

TO: ALL HOLDERS OF AFT ENTRY DOOR ASSEMBLY OVERHAUL MANUAL, 52-16-03

REVISION NO. 37, DATED MAR 1/07

HIGHLIGHTS

DESCRIPTION OF CHANGE	TOPICS AFFECTED												
	D & O	D / Assy	Cleaning	Inspect / Check	Repair	Assy	F / C	Test	T / Shooting	S / Tools	Storage	IPL	L / Overhaul
Changed the Test Length for spring 212-1101, P/N 66-15645-1 to 0.25 - 0.20				X									

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HIGHLIGHTS
Page 1 of 1

AFT ENTRY DOOR ASSEMBLY

52-16-03

BOEING P/N 65-52873-2, -159, -167, -168, -176, -180, -182, -189, -567

AIRLINE P/N

THE FOLLOWING DIRECTIVES APPLY TO THIS SUBJECT:

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVES	DATE DIRECTIVE INCORPORATED INTO TEXT
		PRR 30209	Feb 15/69
		PRR 30458	Feb 15/69
		PRR 31564	Mar 10/70
		PRR 31567	Mar 10/70
		PRR 31665	Mar 10/70
		PRR 31996	Sep 10/72
		PRR 32121-1	Sep 10/72
53-1017		PRR 31870	Dec 25/72
		PRR 32121-7	Dec 25/72
53-1017, Rev 1			Dec 25/72
		PRR 32070-13	Dec 25/73
		PRR 32121-8	Dec 25/73
		PRR 32403	Mar 25/75
		PRR 32533	Jul 5/76
		PRR 32575-1	Jul 5/76
		PRR 32792	Jan 5/79
		PRR 32836	Jan 5/79
		PRR 32950-4	Jan 5/80
		PRR 32989	Jul 5/81
		PRR 33268	Dec 5/83
		PRR 33410-6	Jun 5/85

BOEING
OVERHAUL MANUAL

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVES	DATE DIRECTIVE INCORPORATED INTO TEXT
		PRR 33180-17	Dec 5/85
		PRR 33180-66	Dec 5/85
		PRR 34270	Mar 5/88
52-1094		PRR 34272	Jun 5/88
52-1094R2			Mar 5/89
		PRR 34473	Mar 5/89
52-1097R1			Sep 5/89
52-1094R3			Jul 1/99

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
52-16-03		414	Nov 1/04	1118D	BLANK
T-1	Jul 1/99	501	Nov 1/04	1119	Jul 1/99
T-2	Jul 1/99	502	Nov 1/04	1120	Mar 10/70
* LEP-1	Mar 1/07	503	Jul 1/99	1120A	Mar 1/00
LEP-2	BLANK	504	Jul 1/01	1120B	BLANK
T/C-1	Jun 5/88	505	Nov 1/04	1121	Jul 1/99
T/C-2	BLANK	506	Nov 1/04	1122	Jul 1/99
1	Dec 5/85	507	Nov 1/04	1123	Nov 1/04
2	Mar 10/70	508	Nov 1/04	1124	Jul 1/99
101	Jul 1/99	509	Jul 1/99	1124A	Nov 1/04
102	Nov 1/04	510	BLANK	1124B	Nov 1/04
103	Jul 1/99	601	Mar 1/00	1124C	Nov 1/04
104	Jul 1/99	602	BLANK	1124D	Nov 1/04
105	Jul 1/99	701	Mar 10/70	1124E	Nov 1/04
106	BLANK	702	BLANK	1124F	BLANK
201	Nov 1/04	801	Mar 10/70	1125	Nov 1/04
202	DELETED	802	BLANK	1126	Nov 1/04
* 301	Mar 1/07	901	Mar 10/70	1127	Nov 1/04
302	BLANK	902	BLANK	1128	Jul 1/99
401	Jul 1/05	1001	Nov 1/01	1129	Nov 1/04
402	Jul 1/01	1002	BLANK	1130	Nov 1/04
402A	Jul 1/99	1101	Mar 10/70	1131	Jul 1/99
402B	Mar 1/00	1102	Jun 1/94	1132	Nov 1/04
402C	Mar 1/00	1103	Jul 1/99		
402D	Mar 1/00	1104	Mar 10/70		
402E	Nov 1/01	1105	Jul 1/99		
402F	Mar 1/00	1106	Jul 1/01		
402G	Mar 1/00	1107	Mar 5/89		
402H	Jul 1/99	1108	Jun 1/94		
402I	Jul 1/99	1109	Mar 10/70		
402J	Jul 1/99	1110	Jul 1/99		
403	Jul 1/99	1111	Jul 1/99		
404	Jul 1/99	1112	Jul 1/99		
405	Nov 1/02	1113	Jul 1/99		
406	Nov 1/04	1114	Nov 1/04		
407	Nov 1/04	1114A	Jul 1/99		
408	Jan 5/80	1114B	Jul 1/99		
408A	Jul 1/02	1115	Nov 1/04		
408B	Jul 1/04	1116	Mar 1/00		
409	Jul 1/04	1117	Mar 1/00		
410	Jul 1/99	1118	Nov 1/04		
411	Mar 5/84	1118A	Mar 1/03		
412	Jul 1/99	1118B	Mar 1/00		
413	Nov 1/04	1118C	Nov 1/04		



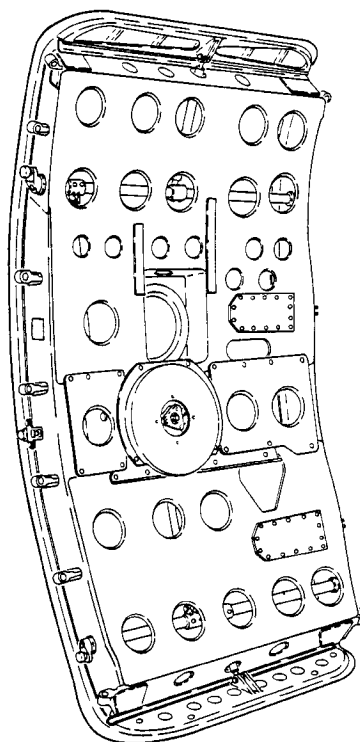
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OVERHAUL MANUAL

AFT ENTRY DOOR ASSEMBLY



Aft Entry Door Assembly
Figure 1

DESCRIPTION AND OPERATION

1. Description

- A. The aft entry door is an inward-outward plug-type door at station 975.0.
- B. A door handle mechanism consisting of a cam, two cam follower crank assemblies, cranks, control rod, and a hinge torque tube is assembled in a housing. The housing, together with the mechanism, is installed in the door structure. Connected to the handle mechanism are the upper and lower gates and roller latch assemblies through control rods, cranks, and torque tubes. Sixteen adjustable door stops are installed on the sides of the door structure and in the gates. A centering guide is assembled on the door to center the door in the frame.

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2. Operation

- A. The aft entry door is opened by operating either the inside or outside handle which causes the door handle mechanism to release the roller latches from the latch fittings on the door jambs, fold the gates inward, and move the door to its most inward position. The door is then manually swung outward through the door opening and stowed in the open position by engagement of a latch pin. Pressurization loads are transmitted through the adjustable stop pins to the door frame.

3. Leading Particulars

Thickness - 5.5 inches (approximately)
Width - 30.0 inches (approximately)
Height - 68.5 inches (approximately)
Weight - 122.0 pounds (approximately)

DISASSEMBLY

1. Detail Disassembly

A. Remove Installation Items (See Fig. 1101.)

NOTE: Items removed in this paragraph are part of the door installation and may or may not be installed on the door assembly when received for overhaul.

- (1) Remove retainer springs (254) and door stop pins (255) from all stop fitting assemblies.
- (2) Remove bolts (256, 257, 261, 262), covers (258, 263), shims (259, 260, 264, 265), and block (266).
- (3) Remove bolts (267, 268), washers (269), and roller fitting (270).
- (4) Remove nut (271), washer (272), and spacer (273) from centering guide (274).
- (5) Remove plugs (275).

B. Remove Assembly Items (See Fig. 1101.)

- (1) Remove retainer assembly (1, 1A, Fig. 1101) by disengaging studs (2, 2A) from fastener assemblies (9, 19).

NOTE: Do not remove washers (3) and rings (4) from studs (2, 2A), rivets (5, 5A) and nutplates (6) from retainer (7, 7A), or rivets (8) and fastener assemblies (9) unless repair or replacement is necessary.

- (2) Remove bolts (10) and cover plates (11, 12).

NOTE: Do not remove rivets (13) and nutplates (14, 15) unless repair or replacement is necessary.

- (3) Remove bolts (16) and bracket assembly (17).

NOTE: Do not remove rivets (18, 20, 23), fastener assemblies (19), nutplates (21) from bracket (22), and nutplates (24) unless repair or replacement is necessary.

- (4) Remove bolts (26), washers (25), and cover plates (27).

NOTE: Do not remove rivets (28) and nutplates (29, 30) unless repair or replacement is necessary.

- (5) Remove nuts (31), washers (32), and bolts (33).

- (6) Remove bolts (34 thru 36), washers (37), nuts (41) as applicable, and reinforcing angles (38 and 39).

NOTE: Do not remove rivets (40), nutplates (41), and fillers (42) unless repair or replacement is necessary.

- (7) Remove bolts (43), washers (44), and window assembly (45).

- (8) Disassemble window assembly (45) as follows:

(a) Remove nuts (46), washers (47), screws (48), clips (49), and shims (50, 51).

(b) Separate seal (52), retainer (53), inner and outer panes (54, 55), and seal (56).

NOTE: Do not remove rivets, nutplates, shims, and fillers (57 thru 60) from doubler (60G) unless repair or replacement is necessary.

- (9) Remove nylon rods (61 thru 63) and pull seal (64) from seal retainer.

NOTE: Do not remove items (65 thru 108) unless repair or replacement is necessary.

- (10) Remove nuts (109) and washers (110, 111) from bolts (112, 113). Then remove bolts (112 thru 114), washers (115) and rod assemblies (117, 122, 127, 132).

NOTE: Do not remove bushings (116) unless replacement is necessary.

- (11) Remove rod assemblies (117, 122) from door structure.

NOTE: Do not disassemble rod assemblies (117, 122) unless repair or replacement is necessary.

- (12) Before you remove the gates (139, 142) from the door, measure and make a note of the gap between each gate and the door (at the outer surface) to help during assembly.

- (13) Remove bolts (137, 137A, 138, 138A) and washers (137B, 138B) as applicable, upper and lower gate assemblies (139, 142), and fillers (146, 147).

NOTE: Do not remove items (140, 141, 143 thru 145, 148, 149) unless repair or replacement is necessary.

- I (14) Remove spring pins (150, 152A, 158A) and hinge pins (152, 158) from upper and lower hinge assemblies (151, 157) to separate hinge halves (155, 156, 161, 162).

NOTE: Do not remove items (153, 154, 159, 160, 163, 164) unless repair or replacement is necessary.

- (15) Remove nuts, washers, and bolts (165 thru 167) at each end of torque tubes (180, 181) and remove cranks (168) and spacers (169).

- (16) Remove cotter pins (170), nuts (171), washers (172), and bearing units (173).

- (17) Remove nuts, washers, and bolts (174 thru 176) to release cranks (177 thru 179).

- (18) Slide torque tubes (180, 181) out of door structure.

- (19) Remove rod assemblies (127, 132) and cranks (177 thru 179) from door structure.

NOTE: Do not disassemble rod assemblies (127, 132) unless repair or replacement is necessary.

- (20) Remove nuts (182), washers (183), bolts (184), shims (185, 186), and support fitting assemblies (187, 190, 193).

NOTE: Do not remove lubricator fittings (188, 191, 194) from support fittings (189, 192, 195) unless repair or replacement is necessary.

- (21) Remove nuts, washers, and bolts (196 thru 199) and housing assemblies (200).

NOTE: Do not remove lubricator fittings (201) from housings (202) unless repair or replacement is necessary.

- (22) Remove bearings (203) from support fittings (189, 192, 195) and housings (202).

- (23) Remove nuts, washers, and bolts (204 thru 206) and slide sleeves (207, 208) together on torque tube (43, Fig. 1102).

- (24) Remove bolts (1 thru 4, Fig. 1102), washers (5), fillers (6, 7), and shims (8). Record number and thickness of shims (8) to facilitate reassembly.

- (25) Remove cotter pin (8A), nuts (9, 9A), and washers (10, 10A) as applicable. Remove cam plate assembly (25), bolts (28), seal washers (29), washers (30), and external handle (14) with attached parts from door. Remove handle mechanism housing assembly (92) from door structure.

NOTE: Do not remove inserts (26) from cam plate (27) unless repair or replacement is necessary.

- (26) Remove bolts and washers (209, 210, Fig. 1101) and hinge link pins (211) with springs (212), washers (213), and O-ring packings (214) from upper and lower hinge arm assemblies (215, 222).

- (27) Remove nut, washer, screw, and striker block (218 thru 221) from hinge arm (224).

NOTE: Do not remove inserts (216, 223) from hinge arms (217, 224) unless repair or replacement is necessary.

- (28) Remove nuts (225), washers (226), bolts (227, 228), seal washers (229), and upper and lower hinge support assemblies (230, 241).

- (29) Disassemble upper hinge support assembly (230) by removing bolts (231, 233), washers (232, 234), and attach fitting (238) from hinge support (240).

NOTE: Do not remove rivets (235), nutplates (236, 237), or bushing (239) unless repair or replacement is necessary.

- (30) Disassemble lower hinge support assembly (241) by removing bolts (242, 244), washers (243, 245), and attach fitting (249) from hinge support (251).

NOTE: Do not remove rivets (246), nutplates (247, 248), bushing (250), or identification plate (252) unless repair or replacement is necessary.

- (31) Remove nuts, washers, and bolts (11 thru 13, Fig. 1102) and disassemble handle (14), spacer (15), and cam (16).

- (32) Using Wrench, F70038, disassemble sleeve (17), pin (18), washer (19), ring (20), nut (21), spring (22), pin (23), and shaft (24).

NOTE: Do not remove rivets (31) and seal plate (32) unless repair or replacement is necessary.

- (33) Remove O-ring packings (33, 34) and housing assembly (35).

NOTE: Do not remove lubricator fitting (36) from housing (37) unless repair or replacement is necessary.

- (34) Remove cotter pins (38) and use Wrench, F70085, to remove nuts (39).

- (35) Remove nuts, washers, bolts (40 thru 42), and hinge torque tube (43).

- (36) Remove nuts, washers, bolts (44 thru 47), rod assembly (48), and crank (53).

NOTE: Do not disassemble rod assembly (48) unless repair or replacement is necessary.

- (37) Remove nuts (54), washers (55), bolts (57, 58), and washers (56). Withdraw crank assemblies (68, 74) from housing (97) and remove crank assembly (59), spacer (63), and crank assembly (64).

NOTE: Do not remove rivets (60, 65) and nutplates (61, 66) from cranks (62, 67) unless repair or replacement is necessary.

- (38) Disassemble crank assembly (68) by removing cotter pin (69), nut (70), washers (71, 71A, 71B, 71C), and bearing unit (72) from crank arm (73).

- (39) Disassemble crank assembly (74) by removing cotter pin (75), nut (76), washers (77, 77A, 78, 78A), and bearing unit (79) from crank arm (80).

- (40) Remove nuts (81), washers (82), bolts (83, 84), and bearing retainers (85).

- (41) Remove bearings (86, 87), washer (88), retaining ring (89), and bearings (90, 91).

NOTE: Do not remove rivets (93, 99), nutplates (94, 95), shims (96), bushings (98), and fillers (100, 101), from housing (97) unless repair or replacement is necessary.

CLEANING

1. Clean all parts but bearings and window panes by standard industry practices and the instructions in SOPM 20-30-03.

CAUTION: BEARINGS (86, 87, 90, 91, FIG. 1102) HAVE TEFLON SEALS. CLEAN ONLY BY THE SPECIAL METHOD IN SOPM 20-30-01.

2. Clean and lubricate bearings by the instructions in SOPM 20-30-01.
3. Wipe window panes (54, 55, Fig. 1101) with a lint-free cloth wet with aliphatic naphtha TT-N-95.

INSPECTION/CHECK

1. Check all parts for obvious defects in accordance with standard industry practices.
2. Perform penetrant check per 20-20-02, if visual examination indicates evidence of defects, on items (72, 75, 78, 81, 84, 87, 90, 93, 96, 99, 102, 105, 108, 126, 131, 136, 141; 155, 156, 161, 162 (65C34053-1 thru -7 only); 145, 168, 189, 192, 195, 217, 224, 238, 240, 249, 251, Fig. 1101); and on (items 14, 17, 19, 21, 23, 24, 60-4455-1, -2, 27, 62, 65-54024-7, 69-1933-9, -14, -18, -20, -22, -508, 67, 73, 69-38733-2, 80, 90-7815-19, -21, -27, -29, 69-38733-2, 85, 69B10068-3, 97, Fig. 1102).
3. Do a magnetic particle check as specified in SOPM 20-20-01, if visual examination indicates evidence of defects on the items specified below.
 - A. Class A acceptance criteria for items 37 and 62, 65-1933-5, Fig. 1102.
 - B. Class B acceptance criteria for items 177, 178, 66-14531-9, 179, 66-14531-10, 180, 60-4406-13, 181, 60-4406-14, 207, 60-4365-3, 208, 211, 255, Fig. 1101; and 24, 60-4455-3, 43, 90-6753-19, 73, 90-7815-33, 80, 90-7815-33, Fig. 1102.
 - C. Class C acceptance criteria for items 121, 180, 60-4407-7, 181, 60-4406-8, Fig. 1101; and 22, 43, 90-6753-7, -12, 73, 90-7815-3, 80, 90-7815-3, Fig. 1102.
4. Check springs (212, Fig. 1101, and 22, Fig. 1102) for load capacity per Fig. 301.

Item and Fig. No.	Test Length (Inches)	Allowable Load Limits (Pounds)
212 - 1101	0.25	0.10 to 0.30
	0.20	0.13 to 0.33
22 - 1102	3.34	3.0 to 3.8
	2.05	5.8 to 7.0

Spring Check Data
Figure 301

REPAIR

1. Repair

NOTE: During fabrication, assemblies were fillet and injection sealed with either BMS 5-95 or other drawing approved sealants. To reduce the need for special refinishing and primer, BMS 5-95 is recommended for use as fillet and injection seals during maintenance activities.

A. Repair minor damage to this component using standard industry practices.

B. Repair mechanism housing assembly (92, Fig. 1102) bores.

- (1) Machine housing (97) as required, within repair limits shown, to remove defects. Refer to Fig. 401.
- (2) Chamfer the outside edge 0.06 inch x 45 degrees for housings 65-1642-15, -33. Chamfer the outside edge 0.04 inch x 45 degrees for housing 65-1642-45.
- (3) Do a penetrant check of machined surfaces. Refer to SOPM 20-20-02.
- (4) Dow 7 or 17 anodize housing (97, P/N 65-1642-15) bore. Dow 7 or 17 anodize housing (97, P/N 65-1642-33) bore and apply one coat of BMS 10-11, Type 1 primer (F-18.09). Dow 17 anodize housing (97, P/N 65-1642-45) bore and apply two coats of BMS 10-11, Type 1 primer (F-20.03). Refer to SOPM 20-43-02 and SOPM 20-41-02.
- (5) Manufacture applicable repair sleeve or repair bushing. Refer to Fig. 401.
- (6) Coat repair sleeve OD and housing bore with BMS 10-11, Type 1 primer and install wet.
- (7) Machine repair sleeve ID to housing bore design diameter. Refer to Fig. 401. Chamfer as shown for the housing bore.

NOTE: Maintain concentricity of upper and lower bores within 0.002 total indicator reading.

- (8) Brush-apply alodine on repair sleeve ID after machining.
- (9) Fillet seal periphery of repair sleeve with BMS 5-95, Class B sealant, both ends.

C. Repair mechanism housing assembly (92) mounting hole boss.

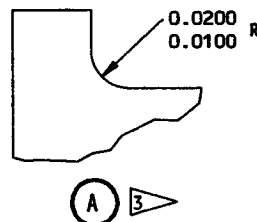
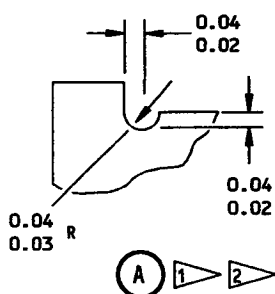
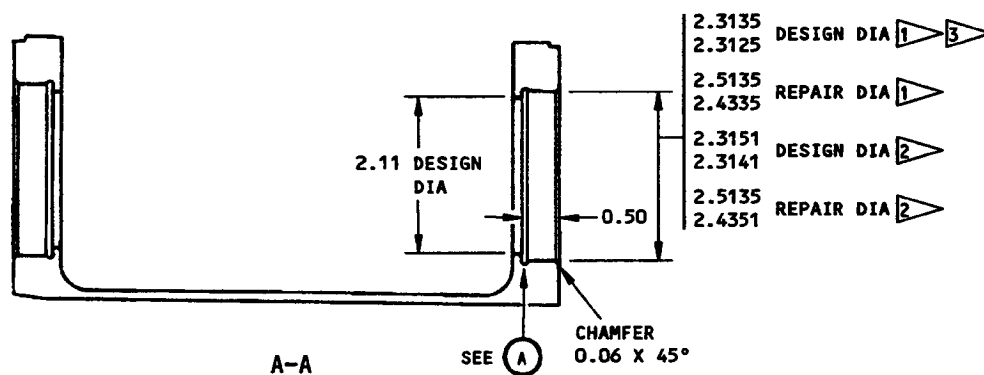
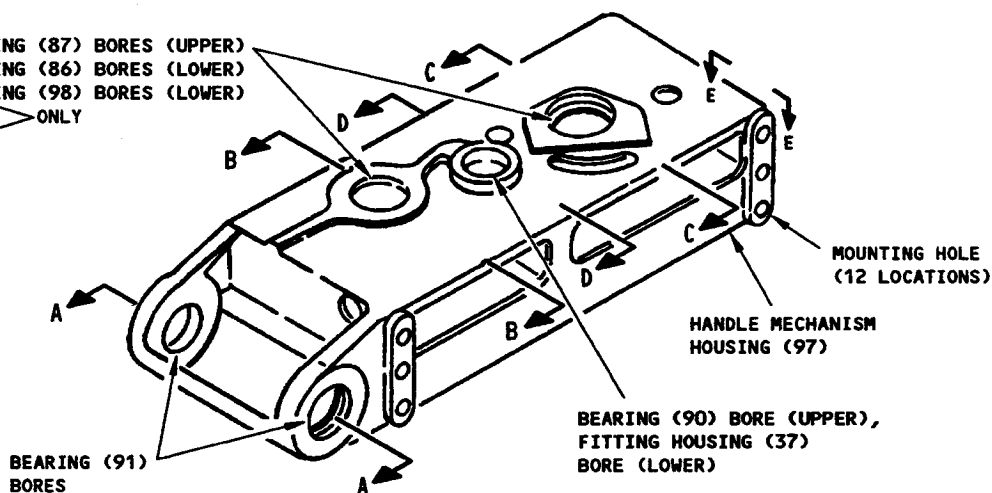
- (1) Machine the face of mounting hole boss to a depth of 0.063 inch to remove defects. Surface finish to be 125 microinch or better.
- (2) Do a penetrant check of machined surfaces. Refer to SOPM 20-20-02.

- (3) Dow 7 or 17 anodize housing (97) and apply one coat of BMS 10-11, Type 1, primer (F-18.09). Refer to SOPM 20-43-02 and SOPM 20-41-02.
 - (4) Use additional shims (8) as required when installing mechanism housing assembly (92).
- D. If the 1/4-inch diameter holes for the bolts (206, Fig. 1101) in the coupling sleeves (207, 208), hinge pins (211), or hinge torque tube (43, Fig. 1102) are worn or corroded, repair the holes as follows:
- (1) Machine the holes as specified in SOPM 20-10-02 to one of the repair diameters that follow:
 - (a) 0.2651-0.2661 inch diameter
 - (b) 0.2807-0.2817 inch diameter
 - (c) 0.2963-0.2973 inch diameter
 - (d) 0.3120-0.3130 inch diameter
 - (2) Assemble the parts as specified in the Assembly instructions with the fasteners (no substitution of the bolt grip length is permitted) that follow:
 - (a) For the 0.2651-0.2661 inch repair diameter - Use BACB30NE4-26X bolts, AN960D416 washers, and BACN10JC4 nuts.
 - (b) For the 0.2807-0.2817 inch repair diameter - Use BACB30NE4-26Y bolts, AN960D416 washers, and BACN10JC4 nuts.
 - (c) For the 0.2963-0.2973 inch repair diameter - Use BACB30NE4-26Z bolts, AN960D416 washers, and BACN10JC4 nuts.
 - (d) For the 0.3120-0.3130 inch repair diameter - Use BACB30NE5-26 bolts, AN960D516 washers, and BACN10JC5 nuts.

CAUTION: THE REPAIR SPECIFIED BELOW IS FOR 65-73978-() HINGE ARMS ONLY.

- E. Repair the 0.250 inch diameter holes on the hinge arm (217, 65-73978-4, -10; 224, 65-73978-3, -9, -11, -13: Fig. 1101).
- (1) Machine the holes as necessary to a maximum diameter of 0.375 inch (+0.0005/-0.0000) to remove defects. The surface roughness of the hole must be 125 microinch or better.
 - (2) Chamfer 0.035/0.045 inch by 45 degrees each side of the machined holes.
 - (3) Do a penetrant check of the machined surfaces as specified in SOPM 20-20-02 to make sure there is no corrosion, cracks, pits or other defects.
 - (4) Chemical treat the machined areas as specified in SOPM 20-43-03.
 - (5) Make a flanged bushing as specified in Fig. 401A.

BEARING (87) BORES (UPPER)
 BEARING (86) BORES (LOWER)
 BUSHING (98) BORES (LOWER)
 FOR 3 ONLY



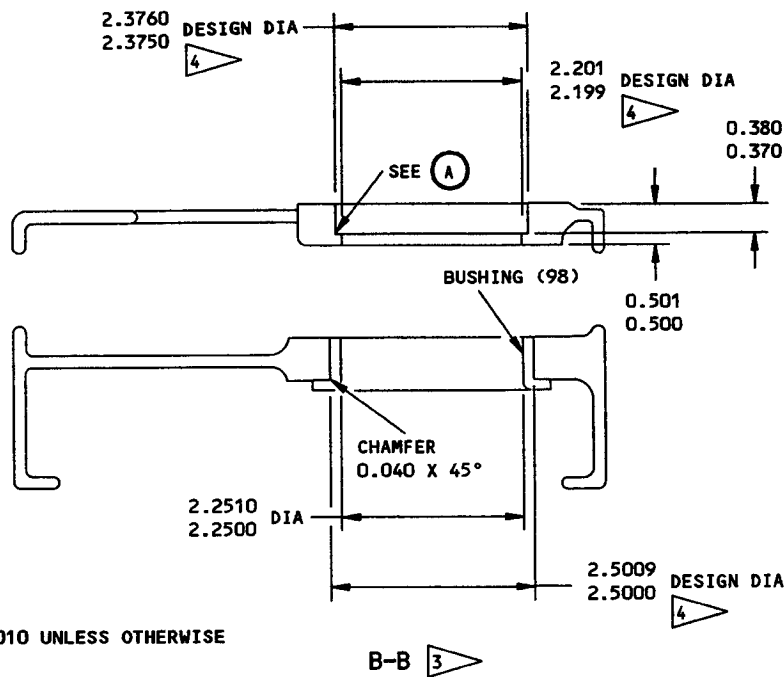
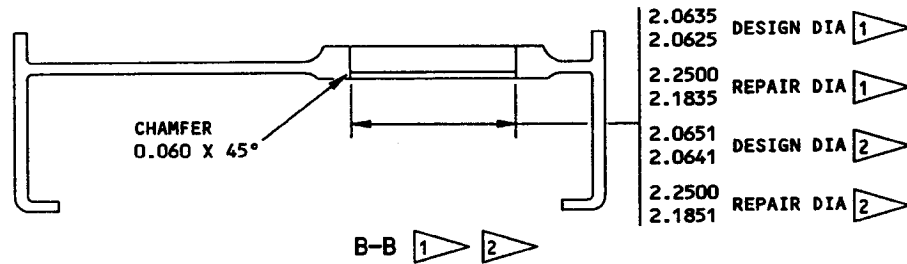
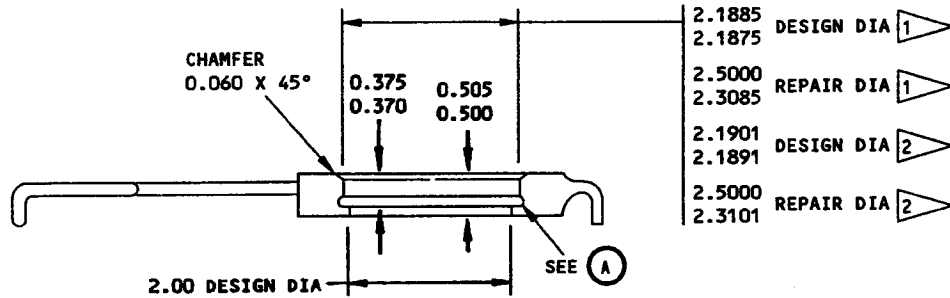
ALL DIMENSIONS APPLY FOR BOTH HOLES
 ALL TOLERANCES ± 0.010 UNLESS OTHERWISE
 SPECIFIED

- 1 HOUSING (97), 65-1642-15
- 2 HOUSING (97), 65-1642-33
- 3 HOUSING (97), 65-1642-45

ITEM NUMBERS REFER TO IPL FIG. 1102

HOUSING (97, FIG. 1102)

Handle Mechanism Housing Repair
 Figure 401 (Sheet 1)

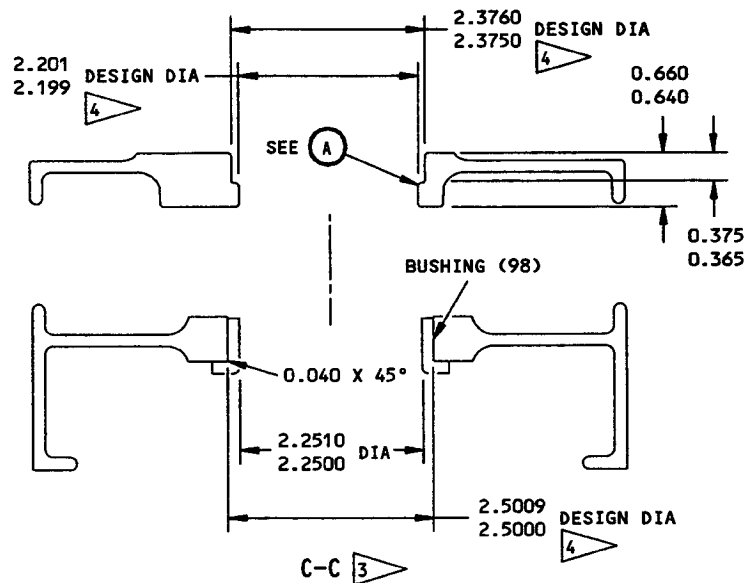
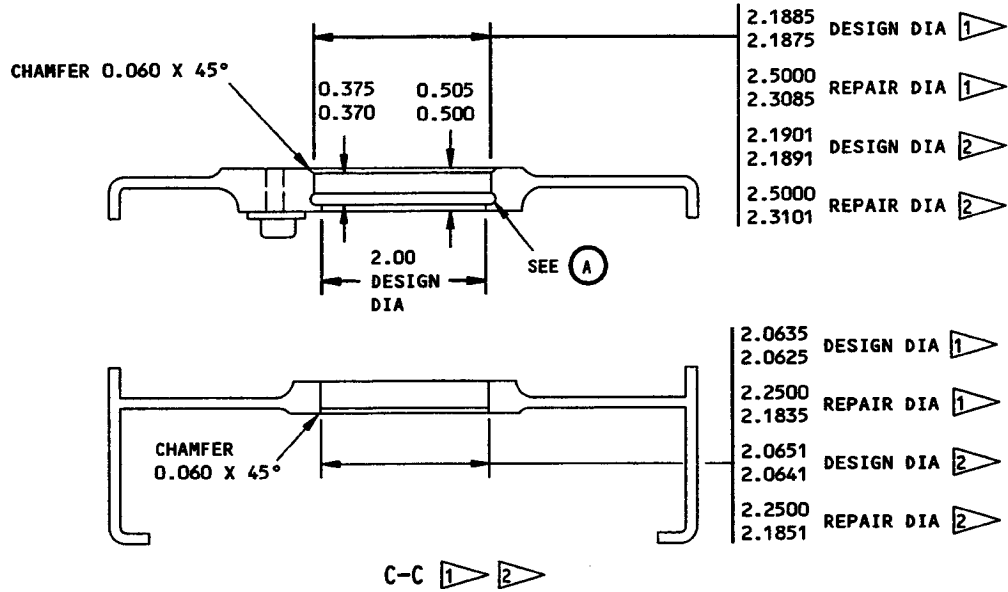


ALL TOLERANCES ± 0.010 UNLESS OTHERWISE SPECIFIED

- 1 HOUSING (97), 65-1642-15.
- 2 HOUSING (97), 65-1642-33.
- 3 HOUSING (97), 65-1642-45.
- 4 CONTACT BOEING TO COORDINATE REPAIRS FOR BORES INDICATED.

