COMPONENT MAINTENANCE MANUAL WITH ILLUSTRATED PARTS LIST

INBOARD LEADING EDGE WING SEAL DOOR ASSEMBLY

PART NUMBER 65C26770–10SP, –13SP, –14SP, –17SP, –18SP, –19SP, –20SP, –21SP, –22SP, –23SP, –24SP, –25SP, –26SP, –27SP, –28SP, –29SP, –30SP, –3SP, –4SP, –5SP,

BOEING PROPRIETARY, CONFIDENTIAL, AND/OR TRADE SECRET
Copyright © 1995 The Boeing Company
Unpublished Work - All Rights Reserved

Boeing claims copyright in each page of this document only to the extent that the page contains copyrightable subject matter. Boeing also claims copyright in this document as a compilation and/or collective work.

This document includes proprietary information owned by The Boeing Company and/or one or more third parties. Treatment of the document and the information it contains is governed by contract with Boeing. For more information, contact The Boeing Company, P.O. Box 3707, Seattle, Washington 98124.

Boeing, the Boeing signature, the Boeing symbol, 707, 717, 727, 737, 747, 757, 767, 777, 787, Dreamliner, BBJ, DC-8, DC-9, DC-10, KC-10, KDC-10, MD-10, MD-11, MD-80, MD-88, MD-90, P-8A, Poseidon and the Boeing livery are all trademarks owned by The Boeing Company; and no trademark license is granted in connection with this document unless provided in writing by Boeing.

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

PART NUMBER (Cont.)

65C26770–6SP, –7SP, –8SP, –9SP

COMPONENT MAINTENANCE MANUAL

Revision No. 8
Jul 01/2009

To: All holders of INBOARD LEADING EDGE WING SEAL DOOR ASSEMBLY 57-56-23.

Attached is the current revision to this COMPONENT MAINTENANCE MANUAL

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

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

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

ATTENTION

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

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details

Location of Change	Description of Change
	NO HIGHLIGHTS

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details

BOEING®

COMPONENT MAINTENANCE MANUAL

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

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details

TABLE OF CONTENTS

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details

BOEING

COMPONENT MAINTENANCE MANUAL

TEMPORARY REVISION AND SERVICE BULLETIN RECORD

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVE	DATE OF INCORPORATION INTO MANUAL
		737-SL-57-27	JUL 01/04

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details

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

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

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details

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

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details

BOEING®

COMPONENT MAINTENANCE MANUAL

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

Temporary Revision		Inserted		Removed	
Number	Date	Date	Initials	Date	Initials

Temporary Revision		Inserted		Removed	
Date	Initials	Number	Date	Date	Initials

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details

Temporary Revision		Inserted		Removed	
Number	Date	Date	Initials	Date	Initials

Temporary Revision		Inserted		Removed	
Date	Initials	Number	Date	Date	Initials

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details

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.

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details

SEAL DOOR ASSEMBLY - DESCRIPTION AND OPERATION

1. **Description**

   A. The seal door assembly is a movable panel made from a machined cast aluminum flap.

2. **Operation**

   A. The seal door assembly is a movable panel assembly. In the extended position the seal door assembly aerodynamically seals the gap between the engine strut and the engine nacelle.

3. **Leading Particulars (approximate)**

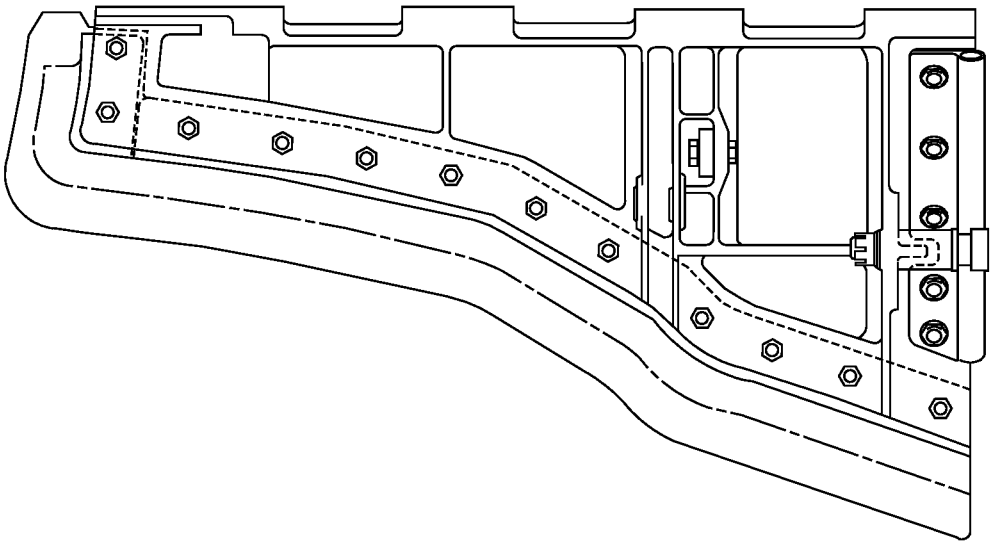
   A. Length – 15 inches

   B. Width – 7 inches

   C. Height – 2 inches

   D. Weight – 20 pounds

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details



Seal Door Assembly
Figure 1

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details

COMPONENT MAINTENANCE MANUAL

TESTING AND FAULT ISOLATION

(NOT APPLICABLE)

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details

(NOT APPLICABLE)

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details

(NOT APPLICABLE)

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details

CHECK

1. General

A. This procedure has the data necessary to check the seal door assembly.

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

C. Refer to the IPL Figure 1 and IPL Figure 2 for the item numbers.

2. Seal Door Assembly Check

A. References

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

B. Procedure

(1) Do a visual check:

(a) Use standard industry procedures to examine all of the parts for defects.

(b) Seals must not be worn or damaged.

(2) Do the penetrant check if cracks or damage are seen or if you think there are cracks or damage:

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

1) Seal Door (135, IPL Figure 1; 125, IPL Figure 2)

3. Seal Retainer Interference Check

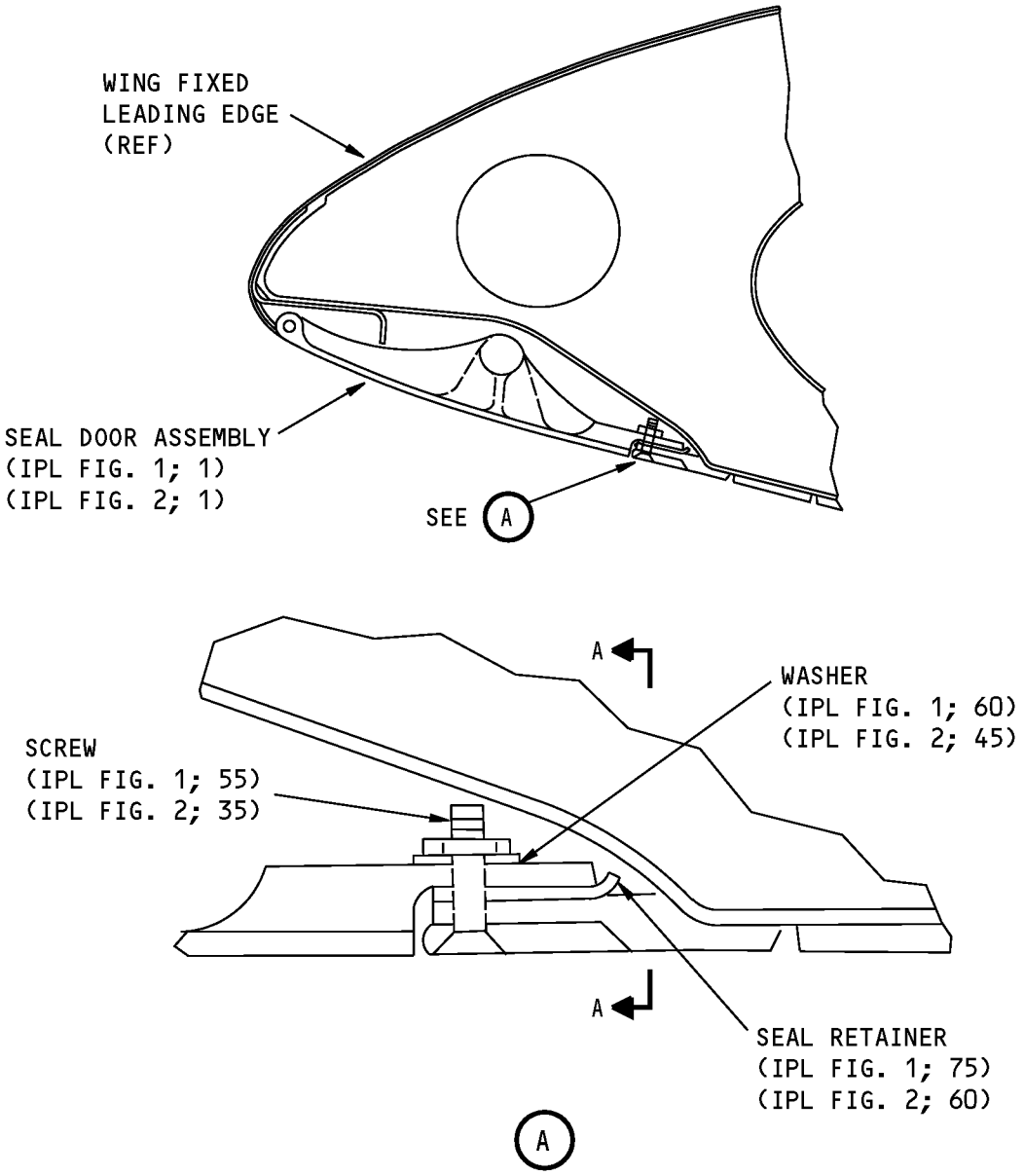
A. Procedure

(1) Reference Service Letter 737-SL-57-27.

