COMPONENT MAINTENANCE MANUAL WITH ILLUSTRATED PARTS LIST

EQUIPMENT ACCESS DOOR ASSEMBLY

PART NUMBER 141A6710–10, –11, –12, –13, –14, –15, –16, –9

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COMPONENT MAINTENANCE MANUAL

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To: All holders of EQUIPMENT ACCESS DOOR ASSEMBLY 52-48-13.

Attached is the current revision to this COMPONENT MAINTENANCE MANUAL

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1028	Mar 01/2008				
1029	Mar 01/2008				
1030	Mar 01/2008				
1031	Mar 01/2006				
1032	Mar 01/2006				
1033	Mar 01/2006				
1034	Mar 01/2006				
1035	Mar 01/2006				
1036	Mar 01/2006				
1037	Mar 01/2006				
1038	Mar 01/2006				
1039	Mar 01/2006				
1040	Mar 01/2006				
1041	Mar 01/2006				
1042	Mar 01/2006				
1043	Mar 01/2006				
1044	Mar 01/2006				
1045	Mar 01/2006				
1046	Mar 01/2006				
1047	Mar 01/2006				
1048	Mar 01/2006				

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TABLE OF CONTENTS

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COMPONENT MAINTENANCE MANUAL

TEMPORARY REVISION AND SERVICE BULLETIN RECORD

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVE	DATE OF INCORPORATION INTO MANUAL
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Revision		Filed		Revision		Filed	
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Temporary Revision		Inserted		Removed	
Number	Date	Date	Initials	Date	Initials

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INTRODUCTION

1. General

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

B. This manual is divided into different parts:

(1) Title Page

(2) Transmittal Letter

(3) Highlights

(4) List of Effective Pages

(5) Table of Contents

(6) Temporary Revision & Service Bulletin Record

(7) Record of Revisions

(8) Record of Temporary Revisions

(9) Introduction

(10) Procedures & IPL Sections

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

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

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

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

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

EQUIPMENT ACCESS DOOR ASSEMBLY - DESCRIPTION AND OPERATION

1. Description

A. The equipment access door assembly is a plug-type door that opens inward to the equipment bay. It is located in the lower fuselage nose. It can be opened from outside the airplane by a manually-operated handle recessed flush in the outer surface.

B. Four link pins, each having a rack-type gear, engage a pinion gear on the actuator shaft and move inward and outward when the handle is turned. A continuous weather and pressurization seal is attached around the entire edge of the door.

2. Operation

A. Pull down the operating handle and turn it counterclockwise to open. This action withdraws all four latch pins.

B. Draw it forward on the rails until the forward rollers start to drop down the incline to close. The operating handle then is pulled out and turned counterclockwise to retract all the latch pins, while at the same time continuing to draw the door forward. When the door is properly seated, a final clockwise turn of the handle moves all four latch pins into place. The handle then can be allowed to return to its recess in the exterior skin of the door.

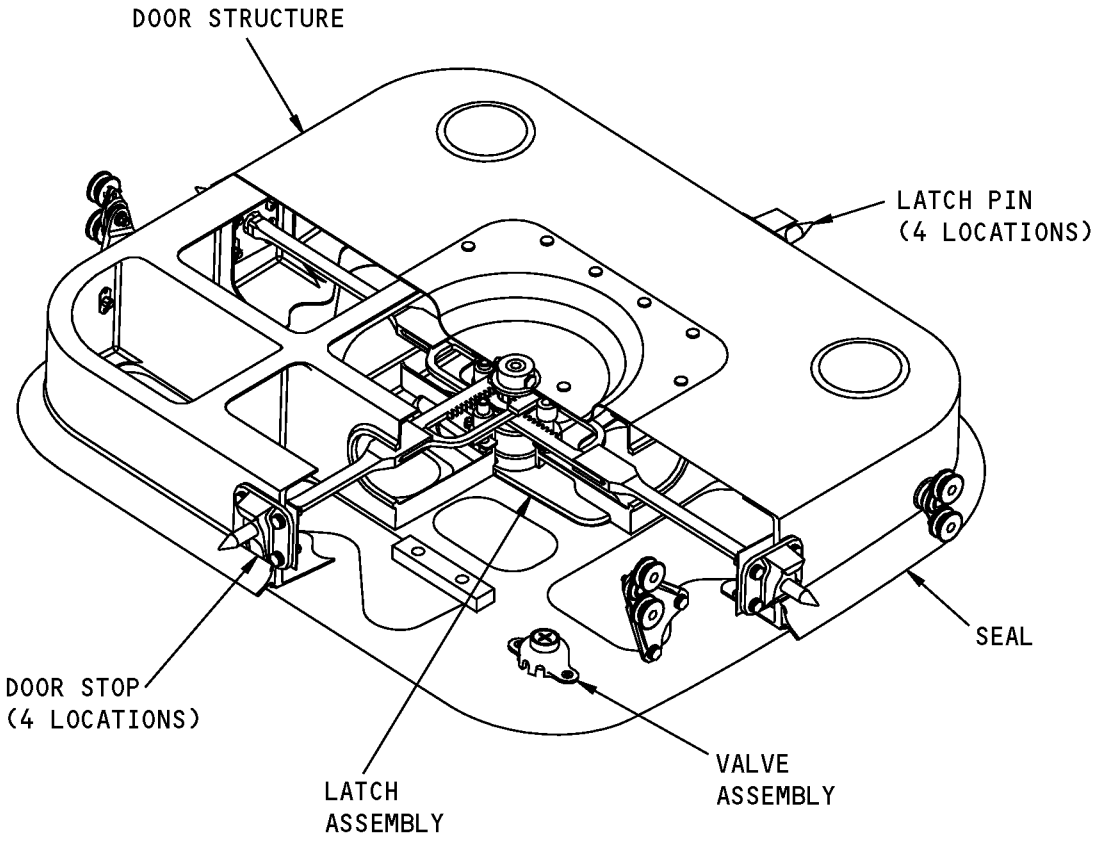
3. Leading Particulars (Approximate)

A. Length – 29 inches

B. Width – 26 inches

C. Height – 7 inches

D. Weight – 23 pounds



Equipment Access Door Assembly
Figure 1

(NOT APPLICABLE)

DISASSEMBLY

1. General

A. This procedure has the data necessary to disassemble the equipment access door assembly.

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

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

D. Refer to IPL Figure 1 or IPL Figure 2, for the item numbers.

2. Disassembly

A. Disassembly procedure for the 141A6710-9, -10, -13, -14, -15, -16 Equipment Access Door Assemblies (IPL Figure 1)

(1) Use standard industry procedures and the steps shown below to disassemble this component.

(2) Remove the caplugs (5) from the inner skin of the door assembly (1B).

(3) Remove the bolts (10) and the cover (25) from the inner skin of the door assembly (1B).

(4) Remove the bolts (30), spacers (35, 40, 45, 50, 55), bearings (75), and latch assembly (115A) from the structural casting (435).

NOTE: Disassemble the latch assembly (115A) as necessary to be able to remove it from the door assembly (1B). Repair, refinish, and adjustment procedures for the latch assembly (115A) can be found in the vendor component maintenance manual.

(5) Remove the bolts (150) and the handle (165) from the door assembly (1B) inner skin.

(6) Remove the bolts (120), nut (125A), shim (145) and handle catch assembly (130) from the structural casting (435).

(7) Remove the bolts (175), washers (180), doorstop (195, 200) and shims (215) from the door assembly (1B).

(8) Remove the bolts (175), washers (180), doorstop (205, 210), and shim (220) from the structural casting (435).

(9) Remove the bolts (275), washer (285, 290), bearing (300), roller truck assembly (305), and nut (295) from the structural casting (435).

(10) Do not remove the carrier assemblies (230, 255, 340) from the structural casting (435) unless replacement or repair is necessary.

(11) Remove the bolts (280), bearing (300), roller truck assembly (305), shim (330), and washer (290) from the structural casting (435).

(12) Remove the cotter pin (310), drilled shank pin (315), rollers (320), and truck (325).

CAUTION: THE DRAIN VALVE ASSEMBLY (410) IS A BONDED PLASTIC ASSEMBLY. DISASSEMBLY WILL DESTROY THE DRAIN VALVE ASSEMBLY.

(13) Remove the bolts (360), washers (365), shim (385, 390), and bracket (380) from the structural casting (435).

NOTE: Do not remove the drain valve assembly (410) from the door assembly (1B) inner skin unless replacement of the drain valve assembly (410) is necessary.

NOTE: Do not remove the retainer (405) from the door assembly (1B) outer skin unless replacement is necessary.

(14) Remove the seal (170) from the structural casting (435).

B. Disassembly procedure for the 141A6710-11 and -12 Equipment Access Door Assemblies (IPL Figure 2)

(1) Use standard industry procedures and the steps shown below to disassemble this set of components.

(2) Remove the screws (35, 380) and the cover (25) from the inner skin of the door assembly (1A).

(3) Remove the screws (385) and the access hole covers (30) from the inner skin of the door assembly (1A).

(4) Remove the bolts (45), nuts (95), washers (60, 70, 85, 390), spacers (50, 55, 75, 80, 90), bearings (65), support plate (40A), and latch assembly (100A) from the door assembly structure.

NOTE: Disassemble the latch assembly (100A), as necessary, to be able to remove it from the door assembly (1A). Repair, refinish, and adjustment procedures for the latch assembly (100A), can be found in the vendor component maintenance manual.

(5) Remove the bolts (105), washers (110), door stops (115, 125, 130, 140), and shims (120, 135) from the door assembly structure.

NOTE: Do not remove the radius fillers (460, 480, 485) or the nutplates (470) unless replacement or repair is necessary.

(6) Remove the bolts (225), nuts (235), washers (230, 265), bearings (270), and roller truck assemblies (240) from the door assembly structure.

NOTE: Do not remove the roller fittings (295, 300) unless replacement or repair is necessary.

(7) Remove the bolt (185), bearing (195), roller truck assembly (240), washer (190), shim (205), and spacer (200) from the door assembly structure.

NOTE: Do not remove the roller backup fitting (220) or the carrier assembly (440) unless replacement or repair is necessary.

CAUTION: THE DRAIN VALVE ASSEMBLY (160) IS A BONDED PLASTIC ASSEMBLY. DISASSEMBLY WILL DESTROY THE DRAIN VALVE ASSEMBLY.

(8) Remove the cotter pins (245), drilled shank pins (250), rollers (255), and truck (260), from the roller truck assembly (240).

NOTE: Do not remove the drain valve assembly (160) from the outer skin of the door assembly (1A) unless replacement of the drain valve assembly (160) is necessary.

NOTE: Do not remove the drain valve retainer (155) from the outer skin of the door assembly (1A) unless replacement of the drain valve retainer (155) is necessary.

(9) Remove the seal (355) from the door assembly structure.

CLEANING

1. General

A. This procedure has the data necessary to clean the equipment access 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 or IPL Figure 2, as applicable, 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 (75, 300, IPL Figure 1; 65, 195, 270, IPL Figure 2) as specified in SOPM 20-30-01.

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

CHECK

1. General

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

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

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

D. Refer to IPL Figure 1 or IPL Figure 2, as applicable, for the item numbers.

2. Check

A. References

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

B. Procedure

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

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

1) Truck (325, IPL Figure 1; 260, IPL Figure 2).

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

1) Bearing (300, IPL Figure 1; 195, 270, IPL Figure 2).

2) Bracket (380, IPL Figure 1).

3) Catch fitting (140, IPL Figure 1).

4) Structural casting (435, IPL Figure 1).

5) Roller spacer (200, IPL Figure 2).

6) Roller fitting (220, 295, 300, IPL Figure 2).

REPAIR

1. General

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

Table 601:

PART NUMBER	NAME	REPAIR
—	REFINISH OF OTHER PARTS	1-1
141A6710	DOOR ASSEMBLY	2-1

2. Dimensioning Symbols

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

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

EXAMPLES

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

True Position Dimensioning Symbols
Figure 601

REFINISH OF OTHER PARTS - REPAIR 1-1

1. General

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

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

C. Refer to IPL Figure 1 or IPL Figure 2, 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
C50069	Coating - Enamel, Color 702 Gloss White	BMS10-11, Type II
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23

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 20-60-04	MISCELLANEOUS MATERIALS

C. General

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

D. Procedure

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

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

Table 601: Refinish Details

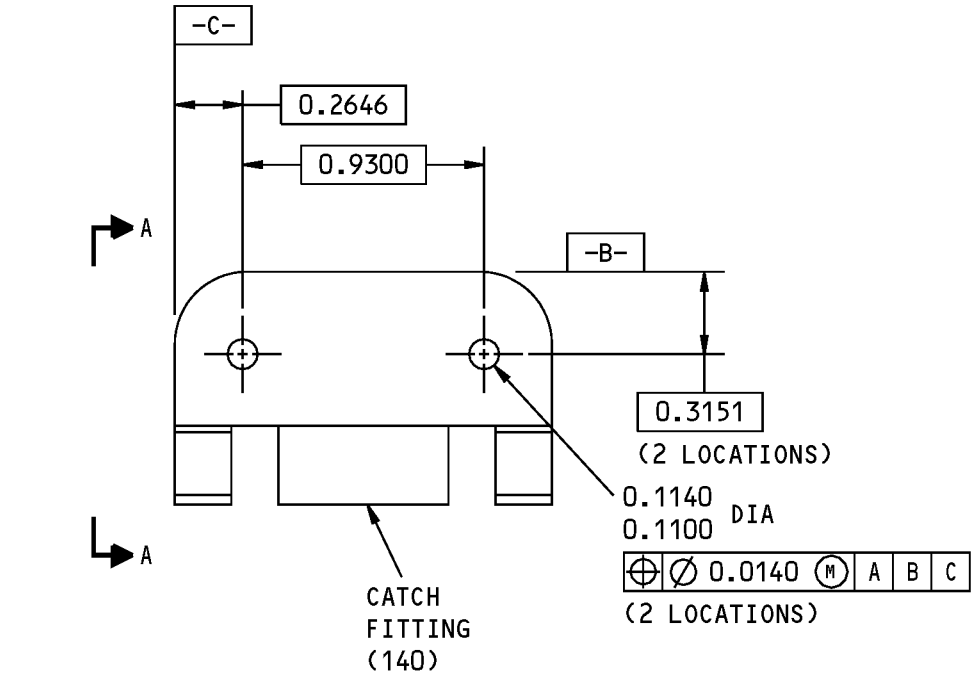
IPL FIG. & ITEM	MATERIAL	FINISH
IPL Fig. 1		
Cover (25)	Aluminum alloy	Chemical treat (F-17.07) and apply primer, C00259 (F-20.03). Apply corrosion inhibiting compound, G00009 (F-19.26) to the outboard side.
Spacer (55)	Aluminum alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.03).

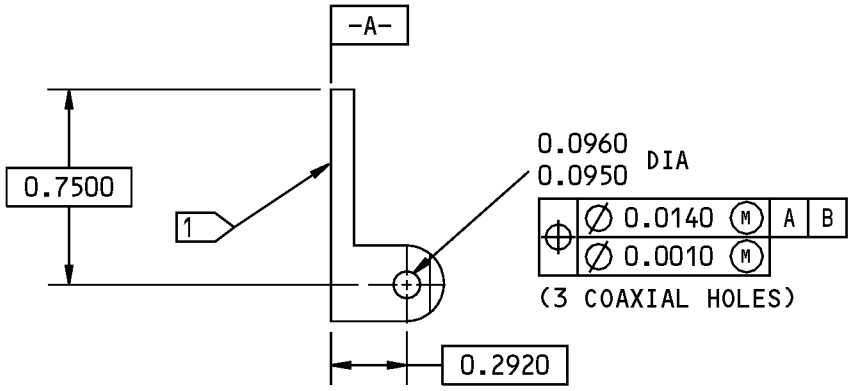
Table 601: Refinish Details (Continued)

IPL FIG. & ITEM	MATERIAL	FINISH
Plate (95,250,270, 355)	Aluminum alloy	Chemical treat (F-17.07) and apply primer, C00259 (F-20.03).
Washer (100,105, 110)	Nylon	No finish (F-6.10).
Pin (135)	302 CRES	Passivate (F-17.25).
Catch fitting (140)	Titanium Alloy	Prepare surface and apply primer, C00259 (F-18.12) in the area specified by flagnote 1 in REPAIR 1-1, Figure 601.
Doorstop (195,200, 209,210)	Aluminum bronze	Cadmium plate (F-15.06) and apply primer, C00259 (F-20.02) only on surfaces mating with the door structure. Do not put primer, C00259 in the holes; overspray is permitted.
Washer (290)	Aluminum nickel bronze	Cadmium plate (F-15.06) all surfaces. Apply primer, C00259 (F-20.02) on faying surface as noted by flagnote 1 in REPAIR 1-1, Figure 602 .
Bearing (300)	Aluminum nickel bronze	No finish (F-25.01).
Truck (325)	15-5PH CRES 180-200 ksi	Passivate (F-17.25).
Bracket (380)	Aluminum alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.03).
IPL Fig. 2		
Cover (25,30) Support Plate (40A)	Aluminum alloy	Chemical treat and apply primer, C00259 (F-18.06). Apply enamel coating, C50069 (F-21.03).
Washer (60,70,390)	Nylon	No finish (F-6.10).
Spacer (90)	Aluminum alloy	Chromic acid anodize and apply primer, C00259 and enamel coating, C50069 (F-21.18). Do not put enamel coating, C50069 in the hole.
Door Stop (115,125, 130,140)	Aluminum bronze	Cadmium plate (F-15.06). Apply primer, C00259 (F-20.02) only on surfaces mating with the door structure. Do not put primer, C00259 in the holes; overspray is permitted.
Washer (190,265)	Aluminum nickel bronze	Cadmium plate (F-15.06). Apply primer, C00259 (F-20.02) only on faying surface as specified by flagnote 1, REPAIR 1-1, Figure 602.
Bearing (195,270)	Aluminum nickel bronze	No finish (F-25.01).
Roller Spacer (200) Roller Fitting (220,295,300)	Aluminum alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.03).
Roller (255)	Nylon	No finish (F-25.01).
Truck (260)	15-5PH CRES 180-200 ksi	Passivate (F-17.25).

Table 601: Refinish Details (Continued)

IPL FIG. & ITEM	MATERIAL	FINISH
Retainer (315,320, 325,330,335,340, 345,350)	Aluminum alloy	Chemical treat or chromic acid anodize and apply primer, C00259 (SRF-2.30). Apply enamel coating, C50069 (F-21.03).
Plate (455)	Aluminum alloy	Chemical treat (F-17.07) and apply primer, C00259 (F-20.03).
Radius Filler (460)	Aluminum alloy	Chromic acid anodize and apply primer, C00259 (F-18.13). Apply enamel coating, C50069 (F-21.03).
Radius Filler (480,485)	Aluminum alloy	Chemical treat or chromic acid anodize and apply primer, C00259 (F-18.05). Apply enamel coating, C50069 (F-21.03).





A–A

1 APPLY PRIMER TO THIS SURFACE

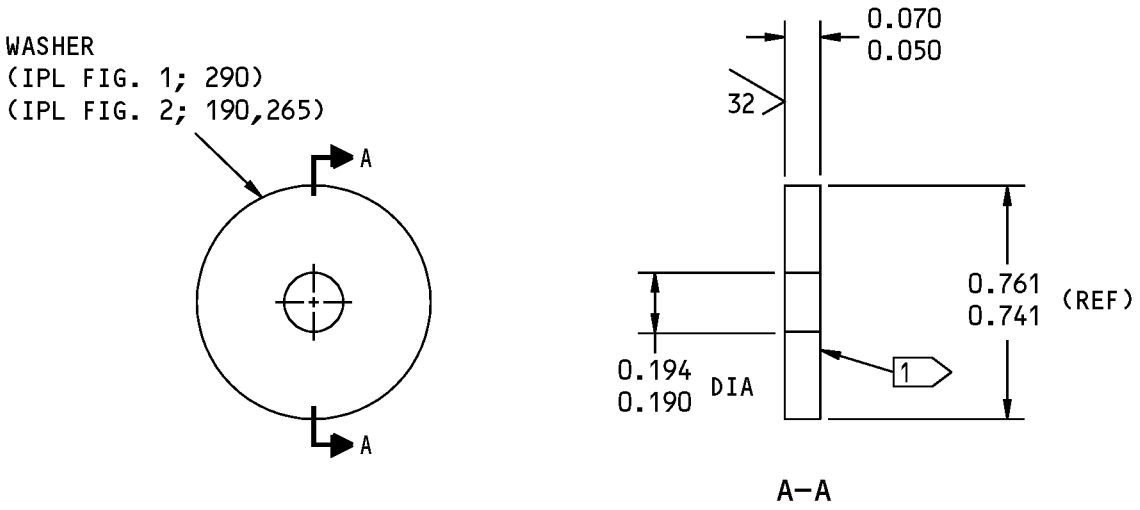
125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

141A6712-2 Fitting Refinish
Figure 601



1 APPLY PRIMER TO THIS SURFACE

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

BREAK ALL SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

69B13438-501 Washer Refinish
Figure 602

EQUIPMENT ACCESS DOOR ASSEMBLY - REPAIR 2-1

141A6710–9, –10, –11, –12, –13, –14, –15, –16

1. General

A. This procedure has the data necessary to repair and refinish the equipment access door assembly (1B, IPL Figure 1; 1A, IPL Figure 2).

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

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

D. Refer to IPL Figure 1 or IPL Figure 2, as applicable, for the item numbers.

2. Marker and ID Plate Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
B00571	Coating - Clear Hydraulic Fluid Resistant Topcoat	BAC5710, Type 41
B01010	Final Cleaning Before Non-Structural Bonding To Solvent Resistant Organic Coatings (AMM 20-30-90/201) - Series 90	

B. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-30-90	SOLVENTS FOR FINAL CLEANING OF SOLVENT RESISTANT ORGANIC COATINGS BEFORE NON-STRUCTURAL BONDING (SERIES 90)
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-50-05	APPLICATION OF ALUMINUM FOIL AND OTHER MARKERS
SOPM 20-60-02	FINISHING MATERIALS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

C. Doors 141A6710-9, -10, -13, -14, -15, -16 (IPL Figure 1)

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

(1) Marker(s) (440, 445):

(a) Remove the old marker(s) (440, 445) from the door.

(b) Clean the bonding surface with a Series 90 solvent, B01010 (SOPM 20-30-90).

(c) Install replacement marker(s) on the door as specified in SOPM 20-50-05 and shown in REPAIR 2-1, Figure 601, Sections A-A and B-B.

(d) Apply Type 41 clear coating, B00571 (F-21.34) to the marker and out a minimum of 0.35 inch from the edge of the marker.

(2) Identification plate (450):

(a) Remove the old identification plate (450) from the door.

(b) Clean the bonding surface with a Series 90 solvent, B01010 as specified in SOPM 20-30-90.

(c) Install a replacement identification plate (450) on the door as shown in REPAIR 2-1, Figure 601, Section C-C.

(d) Apply Type 41 clear coating, B00571 (F-21.34) to the plate and out a minimum of 0.35 inch from the edges of the plate.

D. Doors 141A6710-11, -12 (IPL Figure 2)

(1) Marker(s) (490, 495):

(a) Remove the old marker(s) from the door.

(b) Clean the bonding surface with a Series 90 solvent, B01010 as specified in SOPM 20-30-90.

(c) Install replacement marker(s) on the door and seal their edges as specified in SOPM 20-50-05 and as shown in REPAIR 2-1, Figure 602, Sections A-A and B-B.

(2) Identification plate (375):

(a) Remove the old identification plate (375) from the door.

(b) Clean the bonding surface with a Series 90 solvent, B01010 as specified in SOPM 20-30-90.

(c) Install a replacement identification plate (375) on the door and seal the edges as specified in SOPM 20-50-05 and as shown in REPAIR 2-1, Figure 601, Section A-A.

3. Door Assembly Refinish and Fillet Seal

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A02315	Sealant - Low Density, Synthetic Rubber. 2 Part	BMS5-142
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I
C50069	Coating - Enamel, Color 702 Gloss White	BMS10-11, Type II
G00009	Compound - Organic Corrosion Inhibiting	BMS3-23

B. Doors 141A6710-9, -10, -13, -14, -15, -16 (IPL Figure 1)

(1) Seal the internal surfaces of the door (REPAIR 2-1, Figure 603)

(a) Remove the caplugs (5), bolts (10), cover (25), and the latch components, and mask the remaining structure as shown. Mask the bushings, holes, and hardware. Keep the drainage valve assembly (410) and the drain holes covered during the refinish and sealing. Do not block the drain holes with sealant, A02315.

(b) Apply primer, C00259 (F-14.995) to all surfaces that will get the corrosion inhibiting compound, G00009.

(c) Apply pressure fillet seals with sealant, A02315 as shown.

(d) Apply corrosion inhibiting compound, G00009 (F-19.26) as shown.

(2) Refinish the door (REPAIR 2-1, Figure 604)

(a) Mask the areas shown. Give protection to the outer skin of the door from overspray of primer or paint.

(b) Apply primer, C00259 (F-14.9962) to the surfaces shown. No overspray is permitted on the outer skin.

(c) Apply enamel coating, C50069 (F-21.03) to the surfaces shown. No overspray is permitted on the outer skin.

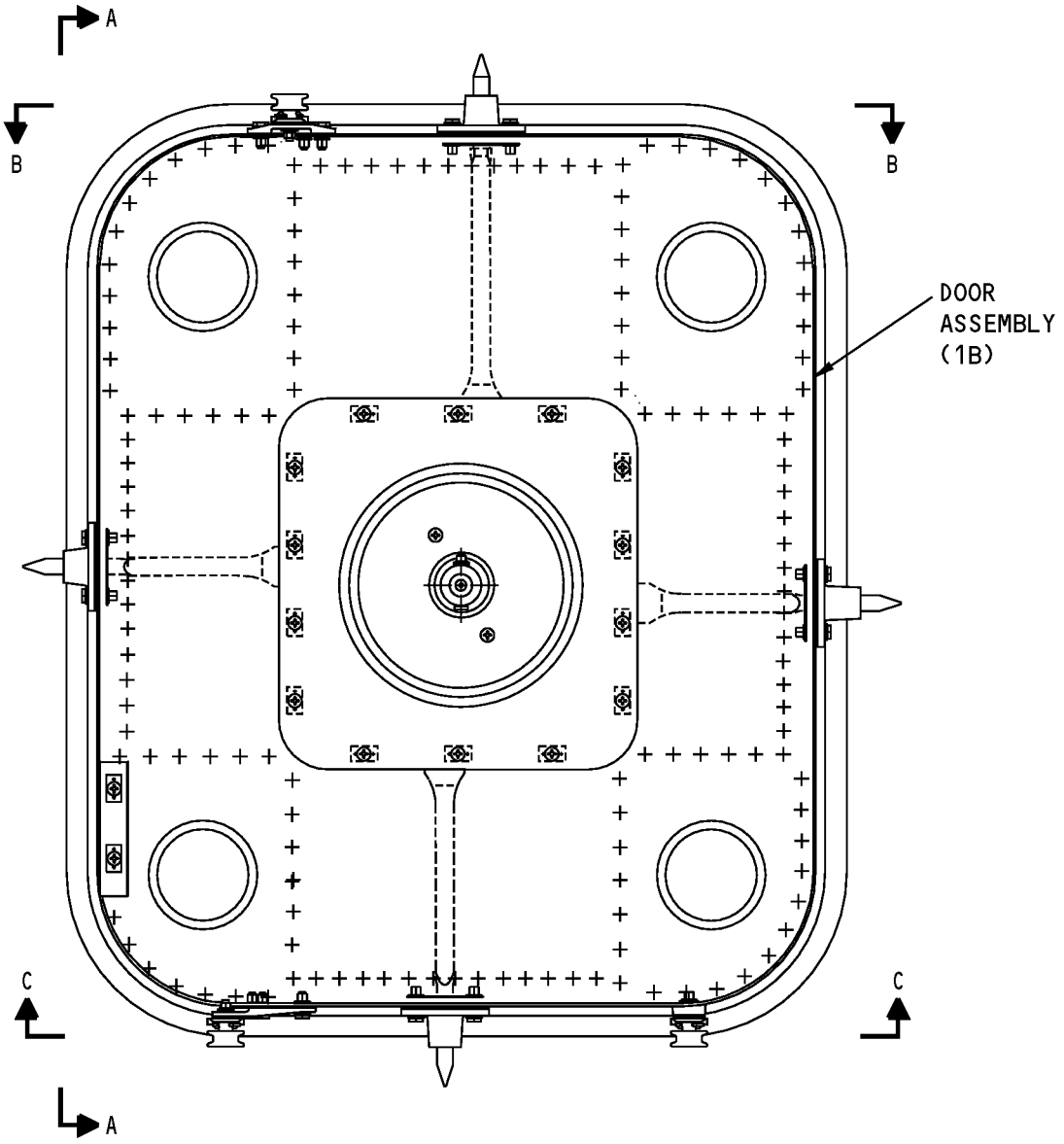
C. Doors 141A6710-11, -12 (IPL Figure 2)

(1) Refinish the door (REPAIR 2-1, Figure 604)

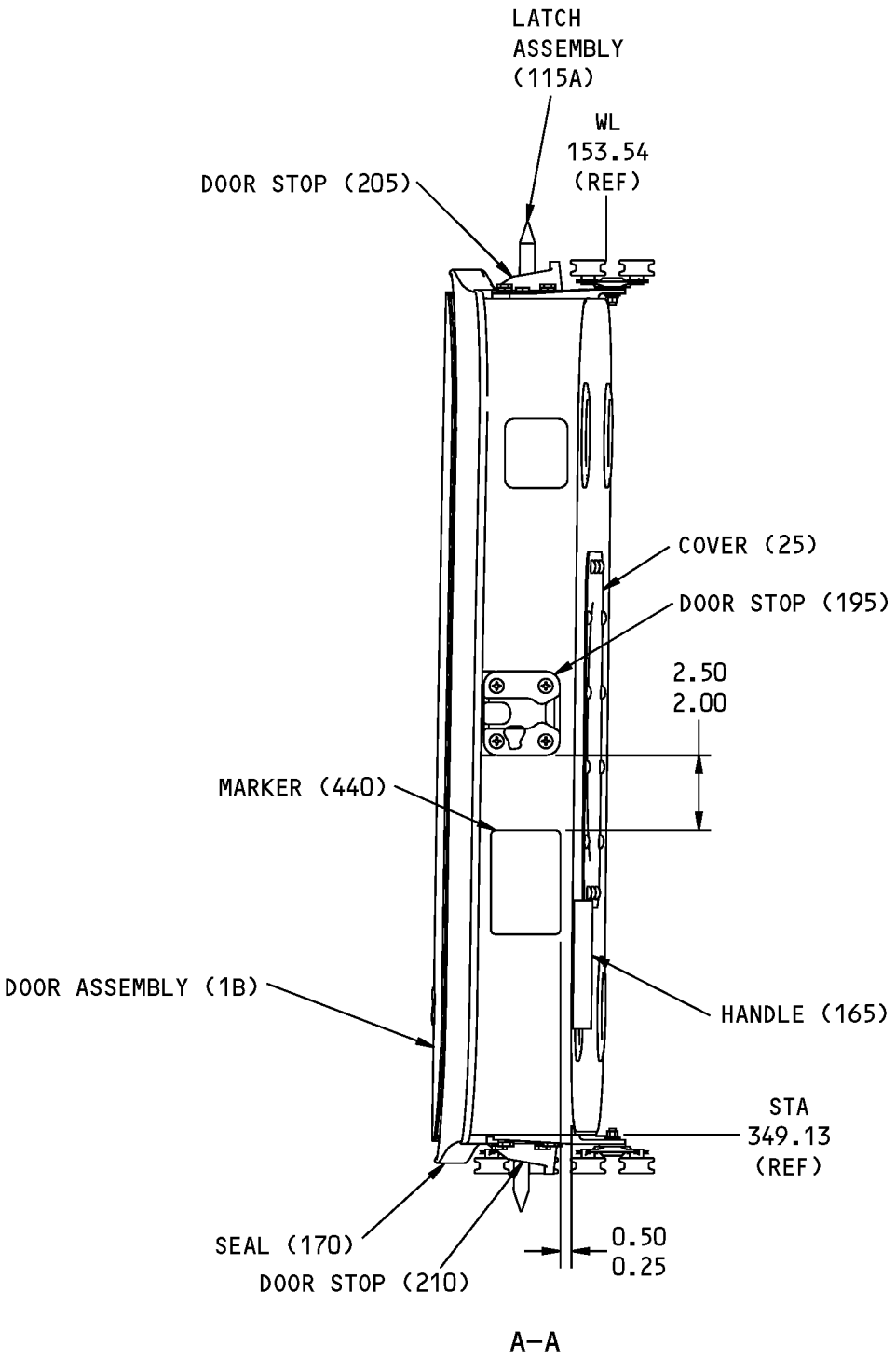
(a) Mask the areas shown. Give protection to the outer skin of the door assembly from overspray of primer or paint.

