

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

TO: ALL HOLDERS OF AFT ATTENDANTS OXYGEN SERVICE UNIT ASSY OVERHAUL  
 MANUAL 25-21-01

REVISION NO. 1, DATED SEPT 5/77

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
Added new top assy 65-26277-9 Deleted welded details of door assys												X	X

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# AFT ATTENDANT'S OXYGEN SERVICE UNIT ASSEMBLY

**25-21-01**

I BOEING P/N 65-26277-1 thru -9

AIRLINE P/N

THE FOLLOWING DIRECTIVES APPLY TO THIS SUBJECT:

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVES	DATE DIRECTIVE INCORPORATED INTO TEXT
25-171		MC 2062-5K PRR 23480-8 PRR 23515 PRR 23516	Feb 10/71 Nov 10/72 Nov 10/72 Nov 10/72

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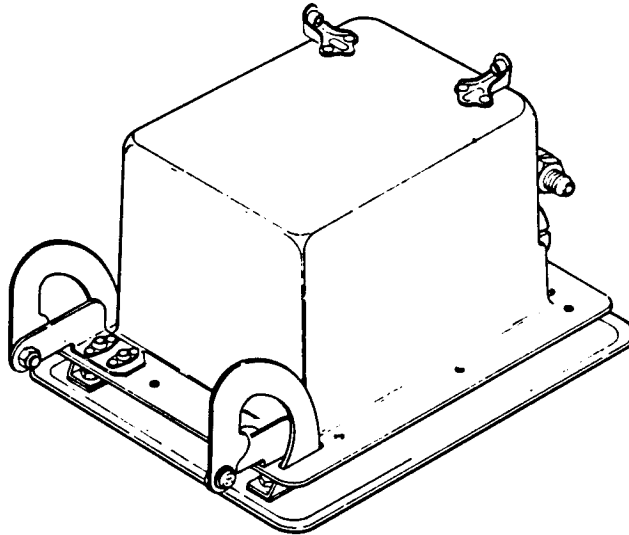
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AFT ATTENDANT'S OXYGEN SERVICE UNIT ASSEMBLY



Aft Attendant's Oxygen Service Unit Assembly  
Figure 1

1. DESCRIPTION AND OPERATION

A. Description

- (1) The aft attendant's oxygen service unit assembly is located in the aft lowered ceiling above the aft attendant's station. The service unit houses two oronasal-type oxygen masks which are automatically presented for use upon opening of the oxygen service unit door.

B. Operation

- (1) The oxygen service unit door opens automatically whenever the passenger oxygen system is actuated with pressure greater than 22 psig. Provisions are also provided for manual opening of the door.

C. Leading Particulars

Height -- 5.55 inches  
Length -- 10.50 inches  
Width -- 7.40 inches  
Weight -- 1.46 pounds

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2. DISASSEMBLY (See figure 2.)

WARNING: THE AFT ATTENDANT'S OXYGEN SERVICE UNIT ASSEMBLY CONTAINS OXYGEN EQUIPMENT WHICH MUST BE OVERHAULED IN A CLEAN, ENCLOSED AREA. SPECIAL CARE MUST BE TAKEN TO ENSURE ALL OPENINGS ARE CAPPED AT ALL TIMES, AS INDICATED, AND THAT THE UNIT IS NOT LEFT UNCOVERED OR UNPROTECTED.

CAUTION: THE LOWER FACE OF THE OXYGEN MASK BOX DOOR IS VISIBLE FROM CABIN INTERIOR. TAKE SPECIAL CARE TO PROTECT THIS AREA FROM SCRATCHES DURING OVERHAUL BY WORKING ON A SUITABLE, LINT-FREE CLOTH SURFACE.

- A. Remove nuts (1), washers (2), spacers (3) and screws (4) separating door assembly (11) from oxygen service unit box (24).
- B. Remove nuts (5) from studs (12) and remove hinges (6 and 7) from door assembly (11).
- C. Remove nuts (9) from studs (12 and 12A) and remove hookplate (10) and packing (10A), if applicable, from door assembly (11).

NOTE: Do not remove studs (12 and 12A) from door assembly (11) unless replacement is necessary.

