



OVERHAUL MANUAL

TO: ALL HOLDERS OF PALLETIZED CARGO SYSTEM SIDE RESTRAINT GUIDE RAIL ASSEMBLY
OVERHAUL MANUAL, 25-56-30

REVISION NO. 2, DATED DEC 5/85

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>Added 65-63639-3 side restraint guide rail assembly per PRR 32721 which incorporates new bumper block.</p> <p>Added Table of Contents</p>				X	X							X	



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PALLETIZED CARGO SYSTEM SIDE RESTRAINT GUIDE RAIL ASSEMBLY

25-56-30

BOEING P/N 65-63639-1, -2, -3
65-63642-1 thru -5

AIRLINE P/N

THE FOLLOWING DIRECTIVES APPLY TO THIS SUBJECT:

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVES	DATE DIRECTIVE INCORPORATED INTO TEXT
25-1051		PRR RC 12048 PRR 32721	Jun 10/70 Jun 10/70 Dec 5/85

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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
25-56-30					
* T-1	Dec 5/85				
T-2	BLANK				
* LEP-1	Dec 5/85				
LEP-2	BLANK				
* T/C-1	Dec 5/85				
* T/C-2	BLANK				
1	Jul 5/76				
* 2	Dec 5/85				
* 3	Dec 5/85				
4	Jul 5/76				
5	BLANK				
* 6	Dec 5/85				
* 7	Dec 5/85				
* 8	Dec 5/85				



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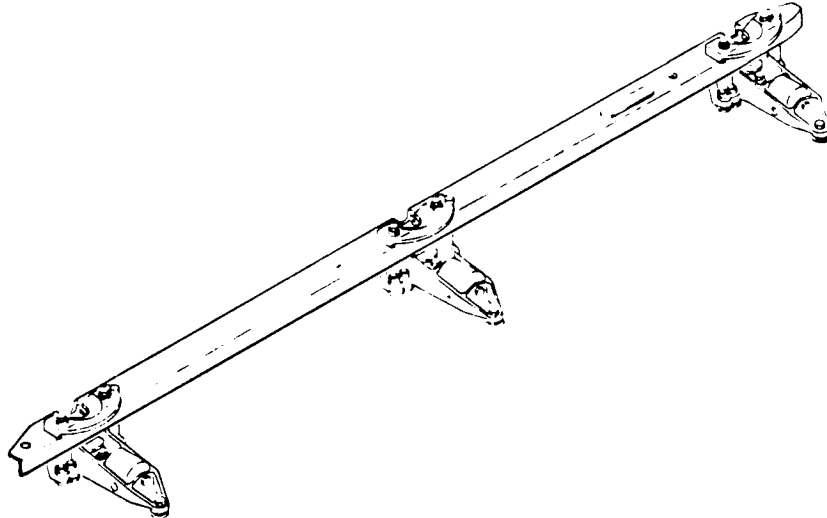
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Fits and Clearances	None
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Trouble Shooting.	None
Storage Instructions.	*[1]
Special Tools, Fixtures, and Equipment.	None
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*[1] Special instructions not required. Use standard industry practices

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PALLETIZED CARGO SYSTEM SIDE RESTRAINT GUIDE RAIL ASSEMBLY



Palletized Cargo System Side Restraint Guide Rail Assembly
Figure 1

1. DESCRIPTION AND OPERATION

A. Description

- (1) The palletized cargo system side restraint guide rail assembly consists of an inverted channel beam to which is secured guide assemblies and vertical restraint (lip) assemblies. Each guide assembly contains a roller or ball bearing on which the cargo pallet rests.

B. Operation

- (1) The palletized cargo system side restraint guide rail assembly provides side guidance and vertical and horizontal restraint for cargo pallets. The vertical restraint assembly has a lip which protrudes over the edge of the cargo pallet and restricts upward movement of the pallet. The lip can be retracted by pulling a spring-loaded plunger pin and rotating the assembly 180 degrees horizontally around a pivot bolt.

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C. Leading Particulars (Approx)

Length -- 48 inches
Width -- 7 inches
Height -- 4 inches
Weight: 65-63639 -- 14 pounds
65-63642 -- 10 pounds

2. DISASSEMBLY (Fig. 2)

NOTE: Disassemble this component only as necessary to complete fault isolation, determine the serviceability of parts, perform required repairs, and restore the unit to a serviceable condition.

A. Use standard industry practices for disassembly of this component and additional procedures in steps B and C.

B. Disassemble lip assembly (8) as follows:

(1) Apply pressure to bottom of pin (10) and remove spring pin (9) and knob (12).

NOTE: Spring (11) force is approximately 3 pounds.

(2) Gradually release spring (11) force and remove pin (10) and spring (11).

