

TO: ALL HOLDERS OF PASSENGER SERVICE UNIT ASSEMBLY OVERHAUL MANUAL, 25-20-13

REVISION NO. 2, DATED JUL 1/02
HIGHLIGHTS

DESCRIPTION OF CHANGE	TOPICS AFFECTED												
	D & O	D / A s s y	C l e a n i n g	I n s p e c t / C h k	R e p a i r	A s s y	F / C	T e s t	T / S h o o t i n g	S / T o o l s	S t o r a g e	I P L	L / O v e r h a u l
Updated 61-23100-8 effectivity in Fig. 1101 Updated Fig. 1102 PSU assemblies as specified by the latest engineering Updated Fig. 1103 PSU assemblies as specified by the latest engineering Updated vendor name												X	
												X	
												X	
												X	

Jul 1/02

 25-20-13
 HIGHLIGHTS
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BOEING 
COMMERCIAL JET
OVERHAUL MANUAL

PASSENGER SERVICE UNIT ASSEMBLY

25-20-13

BOEING P/N 65-86413-57 thru -80

AIRLINE P/N

THE FOLLOWING DIRECTIVES APPLY TO THIS SUBJECT:

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVES	DATE DIRECTIVE INCORPORATED INTO TEXT
		PRR 17863 PRR 23605-44 PRR 32362	Apr 5/75 Apr 5/75 Apr 5/75

LIST OF EFFECTIVE PAGES

- * Indicates pages revised, added or deleted in latest revision
- F Indicates foldout pages - print one side only

PAGE	DATE	PAGE	DATE	PAGE	DATE
25-20-13					
T-1	Apr 5/75				
T-2	BLANK				
* LEP-1	Jul 1/02				
LEP-2	BLANK				
T/C-1	Apr 5/75				
T/C-2	BLANK				
401	Apr 5/75				
402	Apr 5/75				
1101	Apr 5/75				
1102	Mar 1/01				
* 1103	Jul 1/02				
1104	BLANK				
* 1105	Jul 1/02				
1106	Apr 5/75				
* 1107	Jul 1/02				
* 1108	Jul 1/02				
* 1109	Jul 1/02				
1110	Apr 5/75				
1111	Apr 5/75				
1112	Apr 5/75				
* 1113	Jul 1/02				
* 1114	Jul 1/02				
* 1115	Jul 1/02				
* 1116	Jul 1/02				
1117	Mar 1/01				
* 1118	Jul 1/02				

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*[1] Special instructions not required. This manual contains only refinish and replacement information and illustrated parts list. Use standard industry practices (Ref 25-20-00, Passenger Service Unit Overhaul Procedures).

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PASSENGER SERVICE UNIT ASSEMBLY

REPAIR

1. Repair

A. Materials

NOTE: Use listed material or equivalent substitute.

- (1) Fig. 1101 tape (75), Fig. 1102 (205) and Fig. 1103 (365) - 3 inches wide P32 vinyl tape (white), Permacel Division, Johnson and Johnson, Inc., U.S. Highway 1, New Brunswick, New Jersey 08901
- (2) Fig. 1102 and 1103 tape (5) - 0.75 to 1.0 inch wide P32 vinyl tape (white), Peracel Division, Johnson and Johnson, Inc., U.S. Highway 1, New Brunswick, New Jersey 08901

B. Refinish (Fig. 1101-1103)

CAUTION: DO NOT USE HI-SPEED LACQUER TO REFINISH POLYCARBONATE PLASTIC PARTS. IT WILL CAUSE INSTANT DETERIORATION THAT MAY NOT BE DETECTABLE VISUALLY.

NOTE: Refer to 20-30-02 for stripping of protective finishes, and to 20-41-01 for explanation of F and SRF finish codes.

- (1) Mount assembly Fig. 1101-1103 (105), apply Alodize SRF-2.30 all over.

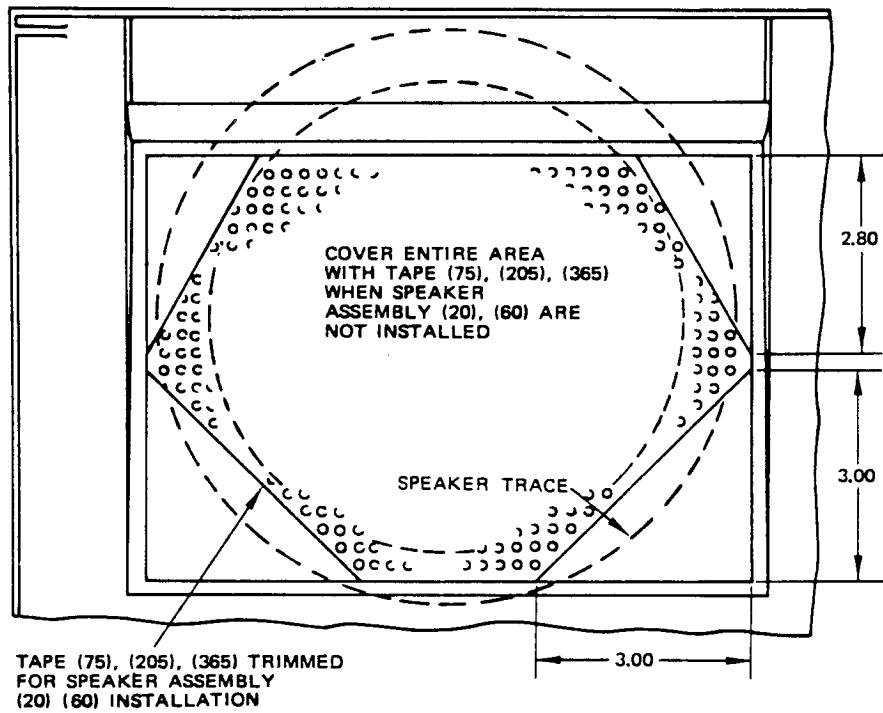
2. Replacement

A. Trim tape for units having speakers as per Fig. 401.

- (1) Paint speaker grille face after tape is applied, per customers color code, to cover tape adhesive exposed through speaker grille holes.