- D. Remove screws (14) and remove hinge support bracket assemblies (15 and 16) from service unit box (24).

NOTE: Do not remove nutplates (18) from brackets (19 and 20) unless replacement is necessary.

- E. Remove screws (21 and 22) and remove latch-valve manifold assembly (23) from service unit box (24).

NOTE: Refer to applicable manufacturer's overhaul instructions for latch-valve manifold assembly.

Do not remove nutplates (26) (27) from service unit box (24) unless replacement is necessary.

3. CLEANING (See figure 2.)

WARNING: DO NOT ALLOW OIL, GREASE, FLAMMABLE SOLVENTS, DUST, LINT, FINE METAL FILINGS, OR OTHER COMBUSTIBLE MATERIAL TO CONTAMINATE PARTS THAT WILL BE EXPOSED TO PRESSURIZED OXYGEN. COMBUSTIBLE MATERIAL MAY IGNITE AND RESULT IN AN EXPLOSION WHEN EXPOSED TO PRESSURIZED OXYGEN.

- A. Clean vendor supplied components per manufacturer's instructions.

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B. Wash all other parts as follows:

- (1) Metal parts -- Wash or rinse in solvent, Specification P-D-680 or equivalent. Refer to 20-30-03, General Cleaning Procedures, for further information.
- (2) Plastic parts -- Clean per Cleaning of Interior Painted or Plastic Surfaces in 20-30-03.

C. Deleted.

4. INSPECTION/CHECK

A. Visual Checks

- (1) Examine all metal parts for pits, scratches, cracks, corrosion, and damage, using strong light and minimum of 10-power magnification.
- (2) Check all metal parts for bending, denting or other damage which may interfere with mating of associated parts.
- (3) Examine all threaded parts for cross-threading or stripping.
- (4) Examine all plated or painted surfaces for scratches, blisters or flaking.

5. REPAIR (See figure 2.)

A. Repair

- (1) Remove minor scratches, nicks and corrosion from metal parts with abrasive cloth, 220-grit or finer. Refinish polished areas as required for protection against corrosion.
- (2) Repair minor defects in threaded parts with triangular file or thread chaser.
- (3) Repair fiberglass parts as necessary using standard airplane shop procedures.

B. Refinish

- (1) If plated or painted surfaces are worn or chipped, refinish the following parts as indicated:

NOTE: Refer to 20-30-02, Stripping of Protective Finishes, and to 20-41-01 for decoding of F and SRF finish symbols and their BAC equivalents.

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- (a) Door hinges (6 and 7), hinge support brackets (19 and 20) -- Apply SRF -2.30 all over.
- (b) Door (13) -- Apply finish in accordance with individual airline color requirements.

C. Replacement

- (1) Replace all parts found unserviceable or damaged beyond simple repair.

6. ASSEMBLY (See figure 2.)

WARNING: ASSEMBLY OPERATIONS SHALL BE ACCOMPLISHED UNDER CONTROLLED CONDITIONS. PARTICULAR ATTENTION SHALL BE GIVEN TO CLEANLINESS OF THE OXYGEN SYSTEM. ALL OPENINGS SHALL BE CAPPED AT ALL TIMES TO PREVENT CONTAMINATION. AFTER ASSEMBLY, THE UNIT SHALL NOT BE LEFT UNCOVERED OR UNPROTECTED. SERIOUS EXPLOSION OR FIRE CAN RESULT FROM COMPRESSED OR LIQUID OXYGEN COMING IN CONTACT WITH GREASE, OIL, OTHER GASES OR COMBUSTIBLE MATERIAL.

CAUTION: TAKE EXTRA CARE IN HANDLING PLASTIC MATERIALS VISIBLE FROM CABIN INTERIOR. THESE MATERIALS ARE EASILY SCRATCHED OR DENTED.

- A. Install latch-valve manifold assembly (23) on oxygen service unit box (24) with screws (21 and 22).
- B. Install hinge support bracket assemblies (15 and 16) on oxygen service unit box (24) with screws (14).
- C. Install nylon hookplate (10) and packing (10A), if applicable, on door assembly (11) with nuts (9).
- D. Install door hinges (6 and 7) and shims (8) on door assembly (11) with nuts (5).
- E. Install door assembly (11) on service unit box (24) with screws, washers, spacers and nuts (1 through 4).