HOUSING (97, FIG. 1102)

Handle Mechanism Housing Repair
Figure 401 (Sheet 2)



ALL TOLERANCES ± 0.010 UNLESS OTHERWISE SPECIFIED

1 HOUSING (97), 65-1642-15

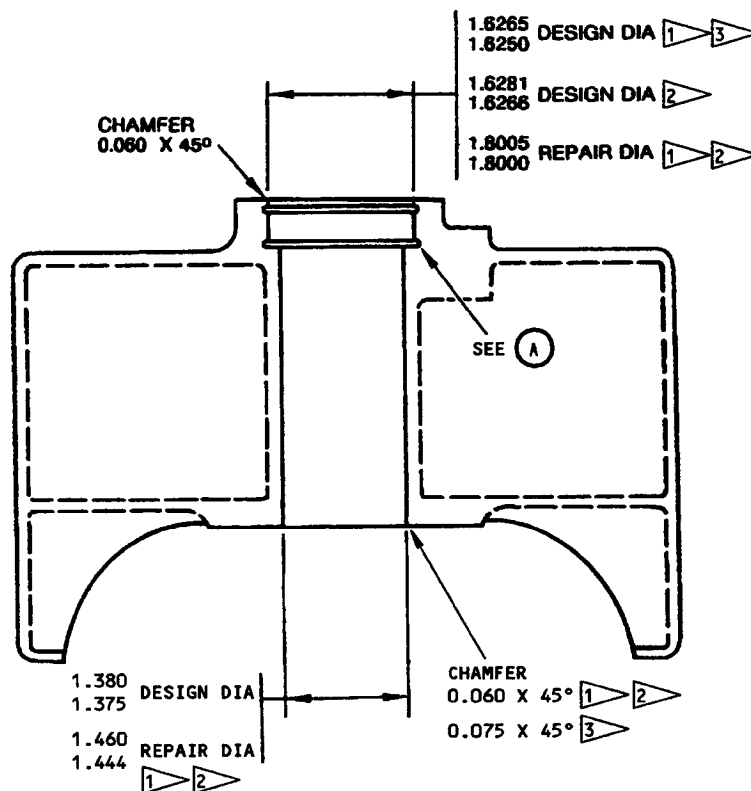
2 HOUSING (97), 65-1642-33

3 HOUSING (97), 65-1642-45

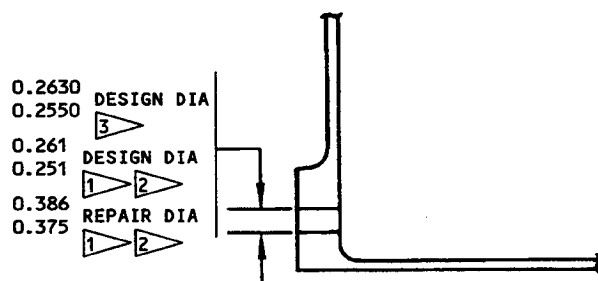
4 CONTACT BOEING TO COORDINATE REPAIRS FOR
BORES INDICATED.

HOUSING (97, FIG. 1102)

Handle Mechanism Housing Repair
Figure 401 (Sheet 3)



D-D

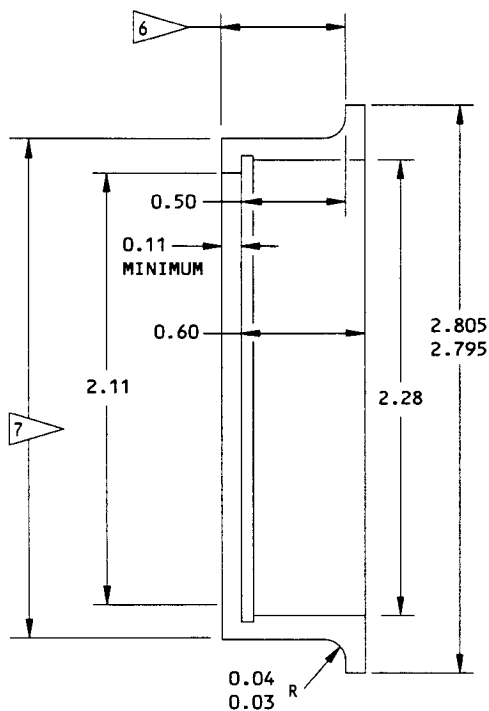


E-E

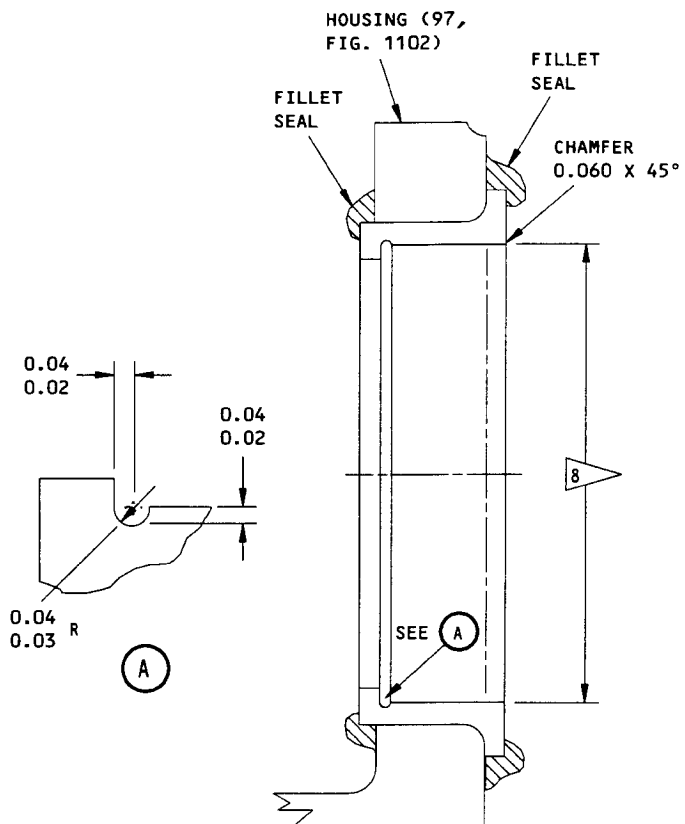
- 1 HOUSING (97), 65-1642-15
- 2 HOUSING (97), 65-1642-33
- 3 HOUSING (97), 65-1642-45

HOUSING (97, FIG. 1102)

Handle Mechanism Housing Repair
Figure 401 (Sheet 4)



SLEEVE FABRICATION



SLEEVE INSTALLATION

- 6 0.06-0.10 GREATER THAN THICKNESS OF HOUSING TO PERMIT APPLICATION OF SEALANT AFTER SLEEVE INSTALLATION.
- 7 FINAL SLEEVE OUTSIDE DIAMETER EQUALS REPAIR DIAMETER OF HOUSING PLUS 0.0005-0.0010 INTERFERENCE
- 8 DESIGN DIAMETER OF HOUSING (97, FIG. 1102) BORE FOR BEARING (91, FIG. 1102), MACHINE AFTER INSTALLATION.

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

ALL TOLERANCES ARE ± 0.010 UNLESS OTHERWISE SPECIFIED

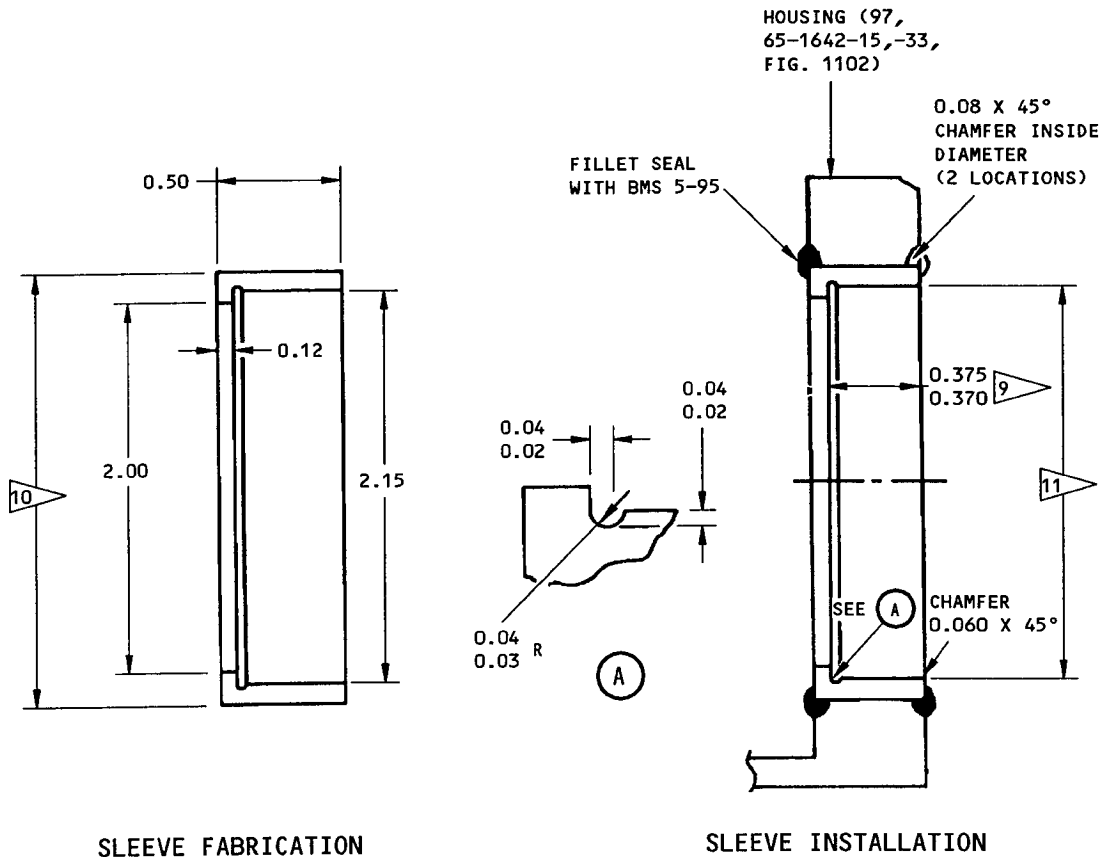
MATERIAL: AL ALLOY 7075-T6

FINISH: CHROMIC ACID ANODIZE PER 20-43-01 AND APPLY ONE COAT BMS 10-11, TYPE 1 PRIMER

ALL DIMENSIONS ARE IN INCHES

REPAIR SLEEVE FOR BEARING (91) BORE

Handle Mechanism Housing Repair
Figure 401 (Sheet 5)



SLEEVE FABRICATION

SLEEVE INSTALLATION

- 9 CONTROLLING DIMENSION FOR BEARING DEPTH.
- 10 FINAL SLEEVE OUTSIDE DIAMETER EQUALS REPAIR DIAMETER OF HOUSING PLUS 0.002-0.003 INTERFERENCE.
- 11 DESIGN DIAMETER OF HOUSING (97, 65-1642-15, -33, FIG. 1102) BORE FOR BEARINGS (87, BACB10BW23, FIG. 1102). MACHINE AFTER INSTALLATION.

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

ALL TOLERANCES ARE ± 0.010 UNLESS OTHERWISE SPECIFIED

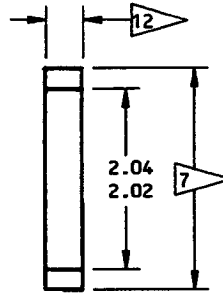
MATERIAL: AL ALLOY 7075-T6

FINISH: CHROMIC ACID ANODIZE PER 20-43-01 AND APPLY ONE COAT BMS 10-11, TYPE 1 PRIMER

ALL DIMENSIONS ARE IN INCHES

REPAIR SLEEVE FOR BEARING (87, BACB10BW23) BORES

Handle Mechanism Housing Repair
Figure 401 (Sheet 6)



- 7 FINAL SLEEVE OD EQUALS REPAIR DIA OF HOUSING PLUS 0.0005-0.0010 INTERFERENCE
- 12 SLEEVE LENGTH TO BE FLUSH MINUS 0.00-0.03 WITH HOUSING

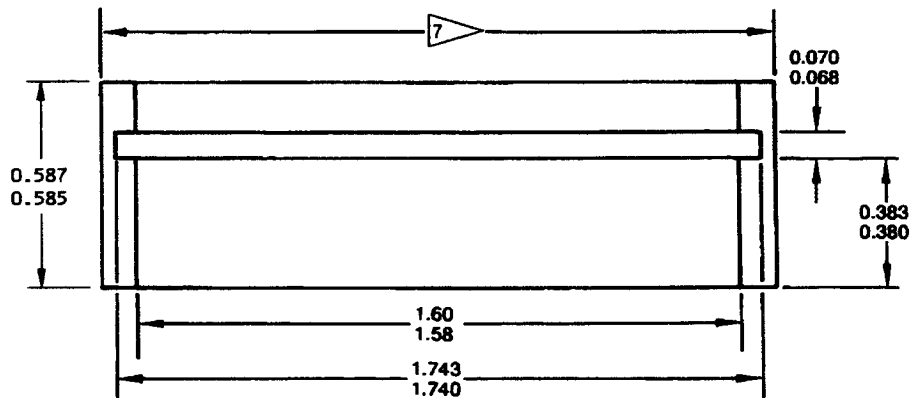
125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: AL ALLOY, 7075-T6

FINISH: CHROMIC ACID ANODIZE PER 20-43-01 AND APPLY ONE COAT OF BMS 10-11, TYPE 1, PRIMER

ALL DIMENSIONS ARE IN INCHES

REPAIR SLEEVE FOR BEARING (86) BORES -
 APPLICABLE TO HOUSINGS (97, 65-1642-15,-33) ONLY



- 7 FINAL SLEEVE OD EQUALS REPAIR DIA OF HOUSING PLUS 0.0005-0.0010 INTERFERENCE

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

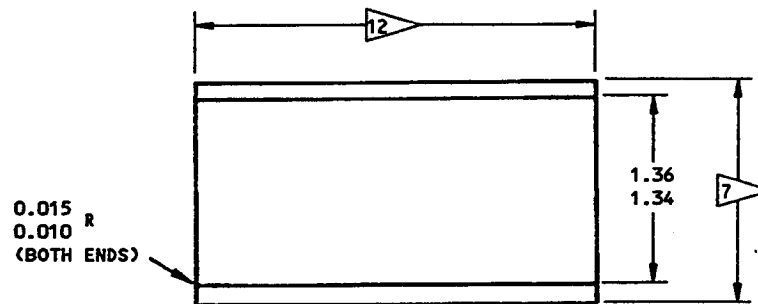
MATERIAL: AL-NI-BRONZE

FINISH: CADMIUM PLATE PER 20-42-05 AND APPLY ONE COAT OF BMS 10-11, TYPE 1, PRIMER

ALL DIMENSIONS ARE IN INCHES

REPAIR SLEEVE FOR BEARING (90) BORE

Handle Mechanism Housing Repair
 Figure 401 (Sheet 7)



- 7 FINAL SLEEVE OD EQUALS REPAIR DIA OF HOUSING PLUS 0.0005-0.0010 INTERFERENCE
- 12 SLEEVE LENGTH TO BE FLUSH MINUS 0.00-0.03 WITH HOUSING

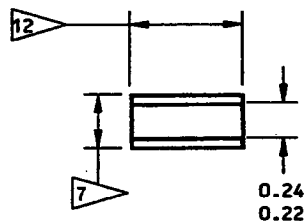
125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: AL ALLOY, 7075-T6

FINISH: CHROMIC ACID ANODIZE PER 20-43-01 AND APPLY ONE COAT OF BMS 10-11, TYPE 1, PRIMER

ALL DIMENSIONS ARE IN INCHES

REPAIR SLEEVE FOR FITTING HOUSING (37) BORE



- 7 FINAL SLEEVE OD EQUALS REPAIR DIA OF HOUSING PLUS 0.0005-0.0010 INTERFERENCE
- 12 SLEEVE LENGTH TO BE FLUSH MINUS 0.00-0.03 WITH HOUSING

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: AL ALLOY, 7075-T6

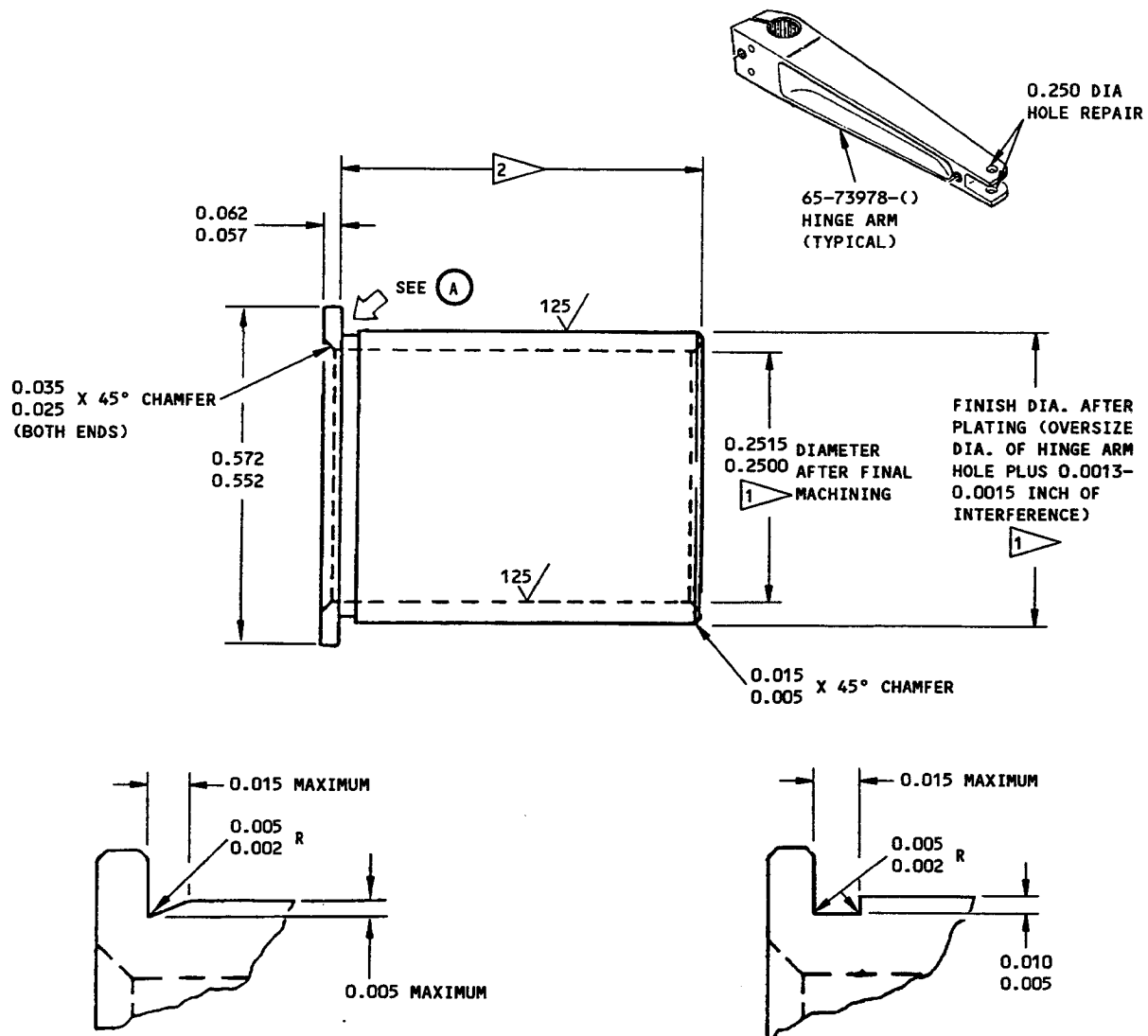
FINISH: CHROMIC ACID ANODIZE PER 20-43-01 AND APPLY ONE COAT OF BMS 10-11, TYPE 1, PRIMER

ALL DIMENSIONS ARE IN INCHES

REPAIR SLEEVE FOR MOUNTING HOLES

Handle Mechanism Housing Repair
Figure 401 (Sheet 8)

- (6) Use the shrink fit procedure as specified in SOPM 20-50-03 to install the bushings in the holes wet with BMS 5-95 sealant. Make sure the flanges are on the external surfaces of the hinge arm and the end of the bushing opposite the bushing flange does not extend out of the hole.
- (7) Remove excess sealant after the bushing is installed.
- (8) Machine the bushing holes to a diameter of 0.2500 to 0.2515 inch. Chamfer the ends of the bushing holes as specified in Fig. 401A.
- (9) Attach a tag to the 0.250 inch hole to identify that it will be necessary to install a longer bolt because of the bushing flange thicknesses. To prevent corrosion, a chromium plated bolt, BACB30LJ4C, should be used.



ALTERNATIVE RELIEF TYPES

(A)

REFINISH

CADMIUM PLATE (F-15.06) THE EXTERNAL SURFACES OF THE BUSHING.

- 1 THE INNER AND OUTER DIAMETERS ARE TO BE CONCENTRIC AND PARALLEL WITHIN 0.003 TIR
- 2 THE LENGTH MUST BE THE SAME AS THE LUG THICKNESS OF THE HINGE ARM

REPAIR

REF 1 2

MATERIAL: ALUMINUM-NICKEL-BRONZE AS SPECIFIED IN AMS 4640.

BREAK ALL SHARP EDGES

PENETRANT CHECK

ALL DIMENSIONS ARE IN INCHES

FLANGED BUSHING FOR HINGE ARM (65-73978-())

Repair Bushing Detail
Figure 401A

2. Refinish

NOTE: Refer to SOPM 20-30-02 for stripping of protective finishes and to 20-41-01 for explanation of F and SRF finish codes.

A. Door Installation Items (Fig. 1101)

- (1) Retainer springs (254) -- Apply two coats primer (F-20.03) all over. Material: Steel music wire.
- (2) Door stop pins (255) -- Cadmium plate per SOPM 20-42-05, Type 2, Class 2 (F-1.1923) all over. Material: Steel, AMS 4140 or 4340, 160-180 ksi.
- (3) Hinge covers (258, 65-52873-103, 263, 65-52873-104) -- Apply Alodine 1000 (SRF-14.01) all over. Material: Al Alloy.
- (4) Hinge covers (258, 65-52873-179, 263, 65-52873-178) -- Clear chemical treat as specified in SOPM 20-43-03 and apply BMS 10-79, Type 3 primer (F-19.66). Material: Al alloy.
- (5) Hinge covers (258, 65-52873-564, 263, 65-52873-563) -- Apply Alodine 1000 to all surfaces as specified in SOPM 20-43-03 and apply BMS 10-11, Type 1 primer (F-20.03). Material: Al alloy.
- (6) Block (266) and plugs (275) -- Alodize (colored film) or chromic acid anodize (Ref SOPM 20-43-01) and apply one coat primer (SRF-2.30) all over. Material: Al alloy.
- (7) Roller fitting (270) -- Chromic acid anodize (Ref SOPM 20-43-01) (F-2.20) all over followed by one coat primer (SRF-12.205) except omit primer on serrations. Material: Al alloy.
- (8) Centering guide (274) -- Hard chrome plate (Ref SOPM 20-42-03) (F-1.842) to 0.002-inch minimum thickness on rounded ball surface. Cadmium plate per 20-42-05, Type 1, Class 2 (F-1.191) to ball slot, back side of ball, and shank. Material: Steel, AMS 4130 or 4330, 150-170 ksi.

B. Door Assembly (Fig. 1101)

- (1) Retainer (7), coverplates (11, 12, 27), bracket (22), reinforcing angles (38, 39), fillers (42, 60, 146, 147), doubler (60G), stop fittings (72, 75, 65-45852-4, -504, 78, 81, 87, 90, 108), fittings (238, 249, 69-42114-2, -1), and hinge supports (240, 251) -- Alodize (colored film) or chromic acid anodize (Ref SOPM 20-43-01) and apply one coat primer (SRF-2.30) all over. Material: Al alloy.
- (2) Clips (49) -- Zinc plate and apply one coat primer (SRF-1.305) all over. Material: Steel, AISI 301.
- (3) Retainer (53) -- Alodize (colored film) or chromic acid anodize (Ref SOPM 20-43-01) and apply one coat primer (SRF-2.30) all over, except omit primer on top of lower flange and flange radius. Material: Al alloy.

- (4) Window doubler assembly (56G, 69-43894-7) -- Apply BMS 10-79, Type 2 primer and BMS 10-60, Type 2 enamel (SRF-14.9863-702) to interior (nutplate and flange) surfaces. Material: Al alloy.
- (5) Stop fitting (75, 65-45852-10, 81, 65-49890-10) -- Boric acid-sulfuric acid anodize (F-17.35) and apply BMS 10-11, Type 1 primer (F-20.03) but do not apply primer in the hole for the bushing. Material: Al alloy.
- (6) Stop fittings (84, 87, 93, 96, 99, 102, 105) -- Chromic acid anodize and apply one coat primer (SRF-2.19) all over. Material: Al alloy.
- (7) Rod (121) -- Cadmium plate exterior surfaces per 20-42-05, Type 2, Class 2; apply 2 coats primer to interior surfaces (SRF-1.611) except omit primer on threads. Material: Steel, AMS 4130, 150-170 ksi.
- (8) Rods (126, 131, 136) -- Alodize (colored film) (F-2.742) all over, followed by one coat primer (SRF-12.205) on exterior surface only. Material: Al alloy.
- (9) Gate (141, 65-55479-3) -- Apply Dow-7 treatment and one coat primer (SRF-3.17) all over except omit primer from bore which receives bushing (140), 0.4353-inch diameter bore adjacent to bushing (140) lug, and area noted in Fig. 402. Apply one coat primer (SRF-12.205) all over except in bore which receives bushing (140), 0.4353-inch diameter bore adjacent to bushing (140) lug, and to area noted in Fig. 402. Obtain a total SRF-3.17 and SRF-12.205 coating system thickness of 0.004 inch minimum. Apply BMS 10-86, Type 1 teflon-filled coating, white (SRF-14.9624), to area indicated in Fig. 402. Material: Magnesium alloy.
- (10) Gate (141, 65-55479-503) -- Dow-17 anodize or Dow-7 treat followed by two coats primer (SRF-3.30), plus two coats BMS 10-60 gloss enamel, BAC 702 white (SRF-14.9815-702), except omit primer and enamel in bore which receives bushing (140), 0.4353-inch diameter bore adjacent to bushing (140) lug, and to area noted in Fig. 402. Obtain a total SRF-3.30 and SRF-14.9815-702 coating system thickness of 0.004 inch minimum. Apply BMS 10-86, Type 1 teflon-filled coating, white (SRF-14.9624), to area indicated in Fig. 402. Material: Magnesium alloy.
- (11) Gate (141, 65-55479-9) -- Dow-17 anodize or Dow-7 chemical treatment to meet MIL-M-3171, Type 3. Apply two (2) coats of BMS 10-79, Type 3 primer (F-19.66). Apply two (2) coats of BMS 10-60 gloss enamel, BAC 702 white (SRF-14.9815-702) to obtain a total coating system thickness of 0.004 inch minimum. Material: Magnesium alloy.
- (12) Gate (145, 65-55478-4) -- Apply Dow-7 treatment and two coats primer (SRF-3.17 plus SRF-12.205), all over except omit primer from bore which receives bushings (143, 144) and 0.4353-inch diameter bore adjacent to bushing (143) lug. Material: Magnesium alloy.

- (13) Gate (145, 65-55478-504) -- Dow 17 anodize or Dow 7 treatment followed by two coats primer (SRF-3.30), plus two coats BMS 10-60 gloss enamel, BAC 702 white (SRF-14.9815-702), except omit primer and enamel in bores which receive bushings (143, 144) or in 0.4353-inch diameter bore adjacent to bushing (143) lug. Obtain complete coating system thickness of 0.004 inch minimum. Material: Al alloy.
- (14) Gate (145, 65-55478-10) -- Dow 17 anodize or Dow 7 chemical treatment to meet MIL-M-3171, Type 3. Apply two (2) coats of BMS 10-79, Type 3 primer (F-19.66). Apply two (2) coats of BMS 10-60 gloss enamel, BAC702 white (SRF-14.9815-702) to obtain a total coating system thickness of 0.004 inch minimum. Material: Magnesium alloy.
- (15) Hinge halves (155, 156, 161, 162; 65-52873-71 thru -74 and 65-52855-507, -509 only) -- Alodize (colored film) or chromic acid anodize (Ref SOPM 20-43-01) and apply two coats primer (SRF-2.30 plus SRF-12.205), except omit primer in hinge pin holes. Material: Al alloy.
- (16) Hinge halves (155, 156, 161, 162; 65C34053-1 thru -7 only) -- Chromic acid anodize and apply one coat of BMS 10-11, Type 1 primer (F-18.13) except omit primer in hinge pin holes. Material: Al alloy.
- (17) Seal retainers (154, 160, 163, 164) -- Alodize (colored film) or chromic acid anodize (Ref SOPM 20-43-01) and apply two coats primer (SRF-2.30 plus SRF-12.205) all over. Material: Al alloy.
- (18) Crank (168) -- Alodize (colored film) or chromic acid anodize (Ref SOPM 20-43-01) and apply one coat primer (SRF-2.30) all over, except omit primer on 0.995-0.997 and 0.869-0.870-inch OD's. Material: Al alloy.
- (19) Cranks (177, 66-14530-1; 178, 66-14531-1; 179, 66-14531-3) -- Cadmium plate per SOPM 20-42-05, Type 2, Class 2 and apply one coat primer (SRF-1.285) all over. Material: Steel, AMS 4130 or 8630, 125-140 ksi.
- (20) Cranks (177, 66-14530-2; 178, 66-14531-10; 179, 66-14531-9) -- Prepare surface and passivate. Material: 15-5 PH CRES, H.T. 150-170 ksi.
- (21) Torque tubes (180, 60-4406-7; 181, 60-4406-8) and sleeves (207, 208, 60-4365, 66-24987-1) -- Cadmium plate exterior surfaces per 20-42-05, Type 2, Class 2; apply 2 coats primer to interior surfaces (SRF-1.611). Material: Steel, AMS 4130, 4340 or 8630, 150-170 ksi.
- (22) Torque tubes (180, 60-4406-13; 181, 60-4406-14) -- Apply cadmium plating (F-15.06) to external surfaces and a minimum of 1.60 inches on each internal end. Apply (1) coat of BMS 10-11 primer (F-20.02) to the internal surface. Material: 17-7 PH CRES (15-5 PH CRES optional), 150-170 ksi.