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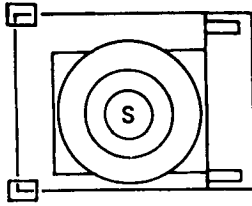


ALL DIMENSIONS ARE IN INCHES

Tape Application
Figure 401

ILLUSTRATED PARTS LIST

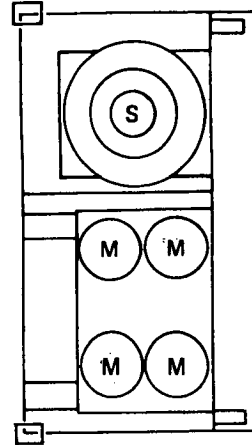
FIG. 1101



65-86413-57, 58, 63, 64 WITH SPEAKER
65-86413-65, -66 WITHOUT SPEAKER

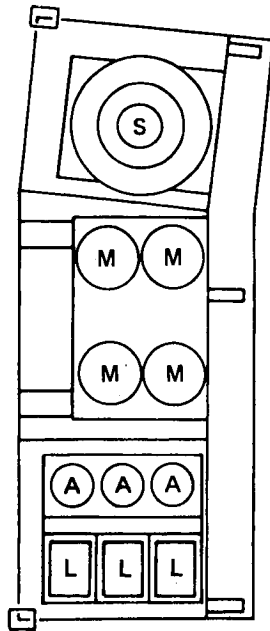
A = AIR OUTLET
L = LIGHT
M = MASK
S = SPEAKER

