

OVERHAUL MANUAL

TO: ALL HOLDERS OF AFT ATTENDANTS OXYGEN SERVICE UNIT ASSEMBLY OVERHAUL MANUAL,
 25-26-01

REVISION NO. 3, DATED MAR 5/90

HIGHLIGHTS

DESCRIPTION OF CHANGE	TOPICS AFFECTED												
	D & O	D / Assy	Cleaning	Insp / Chk	Repair	Assy	F / C	Test	T / Shooting	S / Tools	Storage	I P L	L / Overhaul
<p><u>NOTE:</u> Incorrect title on the highlight page was printed in Revision 2.</p> <p>Added oxygen service unit assy, P/N 65-68967 to header</p>		X			X	X		X					

AFT ATTENDANT'S OXYGEN SERVICE UNIT ASSEMBLY

25-26-01

BOEING P/N

65-53544-2, 65-68967-3

AIRLINE P/N

THE FOLLOWING DIRECTIVES APPLY TO THIS SUBJECT:

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVES	DATE DIRECTIVE INCORPORATED INTO TEXT
		PRR 30870	Jul 5/80

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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
25-26-01					
T-1	Jul 5/80				
T-2	BLANK				
* LEP-1	Mar 5/90				
LEP-2	BLANK				
T/C-1	Sep 10/72				
T/C-2	BLANK				
1	Jul 5/80				
* 2	Mar 5/90				
* 3	Mar 5/90				
* 4	Mar 5/90				
* 5	Mar 5/90				
6	Jul 5/80				
7	Sep 5/89				
8	BLANK				

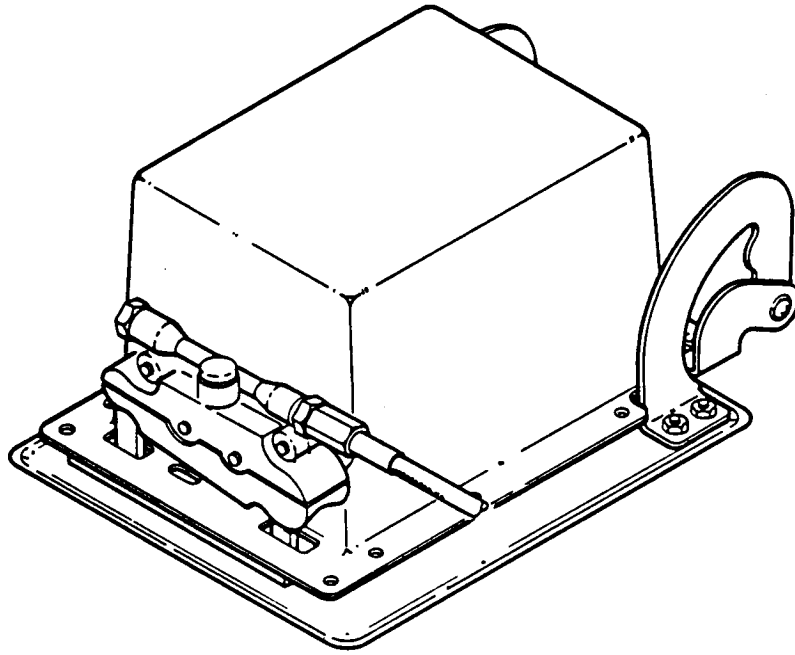
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AFT ATTENDANT'S OXYGEN SERVICE UNIT ASSEMBLY



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 an oro-nasal type oxygen mask which is automatically presented for use upon opening of the service unit door. The unit includes a door assembly, support bracket assembly, and manifold assembly. External oxygen supply connection is provided for through the manifold assembly.

B. Operation

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

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C. Leading Particulars

Height -- 5.0 inches (approximately)
Length -- 10.0 inches (approximately)
Width -- 5.5 inches (approximately)
Weight -- 2.0 pounds (approximately)

2. DISASSEMBLY (Fig. 2)

WARNING: THE PASSENGER 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: 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 and 4), spacers (3), and screws (5).

B. Remove nylon nuts (6) and hinges (7 and 8).

C. Remove nylon nuts (9) and hook plate (10) from door assembly (11).

NOTE: Do not remove studs (12) from door (13) unless repair or replacement is necessary.

D. Remove screws (14 and 15) and latch, valve, and manifold assembly (16).

NOTE: Refer to applicable manufacturer's instructions for overhaul of latch-valve manifold assembly (16).

E. Remove screws (17), washers (18), shims (19), and bracket assemblies (20 and 21).

NOTE: Do not remove nutplates (25) from brackets (22 and 23) unless replacement is necessary.

