COMPONENT MAINTENANCE MANUAL WITH ILLUSTRATED PARTS LIST

FORWARD AIRSTAIR DOOR ASSEMBLY

PART NUMBER 141A6402–2, –3, –4

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

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COMPONENT MAINTENANCE MANUAL

Revision No. 7
Jul 01/2009

To: All holders of FORWARD AIRSTAIR DOOR ASSEMBLY 52-61-02.

Attached is the current revision to this COMPONENT MAINTENANCE MANUAL

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Location of Change	Description of Change
52-61-02	
FRONTMATTER	Changed the part number information on the title page.
	Changed the data in the TEMPORARY REVISION AND SERVICE BULLETIN RECORD list.
	Added forward airstair door assemblies 141A6402-3,-4.
DESCRIPTION AND OPERATION	Added new assembly 141A6402-3.
DISASSEMBLY	Added Clarifications and Updated Call outs.
CLEANING	Added Clarifications and Updated Call outs.
CHECK	Added new item.
REPAIR-GENERAL	Added clarifications.
	Added new assemblies 141A6405-1, -2; 141A6410-5, -6.
REPAIR 2-1	Deleted the Consumable Materials list.
	Changed the data in the References list.
	Added Clarifications and Updated Call outs.
REPAIR 2-2	Added clarifications.
	Changed the data in the References list.
REPAIR 3-1	Added new assemblies 141A6405-1, -2, 141A6410-5, -6.
	Changed the data in the References list.
	Added forward airstair door assemblies 141A6402-3,-4.
REPAIR 3-2	Added new part numbers 141A6406-1, 141A6411-3.
REPAIR 4-1	Added new assembly 141A6413-4.
	Added new insulation panel assemblies 141A6413-4,-7.
	Changed the data in the Consumable Materials list.
	Changed the data in the References list.
	Changed consumable from ‘‘adhesive, A00153’’ to ‘‘adhesive, A50113’’
ASSEMBLY	Revised assembly instructions.
	Added the Tools/Equipment list.
	Changed the data in the Consumable Materials list.
	Changed the data in the References list.
	Added clarifications and updated callouts.
ILLUSTRATED PARTS LIST	Changed the data in the Vendor Codes list.
	Changed the data in the NUMERICAL INDEX list.
	Added forward airstair door assemblies 141A6402-3,-4.
	Added new Illustrated Parts List.

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TEMPORARY REVISION AND SERVICE BULLETIN RECORD

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVE	DATE OF INCORPORATION INTO MANUAL
		PRR 35385-1	NOV 01/98
		PRR 38601	JUL 01/09
		PRR 38759	JUL 01/09

COMPONENT MAINTENANCE MANUAL

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

Revision		Filed		Revision		Filed	
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Number	Date	Date	Initials

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Temporary Revision		Inserted		Removed	
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Temporary Revision		Inserted		Removed	
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INTRODUCTION

1. General

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

B. This manual is divided into different parts:

(1) Title Page

(2) Transmittal Letter

(3) Highlights

(4) List of Effective Pages

(5) Table of Contents

(6) Temporary Revision & Service Bulletin Record

(7) Record of Revisions

(8) Record of Temporary Revisions

(9) Introduction

(10) Procedures & IPL Sections

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

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

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

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

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

FORWARD AIRSTAIR DOOR ASSEMBLY - DESCRIPTION AND OPERATION

1. Description

A. The forward airstair door assembly (DESCRIPTION AND OPERATION, Figure 1) is a plug type door that opens toward the inside of the airplane. It is located below the forward entry door assembly at the left side of the forward end of the fuselage.

B. The door framework assembly is made of aluminum alloy with inner and outer skins attached to the internal webs and stiffeners. The door assembly consist of the door structure, eight adjustable stop fittings, two guide fittings, two vertical alignment roller guide support fittings and a stop guide fitting.

2. Operation

A. The door assembly opens automatically when the forward airstair assembly is activated from the inside of the airplane. A jackscrew moves the door assembly inboard and down along a pair of guide rails. The door assembly is stowed below the airstair carrier assembly when it is fully open.

B. The door assembly closes automatically when the forward airstair assembly is deactivated from the inside of the airplane. The reverse action of the jackscrew moves the door assembly outboard and up along the guide rails to its closed position.

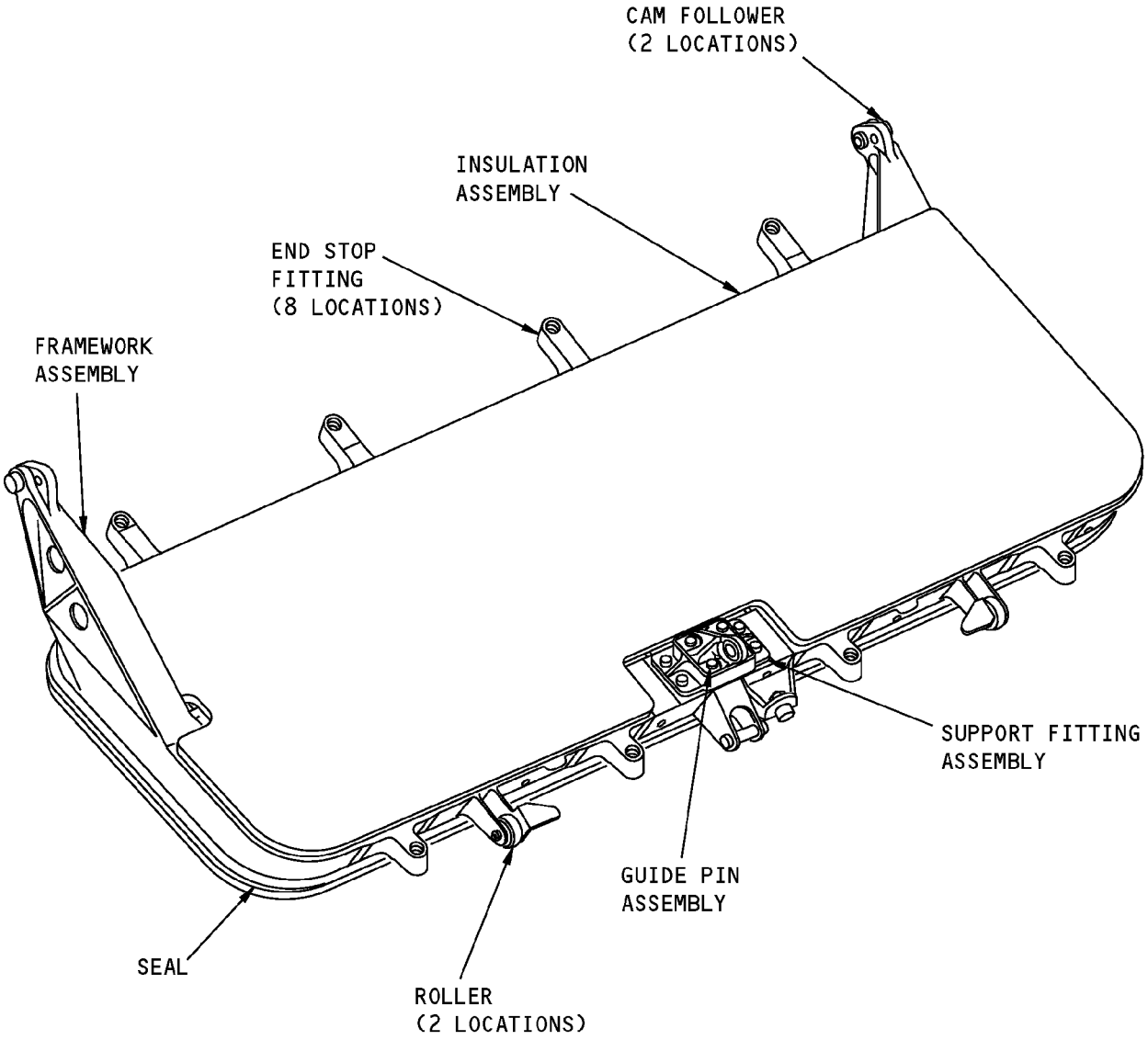
3. Leading Particulars (Approximate)

A. Length – 47 inches

B. Width – 24 inches

C. Height – 10 inches

D. Weight – 28 pounds



141A6402-2,-3,-4 Forward Airstair Door Assembly
Figure 1

(NOT APPLICABLE)

DISASSEMBLY

1. General

A. This procedure has the data necessary to disassemble the forward airstair 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 for item numbers.

2. Disassembly

A. Procedure

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

CAUTION: TO PREVENT DAMAGE, REMOVE PANEL INSULATION ASSEMBLY WITH CARE.

(2) Remove the panel insulation assembly (165) from the framework.

NOTE: If panel insulation assembly (165) is damaged during disassembly, replace entire assembly.

(3) Remove the seal (185A) from the framework assembly (190A).

(4) Remove the bolts (120A), the washers (125) and the guide fitting assembly (130) from the support fitting assembly (145).

NOTE: Do not remove bearing (135A) from the fitting (140) unless replacement is necessary.

(5) Remove the bolt (115), the washer (125), the support fitting assembly (145), and the serrated plate (160) from the framework assembly (190A).

NOTE: Do not remove the insert (150) from the fitting (155) unless replacement is necessary.

(6) Remove the nut (90), the washers (95, 100, 105), and the follower (110) from the framework assembly (190A).

(7) Remove the bolt (25), the washers (35, 40, 45), the spacer (30), the roller (55), and the nut (50) from the framework assembly (190A).

(8) Remove the follower (20), the washers (10, 15), and the nut (5) from the framework assembly (190A).

(9) Remove the bolt (60), the washers (70, 75, 80), the spacer (65), the nut (85), and cotter pin (57) from the framework assembly (190A).

CLEANING

1. General

A. This procedure has the data necessary to clean the forward airstair 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 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

CAUTION: CLEAN TEFLON-LINED BEARINGS ONLY BY THE SPECIAL PROCEDURE IN SOPM 20-30-01.

(1) The bearing (135A) is teflon lined. Clean only by special procedures given in SOPM 20-30-01.

(2) Use standard industry procedures and 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 for item numbers.

2. Check

A. References

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

B. Procedure

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

CAUTION: TO PREVENT DAMAGE TO ANTIFRICTION BEARINGS, IT IS NECESSARY TO PROTECT THEM FROM INSPECTION FLUID WHEN PREPARING MAGNETIC PARTICLE OR PENETRANT EXAMINATION OF COMPONENTS CONTAINING BEARINGS.

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

(a) Bushing (195, 200)

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

(a) Fitting (140, 155)

(b) Framework (225A)

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
65-32166	GUIDE FITTING ASSEMBLY, SUPPORT FITTING	2-1, 2-2
141A6405, 141A6410	FRAMEWORK ASSEMBLY	3-1
141A6406, 141A6411	FRAMEWORK	3-2
141A6413	PANEL INSULATION ASSEMBLY	4-1

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)
(ST)	STATISTICAL TOLERANCE
↔	BETWEEN
∅	DIAMETER
S ∅	SPHERICAL DIAMETER
R	RADIUS
SR	SPHERICAL RADIUS
()	REFERENCE
BASIC (BSC) OR [DIM]	A THEORETICALLY EXACT DIMENSION USED TO DESCRIBE SIZE, SHAPE OR LOCATION OF A FEATURE. FROM THIS FEATURE PERMISSIBLE VARIATIONS ARE ESTABLISHED BY TOLERANCES ON OTHER DIMENSIONS OR NOTES.
[A]◀	DATUM
(F)	FREE STATE
(T)	TANGENT PLANE
(M)	MAXIMUM MATERIAL CONDITION (MMC)
(L)	LEAST MATERIAL CONDITION (LMC)
(S)	REGARDLESS OF FEATURE SIZE (RFS)
(P)	PROJECTED TOLERANCE ZONE
FIM	FULL INDICATOR MOVEMENT
TIR	TOTAL INDICATOR READING

EXAMPLES

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

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. General

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

D. Procedure

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

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

Table 601: Refinish Details

IPL FIG. & ITEM	MATERIAL	FINISH
IPL Fig. 1		
Plate (160)	Aluminum Alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.35) plus apply primer, C00259 (F-20.03) except no primer on serrated surface.
Fitting (155)	Aluminum Alloy	Boric acid-sulfuric acid anodize or chromic acid anodize (F-17.35) plus apply primer, C00259 (F-20.03) except no primer in holes, slots, or serrations.