C. Overhaul guide assemblies (15 or 16) per 25-56-22

3. Deleted

4. INSPECTION/CHECK (Fig. 2)

A. Check all parts for obvious defects in accordance with standard industry practices.

B. Perform penetrant examination per 20-20-02 on lip (13), guide rail (17 or 18), filler bar (22), and bumper block (25).

C. Check spring (11) for approximate free length of 0.440 inch. Compress to 0.247-inch length. Load required should be within 2.88 to 3.52 pounds.

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5. REPAIR (Fig. 2)

- A. Use standard industry practices for repair of this component.
- B. 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) Radius filler (7), guide rail (17 or 18) and filler bar (22) -- Apply chromic acid anodize (F-2.20) all over. Material: Al alloy.
- (2) Lip (13) -- Apply sulphuric acid anodize (F-2.201) dyed red all over. Material: Al alloy.
- (3) Knob (12) -- Apply cadmium plate (F-1.191) all over. Material: 4130 steel.
- (4) Pin (10) -- Passivate (F-8.07) and apply dry lubricant BMS 3-3, type 1, per 20-50-08, to 0.252 diameter surface only. Material: 17-4PH CRES, 180-200 ksi.
- (5) Bumper block (25) -- Apply one coat of BMS 10-11, type 2, red epoxy enamel (SRF-14.905-101). Color chip matching not required. Material: Al alloy.

C. Replacement (Fig. 2)

- (1) Replace all parts found unserviceable or damaged beyond simple repair.
- (2) Replace unserviceable marker (24) on guide rail (17 or 18) in accordance with 20-50-05.

6. ASSEMBLY (Fig. 2)

- A. Use standard industry practices for assembly of this component and additional procedures in steps B and C.

B. Preassemble lip assembly (8) as follows:

- (1) Install spring (11) on pin (10) and position in hole in lip (13).

CAUTION: PIN (10) HAS DRY FILM LUBRICATED BEARING SURFACE WHICH MUST BE KEPT CLEAN AND PROTECTED FROM MECHANICAL DAMAGE DURING ASSEMBLY.

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- (2) Apply pressure to bottom of pin (10) as necessary to position knob (12) on pin (10).
- (3) Continue pressure on bottom of pin (10) and install spring pin (9) in knob (12) through hole in pin (10).

NOTE: Spring (11) force is approximately 3 pounds.

- C. Use washers (6) only on pivot side, if and as required, to limit clearance between lip assembly (8) and guide rail (17 or 18) to 0.000-0.015 inch. Lip assembly (8) must be free to rotate after tightening pivot bolt (2).

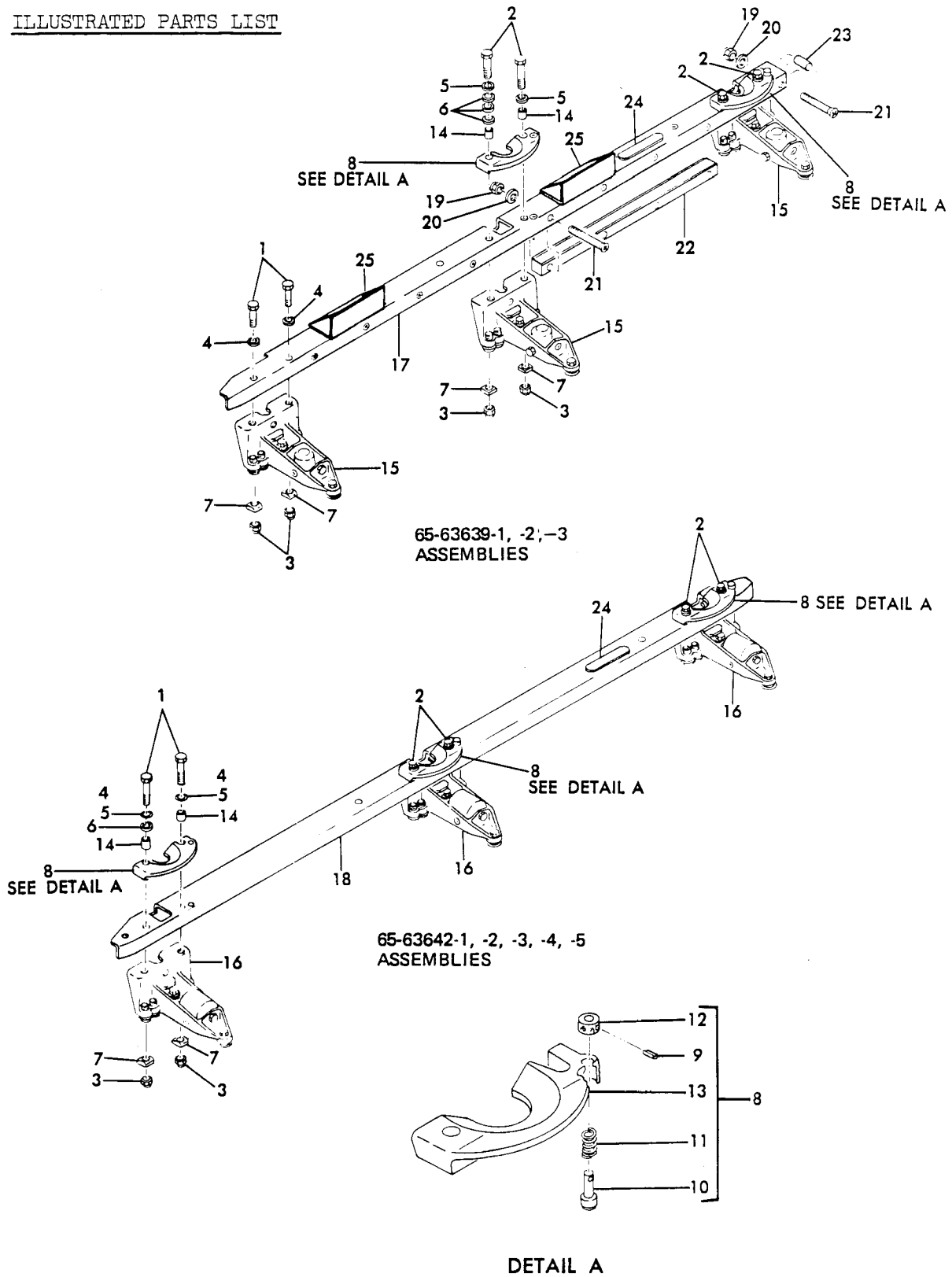
7. TESTING (Fig. 2)

