TO: ALL HOLDERS OF LOWER BODY FORWARD ACCESS DOOR ASSEMBLY OVERHAUL MANUAL, 52-46-03

REVISION NO. 11, DATED NOV 1/08

HIGHLIGHTS

DESCRIPTION OF CHANGE	TOPICS AFFECTED												
	D&O	D/Assy	Cleaning	Insp/Chk	Repair	Assy	F/C	Test	T/Shooting	S/Tools	Storage	IPL	L/Overhaul
Incorporated Service Bulletins 737-32-1396 and 737-32-1400 which add landing gear gravel deflector equipment												X	

LOWER BODY FORWARD ACCESS DOOR ASSEMBLY

52-46-03

BOEING P/N 65-22216-2, -57, -113, -155, -174, -178

AIRLINE P/N

THE FOLLOWING DIRECTIVES APPLY TO THIS SUBJECT:

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVES	DATE DIRECTIVE INCORPORATED INTO TEXT
52-2		PRR 20923	Jan 15/67
52-29		PRR 21925	Jan 15/67
		PRR 30799	Aug 15/69
		PRR 24052	May 10/77
52-123			Nov 10/80
		PRR 33180-86	Mar 5/85
		PRR 34475-1	Mar 5/89
32-1396		MC 3200MK3058	Nov 1/08
32-1400		MC 3200MK3056	Nov 1/08

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
52-46-03						
*	T-1	Nov 1/08				
	T-2	BLANK				
*	LEP-1	Nov 1/08				
	LEP-2	BLANK				
	T/C-1	Aug 15/69				
	T/C-2	BLANK				
	1	Nov 1/00				
	2	Jul 1/01				
	101	Aug 15/69				
	102	Mar 5/89				
	201	Aug 15/69				
	202	BLANK				
	301	Mar 5/89				
	302	BLANK				
	401	Jul 1/01				
	402	Dec 5/90				
	403	Dec 5/90				
	404	Nov 1/00				
	501	Mar 5/89				
	502	Jul 1/01				
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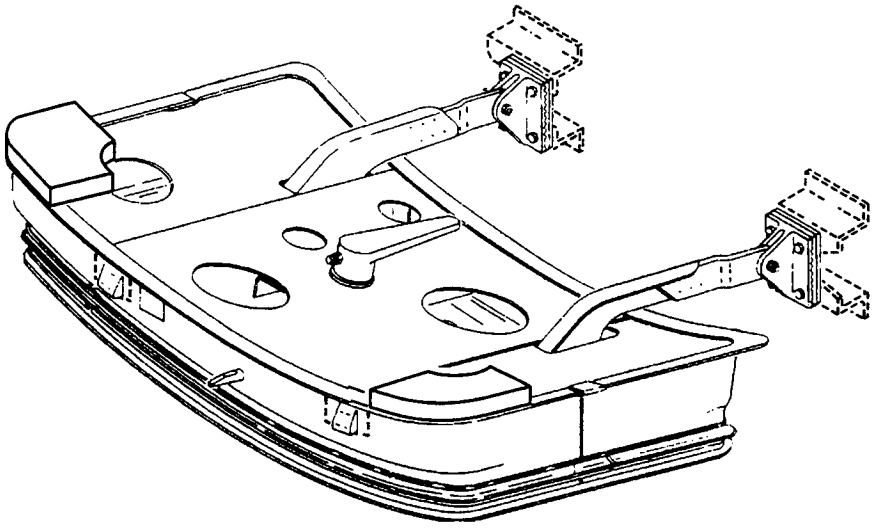
	1102	Mar 5/89				
	1103	Aug 15/69				
	1104	Nov 10/80				
	1105	Aug 15/69				
	1106	Mar 5/89				
*	1107	Nov 1/08				
	1108	Jul 1/01				
	1109	Jul 1/01				
	1110	Jul 1/01				
	1111	Jul 1/01				
	1112	Jul 1/01				
	1113	Jul 1/01				
	1114	Dec 5/90				
	1115	Jul 1/01				
	1116	Dec 5/90				

TABLE OF CONTENTS

Paragraph Title	Page
Description and Operation	1
Disassembly	101
Cleaning	201
Inspection/Check	301
Repair	401
Assembly	501
Fits and Clearances	None
Testing	701
Trouble Shooting	801
Storage Instructions	901
Special Tools, Fixtures and Equipment	None
Illustrated Parts List	1101
Numerical Parts List Index	1113

LOWER BODY FORWARD ACCESS DOOR ASSEMBLY



Lower Body Forward Access Door Assembly
Figure 1

DESCRIPTION AND OPERATION

1. Description

   A. The lower body forward access door is an inward opening plug type door of frame and skin construction. Two hinge arms extend aft from the door structure to engage hinge fittings on the forward face of the nose wheel well. The door sides have a continuous seal to prevent loss of cabin air when the airplane is in flight. Pressurization loads on the door are transmitted to the fuselage by four stop pads on the edge of the door, which bear against equivalent pads on the fuselage structure.

   B. The door latching mechanism consists of a handle-operated shaft, flexibly connected to a latch pin. The protruding latch pin engages a hole in the door opening frame.

2. Operation

A. The door is opened from outside the airplane by pulling the flush type operating handle down clear of the skin and rotating it counterclockwise. This action withdraws the latch pin, and energizes the door warning light in the control cabin, allowing the door to be hinged upward. From inside the airplane, the door may be opened by a protruding handle.

B. As the door is being closed, the outside handle is rotated counterclockwise to seat the door in its opening. The door is latched shut by clockwise rotation of the outside handle.

3. Leading Particulars

Length -- 29 inches
Width -- 17 inches
Height -- 5 inches
Weight -- 65-22216-2 -- 14.9 pounds (approximately)
65-22216-57 -- 19.3 pounds (approximatley)
65-22216-113 -- 14.9 pounds (approximatley)
65-22216-155 -- 13.9 pounds (approximatley)
65-22216-174 -- 13.9 pounds (approximatley)
65-22216-178 -- 13.9 pounds (approximatley)

DISASSEMBLY

1. Disassembly procedure. (See figure 1101.)

NOTE: Do not remove any riveted or bonded parts unless repair or replacement makes it necessary. Perform steps listed below only to the extent necessary for cleaning, inspection, repair, and replacement of defective parts.

A. Remove bolts (1), nuts or collars (2), washer (3) and rivets (4) from hinges (5 and 6) and basic assembly (103) or hinge beams (32 and 33).

B. Remove rivets (7) and disassemble striker plate (8) from forward door frame (9) and aft door frame (10).

C. Do not remove identification and modification plate (11) from forward door frame (9) unless replacement is necessary.

D. Remove seal (12) or seal assembly (13).

NOTE: Do not separate cloth (14) from seal (15).

E. Remove rivets (16) and seal retainer channels (17 through 22) or remove rivets (23) and seal retainer channels (24 and 25).

F. Remove inside handle from lock assembly (56) by removing bolt (26), nut (27) and washer (28).

G. Remove bolts (29), collars (30) and blind bolts (31), and hinge beams (32 and 33).

H. Remove rivets (34 and 35) and skin panel (36).

I. Remove rivets (37, 40, 41, and 42), bolts (38), and collars (39); remove stops (43, 44, 45 and 46) from forward and aft door frames (9 and 10).

J. Remove cotter pins (47), bolts (48), nuts (49), and washers (50) with link assembly (51).

K. Disassemble link assembly (51) by removing rivet (52), spacer (53), and link halves (54).

L. Remove rivets (55) and flush lock assembly (56) with channel assembly (57). Overhaul flush lock assembly per manufacturer's instructions.

NOTE: Do not remove rub strip (58) from channel support (59) unless replacement is required.

M. Disassemble latch pin assembly (60) by removing bearing (61), washer (62), nut (63), and latch pin (64).

N. Remove rivets (65 and 69) and support assemblies (66 and 70), or (73 and 76).

NOTE: Do not remove bushings (67, 71, 74, or 77) from supports (68, 72, 75, or 78) unless repair or replacement makes it necessary.

O. Remove screws (79 and 80), nuts (81), washers (82), rivets (83), latch pin support (84), and latch pin bracket (85).

P. Remove rivets (86) and latch pin support (87).

Q. Remove rivets (88) and seal assembly (89).

NOTE: Do not disassemble seal assembly (89) unless repair or replacement is required.

R. Rework the bolts (113) and the nuts (114).

S. Remove the retainer valve (107) and the drain-valve assembly (108).

NOTE: Do not disassemble the drain-valve assembly (108) unless repair or replacement is required.

T. Remove rivets (95 and 96), retainer (97), and seal (98).

U. Remove screw (99), nut (100), washer (101), and guide pin (102) from basic door assembly (103).

CLEANING

1. General (See figure 1101.)

   A. Wash all metal parts, except bearings, in dry cleaning solvent, Specification P-D-680, or equivalent.

   B. Use a stiff-bristle brush to remove stubborn accumulations of foreign matter.

   C. Drain and dry thoroughly with a lint-free cloth or with clean, moisture-free compressed air.

   D. For further information refer to "General Cleaning Procedures," Subject 20-30-03.

2. Bearings

   A. Clean all bearings per "Cleaning and Relubricating Antifriction Bearings," Subject 20-30-01.

INSPECTION/CHECK

1. Visual Check (Fig. 1101)

   A. Examine all metal parts for pits, cracks, scratches, burrs, and corrosion, using a strong light and 10-power magnification.