FIG. 1102

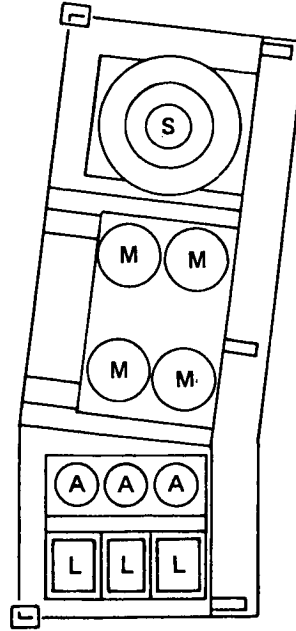


65-86413-59, -60, -67, -77, -78 WITH SPEAKER
65-86413-61, -62, -79, -80 WITHOUT SPEAKER

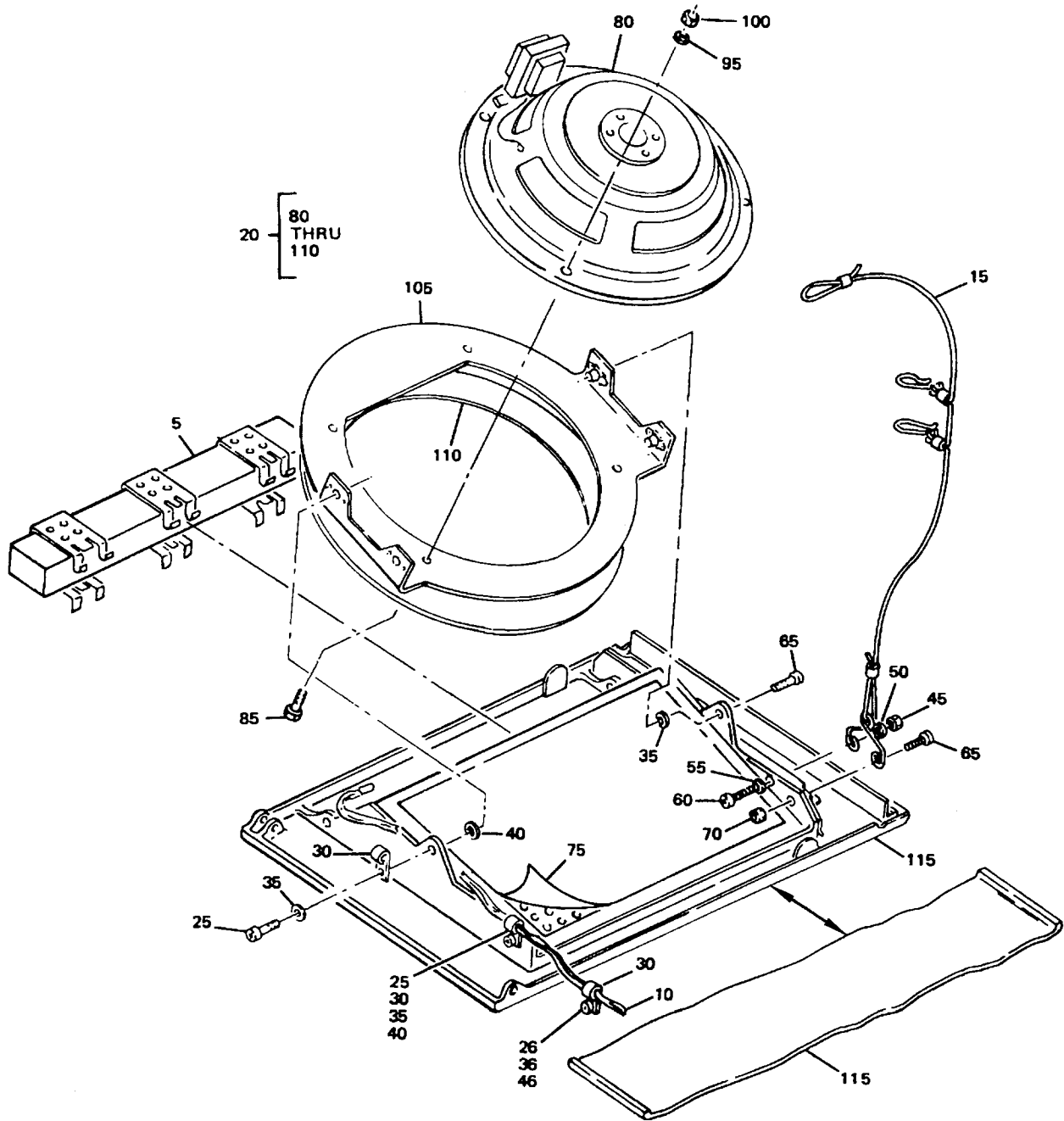
FIG. 1103



65-86413-72, -73 WITH SPEAKER
65-86413-74, -75 WITHOUT SPEAKER

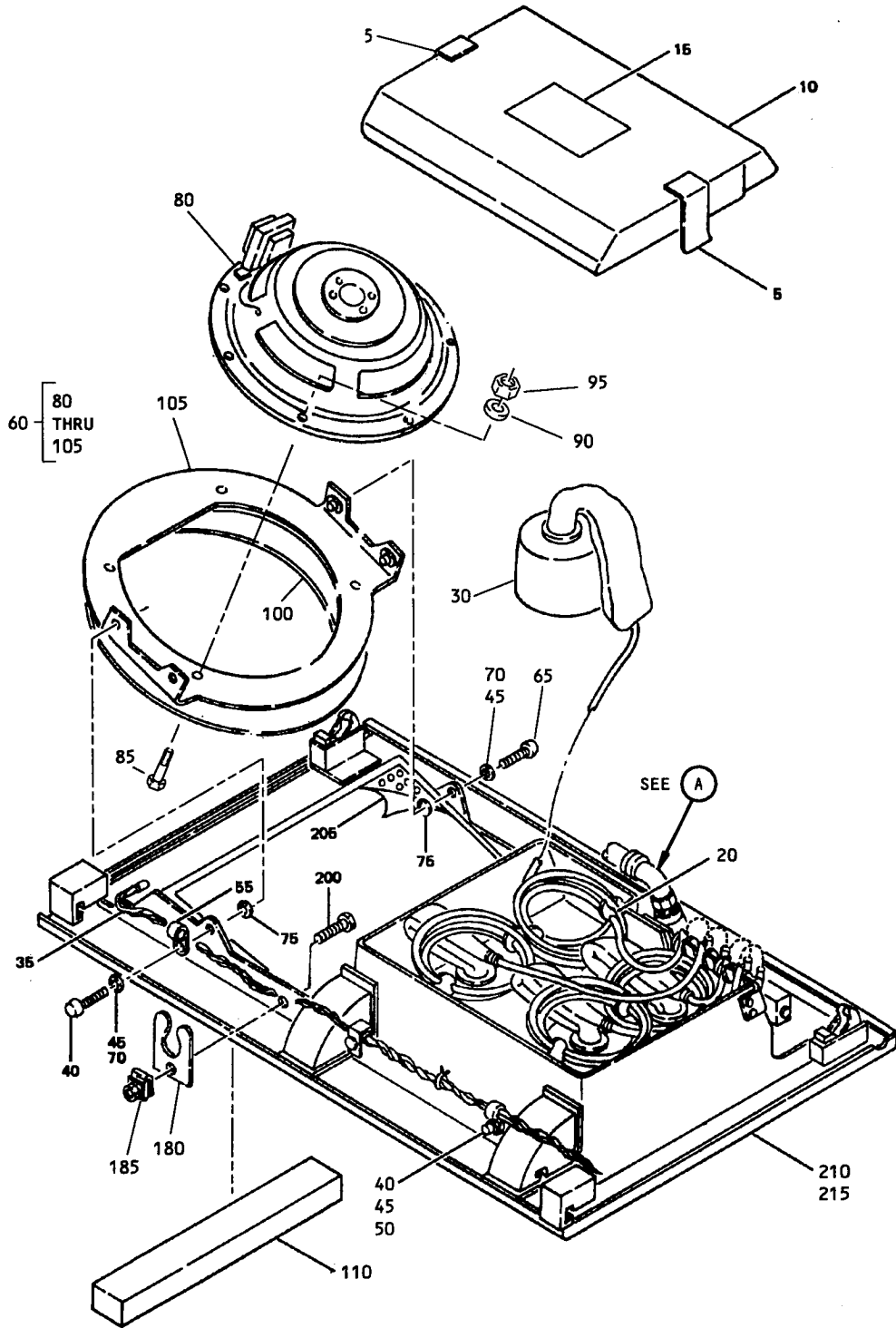


65-86413-68, -69, -76 WITH SPEAKER
65-86413-70, -71 WITHOUT SPEAKER



Passenger Service Unit Assembly
Figure 1101 (Sheet 2)

