



OVERHAUL MANUAL

TO: ALL HOLDERS OF ACCESS AND BLOWOUT DOOR BUILDUP OVERHAUL MANUAL, 52-46-09

REVISION NO. 1, DATED DEC 5/92

HIGHLIGHTS

DESCRIPTION OF CHANGE	TOPICS AFFECTED												
	D & O	D / A S S Y	C l e a n i n g	I n s p / C h k	R e p a i r	A S S Y	F / C	T e s t	T / S h o o t i n g	S / T o o l s	S t o r a g e	I P L	L / O v e r h a u l
Beginning with this revision separate consecutively numbered highlight sheets will be provided whenever this subject is revised													
Added door assemblies 65-46583-44, -522 and 65C35450-1 to the IPL per PRR 35063					X							X	



OVERHAUL MANUAL

ACCESS AND BLOWOUT DOOR BUILDUP

52-46-09

BOEING P/N NO ASSIGNED PART NUMBER

AIRLINE P/N

THE FOLLOWING DIRECTIVES APPLY TO THIS SUBJECT:

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVES	DATE DIRECTIVE INCORPORATED INTO TEXT
1		PRR 35063	Dec 5/92

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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
52-46-09					
* T-1	Dec 5/92				
T-2	BLANK				
* LEP-1	Dec 5/92				
LEP-2	BLANK				
T/C-1	Aug 15/69				
T/C-2	BLANK				
1	Aug 15/69				
2	Aug 15/69				
101	Aug 15/69				
102	Aug 15/69				
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202	BLANK				
301	Aug 15/69				
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1103	Aug 15/69				
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* 1106	Dec 5/92				
* 1107	Dec 5/92				
* 1108	Dec 5/92				
* 1109	Dec 5/92				
* 1110	Dec 5/92				

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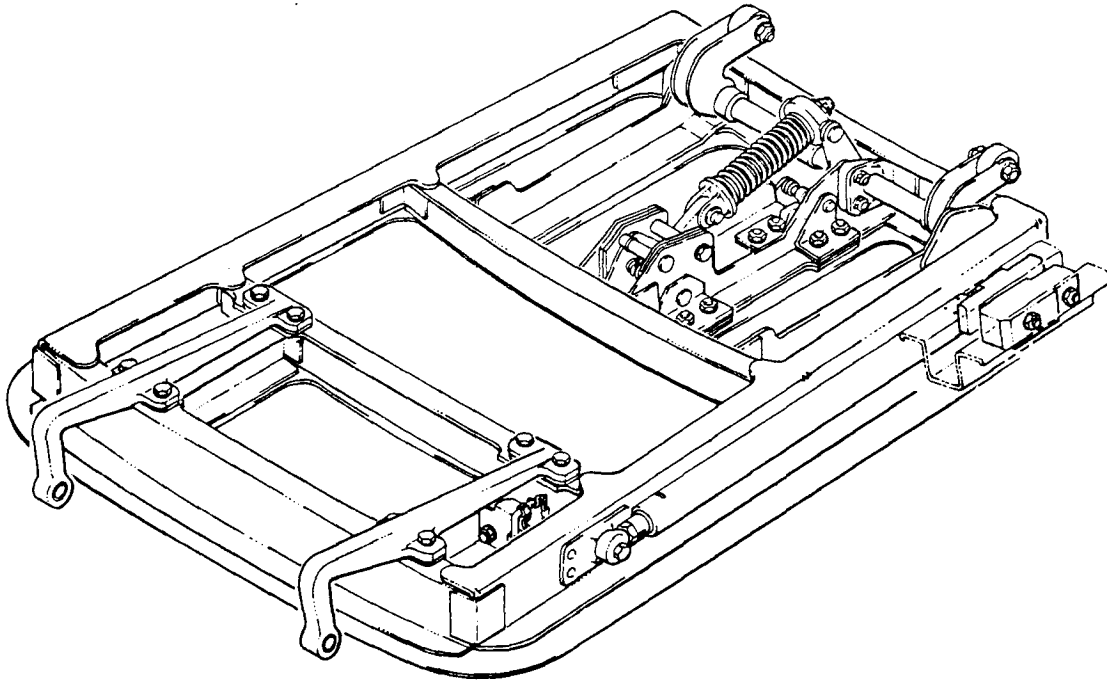
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Illustrated Parts List	1101
Numerical Parts List Index	None

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ACCESS AND BLOWOUT DOOR BUILDUP

No Assigned Part Number



Access and Blowout Door Buildup
Figure 1

DESCRIPTION AND OPERATION

1. Description

- A. The access and blowout door is an outward plug-type door hinged at the lower edge and is operated manually either from the inside or the outside or by pressure buildup from inside the airplane. The latch mechanism consists of two latching rollers connected to a spring assembly through a torque tube.

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2. Operation

- A. The access and blowout door is opened from the inside or the outside by operating a trigger, which allows the latch mechanism to swing outward and forward. This pushes the rollers out of their detents and releases the door. In case of pressure bulkhead leakage or rupture of the air conditioning duct, the door is designed to automatically open when the pressure reaches a predetermined level.

3. Leading Particulars

Height -- 3.50 inches (approximately)
Width -- 18.00 inches (approximately)
Length -- 24.00 inches (approximately)
Weight -- 7.10 pounds (approximately)

DISASSEMBLY

1. Remove nuts (1, figure 1101), bolts (2), and washers (3).
2. Remove shims (4) and hinge assemblies (5).

NOTE: Do not remove hinge (6) or bearing (7) unless repair or replacement is necessary.

3. Remove nut (9), washer (10), and bolt (11).
4. Remove bolt (12), adapter assembly (13), nuts (16), washers (17), bolts (18), and block (19).

NOTE: These parts may be left installed in the airplane. Do not remove adapter (14) or insert (15) unless repair or replacement is necessary.

5. Remove lockwire at both ends of jury strut assembly (20).
6. Remove rod end bearings (28) and nuts (29).
7. Remove roll pins (30), end fitting (31), and spring (32).
8. Separate inner tube assembly (21) from outer tube assembly (25).

NOTE: Do not remove items (22, 23, 24, 26, 27, and 33 through 42) unless repair or replacement is necessary.

9. Remove cotter pin (46) and nut (47).
10. Remove pins (48 and 49), washers (50), cap assembly (51), and spring (54).

NOTE: Do not remove cap (52) or bearing (53) unless repair or replacement is necessary.

11. Remove cotter pin (55), washer (56), flathead pin (57), and rod (58).
12. Disengage spring (64) and remove spring pin (59), handle (60), and spring pin (61).
13. Remove flathead pin (62), washers (63), spring (64), and trigger assembly (65).

