

TO: ALL HOLDERS OF PASSENGER SERVICE UNIT ASSEMBLY OVERHAUL MANUAL, 25-20-94

REVISION NO. 9, DATED MAR 1/03
HIGHLIGHTS

DESCRIPTION OF CHANGE	TOPICS AFFECTED												
	D & O	D / Assy	Cleaning	Inspect / Check	Repair	Assy	F / C	Test	T / Shooting	S / Tools	Storage	I P L	L / Overhaul
Identified BAC5710, Type 60 as optional to HYSOL AC5365 primer					X								

# PASSENGER SERVICE UNIT ASSEMBLY

## 25-20-94

BOEING P/N      65-79164-119 thru -136, -159 thru -162  
65V10794-41 thru -44

AIRLINE P/N

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THE FOLLOWING DIRECTIVES APPLY TO THIS SUBJECT:

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVES	DATE DIRECTIVE INCORPORATED INTO TEXT
25-1151		PRR 17863 PRR 17866 PRR 23605-44 PRR 23741 PRR 32362 PRR 32363 PRR 33140-7 MC 3038-22K	Jan 5/75 Jan 5/75 Jan 5/75 Jan 5/75 Jan 5/75 Jan 5/75 Jan 5/83 Jul 5/83

## 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
25-20-94					
T-1	Jul 5/83				
T-2	BLANK				
* LEP-1	Mar 1/03				
LEP-2	BLANK				
T/C-1	Mar 1/96				
T/C-2	BLANK				
* 1	Mar 1/03				
2	Mar 1/96				
3	Mar 1/96				
4	Jan 5/83				
5	Jan 5/75				
6	May 10/75				
7	Jan 5/83				
8	Mar 1/96				
9	Mar 1/96				
10	Mar 1/96				
11	Mar 1/96				
12	Mar 1/96				
13	Mar 1/96				
14	BLANK				



OVERHAUL MANUAL

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\*[1] This manual contains only refinish and replacement procedures and the illustrated parts list. For all other approved procedures for this unit, refer to OHM 25-20-00.

PASSENGER SERVICE UNIT ASSEMBLY

1. REPAIR

A. Materials

NOTE: Equivalent substitutes can be used.

- (1) Adhesive -- Type 72 (SOPM 20-50-12)
- (2) Adhesive -- Type 70 (SOPM 20-50-12)
- (3) Adhesive -- Type 44 (SOPM 20-50-12)
- (4) Primer -- Hysol AC5365, V33564  
-- BAC5710, Type 60 (optional)
- (5) 1-inch Tape -- White vinyl, P32, V99742: 1-inch wide (5, Fig. 2); 3-inch wide (365)

B. Refinish

CAUTION: DO NOT USE HI-SPEED LACQUER TO REFINISH POLYCARBONATE PLASTIC PARTS. IT WILL CAUSE DAMAGE THAT COULD BE IMMEDIATE BUT NOT VISUALLY DETECTABLE.

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

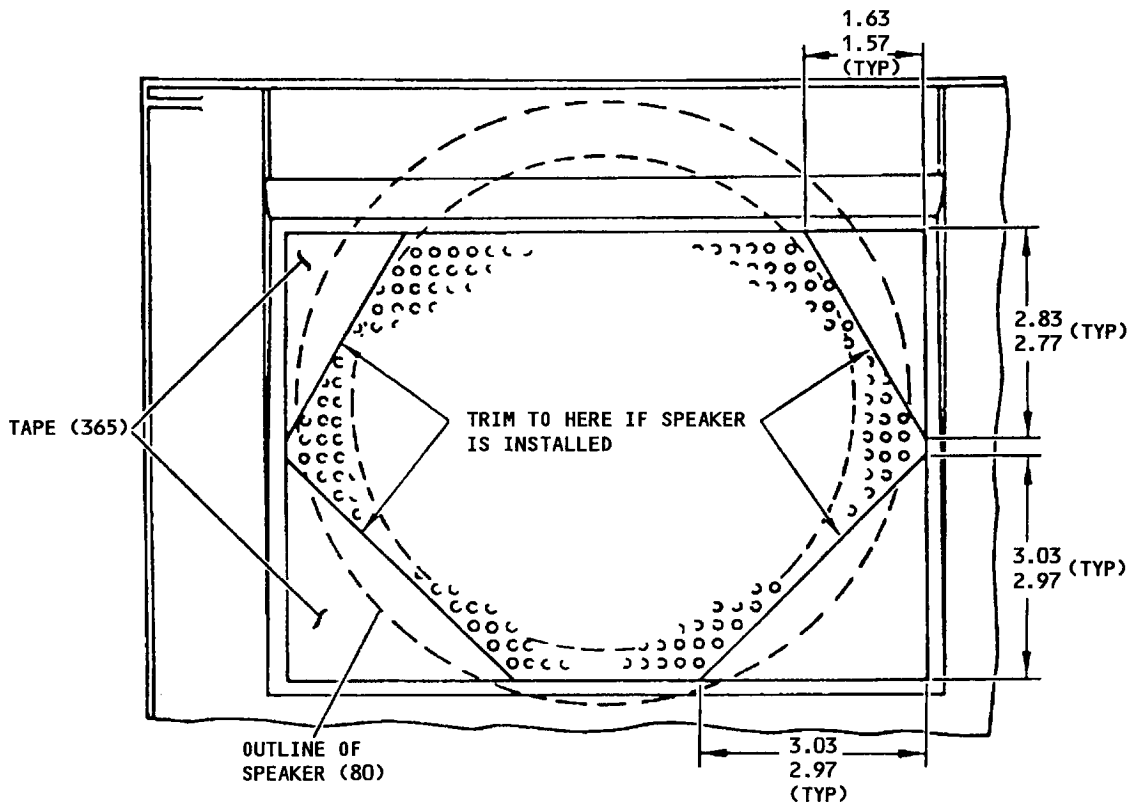
- (1) Mount assembly (105, Fig. 2) -- Chemical treat or anodize and apply primer (SRF-2.30) all over. Material: Al alloy.
- (2) Heat shield (295) -- Apply two coats hi-speed lacquer (F-14.904-711) all over. Material: Al alloy.
- (3) Basic PSU assembly (370) -- Refinish per operator's standard color scheme.