7. STORAGE INSTRUCTIONS

- A. Check that oxygen openings are capped.
- B. Wrap whole unit in vapor barrier paper and seal airtight in a temperature controlled room with temperature of 75 ( $\pm$  15) $^{\circ}$ F and 90% relative humidity, maximum.



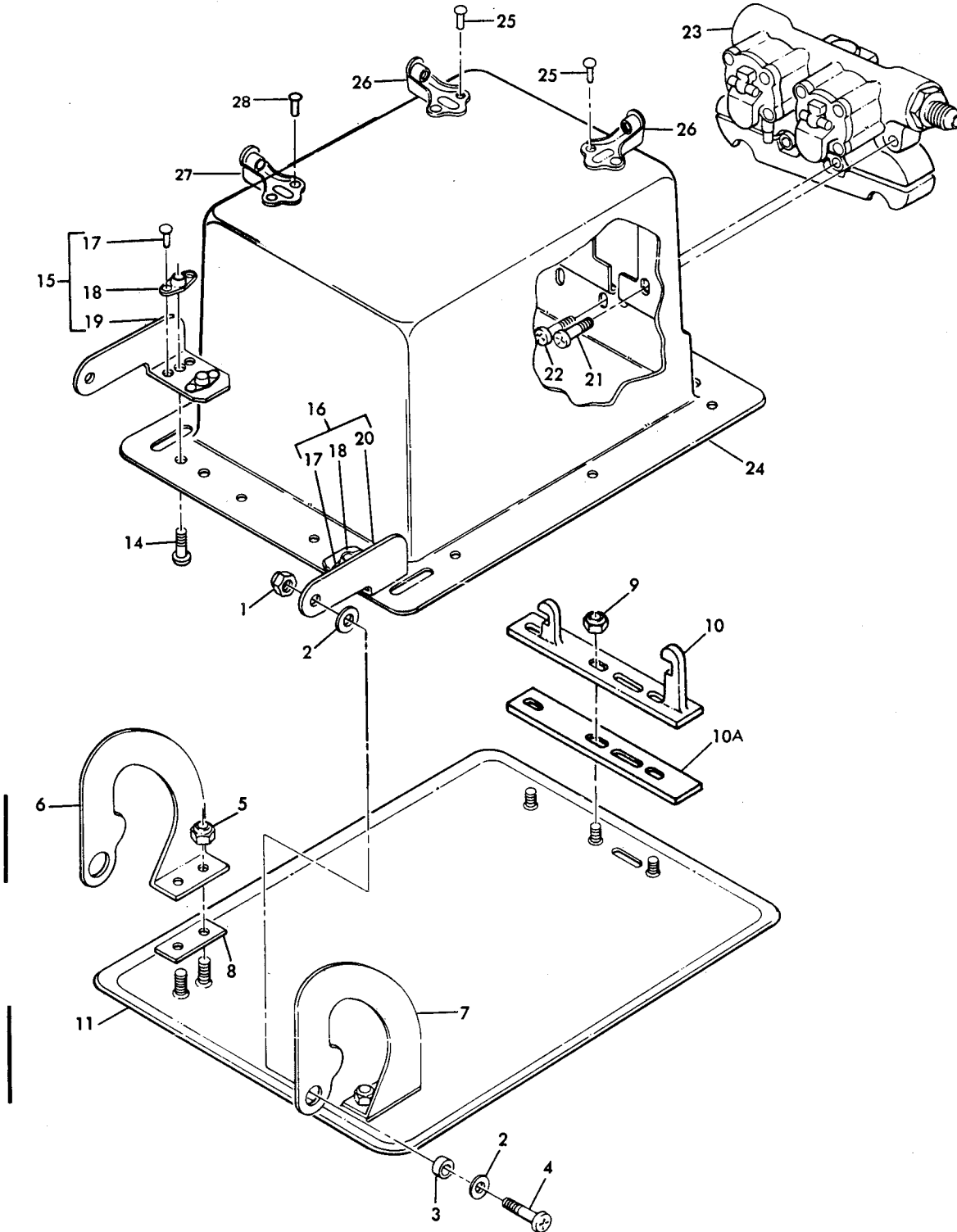
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- C. Protect unit from handling damage with adequate structure or packing.

