

BOEING *Commercial Jet*
OVERHAUL MANUAL

TO: ALL HOLDERS OF DESK LIGHT PASSENGER SERVICE UNIT ASSEMBLY OVERHAUL MANUAL,
25-21-14

REVISION NO. 0, DATED APR 5/76

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
Released new manual covering 65V10153, 65V10695													

DESK LIGHT PASSENGER SERVICE UNIT ASSEMBLY

25-21-14

BOEING P/N 65V10153-1, -7
65V10695-101

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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LIST OF EFFECTIVE PAGES					
* Indicates pages revised, added or deleted in latest revision					
F Indicates foldout pages - print one side only					
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* T-1	Apr 5/76				
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* LEP-1	Apr 5/76				
* LEP-2	BLANK				
* T/C-1	Apr 5/76				
* T/C-2	BLANK				
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*[1] Special instructions not required. Use standard industry practices.

*[2] Use applicable procedures contained in 20-44-02, 20-70-01 and standard industry practices.

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1. REPAIR

A. Materials

NOTE: Use listed materials or equivalent substitutes.

- (1) Adhesive -- Type 72 (Ref 20-50-12)
- (2) Dye, Anodic
 - (a) Nigrosine Black, Allied Chemical Corp., Industrial Chemical Div., P.O. Box 1139R, Morristown, New Jersey 07960
 - (b) Metanil Yellow, Allied Chemical Corp., Industrial Chemical Div., P.O. Box 1139R, Morristown, New Jersey 07960
- (3) Enamel
 - (a) BMS 10-83, type 2 (Ref 20-60-02)
 - (b) Black gloss, fine-wrinkle -- MIL-E-5558, type 1, any convenient source
- (4) Lacquer, hi-speed, flat black (Ref 20-60-02)
- (5) Primer (Ref 20-60-02)
 - (a) BMS 10-11, type 1
 - (b) BMS 10-83, type 1
- (6) Sealer, Anodic
 - (a) Boric acid (any convenient source)
 - (b) Nickel acetate (any convenient source)

B. Repair

- (1) Repair minor damage to this component using standard industry practices.

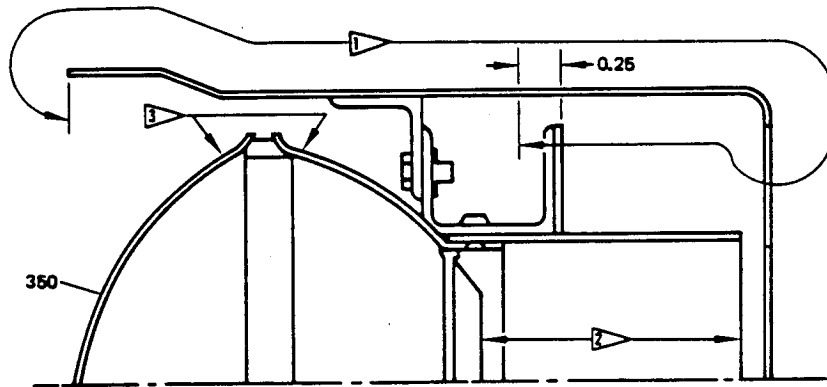
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C. Refinish

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) Latch supports (75, 80, Fig. 4) -- Alodize (colored film) or chromic acid anodize (Ref 20-43-01) and apply one coat BMS 10-11, type 1 primer (SRF-2.30) all over; or alodize (F-2.21) all over. Material: Alum alloy.
- (2) Bolt (100) -- Cadmium plate per 20-42-05, type 2, class 2 (F-1.1926) all over. Material: 4340 steel, 125-145 ksi.
- (3) Plunger bodies (105, 205), plungers (110, 165), latch body (115), clamp body (195) and rocker link (200) -- Chromic acid anodize (F-2.26) (Ref 20-43-01). Material: Alum alloy.
- (4) Channel (215) -- Alodize (colored film) (F-2.21) all over. Material: Alum alloy.
- (5) Guide (220), angles (465, 470) and end panels (550, 555) -- Alodize (colored film) or chromic acid anodize (Ref 20-43-01) and apply one coat BMS 10-11, type 1 primer (SRF-2.30) all over. Material: Alum alloy.
- (6) Light housing assemblies (320, 325) -- Refinish per Fig. 1.



