TO: ALL HOLDERS OF AFT AIRSTAIR ASSEMBLY OVERHAUL MANUAL, 52-66-02

REVISION NO. 12, DATED MAR 1/05

HIGHLIGHTS

DESCRIPTION OF CHANGE	TOPICS AFFECTED												
	D & O	D / Assy	Cleaning	Insp/Chk	Repair	Assy	F/C	Test	T/Shooting	S/Tools	Storage	IPL	L/Overhaul
Changed the torque value for nuts 69-47442-1, -2, IPL Fig. 1109; 30, 32, 102, 103, to agree with the latest engineering data						X							

AFT AIRSTAIR ASSEMBLY

52-66-02

BOEING P/N 65-56632-1, -2

AIRLINE P/N

THE FOLLOWING DIRECTIVES APPLY TO THIS SUBJECT:

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVES	DATE DIRECTIVE INCORPORATED INTO TEXT
		PRR 30012-4	Aug 15/69
		PRR 30012-11	Aug 15/69
		PRR 30012-12	Aug 15/69
		PRR 30448	Aug 15/69
		PRR 30970	Aug 15/69
24-1016		PRR 31812	Dec 10/71
52-1035		PRR 31937	Dec 10/71
		PRR 32120	Jun 25/73
52-1045		PRR 32232-R	Jun 25/73
		PRR 32570	Jan 5/77
52-1067		PRR 32795	Jul 5/78
		PRR 33836	Sep 5/89

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F Indicates foldout pages - print one side only

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	T-2	BLANK		503	Sep 5/89		1114	Aug 15/69
*	LEP-1	Mar 1/05		504	Jul 5/78		1115	Aug 15/69
*	LEP-2	Mar 1/05		504A	Jul 5/78		1116	Aug 15/69
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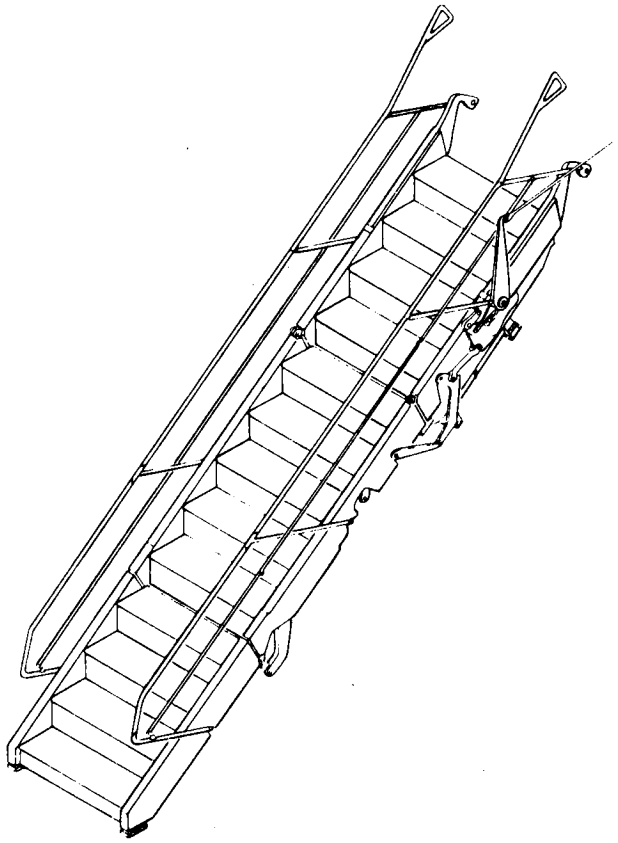
AFT AIRSTAIR ASSEMBLY

Boeing Part Number: 65-56632-1



Aft Airstair Assembly
Figure 1

DESCRIPTION AND OPERATION

1. Description

   A. The aft airstair is a three segment folding metal stairway. The unit consists of a folding mechanism, a rotary hydraulic damper, a segment lock, a carriage assembly, individual segment covers, and handrails with guardrails and stanchions attached to the side beams of the airstair.

B. Each segment of the airstair consists of built-up side beams with permanently attached risers with removable treads. The segments are joined through their hinges and at the aft side uppermost hinge connection is a wire bundle guard.

C. The folding mechanism consists of a shaft, cams and program arm assembly installed in the upper segment, and connected to the middle and lower segments through cranks, pushrods and link assemblies attached to the side beams of the airstair.

D. A rotary hydraulic damper is installed at the upper end of the middle segment of the airstair. It is connected to the upper segment through a link and crank assembly. The damper is a self-contained unit consisting of a housing, a rotary shaft splined at the drive end, a 2-cubic-inch reservoir with an integral capacity indicator and a fill port. The reservoir is serviced with hydraulic fluid, MIL-H-5606.

E. The segment lock consists of a hook that is actuated by a cam attached to the carriage assembly and a bearing attached to the middle segment of the airstair.

F. The carriage assembly is installed and free to move in the track assemblies of the airstair upper segment. It consists of brackets, beams, socket fitting, mounting plate assemblies and a bearing unit which serves as a roller.

2. Operation

A. Extension and retraction of the airstair is accomplished by a drive mechanism directly connected to the upper aft and fore hinge arms of the airstair upper segment. The airstair rotates about this hinge point in its operation, and in this process, the program arm of the folding mechanism folds or unfolds the airstair segments through cranks, pushrods, and linkages.

B. The handrails attached to the side beams of the airstair rise to their erect position as the airstair unfolds to its extended position, and fold simultaneously with the movement of the folding mechanism, as the airstair moves to the stowed or retracted position.

C. The rotary hydraulic damper prevents the airstair segments from bouncing during extension and retraction by restricting the velocity of the folding mechanism.

D. The carriage assembly moves to position the aft entry door to its faired position when the airstair is retracted and position the cam of the segment lock to cause the hook and bearing lock to engage when the airstair is in its extended position.

3. Leading Particulars

Length -- 192 inches (approximately)
Width -- 26 inches (approximately)
Height -- 40 inches (approximately)
Weight -- 483 pounds

DISASSEMBLY

1. General

   A. Mount assembly in a suitable fixture in its extended position.

      CAUTION: FIRMLY SUPPORT UNIT THROUGH THE LADDER ASSEMBLY STRUCTURES ONLY, TO PREVENT DAMAGE TO ITS OTHER PARTS.

   B. Remove and disassemble subassembly and installation parts one at a time, and keep them covered and segregated for protection from damage and for ease of reassembly.

      NOTE: Aft and fore side denotes position of parts with respect to center line of airstair assembly symmetry. (See figure 1101.)

2. Procedures

   A. Basic Airstair Assembly (See figure 1101.)

      (1) Remove and disassemble handrail installation (1) per procedure B, below.

      (2) Remove upper, center, and lower cover installations (2 through 4) per procedures C through E, below.

      (3) Remove and disassemble damper installation (5) per procedure F, below.

      (4) Remove and disassemble segment lock installation (6) per procedure G, below.

      (5) Remove items (7 through 16) to free door rod assembly (17).

      (6) Disassemble door rod assembly (17) as follows:

         (a) Loosen check nut (19) and remove bearing (18).

         (b) Remove check nut (19) from bearing (18).

            NOTE: Do not remove items (20 through 22) from rod (23) unless replacement is necessary.

      (7) Remove carriage assembly (24) by rolling it out of track assemblies of upper ladder assembly (32) and disassemble per procedure H, below.

(8) Remove and disassemble folding mechanism installation (25) per procedure I, below.

NOTE: Remove wire bundle installation, P/N 65-48324, (reference) before proceeding to the next step.

(9) Remove items (26 thru 30) and wire bundle guard (31) to separate upper, center, and lower assemblies (32 thru 34).

(10) Disassemble upper, center, and lower ladder assemblies (32 thru 34) per procedures J thru L, below.

NOTE: Do not remove identification plate (35) unless replacement is necessary.

B. Handrail Installation (Fig. 1102)

NOTE: Use special handrail hinge pin wrench to remove hinge pins.

(1) Remove items (1 thru 7).

(2) Remove items (8 thru 11) to free tie rod assembly (12).

(3) Disassemble tie rod assembly (12) by loosening nut (16), and screw out fitting assembly (13) from tie rod assembly (17). Remove nut (16) from fitting assembly (13).

NOTE: Do not remove bushings (14 and 18) from fitting (15) or tie rod (19) unless replacement is necessary.

(4) Remove items (20 thru 24), bearing (25), and spacer (26) from upper ladder structure and remove upper group of handrail installation parts from basic assembly by sliding it out from inner slide (107) and handrail (122).

(5) Remove items (27 thru 34) to free tie rod assembly (35).

(6) Disassemble tie rod assembly by loosening nut (37) and screw out fitting (36) from rod assembly (38). Remove nut (37) from fitting (36).

NOTE: Do not remove bushing (39) from rod (40) unless replacement is necessary.

(7) Remove items (41 thru 44), bearing (45), and spacer (46) from center ladder structure.

(8) Remove items (47 thru 51), bearing (52) and spacer (53) from lower ladder structure, and remove remaining lower group of handrail installation parts from basic assembly.

(9) Remove items (54 through 56), bearing (57), items (58 through 61), link (62), and bearing (63).

(10) Remove items (64 through 68) to free stanchion (69).

NOTE: Do not remove items (70 through 79) unless replacement is necessary.

(11) Remove items (80 through 83) to free handrail (84); remove bearing (85).

NOTE: Do not remove items (86 through 89) unless repair or replacement is necessary.

(12) Remove nut (90), washer (91), bolt (92), plate fitting (93), and guardrail (94); remove washer (95), pin (96), and bearings (97).

NOTE: Do not remove bolts (98), or fitting (99 or 100) from guardrail (94) unless repair or replacement is necessary.

(13) Remove items (101 through 103), bearings (104), spacer (105), bushing (106), and inner slide (107).

NOTE: Do not remove slide pad (108) from inner slide (107) unless repair or replacement is necessary.

(14) Remove items (109 through 112) to free stanchion (113), bearings (114), and handrail (122).

NOTE: Do not remove any of items (115 through 121) or (123 through 127) unless repair or replacement is necessary.

(15) Remove nut (128), washer (129), bolt (130), plate fittng (131) and guardrail (132); remove washer (133), pin (134), and bearings (135).

NOTE: Do not remove bolt (136) and fitting (137) unless repair or replacement is necessary.

(16) Remove items (138 through 141) to free handrail (142); remove bearings (143).

NOTE: Do not remove any of items (144 through 150) unless repair or replacement is necessary.

(17) Remove items (151 through 160) to free stanchion (161); remove bearings (162).

NOTE: Do not remove items (163 through 169) unless repair or replacement is necessary.

(18) Remove items (170 through 172) to free guardrail (173); remove bearings (174), spacer (175), and bushing (176).

(19) Remove nut (177), washer (178), and bolt (179) to free link assembly (180); remove bushing (183).

NOTE: Do not remove bushing (181) from fitting (182) or any of items (184 through 187) unless repair or replacement is necessary.

(20) Remove items (188 through 191) to free stanchion (192); remove bearings (193).

NOTE: Do not remove bolt (194) and fitting (195) unless repair or replacement is necessary.

(21) Remove items (196 through 200) and bumper (201).

NOTE: Do not remove items (202 through 218) unless repair or replacement is necessary.

C. Upper Cover Installation (See figure 1103.)

(1) Remove bolts (1) and washers (2) to free covers (3 and 4).

(2) Remove clip nuts (5).

NOTE: Do not remove any of items (6 through 28) unless repair or replacement is necessary.

D. Center Cover Installation (See figure 1104.)

(1) Remove bolts (1), washers (2), covers (3) and clip nuts (4).

NOTE: Do not remove any of items (5 through 22) unless repair or replacement is necessary.

E. Lower Cover Installation (See figure 1105.)

(1) Remove bolts (1 and 3), washers (2 and 4), cover (5) and clip nuts (6).

NOTE: Do not remove items (7 through 22) unless repair or replacement is necessary.

F. Damper Installation (See figure 1106.)

(1) Remove nut (1), washer (2), bolt (3) and damper (4).

NOTE: Overhaul damper (4) according to manufacturer's instructions.

(2) Remove nut (5), washer (6), shaft (7), spacers (8 and 9), and bearing (10).

(3) Remove items (11 through 14) to free crank assembly (15).

NOTE: Do not remove bushings (16) from crank (17) unless replacement is necessary.

(4) Remove items (18 through 21) to free link assembly (22).

NOTE: Do not remove bearing (23) from link (24) unless replacement is necessary.

G. Segment Lock Installation (See figure 1107.)

(1) Cut and remove lockwire on nut (1) and remove nut (1), washer (2), and setscrew (3).

(2) Remove springs (4).

(3) Remove items (5 through 15) and hook assembly (16).

(4) Partially disassemble hook assembly (16) by removing locknut (17), washer (18), and eyebolt (19).

NOTE: Do not remove bearing (20) and sleeve (21) from hook (22) unless replacement is necessary.

(5) Remove cotter pin (23), nut (24), washer (25), bolt (26), and bearing (27).

(6) Remove nut (28), washer (29), bolt (30), and cam (31).

NOTE: Do not remove rivets (32) and shims (33) unless repair or replacement is necessary.

H. Carriage Assembly (See figure 1108.)

(1) Remove nut (1), washer (2), bearing (3), and washer (4).

(2) Remove bolt (5), washer (6), and plate assembly (7).

NOTE: Do not remove rivets (8) and nutplates (9 or 10) from mounting plate (11) unless replacement is necessary.

(3) Remove bolt (12), washer (13), and mounting bracket (14).

(4) Remove items (15 through 20), center bonded mount (21), socket fitting assembly (22), and washer (26).

NOTE: Do not remove rivets (23) and nutplates (24) from fitting (25) unless replacement is necessary. Do not remove items (27 through 71) unless repair or replacement is necessary.

I. Folding Mechanism Installation (See figure 1109.)

(1) Remove items (1 through 5) to free link assembly (6).

NOTE: Do not remove bearing (7) from link (8) of link assembly (6) unless replacementis necessary.

(2) Remove items (9 through 18) to free crank assembly (19).

NOTE: Do not remove fitting (20) and bearing (21) from crank (23) unless replacement is necessary.

(3) Remove items (24 through 27) to free pushrod assembly (28).

(4) Partially disassemble pushrod assembly (28) by removing items (29 through 32) from rod assembly (33).

NOTE: Do not disassemble rod assembly (33) unless repair or replacement of a defective part is necessary.

(5) Remove items (39 through 48) to free idler crank assembly (49).

NOTE: Do not remove fitting (50) and bearings (51 and 52) from idler crank (53) unless replacement is necessary.

(6) Remove items (54 through 57) and pushrod (58).

(7) Remove items (59 through 67) to free crank assembly (70); remove bearing (68) and spacer (69).

NOTE: Do not remove fitting (71), bearings (72 through 74), and rub strip (75) from crank (76) unless replacement is necessary.

(8) Remove items (77 through 87) to free crank assembly (88).

NOTE: Do not remove fitting (89), bearings (90 and 91), or bushings (92) from crank (93) unless replacement is necessary.

(9) Remove items (94 through 98) to free rod assembly (99).

(10) Disassemble rod assembly (99) as follows:

(a) Cut and remove lockwires on locknuts (102 and 103). Loosen locknuts and screw out rod ends (100 and 101).

(b) Remove locknuts (102 and 103) from adjusting rod (104).

(11) Remove items (105 thru 108) to free program arm assembly (109); remove shims (114 thru 116).

NOTE: Do not remove fitting (110), bearing (111), and sleeve (112) from arm (113) unless replacement is necessary.

(12) Remove items (117 thru 124) to free cam assembly (127); remove bearing (125) and spacer (126).

NOTE: Do not remove items (128 thru 134) from cam (135) unless replacement is necessary.

(13) Remove items (136 thru 145), cam roller cranks (146 and 146A), and spacers (147 thru 151).

(14) Remove items (152 thru 154) and crank (155).

(15) Remove items (156 thru 161) from shaft (162) and pull out shaft from ladder assembly structure.

J. Upper Ladder Assembly (Fig. 1110 and 1111)

(1) Procedures for upper ladder assembly, P/N 65-58168-1, -31 and 65-68957-1.

NOTE: Do not remove rivets, lockbolts, or press fit parts unless repair or replacement is necessary.

(a) Remove items (1 thru 3 and 4 thru 5C) and tread assemblies (6) from the first two steps of ladder assembly.

(b) Remove bullnose (9) from each tread assembly (6) by removing bolts (8).

(c) Remove items (1 thru 3C, 19, and 20) and tread assembly (21) from the third and fourth steps of ladder assembly.

(d) Detach bullnose (24) from each tread assembly by removing bolts (23).

(e) Remove lights (36) from riser assemblies (167, 172P, 194, and 206).

(f) Remove reinforcement (175A), shims (175B, 175M, 175R, and 175S), stiffener (175L), and separator (175N), if installed.

(g) Remove items (40 thru 54), forward and aft track assemblies (55 and 64) and shims (73 and 74).

(h) Remove grommets (75, 78, and 126).

(i) Remove items (81 thru 100), forward and aft track assemblies (101 and 112) and shims (123 and 124).

(j) Remove retainer ring (176) and bearing (177).

(2) (a) thru (2) (j) DELETED

K. Center Ladder Assembly (Fig. 1112 and 1113).

(1) Procedures for center ladder assembly, P/N 65-58169-1 and -30 (Fig. 1112).

(a) Remove items (1 through 8), as applicable, to free tread assembly (9). Partially disassemble tread assembly (9) by removing nuts (10), bolts (11) and bullnose (12).

NOTE: Do not remove items (13 through 20) from spotweld assembly (21) unless replacement is necessary.

(b) Remove bolts (22), washers (23), and lights (24).

(c) Remove screws (25), washers (26), bumpers (27), and washers (28).

NOTE: Do not remove rivets (29 or 31) and nutplates (30 or 32) unless replacement is necessary.

(d) Remove grommets (34 and 35).

(e) Remove bolts (36), washers (37), and cover (38).

(f) Remove bolts (39 and 41), washers (40 and 42), web (43), and fillers (44 and 45) (if applicable).

NOTE: Do not remove items (46 through 66) unless repair or replacement is necessary.

Do not remove bearing (67) or bushing (68) unless replacement is necessary.

(g) Remove retainer ring (69) and bearing (70).

NOTE: Do not remove items (71 through 74) unless replacement is necessary.

(2) Procedures for center ladder assembly, P/N 65-68956-1 and -13 (See figure 1113.)

(a) Remove bolts (1), washers (2), and cover (3).

(b) Remove grommet (4).

(c) Remove items (5 through 9), web (10), and fillers (11 and 12) (if applicable).

(d) Remove items (13 through 22) to free web (25) (if applicable).

NOTE: Do not remove bolt (22), washer (23), rivet (24), and web (25) used on center ladder assembly, P/N 65-68956-13, unless repair or replacement is necessary.

Do not remove items (26 through 47) unless repair or replacement is necessary.

(e) Partially disassemble ladder assembly (48).

1) Remove screws (49), washers (50), bumpers (51), and washers (52).

2) Remove items (53 thru 58) to free tread assembly (59). Partially disassemble tread assembly (59) by removing nuts (60), bolts (61) and bullnose (62).

NOTE: Do not remove items (63 thru 70) from spotweld assembly (71) unless repair or replacement is necessary.

3) Remove bolts (72), washers (73), and lights (74).

NOTE: Do not remove rivets (75 or 77) and nutplates (76 or 78) unless replacement is necessary.

4) Remove grommets (79 and 80).

NOTE: Do not remove bearings (81) or bushings (82) unless replacement is necessary.

5) Remove retainer rings (83) and bearings (84).

NOTE: Do not remove items (85 thru 88) from ladder assembly structure (89) unless replacement is necessary.

L. Lower Ladder Assembly (Fig. 1114).

(1) Remove screws (1), washers (2), spacers (3), bumpers (4), washers (5), and shims (6).

(2) Remove grommet (7).

(3) Remove items (8 thru 13) and tread assemblies (14 and 27).

NOTE: On reworked aft airstair assembly 65-56632-2, remove bolts (50, Fig. 1115) and washers (45, Fig. 1115).

(4) Partially disassemble tread assemblies (14 and 27) by removing nuts (15 and 28), bolts (16 and 29), and bullnose (17 and 30).

NOTE: Do not remove items (18 thru 25) and (31 thru 38) from spotweld assemblies (26 and 39) unless replacement is necessary.

On reworked aft airstair assembly 65-56632-2, remove bullnose (10, Fig. 1115) and shim (40, Fig. 1115).

(5) Remove bolts (40), washers (41) and lights (42).

NOTE: Do not remove items (43 thru 46) unless replacement is necessary.

(6) Remove nuts (47), washers (48), bolts (49), spacers (50), and scuff plate assemblies (51).

NOTE: Do not disassemble scuff plate assemblies (51) unless a defective part requires replacement.

(7) Remove bolts (56), washers (57), spacers (58) and foot pads (59).

(8) Remove grommet (60).

NOTE: Do not remove items (61 thru 90) from ladder assembly structure (91) unless repair or replacement is necessary.

M. Aft Airstair Assembly (Fig. 1115)

(1) Remove bolts (60), washers (65), nuts (70) and emergency light (55).

NOTE: Do not disassemble and remove items (15 thru 37) and (75 thru 90) unless repair or replacement is necessary.

CLEANING

1. Metal Parts

   A. Clean all metal parts except bearings with clean solvent, Specification P-D-680, or equivalent.

   B. Remove stubborn accumulations of dirt or foreign matter using a stiff-bristle brush.

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

   D. 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 Check

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

   B. Examine entire basic assembly for loose fasteners, corrosion, damage, and general condition of paint and finish.

   C. Examine all bearing, bushing, and bolt holes for excessive or eccentric wear.

2. Special Check

   CAUTION: TO PREVENT DAMAGE TO ANTIFRICTION BEARINGS, IT IS NECESSARY TO PROTECT THEM FROM INSPECTION FLUID WHEN PERFORMING MAGNETIC PARTICLE OR DYE PENETRANT EXAMINATION OF COMPONENTS CONTAINING BEARINGS. AN ADEQUATE EXAMINATION CAN BE MADE BY CAREFULLY MASKING OFF THE BEARING AND APPLYING THE FLUID BY BRUSH INSTEAD OF BY DIPPING.

   NOTE: It is not necessary to press out a bearing to check inside of component bore unless crack indications are detected during visual examination.

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

      (1) Dye penetrant check -- rod (22, Fig. 1101); fittings (15, 71, 75, 79, 89, 99, 100, 116, 127, 137, 148, 164, 182, 185, 187, 195, 205, 211 and 215, Fig. 1102); tie rods (19 and 40), cap (20), link (62), pins (96 and 134), inner slide (107), and handle (217); crank (17, Fig. 1106) and link (24); cam (31, Fig. 1107); plate (11, Fig. 1108), brackets (14, 41, 47, 63 and 67), and fitting (25); link (8, Fig. 1109), shafts (16, 42, 67, and 85), spacers (18, 44, 63, 69, 87, and 126), cranks (23, 53, 76, 93, and 155); fitting (83, Fig. 1114); fitting (25, Fig. 1115).

      (2) Magnetic particle check -- washers (24, 44, 55, 59, 65, 81, 110, and 139, Fig. 1102); pins (56, 61, 67, 83, 96, 103, 112, 134, 141, 153, 160, 172, and 191), and fitting (169); shaft (7, Fig. 1103); hook (19, Fig. 1107); clevis ends (29 and 37, Fig. 1109), pin (121), cam (135), nut (137), washer (138), bolt (140), cam roller cranks (146 and 146A), and shaft (162).

(3) Ultrasonic check or equivalent -- plate fittings (93 and 131, figure 1102).

B. Spring Check (See figure 1107.)

(1) Check spring (4) for load carrying capacity according to "Spring Check Data," figure 301.

Index and Figure No.	Free Length (inches)	Test Length (inches)	Allowable Load Limit (pounds)
4, 1107	8.70 (approximate)	10.34	31.4 to 39.4
		12.49	53.8 to 65.8

Spring Check Data
Figure 301

REPAIR

1. Materials

   A. Adhesive -- BMS 5-26, Class B-1/2 (Class B-2 opt) (Ref 20-60-04)

   B. Adhesive -- BMS 5-14 (Ref 20-50-12)

   C. Adhesive -- Safety Walk Brand, Minnesota Mining and Manufacturing Co., 3M Center, St. Paul, Minnesota (Ref 20-60-04)

   D. Cement -- BMS 5-29, Type 3, Class 1 (Ref 20-60-04)

   E. Corrosion Preventive Compound -- MIL-C-11796, Class 3 (Ref 20-60-03)

   F. Corrosion Preventive Compound -- MIL-C-16173, Grade 2 (Ref 20-60-03)

   G. Primer -- BMS 10-11, Type 1 (Ref 20-60-02)

   H. Safety walk brand sealer -- Minnesota Mining and Manufacturing Co.

   I. Solvent -- Series 80 (Ref 20-30-80)

      -- Series 88 (Ref 20-30-88)

   J. Organic Corrosion Inhibiting Compound -- BMS 3-23 (Ref 20-41-05)

   K. Enamel -- BMS 10-60 (Ref 20-60-02)

2. Repair

   NOTE: Use standard industry practices for repair of this assembly, and additional procedures in par. 3 and 4.

3. 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.

   A. Basic Airstair Assembly (Fig. 1101)

      (1) Rod (22) -- Alodize and apply one coat of BMS 10-1, Type 1 primer (SRF-2.901) all over, except omit primer in holes. Material: Al\alloy.

      (2) Wire Bundle Guard (31) -- Apply Alodine 1000 (F-14.05) all over. Material: Al alloy.

   B. Handrail Installation (Fig. 1102)

      (1) Fittings (15, 71, 75, 79, 89, 93, 99 , 100, 116, 127, 131, 137, 148, 164, 185, 187, 195, 205, 211, and 215), tie rods (19 and 40), and cap (20) -- Apply directional grain satin finish (F-14.29) all over. Material: Al alloy.

(2) Fittings (121 and 169) -- Cadmium plate (F-1.1926) and apply one coat of BMS 10-11, Type 1 primer (SRF-12.205) and one coat of BMS 10-11, Type 2 enamel, color BAC707 (SRF-12.63) all over. Material: 4340 steel, 160-180 ksi.

(3) Washers (24, 44, 55, 59, 65, 81, 110, 139, 158, and 189) -- Cadmium plate 0.0002 to 0.0004 inch thick (F-1.1926) all over. Material: 4340 steel.

(4) Pins (56, 61, 67, 83, 103, 112, 141, 153, 160, 172, and 191) -- Cadmium plate (F-14.16) all over. Material: 4340 steel, 160-180 ksi.

(5) Link (62) , inner slide (107), and fitting (182) -- Apply directional grain satin finish (F-14.29) all over except in holes. Material: Al alloy.

(6) Stanchions (69, 113, 161, and 192), handrails (84 and 122), and guardrails (94 and 173) -- Apply directional grain satin finish (F-14.29) on outside, and one coat of BMS 10-11, Type 1 primer (SRF-12.205) on inside. Material: Al alloy.

(7) Pin (96) -- Sulfuric acid anodize (F-2.201) all over. Material: Al alloy.

(8) Guardrail (132) and handrail (142) -- Apply satin finish (F-14.29) all over, except no directional buff or color required. Material: Al alloy.

C. Upper Cover Installation (Fig. 1103)

(1) Covers (3 and 4) -- Apply static conditioner and surfacer (SRF-14.672), one coat of BMS 10-11, Type 1 primer (SRF-12.205) and BMS 10-11, Type 2 enamel, color BAC707 (SRF-12.63) on exterior surfaces only. Material: Fiberglass.

D. Center Cover Installation (Fig. 1104)

(1) Cover (4) -- Apply static conditioner and surfacer (SRF-14.672), one coat of BMS 10-11, Type 1 primer (SRF-12.205) and BMS 10-11, Type 2 enamel, color BAC707 (SRF-12.63) on exterior surfaces only. Material: Fiberglass.

E. Lower Cover Installation (Fig. 1105)

(1) Cover (5) -- Apply static conditioner and surfacer (SRF-14.672), one coat of BMS 10-11, Type 1 primer (SRF-12.205) and BMS 10-11, type 2 enamel, color BAC707 (SRF-12.63) on exterior surfaces only. Material: Fiberglass.

F. Damper Installation (Fig. 1106)

(1) Shaft (7) -- Cadmium plate (F-14.17) all external surfaces; cadmium throw-in is permitted at each end of the shaft but not in the area with primer. Apply BMS 10-11, Type 1 primer (F-20.03) to the 1.50 inch inner diameter. Do not apply primer to the area of the internal spline. Material: 4340 steel, 160-180 ksi.

(2) Crank (17), and link (24) -- Alodize or chromic acid anodize and apply one coat of BMS 10-11, Type 1 primer (SRF-2.30), plus one coat of BMS 10-11, Type 2 enamel, color BAC707 (SRF-12.63) except no primer and enamel in holes. Material: Al alloy.

G. Segment Lock Installation (Fig. 1107)

(1) Spring (4) -- Cadmium plate and apply one coat of BMS 10-11, Type 1 primer (SRF-1.92) all over.

(2) Hook (22) -- Cadmium -titanium alloy plate (F-1.181), and apply one coat of BMS 10-11, Type 1 primer (SRF-12.205), plus one coat of BMS 10-11, Type 2 enamel, color BAC707 (SRF-12.63) all over, except omit primer and enamel in 0.4370-inch diameter hole. Material: 4340 steel, 270-300 ksi.

(3) Bolt (26) -- Apply Cadmium plate (F-1.1926) all over except on threads. Material: 4340 steel, 160-180 ksi.

(4) Cam (31) -- Alodize or chromic acid anodize and apply one coat of BMS 10-11, Type 1 primer (SRF-2.30) followed by one coat of BMS 10-11, Type 2 enamel, color BAC707 (SRF-12.63) all over, except omit enamel in holes. Material: Alum alloy.

H. Carriage Assembly (Fig. 1108)

(1) Plate (11) -- Chromic acid anodize (F-2.26) all over. Material: Alum alloy.

(2) Fitting (25) and brackets (41 and 47) -- Chromic acid anodize and apply one coat of BMS 10-11, Type 1 primer (SRF-2.19) all over, except no primer on serrations. Material: Alum alloy.

(3) Beam assembly (57 and 71) and brackets (63 and 67) -- Alodize or chromic acid anodize and apply one coat of BMS 10-11, Type 1 primer (SRF-2.30) except no primer in bushing holes.

I. Folding Mechanism Installation (Fig. 1109)

(1) Bolts (5, 12, 27, 48 and 57) -- Cadmium plate (F-1.1913) all over. Material: 4130 steel, 160-180 ksi.

(2) Link (8), cranks (23, 53, 76, and 93), and pushrod (58) -- Alodize or chromic acid anodize and apply one coat of BMS 10-11, type 1 primer (SRF-2.30) all over followed by one coat of BMS 10-11, type 2 enamel, color BAC707 (SRF-12.63) except omit primer and enamel from holes. Material: Alum alloy.

(3) Shafts (16, 42, 67 and 85) and tube (38) -- Cadmium plate (F-14.16) threads only. Material: 17-4PH CRES, 180-200 ksi.

(4) Spacers (18, 44, 63 and 87) -- Chromic acid anodize and apply one coat of BMS 10-11, type 1 primer (SRF-2.19) all over. Material: Alum alloy.

(5) Clevis end (29) -- Cadmium plate (F-1.1926) and apply one coat of BMS 10-11, type 1 primer (SRF-12.205) and one coat of BMS 10-11, type 2 enamel, color BAC707 (SRF-12.63) all over, except omit paint from threads and bolt holes. Material: 4340 steel, 160-180 ksi.

(6) Rods (31 and 104), clevis end (37), and nuts (30, 32, 102, and 103) -- Cadmium plate (F-1.1926) all over. Material: 4340 steel, 160-180 ksi.

(7) Arm (113), cams (135) and cranks (146 and 146A) -- Cadmium-titanium alloy plate (F-1.181) and apply one coat of BMS 10-11, type 1 primer (SRF-12.205) and one coat of BMS 10-11, type 2 enamel, color BAC707 (SRF-12.63) all over, except omit primer and enamel in bearing holes and on splines. Material: 4340 steel, 270-300 ksi.

(8) Washer (120), spacer (126), and retainer (159) -- Alodize or chromic acid anodize and apply one coat of BMS 10-11, type 1 primer (SRF-2.30) all over. Material: Alum alloy.

(9) Washer (138) -- Cadmium plate (F-4.201) and apply one coat of BMS 10-11, type 1 primer (SRF-12.205) and BMS 10-11, type 2 enamel, color BAC707 (SRF-12.63) all over. Material: Beryllium copper.

(10) Washer (141) -- Apply BMS 10-11, type 1 primer (F-12.415) all over, after delamination. Install either wet or dry. Material: Aluminum alloy.

(11) Crank (155) -- Alodize or chromic acid anodize and apply one coat of BMS 10-11, type 1 primer (SRF-2.30) and one coat of BMS 10-11, type 2 enamel, color BAC707 (SRF-12.63) all over, except omit enamel on 135-degree arc surface. Material: Alum alloy.

(12) Shaft (162) -- Cadmium plate (F-1.1926) and apply one coat of BMS 10-11, type 1 primer (SRF-12.205) and one coat of BMS 10-11, type 2 enamel, color BAC707 (SRF-12.63) on external surfaces, except omit paint on splines. Apply phosphate coating (F-14.14), two coats of BMS 10-11, type 1 primer (SRF-12.206) and MIL-C-16173 corrosion preventive compound (F-14.13) on inside surfaces. Material: 4340 steel, 180-200 ksi.

J. Upper Ladder Assembly (Fig. 1110)

(1) Bullnose (9 and 24) and doubler (171) -- Chemical treat (SRF-14.011) all over. Material: Alum alloy.

(2) Straps (15, 17, 30, and 32), brackets (129C, 150A, and 181C), stiffeners (174G and 175R), separator (175N), and fitting (175S) -- Alodize or chromic acid anodize and apply one coat of BMS 10-11, type 1 primer (SRF-2.30) all over. Material: Alum alloy.

(3) Spotweld assemblies (18, 33 and 172) and riser assemblies (172P, 194 and 206) -- Apply Alodine 1000 (F-14.05) and one coat of BMS 10-11, type 1 primer (SRF-12.205) all over. After primer has cured eight hours minimum, apply organic corrosion inhibiting compound per 20-41-05. Solvent clean outer (paneled) surface. Material: Alum alloy.

(4) Track (63, 72, 111, and 122) -- Chromic acid anodize and apply one coat of BMS 10-11, type 1 primer (SRF-2.19) and one coat of BMS 10-11, type 2 enamel, color BAC707 (SRF-12.63) all over, except omit enamel on surfaces where shims of track assembly are installed. Material: Alum alloy.

(5) Angles (149 and 150) -- Alodize or chromic acid anodize and apply one coat of BMS 10-11, type 1 primer (SRF-2.30) all over followed by one coat of BMS 10-11, type 2 enamel, color BAC707 (SRF-12.63) except omit primer and enamel from holes. Material: Alum alloy.

(6) Tees (172F and 200) and stiffener (172H) -- Apply directional buff satin finish (F-14.29) on exposed surface. Apply one coat of BMS 10-11, type 1 primer (SRF-12.205) and one coat of BMS 10-11, type 2 enamel, color BAC707 (SRF-12.63) on remainder of part. Material: Alum alloy.

(7) Angles (172G, 172M, 174F, and 211), shims (173A, 173E, 174R, and 174S), tee (174E), and channel (210) -- Alodize or chromic acid anodize and apply one coat of BMS 10-11, type 1 primer (SRF-2.30) followed by one coat of BMS 10-11, type 2 enamel, color BAC707 (SRF-12.63) all over. Material: Alum alloy.

(8) Angle (174D) -- Chemical treat (SRF-14.01) followed by two coats of BMS 10-11, type 1 primer (SF-12.206) and one coat of BMS 10-11, type 2 enamel, color BAC707 (SRF-12.63) all over. Material: Alum alloy.

(9) Stiffener (175L) -- Apply one coat of BMS 10-11, type 1 primer (SRF-12.205) and one coat of BMS 10-11, type 2 enamel, color BAC707 (SRF-12.63) all over. Material: Alum alloy.

