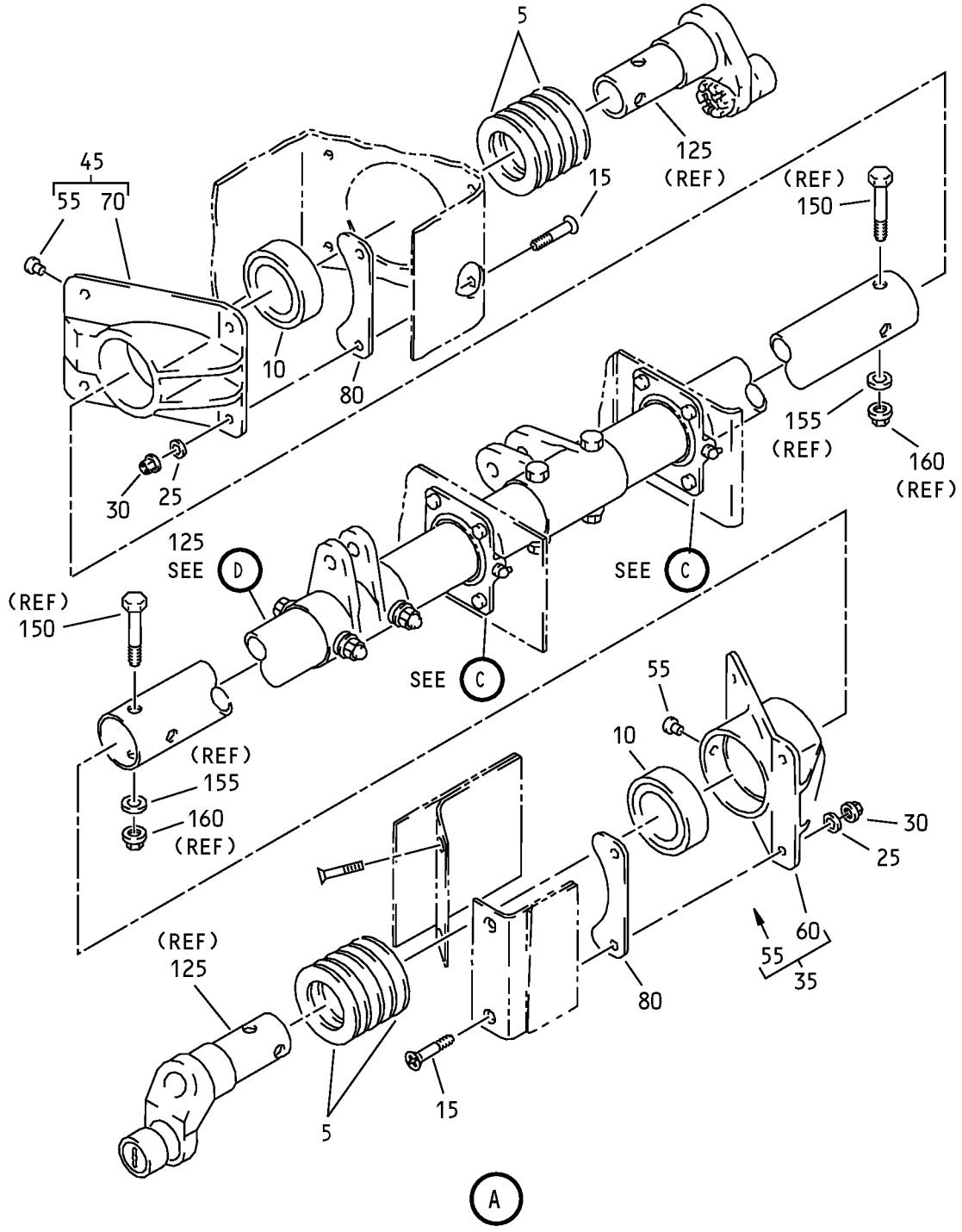
–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
740	BACR15FT6D		. RIVET (SIZE DETERMINED ON INST)		6
744	BACR15FT5D		. RIVET (SIZE DETERMINED ON INST)		9
748	147A6149-2		. BEAM ASSY-HINGE SPRT		1
752	BACR15BB4AD		. . RIVET (SIZE DETERMINED ON INST)		2
756	140N2021-1		. . RETAINER-DRAIN VALVE		1
760	147A6149-6		. . BEAM-STUB		1
764	147A6149-10		. BEAM-STUB		1
768	147A6149-4		. BEAM ASSY-HINGE SPRT		1
772	BACR15BB4D		. . RIVET (SIZE DETERMINED ON INST)		2
776	140N2021-1		. . RETAINER-DRAIN VALVE		1
780	147A6149-8		. . BEAM-STUB		1
			DELETED		

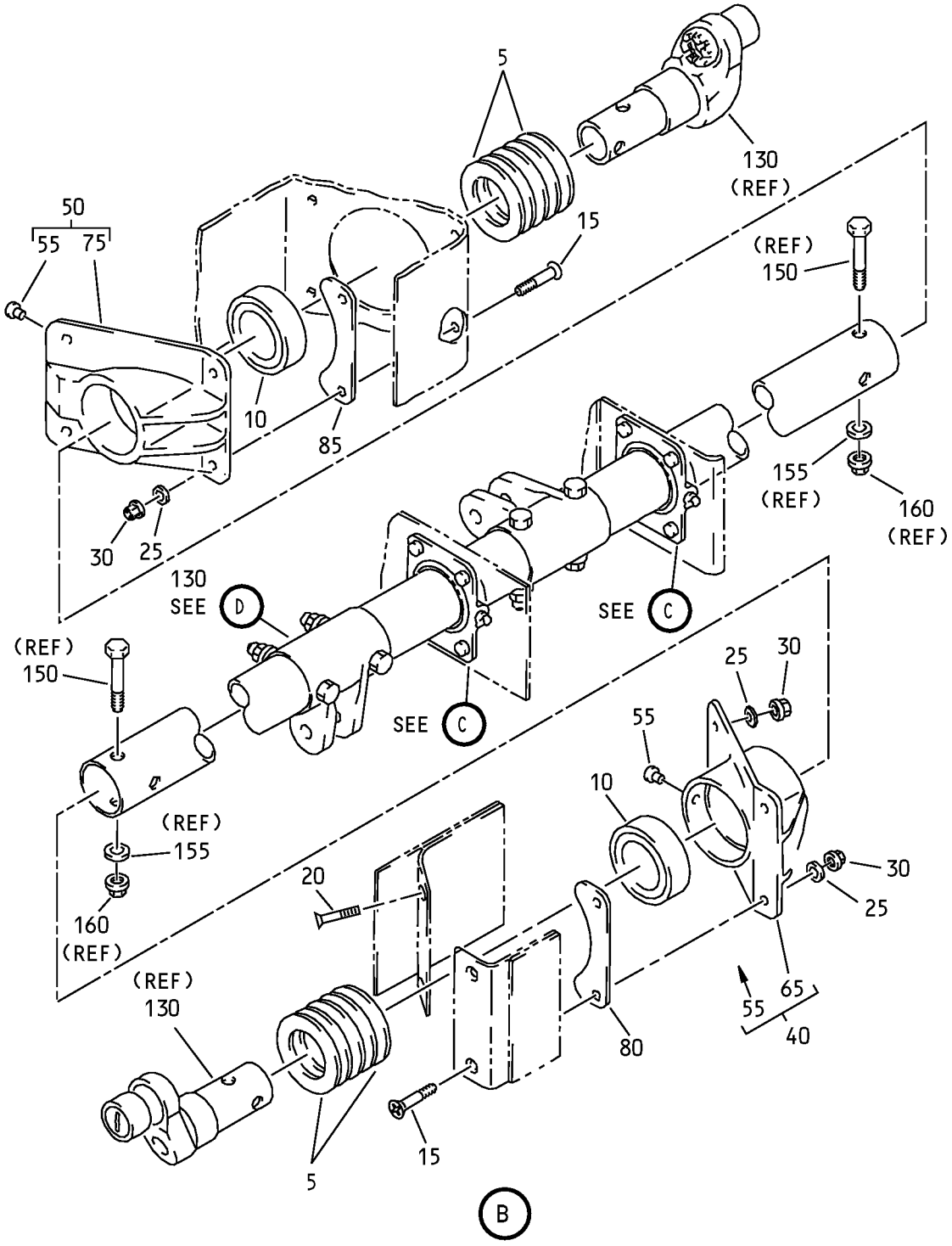
–Item not Illustrated



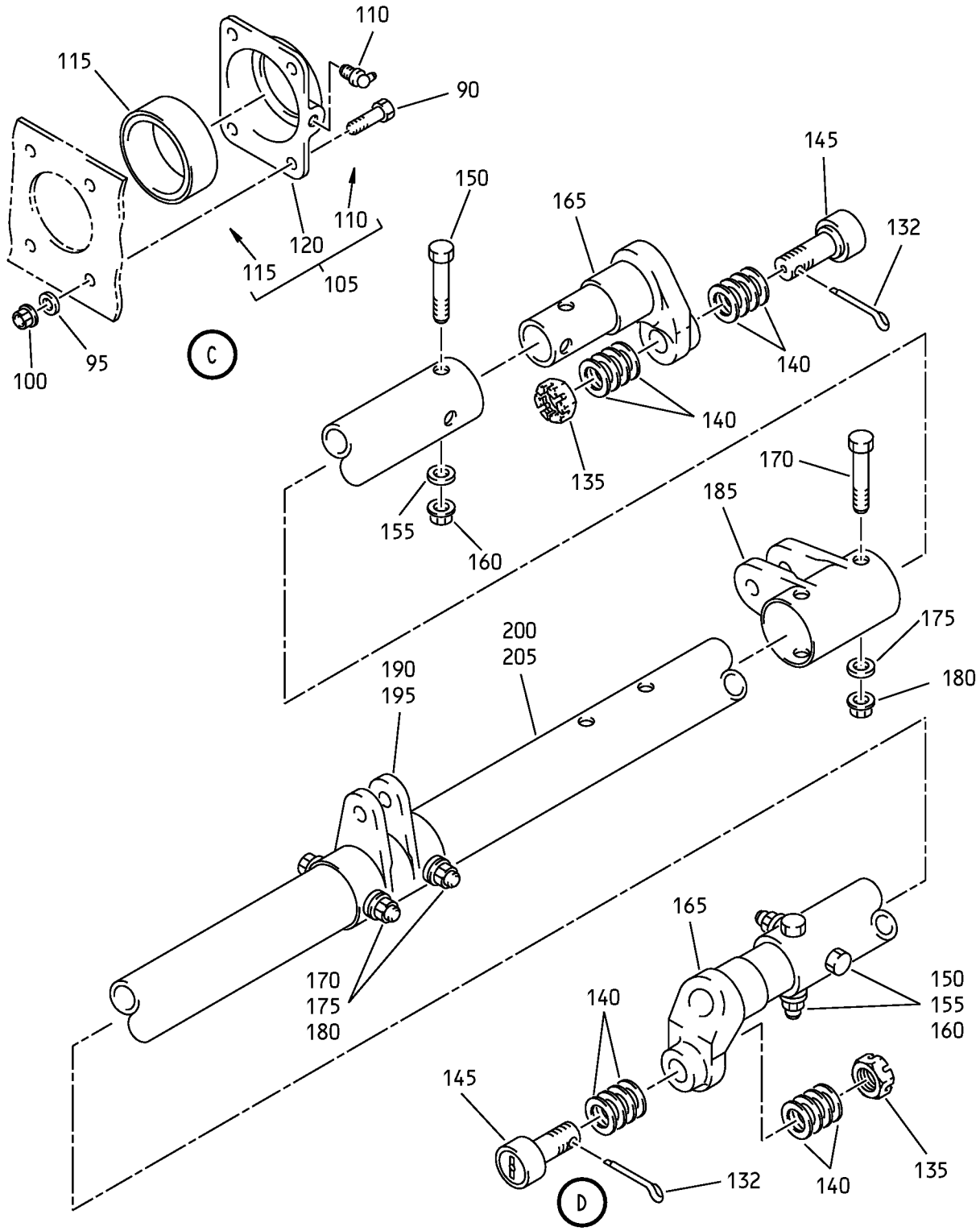
Aft Galley Door Assembly
IPL Figure 2 (Sheet 1 of 28)



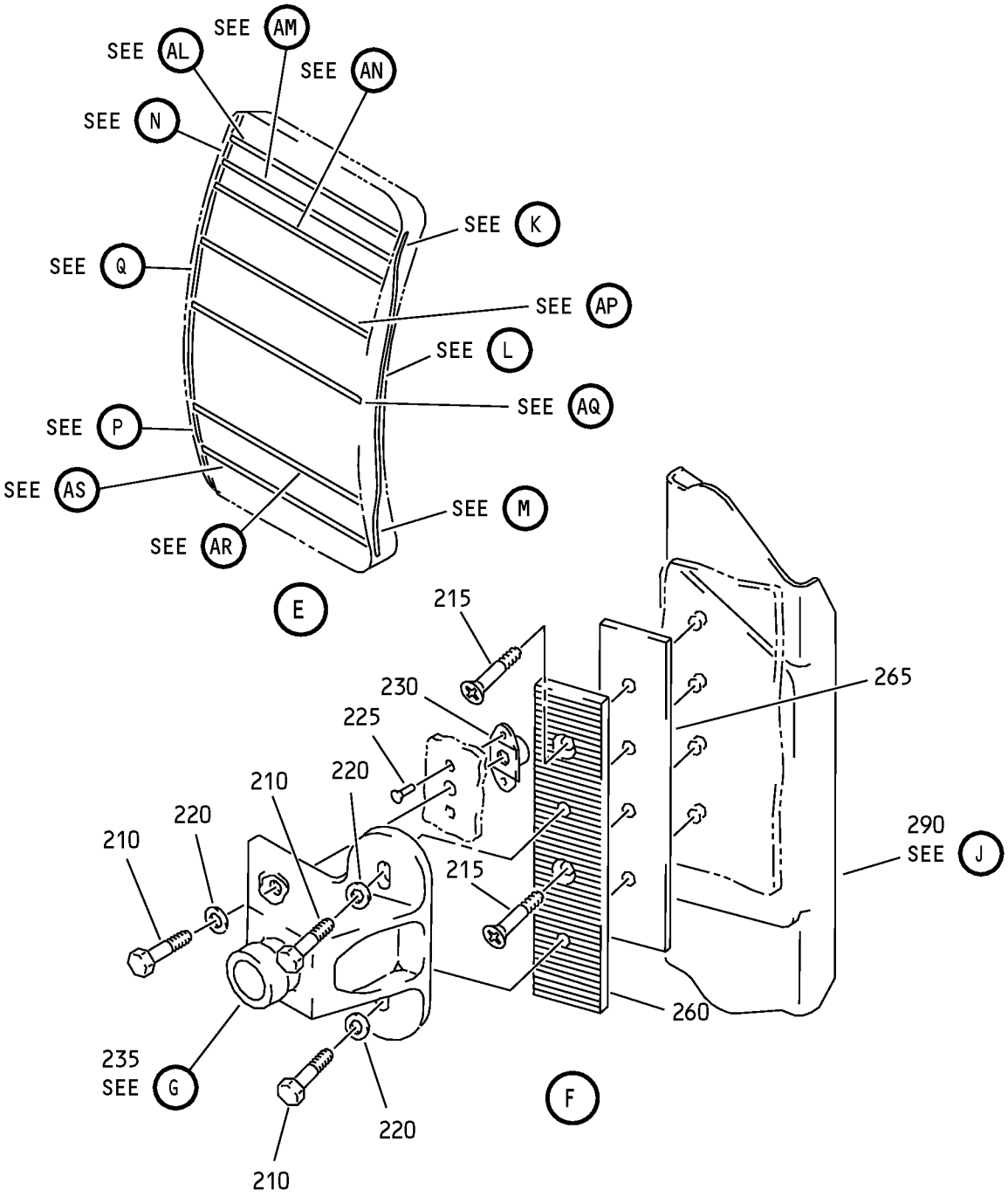
Aft Galley Door Assembly
IPL Figure 2 (Sheet 2 of 28)



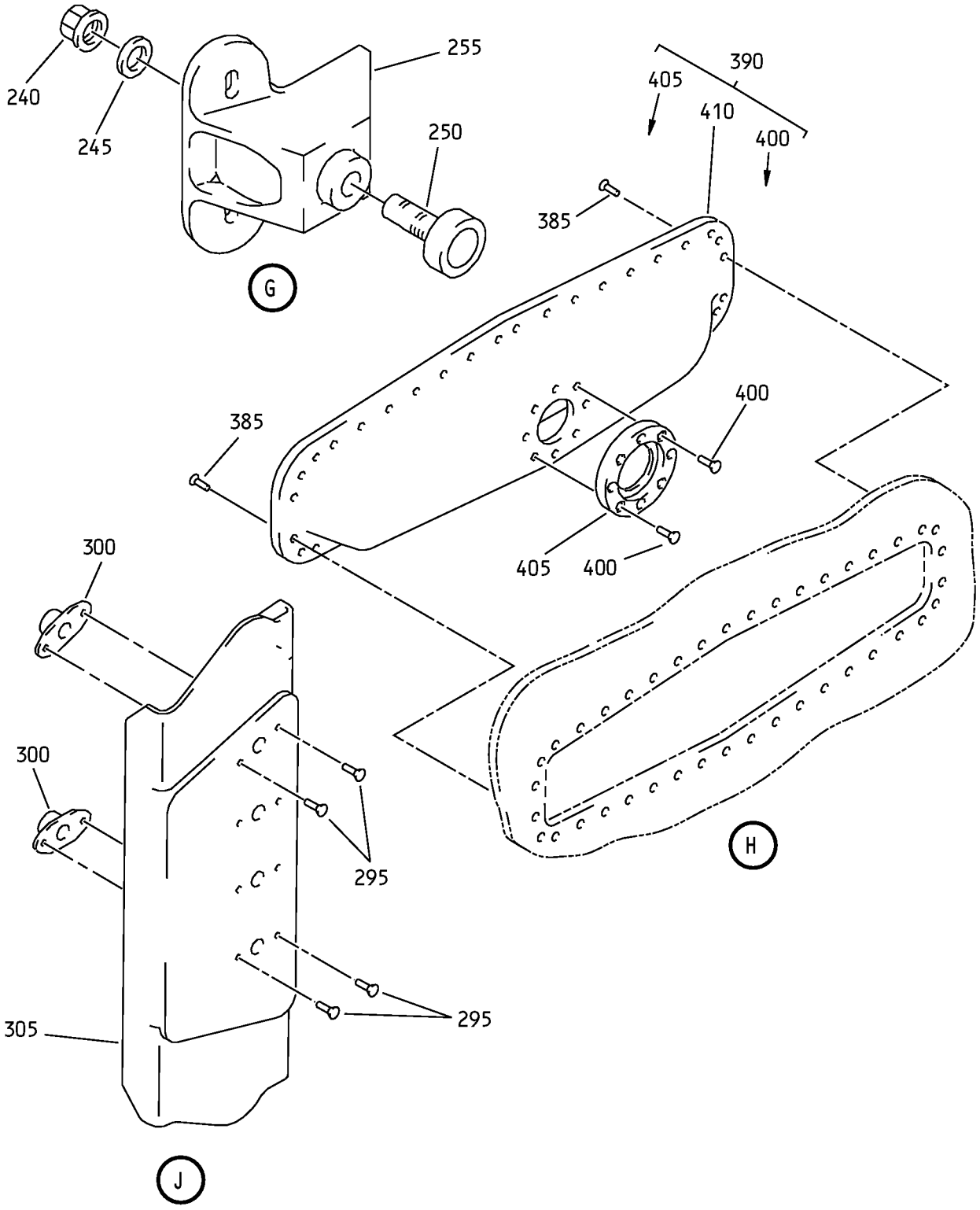
Aft Galley Door Assembly
IPL Figure 2 (Sheet 3 of 28)



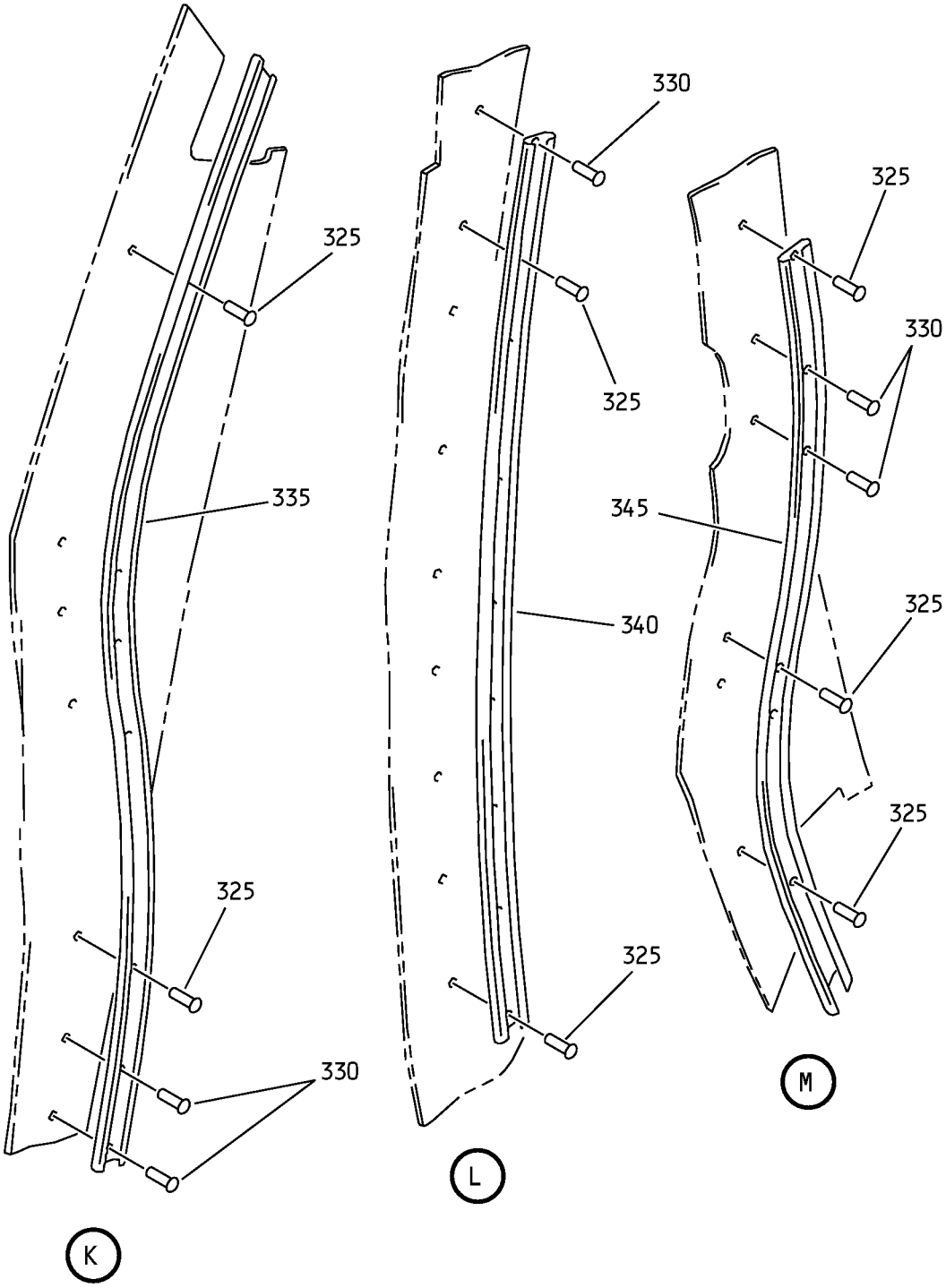
Aft Galley Door Assembly
IPL Figure 2 (Sheet 4 of 28)



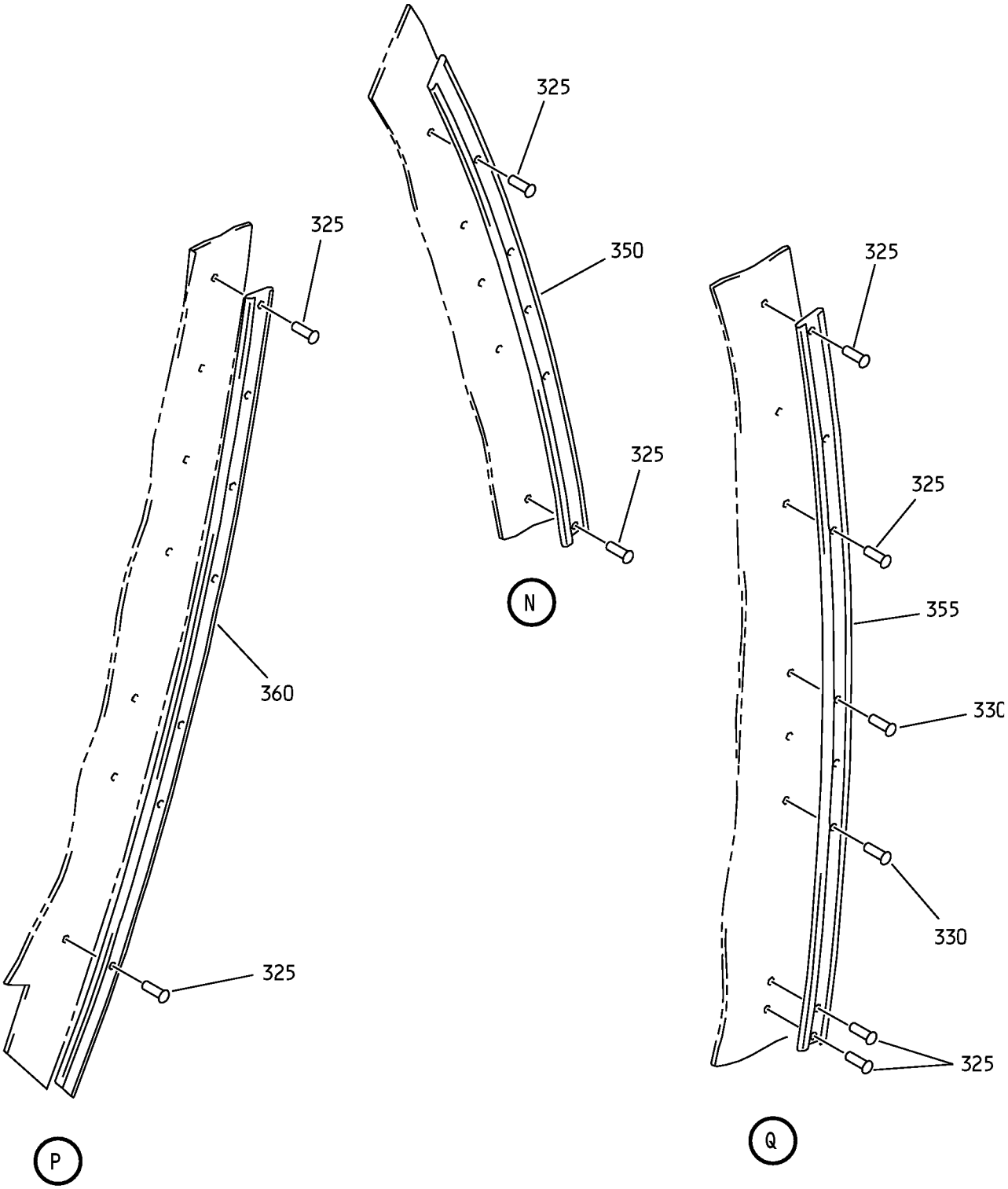
Aft Galley Door Assembly
IPL Figure 2 (Sheet 5 of 28)