NOTE: Do not remove items (66 through 68) unless repair or replacement is necessary.

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14. Remove nuts (69), washers (70), bolts (71), and bearing plate assemblies (72).

NOTE: Do not remove items (73 and 74) unless repair or replacement is necessary.

15. Remove torque shaft assembly (75) from the door structure.

16. Remove pins (76) and lever assembly (77).

17. Remove nut (80), washers (81), bolt (82), bearing (79), and levers (78).

18. Remove lever assembly (83).

19. Remove nut (86), washers (87), bolt (88), bearing (85), and levers (84).

20. Remove lever assemblies (89), torque shaft (92), and washers (93).

NOTE: Do not remove lever (90) or bearing (91) unless repair or replacement is necessary.

21. Remove nut (94), washers (95), bolt (96), and spacer (97).

22. Remove cotter pin (98), washer (99), pin (100), and spacer (101).

WARNING: USE CARE TO PREVENT INJURY DUE TO RECOIL OF SPRINGS (105 AND 106).

23. Remove cotter pin (102), washer (103), flathead pin (104), springs (105 and 106), and link assembly (107).

NOTE: Do not remove link (108) or bearings (109 and 110) unless repair or replacement is necessary.

24. Remove nuts (111), washers (112), bolts (113), keeper (114), and shim (115).

25. Remove latch handle assembly (116).

NOTE: Do not remove items (117 through 123) unless repair or replacement is necessary.

26. Remove nuts (124), washers (125), and bolts (126 and 127).

27. Remove radius fillers (128), bearing blocks (129), laminated shims (130), seals (131), and shims (132).

28. Remove bearing block assemblies (133 and 136) and shims (139).

NOTE: Do not remove bearings (135 and 138) from blocks (134 and 137) unless repair or replacement is necessary.

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CLEANING

1. General

- A. Wash and rinse parts, except bearings, in dry cleaning solvent, Specification P-D-680 or equivalent and dry parts with clean, lint-free cloth, or moisture-free compressed air.
- B. Clean all bores, holes, threads, and metal parts using a stiff bristle brush.
- C. For further information, refer to "General Cleaning Procedures," Subject 20-30-03.

2. Bearings

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

INSPECTION/CHECK

1. Visual Checks

- A. Examine all parts for cracks, burrs, scratches, chips, and corrosion using strong light and 10-power magnification.
- B. Examine all threads for cross-threading and stripping.
- C. Examine all plated and painted surfaces for blisters and flaking.
- D. Check all bearings for roughness, binding, and excessive radial or axial play.

2. Special Checks (See figure 1101.)

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

- (1) Penetrant Check -- Hinge (6), adapter (14), cap (52), rod (58), handle (60), and keeper (114).

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

- (2) Magnetic Particle Examination -- Spring (54).

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

- B. Check springs (32 and 54) for the following:

- (1) Roll springs on flat surface; there should be no wobble.
- (2) Check springs in accordance with figure 301.

NOTE: No permanent set should result from test load.

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Item No. (Figure 1101)	Approximate Free Length (Inches)	Test Length (Inches)	Required Load Limits (Pounds)
32	3.75 to 4.25	1.37	5.18 to 6.34
54	5.28	3.00	36.0 to 44.0
		2.62	42.0 to 52.0

Compression Spring Check Data
Figure 301

D. Check springs (64, 105, and 106) in accordance with figure 302.

Item No. (Figure 1101)	Max. Angular Rotation Without Permanent Set (Degrees)	Test Angular Rotation (Degrees)	Required Moment at Test Angular Rotation (Pound-Inches)
64	150	29	0.45 to 0.55
105, 106	190	115	1.80 to 2.20
		41	0.25 to 0.31
		166	1.03 to 1.25

Torsion Spring Check Data
Figure 302

REPAIR

1. Repair

- A. Remove minor scratches, nicks, and corrosion by polishing lightly with abrasive cloth, 220 grit or finer. Do not exceed limits given in Fig. 601. Refinish as necessary for protection against corrosion.
- B. Repair minor defects in threaded areas with triangular file or thread chaser.

2. Refinish (Fig. 1101)

NOTE: Refer to 20-30-02 for stripping of protective finishes and to 20-41-01 for decoding of F and SRF finish symbols and their BAC equivalents.

- A. If plated or painted surfaces are worn or chipped, refinish the following parts as indicated:
 - (1) Hinge (6) -- Apply SRF-2.30 all over except omit primer in 0.4373 diameter hole.
 - (2) Bearing (7) -- Apply solid film lubricant BMS 3-8 all over per 20-50-08.
 - (3) Adapter (14), Handle (60), and Levers (78 and 84) -- Apply SRF-2.30 all over.
 - (4) Tube Assemblies (21 and 25) -- Apply solid film lubricant BMS 3-8 and dry lubricant per 20-50-08 on sliding surfaces only.
 - (5) Fittings (24 and 31) and Shaft (92) -- Apply F-8.07 all over.
 - (6) Springs (32, 54, 64, 105, and 106) -- Apply SRF-1.92 all over.
 - (7) Pin (34, 151) -- Apply F-8.07 all over. Material is stainless steel bar, 17-4PH per AMS5643, heat treated 180 to 200 ksi.
 - (8) Pins (49, 57, 62, and 104) -- Apply F-8.07 all over plus solid film lubricant BMS 3-8 per 20-50-08. Material is CRES 17-4PH bar per AMS5643 heat treated 180 to 200 ksi.
 - (9) Cap (52) -- Apply SRF-2.30 all over except omit primer in 0.3748 diameter hole.

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- (10) Bearings (53 and 118) -- Apply solid film lubricant BMS 3-8 to inside bore per Subject 20-50-08.
- (11) Rod (58), Trigger (66), and Keeper (114) -- Apply F-8.07 all over. Material is 17-4PH CRES per AMS5643 heat treated 180 to 200 ksi.
- (12) Trigger Assembly (65) -- Apply SRF-12.205 to aluminum surfaces except exterior surface of skin, plus apply solid film lubricant BMS 3-8 per Subject 20-50-08 in the trigger area only.
- (13) Plate (73), Lever (90), Link (108), and Blocks (134 and 137) -- Apply SRF-2.30 all over except omit primer in holes.
- (14) Bearings (74, 91, 109, 110, 135, and 138) -- Apply BMS 3-8 dry lubricant per Subject 20-50-08 inside bore and on ends.
- (15) Handle (117) -- Apply SRF-2.30 all over except omit primer inside 0.3754 diameter hole.
- (16) Filler (128) and Bearing Block (129) -- Apply SRF-2.30 all over.
- (17) Shims (4, 115, 130, 132, and 139) -- Apply F-12.415 all over.

