



# **COMPONENT MAINTENANCE MANUAL WITH ILLUSTRATED PARTS LIST**

## **FORWARD GALLEY DOOR ASSEMBLY**

**PART NUMBER**  
**141A6516-10, -11, -12, -13, -14, -15, -16, -17, -18,**  
**-19, -2, -20, -21, -3, -4, -7, -8, -9**

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**52-41-05**

Page 1  
Jul 01/2009



## COMPONENT MAINTENANCE MANUAL

Revision No. 11  
Jul 01/2009

To: All holders of FORWARD GALLEY DOOR ASSEMBLY 52-41-05.

Attached is the current revision to this COMPONENT MAINTENANCE MANUAL

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

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

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

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**52-41-05**  
TRANSMITTAL LETTER  
Page 1  
Jul 01/2009



## COMPONENT MAINTENANCE MANUAL

Location of Change

Description of Change

NO HIGHLIGHTS

**52-41-05**

HIGHLIGHTS

Page 1

Jul 01/2009



## COMPONENT MAINTENANCE MANUAL

Subject/Page	Date	Subject/Page	Date	Subject/Page	Date
TITLE PAGE		52-41-05 CLEANING		52-41-05 REPAIR 5-2 (cont)	
O 1	Jul 01/2009	401	Mar 01/2006	602	Mar 01/2006
2	BLANK	402	BLANK	52-41-05 REPAIR 6-1	
52-41-05 TRANSMITTAL LETTER		52-41-05 CHECK		601	Mar 01/2006
O 1	Jul 01/2009	501	Mar 01/2006	602	Mar 01/2006
2	BLANK	502	Mar 01/2006	52-41-05 REPAIR 6-2	
52-41-05 HIGHLIGHTS		503	Mar 01/2006	601	Mar 01/2006
O 1	Jul 01/2009	504	Mar 01/2006	602	BLANK
2	BLANK	52-41-05 REPAIR - GENERAL		52-41-05 REPAIR 7-1	
52-41-05 EFFECTIVE PAGES		601	Mar 01/2006	601	Mar 01/2006
1 thru 4	Jul 01/2009	602	Mar 01/2006	602	Mar 01/2006
52-41-05 CONTENTS		603	Mar 01/2006	52-41-05 REPAIR 7-2	
1	Nov 01/2008	604	BLANK	601	Nov 01/2007
2	BLANK	52-41-05 REPAIR 1-1		602	BLANK
52-41-05 TR AND SB RECORD		601	Nov 01/2008	52-41-05 REPAIR 8-1	
1	Mar 01/2006	602	Nov 01/2008	601	Jul 01/2008
2	BLANK	603	Nov 01/2008	602	Mar 01/2006
52-41-05 REVISION RECORD		604	Nov 01/2008	52-41-05 REPAIR 8-2	
1	Mar 01/2006	605	Mar 01/2006	601	Mar 01/2006
2	Mar 01/2006	606	Nov 01/2008	602	Mar 01/2006
52-41-05 RECORD OF TEMPORARY REVISIONS		52-41-05 REPAIR 2-1		52-41-05 REPAIR 9-1	
1	Mar 01/2006	601	Mar 01/2006	601	Mar 01/2006
2	Mar 01/2006	602	Mar 01/2006	602	BLANK
52-41-05 INTRODUCTION		52-41-05 REPAIR 3-1		52-41-05 REPAIR 10-1	
1	Mar 01/2009	601	Mar 01/2006	601	Mar 01/2006
2	BLANK	602	Mar 01/2006	602	Mar 01/2006
52-41-05 DESCRIPTION AND OPERATION		52-41-05 REPAIR 3-2		603	Mar 01/2006
1	Mar 01/2006	601	Mar 01/2006	604	BLANK
2	Mar 01/2006	602	Mar 01/2006	52-41-05 REPAIR 10-2	
52-41-05 TESTING AND FAULT ISOLATION		52-41-05 REPAIR 4-1		601	Mar 01/2006
101	Mar 01/2006	601	Nov 01/2007	602	Mar 01/2006
102	BLANK	602	Mar 01/2006	52-41-05 REPAIR 10-3	
52-41-05 DISASSEMBLY		52-41-05 REPAIR 4-2		601	Mar 01/2006
301	Mar 01/2006	601	Mar 01/2006	602	BLANK
302	Mar 01/2006	602	BLANK	52-41-05 REPAIR 10-4	
303	Mar 01/2006	52-41-05 REPAIR 5-1		601	Mar 01/2006
304	BLANK	601	Mar 01/2006	602	BLANK
		602	BLANK	52-41-05 REPAIR 10-5	
		52-41-05 REPAIR 5-2		601	Mar 01/2006
		601	Mar 01/2006	602	Mar 01/2006

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

# 52-41-05

EFFECTIVE PAGES

Page 1

Jul 01/2009



## COMPONENT MAINTENANCE MANUAL

Subject/Page	Date	Subject/Page	Date	Subject/Page	Date
52-41-05 REPAIR 10-6		52-41-05 REPAIR 15-1		52-41-05 REPAIR 17-2 (cont)	
601	Mar 01/2006	601	Jul 01/2008	602	Mar 01/2006
602	BLANK	602	Jul 01/2008	52-41-05 REPAIR 18-1	
52-41-05 REPAIR 10-7		603	Mar 01/2006	601	Mar 01/2006
601	Mar 01/2006	604	Mar 01/2006	602	BLANK
602	BLANK	52-41-05 REPAIR 15-2		52-41-05 REPAIR 18-2	
52-41-05 REPAIR 11-1		601	Jul 01/2008	601	Mar 01/2006
601	Jul 01/2008	602	BLANK	602	BLANK
602	Mar 01/2006	52-41-05 REPAIR 15-3		52-41-05 REPAIR 19-1	
603	Mar 01/2006	601	Mar 01/2006	601	Jul 01/2008
604	BLANK	602	BLANK	602	Mar 01/2006
52-41-05 REPAIR 11-2		52-41-05 REPAIR 15-4		52-41-05 REPAIR 19-2	
601	Mar 01/2006	601	Jul 01/2008	601	Mar 01/2006
602	BLANK	602	Mar 01/2006	602	BLANK
52-41-05 REPAIR 12-1		52-41-05 REPAIR 15-5		52-41-05 REPAIR 19-3	
601	Jul 01/2008	601	Mar 01/2006	601	Mar 01/2006
602	Mar 01/2006	602	BLANK	602	BLANK
52-41-05 REPAIR 12-2		52-41-05 REPAIR 16-1		52-41-05 REPAIR 20-1	
601	Mar 01/2006	601	Mar 01/2006	601	Jul 01/2008
602	BLANK	602	BLANK	602	Mar 01/2006
52-41-05 REPAIR 13-1		52-41-05 REPAIR 16-2		603	Jul 01/2007
601	Jul 01/2008	601	Mar 01/2006	604	Jul 01/2007
602	BLANK	602	Mar 01/2006	605	Jul 01/2007
52-41-05 REPAIR 13-2		52-41-05 REPAIR 16-3		606	Jul 01/2007
601	Mar 01/2006	601	Mar 01/2006	607	Jul 01/2007
602	BLANK	602	Mar 01/2006	608	BLANK
52-41-05 REPAIR 14-1		52-41-05 REPAIR 16-4		52-41-05 REPAIR 20-2	
601	Jul 01/2008	601	Mar 01/2006	601	Mar 01/2006
602	Jul 01/2008	602	BLANK	602	Mar 01/2006
603	Mar 01/2006	52-41-05 REPAIR 16-5		603	Mar 01/2006
604	Mar 01/2006	601	Mar 01/2006	604	Mar 01/2006
52-41-05 REPAIR 14-2		602	BLANK	52-41-05 REPAIR 21-1	
601	Jul 01/2008	52-41-05 REPAIR 16-6		601	Mar 01/2006
602	BLANK	601	Mar 01/2006	602	Mar 01/2006
52-41-05 REPAIR 14-3		602	Mar 01/2006	52-41-05 REPAIR 22-1	
601	Mar 01/2006	52-41-05 REPAIR 17-1		601	Mar 01/2006
602	BLANK	601	Mar 01/2006	602	BLANK
52-41-05 REPAIR 14-4		602	BLANK	52-41-05 REPAIR 22-2	
601	Mar 01/2009	52-41-05 REPAIR 17-2		601	Mar 01/2006
602	Mar 01/2006	601	Mar 01/2006	602	Mar 01/2006

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

# 52-41-05

EFFECTIVE PAGES

Page 2

Jul 01/2009



## COMPONENT MAINTENANCE MANUAL

Subject/Page	Date	Subject/Page	Date	Subject/Page	Date
52-41-05 REPAIR 22-2 (cont)		52-41-05 ILLUSTRATED PARTS LIST (cont)		52-41-05 ILLUSTRATED PARTS LIST (cont)	
603	Mar 01/2006	1017	Nov 01/2008	1055	Nov 01/2008
604	Mar 01/2006	1018	Nov 01/2008	1056	Nov 01/2008
52-41-05 ASSEMBLY		1019	Nov 01/2008	1057	Nov 01/2008
701	Nov 01/2008	1020	Nov 01/2008	1058	Nov 01/2008
702	Nov 01/2008	1021	Nov 01/2008	1059	Nov 01/2008
703	Nov 01/2008	1022	Nov 01/2008	1060	Nov 01/2008
704	Nov 01/2008	1023	Nov 01/2008	1061	Nov 01/2008
705	Nov 01/2008	1024	Nov 01/2008	1062	Nov 01/2008
706	Nov 01/2008	1025	Nov 01/2008	1063	Nov 01/2008
707	Nov 01/2008	1026	Nov 01/2008	1064	Nov 01/2008
708	Nov 01/2008	1027	Nov 01/2008	1065	Nov 01/2008
709	Mar 01/2009	1028	Nov 01/2008	1066	Nov 01/2008
710	Nov 01/2008	1029	Nov 01/2008	1067	Nov 01/2008
711	Nov 01/2008	1030	Nov 01/2008	1068	Nov 01/2008
712	Nov 01/2008	1031	Nov 01/2008	1069	Nov 01/2008
52-41-05 FITS AND CLEARANCES		1032	Nov 01/2008	1070	Nov 01/2008
801	Mar 01/2006	1033	Nov 01/2008	1071	Nov 01/2008
802	BLANK	1034	Nov 01/2008	1072	Nov 01/2008
52-41-05 SPECIAL TOOLS, FIXTURES, AND EQUIPMENT		1035	Nov 01/2008	1073	Nov 01/2008
901	Mar 01/2009	1036	Nov 01/2008	1074	Nov 01/2008
902	BLANK	1037	Nov 01/2008	1075	Nov 01/2008
52-41-05 ILLUSTRATED PARTS LIST		1038	Nov 01/2008	1076	Nov 01/2008
1001	Nov 01/2008	1039	Nov 01/2008	1077	Nov 01/2008
1002	Nov 01/2008	1040	Nov 01/2008	1078	Nov 01/2008
1003	Nov 01/2008	1041	Nov 01/2008	1079	Nov 01/2008
1004	Nov 01/2008	1042	Nov 01/2008	1080	Nov 01/2008
1005	Nov 01/2008	1043	Nov 01/2008	1081	Nov 01/2008
1006	Nov 01/2008	1044	Nov 01/2008	1082	Nov 01/2008
1007	Nov 01/2008	1045	Nov 01/2008	1083	Nov 01/2008
1008	Mar 01/2006	1046	Nov 01/2008	1084	Nov 01/2008
1009	Nov 01/2008	1047	Nov 01/2008	1085	Nov 01/2008
1010	Nov 01/2008	1048	Nov 01/2008	1086	Nov 01/2008
1011	Nov 01/2008	1049	Nov 01/2008	1087	Nov 01/2008
1012	Nov 01/2008	1050	Nov 01/2008	1088	Nov 01/2008
1013	Nov 01/2008	1051	Nov 01/2008	1089	Nov 01/2008
1014	Nov 01/2008	1052	Nov 01/2008	1090	Nov 01/2008
1015	Nov 01/2008	1053	Nov 01/2008	1091	Nov 01/2008
1016	Nov 01/2008	1054	Nov 01/2008	1092	Nov 01/2008

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

# 52-41-05

EFFECTIVE PAGES

Page 3

Jul 01/2009



## COMPONENT MAINTENANCE MANUAL

Subject/Page	Date	Subject/Page	Date	Subject/Page	Date
52-41-05 ILLUSTRATED PARTS LIST (cont)		52-41-05 ILLUSTRATED PARTS LIST (cont)		52-41-05 ILLUSTRATED PARTS LIST (cont)	
1093	Nov 01/2008	1098.33	Nov 01/2008	1098.71	Nov 01/2008
1094	Nov 01/2008	1098.34	Nov 01/2008	1098.72	Nov 01/2008
1095	Nov 01/2008	1098.35	Nov 01/2008	1098.73	Nov 01/2008
1096	Nov 01/2008	1098.36	Nov 01/2008	1098.74	Nov 01/2008
1097	Nov 01/2008	1098.37	Nov 01/2008	1098.75	Nov 01/2008
1098	Nov 01/2008	1098.38	Nov 01/2008	1098.76	Nov 01/2008
1098.1	Nov 01/2008	1098.39	Nov 01/2008	1098.77	Nov 01/2008
1098.2	Nov 01/2008	1098.40	Nov 01/2008	1098.78	BLANK
1098.3	Nov 01/2008	1098.41	Nov 01/2008		
1098.4	Nov 01/2008	1098.42	Nov 01/2008		
1098.5	Nov 01/2008	1098.43	Nov 01/2008		
1098.6	Nov 01/2008	1098.44	Nov 01/2008		
1098.7	Nov 01/2008	1098.45	Nov 01/2008		
1098.8	Nov 01/2008	1098.46	Nov 01/2008		
1098.9	Nov 01/2008	1098.47	Nov 01/2008		
1098.10	Nov 01/2008	1098.48	Nov 01/2008		
1098.11	Nov 01/2008	1098.49	Nov 01/2008		
1098.12	Nov 01/2008	1098.50	Nov 01/2008		
1098.13	Nov 01/2008	1098.51	Nov 01/2008		
1098.14	Nov 01/2008	1098.52	Nov 01/2008		
1098.15	Nov 01/2008	1098.53	Nov 01/2008		
1098.16	Nov 01/2008	1098.54	Nov 01/2008		
1098.17	Nov 01/2008	1098.55	Nov 01/2008		
1098.18	Nov 01/2008	1098.56	Nov 01/2008		
1098.19	Nov 01/2008	1098.57	Nov 01/2008		
1098.20	Nov 01/2008	1098.58	Nov 01/2008		
1098.21	Nov 01/2008	1098.59	Nov 01/2008		
1098.22	Nov 01/2008	1098.60	Nov 01/2008		
1098.23	Nov 01/2008	1098.61	Nov 01/2008		
1098.24	Nov 01/2008	1098.62	Nov 01/2008		
1098.25	Nov 01/2008	1098.63	Nov 01/2008		
1098.26	Nov 01/2008	1098.64	Nov 01/2008		
1098.27	Nov 01/2008	1098.65	Nov 01/2008		
1098.28	Nov 01/2008	1098.66	Nov 01/2008		
1098.29	Nov 01/2008	1098.67	Nov 01/2008		
1098.30	Nov 01/2008	1098.68	Nov 01/2008		
1098.31	Nov 01/2008	1098.69	Nov 01/2008		
1098.32	Nov 01/2008	1098.70	Nov 01/2008		

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

# 52-41-05

EFFECTIVE PAGES

Page 4

Jul 01/2009

**COMPONENT MAINTENANCE MANUAL****TABLE OF CONTENTS**

<b><u>Paragraph Title</u></b>	<b><u>Page</u></b>
FORWARD 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

**52-41-05**

CONTENTS

Page 1

Nov 01/2008





**COMPONENT MAINTENANCE MANUAL**

**TEMPORARY REVISION AND SERVICE BULLETIN RECORD**

<b>BOEING SERVICE BULLETIN</b>	<b>BOEING TEMPORARY REVISION</b>	<b>OTHER DIRECTIVE</b>	<b>DATE OF INCORPORATION INTO MANUAL</b>

**52-41-05**



# COMPONENT MAINTENANCE MANUAL

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

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

## 52-41-05

REVISION RECORD

Page 1

Mar 01/2006



### COMPONENT MAINTENANCE MANUAL

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



# COMPONENT MAINTENANCE MANUAL

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Temporary Revision		Inserted		Removed		Temporary Revision		Inserted		Removed	
Number	Date	Date	Initials	Date	Initials	Date	Initials	Number	Date	Date	Initials



COMPONENT MAINTENANCE MANUAL

Temporary Revision		Inserted		Removed		Temporary Revision		Inserted		Removed	
Number	Date	Date	Initials	Date	Initials	Date	Initials	Number	Date	Date	Initials

**52-41-05**

RECORD OF TEMPORARY REVISION



## COMPONENT MAINTENANCE MANUAL

### INTRODUCTION

#### 1. General

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

# 52-41-05

INTRODUCTION

Page 1

Mar 01/2009



## COMPONENT MAINTENANCE MANUAL

### FORWARD GALLEY DOOR ASSEMBLY - DESCRIPTION AND OPERATION

#### 1. Description

- A. The forward galley door gives access to the airplane passenger cabin. The forward galley door (DESCRIPTION AND OPERATION, Figure 1) is on the right side of the fuselage, opposite (approximately) the forward passenger entry door. The door is a plug-type door. The door 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. You operate the door manually. Release the door with the central control handle. Then move the door to the fully open position with the offset assist handles. When you turn the central control handle in the OPEN direction, internal mechanisms do these functions:
- (1) Disengage the door roller latches from the latch fittings on the door frame.
  - (2) Fold the door gates inward.
  - (3) Tilt the door hinge edge to the set position.
- B. Then move the door through the door opening to the fully open position. A lock mechanism in the top 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 and guide pin track keep the door in the center of the door frame while 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.

#### 3. Leading Particulars (Approximate)

- A. Length – 68 inches
- B. Width – 35 inches
- C. Height – 6 inches
- D. Weight – 119 pounds

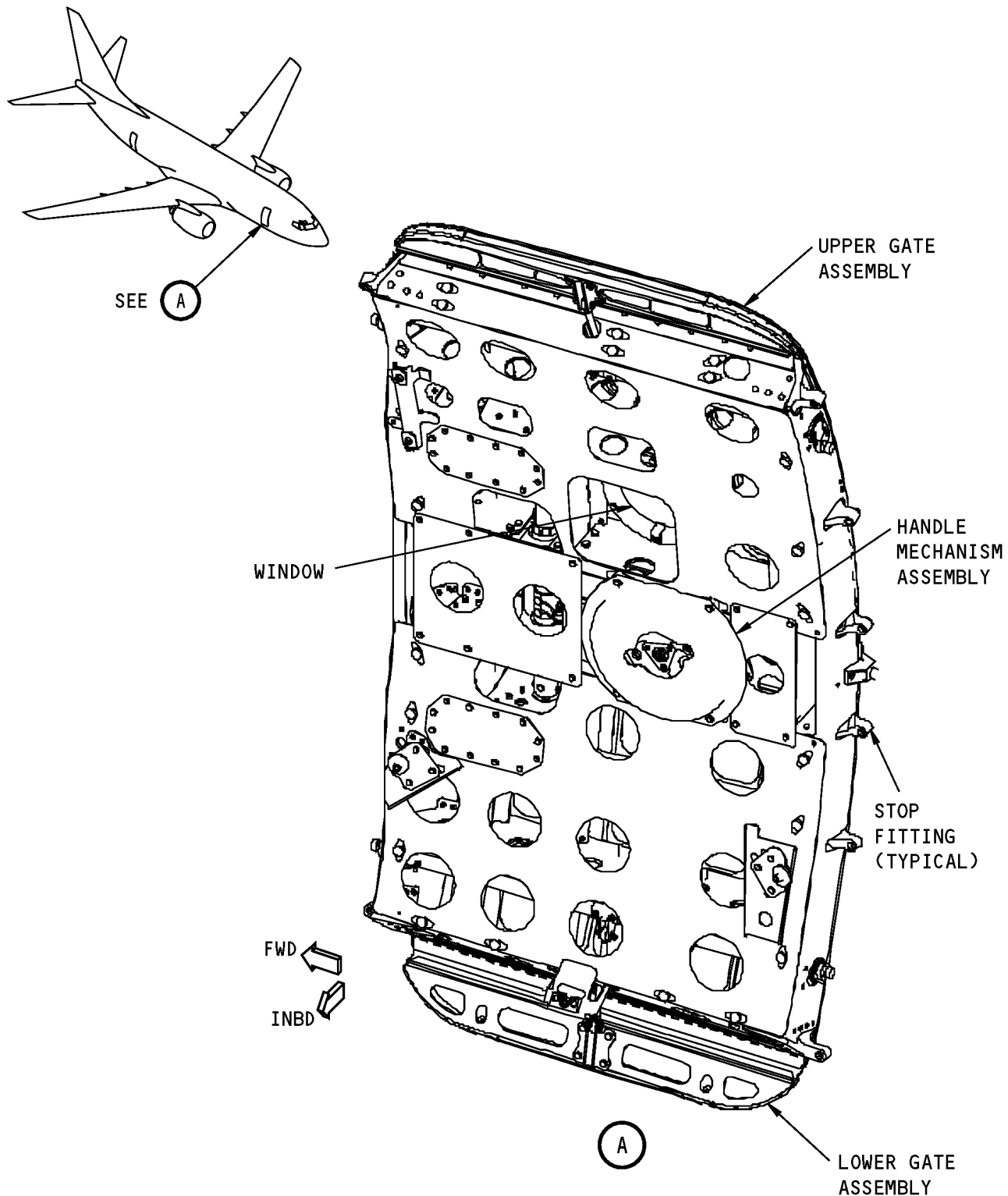
# 52-41-05

DESCRIPTION AND OPERATION

Page 1

Mar 01/2006

COMPONENT MAINTENANCE MANUAL



Forward Galley Door Assembly  
Figure 1

**52-41-05**  
DESCRIPTION AND OPERATION  
Page 2  
Mar 01/2006





**COMPONENT MAINTENANCE MANUAL**

**TESTING AND FAULT ISOLATION**

**(NOT APPLICABLE)**

**52-41-05**

TESTING AND FAULT ISOLATION

Page 101

Mar 01/2006



## COMPONENT MAINTENANCE MANUAL

### DISASSEMBLY

#### 1. General

- A. This procedure has the data necessary to disassemble the forward 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 data about the SOPM subjects identified in this procedure.
- D. Refer to IPL Figure 1 thru IPL Figure 8 for the item numbers.

#### 2. Disassembly

##### A. Special Tools

**NOTE:** Equivalent tools can be used.

- (1) F70038 - Wrench assembly
- (2) F70085 - Spanner wrench

##### B. Procedure

- (1) Use standard industry procedures and the steps that follow to disassemble this component.
- (2) Do not remove any component from the forward galley door assembly that is riveted or bonded unless a replacement is necessary.
- (3) Remove the cover plates (265, 270, 275, IPL Figure 1), the retainer (330), and the stops (210, 215) from the door structure, as follows:
  - (a) Remove the screws (225), washers (230), and the cover plates (265) from the door structure.
  - (b) Remove the screws (225), washers (230), and the cover plate (270) from the door structure.
  - (c) Remove the screws (225), washers (230), and the cover plate (275) from the door structure.
  - (d) Remove the studs (310), washers (315, 320), ring (325), and the retainer (330) from the door structure.
  - (e) Remove the bolts (195), washers (200), nuts (205) and the stops (210, 215) from the door structure.
- (4) Disconnect the upper and lower end gate assemblies (595, 600, IPL Figure 1) from the upper and lower control rod assemblies (540, 545, IPL Figure 1), as follows:
  - (a) Remove the bolt (500), washers (515, 520), and nut (530) to disconnect the upper control rod assembly (540) from the upper end gate assembly (595).
  - (b) Remove the bolt (500), washers (515, 520), and nut (530) to disconnect the lower control rod assembly (545) from the lower end gate assembly (600).
- (5) Remove the upper and lower end gate assemblies (595, 600, IPL Figure 1) from the door structure, as follows:
  - (a) Remove the bolts (605), washers (610) and the upper end gate assembly (595) from the door structure.
  - (b) Remove the bolts (605), washers (610) and the lower end gate assembly (600) from the door structure.
- (6) Remove the upper and lower control rod assemblies (540, 545, 690, 695, IPL Figure 1) from the door structure, as follows:

# 52-41-05

DISASSEMBLY

Page 301

Mar 01/2006



## COMPONENT MAINTENANCE MANUAL

- (a) Remove the bolt (505), washer (525), nut (535) and the upper control rod assembly (540) from the door structure.
  - (b) Remove the bolts (665), washers (675, 680), nut (685) and the upper control rod assembly (690) from the door structure.
  - (c) Remove the bolt (510), washers (515, 520), nut (530) and the lower control rod assembly (545) from the door structure.
  - (d) Remove the bolts (665, 670), washers (675, 680), nut (685) and the lower control rod assembly (695) from the door structure.
- (7) Remove the upper and lower latch tube assemblies (130, 135, IPL Figure 3) from the door structure, as follows:
- (a) Remove the bolts (155), washers (160), nuts (165), the roller cam cranks (170), and the roller latch spacers (5) from the upper and lower tubes (210).
  - (b) Remove the bolts (175), washers (180), nuts (185). Move the upper and lower tubes out of the door structure. Remove the latch cranks (190, 195) and the gate cranks (200, 205) from the door structure.
- (8) Remove the torque tube assembly (IPL Figure 7) from the door structure, as follows:
- (a) Remove the bolt (745, IPL Figure 1), washer (750, IPL Figure 1), and nut (755, IPL Figure 1) to disconnect the rod assembly (180, IPL Figure 8) from the crank (85, IPL Figure 7).
  - (b) Remove the bolts (70), washers (75), and the nuts (80) from the crank (85).
  - (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 coupling sleeves (55).
  - (e) Loosen the special nuts (65) attached to the torque tube assembly.
  - (f) Remove the coupling sleeves (55), special nuts (65), crank (85), and the tube (90) from the door structure.
  - (g) Remove the hinge link pins (60), the packing (730, IPL Figure 1), washer (735, IPL Figure 1), and the compression springs (740, IPL Figure 1) from the door structure.
- (9) Remove the hinge support assemblies (805, 810, IPL Figure 1) from the door structure, as follows:
- (a) Remove the bolts (795) and nuts (800) from the hinge support assemblies.
  - (b) Remove the hinge support assemblies (805, 810, IPL Figure 1), and the hinge arm assemblies (15, 20, IPL Figure 7) from the door structure.
- (10) Remove the handle box assembly (785, IPL Figure 1) from the door structure, as follows:
- (a) Remove the cotter pin (765).
  - (b) Remove the nut (40, IPL Figure 8), washers (45, 50, IPL Figure 8), control cam assembly (60, IPL Figure 8), and the exterior handle (20, IPL Figure 8) from the housing (410, IPL Figure 8).
  - (c) Remove the bolts (775), washers (780), shims (790), and the handle box assembly (785) from the door structure.
  - (d) If necessary, disassemble the handle box assembly (785, IPL Figure 1; IPL Figure 8) as follows:

# 52-41-05

DISASSEMBLY

Page 302

Mar 01/2006



## COMPONENT MAINTENANCE MANUAL

- 1) Remove the bolts (90, IPL Figure 8), 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), shims (25), handle sleeve (30), centering cam (35), and the shaft assembly (130) from the exterior handle (20).
  - a) Make a record of the number of shims (25). This data can be used during assembly.
- 3) If necessary, disassemble the shaft assembly (130) as follows:
  - a) Remove the spring pin (135), ring (145), washer (140), nut (150), 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) and 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.
- (11) Remove the window assembly (485, IPL Figure 1) from the door structure, as follows:
  - (a) Remove the bolts (465), washers (470), and the window assembly (485) from the door structure.
- (12) Remove the guide assembly (60, IPL Figure 2) and channel assembly (90, IPL Figure 2) from the door structure as follows:
  - (a) Remove the bolts (5, 10), washers (25) and the guide assembly (60) from the door structure.
  - (b) Remove the bolts (15), fillers (50, 55, 110, 115), nuts (30), serrated plate (85), and the channel assembly (90) from the door structure.

# 52-41-05

DISASSEMBLY

Page 303

Mar 01/2006



## COMPONENT MAINTENANCE MANUAL

### CLEANING

#### 1. General

- A. This procedure has the data necessary to clean the forward 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 8 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 (555, 565, 710, 715, IPL Figure 1), (75, IPL Figure 2), (10, 120, 150, IPL Figure 3), (125, 195, 240, 270, 345, 360, IPL Figure 8) as specified in SOPM 20-30-01.
- (2) Use standard industry procedures and refer to SOPM 20-30-03 to clean all other parts.

# 52-41-05

CLEANING

Page 401

Mar 01/2006



## COMPONENT MAINTENANCE MANUAL

### CHECK

#### 1. General

- A. This procedure has the data necessary to find defects in the material of the specified parts.
- B. Refer to 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. 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 think there is 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 (570) (Class B)
      - b) Rod (575) (Class C)
    - 2) IPL Figure 2
      - a) Bushing (390, 490, 615, 720, 800, 880) (Class B)
    - 3) IPL Figure 3
      - a) Latch crank (190, 195) (Class B)
      - b) Gate crank (201, 205) (Class B)
      - c) Tube (210) (Class B)
    - 4) IPL Figure 6
      - a) Bushing (85) (Class B)
    - 5) IPL Figure 7
      - a) Coupling sleeve (55) (Class B)
      - b) Hinge link pin (60) (Class A prior to plating and Class B after plating)
      - c) Crank (85) (Class B)
      - d) Torque tube (90) (Class B)
    - 6) IPL Figure 8
      - 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:

# 52-41-05

CHECK

Page 501

Mar 01/2006



## COMPONENT MAINTENANCE MANUAL

- 1) IPL Figure 1
  - a) Spacer (100, 155)
  - b) Retainer (330)
  - c) Rod (720, 725)
  - d) Fitting (840, 845)
  - e) Beam Stub (945, 950)
- 2) IPL Figure 2
  - a) Beam (405A, 410, 515, 630, 735, 825, 830, 895)
  - b) Stop (395, 400, 495, 500, 620, 625, 725, 730, 805, 810, 885, 890)
- 3) IPL Figure 3
  - a) Fitting (70, 75, 80, 85)
  - b) Roller cam crank (170)
- 4) IPL Figure 5
  - a) Gate (70)
- 5) IPL Figure 6
  - a) Gate (90)
- 6) IPL Figure 7
  - a) Hinge arm (30, 35)
- 7) IPL Figure 8
  - 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) Do a load check on the spring (740, IPL Figure 1) as follows:
  - (a) Compress the spring (740) to 0.20 inch length as shown in CHECK, Figure 501 .
  - (b) Make sure that the maximum load on the spring (740) is 0.22 - 0.24 pound.
  - (c) Compress the spring (740) to 0.25 inch length as shown in CHECK, Figure 501 .
  - (d) Make sure that the minimum load on the spring (740) is 0.19 - 0.21 pound.
- (3) Do a load check on the spring (890, IPL Figure 1) as follows:
  - (a) Compress the spring (890) to 0.22 inch length as shown in CHECK, Figure 501 .
  - (b) Make sure that the maximum load on the spring (890) is 0.39 - 0.49 pound.

# 52-41-05

CHECK  
Page 502  
Mar 01/2006



## COMPONENT MAINTENANCE MANUAL

- (c) Compress the spring (890) to 0.44 inch length as shown in CHECK, Figure 501 .
  - (d) Make sure that the minimum load on the spring (890) is 0.06 - 0.14 pound.
- (4) Do a load check on the spring (155, IPL Figure 8) as follows:
- (a) Compress the spring (155) to 2.05 inches length as shown in CHECK, Figure 501 .
  - (b) Make sure that the maximum load on the spring (155) is 5.8 - 7.0 pounds.
  - (c) Compress the spring (155) to 3.34 inches length as shown in CHECK, Figure 501 .
  - (d) Make sure that the minimum load on the spring (155) is 3.0 - 3.8 pounds.

# 52-41-05

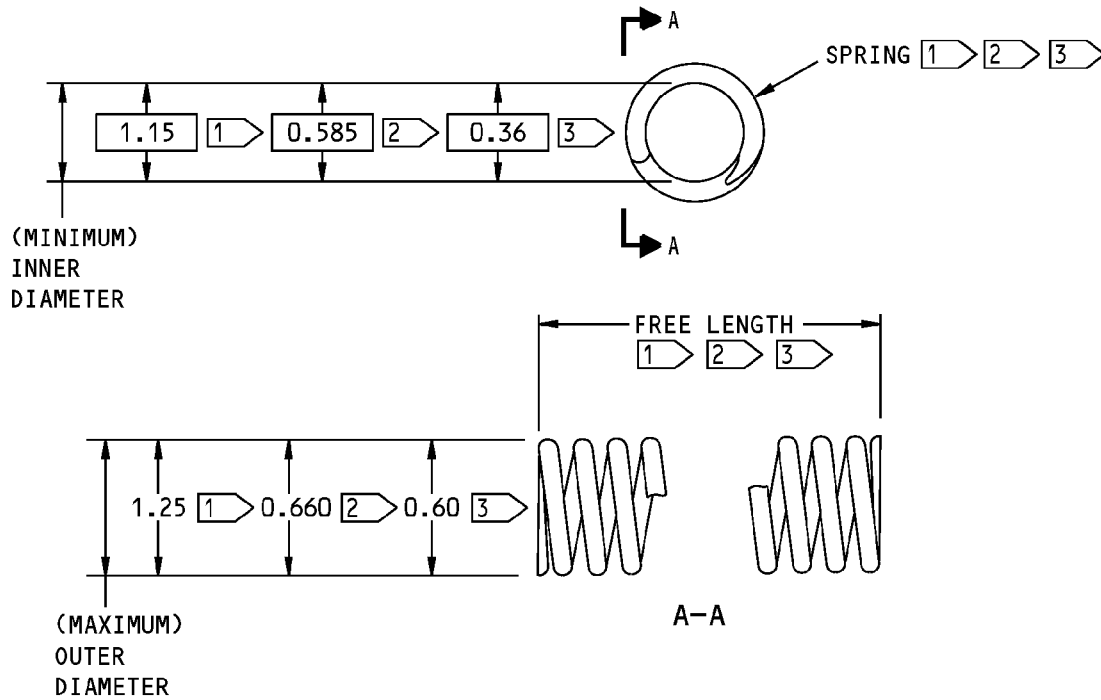
CHECK

Page 503

Mar 01/2006



COMPONENT MAINTENANCE MANUAL



SPRING ITEM NUMBER	FREE LENGTH OF SPRING (INCHES)	TEST LENGTH (INCHES)	PERMITTED LOAD LIMIT (POUNDS)
IPL FIG. 1; 740	0.88	0.20 0.25	0.22-0.24 (MAXIMUM) 0.19-0.21 (MINIMUM)
IPL FIG. 1; 890	0.54	0.22 0.44	0.39-0.49 (MAXIMUM) 0.06-0.14 (MINIMUM)
IPL FIG. 8; 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; 740)

2 FOR 140N2020-1  
(IPL FIG. 1; 890)

3 FOR 63-2848  
(IPL FIG. 8; 155)

ALL DIMENSIONS ARE IN INCHES

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

**52-41-05**

CHECK  
Page 504  
Mar 01/2006



## COMPONENT MAINTENANCE MANUAL

### REPAIR

#### 1. General

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

**Table 601:**

<b>PART NUMBER</b>	<b>NAME</b>	<b>REPAIR</b>
—	REFINISH OF OTHER PARTS	1-1
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
141A6517	TORQUE TUBE ASSEMBLY	10-1
141A6519	TORQUE TUBE	10-2
149A6110	TORQUE TUBE COUPLING SLEEVE	10-3
69-17330	CRANK	10-4
66-14527	HINGE LINK PIN	10-5
65-73978	HINGE ARM ASSEMBLY	10-6, 10-7
141A6526	HINGE SUPPORT ASSEMBLY	11-1
69-70269	FITTING	11-2
141A6527	SUPPORT ASSEMBLY	12-1, 12-2
141A6538	STOP ASSEMBLY	13-1, 13-2
141A6540	(UPPER) END GATE ASSEMBLY	14-1
141A6541	(UPPER) CONTROL ROD CLEVIS ASSEMBLY	14-2, 14-3
141A6543	(UPPER) GATE	14-4
141A6540	(LOWER) END GATE ASSEMBLY	15-1
141A6541	(LOWER) CONTROL ROD CLEVIS ASSEMBLY	15-2, 15-3
141A6542	(LOWER) GATE ASSEMBLY	15-4, 15-5
141A6545	LOWER AND UPPER TUBE ASSEMBLY	16-1
69-37418	ROLLER CAM CRANK	16-2
60-4431	GATE CRANK ASSEMBLY	16-3, 16-4
60-4409	GATE CRANK	16-5

# 52-41-05

REPAIR - GENERAL

Page 601

Mar 01/2006



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	NAME	REPAIR
60-4406	LATCH TORQUE TUBE	16-6
141A6546	LATCH SUPPORT FITTING ASSEMBLY	17-1, 17-2
141A6549	CENTERING GUIDE ASSEMBLY	18-1, 18-2
141A6554	EXTERIOR HANDLE PAN ASSEMBLY	19-1
65-52452	EXTERIOR HANDLE PAN	19-2
60-4412	SEAL PLATE	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.

# 52-41-05

REPAIR - GENERAL

Page 602

Mar 01/2006



## COMPONENT MAINTENANCE MANUAL

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

### EXAMPLES

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

True Position Dimensioning Symbols  
Figure 601

# 52-41-05

REPAIR - GENERAL

Page 603

Mar 01/2006



## COMPONENT MAINTENANCE MANUAL

### 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 8 for the item numbers.

#### 2. Refinish of Other Parts

##### A. Consumable Materials

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

Reference	Description	Specification
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I
C00260	Coating - Chemical And Solvent Resistant Finish, Epoxy Resin Enamel	BMS10-11, Type II
D00113	Lubricant - Liquid Dispersed Solid Film Lubricant	BMS3-8, BAC 5811, TYPE VIII

##### B. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS
SOPM 20-60-03	LUBRICANTS

##### C. Procedure

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

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

**Table 601:** Refinish Details

IPL FIG. & ITEM	MATERIAL	FINISH
IPL Fig. 1		
Collar (70)	Al alloy	Chemical treat or chromic acid anodize and apply primer, C00259 (F-18.05).
Collar (70) (opt)	4130 or 4340 Steel 125-145 ksi	Cadmium plate (F-1.302).
Bracket (75,125, 180,220)	Al alloy	Chemical treat (F-17.07). Apply primer, C00259 (F-20.02).

# 52-41-05

REPAIR 1-1

Page 601

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

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

IPL FIG. & ITEM	MATERIAL	FINISH
Spacer (100,155)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02). Apply enamel coating, C00260 (F-21.03) but do not put primer and enamel coating in the center hole.
Backplate (130,185)	Al alloy	Chemical treat (F-17.07). Apply primer, C00259 (F-20.02).
Stop (210,215)	Nylon	No finish (F-25.01).
Plate-Cover (265, 270,275)	Al alloy	Chemical treat (F-17.07). Apply primer, C00259 (F-20.03).
Retainer (330)	Al alloy	Chemical treat (F-17.07). Apply primer, C00259 (F-20.03).
Filler (450)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.03).
Skin (455,460)	Al alloy	Chemical treat (F-17.07). Apply primer, C00259 (F-20.03).
Window Doubler (495)	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.
Hinge Half (645, 650,655,660)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.03) but do not apply primer to the hinge pin or the spring pin holes.
Compression Spring (740)	Spring Steel Music Wire	Cadmium-titanium plate (F-1.20).
Support (865,870)	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 hole for the bushing.
Spring (890)	Stainless Type 302 Wire	Passivate (F-17.25).
Beam-Stub (945,950)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.03).
IPL Fig. 2		
Plate (85)	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 the serrations.
Channel (105)	Al alloy	Chemical treat (F-17.07). Apply primer, C00259 (F-20.03).
Seal Retainer (165,170,175,180, 185,190)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.03).
Bushing (390,490, 615,720,800,880)	15-5 PH CRES 150-170 ksi	Cadmium plate (F-15.06). Cadmium plate on the inner diameter is optional.

# 52-41-05

REPAIR 1-1  
Page 602  
Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

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

IPL FIG. & ITEM	MATERIAL	FINISH
Stop (395,400,495, 500,620,625,725, 730,805,810,885, 890)	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 hole for the bushing.
Beam (405A,410, 515,630,735,825, 830,895)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.03).
Splice (545,660)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.03).
Filler (555,670)	Al alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.03).
IPL Fig. 3		
Spacer (5)	301 CRES	Passivate (F-17.25).
Shim (90A)		No finish (F-25.01).
Crank-latch (190, 195)	15-5 PH CRES 150-170 ksi	Passivate (F-17.09).
IPL Fig. 4		
Clip (20)	301 CRES	Cadmium plate (F-15.06). Apply primer, C00259 (F-20.02). Apply enamel coating, C00260 (F-21.28-702).
Retainer (55)	Al alloy	Chemical treat (F-17.07). Apply primer, C00259 (F-20.03). Apply enamel coating, C00260 (F-19.39-702) to the surface identified by flagnote 1 in REPAIR 1-1, Figure 602 (over spray is permitted).
IPL Fig. 5		
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. 6		
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 (4130,4140 Steel Opt) 125-145 ksi (4330M Steel, 150-170 ksi (Opt))	Cadmium plate (F-15.06).
IPL Fig. 7		
Special Nut (65)	Al alloy	Chromic acid anodize (F-17.04).
IPL Fig. 8		
Handle (20)	Al alloy	Sulfuric acid anodize (F-14.2998) exterior surfaces only.
Shim (25)	Al alloy	Chemical treat or anodize and apply primer, C00259 (F-2.115).

# 52-41-05

REPAIR 1-1  
Page 603  
Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

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

IPL FIG. & ITEM	MATERIAL	FINISH
Sleeve (30)	Al alloy	Apply lubricant, D00113 (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).
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 (395)	Al-Ni-Bronze AMS 4640	Cadmium plate (F-15.02). Cadmium plate in the bore is optional.

# 52-41-05

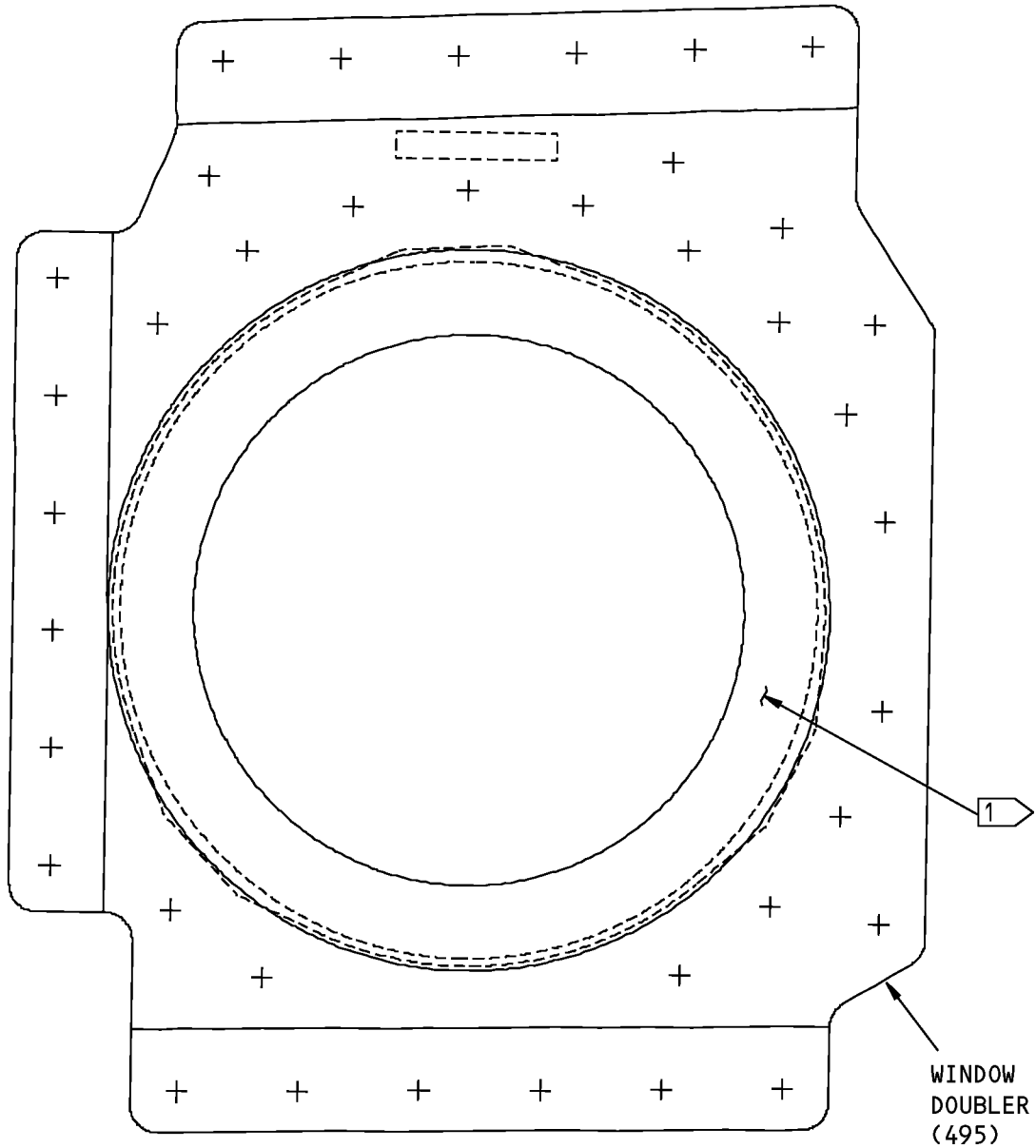
REPAIR 1-1

Page 604

Nov 01/2008



COMPONENT MAINTENANCE MANUAL



REFINISH

**1** NO PRIMER IN THIS AREA. NO  
OVERSPRAY IS PERMITTED

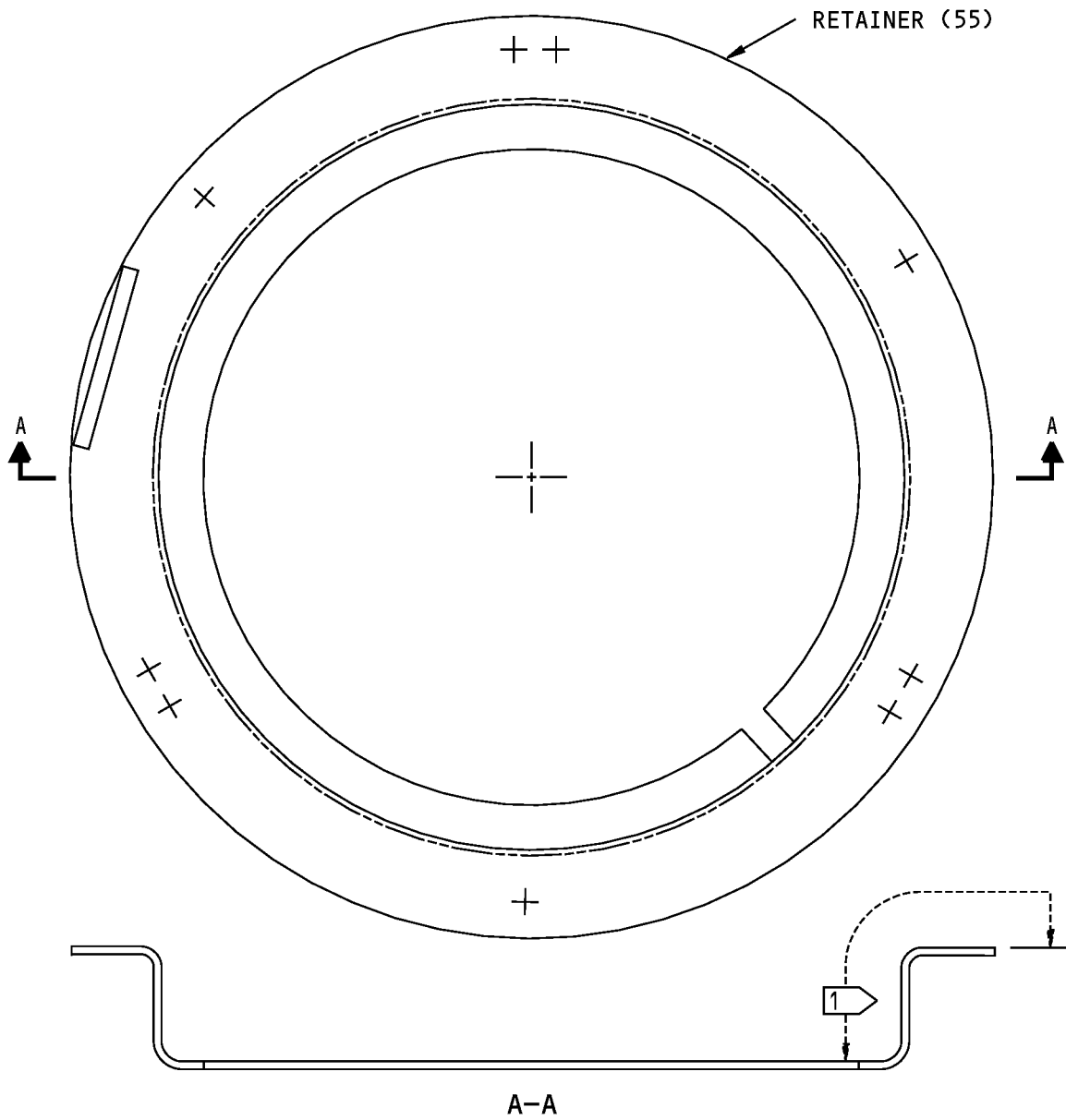
ITEM NUMBERS REFER TO IPL FIG. 1

149A6112-3 Window Doubler  
Figure 601

**52-41-05**

REPAIR 1-1  
Page 605  
Mar 01/2006

COMPONENT MAINTENANCE MANUAL



REFINISH

**1** APPLY ENAMEL TO THIS AREA.  
OVERSPRAY IS PERMITTED

ITEM NUMBERS REFER TO IPL FIG. 4

69-1983-7, 141A6572-1 Retainer Repair  
Figure 602

**52-41-05**

REPAIR 1-1  
Page 606  
Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

### 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 the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 shown in the repair.
- D. Refer to IPL Figure 8 for the item numbers.
- E. General repair details:
  - (1) Material: Aluminum Alloy

#### 2. Nutplate (285) Replacement

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

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

- (1) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.35).
- (2) Apply primer, C00259 (F-20.03) to all surfaces but not on the splined surface shown by flagnote 1.

# 52-41-05

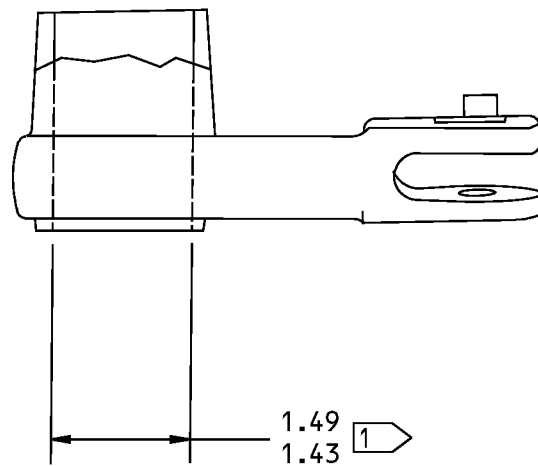
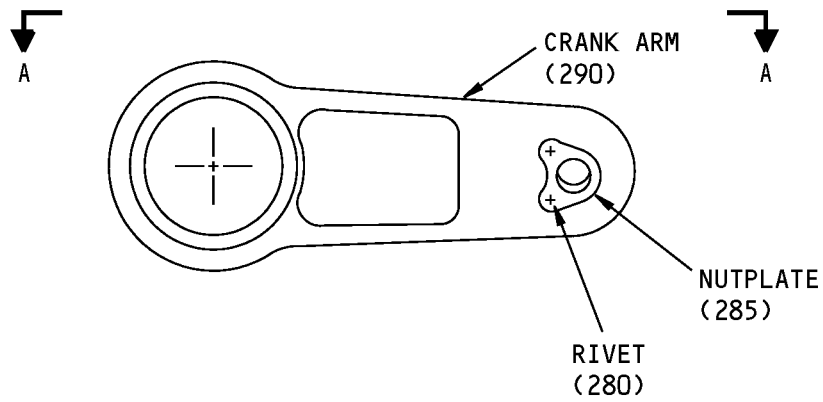
REPAIR 2-1

Page 601

Mar 01/2006



COMPONENT MAINTENANCE MANUAL



A-A

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. 8

ALL DIMENSIONS ARE IN INCHES

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

**52-41-05**

REPAIR 2-1

Page 602

Mar 01/2006



## COMPONENT MAINTENANCE MANUAL

### HOUSING ASSEMBLY - REPAIR 3-1

65-2306-9

#### 1. General

- A. This procedure has the data necessary to repair the housing assembly (110).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the standard true position dimensioning symbols shown in the repair.
- D. Refer to IPL Figure 3 for the item numbers.

#### 2. Fitting Replacement

- A. Procedure
  - (1) Remove the fitting (115) from the housing (125)
  - (2) Install the replacement fitting (115) in the housing (125) as shown in REPAIR 3-1, Figure 601.

#### 3. Bearing Replacement

##### A. References

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

##### B. Procedure

- (1) Remove the bearing (120) from the housing (125).
- (2) Install the replacement bearing (120) into the housing (125) as specified in SOPM 20-50-03 and shown in (REPAIR 3-1, Figure 601).

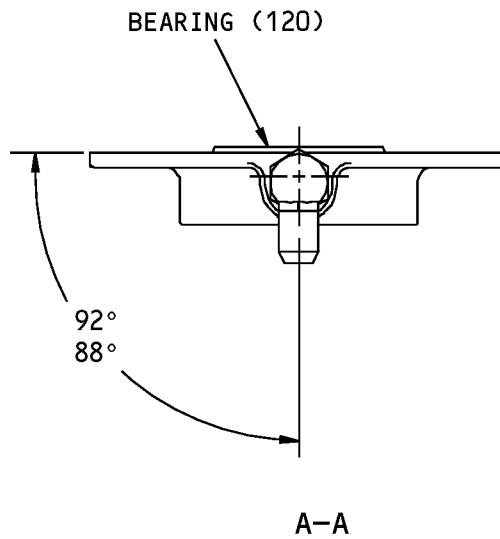
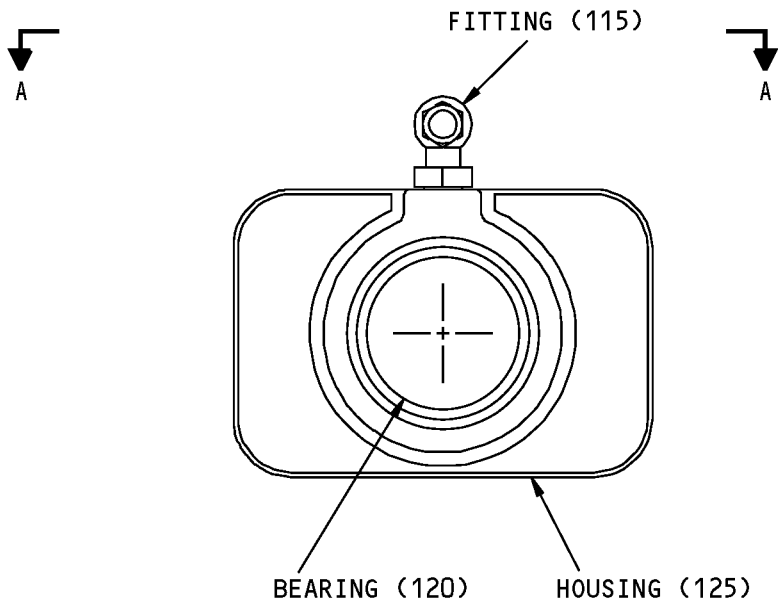
# 52-41-05

REPAIR 3-1

Page 601

Mar 01/2006

COMPONENT MAINTENANCE MANUAL



ITEM NUMBERS REFER TO IPL FIG. 3

65-2306-9 Housing Assembly Repair  
Figure 601

**52-41-05**

REPAIR 3-1  
Page 602  
Mar 01/2006



## COMPONENT MAINTENANCE MANUAL

### HOUSING - REPAIR 3-2

65-2306-10

#### 1. General

- A. This procedure has the data necessary to repair the housing (125).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the standard true position dimensioning symbols shown in the repair.
- D. Refer to IPL Figure 3 for the item numbers.
- 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

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

- (1) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.35).
- (2) Apply primer, C00259 (F-20.03) to all surfaces, but do not put primer, C00259 in the holes for the bearing or the fitting. See (REPAIR 3-2, Figure 601).

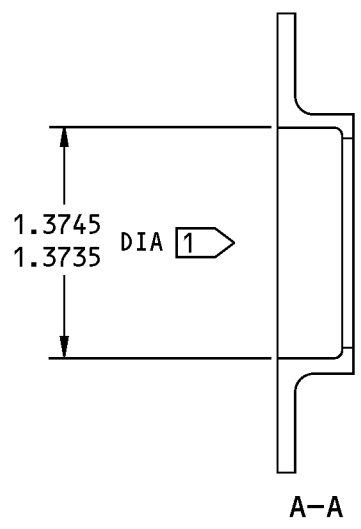
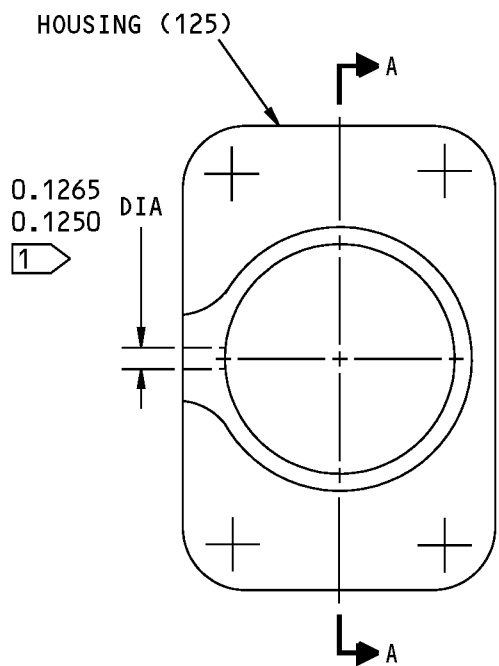
# 52-41-05

REPAIR 3-2

Page 601

Mar 01/2006

COMPONENT MAINTENANCE MANUAL



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. 3

ALL DIMENSIONS ARE IN INCHES

65-2306-10 Housing Repair  
Figure 601

**52-41-05**

REPAIR 3-2  
Page 602  
Mar 01/2006





## COMPONENT MAINTENANCE MANUAL

### CONTROL ROD ASSEMBLY - REPAIR 4-1

65-28925-83, -84, -98, -99

#### 1. General

- A. This procedure has the data necessary to repair the control rod assembly (690, 695).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the standard true position dimensioning symbols shown in the repair.
- D. Refer to IPL Figure 1 for the item numbers.

#### 2. Bearing (710, 715) 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. References

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

- C. Procedure

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

- (1) Remove the bearings (710, 715) from the rods (720, 725).
- (2) Remove the nuts (705) from the bearings (710, 715).
- (3) Apply compound, B50080 (F-12.14) to the mating threads of the bearings (710, 715) and rods (720, 725) as identified by flagnote 1.
- (4) Install the nuts (705) on the new bearings (710, 715).
- (5) Install the new bearings (710, 715) into the rods (720, 725) to get the dimensions given in REPAIR 4-1, Figure 601.
- (6) Tighten the nut (705) identified by flagnote 2 to 60 pound-inches.
- (7) Install the rivet (700).

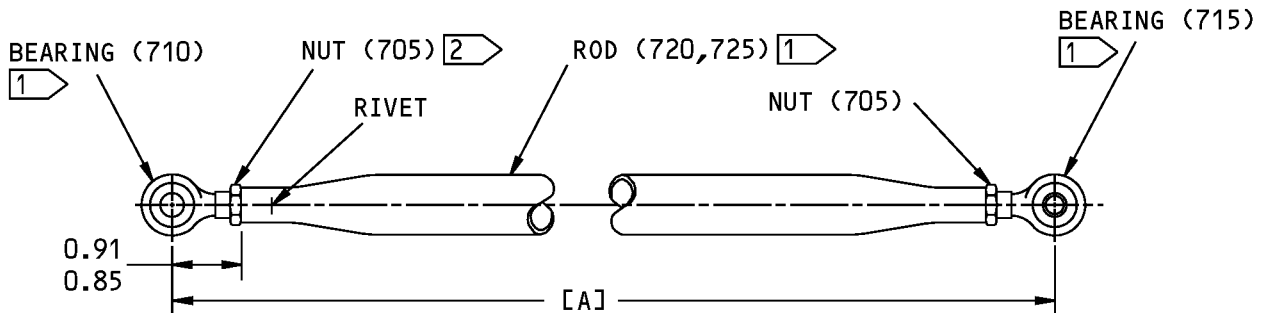
# 52-41-05

REPAIR 4-1

Page 601

Nov 01/2007

## COMPONENT MAINTENANCE MANUAL



REF LETTER	IPL FIG. 1 ITEM NO.	DIMENSION	
		MIN	MAX
[A]	690	22.24	22.30
	695	23.10	23.16

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

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

65-28925-83,-84,-98,-99 Control Rod Assembly - Repair  
Figure 601

# 52-41-05

REPAIR 4-1

Page 602

Mar 01/2006



## COMPONENT MAINTENANCE MANUAL

### CONTROL ROD - REPAIR 4-2

65-28925-43, -44, -102, -103

#### 1. General

- A. This procedure has the data necessary to refinish the control rod (720, 725).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the standard true position dimensioning symbols shown in the repair.
- D. Refer to IPL Figure 1 for the item numbers.
- E. General repair details:
  - (1) Material: Aluminum Alloy

#### 2. Control Rod (720, 725) Refinish

- A. Consumable Materials

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

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

- B. References

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

- C. Procedure:

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

- (1) Finish the 65-28925-43 and -44 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 65-28925-102 and -103 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.

# 52-41-05

REPAIR 4-2

Page 601

Mar 01/2006



## COMPONENT MAINTENANCE MANUAL

### 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 the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the standard true position dimensioning symbols shown in the repair.
- D. Refer to IPL Figure 8 for the item numbers.

#### 2. Insert (80) Replacement

##### A. References

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

##### B. Procedure

- (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.

# 52-41-05

REPAIR 5-1

Page 601

Mar 01/2006



## COMPONENT MAINTENANCE MANUAL

### 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 REPAIR-GENERAL, Figure 601 for the standard true position dimensioning symbols shown in the repair.
- D. Refer to IPL Figure 8 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

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

- (1) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.35) 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 in (REPAIR 5-2, Figure 601).

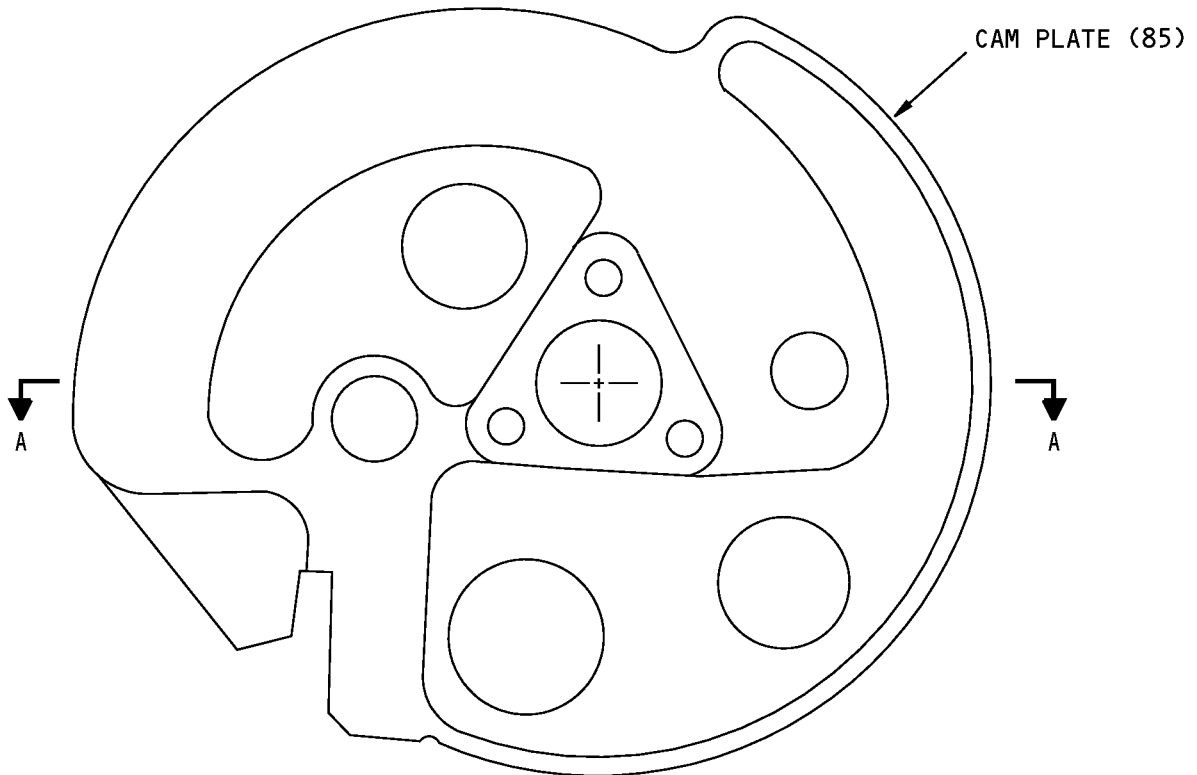
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REPAIR 5-2

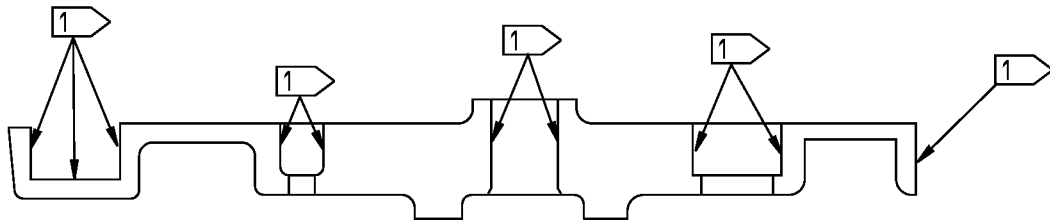
Page 601

Mar 01/2006

COMPONENT MAINTENANCE MANUAL



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. 8

ALL DIMENSIONS ARE IN INCHES

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

**52-41-05**

REPAIR 5-2

Page 602

Mar 01/2006



## COMPONENT MAINTENANCE MANUAL

### CONTROL ROD ASSEMBLY - REPAIR 6-1

69-18187-21, -27

#### 1. General

- A. This procedure has the data necessary to repair the control rod assembly (540, 545).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the standard true position dimensioning symbols shown in the repair.
- D. Refer to IPL Figure 1 for the item numbers.

#### 2. Rod End Bearing (555, 565) Replacement

- A. Procedure
  - (1) Remove the rivet (560) from the rod (575).
  - (2) Remove the rod end bearing (565) from the rod (575).
  - (3) Remove the rod end bearings (555) from the rods (570, 575)
  - (4) Remove the nuts (550) from the rod end bearings (555).
  - (5) Install the nuts (550) onto the new rod end bearings (555).
  - (6) Install the new rod end bearings (555) onto the rods (570, 575).
  - (7) Install the new rod end bearing (565) onto the rod (575) to get the dimension shown in REPAIR 6-1, Figure 601.
  - (8) Install the rivet (560) onto the rod (575) and through the rod end bearing (565).
  - (9) Adjust the rod end bearings (555) to the dimension given in REPAIR 6-1, Figure 601. Tighten the nut(s) (550).

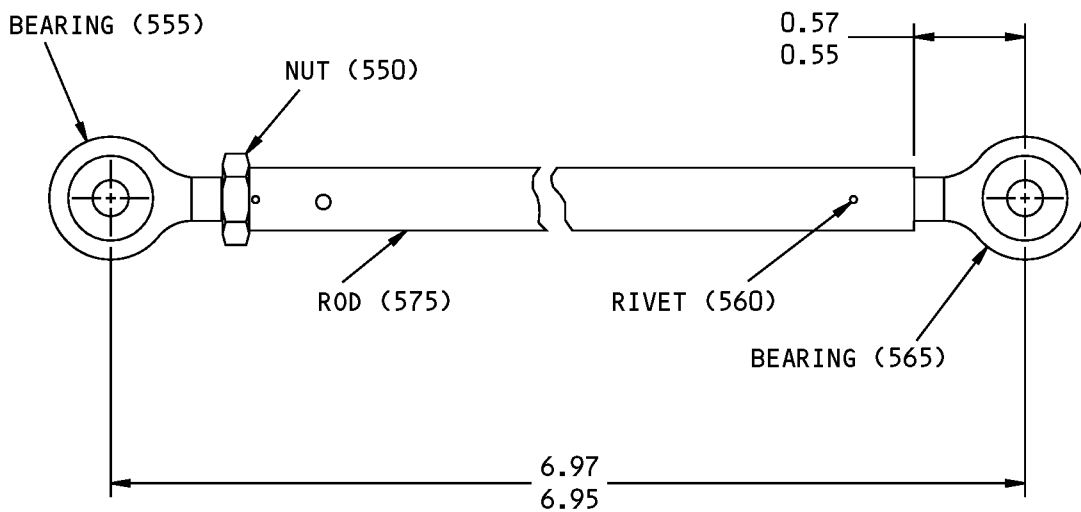
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REPAIR 6-1

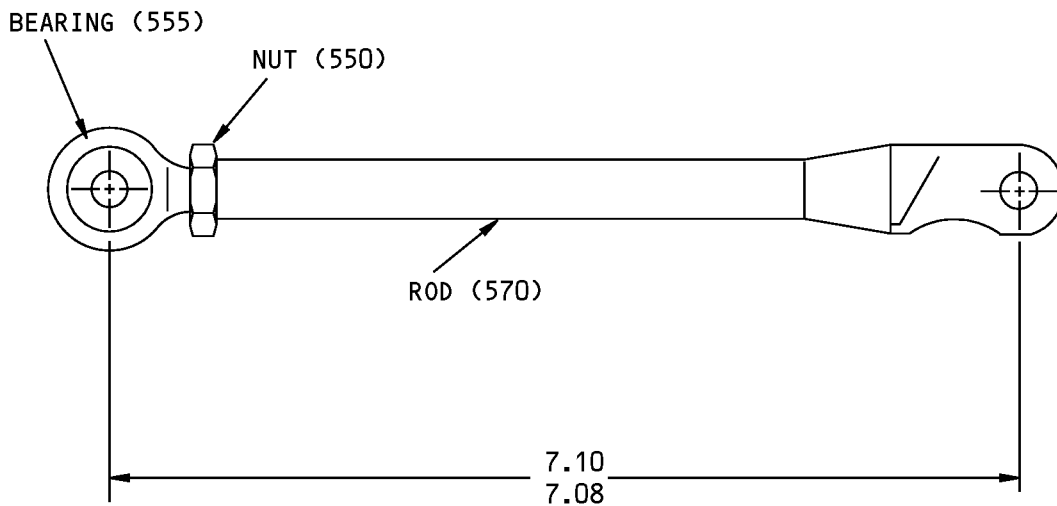
Page 601

Mar 01/2006

COMPONENT MAINTENANCE MANUAL



69-18187-21



69-18187-27

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

69-18187-21,-27 Control Rod Assembly Repair  
 Figure 601

**52-41-05**

REPAIR 6-1  
 Page 602  
 Mar 01/2006





## COMPONENT MAINTENANCE MANUAL

### ROD - REPAIR 6-2

66-14618-5, -13

#### 1. General

- A. This procedure has the data necessary to refinish the control rod (570, 575).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 1 for the item numbers.
- D. General repair details:
  - (1) Material: (570) - 15-5 PH CRES
    - (a) 150-170 KSI
    - (b) (575) - 4130 Steel (15-5 PH CRES (optional))
    - (c) 150-170 KSI

#### 2. Rod (570, 575) 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 (575)

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

- (1) Cadmium plate (F-16.06) the 4130 steel rods.
- (2) Passivate (F-17.25) the CRES rods.
- (3) Apply primer, C00259 (F-20.02) to the alloy steel rods; optional for the CRES rods.

# 52-41-05

REPAIR 6-2

Page 601

Mar 01/2006



## COMPONENT MAINTENANCE MANUAL

### 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 the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the standard true position dimensioning symbols shown in the repair.
- D. Refer to IPL Figure 8 for the item numbers.

#### 2. Rod End Bearing (195) Replacement

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

# 52-41-05

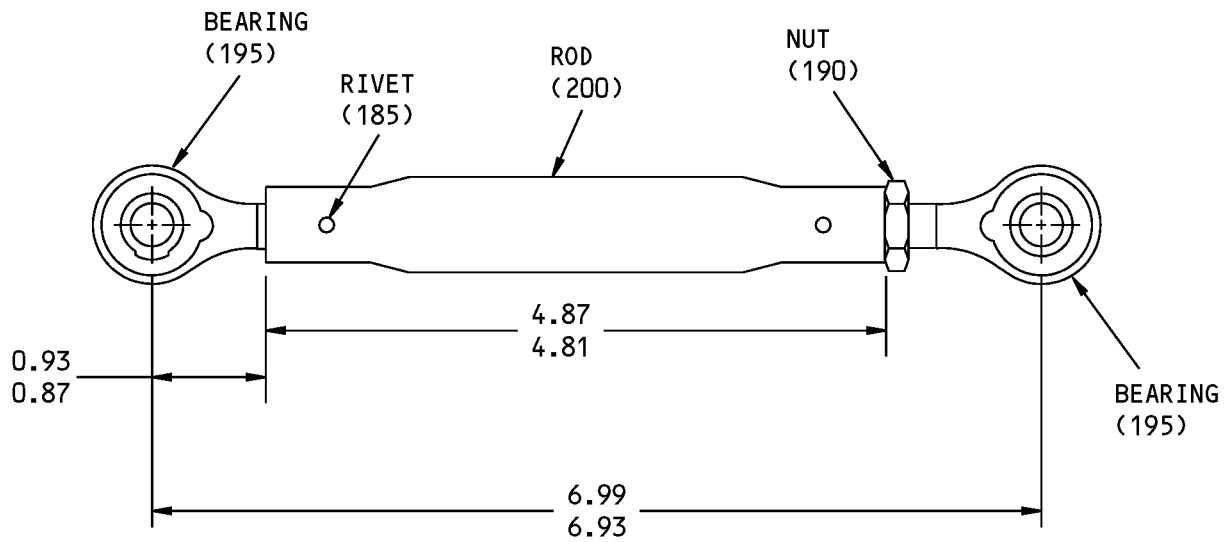
REPAIR 7-1

Page 601

Mar 01/2006



## COMPONENT MAINTENANCE MANUAL



ITEM NUMBERS REFER TO IPL FIG. 8

ALL DIMENSIONS ARE IN INCHES

69-39176-1 Rod Assembly Repair  
Figure 601

# 52-41-05

REPAIR 7-1

Page 602

Mar 01/2006



## COMPONENT MAINTENANCE MANUAL

### 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 the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 8 for the item numbers.
- D. General repair details:
  - (1) Material: 8630 or 4130 Steel Tube
    - (a) 150-170 ksi

#### 2. Rod Refinish

- A. Consumable Materials

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

Reference	Description	Specification
C00308	Compound - Corrosion Preventive, Petrolatum Hot Application	MIL-C-11796

- B. References

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

- C. Procedure

**NOTE:** For 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 corrosion preventive compound, C00308 (F-1.73) onto the internal surfaces.

# 52-41-05

REPAIR 7-2

Page 601

Nov 01/2007



## COMPONENT MAINTENANCE MANUAL

### 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 the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the standard true position dimensioning symbols shown in the repair.
- D. Refer to IPL Figure 8 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 20-50-02	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 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 5 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.

# 52-41-05

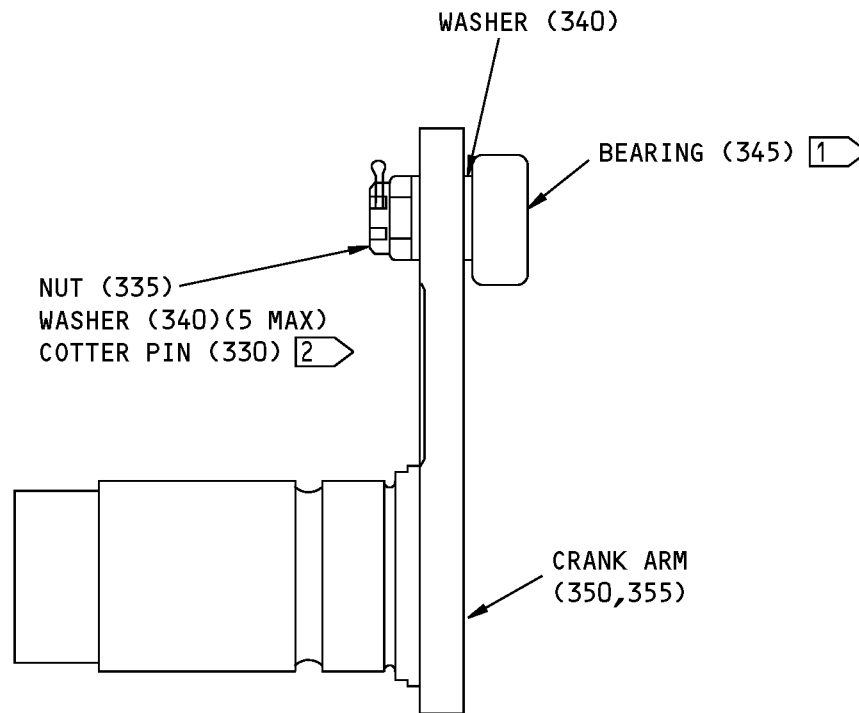
REPAIR 8-1

Page 601

Jul 01/2008



## COMPONENT MAINTENANCE MANUAL



1 INSTALL THE BEARING WITH WET  
BMS 5-95 SEALANT

ITEM NUMBERS REFER TO IPL FIG. 8

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

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

# 52-41-05

REPAIR 8-1

Page 602

Mar 01/2006



## COMPONENT MAINTENANCE MANUAL

### 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 the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 8 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 (REPAIR 8-2, Figure 601)

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

- (1) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.35).
- (2) Apply primer, C00259 (F-20.03) but not on the splined surfaces and surfaces identified by flagnote 1.

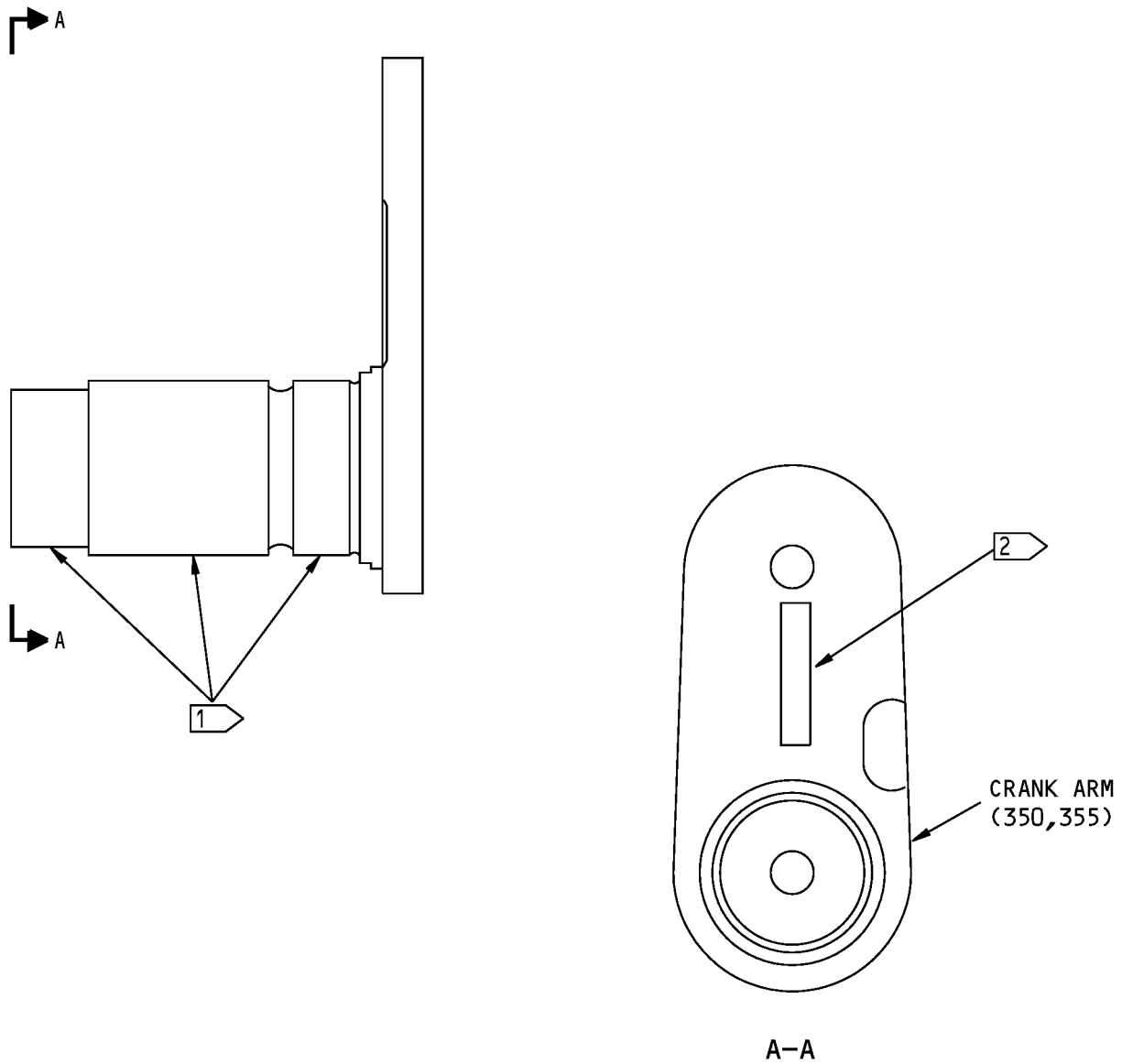
# 52-41-05

REPAIR 8-2

Page 601

Mar 01/2006

COMPONENT MAINTENANCE MANUAL



- 1 DO NOT PUT PRIMER ON THIS SURFACE
- 2 THE PART NUMBER IS FOUND HERE

ITEM NUMBERS REFER TO IPL FIG. 8

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

**52-41-05**

REPAIR 8-2  
Page 602  
Mar 01/2006





## COMPONENT MAINTENANCE MANUAL

### DRAIN VALVE ASSEMBLY - REPAIR 9-1

140N2022-1

#### 1. General

- A. This procedure has the data necessary to replace the drain valve assembly (875).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for 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 (930), washers (935), and the drain valve retainer (940) from the stub beam (945, 950).
  - (2) Remove the drain valve assembly (875) from the drain valve retainer (940).
  - (3) Install the new drain valve assembly (875) into the drain valve retainer (940).
    - (a) Tighten the valve assembly housing (895) to 10-15 pound-inches.
  - (4) Attach the drain valve retainer (940) to the stub beam (945, 950) with washers (935) and rivets (930).

