

TO: ALL HOLDERS OF GALLEY/SERVICE DOOR GUIDE ARM ASSEMBLY COMPONENT
 MAINTENANCE MANUAL, 52-41-02

REVISION NO. 6, DATED NOV 1/01

HIGHLIGHTS

DESCRIPTION OF CHANGE	TOPICS AFFECTED												
	D & O	D / A s s y	C l e a n i n g	I n s p / C h k	R e p a i r	A s s y	F / C	T e s t	T / S h o o t i n g	S / T o o l s	S t o r a g e	I P L	L / O v e r h a u l
Revised reference to SOPM 20-41-01 for an explanation of F and SRF finish codes Added guide arm assembly 65-52854-7					X								X

GALLEY/SERVICE DOOR GUIDE ARM ASSEMBLY

52-41-02

BOEING P/N 65-52854-1, -4, -6, -7, -501
69-20321-2, -3, -4
69-44331-1, -2, -3

AIRLINE P/N

THE FOLLOWING DIRECTIVES APPLY TO THIS SUBJECT:

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

LIST OF EFFECTIVE PAGES					
* Indicates pages revised, added or deleted in latest revision					
F Indicates foldout pages - print one side only					
PAGE	DATE	PAGE	DATE	PAGE	DATE
52-41-02					
* T-1	Nov 1/01				
T-2	BLANK				
* LEP-1	Nov 1/01				
LEP-2	BLANK				
T/C-1	Sep 1/96				
T/C-2	BLANK				
INTRO-1	Sep 1/96				
INTRO-2	BLANK				
1	Jun 1/97				
* 2	Nov 1/01				
3	Sep 1/96				
4	Sep 1/96				
5	Sep 1/96				
6	Sep 1/97				
* 7	Nov 1/01				
* 8	Nov 1/01				



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



OVERHAUL MANUAL

INTRODUCTION

The instructions in this manual provide the information necessary to perform maintenance functions ranging from simple checks and replacement to complete shop type repair.

The manual is divided into separate sections:

- | | |
|--|------------------------------|
| 1. Title Page | 4. List of Effective Pages |
| 2. Record of Revision | 5. Table of Contents |
| 3. Temporary Revision &
Service Bulletin Record | 6. Introduction |
| | 7. Procedures & IPL Sections |

Refer to the Table of Contents for the page location of applicable sections. An asterisked flagnote *[1] in place of the page number indicates that no special instructions are provided since the function can be performed using standard industry practices.

An explanation of the use of the Illustrated Parts List is provided in the Introduction to that section.

All weights and measurements in the manual are in English units, unless otherwise stated. When metric equivalents are given they will be in parenthesis following the English units.

Design changes, optional parts, configuration differences and Service Bulletin modifications create alternate part numbers. These are identified in the Illustrated Parts List (IPL) by adding an alphabetical character to the basic item number. The resulting item number is called an alpha-variant. Throughout the manual, IPL basic item number references also apply to alpha-variants unless otherwise indicated.

ENTRY GALLEY DOOR GUIDE ARM ASSEMBLY

1. DESCRIPTION AND OPERATION

- A. The galley/service-door guide-arm assembly consists of a guide arm, a rod end bearing, an adjustment fitting, bushings, a channel and attaching parts.
- B. The galley/service-door guide-arm assembly controls the movement of the door from the closed to the open position and back. The guide arm assembly together with a hinge arm make a parallel link. A pin in the guide-arm assembly fits in a cam in the door and controls movement.
- C. Leading Particulars (approximate)
 - Height - 2 inches
 - Width - 3 inches
 - Length - 12 inches
 - Weight - 2 pounds

2. DISASSEMBLY

- A. General
 - (1) Disassembly only those items necessary to be removed, or which must be removed to give access to parts to be removed, for inspection, repair, refinish or replacement.
 - (2) Parts such as press-fit bushings, threaded inserts, etc., should not be removed unless replacement is necessary.
- B. Disassemble parts using standard shop procedures.

3. CHECK (Fig. 2)

- A. Examine all parts for defects using standard shop procedures.
- B. Do a penetrant check of the guide arm (45, 55) (Ref 20-20-02).
- C. Do a magnetic particle check of adjustment fitting (30).

4. REPAIR (Fig. 2)

A. Materials

- (1) Primer - BMS 10-11, Type 1 (Ref SOPM 20-60-02)
- (2) Enamel - BMS 10-11, Type 2 (Ref SOPM 20-60-02)

B. Replacement

- (1) If bushings (35, 40) need to be replaced, install new bushing with wet primer (Ref SOPM 20-50-03). Line ream bushings (40) to 0.5000-0.5015 inch.