(a) Do a visual check of the seal retainer (IPL Figure 1; 75) (IPL Figure 2; 60) as shown in CHECK, Figure 501.

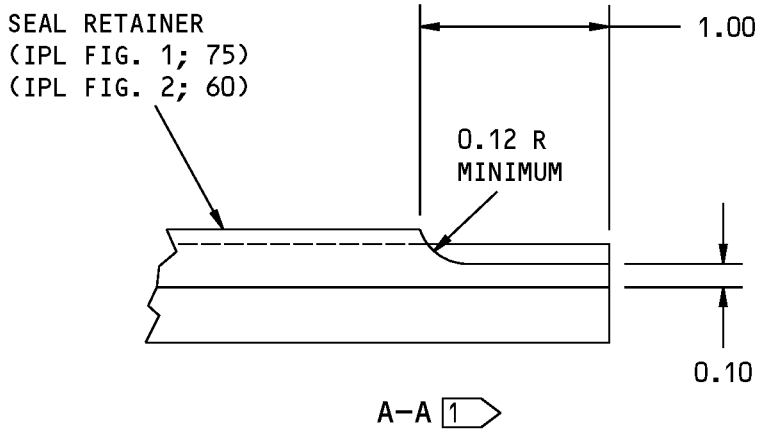
NOTE: Seal retainer (IPL Figure 2; 60B,60C) is the updated design.

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details



Seal Retainer Interference Check
Figure 501 (Sheet 1 of 2)

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details



1 REFERENCE SERVICE LETTER
737-SL-57-27
REFINISH THE REWORKED AREA:
APPLY CHEMICAL COATING (F-17.10).
APPLY BMS 10-79, TYPE II PRIMER
AND BMS 10-60, TYPE II ENAMEL
(F-19.40)

ALL DIMENSIONS ARE IN INCHES

Seal Retainer Interference Check
Figure 501 (Sheet 2 of 2)

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details

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
65C26771	SEAL DOOR ASSY	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.

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details

—	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 WHICH 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
TIR	TOTAL INDICATOR READING

EXAMPLES

[— 0.002]	STRAIGHT WITHIN 0.002
[⊥ 0.002 B]	PERPENDICULAR TO B WITHIN 0.002
[// 0.002 A]	PARALLEL TO 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 PLANE A
[⌓ 0.020 A]	SURFACES MUST LIE WITHIN PARALLEL BOUNDARIES 0.02 INCH APART AND EQUALLY DISPOSED ABOUT TRUE PROFILE
[◎ Ø 0.0005 C]	CONCENTRIC TO C WITHIN 0.0005 DIAMETER
[⌯ 0.010 A]	SYMMETRICAL WITH A WITHIN 0.010
[∠ 0.005 A]	ANGULAR TOLERANCE 0.005 WITH 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, AND EXTENDING 0.510-INCH ABOVE, DATUM A, MAXIMUM MATERIAL CONDITION
[2.000] OR 2.000 BSC	THEORETICALLY EXACT DIMENSION IS 2.000

NOTE: DATUM MAY APPEAR AT EITHER SIDE OF TOLERANCE FRAME [0.020 A] [A 0.020]

True Position Dimensioning Symbols
Figure 601

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details

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 Practices Manual (SOPM) for the SOPM subjects identified in this procedure.

C. Refer to the IPL Figure 1 and IPL Figure 2 for the item numbers.

2. Refinish of Other Parts

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
C00033	Coating - Exterior Protective Enamel, Flexibility Use	BMS10-60, Type II
C00319	Primer - Urethane Compatible, Corrosion Resistant	BMS10-79, Type II

B. References

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

C. Procedure

NOTE: For stippping 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) Instructions for the repair of the parts listed in REPAIR 1-1, Table 601 are for repair of the original finish.

Table 601: Refinish Details

IPL FIG & ITEM	MATERIAL	FINISH
Retainer (70,75, IPL Fig. 1) (55,60, IPL Fig. 2)	2024-T42-AL Alloy	Apply alodine (F-17.07) to the retainer. Apply primer, C00319 and enamel coating, C00033 (F-19.40) to the retainer.
Retainer (105,105B, IPL Fig. 1)	7075-T73 AL Alloy	Apply alodine (F-17.07) to the retainer. Apply primer, C00319 and enamel coating, C00033 (F-14.9846-707) to the retainer.
Retainer (105A,105C, IPL Fig. 1)	2024-T42 AL Alloy	Apply alodine (F-17.07) to the retainer. Apply primer, C00319 and enamel coating, C00033 (F-14.9846-707) to the retainer.

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details

SEAL DOOR ASSEMBLY - REPAIR 2-1

65C26771–1, –2, –7, –8, –11, –12, –17, –18, –31, –32, –35, –36, –39, –40

1. General

A. This procedure has the data necessary to repair the seal door assembly (115, IPL Figure 1; 105, IPL Figure 2).

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

C. Refer to REPAIR-GENERAL, Figure 601 shown in the repair.

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

2. Seal Door Assembly Bushing Replacement

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

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

B. References

Reference	Title
SOPM 20-50-03	BEARING AND BUSHING REPLACEMENT
SOPM 20-50-19	GENERAL SEALING
SOPM 20-60-04	MISCELLANEOUS MATERIALS

C. Procedure

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

(1) Remove the bushing (120, 125, 130, IPL Figure 1; 110, 115, 120, IPL Figure 2) from the seal door (135, IPL Figure 1; 125, IPL Figure 2) as specified in the SOPM 20-50-03.

(2) Apply sealant, A00247 to the inside of the seal door lug hole as shown in REPAIR 2-1, Figure 601.

(3) Install the bushing (120, 125, 130, IPL Figure 1; 110, 115, 120, IPL Figure 2) with sealant, A00247 in the seal door (135, IPL Figure 1; 125, IPL Figure 2) as specified in the SOPM 20-50-03.

(4) Machine the bushing (120, 125, 130, IPL Figure 1; 110, 115, 120, IPL Figure 2) inner diameter to the dimensions specified in REPAIR 2-1, Figure 601.

(5) Break all sharp edges.

(6) Apply a fillet seal all around the bushing (120, 125, 130, IPL Figure 1; 110, 115, 120, IPL Figure 2) flange with sealant, A00247 as specified in SOPM 20-50-19.

3. Seal Door Assembly Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details

Reference	Description	Specification
C00032	Coating - Exterior Protective Enamel, General Use	BMS10-60, Type I