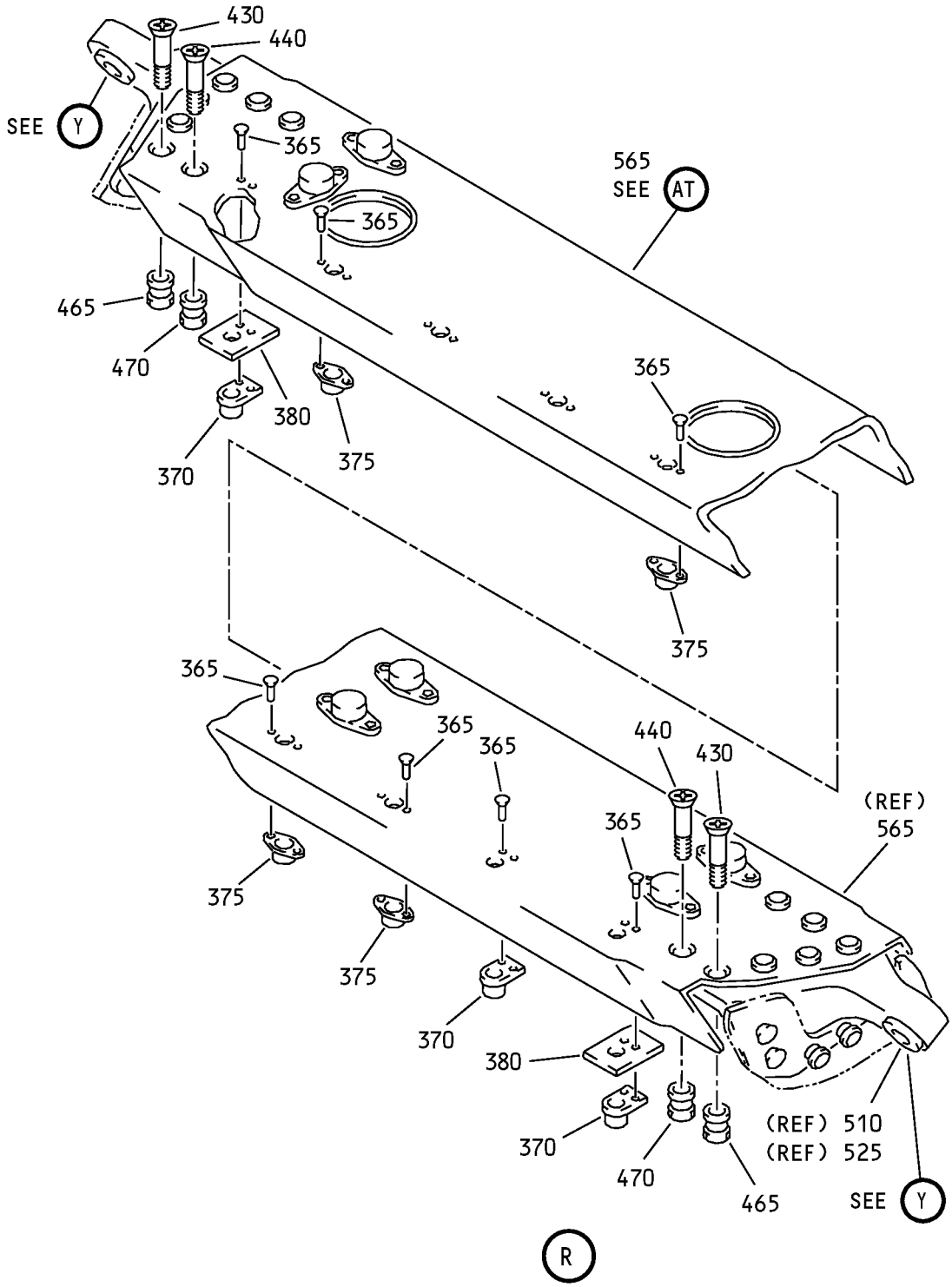
Aft Galley Door Assembly
IPL Figure 2 (Sheet 6 of 28)



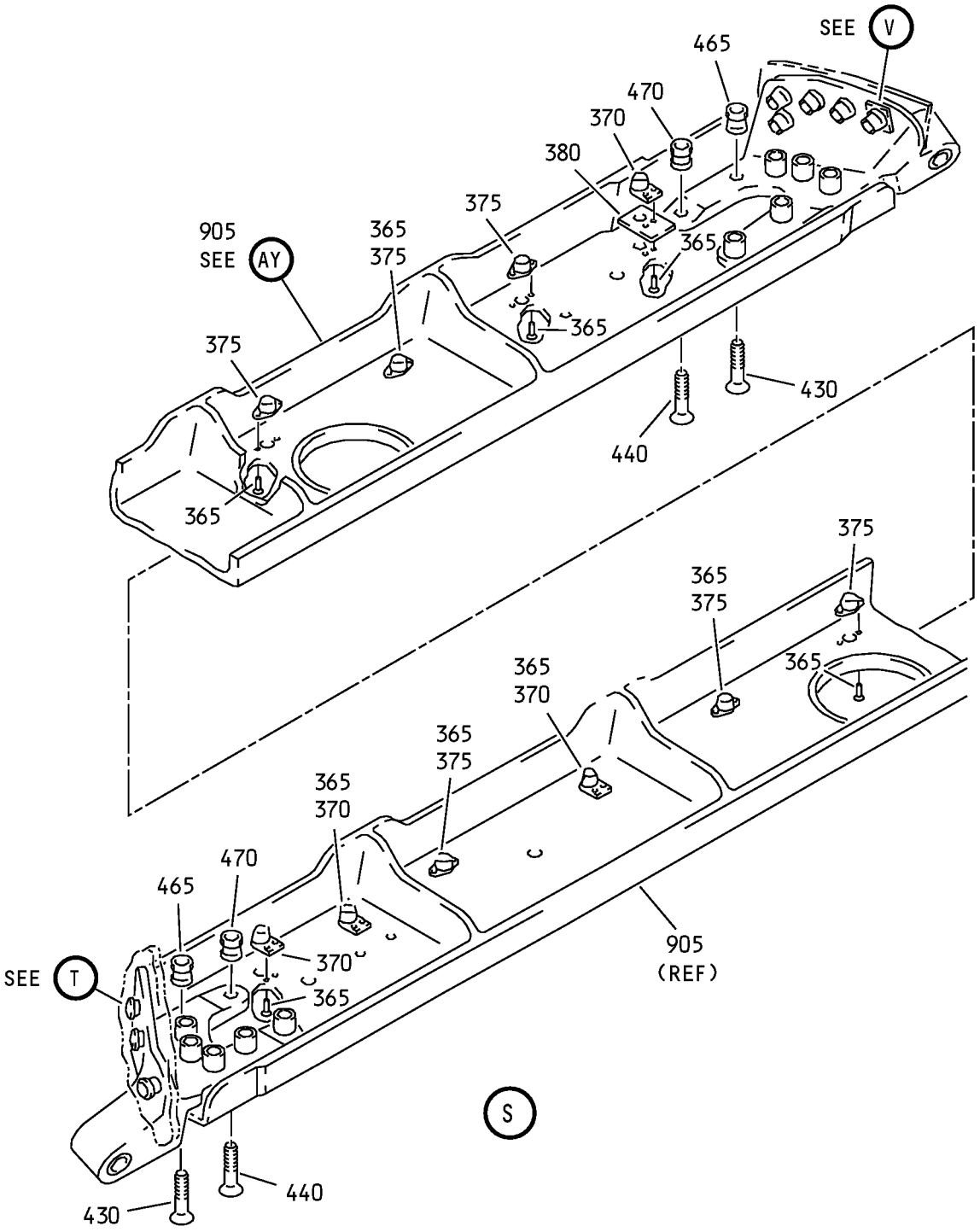
Aft Galley Door Assembly
IPL Figure 2 (Sheet 7 of 28)



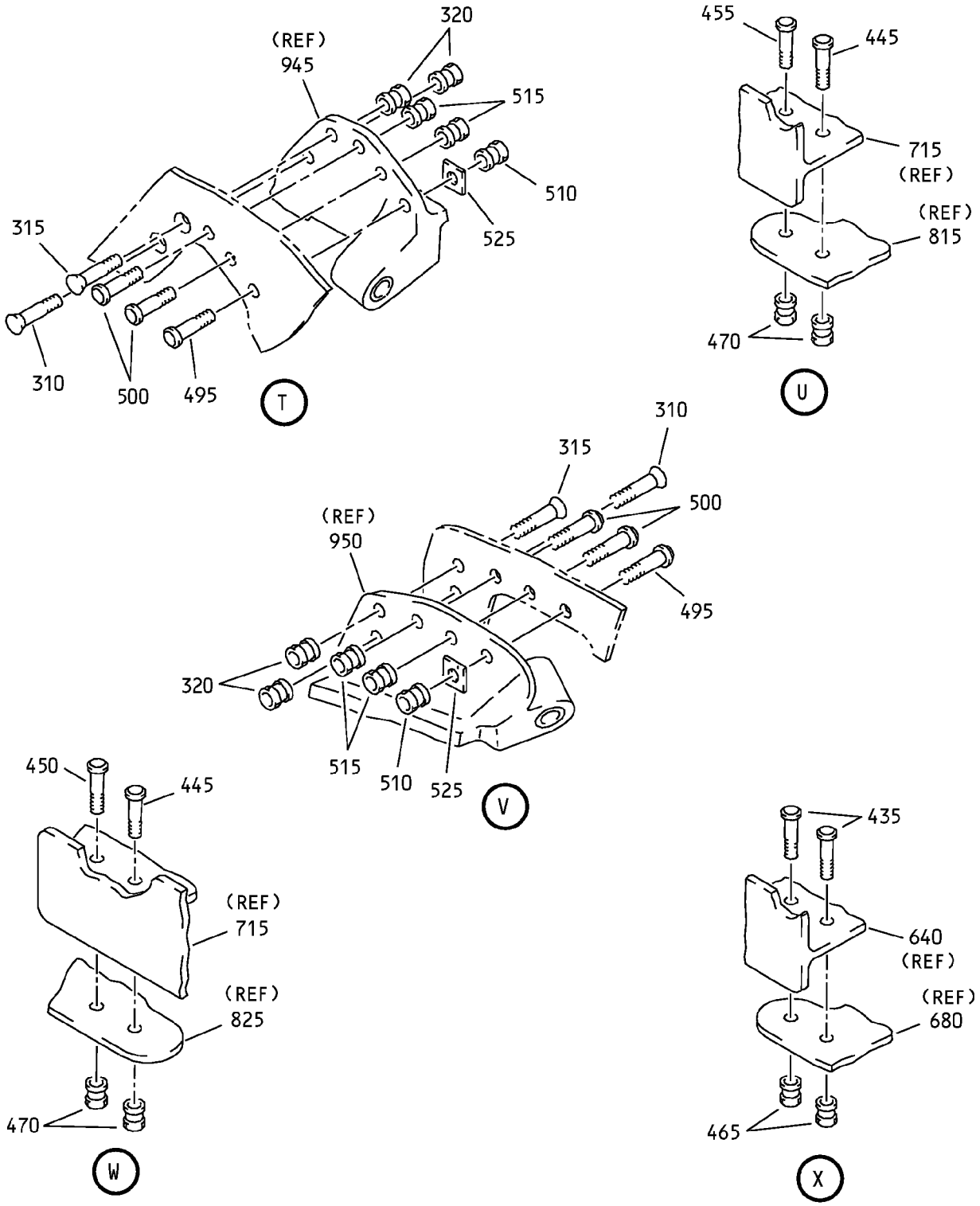
Aft Galley Door Assembly
IPL Figure 2 (Sheet 8 of 28)



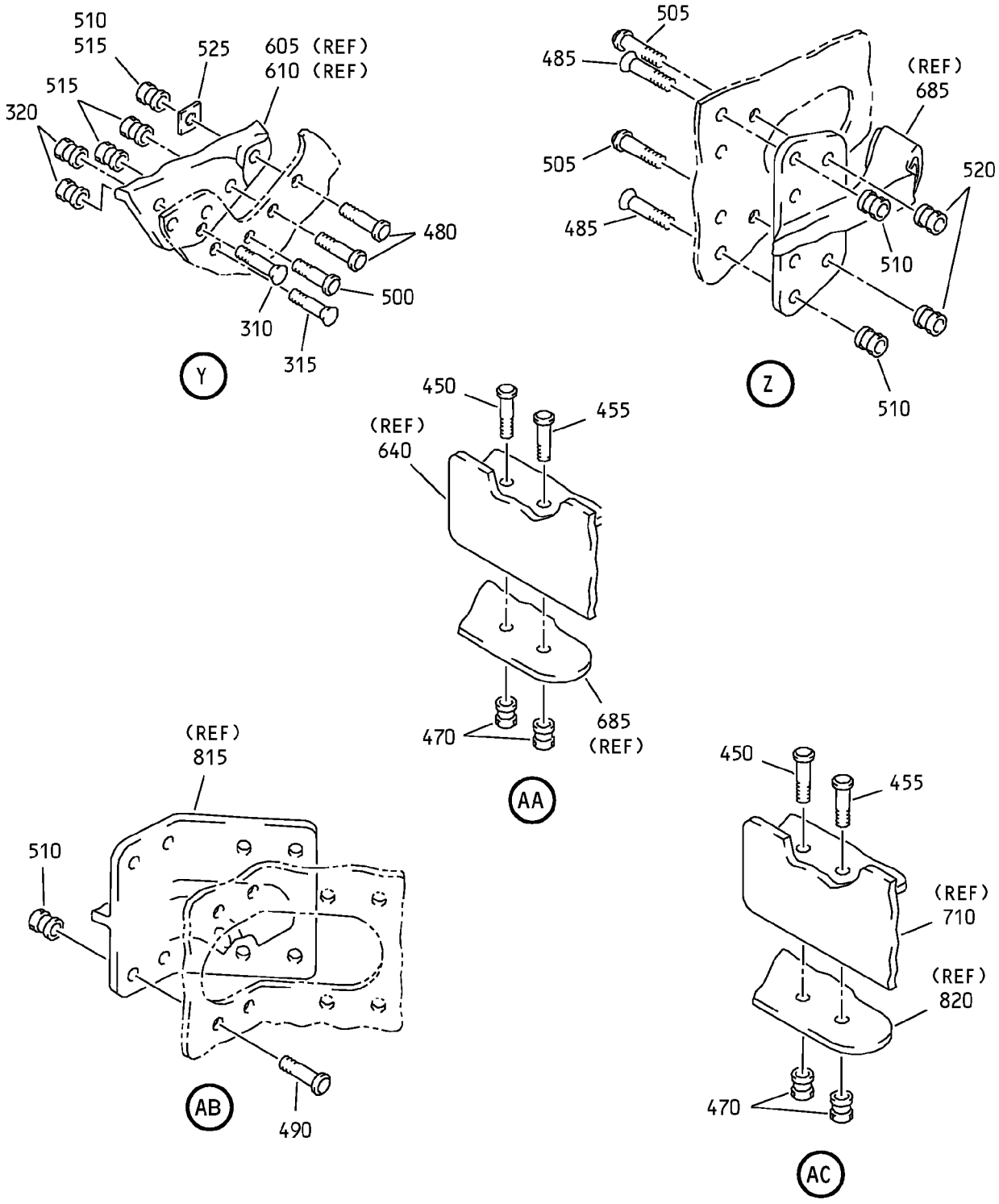
Aft Galley Door Assembly
IPL Figure 2 (Sheet 9 of 28)



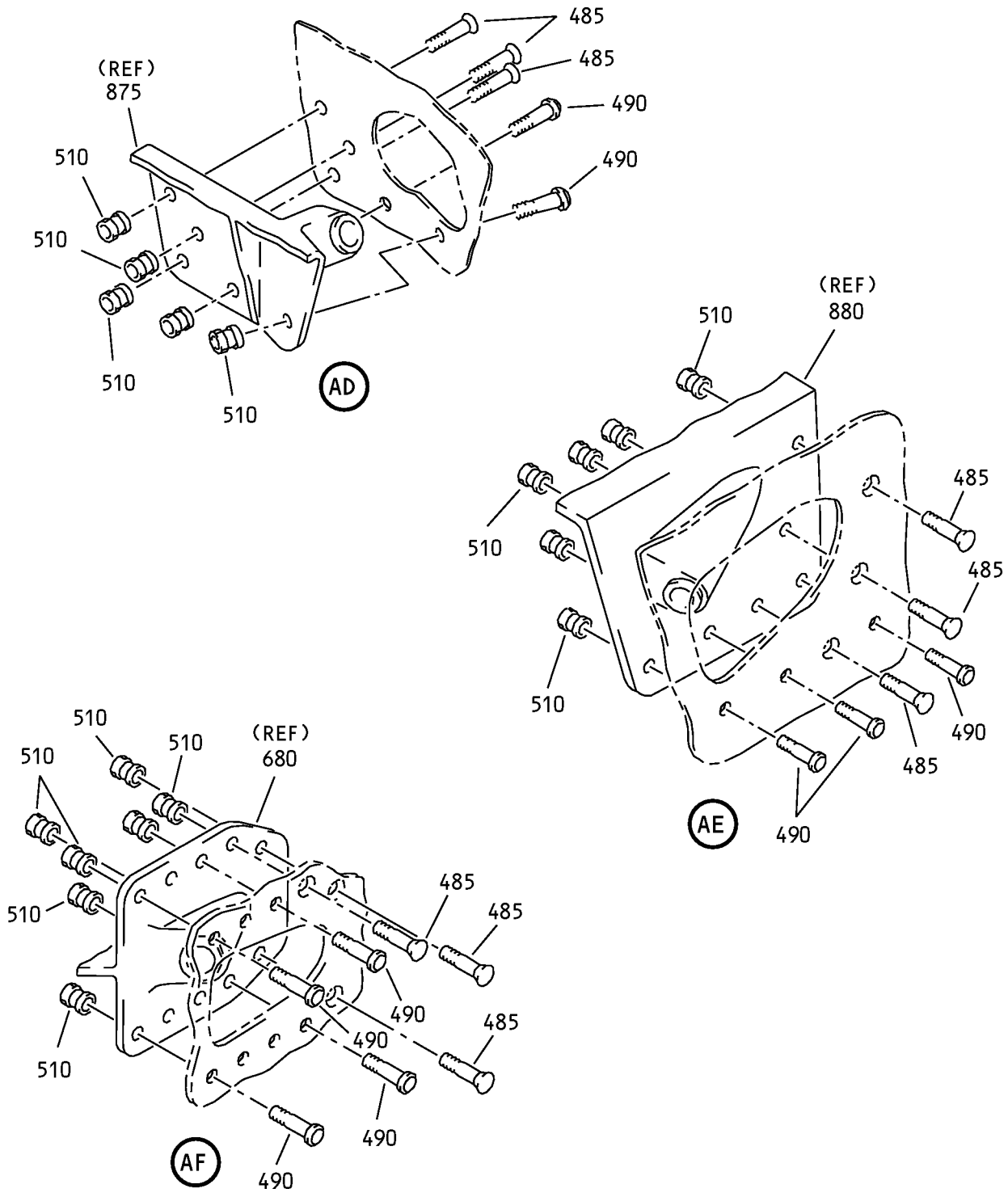
Aft Galley Door Assembly
IPL Figure 2 (Sheet 10 of 28)



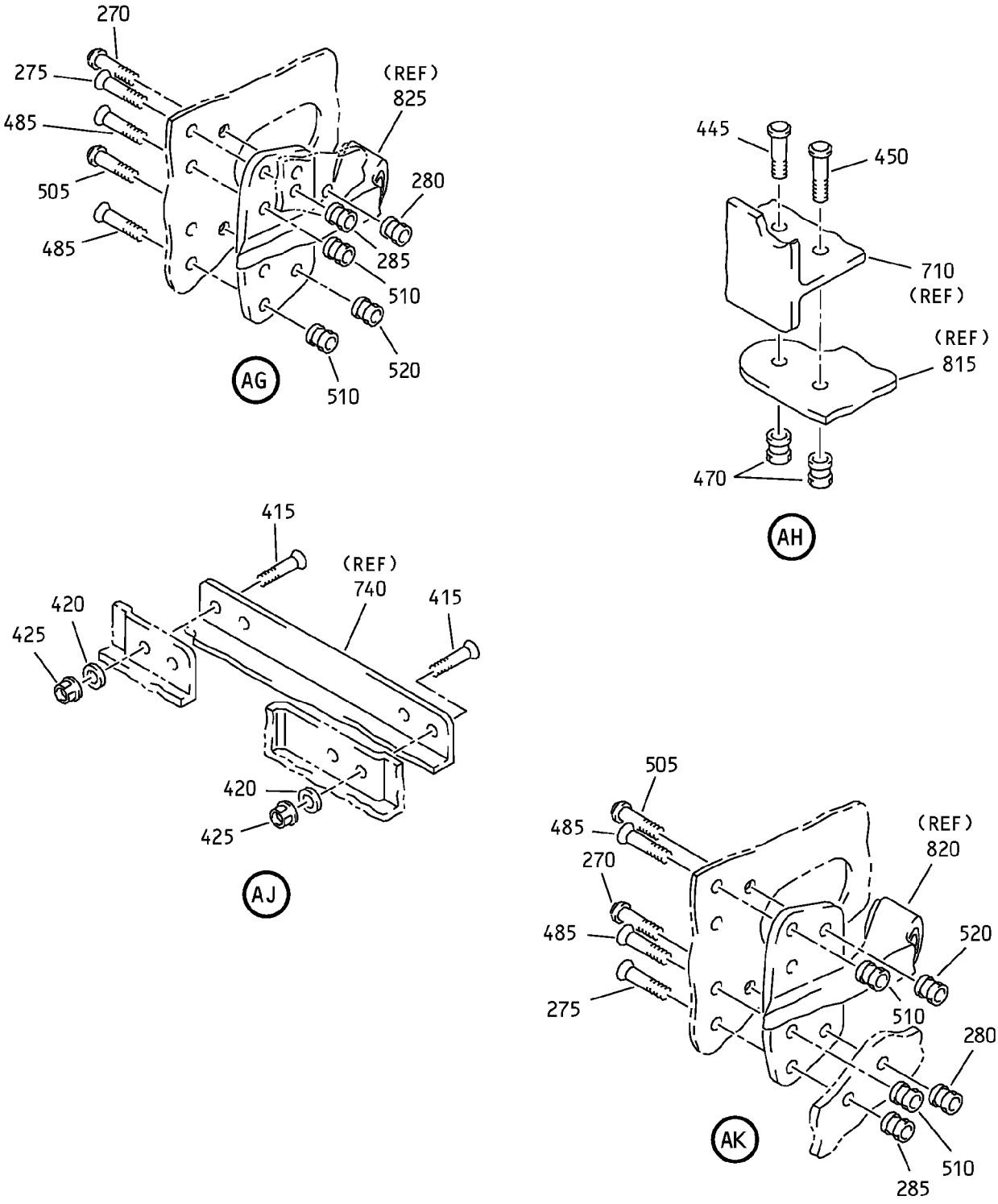
Aft Galley Door Assembly
IPL Figure 2 (Sheet 11 of 28)



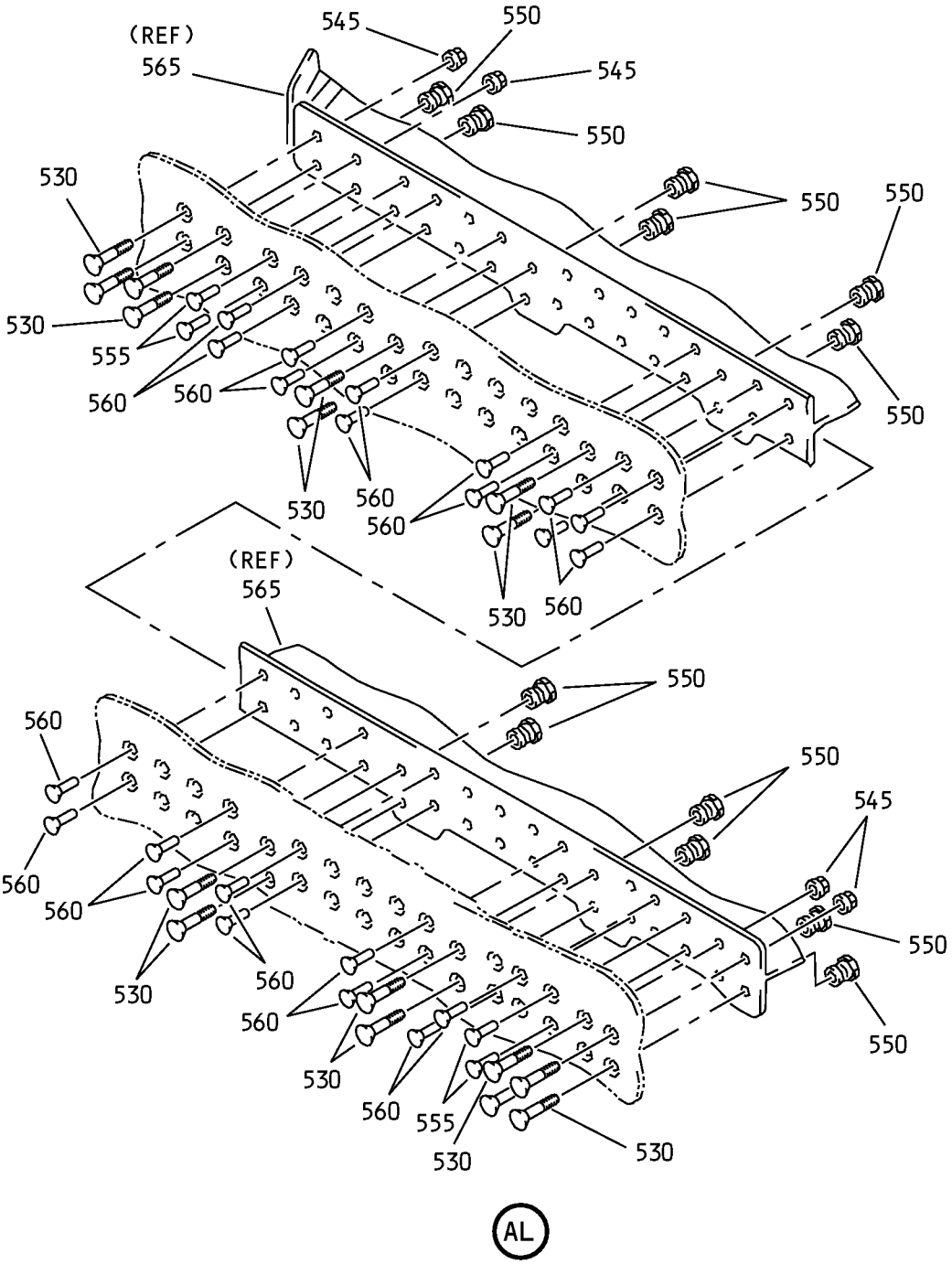
Aft Galley Door Assembly
IPL Figure 2 (Sheet 12 of 28)