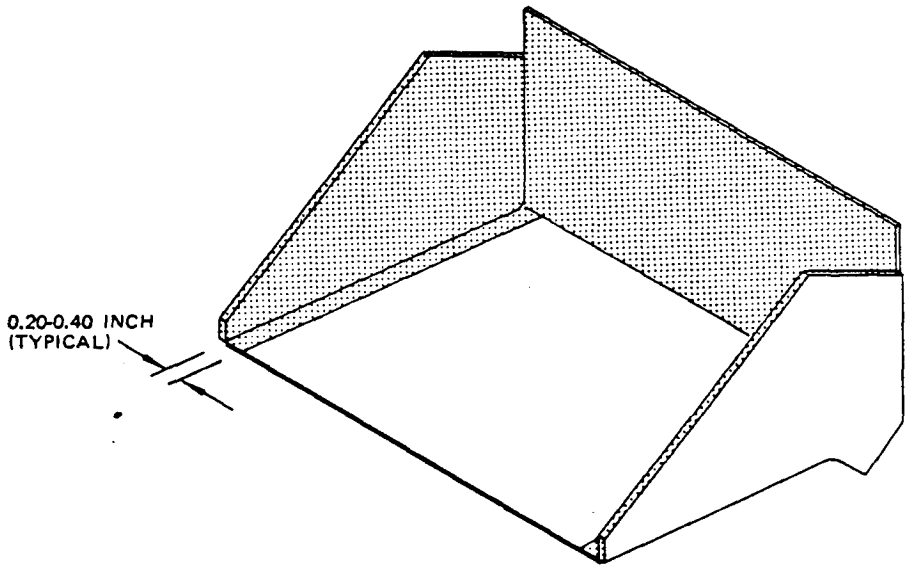
(10) Fitting (180B)

(a) 65-59344-3, -4, -7, -11, -12, -17, -18 -- Apply Alodine 1000 (F-14.05) plus aluminized primer (F-14.963) and BMS 10-60 enamel, aluminum color (SRF-14.9815-9184) except omit primer from bushing and bearing holes. Material: Alum alloy.

(b) 65-59344-21, -22 -- Anodize and apply one coat of BMS 10-11, type 1 primer (F-18.04) plus BMS 10-60 enamel, aluminum color (SRF-14.9815-9184) except omit primer and enamel in bushing and bearing holes. Material: Alum alloy.

(11) Arm (180D) -- Apply directional buff satin finish (F-14.29) all over. Material: Alum alloy.

(12) Reinforcement (175A) -- Apply one coat of BMS 10-11, type 1 primer (SRF-12.205) plus one coat of BMS 10-11, type 2 enamel, color BAC707 (SRF-12.63) all over except passivate (F-8.07) shaded areas of Fig. 401. Material: AISI 321 CRES.



REINFORCEMENT (175A, FIGURE 1110)

Refinish Diagram
Figure 401

K. Upper Ladder Assembly (Fig. 1111)

(1) Angles (18 and 19) -- Alodize or chromic acid anodize and apply one coat of primer (SRF-2.30) all over followed by one coat of BMS 10-11, type 2 enamel, color BAC707 (SRF-12.63) except omit paint and primer from holes. Material: Alum alloy.

L. Center Ladder Assembly (Fig. 1112)

(1) Bullnose (12) -- Clear chemical treat (SRF-14.001) all over. Material: Alum alloy.

(2) Straps (18 and 20) -- Alodize or chromic acid anodize and apply one coat of BMS 10-11, type 1 primer (SRF-2.30) all over. Material: Alum alloy.

(3) Spotweld assemblies (21) -- Apply Alodine 1000 (F-14.05) and one coat of BMS 10-11, type 1 primer (SRF-12.205) all over. After primer has cured eight hours minimum, apply organic corrosion inhibiting compound per 20-41-05. Solvent clean outer (paneled) surface. Material: Alum alloy.

(4) Cover (38) -- Alodize or chromic acid anodize and apply one coat of BMS 10-11, type 1 primer (SRF-2.30) and one coat of BMS 10-11, type 2 enamel, color BAC707 (SRF-12.63) on exterior surfaces only. Material: Alum alloy.

(5) Web (43 and 48) and zee (60) -- Alodize or chromic acid anodize and apply one coat of BMS 10-11, type 1 primer (SRF-2.30) and one coat of BMS 10-11, type 2 enamel, color BAC707 (SRF-12.63) all over. Material: Alum alloy.

(6) Fitting (64 and 65) -- Alodize or chromic acid anodize and apply one coat of BMS 10-11, type 1 primer (SRF-2.30) all over, except omit primer on bearing bore. Material: Alum alloy.

M. Center Ladder Assembly (Fig. 1113)

(1) Bullnose (62) -- Clear chemical treat (SRF-14.011) all over. Material: Alum alloy.

(2) Straps (68 and 70) -- Alodize or chromic acid anodize and apply one coat of BMS 10-11, type 1 primer (SRF-2.30) all over. Material: Alum alloy.

(3) Spotweld assembly (58Q, 58R, 71) -- Apply Alodine 1000 (F-14.05) and one coat of BMS 10-11, type 1 primer (SRF-12.205) all over. Material: Alum alloy.

(4) Cover (3) -- Alodize or chromic acid anodize and apply one coat of BMS 10-11, type 1 primer (SRF-2.30) and one coat of BMS 10-11, type 2 enamel, color BAC707 (SRF-12.63) on exterior surfaces only. Material: Alum alloy.

(5) Web (10 and 32) and zee (41) -- Alodize or chromic acid anodize and apply one coat of BMS 10-11, type 1 primer (SRF-2.30) and one coat of BMS 10-11, type 1 primer (SRF-12.63) all over. Material: Alum alloy.

(6) Fitting (44 and 47) -- Alodize or chromic acid anodize and apply one coat of BMS 10-11, type 1 primer (SRF-2.30) all over except omit primer in bearing bore. Material: Alum alloy.

(7) Angle (58I) and zee (78C) -- Alodize or chromic acid anodize and apply one coat BMS 10-11, type 1 primer (SRF-2.30) and one coat BMS 10-11, type 2 enamel, color BAC707 (SRF-12.63) all over. Material: Alum alloy.

(8) Angle (58P) -- Alodize or chromic acid anodize and apply one coat BMS 10-11, type 1 primer (SRF-2.30) all over. Material: Alum alloy.

(9) Angle (78F) -- Apply directional buff satin finish (F-14.29) on exposed surface. Apply two coats BMS 10-11, type 1 primer (SRF-12.206) and one coat BMS 10-11, type 2 enamel, color BAC707 (SRF-12.63) on remainder of part. Material: Alum alloy.

(10) Tee (78D, 78E) -- Apply directional buff satin finish (F-14.29) on exposed surface. Apply one coat BMS 10-11, type 1 primer (SRF-12.205) and one coat BMS 10-11, type 2 enamel, color BAC707 (SRF-12.63) on remainder of part. Material: Alum alloy.

N. Lower Ladder Assembly (Fig. 1114)

(1) Bullnose (17 and 30) -- Clear chemical treat (SRF-14.011) all over. Material: Alum alloy.

(2) Straps (23, 25, 36, and 58) -- Alodize or chromic acid anodize and apply one coat of BMS 10-11, type 1 primer (SRF-2.30) all over. Material: Alum alloy.

(3) Spotweld assembly (26, 39, 46L, 46M) -- Apply Alodine 1000 (F-14.05) and one coat of BMS 10-11, type 1 primer (SRF-12.205) all over. After primer has cured 8 hours minimum, apply organic corrosion inhibiting compound per 20-41-05. Solvent clean outer (paneled) surface. Material: Alum alloy.

(4) Fitting (76) -- Alodize or chromic acid anodize and apply one coat of BMS 10-11, Type 1 primer (SRF-2.30) all over, except omit primer in bearing bore. Material: Al alloy.

(5) Scuff assembly (51) -- Passivate (F-8.07) all over. Material: 301 CRES.

(6) Angle (46D, 46K) -- Alodize or chromic acid anodize and apply one coat BMS 10-11, Type 1 primer (SRF-2.30) all over. Material: Al alloy.

(7) Zee (46E) -- Alodize or chromic acid anodize and apply one coat BMS 10-11, Type 1 primer (SRF-2.30) all over followed by one coat BMS 10-11, Type 2 enamel, color BAC707 (SRF-12.63) except omit primer and enamel from holes. Material: Al alloy.

(8) Tee (46F) -- Apply directional buff satin finish (F-14.29) on exposed surface. Apply one coat BMS 10-11, Type 1 primer (SRF-12.205) and one coat BMS 10-11, Type 2 enamel, color BAC707 (SRF-12.63) on remainder of part. Material: Al alloy.

O. Aft Airstair Assembly (Fig. 1115)

NOTE: Riser assembly (5, 65C31295-2) is reworked, riser assembly 65-58164-52 used on lower ladder assembly 65-58170-1. For refinish of riser assembly 65C31295-2, see lower ladder assembly refinish, par. 3.N.

(1) Bullnose (10) -- Clear chemical treat (SRF-14.011) all over. Material: Al alloy.

(2) Radius fillers (15 and 20) -- Chemical treat and apply one coat of BMS 10-11, Type 1 primer (F-18.06) also apply one coat of BMS 10-60, Boeing color 707 gray gloss enamel (F-14.9813). Material: Al alloy.

(3) Fitting (25) -- Sulfuric acid anodize (F-17.18). Material: Al alloy.

(4) Clip (30) -- Chemical treat and apply one coat of BMS 10-11, Type 1 primer (F-18.06). Material: Al alloy.

4. Replacement

A. Basic Airstair Assembly (Fig. 1101)

(1) Rod end bearing (21), plug (22) or rod (23):

(a) Cement plug (21) with adhesive type 40 per 20-50-12.

(b) Install bearing (21) in rod (23) with wet BMS 10-11, type 1 primer. Distance between bearing center and end of rod to be 0.94 inch.

(2) Identification plate (35) -- Install identification plate per 20-50-05.

B. Handrail Installation (Fig. 1102)

(1) Bearings (74 and 204) -- Apply corrosion preventive compound on faying surfaces of bearing and housing. Install bearing and roller swage per 20-50-03.

(2) Bearings (120 or 168) -- Apply corrosion preventive compound on faying surfaces of bearing and housing. Install bearing and point stake in six places per 20-50-03.

(3) Replace press fit bushing (14, 18, 39, 78, 88, 126, 147, 181, 210, or 214) per 20-50-03, with corrosion preventive compound, MIL-C-11796, class 3. Machine bushing (181) to ID of 0.3136 to 0.3146 inch after installation.

(4) Fitting assembly (87).

NOTE: Fitting assembly (87) must be drilled in position, after handrail installation is assembled to basic assembly, as follows:

(a) With tierod assembly (12) disconnected and tierod assembly (35) temporarily installed at its nominal length of 6.55 inches, fold ladders in position until they rest on bumpers as shown in "Rigging Diagram," Fig. 505. Use great care in this operation and check handrail pivot joints continually to see that they are free from binding.

(b) Disconnect tierod assembly (35) and check that stanchion (161) is aligned parallel to top surface of ladder beam to within 0.06 inch, and handle (217) contacts bumper (201) with a preload of 3 to 5 pounds.

(c) Place center ladder stanchion (113) in position where outboard hinge of fitting (116) is aligned within 0.06 inch with the centerline of the hinge between center and lower ladder.

(d) Rotate lower ladder stanchion (69) against bumper provided on side of lower ladder beam. Using handrail (84) as a template, drill holes in fitting (89) and install lockbolts (86).

(5) Fitting Assembly (213)

(a) Install fitting assembly (213) in handrail (218) with bolts (212). Use mating part as a template to locate and drill holes in new fitting.

(b) Drill holes in fitting (215) and install bolts (206) connecting fitting assembly (215) and handrail (207) only after the following steps have been taken:

1) Assemble handrail installation to basic assembly.

2) With tierod assembly (12) disconnected and tierod assembly (35) temporarily installed at its nominal length of 6.55 inches, fold ladders in position until they rest on bumpers, as shown in Fig. 505, Rigging Diagram. Check handrail pivot joints continually during folding operation to see that they do not bind.

3) Disconnect tierod assembly (35); check that stanchion (161) is aligned parallel within 0.06 inch to top surface of ladder beam, and handle (217) is in contact with bumper (201) with a preload of 3 to 5 pounds.

(6) Slide pad (108 or 123) -- Bond replacement slide pad in place with type 51 adhesive per 20-50-12.

(7) Rub strips (144, Fig. 1102) and (75, Fig. 1109)

(a) Pry up rub strip using a hardwood or plastic wedge.

NOTE: Heat (190°F maximum) may be used to soften the adhesive. The temperature of the heat used to soften the adhesive may be checked with a thermocouple placed on the part directly under the heat.

(b) Remove adhesive residue by scraping with hardwood or plastic wedge.

(c) Clean all faying surfaces thoroughly by wiping with gauze or cheesecloth dampened with solvent, Series 88 (SOPM 20-30-88). Exchange soiled cloths for clean ones frequently. Use clean cotton or rubber gloves. Wipe off solvent, Series 88 (SOPM 20-30-88) solvent with a clean, dry cloth while surface is still wet. Repeat this operation until cleaning cloths show no soil.

NOTE: This procedure should be performed no more than 1 hour prior to application of adhesive.

(d) Thoroughly mix the base component, BMS 5-26, class B-1/2, adhesive (class B-2, optional), with manufacturer's recommended amount of matched curing component (marked with batch number of base component with which it is to be used) so that mixture is homogeneous.

NOTE: Care must be taken to minimize entrapment of air in sealant during mixing.

(e) Apply a thin uniform coating of 40 to 60 grams per square foot of mixed material to each faying surface. Bond layer should not exceed 0.008 inch thick.

NOTE: Do not apply adhesive when temperature of structure is below 50°F.

(f) Lay rub strip in place and smooth surface with a roll of gauze or cheesecloth, or with a clean roller , to squeeze out all entrapped air. Avoid using excess smoothing pressure which would squeeze adhesive out on bond line, resulting in an adhesive-starved joint.

NOTE: Assemble parts within half an hour after adhesive mixing for class B-1/2 and within 2 hours for class B-2 adhesive.

(g) Remove excess adhesive by wiping with a clean gauze moistened slightly with solvent, Series 80 (SOPM 20-30-80). Take care not to allow solvent to seep into bond line. Allow 10-minute drying time to evaporate any residual solvent before applying curing pressure.

(h) Apply a constant, uniform curing pressure of 10 to 14 psi for not less than 45 hours at a temperature of 72°F to 82°F; or 90 hours at a temperature of 62°F to 72°F; or 135 hours at a temperature of 57°F to 67°F for class B-1/2 adhesive; for class B-2 adhesive, apply same constant, uniform curing pressure of 10 to 14 psi for 72 hours at a temperature of 72°F to 82°F, or six days at a temperature of 62°F to 72°F, or nine days at a temperature of 57°F to 67°F.

(i) Remove excess cured adhesive by scraping away with a hardwood or plastic wedge and clean residual adhesive from aluminum by rubbing the area with a clean gauze moistened slightly with solvent, Series 80 (SOPM 20-30-80).

C. Damper Installation (Fig. 1106)

(1) Bushing (16) -- Apply primer BMS 10-11, Type 1, to faying surfaces of bushing and housing and press fit install bushing per 20-50-03.

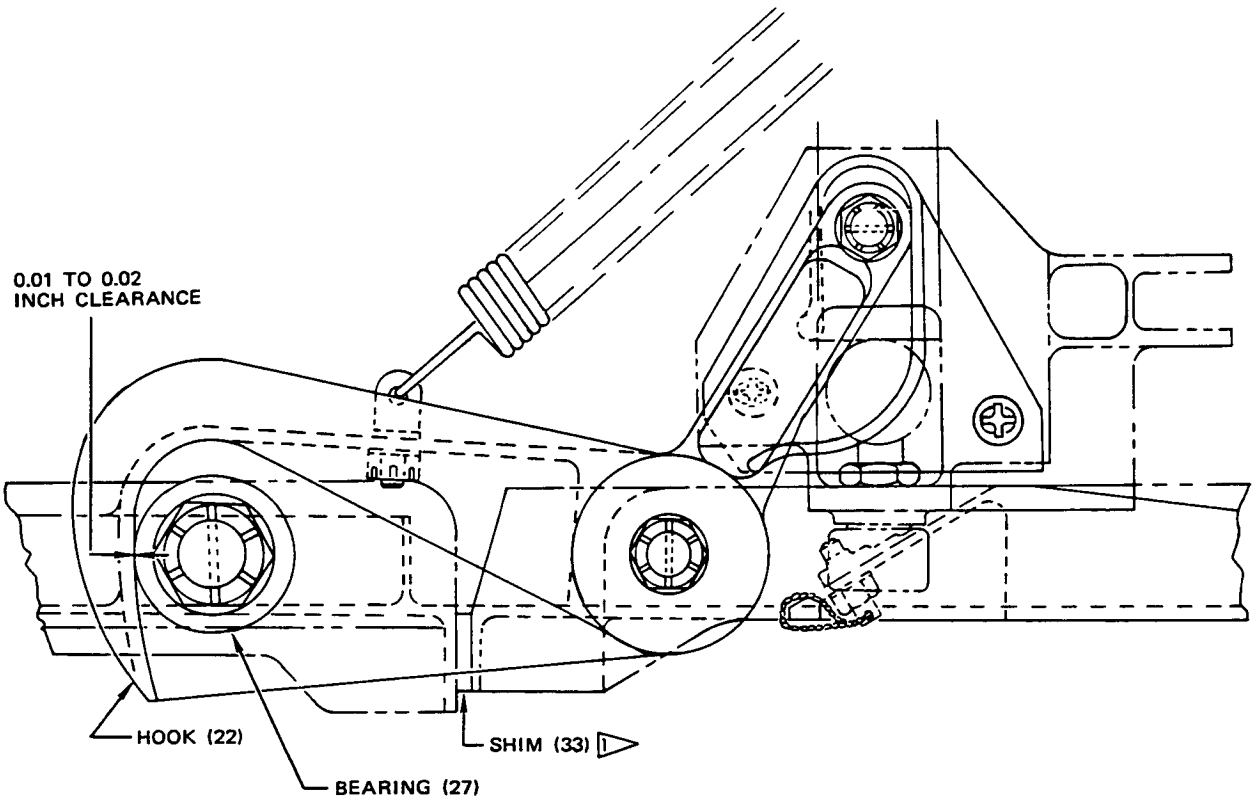
(2) Bearing (23) -- Apply primer BMS 10-11, Type 1, to faying surfaces of bearing and housing, install bearing and roller swage per 20-50-03.

D. Segment Lock Installation (Fig. 1107)

(1) Bearing (20) -- Apply BMS 10-11, Type 1 primer to faying surfaces of bearing and housing; install sleeve (21) and bearing, and roller swage sleeve per 20-50-03.

(2) Shim (33) -- Install shim (33) with primer, BMS 10-11, Type 1, and adjust thickness to establish clearance of 0.01 to 0.02 inch between hook (22) and bearing (27) (Fig. 402).

NOTE: Install shim (33) only after hook assembly (16) and bearing (27) have been installed and ladder assemblies joined as shown in Fig. 402.



NOTE: ITEM NUMBERS REFER TO FIGURE 1107

1 REMOVE LAMINATIONS AS REQUIRED TO OBTAIN 0.01 TO 0.02 INCH CLEARANCE BETWEEN HOOK (22) AND BEARING (27)

Shim Installation
Figure 402

E. Carriage Assembly (Fig. 1108)

(1) Bushings (37 thru 40, 43 thru 46, 61, 62, 65 or 66) -- Apply BMS 10-11, Type 1 primer to faying surfaces of replacement bushing and housing, and press bushing into bore per 20-50-03.

(2) Brackets (41, 47, 63 and 67) or beam assemblies (51, 57, and 71) -- Remove laminations on shims (48 and 49, or 58 and 59), as required, for 0.005-inch maximum allowable gap before installing fasteners. Apply shims evenly at top and bottom of beam assembly, and install with BMS 10-11, Type 1 primer, either wet or dry.

F. Folding Mechanism Installation (Fig. 1109)

(1) Bearings (7, 22, 51, 52, 72, 73, 74, 90 and 91) -- Apply BMS 10-11, Type 1 primer to faying surfaces of replacement bearing and housing, install replacement bearing and roller swage per 20-50-03.

(2) Bearings (111, 129, 131, and 133) -- Apply BMS 10-11, Type 1 primer to faying surfaces of replacement bearing and housing; install bearing and sleeve (112, 130, 132 or 134) in housing and roller swage sleeve per 20-50-03.

(3) Adapter (35), clevis end (37), and tube (38) -- Assemble parts with wet BMS 10-11, Type 1, primer on faying surfaces. Apply corrosion preventive compound, MIL-C-16173, grade 2 on threads.

(4) Rub strip (75) (Refer to par. 3.B.(7).

G. Upper Ladder Assembly (Fig. 1110)

(1) Nonskid (13 and 28 , Fig. 1110,) -- Remove warnout nonskid from spotweld assembly with a sharp edged, nonmetallic scraper, and bond replacement nonskid as follows:

NOTE: Nonskid film may be heated to 120-130°F to soften adhesive.

(a) Clean spotweld assembly receiving surface thoroughly as follows:

1) Wet surface with solvent, Series 88 (SOPM 20-30-88) and wipe or scrub surface using a soft cloth, soft brush or sponge.

2) Rinse surface using clean solvent and clean wipers. Exchange soiled wiper for clean one frequently. Repeat until wiper shows no soil.

3) Dry surface by wiping remaining solvent, using a clean, dry wiper. Do not allow puddles or droplets of solvent to evaporate to dryness. Remove any solvent trapped in limited access areas using compressed air.

4) Protect surface from dust, fingerprints or other contamination.

(b) Apply a coat of Safety Walk Brand adhesive to receiving surface and to new nonskid surface with a brush or carpet type stipple roller.

NOTE: Allow adhesive to become stringy (check by touching with finger - 5 to 8 minutes) before laying replacement nonskid.

(c) Press replacement nonskid firmly into contact with adhesive. Roll down with a roller, or tap down with a rubber mallet, paying particular attention to edges. Start in center and work to edges to eliminate all air bubbles.

NOTE: Allow installed nonskid to cure for at least 30 minutes at a minimum temperature of 70°F before subjecting to foot traffic.

(d) After 3 hours, seal edges of nonskid by applying small fillet of safety walk bead sealer on all edges.

(e) Apply brush coat of BMS 5-29, type 3 (type 2 optional) class 1, to provide 0.75-inch wide strip of cement across curved edge of nonskid. Thickness of coating must be enough to leave surface nonabrasive, but not necessarily smooth.

(2) Bushings (139, 140, 175, 178 thru 180 and 181, Fig. 1110) -- Apply BMS 10-11, type 1 primer to faying surfaces of replacement bushing and housing, install bushing per 20-50-03.

H. Center Ladder Assembly (Fig. 1112 and 1113)

(1) Nonskid (16, Fig. 1112 and 66, Fig. 1113) -- Remove warnout nonskid from spotweld assembly with a sharp-edged, nonmetallic scraper, and bond replacement nonskid same as instructions for upper ladder assembly in par. 3.G.(1)(a) thru (e).

(2) Bearings (63, 67 and 72, Fig. 1112 and 46, 81 and 86, Fig. 1113) -- Apply BMS 10-11, type 1 primer to faying surfaces of replacement bearing and housing, install bearing and roller swage per 20-50-03.

NOTE: Roller swage bearing (67, 72, 81 and 86) installed in forward hinge assembly only.

(3) Bushing (68, 71, 73, and 74, Fig. 1112; 82, 85, 87 and 88, Fig. 1113) -- Apply BMS 10-11, type 1 primer to faying surfaces of replacement bushing and housing, and install bushing per 20-50-03.

I. Lower Ladder Assembly (Fig. 1114)

(1) Nonskid (21 or 34) -- Remove wornout nonskid (31 or 34) from spotweld assembly (26 or 39) with a sharp-edged, nonmetallic scraper and bond replacement nonskid same as instructions for upper ladder assembly in par. 3.G.(1)(a) thru (e).

(2) Bushing (84, 89 and 90) -- Apply BMS 10-11, type 1 primer to faying surfaces of replacement bushing and housing, and install bushing per 20-50-03

ASSEMBLY

1. Procedures

A. Lower Ladder Assembly (Fig. 1114)

NOTE: Use standard industry practices for assembly of reworked aft airstair assembly (Fig. 1115).

(1) Install grommet (60).

(2) Install pads (59) and spacers (58); secure with washers (57) and bolts (56).

(3) Install scuff plate assemblies (51) and spacers (50); secure with bolts (49), washers (48), and nuts (47).

(4) Install lights (42) and secure with washers (41) and bolts (40).

(5) Reassemble partially disassembled tread assemblies (27 and 14) as follows:

(a) Install bullnoses (30 and 17) and secure with bolts (29 and 16).

(b) On reworked aft airstair assembly 65-56632-2, install bullnose (10, Fig. 1115) and secure with bolts (29, Fig 1114).

(c) Clip nuts (28 and 15) in place.

(6) Apply formed-in-place gaskets between tread assemblies (27 and 14) and support structure as follows (Fig. 501A):

(a) Solvent clean faying surfaces of tread assemblies (27 and 14) and support structure. Wipe solvent off with clean wiper before it evaporates.

(b) Apply parting agent or parting film to cleaned faying surfaces of tread assemblies (27 and 14).

(c) Apply sealant, BMS 5-95, Class B, to opposite cleaned surfaces on support structure.

(d) When parting agent is dry-to-touch, assemble parts within application time of sealant.

(e) Install attaching parts (8 thru 13).

(f) On reworked aft airstair assembly 65-566322, install shim (40, Fig. 1115) and attaching parts (45 and 50, Fig. 1115).

(g) Trim excessive sealant.

(7) Apply fillet seal of BMS 5-95, Class B sealant on each side of tread where angle is used (Fig. 501A).

(8) Install grommet (7).

(9) Install shims (6), washers (5), bumper (4), and spacer (3); secure with washers (2) and screws (1).

NOTE: Add or subtract washers (5) or shims (6) to obtain dimensions shown in "Bumper Installation," Fig. 501.

Install lower group of wire bundle installation, P/N 65-48324 (reference) after step (8) is completed.

B. Center Ladder Assembly (Fig. 1112 and 1113)

(1) Center Ladder Assembly, P/N 58169-1 and -30 (Fig. 1112)

(a) Apply BMS 10-11, Type 1 primer to faying surfaces of bearings (70) and bearing housing; install bearings (70) and secure with retainer rings (69).

(b) Install fillers (45 and 44) and web (43); secure with washers (42 and 40) and bolts (41 and 39).

(c) Install cover (38) and secure with washers (37) and bolts (36).

(d) Install grommets (35 thru 33).

(e) Install washers (28) and bumper (27); secure with washers (26) and screws (25).

NOTE: Add or subtract washers (26) to maintain dimensions shown in "Bumper Installation," Fig. 501.

(f) Install lights (24) and secure with washers (23) and bolts (22).

(g) Reassemble partially disassembled tread assemblies (9) as follows:

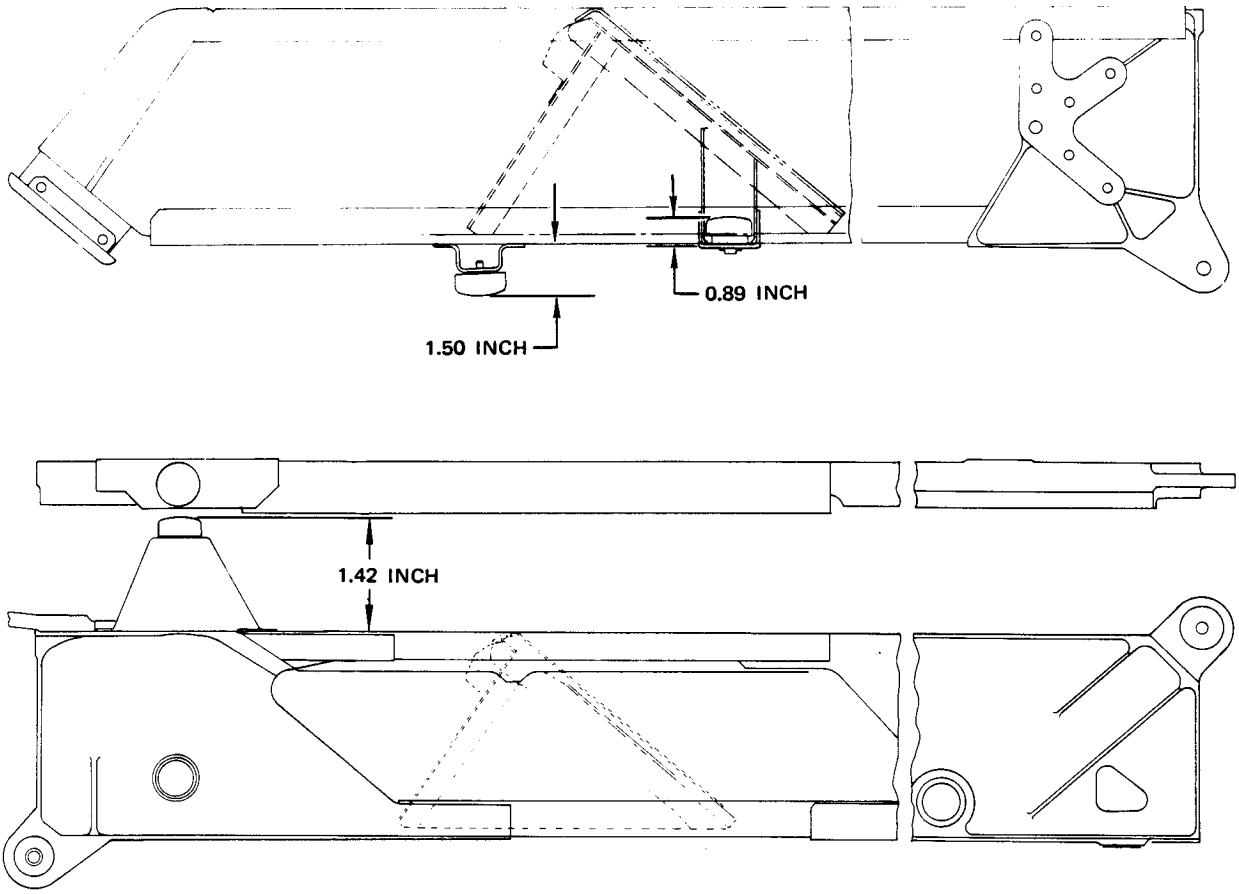
(1) Install bullnose (12) and secure with bolts (11).

(2) Clip nuts (10) in place.

(h) Apply formed-in-place gaskets between tread assemblies (9) and support structure as follows (Fig. 501A):

(1) Solvent clean faying surfaces of tread assemblies (9) and support structure. Wipe solvent off with clean wiper before it evaporates.

(2) Apply parting agent or parting film to cleaned faying surfaces of tread assemblies (9).



Bumper Installation
Figure 501

3) Apply sealant, BMS 5-95, class B, to opposite cleaned surfaces on support structure.

4) When parting agent is dry-to-touch, assemble parts within application time of sealant.

5) Install attaching parts (1 thru 8).

6) Trim excessive sealant.

(i) Apply fillet seal of BMS 5-95, class B sealant on each side of tread where angle is used (Fig. 501A).

NOTE: Install center group of wire bundle installation, P/N 65-48324 (reference), after step (1) (i) is completed.

(2) Center Ladder Assembly, P/N 65-68956-1 and -13 (Fig. 1113)

(a) Apply BMS 10-11, type 1 primer to faying surfaces of bearings (84) and bearing housing; install bearings (84) and secure with retainer rings (83).

(b) Install grommets (79 and 80).

(c) Install lights (74) and secure with washers (73) and bolts (72).

(d) Reassemble partially disassembled tread assemblies (59) as follows:

1) Install bullnose (62) and secure with bolts (61).

2) Clip nuts (70) in place.

(e) Apply formed-in-place gaskets between tread assemblies (59) and support structure as follows (Fig. 501A):

1) Solvent clean faying surfaces of tread assemblies (59) and support structure. Wipe solvent off with clean wiper before it evaporates.

2) Apply parting agent or parting film to cleaned faying surfaces of tread assemblies (59).

3) Apply sealant, BMS 5-95, class B, to opposite cleaned surfaces on support structure.

4) When parting agent is dry-to-touch, assemble parts within application time of sealant.

5) Install attaching parts (53 thru 58).

6) Trim excessive sealant.

(f) Apply fillet seal of BMS 5-95, class B sealant on each side of tread where angle is used (Fig 501A).

(g) Install washer (52) and bumper (51); secure with washer (50) and screw (49).

NOTE: Add or subtract washers (52) to maintain dimension shown in "Bumper Installation," Figure 501.

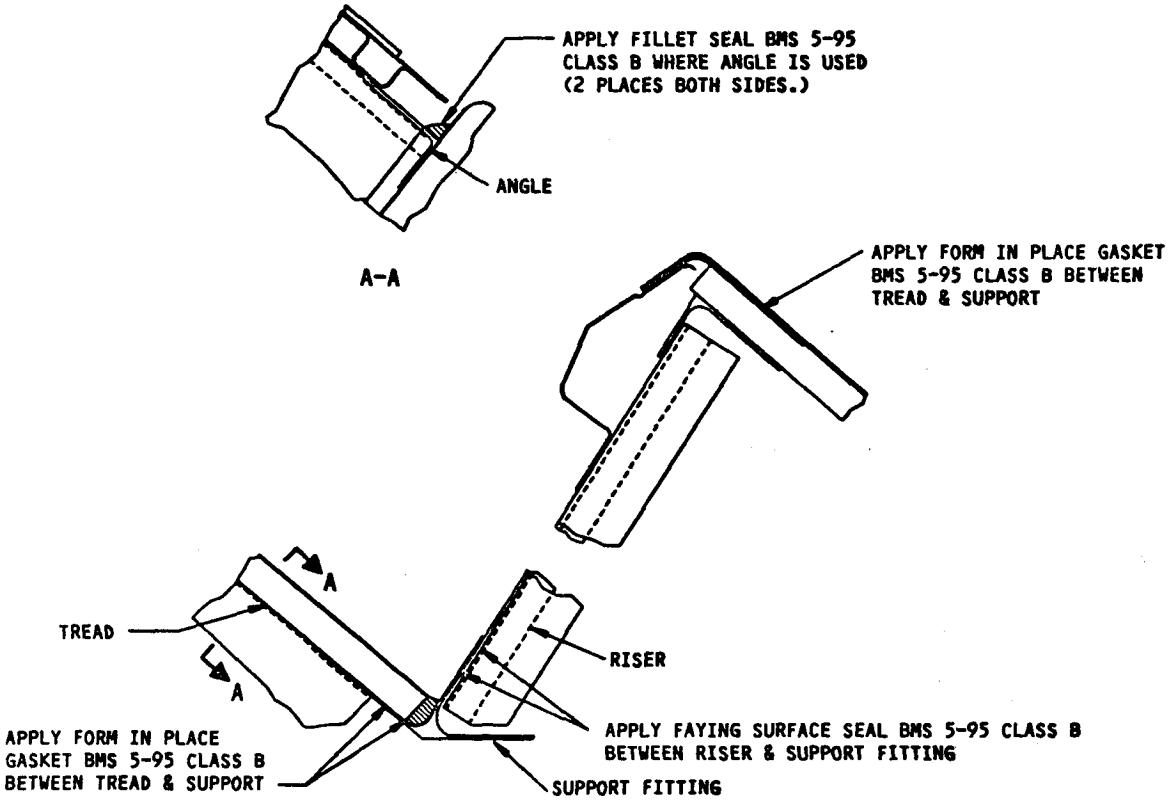
(h) Install web (25) on center ladder assembly, P/N 65-68956-1, and secure with items (21 thru 13).

(i) Install fillers (12 and 11) and web (10); secure with bolts (9 and 7), washers (6 and 8) and nuts (5).

(j) Install grommet (4).

(k) Install cover (3) and secure with washers (2) and bolts (1).

NOTE: Install center group of wire bundle installation, P/N 65-48324 (reference), after step (k) is completed.



Tread and Riser Sealing
Figure 501A

C. Upper Ladder Assembly (Fig. 1110 and 1111)

(1) Upper Ladder Assembly, P/N 58168-1 and -31 and 65-68957-1

(a) Apply BMS 10-11, type 1 primer to faying surfaces of bearings (177) and bearing housing: ; install bearings and secure with retainer rings (176).

(b) Install grommet (75, 78, and 126).

(c) Install track assemblies (55, 64, 101 and 112) and shims (73, 74, 123, and 124) using items (40 thru 54 and 81 thru 100). Use shims as required to meet the following requirements. Apply BMS 10-11, type 1, primer to shims after delamination.

1) Maintain a dimension of 3.65 to 3.68 inches between the bottom surface of hinge fitting assemblies (175X) and the inside surface of the track lower flange.

2) Obtain parallelism between the bottom surfaces of track assemblies (55 and 101) and track assemblies (64 and 112) within 0.02 inch.

(d) If reinforcement (175A) is used, install with shims (173A, 173D, 175B, 175M, 175R, and 175S), a stiffener (175L), and separator (175N). Use shims as necessary to obtain fit of reinforcement (175A) on riser (194), hinge fitting (175X), and stair. Apply sealant, BMS 5-95, to all fasteners used to install reinforcement, shims, stiffener, and separator prior to installation.

(e) Position clipnuts (39) in place, if used, and install lights (36) in riser assemblies.

(f) Reassemble partially disassembled tread assemblies (21 and 6) by installing bullnoses (24 and 9). Secure with bolts (8 and 23).

(g) Position clipnuts (7 and 22) in place on straps (17 and 32) respectively for attaching tread assemblies to ladder structure.

(h) Apply formed-in-place gaskets between tread assemblies (21 and 6) and support structure as follows (Fig. 501A):

1) Solvent clean faying surfaces of tread assemblies (21 and 6) and support structure. Wipe solvent off with clean wiper before it evaporates.

