TO: ALL HOLDERS OF AFT GALLEY DOOR ASSEMBLY OVERHAUL MANUAL, 52-46-05

REVISION NO. 37, DATED JUL 1/05

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
Clarified that the chamfer for the repair sleeve should be the same as the chamfer for the housing bore					X								

AFT GALLEY DOOR ASSEMBLY

52-46-05

BOEING P/N 65-45849-2, -159, -166, -169, -170, -536

AIRLINE P/N

THE FOLLOWING DIRECTIVES APPLY TO THIS SUBJECT:

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVES	DATE DIRECTIVE INCORPORATED INTO TEXT
		PRR 31564	Mar 10/70
		PRR 31567	Mar 10/70
		PRR 31665	Mar 10/70
		PRR 30458	Jun 10/72
		PRR 31996	Jun 10/72
		PRR 32121-1	Jun 10/72
		PRR 32121-7	Dec 25/72
53-1017			Dec 25/72
53-1017 R1			Dec 25/72
		PRR 32070-13	Sep 25/73
		PRR 32121-8	Sep 25/73
		PRR 32403	Mar 25/75
		PRR 32533	Jul 5/76
		PRR 32575-1	Jan 5/77
		PRR 32792	Jan 5/79

THE FOLLOWING DIRECTIVES APPLY TO THIS SUBJECT:

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVES	DATE DIRECTIVE INCORPORATED INTO TEXT
		PRR 32836	Jan 5/79
		PRR 32950-4	Jan 5/80
		PRR 32989	Jul 5/81
		PRR 33268	Dec 5/83
		PRR 33410-6	Dec 5/85
		PRR 33180-17	Dec 5/85
		PRR 33180-66	Dec 5/85
		PRR 34270	Mar 5/88
52-1094		PRR 34272	Jun 5/88
		PRR 34473	Sep 5/88
52-1094R1			Dec 5/88
52-1094R2			Mar 5/89
52-1097R1			Sep 5/89
52-1094R3			Nov 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
	52-46-05			503	Mar 1/05		1118B	BLANK
	T-1	Nov 1/99		504	Mar 1/05		1119	Nov 1/99
	T-2	Nov 1/99		505	Mar 1/05		1120	Nov 1/99
*	LEP-1	Jul 1/05		506	Mar 1/05		1121	Mar 1/00
	LEP-2	BLANK		507	Nov 1/99		1122	Mar 1/00
	T/C-1	Jun 5/88		508	Mar 1/05		1123	Nov 1/99
	T/C-2	BLANK		509	Mar 1/05		1124	Nov 1/99
	1	Jan 5/80		510	BLANK		1125	Nov 1/99
	2	Mar 10/70		601	Mar 1/00		1126	Nov 1/99
	101	Mar 1/05		602	BLANK		1127	Mar 1/00
	102	Mar 1/05		701	Mar 10/70		1128	Mar 1/00
	103	Mar 1/05		702	BLANK		1129	Nov 1/99
	104	Mar 1/05		801	Mar 10/70		1130	Nov 1/99
	201	Mar 10/70		802	BLANK		1131	Nov 1/99
	202	BLANK		901	Mar 10/70		1132	Nov 1/99
	301	Mar 10/70		902	BLANK		1133	Nov 1/99
	302	Mar 10/70		1001	Nov 1/01		1134	Nov 1/99
*	401	Jul 1/05		1002	BLANK		1135	Nov 1/99
	402	Nov 1/03		1101	Mar 10/70		1136	Nov 1/99
	402A	Nov 1/99		1102	Nov 1/99			
	402B	Nov 1/99		1103	Mar 10/70			
	402C	Nov 1/99		1104	Jul 5/81			
	402D	Mar 1/03		1105	Mar 10/70			
	402E	Nov 1/01		1106	Nov 1/99			
	402F	Mar 1/00		1107	Nov 1/99			
	402G	Nov 1/99		1108	Nov 1/99			
	402H	Nov 1/99		1109	Nov 1/99			
	402I	Nov 1/99		1110	Jul 1/01			
	402J	Jul 1/01		1111	Mar 1/00			
	402K	Jul 1/01		1112	Nov 1/99			
	402L	Jul 1/02		1112A	Nov 1/99			
	402M	Jul 1/01		1112B	Nov 1/99			
	402N	BLANK		1113	Mar 1/03			
	403	Nov 1/99		1114	Nov 1/99			
	404	Nov 1/99		1114A	Nov 1/99			
	405	Nov 1/99		1114B	Nov 1/99			
	406	Nov 1/99		1114C	Nov 1/99			
	406A	Nov 1/99		1114D	Mar 1/00			
	406B	BLANK		1115	Nov 1/99			
	407	Nov 1/99		1116	Nov 1/99			
	408	Mar 1/00		1116A	Mar 1/00			
	409	Sep 5/88		1116B	BLANK			
	410	BLANK		1117	Nov 1/99			
	501	Mar 1/05		1118	Mar 10/70			
	502	Mar 1/05		1118A	Mar 1/00			

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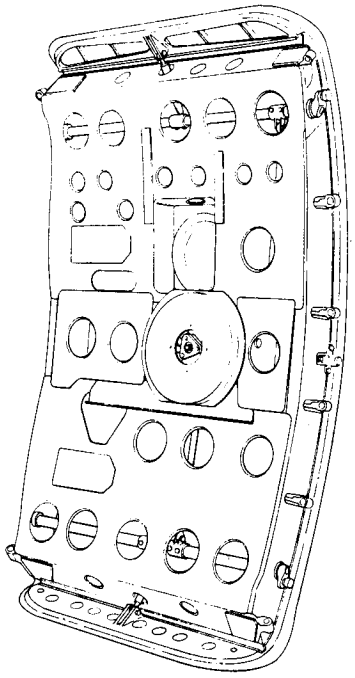
AFT GALLEY DOOR ASSEMBLY



Aft Galley Door Assembly
Figure 1

DESCRIPTION AND OPERATION

1. Description

   A. The aft galley door is an inward-outward plug type door at station 975.

   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. This housing, together with the mechanism, is installed in the door structure. Connected to the handle mechanism are the upper and the lower gates, and the roller latch assemblies through control rods, cranks, and torque tubes. Connected to the hinge torque tube are the upper and lower hinge assemblies. Fourteen adjustable door stops are installed on the sides of the door structure and in the gates. A door centering guide is assembled on the door to center the door in the door frame.

2. Operation

A. The aft galley 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, to fold the gates inward, and to 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 in a hole in the upper hinge assembly. Pressurization loads on the door are transmitted through the adjustable stop pins to the door frame.

3. Leading Particulars

Thickness	--	4.75 inches (approximately)
Width	--	35.00 inches (approximately)
Height	--	68.50 inches (approximately)
Weight	--	110.00 pounds (approximately)

DISASSEMBLY

1. Remove Installation Items (Fig. 1101)

NOTE: Items removed in this paragraph are not part of the door assembly, but could be included with the door when it comes in for overhaul.

A. Remove nut (202), washer (203), spacer (204), and centering guide (205).

NOTE: Roller fitting (201) will be removed from door structure (200) when items (39 thru 42) are removed.

B. Remove retainer springs (206) and stop pins (207) from all stop fitting assemblies.

C. Remove plugs (208).

D. Remove hinge covers (209, 214), bolts (213, 213A, 213B, 217), blocks (210), and shims (211, 212, 215, 216).

2. Disassemble lining retainer assembly (1, Fig. 1101). To do this, disengage studs (2) from split retaining rings (3) and remove retainer (4).

3. Remove bolts and washers (5, 6) and remove cover plates (7, 8) and bracket (9).

4. Remove screws/bolts (10), bolts (11) and washers (10A, 11A) and remove cover plates (12).

NOTE: Do not remove rivets (12A) and nutplates (12B, 12C) unless repair or replacement is necessary.

5. Remove parts (13 thru 18) an d remove reinforcing angles (19, 20).

6. Remove bolts (21), washers (22), and window assembly (23).

7. Dissassemble window assembly as follows:

A. Remove parts (24 thru 26), clips (27), and shims (28, 29).

B. Separate seal (30), retainer (31), inner pane (32), outer pane (33), and seal (34).

8. Remove nylon rods (35 thru 37) and pull seal (38) from seal retainer.

9. Remove bolts (39, 40), washers (41), and serrated plate (42).

NOTE: Do not remove parts (43 thru 75) unless repair or replacement is necessary.

10. Remove nuts (76), washers (77, 78), bolts (79 thru 81), and bushings (82).

11. Remove rod assemblies (83, 88) from door structure.

    NOTE: Do not disassemble rod assemblies (83, 88) unless repair or replacement is necessary.

12. Before you remove the gates (110, 113) from the door, measure and make a note of the gap between each gate and the door to help during assembly. Then remove parts (103 thru 107), fillers (108, 109), and upper and lower gate assemblies (110, 113).

    NOTE: Do not remove bushings (111, 114, 115) unless repair or replacement is necessary.

13. Remove spring pins (118, 125) from hinge pins (119, 126) and pull out the hinge pins. Remove hinge halves (121, 127).

    NOTE: Do not remove seal retainers (122, 129) from hinge halves (121, 127), or seal retainers (123, 130) from gates (112, 116) unless repair or replacement is necessary.

14. Remove nuts, washers, and bolts (131 thru 133) at each end of door latching rod and remove cranks (134) and spacers (135).

15. Remove bearing unit (139) from each crank (134) with cotter pins (136), nuts (137), and washers (138).

16. Remove nuts, washers, and bolts (140 thru 142) and cranks (143 thru 145).

17. Slide torque tubes (146, 147) out of door structure.

18. Remove rod assemblies (93, 98) and cranks (143 thru 145) from door structure.

    NOTE: Do not disassemble rod assemblies (93, 98) unless repair or replacement is necessary.

19. Remove parts (148 thru 152) and support fitting assemblies (153, 156, 159).

20. Remove lube fittings (154, 157, 160).

21. Remove nuts (162), washers (163), bolts (164), and housing assemblies (165).

22. Remove lube fittings (166) from housings (167).

23. Remove bearings (168) from support fittings (155, 158, 161) and housings (167).

24. Remove nuts, washers, and bolts (169 thru 171) and slide coupling sleeves (172, 173) together on hinge torque tube (47, Fig. 1102).

25. Remove parts (1 thru 8, Fig. 1102) and record the number and the thickness of shims (8) to make assembly easier.

26. Remove cotter pin (24A), as applicable, nut (9), washers (9A, 10), as applicable, cam assembly (25), bolts (32), washers (33), and seal washers (34), and remove outer handle (14) with attached parts from door structure. Remove handle mechanism (199, Fig. 1101), with attached parts from door structure.

27. Remove bolts and washers (182A, 182B, Fig. 1101) and pins (174), with springs (175), washers (176), and O-ring packing (177) from upper and lower hinge arm assemblies (182C, 182F).

    NOTE: Do not remove inserts (182D or 182G) unless repair or replacement is necessary.

28. Remove nuts (178, Fig. 1101), washers (179), bolts (180, 181), and seal washers (182) that attach upper and lower hinge support assemblies (183, 191) to door structure.

29. Remove and disassemble upper hinge support assembly (183) with bolts (184, 186), washers (185, 187), attach fitting (188), and bushing (189) from hinge support (190).

30. Remove and disassemble lower hinge support assembly (191) with bolts (192, 194), washers (193, 195), attach fitting (196), and bushing (197) from hinge support (198).

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

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

    NOTE: Do not disassemble guide assembly (25) or remove rivets (36) and seal plate (37) unless repair or replacement is necessary.

33. Remove O-ring packing (35, 38) and housing assembly (39). Remove lube fitting (40) from the housing.

34. Remove cotter pins (42) and use wrench, F70085, to remove nuts (43).

35. Remove nuts, washers, and bolts (44 thru 46) and remove torque tube (47).

36. Remove nut, washers, and bolts (48 thru 51) and remove rod assembly (52) and crank (57).

    NOTE: Do not disassemble rod assembly (52) unless repair or replacement is necessary.

37. Remove nuts (58), washers (59), bolts (61, 62), and washers (60). Remove crank assemblies (66, 73) from handle mechanism housing and remove crank assembly (63), spacer (64), and crank assembly (65).

38. To disassemble crank assembly (66), remove cotter pin (67), nut (68), washer (69, 69A), washers (70), and bearing unit (71) from crank arm (72).

39. To disassemble crank assembly (73), remove cotter pin (74), nut (75), washer (76, 76A), washers (77), and bearing unit (78) from crank arm (79).

40. Remove nuts (80), washers (81), and bolts (82 thru 84). Remove bearing retainers (85) and bearings (86 and 87).

41. Remove washer (88), retaining ring (89), and bearing (90).

42. Remove bearings (91).

    NOTE: Do not remove rivets (97, 100), nutplates (94, 96), bushings (101) or fillers (98, 99) from housing assembly (92) unless repair is necessary.

CLEANING

1. General

   A. Wash and rinse metal parts except bearings in solvent, Specification P-D-680 or equivalent.

   B. Clean all bores, holes, threads, passages, and chambers using a stiff bristle brush.

   C. Dry parts with a clean, lint-free cloth or moisture-free compressed air.

   D. For further information on cleaning methods and processes, refer to Subject 20-30-03.

2. Bearings

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

   CAUTION: BEARINGS (86, 87, 90, AND 91, FIGURE 1102) ARE TEFLON LINED. CLEAN ONLY BY SPECIAL METHOD GIVEN IN REFERENCED SUBJECT.

3. Door Seal -- Wash door seal (38, figure 1101) in a mild soap and water solution. Rinse with clean, abrasive-free water and dry with moisture-free air.

4. Glass -- Wipe window panes (32 and 33, figure 1101) with a lint-free cloth moistened with aliphatic naphtha, Specification TT-N-95.

5. Areas To Be Sealed

   A. Remove large particles using clean bristle brush or cloth wet with BMS 11-7 cleaner. The use of excess cleaner should be avoided.

   CAUTION: DO NOT ALLOW BMS 11-7 CLEANER TO CONTACT PANES OF WINDOW ASSEMBLY (23, FIGURE 1102).

   B. Final cleaning should be done with BMS 11-7 cleaner immediately prior to sealant application. All cleaner should be wiped off while wet with a clean dry cloth.

   C. Remove all solvent by blast of oil-free and water-free air. After blasting with air, make a final cleaning with a cloth just damp with cleaner, and wipe dry.

   D. It is acceptable if some primer is removed during cleaning. Sealant can be applied directly to exposed metal. After sealing, any metal surface exposed by removal of primer during cleaning should be touched up with primer.

INSPECTION/CHECK

1. Visual Check

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

   B. Check splined parts for nicks, gouges, or uneven wear. Wear pattern must be smooth and centered on teeth.

   C. Examine all threaded parts for cross-threading and stripping.

   D. Examine painted and plated surfaces for blisters or flaking.

   E. Examine packing grooves for dirt, burrs, and any defect that will shorten life of packings.

   F. Check bearings for corrosion, roughness, binding, excessive radial or axial play, and for freedom of rotation.

   G. Examine door seal (38, figure 1101) for damages. Any section of the seal, including all joints or splices, should be strong enough to withstand a tensile pull of 35 pounds without failure.

2. Special Check

   A. Check springs (175, figure 1101, and 22, figure 1102) for load capacity according to values in figure 301.

   B. If questionable areas are evident under visual examination, perform applicable operation as follows:

      (1) Penetrant Check -- Machined area only of items (134, figure 1101, and 72 and 79, figure 1102).

      (2) Penetrant Check -- Items (45, 48, 51, 54, 57, 60, 63, 66, 68, 71, 74, 97, 102, 112, 116, 155, 158, 161, 182E, 182H, 188, and 196, figure 1101; and 14, 17, 19, 21, 23, 27, 31, 37, 63, and 65, figure 1102).

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

(3) Magnetic Particle Check -- Items (87, 92, 143, 146, 147, and 174, figure 1101; and items 41, 47, and 57, figure 1102).

NOTE: Subject 20-20-01 contains information regarding magnetic particle check methods.

Item and Figure No.	Approximate Free Length (Inches)	Test Length (Inches)	Allowable Load Limits (Pounds)
175, figure 1101	0.88	0.25 0.20	0.10 to 0.30 0.13 to 0.33
22, figure 1102	5.01	3.34 2.05	3.0 to 3.8 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. Use standard industry practices for repair of this component and additional procedure in step B.

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

(1) Machine housing (93) as required, within repair limits shown, to remove defects. Refer to Fig. 401.

(2) Chamfer outside edge 0.06 inch x 45 degrees.

(3) Do a penetrant check of machined surfaces. Refer to SOPM 20-20-02.

(4) Dow 7 or 17 anodize housing (93, P/N 65-1642-13) bore. Dow 7 or 17 anodize housing (93, P/N 65-1642-35) bore and apply one coat of BMS 10-11 Type 1 primer per SOPM 20-41-02 (F-18.09). Refer to SOPM 20-43-02 and SOPM 20-41-02. Anodize (F-17.12) Housing (93, 65-1642-44, -47) and apply BMS 10-11, Type 1 primer (F-20.03).

(5) Manufacture applicable repair sleeve. Refer to Fig. 401.

(6) Coat repair sleeve OD and housing bore with BMS 10-11, Type 1 primer and install sleeve 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 (93) 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 (171, Fig. 1101) in the coupling sleeves (172, 173), hinge pins (174) or the hinge torque tube (47, 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.

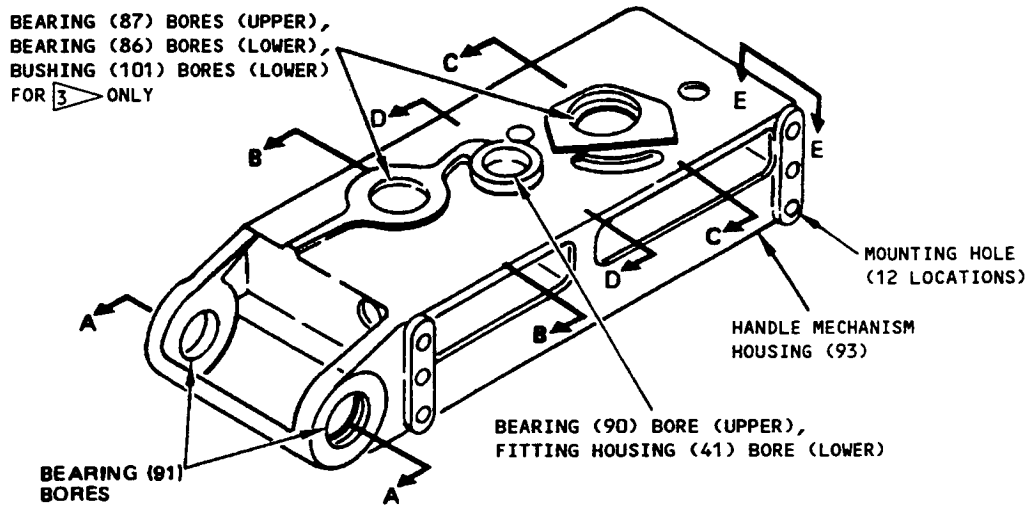
(c) For the 0.2963-0.2973 inch repair diameter - Use BACB30NE4-26Z bolts, AN960D416 washers, and BACN10JC4 nuts.

(d) For the 0.3120-0.3130 inch repair diameter - Use BACB30NE5-26 bolts, AN960D516 washers, and BACN10JC5 nuts.

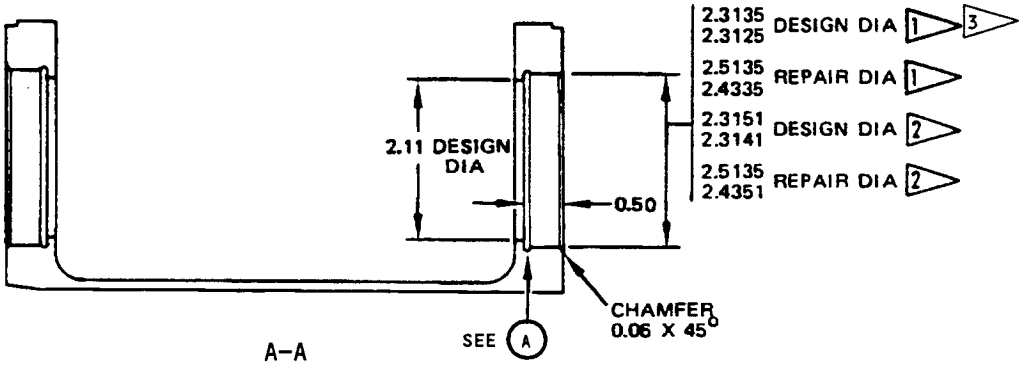
CAUTION: THE REPAIR SPECIFIED BELOW IS FOR 65-73978-( ) HINGE ARMS ONLY.

E. Repair the 0.250 inch diameter holes on the hinge arm (65-73978-3,-9,-11,-13, 182E; 65-73978-4,-10,-12,-14, 182H; Fig. 1101) as follows:

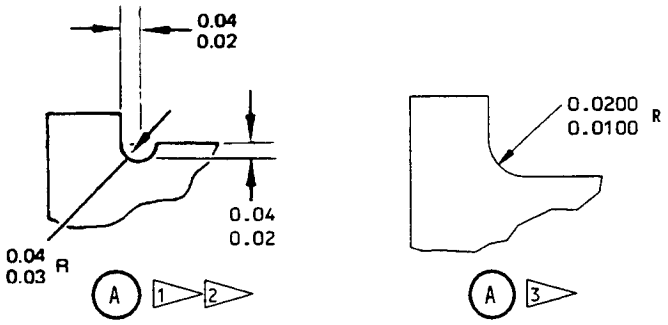
(1) Machine the holes as necessary to a diameter of 0.3115-0.3755 inch to remove defects. The surface roughness of the hole must be 125 microinch or better.



ALL ITEM NUMBERS REFER TO FIGURE 1102



A-A

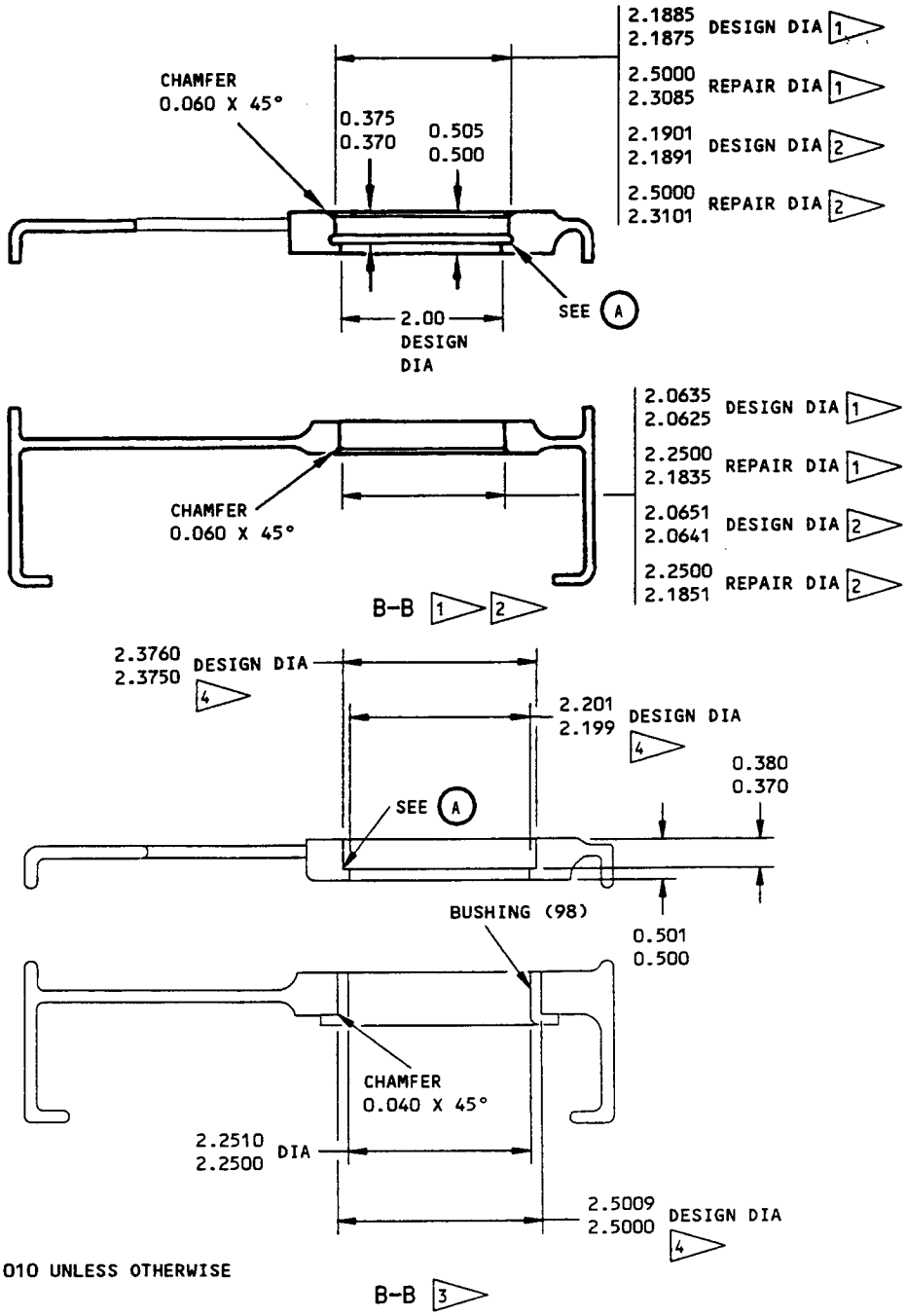


ALL DIMENSIONS APPLY FOR BOTH HOLES
ALL TOLERANCES ± 0.010 UNLESS OTHERWISE SPECIFIED

1 HOUSING (93), 65-1642-13
2 HOUSING (93), 65-1642-35
3 HOUSING (93), 65-1642-44,-47

HOUSING (93, FIG. 1102)

Handle Mechanism Housing Repair
Figure 401 (Sheet 1)



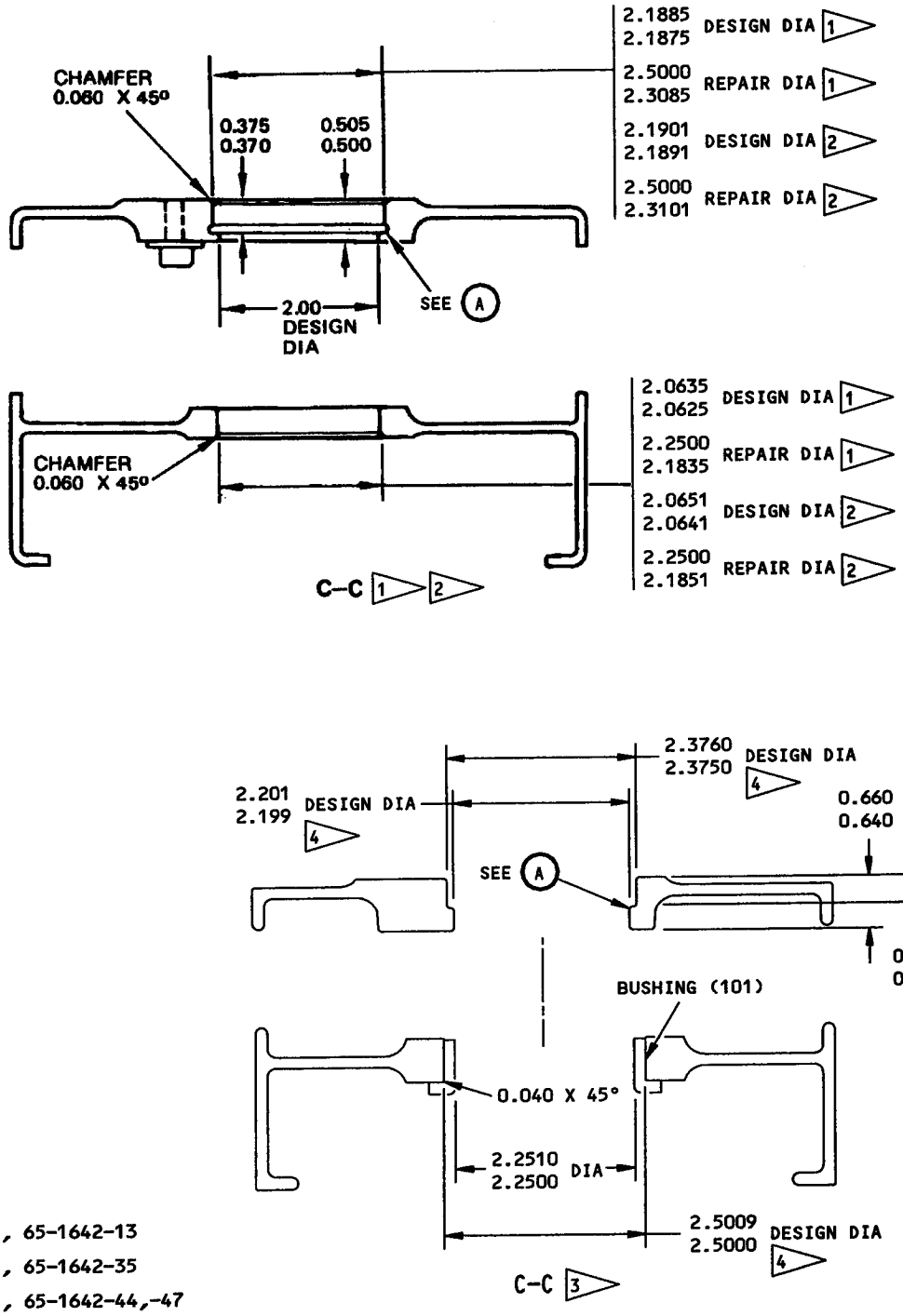
ALL TOLERANCES ±0.010 UNLESS OTHERWISE SPECIFIED

1. HOUSING (93), 65-1642-13.
2. HOUSING (93), 65-1642-35.
3. HOUSING (93), 65-1642-44,-47.
4. CONTACT BOEING TO COORDINATE REPAIRS FOR BORES INDICATED.