# 52-41-05

REPAIR 9-1

Page 601

Mar 01/2006



## COMPONENT MAINTENANCE MANUAL

### TORQUE TUBE ASSEMBLY - REPAIR 10-1

141A6517-1, -2

#### 1. General

- A. This procedure has the data necessary to repair the torque tube assembly (760, IPL Figure 1).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the standard true position dimensioning symbols shown in the repair.
- D. Refer to IPL Figure 7 for the item numbers.

#### 2. Torque Tube Assembly Repair

##### A. References

Reference	Title
SOPM 20-10-02	MACHINING OF ALLOY STEEL

##### B. Procedure

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

- (1) Tighten the bolts (5) to 25 - 30 pound-inches before drilling a hole.
- (2) Drill and deburr the holes for the sleeves (55) and the crank (85) as specified in SOPM 20-10-02 and as shown in REPAIR 10-1, Figure 601.
- (3) Install and tighten the bolts (40) with your fingers with the heads as shown in REPAIR 10-1, Figure 601.
- (4) Install and tighten the bolts (70) with your fingers with the heads as shown in REPAIR 10-1, Figure 601.

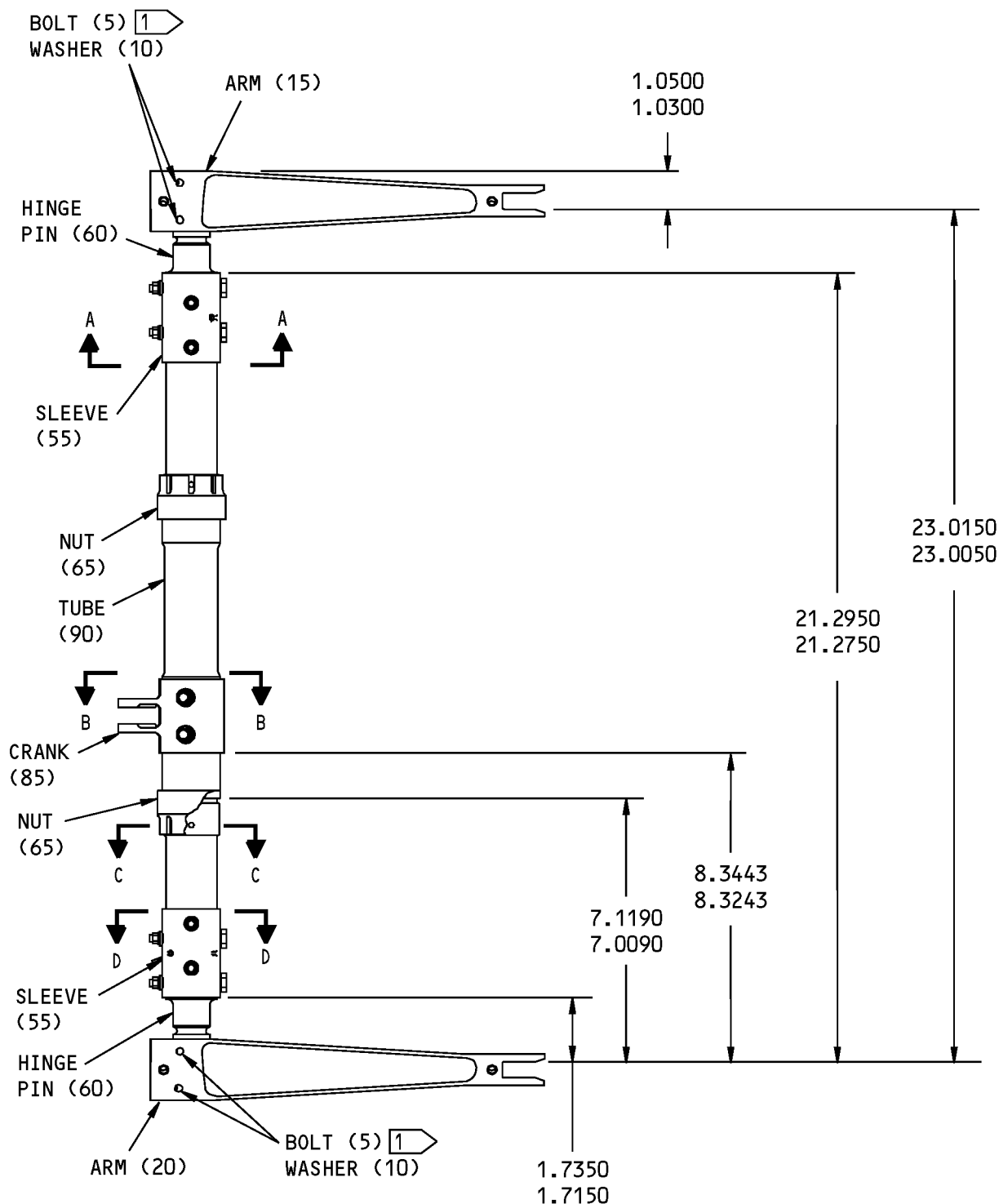
# 52-41-05

REPAIR 10-1

Page 601

Mar 01/2006

COMPONENT MAINTENANCE MANUAL

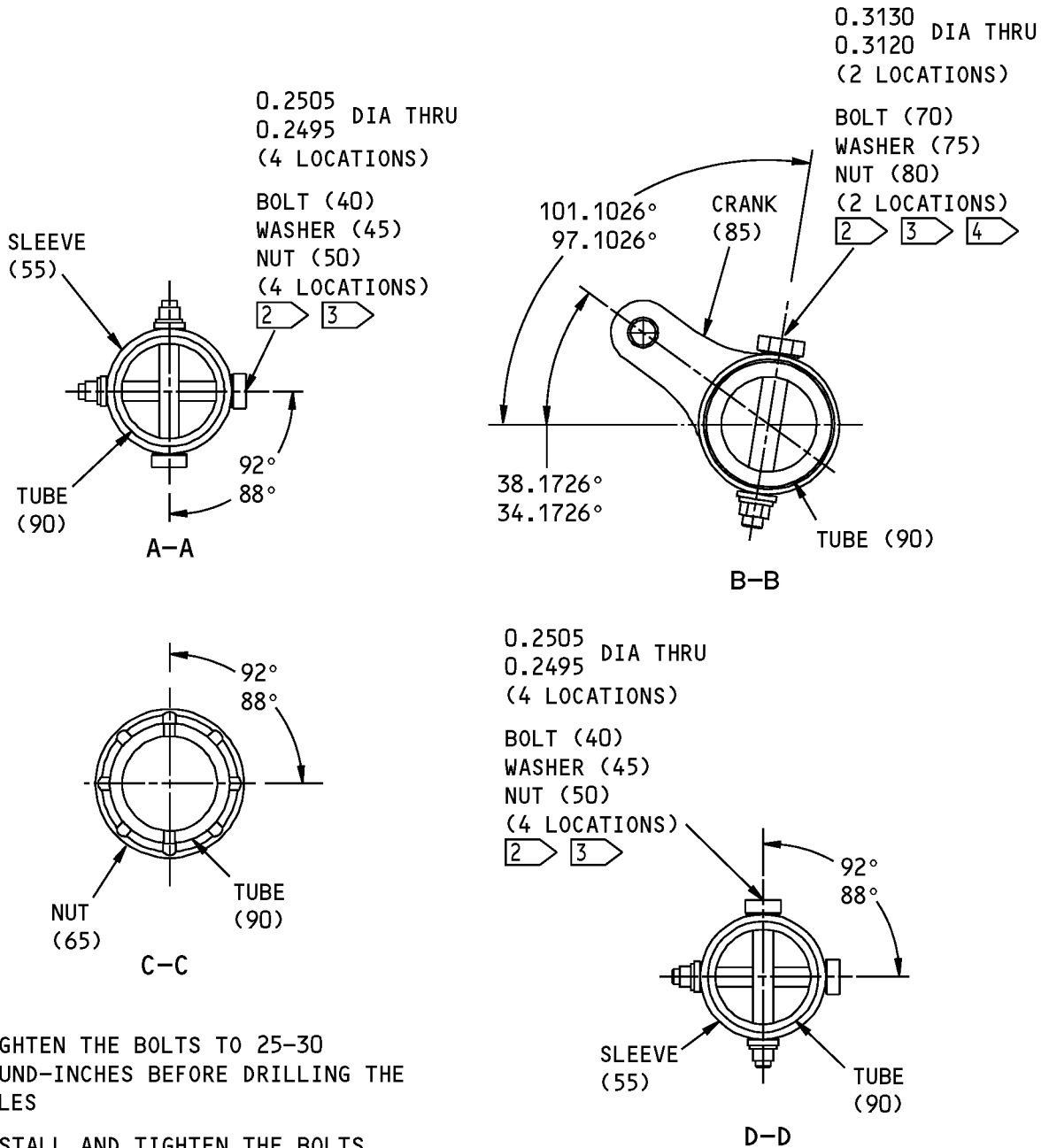


141A6517-1,-2 Torque Tube Assembly  
Figure 601 (Sheet 1 of 2)

**52-41-05**

REPAIR 10-1  
Page 602  
Mar 01/2006

COMPONENT MAINTENANCE MANUAL



- 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 BOLTS WITH A DIFFERENT GRIP LENGTH ARE NOT PERMITTED

ITEM NUMBERS REFER TO IPL FIG. 7  
ALL DIMENSIONS ARE IN INCHES

141A6517-1,-2 Torque Tube Assembly  
Figure 601 (Sheet 2 of 2)

**52-41-05**



## COMPONENT MAINTENANCE MANUAL

### TORQUE TUBE- REPAIR 10-2

141A6519-1

#### 1. General

- A. This procedure has the data necessary to refinish the torque tube (90).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the standard true position dimensioning symbols shown in the repair.
- D. Refer to IPL Figure 7 for the item numbers.
- E. General repair details:
  - (1) Material: 15-5 PH CRES
    - (a) 180-200 ksi

#### 2. Torque Tube Refinish

- A. References

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

- B. Procedure (REPAIR 10-2, Figure 601)

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

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

# 52-41-05

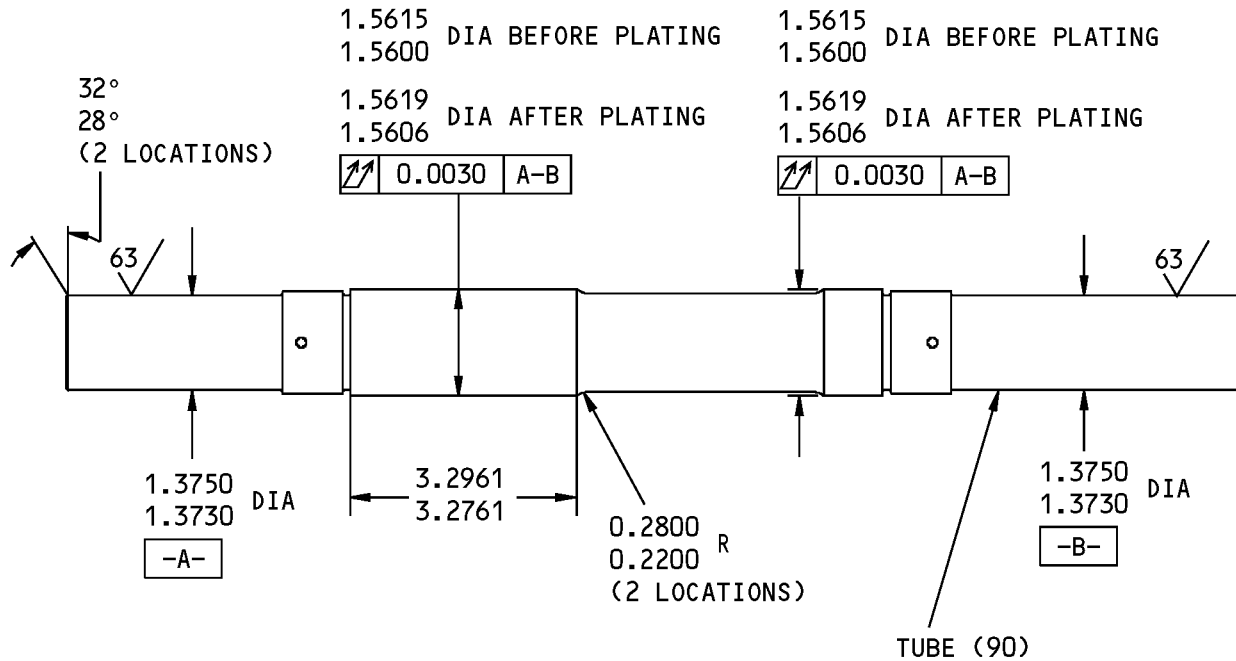
REPAIR 10-2

Page 601

Mar 01/2006



COMPONENT MAINTENANCE MANUAL



ITEM NUMBERS REFER TO IPL FIG. 7  
 ALL DIMENSIONS ARE IN INCHES

141A6519-1 Torque Tube Repair  
 Figure 601

**52-41-05**

REPAIR 10-2  
 Page 602  
 Mar 01/2006



## COMPONENT MAINTENANCE MANUAL

### TORQUE TUBE COUPLING SLEEVE- REPAIR 10-3

149A6110-1

#### 1. General

- A. This procedure has the data necessary to refinish the torque tube coupling sleeve (55).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the standard true position dimensioning symbols shown in the repair.
- D. Refer to IPL Figure 7 for the item numbers.
- E. General repair details:
  - (1) Material: 15-5 PH CRES
    - (a) 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 decoding table for Boeing finish codes, refer to SOPM 20-41-01.

- (1) Passivate (F-17.25).

# 52-41-05

REPAIR 10-3

Page 601

Mar 01/2006



## COMPONENT MAINTENANCE MANUAL

### CRANK - REPAIR 10-4

69-17330-3, -5

#### 1. General

- A. This procedure has the data necessary to refinish the crank (85).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 7 for item numbers.
- D. General repair details:
  - (1) Material: 15-5 PH CRES
    - (a) 150-170 ksi

#### 2. Crank Refinish

##### A. References

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

##### B. Procedure

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

- (1) Passivate (F-17.25).

# 52-41-05

REPAIR 10-4

Page 601

Mar 01/2006





## COMPONENT MAINTENANCE MANUAL

### HINGE LINK PIN - REPAIR 10-5

66-14527-8

#### 1. General

- A. This procedure has the data necessary to refinish the hinge link pin (60).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the standard true position dimensioning symbols shown in the repair.
- D. Refer to IPL Figure 7 for the item numbers.
- E. General repair details:
  - (1) Material:15-5 PH CRES
    - (a) 180-200 Ksi

#### 2. Crank Refinish

##### A. References

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

##### B. Procedure (REPAIR 10-5, Figure 601)

**NOTE:** For 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.

# 52-41-05

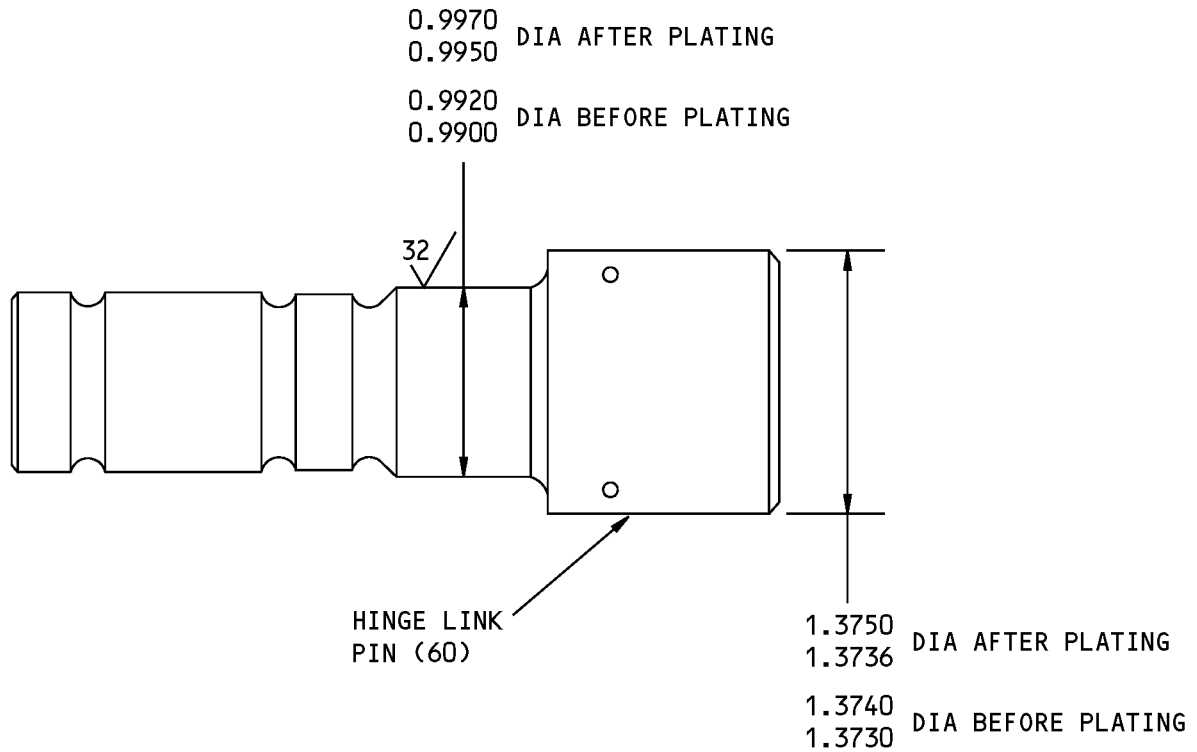
REPAIR 10-5

Page 601

Mar 01/2006



COMPONENT MAINTENANCE MANUAL



250/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 7

ALL DIMENSIONS ARE AFTER PLATING UNLESS SHOWN DIFFERENTLY

ALL DIMENSIONS ARE IN INCHES

66-14527-8 Hinge Link Pin Refinish  
Figure 601

**52-41-05**

REPAIR 10-5

Page 602

Mar 01/2006



## COMPONENT MAINTENANCE MANUAL

### HINGE ARM ASSEMBLY - REPAIR 10-6

65-73978-2, -7

#### 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 7 for the item numbers.

#### 2. Insert (25) Replacement

- A. Procedure
  - (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.

# 52-41-05

REPAIR 10-6

Page 601

Mar 01/2006



## COMPONENT MAINTENANCE MANUAL

### HINGE ARM - REPAIR 10-7

65-73978-4, -9, -11, -14

#### 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 the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the standard true position dimensioning symbols shown in the repair.
- D. Refer to IPL Figure 7 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
C00260	Coating - Chemical And Solvent Resistant Finish, Epoxy Resin Enamel	BMS10-11, Type II
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 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, C00259 in the splined hole.
  - (b) Apply enamel coating, C50069 (F-21.25).
- (2) Hinge arm (35) refinish:
  - (a) Chemical treat or chromic acid anodize and apply primer, C00259 (F-2.30). Do not put primer, C00259 in the splined hole.
  - (b) Apply enamel coating, C00260 (F-21.03).

# 52-41-05

REPAIR 10-7  
Page 601  
Mar 01/2006



## COMPONENT MAINTENANCE MANUAL

### HINGE SUPPORT ASSEMBLY - REPAIR 11-1

141A6526-1, -2

#### 1. General

- A. This procedure has the data necessary to repair the hinge support assembly (805, 810).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the standard true position dimensioning symbols shown in the repair.
- D. Refer to IPL Figure 1 for the item numbers.

#### 2. Fitting (840, 845) Replacement

- A. Consumable Materials

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

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95
A01076	Adhesive - Synthetic Rubber	BAC5010, Type 93 (BMS5-95, Class B)

- B. References

Reference	Title
SOPM 20-50-12	APPLICATION OF ADHESIVES
SOPM 20-50-19	GENERAL SEALING
SOPM 20-60-04	MISCELLANEOUS MATERIALS

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

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

- (1) Remove the bolts (820), washers (825, 830), nuts (835), and the fittings (840, 845) from the support assemblies (850, 855).
- (2) Remove the washers (815) from the fitting (840).
- (3) Machine the holes in the new fitting (840, 845) as specified in REPAIR 11-1, Figure 601.
- (4) Chemical treat (F-17.10) the machined holes.
- (5) Apply a corrosion protection fay surface seal with sealant, A00247 between the mating surfaces of the fitting (840, 845) and the support assembly (850, 855) (see flagnote 1) as specified in SOPM 20-50-19.
- (6) Attach the fitting (840, 845) to the support assembly (850, 855) with the bolts (820), washers (825, 830) and nuts (835).
  - (a) Install the fasteners with wet sealant, A00247 as specified in SOPM 20-50-19, method 2.
- (7) For the 141A6526-1 hinge support assembly only:

# 52-41-05

REPAIR 11-1  
Page 601  
Jul 01/2008



## COMPONENT MAINTENANCE MANUAL

- (a) Bond the washers (815) to the fitting (840) as necessary to meet the 0.3760-0.3910 gap tolerance shown in REPAIR 11-1, Figure 601.
  - 1) Bond the washers with sealant, A00247 as specified in SOPM 20-50-12, adhesive, A01076.
  - 2) Make sure that the holes of the fitting are free of sealant, A00247 and that the washers do not cause blockage of the holes.

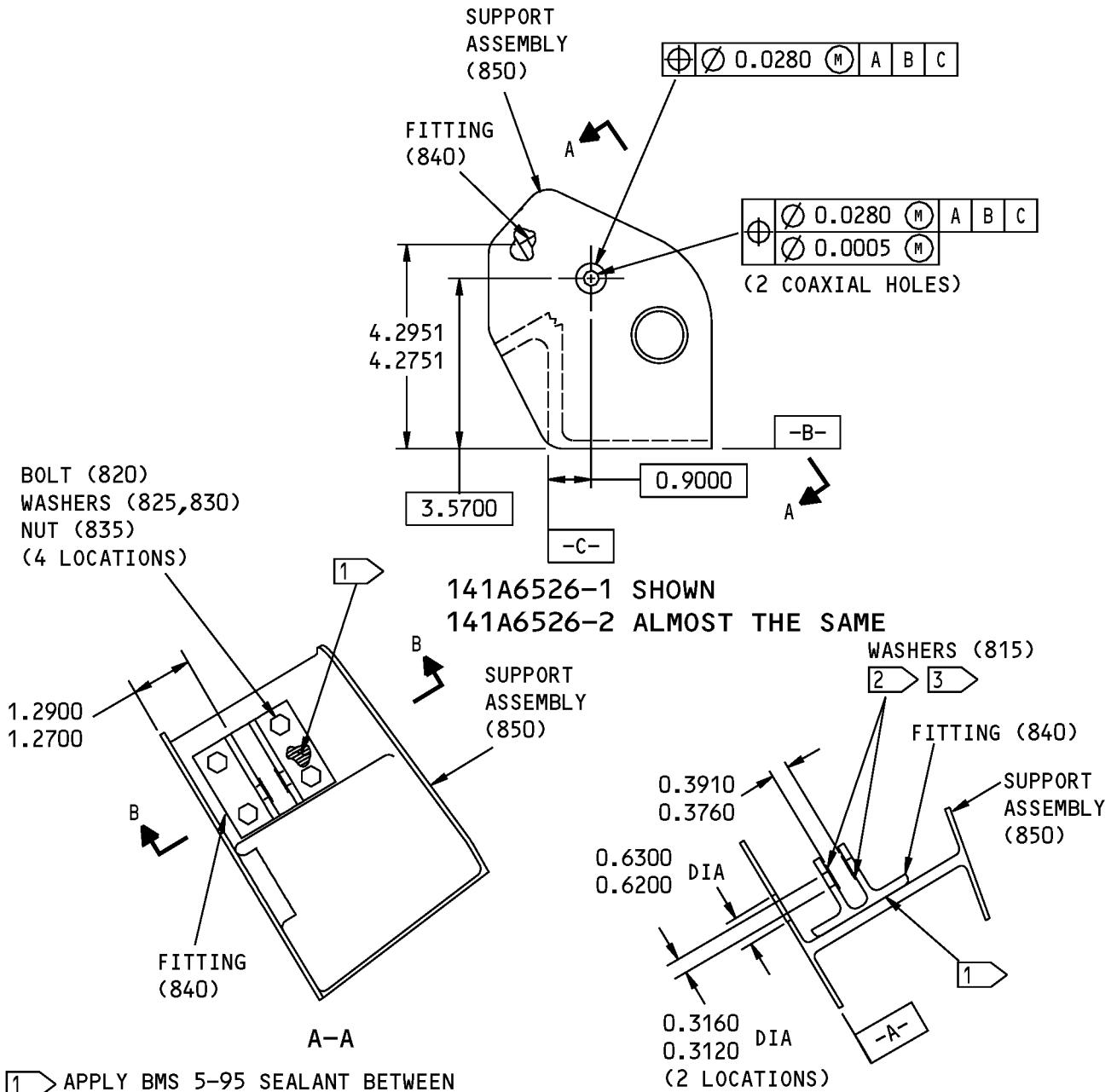
**52-41-05**

REPAIR 11-1

Page 602

Mar 01/2006

COMPONENT MAINTENANCE MANUAL



- 1 APPLY BMS 5-95 SEALANT BETWEEN THE SURFACES SHOWN
- 2 BOND THE WASHERS TO THE FITTING WITH BMS 5-95 SEALANT AS SPECIFIED IN SOPM 20-50-12, TYPE 93. MAKE SURE THE HOLES ARE FREE OF SEALANT, AND THAT THE WASHERS DO NOT CAUSE BLOCKAGE OF THE HOLES

- 3 FOR 141A6526-1 ONLY
- ITEM NUMBERS REFER TO IPL FIG. 1  
ALL DIMENSIONS ARE IN INCHES

141A6526-1,-2 Hinge Support Assembly Repair  
Figure 601

**52-41-05**



## COMPONENT MAINTENANCE MANUAL

### FITTING - REPAIR 11-2

69-70269-3, -4

#### 1. General

- A. This procedure has the data necessary to refinish the fitting (840, 845).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 1 for the item numbers.
- D. 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 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-17.31).
- (2) Apply primer, C00259 (F-20.03).

# 52-41-05

REPAIR 11-2

Page 601

Mar 01/2006





## COMPONENT MAINTENANCE MANUAL

### SUPPORT ASSEMBLY - REPAIR 12-1

141A6527-1, -2

#### 1. General

- A. This procedure has the data necessary to repair the support assembly (850, 855).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the standard true position dimensioning symbols shown in the repair.
- D. Refer to IPL Figure 1 for the item numbers.

#### 2. Bushing Replacement

- A. Consumable Materials

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

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

- B. References

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

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

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

- (1) Remove the bushing (860) from the support (865, 870).
- (2) Use the shrink-fit method specified in SOPM 20-50-03 to install the new bushing (860) in the support (865, 870) with sealant, A00247.
- (3) Fillet seal each end of the bushing (860) with sealant, A00247.
- (4) Ream the new bushing (860) to its pre-shrink fit ID of 1.0000-1.0015 inch.

# 52-41-05

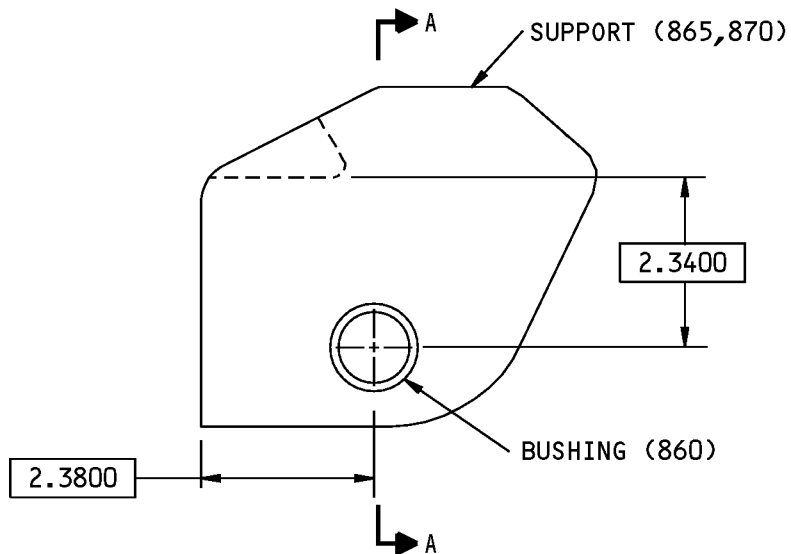
REPAIR 12-1

Page 601

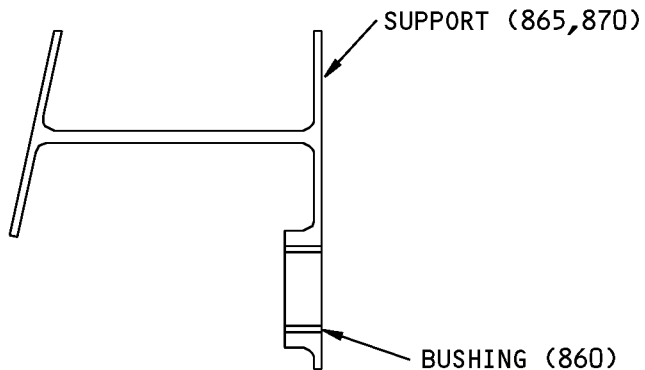
Jul 01/2008



COMPONENT MAINTENANCE MANUAL



141A6527-1 SHOWN  
1416527-2 ALMOST THE SAME



A-A

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

141A6527-1,-2 Support Assembly  
Figure 601

**52-41-05**

REPAIR 12-1  
Page 602  
Mar 01/2006



## COMPONENT MAINTENANCE MANUAL

### HINGE SUPPORT - REPAIR 12-2

141A6527-3, -4

#### 1. General

- A. This procedure has the data necessary to repair the hinge support (865, 870).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the standard true position dimensioning symbols shown in the repair.
- D. Refer to IPL Figure 1 for the item numbers.
- E. General repair details:
  - (1) Material: 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
SOPM 20-60-02	FINISHING MATERIALS

- C. Procedure

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

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

# 52-41-05

REPAIR 12-2

Page 601

Mar 01/2006



## COMPONENT MAINTENANCE MANUAL

### STOP ASSEMBLY - REPAIR 13-1

141A6538-1, -10, -11, -12, -2, -25, -4, -5, -6, -8, -9

#### 1. General

- A. This procedure has the data necessary to repair the stop assemblies (380, 385, 480, 485, 605, 610, 710, 715, 790, 795, 870, 875).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 2 for the item numbers.

#### 2. Bushing (390, 490, 615, 720, 800, 880) 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
SOPM 20-60-04	MISCELLANEOUS MATERIALS

##### C. Procedure

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

- (1) Remove the bushings (390, 490, 615, 720, 800, 880) from the stops (395, 400, 495, 500, 620, 625, 725, 730, 805, 810, 885, 890).
- (2) Install and swage the new bushings (390, 490, 615, 720, 800, 880) into the stops (395, 400, 495, 500, 620, 625, 725, 730, 805, 810, 885, 890) as specified in SOPM 20-50-03 with wet sealant, A00247 as specified in SOPM 20-50-19.
  - (a) Fillet seal each end of the bushing flanges with sealant, A00247 as specified in SOPM 20-50-19.

# 52-41-05

REPAIR 13-1

Page 601

Jul 01/2008



## COMPONENT MAINTENANCE MANUAL

### STOP - REPAIR 13-2

141A6538-13, -14, -16, -17, -18, -20, -21, -22, -23, -24, -26

#### 1. General

- A. This procedure has the data necessary to refinish the stops (395, 400, 495, 500, 620, 625, 725, 730, 805, 810, 885, 890).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 2 for the item numbers.
- D. General repair details:
  - (1) Material: Aluminum Alloy
  - (2) Shot Peen: All outside surfaces, but not the holes
    - (a) Intensity: 0.005A-0.010A
    - (b) Coverage: 1.0 automatic, 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
SOPM 20-60-02	FINISHING MATERIALS

- C. Procedure

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

- (1) 6 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.

# 52-41-05

REPAIR 13-2

Page 601

Mar 01/2006



## COMPONENT MAINTENANCE MANUAL

### (UPPER) END GATE ASSEMBLY - REPAIR 14-1

141A6540-2, -4

#### 1. General

- A. This procedure has the data necessary to repair the (upper) end gate assemblies (595, IPL Figure 1; 1A, IPL Figure 5).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the standard true position dimensioning symbols shown in the repair.
- D. Refer to IPL Figure 5 for the item numbers.

#### 2. Retainer (50, 55, 60, 65) Replacement

- A. Consumable Materials

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

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95
A02315	Sealant - Low Density, Synthetic Rubber. 2 Part	BMS5-142

- B. References

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

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

**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) Apply a pressure fay surface seal with sealant, A00247 between the mating surfaces of the retainers (50, 55, 60, 65) and the gate (70) as specified in SOPM 20-50-19.
  - (a) Do not allow very much squeeze-out in the slotted areas of the retainers (50, 55, 60, 65).
- (3) Attach the retainers (50, 55, 60, 65) to the gate (70) with the rivets (45).
  - (a) Install the rivets (45) with wet sealant, A00247 as specified in SOPM 20-50-19, method 2.
- (4) Apply a reduced size fillet with sealant, A02315 around the edges of the retainers (50, 55, 60, 65) as shown in REPAIR 14-1, Figure 601.

#### 3. Control Rod Clevis Assembly (25) Replacement

- A. Consumable Materials

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

# 52-41-05

REPAIR 14-1

Page 601

Jul 01/2008



## COMPONENT MAINTENANCE MANUAL

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95
A02315	Sealant - Low Density, Synthetic Rubber. 2 Part	BMS5-142

### B. References

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

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

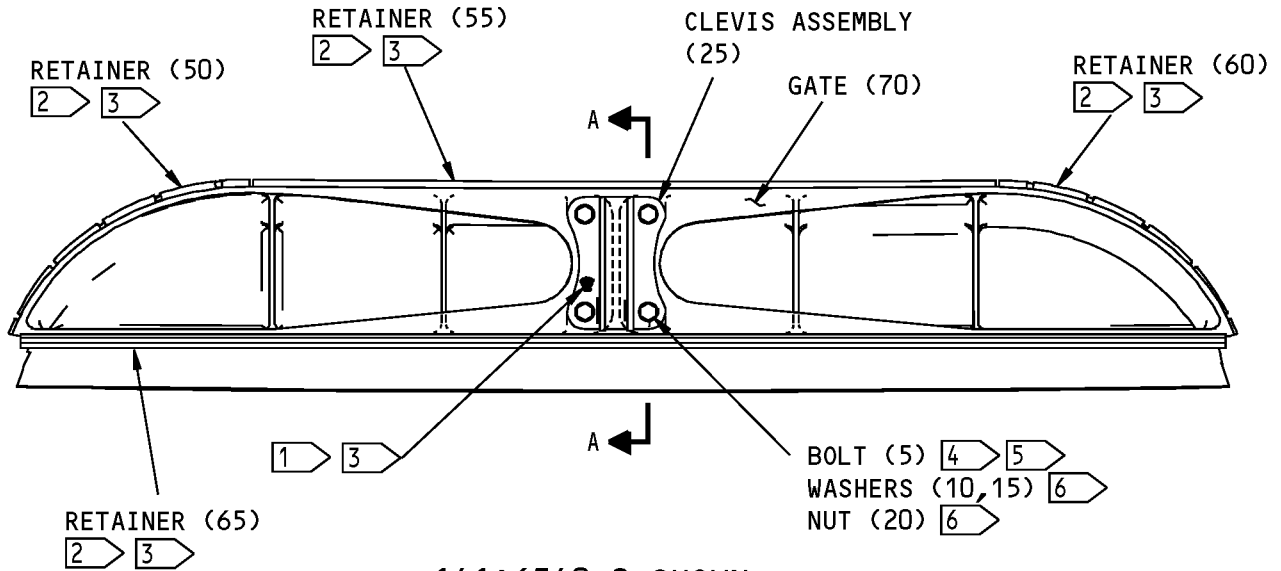
**NOTE:** For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Remove the bolts (5), washers (10, 15), nuts (20) and the clevis assembly (25) from the gate (70).
- (2) Apply a corrosion protection fay surface seal with sealant, A00247 between the mating surfaces of the clevis assembly (25) and the gate (70) as specified in SOPM 20-50-19.
- (3) Attach the clevis assembly (25) to the gate (70) with the bolts (5), washers (10,15) and nuts (20).
  - (a) Install the bolts (5) wet with sealant, A00247 as specified in SOPM 20-50-19, method 2.
  - (b) Tighten the bolts (5) to 25-30 pound-inches.
- (4) Encapsulate the nuts and washers with sealant, A00247 as specified in SOPM 20-50-19.
- (5) Apply a reduced size fillet with sealant, A02315 around the edges of the clevis assembly (25) as shown in REPAIR 14-1, Figure 601.

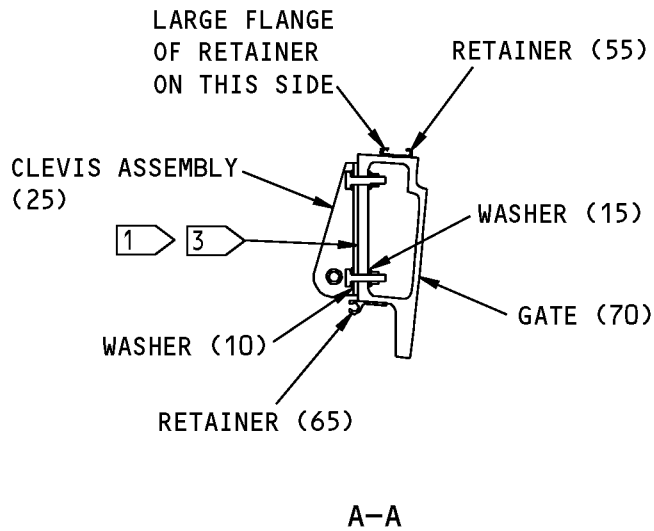
# 52-41-05

REPAIR 14-1  
Page 602  
Jul 01/2008

COMPONENT MAINTENANCE MANUAL



141A6540-2 SHOWN  
 141A6540-4 ALMOST THE SAME



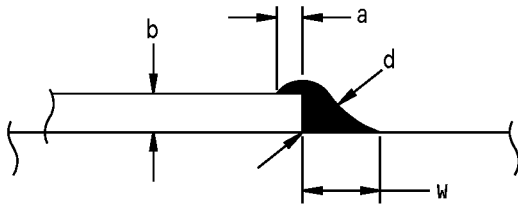
141A6540-2,-4 End Gate Assembly  
 Figure 601 (Sheet 1 of 2)

**52-41-05**

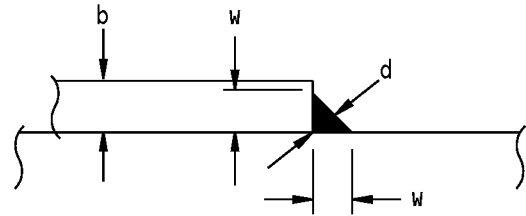
REPAIR 14-1  
 Page 603  
 Mar 01/2006




## COMPONENT MAINTENANCE MANUAL









$b = \text{STRUCTURE SEALED} \leq 0.06$   
APPLICATION A



$b = \text{STRUCTURE SEALED} \geq 0.06$   
APPLICATION B

$d = 0.06 \text{ min}$   
 $w = 0.06 \text{ to } 0.15$   
 $a + b = w \text{ except}$   
 $a = 0 \text{ when } b = 0.06 \text{ or more}$   
**REDUCED SIZE FILLET SEAL** 

-  APPLY A CORROSION PROTECTION FAY SURFACE SEAL WITH BMS 5-95 SEALANT BETWEEN THE MATING SURFACES OF THE CLEVIS ASSEMBLY AND THE GATE AS SPECIFIED IN SOPM 20-50-19
-  APPLY A PRESSURE FAY SURFACE SEAL WITH BMS 5-95 SEALANT BETWEEN THE MATING SURFACES OF THE RETAINERS AND THE GATE. DO NOT ALLOW VERY MUCH SQUEEZE-OUT IN THE SLOTTED AREAS OF THE RETAINER
-  APPLY A REDUCED SIZE FILLET WITH BMS 5-142 AROUND THE EDGES OF ALL FAY SEALED JOINTS

-  INSTALL THE FASTENERS WET WITH BMS 5-95 SEALANT AS SPECIFIED IN SOPM 20-50-19, METHOD 2
  -  TIGHTEN THE BOLTS TO 25-30 POUND-INCHES
  -  ENCAPSULATE THE NUTS AND WASHERS WITH BMS 5-95 SEALANT AS SPECIFIED IN SOPM 20-50-19
- ITEM NUMBERS REFER TO IPL FIG. 5  
ALL DIMENSIONS ARE IN INCHES

141A6540-2,-4 End Gate Assembly  
Figure 601 (Sheet 2 of 2)

# 52-41-05

REPAIR 14-1  
Page 604  
Mar 01/2006



## COMPONENT MAINTENANCE MANUAL

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

141A6541-2

#### 1. General

- A. This procedure has the data necessary to repair the (upper) control rod clevis assembly (25).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. 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

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

- (1) Remove the bushings (30, 35) from the clevis (25).
- (2) Install the new bushings (30, 35) into the clevis (25) with sealant, A00247 as specified in SOPM 20-50-03.
  - (a) Fillet seal each end of the bushing.

# 52-41-05

REPAIR 14-2

Page 601

Jul 01/2008



## COMPONENT MAINTENANCE MANUAL

### (UPPER) CLEVIS - REPAIR 14-3

141A6541-4

#### 1. General

- A. This procedure has the data necessary to refinish the (upper) clevis (40).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 5 for the item numbers.
- D. General repair details: 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 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.

# 52-41-05

REPAIR 14-3

Page 601

Mar 01/2006



## COMPONENT MAINTENANCE MANUAL

### (UPPER) GATE - REPAIR 14-4

141A6543-1, -3

#### 1. General

- A. This procedure has the data necessary to refinish the (upper) gate (70).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the standard true position dimensioning symbols shown in the repair.
- D. Refer to IPL Figure 5 for the item numbers.
- E. General repair details:
  - (1) Material: Magnesium Alloy

#### 2. Gate (70) 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 (REPAIR 14-4, Figure 601)

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

- (1) 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.

**NOTE:** The interior surfaces can be finished by the fill-and-drain method.

- (4) Apply teflon 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).

# 52-41-05

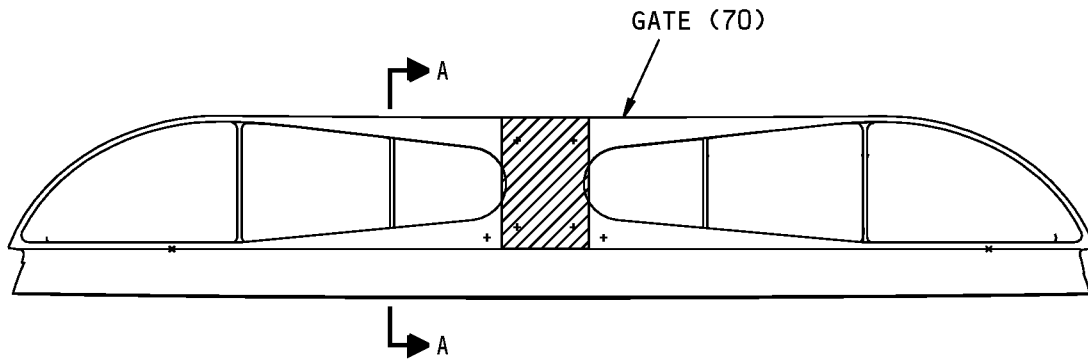
REPAIR 14-4

Page 601

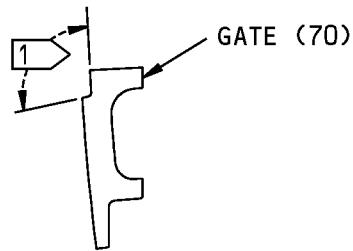
Mar 01/2009



COMPONENT MAINTENANCE MANUAL



141A6543-1 SHOWN  
 141A6543-3 ALMOST THE SAME



A-A

1 APPLY BMS 10-86 TEFLON COATING TO THIS AREA FOR THE LENGTH OF THE GATE

ITEM NUMBERS REFER TO IPL FIG. 5

141A6543-1,-3 (Upper End) Gate Refinish  
 Figure 601

**52-41-05**

REPAIR 14-4  
 Page 602  
 Mar 01/2006



## COMPONENT MAINTENANCE MANUAL

### (LOWER) END GATE ASSEMBLY - REPAIR 15-1

141A6540-1, -3

#### 1. General

- A. This procedure has the data necessary to repair the (lower) end gate assemblies (600, IPL Figure 1; 1A, IPL Figure 6).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the standard true position dimensioning symbols shown in the repair.
- D. Refer to IPL Figure 6 for the item numbers.

#### 2. Retainer (60, 65, 70, 75) Replacement

- A. Consumable Materials

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

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95
A02315	Sealant - Low Density, Synthetic Rubber. 2 Part	BMS5-142

- B. References

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

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

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

- (1) Remove the rivets (55) and the retainers (60, 65, 70, 75) from the gate (90).
- (2) Apply a pressure fay surface seal with sealant, A00247 between the mating surfaces of the retainers (60, 65, 70, 75) and the gate (90) as specified in SOPM 20-50-19.
  - (a) Do not allow very much squeeze-out in the slotted areas of the retainers (60, 65, 70, 75).
- (3) Attach the retainers (60, 65, 70, 75) to the gate (90) with the rivets (55).
  - (a) Install the rivets (55) wet with sealant, A00247 as specified in SOPM 20-50-19, method 2.
- (4) Apply a reduced size fillet with sealant, A02315 around the edges of the retainers (60, 65, 70, 75) as shown in REPAIR 15-1, Figure 601.

#### 3. Control Rod Clevis Assembly (15) Replacement

- A. Consumable Materials

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

# 52-41-05

REPAIR 15-1

Page 601

Jul 01/2008



## COMPONENT MAINTENANCE MANUAL

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95
A02315	Sealant - Low Density, Synthetic Rubber. 2 Part	BMS5-142

### B. References

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

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

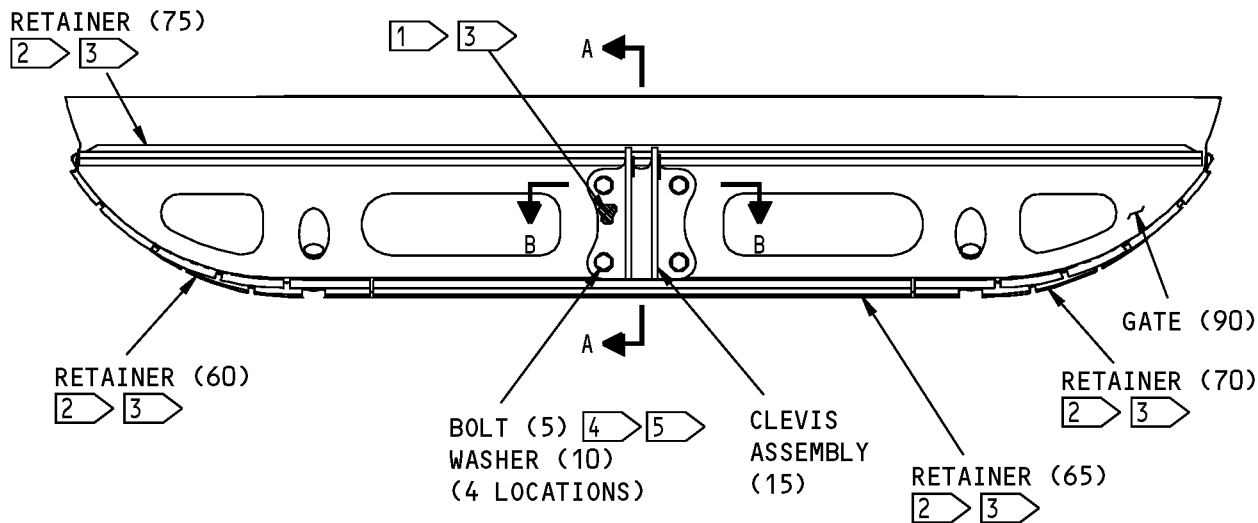
**NOTE:** For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Remove the bolts (5), washers (10), plate assemblies (35), and the clevis assembly (15) from the gate (90).
- (2) Apply a corrosion protection fay surface seal with sealant, A00247 between the mating surfaces of the plate assemblies (35) and the gate (90) as specified in SOPM 20-50-19.
- (3) Apply a corrosion protection fay surface seal with sealant, A00247 between the mating surfaces of the clevis assembly (15) and the gate (90) as specified in SOPM 20-50-19.
- (4) Attach the plate assemblies (35) and clevis assembly (15) with bolts (5) and washers (10).
  - (a) Install the bolts (5) wet with sealant, A00247 as specified in SOPM 20-50-19, method 2.
  - (b) Tighten the bolts (5) to 25-30 pound-inches.
- (5) Encapsulate the nutplates with sealant, A00247 as specified in SOPM 20-50-19.
- (6) Apply a reduced size fillet with sealant, A02315 around the edges of the clevis assembly (15) as shown in REPAIR 15-1, Figure 601.

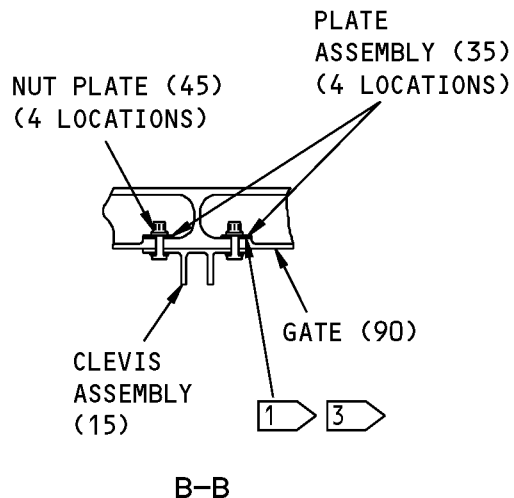
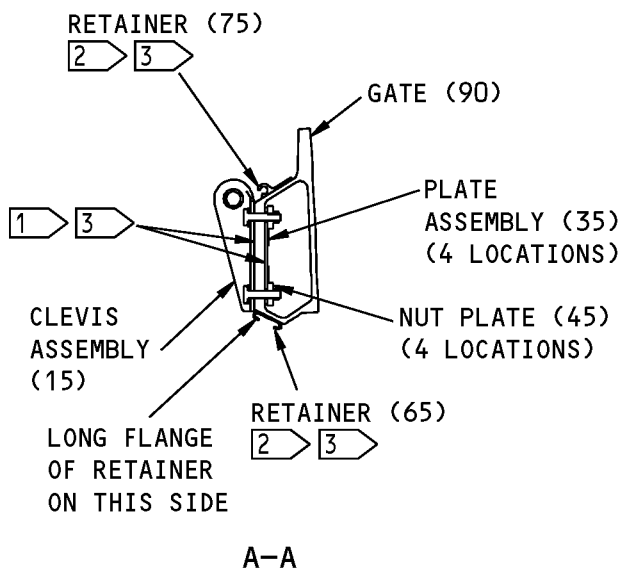
# 52-41-05

REPAIR 15-1  
Page 602  
Jul 01/2008

COMPONENT MAINTENANCE MANUAL



141A6540-1 SHOWN  
 141A6540-3 ALMOST THE SAME

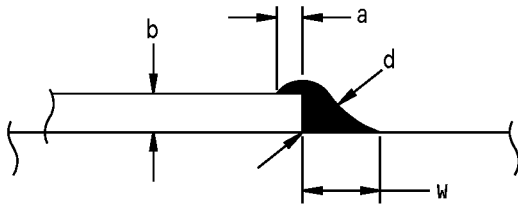


141A6540-1,-3 End Gate Assembly  
 Figure 601 (Sheet 1 of 2)

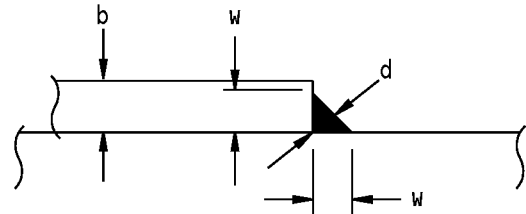
**52-41-05**



## COMPONENT MAINTENANCE MANUAL



b = STRUCTURE SEALED  $\leq$  0.06  
APPLICATION A



b = STRUCTURE SEALED  $\geq$  0.06  
APPLICATION B

d = 0.06 min  
w = 0.06 to 0.15  
a + b = w except  
a = 0 when b = 0.06 or more  
**REDUCED SIZE FILLET SEAL** 3

1 APPLY A CORROSION PROTECTION FAY SURFACE SEAL WITH BMS 5-95 SEALANT BETWEEN THE MATING SURFACES OF THE CLEVIS ASSEMBLY, THE PLATE ASSEMBLIES AND THE GATE AS SPECIFIED IN SOPM 20-50-19

2 APPLY A PRESSURE FAY SURFACE SEAL WITH BMS 5-95 SEALANT BETWEEN THE MATING SURFACES OF THE RETAINERS AND THE GATE. DO NOT ALLOW VERY MUCH SQUEEZE-OUT IN THE SLOTTED AREAS OF THE RETAINER

3 APPLY A REDUCED SIZE FILLET WITH BMS 5-142 AROUND THE EDGES OF ALL FAY SEALED JOINTS

4 INSTALL THE FASTENERS WET WITH BMS 5-95 SEALANT AS SPECIFIED IN SOPM 20-50-19, METHOD 2

5 TIGHTEN THE BOLTS TO 25-30 POUND-INCHES

6 ENCAPSULATE THE NUTPLATES WITH BMS 5-95 SEALANT AS SPECIFIED IN SOPM 20-50-19

ITEM NUMBERS REFER TO IPL FIG. 6  
ALL DIMENSIONS ARE IN INCHES

141A6540-1,-3 End Gate Assembly  
Figure 601 (Sheet 2 of 2)

# 52-41-05

REPAIR 15-1  
Page 604  
Mar 01/2006



## COMPONENT MAINTENANCE MANUAL

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

141A6541-1

#### 1. General

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

#### 2. Bushing (20, 25) Replacement

- A. Consumable Materials

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

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

- B. References

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

- C. Procedure

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

- (1) Remove the bushings (20, 25) from the clevis (25).
- (2) Install the new bushings (20, 25) into the clevis (25) with sealant, A00247 as specified in SOPM 20-50-03.
  - (a) Fillet seal each end of the bushings.

# 52-41-05

REPAIR 15-2

Page 601

Jul 01/2008



## COMPONENT MAINTENANCE MANUAL

### (LOWER) CLEVIS - REPAIR 15-3

141A6541-3

#### 1. General

- A. This procedure has the data necessary to refinish the (lower) clevis (30).
- 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: Aluminum Alloy

#### 2. Lower Clevis Refinish

- A. Consumable Materials

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

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

- B. References

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

- C. Procedure

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

- (1) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.35).
- (2) Apply primer, C00259 (F-20.03) but not in the holes for the bushings.

# 52-41-05

REPAIR 15-3

Page 601

Mar 01/2006



## COMPONENT MAINTENANCE MANUAL

### (LOWER) GATE ASSEMBLY - REPAIR 15-4

141A6542-1, -4

#### 1. General

- A. This procedure has the data necessary to repair the (lower) gate assembly (80).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the standard true position dimensioning symbols shown in the repair.
- D. Refer to IPL Figure 6 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 15-4, Figure 601)

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

- (1) Remove the bushings (85) from the gate (90).

**CAUTION:** AFTER THE BUSHINGS (85) ARE FLARED, THEY MUST BE FLUSH WITH THE FAYING SURFACES.

- (2) Install the new bushings (85) into the gate (90) 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.

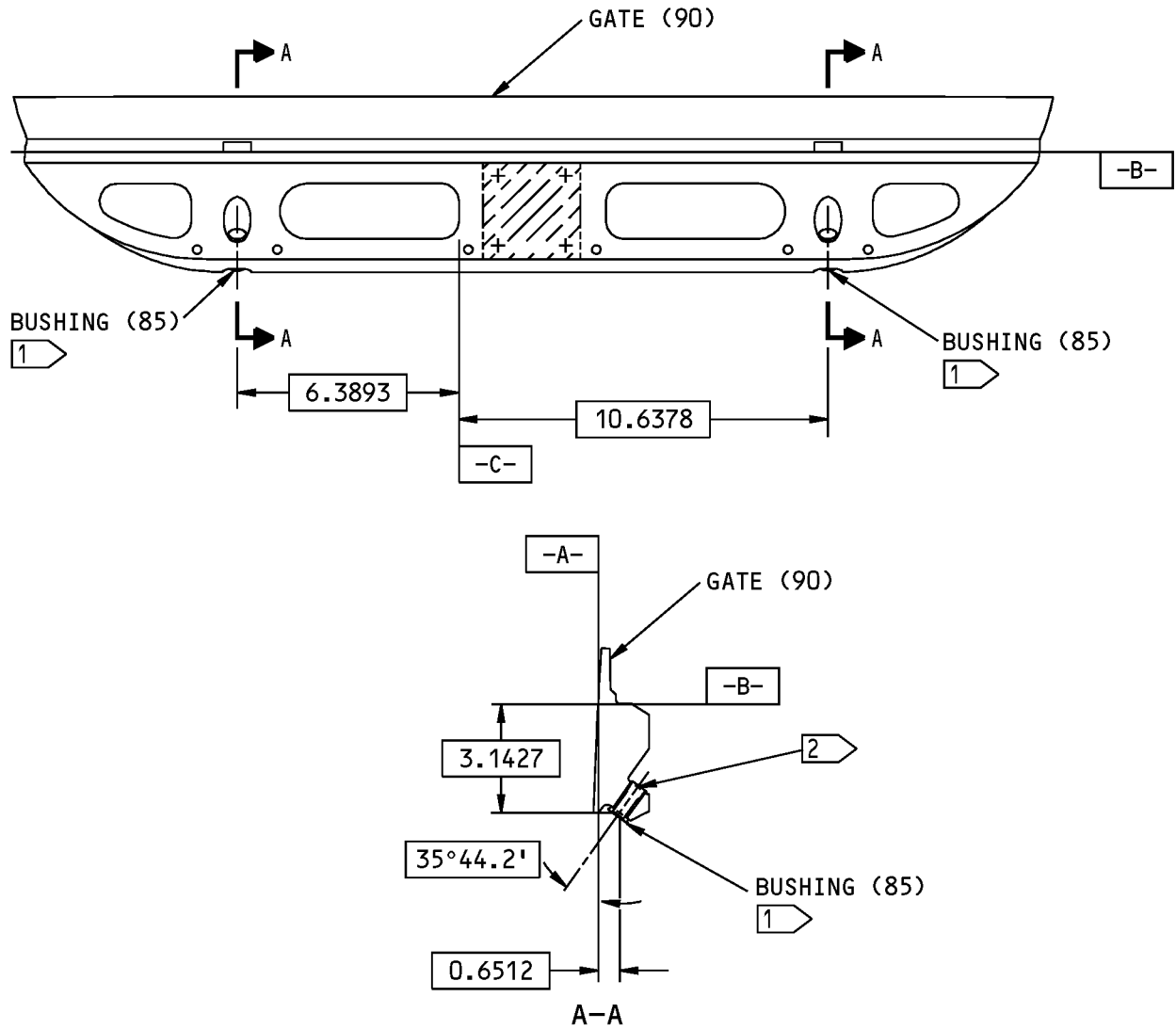
# 52-41-05

REPAIR 15-4

Page 601

Jul 01/2008

COMPONENT MAINTENANCE MANUAL



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

ITEM NUMBERS REFER TO IPL FIG. 6  
ALL DIMENSIONS ARE IN INCHES

2 FLARE THE BUSHING 10-15 DEGREES

141A6542-1,-4 Lower Gate Assembly Repair  
Figure 601

**52-41-05**

REPAIR 15-4  
Page 602  
Mar 01/2006



## COMPONENT MAINTENANCE MANUAL

### (LOWER) GATE - REPAIR 15-5

141A6542-2, -5

#### 1. General

- A. This procedure has the data necessary to refinish the (lower) gate (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: Aluminum Alloy

#### 2. Gate (90) Refinish

- A. Consumable Materials

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

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

- B. References

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

- C. Procedure

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

- (1) Anodize (F-17.12).
- (2) Apply primer, C00259 (F-20.03).
- (3) Apply enamel coating, C00032 (F-14.9813) but not in the holes for the bushings or the bolt holes.

**NOTE:** The interior surfaces can be finished by the fill-and-drain method.

# 52-41-05

REPAIR 15-5

Page 601

Mar 01/2006



## COMPONENT MAINTENANCE MANUAL

### LOWER AND UPPER TUBE ASSEMBLY - REPAIR 16-1

141A6545-1, -2

#### 1. General

- A. This procedure has the data necessary to repair the lower and upper tube assembly (130, 135).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the standard true position dimensioning symbols shown in the repair.
- D. Refer to IPL Figure 3 for the item numbers.

#### 2. Bearing (150) Replacement

##### A. References

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

##### B. Procedure

- (1) Remove the cotter pin (137), nut (140), washers (145), and bearing (150) from the crank (170).
- (2) Install the new bearing (150) as follows:
  - (a) Install the bearing (150) on the crank (170) with four washers (145) under the bearing and four washers (145) under the nut (140).
  - (b) Tighten the nut (140) from 65-90 pound-inches.
  - (c) Install the cotter pin (137) into the nut (140) as specified in SOPM 20-50-02.

# 52-41-05

REPAIR 16-1

Page 601

Mar 01/2006



## COMPONENT MAINTENANCE MANUAL

### ROLLER CAM CRANK - REPAIR 16-2

69-37418-11

#### 1. General

- A. This procedure has the data necessary to refinish the roller cam crank (170).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the standard true position dimensioning symbols shown in the repair.
- D. Refer to IPL Figure 3 for the item numbers.
- E. General repair details:
  - (1) Material: Aluminum Alloy

#### 2. Roller Cam Crank (170) 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 (REPAIR 16-2, Figure 601)

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

- (1) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.35).
- (2) Apply primer, C00259 (F-20.02). 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 enamel on the surfaces identified by flagnote 1 in REPAIR 16-2, Figure 601.
  - (a) Over spray is permitted on surfaces identified by flagnote 2 in REPAIR 16-2, Figure 601.

# 52-41-05

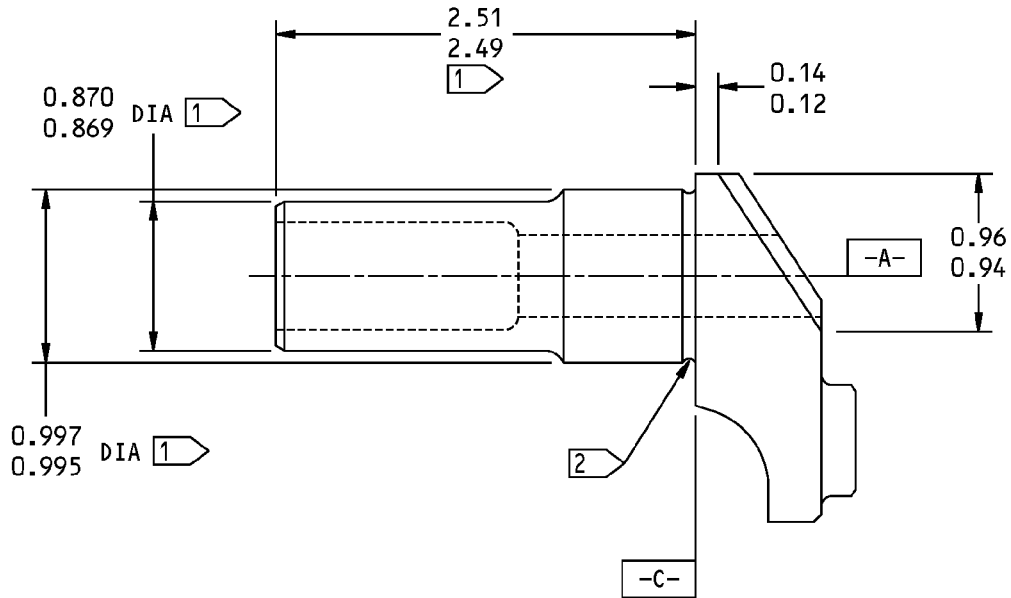
REPAIR 16-2

Page 601

Mar 01/2006



COMPONENT MAINTENANCE MANUAL



- 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. 3  
 ALL DIMENSIONS ARE IN INCHES

69-37418-11 Roller Cam Crank Refinish  
 Figure 601

**52-41-05**

REPAIR 16-2  
 Page 602  
 Mar 01/2006



## COMPONENT MAINTENANCE MANUAL

### GATE CRANK ASSEMBLY - REPAIR 16-3

60-4431-5

#### 1. General

- A. This procedure has the data necessary to repair the gate crank assembly (200).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 shown in the repair.
- D. Refer to IPL Figure 3 for the item numbers.

#### 2. Bearing Replacement

- A. References

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

- B. Procedure (REPAIR 16-3, Figure 601)

- (1) Remove the bearing (202) from the crank (201).
- (2) Install the new bearing (202) into the crank (201).
- (3) Anvil or roller swage the bearing (202) as specified in SOPM 20-50-03 (see flagnote 1).

#### 3. Fitting Replacement

- A. Procedure (REPAIR 16-3, Figure 601)

- (1) Remove the fitting (203) from the crank (201).
- (2) Install the new fitting (203) into the crank (201).

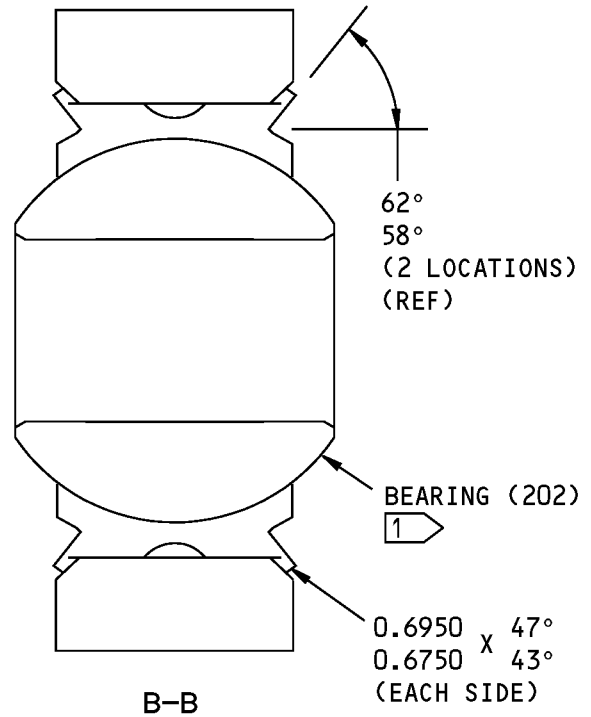
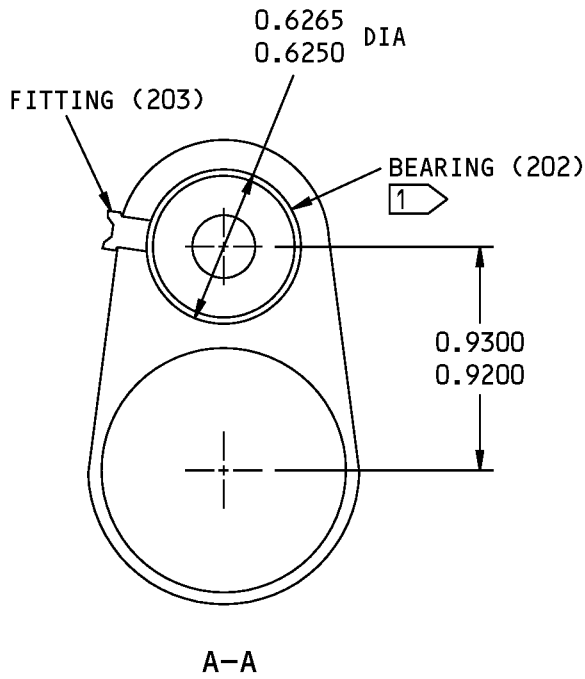
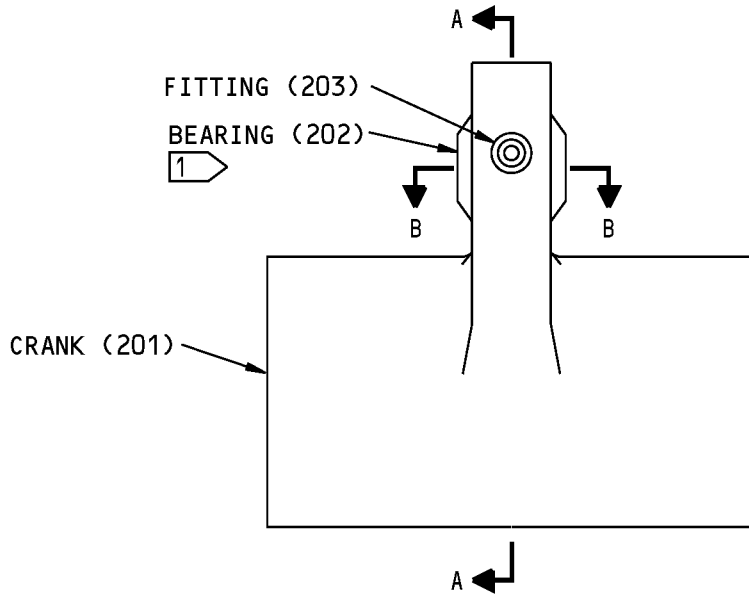
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REPAIR 16-3

Page 601

Mar 01/2006

COMPONENT MAINTENANCE MANUAL



ANVIL OR ROLLER SWAGE THE BEARING AS SPECIFIED IN SOPM 20-50-03

ITEM NUMBERS REFER TO IPL FIG. 3  
ALL DIMENSIONS ARE IN INCHES

60-4431-5 Gate Crank Assembly Repair  
Figure 601

**52-41-05**

REPAIR 16-3  
Page 602  
Mar 01/2006



## COMPONENT MAINTENANCE MANUAL

### CRANK - REPAIR 16-4

60-4431-4

#### 1. General

- A. This procedure has the data necessary to refinish the crank (201).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 3 for the item numbers.
- D. General repair details:
  - (1) Material: 15-5 PH CRES
    - (a) 150-170 ksi

#### 2. Crank (201) Refinish

- A. Consumable Materials

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

Reference	Description	Specification
D00113	Lubricant - Liquid Dispersed Solid Film Lubricant	BMS3-8, BAC 5811, TYPE VIII

- B. References

Reference	Title
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 decoding table for Boeing finish codes, refer to SOPM 20-41-01. For lubricants, refer to SOPM 20-60-03.

- (1) Apply lubricant, D00113 (F-19.10) as specified in SOPM 20-50-08.

# 52-41-05

REPAIR 16-4

Page 601

Mar 01/2006



## COMPONENT MAINTENANCE MANUAL

### GATE CRANK - REPAIR 16-5

60-4409-2

#### 1. General

- A. This procedure has the data necessary to refinish the gate crank (205).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 3 for the item numbers.
- D. General repair details:
  - (1) Material: 15-5 PH CRES
    - (a) 150-170 ksi

#### 2. Gate Crank (205) Refinish

##### A. References

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

##### B. Procedure

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

- (1) Passivate (F-17.25).

# 52-41-05

REPAIR 16-5

Page 601

Mar 01/2006



## COMPONENT MAINTENANCE MANUAL

### LATCH TORQUE TUBE - REPAIR 16-6

60-4406-15

#### 1. General

- A. This procedure has the data necessary to refinish the latch torque tube (210).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 shown in the repair.
- D. Refer to IPL Figure 3 for the item numbers.
- E. General repair details:
  - (1) Material:15-5 PH CRES
    - (a) 150-170 ksi

#### 2. Latch Torque Tube Refinish

##### A. Consumable Materials

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

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

##### B. References

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

##### C. Procedure (REPAIR 16-6, Figure 601)

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

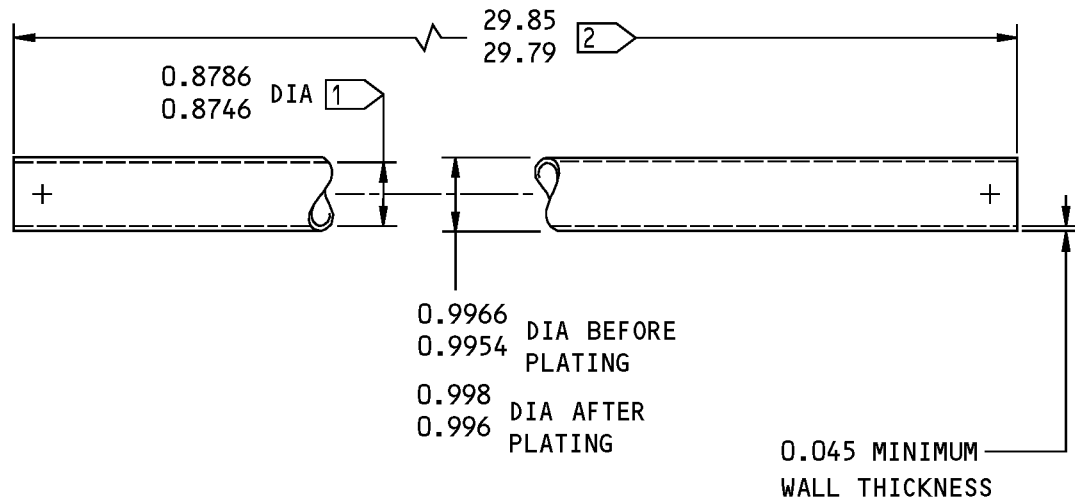
- (1) Cadmium plate (F-15.06) to get the design dimensions shown in REPAIR 16-6, Figure 601.
- (2) Apply primer, C00259 (F-20.48) to the inner diameter only.

# 52-41-05

REPAIR 16-6  
Page 601  
Mar 01/2006



COMPONENT MAINTENANCE MANUAL



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

ITEM NUMBERS REFER TO IPL FIG. 3  
ALL DIMENSIONS ARE IN INCHES

2 TUBE TO BE STRAIGHT 0.002 FOR EVERY LINEAR FOOT

60-4406-15 Latch Torque Tube Refinish  
Figure 601

**52-41-05**

REPAIR 16-6  
Page 602  
Mar 01/2006



## COMPONENT MAINTENANCE MANUAL

### LATCH SUPPORT FITTING ASSEMBLY - REPAIR 17-1

141A6546-1, -2, -3, -4, -10, -12

#### 1. General

- A. This procedure has the data necessary to repair the latch support fitting assemblies (45, 50, 55, 60).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 3 for the item numbers.

#### 2. Fitting (65) Replacement

- A. Procedure
  - (1) Remove the fitting (65) from the fitting (70, 75, 80, 85).
  - (2) Install the new fitting (65) into the fitting (70, 75, 80, 85).

# 52-41-05

REPAIR 17-1

Page 601

Mar 01/2006





## COMPONENT MAINTENANCE MANUAL

### LATCH SUPPORT FITTING - REPAIR 17-2

141A6546-5, -6, -7, -8, -11, -13

#### 1. General

- A. This procedure has the data necessary to refinish the latch support fittings (70, 75, 80, 85).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the standard true position dimensioning symbols shown in the repair.
- D. Refer to IPL Figure 3 for the item numbers.
- E. General repair details:
  - (1) Material: Aluminum Alloy

#### 2. Latch Support Fitting (70, 75, 80, 85) 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 (REPAIR 17-2, Figure 601)

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

- (1) Boric acid-sulfuric-acid anodize or chromic acid anodize (F-17.35) all surfaces.
- (2) Apply primer, C00259 (F-20.03) to all surfaces but not in the area identified by flagnote 1.
- (3) (For 141A6546-5, -6, -7, -8 only) Apply enamel coating, C00260 (F-21.03) to all surfaces but not in the area identified by flagnote 1.
- (4) (For 141A6546-11, -13 only) Apply enamel coating, C00260 (F-21.031) to all surfaces but not in the area identified by flagnote 1.

# 52-41-05

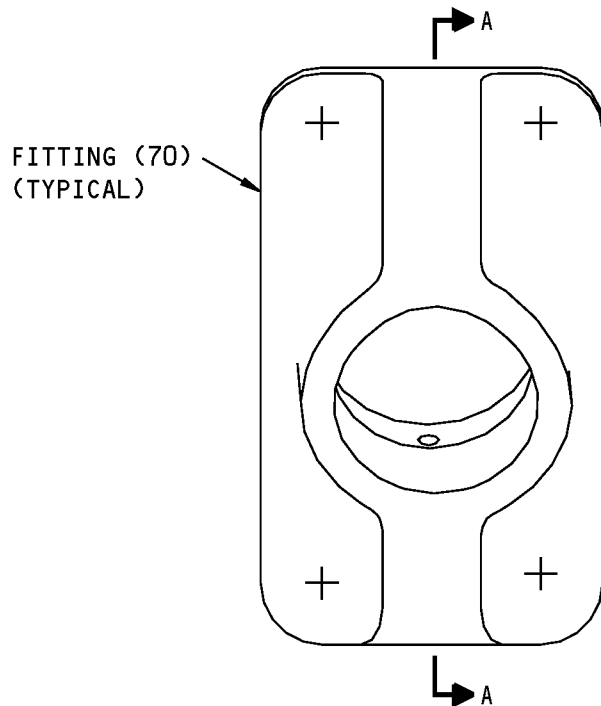
REPAIR 17-2

Page 601

Mar 01/2006

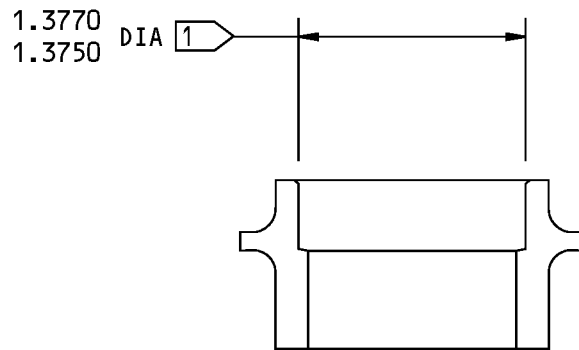


COMPONENT MAINTENANCE MANUAL



FITTING (70)  
(TYPICAL)

FITTING (70) SHOWN  
FITTING (75,80,85) ALMOST THE SAME



A-A

**1** DO NOT APPLY PRIMER OR PAINT IN THIS AREA

ITEM NUMBERS REFER TO IPL FIG. 3  
ALL DIMENSIONS ARE IN INCHES

141A6546-5,-6,-7,-8,-11,-13 Latch Support Fitting Refinish  
Figure 601

**52-41-05**

REPAIR 17-2  
Page 602  
Mar 01/2006



## COMPONENT MAINTENANCE MANUAL

### CENTERING GUIDE ASSEMBLY - REPAIR 18-1

141A6549-1

#### 1. General

- A. This procedure has the data necessary to repair the centering guide assembly (60).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the standard true position dimensioning symbols shown in the repair.
- D. Refer to IPL Figure 2 for the item numbers.

#### 2. Bearing (75) Replacement

##### A. References

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

##### B. Procedure

- (1) Remove the nut (65), washer (70), and bearing (75) from the centering guide assembly (60).
- (2) Install the bearing (75), washer (70), and nut (65) to the fitting (80) as specified in SOPM 20-50-01.
  - (a) Tighten the nut to 100 - 150 pound-inches.