GUIDE FITTING ASSEMBLY - REPAIR 2-1

65-32166–10

1. General

A. This procedure has the data necessary to repair and refinish the guide fitting assembly (130).

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

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

D. Refer to IPL Figure 1 for item numbers.

2. Bearing Replacement

A. References

Reference	Title
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-60-02	FINISHING MATERIALS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

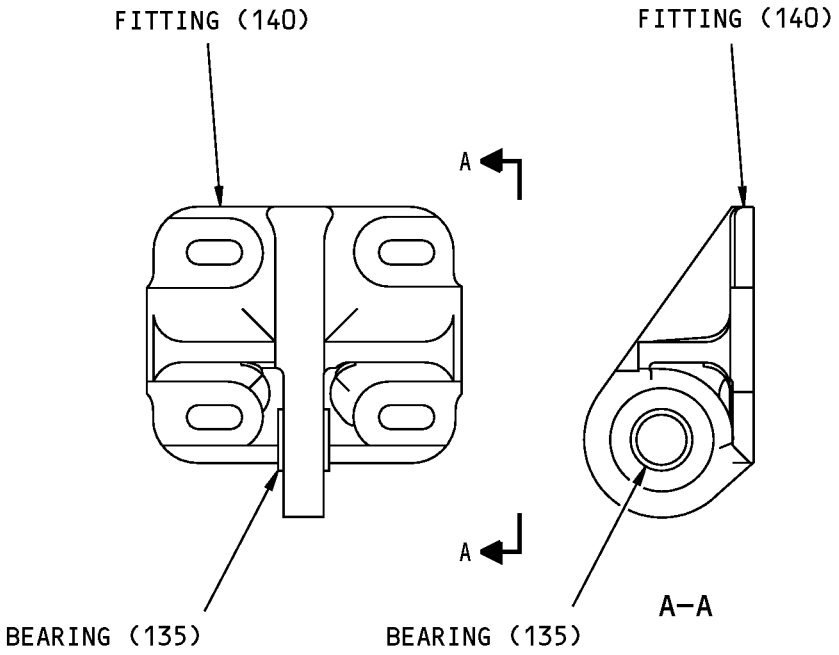
B. Procedure

NOTE: For finishing materials, refer to SOPM 20-60-02. For miscellaneous materials, refer to SOPM 20-60-04.

(1) Remove the bearing (135A) from the fitting (140).

(2) Install the new bearing (135A) in the fitting (140) as specified in SOPM 20-50-03.

(3) The preload torque on the bearing (135A) after installation shall be a maximum of 20 pound-inches.



ITEM NUMBERS REFER TO IPL FIG. 1

65-32166-10 Guide Fitting Assembly Repair
Figure 601

SUPPORT FITTING - REPAIR 2-2

65-32166–11

1. General

A. This procedure has the data necessary to repair and refinish the fitting (140).

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

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

D. Refer to IPL Figure 1 for item numbers.

E. General repair details:

(1) Material: Aluminum alloy

2. Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

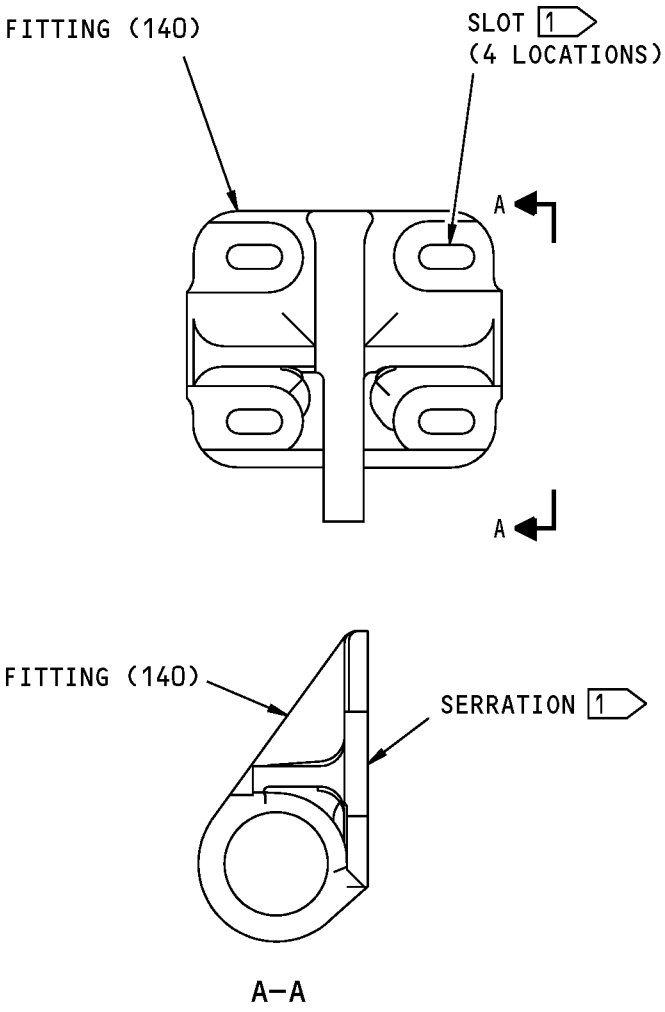
Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

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

(2) Apply primer, C00259 (F-20.03), but not as noted by flagnote 1 in REPAIR 2-2, Figure 601.



1 NO PRIMER IN SLOTS OR SERRATIONS

ITEM NUMBERS REFER TO IPL FIG. 1

65-32166-11 Support Fitting Refinish
Figure 601

FRAMEWORK ASSEMBLY - REPAIR 3-1

141A6405–1, –2, 141A6410–4, –5, –6

1. General

A. This procedure has the data necessary to repair the framework assembly (190A).

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

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

D. Refer to IPL Figure 1 for item numbers.

2. Bushing Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00153	Adhesive - Low Odor, Synthetic Rubber, 1 Part	BMS 5-30
A00247	Sealant - Pressure And Environmental - Chromate Type	BMS 5-95
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	
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 20-30-90	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 20-44-01	APPLICATION OF SPECIAL PURPOSE COATINGS AND FINISHES
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-50-05	APPLICATION OF ALUMINUM FOIL AND OTHER MARKERS
SOPM 20-50-12	APPLICATION OF ADHESIVES
SOPM 20-50-19	GENERAL SEALING
SOPM 20-60-02	FINISHING MATERIALS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

C. Procedure (REPAIR 3-1, Figure 601)

NOTE: For decoding table for Boeing finish codes, refer to SOPM 20-41-01. For miscellaneous materials, refer to SOPM 20-60-04.

(1) Remove the bushings (195, 200) from the framework (225A).

(2) Bushing (195) Installation:

(a) Install bushing (195) with sealant, A00247 as specified in SOPM 20-50-03 and fillet seal as specified in SOPM 20-50-19.

(b) Flare the bushing (195) to the dimension shown in REPAIR 3-1, Figure 601, with no gap allowed, before the sealant cures.

(c) Remove excess sealant to the dimensions shown in REPAIR 3-1, Figure 601 before the sealant cures.

(3) Bushing (200) Installation:

(a) Install bushing (200) with sealant, A00247 as specified in SOPM 20-50-03.

(b) Flare the bushing (200) to match the countersink in the framework (225A), with no gap allowed, before the sealant cures.

(c) Remove excess sealant to the dimensions shown in REPAIR 3-1, Figure 601 before the sealant cures.

(d) Apply touch-up primer, C00259 (F-20.03) after the sealant cures.

D. Loop Fastener Replacement (REPAIR 3-1, Figure 602)

NOTE: For stripping of protective finishes, refer to SOPM 20-30-02. For solvent for final cleaning of solvent resistant organic coatings before non-structural bonding, refer to SOPM 20-30-90.

(1) Remove the loop fasteners (205, 210) from the framework assembly (190A).

(2) Clean bonding surface with Series 90 solvent, B01010.

(3) Apply adhesive, A00153 onto the framework assembly (190A) bonding surface as shown in SOPM 20-50-12. Allow the adhesive, A00153 to air dry until it is tacky.

(4) Install the loop fasteners (205, 210) as shown in SOPM 20-50-12 onto the framework assembly (190A) as shown in REPAIR 3-1, Figure 602.

E. Plate and Marker Replacement (REPAIR 3-1, Figure 602)

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

(1) Replace the identification plate (230) as follows:

(a) Remove the identification plate (230) from the framework assembly (190A).

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

(c) Install self-adhesive plate (230) onto the framework assembly (190A) shown in REPAIR 3-1, Figure 602 and SOPM 20-50-05.

(d) Apply coating, B00571 as shown in SOPM 20-44-01. Coating must extend a minimum of 0.35 inch beyond the edge of the identification plate (230).

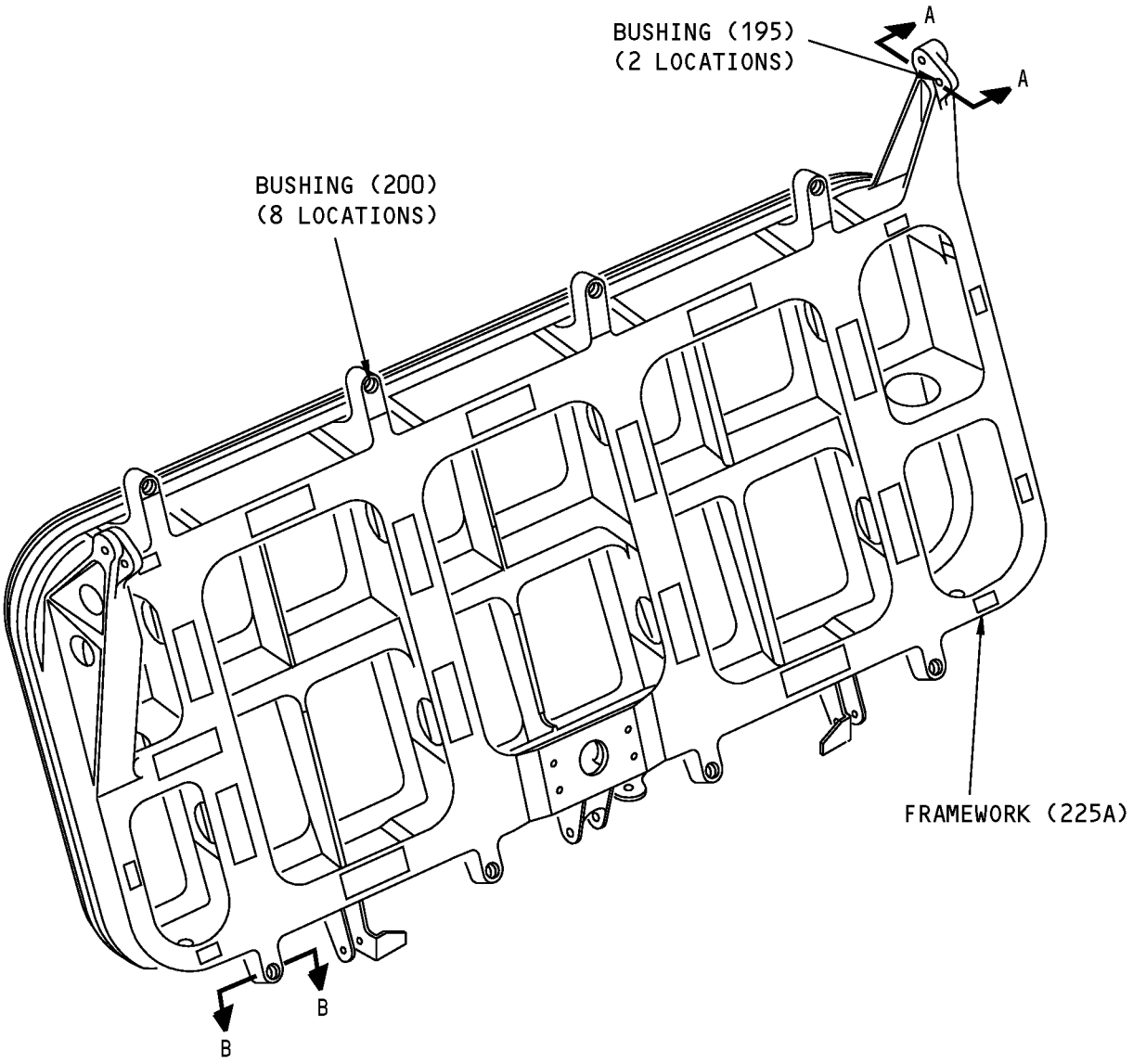
(2) Replace the marker (235) as follows:

(a) Remove the marker (235) from the framework assembly (190A).