HOUSING (93, FIG. 1102)

Handle Mechanism Housing Repair
Figure 401 (Sheet 2)

K54728



1 HOUSING (93), 65-1642-13

2 HOUSING (93), 65-1642-35

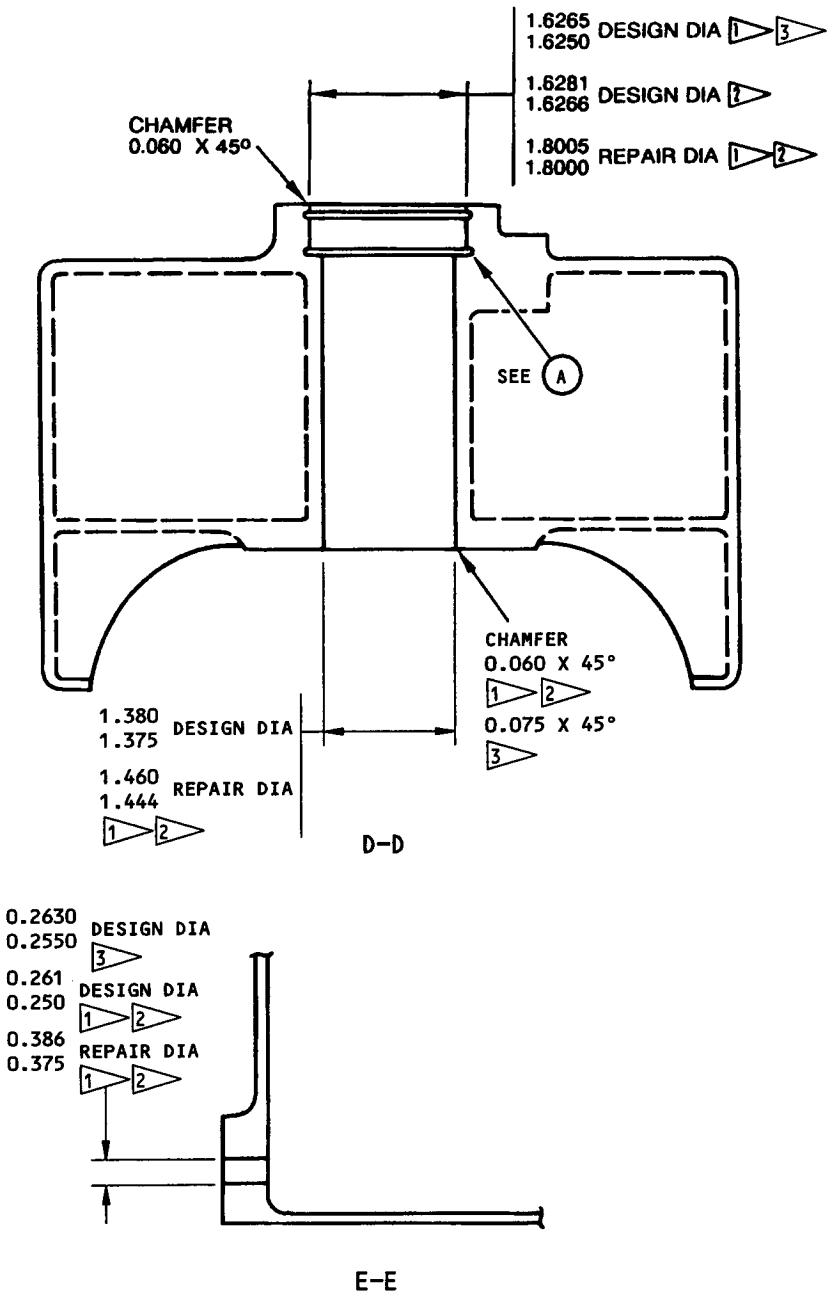
3 HOUSING (93), 65-1642-44,-47

4 CONTACT BOEING TO COORDINATE REPAIRS FOR BORES INDICATED.

HOUSING (93, FIG. 1102)

Handle Mechanism Housing Repair
Figure 401 (Sheet 3)

K54752

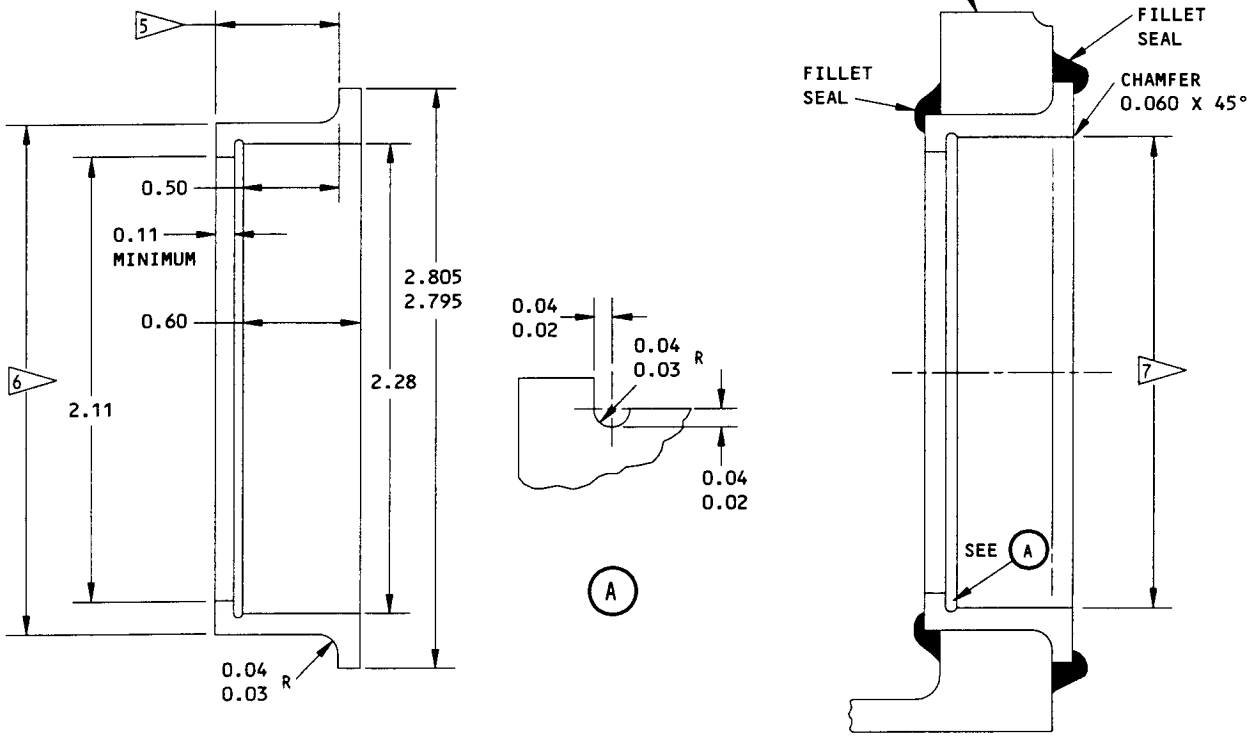


HOUSING (93, FIG. 1102)

1 HOUSING (93), 65-1642-13.
2 HOUSING (93), 65-1642-35.
3 HOUSING (93), 65-1642-44,47.

Handle Mechanism Housing Repair
Figure 401 (Sheet 4)

K54767



SLEEVE FABRICATION

SLEEVE INSTALLATION

REPAIR

5 0.06–0.10 GREATER THAN THICKNESS OF HOUSING TO PERMIT APPLICATION OF SEALANT AFTER SLEEVE INSTALLATION.

6 FINAL SLEEVE OUTSIDE DIA EQUALS REPAIR DIA OF HOUSING PLUS 0.0005–0.0010 INTERFERENCE.

7 DESIGN DIA OF HOUSING (93, FIG. 1102) BORE FOR BEARING (91, FIG. 1102). MACHINE AFTER INSTALLATION

REFINISH

MATERIAL: AL ALLOY 7075-T6

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

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

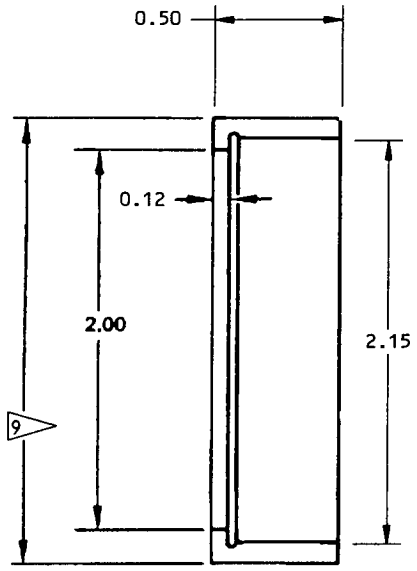
ALL TOLERANCES ARE ± 0.010 UNLESS OTHERWISE SPECIFIED

ALL DIMENSIONS ARE IN INCHES

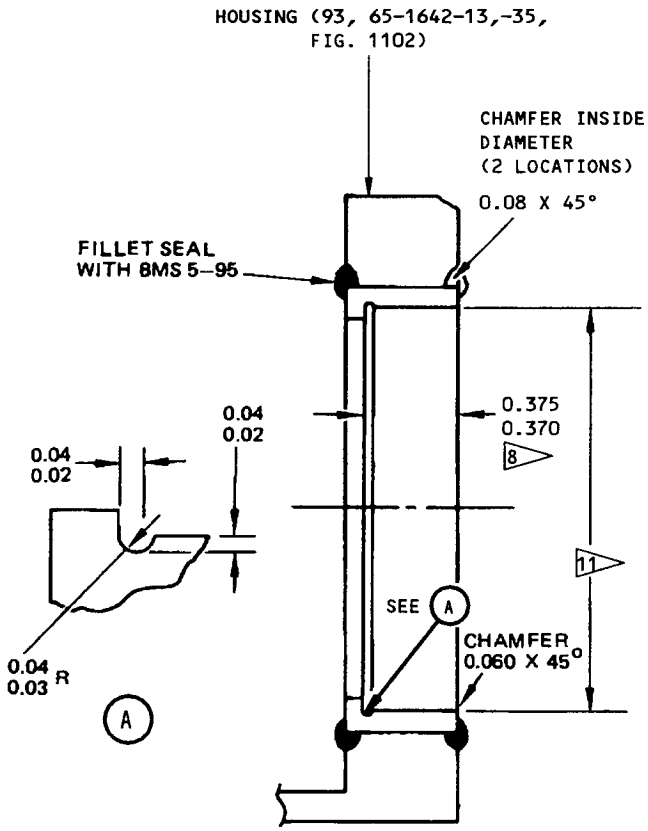
REPAIR SLEEVE FOR BEARING (91) BORES

Handle Mechanism Housing Repair
Figure 401 (Sheet 5)

K54813



SLEEVE FABRICATION



SLEEVE INSTALLATION

8 CONTROLLING DIMENSION FOR BEARING DEPTH.

9 FINAL SLEEVE OUTSIDE DIA. EQUALS REPAIR DIA OF HOUSING PLUS 0.002-0.003 INTERFERENCE.

11 DESIGN DIA. OF HOUSING (93, 65-1642-13,-35, 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

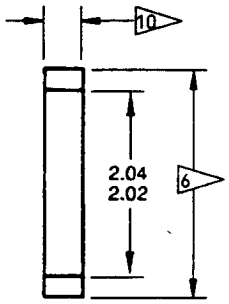
FINISH: CHROMIC ACID ANODIZE PER 20-43-01 AND APPLY ONE COAT BMS 10-11, TYPE 1 PRIMER

ALL DIMENSIONS ARE IN INCHES

REPAIR SLEEVE FOR BEARING (87, BACB10BW23) BORES

Handle Mechanism Housing Repair
Figure 401 (Sheet 6)

K54840



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

10 SLEEVE LENGTH TO BE FLUSH MINUS 0.00-0.03 WITH HOUSING.

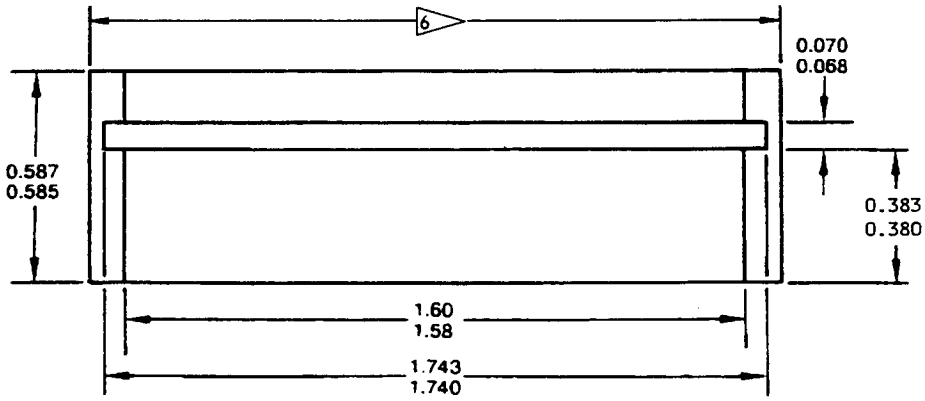
125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

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 (93, 65-1642-13,-35) ONLY



6 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

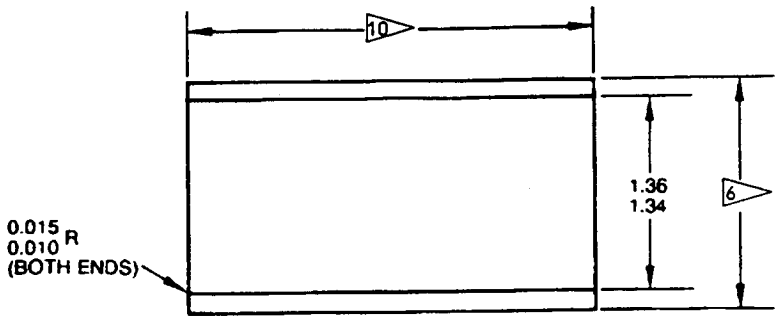
FINISH: CADMIUM PLATE PER 20-42-05 AND APPLY ONE COAT OF BMS 10-11, TYPE 1, PRIMER

ALL DIMENSIONS ARE IN INCHES

REPAIR SLEEVE FOR BEARING (90) BORE

Handle Mechanism Housing Repair
Figure 401 (Sheet 7)

K54884



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

10 SLEEVE LENGTH TO BE FLUSH MINUS 0.00-0.03 WITH HOUSING

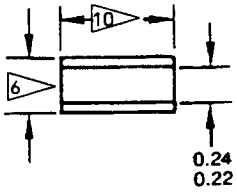
ALL DIMENSIONS ARE IN INCHES

125 ALL MACHINED SURFACES

MATERIAL: AL ALLOY, 7075-T6

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

REPAIR SLEEVE FOR FITTING HOUSING (41) BORE



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

10 SLEEVE LENGTH TO BE FLUSH MINUS 0.00-0.03 WITH HOUSING

ALL DIMENSIONS ARE IN INCHES

125 ALL MACHINED SURFACES

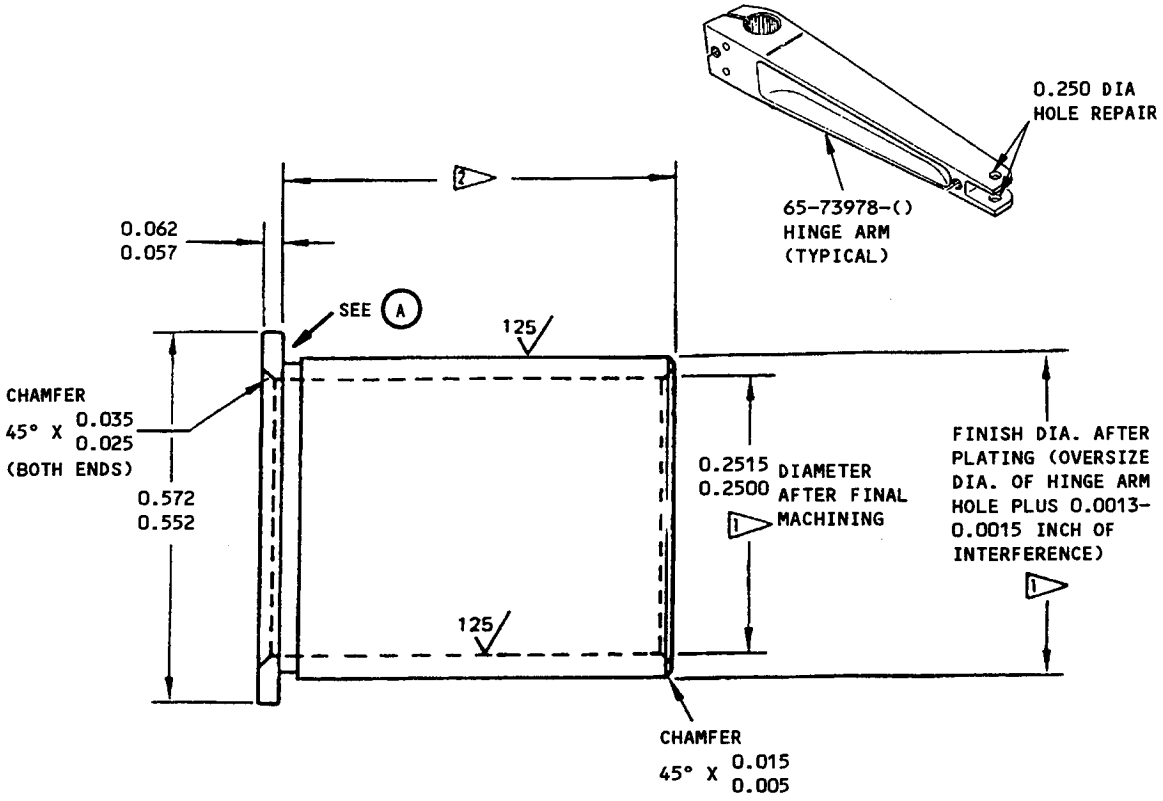
MATERIAL: AL ALLOY, 7075-T6

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

REPAIR SLEEVE FOR MOUNTING HOLES

Handle Mechanism Housing Repair
Figure 401 (Sheet 8)

K54890



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) 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.

(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.

2. Refinish

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. Fig. 1101

(1) Retainer (4), cover plates (7, 8, 12), bracket (9) and reinforcing angles (19, 20) -- Alodize or chromic acid anodize and apply one coat of BMS 10-11, Type 1 primer (SRF-2.30) all over.

(2) Clip (27) -- Zinc plate (SRF-1.305) all over. Material: AISI 301 steel.

(3) Serrated plate (42) -- Chromic acid anodize (F-2.20) and apply one coat of BMS 10-11, Type 1 primer (SRF-12.205) all over except no primer on serrations. Material: Al alloy.

(4) Stop fittings (45, 65-45852-3, 65-45852-503; 48, 51, 54, 65-45851-18, 57, 60, 63, 65-52981-3, -7; 66) -- Alodize or chromic acid anodize and apply one coat of BMS 10-11, Type 1 primer (SRF- 2.30) all over. Material: Al alloy.

(4A) Stop fitting (45; 65-45852-9) -- Boric acid - sulfuric acid anodize (F-17.35) and apply (BMS 10-11, Type 1 primer (F-20.03) but do not put primer in the bushing hole. Material: Al alloy.

(4B) Stop fitting (63; 65-52981-11) -- Chromic acid anodize and apply primer BMS 10-11, Type 1 and enamel BMS 10-11, Type 2 (F-21.18) but do not put enamel in the bushing hole. Material: Al alloy.

(5) Stop fittings (54, 65-45851-15; 68, 71, 74) -- Chromic acid anodize (SRF- 2.19) all over. Material: Al alloy.

(6) Control rods (87, 92) -- Cadmium plate exterior surfaces and apply two coats of BMS 10-11, Type 1 primer on interior surfaces on threads. Material: 4130 steel, 150-170 ksi.

(7) Door mechanism rods (97, 102) -- Alodize (F-2.742) all over and add apply one coat of BMS 10-11, Type 1 primer (SRF-12.205) on exterior surface only.

(8) Gates (112, 116)

(a) Gates (112, 65-55479-4, and 116, 65-55478-3) -- Apply Dow 7 treatment and two coats of BMS 10-11, Type 1 primer (SRF-3.17) plus (SRF-12.205) all over except omit primer in 0.4353- and 0.25-inch diameter holes. Apply abrasion resistant finish (SRF-14.9624) full length of mill cut on gate (112) only. Material: Magnesium alloy.

NOTE: Use "no dimensional loss" procedure for Dow finish. Primer on inside may be applied by filling and draining.

(b) Gates (112, 65-55479-504, and 116, 65-55478-503) -- Dow 17 anodize of Dow 7 treat and apply two coats of BMS 10-11, Type 1 primer (SRF-3.30) plus two coats of enamel (SRF-14.9815-702), except no primer or enamel in bushing holes, to obtain complete coating system thickness of 0.004 inch minimum. Apply abrasion resistant finish (SRF-14.9624) full length of mill cut on gate (112) only. Material: Magnesium alloy.

NOTE: Use "no dimensional loss" procedure for Dow finish. Primer and enamel on inside may be applied by filling and draining.

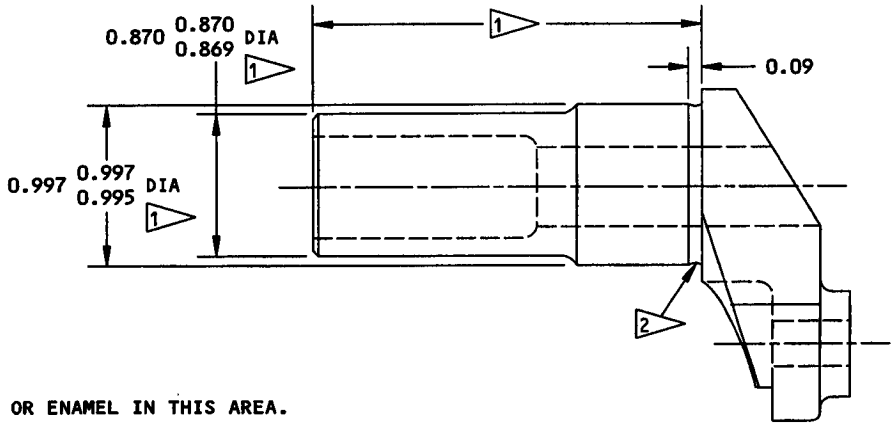
(c) Gates (112, 65-55479-10, and 116, 65-55478-9) -- Apply Dow 17 (F-17.12) or Dow 7 per MIL-M-3171, Type 3. Apply (2) coats of BMS 10-79, Type 3 primer (F-19.66). Apply (2) coats of enamel (SRF-14.9815-702) to obtain a complete coating system thickness of 0.004 inch minimum. Material: Magnesium alloy.

NOTE: Use "no dimensional loss" procedure for Dow finish. Primer and enamel on inside may be applied by filling and draining.

(9) Hinge halves (120, 121, 127, 128; 65-45849-( ) and 65-52855-( )) -- Alodize or chromic acid anodize and apply one coat of BMS 10-11, Type 1 primer (SRF-2.30) all over except no primer in hinge pin holes. Material: Al alloy.

Hinge halves (120, 121, 127, 128; 65C34053-( )) -- Chromic acid anodize and apply one coat of BMS 10-11, Type 1 primer (F-18.13) all over except no primer in hinge pin holes. Material: Al alloy.

(10) Seal retainers (122, 123, 129, 130) and crank (134, 69-37418-2) -- Alodize or chromic acid anodize and apply one coat of BMS 10-11, Type 1 primer (SRF-2.30) all over. For crank (134), apply primer as shown in Fig. 402. Material: Al alloy.



1 NO PRIMER OR ENAMEL IN THIS AREA.
2 OVERSPRAY ALLOWED IN THIS AREA.

CRANK (134)

Refinish Detail
Figure 402

(10A) Crank (134, 69-37418-8) -- Chemical treat or chromic acid anodize and apply BMS 10-11, Type 1 primer as shown in Fig. 402 (F-18.05). Material: Al Alloy

(10B) Crank (134, 69-37418-501) -- Chemical treat or chromic anodize and apply BMS 10-11, Type 1 primer (SRF-2.30), as shown in Fig. 402.

(10C) Crank (134, 69-37418-11) -- Boric acid - sulfuric acid anodize (F-17.35). Apply BMS 10-11, Type 1 primer (F-20.02) and BMS 10-11, Type 2 enamel (F-21.03) as shown in Fig. 402.

(11) Spacer (135, 66-15332-1) -- Passivate (F-17.25) all over. Material: 301 CRES.

(12) Cranks (143, 66-14530-1; 144, 66-14531-1; 145, 66-14531-3) -- Cadmium plate and apply one coat of BMS 10-11, Type 1 primer (SRF-1.285) all over. Material: 4130 steel, 125-145 ksi.

(13) Crank (143, 66-14530-3) -- Passivate (F-17.09). Material: 15-5PH CRES, 150-170 ksi.

(14) Crank (143, 66-14530-4) -- Cadmium plate and apply (1) coat of BMS 10-11, Type 1 primer (F-16.01). Material: 4130 steel, 125-145 ksi.

(15) Crank (144, 66-14531-9; 145, 66-14531-10) -- Passivate (F-17.09). Material: 15-5PH CRES, 150-170 ksi.

(16) Torque tubes (146, 60-4406-8; 147, 60-4406-7) -- Cadmium plate exterior surfaces and apply two coats of BMS 10-11, Type 1 primer on interior surfaces (F-1.611). Material: 4130 or 4340 steel, 150-170 ksi.

(17) Torque Tube (146, 60-4406-14; 147, 60-4406-13) -- Cadmium plate (F-15.06) per SOPM 20-42-05. Apply (1) coat of BMS 10-11, Type 1 primer (F-20.02) to internal diameter. Material: 17-7PH CRES, 150-170 ksi.

(18) Support fittings (155, 65-49560-2; 158, 65-49560-6; 161, 65-49560-7) -- Alodize or chromic acid anodize and apply one coat of BMS 10-11, Type 1 primer (SRF-2.30) all over except 1.375-inch diameter hole. Material: Al alloy.

(18A) Support fittings (155, 65-49560-10, -16; 158, 65-49560-12, -18; 161, 65-49560-14, -20) -- Anodize (F-17.05) and apply BMS 10-11, Type I primer (F-20.02). Material: Al alloy.

(19) Housing (167) -- Alodize or chromic acid anodize and apply one coat of BMS 10-11, Type 1 primer (SRF-2.30) all over except on bearing bore and in lube fitting hole. Material: Al alloy.

(20) Sleeves (172, 60-4365, 60-4365-1; 173, 66-24987-1, -2)

(a) Exterior surfaces -- Cadmium plate (F-16.04), except plating thickness in area of splines to be 0.0002-0.0004 inch. Material: 4130 steel, 125-145 ksi.

(b) Interior surfaces

1) 60-4365 and 66-24987-1 -- Apply one coat of BMS 10-11, Type 1 primer, maximum thickness 0.0008 inch.

2) 60-4365-1 and 66-2497-2 -- Apply phosphate coating (F-14.14) followed by two coats of BMS 10-11, Type 1 primer (F-20.03).

(21) Sleeve (172, 60-4365-3) -- Cadmium plate (F-15.06) per SOPM 20-42-05. Material: 17-7PH CRES (15-5 PH CRES Optional), 150-170 ksi.

(22) Sleeve (173, 66-24987-3) -- Passivate (F-17.09). Material: 17-7PH CRES, 150-170 ksi.

(23) Hinge link pin (174)

(a) 66-14527-1, -2 -- Cadmium plate (F-1.191) all over, except 0.0002-0.0004 inch plating thickness in area of spline. Diameters after plating should be 1.3750-1.3736 and 0.9970-0.9950 inch. Material: 4340 steel, 125-145 ksi.

(b) 66-14527-4 -- Cadmium plate (F-16.04) exterior surfaces. Plating "throw-in" allowed on interior surfaces. Diameter after plating should be 1.3750-1.3736 and 0.9970-0.9950 inch. Apply phosphate coating (F-14.14) and two coats of BMS 10-11, Type 1 primer (F-20.03) on interior surfaces. Material: 4340 steel, 125-145 ksi.