# 52-41-05

REPAIR 18-1

Page 601

Mar 01/2006



## COMPONENT MAINTENANCE MANUAL

### FITTING - REPAIR 18-2

141A6549-2

#### 1. General

- A. This procedure has the data necessary to refinish the fitting (80).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 2 for the item numbers.
- D. General repair details:
  - (1) Material: Aluminum Alloy

#### 2. Fitting (80) Refinish

- A. Consumable Materials

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

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

- B. References

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

- C. Procedure

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

- (1) Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.35) all surfaces.
- (2) Apply primer, C00259 (F-20.03) to all surfaces but not in the serrations.

# 52-41-05

REPAIR 18-2

Page 601

Mar 01/2006



## COMPONENT MAINTENANCE MANUAL

### EXTERIOR HANDLE PAN ASSEMBLY - REPAIR 19-1

141A6554-1

#### 1. General

- A. This procedure has the data necessary to repair the external handle pan assembly (200).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to REPAIR-GENERAL, Figure 601 for the standard true position dimensioning symbols shown in the repair.
- D. Refer to IPL Figure 2 for the item numbers.

#### 2. Seal Plate (210) 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 (REPAIR 19-1, Figure 601)

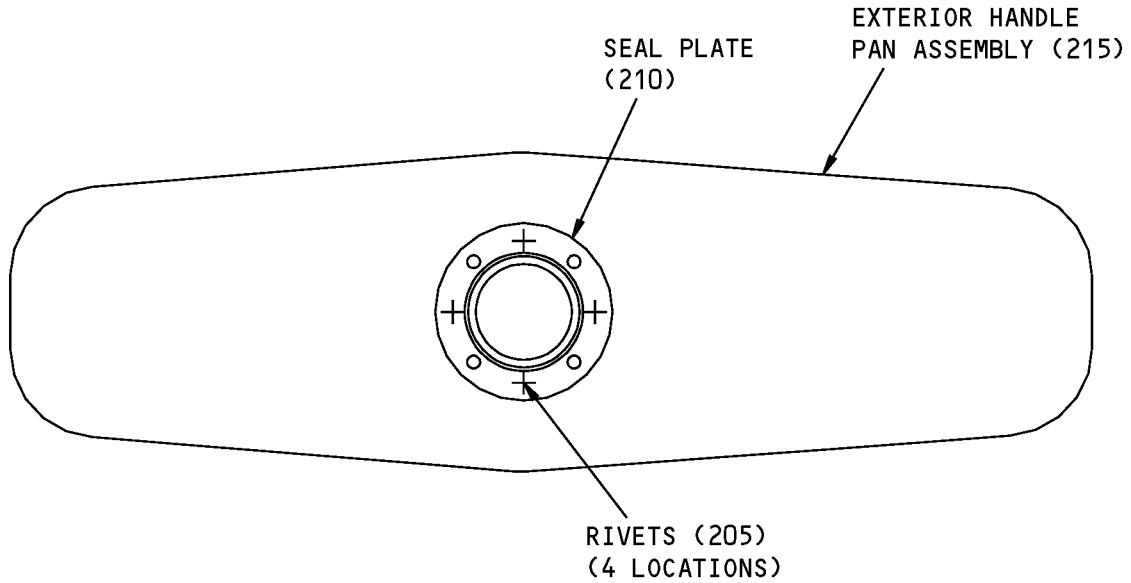
**NOTE:** For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Remove the seal plate (210) from the exterior handle pan (215).
- (2) Apply a pressure fay surface seal with sealant, A00247 between the mating surfaces of the seal plate (210) and the exterior handle pan (215).
- (3) Attach the seal plate (210) to the exterior handle pan (215) with rivets (205).

# 52-41-05

REPAIR 19-1  
Page 601  
Jul 01/2008

COMPONENT MAINTENANCE MANUAL



141A6554-1 Exterior Handle Pan Assembly - Repair  
Figure 601

**52-41-05**

REPAIR 19-1

Page 602

Mar 01/2006



## COMPONENT MAINTENANCE MANUAL

### EXTERIOR HANDLE PAN - REPAIR 19-2

65-52452-1

#### 1. General

- A. This procedure has the data necessary to refinish the external handle pan (215).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 2 for the item numbers.
- D. 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
SOPM 20-60-02	FINISHING MATERIALS

- C. Procedure

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

- (1) Chemical treat and apply primer, C00259 (SRF-14.01).

# 52-41-05

REPAIR 19-2

Page 601

Mar 01/2006



## COMPONENT MAINTENANCE MANUAL

### SEAL PLATE - REPAIR 19-3

60-4412-2

#### 1. General

- A. This procedure has the data necessary to refinish the seal plate (210).
- B. Refer to the Standard Overhaul Practices Manual (SOPM) for the SOPM subjects identified in this procedure.
- C. Refer to IPL Figure 2 for the item numbers.
- D. 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 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-17.31) all surfaces of the seal plate (210).
- (2) Apply primer, C00259 (F-20.03) to all surfaces of the seal plate (210).

# 52-41-05

REPAIR 19-3

Page 601

Mar 01/2006





## COMPONENT MAINTENANCE MANUAL

### HOUSING ASSEMBLY - REPAIR 20-1

149A6107-1

#### 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 REPAIR-GENERAL, Figure 601 for the standard true position dimensioning symbols shown in the repair.
- D. Refer to IPL Figure 8 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

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

- (1) Remove the bushings (395) from the housing (410).
- (2) Install the new bushings (395) into the housing (410) with wet sealant, A00247 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
SOPM 20-60-04	MISCELLANEOUS MATERIALS

# 52-41-05

REPAIR 20-1  
Page 601  
Jul 01/2008



## COMPONENT MAINTENANCE MANUAL

### C. Procedure

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

- (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, A00247 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. Consumable Materials

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

Reference	Description	Specification
C00033	Coating - Exterior Protective Enamel, Flexibility Use	BMS10-60, Type II

##### B. References

Reference	Title
SOPM 20-50-10	APPLICATION OF STENCILS, INSIGNIA, SILK SCREEN, PART NUMBERING AND IDENTIFICATION MARKINGS
SOPM 20-60-02	FINISHING MATERIALS

##### C. Procedure

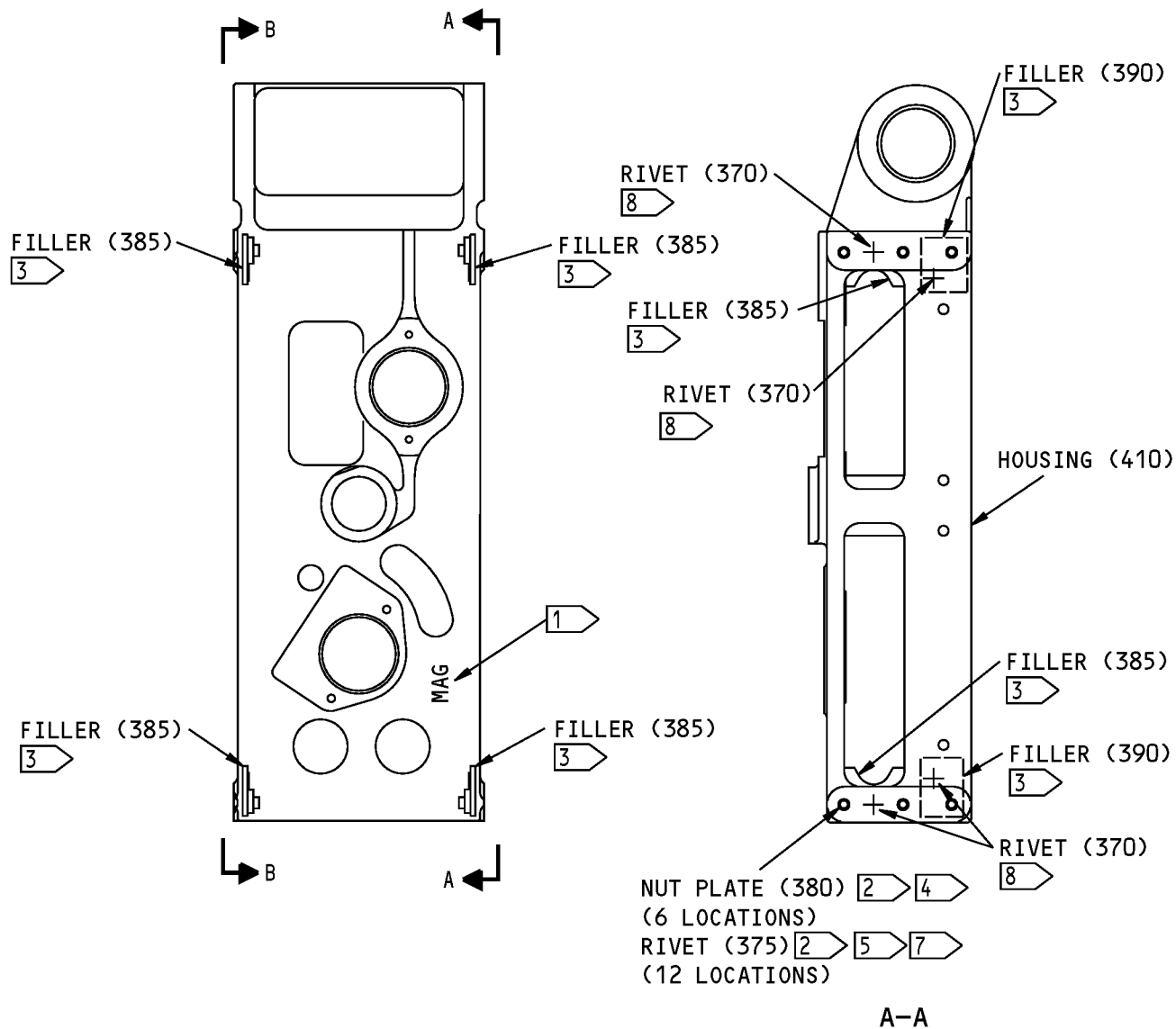
**NOTE:** For finishing materials, refer to SOPM 20-60-02

- (1) Apply enamel coating, C00033 (F-14.9813) after the bushings have been installed but do not put enamel in the locations that follow:
  - (a) The inner diameters of the bushings.
  - (b) The 1.3775, 1.6258, 2.3130 or 2.3750 inch diameter holes.
  - (c) The holes for the nutplates (16 locations).
- (2) 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.

# 52-41-05

REPAIR 20-1  
Page 602  
Mar 01/2006

COMPONENT MAINTENANCE MANUAL

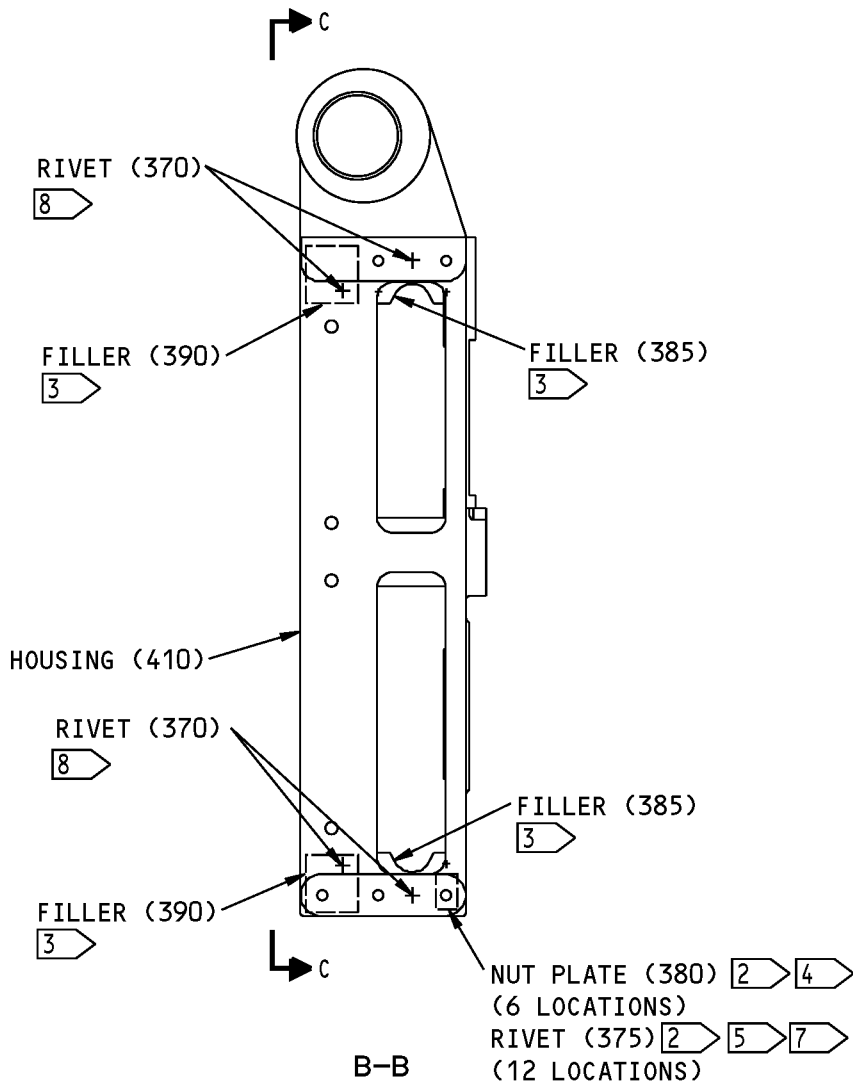


149A6107-1 Housing Assembly  
 Figure 601 (Sheet 1 of 5)

**52-41-05**

REPAIR 20-1  
 Page 603  
 Jul 01/2007

COMPONENT MAINTENANCE MANUAL

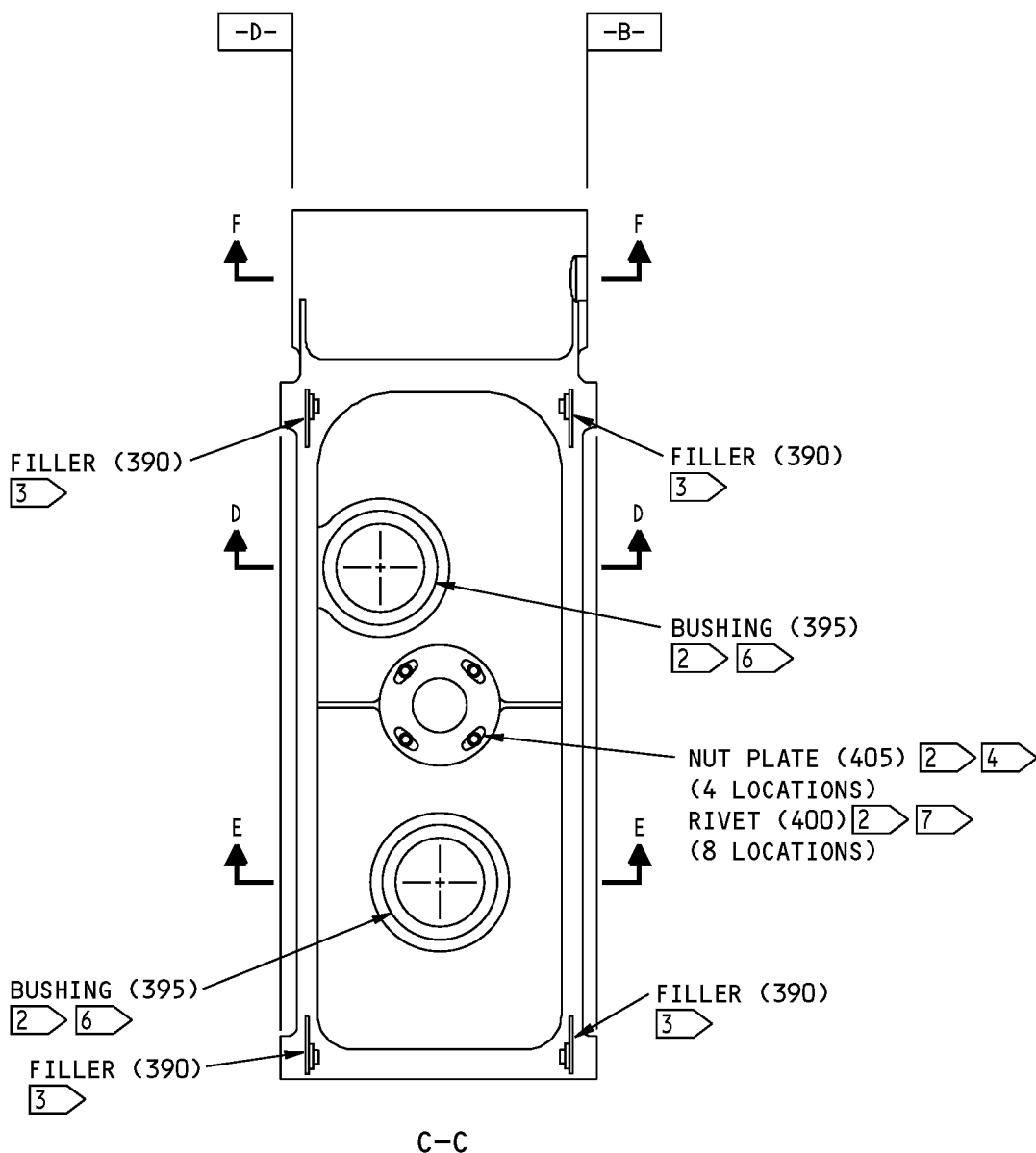


149A6107-1 Housing Assembly  
Figure 601 (Sheet 2 of 5)

**52-41-05**

REPAIR 20-1  
Page 604  
Jul 01/2007

COMPONENT MAINTENANCE MANUAL

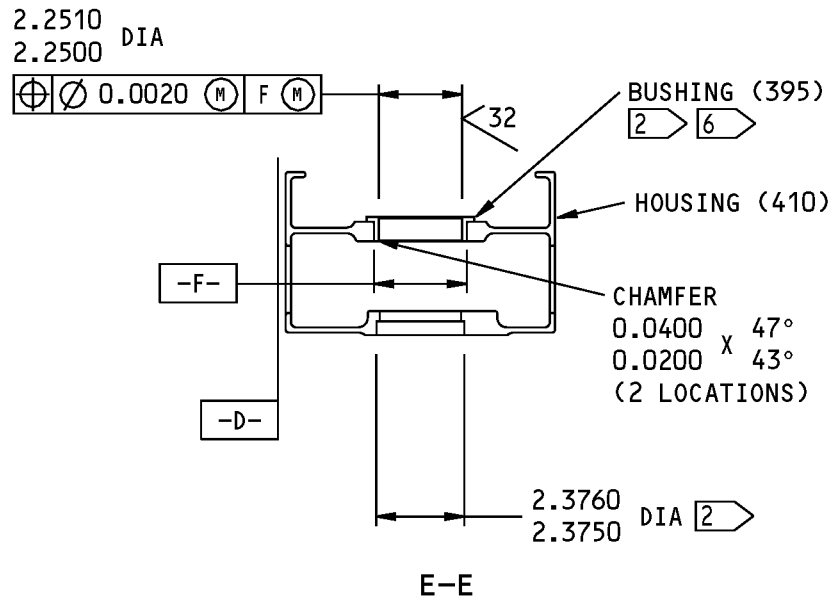
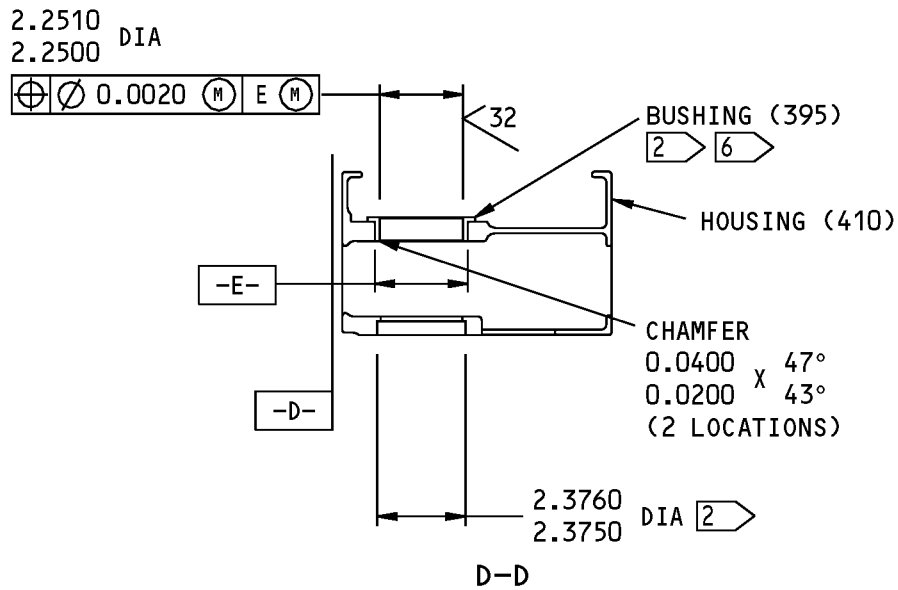


149A6107-1 Housing Assembly  
Figure 601 (Sheet 3 of 5)

**52-41-05**

REPAIR 20-1  
Page 605  
Jul 01/2007

COMPONENT MAINTENANCE MANUAL



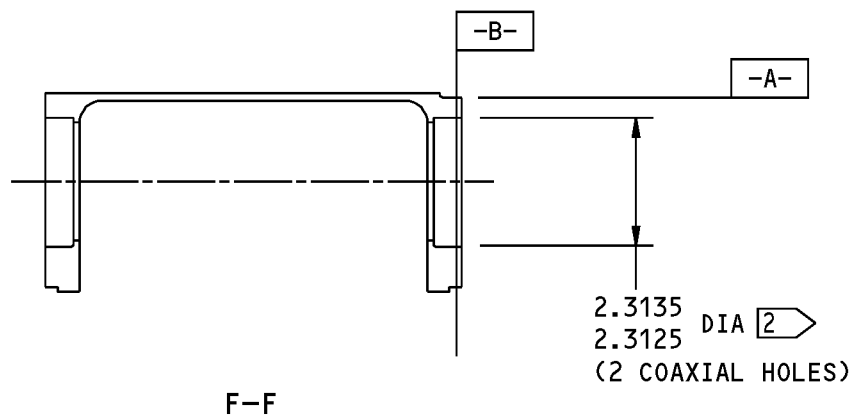
149A6107-1 Housing Assembly  
Figure 601 (Sheet 4 of 5)

**52-41-05**

REPAIR 20-1  
Page 606  
Jul 01/2007



## COMPONENT MAINTENANCE MANUAL



- 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. 8

ALL DIMENSIONS ARE IN INCHES

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

# 52-41-05

REPAIR 20-1

Page 607

Jul 01/2007



## COMPONENT MAINTENANCE MANUAL

### HOUSING - REPAIR 20-2

149A6107-4

#### 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 REPAIR-GENERAL, Figure 601 for the standard true position dimensioning symbols shown in the repair.
- D. Refer to IPL Figure 8 for the item numbers.
- E. General repair details:
  - (1) Material: Magnesium 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 20-2, Figure 601)

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

- (1) Anodize (F-17.12).
- (2) Apply primer, C00259 (F-20.03) to all surfaces but only one layer to the surfaces identified by flagnote 1.

# 52-41-05

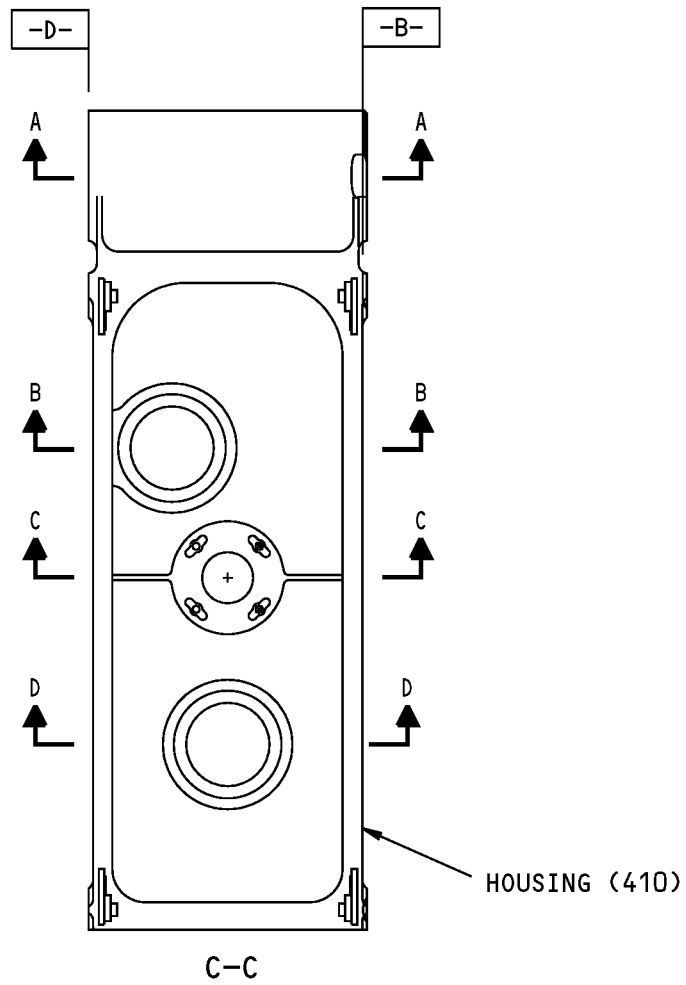
REPAIR 20-2

Page 601

Mar 01/2006



COMPONENT MAINTENANCE MANUAL



149A6107-4 Housing Assembly  
Figure 601 (Sheet 1 of 3)

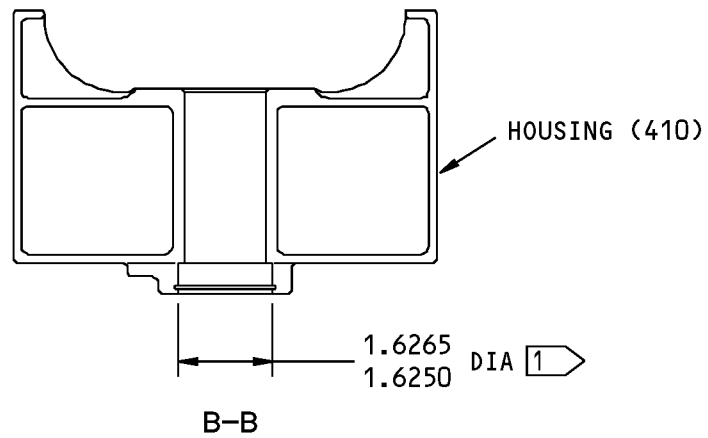
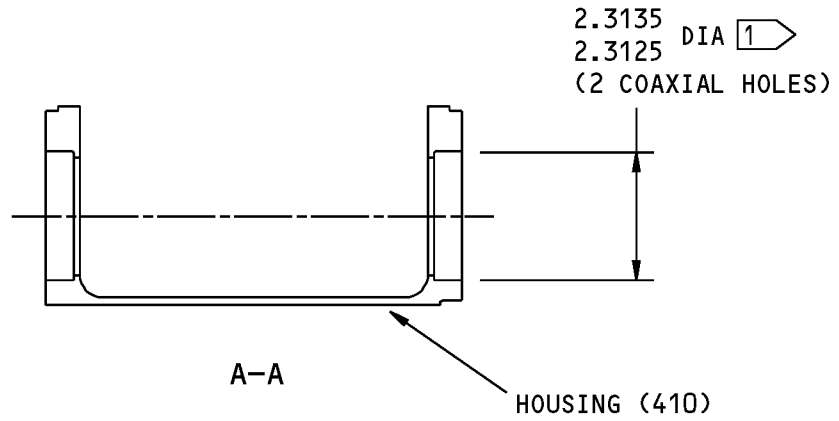
**52-41-05**

REPAIR 20-2

Page 602

Mar 01/2006

COMPONENT MAINTENANCE MANUAL



149A6107-4 Housing Assembly  
Figure 601 (Sheet 2 of 3)

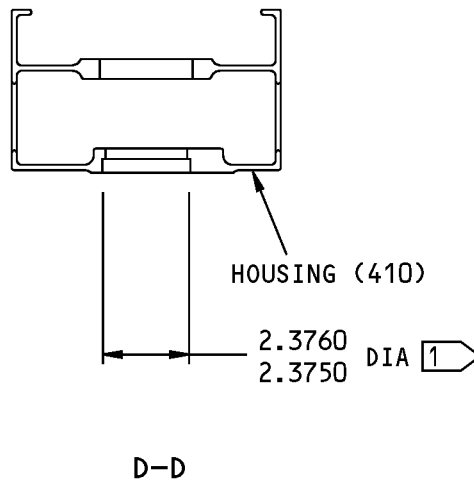
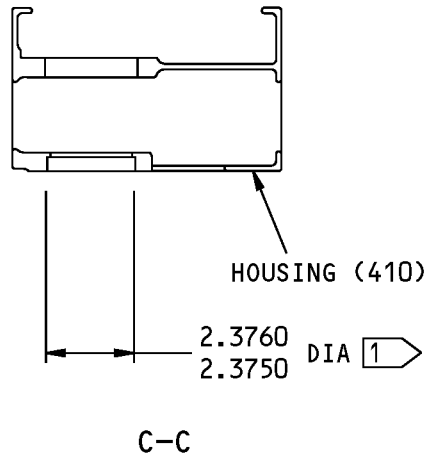
**52-41-05**

REPAIR 20-2

Page 603

Mar 01/2006

COMPONENT MAINTENANCE MANUAL



1 APPLY ONLY ONE LAYER OF PRIMER TO THESE SURFACES

ITEM NUMBERS REFER TO IPL FIG. 8  
ALL DIMENSIONS ARE IN INCHES

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

**52-41-05**

REPAIR 20-2  
Page 604  
Mar 01/2006



## COMPONENT MAINTENANCE MANUAL

### 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 REPAIR-GENERAL, Figure 601 for the standard true position dimensioning symbols shown in the repair.
- D. Refer to IPL Figure 8 for the item numbers.
- E. General repair details:
  - (1) Material: 15-5 PH CRES
    - (a) 150-170 ksi

#### 2. Shaft (165) Refinish

- A. Consumable Materials

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

Reference	Description	Specification
D00113	Lubricant - Liquid Dispersed Solid Film Lubricant	BMS3-8, BAC 5811, TYPE VIII

- B. References

Reference	Title
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 (REPAIR 21-1, Figure 601)

**NOTE:** For decoding table for Boeing finish codes, refer to SOPM 20-41-01. For lubricants, refer to SOPM 20-60-03.

- (1) Passivate (F-17.25) all surfaces.
- (2) Cadmium plate (F-15.06) on the smaller diameter splined surface shown by flagnote 1.
- (3) Apply lubricant, D00113 as specified in SOPM 20-50-08, Type VIII, on the larger diameter splined surface shown by flagnote 2.

# 52-41-05

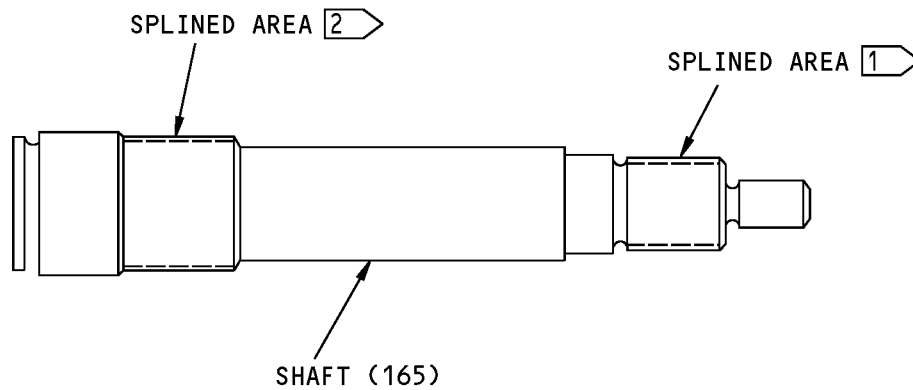
REPAIR 21-1

Page 601

Mar 01/2006



## COMPONENT MAINTENANCE MANUAL



- 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. 8  
ALL DIMENSIONS ARE IN INCHES

60-4455-3 Shaft Refinish  
Figure 601

# 52-41-05

REPAIR 21-1  
Page 602  
Mar 01/2006



## COMPONENT MAINTENANCE MANUAL

### 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 8 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).

# 52-41-05

REPAIR 22-1

Page 601

Mar 01/2006



## COMPONENT MAINTENANCE MANUAL

### (HANDLE MECHANISM) HOUSING FITTING - REPAIR 22-2

141A6120-2

#### 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 REPAIR-GENERAL, Figure 601 for the standard true position dimensioning symbols shown in the repair.
- D. Refer to IPL Figure 8 for the item numbers.
- E. General repair details:
  - (1) Material: 4340 Steel
    - (a) 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 decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

- (1) Cadmium plate (F-15.06) 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 (F-20.03) in the areas shown by flagnote 5.

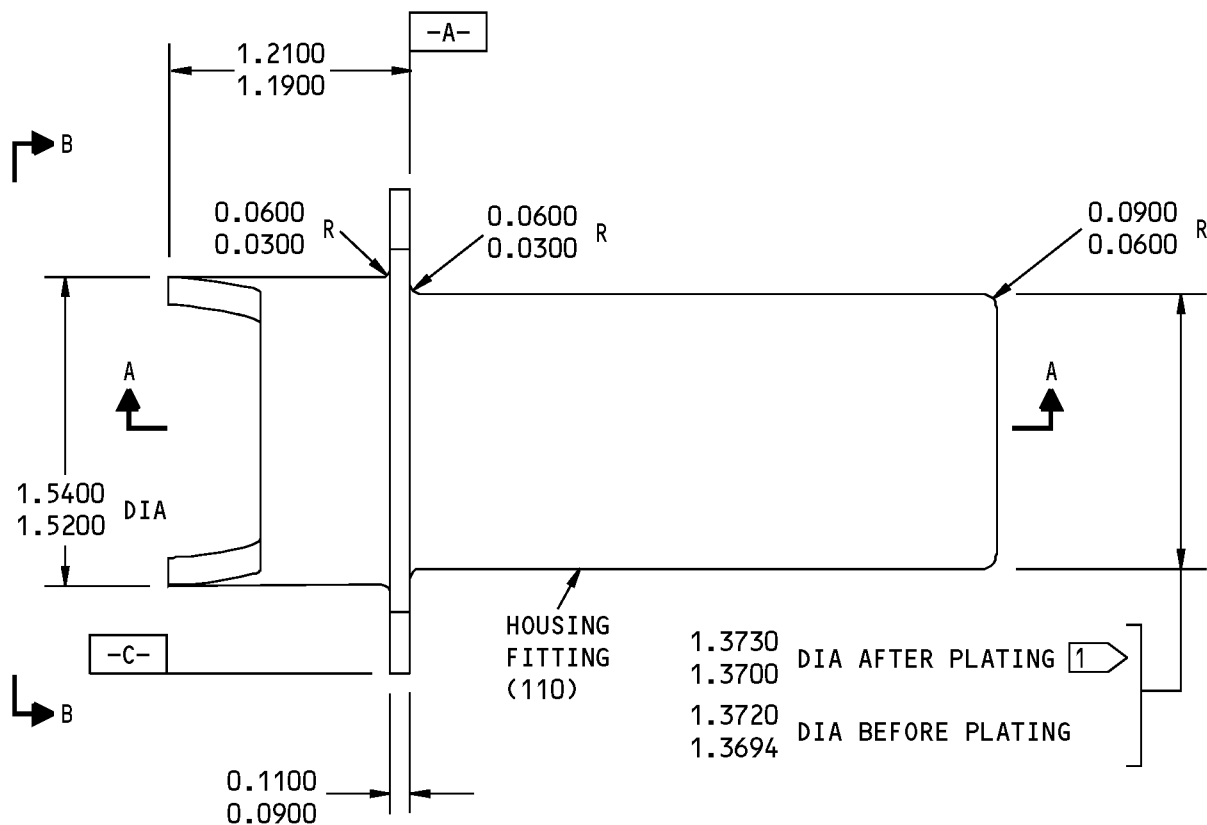
# 52-41-05

REPAIR 22-2

Page 601

Mar 01/2006

COMPONENT MAINTENANCE MANUAL



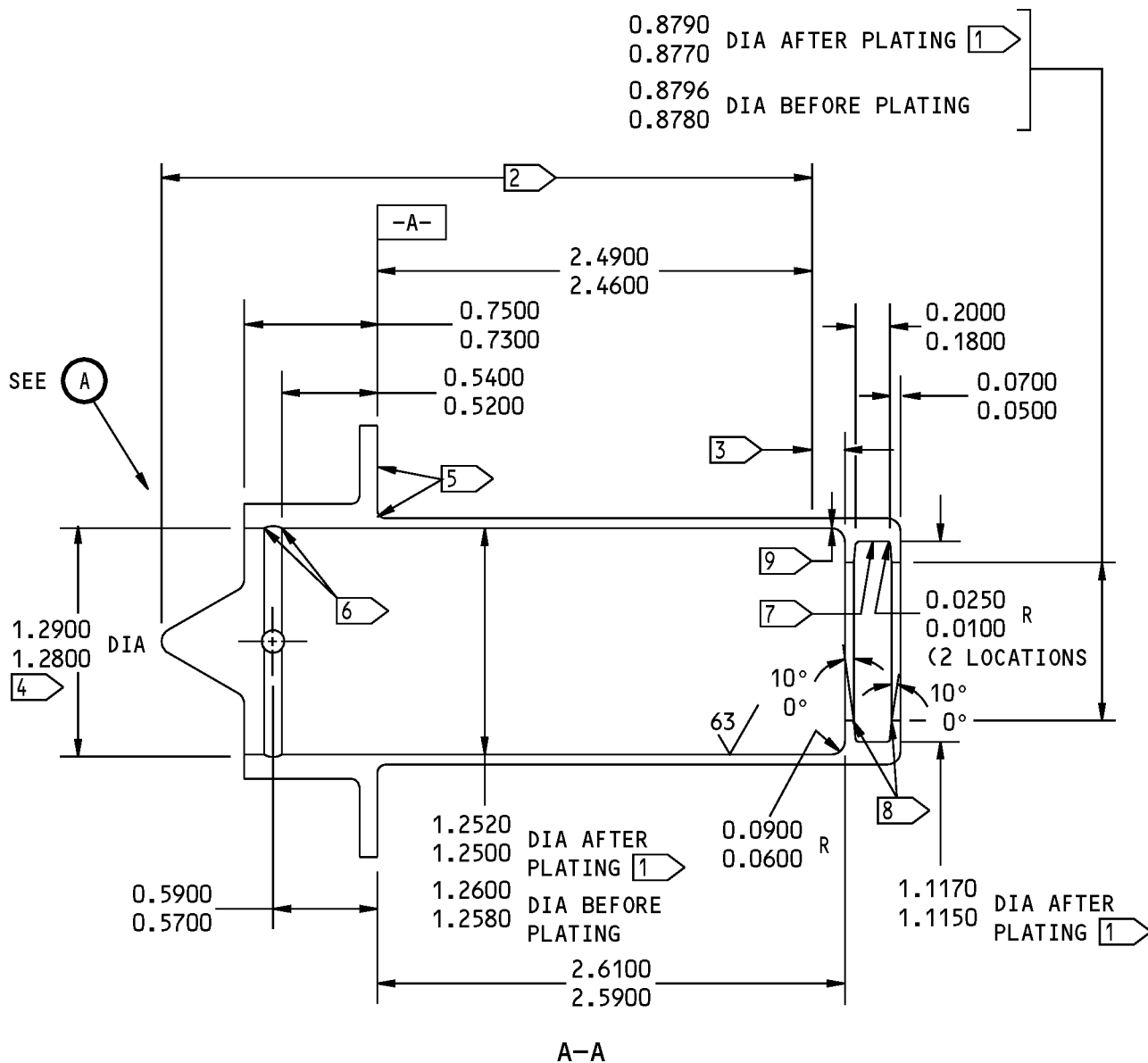
149A6120-2 Handle Mechanism Housing Fitting Refinish  
Figure 601 (Sheet 1 of 3)

**52-41-05**

REPAIR 22-2  
Page 602  
Mar 01/2006



COMPONENT MAINTENANCE MANUAL

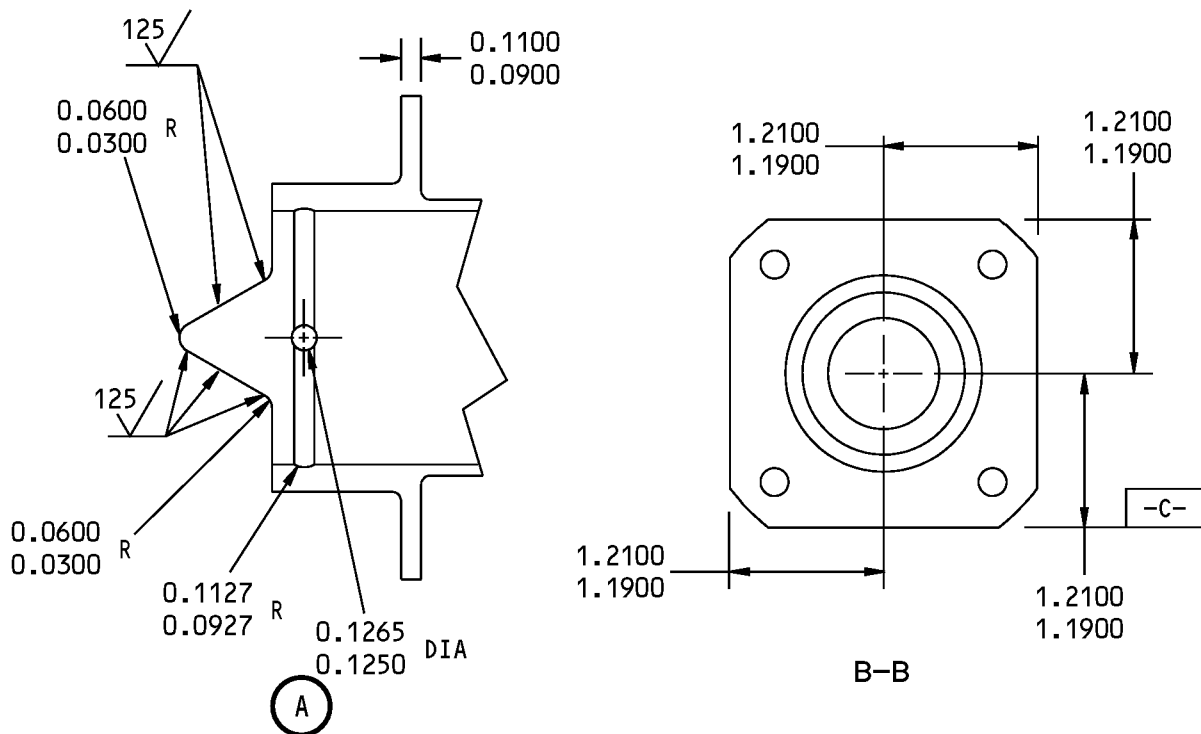


149A6120-2 Handle Mechanism Housing Fitting Refinish  
Figure 601 (Sheet 2 of 3)

**52-41-05**

REPAIR 22-2  
Page 603  
Mar 01/2006

## COMPONENT MAINTENANCE MANUAL



- 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. 8

ALL DIMENSIONS ARE IN INCHES

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

# 52-41-05

REPAIR 22-2

Page 604

Mar 01/2006



## COMPONENT MAINTENANCE MANUAL

### ASSEMBLY

#### 1. General

- A. This procedure has the data necessary to assemble the forward 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
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95
A50113	Adhesive - BMS 5-30	BAC5010 Type 48
B50080	Compound - Corrosion Preventive, Solvent Cutback, Cold-Application (Grade 2 - Soft Film)	MIL-PRF-16173, Grade 2 (Supersedes MIL-C-16173, Grade 2)
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I
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 20-50-01	BOLT AND NUT INSTALLATION
SOPM 20-50-02	INSTALLATION OF SAFETYING DEVICES

# 52-41-05

ASSEMBLY

Page 701

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

Reference	Title
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-50-05	APPLICATION OF ALUMINUM FOIL AND OTHER MARKERS
SOPM 20-50-06	INSTALLATION OF O-RINGS AND TEFLON SEALS
SOPM 20-50-07	LUBRICATION
SOPM 20-50-12	APPLICATION OF ADHESIVES
SOPM 20-50-19	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 decoding table for Boeing finish codes, refer to SOPM 20-41-01. For bolt and nut installation SOPM 20-50-01. For finishing materials, refer to SOPM 20-60-02. For lubricants, refer to SOPM 20-60-03. For miscellaneous materials, refer to SOPM 20-60-04.

- (1) Use standard industry procedures and the steps that follow to assemble this component.
- (2) Install the centering channel assembly (90, IPL Figure 2) and the centering guide assembly (60) on the door structure, as follows:
  - (a) Apply sealant, A00247 fay surface sealant between the mating surfaces of the channel assembly (90), fillers (110, 115), and the door structure.
  - (b) If not done, countersink the holes in the serrated plate (85) to be flush ( $\pm 0.0050$ ) with the bottom of the counterbore.
  - (c) Install the channel assembly (90), fillers (50, 55, 110, 115), and serrated plate (85) on the door structure with the bolts (15) and the nuts (30).
  - (d) Install the guide assembly (60) on the door structure with the bolts (5, 10), and the washers (25).
- (3) Assemble and install the window assembly (485, IPL Figure 1; 1A, IPL Figure 4) on the door structure, as follows:
  - (a) Assemble the window assembly (1A, IPL Figure 4) 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 rubber cement adhesive, A00119 or adhesive, A50113 as specified in SOPM 20-50-12.
    - 2) Put the inner pane (45) into the new seal (40).

# 52-41-05

ASSEMBLY

Page 702

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

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

- 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.
- 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 (20,22), screws (5,7), washers (10,12), and nuts (15,17) 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 to the shims when you get the correct thickness and before installation.
- (b) Install the window assembly (485, IPL Figure 1; 1A, IPL Figure 4) on the door structure with the bolts (465), and the washers (470).
- (c) The outer pane of the window assembly (485) can be 0.0500 inch in or 0.0300 inch out from the outer surface of the doubler (495).
- (4) Install the handle box assembly (785, IPL Figure 1; 1A, IPL Figure 8) on the door structure, as follows:
  - (a) Assemble the external handle (20) 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 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 a 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.

# 52-41-05

ASSEMBLY

Page 703

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

- 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).
    - < 1 > 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) 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) 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).

# 52-41-05

ASSEMBLY

Page 704

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

- c) Apply primer, C00259 (F-20.201) to all areas of the hole of the washer (175).
  - 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 (785, 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 (785, IPL Figure 1), the shims (790, IPL Figure 1), and the door structure.
    - a) Install shims (790, 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 (785, IPL Figure 1) in the door structure with the bolts (775, IPL Figure 1) and the washers (780, IPL Figure 1).
    - a) Install the bolts (775, IPL Figure 1) and the washers (780, IPL Figure 1) with sealant, A00247 as specified in SOPM 20-50-19.
- (d) Install the external handle (20, IPL Figure 8) 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) Fair the external handle (20) with the outer surface of the handle pan (200, IPL Figure 2) as follows:
    - a) Do a check to make sure the external handle (20) is faired with the outer surface of the handle pan (200, IPL Figure 2) within +0.0000 inch or -0.0300 inch.
    - b) Remove or add shims (25, IPL Figure 8) as necessary to get the correct fair.
  - 9) Tighten the nut (40) to 93-110 pound-inches to align the nut clevis to the hole in the shaft (165).
  - 10) Install the cotter pin (765, IPL Figure 1) as specified in SOPM 20-50-02.

# 52-41-05

ASSEMBLY

Page 705

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

- (5) Install the hinge support assemblies (805, 810, IPL Figure 1) as follows:
- If necessary, install the fitting (840, 845) as specified in REPAIR 11-1.
  - 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 (805, 810).
  - Install the hinge support assemblies (805, 810) with bolts (795) and nuts (800).
- (6) Install the torque tube assembly (1A, IPL Figure 7) to the door structure, as follows:
- Apply grease, D00015 to the packing (730, IPL Figure 1).
  - Apply a thin layer of grease, D00015 to all mating surfaces and threads of the door structure, crank (85), and torque tube (90).
  - Put the crank (85) between the bearings (360, IPL Figure 8) in the door structure. Install the torque tube (90) in the door structure through the bearings (360, IPL Figure 8) and the crank (85).
  - Attach the crank (85) to the torque tube (90) with the bolts (70), washers (75) and nuts (80).
    - 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.
    - Substitution of the bolt (70) grip length is not permitted.
  - Apply a thin layer of grease, D00015 to the mating surfaces and threads of the special nuts (65) and the torque tube (90).
  - Install the special nuts (65) on the torque tube (90). Tighten the special nuts (65) to hold the crank (85) in its position between the bearings (360, IPL Figure 8).
  - Apply a thin layer of grease, D00015 to the mating surfaces and threads of the sleeves (55), hinge link pins (60), and the torque tube (90).
  - Install a compression spring (740, IPL Figure 1), washer (735, IPL Figure 1), and packing (730, IPL Figure 1) on each hinge link pin (60).
  - Put the sleeves (55) on the torque tube (90).
  - Put the hinge link pins (60) through the bushings (860, IPL Figure 1) in the door structure.
  - Attach the sleeves (55) and the hinge link pins (60) 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) and the washer (45) is 0.0160 inch. Install more washers if necessary.
  - Apply a thick layer of grease, D00015 to the mating surfaces of the arm assemblies (15, 20) and the hinge link pins (60). When the installation is complete, fill the area between the arm assemblies (15, 20) and the hinge support assemblies (805, 810, IPL Figure 1) with grease, D00015.
  - Install the arm assemblies (15, 20) on the hinge link pins (60) 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 (130, 135, IPL Figure 3) into the door structure.
- Install the lower tube assembly (135, IPL Figure 3), as follows:
    - Move the lower tube (210) into the door structure through the support fitting assemblies (45, 50), housing assemblies (110), latch crank (195), and gate crank (205).

# 52-41-05

ASSEMBLY

Page 706

Nov 01/2008





## COMPONENT MAINTENANCE MANUAL

- 2) Attach the latch crank (195) to the tube assembly (210) with the bolts (175), washers (180), and nuts (185).
- 3) Attach the gate crank (205) to the tube assembly (210) with the bolts (175), washers (180), and nuts (185).
- 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 (210). It is permitted to have one extra spacer on one end of the tube (210) to stay in the tolerance. For some doors (see IPL Figure 3, Item 5) it is permitted to install up to three solid washers (149A6101-1) in place of horseshoe washers (66-15332-1) at each location. Keep a minimum of two horseshoe washers at each location.

- 5) Move the roller cam cranks (170) through the latch roller spacers (5) and the bearing (10) and into the tube (210).
- 6) Attach the roller cam cranks (170) with the bolts (155), washers (160), and nuts (165). Tighten the nuts (165) to 35-45 pound-inches.

**NOTE:** The nut (165) is to tighten on the bolt (155) threads to prevent clamp up. The maximum distance between the tube (210) and the washer (160) is 0.0160 inch. Install more washers if necessary.

- (b) Install the upper tube assembly (130, IPL Figure 3), as follows:

- 1) Move the upper tube (210) into the door structure through the support fitting assemblies (55, 60), housing assemblies (110), latch crank (190), and gate crank (200).
- 2) Attach the latch crank (190) to the tube assembly (210) with the bolts (175), washers (180), and nuts (185).
- 3) Attach the gate crank (200) to the tube assembly (210) with the bolts (175), washers (180), and nuts (185).
- 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 (210). It is permitted to have one extra spacer on one end of the tube (210) to stay in the tolerance. For some doors (see IPL Figure 3, Item 5) it is permitted to install up to three solid washers (149A6101-1) in place of horseshoe washers (66-15332-1) at each location. Keep a minimum of two horseshoe washers at each location.

- 5) Move the roller cam cranks (170) through the latch roller spacers (5) and the bearing (10) and into the tube (210).
- 6) Attach the roller cam cranks (170) with the bolts (155), washers (160), and nuts (165). Tighten the nuts to 35-45 pound-inches.

**NOTE:** The nut (165) is to tighten on the bolt threads to prevent clamp up. The maximum distance between the tube (210) and the washer (160) is 0.0160 inch. Install more washers if necessary.

- (8) Install the upper and lower control rod assemblies (690, 695, IPL Figure 1) to the door structure, as follows:

**NOTE:** The length of the control rod assemblies (690, 695) will be adjusted in the door assembly adjustment instructions (par. 2.D(12)).

# 52-41-05

ASSEMBLY

Page 707

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

- (a) Put the control rod assembly (690) between the clevis of the latching crank assembly (300, IPL Figure 8) and the clevis of the latch crank (190, IPL Figure 3).
  - (b) Attach the control rod assembly (690) with the bolts (665), washer (675, 680) and nut (685).
  - (c) Put the control rod assembly (695) between the clevis of the latching crank assembly (300, IPL Figure 8) and the clevis of the latch crank (195, IPL Figure 3).
  - (d) Attach the control rod assembly (695) with the bolts (665, 670), washers (675, 680) and nut (685).
- (9) Install the upper and lower end gate assemblies (595, 600, IPL Figure 1) to the door structure:
- (a) Install the upper end gate assembly (595, IPL Figure 1) to the door structure, as follows:
    - 1) Apply sealant, A00247 surface sealant as specified in SOPM 20-50-19 to the mating surfaces of the hinge assembly (625) and the door structure.

**CAUTION:** THERE CAN BE NO BURRS ON THE BOLT HEADS (605) AFTER INSTALLATION.

    - 2) Put and align the hinge half (645) of the hinge assembly (625) on the edge of the door structure beam. Align each end of the hinge assembly (625) to be flush (within  $\pm 0.0200$  inch) with the edge of the door structure beam.
    - 3) Install the upper gate assembly (595, IPL Figure 1) on the door structure with the bolts (605) and the washers (610).
  - (b) Install the lower end gate assembly (600, IPL Figure 1) on the door structure, as follows:
    - 1) Apply sealant, A00247 surface sealant as specified in SOPM 20-50-19 to the mating surfaces of the hinge assembly (630) and the door structure.

**CAUTION:** THERE CAN BE NO BURRS ON THE BOLT HEADS (605) AFTER INSTALLATION.

    - 2) Put and align the hinge half (650) of the hinge assembly (630) on the edge of the door structure beam. Align each end of the hinge assembly (630) to be flush (within  $\pm 0.0200$  inch) with the edge of the door structure beam.
    - 3) Install the lower gate assembly (600, IPL Figure 1) on the door structure with the bolts (605) and the washers (610).
- (10) Use door seal installation tool, door seal installation tool, SPL-1981, to install the seal (IPL Figure 1,585) and nylon rod (580) onto the door structure, as follows:
- (a) Install the seal (585) with soap lubricant as specified in SOPM 20-50-07. Install the seal with the label TOP on the topside 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 (585) and the nylon rod (580) onto the hinge assembly (625, 630) with soap lubricant as specified in SOPM 20-50-07. Install the nylon rod (580) at each end of the hinge assembly (625, 630) to form a butt-fit at the center of the door structure. If necessary, trim the unwanted nylon rod (580).
- (11) Install the upper and lower control rod assemblies (540, 545, IPL Figure 1) on the door structure, as follows:
- (a) Put the control rod assembly (540) between the clevis of the upper end gate assembly (595, IPL Figure 1) and the arm of the gate crank assembly (200, IPL Figure 3).

# 52-41-05

ASSEMBLY

Page 708

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

- (b) Attach the control rod assembly (540) with the bolts (500, 505), washer (515, 520, 525) and nuts (530, 535).
  - (c) Put the control rod assembly (545) between the clevis of the lower end gate assembly (600, IPL Figure 1) and the clevis of the gate crank (205, IPL Figure 3).
  - (d) Attach the control rod assembly (545) with the bolts (500, 510), washers (515, 520, 525) and nuts (530, 535).
- (12) Install the cover plates (265, 270, 275, IPL Figure 1), the retainer (330), and the stops (215) on the door structure, as follows:
- (a) Install the cover plate (265) as follows:
    - 1) Apply a parting agent to the mating surfaces of the cover plate (265) as specified in SOPM 20-50-19.
    - 2) Apply a pressure face 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 (265) onto the door structure with the bolts (225) and the washers (230).

**NOTE:** Grip length is important. It is not permitted to use a bolt with a grip length different than bolt (225).
  - (b) Install the cover plate (270) onto the door structure with the bolts (225) and the washers (230).
  - (c) Install the cover plate (275) on the door structure with the bolts (225) and the washers (230).
  - (d) Install the retainer (330) on the door structure as specified in SOPM 20-50-22 with the studs (310), washers (315, 320), and rings (325).
  - (e) Install the stops (210, 215) on the door structure with the bolts (195), washers (200), and nuts (205).
- (13) Adjust the door assembly mechanism as follows:
- (a) With the control rod assemblies (690, 695, IPL Figure 1) not connected to the cranks (190, 195, IPL Figure 3), install the setting tool, 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 (130, 135, IPL Figure 3) until the bearings (150) touch the setting blocks on the tool. Tighten the tool clamps. Make sure that the bearings (150) touch the blocks on the tool.
  - (d) Turn the handle (20, IPL Figure 8) to the closed position. The bearing (345, IPL Figure 8) on the latching crank assembly (300, IPL Figure 8) must bottom out in the cam plate assembly (60, IPL Figure 8). Secure the handle (20, IPL Figure 8) in this position.
  - (e) Adjust the lengths of the control rod assemblies (690, 695, IPL Figure 1) to align the rod ends with the holes in the latching cranks (190, 195, IPL Figure 3).

# 52-41-05

ASSEMBLY

Page 709

Mar 01/2009



## COMPONENT MAINTENANCE MANUAL

- (f) Attach the control rod assemblies (690, 695, IPL Figure 1) to the latching cranks (190, 195, IPL Figure 3) with the bolts (665, IPL Figure 1), washers (675, 680, IPL Figure 1), and nuts (685, IPL Figure 1).
- (g) With the control rod assemblies (540, 545, IPL Figure 1) not connected to the clevis assemblies (25, IPL Figure 5; 30, IPL Figure 6), hold the upper and lower gate assemblies (595, 600, IPL Figure 1) in the door closed position.
- (h) Adjust the lengths of the control rod assemblies (540, 545, IPL Figure 1) to align the rod ends with the holes in the clevis assemblies (25, IPL Figure 5; 30, IPL Figure 6).
- (i) Attach the control rod assemblies (540, 545, IPL Figure 1) to the clevis assemblies (25, IPL Figure 5; 30, IPL Figure 6) with the bolts (500, IPL Figure 1), washers (515, 520, IPL Figure 1), bushings (517, IPL Figure 1), and nuts (520, IPL Figure 1).
- (j) Tighten the nuts (550, 705, IPL Figure 1) on the control rod assemblies (540, 545, 690, 695, IPL Figure 1).
- (k) Attach the handle mechanism control rod (180, IPL Figure 8) to the torque tube crank (85, IPL Figure 7) with bolt (745, IPL Figure 1), washer (750, IPL Figure 1) and nut (755, IPL Figure 1).
  - 1) Install bolt (745, IPL Figure 1), washer (750, IPL Figure 1) and nut (755, IPL Figure 1) with grease, D00015 as specified in SOPM 20-50-03.
  - 2) The bolt (745, IPL Figure 1) direction is important to prevent interference.
  - 3) The bolt head must be at the bottom of the torque tube crank (85, IPL Figure 7).
- (l) Remove the setting tool, F80178-1, from the door assembly.
- (14) If necessary, install the plate (200, IPL Figure 3) and the marker (215, IPL Figure 3) to the door structure as specified in SOPM 20-50-05.

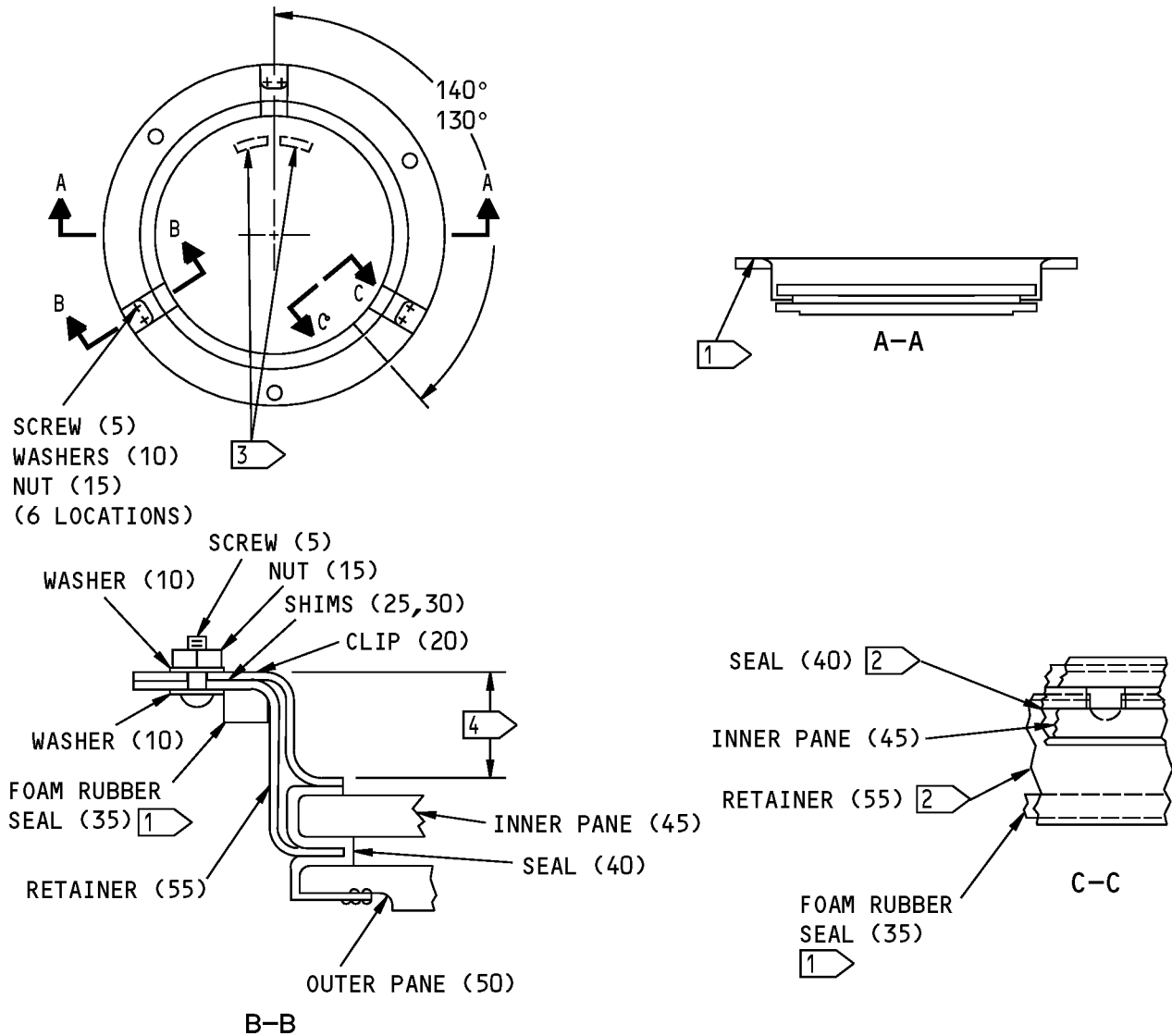
# 52-41-05

ASSEMBLY

Page 710

Nov 01/2008

## COMPONENT MAINTENANCE MANUAL



- 1 ATTACH THE SEAL (35) WITH BMS 5-55 RUBBER CEMENT
- 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)

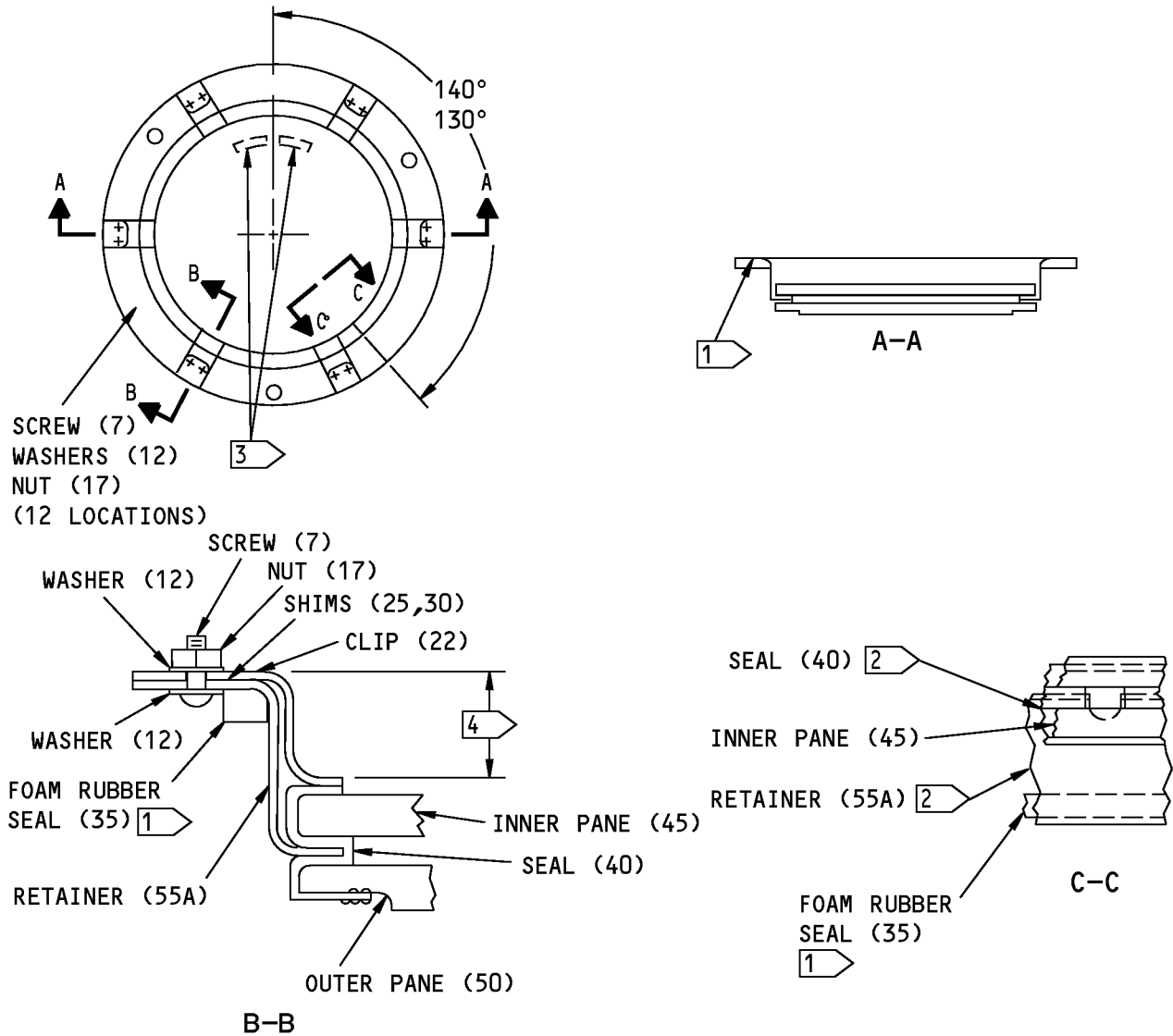
ITEM NUMBERS REFER TO IPL FIG. 4  
ALL DIMENSIONS ARE IN INCHES

Observation Window Assembly  
Figure 701 (Sheet 1 of 2)

# 52-41-05

ASSEMBLY  
Page 711  
Nov 01/2008

COMPONENT MAINTENANCE MANUAL



- 1 ATTACH THE SEAL (35) WITH BMS 5-55 OR BMS 5-30 RUBBER CEMENT
- 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. 4  
ALL DIMENSIONS ARE IN INCHES

0141A6570-1

1596391 S0000296173\_V1

Observation Window Assembly  
Figure 701 (Sheet 2 of 2)

**52-41-05**

ASSEMBLY  
Page 712  
Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

### FITS AND CLEARANCES

REF IPL		NAME	TORQUE*	
FIG. NO.	ITEM NO.		POUND-INCHES	POUND-FEET
1	550	Nut	60 MAX	
1	705	Nut	60 MAX	
2	65	Nut	100-150	
3	140	Nut	65-90	
3	165	Nut	35-45	
5	20	Nut	25-30	
6	5	Bolt	25-30	
7	50	Nut	30-40	
8	40	Nut	93-110	

\* REFER TO SOPM 20-50-01 FOR TORQUE VALUES OF STANDARD FASTENERS.

Torque Table  
Figure 801

**52-41-05**  
FITS AND CLEARANCES  
Page 801  
Mar 01/2006



## COMPONENT MAINTENANCE MANUAL

### SPECIAL TOOLS, FIXTURES, AND EQUIPMENT

#### 1. General

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

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

#### Special Tools

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

# 52-41-05

SPECIAL TOOLS, FIXTURES, AND EQUIPMENT

Page 901

Mar 01/2009





## COMPONENT MAINTENANCE MANUAL

### ILLUSTRATED PARTS LIST

#### 1. Introduction

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

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

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

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1001

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

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

### VENDOR CODES

Code	Name
02758	NETWORKS ELECTRONIC CORP U S BEARING DIV 9750 DE SOTO AVENUE CHATSWORTH, CALIFORNIA 91311-4409 FORMERLY U S BEARING DIV NETWORKS ELEC CORP
06710	LAMSON AND SESSIONS CO THE VALLEY-TODECO 12975 BRADLEY AVENUE SYLMAR, CALIFORNIA 91342-3830 FORMERLY VALLEY BOLT CORP VB0097 IN NORTH HOLLYWOOD, CA
06725	AIR INDUSTRIES CORPORATION 12570 KNOTT STREET GARDEN GROVE, CALIFORNIA 92641-3932 FORMERLY AIR INDUSTRIES OF CALIF IN GARDENA, CALIF.
07484	ACCURATE BUSHING CO INC 443 NORTH AVENUE GARWOOD, NEW JERSEY 07027-1014 FORMERLY V83132 SMITH BRG DIV OF ACCURATE BUSHING CO
09455	RBC TRANSPORT DYNAMICS CORP 3131 W SEGERSTROM AVE SANTA ANA, CALIFORNIA 92704-5872 FORMERLY TRANSPORT DYNAMICS AEROSPACE DIV; FABROID DIV TRANSPORT DYNAMICS V17571 & LEAR SEIGLER INC TRANSPORT DIV V98076; FORMERLY BFM TRANSPORT DYNAMICS
0HDW7	HUCK MFG CO 3724 EAST COLUMBIA STREET TUCSON, ARIZONA 85714

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1002

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

Code	Name
0PTK6	SPS TECHNOLOGIES INC AEROSPACE PRODUCTS DIV 5195 W 4700 SALT LAKE CITY, UTAH 94118 SEE V56878 SPS TECHNOLOGIES INC
11815	CHERRY AEROSPACE FASTENERS DIV OF TEXTRON 1224 EAST WARNER AVENUE PO BOX 2157 SANTA ANA, CALIFORNIA 92707-0157 FORMERLY IN LOS ANGELES, CALIF , FORMERLY CHERRY FASTENERS TOWNSEND DIV OF TEXTRON INC V71087
11960	KIRKHILL - TA HANKON DIV 336 WEIR ST P. O. BOX 1091 TAUNTON, MASSACHUSETTS 02780 FORMERLY HERCULES INC & HAVEG & BURKE INC HASKON DIV
15653	ALCOA GLOBAL FASTENERS INC DIV KAYNAR PRODUCTS 800 S STATE COLLEGE BLVD FULLERTON, CALIFORNIA 92831-3001 FORMERLY VK6405 MICRODOT AEROSP LTD; FORMERLY KAYNAR TECH FORMERLY FAIRCHILD FASTENERS KAYNAR DIV
15656	NATIONAL-STANDARD CO PERFORATED METALS PLANT 166 DUNDAFF ST, PO DRAWER 507 CARBONDALE, PENNSYLVANIA 18407-1565 FORMERLY NATIONAL-STANDARD CO CROSS PERFORATED METALS PLANT
15860	NEW HAMPSHIRE BALL BEARINGS, INC ASTRO DIVISION 155 LEXINGTON AVENUE LACONIA, NEW HAMPSHIRE 03246-2937 FORMERLY ASTRO BEARING CORP, LOS ANGELES, CALIF.
16476	MAXIMA TECHNOLOGIES INC DBA DATON INSTRUMENTS COMPANY 1811 ROHRERSTOWN RD FORMERLY DATCON INSTRUMENTS CO.
16746	SPECLINE INCORPORATED 2230 MOUTON DR CARSON CITY, NV 89706 FORMERLY IN SUN VALLEY, CAIFORNIA

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1003

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

Code	Name
17446	HUCK INTL INC AEROSPACE FASTENER DIV 900 WATSON CENTER ROAD CARSON, CALIFORNIA 90745-4201 FORMERLY V32134 REXNORD INC; FORMERLY V97928 HUCK INTL
21335	TIMKEN US CORPORATION DIV FAFNIR 336 MECHANIC STREET LEBANON, NH 03766-0267 FORMERLY FAFNIR BRG AND TEXTRON INC FAFNIR DIV IN NEW BRITAIN, CONNECTICUT ; FORMERLY TORRINGTON CO THE SPECIAL PRODUCTS DIV SUB OF THE INGERSOLL-RAND CO V8D210 FORMERLY TORRINGTON CO FAFNIR BEARING DIV IN TORRINGTON, CT
21760	SCHATZ BEARING CORP 10 FAIRVIEW AVENUE PO BOX 1191 POUGHKEEPSIE, NEW YORK 12601-1312 FORMERLY FEDERAL BRG CO AND SCHATZ MFG CO V53268 FORMERLY SCHATZ MFG CO
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
50294	NEW HAMPSHIRE BALL BEARINGS, INC PRECISION DIVISION 9700 INDEPENDENCE AVENUE CHATSWORTH, CALIFORNIA 91311 FORMERLY NIPPON MINATURE BEARING CORP V23589 AND NMB AMERICA INC AND NMB INC
50632	KAMATICS CORP SUB OF KAMAN CORP 1335 BLUE HILLS ROAD BLOOMFIELD, CONNECTICUT 06002-1304
52828	REPUBLIC FASTENER MFG CORP 1300 RANCHO CONEJO BLVD NEWBURY PARK, CALIFORNIA 91320-1405 FORMERLY IN SYLMAR, CALIFORNIA

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1004

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

Code	Name
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
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

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1005

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

Code	Name
72962	HARVARD INDUSTRIES INC 3 WERNER WAY SUITE 210 LEBANON, NEW JERSEY 08833 FORMERLY ESNA V7A079 FORMERLY ELASTIC STOP NUT IN UNION, NJ
73134	ROLLER BEARING COMPANY OF AMER DBA HEIM BEARINGS DIV 60 ROUND HILL RD FAIRFIELD, CONNECTICUT 06430-0000 FORMERLY INCOM INTL HEIM DIV; HEIM UNIVERSAL CORP INCOM; FORMERLY HEIM DIV INCOM INTL; IMO IND HEIM BEARINGS DIV
73197	HI-SHEAR TECHNOLOGY CORP 2600 SKYPARK DRIVE TORRANCE, CALIFORNIA 90509
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

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1006

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

Code	Name
83086	NEW HAMPSHIRE BALL BEARING, INC HITECH DIVISION 172 JAFFREY ROAD PETERBOROUGH, NEW HAMPSHIRE 03458
92215	FAIRCHILD IND INC FAIRCHILD AEROSPACE FASTENER DIV 3010 W LOMITA BLVD TORRANCE, CALIFORNIA 90505-5102 FORMERLY VOI-SHAN IN CULVER CITY, CALIF
92563	MCGILL MFG CO INC BEARINGS DIV 909 LAFAYETTE STREET VALPARAISO, INDIANA 46383-4210
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

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1007

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

### NUMERICAL INDEX

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
10-60476-13		1	585B	1
10-60476-3		1	585	1
10-60779-112		8	195	2
102A9213-2-3		1	255	4
		1	395	6
102A9213-4-3		2	45	1
102F177-3		6	45	2
102F177-4		8	380	12
102F9201-4		1	65	2
		1	95	1
		1	150	1
102F9207P3		2	100	2
102F9216-2-3		1	250	5
		1	400	2
102F9219-3		1	390	7
		1	430	4
		1	620	21
102F9220-3		1	405	1
10E4-116		1	555	1
		1	710A	1
		1	715	1
10E4-116NW		1	555	1
		1	710A	1
		1	715	1
140N2020-1		1	890	1
140N2021-1		1	940	1
		2	430	1
140N2022-1		1	875	2
140N2022-2		1	895	1
140N2022-3		1	885	1
140N2022-4		1	880	1
141A6516-10		1	1L	RF
		2	1L	RF
		3	1L	RF

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1008

Mar 01/2006





## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
141A6516-11		1	1M	RF
		2	1M	RF
		3	1M	RF
141A6516-12		1	1N	RF
		2	1N	RF
		3	1N	RF
141A6516-13		1	1P	RF
		2	1P	RF
		3	1P	RF
141A6516-14		1	1Q	RF
		2	1Q	RF
		3	1Q	RF
141A6516-15		1	1R	RF
		2	1R	RF
		3	1R	RF
141A6516-16		1	1S	RF
		2	1S	RF
		3	1S	RF
141A6516-17		1	1T	RF
		2	1T	RF
		3	1T	RF
141A6516-18		1	1U	RF
		2	1U	RF
		3	1U	RF
141A6516-19		1	1V	RF
		2	1V	RF
		3	1V	RF
141A6516-2		1	1F	RF
		2	1F	RF
		3	1F	RF
141A6516-20		1	1W	RF
		2	1W	RF
		3	1W	RF
141A6516-21		1	1X	RF
		2	1X	RF

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1009

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
141A6516-3		3	1X	RF
		1	1G	RF
		2	1G	RF
141A6516-4		3	1G	RF
		1	1H	RF
		2	1H	RF
141A6516-7		3	1H	RF
		1	1E	RF
		2	1E	RF
141A6516-8		3	1E	RF
		1	1J	RF
		2	1J	RF
141A6516-9		3	1J	RF
		1	1K	RF
		2	1K	RF
141A6517-1		3	1K	RF
		1	760	1
		7	1A	RF
141A6517-2		1	760A	1
		7	1B	RF
141A6519-1		7	90	1
141A6521-2		1	785	1
		8	1A	RF
141A6525-1		1	925	1
141A6525-2		1	950	1
141A6525-3		1	945	1
141A6526-1		1	805	1
141A6526-2		1	810	1
141A6527-1		1	850	1
141A6527-2		1	855	1
141A6527-3		1	865	1
141A6527-4		1	870	1
141A6531-1		1	630	1
141A6531-2		1	625	1
141A6531-3		1	650	1

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1010

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
141A6531-4		1	645	1
141A6531-5		1	660	1
141A6531-6		1	655	1
141A6531-7		1	630A	1
141A6531-8		1	650A	1
141A6534-1		2	175	1
141A6534-10		6	70	1
141A6534-11		6	65	1
141A6534-12		6	60	1
141A6534-13		6	75	1
141A6534-14		5	65	1
141A6534-2		2	170	1
141A6534-3		2	165	1
141A6534-4		5	50	1
141A6534-5		5	55	1
141A6534-6		5	60	1
141A6534-7		2	180	1
141A6534-8		2	185	1
141A6534-9		2	190	1
141A6535-1		2	835	1
141A6535-11		2	520A	1
141A6535-12		2	340A	1
141A6535-4		2	635	1
141A6535-5		2	520	1
141A6535-6		2	415	1
141A6535-8		2	340	1
141A6535-9		2	740	1
141A6536-11		2	895	1
141A6536-12		2	830	1
141A6536-13		2	825	1
141A6536-14		2	735	1
141A6536-15		2	630	1
141A6536-16		2	515	1
141A6536-17		2	410	1
141A6536-19		2	405A	1

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1011

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
141A6538-1		2	870	1
141A6538-10		2	485	1
141A6538-11		2	380	1
141A6538-12		2	385	1
141A6538-13		2	885	1
141A6538-14		2	890	1
141A6538-16		2	805	1
141A6538-17		2	620	1
		2	725	1
141A6538-18		2	730	1
141A6538-2		2	875	1
141A6538-20		2	625	1
141A6538-21		2	495	1
141A6538-22		2	500	1
141A6538-23		2	395	1
141A6538-24		2	400	1
141A6538-25		2	795	1
141A6538-26		2	810	1
141A6538-4		2	790	1
141A6538-5		2	605	1
		2	710	1
141A6538-6		2	715	1
141A6538-8		2	610	1
141A6538-9		2	480	1
141A6540-1		1	600	1
		6	1A	RF
141A6540-2		1	595	1
		5	1A	RF
141A6540-3		1	600A	1
		6	1B	RF
141A6540-4		1	595A	1
		5	1B	RF
141A6541-1		6	15	1
141A6541-2		5	25	1
141A6541-3		6	30	1

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1012

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
141A6541-4		5	40	1
141A6542-1		6	80	1
141A6542-2		6	90	1
141A6542-4		6	80A	1
141A6542-5		6	90A	1
141A6543-1		5	70	1
141A6543-3		5	70A	1
141A6545-1		3	135	1
141A6545-2		3	130	1
141A6546-1		3	45	1
141A6546-10		3	50A	1
141A6546-11		3	75A	1
141A6546-12		3	60A	1
141A6546-13		3	85A	1
141A6546-2		3	50	1
141A6546-3		3	55	1
141A6546-4		3	60	1
141A6546-5		3	70	1
141A6546-6		3	75	1
141A6546-7		3	80	1
141A6546-8		3	85	1
141A6547-1		2	90	1
141A6547-2		2	105	1
141A6548-1		2	85	1
141A6549-1		2	60	1
141A6549-2		2	80	1
141A6552-1		1	420	1
141A6552-2		1	415	1
141A6552-3		1	460	1
141A6552-4		1	455	1
141A6552-5		1	450	1
141A6553-2		1	275	1
141A6553-3		1	270	1
141A6553-5		1	265	2
141A6553-6		1	275A	1

