

BOEING 
COMMERCIAL JET
OVERHAUL MANUAL

CHASSIS ASSEMBLY

24-01-01

BOEING P/N 65-40514-1, -6, -9, -11, -17, -18, -20, -28, -30, -33, -34, -37,
-42, -44, -46

AIRLINE P/N

THE FOLLOWING DIRECTIVES APPLY TO THIS SUBJECT:

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVES	DATE DIRECTIVE INCORPORATED INTO TEXT

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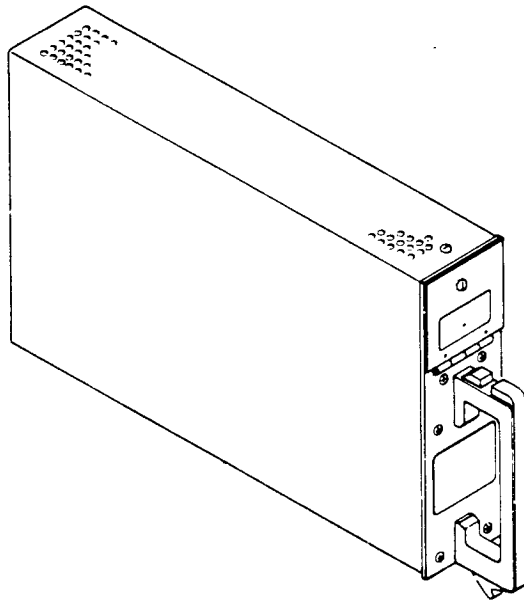
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CHASSIS ASSEMBLY



Chassis Assembly
Figure 1

DESCRIPTION AND OPERATION

1. Description

- A. The 65-40514 chassis assembly is an ATR case used to house the electronic components of various accessory unit assemblies. A perforated dust cover protects housed components and permits ventilation. The interior webs, shelves, brackets, or retainers are configured to meet the requirements for component mounting of the accessory unit assemblies.

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2. Operation

- A. The front plate is equipped with either a latch, or handle and chassis hooks, for carrying, and for locking to the aircraft electronic equipment shelf. The rear plate is designed for installation of a quick-disconnect connector.

3. Leading Particulars

- Height -- 8 inches (approx)
- Width -- 3-1/2 inches (approx)
- Length -- 14 inches (approx)
- Weight -- 3 pounds (approx)

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DISASSEMBLY

1. General

- A. Disassemble only as necessary for replacement or repair of parts. Disassembly not required for cleaning or inspection/check procedures.
- B. This instruction covers the chassis only. If electronic components or wiring are installed, refer to appropriate accessory unit assembly overhaul manual subject.
- C. Disassembly procedures involving replacement of riveted parts are covered under REPAIR.

2. Disassemble units 65-40514-1, -6, -9, -17, and -46 as follows (Fig. 1101):

- A. Disengage spring fastener (23) and remove dust cover (1).
- B. Remove screws (19), nuts (20), and front plate assembly (2).
- C. Remove screws (17), washers (18), and latch (16) from front plate assembly (2).
- D. On 65-40514-17 unit only, disassemble front plate assembly as follows:
 - (1) Remove screws (7), nuts (8), and door assembly (9).
 - (2) Remove retaining ring (15) and stud (14).
- E. On 65-40514-46 only:
 - (1) Disengage studs (47), remove screws (37) and card retainer assembly (38).
 - (2) Remove screws (35), nuts (36), and bracket (32).

3. Disassemble units 65-40514-18, -24, -30, -33, -34, -42 and -44 as follows (Fig. 1102):

- A. Remove screw (1), disengage spring fastener (19), and remove dust cover (2).
- B. Remove screws (5), washers (6), nuts (7), and chassis hooks (8).
- C. Remove screws (3), nuts (4), and front plate assembly (11).
- D. Remove screws (9) and handle (10) from front plate assembly (11).

NOTE: Screws have been installed with Loctite and will be difficult to remove.

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4. Disassemble units 65-40514-20 and -37 as follows: (See figure 1103.)
 - A. Disengage spring fastener (25) and remove dust cover (1).
 - B. Remove screws (2), washers (3), nuts (4), and chassis hooks (5).
 - C. Remove screws (6), nuts (7), and front plate assembly (8).
 - D. Remove screws (9) and handle (10) from front plate assembly (8).

NOTE: Screws are installed with Loctite and will be difficult to remove.
 - E. Remove screws (38), disengage stud (33) from receptacle (35), and remove card retainer assembly (15).
 - F. Remove screws (30), nuts (31), and relay mounting bracket (32) from card retainer assembly (15).
 - G. Remove washer (34) from stud (33) and remove stud from mounting hole.
5. Disassemble units 65-40514-11 and -28 as follows: (See figure 1104.)
 - A. Disengage spring fastener (32) and remove dust cover (1).
 - B. Remove screws (2), nuts (3), and chassis hooks (4).
 - C. Remove screws (14), washers (15), and handle (16).
 - D. Remove screws (5), nuts (6), and front plate assembly (7).
 - E. Perform the following for 65-40514-28 only:
 - (1) Remove screws (17), nuts (18), washers (19), and transformer support angles (20).
 - (2) Remove screws (21), nuts (22), and transformer support angle (23).
 - (3) Remove screws (24, 25), nuts (26), and transformer support angles (27, 28).
 - (4) Remove screws (34), nuts (35), and shelf (36).

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CLEANING

WARNING: MAKE CERTAIN THAT ALL SOURCES OF FLASH OR FIRE ARE ELIMINATED FROM AREA OF POSSIBLE CONTACT WITH COMBUSTIBLE MATERIALS AND VAPORS DURING CLEANING.