B. References

Reference	Title
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS

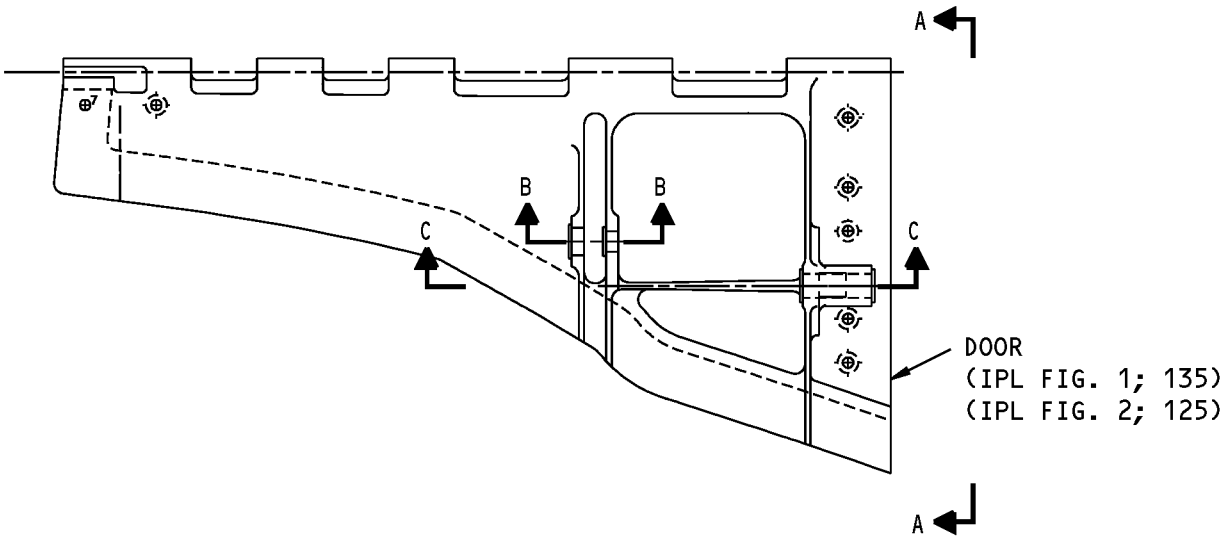
C. Procedure

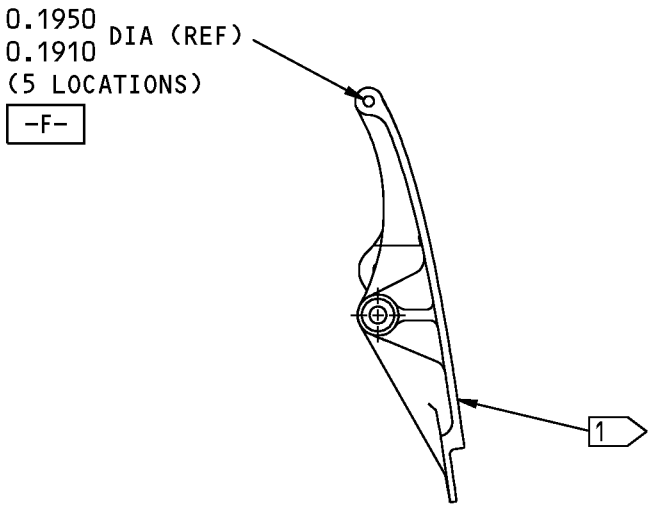
NOTE: For decoding table for Boeing finish codes, refer to SOPM 20-41-01. For finishing materials, refer to SOPM 20-60-02.

(1) Apply enamel coating, C00032 (F-14.9813) to the interior side of the seal door assembly (115, IPL Figure 1; 105, IPL Figure 2).

(a) Do not apply the enamel coating, C00032 in the bushing holes as shown in REPAIR 2-1, Figure 601.

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details

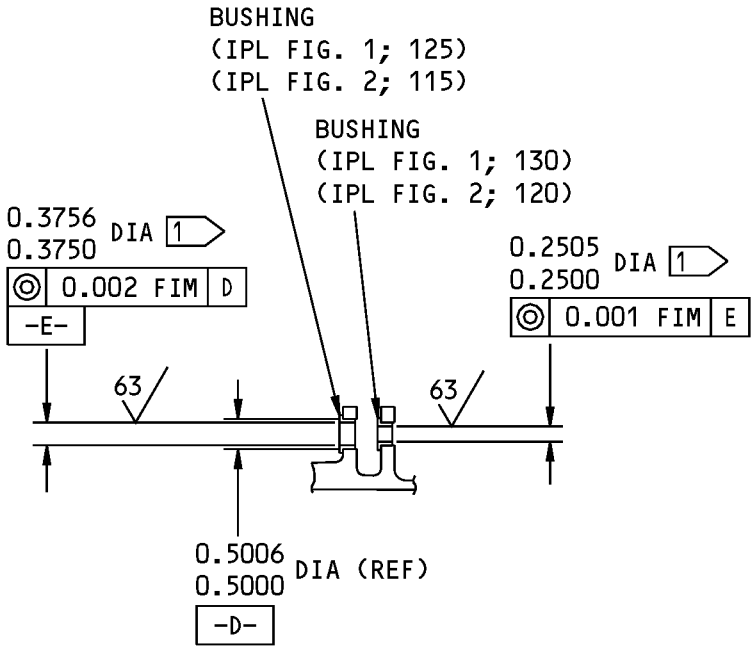




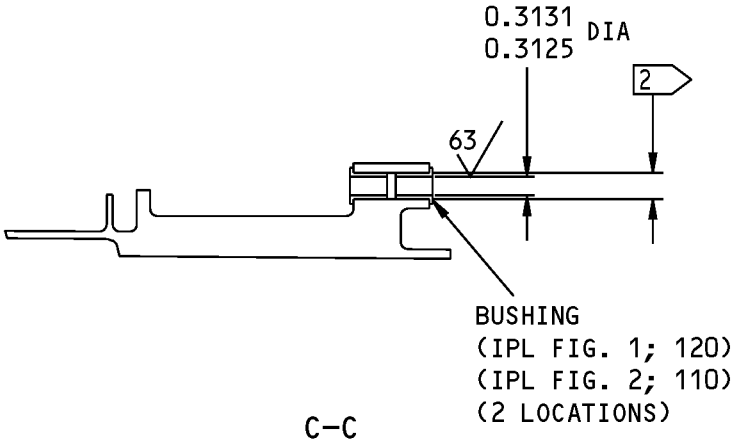
A–A

65C26771-1,-2,-7,-8,-11,-12,-17,-18,-31,-32,-35,-36,-39,-40 Seal Door Assembly Bushing Replacement and Refinish
Figure 601 (Sheet 1 of 2)

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details



B–B



C–C

1 DO NOT APPLY ENAMEL TO THIS AREA OR SURFACE

2 APPLY BMS 5-95 SEALANT TO THE INSIDE OF LUG HOLE

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

ALL DIMENSIONS ARE IN INCHES

65C26771-1,-2,-7,-8,-11,-12,-17,-18,-31,-32,-35,-36,-39,-40 Seal Door Assembly Bushing Replacement and Refinish
Figure 601 (Sheet 2 of 2)

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details

SEAL DOOR - REPAIR 2-2

65C26771 38–3, –4, –9, –10, –13, –14, –19, –20, –25, –26, –33, –34, –37, –41, –42

1. General

A. This procedure has the data necessary to refinish the seal door (135, IPL Figure 1; 125, IPL Figure 2).

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

C. Refer to REPAIR-GENERAL, Figure 601 shown in the repair.

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

E. General Repair Details:

(1) Seal Door Material: A356-T6 Al Alloy

2. Seal Door Refinish

A. Consumable Materials

NOTE: Equivalent substitutes may be used.

Reference	Description	Specification
A00214	Compound - Honeycomb Edge Filling & Potting, Epoxy Based, 2 Part RT Cure (20 Min Gel)	BMS5-28, Type 3
C00175	Primer - Urethane Compatible, Corrosion Resistant (Less Than 1% Aromatic Amines)	BMS10-79, Type III
C00319	Primer - Urethane Compatible, Corrosion Resistant	BMS10-79, Type II

B. References

Reference	Title
SOPM 20-30-02	STRIPPING OF PROTECTIVE FINISHES
SOPM 20-41-01	DECODING TABLE FOR BOEING FINISH CODES
SOPM 20-60-02	FINISHING MATERIALS
SOPM 20-60-04	MISCELLANEOUS MATERIALS

C. Procedure

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

(1) For seal door (135, 135A, 135B, 135C, IPL Figure 1):

(a) Apply a chromic acid anodize (F-17.05) to the seal door.

(b) Apply primer, C00175 (F-19.47) to the seal door.

1) Do not apply primer in the bushing holes as shown in REPAIR 2-2, Figure 601 .

(c) Fill pits, blemishes and porosity on the exterior surface of the seal door with compound, A00214.

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details

1) Sand the compound, A00214 smooth.

2) Apply primer, C00319 (F-19.46).

(2) For seal doors (125B, 125C, 125D, 125E, 125F, 125G, IPL Figure 2):

(a) Apply a chromic acid anodize (F-17.19) to the seal door.

(b) Apply primer, C00319 (F-19.47) to the seal door.

1) Do not apply primer, C00319 in the bushing holes as shown in REPAIR 2-2, Figure 601 .

(c) Fill pits, blemishes and porosity on the exterior surface of the seal door with compound, A00214.

1) Sand the compound, A00214 smooth.

2) Apply primer, C00319 (F-19.46).

(3) For seal doors (125H, 125J, 125K, 125L, IPL Figure 2):

(a) Apply a boric acid anodize (F-17.31) to the seal door.

(b) Apply primer, C00175 (F-19.47) to the seal door.

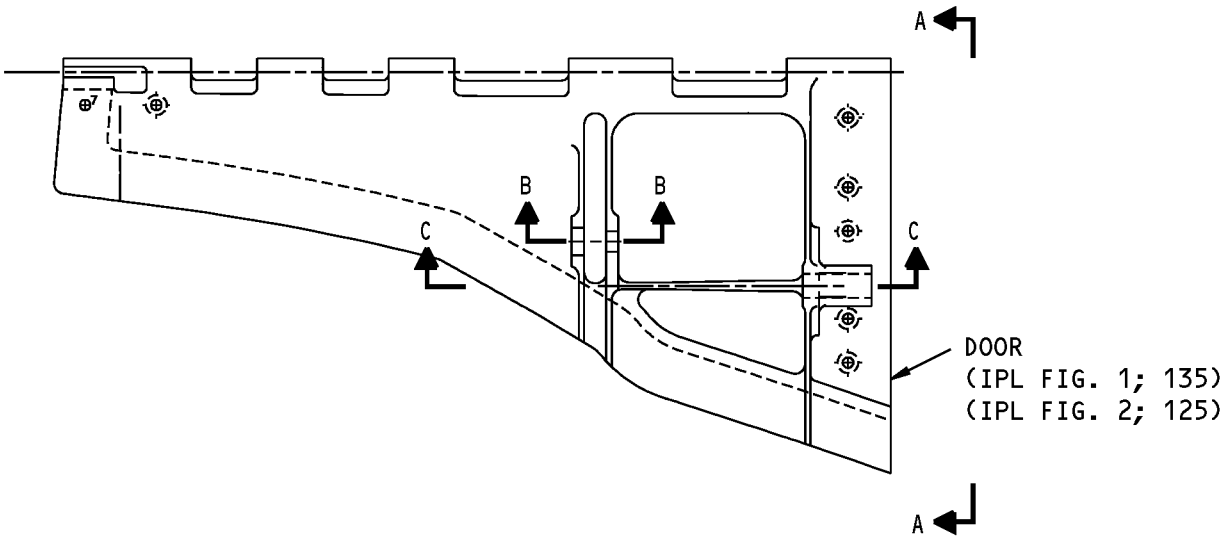
1) Do not apply primer, C00175 in the bushing holes as shown in REPAIR 2-2, Figure 601.