3. CLEANING (Fig. 2)

A. Metallic Parts (except oxygen system components)

(1) Wash and rinse hinges (7 and 8) and brackets (22 and 23) in solvent, Specification P-D-680, or equivalent.

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B. Nonmetallic Parts (except oxygen system components)

- (1) Wash all nonmetallic parts with a mild soap and water solution.
- (2) Dry all parts with clean, lint-free cloth or with clean, moisture-free compressed air.

C. Oxygen System Components

WARNING: DO NOT ALLOW OIL, GREASE, FLAMMABLE SOLVENTS, DUST, LINT, FINE METAL FILINGS OR OTHER COMBUSTIBLE MATERIALS TO ENTER OXYGEN SYSTEM. COMBUSTIBLE MATERIALS MAY IGNITE AND RESULT IN AN EXPLOSION WHEN EXPOSED TO OXYGEN UNDER PRESSURE.

- (1) Clean all oxygen system components per 20-30-03.
- (2) Install protective covers on all openings within 10 minutes after cleaning and checking.
- (3) Clean all vendor parts per manufacturer's instructions.

4. INSPECTION/CHECK

- A. Visually examine all parts for evidence of cracks, burrs, corrosion, or excessive wear, using strong light and 10-power magnification.
- B. Check all metal parts for bending, denting, or other damage which may interfere with mating of associated parts.
- C. Visually examine all threaded parts for cross-threading or stripping.
- D. Check door finish for scratches, blisters, or flaking.

5. REPAIR

A. Repair

- (1) Remove minor scratches, nicks, and corrosion from metal parts with abrasive cloth, 220 grit or finer. Refinish as required for corrosion protection.
- (2) Repair minor defects in threaded parts with triangular file or thread chaser.
- (3) Repair fiberglass parts as necessary using standard methods.
- (4) Rubber stamp damaged or illegible symbols, numbers, and letters.

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B. Refinish (Fig. 2)

NOTE: Refer to 20-30-02 for stripping of protective finishes, and to 20-41-01 for decoding of F and SRF finish symbols and their BAC equivalents.

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

(a) Hinges (7 and 8) -- Apply SRF-2.30 all over.

(b) Door (13) -- Apply SRF-2.30 all over.

(c) Brackets (22 and 23) -- Apply SRF-2.30 all over.

C. Replacement

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

6. ASSEMBLY (Fig. 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 MATERIALS VISIBLE FROM CABIN INTERIOR. THESE MATERIALS ARE EASILY SCRATCHED OR DENTED.

A. Install bracket assemblies (20 and 21) using screws (17), washers (18) and shims (19).

NOTE: Laminations may be removed from shims (19) if required.

B. Install latch, valve, and manifold assembly (16) and secure with screws (14 and 15).

C. Attach hook plate (10) to door assembly (11) with nylon nuts (9).

D. Install hinges (7 and 8) and secure with nylon nuts (6).

E. Install door assembly (11) with nut (1), washers (2 and 4), spacer (3), and screws (5).

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7. TESTING (Fig. 2)

- A. With door assembly (11) closed, actuate manual release pin on latch, valve, and manifold assembly and check for satisfactory door operation.