CAUTION: IF ELECTRICAL COMPONENTS OR WIRES ARE ATTACHED, DO NOT USE ABRASIVES OR BRUSHES. DO NOT ALLOW SOLVENTS OR CLEANING FLUIDS (EXCEPT NAPHTHA AND ALCOHOL) TO CONTACT ELECTRICAL SURFACES. DO NOT ALLOW SOLVENTS OR CLEANING FLUIDS TO CONTACT IMPREGNABLE SURFACES.

1. Remove dust or foreign matter from assembly using low pressure air suction.
2. Clean surfaces per "Alkaline Cleaning" in Subject 20-30-03, except that surfaces containing electronic components or wires should be cleaned with aliphatic naphtha or isopropyl alcohol. Dry with low pressure air.
3. Clean electrical bonding areas per Subject 20-11-03.

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INSPECTION/CHECK

1. Check protective finishes for damage.
2. Check assembly for warping, bending, or other damage.
3. Check hinges for proper alignment.
4. Check rivets, nutplates, or clinch nuts for security.
5. Check stud assemblies for proper locking into receptacles, and latches for proper operation.

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REPAIR

1. Repair

A. Straighten any bent structural members.

2. Refinish

NOTE: Refer to Subject 20-41-01 for decoding of F and SRF finish symbols and to Subject 20-30-02 for stripping of protective finishes.

A. If protective finishes are worn or damaged, refinish as indicated:

- (1) All Structural Parts -- Apply F-2.21, F-2.30, or SRF-2.30 all over.
- (2) Front Plate -- Apply F-12.75 or SRF-14.9031 to front surface and edges.
- (3) Screws (with heads exposed on front of front plate) -- Apply F-14.91 to heads.

3. Replacement

A. Replace all parts damaged beyond minor repair.

B. If rivets or nutplates require replacement, apply a coat of primer, BMS 10-11, Type 1, to faying surfaces and join while wet.

C. If replacement of a stud assembly (14, figure 1101, or 33, figure 1103) is required, remove lockwasher or retaining ring, insert new stud assembly, and secure in place with new lockwasher or retaining ring.

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ASSEMBLY

1. General

A. Complete required REPAIR procedures.

2. Assemble units 65-40514-1, -6, -9, -17, and -46 as follows (Fig. 1101):

A. On 65-40514-17 unit only, assemble front plate assembly as follows:

(1) Insert stud (14) and lock in place with retaining ring (15).

(2) Position door assembly (9) on front plate assembly and install screws (7) and nuts (8).

B. Position latch (16) on front plate assembly (2) and install screws (17) and washers (18).

C. Position front plate assembly (2) on shelf (25) and side plate (26) and install screws (19) and nuts (20).

D. On 65-40514-46 unit only:

(1) Install bracket (32) with screws (35) and nuts (36).

(2) Install card retainer assembly (38) with screws (37). Engage studs (47).

E. Slide dust cover over chassis and engage spring fastener (23).

3. Assemble units 65-40514-18, -24, -30, -33, -34, -42 and -44 as follows (Fig. 1102):

A. Position handle (10) on front plate assembly (11) and install screws (9).

NOTE: Apply Loctite (Loctite Corporation, 705 North Mountain Road, Newington, Connecticut 06111) to threads per manufacturer's instructions before installing screws.

B. Position front plate assembly (11) on side plate (21) and shelf (22) and install screws (3) and nuts (14).

C. Position chassis hooks (8) on front plate assembly (11) and install screws (5), washers (6), and nuts (7).

D. Slide dust cover (2) over chassis assembly, engage spring fastener (19) and install screw (1).

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4. Assemble units 65-40514-20 and -37 as follows: (See figure 1103.)
- A. Insert stud (33) in mounting hole and lock in place with washer (34).
 - B. Position relay mounting bracket (32) on card retainer assembly (15) and install screws (30) and nuts (31).
 - C. Position card retainer assembly (15) on shelf (27); install screws (38), and engage stud (33) in receptacle (35).
 - D. Position handle (10) on front plate assembly (8) and install screws (9).

NOTE: Apply Loctite (Loctite Corporation, 705 North Mountain Road, Newington, Connecticut 06111) to threads per manufacturer's instructions before installing screws.

5. Assemble units 65-40514-11 and -28 as follows: (See figure 1104.)

NOTE: Steps A through D apply to 65-40514-28 only. Assembly of 65-40514-11 begins with step E.