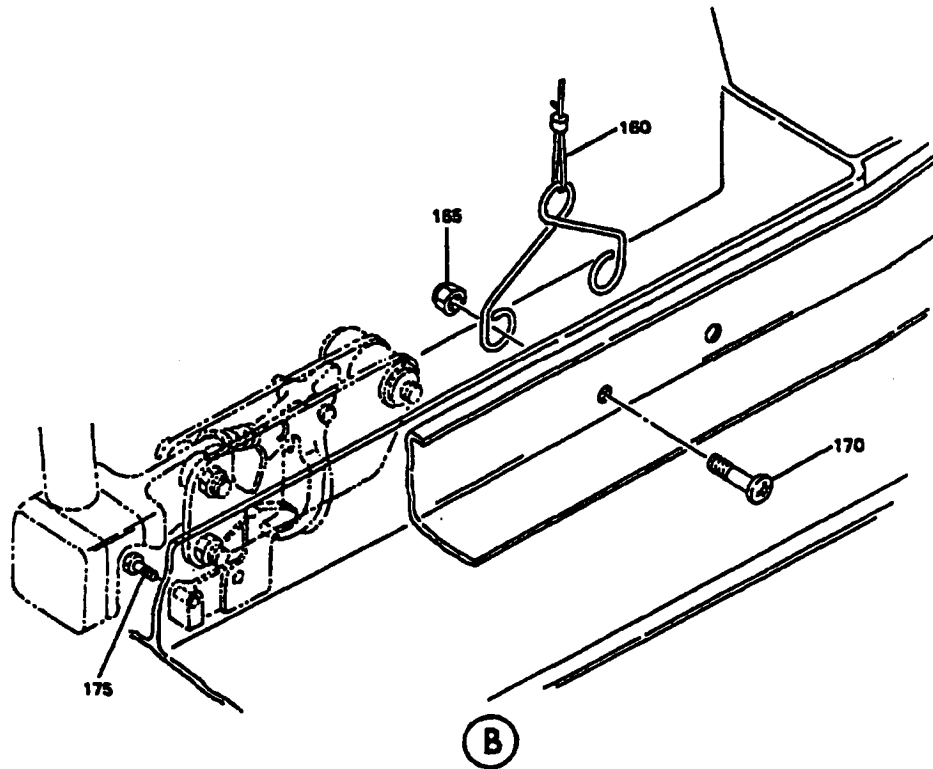
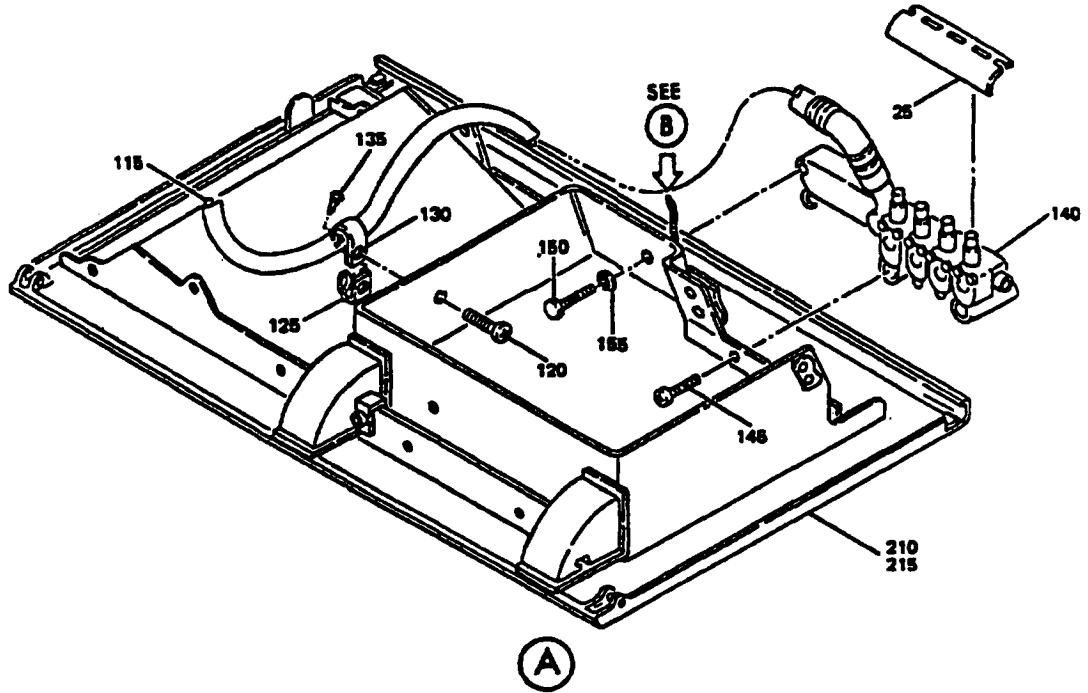
FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
1101-	65-86413-57		PASSENGER SERVICE UNIT ASSY FWD 1/3							A	REF
	65-86413-58		PASSENGER SERVICE UNIT ASSY FWD 1/3							D	REF
	65-86413-63		PASSENGER SERVICE UNIT ASSY FWD 1/3							B	REF
	65-86413-64		PASSENGER SERVICE UNIT ASSY FWD 1/3							E	REF
	65-86413-65		PASSENGER SERVICE UNIT ASSY FWD 1/3							C	REF
	65-86413-66		PASSENGER SERVICE UNIT ASSY FWD 1/3							F	REF
5	10-0040-113		. BASE, V72914 (BOEING 10-60781-113)							AD	1
5	800000095-1		. BASE, V05617 (BOEING 10-61892-1)							BCEF	1
10	61-23100-5		. WIRE BUNDLE (OPT)							AD	1
10	61-23100-8		. WIRE BUNDLE (PREF)							B-F	1
15	69-63824-1		. LANYARD ASSY (OPT)								1
15	69-63824-3		. LANYARD ASSY (PREF)								1
20	69-61466-4		. SPEAKER ASSY							ABDE	1
25	NAS601-7P		DELETED								
25	BACS12CB06-7P		. SCREW								2
26	BACS12CB08		. SCREW								2
30	BACC10DK		. CLAMP								4
35	AN960PD6L		. WASHER								4
36	AN960PD8		. WASHER								2
40	NAS549-8		. WASHER								AR
45	BACN10FX84		. NUT								1
46	BACN10JCB		. NUT								2
50	AN960D8L		. WASHER								1
55	NAS42DD6-48		. SPACER								1
60	NAS602-20P		DELETED								
60	BACS10CB08-20P		. SCREW								1
65	NAS601-8P		. SCREW								2
70	BACN10JC06		. NUT							CF	4
75	65-86413-26		. TAPE							CF	AR
80	C8TS-C8800		. . SPEAKER, V32001 (OPT)							ABDE	1
80	8-3282		. . SPEAKER, V26234 (OPT)							ABDE	1
80	8EU2986		. . SPEAKER, V07109 (PREF)							ABDE	1
85	NAS514P1032-10		DELETED								
85	NAS514P1032-9		. . SCREW								4
90	NAS43DD3-16		DELETED								
95	AN960C10L		. . WASHER								4
100	BACN10JC3		. . NUT								4
105	69-62320-1		. . MOUNT ASSY, SPEAKER								1
110	65-61466-3		. . TAPE SEALING								AR
115	65-86412-1		. BASIC PSU (REF 25-20-15)							A-C	1
115	65-86412-2		. BASIC PSU (REF 25-20-15)							D-F	1



Passenger Service Unit Assembly
Figure 1102 (Sheet 1)

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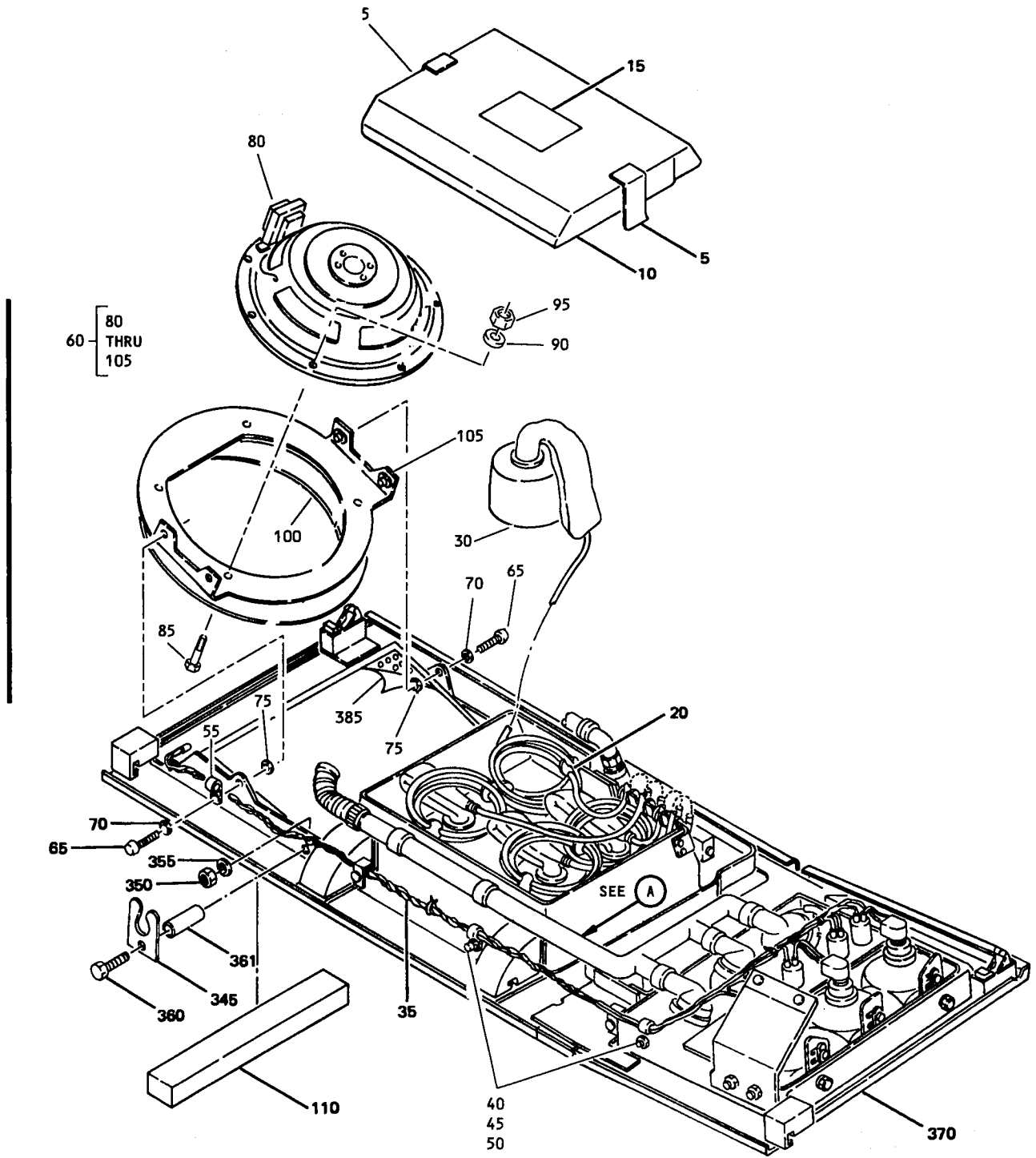
Passenger Service Unit Assembly
Figure 1102 (Sheet 2)