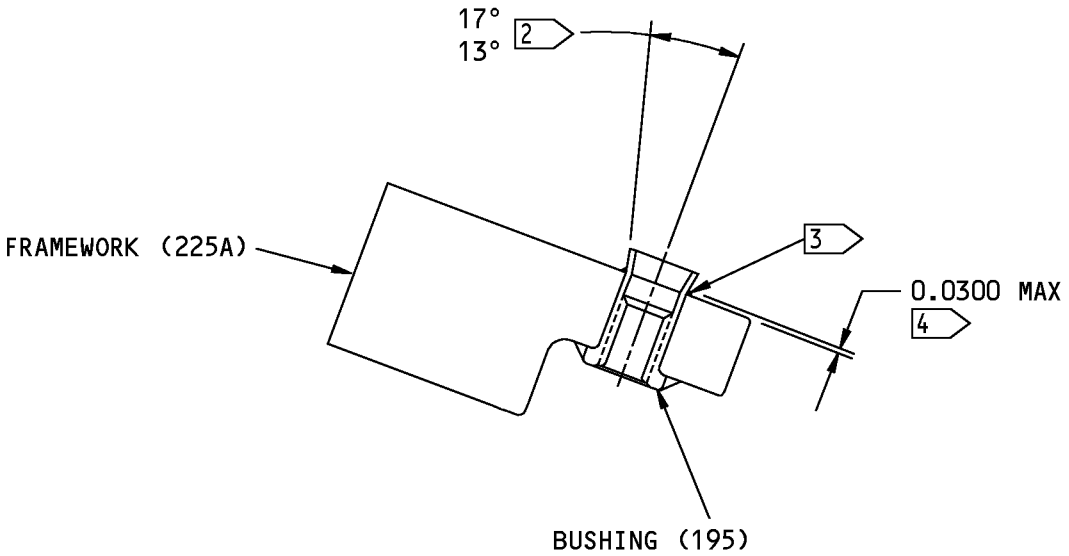
(b) Clean bonding surface with Series 90 solvent, B01010 (SOPM 20-30-90).

(c) Install self-adhesive marker (235) onto the framework assembly (190A) shown in REPAIR 3-1, Figure 602 and SOPM 20-50-05.

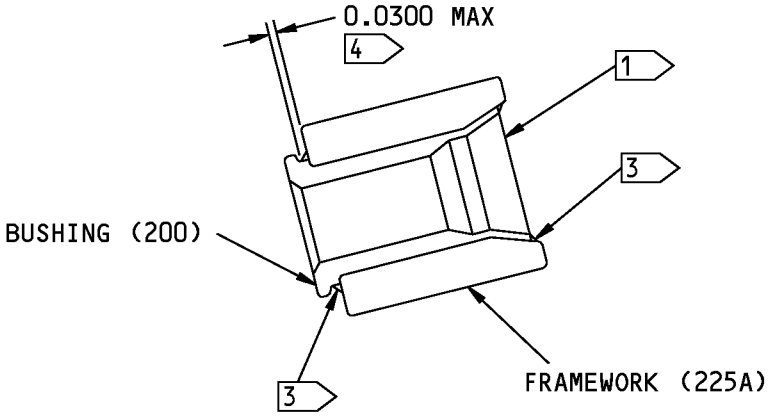
(d) Apply coating, B00571 as shown in SOPM 20-44-01. Coating must extend a minimum of 0.35 inch beyond the edge of the marker (235).



141A6405-1, -2, 141A6410-4,-5,-6 Framework Assembly Repair
Figure 601 (Sheet 1 of 2)



A–A



B–B

1 > FLARE BUSHING TO MATCH COUNTERSINK IN FRAMEWORK WITH NO GAP ALLOWED

2 > FLARE BUSHING TO DIMENSIONS SHOWN WITH NO GAP ALLOWED

3 > FILLET SEAL

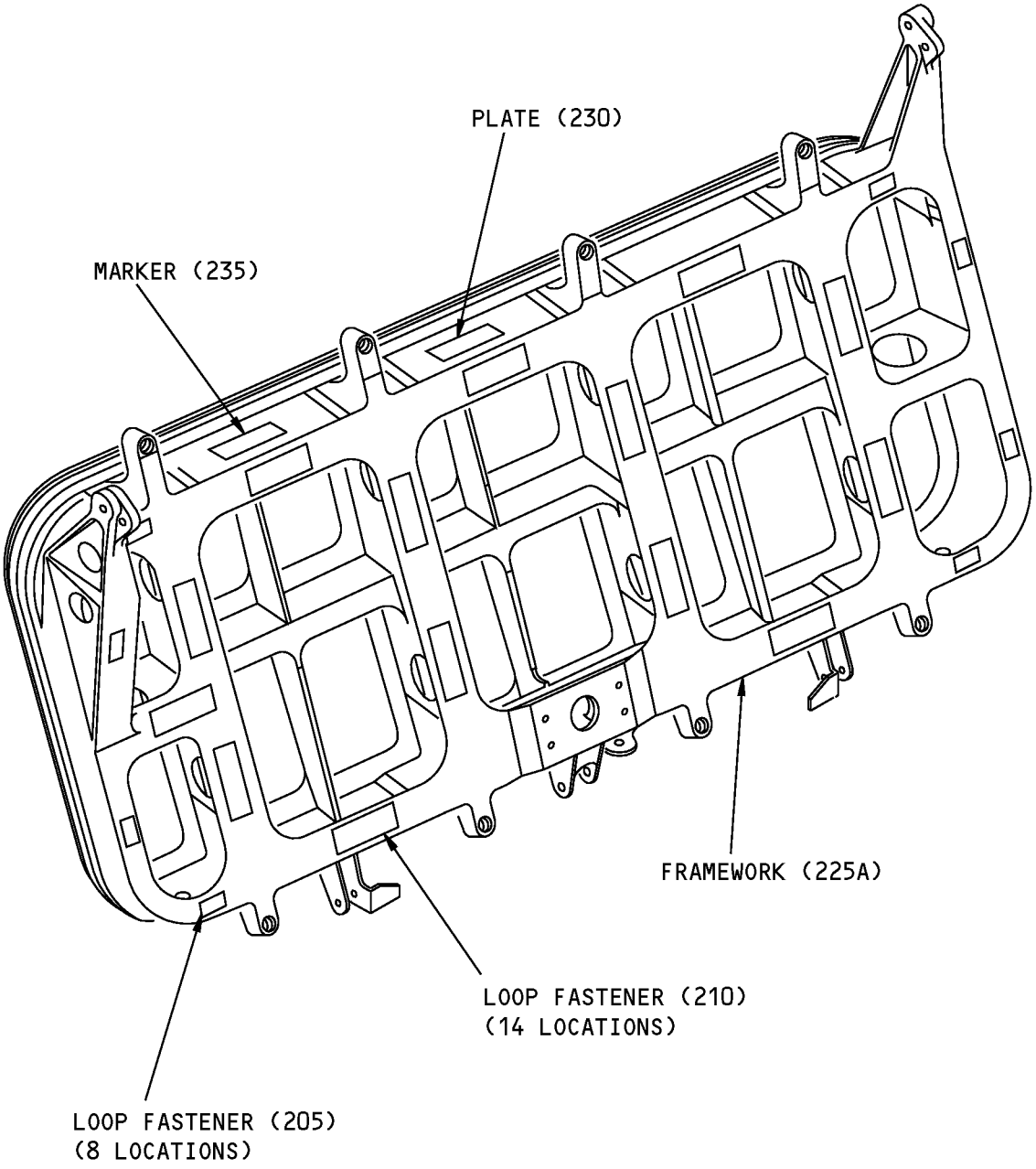
4 > REMOVE EXCESS SEALANT BEFORE SEALANT CURE TO WITHIN DIMENSIONS SHOWN

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

G38176 S00041002725_V2

141A6405-1, -2, 141A6410-4,-5,-6 Framework Assembly Repair
Figure 601 (Sheet 2 of 2)



ITEM NUMBERS REFER TO IPL FIG. 1

141A6406-1, 141A6411-2,-3 Loop Fastener Plate and Marker Replacement
Figure 602

FRAMEWORK - REPAIR 3-2

141A6406–1, 141A6411–2, –3

1. General

A. This procedure has the data necessary to refinish the framework (225A).

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

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

D. Refer to IPL Figure 1 for item numbers.

2. Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

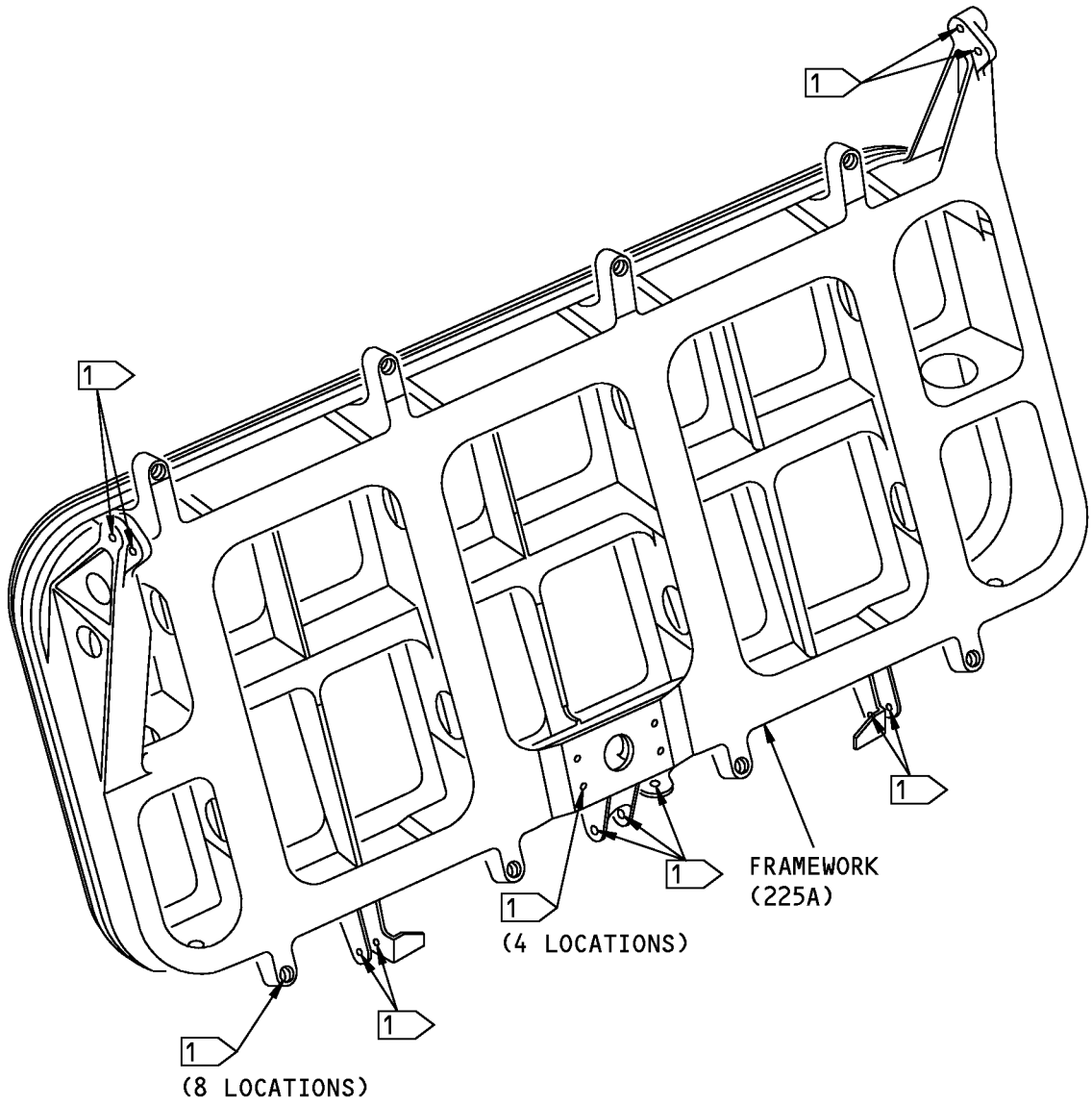
Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

