



OVERHAUL MANUAL

QC CARGO SYSTEM FIXED SIDE GUIDE ASSEMBLY

25-56-49

BOEING P/N 69-55187-1, -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	Sep 5/85

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
25-56-49					
* T-1	Sep 5/85				
* T-2	BLANK				
* LEP-1	Sep 5/85				
* LEP-2	BLANK				
* T/C-1	Sep 5/85				
* T/C-2	BLANK				
* 1	Sep 5/85				
* 2	Sep 5/85				
* 3	Sep 5/85				
* 4	Sep 5/85				



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 MANUALQ.C. CARGO SYSTEM ROLLER SUPPORT ASSEMBLY1. DESCRIPTION AND OPERATION

A. The guide assembly consists of a support base, a roller, a channel, and two angles. The guide assembly attaches to the siderail aft end with four bolts to provide additional support to the siderail and is fastened to the airplane seat track with shear studs.

B. Leading particulars (approximate)

Width -- 3.4 inches

Length -- 2.9 inches

Height -- 2.3 inches

2. INSPECTION/CHECK (Fig. 1)

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

B. Magnetic check per 20-20-02 -- stud (40)

C. Penetrant check per 20-20-01 -- stop pad (35), angle (75, 80, 95), channel (70, 90)

3. REPAIR (Fig. 1)

A. Materials

NOTE: Equivalent substitutes may be used.

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

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.

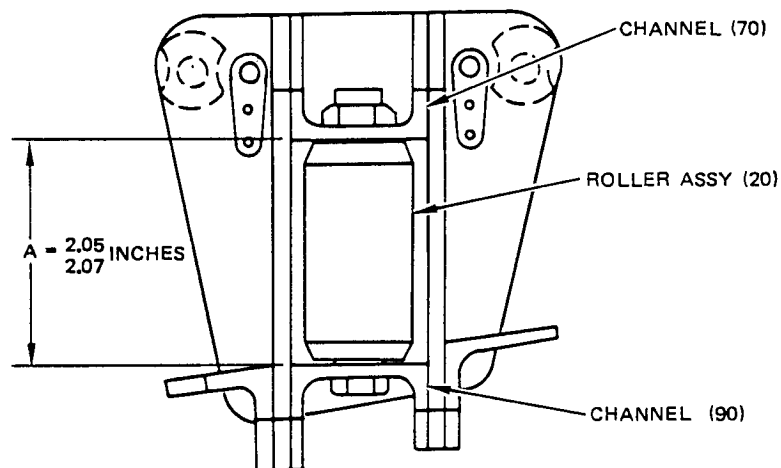
(1) Stop pad (35), angle (75, 80, 95), channel (70, 90) -- Alodize using colored film, or chromic acid anodize and apply one coat BMS 10-11, type 1 primer (SRF - 2.30). Material: Al alloy

(2) Stud (40) -- Cadmuim plate (0.0002 to 0.0004 inch thick) and bake 3 hrs min at 375°F (F-1.1913). Material: 4140 steel