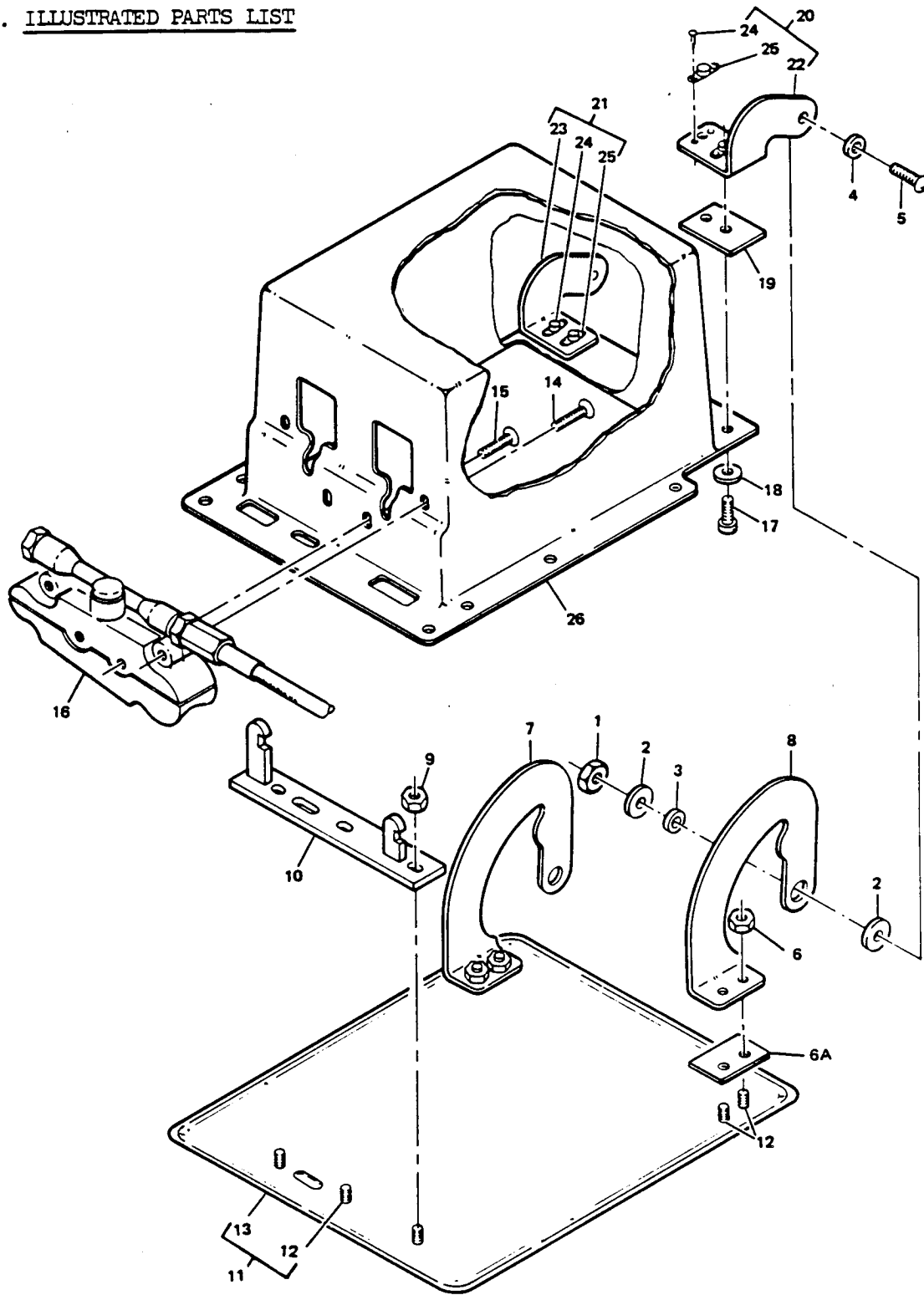
8. STORAGE INSTRUCTIONS

- A. Wrap assembly in vapor barrier paper.
- B. Crate and seal assembly airtight in controlled room with temperature of 75 \pm 15°F and ninety percent relative humidity, maximum.

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

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

12. ILLUSTRATED PARTS LIST



Aft Attendant's Oxygen Service Unit Assembly
Figure 2

65-53544
65-68967



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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-	65-53544-2		OXY SERVICE UNIT ASSY, AFT ATT							A	RF
	65-68967-3		OXY SERVICE UNIT ASSY, AFT ATT							B	RF
1	NAS679A3W		. NUT								2
2	BACW10P193G		. WASHER								4
3	66-15702-1		. SPACER								2
4	AN960PD10L		. WASHER								2
5	NAS603-9P		. SCREW								2
6	BACN10MG8		. NUT								4
6A	BACS40R10D11		. SHIM, LAM							B	2
7	69-46294-5		. HINGE							A	1
7	69-46294-7		. HINGE							B	1
8	69-46294-6		. HINGE								1
9	BACN10MG8		. NUT								3
10	66-15700-2		. HOOKPLATE							A	1
10	69-55471-1		. HOOKPLATE							B	1
11	69-46213-2		. DOOR ASSY							A	1
11	65-68969-1		. DOOR ASSY							B	1
12	BACS21AQ2A3M		. . STUD							A	7
13	69-46213-4		. . DOOR (USED ON 69-46213-2)							A	1
14	NAS603-20P		. SCREW								2
15	NAS603-16P		. SCREW								2
16	115012-01		. ASSEMBLY, LATCH, VALVE, AND MANIFOLD, V16827 (BOEING 10-60732-2)								1
17	NAS602-8P		. SCREW								4
18	AN960PD8L		. WASHER								4
19	BACS40R10D11		. SHIM							A	2
20	69-46294-1		. SUPPORT BRACKET ASSY, HINGE								1
21	69-46294-2		. SUPPORT BRACKET ASSY, HINGE								1
22	69-46294-3		. . BRACKET (USED ON 69-46294-1)								1
23	69-46294-4		. . BRACKET (USED ON 69-46294-2)								1
24	MS20426D3		. . RIVET								4
25	NAS680A08		. . NUTPLATE								2
26	65-58254-2		. BOX								1

VENDORS

V16827 PURITAN-BENNETT AERO SYSTEMS, 10800 PFLUM ROAD, LENEXA, KANSAS 66210