

BOEING 
COMMERCIAL JET
OVERHAUL MANUAL

TO: ALL HOLDERS OF PASSENGER SERVICE UNIT BASIC SHELL ASSEMBLY OVERHAUL MANUAL,
 25-20-15

REVISION NO. 1 DATED NOV 10/80

HIGHLIGHTS

DESCRIPTION OF CHANGE	TOPICS AFFECTED												
	D & O	D/Assy	Cleaning	Insp/Chk	Repair	Assy	F/C	Test	T/Shooting	S/Tools	Storage	IPL	L/Overhaul
Changed quantity of latch assy 65-85901-2												X	

BOEING 
COMMERCIAL JET
OVERHAUL MANUAL

PASSENGER SERVICE UNIT BASIC SHELL ASSY

25-20-15

BOEING P/N 65-86412-1 THRU -10, -21 THRU -24

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

Apr 5/75

25-20-15
Page T-1

BOEING 
COMMERCIAL JET
OVERHAUL MANUAL

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
25-20-15					
T-1	Apr 5/75				
T-2	BLANK				
* LEP-1	Nov 10/80				
LEP-2	BLANK				
T/C-1	Apr 5/75				
T/C-2	BLANK				
1	Apr 5/75				
2	Dec 25/75				
3	BLANK				
4	Apr 5/75				
5	Apr 5/75				
6	Apr 5/75				
7	Apr 5/75				
8	Apr 5/75				
9	Apr 5/75				
10	Apr 5/75				
11	Apr 5/75				
12	Apr 5/75				
* 13	Nov 10/80				
* 14	Nov 10/80				
15	Apr 5/75				
16	Apr 5/75				
17	Apr 5/75				
18	Apr 5/75				
19	Apr 5/75				
20	Apr 5/75				
21	Apr 5/75				
22	BLANK				

BOEING 
COMMERCIAL JET
OVERHAUL MANUAL

TABLE OF CONTENTS

<u>Paragraph Title</u>	<u>Page</u>
Description and Operation	*
Disassembly	*
Cleaning.	*
Inspection/Check.	1
Repair.	2
Assembly.	*
Fits and Clearances (not applicable)	
Testing	*
Trouble Shooting.	*
Storage Instructions.	*
Special Tools, Fixtures, and Equipment (not applicable)	
Illustrated Parts List.	4

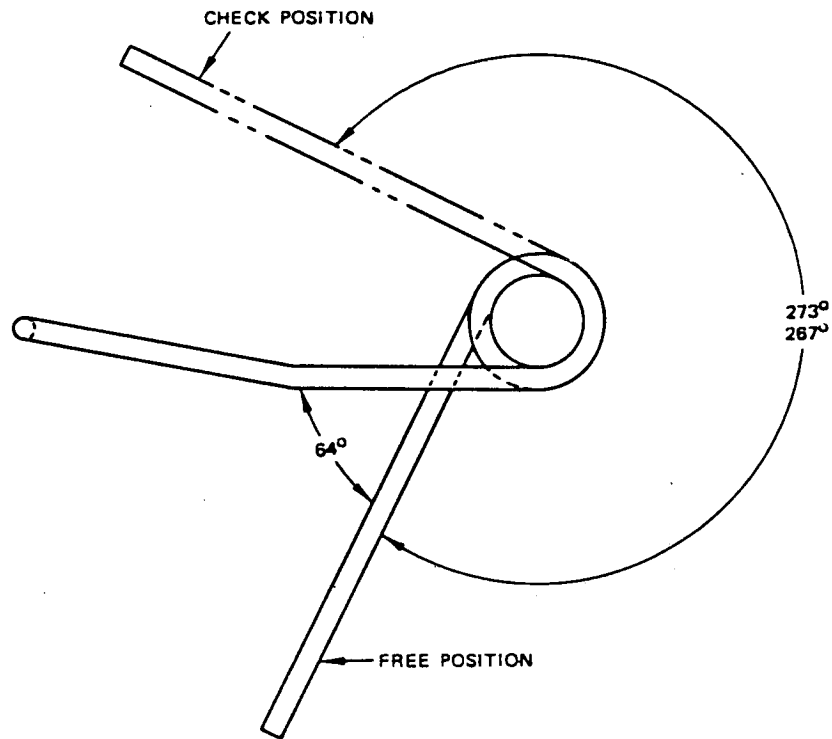
*This manual contains only inspection/check, refinish information, and illustrated parts list. All other approved procedures for this unit are in 25-20-00, Passenger Service Unit Overhaul Procedures.

BOEING 
COMMERCIAL JET
OVERHAUL MANUAL

PASSENGER SERVICE UNIT BASIC SHELL ASSEMBLY

1. INSPECTION/CHECK

- A. Check spring (270, Fig. 2, 3, 4) for free position indicated in Fig. 1, and for a deflection of 267 to 273 degrees under a load of 1.0 pound-inch.