C. Repair small defects using standard shop procedures.

D. Refinish

NOTE: See Fig. 1 for procedures to put back the original finishes. Refer to SOPM 20-30-02 for procedures to remove protective finishes. Refer to SOPM 20-41-01 for an explanation of the F and SRF finish codes.

IPL FIG. & ITEM	MATERIAL	FINISH
<u>Fig. 2</u>		
Channel (15, 15A)	Al alloy	Chemical treat or chromic acid anodize and apply one coat primer BMS 10-11, Type 1 (F-18.05).
Channel (15B)	17-7 PH 150-170 ksi	Cadmium plate and apply one layer of BMS 10-11, Type 1 primer (F-16.01). Apply one layer of BMS 10-11, Type 2 enamel, color 702 white (F-21.03).
Fitting (30)	4130 steel	Cadmium plate (F-15.02).
Fitting (30A)	4340 steel 125-145 ksi	Cadmium plate (F-15.06).
Guide arm (45, 45A, 45D)	Al alloy	Chemical treat and apply one coat primer BMS 10-11, Type 1 (SRF-2.901), except no primer in holes for bushings.
Guide arm (45B)	Al alloy	Chemical treat and apply one layer of BMS 10-11, Type 1 primer (F-18.07).
Guide arm (45C)	Al alloy	Chemical treat and apply one layer of BMS 10-11, Type 1 primer (F-18.07). Apply one layer of BMS 10-11, Type 2 enamel, color 702 white (F-21.03).
Guide arm (55, 55A)	Al alloy	Chemical treat or chromic acid anodize and apply one coat primer BMS 10-11, Type 1 (SRF-2.30), except no primer in holes for bushings.
Guide arm (55B)	Al alloy	Anodize and apply one coat primer BMS 10-11, Type 1 (F-18.04), except no primer in holes for bushings.

 Refinish Details
 Figure 1

5. ASSEMBLY (Fig. 2)

A. Materials

- (1) Corrosion Preventive Compound - MIL-C-16173, Grade 2 (Ref 20-60-02)

B. Assembly

- (1) Assemble the guide arm assembly using standard shop procedures, plus the procedure which follows.
- (2) Apply corrosion preventive compound to threads of rod end bearing (25) and mating threads of adjustment fitting (30), nut (20) and guide arm (45). Install rod end bearing (25), adjustment fitting (30) and nut (20) in guide arm (45).

OVERHAUL MANUAL**6. ILLUSTRATED PARTS LIST****A. Introduction**

- (1) This section lists and illustrates replaceable or repairable component parts. The Illustrated Parts Catalog contains a complete explanation of the Boeing part numbering system.
- (2) Indentures show parts relationships as follows:

- Assembly
 - Detail Parts for Assembly
 - Subassembly
 - Attaching Parts for Subassembly
 - Detail Parts for Subassembly

Detail Installation Parts (Included only if installation parts may be returned to shop as part of assembly)

- (3) One use code letter (A, B, C, etc.) is assigned in the EFF CODE column for each variation of top assembly. All listed parts are used on all top assemblies except when limitations are shown by use code letter opposite individual part entries.
- (4) Letter suffixes (alpha-variants) are added to item numbers for optional parts. Service Bulletin modification parts, configuration differences (except left- and right-hand parts), product improvement parts, and parts added between two sequential item numbers. The alpha-variant is not shown on illustrations when appearance and location of all variants of the part is the same.
- (5) Service Bulletin modifications are shown by the notations PRE SB XXXX and POST SB XXXX.
 - (a) When a new top assembly part number is assigned by Service Bulletin, the notations appear at the top assembly level only. The configuration differences at detail part level are then shown by use code letter.
 - (b) When the top assembly part number is not changed by the Service Bulletin, the notations appear at the detail part level.

