COMPONENT MAINTENANCE MANUAL WITH ILLUSTRATED PARTS LIST

ACCESS AND BLOWOUT DOOR ASSEMBLY

PART NUMBER 148A6110–1, –10, –11, –13, –14, –15, –16, –6, –7, –8, –9

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COMPONENT MAINTENANCE MANUAL

Revision No. 8
Jul 01/2009

To: All holders of ACCESS AND BLOWOUT DOOR ASSEMBLY 52-49-13.

Attached is the current revision to this COMPONENT MAINTENANCE MANUAL

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Subject/Page	Date	Subject/Page	Date	Subject/Page	Date
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1040	Mar 01/2009				
1041	Mar 01/2009				
1042	Mar 01/2009				
O 1043	Jul 01/2009				
O 1044	Jul 01/2009				
O 1045	Jul 01/2009				
O 1046	Jul 01/2009				
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O 1048	Jul 01/2009				
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O 1051	Jul 01/2009				
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TEMPORARY REVISION AND SERVICE BULLETIN RECORD

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVE	DATE OF INCORPORATION INTO MANUAL
		PRR 38312	NOV 01/00

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Revision		Filed	
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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.

ACCESS AND BLOWOUT DOOR ASSEMBLY - DESCRIPTION AND OPERATION

1. Description

A. The access and blowout door is an outward plug-type door hinged at the lower edge and is operated manually either from the inside or the outside or by pressure buildup from inside the airplane. The latch mechanism consists of two latching rollers connected to a spring assembly through a torque tube.

B. The primary components of the access and blowout door includes the hinge assemblies, the latch assembly, the pin holder assembly, the jury strut support, the jury strut assembly, and the door pan as shown in DESCRIPTION AND OPERATION, Figure 1.

2. Operation

A. The access and blowout door is opened from the inside or the outside by operating a trigger, which allows the latch mechanism to swing outward and forward. This pushes the rollers out of their detents and releases the door. In case of pressure bulkhead leakage or rupture of the air conditioning duct, the door is designed to automatically open when the pressure reaches a predetermined level.

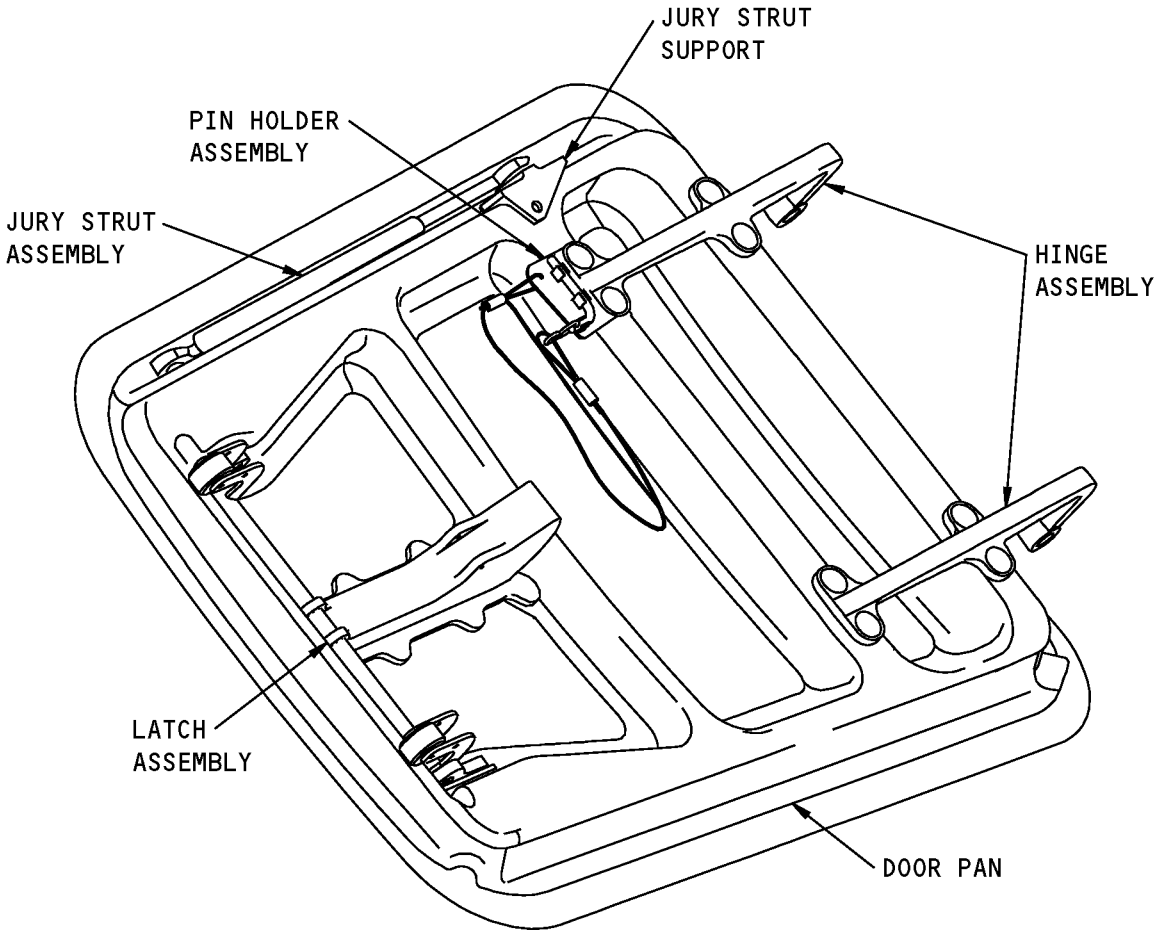
3. Leading Particulars (Approximate)

A. Length – 3.5 inches

B. Width – 18.0 inches

C. Height – 24.0 inches

D. Weight – 7.1 pounds



Access and Blowout Door Assembly
Figure 1

(NOT APPLICABLE)

DISASSEMBLY

1. **General**
   A. This procedure has the data necessary to disassemble the access and blowout 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, IPL Figure 2 and IPL Figure 3 for item numbers.
2. **Disassembly**
   A. Procedure
      (1) Use standard industry procedures to disassemble this component.

CLEANING

1. General

A. This procedure has the data necessary to clean the access and blowout 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, IPL Figure 2 and IPL Figure 3 for 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 (IPL Figure 1, 25, 107A; IPL Figure 2, 55, 170A; IPL Figure 3, 40, 145) 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, IPL Figure 2 and IPL Figure 3 for item numbers.

2. Check

A. References

Reference	Title
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 check if the visual check shows possible damage or if you suspect possible damage on the parts listed below:

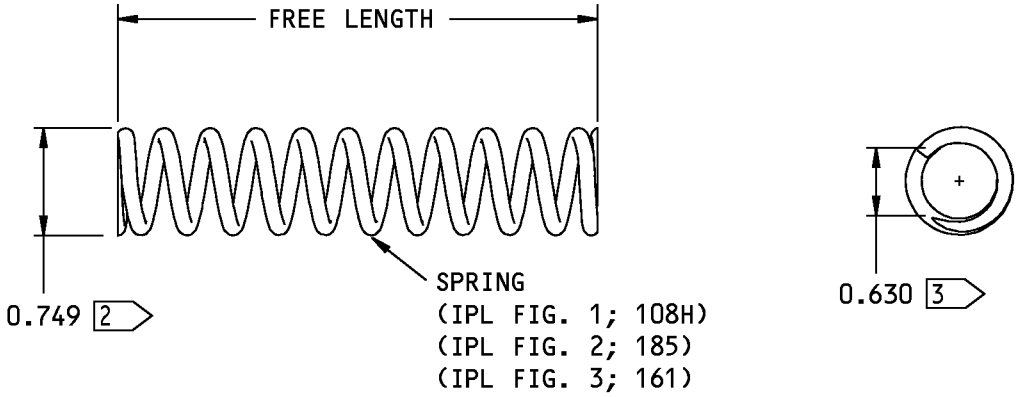
(a) Do a penetrant check (SOPM 20-20-02) of these parts:

1) Hinge (IPL Figure 1, 30; IPL Figure 2, 60; IPL Figure 3, 45)

2) Jury strut fitting (IPL Figure 1, 125; IPL Figure 2, 220; IPL Figure 3, 195)

3) Latch angle (IPL Figure 2, 330, 335, 355; IPL Figure 3, 310)

(2) Check the dimension of the spring (IPL Figure 1, 108H; IPL Figure 2, 185; IPL Figure 3, 161) as shown in CHECK, Figure 501.



SPRING DATA	
TOTAL NUMBER OF COILS	15
FREE LENGTH	3.75–4.25 INCHES
DIRECTION OF COIL	OPTIONAL
CHECK LOAD 1	5.18–6.34 POUNDS
MAXIMUM SOLID HEIGHT	0.713 INCHES

1 AT 1.37 INCH LENGTH

2 MAXIMUM OUTSIDE DIAMETER

3 MINIMUM INSIDE DIAMETER

ALL DIMENSIONS ARE IN INCHES

L43338 S00041002625_V2

69-41401-1 Spring - Compression, Jury Strut
Figure 501

REPAIR

1. General

A. Instructions for repair, refinish, and replacement of the specified subassembly parts are included in each REPAIR when applicable (REPAIR-GENERAL, Table 601):

Table 601: Repair, Refinish, and Replacement Instructions

PART NUMBER	NAME	REPAIR
—	REFINISH OF OTHER PARTS	1-1
65-67747; 148A6160	HINGE ASSEMBLY	2-1, 2-2

2. Dimensioning Symbols

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

—	STRAIGHTNESS
▱	FLATNESS
⊥	PERPENDICULARITY (OR SQUARENESS)
//	PARALLELISM
○	ROUNDNESS
⌭	CYLINDRICITY
⌒	PROFILE OF A LINE
⌓	PROFILE OF A SURFACE
◎	CONCENTRICITY
⌯	SYMMETRY
∠	ANGULARITY
↗	RUNOUT
↗↗	TOTAL RUNOUT
⌴	COUNTERBORE OR SPOTFACE
∨	COUNTERSINK
⌖	THEORETICAL EXACT POSITION OF A FEATURE (TRUE POSITION)
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, IPL Figure 2 and IPL Figure 3 for item numbers.

2. Refinish of Other Parts

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A50071	Sealant	BAC5710, Type 41
C00032	Coating - Exterior Protective Enamel, General Use	BMS10-60, Type I
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I
C50057	Enamel - Camouflage, dull white	MIL-E-5556
C50066	Coating - Exterior Protective Enamel, Clear	BMS10-60, Type I, Class A
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 20-44-04	APPLICATION OF URETHANE COMPATIBLE PRIMER
SOPM 20-50-08	APPLICATION OF BONDED SOLID FILM LUBRICANTS
SOPM 20-50-10	APPLICATION OF STENCILS, INSIGNIA, SILK SCREEN, PART NUMBERING AND IDENTIFICATION MARKINGS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

C. Procedure

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

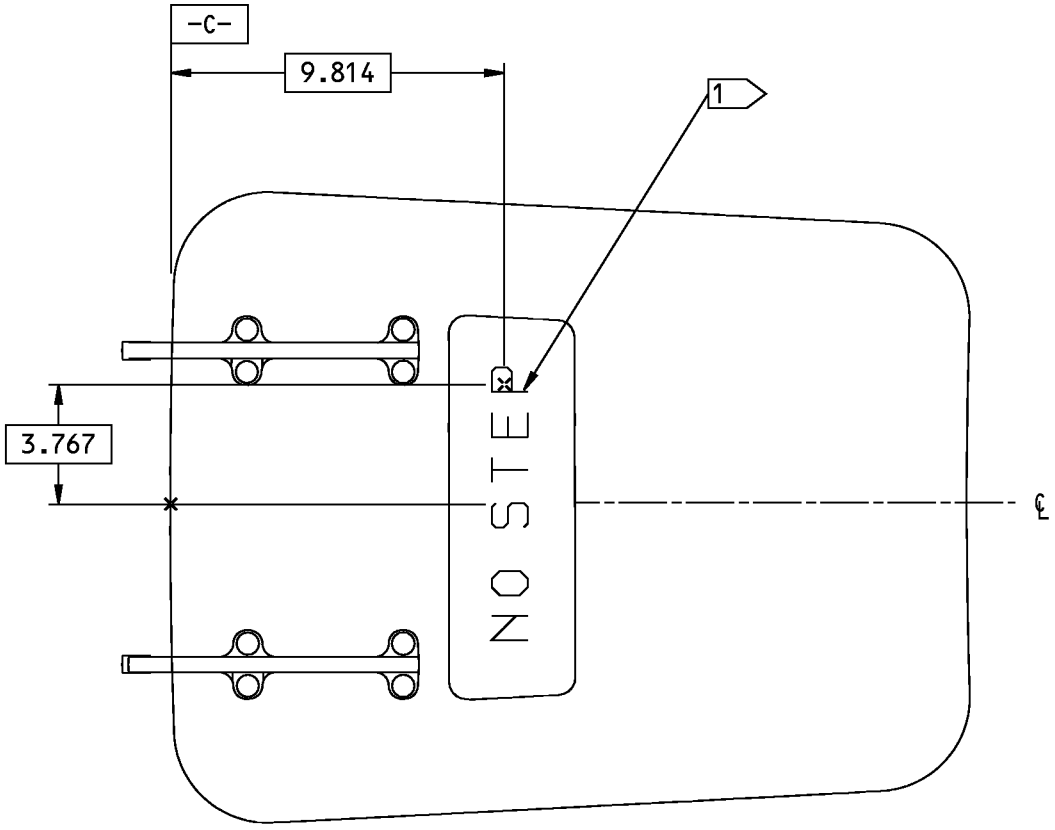
(1) Instructions for the repair of the parts listed in REPAIR 1-1, Table 601 is for repair of the initial finish.

Table 601: Refinish Details

IPL FIG. & ITEM	MATERIAL	FINISH
IPL Fig. 1		
Door assembly (1A)		Refer to REPAIR 1-1, Figure 601. Stencil letters as specified in SOPM 20-50-10 with enamel coating, C00032, color 101 red gloss or enamel, C50057, color 311336. Apply enamel coating, C50066 or sealant, A50071 (SOPM 20-44-04).
Fillers (40, 45, 140)	Al Alloy	Chromic acid anodize and apply primer, C00259 (F-18.13).
Pin (65)	17-4 PH CRES 180-200 ksi	Passivate (F-17.25, which replaces F-17.09).
Pin Holder Plate (85)	Al Alloy	Chemical treat and apply primer, C00259 (F-18.06).
End Fitting (108)	Stainless Steel Bar	Passivate (F-17.25, which replaces F-17.09).
Spring (108H)	Spring Steel Wire	Cadmium plate and apply primer, C00259 (F-16.03).
Tube Assembly (109, 109H)	Stainless Steel Tube	Apply a layer of lubricant, D00113 to the siding surfaces of the tubes as specified in SOPM 20-50-08.
Jury Strut Fitting (125)	Al Alloy	Chromic acid anodize and apply primer, C00259 (F-18.13).
Latch Tee (200)	Al Alloy	Chromic acid anodize and apply primer, C00259 (F-18.13).
Latch Support (220)	Al Alloy	Chemical treat and apply primer, C00259 (F-18.06).
Filler (245)	Al Alloy	Chemical treat (F-17.07). Apply primer, C00259 (F-20.03).
Pan (250)	Al Alloy	Chromic acid anodize and apply primer, C00259 (F-18.13).
Door Skin (255)	Al Alloy	On the inside surfaces, boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31) and apply primer, C00259 (F-20.03). On the outside surfaces, apply no finish (F-25.01).
IPL Fig. 2		
Door Assembly (1A)		Refer to REPAIR 1-1, Figure 601. Stencil letters as specified in SOPM 20-50-10 with enamel coating, C00032, color 101 red gloss or enamel, C50057, color 311336. Apply coating, C50066 or sealant, A50071 (SOPM 20-44-04).
Fillers (40, 45)	Al Alloy	Chemical treat (F-17.07). Apply primer, C00259 (F-20.02).
Pin (110)	17-4 PH CRES 180-200 ksi	Passivate (F-17.25, which replaces F-17.09).
Pin Holder Plate (130)	Al Alloy	Chemical treat and apply primer, C00259 (F-18.06).
End Fitting (180)	Stainless Steel Bar	Passivate (F-17.25, which replaces F-17.09).
Spring (185)	Spring Steel Wire	Cadmium plate and apply primer, C00259 (F-16.03).
Tube Assembly (190, 195)	Stainless Steel Tube	Apply a layer of lubricant, D00113 to the sliding surfaces of the tubes as specified in SOPM 20-50-08.
Jury Strut Fitting (220)	Al Alloy	Chromic acid anodize and apply primer, C00259 (F-18.13).

Table 601: Refinish Details (Continued)

IPL FIG. & ITEM	MATERIAL	FINISH
Filler (235)	Al Alloy	Chromic acid anodize and apply primer, C00259 (F-18.13).
Angle Latch (330, 335)	Al Alloy	Chemical treat (F-17.07). Apply primer, C00259 (F-20.02).
Angle Latch Support (355)	Al Alloy	Chemical treat (F-17.07). Apply primer, C00259 (F-20.02).
Pan (370)	Al Alloy	Chromic acid anodize and apply primer, C00259 (F-18.13).
Pan (370A)	Al Alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02).
Door Skin (375)	Al Alloy	On the inside surfaces, boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31) and apply primer, C00259 (F-20.03). On the outside surfaces, apply no finish (F-25.01).
IPL Fig. 3		
Door Assembly (1A)		Refer to REPAIR 1-1, Figure 602. Stencil letters as specified in SOPM 20-50-10 with enamel coating, C00032, color 101 red gloss.
Filler (30)	Al Alloy	Chemical treat (F-17.07). Apply primer, C00259 (F-20.02).
Pin (90)	17-4 PH CRES 180-200 ksi	Passivate (F-17.25, which replaces F-17.09).
Pin Holder Plate (110)	Al Alloy	Chemical treat and apply primer, C00259 (F-18.06).
End Fitting (155)	Stainless Steel Bar	Passivate (F-17.25, which replaces F-17.09).
Spring (161)	Spring Steel Wire	Cadmium plate and apply primer, C00259 (F-16.03).
Tube Assembly (170)	Stainless Steel Tube	Apply a layer of lubricant, D00113 to the sliding surfaces of the tubes as specified in SOPM 20-50-08.
Jury Strut Fitting (195)	Al Alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31) and apply primer, C00259 (F-20.02).
Filler (210)	Al Alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02).
Angle Latch (290, 295)	Al Alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02).
Angle Latch Support (310)	Al Alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02).
Door Skin (325)	Al Alloy	On inside surface, boric acid-sulfuric acid or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02). On outside surface, apply no finish (F-25.01).
Pan (330)	Al Alloy	Boric acid-sulfuric acid anodize, or chromic acid anodize (F-17.31). Apply primer, C00259 (F-20.02).
Pan (330A, 330B)	Ti Alloy	Prepare surface (F-14.882). Apply primer, C00259 (F-20.03).



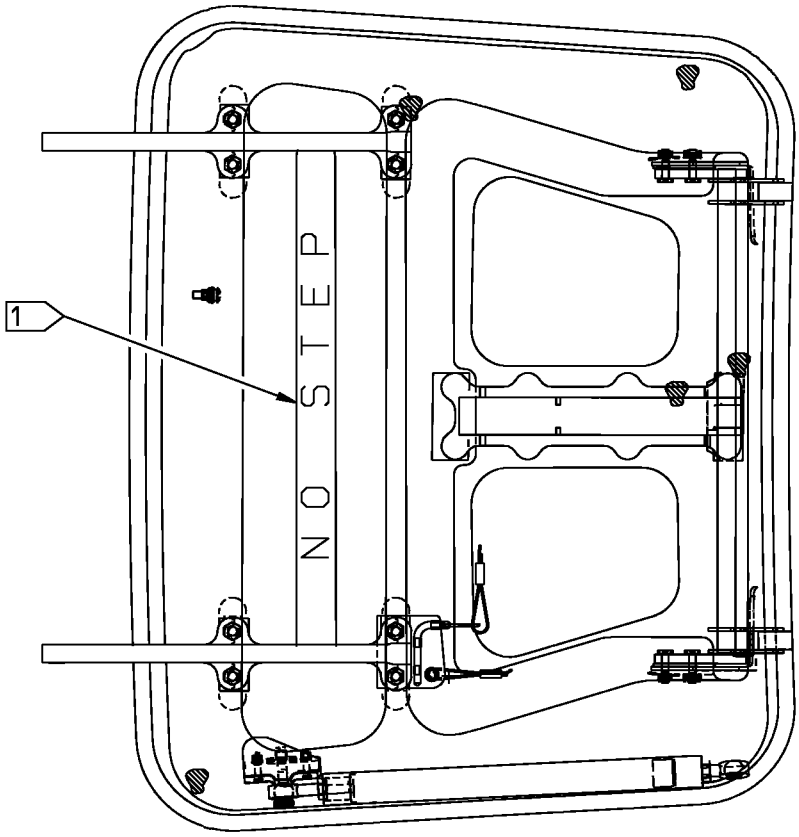
148A6110-1 SHOWN
148A6110-6,-7,-8,-14,-15
ALMOST THE SAME

1 PAINT THE WORDS - NO STEP - IN LETTER 1.5 INCHES HIGH, IN THIS LOCATION

ALL DIMENSIONS ARE IN INCHES

G42013 S00041002635_V2

Access and Blowout Door Assembly Refinish
Figure 601



148A6110-9,-10,-11,-13,-16

1 PAINT THE WORDS - NO STEP - IN LETTER 0.75 INCHES HIGH, IN THIS LOCATION

1565172 S0000288688_V1

Access and Blowout Door Assembly Refinish
Figure 602

HINGE ASSEMBLY - REPAIR 2-1

65-67747–1, –6, 148A6160–1

1. General

A. This procedure has the data necessary to repair and refinish the hinge assembly (IPL Figure 1, 20; IPL Figure 2, 50; IPL Figure 3, 35).

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

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

D. Refer to IPL Figure 1, IPL Figure 2, and IPL Figure 3 for item numbers.

2. Bearing Replacement

A. References

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

B. Procedure

(1) Remove the bearing (IPL Figure 1, 25; IPL Figure 2, 55; IPL Figure 3, 40) from the hinge assembly (IPL Figure 1, 20; IPL Figure 2, 50; IPL Figure 3, 35).

(2) Install the bearing (IPL Figure 1, 25; IPL Figure 2, 55; IPL Figure 3, 40) into hinge (IPL Figure 1, 30; IPL Figure 2, 60; IPL Figure 3, 45) as specified in SOPM 20-50-03.

(3) The bearing must stick out the same amount on the two ends within 0.01 inch.