(b) Apply primer, C00259 (F-14.9962) to the surfaces shown in REPAIR 2-1, Figure 604. No overspray is permitted on the outer skin.

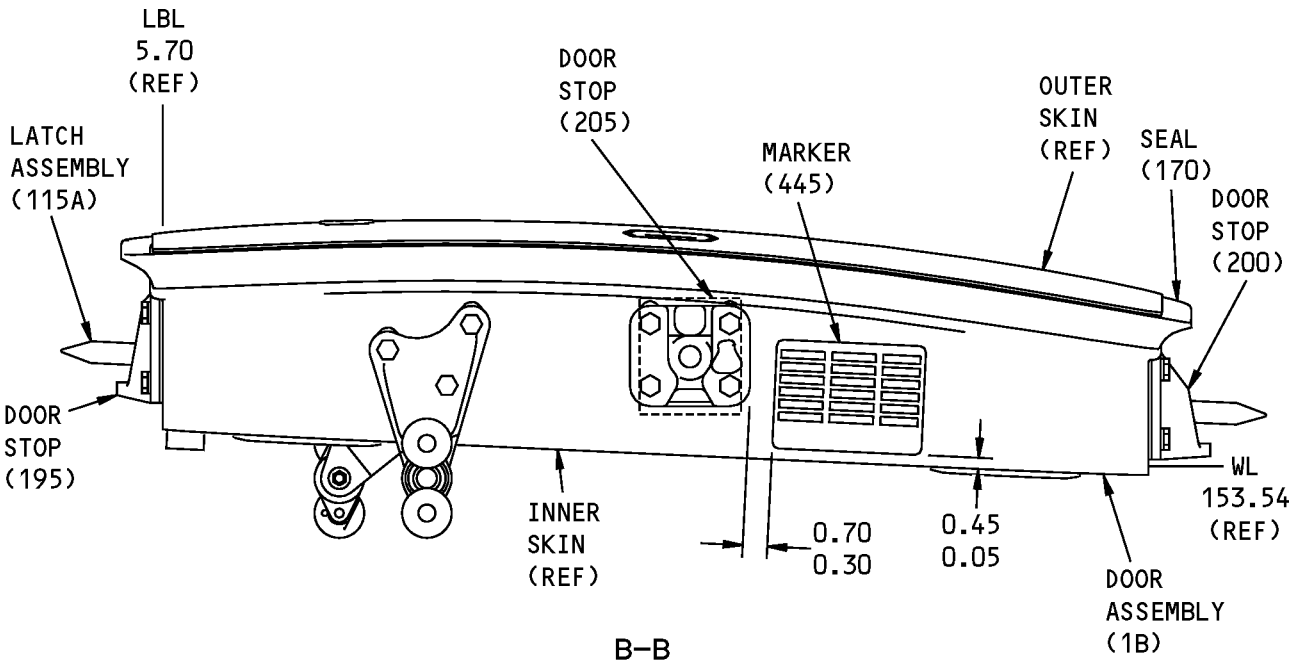
(c) Apply coating, C50069 (F-21.03) to the surfaces shown in REPAIR 2-1, Figure 604. No overspray is permitted on the outer skin.



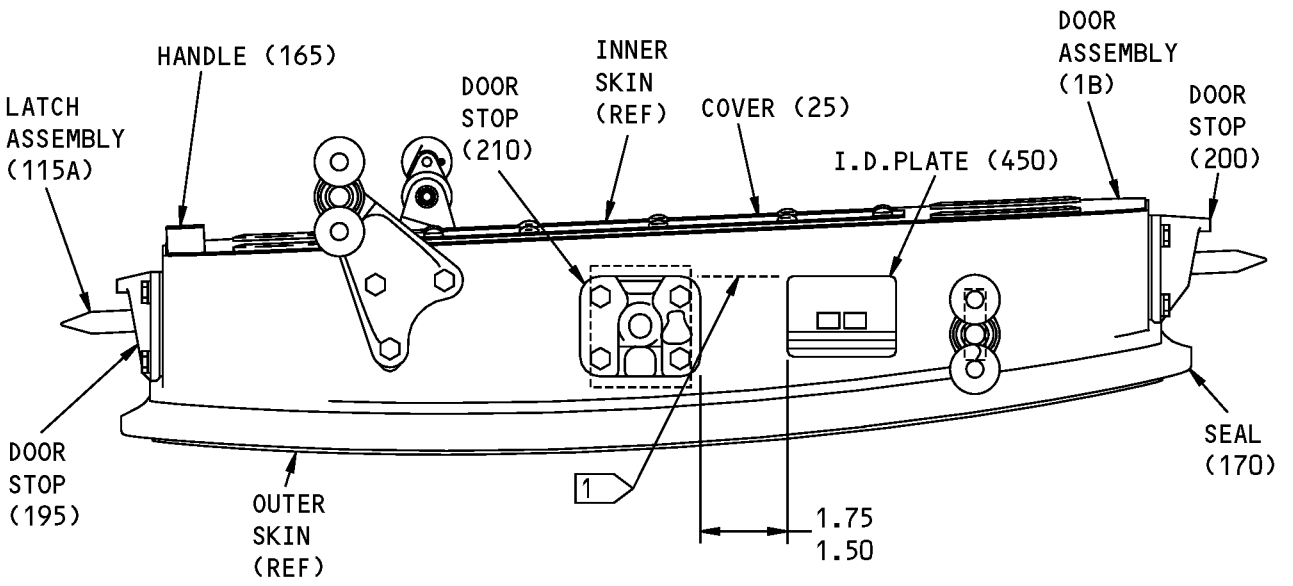
141A6710-9,-10,-13,-14,-15,-16 Door Assembly Repair
Figure 601 (Sheet 1 of 3)



141A6710-9,-10,-13,-14,-15,-16 Door Assembly Repair
Figure 601 (Sheet 2 of 3)



B–B



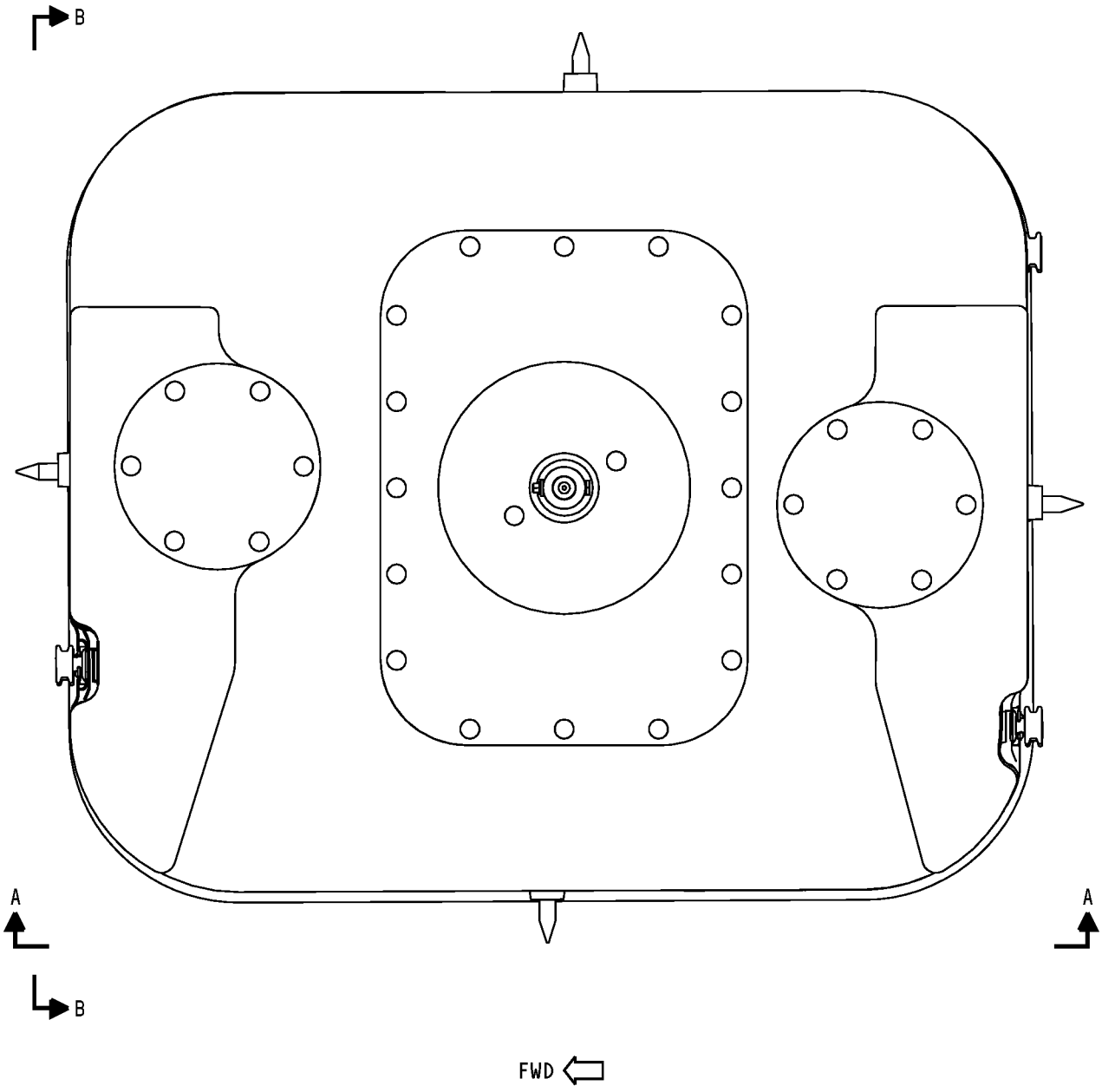
C–C

1 LOCATE I.D. PLATE (450) FLUSH, ±0.25 WITH DOORSTOP (210), AND ORIENT AS SHOWN

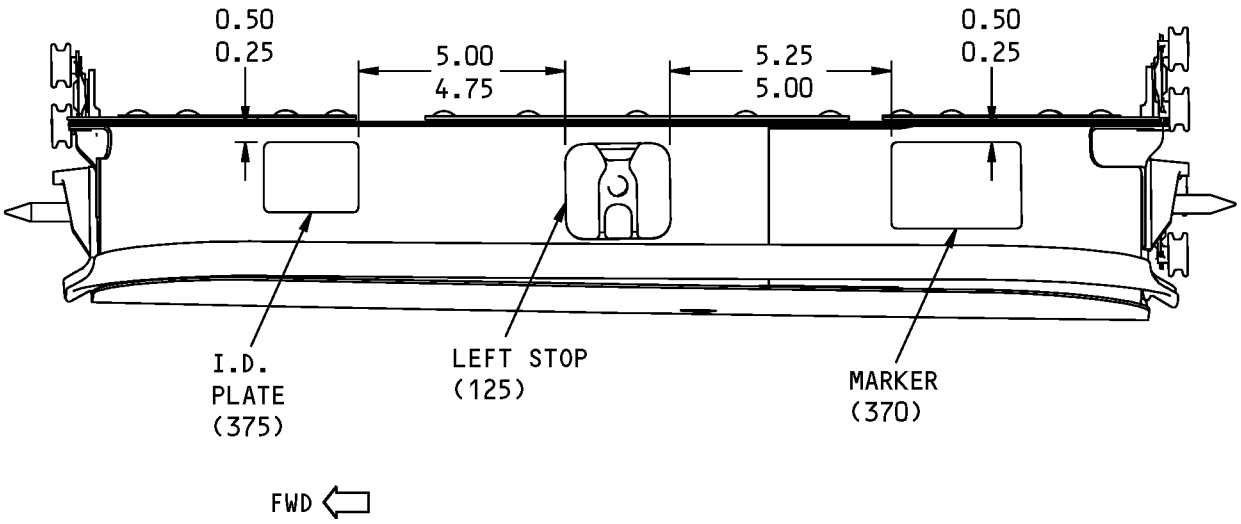
ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

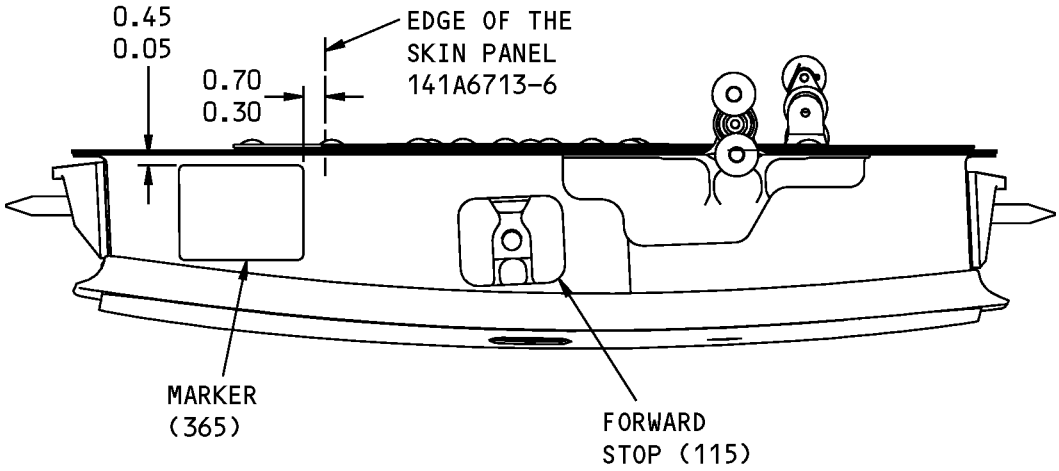
141A6710-9,-10,-13,-14,-15,-16 Door Assembly Repair
Figure 601 (Sheet 3 of 3)



141A6710-11,-12 Door Assembly Repair
Figure 602 (Sheet 1 of 2)



A–A

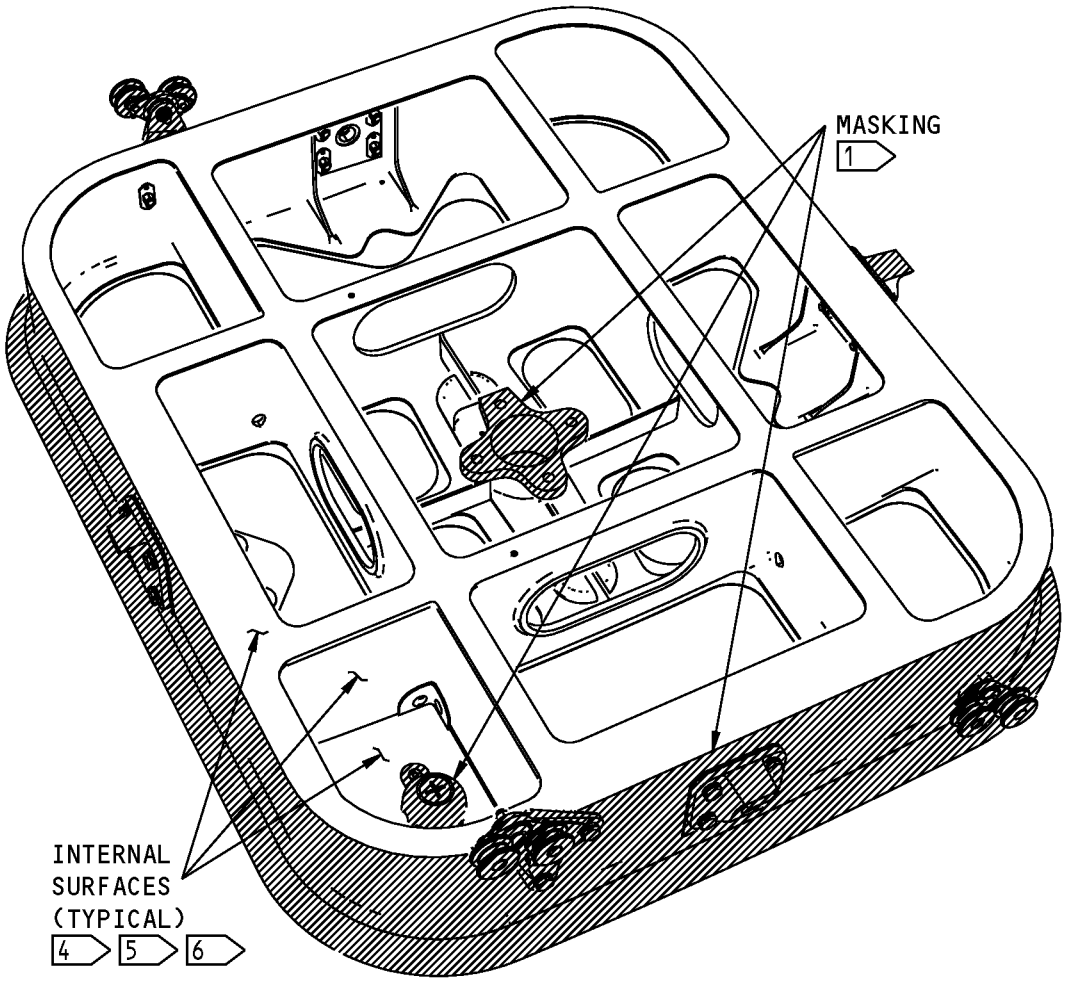


B–B

ITEM NUMBERS REFER TO IPL FIG. 2

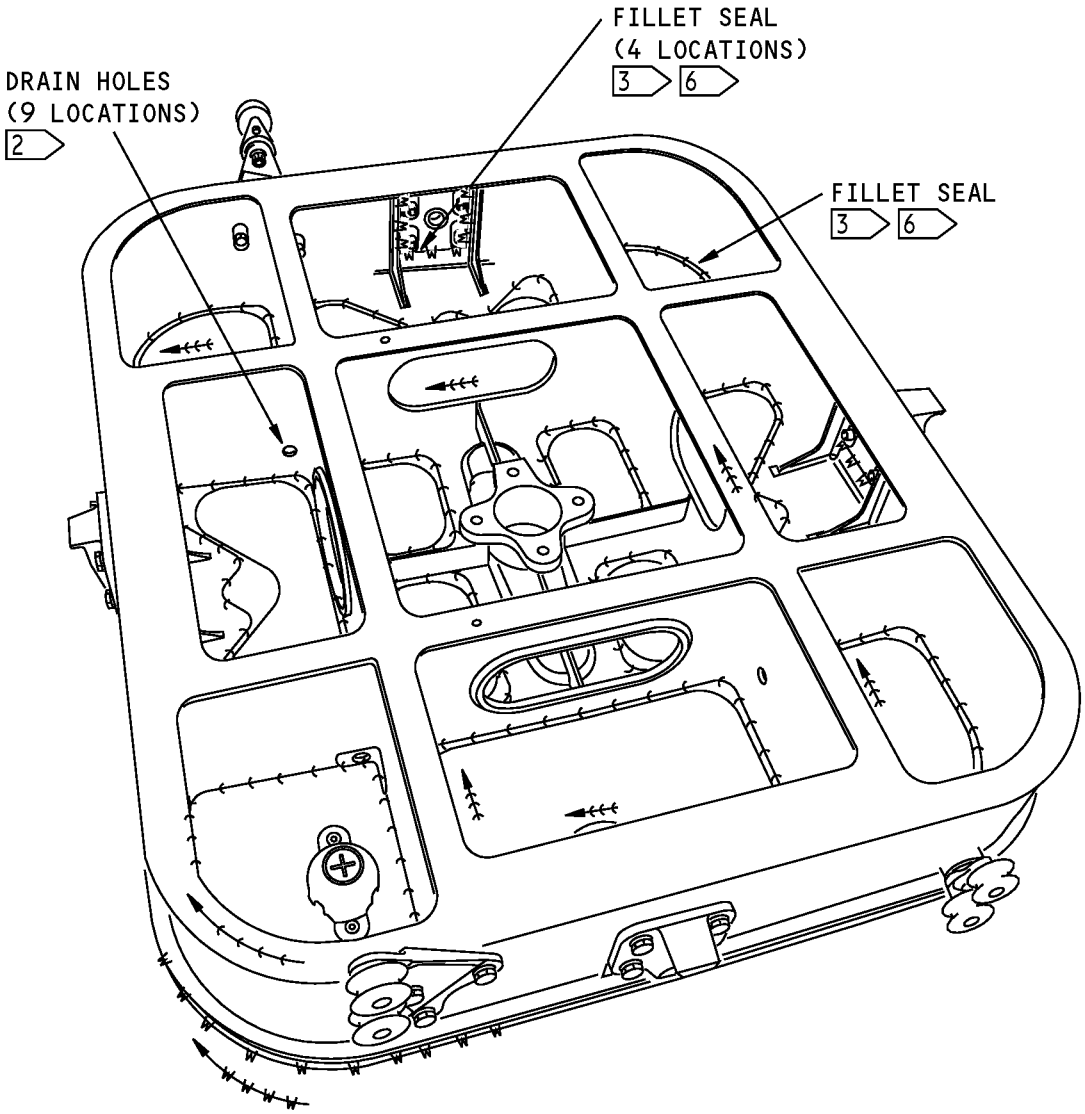
ALL DIMENSIONS ARE IN INCHES

141A6710-11,-12 Door Assembly Repair
Figure 602 (Sheet 2 of 2)



VIEW OF THE DOOR ASSEMBLY WITHOUT
THE INNER SKIN AND LATCH COMPONENTS

141A6710-9,-10,-13,-14,-15,-16 Door Assembly Refinish and Fillet Seal
Figure 603 (Sheet 1 of 3)



VIEW OF THE DOOR ASSEMBLY WITHOUT
THE INNER SKIN AND LATCH COMPONENTS

141A6710-9,-10,-13,-14,-15,-16 Door Assembly Refinish and Fillet Seal
Figure 603 (Sheet 2 of 3)

KEY TO SYMBOLS	
((((	PRESSURE FILLET SEAL WITH BMS 5-142
←((((	CONTINUATION OF PRESSURE FILLET SEAL
WWW	TRIANGULAR SHAPED FILLET SEAL WITH BMS 5-142
←WWW	CONTINUATION OF TRIANGULAR SHAPED FILLET SEAL
▨	MASKING

TABLE A 6

1 MASK THE AREAS SHOWN BEFORE YOU APPLY PRIMER, PAINT AND CORROSION INHIBITING COMPOUND

2 KEEP SEALANT OUT OF THE DRAINAGE HOLES (9 LOCATIONS)

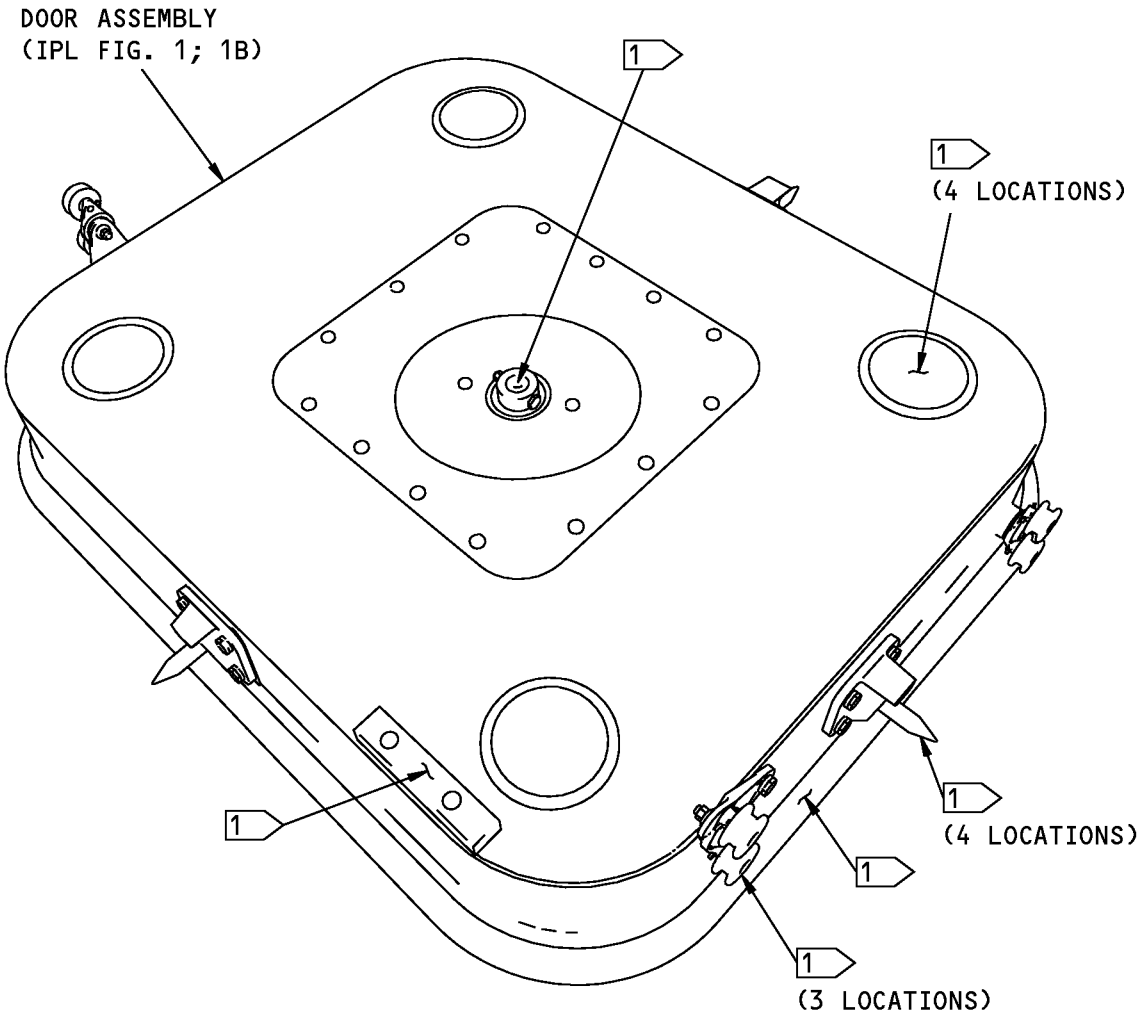
3 APPLY PRESSURE FILLET SEAL TO THE AREAS SHOWN

4 APPLY BMS 10-11, TYPE 1 PRIMER (F-14.995) TO THE INTERNAL SURFACES OF THE DOOR ASSEMBLY

5 APPLY BMS 3-23 CORROSION INHIBITING COMPOUND (F-19.26) TO THE INTERNAL SURFACES OF THE DOOR ASSEMBLY

6 SEE TABLE A FOR THE DEFINITIONS OF THE SEALING AND MASKING SYMBOLS

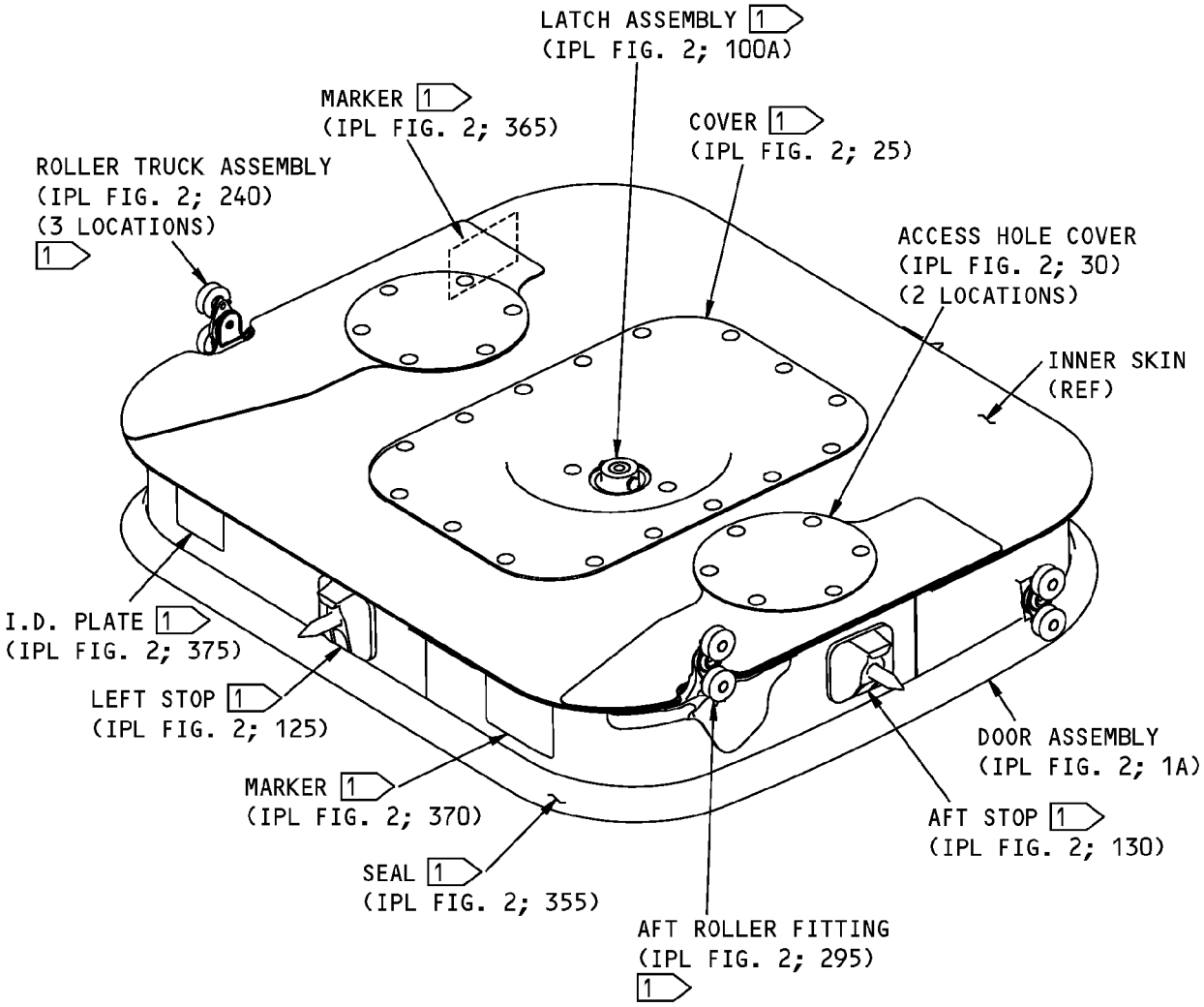
141A6710-9,-10,-13,-14,-15,-16 Door Assembly Refinish and Fillet Seal
Figure 603 (Sheet 3 of 3)



141A6710-9,-10,-13,-14,-15,-16

H52855 S00041002567_V2

141A6710-9 thru -16 Door Assembly Refinish
Figure 604 (Sheet 1 of 2)



1 MASK THIS PART. NO OVERSRPAY ALLOWED

141A6710-9 thru -16 Door Assembly Refinish
Figure 604 (Sheet 2 of 2)

ASSEMBLY

1. General

A. This procedure tells how to assemble the equipment access 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 or IPL Figure 2 as applicable, for the item numbers.