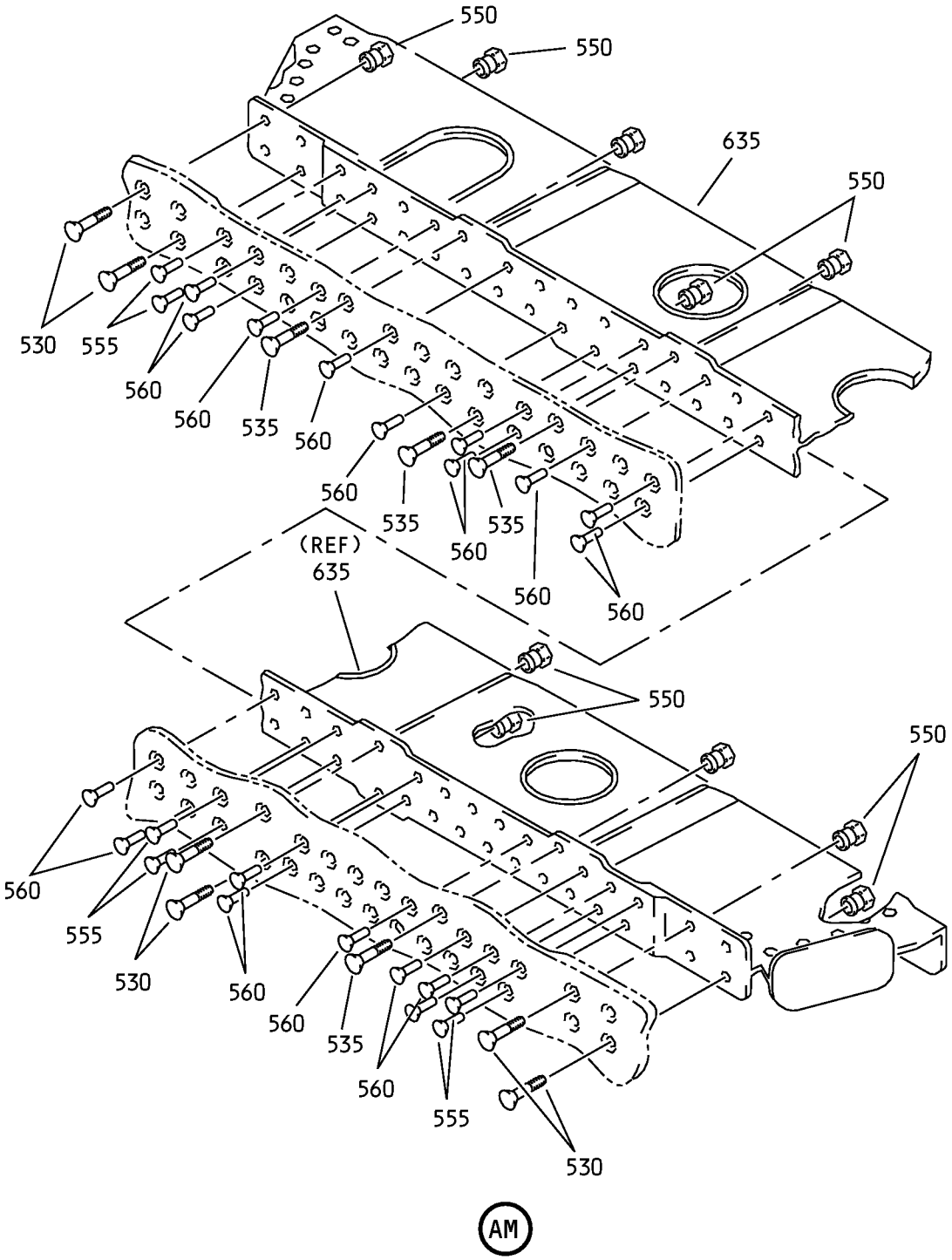
Aft Galley Door Assembly
IPL Figure 2 (Sheet 13 of 28)



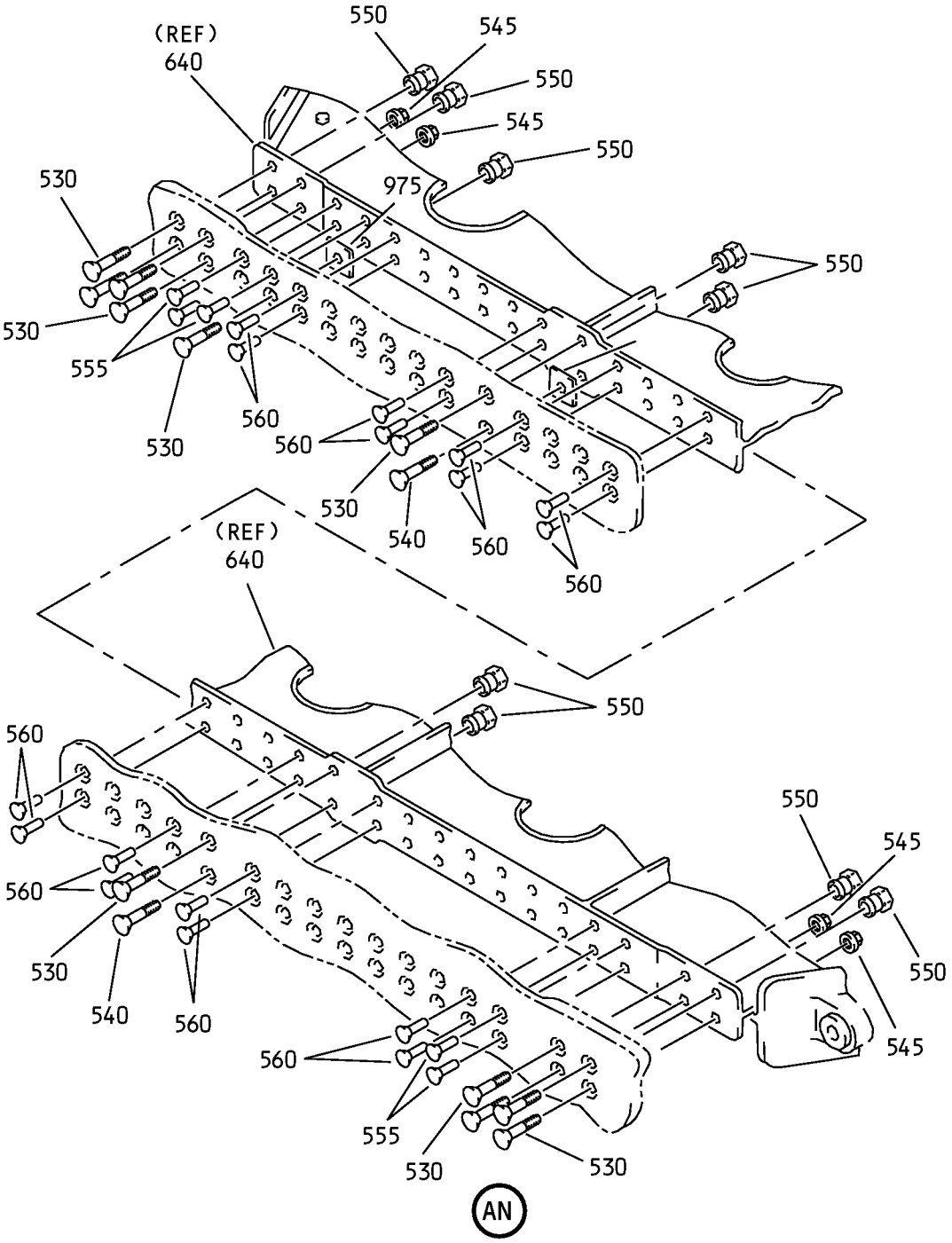
Aft Galley Door Assembly
IPL Figure 2 (Sheet 14 of 28)



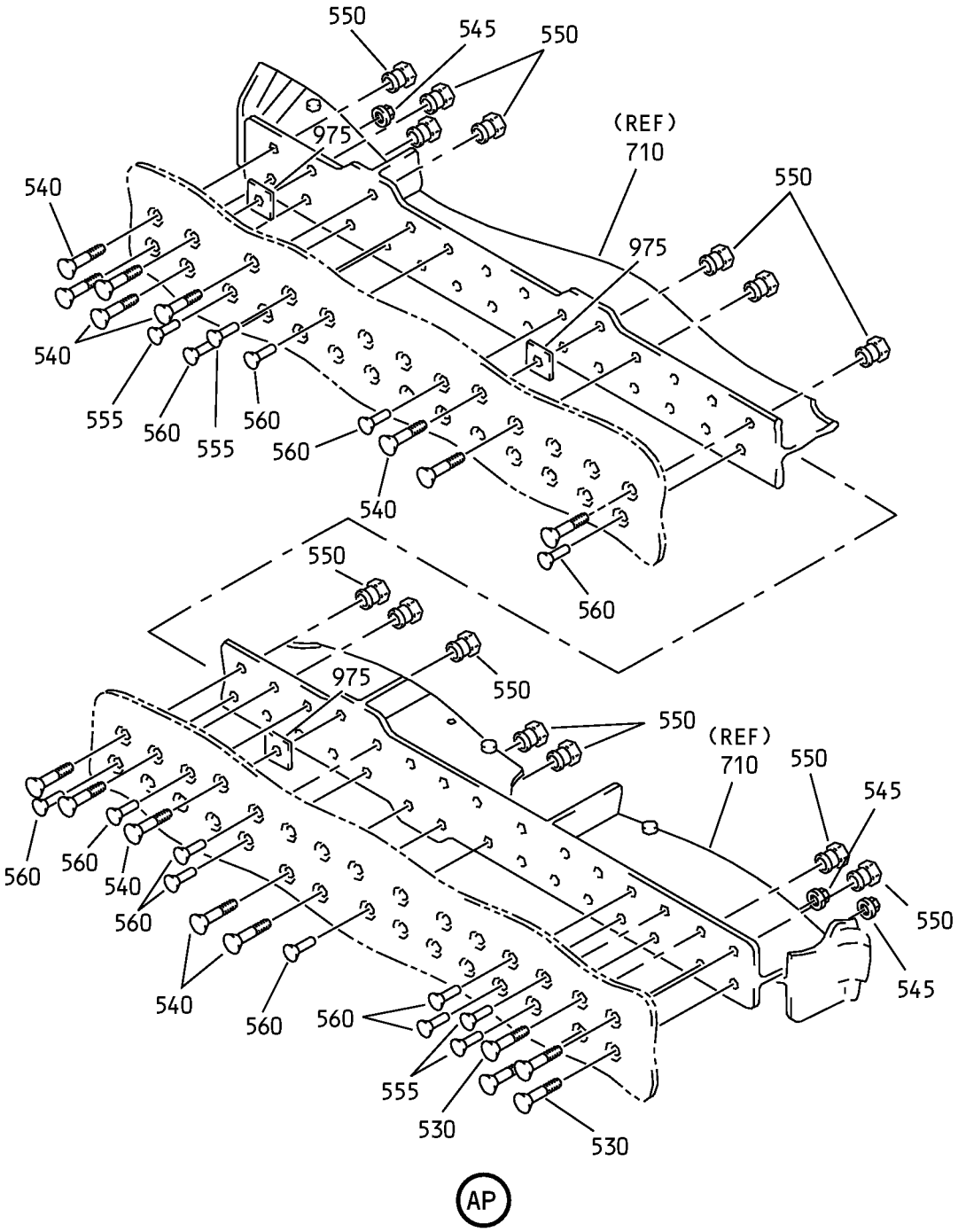
Aft Galley Door Assembly
IPL Figure 2 (Sheet 15 of 28)



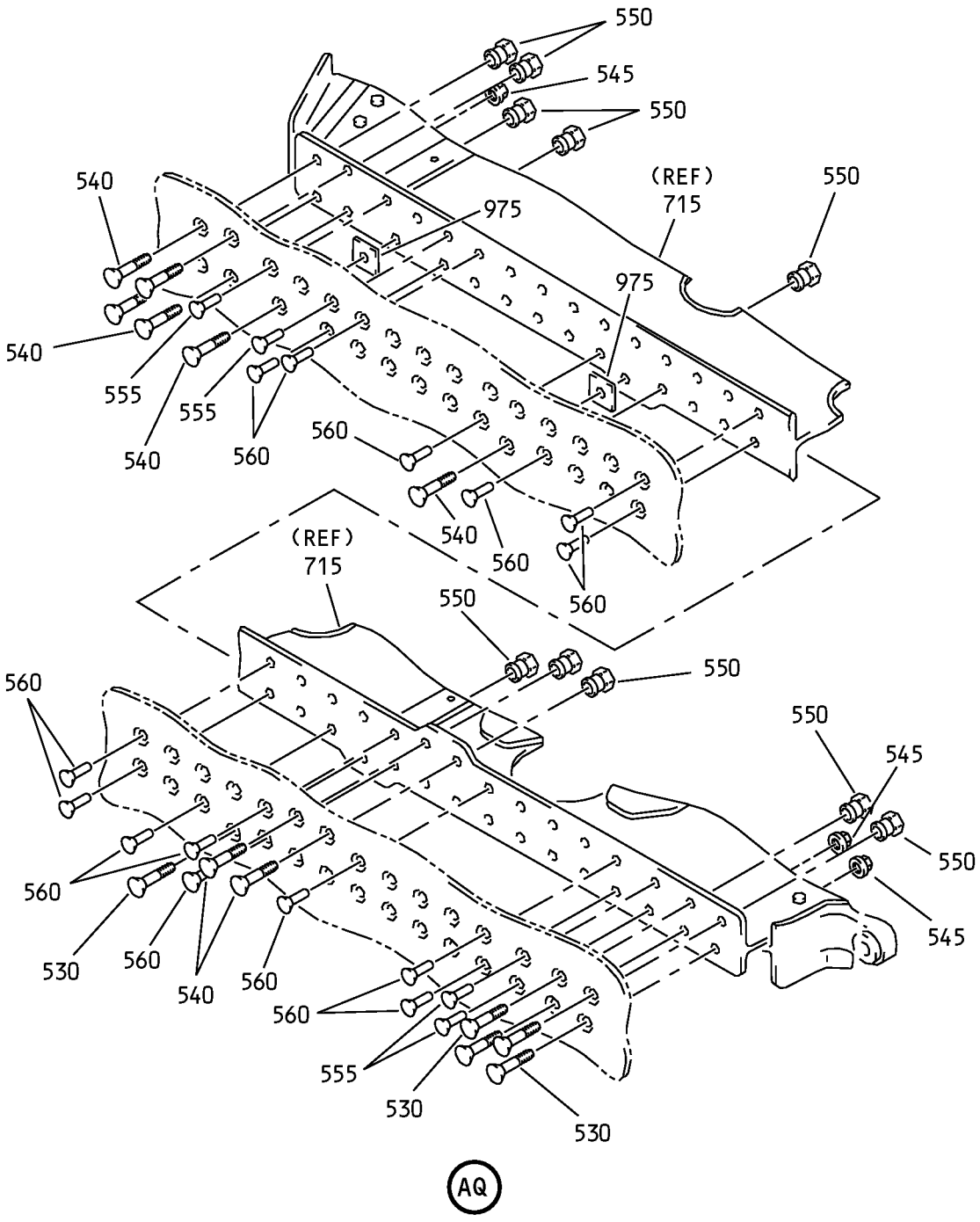
Aft Galley Door Assembly
IPL Figure 2 (Sheet 16 of 28)



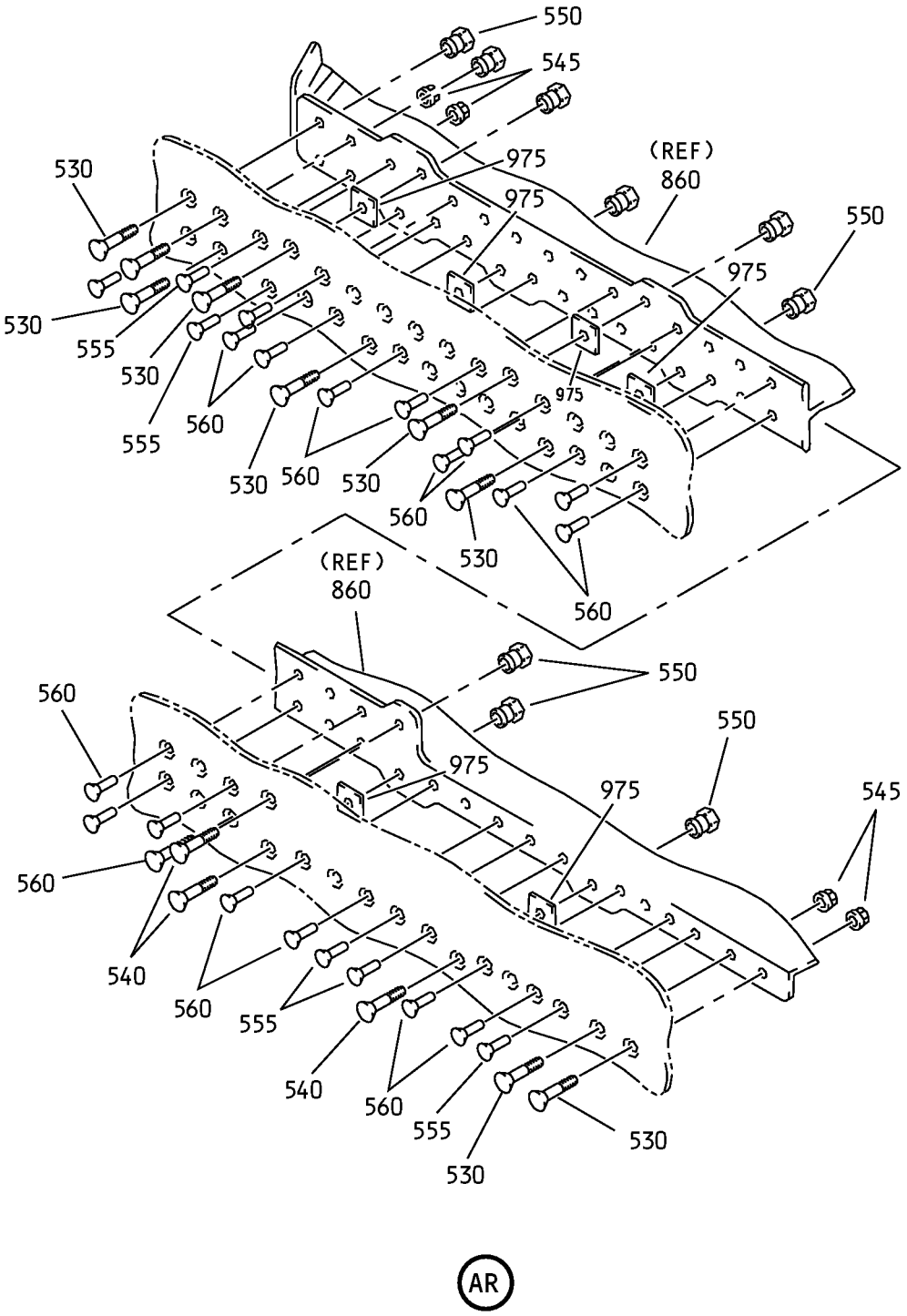
Aft Galley Door Assembly
IPL Figure 2 (Sheet 17 of 28)



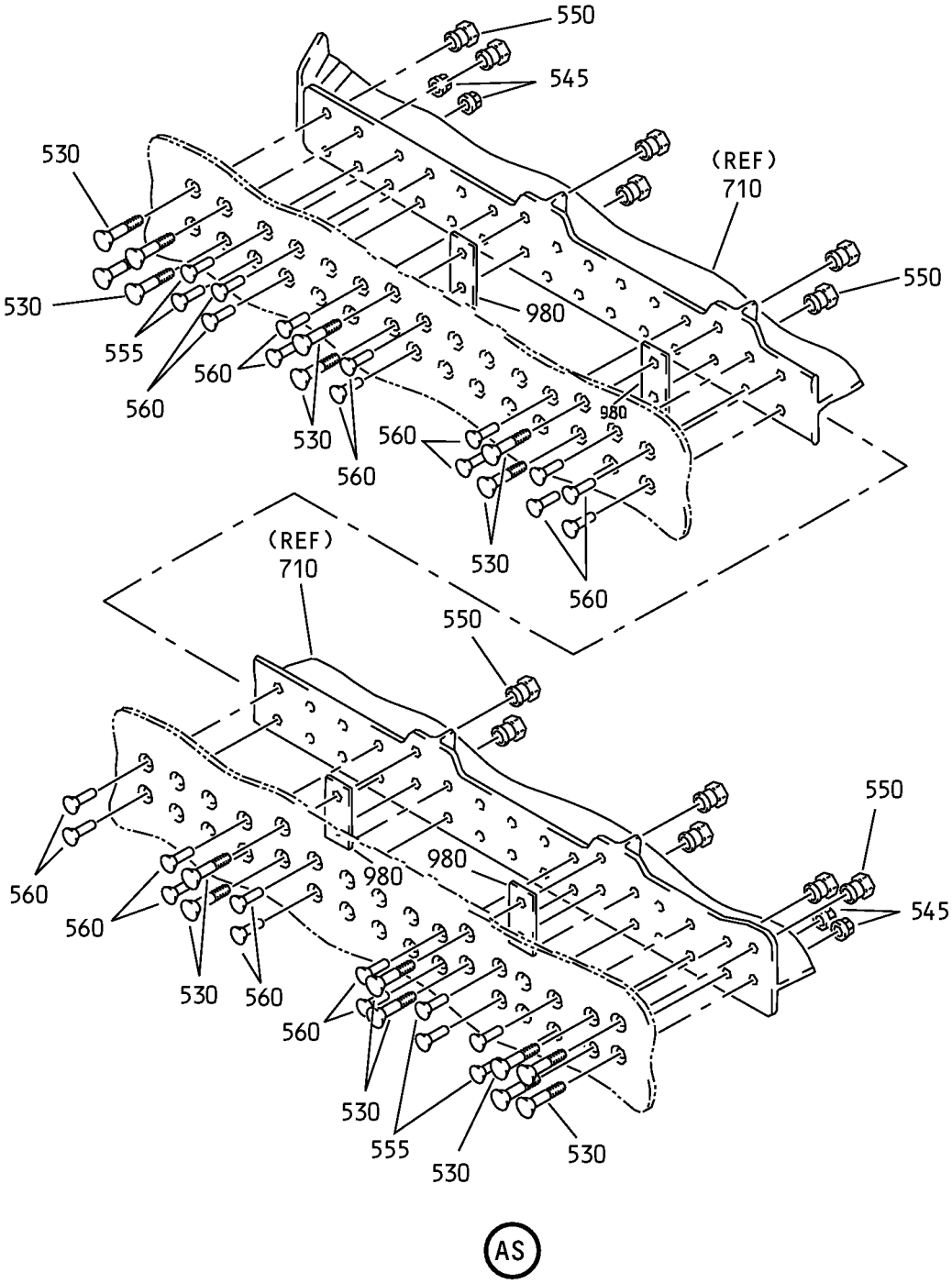
Aft Galley Door Assembly
IPL Figure 2 (Sheet 18 of 28)



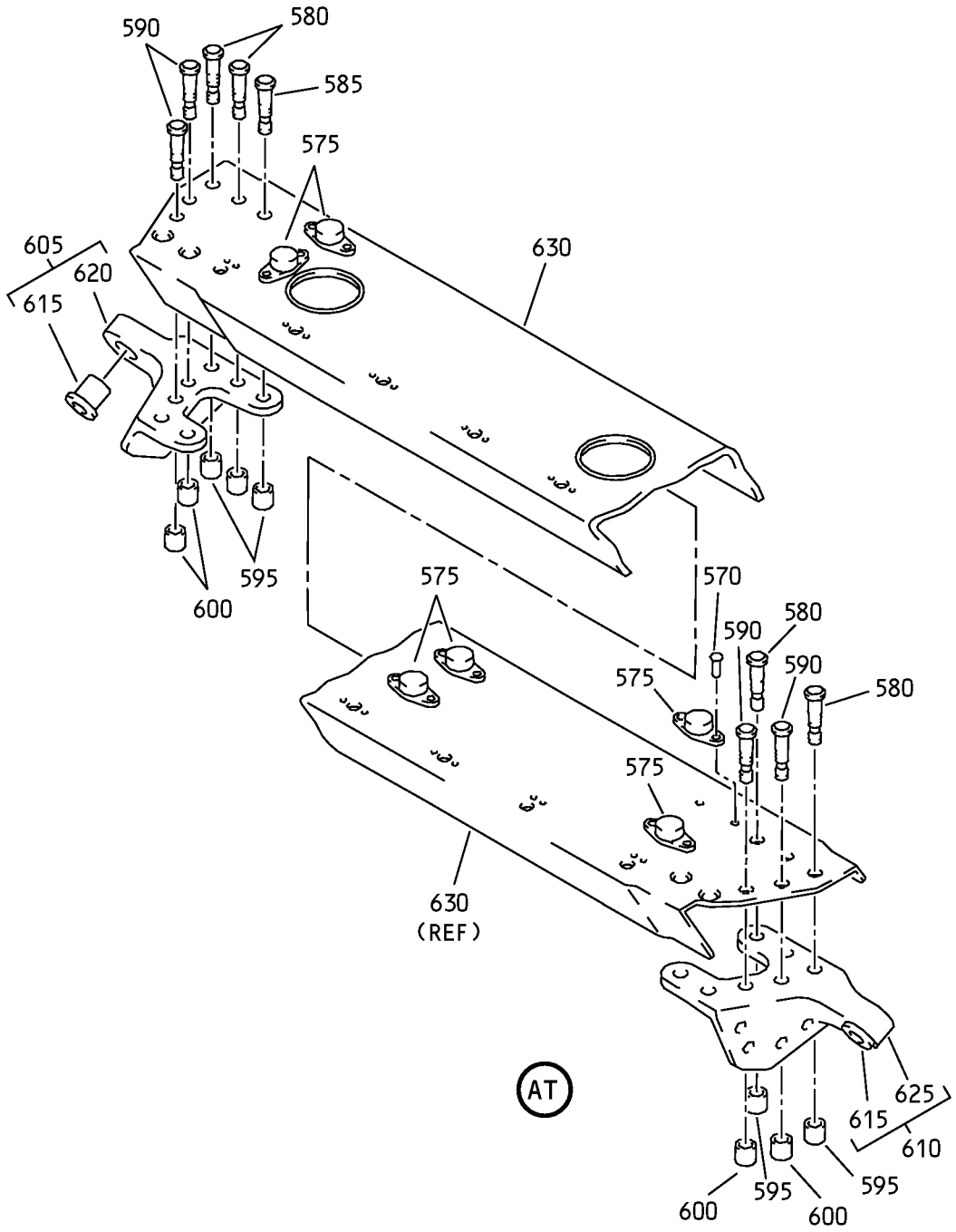
Aft Galley Door Assembly
IPL Figure 2 (Sheet 19 of 28)



