TO: ALL HOLDERS OF EQUIPMENT ACCESS DOOR ASSEMBLY OVERHAUL MANUAL, 52-46-04

REVISION NO. 10, DATED MAR 1/04

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
Changed part numbers on the title page to agree with the parts list													

EQUIPMENT ACCESS DOOR ASSEMBLY

52-46-04

BOEING P/N 65-45830-40, -42, -53, -64, -66, -118, -123, -129, -131, -505, -511, -513

AIRLINE P/N

THE FOLLOWING DIRECTIVES APPLY TO THIS SUBJECT:

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVES	DATE DIRECTIVE INCORPORATED INTO TEXT
52-1016		PRR 30323	Feb 15/69
		PRR 31387	Mar 10/70
		PRR 32180	Sep 25/73
52-1059		PRR 32552	Jan 5/77
		PRR 32653	Jan 5/80
		PRR 32950-4	Jan 5/80
		PRR 33184	Dec 5/83
52-1082			Dec 5/83
		PRR 34184	Sep 5/88
		PRR 34475-1	Dec 5/88
		PRR 34805	Mar 5/91
52-1112			Mar 1/95

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
52-46-04					
* T-1	Mar 1/04				
T-2	BLANK				
* LEP-1	Mar 1/04				
LEP-2	BLANK				
T/C-1	Sep 25/73				
T/C-2	BLANK				
1	Sep 25/73				
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101	Sep 5/88				
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202	BLANK				
301	Mar 5/91				
302	BLANK				
401	Dec 5/88				
402	Mar 5/91				
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602	BLANK				
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801	Feb 15/69				
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901	Feb 15/69				
902	BLANK				
1101	Mar 1/95				
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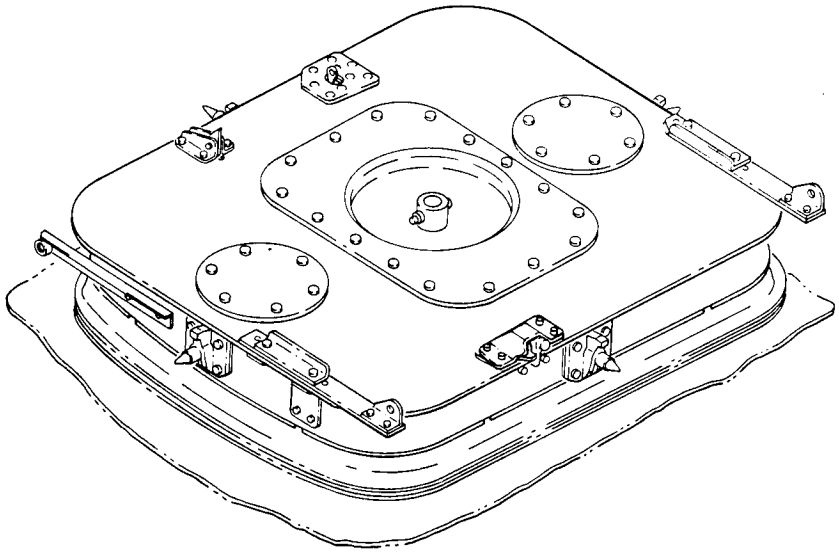
EQUIPMENT ACCESS DOOR ASSEMBLY



Equipment Access Door Assembly
Figure 1

DESCRIPTION AND OPERATION

1. Description

   A. The equipment access door is an inward-opening plug-type door located in the lower fuselage nose. It can be opened and closed from outside the airplane by a manually-operated handle recessed flush in the outer surface.

   B. Four latch pins, each having a rack-type gear, engage a pinion gear on the actuator shaft and move inward and outward when the handles are turned. A continuous weather and pressurization seal is attached around the entire edge of the door.

2. Operation

A. The door can be opened by pulling down the operating handle and rotating counterclockwise. This action withdraws all four latch pins.

B. The door is closed by drawing it forward on the rails until the forward rollers start to drop down the incline. The operating handle then is pulled out and rotated counterclockwise to retract all the latch pins, while at the same time continuing to draw the door forward. When the door is properly seated, a final clockwise rotation of the handle moves all four latch pins into place. The handle then can be allowed to return to its recess in the exterior skin of the door.

3. Leading Particulars

Width -- 21.60 inches (approximately)
Length -- 25.40 inches (approximately)
Thickness -- 4.50 inches (approximately)
Weight -- 15.00 pounds (approximately)

DISASSEMBLY

1. General

CAUTION: IF RETAINERS ARE NOT REMOVED FROM DOOR, PROTECTIVE COVERINGS MUST BE SUPPLIED AND EXTREME CARE TAKEN NOT TO DAMAGE RETAINERS DURING HANDLING OF DOOR. BENT OR DAMAGED RETAINER WILL RESULT IN EXCESSIVE PRESSURIZATION LEAKAGE WHEN DOOR IS INSTALLED ON AIRPLANE.

A. Remove seal (9, Fig. 1101) from retainers (1 thru 8).

NOTE: Do not remove retainers unless repair or replacement is necessary.

B. Remove bolts (10), washers (11), angles (12), and bracket assemblies (13 and 14).

NOTE: Do not remove nutplates (20) from door structure (104) unless repair or replacement is necessary.

C. Remove screws (23) and cover (22).

NOTE: Do not remove rivets (26) and nutplates (24 and 25) unless repair or replacement is necessary.

D. Remove screws (27) and cover (30).

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

E. Remove drain valve assembly (123) from retainer (130). Remove spring (129) and plunger (127) from housing (126).

NOTE: Do not remove cap (128) from housing (126), or retainer (130) from cover (30) unless replacement is necessary.

F. Remove screw (31), washer (32), nut (33), and retainer ring (37).

G. Remove nuts (41), washers (40), bolts (39), plate (42), spacers (43 thru 47), bearings (48), and washers (49).

H. Remove rack pin assemblies (38A, 38B and 38C), washers (50 and 51), and handle assembly (35).

I. Remove nuts (52), washers (53 or 54), bolts (55), washers (61C), and door stops (56, 59, 62, and 65) from door structure (104). Note location of removed shims (58A, 58B, 61A, 61B, 64A, 64B, 67A, and 67B).

NOTE: Do not remove bushings (58, 61, 64, and 67) from fittings (57, 60, 63, and 66) unless replacement is necessary. Do not remove bearing (134) from tee (133) unless replacement is necessary.

J. Refer to applicable manufacturer's overhaul instructions for handle assembly (35) and housing assembly (36).

NOTE: Do not remove housing assembly (36) from door structure unless repair or replacement is necessary.

K. Remove spring (68) from uplatch (69) and bolt (70).

L. Remove nut (72), washer (71), and bolt (70) from bracket (73).

M. Remove cotter pin (79), pin (76), washers (74, 77, and 78), packing (75), and uplatch (69).

N. Remove bolts (80), collars (81), and bracket (73).

P. Remove bolts (82), washers (83), nuts (84), bracket (85A), and guide (85).

Q. Remove lever (86) from rod assembly (87).

R. Remove striker (88) and remove washer (89) and pin (90) from lever (86).

S. Remove, as applicable, nuts (91), washers (89A, 89B, and 92), and spacer (87A) from rod assembly (87).

T. Remove nuts (95), washers (94), bolts (93), and bearing (96).

NOTE: Do not remove stop (97), angles (98 and 99), rivets (100, 101, and 103), or plate (102) unless repair or replacement is necessary.

U. Remove cotter pin (110), nut (109), bolt (108), pulley (107), cable assembly (106), and spring (105).

V. Remove nuts (111), washers (112 and 113), and roller assemblies (114).

W. Remove bolts (117) and washers (118).

NOTE: Do not remove rivets (119), nutplates (120), or guide angles (121) or further disassemble door structure (104) unless repair or replacement of components makes it necessary.

CLEANING

1. General

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

   B. Use a stiff-bristle brush or liquid abrasive blasting (vapor blast) to remove stubborn accumulations of foreign matter.

      NOTE: Do not vapor blast threaded or bearing surfaces or concentrate the blast in any one area.