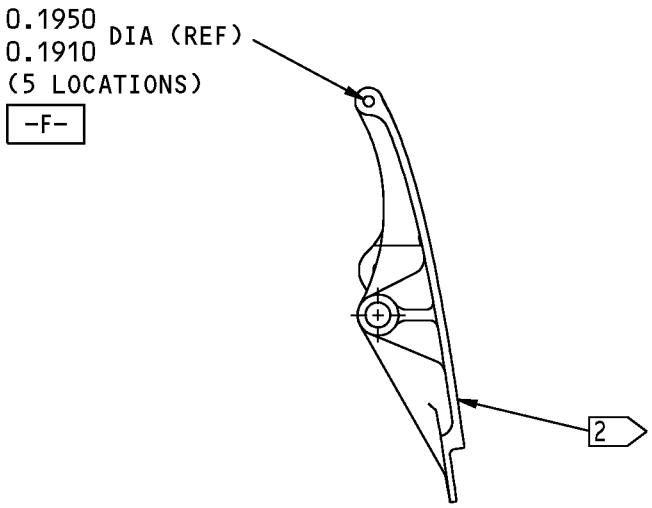
(c) Fill pits, blemishes and porosity on the exterior surface of the seal door with compound, A00214.

1) Sand the compound, A00214 smooth.

2) Apply primer, C00319 (F-19.46).

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details

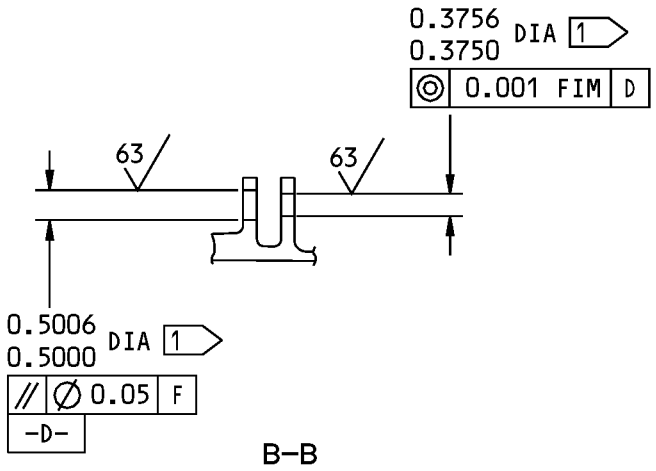




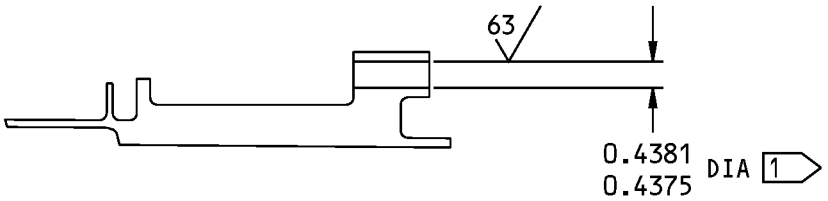
A–A

65C26771-3,-4,-9,-10,-13,-14,-19,-20,-25,-26,-33,-34,-37,-38,-41,-42 Seal Door Refinish
Figure 601 (Sheet 1 of 2)

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details



B–B



C–C

1 DO NOT APPLY PRIMER IN THE HOLES

2 APPLY BMS 5-28 TYPE 3 COMPOUND IF NECESSARY

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

ALL DIMENSIONS ARE IN INCHES

65C26771-3,-4,-9,-10,-13,-14,-19,-20,-25,-26,-33,-34,-37,-38,-41,-42 Seal Door Refinish
Figure 601 (Sheet 2 of 2)

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details

ASSEMBLY

1. General

A. This procedure has the data necessary to assemble the seal 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 and IPL Figure 2 for the item numbers

2. Seal Door Assembly

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 20-50-01	BOLT AND NUT INSTALLATION
SOPM 20-60-02	FINISHING MATERIALS

C. Procedure

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

(1) Install the bolt (35, IPL Figure 1), the washer (40, 45, IPL Figure 1) and the nut (50, IPL Figure 1)

(2) Torque the nut (50, IPL Figure 1) to 20-25 pound-inches.

(3) Install the cam follower (15, IPL Figure 1; 15, IPL Figure 2), the spacer (20, IPL Figure 1; 20A, IPL Figure 2), the washer (25, IPL Figure 1; 25, IPL Figure 2), and the nut (30, IPL Figure 1; 30, IPL Figure 2).

(4) Torque the nut (30, IPL Figure 1; 30, IPL Figure 2) to 60-85 pound-inches.

(5) Install the cotter pin (10, IPL Figure 1; 10, IPL Figure 2), through the nut (30, IPL Figure 1; 30, IPL Figure 2).

(6) Install the seal (110, IPL Figure 1; 100, IPL Figure 2), and the retainer (105, IPL Figure 1; 95, IPL Figure 2), with the bolt (90, IPL Figure 1; 80, IPL Figure 2), the washer (95, IPL Figure 1; 85, IPL Figure 2), and the nut (100, IPL Figure 1; 90, IPL Figure 2).

(a) Apply primer, C00259 (F-14.06) in the boltholes of the seal retainer.

(7) Torque the nut (100, IPL Figure 1; 90, IPL Figure 2) to 15-20 pound-inches.

(8) Apply primer, C00259 (F-14.06) in the boltholes of the seal retainer (70, 75, IPL Figure 1; 55, 60, IPL Figure 2).

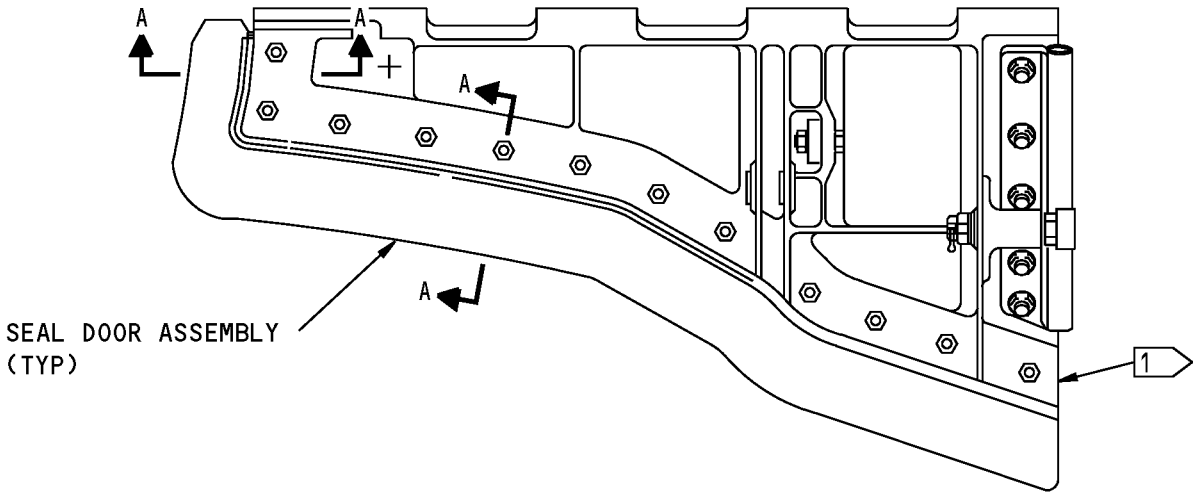
BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details