2. Assembly

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95
B00052	Soap - Liquid - Turco 1526	BAC5507
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)

B. References

Reference	Title
SOPM 20-50-01	BOLT AND NUT INSTALLATION
SOPM 20-50-19	GENERAL SEALING
SOPM 20-60-02	FINISHING MATERIALS
SOPM 20-60-03	LUBRICANTS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

C. Procedure for the 141A6710-9, -10, -13, -14, -15, -16 Equipment Access Door Assembly (1B IPL Figure 1)

NOTE: For bolt and nut installation, refer to SOPM 20-50-01. For finishing materials, refer to SOPM 20-60-02. For lubricants, refer to SOPM 20-60-03. For miscellaneous materials, refer to SOPM 20-60-04

(1) Use standard industry procedures and the steps shown below to assemble this component.

(2) If necessary, install the drain valve retainer (405) onto the inside of the door assembly (1B) outer skin with the washers (400) and the rivets (395) as shown in ASSEMBLY, Figure 701, Section J-J.

(3) If necessary, install the drain valve assembly (410) into the drain valve retainer (405) with the cap (415) as shown in ASSEMBLY, Figure 701, Section C-C. Tighten the cap (415) to 10-15 pound-inches.

(4) Apply grease, D00015 (F-19.16) onto the bolts (360) and the washers (365).

(5) Install the brackets (380) and the shims (385, 390) onto the structural casting (435) with the bolts (360) and the washers (365) as shown in ASSEMBLY, Figure 701, Sections C-C and D-D.

NOTE: Final adjustment and fay surface sealing of the shims (385, 390) will be done on installation of the door assembly (1B) onto the airplane.

(6) If necessary, install the carrier assembly (340) onto the structural casting (435) as shown in ASSEMBLY, Figure 701, Section C-C.

(a) Apply sealant, A00247 between the mating surfaces of the structural casting (435) and carrier assembly (340) as specified in SOPM 20-50-19.

(b) Clamp the carrier assemblies (340) onto the structural casting (435) for squeeze-out of sealant, A00247.

(c) Secure the carrier assembly (340) onto the structural casting (435) with the rivets (335).

(d) Remove the clamps from the carrier assembly (340).

(7) Install the roller(s) (320) onto the truck(s) (325) with the pin(s) (315) and the cotter pin(s) (310).

(8) Apply grease, D00015 to the bolt (280) and the washer (290).

(9) Install the roller truck assembly (305) onto the structural casting (435) with the bolt (280), the bearing (300), the washer (290), and shim (330) as shown in ASSEMBLY, Figure 701, Sections A-A and C-C.

NOTE: Final adjustment of the shims (330) will be done on installation of the door assembly (1B) onto the airplane.

(10) Apply grease, D00015 to the bolts (275) and the washers (290).

(11) Install the roller truck assembly (305) onto the brackets (380) with the bolts (275), the bearings (300), the washers (285, 290), and the nuts (295) as shown in ASSEMBLY, Figure 701, Sections C-C and D-D.

(12) If necessary, install the carrier assembly (230, 255) onto the inside of the structural casting (435) as shown in ASSEMBLY, Figure 701.

(a) Apply sealant, A00247 as specified in SOPM 20-50-19 between the mating surfaces of the structural casting (435) and carrier assemblies (230, 235) as shown in ASSEMBLY, Figure 701, Sections A-A, B-B, E-E, and F-F.

(b) Clamp the carrier assemblies (230, 235) onto the structural casting (435) for squeeze-out of sealant, A00247.

(c) Secure the carrier assemblies (230, 235) onto the structural casting (435) with the rivets (225).

(d) Remove the clamps from the carrier assemblies (230, 235).

(13) Apply grease, D00015 to the bolts (175) and the washers (180).

(14) Install the doorstops (195, 200) onto the structural casting (435) with the shims (215), the bolts (175), and the washers (180) as shown in ASSEMBLY, Figure 701, Sections A-A, B-B, and E-E.

NOTE: Final adjustment and fay surface sealing of the shims (215) will be done on installation of the door assembly (1B) onto the airplane.

(15) Apply grease, D00015 to the bolts (175) and the washers (180).

(16) Install the doorstops (205, 210) onto the structural casting (435) with the shims (220), the bolts (175), and the washers (180) as shown in ASSEMBLY, Figure 701, Sections C-C, D-D, and F-F.

NOTE: Final adjustment and fay surface sealing of the shims (220) will be done on installation of the door assembly (1B) onto the airplane.

(17) Install the handle (165) onto the door assembly (1B) inner skin with bolt (150) as shown in ASSEMBLY, Figure 701, Sections G-G.

(18) Install the catch assembly (130) onto the structural assembly (435) as shown in ASSEMBLY, Figure 701, Section F-F.

(a) Remove 0.003 inch of laminations from the shim (145) as required.

(b) Apply sealant, A00247 between the mating surfaces of the structural casting (435), the catch assembly (130), and the shim (145) as specified in SOPM 20-50-19.

(c) Install the catch assembly (130) onto the structural casting (435) with the bolts (120) and nuts (125A).

(19) Apply grease, D00015 to the bolts (30).

(20) Install the latch assembly (115A) and the plate assembly (80) onto the structural assembly (435) with the bolts (30), the washers (100 thru 110, 185, 190), the spacers (35 thru 55), the shims (70), and the bearings (75), as shown in ASSEMBLY, Figure 701, Sections E-E and F-F.

NOTE: Refer to the vendor component maintenance manual for proper assembly and adjustment of the latch assembly (115A).

(21) Apply grease, D00015 to the bolts (10).

(22) Install the cover (25) onto the door assembly (1B) inner skin with the bolts (10) as shown in ASSEMBLY, Figure 701.

(23) Install the caplugs (5) onto the door assembly (1B) inner skin.

(24) Install the seal (170) onto the structural casting (435) with Turco 1526 soap, B00052 as a lubricant.

(a) Lay the seal on the door with the flap of the seal outboard, and with the FWD and AFT markings in the related positions.

(b) Move the seal into its approximate position over the seal retainer. Make the stretch equal along the length of the seal, but keep the FWD and AFT marks at the forward and aft door centers.

(c) Install each corner of the seal at the corner of the retainer and out from the corner a distance of 2-3 inches. First install the inboard edge of the seal into the inner side of the retainer. Then, with a tool with a rounded edge, push the outboard edge of the seal into the retainer. Push in a direction perpendicular to the seal edge to keep the seal smoothly stretched to help prevent bunched areas.

(d) Then install the seal for 2-3 inches at the centerline of the four sides of the door by this same procedure. Gradually work out from the centerline out to the corners. If necessary, remove the seal from the corners and adjust the seal to remove stretched or bunched areas. Note that the seal is slightly wider than the retainer, and becomes compressed in width when installed.

(e) To remove wrinkles in the flap of the seal, pull seal material into the corners as necessary. Waves in the lip of the seal not more than 0.10 inch from the peak points are permitted if the seal lies flat when the door is closed. Final adjustments of the seal must be made when the door is installed on the airplane.

D. Procedure for the 141A6710-11 and -12 Equipment Access Door Assemblies (1A, IPL Figure 2)

NOTE: 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 shown below to assemble this component.

(2) Install the drain valve retainer (155) onto the inside surface of the door assembly (1A) outer skin with washers (150) and rivets (145).

(3) Install the drain valve assembly (160) into the drain valve retainer (155) with the cap (165). Tighten the cap (165) to 10-15 pound-inches.

(4) Attach the aft roller fitting (295) and shim (285) to the door assembly structure with rivets (275, 280). Apply sealant, A00247 to the mating surfaces between the shim and the door assembly structure, and between the shim and the roller fitting as specified in SOPM 20-50-19.

NOTE: The shim for the roller fitting is adjusted when the door assembly is installed on the airplane.

(5) Attach the forward roller fitting (300) and shim (290) to the door assembly structure with rivets (275, 280). Apply sealant, A00247 to the mating surfaces between the shim and the door assembly structure, and between the shim and the roller fitting as specified in SOPM 20-50-19.

NOTE: The shim for the roller fitting is adjusted when the door assembly is installed on the airplane.

(6) Install the carrier assembly (440) as follows:

(a) Fay surface seal the mating surfaces of the carrier assembly (440) and the roller backup fitting (220) with sealant, A00247 as specified in SOPM 20-50-19.

(b) Clamp the carrier assembly to the roller backup fitting to squeeze out the sealant, A00247.

(c) Attach the carrier assembly to the roller backup fitting with one rivet (435).

(d) Remove the clamps from the carrier assembly.

(7) Attach the rollers (255) onto the truck(s) (260) with pins (255) and cotter pins (245).

(8) Install the roller truck assembly (240) at the carrier assembly (440) location as follows:

(a) Apply grease, D00015 to the bolt (185) and washer (190).

(b) Apply sealant, A00247 as specified in SOPM 20-50-19 to the mating surfaces between the spacer (200) and the door assembly structure.

(c) Install the roller truck assembly (240) with the bearing (195), spacer (200), shim (205), washer (190), and bolt (185).

NOTE: The shim (205) for the carrier assembly (440) and the roller truck spacer (200) is adjusted when the door assembly is installed on the airplane.

(d) Do a check to make sure there is a minimum clearance of 0.020 inches between the spacer (200) and the seal retainer (315). If necessary, trim the spacer to a machine finish of 125AA to get the 0.020 inch clearance and touch-up finish as follows:

1) Chemical treat (F-17.10)

2) Apply primer, C00259 (F-20.02).

(9) Apply grease, D00015 to the bolt (225) and washer (265).

(10) Install the roller truck assembly (240) and bearing (270) onto the aft roller fitting (295) with washer (265) and bolt (225).

(11) Apply grease, D00015 to the bolt (225) and washer (265).

(12) Install the roller truck assembly (240) and bearing (270) onto the forward roller fitting (300) with washer (265) and bolt (225).

(13) Install the door stops (115, 125, 130, 140) and shims (120, 135) onto the frame structure.

NOTE: The shim for the door stop is adjusted when the door assembly is installed on the airplane.

(a) Locate the door stop (115, 125, 130, 140), shim (120, 135), and radius fillers (460, 480, 485) to the door assembly structure for the installation of the bolts (105), washers (110), and nutplates (470).

(b) Attach the nutplates (465) to the radius fillers (460, 480, 485) with rivets (465). The nutplate locations must align with the fasteners on the door stop (115, 125, 130, 140).

(c) Attach each radius filler (460, 480, 485) to the door assembly structure with one rivet (475). Appy sealant, A00247 to the mating surfaces between the radius fillers and the door assembly structure as specified in SOPM 20-50-19.

(d) Apply grease, D00015 to the bolts (105) and washers (110).

(e) Install the door stop (115, 125, 130, 140) and shim (120, 135) to the door assembly structure with bolts (105) and washers (110). Apply sealant, A00247 to the mating surfaces between the shim and the door assembly structure, and between the shim and the door stop as specified in SOPM 20-50-19.

(14) Attach the latch assembly (100A) and support plate (40A) onto the door assembly structure with the bolts (45), washers (60, 70, 85, 390), spacers (50, 55, 75, 80, 90), bearings (65), and nuts (95) (SOPM 20-50-01).

NOTE: Refer to the vendor component maintenance manual for the assembly and adjustment of the latch assembly (100A).

(15) Apply grease, D00015 to the screws (385).

(16) Attach the access hole covers (30) to the inner skin of the door assembly (1A) with screws (385).

(17) Apply grease, D00015 to the screws (35, 380).

(18) Attach the cover (25) to the inner skin of the door assembly (1A) with screws (35, 380).

(19) Install the seal (355) onto the door assembly structure with Turco 1526 soap, B00052 as a lubricant.

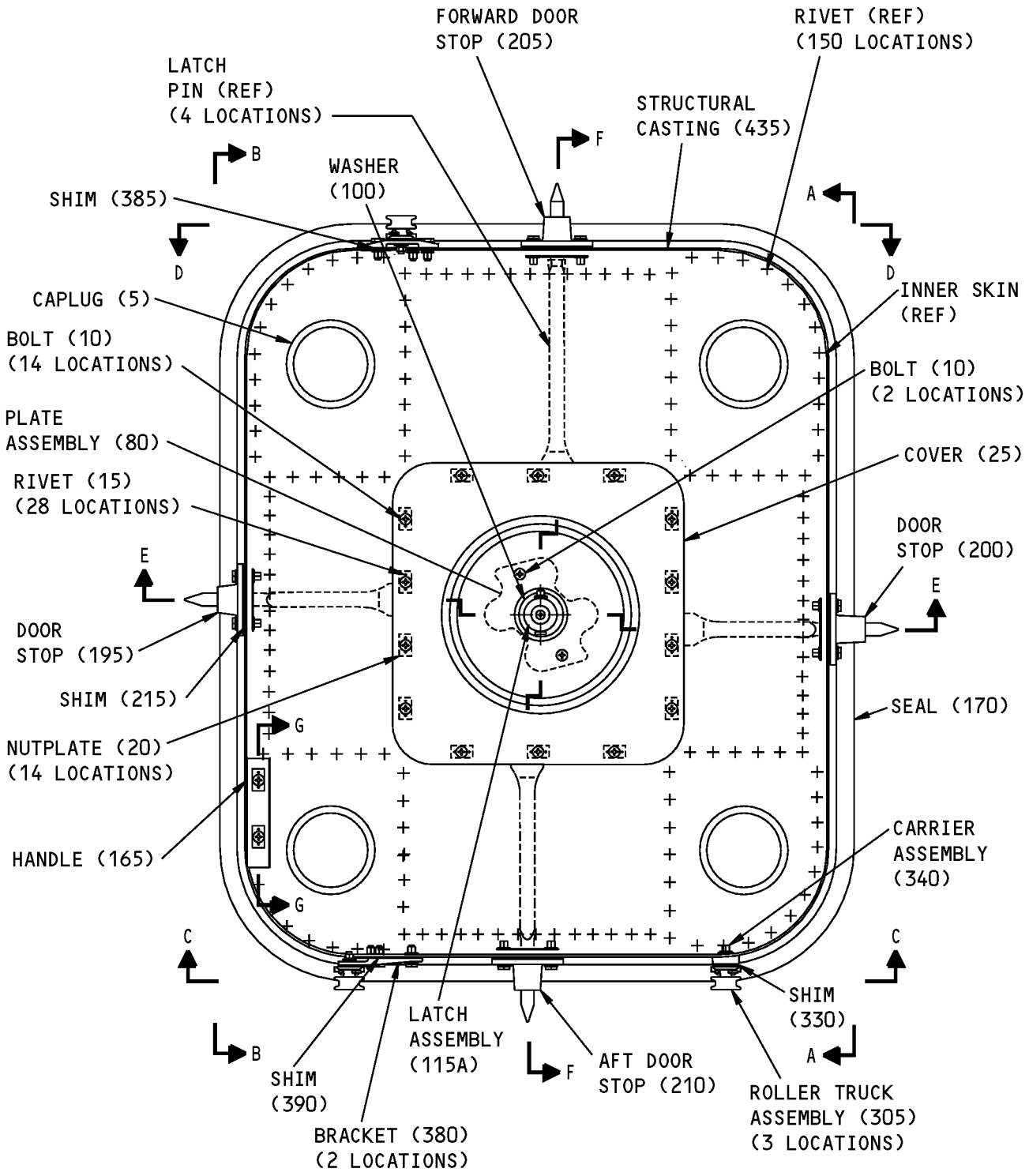
(a) Lay the seal on the door with the flap of the seal outboard, and with the FWD and AFT markings in the related positions.

(b) Move the seal into its approximate position over the seal retainer. Make the stretch equal along the length of the seal, but keep the FWD and AFT marks at the forward and aft door centers.

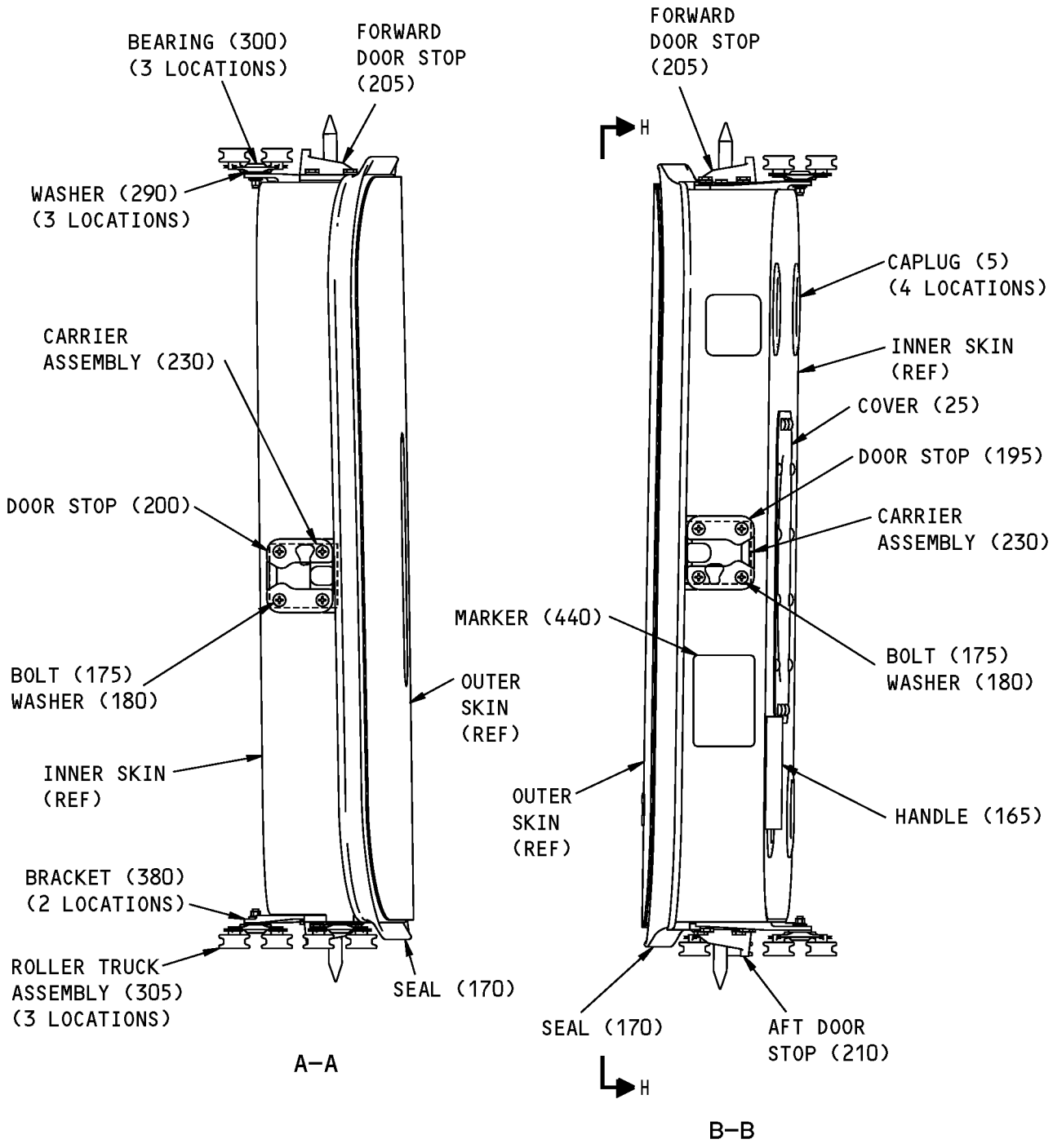
(c) Install each corner of the seal at the corner of the retainer and out from the corner a distance of 2-3 inches. First install the inboard edge of the seal into the inner side of the retainer. Then, with a tool with a rounded edge, push the outboard edge of the seal into the retainer. Push in a direction perpendicular to the seal edge to keep the seal smoothly stretched to help prevent bunched areas.

(d) Then install the seal for 2-3 inches at the centerline of the four sides of the door by this same procedure. Gradually work out from the centerline out to the corners. If necessary, remove the seal from the corners and adjust the seal to remove stretched or bunched areas. Note that the seal is slightly wider than the retainer, and becomes compressed in width when installed.

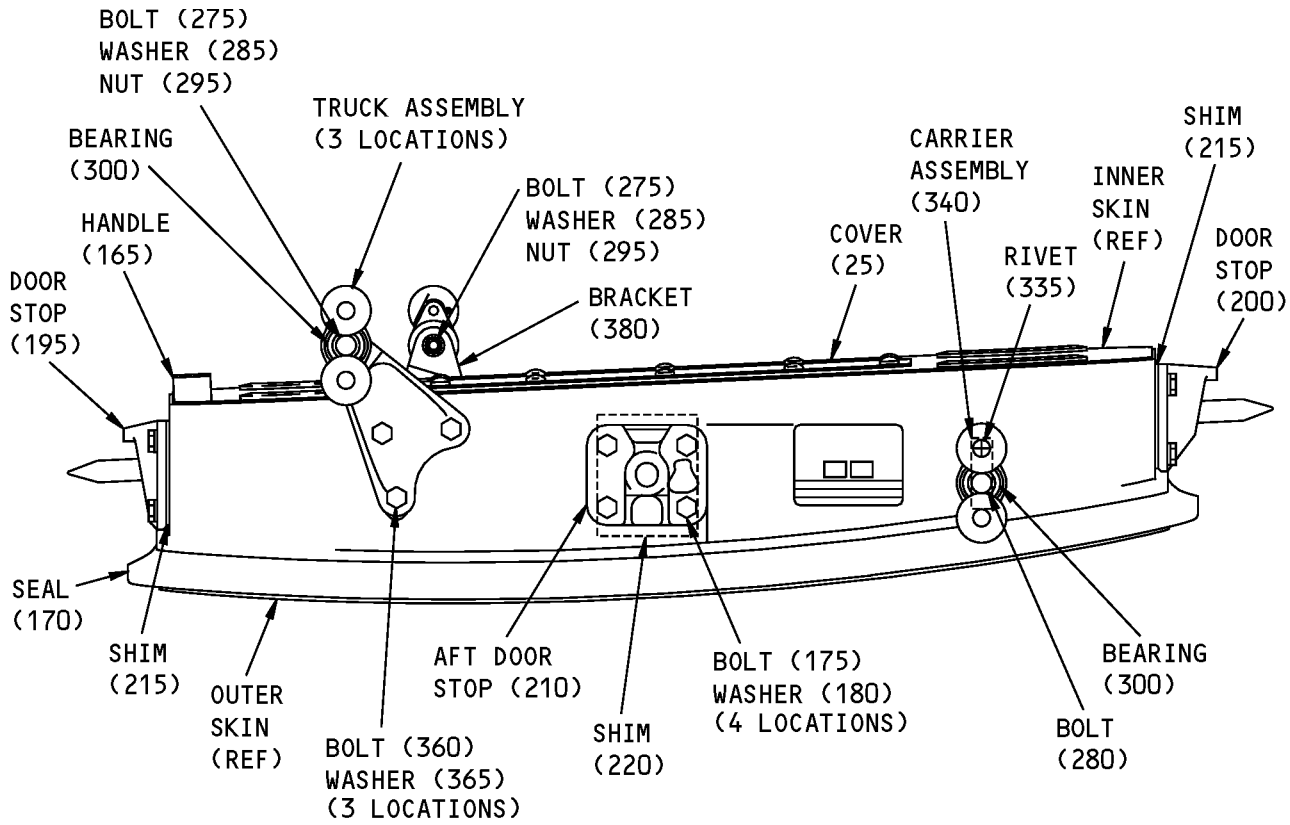
(e) To remove wrinkles in the flap of the seal, pull seal material into the corners as necessary. Waves in the lip of the seal not more than 0.10 inch from the peak points are permitted if the seal lies flat when the door is closed. Final adjustments of the seal must be made when the door is installed on the airplane.