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

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

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

(2) Apply primer, C00259 (F-20.03), but not as shown by flagnote 1 on REPAIR 3-2, Figure 601.



1 NO PRIMER (F-20.03) THIS HOLE

ITEM NUMBERS REFER TO IPL FIG. 1

G38386 S00041002728_V2

141A6406-1, 141A6411-2,-3 Framework Refinish
Figure 601

PANEL INSULATION ASSEMBLY - REPAIR 4-1

141A6413–1, –4, –7

1. General

A. This procedure has the data necessary to repair the panel insulation assembly (165).

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

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

D. Refer to IPL Figure 1 for item numbers.

2. Hook Fastener Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A50113	Adhesive - BMS 5-30	BAC5010 Type 48

B. References

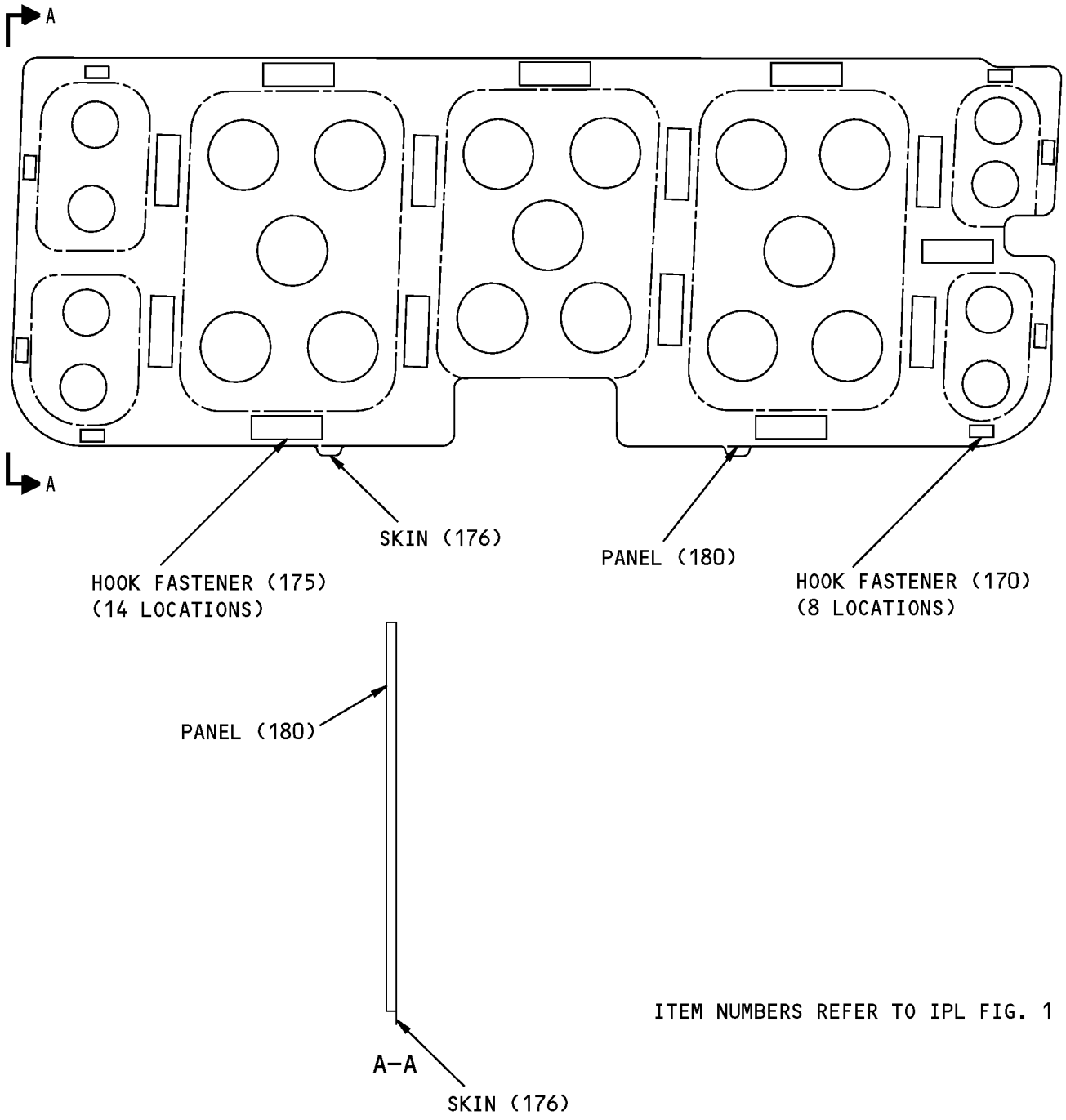
Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-50-12	APPLICATION OF ADHESIVES

C. Procedure (REPAIR 4-1, Figure 601)

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

(1) Remove the hook fasteners (170, 175) from the bonded skin (176) and panel (180).

(2) Install the hook fasteners (170, 175) onto the skin (176) with adhesive, A50113 as specified in SOPM 20-50-12.



141A6413-1, -4, -7 Insulation Panel Assembly Repair
Figure 601

ASSEMBLY

1. General

A. This procedure has the data necessary to assemble the forward airstair 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 for item numbers.

2. Assembly

A. Tools/Equipment

NOTE: Equivalent substitutes may be used.

Reference	Description
SPL-1981	Tool - Installation, Door Seal (Part #: B52004-1, Supplier: 81205) (Part #: K52011-1, Supplier: 81205)

B. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
B00003	Cleaner - Emulsion Alkaline - GMC 528B	
B00052	Soap - Liquid - Turco 1526	BAC5507
B50093	Soap - Liquid - Kelite Spraywhite	BAC5507
C00259	Primer - Chemical And Solvent Resistant Finish, Epoxy Resin	BMS10-11, Type I
C00260	Coating - Chemical And Solvent Resistant Finish, Epoxy Resin Enamel	BMS10-11, Type II

C. References

Reference	Title
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-50-01	BOLT AND NUT INSTALLATION
SOPM 20-50-02	INSTALLATION OF SAFETYING DEVICES
SOPM 20-60-02	FINISHING MATERIALS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

D. Procedure (ASSEMBLY, Figure 701)

NOTE: For the decoding table for Boeing finish codes, refer to SOPM 20-41-01. For bolt and nut installation, refer to SOPM 20-50-01. For finishing materials, refer to SOPM 20-60-02. For 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, apply touch-up finish primer, C00259 (F-14.9962) and enamel coating, C00260 (F-21.17) to surfaces identified by flagnote 1 in ASSEMBLY, Figure 701, section D-D.

(3) Install the followers (20), washers (15), tab washer (10) and nut (5) onto the framework assembly (190A) as shown in ASSEMBLY, Figure 701, section A-A. Tighten the nut (5) to 20-40 pound-inches of torque. Bend a minimum of two tabs on the tab washer (10) after rigging of upper guide track alignment.

(4) Install the rollers (55), bolts (25), washers (35, 40, 45), spacers (30) and nuts (50) onto the framework assembly (190A) as shown in ASSEMBLY, Figure 701, section B-B.

(5) Install the follower (110), washers (100, 105), tab washer (95) and nut (90) onto the framework assembly (190A) as shown in ASSEMBLY, Figure 701, section C-C. Tighten the nut (90) to 20-40 pound-inches. Bend a minimum of two tabs on the tab washer (95).

(6) Install the bolt (60), washers (70, 75, 80), spacer (65), and nut (85) onto the framework assembly (190A) as shown in ASSEMBLY, Figure 701. Tighten the nut (85) to a maximum of 25-35 pound-inches. Install the cotter pin (57) onto the bolt (60) (SOPM 20-50-02).

(7) Install the support fitting assembly (145) onto the framework assembly (190A) with the bolts (115) and washers (125). Make sure to align the bolts (115) to the center of the slots in the support fitting assembly (145).

(8) Install the fitting guide assembly (130) onto the support fitting assembly (145) with the bolts (120A) and washers (125). Make sure to align the bolts (120A) to the center of the slots in the fitting guide assembly (130).

(9) Install the seal (185A) onto the framework assembly (190A):

NOTE: Use Kelite Spraywhite, B50093, Turco 1526 soap, B00052, or GMC 528B cleaner, B00003 to install the seal (185A).

(a) Place the seal (185A) over the seal retainer groove in the framework assembly (190A) with the sealing lip facing outboard and the side marked ''TOP'' on the aft side of the framework assembly (190A). The seal (185A) should be stretched uniformly.