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1013

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
141A6554-1		2	200	1
141A6558-1		1	305	1
141A6558-2		1	330	1
141A6570-1		1	485A	1
		4	1B	RF
141A6571-1		4	50A	1
141A6571-2		4	45A	1
141A6572-1		4	55A	1
141A6573-1		4	22	6
141A6574-1		4	40A	1
141A6575-1		4	35A	1
147A6120-3		3	90A	AR
149A6101-1		3	5B	AR
149A6107-1		8	365	1
149A6107-4		8	410	1
149A6109-1		8	130	1
149A6110-1		7	55	2
149A6112-3		1	495	1
149A6113-1		6	35	2
149A6113-3		6	50	1
149A6114-1		2	545	1
		2	660	1
149A6116-2		2	670	2
149A6116-3		2	555	2
149A6120-1		8	100	1
149A6120-2		8	110	1
149A9480-1		1	190	1
149A9480-38		1	215	1
149A9480-4		1	55	1
149A9480-47		1	75	1
149A9480-48		1	210	1
149A9480-51		1	220	1
149A9480-57		1	130	1
149A9480-58		1	185	1
149A9480-61		1	80	1

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1014

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
149A9480-62		1	135	1
149A9480-63		1	125	1
149A9480-64		1	180	1
149A9480-65		1	100	1
149A9480-66		1	155	1
30-3010		8	150	1
30-3013-2		8	160	1
30-3019-1		8	140	1
30-3035		8	25	11
3SLCC10		2	370	1
3SLCC100GC		2	370	1
3SLCC6		2	475	6
		2	475	6
		2	595A	2
		2	595A	2
		2	600	4
		2	600	4
		2	705	6
		2	705	6
		2	785	6
		2	785	6
3SLCC8		2	375	7
		2	375	7
		2	470	7
		2	470	7
		2	590	5
		2	590	5
		2	595	2
		2	595	2
		2	700	5
		2	700	5
		2	780	7
		2	780	7
		2	865	14
		2	865	14

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1015

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
51564-0402		1	565A	1
		1	710	1
51588-041		1	555	1
		1	710A	1
		1	715	1
5164-0402DD		1	565	1
55001		3	10	4
		3	120	1
55282		3	202	1
60-4405-1		7	65	2
60-4406-15		3	210	1
60-4409-2		3	205	1
60-4412-2		2	210	1
60-4431-4		3	201	1
60-4431-5		3	200	1
60-4455-3		8	165	1
63-1478-1		4	20	3
63-1692-1		8	255	2
63-2848		8	155	1
63-9386-1		8	50	1
65-1933-23		8	275	1
65-1933-24		8	290	1
65-2306-10		3	125	1
65-2306-9		3	110	4
65-2863-8		1	485	1
		4	1A	RF
65-28925-102		1	720A	1
65-28925-103		1	725A	1
65-28925-43		1	720	1
65-28925-44		1	725	1
65-28925-83		1	690	1
65-28925-84		1	695	1
65-28925-98		1	690A	1
65-28925-99		1	695A	1
65-44065-11		8	75	1

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1016

Nov 01/2008





## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
65-44065-12		8	85	1
65-44065-13		8	85A	1
65-45871-504		1	580	8
65-52452-1		2	215	1
65-54013-502		8	315	1
65-54013-503		8	300	1
65-73978-11		7	30A	1
65-73978-14		7	35A	1
65-73978-2		7	20	1
65-73978-4		7	35	1
65-73978-7		7	15	1
65-73978-9		7	30	1
65-8795-501		8	295	1
65C36793-1		8	395	2
66-12688-11		2	390	1
		2	490	1
		2	615	1
		2	720	1
		2	800	1
		2	880	1
		6	85	2
66-14527-8		7	60	2
66-14531-12		3	195	1
66-14531-14		3	190	1
66-14618-13		1	570	1
66-14618-5		1	575	1
66-15332-1		3	5	AR
		3	5A	AR
66-15645-1		1	740	2
66-1921-2		4	40	1
66-2646		4	35	1
66-9776		1	70	2
69-1083-2		4	45	1
69-1084-2		4	50	1
69-17330-3		7	85	1

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1017

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
69-17330-5		7	85A	1
69-18187-21		1	545	1
69-18187-27		1	540	1
69-1983-7		4	55	1
69-34971-11		8	60	1
69-34971-2		8	70	1
69-37418-11		3	170	2
69-39176-1		8	180	1
69-39176-2		8	200	1
69-70269-3		1	840	1
69-70269-4		1	845	1
69-78694-3		8	385	4
69-78694-4		8	390	4
69B10068-3		8	235	2
77253		8	195	2
81669V10K6		2	355	1
81669V5K6		2	570A	1
		2	585	1
		2	695	2
81669V6K4		2	465	3
		2	580	3
		2	685	3
		2	775	3
81669V6K6		2	690	1
81669V6K8		2	455	2
		2	460	1
		2	575A	1
		2	770	3
81669V8K4		2	450	3
		2	560	4
		2	675	4
		2	765	3
81669V8K5		2	365	2
		2	680	1
		2	750	1

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1018

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
81669V8K6		2	860	4
		2	360	5
		2	440	1
		2	565	1
		2	760	1
		2	855	4
81669V8K7		2	445	1
		2	570	1
		2	745	1
		2	850	6
81669V8K8		2	435	2
		2	575	1
		2	755	1
82-99-341-26		1	310	4
90-7811		8	35	1
90-7815-25		8	320	1
90-7815-26		8	325	1
90-7815-29		8	350	1
90-7815-30		8	355	1
90-7821-1		8	30	1
90-7879-10		8	20	1
9554		1	585B	1
AB4E27FN		1	565A	1
		1	710	1
AB4E27FN12		1	565	1
ABW16-101		3	10	4
		3	120	1
ABW4V5		3	202	1
		3	202	1
ACMKP12AP510Y19		8	125	1
ACMKP21BSP510LY		8	270	2
ACMKP23BSP510LY		8	240	2
ACMKP25BP26LY19		8	360	2
ACMKP25BP510LY1		8	360	2
ACMKP25P26LY198		8	360	2

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1019

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
ADNE5-202		8	195	2
AF3253-4-4B		5	45	27
		6	55	28
AF5141-3C		2	535A	20
		2	650A	20
AN316-5R		1	550	1
		1	705	2
AN316-6R		8	190	1
AN996-14		8	145	1
AR4E4FN		1	565A	1
		1	710	1
AR4E4FN12		1	565	1
AR4E7AFNW		1	555	1
		1	710A	1
		1	715	1
ARB4E60FNW		1	555	1
		1	710A	1
		1	715	1
ARHT5E102		8	195	2
ASM4F6		1	565A	1
		1	710	1
ASM4F6DM		1	565	1
ASMK4F1		1	555	1
		1	710A	1
		1	715	1
ASSB16-19		3	10	4
		3	120	1
AW4VCRG		3	202	1
BAC27DBY191		3	215	1
BACB10A187L		1	565A	1
		1	710	1
BACB10A187M2L		1	565	1
BACB10A397GCM2		3	10	4
		3	120	1
BACB10AB4		3	202	1

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1020

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACB10FK5F9HS		2	75	1
		3	150	2
		8	360	2
BACB10FR25		8	360	2
BACB10FS12		8	125	1
BACB10FV21		8	270	2
BACB10FV23		8	240	2
BACB10Y4		1	555	1
		1	710A	1
		1	715	1
BACB28AK04-030		1	512	2
BACB28X4M014		5	35	1
		6	25	1
BACB28X6M014		5	30	1
		6	20	1
BACB30NM3K11		7	5	4
		7	5	4
		8	205	1
		8	205	1
		8	90	4
BACB30NM3K13		3	155	4
BACB30NM3K17		3	175	4
BACB30NM3K19		1	465	3
BACB30NM3K3		3	95	16
		2	525	10
		2	640	10
BACB30NM3K5		2	5	1
		8	220	1
BACB30NM3K7		1	820	4
BACB30NM3K8		2	10	2
		5	5	4
		6	5	4
		1	510	1
BACB30NM4K13		1	665	2
		1	505	1
BACB30NM4K14		1	505	1
BACB30NM4K16		1	500	2

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1021

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACB30NM4K17		1	775	12
BACB30NM5K15		1	745	1
BACB30NN3K11		8	5A	4
BACB30NR4K13		1	670	2
BACB30NR4K6		8	245	2
BACB30NR5K17		8	170	1
BACB30NT3K1		1	105	3
		1	160	3
BACB30NT3K16		1	195	2
BACB30NT3K4		1	605	21
BACB30PU4-25		7	40	8
BACB30PU5-28		7	70	2
BACB30VF08K4		3	20	2
BACB30VF3K11		8	210	1
BACB30VF3K4		2	220	8
		3	15	14
BACB30VF3K6		2	15	2
BACB30VF3K7		8	215	1
BACB30VN10K6		2	355	1
BACB30VN6K4		2	465	3
		2	580	3
		2	685	3
		2	775	3
BACB30VN6K6		2	690	1
BACB30VN6K7		2	570A	1
		2	585	1
		2	695	2
BACB30VN6K8		2	455	2
		2	575A	1
		2	770	3
BACB30VN6K9		2	460	1
BACB30VN8K4		2	450	3
		2	560	4
		2	675	4
		2	765	3

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1022

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACB30VN8K5		2	365	2
		2	680	1
		2	750	1
		2	860	4
BACB30VN8K6		2	360	5
		2	440	1
		2	565	1
		2	760	1
BACB30VN8K7		2	855	4
		2	445	1
		2	570	1
		2	745	1
BACB30VN8K8		2	850	6
		2	435	2
		2	575	1
		2	755	1
BACB30VT6K3		1	795	28
		2	280	44
BACB30VT6K4		1	345	4
		2	275	9
BACB30VT6K5		1	5	3
		1	25	1
		1	350	1
		2	20	2
		2	270	4
BACB30VT8K4		2	240	4
BACB30VT8K6		2	245	2
BACB30VT8K7		2	250	1
BACB30VT8K8		2	255	1
BACB30VU5K5		2	140	1
BACB30VU5K6		2	135	2
BACB30VU6K3		2	285	16
		2	310	8
BACB30VU6K4		1	900	4
		2	305	72

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1023

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACB30VU6K5		2	125	3
		2	290	2
		2	315	12
BACB30VU6K6		2	130	4
BACB30VU6K7		2	120	2
BACB30VU8K6		2	235	4
BACB30YP6K4		1	900A	4
BACC30BK10		2	370	1
BACC30BK6		2	475	6
		2	595A	2
		2	600	4
		2	705	6
		2	785	6
BACC30BK8		2	375	7
		2	470	7
		2	590	5
		2	595	2
		2	700	5
		2	780	7
		2	865	14
BACC30BL6		2	35	2
		2	300	62
		2	320	68
BACC30BL8		2	260	6
BACC30BQ5		2	150	3
BACC30BQ6		2	145	9
		2	295	13
BACC30BQ8		2	265	6
BACF3H06JK006HN		2	900	1
BACF3H07DF011HN		1	410	1
BACF3H08NK009HG		1	50	1
BACF3T02G06-05		2	55A	1
BACF3T02G6-13		2	115	1
BACF3T02G6-5		2	55	1
BACF3T03G09-05		2	50A	1

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1024

Nov 01/2008





## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACF3T03G9-13		2	110	1
BACF3T03G9-5		2	50	1
BACN10JA3CD		6	45	2
BACN10JA4CD		8	380	12
BACN10JD105CD		3	140	2
BACN10JD106ASU		8	335	1
BACN10JD6CD		8	40	1
BACN10JP3ACD		8	405	4
BACN10JP5C		8	285A	1
BACN10JP5CCD		8	285	1
BACN10JR4CFD		1	65	2
		1	95	1
		1	150	1
BACN10JZ3A2CDM		1	390	7
		1	430	4
		1	620	21
BACN10JZ3B2CDM		1	405	1
BACN10KB3CFD		2	100	2
BACN10KE3B2CD		1	255	4
		1	395	6
BACN10KE3B4CD		2	45	1
BACN10KE3DCD		1	260	1
		2	540	10
		2	655	10
BACN10KE3E2CD		1	250	5
		1	400	2
BACN10KF4		8	310	2
BACN10MK3-45		1	480	3
BACN10YR04CD		4	15	6
		4	17	12
BACN10YR08CD		3	40	2
BACN10YR3CD		1	205	2
		2	30	2
		2	230	8
		3	35	14

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1025

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		3	105	16
		5	20	4
		8	15	4
		8	230	4
BACN10YR3CM		3	165	4
		3	185	4
		7	50	8
BACN10YR4CD		1	530	2
		8	265	2
BACN10YR4CM		1	535	2
		1	685	2
		7	80	2
BACN10YR5CD		2	65	1
BACN10YR5CM		1	755	1
BACN10ZV3		1	10	3
		1	30	1
		1	355	5
		1	800	28
		1	905	4
		2	325	24
BACP18BC02A06P		3	137	2
BACP18BC03A08P		1	765	1
BACR15AG2C		1	325	4
BACR15BA3AD		1	425	8
		1	615	42
		2	40	2
		2	95	4
		2	535	20
		2	650	20
		6	40	4
		8	375	24
		8	400	8
BACR15BA3D		1	60	4
		1	85	2
		1	140	2

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1026

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACR15BA4D		1	115	6
		1	170	6
		8	280	2
BACR15BA5AD		2	550	4
		2	665	4
BACR15BA5B		1	590	60
BACR15BA5D		1	90	2
		1	145	2
BACR15BB4AD		2	420	2
BACR15BB4D		1	930	2
		2	160	7
		2	345	12
		2	840	4
BACR15DR3AC		2	535A	20
		2	650A	20
BACR15FR4E4R		5	45	27
		6	55	28
BACR15FT5D		1	435	12
		1	915	10
BACR15FT6D		1	920	2
BACR15GE3CW2		1	235	10
		1	385	32
BACR15GE3CW3		1	245	6
BACR15GE3CW4		1	240	4
BACR15GF4D		1	475	6
BACR15GF5D		1	290	4
		1	380	27
		2	195	40
		2	205	4
		2	335	272
BACR15GF6D		8	370	8
		1	490	38
		1	910	16
BACR15GK4E2		2	330	110
		2	155	25

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1027

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACR15GK5E2		1	375	133
BACR15GK5E3		1	45	4
		1	295	8
BACR15GK6E2		1	370	145
BACR15GK6E3		1	15	13
		1	365	57
BACR15GK6E4		1	35	5
		1	280	8
		1	360	19
BACR15GK6E5		1	40	2
BACS12GU3K10		1	225	34
BACS12HJ04K8		4	7	12
BACS14K1		1	120	3
		1	285	4
		1	445	6
		2	350	6
		2	845	2
BACS14K2		1	175	3
BACS14K7		1	300	4
BACS21AP260RP		1	310	4
BACS40R007B007F		4	25	AR
BACS40R007B008F		2	920	AR
BACS40R007B009F		2	910	AR
BACS40R007B013F		2	815	1
BACS40R007B017F		2	915	AR
BACS40R007C007F		4	30	AR
BACS40R007F013F		2	505	1
BACS40R008B015F		2	820	1
BACS40R008C008F		2	905	AR
BACS40R008C042F		1	790	AR
BACS40R008F015F		2	510	1
BACW10BN3AC		1	470	3
		2	25	3
		5	10	4
		6	10	4

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1028

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		8	95	4
BACW10BN4AC		1	515	2
		1	680	2
		1	780	12
BACW10BP3APU		7	45	8
BACW10BP3CD		7	10	4
BACW10BP4APU		7	75	2
BACW10CT6J		1	610	21
		1	825	4
BACW10P148AL		8	55	1
BACW10P182AL		1	440	10
BH00312-04		4	15	6
BLN16385GC		3	10	4
		3	120	1
BR3000A4		8	310	2
BRE4140L		1	565A	1
		1	710	1
BRE4795L		1	565	1
BRES4-2236L2		1	555	1
		1	710A	1
		1	715	1
BRF100C3D		2	100	2
BRF110C3D		6	45	2
BRF110C4D		8	380	12
BRF170C3D		6	45	2
BRF170C4D		8	380	12
BRF200C4D		1	65	2
		1	95	1
		1	150	1
BRFR120C3-2D		1	250	5
		1	400	2
BRFR220C3-2D		1	255	4
		1	395	6
BRFR220C3-4D		2	45	1
BSSR4804		3	202	1

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1029

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BWG4-110		3	202	1
CHRS3CFR9		2	75	1
		2	75	1
		3	150	2
		3	150	2
CR3253-4-4		5	45	27
		6	55	28
CR6551-3		1	10	3
		1	30	1
		1	355	5
		1	800	28
		1	905	4
		2	325	24
DE586		1	300	4
DE679-10		1	175	3
DE685-10		1	120	3
		1	285	4
		1	445	6
		2	350	6
		2	845	2
DREM5-019		8	195	2
F51604-3		2	100	2
F51636-3		6	45	2
F51636-4		8	380	12
		8	380	12
F51643-3BAC		1	390	7
		1	430	4
		1	620	21
F51646-3BAC		1	405	1
F51747-3-2CD		1	255	4
		1	395	6
F51747-3-4CD		2	45	1
F51751-3-2CD		1	250	5
		1	400	2
F51753-3DC		1	260	1

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1030

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		2	540	10
		2	655	10
H52732-04CD		4	15	6
		4	17	12
H52732-08CD		3	40	2
H52732-3CD		1	205	2
		2	30	2
		2	230	8
		3	35	14
		3	105	16
		5	20	4
		8	15	4
		8	230	4
H52732-3CM		3	165	4
		3	185	4
		7	50	8
H52732-4CD		1	530	2
		8	265	2
H52732-4CM		1	535	2
		1	685	2
		7	80	2
H52732-5CD		2	65	1
H52732-5CM		1	755	1
HB4E135		1	565A	1
		1	710	1
HB4E140		1	565	1
HB4E212K		1	555	1
		1	710A	1
		1	715	1
HGL16-102		3	10	4
		3	120	1
HR3253-4-4		5	45	27
		6	55	28
HRSC3CFR9		2	75	1
		3	150	2

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1031

Nov 01/2008



COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HST10AG6-3		1	795	28
		1	795	28
		1	795	28
		1	795	28
		2	280	44
		2	280	44
		2	280	44
		2	280	44
HST10AG6-4		1	345	4
		1	345	4
		1	345	4
		1	345	4
		2	275	9
		2	275	9
		2	275	9
		2	275	9
HST10AG6-5		1	5	3
		1	5	3
		1	5	3
		1	5	3
		1	25	1
		1	25	1
		1	25	1
		1	25	1
		1	350	1
		1	350	1
		1	350	1
		1	350	1
		2	20	2
		2	20	2
		2	20	2
		2	20	2
2	270	4		
2	270	4		
2	270	4		

**52-41-05**

ILLUSTRATED PARTS LIST

Page 1032

Nov 01/2008





## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HST10AG8-4		2	270	4
		2	240	4
		2	240	4
		2	240	4
HST10AG8-6		2	240	4
		2	245	2
		2	245	2
		2	245	2
HST10AG8-7		2	250	1
		2	250	1
		2	250	1
		2	250	1
HST10AG8-8		2	255	1
		2	255	1
		2	255	1
		2	255	1
HST11AG5-5		2	140	1
		2	140	1
		2	140	1
		2	140	1
HST11AG5-6		2	135	2
		2	135	2
		2	135	2
		2	135	2
HST11AG6-3		2	285	16
		2	285	16
		2	285	16
		2	285	16
		2	310	8
		2	310	8
		2	310	8
		2	310	8
HST11AG6-4		1	900	4
		1	900	4

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1033

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
HST11AG6-5		1	900	4
		1	900	4
		2	305	72
		2	305	72
		2	305	72
		2	305	72
		2	125	3
		2	125	3
		2	125	3
		2	125	3
		2	290	2
		2	290	2
		2	290	2
		2	290	2
		2	315	12
HST11AG6-6		2	315	12
		2	315	12
		2	315	12
		2	315	12
HST11AG6-7		2	130	4
		2	130	4
		2	130	4
		2	130	4
HST11AG8-6		2	120	2
		2	120	2
		2	120	2
		2	120	2
HST79-6		2	235	4
		2	235	4
		2	235	4
		2	235	4
HST79-8		2	35	2
		2	300	62
		2	320	68
HST79CY6		2	260	6
		2	35	2

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1034

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		2	35	2
		2	35	2
		2	300	62
		2	300	62
		2	300	62
		2	320	68
		2	320	68
		2	320	68
HST79CY8		2	260	6
		2	260	6
		2	260	6
HST825AW		2	150	3
		2	150	3
HST826AW		2	145	9
		2	145	9
		2	145	9
		2	295	13
		2	295	13
		2	295	13
HST828AW		2	265	6
		2	265	6
		2	265	6
HST82CY5APBW		2	150	3
		2	150	3
HST82CY6APBW		2	145	9
		2	145	9
		2	295	13
		2	295	13
HST82CY8APBW		2	265	6
		2	265	6
HU4-134		3	202	1
J7444-11		1	300	4
K3000-4BAC		8	310	2
K51602-4BAC		1	65	2
		1	95	1

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1035

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	150	1
KB4ESSD6FN		1	565	1
KB4ESSFN		1	565A	1
		1	710	1
KBDE5-14		8	195	2
KBE4-150AFNW		1	555	1
		1	710A	1
		1	715	1
KRP141500VT6-6		8	345	1
KSSB16-5		3	10	4
		3	120	1
KWB4-20CRG		3	202	1
LGPL2SPV10-6AC		2	355	1
		2	355	1
		2	355	1
LGPL2SPV6-4AC		2	465	3
		2	465	3
		2	465	3
		2	580	3
		2	580	3
		2	580	3
		2	685	3
		2	685	3
		2	685	3
		2	775	3
		2	775	3
		2	775	3
LGPL2SPV6-6AC		2	690	1
		2	690	1
		2	690	1
LGPL2SPV6-7AC		2	570A	1
		2	570A	1
		2	570A	1
		2	585	1
		2	585	1

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1036

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
LGPL2SPV6-8AC		2	585	1
		2	695	2
		2	695	2
		2	695	2
		2	455	2
		2	455	2
		2	455	2
		2	460	1
		2	575A	1
		2	575A	1
		2	575A	1
		2	770	3
		2	770	3
		2	770	3
LGPL2SPV6-9AC		2	460	1
LGPL2SPV8-4AC		2	460	1
		2	450	3
		2	450	3
		2	450	3
		2	560	4
		2	560	4
		2	560	4
		2	675	4
		2	675	4
		2	675	4
		2	765	3
		2	765	3
		2	765	3
	LGPL2SPV8-5AC		2	365
		2	365	2
		2	365	2
		2	680	1
		2	680	1
		2	680	1
		2	750	1

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1037

Nov 01/2008



COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
LGPL2SPV8-6AC		2	750	1
		2	750	1
		2	860	4
		2	860	4
		2	860	4
		2	360	5
		2	360	5
		2	360	5
		2	440	1
		2	440	1
		2	440	1
		2	565	1
		2	565	1
		2	565	1
		2	760	1
		2	760	1
		2	760	1
		2	855	4
	LGPL2SPV8-7AC		2	855
		2	855	4
		2	855	4
		2	445	1
		2	445	1
		2	445	1
		2	570	1
		2	570	1
		2	570	1
		2	745	1
LGPL2SPV8-8AC		2	745	1
		2	745	1
		2	850	6
		2	850	6
		2	850	6
		2	435	2
		2	435	2
	2	435	2	

**52-41-05**

ILLUSTRATED PARTS LIST

Page 1038

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		2	575	1
		2	575	1
		2	575	1
		2	755	1
		2	755	1
		2	755	1
M83461-1-212		8	115	1
M83461-1-214		1	730	2
M83461-1-325		1	770	1
MK3000-5BAC		8	285A	1
MS15001-4		3	115	1
MS16625-4162		8	120	1
MS20253P2-2910		1	640	1
MS20426D5		8	65	3
MS20470D3		1	700	1
MS20470D3-4		8	305	4
MS20470D5		1	560	1
MS20615-5M10		8	185	1
MS21141U0603P		1	340A	8
MS21141U0604P		1	335A	7
MS21209F5-15P		8	80	3
MS24665-283		8	330	1
MS27253F1		3	220	1
MS39086-111		8	135	1
MS39086-125		1	635	2
MSSK4ASFG		1	555	1
		1	710A	1
		1	715	1
MSSR56-14BAC		8	195	2
MXJ45-14BFG		1	565A	1
		1	710	1
MXJ45-14BFG2		1	565	1
NAS1149C0332R		3	160	4
		3	180	4
NAS1149C0632B		8	340	AR

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1039

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
NAS1149C1790R		1	735	2
NAS1149D0316J		1	230	34
NAS1149D0332J		1	165	3
		3	25	14
		3	100	16
		8	225	6
NAS1149D0363J		1	110	3
		1	200	2
		2	225	7
		2	530	10
		2	645	10
		5	15	4
		8	10	4
NAS1149D0416J		1	320	4
NAS1149D0432J		8	250	2
NAS1149D0463J		1	315	4
		1	520	2
NAS1149D0516J		1	815A	AR
		3	145	16
NAS1149D0532J		1	815	AR
		2	70	1
NAS1149D0563J		8	175	1
NAS1149D0632J		8	45	AR
NAS1149D2190J		8	260	2
NAS1149DN432H		1	935	2
NAS1149DN432J		2	425	2
		4	10	12
		4	12	24
NAS1149DN832J		3	30	2
NAS1149E0432R		1	525	2
		1	675	2
NAS1149E0563R		1	750	1
NAS1399CW3		2	535B	20
		2	650B	20
NAS1523C3R		8	97	4

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1040

Nov 01/2008





## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
NAS1805-3L		1	835	4
NAS516-1A		3	65	1
		3	203	1
		8	105	1
NAS620A10L		1	830	4
NAS76A16-016P		1	860	1
NAS8200A8		4	5	6
		4	7A	12
NASM21209F1-15		7	25A	4
NB12BGCM2		3	10	4
		3	120	1
NB16BM2		3	10	4
		3	120	1
NC16-4		3	10	4
		3	120	1
NHNE5-202		8	195	2
NS103195-048		8	310	2
NS103199-054		8	285A	1
NS202476-048		1	65	2
		1	95	1
		1	150	1
NS202478-02		2	100	2
NS202484-02		6	45	2
NS202492-02		1	390	7
		1	430	4
		1	620	21
NS202493-02-2		1	255	4
		1	395	6
NS202493-02-4		2	45	1
NS202494-02-2		1	250	5
		1	400	2
NS202495-02		1	260	1
		2	540	10
		2	655	10
PACMKP12AA3908		8	125	1

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1041

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
PACMKP12AFS428		8	125	1
PACMKP21BSA3908		8	270	2
PACMKP21BSFS428		8	270	2
PACMKP23BSA3908		8	240	2
PACMKP23BSFS428		8	240	2
PACMKP25BA3908		8	360	2
PACMKP25BFS428		8	360	2
PLH504CD		4	17	12
PLH508CD		3	40	2
PLH53CD		1	205	2
		2	30	2
		2	230	8
		3	35	14
		3	105	16
		5	20	4
		8	15	4
		8	230	4
PLH53CM		3	165	4
		3	185	4
		7	50	8
PLH54CD		1	530	2
		8	265	2
PLH54CM		1	535	2
		1	685	2
		7	80	2
PLH55CD		2	65	1
PLH55CM		1	755	1
REM10ATC12-2		8	195	2
RMA9205-4		8	310	2
RMA9205M5		8	285A	1
S14063-3		1	585	1
SL2509		1	300	4
SL2752-3		1	175	3
SL2808-3		1	120	3
		1	285	4

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1042

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	445	6
		2	350	6
		2	845	2
SSMKP12AP		8	125	1
SSMKP12ASD705		8	125	1
SSMKP21BSSD705		8	240	2
		8	270	2
SSMKP23BSSD705		8	240	2
SSMKP25BSD703		8	360	2
T8059S1032B1		1	480	3
		1	480	3
T8078S524		8	285A	1
T8092C428CD		1	65	2
		1	95	1
		1	150	1
T8118S4		8	310	2
TFM5C		8	195	2
VN103A1-048		8	310	2
WC10K6-3		1	795	28
		2	280	44
WC10K6-5		1	5	3
		1	25	1
		1	350	1
		2	20	2
		2	270	4
WC10K8-4		2	240	4
WC10K8-6		2	245	2
WC10K8-7		2	250	1
WC10K8-8		2	255	1
WC4G1		3	202	1
WG4E		3	202	1

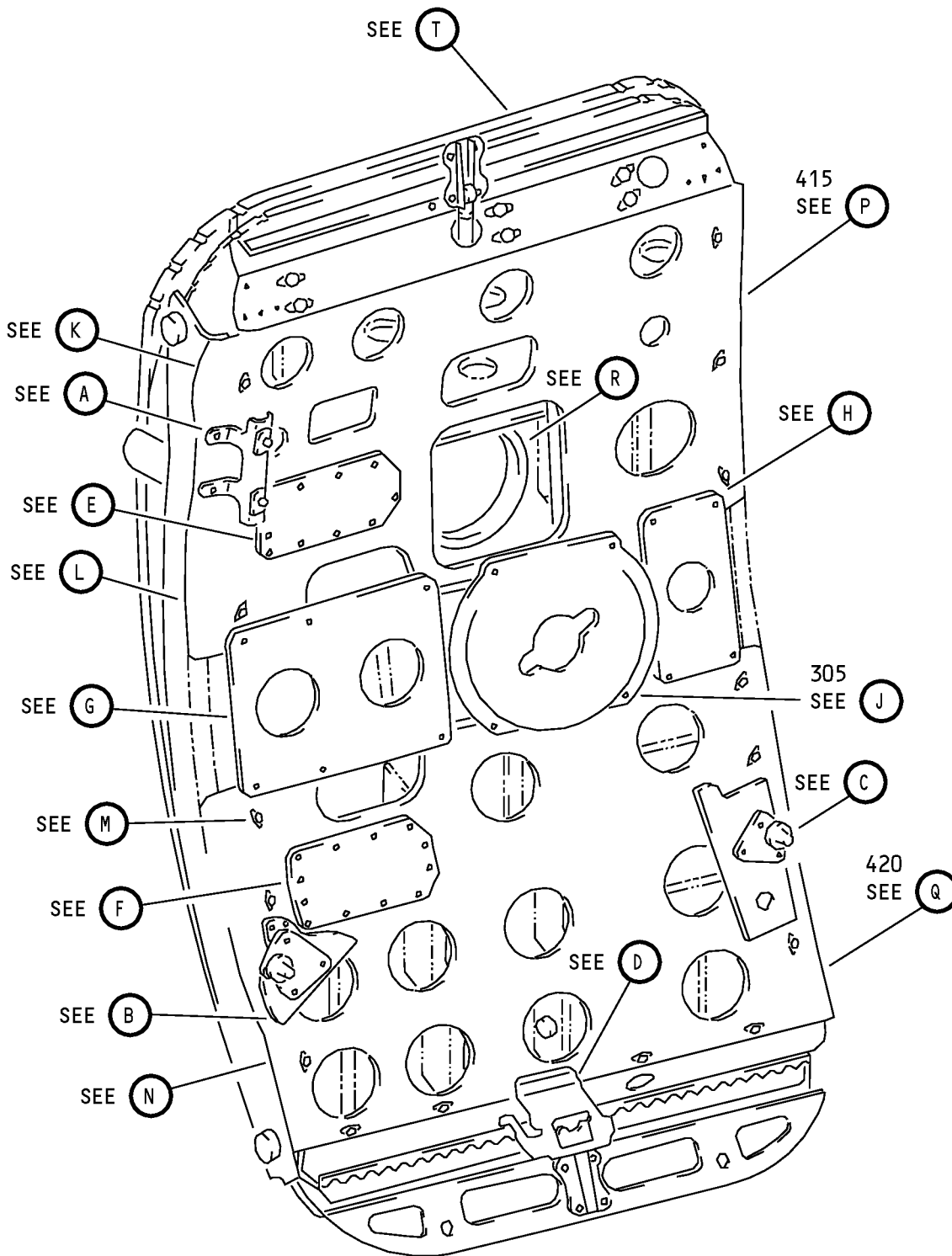
# 52-41-05

ILLUSTRATED PARTS LIST

Page 1043

Nov 01/2008

# COMPONENT MAINTENANCE MANUAL



Forward Galley Door Assembly  
IPL Figure 1 (Sheet 1 of 25)

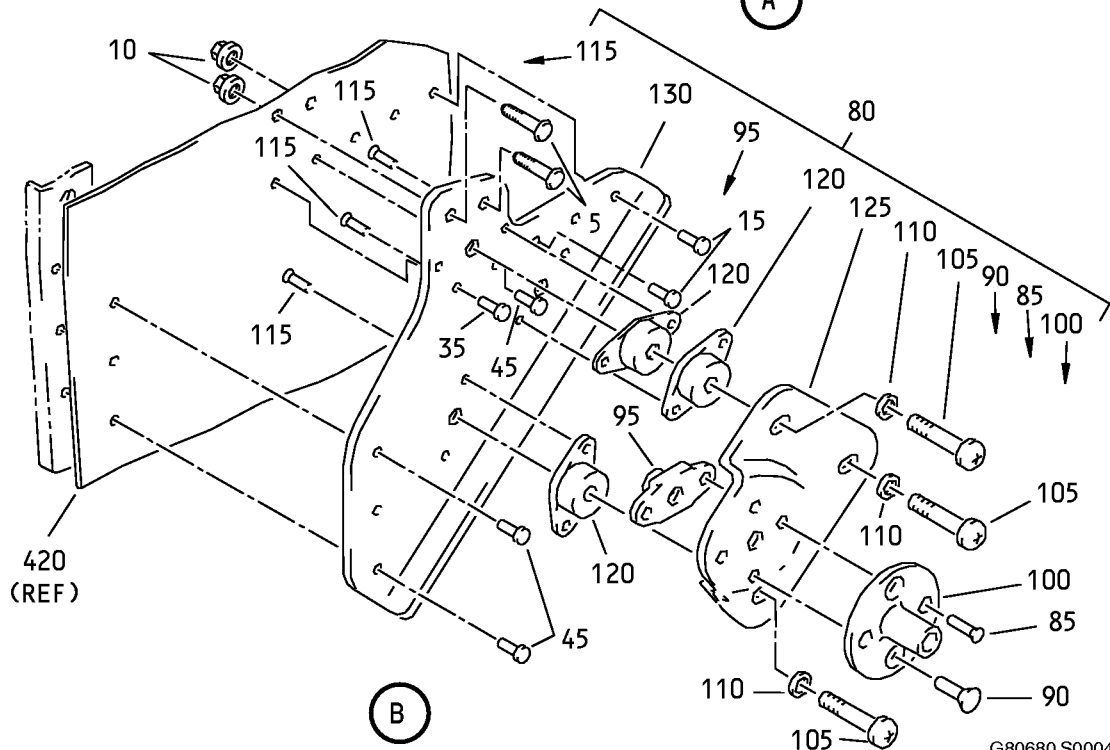
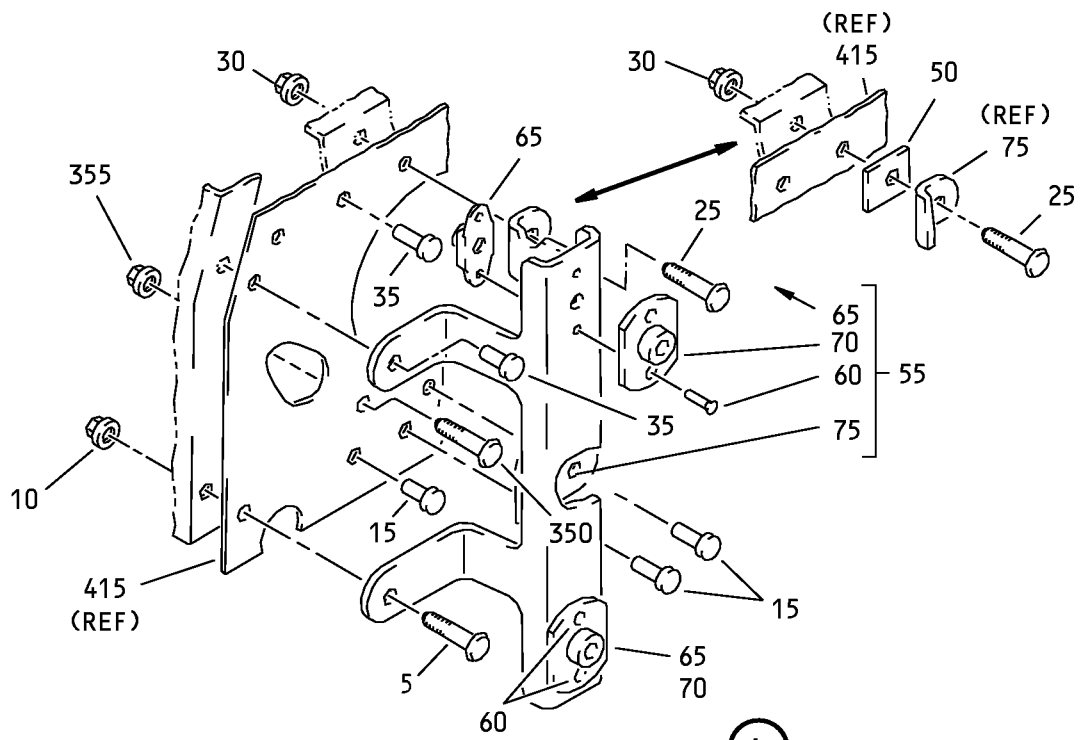
## 52-41-05

ILLUSTRATED PARTS LIST

Page 1044

Nov 01/2008

COMPONENT MAINTENANCE MANUAL



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Forward Galley Door Assembly  
IPL Figure 1 (Sheet 2 of 25)

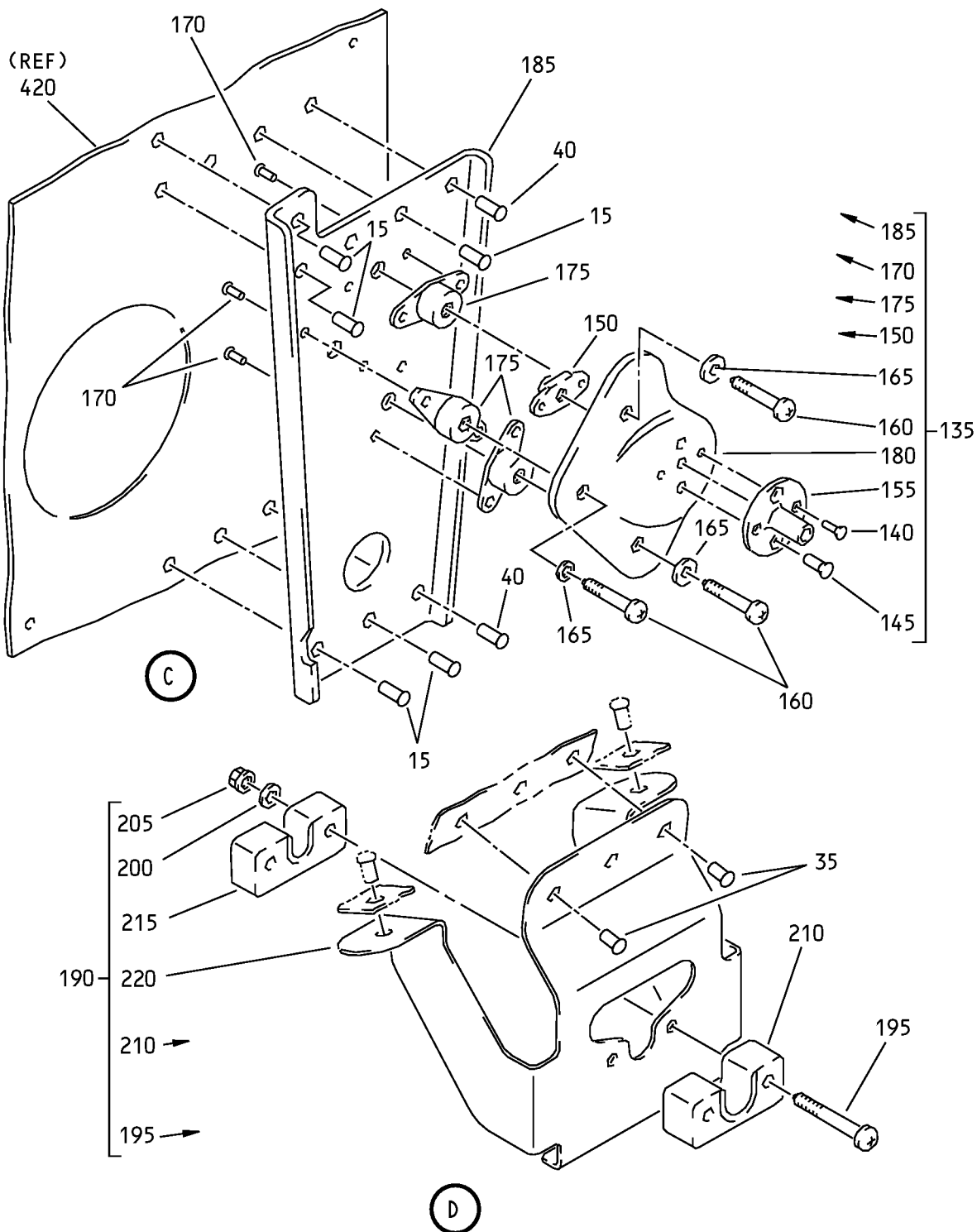
**52-41-05**

ILLUSTRATED PARTS LIST

Page 1045

Nov 01/2008

COMPONENT MAINTENANCE MANUAL



Forward Galley Door Assembly  
IPL Figure 1 (Sheet 3 of 25)

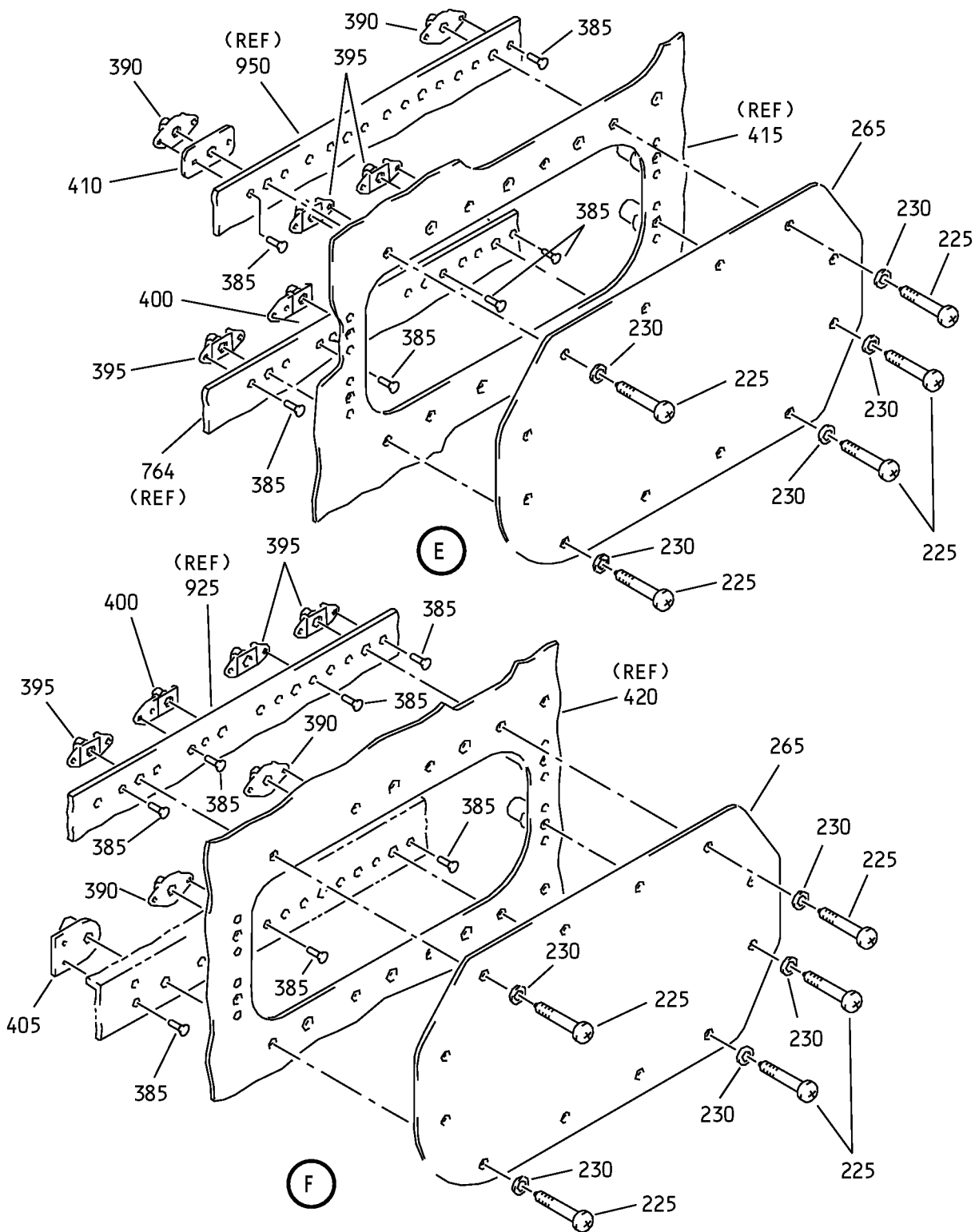
**52-41-05**

ILLUSTRATED PARTS LIST

Page 1046

Nov 01/2008

### COMPONENT MAINTENANCE MANUAL



Forward Galley Door Assembly  
IPL Figure 1 (Sheet 4 of 25)

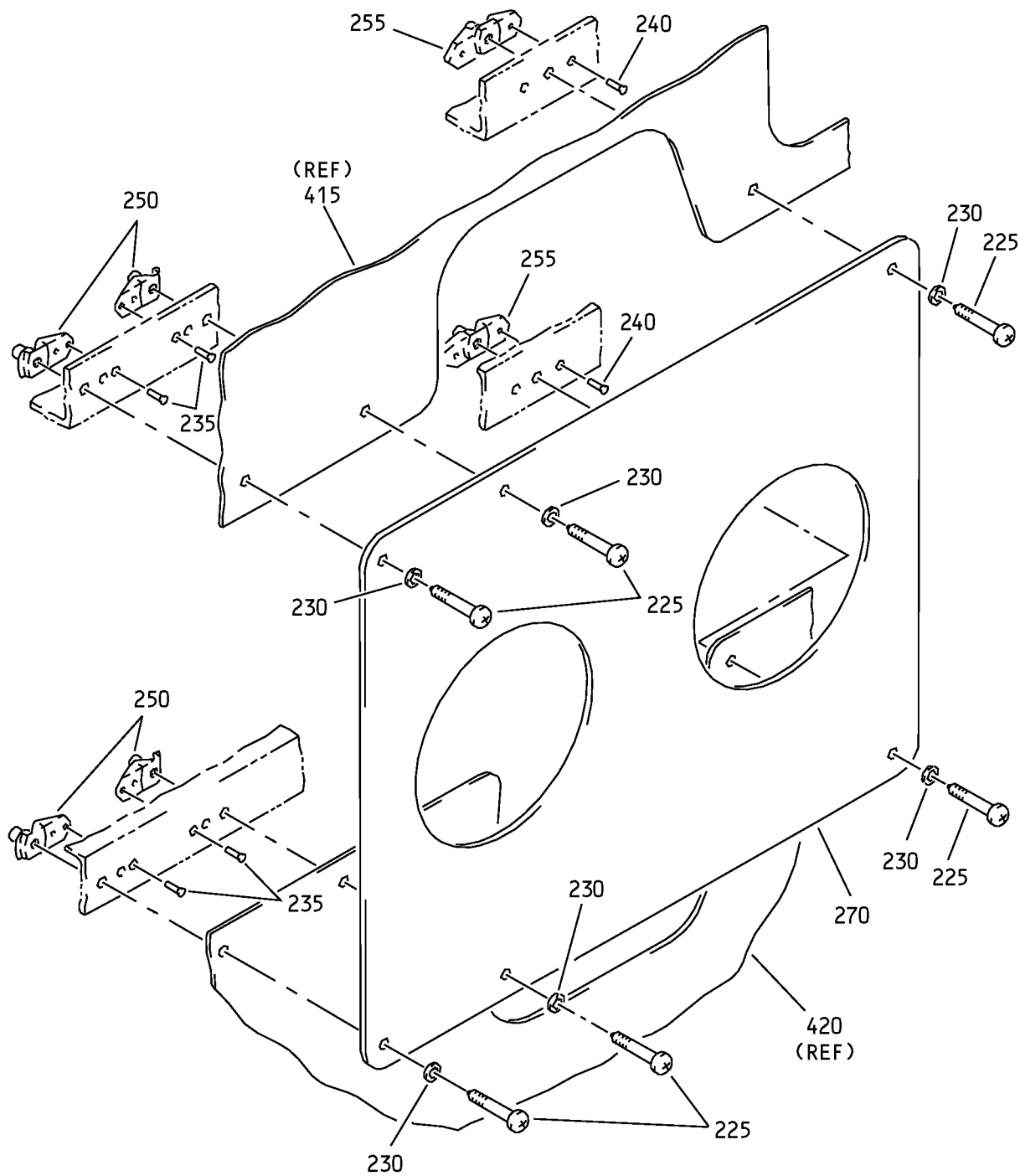
# 52-41-05

ILLUSTRATED PARTS LIST

Page 1047

Nov 01/2008

COMPONENT MAINTENANCE MANUAL



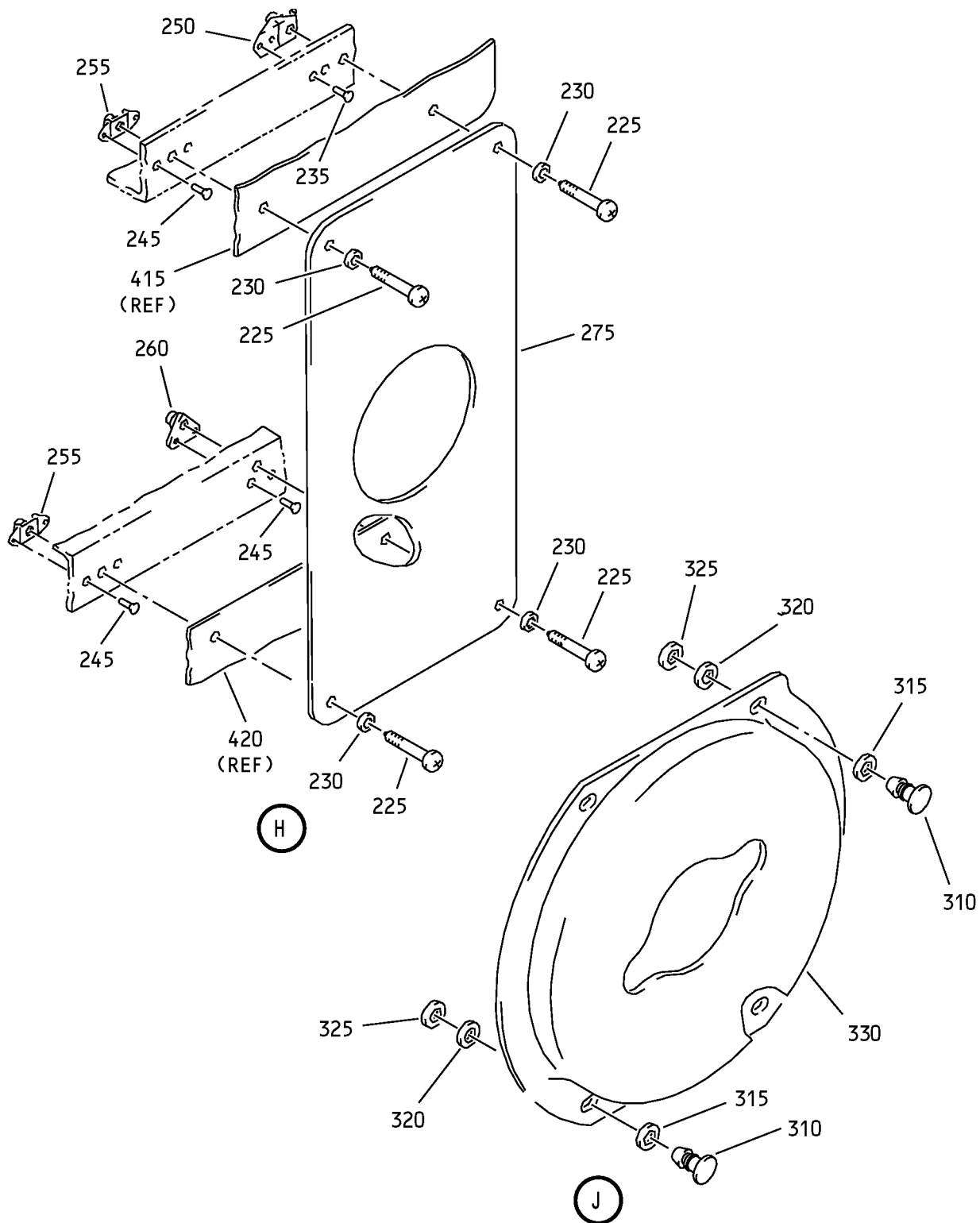
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Forward Galley Door Assembly  
IPL Figure 1 (Sheet 5 of 25)

**52-41-05**  
ILLUSTRATED PARTS LIST  
Page 1048  
Nov 01/2008



### COMPONENT MAINTENANCE MANUAL



Forward Galley Door Assembly  
IPL Figure 1 (Sheet 6 of 25)

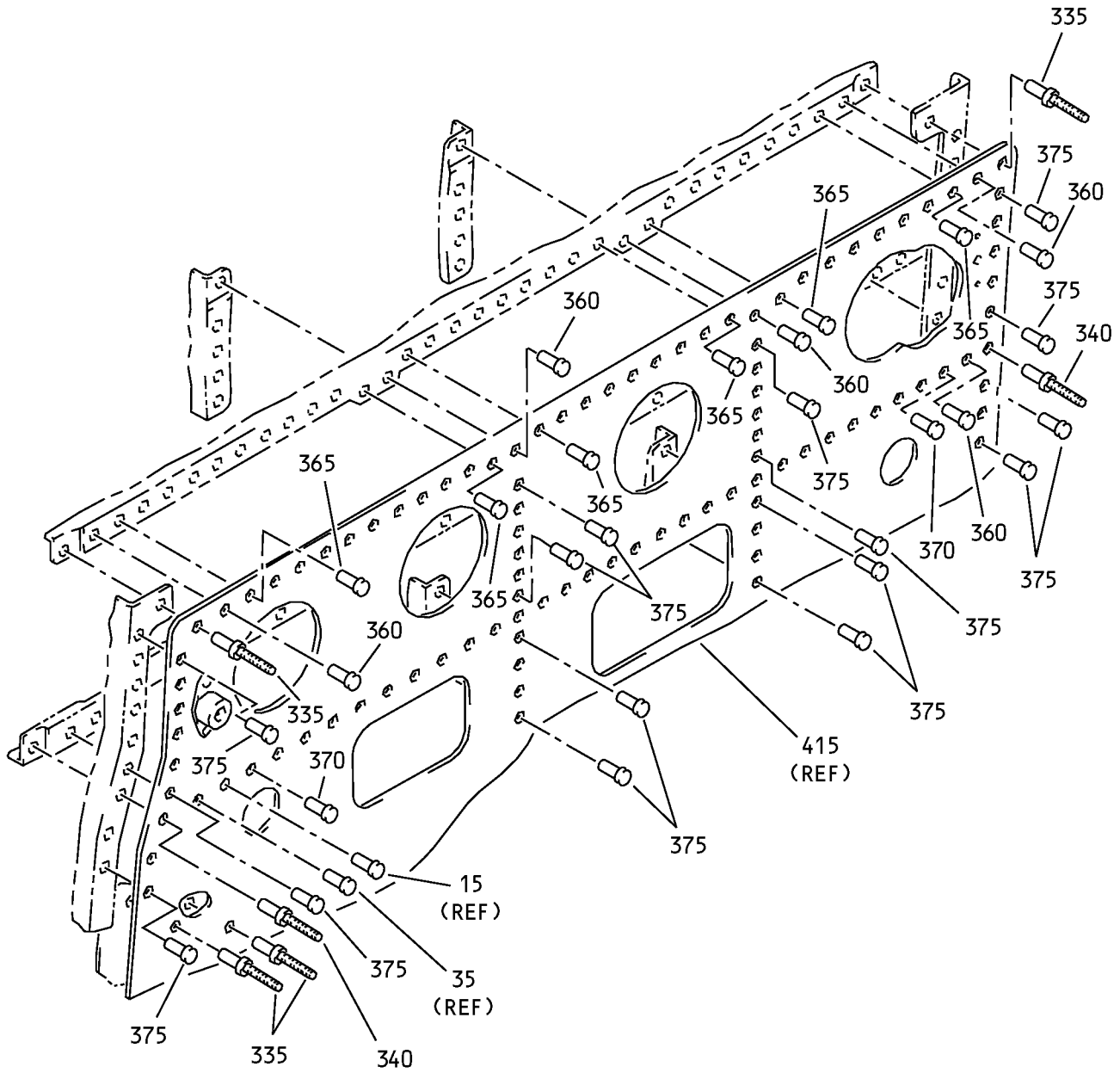
# 52-41-05

ILLUSTRATED PARTS LIST

Page 1049

Nov 01/2008

COMPONENT MAINTENANCE MANUAL



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Forward Galley Door Assembly  
IPL Figure 1 (Sheet 7 of 25)

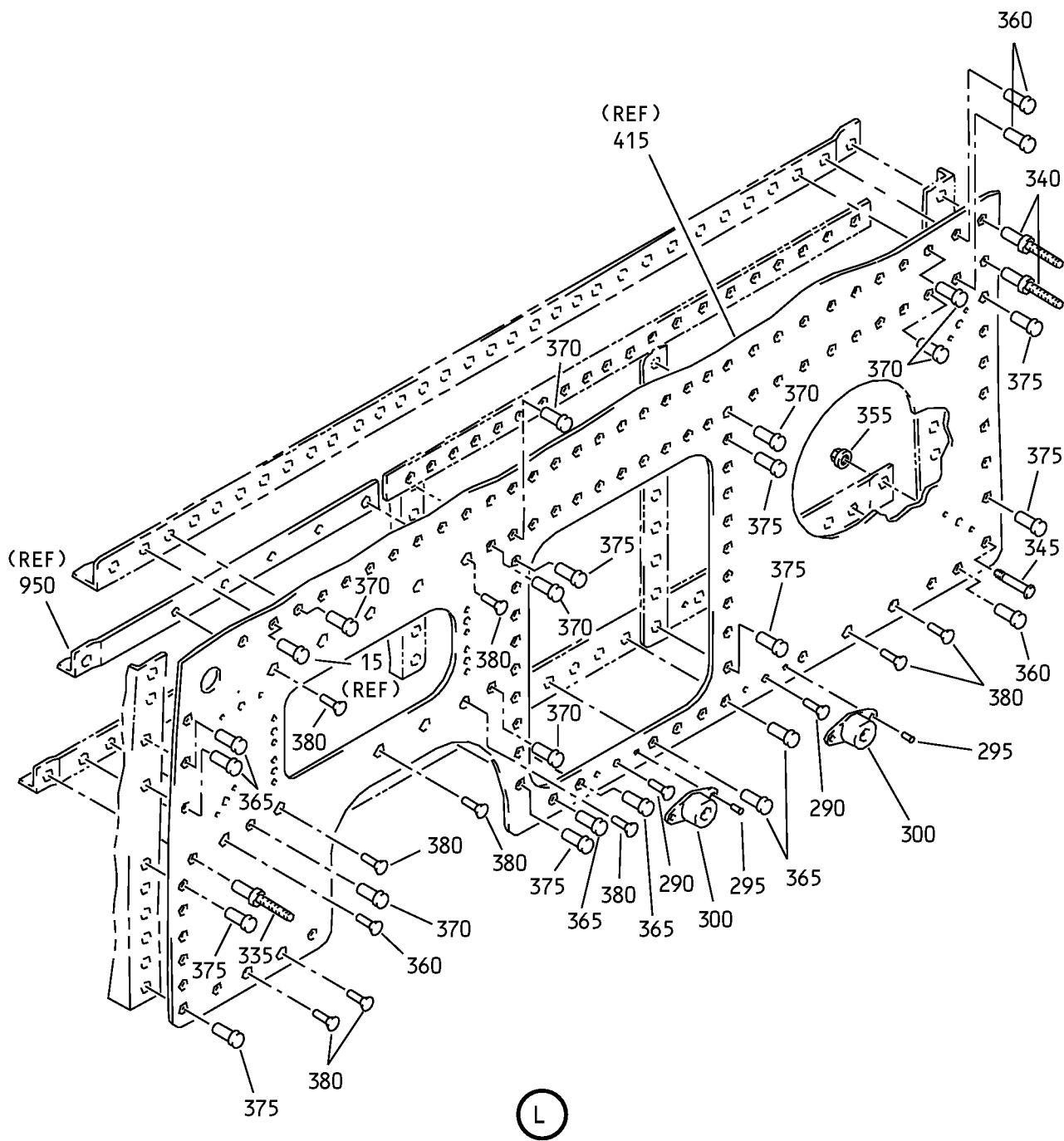
**52-41-05**

ILLUSTRATED PARTS LIST

Page 1050

Nov 01/2008

# COMPONENT MAINTENANCE MANUAL



Forward Galley Door Assembly  
IPL Figure 1 (Sheet 8 of 25)

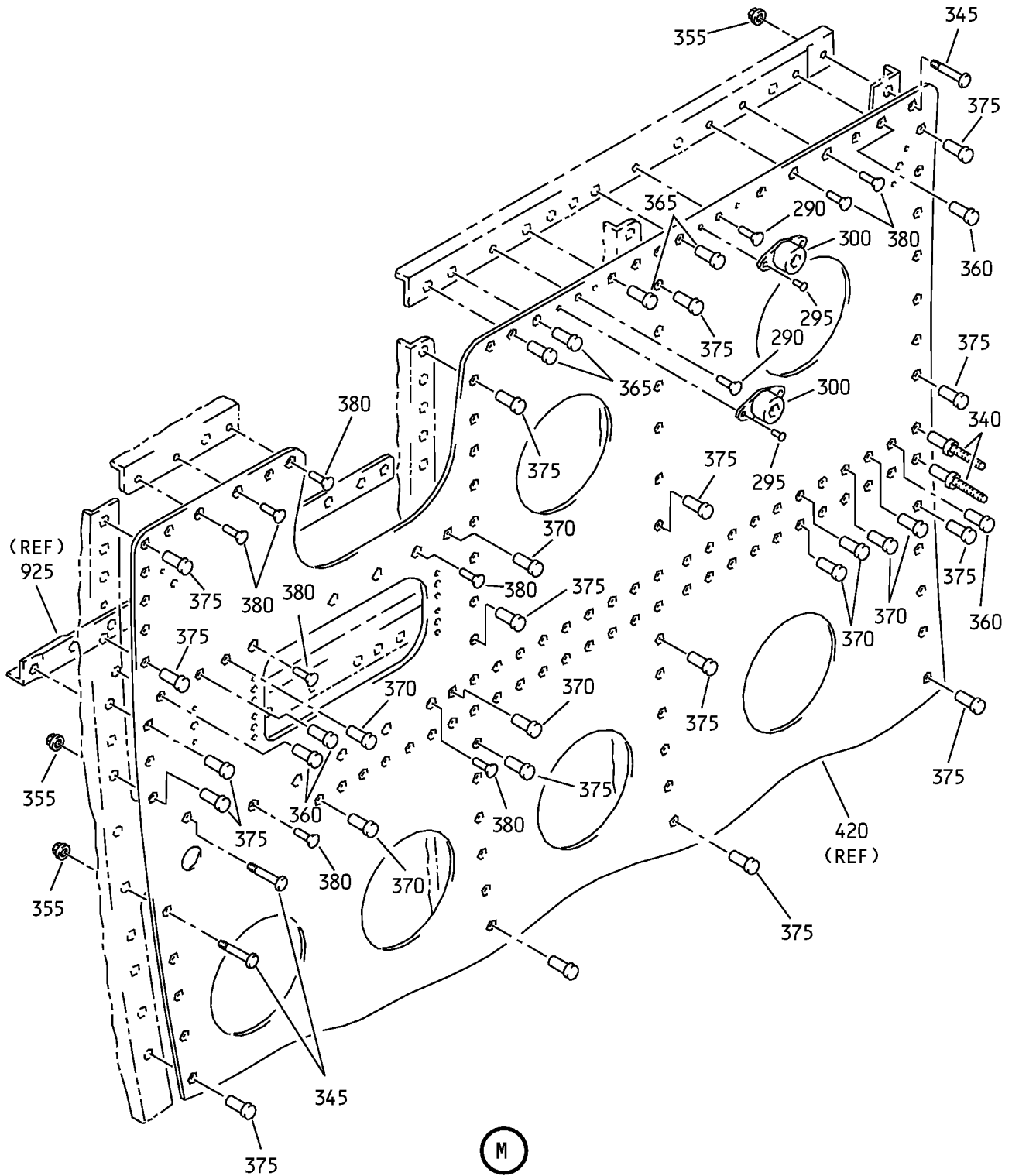
## 52-41-05

ILLUSTRATED PARTS LIST

Page 1051

Nov 01/2008

COMPONENT MAINTENANCE MANUAL



Forward Galley Door Assembly  
IPL Figure 1 (Sheet 9 of 25)

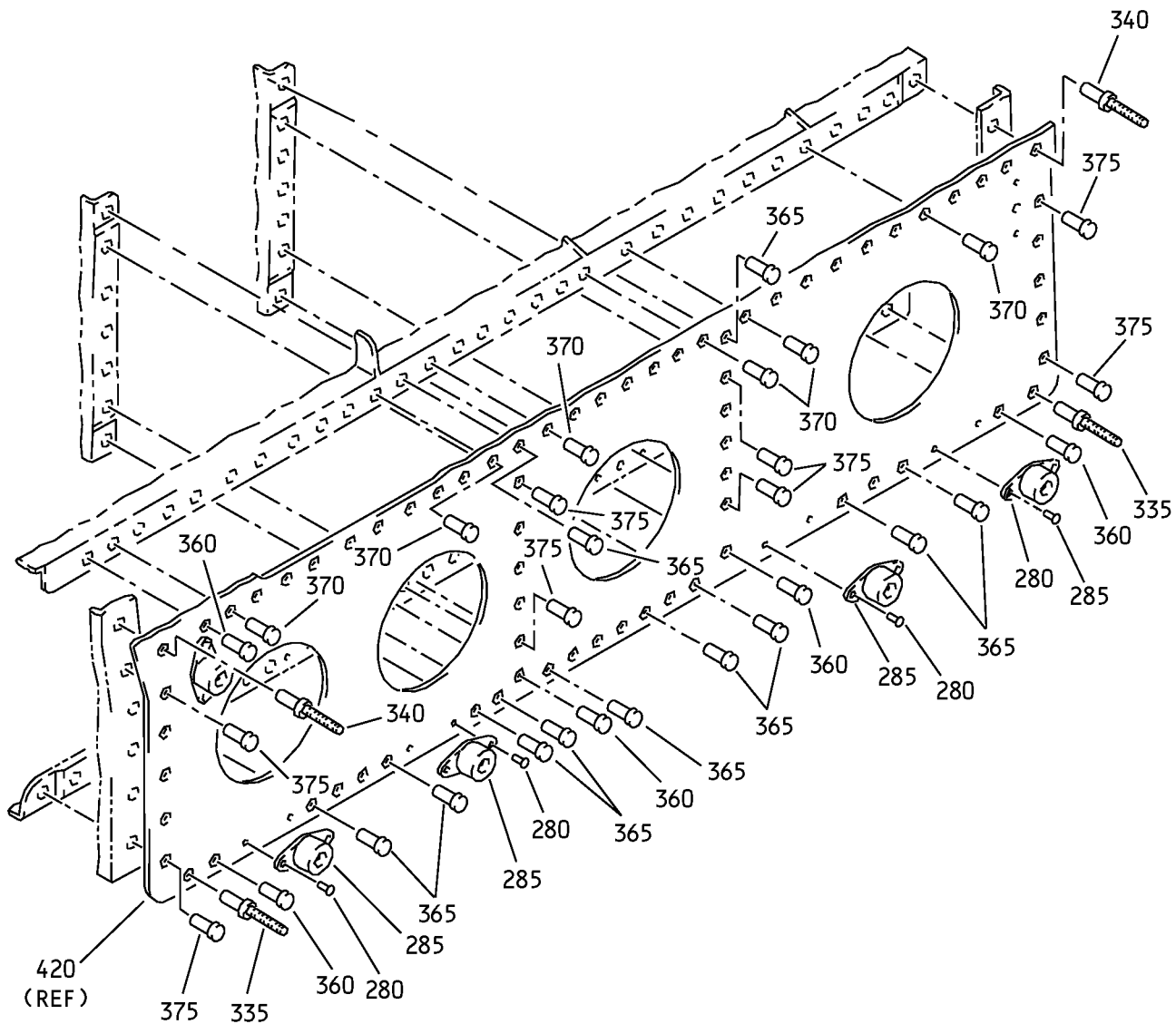
**52-41-05**

ILLUSTRATED PARTS LIST

Page 1052

Nov 01/2008

# COMPONENT MAINTENANCE MANUAL



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Forward Galley Door Assembly  
IPL Figure 1 (Sheet 10 of 25)

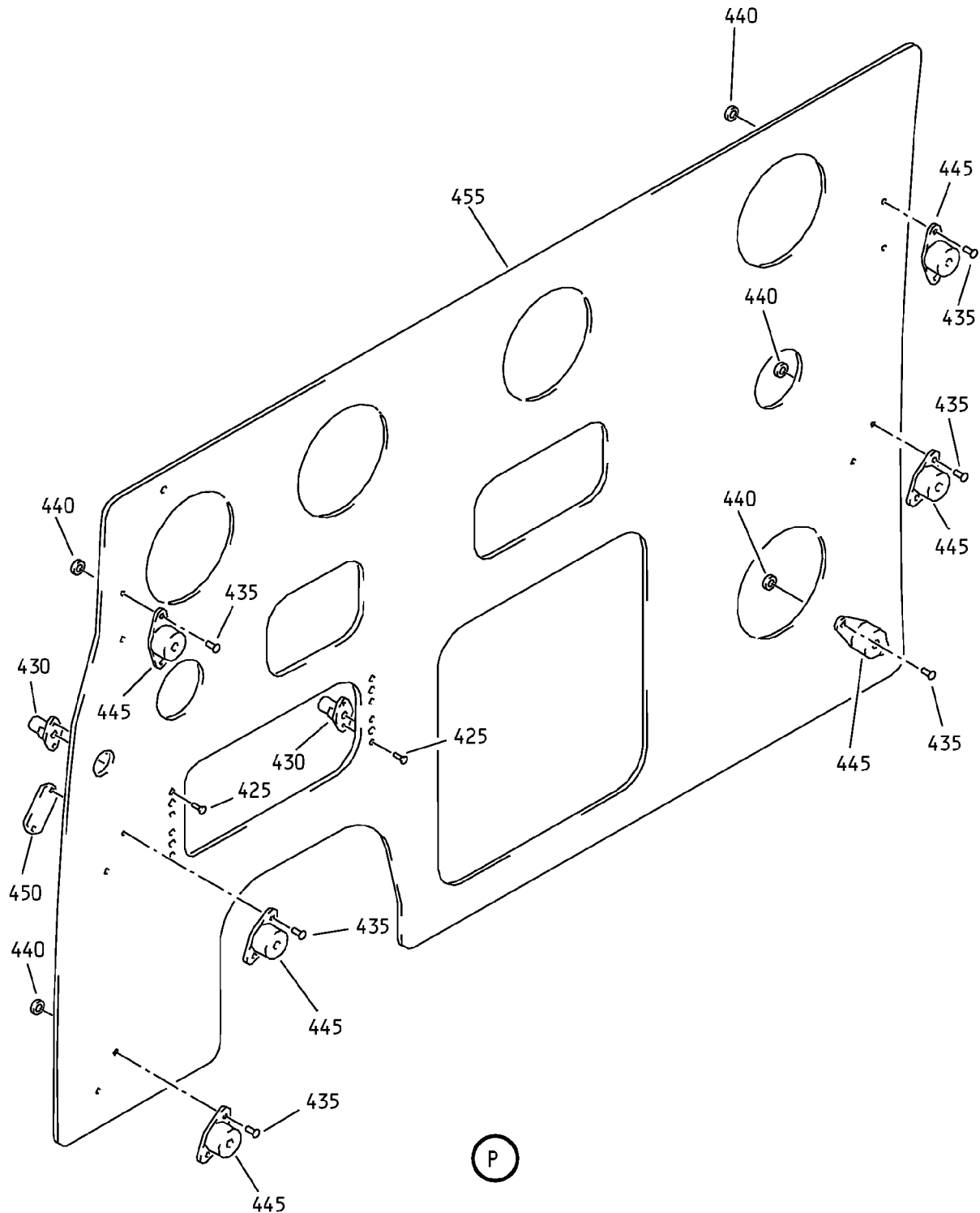
## 52-41-05

ILLUSTRATED PARTS LIST

Page 1053

Nov 01/2008

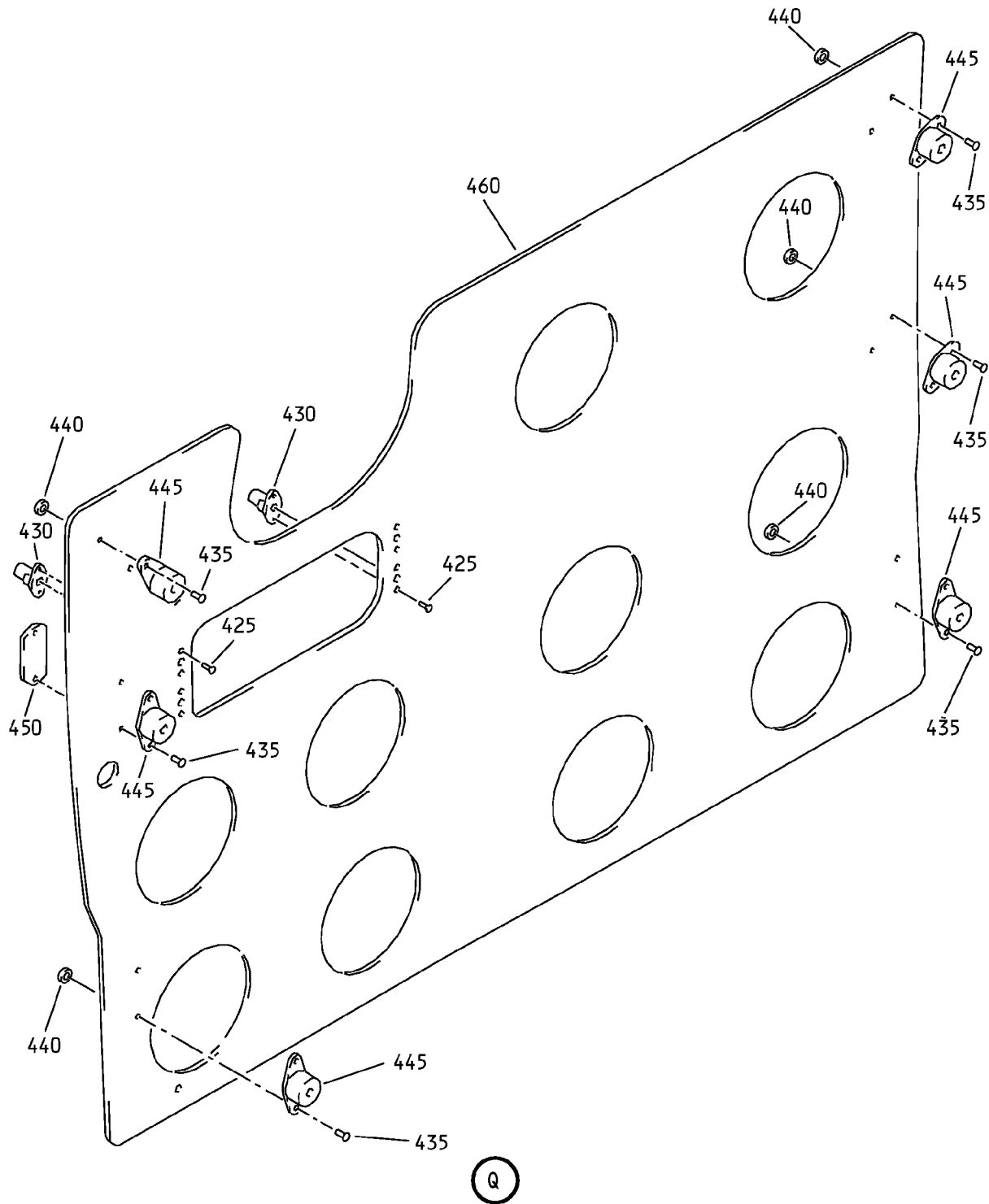
COMPONENT MAINTENANCE MANUAL



Forward Galley Door Assembly  
IPL Figure 1 (Sheet 11 of 25)

**52-41-05**  
ILLUSTRATED PARTS LIST  
Page 1054  
Nov 01/2008

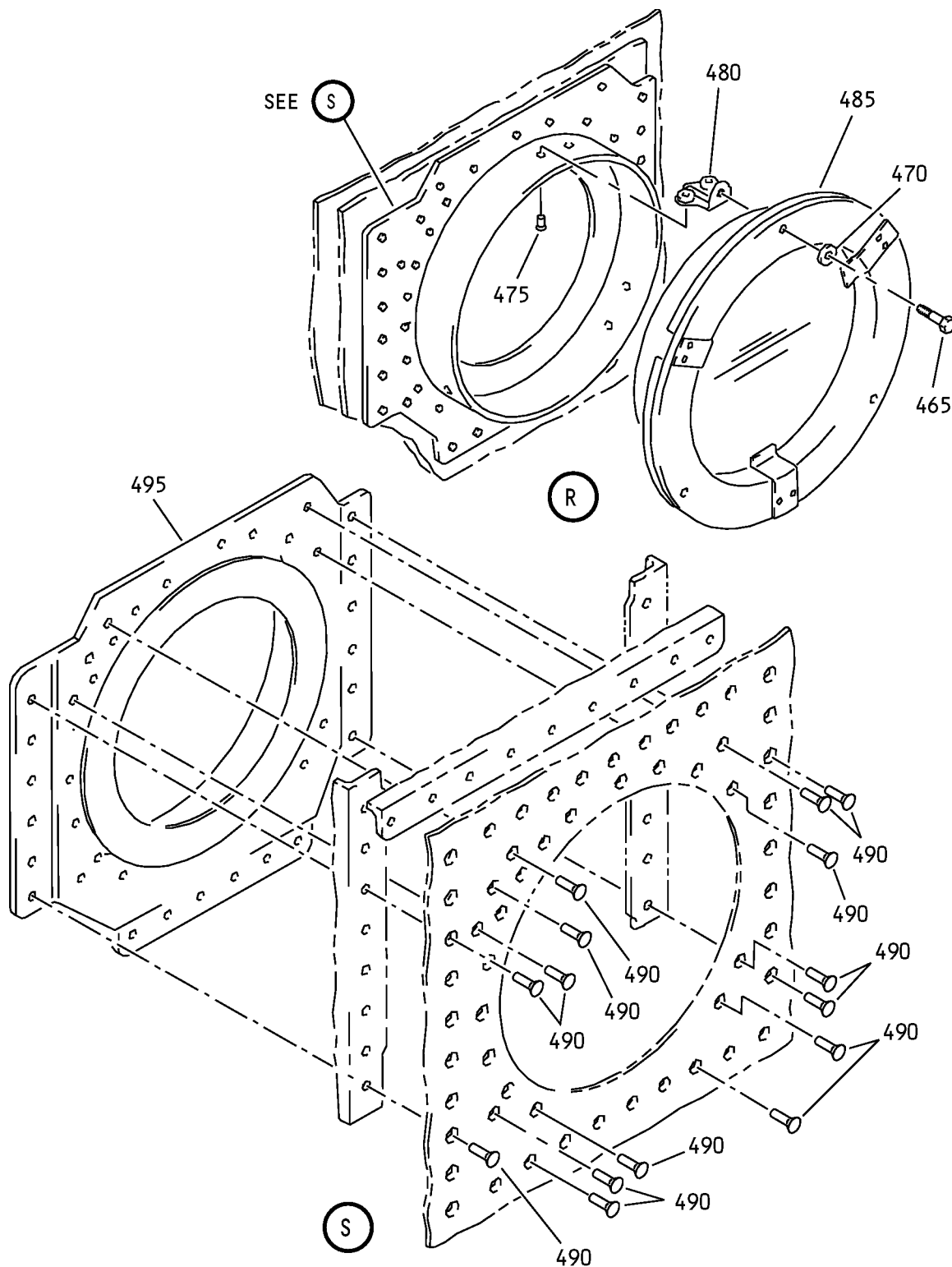
COMPONENT MAINTENANCE MANUAL



Forward Galley Door Assembly  
IPL Figure 1 (Sheet 12 of 25)

