

BOEING 
COMMERCIAL JET
OVERHAUL MANUAL

TO: ALL HOLDERS OF OXYGEN SERVICE UNIT ASSY, 25-21-16

REVISION NO. 0, DATED JUL 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
Released new manual covering 65V10605-3, -4, -9, -11, -12, and -13 assemblies													

OXYGEN SERVICE UNIT ASSEMBLY

25-21-16

BOEING P/N 65V10605-3, -4, -9, -11, -12, -13

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					
PAGE	DATE	PAGE	DATE	PAGE	DATE
25-21-16					
* T-1	Jul 5/77				
* T-2	BLANK				
* LEP-1	Jul 5/77				
* LEP-2	BLANK				
* T/C-1	Jul 5/77				
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Testing	*
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Storage Instructions.	*
Special Tools, Fixtures, and Equipment.	None
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* This manual contains only refinish and replacement information, assembly, and illustrated parts list. All other approved procedures for this unit are in 25-20-00, Passenger Service Unit Overhaul Procedures.

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OXYGEN SERVICE UNIT ASSEMBLY

1. DESCRIPTION AND OPERATION

A. Description

- (1) The oxygen service unit assembly is located in various ceiling panels. These service units provide emergency oxygen and one-way communications from the control cabin. The unit is equipped with an oxygen mask and a speaker assembly. The oxygen mask is made accessible to the passenger when the door latch is released.

B. Operation

- (1) When the oxygen system is activated, line pressure releases the latch, the oxygen service door opens, and the emergency oxygen masks drop within the reach of the passenger. When the mask is pulled down to face level, the oxygen shutoff valve is opened, making oxygen ready for usage by the passenger. The door latch may also be released manually.

2. REPAIR

A. Refinish

NOTE: Refer to 20-30-02 for stripping of protective finishes and to 20-41-1 for explanation of F and SRF finish codes.

(1) Figure 3

- (a) Door hinges (35 and 40), door (95), hinge support brackets (50 and 55) -- Surface treat and apply one coat EMS 10-11, type 1 primer (SRF-2.30). Apply 3 coats high speed flat lacquer (F-22.01). Material: Alum alloy.
- (b) Door (95) -- Apply EMS 10-83, type 1 urethane primer and EMS 10-83 type 2 urethane enamel all over (F-22.05). Color: white (Boeing 7144). Material: Alum alloy - vinyl laminate.

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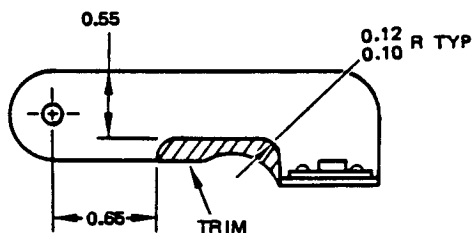
65V10605

(2) Figure 4

- (a) Door hinge (35, 40), hook bracket (65, 85) and plate assy (395) -- Surface treat and apply one coat BMS 10-11, type 1 primer (SRF-2.30). Apply 3 coats high speed flat lacquer of required color (F-22.01) all over. Material: Alum alloy.
- (b) Door (110) -- Apply BMS 10-83 type 1 urethane primer and BMS 10-83 type 2 urethane enamel all over (F-22.05). Color: white (Boeing 7144). Material: Alum alloy - vinyl laminate.

B. Replacement

- (1) Replace all parts found unserviceable or damaged beyond simple repair.
- (2) Replace speaker wires if broken or frayed or if insulation is damaged. Use EMS 13-5D, size No. 22, wire.
- (3) Replace insulating sleeves, on transformer secondary leads, if broken, cracked or frayed through, per 20-11-04.
- (4) If seal (160, Fig. 3) requires replacement, bond new seal to support ring (155, Fig. 3) per 20-50-12, type 46.
- (5) Replace speaker if cone has splits or tears or if it distorts signal excessively.
- (6) If brackets (70, 75, Fig. 3) are replaced, the new parts should be trimmed as shown in Fig. 1 to clear the mounting plate (110, Fig. 3).



