TO: ALL HOLDERS OF FORWARD GALLEY DOOR ASSEMBLY OVERHAUL MANUAL, 52-46-06

REVISION NO. 35, DATED JUL 1/06

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
Updated the callout for the bolts in Repair par. 1.D.(2)(a), (b) and (d)					X								

FORWARD GALLEY DOOR ASSEMBLY

52-46-06

BOEING P/N 65-45871-2, -114, -124, -132, -517, -519, -523

AIRLINE P/N

THE FOLLOWING DIRECTIVES APPLY TO THIS SUBJECT:

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVES	DATE DIRECTIVE INCORPORATED INTO TEXT
		PRR 30458	Mar 10/70
		PRR 31564	Mar 10/70
		PRR 31567	Mar 10/70
		PRR 31665	Mar 10/70
		PRR 31996	Sep 10/72
		PRR 32121-1	Dec 25/72
		PRR 32121-7	Dec 25/72
		PRR 32070-13	Dec 25/73
		PRR 32403	Mar 25/75
		PRR 32533	Jul 5/76
		PRR 32575-1	Jan 5/77
		PRR 32797	Jan 5/79
		PRR 32836	Jan 5/79
		PRR 32950-4	Jan 5/80
		PRR 32989	Jul 5/81
		PRR 33268	Dec 5/83
		PRR 33410-6	Jun 5/85
		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

THE FOLLOWING DIRECTIVES APPLY TO THIS SUBJECT:

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVES	DATE DIRECTIVE INCORPORATED INTO TEXT
52-1094, Rev 1			Dec 5/88
52-1094, Rev 2			Mar 5/89
52-1097, Rev 1			Sep 5/89
52A1124			Jul 1/98
52-1094, Rev 3			Mar 1/00

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
	52-46-06			501	Mar 1/05		1116	Nov 1/04
	T-1	Nov 1/04		502	Nov 1/04		1116A	Nov 1/04
	T-2	Nov 1/04		502A	Mar 1/05		1116B	BLANK
*	LEP-1	Jul 1/06		502B	BLANK		1117	Mar 1/00
	LEP-2	BLANK		503	Mar 1/05		1118	Mar 1/00
	T/C-1	Jun 5/88		504	Jul 1/01		1119	Mar 1/00
	T/C-2	BLANK		505	Nov 1/04		1120	Nov 1/04
	1	Jan 5/80		506	Nov 1/04		1121	Nov 1/03
	2	Mar 10/70		507	Nov 1/03		1122	Nov 1/04
	101	Mar 1/05		508	Mar 1/05		1123	Nov 1/04
	102	Nov 1/04		509	Mar 1/05		1124	Nov 1/04
	103	Nov 1/04		510	BLANK		1125	Nov 1/03
	104	Nov 1/04		601	Mar 1/00		1126	Nov 1/04
	105	Nov 1/04		602	BLANK		1127	Nov 1/04
	106	BLANK		701	Nov 15/67		1128	Nov 1/04
	201	Nov 1/04		702	BLANK		1129	Nov 1/03
	202	BLANK		801	Mar 10/70		1130	Nov 1/03
	301	Mar 1/00		802	BLANK		1131	Nov 1/03
	302	Mar 10/70		901	Mar 10/70		1132	Nov 1/03
	401	Jul 1/05		902	BLANK		1133	Nov 1/03
*	402	Jul 1/06		1001	Nov 1/01		1134	Nov 1/03
	402A	Mar 1/00		1002	BLANK			
	402B	Mar 1/00		1101	Mar 1/00			
	402C	Mar 1/00		1102	Mar 10/70			
	402D	Nov 1/01		1103	Mar 1/00			
	402E	Nov 1/01		1104	Mar 1/00			
	402F	Mar 1/00		1105	Mar 1/00			
	402G	Mar 1/00		1106	Mar 1/00			
	402H	Mar 1/00		1106A	Mar 1/00			
	402I	Mar 1/00		1106B	BLANK			
	402J	Jul 1/01		1107	Nov 1/04			
	402K	Jul 1/01		1108	Mar 1/00			
	402L	Jul 1/01		1108A	Mar 1/00			
	402M	Jul 1/01		1108B	Mar 1/00			
	402N	BLANK		1109	Nov 1/04			
	403	Jul 1/01		1110	Nov 1/04			
	404	Jul 1/01		1111	Mar 1/00			
	404A	Nov 1/04		1112	Nov 1/04			
	404B	Jul 1/01		1113	Nov 1/04			
	405	Jul 1/01		1114	Mar 1/00			
	406	Mar 1/00		1114A	Nov 1/04			
	407	Mar 1/00		1114B	Mar 1/00			
	408	Mar 1/00		1114C	Nov 1/04			
	409	Mar 5/93		1114D	Nov 1/04			
	410	BLANK		1115	Nov 1/04			

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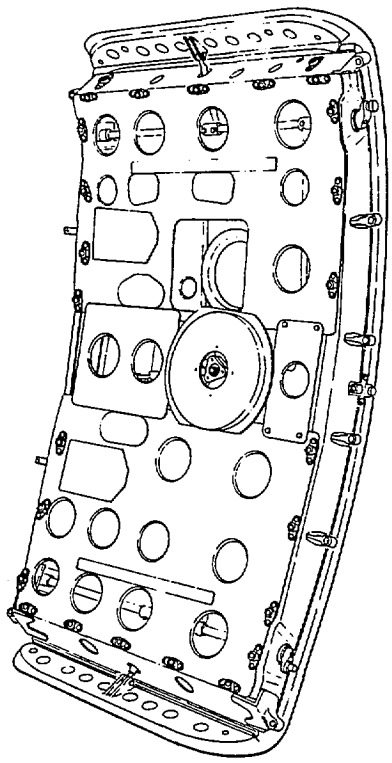
FORWARD GALLEY DOOR ASSEMBLY



Forward Galley Door Assembly
Figure 1.

DESCRIPTION AND OPERATION

1. Description

   A. The forward galley door is an inward-outward plug-type door at station 314.0.

B. A door handle mechanism consisting of a cam, two cam follower crank assemblies, cranks, control rod and a hinge torque tube is assembled in a housing. This housing, together with the mechanism, is installed in the door structure. Connected to the handle mechanism are the upper and 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. Sixteen 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 forward 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, fold the gates inward and move the door to its most inward position. The door is then manually swung outward through the door opening and stowed in the open position by engagement of a latch pin 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 -- 5.00 inches (approximately)
Width -- 35.0 inches (approximately)
Height -- 68.0 inches (approximately)
Weight -- 110.0 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 retainer springs (207) and stop pins (208).

   B. Remove bolts (209, 210), covers (211), and shims (212, 213).

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 screws and washers (5 thru 7) and remove cover plates (8, 9).

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

5. Remove nuts (13, 13A), washers (14) and bolts (15, 16). Remove angle assemblies (18, 21).

   NOTE: Do not remove fillers (20, 23) from angles (19, 22) unless repair or replacement is necessary.

6. Remove bolts (24), washers (25) and window assembly (26).

7. Disassemble window assembly as follows:

   A. Remove parts (27 thru 29), clips (30) and shims (31, 32).

   B. Separate seal (33), retainer (34), inner pane (35), outer panel (36) and seal (37).

8. Remove nylon rods (214, 215) and pull seal (216) from seal retainer.

9. Remove bolts (41, 42), washers (43), serrated plate (44) and roller fitting (45).

10. Remove nut and washers (46, 47) from needle bearing (48).

    NOTE: Do not remove parts (49 thru 72) unless repair or replacement is necessary.

11. Remove nuts (73, 73A) and washers (74, 74A, 75) from bolts (76, 77, 77A).

12. Remove bolts (76 thru 78), bushings (79), washers (80) and rod assemblies (81, 86, 91 and 96).

    NOTE: Do not disassemble rod assemblies (81 and 86) unless repair or replacement is necessary.

13. Before you remove the gates (112, 116) from the door, measure and make a note of the gap between each gate and the door (Fig. 101) to help during assembly. Then remove parts (104 thru 105A), applicable shims (106 thru 111 or 111A, 111B, 111C) and upper and lower gate assemblies (112, 116).

14. Remove bushings (113, 117) from gates (114, 118).

    NOTE: Do not remove bushings (115, 119) unless repair or replacement is necessary.

15. Remove spring pins (121, 128) from hinge pins (122, 129) and pull out the hinge pins. Remove applicable hinge halves or hinge half assemblies (123, 130).

    NOTE: Do not remove seal retainers (125, 132) from hinge halves (124, 131) or seal retainers (134) from gates (114, 118) unless repair or replacement is necessary.

16. Remove nuts, washers and bolts (135 thru 137) at each end of door latching rod, then remove cranks (138) and spacers (139).

17. Remove bearing unit (143) from each crank (138) with cotter pins (140), nuts (141) and washers (142).

18. Remove nuts, washers, bolts (144 thru 146) and cranks (147 thru 150).

19. Pull torque tubes (151) out of the door structure.

20. Remove rod assemblies (91, 96) and cranks (147 thru 150) from door structure.

    NOTE: Do not disassemble rod assemblies (91, 96) unless repair or replacement is necessary.

21. Remove parts (152 thru 156) and support fitting assemblies (157, 159A, 160).

22. Disassemble support fitting assemblies (157, 159A, 160) and remove lubricator fittings (158, 159B, 161).

23. Remove nuts (163), washers (164), bolts (165) and housing assemblies (166).

24. Remove lubricator fitting (167) from housing (168).

25. Remove bearings (169) from support fittings (159, 159C, 162) and housings (168) only if repair or replacement is necessary.

26. Remove nuts, washers and bolts (170 thru 172) and slide coupling sleeves (173) together on torque tube (42, Fig. 1102).

27. Remove bolts (1) and shims (2, 3). Make a note of the number and the thickness of shims to help during assembly.

28. Remove cotter pin (3A), nut (4), and washers (4A, 5), as applicable, guide assembly (20), bolts (27), washers (28), seal washers (29) and remove outer handle (9) with attached parts from the door. Remove handle mechanism housing assembly (87) with attached parts from the door structure.

29. Remove plugs (174, Fig. 1101).

30. Remove bolts and washers (175, 176) and remove pins (177), springs (178), washers (179) and O-ring packing (180), from upper and lower hinge arm assemblies (181, 184).

    NOTE: Do not remove inserts (182, 185) from hinge arms (183, 186) unless repair or replacement is necessary.

31. Remove nuts (187), washers (188), bolts (189, 190) and seal washers (191) that connect upper and lower hinge support assemblies (192, 199) to door structure.

32. Remove and disassemble upper hinge support assembly (192) as follows:

    A. Remove bolts (193), washers (194) and attach fitting (195) from hinge support assembly (196).

    B. Remove bushing (197) from hinge support (198).

33. Remove and disassemble lower hinge support assembly (199) as follows:

    A. Remove bolts (200), washers (201) and attach fitting (202) from hinge support assembly (203).

    B. Remove bushing (204) from hinge support (205).

34. Remove nuts, washers and bolts (6 thru 8, Fig. 1102) and disassemble handle (9), shims (10) and cam (11). Make a note of the number and thickness of shims to help during assembly.

35. With wrench F70038, disassemble sleeve (12), pin (13), washer (14), ring (15), nut (16), spring (17), pin (18) and shaft (19).

    NOTE: Do not disassemble control cam assembly (20) or remove rivets (31) and seal plate (32) unless repair or replacement is necessary.

36. Remove O-ring packings (30, 33) and housing assembly (34) and remove lubricator fitting (35) from housing.

37. Remove cotter pins (37) and nuts (38) with wrench F70085.

38. Remove nuts, washers and bolts (39 thru 41) and remove torque tube (42).

39. Remove nut, washers and bolts (43 thru 46) and remove rod assembly (47) and crank (52).

    NOTE: Do not disassemble rod assembly (47) unless repair or replacement is necessary.

40. Remove nuts (53), washers (54), washer (55) and bolts (56, 57). Pull crank assemblies (61, 68) from handle mechanism housing assembly (87) and remove crank assembly (58), spacer (59) and crank assembly (60).

41. To disassemble crank assembly (61), remove cotter pin (62), nut (63), washer (64), washers (65) and bearing unit (66) from crank arm (67).

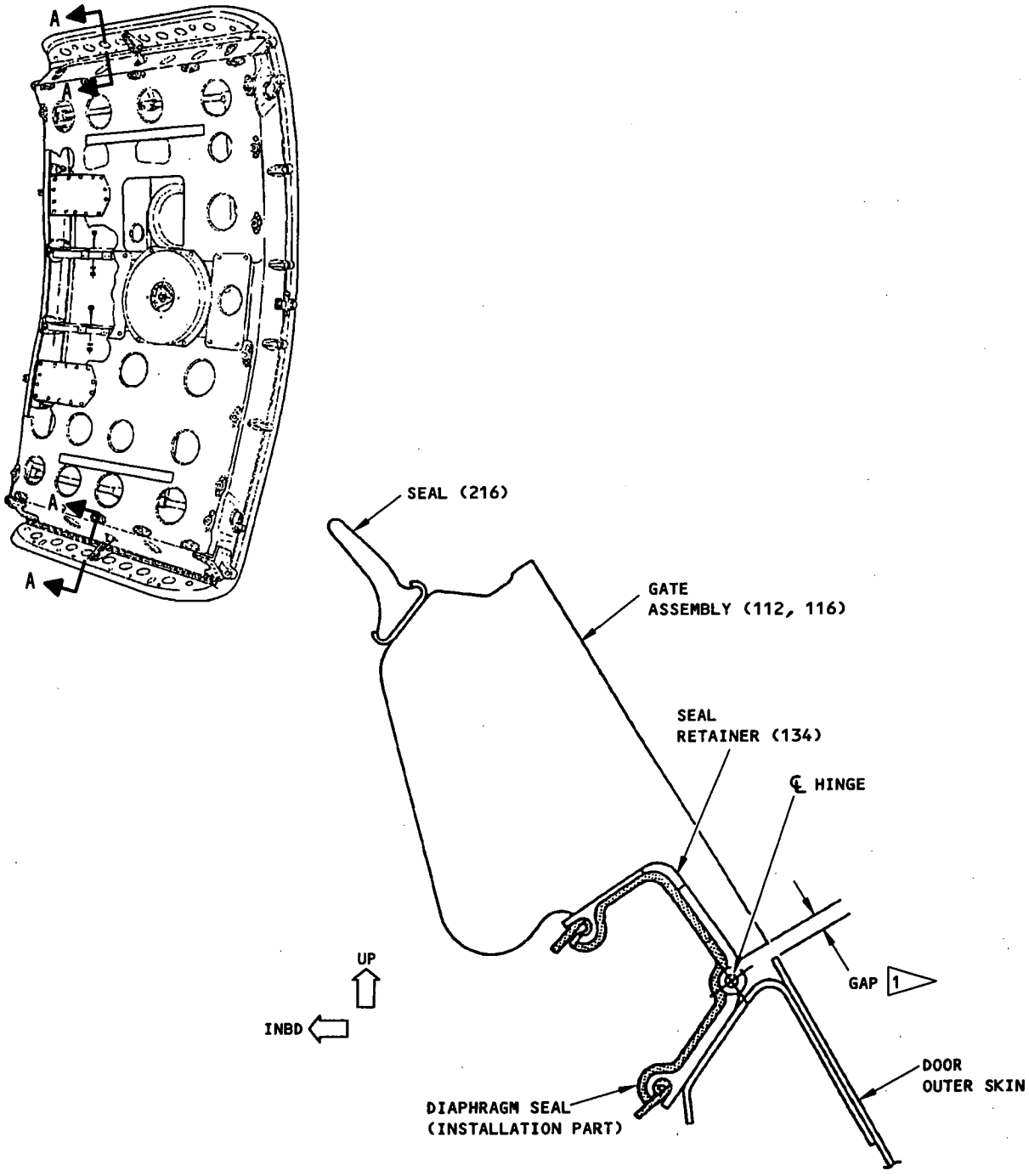
42. To disassemble crank assembly (68), remove cotter pin (69), nut (70), washer (71), washers (72) and bearing unit (73) from crank arm (74).

43. Remove nuts (75), washers (76) and bolts (77 thru 79). Remove bearing retainers (80) and bearings (81, 82).

44. Remove washer (83), retaining ring (84) and bearing (85).

45. Remove bearings (86).

46. Remove bushing (89) from housings (88, 65-1642-44, -47).



1 MEASURE THIS GAP AT UPPER AND LOWER GATE LOCATIONS AND MAKE A NOTE OF IT TO HELP DURING ASSEMBLY.

(UPPER GATE SHOWN)
A-A

Gate Gap Measurement
Figure 101

473288

CLEANING

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

CAUTION: BEARINGS (81, 82, 85, AND 86, FIG. 1102) HAVE TEFLON SEALS. CLEAN ONLY BY THE SPECIAL METHOD IN SOPM 20-30-01.

2. Clean and lubricate bearings by the instructions in SOPM 20-30-01.

3. Wipe window panes (35, 36, Fig. 1101) with a lint-free cloth wet with aliphatic naphtha TT-N-95.

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 (216, Fig. 1101) for damages. Any section of 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 (178, Fig. 1101 and 17, Fig. 1102) for load capacity according to values in Fig. 301.

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

      (1) Perform penetrant check per SOPM 20-20-02 (machined area only) on items (138, Fig. 1101) and (65, 72, Fig. 1102).

      (2) Perform penetrant check per SOPM 20-20-02 on items (50, 53, 65-49894-2, -4, -6, -8, 56, 59, 62, 65, 68, 95, 100, 114, 118, 159, 162, 183, 186, 195, 198, 202, 205, Fig. 1101) and (9, 12, 14, 16, 18, 20, 26, 32, 58, 60, Fig. 1102).

      (3) Perform magnetic particle check per SOPM 20-20-01 on items (53, 65-49894-11, -12, -14, 85, 90, 151, and 177, Fig. 1101) and (36, 42, and 52, Fig. 1102).

INDEX AND FIGURE NO.	APPROXIMATE FREE LENGTH (INCHES)	TEST LENGTH (INCHES)	ALLOWABLE LOAD LIMITS (POUNDS)
178, figure 1101	0.88	0.25 0.20	0.10 to 0.30 0.13 to 0.33
17, 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 (87, Fig. 1102) bores.

(1) Machine housing (88) 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 (88, P/N 65-1642-10) bore. Dow 7 or 17 anodize housing (88, P/N 65-1642-34) bore and apply one coat of BMS 10-11, Type 1 primer (F-18.09). Refer to SOPM 20-43-02 and 20-41-02. Anodize (F-17.12) housing (93, 65-1642-44, -47) and apply BMS 10-11, Type 1 primer.

(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 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 (87) 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 (88) and apply one coat of BMS 10-11, Type 1, primer (F-18.09). Refer to SOPM 20-43-02 and 20-41-02.

(4) Use additional shims (2, 3) as required when installing mechanism housing assembly (87).

D. If the 1/4-inch diameter holes for the bolts (172, Fig. 1101) in the coupling sleeves (173), hinge pins (177) or the hinge torque tube (42, 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 BACB30LM4-26X bolts (Replaces BACB30NE4-26X bolts), AN960D416 washers, and BACN10JC4 nuts.

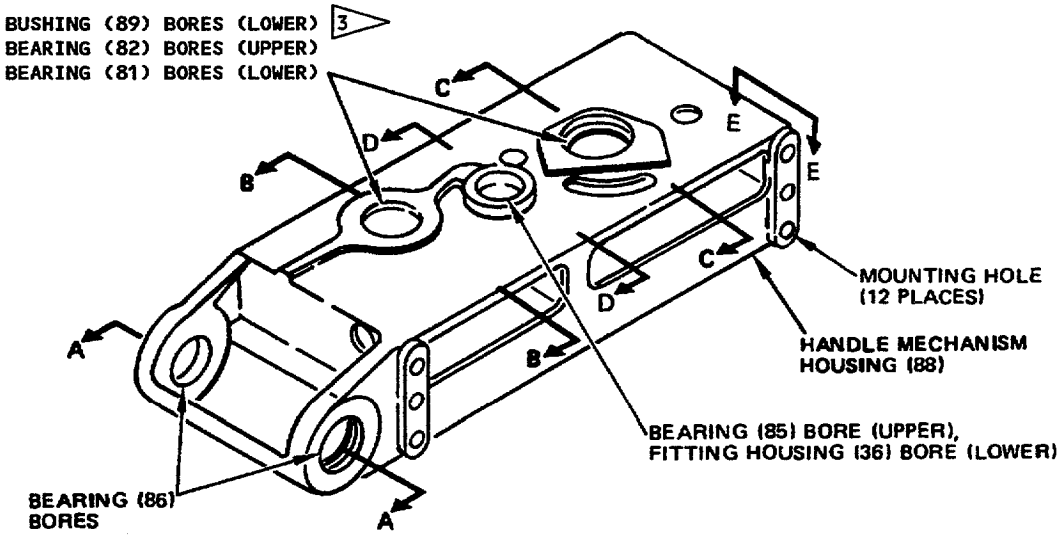
(b) For the 0.2807-0.2817 inch repair diameter - Use BACB30LM4-26Y bolts (Replaces BACB30NE4-26Y bolts), AN960D416 washers, and BACN10JC4 nuts.

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

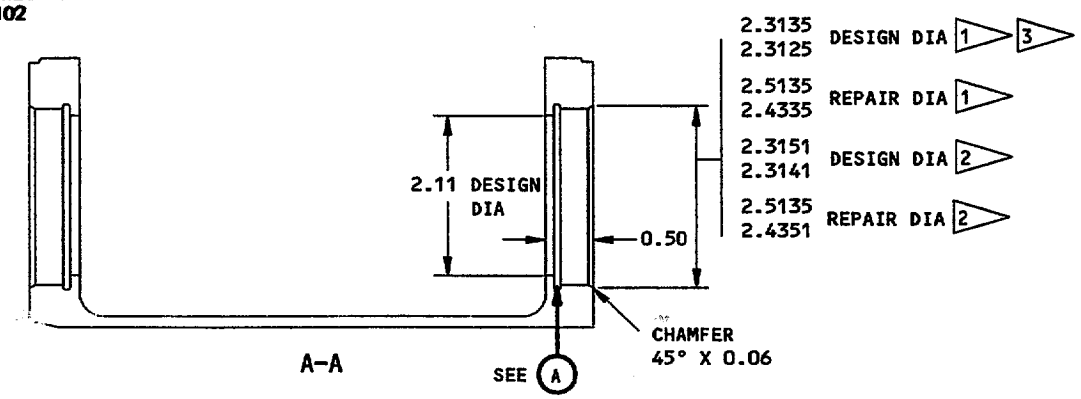
(d) For the 0.3120-0.3130 inch repair diameter - Use BACB30LM5-26 bolts (Replaces BACB30NE5-26 bolts), AN960D516 washers, and BACN10JC5 nuts

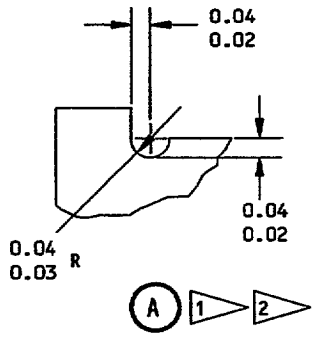
CAUTION: THE REPAIR SPECIFIED BELOW IS FOR 65-73978-( ) HINGE ARMS ONLY.

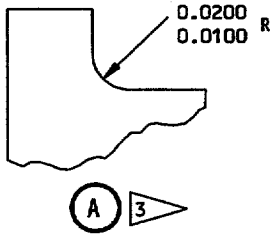
E. Repair the 0.250 inch diameter holes on the hinge arm (65-73978-3, -9, 183; 65-73978-4, -10, -12, -14, 186; Fig 1101) as follows:



ALL ITEM NUMBERS REFER TO FIGURE 1102







1 HOUSING (88), 65-1642-10

2 HOUSING (88), 65-1642-34,-35

3 HOUSING (88), 65-1642-44,-47

ALL DIMENSIONS APPLY FOR BOTH HOLES

ALL TOLERANCES ±0.010 UNLESS OTHERWISE SPECIFIED

ALL DIMENSIONS ARE IN INCHES

HOUSING (88, FIG. 1102)

Handle Mechanism Housing Repair
Figure 401 (Sheet 1)

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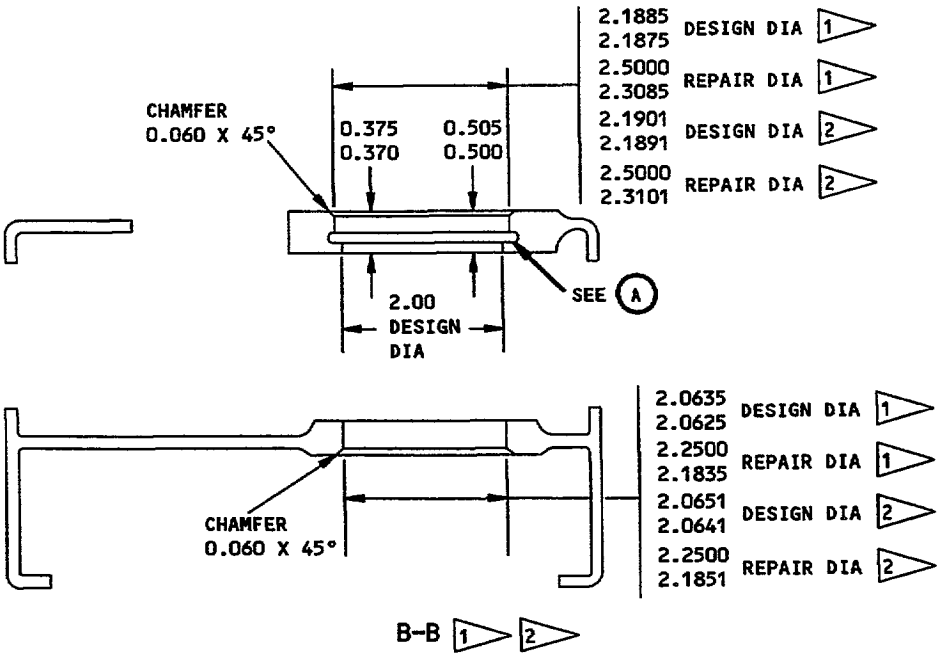

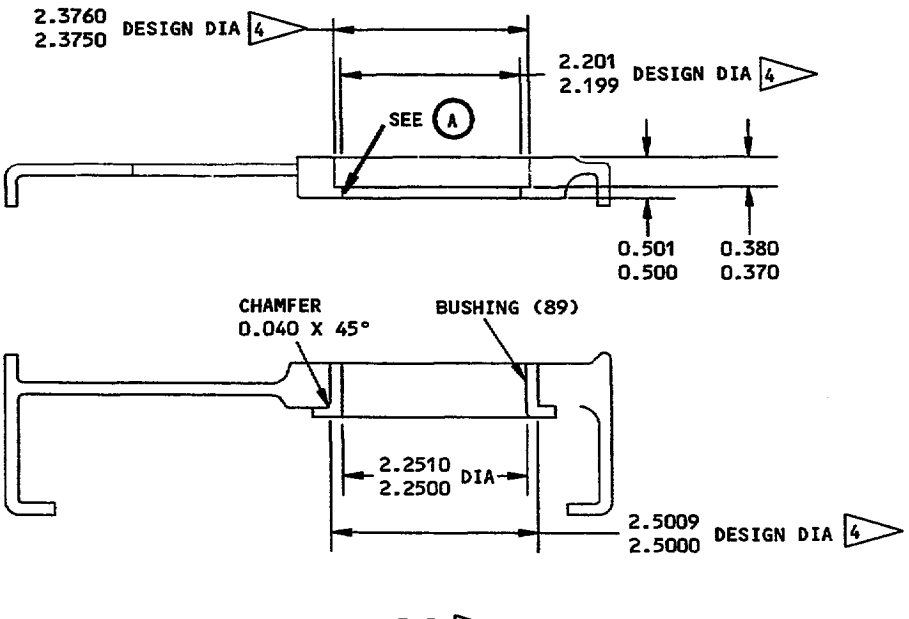

1 HOUSING (88), 65-1642-10

2 HOUSING (88), 65-1642-34,-35

3 HOUSING (88), 65-1642-44,-47

4 CONTACT BOEING TO COORDINATE REPAIRS FOR BORES INDICATED.

ALL TOLERANCES ± 0.010 UNLESS OTHERWISE SPECIFIED

ALL DIMENSIONS ARE IN INCHES

HOUSING (88, FIG. 1102)