(c) 66-14527-6 -- Cadmium plate (F-15.06) exterior surface. Diameters after plating should be 1.3750-1.3736 and 0.9970-0.9950 inch. Material: 15-5PH CRES, 150-170 ksi.

(24) Spring (175) -- Cadmium plate (F-1.20) all over.

(25) Attach fittings (188, 196) -- Alodize or chromic acid anodize and apply one coat of BMS 10-11, Type 1 primer (SRF-2.30) all over. Material: Al alloy.

(26) Hinge arms (182E, 182H)

(a) Hinge arm (182E, 69-17952-19; 182H, 69-17952-20) -- Chemical treat or chromic acid anodize and apply BMS 10-11, Type 1 primer (SRF-2.30). Do not put primer or enamel in the splined hole. Material: Al alloy.

(b) Hinge arm (182E, 65-73978-3, -13; 182H, 65-73978-4, -14) -- 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 put primer or enamel in the splined hole. Material: Al alloy.

(c) Hinge arm (182E, 65-73978-9, -11; 182H, 65-73978-10, -12) -- Chemical treat or chromic acid anodize and apply BMS 10-11, Type 1 primer (F-18.05) and apply BMS 10-11, Type 1 color 702 white enamel (F-21.25). Do not put primer or enamel in the splined hole. Material: Al alloy.

(27) Hinge supports (190, 198) -- Alodize or chromic acid anodize and apply one coat of BMS 10-11, Type 1 primer (SRF-2.30) all over except no primer in bores and holes. Material: Al alloy.

(28) Roller fitting (201) -- Chromic acid anodize (F-2.20) and apply one coat of BMS 10-11, Type 1 primer (SRF-12.205) all over except no primer on serrations. Material: Al alloy.

(29) Centering guide (205) -- Hard chrome plate (F-1.842) on spherical head a minimum of 0.002 inch thick and cadmium plate (F-1.191) on remaining surface. Material: 4130 steel, 150-170 ksi.

(30) Door stop pin (207) -- Cadmium plate (F-1.1923) all over. Material: 4130 or 4340 steel, 160-180 ksi.

(31) Plug (208) and block (210) -- Alodize or chromic acid anodize and apply one coat of BMS 10-11, Type 1 primer (SRF-2.30) all over. Material: Al alloy.

(32) Hinge cover (209 and 214) -- Apply Alodine 1000 (SRF-14.01) all over. Material: Al alloy.

B. Figure 1102

(1) Fillers (6, 7), and spacer (15) -- Alodize or chromic acid anodize and apply one coat of BMS 10-11, Type 1 primer (SRF-2.30) all over.

(2) Outer handle (14)

(a) Outer handle (14, 90-7879-1) -- Chromic acid anodize (F-17.04) (no substitutions allowed for chromic acid anodize), but seal in deionized water. Material: Al alloy.

(b) Outer handle (14, 90-7879-6) -- Boric acid - sulfuric acid anodize (F-17.29) (no substitutions allowed). Material: Al alloy.

(c) Outer handle (14, 90-7879-10) -- Sulfuric acid anodize (F-14.2998) (non-directional on exterior surface only (63Ra)). Material: Al alloy.

(3) Cam (16) -- Cadmium plate (F-4.20) all over. Material: Alum-Bronze or beryllium copper.

(4) Sleeve (17) -- Apply dry lubricant BMS 3-8, class A, all over 0.0002 to 0.0005 inch thick. Material: Al-Ni-Bronze.

(5) Washer (19) -- Cadmium plate (F-4.201) all over. Material: Al-Ni-Bronze.

(6) Nut (21) -- Chromic acid anodize (F-2.20) all over. Material: Al alloy.

(7) Spring (22) -- Cadmium plate (F-1.1923) all over.

(8) Shaft (24)

(a) Shaft (24, 60-4455,-1, -2) -- Passivate (F-8.07). Apply BMS 3-3, Type I coating (0.0002-0.0005 inch thick) on large spline area. Material: 303 CRES, annealed.

(b) Shaft (24, 60-4455-3) -- Passivate (F-17.25) all over. Cadmium plate (F-15.06) on small spline. Apply BMS 3-8 dry film lubricant (0.0002-0.0005 inch thick) on large spline as specified in SOPM 20-50-08, Type VIII. Material: 15-5PH CRES, 150-170 ksi.

(9) Guide (27) and seal plate (37) -- Alodize or chromic acid anodize and apply one coat of BMS 10-11, Type 1 primer (SRF-2.30) all over.

(10) Control cam (31) -- Alodize or chromic acid anodize and apply one coat of BMS 10-11, Type 1 primer (F-2.22) plus (SRF-12.205), and apply one coat of enamel (SRF-12.63) all over except no paint in bores, on splines, and on roller contact surfaces.

(11) Housing (41)

(a) Housing (41, 90-7820-1) -- Cadmium plate (F-1.1923) all over, except dry lubricate surface of 1.250-inch bore with BMS 3-8, class A, per SOPM 20-50-08, Application of Dry Lubricant. Material: 4130 steel, 125-145 ksi.

(b) Housing (41, 69-61511-2) -- Cadmium plate (F-15.24) all over, except Chromium plate (F-15.03), 0.003 inch thick, in 1.250-inch bore. Grind chrome plate to 1.250-1.252 ID and 63-microinch finish. Material: 4130 steel, 125-145 ksi.

(12) Special nut (43).

(a) 60-4405 -- Cadmium plate (F-1.1913) all over. Material: 8630 or 4130 steel, normalized.

(b) 60-4405-1 -- Chromic acid anodize (F-2.20) all over. Material: Al alloy.

(13) Torque tube (47)

(a) 90-6753-6 -- Cadmium plate exterior surfaces and apply two coats of BMS 10-11, Type 1 primer (F-1.611) on interior surfaces. Tube diameters to be 1.3750-1.3756 and 1.5620-1.5606 inches after plating. Material: 4130 steel, 125-145 ksi.

(b) 90-6753-11 -- Cadmium plate (F-16.04) exterior surfaces. Tube diameters to be 1.3750-1.3756 and 1.5620-1.5606 inches after plating. Apply phosphate coating (F-14.14) and two coats of BMS 10-11, Type 1 primer (F-20.03) on interior surfaces. Material: 4130 steel, 125-145 ksi.

(c) 90-6753-18 -- Cadmium Plate (F-15.02) exterior surface per SOPM 20-42-05. Tube diameters to be 1.3750-1.3756 and 1.5620-1.5606 inches after plating. Material: 17-7PH CRES, 150-170 ksi.

(14) Pushrod (56) -- Cadmium plate (F-1.1923) exterior and apply MIL-C-11796 corrosion preventive compound (F-1.73) to interior surface. Plating "throw-in" allowed on interior surface. Material: 8630 or 4130 steel, 150-170 ksi.

(15) Crank (57, 69-17330-2) -- Cadmium plate (F-1.191) all over. Material: 4130 or 8630 steel, 125-145 ksi.

(16) Crank (57, 69-17330-4) -- Passivate (F-17.09). Material: 15-5PH CRES, 150-170 ksi.

(17) Washer (60) -- Cadmium plate (F-1.1923) all over. Material: 1020 or 1025 steel.

(18) Crank (63)

(a) 65-54024-6 -- Alodize or chromic acid anodize and apply one coat of BMS 10-11, Type 1 primer (SRF-2.30) all over except no primer on splines. Material: Al alloy.

(b) 65-1933-4 -- Passivate (F-8.07) all over. Material: 15-5PH CRES, 180-210 ksi.

(c) 65-1933-7, -12, -21, -507 -- Chromic acid anodize and apply (2) coats of BMS 10-11, Type 1 primer (F-18.13) (F-20.02). Omit primer from splined surfaces. Material: Al alloy.

(d) 65-1993-17, -19 -- Chemical treat or chromic acid anodize and apply BMS 10-11, Type 1 primer (F-18.03) (F-20.02). Do not put primer on the splined surfaces. Material: Al alloy

(19) Crank (65) -- Alodize or chromic acid anodize and apply one coat of BMS 10-11, Type 1 primer (SRF-2.30) all over except no primer on splines. Material: Al alloy.

(20) Crank arm (72, 69-38733-2) and (79, 69-38732-2) -- Chromic acid anodize (F-2.26) all over and apply one coat of BMS 10-11, Type 1 primer (SRF-12.205) all over except on bearing surfaces and serrations. Material: Al alloy.

(21) Crank arm (72, 90-7815-3) and (79, 90-7815-5) -- Cadmium plate exterior surfaces and apply two coats of BMS 10-11, Type 1 primer on interior surfaces (SRF-1.611), except use single plating thickness of 0.0002-0.003 inch. Bearing surface diameters to be 1.3110 to 1.3120 and 1.4360 to 1.4370 inch after plating. Material: 4340 steel, 150-170 ksi.

(22) Crank Arm (72, 90-7815-19, -21) -- Chromic acid anodize and apply BMS 10-11, Type I primer (F-18.13). Apply BMS 10-11, Type I primer (F-20.02) but do not put the primer on the splined surfaces. Material: Al alloy.

(23) Crank Arm (72, 90-7815-27, -29; 79, 90-7815-28, -30) -- Boric acid - sulfuric acid anodize (F-17.35). Apply BMS 10-11, Type 1 primer (F-20.03) but do not put primer on the splined surfaces. Material: Al alloy.

(24) Bearing retainer (85, 63-1059) -- Alodize or chromic acid anodize and apply one coat of BMS 10-11, Type 1 primer (SRF-2.30) all over. Material: Al alloy.

(25) Bearing retainer (85, 69B10068-3) -- Chemical treat or chromic acid anodize (F-17.01). Apply BMS 10-11, Type 1 primer (F-20.02). Material: Al alloy.

(26) Housing assembly (92, 65-1642-42, -46) -- Apply BMS 10-60 enamel (SRF-14.9813). Do not apply the enamel to the bushings, close toleranced bores, or holes common to the nutplates (16 locations).

(27) Housing (93, 65-1642-13) -- Dow 17 anodize per SOPM 20-43-02 (or Dow 7 treat) and apply three coats of BMS 10-11, Type 1 primer per 20-41-02 (SRF-3.71) all over except in holes Dow 17 anodize per 20-43-02 but omit primer. Material: Magnesium.

(28) Housing (93, 65-1642-35) -- Dow 17 anodize per 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.

(29) Housing (93, 65-1642-44, -47) -- Dow 17 anodize (F-17.12) and apply BMS 10-11, Type 1 primer (F-20.03). Material: Magnesium.

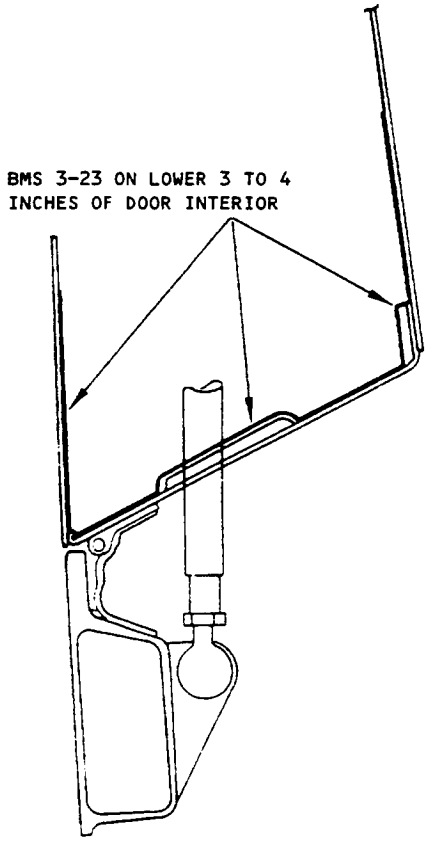
(30) Filler (98, 99) -- Boric acid - sulfuric acid anodize (F-17.31) and apply BMS 10-11, Type 1 primer (F-20.03). Material: Al alloy.

(31) Bushing (101) -- Cadmium plate (F-15.02). Cadmium plate is optional in the bore. Material: Al ni BR.

(32) Door structure

(a) Apply BMS 3-23 corrosion preventive compound (F-19.26) on lower 3 to 4 inches of door interior as shown in Fig. 402A.

(b) Apply one coat of BMS 10-79 primer and BMS 10-60, Type 2 enamel (F-14.9863-702) to entire interior surface of window frame. Overspray allowed on inner surface of skin, window clips and nutplates.



BMS 3-23 Application
Figure 402A

3. Replacement

A. Replace springs (175, Fig. 1101, and 22, Fig. 1102) if requirements of Fig. 301 are not met.

B. If any of bushings (44, 47, 50, 53, 56, 59, 62, 65, 69, 72, and 75, Fig. 1101) need replacement, install new bushing in stop with wet BMS 10-11, Type 1 primer and flare thin end.

CAUTION: AFTER FLARING, BUSHING MUST BE FLUSH AGAINST FAYING SURFACES AND FIT SNUGLY IN BORE.

C. If bushings (111, 114 or 115, Fig. 1101; 101, Fig. 1102) require replacement, install new bushings as follows:

(1) Bushings (111, 115, Fig. 1101) -- Coat faying surfaces with primer, BMS 10-11, Type 1, and press bushing into hole while primer is wet. On gate assemblies P/N 65-55478-501 and 65-55479-502 only, after installation of bushing, as above, apply fillet seal of BMS 5-95 around bushing flange and apply SRF-14.9815 over sealant. Use care not to get sealant or enamel on bushing face.

(2) Bushings (114, Fig. 1101) -- Coat faying surfaces with primer, BMS 10-11, Type 1, install bushing in hole while primer is wet and flare thin end. Be certain that bushing is flush against faying surfaces after flaring. On gate assemblies P/N 65-55478-501 only, after installation of bushing as above, apply fillet seal of BMS 5-95 around flange and apply SRF-14.9815 over sealant. Use care not to get sealant or enamel on bushing face.

(3) Replace bushing (101, Fig. 1102) in housing (93, 65-1642-44, -47), if necessary, as follows:

(a) Remove the flared material from the old bushing and press the bushing from the bore.

(b) Install the new bushing with web BMS 5-95 sealant as specified in SOPM 20-50-03.

(c) Fillet seal the bushing flanges as specified in SOPM 20-50-19.

D. Replace all cotter pins, seal washers, and O-ring packing.

E. Replace any parts damaged beyond simple repair or refinish.

F. Some door assemblies are provided with protection against corrosion of the cold bonded door structure around the periphery of the door frame and the door outer skin by factory-applied sealant or by incorporation of Service Bulletins 53-1017 and 53-1017, Revision 1. If sealant has been removed or damaged, replace as follows:

(1) Reapply sealant around periphery of door frame and door outer skin as required per 53-30-4, 737 Structural Repair Manual, D6-15565. Additional protection against corrosion may be obtained by application of LPS-3 followed by sealing as follows:

(a) Clean area to be sealed and apply LPS-3 as required to the periphery of the door frame and door outer skin per 51-10-2, 737 Structural Repair Manual, D6-15565.

(b) After LPS-3 Solvents have evaporated, remove any visible film of LPS-3 by wiping with a 1:1 mixture of methyl ethyl ketone and toluene.

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

(c) Reapply sealant around periphery of door frame and door outer skin as required per 53-30-4, 737 Structural Repair Manual, D6-15565.

G. Replace damaged torque tube (47, Fig. 1102) or crank (57) using standard industry practice. Maintain linear and angular dimensions given in Fig. 403.

H. Apply any suitable parting agent to exposed heel of hinge (117, 65-45849-521) and lower edge of upper door gate entire width of door. Fill cavity with BMS 5-95, Type B-1/2 sealant entire width of door gate. Door gate must be in door closed position to accomplish proper seal.

I. If nutplates (94, 96, Fig. 1102) require replacement, install as follows:

(1) 65-1642-12 housing assembly -- Install with MIL-C-11796, class 3 corrosion preventive compound (F-12.44) between nutplate base and housing. Optional method, apply BMS 5-95 between nutplate and housing and install nutplate faster with wet sealant BMS 5-95.

(2) 65-1642-27 housing assembly -- Apply BMS 5-95 between nutplate base and housing and install nutplate fasteners with wet sealant BMS 5-95.

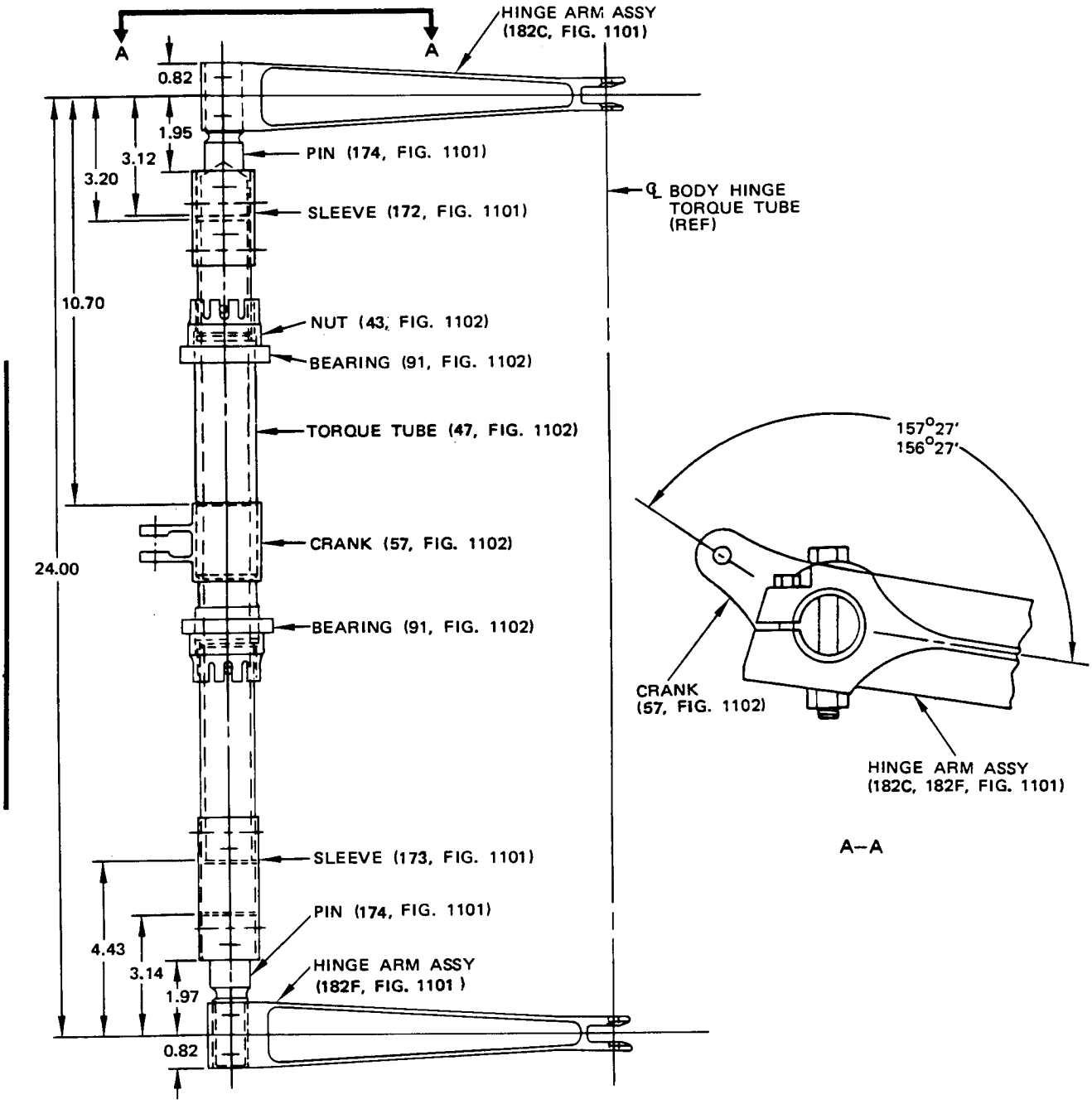
(3) 65-1642-42, -46 housing assembly -- Install nutplates with wet BMS 5-95 (F-19.65) and install nutplate attach rivets with wet BMS 5-95 sealant (F-1 9.48). Coat rivet shank with sealant prior to insertion. Rivet (94) to be flush to +0.010 inch of casting face.

4. Materials

A. Primer -- BMS 10-11, Type 1

B. Sealant -- BMS 5-95, class B (supersedes BMS 5-79, class B)

C. Corrosion Preventive Compound -- LPS-3 (SOPM 20-60-04)



NOTE: DIMENSIONS ARE IN INCHES AND ARE FOR REFERENCE ONLY
PARTS ARE SUPPLIED WITH HOLES JIG DRILLED.

Hinge Arm and Crank Positioning
Figure 403

ASSEMBLY

NOTE: When they were made, the doors were fillet and injection sealed with BMS 5-95 or other 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.

1. Before assembly, apply MIL-C-11796, class 3 corrosion-preventive compound to all bolts and screws and to mating surfaces of parts which are installed with a press fit except as noted in assembly procedure. Install bolts, screws, and nuts per SOPM 20-50-01 and install bearings per SOPM 20-50-03.

2. For handle box housing assemblies (92, 65-1642-42, -46) install bushings (101) into handle box housing (93, 65-1642-44, -47) with wet BMS 5-95 sealant (SOPM 20-50-03) and fillet seal the bushing flanges (SOPM 20-50-19).

3. For 65-45849-2 door assemblies, install bearings (91, Fig. 1102) in housing (92) with wet BMS 10-11, Type 1 primer. On all other door assemblies and on assemblies modified per SB 52-1094, install bearings (91) with BMS 5-95 sealant and fillet seal with sealant.

4. For handle box housing assemblies (92, 65-1642-42, -46) install bushings (101) into handle box housing (93, 65-1642-44, -47) with wet BMS 5-95 sealant (SOPM 20-50-03) and fillet seal the bushing flanges (SOPM 20-50-19).

5. Install bearing (90) with retaining ring (89). Install bearing (90) with wet BMS 10-11, Type 1 primer and install retaining ring (89) with MIL-C-11796, class 3 corrosion-preventive compound.

6. Install bearings (86, 87) with wet BMS 5-95 sealant. Apply MIL-C-11796, class 3 corrosion preventive compound to faying surface common to bearing retainers (85) and housing (92). Install bolts (82, 83, 84) with wet BMS 5-95 sealant, and install washers (81) and nuts (80) with MIL-C-11796, class 3 corrosion preventive compound.

7. Preassemble crank assembly (66, 73) with parts (67 thru 72, 74 thru 79). Install bearing unit (71, 78, BACB10BH60F9, BACB10BH60F8, BACB10BH60CF6, BACB10AF6F3H, BACB10AF6F6H) with MIL-C-11796, class 3 corrosion-preventive compound. Install bearing unit (71, 78, BACB10FK6F6HS, KRP141500VT6-6) with wet BMS 5-95 sealant (SOPM 20-50-03). Install the washers as follows:

   A. For crank assemblies (66, 69-38733-1; 73, 69-38732-1), install washers (69, 70, 76, 77) as follows:

      (1) If bearing (71, 78, BACB10BH60F9) is used: Install four washers (70, 77) adjacent to the head of the bearing and one washer (69, 76) adjacent to the nut (68, 75).

      (2) If bearing (71, 78, BACB10H60F8) is used: Install two washers (70, 77) adjacent to the head of the bearing and one washer (69, 76) adjacent to the nut (68, 75).

   B. For crank assemblies (66, 90-7815-1, -15, -17, -23, -25; 73, 90-7815-4, -16, -18, -24, -26), install washers (69A, 76A) as follows:

      (1) Apply BMS 10-11, Type 1 primer to the washers (69A, 76A) and install one washer (69A, 76A) adjacent to the head of the bearing (71, 78), and a maximum of five washers (69A, 76A) adjacent to the nut (68, 75) to get the correct nut torque and install the cotter pin. Tighten the nut (68, 75) to 95-170 pound-inches (threads not lubricated) or 45-80 pounds-inches (lubricated threads).

8. For 65-45849-2 door assemblies, brush or swab BMS 10-11, Type 1 primer on inside surface of bearing (86, 87) and on washers (60). For all door assemblies, apply thin coat of corrosion preventive compound, MIL-C-16173, grade 2, on both internal and external splines of crank assemblies (63, 65, 66, 73). Prealign crank assemblies (63, 65) and spacer (64) in housing (92) and insert crank assemblies (66, 73). Install bolts (61, 62) with MIL-C-11796, class 3 corrosion preventive compound, washers (60, 59) with BMS 10-11, Type 1 primer, and nuts (58).

9. Brush or swab BMS 10-11, Type 1 primer on inside surface of rod end bearing (55) and crank (63). Insert rod assembly (52) in housing (92) and attach to crank (63) with a washer (49) that has BMS 10-11, Type 1 primer and a bolt (51) that has MIL-C-11796, class 3 corrosion preventive compound.

10. Attach crank (57) to rod assembly (52) with a bolt (50) that has MIL-C-11796, class 3 corrosion preventive compound, washer (49), and nut (48).

NOTE: Lubricate connection with BMS 3-33 or MIL-G-23827 grease.

11. On assemblies modified per SB 52-1094, brush or swab mating surfaces of torque tube (47) and bearings (91) with BMS 10-11, Type 1, primer. Slide torque tube (47) into housing (92) and crank (57) and attach with bolts (46), washers (45), and nuts (44). Assemble torque tube (47) and crank (57) with a thin layer of MIL-C-16173, grade 2 corrosion-preventive compound on both internal and external mating surfaces. Tighten nuts (44) to 65-80 lb-in. on assemblies modified per SB 52-1094.

NOTE: For door assemblies 65-45849-155, -166, -169, -170, -536 and door assemblies 65-45849-2 modified per SB 52-1094, nuts (44) are intended to bottom out on bolt threads in order to avoid clamp up. A gap between crank (57) and washers (45) of up to 0.016 inch is acceptable. If greater gaps occur, install additional washers (45) as required.

12. Install nuts (43) on torque tube (47) but do not tighten nuts or install cotter pins (42). Torque tube will be adjusted on installation of door in airplane. Install nuts (43) with a thin layer of MIL-C-16173, Grade 2 corrosion-preventive compound on both internal and external mating threads.

13. Preassemble parts (11 thru 24) as follows:

A. Put pin (23) and spring (22) in shaft (24). Screw nut (21) in shaft with wrench F70038, and attach the nut with lockring (20). Install nut (21) in shaft (24) with a thin layer of MIL-C-16173, Grade 2 corrosion-preventive compound on both internal and external mating threads.

B. Put washer 30-3019 (19) on a 10-32 bolt and screw the bolt in pin 30-3013-1 (23). With the 10-32 bolt, pull spring-loaded pin (23) until the slot in washer (19) is aligned with the hole in the pin. Install retaining spring pin (18) and remove the 10-32 bolt. Turn washer 30-3019-1 (19) on pin 30-3013-2 (23) until the hole in washer (19) and pin (23) align, and then install spring pin (18). Install washer (19) with BMS 10-11, Type 1 primer.

C. Put shaft (24) in housing (17) and insert housing in cam (16). Install shaft (24) with MIL-C-11796, class 3 corrosion-preventive compound.

D. Add spacer (15) between housing (17) and outside handle (14) and attach all parts with bolts (13), washers (12), and nuts (11). Install bolts (13) with dry BMS 10-11, Type 1 primer on the countersink area of the bolt holes in the handle.

14. Install attach fitting (196, Fig. 1101) in hinge support (198) with washers (193, 195) and bolts (192, 194). Do not tighten bolts (192, 194) to final torque, because attach fitting (196) will be removed on installation of door in airplane. Press fit bushing (197) in hinge support (198) until flush with the outside of the hinge support.

15. Install attach fitting (188) in hinge support (190) with washers (185, 187) and bolts (184, 186). Do not tighten bolts (184, 186) to final torque, because attach fitting (188) will be removed on installation of door in airplane. Press fit bushing (189) in hinge support (190) until flush with the outside of the hinge support.

16. Install upper and lower hinge support assemblies (183, 191) in door structure with seal washers (182), bolts (180, 181), washers (179), and nuts (178). Tighten bolts (180, 181) to 13-60 pound-inches.

17. Slide springs (175), washers (176), and packing (177) on hinge link pins (174). Lubricate packing (177) with AMS-SAE-G-4343 grease (SOPM 20-50-07).

18. Put hinge arm assemblies (1 82C, 182F) in hinge support assemblies (183, 191). Install hinge link pins (174) in support assemblies and hinge arm assemblies. Assemble hinge link pins (174) with a thin layer of MIL-C-16173, Grade 2 corrosion-preventive compound on both internal and external mating surfaces. Install washer (18213) and bolts (182A).

19. Prepare for installation of handle mechanism in door structure as follows:

    A. Slide coupling sleeves (172, 173, Fig. 1101) on torque tube (47, Fig. 1102).

    B. Lubricate packings (35 and 38) with MIL-G-4343 grease (SOPM 20-50-07). Install packing (38) and lubricator fitting (40) in housing (41). Install packing (35) inside seal plate (37).

    C. Apply a corrosion protection faying surface seal of BMS 5-95 sealant between entire mating surface of shims (8), or fillers (7) if shims are not used, and handle housing assembly (92).

        NOTE: Sealant application for corrosion protection faying surface seal normally requires coating of about 0.010 inch of sealant.