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

   D. Remove any flash, grind marks, or other obstructions around handle assembly (35).

   E. For general information, refer to "General Cleaning Procedures," Subject 20-30-03.

2. Bearings (See figure 1101.)

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

INSPECTION/CHECK

1. Visual Checks (Fig. 1101)

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

   B. Examine all painted and plated surfaces for blisters or flaking.

   C. Examine seal (9) for tearing, security of splices, and deterioration.

   D. Check pin (76) for straightness and wear.

   E. Check striker (88) for cracks, tearing, and deterioration.

   F. Examine door structure assembly for security of rivets and corrosion.

2. Special Checks (Fig. 1101)

   A. If questionable areas are evident under visual examination, perform the following check:

      (1) Dye Penetrant Check -- Door stops (56, 59, 62, and 65), uplatch (69), stop (97), rod assembly (87), lever (86) and channel (136).

      NOTE: 20-20-02 contains information regarding penetrant check methods.

   B. Check latch assembly (34) per manufacturer's instructions.

   C. Check bearings (48 and 96) and bushings (58, 61, 64, and 67) for roughness, binding, and excessive radial or axial play.

   D. Check spring (68) for free length of approximately 1.75 inches and length of 3.86 to 4.72 inches with 4.83-pound tensile load applied.

      NOTE: Spring should not wobble when rolled on a flat surface.

   E. Check parts listed in Fig. 601 for specified permissible wear limits.

REPAIR

1. Repair (Fig. 1101)

   A. Remove minor scratches, nicks, and corrosion by polishing lightly with abrasive cloth, 220 grit or finer. Refinish as necessary for protection against corrosion.

   B. Remove minor defects from threads with small triangular file or thread chaser.

   C. File minor defects in rack pin assembly (38) rack gear teeth.

2. Refinish (Fig. 1101)

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

   A. Angle (12, 69-40758-6), brackets (16, 69-40758-9; 85A), angles (98 and 99) and guide angles (121) -- Alodize or chromic acid anodize and apply one coat of BMS 10-11, type 1 primer (SRF-2.30) all over. Material: Al Alloy.

   B. Angle (12, 69-40758-10) and bracket (16, 69-40758-13) -- Chromic acid anodize and apply one coat of BMS 10-11, type 1 primer (F-18.13) plus apply one coat of BMS 10-11, type II enamel, color BAC702 white gloss (F-21.03). Omit enamel from hole on bracket, 69-40758-13. Material: Al Alloy.

   C. Spring (15) -- Cadmium plate and apply one coat of BMS 10-11, type 1 primer (SRF-1.92) all over.

   D. Covers (22; 30, 65-2163-37) and support (42, 65-2163-52) -- Alodize or chromic acid anodize and apply one coat of BMS 10-11, type 1 primer (F-18.05) all over. Material: Al Alloy.

   E. Cover (30, 65-2163-141) and support (42, 65-2163-140) -- Chemical treat. Apply one coat of BMS 10-11, type 1 primer (F-18.06) plus one coat of BMS 10-11, type II enamel, color BAC702 white gloss (F-21.03). Material: Al Alloy.

   F. Doorstops (56, 59, 62, 65; 69-2158-501 thru -504) -- Cadmium plate (F-4.20) all over and apply one coat of BMS 10-11, type 1 primer on faying surface. Material: Al Bronze or Beryllium Copper.

   G. Doorstops (56, 59, 62, 65; 69-2158-9 thru -12) -- Cadmium plate and apply one coat of BMS 10-11, type 1 primer (F-16.01). Apply one coat of BMS 10-11, type II enamel, color BAC702 white gloss (F-21.03). Material: Al Bronze or Beryllium Copper.

   H. Bushings (58, 61, 64, and 67) -- Cadmium plate (F-4.201) all over except on inside diameter. Material: Al-Ni-Bronze.

I. Guide (85) -- Apply one coat of BMS 10-11, type 1 primer (SRF-12.205) all over. Material: Phenolic.

J. Lever (86)

(1) 69-52240-1 and 69-59206-1 -- Passivate (F-8.07) all over. Material: CRES 410, 110-140 ksi; or CRES 301; or CRES 17-7PH, 150-170 ksi.

(2) 69-52221-1 -- Alodize or chromic acid anodize and apply one coat of BMS 10-11, type 1 primer (SRF-2.30) all over. Material: Al Alloy.

K. Stop (97) -- Passivate (F-8.07) all over. Material: CRES 301; or CRES 17-7PH, 150-170 ksi.

L. Uplatch (69) -- Passivate (F-8.07) all over. Material: CRES 301.

M. Spacer (44) -- Chromic acid anodize at 22 volts and seal in dilute chromate solution (Ref 20-43-01). Apply one coat BMS 10-11, type 1 primer plus BMS 10-11, type II enamel, color 702 white (F-21.18). Omit enamel from hole. Material: Al Alloy.

N. Tee (133, 69-77568-4) -- Chromic acid anodize at 22 volts and seal in dilute chromate solution (Ref 20-43-01). Apply BMS 10-11, type 1 primer plus BMS 10-11, type II enamel, color 702 white (F-21.18). Omit enamel from 0.6875-0.6883 inch diameter hole. Material: Al Alloy.

O. Channel (136, 65C35254-2) -- Chromic acid anodize at 22 volts and seal in dilute chromate solution (Ref 20-43-01). Apply BMS 10-11, type 1 primer plus BMS 10-11, type II enamel, color 702 white (F-21.18). Omit primer and enamel from bushing holes. Material: Al Alloy.

3. Replacement (Fig. 1101)

A. Replace all parts found unserviceable or damaged beyond simple repair.

B. Replace bearings (48, 96 and 131) and bushing (58, 61, 64, and 67), if found defective, per 20-50-03.

C. Replace pins (76) if worn or bent.

D. Replace cotter pins (79, 90, and 110) at each overhaul.

E. If necessary, replace bearing (134) in tee (133) and anvil swage per 20-50-03.

F. If necessary, replace bushings (137) in channel assembly. Install with BMS 5-95 primer.

ASSEMBLY

1. General

   A. Install all nuts and bolts with wet BMS 10-11, type 1 primer.

2. Procedures (Fig. 1101)

   A. Install bearing (96) on door structure (104) using bolts (93), washers (94), and nuts (95).

   B. Install bolt (70) on bracket (73) using washer (71) and nut (72).

   C. Install bracket (73) on door structure using bolts (80) and collars (81).

   D. Install, as applicable, nuts (91), washers (89A, 89B, and 92), and spacer (87A) on rod assembly (87).

      NOTE: Final adjustment of the nut or nuts (91) will be made when door is installed on airplane.

   E. Insert rod assembly (87) into bearing (96) and install lever (86), as applicable.

   F. Install striker (88) on lever (86), as applicable, using washer (89) and pin (90).

      NOTE: Rod (87) must operate freely with load applied at end of striker (88). If binding occurs, loosen nuts (95) and install laminations, as required, from BACS40A12-12 shim to bearing (96) at the required fasteners to eliminate the binding. Finish shims with wet or dry BMS 10-11, type 1 primer, after delaminating.

   G. Install uplatch (69) on rod assembly (87) using pins (76), packings (75), washers (74, 77, and 78), and cotter pins (79).

   H. Install spring (68) between uplatch (69) and bolt (70).

   J. Install guide (85) on door structure assembly using bolts (82), washers (83), and nuts (84).

   K. Install stops (56, 59, 62, and 65) on door structure (104) using shims (58A, 58B, 61A, 61B, 64A, 64B, 67A, and 67B), bolts (55), washers (53 or 54), and nuts (52).

      NOTE: Deleted

L. Install the following on door structure (104), as applicable; pulley (107) with bolt (108), nut (109), cotter pin (110), spring (105), and cable assembly (106); bolts (117), washers (112, 113, and 118), roller assemblies (114) and nuts (111).

M. Temporarily install rack pin assemblies (38A, 38B, 38C), washers (50, 51) bolts (39), spacers (43 thru 47) and bearings (48). Set rack pins to protrude 1.40 ±0.10 inch from stop fittings (56, 59, 62, 65). Measure protrusion from horizontal center-line of hole in fitting to tip of rack pin.

N. Position handle assembly (35) in alignment with recess in housing assembly (36) so that handle catch will engage pin. Insert handle assembly so that its pinion will engage teeth of rack pins. Permit rack pins to move up to 0.10 to engage nearest tooth. Measure gap between collar on rack pin assembly (38A) and stop fitting (62).

P. Remove rack pin assemblies and install required number of washers (61C) over end of rack pin (38A) to fill gap measured in par. N. Reassemble rack pins, washers, spacers, bearings, bolts and handle. Install plate (42) and retainer ring (37). Check that handle stops within 3 degrees of alignment with recess in housing assembly.