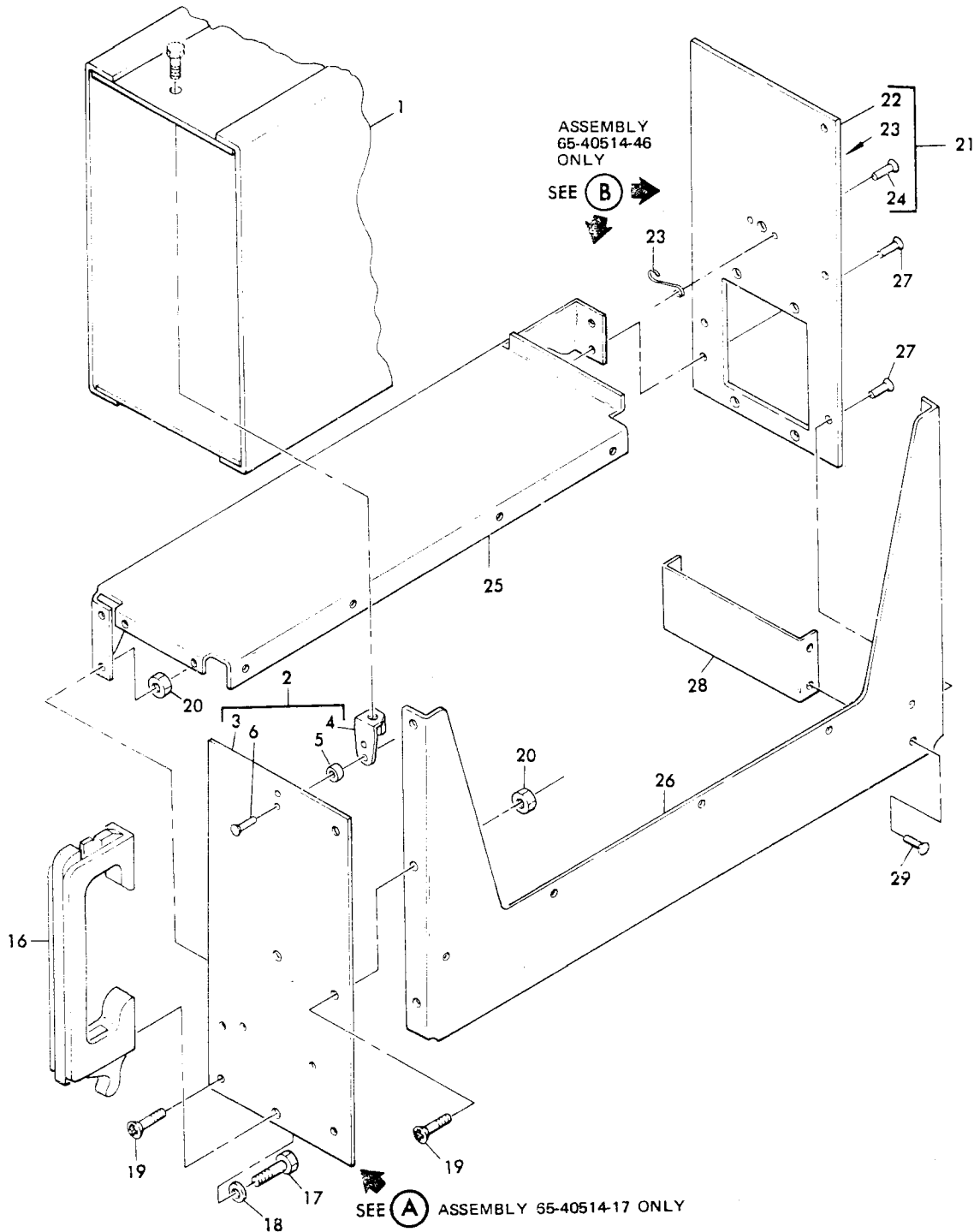
- A. Position shelf (36) on side plate (37) and install screws (34) and nuts (35).
- B. Position transformer support angles (27, 28) on front plate (8) and install screws (24, 25) and nuts (26).
- C. Position transformer support angle (23) on front plate (8) and install screws (21) and nuts (22).
- D. Position transformer support angles (20) on support angle (23) and install screws (17), washers (19), and nuts (18).
- E. Position front plate assembly (7) on shelf (36) and side plate (37) and install screws (5) with nuts (6).
- F. Position handle (16) on front plate (8) and install screws (14) with washers (15).
- G. Position chassis hooks (4) on front plate (8) and install screws (2) and nuts (3).
- H. Slide dust cover (1) over chassis assembly and engage spring fastener (30).