20. Install housing assembly (39) and handle mechanism housing assembly (92) with attached parts in door structure with shims (8), fillers (6, 7), washers (5), and bolts (1 thru 4). Install housing assembly (39) with wet BMS 10-11, Type 1 primer on exterior surface and turn it to put lube fitting (40) on the forward or aft side.

21. Install seal washers (34), washers (33), and bolts (32) to attach housing assembly (39). Tighten bolts (32) to 13-60 pound-inches.

22. Slide preassembled parts (11 thru 24) into bore of handle mechanism housing. Install washer (88), if required, and cam assembly (25) to make (24) to make bearings (71, 78) centered on 0.75 inch holes of control cam (31) in door-closed position. Attach control cam (31) with washers (9A, 10), nut (9), and cotter pin (24A), as applicable. Install control cam (31), washers (9A, 10), nut (9), and cotter pin (24A), as applicable, with MIL-C-11796, class 3 corrosion-preventive compound. Tighten nut (9) used on shaft (24, 60-4455) to 95-110 pound-inches.

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

23. Slide sleeves (172, 173, Fig. 1101) partly on hinge pins (174) and install bolts (171), washers (170), and nuts (169). Install bolts (171) used to fasten sleeve (172), with the heads inboard and forward. Install bolts (171) used to fasten sleeve (173) with the heads inboard and aft. Assemble sleeves (172, 173) with a thin layer of MIL-C-16173, grade 2 corrosion-preventive compound on both internal and external mating surfaces. Tighten nuts (169, BACN10YR4CD) on bolts (171, BACB30NM4K26) to a running torque of 30-40 in-lb.

    NOTE: For door assemblies 65-45849-159, -166, -169, -170, -536 and door assemblies 65-45849-2 modified per SB 52-1094, nuts (169) are intended to boom out on bolts threads in order to avoid clamp up. A gap between sleeves (172, 173) and washers (170) of up to 0.016 inch is acceptable. If greater gaps occur, install additional washers (170) as required.

    NOTE: Bolt (171) direction is important to prevent threads in bearing. No substitution of the bolt (171) grip length is permitted.

24. Install lubricator fittings (1154, 157, 160, 166) in support fittings (155, 158, 161) and housings (167) respectively. Install bearings (168) in support fittings (155, 158, 161) and housings (167). Before you install bearings (168) and lube fittings (154, 157, 160), apply a thin layer of BMS 3-33 or MIL-G-23827 grease to all surfaces (SOPM 20-50-07).

25. Install housing assemblies (165) in door structure with bolts (164), washers (163), and nuts (162).

26. Install shims (151, 152) if and as necessary. Remove 0.003 inch laminations as necessary to get 0.010 inch or less gap. Install support fitting assemblies (153, 156, 159) with bolts (150), washers (1149), and nuts (148). After delamination, install shims (151, 152) with BMS 10-11, Type 1 primer either wet or dry.

27. Put rod assemblies (93, 98) inside door structure with fixed end to be connected to crank (65, Fig. 1102) later.

28. Slide torque tubes (146, 147) in door structure and cranks (143 thru 145). Attach cranks with bolts (142), washers (141), and nuts (140). On assemblies modified per SB 52-1094, apply BMS 10-11, Type 1 primer to mating surfaces of cranks (143 thru 145) and torque tubes (146, 147). For door assemblies 65-45849-159, -166, -169, -170, -536 and door assemblies 65-45849-2 modified by SB 52-1094, tighten nuts (140) to 35-45 lb-in.

    NOTE: For door assemblies 65-45749-159, -166, -169, -170, -536 and door assemblies 65-45849-2 modified per SB 52-1094, nuts (140) are intended to bottom out on bolt thread in order to avoid clamp up. A gap between cranks (143 thru 145) and washers (141) of up to 0.016 inch is acceptable. If greater gaps occur, install additional washers (141) as required.

29. Install three washers (138) on shaft of each bearing unit (139) and install the bearing units in cranks (134). Add one washer (138) to each bearing unit shaft and install nuts (137) and cotter pins (136).

30. Install cranks (134) in torque tubes (146, 147). Use spacers (135) if and as required. Attach the cranks with bolts (133), washers (132), and nuts (131). On assemblies modified per SB 52-1094, coat mating surfaces of cranks (134) and torque tubes (146, 147) with BMS 10-11, Type 1 primer. For door assemblies 65-45849-159, -166, -169, -170, -536 and door assemblies 65-45849-2 that have been modified by SB 52-1094, lubricate bolts (133) with BMS 3-33 or MIL-G-23827 grease (SOPM 20-50-07) and tighten nuts (131) to 35-45 lb-in.

    NOTE: For door assemblies 65-45849-159, -166, -169, -170, -536 and door assemblies 65-45849-2 modified per SB 52-1094, nuts (131) are intended to bottom out on bolt threads in order to avoid clamp up. A gap between torque tubes (146, 147) and washers (132) of up to 0.016 inch is acceptable. If greater gaps occur, install additional washers (132) as required.

31. Apply a thin layer of BMS 3-33 or MIL-G-23827 grease (SOPM 20-50-07) to hinge pins (119, 126). Attach hinge halves (120, 121, 127, 128) with hinge pins (119, 126). Attach hinge pins with spring pins (118, 125). Install spring pins (118, 125) with MIL-C-11796, class 3 corrosion-preventive compound.

32. Install upper and lower gate assemblies (110, 113) with fillers (108, 109).

33. Attach upper and lower gates with bolts (103 thru 105), washers (103A, 104A, 107), and nuts (106). Make sure the gap width between the gate and the door (recorded during disassembly) did not change.

34. Connect handle mechanism to latching rods with rod assemblies (93, 98) using bolts (79, 81), washers (77, 78), and nuts (76). Apply MIL-C-11796, class 3 corrosion preventive compound to washers (78) and bolts (81).

35. Connect the fixed end of rod assemblies (83, 88) to latching rods with bolts (79), washers (77), and nuts (76). Install bushings (82) in upper and lower gates.

36. Apply a thin layer of BMS 3-33 or MIL-G-23827 grease to rod ends (84A, 89A) (SOPM 20-50-07) before installation. Connect the adjustable end of rod assemblies to upper and lower gates with bolts (80), washers (78), and nuts (76). Install bolts (80) with MIL-C-11796, class 3 corrosion preventive compound.

37. Put serrated plate (42, Fig. 1101) on door structure (200) and install roller fitting (201) with washers (41), bolts (39, 40). Do not tighten the bolts because this roller fitting will be adjusted when the door is installed on the airplane.

38. Use the B52004-1 door seal installation tool (SE52-1002 optional) to insert the seal (38) in the door seal retainers. You can use soapy water to make seal installation easier. Attach the diaphragm with nylon rods (35 thru 37). Install the rod at both ends to make a butt fit of the radius end at the centerline of the door.

CAUTION: WHEN YOU INSTALL WINDOW PANES, BE SURE TO TURN THEM TO MAKE THE MARKINGS ON PANES SYMMETRICAL WITH THE CENTER LINE OF THE UPPER MOUNTING CLIP.

39. Assemble seal (34), outer pane (33), inner pane (32), retainer (31), and seal (30). Bond seal (30) to retainer (31) with Type 12 adhesive (SOPM 20-50-12). Use shims (28, 29) as required to compress seal (30) a maximum of 0.03 inch. Install shims (28, 29) 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 these parts with clips (27), screws (26), one washer (25) under head of each screw, and one washer (25) under each nut (24). Install washers (25) and screws (26) with MIL-C-11796, class 3 corrosion-preventive compound.

40. Install window assembly (23) in door structure with washers (22) and bolts (21).

41. Install reinforcing angles (19, 20) with bolts (15, 16), washers (17, 18), and nuts (13, 14).

42. Install cover plates (12) with screws (10), bolts (11) and washers (10A, 1 1A).

43. Install cover plates (7, 8) and bracket (9) with washers (6) and bolts (5).

44. Install retainer (4) and split retaining rings (3) with studs (2).

45. Apply the weather seal to the interior of the lower hinge cavity and the lower gate (113) as follows:

    A. Put the door in the position that it will be in when it is installed on the airplane.

    B. Clean all surfaces that will touch the potting compound or the leveling compound (see CLEANING, step 5).

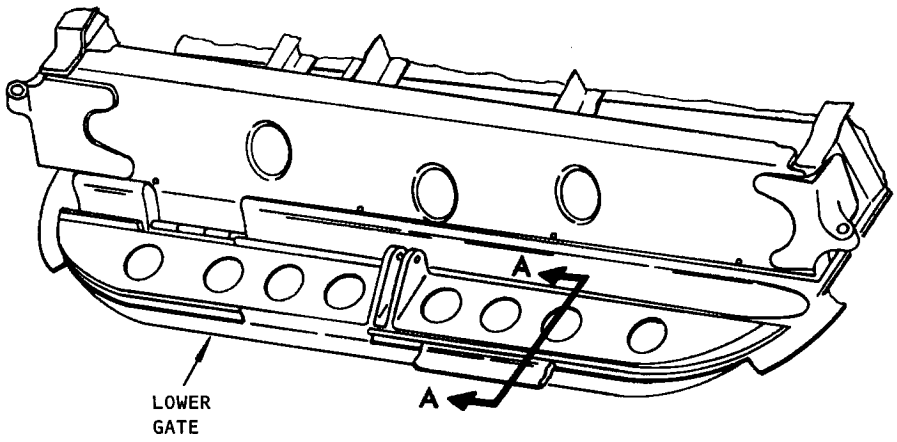
    CAUTION: DO NOT LET THE DRAIN HOLES BECOME PLUGGED.

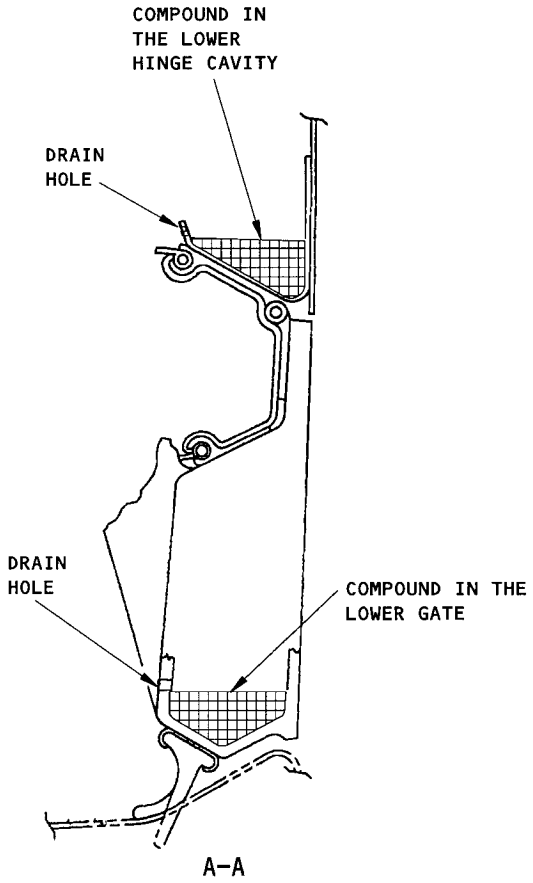
    C. Pour BMS 5-28 Type 1 potting compound or BMS 5-125 Type 2 or 3 leveling compound into the lower hinge cavity and the lower gate.

    D. Let the compound find its own level until it comes to a height shown in Fig. 501. The compound must fill the full width of the door.

46. Inject BMS 5-95, class B sealant into gap between seal retainers (122, 123, 129, 130) and structure.

47. Apply Dow Corning Q3-0121 sealant at corners of diaphragm and mechanical seal (8 places). Cover ends of seal retainers (122, 123, 129, 130) and retainer rods (35 thru 37) generously.





Assembly Details
Figure 501

48. Inject Dow Corning Q3-0121 sealant between the diaphragm seal and seal retainers (123, 130) approximately 1.50 inches long, centered on door centerline. Push the seal into the gap as far as possible.

49. Inject BMS 5-95, class B pressure sealant into the gap between seal retainers around the edges of the door.

50. Install Installation Items

    NOTE: These items are not part of the door assembly, but could be included with the door when it comes in for overhaul.

    A. Put block (210) and shims (211, 212) on upper hinge arm (182C) and install cover (209) with bolts (213) installed with dry BMS 10-11, Type 1 primer applied on the countersink area of the bolt holes.

    B. Put block (210) and shims (215, 216) on lower hinge arm (182F) and install cover (214) with bolts (217) installed with dry BMS 10-11, Type 1 primer applied on the countersink area of the bolt holes.

    C. Install plugs (208) in hinge support assemblies and seal with Type 40 adhesive (SOPM 20-50-12).

    D. Install stop pins (207) and retainer springs (206) in all stop fitting assemblies.

    E. Install centering guide (205), spacer (204), washer (203), and nut (202).

51. Apply BMS 3-23 corrosion preventive compound (F-19.26) on all interior door structure with access through inner skin access panels and intercostal lightening holes. Keep overspray away from the door operating mechanism.

52. Materials

    A. Corrosion-Preventive Compounds (SOPM 20-60-02)

        (1) MIL-C-11796, Class 3

        (2) MIL-C-16173, Grade 2

        (3) BMS 3-23, Type 2

    B. Grease (SOPM 20-60-03)

        (1) BMS 3-33

        (2) MIL-G-23827

        (3) AMS-SAE-G-4343 (Replaces MIL-G-4343)

C. Primer (SOPM 20-60-02)

(1) BMS 10-11, Type 1

D. Sealant (SOPM 20-60-04)

(1) BMS 5-95

(2) Dow Corning Q3-0121 Replacements

E. Solvent (SOPM 20-60-01)

(1) Aliphatic naphtha TT-N-95 (Replaces BMS 3-2)

F. Compounds (SOPM 20-60-04)

(1) BMS 5-28, Type 1 potting compound

(2) BMS 5-125, Type 2 or Type 3 leveling compound

FITS AND CLEARANCES

FOR TORQUE VALUES OF STANDARD FASTENERS, REFER TO SOPM 20-50-01			
		TORQUE	
ITEM NO.	NAME	POUND-INCHES	POUND-FEET
IPL FIG. 1101,			
131 *[1]	NUT	35-45	
140 *[1]	NUT	35-45	
180	BOLT	13-60 *[4]	
169	NUT	30-40 *[4]	
IPL FIG. 1102,			
9 *[6]	NUT	95-110 *[4]	
44 *[1]	NUT	65-80	
68 *[2]	NUT	95-170 *[4] 45-85 *[5]	
75 *[3]	NUT	45-85 *[5]	

*[1] TORQUE SPECIFICATION APPLICABLE TO DOOR ASSEMBLIES 65-45849-159, -166, -169, -170, -536 AND DOOR ASSEMBLIES 65-45849-2 THAT HAVE BEEN MODIFIED PER SB 52-1094.

*[2] TORQUE APPLICABLE TO NUTS USED ON CRANK ASSEMBLIES 90-7815-15, -17.

*[3] TORQUE APPLICABLE TO NUTS USED ON CRANK ASSEMBLIES 90-7815-16, -18.

*[4] UNLUBRICATED THREAD.

*[5] LUBRICATED THREAD.

*[6] TORQUE APPLICABLE TO NUTS FOR INSTALLATION OF SHAFT (24, 60-4455).

Torque Table
Figure 601

TESTING

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

TROUBLE SHOOTING

1. Trouble during test after overhaul.

Trouble	Possible Cause	Correction
A. Binding upper or lower gate control rod assembly (83 or 88, figure 1101)	Rod (87 or 92, figure 1101) bent, or rod end bearing (84 or 89) defective	Check and replace defective parts
B. Binding control rod assembly (93 or 98, figure 1101)	Rod (97 or 102, figure 1101) bent, or rod end bearings (94 or 99) defective	Check and replace defective parts
C. Loose outer handle (14, figure 1102)	Defective spring (22, figure 1102)	Replace spring
D. Binding handle mechanism (figure 1101)	Bearing (71, 78, 86, 87, 90, or 91, figure 1102) defective, rod (56) bent, or rod end bearing (55) defective	Check and replace defective part
	Foreign matter	Examine and clean
	Improper installation	Examine and reassemble

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)

ILLUSTRATED PARTS LIST

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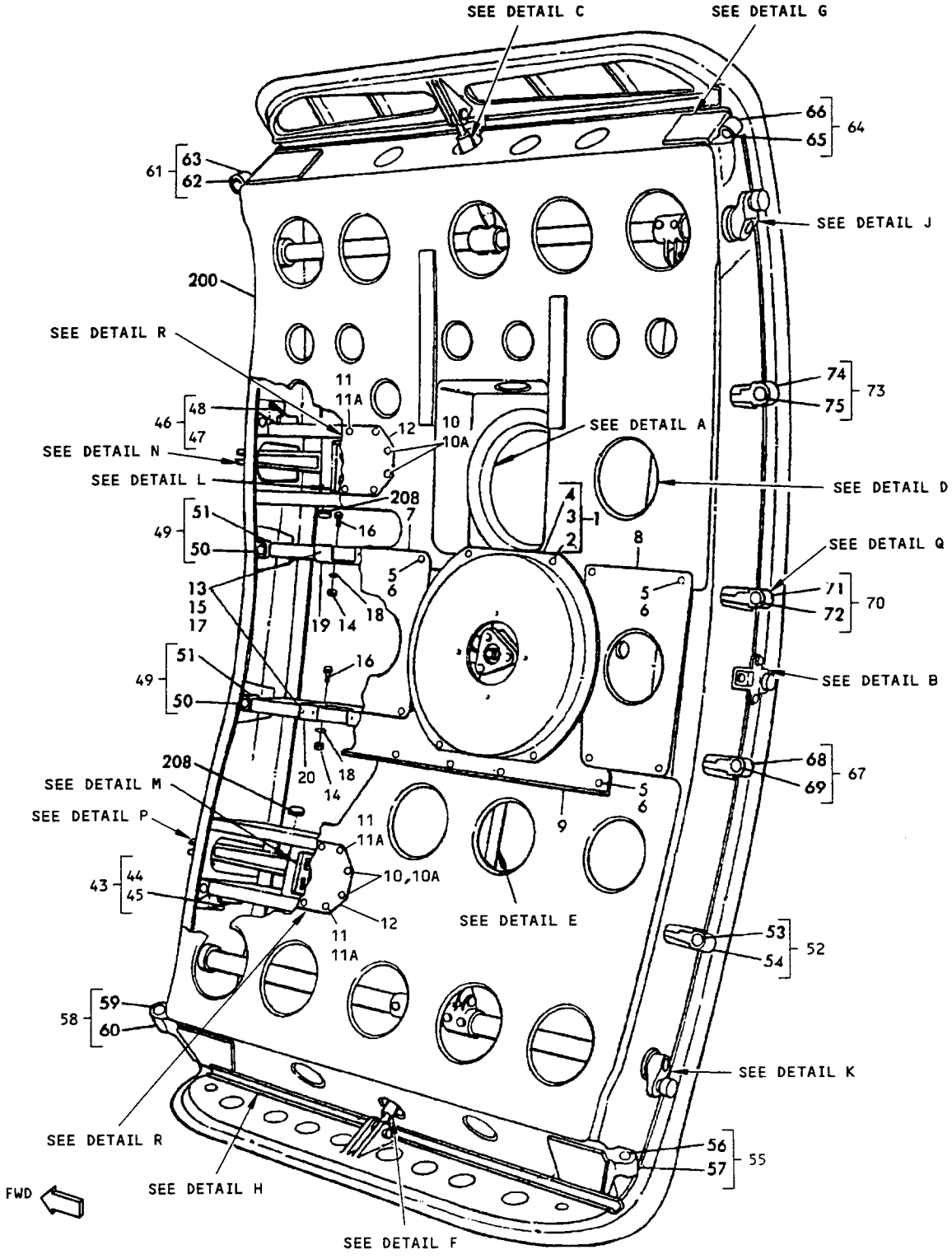
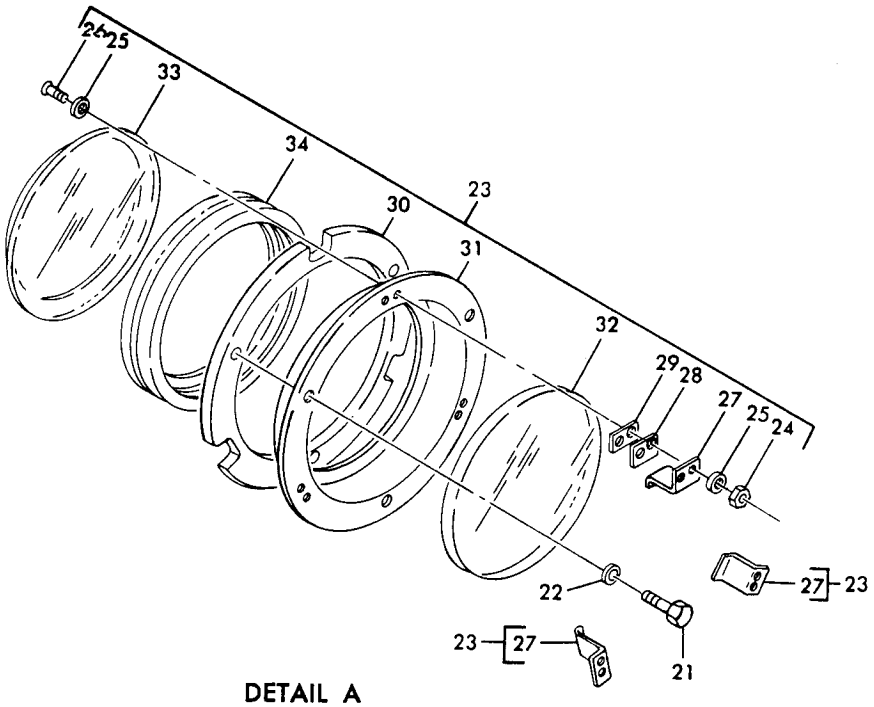
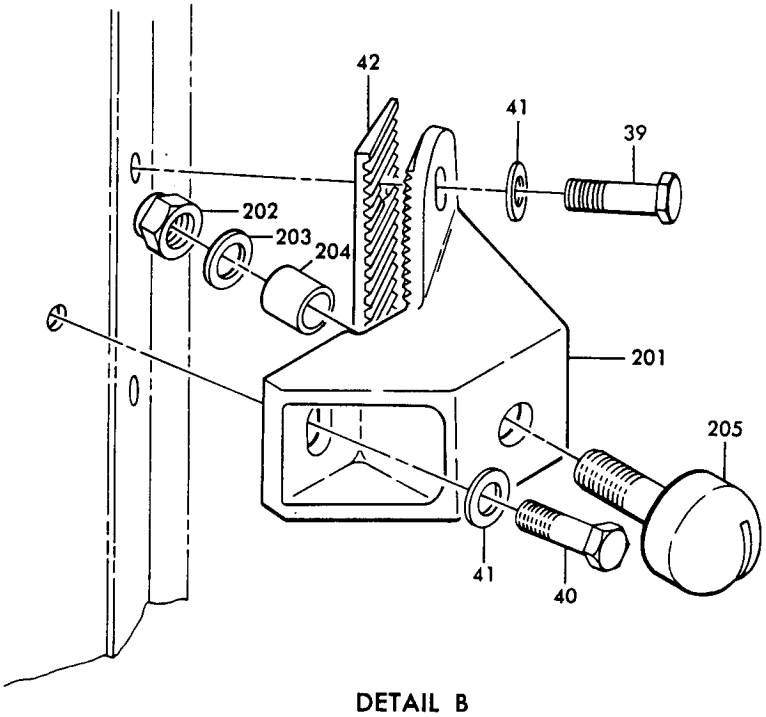


Aft Galley Door Assembly
Figure 1101 (Sheet 1)