Trim of Bracket Assemblies (50, 55)
Figure 1

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3. ASSEMBLY (Fig. 4)

- A. Assemble using standard shop practices and pertinent procedures in 25-20-00.
- B. Shims (30, Fig. 3, 30, 55, Fig. 4) and packing (90, Fig. 3) are used to adjust door fit with ceiling panel at time Oxygen Service Unit is installed in an airplane. Peel shim laminations to suit. Packing may be trimmed by sanding to reduce thickness.
- C. Do not separate spacer (115, Fig. 3) from mounting plate (110, Fig. 3) unless it must be replaced for damage. Bond spacer to mounting plate per 20-50-12, type 38.
- D. Do not separate angle (315, Fig. 4) or cover (335, Fig. 4) from container (320, Fig. 4) unless damaged. Bond these parts per 20-50-12, type 70, if required.
- E. Install installation items: (Assemblies 65V10605-3, -4, -9 shown in Fig. 3)

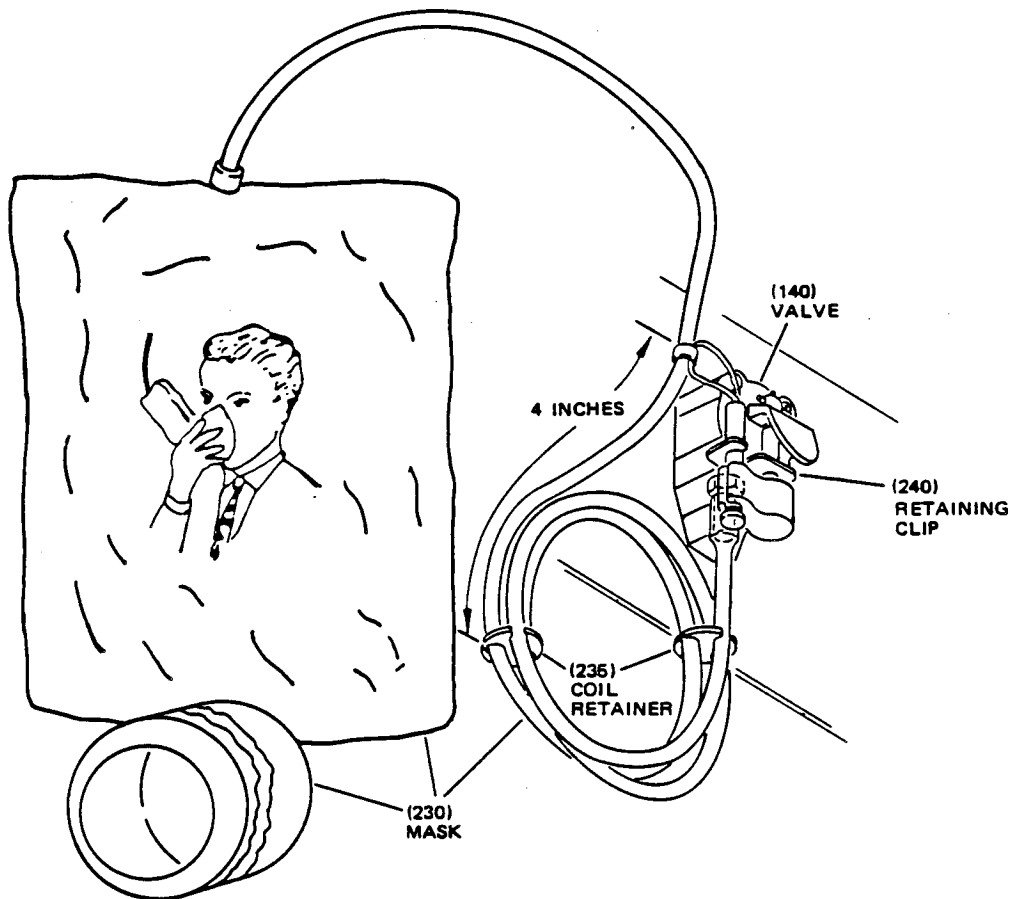
NOTE: Items installed in this paragraph are part of the Service Unit Oxygen Mask Installation and therefore, installation of these items may or may not be required during overhaul.