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
1102-	65-86413-59		PASSENGER SERVICE UNIT ASSY FWD 2/3							A	REF
	65-86413-60		PASSENGER SERVICE UNIT ASSY FWD 2/3							E	REF
	65-86413-61		PASSENGER SERVICE UNIT ASSY FWD 2/3							B	REF
	65-86413-62		PASSENGER SERVICE UNIT ASSY FWD 2/3							F	REF
	65-86413-67		PASSENGER SERVICE UNIT ASSY FWD 2/3							I	REF
	65-86413-77		PASSENGER SERVICE UNIT ASSY FWD 2/3							C	REF
	65-86413-78		PASSENGER SERVICE UNIT ASSY FWD 2/3							G	REF
	65-86413-79		PASSENGER SERVICE UNIT ASSY FWD 2/3							D	REF
	65-86413-80		PASSENGER SERVICE UNIT ASSY FWD 2/3							H	REF
5	65-86413-25		. TAPE							ABEFI	AR
10	65-80172-7		. COVER, OXYGEN BOX							A-D	1
10	65-80172-8		. COVER, OXYGEN BOX							E-I	1
15	BAC27DPA465		. PLACARD (ENGLISH)							A-I	1
20	63-10155		. COIL RETAINER							A-I	8
25	69-64747-1		. GUIDE TUBE							ACDEG HI	1
30	289-701-27		. MASK, OXYGEN, V92114 (BOEING 10-60137-49)							A-I	4
35	61-23100-8		. WIRE BUNDLE							A-I	1
40	NAS601-7P		. SCREW								2
40	BACS12CB08		. SCREW *[1]								2
45	AN960PD6L		. WASHER								2
45	AN960PD8		. WASHER *[1]								2
50	BACN10JC8		. NUT								2
55	BACC10DK		. CLAMP *[2]								5
60	69-61466-4		. SPEAKER ASSY							ACEGI	1
65	NAS601-6P		. SCREW								2
70	AN960PD6L		. WASHER								2
75	NAS549-8		. WASHER								AR
80	C8TSC8800		. . SPEAKER, V32001 (OPT)								1
80	8-3282		. . SPEAKER, V26234 (OPT)								1
80	8EU2986		. . SPEAKER, V07109 (PREF)								1
85	NAS514P1032-10		DELETED								
85	NAS514P1032-9		. . SCREW								4
86	NAS43DD3-16		DELETED								
90	AN960C10L		. . WASHER								4
95	BACN10JC3		. . NUT								4
100	65-61466-3		. . TAPE SEALING								AR
105	69-62320-1		. . MOUNT ASSY SPEAKER								1
110	800000095-1		. BASE, V05617 (BOEING 10-61892-1)							A-I	1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE							USE CODE	QTY PER ASSY	
			1	2	3	4	5	6	7			
1102-115	ZH833-39		.							HOSE, OXYGEN, V02217 (BOEING 10-60174-39)	ABEFI	1
115	37001-39		.							HOSE OXYGEN, V24984 (BOEING 10-60174-39)	ABEFI	1
115	ZH833-40		.							HOSE OXYGEN, V02217 (BOEING 10-60174-40)	CDGH	1
115	37001-40		.							HOSE OXYGEN, V24984 (BOEING 10-60174-40)	CDGH	1
120	NAS602-8P		.							SCREW		1
125	BACN10FX83		.							NUT		1
130	BACC10DK7		.							CLAMP		1
135	BACP20BA1		.							PLUG		1
140	115013-01		.							MANIFOLD ASSY, V16827 (BOEING 10-60513-7) (OPT TO 802078-00)	A-D	1
140	115013-02		.							MANIFOLD ASSY, V16827 (BOEING 10-60513-8) (OPT TO 802078-01)	E-H	1
140	115013-04		.							MANIFOLD ASSY, V16827 (BOEING 10-60513-10) (OPT TO 802078-03)	I	1
140	802078-00		.							MANIFOLD ASSY, V53655 (BOEING 10-60513-11) (OPT TO 115013-01)	A-D	1
140	802078-01		.							MANIFOLD ASSY, V53655 (BOEING 10-60513-12) (OPT TO 115013-02)	E-H	1
140	802078-03		.							MANIFOLD ASSY, V16827 (BOEING 10-60513-4) (OPT TO 115013-04)	I	1
145	BACS12CB3-22		.							SCREW (PREF)		2
145	NAS603-22P		.							SCREW (OPT)		2
150	BACS12CB3-20		.							SCREW (PREF)		1
150	NAS603-20P		.							SCREW (OPT)		1
155	MS35335-32		.							WASHER		1
160	69-63824-1		.							LANYARD ASSY (OPT)	A-I	1
160	69-63824-3		.							LANYARD ASSY (PREF)	A-I	1
165	BACN10JC08		.							NUT		2
170	NAS602-5P		.							SCREW		2
175	BACS12CB04-9		.							SCREW		2
180	69-64747-2		.							GUIDE TUBE	A-I	1
185	BACN10JC08		.							NUT	BDFH	1
200	NAS602-9P		.							SCREW	BDFH	1
205	65-86413-26		.							TAPE	BDFH	1
210	65-86412-7		.							BASIC ASSY, PSU (REF 25-20-15)	A-D	1
215	65-86412-8		.							BASIC ASSY, PSU (REF 25-20-15)	E-I	1