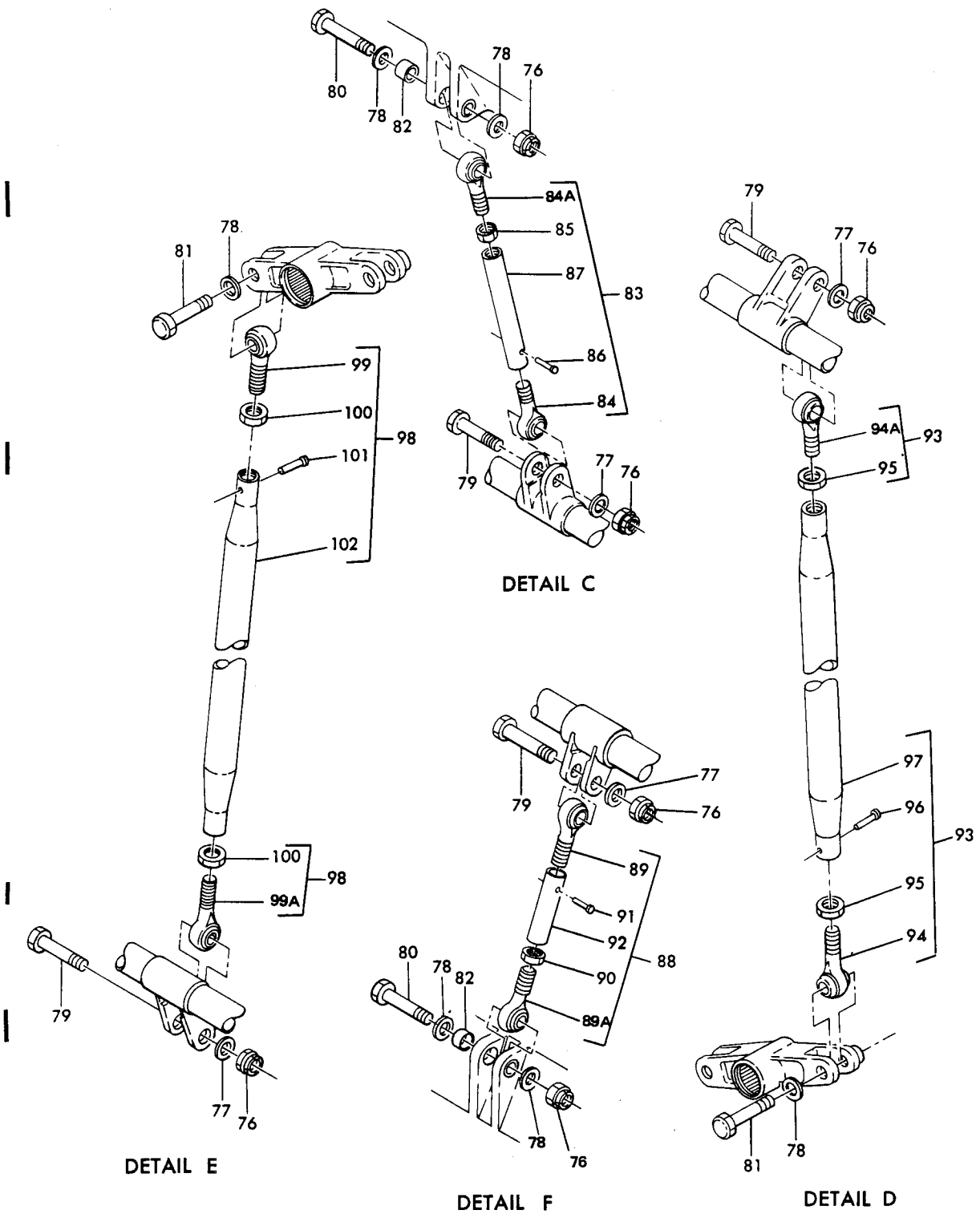
K54969



DETAIL A



DETAIL B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DETAIL C
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DETAIL E
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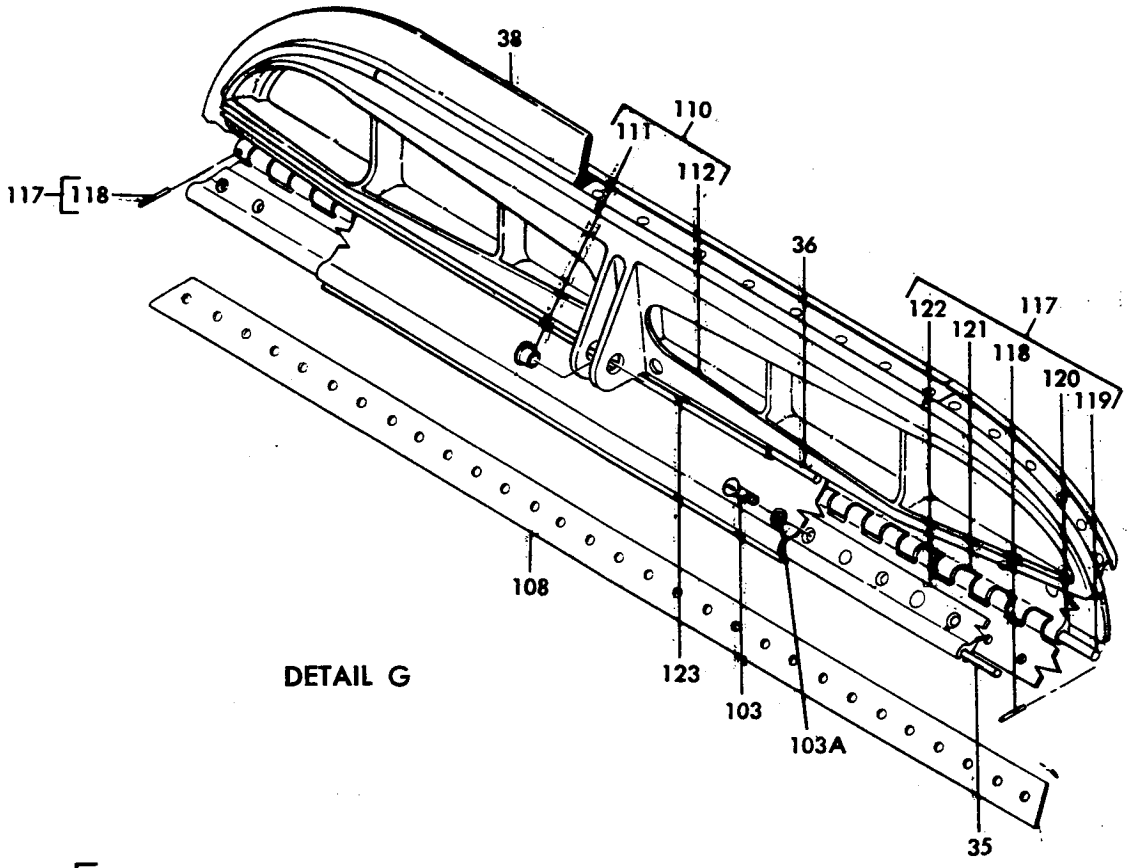
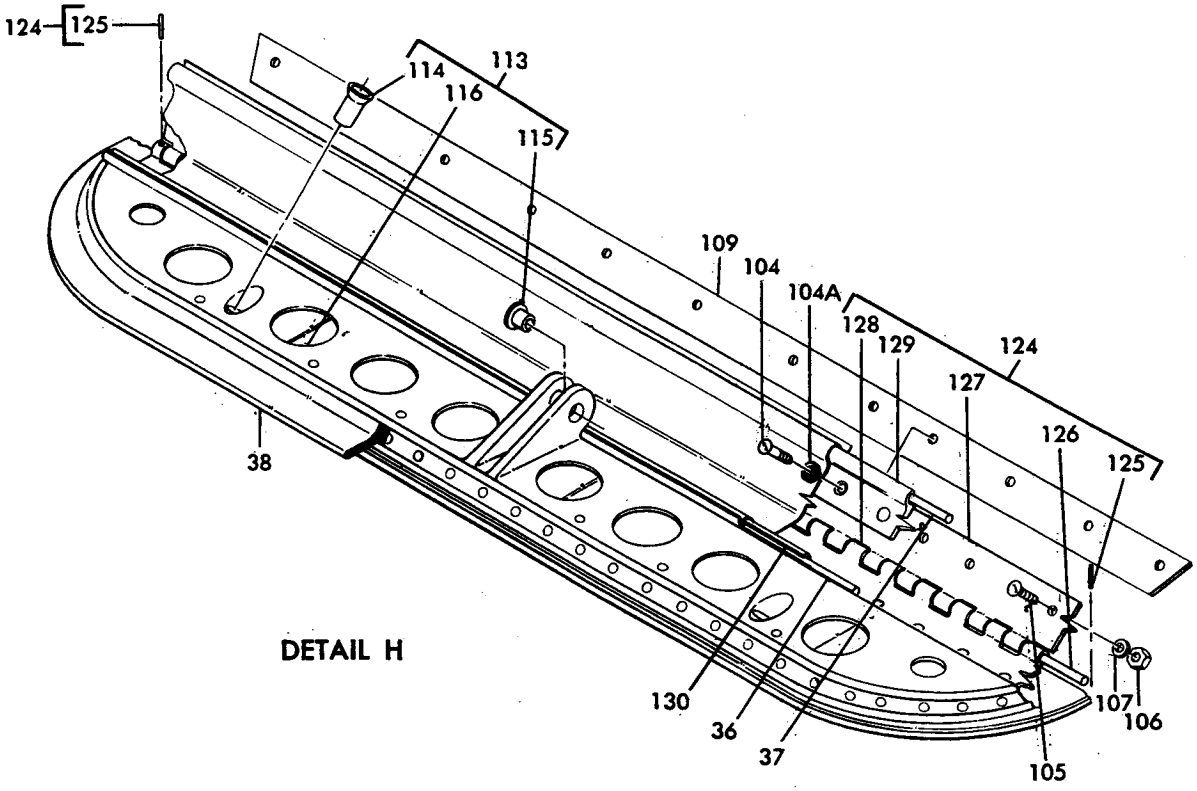
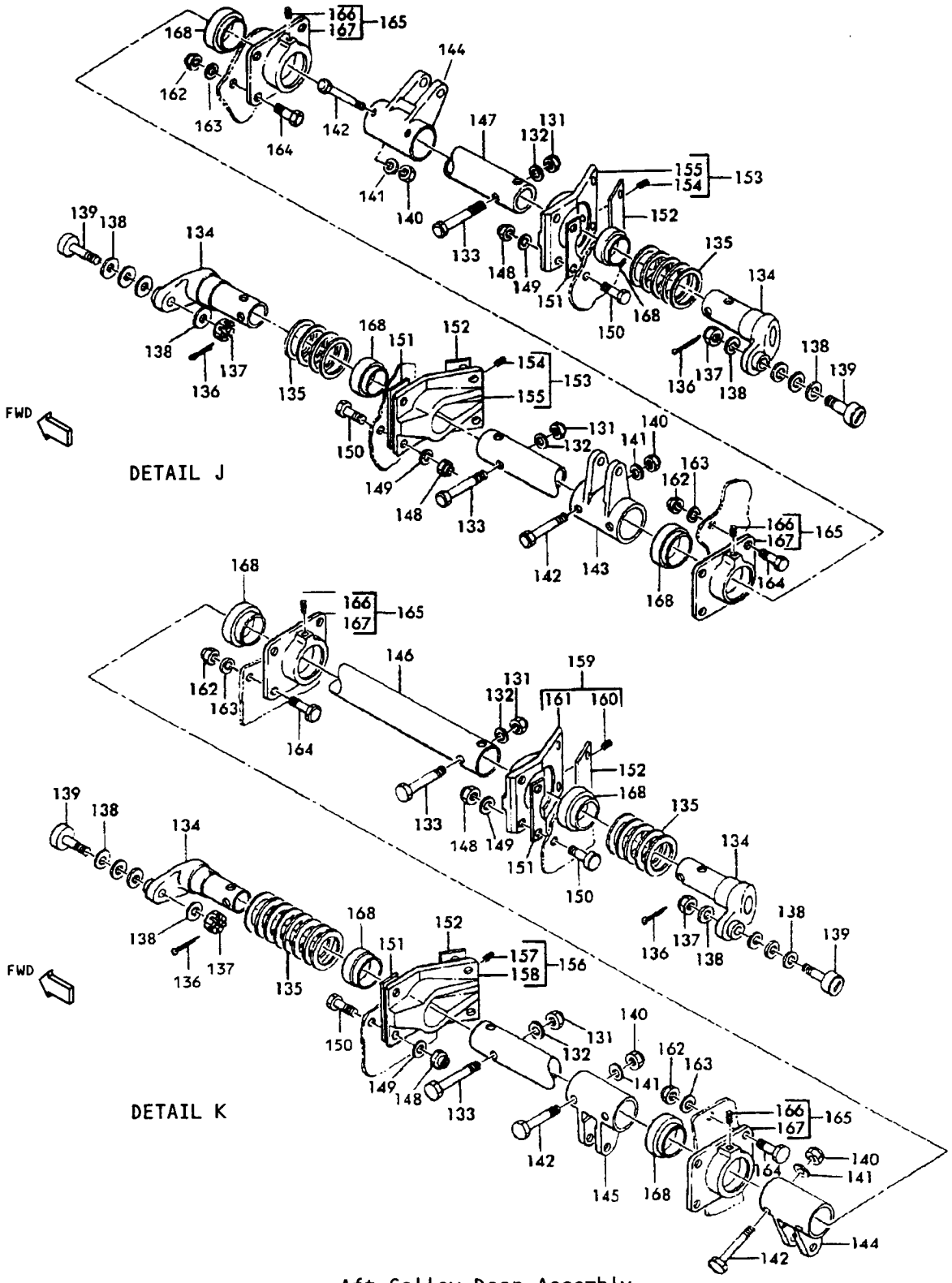
DETAIL D



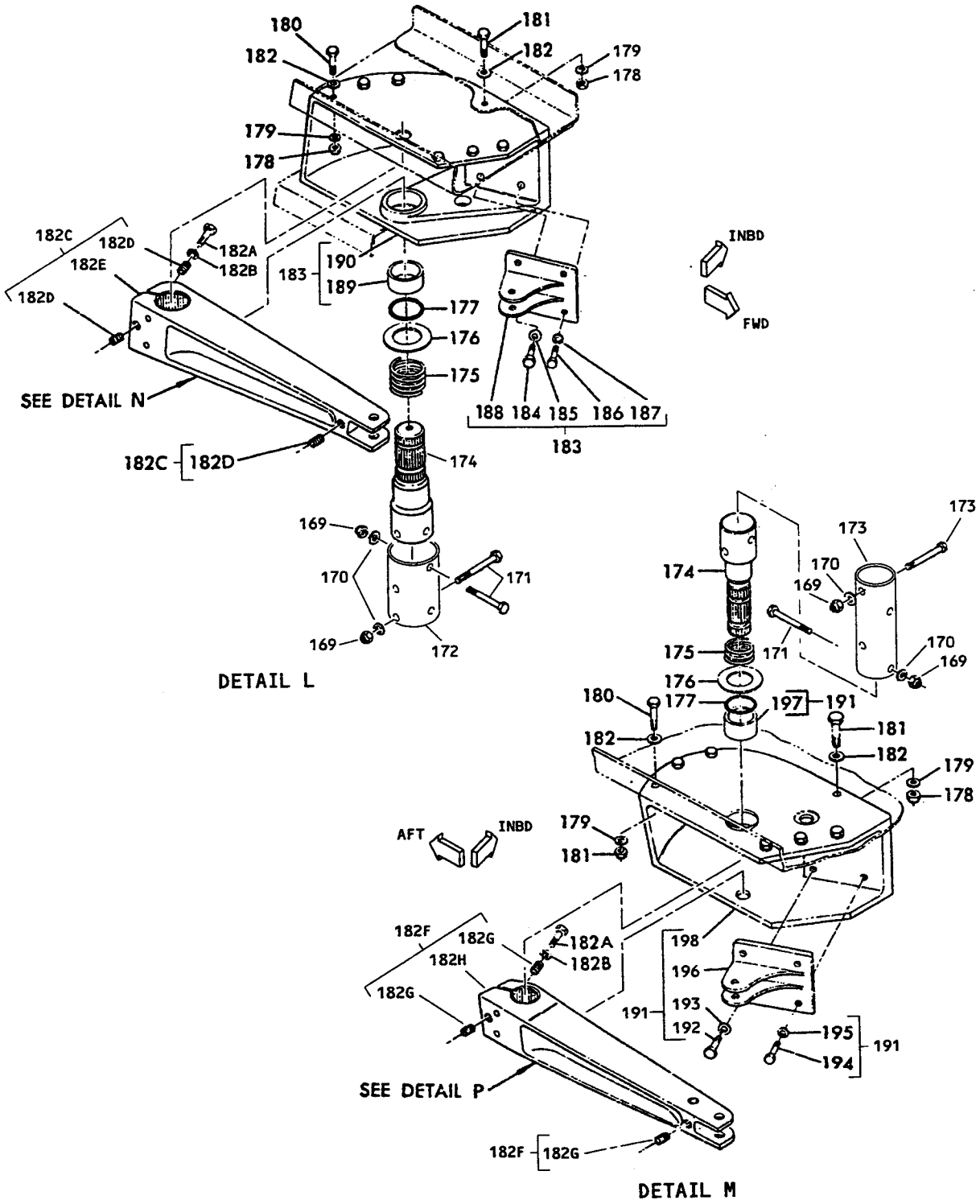
DETAIL G



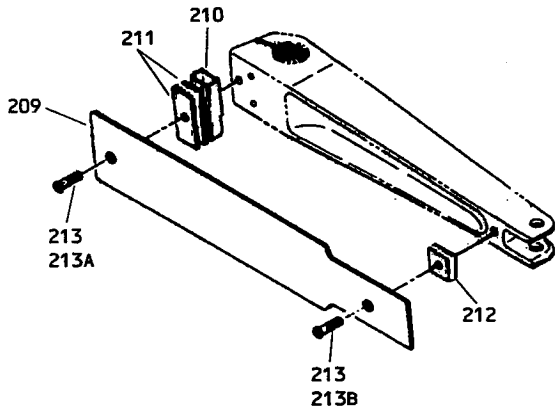
DETAIL H



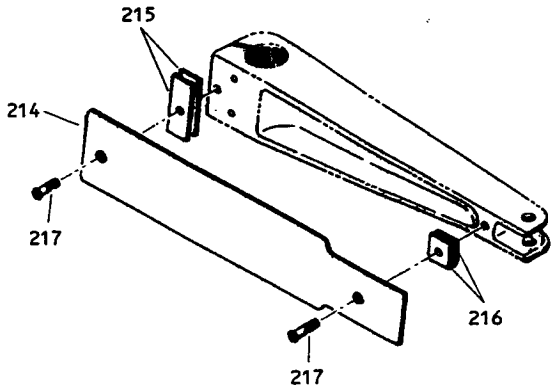
Aft Galley Door Assembly
Figure 1101 (Sheet 5)



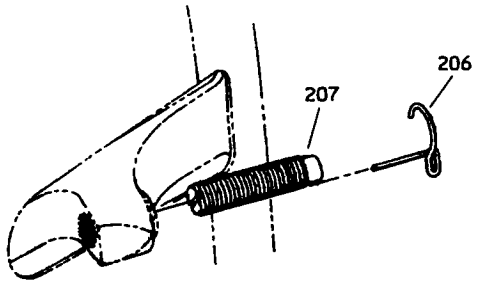
Aft Galley Door Assembly
Figure 1101 (Sheet 6)



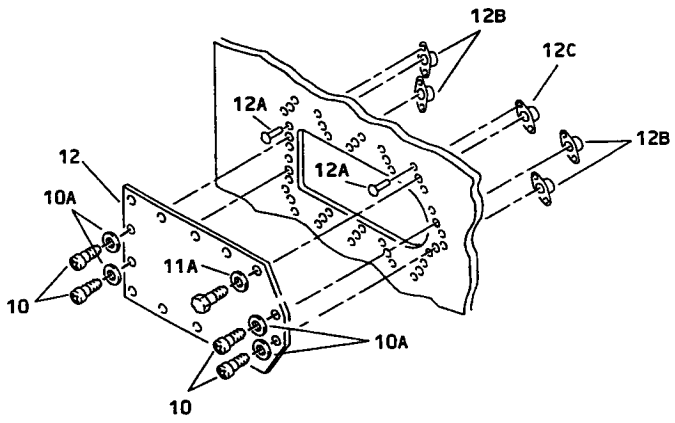
DETAIL N



DETAIL P



DETAIL Q



DETAIL R

Aft Galley Door Assembly
Figure 1101 (Sheet 7)

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
	65-45849-2		AFT GALLEY DOOR ASSY	A	RF
	65-45849-159		AFT GALLEY DOOR ASSY	B	RF
	65-45849-166		AFT GALLEY DOOR ASSY	C	RF
	65-45849-169		AFT GALLEY DOOR ASSY	D	RF
	65-45849-170		AFT GALLEY DOOR ASSY (REWORK FROM 65-45849-166)	E	RF
	65-45849-536		AFT GALLEY DOOR ASSY	F	RF
1	69-20350-5		. RETAINER ASSY, LINING (OPT TO 69-20350-9) *[1]*[2]	A	1
1	69-20350-7		. RETAINER ASSY, LINING *[1]*[2]	A	1
1	69-20350-9		. RETAINER (69-20350-5 OPT) *[1]*[2]	A	1
1	69-20350-11		DELETED		
1	69-20350-14		. RETAINER ASSY, LINING (REPLS 69-20350-11) *[1]*[2]	A	1
1	69-20350-16		. RETAINER ASSY *[1]*[2]	A	1
1	69-20350-16		. RETAINER ASSY *[1]	B-F	1
2	BACS21AP180R		. . STUD, OVAL HEAD (USED ON 69-20350-5,-7,-9		4
2	BACS21AP180RP		DELETED		
2	BACS21AP220RP		. . STUD (USED ON 69-20350-14,-16)		4
3	BACR12AG		. . RING, SPLIT RETAINING (USED ON 69-20350-5,-7,-9)		4
3	BACR12AG2C		. . RING, SPLIT RETAINING (USED ON 69-20350-14,-16)		4
4	69-20350-6		. . RETAINER (USED ON 69-20350-5)		1
4	69-20350-8		. . RETAINER (USED ON 69-20350-7)		1
4	69-20350-12		. . RETAINER (USED ON 69-20350-9,-14)		1
4	69-20350-18		. . RETAINER (USED ON 69-20350-16)		1
5	NAS1303-3		. BOLT		17
6	AN960PD10L		. WASHER		17
7	65-45849-505		. PLATE, COVER *[1]		1
7	65-45849-36		. PLATE, COVER *[1]*[2]	A	1
8	65-45849-506		. PLATE, COVER *[1]		1
8	65-45849-37		. PLATE, COVER *[1]*[2]	A	1
9	69-21619-3		. BRACKET ASSY, DOOR-MOUNTED EVACUATION SLIDE		1
10	NAS603-9P		. SCREW (REPLD BY NAS6603-2 AND BACW10BN3AP)		8
10	NAS6603-2		. BOLT		8
10A	BACW10BN3AP		. WASHER		8
11	NAS1303-9		. BOLT (REPLD BY NA6603-3 AND BACW10BN3AP)		20
11	NAS6603-3		. BOLT		20
11A	BACW10BN3AP		. WASHER		20

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
12	65-45849-24		. PLATE, COVER		2
12A	BACR15BA3D		. RIVET		56
12B	NAS680-A3		. NUTPLATE		20
12C	BACN10JZ3A2		. NUTPLATE		8
13	BACN10JC3		. NUT, SELF-LOCKING (NAS687A3 OPT) (REPLS NAS679A3W)		8
14	BACN10JC3		. NUT, SELF-LOCKING (REPLS NAS679A3W)		40
14	NAS679A3W		. NUTPLATE (OPT TO BACN10JC3)		40
15	NAS583-2		. BOLT, 100° COUNTERSUNK		8
16	NAS1103-2		. BOLT		40
17	AN960PD10		. WASHER		8
18	AN960PD10L		. WASHER		40
19	66-24154-1		. ANGLE, REINFORCING		1
20	66-24154-2		. ANGLE, REINFORCING		1
21	NAS1303-3		. BOLT		3
22	AN960PD10		. WASHER		3
23	65-2863-3		. WINDOW ASSY, OBSERVATION		1
24	BACN10JC04		. . NUT, SELF-LOCKING (REPLS NAS679A04W)		6
25	AN960-4		. . WASHER		12
26	NAS600-8P		. . SCREW (REPLS NAS600-8)		6
27	63-1478		. . CLIP		3
28	BACS40A12-12		. . SHIM, LAMINATED (REPLD BY BACS40R007B007F)		AR
28	BACS40R007B007F		. . SHIM, LAMINATED (REPLS BACS40A12-12)		AR
29	BACS40R007C007F		. . SHIM, LAMINATED (REPLS BACS40B12-12)		AR
29	BACS40B12-12		. . SHIM, LAMINATED (REPLD BY BACS40R007C007F)		AR
30	66-2646		. . SEAL, SPONGE RUBBER		1
31	69-1983		. . RETAINER		1
32	69-1083		. . PANE, INNER		1
33	69-1084		. . PANE, OUTER		1
34	66-1921-1		. . SEAL		1
35	65-45849-511		. ROD, NYLON		2
36	65-45849-513		. ROD, NYLON		4
37	65-45849-514		. ROD, NYLON		2
I 38	S14162-4		. SEAL (V75345)(BOEING 10-60476-4)		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
39	NAS1103-10		. BOLT (REPLD BY NAS6603-10)		2
39	NAS6603-10		. BOLT (REPLS NAS1103-10)		2
40	NAS1103-5		. BOLT (REPLD BY NAS6603-5)		1
40	NAS6603-5		. BOLT (REPLS NAS1103-5)		1
41	AN960PD10L		. WASHER		3
42	69-37495-2		. PLATE, SERRATED		1
43	65-45852-1		. FITTING ASSY, STOP *[2]	A	1
43	65-45852-501		. FITTING ASSY, STOP *[2]	A	1
43	65-45852-501		. FITTING ASSY, STOP	B-E	1
43	65-45852-7		. FITTING ASSY, STOP *[2] (OPT TO 65-45852-501)	F	1
43	65-45852-501		. FITTING ASSY, STOP *[2] (OPT TO 65-45852-7)	F	1
44	66-12688-5		. . BUSHING (REPLS 66-12688-1)		1
44	66-12688-1		. . BUSHING (REPLD BY 66-12688-5)		1
45	65-45852-3		. . FITTING, STOP (USED ON 65-45852-1)		1
45	65-45852-503		. . FITTING, STOP (USED ON 65-45852-501)		1
45	65-45852-9		. . FITTING, STOP (USED ON 65-45852-7)		1
46	65-49890-1		. FITTING ASSY, STOP		1
46	65-49890-1		. FITTING ASSY, STOP (OPT TO 65-49890-7)	F	1
46	65-49890-7		. FITTING ASSY, STOP (OPT TO 65-49890-1)	F	1
47	66-12688-1		. . BUSHING (USED ON 65-49890-1)		1
47	66-12688-1		. . BUSHING (USED ON 65-49890-7) (OPT TO 66-12688-11)		1
47	66-12688-11		. . BUSHING (USED ON 65-49890-7) (OPT TO 66-12688-1)		1
48	65-49890-3		. . FITTING, STOP (USED ON 65-49890-1)		1
48	65-49890-9		. . FITTING, STOP (USED ON 65-49890-7)		1
49	65-54481-1		. FITTING ASSY, STOP		2
50	66-12688-1		. . BUSHING		1
51	65-54481-3		. . FITTING, STOP		1
52	65-45851-7		. FITTING ASSY, STOP *[2]	A	1
52	65-45851-17		. FITTING ASSY, STOP *[2]	A	1
52	65-45851-17		. FITTING ASSY, STOP	B-F	1
53	66-12688-1		. . BUSHING		1
54	65-45851-15		. . FITTING, STOP (USED ON 65-45851-7)		1
54	65-45851-18		. . FITTING, STOP (USED ON 65-45851 -17)		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
55	65-52982-1		. FITTING ASSY, STOP *[2]	A	1
55	65-52982-5		. FITTING ASSY, STOP (OPT TO 65-52982A-1)(PREF) *[2]		1
55	65-52982-5		. FITTING ASSY, STOP	B-F	1
56	66-12688-1		. . BUSHING		1
57	65-52982-3		. . FITTING, STOP (USED ON 65-52982-1)		1
57	65-52982-7		. . FITTING, STOP (USED ON 65-52982-5)		1
58	65-52983-1		. FITTING ASSY, STOP *[2]	A	1
58	65-52983-5		. FITTING ASSY, STOP (OPT TO 65-52983A-1)(PREF) *[2]		1
58	65-52983-5		. FITTING ASSY, STOP	B-F	1
59	66-12688-1		. . BUSHING		1
60	65-52983-3		. . FITTING, STOP (USED ON 65-52983-1)		1
60	65-52983-7		. . FITTING, STOP (USED ON 65-52983-5)		1
61	65-52981-1		. FITTING ASSY, STOP *[2]	A	1
61	65-52981-5		. FITTING ASSY, STOP (OPT TO 65-52981A-1)(PREF) *[2]		1
61	65-52981-5		. FITTING ASSY, STOP	B-E	1
61	65-52981-9		. FITTING ASSY, STOP	F	1
62	66-12688-1		. . BUSHING		1
63	65-52981-3		. . FITTING, STOP (USED ON 65-52981-1)		1
63	65-52981-7		. . FITTING, STOP (USED ON 65-52981-5)		1
63	65-52981-11		. . FITTING, STOP (USED ON 65-52981-9)		1
64	65-52980-1		. FITTING ASSY, STOP *[2]	A	1
64	65-52980-5		. FITTING ASSY, STOP (OPT TO 65-52980-1)(PREF) *[2]	A	1
64	65-52980-5		. FITTING ASSY, STOP	B-F	1
65	66-12688-1		. . BUSHING		1
66	65-52980-3		. . FITTING, STOP (USED ON 65-52980-1)		1
66	65-52980-7		. . FITTING, STOP (USED ON 65-52980-5)		1
67	65-45851-5		. FITTING ASSY, STOP		1
68	65-45851-13		. . FITTING, STOP		1
69	66-12688-1		. . BUSHING		1
70	65-45851-3		. FITTING ASSY, STOP		1
71	65-45851-11		. . FITTING, STOP		1
72	66-12688-1		. . BUSHING		1
73	65-45851-1		. FITTING ASSY, STOP		1
74	65-45851-9		. . FITTING, STOP		1
75	66-12688-1		. . BUSHING		1
76	BACN10JC4		. NUT, SELF-LOCKING (REPLS NAS679A4W)		6
77	AN960PD416		. WASHER		4
78	NAS1197-416L		. WASHER		6
79	NAS1104-13		. BOLT		4

