



OVERHAUL MANUAL

# QC CARGO SYSTEM ROLLER SUPPORT ASSEMBLY

## 25-56-50

BOEING P/N 69-55190-1

AIRLINE P/N

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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

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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
25-56-50					
* T-1	Sep 5/85				
* T-2	BLANK				
* LEP-1	Sep 5/85				
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* T/C-1	Sep 5/85				
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\*[1] Special instructions not required. Use standard industry practices.

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Q.C. CARGO SYSTEM ROLLER SUPPORT ASSEMBLY1. Description and Operation

A. The assembly consists of a support base, a roller assy, a channel, and two angles. The assembly is fastened to airplane seat track with shear studs.

B. Leading Particulars (approximate)

Width -- 3.4 inches

Length -- 3.0 inches

2. CHECK (Fig. 1)

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

B. Penetrant check per 20-20-02 -- channel (60), support base (65).

C. Magnetic particle check per 20-20-01 -- stud (40)

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.

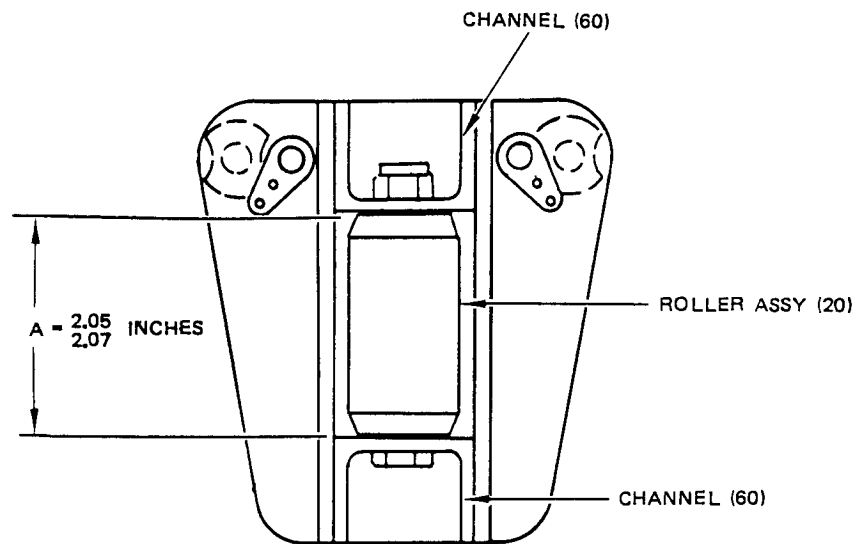
(1) Stop pad (35), channel (60), support base (65) --- Alodize using colored film, or chromic acid anodize and apply one coat BMS 10-11, type 1 primer (SRF-2.30). Material: AL alloy

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

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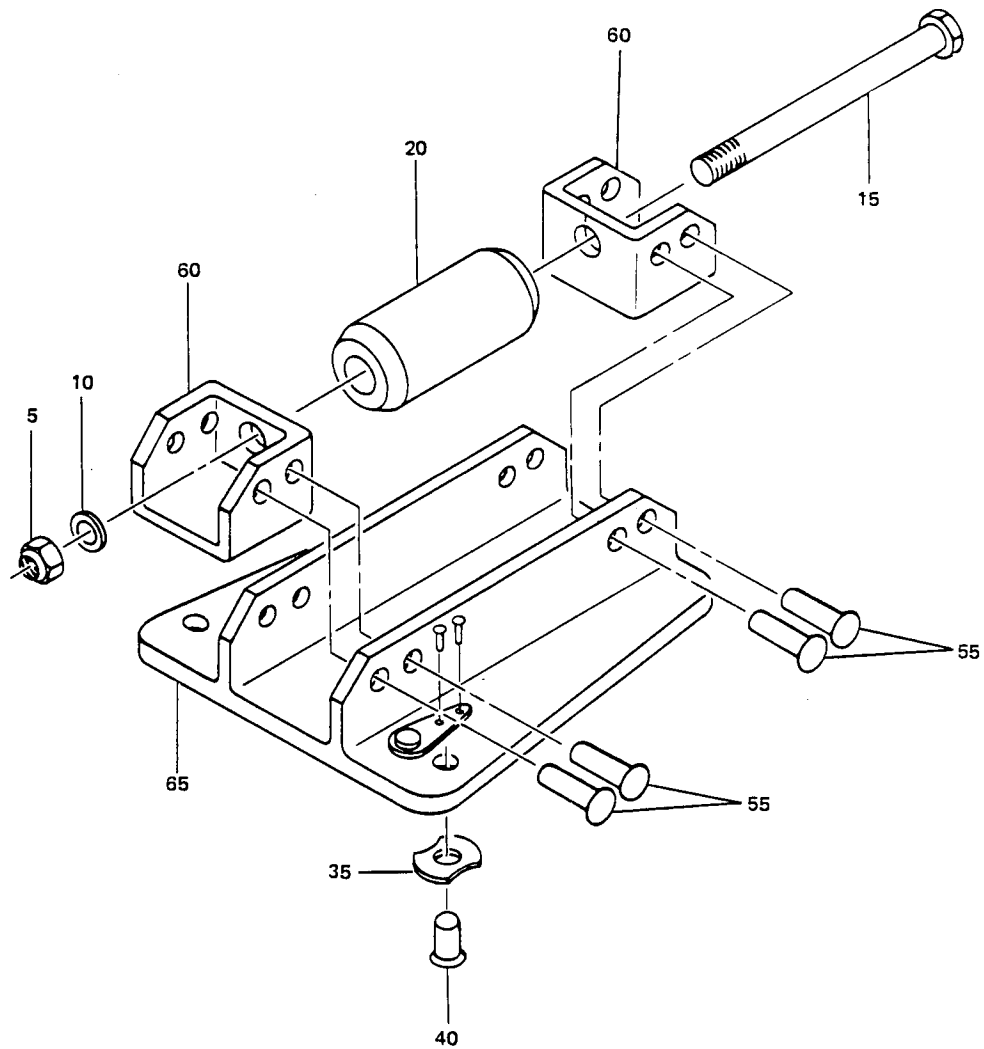
4. Assembly (Fig. 2)

- A. Use standard industry practices for assembly of this component, and additional procedures in step B.,C.
- B. Install bolt (15), washer (10), and nut (5). Tighten nut (5) 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 requirements.



Assembly Detail  
Figure 1

5. ILLUSTRATED PARTS LIST



QC Cargo Roller Support Assy  
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											
1	69-55190-1		SUPPORT ASSY-ROLLER, QC CARGO SYSTEM								RF
5	NAS679A5		. NUT								1
10	AN960C416		. WASHER								1
15	BACB3ONE5-38		. BOLT								1
20	69-36905-2		. ROLLER ASSY								1
25	BACB30FN3-9		. BOLT								2
30	BACC30M6		. COLLAR								2
35	65-51723-15		. STOP PAD								2
40	69-29644-6		. STUD								2
45	MS20426D3		. RIVET								4
50	NAS696A4		. NUTPLATE								2
55	MS20470D		. RIVET								8
60	65-69505-10		. CHANNEL								2
65	65-69505-9		. BASE, SUPPORT								1