

PASSENGER SEAT PALLET QC CARGO SYSTEM STOP ASSEMBLY

25 - 56 - 34

BOEING P/N 65-74572-18
65-76670-8, -14
65C16136-2

AIRLINE P/N

THE FOLLOWING DIRECTIVES APPLY TO THIS SUBJECT:

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVES	DATE DIRECTIVE INCORPORATED INTO TEXT
		PRR 33237-R	Jun 5/84

OVERHAUL MANUAL

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
25-56-34					
* T-1	Jun 5/84				
* T-2	BLANK				
* LEP-1	Jun 5/84				
* LEP-2	BLANK				
* T/C-1	Jun 5/84				
* T/C-2	BLANK				
* 1	Jun 5/84				
* 2	Jun 5/84				
* 3	Jun 5/84				
* 4	Jun 5/84				
* 5	Jun 5/84				
* 6	Jun 5/84				



OVERHAUL MANUAL

TABLE OF CONTENTS

<u>Paragraph Title</u>	<u>Page</u>
Description and Operation	1
Disassembly*[1]	
Cleaning.*[1]	
Inspection/Check.	1
Repair.	1
Assembly.	2
Fits and Clearances (Not Applicable)	
Testing (Not Applicable)	
Trouble Shooting (Not Applicable)	
Storage Instructions.*[1]	
Special Tools, Fixtures, and Equipment (Not Applicable)	
Illustrated Parts List.	3

*[1] Special instructions not required. Use standard industry practices.

OVERHAUL MANUAL

PASSENGER SEAT PALLET QC CARGO SYSTEM STOP ASSEMBLY

1. DESCRIPTION AND OPERATION

A. The stop assembly consists of a rail, two rollers, steel brackets, and attach angles. The assembly provides fwd and aft restraint to passenger seat pallet. The assembly is fastened to airplane seat tracks with shear studs.

B. Leading Particulars (approximate)

Width -- 0.05 to 0.075 inch

Length -- 37.0 to 49.0 inches

Height -- 2.0 to 3.0 inches

2. INSPECTION/CHECK (Fig. 1)

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

B. Magnetic particle check per 20-20-01 -- brackets (20, 25)

C. Penetrant check per 20-20-02 -- rails (105, 110)

3. REPAIR (Fig. 1)

A. Materials

NOTE: Equivalent substitutes may be used.

(1) Primer -- BMS 10-11, Type 1 (Ref 20-60-02)

(2) Lacquer -- Hi-Speed, semigloss brown (Ref 20-60-02)

(3) Adhesive -- BAC 5010, Type 40 (Ref 20-50-12)

OVERHAUL MANUAL

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) Brackets (20, 25) -- Cadmium plate (SRF 1.92) per 20-42-05, type 2, class 2, and apply one coat of BMS 10-11, type 1, primer per 20-41-02. Material: 17-4 PH CRES, 180-220 Ksi.
- (2) Rails (105, 110) -- Alodize (SRF-2.30) using colored film, or chrome acid anodize, type 1, and apply one coat of zinc chromate primer or one coat BMS 10-11, type 1, primer per 20-41-02. Then apply two coats of Hi-Speed semigloss lacquer (F-14.904-849) color brown per 20-41-04. Material: Al Alloy.