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STORAGE INSTRUCTIONS

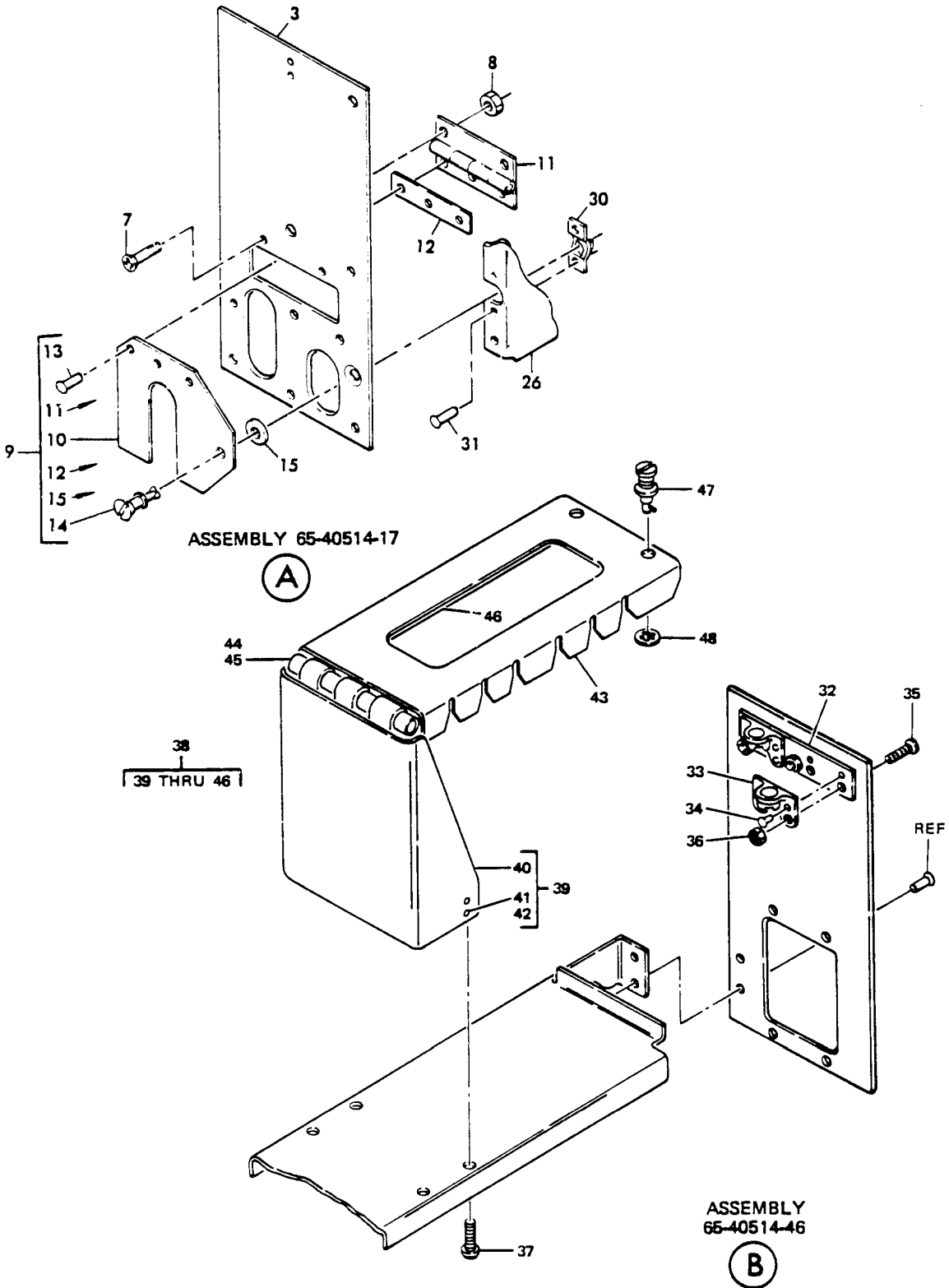
1. Protect chassis assembly from dust, moisture, and atmospheric conditions. Slide unit into plastic bag, and insert in protective carton, padded sufficiently to prevent damage during storage and handling. Close, tape, and mark carton with assembly identity and date of overhaul.
2. For further information refer to Subject 20-70-01, "Protection, Storage and Handling of Airplane Components."

ILLUSTRATED PARTS LIST



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Chassis Assemblies 65-40514-1, -6, -9, -17, -46
 Figure 1101 (Sheet 2)

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2. Group Assembly Parts List

