BOEING COMMERCIAL JET

OVERHAUL MANUAL

TO: ALL HOLDERS OF PALLETIZED CARGO SYSTEM TRANSFER PANEL ASSEMBLY OVERHAUL MANUAL 25-56-46

REVISION NO. 1, DATED JUL 5/81

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
Issued new manual covering assemblies 65-63633-1 thru -4, -6. This manual supersedes OHM 25-57-21 covering the same assemblies and eliminates a conflict with another OHM having the same number. Remove and destroy all pages of OHM 25-57-21 relating to 65-63633 part numbers													

PALLETIZED CARGO SYSTEM TRANSFER PANEL ASSEMBLY 25-56-46

BOEING P/N 65-63633-1 thru -4, -6

AIRLINE P/N

THE FOLLOWING DIRECTIVES APPLY TO THIS SUBJECT:

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVES	DATE DIRECTIVE INCORPORATED INTO TEXT

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
	25-56-46					
*	T-1	Jul 5/81				
	T-2	BLANK				
*	LEP-1	Jul 5/81				
	LEP-2	BLANK				
*	T/C-1	Jul 5/81				
	T/C-2	BLANK				
*	1	Jul 5/81				
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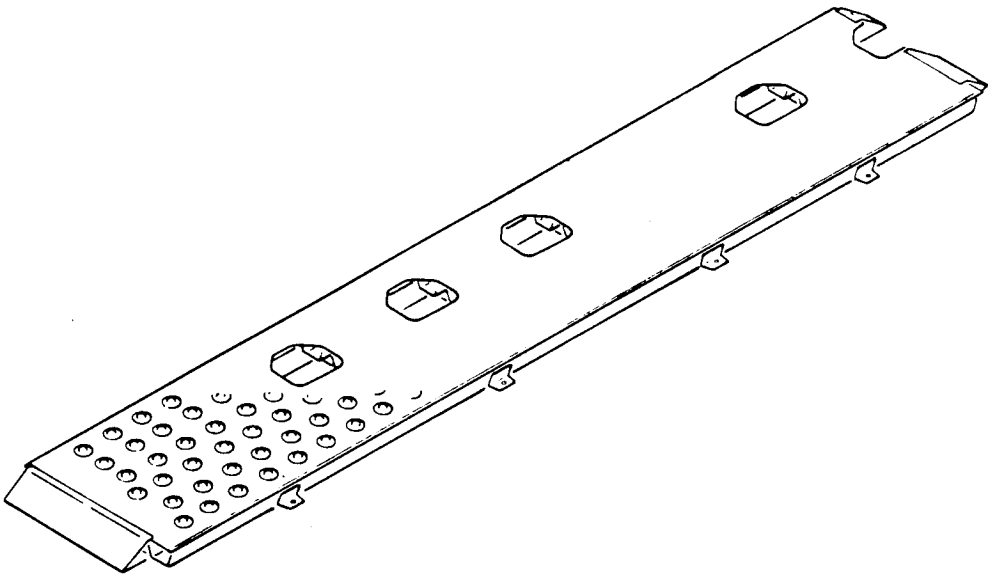
*[1] Special instructions not required. Use standard industry practices.

PALLETIZED CARGO SYSTEM TRANSFER PANEL ASSEMBLY



Palletized Cargo System Transfer Panel Assembly
Figure 1

1. DESCRIPTION AND OPERATION

A. Description

(1) The palletized cargo system transfer panel assembly consists of a panel assembly and spring-loaded ball units. The separate panel assemblies are attached to the floor of the aircraft.

B. Operation

(1) The palletized cargo system transfer panel assemblies are aligned together to provide a continuous rolling surface for cargo pallets.

C. Leading Particulars

NOTE: Dimensions are in inches.

Assembly	Length	Width	Thickness	Weight (pounds)
65-63633-1	147.0	26.0	2.0	97.1
65-63633-2	135.5	30.0	2.0	100.8
65-63633-3	135.5	40.0	2.0	128.8
65-63633-4	135.5	25.5	2.0	83.1
65-63633-6	147.0	26.0	2.0	89.9

2. DISASSEMBLY

A. General

(1) Disassemble only as required for cleaning, inspection and repair or replacement of defective parts.