- (1) Prepare oxygen masks (230).
 - (a) Coil and secure hoses (Fig. 2, Step I).
 - (b) Clip lanyards to hoses.
 - (c) Insert lanyards into valve actuating pins.
 - (d) Attach head strap clips to mask baseplate.
 - (e) Apply talcum (245) to mask and bag.
 - (f) Wrap head strap around facepiece as shown in Fig. 2, Step 1.
- (2) Install hoses and valve actuating pins on outlet valves (Fig. 2, Step 2).
- (3) Fold reservoir bags.

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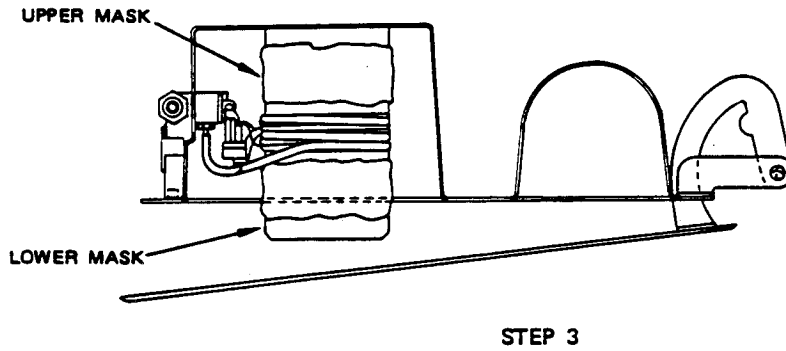