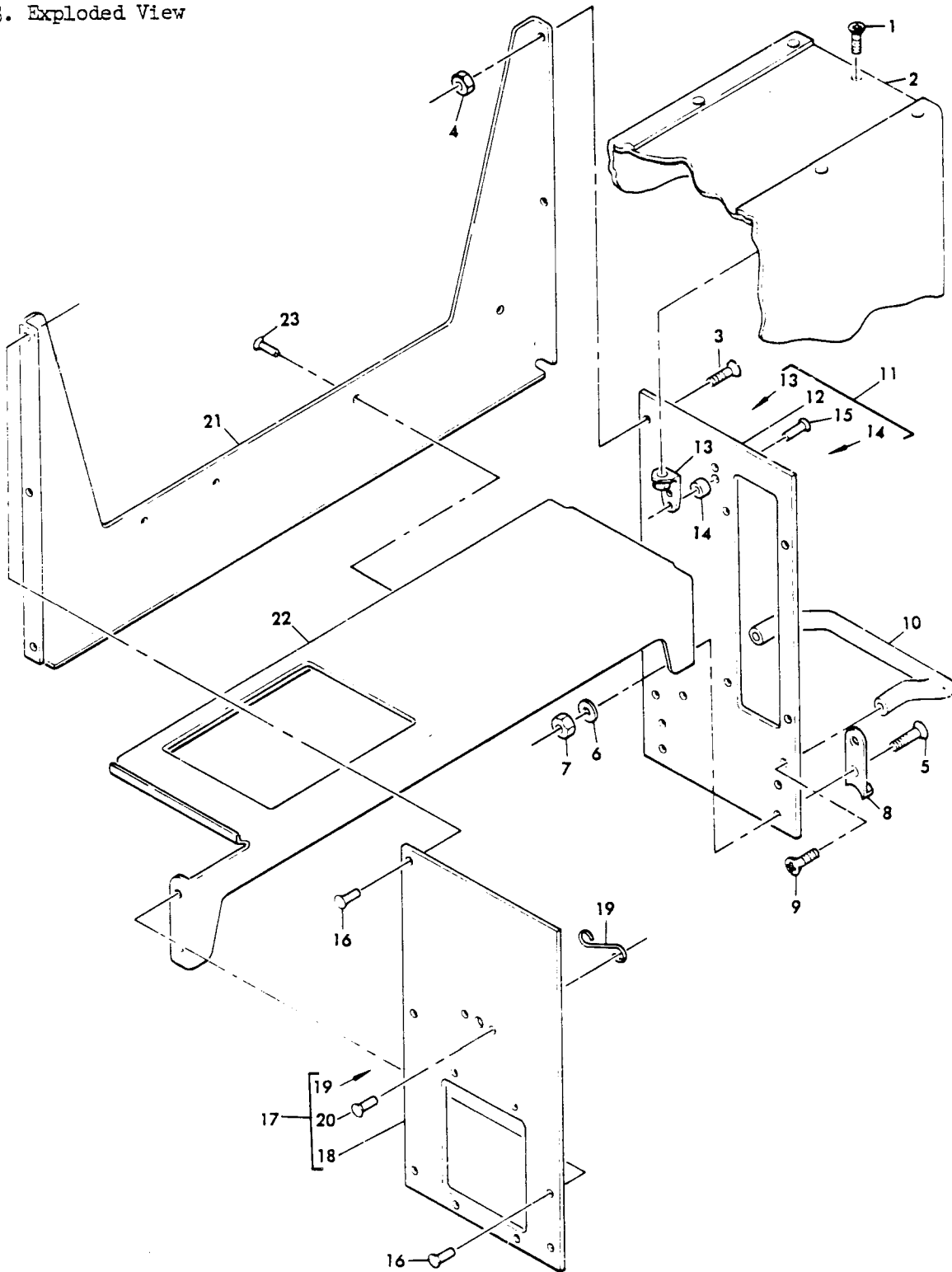
FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	N O M E N C L A T U R E							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
1101	65-40514-1		CHASSIS ASSY, 3/8 ATR CASE							A	
	65-40514-6		CHASSIS ASSY, 3/8 ATR CASE							B	
	65-40514-9		CHASSIS ASSY, 3/8 ATR CASE							C	
	65-40514-17		CHASSIS ASSY, 3/8 ATR CASE							D	
	65-40514-46		CHASSIS ASSY, 3/8 ATR CASE							E	
1	DS232		. DUST COVER, SHORT, V94867							ACD	1
1	DL232		. DUST COVER, LONG, V94867							B	1
1	DS232-204		. DUST COVER, SHORT, V94867							E	1
2	65-40514-2		. PLATE ASSY, FRONT							ABCE	1
2	65-57973-6		. PLATE ASSY, FRONT							D	1
3	69-31961-1		. . PLATE, FRONT							ABCE	1
3	65-57973-1		. . PLATE, FRONT							D	1
4	AN256-6		. . NUTPLATE								1
5	NAS42DD3-6		. . SPACER								2
6	BACR15BA3D		. . RIVET (REPLS MS20426D3)								2
7	NAS514P440-5B		. . SCREW, BLACK							D	2
8	BACN1ODN40		. . NUT							D	2
9	65-57973-5		. . DOOR ASSY							D	1
10	65-57973-2		. . . DOOR								1
11	65-57973-4		. . . HINGE								1
12	65-57973-3		. . . SPACER								1
13	BACR15BA3D		. . . RIVET (REPLS MS20426D3)								3
14	BACS21AP200R		. . . STUD								1
15	BACR12AG		. . . RING, RETAINING								1
16	D4100-1A		. LATCH, V08524								1
16	40L2-2		. LATCH, V71286 (OPT)								1
17	NAS603-6		. SCREW								2
18	MS35337-43		. WASHER								2
19	NAS514P440-5B		. SCREW								7
20	BACN1ODN40		. NUT								7
21	65-40514-3		. PLATE ASSY, REAR								1
22	69-31960-1		. . PLATE, REAR								1
23	S3-150		. . FASTENER, SPRING, V72794								1
24	BACR15BA3D		. . RIVET (REPLS MS20426D3)								2
25	65-40514-4		. SHELF, SHORT							AD	1
25	65-40514-7		. SHELF, LONG							B	1
25	65-40514-10		. SHELF, SHORT							C	1
25	65-40514-47		. SHELF, SHORT							E	1

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FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	N O M E N C L A T U R E							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
1101											
26	65-40514-5		.							ACD	1
26	65-40514-8		.							B	1
26	65-40514-48		.							E	1
27	MS20426D3		.							ACDE	9
27	MS20426D3		.							B	10
28	69-44599-1		.							D	1
29	BACR15BA3D		.							D	4
30	BACR11AM2		.							D	1
31	BACR15BA3D		.							D	2
32	65-60214-35		.							E	1
33	BACR11Y4A		.							E	2
34	BACR15BA3D		.							E	6
35	AN505-2R6		.							E	3
36	BACN1ODN40		.							E	3
37	NAS600-5P		.							E	4
38	65-64993-6		.							E	1
39	69-52922-1		.	.							1
40	69-52922-2		.	.	.						1
41	22A27M22-40		.	.	.						4
42	BACR15BB2D		.	.	.						3
43	69-52922-4		.	.	.						1
44	BACR15BB4D		.	.	.						6
45	MS20257-2-288		.	.	.						1
46	65-64993-5		.	.	.						2
47	BACS21Y3R		.							E	2
48	BACW1OX4		.							E	2