A. Functional Test

- (1) Test lip assembly (8) for freedom of operation on guide rail (17 or 18) as follows:
 - (a) Pull up knob (12) to retract spring-loaded pin (10) from engaging hole in guide rail (17 or 18).
 - (b) Swing lip assembly (8) from stowed to extended position and back. Allow pin (10) to engage hole in guide rail in each position.
 - (c) Lip assembly and spring-loaded pin must move freely without binding or excessive looseness.

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8. ILLUSTRATED PARTS LIST



Palletized Cargo System Side Restraint Guide Rail 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-	65-63639-1		PALLETIZED CARGO SYSTEM SIDE RESTRAINT GUIDE RAIL ASSY							A	RF
	*[1]		PALLETIZED CARGO SYSTEM SIDE RESTRAINT GUIDE RAIL ASSY (REWORKED FROM 65-63639-1 BY SB 25-1051)								
	65-63639-2		PALLETIZED CARGO SYSTEM SIDE RESTRAINT GUIDE RAIL ASSY							B	RF
	65-63639-3		PALLETIZED CARGO SYSTEM SIDE RESTRAINT GUIDE RAIL ASSY							H	RF
	65-63642-1		PALLETIZED CARGO SYSTEM SIDE RESTRAINT GUIDE RAIL ASSY							C	RF
	65-63642-2		PALLETIZED CARGO SYSTEM SIDE RESTRAINT GUIDE RAIL ASSY							D	RF
	65-63642-3		PALLETIZED CARGO SYSTEM SIDE RESTRAINT GUIDE RAIL ASSY							E	RF
	65-63642-4		PALLETIZED CARGO SYSTEM SIDE RESTRAINT GUIDE RAIL ASSY							F	RF
	65-63642-4		PALLETIZED CARGO SYSTEM SIDE RESTRAINT GUIDE RAIL ASSY							G	RF
1	NAS1105-7		. BOLT							AEFH	2
1	NAS1105-16		. BOLT							CDG	2
2	NAS1105-7		. BOLT							BEF	4
2	NAS1105-16		. BOLT							ACDGH	4
3	BACN10JC5		. NUT (REPLS NAS679A5)								6
4	AN960PD516L		. WASHER							AEFH	2
5	BACW10P115S		. WASHER							AH	4
5	BACW10P115S		. WASHER							CDG	6
6	AN960PD716L		. WASHER							ACDGH	AR
7	66-23325-1		. FILLER, RADIUS								6
8	69-36364-1		. LIP ASSY, SIDE RESTRAINT							AH	2
8	69-36364-1		. LIP ASSY, SIDE RESTRAINT							CDG	3
9	MS16562-3		. . PIN, SPRING								1
10	66-21714-1		. . PIN								1
11	MS24585C89		. . SPRING								1
12	66-21266-1		. . KNOB								1
13	65-43624-1		. . LIP								1
14	NAS43HT5-37		. SPACER							A	4
14	NAS43HT5-37		. SPACER							CDG	6
14	NAS43HT5-38		. SPACER							H	4
15	65-37244-22		. GUIDE ASSY (REFER TO 25-56-22 FOR OVERHAUL INSTRUCTIONS)							ABH	