Spring Check Diagram
Figure 1

BOEING 
COMMERCIAL JET
OVERHAUL MANUAL

65-86412

2. REPAIR

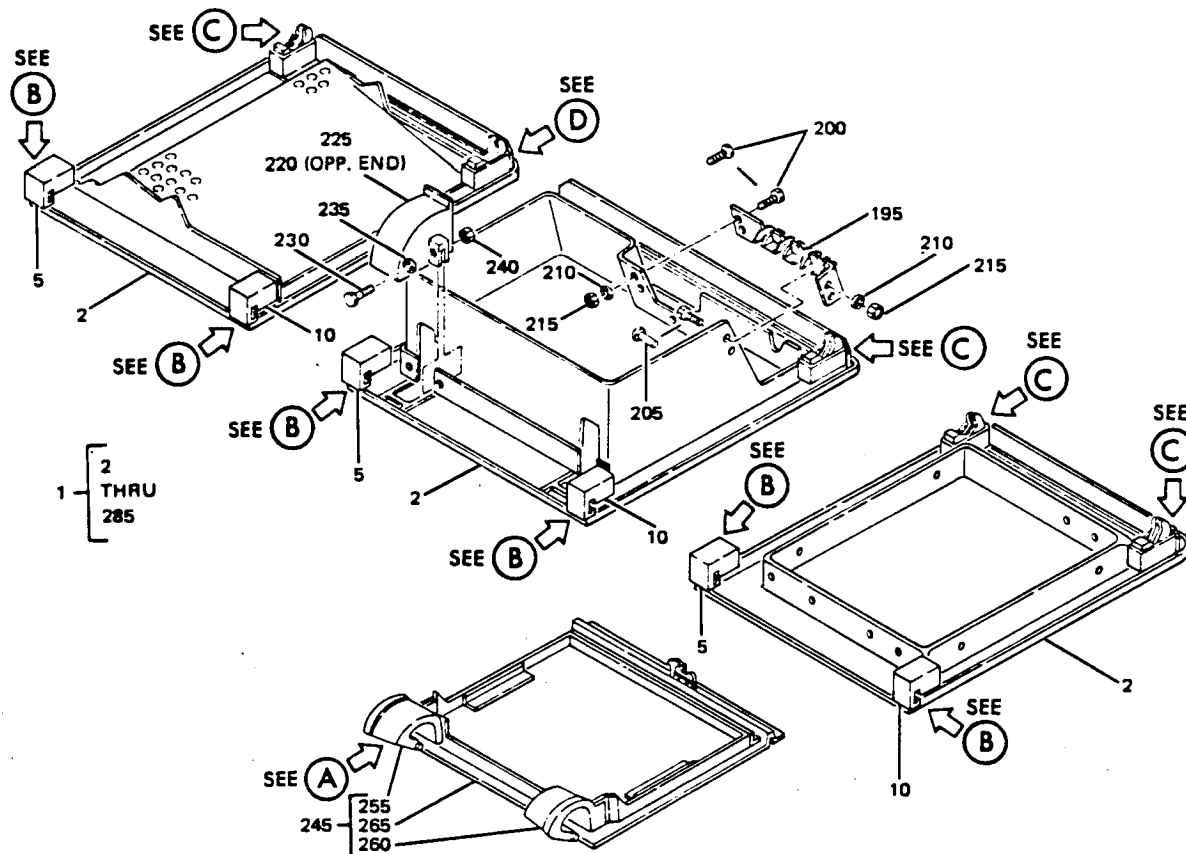
A. Refinish (Fig. 2, 3, 4)

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

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

- (1) Plunger (55, 135), body (85, 95, 130, 140), link (90) -- Chromic acid anodize (F-2.26) all over. Material: Al alloy.
- (2) Bolt (125) -- Cadmium plate per 20-42-05, type 2, class 2 (F-1.1926) all over. Material: Steel, AMS 4340, 125-145 ksi.
- (3) Support (150) -- Alodize (colored film) or chronic acid anodize followed by one coat EMS 10-11, type 1 primer (SRF-2.30) all over. Optional: Alodize (colored film) (F-2.21) all over. Material: Al alloy.
- (4) Spring (270) -- Cadmium plate, per 20-42-05, type 2, class 2. Material: Steel music wire.