3. Exploded View



Chassis Assemblies 65-40514-18, -24, -30, -33, -34, -42 and 44

Figure 1102

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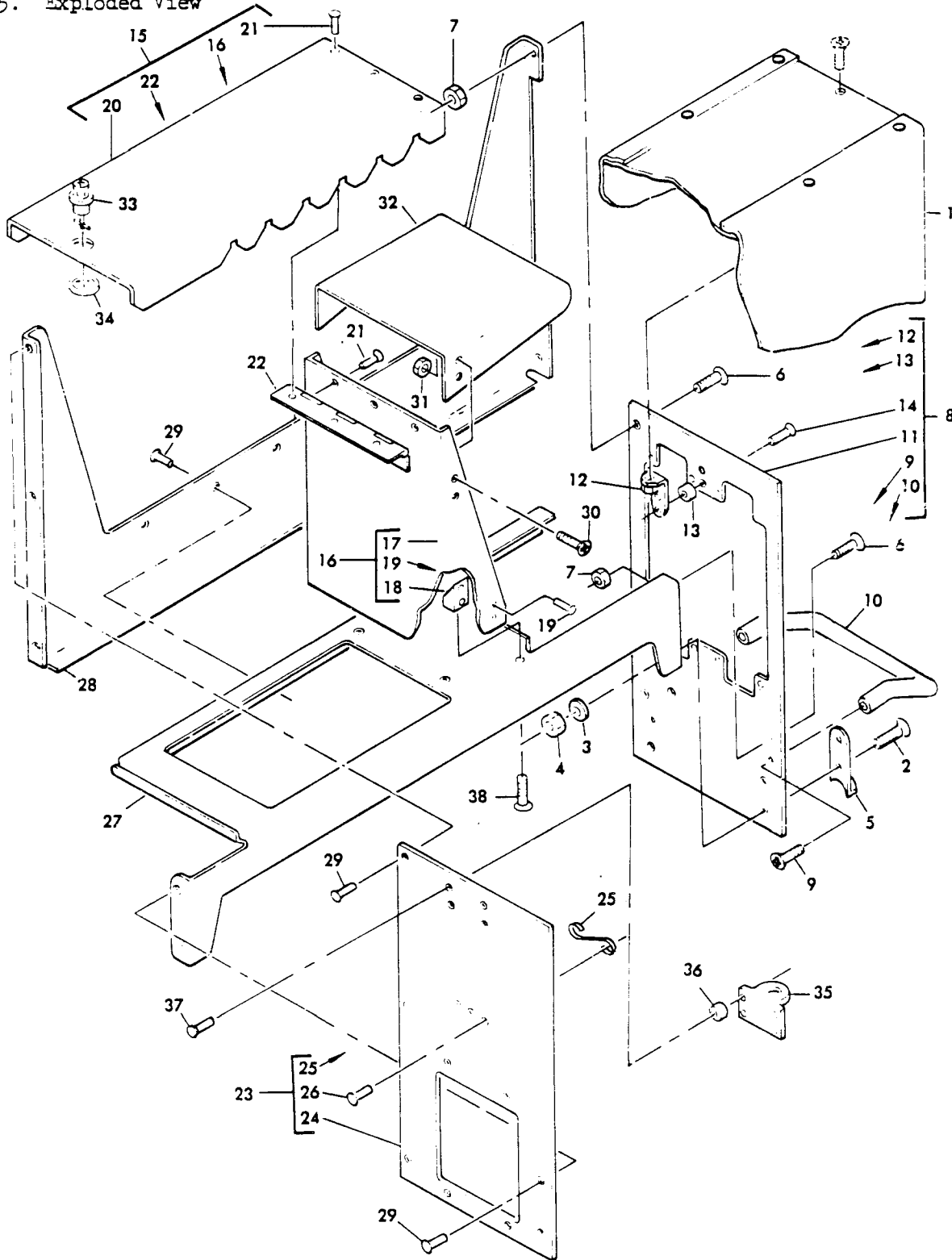
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4. Group Assembly Parts List

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	N O M E N C L A T U R E							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
1102	65-40514-18		CHASSIS ASSEMBLY, 3/8 ATR Case								
	65-40514-24		CHASSIS ASSEMBLY, 3/8 ATR Case								
	65-40514-30		CHASSIS ASSEMBLY, 3/8 ATR Case								
	65-40514-33		CHASSIS ASSEMBLY, 3/8 ATR Case								
	65-40514-34		CHASSIS ASSEMBLY, 3/8 ATR Case								
	65-40514-42		CHASSIS ASSEMBLY, 3/8 ATR Case								
	65-40514-44		CHASSIS ASSEMBLY, 3/8 ATR Case								
1	AN500-6-4		. SCREW								1
2	DS232-147		. DUST COVER, V94867							abc	1
2	DS232-200		. DUST COVER, V94867							defg	1
3	NAS514P440-5B		. SCREW								4
4	BACN10DN40		. NUT								4
5	NAS602-8P		. SCREW								4
6	AN960PD8		. WASHER								4
7	22NM408-82		. NUT, V72962 (preferred)								4
8	HDH2		. HOOK, Chassis, V94867								2
9	NAS514P1032-6		. SCREW (use with ABA9-30 only)								2
10	ABA9-30		. HANDLE, V08730 (optional)								1
10	SS9-30		. HANDLE, V08730 (preferred)								1
11	65-40514-25		. PLATE ASSEMBLY, Front								1
12	65-40514-19		. . PLATE, Front								1
13	AN256F6		. . NUTPLATE								1
14	NAS42DD3-6		. . SPACER, Rivet								2
15	MS20426D3		. . RIVET								5
16	MS20426D3		. RIVET								5
17	65-40514-3		. PLATE ASSEMBLY, Rear							abc	1
17	65-40514-32		. PLATE ASSEMBLY, Rear							defg	1
18	69-31960-1		. . PLATE, Rear (used on 65-40514-3)								1
18	69-31960-2		. . PLATE, Rear (used on 65-40514-32)								1
19	S3-150		. . FASTENER, Spring, V72794								1
20	MS20470D3		. . RIVET								2
21	65-40514-5		. SIDE PLATE, Short								1
22	65-40514-4		. SHELF, Short							a	1
22	65-40514-23		. SHELF, Short							bd	1
22	65-40514-31		. SHELF, Short							c	1
22	65-40514-35		. SHELF, Short							e	1
22	65-40514-43		. SHELF, Short							f	1
22	65-40514-45		. SHELF, Short							g	1
23	MS20426D3		. RIVET								4

a denotes use on 65-40514-18
 b denotes use on 65-40514-24
 c denotes use on 65-40514-30
 d denotes use on 65-40514-33
 e denotes use on 65-40514-34
 f denotes use on 65-40514-42
 g denotes use on 65-40514-44