3. Replacement (See figure 1101.)

- A. Replace all parts found unserviceable or damaged beyond simple repair.
- B. Replace all cotter pins and lockwire at each overhaul.
- C. If replacement of bearings (7, 53, 74, 91, 109, 110, 118, 135, and 138) is required, install per "Bearing Installation and Retention," Subject 20-50-03.
- D. Replace springs (32, 54, 64, 105, and 106) if requirements of figures 301 or 302 are not met.
- E. Replace latch assembly (44) if inoperative or unable to satisfy manufacturer's overhaul requirements.

ASSEMBLY

1. Assemble shims (139, figure 1101) and bearing block assemblies (133 and 136).
2. Assemble shims (132), seals (131), laminated shims (130), bearing blocks (129), and radius fillers (128).
3. Install bolts (126 and 127), washers (125), and nuts (124).
4. Position latch handle assembly (116), laminated shim (115), and keeper (114).

NOTE: If new skin (122) is used, bond to latch handle assembly per Subject 20-50-12, type 44. Trim skin to conform to opening in door skin.

5. Install bolts (113), washers (112), and nuts (111).
6. Assemble link assembly (107), springs (105 and 106), flathead pin (104), washer (103), and cotter pin (102).

NOTE: Install cotter pin (102) per Subject 20-50-02.

7. Install spacer (101), straight pin (100), washer (99), and cotter pin (98).

NOTE: Install cotter pin (98) per Subject 20-50-02. Ensure that ends of springs (105 and 106) are in place on spacer (101).

8. Install spacer (97), bolt (96), washers (95), and nut (94).
9. Assemble levers (84), bearing (85), bolt (88), washers (87), and nut (86).
10. Assemble levers (78), bearing (79), bolt (82), washers (81), and nut (80).
11. Assemble lever assemblies (89, 83, and 77), torque shaft (92), washers (93), and bearing plate assembly (72).

NOTE: Loosen torque shaft assembly (75) prior to installing bearing plate assembly (72) to ensure proper alignment of bearings. If new bearing plate assembly (72) is used, drill 0.190 to 0.194 diameter holes countersunk 100° per old plate. If new torque shaft (92) is used, position lever assemblies (77, 83, and 89) and drill holes per figure 501.

12. Install bolts (71), washers (70), and nuts (69).
13. Install pins (76) in holes wet with primer BMS 10-11.

NOTE: The protrusion of pin must be equal at both ends within 0.02 inch.

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14. Assemble trigger assembly (65), spring (64), washers (63), pin (62), and spring pin (61).

NOTE: Install spring pin (61) in hole wet with BMS 10-11 primer; the protrusion must be equal at both ends within 0.02 inch. If new pin (62) is used, drill hole per figure 501.

15. Install handle (60) and spring pin (59).

NOTE: Install spring pin (59) in hole wet with BMS 10-11 primer; the protrusion must be equal at both ends within 0.02 inch.

16. Install rod (58), pin (57), washer (56), and cotter pin (55).

NOTE: Install cotter pin (55) per Subject 20-50-02.

17. Assemble cap assembly (51), washers (50), pin (49), and spring pin (48).

NOTE: Install spring pin (48) in hole wet with BMS 10-11 primer; spring pin (48) should protrude 0.7 to 0.9 inch maximum one side only.

18. Install nut (47) and secure with cotter pin (46).

19. Assemble inner tube assembly (21) and outer tube assembly (25), and spring (32).

20. Install end fitting (31) and roll pins (30).

NOTE: Protrusion to be symmetrical within 0.02 inch.

21. Install nuts (29) and rod end bearings (28) and lock both ends with lockwire MS20995N per Subject 20-50-02.

NOTE: Adjust rod end bearings so distance between centers is 24.66 inches, with jury strut assembly (20) completely extended and spring (32) fully compressed. Rod end bearings should protrude equal amount from tube within 0.20 inch. Tighten nuts (29) to within a torque range of 60 to 85 pound-inches. Lockwire options are MS20995F32, MS20995N32, or MS20995C32.

22. Install block (19), bolts (18), washers (17), nuts (16), adapter assembly (13), and bolt (12) if with door.

NOTE: Tighten bolt (12) to within a torque range of 25 to 30 pound-inches.

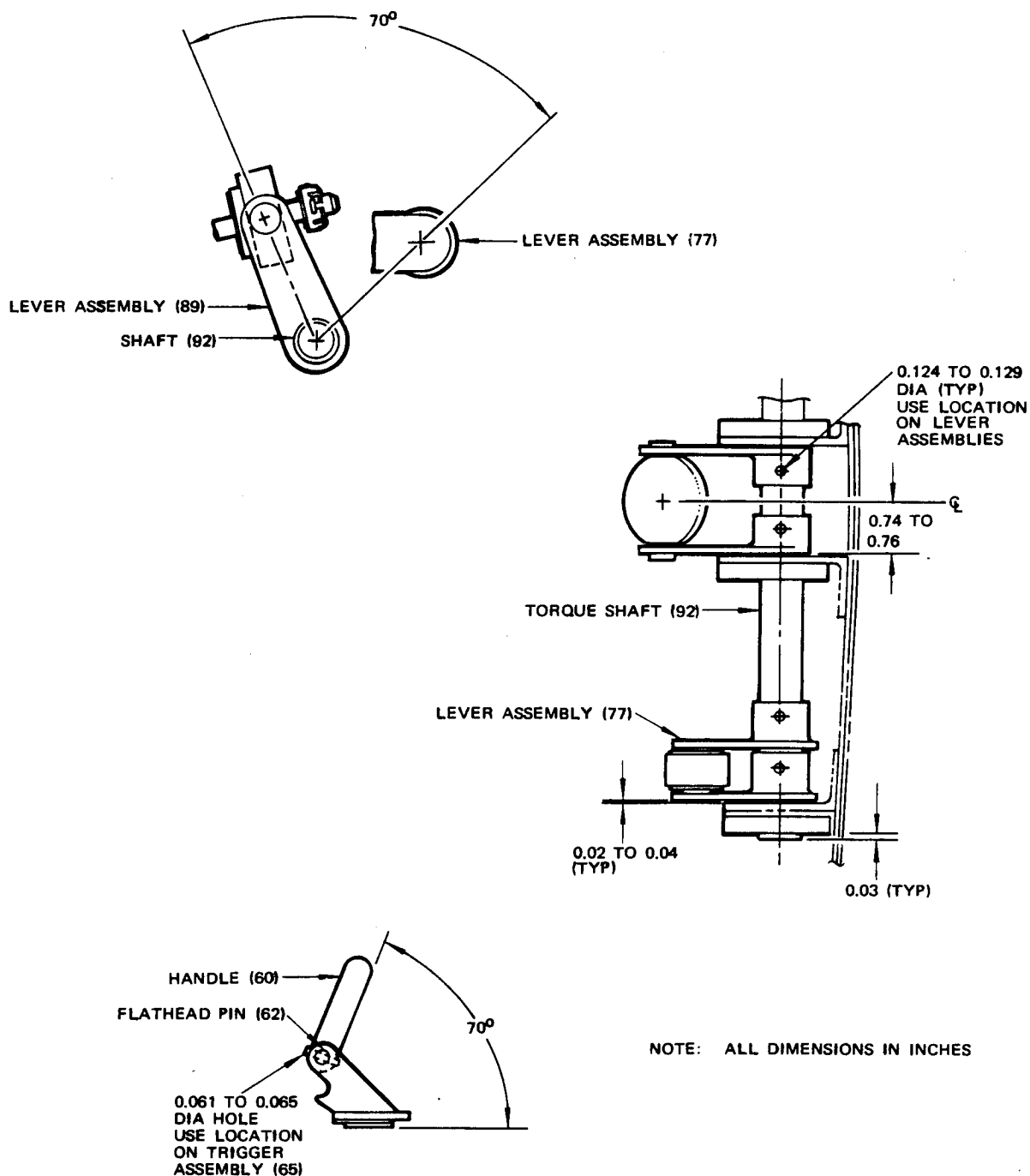
23. Install bolt (11), washer (10), and nut (9).