Q. Install washer (49) and plate support (42) on handle assembly (35).

R. Position spacers (43 thru 47) and bearings (48) and secure with bolts (39), washers (40), and nuts (41).

S. Install drain valve assembly (123) in retainer (130). If necessary, bond cap (128) to housing (126) with Loctite 495 or Loctite 416 adhesive per manufacturer's instructions. Do not bond plunger (127) to housing (126) or cap (128). Test valve assembly per TESTING.

T. Install washer (49), cover (30), and screws (27).

U. Install retainer ring (37) on shaft using screw (31), washer (32), and nut (33).

V. Assemble bracket assemblies (13 and 14) by installing parts (10 thru 12).

W. Install bracket assemblies (13 and 14) and angles (12) on door structure with bolts (10) and washers (11).

X. Install covers (22) with screws (23).

Y. Perform post assembly check as follows:

(1) Extend exterior handle (35).

(2) Apply inward force of 30 to 50 pounds end load on any latch pin (38) to cause rotation of handle inner shaft.

(3) On door assembly equipped with latch assembly (34) part number H759-99, remove and replace with H759-127 or rework per Service Bulletin 52-1082.

Z. Install seal (9) as follows (Fig. 501):

(1) For Assy 65-45830-505:

(a) Strip primer finish from cavity of retainers (1 thru 8).

CAUTION: MAKE SURE THE FLAP OF THE SEAL POINTS TOWARD THE ADJACENT EDGE OF THE DOOR AS SHOWN IN FIG. 501. CABIN PRESSURE PROBLEMS CAN OCCUR IF THE SEAL IS INSTALLED BACKWARDS.

(b) Place seal around door, locating seal corners in position with door corners.

(c) Press seal into position on retainers (1 thru 8) with approximately equal stretch along entire length of seal (d).

(d) Apply a continuous fillet seal of BMS 5-63 between upper and lower edges of retainers.

(e) Strip enamel and primer finish from contact surface on body structure to 0.50 in. from edge of door cutout.

(f) With the door in the closed position, the resistance between the door and the body structure shall not exceed 0.5 ohm.

(2) For all other assys:

CAUTION: MAKE SURE THE FLAP OF THE SEAL POINTS TOWARD THE ADJACENT EDGE OF THE DOOR AS SHOWN IN FIG. 501. CABIN PRESSURE PROBLEMS CAN OCCUR IF THE SEAL IS INSTALLED BACKWARDS.

(a) Place seal around door, locating seal corners in position with door corners.

(b) Press seal into position on retainers (1 thru 8) with approximately equal stretch along entire length of seal.

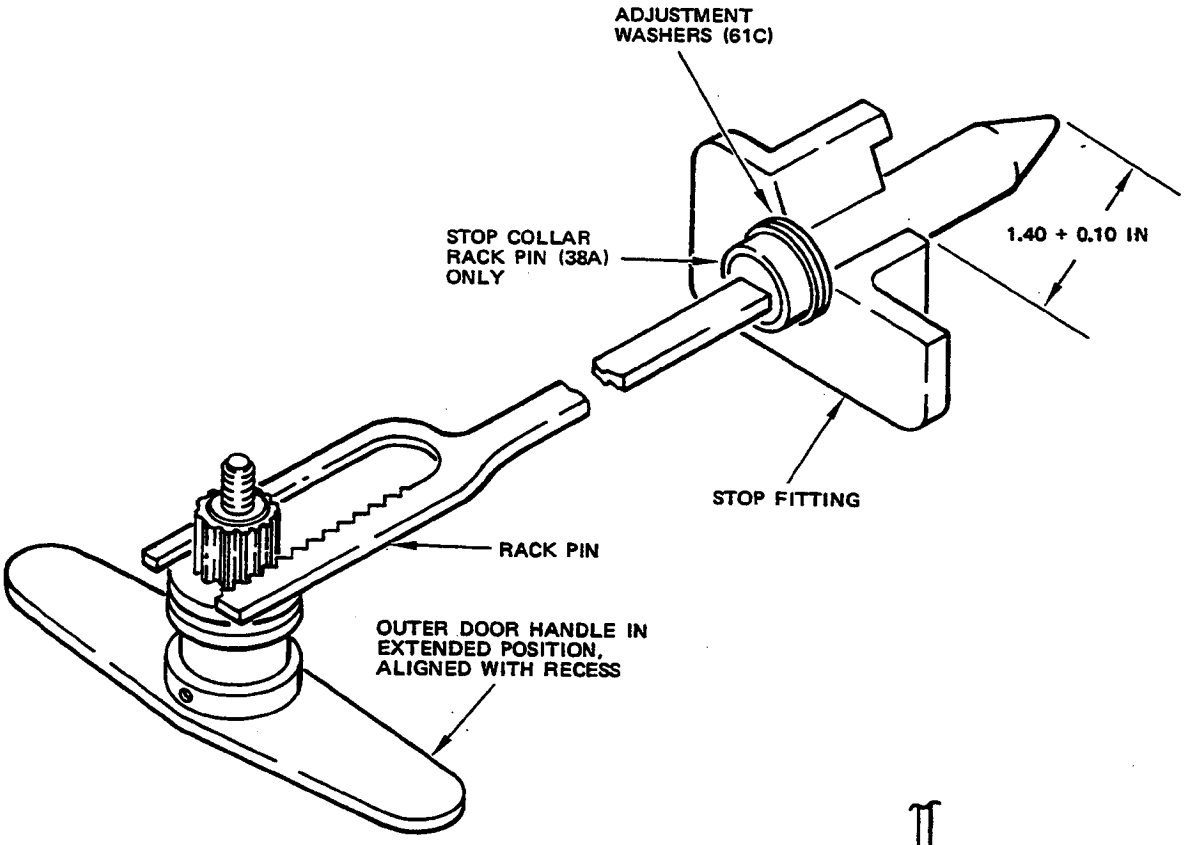
AA. Apply BMS 3-23 corrosion preventive compound (F-19.26) on all interior door structure that is accessable thru inner skin access panels and intercostal lightening holes. Avoid excessive overspray on door operating mechanism.

3. Materials

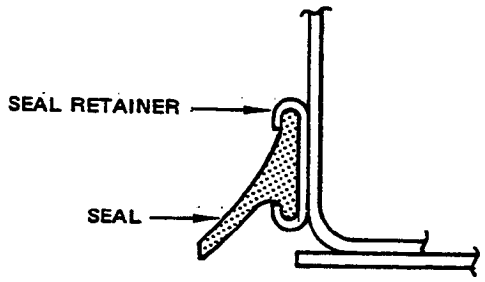
A. Primer-Sealant -- BMS5-63, Dow Corning RTV 1200, V71984.

B. Compound - Corrosion Inhibiting -- MIL-C-23411, BMS3-23 type 1, LPS-3, V32861.

C. Adhesive - Loctite 495 or 416, Loctite Corp., V06111.



HANDLE AND RACK PIN INSTALLATION



SEAL INSTALLATION

FITS AND CLEARANCES

1. and 2. Deleted.