Handle Mechanism Housing Repair
Figure 401 (Sheet 2)

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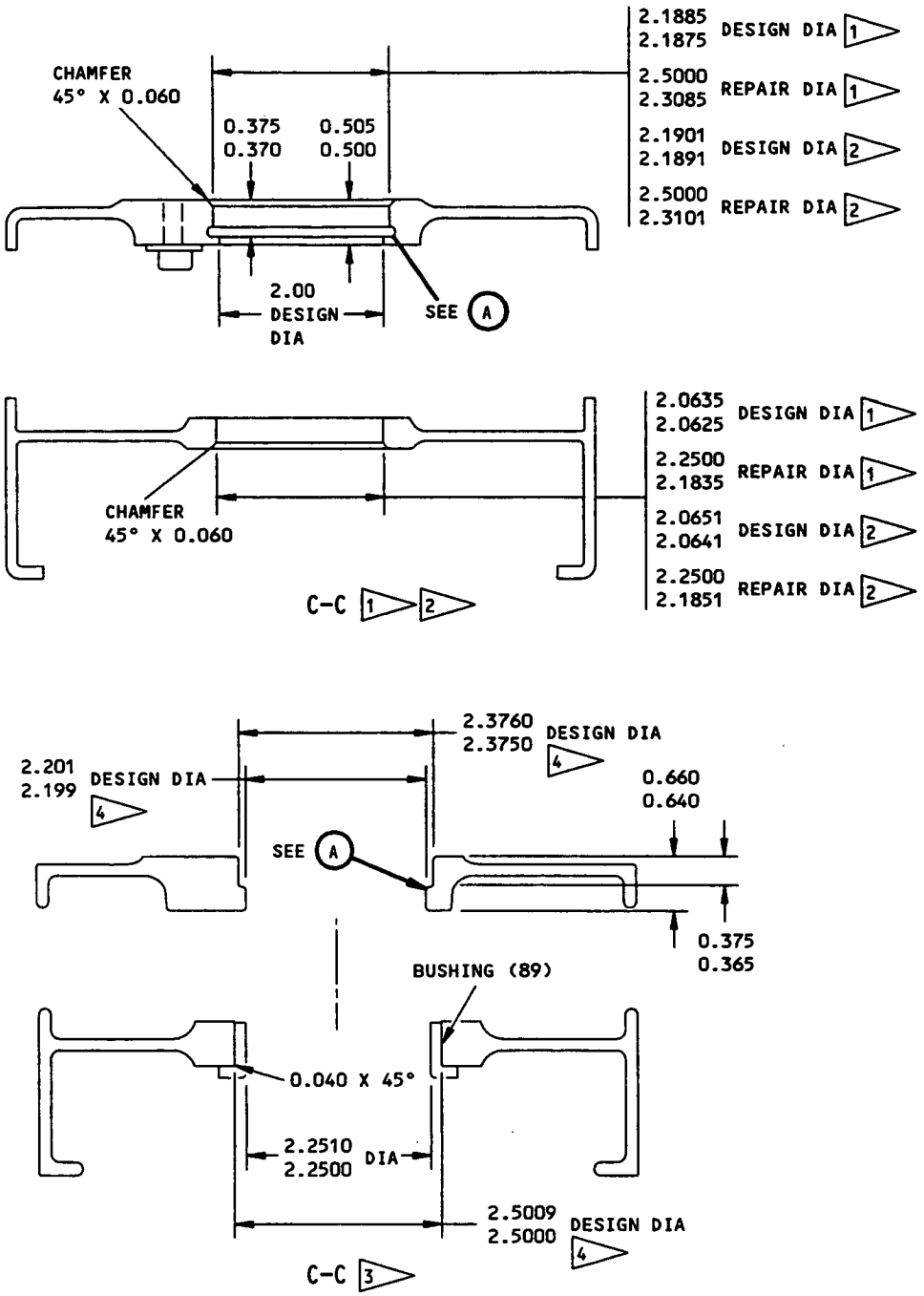


1 HOUSING (88), 65-1642-10

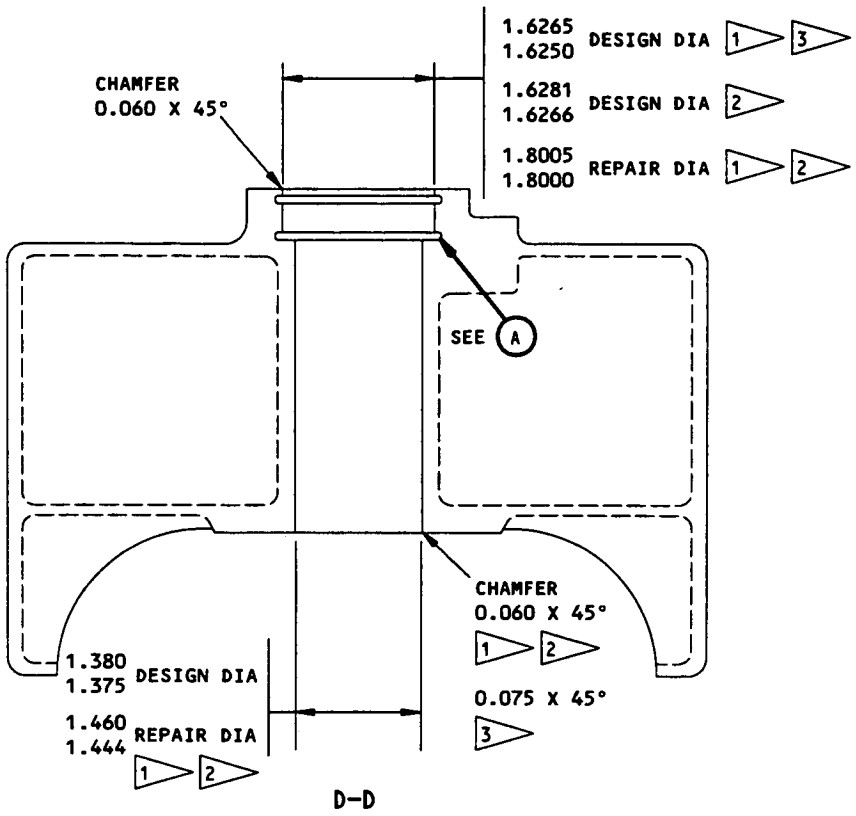
2 HOUSING (88), 65-1642-34,-35

3 HOUSING (88), 65-1642-44,-47

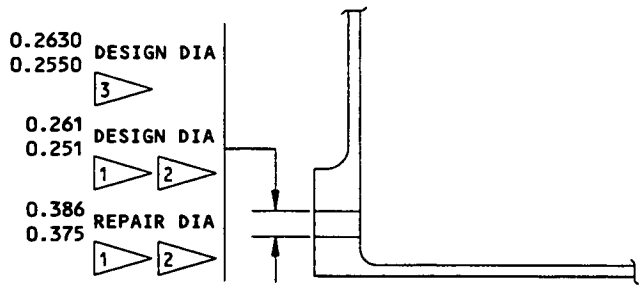
4 CONTACT BOEING TO COORDINATE REPAIRS FOR BORES INDICATED.

HOUSING (88, FIG. 1102)

Handle Mechanism Housing Repair
Figure 401 (Sheet 3)



D-D



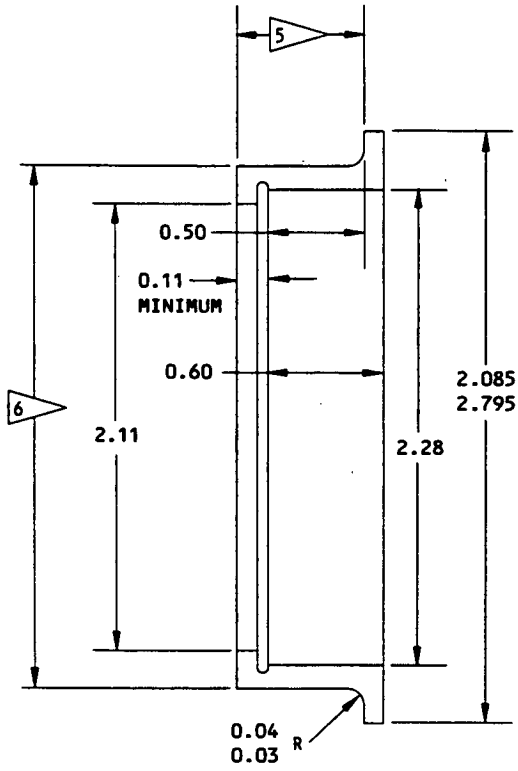
E-E

1 HOUSING (88), 65-1642-10
2 HOUSING (88), 65-1642-34,-35
3 HOUSING (88), 65-1642-44,-47

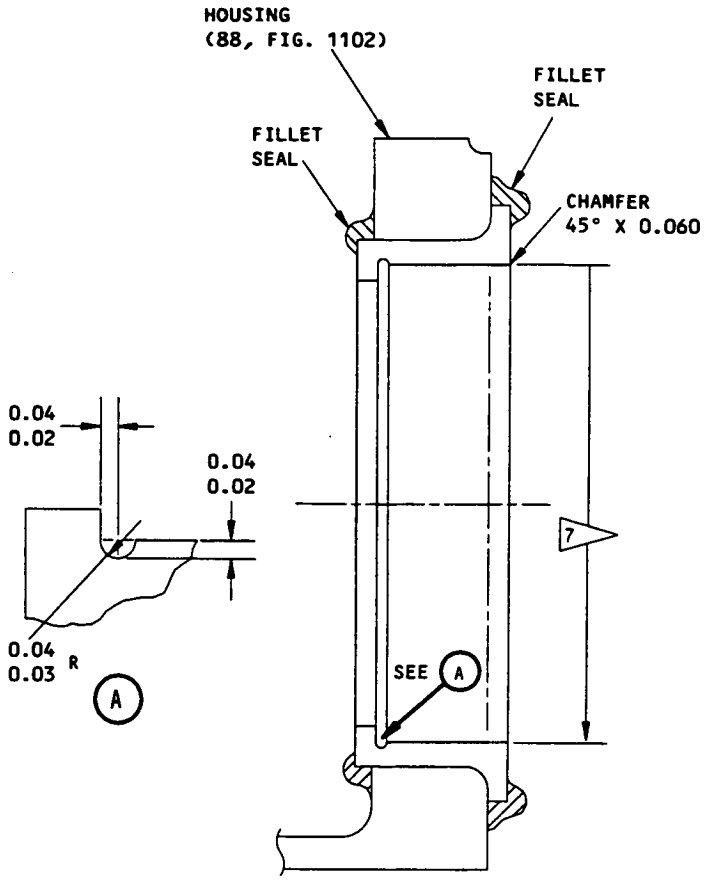
ALL DIMENSIONS ARE IN INCHES

HOUSING (88, FIG. 1102)

Handle Mechanism Housing Repair
Figure 401 (Sheet 4)



SLEEVE FABRICATION



SLEEVE 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.

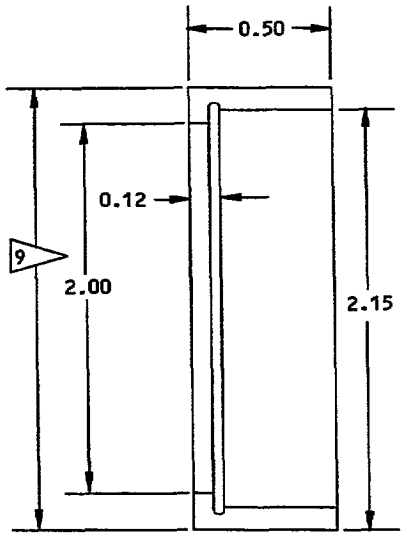
5 0.06-0.10 GREATER THAN THICKNESS OF HOUSING TO PERMIT APPLICATION OF SEALANT AFTER SLEEVE INSTALLATION

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

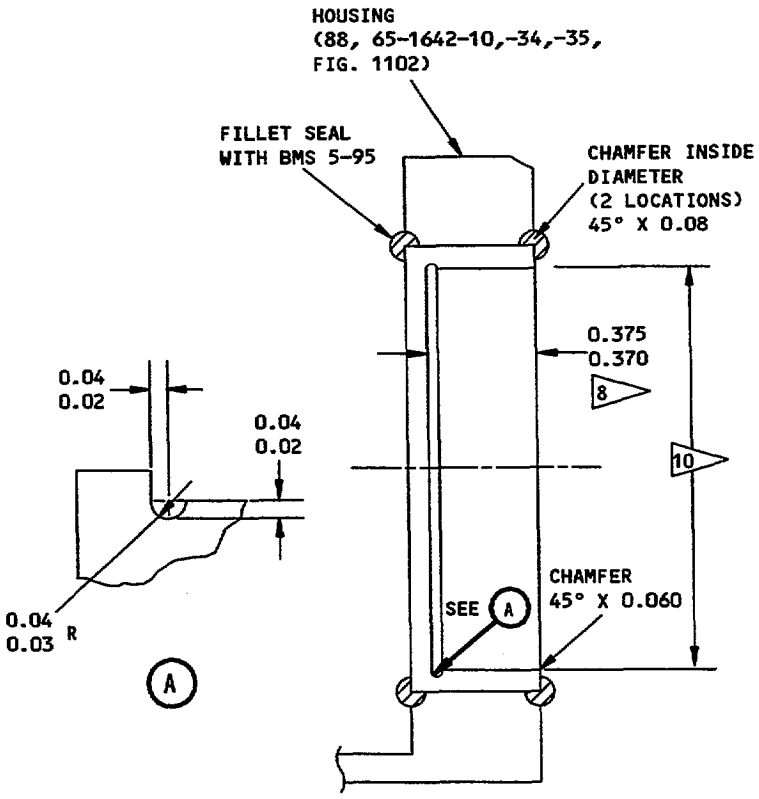
7 DESIGN DIA OF HOUSING (88, 65-1642-10,-34,-35, FIG. 1102) BORE FOR BEARING (86, BACB10FR25, FIG. 1102) MACHINE AFTER INSTALLATION

REPAIR SLEEVE FOR BEARING (86, BACB10FR25 FIG. 1102) BORE

Handle Mechanism Housing Repair
Figure 401 (Sheet 5)



SLEEVE FABRICATION



SLEEVE 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.

8 CONTROLLING DIMENSION FOR BEARING DEPTH

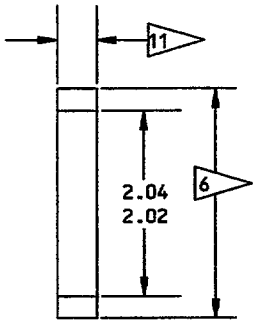
9 FINAL SLEEVE OUTSIDE DIA EQUALS REPAIR DIA OF HOUSING PLUS 0.002-0.003 INTERFERENCE.

10 DESIGN DIA OF HOUSING (88, 65-1642-10,-34,-35, FIG. 1102) BORE FOR BEARINGS (82, BACB10BW23, FIG. 1102). MACHINE AFTER INSTALLATION.

REPAIR SLEEVE FOR BEARING (82, BACB10BW23, FIG. 1102) BORES

Handle Mechanism Housing Repair
Figure 401 (Sheet 6)

L05926



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

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

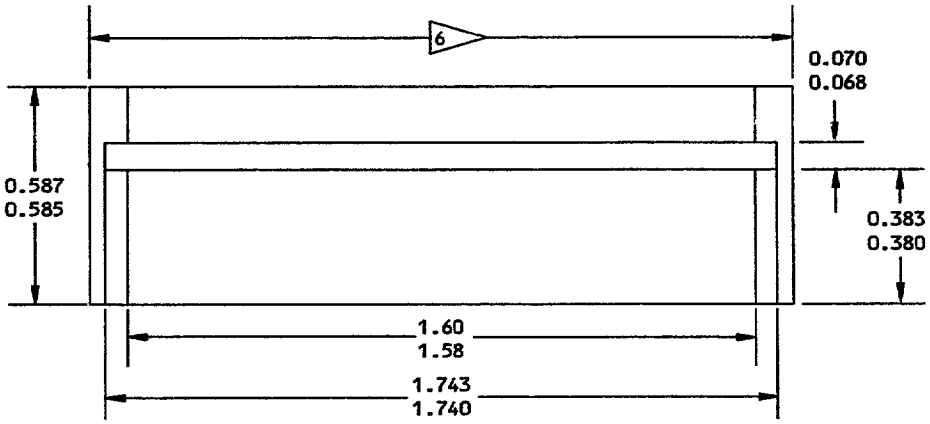
125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

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 (81) BORES - APPLICABLE TO HOUSINGS (88, 65-1642-10,-34,-35, FIG. 1102) ONLY



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

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

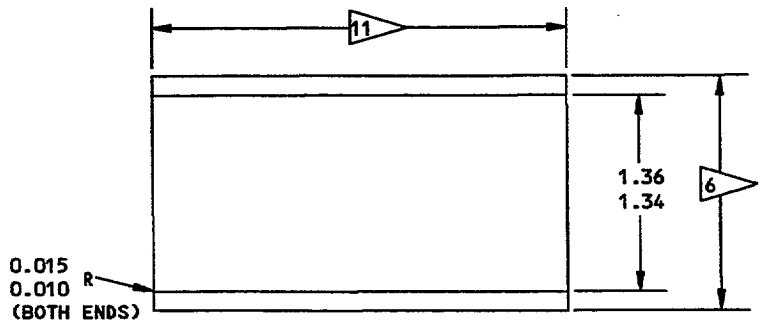
MATERIAL: AL-NI-BRONZE

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 (85) BORE

Handle Mechanism Housing Repair
Figure 401 (Sheet 7)



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

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

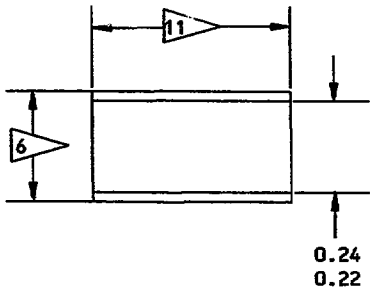
125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: AL ALLOY 7075-T6

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

ALL DIMENSIONS ARE IN INCHES.

REPAIR SLEEVE FOR FITTING HOUSING (36) BORE



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

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

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: AL ALLOY 7075-T6

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

ALL DIMENSIONS ARE IN INCHES.

REPAIR SLEEVE FOR MOUNTING HOLES

Handle Mechanism Housing Repair
Figure 401 (Sheet 8)

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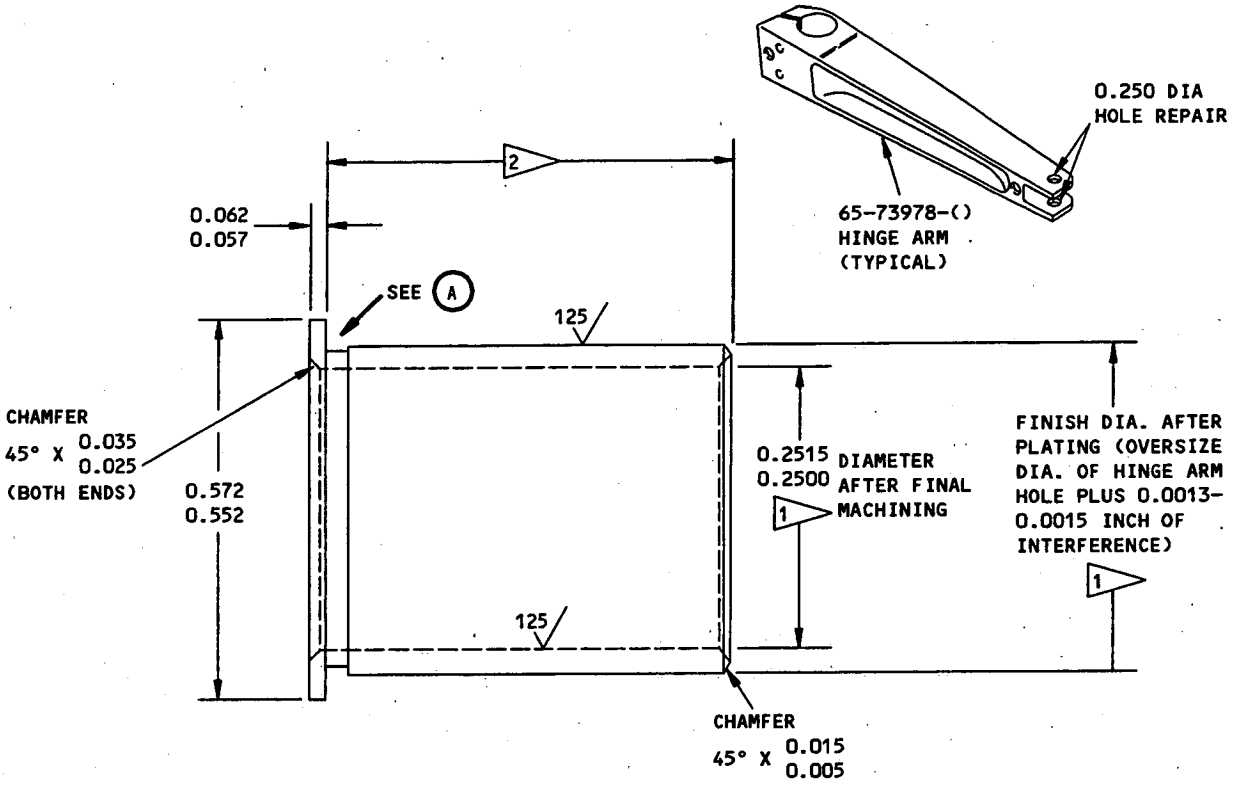


ALTERNATIVE RELIEF TYPES

(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

(1) Machine the holes as necessary to a maximum diameter of 0.375 inch (+0.0005/-0.0000) to remove defects. The surface roughness of the hole must be 125 microinch or better.

(2) Chamfer 0.035/0.045 inch by 45 degrees each side of the machined holes.

(3) Do a penetrant check of the machined surfaces as specified in SOPM 20-20-02 to make sure there is no corrosion, cracks, pits or other defects.

(4) Chemical treat the machined areas as specified in SOPM 20-43-03.

(5) Make a flanged bushing as specified in Fig. 401A.

(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 (8, 9, 12) and angles (19, 22) -- Alodize or chromic acid anodize and apply one coat of BMS 10-11, Type 1 primer (SRF-2.30) all over. Material: Al alloy.

(2) Clip (30) -- Zinc plate (SRF-1.305) all over. Material: AISI 301 steel.

(3) Serrated plate (44, 69-37495-1) and roller fitting (45) -- 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.

(3A) Serrated plate (44, 69-37495-501, -502) -- Chromic acid anodize and apply BMS 10-11, Type 1 primer (F-18.13). Material: Al alloy.

(4) Stop Fittings (50, 53, 65-49894-2, 56, 65-51673-2, 59, 65-51672-2, 71) -- Chromic acid anodize (SRF-2.19) all over. Material: Al alloy.

(4A) Stop fittings (53, 65-49894-4, -6, -8) -- Anodize and apply BMS 10-11, Type 1 primer (F-18.04). Materials: Al alloy.

(4B) Stop fittings (53, 65-49894-11, -12, -14) -- Cadmium plate (F-15.06) and apply BMS 10-11, Type 1 primer (F-20.02) and apply BMS 10-11, Type 2 enamel (F-21.03). Do not put primer or enamel in 0.500-0.502 dia hole. Material: 15-5 PH CRES, 150-170 kis.

(4C) Stop fitting (56, 65-51673-4, 59, 65-51672-4) -- Boric acid-Sulfuric acid anodize (F-17.35) and apply BMS 10-11, Type 1 primer (F-20.03). Do not put primer in bushing hole. Material: Al alloy.

(5) Stop fittings (62, 65, 68) -- Alodize or chromic acid anodize and apply one coat of BMS 10-11, Type 1 primer (SRF-2.30) all over. Material: Al alloy.

(6) Rods (85, 90, 66-14618-4) -- Cadmium plate exterior surfaces and apply two coats of BMS 10-11, Type 1 primer on interior surfaces (SRF-1.611) all over except no primer on threads. Material: 4130 steel, 150-170 ksi.

(6A) Rod (90, 66-14918-13) -- Apply BMS 3-8 solid film lubricant (F-19.10). Material: 15-5 PH CRES, 150-170 ksi.

(7) Rods (95 and 100) -- Alodize (F-2.742) all over and apply one coat of BMS 10-11, Type 1 primer (SRF-12.205) on exterior surface only. Material: Al alloy.

(8) Gates (114, 118) -- As follows:

(a) Gates (114, 118, 65-50572-2, -502 and 65-50573-2) -- Dow 7 treat and apply two coats of BMS 10-11, Type 1 primer (SRF-3.17 plus SRF-12.205) all over except 0.4353- and 0.25-inch diameter holes. Use "no dimensional loss" procedure for Dow finish. Primer on inside may be applied by filling and draining.

(b) Gates (114, 118, 65-50572-504 and 65-50573-502) -- Dow 17 anodize or Dow 7 treat and apply two coats of BMS 10-11, Type 1 primer (SRF-3.30) plus BMS 10-60, gloss enamel (SRF-14.9815-702) all over except in 0.4353- and 0.25-inch diameter holes. Complete coating system thickness to be 0.004 inch minimum. Use "no dimensional loss" procedure for Dow finish.

NOTE: Primer and enamel on inside may be applied by fill and drain method.

(c) Gates (114, 118, 65-50572-5) -- Apply Dow 17 anodize (F-17.12) or Dow 7 treatment to meet MIL-M-3171, Type 3. Apply two coats of BMS 10-79, Type 3 primer. Apply enamel (SRF-14.9815-702) to obtain a complete coating thickness of 0.004 inch minimum.

(d) Gates (114, 118) -- After completion of protective finish per (a), (b), or (c), hand letter or stencil letters MAG, 1/2 inch high, on inner RH surface, using BMS 10-11, Type 2 enamel, color BAC707.

(9) Hinge halves (123, 124, 126, 130, 131, 133; 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 (123, 126, 130, 133; 65C34068-( )) -- 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.

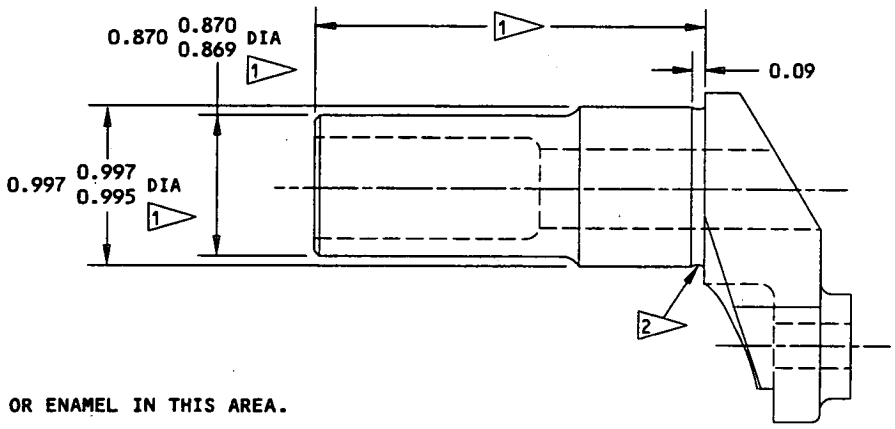
(10) Shims (111A, 111B), Seal retainers (125, 132, 134) and crank (138, 69-37418-2, -501) -- Alodize or chromic acid anodize and apply one coat of BMS 10-11, Type 1 primer (SRF-2.30) all over. Material: Al alloy.