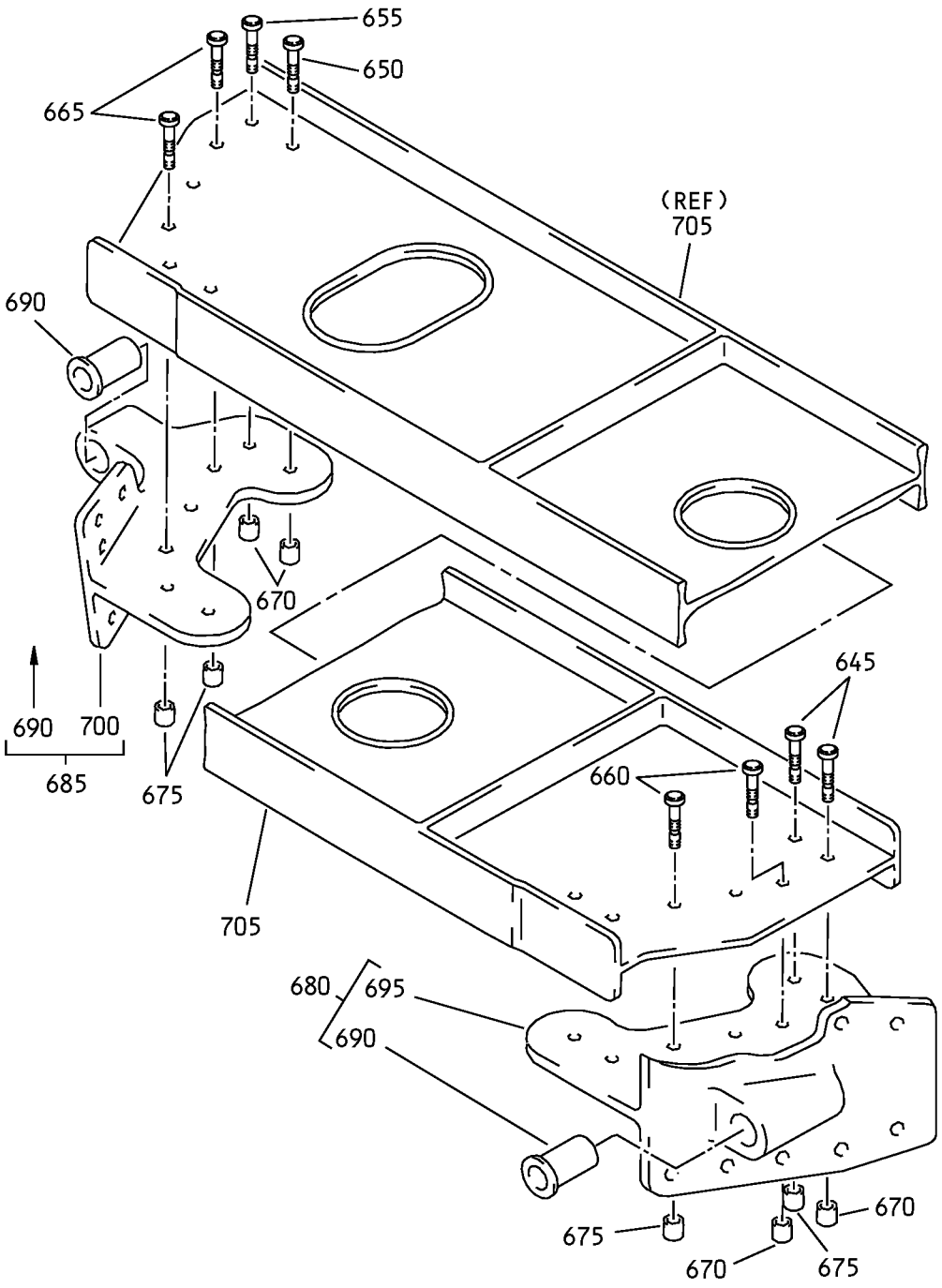
Aft Galley Door Assembly
IPL Figure 2 (Sheet 20 of 28)



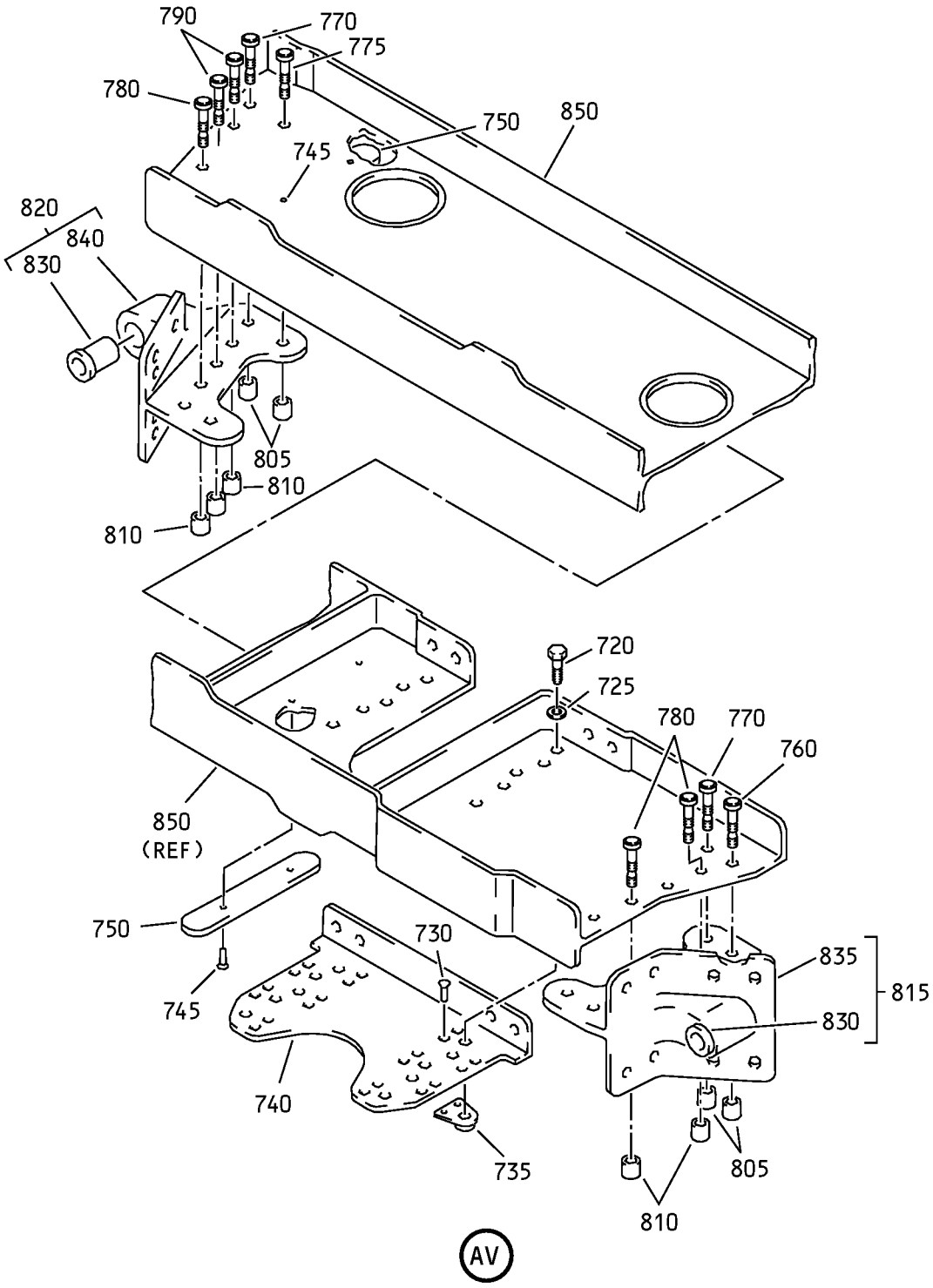
Aft Galley Door Assembly
IPL Figure 2 (Sheet 21 of 28)



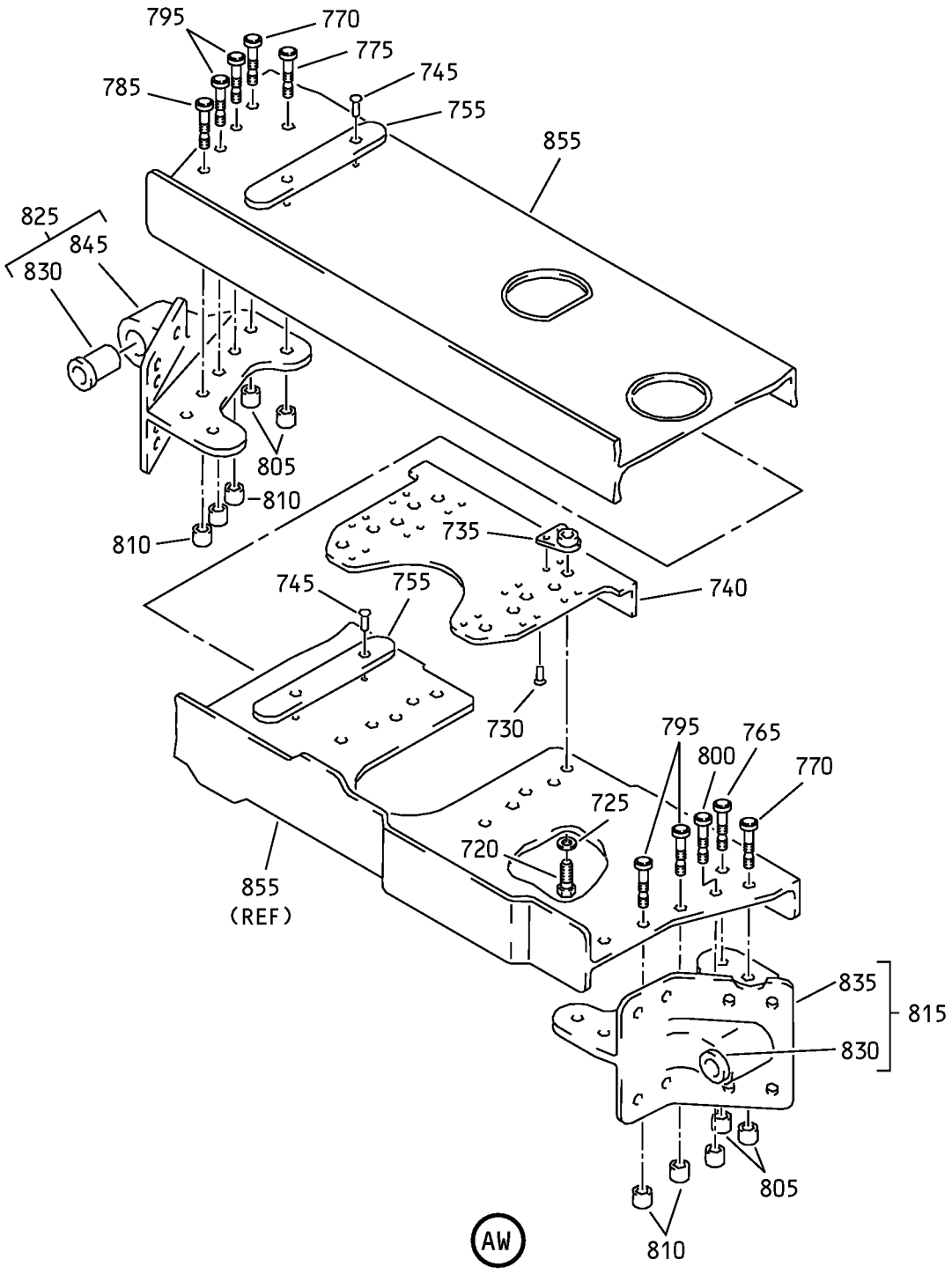
Aft Galley Door Assembly
IPL Figure 2 (Sheet 22 of 28)



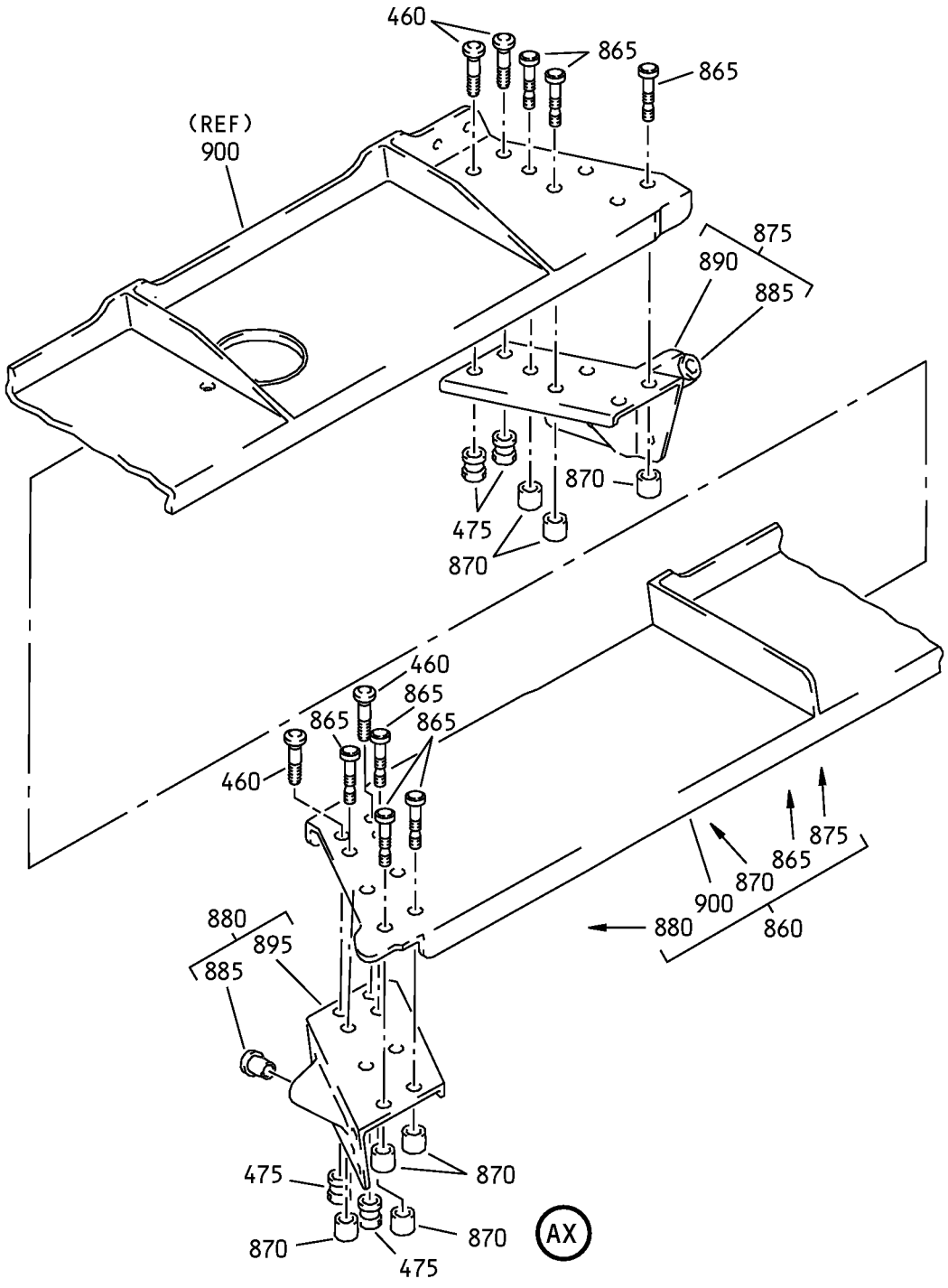
Aft Galley Door Assembly
IPL Figure 2 (Sheet 23 of 28)



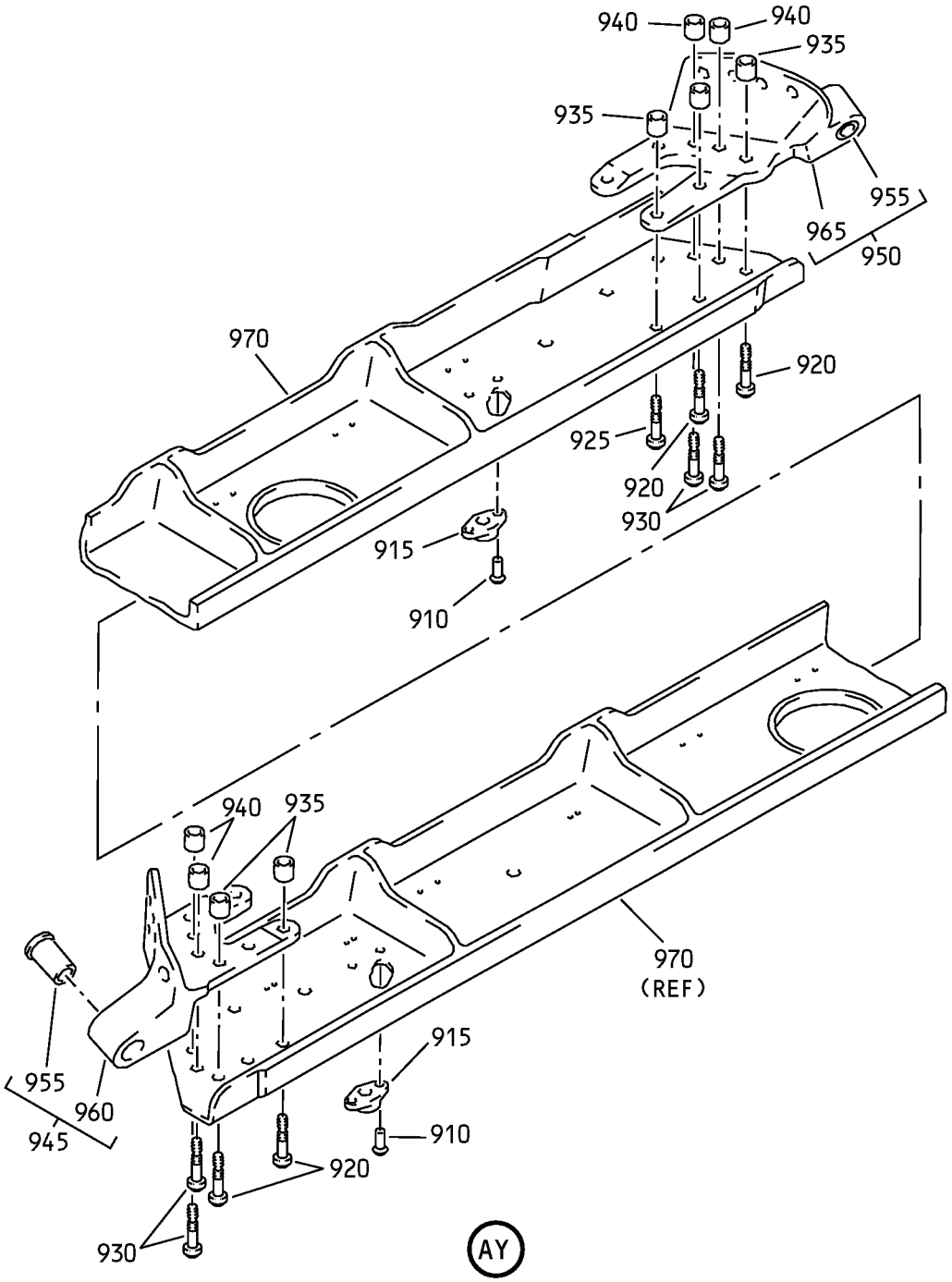
Aft Galley Door Assembly
IPL Figure 2 (Sheet 24 of 28)



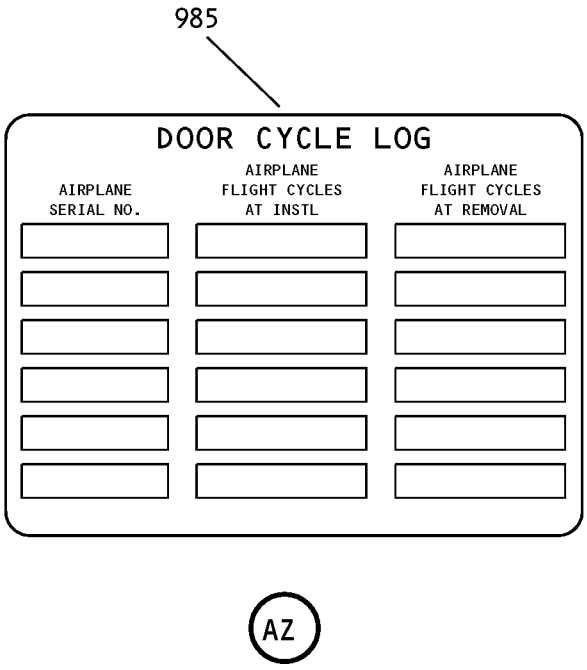
Aft Galley Door Assembly
IPL Figure 2 (Sheet 25 of 28)

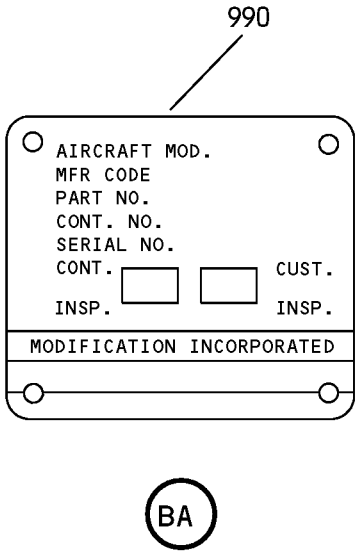


Aft Galley Door Assembly
IPL Figure 2 (Sheet 26 of 28)



Aft Galley Door Assembly
IPL Figure 2 (Sheet 27 of 28)





Aft Galley Door Assembly
IPL Figure 2 (Sheet 28 of 28)

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
–1A	147A6502-1		DOOR ASSY-AFT GALLEY (FOR ADDITIONAL DETAILS SEE FIG. 1)	F	RF
–1B	147A6502-5		DELETED		
–1C	147A6502-6		DELETED		
–1D	147A6502-7		DELETED		
–1E	147A6502-8		DOOR ASSY-AFT GALLEY (FOR ADDITIONAL DETAILS SEE FIG. 1)	D	RF
–1F	147A6502-9		DOOR ASSY-AFT GALLEY (FOR ADDITIONAL DETAILS SEE FIG. 1)	E	RF
–1G	147A6502-2		DOOR ASSY-AFT GALLEY (FOR ADDITIONAL DETAILS SEE FIG. 1)	G	RF
–1H	147A6502-3		DOOR ASSY-AFT GALLEY (FOR ADDITIONAL DETAILS SEE FIG. 1)	H	RF
–1J	147A6502-4		DOOR ASSY-AFT GALLEY (FOR ADDITIONAL DETAILS SEE FIG. 1)	J	RF
–1K	147A6502-10		DOOR ASSY-AFT GALLEY (FOR ADDITIONAL DETAILS SEE FIG. 1)	K	RF
–1L	147A6502-11		DOOR ASSY-AFT GALLEY (FOR ADDITIONAL DETAILS SEE FIG. 1)	L	RF
–1M	147A6502-12		DOOR ASSY-AFT GALLEY (FOR ADDITIONAL DETAILS SEE FIG. 1)	A	RF
–1N	147A6502-13		DOOR ASSY-AFT GALLEY (FOR ADDITIONAL DETAILS SEE FIG. 1)	B	RF
–1P	147A6502-14		DOOR ASSY-AFT GALLEY (FOR ADDITIONAL DETAILS SEE FIG. 1)	C	RF
–1Q	147A6502-15		DOOR ASSY-AFT GALLEY (FOR ADDITIONAL DETAILS SEE FIG. 1)	M	RF

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
–1R	147A6502-16		DOOR ASSY-AFT GALLEY (FOR ADDITIONAL DETAILS SEE FIG. 1)	N	RF
–1S	147A6502-17		DOOR ASSY-AFT GALLEY (FOR ADDITIONAL DETAILS SEE FIG. 1)	P	RF
–1T	147A6502-18		DOOR ASSY-AFT GALLEY (FOR ADDITIONAL DETAILS SEE FIG. 1)	Q	RF
–1U	147A6502-19		DOOR ASSY-AFT GALLEY (FOR ADDITIONAL DETAILS SEE FIG. 1)	R	RF
–1V	147A6502-20		DOOR ASSY-AFT GALLEY (FOR ADDITIONAL DETAILS SEE FIG. 1)	S	RF
–1W	147A6502-21		DOOR ASSY-AFT GALLEY (FOR ADDITIONAL DETAILS SEE FIG. 1)	T	RF
–1X	147A6502-22		DOOR ASSY-AFT GALLEY (FOR ADDITIONAL DETAILS SEE FIG. 1)	U	RF
–1Y	147A6502-23		DOOR ASSY-AFT GALLEY (FOR ADDITIONAL DETAILS SEE FIG. 1)	V	RF
–1Z	147A6502-24		DOOR ASSY-AFT GALLEY (FOR ADDITIONAL DETAILS SEE FIG. 1)	W	RF
–2	147A6502-25		DOOR ASSY-AFT GALLEY (FOR ADDITIONAL DETAILS SEE FIG. 1)	X	RF
–2A	147A6502-26		DOOR ASSY-AFT GALLEY (FOR ADDITIONAL DETAILS SEE FIG. 1)	Y	RF
5	66-15332-1		. SPACER-ROLLER LATCH	A-S	AR
–5A	66-15332-1		. SPACER-ROLLER LATCH (OPT ITEM 5B)	T-Y	AR
–5B	149A6101-1		. SPACER (OPT ITEM 5A)	T-Y	AR