2) Apply parting agent or parting film to cleaned faying surfaces of tread assemblies (21 and 6).

3) Apply sealant, BMS 5-95, class B, to opposite cleaned surfaces on support structure.

4) When parting agent is dry-to-touch, assemble parts within application time of sealant.

5) Install attaching parts (1 thru 3C, 4 thru 5C, 19 and 20)

6) Trim excessive sealant.

(i) Apply fillet seal of BMS 5-95, class B sealant on each side of tread where angle is used (Fig. 501A).

(j) If reinforcement (175A) is used, apply organic corrosion inhibiting compound, per 20-41-05, to bottom of tread assembly which mates with reinforcement (175A) prior to installation.

NOTE: Install upper group of wire bundle installation, P/N 65-48324 (reference), after step (j) is completed.

(2) (a) thru (2)(h) Deleted

D. Folding Mechanism Installation (Fig. 1109)

(1) Preassemble the following parts to the upper ladder assembly:

(a) Insert shaft (162) into position on the ladder structure.

NOTE: Longest shaft end measured from end shoulders should be positioned on aft side of structure.

(b) Slide spacers (161) onto fore side of shaft (162) until they rest on shoulders of shaft.

(c) Apply grease MIC-G-23827 to faying surfaces of bearings (160) and housing and slip bearings over shaft (162) into housing.

(d) Install bearing retainer (159) on aft side bearing, and secure with items (158 thru 156).

(e) Adjust end play between forward bearing (160) and housing by removing laminations from spacer (161) as required to obtain clearance of 0.02 to 0.03 inch as shown in Fig. 502.

(f) Position cranks (155) in place and secure with items (154 thru 152).

(g) Slip spacers (151 thru 147) onto shaft (162).

(h) Preassemble cranks (146 and 146A) with bolts (140), washers (138), cam rollers (139) and nuts (137). Torque nuts (137), 200 to 500 inch pounds and install cotter pins (136) so that they do not extend beyond end of bolt. If cotter pin (136) cannot be installed within given torque range of nut (137), remove lamination from washer, shim (141), refinish and install under head of bolt (140) using minimum thickness required.

(i) Position spacers (151 thru 147) and cranks (146 and 146A) on shaft (162). Remove lamination from spacers (151 thru 147) as required to obtain clearance of 0.12 to 0.18 inch between ladder structure and heads of bolts (140) as shown in Fig. 503. Secure cranks with items (145 thru 142).

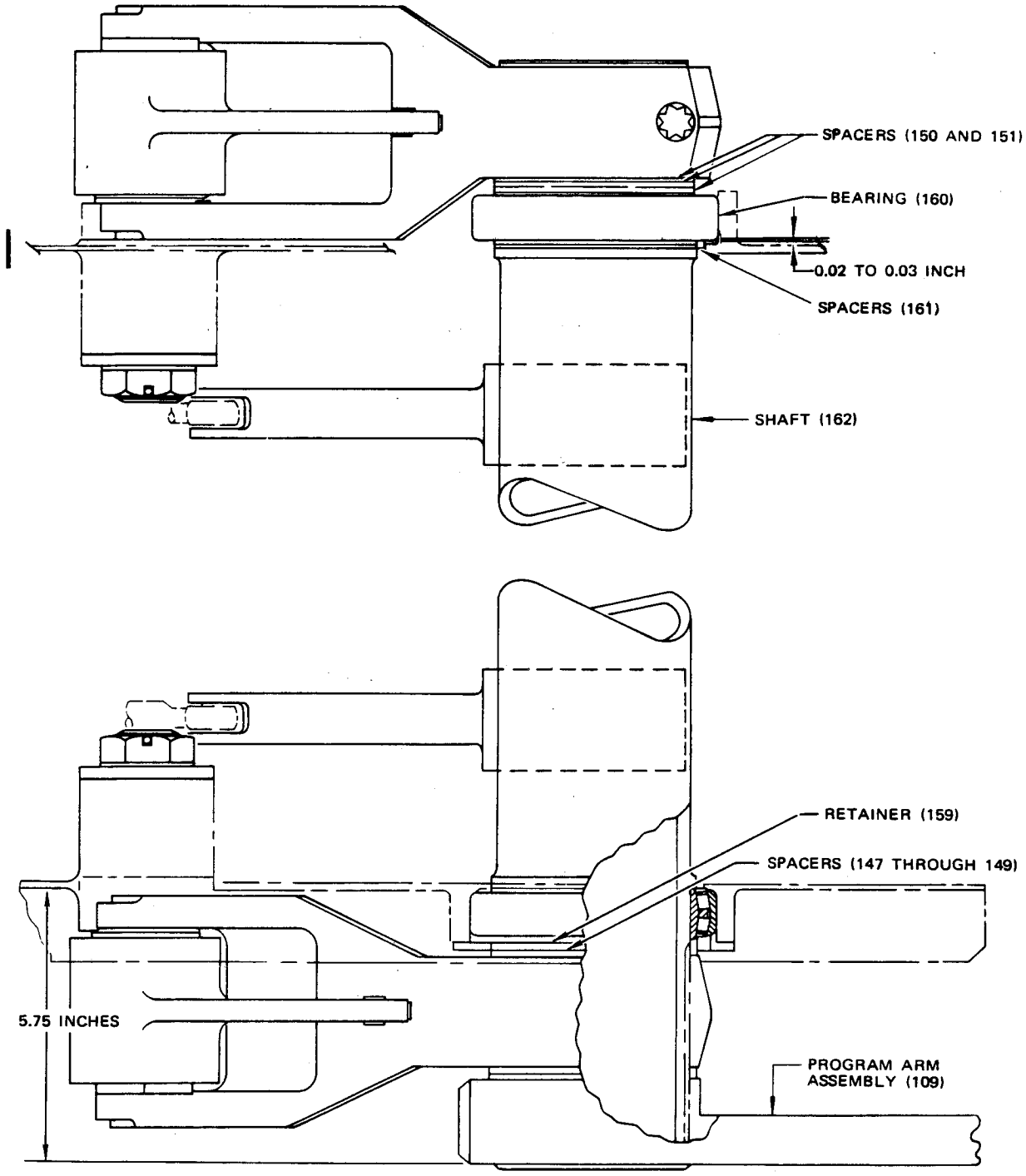
(j) Preassemble cam assembly (127) with pin (121), bearing (125) and spacer (126). Pack cavity between bearings (125 and 131) with grease, MIL-G-21164A.

(k) Engage cam assemblies (127) with cam rollers (139). Position spacers (124 thru 122) removing lamination as required to obtain clearance of 0.065 to 0.100 inch between washers (138) and cams (135) as shown in Fig. 503. Install washers (120), washers (119) and nut (118). Torque nuts (118) 200 to 400 inch pounds and install cotter pins (117). Add or subtract washers (119) as required to install cotter pin (117) within given torque range of nut (118).

(l) Position spacers (116 thru 114) and program arm (109) and shaft (162). Remove laminations from spacers (116 thru 114) as required to obtain distance of 5.75 inches from ladder structure to aft side of program arm (109) as shown in Fig. 502. Secure program arm (109) with items (108 thru 105).

(m) Preassemble rod assemblies (99) by installing locknuts (103 and 102) and rod ends (101 and 100) on adjusting rod (104).

NOTE: Do not fully tighten locknuts (103 and 102) or attach lockwire at this stage.



NOTE: ITEM NUMBERS REFER TO FIGURE 1109

Folding Mechanism Installation
Figure 502

(n) Attach rod ends (101) of preassembled rod assemblies (99) on cam assemblies (127) and secure with items (98 through 94).

(o) Install crank assemblies (88) with items (87 through 83). Tighten nuts (83) within a torque range of 200 to 1000 pound-inches and secure with cotter pins (82). Add or remove washers (84) as required, to permit cotter pin installation within indicated torque range of nuts (83).

(p) Attach crank assemblies (88) to free end of rod assemblies (99) with items (81 through 78).

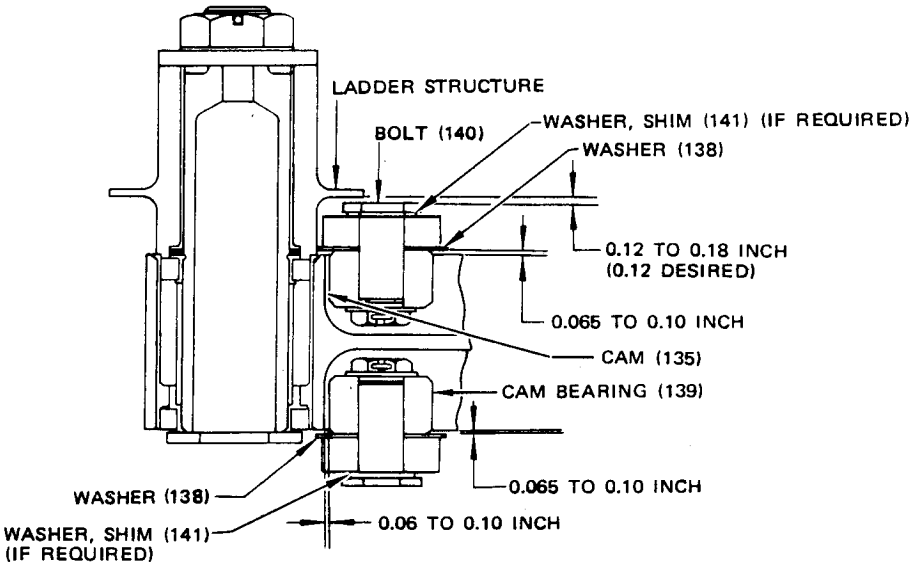
NOTE: Do not attach cotter pins (77) at this stage.

(2) Preassemble following parts to lower ladder assembly:

(a) Install crank assemblies (70) with items (69 through 64).

NOTE: Do not attach crank assemblies (70) to crank assemblies (88) at this stage.

(b) Attach one end of pushrods (58), countersunk hole on outer side, to free end of crank assemblies (88) with items (57 through 55). Torque nuts (55) not to exceed 105 inch pounds. Install cotter pins (54).



NOTE: ALL ITEM NUMBERS REFER TO FIGURE 1109

Folding Mechanism Cam Installation
Figure 503

(c) Attach idler crank assemblies (49) to the free end of pushrods (58) with items (48 through 46). Torque nuts (46) not to exceed 105 inch pounds. Install cotter pins (45).

(d) Install idler crank assemblies (49) with items (44 through 40). Tighten nuts (40) to a torque range of 200 to 750 pound-inches. Add or remove washers (41), as required, to align cotter pin holes within indicated torque range of nuts (40). Install cotter pins (39).

(e) Preassemble pushrod assemblies (28) by installing nuts (32 and 30) and clevis end (29) on adjusting rod (31).

NOTE: Do not tighten nuts (32 and 30) at this stage.

(f) Attach clevis ends (37) of pushrod assemblies (28) to free end of idler crank assemblies (49) with items (27 through 25). Torque nuts (25) not to exceed 105 pound-inches. Install cotter pins (24).

(g) Install crank assemblies (19) with items (18 through 14). Tighten nuts (14) to a torque range of 200 to 1000 pound-inches and secure with cotter pins (13).

NOTE: Add or remove washers (15) to permit cotter pin (13) installation within indicated torque range of nuts (14).

(h) Attach crank assemblies (19) to free end of pushrod assemblies (28) with items (12 through 10). Torque nuts (10) not to exceed 105 pound-inches. Install cotter pins (9).

(3) Install link assemblies (6) to lower ladder assembly with items (4 through 1).

NOTE: Do not attach link assemblies (6) to crank assemblies (19) at this stage.

E. Carriage Assembly (Fig. 1108).

(1) Preassemble carriage assembly as follows:

(a) Position washers (26), socket fitting assemblies (22) and center-bonded mounts (21), and secure with items (20 through 15).

NOTE: Use washer (18), P/N 69-49762-5, with center-bonded mount (21) installed in lower aft corner only.

(b) Install mounting brackets (14) with washers (13) and bolts (12).

NOTE: Do not tighten bolts (12) at this stage. These will be tightened on airplane installation after adjustment to door is completed.

Use washers (13), as required, to keep protrusion of bolts (12) beyond nutplate (24) to a maximum of 0.040 inch.

(c) Install mounting plate assemblies (7) with washers (6) and bolts (5).

NOTE: Do not tighten bolts (5) at this stage. These will be tightened on airplane installation after adjustment to door is completed.

(d) Install washers (4), unit needle bearings (3), washers (2), and nuts (1).

(2) Install preassembled carriage assembly by sliding it through track assemblies of upper ladder assembly (figure 1110 or 1111); check that carriage assembly runs freely in tracks without binding throughout its travel.

F. Door Rod Assembly Installation (See figure 1101.)

(1) Preassemble door rod assemblies (17) as follows:

(a) Install checknut (19) on bearing end (18).

(b) Turn bearing end (18) into rod (23).

NOTE: Do not tighten checknut (19) at this stage.

(2) Adjust door rod assembly to a length of 12.59 to 12.61 inches, measured from centerlines of bolt holes, by turning bearing end (18) in or out from rod (23); tighten checknut (19).

(3) Attach door rod assemblies (17) to folding mechanism (25) and to carriage assembly (24) with items (15 through 7).

G. Segment Lock Installation (See figure 1107.)

(1) Install cam (31) on carriage assembly corner bracket with items (30 through 28).

NOTE: Bolts (30) should be installed with countersunk holes of cam (31) centered in slots of corner bracket assembly (items 36 and 42, figure 1108).

(2) Install bearings (27, figure 1107) on center ladder assembly structure with items (26 through 23).

(3) Preassemble hook assemblies (16) by installing eyebolt (19), washer (18), and locknut (17) on hook (22).

(4) Assemble bearings (15) with items (14 through 12), spacers (11), and bearings (10) on hook assemblies (16).

NOTE: Fill cavity between bearings (20 and 15) with grease, Specification MIL-G-21164A.

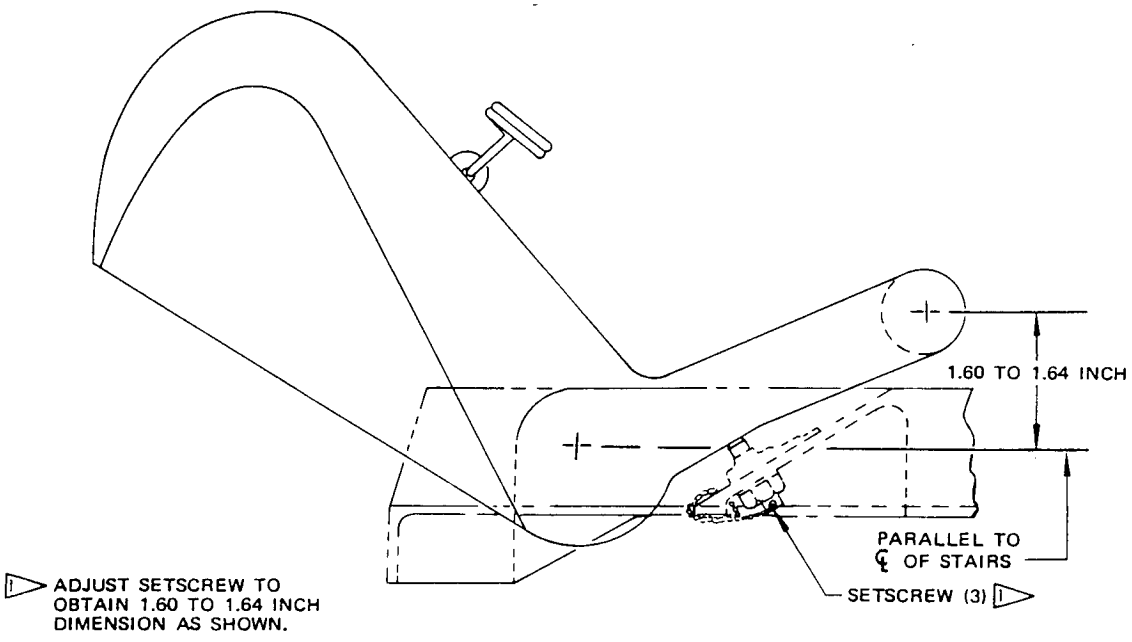
(5) Rotate program arm of folding mechanism (figure 1109) to position cam (31, figure 1107) away from edge of upper ladder structure and install hook assemblies (16) on upper ladder assembly with items (9 through 5).

NOTE: Check that hook assemblies (16) rotate without binding or interference with upper ladder structure. Install a maximum of two washers (9), if required, to meet this condition.

(6) Install springs (4).

(7) Install setscrews (3) with washers (2) and nuts (1). Adjust setscrew to obtain dimension shown in "Setscrew Adjustment," figure 504.

(8) Secure setscrews (3) with lockwire, P/N MS20995NC40, or equivalent.



Setscrew Adjustment
Figure 504

H. Damper Installation (See figure 1106.)

(1) Install link assembly (22) to upper ladder assembly structure with items (21 through 18).

(2) Install following parts to center ladder assembly:

(a) Position crank assembly (15), bearing (10), and spacers (9 and 8) on center ladder assembly fitting, taking care to position spacers as shown in figure 1106.

(b) Align missing gear tooth of shaft (7) to missing gear groove of crank assembly (15) and install shaft (7), key washer (6) and nut (5). Tighten nut (5) and crimp tangs of washer (6) into slots of nut (5).

NOTE: Rotate crank assembly (15) about axis of shaft (7) and check that no binding occurs.

Do not attach crank assembly (15) to link assembly (22) with items (14 through 11) at this stage. This will be done after ladder assemblies are joined per procedure I, below.

(c) Rotate crank assembly (15) to its normal position when attached to link assembly (22); align missing tooth on shaft of damper (4) to missing groove on shaft (7) and engage damper (4) to shaft (7).

(d) Align damper flange holes to upper ladder fitting holes and install bolt (3), washer (2), and nut (1).

(e) Measure break-away torque of damper (4). Force required to rotate input spline in either direction shall not exceed 100 pound-inches.

I. Join sections of ladder assemblies as follows: (See figure 1101.)

(1) Mount upper ladder in a rigging jig, P/N FAJ65-56632-1 and FME65-56632-1, or equivalent.

NOTE: Prior to mounting upper ladder, rotate program arm of folding mechanism (25) to engage cam follower bearing and cam of segment lock installation (6). Tie program arm to ladder structure to maintain this position.

(2) Mount center and lower ladder to the jig and align hinge fitting holes of three ladders.

NOTE: Check that hook and bearing of segment lock installation (6) are properly engaged.

(3) Position wire bundle guard (31) on aft side of stair at upper hinge, and install items (30 through 26) on all four hinge connections.

J. Preliminary Rigging Procedure (See Fig. 505 and 1109.)

(1) Attach crank assemblies (88) to crank assemblies (70) with items (63 through 59).

(2) Attach crank assemblies (19) to link assemblies (6) with bolts (5) and items (4 through 2). Torque nuts (2) not to exceed 105 pound-inches. Install cotter pins (1).

(3) Hold upper ladder in position so that center and lower ladder assembly will be cantilevered off upper ladder assembly. (Center ladder will contact upper ladder through shim at point "B," Fig. 505.) Support lower ladder assembly by clamping to center ladder assembly through hinge fittings to contact tightly at point "A."

NOTE: Clamp through a 0.30-inch shim at point "A."

(4) Rotate and hold program arm assembly (109) in position to place cam roller bearings (139) to within 0.06 to 0.10 inch from end of cam (135); disconnect rod assemblies (99) from crank assemblies (88) by removing items (81 through 78).

(5) Simultaneously adjust forward and aft rod assemblies (28). Extend rod until loose play in all joints is snugged up (finger-tight) and tighten nuts (32 and 30) within a torque range of 400 to 600 pound-inches.

NOTE: Special precaution should be taken to ensure that adjustment is equal on forward and aft sides.

(6) Remove clamps at point "A." (A gap will exist at point "A.") Check that the force required to close the gap at point "A" does not exceed 100 pounds at the lower ladder.

(7) Connect rod assemblies (99) to crank assemblies (88) with items (81 through 77).

(8) Simultaneously adjust forward and aft rod assemblies (99). Shorten rod until loose play in all joints is snugged up (finger-tight) and tighten locknuts (103 and 102) within a torque range of 400 to 600 pound-inches.

NOTE: Special precaution should be taken to ensure that the adjustment is equal on the forward and aft sides.

(9) Fold unit in its nominal retracted position, with upper ladder 5°20' past vertical, and check preloading of ladders. Refer to "Preliminary Rigging Details," Fig. 505. Check only one position at a time.

NOTE: Observe operation of unit for binding. No binding should occur throughout travel from extended to folded position.

(10) With a spring scale hooked between lower and center segments, pull to direction as shown in Fig. 505 and check that a preload of 15 to 30 pounds is present on center segment bumper that rests on hinge arm of upper ladder.

(11) If preload is not within 15-to-30 pound range, extend unit and shorten or lengthen rod assemblies (99) one-half turn at a time. Tighten locknuts of adjustment rods within a range of 400 to 600 pound-inches, retract the unit, and recheck preload requirement.

NOTE: Do not shorten rod more than two complete turns from initial adjustment, and observe special precaution to see that adjustment is equal on forward and aft sides.

(12) Hook the spring scale to the end of the lower segment, pull in direction shown in Fig. 505, and check for a preload of 10 to 60 pounds on the lower segment bumper.

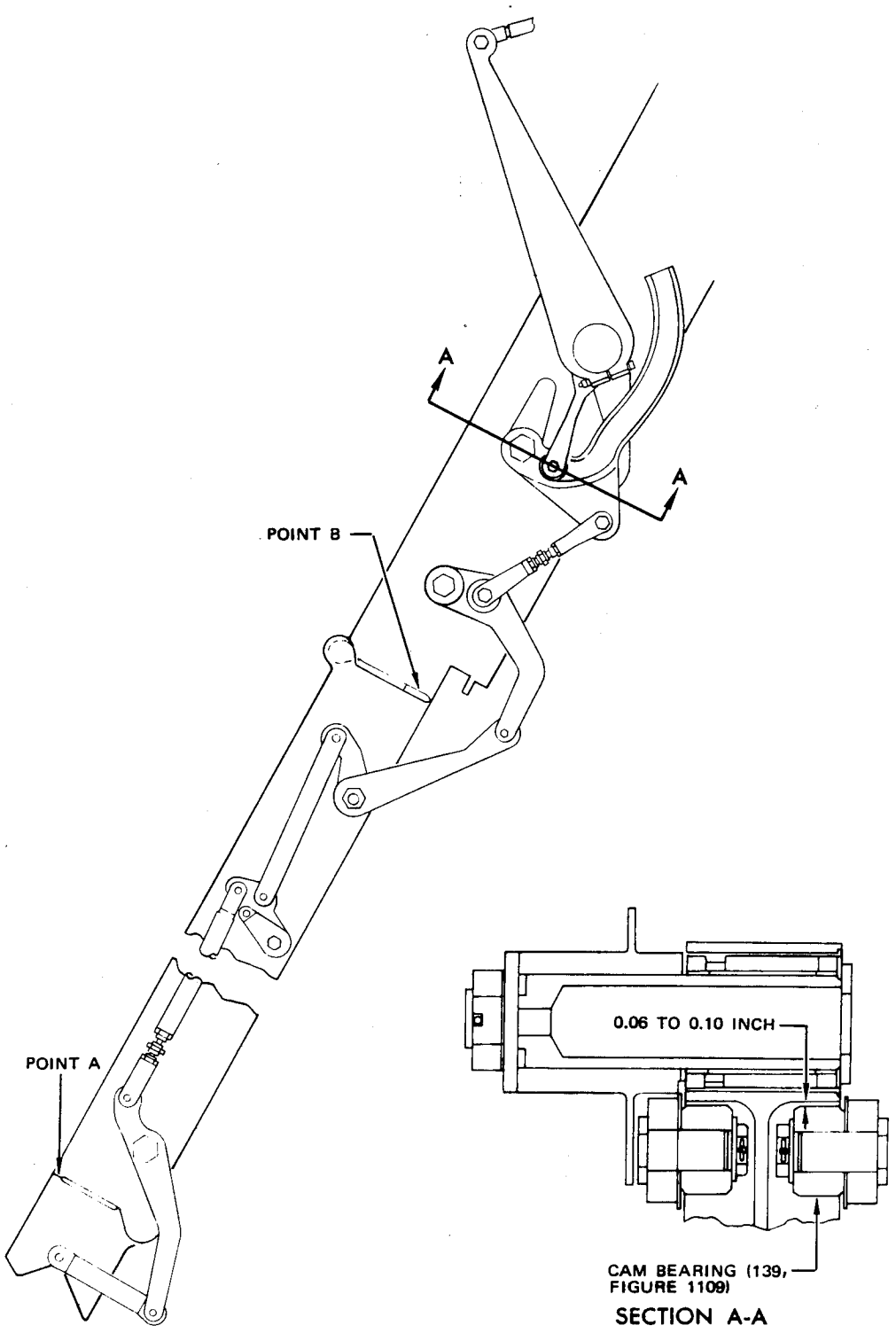
(13) The lower limit of the 10-to 60-pound preload can be adjusted by adding washers (items 28 or 52 of Fig. 1112 or 1113) on lower segment bumper, as required, but not to exceed 0.50 inch total thickness. Recheck preload requirement.

NOTE: The lower limit will go down to below 10 pounds when handrail installation, Fig. 1102, is installed.

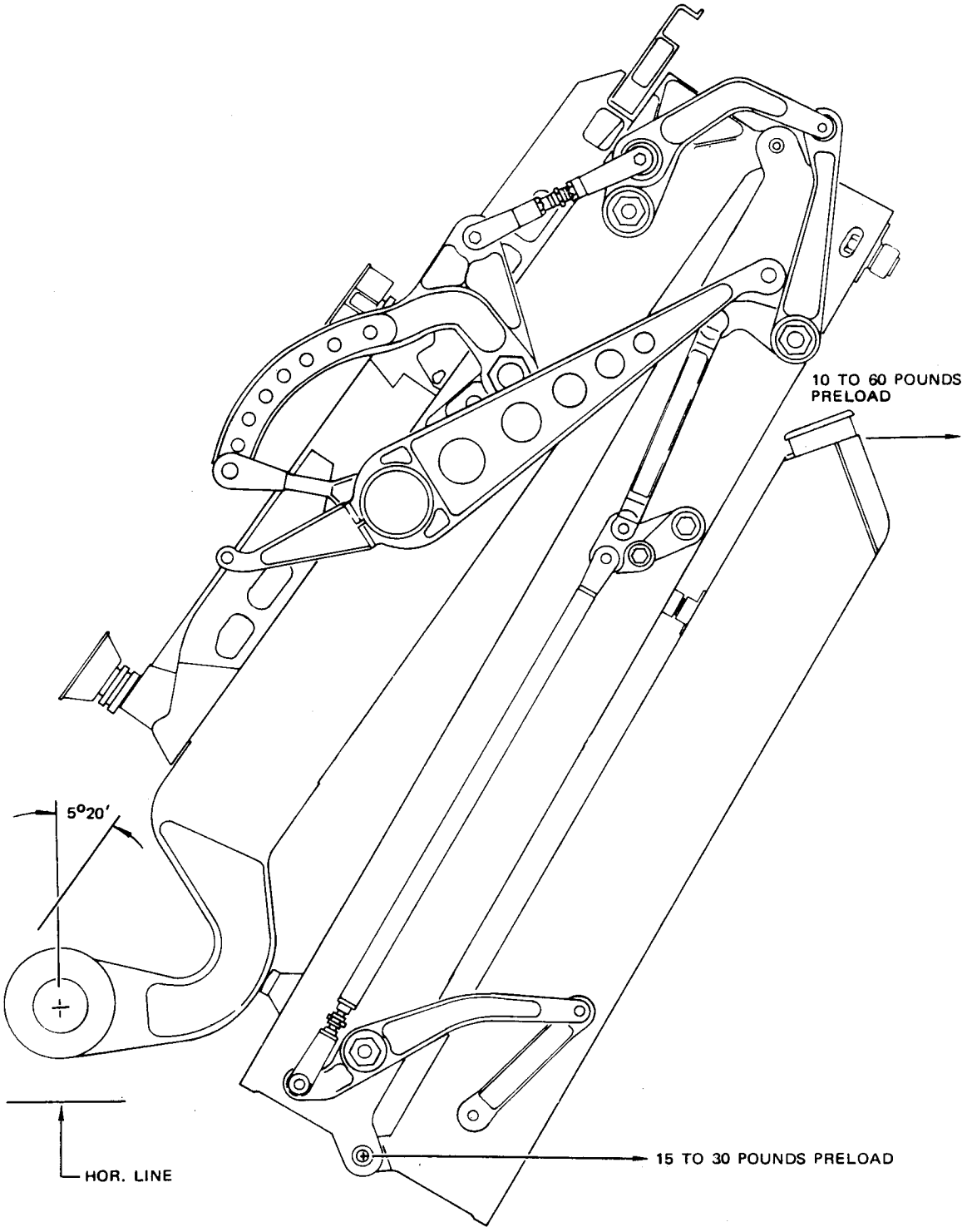
(14) Extend the unit and safety wire adjustment rods to locknuts (103, 102, 30 and 32).

(15) Check that no binding occurs throughout travel from folded to extended position.

(16) Join wire bundle installation, P/N 65-48324 (reference), connections between ladder assemblies.



Preliminary Rigging Details
Figure 505 (Sheet 1)



Preliminary Rigging Details
Figure 505 (Sheet 2)

K. Lower Cover Installation (Fig. 1105)

(1) Attach clipnuts (6).

(2) Install cover (5) with items (4 thru 1).

L. Center Cover Installation (Fig. 1104)

(1) Attach clipnuts (4).

(2) Install cover (3) with items (2 and 1).

M. Upper Cover Installation (Fig. 1103)

(1) Attach clipnuts (5).

(2) Install covers (4 and 3) with items (2 and 1).

N. Handrail Installation (Fig. 1102)

NOTE: Build up each handrail to form a complete unit before installing to the basic airstair assembly.

(1) Preassemble parts as follows:

NOTE: Install all hinge pins using special handrail hinge pin wrench.

(a) Install bumper (201) on fitting assembly (203) attached to stanchion (192), with items (200 thru 196).

(b) Install bearings (193) on fitting (195), attached to stanchion (192), with corrosion preventive compound, MIL-C-11796, class 3.

(c) Attach fitting (195) end of stanchion (192) to midfitting assembly (213) connecting handrail (207) and handle (217), and secure with items (191 thru 188). Check joint for binding by rotating attached parts about pin axis throughout movement span of parts. No binding should exist at any time.

(d) Preassemble fitting (185), attached to guardrail (173), and bushing (183) to link assembly (180) with items (179 thru 177).

(e) Install bushing (176), spacer (175), and bearings (174) with corrosion preventive compound, MIL-C-11796, class 3, on stanchion assembly (192) and link assembly (180); join link assembly (180) to stanchion (192) with items (172 thru 170).

NOTE: Check joint for binding by rotating attached parts about pin axis throughout movement span of parts. No binding should exist at any time.

(f) Preassemble fitting (164) and bearings (162) with corrosion preventive compound, MIL-C-11796, class 3, and join to fitting assembly (209) attached to handrail (207) with items (160 through 157).

NOTE: Check joint for binding by rotating attached parts about pin axis throughout movement span of parts. No binding should exist at any time.

(g) Install bushing (156), spacer (155) and bearings (154) with corrosion preventive compound, MIL-C-11796, class 3, on stanchion (161) and fitting (187) attached to guardrail (173); join fitting (187) to stanchion (161) with items (153 through 151).

(h) Install bearings (143) on fitting (164) with corrosion preventive compound, MIL-C-11796, class 3.

(i) Position one end of handrail (142) attached to fitting (146), on fitting (164) and secure with items (141 through 138).

NOTE: Check joint for binding by rotating attached parts about pin axis throughout movement span of parts. No binding should exist at any time.

(j) Install bearing (135) on fitting (187) with corrosion preventive compound, MIL-C-11796, class 3; insert pin (134) into bearings (135) and slip washer (133) onto pin (134).

(k) Position fitting (137) end of guardrail (132) and plate fitting (131) on fitting (187) and secure with items (130 through 128).

NOTE: Check joint for binding by rotating attached parts about pin axis throughout movement span of parts. No binding should exist at any time.

(l) Install bearings (114) on fitting (116) attached to stanchion (113), with corrosion preventive compound, MIL-C-11796, class 3, and join assembled parts to fitting assembly (125) with items (112 through 109).

NOTE: Check joint for binding by rotating attached parts about pin axis throughout movement span of parts. No binding should exist at any time.

(m) Join mid-section of inner slide (107) to mid-section of stanchion (113) with items (106 through 101).

NOTE: Install bearings (104) with corrosion preventive compound, MIL-C-11796, class 3. Check joint for binding by rotating attached parts about pin axis throughout movement span of parts. No binding should exist at any time.

(n) Join fitting (99), attached to guardrail (94), to end of inner slide (107) with items (97 through 90).

NOTE: Install bearings (97) with corrosion preventive compound, MIL-C-11796, class 3.

Check joint for binding by rotating attached parts about pin axis throughout movement span of parts. No binding should exist at any time.

(o) Join fitting assembly (87), attached to handrail (84), and fitting (116), attached to stanchion (113), with items (85 and 83 through 80).

NOTE: Install bearings (85) with corrosion preventive compound, MIL-C-11796, class 3.

Check joint for binding by rotating attached parts about pin axis throughout movement span of parts. No binding should exist at any time.

(p) Install bearings (68) on fitting (71), attached to stanchion (69), with corrosion preventive compound, MIL-C-11796, class 3, and join to fitting assembly (87) with items (67 through 64).

NOTE: Check joint for binding by rotating attached parts about pin axis throughout movement span of parts. No binding should exist at any time.

(q) Install bearings (63) on link (62) with corrosion preventive compound, MIL-C-11796, class 3, and join to mid-fitting assembly (77) with items (61 through 58).

NOTE: Check joint for binding by rotating attached parts about pin axis throughout movement span of parts. No binding should exist at any time.

(r) Install bearings (57) on free end of link (62) with corrosion preventive compound, MIL-C-11796, class 3, and join to fitting (100) with items (56 through 54).

(2) Install lower segment of handrail installation on basic airstair assembly as follows:

NOTE: Folding mechanism installation (figure 1109) should be properly rigged before installing handrail.

(a) Insert spacer (53) and bearing (52) in fitting assembly (73), attached to stanchion (69), with corrosion preventive compound, MIL-C-11796, class 3.

(b) Position fitting assembly (73) in place on lower ladder structure and install items (51 through 48). Tighten nut (48) within a torque range of 100 to 1000 pound-inches and secure with cotter pin (47).

NOTE: Initially install three washers (49); add or remove one washer, if necessary, to permit installation of cotter pin (47) with nut (48) tightened within specified torque range.

Check joint for binding by rotating attached parts about bolt axis throughout movement span of parts. No binding should occur.

(c) Insert spacer (46) and bearing (45) in place on the center ladder structure with corrosion preventive compound, MIL-C-11796, class 3, and install fitting assembly (118), attached to stanchion (113), with items (44 through 41). Crimp two tangs of washer (42) to locknut (41).

NOTE: Check joint for binding by rotating attached parts about pin axis throughout movement span of parts. No binding should occur.

(d) Preassemble tierod assembly (35) as follows:

1) Install locknut (37) on fitting (36) and screw fitting (36) into rod assembly (38).

2) Adjust length of tierod assembly (35) by turning fitting (36) in or out of rod assembly (35) to obtain a nominal length of 6.55 inches measured between centerlines of bolt holes. Do not fully tighten nut (37) at this stage.

(e) Temporarily install tierod assembly (35).

(3) Install upper segment of handrail installation as follows:

(a) Join upper segment of handrail installation through telescopic parts, items (107, 122, 132, and 142).

NOTE: Check that handrail (122) slides smoothly into and out of handrail (142), and that inner slide (107) slides smoothly into and out of guardrail (132).

(b) Insert spacer (26) and bearing (25) in place on upper ladder structure with corrosion preventive compound, MIL-C-11796, class 3, and install fitting assembly (166), attached to stanchion (161), with items (24 through 21). Crimp two tangs of washer (22) to locknut (21), and install cap (20).

(c) Preassemble tierod assembly (12) by installing nut (16) on fitting assembly (13) and screw fitting (13) into tierod assembly (17). Do not fully tighten nut (16) at this stage.

NOTE: Do not install tierod assembly (12) at this stage. This will be done on rigging procedure.

(d) Insert spacer (7) and bearing (6) in fitting assembly (203), attached to stanchion (192), with corrosion preventive compound, MIL-C-11796, class 3, and install joint to upper ladder structure with items (5 through 2). Tighten nut (2) within a torque range of 100 to 1000 pound-inches and install cotter pin (1).

NOTE: Initially install three washers (3); add or remove one washer, if necessary, to permit installation of cotter pin (1) with nut (2) tightened to within specified torque range.

O. Final Rigging Procedure (See figures 506 and 1102.)

(1) With tierod assembly (12) disconnected and tierod assembly (35) temporarily installed, fold the ladders until they rest on the bumpers. Use great care in this operation and check handrail pivot joints continually to see that they are free from binding.