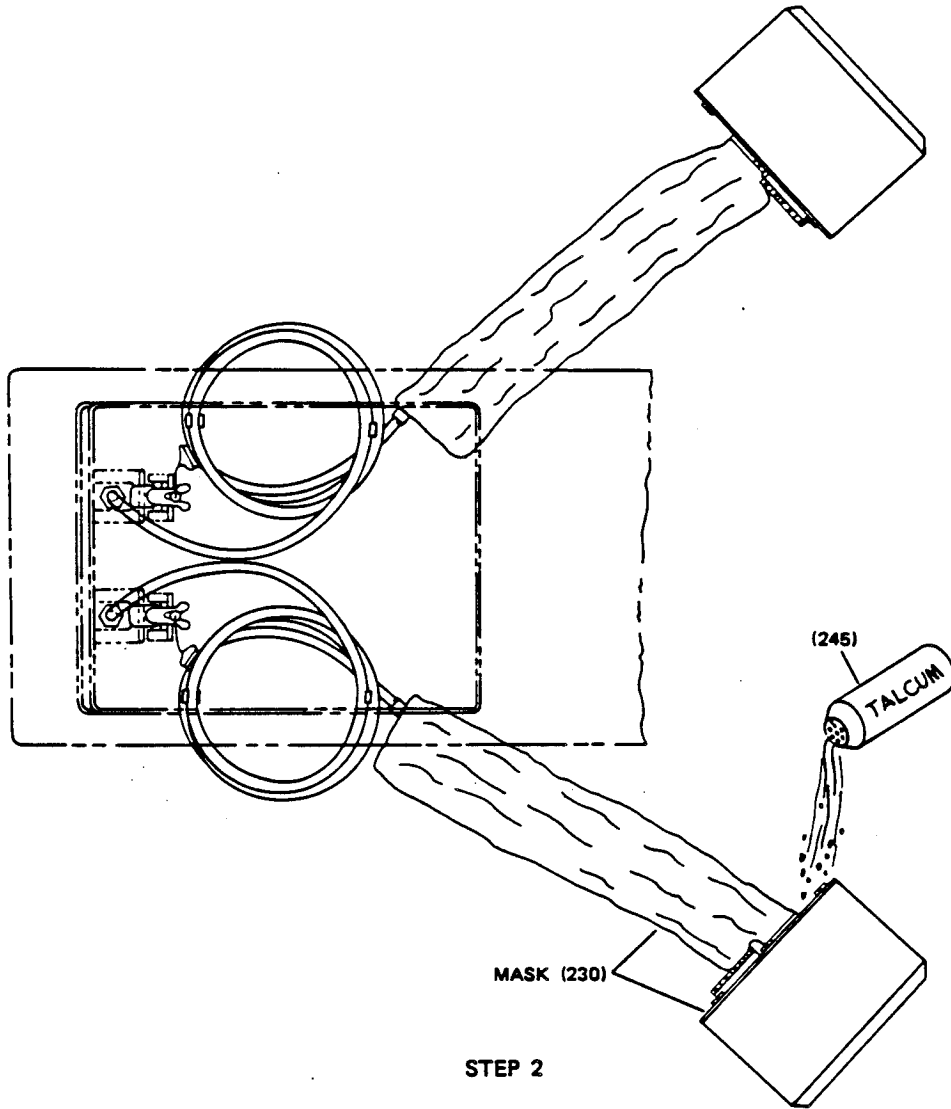
- (4) Wrap folded reservoir bag around facepiece of mask assembly. Place mask assembly inside oxygen mask box with open end of facepiece against box ceiling (Fig. 2, Step 3).
 - (5) Place coiled hose under mask against mask baseplate.
 - (6) Install second mask with hose coiled above baseplate and facepiece against door.
 - (7) Retain mask assemblies inside box with one hand as required and close door, ensuring both hooks are engaged.
- F. Install masks in assemblies 65V10605-11, -12, -13 per procedures in 25-20-00.