(10A) Crank (138, 69-37418-8) -- Chemical treat or chromic acid anodize and apply BMS 10-11, Type 1 primer (F-18.05) as shown in Fig. 401B.

(10B) Crank (138, 69-37418-11) -- Boric acid-Sulfuric acid anodize and apply BMS 10-11, Type 1 primer (F-20.02) and BMS 10-11, Type 2 enamel (F-21.03) as shown in Fig. 401B.

(11) Spacer (139) -- Passivate (SRF-8.07) all over. Material: 301 CRES.

(12) Crank (147, 60-4409) -- Cadmium plate (F-15.02) all over per SOPM 20-42-05. Material: 4130 steel, 125-145 ksi.



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

CRANK (138)

Refinish Detail
Figure 401B

(13) Cranks (147, 60-4409-1; 148, 66-14531-9; 149, 60-4431-1; 150, 66-14531-11) -- Passivate (F-17.09). Material: 15-5 PH CRES, 150-170 ksi.

(14) Cranks (148, 66-14531-1; 150, 66-14531-5) -- Cadmium plate and apply one coat of BMS 10-11, Type 1 primer (SRF-1.285) all over. Material: 4130 steel, 125-145 ksi.

(15) Crank (149, 60-4431) -- Cadmium plate (0.0003 inch thick) with post-plate chromate treatment (F-1.1923). Bake three (3) hours at 375°F, ± 25°F per 20-42-05. Material: 4130 steel, 125-145 ksi.

(15A) Crank (149A, 60-4431-2) -- Apply BMS 3-8 Solid film lubricant (F-19.10). Material: 15-5 PH CRES, 150-170 ksi.

(16) Torque tube (151, 60-4406-6) -- 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 (151, 60-4406-12) -- Cadmium plate (F-15.06) external surface and 1.60 inches of internal surface on each end. Apply one coat of BMS 10-11, Type 1 primer (F-20.02) to the entire internal surface. Material: 17-7 PH CRES, 150-170 ksi.

(18) Support fittings (159, 65-49560-2; 159C, 65-49561-3; 162, 65-49561-4) -- 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 fitting (159, 65-49560-10, -16; 159C, 65-49561-8; 162, 65-49561-9) -- Anodize (F-17.05) and apply BMS 10-11, Type 1 primer (F-20.02). Do not put primer in the 1.375 inch diameter hole. Material: Al alloy.

(19) Housing (168) -- Alodize or chromic acid anodize and apply one coat of BMS 10-11, Type 1 primer (SRF-2.30) all over except 1.375 and 1.25-inch diameter hole. Material: Al alloy.

(20) Coupling Sleeves (173)

(a) 60-4365 -- Cadmium plate, (throw-in permitted) and apply BMS 10-11, Type 1 primer (SRF-1.611). (Primer thickness 0.0008 inch maximum, interior surfaces). Material: 4130 steel, 125-145 ksi.

(b) 60-4365-1 -- Cadmium plate (F-16.04) exterior surfaces. Apply phosphate coating (F-14.14) followed by two coats of BMS 10-11, Type 1 primer (F-20.03) to the interior surfaces. Material: 4130 steel, 125-145 ksi.

(c) 60-4365-3 Cadmium plate (F-15.06), (throw in permitted). Material: 15-5PH or 17-7PH CRES, 150-170 ksi.

(21) Plug (174), attach fittings (195 and 202) -- Alodize or chromic acid anodize and apply one coat of BMS 10-11, Type 1 primer (SRF-2.30) all over. Material: Al alloy.

(22) Hinge link pin (177)

(a) 66-14527-1 -- Cadmium plate (F-1.191) all over, except 0.0002-0.0004 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) 66-14527-2 -- Cadmium plate (F-1.191); 0.0002-0.0004 inch plating thickness in the spline area. Material: 4340 steel, 125-145 ksi.

(c) 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.

(d) 66-14527-6 -- Cadmium plate (F-15.06) per SOPM 20-42-05. Material: 15-5 PH CRES, 150-170 ksi.

(23) Spring (178) -- Cadmium plate (F-1.20) all over.

(24) Hinge arm (183) -- 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 holes. Material: Al alloy.

(25) Hinge arm (186)

(a) 65-73978-4, -14 -- Chemical treat or chromic acid anodize and apply BMS 10-11, Type 1 primer (SRF-2.30). Apply BMS 10-11, Type 2 enamel (F-21.03). Material: Al alloy.

(b) 65-73978-10, -12 -- Chemical treat or chromic acid anodize and apply BMS 10-11, Type 1 primer (F-18.05). Apply BMS 10-11, Type 1, color 702 white enamel (F-21.25). Material: Al alloy.

(c) 69-17952-20 -- Chemical treat or chromic acid anodize and apply BMS 10-11, Type 1 primer (SRF-2.30). Material: Al alloy.

(26) Hinge supports (198, 205) -- 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.

(27) Door stop pin (208) -- Cadmium plate (F-1.1923) all over. Material: 4130 or 4340 steel, 160-180 ksi.

(28) Cover (211) -- Apply Alodine 1000 (SRF-14.01) all over. Material: Al alloy.

B. Fig. 1102

(1) Washer (5) -- Cadmium plate (F-1.1923) all over.

(2) Outer handle (9, 90-7879-1), and nut (16) -- Chromic acid anodize (F-2.20) all over. Material Al alloy.

(2A) Outer handle (9, 90-7879-6) -- Boric acid-Sulfuric acid anodize (F-17.29). No substitutes allowed. Material: Al alloy.

(2B) Outer handle (9, 90-7879-10) -- Sulfuric acid anodize (F-14.2998). Material: Al alloy.

(3) Cam (11) -- Cadmium plate (F-4.20) all over. Material: Alum-Bronze or beryllium copper.

(4) Sleeve (12) -- Apply dry lubricant BMS 3-8, class A (F-19.10) all over 0.0002 to 0.0005 inch thick. Material: Al-Ni-Bronze.

(5) Washer (14) -- Cadmium plate (F-4.201) all over. Material: Al-Ni-Bronze.

(6) Spring (17) -- Cadmium plate (F-1.1923) all over.

(7) Shaft (19, 60-4455-1, -2) -- Passivate (F-8.07) all over. Apply dry lubricant BMS 3-8, class A (F-19.10) on 1.078-inch diameter shaft. Material: 303 CRES.

(7A) Shaft (19, 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: 15-5 PH CRES, 150-170 ksi.

(8) Guide (22), seal plate (32) -- Alodize or chromic acid anodize and apply one coat of BMS 10-11, Type 1 primer (SRF-2.30) all over. Material: Al alloy.

(9) Control cam (26, 69-34971-3, -5, 65-44065-9) -- 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 omit primer and enamel in bores, on splines and on roller contact surfaces. Material: Al alloy.

(9A) Control cam (26, 69-34971-7) -- Chemical treat or chromic acid anodize and apply BMS 10-11, Type 1 (SRF-2.30). Do not put primer and enamel in bores, on splines or on roller contact surfaces. Material: Al alloy.

(9B) Control cam (26, 65-44065-10) -- Chromic acid anodize and apply BMS 10-11, Type 1 primer (F-18.13) and apply BMS 10-11, Type 2 enamel (F-21.03). Do not put primer and enamel in bores, on splines or on roller contact surfaces. Material: Al alloy.

(10) Housing (36) -- As follows:

(a) Housing (36, 90-7820-1) -- Cadmium plate (F-1.1923) all over, except apply dry lubricant BMS 3-8, class A (F-19.10) in 1.250-inch bore. Material: 4130 steel, 125-145 ksi.

(b) Housing (36, 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-inch ID and 63-microinch finish. Material: 4130 steel, 125-145 ksi.

(11) Special Nut (38)

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

(b) 60-4405-1 -- Chromic acid anodize (F-17.04) all over. Material: Al alloy.

(12) Torque tube (42)

(a) 90-6753-5 -- Cadmium-titanium plate (F-1.20) the threaded areas only. Cadmium plate (throw-in permitted) all other surfaces but the threaded areas, and apply BMS 10-11, Type 1 primer (SRF-1.611). The outside diameters of the tubes must be 1.3750-1.3736 and 1.5618-1.5606 inches after plating. Material: 4340 steel (4135 steel is optional), 125-145 ksi.

(b) 90-6753-10 -- Cadmium-titanium plate (F-1.20) the threaded areas only. Cadmium plate (F-16.04) (throw-in permitted) all exterior surfaces but the threaded areas. The outside diameters of the tubes must be 1.3750-1.3736 and 1.5618-1.5606 inches after plating. Apply phosphate coating (F-14.14) and BMS 10-11, Type 1 primer (F-20.03) on the inside diameter. Material: 4340 steel (4135 steel is optional), 125-145 ksi.

(c) 90-6753-17 -- Cadmium-titanium plate (F-1.20) the threaded areas only. Cadmium plate (F-15.02) (throw-in permitted) all exterior surfaces but the threaded areas. The outside diameters of the tubes must be 1.3750-1.3736 and 1.5618-1.5606 inches after plating. Apply BMS 10-11, Type 1 primer (F-20.02) to the inside diameter. Material: 17-7 PH CRES (15-5 PH CRES is optional), 150-170 ksi.

(d) 90-6753-22 -- Cadmium-titanium plate (F-1.20) the threaded areas only. Cadmium plate (F-15.02) (throw-in permitted) all of the exterior surfaces but the threaded areas. The outside diameters of the tubes must be 1.3750-1.3736 and 1.5618-1.5606 inches after plating. Apply BMS 10-11, Type 1 primer (F-20.02) to the inside diameter. Material: 17-7 PH CRES (15-5 PH CRES is optional), 180-200 ksi.

(13) Rod (51) -- Cadmium plate (F-1.32, which replaces SRF-1.1923) exterior and apply MIL-C-11796 corrosion preventive compound (F-1.73) to interior surfaces. Plating throw-in allowed on interior. Material: 8630 steel, 150-170 ksi.

(14) Crank (52, 69-17330-1) -- Cadmium plate (F-1.191) all over. Material: 4130 or 8630 steel, 125-145 ksi.

(14A) Crank (52, 69-17330-3) -- Passivate (F-17.25, which replaces F-17.09). Material: 15-5PH CRES, 150-170 ksi.

(15) Washer (55) -- Cadmium plate (F-1.1929) all over. Material: 1020, 1025 or 4130 steel.

(16) Crank (58)

(a) 65-54024-3 -- Chemical treat or chromic acid anodize and apply BMS 10-11, Type 1 primer (SRF-2.30) all over but no primer on splines. Material: Al alloy.

(b) 65-1933-3 -- Passivate (F-8.07) all over. Material: 15-5PH CRES, 180-210 ksi.

(c) 65-1933-504, -506 -- Chromic acid anodize and apply BMS 10-11, Type 1 primer (F-18.13). Apply BMS 10-11, Type 1 primer (F-20.02). Do not apply primer on the splines. Material: Al alloy.

(17) Crank (60) -- Alodize or chromic acid anodize and apply one coat of BMS 10-11, Type 1 primer apply (SRF-2.30) all over except no primer on splines. Material: Alum alloy.

(18) Crank arm (67)

(a) 69-38733-2 -- Chromic acid anodize (F-2.26) all over followed by one coat of BMS 10-11, Type 1 primer (SRF-12.05), except no primer on bearing surfaces and splines. Material: Alum alloy.

(b) 90-7815-3 -- Cadmium plate exterior surfaces and apply two coats of BMS 10-11, Type 1 primer on interior surfaces (SRF-1.611), except single plating thickness to be 0.0002 to 0.0003 inch. Bearing surface diameters to be 1.3110-1.3120 and 1.4360-1.4370 inch after plating. Material: 4340 steel, 150-170 ksi.

(c) 90-7815-19, -21 -- Chromic acid anodize and apply BMS 10-11, Type 1 primer (F-18.13). Apply BMS 10-11, Type 1 primer (F-20.02). Do not apply primer on the splines, the 1.3110-1.3120 inch outside diameter surface, or the 1.4360-1.4370 inch outside diameter surface. Material: Al alloy.

(d) 90-7815-27, -29 -- Boric acid - sulphuric acid anodize or chromic acid anodize (F-17.35) and apply BMS 10-11, Type 1 primer (F-20.03). Do not apply primer on the splines, the 1.3110-1.3120 inch outside diameter surface, or the 1.4360-1.4370 inch outside diameter surface. Material: Al alloy

(19) Crank arm (74).

(a) 69-38732-2 -- Chromic acid anodize (F-2.26) all over followed by one coat of BMS 10-11, Type 1 primer (SRF-12.205), except no primer on bearing surfaces and splines. Material: Alum alloy.

(b) 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 single plating thickness to be 0.0002 to 0.0003 inch. Bearing surface diameters to be 1.3110-1.3120 and 1.4360-1.4370 inch after plating. Material: 4340 steel, 150-170 ksi.

(c) 90-7815-20, -22 -- Chromic acid anodize and apply BMS 10-11, Type 1 primer (F-18.13). Apply BMS 10-11, Type 1 primer (F-20.02). Do not apply primer on the splines, the 1.3110-1.3120 inch outside diameter surface, or the 1.4360-1.4370 inch outside diameter surface. Material: Al alloy.

(d) 90-7815-28, -30 -- Boric acid - sulphuric acid anodize or chromic acid anodize (F-17.35) and apply BMS 10-11, Type 1 primer (F-20.03). Do not apply primer on the splines, the 1.3110-1.3120 inch outside diameter surface, or the 1.4360-1.4370 inch outside diameter surface. Material: Al alloy

(20) Bearing retainer (80) -- Alodize or chromic acid anodize and apply one coat of BMS 10-11, Type 1 primer (SRF-2.30) all over. Material: Al alloy.

(21) Housing (88, 65-1642-10) -- Dow 17 anodize per SOPM 20-43-02 (or Dow 7 treat) and apply three coats of BMS 10-11, Type 1 primer per SOPM 20-41-02 (SRF-3.71) all over except in holes Dow 17 anodize per SOPM 20-43-02 but omit primer.

(22) Housing (88, 65-1642-34, 65-1642-35) -- Dow 17 anodize per SOPM 20-43-02 (or Dow 7 treat) and apply two coats of BMS 10-11, Type 1 primer per SOPM 20-41-02 (F-18.10) and two coats BMS 10-60 color white gloss enamel (SRF-14.9812) all over except in holes Dow 17 anodize per SOPM 20-43-02 (or Dow 7 treat) and apply one coat of BMS 10-11, Type 1 primer per SOPM 20-41-02 (F-18.09). Omit enamel from holes. Material: Magnesium.

(23) Housing (88, 65-1642-44, -47) -- Dow 17 anodize (F-17.12) and apply BMS 10-11, Type 1 primer (F-20.03). Material: Magnesium.

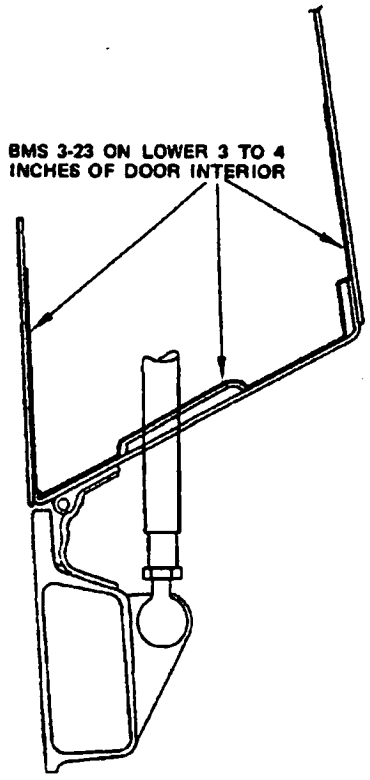
(24) Bushing (89) -- Cadmium plate (F-15.02). Cadmium plate is optional in the bore. Material: Al-Ni-Br.

(25) Filler (95, 96) -- Boric acid-Sulfuric acid anodize (F-17.31) and apply BMS 10-11, Type 1 primer (F-20.03). Material: Al alloy.

(26) 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. 402.

(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 402

3. Replacement

A. Replace springs (178, Fig. 1101 and 17, Fig. 1102) if requirements of Fig. 301 are not met.

B. If bushings (51, 54, 57, 60, 63, 66, 69, 72, 115, and 119, Fig. 1101) require replacement, proceed as follows:

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

(2) Apply BMS 10-11, Type 1, primer to OD of new bushing and install bushing in bore.

(3) Flare thin end of bushing such that bushing flange and flared material fit snug against faying surfaces.

(4) After flaring bushing (115 and 119) in gate assemblies (112, P/N 65-50572-503, 116, P/N 65-50573-501), apply a fillet seal of BMS 5-95 around flange as follows:

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

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

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

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

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

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

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

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

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

C. If necessary to replace bushings (113, 117, Fig. 1101), remove old bushing and install new bushing with wet BMS 10-11, Type 1 primer, per SOPM 20-50-03.

D. Replace bushing (89, Fig. 1102) in housing (88, 65-1642-42, -46), if necessary, as follows:

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

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

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

E. If hinge halves (126 or 133) require replacement, apply a corrosion protection faying surface seal of sealant, BMS 5-95, class B, between hinge half and gate assembly (112 or 116).

F. If retainer for seal (216) requires replacement, apply a corrosion protection faying surface seal of sealant, BMS 5-95, class B, between seal retainer and gate assembly (112 or 116).

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

H. Replace all parts damage beyond simple repair or refinish.

I. Replace damaged torque tube (42) or crank (52) using standard industry practices. Maintain linear and angular dimensions given in Fig. 403.

J. Apply any suitable parting agent to exposed heel of hinge (120) 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.

K. If nutplates (91, 92, 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-19.48). Coat rivet shank with sealant prior to insertion. Rivet (94) to be flush to +0.010 inch of casting face.

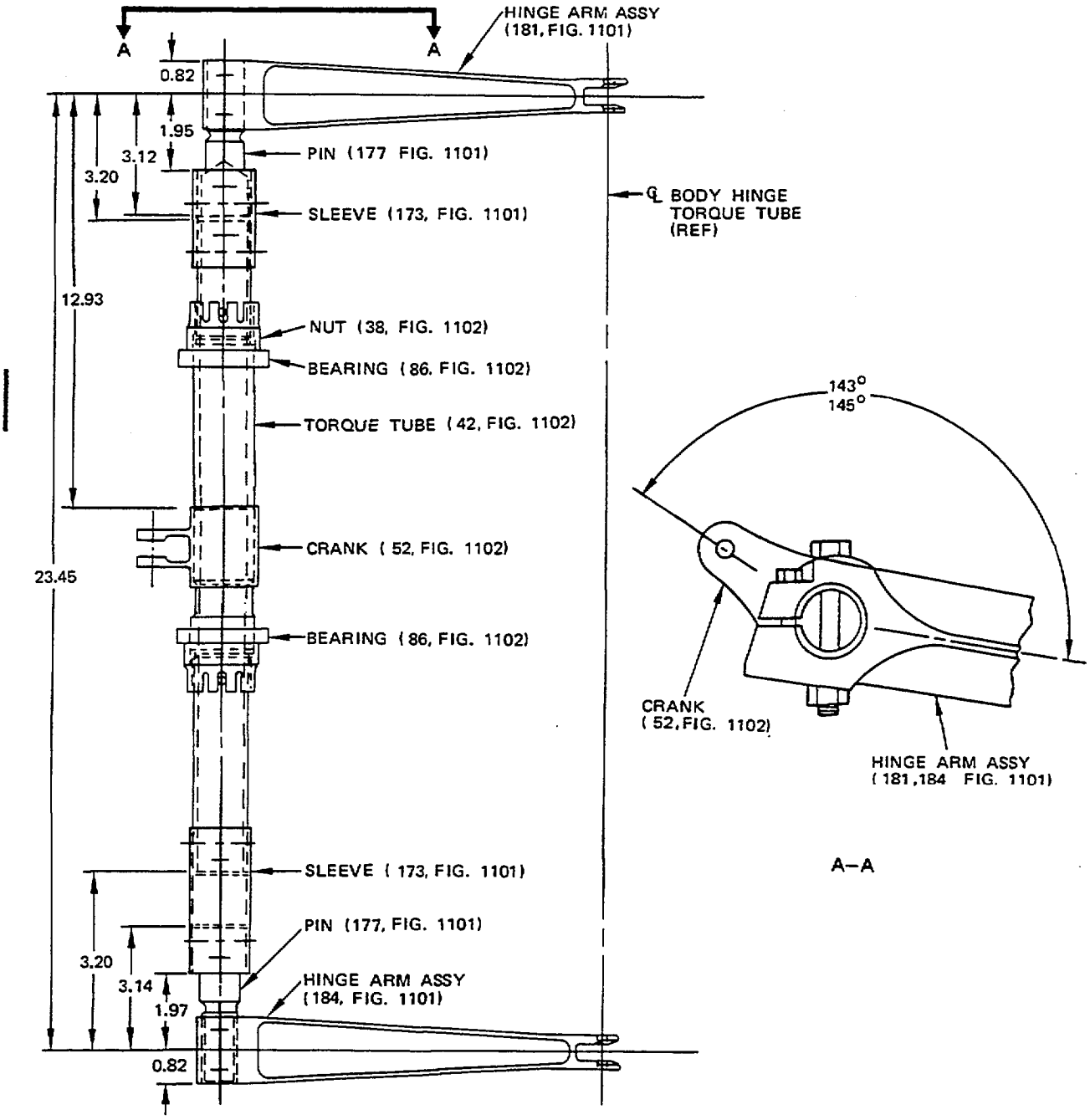
4. Materials

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

B. Enamel, White Gloss -- BMS 10-60

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

D. Corrosion Preventive Compound -- LPS No. 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 according to SOPM 20-50-01 and install bearings per SOPM 20-50-03.

2. Install bearings (86, Fig. 1102) in housing (87) with wet BMS 10-11, Type 1 primer (use BMS 5-95 sealant on assemblies modified per SB 52-1094). Fillet seal with BMS 5-95 sealant after bearing installation as shown in Fig. 501.

3. Install bearing (85) with retaining ring (84). Install bearing (85) with wet BMS 10-11, Type 1 primer and install retaining ring (84) with MIL-C-11796, class 3 corrosion preventive compound.

4. Install bearings (81, 82) with wet BMS 5-95 sealant, apply MIL-C-11796, class 3 corrosion preventive compound to faying surface common to bearing retainers (80) and housing (87), install bolts (77, 78, 79) with wet BMS 5-95 sealant, and install washers (76) and nuts (75).

5. Preassemble crank assembly (61, 68) by assembling parts (62 thru 67, 69 thru 73). Install bearing unit (66, 73, BACB10BH60F9, BACB10BH60F8, BACB10BH60CF6, BACB10AF6F3H, BACB10AF6F6H) with MIL-C-11796, class 3 corrosion preventive compound. Install bearing unit (66, 73, BACB10FK6F6HS, KRP141500VT6-6) with wet BMS 5-95 sealant (SOPM 20-50-03). Install the washers as follows:

   A. For crank assemblies (61, 69-38733-1; 68, 69-38732-1), install washers (64, 65, 71, 72) as follows:

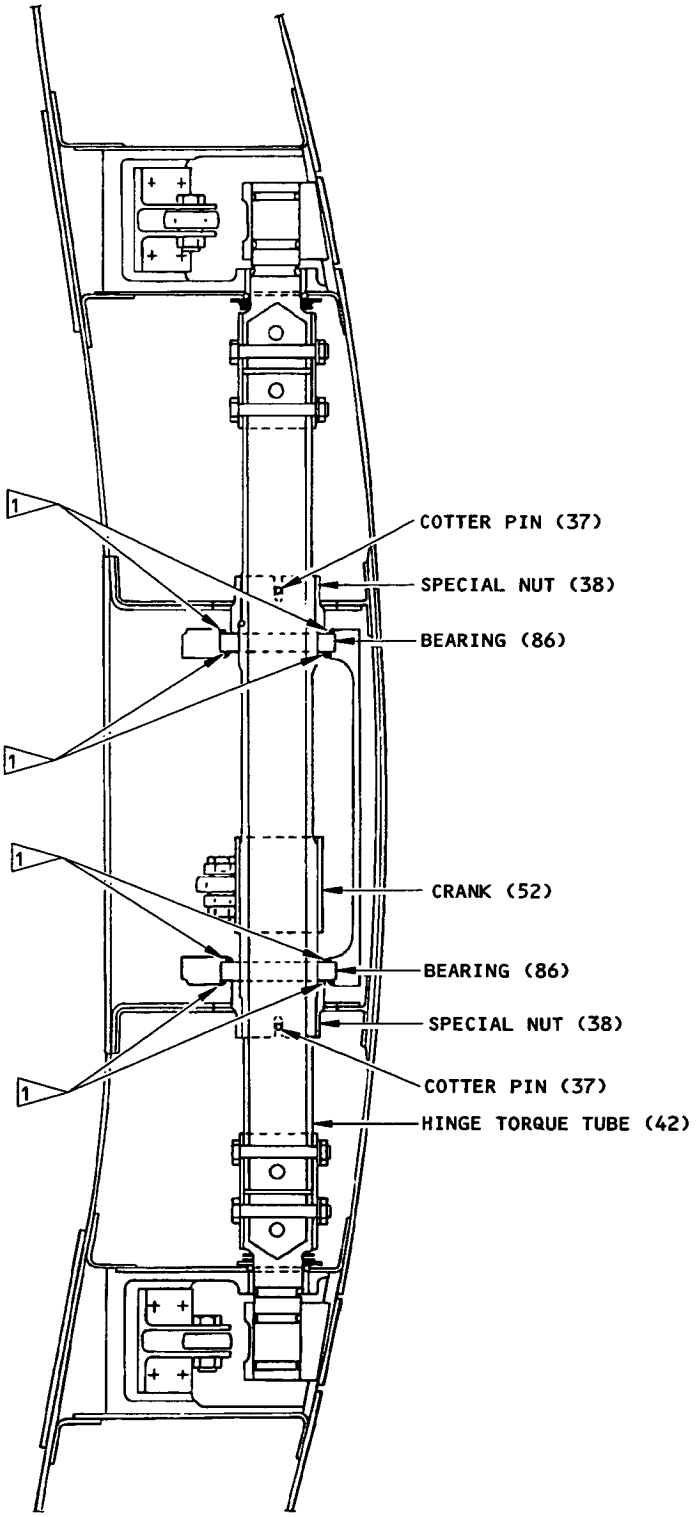
      (1) If bearing (66, 73, BACB10BH60F9) is used: Install four washers (65, 72) adjacent to the head of the bearing and one washer (64, 71) adjacent to the nut (68, 75).

      (2) If bearing (66, 73, BACB10H60F8) is used: Install two washers (65, 72) adjacent to the head of the bearing and one washer (64, 71) adjacent to the nut (63, 70).

   B. For crank assemblies (61, 90-7815-1, -15, -17, -23, -25, 68, 90-7815-4, -16, -18, -24, -26), install washers (64A, 65, 71A) as follows:

      (1) Apply BMS 10-11; Type 1 primer to the washers (64A, 71A) and install one washer (64A, 71A) adjacent to the head of the bearing (66, 73) and a maximum of five washers (64A, 71A) adjacent to the nut (63, 70) to get the correct nut torque and install the cotter pin. Tighten the nut (63, 70) to 95-170 pound-inches (threads not lubricated) or 45-80 pounds-inches (lubricated threads).

6. Apply a thin layer of MIL-C-16173, Grade 2 corrosion preventive compound on internal and external mating surfaces of crank assemblies (58, 60, 61, 68). Prealign crank assemblies (58, 60) and spacer (59) in housing (87) and insert crank assemblies (61, 68). Install bolts (56, 57), washers (54, 55) and nuts (53) with MIL-C-11796, Class 3 corrosion preventive compound on mating surfaces.