Ref Letter Fig.601	Mating Item No. Fig.1101	Design Dimensions				Service Wear Limits		
		Dimensions (inches)		Assembly Clearance (inch)		Dimension Limits (inches)		Maximum Allowable Clearance (inch)
		Min	Max	Min	Max	Min	Max	
A	ID *[1]	0.4600	0.4730	0.0175	0.0405		0.477	0.045
	OD 38	0.4325	0.4425			0.432		
A	ID *[2]	0.448	0.453	0.0055	0.0205		0.457	0.025
	OD 38	0.4325	0.4425			0.432		

*[1] 56, P/N 65-62192-1 and 69-2158-5
59, P/N 65-62192-2 and 69-2158-6
62, P/N 65-62192-3 and 69-2158-7
65, P/N 65-62192-4 and 69-2158-8

*[2] 56, P/N 69-2158-501
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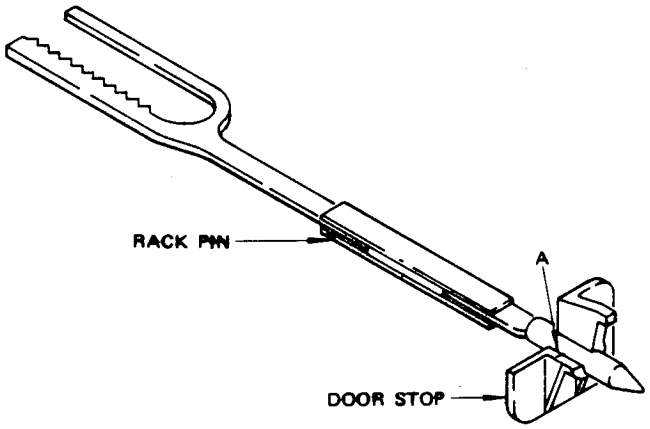
65, P/N 69-2158-504



Fits and Clearances
Figure 601

TESTING

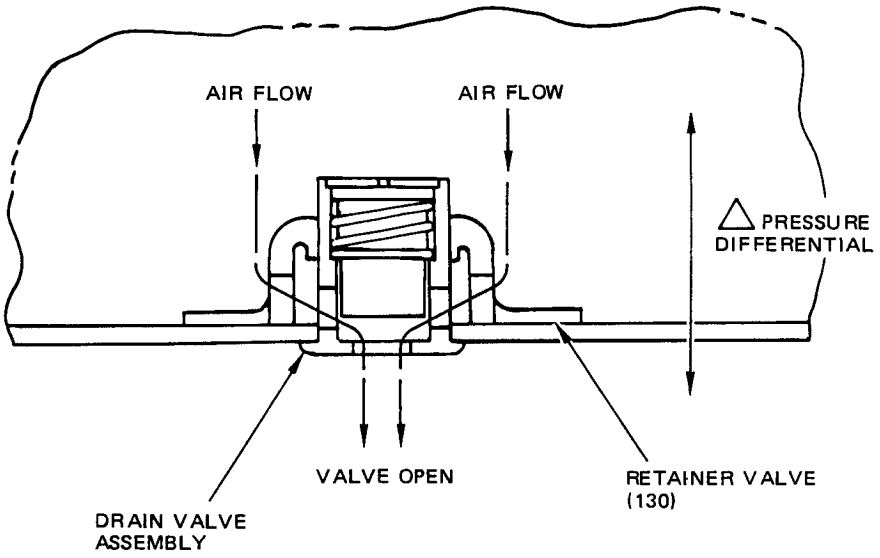
1. Press catch to release handle. Catch must not bind. Extend handle. Handle must engage internally with pinion gear shaft smoothly, and without movement of rack pins.

2. Rotate handle to retract latch pins to stop. The pins must not protrude beyond the outer surface of its stop fitting. Pins must be recessed an equal amount within 0.15 inch.

3. Rotate handle to extend latch pins to stop. Handle must align, within 3 degrees, with centerline of recess.

4. Retract handle. Catch must engage pin securely.

5. Verify that valve (123) opens and closes at 1.60-2.40 psi pressure differential. Flow must be as shown in Fig. 701.



Drain Valve Assembly Air Flow
Figure 701

TROUBLE SHOOTING

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

	Trouble	Possible Cause	Correction
A.	Lock mechanism binding	Bearings (48) binding	Adjust as necessary
B.	Seal (9) leakage	Incorrect installation or defective seal	Examine installation and replace defective seal
C.	Unable to move door handle	Broken latch pin gear teeth or actuator shaft	Replace defective parts
D.	Uplatch mechanism binding	Bearing (96) binding	Examine and correct as necessary