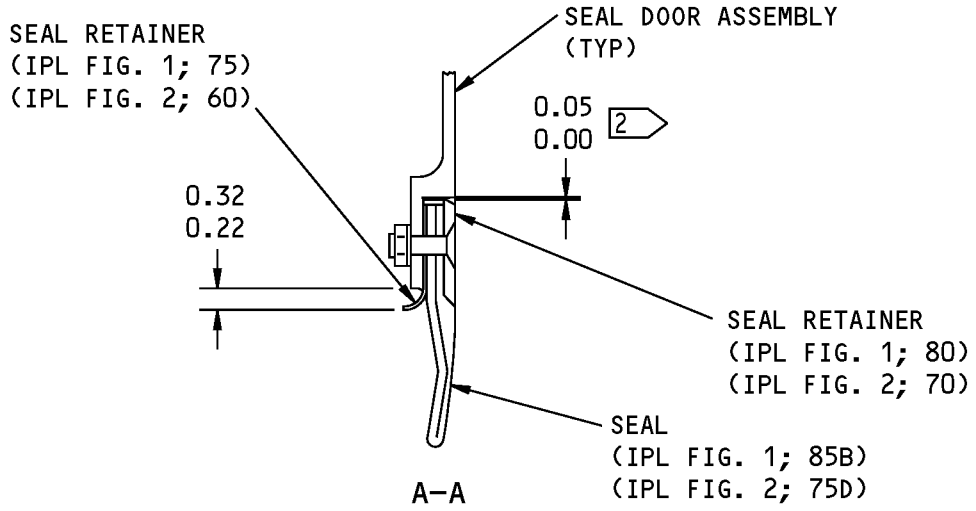
(9) Install the retainers (70, 75, IPL Figure 1; 55, 60, IPL Figure 2), the seal (85B, IPL Figure 1; 75D, IPL Figure 2), the seal (80, IPL Figure 1; 70, IPL Figure 2), and the rubstrip (65, IPL Figure 2) with the bolt (55, IPL Figure 1; 35, 40, IPL Figure 2), the washer (60, IPL Figure 1; 45, IPL Figure 2), and the nut (65, IPL Figure 1; 50A, IPL Figure 2), as specified in ASSEMBLY, Figure 701.

(a) Trim the seal (85B, IPL Figure 1; 75D, IPL Figure 2), the retainers (70, 75, IPL Figure 1; 55, 60, IPL Figure 2), as shown in ASSEMBLY, Figure 701.

(10) Torque the nut (65, IPL Figure 1; 50A, IPL Figure 2) to 15-20 pound-inches.

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details





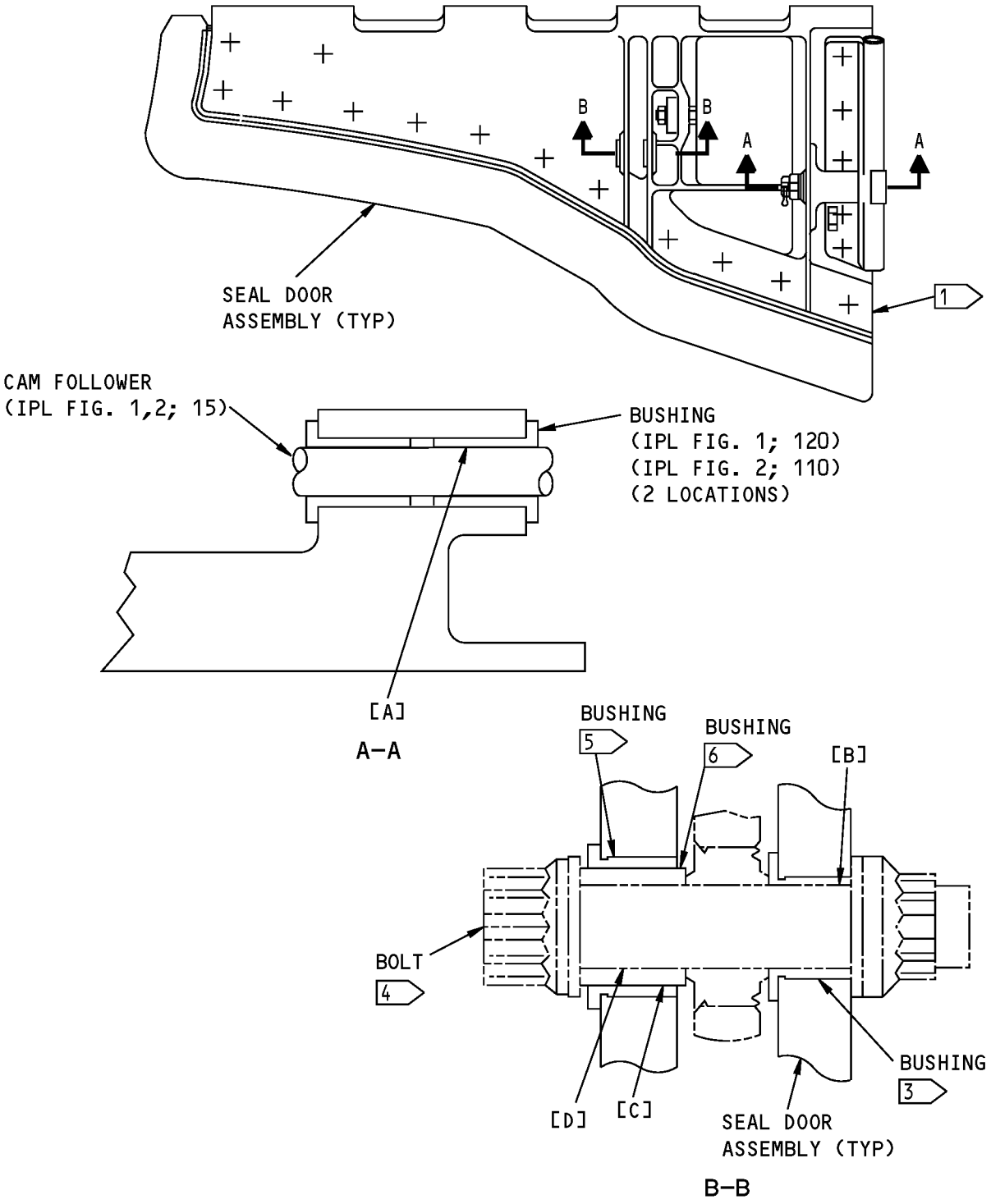
1 TRIM SEAL AND SEAL RETAINER TO ±0.03 INCHES OF THE DOOR EDGE

2 TRIM AS NEEDED

ALL DIMENSIONS ARE IN INCHES

65C26770 Seal Door Assembly
Figure 701

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details



Fits and Clearances
Figure 801 (Sheet 1 of 2)

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details

REF LETTER	REF IPL		DESIGN DIMENSION*				SERVICE WEAR LIMIT*		
	FIG. NO.	MATING ITEM NO.	DIMENSION		ASSEMBLY CLEARANCE		DIMENSION		MAXIMUM CLEARANCE
			MIN	MAX	MIN	MAX	MIN	MAX	
[A]		ID 1	0.3125	0.3131	0.0000	0.0021			
		OD 2	0.3110	0.3125					
[B]		ID 3	0.2500	0.2505	0.0005	0.0026			
		OD 4	0.2479	0.2495					
[C]		ID 5	0.3750	0.3756	0.0005	0.0016			
		OD 6	0.3740	0.3745					
[D]		ID 6	0.2500	0.2505	0.0005	0.0026			
		OD 4	0.2479	0.2495					

*ALL DIMENSIONS ARE IN INCHES

1 BUSHING
(IPL FIG. 1; 120),
(IPL FIG. 2; 110)

2 CAM FOLLOWER
(IPL FIG. 1; 15),
(IPL FIG. 2; 15)

3 BUSHING
(IPL FIG. 1; 130),
(IPL FIG. 2; 120)

4 BOLT, BACB30LJ4C16, USED ON
INSTALLATION 65C26753

5 BUSHING
(IPL FIG. 1; 125),
(IPL FIG. 2; 115)

6 BUSHING, BACB28AK04-038, USED ON
INSTALLATION 65C26753

Fits and Clearances
Figure 801 (Sheet 2 of 2)

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details

COMPONENT MAINTENANCE MANUAL

SPECIAL TOOLS, FIXTURES, AND EQUIPMENT

(NOT APPLICABLE)

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details

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

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details

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
07096	BURKE RUBBER CO PUROSIL DIV 1810 SOUTH SHAMROCK AVENUE PO BOX 5023 MONROVIA, CALIFORNIA 91016-4251 FORMERLY HADBAR DIV OF PUROSIL INC
07484	ACCURATE BUSHING CO INC 443 NORTH AVENUE GARWOOD, NEW JERSEY 07027-1014 FORMERLY V83132 SMITH BRG DIV OF ACCURATE BUSHING CO
11960	KIRKHILL - TA HANKON DIV 336 WEIR ST P. O. BOX 1091 TAUNTON, MASSACHUSETTS 02780 FORMERLY HERCULES INC & HAVEG & BURKE INC HASKON DIV
50744	KIRKHILL-TA CO/SFS DIV 300 E CYPRESS STREET BREA, CALIFORNIA 92821-4007 FORMERLY SFS IND; FORMERLY BURKE RUBBER SFS DIV
60380	TORRINGTON CO BEARINGS DIV SUBSIDIARY OF INGERSOLL-RAND CORP 59 FIELD STREET PO BOX 1008 TORRINGTON, CONNECTICUT 06790-1008 FORMERLY TORRINGTON BEARING COMPANY
92563	MCGILL MFG CO INC BEARINGS DIV 909 LAFAYETTE STREET VALPARAISO, INDIANA 46383-4210