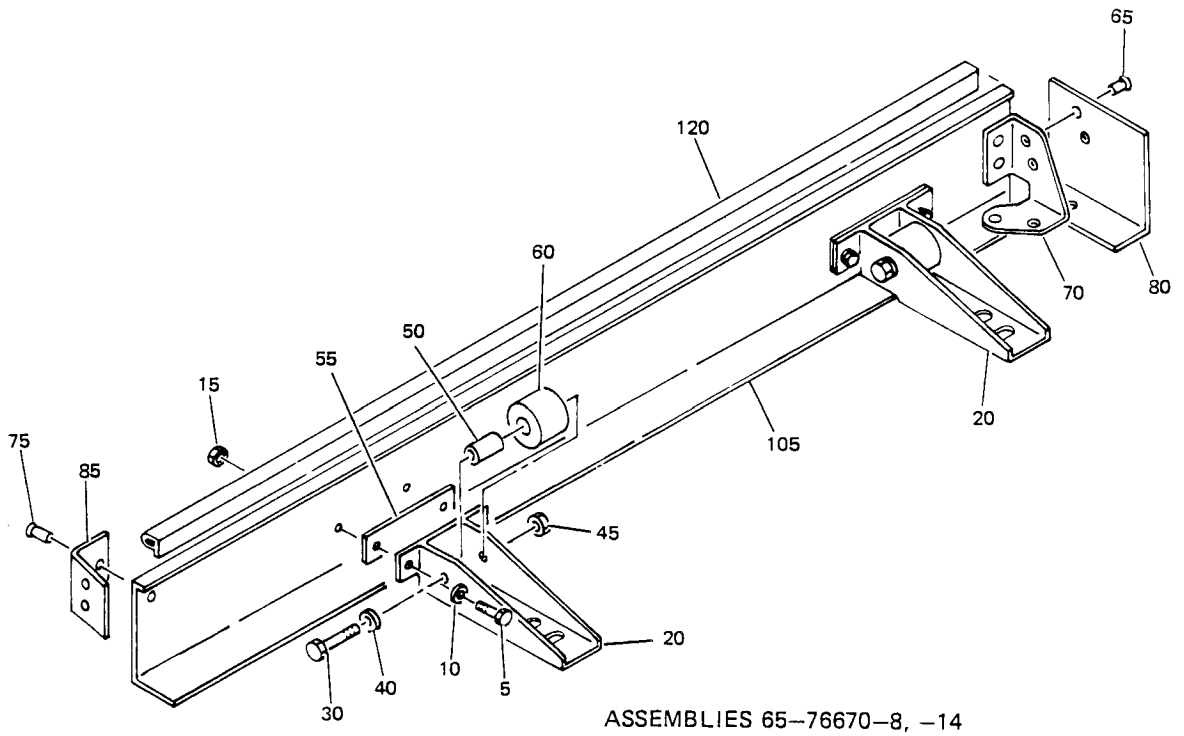
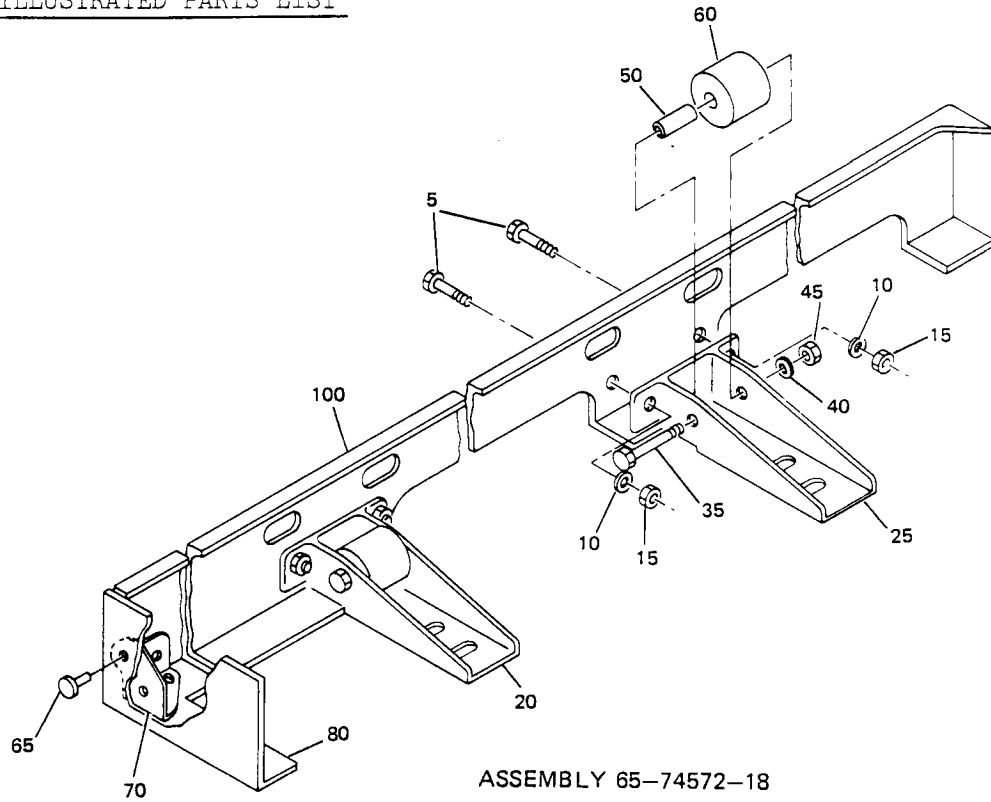
4. ASSEMBLY (Fig. 1)

- A. Use standard industry practices for assembly of this component, and additional procedure in step B.
- B. Trim new seal (115) and bond in rail (105) using type 40 adhesive per 20-50-12.