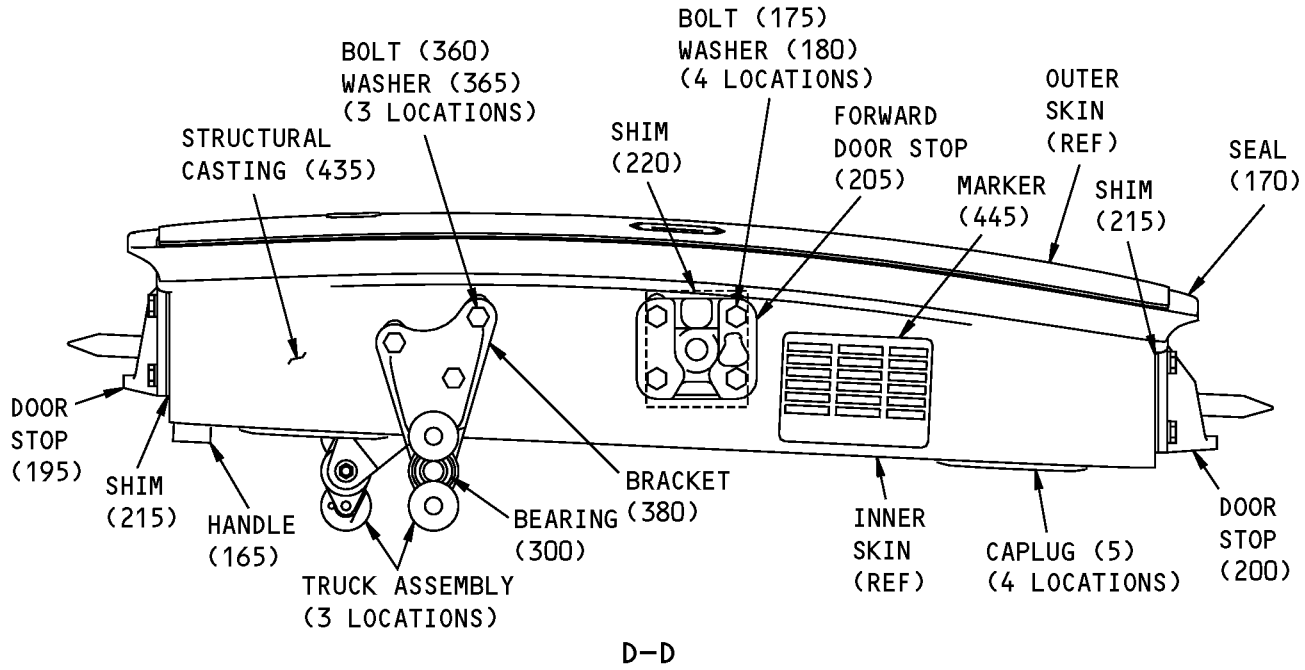
141A6710-9,-10,-13,-14,-15,-16 Equipment Access Door Assembly
Figure 701 (Sheet 1 of 6)



141A6710-9,-10,-13,-14,-15,-16 Equipment Access Door Assembly
Figure 701 (Sheet 2 of 6)

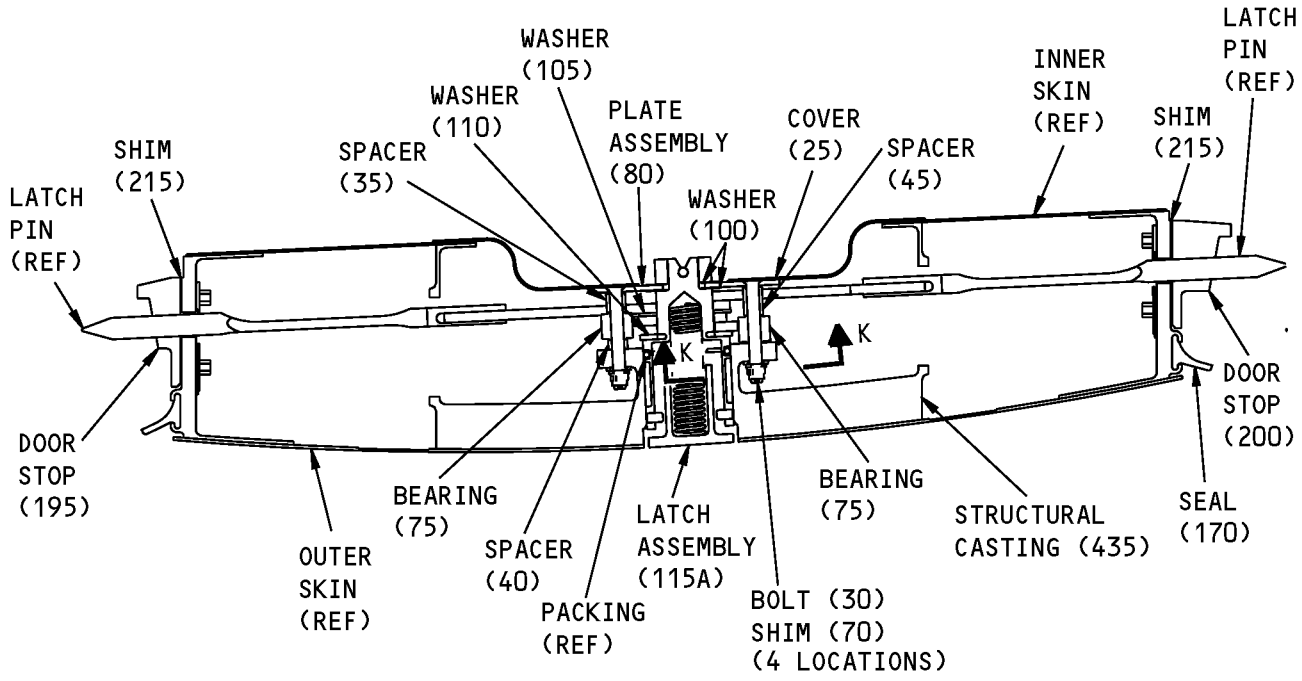


C–C



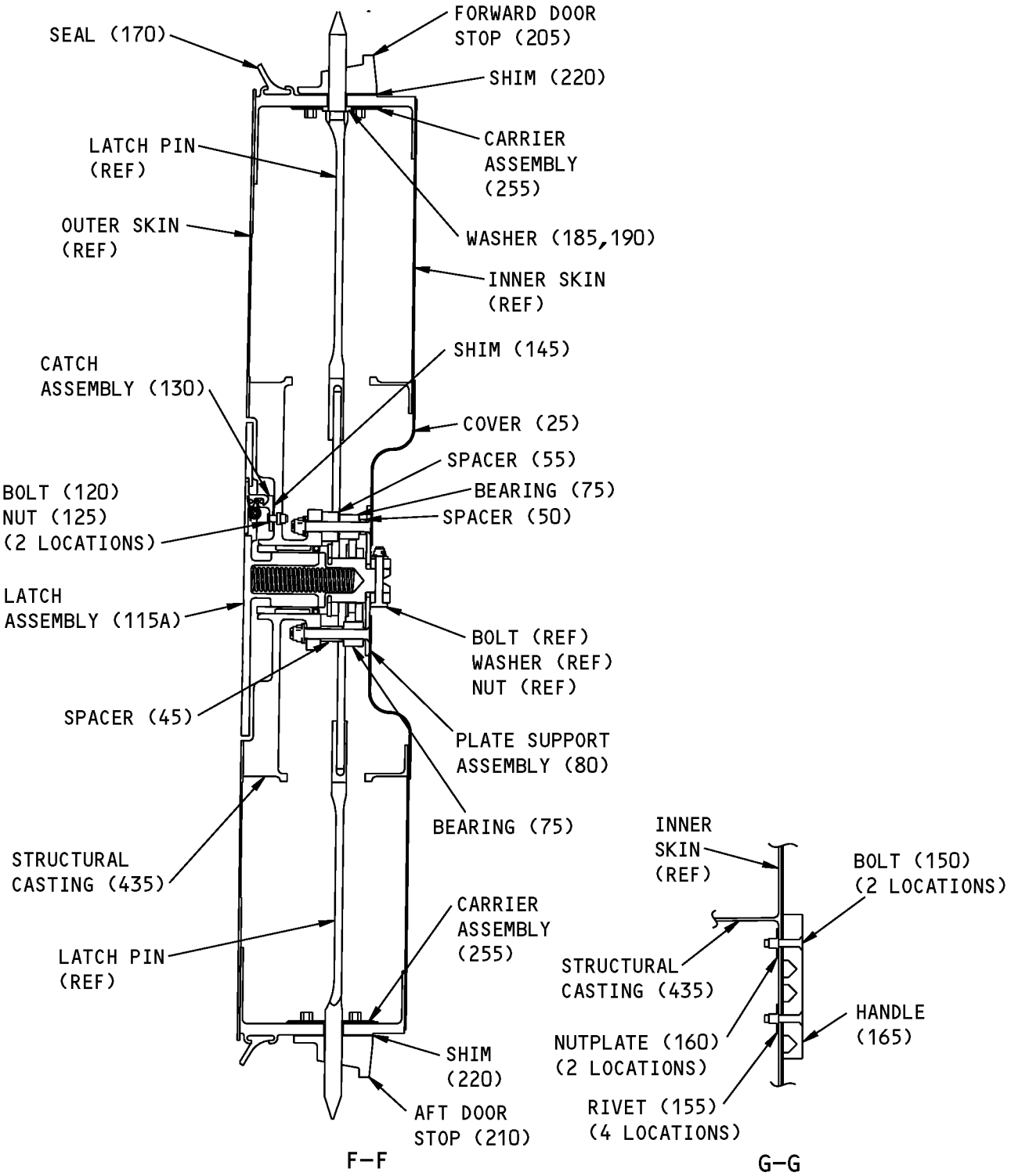
D–D

141A6710-9,-10,-13,-14,-15,-16 Equipment Access Door Assembly
Figure 701 (Sheet 3 of 6)

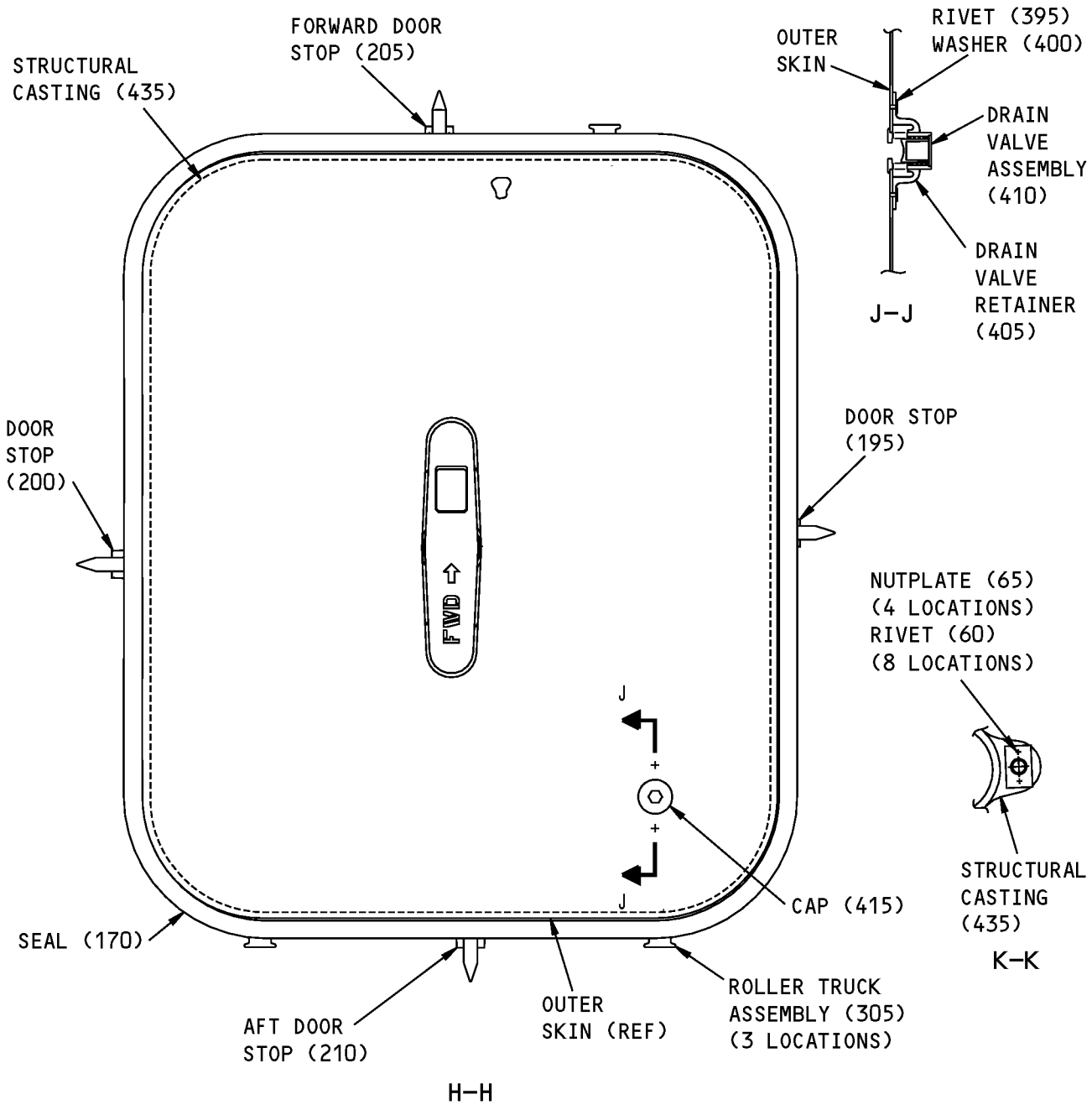


E-E

141A6710-9,-10,-13,-14,-15,-16 Equipment Access Door Assembly
Figure 701 (Sheet 4 of 6)

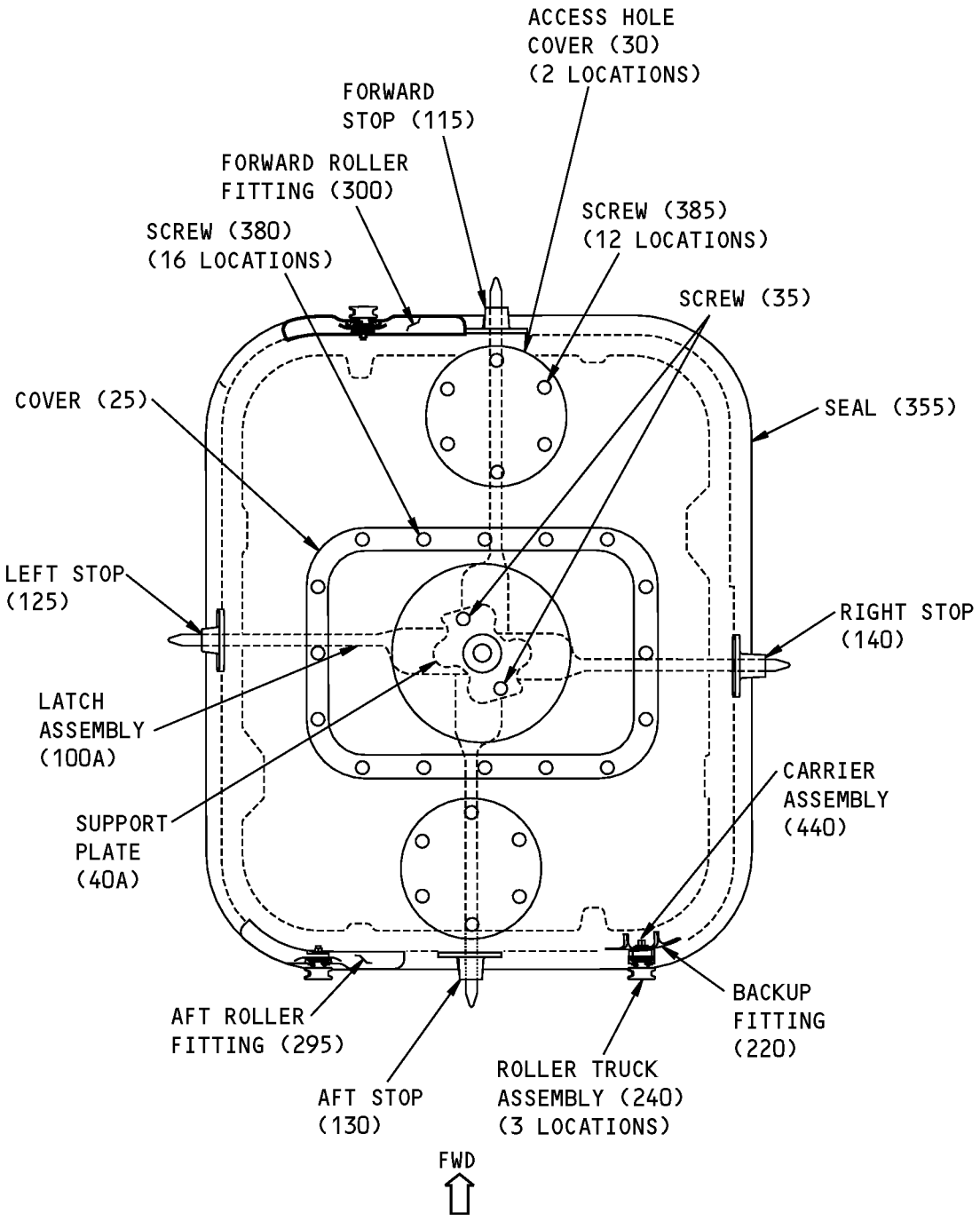


141A6710-9,-10,-13,-14,-15,-16 Equipment Access Door Assembly
Figure 701 (Sheet 5 of 6)

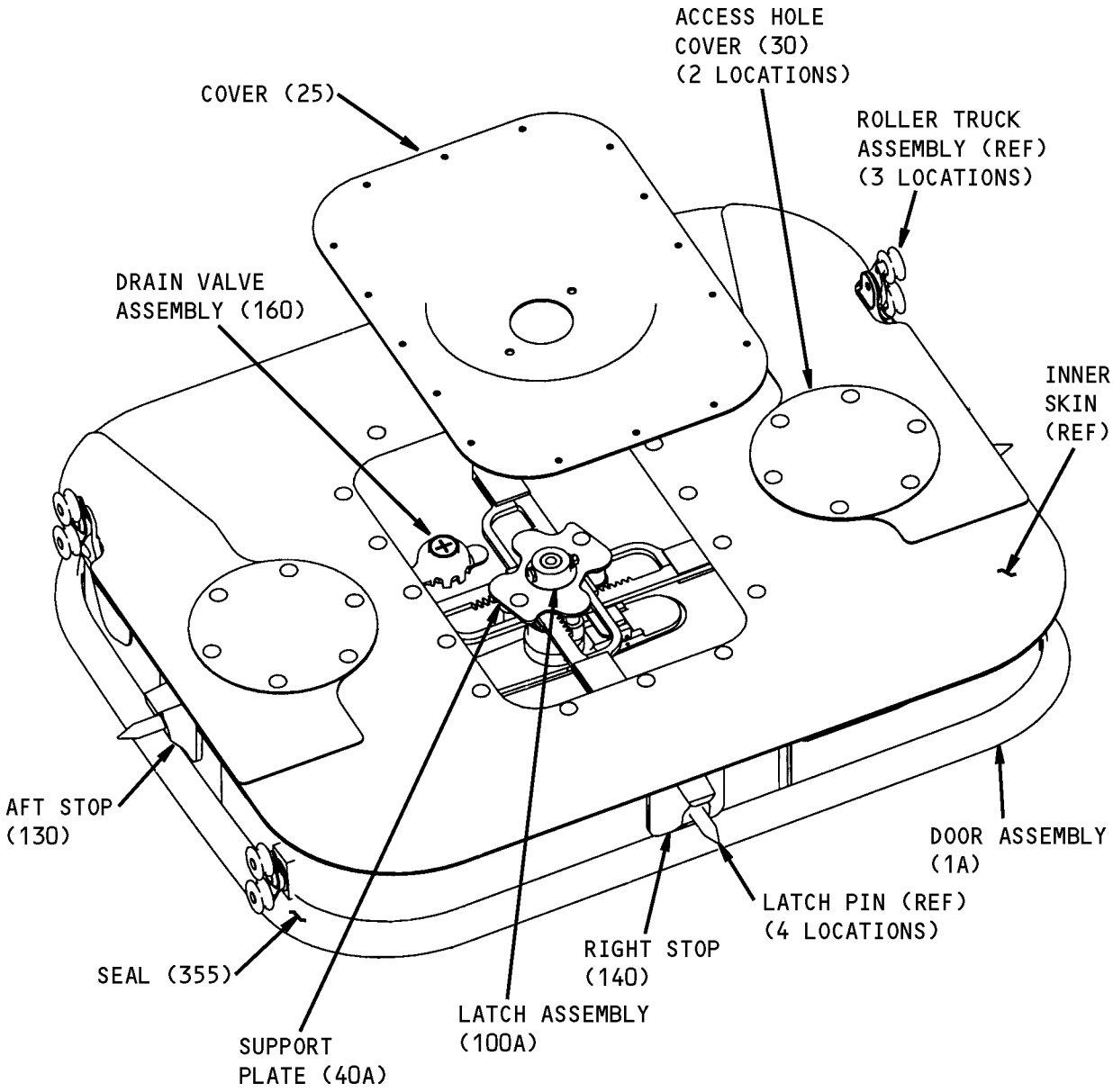


ITEM NUMBERS REFER TO IPL FIG. 1

141A6710-9,-10,-13,-14,-15,-16 Equipment Access Door Assembly
Figure 701 (Sheet 6 of 6)

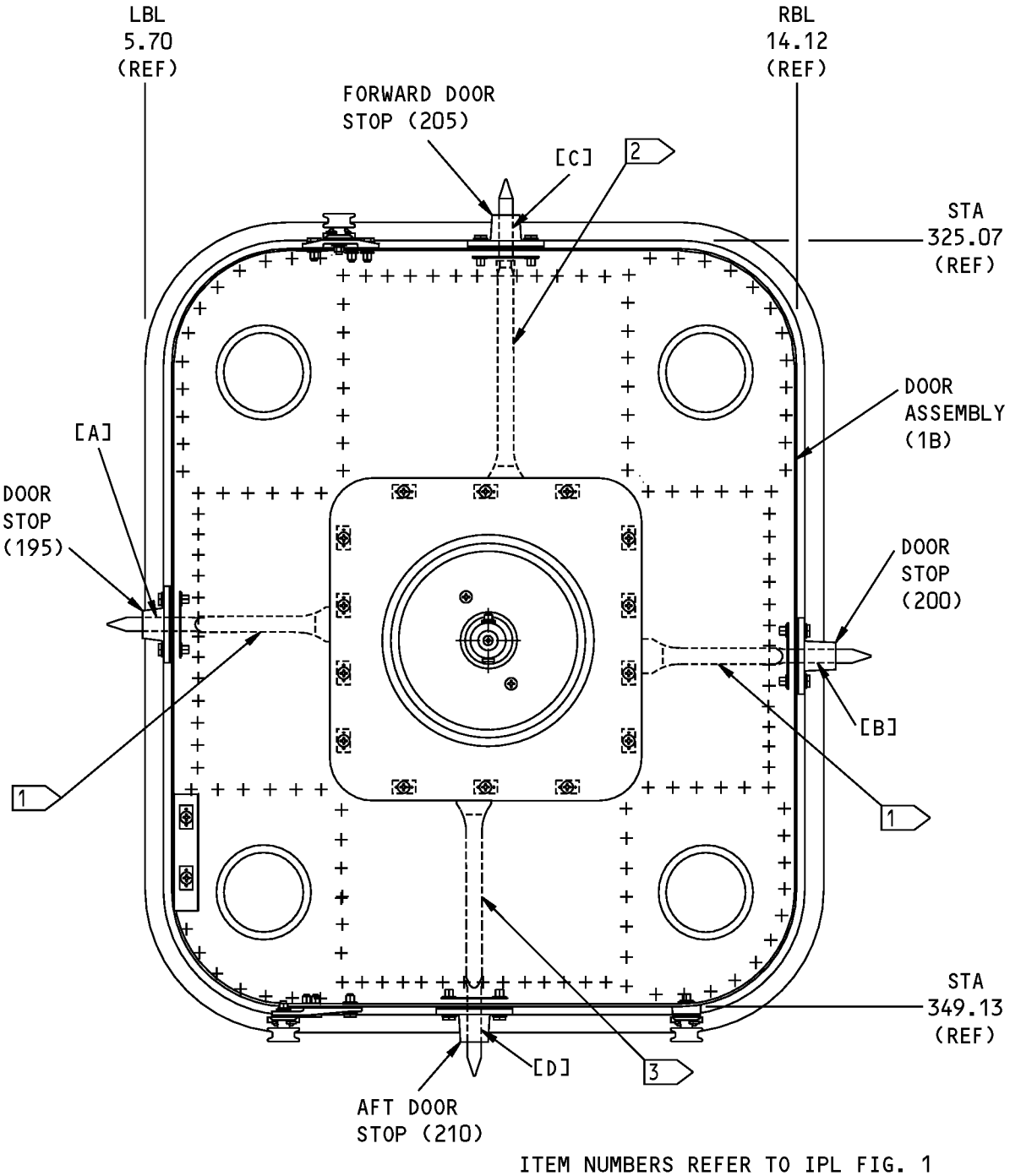


141A6710-11,-12 Equipment Access Door Assembly
Figure 702 (Sheet 1 of 2)



ITEM NUMBERS REFER TO IPL FIG. 2

141A6710-11,-12 Equipment Access Door Assembly
Figure 702 (Sheet 2 of 2)



141A6710-9,-10,-13,-14,-15,-16 Equipment Access Door Assembly Fits and Clearances
Figure 801 (Sheet 1 of 2)

REF LETTER	REF IPL	DESIGN DIMENSION*				SERVICE WEAR LIMIT*		
	ITEM NO. FIG. 1	DIMENSION		ASSEMBLY CLEARANCE		DIMENSION		MAXIMUM CLEARANCE
		MIN	MAX	MIN	MAX	MIN	MAX	
[A]	ID 195	0.448	0.453	0.010	0.020		0.457	0.025
	OD 1	0.433	0.438			0.432		
[B]	ID 200	0.448	0.453	0.010	0.020		0.457	0.025
	OD 1	0.433	0.438			0.432		
[C]	ID 205	0.448	0.453	0.010	0.020		0.457	0.025
	OD 2	0.433	0.438			0.432		
[D]	ID 210	0.448	0.453	0.010	0.020		0.457	0.025
	OD 3	0.433	0.438			0.432		

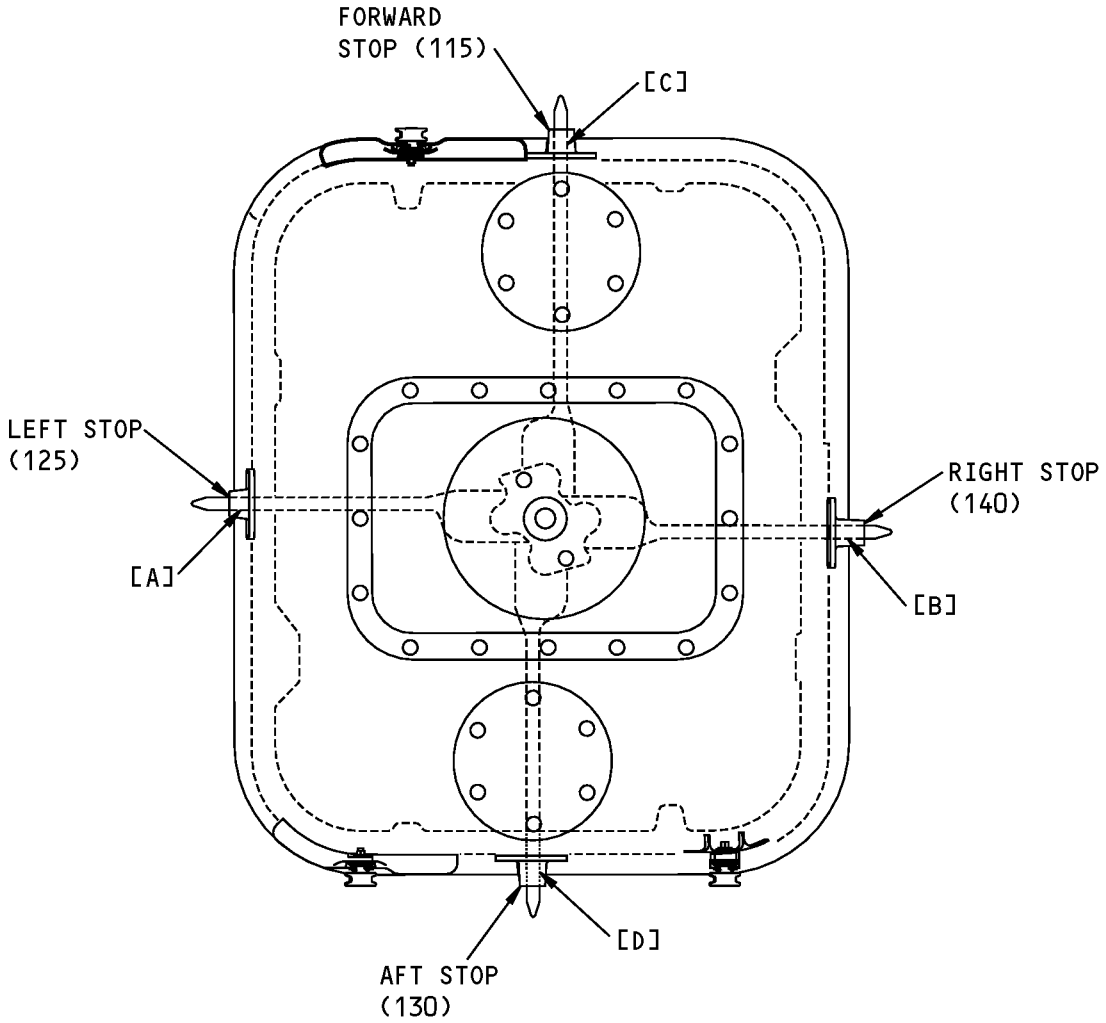
* ALL DIMENSIONS ARE IN INCHES

1 > 110620-1, LATCH PIN

2 > 110621-1, LATCH PIN

3 > 110623-1, LATCH PIN

141A6710-9,-10,-13,-14,-15,-16 Equipment Access Door Assembly Fits and Clearances
Figure 801 (Sheet 2 of 2)



ITEM NUMBERS REFER TO IPL FIG. 2

141A6710-11,-12 Equipment Access Door Assembly Fits and Clearances
Figure 802 (Sheet 1 of 2)

REF LETTER	REF IPL ITEM NO. FIG. 2	DESIGN DIMENSION*				SERVICE WEAR LIMIT*		
		DIMENSION		ASSEMBLY CLEARANCE		DIMENSION		MAXIMUM CLEARANCE
		MIN	MAX	MIN	MAX	MIN	MAX	
[A]	ID 125 OD 1	0.448 0.433	0.453 0.438	0.010	0.020			
[B]	ID 140 OD 1	0.448 0.433	0.453 0.438	0.010	0.020			
[C]	ID 115 OD 2	0.448 0.433	0.453 0.438	0.010	0.020			
[D]	ID 130 OD 3	0.448 0.433	0.453 0.438	0.010	0.020			

* ALL DIMENSIONS ARE IN INCHES

1 > 110620-1, LATCH PIN

2 > 110621-1, LATCH PIN

3 > 110623-1, LATCH PIN

141A6710-11,-12 Equipment Access Door Assembly Fits and Clearances
Figure 802 (Sheet 2 of 2)

REF IPL		NAME	TORQUE*	
FIG. NO.	ITEM NO.		POUND-INCHES	POUND-FEET
1	415	Cap	10-15	
2	165	Cap	10-15	

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

Torque Table
Figure 803

(NOT APPLICABLE)

ILLUSTRATED PARTS LIST

1. Introduction

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

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

1 2 3 4 5 6 7

. Assembly

. Attaching parts for assembly

. . Detail parts for assembly

. . Subassembly

. . Attaching parts for subassembly

. . . Detail parts for subassembly

. . . Sub-subassembly

. . . Attaching parts for subassembly

. . . . . Details parts for sub-subassembly

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

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

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

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

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

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

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

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

H. Interchangeable Parts

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

VENDOR CODES

Code	Name
06725	AIR INDUSTRIES CORPORATION 12570 KNOTT STREET GARDEN GROVE, CALIFORNIA 92641-3932 FORMERLY AIR INDUSTRIES OF CALIF IN GARDENA, CALIF.
0PTK6	SPS TECHNOLOGIES INC AEROSPACE PRODUCTS DIV 5195 W 4700 SALT LAKE CITY, UTAH 94118 SEE V56878 SPS TECHNOLOGIES INC
11815	CHERRY AEROSPACE FASTENERS DIV OF TEXTRON 1224 EAST WARNER AVENUE PO BOX 2157 SANTA ANA, CALIFORNIA 92707-0157 FORMERLY IN LOS ANGELES, CALIF , FORMERLY CHERRY FASTENERS TOWNSEND DIV OF TEXTRON INC V71087
15653	ALCOA GLOBAL FASTENERS INC DIV KAYNAR PRODUCTS 800 S STATE COLLEGE BLVD FULLERTON, CALIFORNIA 92831-3001 FORMERLY VK6405 MICRODOT AEROSP LTD; FORMERLY KAYNAR TECH FORMERLY FAIRCHILD FASTENERS KAYNAR DIV
21335	TIMKEN US CORPORATION DIV FAFNIR 336 MECHANIC STREET LEBANON, NH 03766-0267 FORMERLY FAFNIR BRG AND TEXTRON INC FAFNIR DIV IN NEW BRITAIN, CONNECTICUT ; FORMERLY TORRINGTON CO THE SPECIAL PRODUCTS DIV SUB OF THE INGERSOLL-RAND CO V8D210 FORMERLY TORRINGTON CO FAFNIR BEARING DIV IN TORRINGTON, CT