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
10	ASSB16-19		. BEARING (V15860) (SPEC BACB10A397GCM2) (OPT BLN16385GC (V81376)) (OPT KSSB16-5 (V97613)) (OPT NB16BM2 (V73134)) (OPT 55001 (V09455)) (OPT ABW16-101 (VS0352)) (OPT HGL16-102 (V02758)) (OPT NB12BGCM2 (V73134)) (OPT NC16-4 (V56644))		4
15	BACB30VF3K4		. BOLT		15
20	BACB30VF3K3		. BOLT		1
25	NAS1149D0332J		. WASHER		16
30	H52732-3CD		. NUT (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))		16
35	147A6138-6		. FITTING ASSY-LATCH SPRT		1
40	147A6138-2		. FITTING ASSY-LATCH SPRT		1
45	147A6138-8		. FITTING ASSY-LATCH SPRT	F-J	1
–45A	147A6138-24		. FITTING ASSY-LATCH SPRT	A-E, K-W	1
–45B	147A6138-32		. FITTING ASSY-LATCH SPRT	X, Y	1
50	147A6138-4		. FITTING ASSY-LATCH SPRT	F-J	1
–50A	147A6138-20		. FITTING ASSY-LATCH SPRT	A-E, K-W	1
–50B	147A6138-28		. FITTING ASSY-LATCH SPRT	X, Y	1
55	NAS516-1A		. . FITTING		1
60	147A6138-14		. . FITTING (USED ON ITEM 35)		1
65	147A6138-10		. . FITTING (USED ON ITEM 40)		1
70	147A6138-16		. . FITTING (USED ON ITEM 45)	F-J	1
–70A	147A6138-22		. . FITTING (USED ON ITEM 45A)	A-E, K-W	1
–70B	147A6138-30		. . FITTING	X, Y	1
75	147A6138-12		. . FITTING (USED ON ITEM 50)	F-J	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–					
–75A	147A6138-18		. . FITTING (USED ON ITEM 50A)	A-E, K-W	1
–75B	147A6138-26		. . FITTING	X, Y	1
80	147A6120-1		. SHIM		AR
85	147A6120-2		. SHIM		AR
90	BACB30NM3K3		. BOLT		16
95	NAS1149D0332J		. WASHER		16
100	H52732-3CD		. NUT (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))		16
105	65-2306-9		. HOUSING ASSY		4
110	MS15001-4		. . FITTING		1
115	ASSB16-19		. . BEARING (V15860) (SPEC BACB10A397GCM2) (OPT BLN16385GC (V81376)) (OPT KSSB16-5 (V97613)) (OPT NB16BM2 (V73134)) (OPT 55001 (V09455)) (OPT ABW16-101 (VS0352)) (OPT HGL16-102 (V02758)) (OPT NB12BGCM2 (V73134)) (OPT NC16-4 (V56644))		1
120	65-2306-10		. . HOUSING		1
125	147A6139-4		. TUBE ASSY-UPR		1
130	147A6139-2		. TUBE ASSY-LWR		1
132	BACP18BC02A06P		. . PIN-COTTER		2
135	BACN10JD105CD		. . NUT		2
140	NAS1149D0516J		. . WASHER		16
145	HRSC3CFR9		. . BEARING (V60380) (SPEC BACB10FK5F9HS) (OPT CHRS3CFR9 (V92563)) (OPT CHRS3CFR9 (V07484))		2
150	BACB30NM3K17		. . BOLT		4
155	NAS1149C0332R		. . WASHER		4

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
160	H52732-3CM		. . NUT (V15653) (SPEC BACN10YR3CM) (OPT PLH53CM (V62554))		4
165	69-37418-11		. . CRANK-ROLLER CAM		2
170	BACB30NM3K19		. . BOLT		4
175	NAS1149C0332R		. . WASHER		4
180	H52732-3CM		. . NUT (V15653) (SPEC BACN10YR3CM) (OPT PLH53CM (V62554))		4
185	66-14531-12		. . CRANK-GATE		1
190	66-14530-6		. . CRANK-LATCH (USED ON ITEM 125)		1
195	66-14531-13		. . CRANK-LATCH (USED ON ITEM 130)		1
200	60-4406-16		. . TUBE-LATCH TORQUE (USED ON ITEM 125)		1
205	60-4406-17		. . TUBE-LATCH TORQUE (USED ON ITEM 130)		1
210	BACB30NM3K9		. BOLT		3
215	BACB30VF3K4		. BOLT		2
220	BACW10BN3AC		. WASHER		3
225	BACR15BA3AD		. RIVET (SIZE DETERMINED ON INST)		2
230	NS202493-02-4		. NUTPLATE (V80539) (SPEC BACN10KE3B4CD) (OPT BRFR220C3-4D (V52828)) (OPT F51747-3-4CD (V15653)) (OPT 102A9213-4-3 (V72962))		1
235	147A6130-1		. GUIDE ASSY-CENTERING		1
240	H52732-5CD		. . NUT (V15653) (SPEC BACN10YR5CD) (OPT PLH55CD (V62554))		1
245	NAS1149D0532J		. . WASHER		1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
250	HRSC3CFR9		. . BEARING (V60380) (SPEC BACB10FK5F9HS) (OPT CHRS3CFR9 (V92563)) (OPT CHRS3CFR9 (V07484))		1
255	147A6130-2		. . FITTING		1
260	147A6133-1		. PLATE-SERRATED		1
265	BACF3T01A13-12		. FILLER	F	1
270	HST10AG8-4		. BOLT (V0PTK6) (SPEC BACB30VT8K4) (OPT HST10AG8-4 (V06725)) (OPT HST10AG8-4 (V56878)) (OPT HST10AG8-4 (V73197)) (OPT WC10K8-4 (V60516))		2
275	HST11AG6-4		. BOLT (V06725) (SPEC BACB30VU6K4) (OPT HST11AG6-4 (V73197)) (OPT HST11AG6-4 (V56878)) (OPT HST11AG6-4 (V0PTK6))		2
280	HST79CY8		. COLLAR (V73197) (SPEC BACC30BL8) (OPT HST79-8 (V56878)) (OPT HST79-8 (V92215)) (OPT HST79-8 (V5M902))		2
285	HST79CY6		. COLLAR (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V56878)) (OPT HST79-6 (V92215)) (OPT HST79-6 (V5M902))		2
290	147A6131-2		. CHANNEL ASSY-CENTERING GUIDE		1
295	BACR15BA3AD		. . RIVET (SIZE DETERMINED ON INST)		8
300	NS202493-02-2		. . NUTPLATE (V80539) (SPEC BACN10KE3B2CD) (OPT BRFR220C3-2D (V52828)) (OPT F51747-3-2CD (V15653)) (OPT 102A9213-2-3 (V72962))		4

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
305	147A6131-4		. . CHANNEL		1
310	HST11AG6-6		. BOLT (V06725) (SPEC BACB30VU6K6) (OPT HST11AG6-6 (V73197)) (OPT HST11AG6-6 (V56878)) (OPT HST11AG6-6 (V0PTK6))		4
315	HST11AG6-5		. BOLT (V06725) (SPEC BACB30VU6K5) (OPT HST11AG6-5 (V73197)) (OPT HST11AG6-5 (V56878)) (OPT HST11AG6-5 (V0PTK6))		4
320	HST826AW		. COLLAR (V5M902) (SPEC BACC30BQ6) (OPT HST826AW (V56878)) (OPT HST826AW (V73197)) (OPT HST82CY6APBW (V73197)) (OPT HST82CY6APBW (V56878))		8
325	BACR15GK4E2		. RIVET		34
330	BACR15BB4D		. RIVET (SIZE DETERMINED ON INST)		8
335	147A6145-6		. RETAINER-SEAL		1
340	147A6145-4		. RETAINER-SEAL		1
345	147A6145-26		. RETAINER-SEAL		1
350	147A6145-14		. RETAINER-SEAL		1
355	147A6145-16		. RETAINER-SEAL		1
360	147A6145-18		. RETAINER-SEAL		1
365	BACR15BA3AD		. RIVET (SIZE DETERMINED ON INST)		38
370	F51646-3BAC		. NUTPLATE (V15653) (SPEC BACN10JZ3B2CDM) (OPT 102F9220-3 (V72962))		7
375	F51643-3BAC		. NUTPLATE (V15653) (SPEC BACN10JZ3A2CDM) (OPT 102F9219-3 (V72962)) (OPT NS202492-02 (V80539))		12

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
380	BACF3H12JF007HN		. FILLER		3
385	BACR15GF5D		. RIVET (SIZE DETERMINED ON INST)		40
390	147A6137-4		. PAN ASSY-HANDLE RECESS		1
400	BACR15GF5D		. . RIVET (SIZE DETERMINED ON INST)		2
405	149A6121-1		. . PLATE-SEAL		1
410	147A6137-6		. . PAN		1
415	BACB30VF3K4		. BOLT		8
420	NAS1149D0363J		. WASHER		8
425	H52732-3CD		. NUT (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))		8
430	HST11AG8-6		. BOLT (V0PTK6) (SPEC BACB30VU8K6) (OPT HST11AG8-6 (V73197)) (OPT HST11AG8-6 (V56878)) (OPT HST11AG8-6 (V06725))		4
435	HST10AG8-4		. BOLT (V0PTK6) (SPEC BACB30VT8K4) (OPT HST10AG8-4 (V06725)) (OPT HST10AG8-4 (V56878)) (OPT HST10AG8-4 (V73197)) (OPT WC10K8-4 (V60516))		2
440	HST11AG8-5		. BOLT (V0PTK6) (SPEC BACB30VU8K5) (OPT HST11AG8-5 (V73197)) (OPT HST11AG8-5 (V56878)) (OPT HST11AG8-5 (V06725))		4
445	HST10AG8-6		. BOLT (V0PTK6) (SPEC BACB30VT8K6) (OPT HST10AG8-6 (V06725)) (OPT HST10AG8-6 (V56878)) (OPT HST10AG8-6 (V73197)) (OPT WC10K8-6 (V60516))		3

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
450	HST10AG8-7		. BOLT (V0PTK6) (SPEC BACB30VT8K7) (OPT HST10AG8-7 (V06725)) (OPT HST10AG8-7 (V56878)) (OPT HST10AG8-7 (V73197)) (OPT WC10K8-7 (V60516))		4
455	HST10AG8-5		. BOLT (V0PTK6) (SPEC BACB30VT8K5) (OPT HST10AG8-5 (V06725)) (OPT HST10AG8-5 (V56878)) (OPT HST10AG8-5 (V73197)) (OPT WC10K8-5 (V60516))		3
460	HST10AG6-4		. BOLT (V06725) (SPEC BACB30VT6K4) (OPT HST10AG6-4 (V73197)) (OPT HST10AG6-4 (V56878)) (OPT HST10AG6-4 (V0PTK6))		4
465	HST79CY8		. COLLAR (V73197) (SPEC BACC30BL8) (OPT HST79-8 (V56878)) (OPT HST79-8 (V92215)) (OPT HST79-8 (V5M902))		6
470	HST828AW		. COLLAR (V5M902) (SPEC BACC30BQ8) (OPT HST828AW (V56878)) (OPT HST828AW (V73197)) (OPT HST82CY8APBW (V73197)) (OPT HST82CY8APBW (V56878))		14
475	HST79CY6		. COLLAR (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V56878)) (OPT HST79-6 (V92215)) (OPT HST79-6 (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
2–					
480	HST10AG6-5		. BOLT (V0PTK6) (SPEC BACB30VT6K5) (OPT HST10AG6-5 (V06725)) (OPT HST10AG6-5 (V56878)) (OPT HST10AG6-5 (V73197)) (OPT WC10K6-5 (V60516))		4
485	HST11AG6-3		. BOLT (V06725) (SPEC BACB30VU6K3) (OPT HST11AG6-3 (V73197)) (OPT HST11AG6-3 (V56878)) (OPT HST11AG6-3 (V0PTK6))		19
490	HST10AG6-3		. BOLT (V0PTK6) (SPEC BACB30VT6K3) (OPT HST10AG6-3 (V06725)) (OPT HST10AG6-3 (V56878)) (OPT HST10AG6-3 (V73197)) (OPT WC10K6-3 (V60516))		28
495	HST10AG6-6		. BOLT (V0PTK6) (SPEC BACB30VT6K6) (OPT HST10AG6-6 (V06725)) (OPT HST10AG6-6 (V56878)) (OPT HST10AG6-6 (V73197)) (OPT WC10K6-6 (V60516))		2
500	HST10AG6-4		. BOLT (V06725) (SPEC BACB30VT6K4) (OPT HST10AG6-4 (V73197)) (OPT HST10AG6-4 (V56878)) (OPT HST10AG6-4 (V0PTK6))		6
505	HST10AG8-3		. BOLT (V0PTK6) (SPEC BACB30VT8K3) (OPT HST10AG8-3 (V06725)) (OPT HST10AG8-3 (V56878)) (OPT HST10AG8-3 (V73197)) (OPT WC10K8-3 (V60516))		4

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
510	HST79CY6		. COLLAR (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V56878)) (OPT HST79-6 (V92215)) (OPT HST79-6 (V5M902))		50
515	HST826AW		. COLLAR (V5M902) (SPEC BACC30BQ6) (OPT HST826AW (V56878)) (OPT HST826AW (V73197)) (OPT HST82CY6APBW (V73197)) (OPT HST82CY6APBW (V56878))		9
520	HST79CY8		. COLLAR (V73197) (SPEC BACC30BL8) (OPT HST79-8 (V56878)) (OPT HST79-8 (V92215)) (OPT HST79-8 (V5M902))		4
525	BACF3T02E4-4B		. FILLER	F	3
530	HST11AG6-4		. BOLT (V06725) (SPEC BACB30VU6K4) (OPT HST11AG6-4 (V73197)) (OPT HST11AG6-4 (V56878)) (OPT HST11AG6-4 (V0PTK6))		72
535	HST11AG6-3		. BOLT (V06725) (SPEC BACB30VU6K3) (OPT HST11AG6-3 (V73197)) (OPT HST11AG6-3 (V56878)) (OPT HST11AG6-3 (V0PTK6))		4
540	HST11AG6-5		. BOLT (V06725) (SPEC BACB30VU6K5) (OPT HST11AG6-5 (V73197)) (OPT HST11AG6-5 (V56878)) (OPT HST11AG6-5 (V0PTK6))		22
545	CR6551-3		. NUT (VF0224) (SPEC BACN10ZV3)		22

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
550	HST79CY6		. COLLAR (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V56878)) (OPT HST79-6 (V92215)) (OPT HST79-6 (V5M902))		76
555	BACR15GF6D		. RIVET (SIZE DETERMINED ON INST)		37
560	BACR15GF5D		. RIVET (SIZE DETERMINED ON INST)		273
565	147A6125-14		. BEAM ASSY		1
570	BACR15BB4D		. . RIVET (SIZE DETERMINED ON INST)		12
575	SL2808-3		. . SHOCKMOUNT (V97393) (SPEC BACS14K1) (OPT DE685-10 (V71985))		6
580	LGPL2SPV8-6AC		. . BOLT (V17446) (SPEC BACB30VN8K6) (OPT LGPL2SPV8-6AC (V92215)) (OPT 81669V8K6 (V56878)) (OPT LGPL2SPV8-6AC (V56878))		5
585	LGPL2SPV8-5AC		. . BOLT (V17446) (SPEC BACB30VN8K5) (OPT LGPL2SPV8-5AC (V92215)) (OPT 81669V8K5 (V56878)) (OPT LGPL2SPV8-5AC (V56878))		1
590	LGPL2SPV6-6AC		. . BOLT (V17446) (SPEC BACB30VN6K6) (OPT LGPL2SPV6-6AC (V92215)) (OPT 81669V6K6 (V56878)) (OPT LGPL2SPV6-6AC (V56878))		4
595	3SLCC8		. . COLLAR (V17446) (SPEC BACC30BK8) (OPT 3SLCC8 (V92215))		6

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
600	3SLCC6		. . COLLAR (V17446) (SPEC BACC30BK6) (OPT 3SLCC6 (V92215))		4
605	147A6128-24		. . STOP ASSY		1
610	147A6128-23		. . STOP ASSY		1
615	66-12688-11		. . . BUSHING		1
620	147A6128-48		. . . FITTING-STOP (USED ON ITEM 605)		1
625	147A6128-47		. . . FITTING-STOP (USED ON ITEM 610)		1
630	147A6126-34		. . BEAM		1
635	147A6126-32		. BEAM		1
640	147A6125-10		. BEAM ASSY		1
645	LGPL2SPV8-4AC		. . BOLT (V17446) (SPEC BACB30VN8K4) (OPT LGPL2SPV8-4AC (V92215)) (OPT 81669V8K4 (V56878)) (OPT LGPL2SPV8-4AC (V56878))		2
650	LGPL2SPV8-5AC		. . BOLT (V17446) (SPEC BACB30VN8K5) (OPT LGPL2SPV8-5AC (V92215)) (OPT 81669V8K5 (V56878)) (OPT LGPL2SPV8-5AC (V56878))		1
655	LGPL2SPV8-6AC		. . BOLT (V17446) (SPEC BACB30VN8K6) (OPT LGPL2SPV8-6AC (V92215)) (OPT 81669V8K6 (V56878)) (OPT LGPL2SPV8-6AC (V56878))		1
660	LGPL2SPV6-4AC		. . BOLT (V17446) (SPEC BACB30VN6K4) (OPT LGPL2SPV6-4AC (V92215)) (OPT 81669V6K4 (V56878)) (OPT LGPL2SPV6-4AC (V56878))		3

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
665	LGPL2SPV6-7AC		. . BOLT (V17446) (SPEC BACB30VN6K7) (OPT LGPL2SPV6-7AC (V92215)) (OPT 81669V5K6 (V56878)) (OPT LGPL2SPV6-7AC (V56878))		3
670	3SLCC8		. . COLLAR (V17446) (SPEC BACC30BK8) (OPT 3SLCC8 (V92215))		4
675	3SLCC6		. . COLLAR (V17446) (SPEC BACC30BK6) (OPT 3SLCC6 (V92215))		6
680	147A6128-16		. . STOP ASSY		1
685	147A6128-18		. . STOP ASSY		1
690	66-12688-11		. . . BUSHING		1
695	147A6128-40		. . . FITTING-STOP (USED ON ITEM 680)		1
700	147A6128-42		. . . FITTING-STOP (USED ON ITEM 685)		1
705	147A6126-30		. . BEAM		1
710	147A6125-8		. BEAM ASSY		1
715	147A6125-6		. BEAM ASSY		1
720	BACB30NM3K4		. . BOLT		10
725	NAS1149D0363J		. . WASHER		10
730	BACR15BA3AD		. . RIVET (SIZE DETERMINED ON INST) (OPT ITEM 730A, 730B)		20
–730A	AF5141-3C		. . RIVET (V53551) (SPEC BACR15DR3AC) (SIZE DETERMINED ON INST) (OPT ITEM 730, 730B)		20
–730B	NAS1399CW3		. . RIVET (SIZE DETERMINED ON INST) (OPT ITEM 730, 730A)		20

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
735	NS202495-02		. . NUTPLATE (V80539) (SPEC BACN10KE3DCD) (OPT F51753-3CD (V15653))		10
740	149A6114-1		. . SPLICE		1
745	BACR15BA5AD		. . RIVET (SIZE DETERMINED ON INST)		4
750	149A6116-5		. . FILLER (USED ON ITEM 710)		2
755	149A6116-4		. . FILLER (USED ON ITEM 715)		2
760	LGPL2SPV8-7AC		. . BOLT (V17446) (SPEC BACB30VN8K7) (OPT LGPL2SPV8-7AC (V92215)) (OPT 81669V8K7 (V56878)) (OPT LGPL2SPV8-7AC (V56878)) (USED ON ITEM 710)		1
765	LGPL2SPV8-5AC		. . BOLT (V17446) (SPEC BACB30VN8K5) (OPT LGPL2SPV8-5AC (V92215)) (OPT 81669V8K5 (V56878)) (OPT LGPL2SPV8-5AC (V56878)) (USED ON ITEM 715)		1
770	LGPL2SPV8-6AC		. . BOLT (V17446) (SPEC BACB30VN8K6) (OPT LGPL2SPV8-6AC (V92215)) (OPT 81669V8K6 (V56878)) (OPT LGPL2SPV8-6AC (V56878))		2
775	LGPL2SPV8-4AC		. . BOLT (V17446) (SPEC BACB30VN8K4) (OPT LGPL2SPV8-4AC (V92215)) (OPT 81669V8K4 (V56878)) (OPT LGPL2SPV8-4AC (V56878))		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–					
780	LGPL2SPV6-7AC		. . BOLT (V17446) (SPEC BACB30VN6K7) (OPT LGPL2SPV6-7AC (V92215)) (OPT 81669V5K6 (V56878)) (OPT LGPL2SPV6-7AC (V56878)) (USED ON ITEM 710)		4
785	LGPL2SPV6-7AC		. . BOLT (V17446) (SPEC BACB30VN6K7) (OPT LGPL2SPV6-7AC (V92215)) (OPT 81669V5K6 (V56878)) (OPT LGPL2SPV6-7AC (V56878)) (USED ON ITEM 715)		1
790	LGPL2SPV6-6AC		. . BOLT (V17446) (SPEC BACB30VN6K6) (OPT LGPL2SPV6-6AC (V92215)) (OPT 81669V6K6 (V56878)) (OPT LGPL2SPV6-6AC (V56878)) (USED ON ITEM 710)		2
795	LGPL2SPV6-6AC		. . BOLT (V17446) (SPEC BACB30VN6K6) (OPT LGPL2SPV6-6AC (V92215)) (OPT 81669V6K6 (V56878)) (OPT LGPL2SPV6-6AC (V56878)) (USED ON ITEM 715)		4
800	LGPL2SPV6-5AC		. . BOLT (V17446) (SPEC BACB30VN6K5) (OPT LGPL2SPV6-5AC (V92215)) (OPT 81669V6K5 (V56878)) (OPT LGPL2SPV6-5AC (V56878)) (USED ON ITEM 715)		1
805	3SLCC8		. . COLLAR (V17446) (SPEC BACC30BK8) (OPT 3SLCC8 (V92215))		4
810	3SLCC6		. . COLLAR (V17446) (SPEC BACC30BK6) (OPT 3SLCC6 (V92215))		6
815	147A6128-10		. . STOP ASSY		1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
820	147A6128-14		. . STOP ASSY (USED ON ITEM 710)		1
825	147A6128-12		. . STOP ASSY (USED ON ITEM 715)		1
830	66-12688-11		. . . BUSHING		1
835	147A6128-34		. . . FITTING-STOP (USED ON ITEM 815)		1
840	147A6128-38		. . . FITTING-STOP (USED ON ITEM 820)		1
845	147A6128-36		. . . FITTING-STOP (USED ON ITEM 825)		1
850	147A6126-28		. . BEAM (USED ON ITEM 710)		1
855	147A6126-26		. . BEAM (USED ON ITEM 715)		1
860	147A6125-20		. BEAM ASSY	F	1
–860A	147A6125-22		. BEAM ASSY	A-E, G-Y	1
865	LGPL2SPV6-4AC		. . BOLT (V17446) (SPEC BACB30VN6K4) (OPT LGPL2SPV6-4AC (V92215)) (OPT 81669V6K4 (V56878)) (OPT LGPL2SPV6-4AC (V56878))		11
870	3SLCC6		. . COLLAR (V17446) (SPEC BACC30BK6) (OPT 3SLCC6 (V92215))		11
875	147A6128-8		. . STOP ASSY		1
880	147A6128-6		. . STOP ASSY	F	1
–880A	147A6128-50		. . STOP ASSY	A-E, G-Y	1
885	66-12688-11		. . . BUSHING		1
890	147A6128-32		. . . FITTING-STOP (USED ON ITEM 875)		1
895	147A6128-30		. . . FITTING-STOP (USED ON ITEM 880)	F	1
–895A	147A6128-52		. . . FITTING-STOP (USED ON ITEM 880A)	A-E, G-Y	1
900	147A6126-38		. . BEAM		1