B. Disassembly (Fig. 3)

(1) Remove screws (1).

(2) Apply pressure to retainers (2), rotate retainers counterclockwise approximately 45 degrees, and release pressure.

WARNING: BALL UNITS ARE SPRING LOADED. RESTRAIN RETAINERS WHEN RELEASING PRESSURE.

(3) Remove retainers (2), ball units (3), springs (4) and spacers (5).

(4) Remove nuts (6 and 9), washers (7 and 10), and studs (8 and 11).

(5) Remove pin (12), filler (13), and spring handle (14).

NOTE: Do not remove rivets (15), shear fittings (16), or fillers (17) unless repair or replacement is required.

3. CLEANING

A. Ball Units (Fig. 3)

CAUTION: DO NOT ALLOW SOLVENT TO COME IN CONTACT WITH BALL UNITS. SOLVENT WILL DAMAGE BALL UNIT HOUSING.

(1) Clean all ball units (3) per Subject 20-30-03, Cold Alkaline method. If solvent is required, use general purpose cleaning solvent, BMS 3-2, type 2.

CAUTION: DO NOT LUBRICATE BALL UNITS.

NOTE: Make sure drain holes in bottom of ball cup are clear of foreign matter.

4. INSPECTION/CHECK

A. Visual Check (Fig. 3)

(1) Check all metal parts for pits, cracks, scratches, burrs, and corrosion, using strong light and a minimum of 10-power magnification.

(2) Check threaded areas for cross-threading and stripping.

(3) Check painted and plated surfaces for blisters, chipping, or flaking.

(4) Examine ball units (3) for roughness or binding, open drain holes, and proper assembly.

(5) Examine panel structure (18) for bent, dented, or torn structural members.

(6) Check retainers for damage.

(7) Check lettering and numbering for legibility.

B. Special Check (Fig. 3)

(1) Check springs (4) for deformation or damage.

(2) Perform spring check as follows:

(a) Apply a test load of 65 to 75 pounds.

(b) Verify test length of 1.05 inches.

(c) Remove test load and verify free length of 2.38 inches.

5. REPAIR

A. Repair (Fig. 3)

(1) Remove minor scratches, pitting, or corrosion by polishing with abrasive cloth, 220 grit or finer.

(2) Repair minor defects in threaded areas with small triangular file or thread chaser.

(3) Straighten all minor damage to structural members with standard sheet metal forming equipment.

(4) Replace all loose or missing rivets.

(5) Refer to manufacturer's instructions for repair of ball units (3).

B. Refinish (Fig. 3)

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) Spring (4) -- Apply F-1.1923 all over.

(b) Studs (8 and 11) -- Apply F-1.1913 all over.

(c) Handle (14) -- Apply SRF-12.206 all over.

(d) Fitting (16) -- Apply F-2.20 all over.

(2) If lettering or numbering on upper skin is damaged, proceed as follows:

(a) Stencil with SRF-14.904-701, as indicated in Fig. 2, letters, part numbers, and direction arrows, per 20-41-02.

(b) Apply two coats of clear epoxy enamel, A423 (Andrew Brown Co., Los Angeles, California) or equivalent, over stencilled area.

(3) If walkway coating is damaged, proceed as follows:

WARNING: CONDUCT ALL WORK IN A WELL-VENTILATED AREA TO AVOID TOXIC EFFECTS OF SOLVENT. AVOID OPEN FLAMES IN WORK AREA.

NOTE: Area should be free of dust and severe temperature changes.

(a) Clean surfaces per CLEANING instructions.

(b) Apply one coat of BMS 10-11, type 1, primer per 20-41-02, film thickness 0.0003 to 0.0004 inch.

(c) While primer is curing, prepare the epoxy walkway as follows:

1) Mix enamel, BMS 10-11, type 2 (Andrew Brown A-423 only) by adding T-261 catalyst and T-262 thinner in accordance with 20-41-02.

2) After thinning to proper spray viscosity, add one pound of No. 1-1/2 pumice, 40 to 50 mesh, per gallon of mixed, ready-to-spray enamel.