(2) Check that clearance dimensions are within specified range as shown in "Final Rigging Details," figure 506, and disconnect tierod assembly (35).

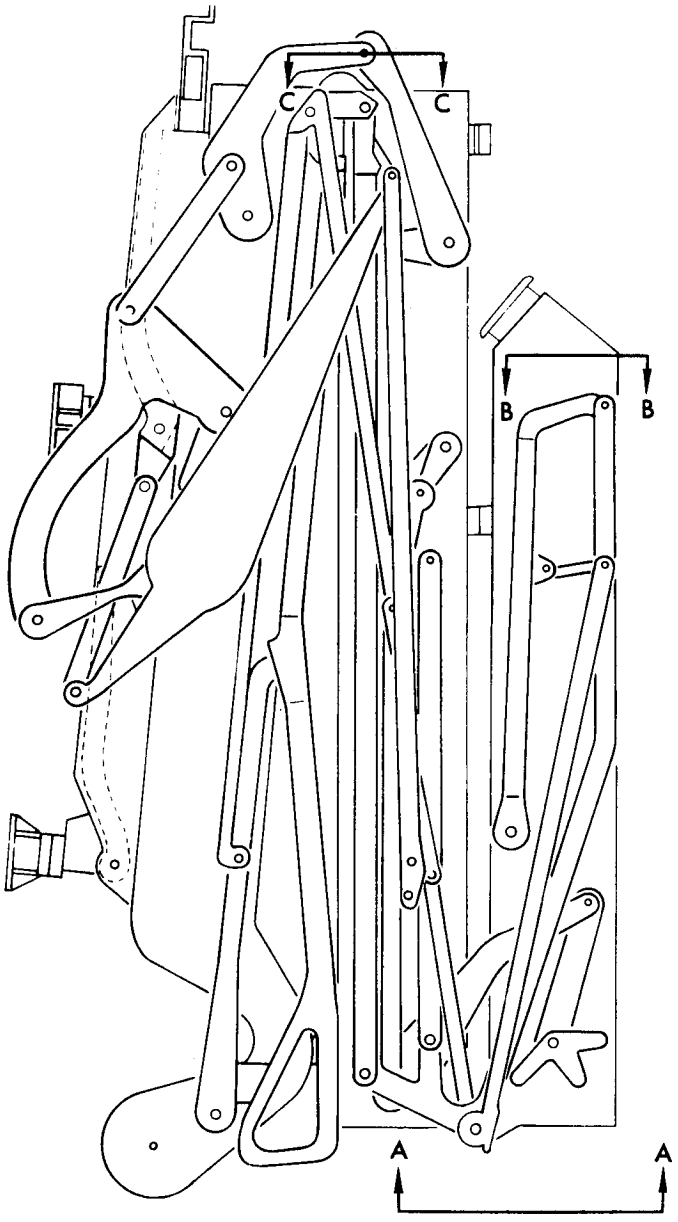
(3) Adjust and connect tierod assembly (12) with items (11 through 8) so that upper outboard stanchion (161) is drawn against rub pad on hub of folding mechanism crank (88, figure 1107).

NOTE: Tighten nut (16) after adjustment of tierod assembly (12).

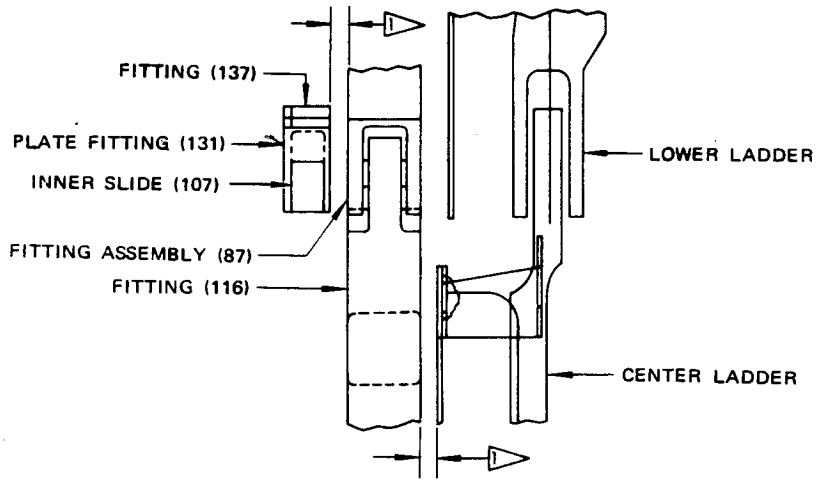
(4) Adjust and connect tierod assembly (35) with items (34 through 27) to maintain a preload of 2 to 5 pounds of stanchion (69) against bumpers (4, figure 1114) and to align centerlines of outboard hinge of fitting (116, figure 1102) and center and lower ladder hinge to within 0.06 inch.

NOTE: Tighten nut (37) after adjustment of tierod assembly (35).

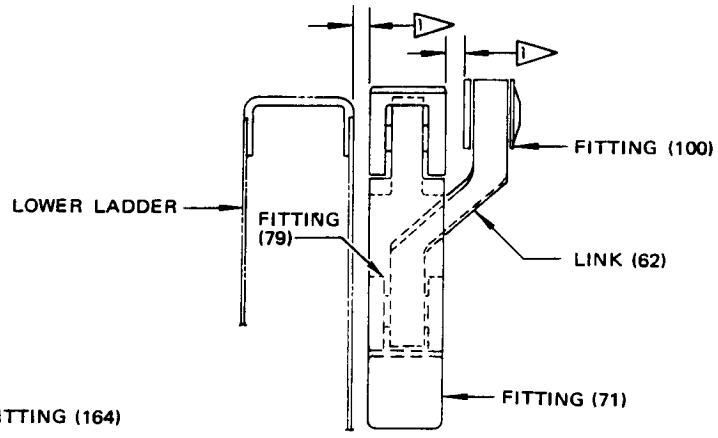
(5) Unfold ladder assemblies and check that handrails operate smoothly without binding.



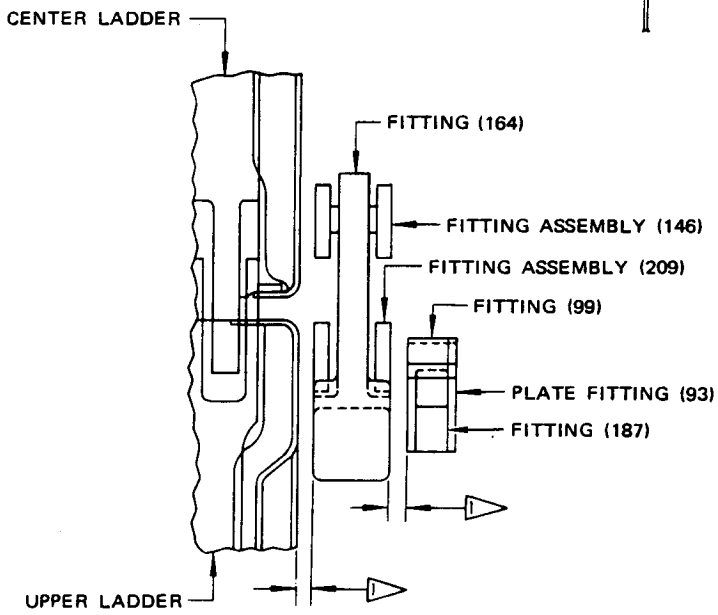
Final Rigging Details
Figure 506 (Sheet 1)



SECTION A-A



SECTION B-B



SECTION C-C

▷ 0.19 TO 0.43 INCH; 0.31 INCH DESIRED

NOTE: ITEM NUMBERS REFER TO FIGURE 1102

P. Materials

NOTE: Use listed materials or equivalent substitutes

(1) Primer -- BMS 10-11, type 1

(2) Grease -- MIL-G-21164

(3) Corrosion Preventive Compound -- MIL-C-11796, class 3

(4) Sealant -- BMS 5-95 (20-60-04)

(5) Water Displacing Compound -- LPS-3, LPS Research Laboratories Inc., 2050 Cotner Avenue, Los Angeles, California 90025

(6) Parting Agent -- 4A-183 Green Stripable Vinyl Coating (20-60-04)

(7) Parting Film -- Delchem X-769 (20-60-04).

(8) Solvent

(a) Isopropal Alcohol, TT-I-735

(b) Methyl Ethyl Ketone, TT-M-261

(c) Toloene, TT-T-548

(9) Organic Corrosion Inhibiting Compound -- BMS 3-23 (20-41-05)

TESTING

1. Preparation for Test

   A. Mount unit in a rigging jig, P/N FAJ65-56632-1 and FME65-56632-1, or equivalent.

2. Operational Test

   A. Slowly retract and extend unit to its nominal positions several times.

   B. Check that no binding occurs during entire travel and that handrail and folding mechanism fold and unfold smoothly, without any jerky movement.

TROUBLE SHOOTING

1. Binding will be the only trouble encountered during test of the unit. This trouble may be from many sources, or may be caused by a single source only. As binding is detected, determine where it might have occurred and make necessary corrections.

Trouble	Possible Cause	Correction
A. Segment lock installation (6, Fig. 1101) binds	Improper clearance between hook (22, Fig. 1107) and bearing (27)	Adjust shims (33, Fig. 1107)
	Hook assembly (16, Fig. 1107) interferes with upper ladder structure	Install a maximum of two washers (9, Fig. 1107) as required, between hook assembly and upper ladder structure
	Rough bearings	Replace defective bearings
B. Carriage assembly (24, Fig. 1101) binds	Rough unit needle bearing (3, Fig. 1108)	Replace defective bearing
C. Folding mechanism installation (25, Fig. 1101) binds	Unequal adjustment of rods (28 and 99, Fig. 1109) on rigging	Readjust per rigging procedure
	Clearance between edge of cam (135, Fig. 1109) and spacer (138), and head of bolt (140) to edge of ladder structure not within specified limits	Add or remove laminations of spacers (147 thru 151), Fig. 1109) until proper clearances are attained per Fig. 503
	End play of shaft (162, Fig. 1109) not within specified limits	Add or subtract spacers (161, Fig. 1109) for proper clearances per Fig. 502.
	Excessive tightening of nuts with specified torque limits	Retighten nuts within specified tolerances

Trouble	Possible Cause	Correction
	Rough or improper installation of bearings	Disassemble and replace defective bearings. Reassemble and rerig unit, as necessary
D. Handrail installation (1, figure 1101) binds	Rough bearings in fitting joints	Replace defective bearings
	Excessive tightening of nuts (2 and 48, figure 1102)	Retighten nuts within specified tolerances

STORAGE INSTRUCTIONS

1. Position unit in its extended position and wrap entirely in vapor barrier paper. Seal and tag for identity, overhaul, and test date.

2. Enclose unit in a strong container for protection against physical damage.

   CAUTION: AIRSTAIR ASSEMBLY SHOULD BE FIRMLY SUPPORTED THROUGH ITS LADDER STRUCTURES ONLY, TO PREVENT DAMAGE TO SUBASSEMBLY AND INSTALLATION PARTS.

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

SPECIAL TOOLS, FIXTURES, AND EQUIPMENT

NOTE: Equivalent substitutes may be used for listed items.

1. Rigging Fixture -- capable of simulating operation of the airstair when installed in the airplane.

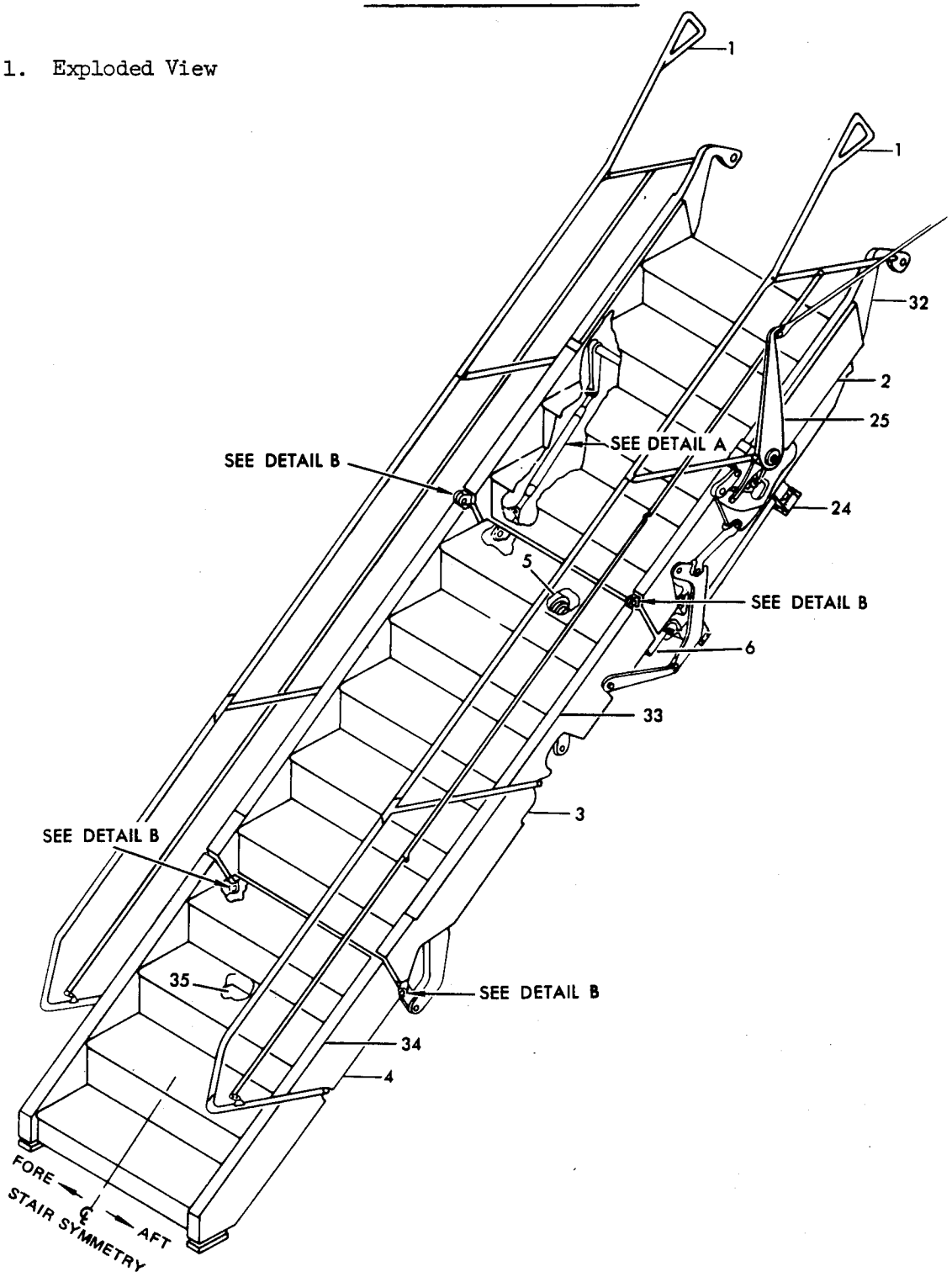
   NOTE: Rigging jigs P/N FAJ65-56632-1 and FME65-56632-1 are Boeing Company production tools. Drawings are available from The Boeing Company, Commercial Airplane Division for manufacture of fixtures similar to those mentioned above.

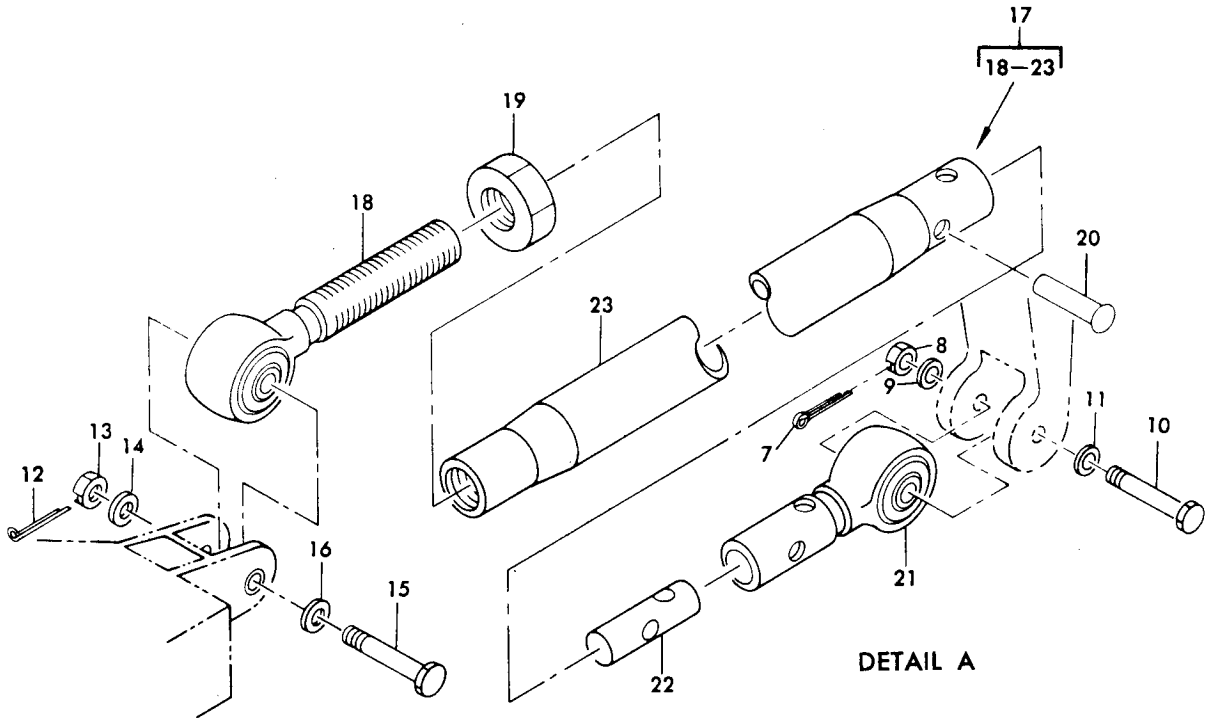
2. Spring Scale or equivalent -- capable of measuring loads within a range of 5 to 100 pounds.

3. Handrail Hinge Pin Wrench, P/N F80157-1 (replaces SE52-1001) -- to install and remove hinge pins on the handrail of the aft airstair.

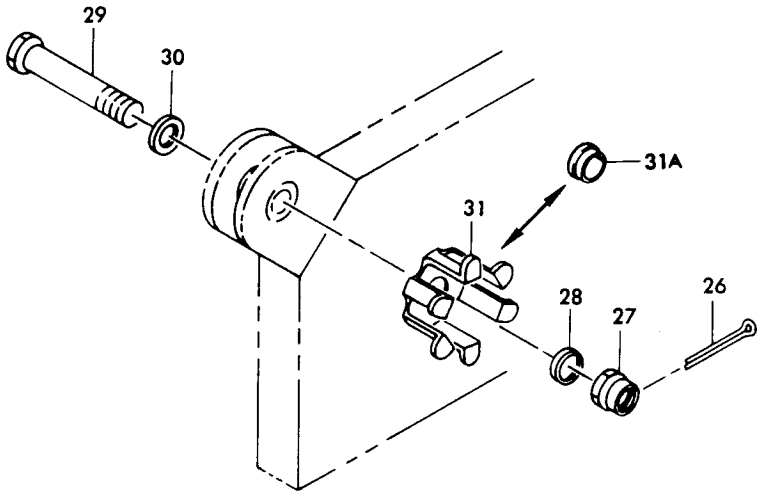
ILLUSTRATED PARTS LIST

1. Exploded View





DETAIL A



DETAIL B
(TYPICAL)

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
	65-56632-1		AFT AIRSTAIR ASSEMBLY	A	
	65-56632-2		AFT AIRSTAIR ASSEMBLY (REWORKED ASSEMBLY 65-56632-1)	B	
1	65-58229-1		. HANDRAIL INSTALLATION, AFT SIDE (FIG. 1102)		1
1	65-58229-2		. HANDRAIL INSTALLATION, FORE SIDE (FIG. 1102)		1
2	65-61780-5		. COVER INSTALLATION, UPPER AFT SIDE (FIG. 1103)		1
2	65-61780-6		. COVER INSTALLATION, UPPER FORE SIDE (FIG. 1103)		1
3	65-61780-3		. COVER INSTALLATION, CENTER AFT SIDE (FIG. 1104)		1
3	65-61780-4		. COVER INSTALLATION, CENTER FORE SIDE (FIG. 1104)		1
4	65-61780-1		. COVER INSTALLATION, LOWER AFT SIDE (FIG. 1105)		1
4	65-61780-2		. COVER INSTALLATION, LOWER FORE SIDE (FIG. 1105)		1
5	65-68950-2		. DAMPER INSTALLATION (REPLS 65-68950-1)(FIG. 1106)		1
5	65-68950-1		. DAMPER INSTALLATION (REPLD by 65-68950-2)(FIG. 1106)		1
6	65-60590-1		. SEGMENT LOCK INSTALLATION (FIG. 1107)		1
7	MS24665-134		. PIN, COTTER		2
8	BACN10JD104		. NUT (REPLS AN320-4)		2
8	AN320-4		. NUT (OBSOLETE)		2
9	AN960-416		. WASHER		2
10	NAS1104-18D		. BOLT		2
11	AN960-416		. WASHER		2
12	MS24665-134		. PIN, COTTER		2
13	BACN10JD104		. NUT (REPLS AN320-4)		2
13	AN320-4		. NUT (OBSOLETE)		2
14	AN960-416L		. WASHER		2
15	NAS1104-18D		. BOLT		2
16	AN960-416L		. WASHER		2
17	65-61336-1		. DOOR ROD ASSEMBLY (PREF)		2
17	69-48922-1		. DOOR ROD ASSEMBLY (OPT TO 65-61336-1)		2
18	BR4M9		. . BEARING, V77896 (PREF)		1
18	RR4M9E6531		. . BEARING, V21335 (OPT to BR4M9)		1
19	AN316-9R		. . NUT, CHECK		1
20	MS20470D6		. . RIVET		2

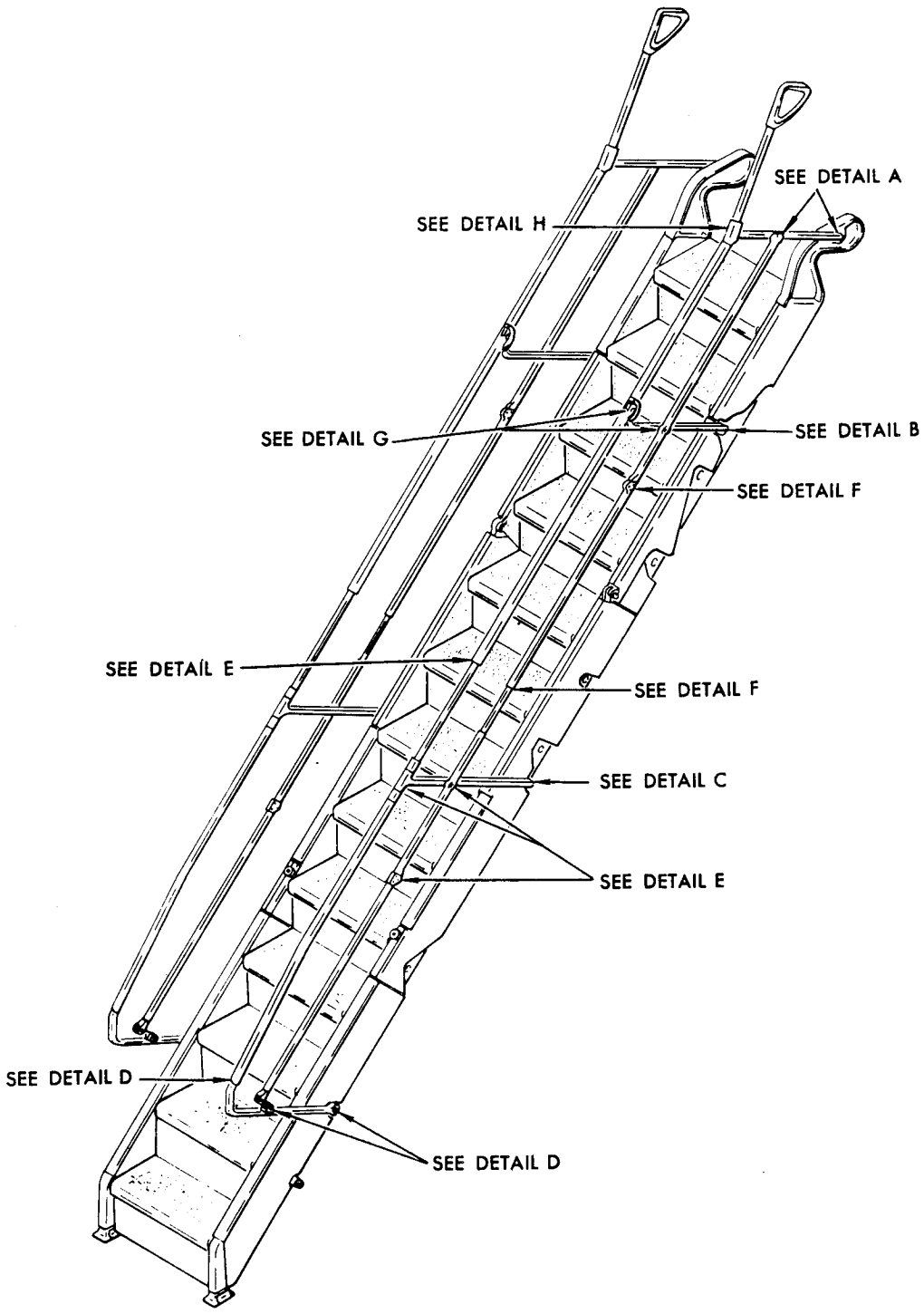
FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1101-					
21	BACB10C240H		. . BEARING (PREF)		1
21	MS20470D6		. . RIVET		2
21	BACB10C240H		. . BEARING (PREF)		1
21	GRR4H10-2		. . BEARING , V21335 (OPT TO BACB10C240H ON 69-48922-1 ONLY)		
22	66-15508-1		. . PLUG		1
23	65-61336-2		. . ROD (USED ON 65-61336-1)		1
23	69-48922-2		. . ROD (USED ON 69-48922-1)		1
24	65-59673-1		. CARRIAGE ASSY (FIG. 1108)		1
25	65-58232-1		. FOLDING MECHANISM INSTL (FIG. 1109)		
26	MS24665-287		. PIN, Cotter		4
27	BACN10JD6		. NUT (REPLS AN310-6)		
27	AN310-6		. NUT		4
28	AN960PD616		. WASHER		4
29	BACB30NE6D20		. BOLT (REPLS NAS1306-20D) *[1]		4
29	NAS1306-20D		. BOLT *[1]		4
29	BACB30NE6D22		. BOLT (REPLS NAS1306-22D) *[2] (SB 24-1016)		1
29	NAS1306-22D		. BOLT (SB 24-1016) *[2]		1
30	AN960PD616		. WASHER		4
31	69-52255-1		. WIRE BUNDLE GUARD *[1]*[2]	A	1
31A	NAS77A6-8P		. SPACER (SB 24-1016) *[2]		1
32	65-58168-31		. LADDER ASSY, UPPER (FIG. 1110)	B	1
32	65-58168-31		. LADDER ASSY, UPPER (PREF TO 65-68957-1)(REPLS 65-58168-1) (FIG. 1110)	A	1
32	65-58168-1		. LADDER ASSY, UPPER (REPLD by 65-58168-31)(FIG. 1110)	A	1
32	65-68957-1		. LADDER ASSY, UPPER (OPT TO 65-58168-31)(FIG. 1111)	A	1
33	65-58169-30		. LADDER ASSY, CENTER	B	1
33	65-58169-30		. LADDER ASSY, CENTER (PREF) (REPLSs 65-58169-1)(FIG. 1112)	A	
33	65-58169-1		. LADDER ASSY, CENTER (REPLD by 65-58169-30)(FIG. 1112)	A	1
33	65-68956-1		. LADDER ASSY, Center (OPT TO 65-58169-30)(FIG. 1113)	A	1
33	65-68956-13		. LADDER ASSY, CENTER (OPT TO 65-58169-30)(FIG. 1113)	A	1
34	65-58170-1		. LADDER ASSY, LOWER (FIG. 1114)		
35	MS27253F1		. PLATE, IDENTIFICATION		1
36	65C31295-1		. AFT AIRSTAIR ASSY (FIG. 1115) FOR REWORKED AFT AIRSTAIR ASSY)	B	1

*[1] LIMITED USAGE
*[2] USED ON AFT SIDE OF STAIR AND AT UPPER HINGE ONLY

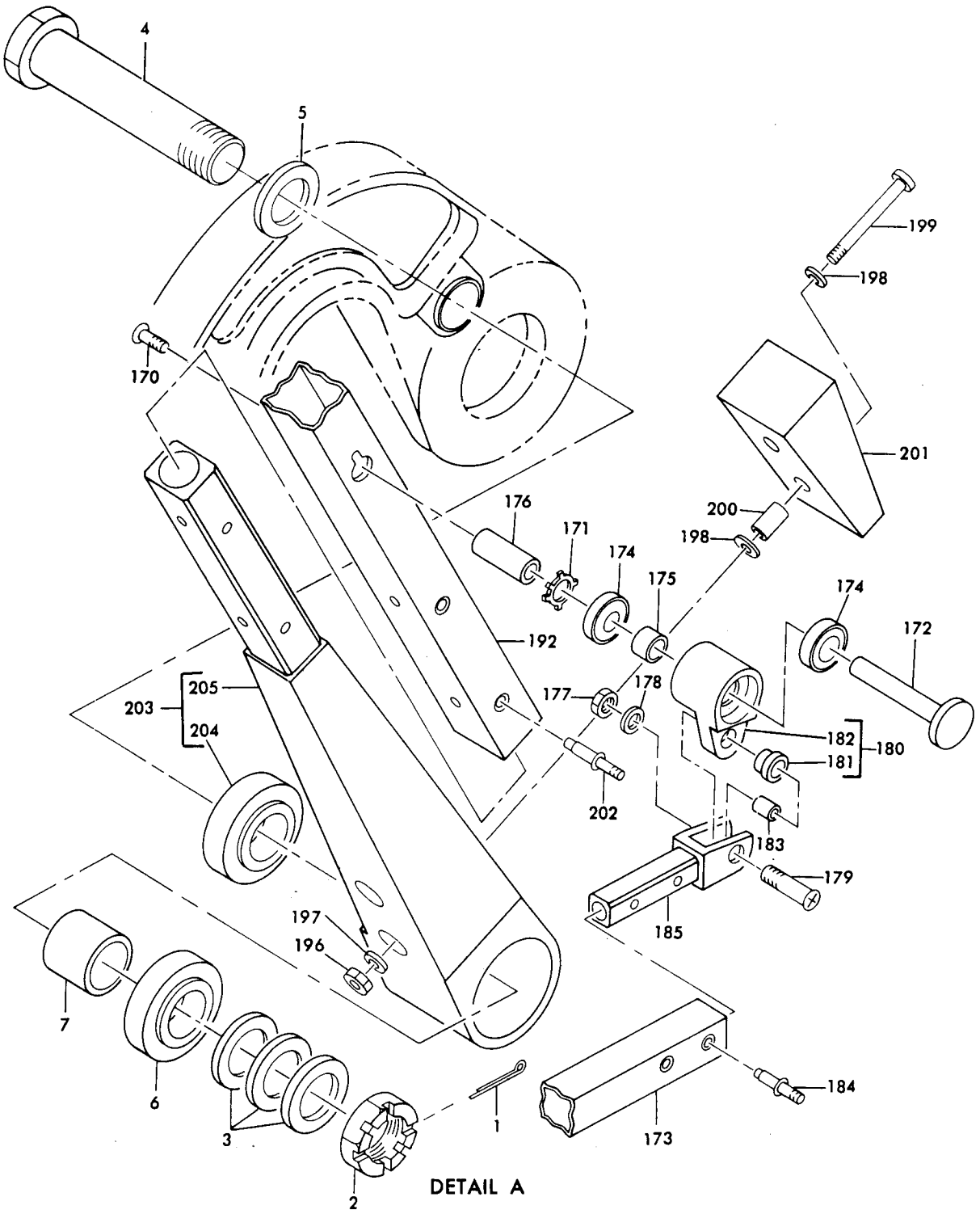
VENDOR CODE

Code	Name and Address
V21335	Fafnir Bearing Co. Division Textron, Inc., 37 Booth St. New Britain, Connecticut 06050
V77896	Shafer Bearing Division Rex Chainbelt Incorporated Belmont Road at Curtiss St. Downers Grove, Illinois

3. Exploded View



Handrail Installation
Figure 1102 (Sheet 1)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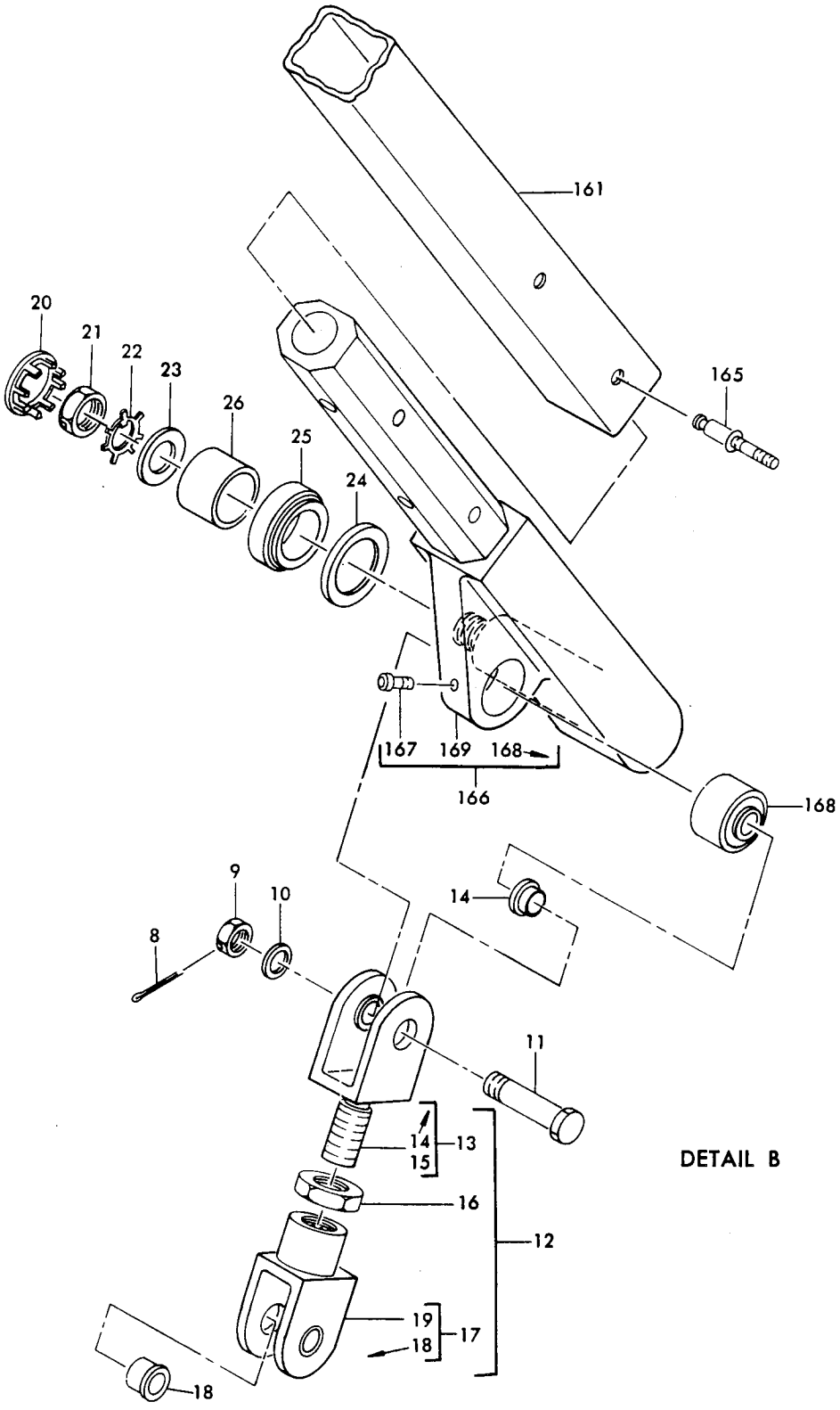
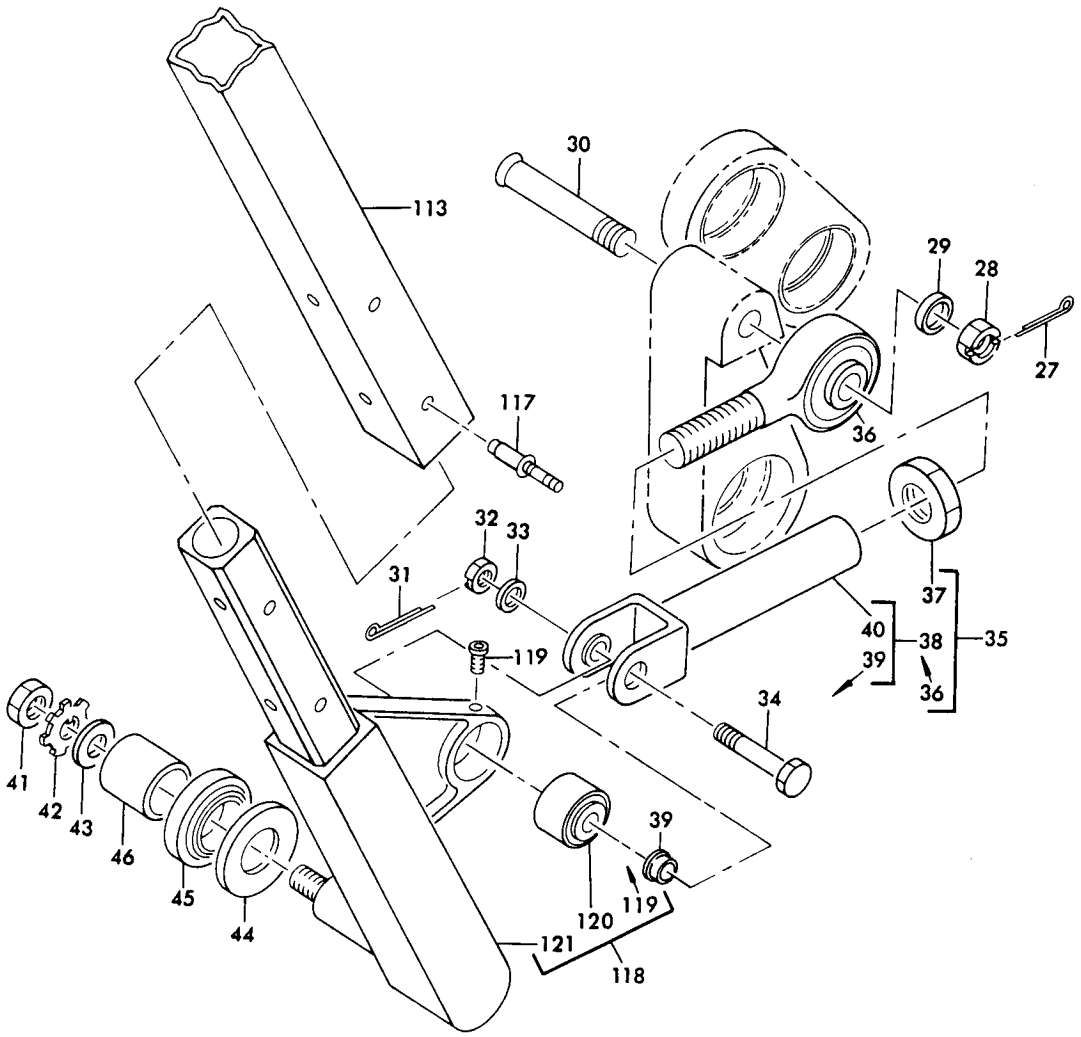
DETAIL A