C. Replacement

- (1) Reinforcing channels -- Apply Hysol AC5365 (BAC5710, Type 60 - optional) primer to all aluminum surfaces to be bonded. Let dry 1/2 - 1 hour. Bond with Type 70 adhesive per SOPM 20-50-12.
- (2) Reinforcing angles on oxygen mask door -- Bond with Type 44 adhesive per SOPM 20-50-12.

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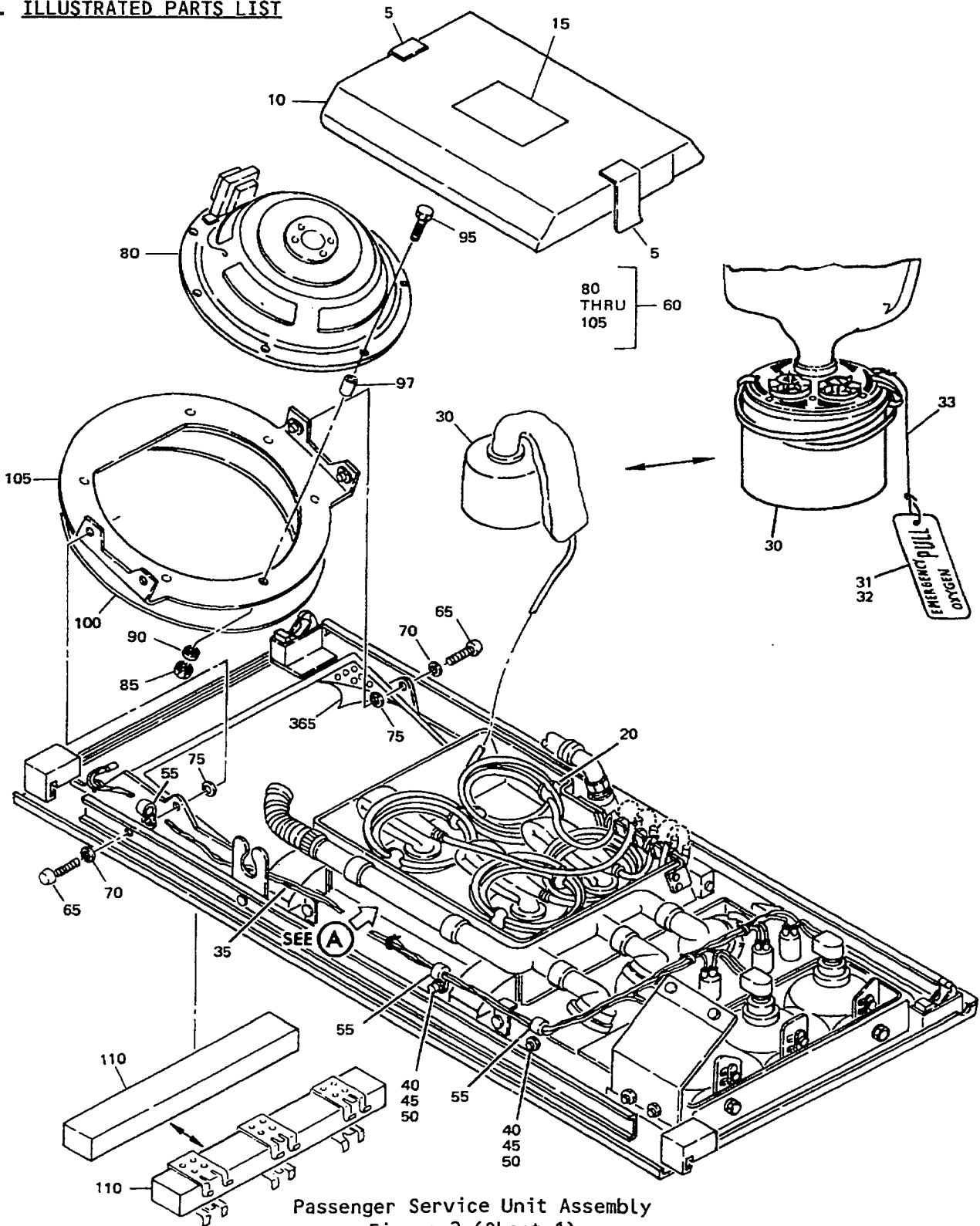
- (3) Quick-disconnect assembly (170) or air duct (175) on duct assembly (161, 69-68932-1) -- Bond new parts with Type 72 adhesive per SOPM 20-50-12.
- (4) Tape (365) -- Trim tape per Fig. 1 on units with speaker assemblies (60) installed. Then paint the speaker grille face with paint of the applicable color, to seal the tape adhesive seen through the speaker grille holes.
- (5) Placard (31) -- Attach a replacement placard to oxygen mask (30) with string (33) to let the placard hang 10-14 inches below the bottom of the mask.



