

**BOEING**   
**COMMERCIAL JET**  
**OVERHAUL MANUAL**

TO: ALL HOLDERS OF NOSE GEAR BUILDUP OVERHAUL MANUAL, 52-64-06

REVISION NO. 2, DATED SEP 5/89

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
Added top assembly 69-26245-6 with white enamel finish on detail parts per PRR 34475-1					X							X	

# AIRSTAIR CARRIAGE ASSEMBLY

## 52-64-06

| BOEING P/N 69-26245-2, -3, -4, -5, -6

AIRLINE P/N

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THE FOLLOWING DIRECTIVES APPLY TO THIS SUBJECT:

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVES	DATE DIRECTIVE INCORPORATED INTO TEXT
		PRR 32070-4 PRR 34475-1	Mar 25/74 Sep 5/89

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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					
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52-64-06					
* T-1	Sep 5/89				
T-2	BLANK				
* LEP-1	Sep 5/89				
LEP-2	BLANK				
T/C-1	Mar 25/74				
T/C-2	BLANK				
1	Mar 25/74				
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* 3	Sep 5/89				
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* 5	Sep 5/89				
* 6	Sep 5/89				

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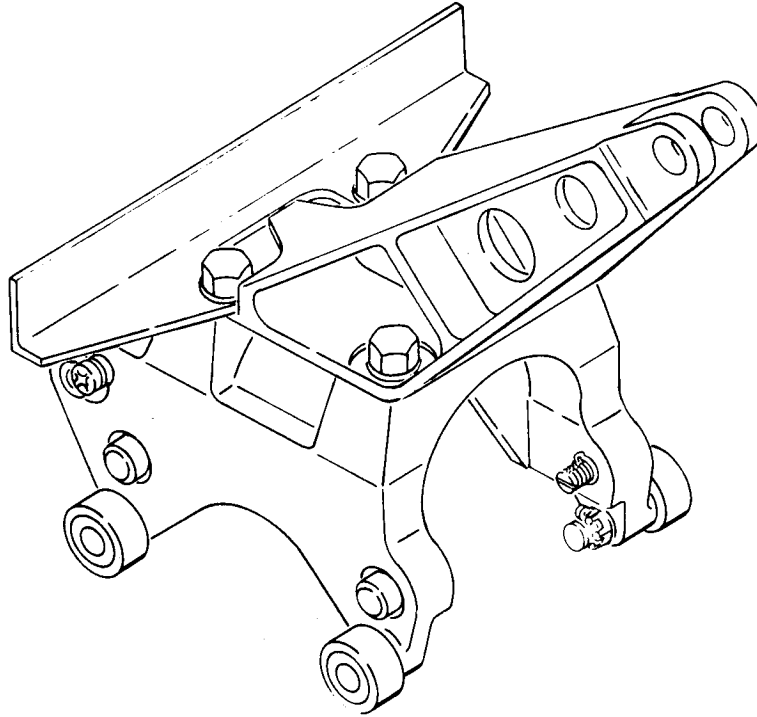
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AIRSTAIR CARRIAGE ASSEMBLY



Airstair Carriage Assembly  
Figure 1

1. DESCRIPTION AND OPERATION

A. Description

- (1) The airstair carriage assembly is assembled from the upper and lower carriages. The upper carriage is an I-beam type forging with a clevis attachment point at the upper end and four bolt holes at the lower end. An angle bracket is attached through two of the bolt holes. The lower carriage is a forging holding four track rollers, four guide pins and two self lubricated journal bushings. The bushings and track rollers form the lower attachment points.

B. Operation

- (1) The airstair carriage assembly rides a curved track in the airstairs. During operation loads are transmitted through the journal bushings to the upper carriage clevis attachment point on the airstairs.

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69-26245

C. Leading Particulars

Width -- 4.5 inches  
Length -- 8 inches  
Height -- 7.7 inches  
Weight -- 3.22 pounds (approximate)

2. DISASSEMBLY (Fig. 2)

A. Use standard industry practices for disassembly of this component, and additional procedure in step (1).

(1) Record thickness of shims (16) between upper carriage (15) and lower carriage (21) to facilitate reassembly.

NOTE: Do not remove helicoil inserts (17, 18 or 19), or bushings (20) unless replacement is required.

3. CLEANING

NOTE: Refer to 20-30-3 for cleaning all parts using standard shop practices, except as follows:

A. Degrease and clean bearings (4) per 20-30-01.

CAUTION: BUSHING (9) IS TEFLON-LINED. CLEAN ONLY BY SPECIAL METHOD GIVEN IN 20-30-01.