LIGHT HOUSING ASSY (320, 325)
(TYPICAL ALL SIDES)

1 FILL AND SAND IMPERFECTIONS AND APPLY BMS 10-83, TYPE 1 PRIMER AND BMS 10-83, TYPE 2 ENAMEL PER OPERATOR'S STANDARD COLOR SCHEME (F-22.05-XXX)

2 HI-SPEED FLAT BLACK ENAMEL (F-14.903-701)

3 FINE-WRINKLE-FINISH, GLOSS BLACK

Refinish Details
Figure 1

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- (7) Light fixture assembly (350) -- Apply black wrinkle-finish enamel MIL-E-5558, type 1 (fine wrinkle) to exterior surfaces per Fig. 1.
- (8) Plug (365) -- Apply two coats hi-speed flat lacquer, BAC701 black (F-14.903-701) to underside.
- (9) Channel (405), light shield (415), shade (425), angles (440, 445), box (450), brackets (480, 485), tube spacer (495), clip (515) and housing (520) -- Apply black anodic film as indicated below.
Material: Alum alloy.
 - (a) Chromic acid anodize (Ref 20-43-01), observing following requirements:
 - 1) Maintain temperature of anodizing bath at 90-122°F.
 - 2) Increase anodizing voltage from 0-40 volts dc during first 5 minutes. Maintain at 38-42 volts.
 - 3) Rinse in cold water. Do not seal.
 - (b) Immerse parts in dye solution per Fig. 2 for 10 minutes minimum. Control pH by adding acetic acid to prepared solution.
 - (c) Rinse in cold water containing no more than 100 parts per million dissolved solids.
 - (d) Seal in nickel acetate solution (Fig. 2) at 200-212°F for 5-10 minutes.
 - (e) Rinse in water containing no more than 100 parts per million dissolved solids at 200-212°F for 15 to 30 minutes.
 - (f) Dry at room temperature to 180°F.
- (10) Desk light assembly (235), light housing assemblies (320, 325), light assembly (340), housing assembly (430), box assembly (455) and panel assembly (530) -- Except as indicated for detail parts, apply BMS 10-83, type 1 primer and BMS 10-83, type 2 enamel per operator's standard color scheme (F-22.05-XXX) to all surfaces visible from airplane interior.

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SOLUTION		MAKEUP AND CONTROL (OZ. PER GAL.) *[1]	TEMPERATURE (DEGREES F)	pH	TIME (MINUTES)
Dye	Nigrosine Black	1.5-1.6	1406	4.5-5.0	10 (Minimum)
	Metanil Yellow	0.12-0.13			
Seal	Nickel Acetate	0.6-0.8	200-212	5-7	5-10
	Boric Acid	0.6-0.8			

*[1] Mix with clean water as required

Black Anodic Dye Solutions
Figure 2

C. Replacement

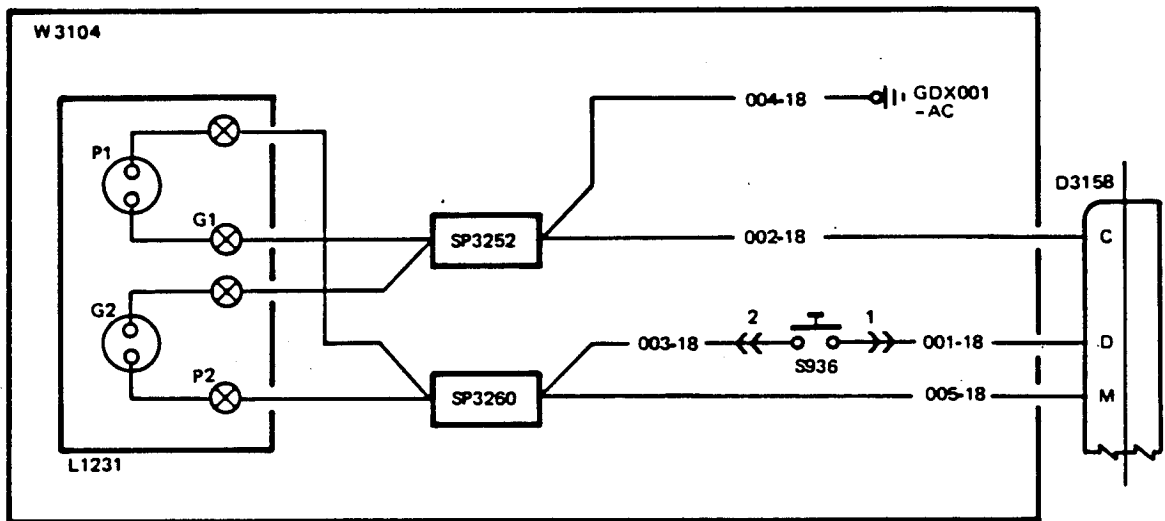
- (1) Replace nonrepairable parts using standard industry practices and additional procedures in subpar. (a) thru (c), below.
 - (a) Smooth surface on manufactured head side of rivets (410, 420, 435, 475, 500) after installing so that rivet head will not be noticeable after finish application.
 - (b) Apply flat black lacquer and BMS 10-83, types 1 and 2 to rivet heads per Refinish to match surrounding surfaces.
 - (c) Bond replacement decorative cover (560) per 20-50-12, using type 72 adhesive.