NOTE: All components of the coating should be uniform, homogeneous, and free of gelled particles. There should be no separation of ingredients that cannot be dispersed readily.

3) Allow mixture to stand 1 hour from time catalyst is added before using.

4) Provide medium to fast paddle agitation of the grit-containing material before and during application to prevent settling of the grit.

(d) When primer has properly cured, spray-apply one cross coat of the grit-containing material and allow to dry a minimum of 60 minutes at 70°F or above. Use a Binks Model 7 spray gun with a No. 38-PD Air Cap, No. 38 Fluid Tip and No. 38 Needle or equivalent. The container should be a pressure tank equipped with a large paddle stirring mechanism for agitation during application. Omit the coating from formed holes, ramps, mating surfaces, identification stencil areas, outside margins of the upper surface, and on a 3.5-inch diameter area around each ball unit.

NOTE: Films of primer (such as BMS 10-11, type 1) that are over 48 hours old should be cleaned and reactivated by the methods listed in 20-41-02 before overcoating.

(e) Spray-apply 1-1/2 cross coats (i.e., 3 wet passes) of A-423 epoxy enamel without grit, using standard spray equipment.

(f) Allow the walkway coating to dry at least 8 hours before stacking and installation and at least 7 days before exposing to traffic. Drying of the final film may be accelerated in accordance with 20-41-02 after it has been allowed to dry at room temperature for at least 1 hour.

NOTE: The final dry film weight should be 4 to 6 ounces per square yard, including the primer. Film weight checks can be made by spraying and weighing test panels in conjunction with parts being refinished.

C. Replacement (Fig. 3)

(1) Replace all parts damaged beyond simple repair.

(2) If any riveted part requires replacement, carefully drill out old rivets, remove defective part, and install serviceable part with new rivets of the same type (or equivalent fasteners). Install rivets with wet primer BMS 10-11, type 1 (or equivalent).

(3) Replace ball unit (3) if the roller ball is worn enough to pass through retainer hole, or is scoured or flattened, or if ball is deformed, or if small bearing balls are missing.

D. Materials

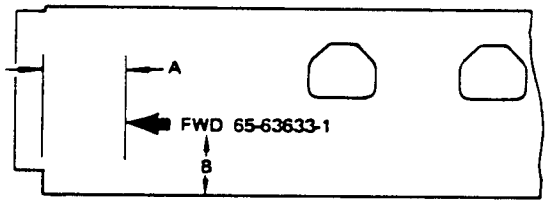
NOTE: Use listed materials or equivalent substitutes.

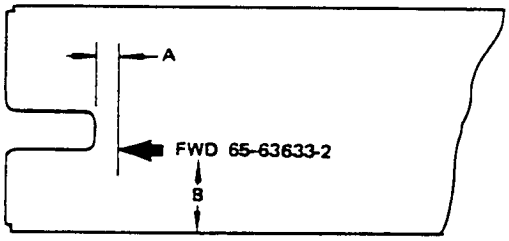
(1) Primer, BMS 10-11, type 1

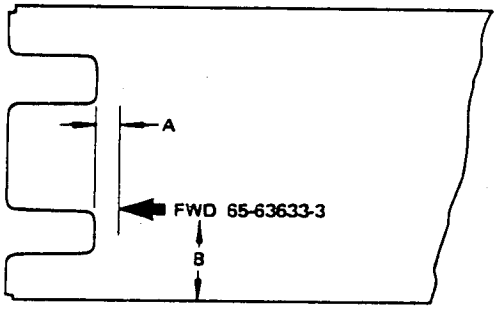
(2) Epoxy Enamel -- BMS 10-11, type 2, color BAC792, A-423 with T-261 Catalyst and T-262 Thinner (Andrew Brown Co., Los Angeles, California)

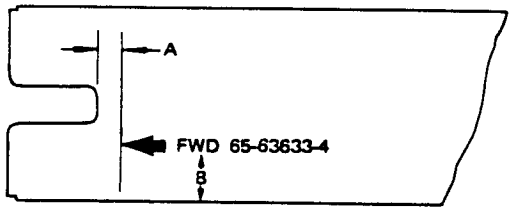
(3) Epoxy Enamel -- A-423 clear (Andrew Brown Co., Los Angeles, California)