4. INSPECTION/CHECK

A. Check all parts for obvious defects in accordance with standard industry practices.

B. Perform penetrant examination per 20-20-02 on upper carriage (15) and lower carriage (21).

5. REPAIR

A. Use standard industry practices for repair of this component, and additional procedures in steps B and C.

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**B. Refinish**

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

- (1) Spring (5) -- Cadmium plate and apply two coats of primer, BMS 10-11, type 1 (SRF-1.92) all over. Material: Music wire, tempered.
- (2) Brackets (12 and 12A, 69-42146-1) and carriage (15, 65-33109-1 and -3) -- Alodize or chromic acid anodize, and apply one coat of primer, BMS 10-11, type 1 (SRF-2.30). Material: Al alloy.
- (3) Carriage (21, 65-33126-1, -3 and -5) -- Chromic acid anodize and apply one coat of primer, BMS 10-11, type 1 (SRF-2.19). Material: Al alloy.
- (4) Bracket (12A, 69-42146-2), carriage (15, 65-33109-5; 21, 65-33126-7) -- Chromic acid anodize and apply one coat of BMS 10-11, type 1 primer plus BMS 10-11, type 2 enamel, color 702 white (F-21.18). Material: Al alloy.

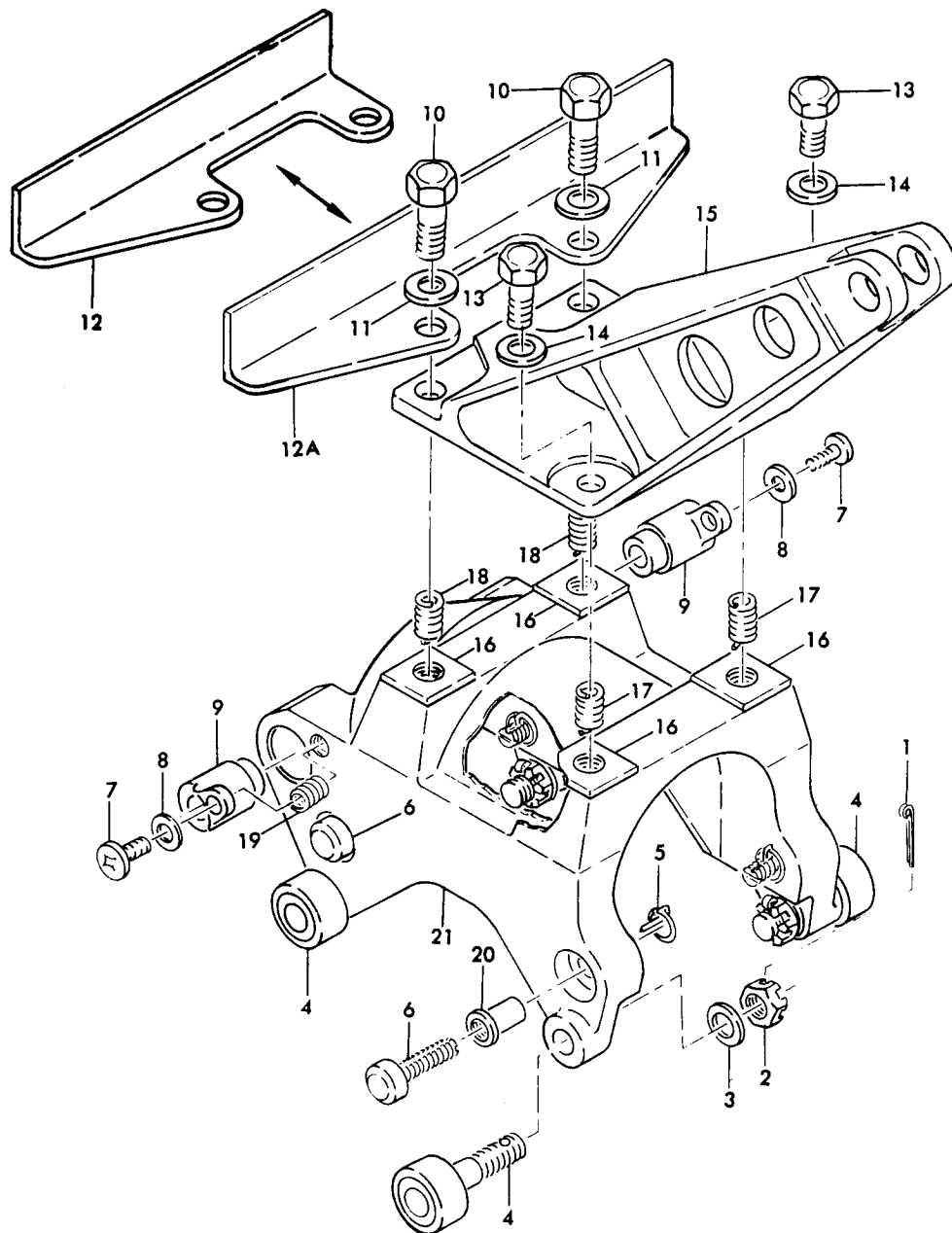
**C. Replacement**

- (1) Bushings (20) -- Install new bushings with wet BMS 10-11, type 1 primer. Flare bushings 13 to 17 degrees. Bushings must contact surface with snug fit.
- (2) Helicoil inserts (17, 18 or 19) -- Insert 1/4 to 1-1/2 turns below start of first thread. Remove tang.