1 APPLY A FILLET SEAL WITH BMS 5-95 SEALANT (SOPM 20-50-19) AFTER BEARING INSTALLATION

Sealant Application
Figure 501

W40631

7. Install rod assembly (47, Fig. 1102)

   A. Adjust the length of the rod assembly, between bearing centers, to 6.97-6.99 inches (66-14302-1) or 6.95-6.97 inches (69-39176-1). To do this, loosen nut (49) and turn the adjacent rod end (50) in or out as necessary to get this length. Finish with the two rod ends 90 degrees apart, as shown. Then tighten nut (49).

   B. Apply MIL-C-11796, Class 3 corrosion preventive compound to the bores of the rod end bearings, the washer (44) faces, and the shank of bolt (46).

   C. Put the end of the rod assembly into housing (87). Connect the rod assembly to crank (58) with bolt (46), washer (44). (Crank (58) includes a nutplate on the mating lug.)

8. Attach crank (52) to rod assembly (47) with a bolt (45) that has MIL-C-11796, Class 3 corrosion preventive compound, washer (44), and nut (43).

9. Slide torque tube (42) into housing (87) and crank (52) and attach with bolts (41), washers (40), and nuts (39). Assemble the torque tube with a thin layer of MIL-C-16173, Grade 2 corrosion preventive compound on both internal and external mating surfaces. On assemblies modified per SB 52-1094, brush or swab mating surfaces of torque tube (42) and bearings (86) with BMS 10-11, Type 1 primer only and tighten nuts (39) to 65-80 lb-in.

   NOTE: For door assemblies 65-45871-114, -124, -132 and door assemblies 65-45871-2, -517, -523 modified per SB 52-1094, nuts (39) are intended to bottom out on bolt threads in order to avoid clamp up. A gap between crank (52) and washers (40) of up to 0.016 inch is acceptable. If greater gaps occur, install additional washers (40) as required.

10. Install nuts (38) on torque tube (42) but do not tighten nuts (38) or install cotter pins (37). Torque tube will be adjusted on installation of door in airplane. Assemble nuts (38) with a thin layer of MIL-C-16173, grade 2 corrosion preventive compound on both internal and external mating threads.

11. Preassemble parts (6 thru 19) as follows:

    A. Put pin (18) and spring (17) in shaft (19). Screw nut (16) in shaft (19) with a thin layer of MIL-C-16173, grade 2 corrosion-preventive compound on both the internal and mating threads with wrench F70038 and install lock ring (15).

    B. Put washer 30-3019 (14) on a 10-32 bolt and screw the bolt in pin 30-3013-1 (18). With the 10-32 bolt, pull spring-loaded pin (18) until the slot in washer (14) is aligned with the hole in pin (18). Install retaining spring pin (13) and remove the 10-32 bolt. Turn washer 30-3019-1 (14) on pin 30-3013-2 (18) until hole in washer (14) and pin (18) align, and then install spring pin (13). Install washer (14) with wet BMS 10-11, Type 1 primer.

    C. Put shaft (19) in housing (12) with MIL-C-11796, class 3 corrosion-preventive compound on mating surfaces, then put housing in cam (11).

    D. Add shims (10) between housing (12) and outside handle (9) as required and attach all parts with bolts (8), washers (7), and nuts (6). Install bolts (8) with dry BMS 10-11, Type 1 primer on the countersink area of the bolt holes in handle (9).

12. Install attach fitting (202, Fig. 1101) in hinge support (205) using washers (201) and bolts (200). Do not tighten bolts (200) as attach fitting (202) will be removed on installation of door in airplane. Press fit bushing (204) in hinge support (205).

13. Install attach fitting (195) in hinge support (198) using washers (194) and bolts (193). Do not tighten bolts (193) as attach fitting (195) will be removed on installation of door in airplane. Press fit bushing (197) in hinge support (198) flush with outside of hinge support.

14. Install upper and lower hinge support assemblies (192, 199) in door structure using seal washers (191), bolts (189, 190), washers (188), and nuts (187). Tighten nuts (187) and bolts (189, 190) to a torque range of 13 to 60 pound-inches.

15. Slide springs (178), washers (179), and packings (180) on hinge link pins (177). Lubricate packings (180) with MIL-G-4343 grease as specified in SOPM 20-50-07, prior to installation.

16. Position hinge arm assemblies (181, 184) in hinge support assemblies (192, 199). Insert hinge link pins (177) in support assemblies (192, 199) and hinge arm assemblies (181, 184). Assemble hinge link pins (177) with thin coat of corrosion preventive compound, MIL-C-16173, grade 2, on both internal and external mating surfaces. Install washers (176) and bolts (175).

17. Install plugs (174) in hinge support assemblies (192, 199) and seal with Type 40 adhesive (SOPM 20-50-12).

18. Prepare for installation of handle mechanism in door structures as follows:

    A. Slide coupling sleeves (173) on torque tube (42, Fig. 1102).

    B. Insert packing (33) and lubricator fitting (35) in housing (36). Insert packing (30) inside seal plate (32). Lubricate packings (30, 33) with AMS-SAE-G-4343 grease (SOPM 20-50-07).

19. Install housing assembly (34) and handle mechanism assembly (87) as follows:

    A. Apply BMS 10-11, Type 1 primer to the exterior surface of housing assembly (34) and, while the primer is wet, install housing assembly (34) into handle mechanism housing assembly (87) with lube fitting on the forward or aft side.

    B. Install handle mechanism housing assembly in door structure with shims (2, 3) and bolts (1). Delaminate the shims as necessary for a good fit. Apply BMS 10-11, Type 1 primer to the delaminated area of shims and let this dry before you install the shims.

    C. Apply a corrosion preventive faying surface seal of BMS 5-95, class B sealant between the mating surfaces of shims (2, 3), or the structure if shims are not used, and handle mechanism housing assembly (87).

    D. Install handle mechanism housing assembly (87) in the door structure with shims (2, 3) and bolts (1).

20. Install seal washers (29), washers (28), and bolts (27) to attach housing assembly (34). Tighten bolts (27) to 13-60 pound-inches.

21. Slide preassembled parts (6 thru 19) into bore of handle mechanism housing. Install washer (83), if required, and cam assembly (20) on shaft (19) so that bearing units (66, 73) are centered on 0.75 inch holes of cam in door-closed position. Secure cam assembly with washers (4A, 5), nut (4), and cotter pin (3A), as applicable. Install cam (20), washer (5), and nut (4) with corrosion preventive compound, MIL-C-11796, class 3. Tighten nut (4) used on shaft (19, 60-4455) to 95-110 lb-in.

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

22. Slide sleeves (173, Fig. 1101) partly on hinge pins (177) and secure with bolts (172), washers (171), and nuts (170). Install bolts (172) with heads inboard and forward. Assemble sleeves (173) with thin coat of corrosion preventive compound, MIL-C-16173, grade 2, on both internal and external mating surfaces. Tighten nuts (170, BACN10YR4CD) on bolts (172, BACB30NM4K26) to a running torque of 30-40 in-lb.

    NOTE: For door assemblies 65-45871-114, -124, -132 and door assemblies 65-45871-2, -517, -523 that have been modified per SB 52-1094, nuts (169) are intended to bottom out on bolt threads in order to avoid clamp up. A gap between sleeves (173) and washers (171) of up to 0.016 inch is acceptable. If greater gaps occur, install additional washers (171) as required.

    NOTE: Bolt (172) direction is significant to avoid threads in bearing. No substitution of the bolt (172) grip length is permitted.

23. Install lubricator fittings (158, 159B, 161, 167) in support fittings (159, 159C, 162) and housings (168) respectively. Install bearings (169) in support fittings (159, 159C, 162) and housings (168). Prior to installation of bearings (169), coat all surfaces with a light film of grease, MIL-C-23827, per SOPM 20-50-07.

24. Install housing assemblies (166) in door structure using bolts (165), washers (164), and nuts (163).

25. Install shims (155, 156), if and as required, removing 0.003 inch laminations as required to maintain 0.010 inch or less gap. Install support fitting assemblies (160, 157). Secure support fittings with bolts (154), washers (153), and nuts (152). After delamination, install shims (155, 156) with BMS 10-11, Type 1 primer either wet or dry.

26. Place rod assemblies (91, 96) inside door structure and locate fixed end near crank (60, Fig. 1102) to be connected later.

27. On assemblies modified per SB 52-1094, coat ID of bearings (169) with a light film of grease, MIL-C-23827, and mating surfaces of torque tubes (151) and cranks (147 thru 150) with BMS 10-11, Type 1, primer. Slide torque tubes (151, Fig. 1101) in door structure and cranks (147 thru 150). Secure cranks with bolts (146), washers (145), and nuts (144). For door assemblies 65-45871-114, -124, -132 and door assemblies 65-45871-2, -517, -523 that have been modified by SB 52-1094, tighten nuts (144) to 35-45 lb-in.

    NOTE: For door assemblies 65-45871-114, -124, -132 and door assemblies 65-45871-2, -517, -523, nuts (144) are intended to bottom out on bolt threads in order to avoid clamp up. A gap between cranks (147 thru 150) and washers (145) of up to 0.016 inch is acceptable. If greater gaps occur, install additional washers (145) as required.

28. Install seven washers (142) on shaft of each bearing unit (143) and install these in cranks (138). Add one washer (142) to each bearing unit shaft and install nuts (141) and cotter pins (140).

29. On assemblies modified per SB 52-1094, coat mating surfaces of cranks (138) and torque tubes (151) with BMS 10-11, Type 1 primer. Install cranks (138) in torque tubes (151). Use spacers (139), if and as required. Attach cranks with bolts (137), washers (136), and nuts (135). For door assemblies 65-45871-114, -124, -132, and door assemblies 65-45871-2, -517, -523, changed by SB 52-1094, lubricate bolts (137) with MIL-C-11796, class 3 corrosion preventive compound (SOPM 20-50-07) and tighten nuts (135) to 35-45 lb-in.

    NOTE: For door assemblies 65-45871-114, -124, -132 and door assemblies 65-45871-2, -517, -523 changed by SB 52-1094, nuts (135) are intended to bottom out on bolt threads in order to avoid clamp up. A gap between torque tubes (151) and washers (136) of up to 0.016 inch is acceptable. If greater gaps occur, install additional washers (136) as required.

30. Apply a thin layer of BMS 3-33 or MIL-G-23827 grease (SOPM 20-50-07) to hinge pins (122, 129). Join hinge halves (124, 126, 131, 133) with hinge pins (122, 129). Attach hinge pins with spring pins (121, 128). Install spring pins (121 and 128) with corrosion preventive compound, MIL-C-11796, class 3.

31. Press-fit bushings (113, 117) in gates (114, 118). Install upper and lower gate assemblies (112, 116) with applicable shims (106 thru 111 or 111A, 111B, 111C). Remove 0.003-inch laminations from shims (106 thru 111) or trim and taper shims (111A, 111B, 111C) as required to adjust the gap to the value you measured during disassembly, or 0.010 inch maximum.

32. Attach upper and lower gates (112, 116) with applicable bolts (104, 105) and washers (104A, 105A). Make sure the gap width (noted during disassembly) did not change.

33. Connect the handle mechanism to latching rods with rod assemblies (91, 96) and bolts (77, 78), washers (74, 80), and nuts (73).

34. Connect the fixed end of rod assemblies (81, 86) to latching rods with bolts (77), washers (74), and nuts (73). Put bushings (79) in the upper and lower gates.

35. Apply BMS 3-33 or MIL-G-23827 grease (SOPM 20-50-07) to rod ends (82, 87). Connect adjustable end of rod assemblies (81, 86) to upper and lower gates using bolts (76), washers (75), and nuts (73). Install bolts (76) with MIL-C-11796, class 3 corrosion preventive compound.

36. Install four washers (47), on needle bearing (48) and put this in roller fitting (45). Attach with nut (46).

37. Install serrated plate (44) on door structure and install roller fitting (45) with washers (43) and bolts (41, 42). Do not tighten bolts. Roller fitting will be adjusted on installation of door in airplane.

38. Use the B52004-1 door seal installation tool (SE52-1002 optional) to install the seal (216) in the door seal retainers. You can use soapy water to make seal installation easier. Attach the diaphragm with nylon rods (214, 215). Install rod at both ends to make a butt fit of the radius end at the centerline of the door.

39. Assemble seal (37), outer pane (36), inner pane (35), retainer (34), and seal (33). Use shims (31, 32) as necessary to compress seal (33) a maximum of 0.03 inch. Attach these parts with clips (30), screws (29), one washer (28) under head of each screw and one washer (28) under head of each nut (27).

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.

40. Install window assembly (26) in door structure with washers (25) and bolts (24).

41. Install reinforcing angle assemblies (18, 21) with bolts (15, 16), washers (14), and nuts (13, 13A).

42. Install coverplates (12) with screws (10, 11, 11A).

43. Install coverplates (8, 9) with washers (7) and screws (5, 6).

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 (118) as follows:

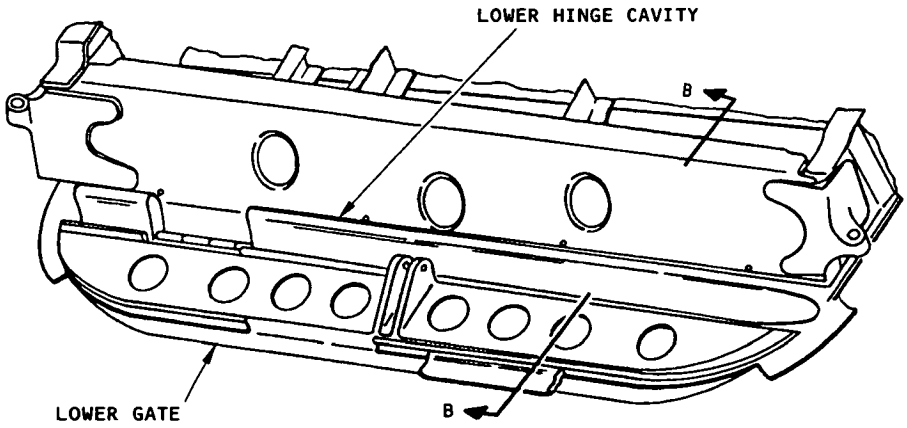
    A. Put the door in the position that it will be in when it is installed on the airplane.

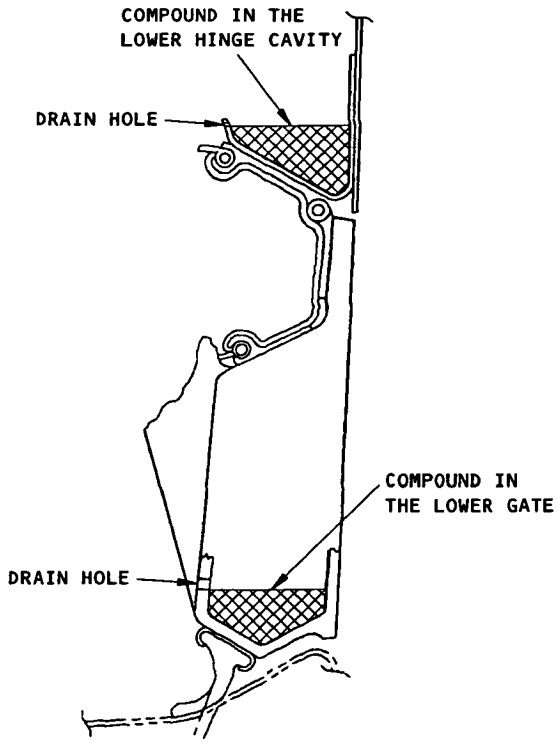
    B. Clean all surfaces that will touch the potting compound or the leveling compound (see CLEANING, step 5).

    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. 502. The compound must fill the full width of the door.





B-B

Assembly Details
Figure 502

46. Inject BMS 5-95, class B sealant into gap between seal retainers (125, 132, and 134) and structure.

47. Apply Dow Corning Q3-0121 sealant at corners of diaphragm and mechanical seal (eight places). Cover ends of seal retainers (125, 132, and 134) and nylon rods (38 and 39) generously.

48. Inject Dow Corning Q3-0121 sealant between diaphragm seal and seal retainers (134) approximately 1.50 inches long, centered on door center-line. Force seal into gap as far as possible.

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

50. Install Installation Items (Fig. 1101)

    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 shims (212 and 213) and covers (211) in position and install screws (209 and 210). Apply MIL-C-11796, class 3 corrosion preventive compound on screws (209 and 210) before installation.

    B. Install stop pins (208) and retainer springs (207).

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,			
135 *[1]	NUT	35-45	
144 *[1]	NUT	35-45	
170	NUT	30-40 *[4]	
187	NUT	13-60	
IPL FIG. 1102,			
4 *[6]	NUT	95-110 *[4]	
39 *[1]	NUT	65-80	
63 *[2]	NUT	95-170 *[4] 45-85 *[5]	
70 *[3]	NUT	95-170 *[4] 45-85 *[5]	

*[1] TORQUE SPECIFICATION APPLICABLE TO DOOR ASSEMBLIES 65-45871-114, -124, -132 AND DOOR ASSEMBLIES 65-45871-2, -517, -523 THAT HAVE BEEN MODIFIED PER SB 52-1094 ONLY.
*[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 (19, 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 (81 or 86, figure 1101)	Rod (85 or 90, figure 1101) bent, or rod end bearings (82 or 87) defective	Check and replace defective parts
B.	Binding control rod assembly (91 or 96, figure 1101)	Rod (95 or 100, figure 1101) bent, or rod end bearings (92 or 97) defective	Check and replace defective parts
C.	Loose outer handle (9, figure 1102)	Defective spring (17, figure 1102)	Replace spring
D.	Binding handle mechanism (figure 1102)	Bearings (66, 73, 81, 82, 85, or 86, figure 1102) defective, or rod (51) bent, or rod end bearing (50) 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.

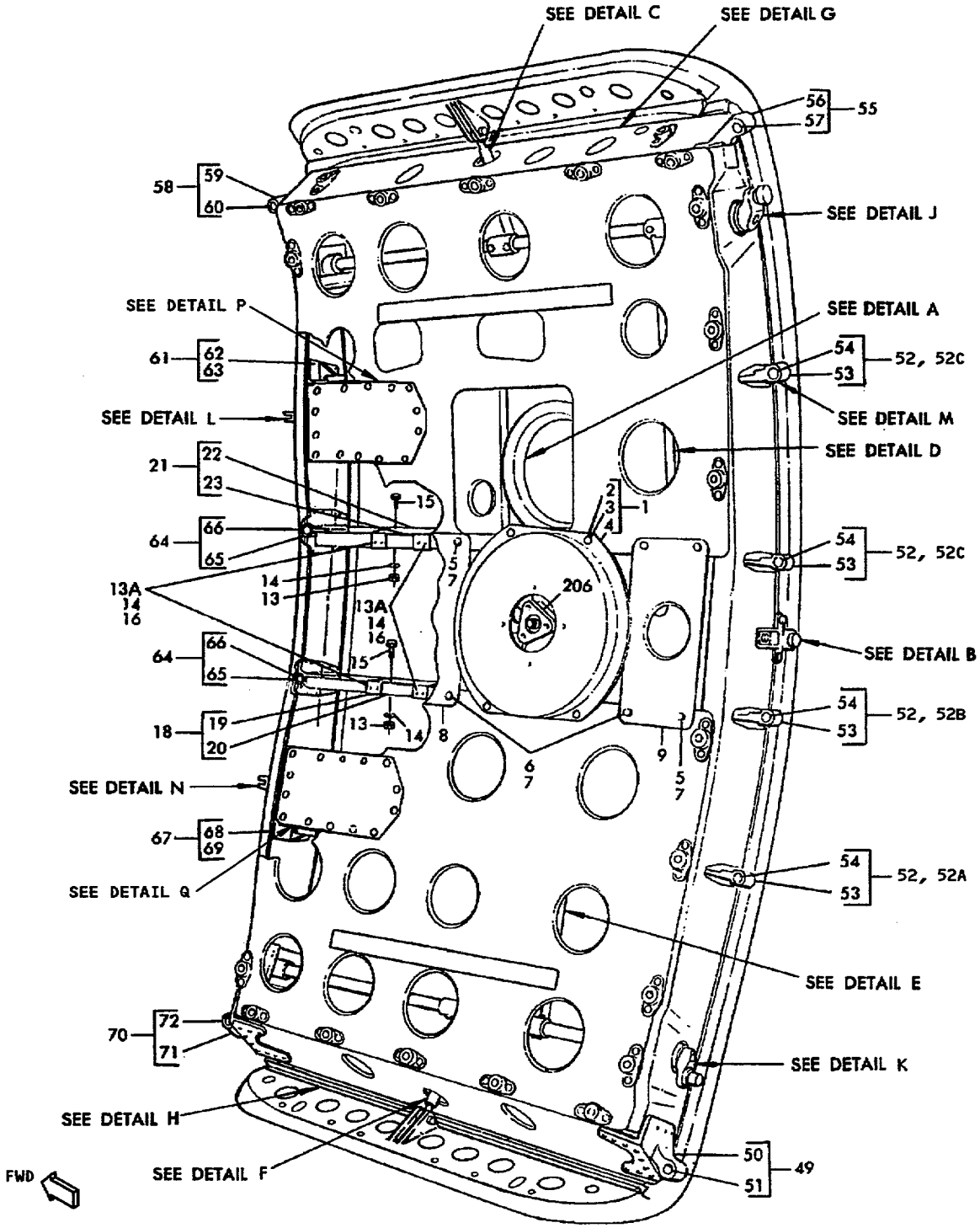
3. Provide a suitable surrounding structure to prevent handling damage.

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

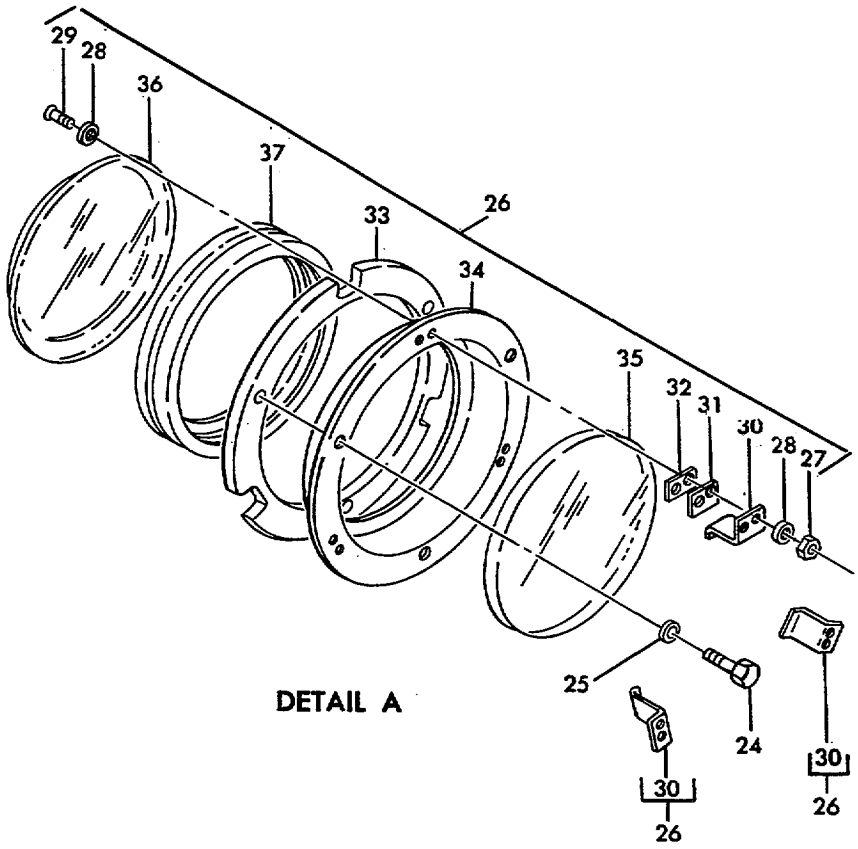
SPECIAL TOOLS, FIXTURES, AND EQUIPMENT

NOTE: Equivalent substitutes can be used.

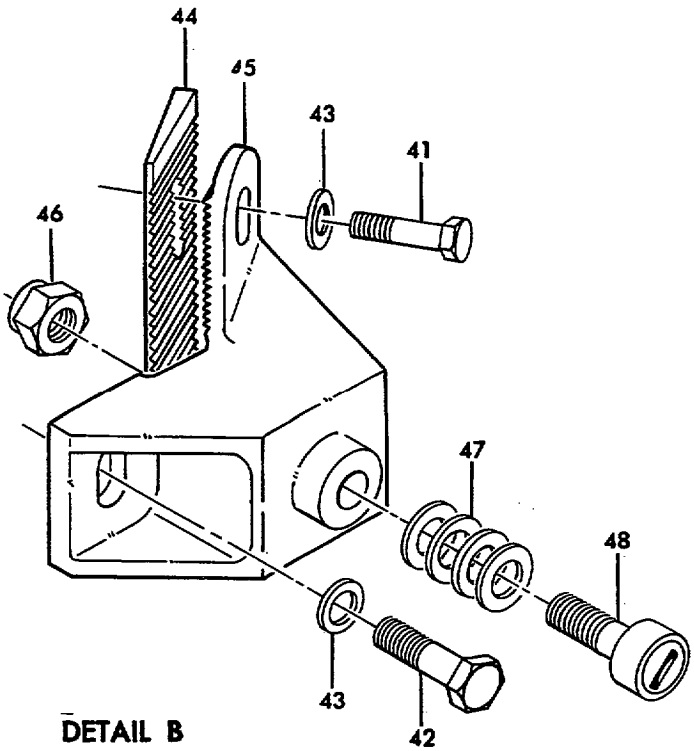
1. F70038 -- Door Handle Mechanism Wrench Assembly or equivalent
2. F70085 -- Bearing Retainer Nut Spanner Wrench or equivalent
3. B52004-1 -- Door Seal Installation Tool or equivalent (SE52-1002 optional)



Forward Galley Door Assembly
Figure 1101 (Sheet 1)