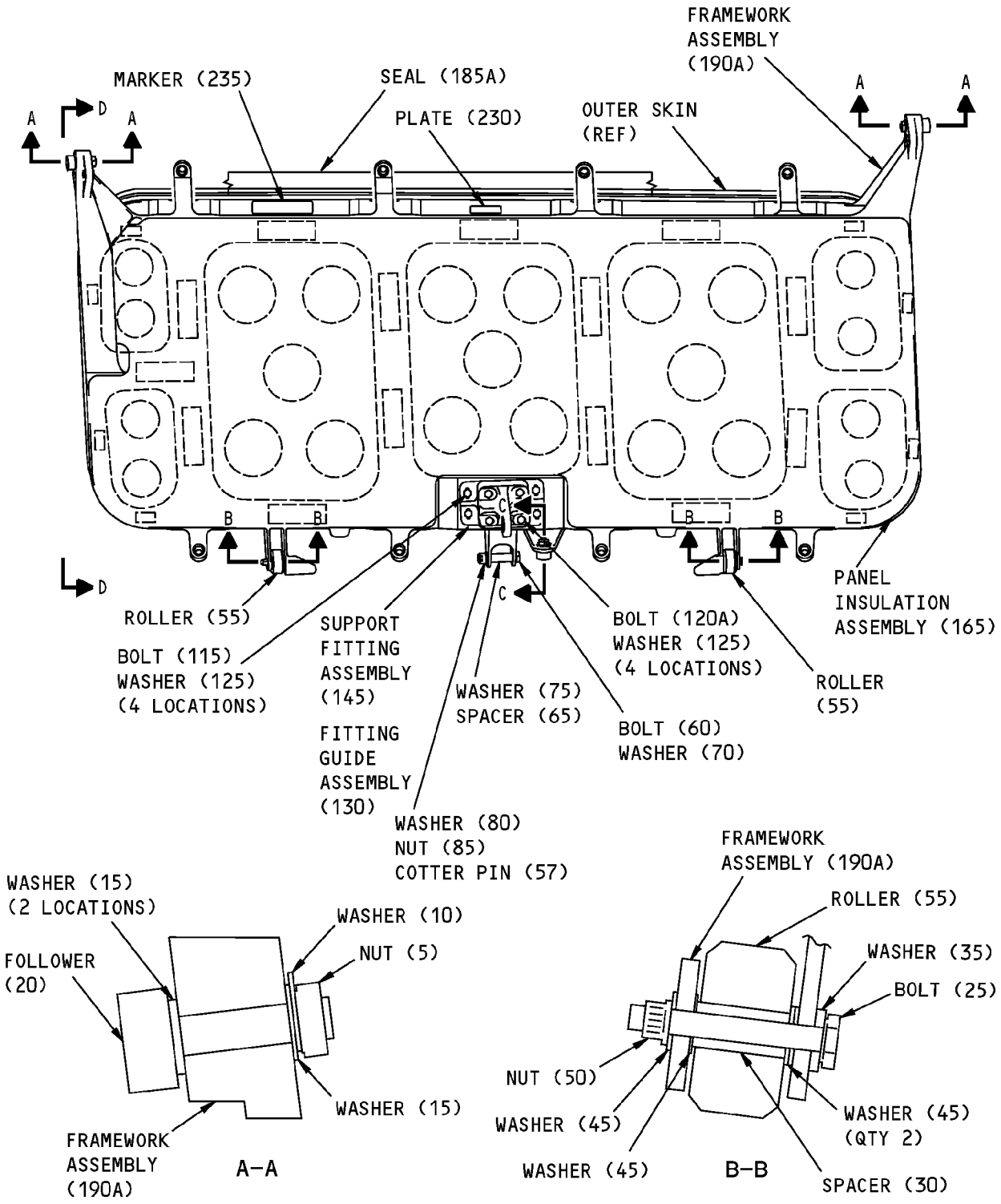
NOTE: Install seal (185A) by slipping the outboard lip of the seal base into the outboard flange of the seal retainer. Use door seal installation tool, SPL-1981 to force the inboard lip of the seal base into the seal retainer. Push perpendicularly to the seal (185A) to avoid bunching and sliding of the seal (185A).

(b) Insert 2 to 3 inches of the seal (185A) into the seal retainer at the four corners of the framework assembly (190A).

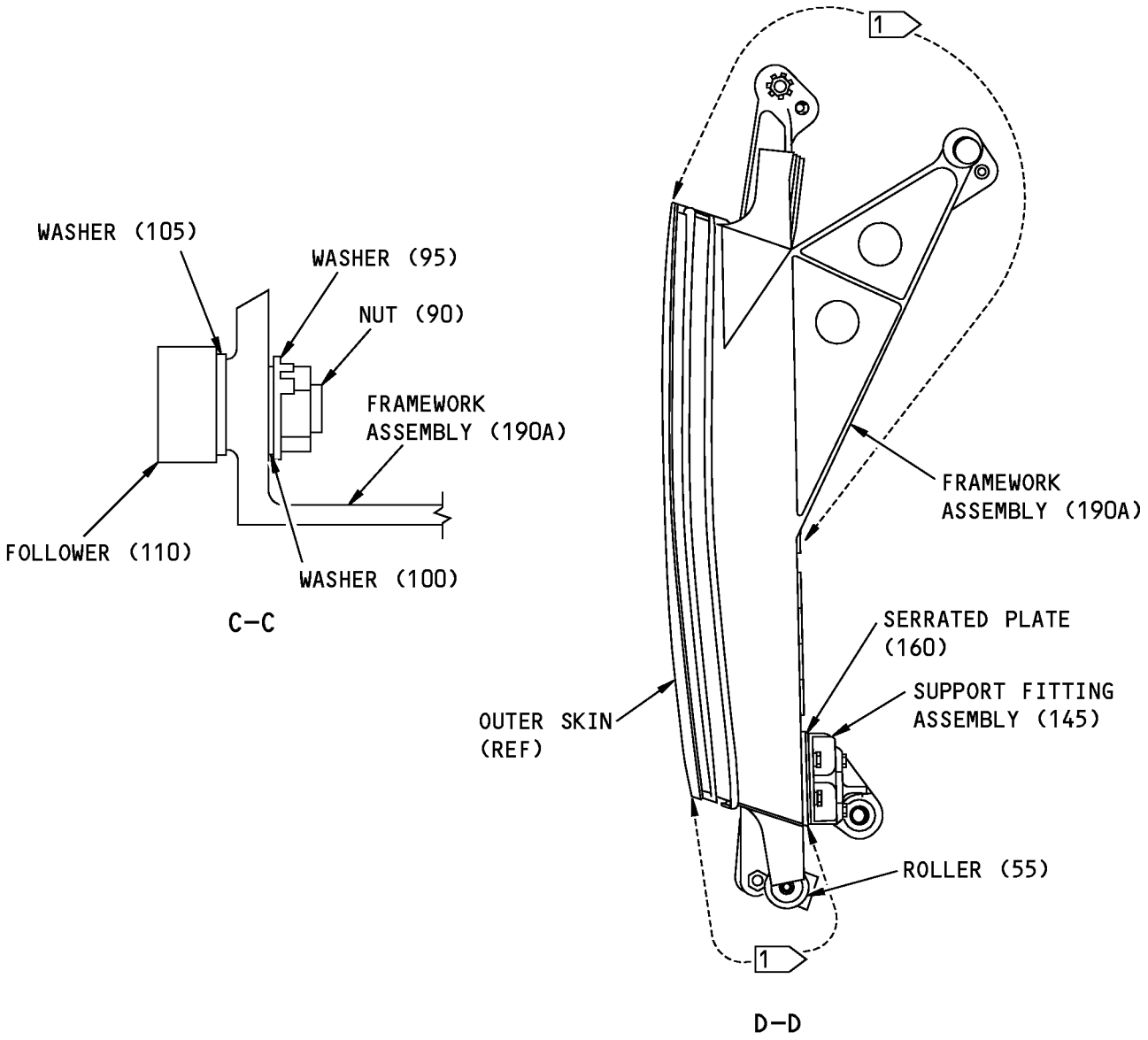
(c) Without stretching the seal (185A), insert 2 to 3 inches of the seal (185A) into the seal retainer at the middle of the four sides.

(d) Complete installing the seal (185A) by going from the middle of the sides to the corners, making sure to eliminate wrinkles.

NOTE: Eliminate wrinkles by redistributing the seal (185A) more uniformly in the seal retainer. A maximum waviness height of 0.10 inch is permissible, as measured at the sealing surface of the seal lip.



Forward Airstair Door Assembly
Figure 701 (Sheet 1 of 2)



1 APPLY FINISH (F-14.9962 + F-21.17) ALL AROUND THE OUTER FRAMEWORK ASSEMBLY AND THE GUIDE ARMS BEFORE INSTALLATION OF SEAL AND OTHER COMPONENTS. OVERSPRAY IS NOT PERMITTED ON THE OUTSIDE SURFACE OF THE SKIN, THE INSIDE OF ATTACH HOLES AND THE INSIDE BUSHINGS

ITEM NUMBERS REFER TO IPL FIG. 1

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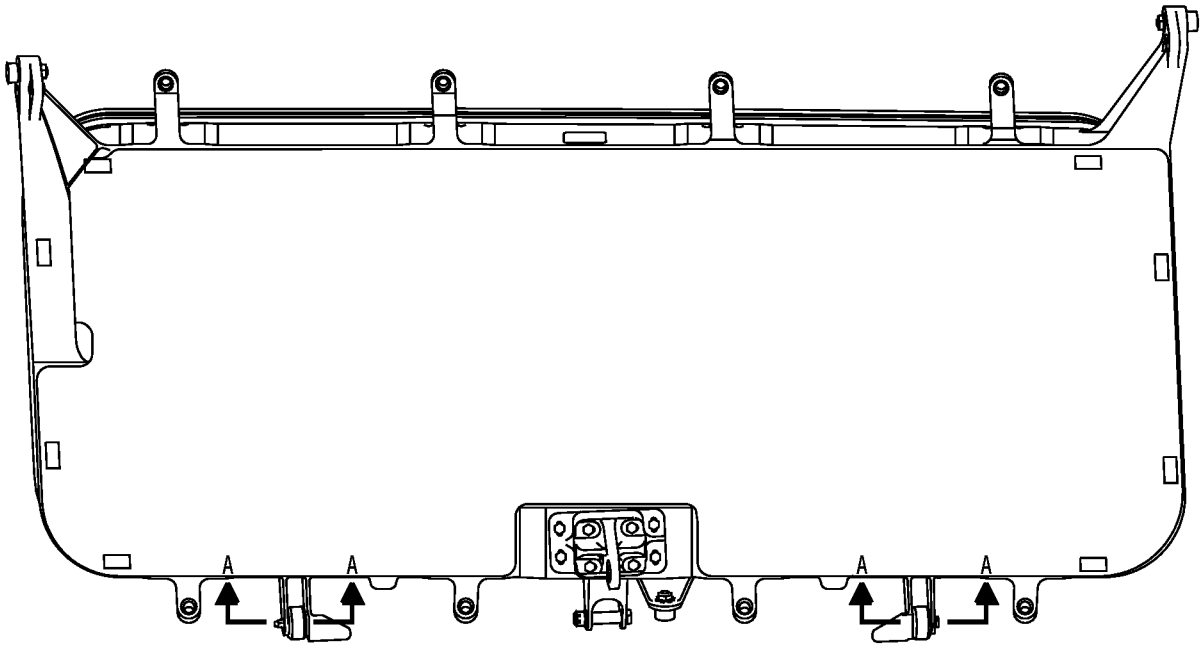
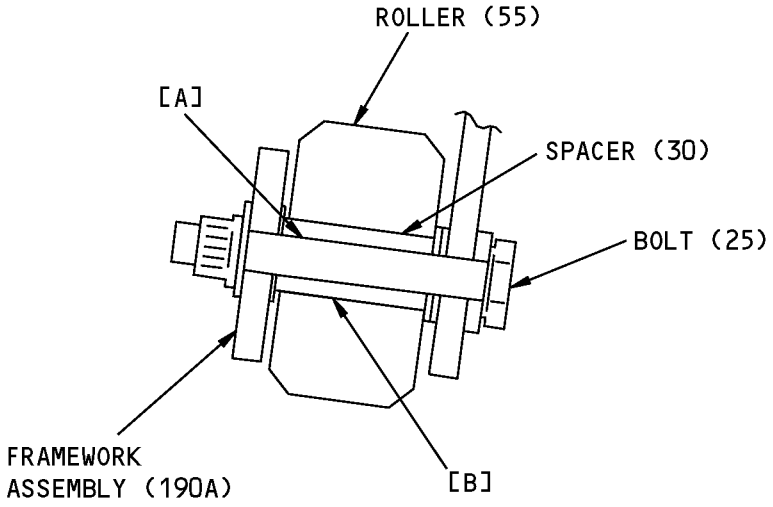
Forward Airstair Door Assembly
Figure 701 (Sheet 2 of 2)





A–A

Fits and Clearances
Figure 801 (Sheet 1 of 2)

REF LETTER	REF IPL FIG. 1, MATING ITEM NO.	DESIGN DIMENSION*				SERVICE WEAR LIMIT*		
		DIMENSION		ASSEMBLY CLEARANCE		DIMENSION		MAXIMUM CLEARANCE
		MIN	MAX	MIN	MAX	MIN	MAX	
[A]	ID 30	0.1940	0.2340	0.0045	0.0455	--	--	--
	OD 25	0.1885	0.1895					
[B]	ID 55	0.3320	0.3360	0.0100	0.0340	0.2940	0.3440	0.0500
	OD 30	0.3020	0.3220					

* ALL DIMENSIONS ARE IN INCHES

Fits and Clearances
Figure 801 (Sheet 2 of 2)

REF IPL		NAME	TORQUE*	
FIG. NO.	ITEM NO.		POUND-INCHES	POUND-FEET
1	5	Nut	20-40	
1	85	Nut	25-35	
1	90	Nut	20-40	

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

Torque Table
Figure 802

SPECIAL TOOLS, FIXTURES, AND EQUIPMENT

1. General

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

NOTE: Equivalent substitutes may be used.