2. TESTING

- A. Test electrical circuit using standard industry practices (Fig. 3).

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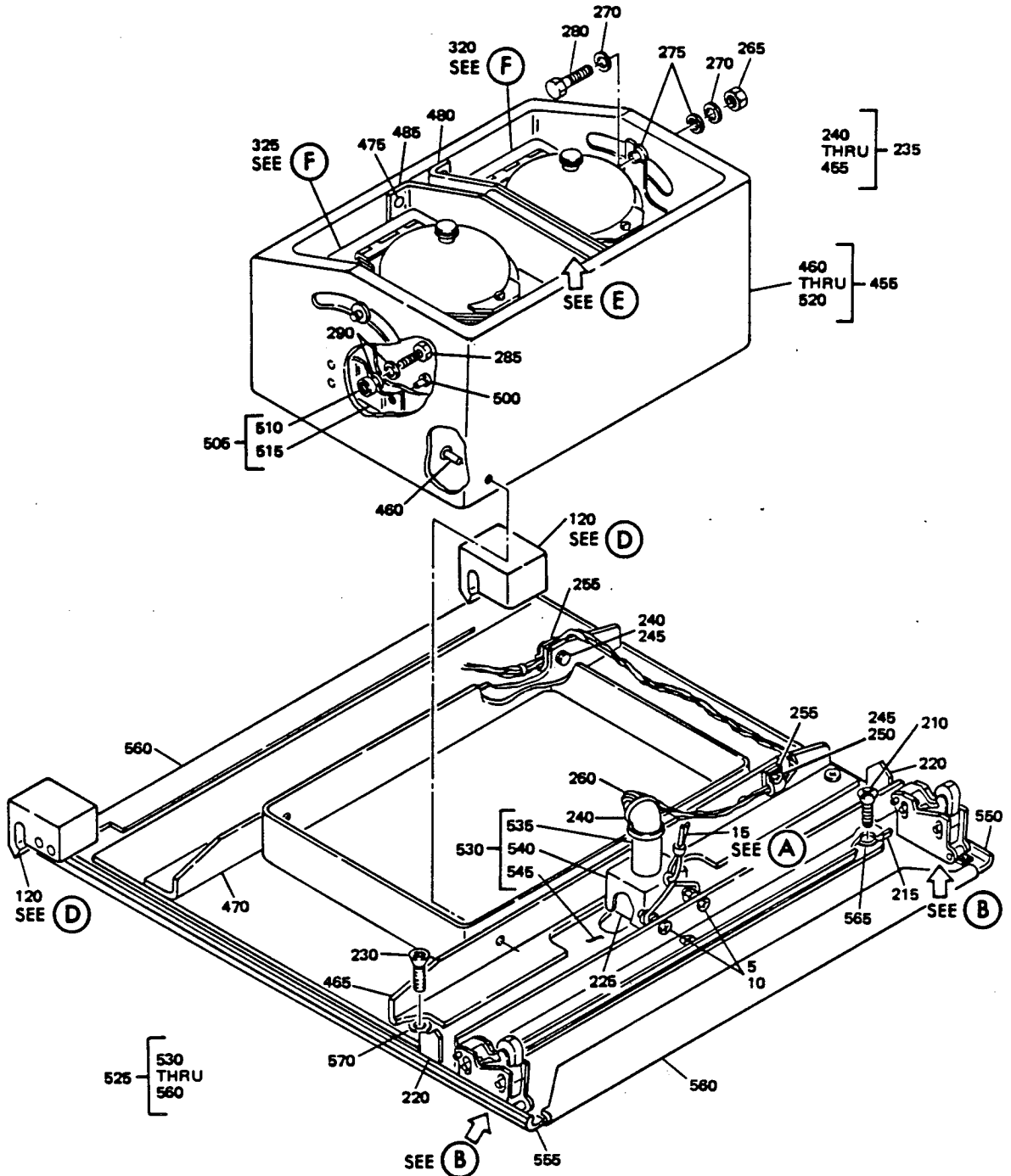