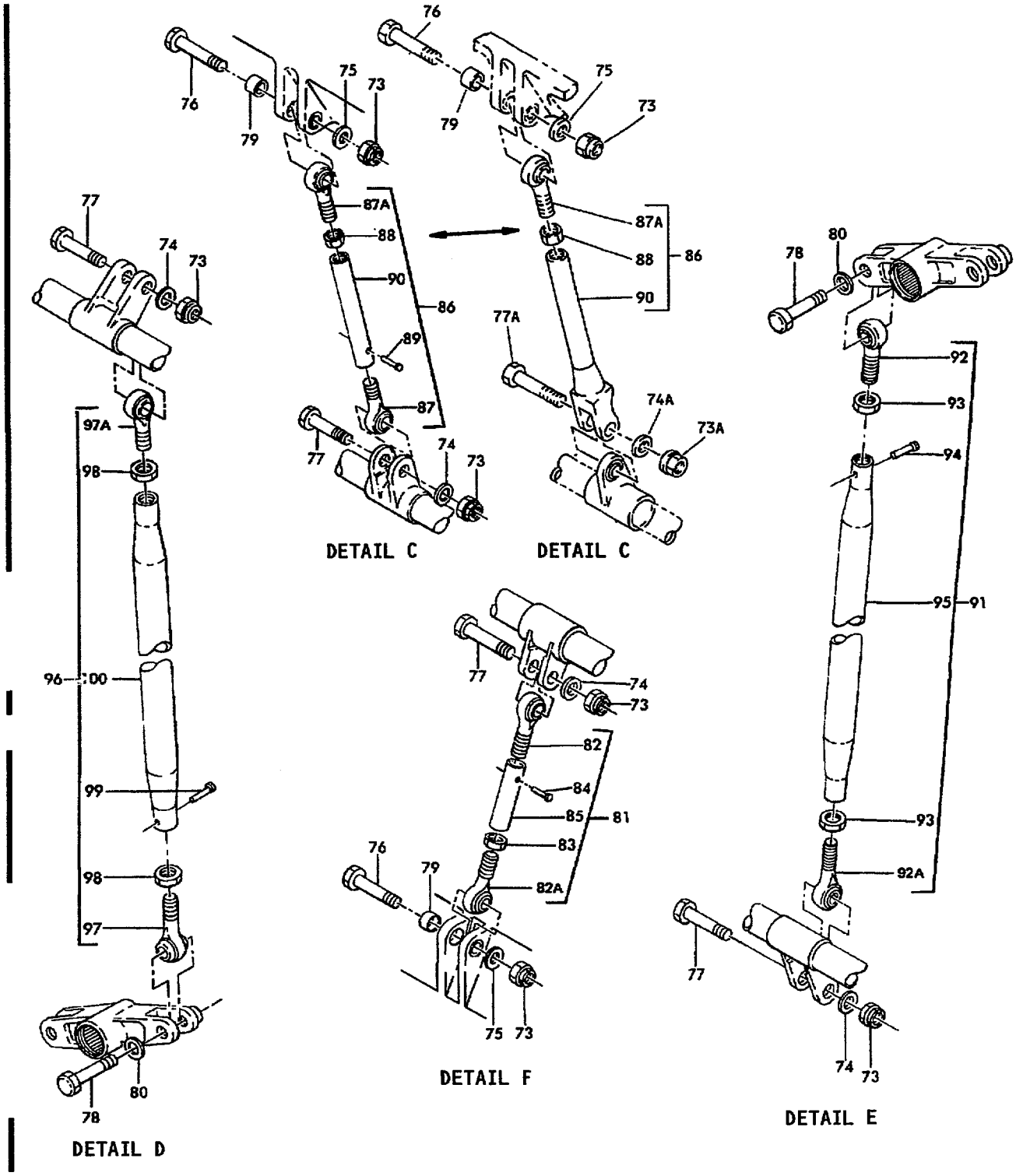


DETAIL A

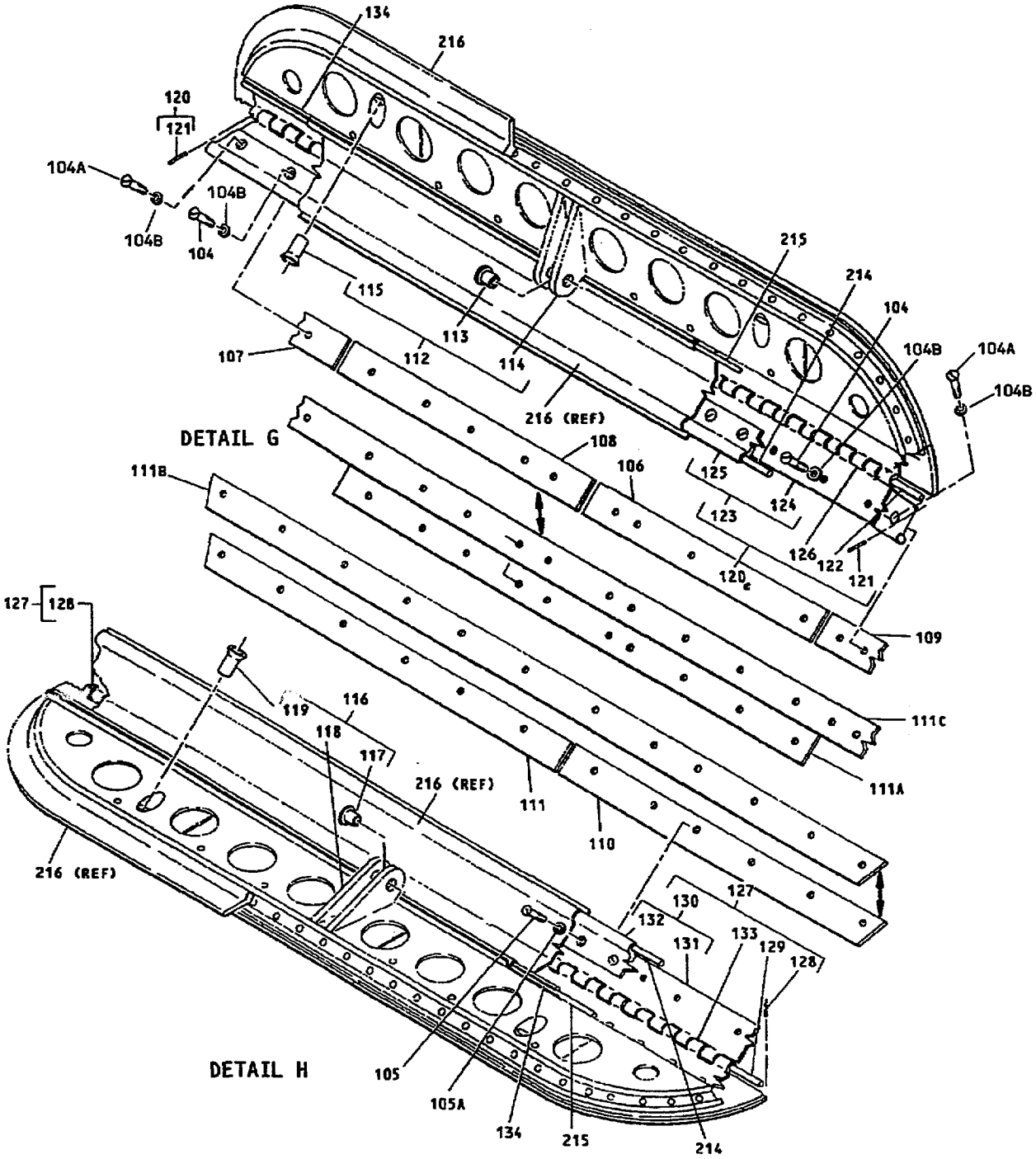


DETAIL B

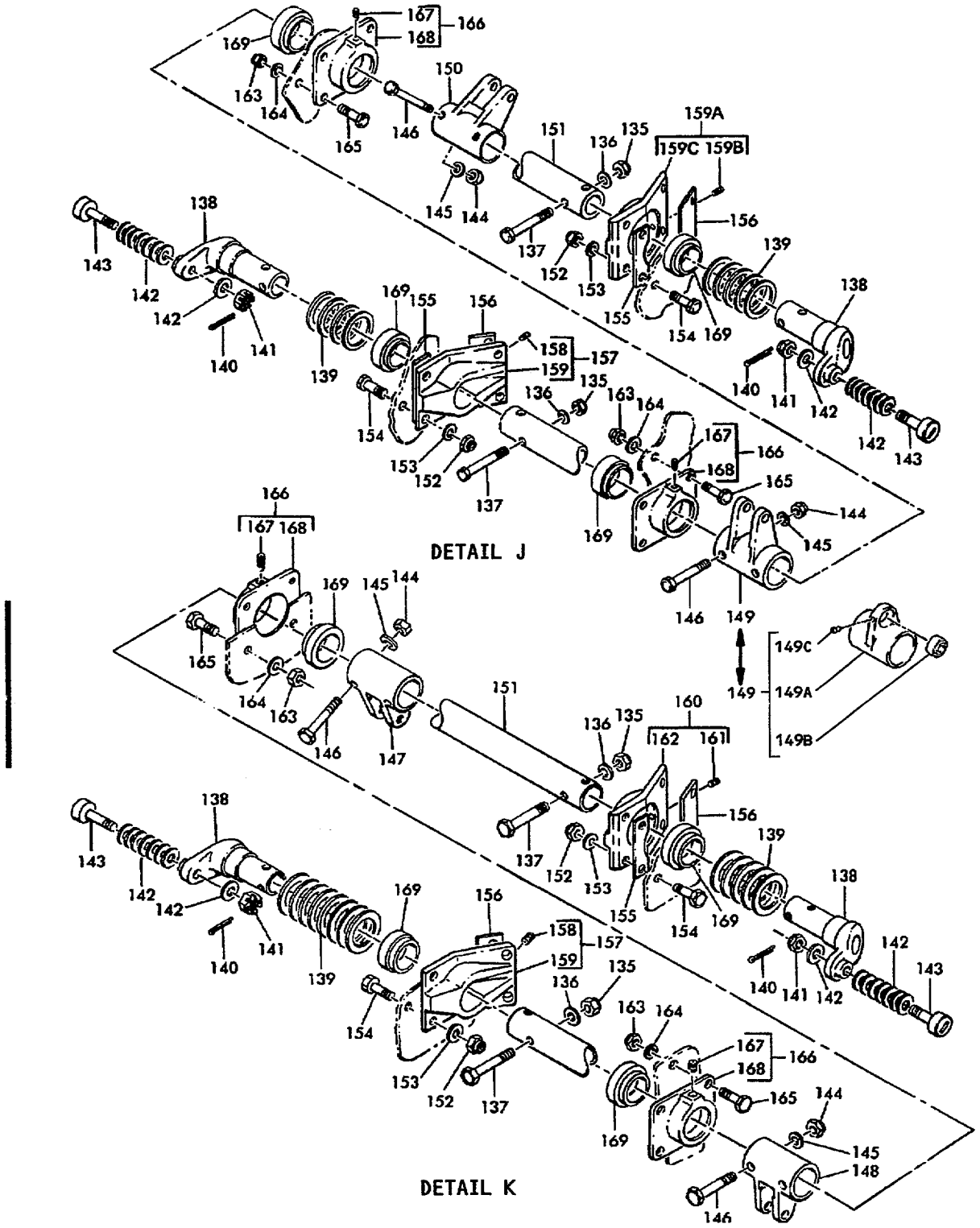
Forward Galley Door Assembly
Figure 1101 (Sheet 2)



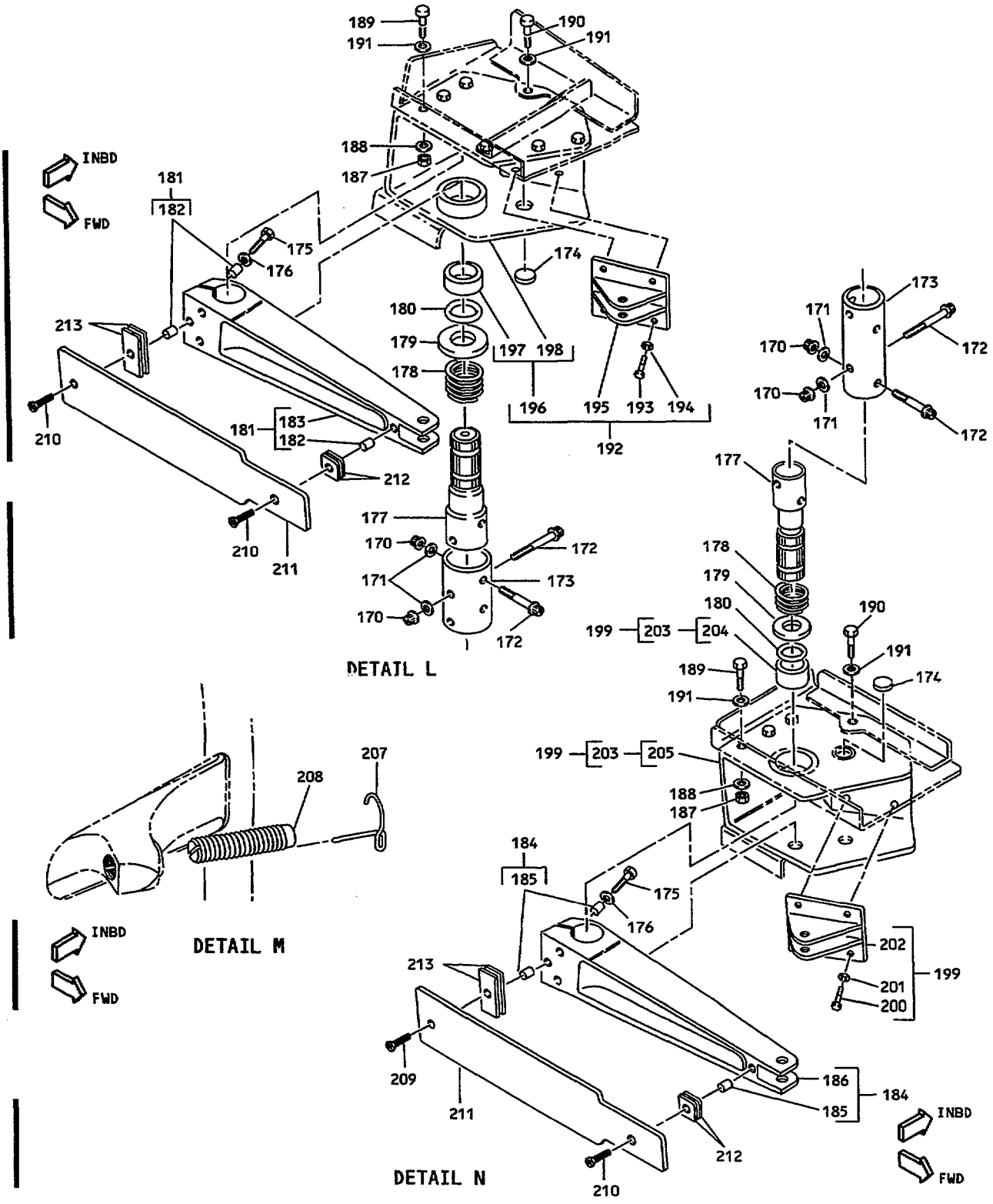
Forward Galley Door Assembly
Figure 1101 (Sheet 3)



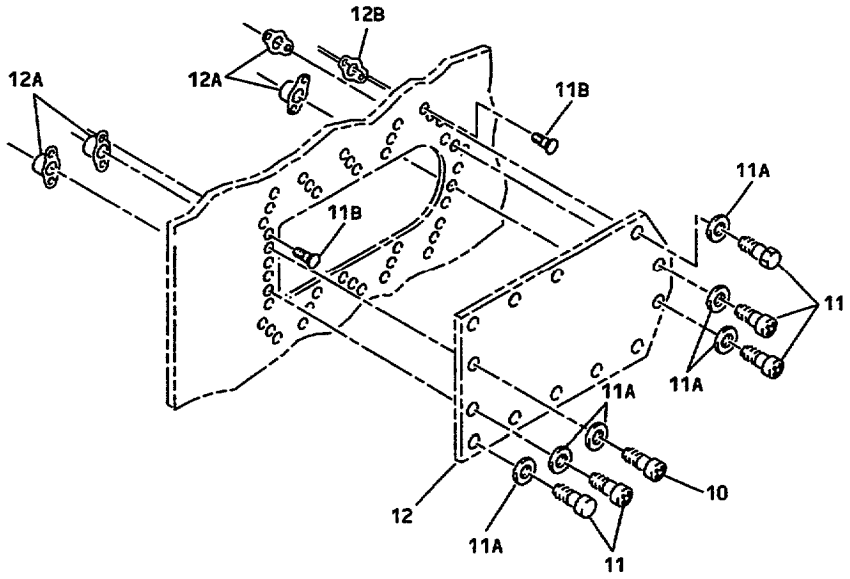
Forward Galley Door Assembly
Figure 1101 (Sheet 4)



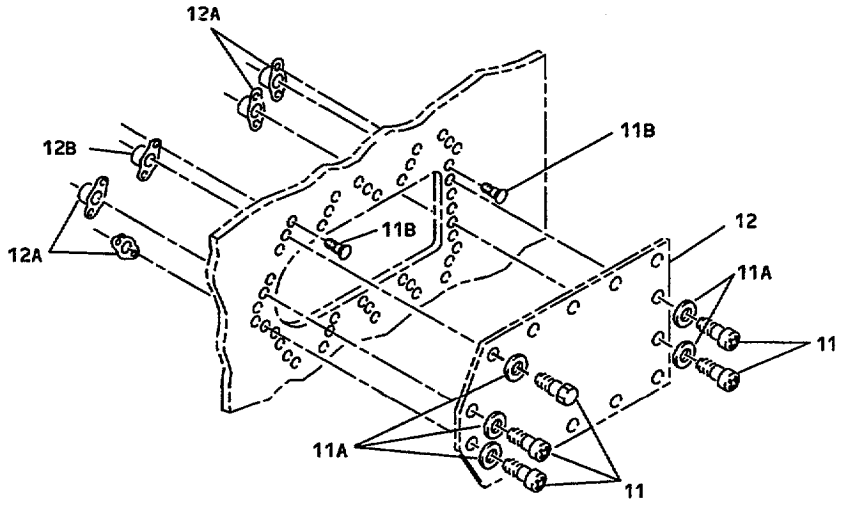
Forward Galley Door Assembly
Figure 1101 (Sheet 5)



Forward Galley Door Assembly
Figure 1101 (Sheet 6)



DETAIL P



DETAIL Q

Forward 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-					
	65-45871-2		FORWARD GALLEY DOOR ASSY	A	RF
	65-45871-523		FORWARD GALLEY DOOR ASSY	B	RF
	65-45871-517		FORWARD GALLEY DOOR ASSY	C	RF
	65-45871-114		FORWARD GALLEY DOOR ASSY	D	RF
	65-45871-124		FORWARD GALLEY DOOR ASSY	E	RF
	65-45871-132		FORWARD GALLEY DOOR ASSY	F	RF
	65-45871-133		FORWARD GALLEY DOOR ASSY	G	RF
1	69-42595-3		. RETAINER ASSY, LINING (OPT TO 69-42595-5)	AC	1
1	69-42595-5		. RETAINER ASSY, LINING (69-42595-3 OPT)	AC	1
1	69-42595-5		. RETAINER ASSY, LINING *[6]	B	1
1	69-42595-6		. RETAINER ASSY, LINING *[6]	B	1
1	69-42595-8		. RETAINER ASSY, LINING *[6]	B	1
1	69-42595-8		. RETAINER ASSY, LINING	D-G	1
2	BACS21AP180RP		. . STUD, OVAL HEAD		4
3	BACR12AG2C		. . RING, SPLIT RETAINING		4
3A	BACN10TL3-3		. . SPACER, NUTPLATE (USED ON 69-42595-6, -8)		4
3B	AN960D416L		. . WASHER (USED ON 69-42595-6 ONLY)		1
4	69-42595-4		. . RETAINER (USED ON 69-42595-3,-5)		1
4	69-42595-7		. . RETAINER (USED ON 69-42495-6)		1
4	69-42595-9		. . RETAINER (USED ON 69-42595-8)		1
5	NAS623-3-4		. SCREW		8
6	NAS623-3-5		. SCREW		4
7	AN960PD10L		. WASHER		12
8	65-45871-50		. PLATE, COVER		1
9	65-45871-59		. PLATE, COVER		1
10	NAS603-10P		. SCREW		1
11	NAS603-9P		. SCREW		27
11A	BACW10BN3AP		. WASHER		28
11B	BACR15BA3D		. RIVET (REPLS MS20426D3)		56
12	65-45871-49		. PLATE, COVER		2
12A	BACN10JZ3A2		. NUTPLATE (REPLS BACN10EN3E)		8
12B	BACN10JR3		. NUTPLATE (REPLS NAS680A3)		20
13	BACN10JC3		. NUT (REPLS NAS679A3W) *[5]		40
13A	BACN10JC3		. NUT		8
14	AN960PD10L		. WASHER		48
15	NAS1103-2		. BOLT		40
16	BACB30LU3-4		. BOLT (REPLS NAS333CPA5)		8
17	NAS333CPA6		DELETED		
18	69-41276-2		. ANGLE ASSY, REINFORCING		1
19	69-41276-4		. . ANGLE		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
20	69-41276-5		. . FILLER		1
21	69-41276-1		. ANGLE ASSY, REINFORCING		1
22	69-41276-3		. . ANGLE		1
23	69-41276-5		. . FILLER		1
24	BACB30NE3-3		. BOLT		3
25	AN960D10		. WASHER		3
26	65-2863-3		. WINDOW ASSY, OBSERVATION		1
27	BACN10JC04		. . NUT (REPLS NAS679A04W)		6
28	AN960-4		. . WASHER		12
29	NAS600-8P		. . SCREW (REPLS NAS600-8)		6
30	63-1478		. . CLIP		3
31	BACS40A12-12		. . SHIM, LAMINATED (REPLD BY BACS40R007B007F)		AR
31	BACS40R007B007F		. . SHIM, LAMINATED (REPLS BACS40A12-12)		AR
32	BACS40B12-12		. . SHIM, LAMINATED (REPLD BY BACS40R007C007F)		AR
32	BACS40R007C007F		. . SHIM, LAMINATED (REPLS BACS40B12-12)		AR
33	66-2646		. . SEAL, SPONGE RUBBER		1
34	69-1983		. . RETAINER		1
35	69-1083		. . PANE, INNER		1
36	69-1084		. . PANE, OUTER		1
37	66-1921-1		. . SEAL		1
38	65-45871-505		DELETED		
39	65-45871-504		DELETED		
40	514063		DELETED		
41	NAS1104-7		. BOLT		2
42	NAS1103-4		. BOLT		1
43	AN960PD10L		. WASHER		3
44	69-37495-1		. PLATE, SERRATED	ABCG	1
44	69-37495-1		. PLATE, SERRATED *[6]	D	1
44	69-37495-501		. PLATE, SERRATED *[6]	DEF	1
44	69-37495-502		. PLATE, SERRATED *[6]	E	1
45	69-17789-1		. FITTING, ROLLER		1
46	BACN10JC4		. NUT (REPLS NAS679A4W)		1
47	AN960PD516L		. WASHER		4
48	BACB10AF5F9H		. BEARING, NEEDLE (PREF)		1
48	BACB10BH59F7		. BEARING, NEEDLE (OPT TO BACB10AF5F9H)		1
49	65-51674-501		. FITTING ASSY, STOP	B-G	1
49	65-51674-501		. FITTING ASSY, STOP *[6]	A	1
49	65-51674-1		. FITTING ASSY, STOP *[6]	A	1
50	65-51674-502		. . FITTING, STOP (USED ON 65-51674-501		1
50	65-51674-2		. . FITTING, STOP (USED ON 65-51674-1)		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
51	66-12688-1		. . BUSHING		1
52	65-49894-1		. FITTING ASSY, STOP		1
52	65-49894-1		. FITTING ASSY, STOP *[6]	BD	4
52	65-49894-501		. FITTING ASSY, STOP *[6]	BDF	4
52	65-49894-501		. FITTING ASSY, STOP	E	4
52A	65-49894-3		. FITTING ASSY, STOP *[6]	F	1
52A	65-49894-9		. FITTING ASSY, STOP *[6]	F	1
52B	65-49894-5		. FITTING ASSY, STOP *[6]	F	1
52B	65-49894-10		. FITTING ASSY, STOP *[6]	F	1
52C	65-49894-7		. FITTING ASSY, STOP *[6]	F	2
52C	65-49894-13		. FITTING ASSY, STOP *[6]	F	2
53	65-49894-2		. . FITTING, STOP (USED ON 65-49894-1)		1
53	65-49894-4		. . FITTING, STOP (USED ON 65-49894-3)		1
53	65-49894-6		. . FITTING, STOP (USED ON 65-49894-5)		1
53	65-49894-8		. . FITTING, STOP (USED ON 65-49894-7)		1
53	65-49894-11		. . FITTING, STOP (USED ON 65-49894-9)		1
53	65-49894-12		. . FITTING, STOP (USED ON 65-49894-10)		1
53	65-49894-14		. . FITTING, STOP (USED ON 65-49894-13)		1
53	65-49894-502		. . FITTING, STOP (USED ON 65-49894-501)		1
54	66-12688-1		. . BUSHING		1
55	65-51673-1		. FITTING ASSY, STOP	A-E	1
55	65-51673-1		. FITTING ASSY, STOP *[6]	F	1
55	65-51673-3		. FITTING ASSY, STOP *[6]	F	1
56	65-51673-2		. . FITTING, STOP (USED ON 65-51673-1)	A-E	1
56	65-51673-4		. . FITTING, STOP (USED ON 65-51673-3)		1
57	66-12688-1		. . BUSHING		1
58	65-51672-1		. FITTING ASSY, STOP	A-E	1
58	65-51672-1		. FITTING ASSY, STOP *[6]	F	1
58	65-51672-3		. FITTING ASSY, STOP *[6]	F	1
59	65-51672-2		. . FITTING, STOP (USED ON 65-51672-1)	A-E	1
59	65-51672-4		. . FITTING ASSY, STOP (USED ON 65-51672-3)		1
60	66-12688-1		. . BUSHING		1
61	65-49583-1		. FITTING ASSY, STOP		1
62	65-49583-3		. . FITTING, STOP		1
63	66-12688-1		. . BUSHING		1
64	65-49563-1		. FITTING ASSY, STOP	AC	2
64	65-49563-1		. FITTING ASSY, STOP *[6]	BD	2
64	65-49563-501		. FITTING ASSY, STOP *[6]	BD	2
64	65-49563-501		. FITTING ASSY, STOP	EFG	2
65	65-49563-2		. . FITTING, STOP (USED ON 65-49563-1)		1
65	65-49563-502		. . FITTING, STOP (USED ON 65-49563-501)		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
66	66-12688-1		. . BUSHING		1
67	65-49583-2		. FITTING ASSY, STOP		1
68	65-49583-4		. . FITTING, STOP		1
69	66-12688-1		. . BUSHING		1
70	65-51675-501		. FITTING ASSY, STOP	B-E	1
70	65-51675-501		. FITTING ASSY, STOP *[6]	A	1
70	65-51675-1		. FITTING ASSY, STOP *[6]	A	1
71	65-51675-502		. . FITTING, STOP (USED ON 65-51675-501)		1
71	65-51675-2		. . FITTING, STOP (USED ON 65-51675-1)		1
72	66-12688-1		. . BUSHING		1
73	BACN10JC4		. NUT (REPLS NAS679A4W)	A-E	6
73	BACN10JC4		. NUT (REPLS NAS679A4W)	F	5
73A	BACN10YR4CD		. NUT	F	1
74	AN960-416		. WASHER	A-E	4
74	AN960-416		. WASHER	F	3
74A	NAS620C-416		. WASHER	F	1
75	NAS1197-416L		. WASHER		2
76	NAS1104-17		. BOLT		2
77	NAS1104-13		. BOLT	A-E	4
77	NAS1104-13		. BOLT	F	3
77A	BACB30NF4-14		. BOLT	F	1
78	NAS1104-12		. BOLT		2
79	NAS74A4E005P		DELETED		
79	NAS74A4E006P		. BUSHING		2
80	AN960PD416L		. WASHER		2
81	69-18187-6		. ROD ASSY, DOOR GATE CONTROL *[6]	B	1
81	69-18187-6		. ROD ASSY, DOOR GATE CONTROL	AC	1
81	69-18187-21		. ROD ASSY, DOOR GATE CONTROL *[6]	B	1
81	69-18187-21		. ROD ASSY, DOOR GATE CONTROL	D-G	1
82	BACB10A187M2L		. . BEARING, ROD END		1
82	BACB10A187L		. . BEARING, ROD END (OPT BACB10A187M2L)		1
82A	BACB10A187M2L		. . BEARING, ROD END (USED ON 69-18187-6)		1
82A	BACB10A187L		. . BEARING, ROD END (OPT TO BACB10A187M2L ON 69-18187-21) (USED ON 69-18187-6)		1
82A	BACB10Y4		. . BEARING, ROD END (USED ON 69-18187-21)		1
83	AN316-5R		. . NUT, CHECK		1
84	BACR15BB5D		. . RIVET (REPLS MS20470D5)		1
85	66-14618-5		. . ROD		1
86	69-18187-5		. ROD ASSY, DOOR GATE CONTROL	AC	1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
86	69-18187-5		. ROD ASSY, DOOR GATE CONTROL *[6]	B	1
86	69-18187-20		. ROD ASSY, DOOR GATE CONTROL *[6]	B	1
86	69-18187-24		. ROD ASSY, DOOR GATE CONTROL *[6]	B	1
86	69-18187-24		. ROD ASSY, DOOR GATE CONTROL	DEG	1
86	69-18187-27		. ROD ASSY, DOOR GATE CONTROL *[6]	F	1
87	BACB10A187M2L		. . BEARING, ROD END (USED ON 69-18187-5)		1
87	BACB10A187L		. . BEARING, ROD END (USED ON 69-18187-20) (OPT TO BACB10A187M2L ON 69-18187-5)		1
87	MXJ45-14BFG2		. . BEARING, ROD END (USED ON 69-18187-24) (V73134)		1
87A	BACB10A187M2L		. . BEARING, ROD END (USED ON 69-18187-5)		1
87A	BACB10A187L		. . BEARING, ROD END (OPT TO BACB10A187M2L) (USED ON 69-18187-5)		1
87A	BACB10Y4		. . BEARING, ROD END (USED ON 69-18187-20, -24, -27)		1
88	AN316-5R		. . NUT, CHECK		1
89	BACR15BB5D		. . RIVET (REPLS MS20470D5)		1
90	66-14618-4		. . ROD		1
90	66-14618-13		. . ROD (USED ON 69-18127-27)		1
91	65-28925-42		. ROD ASSY, DOOR MECHANISM CONTROL	AC	1
91	65-28925-42		. ROD ASSY, DOOR MECHANISM CONTROL *[6]	B	1
91	65-28925-84		. ROD ASSY, DOOR MECHANISM CONTROL *[6]	B	1
91	65-28925-84		. ROD ASSY, DOOR MECHANISM CONTROL	D-G	1
92	11-667A		. . ROD END (V73134) (OPT TO BACB10A187L) (USED ON 65-28925-42)		2
92	BACB10A187L		. . BEARING, ROD END (USED ON 65-28925-42)		2
92A	BACB10A187L		. . BEARING, ROD END (USED ON 65-28925-84)		1
92A	BACB10Y4		. . BEARING, ROD END (USED ON 65-28925-84)		1
93	AN316-5R		. . NUT, CHECK		2
94	BACR15BB3D		. . RIVET, (REPLS MS20470D3)		1
95	65-28925-44		. . ROD		1
96	65-28925-41		. ROD ASSY, DOOR MECHANISM CONTROL	AC	1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
96	65-28925-41		. ROD ASSY, DOOR MECHANISM CONTROL *[6]	B	1
96	65-28925-83		. ROD ASSY, DOOR MECHANISM CONTROL *[6]	B	1
96	65-28925-83		. ROD ASSY, DOOR MECHANISM CONTROL	D-G	1
97	BACB10A187L		. . BEARING, ROD END (USED ON 65-28925-41)		2
97	11-667A		. . BEARING, ROD END (V73134) (OPT) (USED ON 65-28925-41)		2
97A	BACB10A187L		. . BEARING, ROD END (USED ON 65-28925-83)		1
97A	BACB10Y4		. . BEARING, ROD END (USED ON 65-28925-83)		1
98	AN316-5R		. . NUT, CHECK		2
99	BACR15BB3D		. . RIVET (REPLS MS20470D3)		1
100	65-28925-43		. . ROD		1
101	NAS679A3W		DELETED		
102	AN960D10L		DELETED		
103	BACB30EL3-5		DELETED		
104	NAS583-5		. BOLT *[6]		10
104	NAS623-3-3		. BOLT *[6]		10
104A	NAS623-3-8		. BOLT *[6]		2
104A	NAS583-5		. BOLT *[6]		2
104B	AN960PD10L		. WASHER *[6] (USED WITH NAS623-3-3. NAS623-3-8)		AR
105	NAS583-5		. BOLT *[6]		12
105	NAS623-3-3		. BOLT *[6]		12
105A	AN960PD10L		. WASHER *[6] (USED WITH NAS623-3-3)		AR
106	BACS40C16-188		. SHIM, LAMINATED *[6]		AR
107	BACS40B16-69		. SHIM, LAMINATED *[6]		AR
108	BACS40C16-147		. SHIM, LAMINATED *[6]		AR
109	BACS40B16-73		. SHIM, LAMINATED *[6]		AR
110	BACS40C16-217		. SHIM, LAMINATED *[6]		AR
111	BACS40C16-262		. SHIM, LAMINATED *[6]		AR
111A	65-45871-506		. SHIM (REPLS ITEMS 106 THRU 109)	A-E	1
111B	65-45871-507		. SHIM (REPLS ITEMS 110 AND 111)	A-E	1
111C	65-45871-520		. SHIM, LAMINATED	B-E	AR
112	65-50572-1		. GATE ASSY, UPPER *[6]	A	1
112	65-50572-501		. GATE ASSY, UPPER *[6]	A	1
112	65-50572-503		. GATE ASSY, UPPER *[6]	A	1
112	65-50572-503		. GATE ASSY, UPPER	BCD	1
112	65-50572-4		. GATE ASSY, UPPER	EFG	1
113	NAS77A4-18P		. . BUSHING		1
114	65-50572-2		. . GATE (USED ON 65-50572-1)		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
114	65-50572-502		. . GATE (USED ON 65-50572-501)		1
114	65-50572-504		. . GATE (USED ON 65-50572-503)		1
114	65-50572-5		. . GATE (USED ON 65-50572-4)		1
115	66-12688-1		. . BUSHING		2
116	65-50573-1		. GATE ASSY, LOWER *[6]	A	1
116	65-50573-501		. GATE ASSY, LOWER *[6]	A	1
116	65-50573-501		. GATE ASSY, LOWER	BCD	1
116	65-50573-4		. GATE ASSY, LOWER	EFG	1
117	NAS77A4-18P		. . BUSHING		1
118	65-50573-2		. . GATE (USED ON 65-50573-1)		1
118	65-50573-502		. . GATE (USED ON 65-50573-501)		1
118	65-50573-5		. . GATE (USED ON 65-50573-4)		1
119	66-12688-1		. . BUSHING		2
120	65-52855-1		. HINGE ASSY, UPPER GATE *[6]	A	1
120	65-52855-501		. HINGE ASSY, UPPER GATE (PRE SB 52-1097R1) *[6]	A	1
120	65-52855-501		. HINGE ASSY, UPPER GATE (PRE SB 52-1097R1)	B-E	1
120	65C34068-1		. HINGE ASSY, UPPER GATE	F	1
120	65C34068-3		. HINGE ASSY, UPPER GATE	G	1
120	65C34068-3		. HINGE ASSY, UPPER GATE (POST SB 52-1097R1)	A-E	1
121	MS16562-210		. . PIN, SPRING (USED ON 65-52855-1 AND -501)		2
121	MS16562-209		. . PIN, SPRING (USED ON 65C34068-1 AND -3)		2
122	MS20253P2-2910		. . PIN, HINGE		1
123	65-52855-503		. . HINGE HALF (USED ON 65-52855-501)		1
123	65C34068-4		. . HINGE HALF (USED ON 65C34068-1)		1
123	65C34068-7		. . HINGE HALF (USED ON 65C34068-3)		1
123	65-52855-3		. . HINGE HALF ASSY (USED ON 65-52855-1)		1
124	65-52855-6		. . . HINGE HALF *[3]		1
125	65-49939-1		. . . RETAINER, SEAL		1
126	65-52855-5		. . HINGE HALF (USED ON 65-52855-1) *[2]		1
126	65-52855-505		. . HINGE HALF (USED ON 65-52855-501) *[4]		1
126	65C34068-5		. . HINGE HALF (USED ON 65C34068-1)		1
126	65C34068-8		. . HINGE HALF (USED ON 65C34068-3)		1
127	65-52855-2		. HINGE ASSY, LOWER GATE *[6]	A	1
127	65-52855-502		. HINGE ASSY, LOWER GATE (PRE SB 52-1097R1, 52A1124) *[6]	A	1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
127	65-52855-502		. HINGE ASSY, LOWER GATE (PRE SB 52-1097R1, 52A1124)	B-E	1
127	65C34068-2		. HINGE ASSY, LOWER GATE	F	1
127	65C34068-9		. HINGE ASSY, LOWER GATE	G	1
127	65C34068-9		. HINGE ASSY, LOWER GATE (POST SB 52-1097R1, 52A1124)	A-E	1
128	MS16562-210		. . PIN, SPRING (USED ON 65-52855-2 AND -502)		2
128	MS16562-209		. . PIN, SPRING (USED ON 65C34068-2 AND -9)		2
129	MS20253P2-2910		. . PIN, HINGE		1
130	65-52855-504		. . HINGE HALF (USED ON 65-52855-502)		1
130	65C34068-6		. . HINGE HALF (USED ON 65C34068-2)		1
130	65C34068-10		. . HINGE HALF (USED ON 65C34068-9)		1
130	65-52855-4		. . HINGE HALF ASSY (USED ON 65-52855-2)		1
131	65-52855-7		. . . HINGE HALF		1
132	65-49939-1		. . . RETAINER, SEAL		1
133	65-52855-505		. . HINGE HALF (USED ON 65-52855-502) *[4]		1
133	65-52855-5		. . HINGE HALF (USED ON 65-52855-2) *[2]		1
133	65C34068-5		. . HINGE HALF (USED ON 65C34068-2)		1
133	65C34068-8		. . HINGE HALF (USED ON 65C34068-9)		1
134	65-49939-2		. RETAINER, SEAL		2
135	BACN10JC3		. NUT (REPLS NAS679A3W) (PRE SB 52-1094R3)	ABC	8
135	BACN10YR3CD		. NUT (POST SB 52-1094R3) *[9] *[10]	ABC	8
135	BACN10YR3CD		. NUT *[9] *[10]	DEF	8
136	AN960PD10L		. WASHER PRE SB 52-1094R3	ABC	8
136	AN960C10L		. WASHER (POST SB 52-1094R3) *[9] *[10]	ABC	8
136	AN960C10L		. WASHER *[9] *[10]	DEF	8
137	NAS1103-16		. BOLT PRE SB 52-1094R3	ABC	8
137	BACB30NM3K17		. BOLT (POST SB 52-1094R3) *[9] *[10]	ABC	8
137	BACB30NM3K17		. BOLT *[9] *[10]	DEF	8
138	69-37418-501		. CRANK *[6] (POST SB 52-1094R3) *[9] *[10]	A	4
138	69-37418-2		. CRANK *[6] (OPT TO 69-37418-501) PRE SB 52-1094R3	A	4
138	69-37418-8		. CRANK *[6] PRE SB 52-1094R3	A	4
138	69-37418-8		. CRANK (OPT TO 69-37418-501) PRE SB 52-1094R3	B	4
138	69-37418-8		. CRANK (OPT TO 69-37418-501)	DE	4
138	69-37418-8		. CRANK *[6]	F	4