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details

NUMERICAL INDEX

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
10-60754-753		1	85B	1
10-60754-754		1	87	1
10-60754-799		2	75D	1
10-60754-800		2	77	1
5673-753		1	85B	1
5673-754		1	87	1
5673-799		2	75D	1
5673-800		2	77	1
65C26770-10SP		1	5C	RF
65C26770-13SP		1	1D	RF
		2	1	RF
65C26770-14SP		1	5D	RF
		2	5	RF
65C26770-17SP		1	1F	RF
		2	1B	RF
65C26770-18SP		1	5F	RF
		2	5B	RF
65C26770-19SP		1	1G	RF
		2	1C	RF
65C26770-20SP		1	5G	RF
		2	5C	RF
65C26770-21SP		1	1H	RF
		2	1D	RF
65C26770-22SP		1	5H	RF
		2	5D	RF
65C26770-23SP		1	1J	RF
		2	1E	RF
65C26770-24SP		1	5J	RF
		2	5E	RF
65C26770-25SP		1	1K	RF
		2	1F	RF
65C26770-26SP		1	5K	RF
		2	5F	RF
65C26770-27SP		1	1L	RF

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		2	1G	RF
65C26770-28SP		1	5L	RF
		2	5G	RF
65C26770-29SP		1	1M	RF
		2	1H	RF
65C26770-30SP		1	5M	RF
		2	5H	RF
65C26770-3SP		1	1	RF
65C26770-4SP		1	5	RF
65C26770-5SP		1	1A	RF
65C26770-6SP		1	5A	RF
65C26770-7SP		1	1B	RF
65C26770-8SP		1	5B	RF
65C26770-9SP		1	1C	RF
65C26771-1		1	115	1
65C26771-10		1	135C	1
65C26771-17		2	105B	1
65C26771-18		2	105C	1
65C26771-19		2	125B	1
65C26771-2		1	115B	1
65C26771-20		2	125C	1
65C26771-25		2	125D	1
65C26771-26		2	125E	1
65C26771-3		1	135	1
65C26771-31		2	105D	1
65C26771-32		2	105E	1
65C26771-33		2	125F	1
65C26771-34		2	125G	1
65C26771-35		2	105F	1
65C26771-36		2	105G	1
65C26771-37		2	125H	1
65C26771-38		2	125J	1
65C26771-39		2	105H	1
65C26771-4		1	135B	1
65C26771-40		2	105J	1

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
65C26771-41		2	125K	1
65C26771-42		2	125L	1
65C26771-7		1	115A	1
65C26771-8		1	115C	1
65C26771-9		1	135A	1
65C26782-1		1	70	1
		2	55	1
65C26782-17		1	105	1
65C26782-18		1	105B	1
65C26782-2		1	70A	1
		2	55A	1
65C26782-23		1	75A	1
		2	60	1
65C26782-24		1	75C	1
		2	60A	1
65C26782-27		2	60B	1
65C26782-28		2	60C	1
65C26782-3		1	75	1
65C26782-4		1	75B	1
65C26783-10		2	65C	1
65C26783-3		1	80	1
65C26783-4		1	80A	1
65C26783-7		2	65	1
65C26783-8		2	65A	1
65C26783-9		2	65B	1
65C26784-10		1	110A	1
		2	100A	1
65C26784-13		2	100B	1
65C26784-14		2	100C	1
65C26784-9		1	110	1
		2	100	1
69-73874-2		1	45	1
69-76334-1		1	105A	1
		2	95	1
69-76334-2		1	105C	1

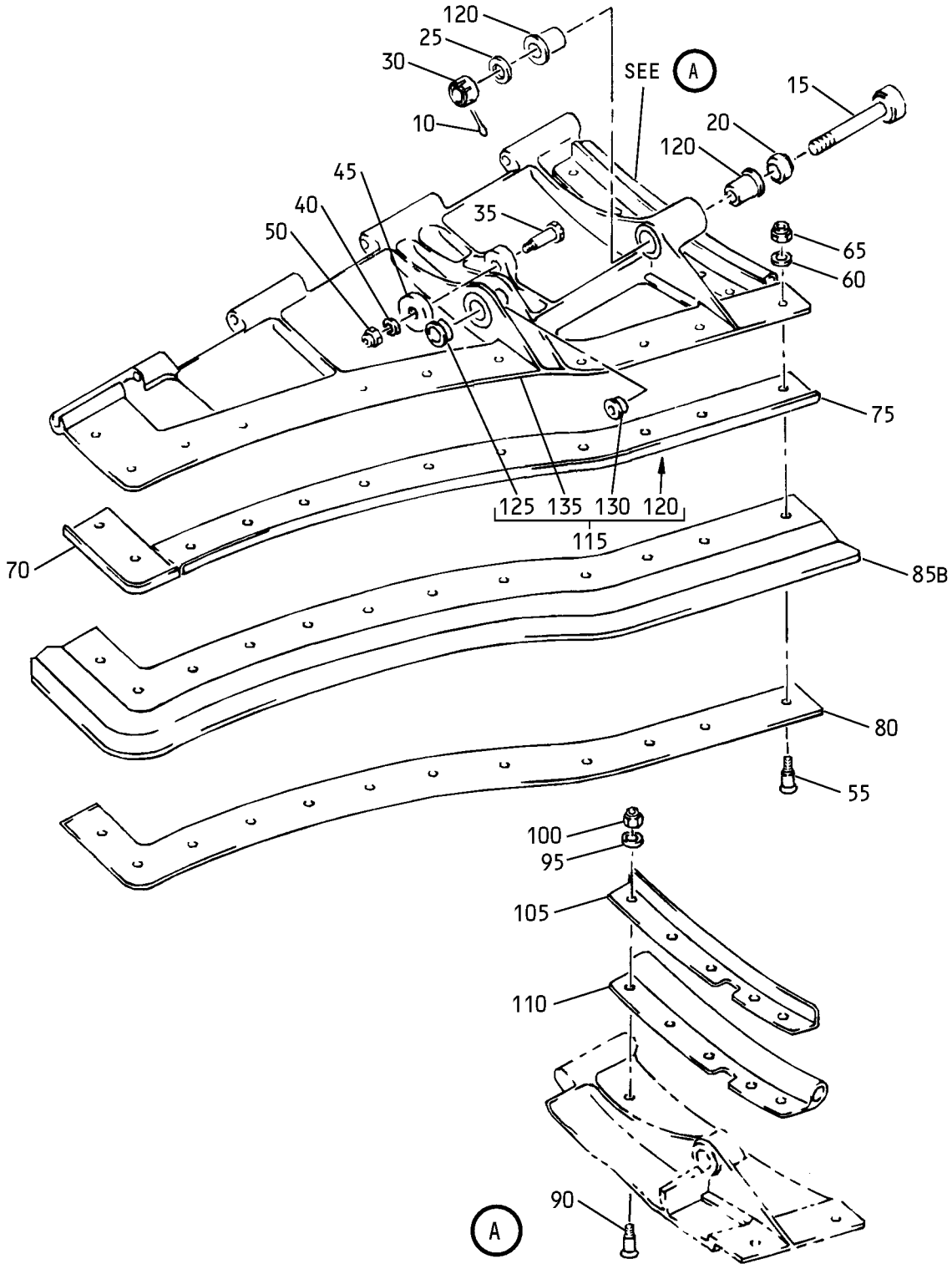
BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
		2	95A	1
69-76334-3		2	95B	1
69-76334-4		2	95C	1
69-76334-5		2	95D	1
69-76334-6		2	95E	1
69-77225-1		2	70	1
69-77225-2		2	70A	1
69-77225-3		2	70B	1
69-77225-4		2	70C	1
69-77225-5		2	70D	1
		2	70E	1
69-77225-6		2	70F	1
		2	70G	1
800-799		2	75D	1
800-800		2	77	1
AN960C516L		1	25	1
		2	25	1
AN960JD10L		1	60	12
		1	95	5
		2	45	8
		2	85	5
AN960PD10L		1	40	1
BACB10AF5F27HS		1	15	1
		2	15	1
BACB28AM06B020A		1	125	1
		2	115	1
BACB28AP04P018		1	130	1
		2	120	1
BACB28AP05P055		1	120	2
		2	110	2
BACB28Z5G022		1	20	1
BACB28Z5G026		2	20A	1
BACB30NM3K7		1	35	1
BACB30NN3K4		1	90	5
		2	80	5

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details

PART NUMBER	AIRLINE PART NUMBER	FIGURE	ITEM	UNITS PER ASSEMBLY
BACB30NN3K6		2	35	5
BACB30NN3K7		1	55	12
BACB30NN3K8		2	40	3
BACN10J3CD		1	50	1
BACN10JC3CD		1	65	12
		1	100	5
		2	50A	8
		2	90	5
BACN10JD5ASU		1	30	1
		2	30	1
HRS3CFR27		1	15	1
		1	15	1
		1	15	1
		2	15	1
		2	15	1
		2	15	1
MS24665-153		1	10	1
		2	10	1
SF15-103-753		1	85B	1
SF15-103-754		1	87	1
SF15-103-799		2	75D	1
SF15-103-800		2	77	1