ALL DIMENSIONS ARE IN INCHES

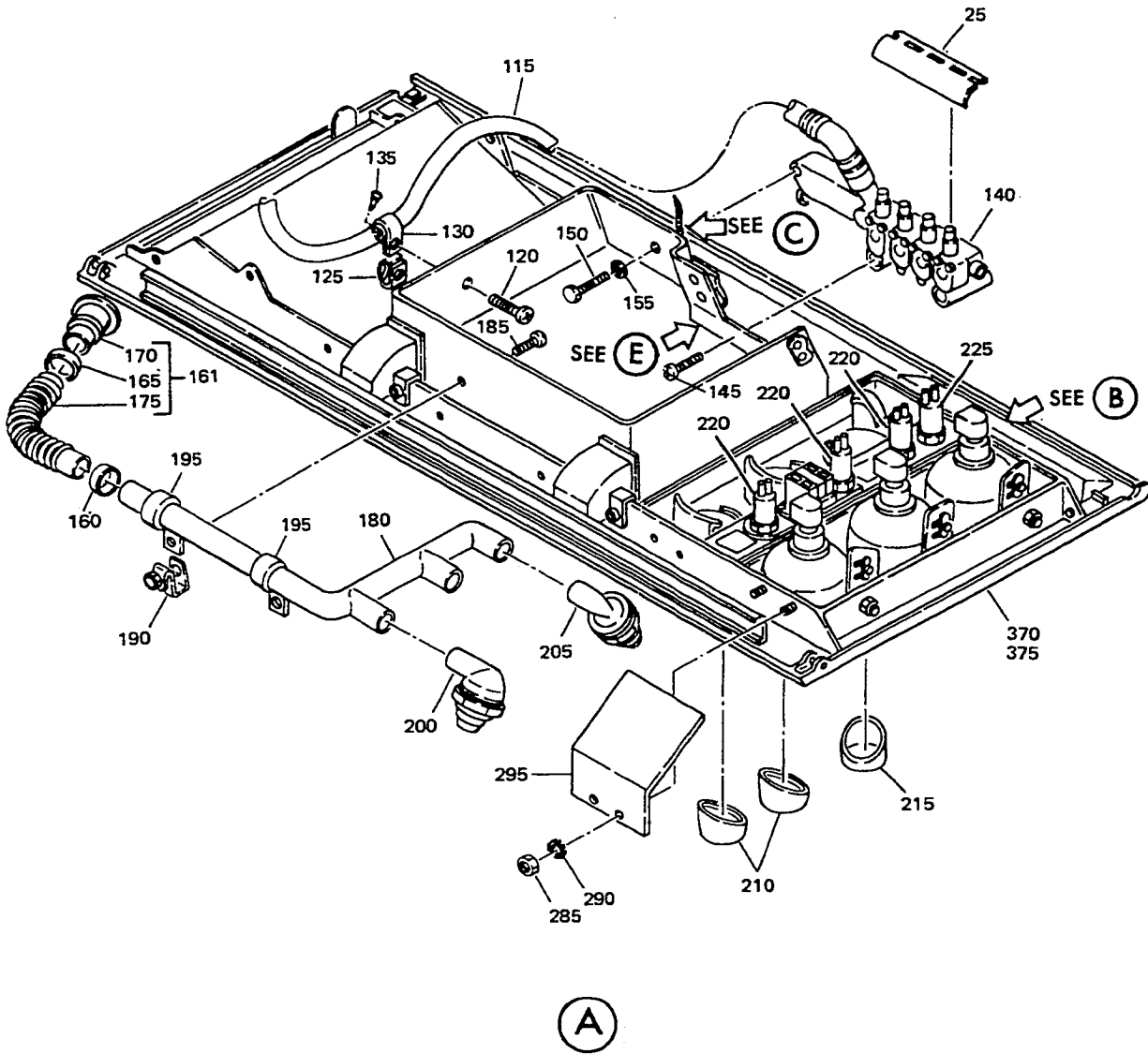
Tape Application  
Figure 1

2. ILLUSTRATED PARTS LIST