NOTE: Tighten bolt (11) to within a torque range of 25 to 30 pound-inches.

24. Install shims (4), hinge assemblies (5), washers (3), bolts (2), and nuts (1).

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Aug 15/69
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Assembly Details
 Figure 501

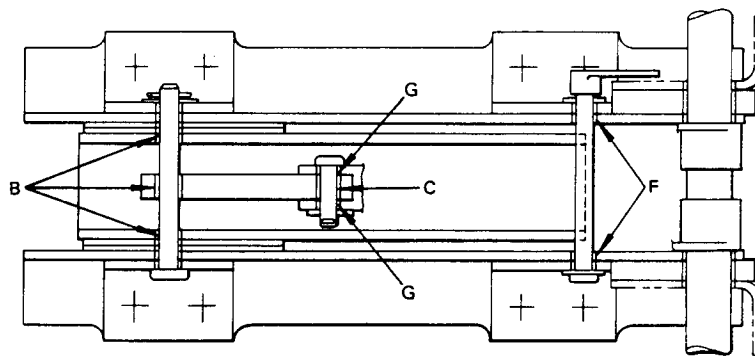
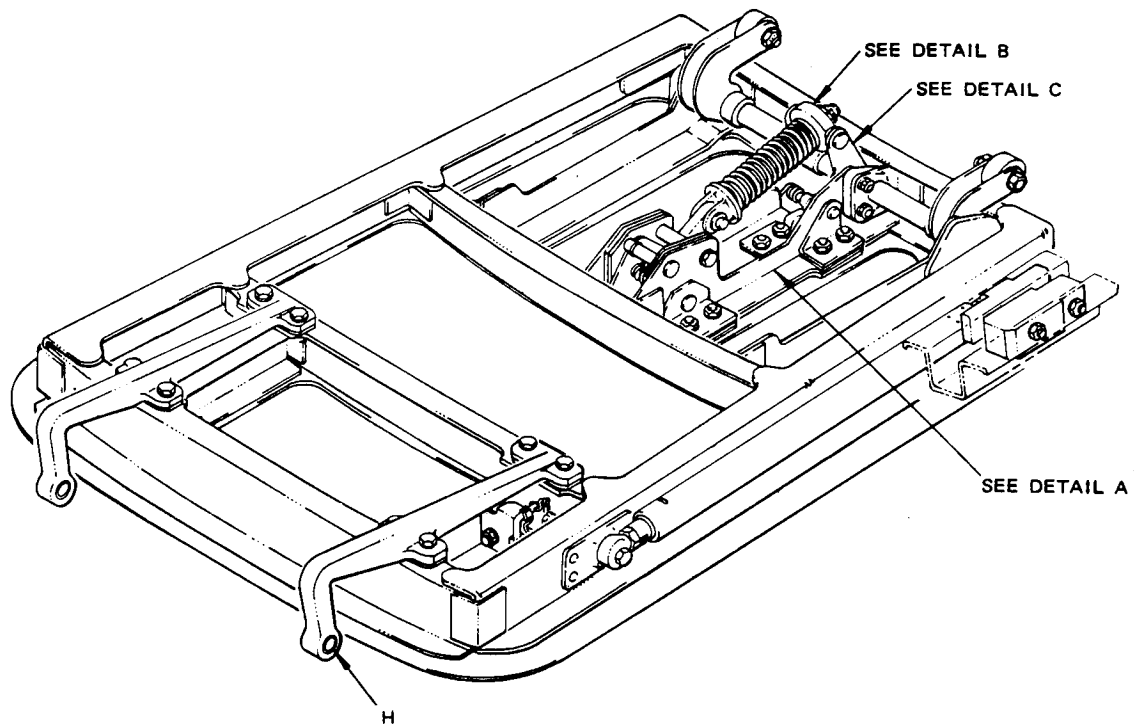
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FIT AND CLEARANCES

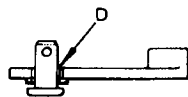
1. The Fits and Clearances table, figure 601, lists original design dimensions and service wear limits for certain close tolerance parts of the buildup. The original design dimensions are to be used as a guide for rework of parts which fail to meet the wear tolerance requirements. Unless otherwise specified in the rework procedure, a part should be returned to the design dimensions whenever rework is accomplished.
2. Clearances are given to aid assembly of the components. The value given in the "Maximum Allowable Clearance" column is the maximum permitted to insure proper functioning until the next overhaul cycle of the component. If assembled parts fail to meet this requirement, one or more of the parts must be rejected. Parts that are rejected should be reworked within limits given in the repair procedure; if not within rework limits, parts should be scrapped. It is recommended that whenever newly reworked parts are assembled, the design clearances should be used as the guiding assembly criteria.