- (23) Support fittings (189, 65-49560-2; 192, 65-49560-6; 195, 65-49560-7) -- Chemical treat or chromic acid anodize and apply BMS 10-11, Type 1 primer (SRF-2.30) but no primer in bores. Material: Al alloy.
- (24) Support fittings (189, 65-49560-10, -16; 192, 65-49560-12, -18; 195, 65-49560-14, -20) -- Anodize (F-17.05) and apply BMS 10-11, Type 1 primer (F-20.02). Material: Al alloy.
- (25) Housing (202) -- Chemical treat or chromic acid anodize (SOPM 20-43-01) and apply BMS 10-11, Type 1 primer (SRF-2.30) but no primer in bores. Material: Al alloy.
- (26) Sleeves (207, 208, 60-4365-1, 66-24987-2) -- Cadmium plate (F-16.04) exterior surfaces (throw-in permitted). On interior surfaces, apply phosphate coating (F-14.14) followed by primer (F-20.03) (maximum primer thickness 0.0008 inch). Material: 4130 steel, 125-145 ksi.

NOTE: Sleeves (207, 208) 60-4365 and 66-24987-1 can be updated to the 60-4365-1 and 66-24987-2 configuration, respectively, for better corrosion resistance. To do this, remove the old finish from the interior and apply the new finish as indicated above.

- (27) Sleeve (207, 60-4365-3) -- Cadmium plate (F-15.06), throw-in permitted. Material: 17-7PH CRES (15-5 PH CRES optional), 150-170 ksi.
- (28) Sleeve (208, 66-24987-3) -- Passivate (F-17.25, which replaces F-17.09). Material: 17-7PH CRES (15-5 PH CRES optional), 150-170 ksi.
- (29) Hinge link pins (211, 66-14527-1, -2) -- Cadmium plate (F-1.191) all over. Material: 4340 steel, 125-145 ksi.
- (30) Hinge link pins (211, 66-14527-4) -- Cadmium plate (F-16.04) outer surfaces (throw-in permitted), 0.0002-0.0004 inch thick on splines. Apply phosphate coating (F-14.14) followed by BMS 10-11, Type 1 primer (F-20.03) to interior surfaces. Material: 4340 steel, 125-145 ksi.

NOTE: Hinge link pins (211, 66-14527-1, -2) can be updated to the 66-14527-4 configuration for better corrosion resistance. To do this, remove the old finish and apply the new finish as indicated above.

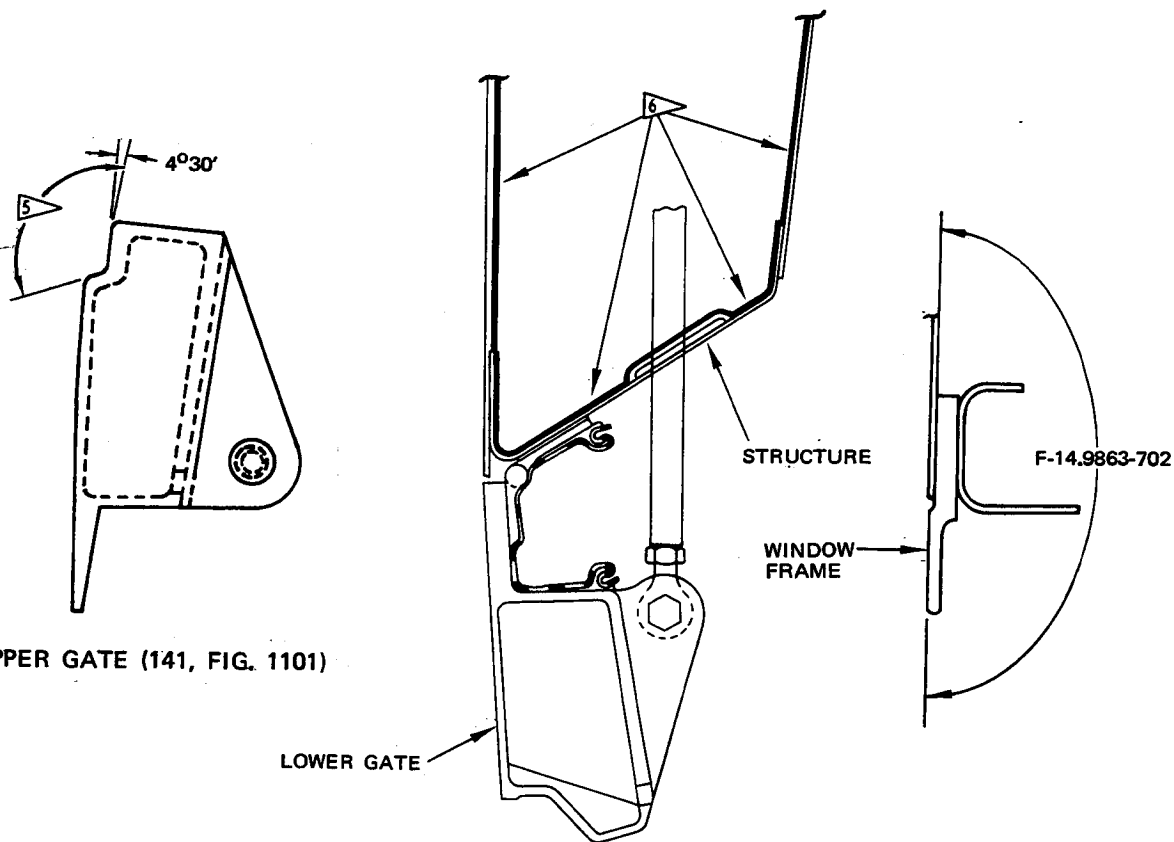
- (31) Hinge link pin (211, 66-14527-6) -- Cadmium plate (F-15.06). Material: 15-5 PH CRES, 150-170 ksi.
- (32) Spring (212) -- Cadmium plate (F-1.20) all over. Material: Steel music wire.
- (33) Hinge arms (217, 69-17952-20, 224, 69-17952-19) -- Chemical treat or chromic acid anodize and apply BMS 10-11, Type 1 primer (SRF-2.30) but no omit primer on splines. Material: Al alloy.

- (34) Hinge arms (217, 65-73978-4; 224, 65-73978-3, -9) -- Chemical treat or chromic acid anodize and apply BMS 10-11, Type 1 primer (SRF-2.30) and apply BMS 10-11, Type 2 enamel (F-21.03). Do not apply primer or enamel to the splined hole. Material: Al alloy.
- (35) Hinge arms (217, 65-73978-10; 224, 65-73978-11) -- Chemical treat or chromic acid anodize and apply BMS 10-11, Type 1 primer (F-18.05) and apply BMS 10-11, Type 2, color 702 white enamel (F-21.25). Do not apply primer or enamel to the splined hole. Material: Al alloy.
- (36) Fittings (238, 249, 69-70268-2, -1) -- Anodize and apply BMS 10-11, Type 1 primer (F-18.04) all over. Material: Al alloy.
- (37) Door structure
 - (a) Apply BMS 3-23 corrosion inhibiting compound (F-19.26) to all accessible interior surfaces of door structure (Fig. 402).

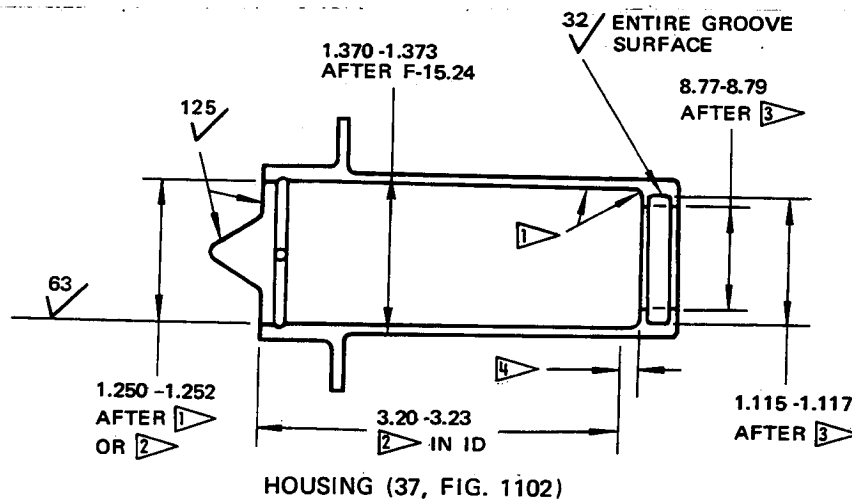
NOTE: Refer to par. 3.G. for additional corrosion protection instructions, and to SOPM 20-41-05 for application procedures.
 - (b) Apply BMS 10-79, Type 2 primer and BMS 10-60, Type 2 white enamel (F-14.9863-702) to entire surface of window frame (Fig. 402).

C. Handle Mechanism (Fig. 1102)

- (1) Fillers (6, 7), spacer (15), plate (32) and bearing retainers (85) -- Chemical treat or chromic acid anodize and apply BMS 10-11, Type 1 primer (SRF-2.30) all over. Material: Al alloy.
- (2) Outer handle (14, 90-7879, -1) -- Chromic acid anodize (F-17.04) (no substitutions permitted for chromic acid anodize) but seal in deionized water. Material: Al alloy.
- (3) Outer handle (14, 90-7879-5) -- Boric acid-sulfuric acid anodize (F-17.29) (no substitutions permitted). Material: Al alloy.
- (4) Outer handle (14, 90-7879-7) -- Sulfuric acid anodize (F-14.2998) (non-directional on exterior surface only (63 microinch finish)). Material: Al alloy.
- (5) Nuts (21, 39, 60-4405-1) -- Chromic acid anodize (F-2.20) all over. Material: Al alloy.
- (6) Cam (16) -- Cadmium plate per SOPM 20-42-05, Type 2, Class 2 (F-4.20) all over. Material: Al-bronze or beryllium copper alloy.



DOOR STRUCTURE (FIG. 1101)



NOTE : ALL LINEAR DIMENSIONS ARE IN INCHES

- 1 APPLY F-19.10 TO P/N 90-7820-1
- 2 APPLY F-15.03 TO P/N 69-61511-2 AND GRIND TO DIMENSIONS SHOWN
- 3 APPLY F-1.1913 OR F-15.24, AS APPLICABLE
- 4 F-15.03 RUNOUT
- 5 APPLY SRF-14.9624 FULL LENGTH OF GATE. OMIT ALL OTHER FINISHES FROM THIS AREA
- 6 APPLY BMS 3-23 TO ALL ACCESSIBLE INTERIOR SURFACES

- (7) Sleeve (17) -- Apply dry film lubricant BMS 3-8, Class A (F-19.10) all over 0.0002-0.0005 inch thick. Maintain after-coating ID of 1.080-1.083 inches and OD of 1.246-1.248 inches. Material: Al-Ni-Bronze per AMS 4640.
- (8) Washer (19) -- Cadmium plate per SOPM 20-42-05, Type 2, Class 2 (F-4.201) all over. Material: Al-Ni-Bronze per AMS 4640.
- (9) Spring (22) -- Cadmium plate per SOPM 20-42-05, Type 2, Class 2 (F-1.1923). Material: Steel music wire.
- (10) Pin (23) -- Apply no finish. Material: 303 CRES.
- (11) Shaft (24, 60-4455-1, -2) -- Passivate (F-8.07) and apply dry film lubricant, BMS 3-3, Type 1 (0.0002 to 0.0005 inch thick) on large spline area. Material: 303 CRES ANNEALED.
- (12) Shaft (24, 60-4455-3) -- Passivate (F-17.25) all over. Cadmium plate (F-15.06) on small spline, apply dry film lubricant BMS 3-3 (0.0002-0.0005 inch thick) on large spline as specified in SOPM 20-50-08, Type VIII. Material: 15-5 PH CRES, 150-170 ksi.
- (13) Cam Plate (27) -- Chromic acid anodize (SOPM 20-43-01) (F-2.26) all over, followed by one coat primer (SRF-12.205) and one coat enamel, BMS 10-11, Type 2, BAC707 gray (SRF-12.63), except omit primer and enamel on perimeter, roller contact areas, and in bores. Material: Al alloy.
- (14) Housing (37, 90-7820-1) -- Cadmium plate per SOPM 20-42-05, Type 2, Class 2 (F-1.1923) all over, followed by dry lubricant, BMS 3-8, Class A (F-19.10) to inside surfaces as shown in Fig. 402. Maintain specified ID and OD dimensions and surface finishes. Material: 4130 steel, 125-145 ksi.
- (15) Housing (37, 69-61511-2) -- Cadmium plate external surfaces per SOPM 20-42-05, Type 2 Class 2 (F-15.06) and internal surfaces not chrome plated. Chrome plate (SOPM 20-42-03) (F-15.03) internal surfaces shown in Fig. 402. Maintain specified ID and OD dimensions and surface finishes. Material: 4340 steel, 125-145 ksi.
- (16) Nut (39, 60-4405) -- Cadmium plate per SOPM 20-42-05, Type 1, Class 3 (F-1.1913) all over. Material: 4130 or 8630 steel, normalized.
- (17) Hinge torque tube (43, 90-6753-7) -- Cadmium plate exterior surfaces per SOPM 20-42-05, Type 2, Class 2; apply 2 coats primer to interior surfaces (SRF-1.611) except apply cadmium plating Type 1, Class 2 (F-1.20) to threaded surfaces. Material: 4340 or 4135 steel, 125-145 ksi.
- (18) Hinge torque tube (43, 90-6753-19) -- Cadmium plate (F-15.02) per 20-42-05. Material: 17-7 PH CRES, 150-170 ksi.

- (19) Hinge torque tube (43, 90-6753-12) -- Cadmium plate exterior surfaces per SOPM 20-42-05, Type 2, Class 2 (F-16.04) (throw-in permitted); apply phosphate coating (F-14.14) followed by one coat primer (F-20.03) to interior surface. Material: 4340 steel, 125-145 ksi.

NOTE: Hinge torque tube (43, 90-6753-7) may be reworked to 90-6753-12 for improved corrosion protection by stripping existing finish and applying finish as indicated above.

- (20) Rod (52) -- Cadmium plate exterior surfaces per SOPM 20-42-05, Type 2, Class 2 (F-1.1923). Apply corrosion preventive compound, MIL-C-11796, Class 1 (F-1.73) to interior. Material: 8630 or 4130 steel, 150-170 ksi.
- (21) Crank (53, 69-17330-2) -- Cadmium plate as specified in SOPM 20-42-05 (F-1.191). Material: 4130 steel, 150-170 ksi.
- (22) Crank (53, 69-17330-4) -- Passivate (F-17.09). Material: 15-5PH CRES, 150-170 ksi.
- (23) Washer (56) -- Cadmium plate per SOPM 20-42-05, Type 2, Class 2 (F-1.1923). Material: 1020 or 1025 steel.
- (24) Cranks (62, 65-54024-7) -- Alodize (colored film) or chromic acid anodize (Ref SOPM 20-43-01) and apply one coat primer (SRF-2.30) all over, except omit primer on splines. Material: Al alloy.
- (25) Crank (62, 65-1933-5) -- Passivate (F-8.07). Material: 15-5 PH or 17-4PH CRES, 180-210 ksi.
- (26) Cranks (62, 65-1933-18, -20) -- Chemical treat or chromic acid anodize and apply one coat of BMS 10-11, Type 1 primer (F-18-03) then apply BMS 10-11, Type 1 primer again (F-20.02). Do not apply primer on splined surface. Material: Aluminum alloy.
- (27) Cranks (62, 65-1933-9, -14, -22, -508) -- Chromic acid anodize, and apply one coat BMS 10-11, Type 1 primer (F-18.13) then apply BMS 10-11, Type 1 primer again (F-20.02). Do not apply primer on splined surface. Material: Aluminum alloy.
- (28) Crank arms (73, 80, 90-7815-3) -- Cadmium plate and apply BMS 10-11, Type 1 primer (SRF-1.611), except 0.0002-0.0003 single plating thickness. Material: 4340 steel, 150-170 ksi.
- (29) Crank arms (73, 80, 69-38733-2) -- Chromic acid anodize (Ref SOPM 20-43-01) (F-2.26) all over, followed by one coat primer (SRF- 12.205) except on 1.3120- and 1.4370-inch OD's. Material: Al alloy.
- (30) Crank (73, 90-7815-33) -- Passivate all surfaces (F-17.25) and then apply BMS 3-8 solid film lubricant (F-19.10) to the splined area. Material: 15-5PH CRES, 150-170 KSI.
- (31) Crank (80, 90-7815-19-21) -- Chromic acid anodize and apply BMS 10-11, Type 1 primer (F-18.13) and then apply BMS 10-11, Type 1 primer (F-20.02) again. Do not apply primer to the splined surfaces or to the 1.3110-1.3120 inch and 1.4360-1.4370 inch diameters. Material: Al alloy.

- (32) Crank (80, 90-7815-27, -29) -- Boric acid-sulfuric acid anodize (F-17.35) and apply BMS 10-11, Type 1 primer (F-20.03). Do not apply primer to the splined surfaces or to the 1.3110-1.3120 inch and 1.4360-1.4370 inch diameters. Material: Al alloy.
- (33) Retainer (85) - Chemical treat or chromic acid anodize (F-17.01) and apply BMS 10-11, Type 1 primer (F-20.02). Material: Al alloy.
- (34) Housing (97, P/N 65-1642-15) -- Dow-17 anodize per SOPM 20-43-02 (or Dow-7 treat) and apply three coats of BMS 10-11, Type 1 primer per SOPM 20-41-02 (SRF-3.71) all over except in holes Dow 17 anodize per SOPM 20-43-02 but omit primer.
- (35) Housing (97, 65-1642-33) -- Dow-17 anodize per SOPM 20-43-02 (or Dow-7 treat) and apply two coats of BMS 10-11 Type 1 primer per SOPM 20-41-02 (F-18.10) and two coats BMS 10-60 color white gloss enamel (SRF-14.9812) all over except in holes Dow-17 anodize per SOPM 20-43-02 (or Dow-7 treat) and apply one coat of BMS 10-11, Type 1 primer per SOPM 20-41-02 (F-18.09). Omit enamel from holes. Material: Magnesium alloy.
- (36) Housing (97, 65-1642-45) -- Dow 17 anodize (F-17.12) and apply BMS 10-11, Type 1 primer (F-20.03). Material: Magnesium alloy.
- (37) Bushing (98, 65C36793-1) -- Cadmium plate (F-15.02) but plating in the bore is optional. Material: Al-Ni-Br per AMS 4640.
- (38) Filler (100, 101) -- Boric acid-sulfuric acid anodize (F-17.31) and apply BMS 10-11, Type 1 primer (F-20.03). Material: Al alloy.

3. Replacement

- A. Replace unserviceable parts using standard industry practices and additional procedures in steps B thru G.
- B. If bushings (71, 74, 77, 80, 83, 86, 89, 92, 95, 98, 101, 104, 107, 144, Fig. 1101) require replacement, proceed as follows:
 - (1) Remove flared material from old bushing and press bushing from bore.
 - (2) Apply primer to OD of new bushing and install bushing in bore.
 - (3) Flare thin end of bushing such that bushing flange and flared material fit snug against faying surfaces.
 - (4) After flaring bushing (144) in lower gate assembly (142, 65-55478-502, Fig. 1101), apply a fillet seal of BMS 5-95 around flange as follows:

CAUTION: DO NOT ALLOW SURFACES TO BECOME CONTAMINATED WITH MOISTURE, FINGERPRINTS, OR ANY FOREIGN MATERIAL AFTER FINAL CLEANING. A DEFECTIVE SEAL WILL RESULT IF SURFACES ARE NOT CLEAN.

- (a) Thoroughly clean area to be sealed with cleaning solvent, BMS 11-7 immediately prior to applying sealant and wipe dry with a clean cheesecloth.

- (b) Mix components of sealant, BMS 5-95 just prior to application.

NOTE: Consult manufacturer's instructions for pot life of mixed sealant.

- (c) Apply fillet of sealant around flange at boundary of flange and gate, ensuring that there are no voids in fillet.

NOTE: If any sealant contacts flange face of bushing bore, wipe off before it cures.

- (d) Cure sealant according to manufacturer's instructions for the particular class of sealant used.

- (e) Apply one coat of BMS 10-60, white gloss enamel, on sealant and sealant edge after sealant has cured.

NOTE: If any paint contacts flange face or bushing bore, wipe off before it dries.

- C. Replace bushings (98) in handle box housing (97, 65-1642-45), if necessary, as follows:

- (1) Remove the flared material from the old bushing and press the bushing from the bore.
- (2) Install the new bushing with wet BMS 5-95 sealant as specified in SOPM 20-50-03.
- (3) Fillet seal the bushing flanges as specified in BAC5000.

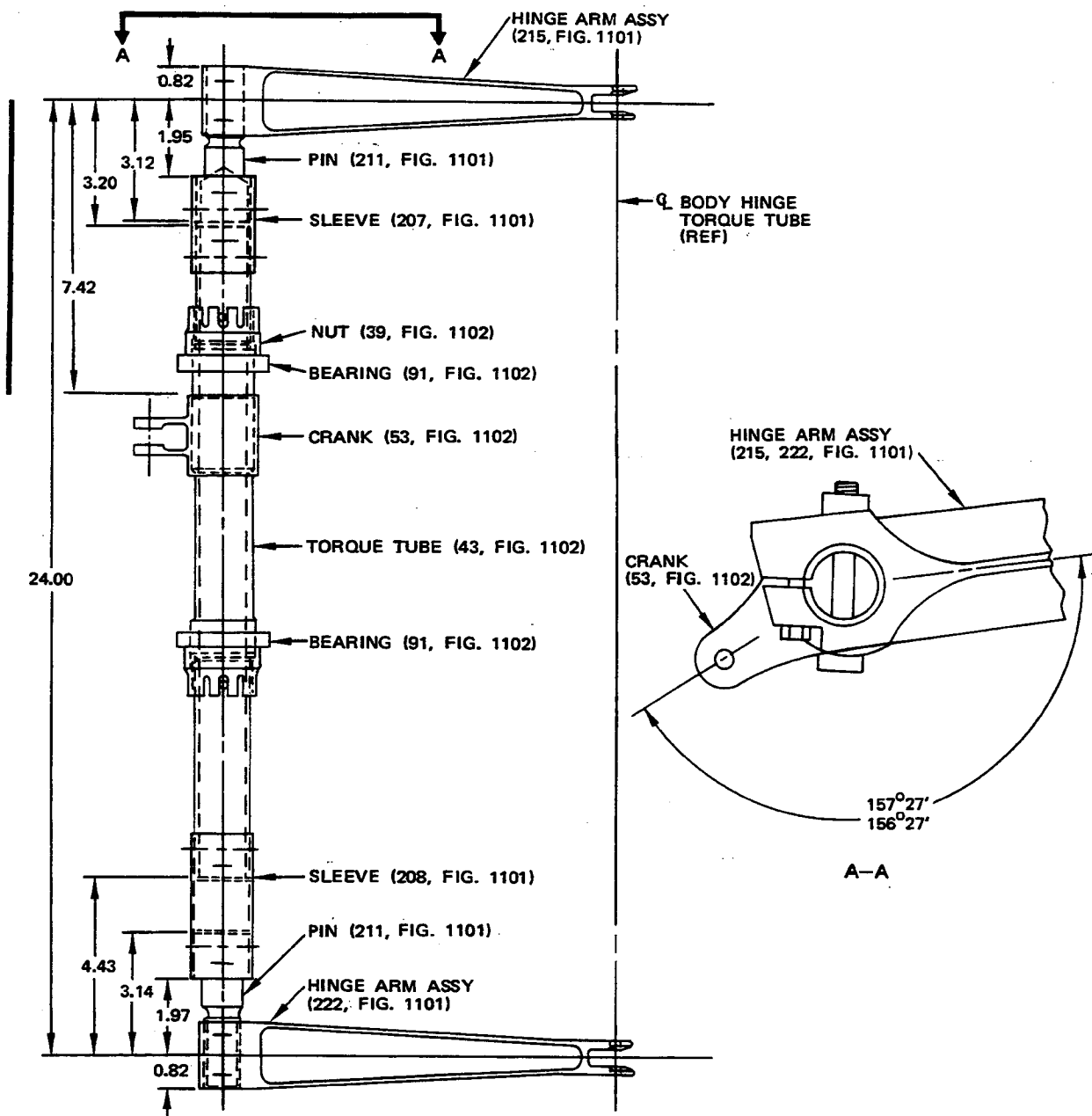
- D. Replace defective pins (211, Fig. 1101) as follows:

- (1) Temporarily assemble torque tube (43, Fig. 1102), crank (53), bolts (42), washers (41) and nuts (40).
- (2) Temporarily assemble sleeves (207, 208, Fig. 1101) to torque tube (43, Fig. 1102) with bolts (206, Fig. 1101), washers (205) and nuts (204).
- (3) Position pins (211) in sleeves (207, 208), observing dimensional requirements of Fig. 403.
- (4) Place upper and lower hinge arm assemblies (215, 222) and install bolts (209) and washers (210).
- (5) Rotate torque tube to establish angular relationship of hinge arm assemblies (215, 222) and crank (53, Fig. 1102) as given in Fig. 403.
- (6) Drill two 0.2495-0.2505-inch diameter holes in each pin (211) to match holes in sleeves (207, 208).
- (7) Disassemble all parts.

NOTE: Keep upper-end parts separated from lower end parts.

- E. Replace springs (212, Fig. 1101, 22, Fig. 1102) if requirements of Fig. 301 are not met.

- F. Replace defective torque tube (43, Fig. 1102) or crank (53) using standard industry practices. Maintain linear and angular dimensions given in Fig. 403.



NOTE: ALL LINEAR DIMENSIONS ARE IN INCHES
 TOLERANCES ARE ± 0.01

Hinge Arm and Crank Positioning
 Figure 403

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I G. If seal plate (32, Fig. 1102) requires replacement, proceed as follows:

- (1) Drill out rivets (31) and remove seal plate from door structure.
- (2) Remove old sealant from door structure with cleaning solvent, BMS 11-7, and wipe dry.
- (3) Thoroughly mix components of sealant, BMS 5-95, just prior to application.

NOTE: Consult manufacturer's instructions for pot life of mixed sealant.

CAUTION: DO NOT ALLOW SURFACES TO BECOME CONTAMINATED WITH MOISTURE, FINGERPRINTS, OR ANY FOREIGN MATERIAL AFTER FINAL CLEANING. A DEFECTIVE SEAL WILL RESULT IF SURFACES ARE NOT CLEAN.

- (4) Wipe faying surfaces with a clean cloth, moistened with BMS 11-7 cleaning solvent, immediately before applying sealant and wipe dry with a clean cheesecloth.
- (5) Apply 1/32-inch thick coating of sealant to the entire faying surface of seal plate (32).

CAUTION: DO NOT ALLOW SEALANT TO CURE BEFORE INSTALLING RIVETS (31). INSTALLING RIVETS IN CURED SEALANT WILL BREAK SEAL.

- (6) Position seal plate on door structure and immediately install rivets (31).
- (7) Check that there is a small bead of extruded sealant around entire periphery of faying surfaces. If any voids exist in extruded sealant, fill voids by injecting sealant into void areas.
- (8) Cure sealant according to manufacturer's instructions for the particular class of sealant being used.

I H. Some door assemblies are provided with protection against corrosion of the cold bonded door structure around the periphery of the doorframe and the door outer skin by factory-applied sealant or by incorporation of SB's 53-1017 and 53-1017, Revision 1. If sealant has been removed or damaged, proceed as follows:

- (1) Apply BMS 3-23 corrosion inhibiting compound to door (preferred).
 - (a) Remove residual sealant and clean surfaces to be protected.
 - (b) Apply BMS 3-23 to entire periphery of door frame and door outer skin per SOPM 20-41-05.

- (c) After BMS 3-23 solvents have evaporated, remove any visible film of BMS 3-23 by wiping with a 1:1 mixture of methyl ethyl ketone and toluene.

NOTE: BMS 3-23 film may be removed after solvents have evaporated without significant loss of protection.

- (2) If desired, reapply sealant around periphery of doorframe and door outer skin per 737 Structural Repair Manual, 53-30-4.

NOTE: Since sealant may trap moisture, BMS 3-23 application without additional sealing is considered best method of protecting structure from corrosion.

- I. Apply a suitable parting agent to exposed heel of hinge (151, 65-52873-525) and lower edge of upper door gate (139) along the full width of the door. Put the gate in the door-closed position. Fill the cavity with BMS 5-95 type B ½ sealant along the full width of the door gate (139).

4. Materials

- A. Compound, Corrosion Inhibiting -- BMS 3-23 (SOPM 20-60-02)

- B. Compound, Corrosion Preventive (SOPM 20-60-02)

(1) MIL-C-11796, class 1

(2) MIL-C-11796, class 3

- C. Enamel (SOPM 20-60-02)

(1) BMS 10-11, Type 2 (BAC707 gray)

(2) BMS 10-60 white gloss

- D. Lubricant, Solid Film -- BMS 3-8, class A (SOPM 20-60-03)

- E. Primer (SOPM 20-60-02)

(1) BMS 10-11, Type 1

(2) BMS 10-79, Type 79

- F. Sealant -- BMS 5-95 (supersedes BMS 5-79) (SOPM 20-60-04)

- I G. Solvent (SOPM 20-60-01)
 - (1) BMS 11-7
 - (2) Methyl ethyl ketone
 - (3) Toluene
- I H. Parting agent (SOPM 20-60-04)

ASSEMBLY

NOTE: When they were made, these doors were fillet and injection sealed with BMS 5-95 or other approved sealants. Special refinishing and primer will not be necessary if you use BMS 5-95 sealant for fillet and injection seals during maintenance activities.

Unless shown differently, tighten bolts, screws, and nuts to standard torque (SOPM 20-50-01).