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details



Seal Inboard Wing L.E. Door Assembly
IPL Figure 1

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
–1	65C26770-3SP		DOOR ASSY-SEAL INBD WING LE (LH)	A	RF
–1A	65C26770-5SP		DOOR ASSY-SEAL INBD WING LE (LH)	C	RF
–1B	65C26770-7SP		DOOR ASSY-SEAL INBD WING LE (LH)	E	RF
–1C	65C26770-9SP		DOOR ASSY-SEAL INBD WING LE (LH)	G	RF
–1D	65C26770-13SP		DOOR ASSY-SEAL INBD WING LE (LH) (FOR DETAILS SEE FIG. 2)	J	RF
–1E	65C26770-17		DELETED		
–1F	65C26770-17SP		DOOR ASSY-SEAL INBD WING LE (LH) (FOR DETAILS SEE FIG. 2)	L	RF
–1G	65C26770-19SP		DOOR ASSY-SEAL INBD WING LE (LH) (FOR DETAILS SEE FIG. 2)	N	RF
–1H	65C26770-21SP		DOOR ASSY-SEAL INBD WING LE (LH) (FOR DETAILS SEE FIG. 2)	P	RF
–1J	65C26770-23SP		DOOR ASSY-SEAL INBD WING LE (LH) (FOR DETAILS SEE FIG. 2)	S	RF
–1K	65C26770-25SP		DOOR ASSY-SEAL INBD WING LE (LH) (FOR DETAILS SEE FIG. 2)	U	RF
–1L	65C26770-27SP		DOOR ASSY-SEAL INBD WING LE (LH) (FOR DETAILS SEE FIG. 2)	V	RF
–1M	65C26770-29SP		DOOR ASSY-SEAL INBD WING LE (LH) (FOR DETAILS SEE FIG. 2)	Y	RF
–5	65C26770-4SP		DOOR ASSY-SEAL INBD WING LE (RH)	B	RF
–5A	65C26770-6SP		DOOR ASSY-SEAL INBD WING LE (RH)	D	RF

–Item not Illustrated

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
–5B	65C26770-8SP		DOOR ASSY-SEAL INBD WING LE (RH)	F	RF
–5C	65C26770-10SP		DOOR ASSY-SEAL INBD WING LE (RH)	H	RF
–5D	65C26770-14SP		DOOR ASSY-SEAL INBD WING LE (RH) (FOR DETAILS SEE FIG. 2)	K	RF
–5E	65C26770-18		DELETED		
–5F	65C26770-18SP		DOOR ASSY-SEAL INBD WING LE (RH) (FOR DETAILS SEE FIG. 2)	M	RF
–5G	65C26770-20SP		DOOR ASSY-SEAL INBD WING LE (RH) (FOR DETAILS SEE FIG. 2)	Q	RF
–5H	65C26770-22SP		DOOR ASSY-SEAL INBD WING LE (RH) (FOR DETAILS SEE FIG. 2)	R	RF
–5J	65C26770-24SP		DOOR ASSY-SEAL INBD WING LE (RH) (FOR DETAILS SEE FIG. 2)	T	RF
–5K	65C26770-26SP		DOOR ASSY-SEAL INBD WING LE (RH) (FOR DETAILS SEE FIG. 2)	W	RF
–5L	65C26770-28SP		DOOR ASSY-SEAL INBD WING LE (RH) (FOR DETAILS SEE FIG. 2)	X	RF
–5M	65C26770-30SP		DOOR ASSY-SEAL INBD WING LE (RH) (FOR DETAILS SEE FIG. 2)	Z	RF
10	MS24665-153		. PIN-COTTER	A-H	1
15	HRS3CFR27		. CAM FOLLOWER (V92563) (SPEC BACB10AF5F27HS) (OPT HRS3CFR27 (V60380)) (OPT HRS3CFR27 (V07484))	A-H	1
20	BACB28Z5G022		. SPACER	A-H	1
25	AN960C516L		. WASHER	A-H	1
30	BACN10JD5ASU		. NUT	A-H	1
35	BACB30NM3K7		. BOLT	A-H	1

–Item not Illustrated

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
40	AN960PD10L		. WASHER	A-H	1
45	69-73874-2		. WASHER	A-H	1
50	BACN10J3CD		. NUT	A-H	1
55	BACB30NN3K7		. BOLT	A-H	12
60	AN960JD10L		. WASHER	A-H	12
65	BACN10JC3CD		. NUT	A-H	12
70	65C26782-1		. RETAINER	A, C, E, G	1
–70A	65C26782-2		. RETAINER	B, D, F, H	1
75	65C26782-3		. RETAINER	A, C, E	1
–75A	65C26782-23		. RETAINER	G	1
–75B	65C26782-4		. RETAINER	B, D, F	1
–75C	65C26782-24		. RETAINER	H	1
80	65C26783-3		. SEAL-PLASTIC	A, C, E, G	1
–80A	65C26783-4		. SEAL-PLASTIC	B, D, F, H	1
85	SF15-103-753		DELETED		
–85A	SF15-103-754		DELETED		
85B	5673-753		. SEAL (V11960) (SPEC 10-60754-753) (OPT SF15-103-753 (V50744))	A, C, E, G	1
–87	5673-754		. SEAL (V11960) (SPEC 10-60754-754) (OPT SF15-103-754 (V50744))	B, D, F, H	1
90	BACB30NN3K4		. BOLT	A-H	5
95	AN960JD10L		. WASHER	A-H	5
100	BACN10JC3CD		. NUT	A-H	5
105	65C26782-17		. RETAINER	A, C	1
–105A	69-76334-1		. RETAINER	E, G	1
–105B	65C26782-18		. RETAINER	B, D	1
–105C	69-76334-2		. RETAINER	F, H	1

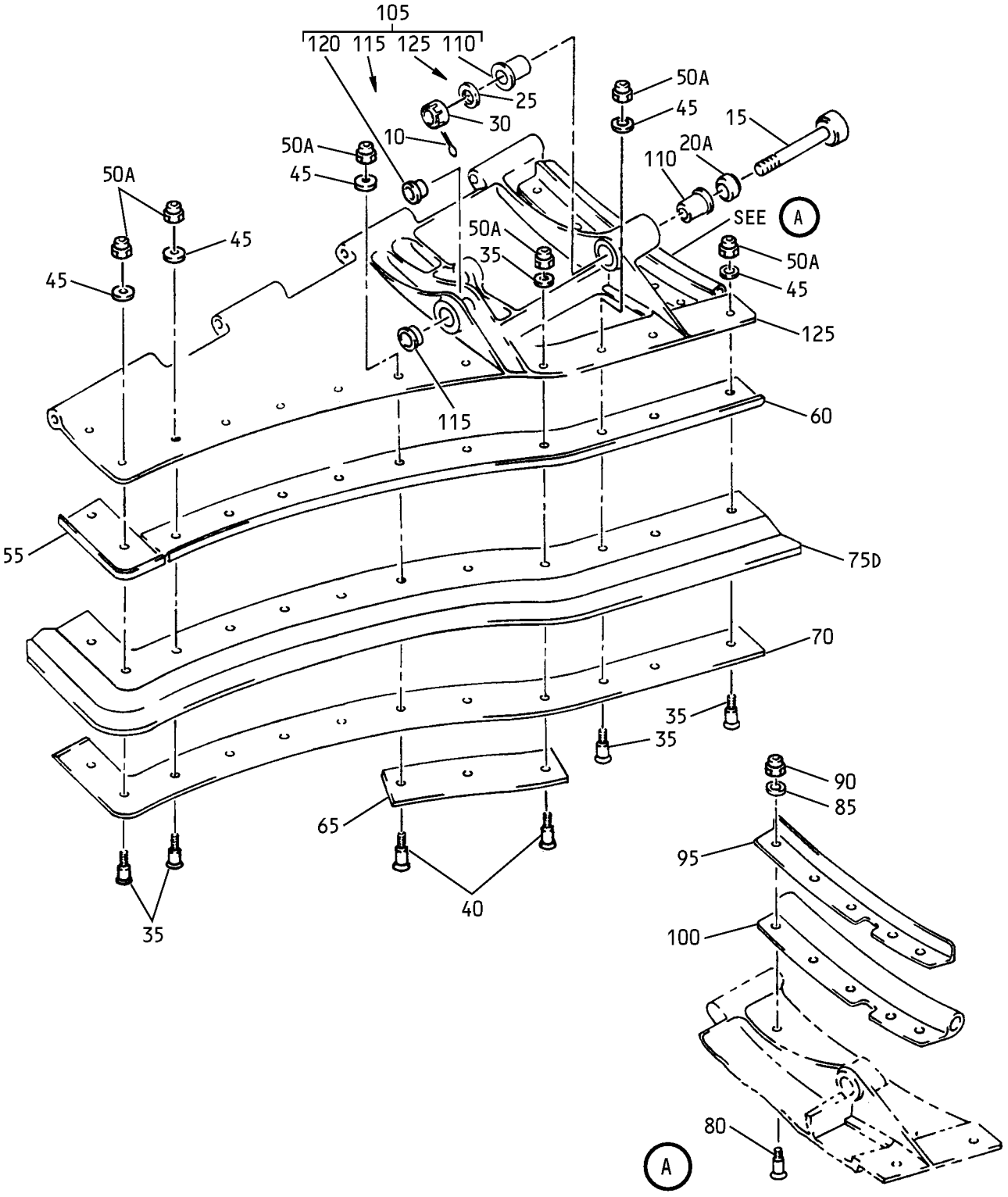
–Item not Illustrated

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
1–					
110	65C26784-9		. SEAL (MAKE FROM SILICONE RUBBER F25.01 10-60754-15 X 5.70)	A, C, E, G	1
–110A	65C26784-10		. SEAL (MAKE FROM SILICONE RUBBER F25.01 10-60754-15 X 5.70)	B, D, F, H	1
115	65C26771-1		. DOOR ASSY	C	1
–115A	65C26771-7		. DOOR ASSY	A, E, G	1
–115B	65C26771-2		. DOOR ASSY	D	1
–115C	65C26771-8		. DOOR ASSY	B, F, H	1
120	BACB28AP05P055		. . BUSHING	A-H	2
125	BACB28AM06˜ B020A		. . BUSHING	A-H	1
130	BACB28AP04P018		. . BUSHING	A-H	1
135	65C26771-3		. . DOOR	C	1
–135A	65C26771-9		. . DOOR	A, E, G	1
–135B	65C26771-4		. . DOOR	D	1
–135C	65C26771-10		. . DOOR	B, F, H	1