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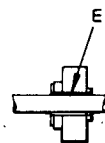
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DETAIL A



DETAIL C



DETAIL B

Fits and Clearances
 Figure 601 (Sheet 1)

Ref. Letter Figure 601	Mating Index No. Fig. 1101		Original Design Limits				Service Wear Limits		
			Dimensions		Assembly Clearance (inch)		Dimension Limits		Maximum Allowable Clearance (inch)
Min.	Max.	Min.	Max.	Min.	Max.				
A	ID	74	0.5625	0.5640	0.0030	0.0065	0.5495	0.5725	 0.013
	OD	92	0.5575	0.5595					
B	ID	109,118	0.2500	0.2515	0.0030	0.0060	0.2380	0.2590	 0.012
	OD	104	0.2455	0.2470					
C	ID	110	0.1900	0.1915	0.0030	0.0060	0.1730	0.2020	 0.015
	OD	57	0.1855	0.1870					
D	ID	91	0.1900	0.1915	0.0030	0.0060	0.1780	0.1990	 0.012
	OD	49	0.1855	0.1870					
E	ID	53	0.2500	0.2515	0.0025	0.0050	0.2350	0.2625	 0.015
	OD	58	0.2465	0.2475					
F	ID	135,138	0.1900	0.1915	0.0030	0.0060	0.1780	0.1990	 0.012
	OD	62	0.1855	0.1870					
G	ID	58	0.1900	0.1940	0.0030	0.0085	0.1750	0.2020	0.015
	OD	57	0.1855	0.1870					
H	ID	7	0.3125	0.3140	0.0030	0.0055	0.2975	0.3245	 0.015
	OD		0.3085	0.3095					

- ① No bushing or plating permitted, optional to replace bearing or bearing assembly; bushing interference: 0.0003 inch min., 0.0020 inch max.
- ② No bushing or plating permitted; optional to replace bearing or bearing assembly; bushing interference: 0.0002 min., 0.0013 inch max.
- ③ Bolt 69-41392-1 (Reference)

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TESTING

1. No specific test is required; however, latch mechanism should operate freely with no binding or sticking.

TROUBLE SHOOTING

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

<u>Trouble</u>	<u>Possible Cause</u>	<u>Correction</u>
A. Latch hook fitting fails to attain full closed position	Incorrect alignment of bearing plate assembly (72)	Loosen bolts (71), realign bearing plate assembly (72), and tighten bolts
	Spring (64) disengaged or broken	Correct condition
B. Rough movement of latch mechanism	Defective bushings or bearings	Check, replace defective bushings or bearings

STORAGE INSTRUCTIONS

1. Place protective cover over surfaces of door skin.
2. Wrap entire assembly in vapor barrier paper. Tag with overhaul date 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.
5. For further information, refer to "Temporary Protective Coatings," Subject 20-44-02.

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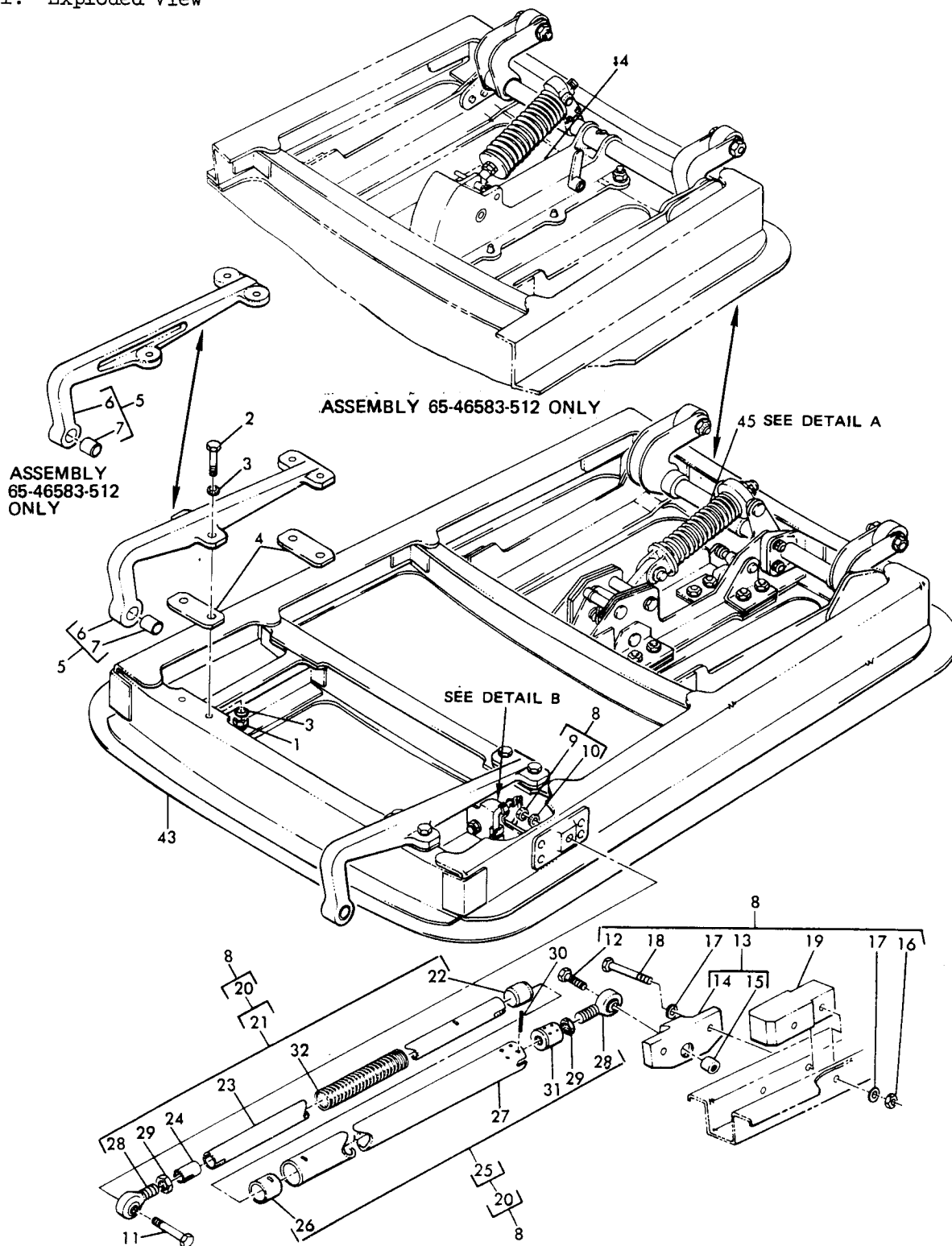
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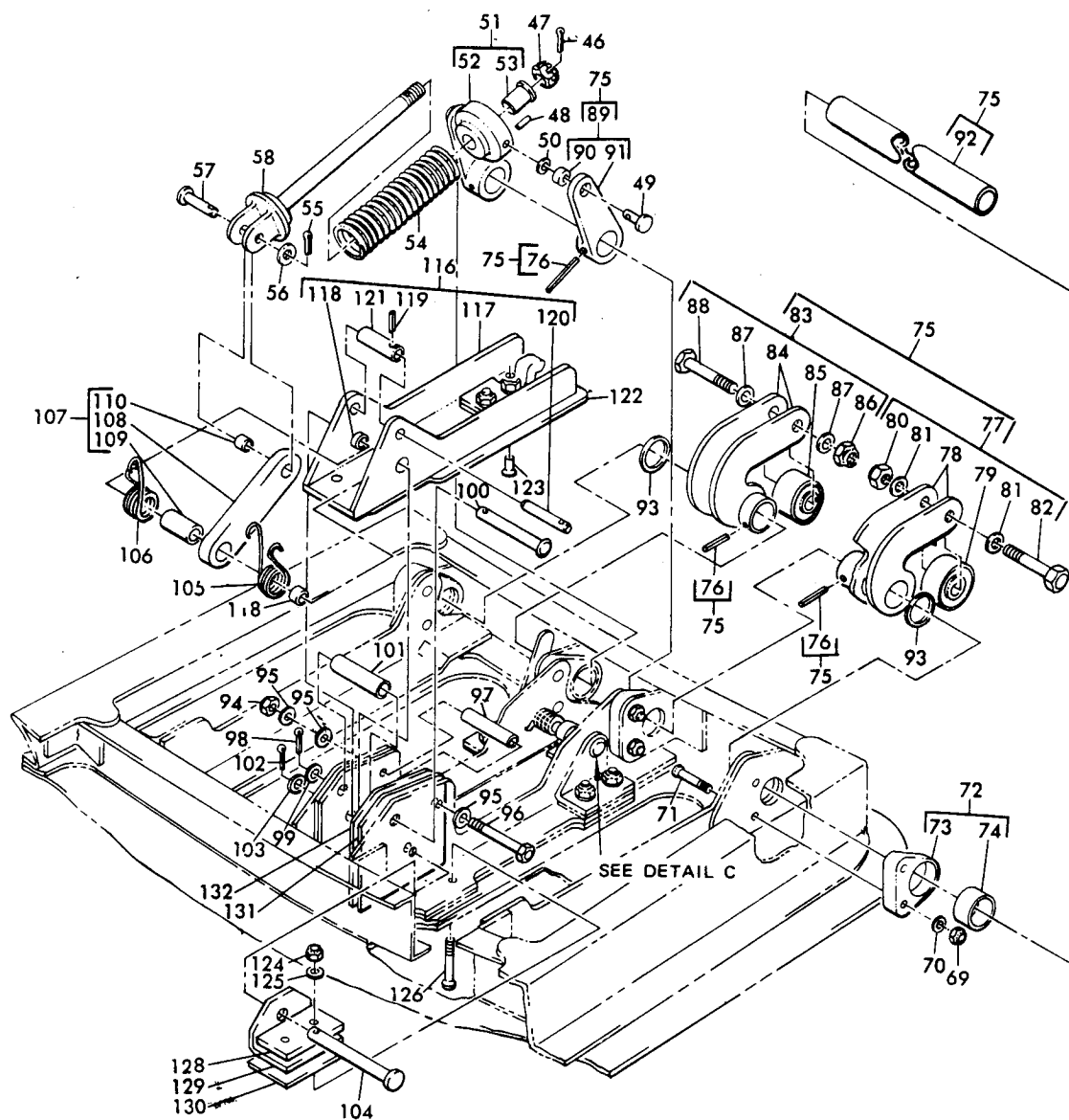
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1. Exploded View