*[1] USE THREE NUTS, WASHER AND SCREWS WHEN SPEAKER IS NOT INSTALLED

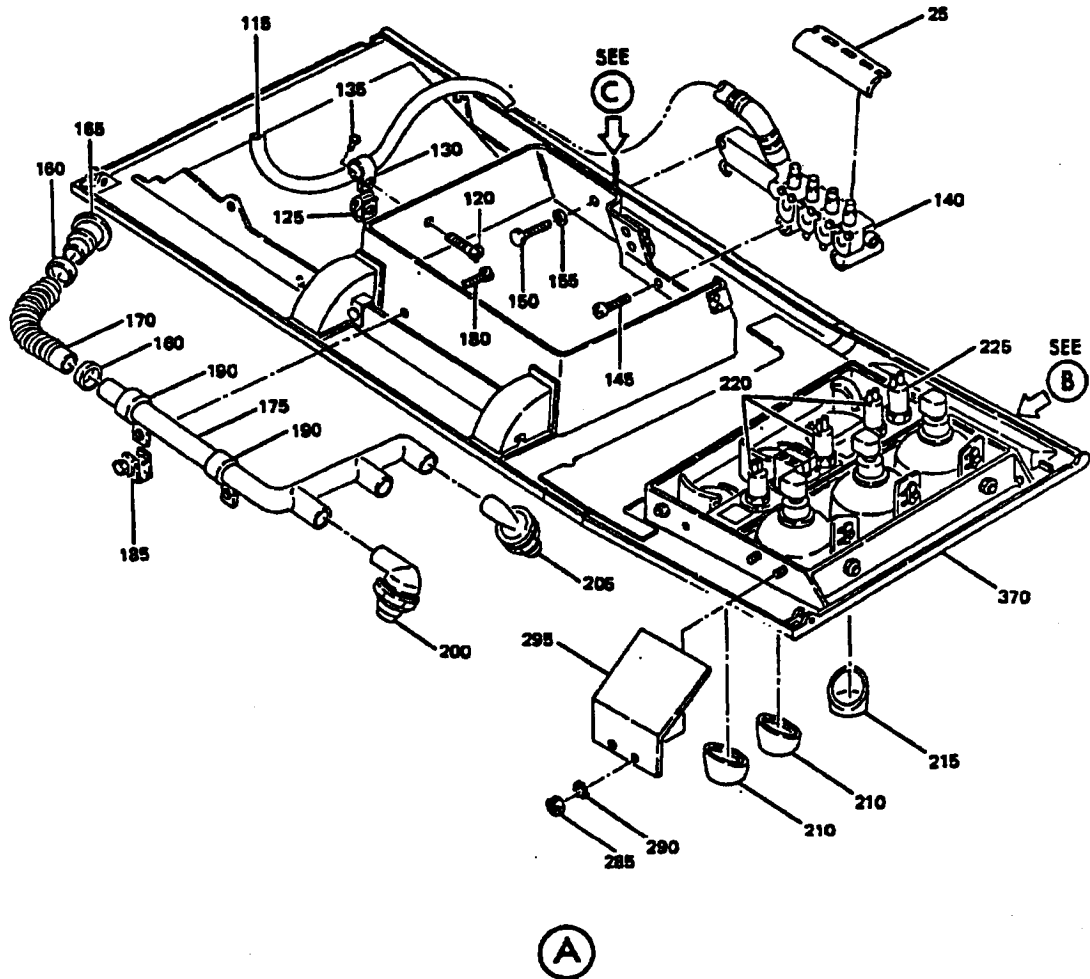
*[2] SIZE TO FIT



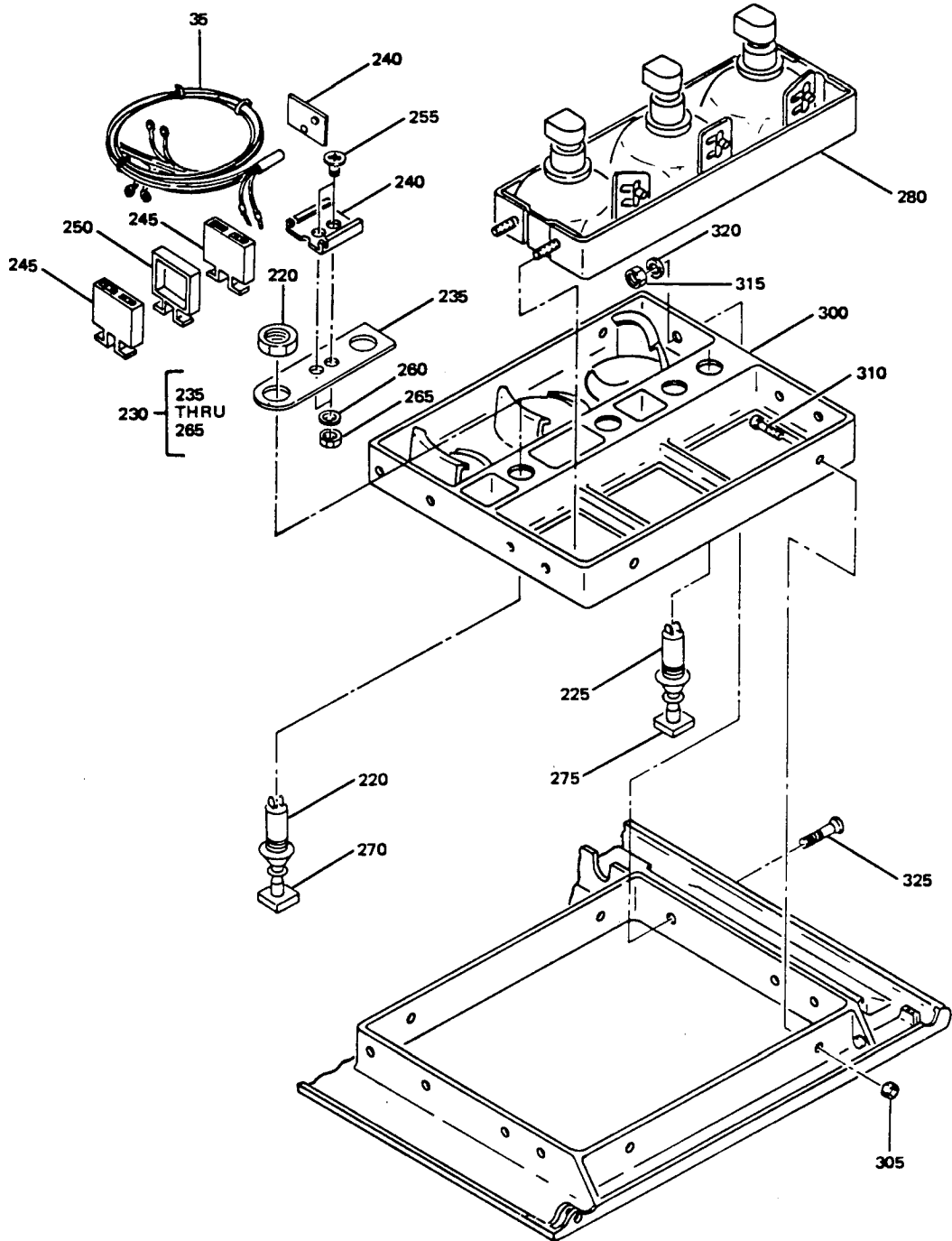
Passenger Service Unit Assembly
Figure 1103 (Sheet 1)