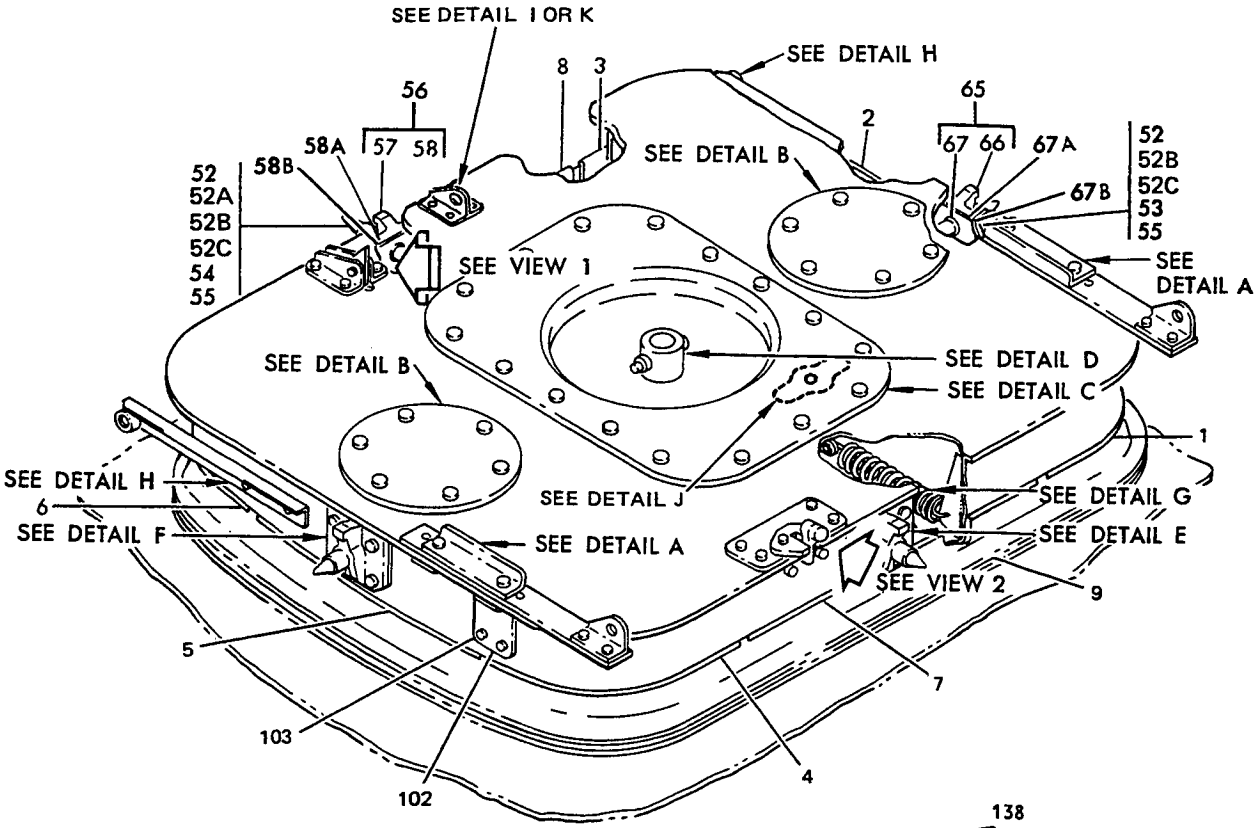
STORAGE INSTRUCTIONS

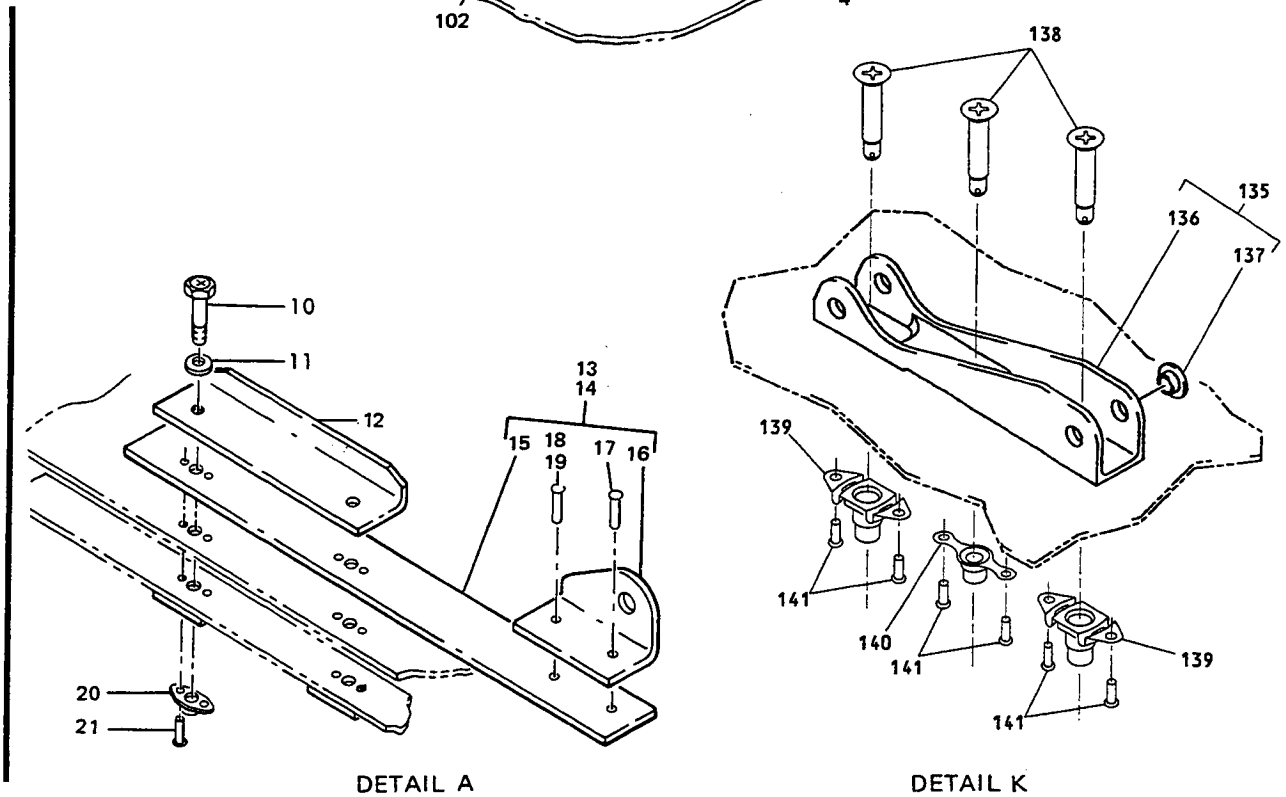
1. Wrap entire assembly in vapor barrier paper.