   B. Examine all threads for cross-threading or stripping.

   C. Check all plated or painted surfaces for blisters, chipping or flaking.

   D. Check seal assembly and seal (12 and 13) for tears, security of splices and deterioration.

   E. Examine all bearings for roughness, binding and excessive radial or axial play.

   F. Check basic assembly for loose fasteners.

   G. Examine all bearing, bushing, and bolt holes for excessive or eccentric wear.

   H. Check identification and modification plate (11) for legibility and mounting.

   I. Check latch pins (64) for continuity of dry lube surface.

   J. Make sure the spring (111) opens the drain valve (108) by depressing the plunger (110) with a thin rod inserted through the cap (109).

2. Special Check (Fig. 1101).

   A. If visual examination discloses evidence of defects in any of listed parts, perform following check:

      (1) Dye penetrant check -- hinge plates (5 and 6), stops (43, 44, 45, and 46) and latch pin support (68 and 72).

      (2) Ultrasonic check -- latch pin support (75 and 78, 69-56303-7 and -8 only).

   B. Check spring (111).

      (1) Apply 0.39 to 0.49 pounds and make sure the length is 0.22 inches.

      (2) Apply 0.06 to 0.14 pounds and make sure the length is 0.11 inches.

REPAIR

1. Repair

   A. Use standard industry practices for repair of this component.

   B. Deleted.

2. Refinish (Fig. 1101)

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

   A. Forward access door basic assembly (103) -- Alodize or chromic acid anodize and apply one coat primer BMS 10-11, Type 1 (SRF-2.30) except on bonded skin assembly, outer door skin, rub strip or seal (12, 13).

   B. Hinge plate (5, 6)

      (1) 69-22788-5, -6 and 69-45716-1, -2 -- Alodize or chromic acid anodize and apply one coat primer BMS 10-11, Type 1 (SRF-2.30) all over. Material: Al alloy.

      (2) 69-22788-7, -8 -- Chromic acid anodize. Apply one coat of BMS\10-11, Type 1 primer and one coat of BMS 10-11, Type 2 enamel, color 702 white (F-21.18). Material: Al alloy.

   C. Striker Plate (8) --

      (1) 65-22216-143 -- Apply BMS 10-11, Type 1 primer (SRF-12.206). Material: 302 CRES.

      (2) 65-22216-179 -- Apply BMS 10-11, Type 1 (F-20.03). Material: 302 CRES.

   D. Frame (9, 10)

      (1) 65-22216-3, -4, -103, -104 and -114 -- Chromic acid anodize and apply one coat primer BMS 10-11, Type 1 (SRF-2.19) all over. Material: Al alloy.

      (2) 65-22216-145, -152 and -176 -- Chemical treat and apply one coat of BMS 10-11, Type 1 primer (F-18.06). Apply one coat of BMS 10-11, Type 2 enamel, color BAC702 white gloss (F-21.03). Material: Al alloy.

      (3) 65-22216-123, -124 and -134 -- Anodize and apply one coat of BMS 10-11, Type 1 primer (F-18.04). Material: Al alloy.

   E. Channel (17 thru 22, 24, 25)

      (1) 65-22216-40, -41, -44 thru -49, -85, -87 thru -91, -107, -108, -110, -111, -112, -115 and -117 -- Alodize or chromic acid anodize and apply one coat primer BMS 10-11, Type 1 (SRF-2.30) all over. Material: Al alloy.

      (2) 65-22216-139, -140, -141, -143, -169, -170, and -180 -- Chromic acid anodize. Apply one coat of BMS 10-11, Type 1 primer and one coat of BMS 10-11, Type 2 enamel, color 702 white (F-21.18). Material: Al alloy.

F. Beam (32, 33) -- Alodize or chromic acid anodize and apply one coat primer BMS 10-11, Type 1 (SRF-2.30) all over. Material: Al alloy.

G. Panel (36)

(1) 65-22216-8 -- Alodize or chromic acid anodize and apply one coat primer BMS 10-11, Type 1 (SRF-2.30) all over. Material: Al alloy.

(2) 65-22216-151 -- Chemical treat and apply one coat of BMS 10-11, Type 1 primer (F-18.06). Apply one coat of BMS 10-11, Type 2 enamel, color BAC702 white gloss (F-21.03). Material: Al alloy.

(3) 65-22216-133 -- Chemical treat and apply one coat of BMS 10-11, Type 1 primer (F-18.06).

H. Stop (43 thru 46)

(1) 69-22752-1 thru -4 and 69-45495-1 thru -4 -- Alodize or chromic acid anodize and apply one coat primer BMS 10-11, Type 1 (SRF-2.30) all over. Material: Al alloy.

(2) 69-22752-9 thru -14 -- Chromic acid anodize. Apply one coat of BMS 10-11, Type 1 primer and one coat of BMS 10-11, Type 2 enamel, color 702 white (F-21.18). Material: Al alloy.

I. Link half (54) -- Electrodeposit nickel plate (F-1.822) all over. Material: 4130 steel.

J. Channel (59)

(1) 65-22216-27 -- Alodize or chromic acid anodize and apply one coat primer BMS 10-11, Type 1 (SRF-2.30) all over. Material: Al alloy.

(2) 65-22216-172 -- Chemical treat and apply one coat of BMS 10-11, Type 1 primer (F-18.08). Apply one coat of BMS 10-11, Type 2 enamel, color BAC702 white gloss (F-21.03). Material: Al alloy.

K. Pin (64)

(1) 90-3173-4 -- Apply phosphate coating (F-14.14) plus two coats primer BMS 10-11, Type 1 (SRF-23.206) on interior surfaces except no primer on threads. Apply dry film lubricant BMS 3-8, class A per 20-50-08, method 3 (F-19.10) on exterior surfaces only. Material: 4340 steel, 180-200 ksi.

(2) 69-45433-2 -- Cadmium-titanium alloy plate with post-plate chromate treatment (F-1.181) plus dry film lubricant BMS 3-8, class A per 20-50-08, method 3 (F-19.10) on exterior surfaces only. Apply one coat primer BMS 10-11, Type 1 (SRF-12.205) on interior surfaces except no primer on threads. Material: 4340M steel, 270-300 ksi.

L. Support (68, 72) -- Alodize or chromic acid anodize and apply one coat primer BMS 10-11, Type 1 (SRF-2.30) on all external surfaces only. Material: Al alloy.

M. Support (75 and 78)

(1) 69-56303-3, -4 -- Alodize or chromic acid anodize and apply one coat primer BMS 10-11, Type 1 (SRF-2.30) on all external surfaces only. Material: Al alloy.

(2) 69-56303-7, -8 -- Chromic acid anodize. Apply one coat of BMS 10-11, Type 1 primer and one coat of BMS 10-11, Type 2 enamel, color 702 white (F-21.18) except omit primer and enamel from internal surfaces. Material: Al alloy.

N. Bracket (85) -- Alodize or chromic acid anodize and apply one coat primer BMS 10-11, Type 1 (SRF-2.30) on all external surfaces only. Material: Al alloy.

O. Support (84, 87) -- Cadmium plate and apply one coat primer BMS 10-11, Type 1 (SRF-4.30) external surfaces only. Material: Alum bronze.

P. Cover (90), retainer (92), angle (94) -- Chemical treat or chromic acid anodize and apply one coat primer BMS 10-11, Type 1 (SRF-2.115) all surfaces. Material: Al alloy.

Q. Pin (102) -- Alodize or chromic acid anodize and apply one coat primer BMS 10-11, Type 1 (SRF-2.30) all over. Material: Al alloy.

3. Replacement (Fig. 1101)

NOTE: Install all non-aluminum countersunk permanent fasteners through exterior aluminum surfaces by applying BMS 5-95, Class B or C sealant to fastener and countersink area. Optional: Apply wet BMS 10-11, Type 1 primer to countersunk area of hole and while primer is still wet, install fastener.

Install all non-aluminum countersunk removable fasteners through exterior aluminum surfaces by applying BMS 10-11, Type 1 primer (dry) to hole surface.

A. Replace all lockwire and cotter pins (47) at each overhaul.

B. Replace all parts damaged beyond simple repair.

C. If identification and modification plate (11) is torn or legibility is impaired, remove remainder of plate and replace with new plate. Install per 20-50-05.

D. If replacement of rub strip (58) is required, bond replacement rub strip (58) to support channel (59) per SOPM 20-50-12, Type 40.

E. If replacement of bushing (67, 71, 74, 77) is required, press bushing out of support (68, 72, 75, 78) and press replacement bushing into support per SOPM 20-50-03.

F. If any component of seal assembly (89) requires replacement, drill out applicable rivets (88) and install serviceable part with new rivets.

G. If components of water valve assembly (91) need replacement, cement valve retainer (92) to seal (93) per SOPM 20-50-12, Type 46.

H. If replacement of bumper (115) is necessary, bond the replacement bumper (115) as specified in SOPM 20-50-12, Type 48 (Types 12, 58, 97 are optional).

ASSEMBLY

1. Procedure (Fig. 1101)

A. Attach guide pin (102) to basic door assembly (103) with washer (101), nut (100) and screw (99).

NOTE: Do not bond the plunger (110) to housing (112) or cap (109).