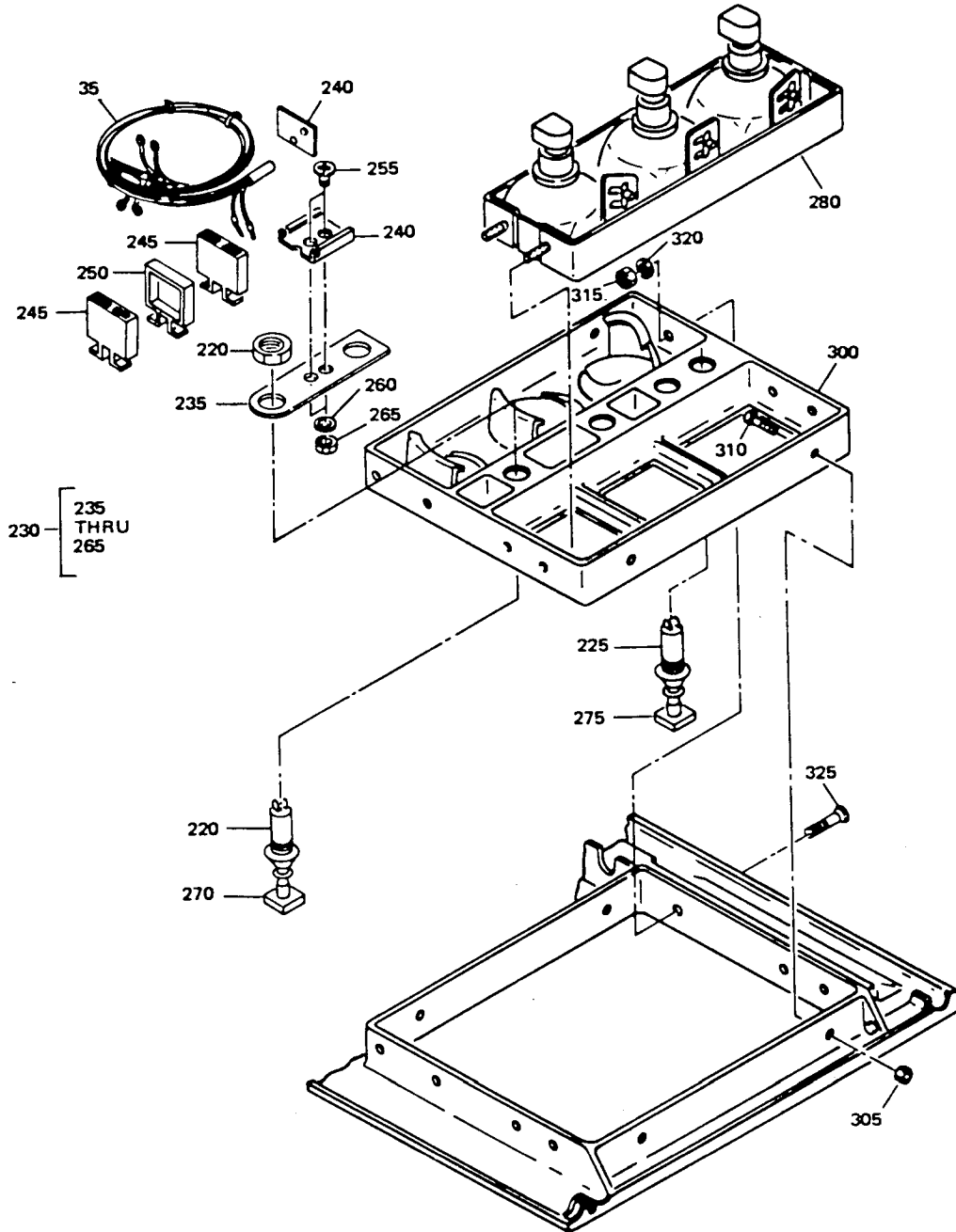
Passenger Service Unit Assembly  
Figure 2 (Sheet 1)

OVERHAUL MANUAL



Passenger Service Unit Assembly  
Figure 2 (Sheet 2)