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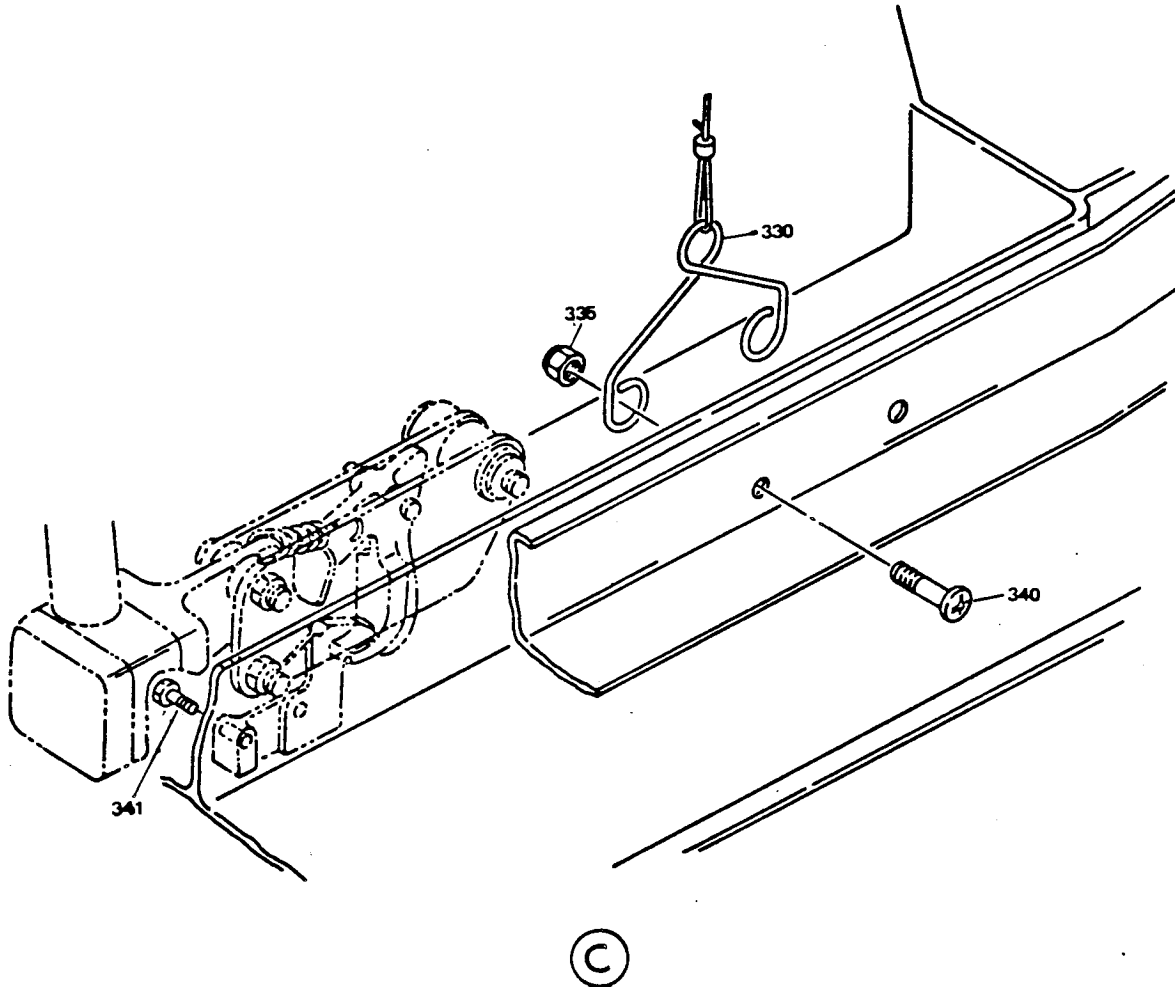
Passenger Service Unit Assembly
Figure 1103 (Sheet 2)



B

Passenger Service Unit Assembly
Figure 1103 (Sheet 3)

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Passenger Service Unit Assembly
Figure 1103 (Sheet 4)

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
1103-	65-86413-68		PASSENGER SERVICE UNIT ASSY LH							A	RF
	65-86413-69		PSU OPP -68							F	RF
	65-86413-70		PASSENGER SERVICE UNIT ASSY, LH							B	RF
	65-86413-71		PSU OPP -70							G	RF
	65-86413-72		PASSENGER SERVICE UNIT ASSY							C	RF
	65-86413-73		PSU OPP -72							H	RF
	65-86413-74		PASSENGER SERVICE UNIT ASSY							D	RF
	65-86413-75		PSU OPP -74							I	RF
	65-86413-76		PASSENGER SERVICE UNIT ASSY							E	RF
5	65-86413-25		. TAPE							A-I	AR
10	65-80172-7		. COVER, OXYGEN BOX							A-E	1
10	65-80172-8		. COVER, OXYGEN BOX							F-I	1
15	BAC27DPA465		. PLACARD (ENGLISH)							A-I	1
20	63-10155		. RETAINER COIL							A-I	8
25	69-64747-1		. GUIDE TUBE							A-I	1
30	289-701-27		. MASK, OXYGEN, V92116 (BOEING 10-60137-49)							A-I	4
35	61-23100-8		. WIRE BUNDLE							A-I	1
			ATTACHING PARTS								
40	BACS12CB08		. SCREW								2
40	BACS12CB08		. SCREW *[1]								2
45	AN960PD8		. WASHER								1
45	AN960PD8		. WASHER								1
50	BACN10JCB		. NUT *[1]								3
50	BACN10JCB		. NUT *[1]								
55	BACC10DK		. CLAMP *[2]								5
			-----*								
60	69-61466-4		. SPEAKER ASSY							ACEFH	1
			ATTACHING PARTS								
65	NAS601-6P		. SCREW								2
66	NAS601-7P		. SCREW								2
70	AN960PD61		. WASHER								4
75	NAS549-8		. WASHER								AR
			-----*								
80	C8TSC8800		. . SPEAKER, V32001 (OPT)								1
80	8-3282		. . SPEAKER, V26234 (OPT)								1
80	8EU2986		. . SPEAKER, V07109 (PREF)								1
			ATTACHING PARTS								
85	NAS514P1032-10		DELETED								
85	NAS514P1032-9		. . SCREW								4
86	NAS43DD3-16		DELETED								
90	AN960C10L		. . WASHER								4
95	BACN10JC3		. . NUT								4
			-----*								