B. Bond cap (109) to housing (112) with LOCTITE 495 or LOCTITE 416 per manufacturer's instructions. Make sure it will operate properly by manually depressing the plunger (110) after bond has set.

C. Install the retaining valve (107) with sealant BMS 5-95 on faying surfaces. Attach with bolts (113) and nuts (114).

CAUTION: EXCESSIVE TIGHTENING OF VALVE ASSEMBLY (108) WILL CAUSE THE HOUSING's (112) FLANGE TO CRACK OR BREAK.

D. Install drain valve assembly (108) from outside of the door until flange of housing (112) is snug with skin.

E. Install rivets (95 and 96) in seal (98), seal retainer (97) on applicable door assembly.

F. Install seal assembly (89) with rivets (88) on applicable door assembly.

G. Install latch pin support (87) with rivets (86), and latch pin bracket (85) with rivets (83) on applicable door assembly.

H. Insert screws (79 and 80) in latch pin support (84) and latch pin bracket (85). Secure with washers (82) and nuts (81) on applicable door assembly.

I. Install rivets (69) in latch pin support assembly (70 or 76) and applicable basic door assembly (103).

J. Install rivets (65) through latch pin support assembly (66 or 73) and applicable basic door assembly (103).

K. Push latch pin (64) through spring (104), washers (105), if used, and applicable supports (66, 70, 73, 76, 84, 87). Assemble latch pin (64) with nut (63), washer (62) and rod end bearing (61), forming latch pin assembly (60). Install cotter pin (106), if used.

NOTE: Check alignment of all supports by moving assembled latch pin. Latch pin must move freely without binding.

Nut (63) will be lockwired after nut is adjusted at time of door installation.

L. Position channel assembly (57) on top of collar on flush lock assembly (56) and install rivets (55) into base of flush lock assembly (56) and door assembly.

NOTE: A minimum gap of 0.05 inch is required between rod end and housing of flush lock assembly (56) to prevent friction drag and interference.

M. Assemble link halves (54), with spacer (53) and rivet (52) to make link assembly (51).

N. Insert bolts (48) into link assembly (51) and rod end bearings (61 and 56); secure with washer (50), nut (49) and cotter pin (47).

O. Position stops (46, 45, 44, 43) on forward and aft frames (9 and 10); install rivets (42, 41, 40, 37), bolts (38) and collars (39).

P. Position skin panel (36) on channel assembly (57) and forward and aft frames (9 and 10); install rivets (35, 34).

Q. Position hinge beams (32, 33) on skin panel (36) and assemble with blind bolts (31), bolts (29) and collars (28).

R. Assemble bolt (26) with washer (28) and nut (27) into lock assembly (56).

S. Position seal retainer channels (25 and 24, or 22, 21, 20, 19, 18 and 17) on frame and install rivets (23 or 16). Make sure the short lip is nearest to the outside skin contour.

T. Insert seal assembly (13) or seal (12) (as applicable) into seal retainer channels.

(1) Place seal around entire door, with spliced and bonded section at the left center of door assembly. Splice must be clean, smooth and faired.

(2) Carefully push seal into seal retainer channel with a blunt implement.

NOTE: Seal may be installed with a liquid soap lubricant.

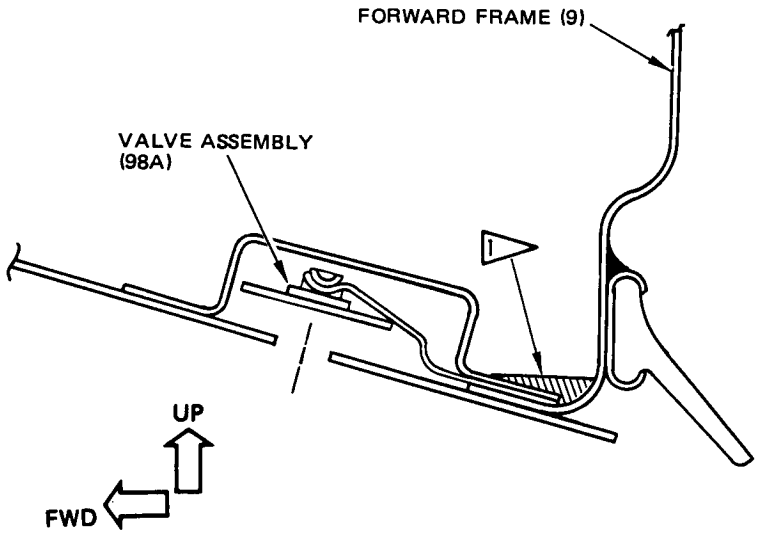
U. Install striker plate (8) on door frame s (9 and 10) with rivets (7).

V. Position hinges or hinge plates (5 and 6) and assemble with rivets (4), bolts (1), washers (3), and nuts (2).

W. Apply leveling compound in inner periphery of forward frame (9) (Fig. 501):

(1) Position the door in installed (taxi) attitude.

(2) Trowel in BMS 5-125, Type I sealant until compound is level and as high as possible without entering in drain valve assembly (98A) or seal (98).



1 BMS 5–125, TYPE 1 SEALANT LEVEL

(69–68855–1 SHOWN)

Leveling Compound Application
Figure 501

TESTING

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

TROUBLE SHOOTING

1. Trouble during test after overhaul. (See figure 1101.)

	Trouble	Possible Cause	Correction
A.	Locking mechanism binding	Bearing (61) or bearing in flush lock assembly (56) dirty, improperly assembled, or defective	Clean, check alignment and/or replace damaged parts