Handrail Installation
Figure 1102 (Sheet 3)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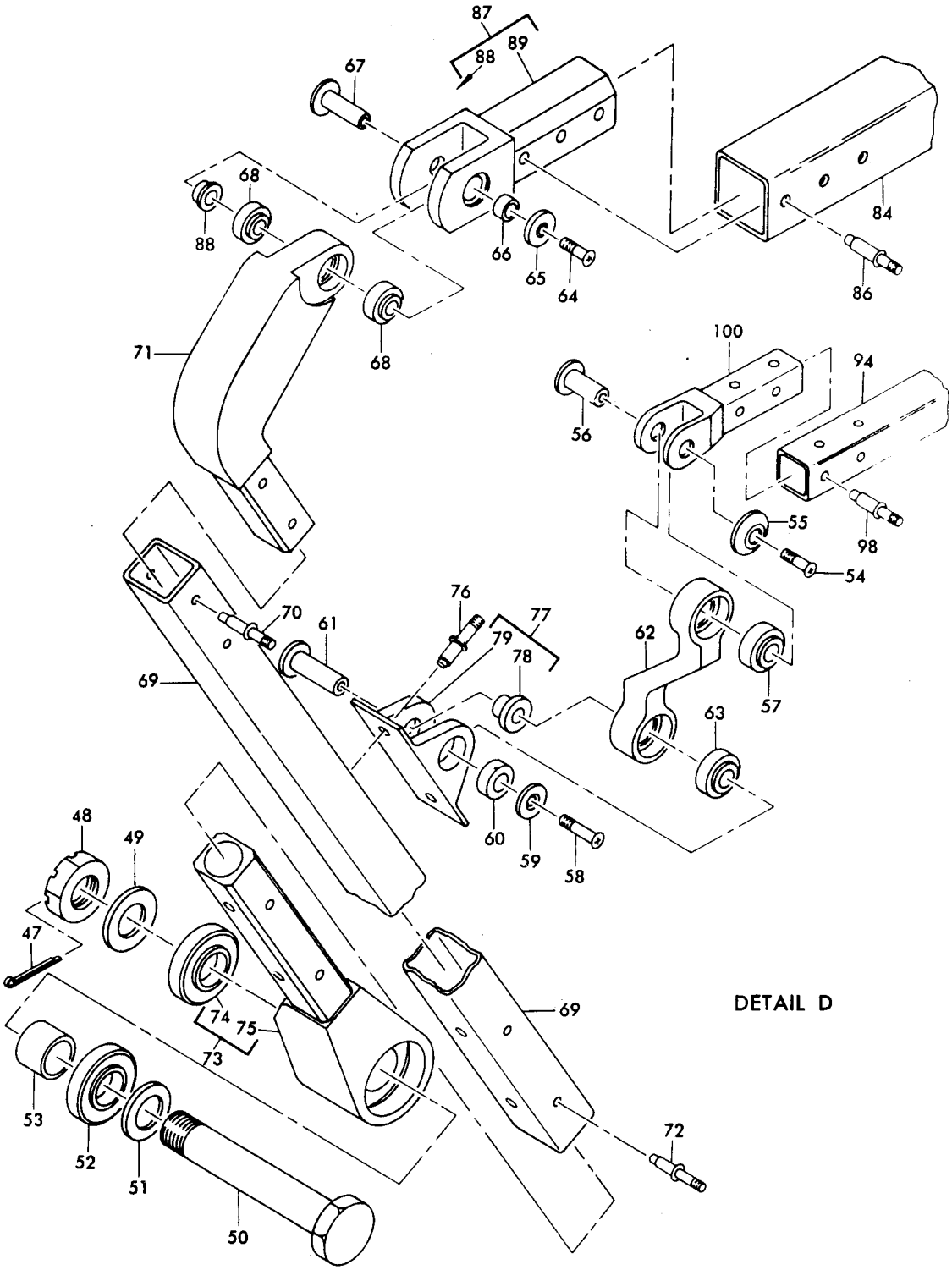
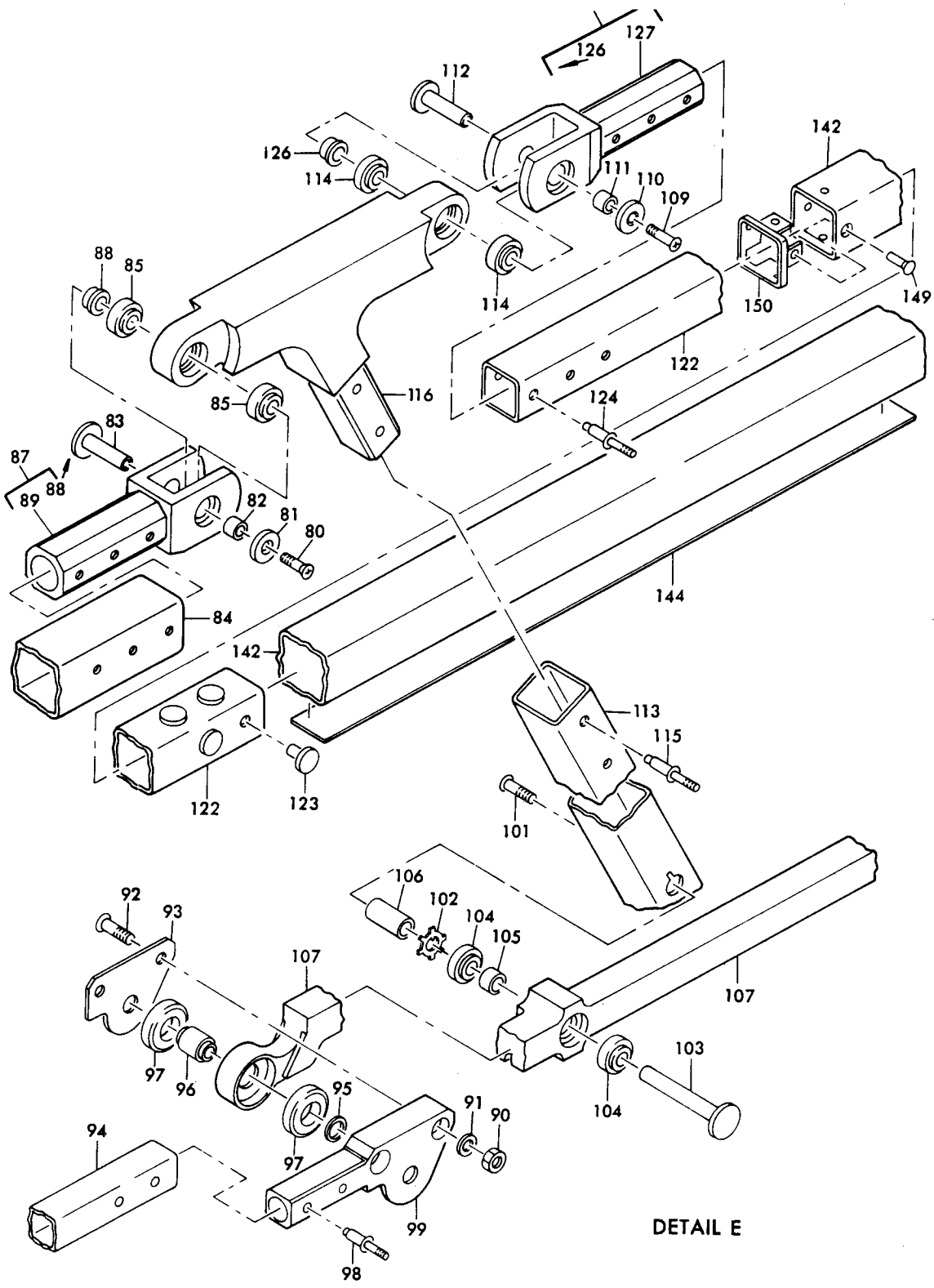
DETAIL C



Handrail Installation
Figure 1102 (Sheet 5)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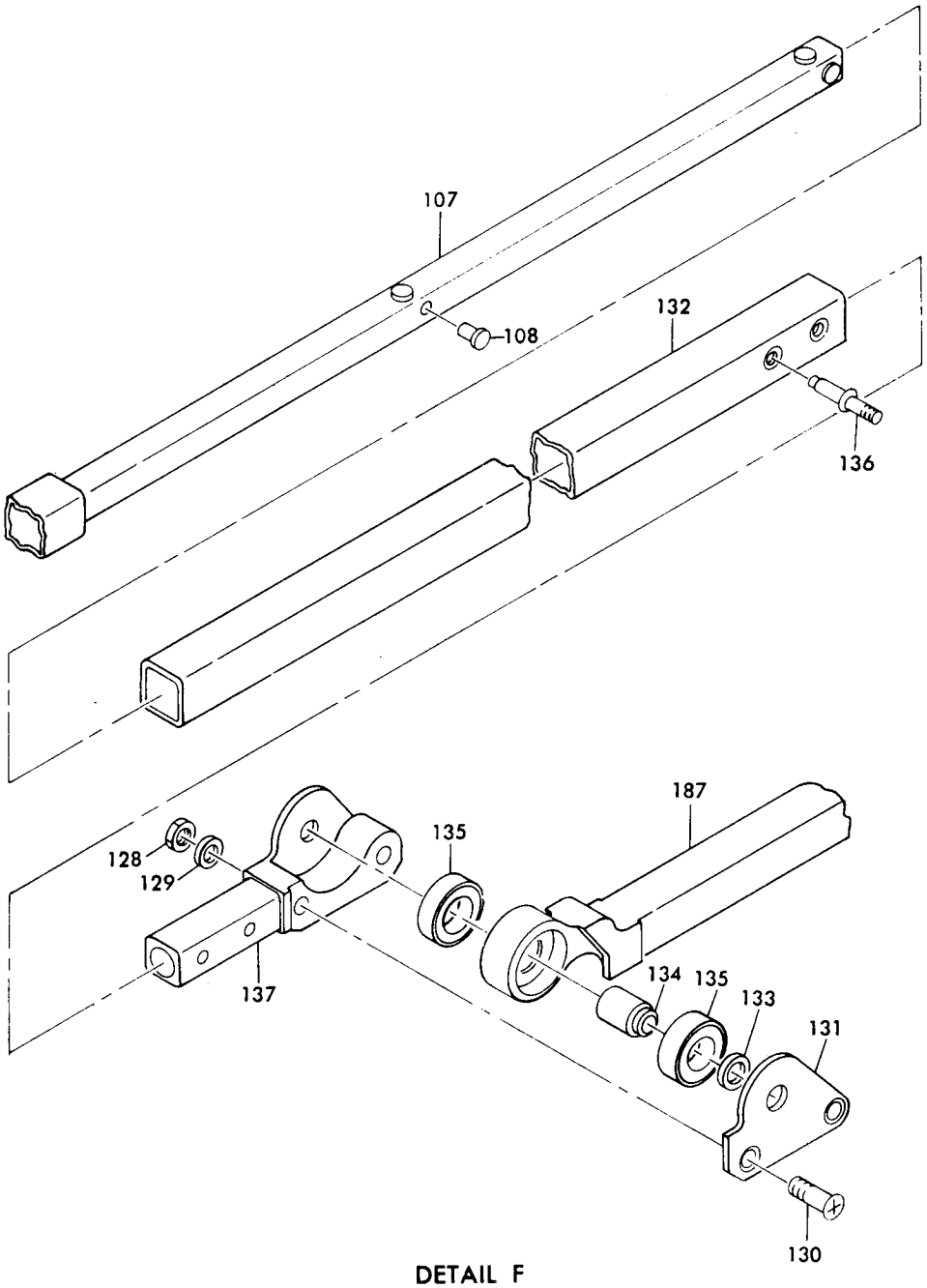
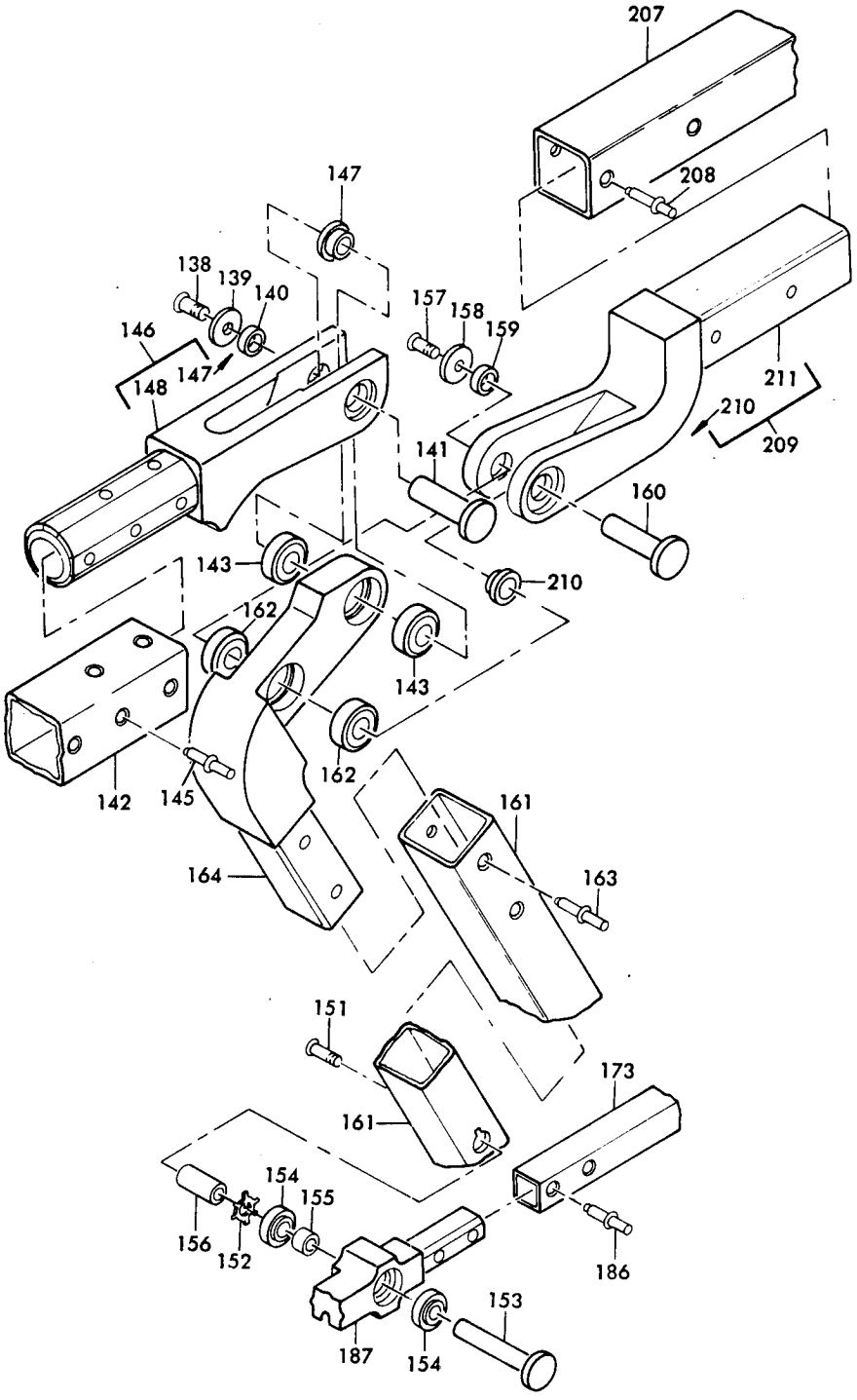
DETAIL E



DETAIL F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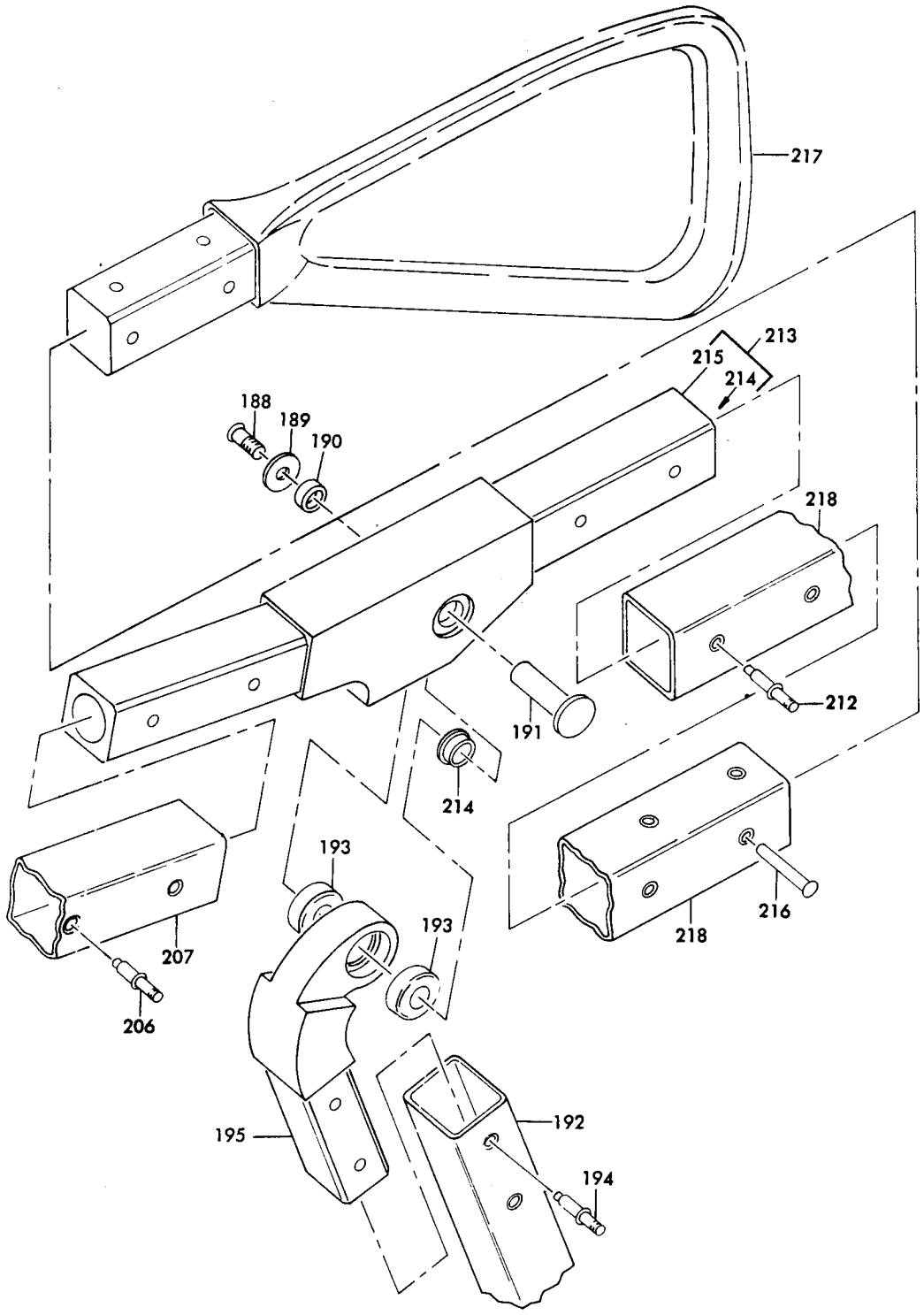
DETAIL G



DETAIL H

Handrail Installation
Figure 1102 (Sheet 9)

4. Group Assembly Parts List

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1102	65-58229-1		HANDRAIL INSTALLATION		
	65-58229-2		HANDRAIL INSTALLATION		
1	MS24665-360		. PIN, Cotter		1
2	BACN10NL16T		. NUT		1
3	AN960PD1616L		. WASHER		AR
4	69-46823-1		. BOLT		1
5	AN960-1616L		. WASHER		1
6	BACB10A686		. BEARING		1
7	NAS43HT16-66		. SPACER		1
8	MS24665-134		. PIN, Cotter		2
9	BACN10JD104		. NUT (replaces AN320-4)		2
9	AN320-4		. NUT		2
10	AN960-416		. WASHER		2
11	NAS1104-16D		. BOLT		2
12	69-46607-1		: TIE ROD ASSEMBLY, Inboard		1
13	69-46282-1		. . FITTING ASSEMBLY		1
14	BACB28X4B10		. . . BUSHING		2
15	69-46282-2		. . . FITTING		1
16	AN316-9		. . NUT		1
17	69-46281-1		. . TIE ROD ASSEMBLY		1
18	BACB28X4B10		. . . BUSHING		2
19	69-46281-2		. . . TIE ROD		1
20	69-48997-1		. CAP		1
21	BACN10JD6		. NUT (replaces NAS679A6)		1
21	NAS679A6		. NUT		1
22	MS27111-3		. WASHER, key		1
23	BACW10P254C		. WASHER		1
24	69-46819-3		. WASHER		1
25	BACB10A685		. BEARING		1
26	NAS43HT12-46		. SPACER		1
27	MS24665-287		. PIN, Cotter		1
28	BACN10JD106		. NUT (replaces AN320-6)		1
28	AN320-6		. NUT		1
29	AN960PD616		. WASHER (replaces AN960PD616L)		2
29	AN960PD616L		. WASHER		2
30	NAS1106-32D		. BOLT (replaces 69-47531-4)		1
30	69-47531-4		. BOLT		1
31	MS24665-134		. PIN, Cotter		1
32	BACN10JD104		. NUT (replaces AN320-4)		1
32	AN320-4		. NUT		1
33	AN960-416		. WASHER		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
34	NAS1104-16D		. BOLT.		1
35	69-46607-2		. TIE ROD ASSEMBLY, Outboard.		1
36	BACB10C59H		. . BEARING, Rod End		1
37	AN316-10		. . NUT		1
38	69-46280-1		. . ROD ASSEMBLY.		1
39	BACB28X4B10		. . . BUSHING		2
40	69-46280-2		. . . ROD		1
41	BACN10JC6		. NUT (replaces NAS679A6)		1
41	NAS679A6		. NUT		1
42	MS27111-3		. WASHER, Key		1
43	BACW10P254C		. WASHER.		1
44	69-46819-3		. WASHER.		1
45	BACB10A685		. BEARING		1
46	NAS43HT12-59		. SPACER.		1
47	MS24665-359		. PIN, Cotter		1
48	BACN10JD112		. NUT (replaces AN320-12)		1
48	AN320-12		. NUT		1
49	AN960-1216L		. WASHER.		1
50	NAS1112-57D		. BOLT.		1
51	MS20002C12		. WASHER.		1
52	BACB10A685		. BEARING		1
53	NAS43HT12-42		. SPACER.		1
54	BACB30EF3-2		. BOLT.		1
55	69-46819-2		. WASHER.		1
56	69-46827-3		. PIN		1
57	BACB10A543		. BEARING		2
58	BACB30EF3-2		. BOLT.		1
59	69-46819-1		. WASHER.		1
60	NAS76A6-008P		. BUSHING (replaces NAS43DD6-16). . .		1
60	NAS43DD6-16		. SPACER.		1
61	69-46827-2		. PIN		1
62	69-46826-1		. LINK.		1
63	BACB10A543		. BEARING		2
64	BACB30EF3-2		. BOLT.		1
65	69-46819-1		. WASHER.		1
66	NAS76A6-008P		. BUSHING (replaces NAS43DD6-16). . .		1
66	NAS43DD6-16		. SPACER		1
67	69-46827-2		. PIN		1
68	BACB10A543		. BEARING		2
69	65-58229-6		. STANCHION		1
70	B100EU6-4CD		. BOLT, V29666 (replaces BACB30LA6-4)		4
70	BACB30LA6-4		. BOLT		4

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
71	69-46810-2		. FITTING, Upper (replaces 65-46810-1).		1
71	69-46810-1		. FITTING, Upper (replaced by 69-46810-2).		1
72	B100EU8-4CD		. BOLT, V29666 (replaces BACB30LA8-4)		8
72	BACB30LA8-4		. BOLT		8
73	69-46812-1		. FITTING ASSEMBLY.		1
74	BACB10A685		. . BEARING		1
75	69-46812-2		. . FITTING		1
76	NAS1398D6-4		. RIVET		2
77	69-46811-1		. MID FITTING ASSEMBLY.		1
78	BACB28X6B12		. . BUSHING		1
79	69-46811-2		. . FITTING		1
80	BACB30EF3-2		. BOLT.		1
81	69-46819-1		. WASHER.		1
82	NAS76A6-008P		. BUSHING (replaces NAS43DD6-16). . .		1
82	NAS43DD6-16		. SPACER		1
83	69-46827-2		. PIN		1
84	65-58229-11		. HANDRAIL.		1
85	BACB10A543		. BEARING		2
86	B100EU6-3CD		. BOLT, V29666 (replaces BACB30LA6-3)		16
86	BACB30LA6-3		. BOLT		16
87	69-46818-3		. FITTING ASSEMBLY (replaces 69-46818-1).		2
87	69-46818-1		. FITTING ASSEMBLY (replaced by 69-46818-3).		2
88	BACB28X6B12		. . BUSHING		1
89	69-46818-4		. . FITTING		1
90	BACN10JC3		. NUT (replaces NAS679A3W).		2
90	NAS679A3W		. NUT		2
91	AN960-10		. WASHER.		2
92	BACB30LU3-14		. BOLT (replaces BACB30LU3-7)		2
92	BACB30LU3-7		. BOLT		2
93	69-46813-1		. FITTING, Plate.	a	1
93	69-46813-2		. FITTING, Plate.	b	1
94	65-58229-14		. GUARDRAIL		1
95	BACW10P237S		. WASHER.		1
96	69-46828-1		. PIN		1
97	BACB10A27DD		. BEARING		2
98	B100EU5-2CD		. BOLT, V29666 (replaces BACB30LA5-2)		8
98	BACB30LA5-2		. BOLT		8
99	69-46822-1		. FITTING	a	1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
99	69-46822-2		. FITTING	b	1
100	69-46825-1		. FITTING		1
101	BACB30EF3-2		. BOLT		1
102	MS27111-3		. WASHER, Key		1
103	69-46827-1		. PIN		1
104	BACB10A543		. BEARING		2
105	NAS43DD6-16		. SPACER		1
106	NAS75-6-107		. BUSHING		1
107	65-59607-1		. SLIDE, Inner	a	1
107	65-59607-2		. SLIDE, Inner	b	1
108	69-48996-2		. PAD, Slide		8
109	BACB30EF3-2		. BOLT		1
110	69-46819-1		. WASHER		1
111	NAS76A6-008P		. BUSHING (replaces NAS43DD6-16)		1
111	NAS43DD6-16		. SPACER		1
112	69-46827-2		. PIN		1
113	65-58229-5		. STANCHION		1
114	BACB10A543		. BEARING		2
115	B100EU6-4CD		. BOLT, V29666 (replaces BACB30LA6-4)		4
115	BACB30LA6-4		. BOLT		4
116	69-46808-2		. FITTING (replaces 69-46808-1)		1
116	69-46808-1		. FITTING		1
117	B100EU8-4		. BOLT, V29666 (replaces BACB30LA8-4)		8
117	BACB30LA8-4		. BOLT		8
118	69-46809-1		. FITTING ASSEMBLY	a	1
118	69-46809-2		. FITTING ASSEMBLY	b	1
119	NAS516-1		. . FITTING, Lubrication		1
120	BACB10C134		. . BEARING		1
121	69-46809-3		. . FITTING (used on 69-46809-1)		1
121	69-46809-4		. . FITTING (used on 69-46809-2)		1
122	65-58229-15		. HANDRAIL (replaces 65-58229-10)		1
122	65-58229-10		. HANDRAIL		1
123	69-48996-3		. PAD, Slide (replaces 69-48996-1)		4
123	69-48996-1		. PAD, Slide		4
124	B100EU6-2CD		. BOLT, V29666 (replaces BACB30LA6-2)		8
124	BACB30LA6-2		. BOLT		8
125	69-46817-3		. FITTING ASSEMBLY (replaces 69-46817-1)		1
125	69-46817-1		. FITTING ASSEMBLY (replaced by 69-46817-3)		1
126	BACB28X6B12		. . BUSHING		1
127	69-46817-4		. . FITTING (replaces 69-46817-2)		1
127	69-46817-2		. . FITTING		1
128	BACN10JC3		. NUT (replaces NAS679A3W)		2
128	NAS679A3W		. NUT		2

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
129	AN960-10		. WASHER.		2
130	BACB30LU3-14		. BOLT (replaces BACB30LU3-7)		2
130	BACB30LU3-7		. BOLT		2
131	69-46813-1		. FITTING, Plate.		1
131	69-46813-2		. FITTING, Plate.		1
132	65-58229-13		. GUARDRAIL		1
133	BACW10P237S		. WASHER.		1
134	69-46828-1		. PIN		1
135	BACB10A27DD		. BEARING		2
136	B100EU5-2CD		. BOLT, V29666 (replaces BACB30LA5-2)		4
136	BACB30LA5-2		. BOLT		4
137	69-46822-1		. FITTING	a	1
137	69-46822-2		. FITTING	b	1
138	BACB30EF3-2		. BOLT.		1
139	69-46819-1		. WASHER.		1
140	NAS76A6-008P		. BUSHING (replaces NAS43DD6-16). . .		1
140	NAS43DD6-16		. SPACER		1
141	69-46827-2		. PIN		1
142	65-58229-9		. HANDRAIL.		1
143	BACB10A543		. BEARING		2
144	65-58229-16		. RUB STRIP		1
145	B100EU6-3CD		. BOLT, V29666 (replaces BACB30LA6-3)		8
145	BACB30LA6-3		. BOLT		8
146	69-46816-1		. FITTING ASSEMBLY.		1
147	BACB28X6B12		. . BUSHING		1
148	69-46816-2		. . FITTING		1
149	MS20426D3		. RIVET		4
150	69-54383-1		. GUIDE		1
151	BACB30EF3-2		. BOLT.		1
152	MS27111-3		. WASHER, Key		1
153	69-46827-1		. PIN		1
154	BACB10A543		. BEARING		2
155	NAS43DD6-16		. SPACER.		1
156	NAS75-6-107		. BUSHING		1
157	BACB30EF3-2		. BOLT.		1
158	69-46819-1		. WASHER.		1
159	NAS76A6-008P		. BUSHING (replaces NAS43DD6-16). . .		1
159	NAS43DD6-16		. SPACER		1
160	69-46827-2		. PIN		1
161	65-58229-4		. STANCHION		1
162	BACB10A543		. BEARING		2
163	B100EU6-4CD		. BOLT, V29666 (replaces BACB30LA6-4)		4

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
163	BACB30LA6-4		. BOLT		4
164	69-46806-1		. FITTING		1
165	B100EU8-4CD		. BOLT, V29666 (replaces BACB30LA8-4)		8
165	BACB30LA8-4		. BOLT		8
166	69-46807-1		. FITTING ASSEMBLY.	a	1
166	69-46807-2		. FITTING ASSEMBLY.	b	1
167	NAS516-1		. . FITTING, Lubrication.		1
168	BACB10C134		. . BEARING		1
169	69-46807-3		. . FITTING (used on 69-46807-1). . .		1
169	69-46807-4		. . FITTING (used on 69-46807-2). . .		1
170	BACB30EF3-2		. BOLT.		1
171	MS27111-3		. WASHER, Key		1
172	69-46827-1		. PIN		1
173	65-58229-12		. GUARDRAIL		1
174	BACB10A543		. BEARING		2
175	NAS43DD6-16		. SPACER.		1
176	NAS75-6-107		. BUSHING		1
177	BACN10JC3		. NUT (replaces NAS679A3W).		1
177	NAS679A3W		. NUT		1
178	AN960-10L		. WASHER.		1
179	BACB30LU3-9		. BOLT.		1
180	69-46824-1		. LINK ASSEMBLY	a	1
180	69-46824-2		. LINK ASSEMBLY	b	1
181	BACB28W5B21		. . BUSHING (replaces BACB28X3B23). .		1
181	BACB28X3B23		. . BUSHING		1
182	69-46824-3		. . LINK (used on 69-46824-1) . . .		1
182	69-46824-4		. . LINK (used on 69-46824-2) . . .		1
183	NAS76A3-10		. BUSHING		1
184	B100EU5-2CD		. BOLT, V29666 (replaces BACB30LA5-2)		4
184	BACB30LA5-2		. BOLT		4
185	69-46820-1		. FITTING	a	1
185	69-46820-2		. FITTING	b	1
186	B100EU5-2CD		. BOLT, V29666 (replaces BACB30LA5-2)		4
186	BACB30LA5-2		. BOLT		4
187	69-46821-1		. FITTING	a	1
187	69-46821-2		. FITTING	b	1
188	BACB30EF3-2		. BOLT.		1
189	69-46819-1		. WASHER.		1
190	NAS76A6-008P		. BUSHING (replaces NAS43DD6-16). . .		1
190	NAS43DD6-16		. SPACER		1
191	69-46827-2		. PIN		1