2. Tag with test date and cure date of O-ring packings and store.

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

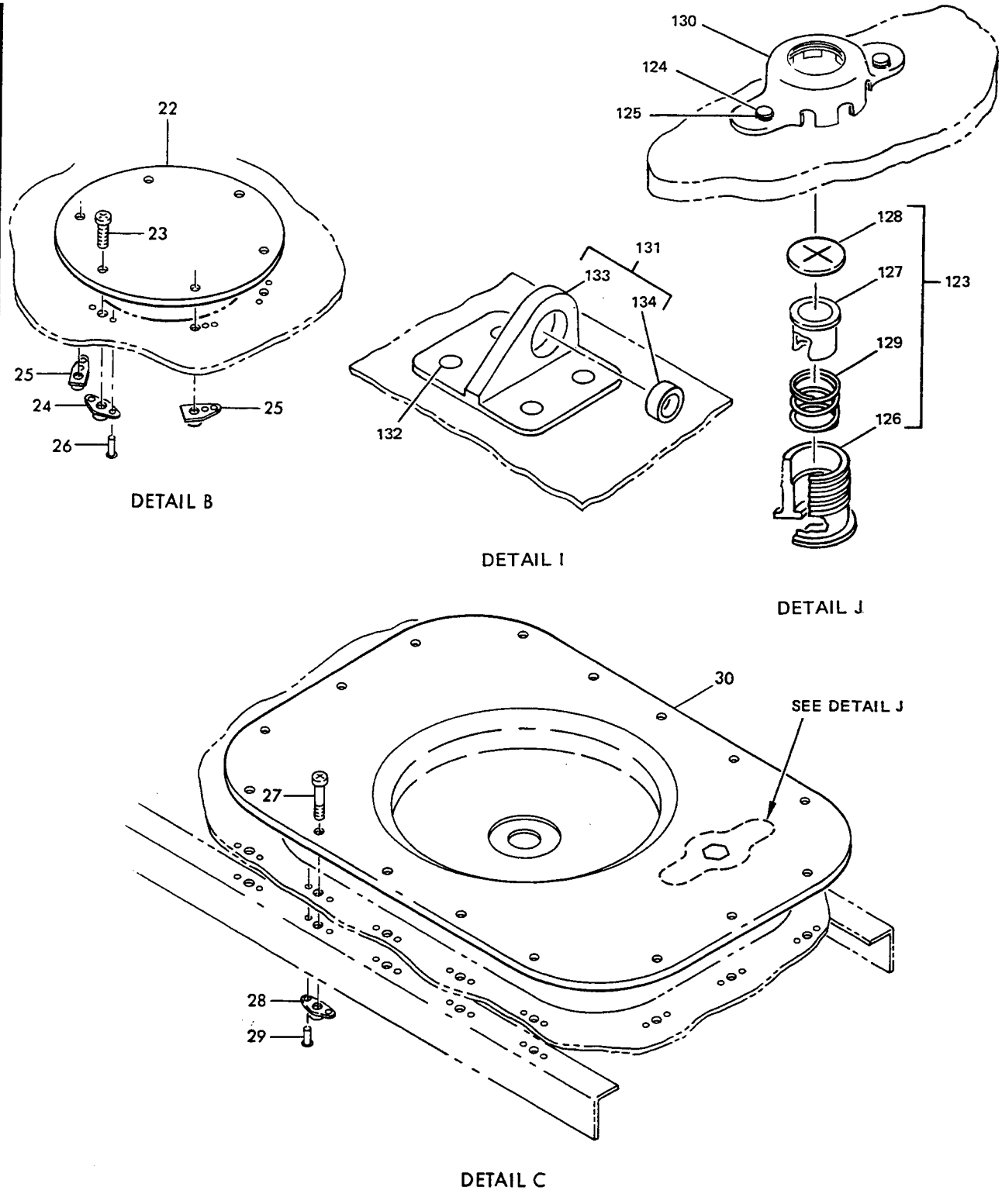
ILLUSTRATED PARTS LIST





DETAIL A

DETAIL K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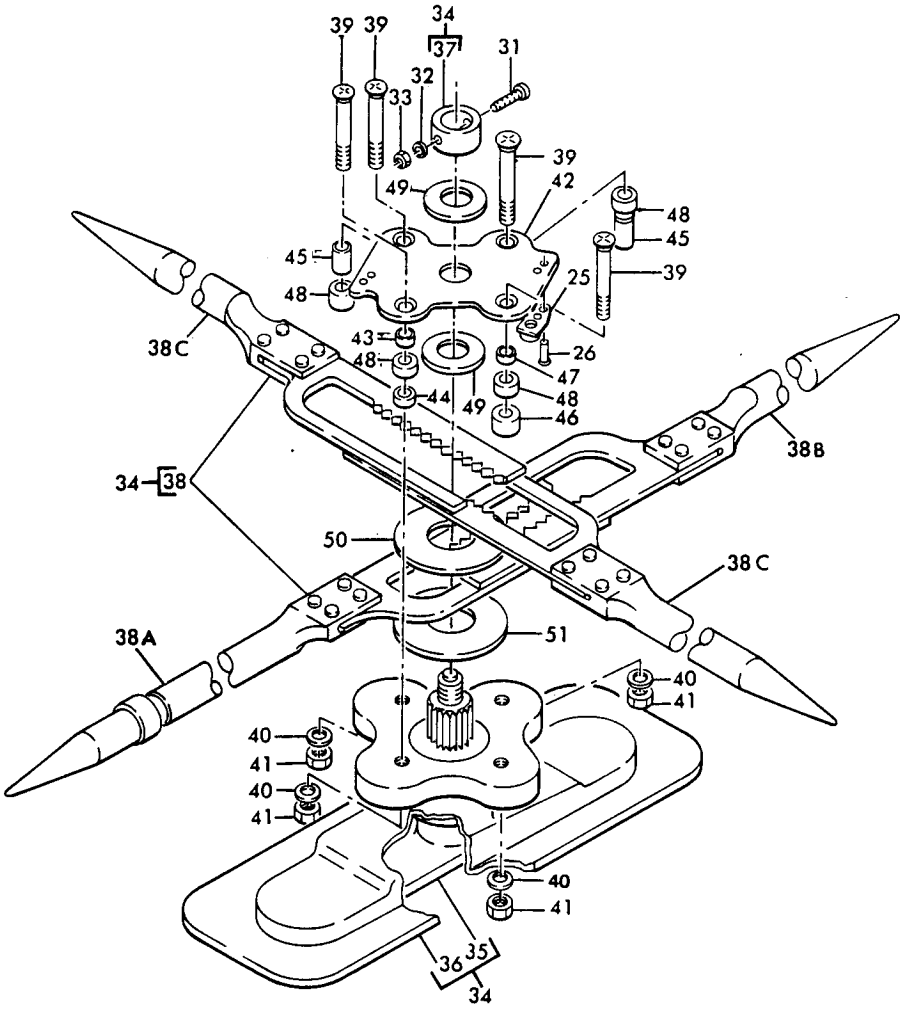
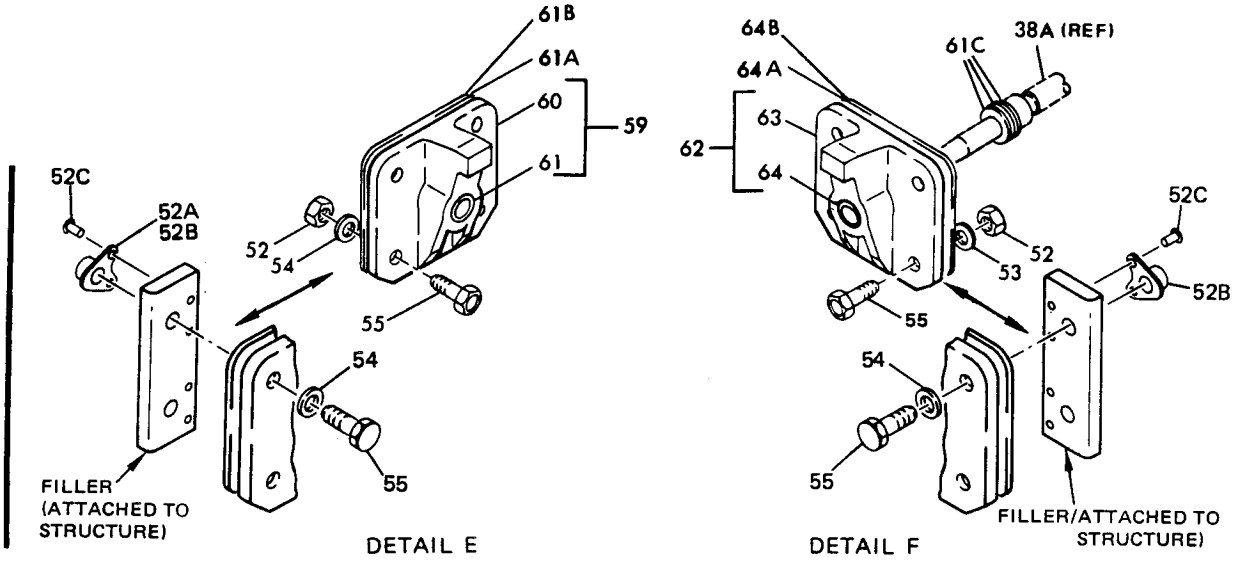
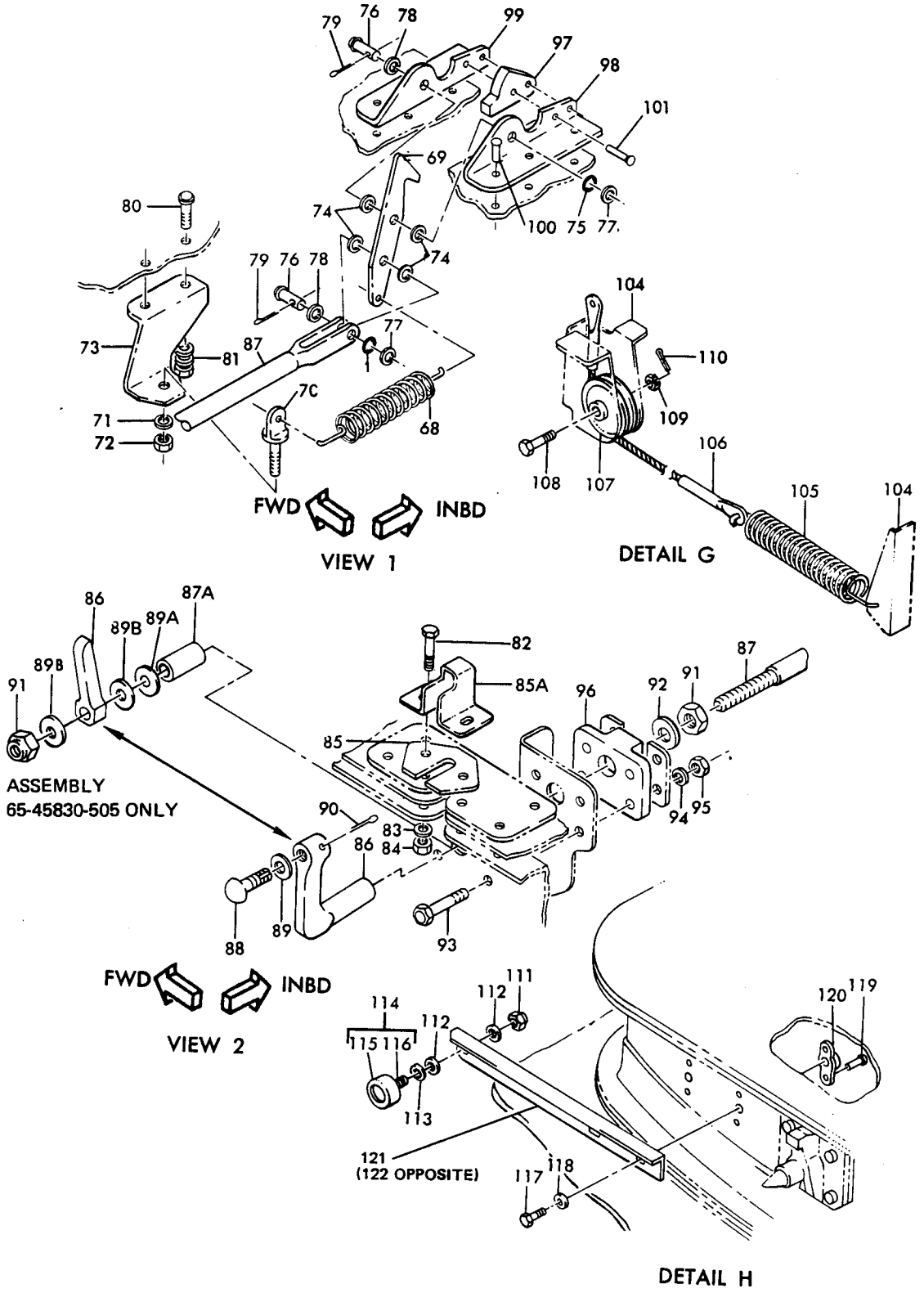


DETAIL D



DETAIL E DETAIL F

Equipment Access Door Assembly
Figure 1101 (Sheet 3)



Equipment Access Door Assembly
Figure 1101 (Sheet 4)