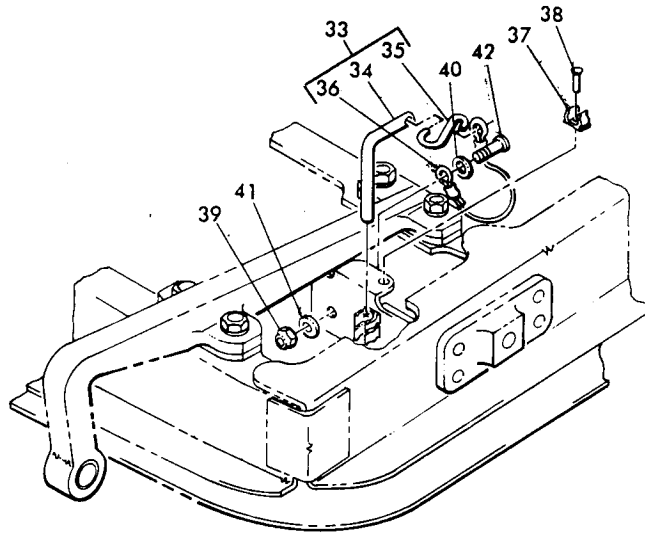




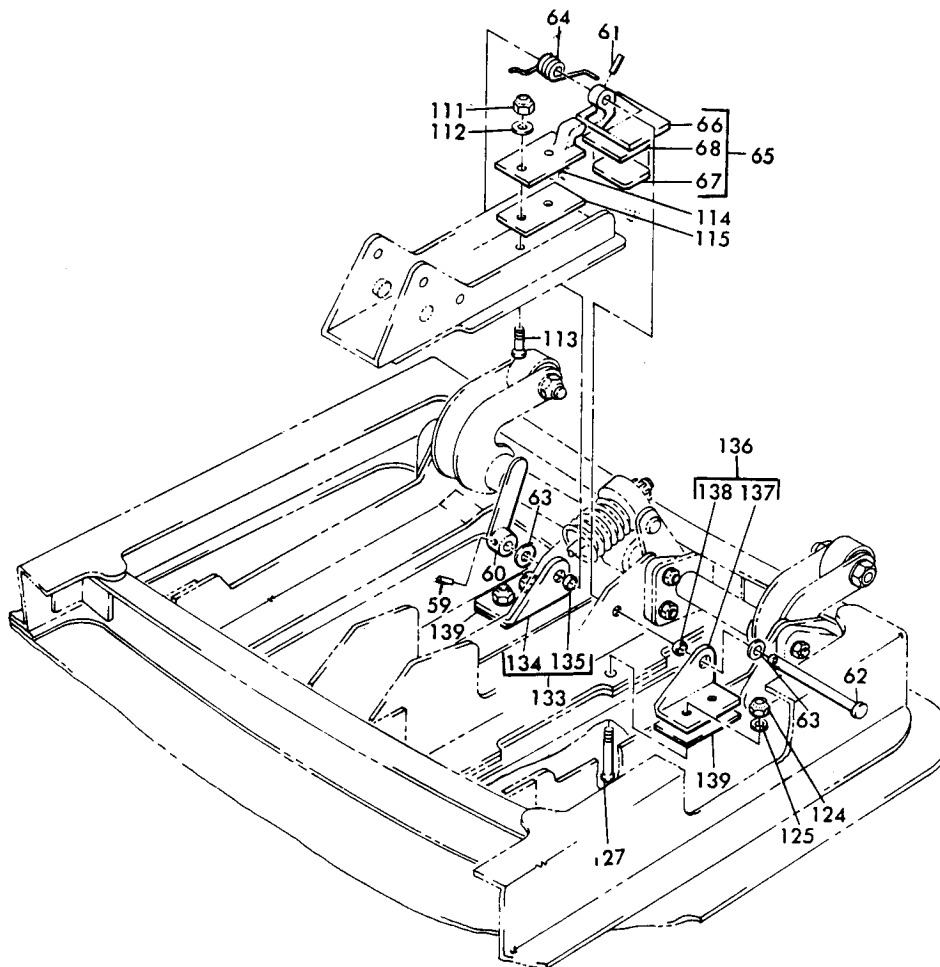
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DETAIL B