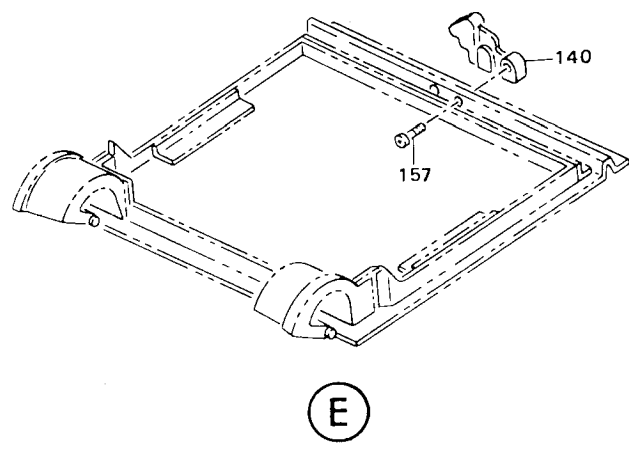
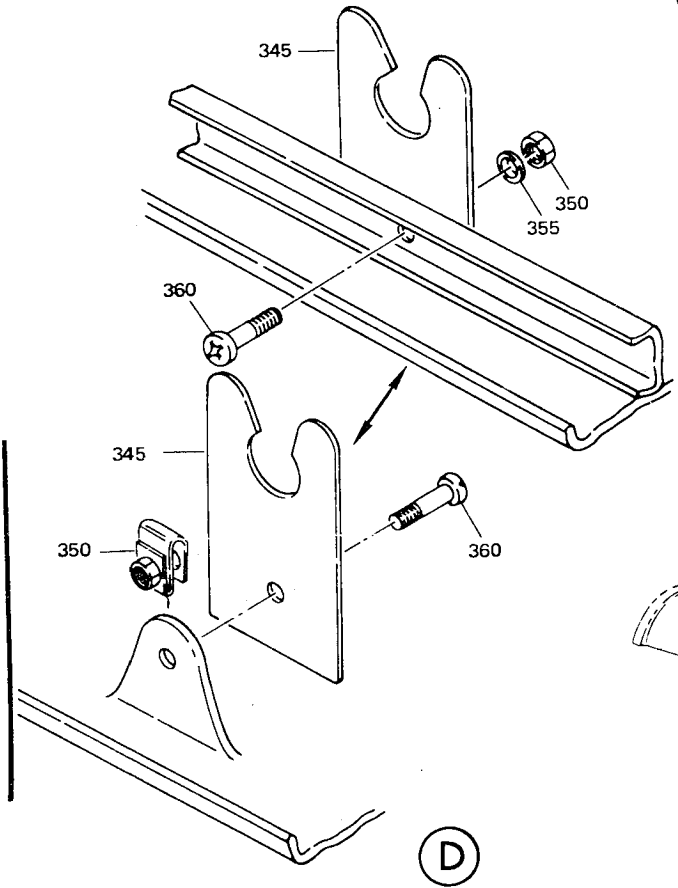
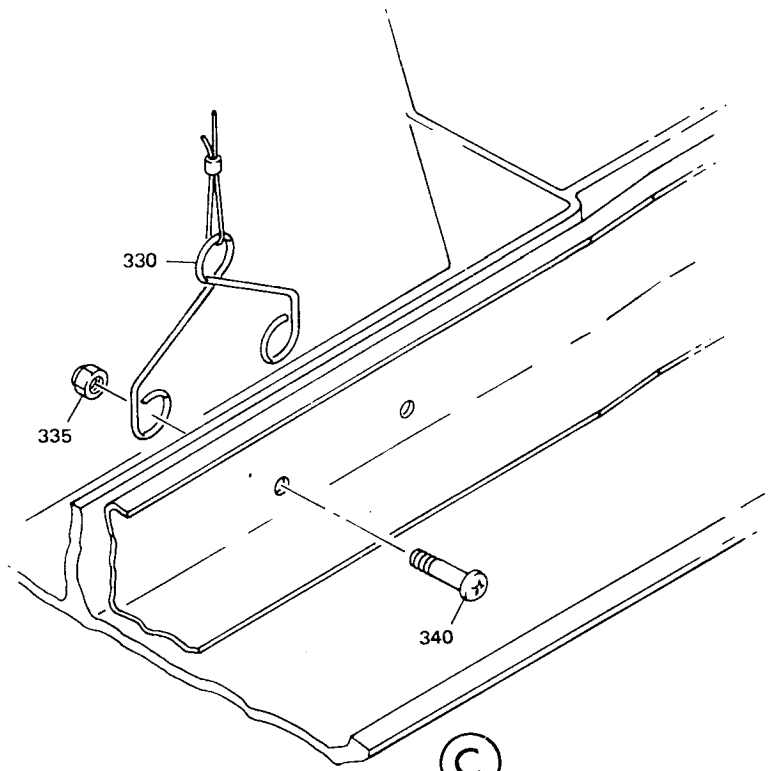


(B)

Passenger Service Unit Assembly  
Figure 2 (Sheet 3)

**BOEING**  
**COMMERCIAL JET**  
**OVERHAUL MANUAL**

65-79164  
DASH NUMBERS LIMITED



Passenger Service Unit Assembly  
Figure 2 (Sheet 4)