1. For 65-52873-2 door assemblies, install bearings (90, 91, Fig. 1102) in housing (97) with wet BMS 10-11, Type 1 primer applied to all areas of bearing cavity in housing. On all other door assemblies and on assemblies modified per SB 52-1094, install bearing (90) in housing (97) and install bearing (91) with BMS 5-95 sealant and fillet seal with sealant.
- 1A. For handle box housing assemblies (92, 65-1642-43), install bushings (98) into handle box housing (97, 65-1642-45) with wet BMS 5-95 sealant (SOPM 20-50-03) and fillet seal the bushing flanges (SOPM 20-50-19).
2. Install bearings (86, 87) with wet BMS 5-95 sealant, apply corrosion preventive compound, MIL-C-11796, class 3 to faying surface common to bearing retainers (85) and housing (97), install bolts (83, 84) with wet BMS 5-95 sealant, and install washers (82) and nuts (81).
3. Apply corrosion preventive compound, MIL-C-11796, class 3, to bearing (72) and preassemble crank assemblies (68 and 74) by installing items (69 thru 72 and 75 thru 79) on crank arms (73, 80). Install the washers as follows:
 - A. For crank assemblies (68, 74, 69-38733-1), install the washers (71, 78) (71A, 77, AN960PD616) as follows:
 - (1) If bearing (72, 79, BACB10BH60F9) is used: Install four washers (71, 78) adjacent to the head of the bearing (72, 79, BACB10BH60F9) and one washer (71A, 77, AN960PD616) adjacent to the nut (70, 76, BACN10JD6).
 - (2) If bearing (72, 79, BACB10BH60F8) is used: Install two washers (71, 78) adjacent to the head of the bearing (72, 79, BACB10BH60F8) and one washer (71A, 77, AN960PD616) adjacent to the nut (70, 76, BACN10JD106).
 - B. For crank assemblies (68, 74, 90-7815-1), install the washers (71B, 71C, 77A, 78A, AN960-616L) as follows:
 - (1) Apply BMS 10-11, Type 1 primer to the washers (71B, 71C, 77A, 78A, AN960-616L) and install one washer ((71B, 78A, AN960-616L) adjacent to the head of the bearing (72, 79, BACB10BH60CF6, BACB10AF6F3H, BACB10FK6F6H) and a maximum of five washers (71C, 77A, AN960-616L) adjacent to the nut (70, 76, BACN10JD106) to get the correct nut torque and install the cotter pin. Tighten the nut (70, 76, BACN10JD106) to 95-170 pound-inches (threads not lubricated) or 45-85 pound-inches (lubricated threads).

C. For crank assemblies (74, 90-7815-15, -17), install the washers (77A, 78A, AN960XC616L) as follows:

- (1) Install one washer (78A, AN960XC616L) adjacent to the head of the bearing (79, BACB10FK6F6HS) and a maximum of five washers (77A, AN960XC616L) adjacent to the nut (70, 76, BACN10JD106) to get the correct nut torque and install the cotter pin. Tighten the nut (70, 76, BACN10JD106) to 95-170 pound-inches (threads not lubricated) or 45-85 pound-inches (lubricated threads).

D. For crank assemblies (74, 90-7815-23, -25), install the washers (77A, 78A, NAS1149C0632B) as follows:

- (1) Install one washer (78A, NAS1149C0632B) adjacent to the head of the bearing (79, KRP141500VT6-6) and a maximum of five washers (77A, NAS1149C0632B) adjacent to the nut for cotter pin installation.

E. For crank assemblies (68, 90-7815-32), install the washer (71A, NAS1149C0632B) adjacent to the nut.

4. Apply BMS 10-11, Type 1, primer on washers (55, 56) and on the ID of bearings (86, 87). Apply corrosion preventive compound MIL-C-16173, Class 3, to bolts (57, 58). Apply corrosion preventive compound MIL-C-16173, Grade 2, or BMS 3-24 grease to the splines of crank assemblies (59, 64, 68, 74).
5. Prealign crank assemblies (59, 64) and spacer (63) in housing (97) and insert crank assemblies (68, 74) while primer is wet. Install bolts (57, 58), washers (56, 55), and nuts (54).
6. Apply BMS 10-11, Type 1 primer on washer (45), the inside surface of rod end bearing (51) and crank (62) and corrosion-preventive compound, MIL-C-11796, class 3 on the shank of bolt (47). Insert rod assembly (48) in housing (97) and attach to crank (62) with washer (45) and bolt (47).
7. Apply a thin layer of BMS 3-33 or MIL-G-23827 grease to the inside faces of the lugs of crank (53) and attach crank (53) to rod assembly (48) with bolt (46), washer (45), and nut (44). Install bolt (46) with corrosion-preventive compound, MIL-C-11796, class 3, applied to shank.
8. On assemblies modified per SB 52-1094, brush or swab bearings (91) ID with BMS 10-11, Type 1, primer. Slide hinge torque tube (43) thru housing (97) and crank (53) and secure with bolts (42), washers (41), and nuts (40). Apply BMS 10-11, Type 1, primer on washers (41), corrosion preventive compound, MIL-C-11796, class 3, on the shank of bolt (42), and corrosion preventive compound, MIL-C-16173, Grade 2, on the mating surfaces of torque tube (43) and crank (53) prior to installation. On assemblies modified per SB 52-1094, tighten nuts (40) to 58-63 lb-in.

NOTE: On assemblies modified per SB 52-1094, nuts (40) are intended to bottom out on bolt threads in order to avoid clamp up. A gap between crank (53) and washers (41) of up to 0.016 inch is acceptable. If greater gaps occur, install additional washers (41) as required.

9. Apply light coat of corrosion preventive compound, MIL-C-16173, Grade 2, to threads of nuts (39) and install nuts (39) on hinge torque tube (43) finger-tight. Attach a tag to nuts (39) stating that nuts are to be tightened when door is adjusted on airplane.

10. Preassemble items (11 thru 24) as follows:

- A. Insert pin (23) and spring (22) in shaft (24). Apply a thin coat of corrosion preventive compound, MIL-C-16173, Grade 2, on both internal and external mating threads of nut (21) and screw nut in shaft (24) using wrench, F70038 and secure with lockring (20).
 - B. Position washer (19, P/N 30-3019) on suitable 10-32 bolt and screw bolt in pin (23, P/N 30-3013-1). Using 10-32 bolt, pull spring-loaded pin (23) until slot in washer (19) is aligned with hole in pin. Install spring pin (18) and remove 10-32 bolt. Screw washer (19, P/N 30-3019-1) on pin (23, P/N 30-3013-2) until holes in washer and pin are aligned and insert spring pin (18).
 - C. Apply corrosion preventive compound, MIL-C-11796, class 3 to shaft (24) and insert shaft (24) in sleeve (17) and sleeve in cam (16).
 - D. Install spacer (15) between sleeve (17) and external handle (14) and secure all parts with bolts (13), washers (12), and nuts (11).
11. Install attach fitting (249, Fig. 1101) in hinge support (251) using washers (243, 245) and bolts (242, 244). Tighten bolts (242, 244) finger-tight and attach tag stating that bolts are to be tightened when door is installed on airplane.
12. Install attach fitting (238) in hinge support (240) using washers (232, 234) and bolts (231, 233). Tighten bolts (231, 233) finger-tight and attach tag stating that bolts are to be tightened when door is installed on airplane.
13. Install upper and lower hinge support assemblies (230, 241) in door structure using seal washers (229), bolts (227, 228), washers (226), and nuts (225).
14. Slide springs (212), washers (213), and packings (214) on hinge link pins (211). Lubricate packings (214) with light film of grease, MIL-G-4343 prior to installation.
15. Apply a light coat of corrosion preventive compound, MIL-C-16173, Grade 2, on the mating surfaces of hinge link pins (211), arms (217, 224) and bushings (239, 250). Position hinge arm assemblies (215, 222) in hinge support assemblies (230, 241). Insert hinge link pins (211) in hinge support assemblies and hinge arm assemblies. Install bolts (209) and washers (210).
16. Prepare for installation of handle mechanism in door structure as follows:
- A. Slide sleeves (207, 208, Fig. 1101) on torque tube (43, Fig. 1102).
 - B. Insert packing (34, Fig. 1102) in housing (37) and packing (33) inside seal plate (32). Lubricate packings (33, 34) with light coat of grease, MIL-G-4343 prior to installation.
17. Install housing assembly (35) and handle mechanism housing assembly (92) as follows:
- A. Trial-install housing assembly (35) and handle mechanism housing assembly (92) with attached parts in door structure using shims (8), fillers (6, 7), washers (5), and bolts (1 thru 4). Determine the number and thickness of shims necessary to fill gap between housing assembly (92) and door structure with housing assembly (35) symmetrically located in cutout in skin.

- B. Remove handle mechanism and housing assembly from door.

CAUTION: DO NOT ALLOW SURFACES TO BECOME CONTAMINATED WITH MOISTURE, FINGERPRINTS, OR ANY FOREIGN MATERIAL AFTER FINAL CLEANING.

- C. Thoroughly clean faying surfaces of handle mechanism housing and shims (8), or fillers (7) if shims are not used, with cleaning solvent, BMS 11-7, and wipe dry with clean cheesecloth.

- D. Mix the two components of sealant, BMS 5-95, just prior to application.

NOTE: Consult manufacturer's instructions for pot life of mixed sealant.

- E. Apply a 1/32-inch thick coating of sealant to the surfaces of handle mechanism housing (97) which mate with shims (8), or fillers (7) if shims are not used.

CAUTION: DO NOT ALLOW SEALANT TO CURE BEFORE INSTALLING BOLTS. SEAL WILL BE BROKEN WHEN BOLTS ARE INSTALLED.

- F. Apply BMS 10-11, Type 1 primer to the exterior surface of housing assembly (35). Position housing assembly (35) and handle mechanism housing assembly (92) with attached parts in door structure and secure, using shims (8), fillers (6, 7), washers (5), and bolts (1 thru 4) before sealant cures.

NOTE: Align housing assembly (35) so that fitting (36) is on forward or aft side.

- G. Check that a small bead of sealant extrudes around the entire periphery of faying surfaces. If any voids exist in bead, fill with sealant, using injection method of application.

- H. Cure sealant according to manufacturer's instructions.

18. Install washers (30), seal washers (29), and bolts (28) securing housing assembly (35). Apply a fillet seal of BMS 5-95 sealant around bolt (28) heads to protect against corrosion.

19. Slide preassembled parts (11 thru 24) into bore of handle mechanism housing. Apply corrosion-preventive compound, MIL-C-11796, class 3 to ring (89), camplate (27), and nut (9) and install ring (89), washer (88), and camplate assembly (25) on shaft (24) so that bearing units (72, 79) are centered on 0.75-inch diameter holes of camplate (27) in door-closed position. Secure camplate (27) with washers (10, 10A), nuts (9, 9A), and cotter pin (8A) as applicable. Tighten nuts (9) used on shaft (24, 60-4455) to 95-110 pound-inches.

NOTE: External handle (14) must engage when pulled straight out of door recess in door-closed and latched position.

20. Apply a light coat of corrosion-preventive compound, MIL-C-16173, Grade 2, on both internal and external mating surfaces of sleeves (207, 208, Fig. 1101) and slide sleeves (207, 208) partly on hinge link pins (211). Secure with bolts (206), washers (205), and nuts (204). Tighten nuts (204) to 30-40 pound-inches.

NOTE: Nuts (204) are intended to bottom out on bolt threads in order to avoid clamp up. A gap between sleeves (207, 208) and washers (205) of up to 0.016 inch is acceptable. If greater gap occurs, install additional washers (205) as required. Direction of bolts (206) is significant to avoid threads in bearing. No substitution of the bolt (206) grip length is permitted.

21. Apply a thin layer of BMS 3-33 or MIL-G-23827 grease to mating surfaces, then install bearings (203) in support fittings (189, 192, 195) and housings (202).
22. Install housing assemblies (200) in door structure using bolts (199), washers (197, 198), and nuts (196).
23. Install shims (185, 186) removing 0.003-inch laminations as required to eliminate gap. After delamination, install shims (185, 186) with BMS 10-11, Type 1 primer either wet or dry. Install support fitting assemblies (187, 190, 193) with bolts (184), washers (183), and nuts (182).
24. Place rod assemblies (127, 132) inside door structure and locate fixed end near crank (67, Fig. 1102) to be connected later.
25. For door assemblies 65-52873-167, -168, -189, -567 and door assemblies 65-52873-159, -176, -180, -182, -2 that have been modified per SB 52-1094, coat mating surfaces of torque tubes (180, 181) and cranks (177 thru 179) with BMS 10-11, Type 1, primer. Slide torque tubes (180, 181) in door structure and cranks (177 thru 179). Secure cranks with bolts (176), washers (175), and nuts (174). On assemblies modified per SB 52-1094, install fasteners (174, 175, 176) with corrosion preventive compound and tighten nuts (174) to 35-45 lb-in.

NOTE: For door assemblies 65-52873-167, -168, -189, -567 and door assemblies 65-52873-159, -176, -180, -182, -2 that have been modified per SB 52-1094, nuts (174) are intended to bottom out on bolt threads in order to avoid clamp up. A gap between cranks (177 thru 179) and washers (175) of up to 0.016 inch is acceptable. If greater gaps occur, install additional washers (175) as required.

26. Install washers (172) on shaft of each bearing unit (173) and insert bearing units in cranks (168). Add one washer (172) to each bearing unit shaft and install nuts (171) securing with cotter pins (170).
27. Install cranks (168) in torque tubes (180, 181). Use spacers (169) if and as required. Secure cranks with bolts (167), washers (166), and nuts (165). For door assemblies 65-52873-167, -168, -189, -567 and door assemblies 65-52873-159, -176, -180, -182, -2 that has been modified per SB 52-1094, install cranks (168) with wet primer, BMS 10-11, Type 1, install fasteners (165, 166, 167) with corrosion preventive compound and tighten nuts (165) to 35-45 lb-in.

NOTE: For door assemblies 65-52873-167, -168, -189, -567 and door assemblies 65-52873-159, -176, -180, -182, -2 that have been modified per SB 52-1094, nuts (165) are intended to bottom out on bolt threads, in order to avoid clamp up. A gap between torque tubes (180, 181) and washers (166) of up to 0.016 inch is acceptable. If greater gaps occur, install additional washers (166) as required.

28. Join hinge halves (155, 156, 161, 162) with hinge pins (152, 158). Secure hinge pins with spring pins (150). Apply corrosion-preventive compound, MIL-C-11796, class 3 to spring pins (150) prior to installation.
29. Install fillers (146, 147) and upper and lower gate assemblies (139, 142) with washers (137B, 138B), and bolts (137, 137A, 138, 138A) as applicable. Make sure the gap width (noted during disassembly) did not change.
30. Connect handle mechanism to latching rods with rod assemblies (127, 132) using bolts (112, 114), washers (110, 115), and nuts (109). Apply corrosion-preventive compound, MIL-C-11796, Class 3 to washers (115) and bolts (114).

31. Connect fixed end of rod assemblies (117, 122) to latching rods with bolts (112), washers (110), and nuts (109). Insert bushings (116) in upper and lower gates with BMS 10-11, Type 1 primer.
32. Apply BMS 3-33 or MIL-G-23827 grease to mating surfaces, then connect adjustable end of rod assemblies (117, 122) to upper and lower gates with bolts (113), washers (111), and nuts (109). Install bolts (113) with corrosion-preventive compound, MIL-C-11796, Class 3 applied to shanks.
33. Use the B52004-1 door seal installation tool (SE52-1002 optional) to insert the seal (64, Fig. 1101) in the door seal retainers. Use soapy water to facilitate seal installation if necessary. Secure diaphragm with nylon rods (61 thru 63). Install rod at both ends forming butt fit of radius end at centerline of door.
34. Assemble seal (56), outer pane (55), inner pane (54), retainer (53), and seal (52). Bond seal (52) to retainer (53) with Type 12 adhesive (SOPM 20-50-12). Use shims (50, 51) to provide a maximum compression of 0.03 inch of seal (52). Install shims (50, 51) with two layers of BMS 10-11, Type 1 primer. If shim delamination is necessary, apply one layer of BMS 10-11, Type 1 primer to delaminated surface. Attach assembled parts with clips (49), screws (48), one washer (47) under head of each screw, and one washer (47) under each nut (46). Install washers (47) and screws (48) with MIL-C-11796, Class 3 corrosion preventive compound.

CAUTION: BECAUSE THE WINDOW IS CURVED, IT MUST BE INSTALLED WITH THE MARKINGS ON PANES SYMMETRICAL WITH THE CENTERLINE OF THE UPPER MOUNTING CLIP.

35. Install window assembly (45) in the door with washers (44) and bolts (43).
36. Install reinforcing angles (38, 39) with bolts (33, 34 thru 36), washers (32, 37), nuts (31), and applicable nuts (41).
37. Install coverplates (27) with bolts (25, NAS603-9P, 26, BACB30NE3-9) or use bolts (25, NAS6603-3 and 26, NAS6603-3) with washers (26A).
38. Install bracket assembly (17) with bolts (16).
39. Install cover plates (11, 12) and secure with bolts (10).
40. Install retainer (7, 7A) and split retaining rings (4, 4A) with washers (3, 4B) and studs (2, 2A).
41. Lubricate fittings (188, 191, 194, and 201, Fig. 1101, and 36, Fig. 1102) and bearing units (173, Fig. 1101, 72, 79, Fig. 1102) with BMS 3-33 or MIL-G-23827 grease.
42. Apply the weather seal to the interior of the lower hinge cavity and the lower gate (142) as follows:
 - A. Put the door in the position that it will be in when it is installed on the airplane.
 - B. With a Series 92 solvent, clean all surfaces that will get the potting compound or the leveling compound.

CAUTION: DO NOT LET THE DRAIN HOLES BECOME BLOCKED.

- C. Pour BMS 5-28 potting compound or BMS 5-125 leveling compound into the lower hinge cavity and the lower gate.
 - D. Let the compound find its own level until it comes to the height shown in Fig. 501. The compound must fill the full width of the door.
- 43. Inject BMS 5-95 sealant into the gap between seal retainers (154, 160, 163, 164) and structure.
 - 44. Apply Dow Corning 30-121 sealant at corners of the diaphragm and mechanical seal (eight locations). Cover ends of seal retainers (154, 160, 163, 164) and nylon rods (61 thru 63) generously.
 - 45. Inject Dow Corning 30-121 sealant between the diaphragm seal and seal retainers (163, 164) approximately 1.50 inches long, centered on door centerline. Push the seal into the gap as far as possible.
 - 46. Inject BMS 5-95 pressure sealant into gap between seal retainers around perimeter of door.
 - 47. Install Installation Items (Fig. 1101).

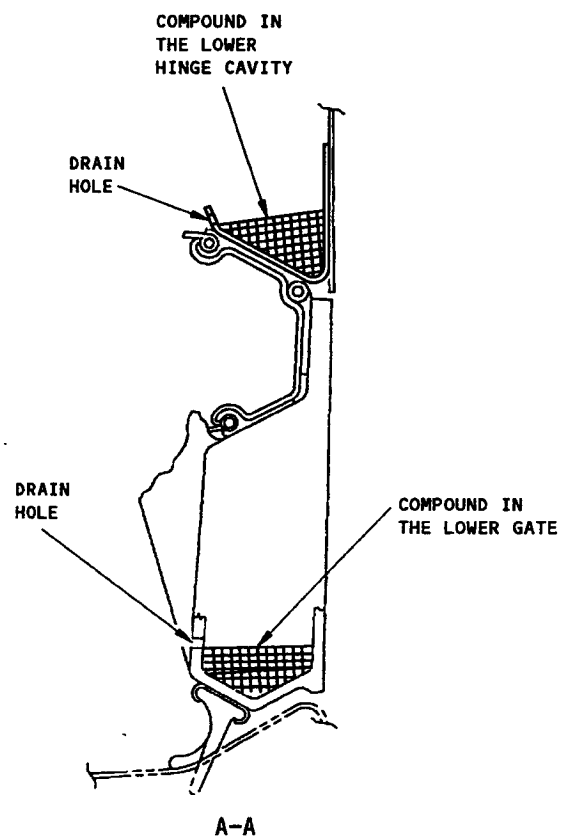
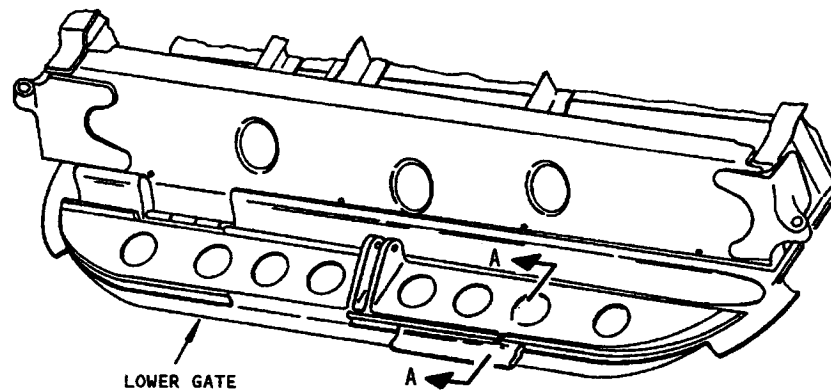
NOTE: Items installed in this paragraph are part of the door installation and could be attached to the door when it came in for overhaul.

- A. Install plugs (275) in upper and lower hinge support assemblies (230, 241) and seal with Type 40 adhesive (SOPM 20-50-12).
- B. Install door stop pins (255) and retainer springs (254) with a thin layer of MIL-C-16173, grade 2 corrosion preventive compound.

- C. Install centering guide (274) in roller fitting (270) with spacer (273), washer (272), and nut (271).
- D. Install roller fitting (270) on the door structure with washers (269) and bolts (267, 268).
- E. Apply BMS 10-11, Type 1 primer to the countersunk areas of bolt holes in hinge covers (258, 263) and let the primer cure.
- F. Temporarily install hinge cover (258) and shims (259, 260) with bolts (256, 257). Make a check of the contour of the hinge cover with the door outer skin. Remove hinge cover (258) and delaminate shims (259, 260) as necessary to align the hinge cover with the door outer skin contour within 0.01 inch. Apply BMS 10-11, Type 1 primer to the delaminated surface of the shims and install them wet or dry with bolts (256, 257).
- G. Temporarily install hinge cover (263), shims (264, 265), and block (266) with bolts (261, 262). Make a check of the contour of the hinge cover with the door outer skin. Remove hinge cover (263) and delaminate shims (264, 265) as necessary to align the hinge cover with the door outer skin contour within 0.01 inch. Apply BMS 10-11, Type 1 primer to delaminated surface of the shims and install them wet or dry with bolts (261, 262).

48. Materials

- A. Adhesive -- Type 40 (SOPM 20-50-12)
- B. Corrosion -- Preventive Compound (SOPM 20-60-02)
 - (1) MIL-C-16173, Grade 2
 - (2) MIL-C-11796, Class 3
- C. Grease (SOPM 20-60-03)
 - (1) BMS 3-33
 - (2) MIL-G-23827
 - (3) MIL-G-4343
- D. Leveling Compound -- BMS 5-125, Type 2, or Type 3 (Replaces Type 1) (SOPM 20-60-04)
- E. Potting Compound -- BMS 5-28, Type 1 (SOPM 20-60-04)
- F. Primer -- BMS 10-11, Type 1 (SOPM 20-60-02)
- G. Sealant (SOPM 20-60-04)
 - (1) BMS 5-95
 - (2) Dow Corning 30-121
- H. Solvent -- BMS 11-7 (SOPM 20-60-01)
- I. Solvent -- Series 92 (SOPM 20-30-92)



Assembly Details
Figure 501

FITS AND CLEARANCES

FOR TORQUE VALUES OF STANDARD FASTENERS, REFER TO 20-50-01			
ITEM NO.	NAME	TORQUE	
		POUND-INCHES	POUND-FEET
IPL FIG. 1101, 165 *[1] 174 *[1] 204 *[1]	NUT	35-45	
	NUT	35-45	
	NUT	30-40	
IPL FIG. 1102, 9 40 *[1] 70, 76 BACN10JD106	NUT	95-110	
	NUT	58-63	
	NUT	95-170 (threads not lubricated) 45-85 (lubricated threads)	

*[1] TORQUE SPECIFICATION APPLICABLE TO DOOR ASSEMBLIES 65-52873-167, -168, -189, -567 AND DOOR ASSEMBLIES 65-52873-259, -176, -180, -182, -2 THAT HAVE BEEN MODIFIED PER SB 52-1094.

Torque Table
Figure 601

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TESTING

1. No specific test is required although the door mechanism should operate freely without binding.

BOEING
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TROUBLE SHOOTING

1. Trouble during test after overhaul.

<u>Trouble</u>	<u>Possible Cause</u>	<u>Correction</u>
A. Binding upper or lower gate control rod assembly (117 or 122, figure 1101)	Rod (121 or 126, figure 1101) bent, or rod end bearing (118 or 123) defective	Check and replace defective parts
B. Binding rod assembly (127 or 132, figure 1101)	Rod (131 or 136, figure 1101) bent, or rod end bearings (128 or 133) defective	Check and replace defective parts
C. Loose exterior handle (14, figure 1102)	Defective spring (22, figure 1102)	Replace spring
D. Binding handle mechanism (figure 1101)	Bearing (72, 79, 86, 87, 90, or 91, figure 1102) defective, rod (52) bent, or rod end bearing (51) defective	Check and replace defective part
	Foreign matter	Examine and clean
	Improper installation	Examine and reassemble

BOEING
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STORAGE INSTRUCTIONS

1. Place protective cover over surfaces of door skin and window panes.
2. Wrap entire assembly in vapor barrier paper. Tag with overhaul date and cure date of rubber or rubber-like parts and store.
3. Provide a suitable surrounding structure to prevent handling damage.
4. For general storage information, refer to "Protection, Storage, and Handling of Airplane Components," Subject 20-70-01.



SPECIAL TOOLS, FIXTURES, AND EQUIPMENT

NOTE: Equivalent substitutes can be used.

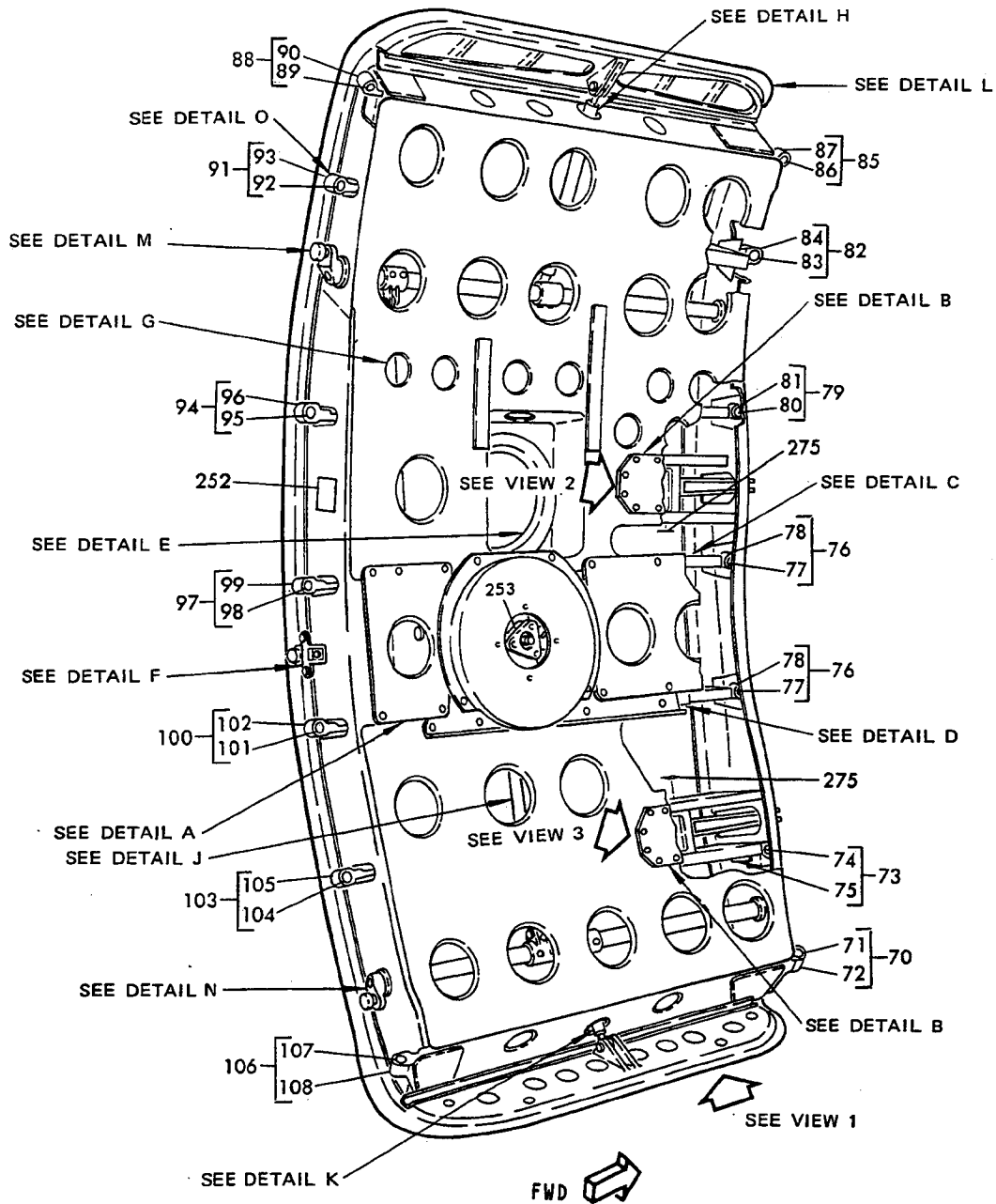
1. F70038 -- Door Handle Mechanism Wrench Assembly
2. F70085 -- Bearing Retainer Nut Spanner Wrench
3. B52004-1 -- Door Seal Installation Tool (SE52-1002 optional)

BOEING
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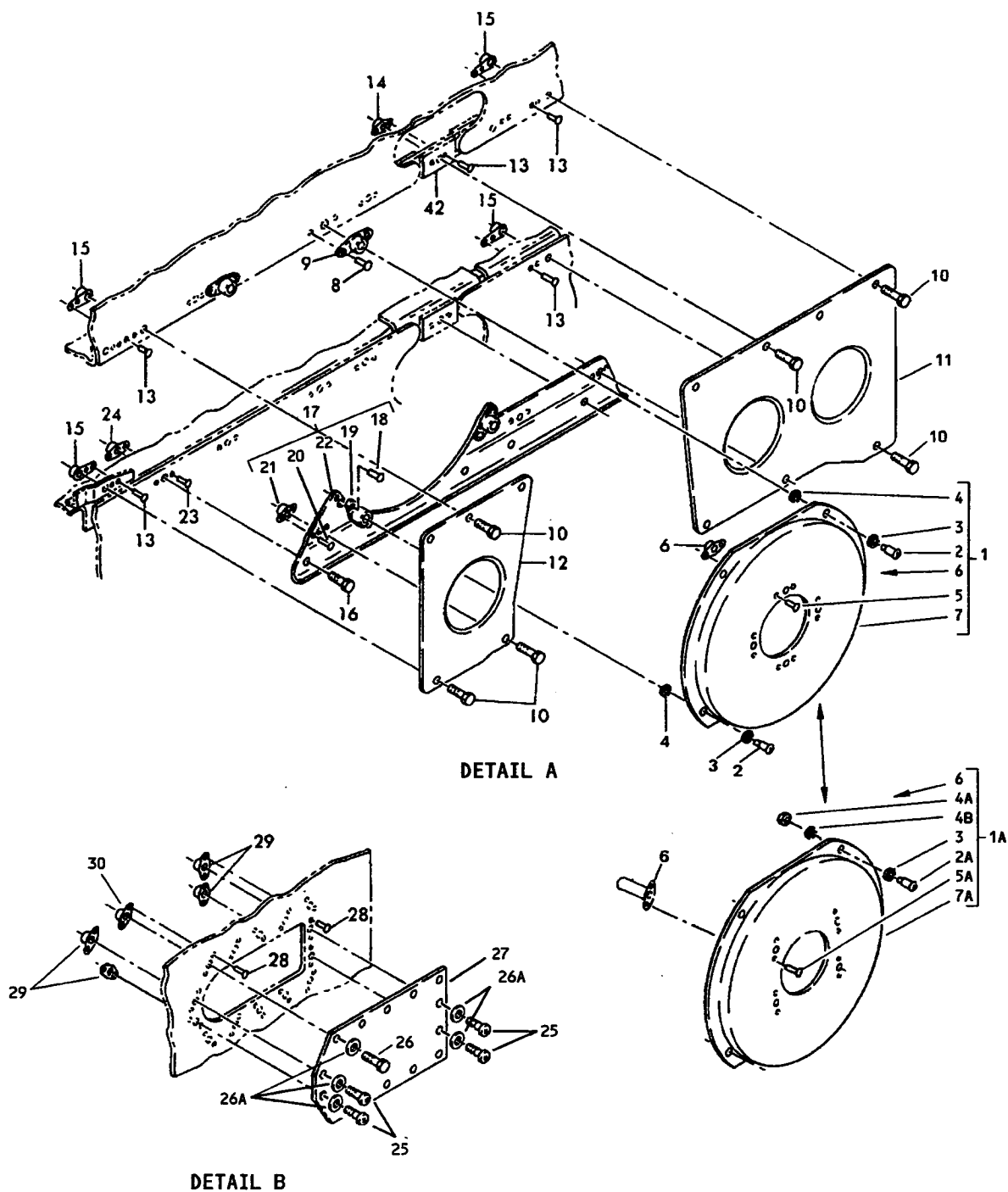
ILLUSTRATED PARTS LIST