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
	65-45830-40		EQUIPMENT ACCESS DOOR ASSY	A	RF
	65-45830-42		EQUIPMENT ACCESS DOOR ASSY	B	RF
	65-45830-505		EQUIPMENT ACCESS DOOR ASSY	C	RF
	65-45830-53		EQUIPMENT ACCESS DOOR ASSY	D	RF
	65-45830-64		EQUIPMENT ACCESS DOOR ASSY (SB 52-1059)	E	
	65-45830-66		EQUIPMENT ACCESS DOOR ASSY (SB 52-1059)	F	
	65-45830-118		EQUIPMENT ACCESS DOOR ASSY	G	RF
	65-45830-123		EQUIPMENT ACCESS DOOR ASSY (PRE SB 52-1111)	H	RF
	65-45830-129		EQUIPMENT ACCESS DOOR ASSY (PRE SB 52-1111)	I	RF
	65-45830-131		EQUIPMENT ACCESS DOOR ASSY (POST SB 52-1111)	J	RF
	65-45830-511		EQUIPMENT ACCESS DOOR ASSY (PRE SB 52-1111)	K	RF
	65-45830-513		EQUIPMENT ACCESS DOOR ASSY (PRE SB 52-1111)	L	RF
1	65-45830-23		. RETAINER	ABCF-L	1
1	65-45830-45		. RETAINER	D	1
1	65-45830-55		. RETAINER	E	1
2	65-45830-24		. RETAINER	ABCF-L	1
2	65-45830-46		. RETAINER	D	1
2	65-45830-56		. RETAINER	E	1
3	65-45830-25		. RETAINER	ABCF-L	1
3	65-45830-47		. RETAINER	D	1
3	65-45830-57		. RETAINER	E	1
4	65-45830-26		. RETAINER	ABCF-L	1
4	65-45830-48		. RETAINER	D	1
4	65-45830-58		. RETAINER	E	1
5	65-45830-27		. RETAINER	ABCF-L	1
5	65-45830-49		. RETAINER	D	1
5	65-45830-59		. RETAINER	E	1
6	65-45830-28		. RETAINER	ABCF-L	1
6	65-45830-50		. RETAINER	D	1
6	65-45830-60		. RETAINER	E	1
7	65-45830-29		. RETAINER	ABCF-L	1
7	65-45830-51		. RETAINER	D	1
7	65-45830-61		. RETAINER	E	1
8	65-45830-30		. RETAINER	ABCF-L	1
8	65-45830-52		. RETAINER	D	1
8	65-45830-62		. RETAINER	E	1
9	5709-5		. SEAL, V14232 (BOEING 10-60821-5)	ABCF-L	1
9	65C10587-1		. SEAL	DE	1
9	65-87827-1		. SEAL (OPT TO 65C10587-1)	D	1
9	69-65395-1		. SEAL	C	1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
10	BACB30LM5DU5		. BOLT (PREF)(REPLS AN173C5)	A-DGI	4
10	BACB30NE3-6		. BOLT (OPT TO BACB30LM5DU5)(REPLS BACB30MF3-6)	A-DGI	4
10	BACB30NF3-6		. BOLT	EFHJKL	4
11	AN960PD10L		. WASHER		4
12	69-40758-6		. ANGLE	A-HKL	2
12	69-40758-10		. ANGLE	IJ	2
13	69-40758-7		. BRACKET ASSY	A-HKL	1
13	69-40758-11		. BRACKET ASSY	IJ	1
14	69-40758-8		. BRACKET ASSY	A-HKL	1
14	69-40758-12		. BRACKET ASSY	IJ	1
15	69-40758-501		. . SPRING (USED ON 69-40758-8,-12)		1
15	69-40758-5		. . SPRING (USED ON 69-40758-7,-11)		1
16	69-40758-9		. . BRACKET (USED ON 69-40758-7,-8)		1
16	69-40758-13		. . BRACKET (USED ON 69-40758-11,-12)		1
17	MS20470D6		. . RIVET (USED ON 69-40758-7,-11)		1
18	BACR15CE6D		. . RIVET (USED ON 69-40758-7,-11)		1
19	MS20470D6		. . RIVET (USED ON 69-40758-8,-12)		2
20	BACN10JN3		. NUTPLATE (REPLS NAS1068A3)		4
21	MS20426D3		. RIVET		8
22	65-2163-20		. COVER		2
23	NAS603-4P		. SCREW		12
24	BACN10JR3F		. NUTPLATE (REPLS NAS686A3)		8
25	BACN10KB3F		. NUTPLATE (REPLS NAS687A3)		4
26	MS20426D3		. RIVET		28
27	NAS623-3-2		. SCREW		16
28	BACN10JR3F		. NUTPLATE (REPLS NAS686A3)		16
29	MS20426D3		. RIVET		32
30	65-2163-37		. COVER	A-HKL	1
30	65-2163-141		. COVER	IJ	1
30	65-2163-144		. COVER *[8]	IJ	1
31	NAS623-3-16		. SCREW (PREF)(OPT TO AN3-13A)		1
31	BACB30NE3-13		. BOLT (OPT TO NAS623-3-16)(REPLS AN3-13A)		1
32	AN960D10		. WASHER		1
33	BACN10BY53W		. NUT		1
34	H759-99		. LATCH ASSY, V83014 (REPLS H759-5) *[2]	A-G	1
34	H759-5		. LATCH ASSY, V83014 (REPLD BY H759-99)	AC	1
34	H759-127		. LATCH ASSY, V83014 (REPLS H759-99) *[2] *[7]	G-L	1
34	H759-135		. LATCH ASSY, V83014 *[7]	J	1
35	H759-31		. . HANDLE ASSY, V83014		1
35	H759-131		. . HANDLE ASSY, V83014 (REPLS H759-31)		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
36	H759-33		. . HOUSING ASSY, V83014		1
37	H759-35		. . RING, RETAINER, V83014		1
38	H759-37		. . PIN ASSY, RACK, V83014		1
38A	H759-107		. . . PIN ASSY, V83014 (USED ON H759-99)		1
38A	H759-29		. . . PIN ASSY, V83014 (USED ON H759-5)		1
38B	H759-105		. . . PIN ASSY, V83014 (USED ON H759-99)		1
38B	H759-27		. . . PIN ASSY, V83014 (USED ON H759-5)		1
38C	H759-103		. . . PIN ASSY, V83014 (USED ON H759-99)		2
38C	H759-25		. . . PIN ASSY, V83014 (USED ON H759-5)		2
39	BACB30LU4-25		. BOLT (REPLS NAS334CPA20)	A-D	4
39	BACB30LU4-26		. BOLT	E-L	4
40	AN960D416		. WASHER *[7]	A-L	4
40	NAS1195DD4XH		. WASHER *[7]	J	4
41	BACN10BY54W		. NUT	A-D	4
41	BACN10JC4		. NUT *[7]	E-L	4
41	BACN10JN4CD		. NUT *[7]	J	4
42	65-2163-52		. SUPPORT, PLATE	A-HKL	1
42	65-2163-140		. SUPPORT, PLATE	IJ	1
43	NAS43DD4-9		. SPACER		1
44	63-9328		. SPACER	A-HKL	1
44	63-9328-2		. SPACER	IJ	1
45	NAS43DD4-33		. SPACER	A	2
45	NAS43DD4-36		. SPACER	B-L	2
46	NAS43DD4-12		. SPACER		1
47	NAS43DD4-21		. SPACER	A	1
47	NAS43DD4-24		. SPACER	B-L	1
48	BACB10A127		. BEARING	A-D	4
48	BACB10CG4		. BEARING	E-L	4
49	63-1658-501		. WASHER		2
50	63-1658		. WASHER		1
51	63-1658-1		. WASHER		1
52	BACN10JC3		. NUT (REPLS NAS679A3W) *[1]	BCD	16
52A	BACN10KE3D		. NUTPLATE *[1]	B	8
52B	BACN10KE3D		. NUTPLATE	E-L	16
52C	MS20426D3		. RIVET	B	16
52C	BACR15BA3D		. RIVET	E-L	32
53	AN960D10		. WASHER		8
54	AN960D10L		. WASHER		8
55	BACB30NE3-5		. BOLT (REPLS NAS1103-5)	A-D	16
55	BACB30NE3-7		. BOLT	E-L	16

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
56	69-2158-5		. STOP *[1]	A	1
56	69-2158-501		. STOP	BD-HKL	1
56	69-2158-9		. STOP	IJ	1
56	65-62192-1		. FITTING ASSY, STOP *[3]	AC	1
57	65-62192-5		. . FITTING		1
58	69-51410-1		. . BUSHING		1
58A	BACS40B36-39		. SHIM, LAMINATED		1
58B	BACS40R23C24F		. SHIM, LAMINATED		1
59	69-2158-6		. STOP *[1]	A	1
59	69-2158-502		. STOP	BD-HKL	1
59	69-2158-10		. STOP	IJ	1
59	65-62192-2		. FITTING ASSY, STOP *[3]	AC	1
60	65-62192-6		. . FITTING		1
61	65-51410-2		. . BUSHING		1
61A	BACS40A36-39		. SHIM, LAMINATED		1
61B	BACS40R23C24F		. SHIM, LAMINATED		1
61C	AN960C716L		. WASHER	BD-L	AR
62	69-2158-7		. STOP *[1]	A	1
62	69-2158-503		. STOP	BD-HKL	1
62	69-2158-11		. STOP	IJ	1
62	65-62192-3		. FITTING ASSY, STOP *[3]	AC	1
63	65-62192-8		. . FITTING		1
64	69-51410-3		. . BUSHING		1
64A	BACS40A33-39		. SHIM, LAMINATED		1
64B	BACS40R21C24F		. SHIM, LAMINATED		1
65	69-2158-8		. STOP *[1]	A	1
65	69-2158-504		. STOP	BD-HKL	1
65	69-2158-12		. STOP	IJ	1
65	65-62192-4		. FITTING ASSY, STOP *[3]	AC	1
66	65-62192-7		. . FITTING		1
67	69-51410-3		. . BUSHING		1
67A	BACS40A33-39		. SHIM, LAMINATED		1
67B	BACS40R21C24F		. SHIM, LAMINATED		1
68	MS24586C166		. SPRING	A-G	1
69	69-52243-1		. UPLATCH	A-G	1
70	AN42BC3A		. BOLT	A-G	1
71	AN960PD10L		. WASHER	A-G	1
72	BACN10JC3		. NUT (REPLS NAS679A3W)	A-G	1
73	69-52244-1		. BRACKET	A-G	1
74	BACW10P262G		. WASHER	A-G	4
75	MS29513-008		. PACKING	A-G	2
76	MS20392-2C13		. PIN	A-G	2
77	AN960PD10L		. WASHER	A-G	2
78	AN960C10L		. WASHER	A-G	2
79	MS24665-227		. PIN, COTTER	A-G	2