Code	Name
29372	ALCOA GLOBAL FASTENERS INC DBA ALCOA FASTENERS SYSTEMS DIV 3000 WEST LOMITA BLVD TORRANCE CALIFORNIA 90505-5103 FORMERLY CALFAX INC V11907; NEWTON INSERT CO V98004;REXNORD INC SPECIALTY FASTERNER DIV AND DELRON CO V82831; REXNORD INC TRIDAIR IND; FORMERLY FAIRCHAIDL IND INC
38443	MRC BEARINGS 402 CHANDLER STREET JAMESTOWN, NEW YORK 14701-3802 FORMERLY MARLIN-ROCKWELL CORP DIV TRW AND TRW INC
43991	FAG BEARING INCORPORATED 118 HAMILTON AVENUE STAMFORD, CONNECTICUT 06904 FORMERLY NORMA-HOFFMAN BEARING CORPORATION FORMERLY NORMA FAG BEARINGS CORPORATION
50744	KIRKHILL-TA CO/SFS DIV 300 E CYPRESS STREET BREA, CALIFORNIA 92821-4007 FORMERLY SFS IND; FORMERLY BURKE RUBBER SFS DIV
52828	REPUBLIC FASTENER MFG CORP 1300 RANCHO CONEJO BLVD NEWBURY PARK, CALIFORNIA 91320-1405 FORMERLY IN SYLMAR, CALIFORNIA
56878	SPS TECHNOLOGIES INC AEROSPACE AND INDUSTRIAL PRODUCTS DIV 301 HIGHLAND AVE JENKINTOWN, PENNSYLVANIA 19046 FORMERLY STANDARD PRESSED STEEL FORMERLY IN SALT LAKE, UTAH
60980	MEGGITT-OREGON INC DBA MEGGITT SILICONE PROD DIV MSP 2010 LAFAYETTE AVE P.O. BOX 887 MCMINNVILLE, OREGON 97128 FORMERLY ELASTOMERIC SILICON PRODUCTS

Code	Name
62554	SIMMONDS MECAERO FASTENERS INC 1734 SEQUOIA AVENUE ORANGE, CALIFORNIA 92668
72962	HARVARD INDUSTRIES INC 3 WERNER WAY SUITE 210 LEBANON, NEW JERSEY 08833 FORMERLY ESNA V7A079 FORMERLY ELASTIC STOP NUT IN UNION, NJ
73197	HI-SHEAR TECHNOLOGY CORP 2600 SKYPARK DRIVE TORRANCE, CALIFORNIA 90509
80539	SPS TECHNOLOGIES INC DIV AERPSOACE - SANTA ANA 2701 SOUTH HARBOR BOULEVARD SANTA ANA, CALIFORNIA 92704-5803 FORMERLY NUTT-SHEL DIV OF SPC WESTERN CO V80539 AND STANDARD PRESSED STEEL WESTERN DIV V17279
83014	HARTWELL CORPORATION 900 SOUTH RICHFIELD ROAD PLACENTIA, CALIFORNIA 92670-6732 FORMERLY V0532B IN LOS ANGELES, CALIFORNIA
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
95760	PROTECTIVE CLOSURES CO. INC. 2150 ELMWOOD AVENUE BUFFALO, NEW YORK 14207-1910

NUMERICAL INDEX

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
102F9201M3		1	20	14
		1	160	2
		2	15	24
102F9201M4		1	65	4
102F9207P3		1	90	2
140N2020-1		1	425	1
		2	175	1
140N2021-1		1	405	1
		2	155	1
140N2022-1		1	410	1
		2	160	1
140N2022-2		1	430	1
		2	180	1
140N2022-3		1	420	1
		2	170	1
140N2022-4		1	415	1
		2	165	1
141A6702-1		1	165	1
141A6710-10		1	1C	RF
141A6710-11		1	1F	RF
		2	1A	RF
141A6710-12		1	1G	RF
		2	1B	RF
141A6710-13		1	1D	RF
141A6710-14		1	1E	RF
141A6710-15		1	1H	RF
141A6710-16		1	1J	RF
141A6710-2		1	220	2
		2	120	2
141A6710-3		1	215	2
		2	135	2
141A6710-4		1	385	1
141A6710-5		1	390	1
141A6710-6		1	145	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
141A6710-7		1	330	1
		2	205	1
141A6710-9		1	1B	RF
141A6711-1		1	435	1
141A6712-1		1	130	1
141A6712-2		1	140	1
141A6712-3		1	135	1
141A6713-10		2	290	1
141A6713-9		2	285	1
141A6714-1		1	25	1
141A6715-1		1	80	1
141A6715-2		1	255	2
141A6715-3		1	230	2
141A6715-4		1	340	1
		2	440	1
141A6715-5		1	270	1
141A6715-6		1	250	1
141A6715-7		1	355	1
		2	455	1
141A6715-8		1	95	1
141A6716-1		1	205	1
		2	115	1
141A6716-2		1	195	1
		2	125	1
141A6716-3		1	210	1
		2	130	1
141A6716-4		1	200	1
		2	140	1
141A6717-1		1	380	2
141A6717-2		2	300	1
141A6717-3		2	295	1
141A6717-4		2	200	1
141A6717-5		2	220	1
141A6718-1		1	305	3
		2	240	3

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
141A6718-2		1	325	1
		2	260	1
63-1658		1	105	1
		2	60	1
63-1658-1		1	110	1
		2	70	1
63-1658-501		1	100	2
		2	390	2
63-9328-2		2	90	1
63-9328-3		1	55	1
65-1263-140		2	40A	1
65-2163-142		2	30	2
65-2163-144		2	25	1
65-45830-139		2	460	4
65-45830-23		2	345	1
65-45830-25		2	315	1
65-45830-26		2	335	1
65-45830-27		2	330	1
65-45830-28		2	325	1
65-45830-29		2	340	1
65-45830-30		2	320	1
65-45830-512		2	485	2
65-45830-61		2	350	1
65-45830-71		2	480	2
69B13433-1		1	320	2
		2	255	2
69B13438-1		1	300	3
		2	195	1
		2	270	2
69B13438-501		1	290	3
		2	190	1
		2	265	2
8100		1	5	4
88D10204-175		1	170	1
		2	355	1

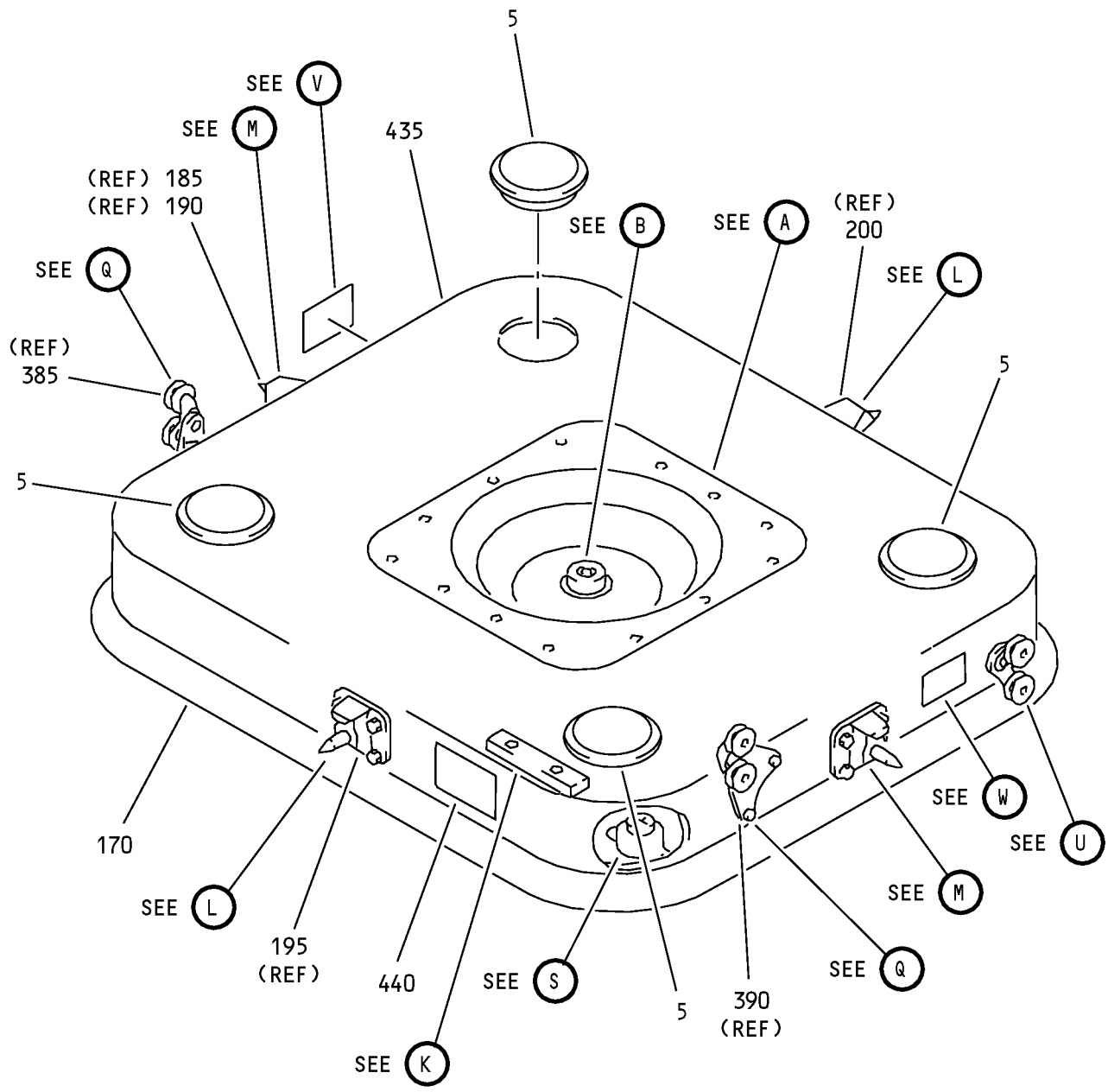
PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
96-048		2	95	4
AN960D146		2	85	4
BAC27DBY187		1	440	1
		2	495	1
BAC27DBY191		1	445	1
		2	490	1
BACB10CG04		1	75A	4
BACB10CG4		1	75	4
		2	65	4
BACB30LU4-26		2	45	4
BACB30NM3K4		1	360	6
BACB30NM3K9		1	175	16
		2	105	16
BACB30NN3K10		1	150	2
BACB30NN3K12		1	280	1
		2	185	1
BACB30NN3K7		1	275	2
		2	225	2
BACB30NT3K3		1	10	16
BACB30VF4K26		1	30	4
BACB30VT5K3		1	120	2
BACN10JC4		2	95	4
BACN10JN3CD		1	20	14
		1	160	2
		2	15	24
BACN10JN4CD		1	65	4
BACN10KB3CFD		1	90	2
BACN10KB3P		2	20	6
BACN10KE3D		2	470	16
BACN10YR3CD		1	295	2
		2	235	2
BACN10ZV5		1	125A	2
BACN11G3A1CD		1	240A	2
		1	265A	4
		1	350A	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	375A	6
		2	450A	1
BACN11G3B1CD		1	245A	2
BACP18BC02A06P		1	310	2
		2	245	2
BACR15BA3D		1	15	28
		1	370	12
		2	10	56
		2	465	32
BACR15BA3D3		1	85	4
		1	235	8
		1	260	8
		1	345	2
		2	395	4
		2	445	2
BACR15BA4D		1	225	4
		1	335	1
		2	310	3
		2	435	1
BACR15BB4D		2	210	1
		2	305	64
BACR15BB5D		2	215	3
		2	275	24
BACR15BB6D		2	280	8
BACR15GE3CW		1	60	8
BACR15GE3CW2		1	155	4
BACR15GE3CW8		1	60C	8
BACR15GF4		2	145	2
BACR15GF4D		1	395	2
BACR15GF6D		2	475	8
BRF100C3D		1	90	2
BRFM20C3D		1	20	14
		1	160	2
		2	15	24
BRFM20C4D		1	65	4

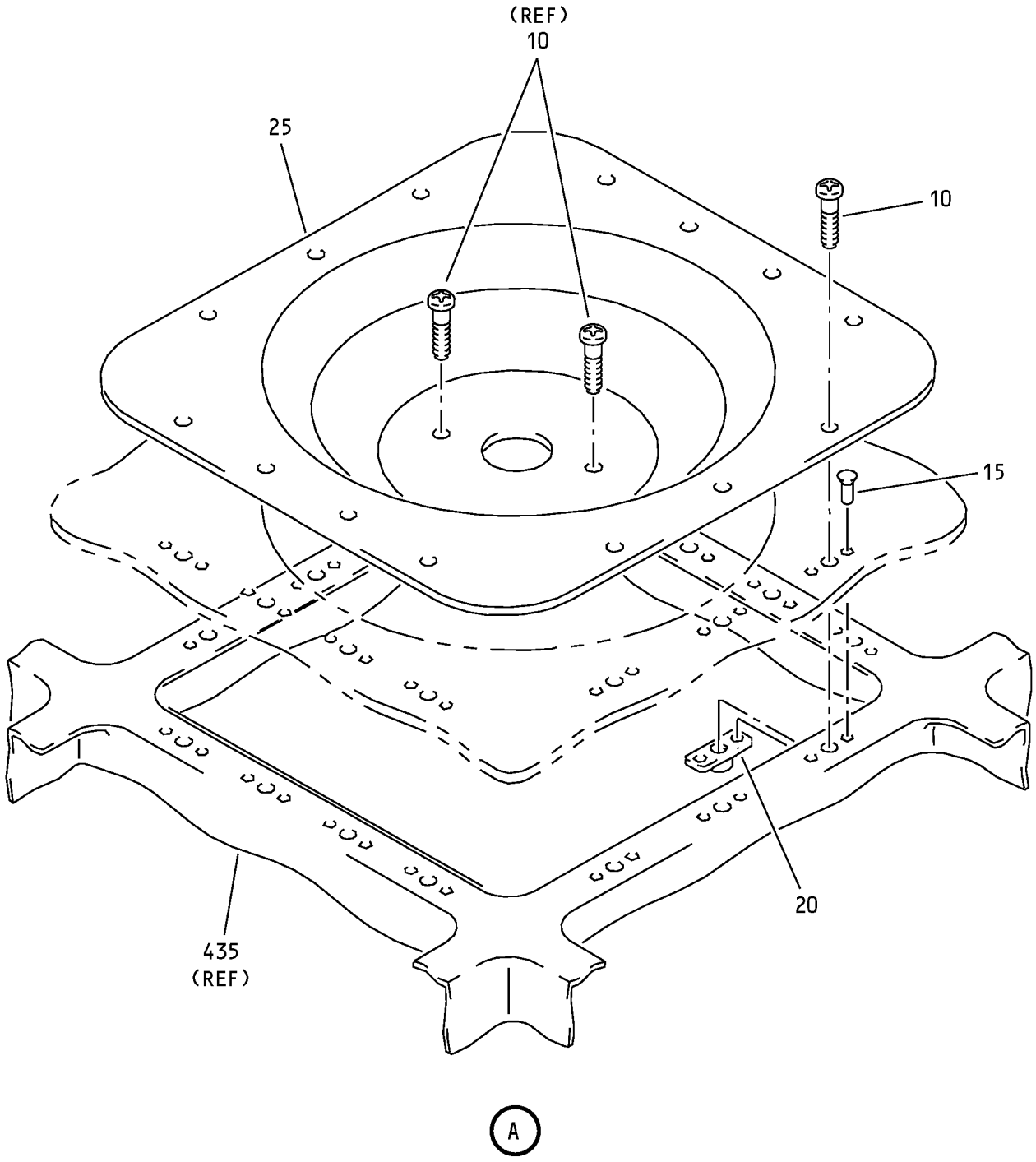
PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BRH10A4		2	95	4
DW4K2-1		1	75	4
		2	65	4
F51604-3		1	90	2
F51754-3		2	470	16
FBL10091C3-1		1	240	2
		1	265	4
		1	350	1
		1	375	6
		1	375B	6
		2	450	1
FBL10093C3-1		1	245	2
GDW4K2FS428		1	75	4
		2	65	4
GDW4K2SD610		1	75	4
		2	65	4
GDW4K2TT		1	75	4
		2	65	4
H10-4BAC		2	95	4
H52732-3CD		1	295	2
		2	235	2
H759-135		2	100A	1
HA247-5		1	115A	1
HST10AG5-3		1	120	2
		1	120	2
		1	120	2
		1	120	2
KFN587-5BAC		1	125A	2
MF51637-3		1	20	14
		1	160	2
		2	15	24
MF51637-4		1	65	4
MF53050-3CD		1	20	14
		1	160	2
		2	15	24

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
MF53050-4CD		1	65	4
MS20392-2R17		1	315	2
		2	250	2
MS27253F1		1	450	1
		2	375	1
NAS1149D0363J		1	180	16
		1	285	2
		1	365	6
		2	110	16
		2	230	2
NAS1149DN432J		1	400	2
		2	150	2
NAS1149E0716P		1	190	AR
NAS1149E0763P		1	185	AR
NAS1195DD4XH		1	70	4
NAS221-8		2	385	12
NAS43DD4-12		2	75	1
NAS43DD4-12FC		1	40	1
NAS43DD4-24		2	55	1
NAS43DD4-24FC		1	35	1
NAS43DD4-36		2	50	2
NAS43DD4-36FC		1	45	2
NAS43DD4-9		2	80	1
NAS43DD4-9FC		1	50	1
NAS623-3-2		2	35	2
		2	380A	16
NS103193-02		2	470	16
NS202101-048		2	95	4
NS202478-02		1	90	2
NS202487-02		1	20	14
		1	160	2
		2	15	24
NS202487-048		1	65	4
PLH53CD		1	295	2
		2	235	2

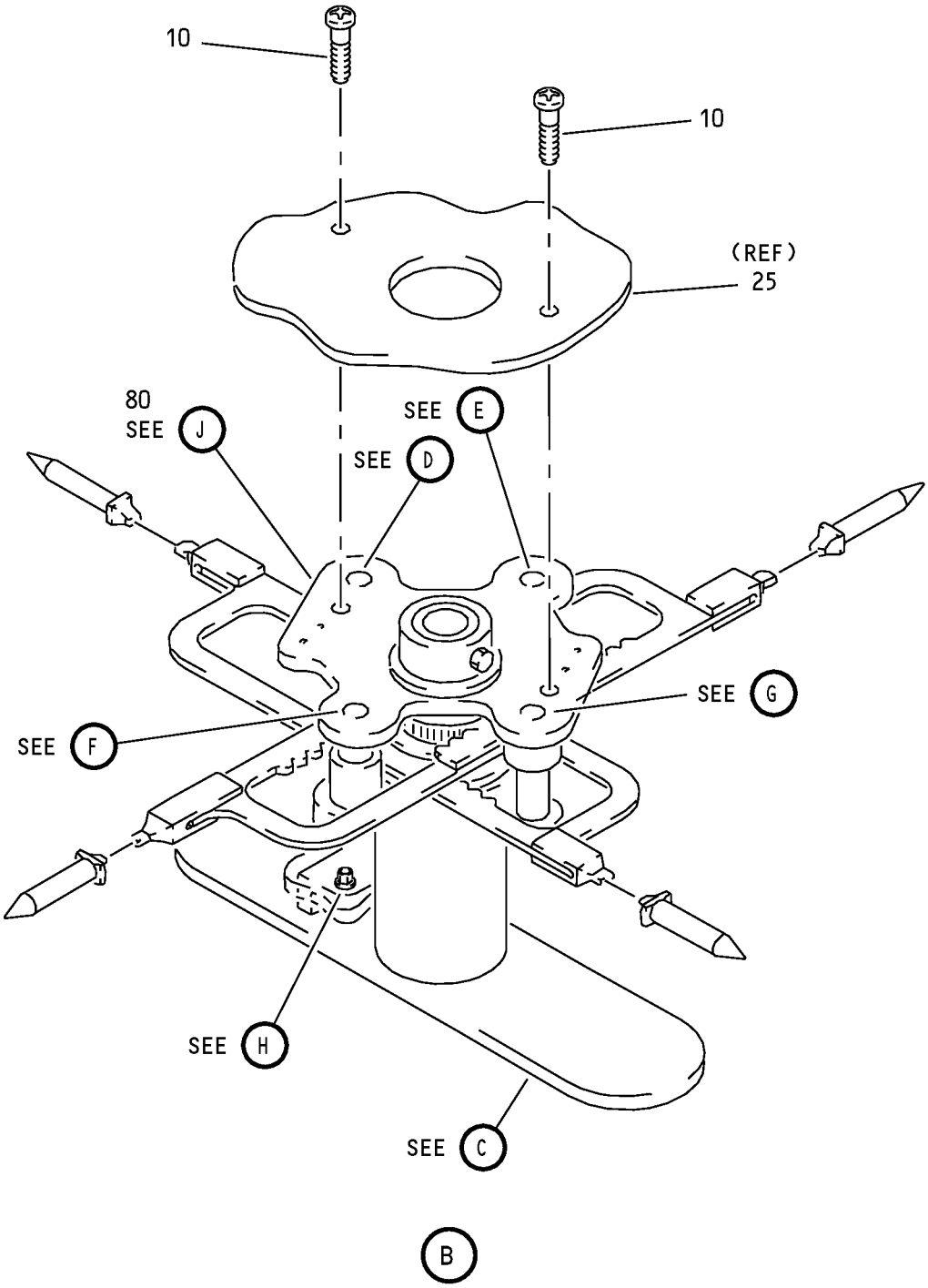
PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
RMLH9075-4W		2	95	4
RV1241W3-8		1	60B	8
S140T263-175		1	170	1
		2	355	1
SF15-120-175		1	170	1
		2	355	1
T6S428J		2	95	4
T8301C428CD		1	65	4
VN303A048		2	95	4



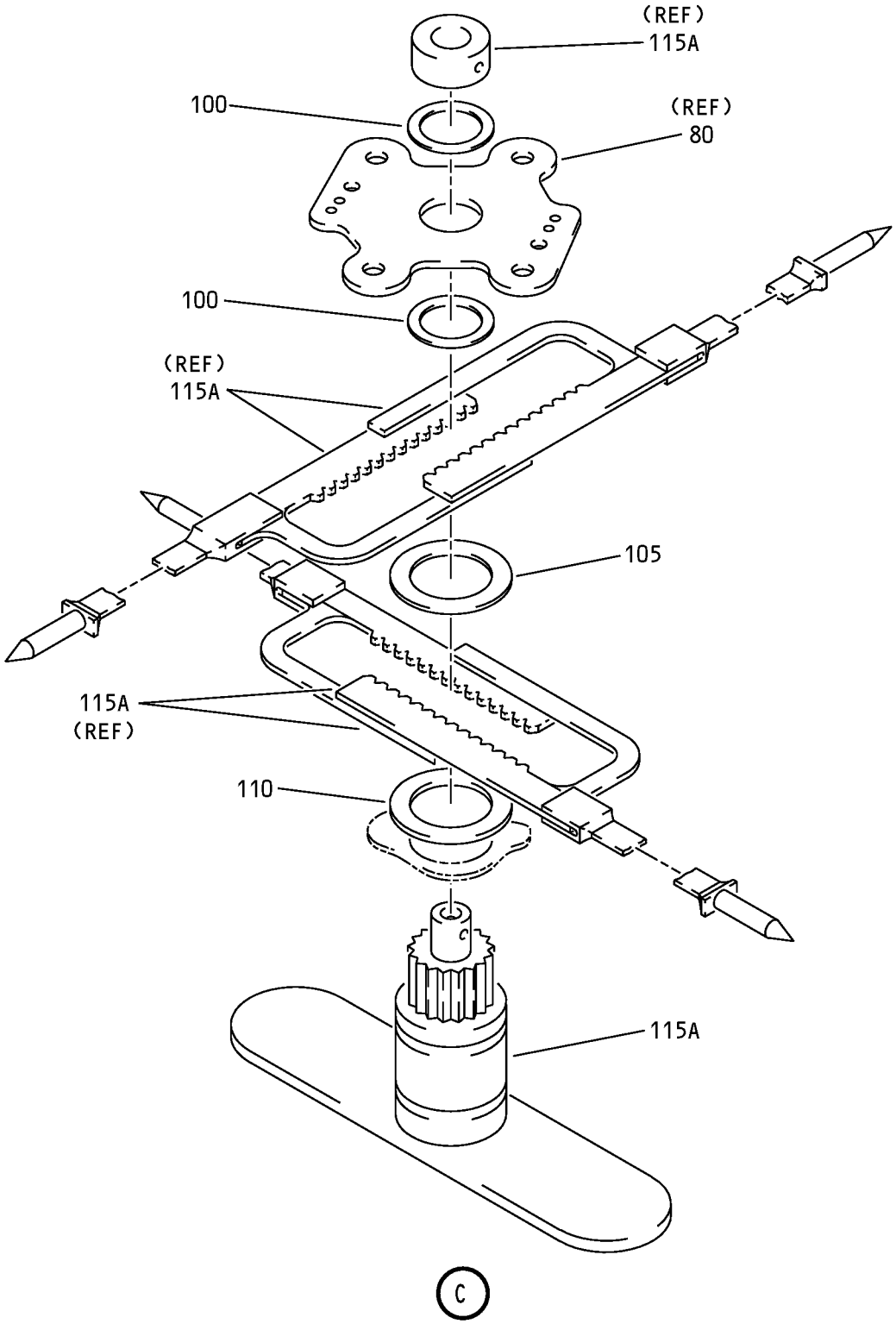
Equipment Access Door Assembly
IPL Figure 1 (Sheet 1 of 12)



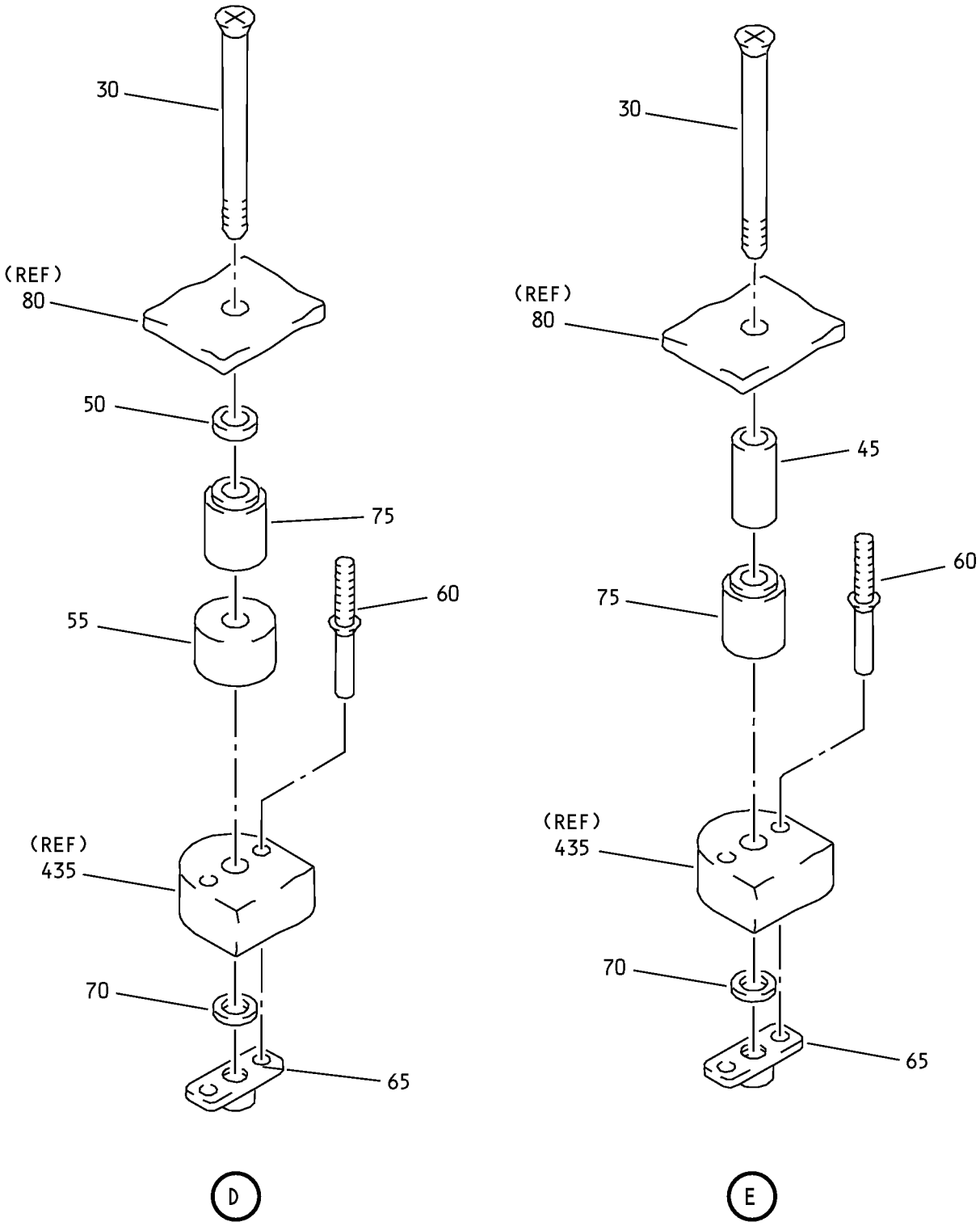
Equipment Access Door Assembly
IPL Figure 1 (Sheet 2 of 12)