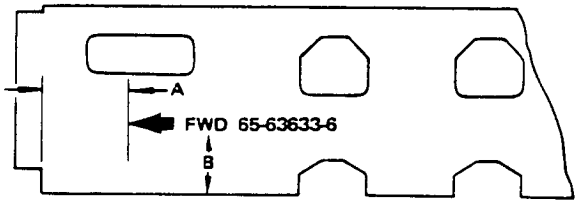
(4) Pumice Grit No. 1-1/2, 40 to 50 mesh (Van Waters and Rogers, Seattle, Washington)

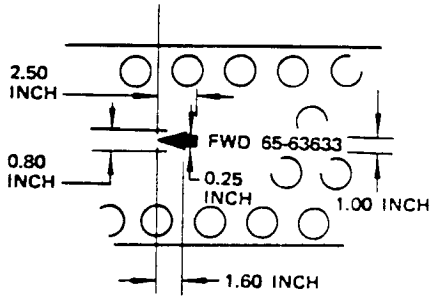












STENCIL DIMENSIONS

PART NO.	DIMENSIONS (INCHES)	
	A	B (1)
65-63633-1	20.25	8.50
65-63633-2	0.00	11.75
65-63633-3	0.00	11.75
65-63633-4	0.00	5.50
65-63633-6	20.25	8.50

(1) ADJUST B SO THAT LETTERS WILL CENTER BETWEEN TWO LINES OF BALL DIMPLES.

Lettering Details
Figure 2

6. ASSEMBLY

A. Procedure (Fig. 3)

(1) Install spacers (5), springs (4), ball units (3), retainer (2), and screws (1) as follows:

(a) Position spacer (5) in panel structure (18).

NOTE: Spacer (5) is not used in the outboard side of the 65-63633-1 and 65-63633-6 assemblies.

(b) Position spring (4) in cup of ball unit (3).

(c) Position ball unit (3) in panel structure (18).

(d) Position retainer (2) on ball unit (3).

NOTE: Retainer locking fingers must be positioned to clear panel skin fingers.

(e) Apply pressure to retainer (2) and rotate clockwise until fingers are engaged and hole for screw (1) is aligned.

(f) Release pressure and install screw (1).