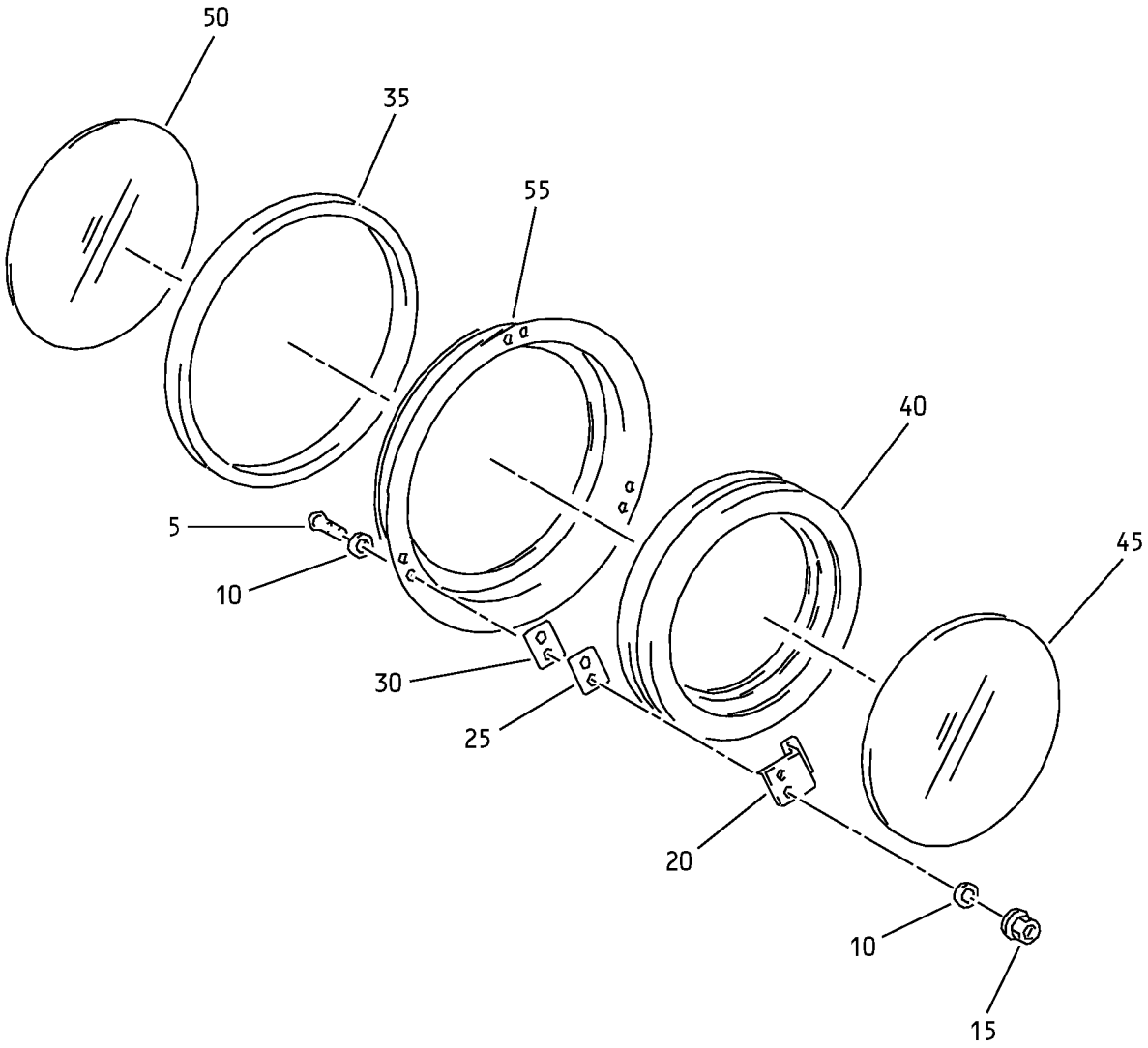
–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
905	147A6125-18		. BEAM ASSY	E-J, L	1
–905A	147A6125-24		. BEAM ASSY	A-D, K, M-Y	1
910	BACR15BB4D		. . RIVET (SIZE DETERMINED ON INST)		4
915	SL2751-3S		. . SHOCKMOUNT (V97393) (SPEC BACS14K3) (OPT DE676-10 (V71985))		2
920	LGPL2SPV8-6AC		. . BOLT (V17446) (SPEC BACB30VN8K6) (OPT LGPL2SPV8-6AC (V92215)) (OPT 81669V8K6 (V56878)) (OPT LGPL2SPV8-6AC (V56878))		5
925	LGPL2SPV8-5AC		. . BOLT (V17446) (SPEC BACB30VN8K5) (OPT LGPL2SPV8-5AC (V92215)) (OPT 81669V8K5 (V56878)) (OPT LGPL2SPV8-5AC (V56878))		1
930	LGPL2SPV6-6AC		. . BOLT (V17446) (SPEC BACB30VN6K6) (OPT LGPL2SPV6-6AC (V92215)) (OPT 81669V6K6 (V56878)) (OPT LGPL2SPV6-6AC (V56878))		4
935	3SLCC8		. . COLLAR (V17446) (SPEC BACC30BK8) (OPT 3SLCC8 (V92215))		6
940	3SLCC6		. . COLLAR (V17446) (SPEC BACC30BK6) (OPT 3SLCC6 (V92215))		4
945	147A6128-2		. . STOP ASSY		1
950	147A6128-4		. . STOP ASSY		1
955	66-12688-11		. . . BUSHING		1
960	147A6128-26		. . . FITTING-STOP (USED ON ITEM 945)		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–					
965	147A6128-28		. . . FITTING-STOP (USED ON ITEM 950)		1
970	147A6126-22		. . BEAM	E-J, L	1
–970A	147A6126-40		. . BEAM	A-D, K, M-Y	1
975	BACS40R007B008F		. SHIM	F	AR
980	BACS40R007B017F		. SHIM	F	AR
985	BAC27DBY191		. MARKER-ALUMINUM FOIL	A-S	1
990	MS27253F1		. PLATE		1

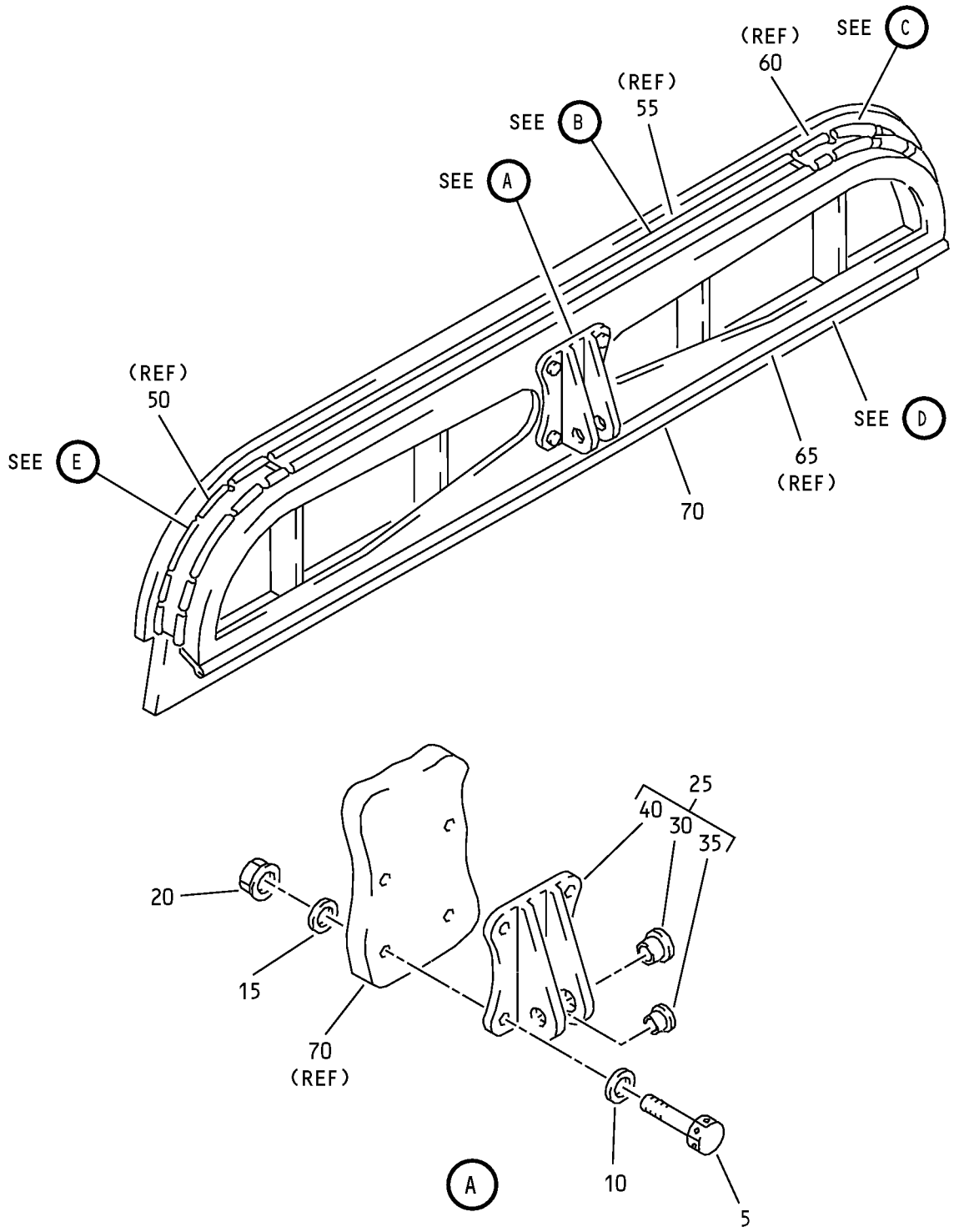
–Item not Illustrated



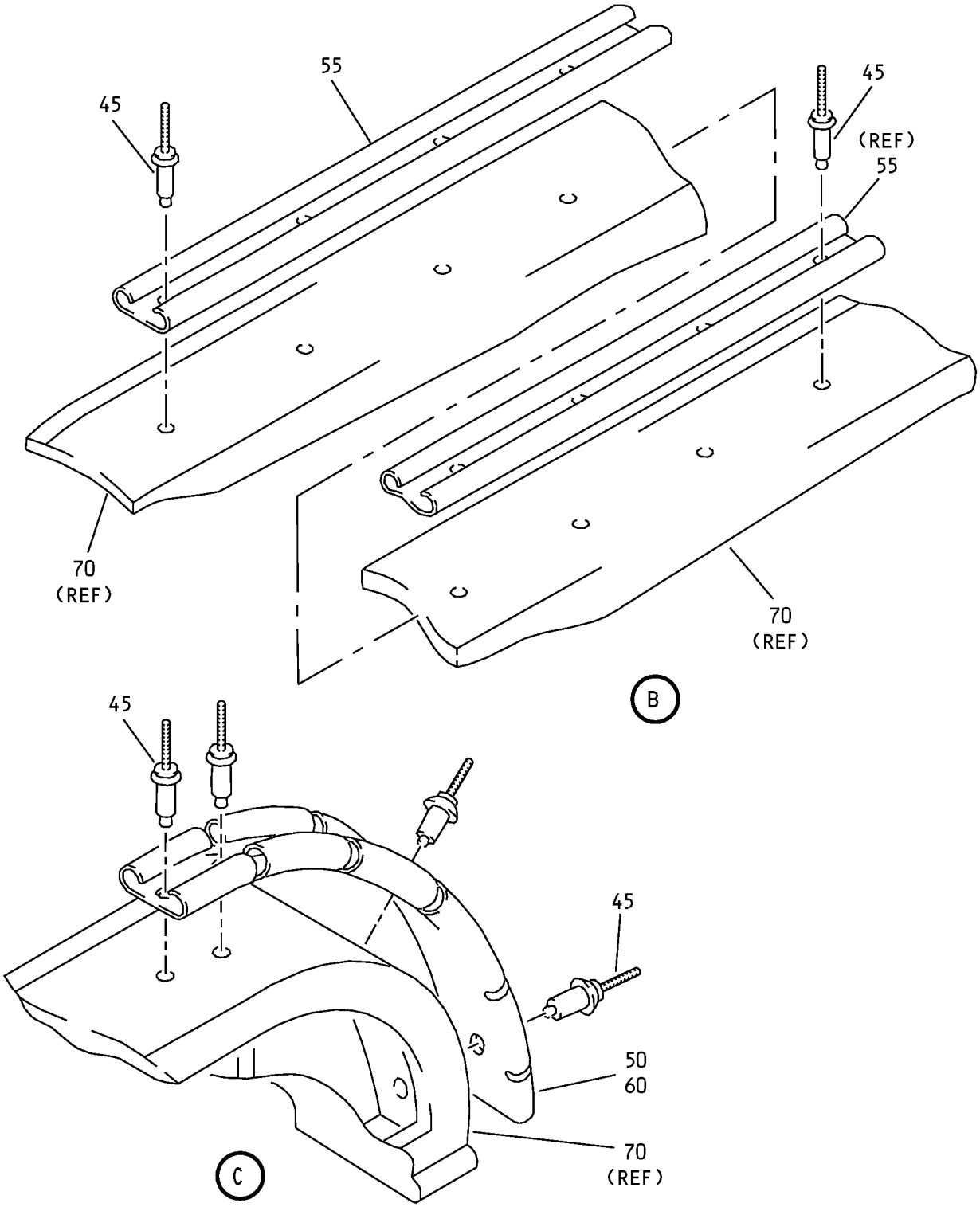
Observation Window Assembly
IPL Figure 3

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
3–					
–1A	65-2863-8		WINDOW ASSY-OBSV, 5 IN. DIA	A-U	RF
5	NAS8200A8		. SCREW	A-U	6
10	NAS1149DN432J		. WASHER	A-U	12
15	H52732-04CD		. NUT (V15653) (SPEC BACN10YR04CD) (OPT BH00312-04 (V27238))	A-U	6
20	63-1478-1		. CLIP	A-U	3
25	BACS40R007B007F		. SHIM	A-U	AR
30	BACS40R007C007F		. SHIM	A-U	AR
35	66-2646		. SEAL-SPONGE RUBBER	A-U	1
40	66-1921-2		. SEAL	A-U	1
45	69-1083-2		. PANE-INNER	A-U	1
50	69-1084-2		. PANE-OUTER	A-U	1
55	69-1983-7		. RETAINER	A-U	1

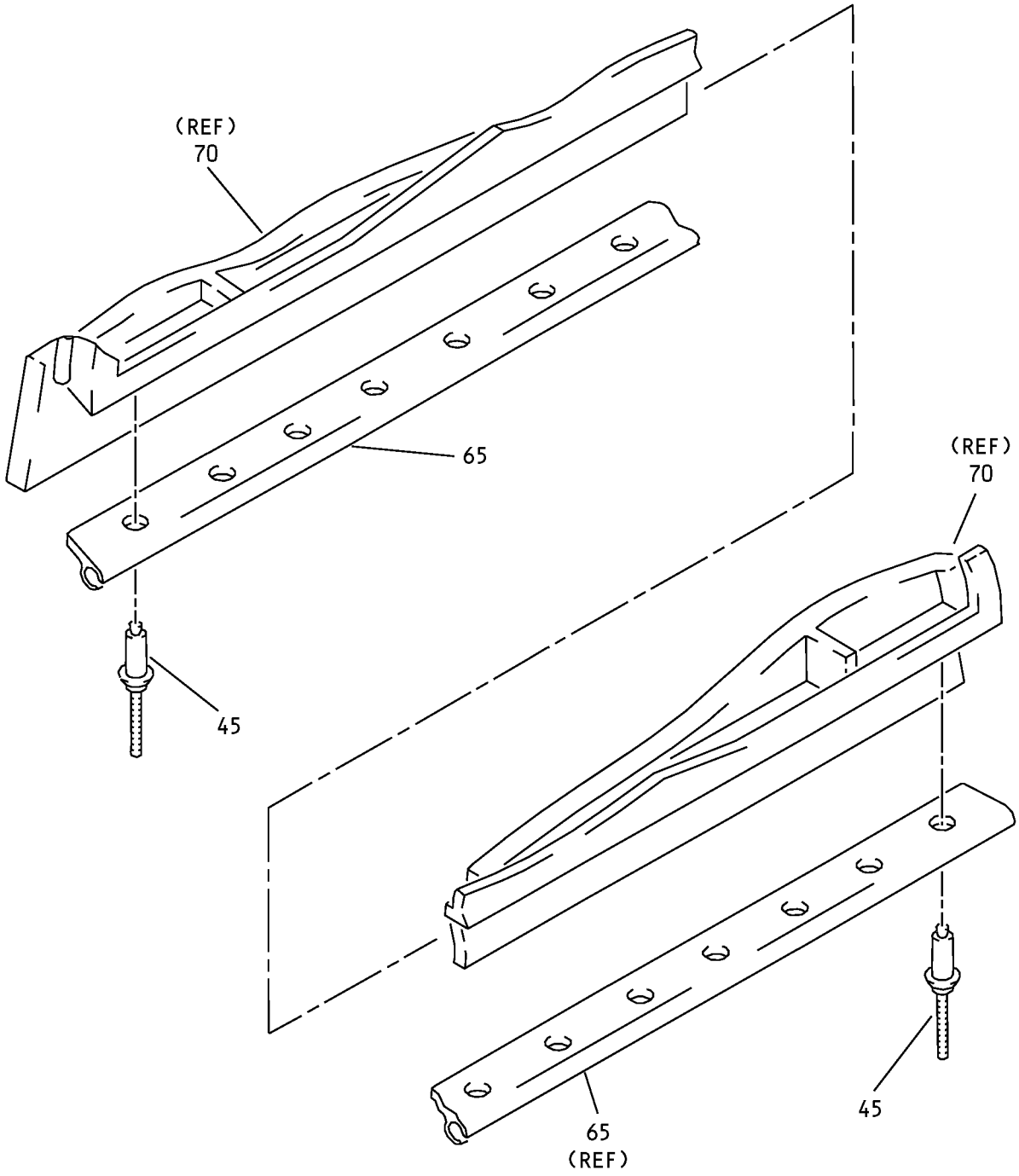
–Item not Illustrated



End Gate Assembly
IPL Figure 4 (Sheet 1 of 3)



End Gate Assembly
IPL Figure 4 (Sheet 2 of 3)



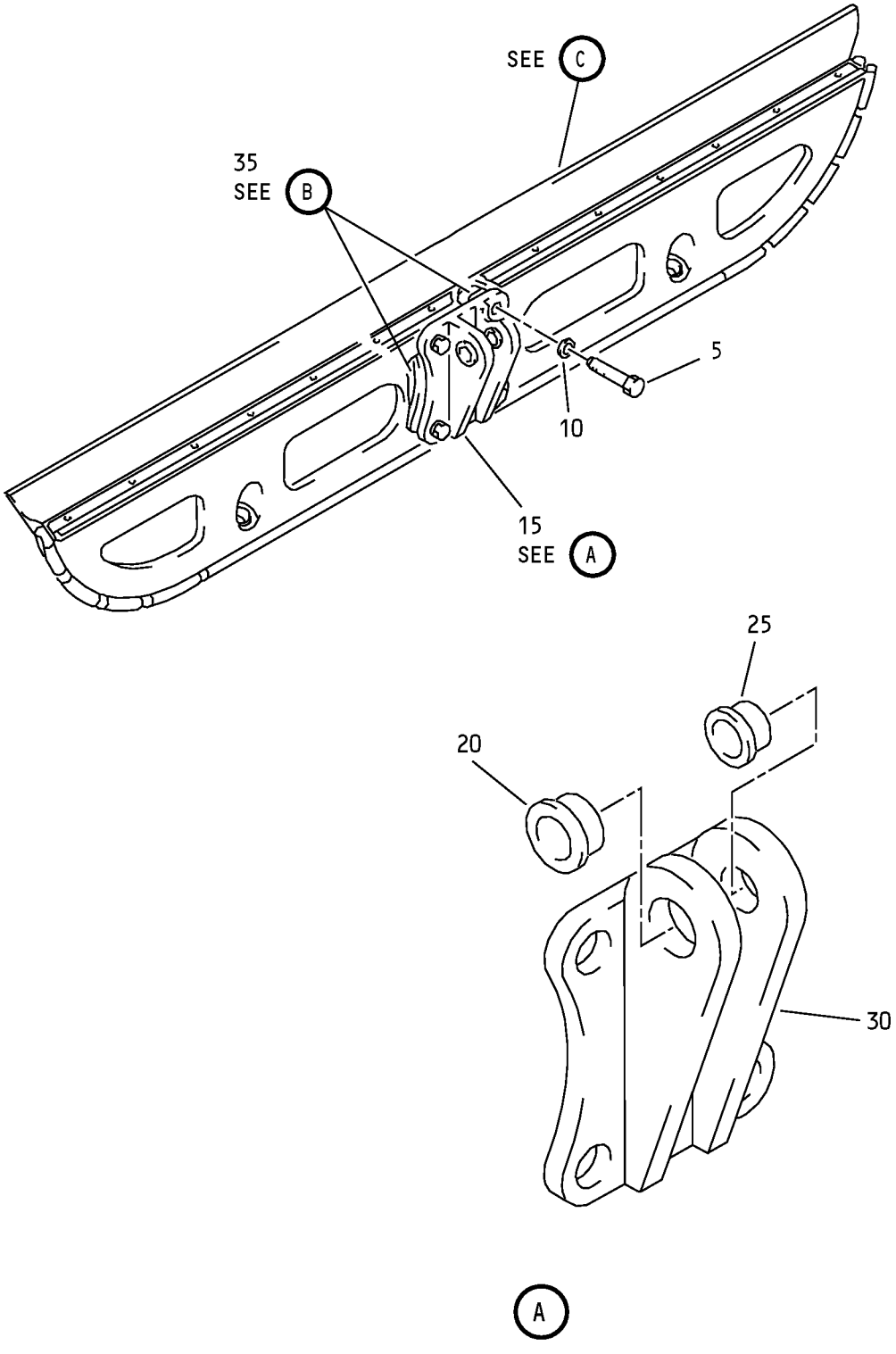
End Gate Assembly
IPL Figure 4 (Sheet 3 of 3)

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
4–					
–1A	147A6514-1		GATE ASSY-END, UPR	D-J, L	RF
–1B	147A6514-2		GATE ASSY-END, UPR	A-C, K, M, N	RF
–1C	147A6514-3		GATE ASSY-END, UPR	P-W	RF
–1D	147A6514-4		GATE ASSY-END, UPR	X, Y	RF
5	BACB30NM3K8		. BOLT		4
10	BACW10BN3AC		. WASHER		4
15	NAS1149D0363J		. WASHER		4
20	H52732-3CD		. NUT (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))		4
25	147A6144-2		. CLEVIS ASSY-CONT ROD ATTACH		1
30	BACB28X6M014		. . BUSHING		1
35	BACB28X4M014		. . BUSHING		1
40	147A6144-4		. . CLEVIS		1
45	AF3253-4-4B		. RIVET (V53551) (SPEC BACR15FR4E4R) (OPT CR3253-4-4 (V11815)) (OPT HR3253-4-4 (V0HDW7))		30
50	147A6145-8		. RETAINER-SEAL (MAKE FROM ROLLED SECTION ALUMINUM BAC1494-171 X 7.8 6061-0 AL SH PER QQ-A-250/11)		1
55	147A6145-9		. RETAINER-SEAL (MAKE FROM ROLLED SECTION ALUMINUM BAC1494-171 X 16.5 6061-T42 AL SH QQ-A-250/11)		1
60	147A6145-12		. RETAINER-SEAL (MAKE FROM ROLLED SECTION ALUMINUM BAC1494-171 X 7.8 6061-0 AL SH PER QQ-A-250/11)		1
65	147A6145-10		. RETAINER-SEAL (MAKE FROM BAC1520-584 X 29.2 2024-T3511 AL EXTRU PER QQ-A-200/3)	A-W	1

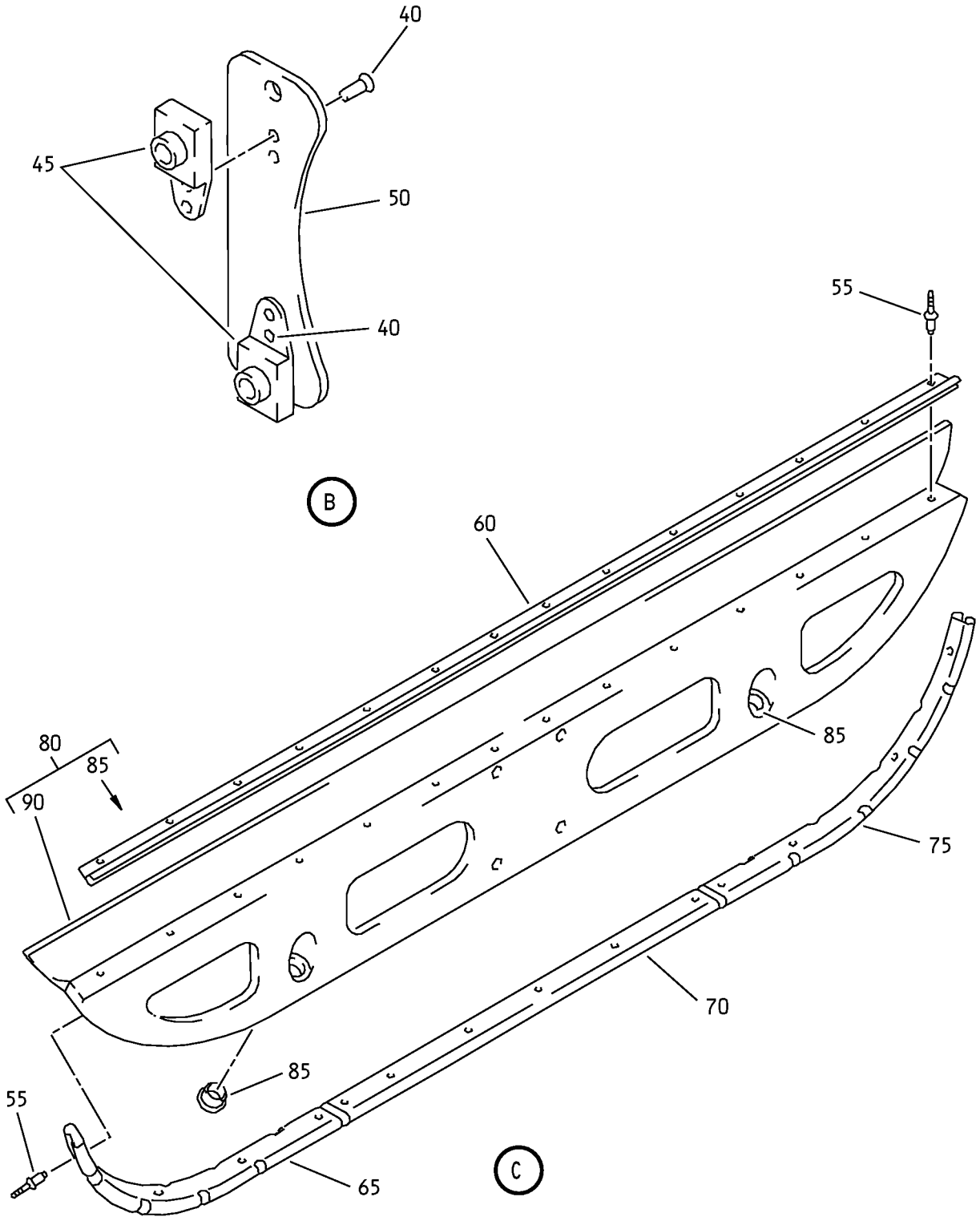
–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
4–					
–65A	147A6145-28		. RETAINER-SEAL	X, Y	1
70	147A6516-1		. GATE	D-J, L	1
–70A	147A6516-3		. GATE	A-C, K, M, N	1
–70B	147A6516-4		. GATE	P-Y	1

–Item not Illustrated



End Gate Assembly
IPL Figure 5 (Sheet 1 of 2)