5. Exploded View



Chassis Assembly 65-40514-20 and -37
 Figure 1103

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6. Group Assembly Parts List

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	N O M E N C L A T U R E							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
1103	65-40514-20		CHASSIS ASSEMBLY, 3/8 ATR Case								
	65-40514-37		CHASSIS ASSEMBLY, 3/8 ATR Case								
1	DS232-204		. DUST COVER, V94867 (preferred) . . .							b	1
1	69-58863-1		. DUST COVER, (optional)							b	1
1	DS232-147		. DUST COVER, V94867.							a	1
2	NAS602-13		. SCREW								4
3	AN960PD8L		. WASHER.								4
4	22NM408-82		. NUT, V72962								4
5	HDH2		. HOOK, Chassis, V94867								2
6	NAS600-6P		. SCREW								2
7	BACN10DN40		. NUT								2
8	65-40514-22		. PLATE ASSEMBLY, Front							a	1
8	65-40514-39		. PLATE ASSEMBLY, Front							b	1
9	NAS514P832-8		. SCREW								2
10	MSS2		. HANDLE, VO8730 (preferred)								1
10	MBO2		. HANDLE, VO8730 (optional)								1
11	69-31961-4		. PLATE, Front.								1
12	AN256F6		. NUT ANCHOR.								1
13	NAS42DD3-6		. SPACER, Rivet								2
14	MS20426A3		. RIVET (used on 65-40514-22)								2
14	MS20426D3		. RIVET (used on 65-40514-39)								2
15	65-44326-32		. RETAINER ASSEMBLY, Card								1
16	65-44326-19		. SUPPORT ASSEMBLY, Retainer.								1
17	65-44326-20		. BRACKET, Retainer								1
18	22A27M22-40		. NUT, Miniature, V72962.								4
19	MS20470A2		. RIVET								8
20	65-44326-33		. RETAINER.								1
21	MS20470A3		. RIVET								6
22	MS20257-2-288		. HINGE								1
23	65-40514-3		. PLATE ASSEMBLY, Rear.							a	1
23	65-50514-38		. PLATE ASSEMBLY, Rear.							b	1
24	69-31960-1		. PLATE, Rear								1
25	S3-150		. FASTENER, Spring (V72794)								1
26	MS20470D3		. RIVET								2
27	65-67384-3		. SHELF								1
28	65-40514-21		. PLATE, Side, short.								1
29	MS20426A3		. RIVET							a	10
29	MS20470D3		. RIVET							b	10
30	NAS514P632-6P		. SCREW								4
31	22NML07-62		. NUT, V72962 (preferred)								4
31	NAS679A06W		. NUT, (optional)								4
32	69-48716-1		. BRACKET, Relay mounting								1
33	BACS21Y1R		. STUD.								1
34	BACW10X4		. WASHER.								1

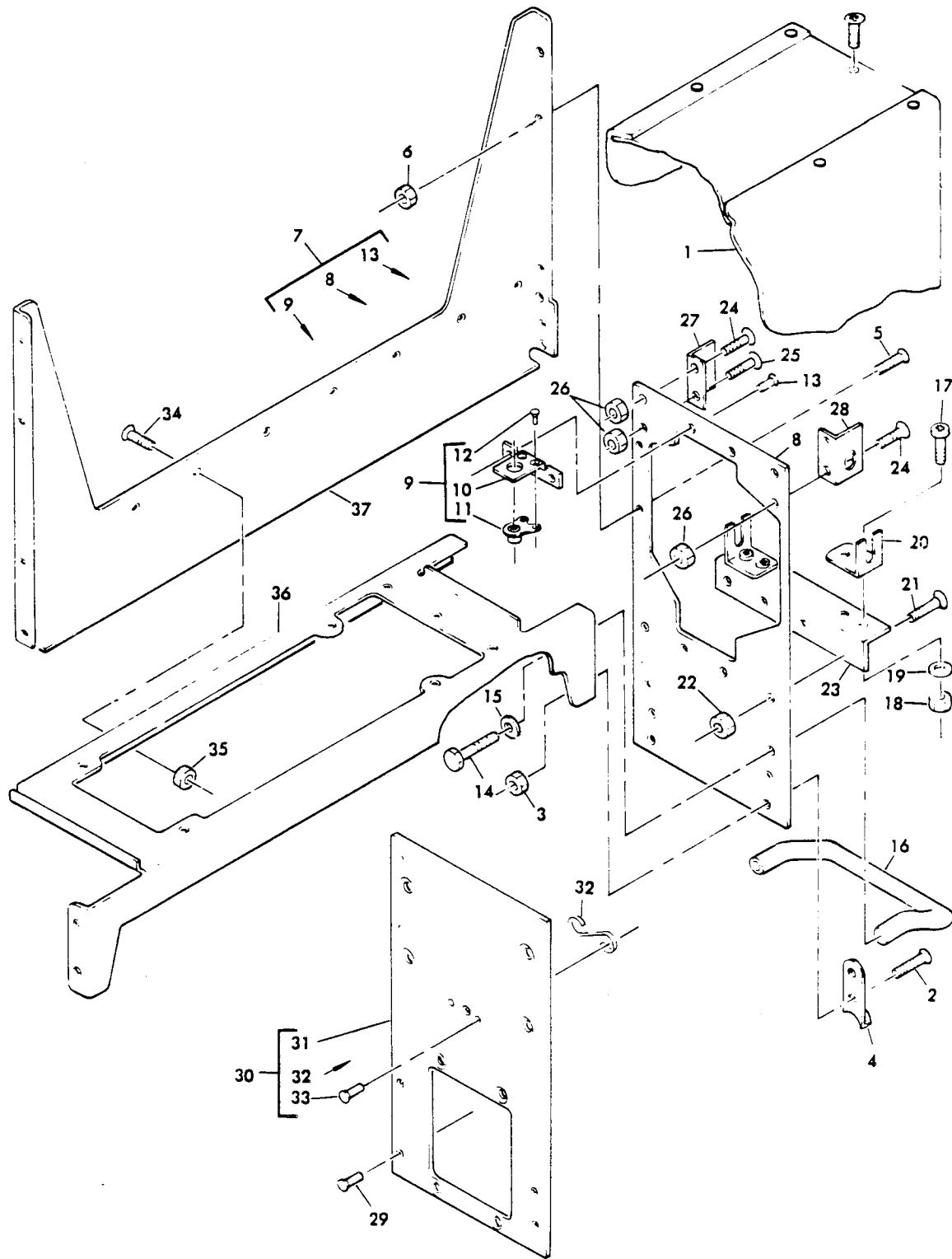
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FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	N O M E N C L A T U R E							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
1103											
35	BACR11Y4A									1	
36	NAS43DD3-10									4	
37	MS20426A3								a	4	
37	MS20426D3								b	4	
38	NAS600-4P									4	