**52-41-05**  
ILLUSTRATED PARTS LIST  
Page 1055  
Nov 01/2008

COMPONENT MAINTENANCE MANUAL



Forward Galley Door Assembly  
IPL Figure 1 (Sheet 13 of 25)

**52-41-05**

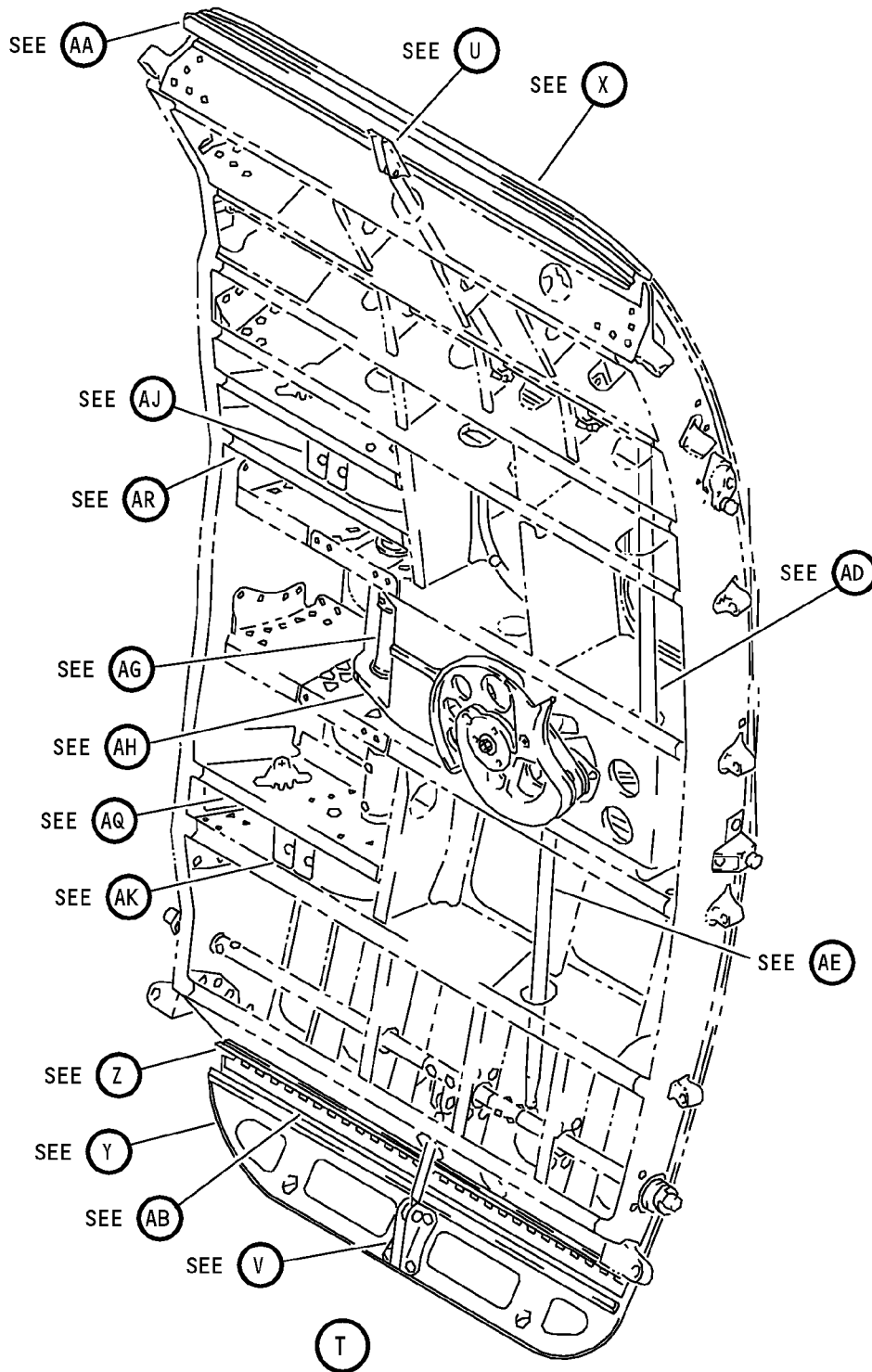
ILLUSTRATED PARTS LIST

Page 1056

Nov 01/2008



COMPONENT MAINTENANCE MANUAL



Forward Galley Door Assembly  
IPL Figure 1 (Sheet 14 of 25)

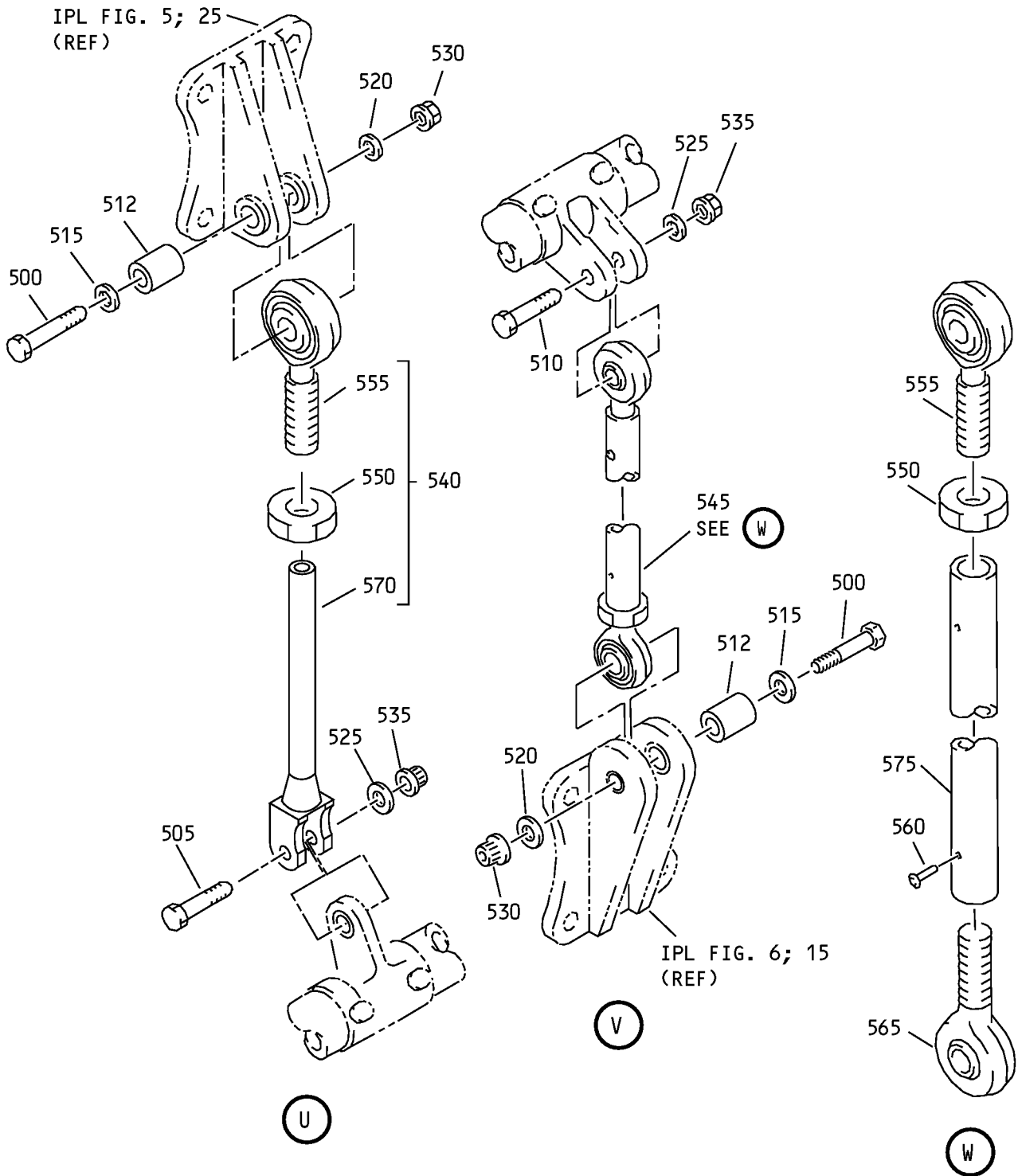
**52-41-05**

ILLUSTRATED PARTS LIST

Page 1057

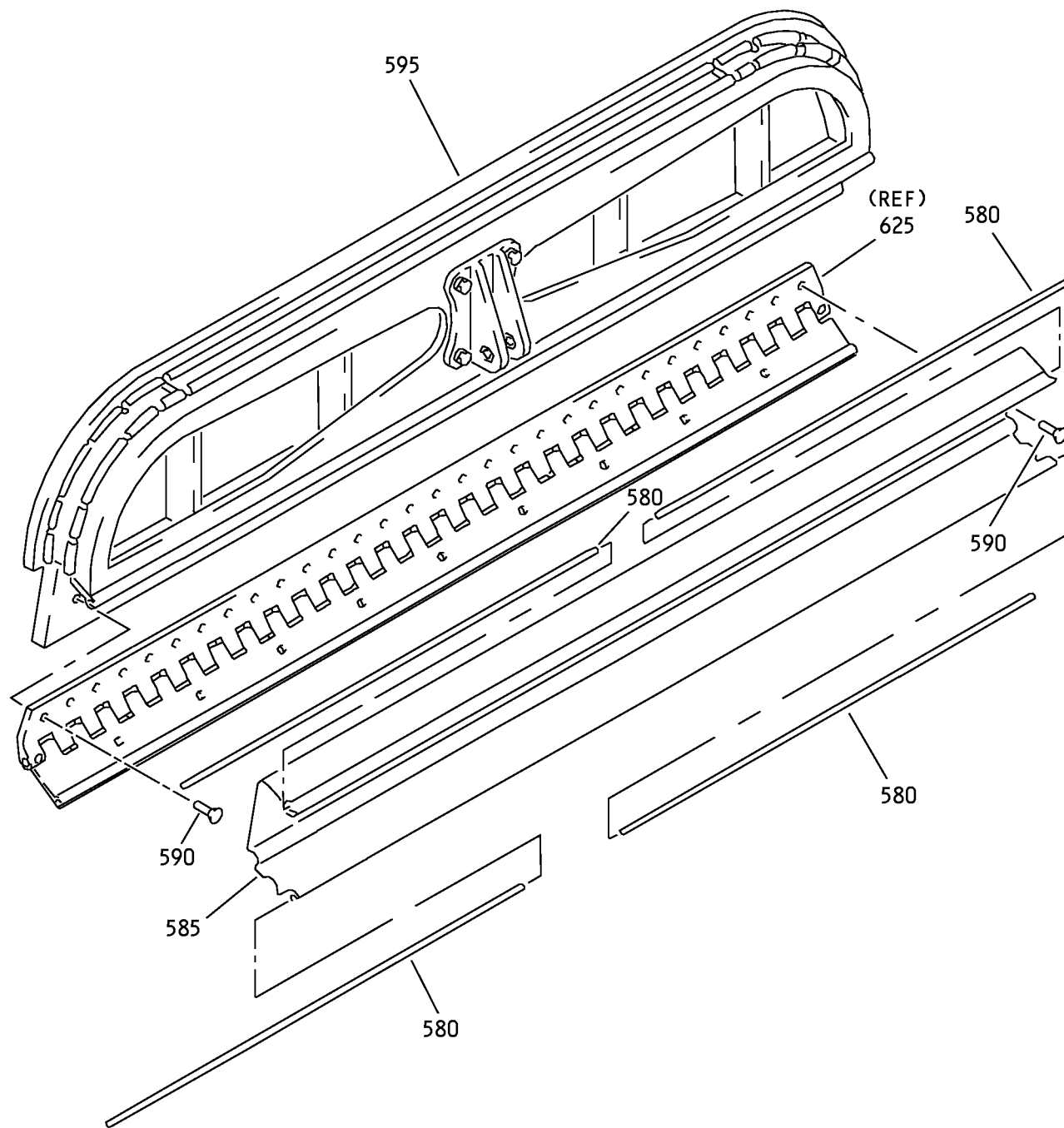
Nov 01/2008

COMPONENT MAINTENANCE MANUAL



Forward Galley Door Assembly  
IPL Figure 1 (Sheet 15 of 25)

COMPONENT MAINTENANCE MANUAL



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Forward Galley Door Assembly  
IPL Figure 1 (Sheet 16 of 25)

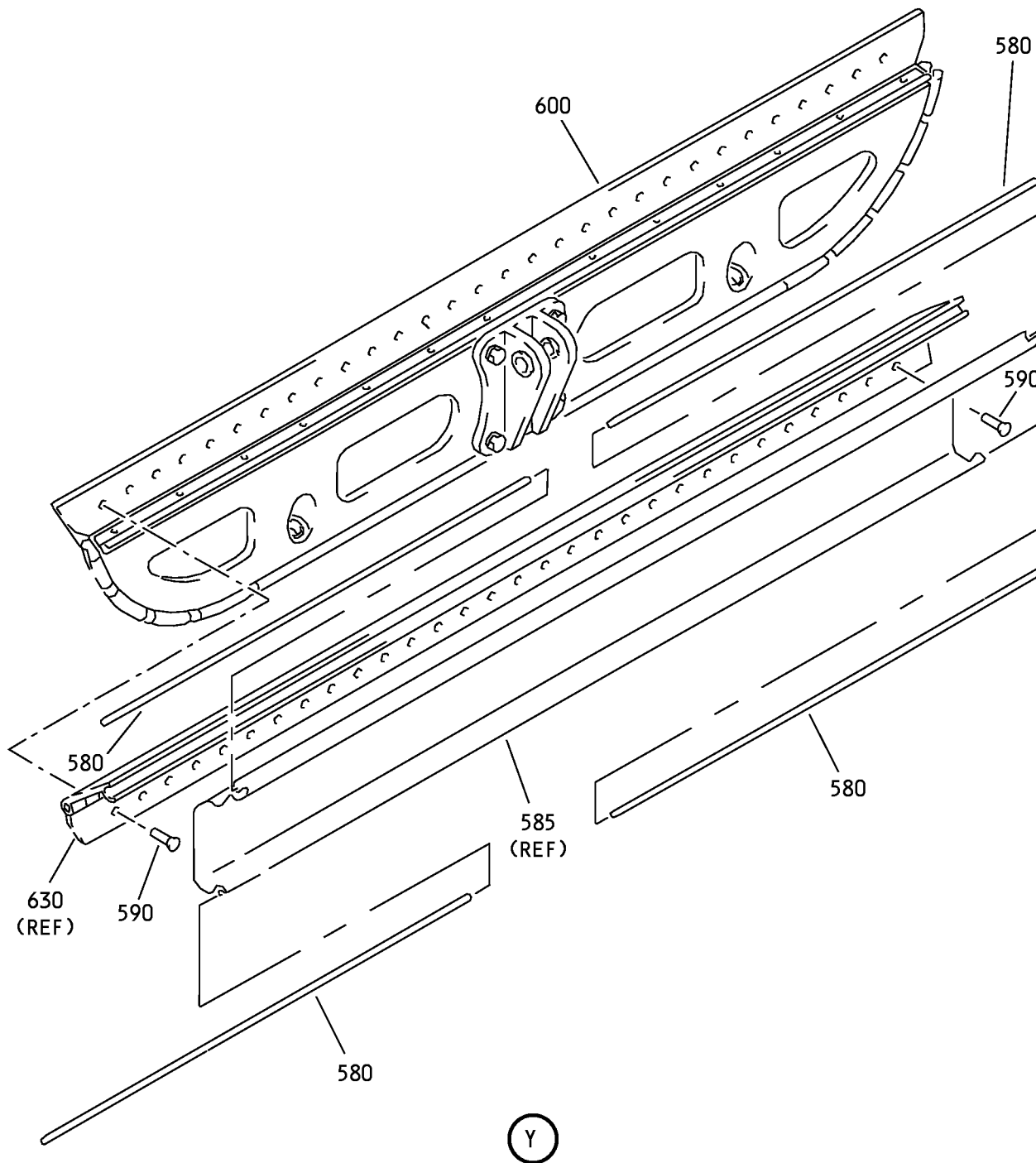
# 52-41-05

ILLUSTRATED PARTS LIST

Page 1059

Nov 01/2008

COMPONENT MAINTENANCE MANUAL

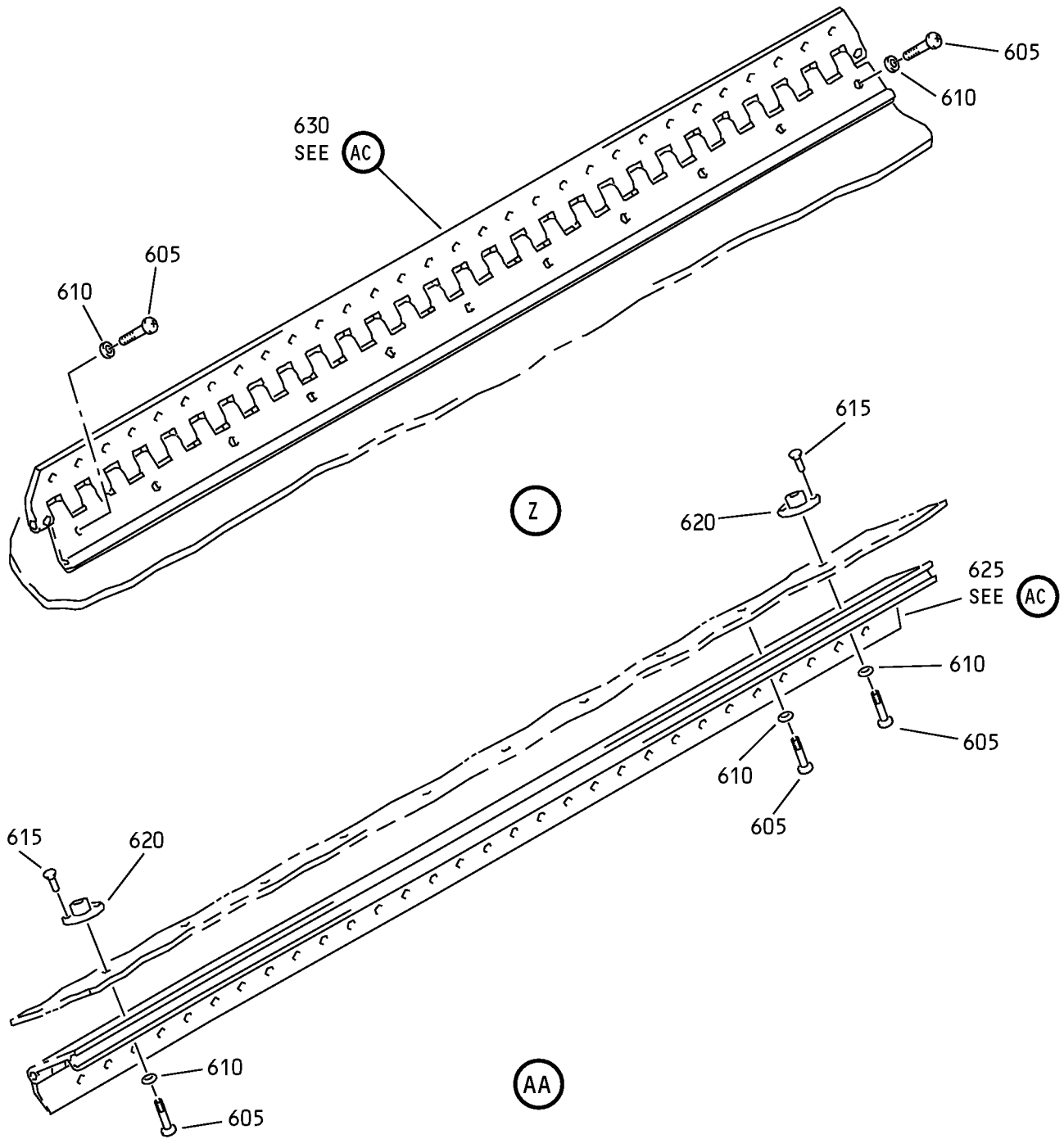


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Forward Galley Door Assembly  
IPL Figure 1 (Sheet 17 of 25)

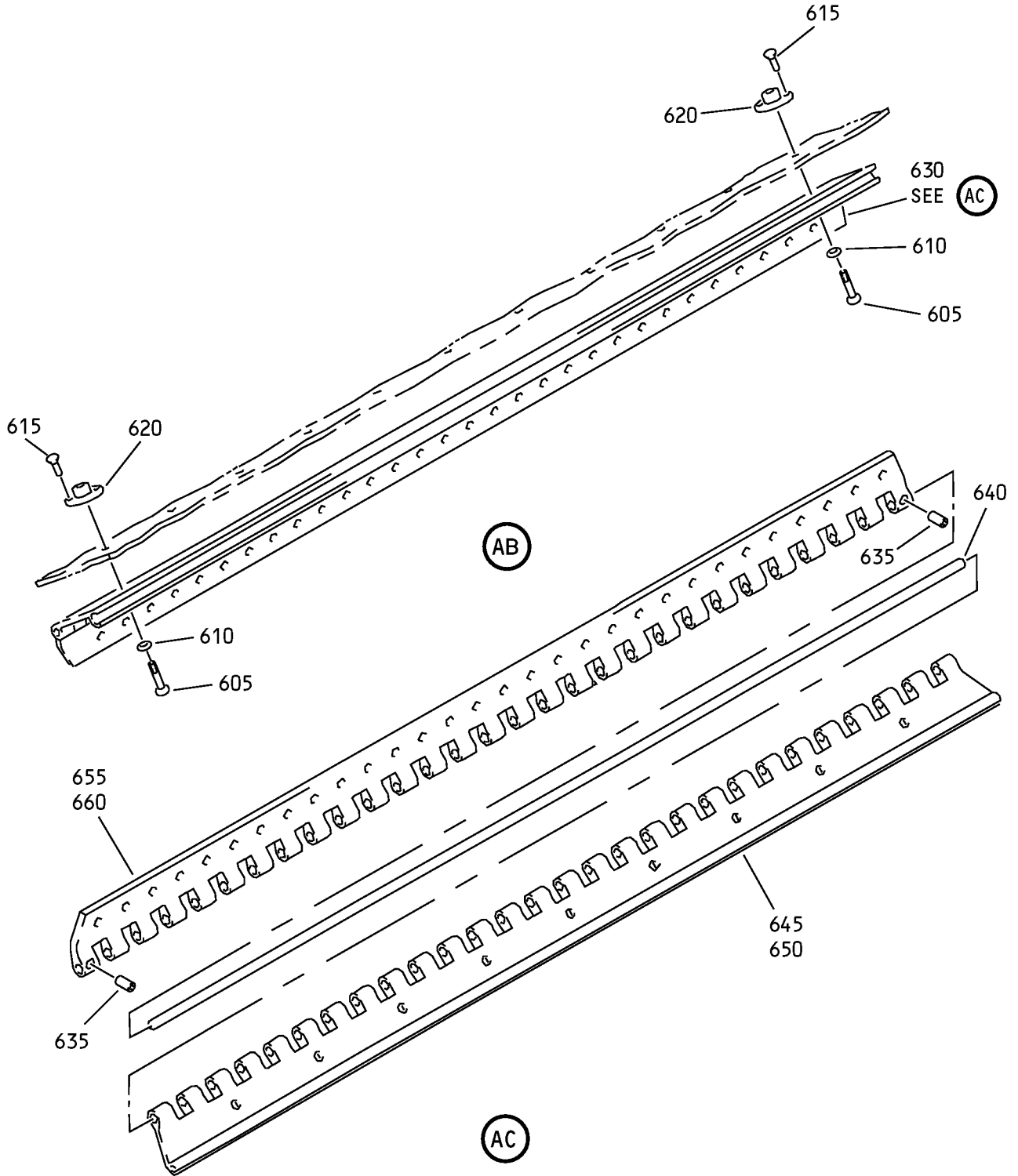
**52-41-05**  
ILLUSTRATED PARTS LIST  
Page 1060  
Nov 01/2008

COMPONENT MAINTENANCE MANUAL



Forward Galley Door Assembly  
IPL Figure 1 (Sheet 18 of 25)

COMPONENT MAINTENANCE MANUAL



Forward Galley Door Assembly  
IPL Figure 1 (Sheet 19 of 25)

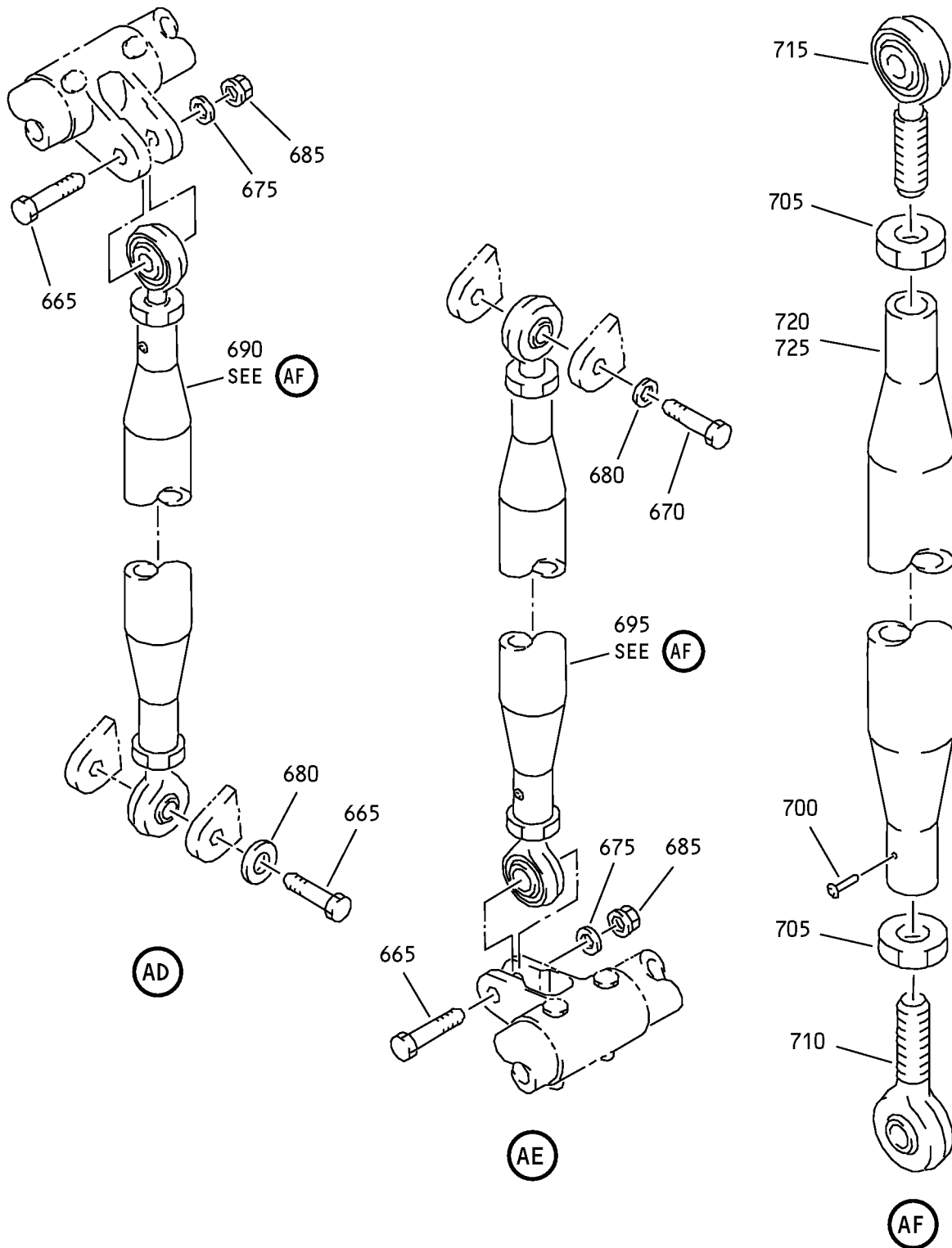
**52-41-05**

ILLUSTRATED PARTS LIST

Page 1062

Nov 01/2008

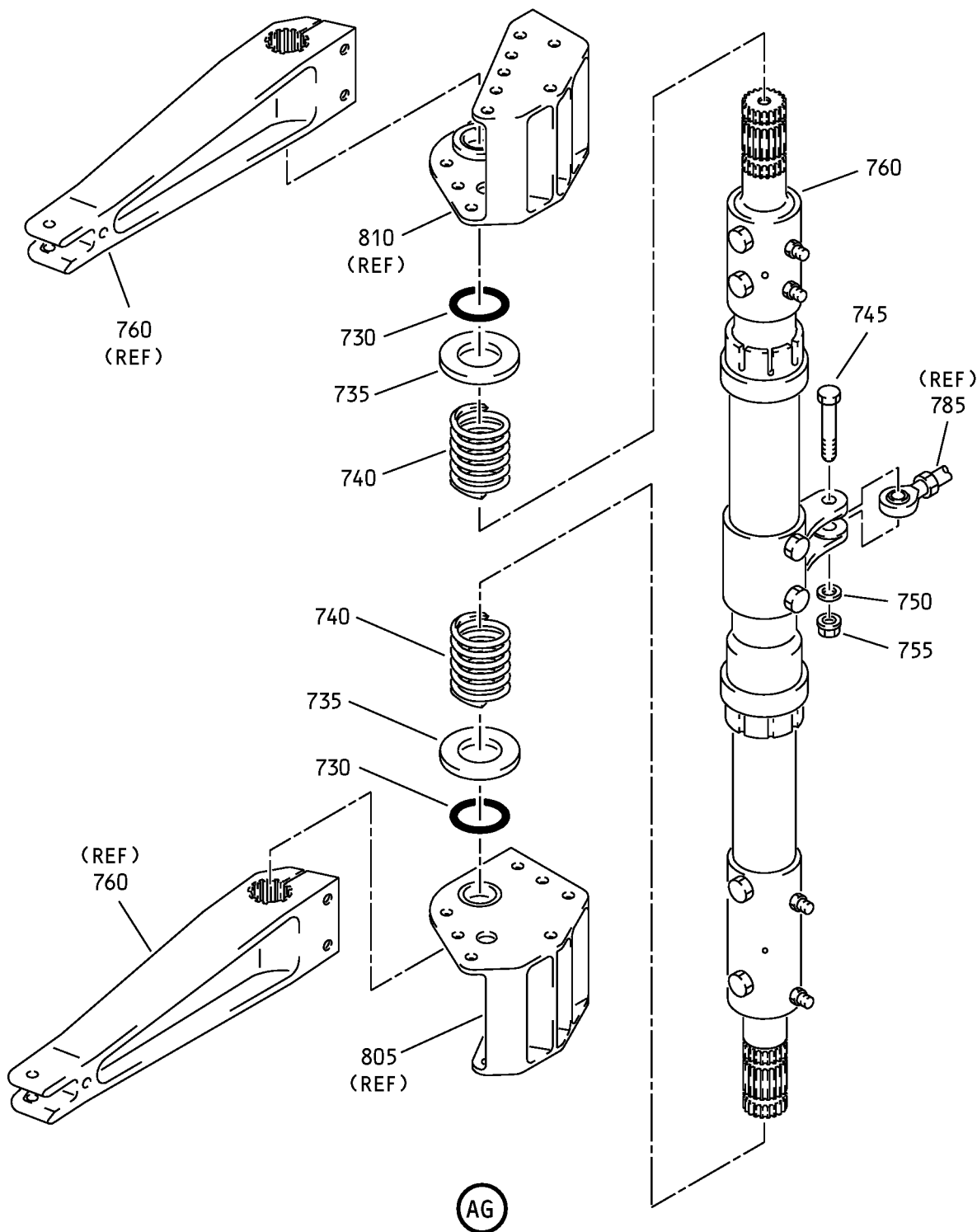
COMPONENT MAINTENANCE MANUAL



Forward Galley Door Assembly  
IPL Figure 1 (Sheet 20 of 25)

**52-41-05**  
ILLUSTRATED PARTS LIST  
Page 1063  
Nov 01/2008

COMPONENT MAINTENANCE MANUAL



Forward Galley Door Assembly  
IPL Figure 1 (Sheet 21 of 25)

**52-41-05**

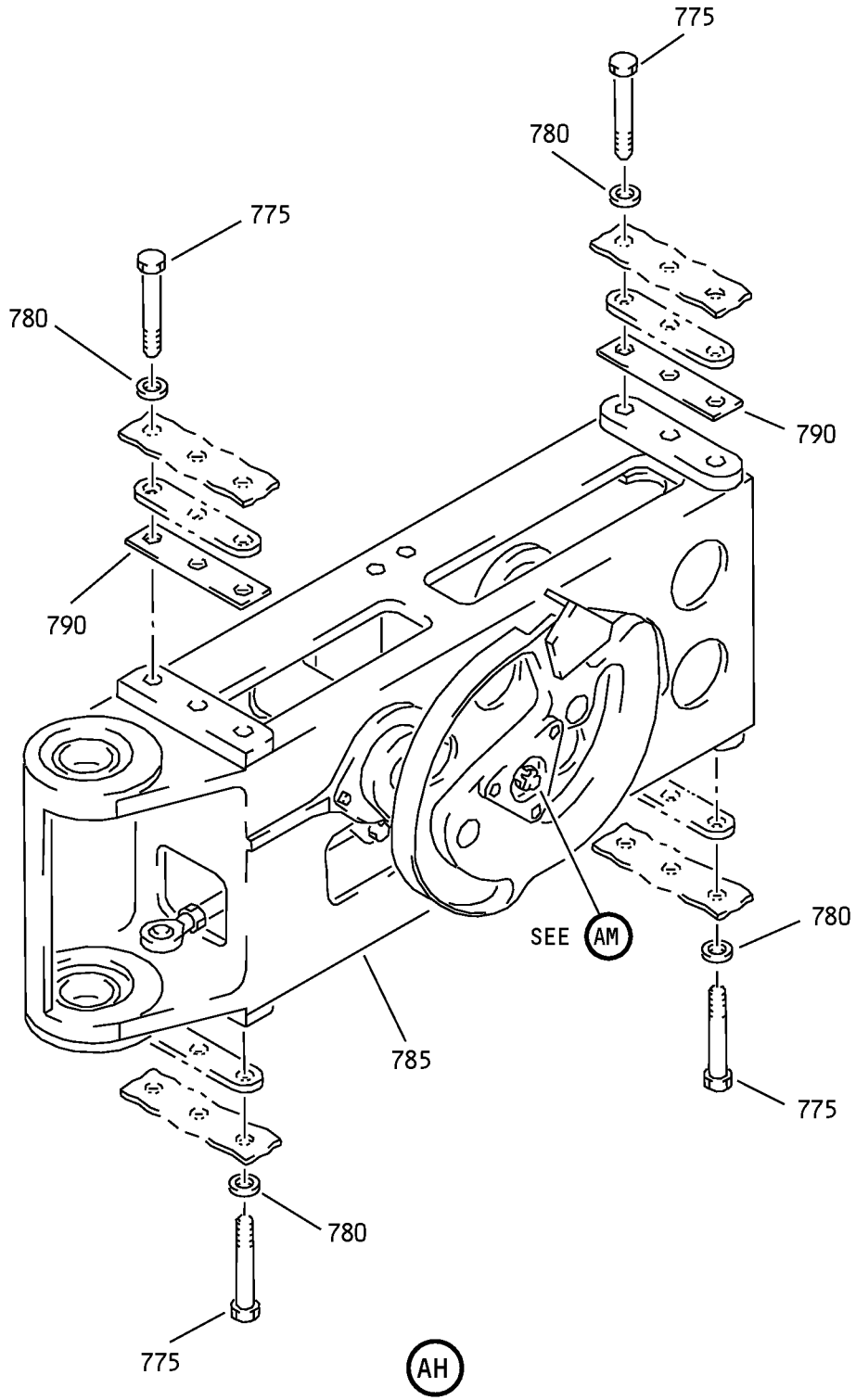
ILLUSTRATED PARTS LIST

Page 1064

Nov 01/2008

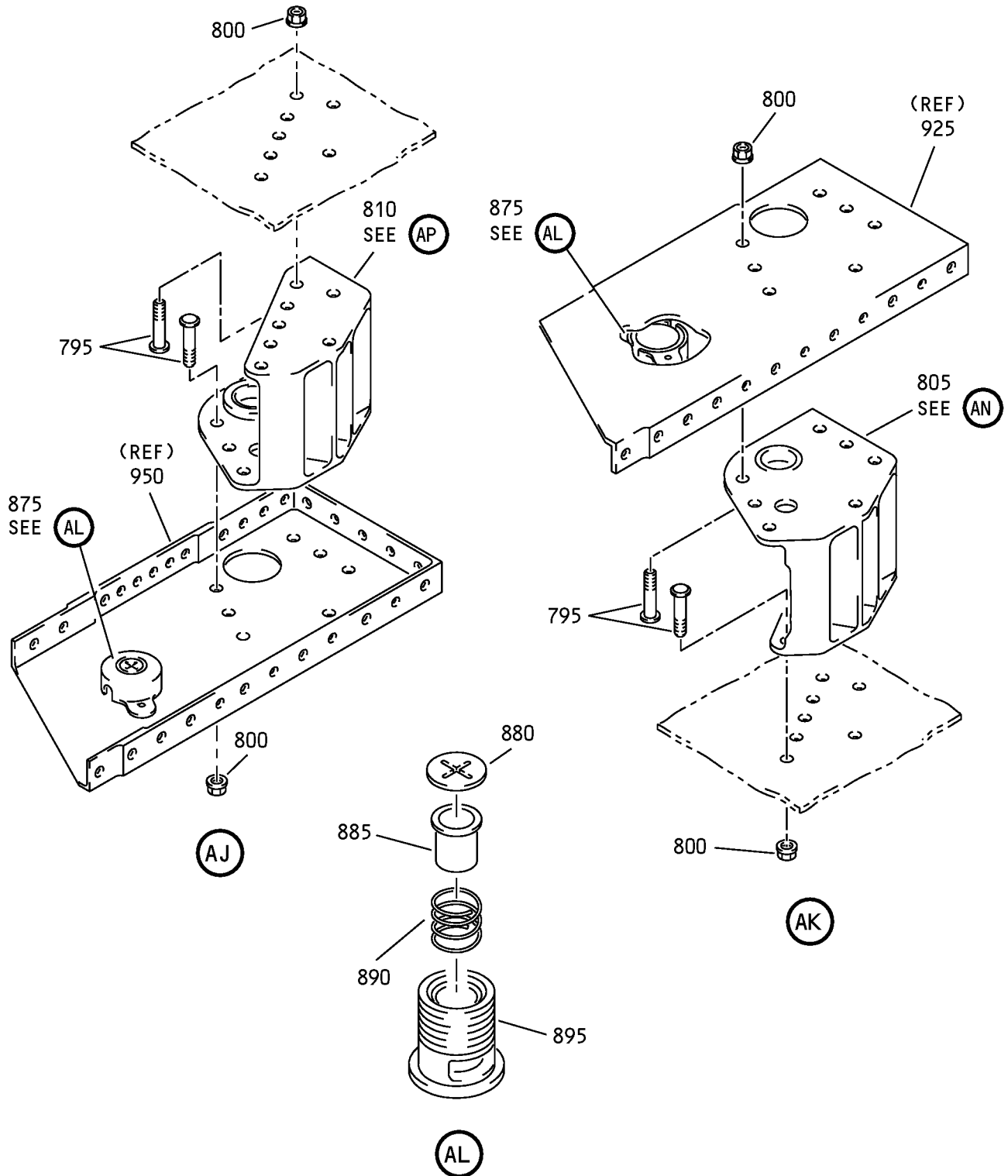


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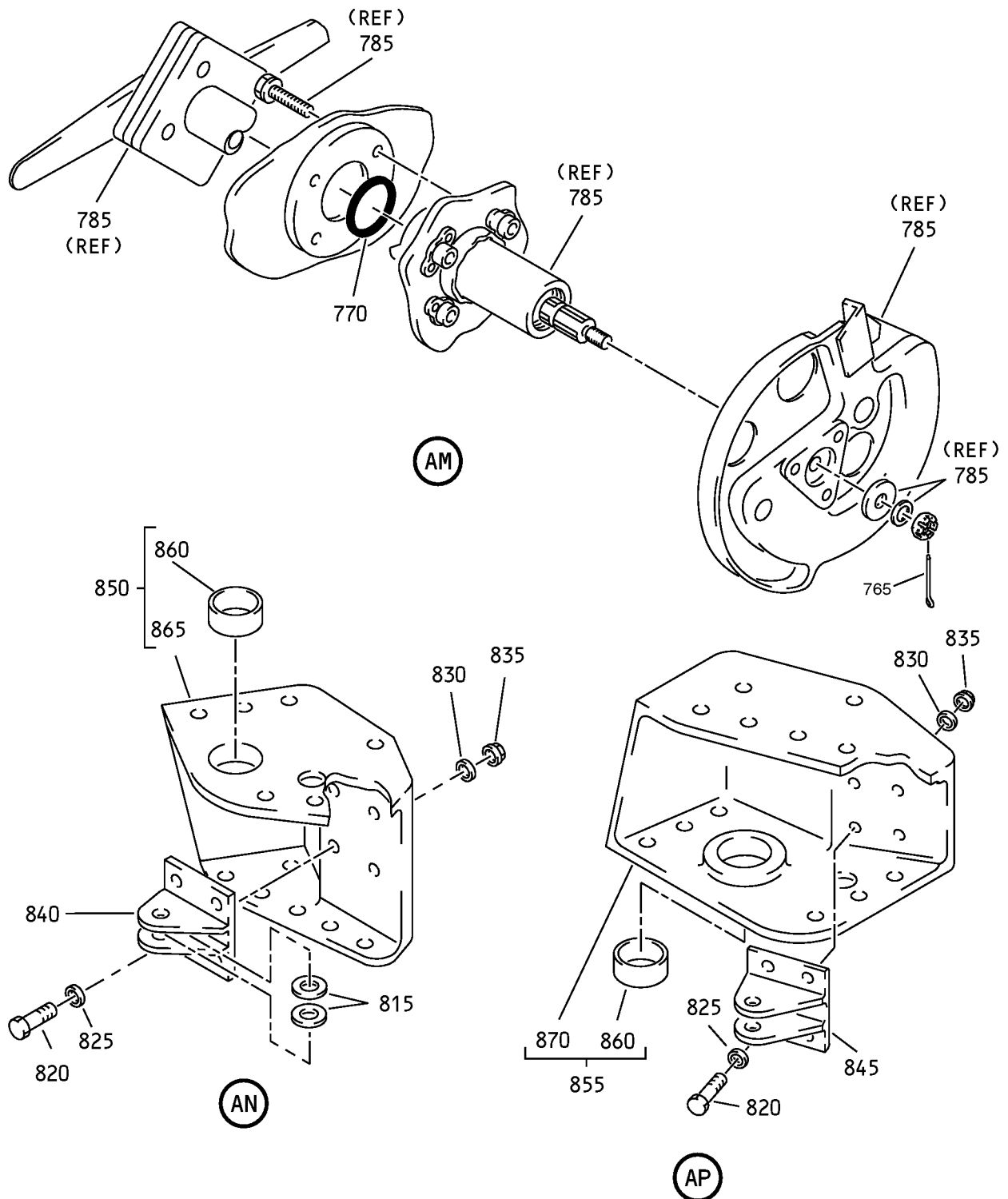
Forward Galley Door Assembly  
IPL Figure 1 (Sheet 22 of 25)

COMPONENT MAINTENANCE MANUAL



Forward Galley Door Assembly  
IPL Figure 1 (Sheet 23 of 25)

COMPONENT MAINTENANCE MANUAL



Forward Galley Door Assembly  
IPL Figure 1 (Sheet 24 of 25)

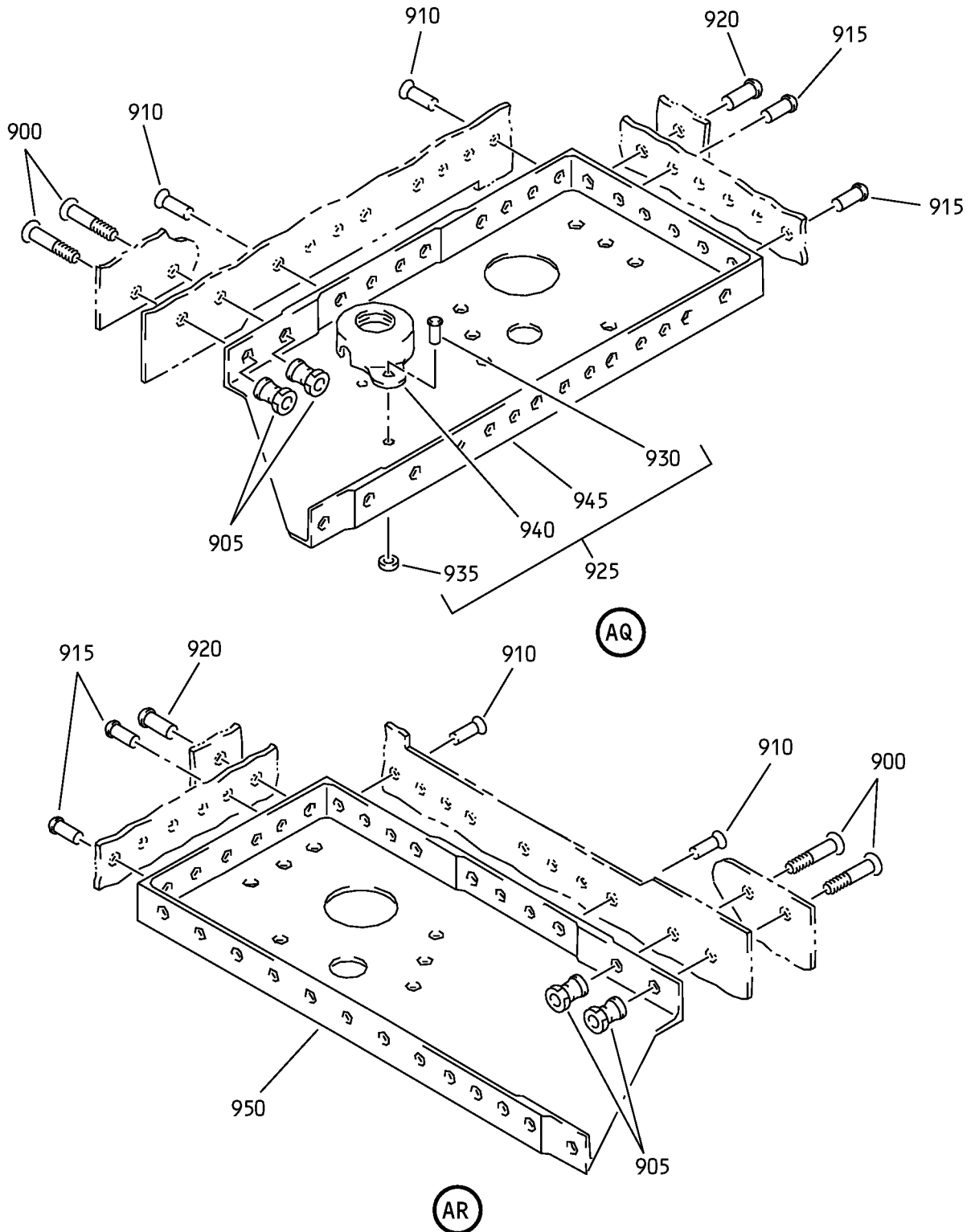
**52-41-05**

ILLUSTRATED PARTS LIST

Page 1067

Nov 01/2008

COMPONENT MAINTENANCE MANUAL



Forward Galley Door Assembly  
IPL Figure 1 (Sheet 25 of 25)

**52-41-05**

ILLUSTRATED PARTS LIST

Page 1068

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-1A	141A6516-2										
-1B	141A6516-3										
-1C	141A6516-5										
-1D	141A6516-6										
-1E	141A6516-7									E	RF
-1F	141A6516-2									A	RF
-1G	141A6516-3									B	RF
-1H	141A6516-4									C	RF
-1J	141A6516-8									D	RF
-1K	141A6516-9									F	RF
-1L	141A6516-10									G	RF
-1M	141A6516-11									H	RF
-1N	141A6516-12									J	RF
-1P	141A6516-13									K	RF
-1Q	141A6516-14									L	RF

-Item not Illustrated

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1069

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
-1R	141A6516-15									M	RF
-1S	141A6516-16									N	RF
-1T	141A6516-17									P	RF
-1U	141A6516-18									Q	RF
-1V	141A6516-19									R	RF
-1W	141A6516-20									S	RF
-1X	141A6516-21									T	RF
5	HST10AG6-5										3
10	CR6551-3										3
15	BACR15GK6E3										13
20	BACR15GK6E3										DELETED
25	HST10AG6-5										1

-Item not Illustrated

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1070

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
30	CR6551-3		.								1
35	BACR15GK6E4		.								5
40	BACR15GK6E5		.								2
45	BACR15GK5E3		.								4
50	BACF3H08NK009H~ G		.							B-K, S, T	1
55	149A9480-4		.								1
60	BACR15BA3D		..								4
65	BRF200C4D		..								2
70	66-9776		..								2
75	149A9480-47		..								1
80	149A9480-61		.								1
85	BACR15BA3D		..								2
90	BACR15BA5D		..								2
95	BRF200C4D		..								1
100	149A9480-65		..								1
105	BACB30NT3K1		..								3
110	NAS1149D0363J		..								3
115	BACR15BA4D		..								6

-Item not Illustrated

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1071

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
120	SL2808-3		. .								3
125	149A9480-63		. .								1
130	149A9480-57		. .								1
135	149A9480-62		. .								1
140	BACR15BA3D		. .								2
145	BACR15BA5D		. .								2
150	BRF200C4D		. .								1
155	149A9480-66		. .								1
160	BACB30NT3K1		. .								3
165	NAS1149D0332J		. .								3
170	BACR15BA4D		. .								6
175	DE679-10		. .								3
180	149A9480-64		. .								1
185	149A9480-58		. .								1
190	149A9480-1		. .								1
195	BACB30NT3K16		. .								2
200	NAS1149D0363J		. .								2
205	H52732-3CD		. .								2
210	149A9480-48		. .								1
215	149A9480-38		. .								1

-Item not Illustrated

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1072

Nov 01/2008





COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
220	149A9480-51		.	.	BRACKET						1
225	BACS12GU3K10		.		SCREW						34
230	NAS1149D0316J		.		WASHER						34
235	BACR15GE3CW2		.		RIVET						10
240	BACR15GE3CW4		.		RIVET						4
245	BACR15GE3CW3		.		RIVET						6
250	NS202494-02-2		.		NUTPLATE						5
					(V80539)						
					(SPEC BACN10KE3E2CD)						
					(OPT 102F9216-2-3 (V72962))						
					(OPT F51751-3-2CD (V15653))						
					(OPT BRFR120C3-2D (V52828))						
255	NS202493-02-2		.		NUTPLATE						4
					(V80539)						
					(SPEC BACN10KE3B2CD)						
					(OPT F51747-3-2CD (V15653))						
					(OPT 102A9213-2-3 (V72962))						
					(OPT BRFR220C3-2D (V52828))						
260	NS202495-02		.		NUTPLATE						1
					(V80539)						
					(SPEC BACN10KE3DCD)						
					(OPT F51753-3DC (V15656))						
265	141A6553-5		.		PLATE-COVER						2
270	141A6553-3		.		PLATE-COVER						1
275	141A6553-2		.		PLATE-COVER				A-E, G		1
-275A	141A6553-6		.		PLATE-COVER				F, H-T		1
280	BACR15GK6E4		.		RIVET						8
285	SL2808-3		.		SHOCKMOUNT						4
					(V97393)						
					(SPEC BACS14K1)						
					(OPT DE685-10 (V71985))						
290	BACR15GF5D		.		RIVET						4
					(SIZE DETERMINED ON INST)						
295	BACR15GK5E3		.		RIVET						8
300	SL2509		.		SHOCKMOUNT						4
					(V97393)						
					(SPEC BACS14K7)						
					(OPT J7444-11 (V76005))						
					(OPT DE586 (V71985))						

-Item not Illustrated

**52-41-05**



COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
305	141A6558-1		.								1
310	82-99-341-26		.	.							4
								(V94222)			
								(SPEC BACS21AP260RP)			
315	NAS1149D0463J		.	.							4
320	NAS1149D0416J		.	.							4
325	BACR15AG2C		.	.							4
330	141A6558-2		.	.							1
-335	MS21141U6P4										
335A	MS21141U0604P		.								7
-340	MS21141U6P3										
-340A	MS21141U0603P		.								8
345	HST10AG6-4		.								4
								(V06725)			
								(SPEC BACB30VT6K4)			
								(OPT HST10AG6-4 (V73197))			
								(OPT HST10AG6-4 (V56878))			
								(OPT HST10AG6-4 (V0PTK6))			
350	HST10AG6-5		.								1
								(V0PTK6)			
								(SPEC BACB30VT6K5)			
								(OPT HST10AG6-5 (V06725))			
								(OPT HST10AG6-5 (V56878))			
								(OPT HST10AG6-5 (V73197))			
								(OPT WC10K6-5 (V60516))			
355	CR6551-3		.								5
								(VF0224)			
								(SPEC BACN10ZV3)			
360	BACR15GK6E4		.								19
365	BACR15GK6E3		.								57
370	BACR15GK6E2		.								145
375	BACR15GK5E2		.								133
380	BACR15GF5D		.								27
								(SIZE DETERMINED ON INST)			
385	BACR15GE3CW2		.								32

-Item not Illustrated

**52-41-05**

ILLUSTRATED PARTS LIST

Page 1074

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
390	F51643-3BAC		.								7
395	NS202493-02-2		.								6
400	NS202494-02-2		.								2
405	F51646-3BAC		.								1
410	BACF3H07DF011HN		.								1
415	141A6552-2		.								1
420	141A6552-1		.								1
425	BACR15BA3AD		. .								8
430	F51643-3BAC		. .								4
435	BACR15FT5D		. .								12
440	BACW10P182AL		. .								10
445	SL2808-3		. .								6
450	141A6552-5		. .								1
455	141A6552-4		. .								1

-Item not Illustrated

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1075

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
460	141A6552-3		.	.	SKIN (USED ON ITEM 420)						1
465	BACB30NM3K3		.		BOLT						3
470	BACW10BN3AC		.		WASHER						3
475	BACR15GF4D		.		RIVET (SIZE DETERMINED ON INST)						6
480	T8059S1032B1		.		NUTPLATE (V52828) (SPEC BACN10MK3-45) (OPT T8059S1032B1 (V11815))						3
485	65-2863-8		.		WINDOW ASSY-OBSV (FOR DETAILS SEE FIG. 4)				A-R		1
-485A	141A6570-1		.		WINDOW ASSY-OBSV (FOR DETAILS SEE FIG. 4)				S, T		1
490	BACR15GF6D		.		RIVET (SIZE DETERMINED ON INST)						38
495	149A6112-3		.		DOUBLER-WINDOW						1
500	BACB30NM4K16		.		BOLT						2
505	BACB30NM4K14		.		BOLT						1
510	BACB30NM4K13		.		BOLT						1
512	BACB28AK04-030		.		BUSHING						2
515	BACW10BN4AC		.		WASHER						2
520	NAS1149D0463J		.		WASHER						2
525	NAS1149E0432R		.		WASHER						2
530	H52732-4CD		.		NUT (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))						2
535	H52732-4CM		.		NUT (V15653) (SPEC BACN10YR4CM) (OPT PLH54CM (V62554))						2
540	69-18187-27		.		ROD ASSY-CONT						1
545	69-18187-21		.		ROD ASSY-CONT						1
550	AN316-5R		.	.	NUT						1

-Item not Illustrated

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1076

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1- 555	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
560	MS20470D5		. . RIVET (SIZE DETERMINED ON INST) (USED ON ITEM 545)								1
565	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 565A) (USED ON ITEM 545)								1
-565A	AB4E27FN		. . BEARING (V15860) (SPEC BACB10A187L) (OPT BRE4140L (V81376)) (OPT HB4E135 (V02758)) (OPT KB4ESSFN (V97613)) (OPT MXJ45-14BFG (V73134)) (OPT 51564-0402 (V09455)) (OPT AR4E4FN (VS0352)) (OPT ASM4F6 (V56644)) (OPT ITEM 565) (USED ON ITEM 545)								1
570	66-14618-13		. . ROD (USED ON ITEM 540)								1
575	66-14618-5		. . ROD (USED ON ITEM 545)								1

-Item not Illustrated

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1077

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
580	65-45871-504										8
585	S14063-3									A	1
-585A	10-60476-13										
-585B	9554									B-T	1
590	BACR15BA5B										60
595	141A6540-2									A-K	1
-595A	141A6540-4									L-T	1
600	141A6540-1									A-K	1
-600A	141A6540-3									L-T	1
605	BACB30NT3K4										21
610	BACW10CT6J										21
615	BACR15BA3AD										42
620	F51643-3BAC										21
625	141A6531-2										1
630	141A6531-1									A-H	1
-630A	141A6531-7									J-T	1
635	MS39086-125										2
640	MS20253P2-2910										1

-Item not Illustrated

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1078

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
645	141A6531-4		.	.	HINGE-HALF (USED ON ITEM 625)						1
650	141A6531-3		.	.	HINGE-HALF (USED ON ITEM 630)				A-H		1
-650A	141A6531-8		.	.	HINGE-HALF (USED ON ITEM 630A)				J-T		1
655	141A6531-6		.	.	HINGE-HALF (USED ON ITEM 625)						1
660	141A6531-5		.	.	HINGE-HALF (USED ON ITEMS 630, 630A)						1
665	BACB30NM4K13		.		BOLT						2
670	BACB30NR4K13		.		BOLT						2
675	NAS1149E0432R		.		WASHER						2
680	BACW10BN4AC		.		WASHER						2
685	H52732-4CM		.		NUT (V15653) (SPEC BACN10YR4CM) (OPT PLH54CM (V62554))						2
690	65-28925-83		.		ROD ASSY-CONT				A-E, G		1
-690A	65-28925-98		.		ROD ASSY-CONT				F, H-T		1
695	65-28925-84		.		ROD ASSY-CONT				A-E, G		1
-695A	65-28925-99		.		ROD ASSY-CONT				F, H-T		1
700	MS20470D3		.	.	RIVET (SIZE DETERMINED ON INST)						1
705	AN316-5R		.	.	NUT						2
710	AB4E27FN		.	.	BEARING (V15860) (SPEC BACB10A187L) (OPT BRE4140L (V81376)) (OPT HB4E135 (V02758)) (OPT KB4ESSFN (V97613)) (OPT MXJ45-14BFG (V73134)) (OPT 51564-0402 (V09455)) (OPT AR4E4FN (VS0352)) (OPT ASM4F6 (V56644))			A-E, G		1	

-Item not Illustrated

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1079

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE	USAGE CODE	UNITS PER ASSY
1- -710A	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))	F, H-T	1
715	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
720	65-28925-43		. . ROD (USED ON ITEM 690)	A-E, G	1
-720A	65-28925-102		. . ROD (USED ON ITEM 690A)	F, H-T	1
725	65-28925-44		. . ROD (USED ON ITEM 695)	A-E, G	1
-725A	65-28925-103		. . ROD (USED ON ITEM 695A)	F, H-T	1
730	M83461-1-214		. PACKING		2
735	NAS1149C1790R		. WASHER		2
740	66-15645-1		. SPRING-CPRSN		2
745	BACB30NM5K15		. BOLT		1
750	NAS1149E0563R		. WASHER		1
755	H52732-5CM		. NUT (V15653) (SPEC BACN10YR5CM) (OPT PLH55CM (V62554))		1

-Item not Illustrated

**52-41-05**  
ILLUSTRATED PARTS LIST  
Page 1080  
Nov 01/2008





## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE	USAGE CODE	UNITS PER ASSY
1-					
760	141A6517-1		. TUBE ASSY-TORQUE (FOR DETAILS SEE FIG. 7)	A, B	1
-760A	141A6517-2		. TUBE ASSY-TORQUE (FOR DETAILS SEE FIG. 7)	C-T	1
765	BACP18BC03A08P		. PIN-COTTER		1
770	M83461-1-325		. PACKING		1
775	BACB30NM4K17		. BOLT		12
780	BACW10BN4AC		. WASHER		12
785	141A6521-2		. BOX ASSY-HANDLE (FOR DETAILS SEE FIG. 8)		1
790	BACS40R008C042F		. SHIM		AR
795	HST10AG6-3		. BOLT (V0PTK6) (SPEC BACB30VT6K3) (OPT HST10AG6-3 (V06725)) (OPT HST10AG6-3 (V56878)) (OPT HST10AG6-3 (V73197)) (OPT WC10K6-3 (V60516))		28
800	CR6551-3		. NUT (VF0224) (SPEC BACN10ZV3)		28
805	141A6526-1		. SUPPORT ASSY-HINGE		1
810	141A6526-2		. SUPPORT ASSY-HINGE		1
815	NAS1149D0532J		. . WASHER (SELECT FROM) (USED ON ITEM 805)		AR
-815A	NAS1149D0516J		. . WASHER (SELECT FROM) (USED ON ITEM 805)		AR
820	BACB30NM3K8		. . BOLT		4
825	BACW10CT6J		. . WASHER		4
830	NAS620A10L		. . WASHER		4
835	NAS1805-3L		. . NUT		4
840	69-70269-3		. . FITTING (USED ON ITEM 805)		1
845	69-70269-4		. . FITTING (USED ON ITEM 810)		1

-Item not illustrated

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1081

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1-											
850	141A6527-1		. .								1
855	141A6527-2		. .								1
860	NAS76A16-016P		. . .								1
865	141A6527-3		. . .								1
870	141A6527-4		. . .								1
875	140N2022-1		. VALVE								2
880	140N2022-4		. . CAP								1
885	140N2022-3		. . PLUNGER								1
890	140N2020-1		. . SPRING								1
895	140N2022-2		. . HOUSING								1
900	HST11AG6-4		. BOLT (V06725) (SPEC BACB30VU6K4) (OPT HST11AG6-4 (V73197)) (OPT HST11AG6-4 (V0PTK6)) (OPT HST11AG6-4 (V56878))						A-R		4
-900A	BACB30YP6K4		. BOLT						S, T		4
905	CR6551-3		. NUT (VF0224) (SPEC BACN10ZV3)						A-R		4
910	BACR15GF6D		. RIVET (SIZE DETERMINED ON INST)								16
915	BACR15FT5D		. RIVET (SIZE DETERMINED ON INST)								10
920	BACR15FT6D		. RIVET (SIZE DETERMINED ON INST)								2
925	141A6525-1		. BEAM ASSY-HINGE SPRT								1
930	BACR15BB4D		. . RIVET (SIZE DETERMINED ON INST)								2
935	NAS1149DN432H		. . WASHER								2
940	140N2021-1		. . RETAINER-DRAIN VALVE								1
945	141A6525-3		. . BEAM-STUB								1

-Item not Illustrated

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1082

Nov 01/2008

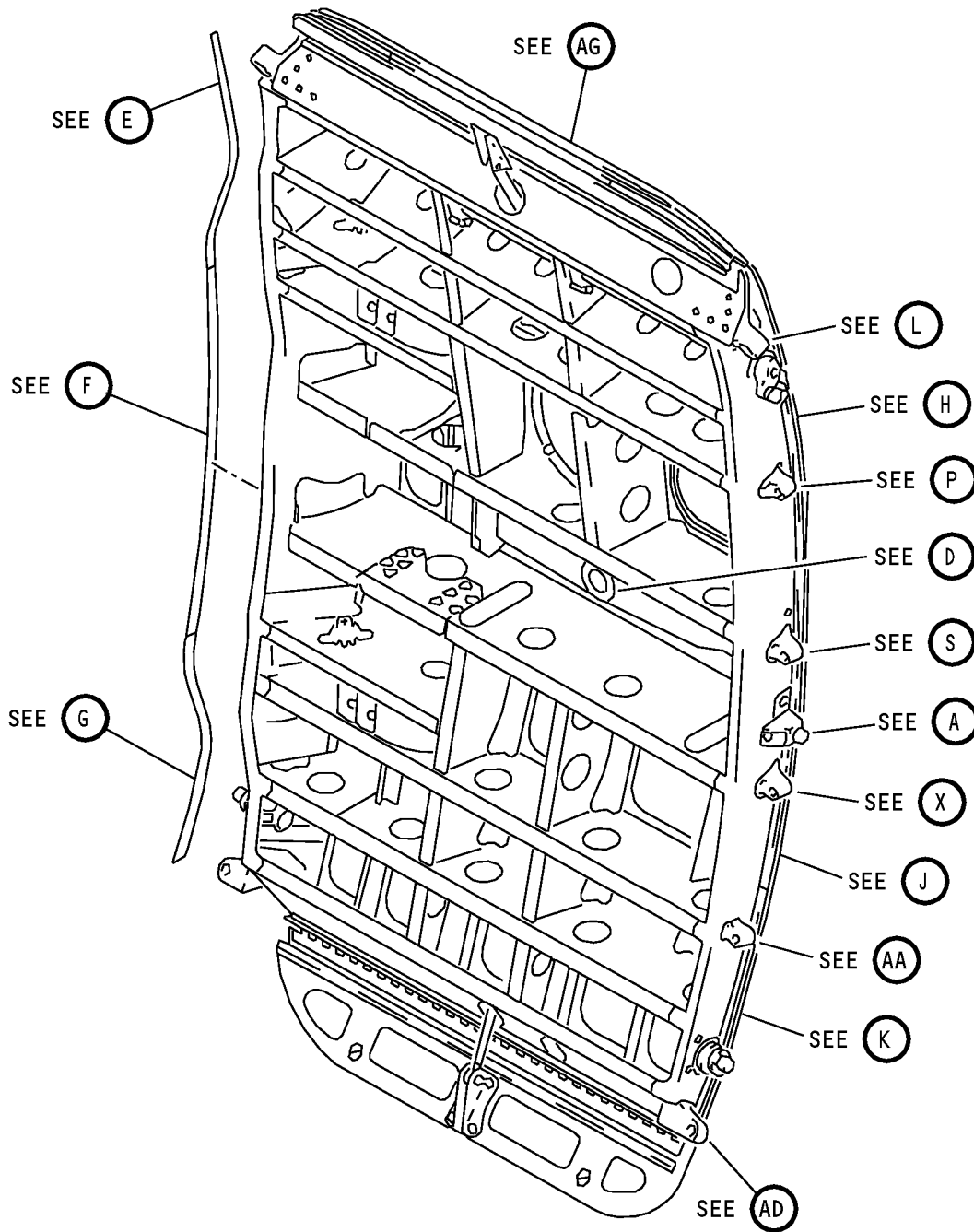


## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
1- 950	141A6525-2										1

-Item not Illustrated

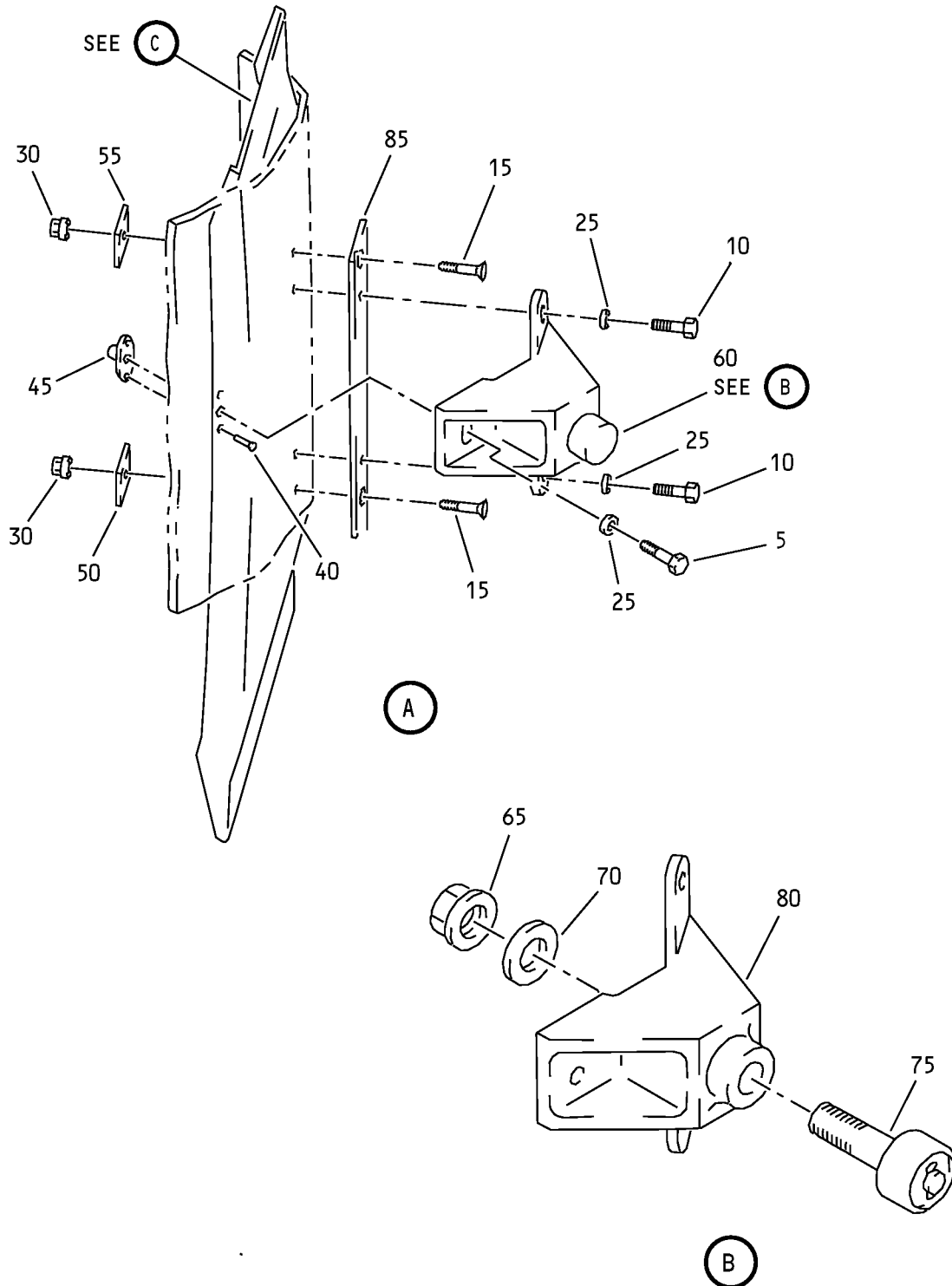
COMPONENT MAINTENANCE MANUAL



Forward Galley Door Assembly  
IPL Figure 2 (Sheet 1 of 37)

**52-41-05**  
ILLUSTRATED PARTS LIST  
Page 1084  
Nov 01/2008

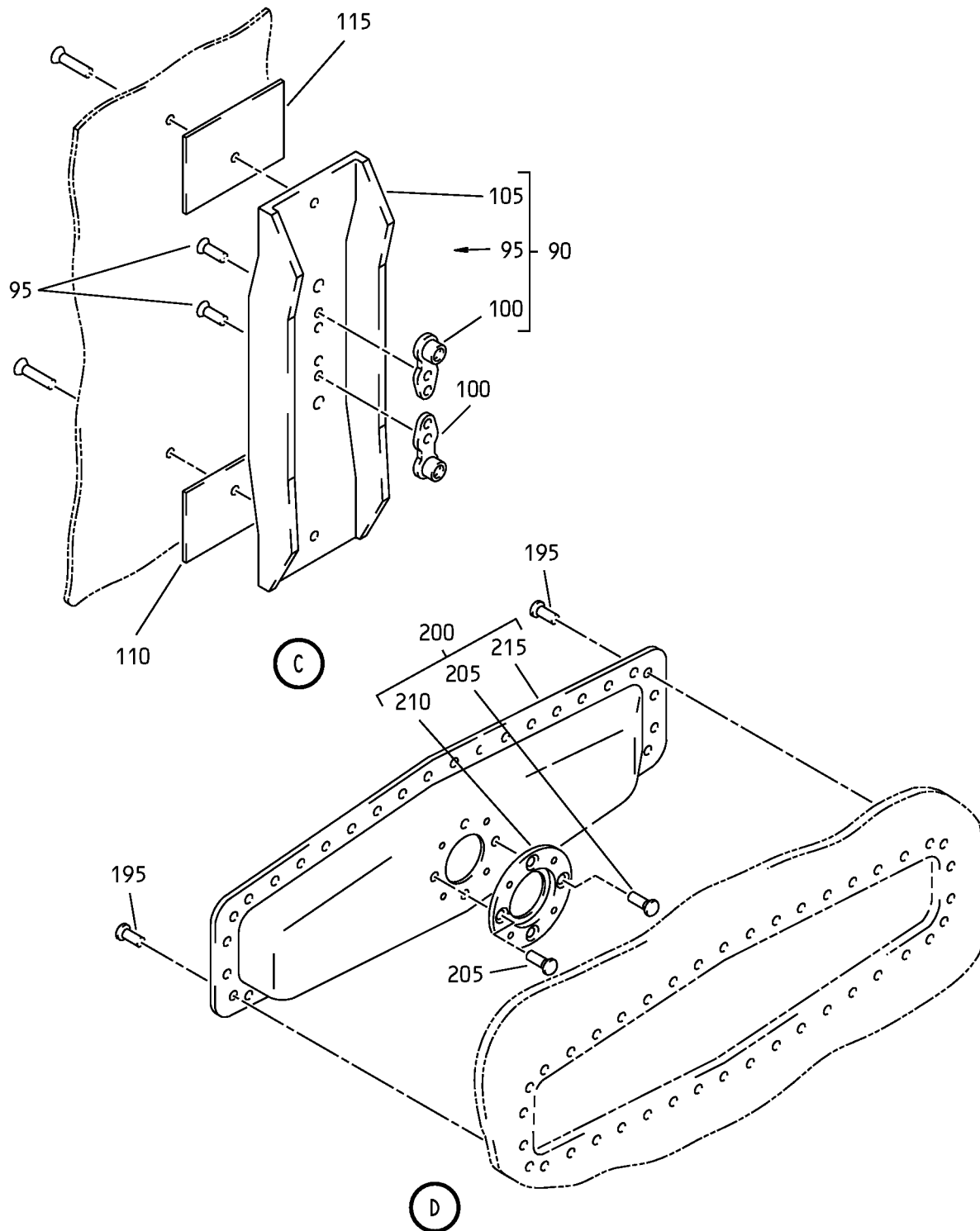
COMPONENT MAINTENANCE MANUAL



Forward Galley Door Assembly  
IPL Figure 2 (Sheet 2 of 37)

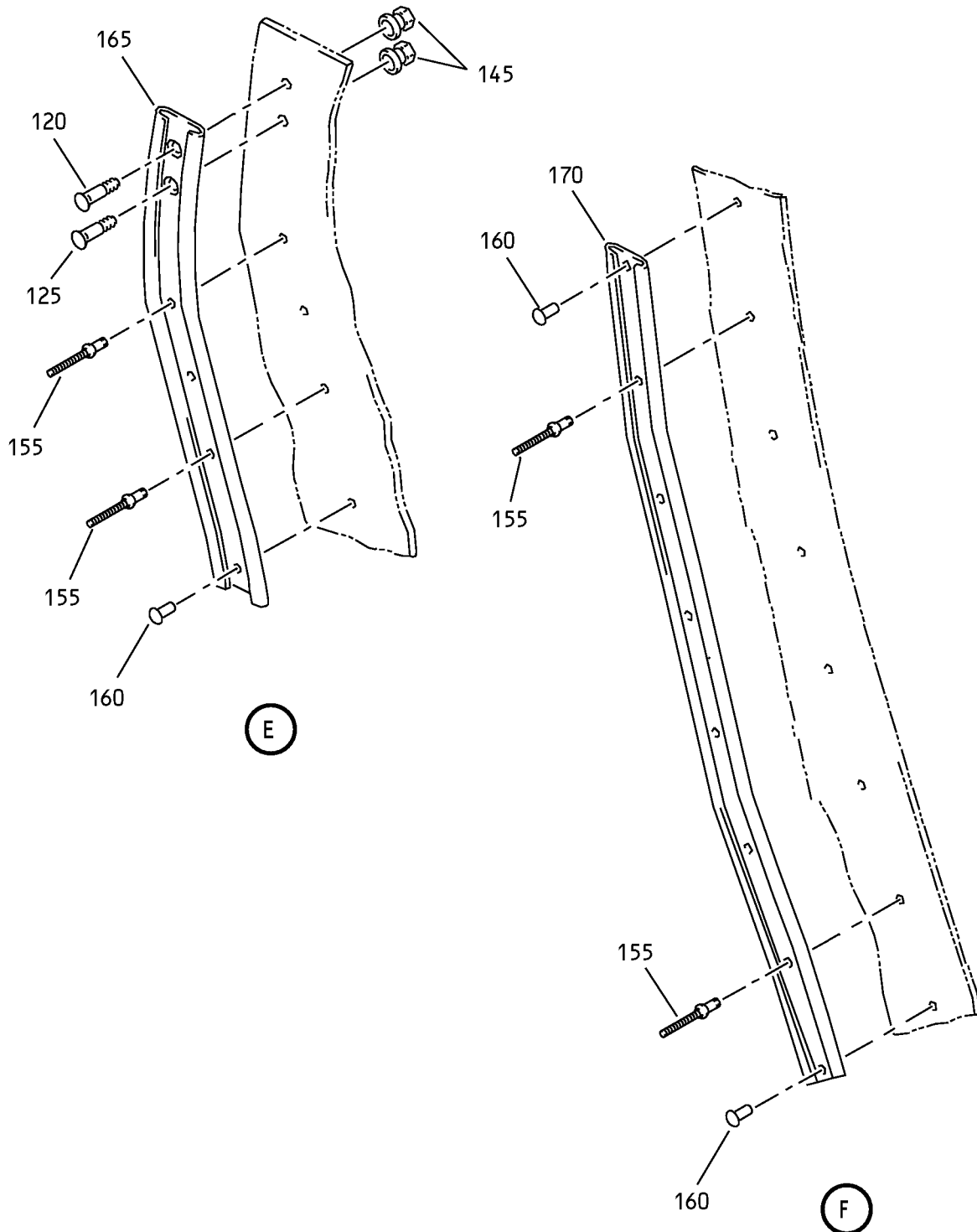
**52-41-05**  
ILLUSTRATED PARTS LIST  
Page 1085  
Nov 01/2008

COMPONENT MAINTENANCE MANUAL



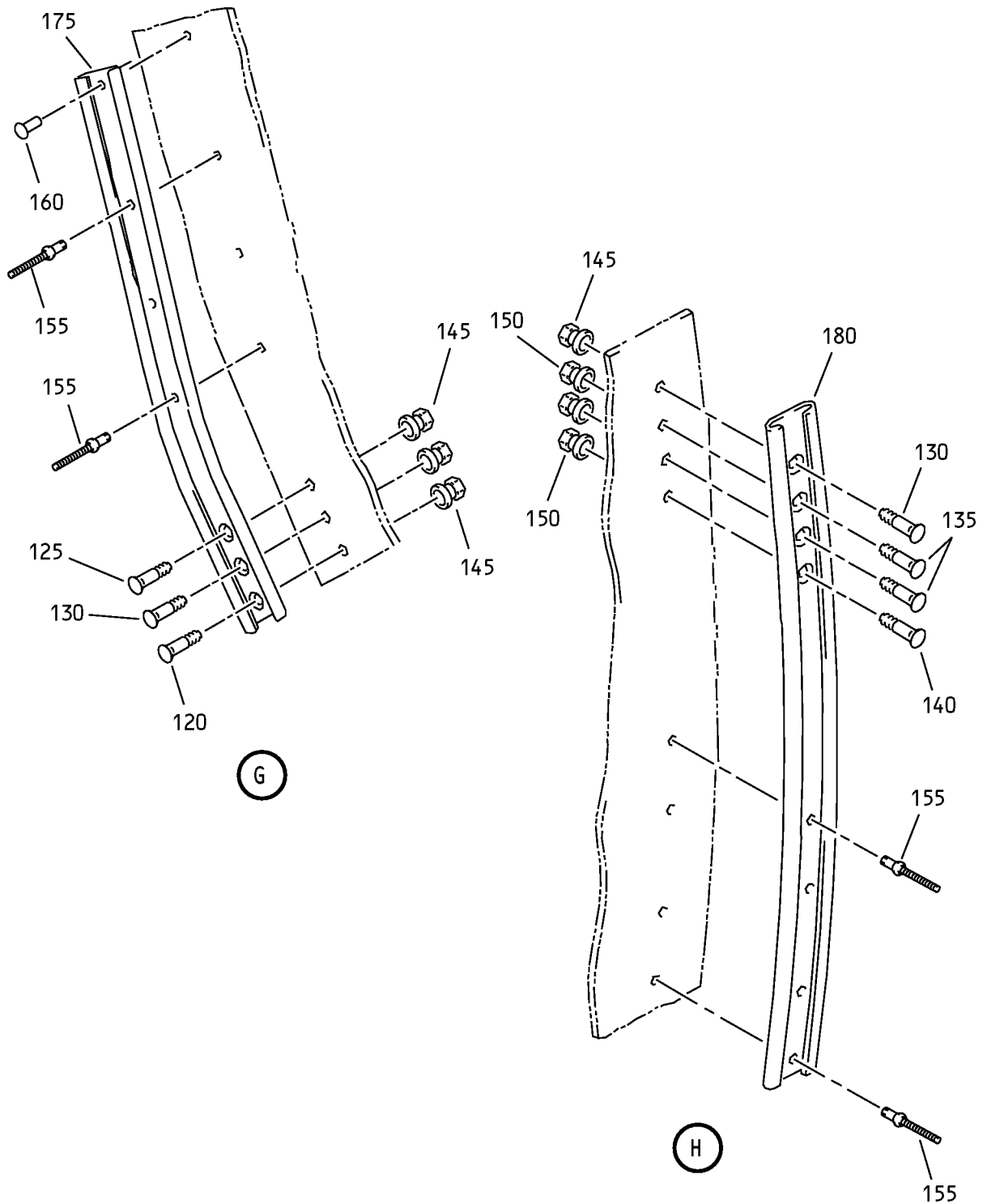
Forward Galley Door Assembly  
IPL Figure 2 (Sheet 3 of 37)