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
80	BACB30FM5-3		. BOLT	A-DG	2
80	NAS1103-3		. BOLT	EF	1
80	NAS1103-4		. BOLT	EF	1
81	BACC30M		. COLLAR	A-D	2
82	BACB30NE3-5		. BOLT (REPLS NAS1103-5)	A	2
82	BACB30NE3-6		. BOLT	B-G	2
83	AN960C10L		. WASHER	A-G	2
84	BACN10JC3		. NUT (REPLS NAS679A3W)	A-G	2
85	69-52237-1		. GUIDE	A-G	1
85A	69-59205-501		. BRACKET *[4]	B-G	1
86	69-52240-1		. LEVER	A	1
86	69-59206-1		. LEVER *[1]	C	1
86	69-59221-1		. LEVER *[4]	B-G	1
87	69-59222-1		. ROD ASSY *[4]	B-G	1
87	BACT32G64-1850		. ROD ASSY (REPLS NAS356-64-1850)*[4]	AC	1
87A	NAS43DD4-62		. SPACER *[4]	B-G	1
88	69-52239-1		. STRIKER *[4]	AC	1
89	BACW10P225AX		. WASHER *[4]	AC	1
89A	AN960PD416		. WASHER	B-G	1
89B	AN960PD416L		. WASHER	B-G	2
90	MS24665-153		. PIN, COTTER	A	1
91	BACN10JC4		. NUT (REPLS NAS679A4W)	A	1
91	BACN10JC4		. NUT	B-G	2
92	BACW10P250S		. WASHER	A-G	1
93	BACB30NE3-6		. BOLT (REPLS NAS1103-6)	A-H	4
94	AN960PD10		. WASHER	A-H	4
95	BACN10JC3		. NUT (REPLS NAS679A3W)	A-H	4
96	69-52238-1		. BEARING	A-G	1
97	69-52242-1		. STOP	A-G	1
98	65-56653-17		. ANGLE	A-G	1
99	65-56653-18		. ANGLE	A-G	1
100	BACR15BB5D		. RIVET (REPLS MS20470D5)	A-G	6
101	BACR15BB4D		. RIVET (REPLS MS20470D4)	A-G	2
102	MS27253-1		. PLATE, IDENTIFICATION	E-L	1
102	AN7510-1		. PLATE, IDENTIFICATION	A-D	1
103	MS20470D3		. RIVET		4
104	NONE		. STRUCTURE, DOOR		1
105	MS24586C334		. SPRING	B-G	1
106	69-59204-1		. CABLE ASSY	B-G	1
107	MS20219A2		. PULLEY	B-G	1
108	NAS1104-9D		. BOLT	B-G	1
109	MS17825-4		. NUT	B-G	1
110	MS24665-132		. PIN, COTTER	B-G	1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
111	BACN10JC3		. NUT (REPLS NAS679A3W)(SB 52-106)	B-G	2
111	BACN10JC3		. NUT	I-L	2
112	AN960PD10L		. WASHER (SB 52-1016)	B-G	4
112	AN960PD10L		. WASHER	I-L	4
113	AN960PD10		. WASHER (SB 52-1016)	B-G	2
113	AN960PD10		. WASHER	I-L	2
114	69-38548-3		. ROLLER ASSY (SB 52-1016) *[2]*[5]	B-H	2
114	69-38548-3		. ROLLER ASSY *[6]	KL	2
114	69-38548-6		. ROLLER ASSY *[2]*[5]*[6]	G-L	2
115	69-38548-2		. . SLEEVE (SB 52-1016)	B-H	1
115	69-38548-2		. . SLEEVE	G-L	1
116	BACB10B72-3		. . BEARING UNIT, NEEDLE (OPT TO HRS1C1)(SB 52-1016)	B-H	1
116	HRS1C1		. . BEARING UNIT, NEEDLE, V60380 (OPT TO BACB10B72-3)(SB 52-1016)	B-H	1
116	69-38548-501		. . BEARING UNIT, NEEDLE (OPT TO CC61958)	G-L	1
116	CC61958		. . BEARING UNIT, NEEDLE (OPT TO 69-38548-501)	G-L	1
117	BACB30NF4-2		. BOLT (SB 52-1016)	B-G	4
117	BACB30NF4-2		. BOLT	I-L	4
118	AN960PD416		. WASHER (SB 52-1016)	B-G	4
118	AN960PD416		. WASHER	I-L	4
119	MS20426D3-4		. RIVET (SB 52-1016)	B-G	8
119	MS20426D3-4		. RIVET	I-L	8
120	NAS680A4		. NUTPLATE (SB 52-1016)	B-G	4
120	NAS680A4		. NUTPLATE	I-L	4
121	65-45830-507		. GUIDE ANGLE (FWD)(SB 52-1016)	B-H	1
121	65-45830-507		. GUIDE ANGLE (FWD)	I-L	1
122	65-45830-508		. GUIDE ANGLE (AFT)(SB 52-1016)	B-H	1
122	65-45830-508		. GUIDE ANGLE (AFT)	I-L	1
123	140N2022-1		. VALVE ASSY, DRAIN *[2]	G-L	1
			ATTACHING PARTS		
124	BACR15CE4D		. RIVET		2
125	AN960D4		. WASHER		2
			-------*-------		
126	140N2022-2		. . HOUSING		1
127	140N2022-3		. . PLUNGER		1
128	140N2022-4		. . CAP		1
129	140N2020-1		. . SPRING		1
130	140N2021-1		. RETAINER, VALVE *[2]	G-L	1
131	69-77568-1		. TEE ASSEMBLY	HKL	1
131	69-77568-3		. TEE ASSEMBLY	I	1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
			ATTACHING PARTS		
132	BACB30FM6		. RIVET		4
			-------*-------		
133	69-77568-2		. . TEE	HKL	1
133	69-77568-4		. . TEE	I	1
134	BACB10ES04GC		. . BEARING		1
135	65C35254-1		. CHANNEL ASSY	J	1
136	65C35254-2		. . CHANNEL	J	1
137	BACB28AT0 6B010C		. . BUSHING	J	4
138	BACB30LH3-6		. BOLT	J	3
139	BACN10KE3B3CD		. NUTPLATE	J	2
140	BACN10JR3CD		. NUTPLATE	J	1
141	BACR15BA3D		. RIVET	J	6

*[1] LIMITED USAGE
*[2] LIMITED USAGE ON 65-45830-118
*[3] LIMITED USAGE ON 65-45830-40
*[4] LIMITED USAGE ON 65-45830-505
*[5] LIMITED USAGE ON 65-45830-123
*[6] LIMITED USAGE ON 65-45830-511
*[7] LIMITED USAGE ON 65-45830-131
*[8] LIMITED USAGE ON 65-45830-129

VENDORS

V14232 HAVEG INDUSTRIES INC., P.O. BOX 5225, WILMINGTON, DELAWARE 19808

V21335 FAFNIR BEARING COMPANY, DIVISION OF TEXTRON, INC., 37 BOOTH STREET, NEW BRITAIN, CONNECTICUT 06050

V60380 TORRINGTON CO., BEARINGS DIVISION, SUBSIDIARY OF INGERSOLL-RAND CORP., 59 FIELD STREET, TORRINGTON, CONNECTICUT 06790

V83014 HARTWELL CORP., 900 S. RICHFIELD ROAD, PLACENTIA, CALIFORNIA 92670