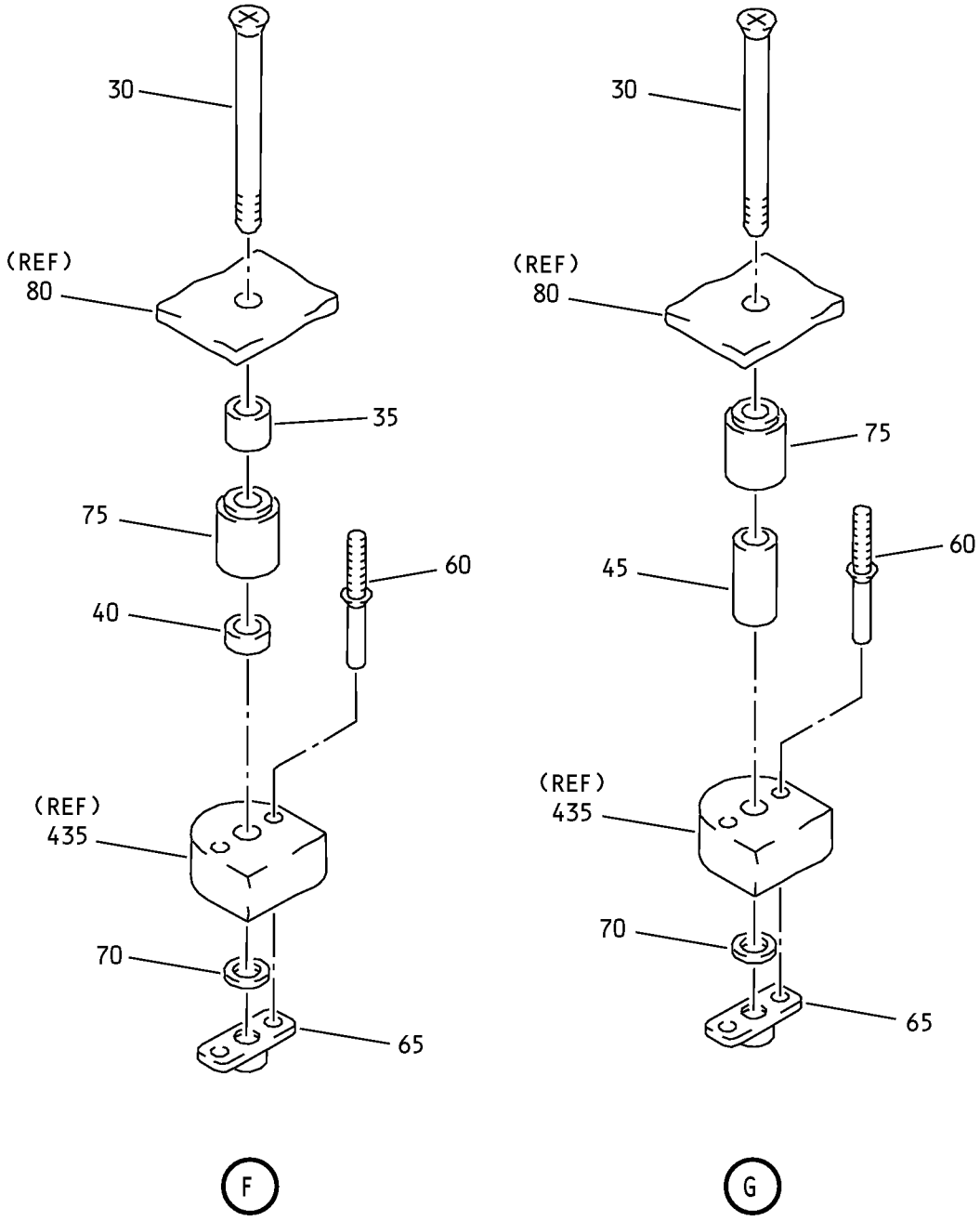
Equipment Access Door Assembly
IPL Figure 1 (Sheet 3 of 12)



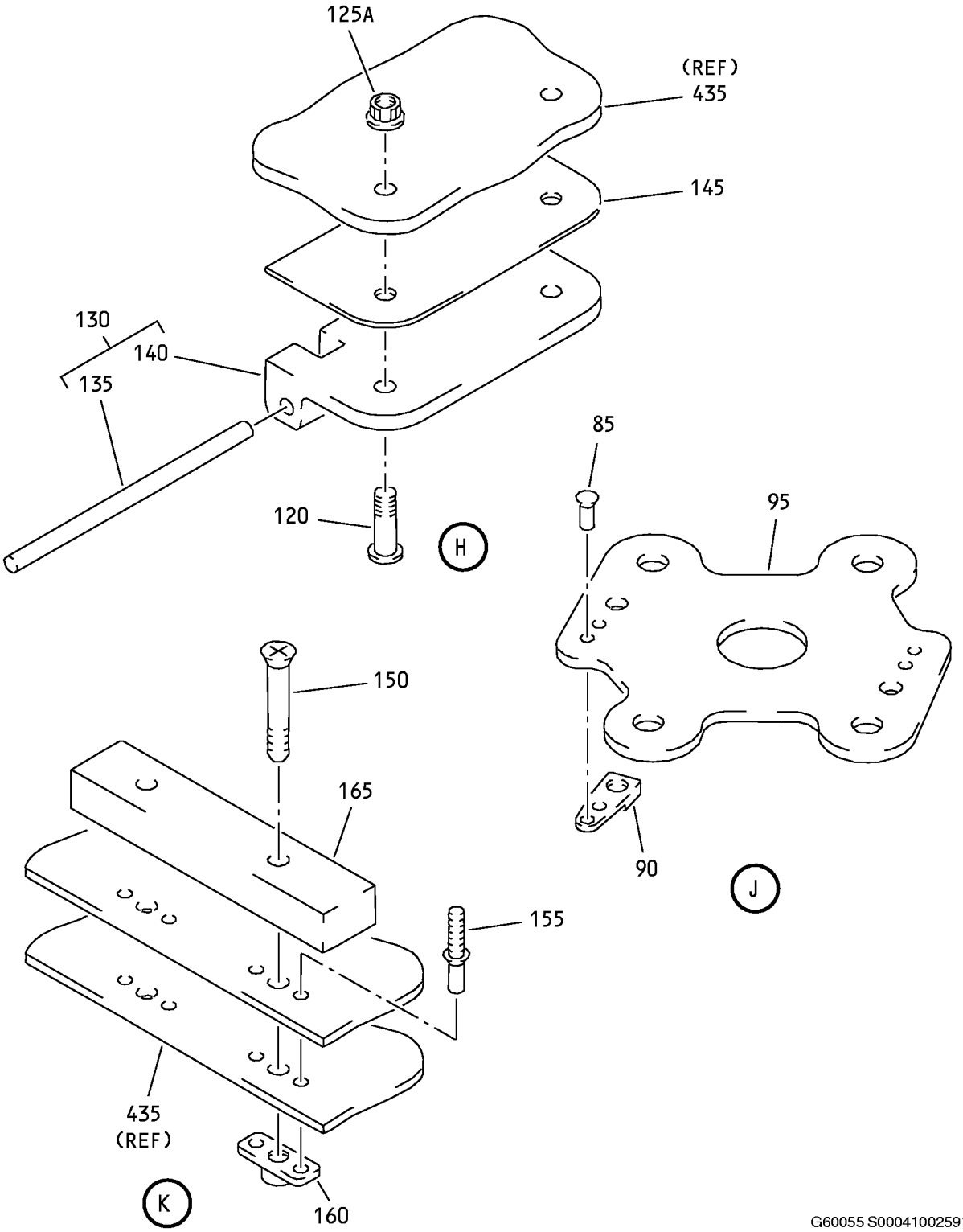
Equipment Access Door Assembly
IPL Figure 1 (Sheet 4 of 12)



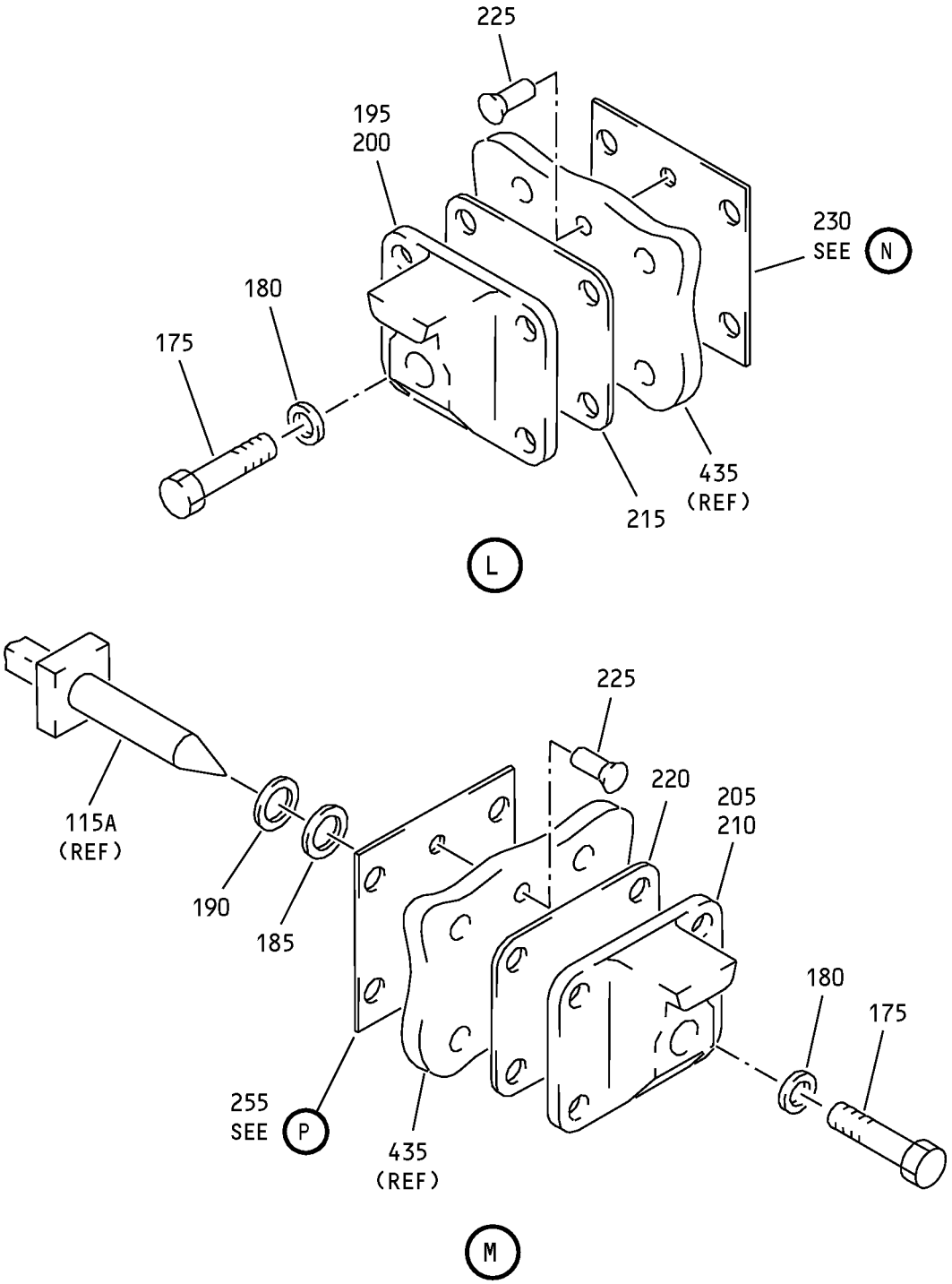
Equipment Access Door Assembly
IPL Figure 1 (Sheet 5 of 12)



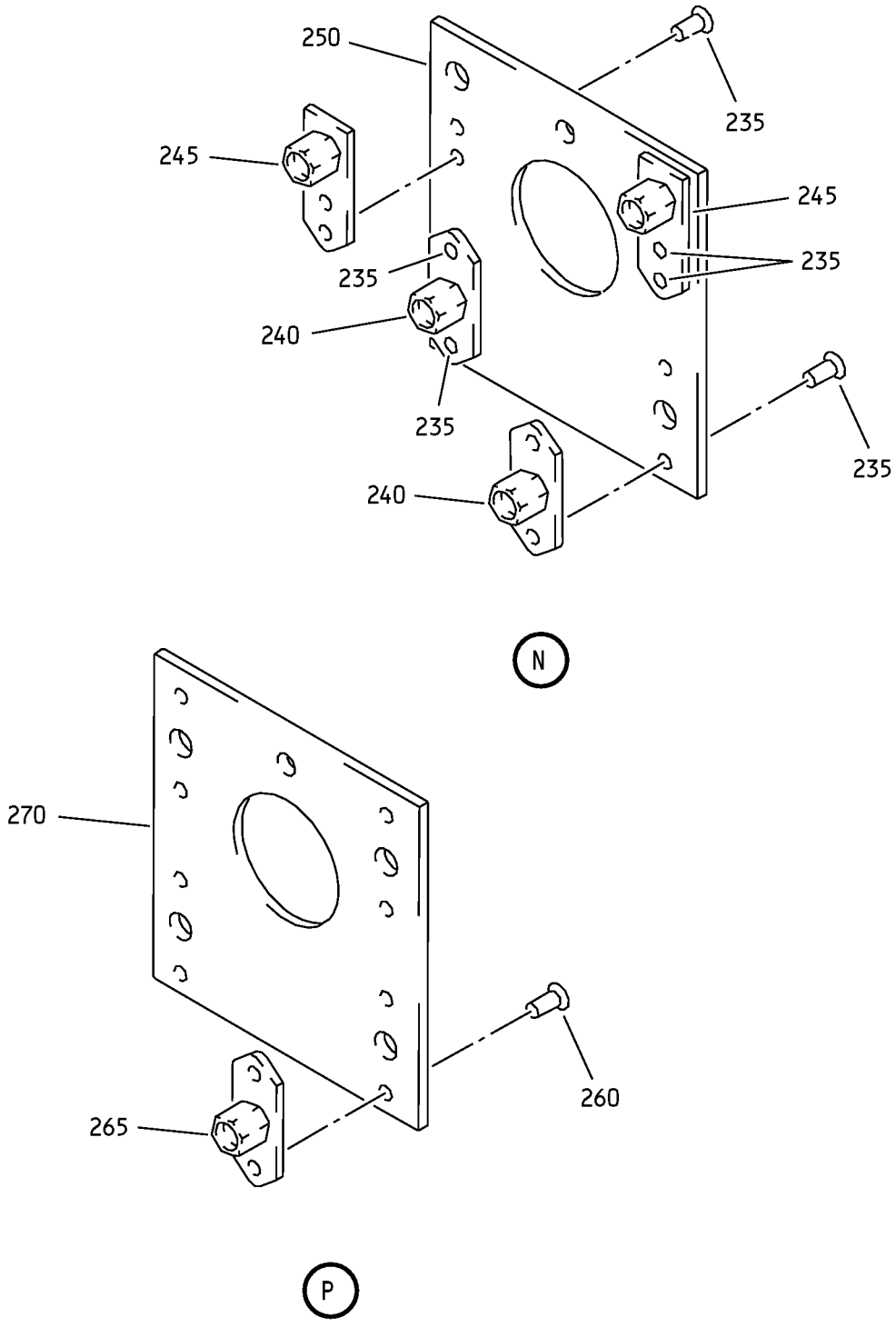
Equipment Access Door Assembly
IPL Figure 1 (Sheet 6 of 12)



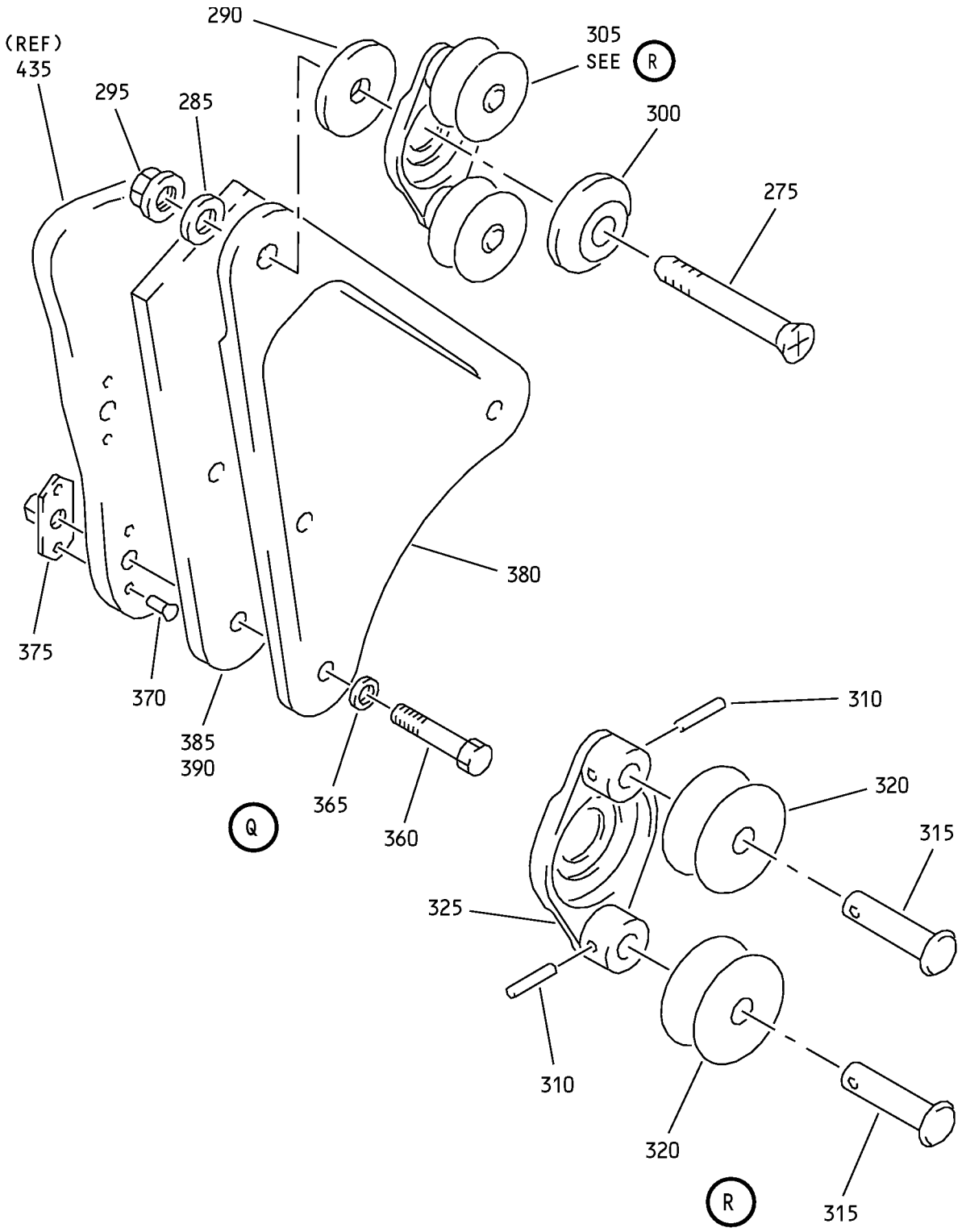
Equipment Access Door Assembly
IPL Figure 1 (Sheet 7 of 12)



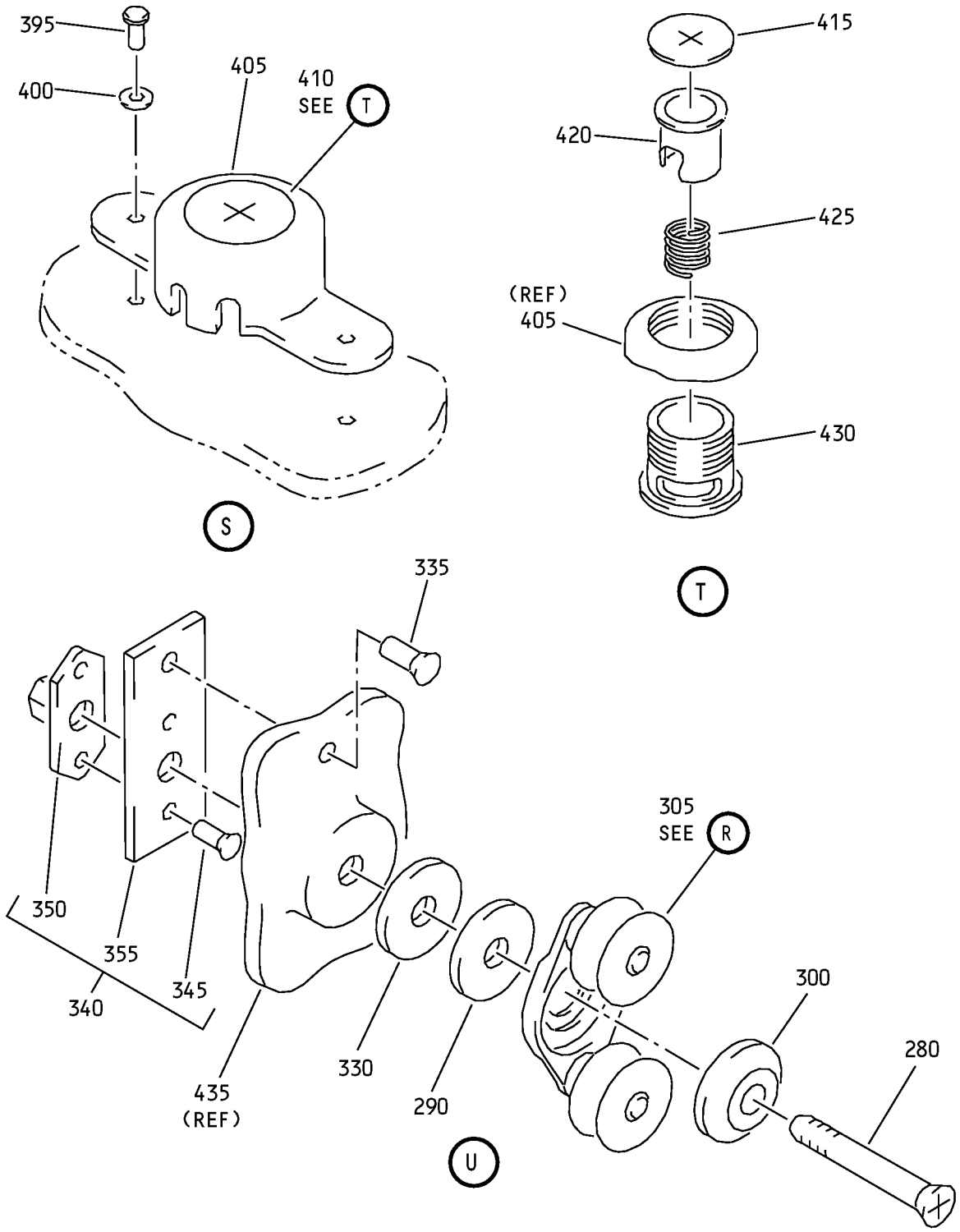
Equipment Access Door Assembly
IPL Figure 1 (Sheet 8 of 12)



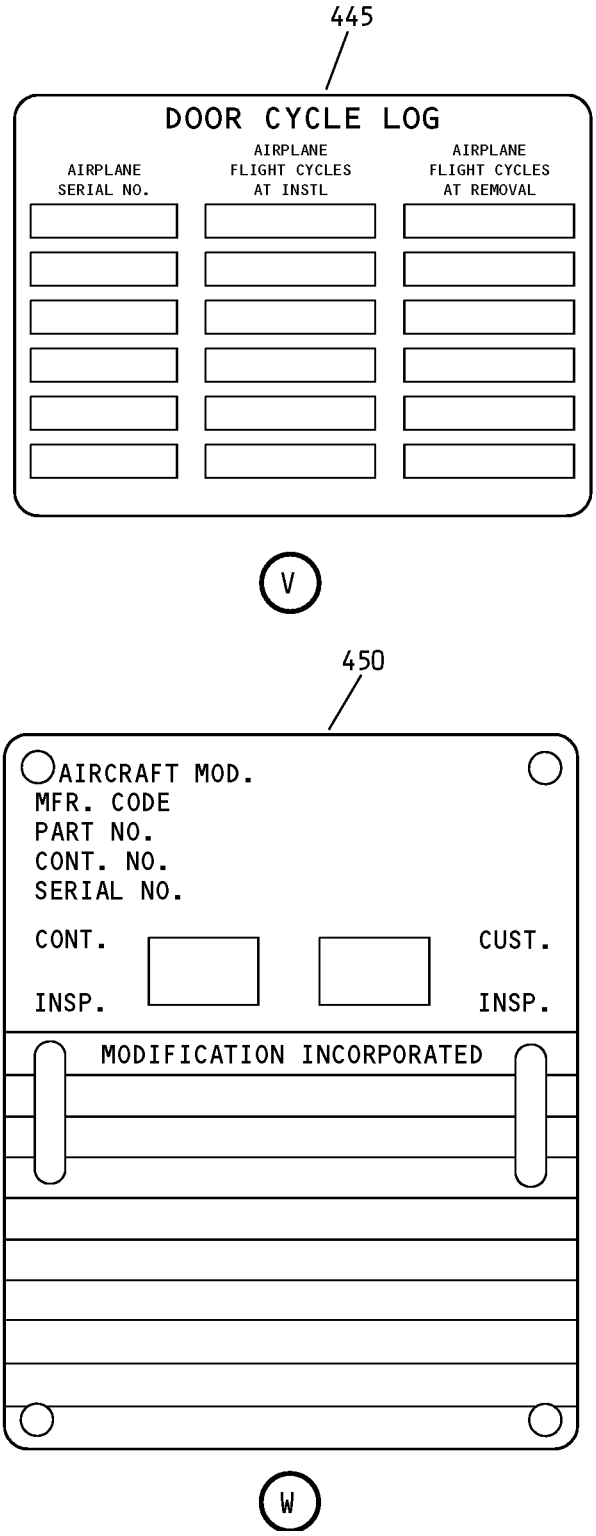
Equipment Access Door Assembly
IPL Figure 1 (Sheet 9 of 12)



Equipment Access Door Assembly
IPL Figure 1 (Sheet 10 of 12)



Equipment Access Door Assembly
IPL Figure 1 (Sheet 11 of 12)



Equipment Access Door Assembly
IPL Figure 1 (Sheet 12 of 12)

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
–1A	141A6710-1		DELETED		
–1B	141A6710-9		DOOR ASSY-EQPT ACCESS	A	RF
–1C	141A6710-10		DOOR ASSY-EQPT ACCESS	B	RF
–1D	141A6710-13		DOOR ASSY-EQPT ACCESS	C	RF
–1E	141A6710-14		DOOR ASSY-EQPT ACCESS	D	RF
–1F	141A6710-11		DOOR ASSY-EQPT ACCESS (FOR DETAILS SEE FIG. 2)	E	RF
–1G	141A6710-12		DOOR ASSY-EQPT ACCESS (FOR DETAILS SEE FIG. 2)	F	RF
–1H	141A6710-15		DOOR ASSY-EQUIP ACCESS	G	RF
–1J	141A6710-16		DOOR ASSY-EQUIP ACCESS	H	RF
5	8100		. CAPLUG (V95760)	A-D, G, H	4
10	BACB30NT3K3		. BOLT	A-D, G, H	16
15	BACR15BA3D		. RIVET (SIZE DETERMINED ON INST)	A-D, G, H	28
20	BRFM20C3D		. NUTPLATE (V52828) (SPEC BACN10JN3CD) (OPT 102F9201M3 (V72962)) (OPT NS202487-02 (V80539)) (OPT MF51637-3 (V15653)) (OPT MF53050-3CD (V15653))	A-D, G, H	14
25	141A6714-1		. COVER	A-D, G, H	1
30	BACB30VF4K26		. BOLT	A-D, G, H	4
35	NAS43DD4-24FC		. SPACER	A-D, G, H	1
40	NAS43DD4-12FC		. SPACER	A-D, G, H	1
45	NAS43DD4-36FC		. SPACER	A-D, G, H	2
50	NAS43DD4-9FC		. SPACER	A-D, G, H	1
55	63-9328-3		. SPACER	A-D, G, H	1
60	BACR15GE3CW		. RIVET (SIZE DETERMINED ON INST)	A, B	8
–60A	BACR15GE3CW		DELETED		
–60B	RV1241W3-8		. RIVET (OPT ITEM 60C)	C, D, G, H	8

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
–60C	BACR15GE3CW8		. RIVET (OPT ITEM 60B)	C, D, G, H	8
65	BRFM20C4D		. NUTPLATE (V52828) (SPEC BACN10JN4CD) (OPT T8301C428CD (V11815)) (OPT 102F9201M4 (V72962)) (OPT NS202487-048 (V80539)) (OPT MF51637-4 (V15653)) (OPT MF53050-4CD (V15653))	A-D, G, H	4
70	NAS1195DD4XH		. SHIM	A-D, G, H	4
75	GDW4K2SD610		. BEARING (V83086) (SPEC BACB10CG4) (OPT GDW4K2TT (V43991)) (OPT GDW4K2FS428 (V21335)) (OPT DW4K2-1 (V38443))	A, B, G, H	4
–75A	BACB10CG04		. BEARING	C, D	4
80	141A6715-1		. PLATE ASSY-SPRT	A-D, G, H	1
85	BACR15BA3D3		. . RIVET	A-D, G, H	4
90	BRF100C3D		. . NUTPLATE (V52828) (SPEC BACN10KB3CFD) (OPT NS202478-02 (V80539)) (OPT 102F9207P3 (V72962)) (OPT F51604-3 (V15653))	A-D, G, H	2
95	141A6715-8		. . PLATE	A-D, G, H	1
100	63-1658-501		. WASHER (MAKE FROM SH NYLON FM10001 0.015 IN 1.50 IN 1.50 IN)	A-D, G, H	2
105	63-1658		. WASHER (MAKE FROM SH NYLON FM10001 0.06 IN 2.0 IN 2.0 IN)	A-D, G, H	1
110	63-1658-1		. WASHER (MAKE FROM SH NYLON FM10001 0.10 IN 2.0 IN 2.0 IN)	A-D, G, H	1
115	HA247-3		DELETED		
115A	HA247-5		. LATCH ASSY (V83014)	A-D, G, H	1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
120	HST10AG5-3		. BOLT (V0PTK6) (SPEC BACB30VT5K3) (OPT HST10AG5-3 (V06725)) (OPT HST10AG5-3 (V56878)) (OPT HST10AG5-3 (V73197))	A-D, G, H	2
125	BACN10ZV08		DELETED		
125A	KFN587-5BAC		. NUT (V15653) (SPEC BACN10ZV5)	A-D, G, H	2
130	141A6712-1		. CATCH ASSY-HANDLE	A-D, G, H	1
135	141A6712-3		. . PIN	A-D, G, H	1
140	141A6712-2		. . FITTING-CATCH	A-D, G, H	1
145	141A6710-6		. SHIM-LAMINATED	A-D, G, H	1
150	BACB30NN3K10		. BOLT	A-D, G, H	2
155	BACR15GE3CW2		. RIVET	A-D, G, H	4
160	BRFM20C3D		. NUTPLATE (V52828) (SPEC BACN10JN3CD) (OPT 102F9201M3 (V72962)) (OPT NS202487-02 (V80539)) (OPT MF51637-3 (V15653)) (OPT MF53050-3CD (V15653))	A-D, G, H	2
165	141A6702-1		. HANDLE	A-D, G, H	1
170	88D10204-175		. SEAL (V60980) (SPEC S140T263-175) (OPT SF15-120-175 (V50744))	A-D, G, H	1
175	BACB30NM3K9		. BOLT	A-D, G, H	16
180	NAS1149D0363J		. WASHER	A-D, G, H	16
185	NAS1149E0763P		. WASHER (SELECT FROM)	A-D	AR
190	NAS1149E0716P		. WASHER (SELECT FROM)	A-D	AR
195	141A6716-2		. STOP-DOOR, L	A-D, G, H	1
200	141A6716-4		. STOP-DOOR, R	A-D, G, H	1
205	141A6716-1		. STOP-DOOR, FWD	A-D, G, H	1
210	141A6716-3		. STOP-DOOR, AFT	A-D, G, H	1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
215	141A6710-3		. SHIM-LAMINATED	A-D, G, H	2
220	141A6710-2		. SHIM-LAMINATED	A-D, G, H	2
225	BACR15BA4D		. RIVET (SIZE DETERMINED ON INST)	A-D, G, H	4
230	141A6715-3		. CARRIER ASSY-L AND R STOPS	A-D, G, H	2
235	BACR15BA3D3		. . RIVET	A-D, G, H	8
240	FBL10091C3-1		. . NUTPLATE (V29372) (OPT ITEM 240A)	A-D, G, H	2
–240A	BACN11G3A1CD		. . NUTPLATE (OPT ITEM 240)	A-D, G, H	2
245	FBL10093C3-1		. . NUTPLATE (V29372) (OPT ITEM 245A)	A-D, G, H	2
–245A	BACN11G3B1CD		. . NUTPLATE (OPT ITEM 245)	A-D, G, H	2
250	141A6715-6		. . PLATE	A-D, G, H	1
255	141A6715-2		. CARRIER ASSY-FWD AND AFT STOPS	A-D, G, H	2
260	BACR15BA3D3		. . RIVET	A-D, G, H	8
265	FBL10091C3-1		. . NUTPLATE (V29372) (OPT ITEM 265A)	A-D, G, H	4
–265A	BACN11G3A1CD		. . NUTPLATE (OPT ITEM 265)	A-D, G, H	4
270	141A6715-5		. . PLATE	A-D, G, H	1
275	BACB30NN3K7		. BOLT	A-D, G, H	2
280	BACB30NN3K12		. BOLT	A-D, G, H	1
285	NAS1149D0363J		. WASHER	A-D, G, H	2
290	69B13438-501		. WASHER	A-D, G, H	3
295	H52732-3CD		. NUT (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))	A-D, G, H	2
300	69B13438-1		. BEARING	A-D, G, H	3
305	141A6718-1		. TRUCK ASSY-ROLLER	A-D, G, H	3
310	BACP18BC02A06P		. . PIN-COTTER	A-D, G, H	2