Special Tools

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

Tool Supplier Information

CAGE Code	Supplier Name	Supplier Address
81205	THE BOEING COMPANY	17930 INTERNATIONAL BLVD. SOUTH SEATAC, WA 98188-4321 Telephone: 206-662-6650 Facsimile: 206-662-7145

ILLUSTRATED PARTS LIST

1. Introduction

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

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

1 2 3 4 5 6 7

. Assembly

. Attaching parts for assembly

. . Detail parts for assembly

. . Subassembly

. . Attaching parts for subassembly

. . . Detail parts for subassembly

. . . Sub-subassembly

. . . Attaching parts for subassembly

. . . . . Details parts for sub-subassembly

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

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

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

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

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

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

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

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

H. Interchangeable Parts

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

VENDOR CODES

Code	Name
07484	ACCURATE BUSHING CO INC 443 NORTH AVENUE GARWOOD, NEW JERSEY 07027-1014 FORMERLY V83132 SMITH BRG DIV OF ACCURATE BUSHING CO
11815	CHERRY AEROSPACE FASTENERS DIV OF TEXTRON 1224 EAST WARNER AVENUE PO BOX 2157 SANTA ANA, CALIFORNIA 92707-0157 FORMERLY IN LOS ANGELES, CALIF , FORMERLY CHERRY FASTENERS TOWNSEND DIV OF TEXTRON INC V71087
11960	KIRKHILL - TA HANKON DIV 336 WEIR ST P. O. BOX 1091 TAUNTON, MASSACHUSETTS 02780 FORMERLY HERCULES INC & HAVEG & BURKE INC HASKON DIV
15653	ALCOA GLOBAL FASTENERS INC DIV KAYNAR PRODUCTS 800 S STATE COLLEGE BLVD FULLERTON, CALIFORNIA 92831-3001 FORMERLY VK6405 MICRODOT AEROSP LTD; FORMERLY KAYNAR TECH FORMERLY FAIRCHILD FASTENERS KAYNAR DIV
52828	REPUBLIC FASTENER MFG CORP 1300 RANCHO CONEJO BLVD NEWBURY PARK, CALIFORNIA 91320-1405 FORMERLY IN SYLMAR, CALIFORNIA

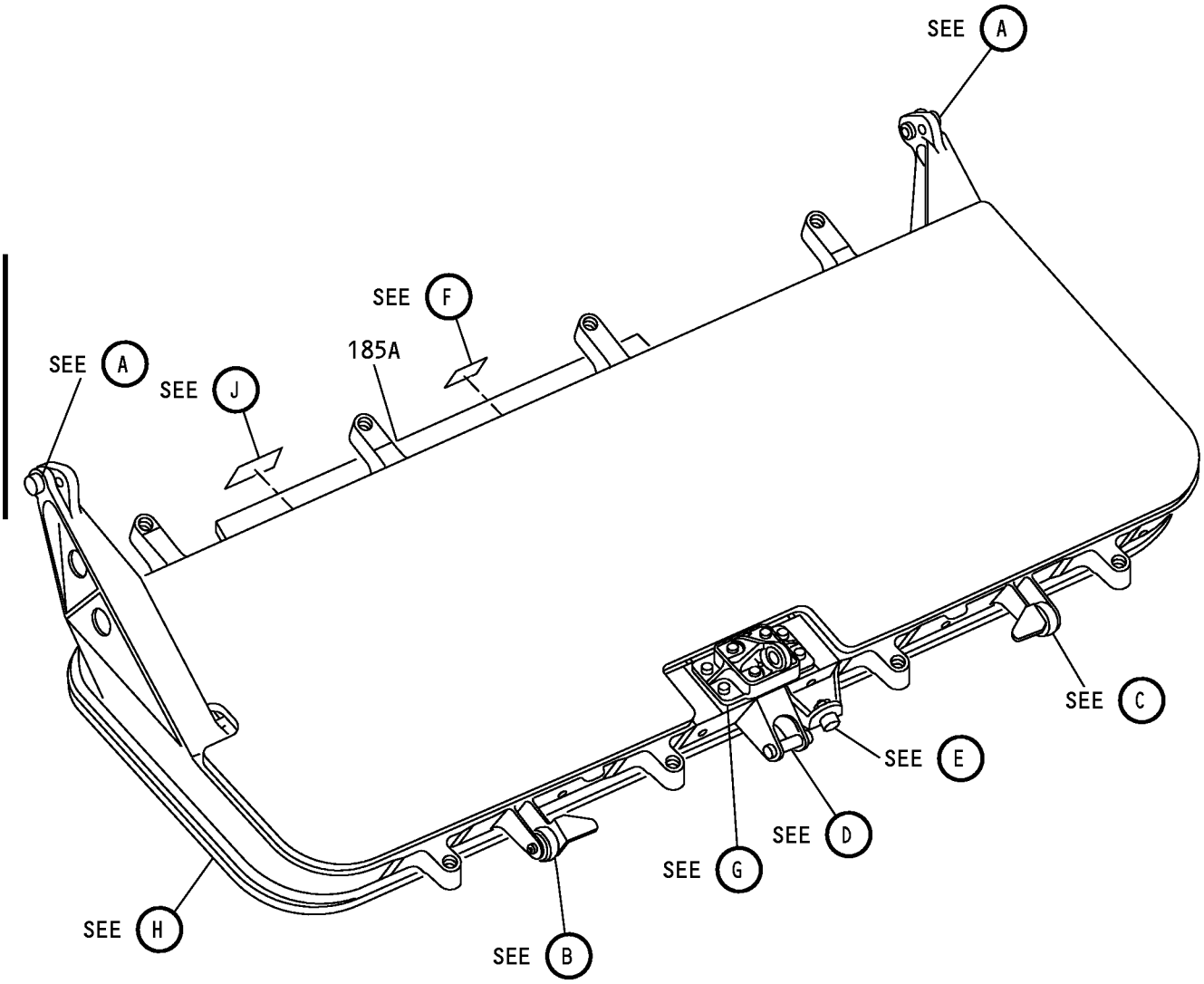
Code	Name
53551	ALLFAST FASTENING SYSTEMS INC 15200 EAST DON JULIAN ROAD PO BOX 3166 CITY OF INDUSTRY, CALIFORNIA 91745-1001 FORMERLY V0736B FORMERLY ALLFAST INC V5K545
60380	TORRINGTON CO BEARINGS DIV SUBSIDIARY OF INGERSOLL-RAND CORP 59 FIELD STREET PO BOX 1008 TORRINGTON, CONNECTICUT 06790-1008 FORMERLY TORRINGTON BEARING COMPANY
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
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
92563	MCGILL MFG CO INC BEARINGS DIV 909 LAFAYETTE STREET VALPARAISO, INDIANA 46383-4210
98996	OLYMPIC FASTENING SYSTEMS INC DOWNEY, CALIFORNIA 90241-4986 OBSOLETE RECORD
F0224	SIMMONDS SA FAIRCHILD FASTENERS ST COSME ST COSME EN VAIRAIS F-72580, FRANCE

NUMERICAL INDEX

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
10-60476-12		1	185A	1
102A9201-3		1	220	4
141A6402-2		1	1B	RF
141A6402-3		1	1C	RF
141A6402-4		1	1D	RF
141A6405-1		1	190B	1
141A6405-2		1	190E	1
141A6406-1		1	225B	1
141A6410-2		1	210	14
141A6410-3		1	205	8
141A6410-4		1	190A	1
141A6410-5		1	190D	1
141A6410-6		1	190F	1
141A6410-7		1	210A	14
141A6410-8		1	205A	8
141A6411-2		1	225A	1
141A6411-3		1	225C	1
141A6413-1		1	165	1
141A6413-2		1	175	14
141A6413-3		1	170	8
141A6413-4		1	165A	1
141A6413-5		1	175A	14
141A6413-6		1	170A	8
141A6413-7		1	165B	1
141A6415-1		1	160	1
141A6416-1		1	176	1
141A6417-1		1	180	1
141A6417-2		1	180A	1
411A4907-25		1	180B	1
65-32166-10		1	130	1
65-32166-11		1	140	1
66-12688-11		1	200	8
66-19165-3		1	195	2
66-20342-1		1	55	2