3. Bearing 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

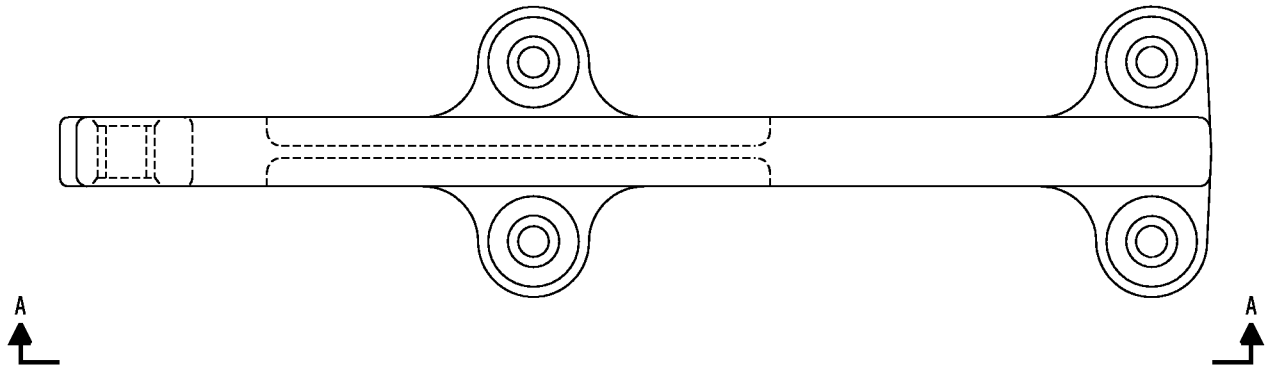
B. References

Reference	Title
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-50-08	APPLICATION OF BONDED SOLID FILM LUBRICANTS

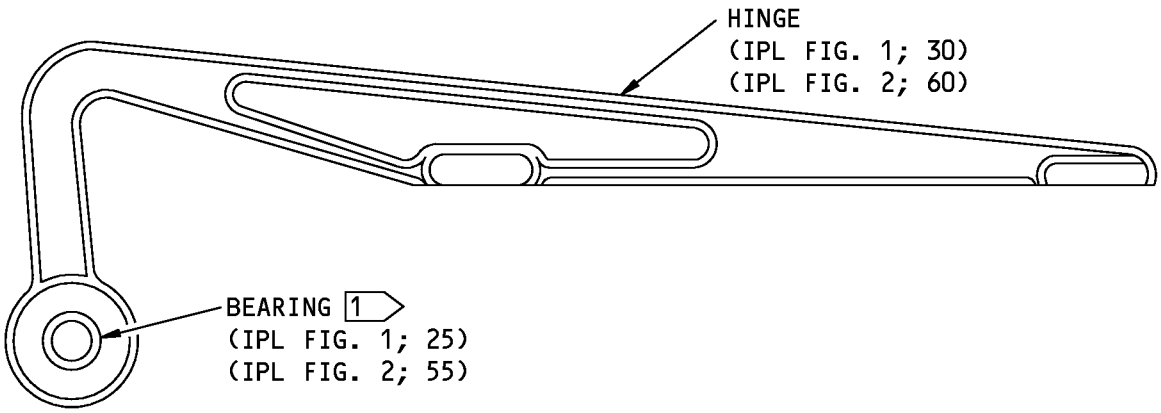
C. Procedure

NOTE: For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For application of bonded solid-film lubricants, refer to SOPM 20-50-08.

(1) Apply lubricant, D00113 to the bearing (IPL Figure 1, 25; IPL Figure 2, 55; IPL Figure 3, 40) inside diameter.



65-67747-1 SHOWN
65-67747-6 SIMILAR



A-A

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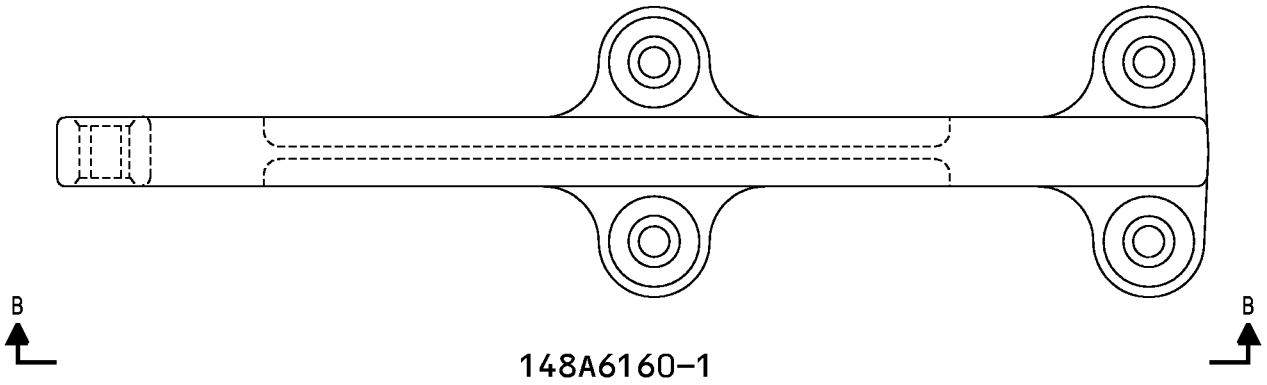
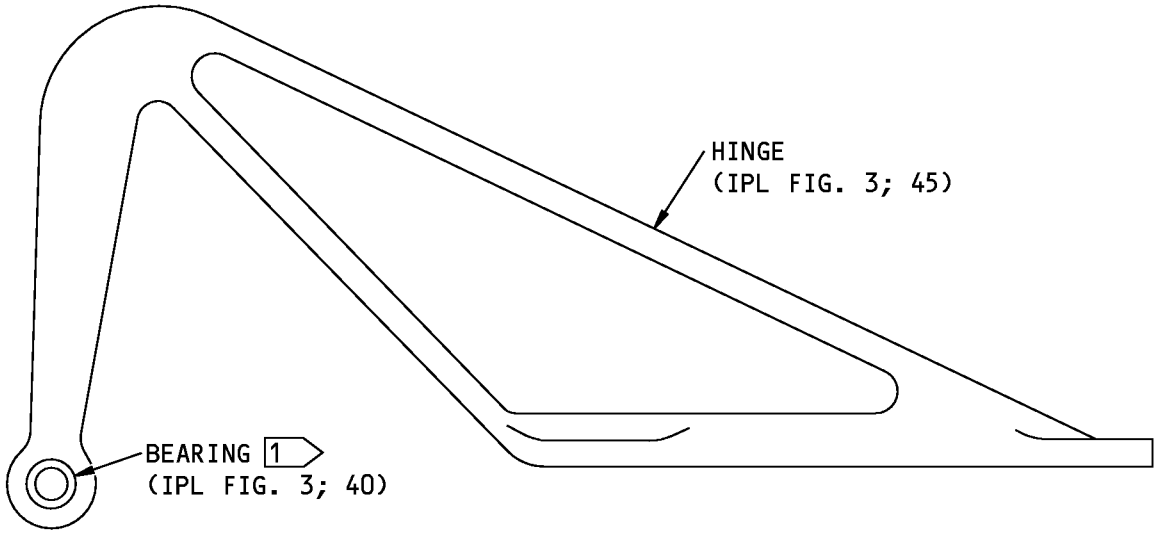
Hinge Bearing Replacement
Figure 601 (Sheet 1 of 2)





B–B

1 INSTALL BEARING AS SPECIFIED IN SOPM 20-50-03. THE BEARING MUST STICK OUT ON BOTH SIDES THE SAME AMOUNT, TO WITHIN 0.01 INCH

1565171 S0000288689_V1

Hinge Bearing Replacement
Figure 601 (Sheet 2 of 2)

HINGE - REPAIR 2-2

65-67747–2, –5, 148A6160–2

1. General

A. This procedure has the data necessary to repair and refinish the hinge (IPL Figure 1, 30; IPL Figure 2, 60; IPL Figure 3, 45).

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

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

D. Refer to IPL Figure 1, IPL Figure 2, and IPL Figure 3 for item numbers.

E. General repair details:

(1) Material: Aluminum alloy

2. Repair

A. References

Reference	Title
SOPM 20-20-02	PENETRANT METHODS OF INSPECTION

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

(1) Machine the hole, for the bearing (IPL Figure 1, 25; IPL Figure 2, 55; IPL Figure 3, 40), in the hinge (IPL Figure 1, 30; IPL Figure 2, 60; IPL Figure 3, 45) to remove defects, to the repair limit as shown in REPAIR 2-2, Figure 601.

(2) Do a penetrant check of the hinge (IPL Figure 1, 30; IPL Figure 2, 60; IPL Figure 3, 45) (SOPM 20-20-02).

(3) Manufacture the oversize bearing as shown in REPAIR 2-2, Figure 602 to adjust for the material removed in REPAIR 2-2, Paragraph 2.B.(1).

(4) Install the oversize bearing as shown in REPAIR 2-1.

3. 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

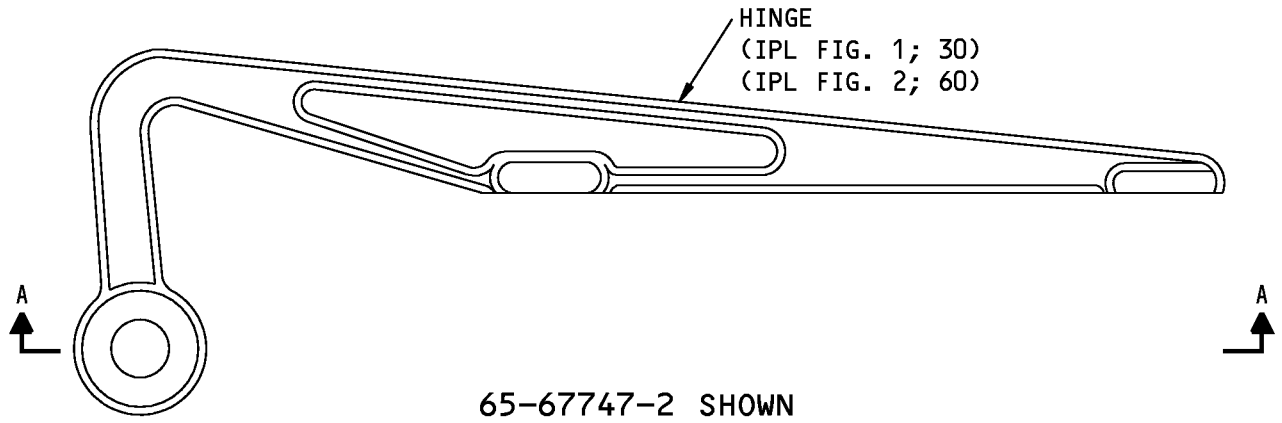
C. Procedure (REPAIR 2-2, Figure 601)

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

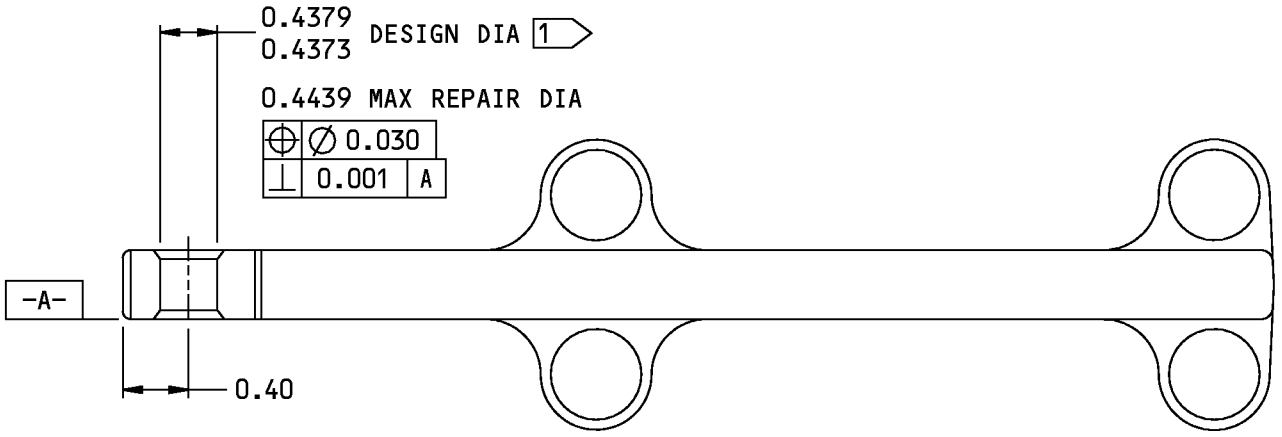
(1) For hinge 65-67747-2: chemical treat or chromic acid anodize and apply primer, C00259 (SRF-2.30). Do not apply primer, C00259 in the hole for the bearing.

(2) For hinge 65-67747-5: Chromic acid anodize and apply primer, C00259 (F-18.13). Do not apply primer, C00259 in the hole for the bearing.

(3) For hinge 148A6160-2: Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.31), and apply primer, C00259 (F-20.02). Do not apply primer, C00259 in the hole for the bearing.



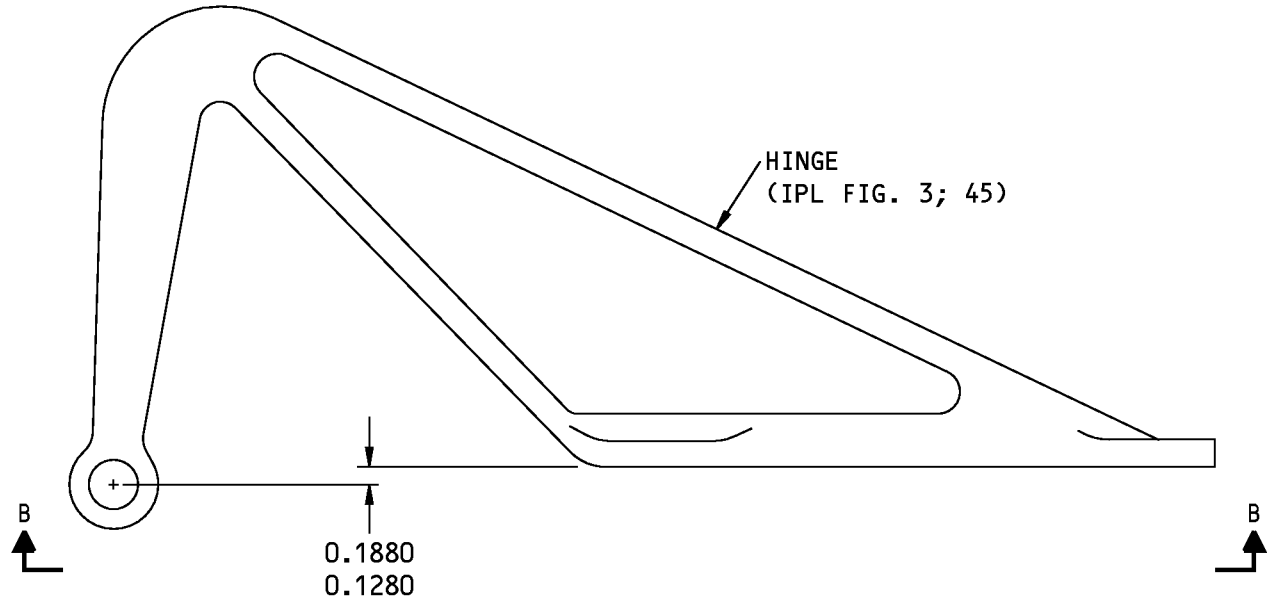
65-67747-2 SHOWN
65-67747-5 SIMILAR



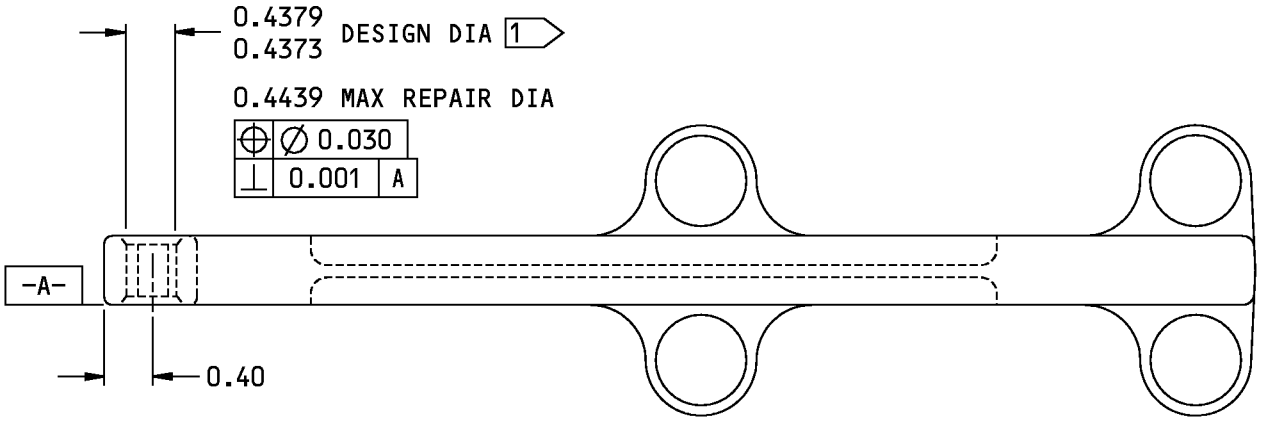
A-A

G44211 S00041002639_V2

Hinge Repair
Figure 601 (Sheet 1 of 2)



148A6160-2



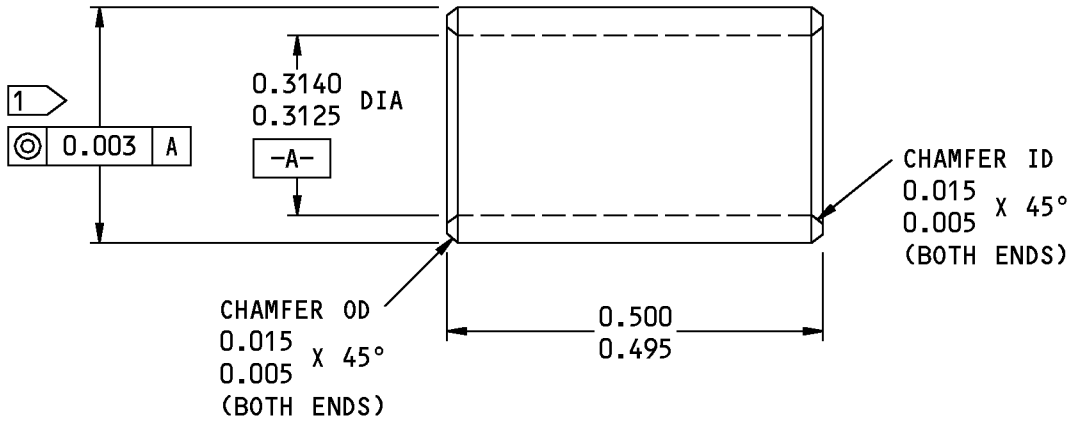
B-B

1 APPLY NO PRIMER IN THE INSIDE DIAMETER

ALL DIMENSIONS ARE IN INCHES

1565170 S0000288782_V1

Hinge Repair
Figure 601 (Sheet 2 of 2)



1 THE FINAL BEARING OUTSIDE DIAMETER EQUALS THE REPAIR DIAMETER OF FITTING PLUS 0.0002-0.0013 INCH INTERFERENCE

32 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

ALL DIMENSIONS ARE IN INCHES

G41986 S00041002640_V2

Oversize Bearing Details
Figure 602

ASSEMBLY

1. General

A. This procedure has the data necessary to assemble the access and blowout 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, IPL Figure 2, and IPL Figure 3 for 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

B. References

Reference	Title
SOPM 20-11-03	REPAIR OF ELECTRICAL TERMINATIONS AND ELECTRICAL BONDING AREAS
SOPM 20-50-01	BOLT AND NUT INSTALLATION
SOPM 20-50-02	INSTALLATION OF SAFETYING DEVICES
SOPM 20-50-19	GENERAL SEALING
SOPM 20-60-04	MISCELLANEOUS MATERIALS

C. Procedure

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

(1) Use standard industry procedures and the following steps to assemble this component:

(2) Install the jury strut fitting (IPL Figure 1, 125; IPL Figure 2, 220; IPL Figure 3, 195).

(a) Apply wet sealant, A00247 to the surfaces that touch between the jury strut fitting (IPL Figure 1, 125; IPL Figure 2, 220; IPL Figure 3, 195) and the door pan (IPL Figure 1, 250; IPL Figure 2, 370; IPL Figure 3, 330).

(b) Apply wet sealant, A00247 to the surfaces that touch between the filler (IPL Figure 1, 140; IPL Figure 2, 235; IPL Figure 3, 210) and the door pan (IPL Figure 1, 250; IPL Figure 2, 370; IPL Figure 3, 330).

(c) Apply wet sealant, A00247 (F-19.48) to the bolts (IPL Figure 1, 110A, 225; IPL Figure 2, 200, 205; IPL Figure 3, 180).

(d) Install the bolts (IPL Figure 1, 110A, 225; IPL Figure 2, 200, 205; IPL Figure 3, 180), washers (IPL Figure 1, 115; IPL Figure 2, 210; IPL Figure 3, 185), jury strut fitting (IPL Figure 1, 125; IPL Figure 2, 220; IPL Figure 3, 195), filler (IPL Figure 1, 140; IPL Figure 2, 235; IPL Figure 3, 210) and the nuts (IPL Figure 1, 120, 230; IPL Figure 2, 215; IPL Figure 3, 190) onto the door pan (IPL Figure 1, 250; IPL Figure 2, 370; IPL Figure 3, 330).

(3) Install the hinge assemblies (IPL Figure 1, 20; IPL Figure 2, 50; IPL Figure 3, 35).

(a) Apply wet sealant, A00247 to the surfaces that touch between the door pan (IPL Figure 1, 250; IPL Figure 2, 370; IPL Figure 3, 330) and pin holder assembly (IPL Figure 1, 70; IPL Figure 2, 115; IPL Figure 3, 95) and the hinge assembly (IPL Figure 1, 20; IPL Figure 2, 50; IPL Figure 3, 35).

(b) Install the pin holder assembly (IPL Figure 1, 70; IPL Figure 2, 115; IPL Figure 3, 95) and the hinge assembly (IPL Figure 1, 20; IPL Figure 2, 50; IPL Figure 3, 35) that is adjacent to the jury strut fitting (IPL Figure 1, 125; IPL Figure 2, 220; IPL Figure 3, 195) onto the door pan (IPL Figure 1, 250; IPL Figure 2, 370; IPL Figure 3, 330) with bolts (IPL Figure 1, 5; IPL Figure 2, 5; IPL Figure 3, 5). Install bolts (IPL Figure 1, 5; IPL Figure 2, 5; IPL Figure 3, 5) with wet sealant, A00247 (F-19.48).

NOTE: Shims (IPL Figure 1, 35; IPL Figure 2, 65; IPL Figure 3, 50, 55) and filler (IPL Figure 1, 40, 45; IPL Figure 2, 40, 45; IPL Figure 3, 30) were installed with sealant, A00247 on mating surfaces as specified in SOPM 20-50-19.

(c) Install the second hinge assembly (IPL Figure 1, 20; IPL Figure 2, 50; IPL Figure 3, 35) onto the door pan (IPL Figure 1, 250; IPL Figure 2, 370; IPL Figure 3, 330) with bolts (IPL Figure 1, 5; IPL Figure 2, 5; IPL Figure 3, 5). Install bolts (IPL Figure 1, 5; IPL Figure 2, 5; IPL Figure 3, 5) with wet sealant, A00247 (F-19.48).

NOTE: Shims (IPL Figure 1, 35; IPL Figure 2, 65, 70A; IPL Figure 3, 50, 52) and filler (IPL Figure 1, 40, 45; IPL Figure 2, 40, 45; IPL Figure 3, 30) were installed with sealant, A00247 on mating surfaces as specified in SOPM 20-50-19.