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
80	NAS1104-18		. BOLT		2
81	NAS1104-12		. BOLT		2
82	NAS74A4E006P		. BUSHING		2
83	69-18187-7		. ROD ASSY, DOOR GATE CONTROL *[2]	A	1
83	69-18187-22		. ROD ASSY, DOOR GATE CONTROL (OPT TO 69-18187-25)	CDEF	1
83	69-18187-25		. ROD ASSY, DOOR GATE CONTROL *[2]	A	1
83	69-18187-25		. ROD ASSY, DOOR GATE CONTROL	B	1
83	69-18187-25		. ROD ASSY, DOOR GATE CONTROL (PREF)	CDEF	1
84	BACB10A187M2L		. . BEARING, ROD END		1
84	BACB10A187L		. . BEARING, ROD END (OPT TO BACB10A187M2L)		1
84A	BACB10A187M2L		. . BEARING, ROD END (USED ON 69-18187-7)		1
84A	BACB10A187L		. . BEARING, ROD END (OPT TO BACB10A187M2L)(USED ON 69-18187-7)		1
84A	BACB10Y4		. . BEARING, ROD END (USED ON 69-18187-22,-25)		1
85	AN316-5R		. . NUT, CHECK		1
86	BACR15BB5D		. . RIVET (REPLS MS20470D5)		1
87	66-14618-6		. . ROD		1
88	69-18187-8		. ROD ASSY, DOOR GATE CONTROL *[2]	A	1
88	69-18187-23		. ROD ASSY, DOOR GATE CONTROL *[2]	A	1
88	69-18187-23		. ROD ASSY, DOOR GATE CONTROL	B-E	1
88	69-18187-23		. ROD ASSY, DOOR GATE CONTROL *[2] (REPLD BY 69-18187-26)	F	1
88	69-18187-26		. ROD ASSY, DOOR GATE CONTROL *[2] (REPLS 69-18187-23)	F	1
89	BACB10A187M2L		. . BEARING, ROD END		1
89	BACB10A187L		. . BEARING, ROD END (OPT TO BACB10A187M2L)		1
89A	BACB10A187M2L		. . BEARING, ROD END (USED ON 69-18187-8)		1
89A	BACB10A187L		. . BEARING, ROD END (OPT TO BACB10A187M2L)(USED ON 69-18187-8)		1
89A	BACB10Y4		. . BEARING, ROD END (USED ON 69-18187-23,-26)		1
90	AN316-5R		. . NUT, CHECK		1
91	BACR15BB5D		. . RIVET (REPLS MS20470D5)		1
92	66-14618-7		. . ROD		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-93	65-28925-45		. ROD ASSY, DOOR MECHANISM CONTROL *[2]	A	1
93	65-28925-85		. ROD ASSY, DOOR MECHANISM CONTROL *[2]	A	1
93	65-28925-85		. ROD ASSY, DOOR MECHANISM CONTROL	B-F	1
94	BACB10A187L		. . BEARING, ROD END (USED ON 65-28925-85)		1
94	BACB10A187L		. . BEARING, ROD END (USED ON 65-28925-45)(OPT TO 11-667A)		1
94	11-667A		. . BEARING, ROD END (V73134)(USED ON 65-28925-45)(OPT TO BACB10A187L)		1
94A	BACB10A187L		. . BEARING, ROD END (USED ON 65-28925-45)(OPT TO 11-667A)		1
94A	11-667A		. . BEARING, ROD END (V73134)(USED ON 65-28925-45)(OPT TO BACB10A187L)		1
94A	BACB10Y4		. . BEARING, ROD END (USED ON 65-28925-85)		1
95	AN316-5R		. . NUT, CHECK		2
96	BACR15BB3D		. . RIVET (REPLS MS20470D3)		1
97	65-28925-47		. . ROD		1
98	65-28925-46		. ROD ASSY, DOOR MECHANISM CONTROL *[2]	A	1
98	65-28925-86		. ROD ASSY, DOOR MECHANISM CONTROL *[2]	A	1
98	65-28925-86		. ROD ASSY, DOOR MECHANISM CONTROL	B-F	1
99	BACB10A187L		. . BEARING, ROD END (USED ON 65-28925-86)		1
99	BACB10A187L		. . BEARING, ROD END (USED ON 65-28925-46)(OPT TO 11-667A)		1
99	11-667A		. . BEARING, ROD END (V73134)(USED ON 65-28925-46)(OPT TO BACB10A187L)		1
99A	BACB10A187L		. . BEARING, ROD END (USED ON 65-28925-46)(OPT TO 11-667A)		1
99A	11-667A		. . BEARING, ROD END (V73134)(USED ON 65-28925-46)(OPT TO BACB10A187L)		1
99A	BACB10Y4		. . BEARING, ROD END (USED ON 65-28925-86)		1
100	AN316-5R		. . NUT, CHECK		2
101	BACR15BB3D		. . RIVET (REPLS MS20470D3)		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
102	65-28925-48		. . ROD		1
103	BACB30LU3-4		. BOLT (REPLS NAS333GPA5)(USED ON 65-45849-107)		9
103	NAS623-3-2		. SCREW (USED ON 65-45849-521, 65C34071-1)		9
103A	AN960PD10L		. WASHER (USED ON 65-45849-521, 65C34071-1)		9
104	NAS583-4		. BOLT (USED ON 65-45849-108)		9
104	NAS623-3-2		. SCREW (USED ON 65-45849-522-11)		9
104A	AN960PD10L		. WASHER (USED ON 65-45849-522-11, 65C34071-3)		9
105	BACB30EL3-4		. BOLT		4
106	BACN10JC3		. NUT (REPLS NAS679A3W)		4
107	AN960PD10L		. WASHER		4
108	65-45849-33		. FILLER	ABC	1
109	65-45849-43		. FILLER	ABC	1
110	65-55479-502		. GATE ASSY, UPPER *[2]	A	1
110	65-55479-502		. GATE ASSY, UPPER	B	1
110	65-55479-2		. GATE ASSY, UPPER *[2]	A	1
110	65-55479-8		. GATE ASSY, UPPER	CDEF	1
111	NAS77A4-23P		. . BUSHING		1
112	65-55479-504		. . GATE (USED ON 65-55479-502)		1
112	65-55479-4		. . GATE (USED ON 65-55479-2)		1
112	65-55479-10		. . GATE (USED ON 65-55479-8)		1
113	65-55478-501		. GATE ASSY, LOWER *[2]	A	1
113	65-55478-501		. GATE ASSY, LOWER	B	1
113	65-55478-1		. GATE ASSY, LOWER *[2]	A	1
113	65-55478-7		. GATE ASSY, LOWER	CDEF	1
114	69-41720-1		. . BUSHING		2
115	NAS77A4-23P		. . BUSHING		1
116	65-55478-503		. . GATE (USED ON 65-55478-501)		1
116	65-55478-3		. . GATE (USED ON 65-55478-1)		1
116	65-55478-9		. . GATE (USED ON 65-55478-7)		1
117	65-45849-107		. HINGE ASSY, UPPER *[2]	A	1
117	65-45849-521		. HINGE ASSY, UPPER (PRE SB 52-1097R1) *[2]	A	1
117	65-45849-521		. HINGE ASSY, UPPER (PRE SB 52-1097R1)	BC	1
117	65C34071-1		. HINGE ASSY, UPPER	DEF	1
117	65C34071-1		. HINGE ASSY, UPPER (POST SB 52-1097R1)	A-C	1
118	MS16562-1		. . PIN, SPRING (USED ON 65-45849-107 AND -521)		2

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
118	MS16562-209		. . PIN, SPRING (USED ON 65C34071-1)		2
119	MS20253-2-2870		. . PIN (USED ON 65-45849-107 AND -521)		1
119	MS20253P2-2870		. . PIN (USED ON 65C34071-1)		1
120	65-45849-71		. . HINGE HALF (USED ON 65-45849-107 AND -521)		1
120	65C34053-3		. . HINGE HALF (USED ON 65C34071-1)		1
121	65-45849-72		. . HINGE HALF (USED ON 65-45849-107)		1
121	65-52855-506		. . HINGE HALF (USED ON 65-45849-521)		1
121	65C34053-1		. . HINGE HALF (USED ON 65C34071-1)		1
122	65-45849-123		. . RETAINER, SEAL (USED ON 65-45849-107)		1
123	65-45849-124		. RETAINER, SEAL *[2]	A	1
123	65-45849-518		. RETAINER, SEAL *[2]	A	1
123	65-45849-518		. RETAINER, SEAL	B-F	1
124	65-45849-108		. HINGE ASSY, LOWER *[2]	A	1
124	65-45849-522		. HINGE ASSY, LOWER (PRE SB 52-1097R1) *[2]	A	1
124	65-45849-522		. HINGE ASSY, LOWER (PRE SB 52-1097R1)	BC	1
124	65C34071-3		. HINGE ASSY, LOWER	DEF	1
124	65C34071-3		. HINGE ASSY, LOWER (POST SB 52-1097R1)	A-C	1
125	MS16562-1		. . PIN, SPRING (USED ON 65-45849-108 AND -522)		2
125	MS16562-209		. . PIN, SPRING (USED ON 65C34071-3)		2
126	MS20253-2-2885		. . PIN (USED ON 65-45849-108 AND -522)		1
126	MS20253P2-2880		. . PIN (USED ON 65C34071-3)		1
127	65-45849-73		. . HINGE HALF (USED ON 65-45849-108)		1
127	65-52855-508		. . HINGE HALF (USED ON 65-45849-522)		1
127	65C34053-5		. . HINGE HALF (USED ON 65C34071-3)		1
128	65-45849-74		. . HINGE HALF (USED ON 65-45849-108 AND -522)		1
128	65C34053-7		. . HINGE HALF (USED ON 65C34071-3)		1
129	65-45849-125		. . RETAINER, SEAL (USED ON 65-45849-108)		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
130	65-45849-126		. RETAINER, SEAL	AB	1
130	65-45849-126		. RETAINER, SEAL *[2]	CDE	1
130	65-45849-535		. RETAINER, SEAL *[2]	CDE	1
130	65-45849-535		. RETAINER, SEAL	F	1
131	BACN10JC3		. NUT, SELF-LOCKING (REPS NAS679A3W)(PRE SB 52-1094, R1,R2,R3)	A	8
131	BACN10YR3CD		. NUT (POST SB 52-1094, R1,R2,R3) *[5]*[6]	A	8
131	BACN10YR3CD		. NUT	B-F	8
132	AN960-10L		. WASHER (PRE SB 52-1094, R1,R2,R3)	A	8
132	AN960C10L		. WASHER (POST SB 52-1094, R1,R2,R3) *[5]*[6]	A	8
132	AN960C10L		. WASHER *[5]*[6]	B-F	8
133	NAS1103-16		. BOLT (PRE SB 52-1094, R1,R2,R3)	A	8
133	BACB30NM3K17		. BOLT (POST SB 52-1094, R1,R2,R3) *[5]*[6]	A	8
133	BACB30NM3K17		. BOLT *[5]*[6]	B-F	8
134	69-37418-2		. CRANK *[2] (PRE SB 52-1094, R3)	A	4
134	69-37418-4		DELETED		
134	69-37418-501		. CRANK (POST SB 52-1094, R3) *[5]*[6]	A	4
134	69-37418-8		. CRANK *[2] (PRE SB 52-1094, R3)	A	4
134	69-37418-8		. CRANK	B-E	4
134	69-37418-501		. CRANK (OPT)	B-E	4
134	69-37418-11		. CRANK *[2]	F	4
134	69-37418-8		. CRANK *[2] (OPT TO 69-37418-501)	F	4
134	69-37418-501		. CRANK *[2] (OPT TO 69-37418-8) *[5]*[6]	F	4
135	66-15332-1		. SPACER (OPT TO 30-3004)		22
135	30-3004		. SPACER (OPT TO 66-15332-1)		22
136	MS24665-134		. PIN, COTTER (REPLS AN380-2-3)		4
137	BACN10JD105		. NUT, CASTELLATED (REPLS AN320-5)		4
138	AN960PD516L		. WASHER		16
139	BACB10AF5F9H		. BEARING (PREF)	A-E	4
139	BACB10BH59F7		. BEARING (OPT TO BACB10AF5F9H)	A-E	4
139	BACB10AF5F9H		. BEARING *[2] (OPT TO BACB10BH59F7)	F	4
139	BACB10BH59F7		. BEARING *[2] (OPT TO BACB10AF5F9H)	F	4
139	KRP141500VT5-9		. BEARING *[2] (V50632)	F	4
140	BACN10JC3		. NUT, SELF-LOCKING (REPLS NAS679A3W)(POST SB 52-1094, R1,R2,R3)	A	8
140	BACN10YR3CD		. NUT (POST SB 52-1094, R1,R2,R3) *[5]*[6]	A	8
140	BACN10YR3CD		. NUT	B-F	8
141	AN960-10L		. WASHER (POST SB 52-1094, R1,R2,R3)	A	8

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-141	AN960C10L		. WASHER (POST SB 52-1094, R1,R2,R3) *[5]*[6]	A	8
141	AN960C10L		. WASHER	B-F	8
142	NAS1103-18		. BOLT (POST SB 52-1094, R1,R2,R3)	A	8
142	BACB30NM3K19		. BOLT (POST SB 52-1094, R1,R2,R3) *[5]*[6]	A	8
142	BACB30NM3K19		. BOLT	B-F	8
143	66-14530-1		. CRANK, UPPER TORQUE TUBE LATCH (PRE SB 52-1094, R1,R2,R3) *[2]	A	1
143	66-14530-2		. CRANK, UPPER TORQUE TUBE LATCH (POST SB 52-1094, R2,R3)	AB	1
143	66-14530-3		. CRANK, UPPER TORQUE TUBE LATCH (POST SB 52-1094, R1)	A	1
143	66-14530-4		. CRANK, UPPER TORQUE TUBE LATCH *[2]	A	1
143	66-14530-2		. CRANK, UPPER TORQUE TUBE LATCH (REPLD BY 66-14530-3)	B	1
143	66-14530-3		. CRANK, UPPER TORQUE TUBE LATCH (REPLS 66-14530-2) *[5]	B	1
143	66-14530-3		. CRANK, UPPER TORQUE TUBE LATCH	C-F	1
144	66-14531-1		. CRANK, TORQUE TUBE LATCH (PRE SB 52-1094, R1,R2,R3)	A	2
144	66-14531-9		. CRANK, TORQUE TUBE LATCH (POST SB 52-1094, R1,R2,R3) *[5]*[6]	A	2
144	66-14531-9		. CRANK, TORQUE TUBE LATCH	B-F	2
145	66-14531-3		. CRANK, LOWER TORQUE TUBE LATCH (PRE SB 52-1094, R1,R2,R3)	A	1
145	66-14531-10		. CRANK, LOWER TORQUE TUBE LATCH *[6] (POST SB 52-1094, R1,R2,R3)	A	1
145	66-14531-10		. CRANK, LOWER TORQUE TUBE LATCH	B-F	1
146	60-4406-8		. TUBE, TORQUE (PRE SB 52-1094)	A	1
146	60-4406-14		. TUBE, TORQUE (POST SB 52-1094, R1,R2,R3) *[6]	A	1
146	60-4406-14		. TUBE, TORQUE	B-F	1
147	60-4406-7		. TUBE, TORQUE (PRE SB 52-1094)	A	1
147	60-4406-13		. TUBE, TORQUE (POST SB 52-1094, R1,R2,R3) *[5]	A	1
147	60-4406-13		. TUBE, TORQUE	B-F	1
148	BACN10JC3		. NUT, SELF-LOCKING (REPLS NAS679A3W)		16
149	AN960PD10		. WASHER		16
150	BACB30EL3-5		. BOLT		16
151	66-9330-1		. SHIM, LAMINATED		AR
152	66-9330-3		. SHIM, LAMINATED		AR

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
153	65-49560-1		. FITTING ASSY, SUPPORT	A-E	2
153	65-49560-1		. FITTING ASSY, SUPPORT *[2]	F	2
153	65-49560-9		. FITTING ASSY, SUPPORT *[2]	F	2
153	65-49560-15		. FITTING ASSY, SUPPORT *[2]	F	2
154	NAS516-1		. . FITTING, LUBRICATOR (USED ON 65-49560-1,-9)		1
154	NAS516-1A		. . FITTING, LUBRICATOR (USED ON 65-49560-15)		1
155	65-49560-2		. . FITTING, SUPPORT (USED ON 65-49560-1)		1
155	65-49560-10		. . FITTING, SUPPORT (USED ON 65-49560-9)		1
155	65-49560-16		. . FITTING, SUPPORT (USED ON 65-49560-15)		1
156	65-49560-4		. FITTING ASSY, SUPPORT	A-E	1
156	65-49560-4		. FITTING ASSY, SUPPORT *[2]	F	2
156	65-49560-11		. FITTING ASSY, SUPPORT *[2]	F	2
156	65-49560-17		. FITTING ASSY, SUPPORT *[2]	F	2
157	NAS516-1		. . FITTING, LUBRICATOR (USED ON 65-49560-4,-11)		1
157	NAS516-1A		. . FITTING, LUBRICATOR (USED ON 65-49560-17)		1
158	65-49560-6		. . FITTING, SUPPORT (USED ON 65-49560-4)		1
158	65-49560-12		. . FITTING, SUPPORT (USED ON 65-49560-11)		1
158	65-49560-18		. . FITTING, SUPPORT (USED ON 65-49560-17)		1
159	65-49560-5		. FITTING ASSY, SUPPORT	A-E	1
159	65-49560-5		. FITTING ASSY, SUPPORT *[2]	F	2
159	65-49560-13		. FITTING ASSY, SUPPORT *[2]	F	2
159	65-49560-19		. FITTING ASSY, SUPPORT *[2]	F	2
160	NAS516-1		. . FITTING, LUBRICATOR (USED ON 65-49560-5,-13)		1
160	NAS516-1A		. . FITTING, LUBRICATOR (USED ON 65-49560-19)		1
161	65-49560-7		. . FITTING, SUPPORT (USED ON 65-49560-5)		1
161	65-49560-14		. . FITTING, SUPPORT (USED ON 65-49560-13)		1
161	65-49560-20		. . FITTING, SUPPORT (USED ON 65-49560-19)		1

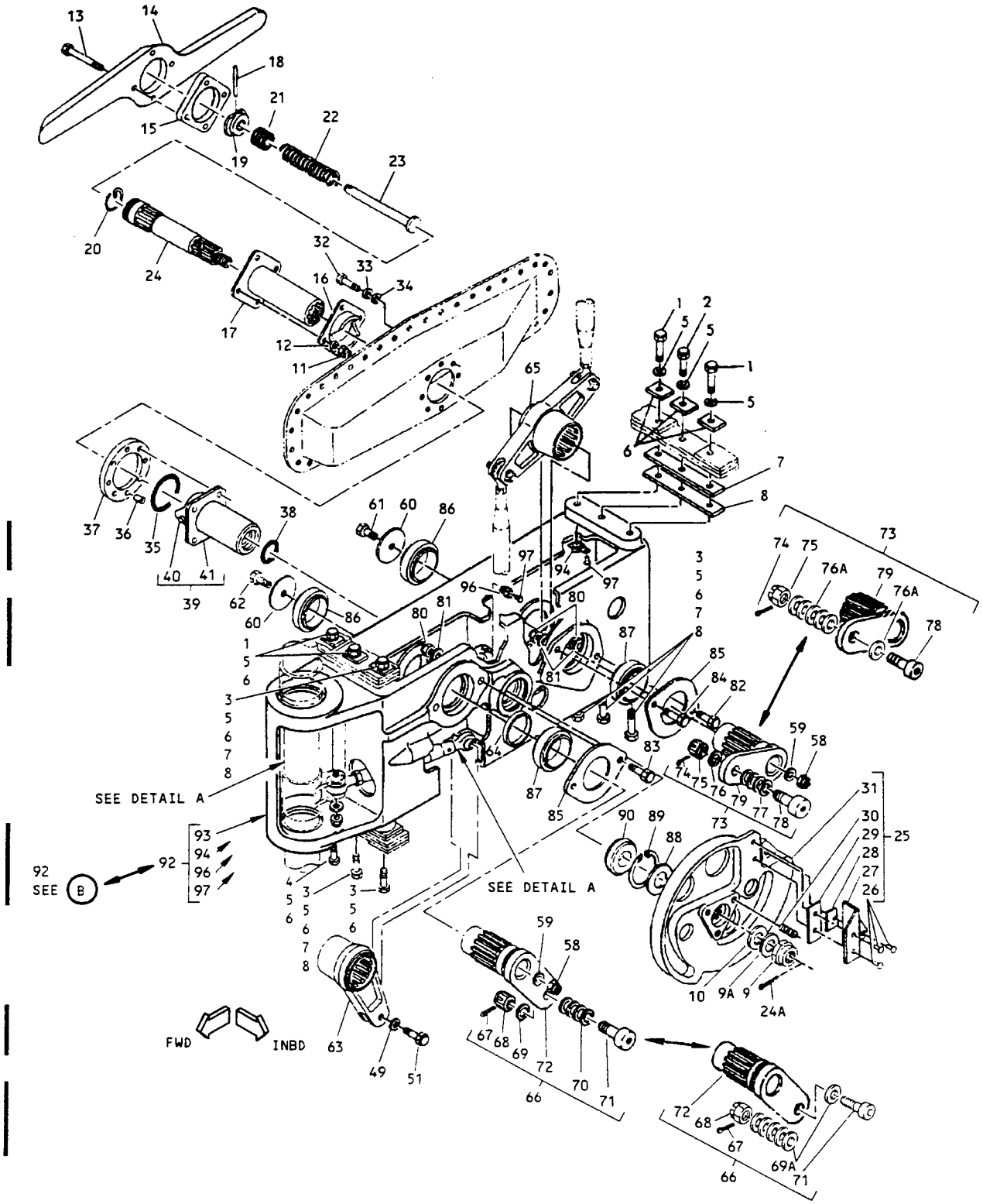
FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
162	BACN10JC3		. NUT, SELF-LOCKING (REPLS NAS679A3W)		16
163	AN960D10		. WASHER		16
164	NAS1103-3		. BOLT		16
165	65-2306-3		. HOUSING ASSY, BEARING *[2]	A	4
165	65-2306-3		. HOUSING ASSY, BEARING	B-F	4
165	65-2306		. HOUSING ASSY, BEARING *[2]	A	4
166	MS15001-4		. . FITTING, LUBE (USED ON 65-2306-3)		1
166	NAS516-1		. . FITTING, LUBE (USED ON 65-2306)		1
167	65-2306-4		. . HOUSING (USED ON 65-2306-3)		1
167	65-2306-1		. . HOUSING (USED ON 65-2306)		1
168	BACB10A397-GCM2		. BEARING		8
169	BACN10JC4		. NUT, SELF-LOCKING (REPLS NAS679A4W) (PRE SB 52-1094, R1,R2,R3)	A	8
169	BACN10YR4CD		. NUT *[7]	B-F	8
169	BACN10YR4CD		. NUT (POST SB 52-1094, R1,R2,R3) *[7]	A	8
170	AN960-416		. WASHER (PRE SB 52-1094, R1,R2,R3)	A	8
170	AN960C416L		. WASHER (POST SB 52-1094, R1,R2,R3) *[7]	A	8
170	AN960C416L		. WASHER *[7]	B-F	8
171	NAS1104-25		. BOLT (PRE SB 52-1094, R1,R2,R3)	A	8
171	BACB30NM4K26		. BOLT (POST SB 52-1094, R1,R2,R3) *[7]	A	8
171	BACB30NM4K26		. BOLT *[7]	B-F	8
172	60-4365-1		. SLEEVE (PRE SB 52-1094, R1,R2,R3) *[2]	A	1
172	60-4365		. SLEEVE (PRE SB 52-1094, R1,R2,R3) *[2]	A	1
172	60-4365-3		. SLEEVE (POST SB 52-1094, R1,R2,R3) *[7]	A	1
172	60-4365-3		. SLEEVE *[7]	B-F	1
173	66-24987-2		. SLEEVE (PRE SB 52-1094, R1,R2,R3) *[2]	A	1
173	66-24987-1		. SLEEVE (PRE SB 52-1094, R1,R2,R3) *[2]	A	1
173	66-24987-3		. SLEEVE (POST SB 52-1094, R1,R2,R3) *[7]	A	1
173	66-24987-3		. SLEEVE *[7]	B-F	1
174	66-14527-4		. PIN, HINGE LINK (PRE SB 52-1094, R1,R2,R3) *[2]	A	2
174	66-14527-2		. PIN, HINGE LINK (PRE SB 52-1094, R1,R2,R3) *[2]	A	2
174	66-14527-1		. PIN, HINGE LINK (PRE SB 52-1094, R1,R2,R3) *[2]	A	2
174	66-14527-6		. PIN, HINGE LINK (POST SB 52-1094, R1,R2,R3) *[7]	A	2
174	66-14527-6		. PIN, HINGE LINK *[7]	B-F	1
175	66-15645-1		. SPRING, COMPRESSION		2
176	AN960-1716		. WASHER, FLAT (PRE SB 52-1094)	A	2
176	AN960C1716L		. WASHER, FLAT (POST SB 52-1094) *[4]	A	2

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
176	AN960C1716L		. WASHER, FLAT	B-F	2
177	AN6227B19		. PACKING, O-RING (REPLS AN6227-19)		2
177	AN6227-19		. PACKING, O-RING (PRE SB 52-1094, R2, R3) (REPLD BY AN6227B19)		2
177	MS28775-214		. PACKING, O-RING (POST SB 52-1094, R2, R3) (REPLS AN6227B19) (REPLD BY M83461-1-214) *[4]		2
177	M83461-1-214		. PACKING, O-RING (REPLS MS28775-214)		2
178	BACN10JC3		. NUT, SELF-LOCKING (REPLS NAS679A3W)		28
179	AN960PD10		. WASHER		28
180	NAS1103-3		. BOLT		23
181	NAS1103-4		. BOLT		5
182	BACS11W-3		. SEAL, WASHER		28
182A	NAS1303-7		. BOLT		4
182B	AN960PD10L		. WASHER		4
182C	65-73978-7		. ARM ASSY, HINGE *[2] (PREF)	A	1
182C	65-73978-7		. ARM ASSY, HINGE	B-F	1
182C	65-73978-1		. ARM ASSY, HINGE *[2] (OPT)	A	1
182C	69-17952-17		. ARM ASSY, HINGE *[2] (OPT)	A	1
182D	MS21209F1-15		. . INSERT (REPLS BACS13W3CN3)		4
182E	65-73978-9		. . ARM (USED ON 65-73978-7)(OPT TO 65-73978-11)		1
182E	65-73978-11		. . ARM (USED ON 65-73978-7)(OPT TO 65-73978-9)		1
182E	65-73978-3		. . ARM (USED ON 65-73978-1)(OPT TO 65-73978-13)		1
182E	65-73978-13		. . ARM (USED ON 65-73978-1)(OPT TO 65-73978-3)		1
182E	69-17952-19		. . ARM (USED ON 69-17952-17)		1
182F	65-73978-2		. ARM ASSY, HINGE *[2] (OPT)	A	1
182F	65-73978-2		. ARM ASSY, HINGE	B-F	1
182F	65-73978-2		. ARM ASSY, HINGE (OPT)	C-E	1
182F	65-73978-2		. ARM ASSY, HINGE (OPT TO 65-73978-8)	F	1
182F	65-73978-8		. ARM ASSY, HINGE (OPT TO 65-73978-2)	F	1
182F	69-17952-18		. ARM ASSY, HINGE *[2] (OPT)	A	1
182F	69-17952-18		. ARM ASSY, HINGE (OPT)	C-E	1
182G	MS21209F1-15		. . INSERT (REPLS BACS13W3CN3)		4
182H	65-73978-4		. . ARM (USED ON 65-73978-2)(OPT TO 65-73978-14)		1
182H	65-73978-10		. . ARM (USED ON 65-73978-8)(OPT TO 65-73978-12)		1
182H	65-73978-12		. . ARM (USED ON 65-73978-8)(OPT TO 65-73978-10)		1

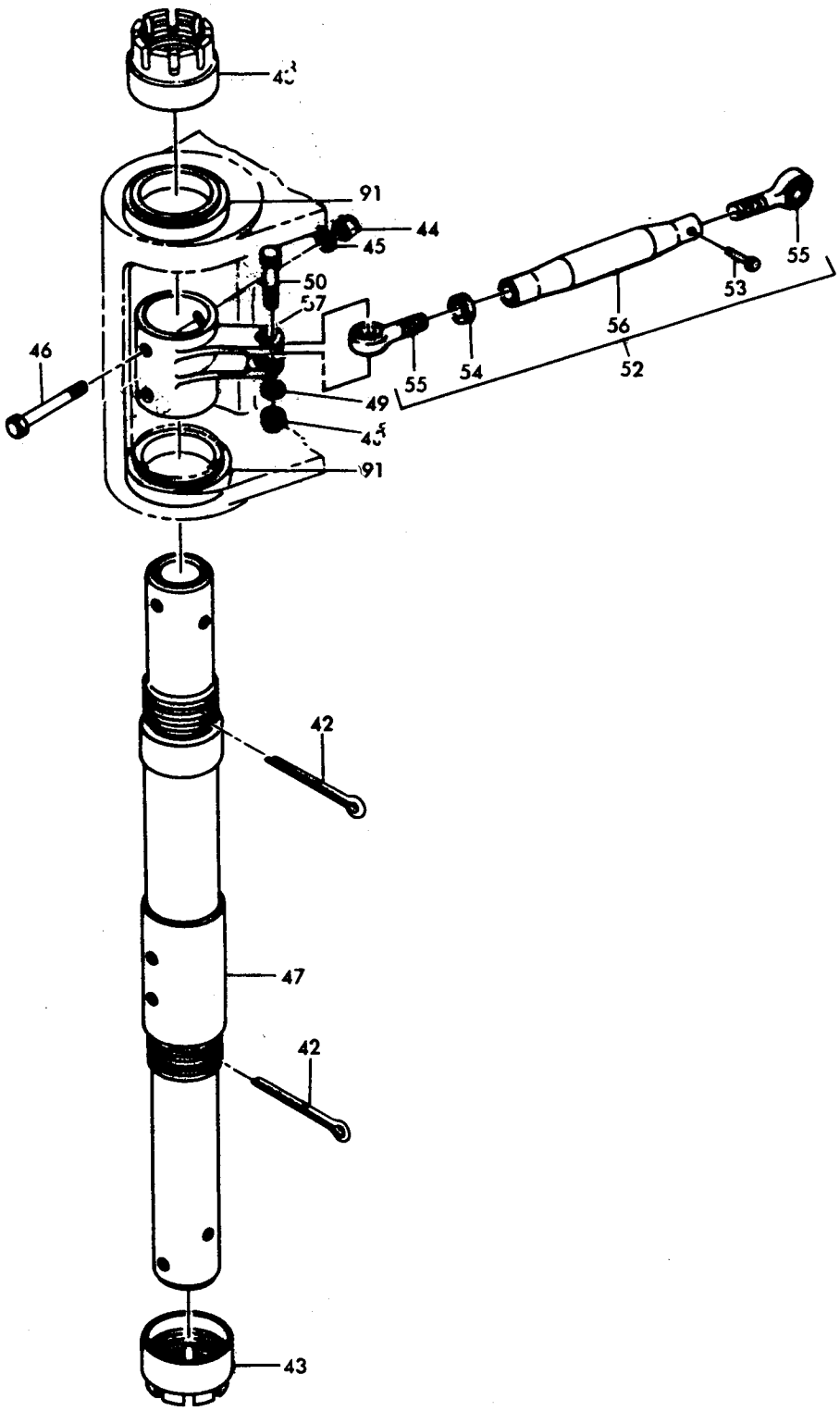
FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
182H	65-73978-14		. . ARM (USED ON 65-73978-2)(OPT TO 65-73978-4)		1
182H	69-17952-20		. . ARM (USED ON 69-17952-18)		1
183	65-55720-13		. SUPPORT ASSY, UPPER HINGE *[2]	A	1
183	65-55720-13		. SUPPORT ASSY, UPPER HINGE	B-F	1
183	65-55720-3		. SUPPORT ASSY, UPPER HINGE *[2]	A	1
184	NAS1304-10		. . BOLT		2
185	AN960PD416L		. . WASHER		AR
185	AN960PD416		. . WASHER		AR
186	NAS1303-10		. . BOLT		2
187	AN960PD10L		. . WASHER		2
188	69-70268-2		. . FITTING, ATTACH (USED ON 65-55720-13)		1
188	69-42114-2		. . FITTING, ATTACH (USED ON 65-55720-3)		1
189	NAS76A16-016P		. . BUSHING		1
190	65-55720-7		. . SUPPORT		1
191	65-55720-11		. SUPPORT ASSY, LOWER HINGE *[2]	A	1
191	65-55720-11		. SUPPORT ASSY, LOWER HINGE	B-F	1
191	65-55720-1		. SUPPORT ASSY, LOWER HINGE *[2]	A	1
192	NAS1304-10		. . BOLT		2
193	AN960PD416L		. . WASHER		AR
193	AN960PD416		. . WASHER		AR
194	NAS1303-10		. . BOLT		2
195	AN960PD10L		. . WASHER		2
196	69-70268-1		. . FITTING , ATTACH (USED ON 65-55720-11)		1
196	69-42114-1		. . FITTING, ATTACH (USED ON 65-55720-1)		1
197	NAS76A16-016P		. . BUSHING		1
198	65-55720-5		. . SUPPORT		1
199	*[3]		. HANDLE MECHANISM, AFT GALLEY DOOR (FIG. 1102)		1
200	*[3]		. DOOR STRUCTURE		1
			INSTALLATION ITEMS		
201	69-17789-2		FITTING, ROLLER		1
202	BACN10JC5		NUT, SELF-LOCKING (REPLS NAS679A5)		1
203	AN960-516L		WASHER		1
204	NAS43HT5-23		SPACER		1
205	66-10363		GUIDE, CENTERING		1
206	66-16691-1		SPRING, PIN RETAINER		14

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
207	66-12687-1		PIN, DOORSTOP		14
208	65-45849-62		PLUG		2
209	65-45849-104		COVER, HINGE		1
209	65-45849-534		COVER, HINGE		1
210	65-45849-102		BLOCK		1
211	BACS40R07E16		SHIM		2
212	BACS40R05E08		SHIM		2
213	BACB30LH3		BOLT (REPLS BACB30FL3) *[2]		2
213A	NAS514P1032-15		BOLT *[2]		1
213B	NAS514P1032-9		BOLT *[2]		1
214	65-45849-103		COVER, HINGE		1
214	65-45849-533		COVER, HINGE		1
215	BACS40R08E16		SHIM		2
216	BACS40R06E08		SHIM		2
217	BACB30LH3		BOLT (REPLS BACB30FL3) *[2]		2
217	NAS514P1032-9		BOLT *[2]		1
			---------*---------		

*[1] INSTALL WITH BACR15BB3D RIVETS
*[2] LIMITED USAGE
*[3] NO BOEING PART NUMBER ASSIGNED
*[4] NOT USED ON ALL POST SERVICE BULLETIN CONFIGURATIONS
*[5] UPPER LATCH ASSY KIT 65C33403-36 CONSISTS OF: TORQUE TUBE 60-4406-13; CRANKS 66-14530-2, 66-14531-9, 69-37418-501; WASHERS AN960C10L; BOLTS BACB30NM3K17, BACB30NM3K19; NUTS BACN10YR3CD.
*[6] LOWER LATCH ASSY KIT 65C33403-40 CONSISTS OF: TORQUE TUBE 60-4406-14; CRANKS 66-14531-10, 66-14531-9 AND 69-37418-501; WASHERS AN960C10L; BOLTS BACB30NM3K17, BACB30NM3K19; NUTS BACN10YR3CD.
*[7] TORQUE TUBE ASSEMBLY KIT 65C33403-10 CONSISTS OF: SLEEVE 60-4365-3 (FIG. 1101); HINGE LINK PIN 66-14527-6 (FIG. 1101); SLEEVE 66-24987-3 (FIG. 1101); CRANK 69-17330-4 (FIG. 1102); TORQUE TUBE 90-6753-18 (FIG. 1102); WASHERS AN960C416L (FIG. 1101), AN960C516L (FIG. 1102); BALL BEARING BACB10FR25 (FIG. 1102); BOLTS BACB30NM4K26 (FIG. 1101), BACB30NM5K29 (FIG. 1102); NUTS BACN10YR4CD (FIG. 1101), BACN10YR5CD (FIG. 1102).