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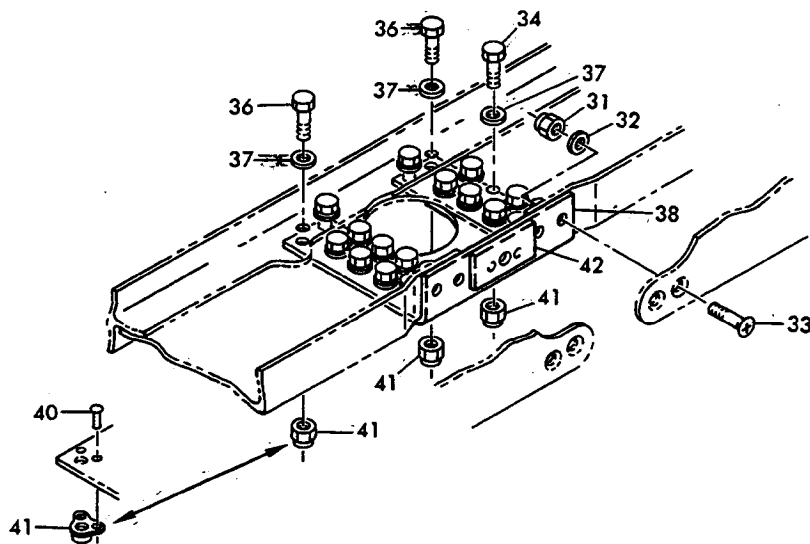
1. Exploded View



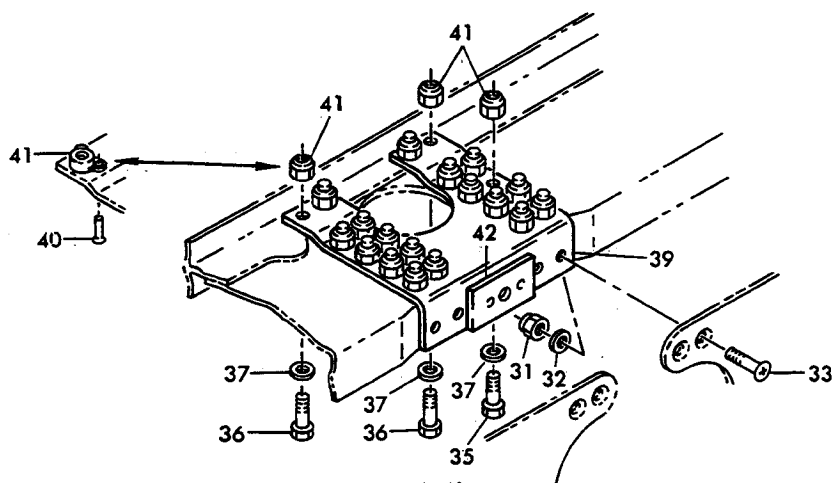
Aft Entry Door Assembly
Figure 1101 (Sheet 1)



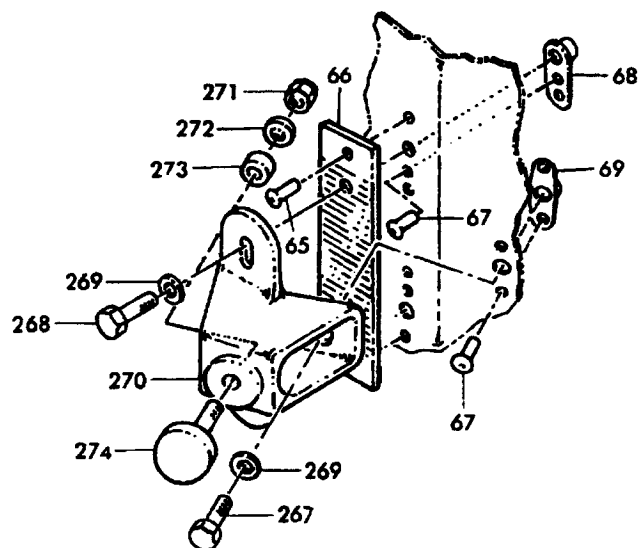
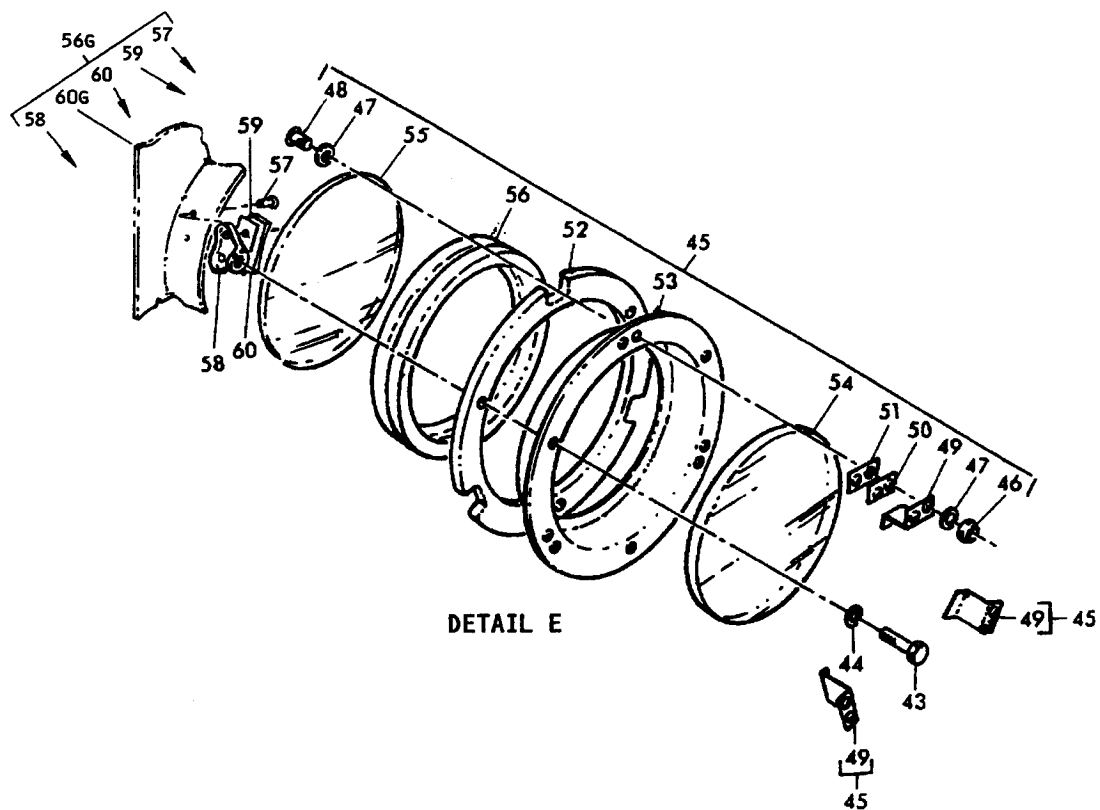
Aft Entry Door Assembly
 Figure 1101 (Sheet 2)



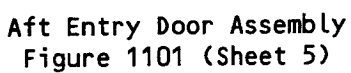
DETAIL C



DETAIL D

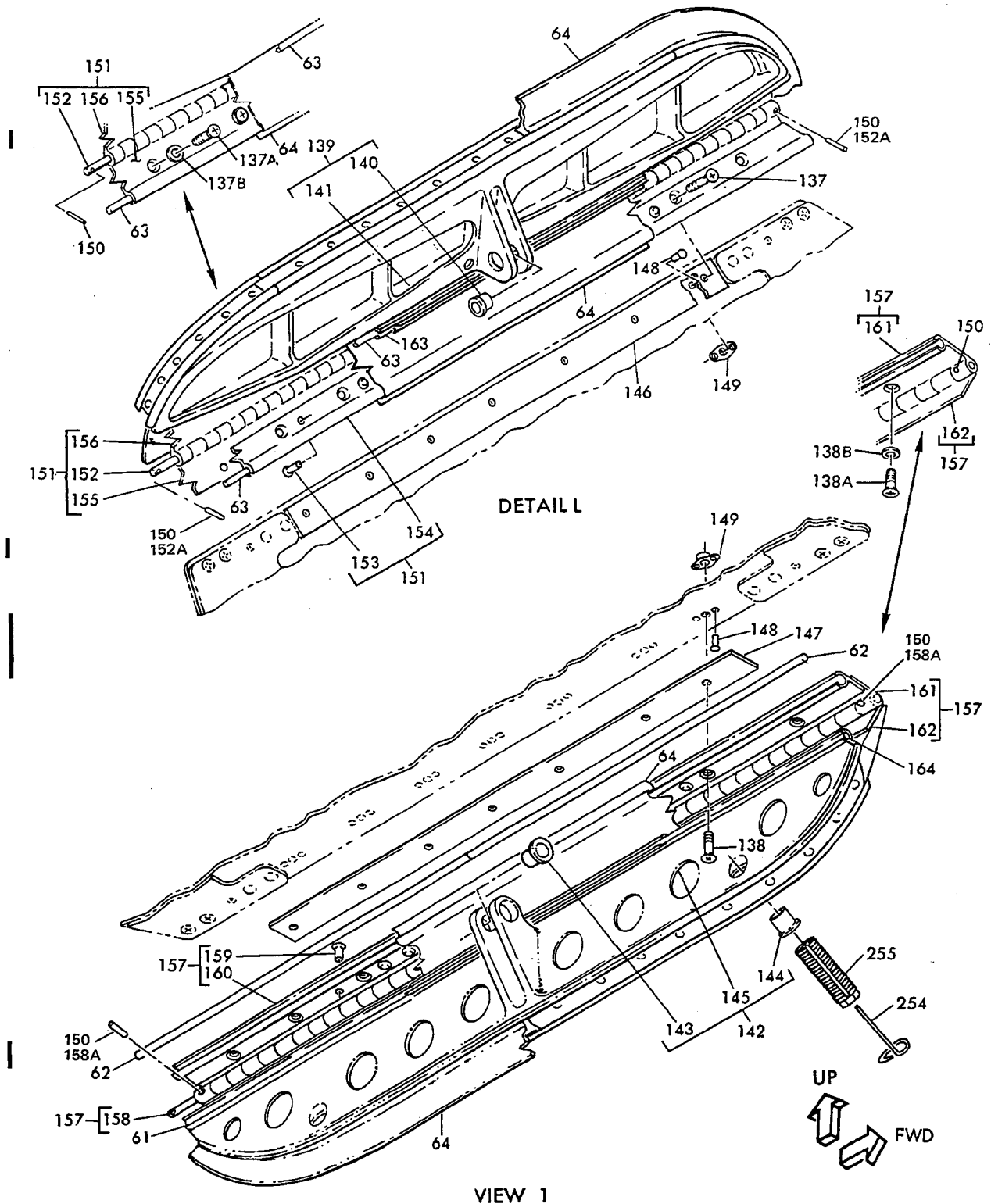


Aft Entry Door Assembly
 Figure 1101 (Sheet 4)



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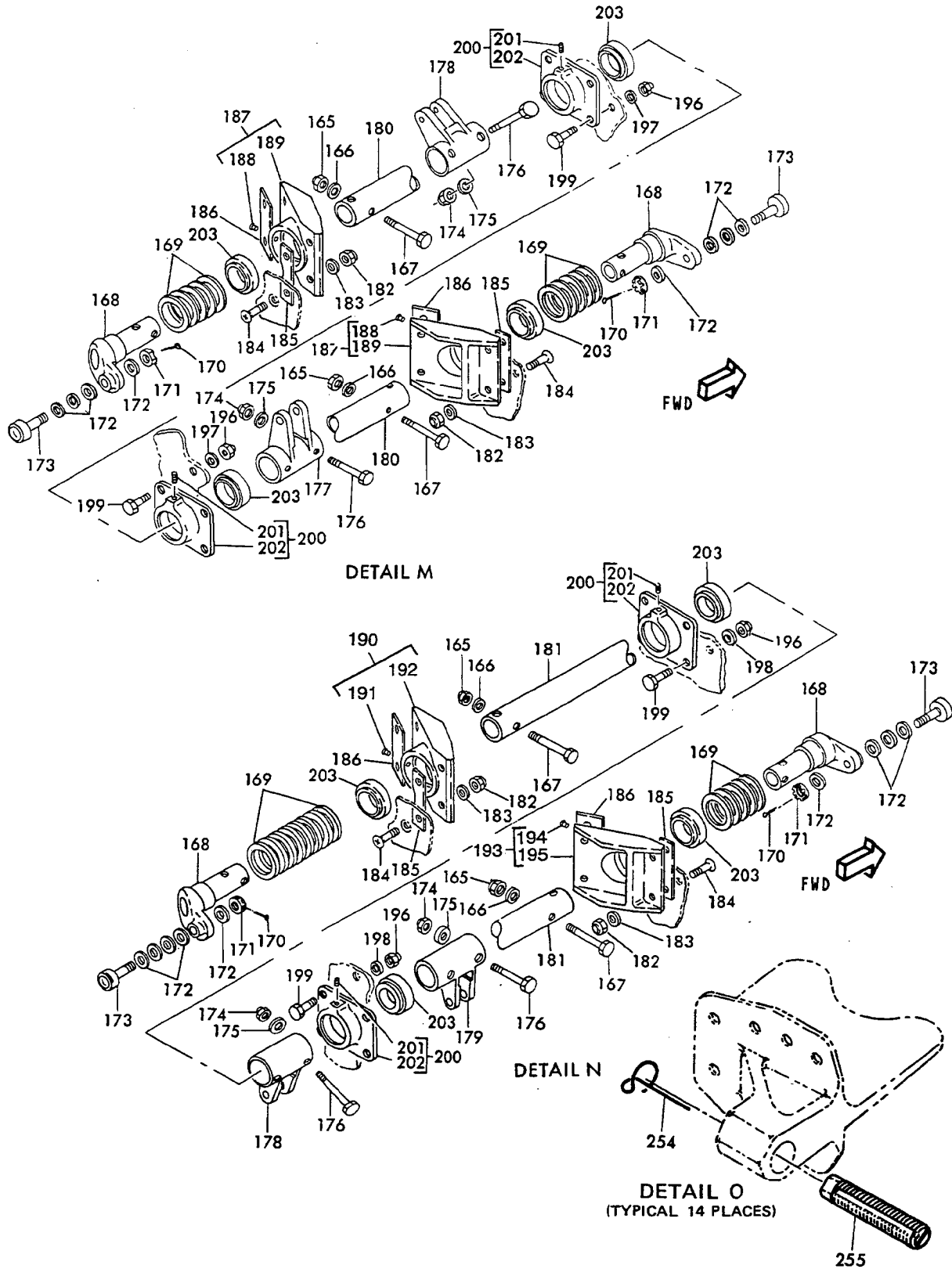
65-52873



Aft Entry Door Assembly
 Figure 1101 (Sheet 6)

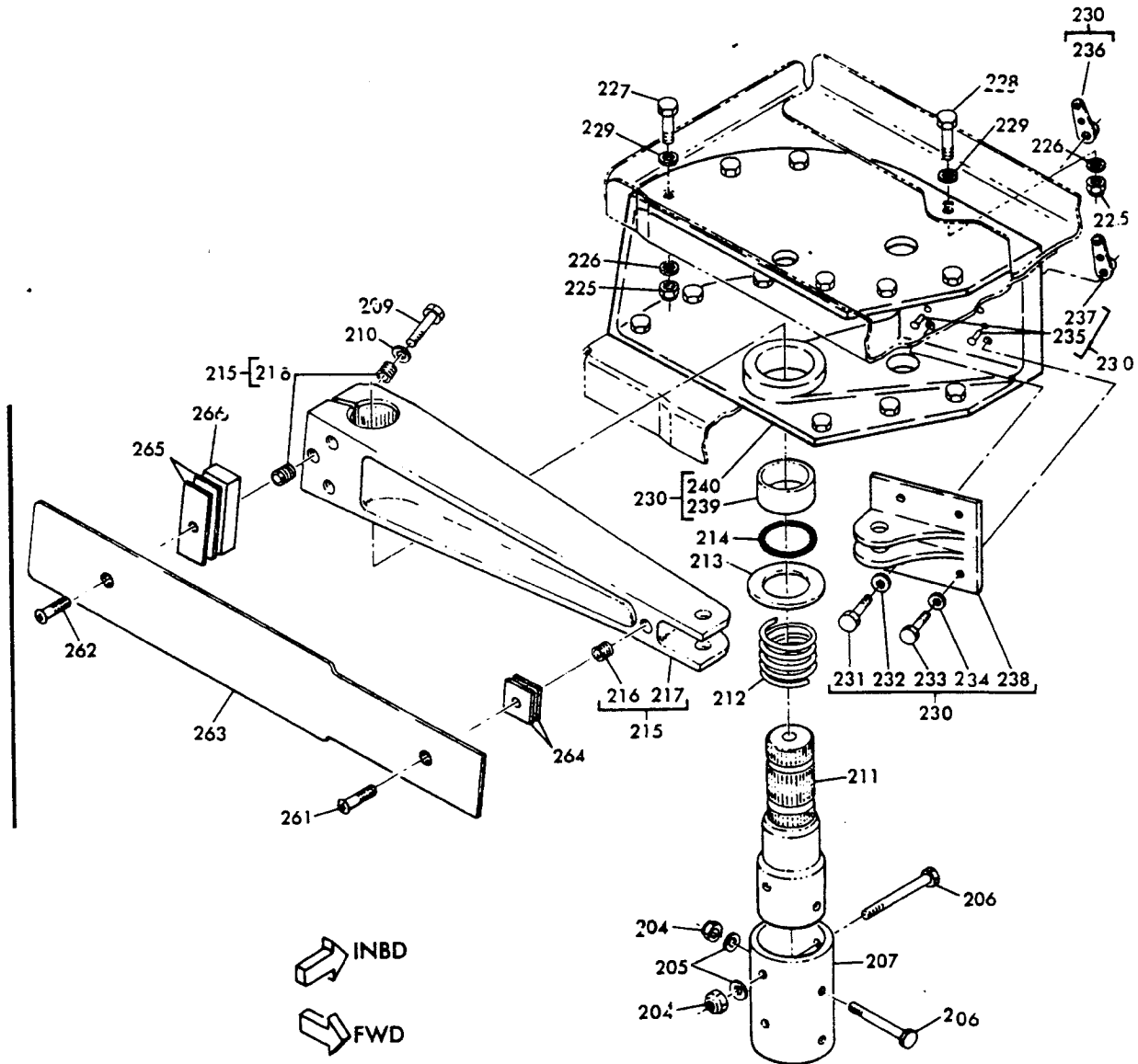
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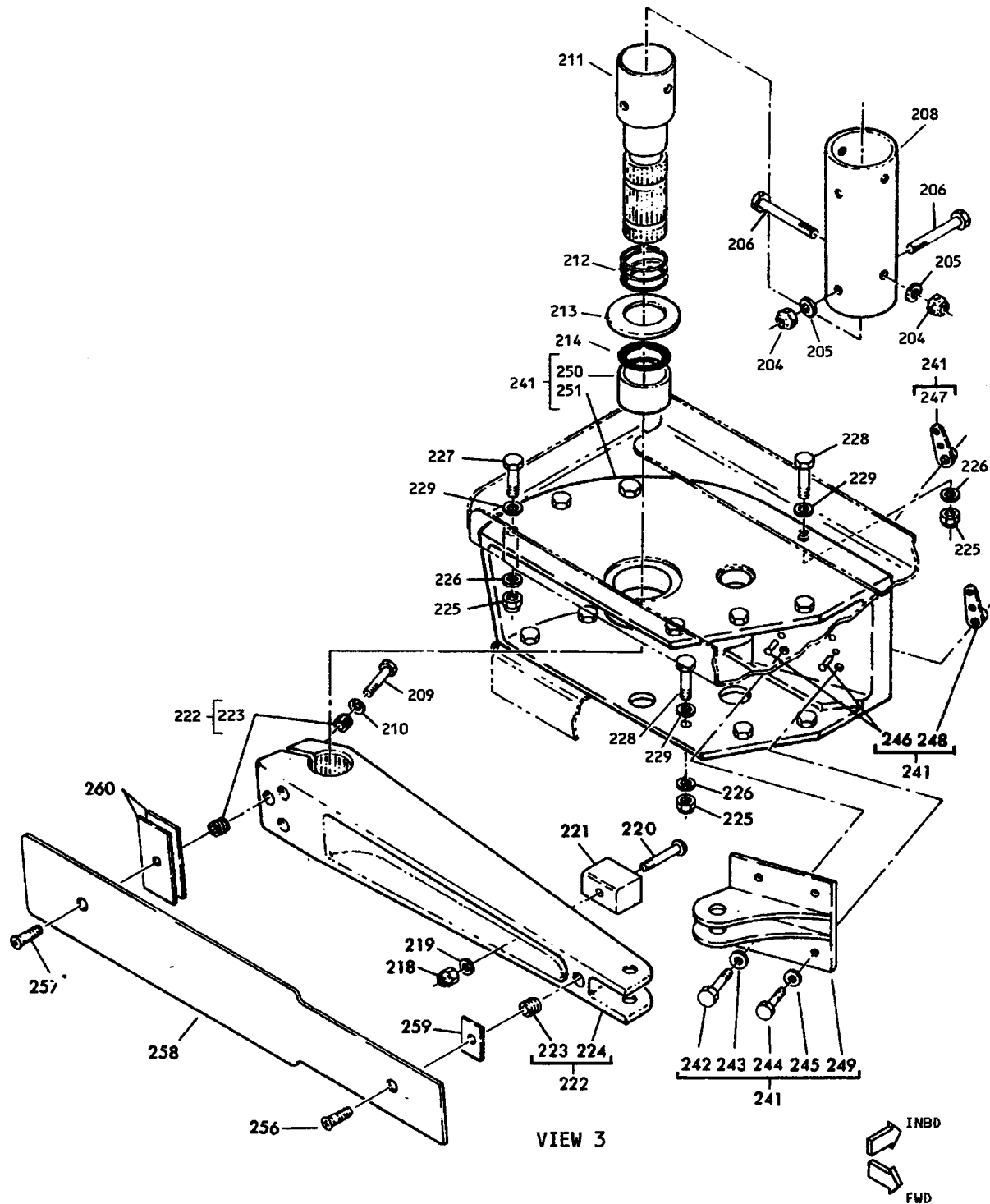


Aft Entry Door Assembly
Figure 1101 (Sheet 7)

BOEING
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VIEW 2



Aft Entry Door Assembly
Figure 1101 (Sheet 9)