CAUTION: LOWER FACE OF SHELL ASSEMBLY, PANEL ASSEMBLY, AND OXYGEN MASK DOOR IS VISIBLE FROM CABIN INTERIOR WHEN INSTALLED. TAKE SPECIAL CARE TO PROTECT THIS AREA FROM DAMAGE DURING STORAGE.

- D. Tag as Breathing Oxygen System Components; include part number and date part was cleaned and sealed.
- E. For further information, refer to 20-44-02, Temporary Protective Coatings, and to 20-70-01, Protection, Storage, and Handling of Airplane Components.

8. ILLUSTRATED PARTS LIST



Aft Attendant's Oxygen Service Unit Assembly  
Figure 2

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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-	65-26277-1		AFT ATTENDANT'S OXYGEN SERVICE UNIT ASSY							A	RF
	65-26277-2		AFT ATTENDANT'S OXYGEN SERVICE UNIT ASSY							B	RF
	65-26277-3		AFT ATTENDANT'S OXYGEN SERVICE UNIT ASSY							C	RF
	65-26277-4		AFT ATTENDANT'S OXYGEN SERVICE UNIT ASSY							D	RF
	65-26277-5		AFT ATTENDANT'S OXYGEN SERVICE UNIT ASSY							E	RF
	65-26277-6		AFT ATTENDANT'S OXYGEN SERVICE UNIT ASSY							F	RF
	65-26277-7		AFT ATTENDANT'S OXYGEN SERVICE UNIT ASSY							G	RF
	65-26277-8		AFT ATTENDANT'S OXYGEN SERVICE UNIT ASSY							H	RF
	65-26277-9		AFT ATTENDANT'S OXYGEN SERVICE UNIT ASSY							I	RF
1	BACN10JC3		. NUT (RPLS NAS679A3W)								2
2	BACW10P193G		. WASHER								4
3	66-15702-1		. SPACER, NYLON								2
4	NAS603-9P		. SCREW (RPLS NAS603-9)								2
5	BACN10MG8		. NUT								4
6	66-15699-1		. HINGE, OXYGEN SERVICE UNIT DOOR								1
7	66-15699-2		. HINGE, OXYGEN SERVICE UNIT DOOR								1
8	BACS40C12-20		DELETED								
8	BACS40R08E12F		. SHIM								AR
9	BACN10MG8		. NUT								3
10	66-15700-2		. HOOK PLATE, NYLON								1
10A	66-25579-1		. PACKING								AR
11	65-26279-3		. DOOR ASSY, OXYGEN SERVICE UNIT							ABE	1
11	69-54490-1		. DOOR ASSY, OXYGEN SERVICE UNIT							C	1
11	69-58030-1		. DOOR ASSY, OXYGEN SERVICE UNIT							DFI	1
11	65-26279-5		. DOOR ASSY, OXYGEN SERVICE UNIT							G-H	1
12	BACS21AQ6A4M		DELETED								
12	BACS21AQ2A3M		DELETED								
12	BACS21AQ6A3M		DELETED								
12	BACS21AQ6A3M		DELETED								
12A	BACS21AQ2A3M		DELETED								
13	65-26279-4		DELETED								
13	69-54490-2		DELETED								
13	69-58030-2		DELETED								

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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		
2-14	NAS602-8P										4
15	66-15701-1										1
16	66-15701-2										1
17	BACR15BA3D										4
18	BACN10JR08										2
19	66-15701-3										1
20	66-15701-4										1
21	NAS603-20P										2
22	NAS603-16P										2
23	115012								AEFG		1
23	115012-01								BCDHI		1
24	65-26278-2								ABD-I		1
24	65-68634-1								C		1
25	BACR15DA4								A		4
26	BACN10MK3-85								A		2
27	BACN10MK3-85								D		1
28	BACR15DA4								D		2

VENDORS

V16827 PURITAN EQUIPMENT, INC., 10800 PFLUMM ROAD, KS 66211