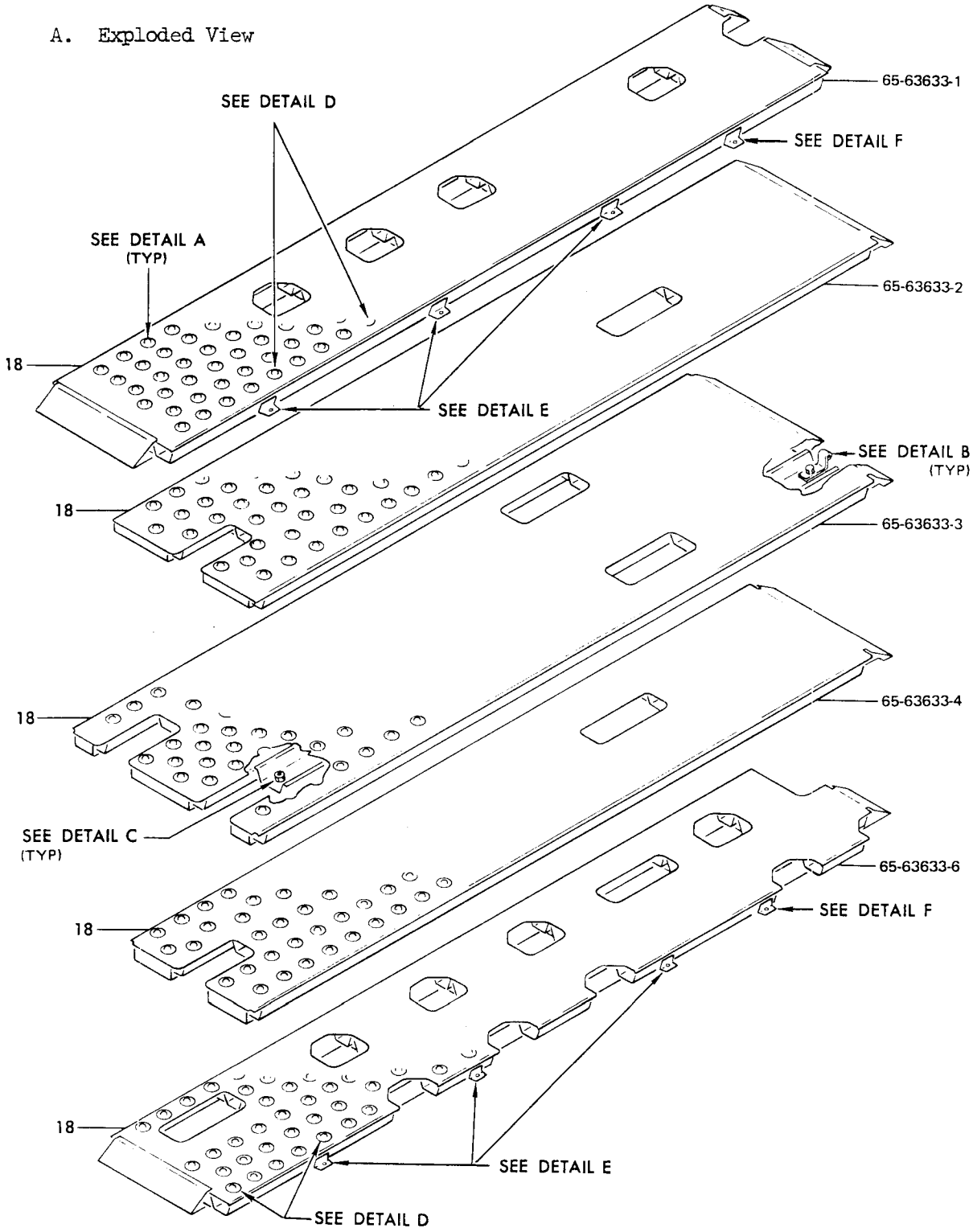
NOTE: Screw (1) is for antirotation only and is to be drawn down flush with retainer surface.

(g) Install pin (12) to spring handle (14) and filler (13), and position to panel structure.

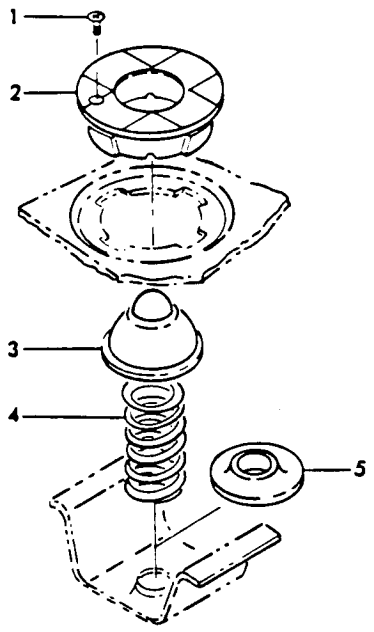
(h) Position studs (8 and 11) and install washers (7 and 10) and nuts (6 and 9).