COMPONENT MAINTENANCE MANUAL



Forward Galley Door Assembly  
IPL Figure 2 (Sheet 4 of 37)

COMPONENT MAINTENANCE MANUAL



Forward Galley Door Assembly  
IPL Figure 2 (Sheet 5 of 37)

**52-41-05**

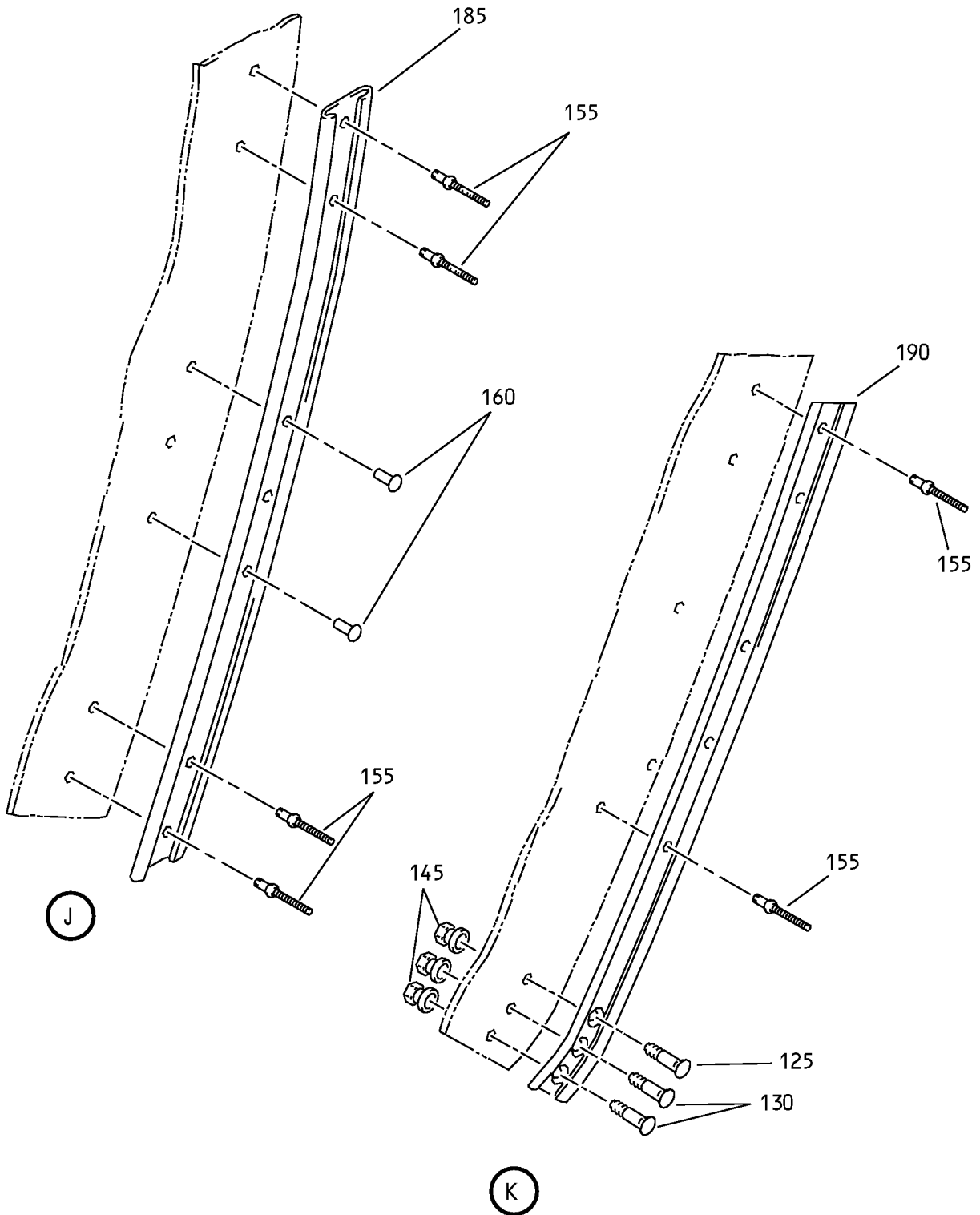
ILLUSTRATED PARTS LIST

Page 1088

Nov 01/2008

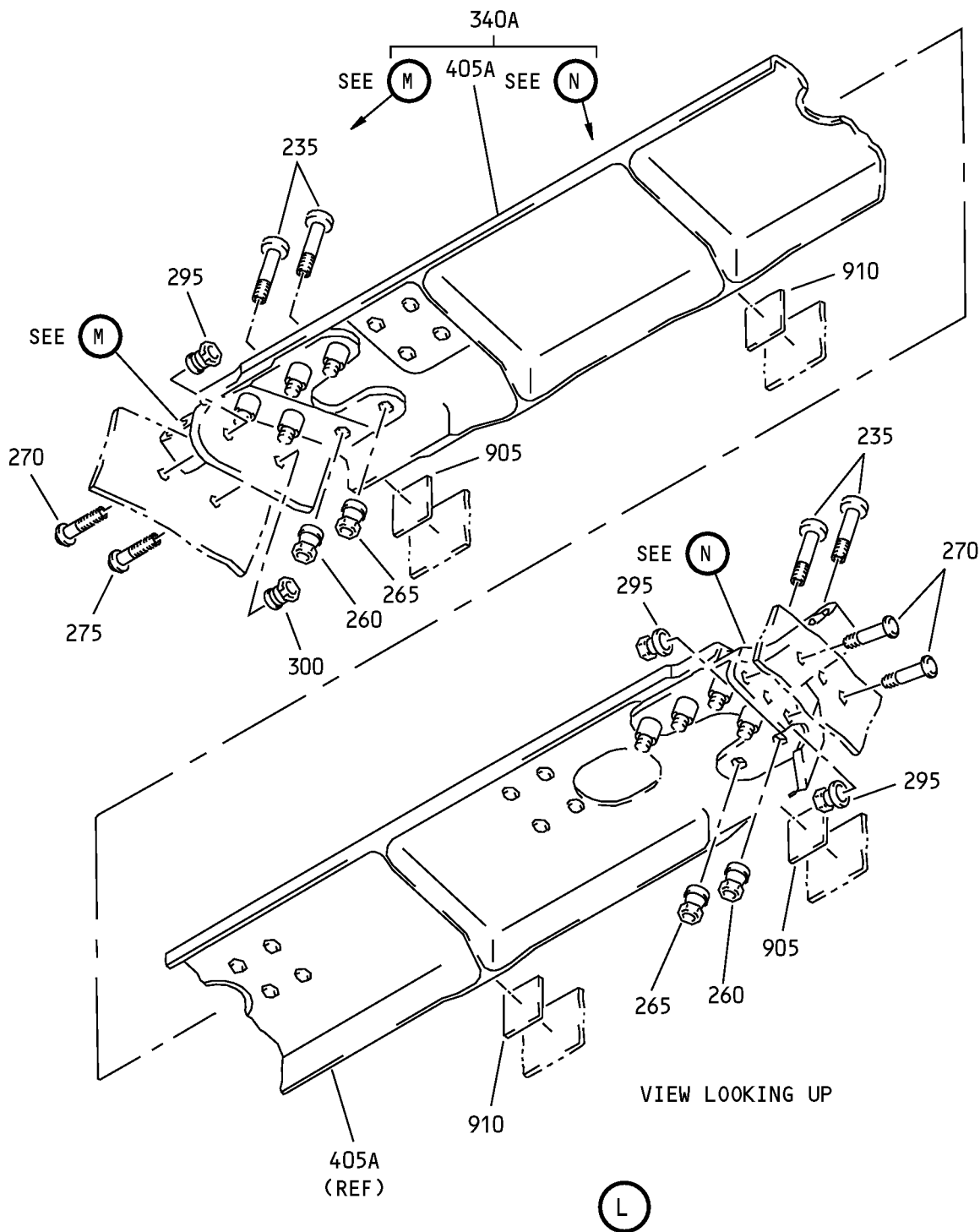


COMPONENT MAINTENANCE MANUAL



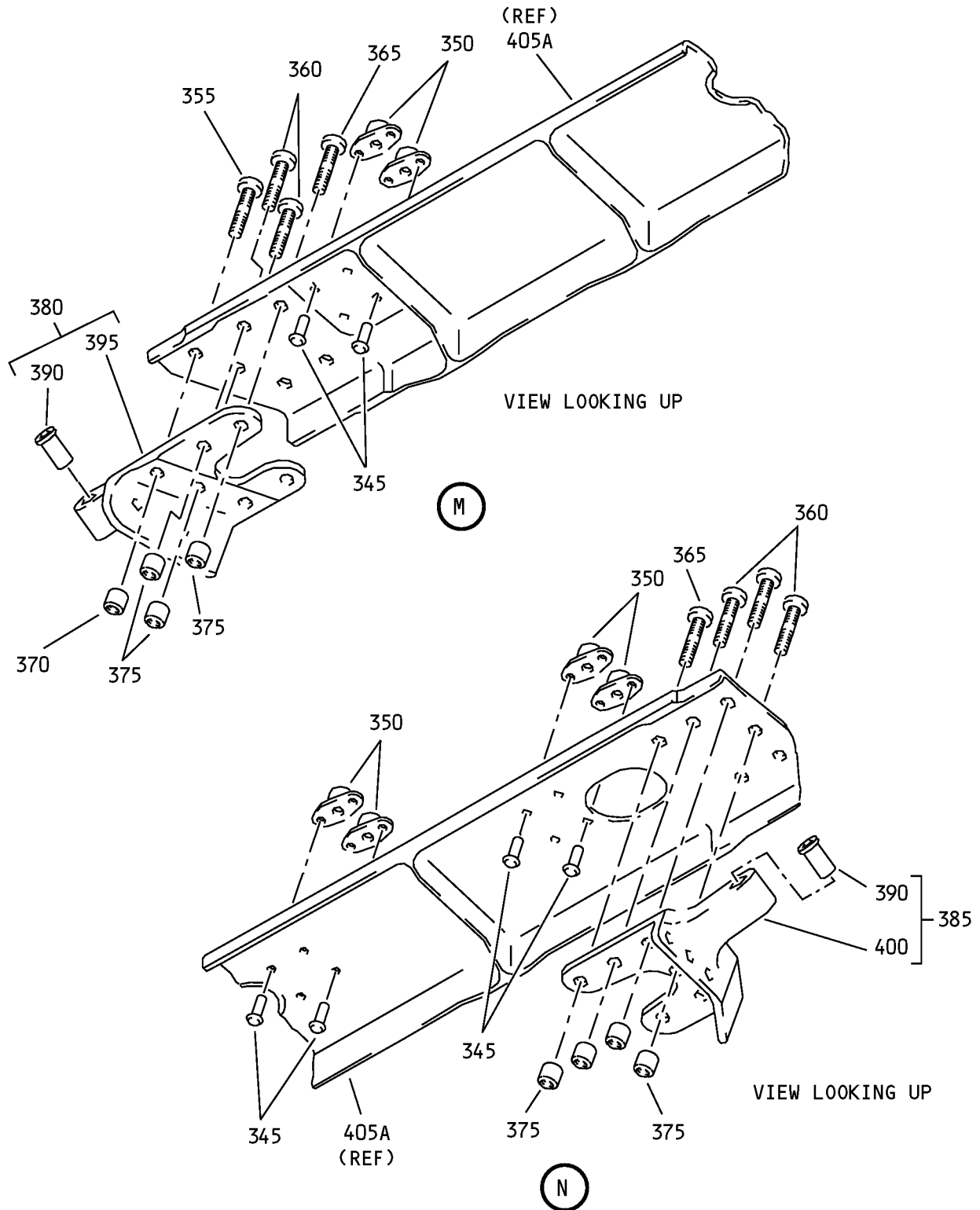
Forward Galley Door Assembly  
IPL Figure 2 (Sheet 6 of 37)

### COMPONENT MAINTENANCE MANUAL



Forward Galley Door Assembly  
IPL Figure 2 (Sheet 7 of 37)

COMPONENT MAINTENANCE MANUAL



Forward Galley Door Assembly  
IPL Figure 2 (Sheet 8 of 37)

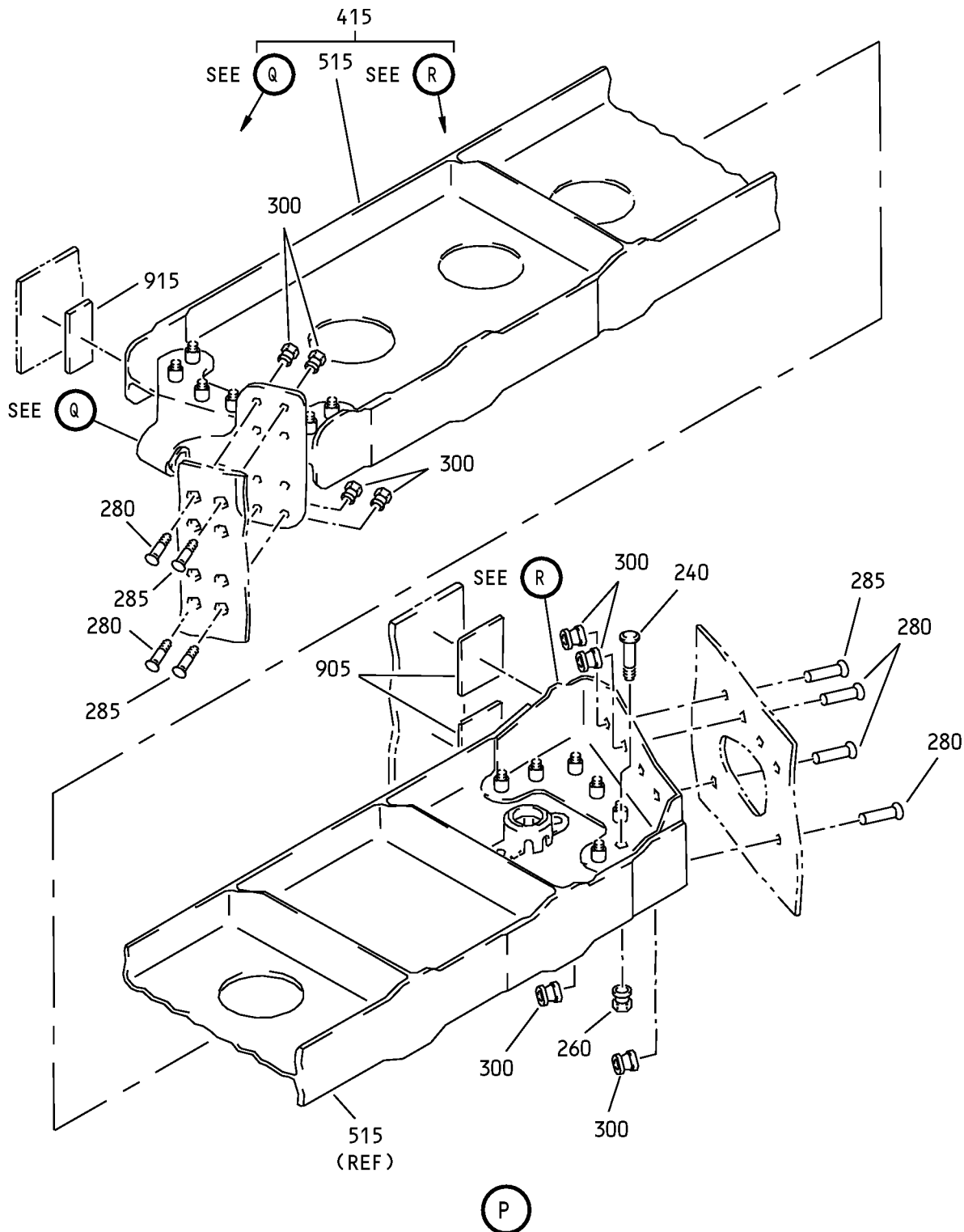
**52-41-05**

ILLUSTRATED PARTS LIST

Page 1091

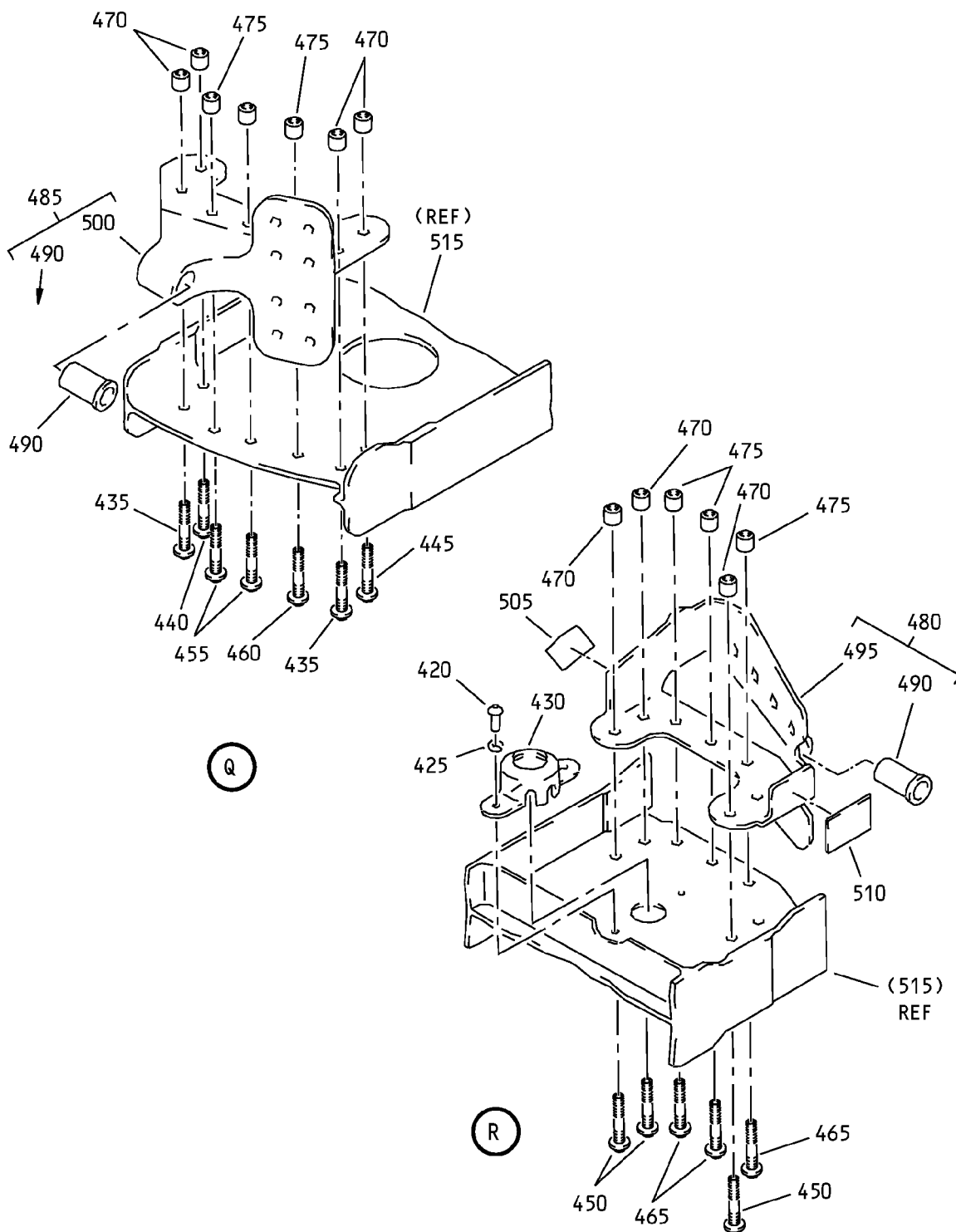
Nov 01/2008

COMPONENT MAINTENANCE MANUAL



Forward Galley Door Assembly  
IPL Figure 2 (Sheet 9 of 37)

COMPONENT MAINTENANCE MANUAL



Forward Galley Door Assembly  
IPL Figure 2 (Sheet 10 of 37)

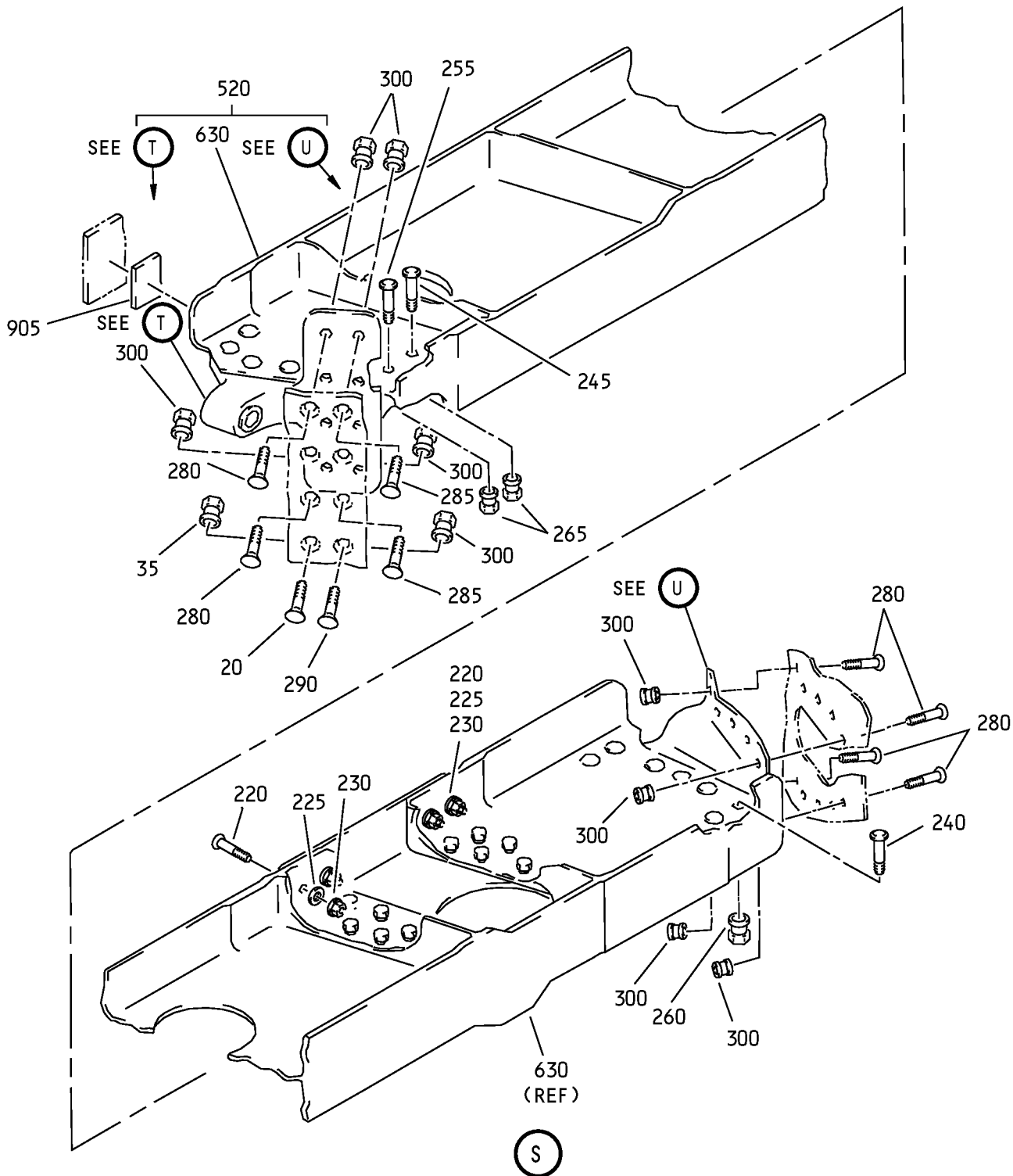
**52-41-05**

ILLUSTRATED PARTS LIST

Page 1093

Nov 01/2008

COMPONENT MAINTENANCE MANUAL



Forward Galley Door Assembly  
IPL Figure 2 (Sheet 11 of 37)

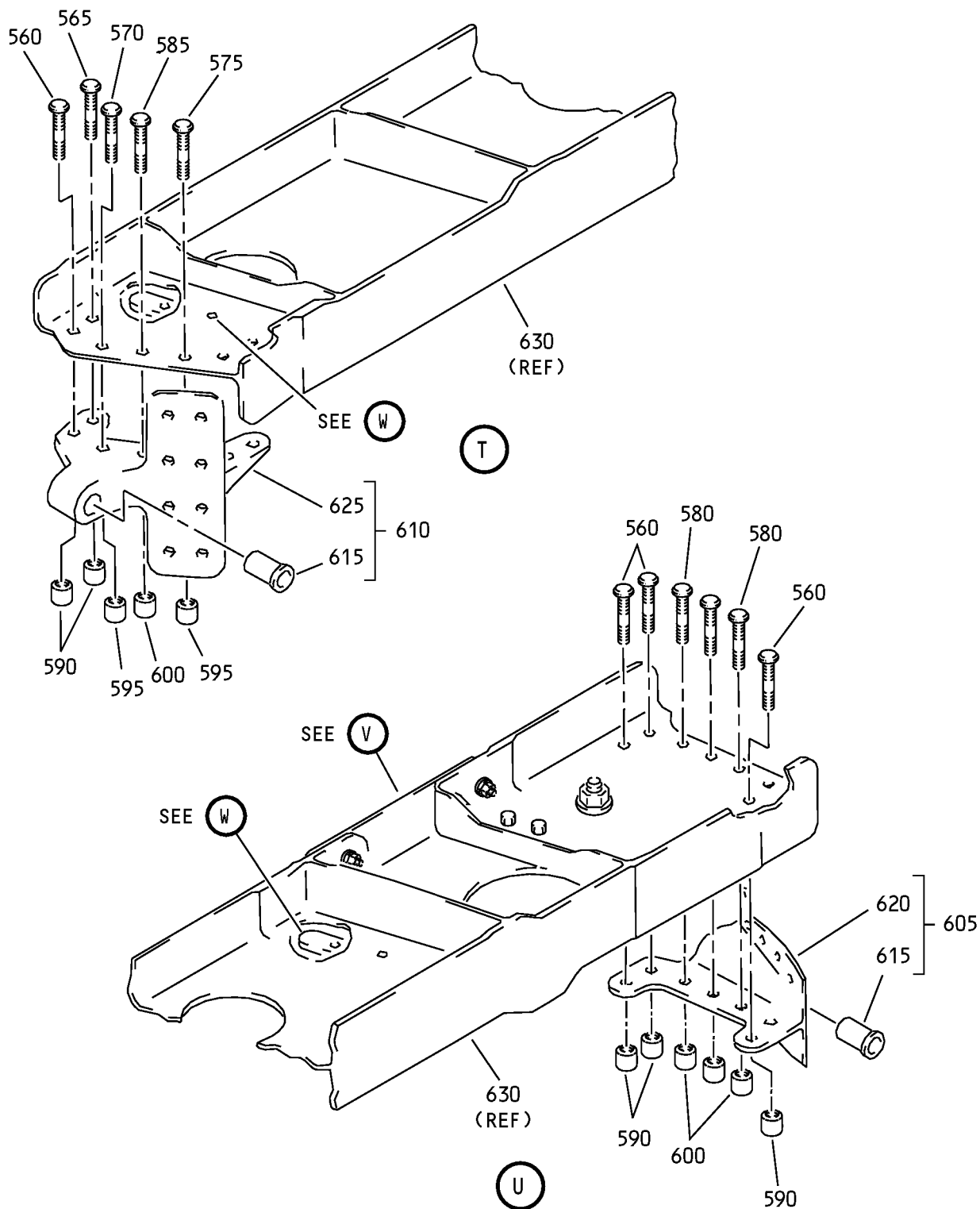
**52-41-05**

ILLUSTRATED PARTS LIST

Page 1094

Nov 01/2008

COMPONENT MAINTENANCE MANUAL



Forward Galley Door Assembly  
IPL Figure 2 (Sheet 12 of 37)

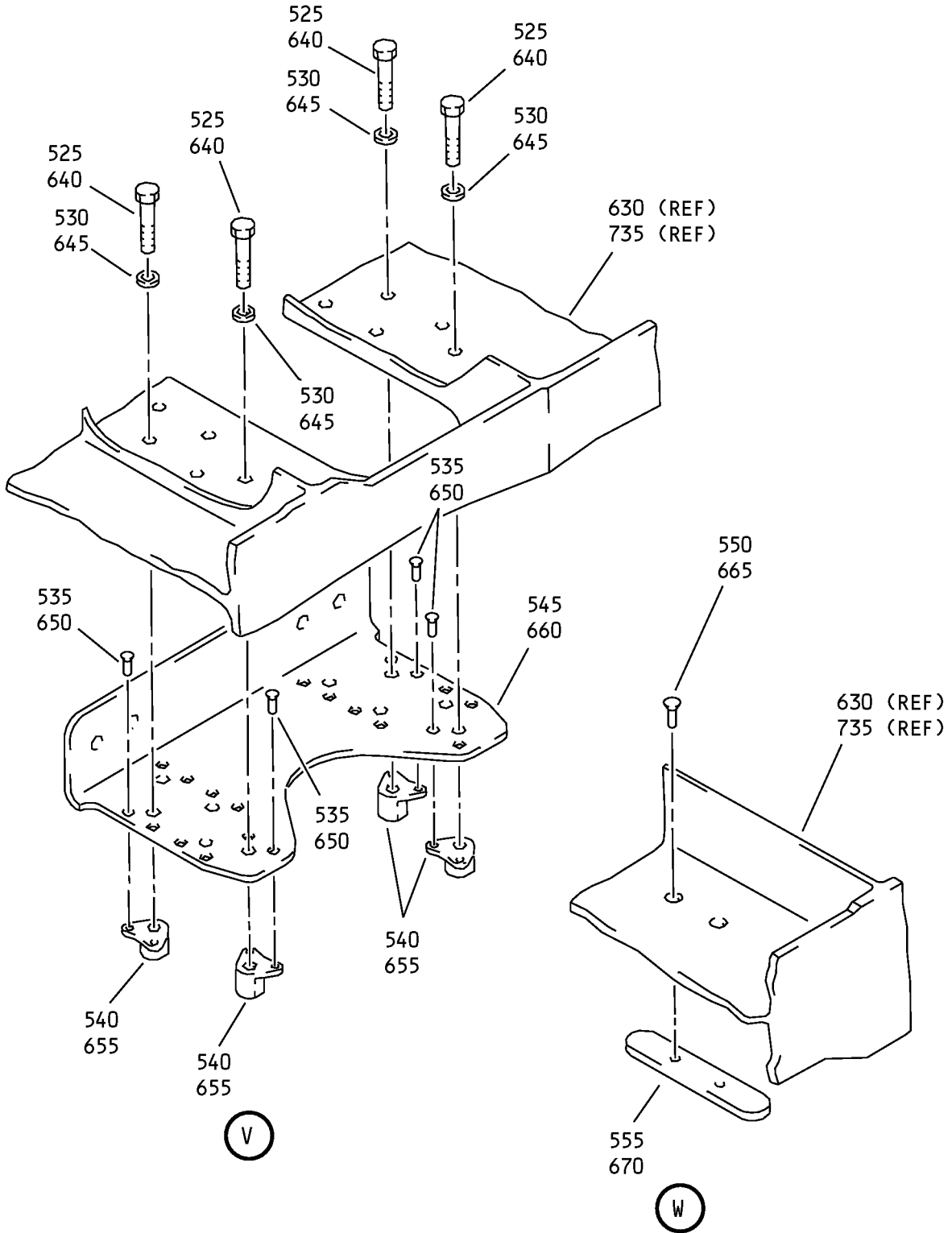
**52-41-05**

ILLUSTRATED PARTS LIST

Page 1095

Nov 01/2008

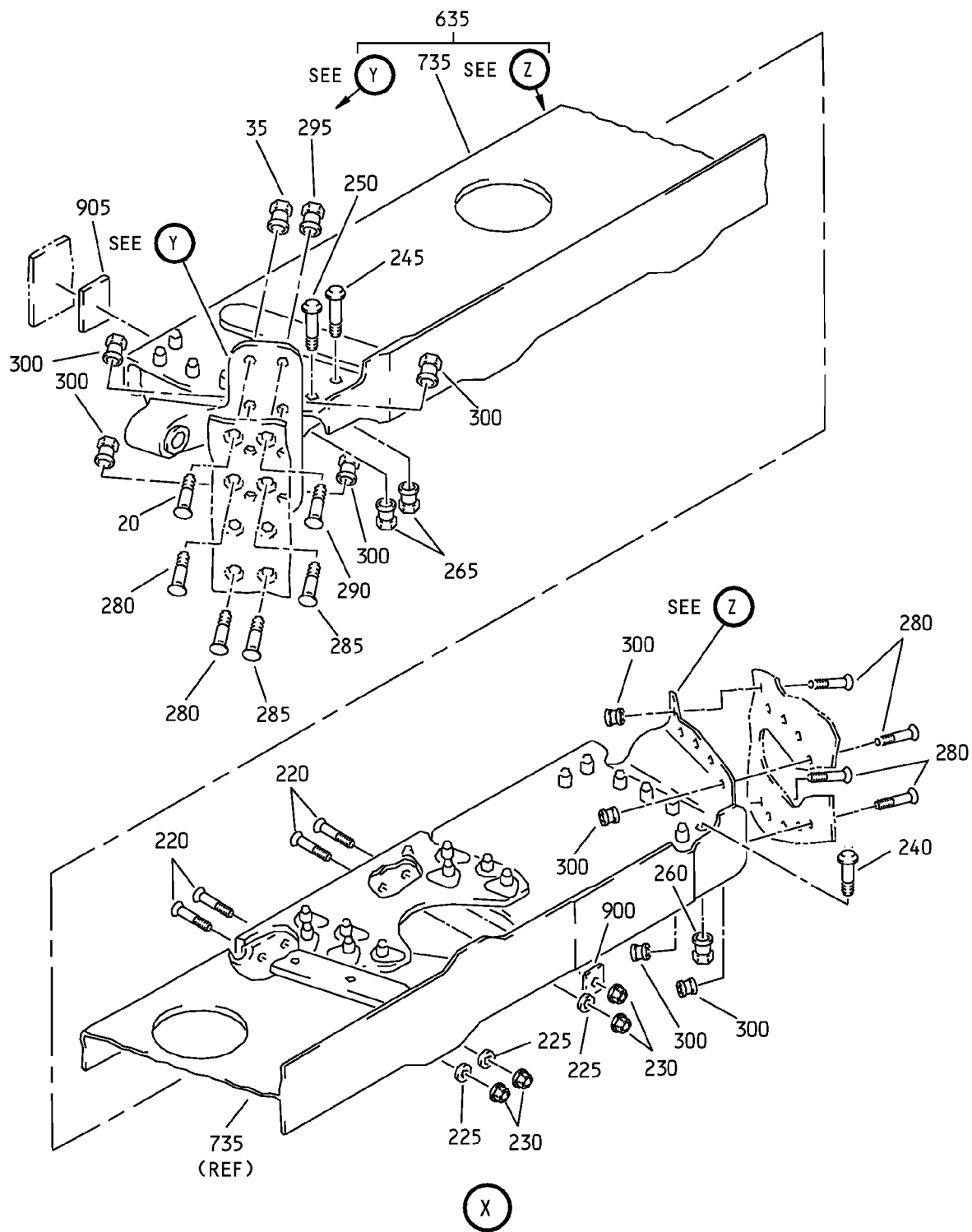
COMPONENT MAINTENANCE MANUAL



Forward Galley Door Assembly  
IPL Figure 2 (Sheet 13 of 37)



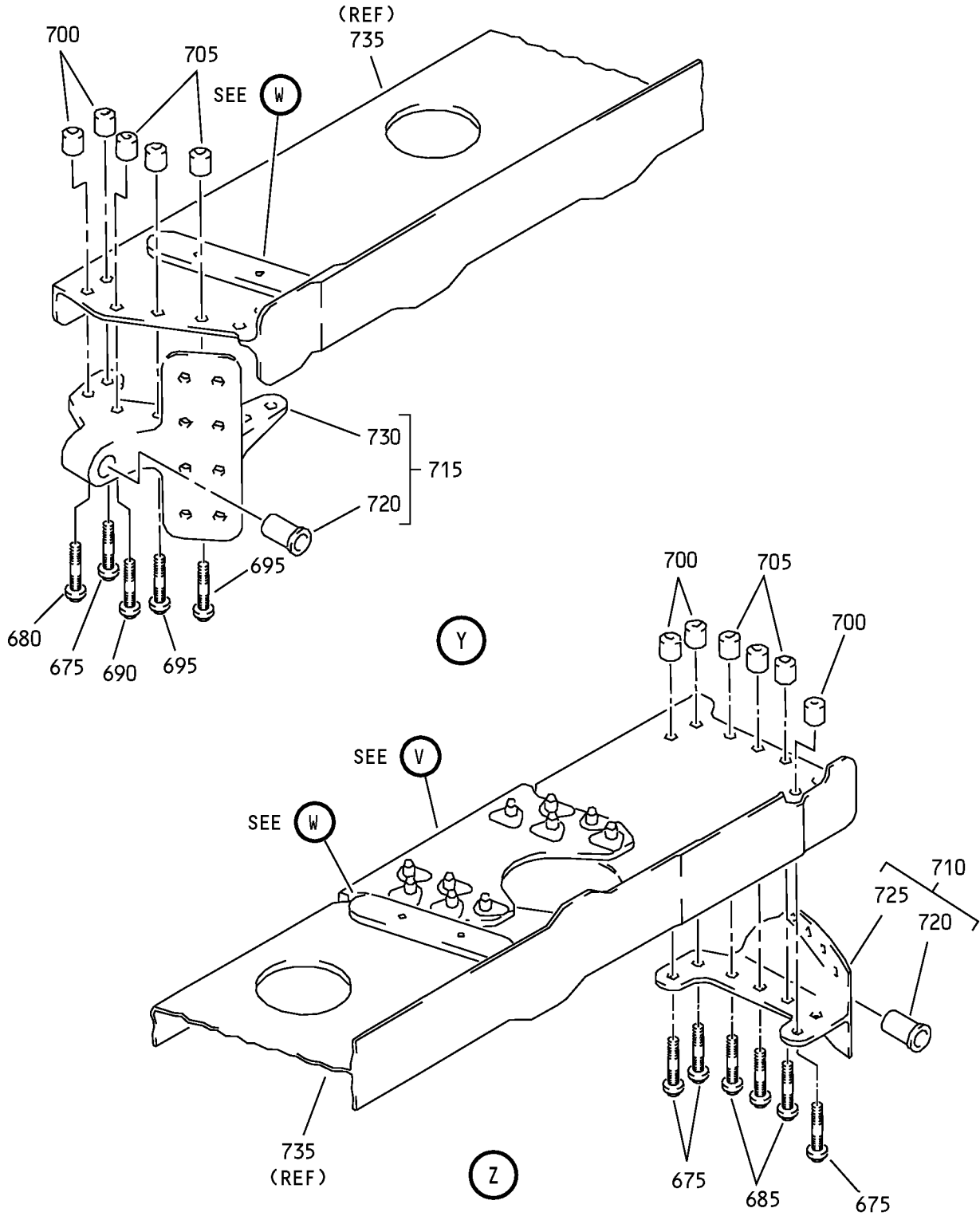
COMPONENT MAINTENANCE MANUAL



Forward Galley Door Assembly  
IPL Figure 2 (Sheet 14 of 37)

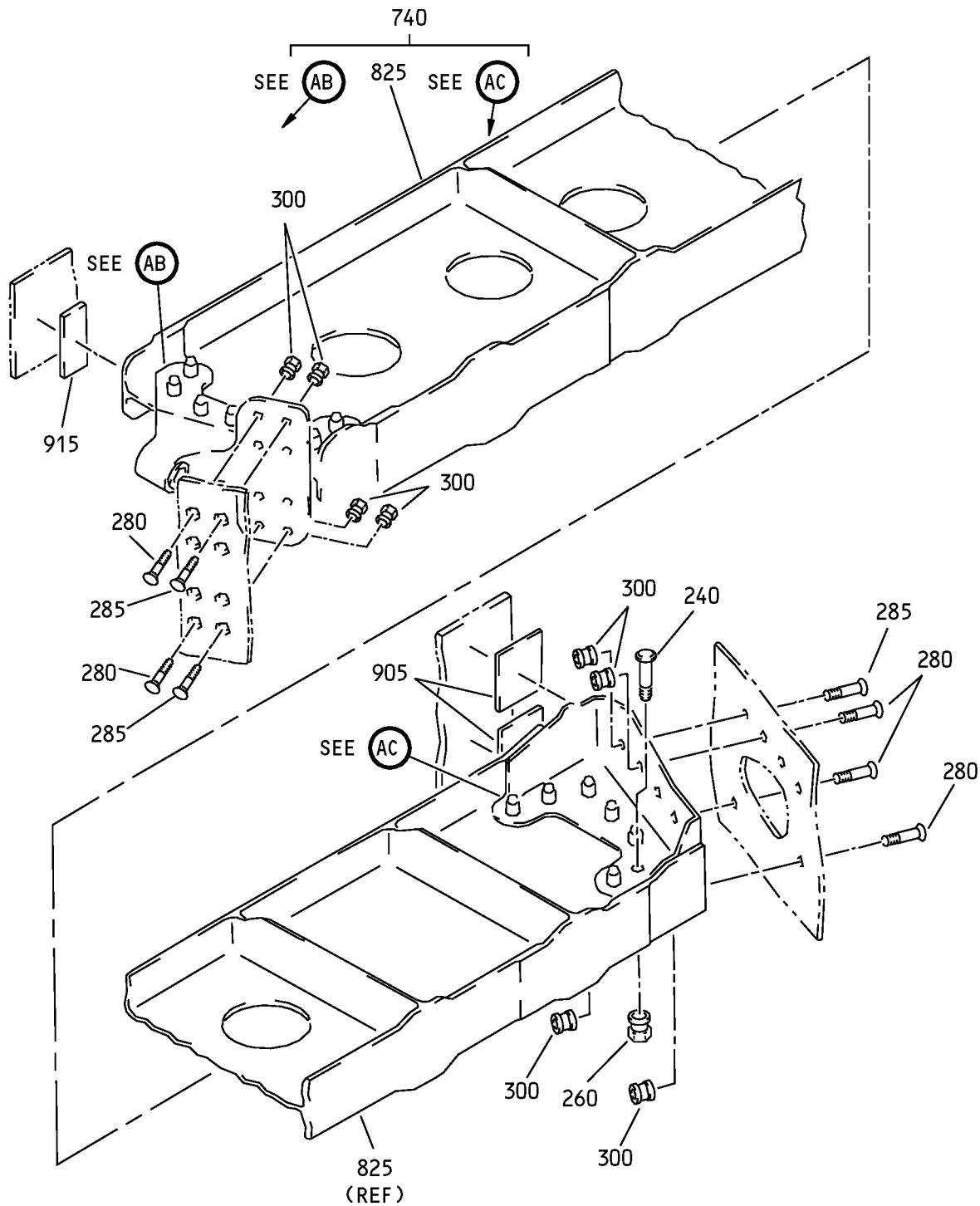
**52-41-05**  
ILLUSTRATED PARTS LIST  
Page 1097  
Nov 01/2008

COMPONENT MAINTENANCE MANUAL



Forward Galley Door Assembly  
IPL Figure 2 (Sheet 15 of 37)

COMPONENT MAINTENANCE MANUAL



AA

Forward Galley Door Assembly  
IPL Figure 2 (Sheet 16 of 37)

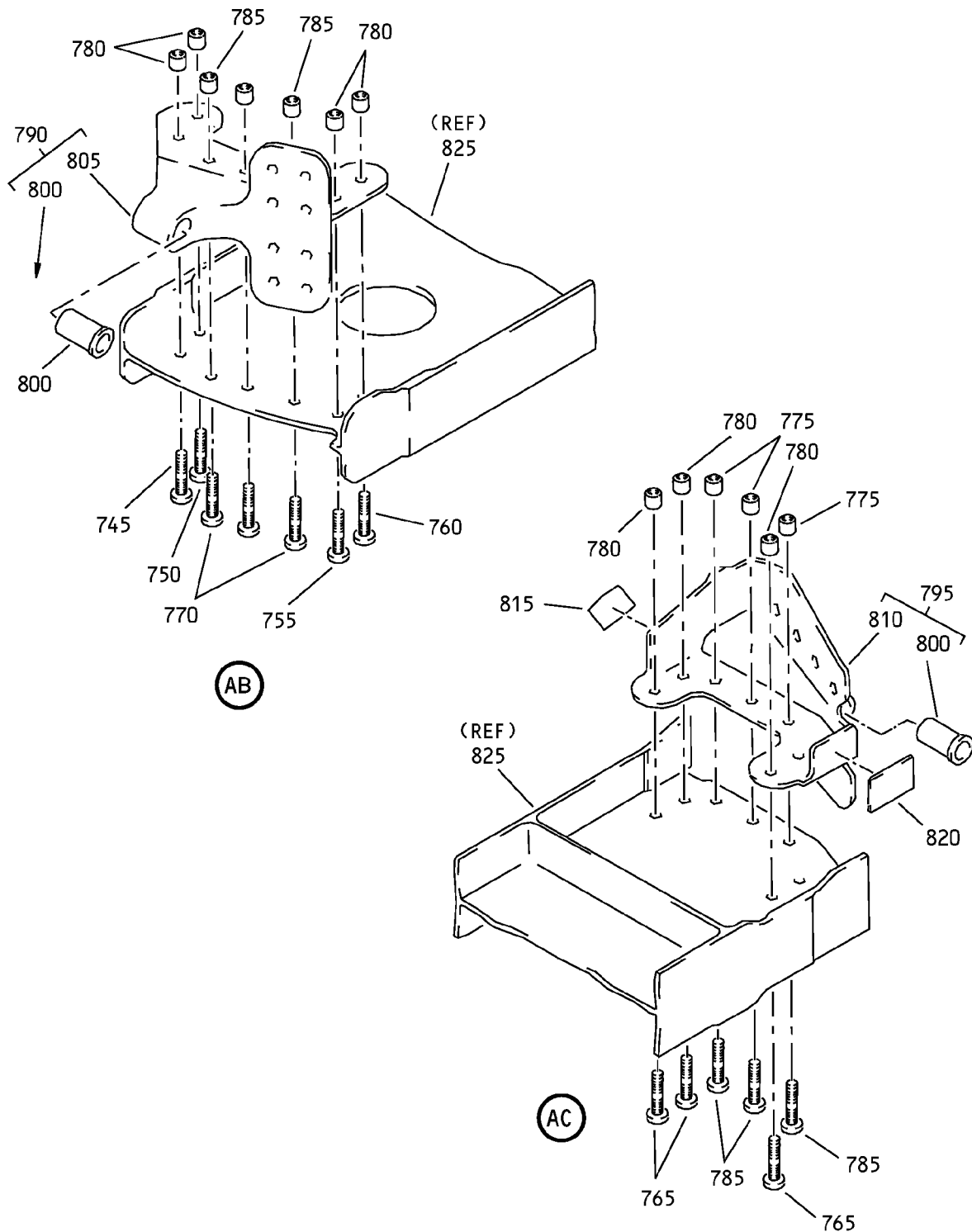
**52-41-05**

ILLUSTRATED PARTS LIST

Page 1098.1

Nov 01/2008

COMPONENT MAINTENANCE MANUAL



Forward Galley Door Assembly  
IPL Figure 2 (Sheet 17 of 37)

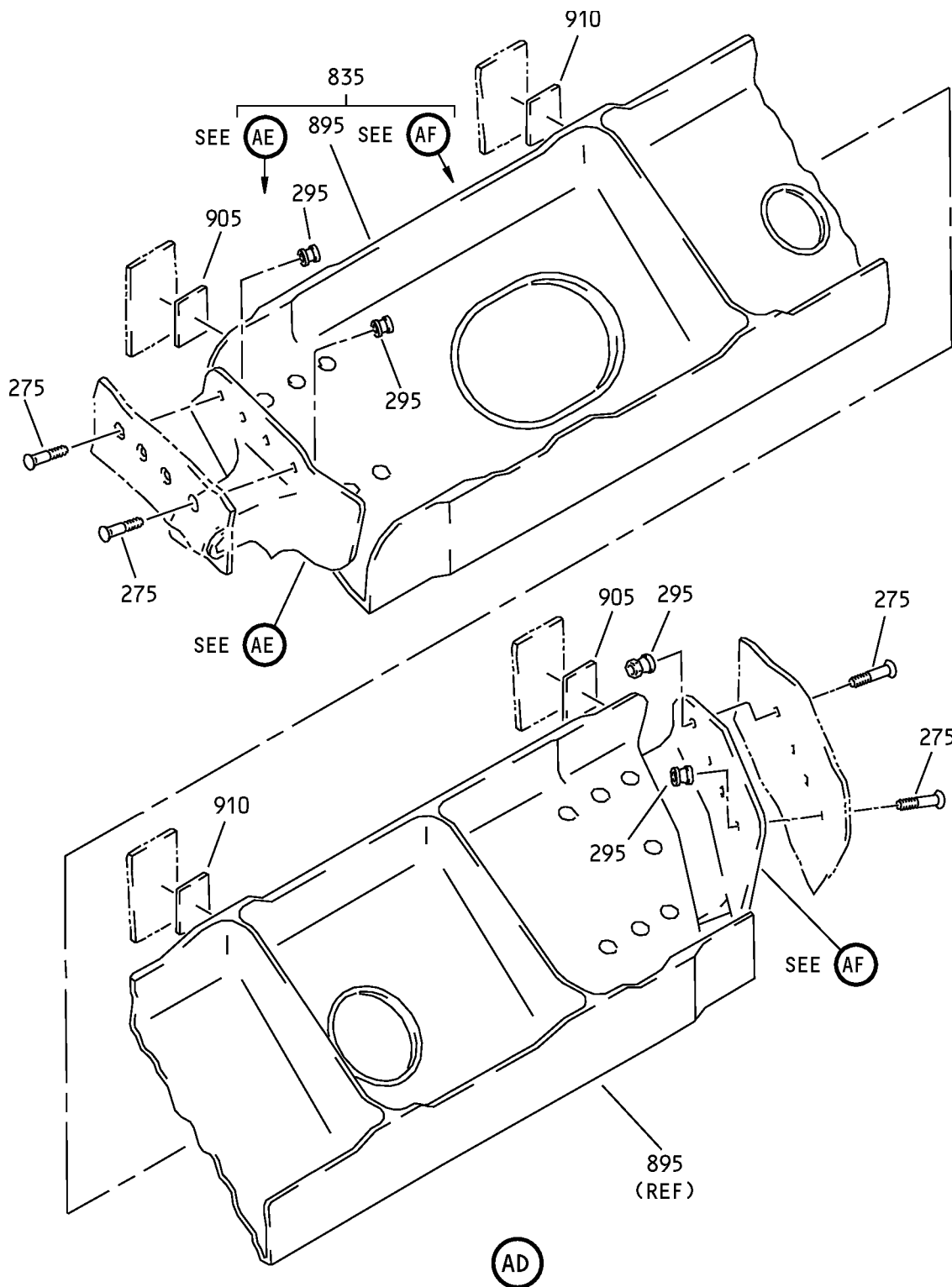
**52-41-05**

ILLUSTRATED PARTS LIST

Page 1098.2

Nov 01/2008

COMPONENT MAINTENANCE MANUAL



Forward Galley Door Assembly  
IPL Figure 2 (Sheet 18 of 37)

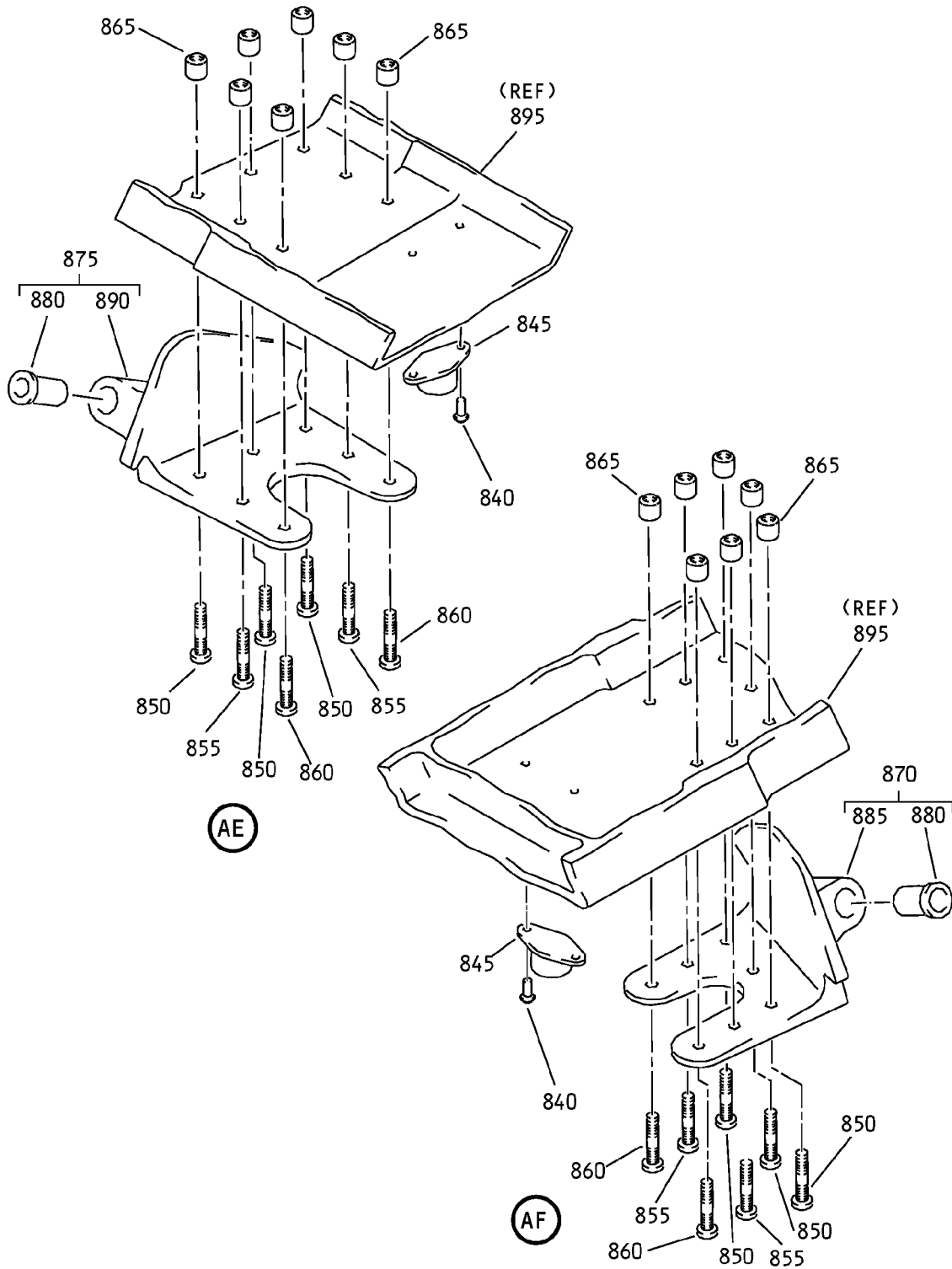
**52-41-05**

ILLUSTRATED PARTS LIST

Page 1098.3

Nov 01/2008

COMPONENT MAINTENANCE MANUAL



Forward Galley Door Assembly  
IPL Figure 2 (Sheet 19 of 37)

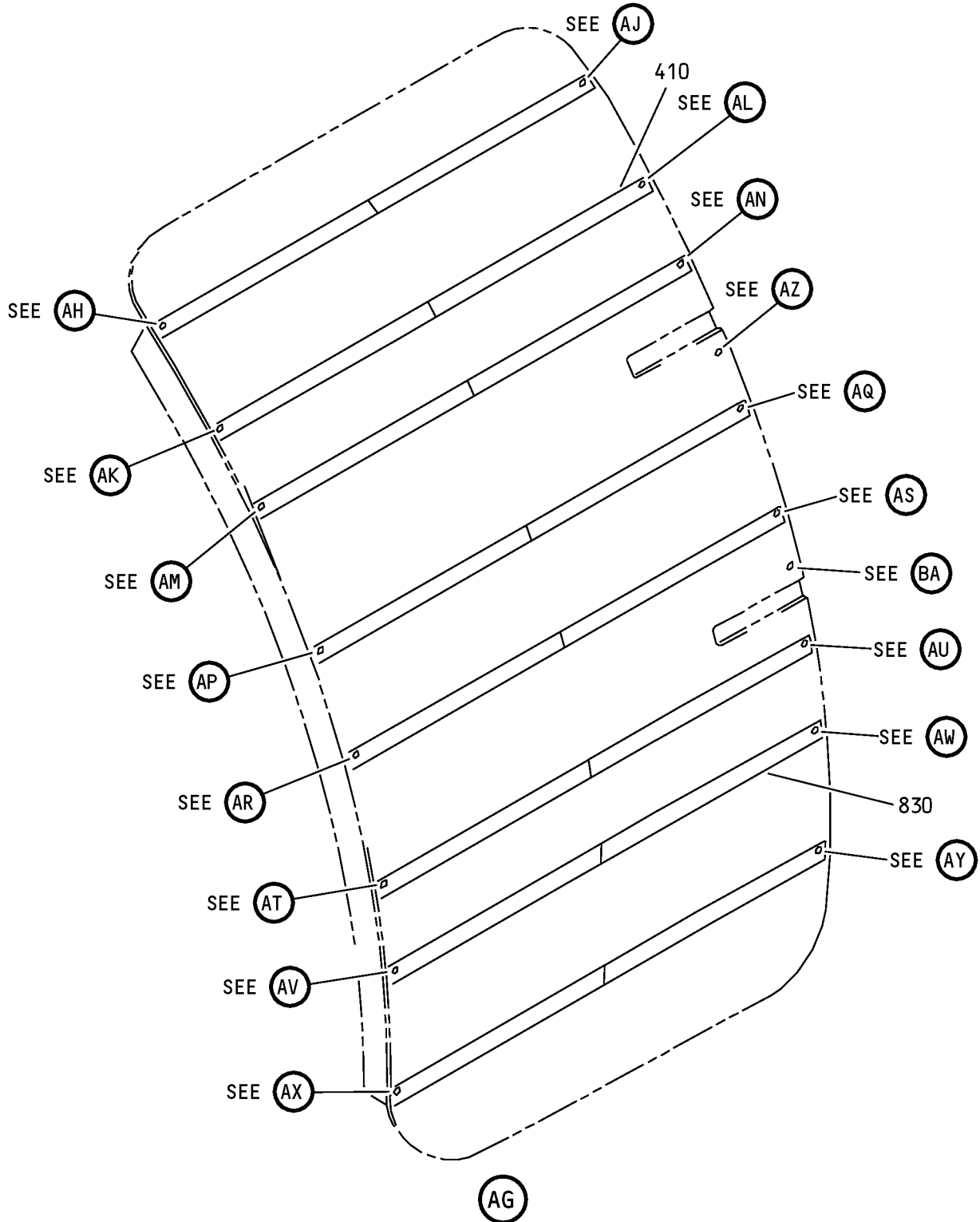
**52-41-05**

ILLUSTRATED PARTS LIST

Page 1098.4

Nov 01/2008

COMPONENT MAINTENANCE MANUAL



Forward Galley Door Assembly  
IPL Figure 2 (Sheet 20 of 37)

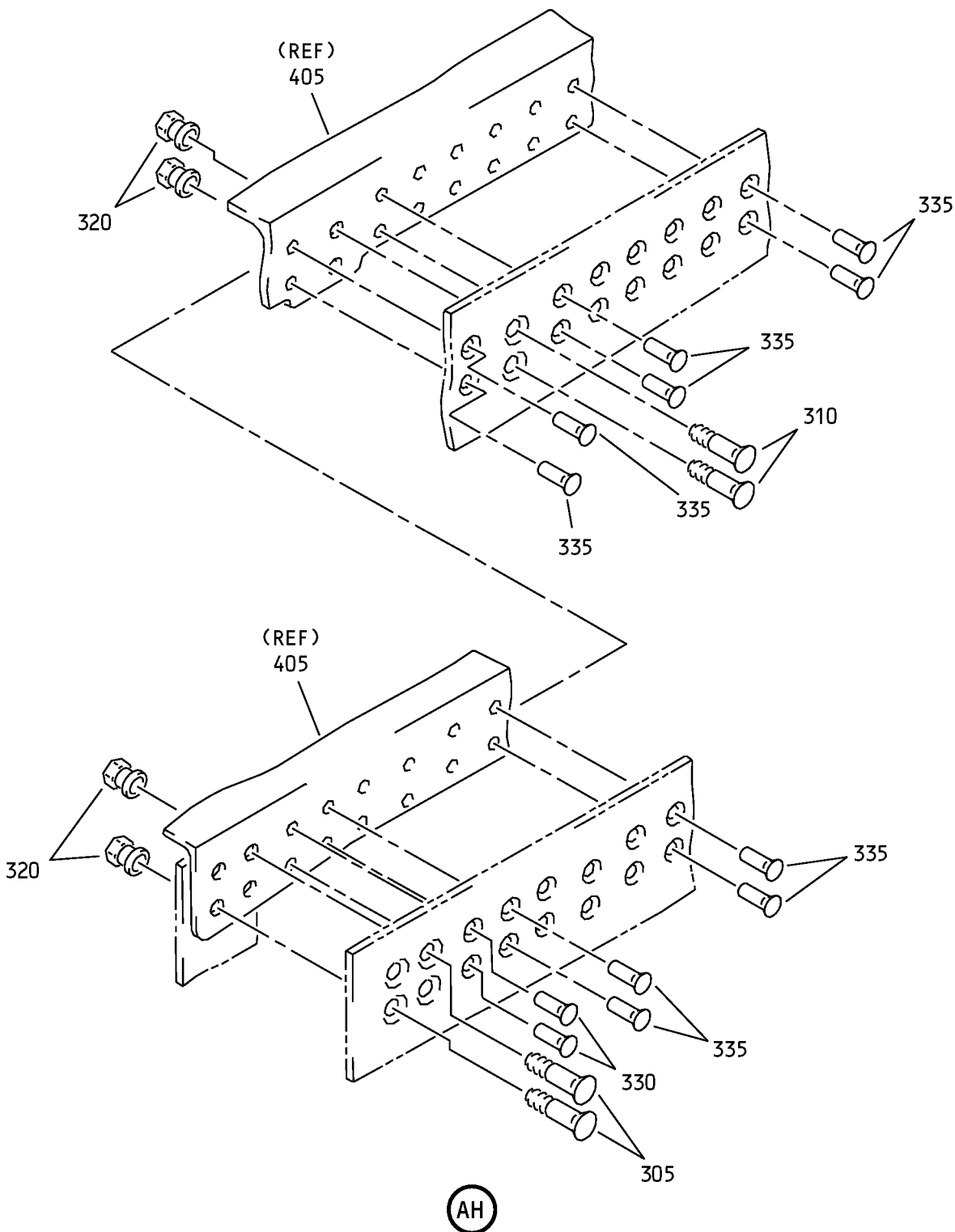
**52-41-05**

ILLUSTRATED PARTS LIST

Page 1098.5

Nov 01/2008

COMPONENT MAINTENANCE MANUAL



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Forward Galley Door Assembly  
IPL Figure 2 (Sheet 21 of 37)

**52-41-05**

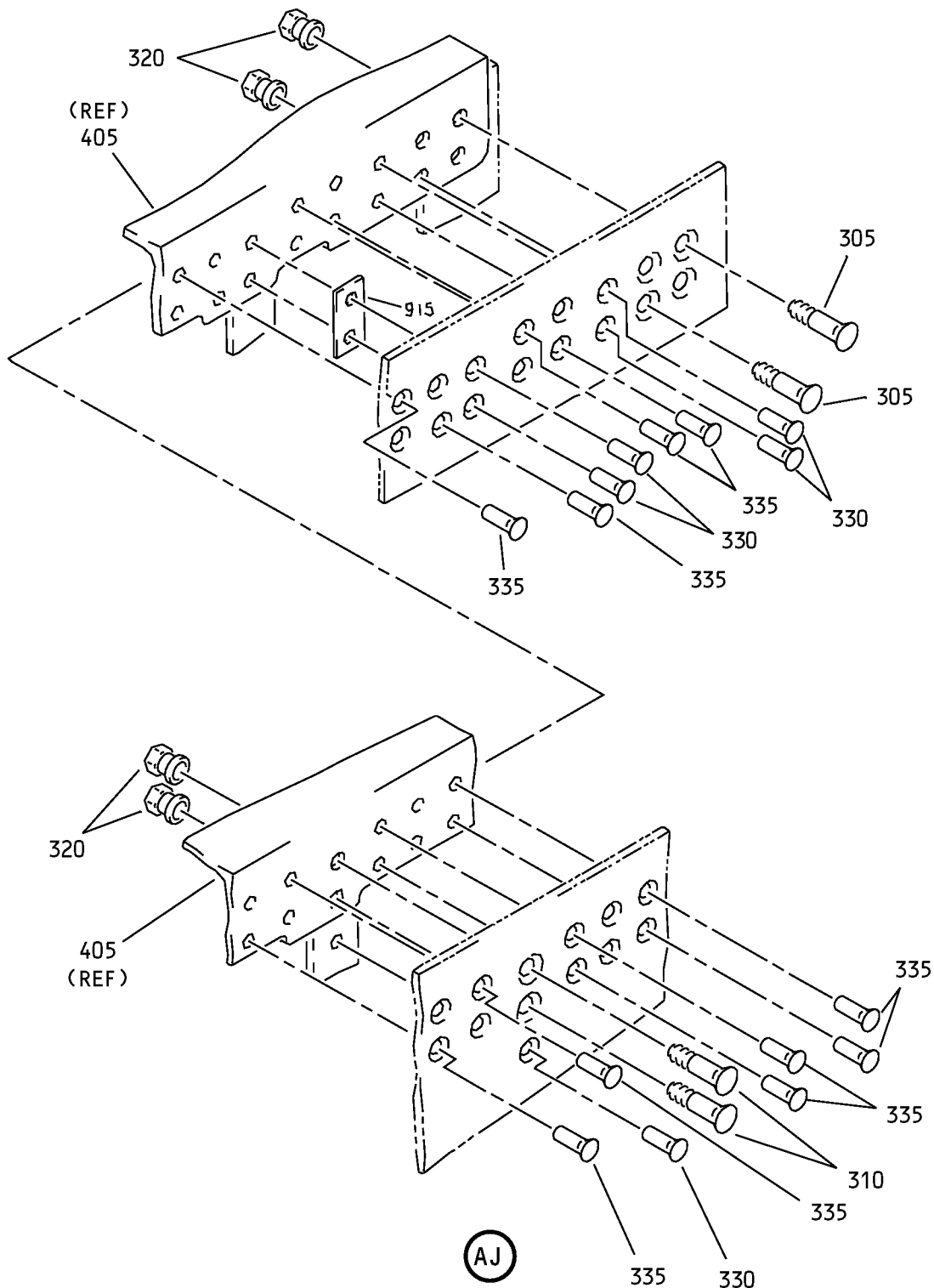
ILLUSTRATED PARTS LIST

Page 1098.6

Nov 01/2008



COMPONENT MAINTENANCE MANUAL



Forward Galley Door Assembly  
IPL Figure 2 (Sheet 22 of 37)

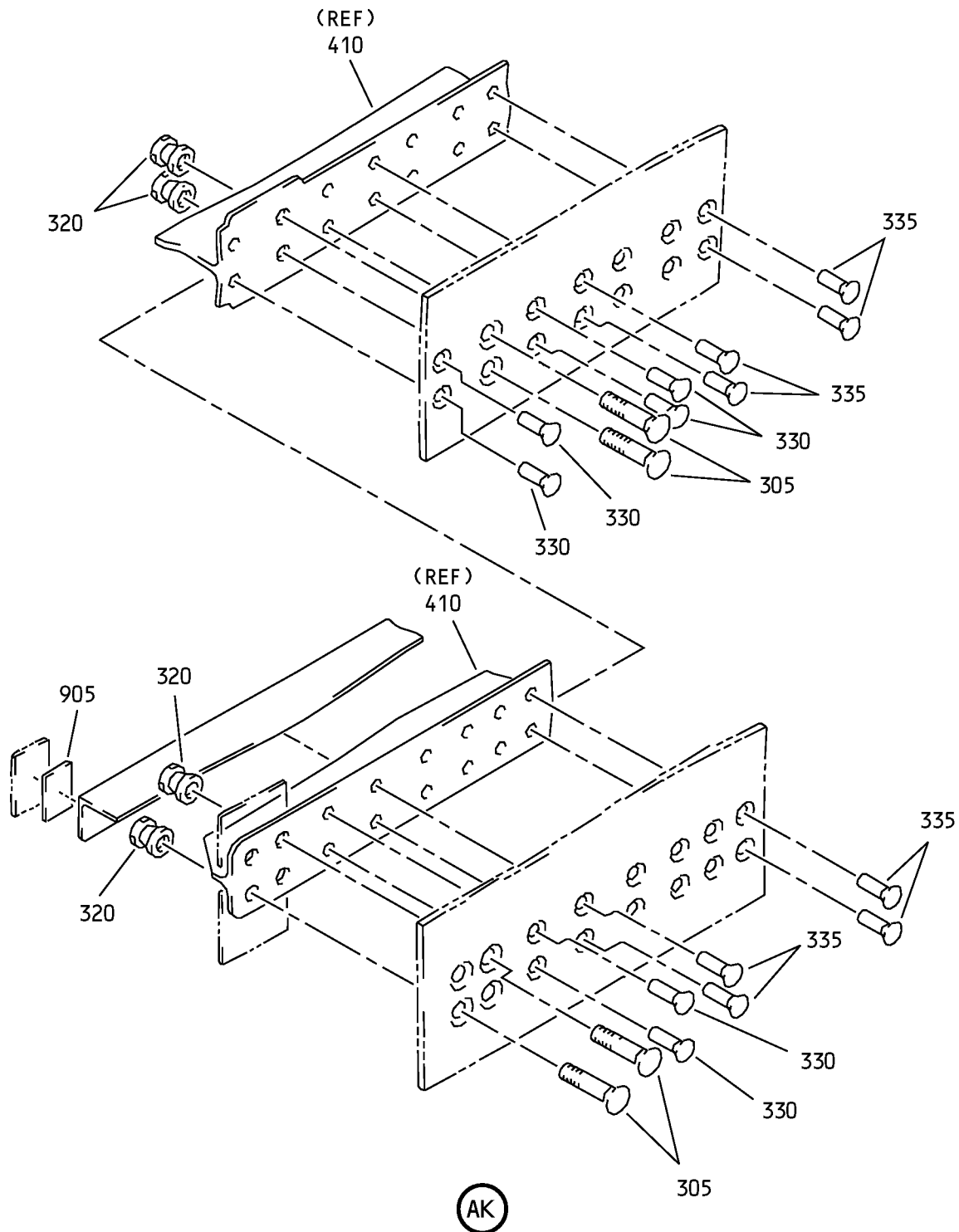
**52-41-05**

ILLUSTRATED PARTS LIST

Page 1098.7

Nov 01/2008

COMPONENT MAINTENANCE MANUAL

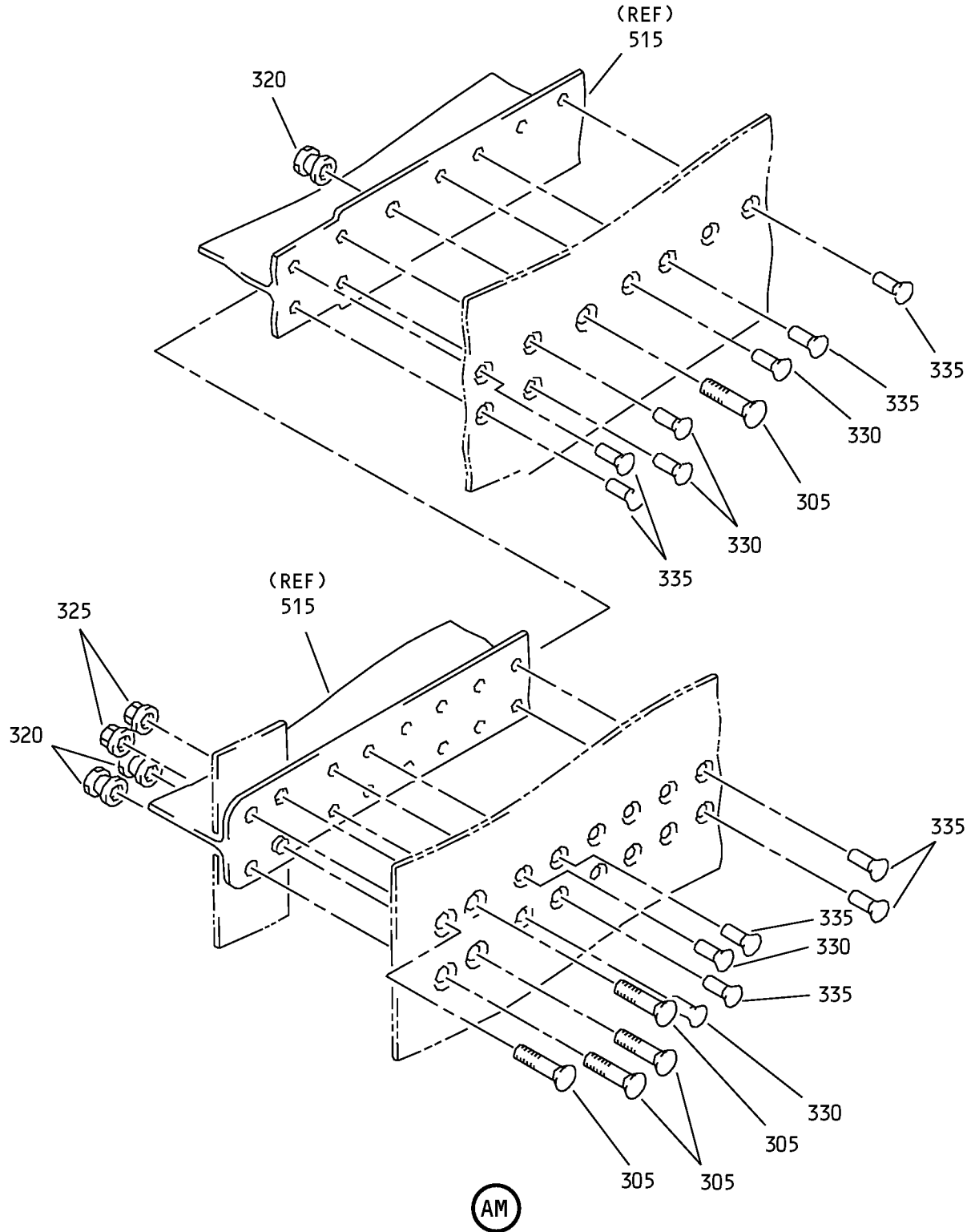


Forward Galley Door Assembly  
IPL Figure 2 (Sheet 23 of 37)

**52-41-05**  
ILLUSTRATED PARTS LIST  
Page 1098.8  
Nov 01/2008



COMPONENT MAINTENANCE MANUAL



Forward Galley Door Assembly  
IPL Figure 2 (Sheet 25 of 37)

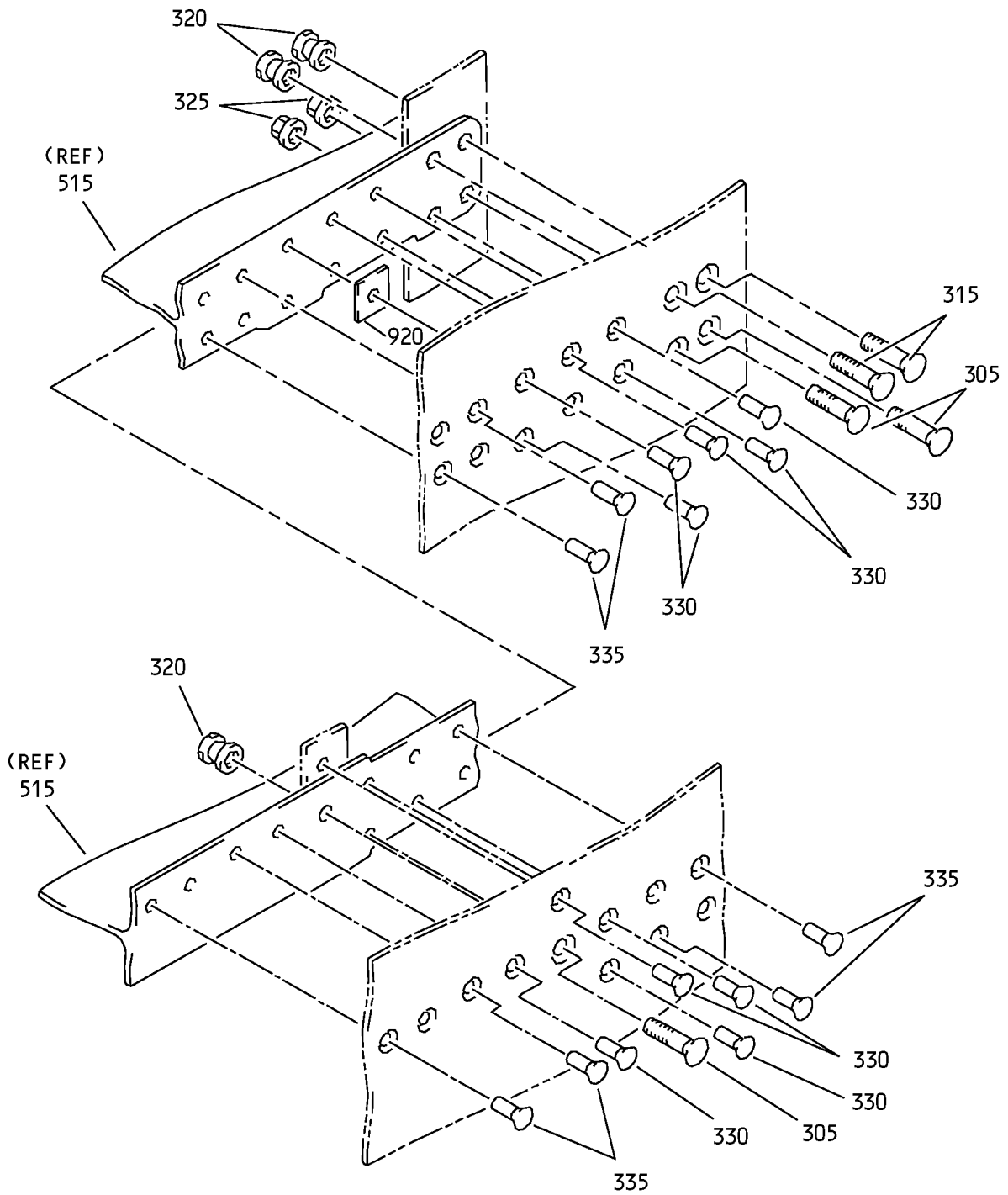
**52-41-05**

ILLUSTRATED PARTS LIST

Page 1098.10

Nov 01/2008

COMPONENT MAINTENANCE MANUAL



AN

Forward Galley Door Assembly  
IPL Figure 2 (Sheet 26 of 37)