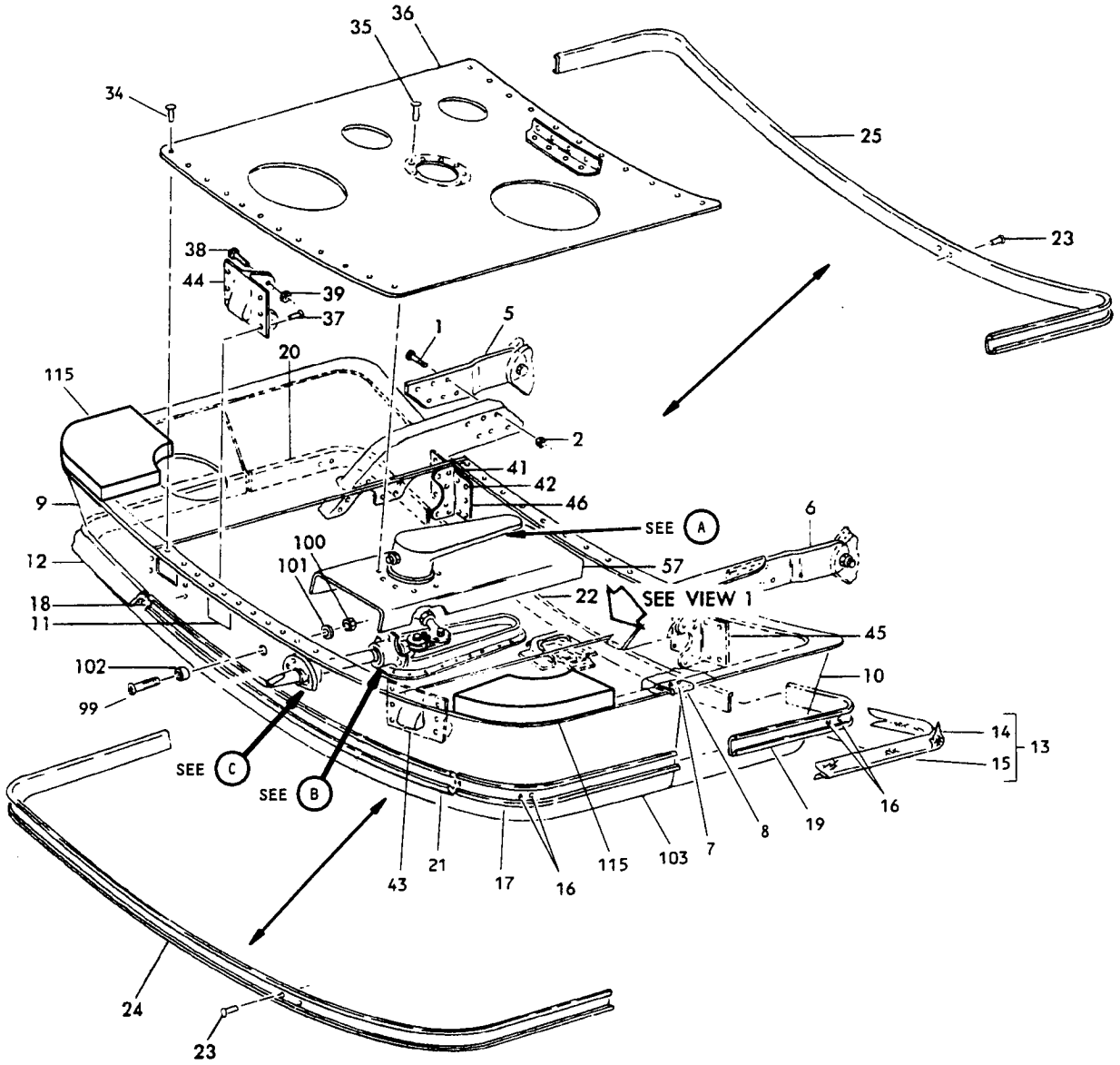
STORAGE INSTRUCTIONS

1. Place protective covers over surface of door linings.

2. Wrap entire assembly in vapor barrier paper. Tag with overhaul date.

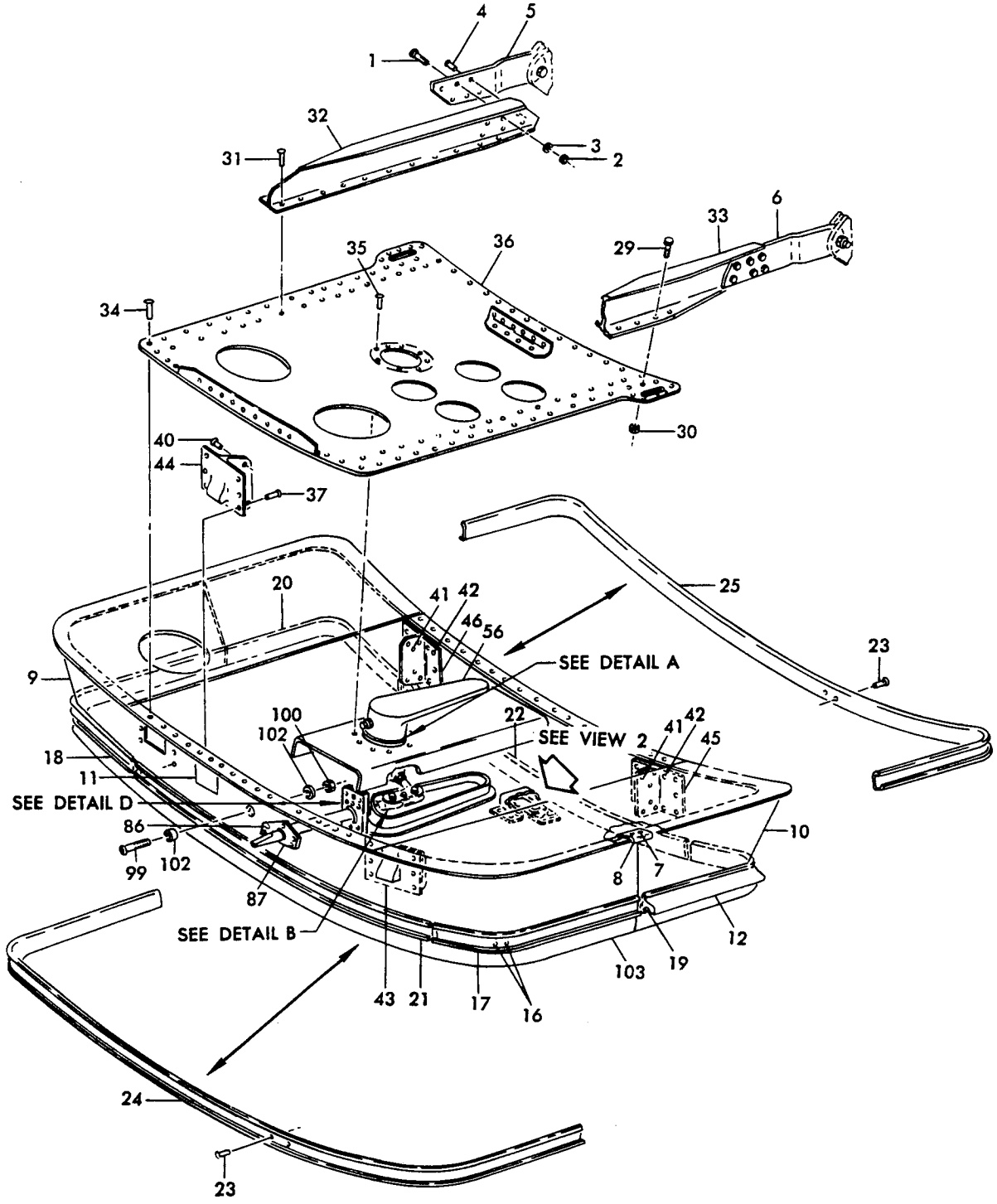
3. Provide a suitable surrounding structure to prevent handling damage.

4. For general storage information, refer to "Temporary Protective Coatings," Subject 20-44-02, and to "Protection, Storage and Handling of Airplane Components," Subject 20-70-01.



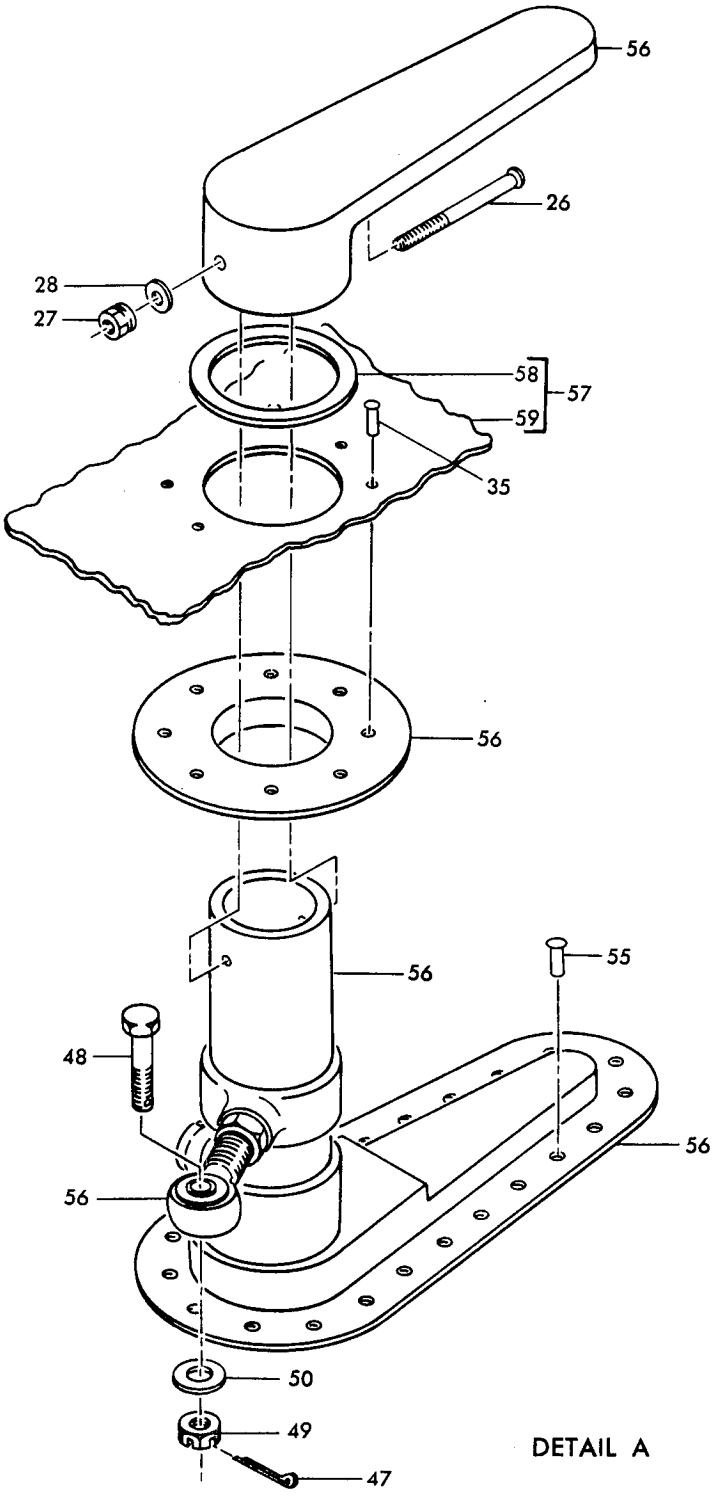
65-22216-2,-113,-155,-174 AND -178

Lower Body Forward Access Door Assembly
Figure 1101 (Sheet 1)