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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			
2-	65-79164-119		PASSENGER	SERVICE	UNIT	ASSY					A	RF
	65-79164-120		PASSENGER	SERVICE	UNIT	ASSY					B	RF
	65-79164-121		PASSENGER	SERVICE	UNIT	ASSY					C	RF
	65-79164-122		PASSENGER	SERVICE	UNIT	ASSY					D	RF
	65-79164-123		PASSENGER	SERVICE	UNIT	ASSY					E	RF
	65-79164-124		PASSENGER	SERVICE	UNIT	ASSY					F	RF
	65-79164-125		PASSENGER	SERVICE	UNIT	ASSY					G	RF
	65-79164-126		PASSENGER	SERVICE	UNIT	ASSY					H	RF
	65-79164-127		PASSENGER	SERVICE	UNIT	ASSY					I	RF
	65-79164-128		PASSENGER	SERVICE	UNIT	ASSY					J	RF
	65-79164-129		PASSENGER	SERVICE	UNIT	ASSY					K	RF
	65-79164-130		PASSENGER	SERVICE	UNIT	ASSY					L	RF
	65-79164-131		PASSENGER	SERVICE	UNIT	ASSY					M	RF
	65-79164-132		PASSENGER	SERVICE	UNIT	ASSY					N	RF
	65-79164-133		PASSENGER	SERVICE	UNIT	ASSY					O	RF
	65-79164-134		PASSENGER	SERVICE	UNIT	ASSY					P	RF
	65-79164-135		PASSENGER	SERVICE	UNIT	ASSY					Q	RF
	65-79164-136		PASSENGER	SERVICE	UNIT	ASSY					R	RF
	65-79164-159		PASSENGER	SERVICE	UNIT	ASSY					S	RF
	65-79164-160		PASSENGER	SERVICE	UNIT	ASSY					T	RF
	65-79164-161		PASSENGER	SERVICE	UNIT	ASSY					U	RF
	65-79164-162		PASSENGER	SERVICE	UNIT	ASSY					V	RF
	65V10794-41		PASSENGER	SERVICE	UNIT	ASSY					W	RF
	65V10794-42		PASSENGER	SERVICE	UNIT	ASSY					X	RF
	65V10794-43		PASSENGER	SERVICE	UNIT	ASSY					Y	RF
	65V10794-44		PASSENGER	SERVICE	UNIT	ASSY					Z	RF
5	65-79164-3		. TAPE									2
10	65-80172-7		. COVER, OXYGEN BOX								ACEGI KMOQS UWY	1
10	65-80172-8		. COVER, OXYGEN BOX								BDFHJ LNPRT VXZ	1
15	BAC27DPA465		. PLACARD								A-N S-Z	1
15	BAC27DPA489		. PLACARD								O-R W-Z	1
20	63-10155		. RETAINER, COIL									8
25	69-64747-1		. GUIDE, TUBE									1
30	289-701-27		. MASK, OXYGEN, V92114 (BOEING 10-60137-49)								A-V	4
30	69V10315-6		. MASK, OXYGEN								W-Z	4
31	66-35012-0		. STREAMER PLACARD								W-Z	4
32	66-35012-5		. PLATE								W-Z	4
33	65V10794-46		. STRING								W-Z	AR

OVERHAUL MANUAL

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
2-35	61-23100-5		.	WIRE BUNDLE						A-F	1
35	61-23100-8		.	WIRE BUNDLE						G-Z	1
40	BACS12CB08		.	ATTACHING PARTS							
40	BACS12CB08		.	SCREW *[1]							4
45	AN960PD8		.	SCREW *[1]							5
45	AN960PD8		.	WASHER *[1]							4
45	AN960PD8		.	WASHER *[1]							4
50	BACN10FX83		.	WASHER *[1]							5
50	BACN10FX83		.	NUT *[1]							4
50	BACN10FX83		.	NUT *[1]							5
55	BACC10DK		.	NUT *[1]							5
			.	CLAMP *[2]							5
			-----*								
60	69-61466-4		.	SPEAKER ASSY						CDEFI JMNQR UVYZ	1
				ATTACHING PARTS							
65	NAS601-5P		.	SCREW							4
70	AN960PD6L		.	WASHER							4
75	NAS549-8		.	WASHER							AR
			-----*								
80	8-3282		.	SPEAKER, V34263 (PREF)							1
80	C8TS-C8800		.	SPEAKER, V74239 (OPT)							1
			.	ATTACHING PARTS							
85	BACN10JC3		.	NUT							7
90	AN960C10L		.	WASHER							7
95	NAS514P1032-10		.	SCREW							7
97	NAS43DD3-16		.	SPACER							7
			-----*								
100	69-61466-3		.	TAPE, SEALING							AR
105	69-62320-1		.	MOUNT ASSY, SPEAKER							1
110	10-0040-101		.	FIXTURE, LAMP, V72914 (BOEING 10-60781-101)					A-D		1
110	10-0040-113		.	FIXTURE, LAMP, V72914 (BOEING 10-60781-113)					EF		1
110	800000095-1		.	BASE, V05617 (BOEING 10-61892-1)					G-Z		1
115	ZH833-39		.	HOSE, OXYGEN, V02217 (BOEING 10-60174-39)					A-J		1
115	173470-39		.	HOSE, OXYGEN, V02217 (BOEING 10-60174-39)					O-Z		1
115	173470-39		.	HOSE, OXYGEN, V02217 (BOEING 10-60174-39)					A-J		1
115	37001-39		.	HOSE, OXYGEN, V24984 (BOEING 10-60174-39)					A-J		1
115	37001-39		.	HOSE, OXYGEN, V24984 (BOEING 10-60174-39)					O-Z		1
115	42001-233-032		.	HOSE, OXYGEN, V28445 (BOEING 10-60174-39)					A-J		1
115	42001-233-032		.	HOSE, OXYGEN, V28445 (BOEING 10-60174-39)					O-Z		1
115	ZH833-40		.	HOSE, OXYGEN, V02217 (BOEING 10-60174-40)					K-N		1
115	ZH833-40		.	HOSE, OXYGEN, V02217 (BOEING 10-60174-40)					K-N		1
115	37001-40		.	HOSE, OXYGEN, V24984 (BOEING 10-60174-40)					K-N		1
115	37001-40		.	HOSE, OXYGEN, V24984 (BOEING 10-60174-40)					K-N		1
			.	ATTACHING PARTS							
120	NAS602-8P		.	SCREW							1