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
138	69-37418-11		. CRANK *[6]	F	4
138	69-37418-501		. CRANK (PREF) (POST SB 52-1094R3) *[9] *[10]	B	4
138	69-37418-501		. CRANK *[9] *[10]	C	4
138	69-37418-501		. CRANK (OPT TO 69-37418-8) *[9] *[10]	DE	4
138	69-37418-501		. CRANK *[6] *[9] *[10]	F	4
139	66-15332-1		. SPACER		AR
140	MS24665-134		. PIN, COTTER		4
141	BACN10JD105		. NUT, CASTELLATED (REPLS AN320-5)		4
142	AN960PD516L		. WASHER		32
143	BACB10AF5F9H		. BEARING, NEEDLE (PREF)		4
143	BACB10BH59F7		. BEARING, NEEDLE (OPT BACB10AF5F9H)		4
144	BACN10JC3		. NUT (REPLS NAS679A3W) (PRE SB 52-1094)	ABC	8
144	BACN10YR3CD		. NUT (POST SB 52-1094) *[9] *[10]	ABC	8
144	BACN10YR3CD		. NUT *[9] *[10]	DEF	8
145	AN960-10L		. WASHER (PRE SB 52-1094)	ABC	8
145	AN960C10L		. WASHER (POST SB 52-1094) *[9] *[10]	ABC	8
145	AN960C10L		. WASHER *[9] *[10]	DEF	8
146	NAS1103-18		. BOLT (PRE SB 52-1094)	ABC	8
146	BACB30NM3K19		. BOLT (POST SB 52-1094) *[9] *[10]	ABC	8
146	BACB30NM3K17		. BOLT *[9] *[10]	DEF	8
147	60-4409		. CRANK, LOWER TORQUE TUBE LATCH (PRE SB 52-1094)	ABC	1
147	60-4409-1		. CRANK, LOWER TORQUE TUBE LATCH (POST SB 52-1094) *[10]	ABC	1
147	60-4409-1		. CRANK, LOWER TORQUE TUBE LATCH *[10]	DEF	1
148	66-14531-1		. CRANK, LOWER TORQUE TUBE LATCH (PRE SB 52-1094)	ABC	1
148	66-14531-9		. CRANK, LOWER TORQUE TUBE LATCH (POST SB 52-1094) *[10]		1
148	66-14531-9		. CRANK, LOWER TORQUE TUBE LATCH *[10]	DEF	1
149	60-4431		. CRANK, UPPER TORQUE TUBE LATCH (PRE SB 52-1094)	ABC	1
149	60-4431-1		. CRANK, UPPER TORQUE TUBE LATCH (POST SB 52-1094) *[9]	ABC	1
149	60-4431-1		. CRANK, UPPER TORQUE TUBE LATCH *[9]	DE	1
149	60-4431-1		. CRANK, UPPER TORQUE TUBE LATCH *[6] *[9]	F	1
149	60-4431-3		. CRANK ASSY *[6]	F	1
149A	60-4431-2		. . CRANK (USED ON 60-4431-3)		1

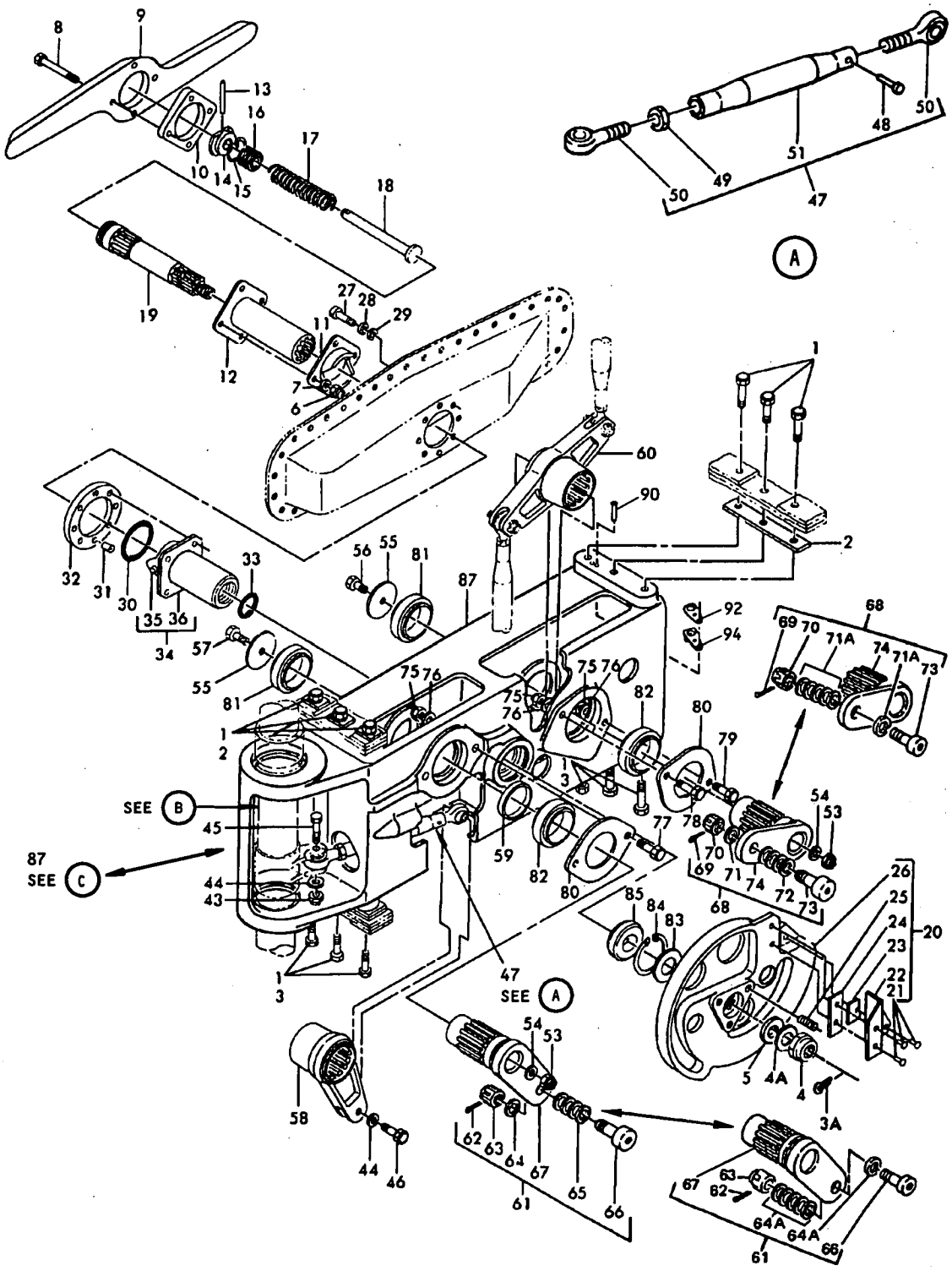
FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
149B	BACB10AB4		. . BEARING (USED ON 60-4431-3)		1
149C	NAS516-1A		. . GREASE FITTING (USED ON 60-4431-3)		1
150	66-14531-5		. CRANK, UPPER TORQUE TUBE LATCH (PRE SB 52-1094)	ABC	1
150	66-14531-11		. CRANK, UPPER TORQUE TUBE LATCH (POST SB 52-1094) *[9]	ABC	1
150	66-14531-11		. CRANK, UPPER TORQUE TUBE LATCH *[9]	DEF	1
151	60-4406-6		. TUBE, TORQUE (PRE SB 52-1094)	ABC	2
151	60-4406-12		. TUBE, TORQUE (POST SB 52-1094) *[9] *[10]	ABC	2
151	60-4406-12		. TUBE, TORQUE *[9] *[10]	DEF	2
152	BACN10JC3		. NUT (REPLS NAS679A3W)		16
153	AN960PD10L		. WASHER		16
154	NAS583-3		. BOLT		16
155	65-45871-91		. SHIM, LAMINATED *[1]		AR
156	BACS40A12-40		. SHIM, LAMINATED		AR
157	65-49560-1		. FITTING ASSY, SUPPORT	A-E	2
157	65-49560-1		. FITTING ASSY, SUPPORT *[6]	F	2
157	65-49560-15		. FITTING ASSY, SUPPORT *[6]	F	2
157	65-49560-9		. FITTING ASSY, SUPPORT *[6]	F	2
158	NAS516-1		. . FITTING, LUBRICATOR (USED ON 65-49560-1, -9)		1
158	NAS516-1A		. . FITTING, LUBRICATOR (USED ON 65-49560-15)		1
159	65-49560-2		. . FITTING, SUPPORT (USED ON 65-49560-1)		1
159	65-49560-10		. . FITTING, SUPPORT (USED ON 65-49560-9)		1
159	65-49560-16		. . FITTING, SUPPORT (USED ON 65-49560-15)		1
159A	65-49561-1		. FITTING ASSY, SUPPORT	A-E	1
159A	65-49561-1		. FITTING ASSY, SUPPORT *[6]	F	1
159A	65-49561-6		. FITTING ASSY, SUPPORT *[6]	F	1
159B	NAS516-1		. . FITTING, LUBRICATOR		1
159C	65-49561-3		. . FITTING, SUPPORT (USED ON 65-49561-1)		1
160	65-49561-2		. FITTING ASSY, SUPPORT		1
160	65-49561-2		. FITTING ASSY, SUPPORT *[6]	F	1
160	65-49561-7		. FITTING ASSY, SUPPORT *[6]	F	1
161	NAS516-1		. . FITTING, LUBRICATOR		1
162	65-49561-4		. . FITTING, SUPPORT (USED ON 65-49561-2)		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-162	65-49561-9		. . FITTING, SUPPORT (USED ON 65-49561-7)		1
163	BACN10JC3		. NUT (REPLS NAS679A3W)		16
164	AN960D10		. WASHER		16
165	NAS1103-3		. BOLT		16
166	65-2306		. HOUSING ASSY, DOOR CAMSHAFT *[6]	A	4
166	65-2306-3		. HOUSING ASSY, DOOR CAMSHAFT *[6]	A	4
166	65-2306-3		. HOUSING ASSY, DOOR CAMSHAFT	B-G	4
167	NAS516-1		. . FITTING, LUBRICATOR (USED ON 65-2306)		1
167	MS15001-4		. . FITTING, LUBRICATION (USED ON 65-2306-3)		1
168	65-2306-1		. . HOUSING (USED ON 65-2306)		1
168	65-2306-4		. . HOUSING (USED ON 65-2306-3)		1
169	BACB10A397G CM2		. BEARING, PLAIN SPHERICAL		8
170	BACN10JC4		. NUT (REPLS NAS679A4W) (PRE SB 52-1094)	ABC	8
170	BACN10YR4CD		. NUT (POST SB 52-1094) *[11]	ABC	8
170	BACN10YR4CD		. NUT *[11]	DEF	8
171	AN960-416		. WASHER (PRE SB 52-1094)	ABC	8
171	AN960C416L		. WASHER (POST SB 52-1094) *[11]	ABC	8
171	AN960C416L		. WASHER *[11]	DEF	8
172	NAS1104-25		. BOLT (PRE SB 52-1094)	ABC	8
172	BACB30NM4K26		. BOLT (POST SB 52-1094) *[11]	ABC	8
172	BACB30NM4K26		. BOLT *[11]	DEF	8
173	60-4365-1		. SLEEVE, COUPLING *[6] (PRE SB 52-1094)	B	2
173	60-4365		. SLEEVE, COUPLING *[6] (PRE SB 52-1094)	B	2
173	60-4365		. SLEEVE, COUPLING (PRE SB 52-1094)	AC	2
173	60-4365-3		. SLEEVE, COUPLING (POST SB 52-1094) *[11]	ABC	2
173	60-4365-3		. SLEEVE, COUPLING *[11]	D-F	2
174	65-45871-87		. PLUG		2
175	NAS1303-12		. BOLT		4
176	AN960PD10L		. WASHER		4
177	66-14527-4		. PIN, HINGE LINK *[6] (PRE SB 52-1094)	B	2
177	66-14527-2		. PIN, HINGE LINK *[6] (PRE SB 52-1094)	AB	2
177	66-14527-2		. PIN, HINGE LINK (PRE SB 52-1094)	C	2
177	66-14527-1		. PIN, HINGE LINK *[6] (PRE SB 52-1094)	A	2
177	66-14527-6		. PIN, HINGE LINK (PRE SB 52-1094) *[11]	ABC	2
177	66-14527-6		. PIN, HINGE LINK *[11]	D-F	2
178	66-15645-1		. SPRING, COMPRESSION		2

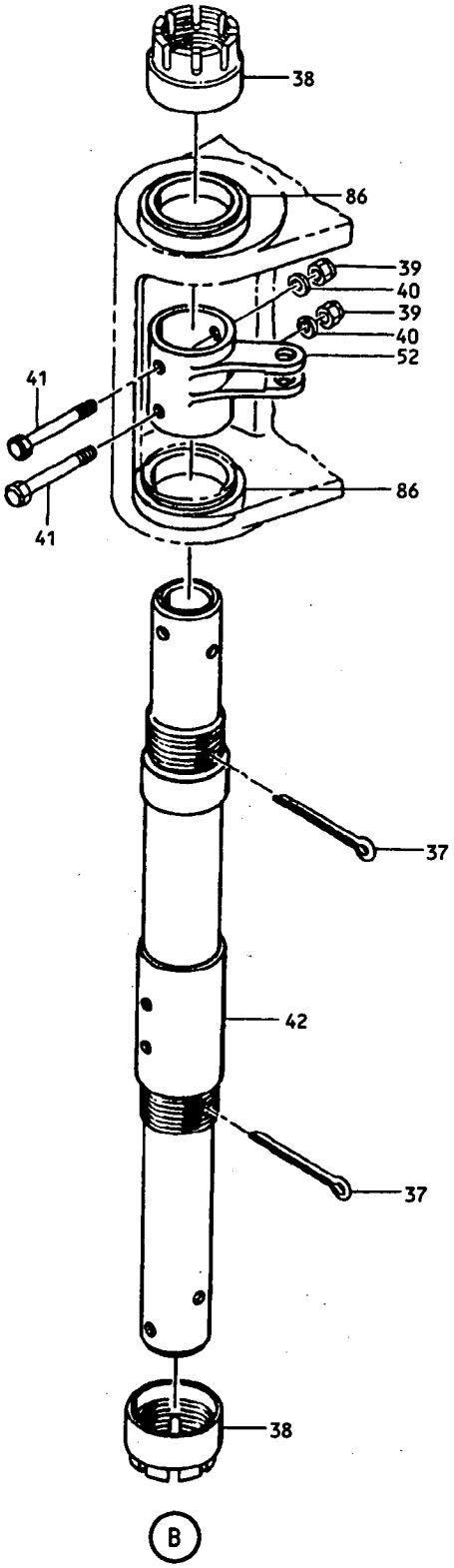
FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
179	AN960-1716		. WASHER (PRE SB 52-1094)	ABC	2
179	AN960C1716L		. WASHER (POST SB 52-1094)	ABC	2
179	AN960C1716L		. WASHER	D-F	2
180	AN6227-19		. PACKING, O-RING (REPLS AN6227-19)		2
181	65-73978-7		. ARM ASSY, UPPER HINGE *[6] (PREF)	A	1
181	65-73978-7		. ARM ASSY, UPPER HINGE	B-G	1
181	65-73978-1		. ARM ASSY, UPPER HINGE *[6] OPT TO 69-17952-17	A	1
181	69-17952-17		. ARM ASSY, UPPER HINGE *[6] OPT TO 65-73978-1	A	1
182	MS21209F1-15		. . INSERT, HELI-COIL		4
183	65-73978-9		. . ARM, HINGE (USED ON 65-73978-7)		1
183	65-73978-3		. . ARM, HINGE (USED ON 65-73978-1)		1
183	69-17952-19		. . ARM, HINGE (USED ON 69-17952-17)		1
184	65-73978-2		. ARM ASSY, LOWER HINGE *[6] OPT TO 69-17952-18	A	1
184	65-73978-2		. ARM ASSY, LOWER HINGE	B-E	1
184	65-73978-2		. ARM ASSY, LOWER HINGE (OPT TO 65-73978-8)	F	1
184	69-17952-18		. ARM ASSY, LOWER HINGE *[6] OPT TO 65-73978-2	A	1
184	65-73978-8		. ARM ASSY, LOWER HINGE (OPT TO 65-73978-2)	F	1
185	MS21209F1-15		. . INSERT, HELI-COIL		4
186	65-73978-4		. . ARM, HINGE (USED ON 65-73978-2) OPT TO 65-73978-14)		1
186	65-73978-14		. . ARM, HINGE (USED ON 65-73978-2) (OPT TO 65-73978-4)		1
186	65-73978-10		. . ARM, HINGE (USED ON 65-73978-8) (OPT TO 65-73978-12)		1
186	65-73978-12		. . ARM, HINGE (USED ON 65-73978-8) (OPT TO 65-73978-10)		1
186	69-17952-20		. . ARM, HINGE (USED ON 69-17952-18)		1
187	BACN10JC3		. NUT (REPLS NAS679A3W)		27
188	AN960D10		. WASHER		27
189	NAS1103-3		. BOLT		21
190	NAS1103-4		. BOLT		6
191	BACS11W3		. WASHER, SEAL		27
192	69-20407-6		. SUPPORT ASSY, UPPER HINGE	BD-G	1
192	69-20407-1		. SUPPORT ASSY, UPPER HINGE	AC	1
193	NAS1103-7W		. . BOLT		4
194	AN960PD10L		. . WASHER		4