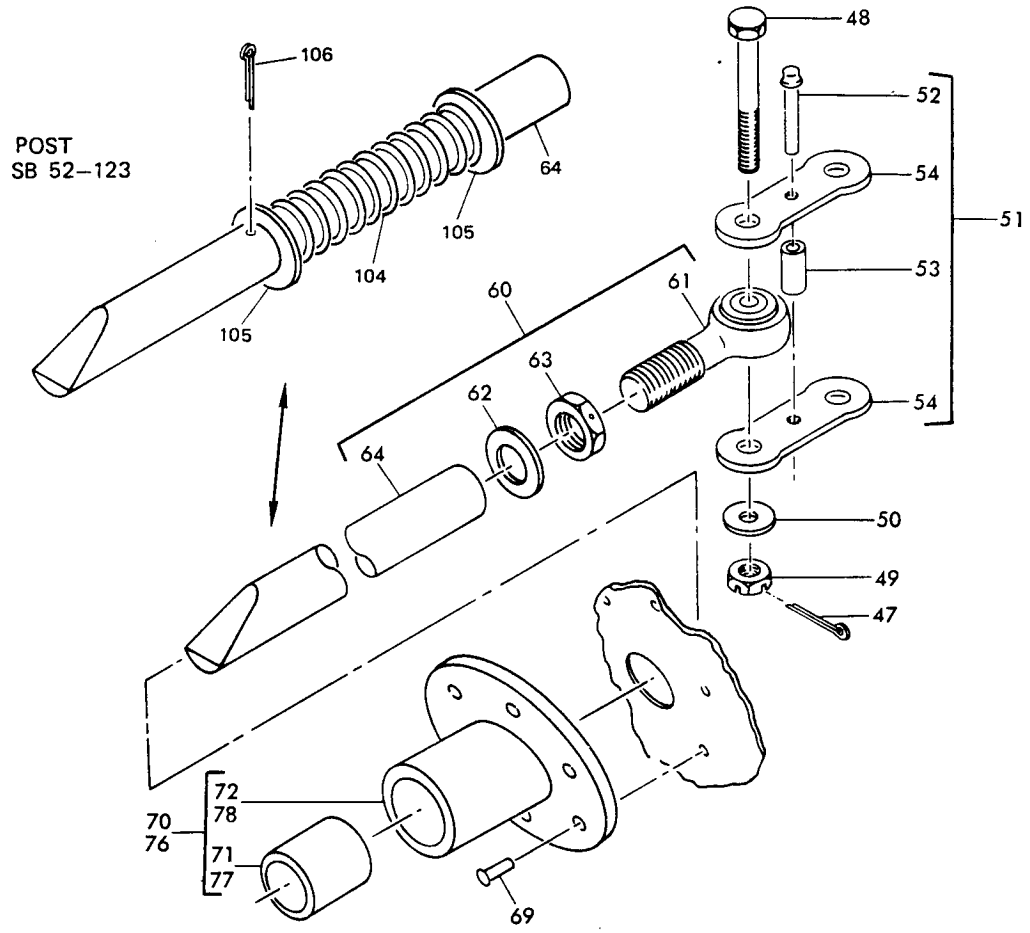


65-22216-57

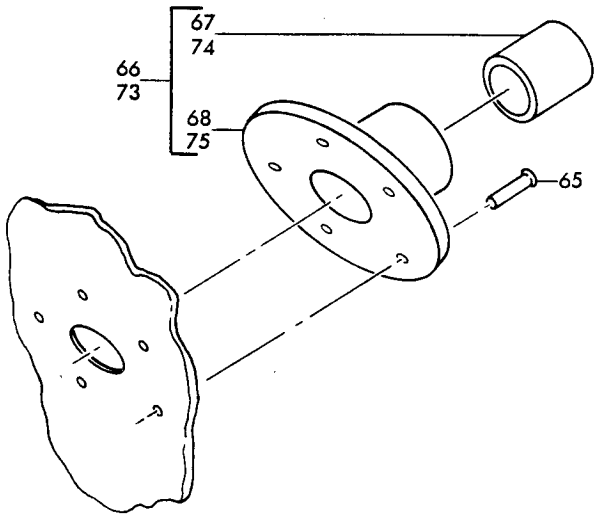
Lower Body Forward Access Door Assembly
Figure 1101 (Sheet 2)



Lower Body Forward Access Door Assembly
Figure 1101 (Sheet 3)