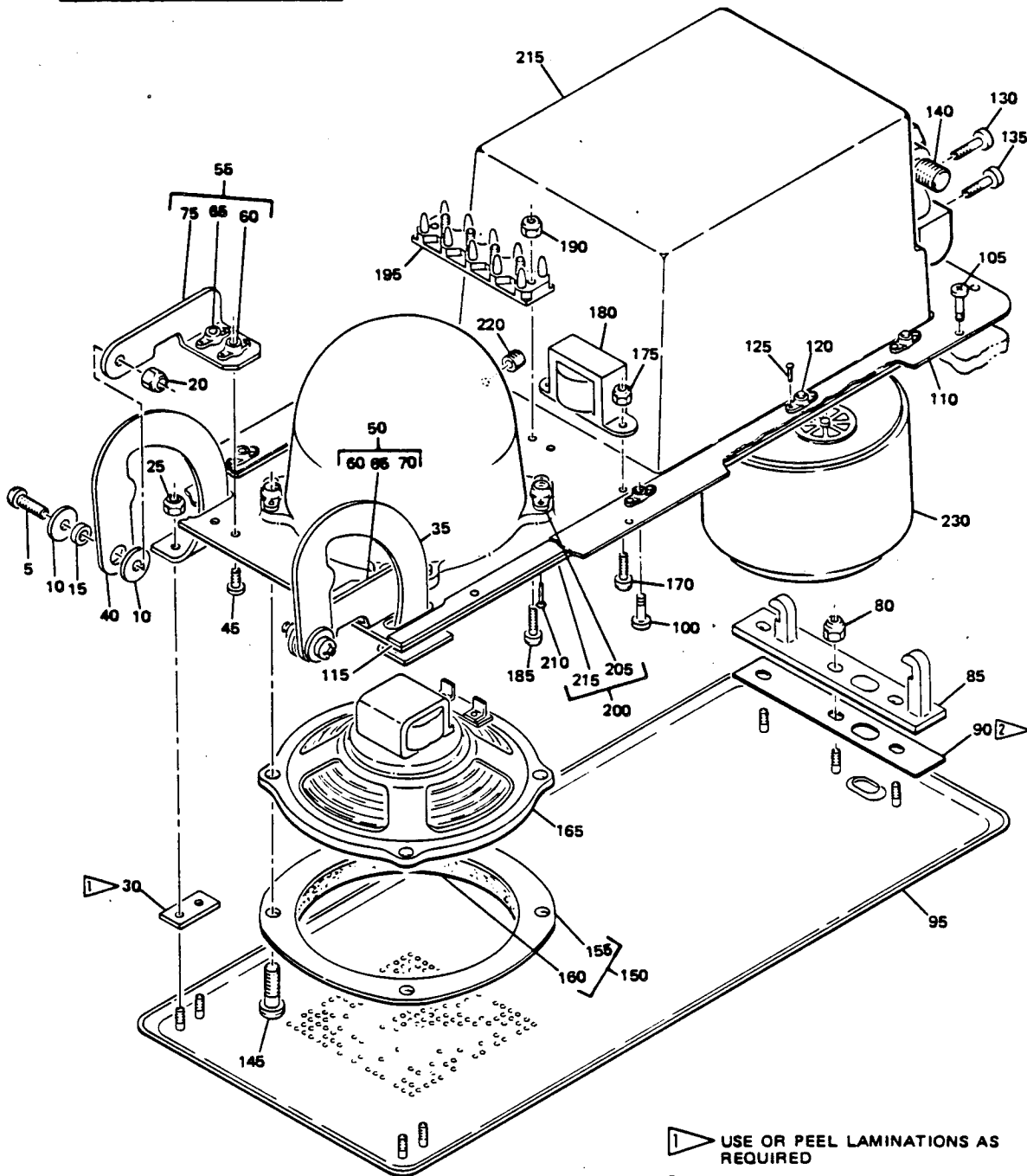
STEP 1

Oxygen Mask Installation
Figure 2 (Sheet 1)