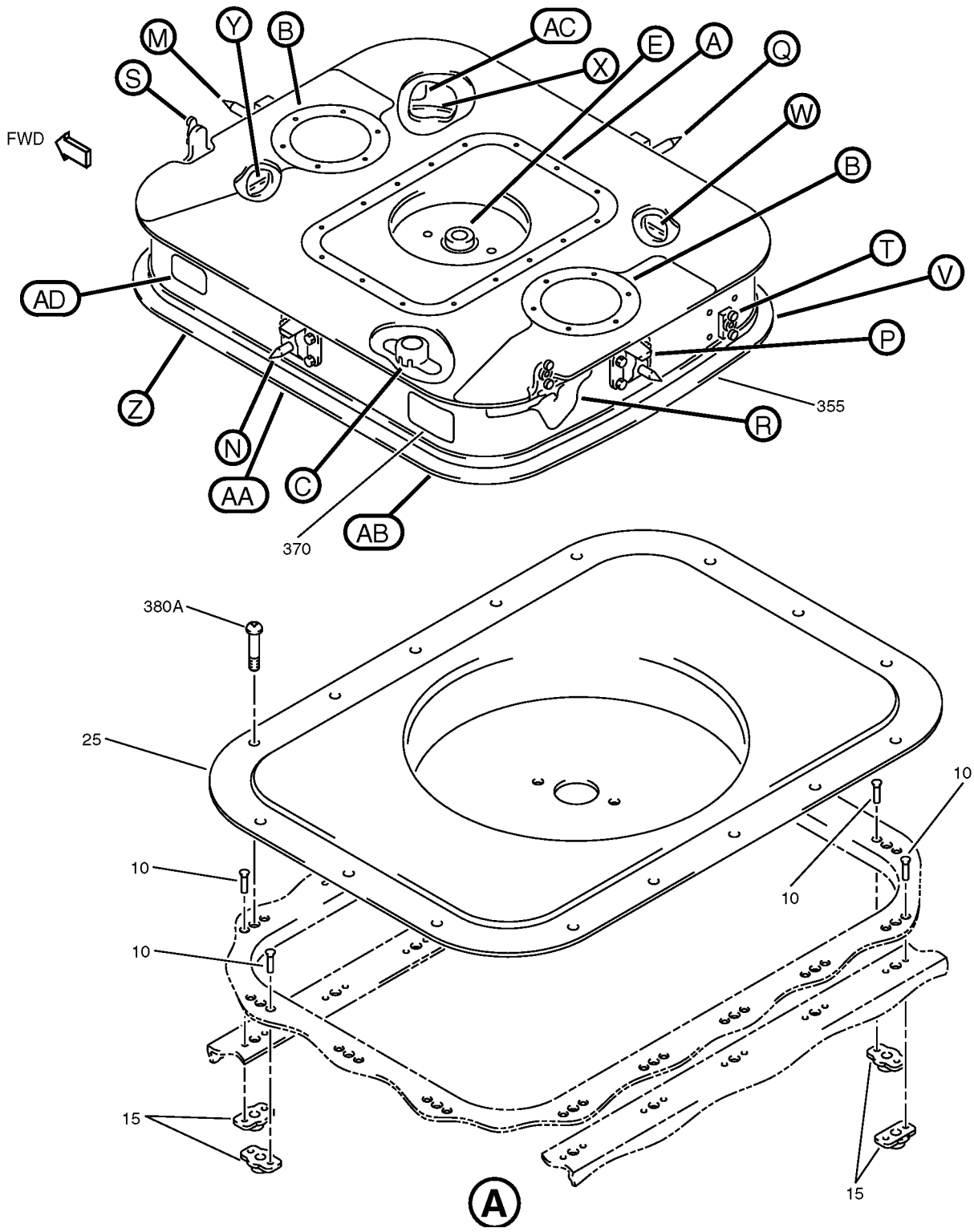
–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
315	MS20392-2R17		. . PIN-DRILLED SHANK	A-D, G, H	2
320	69B13433-1		. . ROLLER	A-D, G, H	2
325	141A6718-2		. . TRUCK	A-D, G, H	1
330	141A6710-7		. SHIM-LAMINATED	A-D, G, H	1
335	BACR15BA4D		. RIVET (SIZE DETERMINED ON INST)	A-D, G, H	1
340	141A6715-4		. CARRIER ASSY-TRUCK ATTACH	A-D, G, H	1
345	BACR15BA3D3		. . RIVET	A-D, G, H	2
350	FBL10091C3-1		. . NUTPLATE (V29372) (OPT ITEM 350A)	A-D, G, H	1
–350A	BACN11G3A1CD		. . NUTPLATE (OPT ITEM 350)	A-D, G, H	1
355	141A6715-7		. . PLATE	A-D, G, H	1
360	BACB30NM3K4		. BOLT	A-D, G, H	6
365	NAS1149D0363J		. WASHER	A-D, G, H	6
370	BACR15BA3D		. RIVET (SIZE DETERMINED ON INST)	A-D, G, H	12
375	FBL10091C3-1		. NUTPLATE (V29372)	A, B	6
–375A	BACN11G3A1CD		. NUTPLATE (OPT ITEM 375B)	C, D, G, H	6
–375B	FBL10091C3-1		. NUTPLATE (V29372) (OPT ITEM 375A)	C, D, G, H	6
380	141A6717-1		. BRACKET	A-D, G, H	2
385	141A6710-4		. SHIM-LAMINATED	A-D, G, H	1
390	141A6710-5		. SHIM-LAMINATED	A-D, G, H	1
395	BACR15GF4D		. RIVET (SIZE DETERMINED ON INST)	A-D, G, H	2
400	NAS1149DN432J		. WASHER	A-D, G, H	2
405	140N2021-1		. RETAINER-DRAIN VALVE	A-D, G, H	1
410	140N2022-1		. VALVE ASSY-DRAIN	A-D, G, H	1
415	140N2022-4		. . CAP	A-D, G, H	1
420	140N2022-3		. . PLUNGER	A-D, G, H	1

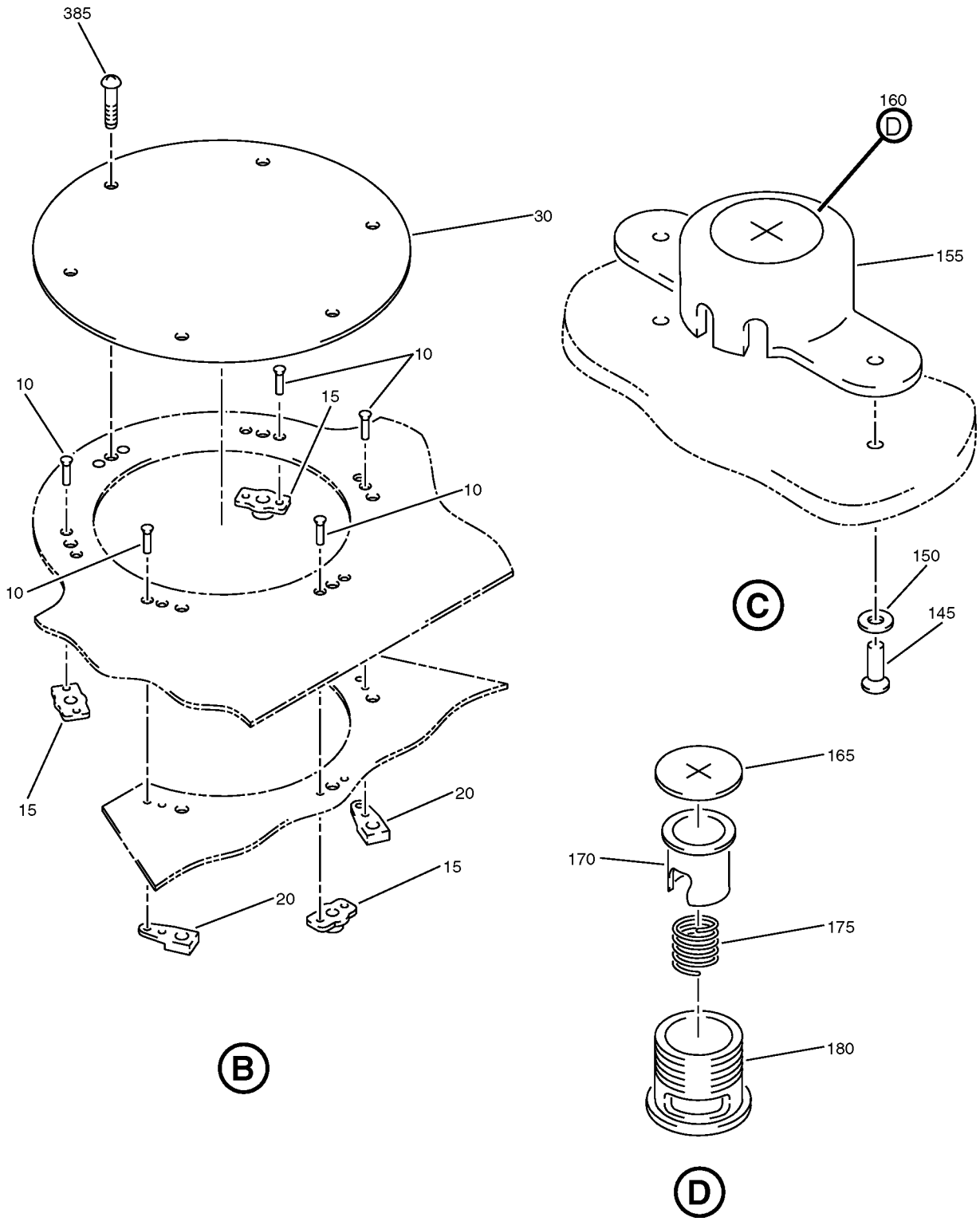
–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
425	140N2020-1		. . SPRING	A-D, G, H	1
430	140N2022-2		. . HOUSING	A-D, G, H	1
435	141A6711-1		. CASTING-STRUCTURAL	A-D, G, H	1
440	BAC27DBY187		. MARKER-ALUMINUM FOIL CAUTION RESTRAIN DOOR WITH ONE HAND DURING DOOR CLOSURE	A-D, G, H	1
445	BAC27DBY191		. MARKER-ALUMINUM FOIL	A-D, G, H	1
450	MS27253F1		. PLATE	A-D, G, H	1
			DELETED		

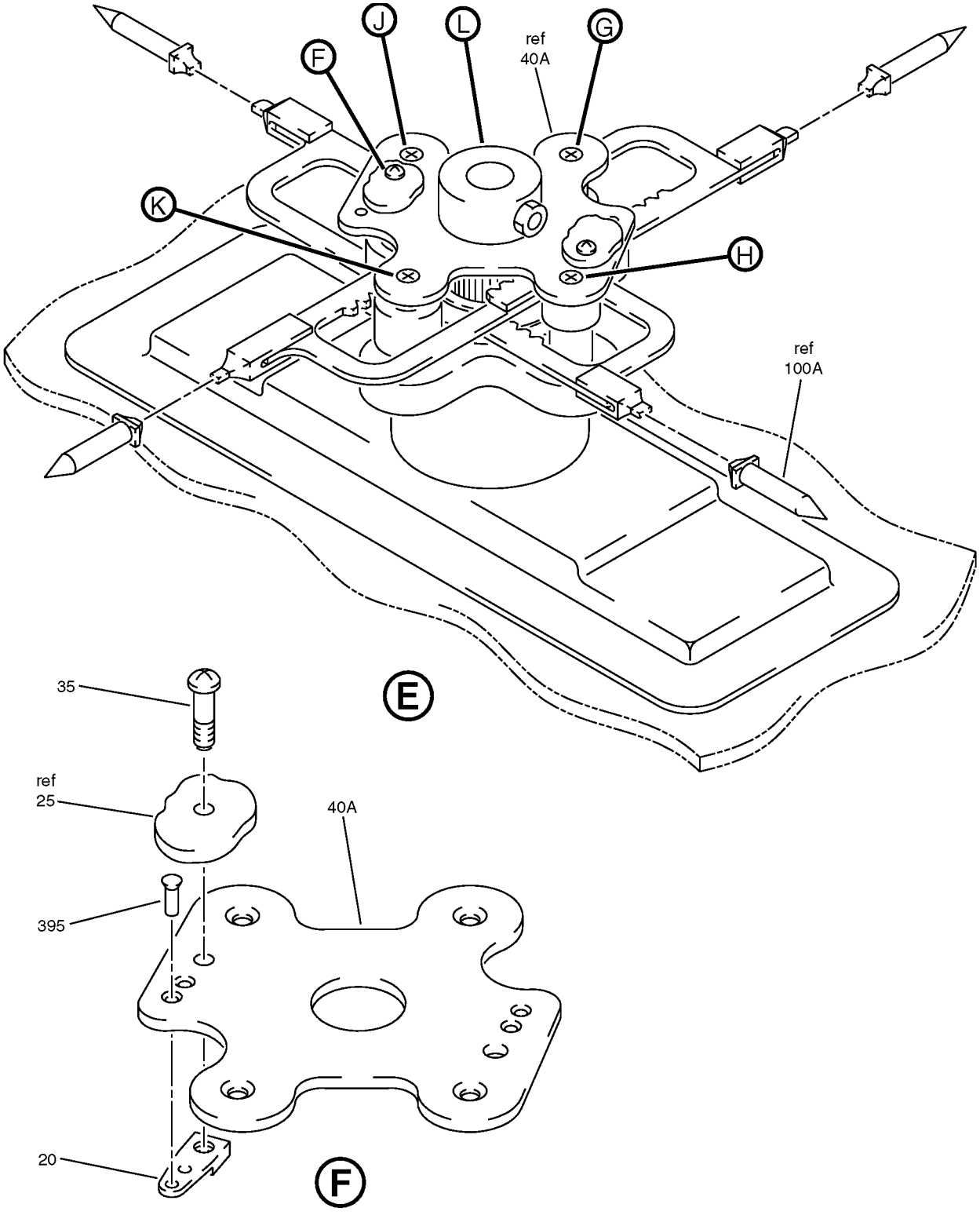
–Item not Illustrated



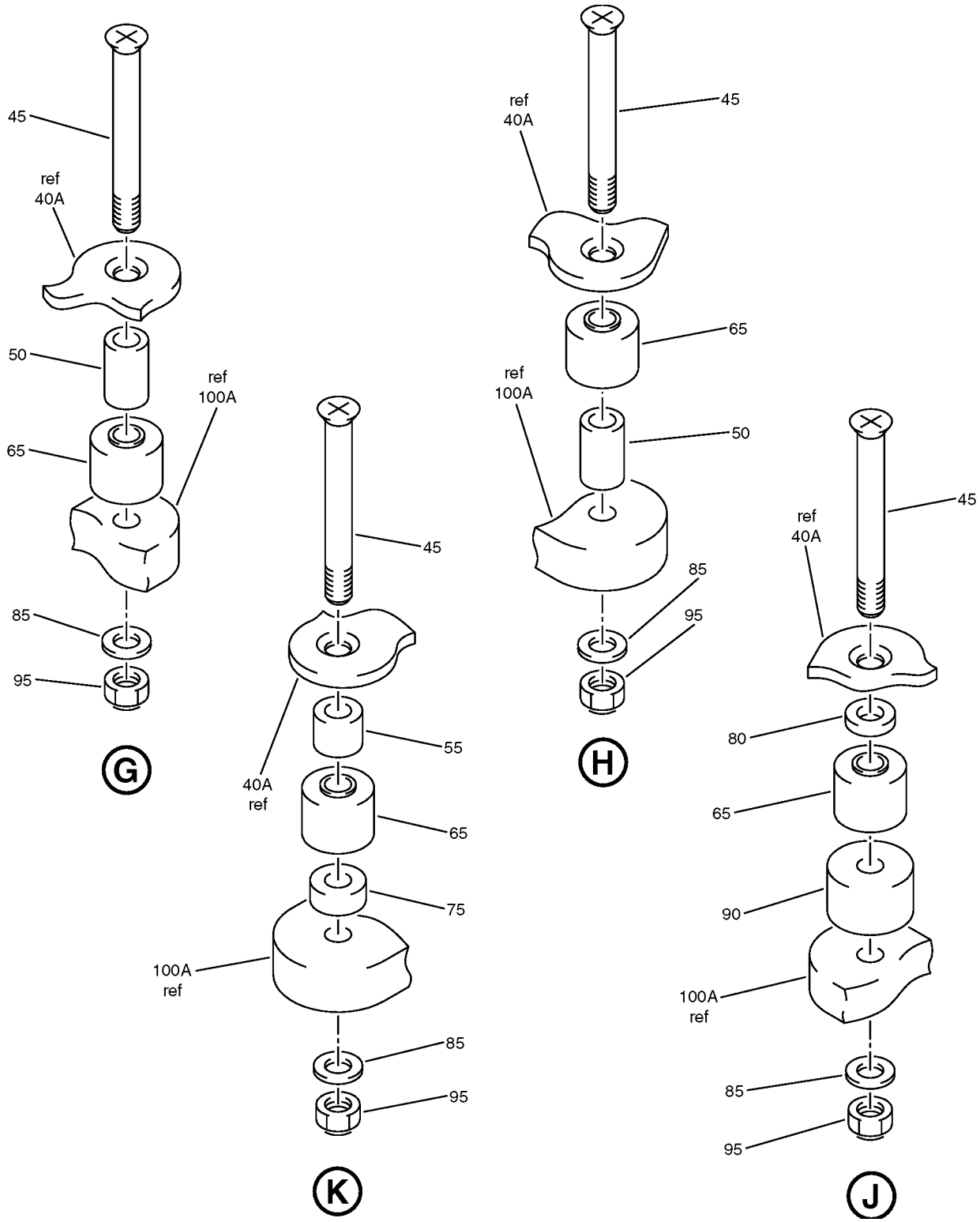
Equipment Access Door Assembly
IPL Figure 2 (Sheet 1 of 13)



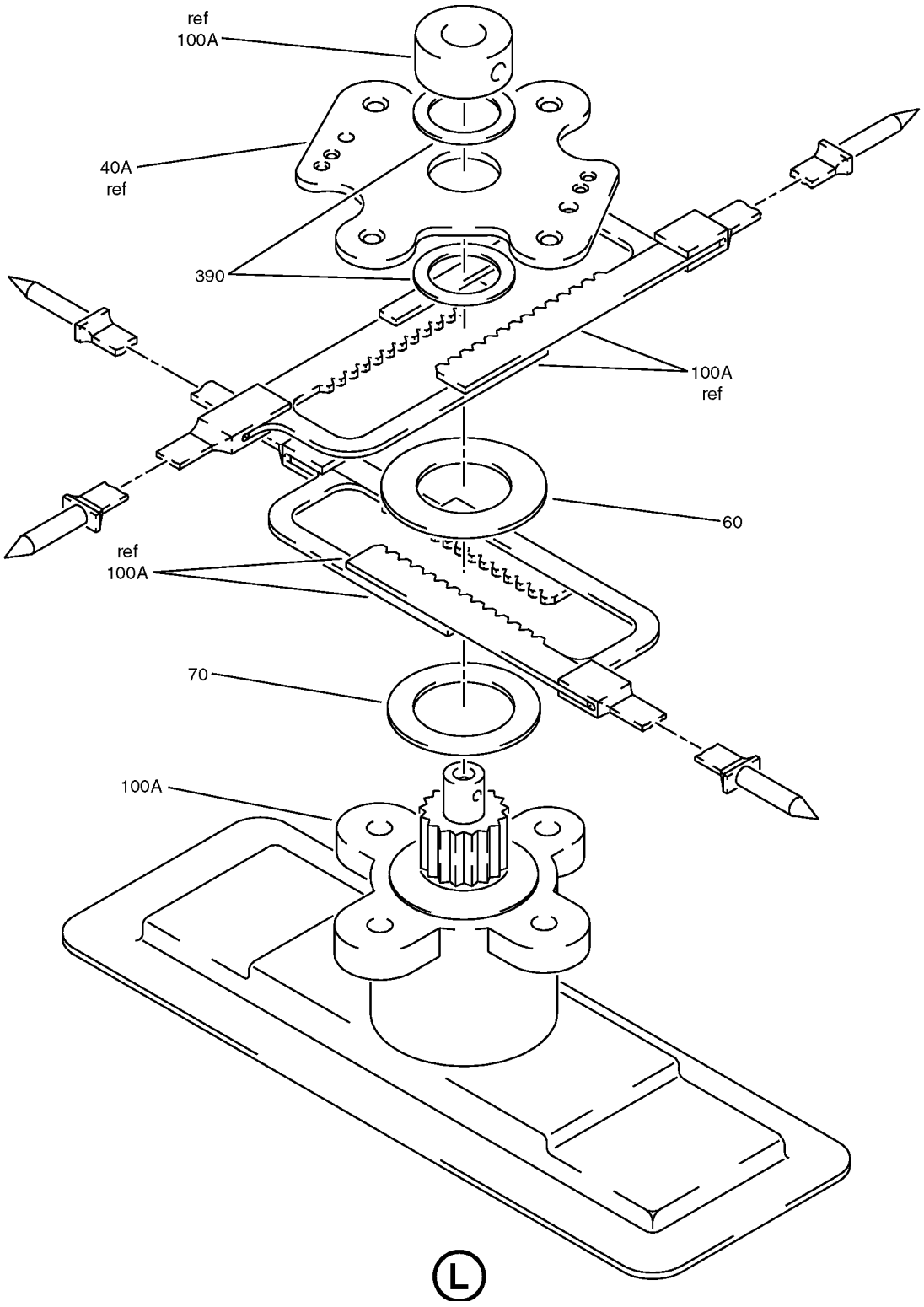
Equipment Access Door Assembly
IPL Figure 2 (Sheet 2 of 13)



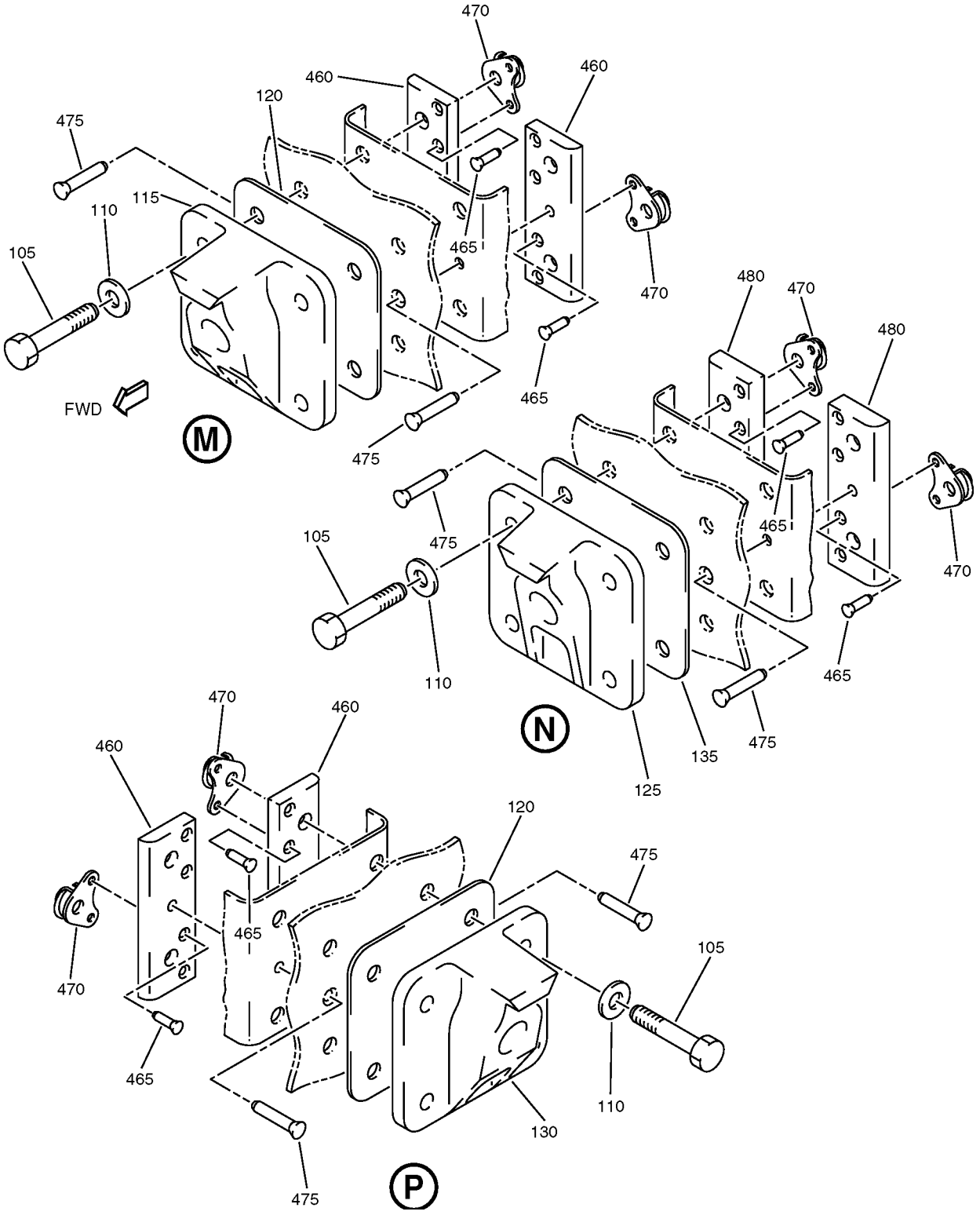
Equipment Access Door Assembly
IPL Figure 2 (Sheet 3 of 13)



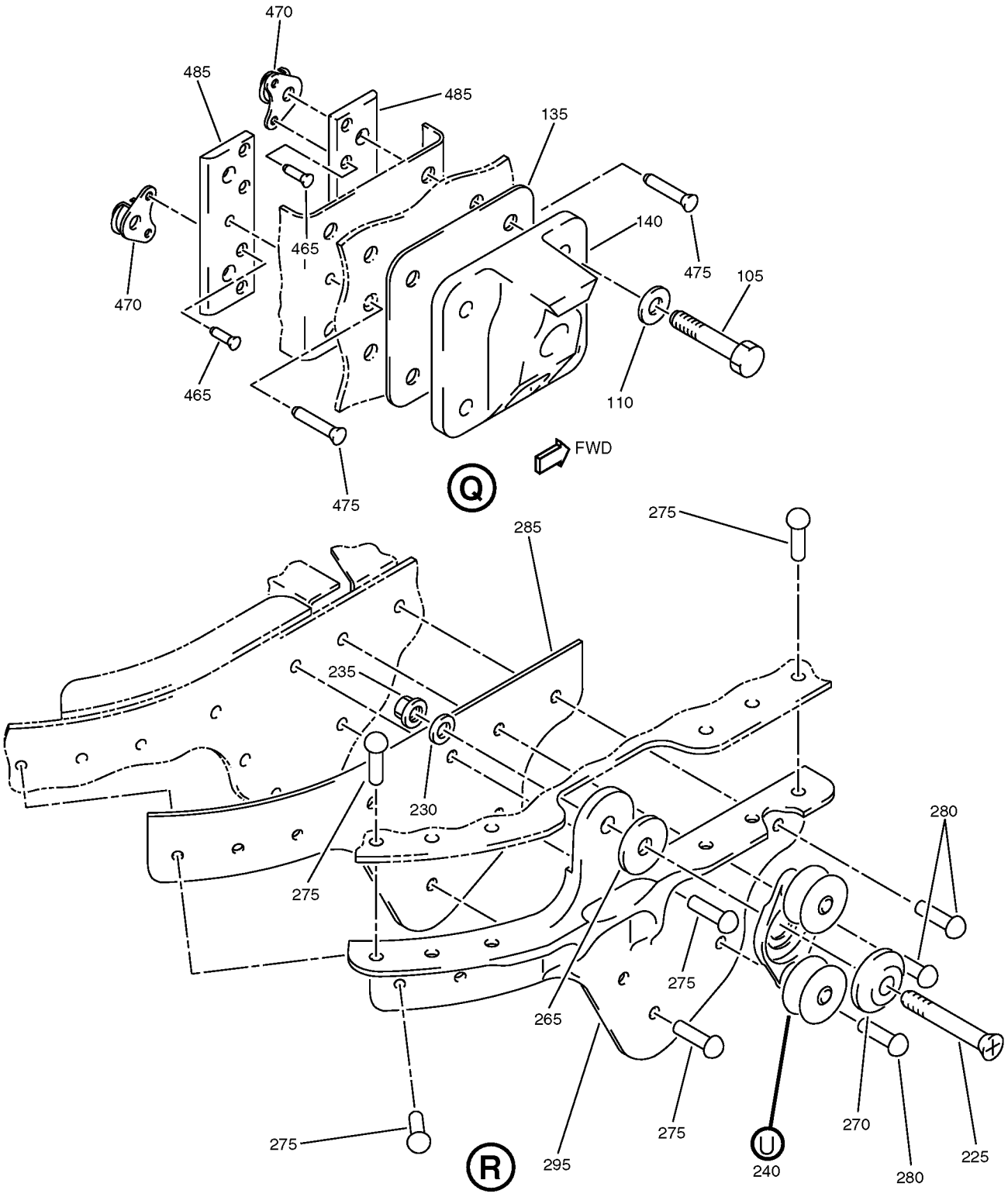
Equipment Access Door Assembly
IPL Figure 2 (Sheet 4 of 13)