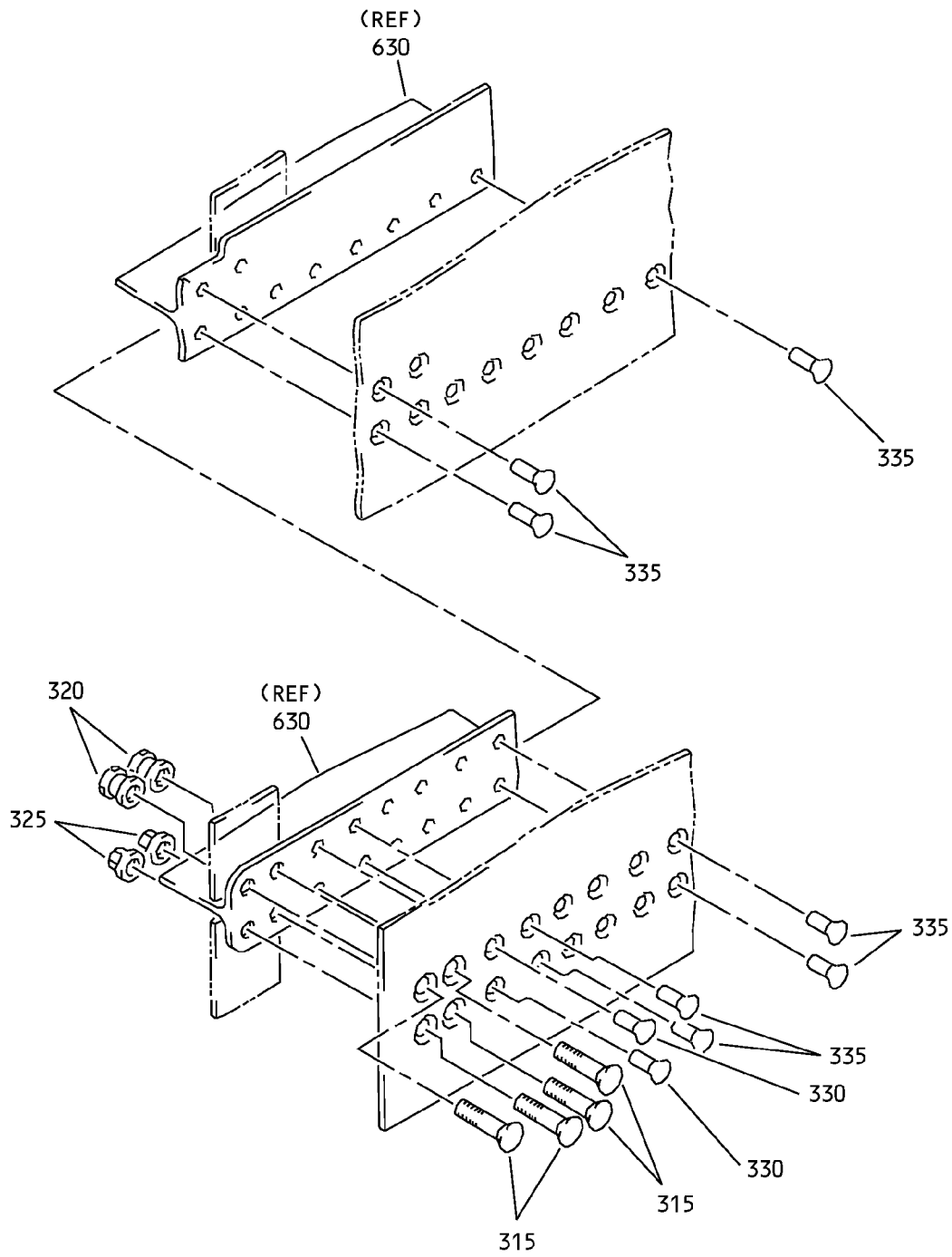
**52-41-05**

ILLUSTRATED PARTS LIST

Page 1098.11

Nov 01/2008

COMPONENT MAINTENANCE MANUAL



AP

Forward Galley Door Assembly  
IPL Figure 2 (Sheet 27 of 37)

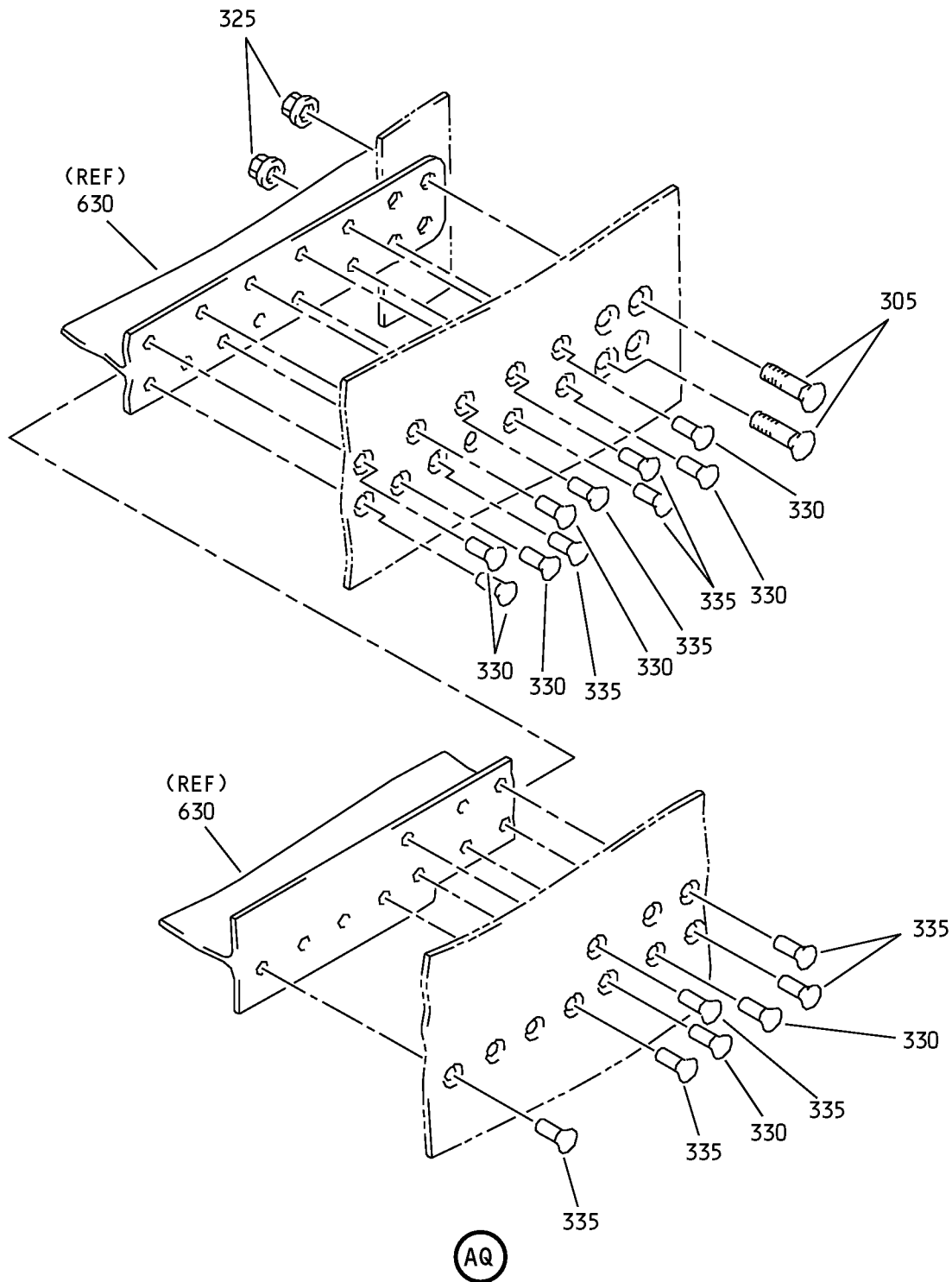
**52-41-05**

ILLUSTRATED PARTS LIST

Page 1098.12

Nov 01/2008

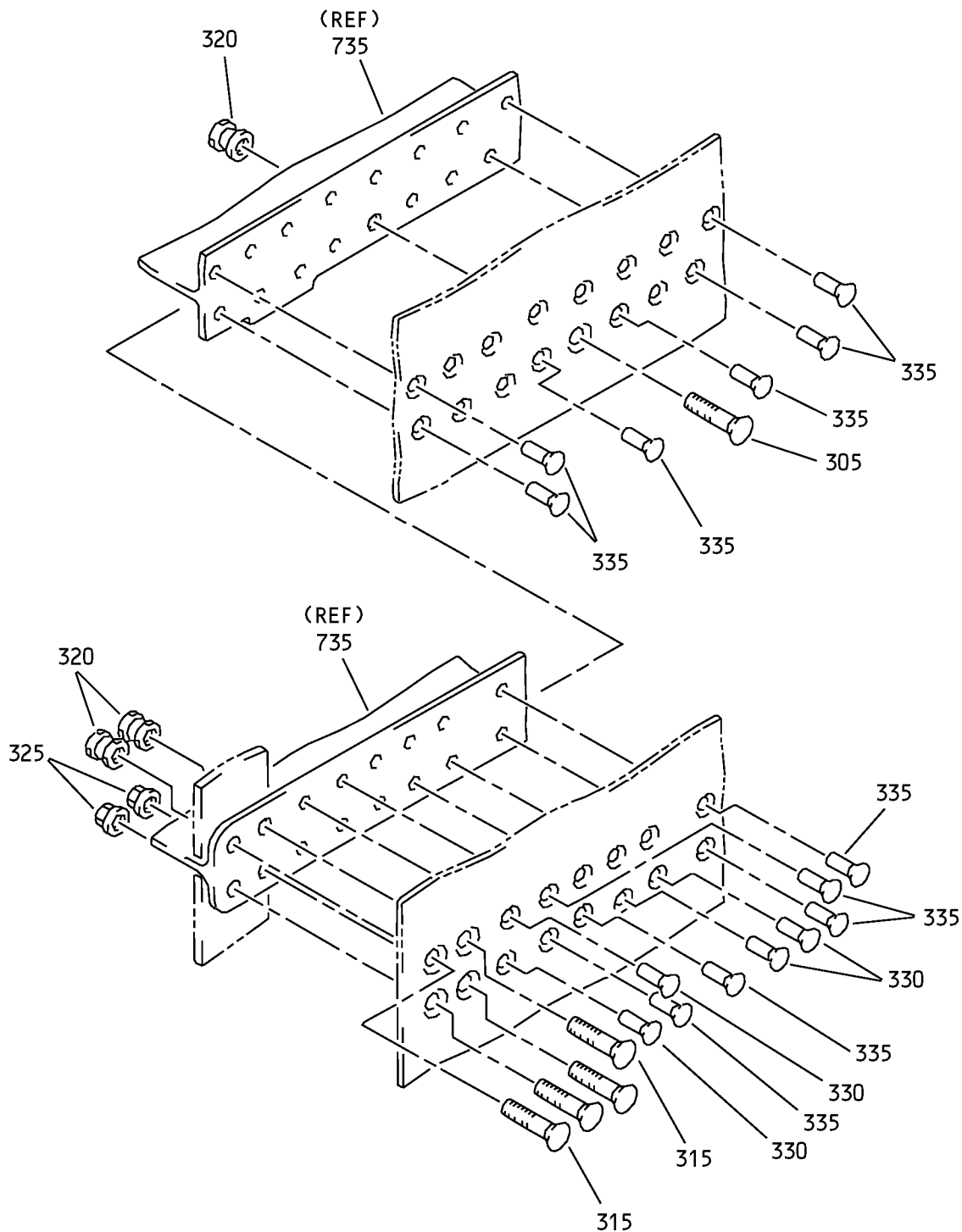
COMPONENT MAINTENANCE MANUAL



Forward Galley Door Assembly  
IPL Figure 2 (Sheet 28 of 37)

**52-41-05**  
ILLUSTRATED PARTS LIST  
Page 1098.13  
Nov 01/2008

COMPONENT MAINTENANCE MANUAL



AR

Forward Galley Door Assembly  
IPL Figure 2 (Sheet 29 of 37)

**52-41-05**

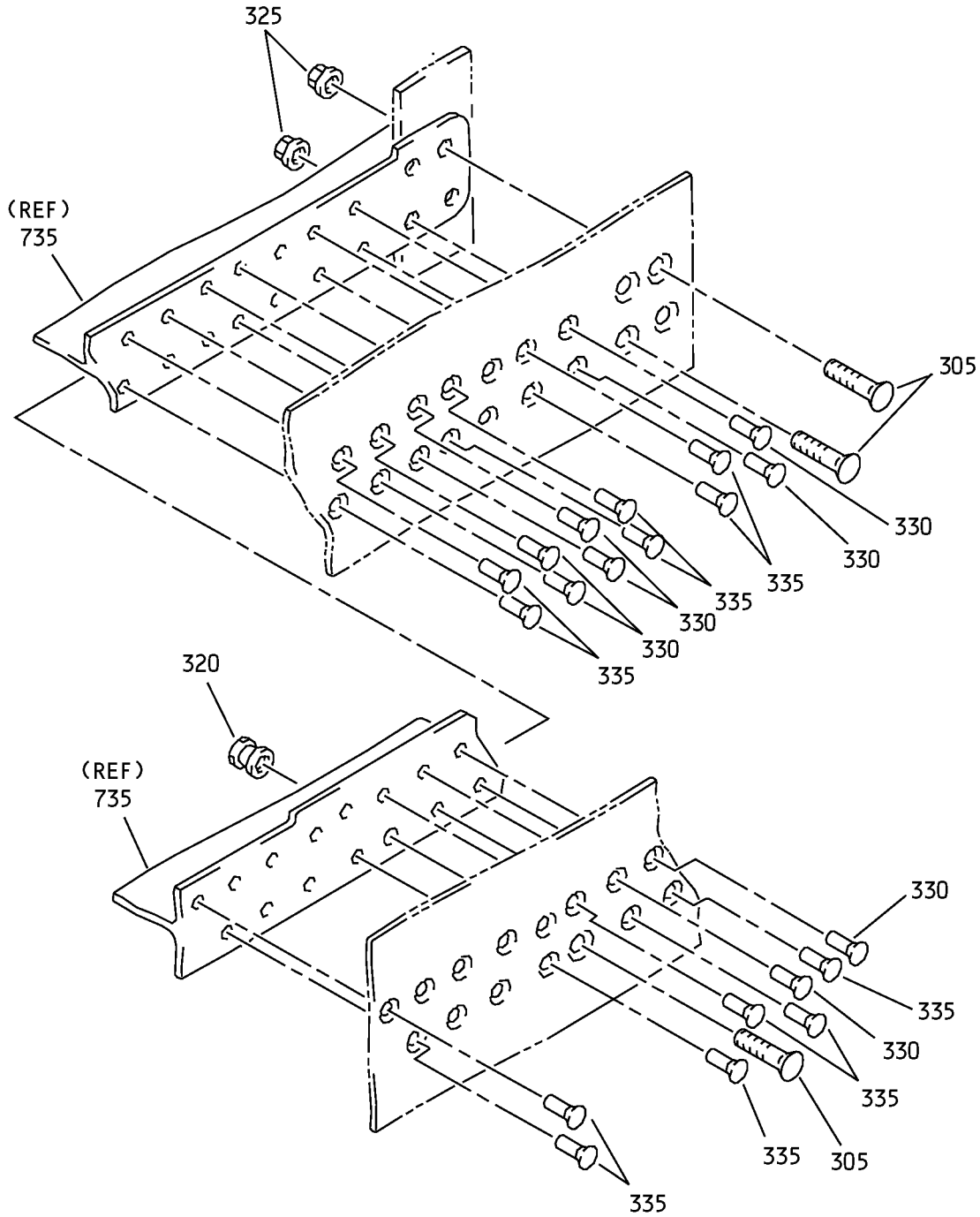
ILLUSTRATED PARTS LIST

Page 1098.14

Nov 01/2008



COMPONENT MAINTENANCE MANUAL



AS

Forward Galley Door Assembly  
IPL Figure 2 (Sheet 30 of 37)

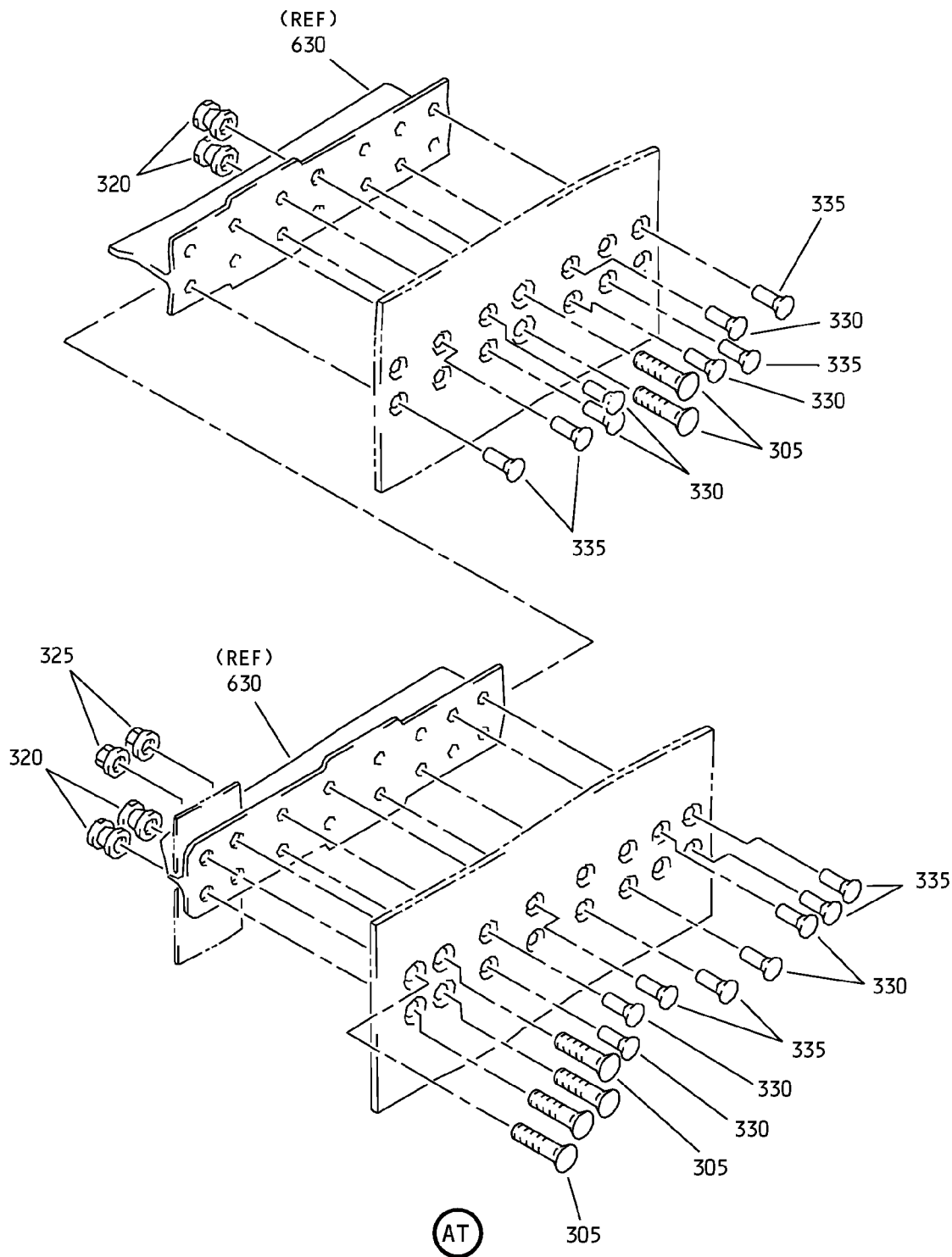
**52-41-05**

ILLUSTRATED PARTS LIST

Page 1098.15

Nov 01/2008

### COMPONENT MAINTENANCE MANUAL



Forward Galley Door Assembly  
IPL Figure 2 (Sheet 31 of 37)

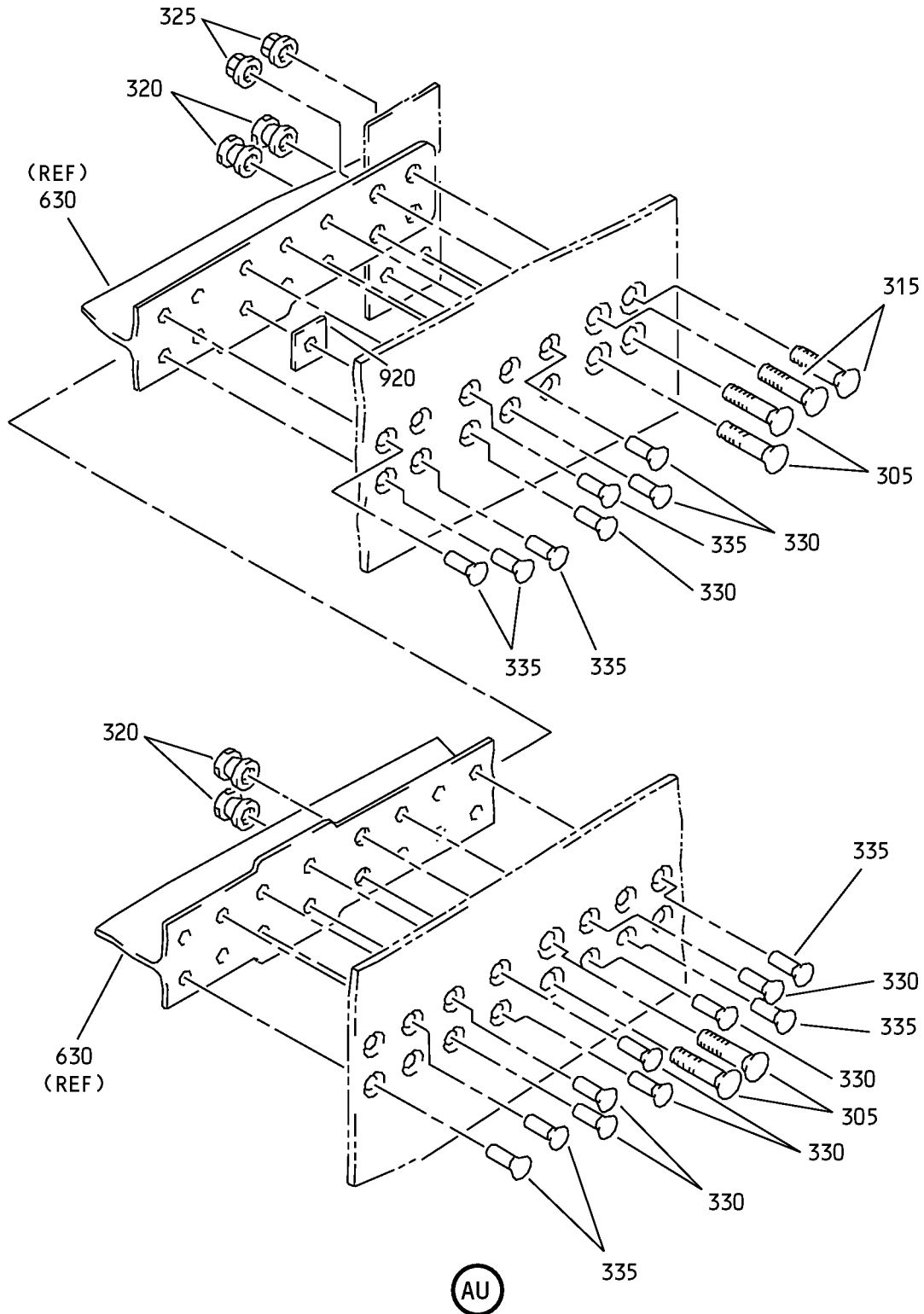
# 52-41-05

ILLUSTRATED PARTS LIST

Page 1098.16

Nov 01/2008

COMPONENT MAINTENANCE MANUAL



Forward Galley Door Assembly  
IPL Figure 2 (Sheet 32 of 37)

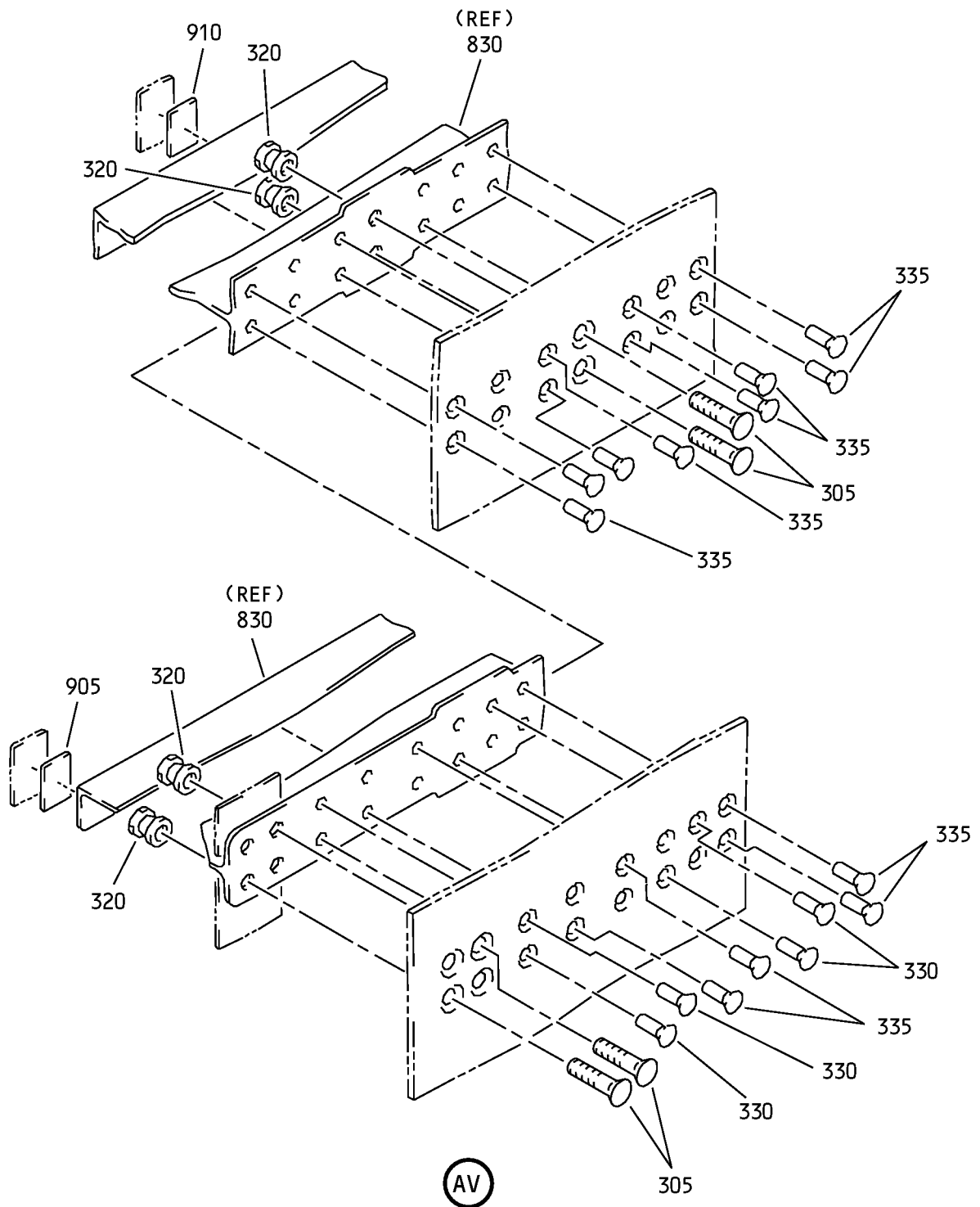
**52-41-05**

ILLUSTRATED PARTS LIST

Page 1098.17

Nov 01/2008

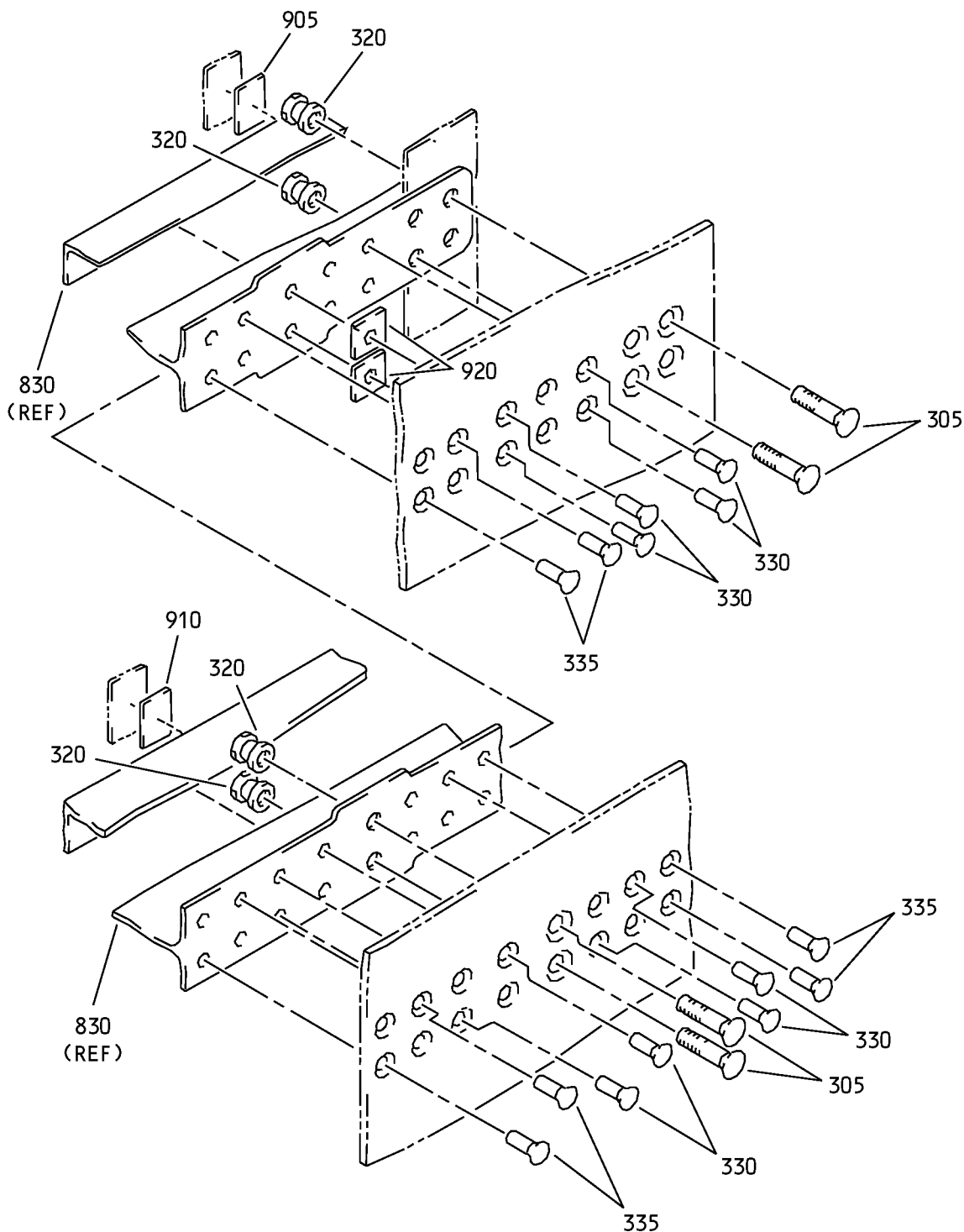
COMPONENT MAINTENANCE MANUAL



Forward Galley Door Assembly  
IPL Figure 2 (Sheet 33 of 37)

**52-41-05**  
ILLUSTRATED PARTS LIST  
Page 1098.18  
Nov 01/2008

### COMPONENT MAINTENANCE MANUAL



Forward Galley Door Assembly  
IPL Figure 2 (Sheet 34 of 37)

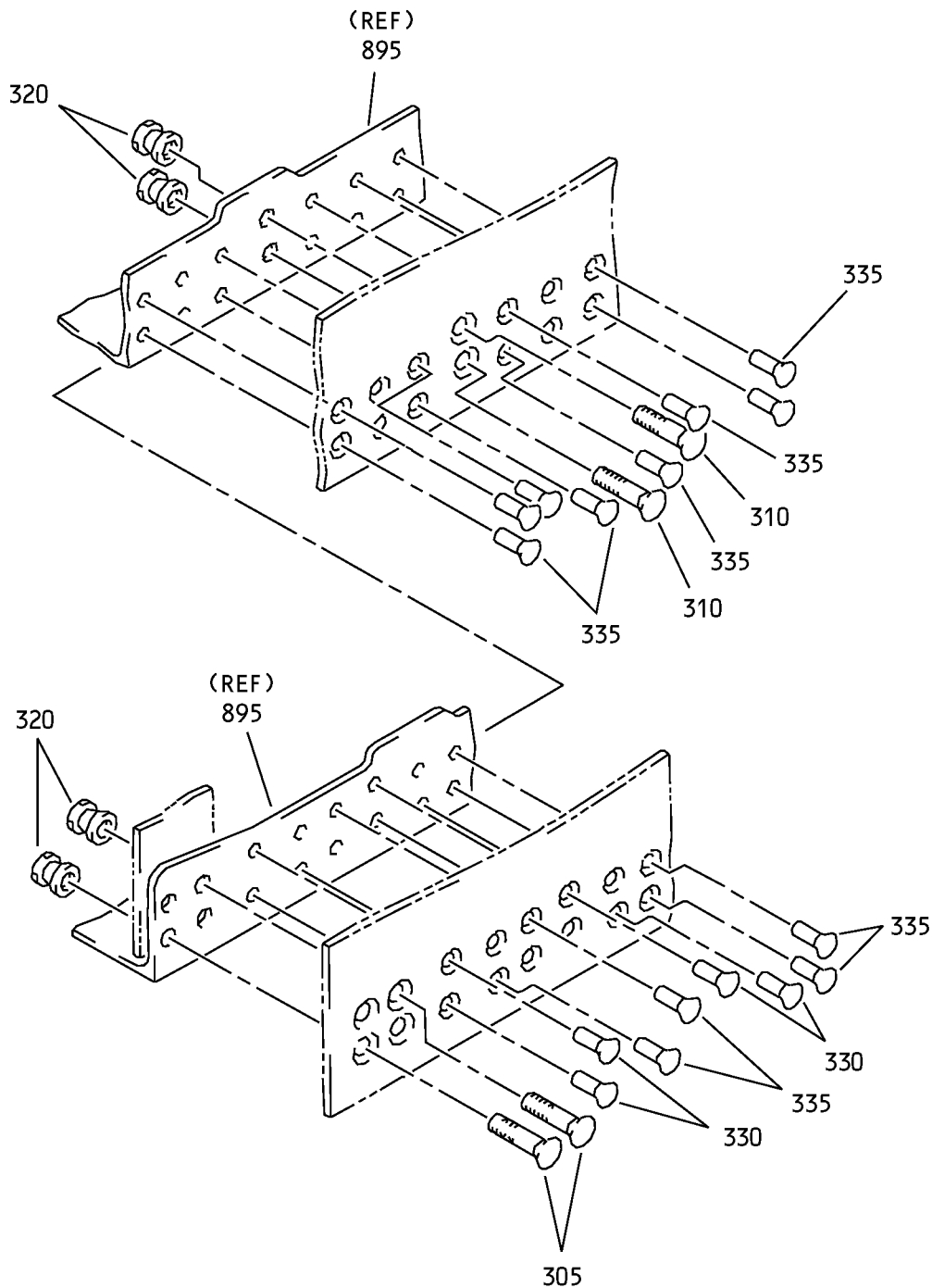
# 52-41-05

ILLUSTRATED PARTS LIST

Page 1098.19

Nov 01/2008

### COMPONENT MAINTENANCE MANUAL



AX

Forward Galley Door Assembly  
IPL Figure 2 (Sheet 35 of 37)

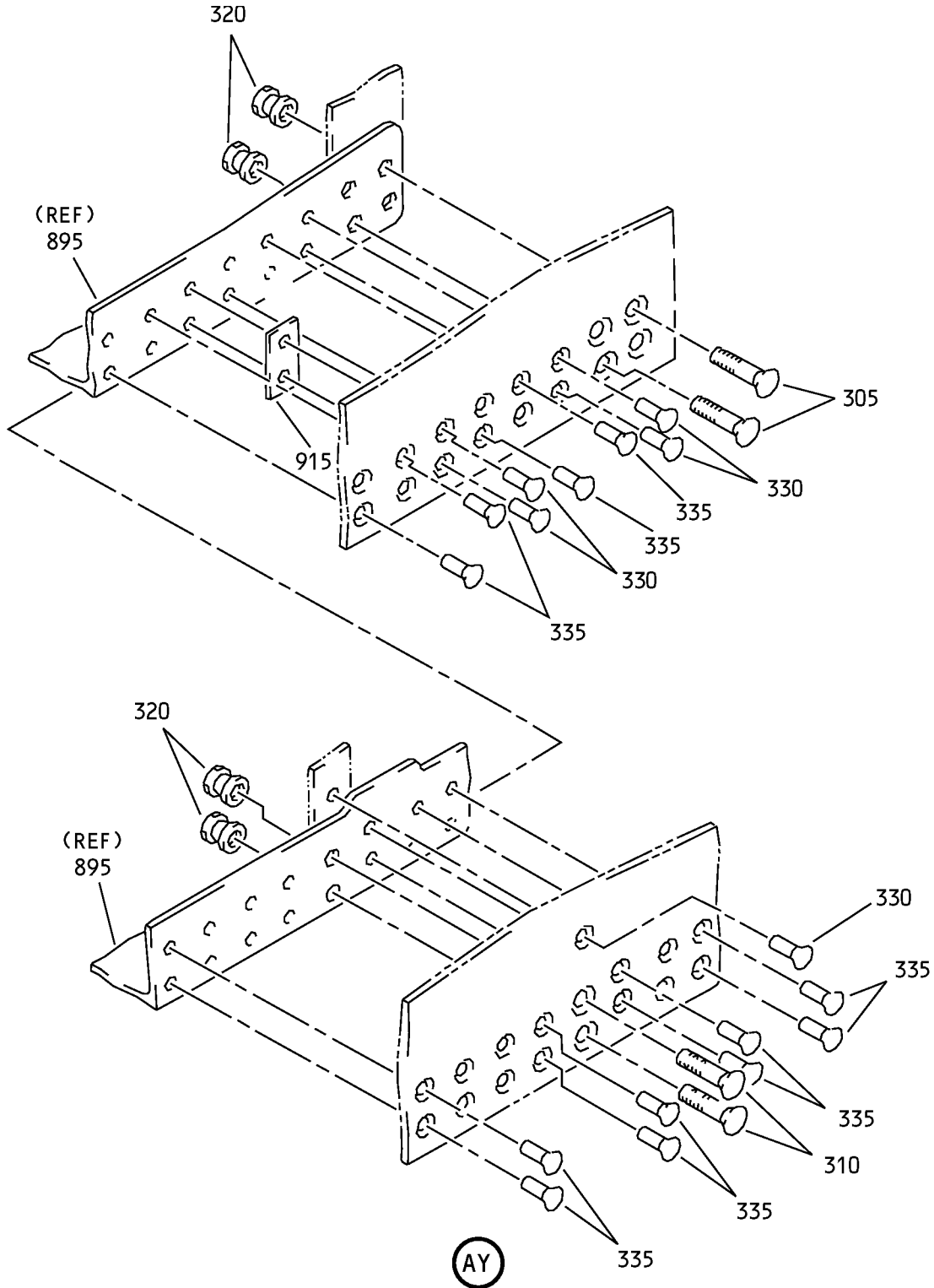
# 52-41-05

ILLUSTRATED PARTS LIST

Page 1098.20

Nov 01/2008

COMPONENT MAINTENANCE MANUAL



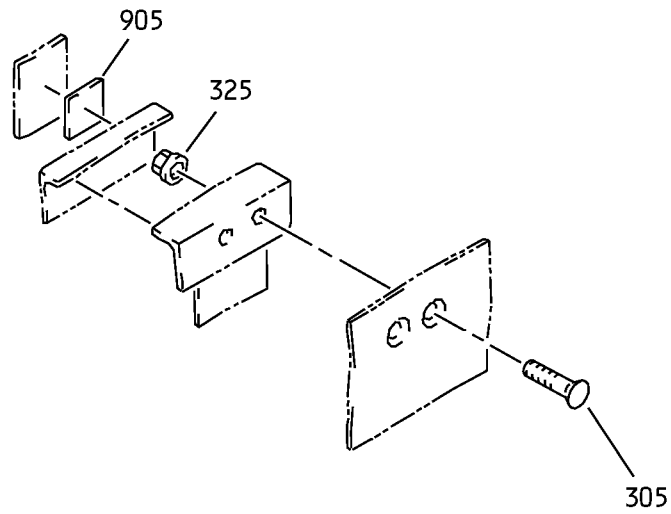
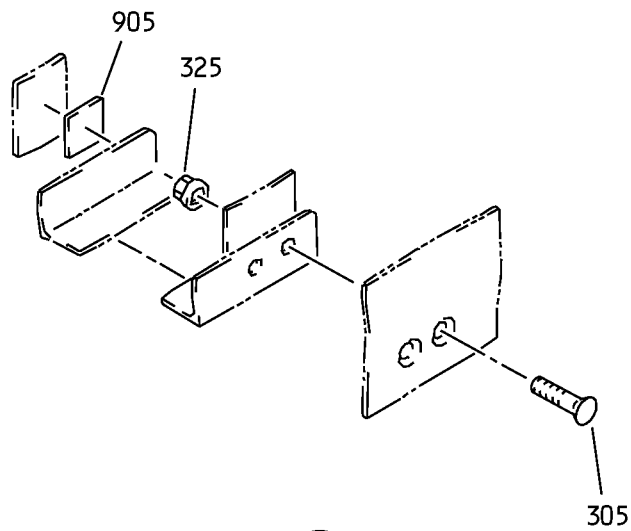
Forward Galley Door Assembly  
IPL Figure 2 (Sheet 36 of 37)

**52-41-05**

ILLUSTRATED PARTS LIST

Page 1098.21

Nov 01/2008

**COMPONENT MAINTENANCE MANUAL****AZ****BA**

Forward Galley Door Assembly  
IPL Figure 2 (Sheet 37 of 37)

**52-41-05**  
ILLUSTRATED PARTS LIST  
Page 1098.22  
Nov 01/2008





## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
2-											
-1A	141A6516-2										
-1B	141A6516-3										
-1C	141A6516-5										
-1D	141A6516-6										
-1E	141A6516-7									E	RF
-1F	141A6516-2									A	RF
-1G	141A6516-3									B	RF
-1H	141A6516-4									C	RF
-1J	141A6516-8									D	RF
-1K	141A6516-9									F	RF
-1L	141A6516-10									G	RF
-1M	141A6516-11									H	RF
-1N	141A6516-12									J	RF
-1P	141A6516-13									K	RF
-1Q	141A6516-14									L	RF

-Item not Illustrated

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1098.23

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
2-											
-1R	141A6516-15		DOOR ASSY-FWD GALLEY (FOR ADDITIONAL DETAILS SEE FIGS. 1 AND 3)							M	RF
-1S	141A6516-16		DOOR ASSY-FWD GALLEY (FOR ADDITIONAL DETAILS SEE FIGS. 1 AND 3)							N	RF
-1T	141A6516-17		DOOR ASSY-FWD GALLEY (FOR ADDITIONAL DETAILS SEE FIGS. 1 AND 3)							P	RF
-1U	141A6516-18		DOOR ASSY-FWD GALLEY (FOR ADDITIONAL DETAILS SEE FIGS. 1 AND 3)							Q	RF
-1V	141A6516-19		DOOR ASSY-FWD GALLEY (FOR ADDITIONAL DETAILS SEE FIGS. 1 AND 3)							R	RF
-1W	141A6516-20		DOOR ASSY-FWD GALLEY (FOR ADDITIONAL DETAILS SEE FIGS. 1 AND 3)							S	RF
-1X	141A6516-21		DOOR ASSY-FWD GALLEY (FOR ADDITIONAL DETAILS SEE FIGS. 1 AND 3)							T	RF
5	BACB30NM3K7		. BOLT								1
10	BACB30NM3K8		. BOLT								2
15	BACB30VF3K6		. BOLT								2
20	HST10AG6-5		. BOLT (V0PTK6) (SPEC BACB30VT6K5) (OPT HST10AG6-5 (V06725)) (OPT HST10AG6-5 (V56878)) (OPT HST10AG6-5 (V73197)) (OPT WC10K6-5 (V60516))								2
25	BACW10BN3AC		. WASHER								3
30	H52732-3CD		. NUT (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))								2

-Item not Illustrated

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1098.24

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
2- 35	HST79CY6		.									2
40	BACR15BA3AD		.									2
45	NS202493-02-4		.									1
50	BACF3T03G9-5		.							A-H		1
-50A	BACF3T03G09-05		.							J-T		1
55	BACF3T02G6-5		.							A-H		1
-55A	BACF3T02G06-05		.							J-T		1
60	141A6549-1		.									1
65	H52732-5CD		.	.								1
70	NAS1149D0532J		.	.								1
75	HRSC3CFR9		.	.								1
80	141A6549-2		.	.								1
85	141A6548-1		.									1
90	141A6547-1		.									1
95	BACR15BA3AD		.	.								4
100	BRF100C3D		.	.								2

-Item not illustrated

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1098.25

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
2-											
105	141A6547-2		.	.							1
110	BACF3T03G9-13		.						A-H		1
115	BACF3T02G6-13		.								1
120	HST11AG6-7		.								2
125	HST11AG6-5		.								3
130	HST11AG6-6		.								4
135	HST11AG5-6		.								2
140	HST11AG5-5		.								1
145	HST826AW		.								9

-Item not Illustrated

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1098.26

Nov 01/2008



COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE	USAGE							UNITS PER ASSY
				1	2	3	4	5	6	7	
2-											
150	HST82CY5APBW		. COLLAR (V73197) (SPEC BACC30BQ5) (OPT HST825AW (V56878)) (OPT HST825AW (V73197)) (OPT HST82CY5APBW (V56878))								3
155	BACR15GK4E2		. RIVET								25
160	BACR15BB4D		. RIVET								7
165	141A6534-3		. RETAINER-SEAL								1
170	141A6534-2		. RETAINER-SEAL								1
175	141A6534-1		. RETAINER-SEAL								1
180	141A6534-7		. RETAINER-SEAL								1
185	141A6534-8		. RETAINER-SEAL								1
190	141A6534-9		. RETAINER-SEAL								1
195	BACR15GF5D		. RIVET (SIZE DETERMINED ON INST)								40
200	141A6554-1		. PAN ASSY-EXT HANDLE								1
205	BACR15GF5D		. . RIVET (SIZE DETERMINED ON INST)								4
210	60-4412-2		. . PLATE-SEAL								1
215	65-52452-1		. . PAN								1
220	BACB30VF3K4		. BOLT								8
225	NAS1149D0363J		. WASHER								7
230	H52732-3CD		. NUT (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))								8
235	HST11AG8-6		. BOLT (V0PTK6) (SPEC BACB30VU8K6) (OPT HST11AG8-6 (V73197)) (OPT HST11AG8-6 (V56878)) (OPT HST11AG8-6 (V06725))								4

-Item not Illustrated

**52-41-05**

ILLUSTRATED PARTS LIST  
Page 1098.27  
Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY	
			1	2	3	4	5	6	7			
2- 240	HST10AG8-4		.	BOLT	(V0PTK6)	(SPEC BACB30VT8K4)	(OPT HST10AG8-4 (V06725))	(OPT HST10AG8-4 (V56878))	(OPT HST10AG8-4 (V73197))	(OPT WC10K8-4 (V60516))		4
245	HST10AG8-6		.	BOLT	(V0PTK6)	(SPEC BACB30VT8K6)	(OPT HST10AG8-6 (V06725))	(OPT HST10AG8-6 (V56878))	(OPT HST10AG8-6 (V73197))	(OPT WC10K8-6 (V60516))		2
250	HST10AG8-7		.	BOLT	(V0PTK6)	(SPEC BACB30VT8K7)	(OPT HST10AG8-7 (V06725))	(OPT HST10AG8-7 (V56878))	(OPT HST10AG8-7 (V73197))	(OPT WC10K8-7 (V60516))		1
255	HST10AG8-8		.	BOLT	(V0PTK6)	(SPEC BACB30VT8K8)	(OPT HST10AG8-8 (V06725))	(OPT HST10AG8-8 (V56878))	(OPT HST10AG8-8 (V73197))	(OPT WC10K8-8 (V60516))		1
260	HST79CY8		.	COLLAR	(V73197)	(SPEC BACC30BL8)	(OPT HST79-8 (V92215))	(OPT HST79CY8 (V56878))	(OPT HST79CY8 (V5M902))			6
265	HST828AW		.	COLLAR	(V5M902)	(SPEC BACC30BQ8)	(OPT HST828AW (V56878))	(OPT HST828AW (V73197))	(OPT HST82CY8APBW (V73197))	(OPT HST82CY8APBW (V56878))		6

-Item not Illustrated

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1098.28

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
2- 270	HST10AG6-5		.	BOLT							4
				(V0PTK6)							
				(SPEC BACB30VT6K5)							
				(OPT HST10AG6-5 (V06725))							
				(OPT HST10AG6-5 (V56878))							
				(OPT HST10AG6-5 (V73197))							
				(OPT WC10K6-5 (V60516))							
275	HST10AG6-4		.	BOLT							9
				(V06725)							
				(SPEC BACB30VT6K4)							
				(OPT HST10AG6-4 (V73197))							
				(OPT HST10AG6-4 (V56878))							
				(OPT HST10AG6-4 (V0PTK6))							
280	HST10AG6-3		.	BOLT							44
				(V0PTK6)							
				(SPEC BACB30VT6K3)							
				(OPT HST10AG6-3 (V06725))							
				(OPT HST10AG6-3 (V56878))							
				(OPT HST10AG6-3 (V73197))							
				(OPT WC10K6-3 (V60516))							
285	HST11AG6-3		.	BOLT							16
				(V06725)							
				(SPEC BACB30VU6K3)							
				(OPT HST11AG6-3 (V73197))							
				(OPT HST11AG6-3 (V56878))							
				(OPT HST11AG6-3 (V0PTK6))							
290	HST11AG6-5		.	BOLT							2
				(V06725)							
				(SPEC BACB30VU6K5)							
				(OPT HST11AG6-5 (V73197))							
				(OPT HST11AG6-5 (V56878))							
				(OPT HST11AG6-5 (V0PTK6))							
295	HST826AW		.	COLLAR							13
				(V5M902)							
				(SPEC BACC30BQ6)							
				(OPT HST826AW (V56878))							
				(OPT HST826AW (V73197))							
				(OPT HST82CY6APBW (V73197))							
				(OPT HST82CY6APBW (V56878))							

-Item not Illustrated

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1098.29

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE	USAGE CODE	UNITS PER ASSY
2- 300	HST79CY6		. COLLAR (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V92215)) (OPT HST79CY6 (V56878)) (OPT HST79CY6 (V5M902))		62
305	HST11AG6-4		. BOLT (V06725) (SPEC BACB30VU6K4) (OPT HST11AG6-4 (V73197)) (OPT HST11AG6-4 (V0PTK6)) (OPT HST11AG6-4 (V56878))		72
310	HST11AG6-3		. BOLT (V06725) (SPEC BACB30VU6K3) (OPT HST11AG6-3 (V73197)) (OPT HST11AG6-3 (V56878)) (OPT HST11AG6-3 (V0PTK6))		8
315	HST11AG6-5		. BOLT (V06725) (SPEC BACB30VU6K5) (OPT HST11AG6-5 (V73197)) (OPT HST11AG6-5 (V56878)) (OPT HST11AG6-5 (V0PTK6))		12
320	HST79CY6		. COLLAR (V73197) (SPEC BACC30BL6) (OPT HST79-6 (V92215)) (OPT HST79CY6 (V56878)) (OPT HST79CY6 (V5M902))		68
325	CR6551-3		. NUT (VF0224) (SPEC BACN10ZV3)		24
330	BACR15GF6D		. RIVET (SIZE DETERMINED ON INST)		110
335	BACR15GF5D		. RIVET (SIZE DETERMINED ON INST)		272
-340	141A6535-8		. BEAM ASSY	A-C	1
340A	141A6535-12		. BEAM ASSY	D-T	1
345	BACR15BB4D		. . RIVET (SIZE DETERMINED ON INST)		12

-Item not Illustrated

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1098.30

Nov 01/2008





## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
2-											
350	SL2808-3								. . SHOCKMOUNT (V97393) (SPEC BACS14K1) (OPT DE685-10 (V71985))		6
355	LGPL2SPV10-6AC								. . BOLT (V17446) (SPEC BACB30VN10K6) (OPT LGPL2SPV10-6AC (V92215)) (OPT 81669V10K6 (V56878)) (OPT LGPL2SPV10-6AC (V56878))		1
360	LGPL2SPV8-6AC								. . BOLT (V17446) (SPEC BACB30VN8K6) (OPT LGPL2SPV8-6AC (V92215)) (OPT 81669V8K6 (V56878)) (OPT LGPL2SPV8-6AC (V56878))		5
365	LGPL2SPV8-5AC								. . BOLT (V17446) (SPEC BACB30VN8K5) (OPT LGPL2SPV8-5AC (V92215)) (OPT 81669V8K5 (V56878)) (OPT LGPL2SPV8-5AC (V56878))		2
370	3SLCC10								. . COLLAR (V17446) (SPEC BACC30BK10) (OPT 3SLCC100GC (V92215))		1
375	3SLCC8								. . COLLAR (V17446) (SPEC BACC30BK8) (OPT 3SLCC8 (V92215))		7
380	141A6538-11								. . STOP ASSY		1
385	141A6538-12								. . STOP ASSY		1
390	66-12688-11								. . . BUSHING		1
395	141A6538-23								. . . STOP (USED ON ITEM 380)		1
400	141A6538-24								. . . STOP (USED ON ITEM 385)		1
405	141A6536-18								DELETED		
405A	141A6536-19								. . BEAM		1
410	141A6536-17								. BEAM		1

-Item not illustrated

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1098.31

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
2-											
415	141A6535-6		.								1
420	BACR15BB4AD		..								2
425	NAS1149DN432J		..								2
430	140N2021-1		..								1
435	LGPL2SPV8-8AC		..								2
440	LGPL2SPV8-6AC		..								1
445	LGPL2SPV8-7AC		..								1
450	LGPL2SPV8-4AC		..								3
455	LGPL2SPV6-8AC		..								2
460	LGPL2SPV6-9AC		..								1

-Item not Illustrated

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1098.32

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
2-											
465	LGPL2SPV6-4AC		. .	BOLT							3
				(V17446)							
				(SPEC BACB30VN6K4)							
				(OPT LGPL2SPV6-4AC (V92215))							
				(OPT 81669V6K4 (V56878))							
				(OPT LGPL2SPV6-4AC (V56878))							
470	3SLCC8		. .	COLLAR							7
				(V17446)							
				(SPEC BACC30BK8)							
				(OPT 3SLCC8 (V92215))							
475	3SLCC6		. .	COLLAR							6
				(V17446)							
				(SPEC BACC30BK6)							
				(OPT 3SLCC6 (V92215))							
480	141A6538-9		. .	STOP ASSY							1
485	141A6538-10		. .	STOP ASSY							1
490	66-12688-11		. . .	BUSHING							1
495	141A6538-21		. . .	STOP							1
				(USED ON ITEM 480)							
500	141A6538-22		. . .	STOP							1
				(USED ON ITEM 485)							
505	BACS40R007F013F		. .	SHIM							1
510	BACS40R008F015F		. .	SHIM							1
515	141A6536-16		. .	BEAM							1
520	141A6535-5		. .	BEAM ASSY					A		1
-520A	141A6535-11		. .	BEAM ASSY					B-T		1
525	BACB30NM3K5		. .	BOLT							10
530	NAS1149D0363J		. .	WASHER							10
535	BACR15BA3AD		. .	RIVET							20
				(SIZE DETERMINED ON INST)							
				(OPT ITEM 535A, 535B)							
-535A	AF5141-3C		. .	RIVET							20
				(V53551)							
				(SPEC BACR15DR3AC)							
				(SIZE DETERMINED ON INST)							
				(OPT ITEM 535, 535B)							
-535B	NAS1399CW3		. .	RIVET							20
				(SIZE DETERMINED ON INST)							
				(OPT ITEM 535, 535A)							

-Item not Illustrated

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1098.33

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
2-											
540	NS202495-02		. .								10
545	149A6114-1		. .								1
550	BACR15BA5AD		. .								4
555	149A6116-3		. .								2
560	LGPL2SPV8-4AC		. .								4
565	LGPL2SPV8-6AC		. .								1
570	LGPL2SPV8-7AC		. .						A		1
-570A	LGPL2SPV6-7AC		. .						B-T		1
575	LGPL2SPV8-8AC		. .						A		1

-Item not Illustrated

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1098.34

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
2- -575A	LGPL2SPV6-8AC		. .	BOLT						B-T	1
				(V17446)							
				(SPEC BACB30VN6K8)							
				(OPT LGPL2SPV6-8AC (V92215))							
				(OPT 81669V6K8 (V56878))							
				(OPT LGPL2SPV6-8AC (V56878))							
580	LGPL2SPV6-4AC		. .	BOLT							3
				(V17446)							
				(SPEC BACB30VN6K4)							
				(OPT LGPL2SPV6-4AC (V92215))							
				(OPT 81669V6K4 (V56878))							
				(OPT LGPL2SPV6-4AC (V56878))							
585	LGPL2SPV6-7AC		. .	BOLT							1
				(V17446)							
				(SPEC BACB30VN6K7)							
				(OPT LGPL2SPV6-7AC (V92215))							
				(OPT 81669V5K6 (V56878))							
				(OPT LGPL2SPV6-7AC (V56878))							
590	3SLCC8		. .	COLLAR							5
				(V17446)							
				(SPEC BACC30BK8)							
				(OPT 3SLCC8 (V92215))							
595	3SLCC8		. .	COLLAR					A		2
				(V17446)							
				(SPEC BACC30BK8)							
				(OPT 3SLCC8 (V92215))							
-595A	3SLCC6		. .	COLLAR					B-T		2
				(V17446)							
				(SPEC BACC30BK6)							
				(OPT 3SLCC6 (V92215))							
600	3SLCC6		. .	COLLAR							4
				(V17446)							
				(SPEC BACC30BK6)							
				(OPT 3SLCC6 (V92215))							
605	141A6538-5		. .	STOP ASSY							1
610	141A6538-8		. .	STOP ASSY							1
615	66-12688-11		. . .	BUSHING							1
620	141A6538-17		. . .	STOP							1
				(USED ON ITEM 605)							
625	141A6538-20		. . .	STOP							1
				(USED ON ITEM 610)							

-Item not illustrated

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1098.35

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
2-											
630	141A6536-15								. . BEAM		1
635	141A6535-4								. BEAM ASSY		1
640	BACB30NM3K5								. . BOLT		10
645	NAS1149D0363J								. . WASHER		10
650	BACR15BA3AD								. . RIVET (SIZE DETERMINED ON INST) (OPT ITEM 650A, 650B)		20
-650A	AF5141-3C								. . RIVET (V53551) (SPEC BACR15DR3AC) (SIZE DETERMINED ON INST) (OPT ITEM 650, 650B)		20
-650B	NAS1399CW3								. . RIVET (SIZE DETERMINED ON INST) (OPT ITEM 650, 650A)		20
655	NS202495-02								. . NUTPLATE (V80539) (SPEC BACN10KE3DCD) (OPT F51753-3DC (V15656))		10
660	149A6114-1								. . SPLICE		1
665	BACR15BA5AD								. . RIVET (SIZE DETERMINED ON INST)		4
670	149A6116-2								. . FILLER		2
675	LGPL2SPV8-4AC								. . BOLT (V17446) (SPEC BACB30VN8K4) (OPT LGPL2SPV8-4AC (V92215)) (OPT 81669V8K4 (V56878)) (OPT LGPL2SPV8-4AC (V56878))		4
680	LGPL2SPV8-5AC								. . BOLT (V17446) (SPEC BACB30VN8K5) (OPT LGPL2SPV8-5AC (V92215)) (OPT 81669V8K5 (V56878)) (OPT LGPL2SPV8-5AC (V56878))		1
685	LGPL2SPV6-4AC								. . BOLT (V17446) (SPEC BACB30VN6K4) (OPT LGPL2SPV6-4AC (V92215)) (OPT 81669V6K4 (V56878)) (OPT LGPL2SPV6-4AC (V56878))		3

-Item not Illustrated

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1098.36

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
2-											
690	LGPL2SPV6-6AC		. .	BOLT							1
				(V17446)							
				(SPEC BACB30VN6K6)							
				(OPT LGPL2SPV6-6AC (V92215))							
				(OPT 81669V6K6 (V56878))							
				(OPT LGPL2SPV6-6AC (V56878))							
695	LGPL2SPV6-7AC		. .	BOLT							2
				(V17446)							
				(SPEC BACB30VN6K7)							
				(OPT LGPL2SPV6-7AC (V92215))							
				(OPT 81669V5K6 (V56878))							
				(OPT LGPL2SPV6-7AC (V56878))							
700	3SLCC8		. .	COLLAR							5
				(V17446)							
				(SPEC BACC30BK8)							
				(OPT 3SLCC8 (V92215))							
705	3SLCC6		. .	COLLAR							6
				(V17446)							
				(SPEC BACC30BK6)							
				(OPT 3SLCC6 (V92215))							
710	141A6538-5		. .	STOP ASSY							1
715	141A6538-6		. .	STOP ASSY							1
720	66-12688-11		. . .	BUSHING							1
725	141A6538-17		. . .	STOP							1
				(USED ON ITEM 710)							
730	141A6538-18		. . .	STOP							1
				(USED ON ITEM 715)							
735	141A6536-14		. .	BEAM							1
740	141A6535-9		. .	BEAM ASSY							1
745	LGPL2SPV8-7AC		. .	BOLT							1
				(V17446)							
				(SPEC BACB30VN8K7)							
				(OPT LGPL2SPV8-7AC (V92215))							
				(OPT 81669V8K7 (V56878))							
				(OPT LGPL2SPV8-7AC (V56878))							
750	LGPL2SPV8-5AC		. .	BOLT							1
				(V17446)							
				(SPEC BACB30VN8K5)							
				(OPT LGPL2SPV8-5AC (V92215))							
				(OPT 81669V8K5 (V56878))							
				(OPT LGPL2SPV8-5AC (V56878))							

-Item not Illustrated

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1098.37

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
2- 755	LGPL2SPV8-8AC		. .	BOLT							1
				(V17446)							
				(SPEC BACB30VN8K8)							
				(OPT LGPL2SPV8-8AC (V92215))							
				(OPT 81669V8K8 (V56878))							
				(OPT LGPL2SPV8-8AC (V56878))							
760	LGPL2SPV8-6AC		. .	BOLT							1
				(V17446)							
				(SPEC BACB30VN8K6)							
				(OPT LGPL2SPV8-6AC (V92215))							
				(OPT 81669V8K6 (V56878))							
				(OPT LGPL2SPV8-6AC (V56878))							
765	LGPL2SPV8-4AC		. .	BOLT							3
				(V17446)							
				(SPEC BACB30VN8K4)							
				(OPT LGPL2SPV8-4AC (V92215))							
				(OPT 81669V8K4 (V56878))							
				(OPT LGPL2SPV8-4AC (V56878))							
770	LGPL2SPV6-8AC		. .	BOLT							3
				(V17446)							
				(SPEC BACB30VN6K8)							
				(OPT LGPL2SPV6-8AC (V92215))							
				(OPT 81669V6K8 (V56878))							
				(OPT LGPL2SPV6-8AC (V56878))							
775	LGPL2SPV6-4AC		. .	BOLT							3
				(V17446)							
				(SPEC BACB30VN6K4)							
				(OPT LGPL2SPV6-4AC (V92215))							
				(OPT 81669V6K4 (V56878))							
				(OPT LGPL2SPV6-4AC (V56878))							
780	3SLCC8		. .	COLLAR							7
				(V17446)							
				(SPEC BACC30BK8)							
				(OPT 3SLCC8 (V92215))							
785	3SLCC6		. .	COLLAR							6
				(V17446)							
				(SPEC BACC30BK6)							
				(OPT 3SLCC6 (V92215))							
790	141A6538-4		. .	STOP ASSY							1
795	141A6538-25		. .	STOP ASSY							1
800	66-12688-11		. . .	BUSHING							1

-Item not Illustrated

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1098.38

Nov 01/2008





## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
2-											
805	141A6538-16		. . .	STOP							1
				(USED ON ITEM 790)							
810	141A6538-26		. . .	STOP							1
				(USED ON ITEM 795)							
815	BACS40R007B013F		. .	SHIM							1
820	BACS40R008B015F		. .	SHIM							1
825	141A6536-13		. .	BEAM							1
830	141A6536-12		. .	BEAM							1
835	141A6535-1		. .	BEAM ASSY							1
840	BACR15BB4D		. .	RIVET							4
				(SIZE DETERMINED ON INST)							
845	SL2808-3		. .	SHOCKMOUNT							2
				(V97393)							
				(SPEC BACS14K1)							
				(OPT DE685-10 (V71985))							
850	LGPL2SPV8-7AC		. .	BOLT							6
				(V17446)							
				(SPEC BACB30VN8K7)							
				(OPT LGPL2SPV8-7AC (V92215))							
				(OPT 81669V8K7 (V56878))							
				(OPT LGPL2SPV8-7AC (V56878))							
855	LGPL2SPV8-6AC		. .	BOLT							4
				(V17446)							
				(SPEC BACB30VN8K6)							
				(OPT LGPL2SPV8-6AC (V92215))							
				(OPT 81669V8K6 (V56878))							
				(OPT LGPL2SPV8-6AC (V56878))							
860	LGPL2SPV8-5AC		. .	BOLT							4
				(V17446)							
				(SPEC BACB30VN8K5)							
				(OPT LGPL2SPV8-5AC (V92215))							
				(OPT 81669V8K5 (V56878))							
				(OPT LGPL2SPV8-5AC (V56878))							
865	3SLCC8		. .	COLLAR							14
				(V17446)							
				(SPEC BACC30BK8)							
				(OPT 3SLCC8 (V92215))							
870	141A6538-1		. .	STOP ASSY							1
875	141A6538-2		. .	STOP ASSY							1
880	66-12688-11		. . .	BUSHING							1

-Item not Illustrated

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1098.39

Nov 01/2008

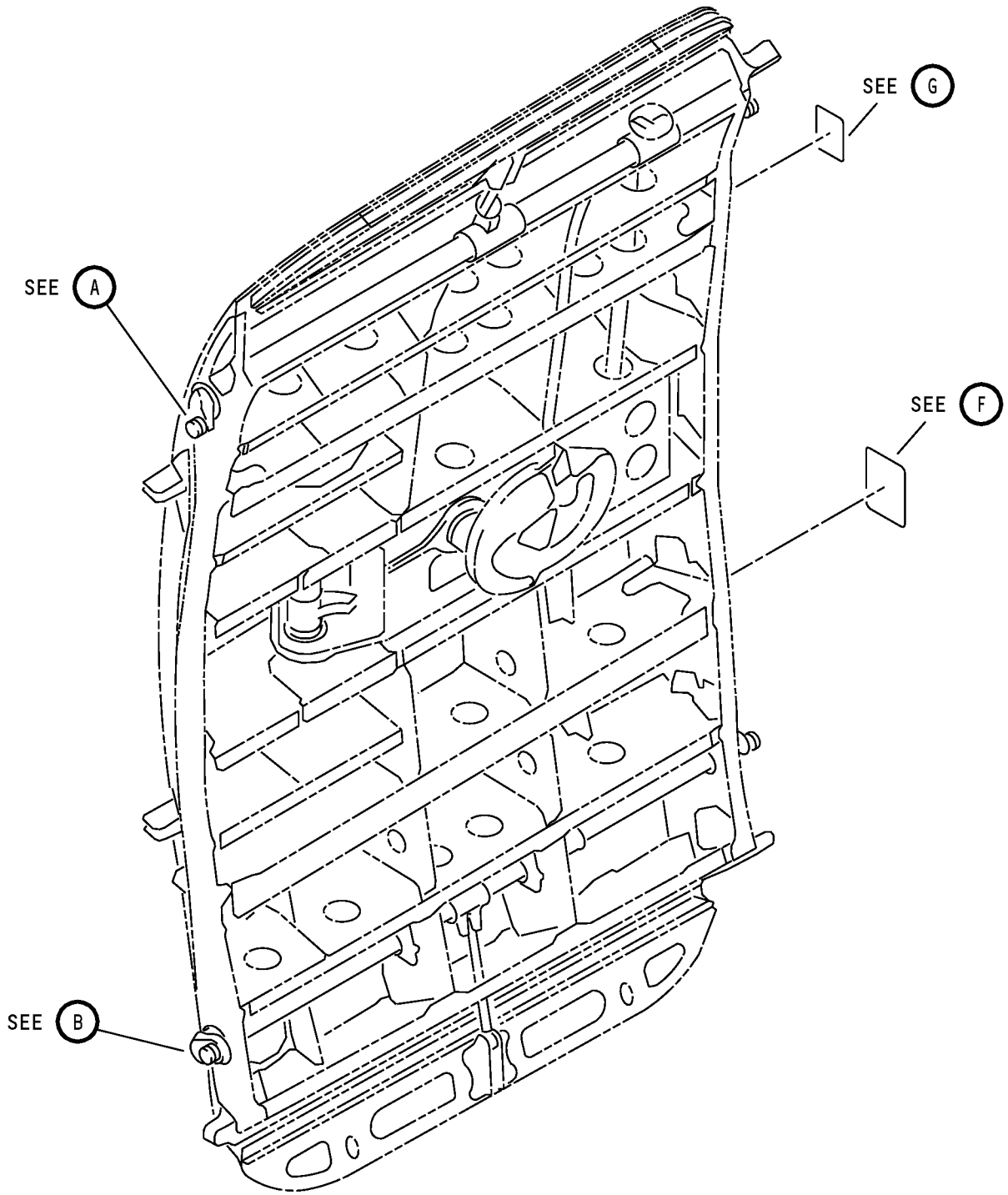


## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
2- 885	141A6538-13		.	.	.	STOP (USED ON ITEM 870)					1
890	141A6538-14		.	.	.	STOP (USED ON ITEM 875)					1
895	141A6536-11		.	.	BEAM						1
900	BACF3H06JK006HN		.	FILLER							1
905	BACS40R008C008F		.	SHIM							AR
910	BACS40R007B009F		.	SHIM							AR
915	BACS40R007B017F		.	SHIM							AR
920	BACS40R007B008F		.	SHIM							AR

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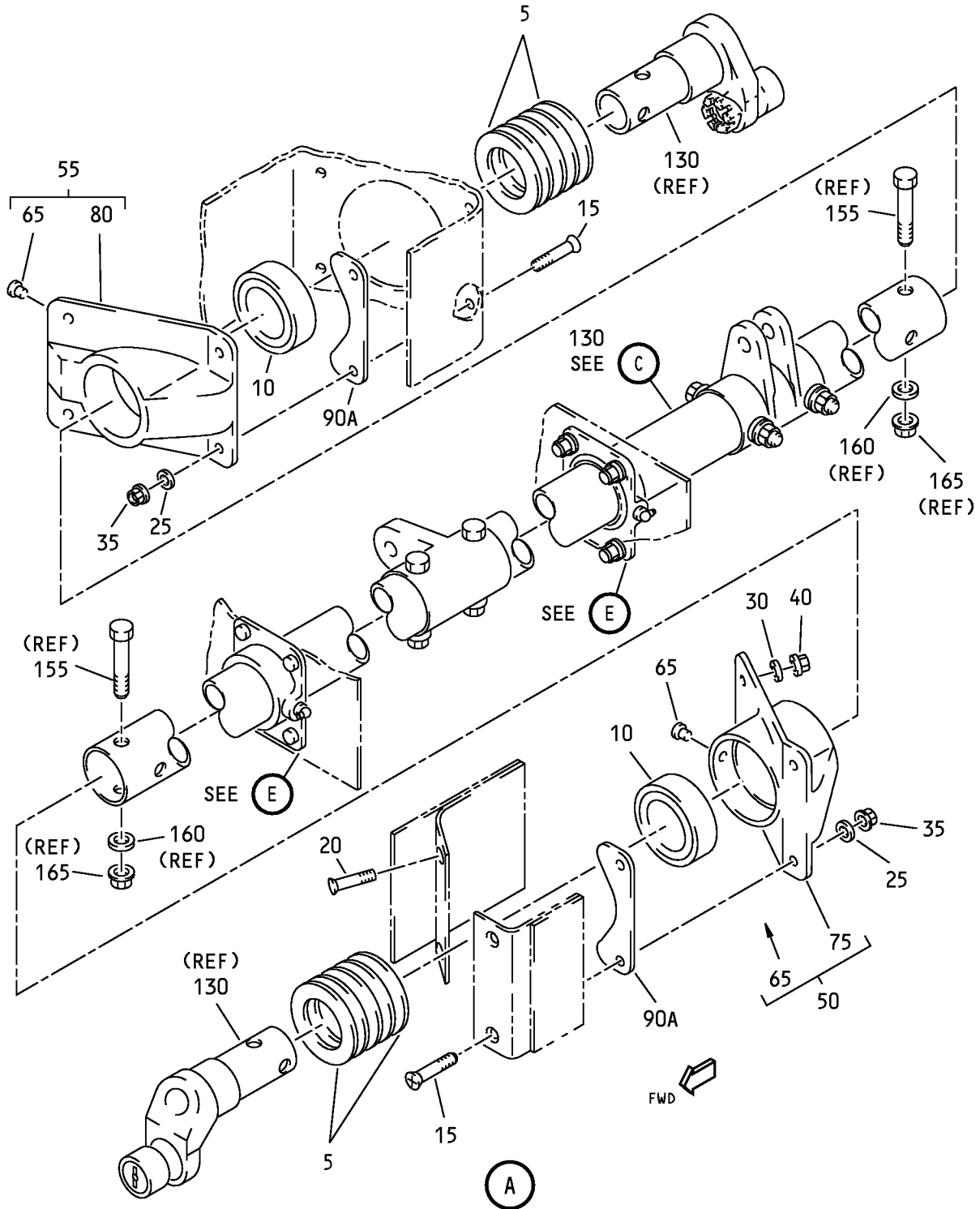
COMPONENT MAINTENANCE MANUAL



Forward Galley Door Assembly  
IPL Figure 3 (Sheet 1 of 6)

**52-41-05**  
ILLUSTRATED PARTS LIST  
Page 1098.41  
Nov 01/2008

COMPONENT MAINTENANCE MANUAL



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Forward Galley Door Assembly  
IPL Figure 3 (Sheet 2 of 6)

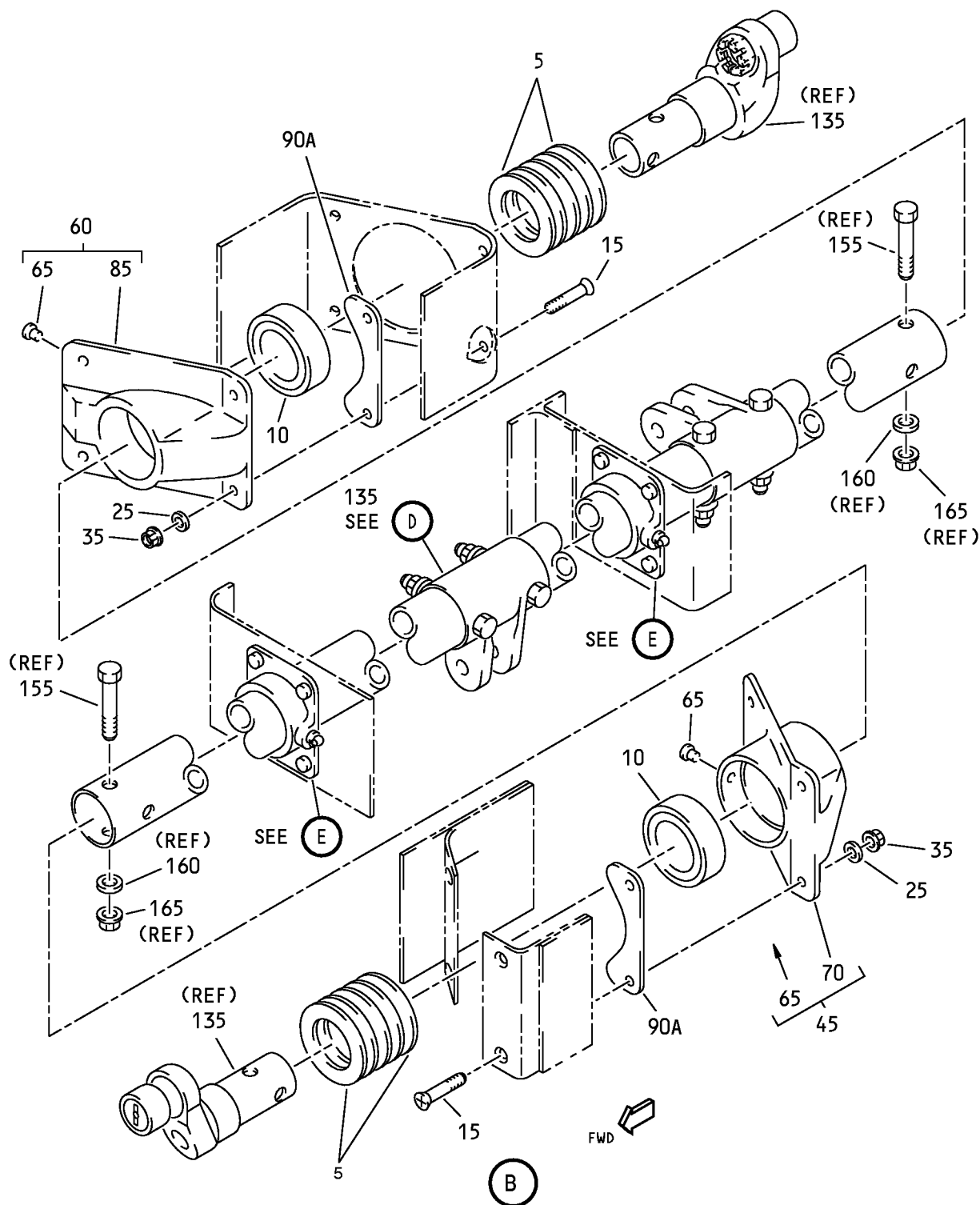
**52-41-05**

ILLUSTRATED PARTS LIST

Page 1098.42

Nov 01/2008

COMPONENT MAINTENANCE MANUAL

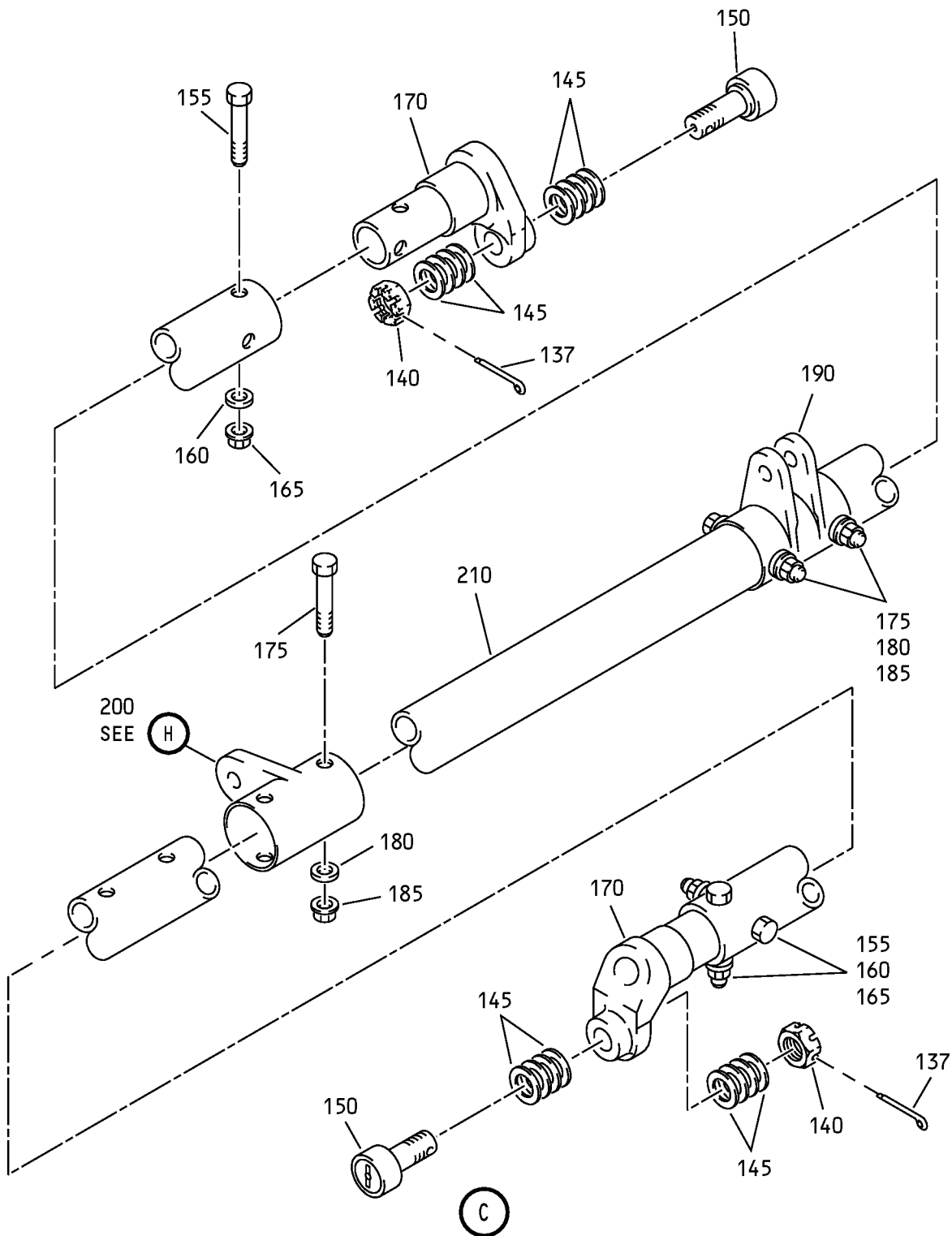


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Forward Galley Door Assembly  
IPL Figure 3 (Sheet 3 of 6)

**52-41-05**  
ILLUSTRATED PARTS LIST  
Page 1098.43  
Nov 01/2008

COMPONENT MAINTENANCE MANUAL



Forward Galley Door Assembly  
IPL Figure 3 (Sheet 4 of 6)