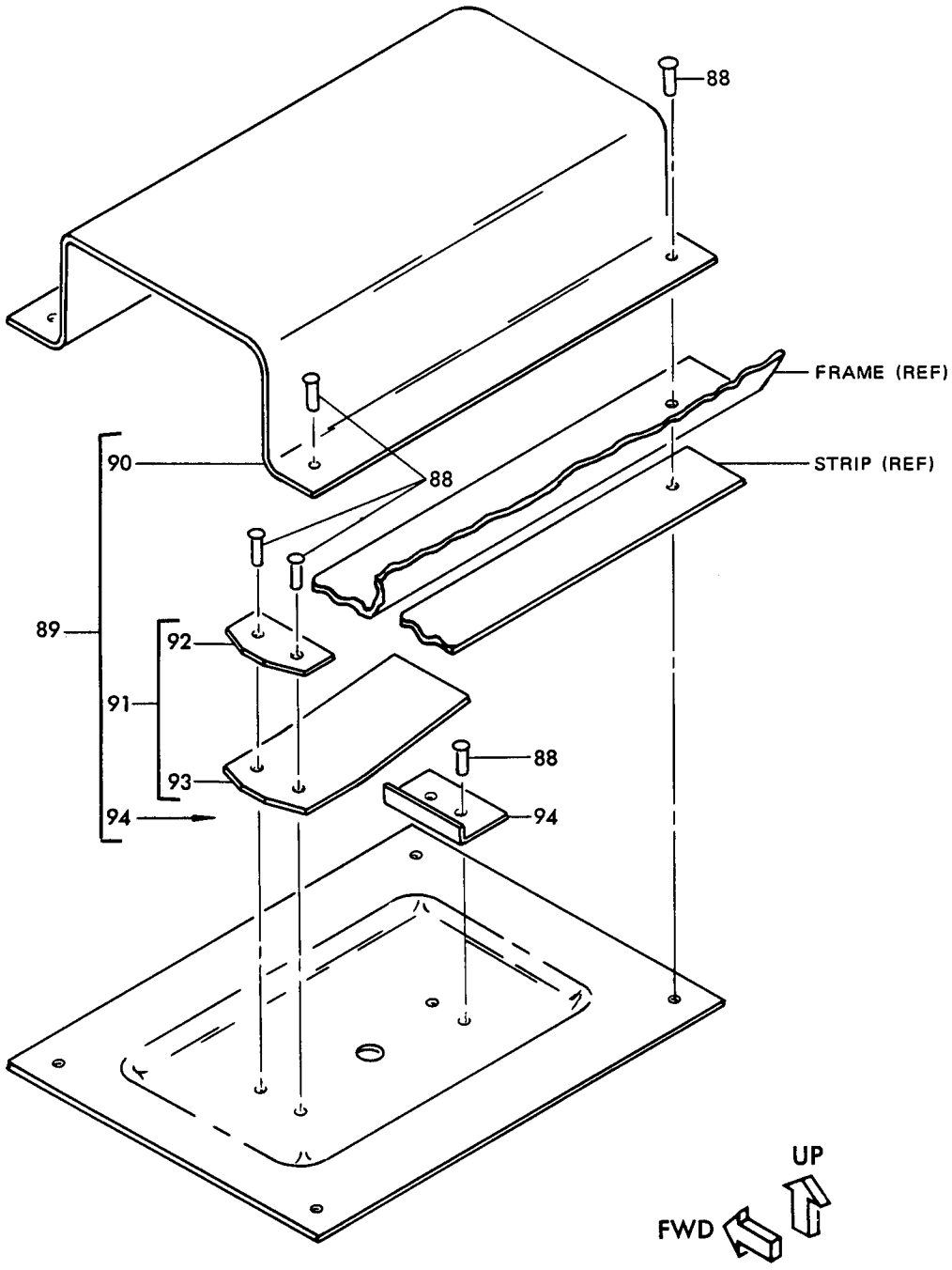


DETAIL B

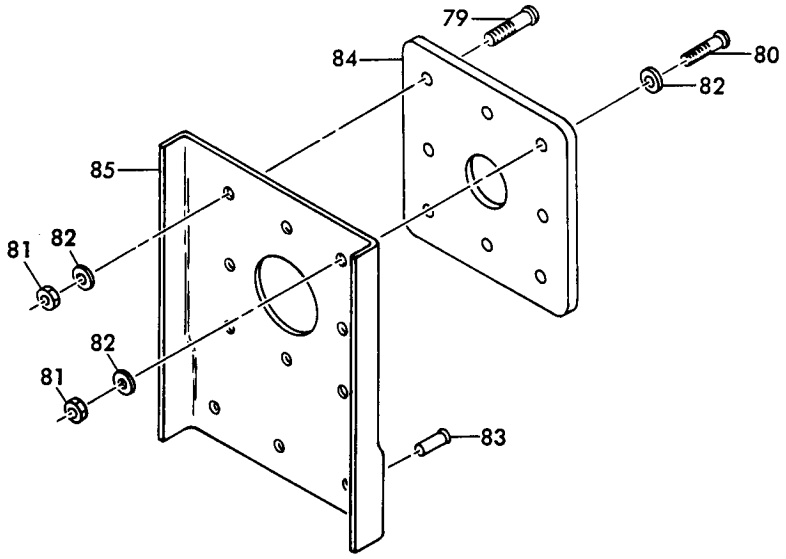


DETAIL C

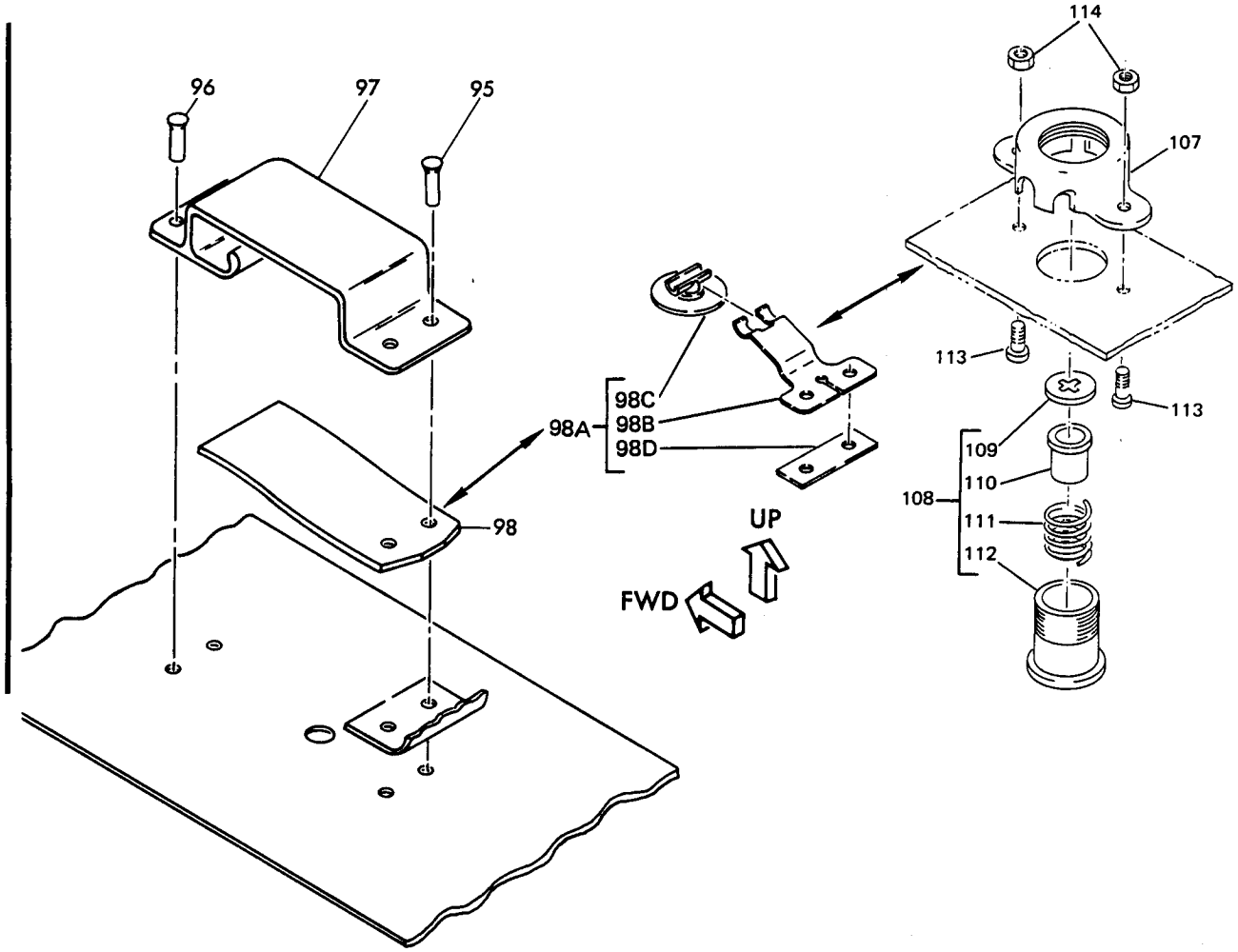
Lower Body Forward Access Door Assembly
Figure 1101 (Sheet 4)



VIEW 1



DETAIL D



VIEW 2

Lower Body Forward Access Door Assembly
Figure 1101 (Sheet 6)

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
	65-22216-2		LOWER BODY FORWARD ACCESS DOOR ASSY	A	RF
	65-22216-57		LOWER BODY FORWARD ACCESS DOOR ASSY	B	RF
	65-22216-113		LOWER BODY FORWARD ACCESS DOOR ASSY (PRE SB 737-32-1396) (PRE SB 737-32-1400)	C	RF
	65-22216-155		LOWER BODY FORWARD ACCESS DOOR ASSY	D	RF
	65-22216-174		LOWER BODY FORWARD ACCESS DOOR ASSY	E	RF
	65-22216-178		LOWER BODY FORWARD ACCESS DOOR ASSY	F	RF
1	BACB30GW6-6		. BOLT	ACDEF	12
1	NAS1104-6W		. BOLT	B	1
2	BACC30M6		. COLLAR (REPLS BACC30K6)	ACDEF	12
2	BACN10JC4		. NUT (REPLS NAS679A4W)	B	1
3	AN960D416		. WASHER	B	1
4	BACR15CE8D		. RIVET	B	10
5	69-22788-3		DELETED		
5	69-22788-5		. HINGE PLATE	ACE	1
5	69-45716-1		. HINGE PLATE	B	1
5	69-22788-7		. HINGE PLATE	DF	1
5	69-22788-7		. HINGE PLATE (OPT)	E	1
6	69-22788-4		DELETED		
6	69-22788-6		. HINGE PLATE (OPP 69-22788-5)	ACE	1
6	69-45716-2		. HINGE PLATE (OPP 69-45716-1)	B	1
6	69-22788-8		. HINGE PLATE (OPP 69-22788-7)	DF	1
6	69-22788-8		. HINGE PLATE (OPT)	E	1
7	BACR15BB6D		. RIVET (REPLS MS20470D6)		16
8	65-22216-43		. PLATE, STRIKER	A-E	1
8	65-22216-179		. PLATE, STRIKER	F	1
9	65-22216-3		. FRAME, FORWARD	A	1
9	65-22216-103		. FRAME, FORWARD	B	1
9	65-22216-114		. FRAME, FORWARD (LIMITED)	C	1
9	65-22216-124		. FRAME, FORWARD (LIMITED)	C	1
9	65-22216-134		. FRAME, FORWARD (LIMITED)	C	1
9	65-22216-134		. FRAME, FORWARD (OPT)	E	1
9	65-22216-152		. FRAME, FORWARD (OPT)	DEF	1
9	65-22216-176		. FRAME, FORWARD (OPT)	DEF	1
10	65-22216-4		. FRAME, AFT (LIMITED)	AC	1
10	65-22216-104		. FRAME, AFT	B	1
10	65-22216-123		. FRAME, AFT (LIMITED)	AC	1
10	65-22216-123		. FRAME, AFT	E	1
10	65-22216-145		. FRAME, AFT (OPT)	E	1
10	65-22216-145		. FRAME, AFT	DF	1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-11	MS27253F1		. PLATE, IDENTIFICATION AND MODIFICATION (REPLS AN7510F1)		
12	10-60476-9		. SEAL, V75345 (BOEING 10-60476-9)	BCDEF	1
13	65-22216-53		. SEAL ASSY	A	1
14	65-22216-52		. . CLOTH, REINFORCING		1
15	65-22216-42		. . SEAL		1
16	BACR15BA4D		. RIVET (REPLS MS20426D4)		58
17	65-22216-45		. CHANNEL, SEAL RETAINER (PREF TO 65-22216-40 WHEN USED WITH 65-22216-44 AND 65-22216-46)	AE	1
17	65-22216-88		. CHANNEL, SEAL RETAINER (PREF TO 65-22216-85 WHEN USED WITH 65-22216-87 AND 65-22216-89)	BC	1
17	65-22216-170		. CHANNEL, SEAL	DF	1
17	65-22216-170		. CHANNEL, SEAL RETAINER (OPT)	E	1
18	65-22216-46		. CHANNEL, SEAL RETAINER (OPP 65-22216-45)(PREF TO 65-22216-40 WHEN USED WITH 65-22216-44 AND -45)	AE	1
18	65-22216-89		. CHANNEL, SEAL RETAINER (OPP 65-22216-88)(PREF TO 65-22216-85 WHEN USED WITH 65-22216-87 AND -88)	BC	1
18	65-22216-169		. CHANNEL, SEAL RETAINER (OPP 65-22216-170)	DF	1
18	65-22216-169		. CHANNEL, SEAL RETAINER (OPT)	E	1
19	65-22216-47		. CHANNEL, SEAL RETAINER (PREF TO 65-22216-41 WHEN USED WITH 65-22216-48 AND -49)	A	1
19	65-22216-90		. CHANNEL, SEAL RETAINER (PREF TO 65-22216-107 WHEN USED WITH 65-22216-91 AND -108)	B	1
19	65-22216-111		. CHANNEL, SEAL RETAINER (PREF TO 65-22216-115 WHEN USED WITH 65-22216-110 AND -112)	CE	1
19	65-22216-140		. CHANNEL, SEAL RETAINER	DF	1
19	65-22216-140		. CHANNEL, SEAL RETAINER (OPT)	E	1
20	65-22216-48		. CHANNEL, SEAL RETAINER (OPP 65-22216-47)(PREF TO 65-22216-41 WHEN USED WITH 65-22216-47 AND -49)	A	
20	65-22216-91		. CHANNEL, SEAL RETAINER (OPP 65-22216-90)(PREF TO 65-22216-107 WHEN USED WITH 65-22216-90 AND -108)	B	