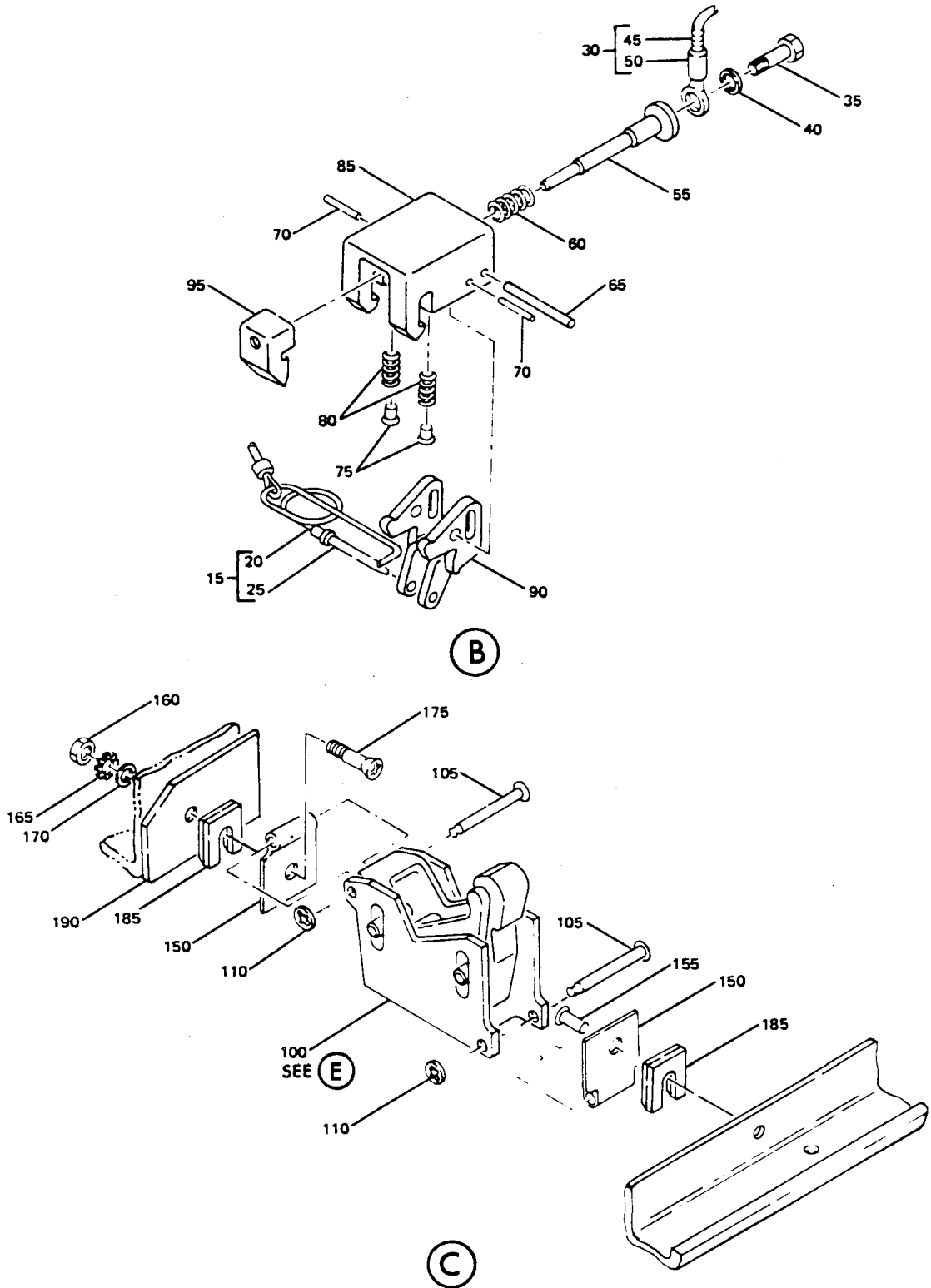
3. ILLUSTRATED PARTS LIST



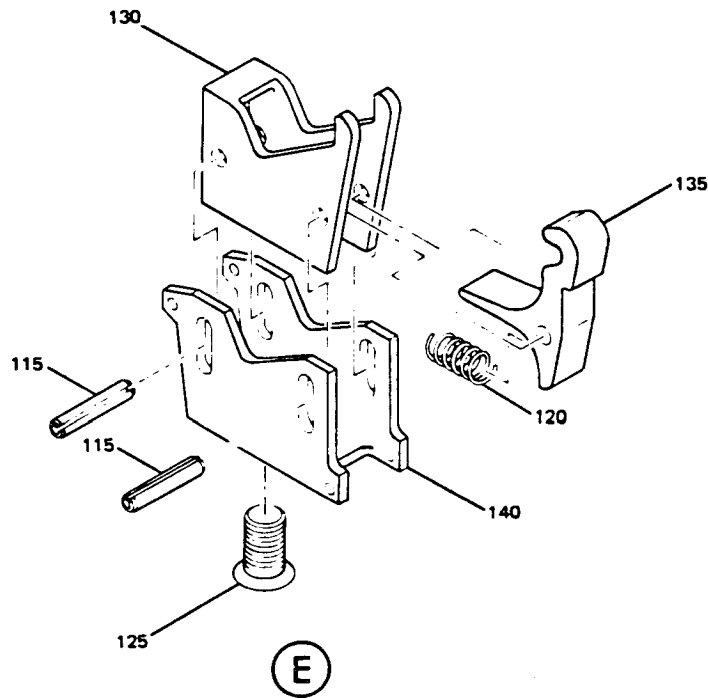
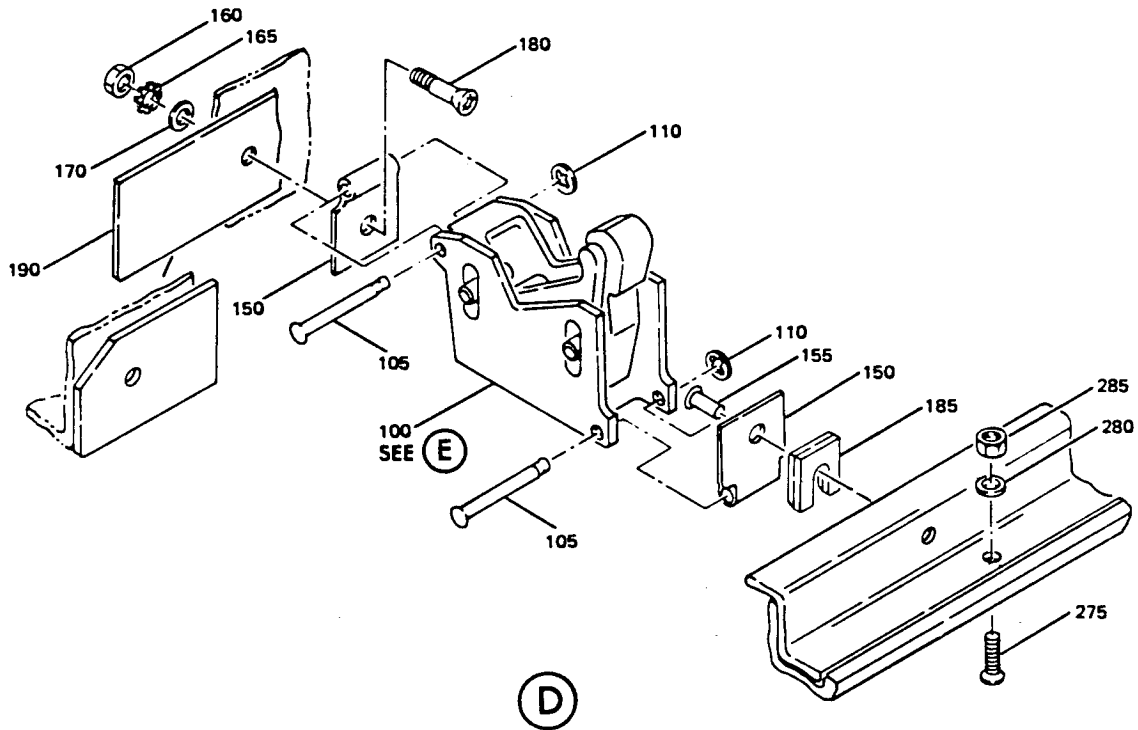
(A)

Basic Shell Assembly
 Figure 2 (Sheet 1)

BOEING 
COMMERCIAL JET
OVERHAUL MANUAL



Basic Shell Assembly
Figure 2 (Sheet 2)



Basic Shell Assembly
Figure 2 (Sheet 3)

BOEING 
COMMERCIAL JET
OVERHAUL MANUAL

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		
2-	65-86412-1		SHELL ASSY FWD 1/3							A	RF
	65-86412-2		SHELL ASSY FWD 1/3							B	RF
	65-86412-3		SHELL ASSY CENTER 1/3							C	RF
	65-86412-4		SHELL ASSY CENTER 1/3							D	RF
	65-86412-5		SHELL ASSY AFT 1/3							E	RF
	65-86412-6		SHELL ASSY AFT 1/3							F	RF
1	65-86412-27		. SHELL ASSY FWD 1/3							A	1
1	65-86412-28		. SHELL ASSY FWD 1/3							B	1
1	65-86412-29		. SHELL ASSY CENTER 1/3							C	1
1	65-86412-30		. SHELL ASSY CENTER 1/3							D	1
1	65-86412-31		. SHELL ASSY AFT 1/3							E	1
1	65-86412-32		. SHELL ASSY AFT 1/3							F	1
2	65-86412-11		. . . BASIC SHELL FWD 1/3							A	1
2	65-86412-12		. . . BASIC SHELL FWD 1/3							B	1
2	65-86412-13		. . . BASIC SHELL CENTER 1/3							C	1
2	65-86412-14		. . . BASIC SHELL CENTER 1/3							D	1
2	65-86412-15		. . . BASIC SHELL AFT 1/3							E	1
2	65-86412-16		. . . BASIC SHELL AFT 1/3							F	1
2	65-86412-25		. . . END CAP							E	1
2	65-86412-26		. . . END CAP							F	1
5	65-8900-1	 CLAMP ASSY OUTBD SUPPORT							A-F	1
10	65-8900-2	 CLAMP ASSY OUTBD SUPPORT							A-F	2
15	69-64539-1	 PIN ASSY								2
20	69-64539-2	 RETAINER, SPRING								2
25	69-64539-3	 PIN								2
30	69-61465-5	 LANYARD ASSY ATTACHING PARTS								2
35	NAS1191-06P4L	 SCREW								2
40	AN960PD6	 WASHER								2
			-----*								
45	69-61465-6	 CORD, NYLON								1
50	BACT12AC8	 LUG TERMINAL								1
55	65-85905-1	 PLUNGER								1
60	RCS3290	 SPRING, V08205								1
65	NAS607-2-8P	 PIN								1
70	NAS607-1-4P	 PIN								2
75	65-85900-3	 PLUNGER, SPRING								2
80	RCS3289	 SPRING, V08205								2
85	65-85904-1	 BODY, CLAMP								1
90	65-85902-1	 LINK, ROCKER								1
95	65-85903-1	 BODY, PLUNGER (USED ON 65- 859001-1)								1