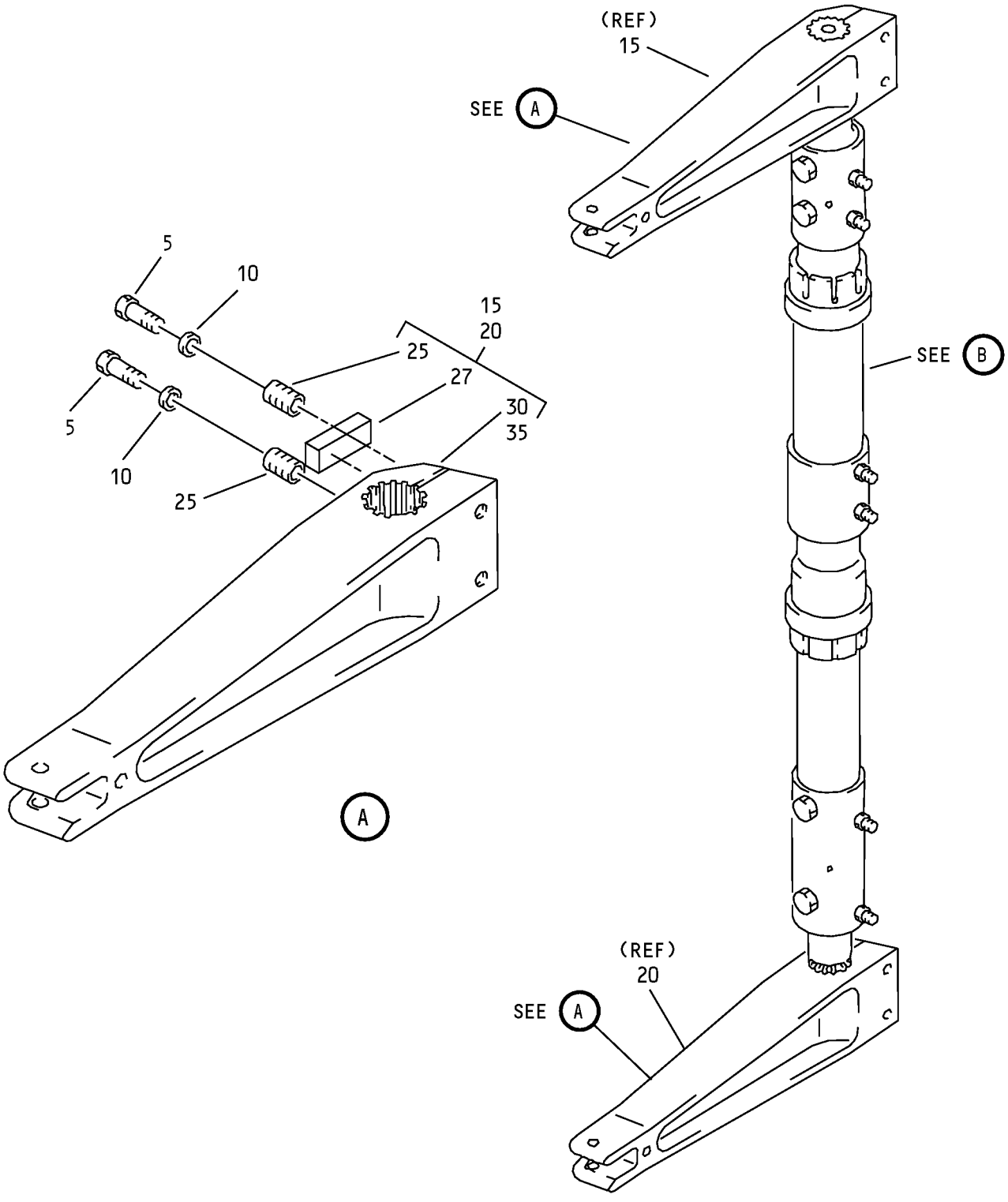
End Gate Assembly
IPL Figure 5 (Sheet 2 of 2)

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
5–					
–1A	147A6143-2		GATE ASSY-END, LWR	D-J, L	RF
–1B	147A6143-6		GATE ASSY-END, LWR	A-C, K, M, N	RF
–1C	147A6143-10		GATE ASSY-END, LWR	P-W	RF
–1D	147A6143-12		GATE ASSY-END, LWR	X, Y	RF
5	BACB30NM3K8		. BOLT		4
10	BACW10BN3AC		. WASHER		4
15	147A6144-1		. CLEVIS ASSY		1
20	BACB28X6M014		. . BUSHING		1
25	BACB28X4M014		. . BUSHING		1
30	147A6144-3		. . CLEVIS		1
35	149A6113-2		. PLATE ASSY-NUTPLATE CARRIER		2
40	BACR15BA3AD		. . RIVET (SIZE DETERMINED ON INST)		4
45	F51636-3		. . NUTPLATE (V15653) (SPEC BACN10JA3CD) (OPT 102F177-3 (V72962)) (OPT BRF110C3D (V52828)) (OPT BRF170C3D (V52828)) (OPT NS202484-02 (V80539))		2
50	149A6113-4		. . PLATE		1
55	AF3253-4-3B		. RIVET (V53551) (SPEC BACR15FR4E3R) (OPT CR3253-4-3 (V11815))		28
60	147A6145-22		. RETAINER-SEAL (MAKE FROM ROLLED SECTION ALUMINUM BAC1520-584 X 29.1 2024-T3511 AL EXTRU QQ-A-200/3)	A-W	1
–60A	147A6145-29		. RETAINER-SEAL	X, Y	1
65	147A6145-20		. RETAINER-SEAL (MAKE FROM ROLLED SECTION ALUMINUM BAC1494-171 X 9.3 6061-0 AL SH QQ-1-250/11)		1

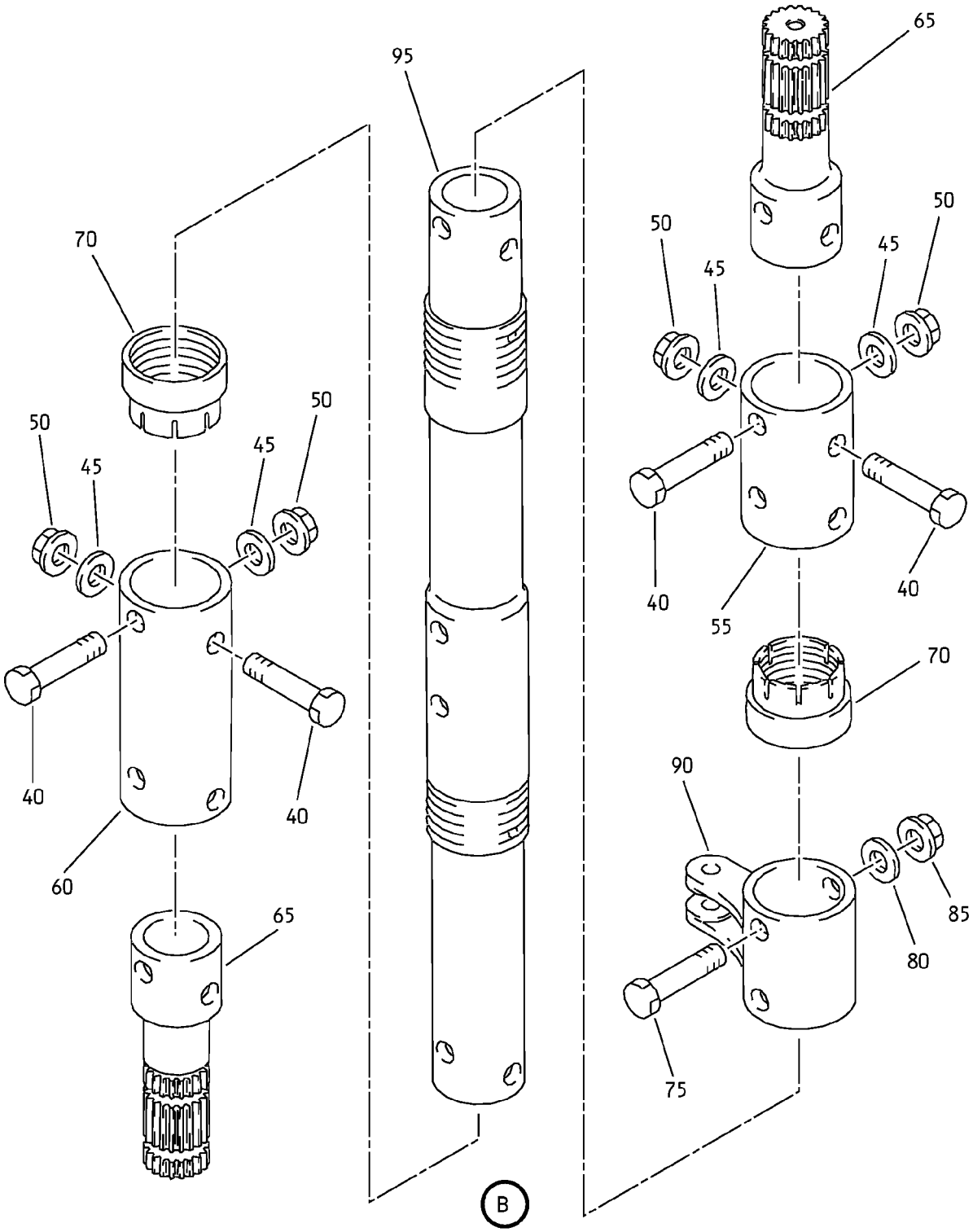
–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
5–					
70	147A6145-21		. RETAINER-SEAL (MAKE FROM ROLLED SECTION ALIMINUM BAC1494-171 X 13.2 6061-T42 AL SH QQ-A-250/11)		1
75	147A6145-24		. RETAINER-SEAL (MAKE FROM ROLLED SECTION ALUNINUM BAC1494-171 X 9.5 6061-0 AL SH QQ-A-250/11)		1
80	147A6146-2		. GATE ASSY	D-J, L	1
–80A	147A6146-8		. GATE ASSY	A-C, K, M, N	1
–80B	147A6146-12		. GATE ASSY	P-Y	1
85	69-41720-3		. . BUSHING		2
90	147A6146-4		. . GATE	D-J, L	1
–90A	147A6146-10		. . GATE	A-C, K, M, N	1
–90B	147A6146-14		. . GATE	P-Y	1

–Item not Illustrated



Torque Tube Assembly
IPL Figure 6 (Sheet 1 of 2)



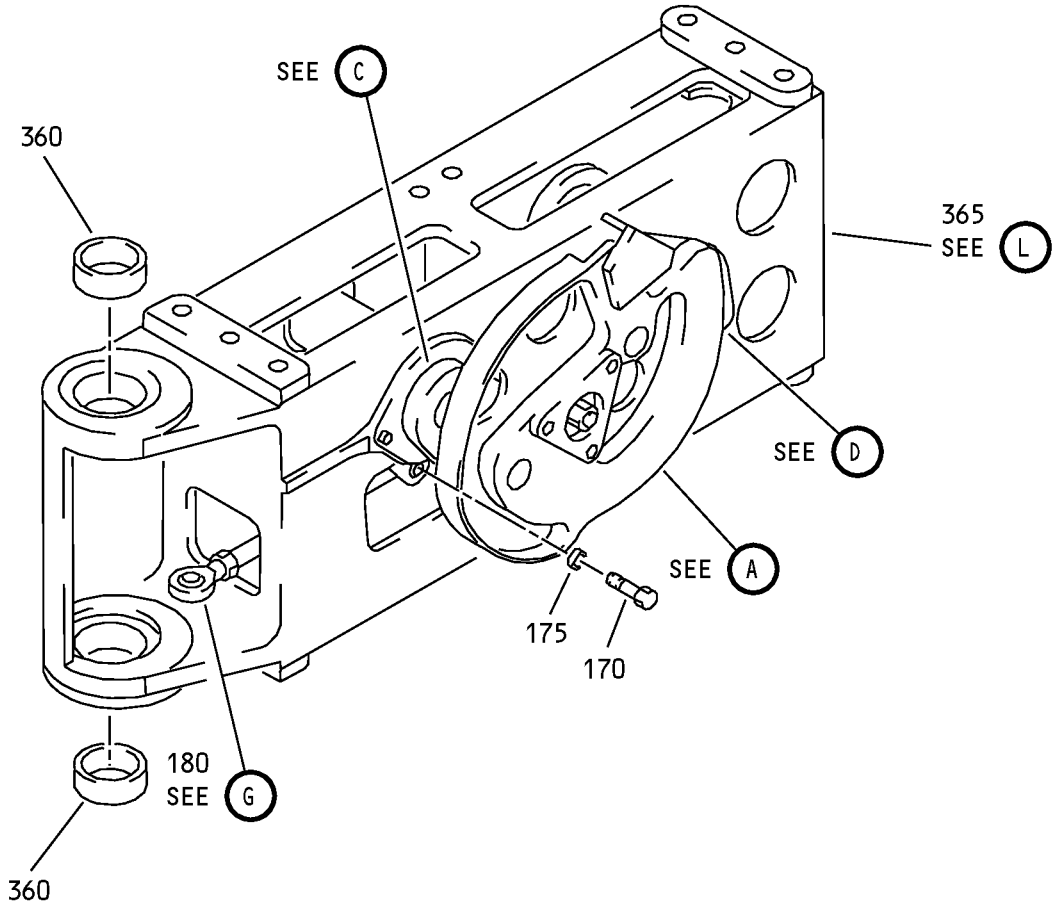
Torque Tube Assembly
IPL Figure 6 (Sheet 2 of 2)

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
6–					
–1A	147A6503-1		TUBE ASSY-TORQUE	F, G	RF
–1B	147A6503-2		TUBE ASSY-TORQUE	H	RF
–1C	147A6503-3		TUBE ASSY-TORQUE	E, J	RF
–1D	147A6503-4		TUBE ASSY-TORQUE	A-D, K-Y	RF
5	BACB30NM3K11		. BOLT (V06710) (SPEC BACB30NM3K11)		4
10	BACW10BP3CD		. WASHER		4
15	65-73978-7		. ARM ASSY-HINGE (FOR SPARES PROCURE 65-99909-2173)		1
20	65-73978-2		. ARM ASSY-HINGE	F-H	1
–20A	65-73978-16		. ARM ASSY-HINGE	E, J	1
–20B	65-73978-20		. ARM ASSY-HINGE	A-D, K-Y	1
–25	BACS13W3CN3		DELETED		
25A	NASM21209F1-15		. . INSERT		4
27	65-73978-23		. . FILLER (USED ON ITEM 20B)	A-D, K-Y	1
30	65-73978-9		. . ARM (OPT ITEM 30A) (USED ON ITEM 15)		1
–30A	65-73978-11		. . ARM (OPT ITEM 30) (USED ON ITEM 15)		1
35	65-73978-4		. . ARM (OPT ITEM 35A) (USED ON ITEM 20)	F-H	1
–35A	65-73978-14		. . ARM (OPT ITEM 35) (USED ON ITEM 20)	F-H	1
–35B	65-73978-18		. . ARM (USED ON ITEM 20A)	E, J	1
–35C	65-73978-22		. . ARM (USED ON ITEM 20B)	A-D, K-Y	1
40	BACB30PU4-25		. BOLT		8
45	BACW10BP3APU		. WASHER		8

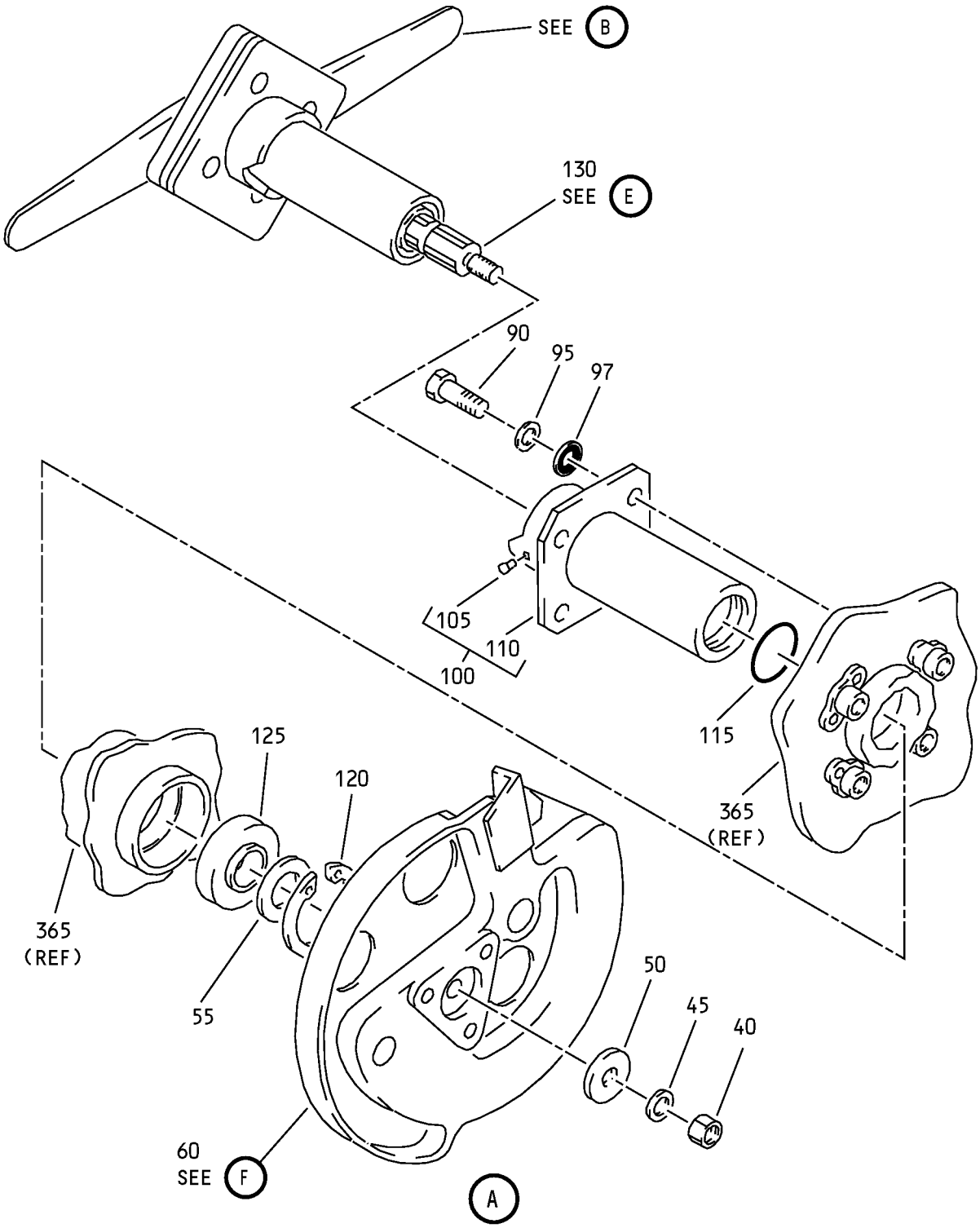
–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
6–					
50	H52732-3CM		. NUT (V15653) (SPEC BACN10YR3CM) (OPT PLH53CM (V62554))		8
55	149A6110-1		. SLEEVE-TORQUE TUBE CPLG		1
60	147A6119-1		. SLEEVE-TORQUE TUBE CPLG		1
65	66-14527-8		. PIN-HINGE LINK		2
70	60-4405-1		. NUT-SPECIAL		2
75	BACB30PU5-28		. BOLT		2
80	BACW10BP4APU		. WASHER		2
85	H52732-4CM		. NUT (V15653) (SPEC BACN10YR4CM) (OPT PLH54CM (V62554))		2
90	69-17330-6		. CRANK		1
95	147A6118-2		. TUBE	F, G	1
–95A	147A6118-4		. TUBE	A-E, H-Y	1

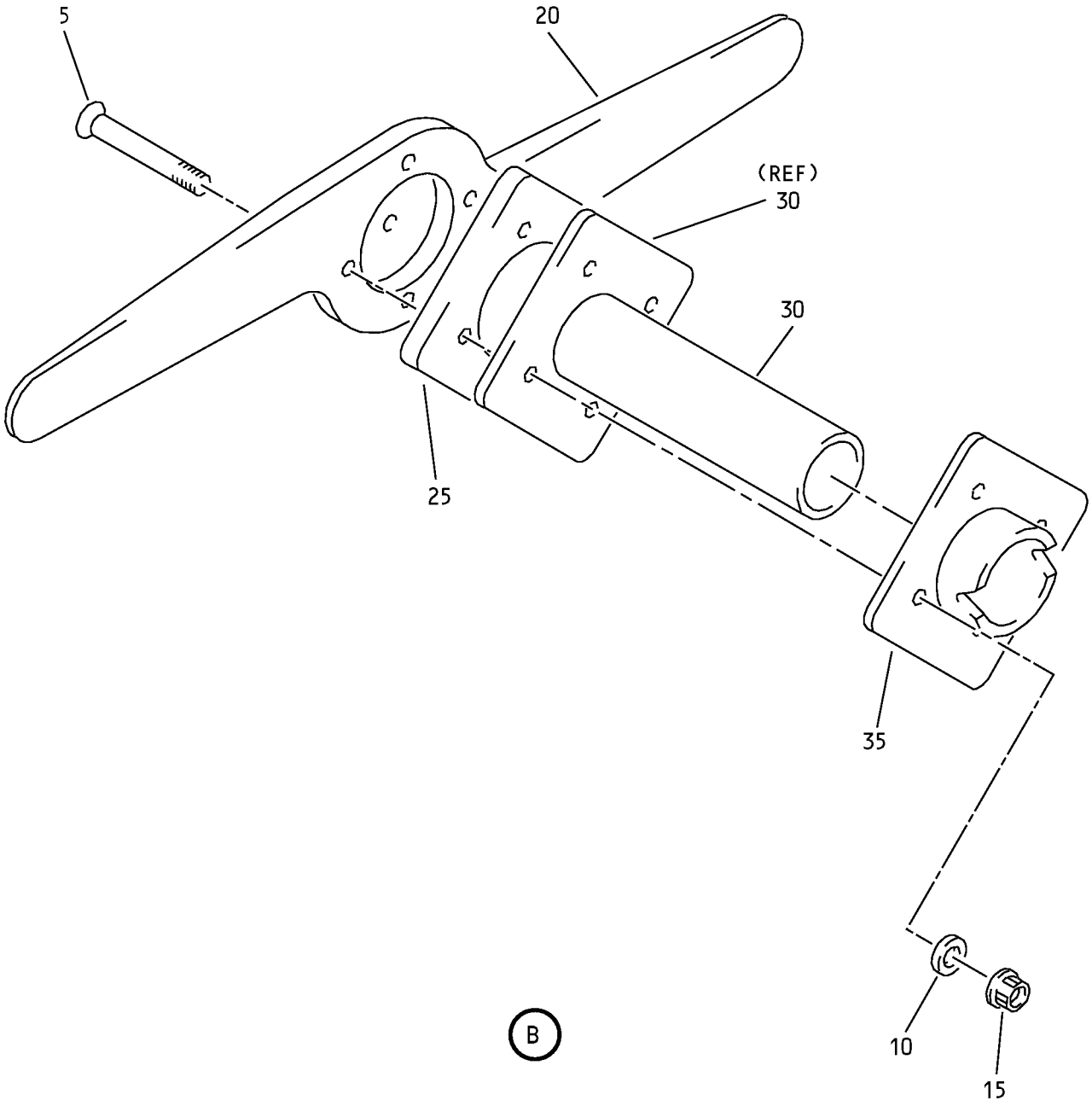
–Item not Illustrated



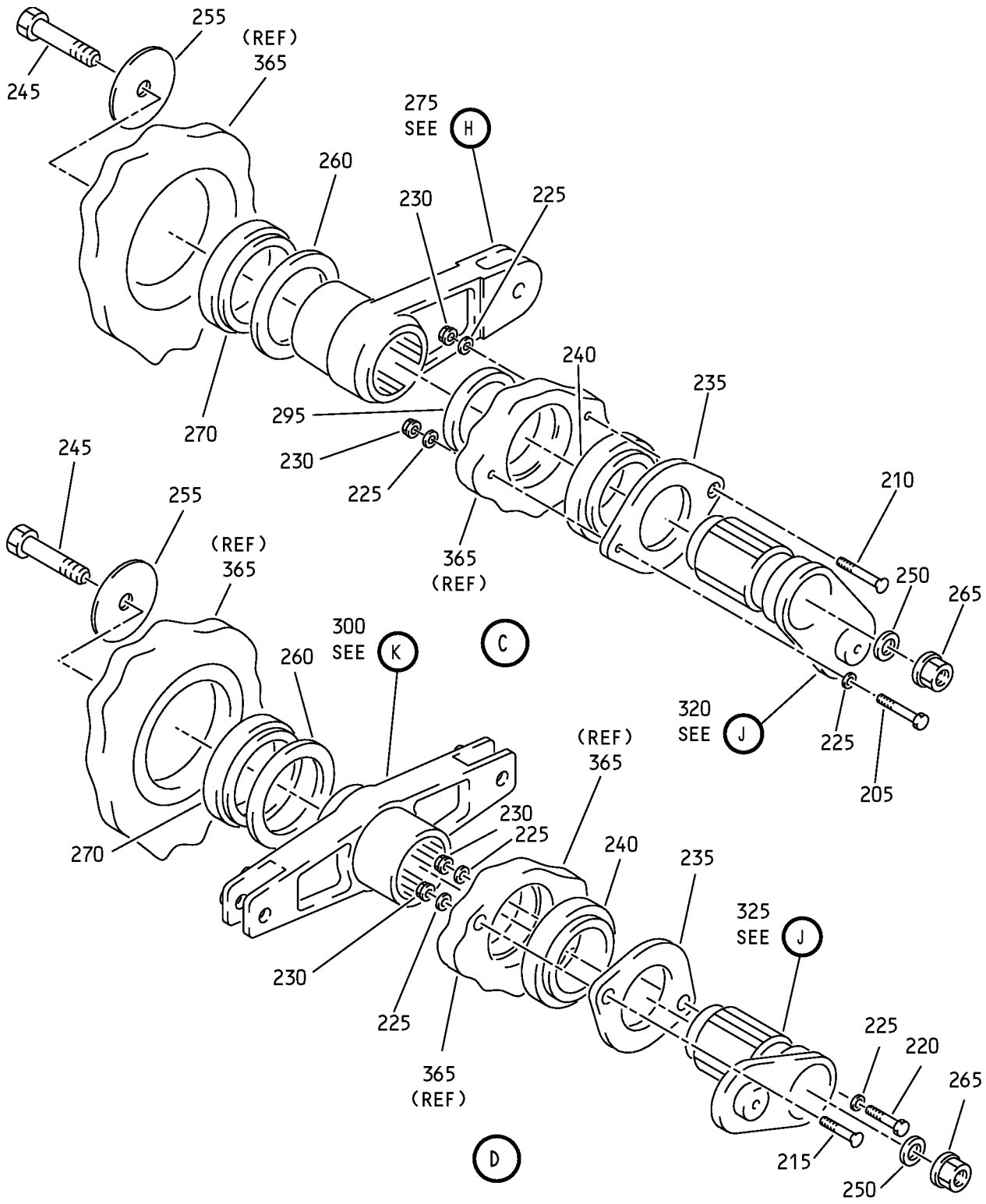
Handle Box Assembly
IPL Figure 7 (Sheet 1 of 8)