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-	65-52873-2		AFT ENTRY DOOR ASSY	A	RF
	65-52873-159		AFT ENTRY DOOR ASSY	B	RF
	65-52873-176		AFT ENTRY DOOR ASSY	C	RF
	65-52873-177		DELETED		
	65-52873-180		AFT ENTRY DOOR ASSY	E	RF
	65-52873-182		AFT ENTRY DOOR ASSY	F	RF
	65-52873-189		AFT ENTRY DOOR ASSY	K	RF
	65-52873-167		AFT ENTRY DOOR ASSY	G	RF
	65-52873-168		AFT ENTRY DOOR ASSY	H	RF
	65-52873-567		AFT ENTRY DOOR ASSY	J	RF
1	69-20350-5		. RETAINER ASSY *[1]	AG	1
1	69-20350-7		. RETAINER ASSY *[1]	A	1
1	69-20350-9		. RETAINER *[1]	AG	1
1A	69-20350-10		DELETED		
1A	69-20350-13		. RETAINER ASSY (REPLS 69-20350-10) *[1]	A	1
1A	69-20350-13		. RETAINER ASSY *[1]	B	1
1A	69-20350-15		. RETAINER ASSY *[1]	ABG	1
1A	69-20350-15		. RETAINER ASSY	CEFHHK	1
2	BACS21AP180R		. . STUD (USED ON 69-20350-5,-7)		4
2A	BACS21AP180RP		DELETED		
2A	BACS21AP220RP		. . STUD (USED ON 69-20350-13,-15)		4
3	AN960D416		. . WASHER		4
4	BACR12AG		. . RING (USED ON 69-20350-5,-7)		4
4A	BACR12AG2C		. . RING (USED ON 69-20350-13,-15)		4
4B	AN960D416L		. . WASHER (USED ON 69-20350-13,-15)		4
5	BACR15BA3D		. . RIVET (REPLS MS20426D3) (USED ON 69-20350-5,-7)		8
5A	BACR15BB3AD		. . RIVET (USED ON 69-20350-13,-15)		8
6	BACN10JR3F		. . NUTPLATE (REPLS NAS686A3) (USED ON 69-20350-5,-7)		4
6	BACN10TL3-3		. . SPACER (USED ON 69-20350-13,-15)		4
7	69-20350-6		. . RETAINER (USED ON 69-20350-5)		1
7	69-20350-8		. . RETAINER (USED ON 69-20350-7)		1
7A	69-20350-12		. . RETAINER (USED ON 69-20350-13)		1
7A	69-20350-17		. . RETAINER (USED ON 69-20350-15)		1
8	BACR15BB4D		. RIVET (REPLS MS20470D4)	AG	4
9	DE586		. FASTENER ASSY, V71985 (BOEING 10-60831-7)	AG	2
9	J7444-11		. FASTENER ASSY, V76005 (BOEING 10-60831-7)	AG	2
9	SL25209		. FASTENER ASSY, V97393 (BOEING 10-60831-7)	AG	2
10	BACB30NE3-3		. BOLT (REPLS NAS1303-3)		12
11	65-52873-36		. COVERPLATE		1
12	65-52873-37		. COVERPLATE	A-J	1
12	65-52873-37		. COVERPLATE *[1]	K	1
12	65-52873-193		. COVERPLATE *[1]	K	1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
1101-13	BACR15BA3D		.	RIVET (REPLS MS20426D3)							18
14	BACN10JR3F		.	NUTPLATE (REPLS NAS686A3)							3
15	BACN10KB3F		.	NUTPLATE (REPLS NAS687A3)							6
16	BACB30NE3-3		.	BOLT (REPLS NAS1303-3)							5
17	69-21619-5		.	BRACKET ASSY							1
18	BACR15BB4D		.	RIVET (REPLS MS20470D4)							4
19	DE575		.	FASTENER ASSY, V71985 (BOEING 10-60124)							2
19	90-3287-11		.	FASTENER ASSY, V94222 (BOEING 10-60124)							2
19	SL1737		.	FASTENER ASSY, V97393 (BOEING 10-60124)							2
20	BACR15BA3D		.	RIVET (REPLS MS20426D3)							6
21	BACN10JR3F		.	NUTPLATE (REPLS NAS686A3)							3
22	69-21619-4		.	BRACKET							1
23	BACR15BA3D		.	RIVET (REPLS MS20426D3)							10
24	BACN10JR3F		.	NUTPLATE (REPLS NAS686A3)							5
25	NAS603-9P		.	BOLT *[1]						A-H	8
25	NAS6603-3		.	BOLT *[1]						A-H	8
25	NAS6603-3		.	BOLT						JK	8
26	BACB30NE3-9		.	BOLT (REPLS NAS1303-9) *[1]						A-H	20
26	NAS6603-3		.	BOLT *[1]						A-H	20
26	NAS6603-3		.	BOLT						JK	20
26A	BACW10BN3AP		.	WASHER *[1]						A-H	28
26A	BACW10BN3AP		.	WASHER						JK	28
27	65-52873-24		.	COVERPLATE							2
28	BACR15BA3D		.	RIVET (REPLS MS20426D3)							56
29	BACN10JZ3A2		.	NUTPLATE (REPLS BACN10EN3E)							8
30	BACN10JR3		.	NUTPLATE (REPLS NAS680A3)							20
31	BACN10JC3		.	NUT (REPLS NAS679A3W)							8
32	AN960PD10		.	WASHER							8
33	NAS583-2		.	BOLT							8
34	NAS1103-2		.	BOLT							16
35	NAS1103-3		.	BOLT							16
36	NAS1103-4		.	BOLT							8
37	AN960PD10L		.	WASHER							40
38	66-24154-1		.	ANGLE							1
39	66-24154-2		.	ANGLE							1
40	BACR15BA3D		.	RIVET (REPLS MS20426D3)							80
41	BACN10KF3		.	DELETED							
41	BACN10KE3D		.	NUTPLATE							40
41	BACN10JC3		.	NUT (REPLS NAS679A3W)(OPT TO BACN10KE3D)							40
42	65-52873-32		.	FILLER							2
43	BACB30NE3-3		.	BOLT (REPLS NAS1303-3)							3
44	AN960D10		.	WASHER							3
45	65-2863-3		.	WINDOW ASSY							1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-46	BACN10JC04		. . NUT (REPLS NAS679A04W)		6
47	AN960-4		. . WASHER		12
48	NAS600-8P		. . SCREW		6
49	63-1478		. . CLIP		3
50	BACS40A12-12		. . SHIM		AR
51	BACS40B12-12		. . SHIM		AR
52	66-2646		. . SEAL		1
53	69-1983		. . RETAINER		1
54	69-1083		. . PANE, INNER		1
55	69-1084		. . PANE, OUTER		1
56	66-1921-1		. . SEAL		1
56G	69-43894-4		. WINDOW DOUBLER ASSY	A-J	1
56G	69-43894-4		. WINDOW DOUBLER ASSY *[1]	K	1
56G	69-43894-7		. WINDOW DOUBLER ASSY *[1]	K	1
57	BACR15BA4D		. . RIVET (REPLS MS20426D4)		6
58	BACN10MK3-45		. . NUTPLATE		3
58	BACN10YG3-45		. . NUTPLATE (USED ON 69-43894-7)		3
59	BACS40P8E11		DELETED		
59	BACS40R007C011		. . SHIM (USED ON 69-43894-4)		AR
59	BACS40R007B011		. . SHIM (USED ON 69-43894-7)		AR
60	69-43894-4		DELETED		
60	69-43894-3		. . FILLER (USED ON 69-43894-4)		3
60	69-43894-8		. . FILLER (USED ON 69-43894-7)		3
60G	69-43894-5		. . DOUBLER		1
61	65-52873-509		. ROD		2
62	65-52873-510		. ROD		2
63	65-52873-507		. ROD		4
64	S14162-5		. SEAL, V75345 (BOEING 10-60476-5)		1
65	BACR15CE6D		. RIVET		2
66	69-37495-2		. PLATE		1
67	BACR15BA3D		. RIVET (REPLS MS20426D3)		6
68	BACN10KB3F		. NUTPLATE (REPLS NAS687A3)		2
69	BACN10JR3F		. NUTPLATE (REPLS NAS686A3)		1
70	65-52983-2		. FITTING ASSY, STOP *[1]	A	1
70	65-52983-6		. FITTING ASSY, STOP *[1]	A	1
70	65-52983-6		. FITTING ASSY, STOP	B-K	1
71	66-12688-1		. . BUSHING		1
72	65-52983-4		. . FITTING (USED ON 65-52983-2)		1
72	65-52983-8		. . FITTING (USED ON 65-52983-6)		1
73	65-45852-2		. FITTING ASSY, STOP *[1]	A	1
73	65-45852-502		. FITTING ASSY, STOP *[1]	A	1
73	65-45852-502		. FITTING ASSY, STOP	B-J	1
73	65-45852-502		. FITTING ASSY, STOP *[1] (OPT TO 65-45852-8)	K	1
73	65-45852-8		. FITTING ASSY, STOP *[1] (OPT TO 65-45852-502)	K	1
74	66-12688-1		. . BUSHING		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
1101-											
74	65-12688-5		.	.	BUSHING (USED ON 65-45852-8)						1
75	65-45852-4		.	.	FITTING (USED ON 65-45852-2)						1
75	65-45852-10		.	.	FITTING (USED ON 65-45852-8)						1
75	65-45852-504		.	.	FITTING (USED ON 65-45852-502)						1
76	65-54481-2		.		FITTING ASSY, STOP						2
77	66-12688-1		.	.	BUSHING (REPLD BY 66-12688-5)						1
77	66-12688-5		.	.	BUSHING (REPLS 66-12688-1)						1
78	65-54481-4		.	.	FITTING						1
79	65-49890-2		.		FITTING ASSY, STOP					A-J	1
79	65-49890-2		.		FITTING ASSY, STOP (OPT TO 65-49890-8)					K	1
79	65-49890-8		.		FITTING ASSY, STOP (OPT TO 65-49890-2)					K	1
80	66-12688-1		.	.	BUSHING (USED ON 65-49890-2, -8)						1
80	66-12688-11		.	.	BUSHING (USED ON 65-49890-8) (OPT)						1
81	65-49890-4		.	.	FITTING (USED ON 65-49890-2)						1
81	65-49890-10		.	.	FITTING (USED ON 65-49890-8)						1
82	65-58138-2		.		FITTING ASSY, STOP *[1] (OPT TO 65-58138-6)					E	1
82	65-58138-2		.		FITTING ASSY, STOP					A-CF-H	1
82	65-58138-2		.		FITTING ASSY, STOP (OPT TO 65-58138-6)					J	1
82	65-58138-2		.		FITTING ASSY, STOP *[1]					K	1
82	65-58138-6		.		FITTING ASSY, STOP *[1] (OPT 65-58138-2)					E	1
82	65-58138-6		.		FITTING ASSY, STOP (OPT 65-58138-2)					J	1
82	65-58138-6		.		FITTING ASSY, STOP *[1]					K	1
83	66-12688-1		.	.	BUSHING						1
84	65-58138-4		.	.	FITTING (USED ON 65-58138-2)						1
84	65-58138-5		.	.	FITTING (USED ON 65-58138-6)						1
85	65-52981-2		.		FITTING ASSY, STOP *[1]					A	1
85	65-52981-6		.		FITTING ASSY, STOP *[1]					AK	1
85	65-52981-6		.		FITTING ASSY, STOP					B-J	1
85	65-52981-10		.		FITTING ASSY, STOP *[1]					K	1
86	66-12688-1		.	.	BUSHING						1
87	65-52981-4		.	.	FITTING (USED ON 65-52981-2)						1
87	65-52981-8		.	.	FITTING (USED ON 65-52981-6)						1
87	65-52981-12		.	.	FITTING (USED ON 65-52981-10)						1
88	65-52980-2		.		FITTING ASSY, STOP *[1]					A	1
88	65-52980-6		.		FITTING ASSY, STOP *[1]					A	1
88	65-52980-6		.		FITTING ASSY, STOP					B-K	1
89	66-12688-1		.	.	BUSHING						1
90	65-52980-4		.	.	FITTING (USED ON 65-52980-2)						1
90	65-52980-8		.	.	FITTING (USED ON 65-52980-6)						1
91	65-58138-1		.		FITTING ASSY, STOP						1
92	66-12688-1		.	.	BUSHING						1
93	65-58138-3		.	.	FITTING						1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
1101-											
94	65-45851-2		.	.	FITTING ASSY, STOP						1
95	66-12688-1		.	.	BUSHING						1
96	65-45851-10		.	.	FITTING						1
97	65-45851-4		.	.	FITTING ASSY, STOP						1
98	66-12688-1		.	.	BUSHING						1
99	65-45851-12		.	.	FITTING						1
100	65-45851-6		.	.	FITTING ASSY, STOP						1
101	66-12688-1		.	.	BUSHING						1
102	65-45851-14		.	.	FITTING						1
103	65-45851-8		.	.	FITTING ASSY, STOP						1
104	66-12688-1		.	.	BUSHING						1
105	65-45851-16		.	.	FITTING						1
106	65-52982-2		.	.	FITTING ASSY, STOP *[1]					A	1
106	65-52982-6		.	.	FITTING ASSY, STOP *[1]					A	1
106	65-52982-6		.	.	FITTING ASSY, STOP					B-J	1
107	66-12688-1		.	.	BUSHING						1
108	65-52982-4		.	.	FITTING (USED ON 65-52982-2)						1
108	65-52982-8		.	.	FITTING (USED ON 65-52982-6)						1
109	BACN10JC4		.	.	NUT (REPLS NAS679A4W)						6
110	AN960PD416		.	.	WASHER						4
111	NAS1197-416L		.	.	WASHER						4
112	NAS1104-13		.	.	BOLT						4
113	NAS1104-18		.	.	BOLT						2
114	NAS1104-12		.	.	BOLT						2
115	AN960PD416L		.	.	WASHER						2
116	NAS74A4E006P		.	.	BUSHING						2
117	69-18187-8		.	.	ROD ASSY *[1]					A	1
117	69-18187-23		.	.	ROD ASSY *[1]					A	1
117	69-18187-23		.	.	ROD ASSY					B-J	1
117	69-18187-23		.	.	ROD ASSY *[1] (REPLD BY 69-18187-26)					K	1
117	69-18187-26		.	.	ROD ASSY *[1] (REPLS 69-18187-23, -26)					K	1
118	BACB10A187M2L		.	.	BEARING						1
118	BACB10A187L		.	.	BEARING (OPT TO BACB10A187M2L)						1
118A	BACB10Y4		.	.	BEARING (USED ON 69-18187-23, -26)						1
118A	BACB10A187M2L		.	.	BEARING (USED ON 69-18187-8) (OPT TO BACB10A187L)						1
118A	BACB10A187L		.	.	BEARING (OPT TO BACB10A187M2L) (USED ON 69-18187-8)						1
119	AN316-5R		.	.	NUT						1
120	BACR15BB5D		.	.	RIVET (REPLS MS20470D5)						1
121	66-14618-7		.	.	ROD						1
122	65-28925-57		.	.	ROD ASSY *[1]					A	1
122	65-28925-87		.	.	ROD ASSY *[1]					A	1
122	65-28925-87		.	.	ROD ASSY					B-K	1
123	BACB10A187L		.	.	BEARING						1
123A	BACB10A187L		.	.	BEARING (USED ON 65-28925-57)						1
123A	BACB10Y4		.	.	BEARING (USED ON 65-28925-87)						1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-124	AN316-5R		. . NUT		2
125	BACR15BB3D		. . RIVET (REPLS MS20470D3)		1
126	65-28925-58		. . ROD		1
127	65-28925-46		. ROD ASSY *[1]	A	1
127	65-28925-86		. ROD ASSY *[1]	A	1
127	65-28925-86		. ROD ASSY	B-K	1
128	BACB10A187L		. . BEARING		2
128A	BACB10A187L		. . BEARING (USED ON 65-28925-46)		1
128A	BACB10Y4		. . BEARING (USED ON 65-28925-86)		1
129	AN316-5R		. . NUT		2
129	AN316-5R		. . NUT		2
130	BACR15BB3D		. . RIVET (REPLS MS20470D3)		1
131	65-28925-48		. . ROD		1
132	65-28925-45		. ROD ASSY *[1]	A	1
132	65-28925-85		. ROD ASSY *[1]	A	1
132	65-28925-85		. ROD ASSY	B-K	1
133	BACB10A187L		. . BEARING		1
133A	BACB10A187L		. . BEARING (USED ON 65-28925-45)		1
133A	BACB10Y4		. . BEARING (USED ON 65-28925-85)		1
134	AN316-5R		. . NUT		2
135	BACR15BB3D		. . RIVET (REPLS MS20470D3)		1
136	65-28925-47		. . ROD		1
137	BACB30LU3-4		. BOLT (REPLS NAS333CPA5) *[1]	A-CGH	9
137A	NAS623-3-2		. BOLT *[1]	A-CGH	9
137A	NAS623-3-2		. BOLT	EFJK	9
137B	AN960PD10L		. WASHER *[1]	A-CGH	9
137B	AN960PD10L		. WASHER	EFJK	9
138	NAS583-4		. BOLT *[1]	A-CGH	9
138A	NAS623-3-2		. BOLT *[1]	A-CGH	9
138A	NAS623-3-2		. BOLT	EFJK	9
138B	AN960PD10L		. WASHER *[1]	A-CGH	9
138B	AN960PD10L		. WASHER	EFJK	9
139	65-55479-1		. GATE ASSY, UPPER (REPLD BY 65-55479-501) *[1]	A	1
139	65-55479-501		. GATE ASSY, UPPER (REPLS 65-55479-1) *[1]	A	1
139	65-55479-501		. GATE ASSY, UPPER	BGH	1
139	65-55479-7		. GATE ASSY, UPPER	C-FJK	1
140	NAS77A4-23P		. . BUSHING		1
141	65-55479-3		. . GATE (USED ON 65-55479-1)		1
141	65-55479-503		. . GATE (USED ON 65-55478-501)		1
141	65-55479-9		. . GATE (USED ON 65-55479-7)		1
142	65-55478-2		. GATE ASSY, LOWER (REPLD BY 65-55478-502) *[1]	A	1
142	65-55478-502		. GATE ASSY, LOWER (REPLS 65-55478-1) *[1]	A	1
142	65-55478-502		. GATE ASSY, LOWER	BGH	1

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		
1101-142	65-55478-8		.	.	.	.	.	.	.	C-FJK	1
143	NAS77A4-23P		.	.	.	.	.	.	.		1
144	69-41720-1		.	.	.	.	.	.	.		2
145	65-55478-4		.	.	.	.	.	.	.		1
145	65-55478-504		.	.	.	.	.	.	.		1
145	65-55478-10		.	.	.	.	.	.	.		1
146	65-52873-33		.	.	.	.	.	.	.	A-CGH	1
147	65-52873-43		.	.	.	.	.	.	.	A-CGH	1
148	BACR15BA3D		.	.	.	.	.	.	.		36
149	BACN10JZ3A2		.	.	.	.	.	.	.		18
149	BACN10JR3F		.	.	.	.	.	.	.		18
150	MS16562-1		.	.	.	.	.	.	.	A-CGH	4
151	65-52873-107		.	.	.	.	.	.	.	A	1
151	65-52873-525		.	.	.	.	.	.	.	AC	1
151	65-52873-525		.	.	.	.	.	.	.	BGH	1
151	65C34071-2		.	.	.	.	.	.	.	C	1
151	65C34071-2		.	.	.	.	.	.	.	EFJK	1
151	65C34071-2		.	.	.	.	.	.	.	A-CGHJ	1
152	MS20253-2-2870		.	.	.	.	.	.	.		1
152A	MS16562-209		.	.	.	.	.	.	.		2
153	BACR15CE5D		.	.	.	.	.	.	.		9
154	65-52873-123		.	.	.	.	.	.	.	A-CGH	1
155	65-52873-72		.	.	.	.	.	.	.		1
155	65-52855-507		.	.	.	.	.	.	.		1
155	65C34053-2		.	.	.	.	.	.	.		1
156	65-52873-71		.	.	.	.	.	.	.		1
156	65C34053-3		.	.	.	.	.	.	.		1
157	65-52873-108		.	.	.	.	.	.	.	A	1
157	65-52873-526		.	.	.	.	.	.	.	AC	1
157	65-52873-526		.	.	.	.	.	.	.	BCGH	1
157	65C34071-4		.	.	.	.	.	.	.	C	1
157	65C34071-4		.	.	.	.	.	.	.	EFJK	1
157	65C34071-4		.	.	.	.	.	.	.	A-CGH	1
158	MS20253-2-2885		.	.	.	.	.	.	.		1
158	MS20253P2-2880		.	.	.	.	.	.	.		1
158A	MS16562-209		.	.	.	.	.	.	.		2
159	BACR15CE5D		.	.	.	.	.	.	.		9
160	65-52873-125		.	.	.	.	.	.	.		1
161	65-52873-73		.	.	.	.	.	.	.		1
161	65-52855-509		.	.	.	.	.	.	.		1
161	65C34053-6		.	.	.	.	.	.	.		1
162	65-52873-74		.	.	.	.	.	.	.		1
162	65C34083-8		.	.	.	.	.	.	.		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-163	65-52873-124		. RETAINER		1
164	65-52873-126		. RETAINER	ABCGH	1
165	BACN10JC3		. NUT (REPLS NAS679A3W) (PRE SB 52-1094, R3)	A-F	8
165	BACN10YR3CD		. NUT (POST SB 52-1094) *[3] *[4] *[5]	A-F	8
165	BACN10YR3CD		. NUT *[4] *[5]	GHJK	8
166	AN960-10L		. WASHER (PRE SB 52-1094, R3)	A-F	8
166	AN960C10L		. WASHER (POST SB 52-1094, R3) *[3] *[4] *[5]	A-F	8
166	AN960C10L		. WASHER *[4] *[5]	GHJK	8
167	NAS1103-1		. BOLT (PRE SB 52-1094, R3)	A-F	8
167	BACB30NM3K17		. BOLT (POST SB 52-1094, R3) *[3] *[4] *[5]	A-F	8
167	BACB30NM3K17		. BOLT *[4] *[5]	GHJK	8
167	NAS6703-19		. BOLT (OPT)	GH	8
168	69-37418-2		. CRANK *[1] (PRE SB 52-1094, R3)	A	4
168	69-37418-501		. CRANK *[1] (OPT TO 69-37418-8) (POST SB 52-1094, R3) *[4] *[5]	AK	4
168	69-37418-501		. CRANK (OPT TO 69-37418-8) (POST SB 52-1094, R3) *[4] *[5]	B-J	4
168	69-37418-8		. CRANK *[1] (OPT TO 69-37418-501) (PRE SB 52-1094, R3)	AK	4
168	69-37418-8		. CRANK (OPT TO 69-37418-501) (PRE SB 52-1094, R3)	B-J	4
168	69-37418-11		. CRANK *[1]	K	4
169	66-15332-1		. SPACER		AR
169	30-3004		. WASHER (OPT)		AR
170	MS24665-134		. PIN, COTTER		4
171	BACN10JD105		. NUT (REPLS AN320-5)		4
172	AN960PD516L		. WASHER		AR
173	BACB10AF5F9H		. BEARING (PREF)	A-J	4
173	BACB10AF5F9H		. BEARING *[1] (OPT TO BACB10BH59F7)	K	4
173	BACB10BH59F7		. BEARING (OPT TO BACB10AF5F9H)	A-J	4
173	BACB10BH59F7		. BEARING *[1] (OPT TO BACB10AF5F9H)	K	4
173	KRP141500VT5-9		. BEARING *[1] (V50632)	K	4
174	BACN10JC3		. NUT (REPLS NAS679A3W) (PRE SB 52-1094, R3)	A-F	8
174	BACN10YR3CD		. NUT (POST SB 52-1094) *[3] *[4] *[5]	A-F	8
174	BACN10YR3CD		. NUT *[4] *[5]	GHJK	8
175	AN960-10L		. WASHER (PRE SB 52-1094, R3)	A-F	8
175	AN960C10L		. WASHER (POST SB 52-1094) *[3] *[4] *[5]	A-F	8
175	AN960C10L		. WASHER *[4] *[5]	GHJ	8
176	NAS1103-18		. BOLT (PRE SB 52-1094, R3)	A-F	8
176	BACB30NM3K19		. BOLT (POST SB 52-1094) *[3] *[4] *[5]	A-F	8
176	BACB30NM3K19		. BOLT *[4] *[5]	GHJK	8
176	NAS6703-19		. BOLT (OPT)	GH	8

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			
1101-												
177	66-14530-1		.							CRANK (PRE SB 52-1094, R3)	AB	1
177	66-14530-2		.							CRANK (POST SB 52-1094) *[4]	AB	1
177	66-14530-2		.							CRANK *[4]	C-K	1
178	66-14531-1		.							CRANK (PRE SB 52-1094, R3)	AB	2
178	66-14531-9		.							CRANK (POST SB 52-1094) *[4] *[5]		2
178	66-14531-9		.							CRANK *[4] *[5]	C-K	2
179	66-14531-3		.							CRANK (PRE SB 52-1094, R3)	AB	1
179	66-14531-10		.							CRANK (POST SB 52-1094) *[5]		1
179	66-14531-10		.							CRANK *[5]	C-K	1
180	60-4406-7		.							TUBE, TORQUE (PRE SB 52-1094, R3)	AB	1
180	60-4406-13		.							TUBE, TORQUE (POST SB 52-1094) *[4]		1
180	60-4406-13		.							TUBE, TORQUE *[4]	C-K	1
181	60-4406-8		.							TUBE, TORQUE (PRE SB 52-1094, R3)	AB	1
181	60-4406-14		.							TUBE, TORQUE (POST SB 52-1094) *[5]		1
181	60-4406-14		.							TUBE, TORQUE *[5]	C-K	1
182	BACN10JC3		.							NUT (REPLS NAS679A3W)		16
183	AN960PD10		.							WASHER		16
184	BACB30EL3-6		.							BOLT		16
185	66-9330-1		.							SHIM		AR
186	66-9330-3		.							SHIM		AR
187	65-49560-1		.							FITTING ASSY	A-CEG-J	2
187	65-49560-1		.							FITTING ASSY *[1]	K	2
187	65-49560-9		.							FITTING ASSY *[1]	K	2
187	65-49560-15		.							FITTING ASSY *[1]	K	2
188	NAS516-1		.	.						FITTING, LUBRICATION (USED ON 65-49560-1, -9)		1
188	NAS516-1A		.	.						FITTING, LUBRICATION (USED ON 65-49560-15)		1
189	65-49560-2		.	.						FITTING (USED ON 65-49560-1)		1
189	65-49560-10		.	.						FITTING (USED ON 65-49560-9)		1
189	65-49560-16		.	.						FITTING (USED ON 65-49560-15)		1
190	65-49560-4		.							FITTING ASSY	A-CEG-J	1
190	65-49560-4		.							FITTING ASSY *[1]	K	1
190	65-49560-11		.							FITTING ASSY *[1]	K	1
190	65-49560-17		.							FITTING ASSY *[1]	K	1
191	NAS516-1		.	.						FITTING, LUBRICATION (USED ON 65-49560-4, -11)		1
191	NAS516-1A		.	.						FITTING, LUBRICATION (USED ON 65-49560-17)		1
192	65-49560-6		.	.						FITTING (USED ON 65-49560-4)		1
192	65-49560-12		.	.						FITTING (USED ON 65-49560-11)		1
192	65-49560-18		.	.						FITTING (USED ON 65-49560-17)		1
193	65-49560-5		.							FITTING ASSY	A-CEG-J	1
193	65-49560-5		.							FITTING ASSY *[1]	K	1
193	65-49560-13		.							FITTING ASSY *[1]	K	1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
1101-193	65-49560-19		.	FITTING ASSY *[1]						K	1
194	NAS516-1		.	.	FITTING, LUBRICATION (USED ON 65-49560-5, -13)						1
194	NAS516-1A		.	.	FITTING, LUBRICATION (USED ON 65-49560-19)						1
195	65-49560-7		.	.	FITTING (USED ON 65-49560-5)						1
195	65-49560-14		.	.	FITTING (USED ON 65-49560-13)						1
195	65-49560-20		.	.	FITTING (USED ON 65-49560-19)						1
196	BACN10JC3		.	NUT (REPLS NAS679A3W)							16
197	AN960D10		.	WASHER							8
198	AN960PD10		.	WASHER							8
199	NAS1103-3		.	BOLT							16
200	65-2306		.	HOUSING ASSY *[1]						A	4
200	65-2306-3		.	HOUSING ASSY *[1]						A	4
200	65-2306-3		.	HOUSING ASSY						B-K	4
201	NAS516-1		.	.	FITTING, LUBE (USED ON 65-2306)						1
201	MS15001-4		.	.	FITTING, LUBE (USED ON 65-2306-3)						1
202	65-2306-1		.	.	HOUSING (USED ON 65-2306)						1
202	65-2306-4		.	.	HOUSING (USED ON 65-2306-3)						1
203	BACB10A397G-CM2		.	BEARING							8
204	BACN10JC4		.	NUT (REPLS NAS679A4W) (PRE SB 52-1094, R3)						AB	8
204	BACN10YR4CD		.	NUT (POST SB 52-1094, R3)							8
204	BACN10YR4CD		.	NUT						C-K	8
205	AN960-416		.	WASHER (PRE SB 52-1094, R3)							8
205	AN960C416L		.	WASHER (POST SB 52-1094, R3)							8
205	AN960C416L		.	WASHER						C-K	8
206	NAS1104-25		.	BOLT (PRE SB 52-1094, R3)						AB	8
206	BACB30NM4K26		.	BOLT (POST SB 52-1094, R3)							8
206	BACB30NM4K26		.	BOLT						C-K	8
207	60-4365		.	SLEEVE *[1] (PRE SB 52-1094, R3)						A	1
207	60-4365-1		.	SLEEVE *[1] (PRE SB 52-1094, R3)						A	1
207	60-4365-1		.	SLEEVE (PRE SB 52-1094, R3)						B	1
207	60-4365-3		.	SLEEVE (POST SB 52-1094, R3)						AB	1
207	60-4365-3		.	SLEEVE						C-K	1
208	66-24987-1		.	SLEEVE *[1] (PRE SB 52-1094, R3)						A	1
208	66-24987-2		.	SLEEVE *[1] (PRE SB 52-1094, R3)						A	1
208	66-24987-2		.	SLEEVE (PRE SB 52-1094, R3)						B	1
208	66-24987-3		.	SLEEVE (POST SB 52-1094, R3)						AB	1
208	66-24987-3		.	SLEEVE						C-K	1
209	BACB30NE3-12		.	BOLT (REPLS NAS1303-12)							4
210	AN960PD10L		.	WASHER							4

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE						USE CODE	QTY PER ASSY
			1	2	3	4	5	6		
1101-										
211	66-14527-1		.	PIN	*[1]	(PRE SB 52-1094, R3)			A	2
211	66-14527-2		.	PIN	*[1]	(PRE SB 52-1094, R3)			A	2
211	66-14527-4		.	PIN	*[1]	(PRE SB 52-1094, R3)			A	2
211	66-14527-4		.	PIN		(PRE SB 52-1094, R3)			B	2
211	66-14527-6		.	PIN		(POST SB 52-1094, R3)			AB	2
211	66-14527-4		.	PIN					C-K	2
212	66-15645-1		.	SPRING						2
213	AN960-1716		.	WASHER		(PRE SB 52-1094, R3)				2
213	AN960C1716L		.	WASHER		(POST SB 52-1094) *[3]			AB	2
213	AN960C1716		.	WASHER		(POST SB 52-1094, R3)			AB	2
214	AN6227B19		.	PACKING, O-RING					AB	2
214	AN6227-19		.	PACKING, O-RING		(POST SB 52-1094) (PRE SB 52-1094, R3) *[3]			AB	2
214	MS28775-214		.	PACKING, O-RING		(POST SB 52-1094, R3)			AB	2
214	M83461-1-214		.	PACKING, O-RING		(OPT TO AN6227B19, AN6227-19, MS28775-214)			A-K	2
215	65-73978-8		.	ARM ASSY, HINGE		(PREF) *[1]			A	1
215	65-73978-2		.	ARM ASSY, HINGE		*[1]			A	1
215	69-17952-18		.	ARM ASSY, HINGE		(65-73978-2 OPT) *[1]			A	1
215	65-73978-8		.	ARM ASSY, HINGE					B-K	1
216	MS21209F1-15		.	.	INSERT	(REPLS BACS13W3CN3)				4
217	65-73978-4		.	.	ARM, HINGE	(USED ON 65-73978-2)				1
217	65-73978-10		.	.	ARM, HINGE	(USED ON 65-73978-8)				1
217	69-17952-20		.	.	ARM, HINGE	(USED ON 69-17952-18)				1
218	BACN10JC3		.	NUT	*[1]					1
218	BACN10JC3		.	NUT					B-K	1
219	AN960PD10		.	WASHER	*[1]					1
219	AN960PD10		.	WASHER					B-K	1
220	NAS623-3-10		.	SCREW	*[1]					1
220	NAS623-3-10		.	SCREW					B-K	1
221	65-52873-524		.	BLOCK	*[1]					1
221	65-52873-524		.	BLOCK					B-K	1
222	65-73978-1		.	ARM ASSY, HINGE		(OPT TO 69-17952-17) *[1]			A	1
222	69-17952-17		.	ARM ASSY, HINGE		(OPT TO 65-73978-1) *[1]			A	1
222	65-73978-1		.	ARM ASSY, HINGE					B-K	1
222	65-73978-1		.	ARM ASSY, HINGE		(OPT TO 65-73978-7)			K	1
222	65-73978-7		.	ARM ASSY, HINGE		(OPT TO 65-73978-1)			K	1
223	MS21209F1-15		.	.	INSERT	(REPLS BACS13W3CN3)				4
224	65-73978-3		.	.	ARM, HINGE	(USED ON 65-73978-1)				1
224	65-73978-9		.	.	ARM, HINGE	(USED ON 65-73978-7)				1
224	65-73978-11		.	.	ARM, HINGE	(USED ON 65-73978-7) (OPT)				1

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		
1101- 224	65-73978-13		.	.	ARM, HINGE (USED ON 65-73978-1)						1
					(OPT)						
224	69-17952-19		.	.	ARM, HINGE (USED ON 69-17952-17)						1
225	BACN10JC3		.		NUT (REPLS NAS679A3W)						28
226	AN960PD10		.		WASHER						28
227	NAS1103-3		.		BOLT						23
228	NAS1103-4		.		BOLT						5
229	BACS11W3		.		WASHER, SEAL						28
230	65-55720-4		.		SUPPORT ASSY, HINGE *[1]					A	1
230	65-55720-14		.		SUPPORT ASSY, HINGE *[1]					A	1
230	65-55720-14		.		SUPPORT ASSY, HINGE					B-K	1
231	NAS1104-10		.	.	BOLT						2
232	AN960PD416L		.	.	WASHER						AR
232	AN960PD416		.	.	WASHER						AR
233	NAS1103-10		.	.	BOLT						2
234	AN960PD10L		.	.	WASHER						2
235	BACR15BA3D		.	.	RIVET (REPLS MS20426D3)						8
236	BACN10KB4		.	.	NUTPLATE (REPLS NAS682A4)						2
237	BACN10KB3		.	.	NUTPLATE (REPLS NAS682A3)						2
238	69-42114-2		.	.	FITTING (USED ON 65-55720-4)						1
238	69-70268-2		.	.	FITTING (USED ON 65-55720-14)						1
239	NAS76A16-016P		.	.	BUSHING						1
240	65-55720-8		.	.	SUPPORT, HINGE						1
241	65-55720-2		.		SUPPORT ASSY, HINGE *[1]					A	1
241	65-55720-12		.		SUPPORT ASSY, HINGE *[1]					A	1
241	65-55720-12		.		SUPPORT ASSY, HINGE					B-K	1
242	NAS1104-10		.	.	BOLT						2
243	AN960PD416L		.	.	WASHER						AR
243	AN960PD416		.	.	WASHER						AR
244	NAS1103-10		.	.	BOLT						2
245	AN960PD10L		.	.	WASHER						2
246	BACR15BA3D		.	.	RIVET (REPLS MS20426D3)						8
247	BACN10KB4		.	.	NUTPLATE (REPLS NAS682A4)						2
248	BACN10KB3		.	.	NUTPLATE (REPLS NAS682A3)						2
249	69-42114-1		.	.	FITTING, ATTACH (USED ON 65-55720-2)						1
249	69-70268-1		.	.	FITTING (USED ON 65-55720-12)						1
250	NAS76A16-016P		.	.	BUSHING						1
251	65-55720-6		.	.	SUPPORT, HINGE						1
252	MS27253F1		.		PLATE, IDENTIFICATION						1
253	NONE		AFT ENTRY DOOR HANDLE MECHANISM (FIG. 1102) INSTALLATION ITEMS								1
254	66-16691-1		SPRING								16
255	66-12687-1		PIN								16

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
1101-256	BACB30LH3-2		BOLT (REPLS BACB30LU3-2 AND BACB30FL3-2) *[1]								1
256	NAS514P1032-9		SCREW *[1]								1
257	BACB30LH3-3		BOLT (REPLS BACB30LU3-3 AND BACB30FL3-3) *[1]								1
257	NAS514P1032-9		SCREW *[1]								1
258	65-52873-103		COVER *[1]								1
258	65-52873-179		COVER *[1]								1
258	65-52873-564		COVER *[1]								1
259	BACS40R06E08		SHIM								AR
260	BACS40R08E16		SHIM								AR
261	BACB30LH3-3		BOLT (REPLS BACB30LU3-3 AND BACB30FL3-3) *[1]								1
261	NAS514P1032-9		SCREW *[1]								1
262	BACB30LH3-10		BOLT (REPLS BACB30LU3-10 AND BACB30FL3-10) *[1]								1
262	NAS514P1032-15		SCREW *[1]								1
263	65-52873-104		COVER *[1]								1
263	65-52873-178		COVER *[1]								1
263	65-52873-563		COVER *[1]								1
264	BACS40R05E08		SHIM								AR
265	BACS40R07E16		SHIM								AR
266	65-52873-102		BLOCK								1
267	NAS1103-5		BOLT								1
268	NAS1103-10		BOLT								2
269	AN960PD10L		WASHER								3
270	69-17789-2		FITTING								1
271	BACN10JC5		NUT (REPLS NAS679A5)								1
272	AN960-516L		WASHER								1
273	NAS43HT5-23		SPACER								1
274	66-10363		GUIDE *[1]								1
274	KRP141500VT5-8		GUIDE *[1]								1
275	65-52873-62		PLUG *[1]								2