(d) Assemble the retaining pin assembly (IPL Figure 1, 50; IPL Figure 2, 95; IPL Figure 3, 75) by putting the cable assembly (IPL Figure 1, 60; IPL Figure 2, 105; IPL Figure 3, 85) and pin (IPL Figure 1, 65; IPL Figure 2, 110; IPL Figure 3, 90) on the hook (IPL Figure 1, 55; IPL Figure 2, 100; IPL Figure 3, 80) and closing the loops. The hook (IPL Figure 1, 55; IPL Figure 2, 100; IPL Figure 3, 80) shall be able withstand a force of 40 pounds without permanently opening the loops more than 1/32 inch.

(e) Install the retaining pin assembly (IPL Figure 1, 50; IPL Figure 2, 95; IPL Figure 3, 75) onto the pin holder assembly (IPL Figure 1, 70; IPL Figure 2, 115; IPL Figure 3, 95) with screw (IPL Figure 1, 46; IPL Figure 2, 75; IPL Figure 3, 60), washers (IPL Figure 1, 47, 48; IPL Figure 2, 80, 85; IPL Figure 3, 65), and nut (IPL Figure 1, 49; IPL Figure 2, 90; IPL Figure 3, 70).

(4) Install the latch assembly (IPL Figure 1, 160; IPL Figure 2, 265; IPL Figure 3, 230A).

(a) Apply wet sealant, A00247 to the surfaces that touch between the latch assembly (IPL Figure 1, 160; IPL Figure 2, 265; IPL Figure 3, 230A), shims (IPL Figure 1, 165, 167, 170A; IPL Figure 2, 270, 275; IPL Figure 3, 235, 240), latch support angle (IPL Figure 3, 310), and door pan (IPL Figure 1, 250; IPL Figure 2, 370; IPL Figure 3, 330).

(b) Apply wet sealant, A00247 (F-19.48) to the bolts (IPL Figure 1, 145, 150; IPL Figure 2, 240, 245, 250; IPL Figure 3, 215) and nuts (IPL Figure 1, 155; IPL Figure 2, 260; IPL Figure 3, 220).

(c) Install the latch assembly (IPL Figure 1, 160; IPL Figure 2, 265; IPL Figure 3, 230A) onto the latch support angle (IPL Figure 3, 310) and the door pan (IPL Figure 1, 250; IPL Figure 2, 370; IPL Figure 3, 330) with the shims (IPL Figure 1, 165, 167, 170A; IPL Figure 2, 270, 275; IPL Figure 3, 235, 240), bolts (IPL Figure 1, 145, 150; IPL Figure 2, 240, 245, 250; IPL Figure 3, 215), and nuts (IPL Figure 1, 155; IPL Figure 2, 260; IPL Figure 3, 220).

(d) If not already done, remove the cotter pin and install the washers (IPL Figure 1, 157; IPL Figure 2, 260; IPL Figure 3, 225), and cotter pin as specified in SOPM 20-50-02.

(5) Install the jumper assembly (IPL Figure 1, 105; IPL Figure 2, 150; IPL Figure 3, 130).

(a) Install the stud (IPL Figure 1, 90; IPL Figure 2, 135; IPL Figure 3, 115) onto the door pan (IPL Figure 1, 250; IPL Figure 2, 370; IPL Figure 3, 330) as specified in SOPM 20-11-03.

(b) Install the jumper assembly (IPL Figure 1, 105; IPL Figure 2, 150; IPL Figure 3, 130) onto the stud (IPL Figure 1, 90; IPL Figure 2, 135; IPL Figure 3, 115), with washer (IPL Figure 1, 95; IPL Figure 2, 140; IPL Figure 3, 120), and nut (IPL Figure 1, 100; IPL Figure 2, 145; IPL Figure 3, 125) as specified in SOPM 20-11-03.

(6) Install the jury strut assembly (IPL Figure 1, 106; IPL Figure 2, 160; IPL Figure 3, 140) on the jury strut fitting (IPL Figure 1, 125; IPL Figure 2, 220; IPL Figure 3, 195).

(a) Install the jury strut assembly (IPL Figure 1, 106; IPL Figure 2, 160; IPL Figure 3, 140) and the bolt (IPL Figure 1, 105H; IPL Figure 2, 155; IPL Figure 3, 135).

(b) Tighten the bolt (IPL Figure 1, 105H; IPL Figure 2, 155; IPL Figure 3, 135) as necessary, to a maximum of 30 pound-inches to hold the jury strut assembly (IPL Figure 1, 106; IPL Figure 2, 160; IPL Figure 3, 140) to the door pan (IPL Figure 1, 250; IPL Figure 2, 370; IPL Figure 3, 330).

FITS AND CLEARANCES

REF LETTER	REF IPL		DESIGN DIMENSION				SERVICE WEAR LIMIT		
	FIG. NO.	MATING ITEM NO.	DIMENSION		ASSEMBLY CLEARANCE 1		DIMENSION		MAXIMUM CLEARANCE
			MIN	MAX	MIN	MAX	MIN	MAX	
--	1	ID 30 OD 25	0.4373 0.4381	0.4379 0.4386	-0.0002	-0.0013	0.4378	0.4382	0.0004
--	2	ID 60 OD 55	0.4373 0.4381	0.4379 0.4386	-0.0002	-0.0013	0.4378	0.4382	0.0004
--	3	ID 45 OD 40	0.4373 0.4381	0.4379 0.4386	-0.0002	-0.0013	0.4378	0.4382	0.0004

1 NEGATIVE VALUES DENOTE INTERFERENCE FIT

ALL DIMENSIONS ARE IN INCHES

G42024 S00041002643_V3

Fits and Clearances
Figure 801

REF IPL		NAME	TORQUE*	
FIG. NO.	ITEM NO.		POUND-INCHES	POUND-FEET
1	105H	Bolt	30 (Maximum)	
2	155	Bolt	30 (Maximum)	
3	135	Bolt	30 (Maximum)	

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

G43228 S00041002644_V2

Torque Table
Figure 802

(NOT APPLICABLE)

ILLUSTRATED PARTS LIST

1. Introduction

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

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

1 2 3 4 5 6 7

. Assembly

. Attaching parts for assembly

. . Detail parts for assembly

. . Subassembly

. . Attaching parts for subassembly

. . . Detail parts for subassembly

. . . Sub-subassembly

. . . Attaching parts for subassembly

. . . . . Details parts for sub-subassembly

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

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

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

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

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

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

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

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

H. Interchangeable Parts

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

VENDOR CODES

Code	Name
02758	NETWORKS ELECTRONIC CORP U S BEARING DIV 9750 DE SOTO AVENUE CHATSWORTH, CALIFORNIA 91311-4409 FORMERLY U S BEARING DIV NETWORKS ELEC CORP
06725	AIR INDUSTRIES CORPORATION 12570 KNOTT STREET GARDEN GROVE, CALIFORNIA 92641-3932 FORMERLY AIR INDUSTRIES OF CALIF IN GARDENA, CALIF.
06950	SCREWCORP VSI AEROSPACE PRODUCTS DIV FAIRCHILD IND DIV 13001 EAST TEMPLE AVENUE PO BOX 730 CITY OF INDUSTRY, CALIFORNIA 91746-1417 FORMERLY VB0096 AND VSI CORP SCREWCORP DIV FORMERLY IN CULVER CITY, CALIFORNIA SCREW CORP SEE V.S.I. CORP SCREWCORP DIVISION
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

Code	Name
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
17446	HUCK INTL INC AEROSPACE FASTENER DIV 900 WATSON CENTER ROAD CARSON, CALIFORNIA 90745-4201 FORMERLY V32134 REXNORD INC; FORMERLY V97928 HUCK INTL
52828	REPUBLIC FASTENER MFG CORP 1300 RANCHO CONEJO BLVD NEWBURY PARK, CALIFORNIA 91320-1405 FORMERLY IN SYLMAR, CALIFORNIA
56644	AURORA BEARING CO 970 SOUTH LAKE STREET AURORA, ILLINOIS 60506-5929
56878	SPS TECHNOLOGIES INC AEROSPACE AND INDUSTRIAL PRODUCTS DIV 301 HIGHLAND AVE JENKINTOWN, PENNSYLVANIA 19046 FORMERLY STANDARD PRESSED STEEL FORMERLY IN SALT LAKE, UTAH
5M902	ALCOA GLOBAL FASTENERS INC, DIV OF VOI-SHAN PRODUCTS 3000 W LOMITA BLVD TORRANCE, CALIFORNIA 90505-5103 FORMERLY FAIRCHILD INC INC FAIRCHILD AEROSPACE FASTENERS DIV
60516	WEST COAST AEROSPACE INC 812 MIRAFLORES STREET SAN PEDRO, CALIFORNIA 90731-1439
62554	SIMMONDS MECAERO FASTENERS INC 1734 SEQUOIA AVENUE ORANGE, CALIFORNIA 92668

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
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
92215	FAIRCHILD IND INC FAIRCHILD AEROSPACE FASTENER DIV 3010 W LOMITA BLVD TORRANCE, CALIFORNIA 90505-5102 FORMERLY VOI-SHAN IN CULVER CITY, CALIF
97928	Replaced: [V97928] SEE V17446 HUCK INTL by Code: Name and Address below 17446: HUCK INTL INC AEROSPACE FASTENER DIV 900 WATSON CENTER ROAD CARSON, CALIFORNIA 90745-4201 FORMERLY V32134 REXNORD INC; FORMERLY V97928 HUCK INTL
99378	ATLEE OF DELAWARE INC NORTH ANDOVER BUSINESS PARK 10 BAYFIELD DRIVE NORTH ANDOVER, MASSACHUSETTS 01845 FORMERLY IN WINCHESTER AND WOBURN, MASSACHUSETTS

NUMERICAL INDEX

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
10-60779-174		1	107A	2
		2	170A	2
		3	145	2
10-61704-1		1	160	1
		2	265	1
10-61704-2		3	230A	1
100-225-2-10		1	80	3
		2	125	3
		3	105	3
102F9201-4		1	15	6
		1	135	1
		2	30	2
		2	230	1
102F9201M4		1	17	2
		2	35	2
		3	25	2
102F9209M3		1	181	2
		2	310	2
		3	265	2
148A6110-1		1	1A	RF
148A6110-10		1	1F	RF
		3	1B	RF
148A6110-11		1	1G	RF
		3	1C	RF
148A6110-13		1	1H	RF
		3	1D	RF
148A6110-14		1	1J	RF
		2	1D	RF
148A6110-15		1	1K	RF
		2	1E	RF
148A6110-16		1	1L	RF
		3	1E	RF
148A6110-2		1	178	1
148A6110-3		1	179	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
148A6110-4		1	182	1
148A6110-5		1	183	1
148A6110-6		1	1B	RF
		2	1A	RF
148A6110-7		1	1C	RF
		2	1B	RF
148A6110-8		1	1D	RF
		2	1C	RF
148A6110-9		1	1E	RF
		3	1A	RF
148A6111-1		2	370A	1
148A6111-2		3	330	1
148A6111-3		3	330A	1
148A6111-4		2	370B	1
148A6111-5		3	330B	1
148A6120-1		1	255	1
		2	375	1
148A6120-2		1	245	1
		2	365	1
148A6120-3		2	375A	1
148A6120-4		3	325	1
148A6121-1		2	335	1
148A6121-10		3	195	1
148A6121-11		3	295	1
148A6121-12		3	290	1
148A6121-15		3	310A	1
148A6121-2		2	330	1
148A6121-3		2	355	1
148A6121-9		3	310	1
148A6130-10		2	40	1
148A6130-11		2	20	2
148A6130-12		2	45	1
148A6130-13		3	15	4
148A6130-14		3	30	1
148A6130-15		3	255	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
148A6130-16		3	250	1
148A6130-17		3	210	1
148A6130-19		3	275	1
148A6130-20		3	270	1
148A6130-7		2	300	1
148A6130-8		2	295	1
148A6130-9		2	15	2
148A6150-1		3	140	1
148A6150-2		3	140A	1
148A6151-1		3	166	1
148A6151-2		3	170	1
148A6151-3		3	166A	1
148A6160-1		3	35	2
148A6160-2		3	45	1
65-54860-501		1	109	1
		2	190	1
65-54860-502		1	109H	1
		2	195	1
65-54860-503		1	106	1
		2	160	1
65-54860-6		1	50	1
		2	95	1
		3	75	1
65-67747-1		1	20	2
		2	50	2
65-67747-2		1	30	1
		2	60	1
65-67747-4		1	25	1
		2	55	1
		3	40	1
65-67747-5		1	30A	1
		2	60A	1
65-67747-6		1	20A	2
		2	50A	2
65C35118-1		1	250	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		2	370	1
65C35450-2		1	40	2
65C35450-4		1	140	1
		2	235	1
65C35450-5		1	45	2
65C36295-2		1	200	2
65C36295-4		1	125	1
		2	220	1
65C36295-5		1	220	1
65C36303-1		1	70	1
		2	115	1
		3	95	1
65C36303-2		1	85	1
		2	130	1
		3	110	1
69-41401-1		1	108H	1
		2	185	1
		3	161	1
69-41402-2		1	108	1
		2	180	1
		3	155	1
69-41407-1		1	65	1
		2	110	1
		3	90	1
ASMK4T21		1	107A	2
		2	170A	2
BACB30NM3K8		1	175A	4
		2	280	4
		3	245	4
BACB30NM4K15		1	105H	1
		2	155	1
BACB30NM4K17		3	135	1
BACB30NM4K5		1	5	8
BACB30NM4K7		2	5	8
		3	5	8

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACB30NN3K4		1	150	2
		2	250	2
BACB30NX5K4		1	110A	2
BACB30VF08K3		2	205	1
BACB30VF08K6		2	200	2
BACB30VF08K7		3	180	3
BACB30VF3K3		1	145	6
		2	245	4
BACB30VF3K5		2	240	2
		3	215	8
BACB30VT5K2		3	287	4
BACB30VT5K3		1	225	1
		3	286	8
BACB30YP5K2		3	317	69
		3	317A	1
BACB30YP6K3		3	283	4
BACC13Y3-130		1	60	1
		2	105	1
		3	85	1
BACC30BL5		1	230	1
		3	288	12
BACF3F008D020NN		2	70A	1
		3	55	1
BACF3F008G020NN		2	70B	1
BACF3F008L020NN		3	52	1
BACF3H07GH022AN		2	315	1
BACF3H07GH023AN		1	184	1
BACJ40A20-9		1	105	1
		2	150	1
		3	130	1
BACN10JN4CD		1	17	2
		2	35	2
		3	25	2
		3	205	1
BACN10JR4CFD		1	15	6

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		1	135	1
		2	30	2
		2	230	1
BACN10KH3CD		1	181	2
		2	310	2
		3	265	2
BACN10YR08CD		1	49	1
		1	120	2
		2	90	1
		2	215	3
		3	70	1
		3	190	3
BACN10YR3CD		1	100	1
		1	155	8
		2	145	1
		2	255	8
		3	125	1
		3	220	8
BACN11AJ5CS		3	318	69
		3	318A	1
BACN11AJ6CS		3	284	4
BACN11U5CD1		3	175	2
BACP18BE4C0750U		3	150A	4
BACR15BA3AD		3	247	4
BACR15BA5DC		3	320	4
BACR15BB3D		1	75	3
		1	176	2
		2	120	3
		2	285	2
		3	100	3
BACR15CE4M		3	10A	8
BACR15CE5M		3	322	9
BACR15CE6M		3	282	4
BACR15FT5D		1	215	8
		2	350	6

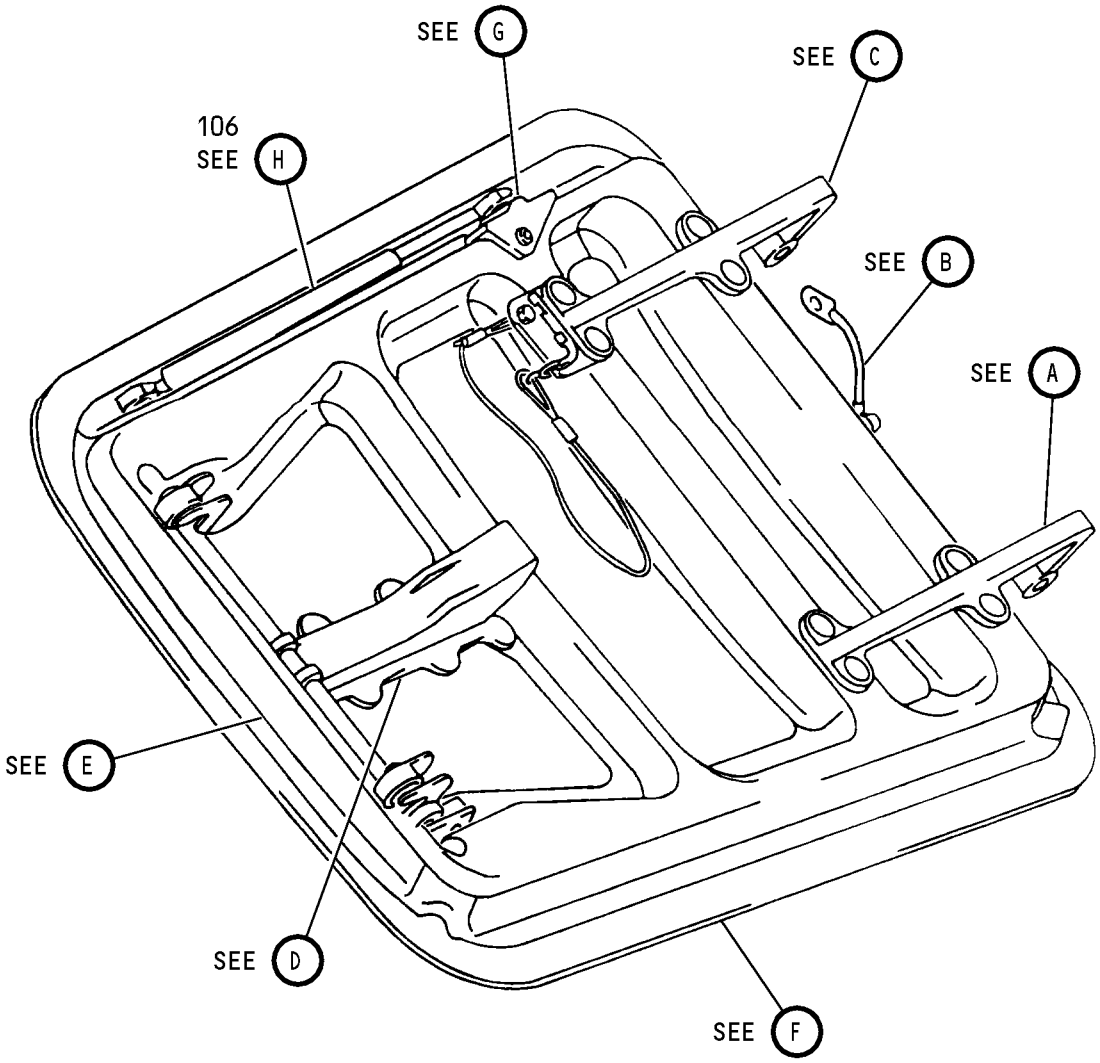
PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		3	285	12
BACR15FT6D		1	190	2
		2	325	2
BACR15GF3D		1	10	16
		1	130	2
		1	177	2
		1	180	4
		2	25	4
		2	225	2
		2	290	2
		2	305	4
		3	20	4
		3	200	2
		3	260	4
BACR15GF4D		1	235	8
		2	10	8
		3	10	8
BACR15GF5D		1	210	8
		1	240	93
		2	345	8
		2	360	91
		3	305	14
		3	315	75
		3	316	1
BACR15GF6D		1	195	2
		2	320	2
		3	280	4
BACS12GU08K6		1	46	1
		2	75	1
		3	60	1
BACS40R008A024F		2	275	AR
		3	240	AR
BACS40R008C020F		1	35	3
BACS40R008D016F		2	340	2
BACS40R008D017F		3	300	2

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACS40R008D018F		1	205A	2
BACS40R008D020F		2	65	2
BACS40R008D024F		1	165	1
BACS40R008E020F		3	50	2
BACS40R009C024F		2	270	1
BACS40R009C064F		1	170A	2
BACS40R009E024F		1	167	1
BACS40R010B024F		2	270A	1
		3	235	1
BACS53B1EA1		1	90	1
		2	135	1
BACS53B1ES1		3	115	1
BRF200C4D		1	15	6
		1	135	1
		2	30	2
		2	230	1
BRFM20C4D		1	17	2
		2	35	2
		3	25	2
FS1651-3		1	181	2
		2	310	2
		3	265	2
H52732-08CD		1	49	1
		1	120	2
		2	90	1
		2	215	3
		3	70	1
		3	190	3
H52732-3CD		1	100	1
		1	155	8
		2	145	1
		2	255	8
		3	125	1
		3	220	8
H942-1		1	160	1

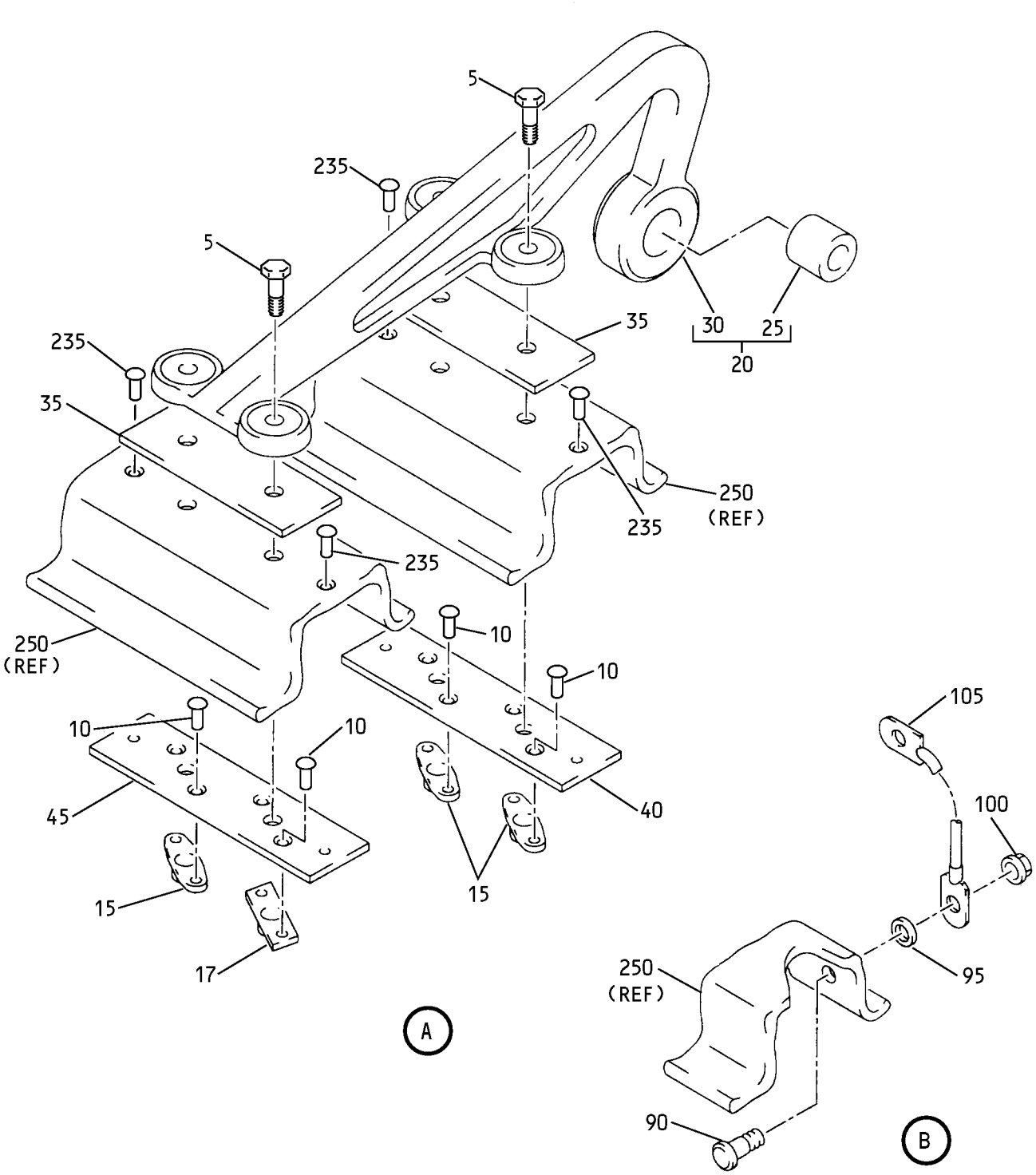
PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		2	265	1
H942-3		3	230A	1
HB4ETL186		1	107A	2
		2	170A	2
		3	145	2
HL1012AZ5-4		1	110A	2
		1	110A	2
		1	110A	2
		1	110A	2
		1	110A	2
		1	110A	2
		1	110A	2
		1	110A	2
HL12VAZ5-4		1	110A	2
		1	110A	2
		1	110A	2
		1	110A	2
HST10AG5-3		1	225	1
		1	225	1
		1	225	1
		1	225	1
HST79-5		1	230	1
		1	230	1
		1	230	1
HST79CY5		1	230	1
K51602-4BAC		1	15	6
		1	135	1
		2	30	2
		2	230	1
L802-5K4		1	110A	2
MF51637-4		1	17	2
		2	35	2
		3	25	2
MF53050-4CD		1	17	2
		2	35	2