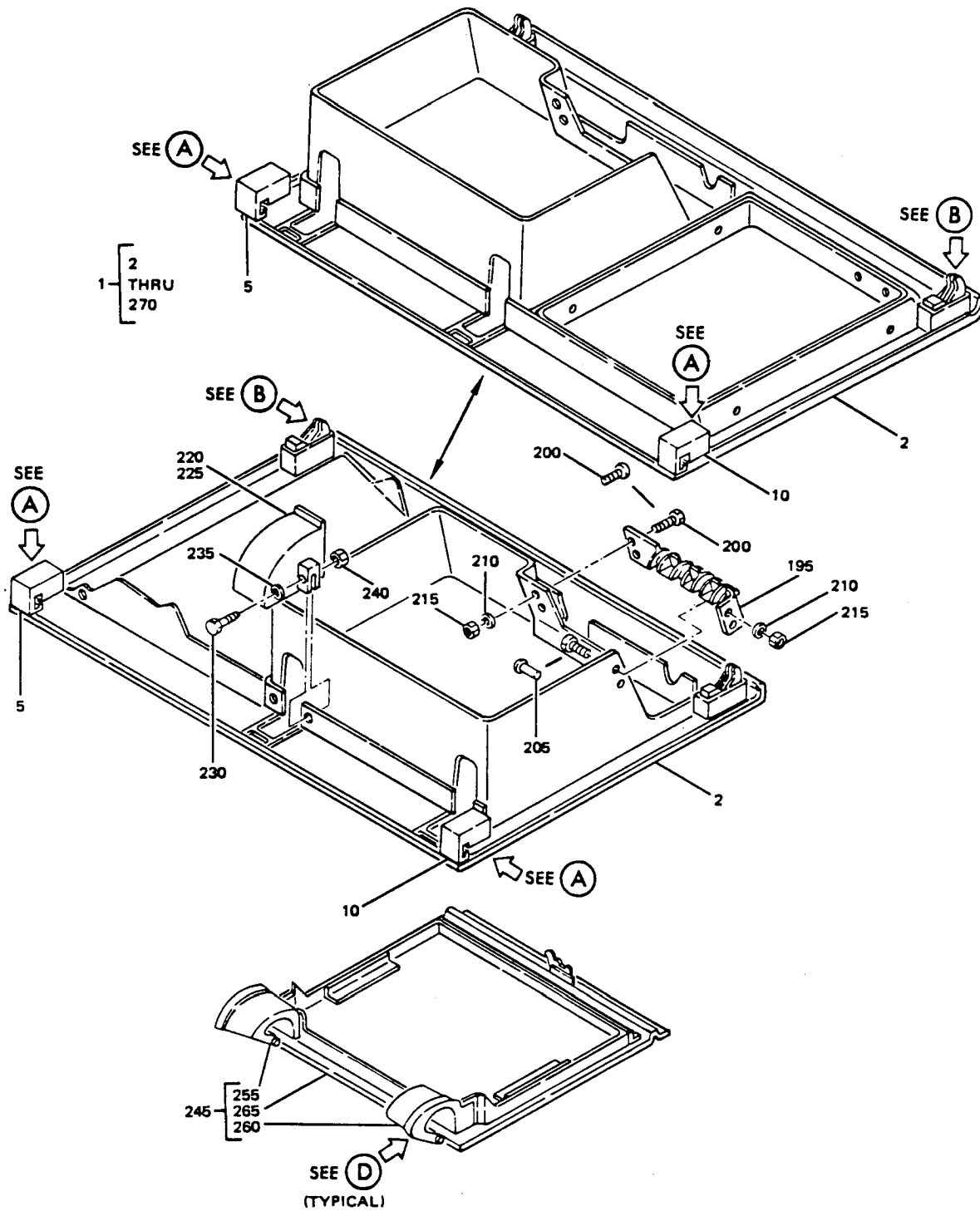
BOEING 
COMMERCIAL JET
OVERHAUL MANUAL

65-86412

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		
2-95	65-85903-2			1
100	65-85901-2		A-F	2
105	BACR15BB3D11		A-F	4
110	6100-9		A-F	4
115	MS16562-35		A-F	4
120	RCS3288			1
125	65-85905-3			1
130	65-85907-1			1
135	65-85908-1			1
140	65-85906-1			1
150	69-64895-1		A-F	4
155	BACR15BA6AD		A-F	2
			-----*								
160	MS35649-282			2
165	MS35335-31			2
170	AN960PD8			2
175	NAS514P832-8		AB	1
175	NAS514-P832-8		CD	2
180	NAS514-P832-6			
185	66-25727-1		A-D	4
185	66-25727-1		E-F	2
190	69-65405-1		AB,EF	2
195	65-79165-21			1
195	65-79165-22			1
200	NAS514P632-6		CD	2
200	BACR15DA4CH		CD	2
205	NAS601-6P		CD	2
205	NAS601-6B		CD	2
205	BACR15DA4H		CD	2
210	NAS620-6L		CD	4
215	BACN10JC06		CD	4
220	65-79165-51		CD	1
225	65-79165-52		CD	1
				