–Item not Illustrated

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details



Seal Inboard Wing L.E. Door Assembly
IPL Figure 2

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
–1	65C26770-13SP		DOOR ASSY-SEAL INBD WING LE (LH)	J	RF
–1A	65C26770-17		DELETED		
–1B	65C26770-17SP		DOOR ASSY-SEAL INBD WING LE (LH)	L	RF
–1C	65C26770-19SP		DOOR ASSY-SEAL INBD WING LE (LH)	N	RF
–1D	65C26770-21SP		DOOR ASSY-SEAL INBD WING LE (LH)	P	RF
–1E	65C26770-23SP		DOOR ASSY-SEAL INBD WING LE (LH)	S	RF
–1F	65C26770-25SP		DOOR ASSY-SEAL INBD WING LE (LH)	U	RF
–1G	65C26770-27SP		DOOR ASSY-SEAL INBD WING LE (LH)	V	RF
–1H	65C26770-29SP		DOOR ASSY-SEAL INBD WING LE (LH)	Y	RF
–5	65C26770-14SP		DOOR ASSY-SEAL INBD WING LE (RH)	K	RF
–5A	65C26770-18		DELETED		
–5B	65C26770-18SP		DOOR ASSY-SEAL INBD WING LE (RH)	M	RF
–5C	65C26770-20SP		DOOR ASSY-SEAL INBD WING LE (RH)	Q	RF
–5D	65C26770-22SP		DOOR ASSY-SEAL INBD WING LE (RH)	R	RF
–5E	65C26770-24SP		DOOR ASSY-SEAL INBD WING LE (RH)	T	RF
–5F	65C26770-26SP		DOOR ASSY-SEAL INBD WING LE (RH)	W	RF
–5G	65C26770-28SP		DOOR ASSY-SEAL INBD WING LE (RH)	X	RF
–5H	65C26770-30SP		DOOR ASSY-SEAL INBD WING LE (RH)	Z	RF
10	MS24665-153		. PIN-COTTER	J-Z	1

–Item not Illustrated

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
15	HRS3CFR27		. CAM FOLLOWER (V92563) (SPEC BACB10AF5F27HS) (OPT HRS3CFR27 (V60380)) (OPT HRS3CFR27 (V07484))	J-Z	1
20	BACB28Z5G0226		DELETED		
20A	BACB28Z5G026		. SPACER	J-Z	1
25	AN960C516L		. WASHER	J-Z	1
30	BACN10JD5ASU		. NUT	J-Z	1
35	BACB30NN3K6		. BOLT	J-Z	5
40	BACB30NN3K8		. BOLT	J-Z	3
45	AN960JD10L		. WASHER	J-Z	8
50	BACN10J3CD		DELETED		
50A	BACN10JC3CD		. NUT	J-Z	8
55	65C26782-1		. RETAINER	J, L, N, P, S, U, V, Y	1
–55A	65C26782-2		. RETAINER	K, M, Q, R, T, W, X, Z	1
60	65C26782-23		. RETAINER	J, L	1
–60A	65C26782-24		. RETAINER	K, M	1
–60B	65C26782-27		. RETAINER	N, P, S, U, V, Y	1
–60C	65C26782-28		. RETAINER	Q, R, T, W, X, Z	1
65	65C26783-7		. STRIP-RUB	J	1
–65A	65C26783-8		. STRIP-RUB	K	1
–65B	65C26783-9		. STRIP-RUB	L, N, P, S, U, V, Y	1
–65C	65C26783-10		. STRIP-RUB	M, Q, R, T, W, X, Z	1
70	69-77225-1		. RETAINER	J, L, N	1
–70A	69-77225-2		. RETAINER	K, M, Q	1
–70B	69-77225-3		. RETAINER (OPT ITEM 70D)	P, V	1

–Item not Illustrated

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
–70C	69-77225-4		. RETAINER (OPT ITEM 70F)	R, X	1
–70D	69-77225-5		. RETAINER (OPT ITEM 70B)	P, V	1
–70E	69-77225-5		. RETAINER	S, U, Y	1
–70F	69-77225-6		. RETAINER (OPT ITEM 70C)	R, X	1
–70G	69-77225-6		. RETAINER	T, W, Z	1
75	SF15-103-799		DELETED		
–75A	SF15-103-800		DELETED		
75B	800-799		DELETED		
–75C	800-800		DELETED		
75D	5673-799		. SEAL (V07096) (SPEC 10-60754-799) (OPT 800-799 (V07096)) (OPT SF15-103-799 (V50744))	J, L, N, P, S, U, V, Y	1
–77	5673-800		. SEAL (V11960) (SPEC 10-60754-800) (OPT SF15-103-800 (V50744)) (OPT 800-800 (V07096))	K, M, Q, R, T, W, X, Z	1
80	BACB30NN3K4		. BOLT	J-Z	5
85	AN960JD10L		. WASHER	J-Z	5
90	BACN10JC3CD		. NUT	J-Z	5
95	69-76334-1		. RETAINER	J, L, N, P, S	1
–95A	69-76334-2		. RETAINER	K, M, Q, R, T	1
–95B	69-76334-3		. RETAINER	U, V	1
–95C	69-76334-4		. RETAINER	W, X	1
–95D	69-76334-5		. RETAINER	Y	1
–95E	69-76334-6		. RETAINER	Z	1
100	65C26784-9		. SEAL (MAKE FROM SILICONE RUBBER F25.01 10-60754-15 X 5.70)	J, L, N, P, S, U, V	1

–Item not Illustrated

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
–100A	65C26784-10		. SEAL (MAKE FROM SILICONE RUBBER F25.01 10-60754-15 X 5.70)	K, M, Q, R, T, W, X	1
–100B	65C26784-13		. SEAL (MAKE FROM SILICONE RUBBER F25.01 10-60754-15 X 5.70)	Y	1
–100C	65C26784-14		. SEAL (MAKE FROM SILICONE RUBBER F25.01 10-60754-15 X 5.70)	Z	1
105	65C26771-11		DELETED		
–105A	65C26771-12		DELETED		
105B	65C26771-17		. DOOR ASSY	J, L, N	1
–105C	65C26771-18		. DOOR ASSY	K, M, Q	1
–105D	65C26771-31		. DOOR ASSY	P, V	1
–105E	65C26771-32		. DOOR ASSY	R, X	1
–105F	65C26771-35		. DOOR ASSY	S, U	1
–105G	65C26771-36		. DOOR ASSY	T, W	1
–105H	65C26771-39		. DOOR ASSY	Y	1
–105J	65C26771-40		. DOOR ASSY	Z	1
110	BACB28AP05P055		. . BUSHING	J-Z	2
115	BACB28AM06~ B020A		. . BUSHING	J-Z	1
120	BACB28AP04P018		. . BUSHING	J-Z	1
125	65C26771-13		DELETED		
–125A	65C26771-14		DELETED		
125B	65C26771-19		. . DOOR (OPT ITEM 125D)	J, L, N	1
–125C	65C26771-20		. . DOOR (OPT ITEM 125E)	K, M, Q	1
–125D	65C26771-25		. . DOOR (OPT ITEM 125B)	J, L, N	1
–125E	65C26771-26		. . DOOR (OPT ITEM 125C)	K, M, Q	1
–125F	65C26771-33		. . DOOR	P, V	1
–125G	65C26771-34		. . DOOR	R, X	1

–Item not Illustrated

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details

FIG/ ITEM	PART NUMBER	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USAGE CODE	UNITS PER ASSY
2–					
–125H	65C26771-37		. . DOOR	S, U	1
–125J	65C26771-38		. . DOOR	T, W	1
–125K	65C26771-41		. . DOOR	Y	1
–125L	65C26771-42		. . DOOR	Z	1

–Item not Illustrated

BOEING PROPRIETARY - Copyright © Unpublished Work - See title page for details