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		3	25	2
MS16562-198		1	107H	4
		2	175	4
MS39086-108		3	150	4
NAS1090-1		1	55	1
		2	100	1
		3	80	1
NAS1149D0316J		1	95	1
		2	140	1
		3	120	1
NAS1149DN816J		1	48	1
		2	85	1
		3	65	1
		3	185	2
NAS1149DN832J		1	47	1
		1	115	2
		2	80	1
		2	210	2
NAS1149E0316P		2	260A	2
		3	225A	2
NAS1149E0332P		2	263A	1
		3	228A	1
NAS1149EN816P		1	157	3
		2	260	2
		2	260B	2
		2	263	1
		2	263B	1
		3	225	2
		3	225B	2
		3	228	1
		3	228B	1
NAS509-5		1	106H	2
		2	165	2
NS202476-048		1	15	6
		1	135	1

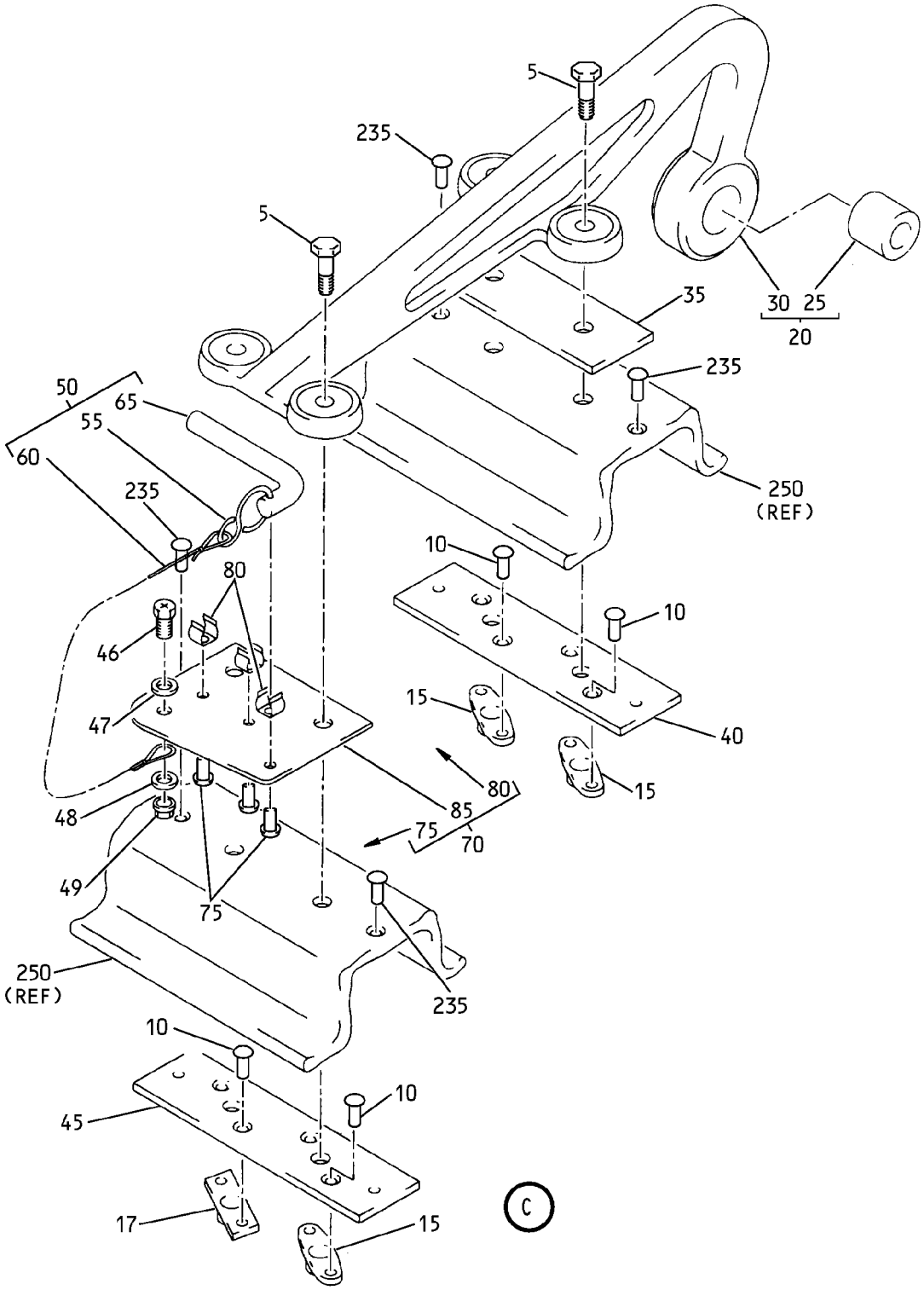
PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		2	30	2
		2	230	1
NS202487-048		1	17	2
		2	35	2
		3	25	2
NS202496-02		1	181	2
		2	310	2
		3	265	2
PLH508CD		1	49	1
		1	120	2
		2	90	1
		2	215	3
		3	70	1
		3	190	3
PLH53CD		1	100	1
		1	155	8
		2	145	1
		2	255	8
		3	125	1
		3	220	8
T8092C428CD		1	15	6
		1	135	1
		2	30	2
		2	230	1
T8301C428CD		1	17	2
		2	35	2
		3	25	2
VNS1924CA1-8		1	90	1
		2	135	1
VNS1924CA3-1-8		1	90	1
		2	135	1



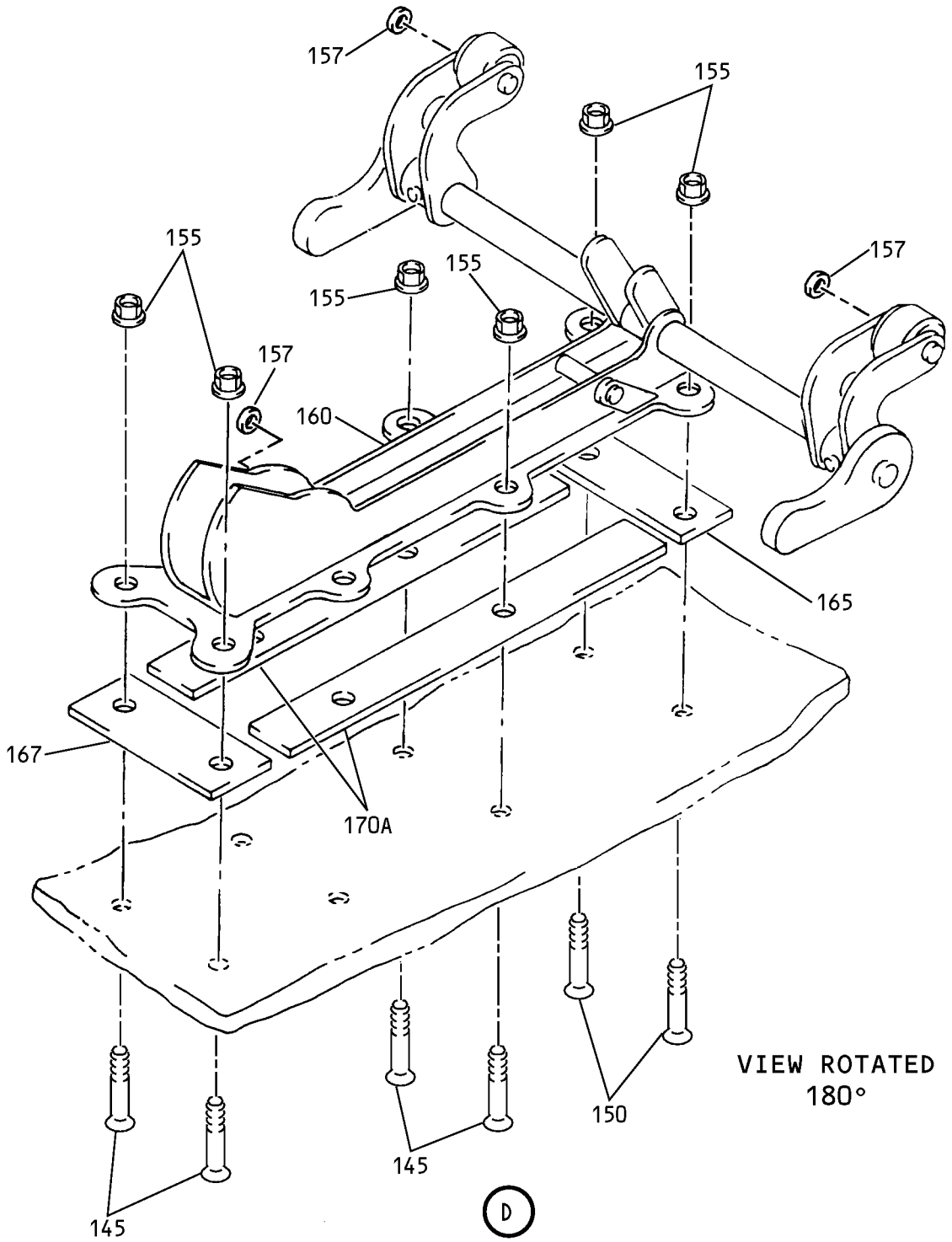
Access and Blowout Door Assembly
IPL Figure 1 (Sheet 1 of 8)



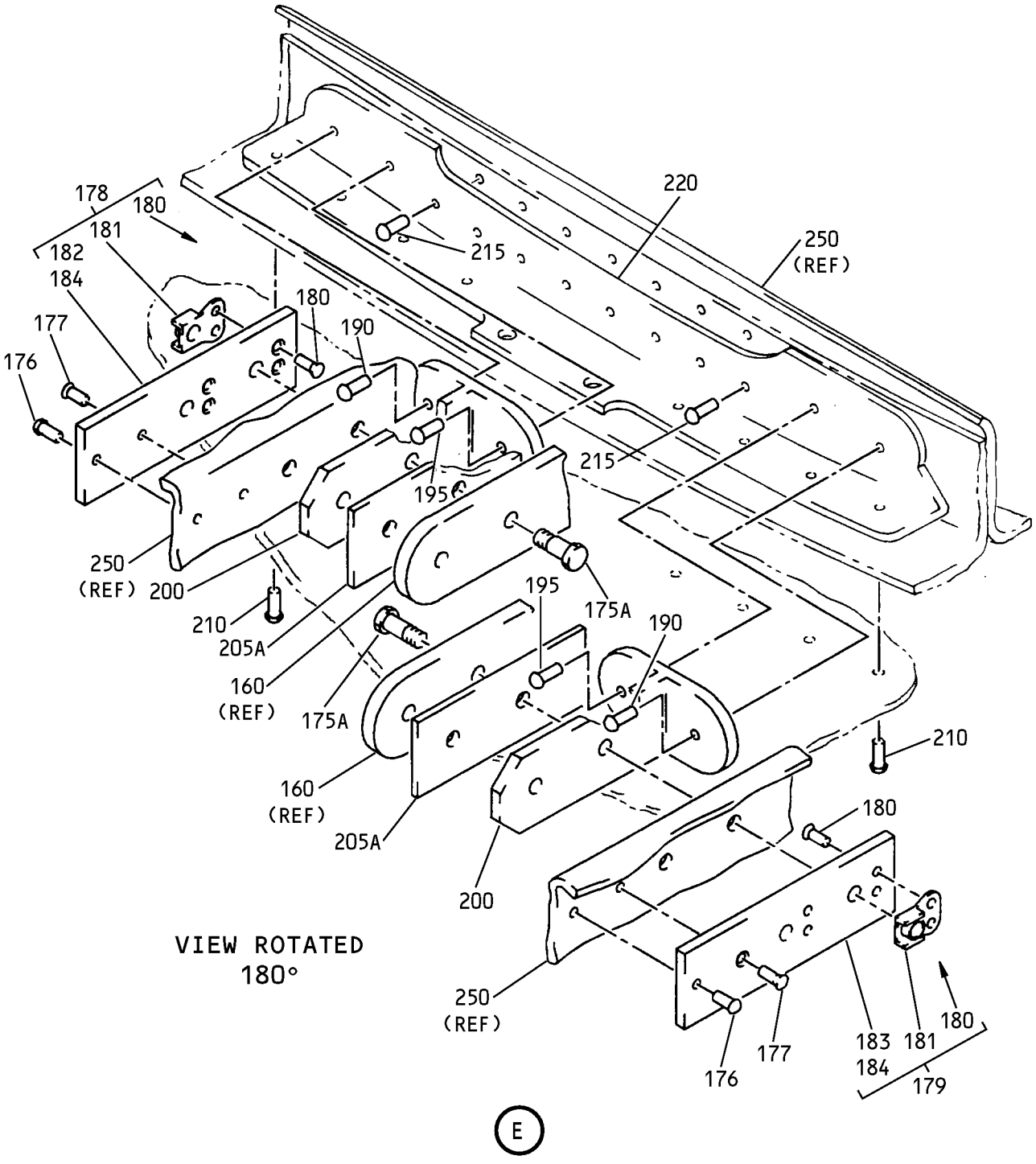
Access and Blowout Door Assembly
IPL Figure 1 (Sheet 2 of 8)



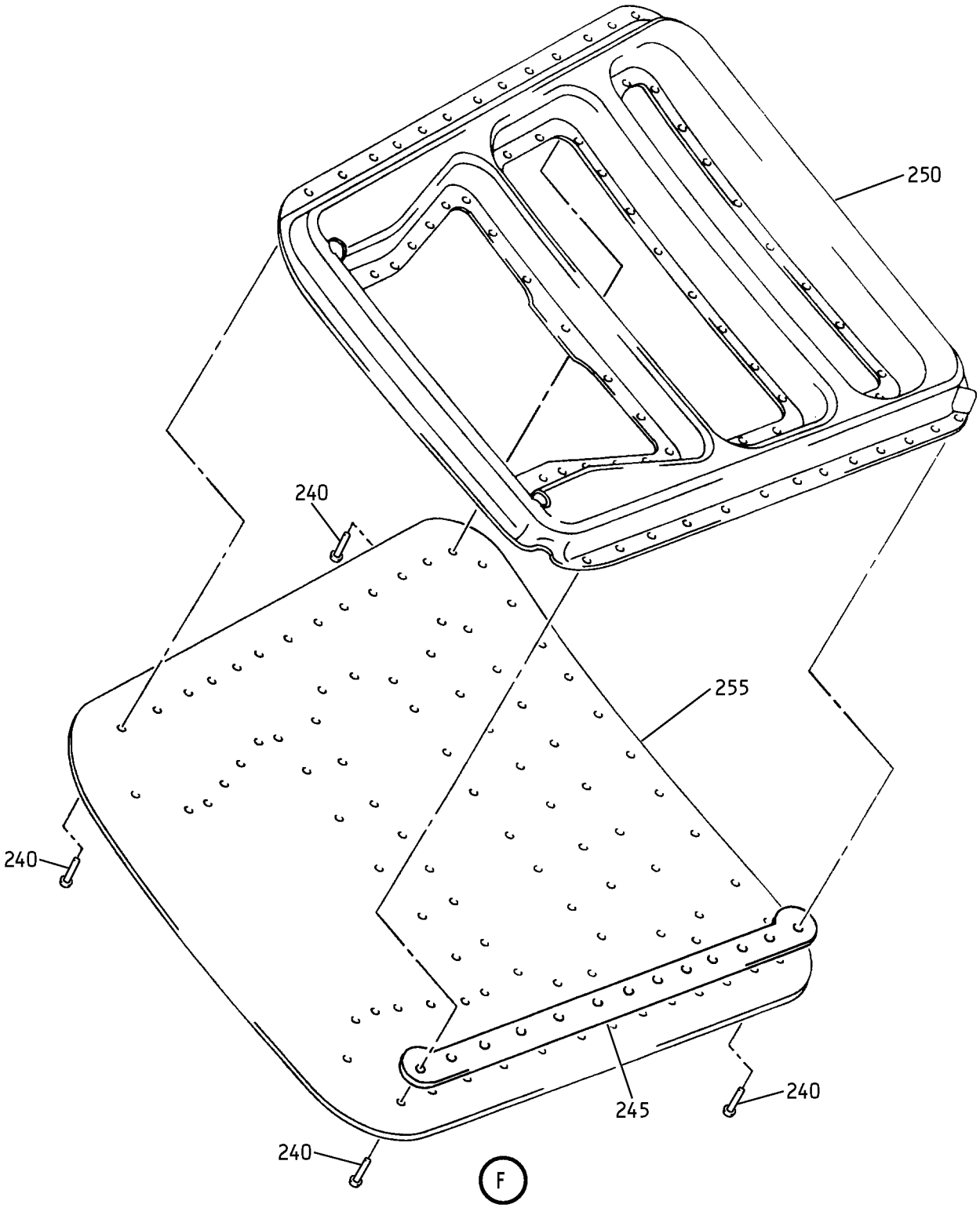
Access and Blowout Door Assembly
IPL Figure 1 (Sheet 3 of 8)



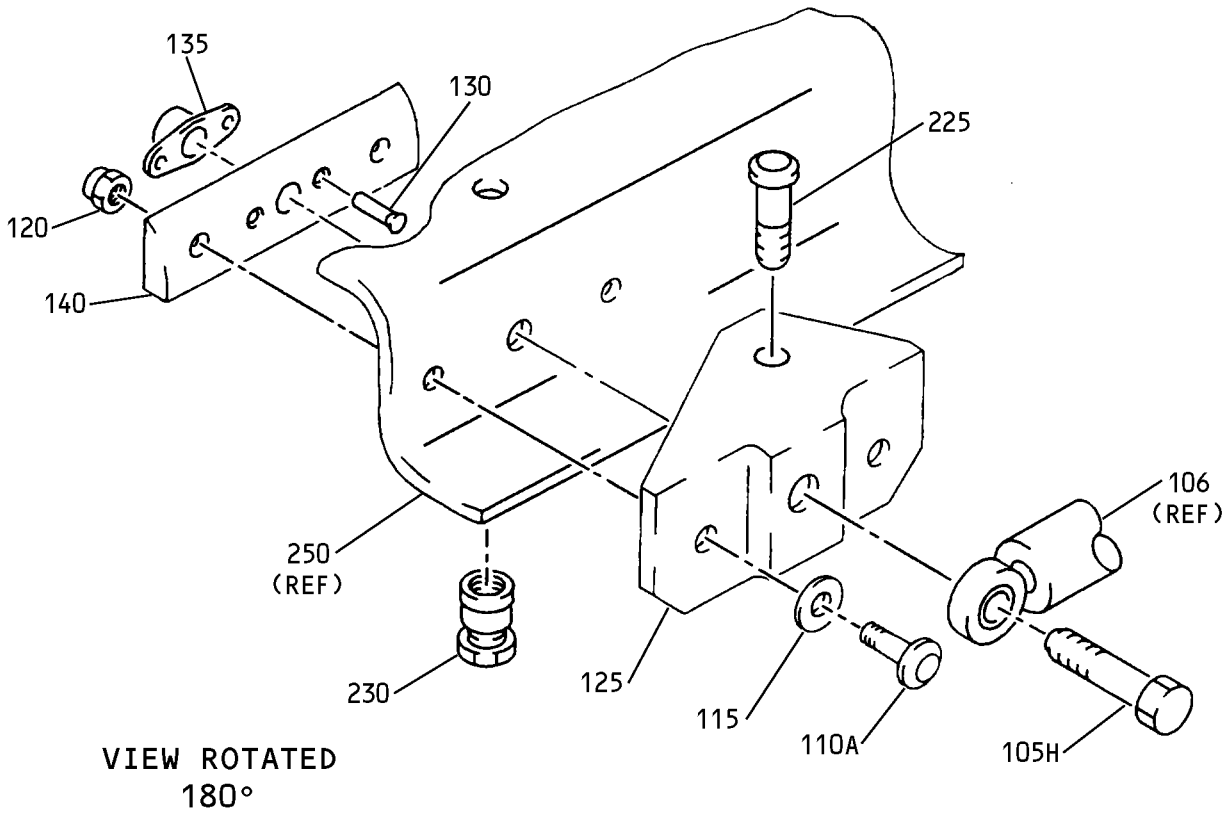
Access and Blowout Door Assembly
IPL Figure 1 (Sheet 4 of 8)