230	NAS623-2-5			4
235	NAS620-8L			4
240	BACN10JC08			4
			-----*								

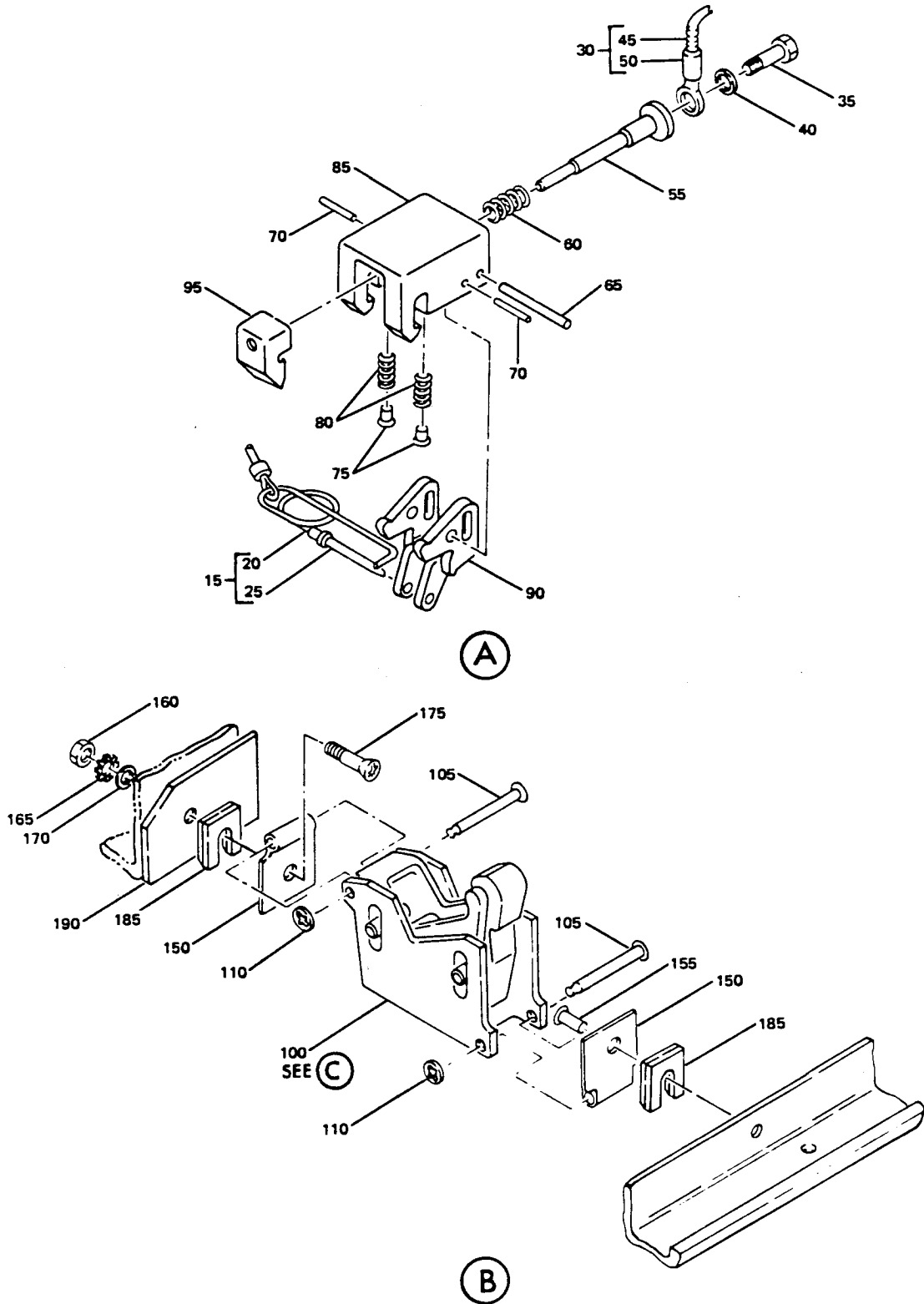
BOEING 
COMMERCIAL JET
OVERHAUL MANUAL

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		
2-											
245	65-79165-41		.	.	.	DOOR	ASSY			C	1
245	65-79165-42		.	.	.	DOOR	ASSY			D	1
						ATTACHING PARTS					
250	MS20253-3-124		.	.	.	HINGE	PIN				2
						-----*					
255	65-79165-53		.	.	.	HINGE					1
260	65-79165-54		.	.	.	HINGE					1
265	65-79165-43		.	.	.	DOOR			E		1
265	65-79165-44		.	.	.	DOOR			D		1
270	69-61458-1		.	.	.	SPRING					2
275	NAS514F440-6		.	.	.	SCREW					2
280	AN960D4L		.	.	.	WASHER					2
285	BACN10JC04		.	.	.	NUT					2



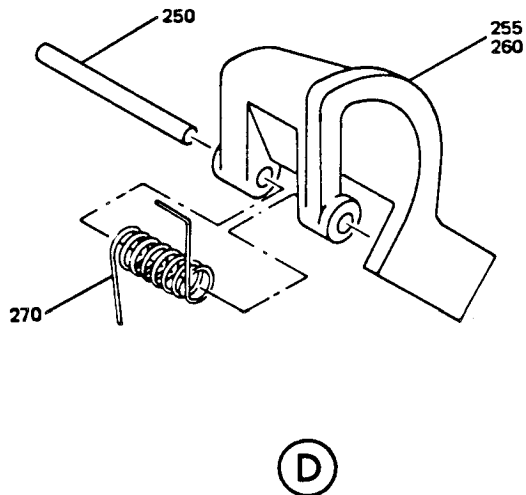
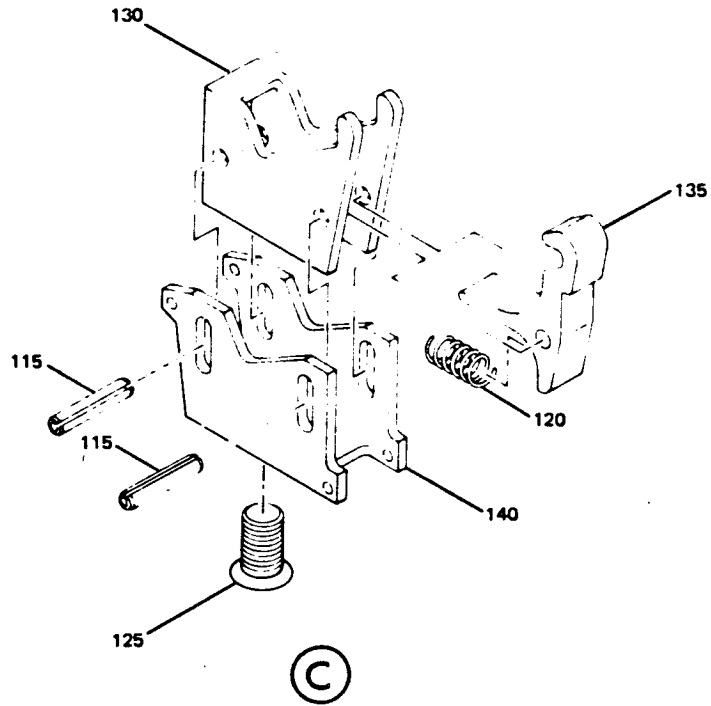
Basic Shell Assembly
 Figure 3 (Sheet 1)