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FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
2- 130	BACC10DK7		.								1
135	BACP20BA1		.								1
140	115013-01		.							ACEGI KMOQS UWY	1
140	802078-00		.							ACEGI KMOQS UWY	1
140	115013-02		.							BDFHJ LNPRT VXZ	1
140	802078-01		.							BDFHJ LNPRT VXZ	1
145	BACS12CB3-22		.								2
145	NAS603-22P		.							EF	2
150	BACS12CB3-20		.								1
150	NAS603-20P		.							EF	1
155	MS35335-32		.								1
157	BACS12CB04-9		.								2
160	MS3367-4-9		.								1
160	6203		.								1
161	69-68932-1		.								1
161	69-68932-2		.								1
165	MS3367-4-9		.								1
170	69-64738-1		.								1
175	BE406-3		.								1
175	AD604-3		.								1
180	69-62660-2		.								1
185	NAS602-8P		.								2
190	BACN10FX83		.								2
195	BACC10DK12		.								2
200	L16999-15C		.								2
200	1707-18A		.								2
200	750801-003		.								2
205	L20646-1C		.								1
205	1707-19A		.								1
205	750801-004		.								1

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FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
2-210	65-79165-31		.								2
215	65-79165-32		.								1
220	710907-13A2		.								3
225	710906-13A1		.								1
230	69-65298-1		.								1
235	69-65258-1		.	.							
240	AMY0110T-8		.	.							1
											(2 PIECES)
245	BACM15C1A		.	.							2
250	YHLZ1C-8		.	.							1
255	BACR15DA6-2		.	.							2
255	NAS602-7		.	.							2
260	AN960PD8L		.	.							2
265	BACN10JC08		.	.							2
270	691212-13A1-1		.								3
											(PRE SB 25-1151)
270	691212-13A1-1AJ		.						G-J		3
											(POST SB 25-1151)
275	690623A1-4		.								1
280	10-0429-1		.						ACEGI		1
									KMOQS		
									UWY		
280	10-0429-2		.						BDFHJ		1
									LNPRT		
									VXZ		
											ATTACHING PARTS
285	MS35649-282		.								4
285	BACN10JC08		.						EF		4
											NUT (OPT TO MS35649-282 AND MS35335-31)
290	MS35335-31		.								4
											WASHER (USED WITH MS35649-282)
											-----*
295	69-65414-1		.								1
300	65-79165-5		.						ACEGI		1
									KMOQS		
									UWY		
300	65-79165-6		.						BDFHJ		1
									LNPRT		
									VXZ		
											ATTACHING PARTS
305	BACN10JC08		.								4
310	NAS514P832-5P		.								4
315	BACN10JC06		.								
1											NUT
320	AN960PD6L		.								1
325	NAS601-8P		.								1
											WASHER
											SCREW
											-----*