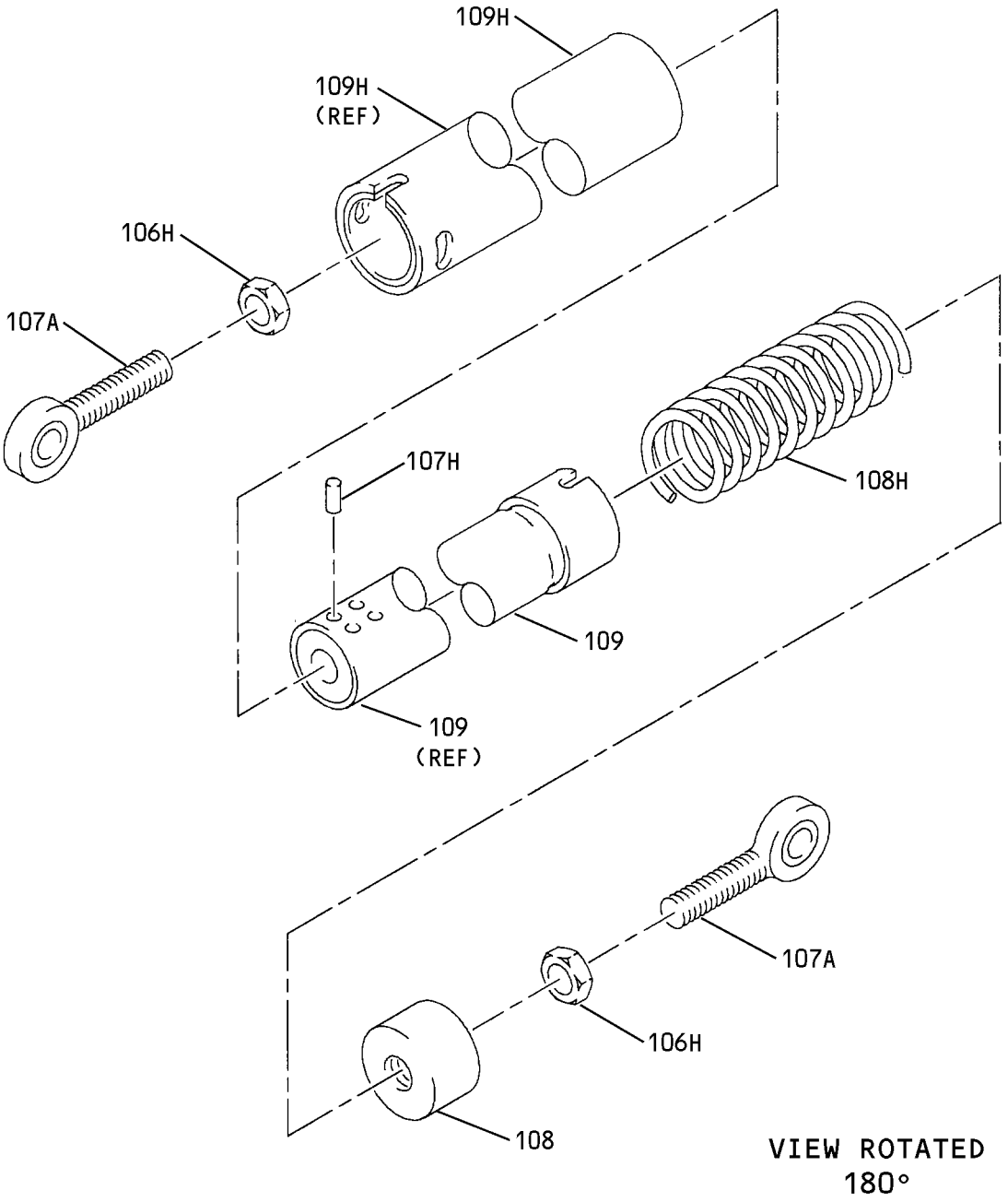
Access and Blowout Door Assembly
IPL Figure 1 (Sheet 5 of 8)



Access and Blowout Door Assembly
IPL Figure 1 (Sheet 6 of 8)



Access and Blowout Door Assembly
IPL Figure 1 (Sheet 7 of 8)



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Access and Blowout Door Assembly
IPL Figure 1 (Sheet 8 of 8)

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
–1A	148A6110-1		DOOR ASSY-ACCESS AND BLOWOUT, SECT. 48	A	RF
–1B	148A6110-6		DOOR ASSY-ACCESS AND BLOWOUT, SECT. 48 (FOR DETAILS SEE FIG. 2)	B	RF
–1C	148A6110-7		DOOR ASSY-ACCESS AND BLOWOUT, SECT. 48 (FOR DETAILS SEE FIG. 2)	C	RF
–1D	148A6110-8		DOOR ASSY-ACCESS AND BLOWOUT, SECT. 48 (FOR DETAILS SEE FIG. 2)	D	RF
–1E	148A6110-9		DOOR ASSY-ACCESS AND BLOWOUT, SECT. 48 (FOR DETAILS SEE FIG. 3)	E	RF
–1F	148A6110-10		DOOR ASSY-ACCESS AND BLOWOUT, SECT. 48 (FOR DETAILS SEE FIG. 3)	F	RF
–1G	148A6110-11		DOOR ASSY-ACCESS AND BLOWOUT, SECT. 48 (FOR DETAILS SEE FIG. 3)	G	RF
–1H	148A6110-13		DOOR ASSY-ACCESS AND BLOWOUT, SECT. 48 (FOR DETAILS SEE FIG. 3)	H	RF
–1J	148A6110-14		DOOR ASSY-ACCESS AND BLOWOUT, SECT. 48 (FOR DETAILS SEE FIG. 2)	J	RF
–1K	148A6110-15		DOOR ASSY-ACCESS AND BLOWOUT, SECT. 48 (FOR DETAILS SEE FIG. 2)	K	RF
–1L	148A6110-16		DOOR ASSY-ACCESS AND BLOWOUT, SECT. 48 (FOR DETAILS SEE FIG. 3)	L	RF
5	BACB30NM4K5		. BOLT	A	8
10	BACR15GF3D		. RIVET (SIZE DETERMINED ON INST)	A	16

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
15	BRF200C4D		. NUTPLATE (V52828) (SPEC BACN10JR4CFD) (OPT K51602-4BAC (V15653)) (OPT NS202476-048 (V80539)) (OPT 102F9201-4 (V72962)) (OPT T8092C428CD (V11815))	A	6
17	BRFM20C4D		. NUTPLATE (V52828) (SPEC BACN10JN4CD) (OPT T8301C428CD (V11815)) (OPT 102F9201M4 (V72962)) (OPT NS202487-048 (V80539)) (OPT MF51637-4 (V15653)) (OPT MF53050-4CD (V15653))	A	2
20	65-67747-1		. HINGE ASSY (OPT ITEM 20A)	A	2
–20A	65-67747-6		. HINGE ASSY (OPT ITEM 20)	A	2
25	65-67747-4		. . BEARING	A	1
30	65-67747-2		. . HINGE (USED ON ITEM 20)	A	1
–30A	65-67747-5		. . HINGE (USED ON ITEM 20A)	A	1
35	BACS40R008C020F		. SHIM	A	3
40	65C35450-2		. FILLER	A	2
45	65C35450-5		. FILLER	A	2
46	BACS12GU08K6		. SCREW	A	1
47	NAS1149DN832J		. WASHER	A	1
48	NAS1149DN816J		. WASHER	A	1
49	H52732-08CD		. NUT (V15653) (SPEC BACN10YR08CD) (OPT PLH508CD (V62554))	A	1
50	65-54860-6		. PIN ASSY-RETAINING	A	1
55	NAS1090-1		. . HOOK	A	1
60	BACC13Y3-130		. . CABLE ASSY	A	1
65	69-41407-1		. . PIN	A	1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
70	65C36303-1		. HOLDER ASSY-PIN	A	1
75	BACR15BB3D		. . RIVET (SIZE DETERMINED ON INST)	A	3
80	100-225-2-10		. . CLIP (V99378)	A	3
85	65C36303-2		. . PLATE	A	1
90	VNS1924CA1-8		. STUD (V5M902) (SPEC BACS53B1EA1) (OPT VNS1924CA3-1-8 (V92215))	A	1
95	NAS1149D0316J		. WASHER	A	1
100	H52732-3CD		. NUT (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))	A	1
105	BACJ40A20-9		. JUMPER ASSY	A	1
105H	BACB30NM4K15		. BOLT	A	1
106	65-54860-503		. STRUT ASSY-JURY	A	1
106H	NAS509-5		. . NUT	A	2
–107	ASMK4T21		DELETED		
107A	HB4ETL186		. . BEARING (V02758) (SPEC 10-60779-174) (OPT ASMK4T21 (V56644))	A	2
107H	MS16562-198		. . PIN-ROLL	A	4
108	69-41402-2		. . FITTING-END	A	1
108H	69-41401-1		. . SPRING-CPRSN	A	1
109	65-54860-501		. . TUBE ASSY-INNER	A	1
109H	65-54860-502		. . TUBE ASSY-OUTER	A	1
–110	HL12VAZ5-7		DELETED		

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
110A	HL1012AZ5-4		. BOLT (V97928) (SPEC BACB30NX5K4) (OPT HL12VAZ5-4 (V73197)) (OPT HL12VAZ5-4 (V92215)) (OPT HL12VAZ5-4 (V97928)) (OPT L802-5K4 (V06725)) (OPT HL12VAZ5-4 (V56878)) (OPT HL1012AZ5-4 (V0PTK6)) (OPT HL1012AZ5-4 (V06725)) (OPT HL1012AZ5-4 (V06950)) (OPT HL1012AZ5-4 (V17446)) (OPT HL1012AZ5-4 (V56878)) (OPT HL1012AZ5-4 (V60516)) (OPT HL1012AZ5-4 (V73197))	A	2
115	NAS1149DN832J		. WASHER	A	2
120	H52732-08CD		. NUT (V15653) (SPEC BACN10YR08CD) (OPT PLH508CD (V62554))	A	2
125	65C36295-4		. FITTING-JURY STRUT	A	1
130	BACR15GF3D		. RIVET (SIZE DETERMINED ON INST)	A	2
135	BRF200C4D		. NUTPLATE (V52828) (SPEC BACN10JR4CFD) (OPT K51602-4BAC (V15653)) (OPT NS202476-048 (V80539)) (OPT 102F9201-4 (V72962)) (OPT T8092C428CD (V11815))	A	1
140	65C35450-4		. FILLER	A	1
145	BACB30VF3K3		. BOLT	A	6
150	BACB30NN3K4		. BOLT	A	2
155	H52732-3CD		. NUT (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))	A	8
157	NAS1149EN816P		. WASHER	A	3
160	H942-1		. LATCH ASSY (V83014) (SPEC 10-61704-1)	A	1

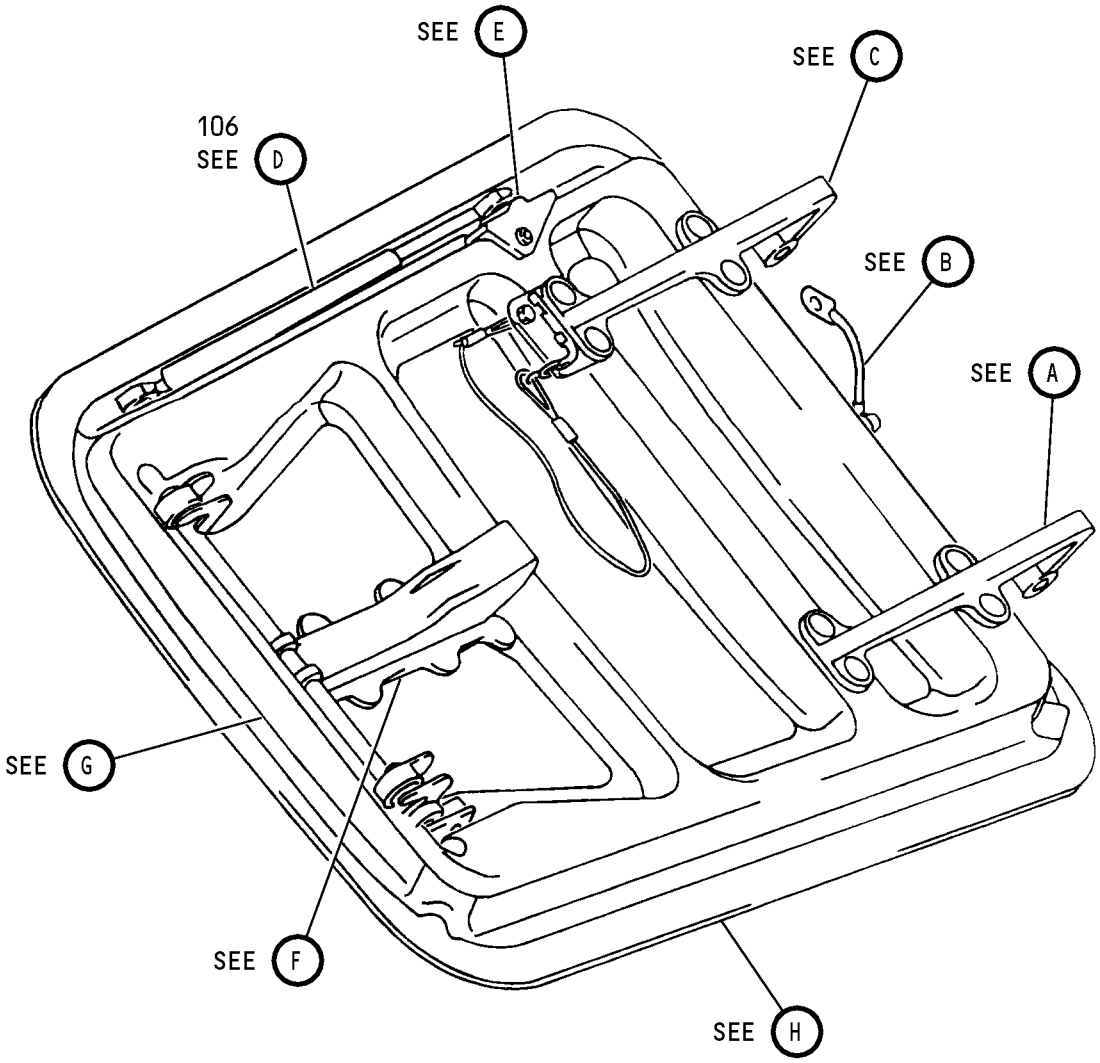
–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
165	BACS40R008D024F		. SHIM	A	1
167	BACS40R009E024F		. SHIM	A	1
–170	BACS40R008D064F		DELETED		
170A	BACS40R009C064F		. SHIM	A	2
–175	BACS12GU3K7		DELETED		
175A	BACB30NM3K8		. BOLT		4
176	BACR15BB3D		. RIVET (SIZE DETERMINED ON INST)	A	2
177	BACR15GF3D		. RIVET (SIZE DETERMINED ON INST)	A	2
178	148A6110-2		. FILLER ASSY	A	1
179	148A6110-3		. FILLER ASSY	A	1
180	BACR15GF3D		. . RIVET (SIZE DETERMINED ON INST)	A	4
181	102F9209M3		. . NUTPLATE (V72962) (SPEC BACN10KH3CD) (OPT FS1651-3 (V15653)) (OPT NS202496-02 (V80539))	A	2
182	148A6110-4		. . FILLER ASSY-RADIUS (USED ON ITEM 178)	A	1
183	148A6110-5		. . FILLER ASSY-RADIUS (USED ON ITEM 179)	A	1
184	BACF3H07˜ GH023AN		. . . FILLER	A	1
–185	102F9209M3		DELETED		
190	BACR15FT6D		. RIVET (SIZE DETERMINED ON INST)	A	2
195	BACR15GF6D		. RIVET (SIZE DETERMINED ON INST)	A	2
200	65C36295-2		. TEE-LATCH	A	2
–205	BACS40R008C014F		DELETED		
205A	BACS40R008D018F		. SHIM		2
210	BACR15GF5D		. RIVET (SIZE DETERMINED ON INST)	A	8

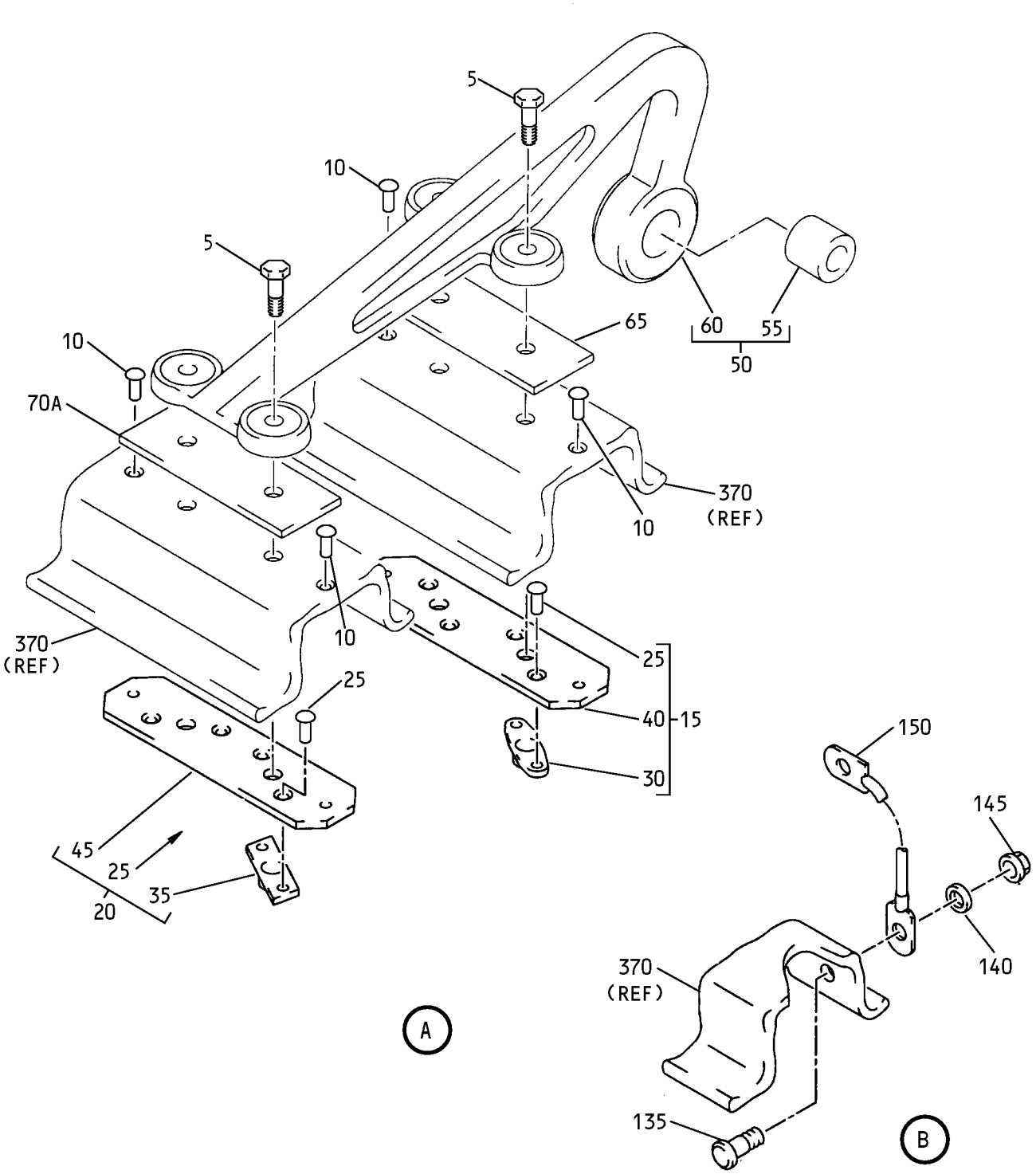
–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
215	BACR15FT5D		. RIVET (SIZE DETERMINED ON INST)	A	8
220	65C36295-5		. SUPPORT-LATCH	A	1
225	HST10AG5-3		. BOLT (V0PTK6) (SPEC BACB30VT5K3) (OPT HST10AG5-3 (V06725)) (OPT HST10AG5-3 (V56878)) (OPT HST10AG5-3 (V73197))	A	1
230	HST79CY5		. COLLAR (V73197) (SPEC BACC30BL5) (OPT HST79-5 (V92215)) (OPT HST79-5 (V56878)) (OPT HST79-5 (V5M902))	A	1
235	BACR15GF4D		. RIVET (SIZE DETERMINED ON INST)	A	8
240	BACR15GF5D		. RIVET (SIZE DETERMINED ON INST)	A	93
245	148A6120-2		. FILLER	A	1
250	65C35118-1		. PAN	A	1
255	148A6120-1		. SKIN-DOOR	A	1