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Electrical Schematic Diagram
Figure 3

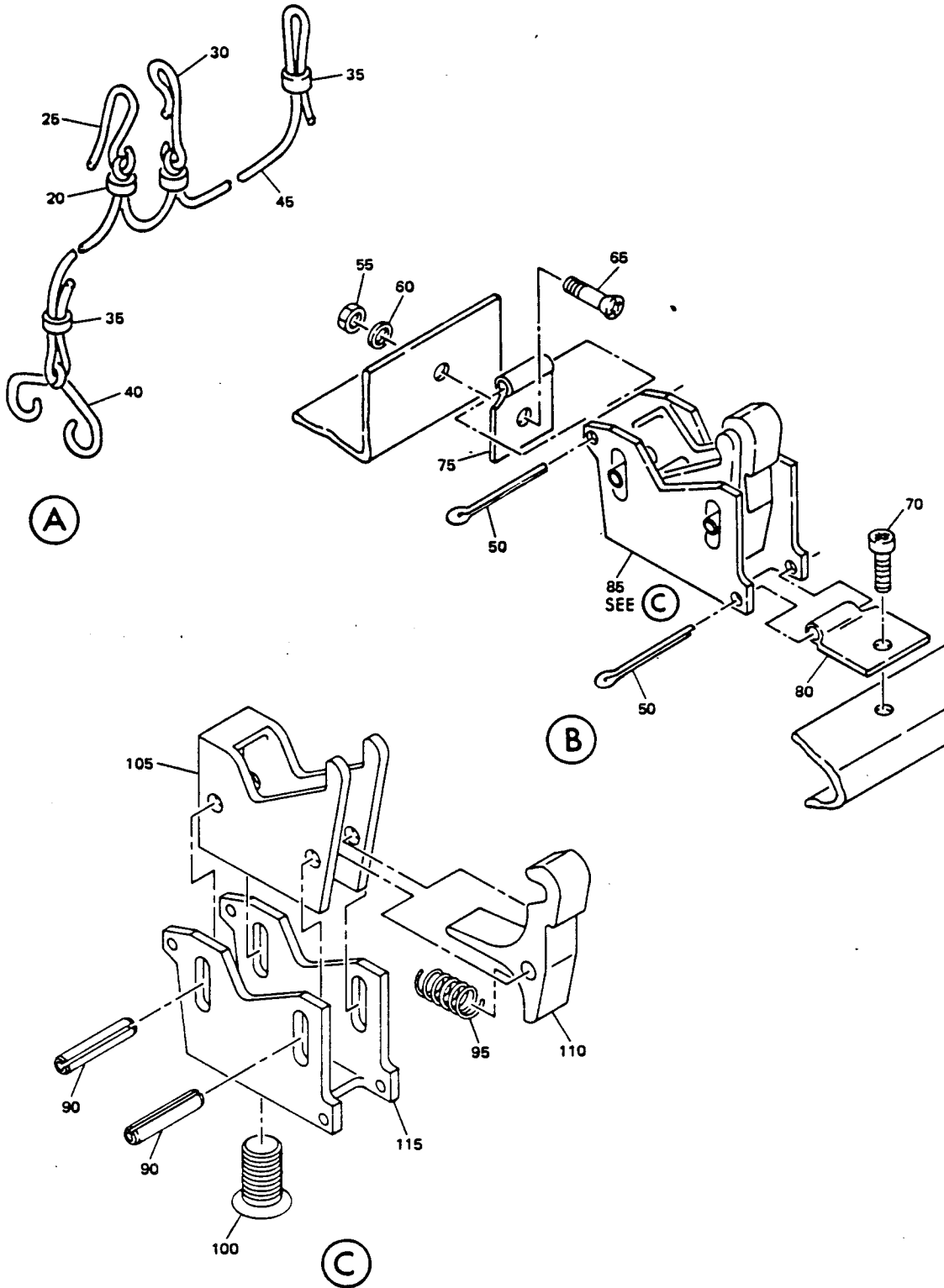
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3. ILLUSTRATED PARTS LIST