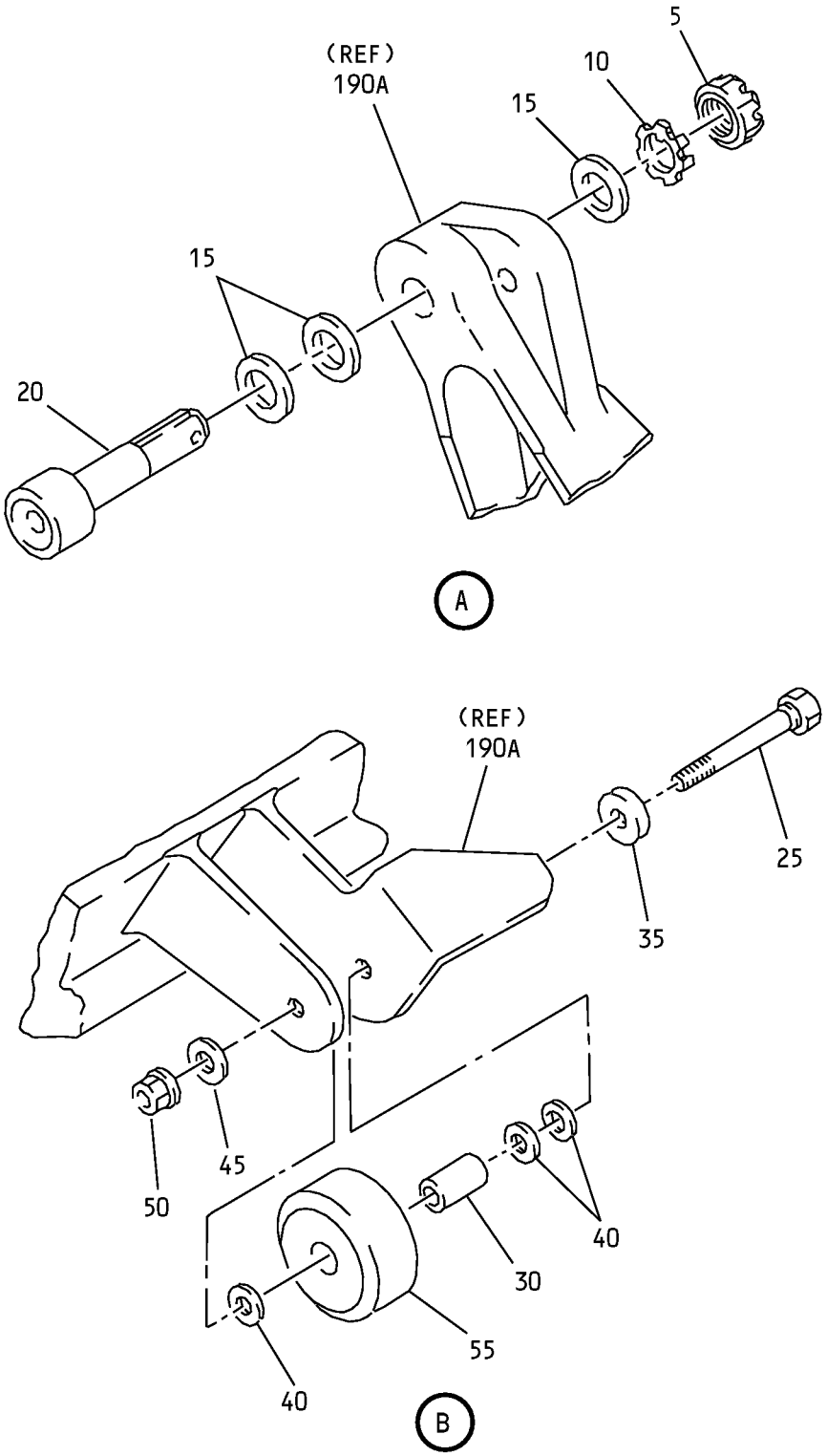
PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
69-78575-3		1	145	1
69-78575-4		1	155	1
9539		1	185A	1
AF5141-3C		1	215A	8
BAC27DBY191		1	235	1
BACB10FK5K13HS		1	20	2
BACB10FK5K5HS		1	110	1
BACB30NM3K17		1	25	2
BACB30NM3K4		1	120A	4
BACB30NM3K8		1	115	4
BACB30NR5DK25		1	60	1
BACN10JD105AU		1	5	2
		1	90	1
BACN10JD5CD		1	85	1
BACN10JR3CD		1	220	4
BACN10YR3CD		1	50	2
BACP18BC02A06P		1	57	1
BACR15DR3AC		1	215A	8
BACW10BN3AC		1	35	2
BACW10BN5AC		1	70	1
BACW10BP3CD		1	125	8
BACW10BP5CD		1	100	1
BR2000C3D		1	220	4
CCR264CS3C		1	215A	8
CHR3CTKR13		1	20	2
CHRS3CTKR13		1	20	2
CHRS3CTKR5		1	110	1
		1	110	1
HRSC3CTKR13		1	20	2
HRSC3CTKR5		1	110	1
K51601-3BAC		1	220	4
MS14107-7		1	135A	1
MS21209F1-20P		1	150	4
MS27111-2		1	10	2
		1	95	1

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
MS27253F1		1	230	1
NAS1149D0316J		1	40	6
NAS1149D0332J		1	45	2
NAS1149D0532H		1	15	6
		1	105	1
NAS1149D0532J		1	75	2
NAS1149D0563J		1	80	1
NAS43DD3-45FC		1	30	2
NAS43DD5-72FC		1	65	1
NS202439-02		1	220	4
PLH53CD		1	50	2
		1	50	2
RV541A3C		1	215A	8

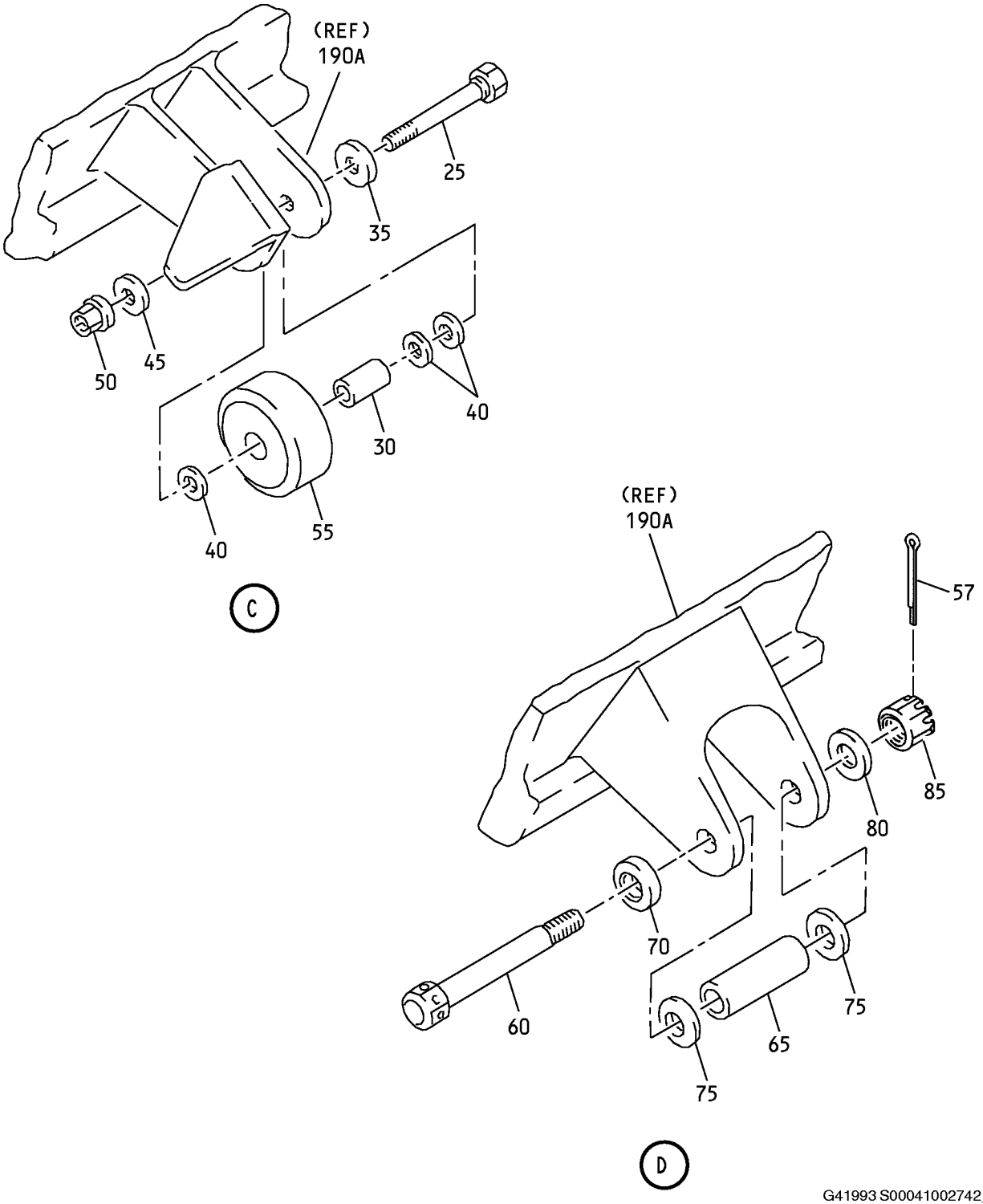


G41928 S00041002740_V2

Forward Airstair Door Assembly
IPL Figure 1 (Sheet 1 of 6)

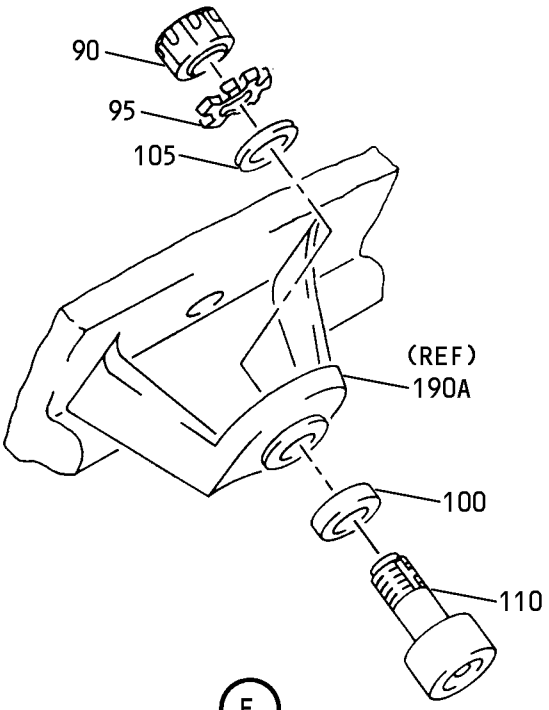


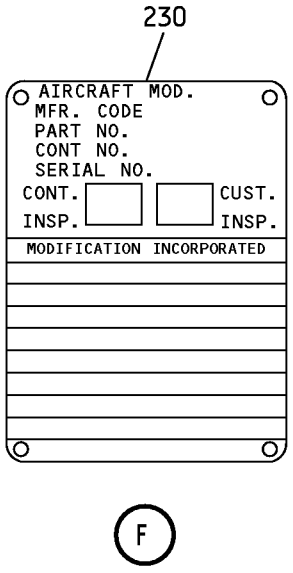
Forward Airstair Door Assembly
IPL Figure 1 (Sheet 2 of 6)