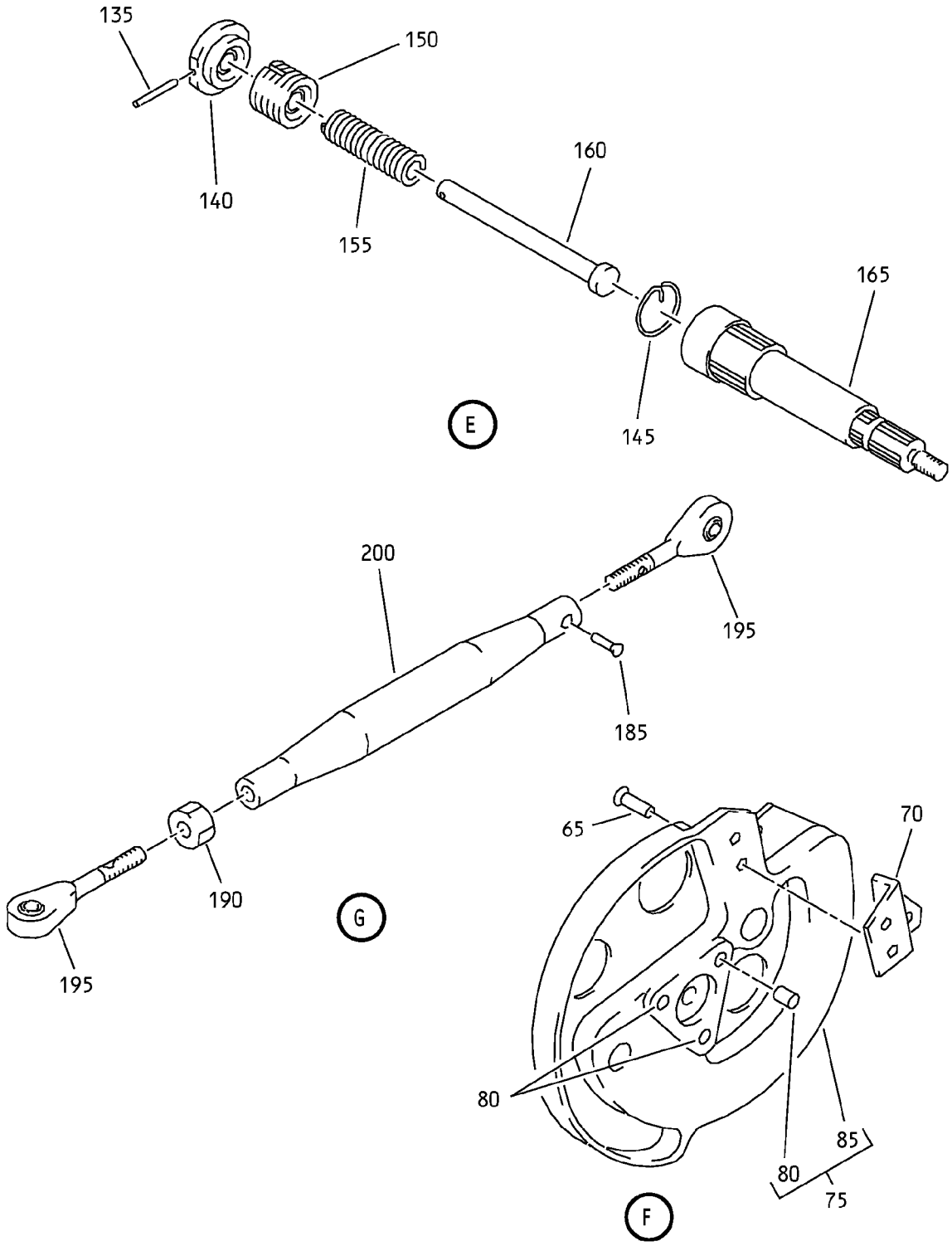
Handle Box Assembly
IPL Figure 7 (Sheet 2 of 8)



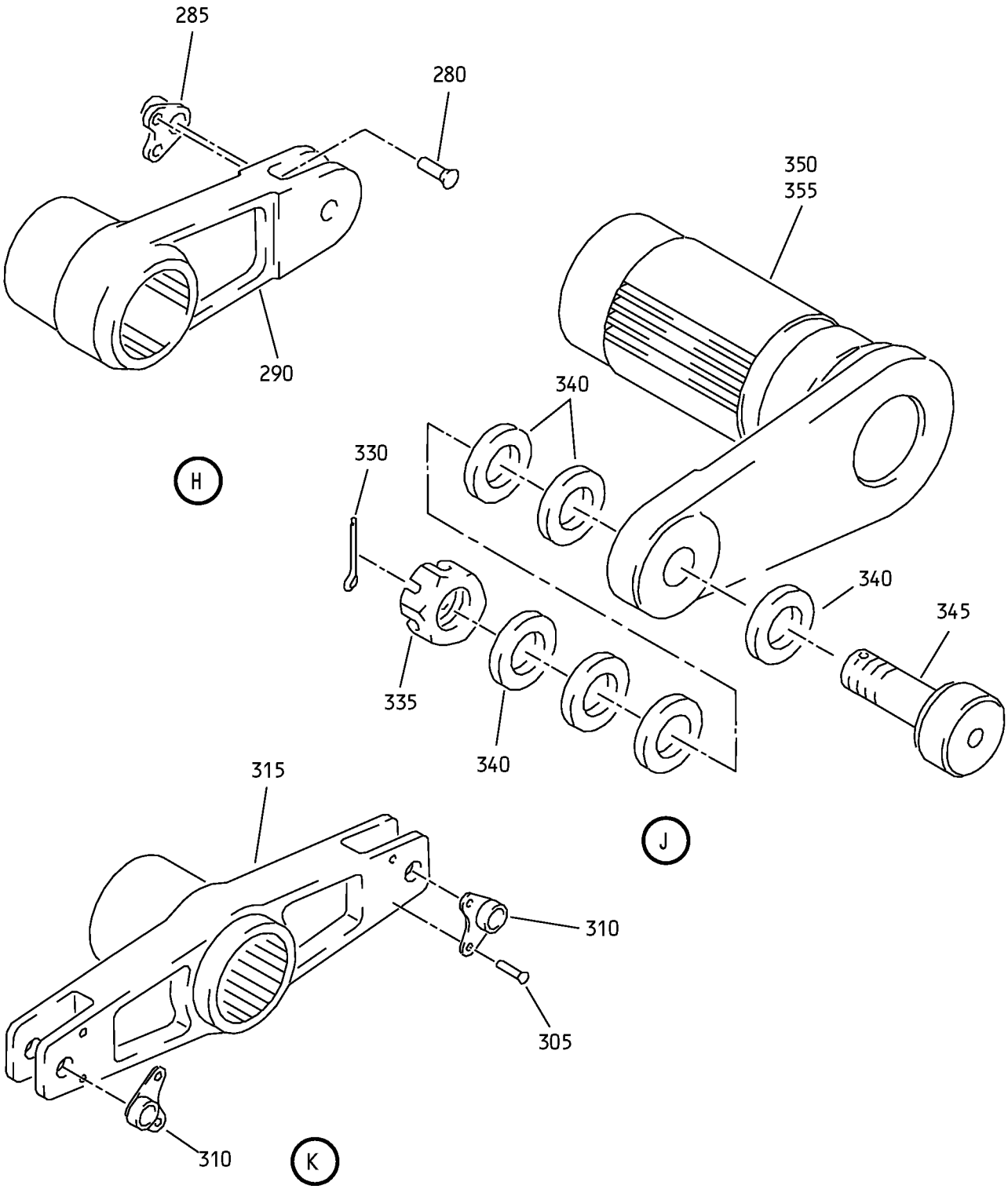
Handle Box Assembly
IPL Figure 7 (Sheet 3 of 8)



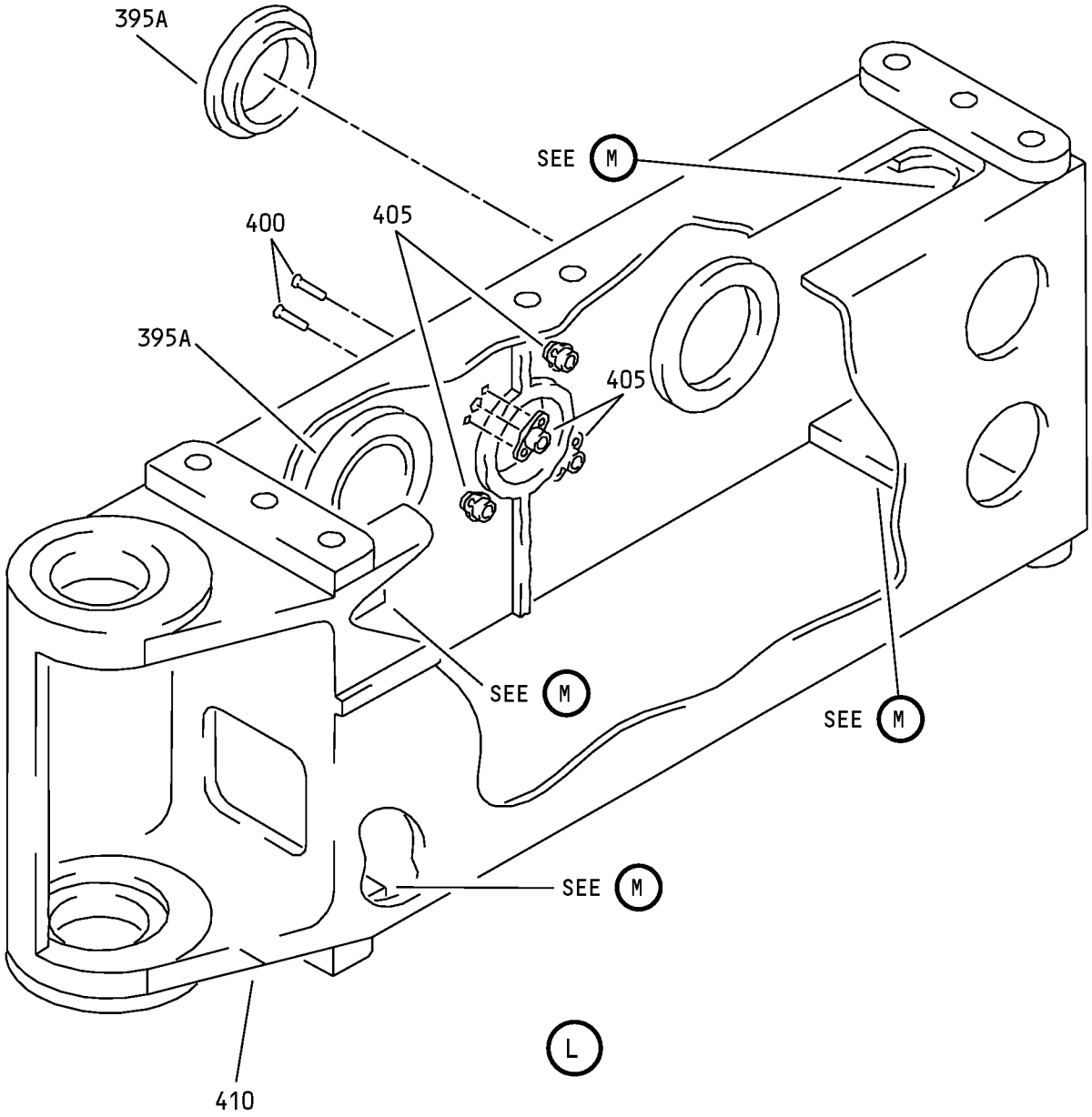
Handle Box Assembly
IPL Figure 7 (Sheet 4 of 8)



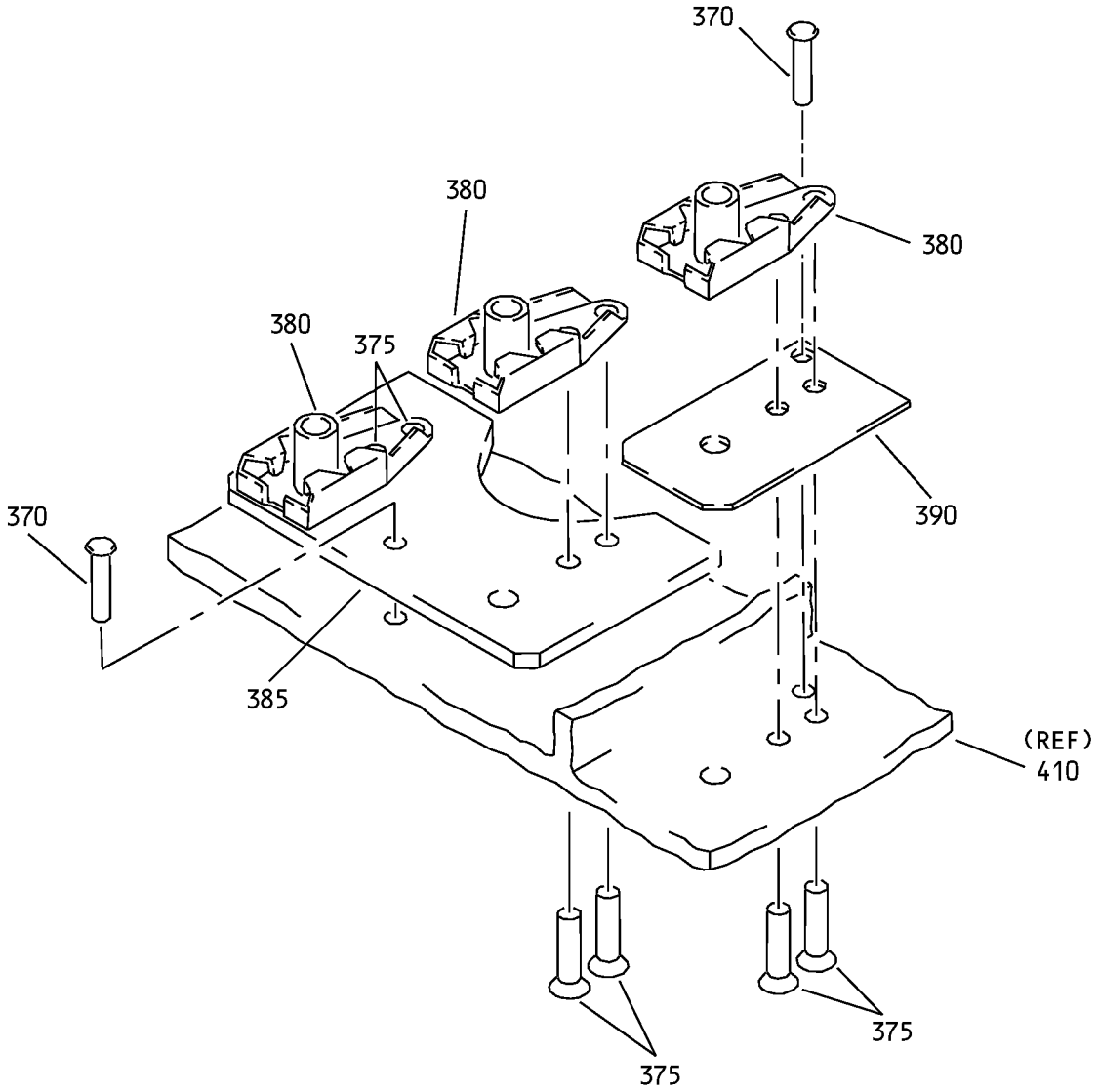
Handle Box Assembly
IPL Figure 7 (Sheet 5 of 8)



Handle Box Assembly
IPL Figure 7 (Sheet 6 of 8)



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



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

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
7–					
–1A	147A6505-2		BOX ASSY-HANDLE		RF
5	BACB30NN3K12		. BOLT		4
10	NAS1149D0363J		. WASHER		4
15	H52732-3CD		. NUT (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))		4
20	90-7879-10		. HANDLE-EXT		1
25	66-24986-1		. SPACER-HANDLE MECH		1
30	90-7821-1		. SLEEVE-HANDLE MECH		1
35	90-7811		. CAM-CENTERING		1
40	BACN10JD6CD		. NUT		1
45	NAS1149D0632J		. WASHER		AR
50	63-9386-1		. WASHER-MECH SHAFT		1
55	BACW10P148AL		. WASHER		1
60	69-34971-11		. CAM ASSY-CONT		1
65	MS20426D5		. . RIVET (SIZE DETERMINED ON INST)		3
70	69-34971-2		. . GUIDE		1
75	65-44065-11		. . CAM ASSY		1
80	MS21209F5-15P		. . . INSERT		3
85	65-44065-12		. . . CAMPLATE (OPT ITEM 85A)		1
–85A	65-44065-13		. . . CAMPLATE-HOGOUT (OPT ITEM 85)		1
90	BACB30NM3K13		. BOLT		4
95	BACW10BN3AC		. WASHER		4
97	NAS1523C3R		. PACKING		4
100	149A6120-1		. HOUSING ASSY-HANDLE MECH		1
105	NAS516-1A		. . FITTING		1
110	149A6120-2		. . FITTING-HOUSING		1
115	M83461-1-212		. PACKING		1
120	MS16625-4162		. RING		1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
7–					
125	PACMKP12AFS428		. BEARING (V21335) (SPEC BACB10FS12) (OPT SSMKP12ASD705 (V83086)) (OPT ACMKP12AP510Y198 (V40920)) (OPT PACMKP12AA3908 (V21335)) (OPT SSMKP12AP (V21760))		1
130	149A6109-1		. SHAFT ASSY		1
135	MS39086-111		. . PIN-SPR		1
140	30-3019-1		. . WASHER		1
145	AN996-14		. . RING		1
150	30-3010		. . NUT		1
155	63-2848		. . SPRING-CPRSN		1
160	30-3013-2		. . PIN		1
165	60-4455-3		. . SHAFT		1
170	BACB30NR5K17		. BOLT		1
175	NAS1149D0563J		. WASHER		1
180	69-39176-1		. ROD ASSY		1
185	MS20615-5M10		. . RIVET		1
190	AN316-6R		. . NUT		1
195	ARHT5E102		. . ROD END-BRG (VS0352) (SPEC 10-60779-112) (OPT 77253 (V09455)) (OPT DREM5-019 (V81376)) (OPT KBDE5-14 (V97613)) (OPT MSSR56-14BAC (V73134)) (OPT NHNE5-202 (V15860)) (OPT REM10ATC12-2 (V21335)) (OPT TFM5C (V77896)) (OPT ADNE5-202 (V15860))		2
200	69-39176-2		. . ROD		1
205	BACB30NM3K11		. BOLT (V06710) (SPEC BACB30NM3K11)		1
210	BACB30VF3K11		. BOLT		1
215	BACB30VF3K7		. BOLT		1
220	BACB30NM3K7		. BOLT		1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
7–					
225	NAS1149D0332J		. WASHER		6
230	H52732-3CD		. NUT (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))		4
235	69B10068-3		. RETAINER-BRG		2
240	PACMKP23BSF˜ S428		. BEARING (V21335) (SPEC BACB10FV23) (OPT SSMKP21BSSD705 (V83086)) (OPT ACMKP23BSP510LY (V40920)) (OPT SSMKP23BSSD705 (V83086)) (OPT PACMKP23BSA3908 (V21335))		2
245	BACB30NR4K6		. BOLT		2
250	NAS1149D0432J		. WASHER		2
255	63-1692-1		. WASHER		2
260	NAS1149D2190J		. WASHER		2
265	H52732-4CD		. NUT (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))		2
270	PACMKP21BSF˜ S428		. BEARING (V21335) (SPEC BACB10FV21) (OPT SSMKP21BSSD705 (V83086)) (OPT ACMKP21BSP510LY19 (V40920)) (OPT PACMKP21BSA3908 (V21335))		2
275	65-1933-23		. CRANK ASSY-COCKING		1
280	BACR15BA4D		. . RIVET (SIZE DETERMINED ON INST)		2
285	BACN10JP5CCD		. . NUTPLATE (SIZE DETERMINED ON INST) (OPT ITEM 285A)		1

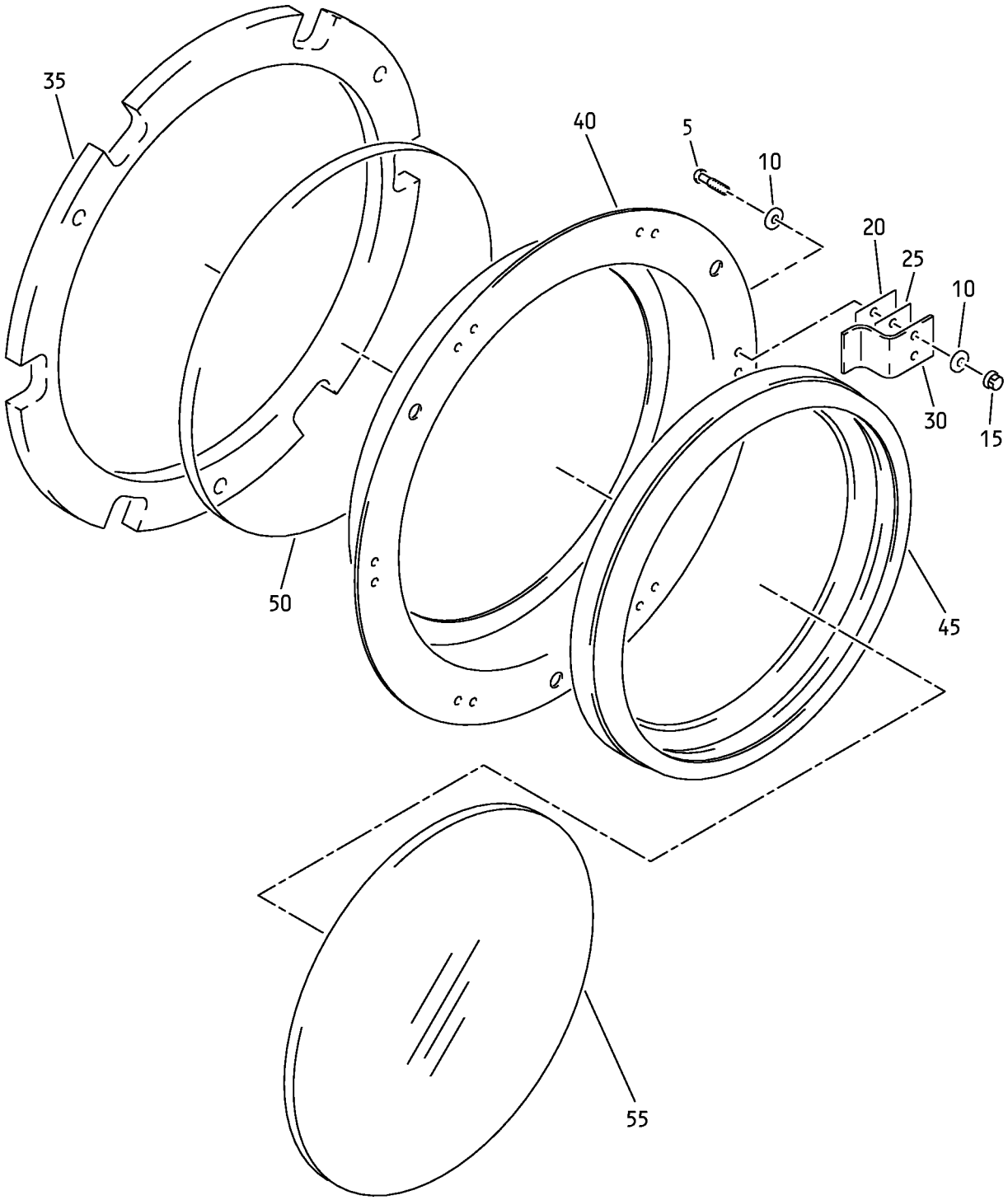
–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
7–					
–285A	MK3000-5BAC		. . NUTPLATE (V15653) (SPEC BACN10JP5C) (OPT NS103199-054 (V80539)) (OPT RMA9205M5 (V72962)) (OPT T8078S524 (V11815)) (SIZE DETERMINED ON INST) (OPT ITEM 285)		1
290	65-1933-24		. . ARM-CRANK		1
295	65-8795-501		. RING-SPACER		1
300	65-54013-503		. CRANK ASSY-LATCHING		1
305	MS20470D3-4		. . RIVET		4
310	BR3000A4		. . NUTPLATE (V52828) (SPEC BACN10KF4) (OPT K3000-4BAC (V15653)) (OPT NS103195-048 (V80539)) (OPT RMA9205-4 (V72962)) (OPT VN103A1-048 (V92215)) (OPT T8118S4 (V11815))		2
315	65-54013-502		. . CRANK		1
320	90-7815-25		. CRANK ASSY-CAM FOLLOWER		1
325	90-7815-26		. CRANK ASSY-CAM FOLLOWER		1
330	MS24665-283		. . PIN-COTTER		1
335	BACN10JD106ASU		. . NUT		1
340	NAS1149C0632B		. . WASHER		AR
345	KRP141500VT6-6		. . BEARING (V50632)		1
350	90-7815-29		. . ARM-CRANK (USED ON ITEM 320)		1
355	90-7815-30		. . ARM-CRANK (USED ON ITEM 325)		1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
7–					
360	ACMKP25P26LY198		. BEARING (V40920) (SPEC BACB10FR25) (OPT ACMKP25BP510LY198 (V40920)) (OPT ACMKP25BP26LY198 (V40920)) (OPT SSMKP25BSD703 (V83086)) (OPT PACMKP25BA3908 (V21335)) (OPT PACMKP25BFS428 (V21335))		2
365	149A6107-3		. HOUSING ASSY		1
370	BACR15GF5D		. . RIVET (SIZE DETERMINED ON INST)		8
375	BACR15BA3AD		. . RIVET (SIZE DETERMINED ON INST)		24
380	F51636-4		. . NUTPLATE (V15653) (SPEC BACN10JA4CD) (OPT 102F177-4 (V72962)) (OPT BRF110C4D (V52828)) (OPT BRF170C4D (V52828)) (OPT F51636-4 (V15653))		12
385	69-78694-3		. . FILLER		4
390	69-78694-4		. . FILLER		4
395	65C36793-3		DELETED		
395A	65C36793-1		. . BUSHING		2
400	BACR15BA3AD		. . RIVET (SIZE DETERMINED ON INST)		8
405	BACN10JP3ACD		. . NUTPLATE		4
410	149A6107-6		. . HOUSING		1

–Item not Illustrated



1665211 S0000295929_V1

Window Assy - Obsv 5 in. Dia
IPL Figure 8

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
8–					
–1A	141A6570-1		WINDOW ASSY-OBSV 5 IN. DIA	V-Y	RF
5	BACS12HJ04K8		. SCREW (OPT ITEM 5A)		12
–5A	NAS8200A8		. SCREW (OPT ITEM 5)		12
10	NAS1149DN432J		. WASHER		24
15	PLH504CD		. NUT (V62554) (SPEC BACN10YR04CD) (OPT H52732-04CD (V15653))		12
20	BACS40R007B007F		. SHIM		AR
25	BACS40R007C007F		. SHIM		AR
30	141A6573-1		. CLIP		6
35	141A6575-1		. SEAL-SPONGE RUBBER		1
40	141A6572-1		. RETAINER		1
45	141A6574-1		. SEAL		1
50	141A6571-1		. PANE-OUTER		1
55	141A6571-2		. PANE-INNER		1

–Item not Illustrated