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4. ILLUSTRATED PARTS LIST

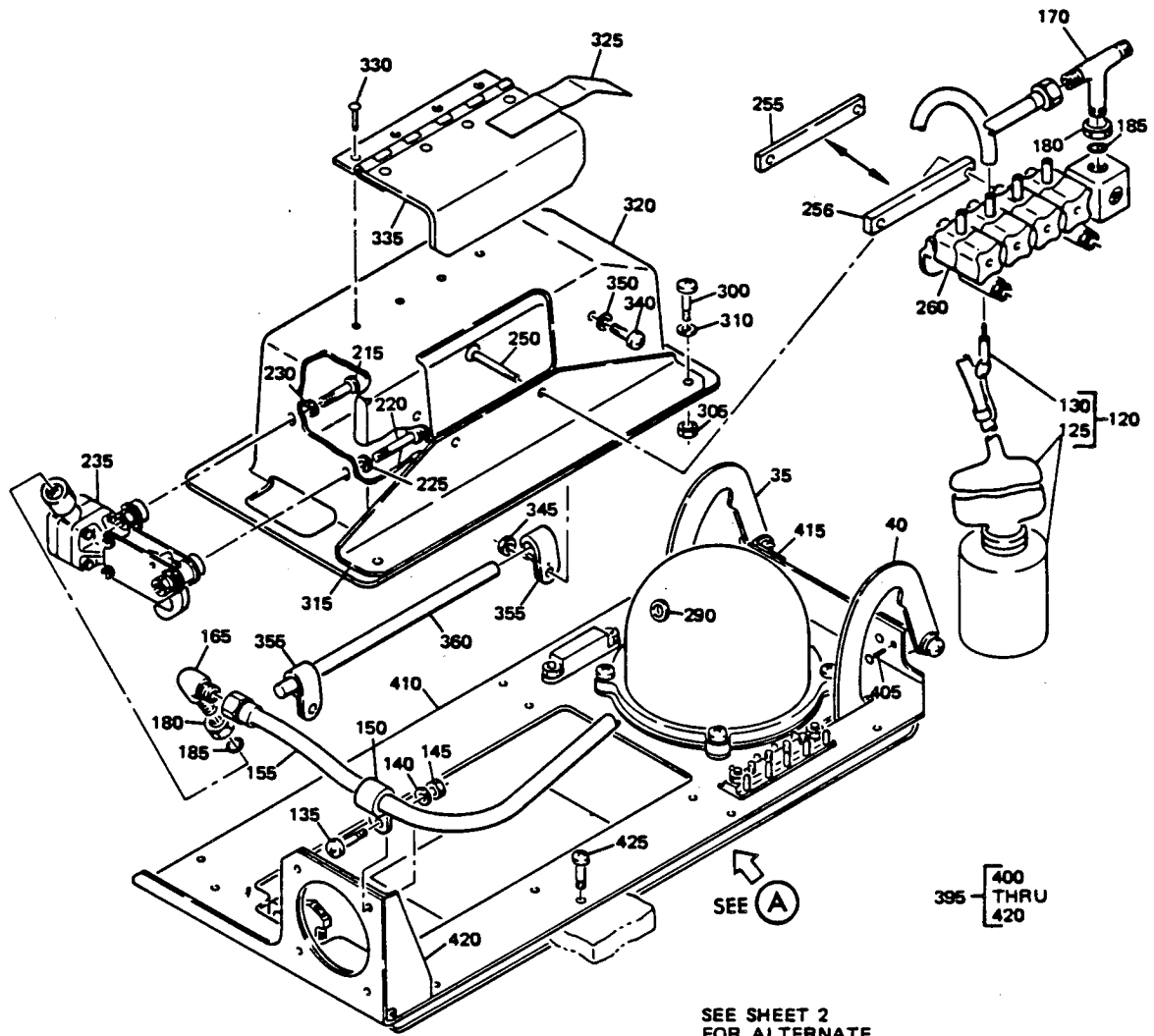


- 1 USE OR PEEL LAMINATIONS AS REQUIRED
- 2 USE IF REQUIRED TO ADJUST LATCH

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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		
3-											
1	65V10605-3									A	
1	65V10605-4									B	
1	65V10605-9									C	
5	NAS603-9P										2
10	BACW10P-193G										4
15	66-15702-1										2
20	BACN10JC3										2
25	BACN10MG-8										4
30	65-86016-2										2
35	66-16406-1										1
40	66-16406-2										1
45	NAS602-8P										4
50	66-16407-1										1
55	66-16407-2										1
60	BACN10JRO8										2
65	MS20426D3										4
70	66-16407-3										1
75	66-16407-4										1
80	BACN10MG8										3
85	66-15700-2										1
90	66-25579-1										1
95	65-21918-5									AB	1
95	65V10605-10									C	1
100	NAS602-8P										10
105	NAS602-6P										14
110	65-21920-1										1
115	65V10605-6										2
120	BACN10JRO8F										10
125	MS20426D3										20
130	NAS603-20P										2
135	NAS603-16P										2
140	115012										1
145	NAS602-20P										4
150	66-16857-1										1
155	66-16857-2										1
160	66-16857-4										1
165	A5C133										1
165	V5C133										1
165	V5C134										1
170	NAS601-8P										2
175	BACN10JC-06										2
180	T57272										1