65-74572
65-76670
65C16136

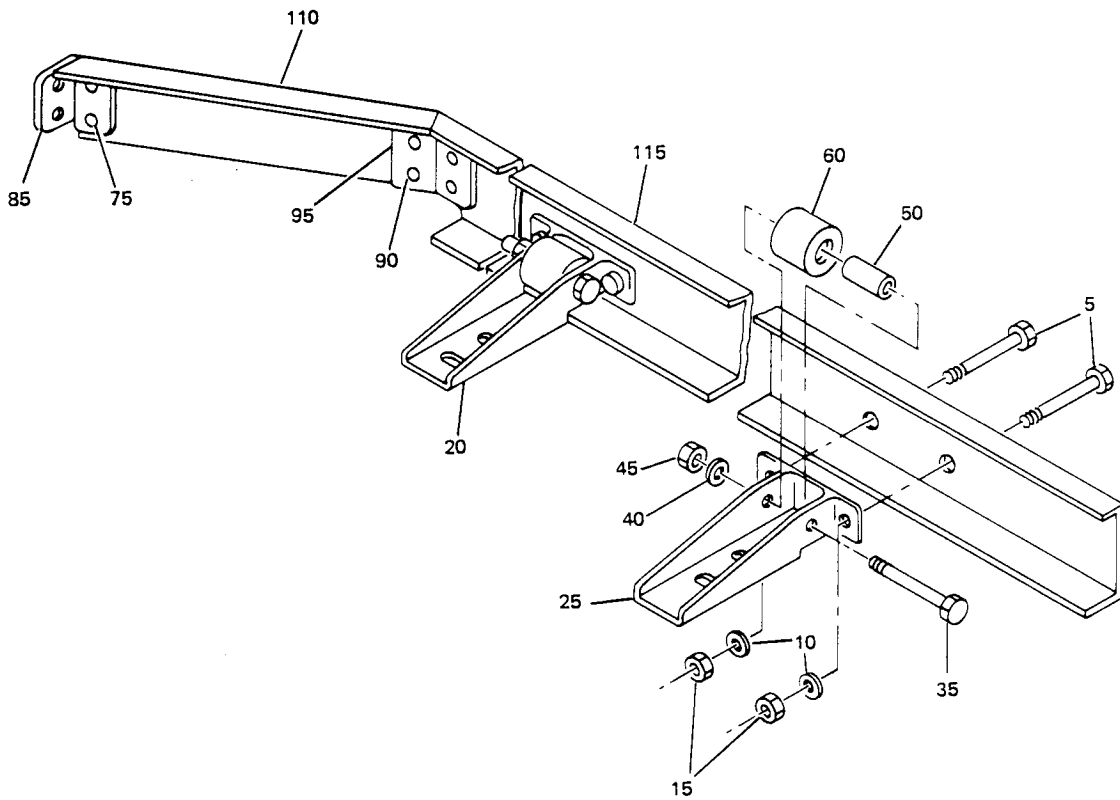
OVERHAUL MANUAL

5. ILLUSTRATED PARTS LIST



Passenger Seat Pallet QC Cargo System Stop Assembly
Figure 1 (Sheet 1)

Jun 5/84



ASSEMBLY 65C16136-2

65-74572
65-76670
65C16136



OVERHAUL MANUAL

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		
1-											
-1	65-74572-18									A	RF
-1	65-76670-8									B	RF
-1	65-76670-14									C	RF
-1	65C16136-2									D	RF
5	BACB30LU3-4										4
10	AN960C10										4
15	BACN10JC3										4
20	65-51712-4									A	1
20	65-51712-10									D	1
25	65-51712-5									A	1
25	65-51712-16									BC	1
25	65-51712-18									D	1
30	NAS1104-21									ABC	2
35	BACB30NF4-21									D	2
40	AN960C416										2
45	BACN10JC4										2
50	NAS75-4-101										2
55	65-75998-8									BC	1
60	66-23623-1										2
65	MS204260-6F									A	4
65	BACR15BA6D									BC	6
70	69-60431-1									B	1
70	69-60431-2									AC	1
75	BACR15BB6D									BC	2
75	BACR15BA6D									D	4
80	65-74571-22									A	1
80	65-74571-7									B	1
80	65-74571-20									C	1
85	65-75998-5									B	1
85	65-75998-19									C	1
85	69-68875-2									D	1

OVERHAUL MANUAL

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		
1-											
90	BACR15BA6D		.	R	I	V	E	T		D	4
95	69-58325-5		.	A	N	G	L	E		D	1
100	65-74572-19		.	W	E	L	D	A	S	A	1
105	65-75998-9		.	R	A	I	L	-	A	B	1
105	65-75998-20		.	R	A	I	L	-	A	B	1
110	65C16137-8		.	R	A	I	L	-	F	D	1
115	65C16137-9		.	R	A	I	L	-	F	D	1
120	65-76670-10		.	S	E	A	L	-	B	U	1