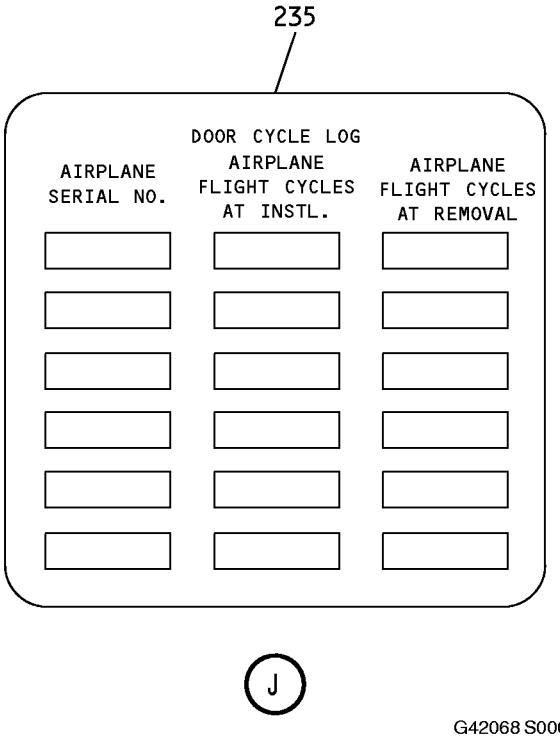


G41993 S00041002742_V2

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

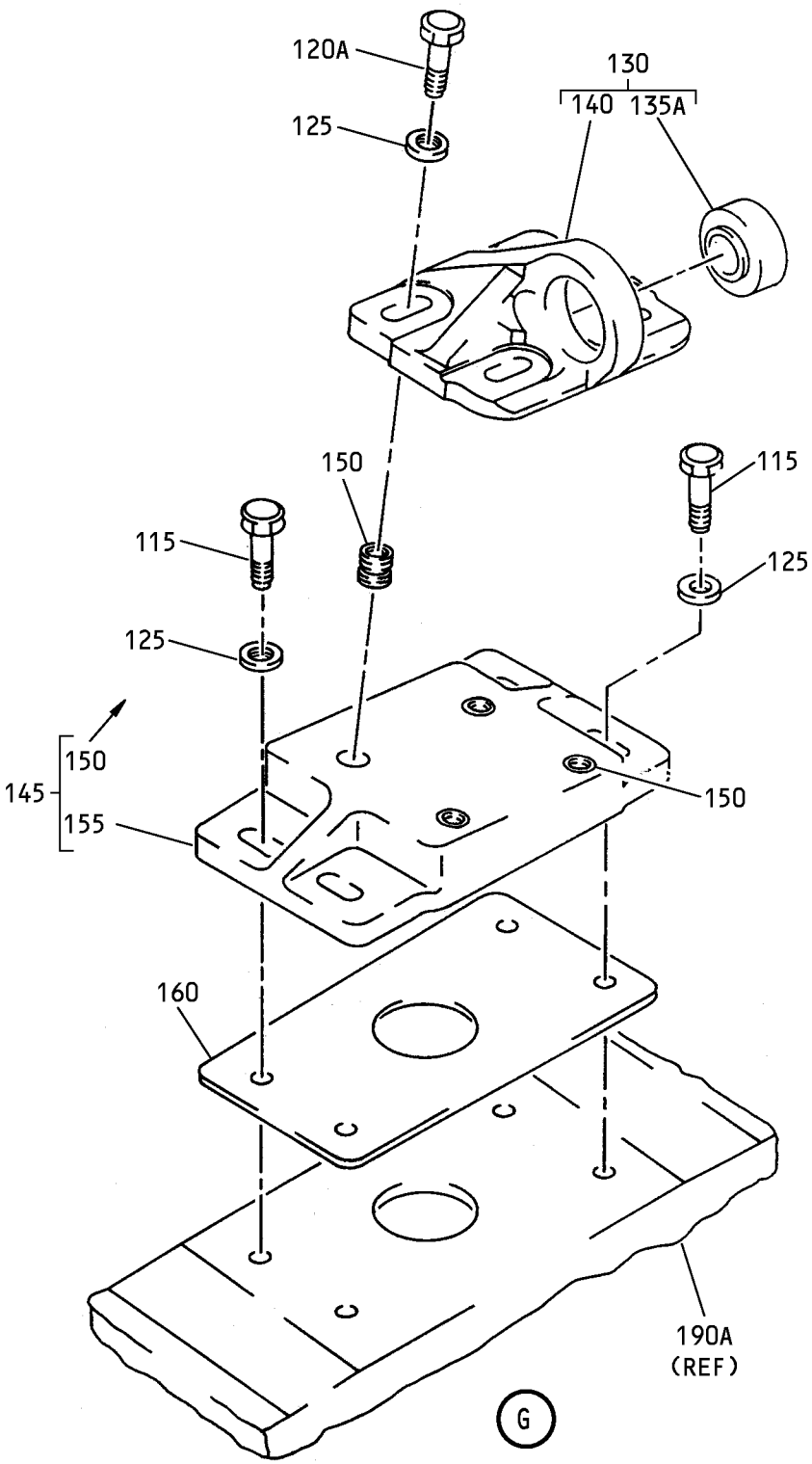






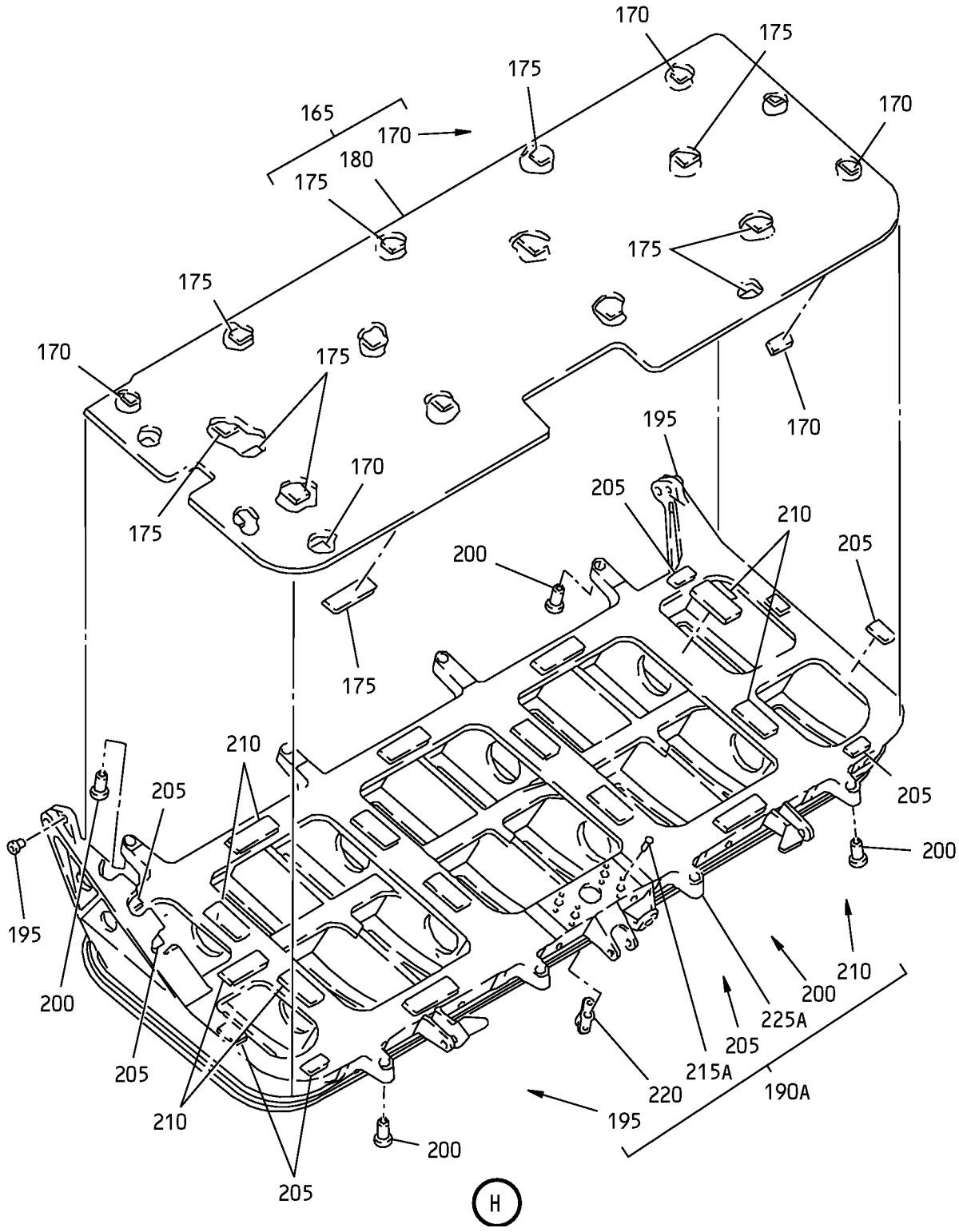
G42068 S00041002743_V2

Forward Airstair Door Assembly
IPL Figure 1 (Sheet 4 of 6)



G42071 S00041002744_V2

Forward Airstair Door Assembly
IPL Figure 1 (Sheet 5 of 6)



Forward Airstair Door Assembly
IPL Figure 1 (Sheet 6 of 6)

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
–1A	141A6402-1		DELETED		
–1B	141A6402-2		DOOR ASSY-FWD AIR STAIR	A	RF
–1C	141A6402-3		DOOR ASSY-FWD AIR STAIR	B	RF
–1D	141A6402-4		DOOR ASSY-FWD AIR STAIR	C	RF
5	BACN10JD105AU		. NUT		2
10	MS27111-2		. WASHER		2
15	NAS1149D0532H		. WASHER		6
20	HRSC3CTKR13		. FOLLOWER (V60380) (SPEC BACB10FK5K13HS) (OPT CHRS3CTKR13 (V92563)) (OPT CHR3CTKR13 (V07484))		2
25	BACB30NM3K17		. BOLT		2
30	NAS43DD3-45FC		. SPACER		2
35	BACW10BN3AC		. WASHER		2
40	NAS1149D0316J		. WASHER		6
45	NAS1149D0332J		. WASHER		2
50	PLH53CD		. NUT (VF0224) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))		2
55	66-20342-1		. ROLLER		2
57	BACP18BC02A06P		. PIN-COTTER		1
60	BACB30NR5DK25		. BOLT		1
65	NAS43DD5-72FC		. SPACER		1
70	BACW10BN5AC		. WASHER		1
75	NAS1149D0532J		. WASHER		2
80	NAS1149D0563J		. WASHER		1
85	BACN10JD5CD		. NUT		1
90	BACN10JD105AU		. NUT		1
95	MS27111-2		. WASHER		1
100	BACW10BP5CD		. WASHER		1

–Item not Illustrated

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
105	NAS1149D0532H		. WASHER		1
110	HRSC3CTKR5		. FOLLOWER (V60380) (SPEC BACB10FK5K5HS) (OPT CHRS3CTKR5 (V92563)) (OPT CHRS3CTKR5 (V07484))		1
115	BACB30NM3K8		. BOLT		4
120	BACB30NM3K6		DELETED		
120A	BACB30NM3K4		. BOLT		4
125	BACW10BP3CD		. WASHER		8
130	65-32166-10		. FITTING ASSY-GUIDE		1
135	10-60545-114SA		DELETED		
135A	MS14107-7		. . BEARING		1
140	65-32166-11		. . FITTING		1
145	69-78575-3		. FITTING ASSY-SPRT		1
150	MS21209F1-20P		. . INSERT		4
155	69-78575-4		. . FITTING		1
160	141A6415-1		. PLATE-SERRATED		1
165	141A6413-1		. INSULATION ASSY-PNL	A	1
–165A	141A6413-4		. INSULATION ASSY-PNL	B	1
–165B	141A6413-7		. INSULATION ASSY-PNL	C	1
170	141A6413-3		. . FASTENER-HOOK	A	8
–170A	141A6413-6		. . FASTENER-HOOK	B, C	8
175	141A6413-2		. . FASTENER-HOOK	A	14
–175A	141A6413-5		. . FASTENER-HOOK	B, C	14
–176	141A6416-1		. . SKIN		1
180	141A6417-1		. . PANEL	A	1
–180A	141A6417-2		. . PANEL	B	1
–180B	411A4907-25		. . PANEL	C	1
185	10-60476-12		DELETED		
185A	9539		. SEAL-DOOR (V11960) (SPEC 10-60476-12)		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–					
190	141A6410-1		DELETED		
190A	141A6410-4		. FRAMEWORK ASSY (OPT ITEM 190B, 190D)	A	1
–190B	141A6405-1		. FRAMEWORK ASSY (OPT ITEM 190A, 190D)	A	1
–190C	141A6405-5		DELETED		
–190D	141A6410-5		. FRAMEWORK ASSY (OPT ITEM 190A, 190B)	A	1
–190E	141A6405-2		. FRAMEWORK ASSY (OPT ITEM 190F)	B, C	1
–190F	141A6410-6		. FRAMEWORK ASSY (OPT ITEM 190E)	B, C	1
195	66-19165-3		. . BUSHING		2
200	66-12688-11		. . BUSHING		8
205	141A6410-3		. . FASTENER-LOOP	A	8
–205A	141A6410-8		. . FASTENER-LOOP	B, C	8
210	141A6410-2		. . FASTENER-LOOP	A	14
–210A	141A6410-7		. . FASTENER-LOOP	B, C	14
215	BACR15BA3AD		DELETED		
215A	AF5141-3C		. . RIVET (V53551) (SPEC BACR15DR3AC) (OPT CCR264CS3C (V11815)) (OPT RV541A3C (V98996)) (SIZE DETERMINED ON INST)		8
220	BR2000C3D		. . NUTPLATE (V52828) (SPEC BACN10JR3CD) (OPT K51601-3BAC (V15653)) (OPT NS202439-02 (V80539)) (OPT 102A9201-3 (V72962))		4
225	141A6411-1		DELETED		
225A	141A6411-2		. . FRAMEWORK (USED ON ITEM 190A)	A	1
–225B	141A6406-1		. . FRAMEWORK (USED ON ITEMS 190B, 190E)		1
–225C	141A6411-3		. . FRAMEWORK (USED ON ITEMS 190D, 190F)		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–					
230	MS27253F1		. PLATE		1
235	BAC27DBY191		. MARKER-ALUMINUM FOIL	A	1

–Item not Illustrated