BOEING 
COMMERCIAL JET
OVERHAUL MANUAL



Basic Shell Assembly
 Figure 3 (Sheet 2)

Apr 5/75



BOEING 
COMMERCIAL JET
OVERHAUL MANUAL

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	N O M E N C L A T U R E							USE CODE	QTY PEP ASSY
			1	2	3	4	5	6	7		
3-	65-86412-7		PASSENGER SERVICE UNIT, SHELL ASSY FWD 2/3							A	REF
	65-86412-8		PASSENGER SERVICE UNIT, SHELL ASSY FWD 2/3							B	REF
	65-86412-9		PASSENGER SERVICE UNIT, SHELL ASSY AFT 2/3							C	REF
	65-86412-10		PASSENGER SERVICE UNIT, SHELL ASSY AFT 2/3							D	REF
1	65-86412-33		. SHELL ASSY FWD 2/3							A	1
1	65-86412-34		. SHELL ASSY FWD 2/3							B	1
1	65-86412-35		. SHELL ASSY AFT 2/3							C	1
1	65-86412-36		. SHELL ASSY AFT 2/3							D	1
2	65-86412-17		. . . BASIC SHELL FWD 2/3							A	1
2	65-86412-18		. . . BASIC SHELL FWD 2/3							B	1
2	65-86412-19		. . . BASIC SHELL AFT 2/3							C	1
2	65-86412-20		. . . BASIC SHELL AFT 2/3							D	1
5	65-8900-1	 CLAMP ASSY, OUTBD SUPPORT							A-D	1
10	65-8900-2	 CLAMP ASSY, OUTBD SUPPORT							A-D	1
15	69-64539-1	 PIN ASSY								1
20	69-64539-2	 RETAINER, SPRING								1
25	69-64539-3	 PIN								1
30	69-61465-5	 LANYARD ASSY								1
			ATTACHING PARTS								
35	NAS1191-06P4L	 SCREW								1
40	AN960PD6	 WASHER								1
			-----*-----								
45	69-61465-6	 CORD, NYLON								1
50	BACT12AC8	 LUG TERMINAL								1
55	65-85905-1	 PLUNGER								1
60	RCS3290	 SPRING, V08205								1
65	NAS607-28P	 PIN								1
70	NAS607-1-4P	 PIN								2
75	65-85900-3	 PLUNGER, SPRING								2
80	RCS3289	 SPRING, V08205								2
85	65-85904-1	 BODY, CLAMP								1
90	65-85902-1	 LINK ROCKER								1
95	65-85903-1	 BODY, PLUNGER (USED ON 65- 859001-1)								1
95	65-85903-1	 BODY, PLUNGER (USED ON 65- 859001-2)								1
100	65-85901-2		. . . LATCH ASSY, INBD							A-D	2
105	BACR15BB3D11		. . . RIVET								4

BOEING **COMMERCIAL JET**
OVERHAUL MANUAL

65-86412

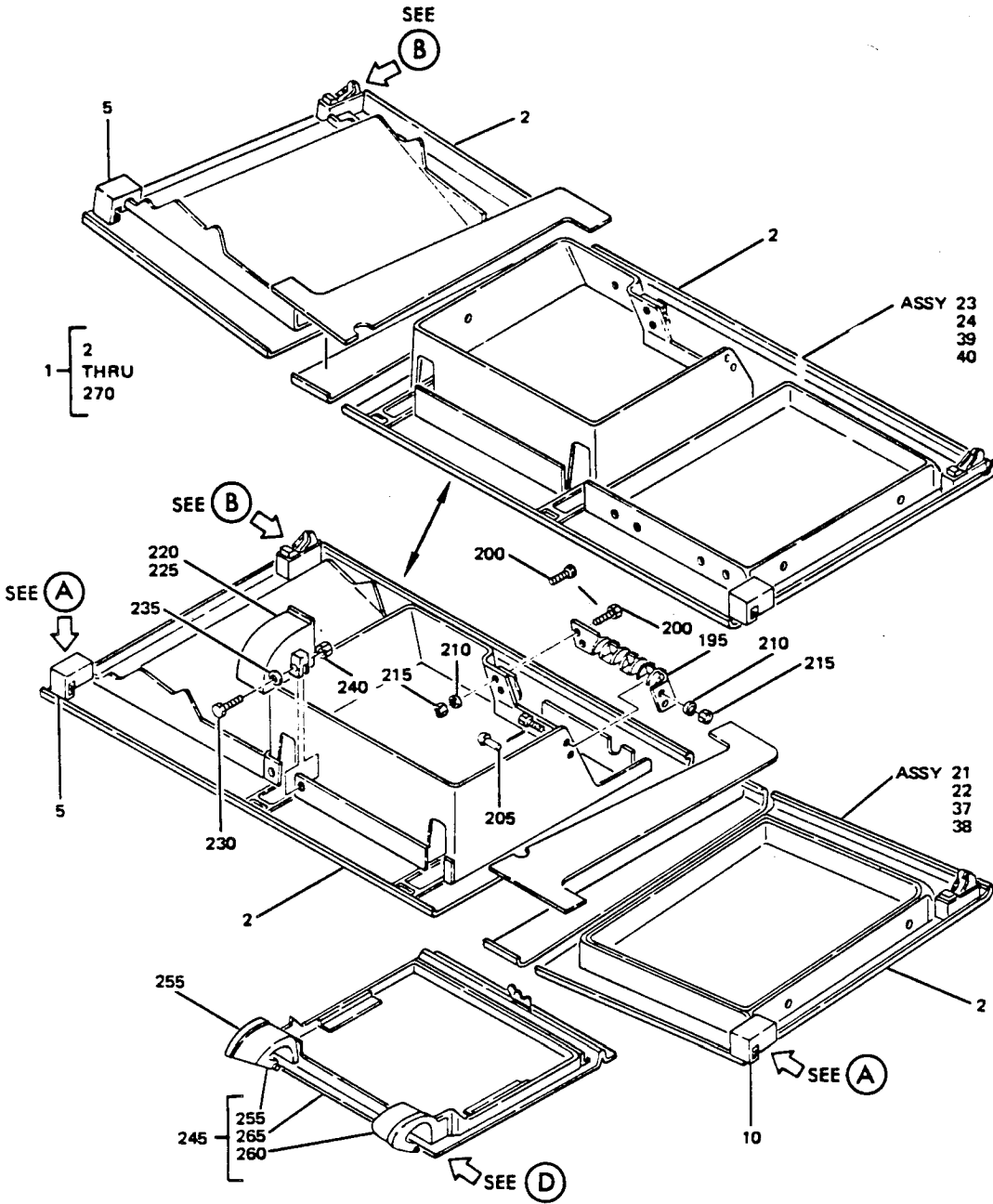
FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	N O M E N C L A T U R E							USE CODE	QTY PER ASSY		
			1	2	3	4	5	6	7				
3-110	6100-9			4	
115	MS16562-35			2	
120	RCS3288			1	
125	65-85905-3			1	
130	65-85907-1			1	
135	65-85908-1			1	
140	65-85906-1			1	
150	69-64895-1			2	
155	BACR15BA6AD			2	
155	BACR15BA6AD			2	
			-----*-----										
160	MS35649-282			2	
165	MS35335-31			2	
170	AN960PD-8			2	
175	NAS514P832-8		A-D	1	
185	66-25727-1		A-D	2	
190	69-65405-1			1	
190	69-61459-5			1	
195	65-79165-21		A,C	1	
195	65-79165-22		B,D	1	
				ATTACHING PARTS	
200	NAS514P632-6			2	
200	BACR15DA4CH			2	
205	NAS601-6P			2	
205	NAS601-6B			2	
205	BACR15DA4H			2	
210	NAS620-6L			4	
215	BACN10JC06			4	
220	65-79165-51		A,C	1	
225	65-79165-52		B,D	1	
230	NAS623-2-5			4	
235	NAS620-8L			4	
240	BACN10JC08			4	