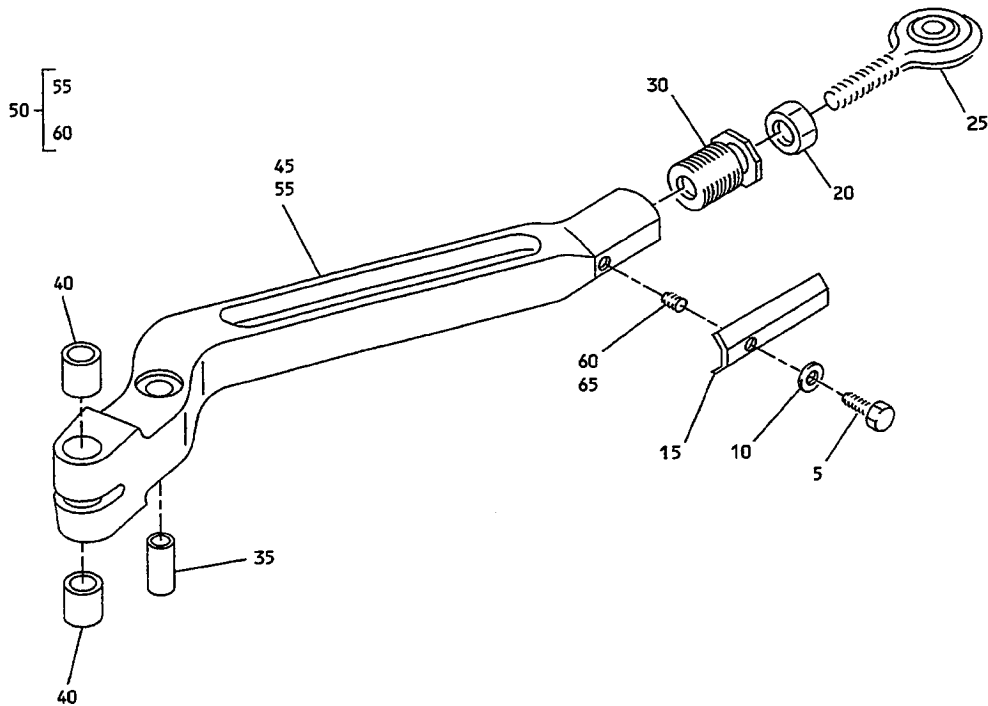
65-52854
69-20321
69-44331

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6. ILLUSTRATED PARTS LIST (Cont)

(6) Parts Interchangeability

Optional (OPT)	The parts are optional to and interchangeable with other parts having the same item number.
Superseded, Superseded by (SUPSDS, SUPSD BY)	The part supersedes and is not interchangeable with the original part.
Replaces, Replaced by (REPLS; REPLD BY)	The part replaces and is interchangeable with, or is an alternate to, the original part.



Entry/Galley Door Guide Arm Assembly
Figure 2

65-52854
69-20321
69-44331

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FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
02-											
-1	65-52854-1									A	RF
-1A	65-52854-501									B	RF
-1B	69-20321-2									C	RF
-1C	69-44331-1									D	RF
-1D	69-44331-2									E	RF
-1E	69-44331-3									F	RF
-1F	69-20321-3									G	RF
-1G	69-20321-4									H	RF
-1H	65-52854-4									J	RF
-1J	65-52854-6									K	RF
-1K	65-52854-7									L	RF
5	NAS1103-1									ABCGH	1
										J-L	
-5A	NAS1103-1									DEF	1
-5B	NAS6603-1									A-L	1
-5C	NAS6603-1										
10	AN960PD10L										1
15	66-15530-2									ABDEF	1
-15A	66-15530-1									C	1
-15B	69-78234-1									GH	1
-15C	69-78234-2									J-L	1
20	AN316-7R										1
25	BACB10A223L									ABDEFJ	1
										KL	
-25A	KBE5-13SSFN									CGH	1
30	66-14523-1									A-F	1
-30A	69-78241-1									GHJKL	1
35	NAS76A6-026P									ABDEFJ	1
										KL	
-35A	NAS76A6-026									CGH	1
40	NAS76A8-019P									ABDEFJ	2
										KL	
-40A	NAS76A8-019									CGH	2
45	65-52854-2									A	1
-45A	65-52854-502									BJ	1
-45B	69-17791-2									CG	1
-45C	69-17791-3									H	1
-45D	65-52854-5									KL	1
50	69-44194-1									D	1
-50A	69-44194-2									E	1
-50B	65C18398-1									F	1
55	NO ASSIGNED P/N									D	1
-55A	69-44194-3									E	1
-55B	65C18398-2									F	1

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FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
02-60	MS21209F1-15		.	.	INSERT					D-F	1
65	MS21209F1-15		.		INSERT					ABJKL	1
-65A	MS21209F1-15		.		INSERT (REPLS BACS13W3CN3)					CGH	1
-65B	MS21209F1-15				DELETED						

VENDORS

V97613 SARGENT TECHNOLOGIES, 1851 S. PANTANO RD., TUCSON, ARIZONA 85710