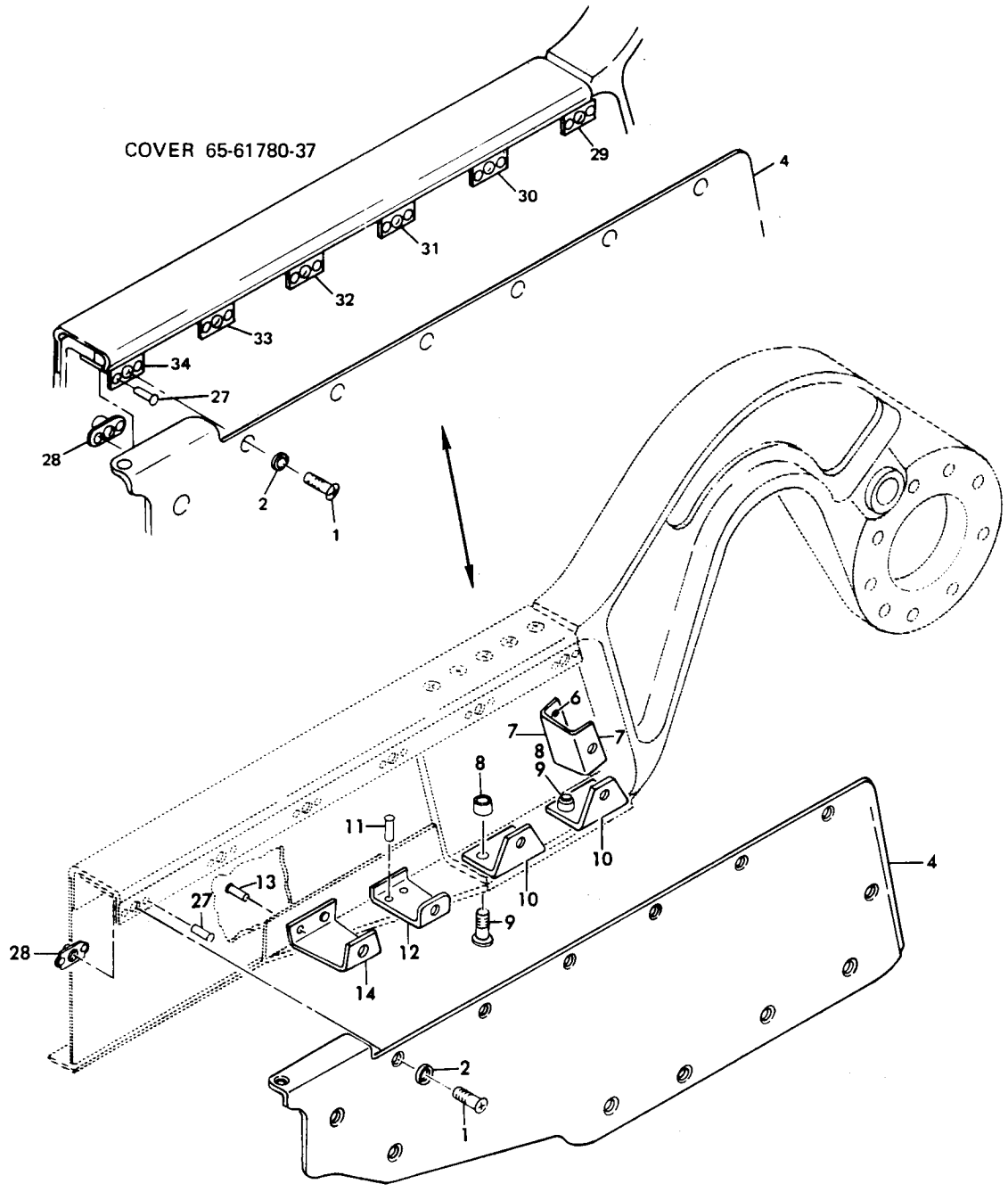
FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
192	65-58229-3		. STANCHION		1
193	BACB10A543		. BEARING		2
194	B100EU6-4CD		. BOLT, V29666 (replaces BACB30LA6-4)		4
194	BACB30LA6-4		. BOLT		4
195	69-46804-1		. FITTING		1
196	BACN10JC3		. NUT (replaces NAS679A3W).		2
196	NAS679A3W		. NUT		2
197	AN960-10		. WASHER.		2
198	BACW10P42S		. WASHER.		4
199	NAS1103-35		. BOLT.		2
200	NAS43HT3-38		. SPACER.		2
201	69-48995-1		. BUMPER.		1
202	B100EU8-4CD		. BOLT, V29666 (replaces BACB30LA8-4)		8
202	BACB30LA8-4		. BOLT		8
203	69-46805-1		. FITTING ASSEMBLY.		1
204	BACB10A686		. . BEARING		1
205	69-46805-2		. . FITTING		1
206	B100EU8-4CD		. BOLT, V29666 (replaces BACB30LA8-4)		6
206	BACB30LA8-4		. BOLT		6
207	65-58229-8		. HANDRAIL.		1
208	B100EU8-4CD		. BOLT, V29666 (replaces BACB30LA8-4)		4
208	BACB30LA8-4		. BOLT		4
209	69-46815-1		. FITTING ASSEMBLY.		1
210	BACB28X6B12		. . BUSHING		1
211	69-46815-2		. . FITTING		1
212	B100EU8-4CD		. BOLT, V29666 (replaces BACB30LA8-4)		6
212	BACB30LA8-4		. BOLT		6
213	69-46814-1		. MID FITTING ASSEMBLY.		1
214	BACB28X6B12		. . BUSHING		1
215	69-46814-2		. . FITTING		1
216	MS20426D8		. RIVET (replaces BACR15BA8).		4
216	BACR15BA8		. RIVET		4
217	65-59606-1		. HANDLE, handrail.		1
218	65-58229-7		. HANDRAIL.		1

a used on 65-58229-1
b used on 65-58229-2

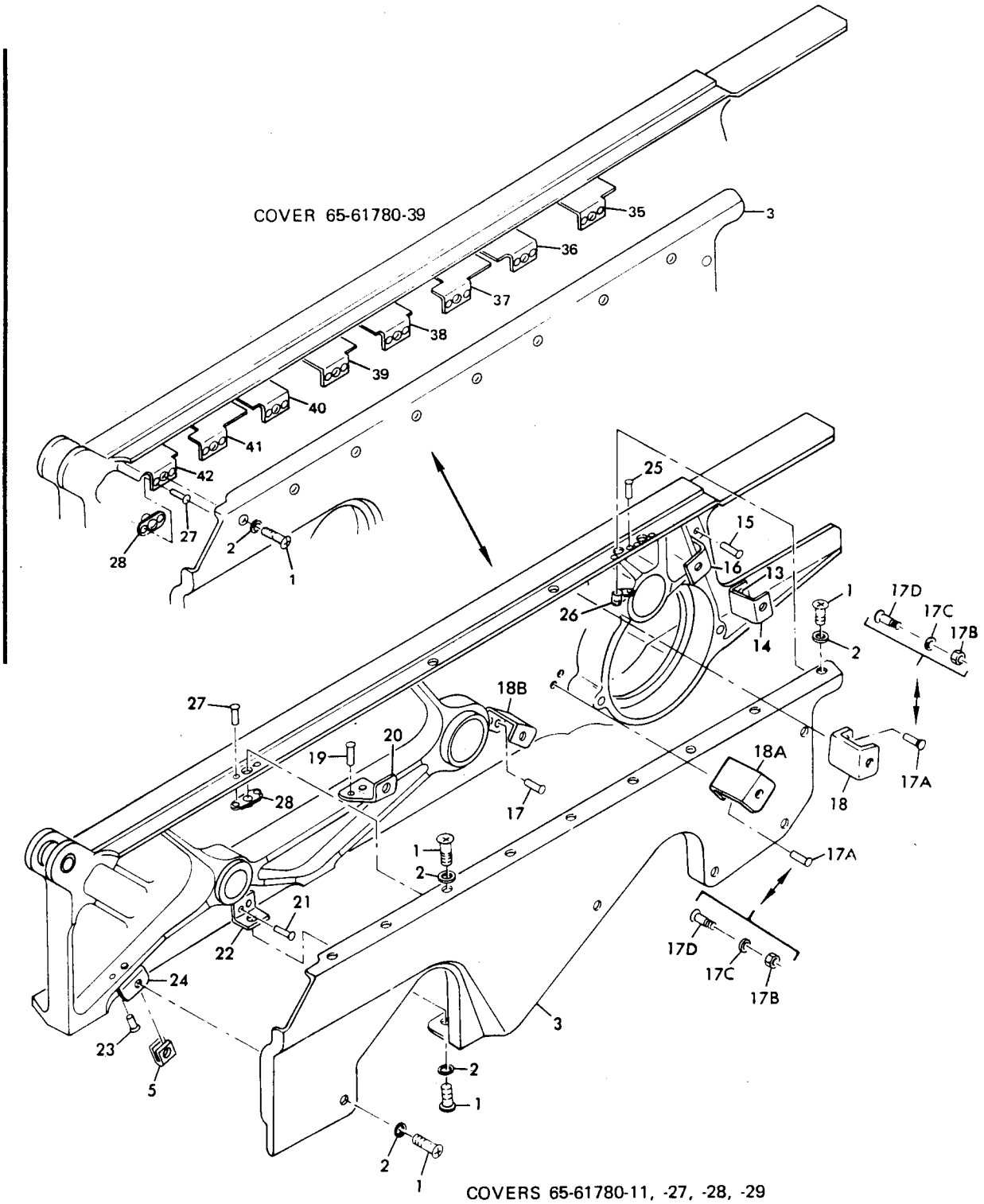
VENDOR CODE

Code	Name and Address
V29666	Huck Manufacturing Co. 2500 Bellevue Ave. Detroit, Michigan 48207

5. Exploded View



COVERS 65-61780-13, -14



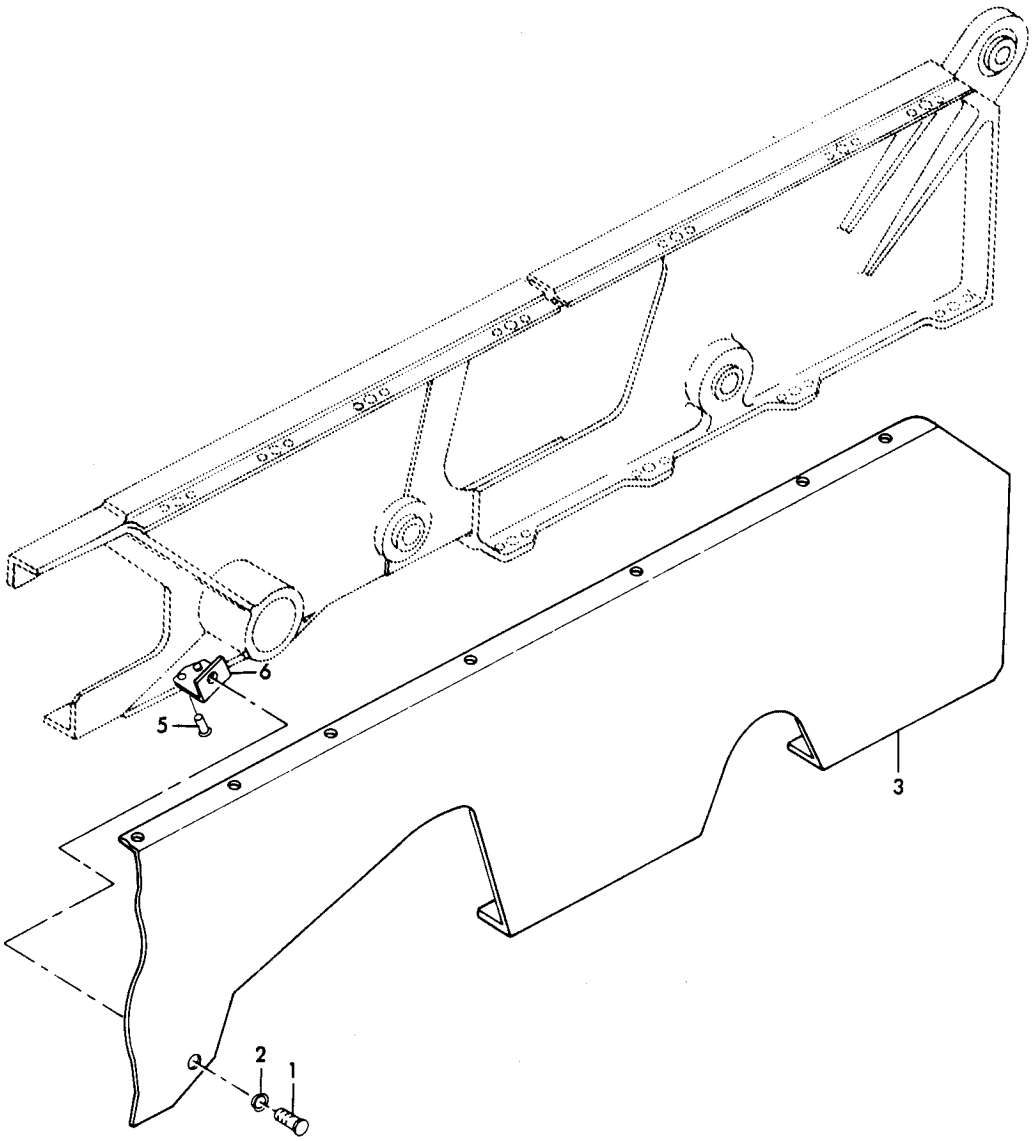
Upper Cover Installation
Figure 1103 (Sheet 2)

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1103					
	65-61780-5		UPPER COVER INSTL, AFT SIDE	A	RF
	65-61780-6		UPPER COVER INSTL, FWD SIDE	B	RF
1	BACB30LU2-2		. BOLT *[2]		29
1	BACB30LU2-2		. BOLT *[3]		27
2	BACW10U-D8		. WASHER *[2]		29
2	BACW10U-D8		. WASHER *[3]		27
3	65-61780-11		. COVER *[1]	A	1
3	65-61780-28		. COVER (REPLS 65-61780-11)(SB 24-1016)*[1]	A	
3	65-61780-29		. COVER (REPLS 65-61780-11 or -28) (SB 52-1035)*[1]	A	
3	65-61780-39		. COVER (REPLS 65-61780-11,-28 or -29) (SB 52-1067)	A	1
3	65-61780-27		. COVER *[1]	B	1
3	65-61780-40		. COVER (REPLS 65-61780-27) (SB52-1067)	B	1
4	65-61780-13		. COVER *[1]	A	1
4	65-61780-37		. COVER *[1]	A	1
4	65-61780-14		. COVER *[1]	B	1
4	65-61780-38		. COVER *[1]	B	1
5	BACN10FX81		. NUT, CLIP		13
6	BACR15BB5D		. RIVET (REPLS MS20470D5)		2
7	69-49788-2		. CLIP		1
8	BACC30K8		. COLLAR		4
9	BACB30GW8		. LOCKBOLT		4
10	69-49789-1		. CLIP		2
11	BACCR15BB5D		. RIVET (REPLS MS20470D5)		2
12	69-49788-3		. CLIP	A	1
12	69-49788-4		. CLIP	B	1
13	BACR15BB5D		. RIVET (REPLS MS20470D5)		4
14	69-49788-2		. CLIP		2
15	BACR15BB5D		. RIVET (REPLS MS20470D5)		2
16	69-49788-1		. CLIP		1
17	BACR15BB5D		. RIVET (REPLS MS20470D5)		2
17A	BACR15BB5D		. RIVET (REPLS MS20470D5)*[1]		4
17B	BACN10JC3		. NUT (SB 52-1045)		4
17C	AN960PD10		. WASHER (SB 52-1045)		4
17D	BACB30LL3-6		. BOLT (SB 52-1045)*[1]		4
17D	BACB30LL3-8		. BOLT (SB 52-1045)*[1]		4
18	69-49787-4		. CLIP		1
18A	69-49787-4		. CLIP *[1]	A	1
18A	69-49787-6		. CLIP (REPLS 69-49787-4)	A	1
18A	69-49787-4		. CLIP	B	1
18B	69-49787-4		. CLIP *[1]		1

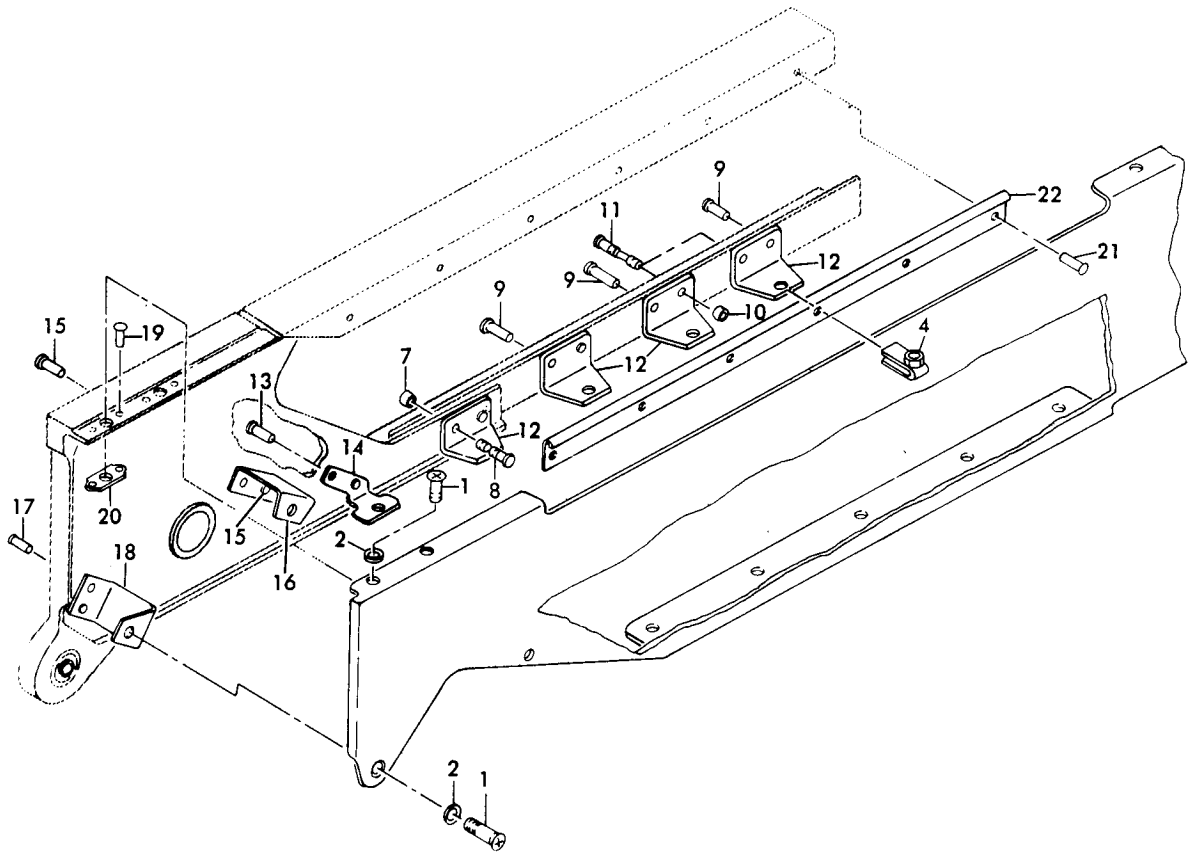
FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1103					
18B	69-49787-6		. CLIP (REPLS 69-49787-4)		1
19	BACR15BB5D		. RIVET (REPLS MS20470D5)		2
20	69-49787-1		. CLIP	A	1
20	69-49787-2		. CLIP	B	1
21	BACR15BB5D		. RIVET (REPLS MS20470D5)		2
22	69-49787-5		. CLIP		1
23	BACR15BB5D		. RIVET (REPLS MS20470D5)		2
24	69-49787-3		. CLIP		1
25	BACR15BA3D		. RIVET (REPLS MS20426D3)*[2]		4
26	NAS684A08		. NUTPLATE *[2]		2
27	BACR15BA3D		. RIVET (REPLS MS20426D3)		28
28	BACN10JR08F		. NUTPLATE		14
29	65-61780-31		. CLIP *[3]	A	1
29	65-61780-32		. CLIP *[3]	B	1
30	65-61780-33		. CLIP *[3]	A	1
30	65-61780-34		. CLIP *[3]	B	1
31	69-68808-3		. CLIP *[3]	A	1
31	69-68808-4		. CLIP *[3]	B	1
32	65-61780-41		. CLIP *[3]	A	1
32	65-61780-42		. CLIP *[3]	B	1
33	65-61780-43		. CLIP *[3]	A	1
33	65-61780-44		. CLIP *[3]	B	1
34	65-61780-45		. CLIP *[3]	A	1
34	65-61780-46		. CLIP *[3]	B	1
35	65-61780-47		. CLIP *[3]	A	1
35	65-61780-48		. CLIP *[3]	B	1
36	65-61780-45		. CLIP *[3]	A	1
36	65-61780-50		. CLIP *[3]	B	1
37	65-61780-51		DELETED		
37	65-61780-52		DELETED		
37	65-61780-63		. CLIP *[3]	A	1
37	65-61780-64		. CLIP *[3]	B	1
38	65-61780-53		. CLIP *[3]	A	1
38	65-61780-54		. CLIP *[3]	B	1
39	65-61780-55		. CLIP *[3]	A	1
39	65-61780-56		. CLIP *[3]	B	1
40	65-61780-57		. CLIP *[3]	A	1
40	65-61780-58		. CLIP *[3]	B	1
41	65-61780-59		DELETED		
41	65-61780-60		DELETED		
41	65-61780-61		. CLIP *[3]	A	1
41	65-61780-62		. CLIP *[3]	B	1
42	69-68808-1		DELETED		
42	69-68808-2		. CLIP *[3]	B	1

*[1] LIMITED USE
*[2] USED WITH COVERS 65-61780-11,-13,-14,-27,-28,-29
*[3] USED WITH COVERS 65-61780-37,-38,-39,-40

7. Exploded View



Center Cover Installation
Figure 1104 (Sheet 1)



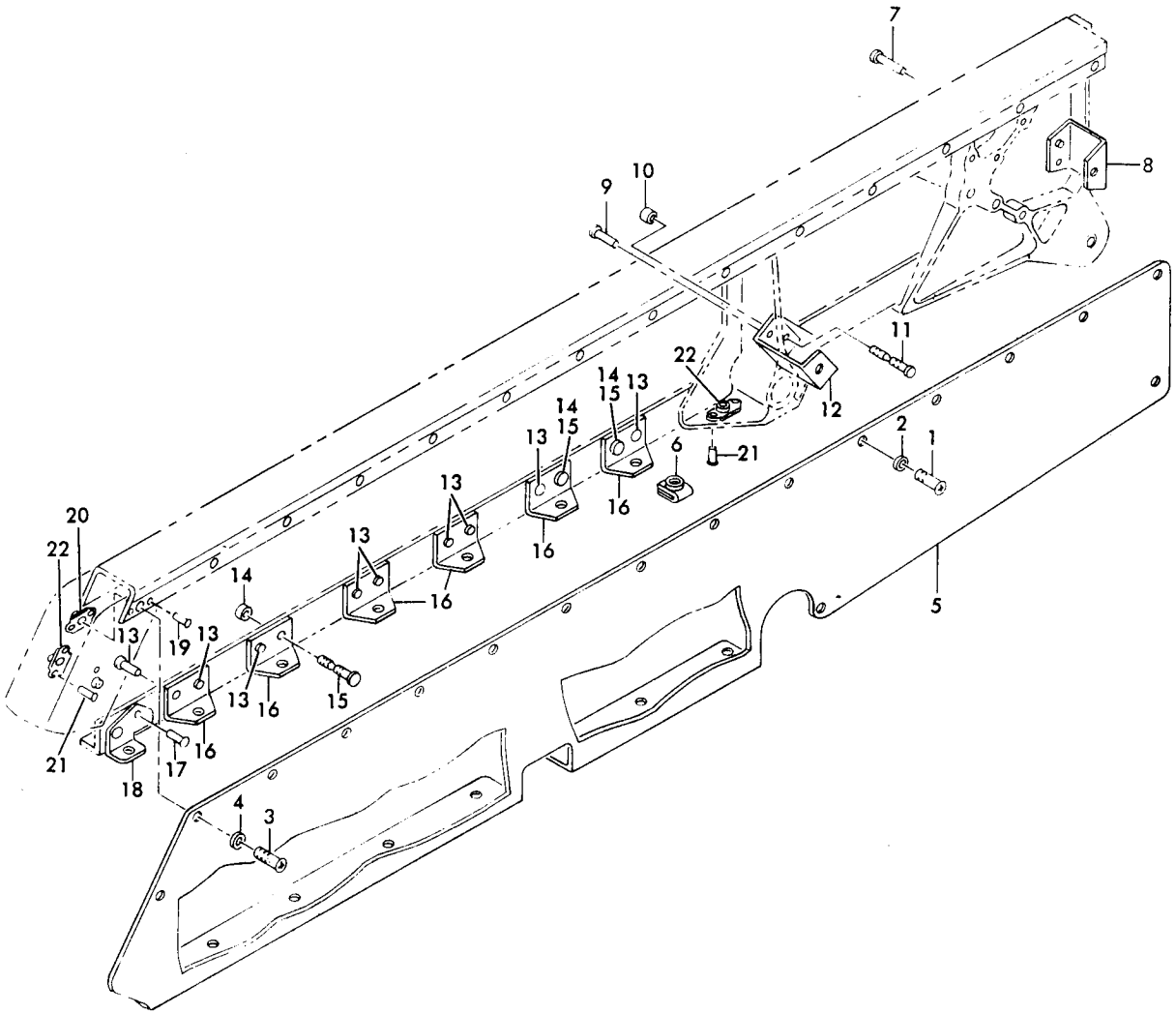
Center Cover Installation
Figure 1104 (Sheet 2)

8. Group Assembly Parts List

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1104	65-61780-3		CENTER COVER INSTALLATION		
	65-61780-4		CENTER COVER INSTALLATION		
1	BACB30LU2-2		. BOLT.		21
2	BACW10UD8		. WASHER.		21
3	65-61780-25		. COVER	a	1
3	65-61780-26		. COVER	b	1
4	BACN10FX81		. NUT, Clip		2
5	MS20470D5		. RIVET		2
6	69-50392-1		. CLIP.	a	1
6	69-50392-2		. CLIP.	b	1
7	BACC30K6		. COLLAR.		2
8	BACB30GW6-5		. LOCKBOLT.		2
9	MS20470D5		. RIVET		4
10	NAS1080-6		. COLLAR.		2
11	BACB30DX6-4		. LOCKBOLT.		2
12	69-49789-1		. CLIP.		4
13	MS20470D5		. RIVET		2
14	69-50392-3		. CLIP.	a	1
14	69-50392-4		. CLIP.	b	1
15	MS20470D5		. RIVET		2
16	69-50392-5		. CLIP.	a	1
16	69-50392-6		. CLIP.	b	1
17	BACR15CE5D		. RIVET		2
18	69-50392-9		. CLIP.	a	1
18	69-50392-8		. CLIP.	b	1
19	MS20426D3		. RIVET		26
20	BACN10JR08F		. NUTPLATE.		13
21	MS20426D3		. RIVET		6
22	65-61780-24		. CHANNEL		1

a used on 65-61780-3
b used on 65-61780-4

9. Exploded View



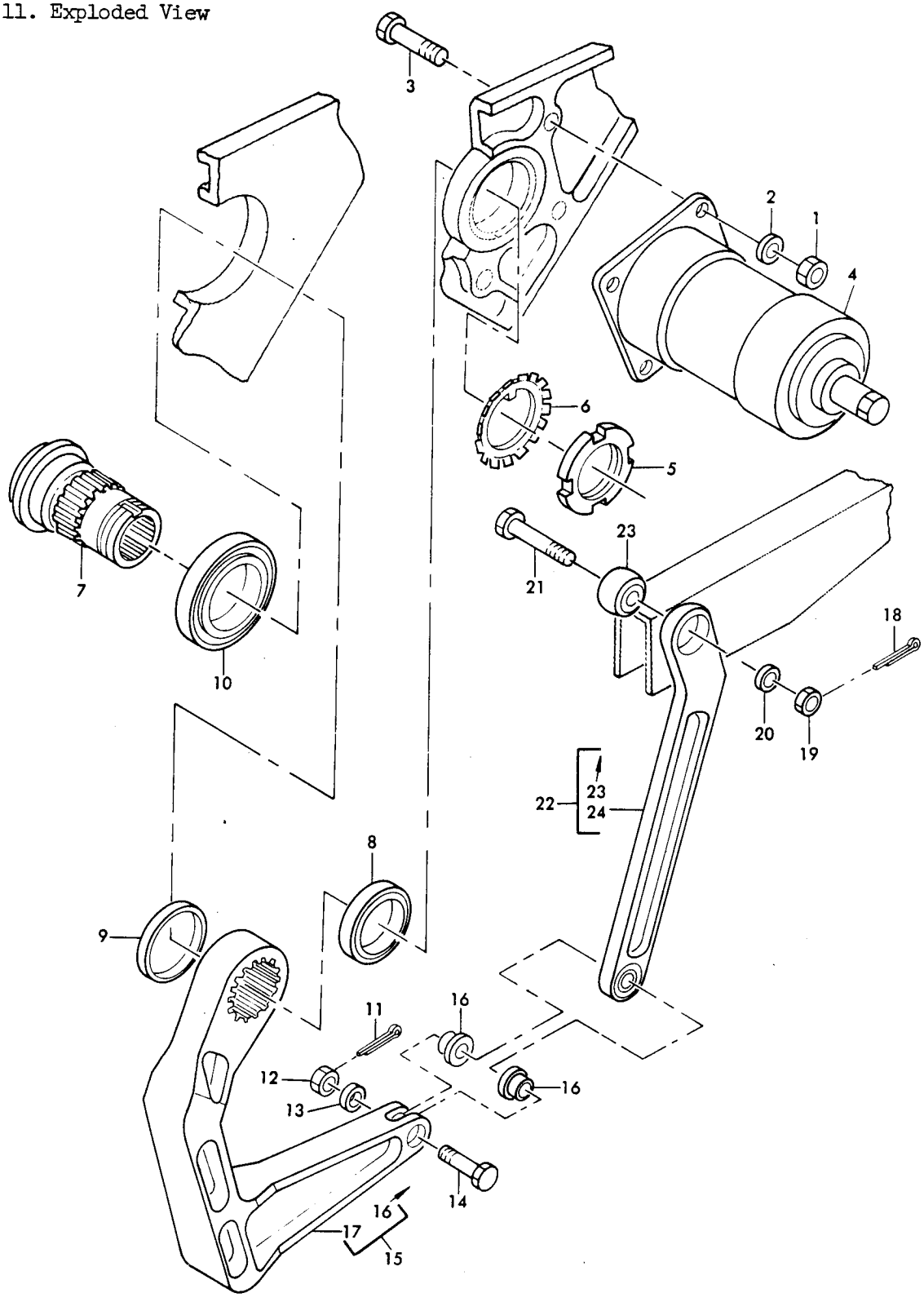
Lower Cover Installation
Figure 1105

10. Group Assembly Parts List

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1105	65-61780-1		LOWER COVER INSTALLATION		
	65-61780-2		LOWER COVER INSTALLATION		
1	BACB30LU2-2		. BOLT.		24
2	BACW10U-D8		. WASHER.		24
3	BACB30LU3-4		. BOLT.		1
4	BACW10U-D10		. WASHER.		1
5	65-61780-7		. COVER	a	1
5	65-61780-8		. COVER	b	1
6	BACN10FX81		. NUT, Clip		22
7	MS20470D6		. RIVET		2
8	69-49789-2		. CLIP.		1
9	MS20470D6		. RIVET		1
10	BACC30K6		. COLLAR.		1
11	BACB30GW6-4		. LOCKBOLT.		1
12	69-49788-5		. CLIP.	a	1
12	69-49788-6		. CLIP.	b	1
13	MS20470D5		. RIVET		9
14	BACC30K6		. COLLAR.		3
15	BACB30GW6-4		. LOCKBOLT.		3
16	69-49789-1		. CLIP.		6
17	MS20470D6		. RIVET		2
18	69-49789-3		. CLIP.	a	1
18	69-49789-4		. CLIP.	b	1
19	MS20426D3		. RIVET		2
20	BACN10JR3F		. NUTPLATE.		1
21	MS20426D3		. RIVET		4
22	BACN10JR08F		. NUTPLATE.		2

a used on 65-61780-1
b used on 65-61780-2

11. Exploded View



Damper Installation
Figure 1106

12. Group Assembly Parts List

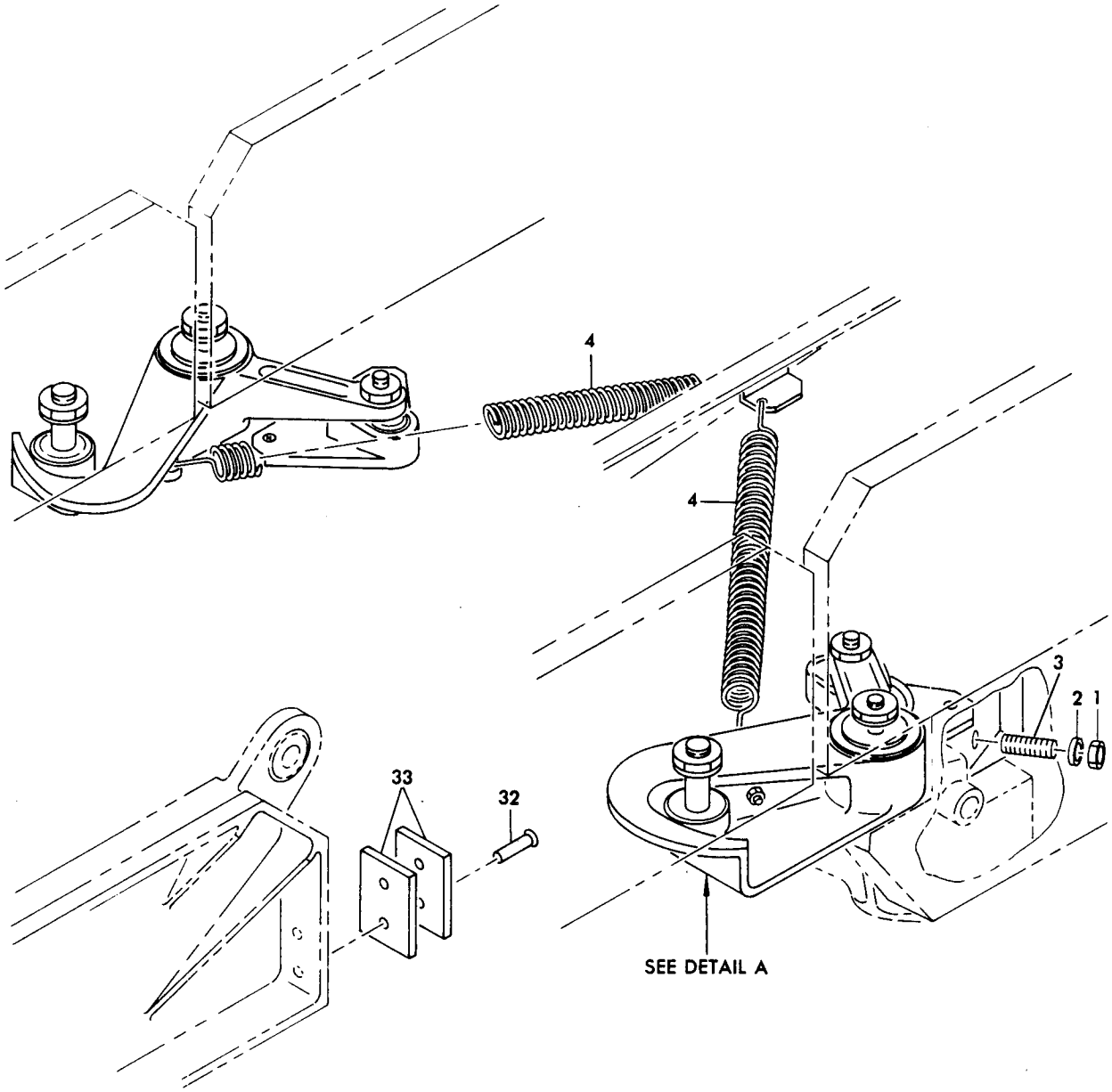
FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1106	65-68950-2		DAMPER INSTALLATION		
	65-68950-1		DAMPER INSTALLATION		
1	BACN10JC4		. NUT (replaces NAS679A4W).		1
1	NAS679A4W		. NUT		1
2	AN960PD416		. WASHER.		1
3	NAS1104-11		. BOLT.		1
4	HP1017100-3		. DAMPER, V84685 (Boeing 10-61237-2).	a	1
4	HP1017100-2		. DAMPER, V84685 (Boeing 10-61237-1).	b	1
5	MS19068-092		. NUT		1
6	MS19070-092		. WASHER.		1
7	65-68953-2		. SHAFT (preferred)		1
7	65-68953-1		. SHAFT (optional to 65-68953-2). . .		1
8	69-55164-2		. SPACER.		1
9	69-55164-1		. SPACER.		1
10	BACB10A832		. BEARING		1
11	MS24665-134		. PIN, Cotter		1
12	BACN10JD105		. NUT (replaces AN320-5).		1
12	AN320-5		. NUT		1
13	AN960PD516		. WASHER.		1
14	NAS1105-16D		. BOLT.		1
15	65-68952-1		. CRANK ASSEMBLY.		1
16	BACB28W5B15		. . BUSHING		2
17	65-68952-2		. . CRANK		1
18	MS24665-134		. PIN, Cotter		1
19	BACN10JD105		. NUT (replaces AN320-5).		1
19	AN320-5		. NUT		1
20	AN960PD516		. WASHER.		1
21	NAS1105-15D		. BOLT.		1
22	65-68951-1		. LINK ASSEMBLY		1
23	BACB10AC5		. . BEARING		1
24	65-68951-2		. . LINK.		1

a used with 65-68950-2
b used with 65-68950-1

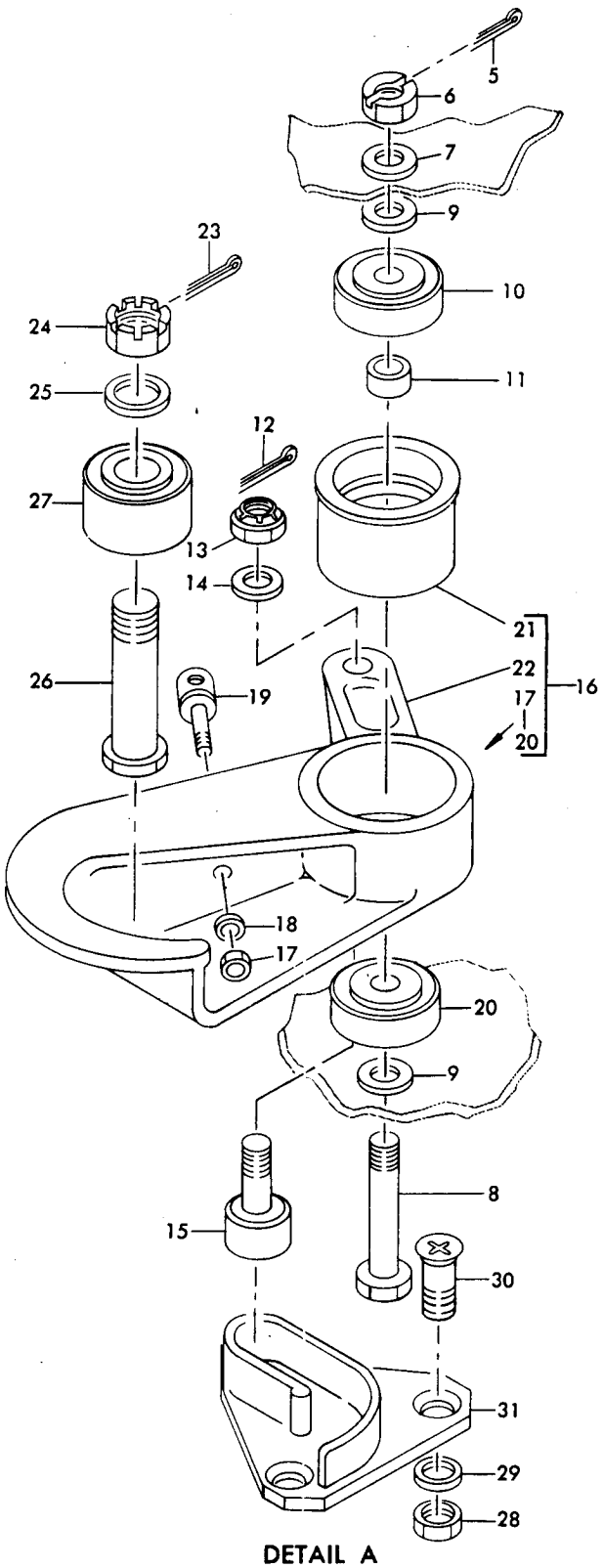
VENDOR CODE

Code	Name and Address
V84685	Hydra-Power Corp. 310 Main St. New Rochelle, New York 10801