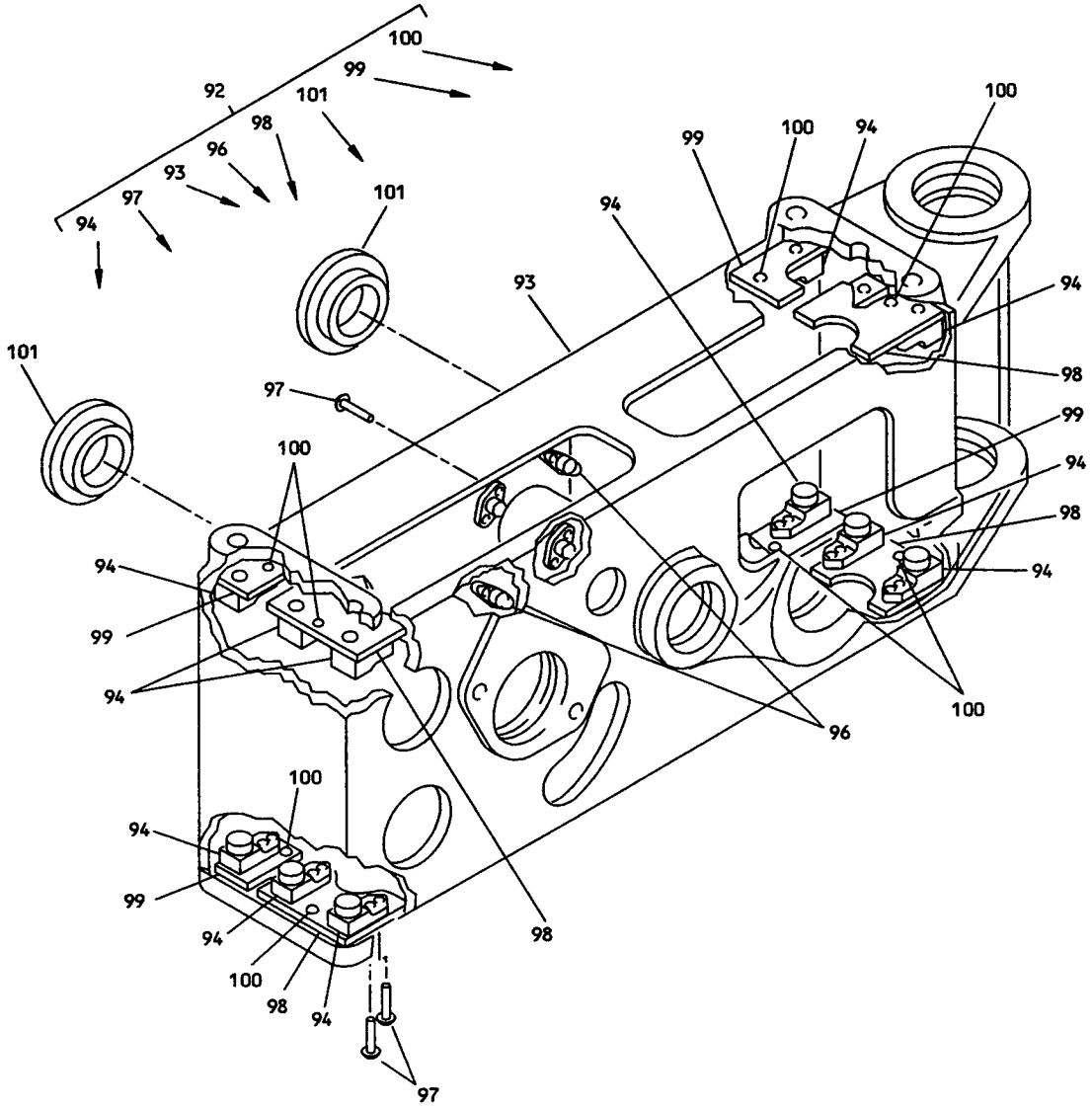


Aft Galley Door Handle Mechanism
Figure 1102 (Sheet 1)



DETAIL A

Aft Galley Door Handle Mechanism
Figure 1102 (Sheet 2)



(B)

65-1642-42,-46

Aft Galley 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 GALLEY DOOR HANDLE MECHANISM		REF
1	NAS1304-18		. BOLT		4
2	NAS1304-17		. BOLT		1
3	NAS1304-19		. BOLT		6
4	NAS1304-20		. BOLT		1
5	AN960PD416		. WASHER		12
6	65-45849-138		. FILLER, RADIUS		12
7	65-45849-81		. FILLER		4
8	BACS40R07E42		. SHIM, LAMINATED		AR
9	BACN10JC6		. NUT, SELF-LOCKING (USED ON 60-4455) (REPLS NAS679A6)		1
9	BACN10JD-6		. NUT (USED ON 60-4455-1, -2, -3)		1
9A	AN960-616		. WASHER (USED ON 60-4455-1, -2, -3)		AR
10	63-9386		. WASHER		1
11	BACN10JC3		. NUT, SELF-LOCKING (REPLS NAS679A3W)		4
12	AN960PD10L		. WASHER		4
13	NAS1503-11		DELETED		
13	BACB30LH-3-11		DELETED		
13	BACB30LH3-13		. BOLT (PREF)		4
13	NAS1503-13		. BOLT (OPT TO BACB30LH3-13)		4
14	90-7879-1		. HANDLE, OUTER (USED ON 65-45849-2, -159, -166, -169, -170)		1
14	90-7879-1		. HANDLE, OUTER *[2] (USED ON 65-45849-536)		1
14	90-7879-6		. HANDLE, OUTER *[2] (USED ON 65-45849-536)		1
14	90-7879-10		. HANDLE, OUTER *[2] (USED ON 65-45849-536)		1
15	66-24986-1		. SPACER		1
16	90-7811		. CAM		1
17	90-7821		. SLEEVE		1
18	MS39086-111		. PIN, SPRING (USED WITH 30-3013-1)		1
18	MS39086-13		. PIN, SPRING (USED WITH 30-3013-2)		1
19	30-3019		. WASHER (USED WITH 30-3013-1) (USED ON 65-45849-2) *[1]		1
19	30-3019-1		. WASHER (USED WITH 30-3013-2) (USED ON 65-45849-2) *[1]		1
19	30-3019-1		. WASHER (USED WITH 30-3013-2)(USED ON 65-45849-159,-166,-169,-170,-536)		1
20	AN996-14		. RING, LOCK		1
21	30-3010		. NUT		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1102-					
22	63-2848		. SPRING, COMPRESSION		1
23	30-3013-1		. PIN *[1] (USED ON 65-45849-2)		1
23	30-3013-2		. PIN *[1] (USED ON 65-45849-2)		1
23	30-3013-2		. PIN (USED ON 65-45849-159, -166, -169, -170, -536)		1
24	60-4455		. SHAFT *[1] (USED ON 65-45849-2)		1
24	60-4455-1		. SHAFT *[1] (USED ON 65-45849-2, -536) (OPT TO 60-4455-2)		1
24	60-4455-2		. SHAFT *[1] (USED ON 65-45849-2, -536) (OPT TO 60-4455-1)		1
24	60-4455-2		. SHAFT (USED ON 65-45849-159,-166, -169,-170)(OPT TO 60-4455-1)		1
24	60-4455-1		. SHAFT (USED ON 65-45849-159,-166, -169,-170)(OPT TO 60-4455-2)		1
24	60-4455-3		. SHAFT *[1] (USED ON 65-45849-536)		1
24A	MS24665-283		. PIN, COTTER (USED ON 60-4455-1, -2,-3)		1
25	69-34971-1		. CAM ASSY, CONTROL *[1] (USED ON 65-45849-2)		1
25	69-34971-4		. CAM ASSY, CONTROL (OPT TO 69-34976-1)(PREF) *[1] (USED ON 65-45849-2)		1
25	69-34971-4		. CAM ASSY, CONTROL (USED ON 65-45849-159,-166,-169,-170)		1
25	69-34971-4		. CAM ASSY, CONTROL *[1] (USED ON 65-45849-536)		1
25	69-34971-6		. CAM ASSY, CONTROL *[1] (USED ON 65-45849-536)		1
25	69-34971-8		. CAM ASSY, CONTROL *[1] (USED ON 65-45849-536)		1
26	BACR15BA5D		. . RIVET (REPLS MS20426D5)		3
27	69-34971-2		. . GUIDE		1
28	BACS40B11-11		. . SHIM, LAMINATED		AR
29	BACS40B12-26		. . SHIM, LAMINATED		AR
30	MS21209F5-15		. . SLEEVE, HELI-COIL		3
31	69-34971-3		. . CAM, CONTROL (USED ON 69-34971-1)		1
31	69-34971-5		. . CAM, CONTROL (USED ON 69-34971-4)		1
31	69-34971-7		. . CAM, CONTROL (USED ON 69-34971-6)		1
31	69-44065-8		. . CAM, CONTROL (USED ON 69-34971-8)		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1102-					
32	NAS1103-11		. BOLT		4
33	AN960PD10L		. WASHER		4
34	BACS11W3		. WASHER, SEAL		4
35	AN6227B28		. PACKING, O-RING (REPLS AN6227-28)		1
36	BACR15CE5D		. RIVET, SHEAR HEAD		4
37	66-14542-1		. PLATE, SEAL		1
38	AN6227B17		. PACKING, O-RING (REPLS AN6227-17)		1
39	69-61511-1		. HOUSING ASSY (USED ON 65-45849-159,-166,-169,-170,-536)		1
39	69-61511-1		. HOUSING ASSY (PREF) *[1] (USED ON 65-45849-2)		1
39	90-7820		. HOUSING ASSY *[1] (USED ON 65-45849-2)		1
40	NAS516-1		. . FITTING, LUBRICATOR		1
41	69-61511-2		. . HOUSING, FITTING (USED ON 69-61511-1)		1
41	90-7820-1		. . HOUSING, FITTING (USED ON 90-7820)		1
42	MS24665-360		. PIN, COTTER		2
43	60-4405		. NUT, SPECIAL *[1] (USED ON 65-45849-2)		2
43	60-4405-1		. NUT, SPECIAL *[1] (USED ON 65-45849-2)		2
43	60-4405-1		. NUT, SPECIAL (USED ON 65-45849-159, -166,-169,-170,-536)		2
44	BACN10JC5		. NUT, SELF-LOCKING (REPLS NAS679A5)(USED ON 65-45849-2) (PRE SB 52-1094)		2
44	BACN10YR5CD		. NUT (POST SB 52-1094, R3)(USED ON 65-45849-2) *[16]		2
44	BACN10YR5CD		. NUT (USED ON 65-45849-159,-166,-169, -170,-536) *[16]		2
45	AN960PD516L		. WASHER) (USED ON 65-45849-2) (PRE SB 52-1094)		2
45	AN960C516L		. WASHER (USED ON 65-45849-2)(POST SB 52-1094, R3) *[16]		2
45	AN960C516L		. WASHER (USED ON 65-45849-159,-166, -169, -170,-536) *[16]		2
46	NAS1105-29		. BOLT (USED ON 65-45849-2) (PRE SB 52-1094)		2
46	BACB30NM5K29		. BOLT (USED ON 65-45849-2)(POST SB 52-1094, R3) *[16]		2

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1102-46	BACB30NM5K29		. BOLT (USED ON 65-45849-159,-166, -169, -170,-536)(OPT TO NAS6805A29) *[16]		2
46	NAS6805A29		. BOLT (USED ON 65-45849-159,-166,-169, -170,-536)(OPT TO BACB30NM5K29)		2
47	90-6753-11		. TUBE, HINGE TORQUE *[1] (USED ON 65-45849-2)(PRE SB 52-1094, R3)		1
47	90-6753-6		. TUBE, HINGE TORQUE *[1] (USED ON 65-45849-2)(PRE SB 52-1094, R3)		1
47	90-6753-18		. TUBE, HINGE TORQUE (USED ON 65-45849-2)(POST SB 52-1094, R3) *[16]		1
47	90-6753-18		. TUBE, HINGE TORQUE (USED ON 65-45849-159,-166,-169, -170,-536)*[16]		1
48	BACN10JC5		. NUT, SELF-LOCKING (REPLS NAS679A5)		1
49	AN960PD516L		. WASHER		2
50	NAS1105-16		. BOLT		1
51	NAS1105-12		DELETED		1
51	BACB30NF5-15		. BOLT		1
52	69-39176-1		. ROD ASSY, PUSH		1
53	MS20615		. . RIVET		1
54	AN316-6R		. . NUT, CHECK		1
55	77253		. . BEARING, ROD END, V09455 (BOEING 10-60779-112)		2
55	TEM5C		. . BEARING, ROD END, V14125 (BOEING 10-60779-112)		2
55	REM10ATC12-2		. . BEARING, ROD END, V21335 (BOEING 10-60779-112)		2
55	DREM5-019		. . BEARING, ROD END, V81376 (BOEING 10-60779-112)		2
56	69-39176-2		. . ROD		1
57	69-17330-2		. CRANK (USED ON 65-45849-2)(PRE SB 52-1094, R3)		1
57	69-17330-4		. CRANK (USED ON 65-45849-2) (POST SB 52-1094, R3) *[16]		1
57	69-17330-4		. CRANK (USED ON 65-45849-159,-166, -169,-170,-536) *[16]		1
58	BACN10JC4		. NUT, SELF-LOCKING (REPLS NAS679A4W)		2
59	AN960PD416L		. WASHER		2
60	63-1692		. WASHER		2
61	NAS1104-5		. BOLT		1
62	NAS1104-6		. BOLT		1
63	65-54024-6		. CRANK ASSY (65-1933-4 OPT)(USED ON 65-45849-2) *[1]		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1102-					
63	65-1933-4		. CRANK ASSY (OPT TO 65-54024-6) (USED ON 65-45849-2) *[1]		1
63	65-1933-7		. CRANK ASSY (65-1933-12 OPT) (USED ON 65-45849-2) *[1]		1
63	65-1933-12		. CRANK ASSY (OPT TO 65-1933-7) (USED ON 65-45849-2) *[1]		1
63	65-1933-507		. CRANK ASSY *[1] (USED ON 65-45849-2, -536)		1
63	65-1933-507		. CRANK ASSY (USED ON 65-45849-159, -66,-169,-170)		1
63	65-1933-17		. CRANK ASSY (USED ON 65-45849-536)		1
63	65-1933-19		. CRANK ASSY (USED ON 65-45849-536) (OPT TO 65-1933-21)		1
63	65-1933-21		. CRANK ASSY (USED ON 65-45849-536) (OPT TO 65-1933-19)		1
64	65-8795-801		. SPACER		1
65	65-54013		. CRANK ASSY *[1] (65-54013-503 OPT) (USED ON 65-45849-2)		1
65	65-54013-503		. CRANK ASSY *[1] (OPT TO 65-54013) (USED ON 65-45849-2)		1
65	65-54013-503		. CRANK ASSY (USED ON 65-45849-159, -66,-169,-170,-536)		1
66	69-38733-1		. CRANK ASSY, CAM FOLLOWER (90-815-1 OPT) *[1] (USED ON 65-5849-2)		1
66	90-7815-1		. CRANK ASSY, CAM FOLLOWER (OPT TO 69-38733-1) *[1] (USED ON 65-5849-2)		1
66	90-7815-17		. CRANK ASSY, CAM FOLLOWER (90-815-15 OPT) *[1] (USED ON 65-5849-2,-536)		1
66	90-7815-15		. CRANK ASSY, CAM FOLLOWER (USED ON 65-45849-2,-536)(OPT TO 90-7815-17) *[1]		1
66	90-7815-15		. CRANK ASSY, CAM FOLLOWER (USED ON 65-45849-159,-166,-169,-170)(OPT TO 90-7815-17)		1
66	90-7815-17		. CRANK ASSY, CAM FOLLOWER (USED ON 65-45849-159,-166,-169,-170) (90-7815-15 OPT)		1
66	90-7815-23		. CRANK ASSY, CAM FOLLOWER *[1] (USED ON 65-45849-536) (OPT TO 90-7815-25)		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1102-66	90-7815-25		. CRANK ASSY, CAM FOLLOWER *[1] (USED ON 65-45849-536) (OPT TO 90-7815-23)		1
67	MS24665-283		. . PIN, COTTER *[2] *[4] *[5] *[11] *[12]		1
67	AN380-3-3		. . PIN, COTTER *[3]		1
68	BACN10JD6		. . NUT, CASTELLATED (REPLS AN310-6) *[2A]		1
68	BACN10JD106		. . NUT, CASTELLATED (REPLS AN320-6) *[2B] *[3]		1
68	BACN10JD106		. . NUT, CASTELLATED *[4] *[5]		1
68	BACN10JD106ASU		. . NUT, CASTELLATED *[11] *[12]		1
69	AN960PD616		. . WASHER *[2]		1
69A	AN960-616L		. . WASHER *[3]		*[13]
69A	AN960XC616L		. . WASHER *[4] *[5]		*[13]
69A	NAS1149C0632B		. . WASHER *[11] *[12]		*[13]
70	AN960PD616L		. . WASHER (USED WITH BACB10BH60F9) *[2]		4
70	AN960PD616L		. . WASHER (USED WITH BACB10BH6OF8) *[2]		2
71	BACB10BH60F9		. . BEARING UNIT, NEEDLE (BACB10BH6OF8 OPT) *[2]		1
71	BACB10BH60F8		. . BEARING UNIT, NEEDLE (OPT TO BACB10BH60F9) *[2]		1
71	BACB10BH60CF6		. . BEARING UNIT, NEEDLE (BACB10AF6F3H, BACB10AF6F6H OPT) *[3]		1
71	BACB10AF6F3H		. . BEARING UNIT, NEEDLE (OPT TO BACB10BH60CF6) *[3]		1
71	BACB10AF6F6H		. . BEARING UNIT, NEEDLE (OPT TO BACB10BH60CF6) *[3]		1
71	BACB10FK6F6HS		. . BEARING UNIT, NEEDLE *[4] *[5]		1
71	KRP141500VT6-6		. . BEARING UNIT, NEEDLE, V50632 *[11] *[12]		1
72	69-38733-2		. . ARM, CRANK *[2]		1
72	90-7815-3		. . ARM, CRANK *[3]		1
72	90-7815-21		. . ARM, CRANK *[4]		1
72	90-7815-19		. . ARM, CRANK *[5]		1
72	90-7815-27		. . ARM, CRANK *[11]		1
72	90-7815-29		. . ARM, CRANK *[12]		1
73	69-38732-1		. CRANK ASSY, CAM FOLLOWER *[1] (90-7815-4 OPT)(USED ON 65-45849-2)		1
73	90-7815-4		. CRANK ASSY, CAM FOLLOWER *[1] (OPT TO 69-38732-1)(USED ON 65-45849-2)		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1102-					
73	90-7815-18		. CRANK ASSY, CAM FOLLOWER *[1] (90-7815-16 OPT)(USED ON 65-45849-2, -536)		1
73	90-7815-16		. CRANK ASSY, CAM FOLLOWER *[1] (OPT TO 90-7815-18)(USED ON 65-45839-2,-536)		1
73	90-7815-16		. CRANK ASSY, CAM FOLLOWER (USED ON 65-45849-159,-166,-169,-170) (90-7815-18 OPT)		1
73	90-7815-18		. CRANK ASSY, CAM FOLLOWER (USED ON 65-45849-159,-166,-169,-170) (90-7815-16 OPT)		1
73	90-7815-24		. CRANK ASSY, CAM FOLLOWER *[1] (USED ON 65-45849-536) (OPT TO 90-7815-26)		1
73	90-7815-26		. CRANK ASSY, CAM FOLLOWER *[1] (USED ON 65-45849-536) (OPT TO 90-7815-24)		1
74	MS24665-283		. . PIN, COTTER *[6] *[8] *[9] *[14] *[15]		1
74	AN380-3-3		. . PIN, COTTER *[7]		1
75	BACN10JD6		. . NUT, CASTELLATED (REPLS AN310-6) *[6]		1
75	BACN10JD106		. . NUT, CASTELLATED (REPLS AN320-6) *[7]		1
75	BACN10JD106		. . NUT, CASTELLATED *[8] *[9]		1
75	BACN10JD106ASU		. . NUT, CASTELLATED *[14] *[15]		1
76	AN960PD616		. . WASHER *[6]		1
76A	AN960-616L		. . WASHER *[7]		*[13]
76A	AN960XC616L		. . WASHER *[8] *[9]		*[13]
76A	NAS1149C0632B		. . WASHER *[14] *[15]		*[13]
77	AN960PD616L		. . WASHER *[6] (USED WITH BACB10BH60F9)		4
77	AN960PD616L		. . WASHER *[6] (USED WITH BACB10BH60F8)		2
78	BACB10BH60F9		. . BEARING UNIT, NEEDLE (BACB10BH60F8 OPT) *[6]		1
78	BACB10BH60F8		. . BEARING UNIT, NEEDLE (OPT TO BACB10BH6OF9) *[6]		1
78	BACB10BH60CF6		. . BEARING UNIT, NEEDLE (BACB10AF6F6H OPT) *[7]		1
78	BACB10AF6F6H		. . BEARING UNIT, NEEDLE (OPT TO BACB10BH6OCF6) *[7]		1
78	BACB10FK6F6HS		. . BEARING UNIT, NEEDLE *[8] *[9]		1
78	KRP141500VT6-6		. . BEARING UNIT, NEEDLE, V50632 *[14] *[15]		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1102-					
79	69-38732-2		. . ARM, CRANK *[6]		1
79	90-7815-5		. . ARM, CRANK *[7]		1
79	90-7815-22		. . ARM, CRANK *[8]		1
79	90-7815-20		. . ARM, CRANK *[9]		1
79	90-7815-28		. . ARM, CRANK *[14]		1
79	90-7815-30		. . ARM, CRANK *[15]		1
80	BACN10JC3		. NUT, SELF-LOCKING (REPLS NAS679A3W)		4
81	NAS1197-10		. WASHER		4
82	NAS1103-5		. BOLT		1
83	NAS1103-7		. BOLT		2
84	NAS583-10		. BOLT		1
85	63-1059		. RETAINER, BEARING (USED ON 65-45849-159,-166,-169,-170,-2)		2
85	63-1059		. RETAINER, BEARING *[1] (USED ON 65-45849-536)		2
85	69B10068-3		. RETAINER, BEARING *[1] (USED ON 65-45849-536)		2
86	BACB10BW21		. BEARING (REPLS BACB10A822, AN202KP21B) (USED ON 65-45849-159, -166,-169,-170,-2)		2
86	BACB10BW21		. BEARING *[1] (USED ON 65-45849-536) (REPLS BACB10A822, AN202KP21B)		2
86	BACB10FV21		. BEARING *[1] (USED ON 65-45849-536)		2
87	BACB10BW23		. BEARING (REPLS BACB10A823, AN202KP23B) (USED ON 65-45849-159, -166,-169,-170,-2)		2
87	BACB10BW23		. BEARING *[1] (USED ON 65-45849-536) (REPLS BACB10A823, AN202KP23B)		2
87	BACB10FV23		. BEARING *[1] (USED ON 65-45849-536)		2
88	BACW10P148AL		. WASHER		1
89	MS16625-1162		. RING, INTERNAL RETAINING		1
90	BACB10BX12		. BEARING (REPLS BACB10A685,MS20201KP12A, AN201KP12A) (REPLD BY BACB10FS12)		1
90	BACB10FS12		. BEARING (REPLS BACB10BX12)		1
91	BACB10BW25		. BEARING (USED ON 65-45849-2) (REPLS BACB10A824, MS20202KP25B, AN202KP25B) (PRE SB 52-1094,R1,R2,R3)		2

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1102-91	BACB10BW25		. BEARING *[1] (USED ON 65-45849-159) (REPLS BACB10A824, MS20202KP25B, AN202KP25B) (PRE SB 52-1094,R1,R2,R3)		2
91	PACMKP25BA3908		. BEARING (V21335)(POST SB 52-1094, R1)		2
91	BACB10FR25		. BEARING (USED ON 65-45849-159,-2) (POST SB 52-1094R2,R3) *[16]		2
91	BACB10FR25		. BEARING *[1] (USED ON 65-45849-159) *[16]		2
91	BACB10FR25		. BEARING (USED ON 65-45849-166, -169, -170,-536) *[16]		2
92	65-1642-12		. HOUSING ASSY, HANDLE MECHANISM *[1] (USED ON 65-45849-2)		1
92	65-1642-27		. HOUSING ASSY, HANDLE MECHANISM *[1] (USED ON 65-45849-2,-536)		1
92	65-1642-27		. HOUSING ASSY, HANDLE MECHANISM (USED ON 65-45849-159,-166,-169, -170)		1
92	65-1642-42		. HOUSING ASSY, HANDLE MECHANISM *[1] (USED ON 65-45849-536)		1
92	65-1642-46		. HOUSING ASSY, HANDLE MECHANISM *[1] (USED ON 65-45849-536)		1
93	65-1642-13		. . HOUSING (USED ON 65-1642-12)		1
93	65-1642-28		DELETED		1
93	65-1642-35		. . HOUSING (USED ON 65-1642-27)		1
93	65-1642-44		. . HOUSING (USED ON 65-1642-42)		1
93	65-1642-47		. . HOUSING (USED ON 65-1642-46)		1
94	BACN10KE4E4		. . NUTPLATE (PREF) (USED ON 65-1642-12,-27)		12
94	NAS1792A4-4		. . NUTPLATE (OPT)		12
94	BACB10JA4CD		. . NUTPLATE (USED ON 65-1642-42,-46)		12
-95	NAS463YD416		. . SHIM (USED ON 65-1642-12,-27)		12
96	NAS680A3		. . NUTPLATE (USED ON 65-1642-12,-27)		4
96	BACB10JP3ACD		. . NUTPLATE (USED ON 65-1642-12,-27)		4
97	MS20426B3		. . RIVET (USED ON 65-1642-12,-27)		32
97	BACR15BA3AD		. . RIVET (USED ON 65-1642-42,-46)		32
98	69-78694-3		. . FILLER (USED ON 65-1642-42,-46)		4
99	69-78694-4		. . FILLER (USED ON 65-1642-42,-46)		4
100	BACR15GF5D		. . RIVET (USED ON 65-1642-42,-46)		8
101	65C36793-1		. . BUSHING (USED ON 65-1642-42,-46)		2

*[1] LIMITED USAGE
*[2] USED ON 69-38733-1
*[2A] USED ON 69-38733-1 WITH BEARING BACB10BH60F8
*[2B] USED ON 69-38733-1 WITH BEARING BACB10BH60F9
*[3] USED ON 90-7815-1
*[4] USED ON 90-7815-17
*[5] USED ON 90-7815-15
*[6] USED ON 69-38732-1
*[7] USED ON 90-7815-4
*[8] USED ON 90-7815-18
*[9] USED ON 90-7815-16
*[10] DELETED
*[11] USED ON 90-7815-23
*[12] USED ON 90-7815-25
*[13] USE ONE WASHER ADJACENT TO THE HEAD OF THE BEARING (71, 78). USE A MAXIMUM OF 5 WASHERS ADJACENT TO THE NUT (68, 75) TO GET THE CORRECT NUT TORQUE AND COTTER PIN INSTALLATION.
*[14] USED ON 90-7815-24
*[15] USED ON 90-7815-26
*[16] TORQUE TUBE ASSEMBLY KIT 65C33403-10 CONSISTS OF:
SLEEVE 60-4365-3 (FIG. 1101); HINGE LINK PIN 66-14527-6 (FIG. 1101); SLEEVE 66-24987-3 (FIG. 1101); CRANK 69-17330-4 (FIG. 1102); TORQUE TUBE 90-6753-18 (FIG. 1102); WASHERS AN960C416L (FIG. 1101), AN960C516L (FIG. 1102); BALL BEARING BACB10FR25 (FIG. 1102); BOLTS BACB30NM4K26 (FIG. 1101), BACB30NM5K29 (FIG. 1102); NUTS BACN10YR4CD (FIG. 1101), BACN10YR5CD (FIG. 1102).