DETAIL C

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2. GROUP ASSEMBLY PARTS LIST

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	N O M E N C L A T U R E 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-			ACCESS AND BLOWOUT DOOR BUILDUP		
1	BACN10JC4		. NUT (REPLS NAS679A4W) *[1] *[2]		8
2	BACB3ONE4-6		. BOLT (REPLS NAS1304-6) *[1] *[2]		8
2	NAS6604-5		. BOLT *[4]		8
3	AN96OPD416L		. WASHER *[1] *[2]		16
3	AN96OJD416L		. WASHER *[4]		16
4	BACS40K13A32		. SHIM *[1] *[2]		4
4	BACS40ROO8DO2 OF		. SHIM *[4]		3
4A	BACS40ROO8CO2 OF		. SHIM *[4]		1
5	65-54852-1		. HINGE ASSY *[1]		2
5	65-67747-1		. HINGE ASSY *[2] *[4]		2
6	65-54852-2		. . HINGE (USED ON 65-54852-1)		1
6	65-67747-2		. . HINGE (USED ON 65-67747-1)		1
7	65-54852-3		. . BEARING (USED ON 65-54852-1)		1
7	65-67747-4		. . BEARING (USED ON 65-67747-1)		1
8	65-54860-1		. STRUT INSTALLATION, JURY *[1] *[2]		1
8	65-54860-7		. STRUT INSTALLATION, JURY *[4]		1
9	BACN10JC4CD		. . NUT (REPLS NAS679A4W)		1
10	AN96OPD416		. . WASHER (USED ON 65-54860-1)		1
10	AN96OJD416		. . WASHER (USED ON 65-54860-7)		1
11	NAS1104-15		. . BOLT (USED ON 65-54860-1)		1
11	NAS6604-12		. . BOLT (USED ON 65-54860-7)		1
12	NAS1104-8		. . BOLT *[3]		1
13	69-41408-1		. . ADAPTER ASSY *[3]		1
14	69-41408-2		. . . ADAPTER		1
15	NAS1395-4		. . . INSERT		1
16	BACN10JC4CD		. . NUT (REPLS NAS679A4W) *[3]		2
17	AN96OPD416		. . WASHER (USED ON 65-54860-1) *[3]		4
17	AN96OJD416		. . WASHER (USED ON 65-54860-7) *[3]		1
18	NAS1104-24		. . BOLT (USED ON 65-54860-1) *[3]		2
18	NAS6604-24		. . BOLT (USED ON 65-54860-7) *[3]		1
19	69-41406-1		. . BLOCK *[3]		1
20	65-54860-503		. . STRUT ASSY		1
21	65-54860-501		. . . TUBE ASSY, INNER		1
22	69-41398-501		 TUBE		1
23	69-41398-505		 TUBE		1
24	69-41402-501		 FITTING, END		1
25	65-54860-502		. . . TUBE ASSY, OUTER		1
26	69-41398-502		 TUBE		1
27	69-41398-504		 TUBE		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	N O M E N C L A T U R E 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101 28	10-60779-174 (BOEING)		. . . BEARING, ROD END APPROVED PARTS ARE: REMS8ATC10-5, V86174; YTM-124-M, V77896; DREM-4-279, V81376; 177131, V09455		2
29	NAS509-5		. . . NUT		2
30	MS16562-198		. . . PIN, ROLL		4
31	69-41402-2		. . . FITTING, END		1
32	69-41401-1		. . . SPRING		1
33	65-54860-6		. . PIN ASSY, RETAINING (USED ON 65-54860-1)		1
34	69-41407-1		. . . PIN, RETAINING		1
35	NAS1090-1		. . . HOOK, CHAIN		1
36	BACC13Y3-130		. . . CABLE ASSY		1
37	100-225-2-10		. . CLIP, V99378 (USED ON 65-54860-1)		3
38	BACR15BB3D		. . RIVET (REPLS MS20470D3)		3
39	NAS679A08W		. . NUT (USED ON 65-54860-1)		1
39	BACN10JC4CD		. . NUT (USED ON 65-54860-7)		1
40	AN96OPD8		. . WASHER (USED ON 65-54860-1)		
40	AN960JD416L		. . WASHER (USED ON 65-54860-7)		
41	AN96OPD8L		. . WASHER (USED ON 65-54860-1)		1
41	AN960JD416L		. . WASHER (USED ON 65-54860-7)		
42	NAS623-2-2		. . SCREW (USED ON 65-54860-1)		1
42	NAS6604-12		. . BOLT (USED ON 65-54860-7)		1
43	65-46583-2		. DOOR ASSY		1
43	65-46583-512		. DOOR ASSY		1
43	65-46583-522		. DOOR ASSY		1
43	65-46583-44		. DOOR ASSY		1
43	65C35450-1		. DOOR ASSY		1
44	H942-1		. . LATCH ASSY, V83014 (BOEING 10-61704-1) (USED ON 65-46583 -44,-512,-522; 65C35450-1)		1
45	65-54859-1		. . LATCH ASSY (USED ON 65-46583-2)		1
46	MS24665-153		. . . PIN, COTTER		1
47	AN310-4		. . . NUT		1
48	MS16562-194		. . . PIN, SPRING		2
49	69-41411-1		. . . PIN, FLATHEAD		2
50	AN96OPD10L		. . . WASHER		2
51	69-41383-1		. . . CAP ASSY		1
52	69-41383-2		 CAP		1
53	69-41383-4		 BEARING		1
54	69-41334-1		. . . SPRING		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	N O M E N C L A T U R E 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101					
55	MS24665-153		. . . PIN, COTTER		1
56	AN960C10L		. . . WASHER		1
57	69-41411-2		. . . PIN, FLATHEAD		1
58	69-41383-3		. . . ROD		1
59	MS16562-193		. . . PIN, SPRING		1
60	69-41400-6		. . . HANDLE		1
61	MS16562-194		. . . PIN, SPRING		1
62	69-41411-3		. . . PIN, FLATHEAD		1
63	BACW10P230TF		. . . WASHER		2
64	69-41391-3		. . . SPRING		1
65	69-41400-1		. . . TRIGGER ASSY		1
66	69-41400-2		 TRIGGER		1
67	69-41400-3		 SKIN		1
68	69-41400-4		 DOUBLER		1
69	BACN10JC3		. . . NUT (REPLS NAS679A3W)		8
70	AN960PD10L		. . . WASHER		8
71	BACB30FL-3-7		. . . BOLT		8
72	65-54855-10		. . . PLATE ASSY, BEARING		4
73	65-54855-11		 PLATE		1
74	65-54855-12		 BEARING		1
75	65-54859-2		. . . SHAFT ASSY, TORQUE		1
76	MS51923-292		 PIN		6
77	65-54855-1		 LEVER ASSY		1
78	65-54855-21		 LEVER		2
79	AN207DPP4		 BEARING		1
80	MS20500-428		 NUT		1
81	AN960PD416L		 WASHER		2
82	NAS1304-12		 BOLT		1
83	65-54855-2		 LEVER ASSY		1
84	65-54855-22		 LEVER		2
85	AN207DPP4		 BEARING		1
86	MS20500-428		 NUT		1
87	AN960PD416L		 WASHER		2
88	NAS1304-12		 BOLT		1
89	65-54855-4		 LEVER ASSY		2
90	65-54855-5		 LEVER		1
91	65-54855-19		 BEARING		1
92	65-54855-501		 SHAFT, TORQUE		1
93	65-54859-6		. . . WASHER		2
94	BACN10JC4		. . . NUT (REPLS NAS679A4W)		1
95	AN960PD416L		. . . WASHER		3
96	NAS1304-28		. . . BOLT		1
97	NAS43DD4-81		. . . SPACER		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	N O M E N C L A T U R E 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101					
98	MS24665-153		. . . PIN, COTTER		1
99	AN96OPD416L		. . . WASHER		1
100	MS20392-3C55		. . . PIN, STRAIGHT		1
101	NAS43DD4-83		. . . SPACER		1
102	MS24665-153		. . . PIN, COTTER		1
103	AN96OPD416L		. . . WASHER		1
104	69-41411-4		. . . PIN, FLATHEAD		1
105	69-41391-1		. . . SPRING		1
106	69-41391-2		. . . SPRING		1
107	65-54855-6		. . . LINK ASSY		1
108	65-54855-7		 LINK		1
109	65-54855-13		 BEARING		1
110	65-54855-14		 BEARING		1
111	BACN10JC3		. . . NUT (REPLS NAS679A3W)		2
112	AN96OPD10L		. . . WASHER		2
113	BACB30FL3-5		. . . BOLT		2
114	69-41400-5		. . . KEEPER		1
115	BACS40B11-25		. . . SHIM, LAMINATED		1
116	69-41384-1		. . . HANDLE ASSY		1
117	69-41384-2		 HANDLE		1
118	69-41384-3		 BEARING		2
119	MS16562-193		 PIN, ROLL		2
120	MS9105-94		 PIN		2
121	NAS43DD3-64		 SPACER		2
122	65-54859-5		. . . SKIN		1
123	BACR15CE4D		. . . RIVET		6
124	BACN10JC3		. . . NUT (REPLS NAS679A3W)		8
125	AN96OPD10L		. . . WASHER		8
126	BACB30FL3-8		. . . BOLT		4
127	BACB30FL3-5		. . . BOLT		4
128	65-54859-7		. . . FILLER, RADIUS		2
129	65-54855-9		. . . BLOCK, BEARING		2
130	BACS40B12-25		. . . SHIM, LAMINATED		2
131	65-54859-3		. . . SEAL		2
132	65-54859-4		. . . SHIM		2
133	65-54855-15		. . . BLOCK ASSY, BEARING		1
134	65-54855-17		 BLOCK, BEARING		1
135	65-54855-19		 BEARING		1
136	65-54855-16		. . . BLOCK ASSY, BEARING		1
137	65-54855-18		 BLOCK, BEARING		1
138	65-54855-19		 BEARING		1
139	BACS40B12-24		. . . SHIM		2