13. Exploded View



Segment Lock Installation
Figure 1107 (Sheet 1)



DETAIL A

Segment Lock Installation
Figure 1107 (Sheet 2)

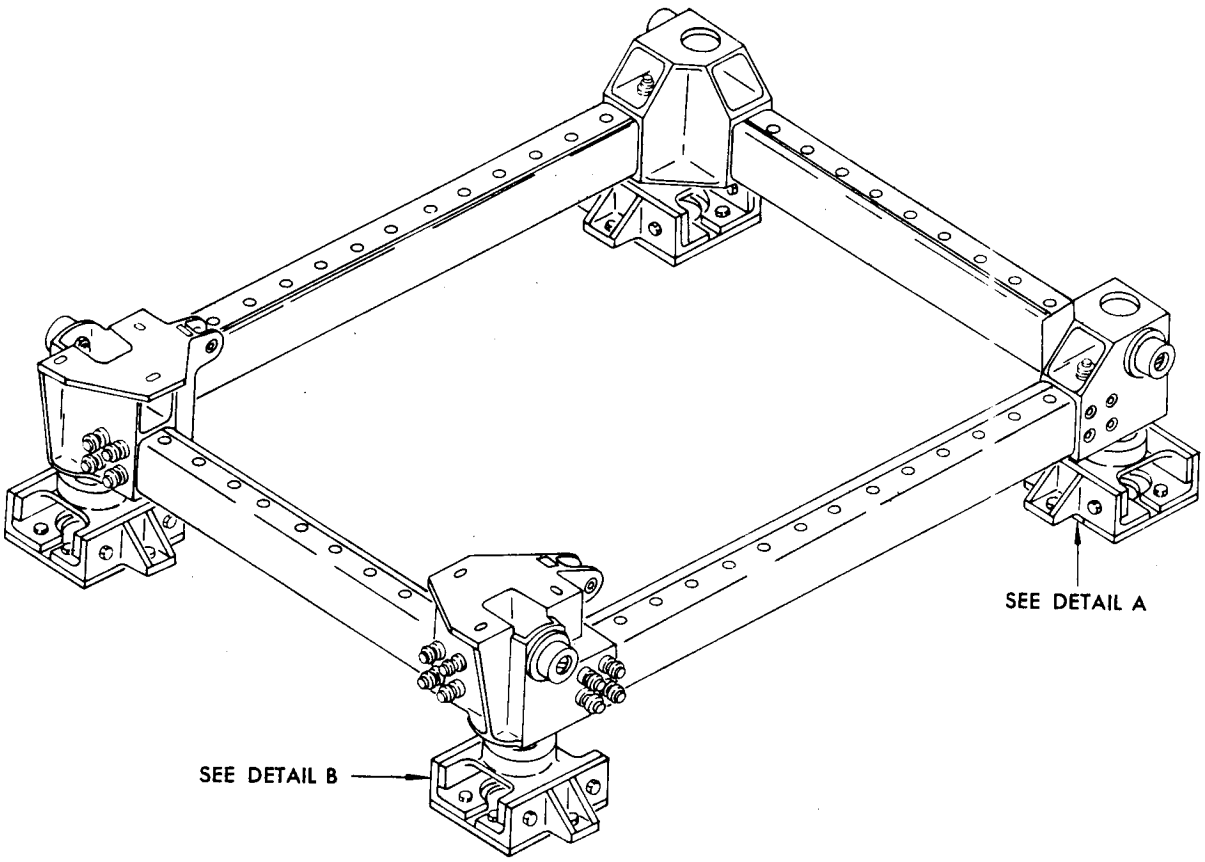
14. Group Assembly Parts List

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1107	65-60590-1		SEGMENT LOCK INSTALLATION		
1	AN316-4		. NUT		2
2	AN960-416		. WASHER		2
3	MS51966-67		. SETSCREW		2
4	69-49749-1		. SPRING		2
5	MS24665-287		. PIN, Cotter		2
6	BACN10JD108		. NUT (replaces AN320-8)		2
6	AN320-8		. NUT		2
7	AN960-816		. WASHER		2
8	NAS1108-36		. BOLT		2
9	AN960PD816L		. WASHER ▷		AR
10	BACB10A692		. BEARING		2
11	NAS43HT8-21		. SPACER		2
12	MS24665-304		. PIN, Cotter		2
13	BACN10JD107		. NUT (replaces AN320-7) (used with BACB10AF7F3H)		2
13	AN320-7		. NUT (obsolete) (used with BACB10AF7F3H)		2
13	BACN10JD7		. NUT (replaces AN310-7) (used with BACB10BH62F6)		2
13	AN310-7		. NUT (obsolete) (used with BACB10BH62F6)		2
14	AN960-716		. WASHER		2
15	BACB10AF7F3H		. BEARING (replaces BACB10BH62F6)		2
15	BACB10BH62F6		. BEARING		2
16	65-60520-1		. HOOK ASSEMBLY (used on aft side)		1
16	65-60520-2		. HOOK ASSEMBLY (used on fore side)		1
17	BACN10JD4AU		. . NUT, Lock (replaces AN310C4)		1
17	AN310C4		. . NUT, Lock		1
18	AN960C416		. . WASHER		1
19	AN43BC4		. . BOLT, Eye		1
20	BACB10A692		. . BEARING		1
21	69-48947-1		. . SLEEVE		1
22	65-60520-3		. . HOOK (used on 65-60520-1)		1
22	65-60520-4		. . HOOK (used on 65-60520-2)		1
23	MS24665-359		. PIN, Cotter		2
24	BACN10JD112		. NUT (replaces AN320-12)		2
24	AN320-12		. NUT		2
25	AN960-1216		. WASHER		2
26	69-48910-1		. BOLT		2
27	BACB10B135		. BEARING		2
28	BACN10JC4C		. NUT (replaces NAS679C4W)		6
28	NAS679C4W		. NUT		6

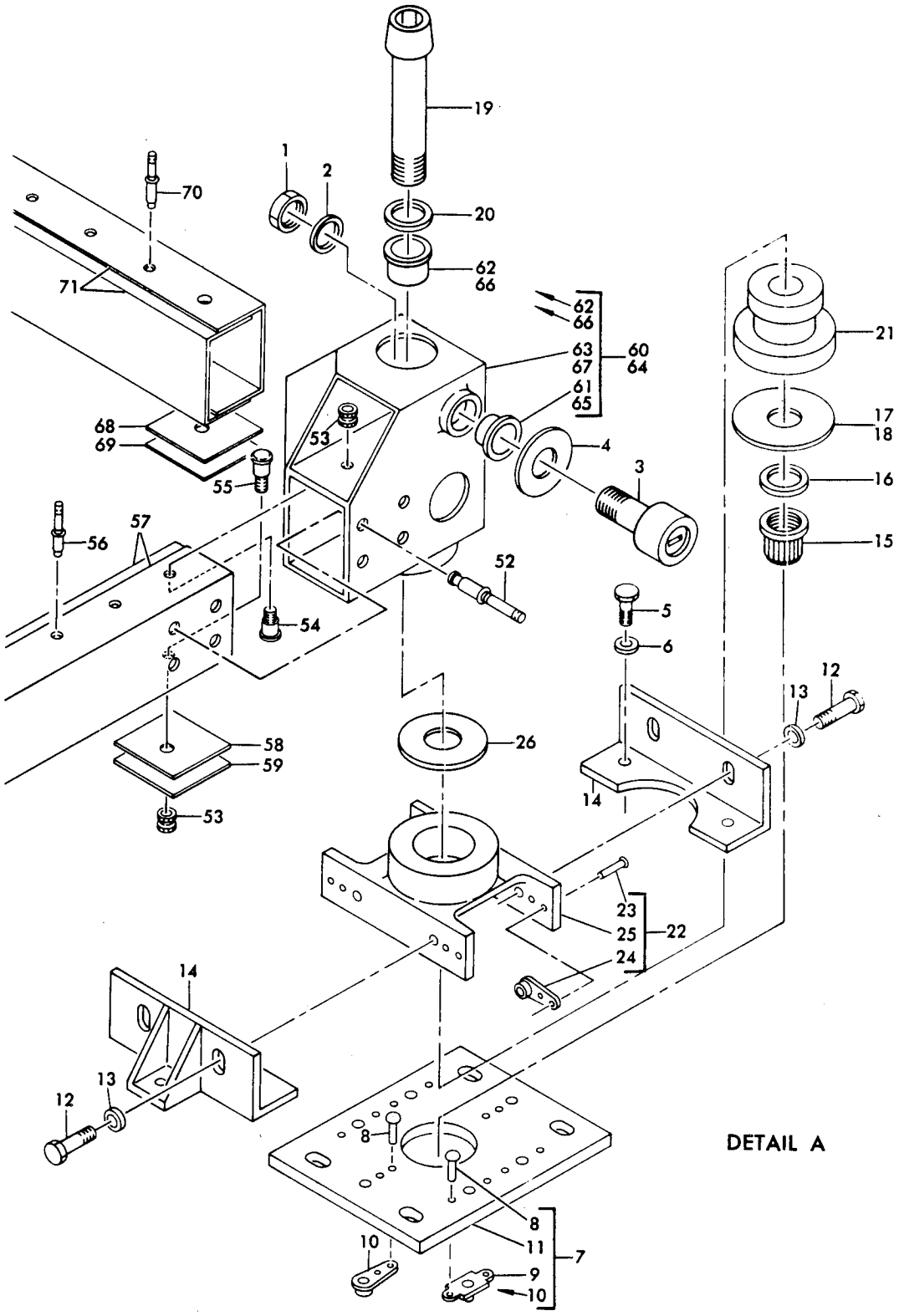
FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
29	AN960-416		. WASHER.		6
30	BACB30LU4-5		. BOLT.		6
31	65-60591-1		. CAM, Segment lock (used on aft side)		1
31	65-60591-2		. CAM, Segment lock (used on fore side)		1
32	MS20426D5		. RIVET		4
33	BACS40R08E13		. SHIM.		4

▷ use a maximum of two washers each on aft and fore side, as required.

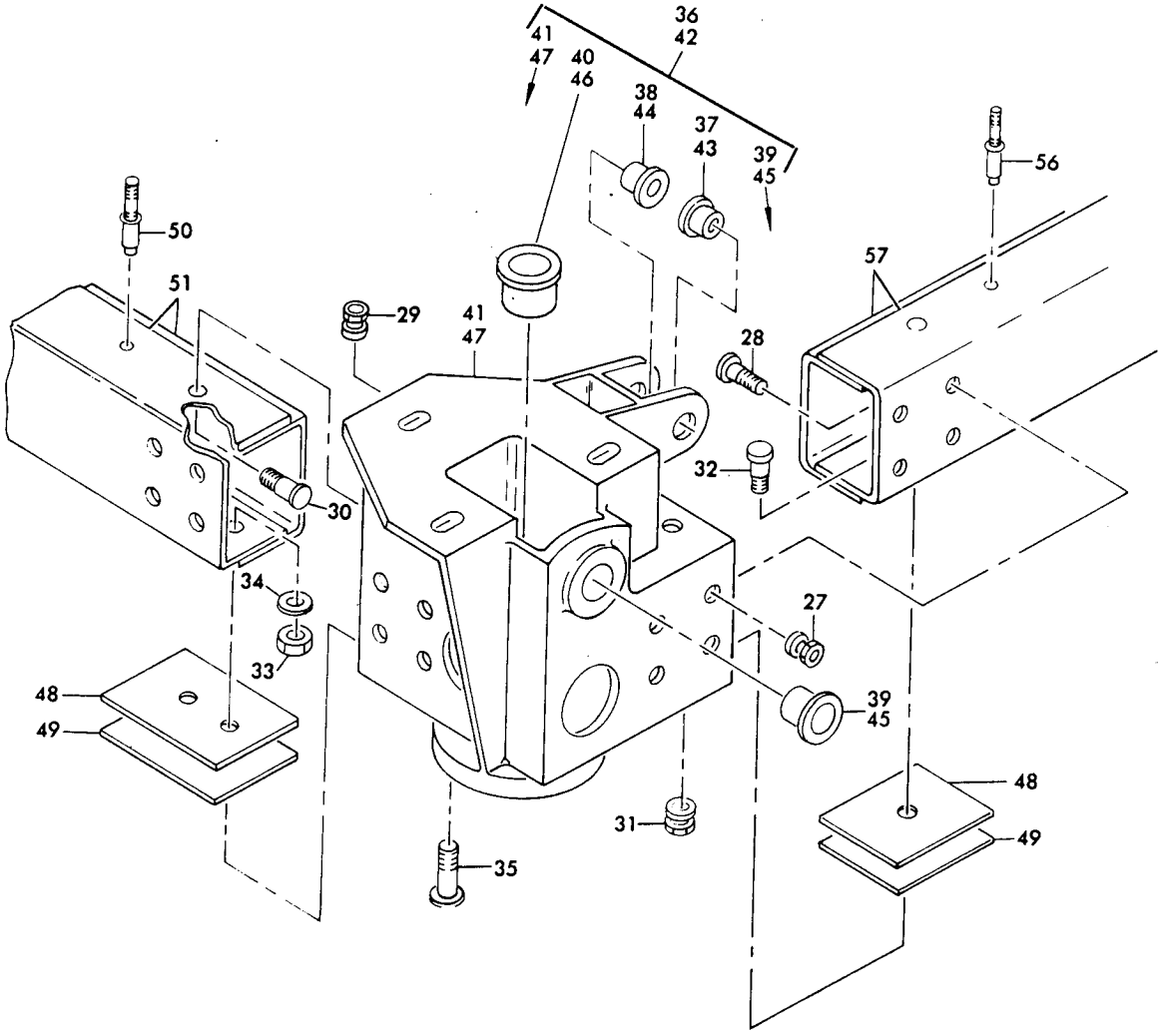
15. Exploded View



Carriage Assembly
Figure 1108 (Sheet 1)



Carriage Assembly
Figure 1108 (Sheet 2)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DETAIL B

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1108-					
	65-59673-1		CARRIAGE ASSEMBLY		
1	AN316-8R		. NUT		4
2	MS27111-5		. WASHER		4
3	BACB10AF8K6H		. BEARING UNIT, NEEDLE (REPLS BACB10AF8K5H)		4
3	BACB10AF8K5H		. BEARING UNIT, NEEDLE (OPTIONAL TO BACB10AF8K6H)		4
4	69-49762-2		. WASHER		4
5	BACB30NE4-7		. BOLT		24
6	AN960D416		. WASHER		24
7	69-48712-1		. PLATE ASSEMBLY, MOUNTING		4
8	MS20426D3		. . RIVET		12
9	BACN10JR4F		. . NUTPLATE		4
10	BACN10JP4B		. . NUTPLATE		2
11	69-48712-2		. . PLATE, MOUNTING		1
12	NAS1104-6		. BOLT		16
13	AN960D416L		. WASHER		16
14	69-48711-1		. BRACKET, MOUNTING		8
15	BACN10GW10		. NUT		4
16	MS20002-10		. WASHER		4
17	69-49762-1		. WASHER		3
18	69-49762-5		. WASHER ▷1		1
19	MS20010-34		. BOLT		4
20	MS20002C10		. WASHER		4
21	J6256-22		. CENTER-BONDED MOUNT, V76005		4
22	69-48710-1		. SOCKET FITTING ASSEMBLY		4
23	MS20426D3		. . RIVET		8
24	BACN10JP4B		. . NUTPLATE		4
25	69-48710-2		. . FITTING		1
26	69-49762-4		. WASHER		4
27	BACC30M6		. COLLAR		34
28	BACB30FM6-4		. LOCKBOLT		34
29	BACC30M8		. COLLAR (USED WITH BACB30FM8-5)		2
29	BACC30M6		. COLLAR (USED WITH BACB30FM6-4)		2
30	BACB30FM8-5		. LOCKBOLT (REPLS BACB30FM6-4)		2
30	BACB30FM6-4		. LOCKBOLT		2
31	BACC30M6		. COLLAR		4
32	BACB30FM6-5		. LOCKBOLT		4
33	BACN10JC3		. NUT (REPLS NAS679A3)		24
33	NAS679A3		. NUT		2
34	AN960PD10		. WASHER		2
35	BACB30LU6-10		. BOLT		2
36	65-61349-1		. BRACKET ASSEMBLY		1
37	BACB28X4B24		. . BUSHING		1
38	BACB28X4B19		. . BUSHING		1

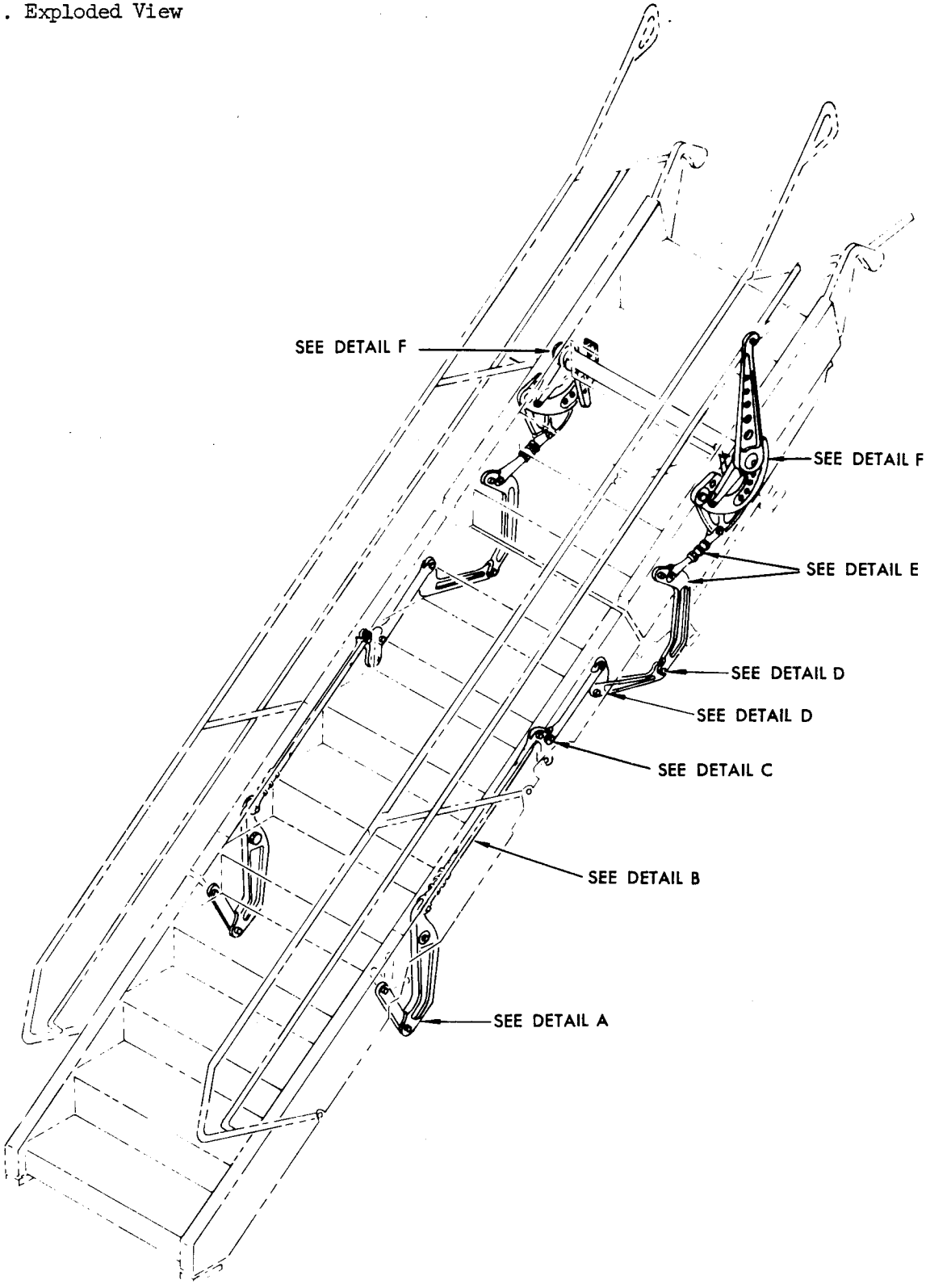
FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
39	BACB28X8B38		. . BUSHING		1
40	BACB28X10B48		. . BUSHING		1
41	65-61349-3		. . BRACKET		1
42	65-61349-2		. BRACKET ASSEMBLY		1
43	BACB28X4B24		. . BUSHING		1
44	BACB28X4B19		. . BUSHING		1
45	BACB28X8B38		. . BUSHING		1
46	BACB28X10B48		. . BUSHING		1
47	65-61349-4		. . BRACKET		1
48	BACS40R09B14		. SHIM		4
49	BACS40R09C14		. SHIM		4
50	BACR15DJ5P2		. RIVET, Blind		18
51	65-63365-2		. BEAM ASSEMBLY		2
52	BACB30LA6-4		. BOLT		8
53	BACC30M6		. COLLAR		AR
54	BACB30FM6-4		. LOCKBOLT		28
55	BACB30FM6-5		. LOCKBOLT		4
56	BACR15DJ5P2		. RIVET, Blind		52
57	65-63365-1		. BEAM ASSEMBLY		4
58	BACS40R09B14		. SHIM		2
59	BACS40R09C14		. SHIM		2
60	65-59681-2		. BRACKET ASSEMBLY		1
61	BACB28X8B38		. . BUSHING		1
62	BACB28X10B48		. . BUSHING		1
63	65-59681-4		. . BRACKET		1
64	65-59681-1		. BRACKET ASSEMBLY		1
65	BACB28X8B38		. . BUSHING		1
66	BACB28X10B48		. . BUSHING		1
67	65-59681-3		. . BRACKET		1
68	BACS40R09B14		. SHIM		2
69	BACS40R09C14		. SHIM		2
70	BACR15DJ5P2		. RIVET		36
71	65-63365-2		. BEAM ASSEMBLY		2

▷ used with center bonded mount installed in lower aft corner only

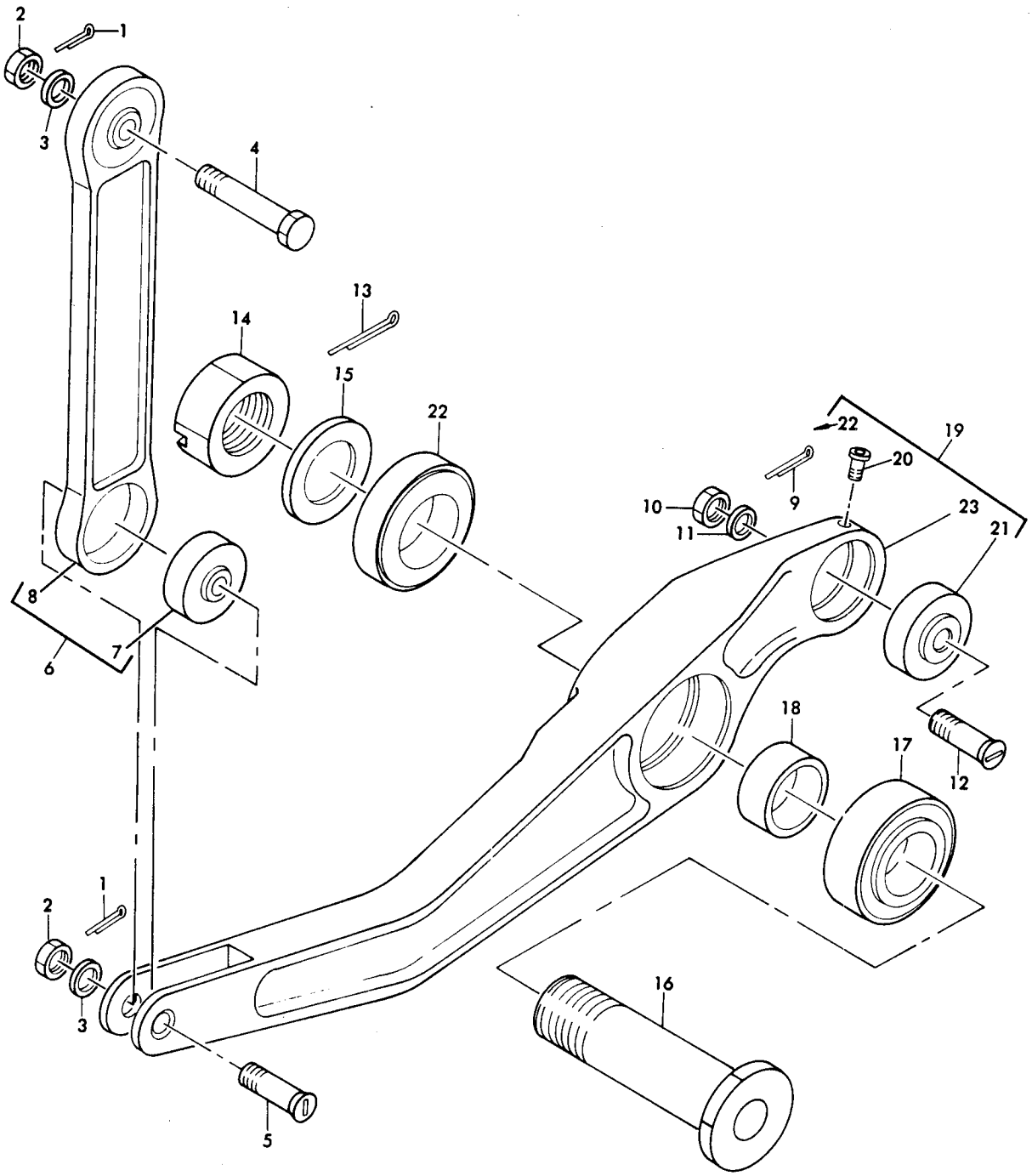
VENDOR CODE

Code	Name and Address
V76005	Lord Manufacturing Company Division Lord Corporation 1635 West 12th Street Erie, Pennsylvania 16512

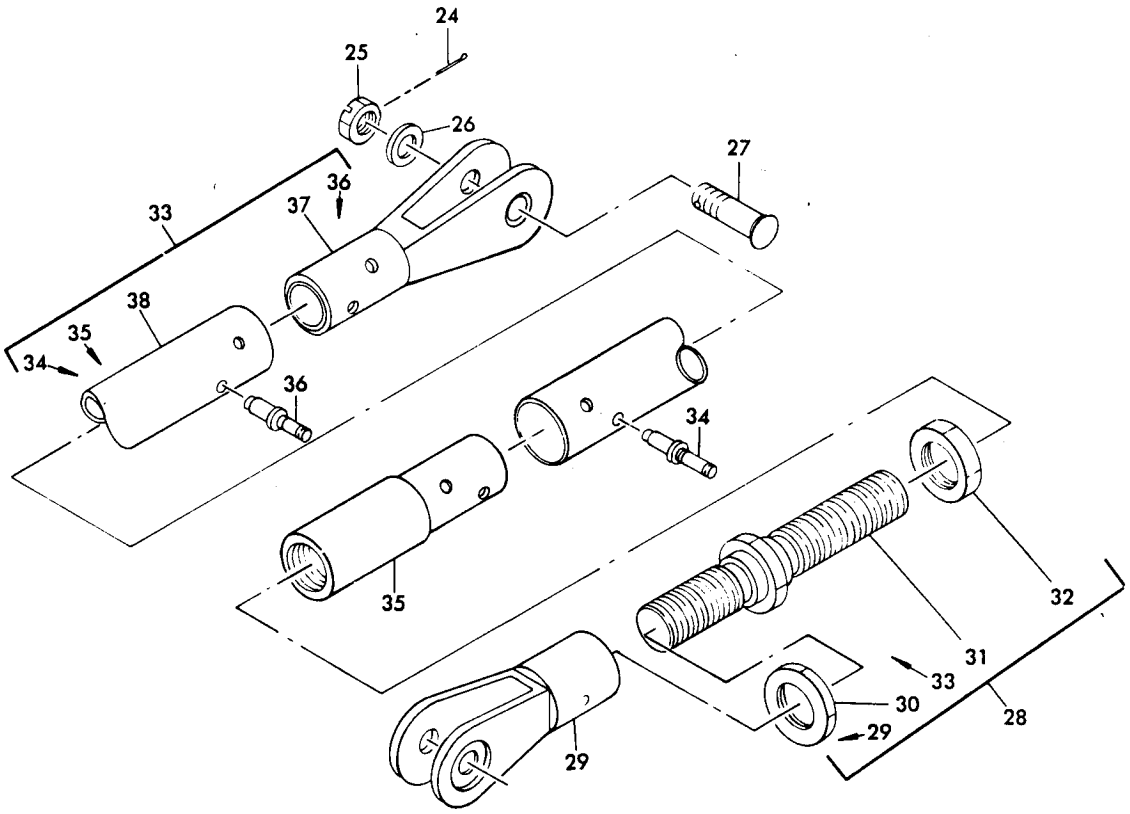
17. Exploded View



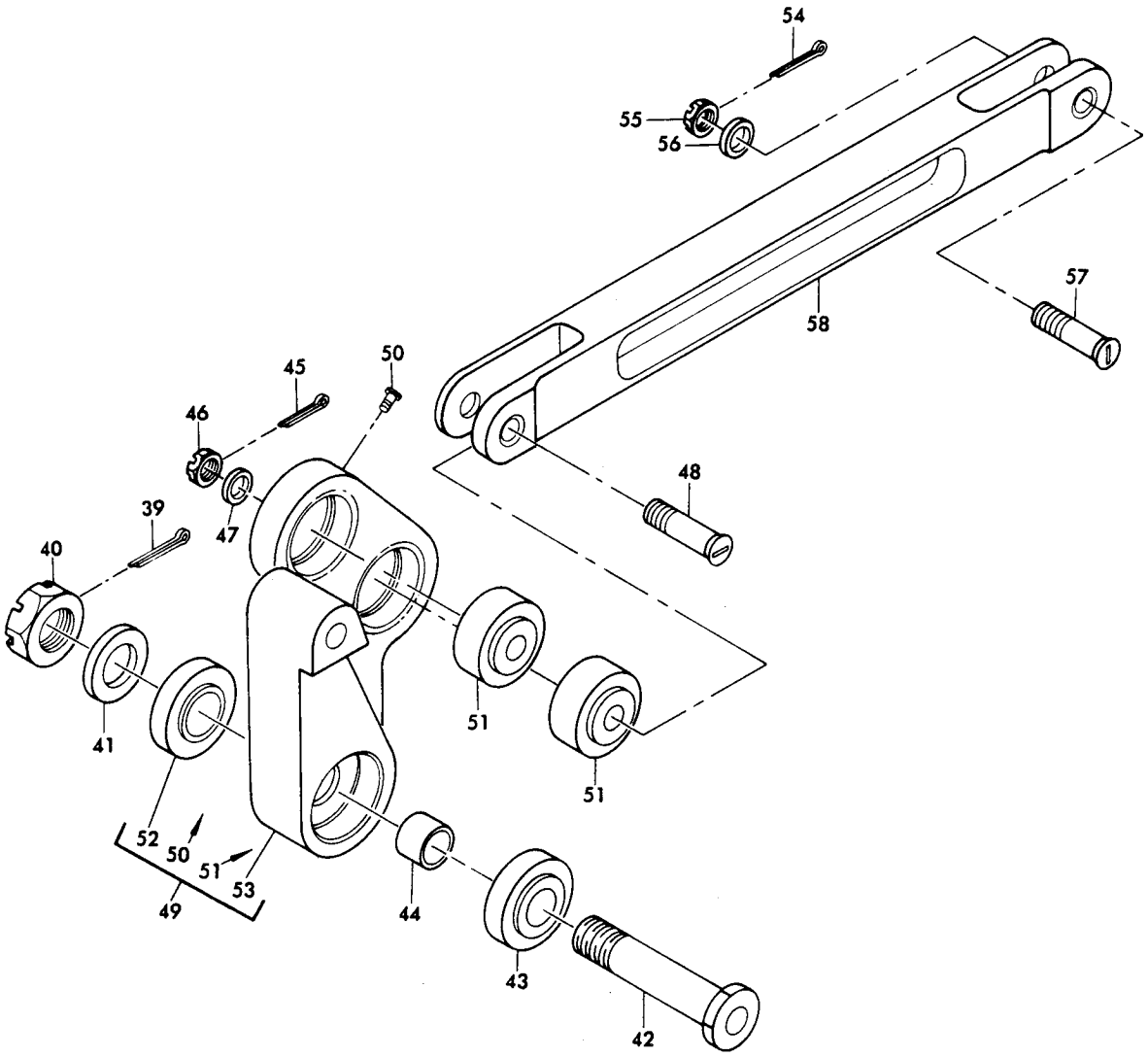
Folding Mechanism Installation
Figure 1109 (Sheet 1)