VENDORS

V09455 LEAR SIEGLER INC., TRANSPORT DYNAMICS DIV., 3131 W. SEGERSTROM AVE., SANTA ANA, CALIFORNIA 92702

V21335 FAFNIR BEARING CO., DIV. OF TEXTRON, INC., 37 BOOTH ST., NEW BRITIAN, CONNECTICUT 06050

V50632 KAMATICS CORP., SUB OF KAMAN CORP., 1335 BLUE HILLS RD., BLOOMFIELD, CONNECTICUT 06002-1304

V73134 IMO INDUSTRIES, INC., HEIM BEARING DIV., 60 ROUND HILL RD., P.O. BOX 430, FAIRIFELD, CONNECTICUT 06430

V75345 KIRKHILL RUBBER CO., 300 E. CYPRESS ST., BREA, CALIFORNIA 92621

V77896 REX CHAIN BELT, INC., BEARING DIV., 2400 CURTIS ST., DOWNERS GROVE, ILLINOIS 60515

V81376 SOUTHWEST PRODUCTS CO., 1705 SOUTH MOUNTAIN AVE., MONROVIA, CALIFORNIA 91016

Part No.	Fig. and Index No.	Qty. per Assy.
AN316-5R	1101-100	2
AN316-5R	1101-85	1
AN316-5R	1101-90	1
AN316-5R	1101-95	2
AN316-6R	1102-54	1
AN380-3-3	1102-67	1
AN380-3-3	1102-74	1
AN6227-19	1101-177	2
AN6227B17	1102-38	1
AN6227B19	1101-177	2
AN6227B28	1102-35	1
AN960-10L	1101-132	8
AN960-10L	1101-141	8
AN960-1716	1101-176	2
AN960-4	1101-25	12
AN960-416	1101-170	8
AN960-516L	1101-203	1
AN960-616	1102-9A	AR
AN960-616L	1102-69A	*[13]
AN960-616L	1102-76A	*[13]
AN960C10L	1101-132	8
AN960C10L	1101-132	8
AN960C10L	1101-141	8
AN960C10L	1101-141	8
AN960C1716L	1101-176	2
AN960C1716L	1101-176	2
AN960C416L	1101-170	8
AN960C416L	1101-170	8
AN960C516L	1102-45	2
AN960C516L	1102-45	2
AN960D10	1101-163	16
AN960PD10	1101-149	16
AN960PD10	1101-17	8
AN960PD10	1101-179	28
AN960PD10	1101-22	3
AN960PD10L	1101-103A	9
AN960PD10L	1101-104A	9
AN960PD10L	1101-107	4
AN960PD10L	1101-18	40
AN960PD10L	1101-182B	4
AN960PD10L	1101-187	2
AN960PD10L	1101-195	2
AN960PD10L	1101-41	3
AN960PD10L	1101-6	17
AN960PD10L	1102-12	4
AN960PD10L	1102-33	4
AN960PD416	1101-185	AR

Part No.	Fig. and Index No.	Qty. per Assy.
AN960PD416	1101-193	AR
AN960PD416	1101-77	4
AN960PD416	1102-5	12
AN960PD416L	1101-185	AR
AN960PD416L	1101-193	AR
AN960PD416L	1102-59	2
AN960PD516	1102-45	2
AN960PD516L	1101-138	16
AN960PD516L	1102-49	2
AN960PD616	1102-69	1
AN960PD616	1102-76	1
AN960PD616L	1102-70	4
AN960PD616L	1102-70	2
AN960PD616L	1102-77	4
AN960PD616L	1102-77	2
AN960XC616L	1102-69A	*[13]
AN960XC616L	1102-76A	*[13]
AN996-14	1102-20	1
BACB10A187L	1101-84	1
BACB10A187L	1101-84A	1
BACB10A187L	1101-89	1
BACB10A187L	1101-89A	1
BACB10A187L	1101-94	1
BACB10A187L	1101-94	1
BACB10A187L	1101-94A	1
BACB10A187L	1101-99	1
BACB10A187L	1101-99	1
BACB10A187L	1101-99A	1
BACB10A187M2L	1101-84	1
BACB10A187M2L	1101-84A	1
BACB10A187M2L	1101-89	1
BACB10A187M2L	1101-89A	1
BACB10A397-GCM2	1101-168	8
BACB10AF5F9H	1101-139	4
BACB10AF5F9H	1101-139	4
BACB10AF6F3H	1102-71	1
BACB10AF6F6H	1102-71	1
BACB10AF6F6H	1102-78	1
BACB10BH59F7	1101-139	4
BACB10BH59F7	1101-139	4
BACB10BH60CF6	1102-71	1
BACB10BH60CF6	1102-78	1
BACB10BH60F8	1102-71	1
BACB10BH60F8	1102-78	1
BACB10BH60F9	1102-71	1
BACB10BH60F9	1102-78	1
BACB10BW21	1102-86	2

Part No.	Fig. and Index No.	Qty. per Assy.
BACB10BW21	1102-86	2
BACB10BW23	1102-87	2
BACB10BW23	1102-87	2
BACB10BW25	1102-91	2
BACB10BW25	1102-91	2
BACB10BX12	1102-90	1
BACB10FK6F6HS	1102-71	1
BACB10FK6F6HS	1102-78	1
BACB10FR25	1102-91	2
BACB10FR25	1102-91	2
BACB10FR25	1102-91	2
BACB10FS12	1102-90	1
BACB10FV21	1102-86	2
BACB10FV23	1102-87	2
BACB10JA4CD	1102-94	12
BACB10JP3ACD	1102-96	4
BACB10Y4	1101-84A	1
BACB10Y4	1101-89A	1
BACB10Y4	1101-94A	1
BACB10Y4	1101-99A	1
BACB30EL3-4	1101-105	4
BACB30EL3-5	1101-150	16
BACB30LH3	1101-213	2
BACB30LH3	1101-217	2
BACB30LH-3-11	1102-13	
BACB30LH3-13	1102-13	4
BACB30LU3-4	1101-103	9
BACB30NF5-15	1102-51	1
BACB30NM3K17	1101-133	8
BACB30NM3K17	1101-133	8
BACB30NM3K19	1101-142	8
BACB30NM3K19	1101-142	8
BACB30NM4K26	1101-171	8
BACB30NM4K26	1101-171	8
BACB30NM5K29	1102-46	2
BACB30NM5K29	1102-46	2
BACN10JC04	1101-24	6
BACN10JC3	1101-106	4
BACN10JC3	1101-13	8
BACN10JC3	1101-131	8
BACN10JC3	1101-14	40
BACN10JC3	1101-140	8
BACN10JC3	1101-148	16
BACN10JC3	1101-162	16
BACN10JC3	1101-178	28
BACN10JC3	1102-11	4
BACN10JC3	1102-80	4

Part No.	Fig. and Index No.	Qty. per Assy.
BACN10JC4	1101-169	8
BACN10JC4	1101-76	6
BACN10JC4	1102-58	2
BACN10JC5	1101-202	1
BACN10JC5	1102-44	2
BACN10JC5	1102-48	1
BACN10JC6	1102-9	1
BACN10JD105	1101-137	4
BACN10JD106	1102-68	1
BACN10JD106	1102-68	1
BACN10JD106	1102-75	1
BACN10JD106	1102-75	1
BACN10JD106ASU	1102-68	1
BACN10JD106ASU	1102-75	1
BACN10JD6	1102-68	1
BACN10JD6	1102-75	1
BACN10JD-6	1102-9	1
BACN10JR3F	1101-41A	1
BACN10JZ3A2	1101-12C	8
BACN10KE4E4	1102-94	12
BACN10YR3CD	1101-131	8
BACN10YR3CD	1101-131	8
BACN10YR3CD	1101-140	8
BACN10YR3CD	1101-140	8
BACN10YR4CD	1101-169	8
BACN10YR4CD	1101-169	8
BACN10YR5CD	1102-44	2
BACN10YR5CD	1102-44	2
BACR12AG	1101-3	4
BACR12AG2C	1101-3	4
BACR15BA3AD	1102-97	32
BACR15BA3D	1101-12A	56
BACR15BA5D	1102-26	3
BACR15BB3D	1101-101	1
BACR15BB3D	1101-96	1
BACR15BB5D	1101-86	1
BACR15BB5D	1101-91	1
BACR15CE5D	1102-36	4
BACR15GF5D	1102-100	8
BACS11W3	1102-34	4
BACS11W-3	1101-182	28
BACS21AP180R	1101-2	4
BACS21AP180RP	1101-2	
BACS21AP220RP	1101-2	4
BACS40A12-12	1101-28	AR
BACS40B11-11	1102-28	AR
BACS40B12-12	1101-29	AR

Part No.	Fig. and Index No.	Qty. per Assy.
BACS40B12-26	1102-29	AR
BACS40R007B007F	1101-28	AR
BACS40R007C007F	1101-29	AR
BACS40R05E08	1101-212	2
BACS40R06E08	1101-216	2
BACS40R07E16	1101-211	2
BACS40R07E42	1102-8	AR
BACS40R08E16	1101-215	2
BACW10BN3AP	1101-10A	8
BACW10BN3AP	1101-11A	20
BACW10P148AL	1102-88	1
DREM5-019	1102-55	2
JRO1415IDVT6-6	1102-71	1
KRP141500VT5-9	1101-139	4
KRP141500VT6-6	1102-78	1
M83461-1-214	1101-177	2
MS15001-4	1101-166	1
MS16562-1	1101-118	2
MS16562-1	1101-125	2
MS16562-209	1101-118	2
MS16562-209	1101-125	2
MS16625-1162	1102-89	1
MS20253-2-2870	1101-119	1
MS20253-2-2885	1101-126	1
MS20253P2-2870	1101-119	1
MS20253P2-2880	1101-126	1
MS20426B3	1102-97	32
MS20615	1102-53	1
MS21209F1-15	1101-182D	4
MS21209F1-15	1101-182G	4
MS21209F5-15	1102-30	3
MS24665-134	1101-136	4
MS24665-283	1102-24A	1
MS24665-283	1102-67	1
MS24665-283	1102-74	1
MS24665-360	1102-42	2
MS28775-214	1101-177	2
MS39086-111	1102-18	1
MS39086-13	1102-18	1
NAS1103-10	1101-39	2
NAS1103-11	1102-32	4
NAS1103-16	1101-133	8
NAS1103-18	1101-142	8
NAS1103-2	1101-16	40
NAS1103-3	1101-164	16
NAS1103-3	1101-180	23
NAS1103-4	1101-181	5

Part No.	Fig. and Index No.	Qty. per Assy.
NAS1103-5	1101-40	1
NAS1103-5	1102-82	1
NAS1103-7	1102-83	2
NAS1104-12	1101-81	2
NAS1104-13	1101-79	4
NAS1104-18	1101-80	2
NAS1104-25	1101-171	8
NAS1104-5	1102-61	1
NAS1104-6	1102-62	1
NAS1105-12	1102-51	1
NAS1105-16	1102-50	1
NAS1105-29	1102-46	2
NAS1149C0632B	1102-76A	*[13]
NAS1149C9632B	1102-69A	*[13]
NAS1197-10	1102-81	4
NAS1197-416L	1101-78	6
NAS1303-10	1101-186	2
NAS1303-10	1101-194	2
NAS1303-3	1101-21	3
NAS1303-3	1101-5	17
NAS1303-7	1101-182A	4
NAS1303-9	1101-11	20
NAS1304-10	1101-184	2
NAS1304-10	1101-192	2
NAS1304-17	1102-2	1
NAS1304-18	1102-1	4
NAS1304-19	1102-3	6
NAS1304-20	1102-4	1
NAS1503-11	1102-13	
NAS1503-13	1102-13	4
NAS1792A4-4	1102-94	12
NAS43HT5-23	1101-204	1
NAS463YD416	1102--95	12
NAS514P1032-15	1101-213A	1
NAS514P1032-9	1101-213B	1
NAS514P1032-9	1101-217	1
NAS516-1	1101-154	1
NAS516-1	1101-157	1
NAS516-1	1101-160	1
NAS516-1	1101-166	1
NAS516-1	1102-40	1
NAS516-1A	1101-154	1
NAS516-1A	1101-157	1
NAS516-1A	1101-160	1
NAS583-10	1102-84	1
NAS583-2	1101-15	8
NAS583-4	1101-104	9

Part No.	Fig. and Index No.	Qty. per Assy.
NAS600-8P	1101-26	6
NAS603-9P	1101-10	8
NAS623-3-2	1101-103	9
NAS623-3-2	1101-104	9
NAS6603-10	1101-39	2
NAS6603-2	1101-10	8
NAS6603-3	1101-11	20
NAS6603-5	1101-40	1
NAS679A3W	1101-14	40
NAS6805A29	1102-46	2
NAS680A3	1102-96	4
NAS680-A3	1101-12B	20
NAS686A3	1101-41A	1
NAS74A4E006P	1101-82	2
NAS76A16-016P	1101-189	1
NAS76A16-016P	1101-197	1
NAS77A4-23P	1101-111	1
NAS77A4-23P	1101-115	1
PACMKP25BA3908	1102-91	2
REM10ATC12-2	1102-55	2
TEM5C	1102-55	2
*[3]	1101-199	1
*[3]	1101-200	1
11-667A	1101-94	1
11-667A	1101-94A	1
11-667A	1101-99	1
11-667A	1101-99A	1
30-3004	1101-135	22
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
514162-4	1101-38	1
60-4365	1101-172	1
60-4365-1	1101-172	1
60-4365-3	1101-172	1
60-4365-3	1101-172	1
60-4405	1102-43	2
60-4405-1	1102-43	2
60-4405-1	1102-43	2
60-4406-13	1101-147	1
60-4406-13	1101-147	1
60-4406-14	1101-146	1
60-4406-14	1101-146	1

Part No.	Fig. and Index No.	Qty. per Assy.
60-4406-7	1101-147	1
60-4406-8	1101-146	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
63-1059	1102-85	2
63-1478	1101-27	3
63-1692	1102-60	2
63-2848	1102-22	1
63-9386	1102-10	1
65-1642-12	1102-92	1
65-1642-13	1102-93	1
65-1642-27	1102-92	1
65-1642-27	1102-92	1
65-1642-28	1102-93	1
65-1642-35	1102-93	1
65-1642-42	1102-92	1
65-1642-44	1102-93	1
65-1642-46	1102-92	1
65-1642-47	1102-93	1
65-1933-12	1102-63	1
65-1933-17	1102-63	1
65-1933-19	1102-63	1
65-1933-21	1102-63	1
65-1933-4	1102-63	1
65-1933-507	1102-63	1
65-1933-507	1102-63	1
65-1933-7	1102-63	1
65-2306	1101-165	4
65-2306-1	1101-167	1
65-2306-3	1101-165	4
65-2306-3	1101-165	14
65-2306-4	1101-167	1
65-2863-3	1101-23	1
65-28925-45	1101-93	1
65-28925-46	1101-98	1
65-28925-47	1101-97	1
65-28925-48	1101-102	1
65-28925-85	1101-93	1
65-28925-85	1101-93	1
65-28925-86	1101-98	1
65-28925-86	1101-98	1
65-45849-102	1101-210	1

Part No.	Fig. and Index No.	Qty. per Assy.
65-45849-103	1101-214	1
65-45849-104	1101-209	1
65-45849-107	1101-117	1
65-45849-108	1101-124	1
65-45849-123	1101-122	1
65-45849-124	1101-123	1
65-45849-125	1101-129	1
65-45849-126	1101-130	1
65-45849-126	1101-130	1
65-45849-138	1102-6	12
65-45849-159	1101-	RF
65-45849-166	1101-	RF
65-45849-169	1101-	RF
65-45849-170	1101-	RF
65-45849-2	1101-	RF
65-45849-24	1101-12	2
65-45849-33	1101-108	1
65-45849-36	1101-7	1
65-45849-37	1101-8	1
65-45849-43	1101-109	1
65-45849-505	1101-7	1
65-45849-506	1101-8	1
65-45849-511	1101-35	2
65-45849-513	1101-36	4
65-45849-514	1101-37	2
65-45849-518	1101-123	1
65-45849-518	1101-123	1
65-45849-521	1101-117	1
65-45849-521	1101-117	1
65-45849-522	1101-124	1
65-45849-522	1101-124	1
65-45849-533	1101-214	1
65-45849-534	1101-209	1
65-45849-535	1101-130	1
65-45849-535	1101-130	1
65-45849-536	1101-	RF
65-45849-62	1101-208	2
65-45849-71	1101-120	1
65-45849-72	1101-121	1
65-45849-73	1101-127	1
65-45849-74	1101-128	1
65-45849-81	1102-7	4
65-45851-1	1101-73	1
65-45851-11	1101-71	1
65-45851-13	1101-68	1
65-45851-15	1101-54	1
65-45851-17	1101-52	1

Part No.	Fig. and Index No.	Qty. per Assy.
65-45851-17	1101-52	1
65-45851-18	1101-54	1
65-45851-3	1101-70	1
65-45851-5	1101-67	1
65-45851-7	1101-52	1
65-45851-9	1101-74	1
65-45852-1	1101-43	1
65-45852-3	1101-45	1
65-45852-501	1101-43	1
65-45852-501	1101-43	1
65-45852-501	1101-43	1
65-45852-503	1101-45	1
65-45852-7	1101-43	1
65-45852-9	1101-45	1
65-49560-1	1101-153	2
65-49560-1	1101-153	2
65-49560-10	1101-155	1
65-49560-11	1101-156	2
65-49560-12	1101-158	1
65-49560-13	1101-159	2
65-49560-14	1101-161	1
65-49560-15	1101-153	2
65-49560-16	1101-155	1
65-49560-17	1101-156	2
65-49560-18	1101-158	1
65-49560-19	1101-159	2
65-49560-2	1101-155	1
65-49560-20	1101-161	1
65-49560-4	1101-156	1
65-49560-4	1101-156	2
65-49560-5	1101-159	1
65-49560-5	1101-159	2
65-49560-6	1101-158	1
65-49560-7	1101-161	1
65-49560-9	1101-153	2
65-49890-1	1101-46	1
65-49890-1	1101-46	1
65-49890-3	1101-48	1
65-49890-7	1101-46	1
65-49890-9	1101-48	1
65-52855-506	1101-121	1
65-52855-508	1101-127	1
65-52980-1	1101-64	1
65-52980-3	1101-66	1
65-52980-5	1101-64	1
65-52980-5	1101-64	1
65-52980-7	1101-66	1

Part No.	Fig. and Index No.	Qty. per Assy.
65-52981-1	1101-61	1
65-52981-3	1101-63	1
65-52981-5	1101-61	
65-52981-5	1101-61	1
65-52981-7	1101-63	1
65-52981-9	1101-61	1
65-52982-1	1101-55	1
65-52982-3	1101-57	1
65-52982-5	1101-55	1
65-52982-5	1101-55	1
65-52982-7	1101-57	1
65-52983-1	1101-58	1
65-52983-3	1101-60	1
65-52983-5	1101-58	1
65-52983-5	1101-58	1
65-52983-7	1101-60	1
65-54013	1102-65	1
65-54013-503	1102-65	1
65-54013-503	1102-65	1
65-54024-6	1102-63	1
65-54481-1	1101-49	2
65-54481-3	1101-51	1
65-55478-1	1101-113	1
65-55478-3	1101-116	1
65-55478-501	1101-113	1
65-55478-501	1101-113	1
65-55478-503	1101-116	1
65-55478-7	1101-113	1
65-55478-9	1101-116	1
65-55479-10	1101-112	1
65-55479-2	1101-110	1
65-55479-4	1101-112	1
65-55479-502	1101-110	1
65-55479-502	1101-110	1
65-55479-504	1101-112	1
65-55479-8	1101-110	1
65-55720-1	1101-191	1
65-55720-11	1101-191	1
65-55720-11	1101-191	1
65-55720-13	1101-183	1
65-55720-13	1101-183	1
65-55720-3	1101-183	1
65-55720-5	1101-198	1
65-55720-7	1101-190	1
65-62981-11	1101-63	1
65-73978-1	1101-182C	1
65-73978-10	1101-182H	1

Part No.	Fig. and Index No.	Qty. per Assy.
65-73978-11	1101-182E	1
65-73978-12	1101-182H	1
65-73978-13	1101-182E	1
65-73978-14	1101-182H	1
65-73978-2	1101-182F	1
65-73978-2	1101-182F	1
65-73978-2	1101-182F	1
65-73978-2	1101-182F	1
65-73978-3	1101-182E	1
65-73978-4	1101-182H	1
65-73978-7	1101-182C	1
65-73978-7	1101-182C	1
65-73978-8	1101-182F	1
65-73978-9	1101-182E	1
65-8795-801	1102-64	1
65C34053-1	1101-121	1
65C34053-3	1101-120	1
65C34053-5	1101-127	1
65C34053-7	1101-128	1
65C34071-1	1101-117	1
65C34071-1	1101-117	1
65C34071-3	1101-124	1
65C34071-3	1101-124	1
65C36793-1	1102-101	1
66-10363	1101-205	1
66-12687-1	1101-207	14
66-12688-1	1101-44	1
66-12688-1	1101-47	1
66-12688-1	1101-47	1
66-12688-1	1101-50	1
66-12688-1	1101-53	1
66-12688-1	1101-56	1
66-12688-1	1101-59	1
66-12688-1	1101-62	1
66-12688-1	1101-65	1
66-12688-1	1101-69	1
66-12688-1	1101-72	1
66-12688-1	1101-75	1
66-12688-11	1101-47	1
66-12688-5	1101-44	1
66-14527-1	1101-174	2
66-14527-2	1101-174	2
66-14527-4	1101-174	2
66-14527-6	1101-174	2
66-14527-6	1101-174	1
66-14530-1	1101-143	1
66-14530-2	1101-143	1

Part No.	Fig. and Index No.	Qty. per Assy.
66-14530-2	1101-143	1
66-14530-3	1101-143	1
66-14530-3	1101-143	1
66-14530-3	1101-143	1
66-14530-4	1101-143	1
66-14531-1	1101-144	2
66-14531-10	1101-145	1
66-14531-10	1101-145	1
66-14531-3	1101-145	1
66-14531-9	1101-144	2
66-14531-9	1101-144	2
66-14542-1	1102-37	1
66-14618-6	1101-87	1
66-14618-7	1101-92	1
66-15332-1	1101-135	22
66-15645-1	1101-175	2
66-16691-1	1101-206	14
66-1921-1	1101-34	1
66-24154-1	1101-19	1
66-24154-2	1101-20	1
66-24986-1	1102-15	1
66-24987-1	1101-173	1
66-24987-2	1101-173	1
66-24987-3	1101-173	1
66-24987-3	1101-173	1
66-2646	1101-30	1
66-9330-1	1101-151	AR
66-9330-3	1101-152	AR
69-1083	1101-32	1
69-1084	1101-33	1
69-17330-2	1102-57	1
69-17330-4	1102-57	1
69-17330-4	1102-57	1
69-17789-2	1101-201	1
69-17952-17	1101-182C	1
69-17952-18	1101-182F	1
69-17952-18	1101-182F	1
69-17952-19	1101-182E	1
69-17952-20	1101-182H	1
69-18187-22	1101-83	1
69-18187-23	1101-88	1
69-18187-23	1101-88	1
69-18187-23	1101-88	1
69-18187-25	1101-83	1
69-18187-25	1101-83	1
69-18187-25	1101-83	1
69-18187-26	1101-88	1

Part No.	Fig. and Index No.	Qty. per Assy.
69-18187-7	1101-83	1
69-18187-8	1101-88	1
69-1983	1101-31	1
69-20350-11	1101-1	1
69-20350-12	1101-4	1
69-20350-14	1101-1	1
69-20350-16	1101-1	1
69-20350-16	1101-1	1
69-20350-18	1101-4	1
69-20350-5	1101-1	1
69-20350-6	1101-4	1
69-20350-7	1101-1	1
69-20350-8	1101-4	1
69-20350-9	1101-1	1
69-21619-3	1101-9	
69-34971-1	1102-25	1
69-34971-2	1102-27	1
69-34971-3	1102-31	1
69-34971-4	1102-25	1
69-34971-4	1102-25	1
69-34971-4	1102-25	1
69-34971-5	1102-31	1
69-34971-6	1102-25	1
69-34971-7	1102-31	1
69-34971-8	1102-25	1
69-37418-11	1101-134	4
69-37418-2	1101-134	4
69-37418-4	1101-134	
69-37418-501	1101-134	4
69-37418-501	1101-134	4
69-37418-501	1101-134	4
69-37418-8	1101-134	4
69-37418-8	1101-134	4
69-37418-8	1101-134	4
69-37495-2	1101-42	1
69-38732-1	1102-73	1
69-38732-2	1102-79	1
69-38733-1	1102-66	1
69-38733-2	1102-72	1
69-39176-1	1102-52	1
69-39176-2	1102-56	1
69-41720-1	1101-114	2
69-42114-1	1101-196	1
69-42114-2	1101-188	1
69-44065-8	1102-31	1
69-61511-1	1102-39	1
69-61511-1	1102-39	1

Part No.	Fig. and Index No.	Qty. per Assy.
69-61511-2	1102-41	1
69-70268-1	1101-196	1
69-70268-2	1101-188	1
69-78694-3	1102-98	4
69-78694-4	1102-99	4
69B10068-3	1102-85	2
77253	1102-55	2
90-6753-11	1102-47	1
90-6753-18	1102-47	1
90-6753-18	1102-47	1
90-6753-6	1102-47	1
90-7811	1102-16	1
90-7812-26	1102-73	1
90-7815-1	1102-66	1
90-7815-15	1102-66	1
90-7815-15	1102-66	1
90-7815-16	1102-73	1
90-7815-16	1102-73	1
90-7815-17	1102-66	1
90-7815-17	1102-66	1
90-7815-18	1102-73	1
90-7815-18	1102-73	1
90-7815-19	1102-72	1
90-7815-20	1102-79	1
90-7815-21	1102-72	1
90-7815-22	1102-79	1
90-7815-23	1102-66	1
90-7815-24	1102-73	1
90-7815-25	1102-66	1
90-7815-27	1102-72	1
90-7815-28	1102-79	1
90-7815-29	1102-72	1
90-7815-3	1102-72	1
90-7815-30	1102-79	1
90-7815-4	1102-73	1
90-7815-5	1102-79	1
90-7820	1102-39	1
90-7820-1	1102-41	1
90-7821	1102-17	1
90-7879-1	1102-14	1
90-7879-1	1102-14	1
90-7879-10	1102-14	1
90-7879-6	1102-14	1

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