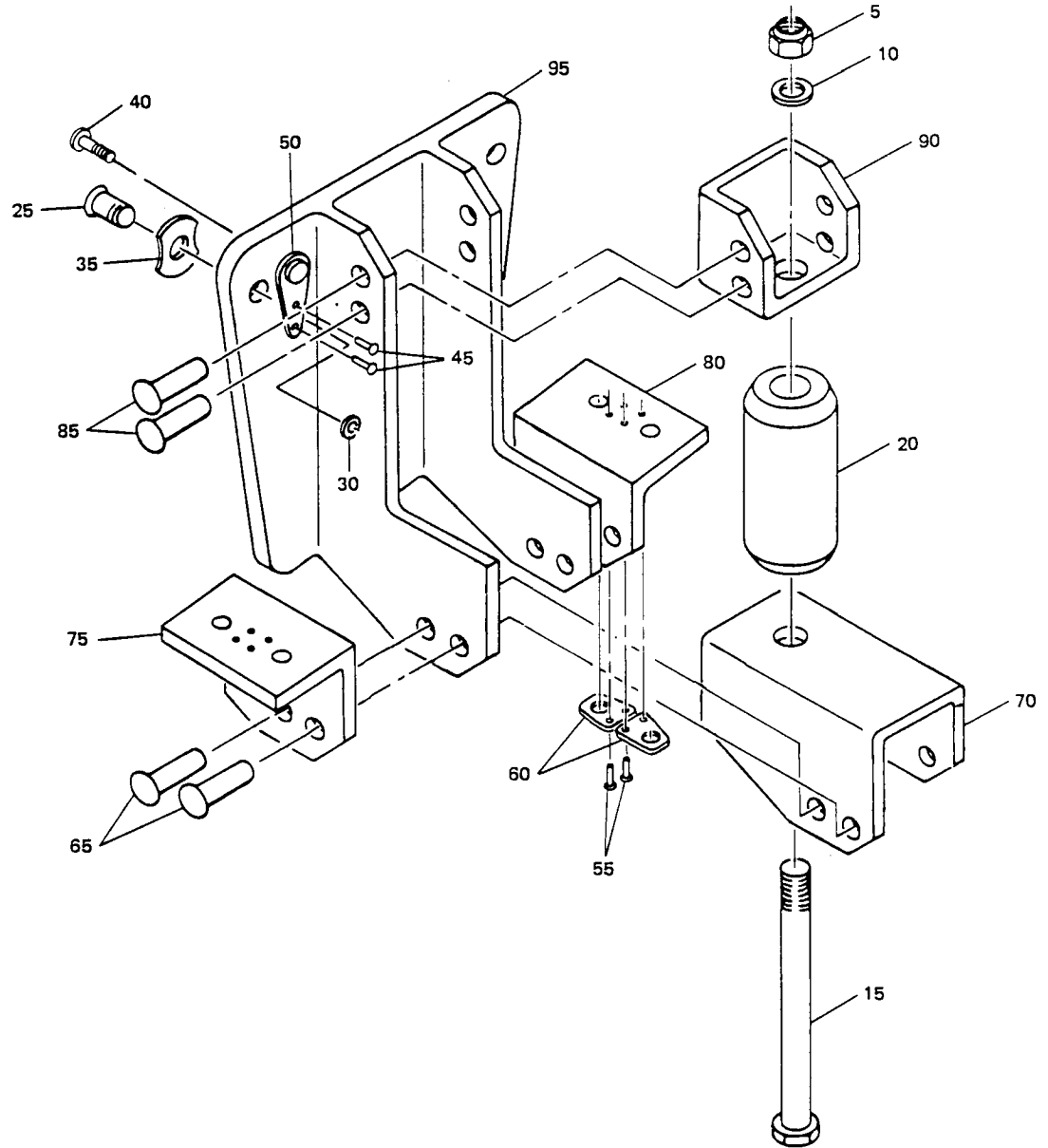
OVERHAUL MANUAL

4. ASSEMBLY (Fig. 1)

- A. Use standard industry practices for assembly of this component, and additional procedure in step B., C.
- B. Install bolt (20), washer (15), and nut (10). Tighten nut (10) to 60-85 lb-in.
- C. Check that dimension A, as shown in Fig. 1, is 2.05-2.07 inches. Reduce torque requirements as necessary to meet the dimensional requirement.



5. ILLUSTRATED PARTS LIST



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		
2- 1	69-55187-1		SIDE GUIDE ASSY-FIXED, QC CARGO SYSTEM							A	RF
1	69-55187-2		SIDE GUIDE ASSY-FIXED, QC CARGO SYSTEM							B	RF
5	NAS679A5		. NUT								1
10	AN960-C416		. WASHER								1
15	BACB30NE5-38		. BOLT								1
20	69-36905-2		. ROLLER ASSY								1
25	BACB30FN6-6		. BOLT								2
30	BACC30M6		. COLLAR								2
35	65-51723-15		. STOP PAD								2
40	69-2944-6		. STUD								2
45	MS20426D3		. RIVET								4
50	NAS696A4		. NUPLATE								2
55	MS20426D3		. RIVET								8
60	BACN10PC3		. NUTPLATE								4
65	MS20470D6		. RIVET								4
70	65-69505-3		. CHANNEL							A	1
70	65-69505-4		. CHANNEL							B	1
75	65-69505-5		. ANGLE							A	1
75	65-69505-6		. ANGLE							B	1
80	65-69505-7		. ANGLE							A	1
80	65-69505-8		. ANGLE							B	1
85	MS20470D5		. RIVET								4
90	69-69505-10		. CHANNEL								1
95	69-69505-1		. BASE, SUPPORT							A	1
95	69-69505-2		. BASE, SUPPORT							B	1