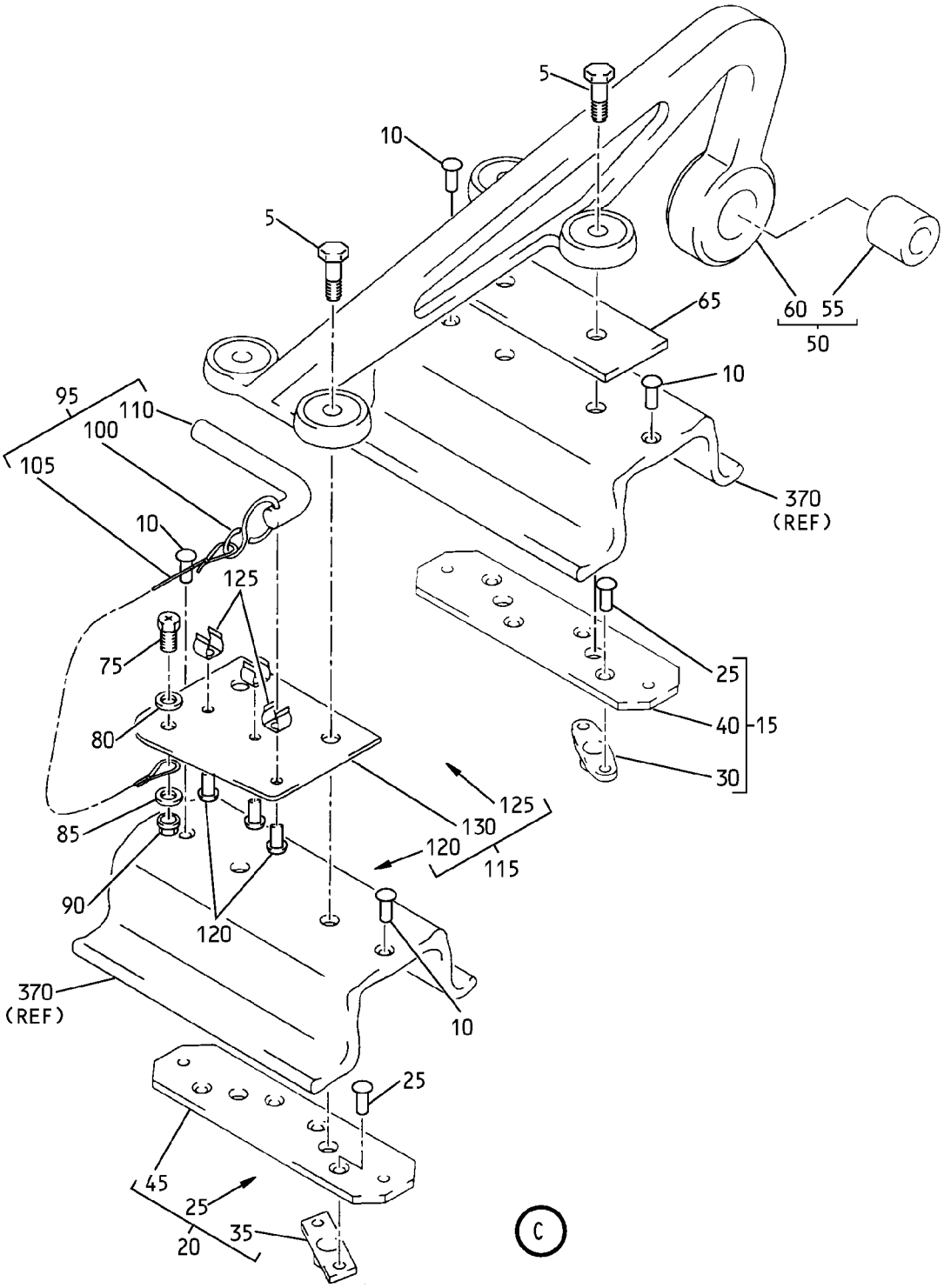
–Item not Illustrated



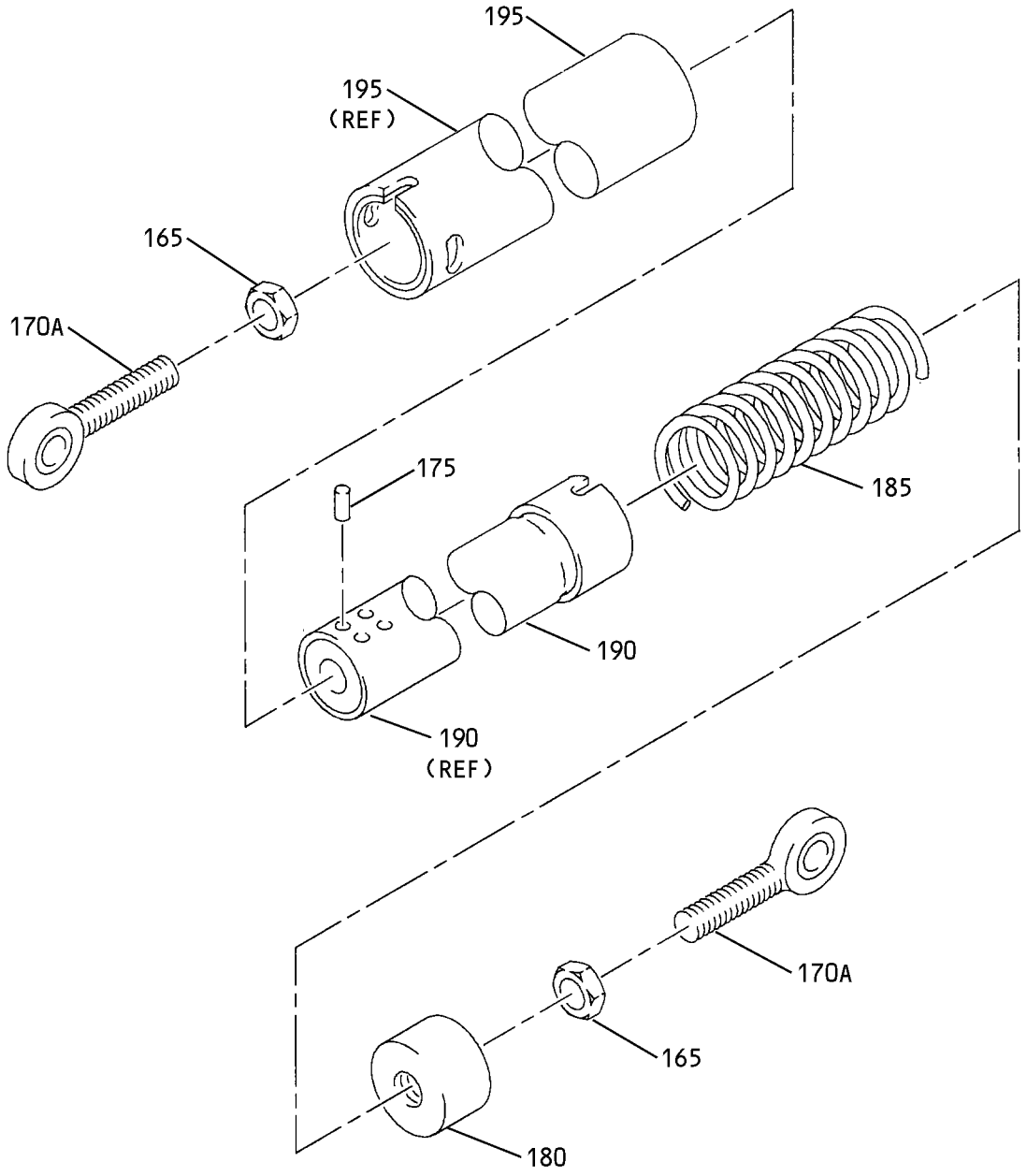
Access and Blowout Door Assembly
IPL Figure 2 (Sheet 1 of 8)



Access and Blowout Door Assembly
IPL Figure 2 (Sheet 2 of 8)



Access and Blowout Door Assembly
IPL Figure 2 (Sheet 3 of 8)



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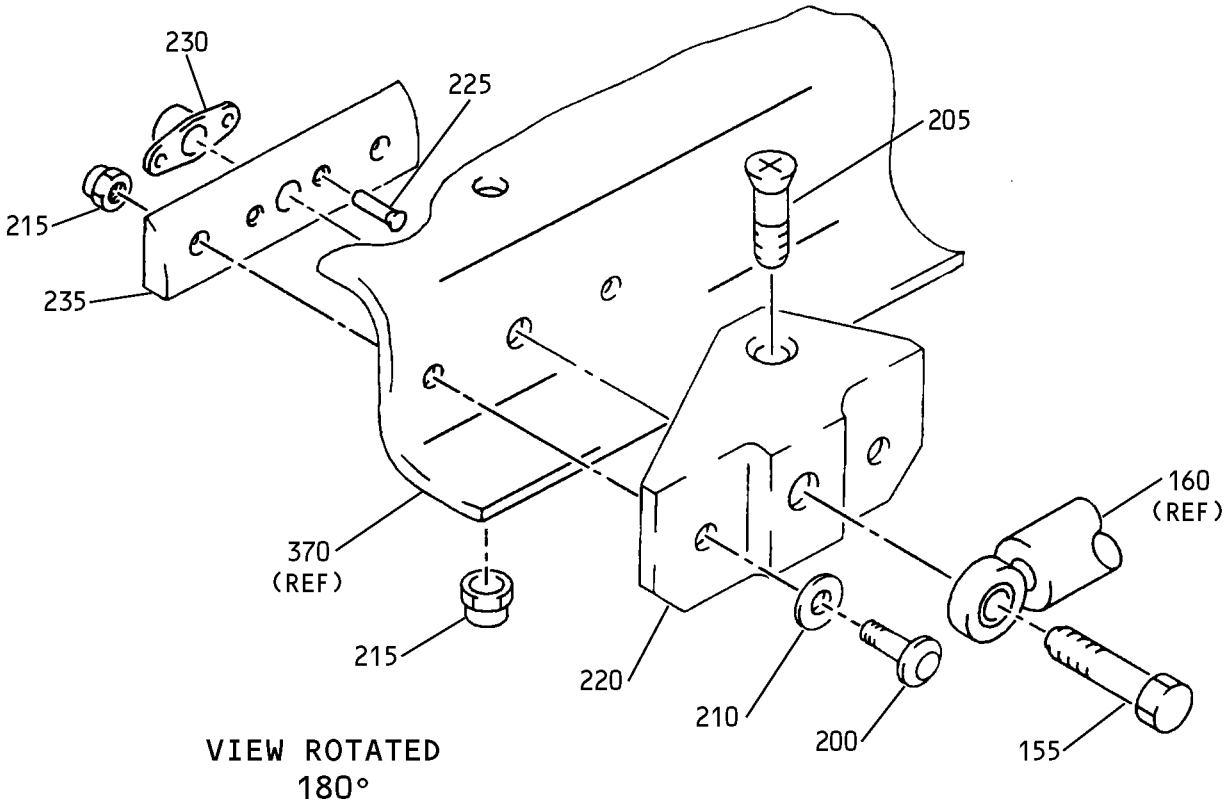
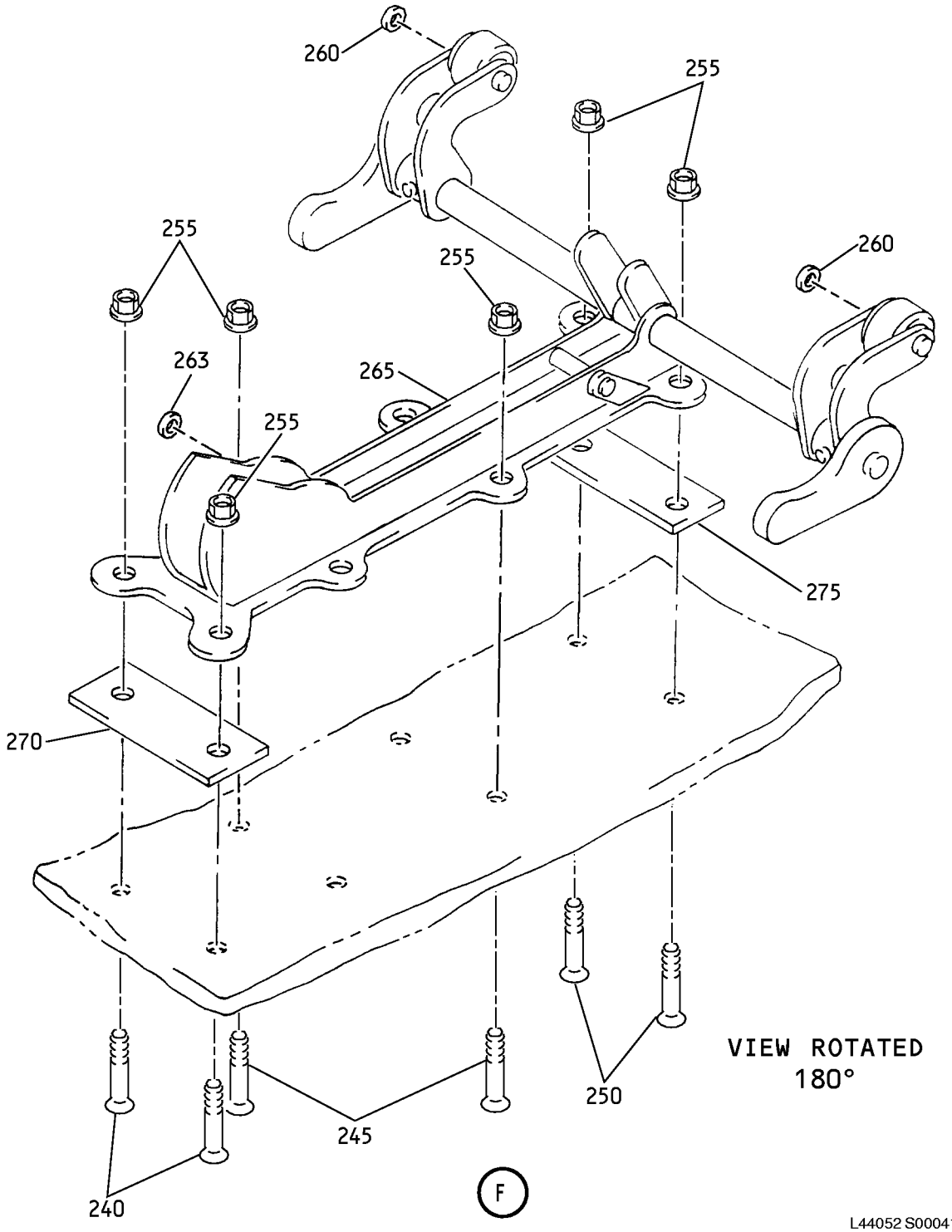
Access and Blowout Door Assembly
IPL Figure 2 (Sheet 4 of 8)



Access and Blowout Door Assembly
IPL Figure 2 (Sheet 5 of 8)



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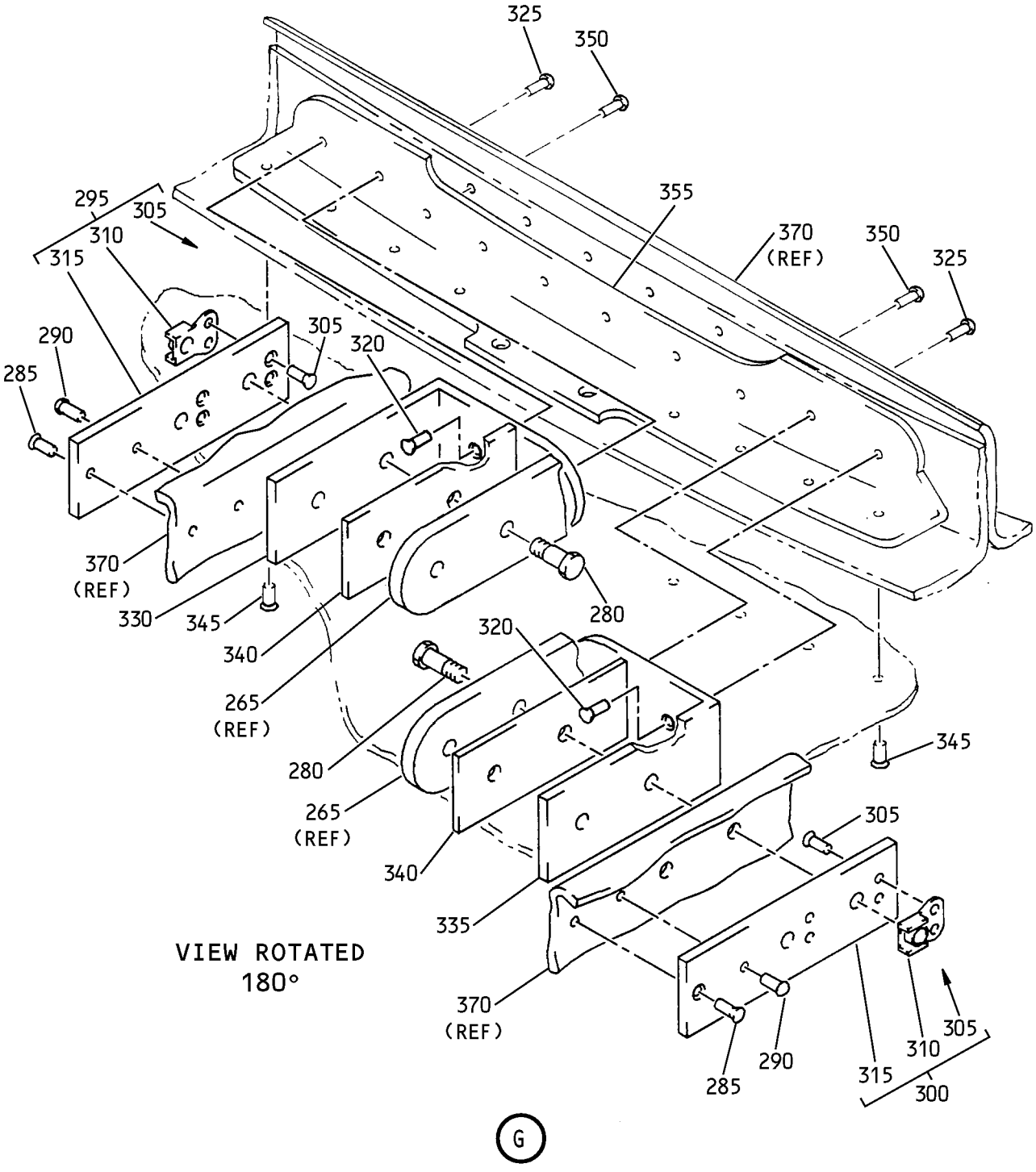
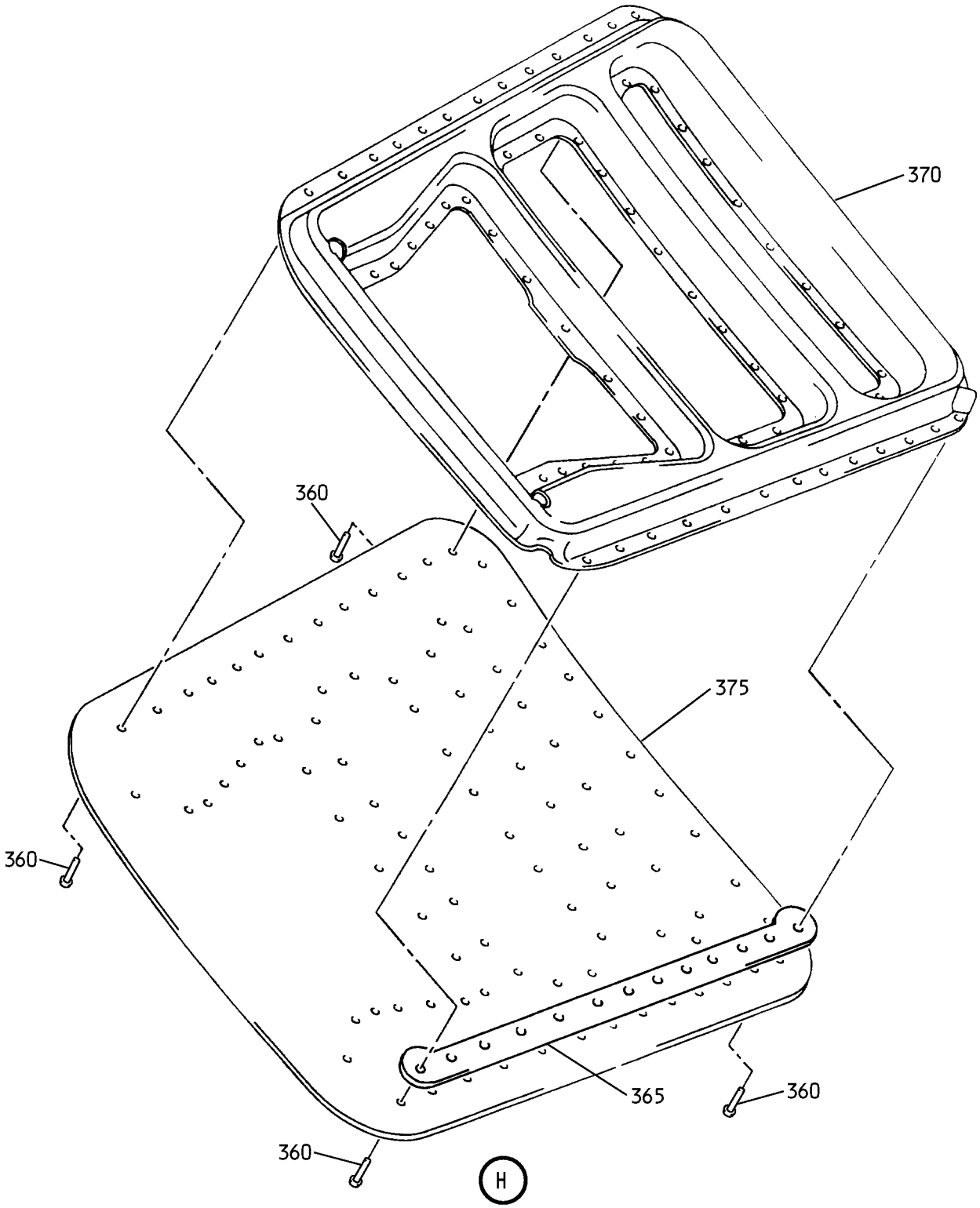
Access and Blowout Door Assembly
IPL Figure 2 (Sheet 6 of 8)



Access and Blowout Door Assembly
IPL Figure 2 (Sheet 7 of 8)



Access and Blowout Door Assembly
IPL Figure 2 (Sheet 8 of 8)

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
–1A	148A6110-6		DOOR ASSY-ACCESS AND BLOWOUT, SECT. 48	B	RF
–1B	148A6110-7		DOOR ASSY-ACCESS AND BLOWOUT, SECT. 48	C	RF
–1C	148A6110-8		DOOR ASSY-ACCESS AND BLOWOUT, SECT. 48	D	RF
–1D	148A6110-14		DOOR ASSY-ACCESS AND BLOWOUT, SECT. 48	J	RF
–1E	148A6110-15		DOOR ASSY-ACCESS AND BLOWOUT, SECT. 48	K	RF
5	BACB30NM4K7		. BOLT	B-D, J, K	8
10	BACR15GF4D		. RIVET (SIZE DETERMINED ON INST)	B-D, J, K	8
15	148A6130-9		. FILLER ASSY	B-D, J, K	2
20	148A6130-11		. FILLER ASSY	B-D, J, K	2
25	BACR15GF3D		. . RIVET (SIZE DETERMINED ON INST)	B-D, J, K	4
30	BRF200C4D		. . NUTPLATE (V52828) (SPEC BACN10JR4CFD) (OPT K51602-4BAC (V15653)) (OPT NS202476-048 (V80539)) (OPT 102F9201-4 (V72962)) (OPT T8092C428CD (V11815)) (USED ON ITEM 15)	B-D, J, K	2
35	BRFM20C4D		. . NUTPLATE (V52828) (SPEC BACN10JN4CD) (OPT T8301C428CD (V11815)) (OPT 102F9201M4 (V72962)) (OPT NS202487-048 (V80539)) (OPT MF51637-4 (V15653)) (OPT MF53050-4CD (V15653)) (USED ON ITEM 20)	B-D, J, K	2
40	148A6130-10		. . FILLER (USED ON ITEM 15)	B-D, J, K	1
45	148A6130-12		. . FILLER (USED ON ITEM 20)	B-D, J, K	1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
50	65-67747-1		. HINGE ASSY (OPT ITEM 50A)	B-D, J, K	2
–50A	65-67747-6		. HINGE ASSY (OPT ITEM 50)	B-D, J, K	2
55	65-67747-4		. . BEARING	B-D, J, K	1
60	65-67747-2		. . HINGE (USED ON ITEM 50)	B-D, J, K	1
–60A	65-67747-5		. . HINGE (USED ON ITEM 50A)	B-D, J, K	1
65	BACS40R008D020F		. SHIM	B-D, J, K	2
70	BACF3F008D020N		DELETED		
70A	BACF3F008D020NN		. FILLER	B	1
–70B	BACF3F008G020NN		. FILLER	C, D, J, K	1
75	BACS12GU08K6		. SCREW	B-D, J, K	1
80	NAS1149DN832J		. WASHER	B-D, J, K	1
85	NAS1149DN816J		. WASHER	B-D, J, K	1
90	H52732-08CD		. NUT (V15653) (SPEC BACN10YR08CD) (OPT PLH508CD (V62554))	B-D, J, K	1
95	65-54860-6		. PIN ASSY-RETAINING	B-D, J, K	1
100	NAS1090-1		. . HOOK	B-D, J, K	1
105	BACC13Y3-130		. . CABLE ASSY	B-D, J, K	1
110	69-41407-1		. . PIN	B-D, J, K	1
115	65C36303-1		. HOLDER ASSY-PIN	B-D, J, K	1
120	BACR15BB3D		. . RIVET (SIZE DETERMINED ON INST)	B-D, J, K	3
125	100-225-2-10		. . CLIP (V99378)	B-D, J, K	3
130	65C36303-2		. . PLATE	B-D, J, K	1
135	VNS1924CA1-8		. STUD (V5M902) (SPEC BACS53B1EA1) (OPT VNS1924CA3-1-8 (V92215))	B-D, J, K	1
140	NAS1149D0316J		. WASHER	B-D, J, K	1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
145	H52732-3CD		. NUT (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))	B-D, J, K	1
150	BACJ40A20-9		. JUMPER ASSY	B-D, J, K	1
155	BACB30NM4K15		. BOLT	B-D, J, K	1
160	65-54860-503		. STRUT ASSY-JURY	B-D, J, K	1
165	NAS509-5		. . NUT	B-D, J, K	2
170	ASMK4T21		DELETED		
170A	HB4ETL186		. . BEARING (V02758) (SPEC 10-60779-174) (OPT ASMK4T21 (V56644))	B-D, J, K	2
175	MS16562-198		. . PIN-ROLL	B-D, J, K	4
180	69-41402-2		. . FITTING-END	B-D, J, K	1
185	69-41401-1		. . SPRING-CPRSN	B-D, J, K	1
190	65-54860-501		. . TUBE ASSY-INNER	B-D, J, K	1
195	65-54860-502		. . TUBE ASSY-OUTER	B-D, J, K	1
200	BACB30VF08K6		. BOLT	B-D, J, K	2
205	BACB30VF08K3		. BOLT	B-D, J, K	1
210	NAS1149DN832J		. WASHER	B-D, J, K	2
215	H52732-08CD		. NUT (V15653) (SPEC BACN10YR08CD) (OPT PLH508CD (V62554))	B-D, J, K	3
220	65C36295-4		. FITTING-JURY STRUT	B-D, J, K	1
225	BACR15GF3D		. RIVET (SIZE DETERMINED ON INST)	B-D, J, K	2
230	BRF200C4D		. NUTPLATE (V52828) (SPEC BACN10JR4CFD) (OPT K51602-4BAC (V15653)) (OPT NS202476-048 (V80539)) (OPT 102F9201-4 (V72962)) (OPT T8092C428CD (V11815))	B-D, J, K	1
235	65C35450-4		. FILLER-RADIUS	B-D, J, K	1
240	BACB30VF3K5		. BOLT	B-D, J, K	2