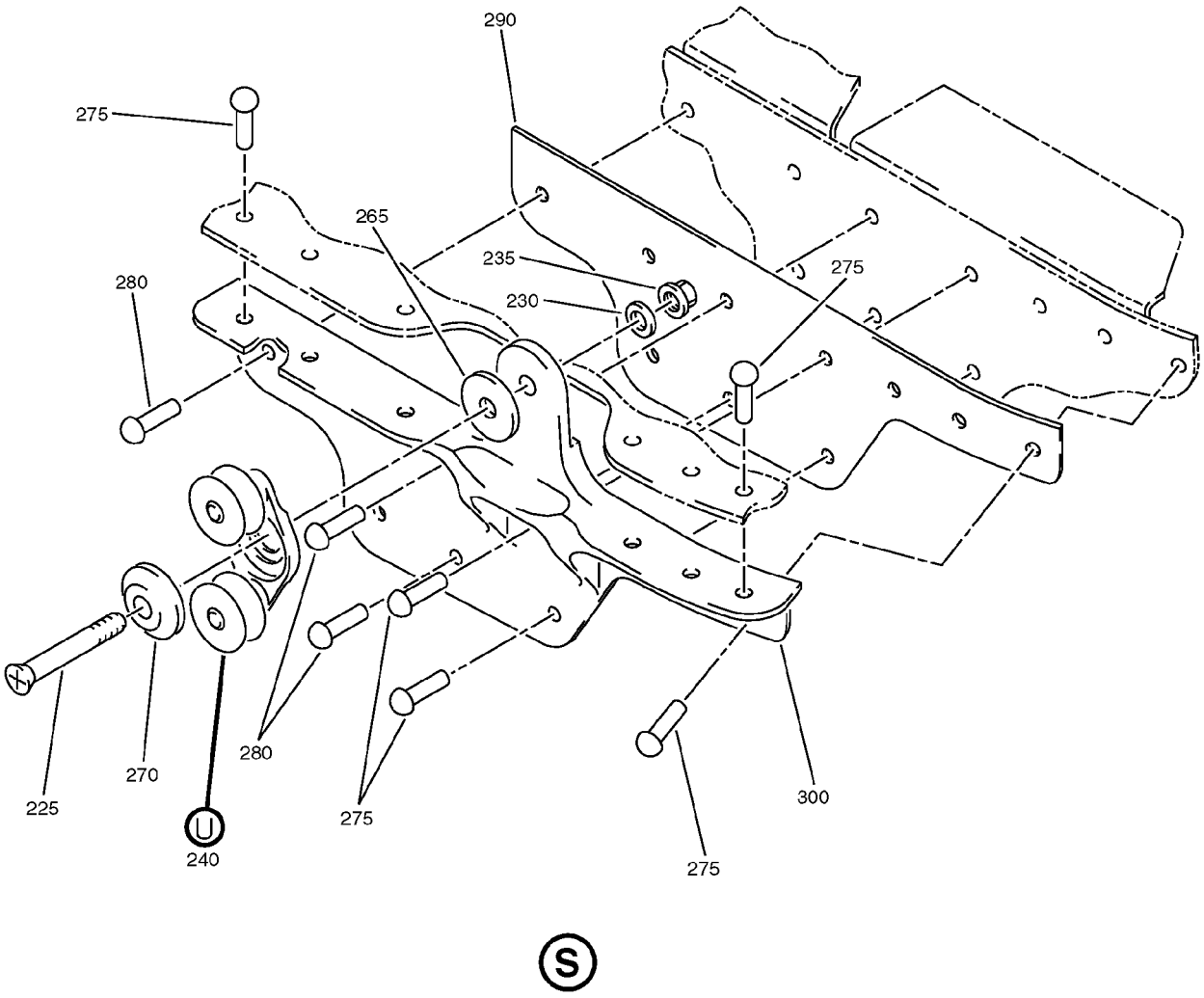
Equipment Access Door Assembly
IPL Figure 2 (Sheet 5 of 13)



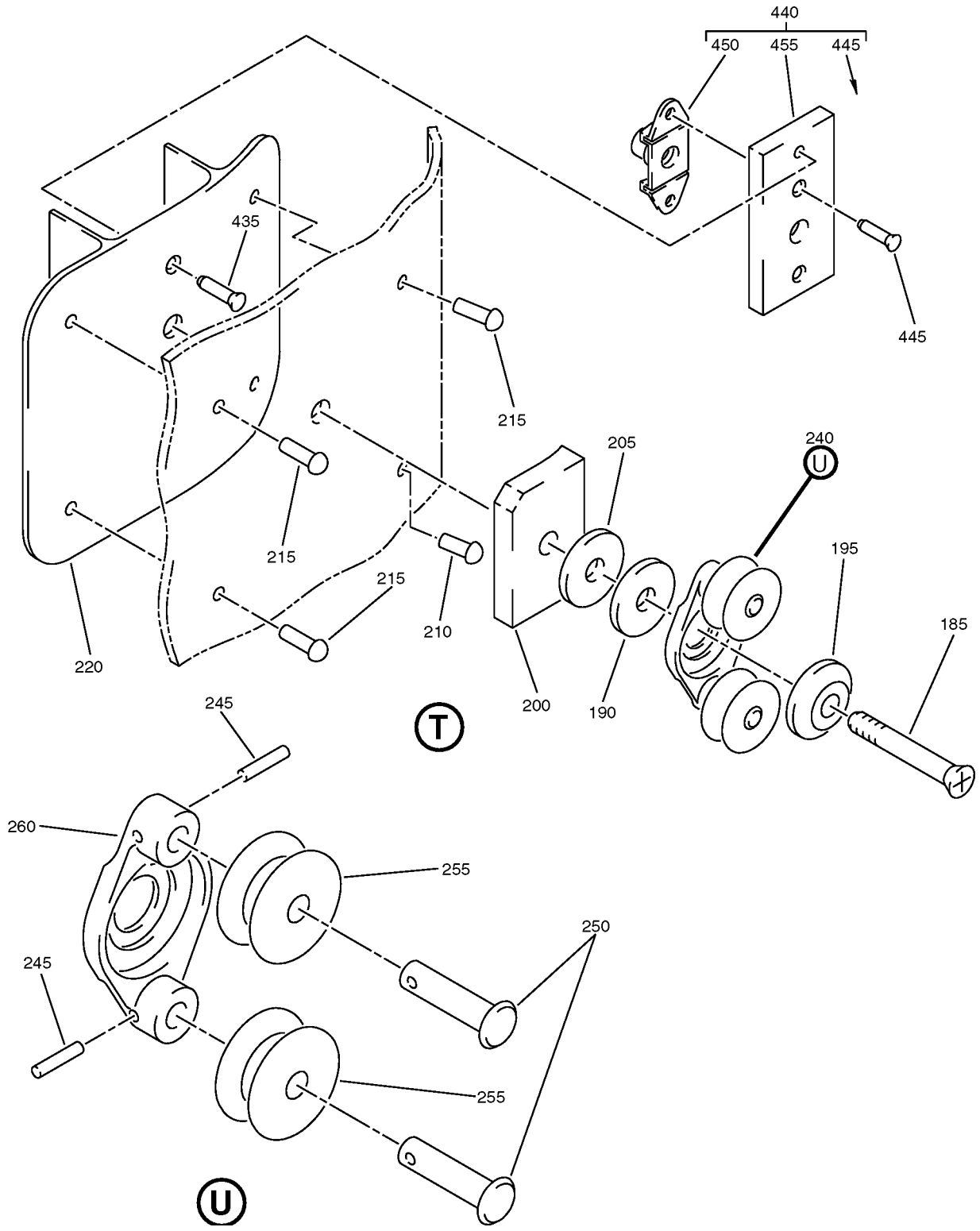
Equipment Access Door Assembly
IPL Figure 2 (Sheet 6 of 13)



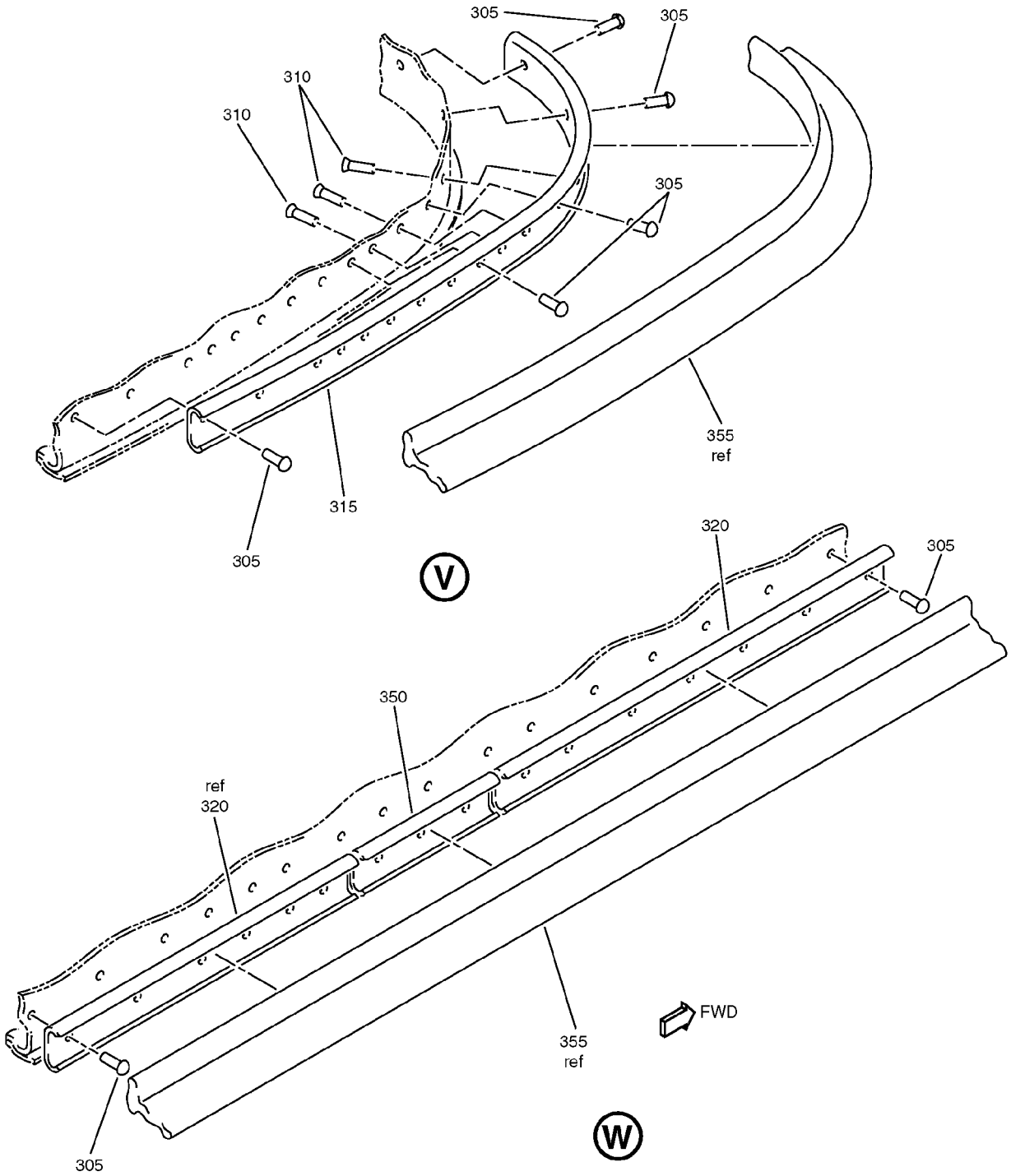
Equipment Access Door Assembly
IPL Figure 2 (Sheet 7 of 13)



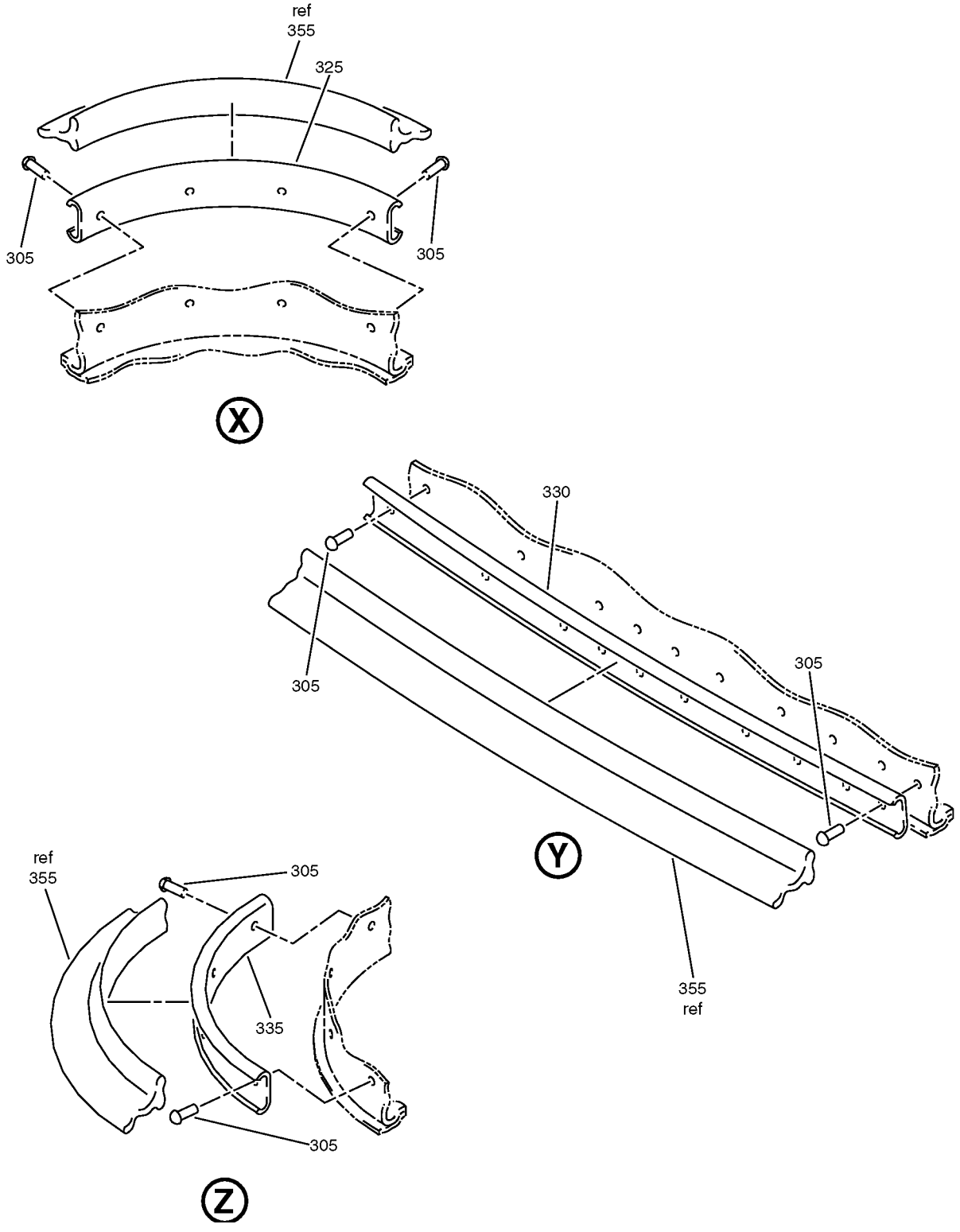
Equipment Access Door Assembly
IPL Figure 2 (Sheet 8 of 13)



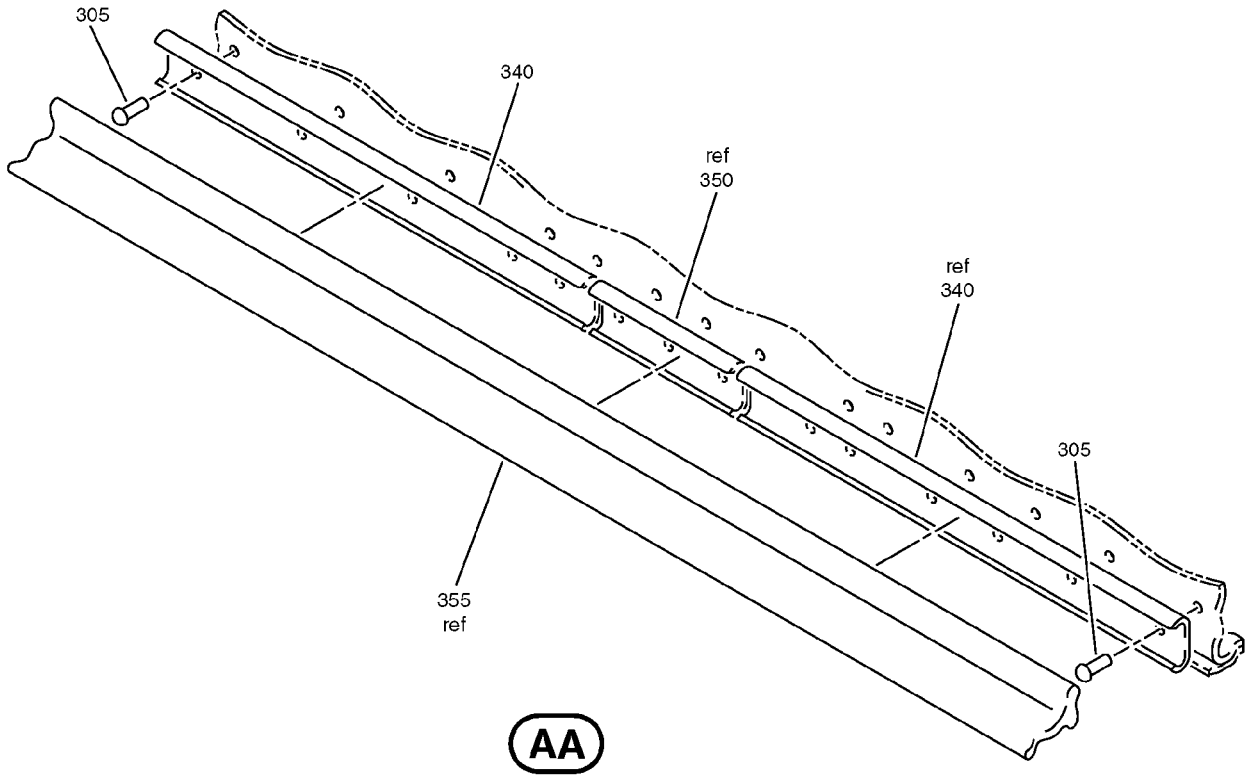
Equipment Access Door Assembly
IPL Figure 2 (Sheet 9 of 13)

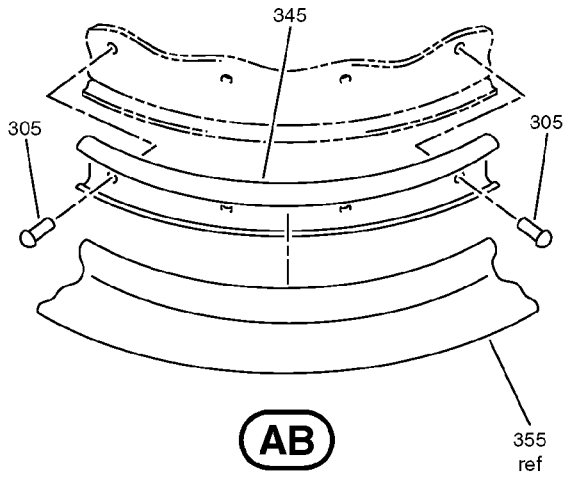


Equipment Access Door Assembly
IPL Figure 2 (Sheet 10 of 13)

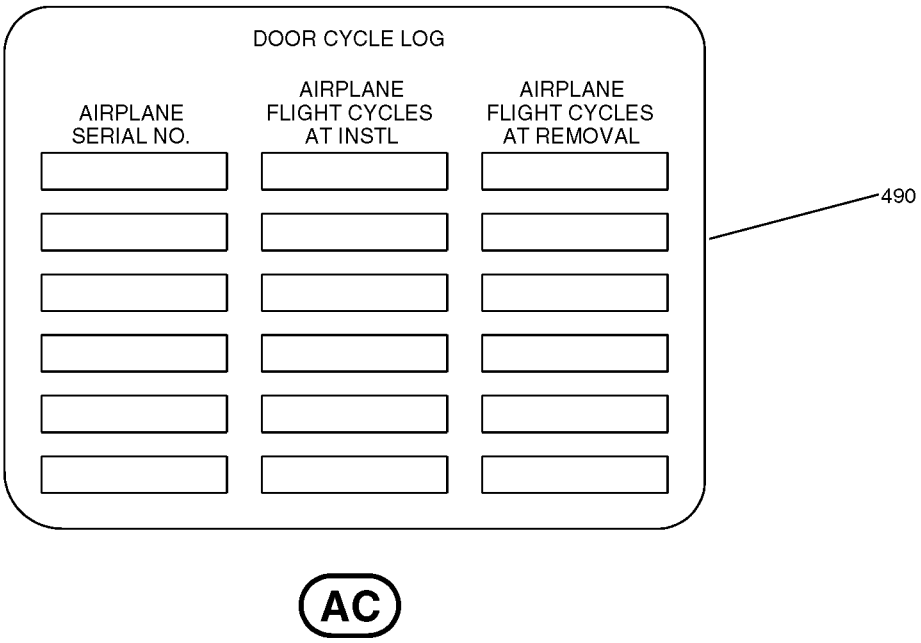


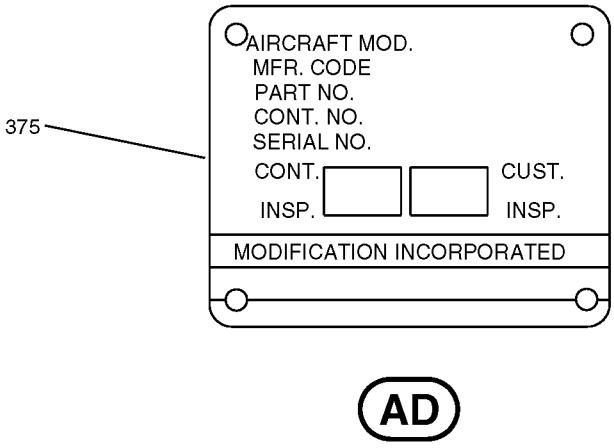
Equipment Access Door Assembly
IPL Figure 2 (Sheet 11 of 13)





Equipment Access Door Assembly
IPL Figure 2 (Sheet 12 of 13)





Equipment Access Door Assembly
IPL Figure 2 (Sheet 13 of 13)

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
–1A	141A6710-11		DOOR ASSY-EQPT ACCESS	E	RF
–1B	141A6710-12		DOOR ASSY-EQPT ACCESS	F	RF
10	BACR15BA3D		. RIVET (SIZE DETERMINED ON INST)	E, F	56
15	BRFM20C3D		. NUTPLATE (V52828) (SPEC BACN10JN3CD) (OPT 102F9201M3 (V72962)) (OPT NS202487-02 (V80539)) (OPT MF51637-3 (V15653)) (OPT MF53050-3CD (V15653))	E, F	24
20	BACN10KB3P		. NUTPLATE	E, F	6
25	65-2163-144		. COVER	E, F	1
30	65-2163-142		. COVER-ACCESS HOLE	E, F	2
35	NAS623-3-2		. SCREW	E, F	2
40	69-1263-140		DELETED		
40A	65-1263-140		. PLATE-SPRT	E, F	1
45	BACB30LU4-26		. BOLT	E, F	4
50	NAS43DD4-36		. SPACER	E, F	2
55	NAS43DD4-24		. SPACER	E, F	1
60	63-1658		. WASHER	E, F	1
65	GDW4K2SD610		. BEARING (V83086) (SPEC BACB10CG4) (OPT GDW4K2TT (V43991)) (OPT GDW4K2FS428 (V21335)) (OPT DW4K2-1 (V38443))	E, F	4
70	63-1658-1		. WASHER	E, F	1
75	NAS43DD4-12		. SPACER	E, F	1
80	NAS43DD4-9		. SPACER	E, F	1
85	AN960D146		. WASHER	E, F	4
90	63-9328-2		. SPACER	E, F	1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
95	BRH10A4		. NUT (V52828) (SPEC BACN10JC4) (OPT T6S428J (V11815)) (OPT 96-048 (V80539)) (OPT VN303A048 (V92215)) (OPT RMLH9075-4W (V72962)) (OPT NS202101-048 (V80539)) (OPT H10-4BAC (V15653))	E, F	4
100	H756-135		DELETED		
100A	H759-135		. LATCH ASSY (V83014)	E, F	1
105	BACB30NM3K9		. BOLT	E, F	16
110	NAS1149D0363J		. WASHER	E, F	16
115	141A6716-1		. STOP-FWD	E, F	1
120	141A6710-2		. SHIM-LAMINATED	E, F	2
125	141A6716-2		. STOP-LEFT	E, F	1
130	141A6716-3		. STOP-AFT	E, F	1
135	141A6710-3		. SHIM	E, F	2
140	141A6716-4		. STOP-RIGHT	E, F	1
145	BACR15GF4		. RIVET (SIZE DETERMINED ON INST)	E, F	2
150	NAS1149DN432J		. WASHER	E, F	2
155	140N2021-1		. RETAINER-DRAIN VALVE	E, F	1
160	140N2022-1		. VALVE ASSY-DRAIN	E, F	1
165	140N2022-4		. . CAP	E, F	1
170	140N2022-3		. . PLUNGER	E, F	1
175	140N2020-1		. . SPRING	E, F	1
180	140N2022-2		. . HOUSING	E, F	1
185	BACB30NN3K12		. BOLT	E, F	1
190	69B13438-501		. WASHER	E, F	1
195	69B13438-1		. BEARING	E, F	1
200	141A6717-4		. SPACER-ROLLER	E, F	1
205	141A6710-7		. SHIM	E, F	1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
210	BACR15BB4D		. RIVET (SIZE DETERMINED ON INST)	E, F	1
215	BACR15BB5D		. RIVET (SIZE DETERMINED ON INST)	E, F	3
220	141A6717-5		. FITTING-ROLLER BACKUP	E, F	1
225	BACB30NN3K7		. BOLT	E, F	2
230	NAS1149D0363J		. WASHER	E, F	2
235	H52732-3CD		. NUT (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))	E, F	2
240	141A6718-1		. TRUCK ASSY-ROLLER	E, F	3
245	BACP18BC02A06P		. . PIN-COTTER	E, F	2
250	MS20392-2R17		. . PIN	E, F	2
255	69B13433-1		. . ROLLER	E, F	2
260	141A6718-2		. . TRUCK	E, F	1
265	69B13438-501		. WASHER	E, F	2
270	69B13438-1		. BEARING	E, F	2
275	BACR15BB5D		. RIVET (SIZE DETERMINED ON INST)	E, F	24
280	BACR15BB6D		. RIVET (SIZE DETERMINED ON INST)	E, F	8
285	141A6713-9		. SHIM-LAMINATED	E, F	1
290	141A6713-10		. SHIM-LAMINATED	E, F	1
295	141A6717-3		. FITTING-ROLLER AFT	E, F	1
300	141A6717-2		. FITTING-ROLLER FWD	E, F	1
305	BACR15BB4D		. RIVET (SIZE DETERMINED ON INST)	E, F	64
310	BACR15BA4D		. RIVET (SIZE DETERMINED ON INST)	E, F	3
315	65-45830-25		. RETAINER-SEAL	E, F	1
320	65-45830-30		. RETAINER-SEAL	E, F	1
325	65-45830-28		. RETAINER-SEAL	E, F	1
330	65-45830-27		. RETAINER-SEAL	E, F	1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
335	65-45830-26		. RETAINER-SEAL	E, F	1
340	65-45830-29		. RETAINER-SEAL	E, F	1
345	65-45830-23		. RETAINER-SEAL	E, F	1
350	65-45830-61		. RETAINER-SEAL	E, F	1
355	88D10204-175		. SEAL (V60980) (SPEC S140T263-175) (OPT SF15-120-175 (V50744))	E, F	1
360	65C10587-1		DELETED		
365	BAC27DBY191		DELETED		
370	BAC27DBY187		DELETED		
375	MS27253F1		. PLATE	E, F	1
380	NAS517		DELETED		
380A	NAS623-3-2		. SCREW	E, F	16
385	NAS221-8		. SCREW	E, F	12
390	63-1658-501		. WASHER	E, F	2
395	BACR15BA3D3		. RIVET	E, F	4
435	BACR15BA4D		. RIVET (SIZE DETERMINED ON INST)	E, F	1
440	141A6715-4		. CARRIER ASSY-TRUCK ATTACH	E, F	1
445	BACR15BA3D3		. . RIVET	E, F	2
450	FBL10091C3-1		. . NUTPLATE (V29372) (OPT ITEM 450A)	E, F	1
–450A	BACN11G3A1CD		. . NUTPLATE (OPT ITEM 450)	E, F	1
455	141A6715-7		. . PLATE	E, F	1
460	65-45830-139		. FILLER-RADIUS	E, F	4
465	BACR15BA3D		. RIVET (SIZE DETERMINED ON INST)	E, F	32
470	F51754-3		. NUTPLATE (V15653) (SPEC BACN10KE3D) (OPT NS103193-02 (V80539))	E, F	16

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
475	BACR15GF6D		. RIVET (SIZE DETERMINED ON INST)	E, F	8
480	65-45830-71		. FILLER-RADIUS	E, F	2
485	65-45830-512		. FILLER-RADIUS	E, F	2
490	BAC27DBY191		. MARKER-ALUMINUM FOIL	E, F	1
495	BAC27DBY187		. MARKER-ALUMINUM FOIL (CAUTION RESTRAIN DOOR WITH ONE HAND DURING DOOR CLOSURE)	E, F	1

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