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
195	69-70269-2		. . FITTING, ATTACH (USED ON 69-20407-6)		1
195	66-14315-2		. . FITTING, ATTACH (USED ON 69-20407-1)		1
196	65-19434-1		. . SUPPORT ASSY, HINGE		1
197	NAS76A16-016P		. . . BUSHING		1
198	65-19434-3		. . . SUPPORT, HINGE		1
199	69-20407-7		. SUPPORT ASSY, LOWER HINGE	BD-G	1
199	69-20407-2		. SUPPORT ASSY, LOWER HINGE	AC	1
200	NAS1103-7W		. . BOLT		4
201	AN960PD10L		. . WASHER		4
202	69-70269-1		. . FITTING, ATTACH (USED ON 69-20407-7)		1
202	66-14315-1		. . FITTING, ATTACH (USED ON 69-20407-2)		1
203	65-19434-2		. . SUPPORT ASSY, HINGE		1
204	NAS76A16-016P		. . . BUSHING		1
205	65-19434-4		. . . SUPPORT, HINGE		1
206			HANDLE MECHANISM, FORWARD GALLEY DOOR (REFER TO FIG. 1102) INSTALLATION ITEMS		1
207	66-16691-1		SPRING, PIN RETAINER		16
208	66-12687-1		PIN, DOORSTOP		16
209	NAS514P1032-9		SCREW (REPLS BACB30LH3-5)		1
210	NAS514P1032-9		SCREW (REPLS BACB30LH3-8)		3
211	69-20324-10		COVER		2
212	BACS40RE8-8		SHIM		4
213	BACS40RE8-16		SHIM		4
214	65-45871-504		ROD, NYLON		1
215	65-45871-505		ROD, NYLON		1
216	10-60476-3		SEAL (V75345)		1

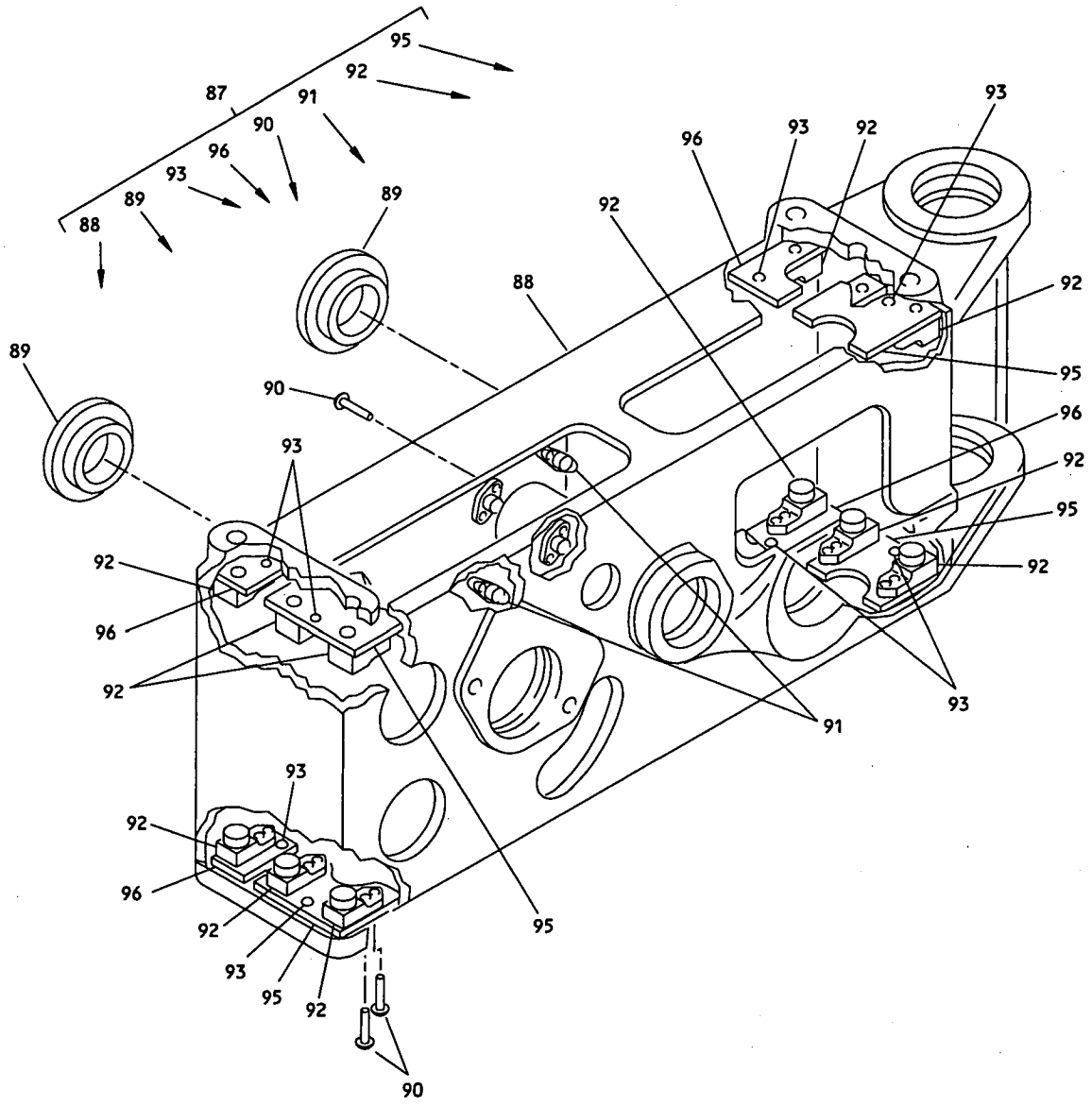
*[1] MAKE FROM BACS40A15-28
*[2] MAKE FROM MS20001Y12-2960
*[3] MAKE FROM MS20001X12-3040
*[4] MAKE FROM MS20001PY10-2960
*[5] NUTS (13) OPTIONAL TO BACR15BA3D RIVETS AND BACN10KF3 NUTPLATES
*[6] LIMITED
*[7] DELETED
*[8] NOT USED ON ALL POST SERVICE BULLETIN CONFIGURATIONS
*[9] UPPER LATCH CRANK ASSY KIT 65C33403-35 CONSISTS OF: TORQUE TUBE 60-4406-12; CRANKS 60-4431-1, 66-14531-11 AND 69-37418-501; WASHERS AN960C10L; BOLTS BACB30NM3K17, BACB30NM3K19; NUTS BACN10YR3CD.
*[10] LOWER LATCH CRANK ASSY KIT 65C33403-39 CONSISTS OF: TORQUE TUBE 60-4406-12; CRANKS 60-4409-1, 66-14531-9, 69-37418-501; WASHERS AN960C10L; BOLTS BACB30NM3K17; BACB30NM3K19; NUTS BACN10YR3CD.
*[11] TORQUE TUBE ASSEMBLY KIT 65C33403-9 CONSISTS OF: SLEEVES 60-4365-3 (FIG. 1101); HINGE LINK PINS 66-14527-6 (FIG. 1101); CRANK 69-17330-3 (FIG. 1102); TORQUE TUBE 90-6753-17 (FIG. 1102); WASHERS AN960C416L (FIG. 1101), AN960C516L (FIG. 1102); BALL BEARINGS BACB10FR25 (FIG. 1102); BOLTS BACN30NM4K26 (FIG. 1101), BACB30NM5K29 (FIG. 1102); NUTS BACN10YR4CD (FIG. 1101), BACN10YR5CD (FIG. 1102).



Forward Galley Door Handle Mechanism
Figure 1102 (Sheet 1)



Forward Galley Door Handle Mechanism
Figure 1102 (Sheet 2)



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Forward 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-			FORWARD GALLEY DOOR HANDLE MECHANISM		
1	NAS1104-14		. BOLT		12
2	BACS40H1668		. SHIM, LAMINATED		2
3	BACS40A1652		. SHIM, LAMINATED		2
3A	MS24665-283		. PIN, COTTER (USED WITH BACN10JD6) *[1]		1
4	BACN10JD6		. NUT (USED WITH 60-4455-1) *[1]		1
4	BACN10JC6		. NUT (REPLACES NAS679A6) (USED WITH 60-4455)		1
4A	AN960-616		. WASHER (USED WITH BACN10JD6)		AR
5	63-9386		. WASHER		1
6	BACN10JC3		. NUT (REPLACES NAS679A3W)		4
7	AN960PD10L		. WASHER		4
8	BACB30LH3-11		. BOLT *[1]		4
8	NAS1503-11		. BOLT (OPT TO BACB30LH3-11)*[1]		4
8	BACB30LH3-10		. BOLT *[1]		4
9	90-7879-1		. HANDLE, OUTER	A-E	1
9	90-7879-1		. HANDLE, OUTER *[1]	F	1
9	90-7879-10		. HANDLE, OUTER *[1]	F	1
9	90-7879-6		. HANDLE, OUTER *[1]	F	1
10	30-3035		. SHIM		8
11	90-7811		. CAM		1
12	90-7821		. SLEEVE		1
13	MS39086-111		. PIN, SPRING		1
14	30-3019		. WASHER (USED ON 65-45871-2) *[1]		1
14	30-3019-1		. WASHER (USED ON 65-45871-2) *[1]		1
14	30-3019-1		. WASHER (USED ON 65-45871-114, -124, -132, -133, -517, -523)		1
15	AN996-14		. RING, LOCK		1
16	30-3010		. NUT		1
17	63-2848		. SPRING, COMPRESSION		1
18	30-3013-1		. PIN (USED ON 65-45871-2) *[1]		1
18	30-3013-2		. PIN (USED ON 65-45871-2) *[1]		1
18	30-3013-2		. PIN (USED ON 65-45871-114, -124, -132, -133, -517, -523)		1
19	60-4455		. SHAFT (USED ON 65-45871-2) *[1]		1
19	60-4455-1		. SHAFT (USED ON 65-45871-2) *[1]		1
19	60-4455-1		. SHAFT (USED ON 65-45871-114, -124, -133, -523) (OPT TO 60-4455-2)		1
19	60-4455-1		. SHAFT (USED ON 65-45871-517)		1
19	60-4455-1		. SHAFT (USED ON 65-45871-132) (OPT TO 60-4455-2) *[1]		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1102-					
19	60-4455-2		. SHAFT (USED ON 65-45871-114, -124, -133, -523) (OPT TO 60-4455-1)		1
19	60-4455-2		. SHAFT (USED ON 65-45871-132) (OPT TO 60-4455-1) *[1]		1
19	60-4455-3		. SHAFT (USED ON 65-45871-132) *[1]		1
20	69-34971-1		. CAM ASSY, CONTROL (USED ON 65-45871-2) *[1]		1
20	69-34971-4		. CAM ASSY, CONTROL (USED ON 65-45871-2,-132) *[1]		1
20	69-34971-4		. CAM ASSY, CONTROL (USED ON 65-45871-114, -124, -133,-517, -523)		1
20	69-34971-6		. CAM ASSY, CONTROL (USED ON 65-45871-132) *[1]		1
20	69-34971-8		. CAM ASSY, CONTROL (USED ON 65-45871-132) *[1]		1
21	BACR15BA5D		. . RIVET (REPLACES MS20426D5)		3
22	69-34971-2		. . GUIDE		1
23	BACS40B11-11		. . SHIM, LAMINATED		AR
24	BACS40B12-26		. . SHIM, LAMINATED		AR
25	MS21209F5-15		. . INSERT, HELI-COIL		3
26	69-34971-5		. . CAM, CONTROL (USED ON 69-34971-4)		1
26	69-34971-3		. . CAM, CONTROL (USED ON 69-34971-1)		1
26	69-34971-7		. . CAM, CONTROL (USED ON 69-34971-6)		1
26	65-44065-8		. . CAM ASSY, CONTROL (USED ON 69-34971-8)		1
-26A	65-44065-9		. . . CAM, CONTROL (OPT TO 65-44065-10) (USED ON 65-44065-8)		1
-26A	65-44065-10		. . . CAM, CONTROL (OPT TO 65-44065-9) (USED ON 65-44065-8)		1
27	NAS1103-11		. BOLT		4
28	AN960D10L		. WASHER		4
29	BACS11W3		. WASHER, SEAL		4
30	AN6227-28		. PACKING, O-RING (REPLACES AN6227-28)		1
31	BACR15CE5D		. RIVET, SHEAR HEAD		4
32	60-4412		. PLATE, SEAL		1
33	AN6227-17		. PACKING, O-RING (REPLS AN6227-17)		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1102-					
34	69-61511-1		. HOUSING ASSY (USED ON 65-45871-2) (REPLS 90-7820) *[1]		1
34	69-61511-1		. HOUSING ASSY (USED ON 65-45871-114, -124, -132, -517, -523)		1
34	90-7820		. HOUSING ASSY (USED ON 65-45871-2) *[1] (REPLD BY 69-61511-1)		1
35	NAS516-1		. . FITTING, LUBRICATOR		1
36	69-61511-2		. . HOUSING, FITTING (USED ON 69-61511-1)		1
36	90-7820-1		. . HOUSING, FITTING (USED ON 90-7820)		1
37	MS24665-360		. PIN, COTTER		2
38	60-4405		. NUT, SPECIAL (USED ON 65-45871-2) *[1]		2
38	60-4405-1		. NUT, SPECIAL (USED ON 65-45871-2) *[1]		2
38	60-4405-1		. NUT, SPECIAL (USED ON 65-45871-114, -124, -132, -133, -517, -523)		2
39	BACN10JC5		. NUT (REPLS NAS679A5)		2
39	BACN10YR5CD		. NUT (SB 52-1094) *[10] *[16]		2
40	AN960PD516L		. WASHER		2
40	AN960C516L		. WASHER (SB 52-1094) *[10] *[16]		2
41	NAS1105-29		. BOLT		2
41	BACB30NM5K29		. BOLT (SB 52-1094) *[10] *[16]		2
42	90-6753-10		. TUBE, HINGE TORQUE (USED ON 65-45871-523) *[1] (PRE SB 52-1094)		1
42	90-6753-5		. TUBE, HINGE TORQUE (USED ON 65-45871-523) *[1] (PRE SB 52-1094)		1
42	90-6753-5		. TUBE, HINGE TORQUE (USED ON 65-45871-2, -517) (PRE SB 52-1094)		1
42	90-6753-17		. TUBE, HINGE TORQUE (POST SB 52-1094) (65-45871-2, -517, -523) *[16]		1
42	90-6753-17		. TUBE, HINGE TORQUE (USED ON 65-45871-114, -124)		1
42	90-6753-17		. TUBE, HINGE TORQUE (USED ON 65-45871-132) *[1] *[17]		1
42	90-6753-22		. TUBE, HINGE TORQUE (USED ON 65-45871-132) *[1]		1
43	BACN10JC5		. NUT (REPLS NAS679A5)		1
44	AN960PD516L		. WASHER		2
45	NAS1105-16		. BOLT		1
46	NAS1105-12		DELETED		
46	NAS1105-15		. BOLT		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1102-					
47	66-14302-1		. ROD ASSY, PUSH (USED ON 65-45871-2, -517)		1
47	69-39176-1		. ROD ASSY, PUSH (USED ON 65-45871-114,-124,-132,-523)		1
48	NAS20615-6M6		. . RIVET (REPLS NAS508M6-6) (USED ON 66-14302-1)		1
48	MS20615-5M10		. . RIVET (USED ON 69-39176-1)		1
49	AN316-8R		. . NUT, CHECK (USED ON 66-14302-1)		1
49	AN316-6R		. . NUT, CHECK (USED ON 69-39176-1)		1
50	77266		. . BEARING, V09455 (BOEING 10-60779-164) (USED ON 66-14302-1)		2
50	77253		. . BEARING, V09455 (BOEING 10-60779-112) (USED ON 69-39176-1)		2
50	REM10ATC16-2		. . BEARING, V21335 (BOEING 10-60779-164) (USED ON 66-14302-1)		2
50	REM10ATC12-2		. . BEARING, V21335 (BOEING 10-60779-112) (USED ON 69-39176-1)		2
50	TEM105A		. . BEARING, V77896 (BOEING 10-60779-164) (USED ON 66-14302-1)		2
50	DREM5-023		. . BEARING, V81376 (BOEING 10-60779-164) (USED ON 66-14302-1)		2
50	DREM5-019		. . BEARING, V81376 (BOEING 10-60779-112) (USED ON 69-39176-1)		2
51	66-14302-2		. . ROD (USED ON 66-14302-1)		1
51	69-39176-2		. . ROD (USED ON 69-39176-1)		1
52	69-17330-1		. CRANK (USED ON 65-45871-2, -517, -523) (PRE SB 52-1094, R1, R2, R3)		1
52	69-17330-3		. CRANK (POST SB 52-1094R1, R2, R3) (USED ON 65-45871-2, -517, -523) *[16]		1
52	69-17330-3		. CRANK (USED ON 65-45871-114, -124, -132) *[17]		1
53	BACN10JC4		. NUT (REPLS NAS679A4W)		2
54	AN960PD416L		. WASHER		2
55	63-1692		. WASHER		2
56	NAS1104-5		. BOLT		1
57	NAS1104-6		. BOLT		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1102-					
58	65-54024-3		. CRANK ASSY (USED ON 65-54871-2) *[1]		1
58	65-1933-3		. CRANK ASSY (USED ON 65-45871-2) *[1]		1
58	65-1933-3		. CRANK ASSY (USED ON 65-45871-517)		1
58	65-1933-3		. CRANK ASSY (USED ON 65-45871-523) *[1]		1
58	65-1933-504		. CRANK ASSY (USED ON 65-45871-523) *[1]		1
58	65-1933-504		. CRANK ASSY (USED ON 65-45871-114, -124, -132, -133)		1
58	65-1933-506		. CRANK ASSY (USED ON 65-45871-523) *[1]		1
58	65-1933-506		. CRANK ASSY (USED ON 65-45871-114, -124, -132, -133)		1
58	65-1933-6		DELETED		
58	65-1933-11		DELETED		
59	65-8795-801		. SPACER		1
60	65-54013		. CRANK ASSY (USED ON 65-45871-2) *[1]		1
60	65-54013-503		. CRANK ASSY (USED ON 65-45871-2) *[1]		1
60	65-54013-503		. CRANK ASSY (USED ON 65-45871-114, -124, -132, -133, -517, -523)		1
61	69-38733-1		. CRANK ASSY, CAM FOLLOWER (USED ON 65-45871-2) *[1]		1
61	90-7815-1		. CRANK ASSY, CAM FOLLOWER (USED ON 65-45871-2, -523) *[1]		1
61	90-7815-1		. CRANK ASSY, CAM FOLLOWER (USED ON 65-45871-517)		1
61	90-7815-15		. CRANK ASSY, CAM FOLLOWER (USED ON 65-45871-132, -523) *[1] (OPT TO 90-7815-17)		1
61	90-7815-15		. CRANK ASSY, CAM FOLLOWER (USED ON 65-45871-114, -124, -133) (OPT TO 90-7815-17)		1
61	90-7815-17		. CRANK ASSY, CAM FOLLOWER (USED ON 65-45871-132, -523) *[1] (OPT TO 90-7815-15)		1
61	90-7815-17		. CRANK ASSY, CAM FOLLOWER (USED ON 65-45871-114, -124, -133) (OPT TO 90-7815-15)		1
61	90-7815-23		. CRANK ASSY, CAM FOLLOWER (USED ON 65-45871-132) (OPT TO 90-781525) *[1]		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1102-					
61	90-7815-25		. CRANK ASSY, CAM FOLLOWER (USED ON 65-45871-132) (OPT TO 90-7815-23) *[1]		1
62	AN380-3-3		. . PIN, COTTER *[3]		1
62	MS24665-283		. . PIN, COTTER *[2] *[4] *[5] *[11] *[12]		1
63	AN320-6		. . NUT, CASTELLATED *[3]		1
63	BACN10JD6		. . NUT, CASTELLATED (REPLS AN320-6) *[2]		
63	BACN10JD106		. . NUT, CASTELLATED (REPLS AN320-6) *[4] *[5]		1
63	BACN10JD106 ASU		. . NUT, CASTELLATED *[11] *[12]		1
64	AN960PD616		. . WASHER *[2]		1
64A	AN960-616L		. . WASHER *[3]		*[15]
64A	AN960XC616L		. . WASHER *[4] *[5]		*[15]
64A	NAS1149C0632B		. . WASHER *[11] *[12]		
65	AN960-616L		DELETED		
65	AN960PD616L		. . WASHER (USED WITH BACB10BH60F9) *[2]		4
65	AN960PD616L		. . WASHER (USED WITH BACB10BH60F8) *[2]		2
66	BACB10BH60F9		. . BEARING, NEEDLE (BACB10BH60F8 OPT) *[2]		1
66	BACB10BH60F8		. . BEARING, NEEDLE (OPT TO BACB10BH60F9) *[2]		1
66	BACB10BH60CF6		. . BEARING, NEEDLE (BACB10AF6F3H, BACB10AF6F6H OPT) *[3]		1
66	BACB10AF6F3H		. . BEARING, NEEDLE (OPT TO BACB10BH60CF6) *[3]		1
66	BACB10AF6F6H		. . BEARING, NEEDLE (OPT TO BACB10BH60CF6) *[3]		1
66	BACB10FK6F6HS		. . BEARING, NEEDLE *[4] *[5]		1
66	KRP141500VT6-6		. . BEARING, NEEDLE (V50632) *[12] *[13]		1
67	90-7815-3		. . ARM, CRANK *[3]		1
67	69-38733-2		. . ARM, CRANK *[2]		1
67	90-7815-21		. . ARM, CRANK *[4]		1
67	90-7815-19		. . ARM, CRANK *[5]		1
67	90-7815-27		. . ARM, CRANK *[12]		1
67	90-7815-29		. . ARM, CRANK *[13]		1
68	69-38732-1		. CRANK ASSY, CAM FOLLOWER (USED ON 65-45871-2) *[1]		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1102-					
68	90-7815-4		. CRANK ASSY, CAM FOLLOWER (USED ON 65-45871-2) *[1]		1
68	90-7815-4		. CRANK ASSY, CAM FOLLOWER (USED ON 65-45871-517, -523)		1
68	90-7815-16		. CRANK ASSY, CAM FOLLOWER (USED ON 65-45871-132, -523) *[1] (OPT TO 90-7815-18)		1
68	90-7815-16		. CRANK ASSY, CAM FOLLOWER (USED ON 65-45871-114, -124, -133) (OPT TO 90-7815-18)		1
68	90-7815-18		. CRANK ASSY, CAM FOLLOWER (USED ON 65-45871-132, -523) *[1] (OPT TO 90-7815-16)		1
68	90-7815-18		. CRANK ASSY, CAM FOLLOWER (USED ON 65-45871-114, -124, -133) (OPT TO 90-7815-16)		1
68	90-7815-24		. CRANK ASSY, CAM FOLLOWER (USED ON 65-45871-132) (OPT TO 90-7815-26) *[1]		1
68	90-7815-26		. CRANK ASSY, CAM FOLLOWER (USED ON 65-45871-132) (OPT TO 90-7815-24) *[1]		1
69	AN380-3-3		. . PIN, COTTER *[7]		1
69	MS24665-283		. . PIN, COTTER *[6] *[8] *[9]		1
70	AN320-6		. . NUT, CASTELLATED *[7]		1
70	BACN10JD6		. . NUT, CASTELLATED (REPLS AN310-6) (USED WITH BACB10BH60F9) *[6]		1
70	BACN10JD106		. . NUT, CASTELLATED (REPLS AN320-6) (USED WITH BACB10BH60F8) *[6]		1
70	BACN10JD106		. . NUT, CASTELLATED *[8] *[9]		1
70	BACN10JD106 ASU		. . NUT, CASTELLATED *[14] *[15]		1
71	AN960PD616		. . WASHER *[6]		1
71A	AN960-616L		. . WASHER *[7]		*[15]
71A	AN960XC616L		. . WASHER *[8] *[9]		*[15]
71A	NAS1149C0632B		. . WASHER *[14] *[15]		*[16]
72	AN960PD616L		. . WASHER (USED WITH BACB10BH60F9) *[6]		4
72	AN960PD616L		. . WASHER (USED WITH BACB10BH60F8) *[6]		2
73	BACB10BH60F9		. . BEARING, NEEDLE (BACB10BH60F8 OPT) *[6]		1
73	BACB10BH60F8		. . BEARING, NEEDLE (OPT TO BACB10BH60F9) *[6]		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1102-					
73	BACB10BH60CF6		. . BEARING, NEEDLE (BACB10AF6F6H OPT) *[7]		1
73	BACB10AF6F6H		. . BEARING, NEEDLE (OPT TO BACB10BH60CF6) *[7]		1
73	KRP141500VT6-6		. . BEARING, NEEDLE (V50632) *[14] *[15]		1
74	90-7815-5		. . ARM, CRANK *[7]		1
74	69-38732-2		. . ARM, CRANK *[6]		1
74	90-7815-22		. . ARM, CRANK *[8]		1
74	90-7815-20		. . ARM, CRANK *[9]		1
74	90-7815-28		. . ARM, CRANK *[14]		1
74	90-7815-30		. . ARM, CRANK *[15]		1
75	BACN10JC3		. NUT (REPLS NAS679A3W)		4
76	NAS1197-10		. WASHER		4
77	NAS1103-9		. BOLT		2
78	BACB30LU3-4		. BOLT (REPLS NAS333CPA5)		1
79	NAS1103-5		. BOLT		1
80	63-1059		. RETAINER, BEARING		2
81	BACB10BW21		. BEARING (REPLS BACB10A822)		2
82	BACB10BW23		. BEARING (REPLS BACB10A823)		2
83	BACW10P148AL		. WASHER		AR
84	MS16625-162		. RING, INTERNAL RETAINING		1
85	BACB10BX12		. BEARING (REPLS BACB10A685)		1
86	BACB10BW25		. BEARING (REPLS BACB10A824, MS20202KP25B, AN202KP25B) (PRE SB 52-1094, R1, R2, R3)		2
86	PACMKP25BA390		. BEARING (V21335)(POST SB 52-1094R1)		2
86	BACB10FR25		. BEARING (POST SB 52-1094R2, R3) *[16]		2
87	65-1642-11		. HOUSING ASSY, HANDLE MECHANISM (USED ON 65-45871-523) *[1]		1
87	65-1642-11		. HOUSING ASSY, HANDLE MECHANISM (USED ON 65-45871-2, -517)		1
87	65-1642-25		. HOUSING ASSY, HANDLE MECHANISM (USED ON 65-45871-132, -523) *[1] (OPT TO 65-1642-27)		1
87	65-1642-25		. HOUSING ASSY, HANDLE MECHANISM (USED ON 65-45871-114, -124, -133) (OPT TO 65-1642-27)		1
87	65-1642-27		. HOUSING ASSY, HANDLE MECHANISM (USED ON 65-45871-132, -523) *[1] (OPT TO 65-1642-25)		1
87	65-1642-27		. HOUSING ASSY, HANDLE MECHANISM (USED ON 65-45871-114, -124, -133) (OPT TO 65-1642-25)		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1102-					
87	65-1642-42		. HOUSING ASSY, HANDLE MECHANISM (USED ON 65-45871-132) *[1]		1
87	65-1642-46		. HOUSING ASSY, HANDLE MECHANISM (USED ON 65-45871-132) *[1]		1
88	65-1642-10		. . HOUSING (USED ON 65-1642-11)		1
88	65-1642-26		DELETED		
88	65-1642-34		. . HOUSING (USED ON 65-1642-25)		1
88	65-1642-35		. . HOUSING (USED ON 65-1642-27)		1
88	65-1642-44		. . HOUSING (USED ON 65-1642-42)		1
88	65-1642-47		. . HOUSING (USED ON 65-1642-46)		1
89	65C36793-1		. . BUSHING (USED ON 65-1642-42, -46)		2
90	BACR15BA3B		. . RIVET (REPLS MS20246B3) (USED ON 65-1642-11, -25, -27)		32
90	BACR15BA3AD		. . RIVET (USED ON 65-1642-42, -46)		32
91	BACN10JR3		. . NUTPLATE (REPLS NAS680A3) (USED ON 65-1642-11, -25, -27)		4
91	BACN10JP3ACD		. . NUTPLATE (USED ON 65-1642-42, -46)		4
92	BACN10KE4E4		. . NUTPLATE (USED ON 65-1642-11, -25, -27) (PREF)		12
92	NAS1792A4-4		. . NUTPLATE (USED ON 65-1642-11, -25, -27) (OPT TO BACN10KE4E4)		12
92	BACN10JA4CD		. . NUTPLATE (USED ON 65-1642-42, -46)		12
93	BACR15GF5D		. . RIVET (USED ON 65-1642-11, -25, -27, -42, -46)		8
94	NAS463YD416		. . SHIM (USED ON 65-1642-11, -25, -27)		12
95	69-78694-3		. . FILLER (USED ON 65-1642-42, -46)		4
96	69-78694-4		. . FILLER (USED ON 65-1642-42, -46)		4

*[1] LIMITED
*[2] USED ON 69-38733-1
*[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] NOT USED ON ALL POST SERVICE BULLETIN CONFIGURATIONS
*[11] USED ON 90-7815-23
*[12] USED ON 90-7815-25

*[13] USED ON 90-7815-24
*[14] USED ON 90-7815-26
*[15] USE ONE WASHER ADJACENT TO THE HEAD OF THE BEARING (66, 73). USE A MAXIMUM OF 5 WASHERS ADJACENT TO THE NUT (63, 70) TO GET THE CORRECT NUT TORQUE AND COTTER PIN INSTALLATION.
*[16] THE TORQUE TUBE ASSEMBLY KIT CONSISTS OF: SLEEVE 60-4365-3 (FIG. 1101); LINK PIN-HINGE 66-14527-6 (FIG. 1101); CRANK 69-17330-3 (FIG. 1102); TORQUE TUBE 90-6753-17 (FIG. 1102); WASHERS AN960C416L (FIG. 1101), AN960C516L (FIG. 1102); BEARING BACB10FR25 (FIG. 1102); BOLTS BACB30NM4K26 (FIG. 1101), BACB30NM5K29 (FIG. 1102); NUTS BACN10YR4CD (FIG. 1101), BACN10YR5CD (FIG. 1102).