Desk Light Passenger Service Unit Assembly
Figure 4 (Sheet 1)

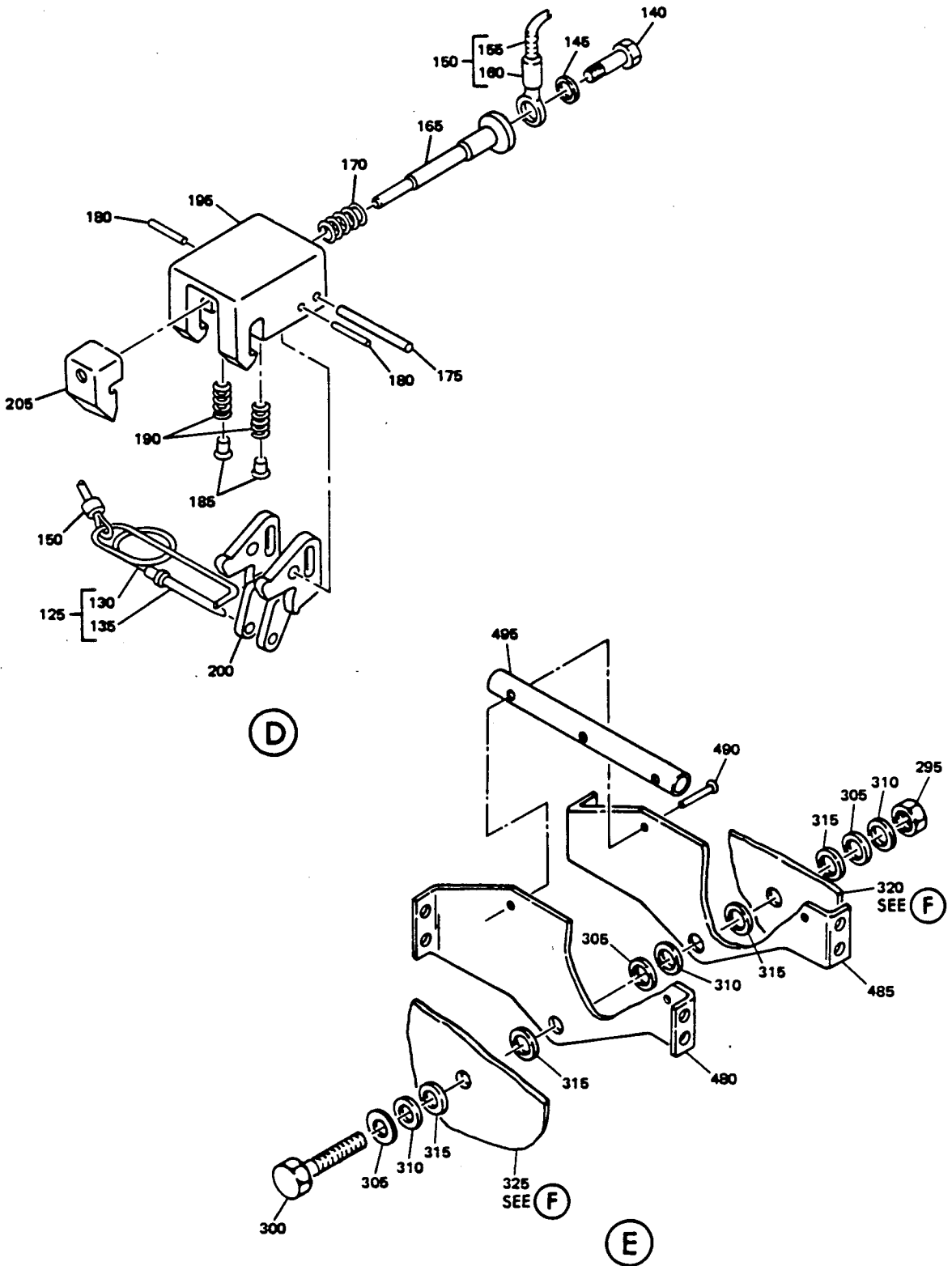
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Desk Light Passenger Service Unit Assembly
 Figure 4 (Sheet 2)