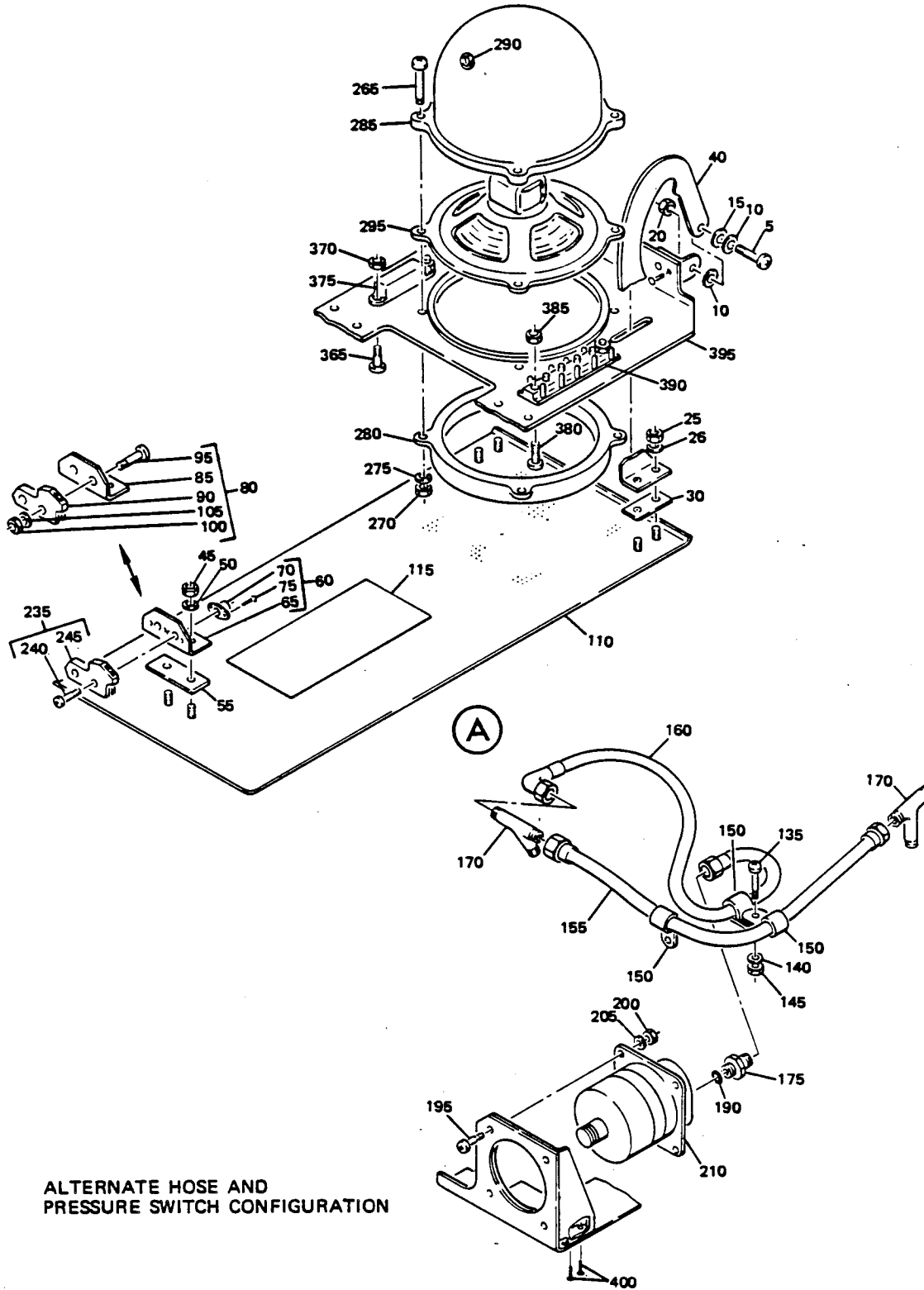
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SEE **A**