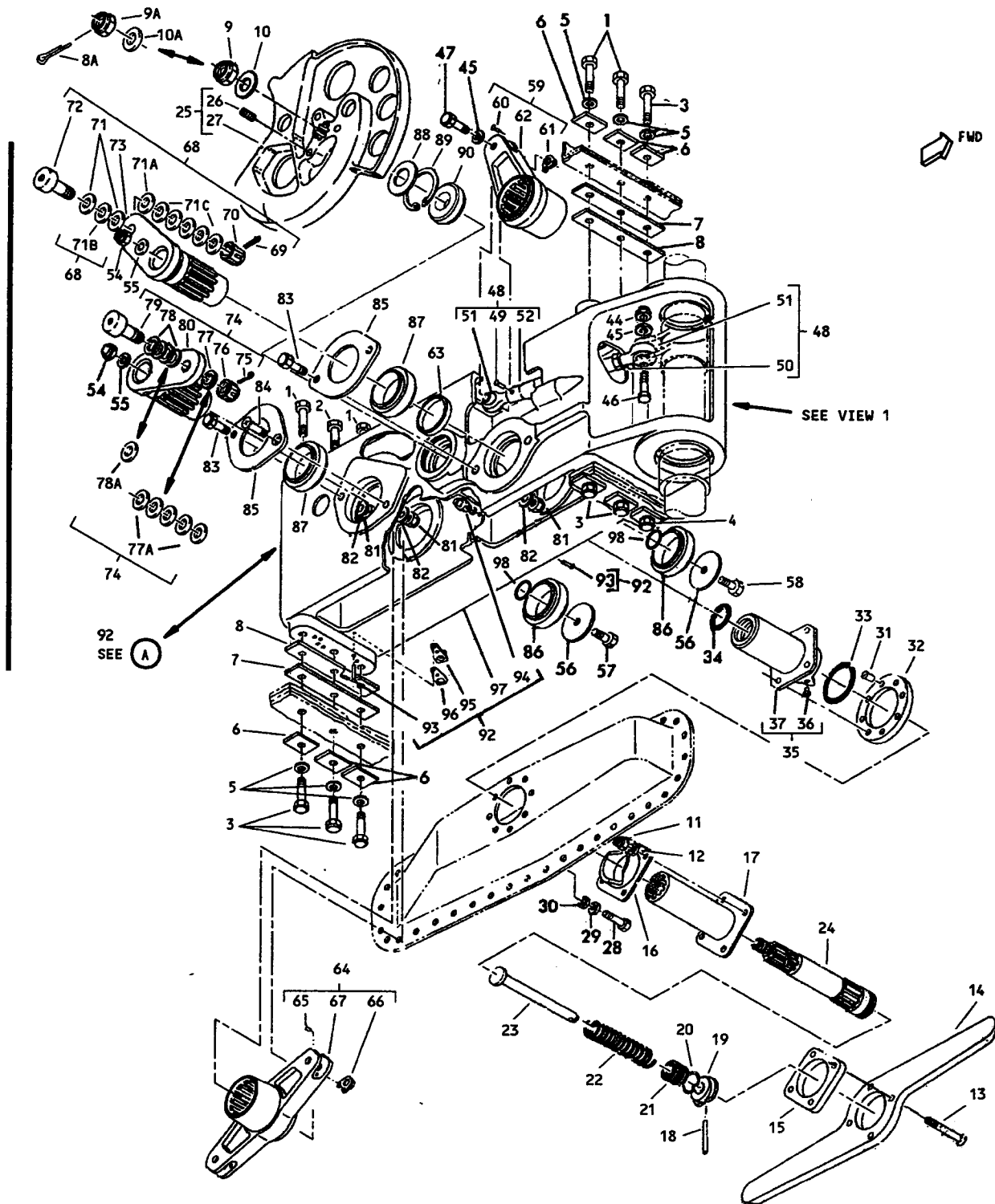
| *[1] LIMITED

| *[2] NO BOEING PART NUMBER ASSIGNED

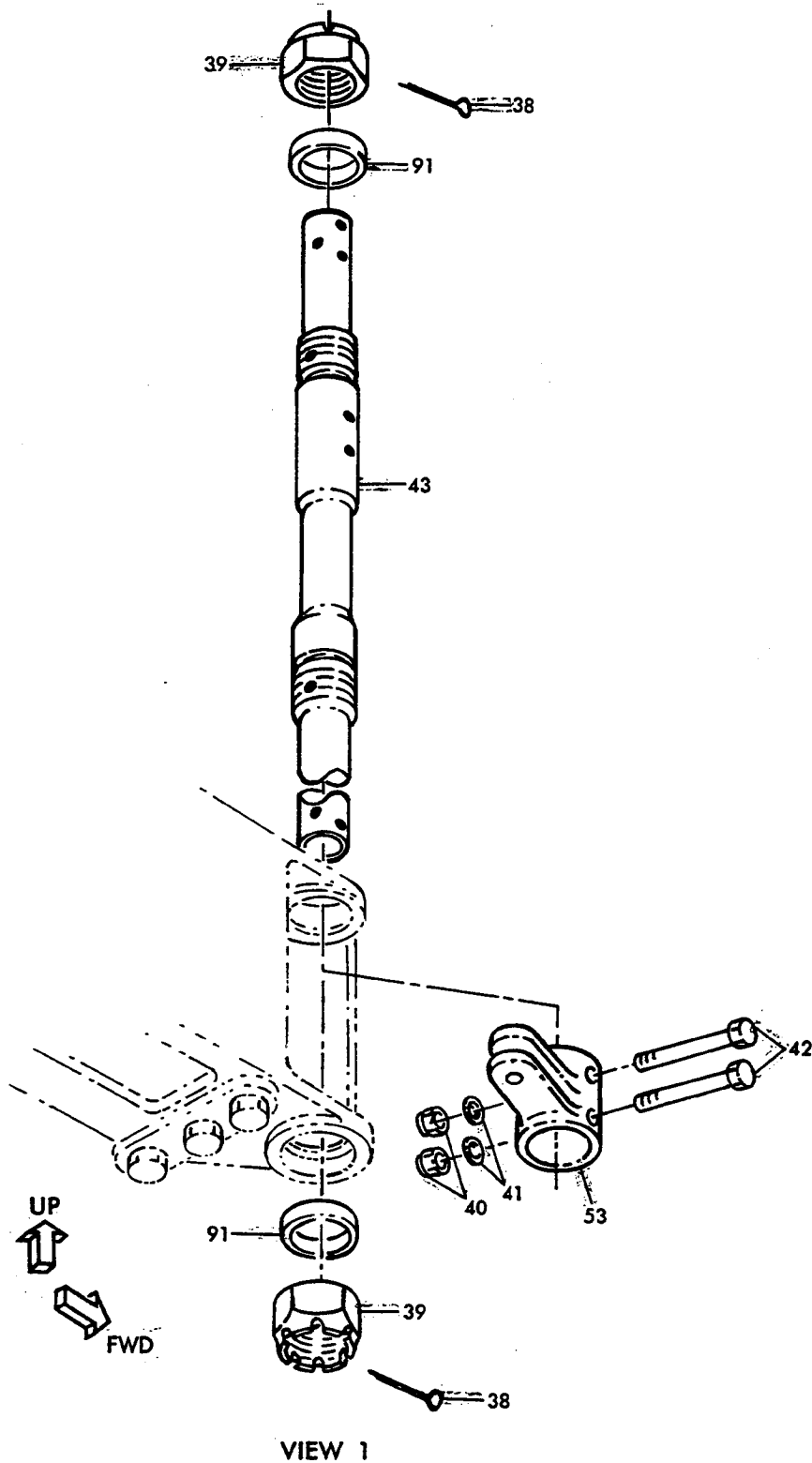
| *[3] NOT USED ON ALL POST SERVICE BULLETIN CONFIGURATIONS

| *[4] UPPER LATCH ASSY 65C33403-34 KIT HAS: TORQUE TUBE 60-4406-13; CRANKS 66-14530-2, 66-14531-9, 69-37418-501; WASHERS AN960C10L; BOLTS BACB30NM3K17, BACB30NM3K19; NUTS BACN10YR3CD.

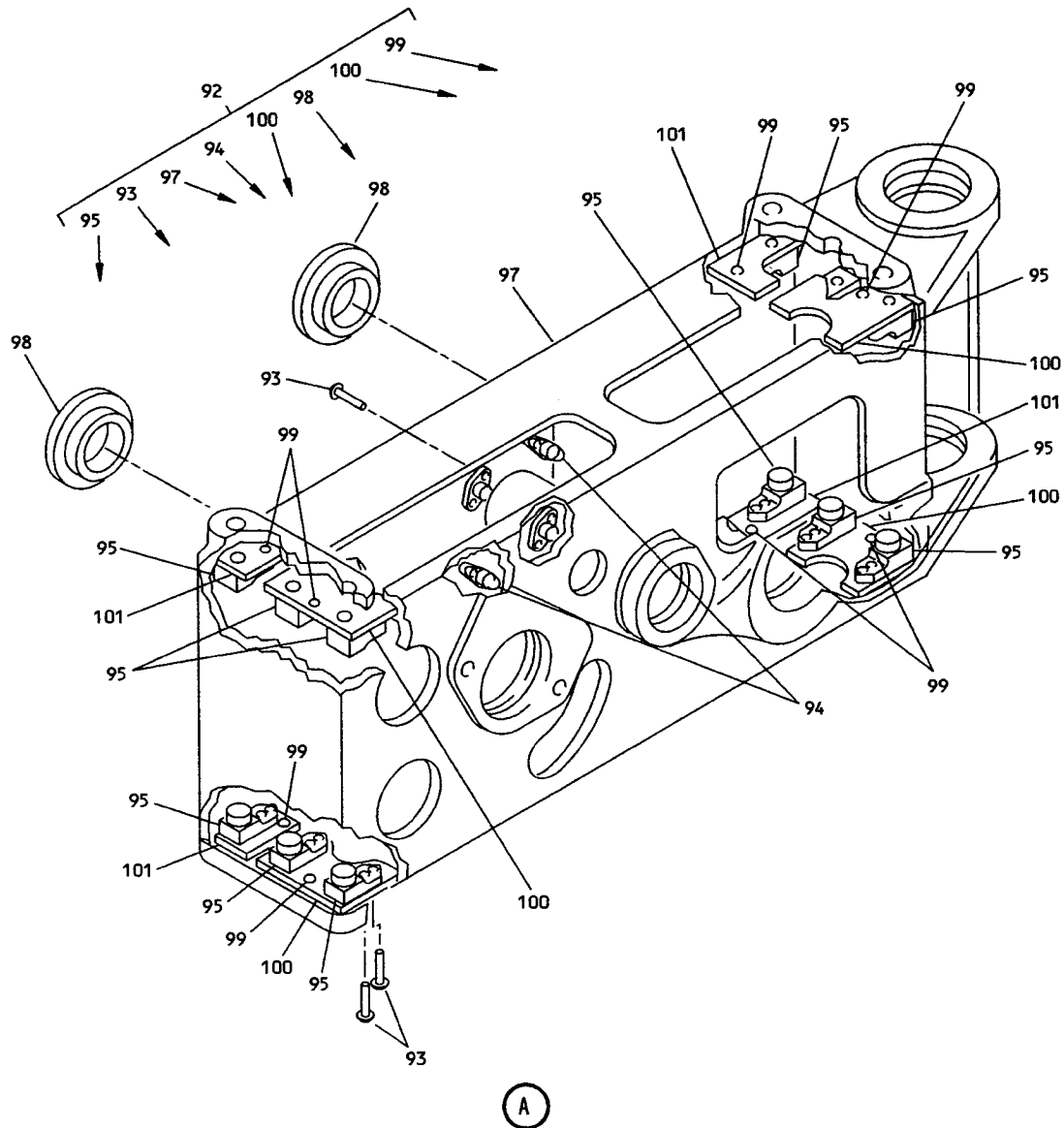
| *[5] LOWER LATCH ASSY 65C33403-38 KIT HAS: TORQUE TUBE 60-4406-14; CRANKS 66-14531-10, 66-14531-9, 69-37418-501, WASHERS AN960C10L; BOLTS BACB30NM3K17, BACB30NM3K19; NUTS BACN10YR3CD.



Aft Entry Door Handle Mechanism
 Figure 1102 (Sheet 1)



Aft Entry Door Handle Mechanism
Figure 1102 (Sheet 2)



(A)

65-1642-43

Aft Entry Door Handle Mechanism
 Figure 1102 (Sheet 3)

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1102-			AFT ENTRY DOOR HANDLE MECHANISM		
1	NAS1104-18		. BOLT		4
2	NAS1104-17		. BOLT		1
3	NAS1104-19		. BOLT		6
4	NAS1104-20		. BOLT		1
5	AN960PD416		. WASHER		12
6	65-52873-151		. FILLER		12
7	65-52873-81		. FILLER		4
8	BACS40R07E42		. SHIM		AR
8A	MS24665-283		. PIN, COTTER (USED WITH 60-4455-1) *[1]		1
9	BACN10JC6		. NUT (REPLS NAS679A6)(USED WITH 60-4455) *[1]		1
9A	BACN10JD6		. NUT (USED WITH 60-4455-1,-2,-3)*[1]		1
10	63-9386		. WASHER		1
10A	AN960-616		. WASHER (USED WITH 60-4455-1,-2,-3)*[1]		AR
11	BACN10JC3		. NUT (REPLS NAS679A3W)		4
12	AN960PD10L		. WASHER		4
13	BACB30LH3-13		. BOLT		4
14	90-7879		. HANDLE *[13]*[14]*[15]*[17]*[18]*[19]		1
14	90-7879-1		. HANDLE *[1]*[20]		1
14	90-7879-5		. HANDLE *[1]*[20]		1
14	90-7879-7		. HANDLE *[1]*[20]		1
15	66-24986-1		. SPACER		1
16	90-7811		. CAM		1
17	90-7821		. SLEEVE		1
18	MS39086-111		. PIN		1
19	30-3019		. WASHER *[13]*[1]		1
19	30-3019-1		. WASHER *[13]*[1]		1
19	30-3019-1		. WASHER *[14]*[15]*[17]*[18]*[19]*[20]		1
20	AN996-14		. RING		1
21	30-3010		. NUT		1
22	63-2848		. SPRING		1
23	30-3013-1		. PIN *[13]*[1]		1
23	30-3013-2		. PIN *[13]*[1]		1
23	30-3013-2		. PIN *[14]*[15]*[17]*[18]*[19]*[20]		1
24	60-4455		. SHAFT *[13]*[1]		1
24	60-4455-1		. SHAFT *[13]*[1]*[20]		1
24	60-4455-1		. SHAFT *[14]*[15]*[17]*[18]*[19]		1
24	60-4455-2		. SHAFT (OPT TO 60-4455-1)*[1]*[13]*[20]		1
24	60-4455-2		. SHAFT (OPT TO 60-4455-1)*[14]*[15] *[17] *[18]*[19]		1
24	60-4455-3		. SHAFT *[11]*[20]		1
25	65-51687-1		. PLATE ASSY, CAM (OPT TO 65-51687-4) *[1]*[13]		1
25	65-51687-4		. PLATE ASSY, CAM (OPT TO 65-51687-1) *[1]*[13] (REPLD BY 65-51687-12)		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1102-25	65-51687-4		. PLATE ASSY, CAM *[14]*[15]*[17]*[18]*[19]*[20] (REPLD BY 65-51687-12)		1
25	65-51687-12		. PLATE ASSY, CAM (REPLS 65-51687-4) *[1]*[13]*[14]*[15]*[17]*[18]*[19]*[20]		1
26	MS21209F5-20		. . INSERT		3
27	65-51687-3		. . PLATE, CAM (USED ON 65-51687-1)		1
27	65-51687-5		. . PLATE, CAM (USED ON 65-51687-4)		1
27	65-51687-501		. . PLATE, CAM (USED ON 65-51687-4) (OPT)		1
27	65-51687-13		. . PLATE, CAM (USED ON 65-51687-12)		1
27	65-51687-14		. . PLATE, CAM (USED ON 65-51687-12) (OPT)		1
28	NAS1103-11		. BOLT		4
29	BACS11W3		. WASHER, SEAL		4
30	AN960PD10L		. WASHER		4
31	BACR15CE5D		. RIVET		4
32	66-14542-1		. PLATE, SEAL		1
33	AN6227B28		. PACKING, O-RING (REPLD BY M83461-1-325)		1
33	M83461-1-325		. PACKING, O-RING (REPLS AN6227B28)		1
34	AN6227B17		. PACKING, O-RING (REPLD BY M83461-1-212)		1
34	M83461-1-212		. PACKING, O-RING (REPLS AN6227B17)		1
35	90-7820		. HOUSING ASSY (REPLD BY 69-61511-1) *[1]*[13]		1
35	69-61511-1		. HOUSING ASSY (REPLS 90-7820) *[1]*[13]		1
35	69-61511-1		. HOUSING ASSY *[14]*[15]*[17]*[18]*[19]*[20]		1
36	NAS516-1		. . FITTING, LUBRICATION		1
37	90-7820-1		. . HOUSING, FITTING (USED ON 90-7820)		1
37	69-61511-2		. . HOUSING, FITTING (USED ON 69-61511-1)		1
38	MS24665-360		. PIN, COTTER		2
39	60-4405		. NUT *[1]*[13]		2
39	60-4405-1		. NUT *[1]*[13]		2
39	60-4405-1		. NUT *[14]*[15]*[17]*[18]*[19]*[20]		2
39	60-4405-2		DELETED		2
39	60-4405-2		DELETED		2
40	BACN10JC5		. NUT *[13]*[14]*[15]*[17]*[18]*[19]*[20]		2
40	BACN10YR5CD		. NUT (POST SB 52-1094, R3) *[13]*[14]		2
40	BACN10YR5CD		. NUT (SB 52-1094) *[16]		2
41	AN960PD516L		. WASHER (PRE SB 52-1094, R3) *[13]*[14]		2
41	AN960C516L		. WASHER (POST SB 52-1094, R3) *[13]*[14]		2
41	AN960C516L		. WASHER *[15]*[17]*[18]*[19]*[20]		2

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
1102-42	NAS1105-29		.	BOLT	(PRE	SB	52-1094,	R3)			2
42	BACB30NM5K29		.	BOLT	(POST	SB	52-1094,	R3) *[13]*[14]			2
42	BACB30NM5K29		.	BOLT	*[15]*[17]*[18]*[19]*[20]						2
43	90-6753-7		.	TUBE, TORQUE	*[1]*[13] (PRE	SB	52-1094,	R3)			1
43	90-6753-12		.	TUBE, TORQUE	*[1]*[13] (PRE	SB	52-1094,	R3)			1
43	90-6753-12		.	TUBE, TORQUE	*[14] (PRE	SB	52-1094,	R3))			1
43	90-6753-19		.	TUBE, TORQUE	*[15]*[17]*[18]*[19]*[20]						1
43	90-6753-19		.	TUBE, TORQUE	(POST	SB	52-1094,	R3) *[13]*[14]			1
44	BACN10JC5		.	NUT	(REPLS	NAS679A5)					1
45	AN960PD516L		.	WASHER							2
46	NAS1105-16		.	BOLT							1
47	NAS1105-12		.	BOLT							1
48	69-39176-3		.	ROD ASSY							1
49	MS20615-5M10		.	RIVET							1
50	AN316-6R		.	NUT							1
51	77253		.	BEARING, V09455	(BOEING	10-60779-112)					2
51	TFM5C		.	BEARING, V77896	(BOEING	10-60779-112)					2
51	DREM5-019		.	BEARING, V81376	(BOEING	10-60779-112)					2
51	REM10ATC12-2		.	BEARING, V86174	(BOEING	10-60779-112)					2
52	69-39176-4		.	ROD							1
53	69-17330-2		.	CRANK (PRE	SB	52-1094,	R3) *[13]*[14]				1
53	69-17330-4		.	CRANK (POST	SB	52-1094,	R3) *[13]*[14]				1
53	69-17330-4		.	CRANK	*[15]*[17]*[18]*[19]*[20]						1
54	BACN10JC4		.	NUT	(REPLS	NAS679A4W)					2
55	AN960PD416L		.	WASHER							2
56	63-1692		.	WASHER							2
57	NAS1104-5		.	BOLT							1
58	NAS1104-6		.	BOLT							1
59	65-54024-6		.	CRANK ASSY	*[1]*[13] (OPT	65-1933-4)					1
59	65-1933-4		.	CRANK ASSY	*[1]*[14]						1
59	65-1933-4		.	CRANK ASSY	*[1]*[13] (OPT	65-54024-6)					1
59	65-1933-7		.	CRANK ASSY	*[1]*[13]*[14] (OPT	65-1933-12)					1
59	65-1933-12		.	CRANK ASSY	*[1]*[13]*[14] (OPT	65-1933-7)					1
59	65-1933-17		.	CRANK ASSY	*[1]*[20]						1
59	65-1933-19		.	CRANK ASSY	*[1]*[20] (OPT	TO	65-1933-21)				1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1102-59	65-1933-21		. CRANK ASSY *[1]*[20] (OPT TO 65-1933-19)		1
59	65-1933-507		. CRANK ASSY *[1]*[13]*[14]*[20]		1
59	65-1933-507		. CRANK ASSY *[15]*[18]*[17]*[19]		1
60	BACR15BA4D		. . RIVET		2
61	BACN10AM5C5		. . NUTPLATE *[4]*[5]		1
61	BACN10JP5C		. . NUTPLATE (OPT TO BACN10JP5CCM) *[6]*[7]*[8]		1
61	BACN10JP5C		. . NUTPLATE (OPT TO BACN10JP5CCD) *[24]		1
61	BACN10JP5CCD		. . NUTPLATE (OPT TO BACN10JP5C) *[24]		1
61	BACN10JP5CCD		. . NUTPLATE *[25]*[26]		1
61	BACN10JP5CCM		. . NUTPLATE (BACN10JP5C OPT) *[6] *[7]*[8]		1
62	65-54024-7		. . CRANK *[4]		1
62	65-1933-5		. . CRANK *[5]		1
62	65-1933-9		. . CRANK *[6]		1
62	65-1933-14		. . CRANK *[7]		1
62	65-1933-18		. . CRANK *[24]		1
62	65-1933-20		. . CRANK *[25]		1
62	65-1933-22		. . CRANK *[26]		1
62	65-1933-508		. . CRANK *[8]		1
63	65-8795-801		. SPACER		1
64	65-54013		. CRANK ASSY *[1]*[13]		1
64	65-54013-503		. CRANK ASSY *[1]*[13] (OPT 65-54013)		1
64	65-54013-503		. CRANK ASSY *[14]*[15]*[17]*[18]*[19]*[20]		1
65	BACR15BA4D		. . RIVET (REPLS MS20426D4)		4
66	BACN10JP4C		. . NUTPLATE (REPLS NAS698A4)		2
67	65-54013-2		. . CRANK (USED ON 65-54013)		1
67	65-54013-502		. . CRANK (USED ON 65-54013-503)		1
68	69-38733-1		. CRANK ASSY (90-7815-1 OPT) *[1]*[13]		1
68	90-7815-1		. CRANK ASSY (OPT TO 69-38733-1) *[1]*[13]		1
68	90-7815-1		. CRANK ASSY *[1]*[14]*[20]*[23]		1
68	90-7815-1		. CRANK ASSY *[15]*[17]*[18]*[19]		1
68	90-7815-1		. CRANK ASSY *[1]*[13]*[14]		1
68	90-7815-15		DELETED		
68	90-7815-17		DELETED		
68	90-7815-24		DELETED		
68	90-7815-26		DELETED		
68	90-7815-32		. CRANK ASSY *[1]*[20]		1
69	MS24665-283		. . PIN, COTTER *[9]*[23]		1
69	AN380-3-3		. . PIN, COTTER *[10]		1
70	BACN10JD106		. . NUT (REPLS AN320-6) *[10]		1
70	BACN10JD106		. . NUT (REPLS AN320-6) *[2]		1
70	BACN10JD6		. . NUT (REPLS AN310-6) *[3]		1

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		
1102-70	BACN10JD106		DELETED								
70	BACN10JD106ASU		. . NUT *[23]								1
71	AN960PD616L		. . WASHER *[3]								4
71	AN960PD616L		. . WASHER *[2]								2
71	AN960-616L		. . WASHER *[10]								4
71	AN960XC616L		DELETED								
71	NAS1149C0632B		. . WASHER *[23]								1
71A	AN960PD616		. . WASHER *[9]								1
71B	AN960-616L		. . WASHER *[10]								1
71C	AN960-616L		. . WASHER *[10]								*[28]
71C	NAS1149C0632B		. . WASHER *[23]								*[28]
72	BACB10BH60F9		. . BEARING (BACB10BH60F8 OPT)*[9]								1
72	BACB10BH60F8		. . BEARING (OPT TO BACB10BH60F9)*[9]								1
72	BACB10BH60CF6		. . BEARING (BACB10AF6F3H, BACB10AF6F6H OPT)*[10]								1
72	BACB10AF6F3H		. . BEARING (OPT TO BACB10BH60CF6)*[10]								1
72	BACB10AF6F6H		. . BEARING (OPT TO BACB10BH60CF6)*[10]								1
72	BACB10FK6F6HS		DELETED								
72	KRP141500VT6-6		. . BEARING *[23] (V50632)								1
73	69-38733-2		. . CRANK *[9]								1
73	90-7815-3		. . CRANK *[10]								1
73	90-7815-19		DELETED								
73	90-7815-21		DELETED								
73	90-7815-33		. . CRANK *[23]								1
74	69-38733-1		. CRANK ASSY (OPT TO 90-7815-1) *[1]*[13]								1
74	90-7815-1		. CRANK ASSY (OPT TO 69-38733-1) *[1]*[13]								1
74	90-7815-1		. CRANK ASSY *[1]*[14]								1
74	90-7815-15		. CRANK ASSY (OPT TO 90-7815-17) *[15] *[17]*[18]*[19]								1
74	90-7815-15		. CRANK ASSY (OPT TO 90-7815-17)*[1] *[13]*[14]*[20]*[23]								1
74	90-7815-17		. CRANK ASSY (OPT TO 90-7815-15) *[15] *[17]*[18]*[19]								1
74	90-7815-17		. CRANK ASSY (90-7815-15 OPT)*[1]*[13] *[14]*[20]*[23]								1
74	90-7815-23		. CRANK ASSY *[1]*[20] (OPT TO 90-7815-25)								1
74	90-7815-25		. CRANK ASSY *[1]*[20] (OPT TO 90-7815-23)								1
75	MS24665-283		. . PIN, COTTER *[11]*[12]*[21]*[22]								1
75	AN380-3-3		. . PIN, COTTER *[10]								1
76	BACN10JD106		. . NUT (REPLS NAS320-6)*[10]								1
76	BACN10JD6		. . NUT (REPLS AN310-6) *[3]								1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
1102-											
76	BACN10JD106		.	.					NUT (REPLS AN320-6) *[2]		1
76	BACN10JD106		.	.					NUT *[11]*[12]		1
76	BACN10JD106ASU		.	.					NUT *[21]*[22]		1
77	AN960PD616		.	.					WASHER *[9]		1
77A	AN960-616L		.	.					WASHER *[10]		*[28]
77A	AN960XC616L		.	.					WASHER *[11]*[12]		*[28]
77A	NAS1149C0632B		.	.					WASHER *[21]*[22]		*[28]
78	AN960PD616L		.	.					WASHER *[3]		4
78	AN960PD616L		.	.					WASHER *[2]		2
78	AN960-616L		.	.					WASHER *[10]		1
78	AN960XC616L		.	.					WASHER *[11]*[12]		1
78A	NAS1149C0632B		.	.					WASHER *[21]*[22]		1
79	BACB10BH60F9		.	.					BEARING (BACB10BH60F8 OPT) *[9]		1
79	BACB10BH60F8		.	.					BEARING (OPT TO BACB10BH60F9) *[9]		1
79	BACB10BH60CF6		.	.					BEARING (BACB10AF6F3H, BACB10AF6F6H OPT) *[10]		1
79	BACB10AF6F3H		.	.					BEARING (OPT TO BACB10BH60CF6) *[10]		1
79	BACB10AF6F6H		.	.					BEARING (OPT TO BACB10BH60CF6) *[10]		1
79	BACB10FK6F6HS		.	.					BEARING *[11] *[12]		1
79	KRP141500VT6-6		.	.					BEARING *[21]*[22] (V50632)		1
80	69-38733-2		.	.					CRANK *[9]		1
80	90-7815-3		.	.					CRANK *[10]		1
80	90-7815-19		.	.					CRANK *[11]		1
80	90-7815-21		.	.					CRANK *[12]		1
80	90-7815-27		.	.					CRANK *[21]		1
80	90-7815-29		.	.					CRANK *[22]		1
81	BACN10JC3		.						NUT (REPLS NAS679A3W)		4
82	NAS1197-10		.						WASHER		4
83	NAS1103-10		.						BOLT		3
84	BACB30LU3-10		.						BOLT (REPL NAS333CPA10)		1
85	63-1059		.						RETAINER *[13]*[14]*[15]*[17]*[18]*[19]		2
85	63-1059		.						RETAINER *[1]*[20]		2
85	69B10068-3		.						RETAINER *[1]*[20]		2
86	BACB10FV23		.						BEARING *[1]*[20]		2
86	BACB10BW21		.						BEARING (REPLS BACB10A822, AN202KP21B) *[13]*[14]*[15]*[17]*[18] *[19]		2
86	BACB10BW21		.						BEARING (REPLS AN202KP21B) *[1]*[20]		2
87	BACB10FV23		.						BEARING *[1]*[20]		2
87	BACB10BW23		.						BEARING (REPLS BACB10A823, AN202KP23B) *[13]*[14]*[15]*[17]*[18] *[19]		2
87	BACB10BW23		.						BEARING (REPLS AN202KP21B) *[1]*[20]		2
88	BACW10P148AL		.						WASHER		1

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			
1102-89	MS16625-1162		.	R	I	N	G				1	
90	BACB10BX12		.	B	E	A	R	I	N	G (REPLS BACB10A685, AN201KP12A) (REPLD BY BACB10FS12J)	1	
90	BACB10FS12J		.	B	E	A	R	I	N	G (REPLS BACB10BX12J, BACB10BX12)	1	
91	BACB10BW25		.	B	E	A	R	I	N	G (PRE SB 52-1094R2, R3) (REPLS BACB10A824, MS20202KP25B, AN202KP25B) *[13]*[14]	2	
91	PACMKP25BA3908		DELETED									
91	BACB10FR25		.	B	E	A	R	I	N	G *[15]*[18]*[19]*[20]*[29]	2	
91	BACB10FR25		.	B	E	A	R	I	N	G *[27]	2	
91	BACB10FR25		.	B	E	A	R	I	N	G (POST SB 52-1094, R3) *[13] *[14]*[27]	2	
91	BACB10BW25		.	B	E	A	R	I	N	G *[1]*[27] (PRE SB 52-1094R2, R3)	2	
92	65-1642-14		.	H	O	U	S	I	N	G ASSY *[1]*[13]	1	
92	65-1642-29		.	H	O	U	S	I	N	G ASSY *[1]*[13]*[20]	1	
92	65-1642-29		.	H	O	U	S	I	N	G ASSY *[14]*[15]*[17]*[18]*[19]	1	
92	65-1642-43		.	H	O	U	S	I	N	G ASSY *[20]	1	
93	BACR15BA3B		.	.	R	I	V	E	T (REPLS MS20426B3) (USED ON 65-1642-14, 29)	32		
93	BACR15DR3AC		.	.	R	I	V	E	T (OPT) (USED ON 65-1642-14, -29)	32		
93	MS20605H3		.	.	R	I	V	E	T (OPT) (USED ON 65-1642-14, -29)	32		
93	BACR15BA3AD		.	.	R	I	V	E	T (USED ON 65-1642-43)	32		
94	BACN10JR3		.	.	N	U	T	P	L	A	T (REPLS NAS680A3) (USED ON 65-1642-14, 29)	4
94	BACN10JP3ACD		.	.	N	U	T	P	L	A	T (USED ON 65-1642-43)	4
95	BACN10KB4F		.	.	N	U	T	P	L	A	T (REPLS NAS687A4) (USED ON 65-1642-14, 29) (REPLD BY BACN10KE4E4, NAS1792A4-4)	12
95	BACN10KE4E4		.	.	N	U	T	P	L	A	T (USED ON 65-1642-14, -29) (REPLS BACN10KB4F) (OPT TO NAS1792A4-4)	12
95	NAS1792A4-4		.	.	N	U	T	P	L	A	T (USED ON 65-1642-14, -29) (REPLS BACN10KB4F) (OPT TO BACN10KE4E4)	12
95	BACN10JA4CD		.	.	N	U	T	P	L	A	T (USED ON 65-1642-43)	12
96	NAS463YD416		.	.	S	H	I	M (USED ON 65-1642-14, 29)			12	
97	65-1642-15		.	.	H	O	U	S	I	N	G (USED ON 65-1642-14)	1
97	65-1642-30		DELETED									
97	65-1642-33		.	.	H	O	U	S	I	N	G (USED ON 65-1642-29)	1
97	65-1642-45		.	.	H	O	U	S	I	N	G (USED ON 65-1642-43)	1
98	65C36793-1		.	.	B	U	S	H	I	N	G (USED ON 65-1642-43)	2