7 ILLUSTRATED PARTS LIST

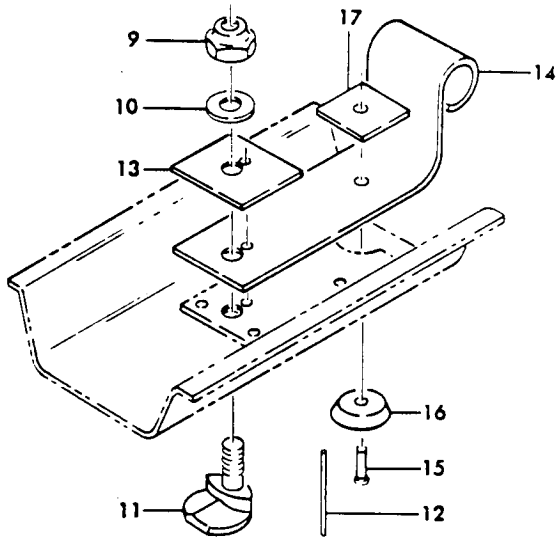
A. Exploded View



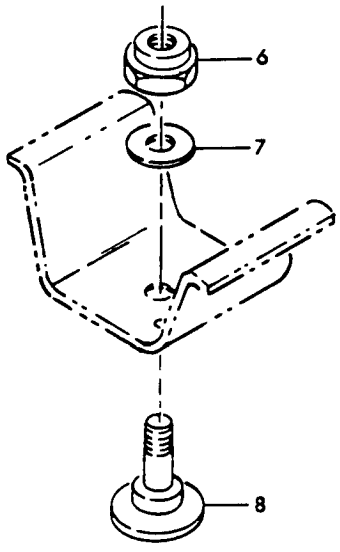
Palletized Cargo System Transfer Panel Assembly
Figure 3 (Sheet 1)



DETAIL A

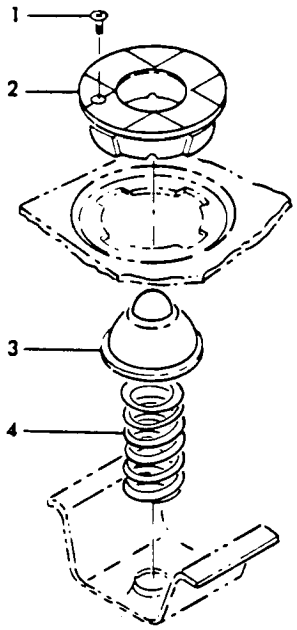


DETAIL B

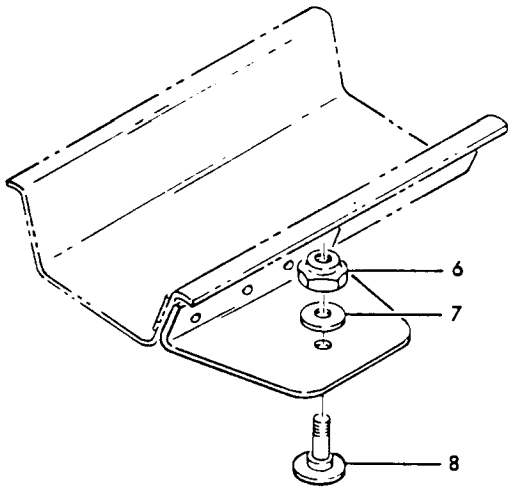


DETAIL C

Palletized Cargo System Transfer Panel Assembly
Figure 3 (Sheet 2)

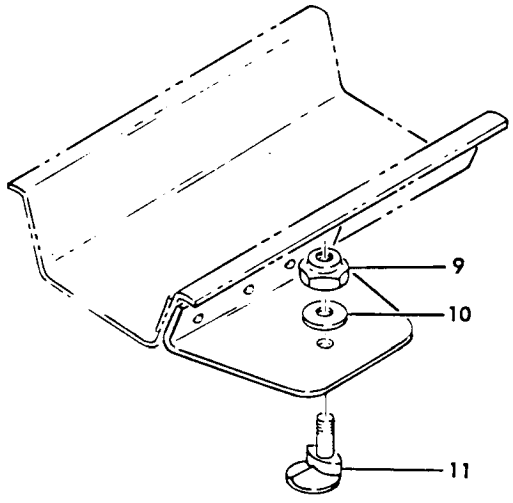


DETAIL D



DETAIL E

NOTE: DETAIL D APPLIES ONLY TO BALL ROWS IN OUTBOARD SIDE OF PANEL STRUCTURE OF 65-63633-1 AND 65-63633-6 ASSEMBLIES.