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 420

SEE SHEET 2
 FOR ALTERNATE
 HOSE AND PRESSURE
 SWITCH CONFIGURATION



ALTERNATE HOSE AND
 PRESSURE SWITCH CONFIGURATION

Oxygen Service Unit Assy
 Figure 4 (Sheet 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		
4-											
1	65V10605-11									A	RF
1	65V1D605-12									B	RF
1	65V1D605-13									C	RF
5	NAS603-9P										2
10	BACW10P193G										4
15	66-15702-1										2
20	BACN10JC3										2
25	BACN10MG8										4
26	AN960-8L										4
30	65-86016-2										2
30	BACS40C12-20										2
35	69V10319-7										1
35	69V10319-1										1
40	69V10319-8										1
40	69V10319-2										1
45	BACN10MG8										2
50	AN960-8L										2
55	BACS40R10D16F									AC	1
60	69V10372-2									AC	1
65	69V10372-4										1
70	BACN10JPO4A										2
75	MS20426B3										4
80	69V10316-2									B	1
85	69V10316-5										1
90	69V10316-3										1
95	NAS600-11										2
100	BACN10JC04										2
105	AN960-4L										2
110	65V11222-3									B	1
110	65V11222-5									AC	1
115	BAC27OPA1801										1
120	69V10315-3										3
125	289-701-27										1
130	210650										1
135	NAS603-10									A	1
135	NAS603-10									BC	2
140	AN960-10L									A	1
140	AN960-10L									BC	2
145	BACN10JC3									A	1
145	BACN10JC3									BC	2
150	BACC10DK6									A	1
150	BACC10DK6									BC	3
155	ZH833-31										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		
4-155	37001-31		. HOSE ASSY, V24984 (BOEING 10-60174-31)							1
160	ZH833-35		. HOSE ASSY, V02217 (BOEING 10-60174-35)						BC	1
160	37001-31		. HOSE ASSY, V24984 (BOEING 10-60174-35)						BC	1
165	65-87621-15		. ELBOW						A	1
170	65-87621-19		. TEE						A	1
170	65-87621-19		. TEE						BC	2
175	65-87621-21		. UNION, REDUCER						BC	1
180	AN-924-5J		. NUT, BULKHEAD							2
185	BACP11K-5		. O-RING							2
190	BACP11K-4		. O-RING						BC	1
195	NAS603-6		. SCREW						BC	4
200	BACN10JC3		. NUT						BC	4
205	AN960-10L		. WASHER						BC	4
210	40103		. SWITCH, PRESSURE, V09049 (BOEING 10-60121-1)						BC	1
215	NAS603-12		. SCREW							1
220	NAS603-22		. SCREW							1
225	AN960-8L		. WASHER							1
230	AN960-10L		. WASHER							1
235	118210-XX		. LATCH ASSY, V02217 (BOEING 65V11026-5)						AC	1
235	118210-01		. LATCH ASSY, V02217 (BOEING 65V11026-2)						B	1
240	NAS600-8		. . SCREW						AC	2
245	210784		. . HOOK, V02217 (PART OF 65V11026-5)							1
250	NAS514P1032-26		. SCREW							2
255	65V10687-42		. SPACER						AC	1
256	65V10687-19		. SPACER						B	1
260	65V11026-1		. MANIFOLD							1
265	NAS602-16P		. SCREW							4
270	BACN10JC08C		. NUT							4
275	AN960C8L		. WASHER							4
280	69V10320-1		. SEAL							1
285	65V10605-15		. SHROUD, SPEAKER							1
290	BACG20C-1		. GROMMET							1
295	A5C133		. SPEAKER, V80331							1
295	V5C133		. SPEAKER, V80331 (OPT TO A5C133)							1
295	V5C134		. SPEAKER, V80331 (OPT TO A5C133)							1

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			1	2	3	4	5	6	7		
4-											
300	NAS603-6										5
305	BACN10JC3										5
310	AN960-10L										5
315	69V10375-1										1
320	65V11204-1										1
325	65V10605-16										1
330	MS20470B4										4
335	65V11230-1										1
340	NAS603-7										2
345	BACN10JC3										2
350	AN960-10L										2
355	BACC10DK7										2
360	65V10687-18										1
365	NAS601-8										2
370	BACN10JC06C										2
375	T-57272										1
380	NAS600-8										2
385	BACN10JC04C										2
390	MS27212-1-4										1
395	65V11221-1										1
400	MS20426B4										2
405	MS20470B3										4
410	65V11221-4										1
415	65V11221-2										1
420	65V11221-3										1
425	NAS602-6 69V10321										12