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
1102-99	BACR15GF5D		.	.					RIVET (USED ON 65-1642-43)		8
100	69-78694-3		.	.					FILLER (USED ON 65-1642-43)		4
101	69-78694-4		.	.					FILLER (USED ON 65-1642-43)		4

- I
- *[1] LIMITED
 - *[2] USED ON 69-38733-1 WITH BEARING BACB10BH60F8
 - *[3] USED ON 69-38733-1 WITH BEARING BACB10BH60F9
 - *[4] USED ON 65-54024-6
 - *[5] USED ON 65-1933-4
 - *[6] USED ON 65-1933-7
 - *[7] USED ON 65-1933-12
 - *[8] USED ON 65-1933-507
 - *[9] USED ON 69-38733-1
 - *[10] USED ON 90-7815-1
 - *[11] USED ON 90-7815-15
 - *[12] USED ON 90-7815-17
 - *[13] USED ON 65-52873-2
 - *[14] USED ON 65-52873-159
 - *[15] USED ON 65-52873-176, -177
 - *[16] NOT USED ON ALL POST SERVICE BULLETIN CONFIGURATIONS
 - *[17] USED ON 65-52873-567
 - *[18] USED ON 65-52873-167, -168
 - *[19] USED ON 65-52873-180
 - *[20] USED ON 65-52873-189
 - *[21] USED ON 90-7815-23
 - *[22] USED ON 90-7815-25
 - *[23] USED ON 90-7815-32
 - *[24] USED ON 65-1933-17
 - *[25] USED ON 65-1933-19
 - *[26] USED ON 65-1933-21
 - *[27] USED ON 65-52873-168
 - *[28] USE A MAXIMUM OF 5 WASHERS IN ANY COMBINATION TO GET THE CORRECT NUT TORQUE AND COTTER PIN INSTALLATION
 - *[29] USED ON 65-52873-167

VENDORS

V09455	RBC TRANSPORT DYNAMICS CORP., 3131 W. SEGERSTROM AVE., SANTA ANA, CALIFORNIA 92704-5872
V21335	TIMKEN US CORP., 59 FIELD ST., TORRINGTON, CONNECTICUT 06790-1008
V50632	KAMATICS CORP., SUB OF KAMAN CORP., 1335 BLUE HILLS RD., BLOOMFIELD, CONNECTICUT 06002-1303
V71985	DOW-ELCO, INC., 1313 W. OLYMPIC BLVD., MONTEBELLO, CALIFORNIA 90640-5010
V75345	KIRK HILL RUBBER CO., 300 E. CYPRESS ST., BREA, CALIFORNIA 92821-4097
V76005	LORD CORP., 1635 W. 12 TH ST., ERIE, PENNSYLVANIA 16514-0039
V77896	REXNORD, INC., BEARING OPERATION, 2400 CURTISS ST., DOWNER'S GROVE, ILLINOIS 60515-0722
V81376	SOUTHWEST PRODUCTS CO., 2240 BUENA VISTA, IRVINDALE, CALIFORNIA 91010-3318
V94222	SOUTHCO, INC., 210 BRINTON LAKE RD., P.O. BOX 0116, CONCORDVILLE, PENNSYLVANIA 19331-0116
V97393	SHUR-LOK CORP., 2541 WHITE RD., P.O. BOX 19584, IRVINE, CALIFORNIA 92623-9584

Part No.	Fig. and Index No.	Qty. per Assy.	Part No.	Fig. and Index No.	Qty. per Assy.
AN316-5R	1101-119	1	AN960PD416	1101-110	4
AN316-5R	1101-124	2	AN960PD416	1101-232	AR
AN316-5R	1101-129	2	AN960PD416	1101-243	AR
AN316-5R	1101-129	2	AN960PD416	1102-5	12
AN316-5R	1101-134	2	AN960PD416L	1101-115	2
AN316-6R	1102-50	1	AN960PD416L	1101-232	AR
AN380-3-3	1102-69	1	AN960PD416L	1101-243	AR
AN380-3-3	1102-75	1	AN960PD416L	1102-55	2
AN6227-19	1101-214	2	AN960PD516L	1101-172	AR
AN6227B17	1102-34	1	AN960PD516L	1102-41	2
AN6227B19	1101-214	2	AN960PD516L	1102-45	2
AN6227B28	1102-33	1	AN960PD616	1102-71A	1
AN960-10L	1101-166	8	AN960PD616	1102-77	1
AN960-10L	1101-175	8	AN960PD616L	1102-71	4
AN960-1716	1101-213	2	AN960PD616L	1102-71	2
AN960-4	1101-47	12	AN960PD616L	1102-78	AR
AN960-416	1101-205	8	AN960PD616L	1102-78	AR
AN960-516L	1101-272	1	AN960XC616L	1102-71	
AN960-616	1102-10A	AR	AN960XC616L	1102-77A	AR
AN960-616L	1102-71	4	AN960XC616L	1102-78	4
AN960-616L	1102-78	4	AN996-14	1102-20	1
AN960-616L	1102-77A	AR	BACB10A187L	1101-118	1
AN960C10L	1101-166	8	BACB10A187L	1101-118A	1
AN960C10L	1101-166	8	BACB10A187L	1101-123	1
AN960C10L	1101-175	8	BACB10A187L	1101-123A	1
AN960C10L	1101-175	8	BACB10A187L	1101-128	2
AN960C1716L	1101-213	2	BACB10A187L	1101-128A	1
AN960C416L	1101-205	8	BACB10A187L	1101-133	1
AN960C516L	1102-41	2	BACB10A187L	1101-133A	1
AN960D10	1101-197	8	BACB10A187M2L	1101-118	1
AN960D10	1101-44	3	BACB10A397G-CM2	1101-203	8
AN960D416	1101-3	4	BACB10AF5F9H	1101-173	4
AN960D416L	1101-4B	4	BACB10AF6F3H	1102-72	1
AN960PD10	1101-183	16	BACB10AF6F3H	1102-79	1
AN960PD10	1101-198	8	BACB10AF6F6H	1102-72	1
AN960PD10	1101-219	1	BACB10AF6F6H	1102-79	1
AN960PD10	1101-226	28	BACB10BH59F7	1101-173	4
AN960PD10	1101-32	8	BACB10BH60CF6	1102-72	1
AN960PD10L	1101-137B	9	BACB10BH60CF6	1102-79	1
AN960PD10L	1101-137B	9	BACB10BH60F8	1102-72	1
AN960PD10L	1101-138B	9	BACB10BH60F8	1102-79	1
AN960PD10L	1101-138B	9	BACB10BH60F9	1102-72	1
AN960PD10L	1101-210	4	BACB10BH60F9	1102-79	1
AN960PD10L	1101-234	2	BACB10BW21	1102-86	2
AN960PD10L	1101-245	2	BACB10BW23	1102-87	2
AN960PD10L	1101-269	3	BACB10BW25	1102-91	2
AN960PD10L	1101-37	40	BACB10BW25	1102-91	2
AN960PD10L	1102-12	4	BACB10BX12	1102-90	1
AN960PD10L	1102-30	4	BACB10FK6F6HS	1102-72	

Part No.	Fig. and Index No.	Qty. per Assy.	Part No.	Fig. and Index No.	Qty. per Assy.
BACB10FK6F6HS	1102-79	1	BACN10JC5	1102-40	2
BACB10FR25	1102-91	2	BACN10JC5	1102-44	1
BACB10FR25	1102-91	2	BACN10JC6	1102-9	1
BACB10FV23	1102-86	2	BACN10JD105	1101-171	4
BACB10FV23	1102-87	2	BACN10JD106	1102-70	1
BACB10S12J	1102-90	1	BACN10JD106	1102-70	1
BACB10WBW21	1102-86	2	BACN10JD106	1102-70	1
BACB10WBW23	1102-87	2	BACN10JD106	1102-76	1
BACB10Y4	1101-118A	1	BACN10JD106	1102-76	1
BACB10Y4	1101-118A	1	BACN10JD106	1102-76	1
BACB10Y4	1101-123A	1	BACN10JD106ASU	1102-70	1
BACB10Y4	1101-128A	1	BACN10JD106ASU	1102-76	1
BACB10Y4	1101-133A	1	BACN10JD6	1102-70	1
BACB30EL3-6	1101-184	16	BACN10JD6	1102-76	1
BACB30LH3-10	1101-262	1	BACN10JP3ACD	1102-94	4
BACB30LH3-13	1102-13	4	BACN10JP4C	1102-66	2
BACB30LH3-2	1101-256	1	BACN10JP5C	1102-61	1
BACB30LH3-3	1101-257	1	BACN10JP5CCD	1102-61	1
BACB30LH3-3	1101-261	1	BACN10JP5CCM	1102-61	1
BACB30LU3-10	1102-84	1	BACN10JR3	1101-30	20
BACB30LU3-4	1101-137	9	BACN10JR3	1102-94	4
BACB30NE3-12	1101-209	4	BACN10JR3F	1101-14	3
BACB30NE3-3	1101-10	12	BACN10JR3F	1101-149	18
BACB30NE3-3	1101-16	5	BACN10JR3F	1101-21	3
BACB30NE3-3	1101-43	3	BACN10JR3F	1101-24	5
BACB30NE3-9	1101-26	20	BACN10JR3F	1101-6	4
BACB30NM3K17	1101-167	8	BACN10JR3F	1101-69	1
BACB30NM3K17	1101-167	8	BACN10JZ3A2	1101-149	18
BACB30NM3K17	1101-176	8	BACN10JZ3A2	1101-29	8
BACB30NM3K19	1101-176	8	BACN10KB3	1101-237	2
BACB30NM4K26	1101-206	8	BACN10KB3	1101-248	2
BACB30NM5K29	1102-42	2	BACN10KB3F	1101-15	6
BACN10AM5C5	1102-61	1	BACN10KB3F	1101-68	2
BACN10JA4CD	1102-95	12	BACN10KB4	1101-236	2
BACN10JC04	1101-46	6	BACN10KB4	1101-247	2
BACN10JC3	1101-165	8	BACN10KB4F	1102-95	12
BACN10JC3	1101-174	8	BACN10KE3D	1101-41	40
BACN10JC3	1101-182	16	BACN10KE4E4	1102-95	12
BACN10JC3	1101-196	16	BACN10KF3	1101-41	40
BACN10JC3	1101-218	1	BACN10MK3-45	1101-58	3
BACN10JC3	1101-225	28	BACN10TL3-3	1101-6	4
BACN10JC3	1101-31	8	BACN10YG3-45	1101-58	3
BACN10JC3	1101-41	40	BACN10YR3CD	1101-165	8
BACN10JC3	1102-11	4	BACN10YR3CD	1101-165	8
BACN10JC3	1102-81	4	BACN10YR3CD	1101-174	8
BACN10JC4	1101-109	6	BACN10YR3CD	1101-174	8
BACN10JC4	1101-204	8	BACN10YR4CD	1101-204	8
BACN10JC4	1102-54	2	BACN10CJD6	1102-9A	1
BACN10JC5	1101-271	1	BACN10YR5CD	1102-40	2

Part No.	Fig. and Index No.	Qty. per Assy.	Part No.	Fig. and Index No.	Qty. per Assy.
BACR12AG	1101-4	4	J7444-11	1101-9	2
BACR12AG2C	1101-4A	4	KRP141500VT5-8	1101-274	1
BACR15BA3AD	1102-93	32	KRP141500VT5-9	1101-173	4
BACR15BA3D	1102-93	32	KRP141500VT6-6	1102-72	1
BACR15BA3D	1101-13	18	KRP141500VT6-6	1102-79	1
BACR15BA3D	1101-148	36	MS15001-4	1101-201	1
BACR15BA3D	1101-20	6	MS16562-1	1101-150	4
BACR15BA3D	1101-23	10	MS16562-209	1101-152A	2
BACR15BA3D	1101-235	8	MS16562-209	1101-158A	2
BACR15BA3D	1101-246	8	MS16625-1162	1102-89	1
BACR15BA3D	1101-28	56	MS20253-2-2870	1101-152	1
BACR15BA3D	1101-40	80	MS20253-2-2885	1101-158	1
BACR15BA3D	1101-5	8	MS20253P2-2880	1101-158	1
BACR15BA3D	1101-67	6	MS20605H3	1102-95	12
BACR15BA4D	1101-57	6	MS20615-5M10	1102-49	1
BACR15BA4D	1102-60	2	MS21209F1-15	1101-216	4
BACR15BA4D	1102-65	4	MS21209F1-15	1101-223	4
BACR15BB3AD	1101-5A	8	MS21209F5-20	1102-26	3
BACR15BB3D	1101-125	1	MS24665-134	1101-170	4
BACR15BB3D	1101-130	1	MS24665-283	1102-69	1
BACR15BB3D	1101-135	1	MS24665-283	1102-75	1
BACR15BB4D	1101-18	4	MS24665-283	1102-8A	1
BACR15BB4D	1101-8	4	MS24665-360	1102-38	2
BACR15BB5D	1101-120	1	MS27253F1	1101-252	1
BACR15CE5D	1101-153	9	MS28775-214	1101-214	2
BACR15CE5D	1101-159	9	MS39086-111	1102-18	1
BACR15CE5D	1102-31	4	M83461-1-214	1101-214	2
BACR15CE6D	1101-65	2	M83461-1-325	1102-33	1
BACR15DR3AC	1102-93	32	M83461-1-212	1102-34	1
BACR15GF5D	1102-99	8	NAS1103-1	1101-167	8
BACS11W3	1101-229	28	NAS1103-10	1101-233	2
BACS11W3	1102-29	4	NAS1103-10	1101-244	2
BACS21AP180R	1101-2	4	NAS1103-10	1101-268	2
BACS21AP180RP	1101-2A		NAS1103-10	1102-83	3
BACS21AP220RP	1101-2A	4	NAS1103-11	1102-28	4
BACS40A12-12	1101-50	AR	NAS1103-18	1101-176	8
BACS40B12-12	1101-51	AR	NAS1103-2	1101-34	16
BACS40P8E11	1101-59	AR	NAS1103-3	1101-199	16
BACS40R007B011	1101-59	AR	NAS1103-3	1101-227	23
BACS40R007C011	1101-59	AR	NAS1103-3	1101-35	16
BACS40R05E08	1101-264	2	NAS1103-4	1101-228	5
BACS40R06E08	1101-259	1	NAS1103-4	1101-36	8
BACS40R07E16	1101-265	2	NAS1103-5	1101-267	1
BACS40R07E42	1102-8	AR	NAS1104-10	1101-231	2
BACS40R08E16	1101-260	1	NAS1104-10	1101-242	2
BACW10BN3AP	1101-26A	28	NAS1104-12	1101-114	2
BACW10P148AL	1102-88	1	NAS1104-13	1101-112	4
DE575	1101-19	2	NAS1104-17	1102-2	1
DE586	1101-9	2	NAS1104-18	1101-113	2
DREM5-019	1102-51	2			

Part No.	Fig. and Index No.	Qty. per Assy.
NAS1104-18	1102-1	4
NAS1104-19	1102-3	6
NAS1104-20	1102-4	1
NAS1104-25	1101-206	8
NAS1104-5	1102-57	1
NAS1104-6	1102-58	1
NAS1105-12	1102-47	1
NAS1105-16	1102-46	1
NAS1105-29	1102-42	2
NAS1149C0632B	1102-71	1
NAS1149C0632B	1102-77	1
NAS1149C0632B	1102-77A	AR
NAS1197-10	1102-82	4
NAS1197-416L	1101-111	4
NAS1792A4-4	1102-95	12
NAS43HT5-23	1101-273	1
NAS463YD416	1102-96	12
NAS514P1032-9	1101-256	1
NAS514P1032-9	1101-257	1
NAS514P1032-9	1101-261	1
NAS514P1032-15	1101-262	1
NAS516-1	1101-188	1
NAS516-1	1101-191	1
NAS516-1	1101-194	1
NAS516-1	1101-201	1
NAS516-1	1102-36	1
NAS516-1A	1101-188	1
NAS516-1A	1101-191	1
NAS516-1A	1101-194	1
NAS583-2	1101-33	8
NAS583-4	1101-138	9
NAS600-8P	1101-48	6
NAS603-9P	1101-25	8
NAS623-3-10	1101-220	1
NAS623-3-2	1101-137A	9
NAS623-3-2	1101-137A	9
NAS623-3-2	1101-138A	9
NAS623-3-2	1101-138A	9
NAS6603-3	1101-25	8
NAS6603-3	1101-26	20
NAS6703-19	1101-167	8
NAS6703-19	1101-176	8
NAS74A4E006P	1101-116	2
NAS76A16-016P	1101-239	1
NAS76A16-016P	1101-250	1
NAS77A4-23P	1101-140	1
NAS77A4-23P	1101-143	1
PACMKP25BA3908	1102-91	
REM10ATC12-2	1102-51	2

Part No.	Fig. and Index No.	Qty. per Assy.
S14162-5	1101-64	1
SL1737	1101-19	2
SL25209	1101-9	2
TFM5C	1102-51	2
30-3004	1101-169	AR
30-3010	1102-21	1
30-3013-1	1102-23	1
30-3013-2	1102-23	1
30-3013-2	1102-23	1
30-3019	1102-19	1
30-3019-1	1102-19	1
30-3019-1	1102-19	1
60-4365	1101-207	1
60-4365-1	1101-207	1
60-4365-1	1101-207	1
60-4365-3	1101-207	1
60-4405	1102-39	2
60-4405-1	1102-39	2
60-4405-1	1102-39	2
60-4405-2	1102-39	2
60-4405-2	1102-39	2
60-4406-13	1101-180	1
60-4406-14	1101-181	1
60-4406-7	1101-180	1
60-4406-8	1101-181	1
60-4455	1102-24	1
60-4455-1	1102-24	1
60-4455-1	1102-24	1
60-4455-2	1102-24	1
60-4455-2	1102-24	1
60-4455-3	1102-24	1
63-1059	1102-85	2
63-1478	1101-49	3
63-1692	1102-56	2
63-2848	1102-22	1
63-9386	1102-10	1
65-12688-5	1101-74	20
65-1642-14	1102-92	1
65-1642-15	1102-97	1
65-1642-29	1102-92	1
65-1642-29	1102-92	1
65-1642-30	1102-97	
65-1642-33	1102-97	1
65-1642-43	1102-92	1
65-1642-45	1102-97	1
65-1933-12	1102-59	1
65-1933-12	1102-59	1
65-1933-14	1102-62	1
65-1933-17	1102-59	1

Part No.	Fig. and Index No.	Qty. per Assy.	Part No.	Fig. and Index No.	Qty. per Assy.
65-1933-18	1102-62	1	65-49560-1	1101-187	2
65-1933-19	1102-59	1	65-49560-10	1101-189	1
65-1933-20	1102-62	1	65-49560-11	1101-190	1
65-1933-21	1102-59	1	65-49560-12	1101-192	1
65-1933-22	1102-62	1	65-49560-13	1101-193	1
65-1933-4	1102-59	1	65-49560-14	1101-195	1
65-1933-4	1102-59	1	65-49560-15	1101-187	2
65-1933-5	1102-62	1	65-49560-16	1101-189	1
65-1933-507	1102-59	1	65-49560-17	1101-193	1
65-1933-507	1102-59	1	65-49560-18	1101-195	1
65-1933-507	1102-59	1	65-49560-19	1101-190	1
65-1933-508	1102-62	1	65-49560-2	1101-189	1
65-1933-7	1102-59	1	65-49560-20	1101-192	1
65-1933-7	1102-59	1	65-49560-4	1101-190	1
65-1933-9	1102-62	1	65-49560-4	1101-190	1
65-2306	1101-200	4	65-49560-5	1101-193	1
65-2306-1	1101-202	1	65-49560-5	1101-193	1
65-2306-3	1101-200	4	65-49560-6	1101-192	1
65-2306-3	1101-200	4	65-49560-7	1101-195	1
65-2306-4	1101-202	1	65-49560-9	1101-187	2
65-2863-3	1101-45	1	65-49890-10	1101-81	1
65-28925-45	1101-132	1	65-49890-2	1101-79	1
65-28925-46	1101-127	1	65-49890-4	1101-81	1
65-28925-47	1101-136	1	65-49890-8	1101-79	1
65-28925-48	1101-131	1	65-51687-1	1102-25	1
65-28925-57	1101-122	1	65-51687-12	1102-25	1
65-28925-58	1101-126	1	65-51687-13	1102-27	1
65-28925-85	1101-132	1	65-51687-14	1102-27	1
65-28925-85	1101-132	1	65-51687-3	1102-27	1
65-28925-86	1101-127	1	65-51687-4	1102-25	1
65-28925-86	1101-127	1	65-51687-4	1102-25	1
65-28925-87	1101-122	1	65-51687-5	1102-27	1
65-28925-87	1101-122	1	65-51687-501	1102-27	1
65-45851-10	1101-96	1	65-52855-507	1101-155	1
65-45851-12	1101-99	1	65-52855-509	1101-161	1
65-45851-14	1101-102	1	65-52873-102	1101-266	1
65-45851-16	1101-105	1	65-52873-103	1101-258	1
65-45851-2	1101-94	1	65-52873-104	1101-263	1
65-45851-4	1101-97	1	65-52873-107	1101-151	1
65-45851-6	1101-100	1	65-52873-108	1101-157	1
65-45851-8	1101-103	1	65-52873-123	1101-154	1
65-45852-2	1101-73	1	65-52873-124	1101-163	1
65-45852-4	1101-75	1	65-52873-125	1101-160	1
65-45852-502	1101-73	1	65-52873-126	1101-164	1
65-45852-502	1101-73	1	65-52873-151	1102-6	12
65-45852-504	1101-75	1	65-52873-159	1101-	RF
65-45852-8	1101-73	1	65-52873-167	1101-	RF
65-45852-10	1101-75	1	65-52873-168	1101-	RF
65-49560-1	1101-187	2	65-52873-176	1101-	RF

Part No.	Fig. and Index No.	Qty. per Assy.
65-52873-177	1101-	
65-52873-178	1101-263	1
65-52873-179	1101-258	1
65-52873-180	1101-	RF
65-52873-182	1101-	RF
65-52873-189	1101-	RF
65-52873-193	1101-12	1
65-52873-2	1101-	RF
65-52873-24	1101-12	2
65-52873-24	1101-27	2
65-52873-32	1101-42	2
65-52873-33	1101-146	1
65-52873-36	1101-11	1
65-52873-37	1101-12	1
65-52873-43	1101-147	1
65-52873-507	1101-63	4
65-52873-509	1101-61	2
65-52873-510	1101-62	2
65-52873-524	1101-221	1
65-52873-525	1101-151	1
65-52873-525	1101-151	1
65-52873-526	1101-157	1
65-52873-526	1101-157	1
65-52873-563	1101-263	1
65-52873-564	1101-258	1
65-52873-567	1101-	RF
65-52873-62	1101-275	2
65-52873-71	1101-156	1
65-52873-72	1101-155	1
65-52873-73	1101-161	1
65-52873-74	1101-162	1
65-52873-81	1102-7	4
65-52980-2	1101-88	1
65-52980-4	1101-90	1
65-52980-6	1101-88	1
65-52980-6	1101-88	1
65-52980-8	1101-90	1
65-52981-10	1101-85	1
65-52981-12	1101-87	1
65-52981-2	1101-85	1
65-52981-4	1101-87	1
65-52981-6	1101-85	1
65-52981-6	1101-85	1
65-52981-8	1101-87	1
65-52982-2	1101-106	1
65-52982-4	1101-108	1
65-52982-6	1101-106	1
65-52982-6	1101-106	1
65-52982-8	1101-108	1

Part No.	Fig. and Index No.	Qty. per Assy.
65-52983-2	1101-70	1
65-52983-4	1101-72	1
65-52983-6	1101-70	1
65-52983-6	1101-70	1
65-52983-8	1101-72	1
65-54013	1102-64	1
65-54013-2	1102-67	1
65-54013-502	1102-67	1
65-54013-503	1102-64	1
65-54013-503	1102-64	1
65-54024-6	1102-59	1
65-54024-7	1102-62	1
65-54481-2	1101-76	2
65-54481-4	1101-78	1
65-55478-10	1101-145	1
65-55478-2	1101-142	1
65-55478-4	1101-145	1
65-55478-502	1101-142	1
65-55478-502	1101-142	1
65-55478-504	1101-145	1
65-55478-8	1101-142	1
65-55479-1	1101-139	1
65-55479-3	1101-141	1
65-55479-501	1101-139	1
65-55479-501	1101-139	1
65-55479-503	1101-141	1
65-55479-7	1101-139	1
65-55479-9	1101-141	1
65-55720-12	1101-241	1
65-55720-12	1101-241	1
65-55720-14	1101-230	1
65-55720-14	1101-230	1
65-55720-2	1101-241	1
65-55720-4	1101-230	1
65-55720-6	1101-251	1
65-55720-8	1101-240	1
65-58138-1	1101-91	1
65-58138-2	1101-82	1
65-58138-2	1101-82	1
65-58138-2	1101-82	1
65-58138-3	1101-93	1
65-58138-4	1101-84	1
65-58138-5	1101-84	1
65-58138-6	1101-82	1
65-58138-6	1101-82	1
65-73978-1	1101-222	1
65-73978-1	1101-222	1
65-73978-1	1101-222	1
65-73978-10	1101-217	1

Part No.	Fig. and Index No.	Qty. per Assy.	Part No.	Fig. and Index No.	Qty. per Assy.
65-73978-11	1101-224	1	66-15332-1	1101-169	AR
65-73978-13	1101-224	1	66-15645-1	1101-212	2
65-73978-2	1101-215	1	66-16691-1	1101-254	16
65-73978-3	1101-224	1	66-1921-1	1101-56	1
65-73978-4	1101-217	1	66-24154-1	1101-38	1
65-73978-7	1101-222	1	66-24154-2	1101-39	1
65-73978-8	1101-215	1	66-24986-1	1102-15	1
65-73978-8	1101-215	1	66-24987-1	1101-208	1
65-73978-9	1101-224	1	66-24987-2	1101-208	1
65-8795-801	1102-63	1	66-24987-2	1101-208	1
65C34053-2	1101-155	1	66-24987-3	1101-208	1
65C34053-3	1101-156	1	66-2646	1101-52	1
65C34053-6	1101-161	1	66-9330-1	1101-185	AR
65C34071-2	1101-151	1	66-9330-3	1101-186	AR
65C34071-2	1101-151	1	69-1083	1101-54	1
65C34071-4	1101-157	1	69-1084	1101-55	1
65C34071-4	1101-157	1	69-17330-2	1102-53	1
65C34083-8	1101-162	1	69-17330-4	1102-53	1
65C36793-1	1102-98	2	69-17789-2	1101-270	1
66-10363	1101-274	1	69-17952-17	1101-222	1
66-12687-1	1101-255	16	69-17952-18	1101-215	1
66-12688-1	1101-101	1	69-17952-19	1101-224	1
66-12688-1	1101-104	1	69-17952-20	1101-217	1
66-12688-1	1101-107	1	69-18187-23	1101-117	1
66-12688-1	1101-71	1	69-18187-23	1101-117	1
66-12688-1	1101-74	1	69-18187-26	1101-117	1
66-12688-1	1101-77	1	69-18187-8	1101-117	1
66-12688-1	1101-80	1	69-1983	1101-53	1
66-12688-1	1101-83	1	69-20350-10	1101-1A	
66-12688-1	1101-86	1	69-20350-12	1101-7A	1
66-12688-1	1101-89	1	69-20350-13	1101-1A	1
66-12688-1	1101-92	1	69-20350-13	1101-1A	1
66-12688-1	1101-95	1	69-20350-15	1101-1A	1
66-12688-1	1101-98	1	69-20350-15	1101-1A	1
66-12688-11	1101-80	1	69-20350-17	1101-7A	1
66-12688-5	1101-77	1	69-20350-5	1101-1	1
66-14527-1	1101-211	2	69-20350-6	1101-7	1
66-14527-2	1101-211	2	69-20350-7	1101-1	1
66-14527-4	1101-211	2	69-20350-8	1101-7	1
66-14527-4	1101-211	1	69-20350-9	1101-1	1
66-14527-6	1101-211	2	69-21619-4	1101-22	1
66-14530-1	1101-177	1	69-21619-5	1101-17	1
66-14530-2	1101-177	1	69-37418-11	1101-168	4
66-14531-1	1101-178	2	69-37418-2	1101-168	4
66-14531-10	1101-179	2	69-37418-501	1101-168	4
66-14531-3	1101-179	1	69-37418-501	1101-168	4
66-14531-9	1101-178	1	69-37418-8	1101-168	4
66-14542-1	1102-32	1	69-37418-8	1101-168	4
66-14618-7	1101-121	1	69-37495-2	1101-66	1

Part No.	Fig. and Index No.	Qty. per Assy.
69-38733-1	1102-68	1
69-38733-1	1102-74	1
69-38733-2	1102-73	1
69-38733-2	1102-80	1
69-39176-3	1102-48	1
69-39176-4	1102-52	1
69-41720-1	1101-144	2
69-42114-1	1101-249	1
69-42114-2	1101-238	1
69-43894-3	1101-60	3
69-43894-4	1101-56G	1
69-43894-5	1101-60G	1
69-43894-7	1101-56G	1
69-43894-8	1101-60	3
69-61511-1	1102-35	1
69-61511-2	1102-37	1
69-70268-1	1101-249	1
69-70268-2	1101-238	1
69-78694-3	1102-100	4
69-78694-4	1102-101	4
69B10068-3	1102-85	2
77253	1102-51	2
90-3287-11	1101-19	2
90-6753-12	1102-43	1
90-6753-12	1102-43	1
90-6753-19	1102-43	1
90-6753-7	1102-43	1
90-7811	1102-16	1
90-7815-1	1102-68	1
90-7815-1	1102-74	1
90-7815-15	1102-68	
90-7815-15	1102-74	1
90-7815-17	1102-68	
90-7815-17	1102-74	1
90-7815-19	1102-73	
90-7815-19	1102-80	1
90-7815-21	1102-73	
90-7815-21	1102-80	1
90-7815-23	1102-74	1
90-7815-24	1102-68	
90-7815-25	1102-74	1
90-7815-26	1102-68	1
90-7815-27	1102-80	1
90-7815-29	1102-80	1
90-7815-3	1102-73	1
90-7815-3	1102-80	1
90-7815-32	1102-68	1
90-7815-33	1102-73	1

Part No.	Fig. and Index No.	Qty. per Assy.
90-7820	1102-35	1
90-7820-1	1102-37	1
90-7821	1102-17	1
90-7879	1102-14	1
90-7879-1	1102-14	1
90-7879-5	1102-14	1