VENDORS

V09455	RBC TRANSPORT DYNAMICS CORP., 3131 W. SEGERSTROM AVE., SANTA ANA, CALIFORNIA 92704-5872
V21335	TIMKEN US CORP., FAFNIR BEARING DIV., 59 FIELD ST., TORRINGTON, CONNECTICUT 06790-1008
V50632	KAMATICS CORP., 1335 BLUE HILLS RD., BLOOMFIELD, CONNECTICUT 06002-1303
V73134	ROLLER BEARING CO. OF AMERICA DBA HEIM BEARINGS DIV., 60 ROUND HILL RD., FAIRFIELD, CONNECTICUT 06430
V75345	KIRKHILL RUBBER CO., 300 E. CYPRESS ST., BREA, CALIFORNIA 92821-4097
V77896	REXNORD INDUSTRIES, INC., BEARING OPERATION, 2400 CURTISS ST., DOWNER'S GROVE, ILLINOIS 60515-0722
V81376	SMITH ACQUISITION CO., DBA SOUTHWEST PRODUCTS CO., 2240 BUENA VISTA, IRWINDALE, CALIFORNIA 91010-3318

Part No.	Fig. and Index No.	Qty. per Assy.
AN316-5R	1101-83	1
AN316-5R	1101-88	1
AN316-5R	1101-93	2
AN316-5R	1101-98	2
AN316-6R	1102-49	1
AN316-8R	1102-49	1
AN320-6	1102-63	1
AN320-6	1102-70	1
AN380-3-3	1102-62	1
AN380-3-3	1102-69	1
AN6227-17	1102-33	1
AN6227-19	1101-180	2
AN6227-28	1102-30	1
AN960-10L	1101-145	8
AN960-1716	1101-179	2
AN960-4	1101-28	12
AN960-416	1101-171	8
AN960-416	1101-74	3
AN960-416	1101-74	4
AN960-616	1102-4A	AR
AN960-616L	1102-64A	*[15]
AN960-616L	1102-65	
AN960-616L	1102-71A	*[15]
AN960C10L	1101-136	8
AN960C10L	1101-136	8
AN960C10L	1101-145	8
AN960C10L	1101-145	8
AN960C1716L	1101-179	2
AN960C1716L	1101-179	2
AN960C416L	1101-171	8
AN960C416L	1101-171	8
AN960C516L	1102-40	2
AN960D10	1101-164	16
AN960D10	1101-188	27
AN960D10	1101-25	3
AN960D10L	1101-102	
AN960D10L	1102-28	4
AN960D416L	1101-3B	1
AN960PD10L	1101-104B	AR
AN960PD10L	1101-105A	AR
AN960PD10L	1101-136	8
AN960PD10L	1101-14	48
AN960PD10L	1101-153	16
AN960PD10L	1101-176	4
AN960PD10L	1101-194	4
AN960PD10L	1101-201	4
AN960PD10L	1101-43	3
AN960PD10L	1101-7	12

Part No.	Fig. and Index No.	Qty. per Assy.
AN960PD10L	1102-7	4
AN960PD416L	1101-80	2
AN960PD416L	1102-54	2
AN960PD516L	1101-142	32
AN960PD516L	1101-47	4
AN960PD516L	1102-40	2
AN960PD516L	1102-44	2
AN960PD616	1102-64	1
AN960PD616	1102-71	1
AN960PD616L	1102-65	2
AN960PD616L	1102-65	4
AN960PD616L	1102-72	2
AN960PD616L	1102-72	4
AN960XC616L	1102-64A	*[15]
AN960XC616L	1102-71A	*[15]
AN996-14	1102-15	1
BACB10A187L	1101-82	1
BACB10A187L	1101-82A	1
BACB10A187L	1101-87	1
BACB10A187L	1101-87A	1
BACB10A187L	1101-92	2
BACB10A187L	1101-92A	1
BACB10A187L	1101-97	2
BACB10A187L	1101-97A	1
BACB10A187M2L	1101-82	1
BACB10A187M2L	1101-82A	1
BACB10A187M2L	1101-87	1
BACB10A187M2L	1101-87A	1
BACB10A397GCM2	1101-169	8
BACB10AB4	1101-149B	1
BACB10AF5F9H	1101-143	4
BACB10AF5F9H	1101-48	1
BACB10AF6F3H	1102-66	1
BACB10AF6F6H	1102-66	1
BACB10AF6F6H	1102-73	1
BACB10BH59F7	1101-143	4
BACB10BH59F7	1101-48	1
BACB10BH60CF6	1102-66	1
BACB10BH60CF6	1102-73	1
BACB10BH60F8	1102-66	1
BACB10BH60F8	1102-73	1
BACB10BH60F9	1102-66	1
BACB10BH60F9	1102-73	1
BACB10BW21	1102-81	2
BACB10BW23	1102-82	2
BACB10BW25	1102-86	2
BACB10BX12	1102-85	1
BACB10FK6F6HS	1102-66	1

Part No.	Fig. and Index No.	Qty. per Assy.
BACB10FR25	1102-86	2
BACB10Y4	1101-82A	1
BACB10Y4	1101-87A	1
BACB10Y4	1101-92A	1
BACB10Y4	1101-97A	1
BACB30EL3-5	1101-103	
BACB30LH3-10	1102-8	4
BACB30LH3-11	1102-8	4
BACB30LU3-4	1101-16	8
BACB30LU3-4	1102-78	1
BACB30NE3-3	1101-24	3
BACB30NF4-14	1101-77A	1
BACB30NM3K17	1101-137	8
BACB30NM3K17	1101-137	8
BACB30NM3K17	1101-146	8
BACB30NM3K19	1101-146	8
BACB30NM4K26	1101-172	8
BACB30NM4K26	1101-172	8
BACB30NM5K29	1102-41	2
BACN10JA4CD	1102-92	12
BACN10JC04	1101-27	6
BACN10JC3	1101-13	40
BACN10JC3	1101-135	8
BACN10JC3	1101-13A	8
BACN10JC3	1101-144	8
BACN10JC3	1101-152	16
BACN10JC3	1101-163	16
BACN10JC3	1101-187	27
BACN10JC3	1102-6	4
BACN10JC3	1102-75	4
BACN10JC4	1101-170	8
BACN10JC4	1101-46	1
BACN10JC4	1101-73	5
BACN10JC4	1101-73	6
BACN10JC4	1102-53	2
BACN10JC5	1102-39	2
BACN10JC5	1102-43	1
BACN10JC6	1102-4	1
BACN10JD105	1101-141	4
BACN10JD106	1102-63	1
BACN10JD106	1102-70	1
BACN10JD106	1102-70	1
BACN10JD106 ASU	1102-63	1
BACN10JD106 ASU	1102-70	1
BACN10JD6	1102-4	1
BACN10JD6	1102-63	1
BACN10JD6	1102-70	1
BACN10JP3ACD	1102-91	4

Part No.	Fig. and Index No.	Qty. per Assy.
BACN10JR3	1101-12B	20
BACN10JR3	1102-91	4
BACN10JZ3A2	1101-12A	8
BACN10KE4E4	1102-92	12
BACN10TL3-3	1101-3A	4
BACN10YR3CD	1101-135	8
BACN10YR3CD	1101-135	8
BACN10YR3CD	1101-144	8
BACN10YR3CD	1101-144	8
BACN10YR4CD	1101-170	8
BACN10YR4CD	1101-170	8
BACN10YR4CD	1101-73A	1
BACN10YR5CD	1102-39	2
BACR12AG2C	1101-3	4
BACR15BA3AD	1102-90	32
BACR15BA3B	1102-90	32
BACR15BA3D	1101-11B	56
BACR15BA5D	1102-21	3
BACR15BB3D	1101-94	1
BACR15BB3D	1101-99	1
BACR15BB5D	1101-84	1
BACR15BB5D	1101-89	1
BACR15CE5D	1102-31	4
BACR15GF5D	1102-93	8
BACS11W3	1101-191	27
BACS11W3	1102-29	4
BACS21AP180RP	1101-2	4
BACS40A12-12	1101-31	AR
BACS40A12-40	1101-156	AR
BACS40A1652	1102-3	2
BACS40B11-11	1102-23	AR
BACS40B12-12	1101-32	AR
BACS40B12-26	1102-24	AR
BACS40B16-69	1101-107	AR
BACS40B16-73	1101-109	AR
BACS40C16-147	1101-108	AR
BACS40C16-188	1101-106	AR
BACS40C16-217	1101-110	AR
BACS40C16-262	1101-111	AR
BACS40H1668	1102-2	2
BACS40R007B007F	1101-31	AR
BACS40R007C007F	1101-32	AR
BACS40RE8-16	1101-213	4
BACS40RE8-8	1101-212	4
BACW10BN3AP	1101-11A	28
BACW10P148AL	1102-83	AR
DREM5-019	1102-50	2
DREM5-023	1102-50	2

Part No.	Fig. and Index No.	Qty. per Assy.
KRP141500VT6-6	1102-66	1
KRP141500VT6-6	1102-73	1
MS15001-4	1101-167	1
MS16562-209	1101-121	2
MS16562-209	1101-128	2
MS16562-210	1101-121	2
MS16562-210	1101-128	2
MS16625-162	1102-84	1
MS20253P2-2910	1101-122	1
MS20253P2-2910	1101-129	1
MS20615-5M10	1102-48	1
MS21209F1-15	1101-182	4
MS21209F1-15	1101-185	4
MS21209F5-15	1102-25	3
MS24665-134	1101-140	4
MS24665-283	1102-3A	1
MS24665-283	1102-62	1
MS24665-283	1102-69	1
MS24665-360	1102-37	2
MS39086-111	1102-13	1
MXJ45-14BFG-2	1101-87	1
NAS1103-11	1102-27	4
NAS1103-16	1101-137	8
NAS1103-18	1101-146	8
NAS1103-2	1101-15	40
NAS1103-3	1101-165	16
NAS1103-3	1101-189	21
NAS1103-4	1101-190	6
NAS1103-4	1101-42	1
NAS1103-5	1102-79	1
NAS1103-7W	1101-193	4
NAS1103-7W	1101-200	4
NAS1103-9	1102-77	2
NAS1104-12	1101-78	2
NAS1104-13	1101-77	3
NAS1104-13	1101-77	4
NAS1104-14	1102-1	12
NAS1104-17	1101-76	2
NAS1104-25	1101-172	8
NAS1104-5	1102-56	1
NAS1104-6	1102-57	1
NAS1104-7	1101-41	2
NAS1105-12	1102-46	
NAS1105-15	1102-46	1
NAS1105-16	1102-45	1
NAS1105-29	1102-41	2
NAS1149C0632B	1102-64A	
NAS1149C0632B	1102-71A	*[16]

Part No.	Fig. and Index No.	Qty. per Assy.
NAS1197-10	1102-76	4
NAS1197-416L	1101-75	2
NAS1303-12	1101-175	4
NAS1503-11	1102-8	4
NAS1792A4-4	1102-92	12
NAS20615-6M6	1102-48	1
NAS333CPA6	1101-17	
NAS463YD416	1102-94	12
NAS514P1032-9	1101-209	1
NAS514P1032-9	1101-210	3
NAS516-1	1101-158	1
NAS516-1	1101-159B	1
NAS516-1	1101-161	1
NAS516-1	1101-167	1
NAS516-1	1102-35	1
NAS516-1A	1101-149C	1
NAS516-1A	1101-158	1
NAS583-3	1101-154	16
NAS583-5	1101-104	10
NAS583-5	1101-104A	2
NAS583-5	1101-105	12
NAS600-8P	1101-29	6
NAS603-10P	1101-10	1
NAS603-9P	1101-11	27
NAS620C-416	1101-74A	1
NAS623-3-3	1101-104	10
NAS623-3-3	1101-105	12
NAS623-3-4	1101-5	8
NAS623-3-5	1101-6	4
NAS623-3-8	1101-104A	2
NAS679A3W	1101-101	
NAS74A4E005P	1101-79	
NAS74A4E006P	1101-79	2
NAS76A16-016P	1101-197	1
NAS76A16-016P	1101-204	1
NAS77A4-18P	1101-113	1
NAS77A4-18P	1101-117	1
PACMKP25BA3908	1102-86	2
REM10ATC12-2	1102-50	2
REM10ATC16-2	1102-50	2
TEM105A	1102-50	2
10-60476-3	1101-216	1
11-667A	1101-92	2
11-667A	1101-97	2
30-3010	1102-16	1
30-3013-1	1102-18	1
30-3013-2	1102-18	1
30-3013-2	1102-18	1

Part No.	Fig. and Index No.	Qty. per Assy.
30-3019	1102-14	1
30-3019-1	1102-14	1
30-3019-1	1102-14	1
30-3035	1102-10	8
514063	1101-40	
60-4365	1101-173	2
60-4365	1101-173	2
60-4365-1	1101-173	2
60-4365-3	1101-173	2
60-4365-3	1101-173	2
60-4405	1102-38	2
60-4405-1	1102-38	2
60-4405-1	1102-38	2
60-4406-12	1101-151	2
60-4406-12	1101-151	2
60-4406-6	1101-151	2
60-4409	1101-147	1
60-4409-1	1101-147	1
60-4409-1	1101-147	1
60-4412	1102-32	1
60-4431	1101-149	1
60-4431-1	1101-149	1
60-4431-1	1101-149	1
60-4431-1	1101-149	1
60-4431-2	1101-149A	1
60-4431-3	1101-149	1
60-4455	1102-19	1
60-4455-1	1102-19	1
60-4455-1	1102-19	1
60-4455-1	1102-19	1
60-4455-1	1102-19	1
60-4455-2	1102-19	1
60-4455-2	1102-19	1
60-4455-3	1102-19	1
63-1059	1102-80	2
63-1478	1101-30	3
63-1692	1102-55	2
63-2848	1102-17	1
63-9386	1102-5	1
65-1642-10	1102-88	1
65-1642-11	1102-87	1
65-1642-11	1102-87	1
65-1642-25	1102-87	1
65-1642-25	1102-87	1
65-1642-26	1102-88	
65-1642-27	1102-87	1
65-1642-27	1102-87	1
65-1642-34	1102-88	1

Part No.	Fig. and Index No.	Qty. per Assy.
65-1642-35	1102-88	1
65-1642-42	1102-87	1
65-1642-44	1102-88	1
65-1642-46	1102-87	1
65-1642-47	1102-88	1
65-1933-11	1102-58	
65-1933-3	1102-58	1
65-1933-3	1102-58	1
65-1933-3	1102-58	1
65-1933-504	1102-58	1
65-1933-504	1102-58	1
65-1933-506	1102-58	1
65-1933-506	1102-58	1
65-1933-6	1102-58	
65-19434-1	1101-196	1
65-19434-2	1101-203	1
65-19434-3	1101-198	1
65-19434-4	1101-205	1
65-2306	1101-166	4
65-2306-1	1101-168	1
65-2306-3	1101-166	4
65-2306-3	1101-166	4
65-2306-4	1101-168	1
65-2863-3	1101-26	1
65-28925-41	1101-96	1
65-28925-41	1101-96	1
65-28925-42	1101-91	1
65-28925-42	1101-91	1
65-28925-43	1101-100	1
65-28925-44	1101-95	1
65-28925-83	1101-96	1
65-28925-83	1101-96	1
65-28925-84	1101-91	1
65-28925-84	1101-91	1
65-44065-10	1102-26A	1
65-44065-8	1102-26	1
65-44065-9	1102-26A	1
65-45871-114	1101-	RF
65-45871-124	1101-	RF
65-45871-132	1101-	RF
65-45871-133	1101-	RF
65-45871-2	1101-	RF
65-45871-49	1101-12	2
65-45871-50	1101-8	1
65-45871-504	1101-214	1
65-45871-504	1101-39	
65-45871-505	1101-215	1
65-45871-505	1101-38	

Part No.	Fig. and Index No.	Qty. per Assy.
65-45871-506	1101-111A	1
65-45871-507	1101-111B	1
65-45871-517	1101-	RF
65-45871-520	1101-111C	AR
65-45871-523	1101-	RF
65-45871-59	1101-9	1
65-45871-87	1101-174	2
65-45871-91	1101-155	AR
65-49560-1	1101-157	2
65-49560-1	1101-157	2
65-49560-10	1101-159	1
65-49560-15	1101-157	2
65-49560-16	1101-159	1
65-49560-2	1101-159	1
65-49560-9	1101-157	2
65-49561-1	1101-159A	1
65-49561-1	1101-159A	1
65-49561-2	1101-160	1
65-49561-2	1101-160	1
65-49561-3	1101-159C	1
65-49561-4	1101-162	1
65-49561-6	1101-159A	1
65-49561-7	1101-160	1
65-49561-9	1101-162	1
65-49563-1	1101-64	2
65-49563-1	1101-64	2
65-49563-2	1101-65	1
65-49563-501	1101-64	2
65-49563-501	1101-64	2
65-49563-502	1101-65	1
65-49583-1	1101-61	1
65-49583-2	1101-67	1
65-49583-3	1101-62	1
65-49583-4	1101-68	1
65-49894-1	1101-52	1
65-49894-1	1101-52	4
65-49894-10	1101-52B	1
65-49894-11	1101-53	1
65-49894-12	1101-53	1
65-49894-13	1101-52C	2
65-49894-14	1101-53	1
65-49894-2	1101-53	1
65-49894-3	1101-52A	1
65-49894-4	1101-53	1
65-49894-5	1101-52B	1
65-49894-501	1101-52	4
65-49894-501	1101-52	4
65-49894-502	1101-53	1

Part No.	Fig. and Index No.	Qty. per Assy.
65-49894-6	1101-53	1
65-49894-7	1101-52C	2
65-49894-8	1101-53	1
65-49894-9	1101-52A	1
65-49939-1	1101-125	1
65-49939-1	1101-132	1
65-49939-2	1101-134	2
65-50572-1	1101-112	1
65-50572-2	1101-114	1
65-50572-4	1101-112	1
65-50572-5	1101-114	1
65-50572-501	1101-112	1
65-50572-502	1101-114	1
65-50572-503	1101-112	1
65-50572-503	1101-112	1
65-50572-504	1101-114	1
65-50573-1	1101-116	1
65-50573-2	1101-118	1
65-50573-4	1101-116	1
65-50573-5	1101-118	1
65-50573-501	1101-116	1
65-50573-501	1101-116	1
65-50573-502	1101-118	1
65-51672-1	1101-58	1
65-51672-1	1101-58	1
65-51672-2	1101-59	1
65-51672-3	1101-58	1
65-51672-4	1101-59	1
65-51673-1	1101-55	1
65-51673-1	1101-55	1
65-51673-2	1101-56	1
65-51673-3	1101-55	1
65-51673-4	1101-56	1
65-51674-1	1101-49	1
65-51674-2	1101-50	1
65-51674-501	1101-49	1
65-51674-501	1101-49	1
65-51674-502	1101-50	1
65-51675-1	1101-70	1
65-51675-2	1101-71	1
65-51675-501	1101-70	1
65-51675-501	1101-70	1
65-51675-502	1101-71	1
65-52855-1	1101-120	1
65-52855-2	1101-127	1
65-52855-3	1101-123	1
65-52855-4	1101-130	1
65-52855-5	1101-126	1

Part No.	Fig. and Index No.	Qty. per Assy.
65-52855-5	1101-133	1
65-52855-501	1101-120	1
65-52855-501	1101-120	1
65-52855-502	1101-127	1
65-52855-502	1101-127	1
65-52855-503	1101-123	1
65-52855-504	1101-130	1
65-52855-505	1101-126	1
65-52855-505	1101-133	1
65-52855-6	1101-124	1
65-52855-7	1101-131	1
65-54013	1102-60	1
65-54013-503	1102-60	1
65-54013-503	1102-60	1
65-54024-3	1102-58	1
65-73978-1	1101-181	1
65-73978-10	1101-186	1
65-73978-12	1101-186	1
65-73978-14	1101-186	1
65-73978-2	1101-184	1
65-73978-2	1101-184	1
65-73978-2	1101-184	1
65-73978-3	1101-183	1
65-73978-4	1101-186	1
65-73978-7	1101-181	1
65-73978-7	1101-181	1
65-73978-8	1101-184	1
65-73978-9	1101-183	1
65-8795-801	1102-59	1
65C34068-1	1101-120	1
65C34068-10	1101-130	1
65C34068-2	1101-127	1
65C34068-3	1101-120	1
65C34068-3	1101-120	1
65C34068-4	1101-123	1
65C34068-5	1101-126	1
65C34068-5	1101-133	1
65C34068-6	1101-130	1
65C34068-7	1101-123	1
65C34068-8	1101-126	1
65C34068-8	1101-133	1
65C34068-9	1101-127	1
65C34068-9	1101-127	1
65C36793-1	1102-89	2
66-12687-1	1101-208	16
66-12688-1	1101-115	2
66-12688-1	1101-119	2
66-12688-1	1101-51	1

Part No.	Fig. and Index No.	Qty. per Assy.
66-12688-1	1101-54	1
66-12688-1	1101-57	1
66-12688-1	1101-60	1
66-12688-1	1101-63	1
66-12688-1	1101-66	1
66-12688-1	1101-69	1
66-12688-1	1101-72	1
66-14302-1	1102-47	1
66-14302-2	1102-51	1
66-14315-1	1101-202	1
66-14315-2	1101-195	1
66-14527-1	1101-177	2
66-14527-2	1101-177	2
66-14527-2	1101-177	2
66-14527-4	1101-177	2
66-14527-6	1101-177	2
66-14527-6	1101-177	2
66-14531-1	1101-148	1
66-14531-11	1101-150	1
66-14531-11	1101-150	1
66-14531-5	1101-150	1
66-14531-9	1101-148	1
66-14531-9	1101-148	1
66-14618-13	1101-90	1
66-14618-4	1101-90	1
66-14618-5	1101-85	1
66-15332-1	1101-139	AR
66-15645-1	1101-178	2
66-16691-1	1101-207	16
66-1921-1	1101-37	1
66-2646	1101-33	1
69-1083	1101-35	1
69-1084	1101-36	1
69-17330-1	1102-52	1
69-17330-3	1102-52	1
69-17330-3	1102-52	1
69-17789-1	1101-45	1
69-17952-17	1101-181	1
69-17952-18	1101-184	1
69-17952-19	1101-183	1
69-17952-20	1101-186	1
69-18187-20	1101-86	1
69-18187-21	1101-81	1
69-18187-21	1101-81	1
69-18187-24	1101-86	1
69-18187-24	1101-86	1
69-18187-27	1101-86	1
69-18187-5	1101-86	1

Part No.	Fig. and Index No.	Qty. per Assy.
69-18187-5	1101-86	1
69-18187-6	1101-81	1
69-18187-6	1101-81	1
69-1983	1101-34	1
69-20324-10	1101-211	2
69-20407-1	1101-192	1
69-20407-2	1101-199	1
69-20407-6	1101-192	1
69-20407-7	1101-199	1
69-34971-1	1102-20	1
69-34971-2	1102-22	1
69-34971-3	1102-26	1
69-34971-4	1102-20	1
69-34971-4	1102-20	1
69-34971-5	1102-26	1
69-34971-6	1102-20	1
69-34971-7	1102-26	1
69-34971-8	1102-20	1
69-37418-11	1101-138	4
69-37418-2	1101-138	4
69-37418-501	1101-138	4
69-37418-501	1101-138	4
69-37418-501	1101-138	4
69-37418-501	1101-138	4
69-37418-501	1101-138	4
69-37418-8	1101-138	4
69-37418-8	1101-138	4
69-37418-8	1101-138	4
69-37418-8	1101-138	4
69-37495-1	1101-44	1
69-37495-1	1101-44	1
69-37495-501	1101-44	1
69-37495-502	1101-44	1
69-38732-1	1102-68	1
69-38732-2	1102-74	1
69-38733-1	1102-61	1
69-38733-2	1102-67	1
69-39176-1	1102-47	1
69-39176-2	1102-51	1
69-41276-1	1101-21	1
69-41276-2	1101-18	1
69-41276-3	1101-22	1
69-41276-4	1101-19	1
69-41276-5	1101-20	1
69-41276-5	1101-23	1
69-42595-3	1101-1	1
69-42595-4	1101-4	1
69-42595-5	1101-1	1

Part No.	Fig. and Index No.	Qty. per Assy.
69-42595-5	1101-1	1
69-42595-6	1101-1	1
69-42595-7	1101-4	1
69-42595-8	1101-1	1
69-42595-8	1101-1	1
69-42595-9	1101-4	1
69-61511-1	1102-34	1
69-61511-1	1102-34	1
69-61511-2	1102-36	1
69-70269-1	1101-202	1
69-70269-2	1101-195	1
69-78694-3	1102-95	4
69-78694-4	1102-96	4
77253	1102-50	2
77266	1102-50	2
90-6753-10	1102-42	1
90-6753-17	1102-42	1
90-6753-17	1102-42	1
90-6753-17	1102-42	1
90-6753-22	1102-42	1
90-6753-5	1102-42	1
90-6753-5	1102-42	1
90-7811	1102-11	1
90-7815-1	1102-61	1
90-7815-1	1102-61	1
90-7815-15	1102-61	1
90-7815-15	1102-61	1
90-7815-16	1102-68	1
90-7815-16	1102-68	1
90-7815-17	1102-61	1
90-7815-17	1102-61	1
90-7815-18	1102-68	1
90-7815-18	1102-68	1
90-7815-19	1102-67	1
90-7815-20	1102-74	1
90-7815-21	1102-67	1
90-7815-22	1102-74	1
90-7815-23	1102-61	1
90-7815-24	1102-68	1
90-7815-25	1102-61	1
90-7815-26	1102-68	1
90-7815-27	1102-67	1
90-7815-28	1102-74	1
90-7815-29	1102-67	1
90-7815-3	1102-67	1
90-7815-30	1102-74	1
90-7815-4	1102-68	1
90-7815-4	1102-68	1

Part No.	Fig. and Index No.	Qty. per Assy.
90-7815-5	1102-74	1
90-7820	1102-34	1
90-7820-1	1102-36	1
90-7821	1102-12	1
90-7879-1	1102-9	1
90-7879-1	1102-9	1
90-7879-10	1102-9	1
90-7879-6	1102-9	1

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