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FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE							USE CODE	QTY PER ASSY	
			1	2	3	4	5	6	7			
2-330	69-63824-1		.	L	A	N	A	S	S		1	
335	BACN10JC08		.	N							2	
340	NAS602-4P		.	S							2	
345	69-64747-2		.	G	U	I	D	E	,	T	U	1
350	BACN10JC08		.	N							1	
350	BACN10FX84		.	N							1	
355	AN960PD8L		.	W							1	
360	NAS602-7		.	S							1	
360	NAS602-8P		.	S							1	
365	65-79164-79		.	T	A	P	E			ABE-H KLOPS TWX	1	
370	65-79164-63		.	B	A	S	I	C	A	S	S	1
370	65-79164-64		.	B	A	S	I	C	A	S	S	1
370	65-79164-137		.	B	A	S	I	C	A	S	S	1
370	65-79164-138		.	B	A	S	I	C	A	S	S	1
370	65-79164-107		.	B	A	S	I	C	A	S	S	1
370	65-79164-108		.	B	A	S	I	C	A	S	S	1
370	65-79164-137		.	B	A	S	I	C	A	S	S	1
370	65-79164-138		.	B	A	S	I	C	A	S	S	1
375	65-79165-61		.	.	S	H	E	L	L	A	S	1
375	65-79165-59		.	.	S	H	E	L	L	A	S	1
375	65-79165-62		.	.	S	H	E	L	L	A	S	1
375	65-79165-60		.	.	S	H	E	L	L	A	S	1

\*[1] USE THREE NUTS, WASHERS AND SCREWS WHEN SPEAKER IS NOT INSTALLED.

\*[2] SIZE TO FIT

\*[3] NUT, WASHER AND SCREW OPTIONAL TO RIVET

## OVERHAUL MANUAL

REFERENCE DESIGNATION INDEX (SEE 25-20-00 SCHEMATIC)		
REFERENCE DESIGNATION	PART NUMBER	ITEM NO. FIG. 2
D600P	BACC45FT14-15P	
L3000	10-0429-1	280
L3001	10-0429-2	280
L3002	10-0040-101	110
L3002	10-0040-113	110
L3002	800000095-1	110
M3001	8-3282	80
M3001	C8TS-C8800	80
S3000	710906-13A1	225
S3001-S3003	710907-13A2	220
T3000	69-65298-1	230



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VENDORS

- V02217 PURITAN-BENNETT AEROSYSTEMS CO., 111 PENN ST., EL SEGUNDO, CALIFORNIA  
90245-3908
- V05399 BEMCO, INC., 157 MAIN STREET, P.O. BOX 68, CENTERTON, ARKANSAS 72719
- V05617 BELL INDUSTRIES, INC., ILLUMINATED DISPLAYS DIV., 18225 N.E. 76th ST., REDMOND,  
WASHINGTON 98052-5021
- V09922 BURNDY CORP., 1 RICHARDS AVE., NORWALK, CONNECTICUT 06856
- V16827 PURITAN-BENNETT AEROSYSTEMS CO., 10800 PFLUMM RD., LENEXA, KANSAS  
66215-2182
- V17744 LUMINATOR DIV., GULTON INDUSTRIES, INC., 1200 E. PLANO PARKWAY, PLANO,  
TEXAS 75074-8522
- V21868 HBD INDUSTRIES, INC., BELLEFONTAINE WORKS, 1301 WEST SANDUSKY AVE.,  
BELLEFONTAINE, OHIO 43311-1082
- V24984 HYDRAFLOW, 13259 EAST 166TH ST., CERRITOS, CALIFORNIA 90701-2203
- V28406 VAUPELL INDUSTRIAL PLASTICS, INC., 1144 N.W. 53RD., SEATTLE, WASHINGTON  
98107-3735
- V28445 R.E. DARLING CO., INC., 3749 NORTH ROMERO RD., TUCSON, ARIZONA 85705-3031
- V34263 CTS CORP. IN TEXAS, DBA CTS ELECTRONIC CORP., 1100 ROOSEVELT ST., P.O. BOX  
2420, BROWNSVILLE, TEXAS 78521
- V53655 SCOTT AVIATION DIV., FIGGIE INTERNATIONAL, INC., 225 ERIE ST., LANCASTER, NEW  
YORK 14086-9502
- V54753 GENERAL INSTRUMENT CORP., SICKLES FW DIV., 11801 MIRIAM DRIVE, SUITE B-1,  
EL PASO, TEXAS 79936
- V72914 GRIMES DIV., MIDLAND-ROSS, 550 STATE ROUTE 55, P.O. BOX 247, CHAMPAIGN  
COUNTY, URBANA, OHIO 43078
- V74239 INTERNATIONAL JENSEN, INC., ROLA CO. DIV., 21010 MILES PARKWAY, CLEVELAND,  
OHIO 44128-5512
- V81646 EPICOR INDUSTRIES, INC., IDEAL DIV., 3200 PARKER DRIVE, ST. AUGUSTINE,  
FLORIDA 32084
- V83564 WEMAC DIV. OF PURITAN-BENNETT AEROSYSTEMS CO., 18475 PACIFIC ST., P.O.  
BOX 8797, FOUNTAIN VALLEY, CALIFORNIA 92708-7004
- V92114 SCOTT AVIATION DIV. OF FIGGIE INTERNATIONAL, INC., 123 E. MONTECITO AVE.,  
SIERRA MADRE, CALIFORNIA 91024-1923