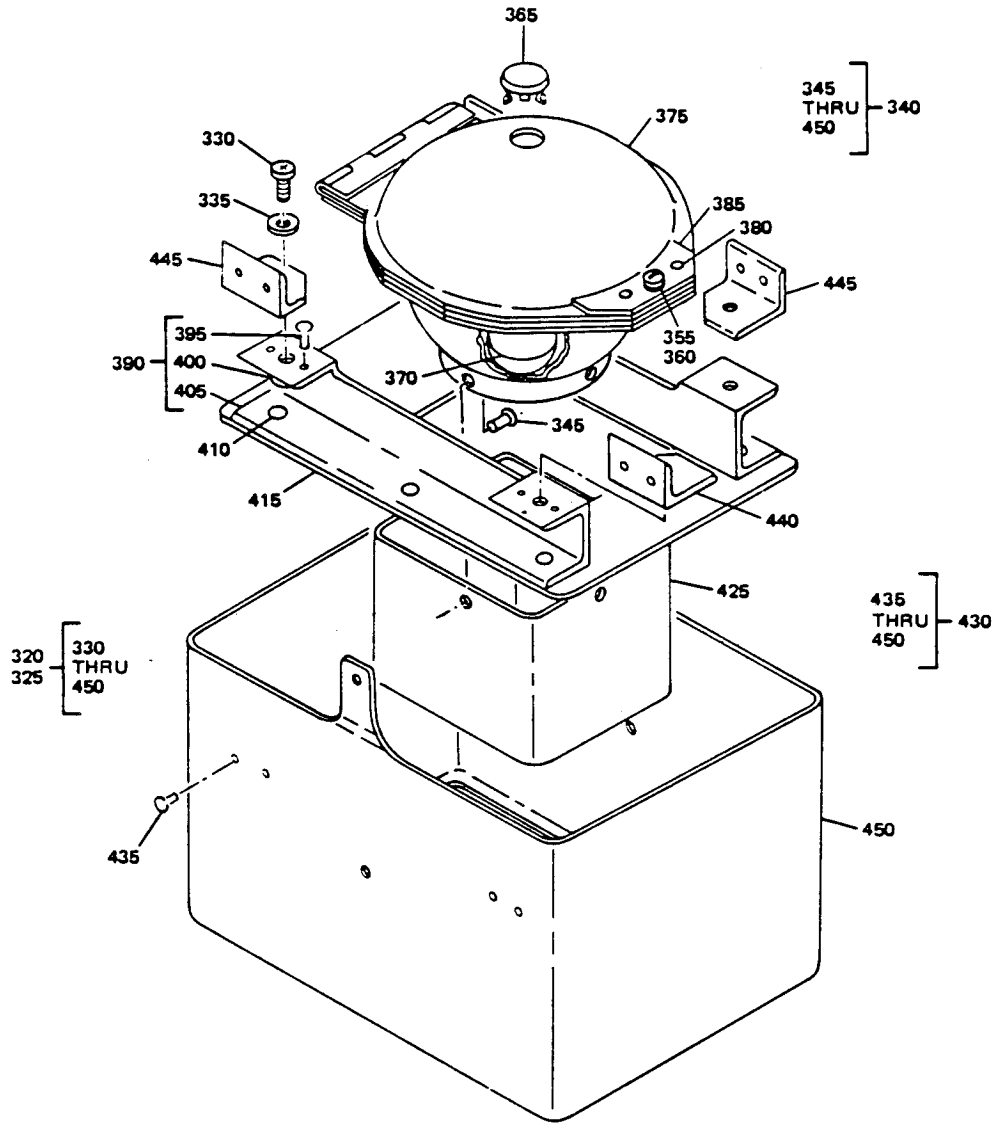
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Desk Light Passenger Service Unit Assembly
Figure 4 (Sheet 3)

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(F)