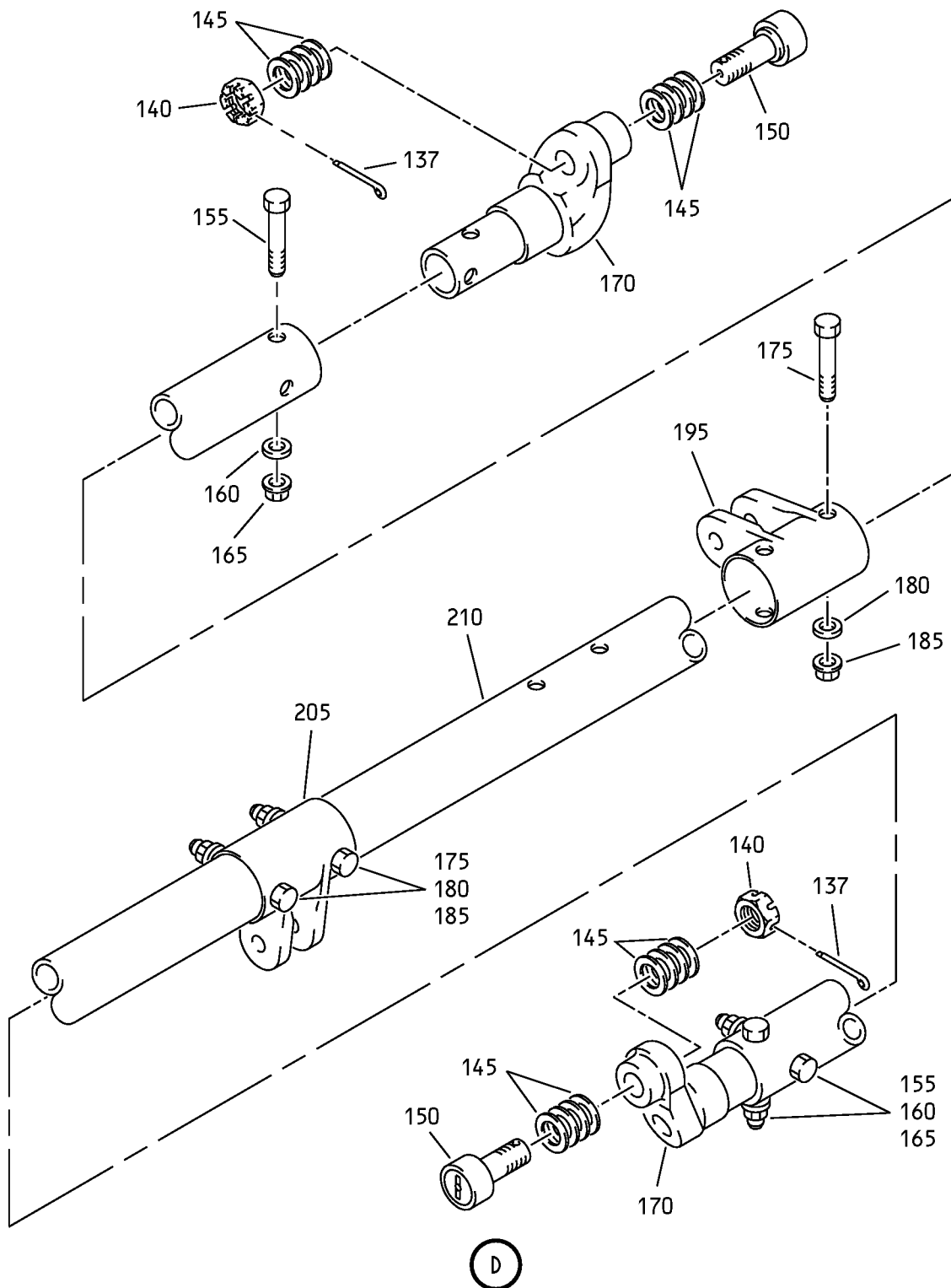
**52-41-05**

ILLUSTRATED PARTS LIST

Page 1098.44

Nov 01/2008

COMPONENT MAINTENANCE MANUAL



Forward Galley Door Assembly  
IPL Figure 3 (Sheet 5 of 6)

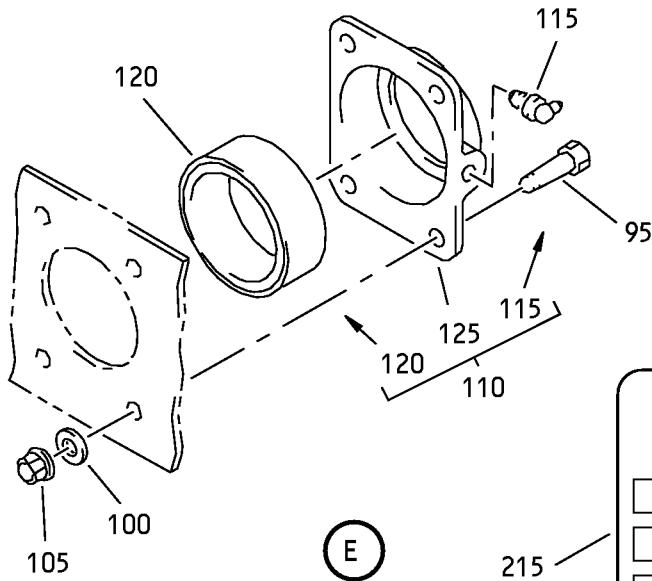
**52-41-05**

ILLUSTRATED PARTS LIST

Page 1098.45

Nov 01/2008

COMPONENT MAINTENANCE MANUAL



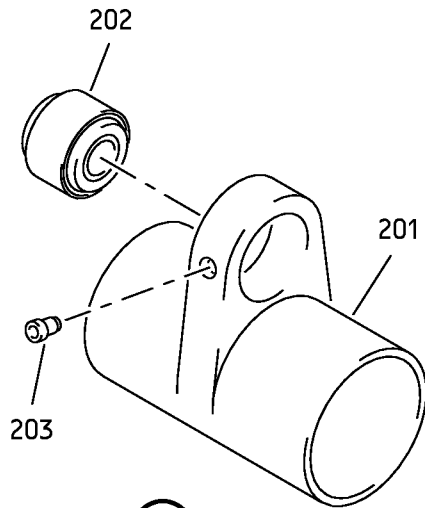
DOOR CYCLE LOG		
AIRPLANE SERIAL NO.	AIRPLANE FLIGHT CYCLES AT INSTL	AIRPLANE FLIGHT CYCLES AT REMOVAL

F

220

AIRCRAFT MOD.	_____		
MFR. CODE	_____		
PART NO.	_____		
CONT. NO.	_____		
SERIAL NO.	_____		
CONT.	<input type="checkbox"/>	CONT.	<input type="checkbox"/>
INSP.	<input type="checkbox"/>	INSP.	<input type="checkbox"/>
MODIFICATION INCORPORATED			
_____			

G



H

G77039 S00041002316\_V2

Forward Galley Door Assembly  
IPL Figure 3 (Sheet 6 of 6)

**52-41-05**

ILLUSTRATED PARTS LIST

Page 1098.46

Nov 01/2008





## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
3-											
-1A	141A6516-2										
-1B	141A6516-3										
-1C	141A6516-5										
-1D	141A6516-6										
-1E	141A6516-7								E	RF	
-1F	141A6516-2								A	RF	
-1G	141A6516-3								B	RF	
-1H	141A6516-4								C	RF	
-1J	141A6516-8								D	RF	
-1K	141A6516-9								F	RF	
-1L	141A6516-10								G	RF	
-1M	141A6516-11								H	RF	
-1N	141A6516-12								J	RF	
-1P	141A6516-13								K	RF	
-1Q	141A6516-14								L	RF	

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# 52-41-05

ILLUSTRATED PARTS LIST

Page 1098.47

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
3-											
-1R	141A6516-15									M	RF
-1S	141A6516-16									N	RF
-1T	141A6516-17									P	RF
-1U	141A6516-18									Q	RF
-1V	141A6516-19									R	RF
-1W	141A6516-20									S	RF
-1X	141A6516-21									T	RF
5	66-15332-1									A-K	AR
-5A	66-15332-1									L-T	AR
-5B	149A6101-1									L-T	AR
10	ASSB16-19										4
15	BACB30VF3K4										14
20	BACB30VF08K4										2
25	NAS1149D0332J										14

-Item not Illustrated

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1098.48

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
3-											
30	NAS1149DN832J		.								2
35	H52732-3CD		.								14
40	H52732-08CD		.								2
45	141A6546-1		.								1
50	141A6546-2		.						A-P		1
-50A	141A6546-10		.						Q-T		1
55	141A6546-3		.								1
60	141A6546-4		.						A-P		1
-60A	141A6546-12		.						Q-T		1
65	NAS516-1A		.	.							1
70	141A6546-5		.	.							1
75	141A6546-6		.	.					A-P		1
75A	141A6546-11		.	.					Q-T		1
80	141A6546-7		.	.							1
85	141A6546-8		.	.					A-P		1
-85A	141A6546-13		.	.					Q-T		1
90	141A6120-3										
90A	147A6120-3		.								AR
95	BACB30NM3K3		.								16
100	NAS1149D0332J		.								16
105	H52732-3CD		.								16

-Item not Illustrated

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1098.49

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
3-											
110	65-2306-9		. HOUSING ASSY								4
115	MS15001-4		. . FITTING								1
120	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
125	65-2306-10		. . HOUSING								1
130	141A6545-2		. TUBE ASSY-UPR								1
135	141A6545-1		. TUBE ASSY-LWR								1
137	BACP18BC02A06P		. . PIN-COTTER								2
140	BACN10JD105CD		. . NUT								2
145	NAS1149D0516J		. . WASHER								16
150	HRSC3CFR9		. . BEARING (V60380) (SPEC BACB10FK5F9HS) (OPT CHRS3CFR9 (V92563)) (OPT CHRS3CFR9 (V07484))								2
155	BACB30NM3K17		. . BOLT								4
160	NAS1149C0332R		. . WASHER								4
165	H52732-3CM		. . NUT (V15653) (SPEC BACN10YR3CM) (OPT PLH53CM (V62554))								4
170	69-37418-11		. . CRANK-ROLLER CAM								2
175	BACB30NM3K19		. . BOLT								4
180	NAS1149C0332R		. . WASHER								4
185	H52732-3CM		. . NUT (V15653) (SPEC BACN10YR3CM) (OPT PLH53CM (V62554))								4
190	66-14531-14		. . CRANK-LATCH (USED ON ITEM 130)								1

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# 52-41-05

ILLUSTRATED PARTS LIST

Page 1098.50

Nov 01/2008

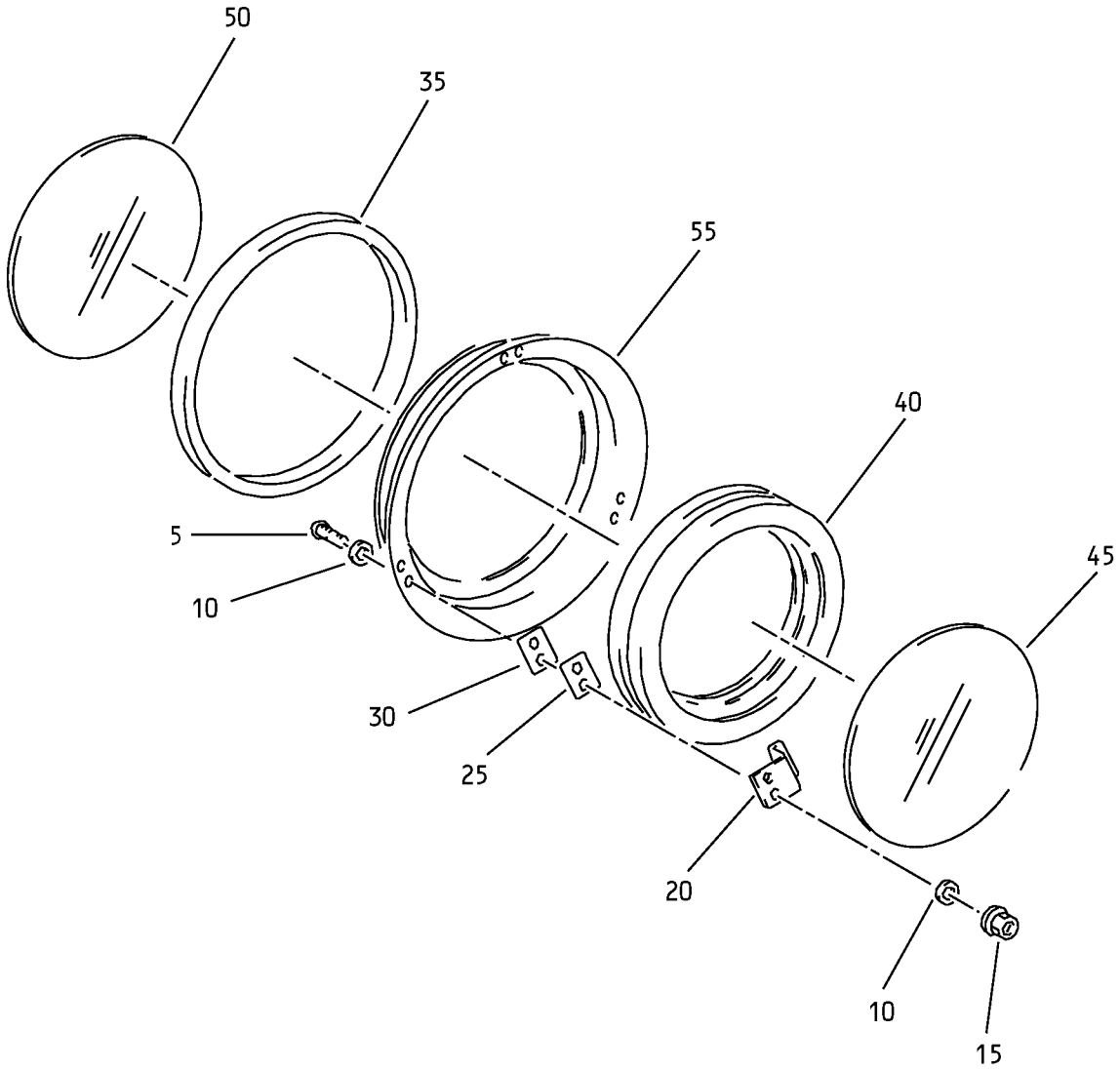


## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE	USAGE CODE	UNITS PER ASSY
3-					
195	66-14531-12		. . CRANK-LATCH (USED ON ITEM 135)		1
200	60-4431-5		. . CRANK ASSY-GATE (USED ON ITEM 130)		1
201	60-4431-4		. . . CRANK		1
202	ABW4V5		. . . BEARING (VS0352) (SPEC BACB10AB4) (OPT ABW4V5 (V50294)) (OPT BSSR4804 (V81376)) (OPT KWB4-20CRG (V97613)) (OPT WG4E (V73134)) (OPT 55282 (V09455)) (OPT WC4G1 (V56644)) (OPT AW4VCRG (V15860)) (OPT HU4-134 (V02758)) (OPT BWG4-110 (V16476))		1
203	NAS516-1A		. . . FITTING		1
205	60-4409-2		. . CRANK-GATE (USED ON ITEM 135)		1
210	60-4406-15		. . TUBE-LATCH TORQUE		1
215	BAC27DBY191		. MARKER-ALUMINUM FOIL		1
220	MS27253F1		. PLATE		1

-Item not Illustrated

# COMPONENT MAINTENANCE MANUAL



Observation Window Assembly  
IPL Figure 4

**52-41-05**  
ILLUSTRATED PARTS LIST  
Page 1098.52  
Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
4-											
-1A	65-2863-8									A-R	RF
-1B	141A6570-1									S, T	RF
5	NAS8200A8									A-R	6
7	BACS12HJ04K8									S, T	12
-7A	NAS8200A8									S, T	12
10	NAS1149DN432J										12
12	NAS1149DN432J									S, T	24
15	H52732-04CD										6
17	PLH504CD									S, T	12
20	63-1478-1									A-R	3
22	141A6573-1									S, T	6
25	BACS40R007B007F										AR
30	BACS40R007C007F										AR
35	66-2646									A-R	1
-35A	141A6575-1									S, T	1
40	66-1921-2									A-R	1
-40A	141A6574-1									S, T	1
45	69-1083-2									A-R	1
-45A	141A6571-2									S, T	1
50	69-1084-2									A-R	1
-50A	141A6571-1									S, T	1
55	69-1983-7									A-R	1
55A	141A6572-1									S, T	1

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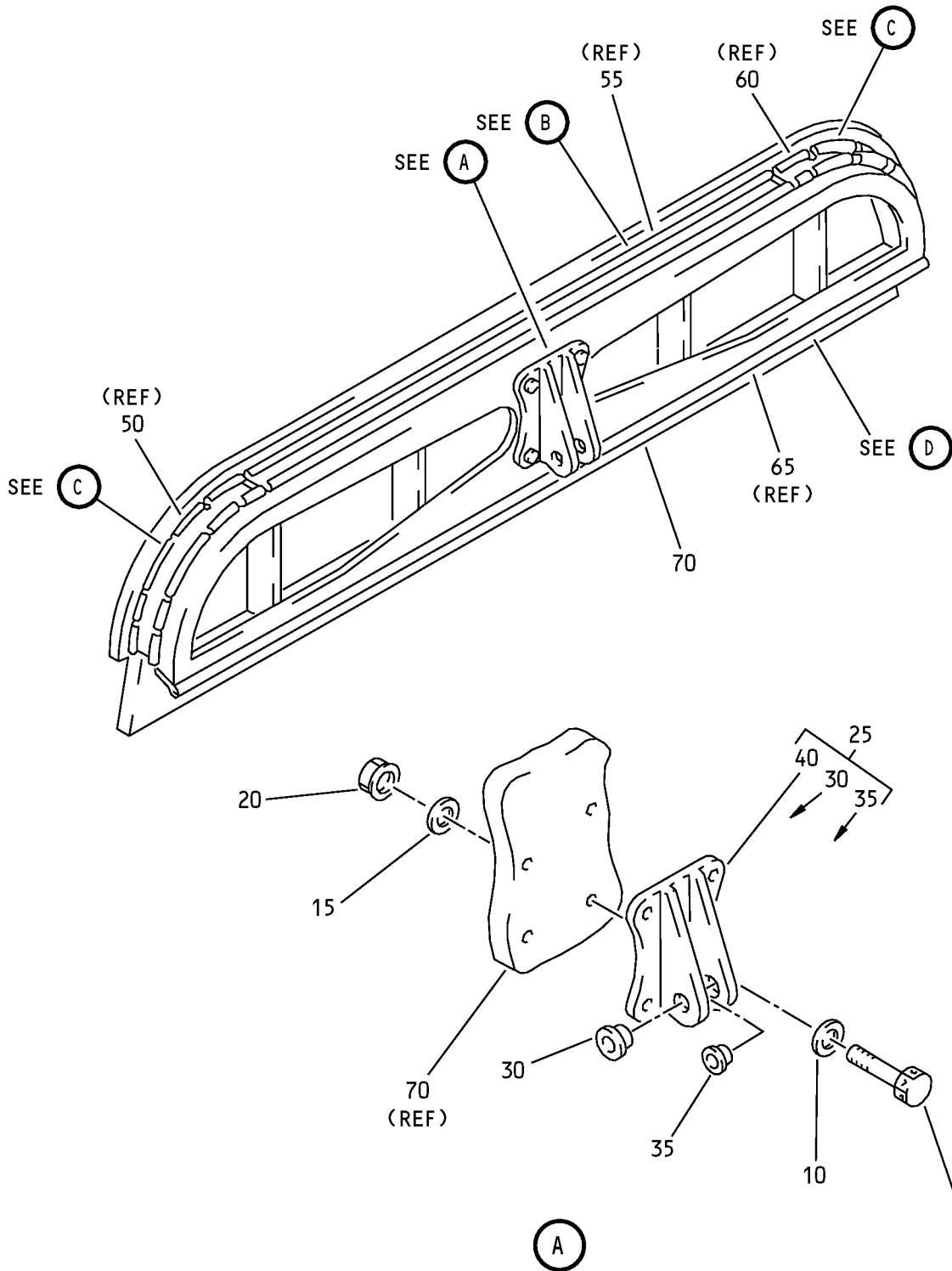
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ILLUSTRATED PARTS LIST

Page 1098.53

Nov 01/2008

COMPONENT MAINTENANCE MANUAL

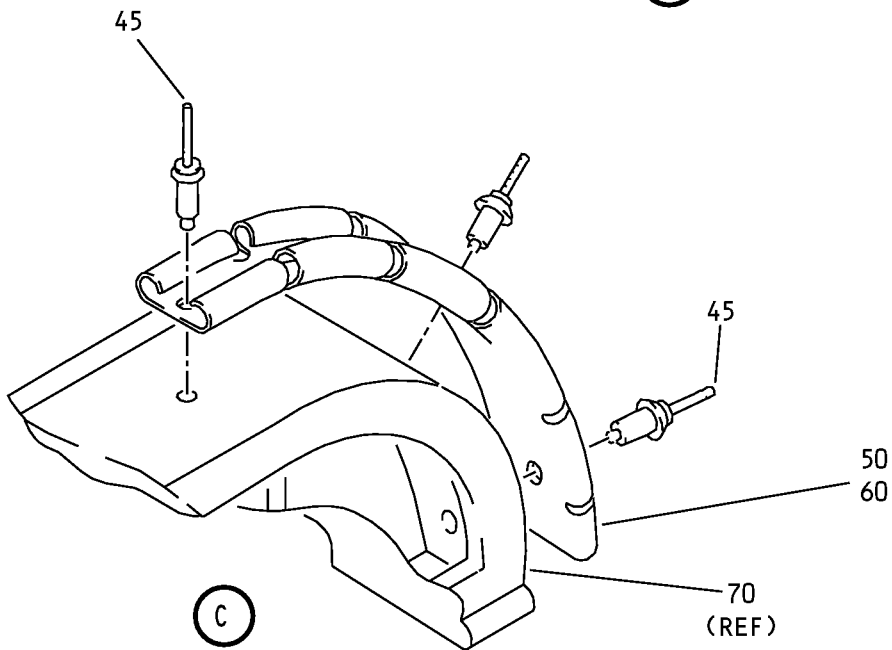
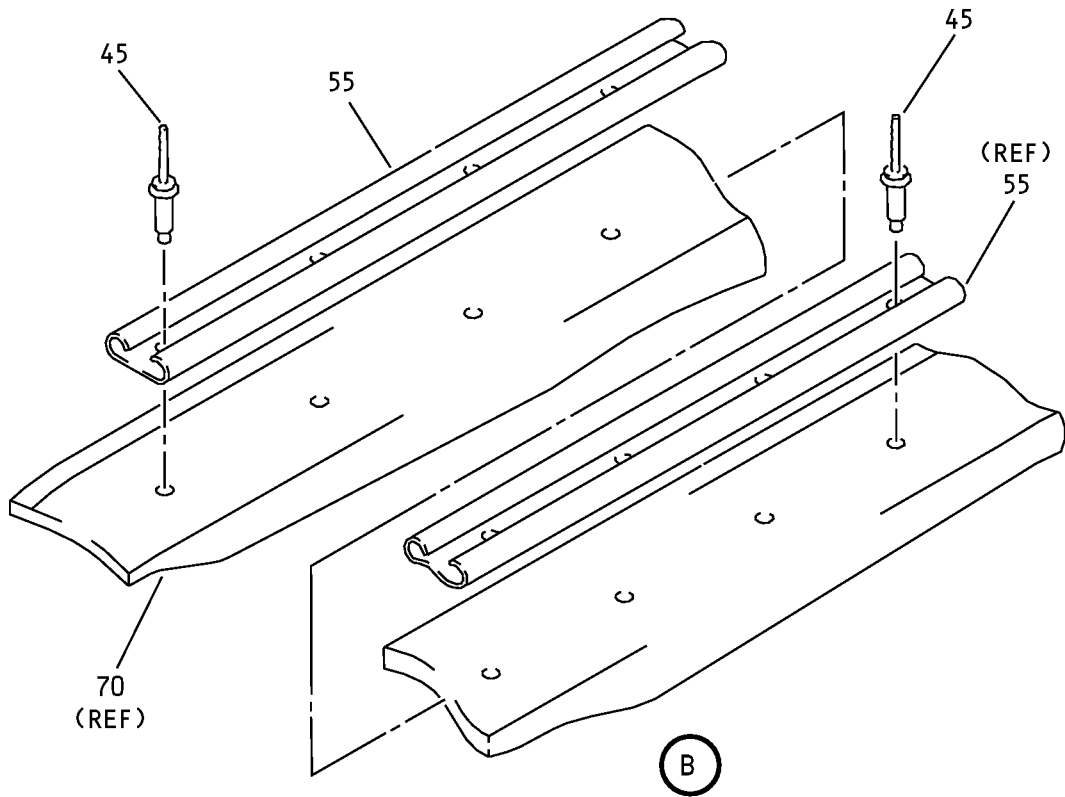


End Gate Assembly  
IPL Figure 5 (Sheet 1 of 3)

**52-41-05**  
ILLUSTRATED PARTS LIST  
Page 1098.54  
Nov 01/2008

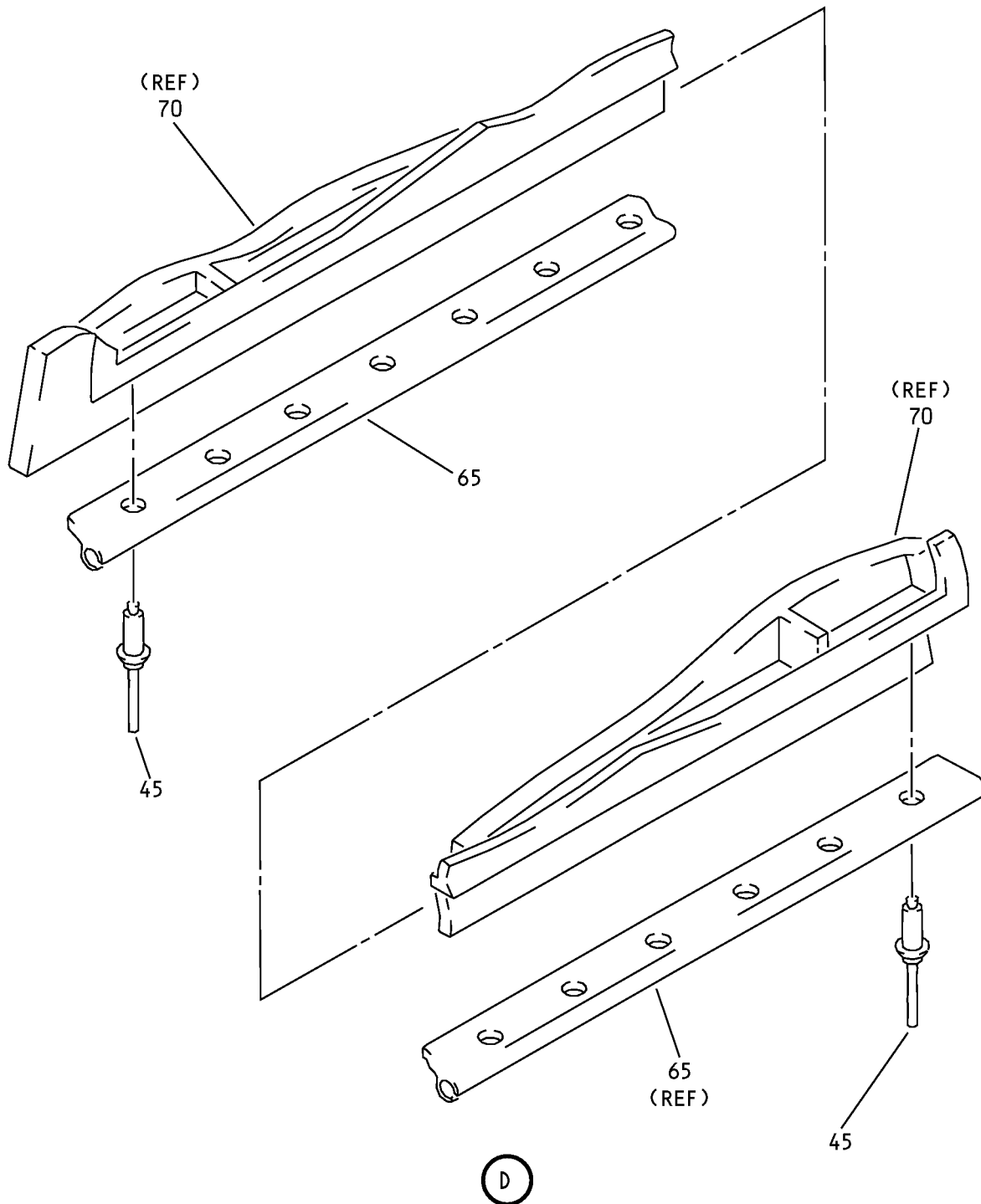


COMPONENT MAINTENANCE MANUAL



End Gate Assembly  
IPL Figure 5 (Sheet 2 of 3)

COMPONENT MAINTENANCE MANUAL



End Gate Assembly  
IPL Figure 5 (Sheet 3 of 3)



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
5-											
-1A	141A6540-2									A-K	RF
-1B	141A6540-4									L-T	RF
5	BACB30NM3K8										4
10	BACW10BN3AC										4
15	NAS1149D0363J										4
20	H52732-3CD										4
25	141A6541-2										1
30	BACB28X6M014										1
35	BACB28X4M014										1
40	141A6541-4										1
45	AF3253-4-4B										27
50	141A6534-4										1
55	141A6534-5										1
60	141A6534-6										1
65	141A6534-14										1
70	141A6543-1									A-K	1
-70A	141A6543-3									L-T	1

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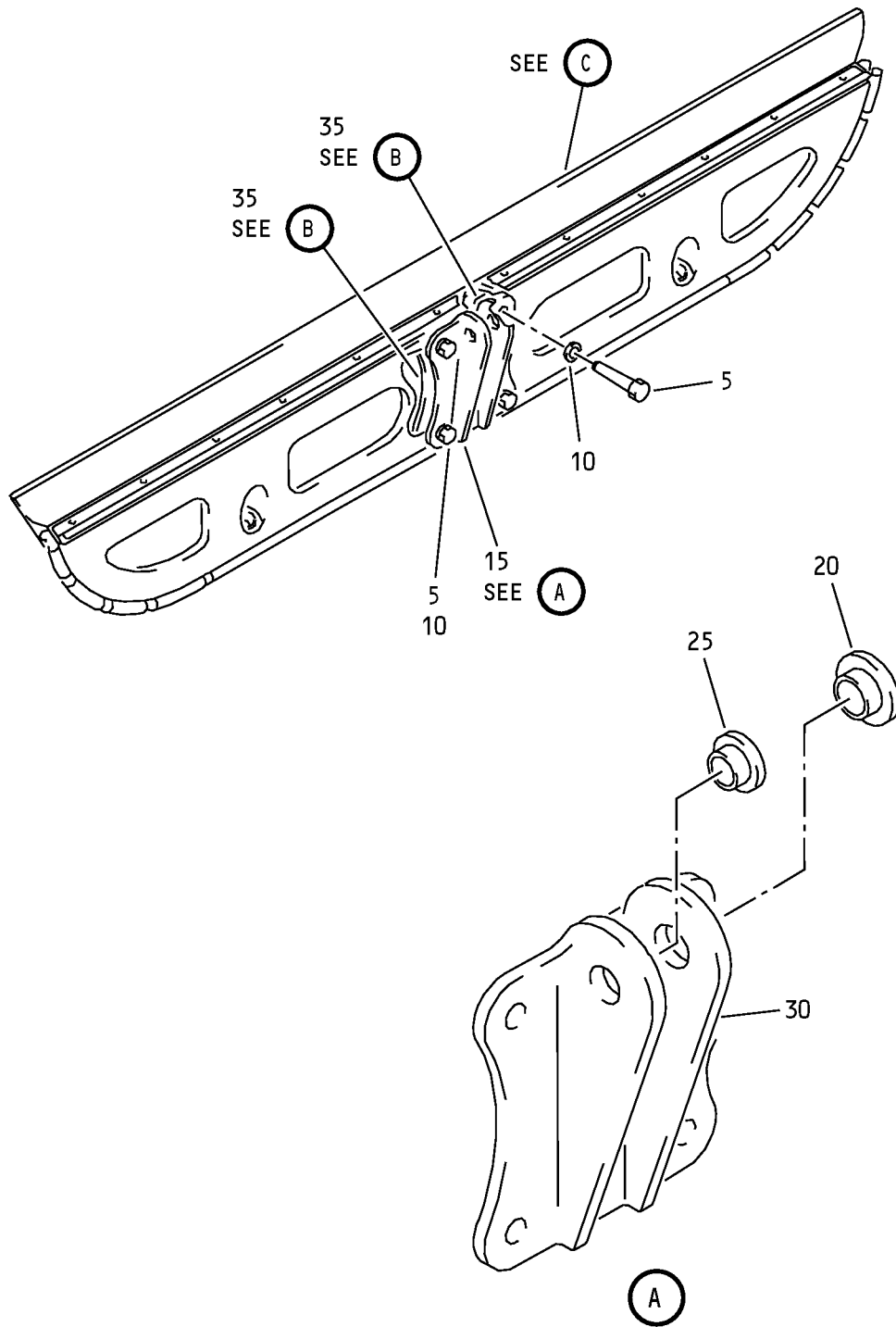
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ILLUSTRATED PARTS LIST

Page 1098.57

Nov 01/2008

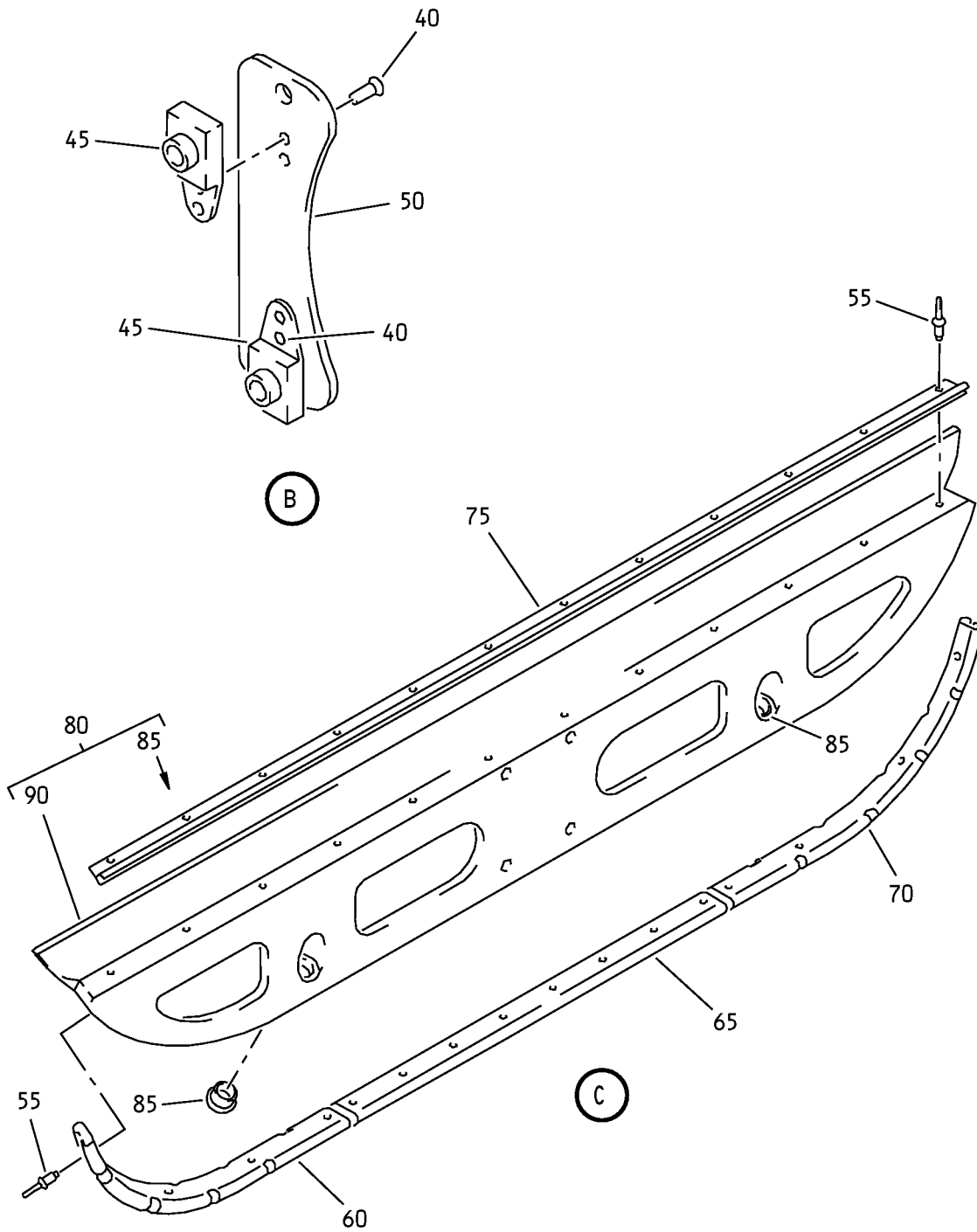
COMPONENT MAINTENANCE MANUAL



End Gate Assembly  
IPL Figure 6 (Sheet 1 of 2)

**52-41-05**  
ILLUSTRATED PARTS LIST  
Page 1098.58  
Nov 01/2008

COMPONENT MAINTENANCE MANUAL



End Gate Assembly  
IPL Figure 6 (Sheet 2 of 2)

**52-41-05**  
ILLUSTRATED PARTS LIST  
Page 1098.59  
Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
6-											
-1A	141A6540-1									A-K	RF
-1B	141A6540-3									L-T	RF
5	BACB30NM3K8										4
10	BACW10BN3AC										4
15	141A6541-1										1
20	BACB28X6M014										1
25	BACB28X4M014										1
30	141A6541-3										1
35	149A6113-1										2
40	BACR15BA3AD										4
45	F51636-3										2
50	149A6113-3										1
55	AF3253-4-4B										28
60	141A6534-12										1
65	141A6534-11										1
70	141A6534-10										1
75	141A6534-13										1
80	141A6542-1									A-K	1
-80A	141A6542-4									L-T	1
85	66-12688-11										2
90	141A6542-2									A-K	1
-90A	141A6542-5									L-T	1

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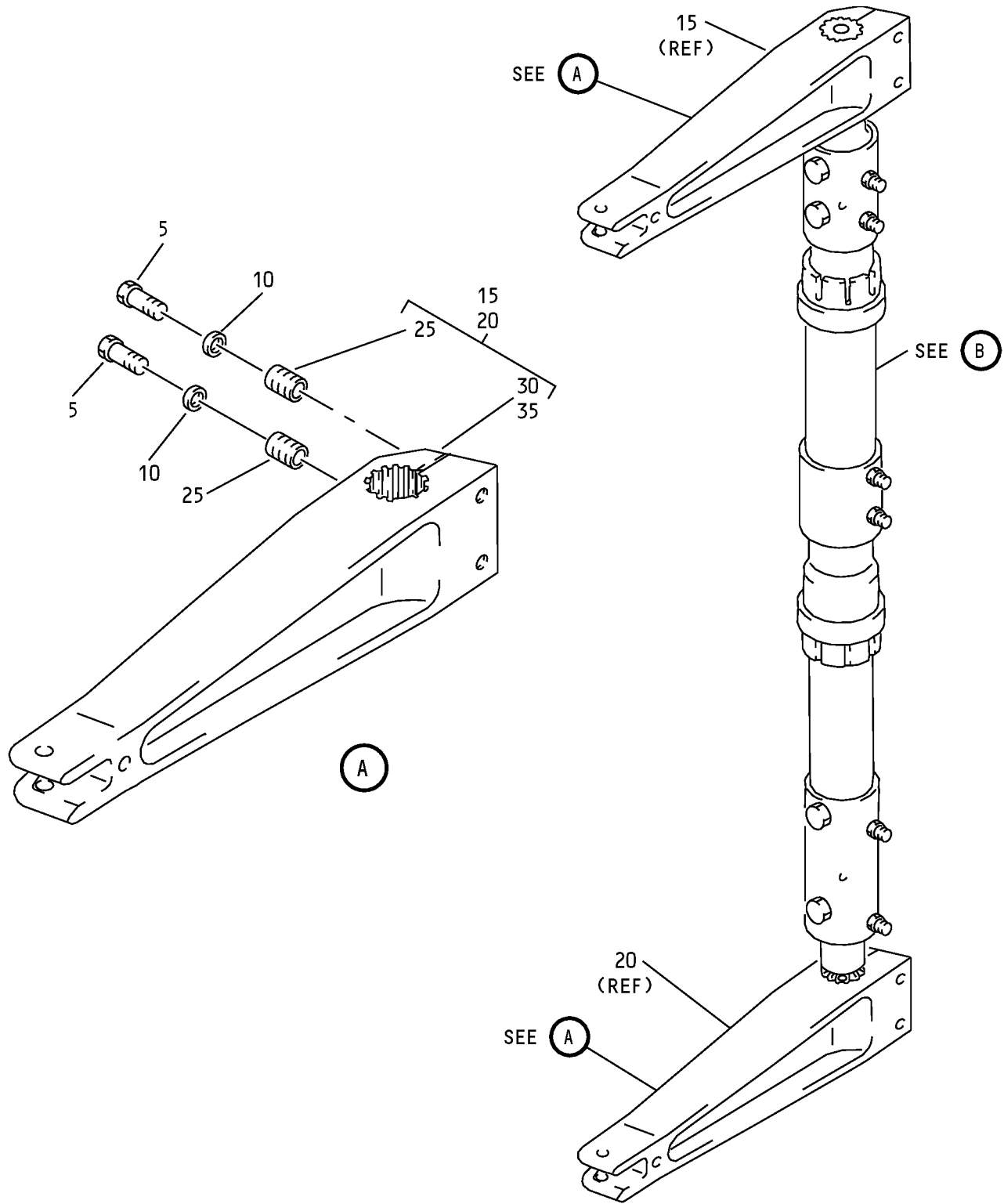
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ILLUSTRATED PARTS LIST

Page 1098.60

Nov 01/2008

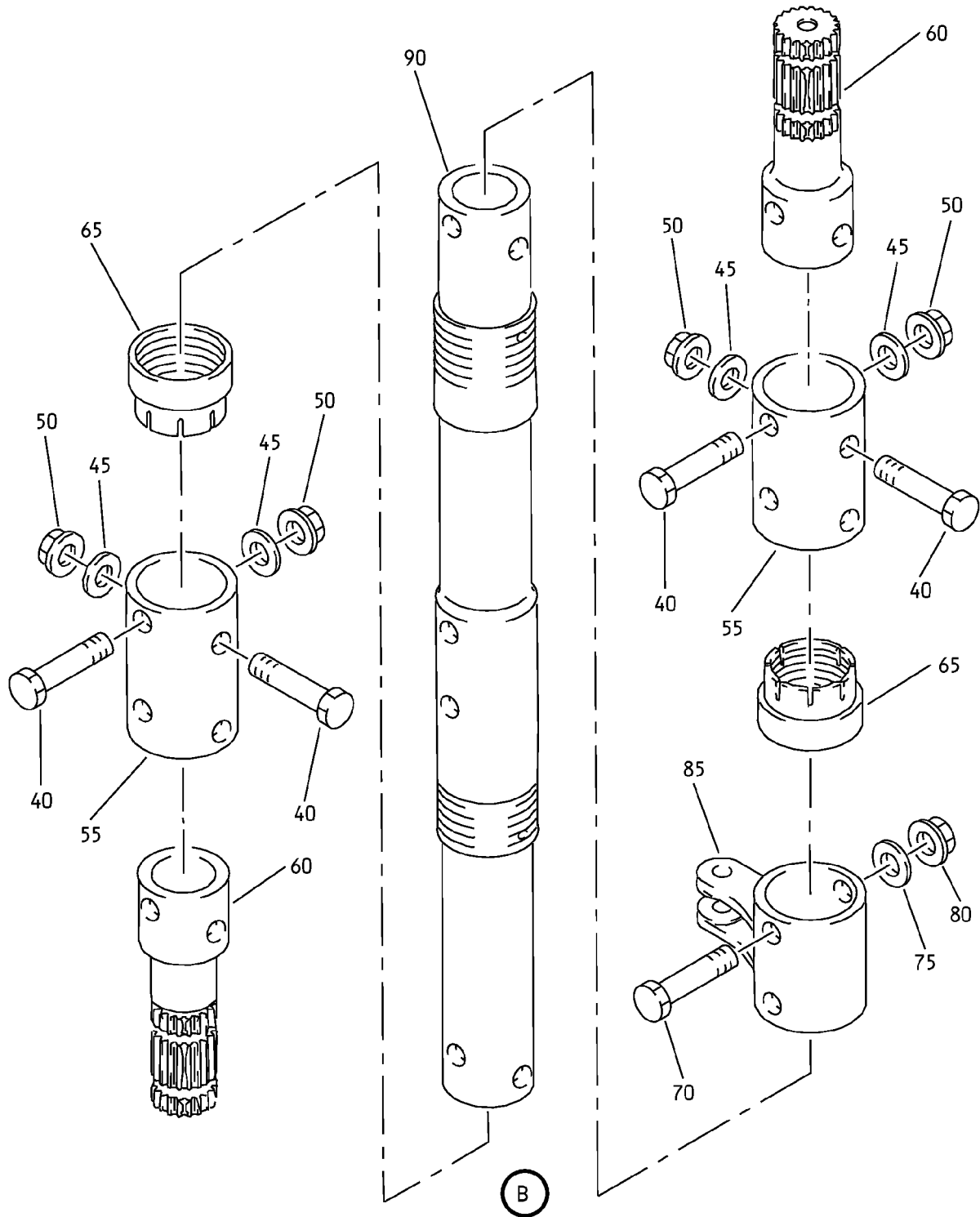
COMPONENT MAINTENANCE MANUAL



Torque Tube Assembly  
IPL Figure 7 (Sheet 1 of 2)

**52-41-05**  
ILLUSTRATED PARTS LIST  
Page 1098.61  
Nov 01/2008

COMPONENT MAINTENANCE MANUAL



Torque Tube Assembly  
IPL Figure 7 (Sheet 2 of 2)

**52-41-05**

ILLUSTRATED PARTS LIST

Page 1098.62

Nov 01/2008





## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
7-											
-1A	141A6517-1									A, B	RF
-1B	141A6517-2									C-T	RF
5	BACB30NM3K11										4
10	BACW10BP3CD										4
15	65-73978-7										1
20	65-73978-2										1
-25	BACS13W3CN3										
25A	NASM21209F1-15										4
30	65-73978-9										1
-30A	65-73978-11										1
35	65-73978-4										1
-35A	65-73978-14										1
40	BACB30PU4-25										8
45	BACW10BP3APU										8
50	H52732-3CM										8
55	149A6110-1										2
60	66-14527-8										2
65	60-4405-1										2
70	BACB30PU5-28										2
75	BACW10BP4APU										2

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# 52-41-05

ILLUSTRATED PARTS LIST

Page 1098.63

Nov 01/2008



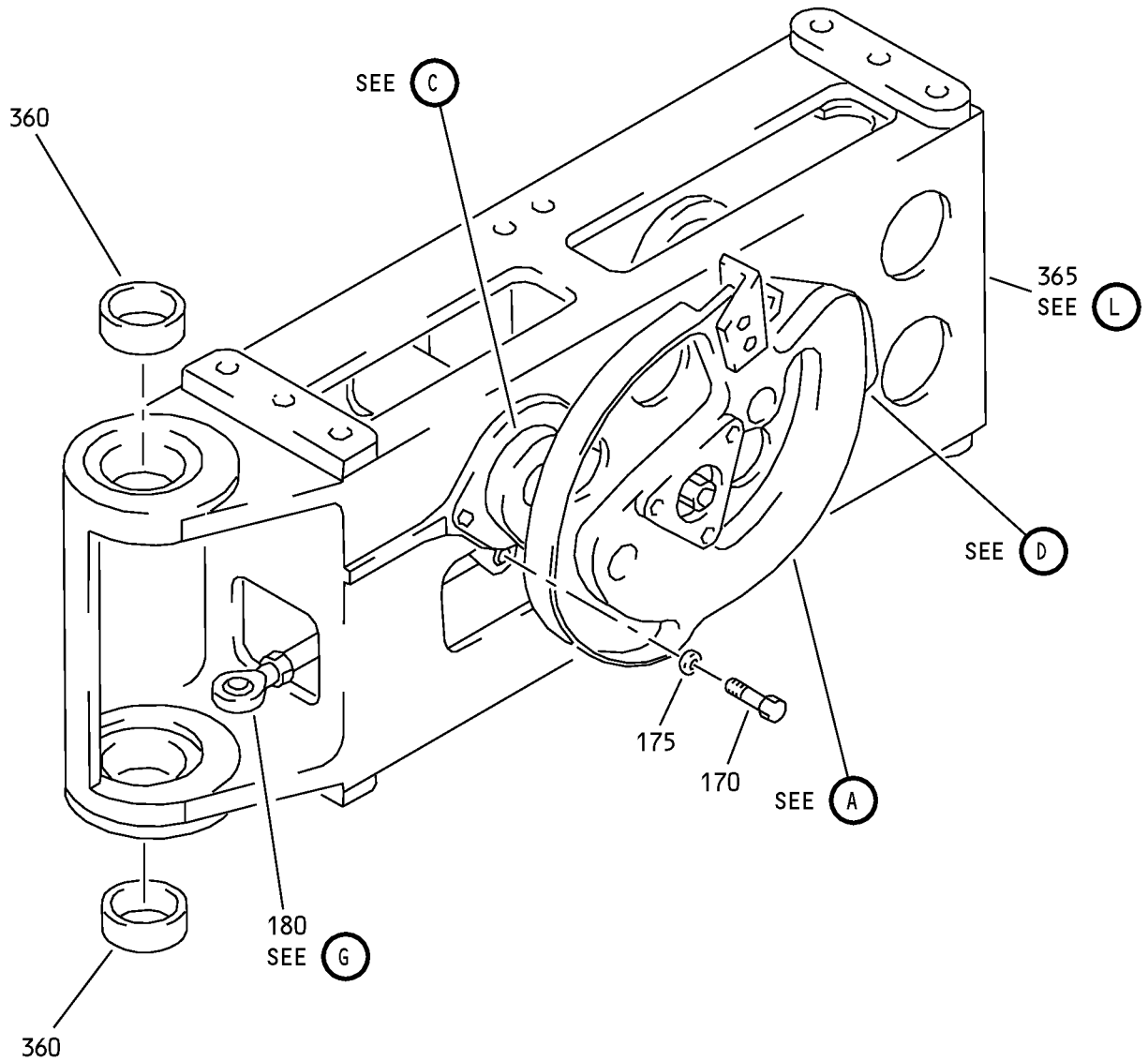
## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
7- 80	H52732-4CM		.	NUT (V15653) (SPEC BACN10YR4CM) (OPT PLH54CM (V62554))							2
85	69-17330-3		.	CRANK						A, B	1
-85A	69-17330-5		.	CRANK						C-T	1
90	141A6519-1		.	TUBE							1

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**52-41-05**  
 ILLUSTRATED PARTS LIST  
 Page 1098.64  
 Nov 01/2008

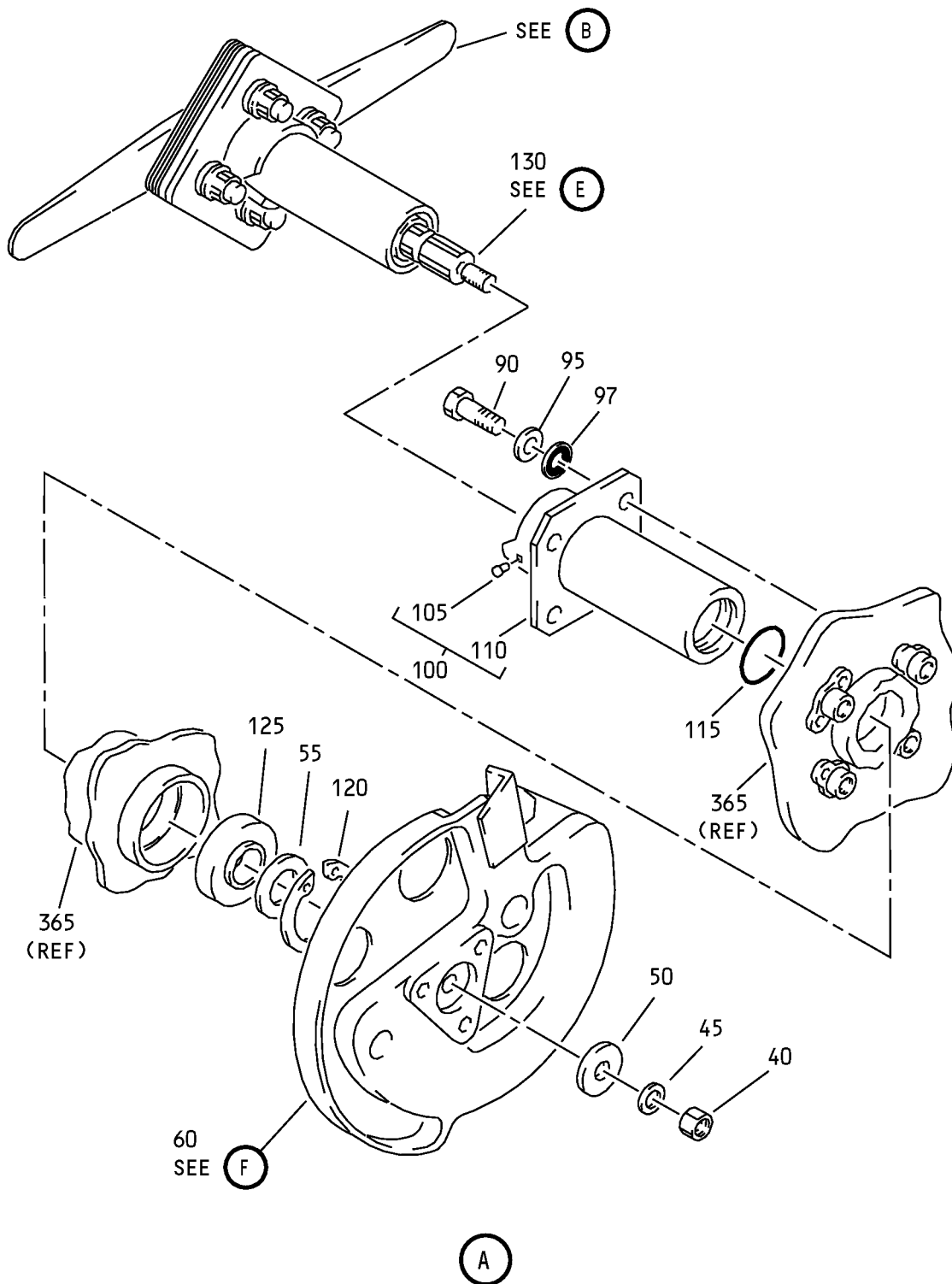
COMPONENT MAINTENANCE MANUAL



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

**52-41-05**  
ILLUSTRATED PARTS LIST  
Page 1098.65  
Nov 01/2008

COMPONENT MAINTENANCE MANUAL



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

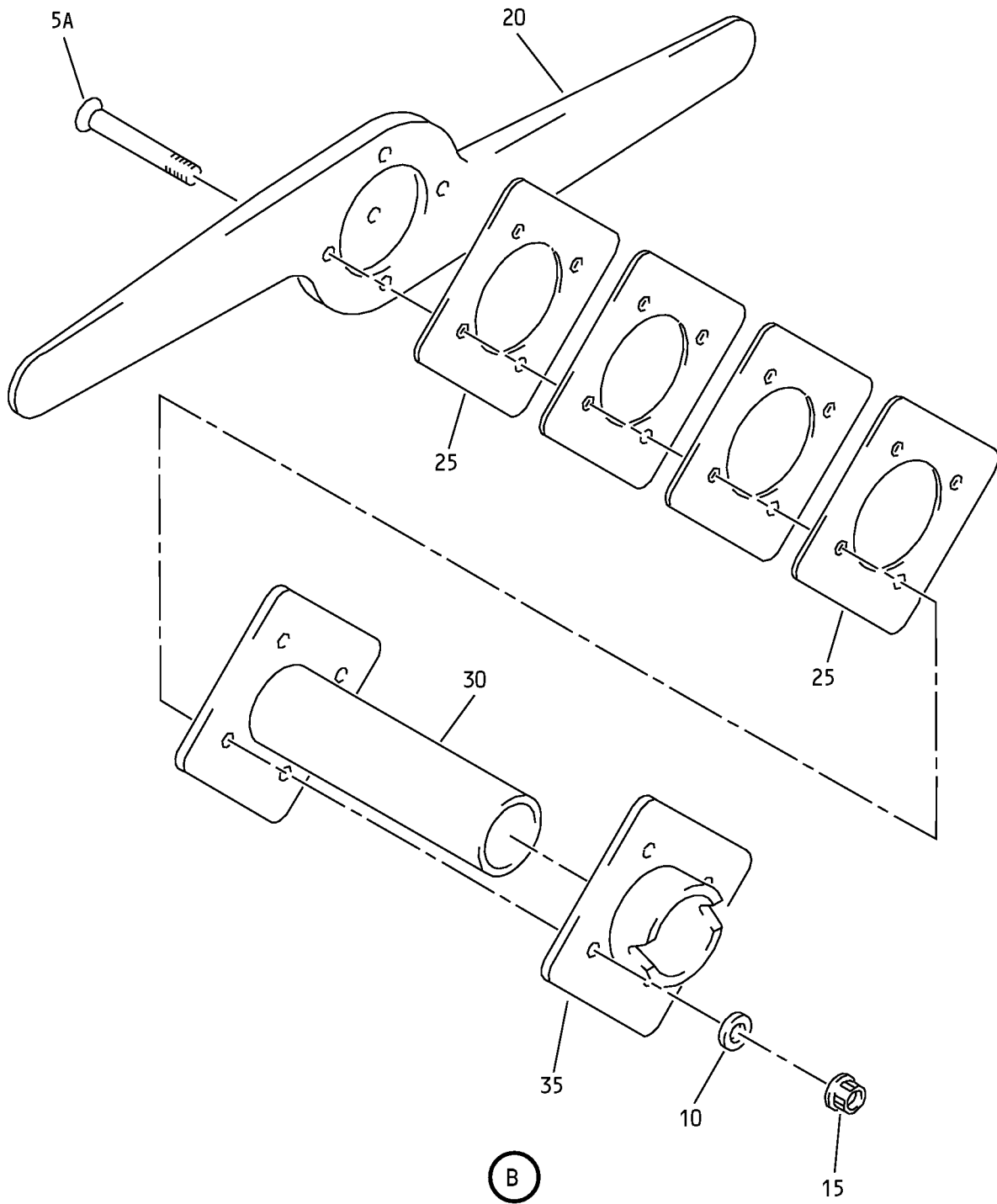
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ILLUSTRATED PARTS LIST

Page 1098.66

Nov 01/2008

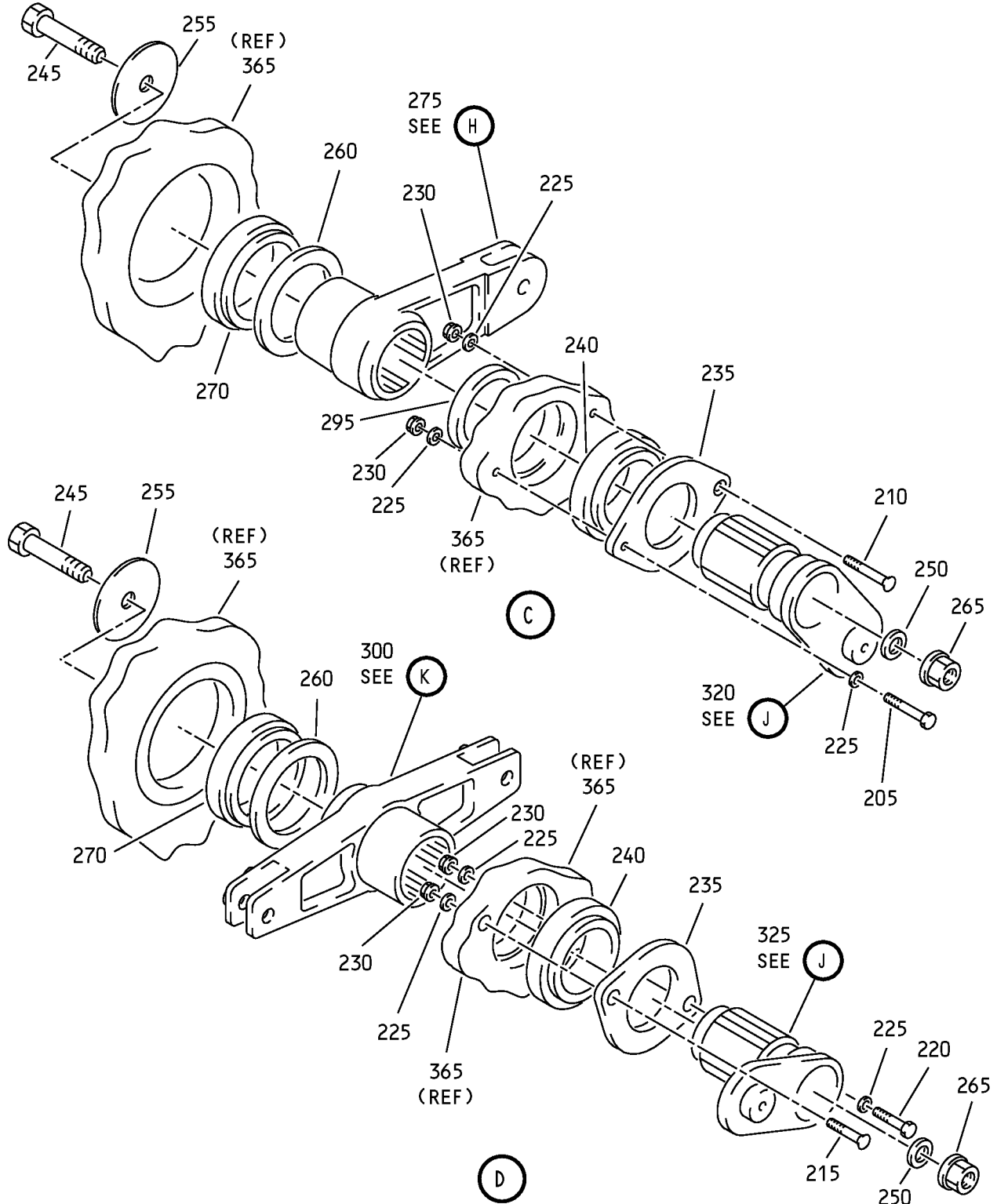
COMPONENT MAINTENANCE MANUAL



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

**52-41-05**  
ILLUSTRATED PARTS LIST  
Page 1098.67  
Nov 01/2008

COMPONENT MAINTENANCE MANUAL



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

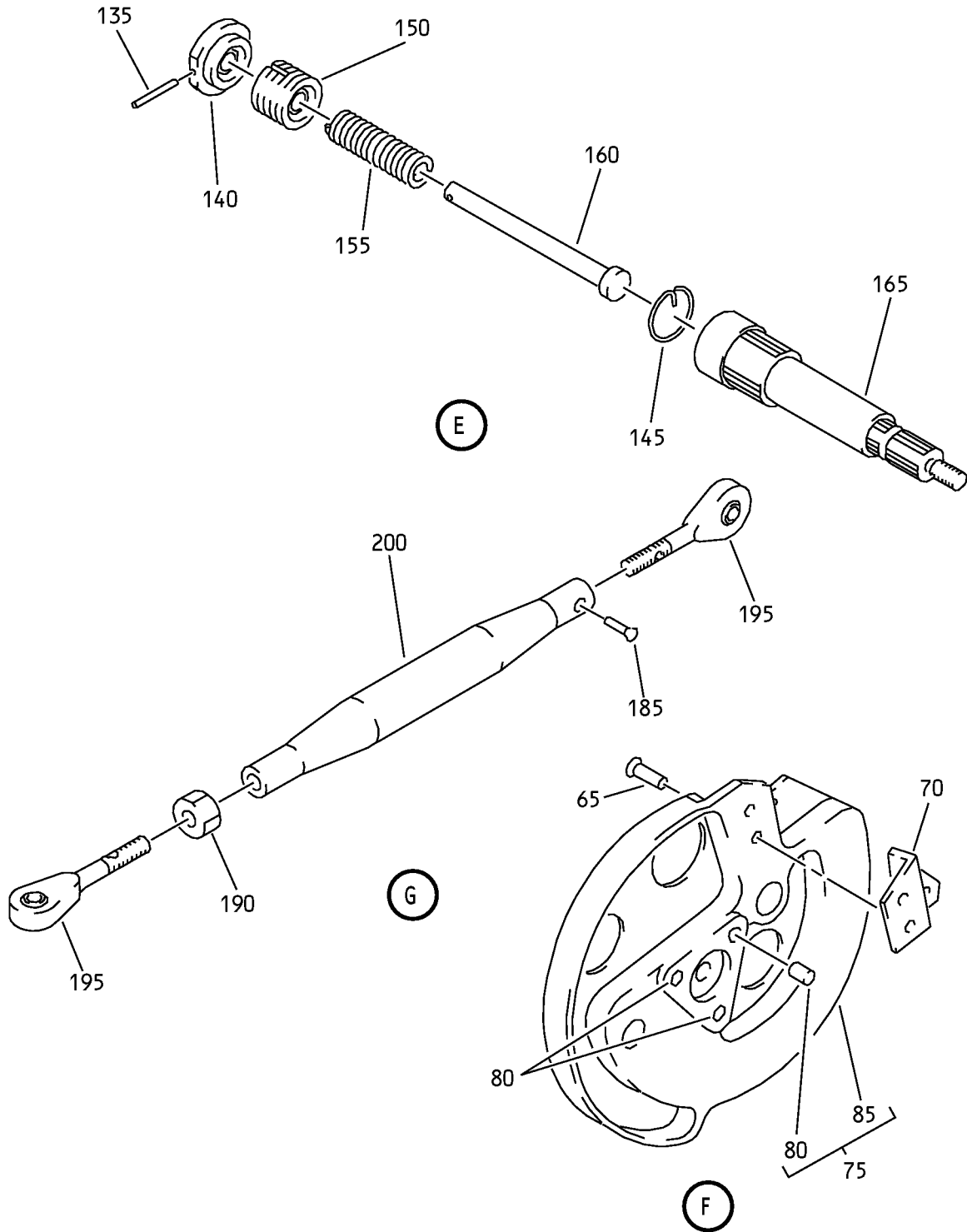
**52-41-05**

ILLUSTRATED PARTS LIST

Page 1098.68

Nov 01/2008

COMPONENT MAINTENANCE MANUAL



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

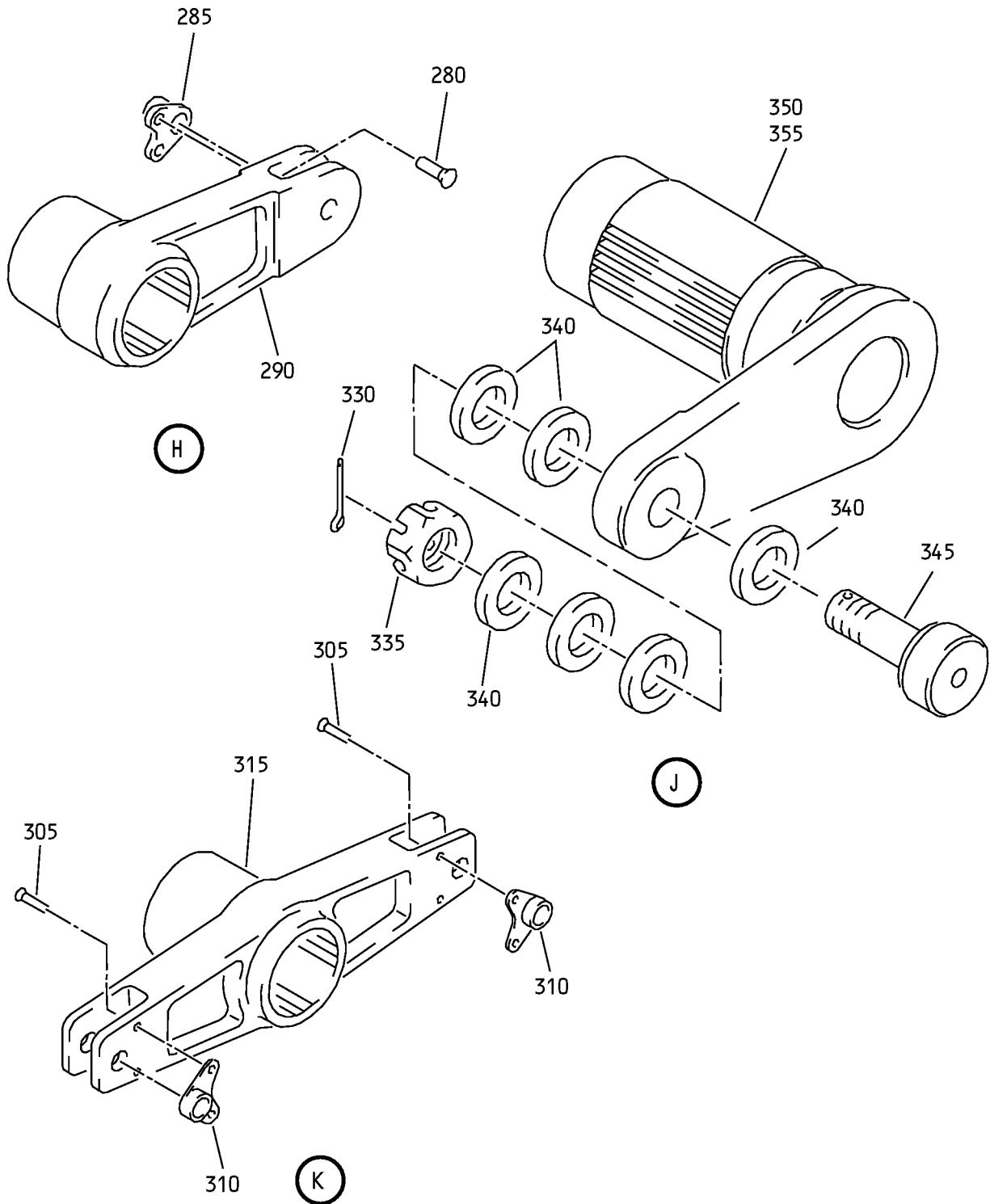
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ILLUSTRATED PARTS LIST

Page 1098.69

Nov 01/2008

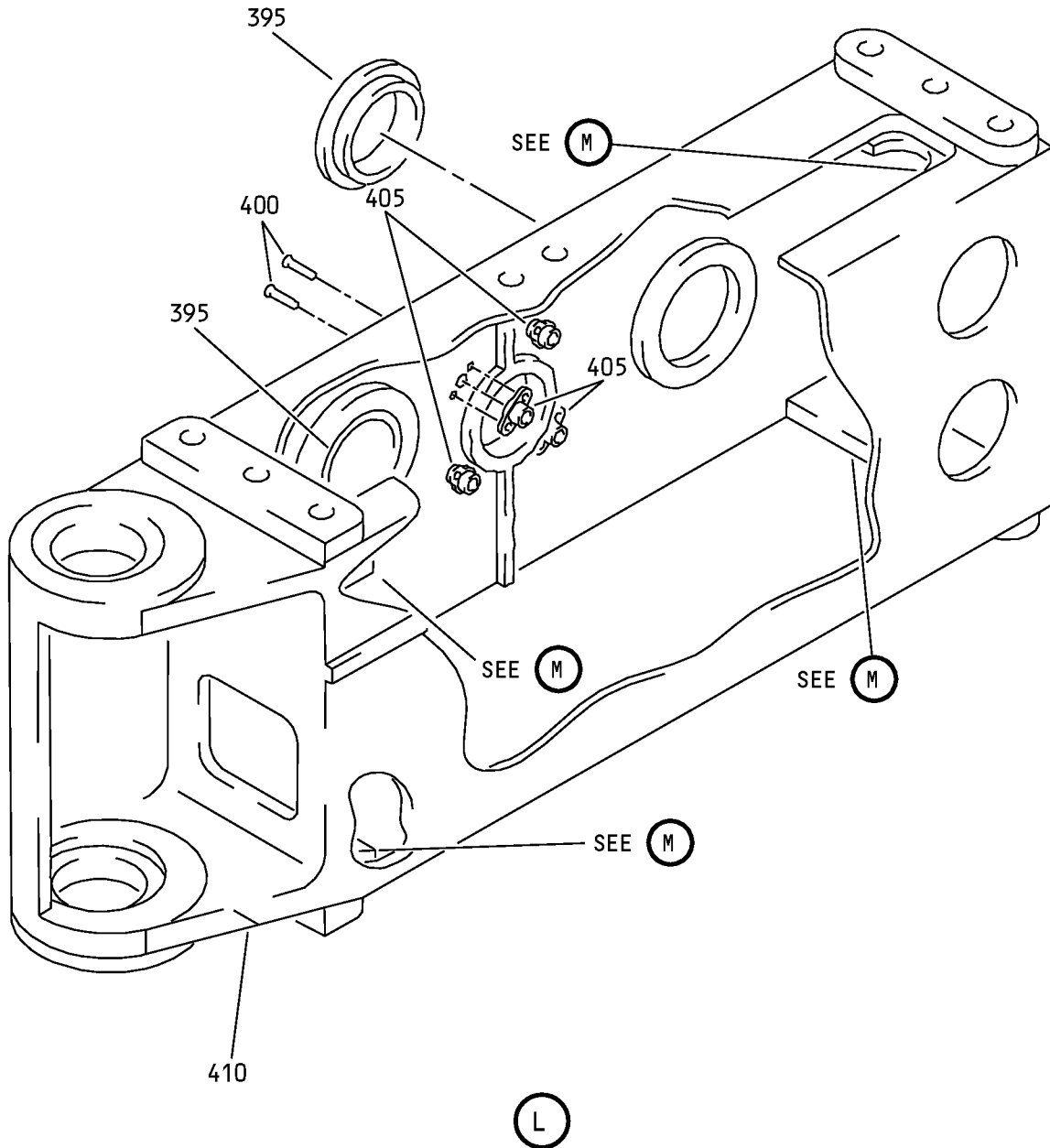
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Handle Box Assembly  
IPL Figure 8 (Sheet 6 of 8)



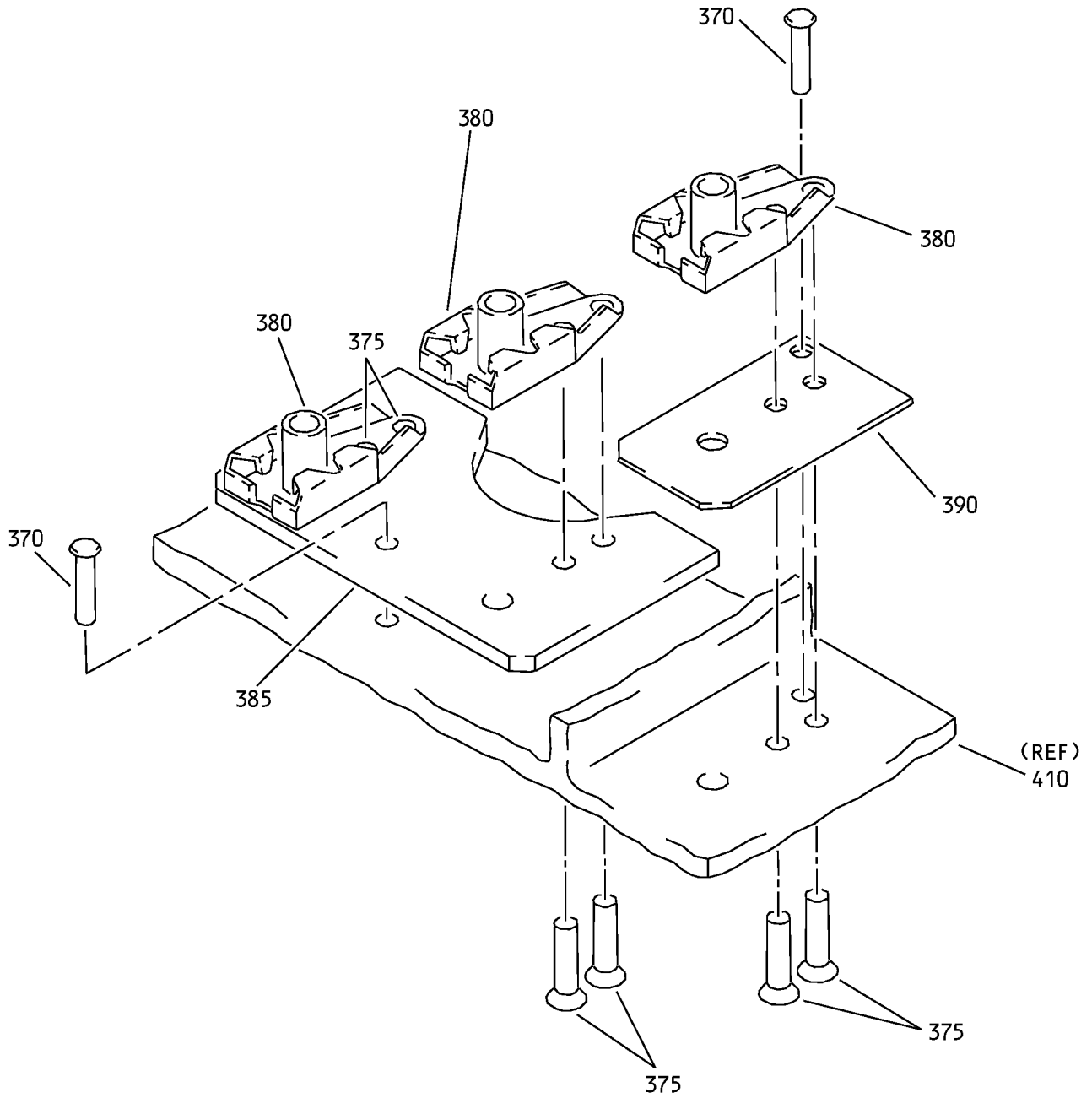
COMPONENT MAINTENANCE MANUAL



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

**52-41-05**  
ILLUSTRATED PARTS LIST  
Page 1098.71  
Nov 01/2008

COMPONENT MAINTENANCE MANUAL



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

**52-41-05**

ILLUSTRATED PARTS LIST

Page 1098.72

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
8-											
-1A	141A6521-2										RF
5	BACB30NN3K7										
5A	BACB30NN3K11										4
10	NAS1149D0363J										4
15	H52732-3CD										4
20	90-7879-10										1
25	30-3035										11
30	90-7821-1										1
35	90-7811										1
40	BACN10JD6CD										1
45	NAS1149D0632J										AR
50	63-9386-1										1
55	BACW10P148AL										1
60	69-34971-11										1
65	MS20426D5										3
70	69-34971-2										1
75	65-44065-11										1
80	MS21209F5-15P										3
85	65-44065-12										1
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90	BACB30NM3K13										4
95	BACW10BN3AC										4
97	NAS1523C3R										4
100	149A6120-1										1
105	NAS516-1A										1
110	149A6120-2										1
115	M83461-1-212										1

-Item not Illustrated

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1098.73

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
8-											
120	MS16625-4162		.								1
125	PACMKP12AFS428		.								1
130	149A6109-1		.								1
135	MS39086-111		.	.							1
140	30-3019-1		.	.							1
145	AN996-14		.	.							1
150	30-3010		.	.							1
155	63-2848		.	.							1
160	30-3013-2		.	.							1
165	60-4455-3		.	.							1
170	BACB30NR5K17		.								1
175	NAS1149D0563J		.								1
180	69-39176-1		.								1
185	MS20615-5M10		.	.							1
190	AN316-6R		.	.							1
195	ARHT5E102		.	.							2
200	69-39176-2		.	.							1
205	BACB30NM3K11		.								1
210	BACB30VF3K11		.								1
215	BACB30VF3K7		.								1

-Item not Illustrated

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1098.74

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
8-											
220	BACB30NM3K7		.								1
225	NAS1149D0332J		.								6
230	H52732-3CD		.								4
235	69B10068-3		.								2
240	PACMKP23BSF~ S428		.								2
245	BACB30NR4K6		.								2
250	NAS1149D0432J		.								2
255	63-1692-1		.								2
260	NAS1149D2190J		.								2
265	H52732-4CD		.								2
270	PACMKP21BSF~ S428		.								2
275	65-1933-23		.								1
280	BACR15BA4D		..								2
285	BACN10JP5CCD		..								1
-285A	MK3000-5BAC		..								1

-Item not Illustrated

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1098.75

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
8-											
290	65-1933-24		.	.							1
295	65-8795-501		.								1
300	65-54013-503		.								1
305	MS20470D3-4		.	.							4
310	BR3000A4		.	.							2
315	65-54013-502		.	.							1
320	90-7815-25		.								1
325	90-7815-26		.								1
330	MS24665-283		.	.							1
335	BACN10JD106ASU		.	.							1
340	NAS1149C0632B		.	.							AR
345	KRP141500VT6-6		.	.							1
350	90-7815-29		.	.							1
355	90-7815-30		.	.							1
360	ACMKP25P26LY198		.								2
365	149A6107-1		.								1
370	BACR15GF5D		.	.							8
375	BACR15BA3AD		.	.							24

-Item not Illustrated

# 52-41-05

ILLUSTRATED PARTS LIST

Page 1098.76

Nov 01/2008



## COMPONENT MAINTENANCE MANUAL

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE							USAGE CODE	UNITS PER ASSY
			1	2	3	4	5	6	7		
8- 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	65C36793-1								. . BUSHING		2
400	BACR15BA3AD								. . RIVET (SIZE DETERMINED ON INST)		8
405	BACN10JP3ACD								. . NUTPLATE		4
410	149A6107-4								. . HOUSING		1

-Item not Illustrated