a used on 65-40514-20
b used on 65-40514-37

7. Exploded View



Chassis Assembly 65-40514-28 and 11
Figure 1104

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8. Group Assembly Parts List

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	N O M E N C L A T U R E							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
1104	65-40514-11		CHASSIS ASSEMBLY, 3/8 ATR Case								
	65-40514-28		CHASSIS ASSEMBLY, 3/8 ATR Case								
1	DS232-142		. DUST COVER, V94867 (preferred)								1
1	DS232-204		. DUST COVER, V94867 ▽								1
1	69-58863-4		. DUST COVER, ▽								1
2	NAS602-8P		. SCREW								4
3	22NM408-82		. NUT, V72962								4
4	HDH2		. HOOK, Chassis, V94867								2
5	NAS600-6P		. SCREW							a	2
5	NAS600-6P		. SCREW							b	3
6	NAS679A06W		. NUT, Self-locking							a	2
6	NAS679A06W		. NUT, Self-locking							b	3
7	65-40514-12		. PLATE ASSEMBLY, Front							a	1
7	65-40514-29		. PLATE ASSEMBLY, Front								1
8	69-31963-3		. . PLATE, Front								1
9	65-40514-14		. . MOUNTING ANGLE ASSEMBLY								1
10	65-40514-15		. . MOUNTING ANGLE								1
11	NAS698A06L		. . . NUTPLATE, V72962.								1
12	MS20426B3		. . . RIVET								2
13	MS20426D3		. . RIVET								2
14	BACS12CB3-8		. SCREW								2
15	MS35337-43		. WASHER.								2
16	SS9-30		. HANDLE, V08730 (preferred).								1
16	ABA9-30		. HANDLE, V08730 (optional)								1
17	NAS600-5P		. SCREW							b	4
18	NAS679A04W		. NUT, Self-locking							b	4
19	AN960-4		. WASHER.							b	4
20	69-40392-6		. ANGLE, Transformer support.							b	2
21	NAS601-7P		. SCREW							b	4
22	22NM408-62		. NUT, V72962 (preferred)							b	4
22	NAS679A06W		. NUT, Self-locking (optional).							b	4
23	69-40392-7		. ANGLE, Transformer support.							b	1
24	NAS514P440-6		. SCREW							b	3
25	NAS514P440-7		. SCREW							b	1
26	BACN10DN40		. NUT							b	4
27	69-40392-9		. ANGLE, Transformer support.							b	1
28	69-40392-10		. ANGLE, Transformer support.							b	1
29	MS20426D4		. RIVET								6
30	65-40514-13		. PLATE ASSEMBLY, Rear.								1
31	69-31960-1		. . PLATE, Rear								1
32	S3-150		. . FASTENER, Spring, V72794.								1

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FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	N O M E N C L A T U R E							USE CODE	QTY PER ASSY	
			1	2	3	4	5	6	7			
1104												
33	MS20426D3		.	.	RIVET	2
34	MS20426A3		.	.	RIVET	a	.	4
34	NAS514P440-4		.	.	SCREW	b	.	7
35	NAS679A04W		.	.	NUT, Self-locking	b	.	7
36	65-67384-1		.	.	SHELF, Window heat.	1
37	65-67384-4		.	.	PLATE, Side	b	.	1
37	65-40514-16		.	.	PLATE, Side	a	.	1

a used on 65-40514-11

b used on 65-40514-28

▷ optional for 737 Airplanes.

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VENDOR CODE

<u>Code</u>	<u>Name and Address</u>
V08524	Deutsch Fastener Corporation Los Angeles, California
V08730	Vemaline Products Co. 511 Commerce Street Franklin Lakes, New Jersey 07417
V71286	Camloc Fastener Corporation 22 Spring Valley Road Paramus, New Jersey 07652
V72794	Dzus Fastener Co., Inc. 425 Union Blvd. West Islip, New York 11795
V72962	Elastic Stop Nut Corporation of America 2330 Vauxhaul Road Union, New Jersey 07083
V94867	Churchill Corporation 344 Franklin Street Melrose, Massachusetts 02176