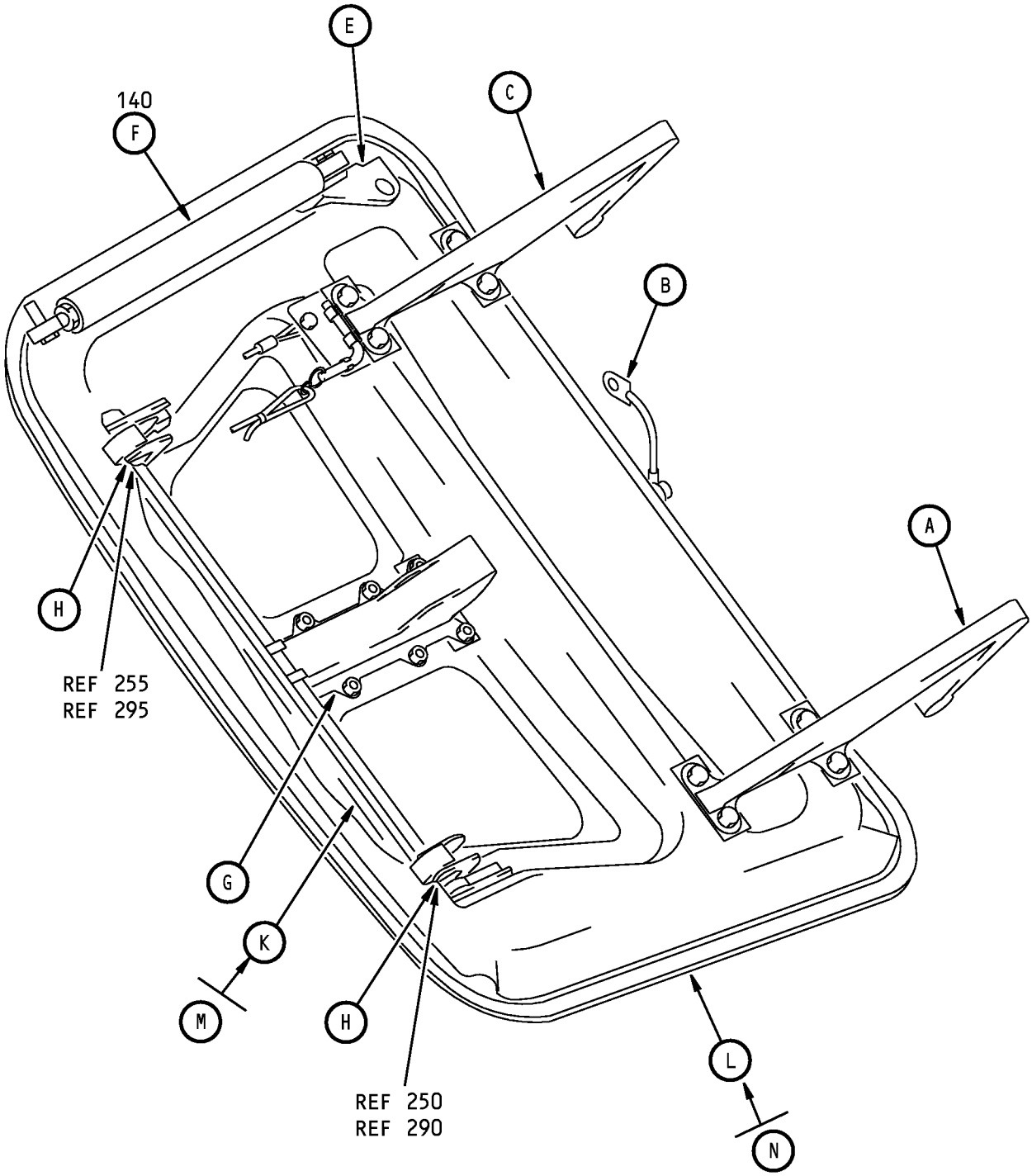
–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
245	BACB30VF3K3		. BOLT	B-D, J, K	4
250	BACB30NN3K4		. BOLT	B-D, J, K	2
255	H52732-3CD		. NUT (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))	B-D, J, K	8
260	NAS1149EN816P		. WASHER	B-D	2
–260A	NAS1149E0316P		. WASHER (OPT ITEM 260B)	J, K	2
–260B	NAS1149EN816P		. WASHER (OPT ITEM 260A)	J, K	2
263	NAS1149EN816P		. WASHER	B-D	1
–263A	NAS1149E0332P		. WASHER (OPT ITEM 263B)	J, K	1
–263B	NAS1149EN816P		. WASHER (OPT ITEM 263A)	J, K	1
265	H942-1		. LATCH ASSY (V83014) (SPEC 10-61704-1)	B-D, J, K	1
270	BACS40R009C024F		. SHIM	B	1
–270A	BACS40R010B024F		. SHIM	C, D, J, K	1
275	BACS40R008A024F		. SHIM	B-D, J, K	AR
280	BACB30NM3K8		. BOLT	B-D, J, K	4
285	BACR15BB3D		. RIVET (SIZE DETERMINED ON INST)	B-D, J, K	2
290	BACR15GF3D		. RIVET (SIZE DETERMINED ON INST)	B-D, J, K	2
295	148A6130-8		. FILLER ASSY	B-D, J, K	1
300	148A6130-7		. FILLER ASSY	B-D, J, K	1
305	BACR15GF3D		. . RIVET (SIZE DETERMINED ON INST)	B-D, J, K	4
310	102F9209M3		. . NUTPLATE (V72962) (SPEC BACN10KH3CD) (OPT FS1651-3 (V15653)) (OPT NS202496-02 (V80539))	B-D, J, K	2

–Item not Illustrated

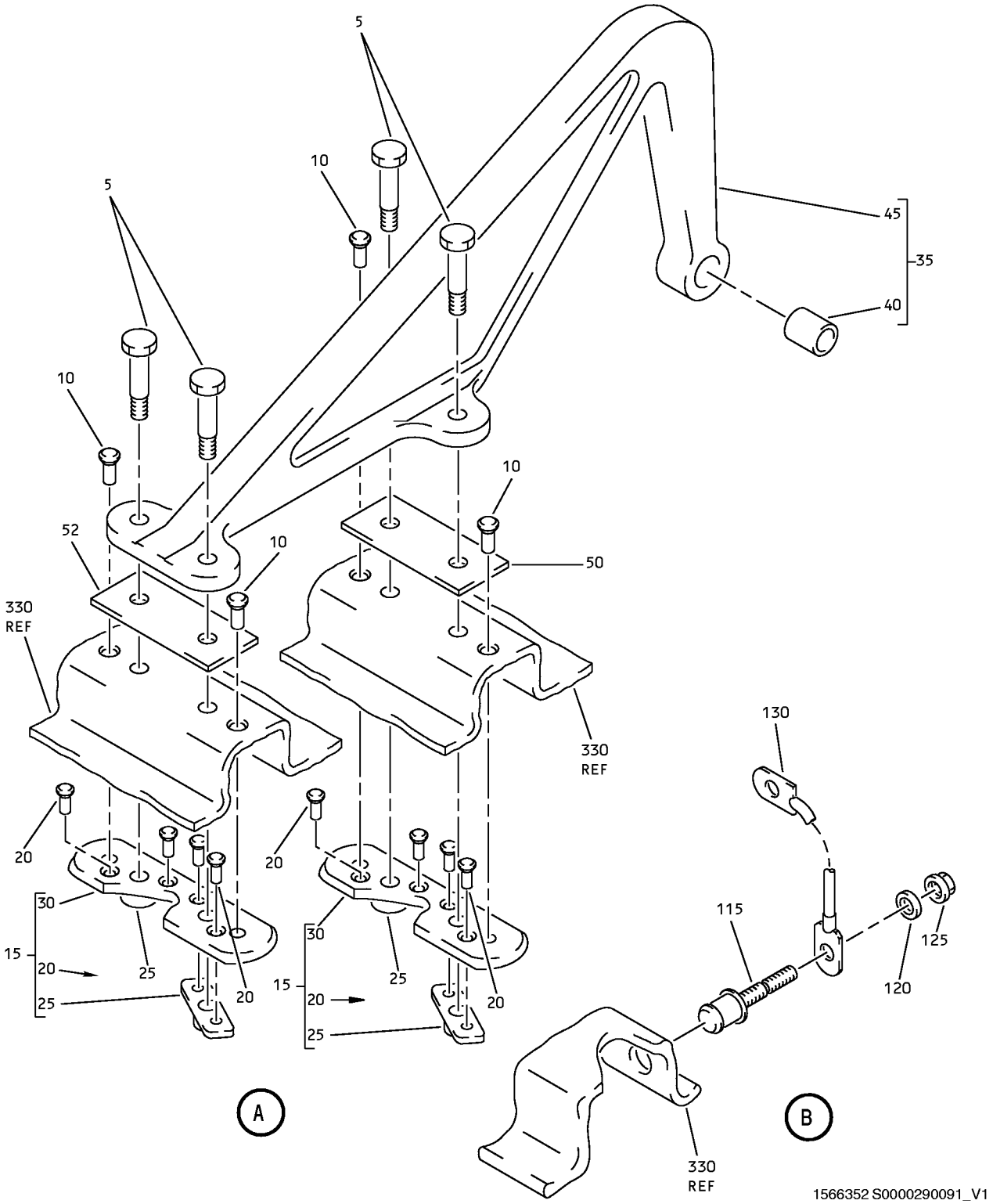
FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
315	BACF3H07˜ GH022AN		. . FILLER	B-D, J, K	1
320	BACR15GF6D		. RIVET (SIZE DETERMINED ON INST)	B-D, J, K	2
325	BACR15FT6D		. RIVET (SIZE DETERMINED ON INST)	B-D, J, K	2
330	148A6121-2		. ANGLE-LATCH	B-D, J, K	1
335	148A6121-1		. ANGLE-LATCH	B-D, J, K	1
340	BACS40R008D016F		. SHIM	B-D, J, K	2
345	BACR15GF5D		. RIVET (SIZE DETERMINED ON INST)	B-D, J, K	8
350	BACR15FT5D		. RIVET (SIZE DETERMINED ON INST)	B-D, J, K	6
355	148A6121-3		. ANGLE-LATCH SPRT	B-D, J, K	1
360	BACR15GF5D		. RIVET (SIZE DETERMINED ON INST)	B-D, J, K	91
365	148A6120-2		. FILLER	B	1
370	65C35118-1		. PAN	B	1
–370A	148A6111-1		. PAN	C, D	1
–370B	148A6111-4		. PAN	J, K	1
375	148A6120-1		. SKIN-DOOR	B, C, J	1
–375A	148A6120-3		. SKIN-DOOR	D, K	1

–Item not Illustrated

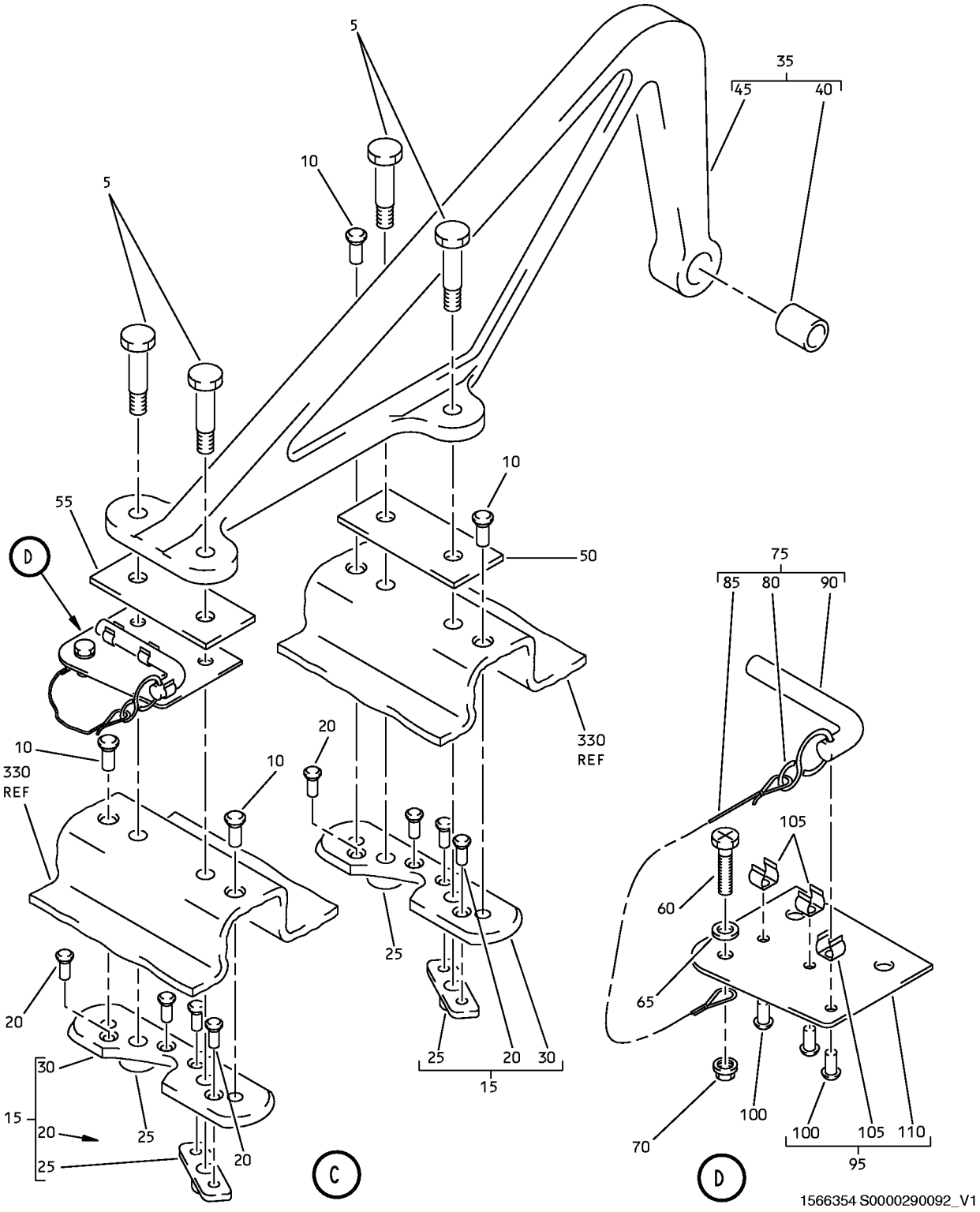


1566350 S0000290090_V1

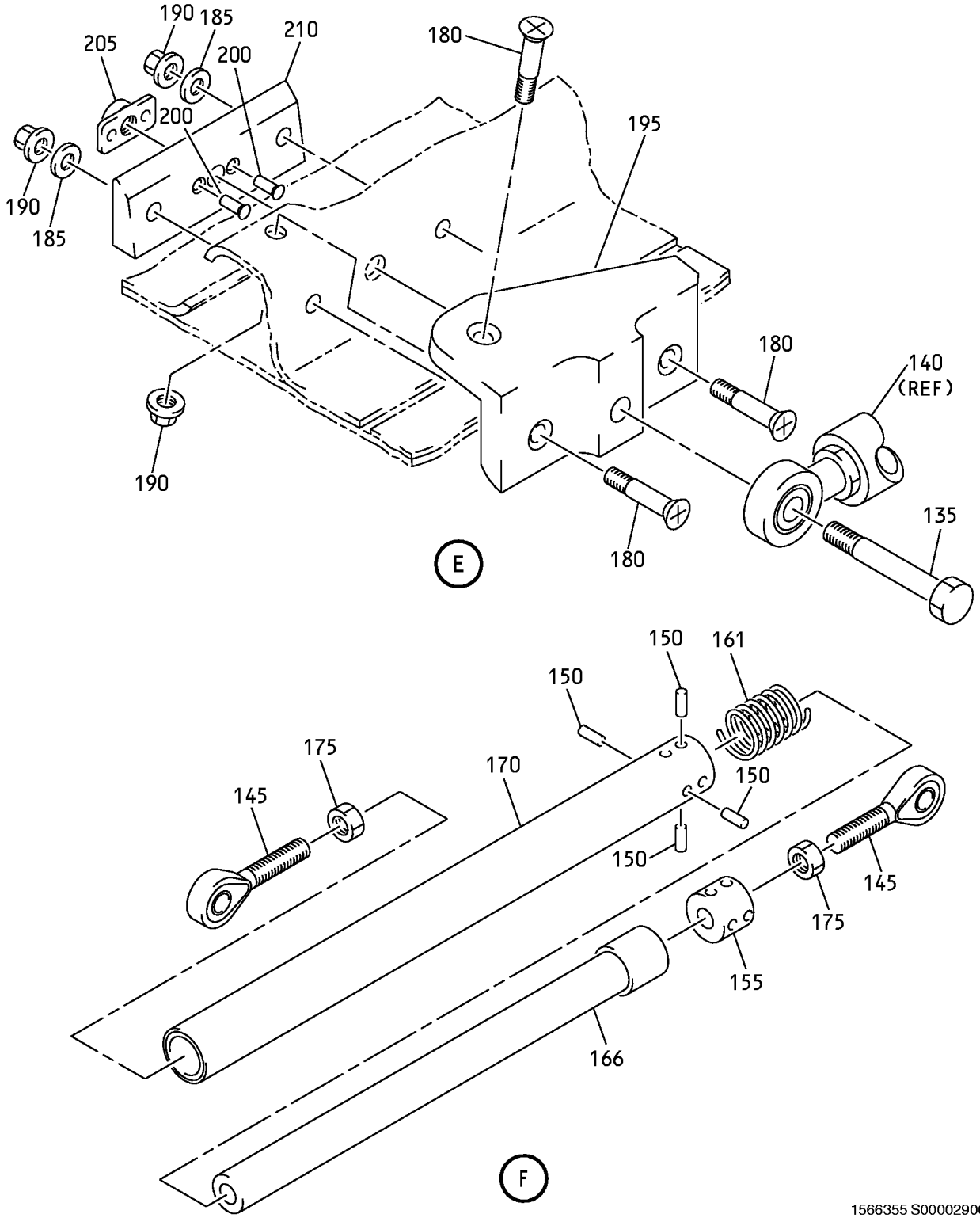
Access and Blowout Door Assembly
IPL Figure 3 (Sheet 1 of 9)



Access and Blowout Door Assembly
IPL Figure 3 (Sheet 2 of 9)

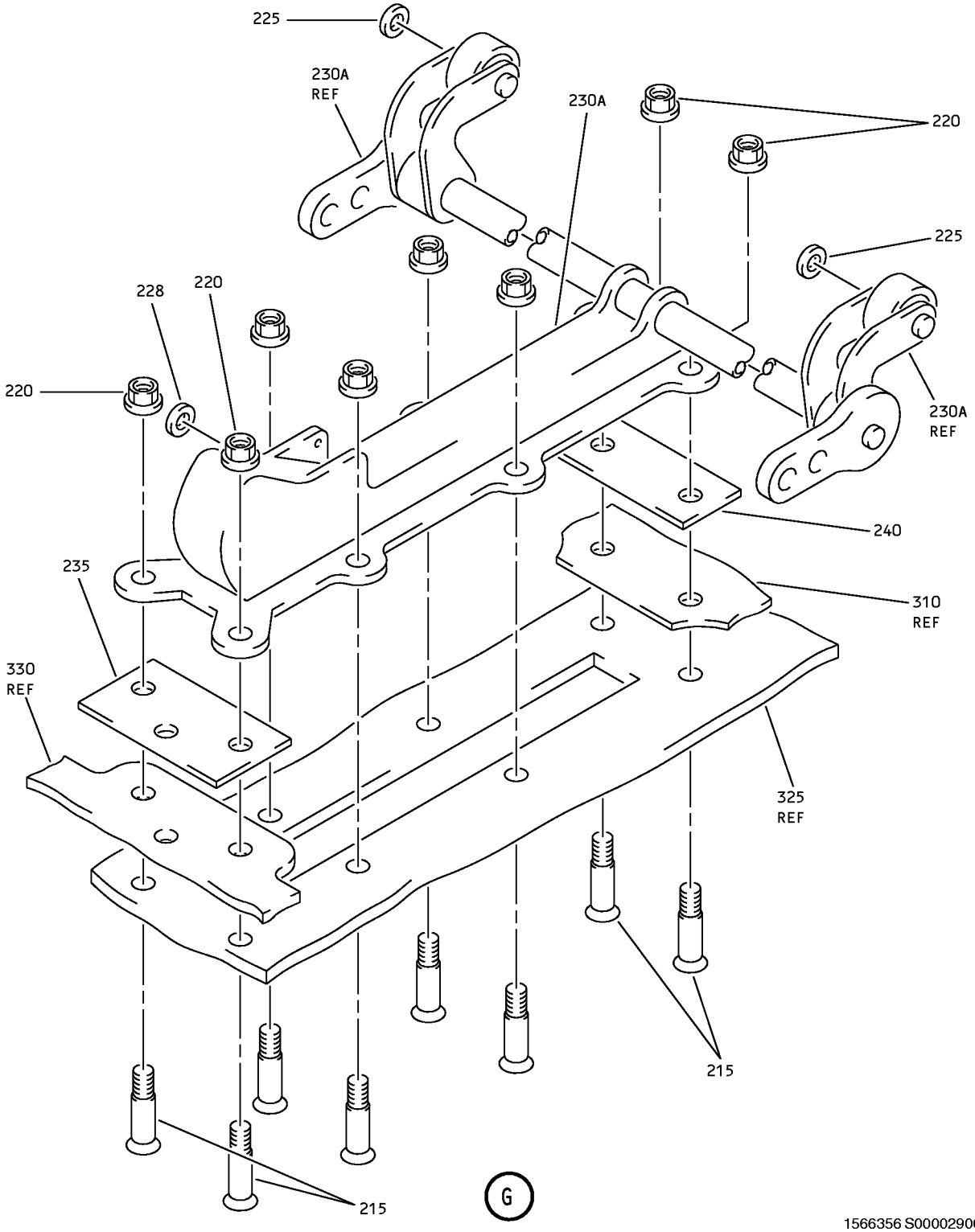


Access and Blowout Door Assembly
IPL Figure 3 (Sheet 3 of 9)