BOEING
COMMERCIAL JET
OVERHAUL MANUAL

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		
3-245	65-79165-41		A, C	1
245	65-79165-42		B,D	1
250	MS20253-3-124			2
255	65-79165-53			1
260	65-79165-54			1
265	65-79165-43			1
265	65-79165-44			1
270	69-61458-1			1

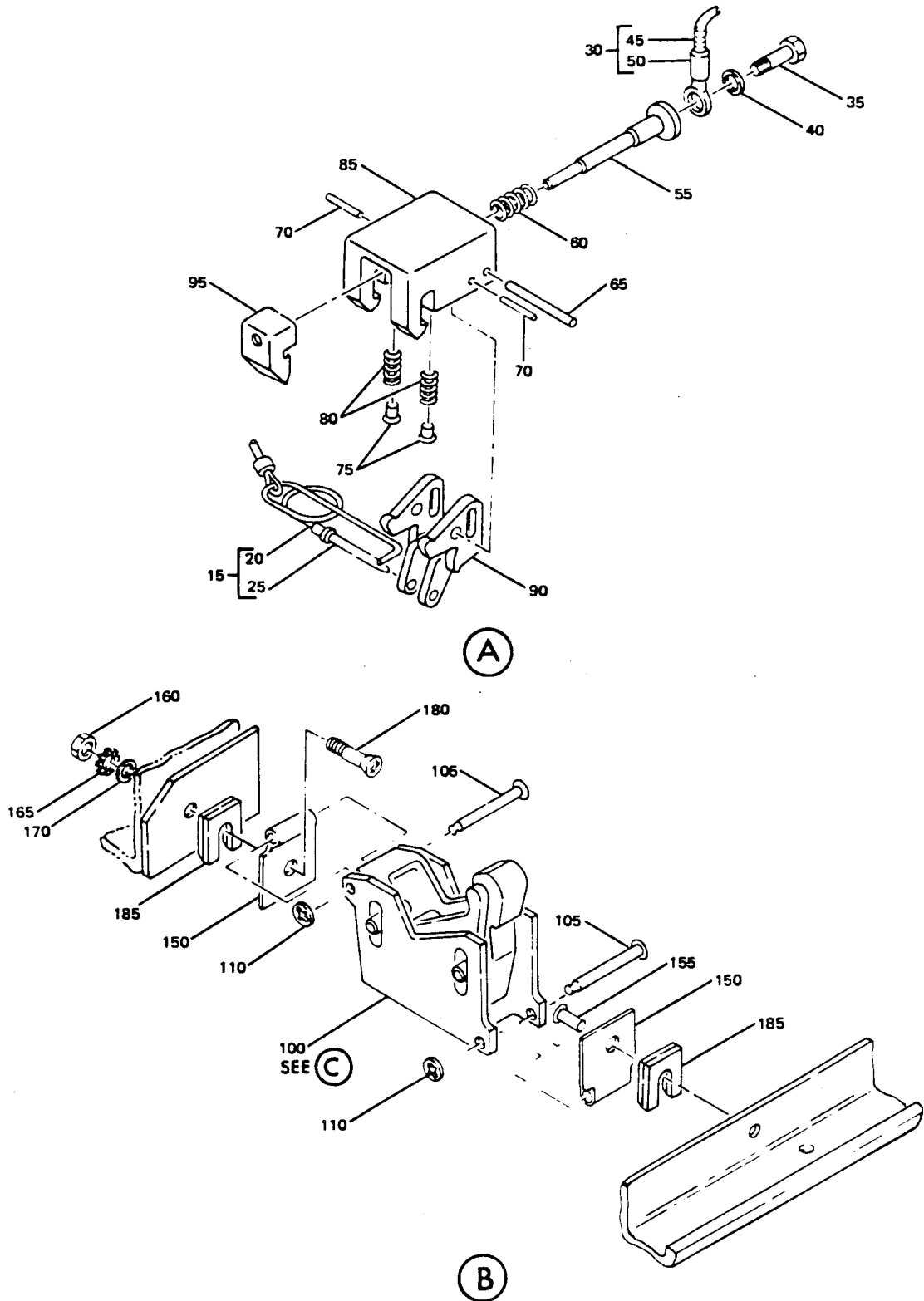
BOEING 
COMMERCIAL JET
OVERHAUL MANUAL

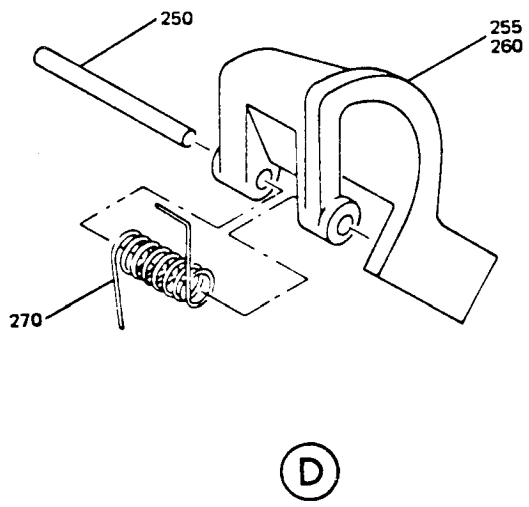
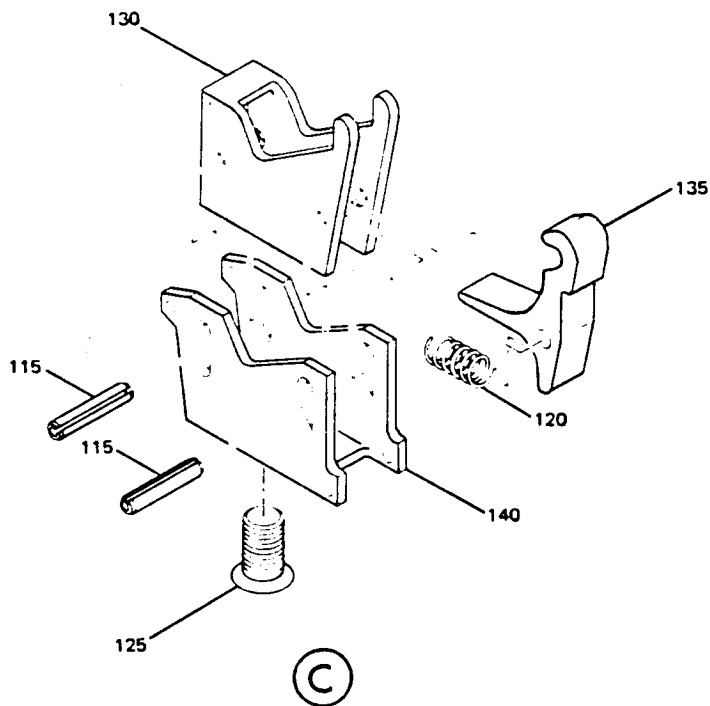
65-86412



Basic Shell Assembly
 Figure 4 (Sheet 1)

BOEING 
COMMERCIAL JET
OVERHAUL MANUAL





Basic Shell Assembly
Figure 4 (Sheet 3)

BOEING 
COMMERCIAL JET
OVERHAUL MANUAL

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		
4-	65-86412-21		PASSENGER SERVICE UNIT SHELL ASSY AFT SPLIT							A	RF
	65-86412-22		PASSENGER SERVICE UNIT SHELL ASSY AFT SPLIT							B	RF
	65-86412-23		PASSENGER SERVICE UNIT SHELL ASSY FWD SPLIT							C	RF
	65-86412-24		PASSENGER SERVICE UNIT SHELL ASSY FWD SPLIT							D	RF
1	65-86412-37		. SHELL ASSY AFT SPLIT							A	1
1	65-86412-38		. SHELL ASSY AFT SPLIT							B	1
1	65-86412-39		. SHELL ASSY FWD SPLIT							C	1
1	65-86412-40		. SHELL ASSY FWD SPLIT							D	1
2	65-86412-11		. . BASIC SHELL FWD 1/3							C	1
2	65-86412-12		. . BASIC SHELL FWD 1/3							D	1
2	65-86412-15		. . BASIC SHELL AFT 1/3							A	1
2	65-86412-16		. . BASIC SHELL AFT 1/3							B	1
2	65-86412-17		. . BASIC SHELL FWD 2/3							A	1
2	65-86412-18		. . BASIC SHELL FWD 2/3							B	1
2	65-86412-19		. . BASIC SHELL AFT 2/3							C	1
2	65-86412-20		. . BASIC SHELL AFT 2/3							D	1
5	65-85900-1		. . . CLAMP ASSY, OUTED SUPPORT								2
10	65-85900-2		. . . CLAMP ASSY, OUTED SUPPORT								2
15	69-64539-1	 PIN ASSY								2
20	69-64539-2	 RETAINER, SPRING								2
25	69-64539-3	 PIN								2
30	69-61465-5	 LANYARD ASSY								2
			ATTACHING PARTS								
35	NAS1191-06P4L	 SCREW								2