**6. ASSEMBLY**

- A. Use standard industry practices for assembly of this component, and additional procedure in step B.
- B. Assembly upper carriage (15) and lower carriage (21) as follows:
  - (1) Place upper carriage (15) on lower carriage (21) so clevis end is furthest away from teflon-lined bushings (9).
  - (2) Use shims (16), the same thickness recorded during disassembly, to maintain a distance of 6.90 inches vertically between upper carriage (15) clevis hole centerline and track roller bearing (4) center line.

7. ILLUSTRATED PARTS LIST



Airstair Carriage Assembly  
Figure 2



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FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	N O M E N C L A T U R E							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
2-	69-26245-2		AIRSTAIR CARRIAGE ASSY							A	RF
	69-26245-3		AIRSTAIR CARRIAGE ASSY							B	RF
	69-26245-4		AIRSTAIR CARRIAG E ASSY							C	RF
	69-26245-5		AIRSTAIR CARRIAGE ASSY							D	RF
	69-26245-6		AIRSTAIR CARRIAGE ASSY							E	RF
1	MS24665-132		. PIN, COTTER (REPLS AN380-2-2)							A-D	4
1	MS24665-281		. PIN, COTTER							E	4
2	AN310C5		. NUT (USED WITH BACB10BH59F8)								4
2	AN320C5		. NUT (USED WITH BACB10AF5F9H)								4
2	BACN10JD105AU		. NUT							E	4
3	AN960D516L		. WASHER								4
4	BACB10AF5F9H		. BEARING, CAM FOLLOWER (OPT TO BACB10BH59F8)(USED WITH AN320C5)							A-D	4
4	BACB10BH59F8		. BEARING, CAM FOLLOWER (OPT TO BACB10AF5F9H)(USED WITH AN310C5)							A-D	4
4	BACB10FK5F9HS		. BEARING, CAM FOLLOWER							E	4
5	66-18574-2		. SPRING, THREAD LOCK								4
6	66-18995-1		. GUIDE PIN								4
7	NAS603-6P		. SCREW								2
8	AN960PD10L		. WASHER								2
9	KJN5-11		. BUSHING (V97613)(BOEING 10-60516-89)								2
9	YTS232A		. BUSHING (V77896)(BOEING 10-60516-89)								2
9	DBAF5-061		. BUSHING (V81376)(BOEING 10-60516-89)								2
9	78564		. BUSHING (V09455)(BOEING 10-60516-89)								2
10	BACB30NE5-7		. BOLT (REPLS NAS1105W7)							A-D	2
10	BACB30NF5-7		. BOLT							E	2
11	AN960D516L		. WASHER								2
12	66-19269-1		. BRACKET							AD	1
12A	69-42146-1		. BRACKET							BC	1
12A	69-42146-2		. BRACKET							E	1
13	BACB30NE4-3		. BOLT (REPLS NAS1104W3)							A-D	2
13	BACB30NF4-3		. BOLT							E	2

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FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	N O M E N C L A T U R E							USE CODE	QTY PER ASSY
			1	2	3	4	5	6	7		
2- 14	AN960D416L		.	W	A	S	H	E			2
15	65-33109-1		.	C	A	R	R	I	A	AB	1
15	65-33109-3		.	C	A	R	R	I	A	CD	1
15	65-33109-5		.	C	A	R	R	I	A	E	1
16	BACS40A13-48		.	S	H	I	M			A-D	AR
16	BACS40R013B048		.	S	H	I	M			E	AR
17	MS21209F4-15		.	I	N	S	E	R	T		2
18	MS21209F5-15		.	I	N	S	E	R	T		2
19	MS21209F1-15		.	I	N	S	E	R	T		2
20	66-19165-2		.	B	U	S	H	I	N		4
21	65-33126-1		.	C	A	R	R	I	A	A	1
21	65-33126-3		.	C	A	R	R	I	A	B	1
21	65-33126-5		.	C	A	R	R	I	A	CD	1
21	65-33126-7		.	C	A	R	R	I	A	E	1

VENDORS

- V09455      LEAR SIEGLER INC., TRANSPORT DYNAMICS DIVISION, P.O. BOX 1953,  
 3131 WEST SEGERSTROM AVE., SANTA ANA, CALIFORNIA 92702
- V77896      REXNORD INC., BEARING DIVISION, 2400 CURTISS STREET, DOWNERS  
 GROVE, ILLINOIS 60515
- V81376      SOUTHWEST PRODUCTS CO., 1705 SOUTH MOUNTAIN AVE., MONROVIA,  
 CALIFORNIA 91016
- V97613      SARGENT INDUSTRIES, KAHR BEARING DIVISION, 3010 NORTH SAN FERNANDO  
 BLVD, BURBANK, CALIFORNIA 91503