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
20	65-22216-112		. CHANNEL, SEAL RETAINER (OPP 65-22216-111)(PREF TO 65-22216-115 WHEN USED WITH 65-22216-110 AND -111)	CE	1
20	65-22216-141		. CHANNEL, SEAL RETAINER (OPP 65-22216-140)	DF	1
20	65-22216-141		. CHANNEL, SEAL RETAINER (OPT)	E	1
21	65-22216-44		. CHANNEL, SEAL RETAINER (PREF TO 65-22216-40 WHEN USED WITH 65-22216-45 AND -46)	A	1
21	65-22216-87		. CHANNEL, SEAL RETAINER (PREF TO 65-22216-85 WHEN USED WITH 65-22216-88 AND -89)	B	1
21	65-22216-117		. CHANNEL, SEAL RETAINER	CE	1
21	65-22216-143		. CHANNEL, SEAL RETAINER	D	1
21	65-22216-143		. CHANNEL, SEAL RETAINER (OPT)	E	1
21	65-22216-143		. CHANNEL, SEAL RETAINER (LIMITED)	F	1
21	65-22216-180		. CHANNEL, SEAL RETAINER (LIMITED)	F	1
22	65-22216-49		. CHANNEL, SEAL RETAINER (PREF TO 65-22216-41 WHEN USED WITH 65-22216-47 AND -48)	A	1
22	65-22216-108		. CHANNEL, SEAL RETAINER (PREF TO 65-22216-107 WHEN USED WITH 65-22216-90 AND -91)	B	1
22	65-22216-110		. CHANNEL, SEAL RETAINER (PREF TO 65-22216-115 WHEN USED WITH 65-22216-111 AND -112)	CE	1
22	65-22216-139		. CHANNEL, SEAL RETAINER	DF	1
22	65-22216-139		. CHANNEL, SEAL RETAINER (OPT)	E	1
23	BACR15BA4D		. RIVET (REPLS MS20426D4)		52
24	65-22216-40		. CHANNEL, SEAL RETAINER (OPT TO 65-22216-44,-45 AND -46)	A	1
24	65-22216-85		. CHANNEL, SEAL RETAINER (OPT TO 65-22216-44,-45 AND -46 OR -88, -89 AND -117)	BC	1
25	65-22216-41		. CHANNEL, SEAL RETAINER (OPT TO 65-22216-47,-48 AND -49)	A	1
25	65-22216-107		. CHANNEL, SEAL RETAINER (OPT TO 65-22216-90,-91 AND -108)	B	1
25	65-22216-115		. CHANNEL, SEAL RETAINER (OPT TO 65-22216-110,-111 AND -112 OR -47, -49 AND -112)	C	1
26	NASI103-27W		. BOLT		1
27	BACN10J3		. NUT (REPLS NAS679A3W)		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
28	AN960PD10		. WASHER		1
29	BACB30DX6-4		. BOLT	B	28
30	BACC30M6		. COLLAR	B	28
31	BACB30LB6-4		. BOLT, BLIND	B	4
32	69-45711-5		. BEAM, HINGE	B	1
33	69-45711-6		. BEAM, HINGE (OPP 69-45711-5)	B	1
34	BACR15BB5D		. RIVET (REPLS MS20470D5)	ACDEF	27
34	BACR15BB5D		. RIVET (REPLS MS20470D5)	B	66
35	NAS1398D6		. RIVET		8
36	65-22216-109		. SKIN PANEL, INNER DOOR (REPLS 65-22216-60)	B	1
36	65-22216-8		. SKIN PANEL, INNER DOOR	A	1
36	65-22216-8		. SKIN PANEL, INNER DOOR (LIMITED)	C	1
36	65-22216-133		. SKIN PANEL, INNER DOOR (LIMITED)	C	1
36	65-22216-133		. SKIN PANEL, INNER DOOR	E	1
36	65-22216-151		. SKIN PANEL, INNER DOOR	DF	1
36	65-22216-151		. SKIN PANEL, INNER DOOR (OPT)	E	1
37	BACR15BB6D		. RIVET (USED WITH 69-22752-1,-2,-9 AND -10)(REPLS MS20470D6)	ACDEF	12
37	BACR15BB6D		. RIVET (USED WITH 69-45495-1 AND -2) (REPLS MS20470D6)	B	12
38	BACB30GW6		. BOLT (USED WITH 69-22752-1,-2,-9 AND -10)(REPLS BACB30N6-4)	ACDEF	10
39	BACC30M6		. COLLAR (USED WITH 69-22752-1,-2,-9 AND -10)(REPLS BACC30K6)	ACDEF	10
40	BACR15CE6D		. RIVET (USED WITH 69-45495-1 AND -2)	B	20
41	BACR15BB6D		. RIVET (USED WITH 69-22752-3,-4,-13 AND -14)(REPLS MS20470D6)	ACDEF	24
41	BACR15BB6D		. RIVET (USED WITH 69-45495-3 AND -4) (REPLS MS20470D6)	B	12
42	BACR15CE6D		. RIVET (USED WITH 6945495-3 AND -4)	B	20
43	69-22752-1		. STOP	ACE	1
43	69-45495-1		. STOP	B	1
43	69-22752-9		. STOP	DF	1
43	69-22752-9		. STOP (OPT)	E	1
44	69-22752-2		. STOP (OPP 69-22752-1)	ACE	1
44	69-45495-2		. STOP (OPP 69-45495-1)	B	1
44	69-22752-10		. STOP (OPP 69-22752-9)	DF	1
44	69-22752-10		. STOP (OPT)(OPP 69-22752-9)	E	1
45	69-22752-7		. STOP (REPLS 69-22752-3)	ACE	1
45	69-22752-5		. STOP (OPT)	ACE	
45	69-22752-3		. STOP (REPLD BY 69-22752-7)	AC	1
45	69-45495-3		. STOP	B	1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
45	69-22752-13		. STOP	DF	1
45	69-22752-13		. STOP (OPT)	E	1
45	69-22752-11		. STOP (OPT)	D	1
46	69-22752-8		. STOP (OPP 69-22752-7, REPLS -4)	ACE	1
46	69-22752-6		. STOP (OPT)	ACE	
46	69-22752-4		. STOP (OPP 69-22752-3, REPLD BY 69-22572-8)	AC	
46	69-45495-4		. STOP (OPP 69-45495-3)	B	1
46	69-22752-14		. STOP (OPP 69-22752-13)	DF	1
46	69-22752-14		. STOP (OPT)	E	1
46	69-22752-12		. STOP (OPP 69-22752-11)(OPT)	D	1
47	MS24665-132		. COTTER PIN (REPLS AN380-2-2)		2
48	NASI104-10DW		. BOLT		
49	BACN10JD4		. NUT (REPLS AN310-4)		2
50	AN960-416		. WASHER		2
51	65-22216-31		. LINK ASSY		1
52	BACR15BB5D		. . RIVET (REPLS MS20470D5)		1
53	NAS42-5-28		. . SPACER		1
54	65-22216-32		. . LINK HALF		2
55	BACR15CE5D		. RIVET		22
56	H31-33		DELETED		
56	H31-35		. LOCK ASSY, FLUSH, V83014 (SB 52-29)		1
57	65-22216-38		. CHANNEL ASSY	ABCE	1
57	65-22216-171		. CHANNEL ASSY	DF	1
58	65-22216-39		. . STRIP, RUB		1
59	65-22216-27		. . CHANNEL, SUPPORT (USED ON 65-22216-38)		1
59	65-22216-172		. . CHANNEL, SUPPORT (USED ON 65-22216-171)		1
60	90-3173-3		. PIN ASSY, LATCH	A	1
60	69-45433-1		. PIN ASSY, LATCH	BCDEF	1
61	BACB10N6		. . BEARING, ROD END (PREF)		1
61	NACB10A278		. . BEARING, ROD END (OPT)		1
61	BACB10A278L		. . BEARING, ROD END (OPT)		1
62	NAS513-5		. . WASHER		1
63	NAD509-5		. . NUT		1
64	90-3173-4		. . PIN, LATCH (USED ON 90-3173-3)		1
64	69-45433-2		. . PIN, LATCH (USED ON 69-45433-1)		1
65	BACR15BB5D		. RIVET (REPLS MS20470D5)	ACDEF	5
66	69-21366-1		. SUPPORT ASSY, LATCH PIN	A	1
67	NAS75-8-028		. . BUSHING		1
68	69-21366-3		. . SUPPORT, LATCH PIN		1
69	BACR15BB5D		. RIVET (REPLS MS20470D5)	ACDEF	6