30	AN960PD6	 WASHER								2
			-----*								
45	69-61465-6	 CORD, NYLON								1
50	BACT12AC8	 LUG, TERMINAL								1
55	65-85905-1	 PLUNGER								
60	RCS3290	 SPRING, V08205								1
65	NAS607-2-8P	 PIN								1
70	NAS607-1-4P	 PIN								2
75	65-85900-3	 PLUNGER SPRING								2
80	RCS3289	 SPRING, V08205								2
85	65-85904-1	 BODY, CLAMP								1
90	65-85902-1	 LINK, ROCKER								1

BOEING 
COMMERCIAL JET
OVERHAUL MANUAL

65-86412

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		
4-											
95	65-85903-1			1
95	65-85903-2			1
100	65-85901-2		A-D	2
105	BACR15BB3D11			4
110	6100-9			4
115	MS16562-35			2
120	RCS3288			1
125	65-85905-3			1
130	65-85907-1			1
135	65-85908-1			1
140	65-85906-1			1
150	69-64895-1			4
155	BACR15BA6AD			2
160	MS35649-282			2
165	MS35335-31			2
170	AN960PD8			2
180	NAS514-P832-8		A-D	1
185	66-25727-1		A-D	2
190	69-64505-1			2
190	69-61459-5			2
195	65-79165-21			1
195	65-79165-22			1
200	NAS514P632-6			2
200	BACR15DA4CH			2
205	NAS601-6P			2
205	NAS601-6B			2
210	NAS620-6L			4
215	BACN10JC06			4

BOEING 
COMMERCIAL JET
OVERHAUL MANUAL

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													
4-																						
220	65-79165-51		.	.	.	C	O	V	E	R,	H	I	N	G	E						1	
225	65-79165-52		.	.	.	C	O	V	E	R,	H	I	N	G	E						1	
230	NAS623-2-5		.	.	.	S	C	R	E	W											4	
235	NAS620-8L		.	.	.	W	A	S	H	E	R										4	
240	BACN10JC08		.	.	.	N	U	T													4	
245	65-79165-41		.	.	.	D	O	O	R	A	S	S										1
245	65-79165-42		.	.	.	D	O	O	R	A	S	S										1
255	65-79165-53		.	.	.	H	I	N	G	E												1
260	65-79165-54		.	.	.	H	I	N	G	E												1
265	65-79165-43		.	.	.	D	O	O	R													1
265	65-79165-44		.	.	.	D	O	O	R													1
270	69-61458-1		.	.	.	S	P	R	I	N	G											2

VENDORS

V08205 RENTON COIL SPRING CO., 325 BURNETT N., RENTON, WA 98055