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE							USE CODE	QTY PER ASSY	
			1	2	3	4	5	6	7			
1103-100	65-61466-3		.	.	.						AR	
105	69-62320-1		.	.	.							1
110	800000095-2		DELETED									
110	800000095-1		.							A-I		1
115	ZH833-39		.							A-D F-I		1
115	37001-39		.							A-D F-I		1
115	ZH833-40		.							E		1
115	37001-40		.							E		1
			ATTACHING PARTS									
120	NAS602-8P		.									1
125	BACN10FX83		.									1
130	BACC10DK7		.									1
135	BACP20BA1		.									1
			-----*-----									
140	115013-1		.							A-E		1
140	115013-2		.							F-I		1
140	802078-00		.							A-E		1
140	802078-01		.							F-I		1
			ATTACHING PARTS									
145	BACS12CB3-22		.									2
145	NAS603-22P		.									2
150	BACS12CB3-20		.									1
150	NAS603-20P		.									1
155	MS35335-32		.									1
			-----*-----									
160	6203		.							A-I		2
160	MS3367-4-9		.							A-I		2
165	69-64738-1		.							A-I		1
170	BE406-3		DELETED									
170	AD604-3		DELETED									
170	69-68932-1		.							A-I		1
170	69-68932-2		.							A-I		1
175	69-62660-2		.							A-I		1
			ATTACHING PARTS									
180	NAS602-8P		.									2
185	BACN10FX83		.									2

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE							USE CODE	QTY PER ASSY	
			1	2	3	4	5	6	7			
1103-190	BACC10DK12		.									2
			-----*									
200	116999-15C		.							A-I		2
205	120646-1C		.							A-I		1
210	65-79165-31		.							A-I		2
215	65-69165-32		.							A-I		1
220	710907-13A2		.							A-I		3
220	SW43853		.							A-I		3
225	710906-13A1		.							A-I		1
225	SW43830		.							A-I		1
230	69-65298-1		.							A-I		1
235	69-65258-1		.	.								1
240	AMY0110T8		.	.								1
245	BACM15C1A		.	.								2
250	YHLZ1C8		.	.								1
255	BACR15DA6-2		.	.								2
255	NAS602-7		.	.								2
260	AN960PD8L		.	.								2
265	BACN10JC08		.	.								2
270	691212-13A1-1		.							A-I		3
270	VIP720-6		.							A-I		3
275	690623A1-4		.							A-I		1
275	VIP720-8		.							A-I		1
280	10-0429-1		.							A-E		1
280	10-0429-2		.							F-I		1
285	MS25649-282		.									4
285	BACN10JC08		.									4
290	MS35335-31		.									4
295	69-65414-1		.							A-I		1
300	65-79165-5		.							A-E		1
300	65-79165-6		.							F-I		1
305	BACN10JC08		.									4
310	NAS514P832-5P		.									4
315	BACN10JC06		.									1
320	AN960PD6L		.									1
325	NAS601-8P		.									1
330	69-63824-1		.							A-I		1

REFERENCE DESIGNATION INDEX (SEE SCHEMATIC DIAGRAM 25-20-00)		
REFERENCE DESIGNATION	PART NUMBER	ITEM NO., FIG. NO.
D600P	BACC45FT14-15P	---
D3100	67-907	---
L3000	10-0429-1	280 (1103)
L3001	10-0429-2	280 (1103)
L3002	800000095-1	5 (1101), 110 (1102,1103)
	800000095-2	110 (1102,1103)
M3001	C8TS-C8800	80 (1101-1103)
M3001	8-3282	80 (1101-1103)
S3000	710906-13A1	225 (1103)
S3001-S3003	710907-13A2	220 (1103)
T3000	69-65298-1	225 (1103)

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VENDORS

V02217 PURITAN-ZEP DIV. OF PURITAN EQUIPMENT, INC., 111 PENN ST., EL SEGUNDO,
CALIFORNIA 90245

V05399 BEMCO, INC., P.O. BOX 68, CENTERTON, ARIZONA 72719

V05617 BELL INDUSTRIES, FARWEST MFG. DIV., 12410 S.E. 32ND ST., BELLEVUE,
WASHINGTON 98005

V07109 MITEK CORP., 704 30TH ST., MONROE, WISCONSIN 53566-3522

V09922 BURNDY CORP., RICHARDS AVE, NORWALIC, CONNECTICUT 06852

V16827 PURITAN EQUIPMENT, INC., 10800 PFLUM RD, LENEXA, KANSAS 66211

V17744 LUMNATOR DIV., GULTON INDUSTRIES, INC., 1200E DALLAS N. PARKWAY,
PLANO, TEXAS 75074

V21868 H.K. PORTER CO., INC., THEMOID DIV., GOVERNMENT SALES OFFICE,
601 GRAM ST., 1627 PORTER BLDG, PITTSBURG, PENNSYLVANIA 15219

V24984 HYDRA-FLOW SUPPLY, INC., 5341 SHEILA ST., LOS ANGELES, CALIFORNIA 90040

V26234 CTS OF PADUCAH, INC., 1565 N. 85TH ST., PADUCAH, KENTUCKY 42001

V32001 JENSEN MFG. DIV., THE MUTER CO., 5655 W 73RD ST, CHICAGO, ILLINOIS 60638

V53655 SCOTT AVIATION, 225 ERIE ST., LANCASTER, NEW YORK 14086-9502

V72914 GRIMES MFG CO., 515 N. RUSSELL, URBANA, OHIO 43078

V81646 IDEAL CORP., P.O. BOX 8827, CHURCH ST, STATION, NEW YORK, NEW YORK
10049

V92114 SIERRA ENGINEERING CO., 123 E. MONTECITO AVE., SIERRA MADRE,
CALIFORNIA 91024

V97564 CLARE-PENDAR, INC., P.O. BOX 785, POST FALLS, IDAHO 83854