DETAIL F

Palletized Cargo System Transfer Panel Assembly
Figure 3 (Sheet 3)

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
3-					
	65-63633-1		PALLETIZED CARGO SYSTEM TRANSFER PANEL ASSY	A	
	65-63633-2		PALLETIZED CARGO SYSTEM TRANSFER PANEL ASSY	B	
	65-63633-3		PALLETIZED CARGO SYSTEM TRANSFER PANEL ASSY	C	
	65-63633-4		PALLETIZED CARGO SYSTEM TRANSFER PANEL ASSY	D	
	65-63633-6		PALLETIZED CARGO SYSTEM TRANSFER PANEL ASSY	E	
1	NAS514P632-6B		. SCREW	A	143
1	NAS514P632-6B		. SCREW	B	141
1	NAS514P632-6B		. SCREW	C	177
1	NAS514P632-6B		. SCREW	D	115
1	NAS514P632-6B		. SCREW	E	123
2	69-29615-1		. RETAINER	A	143
2	69-29615-1		. RETAINER	B	141
2	69-29615-1		. RETAINER	C	177
2	69-29615-1		. RETAINER	D	115
2	69-29615-1		. RETAINER	E	123
3	4340-35		. BALL UNIT, V09721 (PREF)	A	143
3	4340-35		. BALL UNIT, V09721 (PREF)	B	141
3	4340-35		. BALL UNIT, V09721 (PREF)	C	177
3	4340-35		. BALL UNIT, V09721 (PREF)	D	115
3	4340-35		. BALL UNIT, V09721 (PREF)	E	123
3	100000		. BALL UNIT, V12802 (OPT TO 4340-35)		AR
3	9559F		. BALL UNIT, V06144 (OPT TO 4340-35)		AR
3	TYE1000		. BALL UNIT V56958 (OPT TO 4340-35)		AR
4	66-20715-2		. SPRING	A	143
4	66-20715-2		. SPRING	B	141
4	66-20715-2		. SPRING	C	177
4	66-20715-2		. SPRING	D	115
4	66-20715-2		. SPRING	E	123
5	69-43760-1		. SPACER	A	116
5	69-43760-1		. SPACER	B	141
5	69-43760-1		. SPACER	C	177

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
3-					
5	69-43760-1		. SPACER	D	115
5	69-43760-1		. SPACER	E	104
6	BACN10JC4		. NUT (REPLS NAS679A4W)	AE	3
6	BACN10JC4		. NUT (REPLS NAS679A4W)	BD	1
6	BACN10JC4		. NUT (REPLS NAS679A4W)	C	2
7	AN960PD416		. WASHER	AE	3
7	AN960PD416		. WASHER	BD	1
7	AN960PD416		. WASHER	C	2
8	69-29644-1		. STUD	AE	3
8	69-29644-1		. STUD	BD	1
8	69-29644-1		. STUD	C	2
9	BACN10JC6		. NUT (REPLS NAS679A6)	ABDE	1
9	BACN10JC6		. NUT (REPLS NAS679A6)	C	2
10	AN960PD616		. WASHER	ABDE	1
10	AN960PD616		. WASHER	C	2
11	69-29654-1		. STUD	ABDE	1
11	69-29654-1		. STUD	C	2
12	MS16562-26		. PIN	BD	1
12	MS16562-26		. PIN	C	2
13	65-63635-28		. FILLER	BD	1
13	65-63635-28		. FILLER	C	2
14	69-29620-3		. HANDLE, SPRING	BD	1
14	69-29620-3		. HANDLE, SPRING	C	2
15	BACR15BB6D		. RIVET (REPLS MS20470D6)	BD	1
15	BACR15BB6D		. RIVET (REPLS MS20470D6)	C	2
16	66-20785-1		. FITTING, SHEAR	BD	1
16	66-20785-1		. FITTING, SHEAR	C	2
17	65-63635-27		. FILLER	BD	1
17	65-63635-27		. FILLER	C	2
18			. PANEL STRUCTURE		1

VENDORS

V06144	INDUSTRIAL TECTRONICS INC., BEARING DIVISION 18301 SANTA FE AVE., P.O. BOX 48799, COMPTON, CALIFORNIA 90224
V09721	GENERAL BEARING COMPANY INC., HIGH STREET, WEST, NYACK, NEW YORK 10994
V12802	VALLEY - TODECO INCORPORATED, 12975 BRADLEY AVE., SYLMAR, CALIFORNIA 91342
V56958	THE YOUNG ENGINEERS, INC., 23151 ALCALDE DR., SUITE B-5, P.O. BOX 2098, LAGUNA HILLS, CALIFORNIA 92653