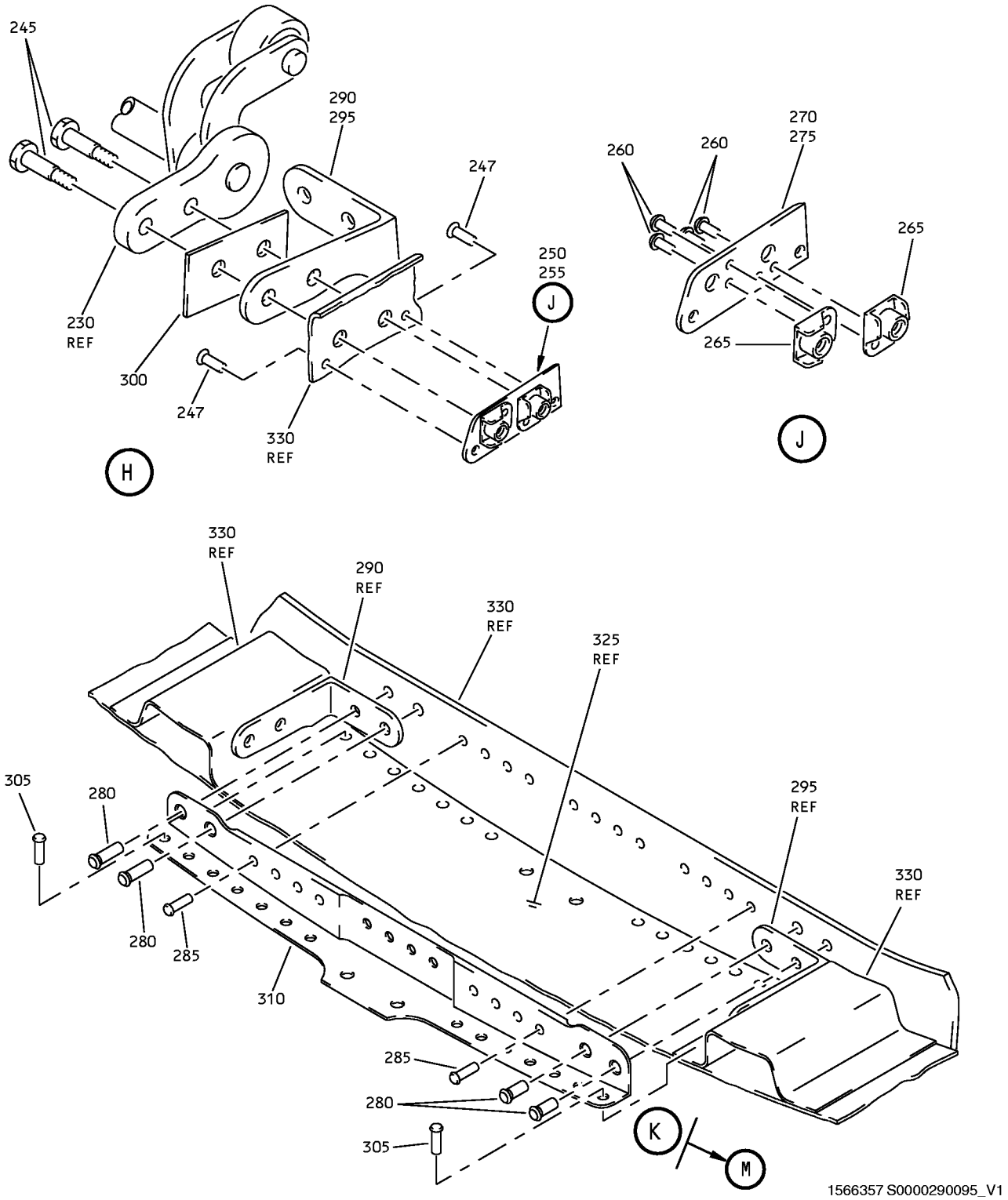
1566355 S0000290093_V1

Access and Blowout Door Assembly
IPL Figure 3 (Sheet 4 of 9)

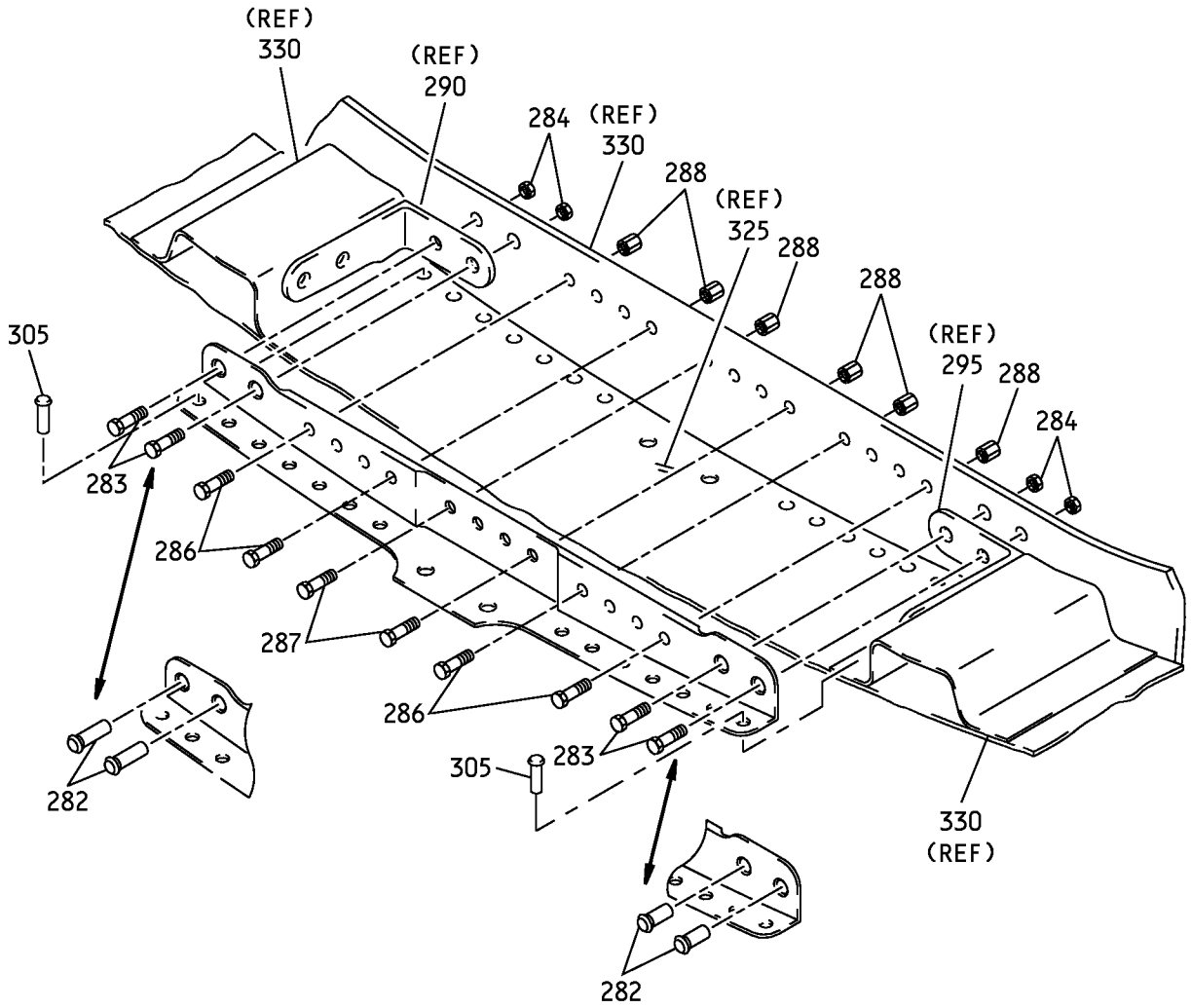


1566356 S0000290094_V1

Access and Blowout Door Assembly
IPL Figure 3 (Sheet 5 of 9)

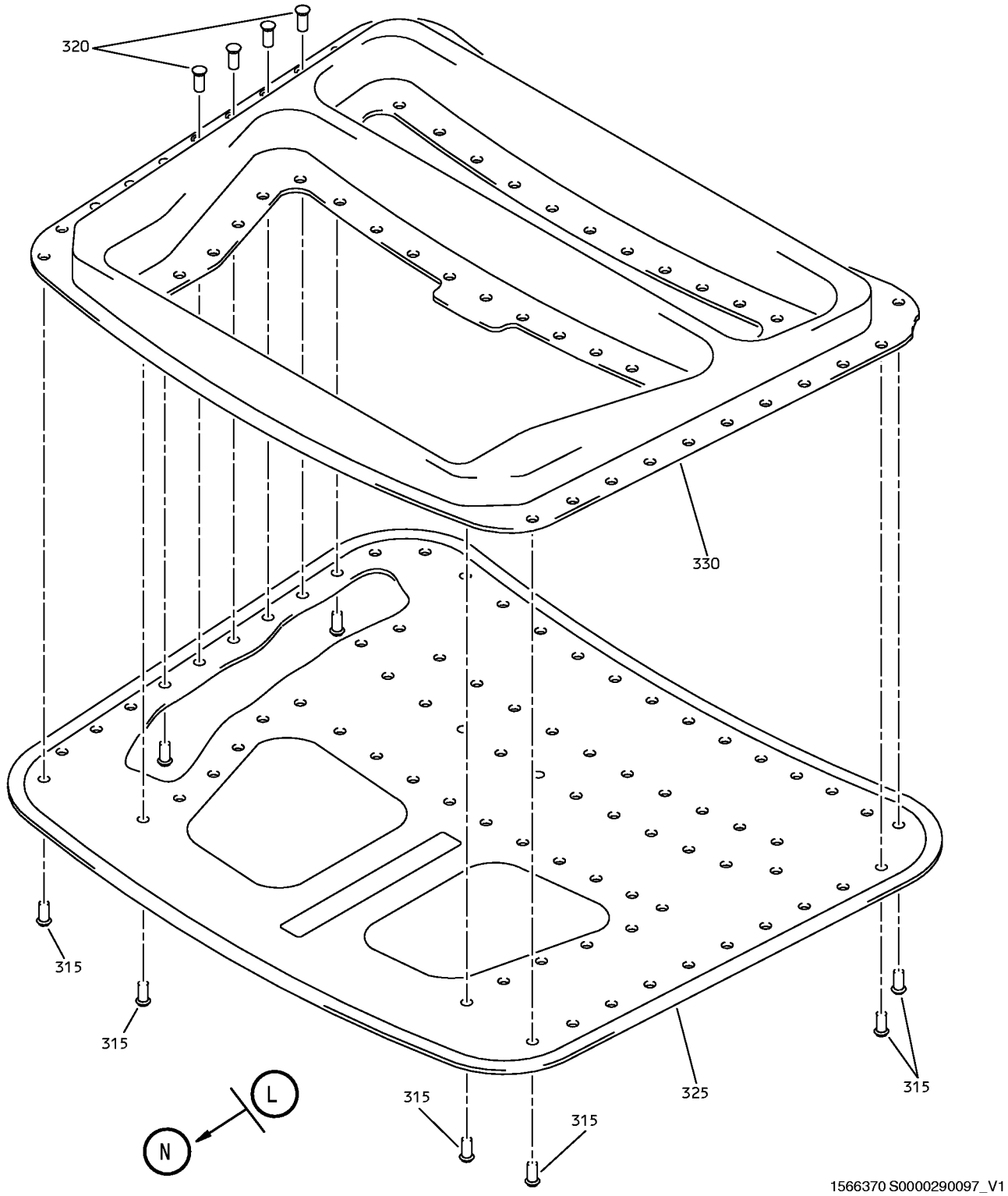


Access and Blowout Door Assembly
IPL Figure 3 (Sheet 6 of 9)

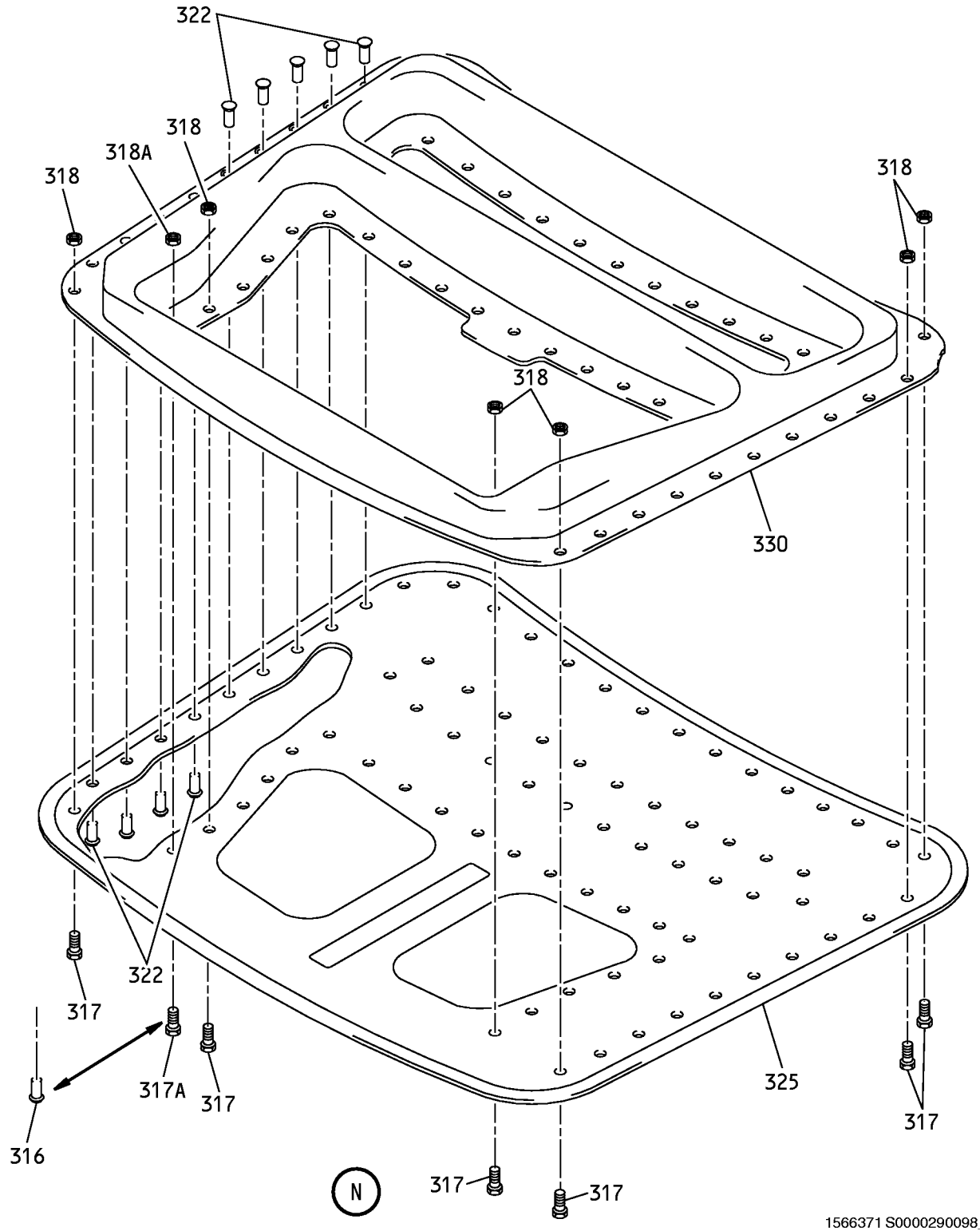


1566368 S0000290096_V1

Access and Blowout Door Assembly
IPL Figure 3 (Sheet 7 of 9)



Access and Blowout Door Assembly
IPL Figure 3 (Sheet 8 of 9)



1566371 S0000290098_V1

Access and Blowout Door Assembly
IPL Figure 3 (Sheet 9 of 9)

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
3–					
–1A	148A6110-9		DOOR ASSY-ACCESS AND BLOWOUT, SECT. 48 148A6110 PDM D	E	RF
–1B	148A6110-10		DOOR ASSY-ACCESS AND BLOWOUT, SECT. 48 148A6110 PDM A	F	RF
–1C	148A6110-11		DOOR ASSY-ACCESS AND BLOWOUT, SECT. 48 148A6110 PDM A	G	RF
–1D	148A6110-13		DOOR ASSY-ACCESS AND BLOWOUT, SECT. 48	H	RF
–1E	148A6110-16		DOOR ASSY-ACCESS AND BLOWOUT, SECT. 48	L	RF
5	BACB30NM4K7		. BOLT	E-H, L	8
10	BACR15GF4D		. RIVET (SIZE DETERMINED ON INST)	E-G	8
–10A	BACR15CE4M		. RIVET (SIZE DETERMINED ON INST)	H, L	8
15	148A6130-13		. FILLER ASSY	E-H, L	4
20	BACR15GF3D		. . RIVET (SIZE DETERMINED ON INST)	E-H, L	4
25	MF53050-4CD		. . NUTPLATE (V15653) (SPEC BACN10JN4CD) (OPT BRFM20C4D (V52828)) (OPT T8301C428CD (V11815)) (OPT 102F9201M4 (V72962)) (OPT NS202487-048 (V80539)) (OPT MF51637-4 (V15653))	E-H, L	2
30	148A6130-14		. . FILLER	E-H, L	1
35	148A6160-1		. HINGE ASSY	E-H, L	2
40	65-67747-4		. . BEARING	E-H, L	1
45	148A6160-2		. . HINGE	E-H, L	1
50	BACS40R008E020F		. SHIM	E-H, L	2
52	BACF3F008L020NN		. FILLER	E-H, L	1
55	BACF3F008D020NN		. FILLER	E-H, L	1
60	BACS12GU08K6		. SCREW	E-H, L	1
65	NAS1149DN816J		. WASHER	E-H, L	1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
3–					
70	PLH508CD		. NUT (V62554) (SPEC BACN10YR08CD) (OPT H52732-08CD (V15653))	E-H, L	1
75	65-54860-6		. PIN ASSY-RETAINING	E-H, L	1
80	NAS1090-1		. . HOOK	E-H, L	1
85	BACC13Y3-130		. . CABLE ASSY	E-H, L	1
90	69-41407-1		. . PIN	E-H, L	1
95	65C36303-1		. HOLDER ASSY-PIN	E-H, L	1
100	BACR15BB3D		. . RIVET (SIZE DETERMINED ON INST)	E-H, L	3
105	100-225-2-10		. . CLIP (V99378)	E-H, L	3
110	65C36303-2		. . PLATE	E-H, L	1
115	BACS53B1ES1		. STUD	E-H, L	1
120	NAS1149D0316J		. WASHER	E-H, L	1
125	PLH53CD		. NUT (V62554) (SPEC BACN10YR3CD) (OPT H52732-3CD (V15653))	E-H, L	1
130	BACJ40A20-9		. JUMPER ASSY	E-H, L	1
135	BACB30NM4K17		. BOLT	E-H, L	1
140	148A6150-1		. STRUT ASSY-JURY 148A6150 PDM A	E	1
–140A	148A6150-2		. STRUT ASSY-JURY 148A6150-2 PDM A	F, G, H, L	1
145	HB4ETL186		. . BEARING (V02758) (SPEC 10-60779-174)	E-H, L	2
150	MS39086-108		. . PIN-SPR	E	4
–150A	BACP18BE4C0750U		. . PIN-SPR	F, G, H, L	4
155	69-41402-2		. . FITTING-END	E-H, L	1
–160	69-41402-1		DELETED		
161	69-41401-1		. . SPRING	E-H, L	1
–165	148A6150-1		DELETED		
–165A	148A6150-3		DELETED		
166	148A6151-1		. . STRUT ASSY-INNER	E	1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
3–					
–166A	148A6151-3		. . STRUT ASSY-INNER	F, G, H, L	1
170	148A6151-2		. . TUBE ASSY-OUTER	E-H, L	1
175	BACN11U5CD1		. . NUT	E-H, L	2
180	BACB30VF08K7		. BOLT	E-H, L	3
185	NAS1149DN816J		. WASHER	E-H, L	2
190	PLH508CD		. NUT (V62554) (SPEC BACN10YR08CD) (OPT H52732-08CD (V15653))	E-H, L	3
195	148A6121-10		. FITTING-JURY STRUT	E-H, L	1
200	BACR15GF3D		. RIVET (SIZE DETERMINED ON INST)	E-H, L	2
205	BACN10JN4CD		. NUTPLATE	E-H, L	1
210	148A6130-17		. FILLER	E-H, L	1
215	BACB30VF3K5		. BOLT	E-H, L	8
220	PLH53CD		. NUT (V62554) (SPEC BACN10YR3CD) (OPT H52732-3CD (V15653))	E-H, L	8
225	NAS1149EN816P		. WASHER	E-H	2
–225A	NAS1149E0316P		. WASHER (OPT ITEM 225B)	L	2
–225B	NAS1149EN816P		. WASHER (OPT ITEM 225A)	L	2
228	NAS1149EN816P		. WASHER	E-H	1
–228A	NAS1149E0332P		. WASHER (OPT ITEM 228B)	L	1
–228B	NAS1149EN816P		. WASHER (OPT ITEM 228A)	L	1
–230	10-61704-2		DELETED		
230A	H942-3		. LATCH ASSY (V83014) (SPEC 10-61704-2)	E-H, L	1
235	BACS40R010B024F		. SHIM	E-H, L	1
240	BACS40R008A024F		. SHIM	E-H, L	AR
245	BACB30NM3K8		. BOLT	E-H, L	4

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
3–					
247	BACR15BA3AD		. RIVET (SIZE DETERMINED ON INST)	E-H, L	4
250	148A6130-16		. FILLER ASSY	E-H, L	1
255	148A6130-15		. FILLER ASSY	E-H, L	1
260	BACR15GF3D		. . RIVET (SIZE DETERMINED ON INST)	E-H, L	4
265	FS1651-3		. . NUTPLATE (V15653) (SPEC BACN10KH3CD) (OPT 102F9209M3 (V72962)) (OPT NS202496-02 (V80539))	E-H, L	2
270	148A6130-20		. . FILLER (USED ON ITEM 250)	E-H, L	1
275	148A6130-19		. . FILLER (USED ON ITEM 255)	E-H, L	1
280	BACR15GF6D		. RIVET (SIZE DETERMINED ON INST)	E-G	4
282	BACR15CE6M		. RIVET (SIZE DETERMINED ON INST)	L	4
283	BACB30YP6K3		. BOLT	H	4
284	BACN11AJ6CS		. NUT	H	4
285	BACR15FT5D		. RIVET (SIZE DETERMINED ON INST)	E-G	12
286	BACB30VT5K3		. BOLT	H, L	8
287	BACB30VT5K2		. BOLT	H, L	4
288	BACC30BL5		. COLLAR	H, L	12
290	148A6121-12		. ANGLE-LATCH	E-H, L	1
295	148A6121-11		. ANGLE-LATCH	E-H, L	1
300	BACS40R008D017F		. SHIM	E-H, L	2
305	BACR15GF5D		. RIVET (SIZE DETERMINED ON INST)	E-H, L	14
310	148A6121-9		. ANGLE-LATCH SPRT	E, F	1
–310A	148A6121-15		. ANGLE-LATCH SPRT	G, H, L	1
315	BACR15GF5D		. RIVET (SIZE DETERMINED ON INST)	E-G	75

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
3–					
316	BACR15GF5D		. RIVET (SIZE DETERMINED ON INST)	H	1
317	BACB30YP5K2		. BOLT	H, L	69
317A	BACB30YP5K2		. BOLT	L	1
318	BACN11AJ5CS		. NUT	H, L	69
318A	BACN11AJ5CS		. NUT	L	1
320	BACR15BA5DC		. RIVET (SIZE DETERMINED ON INST)	E-G	4
322	BACR15CE5M		. RIVET (SIZE DETERMINED ON INST)	H, L	9
325	148A6120-4		. SKIN	E-H, L	1
330	148A6111-2		. PAN	E-G	1
–330A	148A6111-3		. PAN	H	1
–330B	148A6111-5		. PAN	L	1

–Item not Illustrated