Desk Light Passenger Service Unit Assembly
Figure 4 (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		
4-1	65V10153-1									A	RF
1	65V10153-7									B	RF
1	65V10695-101									C	RF
5	BACN10JCO8										2
10	NAS602-5P										2
15	69-63824-1										1
20	MS17821-1-9										2
25	69-55039-2										1
25	69-55039-1										1
30	63-9446										1
35	BACS13S219C										2
35	BACS13S261C										2
40	63-10191-1										1
45	69-63824-2										1
50	MS24665-283										4
55	MS35649-282										2
60	MS35335-31										2
65	NAS514P832-6										2
70	NAS601-3P										2
75	69-64895-8										2
80	69-64895-7										2
85	65-85901-2										2
90	MS16562-35										2
95	RCS3288										1
100	65-85905-3										1
105	65-85907-1										1
110	65-85908-1										1
115	65-85906-1										1
120	65-85900-2										2
125	69-64539-1										1
130	69-64539-2										1
135	69-64539-3										1
140	NAS1191-06P4L										1
145	AN960PD6										1
150	69-61465-5										1
155	69-61465-6										1
160	BACT12AC8										1
165	65-85905-1										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		
4-											
170	RCS3290										1
175	NAS607-2-8P										1
180	NAS607-1-4P										2
185	65-85900-3										2
190	RCS3289										2
195	65-85904-1										1
200	65-85902-1										1
205	65-85903-2										1
210	NAS601-4P										3
215	65V10153-3										1
220	69-65183-1										2
225	691212-13A1										1
230	NAS602-4P										4
235	65V10387-1								A		1
235	65V10387-13								B		1
235	*[1]								C		1
240	424										1
245	BACN10JC3										2
250	BACS12CB3-6										2
255	BACC10DK5										2
260	61-23104-001										1
260	61-23104-002										1
260	61-33114-001										1
265	BACN10JC06										2
270	AN960PD6										4
275	NAS1515M06L										4
280	BACS12CB06-6										2
285	BACS12CB08-7										2
290	NAS1515M08L										4
295	BACN10JC3										1
300	BACB30NE3-7										1
305	BACW10CA3CVS										3
310	BACW10CA3CCS										3
315	NAS1515M3L										4
320	65V10379-1								AC		1
320	65V10379-22								B		1
325	65V10379-2								AC		1
325	65V10379-23								B		1
330	BACS12CB06-6										4
335	AN960PD06										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		
4-											
340	65V10379-14										1
345	BACR15BA3A										3
350	65V10379-4										1
355	5S5-10										1
360	5S3-1										1
365	65V10379-11										1
370	MS25235-3011										1
375	65V10379-12										1
380	BACR15BA3A										2
385	65V10379-9										1
390	65V10379-3										2
395	BACR15BA3A										4
400	BACN10JN06										2
405	65V10379-15										1
410	BACR15BA3A										6
415	65V10379-10										1
420	NOT USED										
425	65V10379-8										1
430	65V10379-5										1
430	65V10379-18										1
430	65V10379-19										1
435	BACR15BA3A										8
440	65V10379-16										2
445	65V10379-7										2
450	65V10379-13										1
450	65V10379-20										1
450	65V10379-21										1
455	65V10387-2								A		1
455	65V10387-14								B		1
455	*[1]								C		1
460	BACR15BA4D										6
465	65V10387-8										1
470	65V10387-12										1
475	BACR15BA3D										8
480	65V10387-6								A		2
480	65V10387-15								B		1
480	*[1]								C		1
											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		
4-											
485	65V10387-16									B	1
485	*[1]									C	1
490	BACR15BA3A									A	4
490	BACR15BA3A									BC	3
495	65V10387-7									A	1
495	65V10387-17									B	1
495	*[1]									C	1
500	BACR15BA3D										8
505	65V10387-4										2
510	NAS1329S08 K75L										1
515	65V10387-5										1
520	65V10387-3									A	1
520	65V10387-18									B	1
520	*[1]									C	1
525	65V10153-2										1
530	65V10387-9										1
535	710907-13A2										1
540	65V10387-10										1
545	65V10387-11										1
550	69-64744-9										1
555	69-64744-10										1
560	65V10153-4										1
565	SL644-06-03										5
570	SL644-08-03										4

*[1] NO BOEING PART NUMBER ASSIGNED

*[2] WIRE BUNDLES ARE IDENTICAL, AND ARE OPTIONAL TO EACH OTHER

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REFERENCE DESIGNATION INDEX (SEE SCHEMATIC DIAGRAM)		
REFERENCE DESIGNATION	PART NUMBER	ITEM NO.
L1231	65V10387-1, -13	240
S936	710907-13A2	545

VENDORS

V08205 RENTON COIL SPRING CO., P.O. BOX 328, 325 BURNETT N., RENTON,
WASHINGTON 98055

V71286 REXNORD INC., SPECIALTY FASTENER DIV., 22 SPRING VALLEY RD.,
PARAMUS, NEW JERSEY 07652

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

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