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
70	69-21366-2		. SUPPORT ASSY, LATCH PIN	A	1
71	NAS75-8-022		. . BUSHING		1
72	69-21366-4		. . SUPPORT, LATCH PIN		1
73	69-56303-1		. SUPPORT ASSY, LATCH PIN	CE	1
73	69-56303-5		. SUPPORT ASSY, LATCH PIN	DF	1
74	NAS75-11-19		. . BUSHING		1
75	69-56303-3		. . SUPPORT, LATCH PIN (USED ON 69-56303-1)		1
75	69-56303-7		. . SUPPORT, LATCH PIN (USED ON 69-56303-5)		1
76	69-56303-2		. SUPPORT ASSY, LATCH PIN	CE	1
76	69-56303-6		. SUPPORT ASSY, LATCH PIN	DF	1
77	NAS75-11-27		. . BUSHING		1
78	69-56303-4		. . SUPPORT, LATCH PIN (USED ON 69-56303-2)		1
78	69-56303-8		. . SUPPORT, LATCH PIN (USED ON 69-56303-6)		1
79	NAS602-4P		. SCREW, REPLS NAS602-4)	B	7
80	NAS602-5P		. SCREW (REPLS NAS602-5)	B	1
81	BACN10JC08		. NUT (REPLS NAS679A08W)	B	8
82	AN960D8		. WASHER	B	9
83	BACR15BB6D		. RIVET (REPLS MS20470D6)	B	3
84	69-45431-2		. SUPPORT, LATCH PIN	B	1
85	69-45435-5		. BRACKET, LATCH PIN	B	1
86	BACR15CE8D		. RIVET	B	5
87	69-45431-1		. SUPPORT, LATCH PIN	B	1
88	BACR15CE5D		. RIVET (LIMITED)	A	8
89	65-22216-37		. SEAL ASSY (LIMITED)	A	1
90	66-37080-1		. . COVER, DRAIN		1
91	90-4007-3008		. . VALVE ASSY, WATER		1
92	90-4007-3004		. . . RETAINER		1
93	90-4007-3009		. . . SEAL		1
94	90-4007-3010		. . ANGLE, VALVE		1
95	BACR15CE5B		. RIVET (USED WITH 69-68855-1)	BC	2
95	BACR15BA5D		. RIVET (USED WITH 90-4007-3009)	BC	2
96	BACR15BA4A		. RIVET (LIMITED)(REPLS MS20426A4)	BC	2
97	69-41867-1		. RETAINER, SEAL (LIMITED)	AC	1
97	69-41867-3		. RETAINER, SEAL (LIMITED)	AC	1
98	90-4007-3009		. SEAL (LIMITED)	AC	1
98	90-4007-3009		. SEAL	B	1
98A	69-68855-1		. VALVE ASSY, SPRING (LIMITED)	AC	1
98B	69-68855-2		. . SPRING		1
98C	69-68856-1		. . VALVE		1
98D	69-68856-2		. FILLER (USED WITH 60-68855-1)	AC	1
					1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-99	BACB30LU3-10		. SCREW, CSK (SB 52-2)(REPLS NAS517-3-10)		
100	BACN10JC3		. NUT (REPLS NAS679A3W)(SB 52-2)		1
101	AN960PD10		. WASHER (SB 52-2)		1
102	66-21238-1		. PIN, GUIDE (SB 52-2)		1
103			. BASIC ASSEMBLY, FORWARD ACCESS DOOR		
104	66-25982-1		. SPRING (POST SB 52-123)	A	1
105	AN960C816		. WASHER (POST SB 52-123)	A	2
106	MS24665-283		. PIN, COTTER (POST SB 52-123)	A	1
107	140N2021-1		. RETAINER VALVE (LIMITED)	C	1
107	140N2021-1		. RETAINER VALVE	DEF	1
108	140N2022-1		. VALVE ASSY - DRAIN (LIMITED)	C	1
108	140N2022-1		. VALVE ASSY - DRAIN	DEF	1
109	140N2022-4		. . CAP (USED ON 140N2022-1)		1
110	140N2022-3		. . PLUNGER (USED ON 140N2022-1)		1
111	140N2020-1		. . SPRING (USED ON 140N2022-1)		1
112	140N2022-2		. . HOUSING (USED ON 1140N2022-1)		1
113	BACB30NW5K3		. BOLT	CDEF	2
114	BACN10JC08CD		. NUT	CDEF	2
115	65-22216-118		. BUMPER	CE	2
115	65-22216-118		. BUMPER (LIMITED)	D	2
115	65-22216-177		. BUMPER (LIMITED)	D	2
115	65-22216-177		. BUMPER	F	2

VENDORS

V75345	KIRKHILL RUBBER CO., 300 E. CYPRESS ST., BREA, CALIFORNIA 92621
V83014	HARTWELL CORP., 900 S. RICHFIELD RD., PLACENTIA, CALIFORNIA 92670
V97613	SARGENT INDUSTRIES, KAHR BEARING DIV., 3010 N. SAN FERNANDO BLVD., BURBANK, CALIFORNIA 91504

Part No.	Fig. and Index No.	Qty. per Assy
AN310-4	1101-	AR
AN380-2-2		AR
AN7510F1		AR
AN960-416		AR
AN960C816		AR
AN960D416		AR
AN960D8		AR
AN960PD10		AR
BACB10A278	61	1
BACB10N6	61	1
BACB30DX6-4	29	28
BACB30GW6-4	38	10
BACB30GW6-6	1	12
BACB30LB6-4	31	4
BACB30LU3-10	99	1
BACB30NW5K3	113	2
BAC30N6-4	38	10
BACB30N6-6	1	12
BACC30K6	2	12
BACC30K6	39	10
BACC30M6	2	12
BACC30M6	30	28
BACC30M6	39	10
BACN10JC08	81	8
BACN10JC08CD	114	2
BACN10JC3	27	1
BACN10JC3	100	1
BACN10JC4	2	1
BACN10JD4	49	2
BACR15BA4A	96	2
BACR15BA4D	16	58
BACR15BA4D	23	52
BACR15BA5A	95	2
BACR15BB5D	34	27
BACR15BB5D	34	66
BACR15BB5D	52	1
BACR15BB5D	65	5
BACR15BB6D	7	16
BACR15BB6D	37	12
BACR15BB6D	41	12
BACR15BB6D	41	24
BACR15BB6D	83	3
BACR15CE5B	95	2
BACR15CE5D	55	22
BACR15CE5D	88	8
BACR15CE6D	40	20
BACR15CE6D	42	20
BACR15CE8D	86	5
BACR15CE8D	4	10
H31-35	56	1
MS20426A4		AR
MS20426D4		AR
MS20470D5		AR
MS20470D6		AR
MS24665-132		AR
MS24665-283		AR
MS27253F1		AR
MS35337-25		AR
NAS1103-27W		AR
NAS1104-10DW		AR
NAS1104-6W		AR
NAS1398D6		AR
NAS1104-6W		AR
NAS42-5-28		AR
NAS509-5		AR
NAS513-5		AR
NAS517-3-10		AR
NAS602-4		AR
NAS602-4P		AR
NAS602-5		AR
NAS602-5P		AR
NAS679A08W		AR
NAS679A3W		AR
NAS679A4W		AR
NAS75-11-19		AR
NAS75-11-27		AR
NAS75-8-022		AR
NAS75-8-028		AR
10-60476-9	12	1
140N2020-1	111	1
140N2021-1	107	1
140N2022-1	108	1
140N2022-2	112	1
140N2022-3	110	1
140N2022-4	109	1
65-22216-103	9	1
65-22216-104	10	1
65-22216-107	25	1

Part No.	Fig. And Index No.	Qty. per Assy.
65-22216-108	1101-22	1
65-22216-109	36	1
65-22216-110	22	1
65-22216-111	19	1
65-22216-112	20	1
65-22216-113	1101	RF
65-22216-114	9	1
65-22216-115	25	1
65-22216-117	21	1
65-22216-118	115	2
65-22216-123	10	1
65-22216-124	9	1
65-22216-133	36	1
65-22216-134	9	1
65-22216-139	22	1
65-22216-140	19	1
65-22216-141	20	1
65-22216-143	21	1
65-22216-145	10	1
65-22216-151	36	1
65-22216-152	9	1
65-22216-155	1101	
65-22216-169	18	1
65-22216-170	17	1
65-22216-171	57	1
65-22216-172	59	1
65-22216-174	1101	RF
65-22216-176	9	1
65-22216-177	115	2
65-22216-178	1101	RF
65-22216-179	8	1
65-22216-180	21	1
65-22216-2	1101	RF
65-22216-27	59	1
65-22116-3	9	1
65-22116-31	51	1
65-22116-32	54	2
65-22216-37	89	1
65-22216-38	57	1
65-22216-39	58	1
65-22216-4	10	1
65-22216-40	24	1
65-22216-41	25	1
65-22216-42	15	1
65-22216-43	8	1
65-22216-44	21	1
65-22216-45	17	1
65-22216-46	18	1
65-22216-47	19	1
65-22216-48	20	1

Part No.	Fig. And Index No.	Qty. per Assy.
65-22216-49	22	1
65-22216-52	14	1
65-22216-53	13	1
65-22216-57	1101	RF
65-22216-60	36	1
65-22216-8	36	1
65-22216-85	24	1
65-22216-87	21	1
65-22216-88	17	1
65-22216-89	18	1
65-22216-90	19	1
65-22216-91	20	1
66-21238-1	102	1
66-25982-1	104	1
66-37080-1	90	1
69-21366-1	66	1
69-21366-2	70	1
69-21366-3	68	1
69-21366-4	72	1
69-22752-1	43	1
69-22752-10	44	1
69-22752-11	45	1
69-22752-12	46	1
69-22752-13	45	1
69-22752-14	46	1
69-22752-2	44	1
69-22752-3	45	1
69-22752-4	46	1
69-22752-5	45	1
69-22752-6	46	1
69-22752-7	45	1
69-22752-8	46	1
69-22752-9	43	1
69-22788-3	5	1
69-22788-4	6	1
69-22788-5	5	1
69-22788-6	6	1
69-22788-7	5	1
69-22788-8	6	1
69-41867-1	97	1
69-41867-3	97	1
69-45431-1	87	1
69-45431-2	84	1
69-45433-1	60	1
69-45433-2	64	1
69-45435-5	85	1
69-45495-1	43	1
69-45495-2	44	1
69-45495-3	45	1
69-45495-4	46	1
69-45711-5	32	1

Part No.	Fig. and Index No.	Qty. per Assy
69-45711-6	33	1
69-45716-1	5	1
69-45716-2	6	1
69-56303-1	73	1
69-56303-2	76	1
69-56303-3	1101-75	1
69-56303-4	78	1
69-56303-5	73	1
69-56303-6	76	1
69-56303-7	75	1
69-56303-8	78	1
69-68855-1	98A	1
69-68855-2	98B	1
69-68856-1	98C	1
69-68856-2	98D	1
90-3173-3	60	1
90-3173-4	64	1
90-4007-3004	92	1
90-4007-3008	91	1
90-4007-3009	93	1
90-4007-3009	98	1
90-4007-3010	94	1

Part No.	Fig. and Index No.	Qty. per Assy