ACCESS AND BLOWOUT
DOOR BUILDUP
(NO ASSIGNED P/N)



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FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	N O M E N C L A T U R E 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101 150	65-54860-6		. PIN ASSY, RETAINING (USED WITH 65-54860-7)		1
151	69-41407-1		. . PIN, RETAINING		1
152	NAS1090-1		. . HOOK, CHAIN		1
153	BACC13Y3-130		. . CABLE ASSY		1

- *[1] USED WITH 65-46583-2 DOOR ASSY
- *[2] USED WITH 65-46583-44, -512 AND -522 DOOR ASSYS
- *[3] MAY NOT BE WITH DOOR WHEN RECEIVED FOR OVERHAUL
- *[4] USED WITH 65C35450-1 DOOR ASSY



OVERHAUL MANUAL

ACCESS AND BLOWOUT
DOOR BUILDUP
(NO ASSIGNED P/N)

VENDOR CODE

V09455	TRANSPORT DYNAMIC INC., AEROSPACE DIVISION, 3131 WEST SEGESTROM AVENUE, SANTA ANA, CALIFORNIA 92702
V77896	REX CHAINBELT INC., SHAFER BEARING DIVISION, BELMONT ROAD AT CURTISS STREET, DOWNERS GROVE, ILLINOIS 60515
V81376	SOUTHWEST PRODUCTS COMPANY, 1705 SOUTH MOUNTAIN AVENUE, MONROVIA, CALIFORNIA 91016
V83014	HARTWELL CORPORATION, 9035 VENICE BOULEVARD, LOS ANGELES, CALIFORNIA 90034
V86174	THE FAFNIR BEARING COMPANY, 2276 EAST 16TH STREET, LOS ANGELES, CALIFORNIA
V99378	ATLEE CORPORATION, 2 LOWELL AVENUE, WINCHESTER, MASSACHUSETTS 01890