DETAIL A

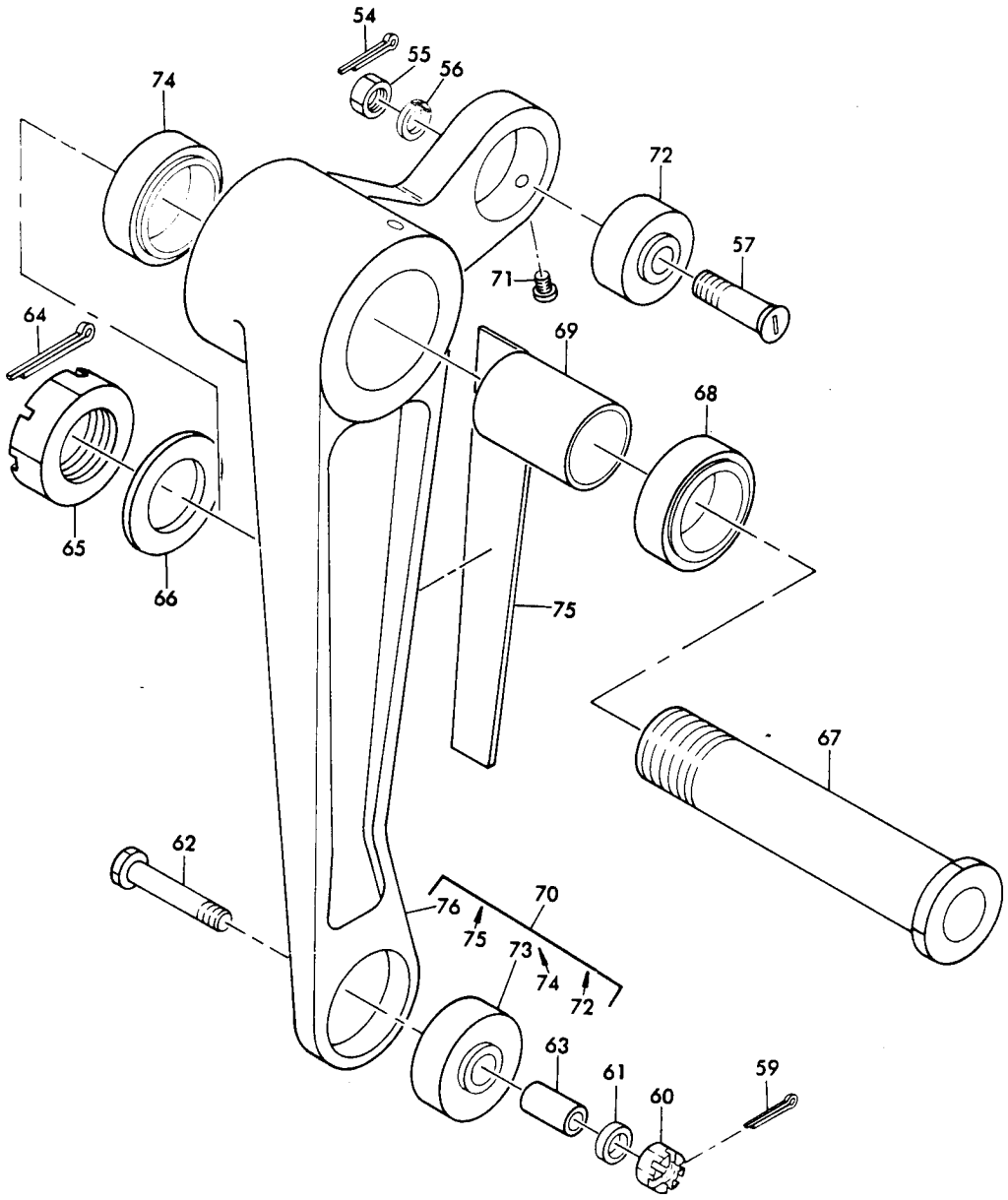


DETAIL B



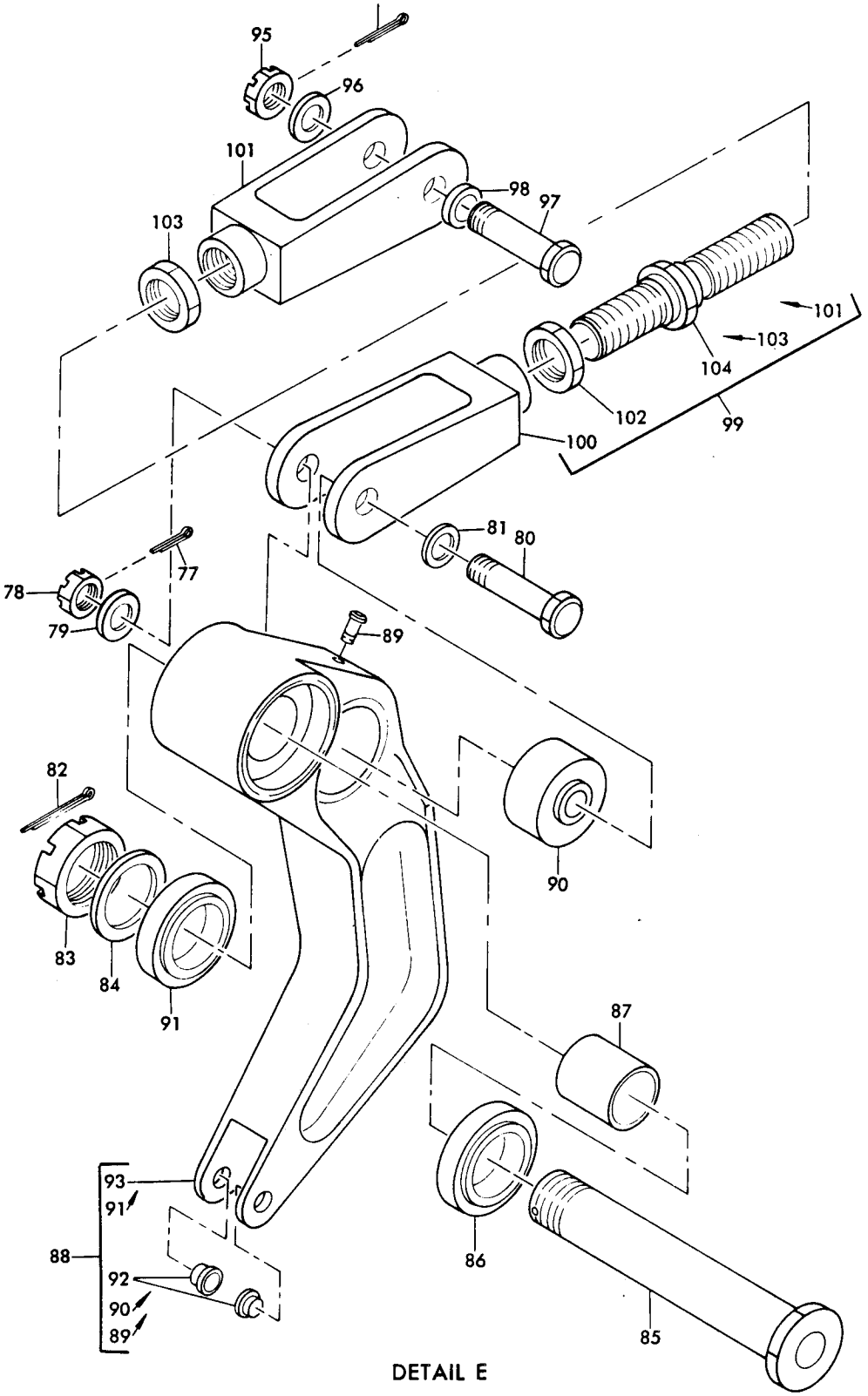
DETAIL C

Folding Mechanism Installation
Figure 1109 (Sheet 4)



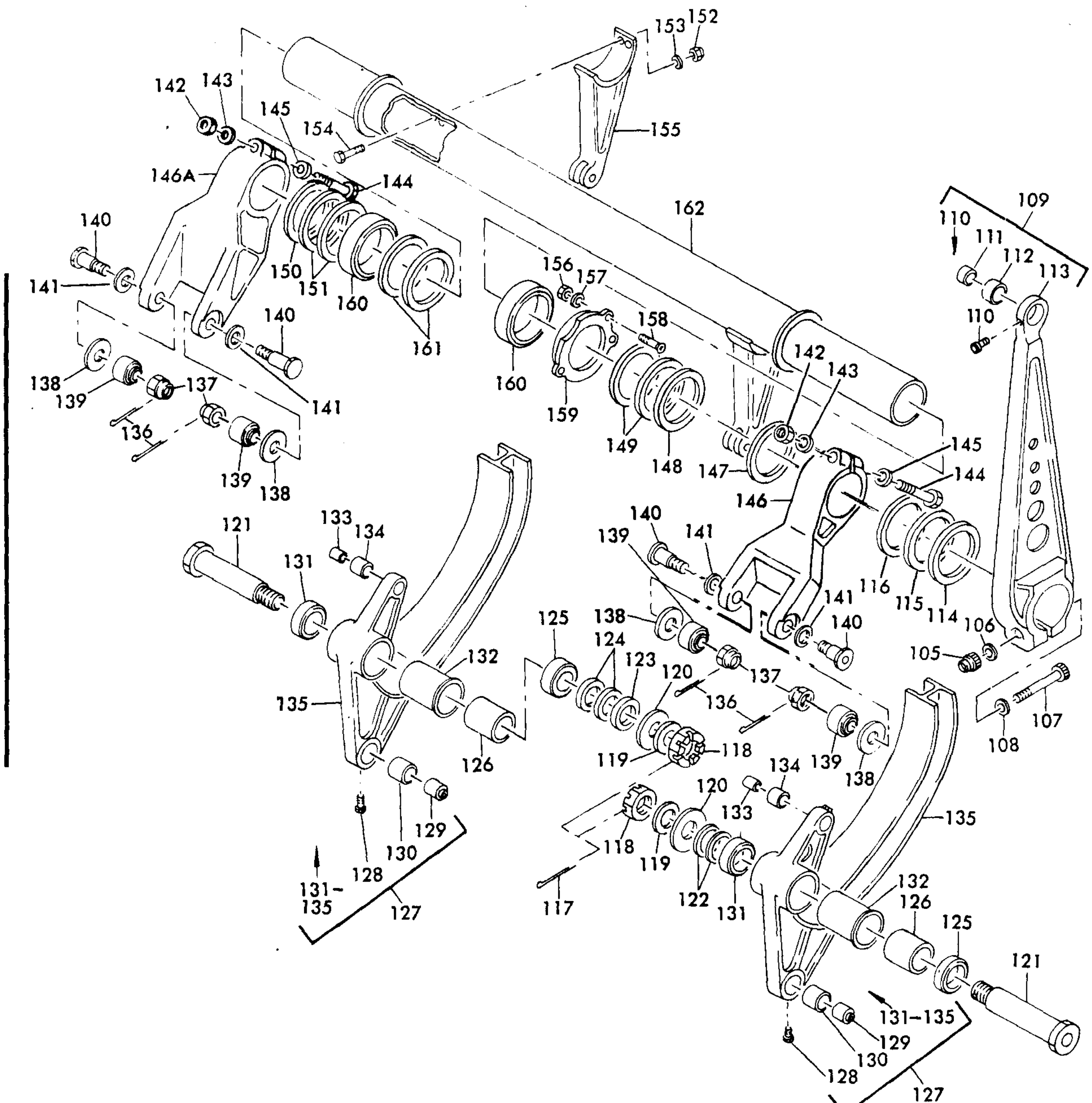
DETAIL D

Folding Mechanism Installation
Figure 1109 (Sheet 5)



DETAIL E

Folding Mechanism Installation
Figure 1109 (Sheet 6)



DETAIL F

Folding Mechanism Installation
Figure 1109 (Sheet 7)

18. Group Assembly Parts List

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1109	65-58232-1		FOLDING MECHANISM INSTALLATION		
1	MS24665-304		. PIN, Cotter		4
2	BACN10JD106AU		. NUT (replaces AN320C6)		4
2	AN320C6		. NUT		4
3	AN960PD616		. WASHER		4
4	BACB30LJ6D26		. BOLT		2
5	69-47531-1		. BOLT		2
6	69-46262-1		. LINK ASSEMBLY		2
7	BACB10AC6		. . BEARING		2
8	69-46262-2		. . LINK		1
9	MS24665-304		. PIN, Cotter		2
10	BACN10JD106AU		. NUT (replaces AN320C6)		2
10	AN320C6		. NUT		2
11	AN960PD616		. WASHER		2
12	65-47531-2		. BOLT		2
13	MS24665-362		. PIN, Cotter		2
14	AN320D20		. NUT		2
15	AN960PD2016		. WASHER		AR
16	69-47800-1		. SHAFT		2
17	BACB10A687		. BEARING		2
18	69-46684-1		. SPACER		2
19	65-59358-1		. CRANK ASSEMBLY, Aft side		1
19	65-59358-2		. CRANK ASSEMBLY, Fore side		1
20	NAS516-1		. . LUBRICATION FITTING		1
21	YS211B		. . ROLLER BEARING, V77896		1
22	BACB10A687		. . BEARING		1
23	65-59358-3		. . CRANK (used on 65-59358-1)		1
23	65-59358-4		. . CRANK (used on 65-59358-2)		1
24	MS24665-304		. PIN, Cotter		2
25	BACN10JD106AU		. NUT (replaces AN320C6)		2
25	AN320C6		. NUT		2
26	AN960PD616		. WASHER		2
27	69-47531-2		. BOLT		2
28	65-59652-1		. PUSHROD ASSEMBLY		2
29	69-46884-1		. . CLEVIS END		1
30	69-47442-2		. . NUT, Lock		1
31	69-46874-2		. . ROD, Adjusting		1
32	69-47442-1		. . NUT, Lock		1
33	65-59652-2		. . ROD ASSEMBLY (preferred)		1
33	65-59652-3		. . ROD ASSEMBLY (optional to 65-59652-2)		1
34	BACB30LB6-3		. . . BOLT		4
35	69-46885-1		. . . ADAPTER, Rod end		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
36	BACB30LB6-3		. . . BOLT.		4
37	69-46884-2		. . . CLEVIS END.		1
38	69-46893-1		. . . TUBE (used on 65-59652-2) . . .		1
38	69-46893-2		. . . TUBE (used on 65-59652-3) . . .		1
39	MS24665-376		. PIN, Cotter		2
40	AN320D12		. NUT		2
41	AN960PD1216		. WASHER.		AR
42	69-47800-4		. SHAFT		2
43	BACB10A685		. BEARING		2
44	69-46684-4		. SPACER.		2
45	MS24665-304		. PIN, Cotter		2
46	BACN10JD106AU		. NUT (replaces AN320C6).		2
46	AN320C6		. NUT		2
47	AN960PD616		. WASHER.		2
48	69-47531-3		. BOLT.		2
49	65-60523-1		. IDLER CRANK ASSEMBLY, Aft side. . .		1
49	65-60523-2		. IDLER CRANK ASSEMBLY, Fore side . .		1
50	NAS516-1		. . FITTING		2
51	YS211B		. . ROLLER BEARING, V77896.		2
52	BACB10A685		. . BEARING		1
53	65-60523-3		. . CRANK, Idler (used on 65-60523-1)		1
53	65-60523-4		. . CRANK, Idler (used on 65-60523-2)		1
54	MS24665-304		. PIN, Cotter		2
55	BACN10JD106AU		. NUT (replaces AN320C6).		2
55	AN320C6		. NUT		2
56	AN960PD616		. WASHER.		2
57	69-47531-3		. BOLT.		2
58	69-46650-1		. PUSHROD		2
59	MS24665-304		. PIN, Cotter		2
60	BACN10JD106AU		. NUT (replaces AN320C6).		2
60	AN320C6		. NUT		2
61	AN960PD616		. WASHER.		2
62	BACB30LJ6D23		. BOLT.		2
63	69-46684-5		. SPACER.		2
64	MS24665-362		. PIN, Cotter		2
65	AN320D20		. NUT		2
66	AN960PD2016		. WASHER.		2
67	69-47800-2		. SHAFT		2
68	BACB10A687		. BEARING		2
69	69-46684-2		. SPACER.		2
70	65-59620-1		. CRANK ASSEMBLY, Aft side.		1
70	65-59620-2		. CRANK ASSEMBLY, Fore side		1
71	NAS516-1		. . LUBRICATION FITTING		1
72	YS211B		. . ROLLER BEARING, V77896.		1

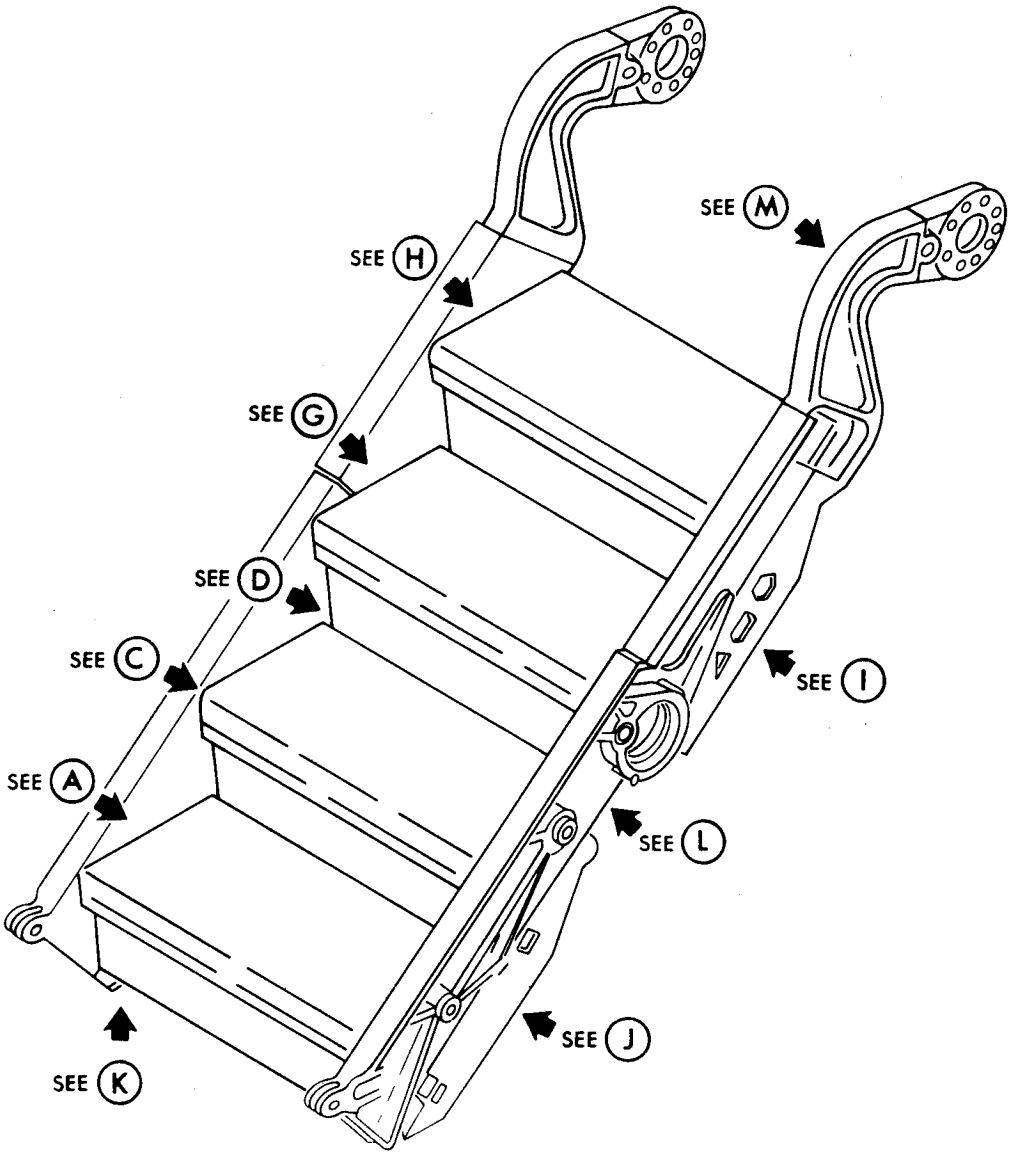
FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
73	BACB10AC8		. . BEARING		1
74	BACB10A687		. . BEARING		1
75	65-59620-5		. . RUB STRIP		1
76	65-59620-3		. . CRANK (used on 65-59620-1)		1
76	65-59620-4		. . CRANK (used on 65-59620-2)		1
77	MS24665-357		. PIN, Cotter		2
78	AN320C10		. NUT		2
79	AN960PD1016		. WASHER		2
80	NAS1110-26D		. BOLT		2
81	AN960PD1016		. WASHER		2
82	MS24665-362		. PIN, Cotter		2
83	AN320D10		. NUT		2
84	AN960PD2016		. WASHER		2
85	69-47800-3		. SHAFT		2
86	BACB10A687		. BEARING		2
87	69-46684-3		. SPACER		2
88	65-59635-1		. CRANK ASSEMBLY		2
89	NAS516-1		. . LUBRICATION FITTING		1
90	BACB10C94H		. . BEARING		1
91	BACB10A687		. . BEARING		1
92	BACB28W6B19		. . BUSHING		2
93	65-59635-3		. . CRANK		1
94	MS24665-357		. PIN, Cotter		2
95	BACN10JD110AU		. NUT (replaces AN320C10)		2
95	AN320C10		. NUT		2
96	AN960PD1016		. WASHER		2
97	NAS1110-26D		. BOLT		2
98	AN960PD1016		. WASHER		2
99	69-46873-1		. ROD ASSEMBLY, Adjustment		2
100	69-46875-1		. . ROD END		1
101	69-46876-1		. . ROD END		1
102	69-47442-2		. . NUT, Lock		1
103	69-47442-1		. . NUT, Lock		1
104	69-46874-1		. . ADJUSTING ROD		1
105	BACN10HR7		. NUT		1
106	AN960-716		. WASHER		1
107	BACB30MT7-48		. BOLT		1
108	MS20002C7		. WASHER		1
109	65-60516-1		. PROGRAM ARM ASSEMBLY		1
110	NAS516-1		. . LUBRICATION FITTING		1
111	YS211B		. . BEARING, V77896		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
112	69-47811-3		. . SLEEVE		1
113	65-60516-2		. . ARM		1
114	69-48740-5		. SHIM		1
115	69-48740-2		. SHIM		1
116	69-48740-1		. SHIM		1
117	MS24665-360		. PIN, Cotter		2
118	AN320D18		. NUT		2
119	AN960PD1816		. WASHER		AR
120	69-48729-1		. WASHER		2
121	69-47807-1		. PIN, Pivot		2
122	69-48740-3		. SPACER		2
123	69-48740-4		. SPACER		1
124	69-48740-3		. SPACER		2
125	BACB10A553		. BEARING		2
126	69-46682-1		. SPACER		2
127	65-60515-1		. CAM ASSY		2
128	NAS516-1		. . FITTING, Lubrication		2
129	BACB10C94H		. . BEARING (preferred)		1
129	BACB10C94		. . BEARING (optional to BACB10C94H)		1
130	69-47811-2		. . SLEEVE		1
131	BACB10A553		. . BEARING		1
132	69-47810-1		. . SLEEVE		1
133	BACB10C134H		. . BEARING (preferred)		1
133	BACB10C134		. . BEARING (optional to BACB10C134H)		1
134	69-47811-1		. . SLEEVE		1
135	65-60515-2		. . CAM		1
136	MS24665-287		. PIN, Cotter		4
137	69-48738-1		. NUT		4
138	69-48739-1		. WASHER		4
139	BACB10B135		. BEARING, Cam roller		4
140	69-48737-1		. BOLT		4
141	65-58232-2		. WASHER, SHIM		AR
142	BACN10HR6		. NUT		2
143	AN960-616		. WASHER		2
144	BACB30MT6-44		. BOLT		2
145	MS20002C6		. WASHER		2
146	65-60519-2		. CAM ROLLER CRANK (preferred)(SB 52-1035)		1
146	65-60519-1		. CAM ROLLER CRANK (optional)		1
146A	65-60518-2		. CAM ROLLER CRANK (preferred)(SB 52-1035)		1
146A	65-60518-1		. CAM ROLLER CRANK (optional)		1
147	69-48740-5		. SPACER		1
148	69-48740-2		. SPACER		1
149	69-48740-1		. SPACER		2

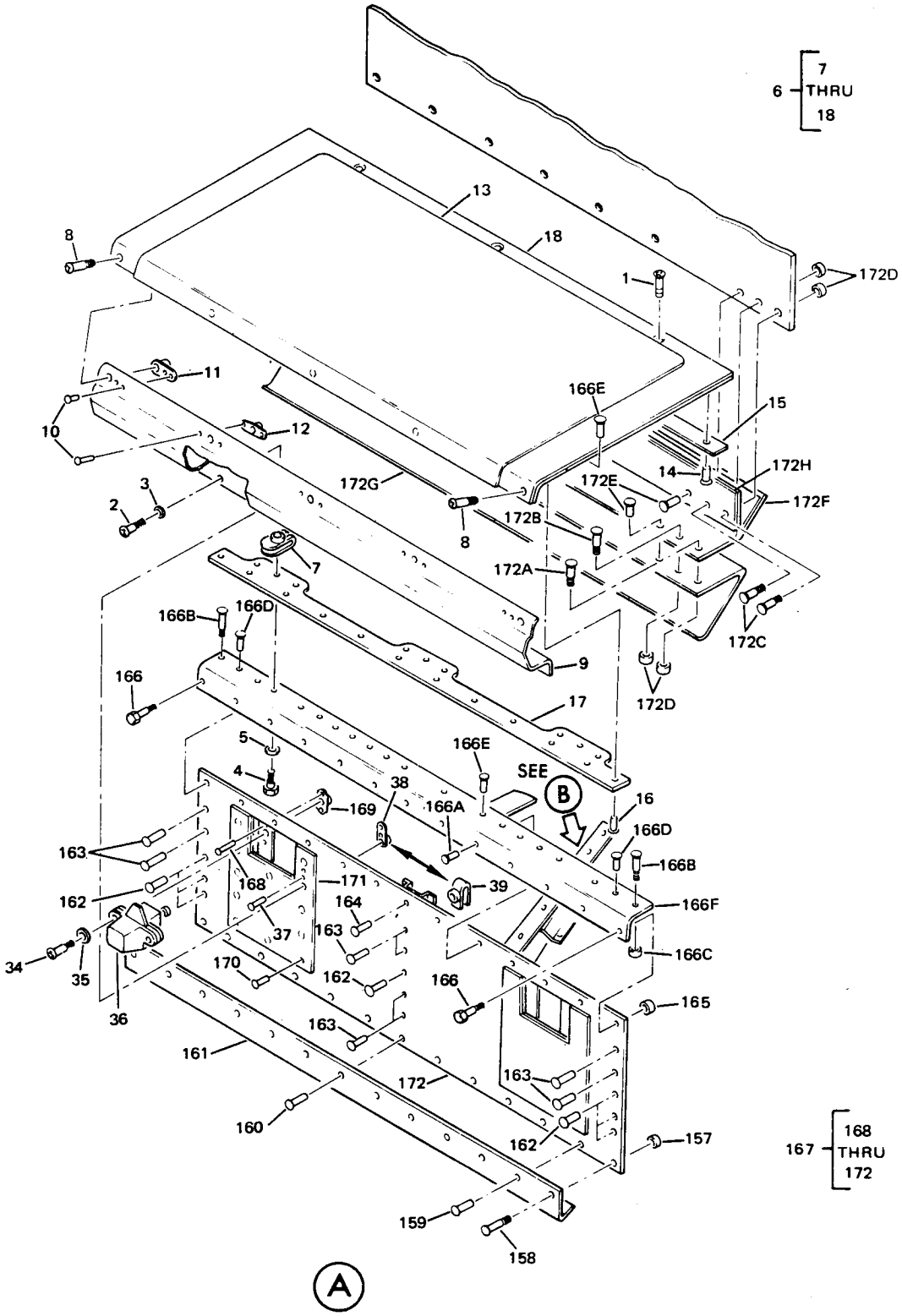
FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
150	69-48740-2		. SPACER.		1
151	69-48740-1		. SPACER.		2
152	BACN10GW5		. NUT		4
153	AN960PD516		. WASHER.		4
154	BACB30NE5-9		. BOLT (replaces NAS1305-9)		4
154	NAS1305-9		. BOLT		4
155	65-60521-1		. CRANK, Door drive		2
156	BACN10JC3		. NUT (replaces NAS679A3W).		3
156	NAS679A3W		. NUT		3
157	AN960PD10L		. WASHER.		3
158	BACB30LU3-22		. SCREW		3
159	69-46899-1		. RETAINER, Bearing		1
160	YD109N		. BEARING, V77896 (replaces YD109B) .		2
160	YD109B		. BEARING, V77896 (replaced by YD109N)		2
161	69-48740-5		. SPACER.		2
162	65-60517-1		. SHAFT		1

VENDOR CODE

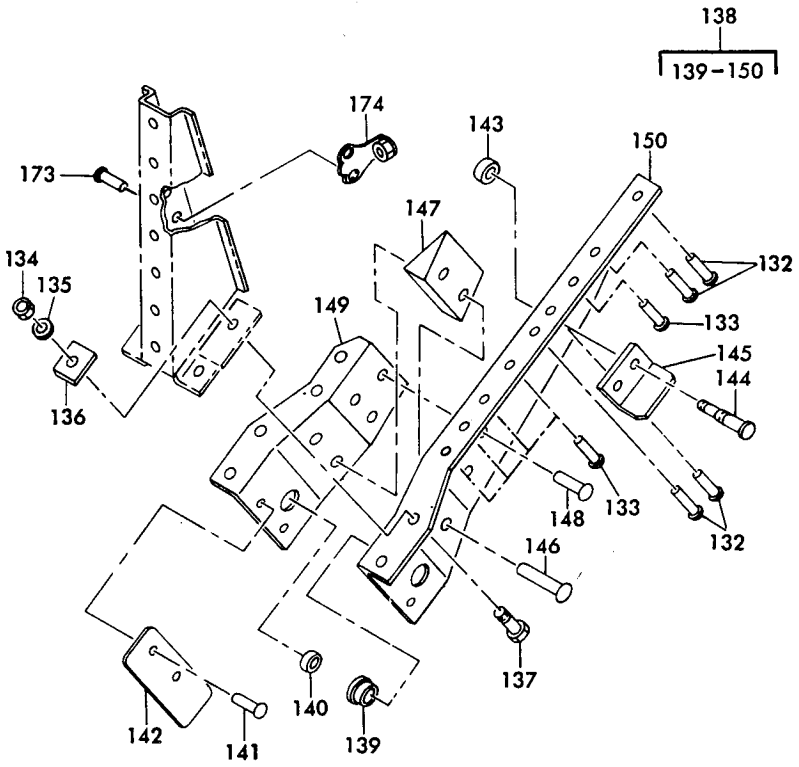
Code	Name and Address
V77896	Shafer Bearing Division, Rex Chainbelt Inc. Belmont Road at Curtiss St. Downers Grove, Illinois



Upper Ladder Assembly
Figure 1110 (Sheet 1)



Upper Ladder Assembly
Figure 1110 (Sheet 2)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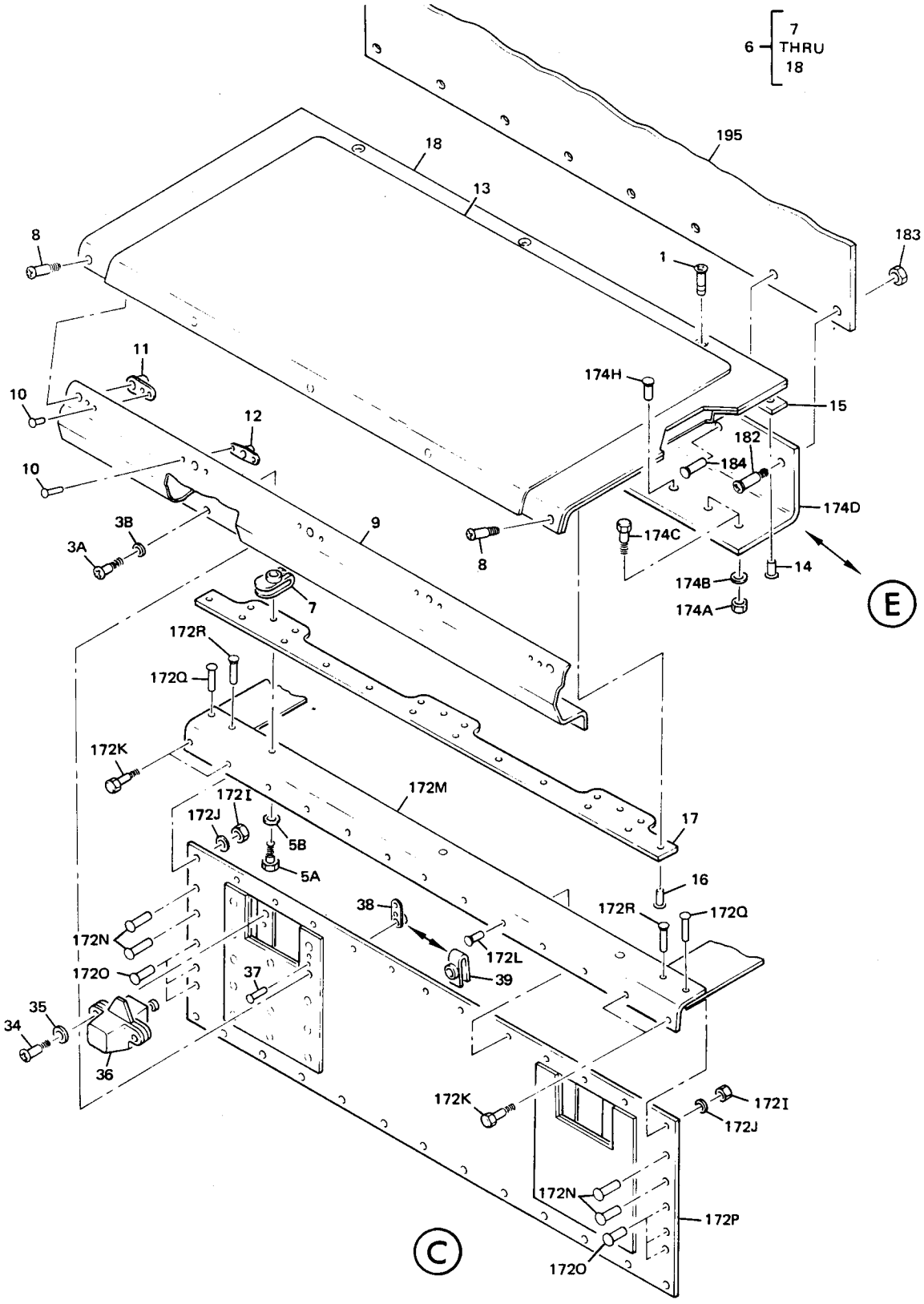
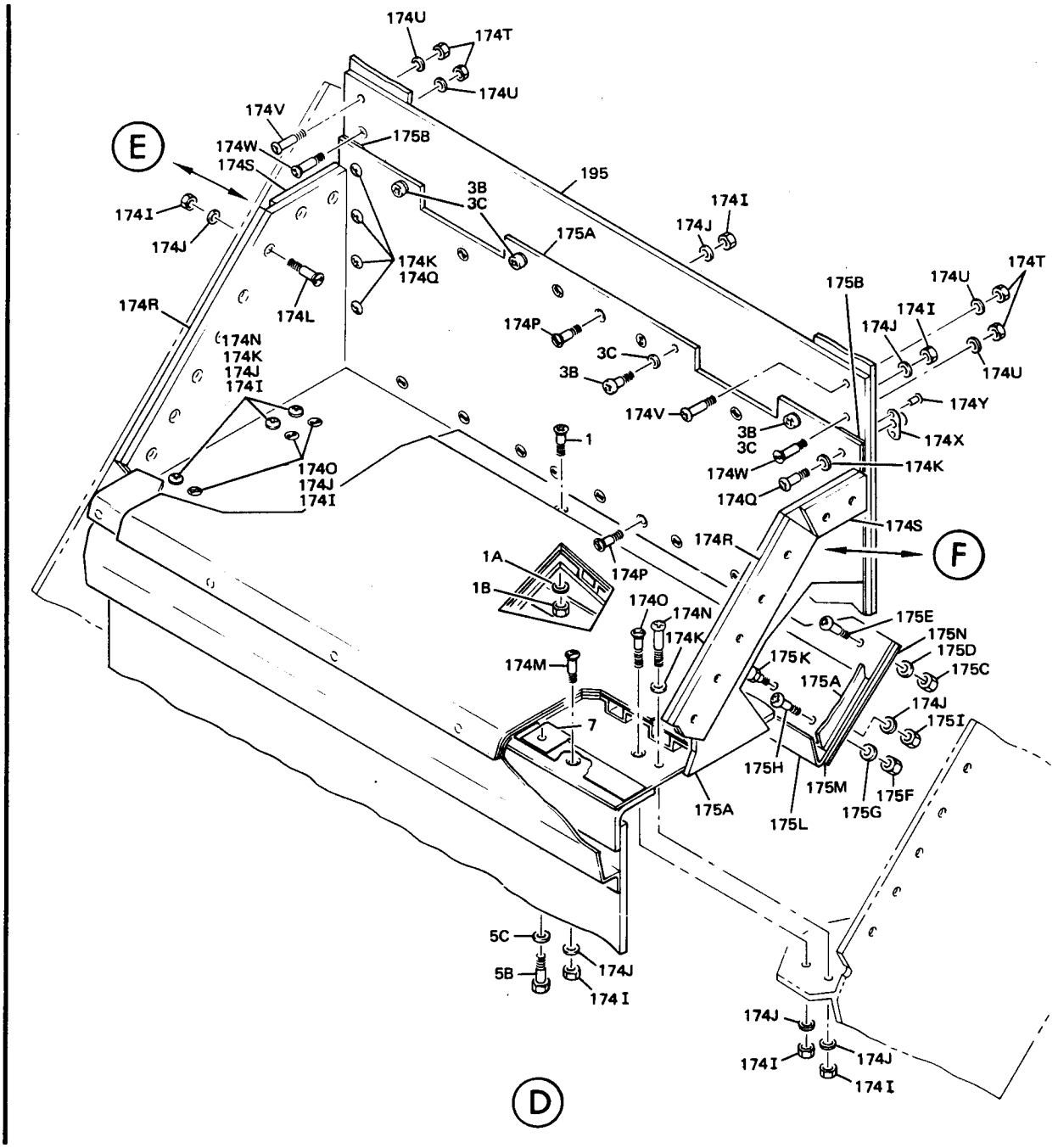


Upper Ladder Assembly
Figure 1110 (Sheet 4)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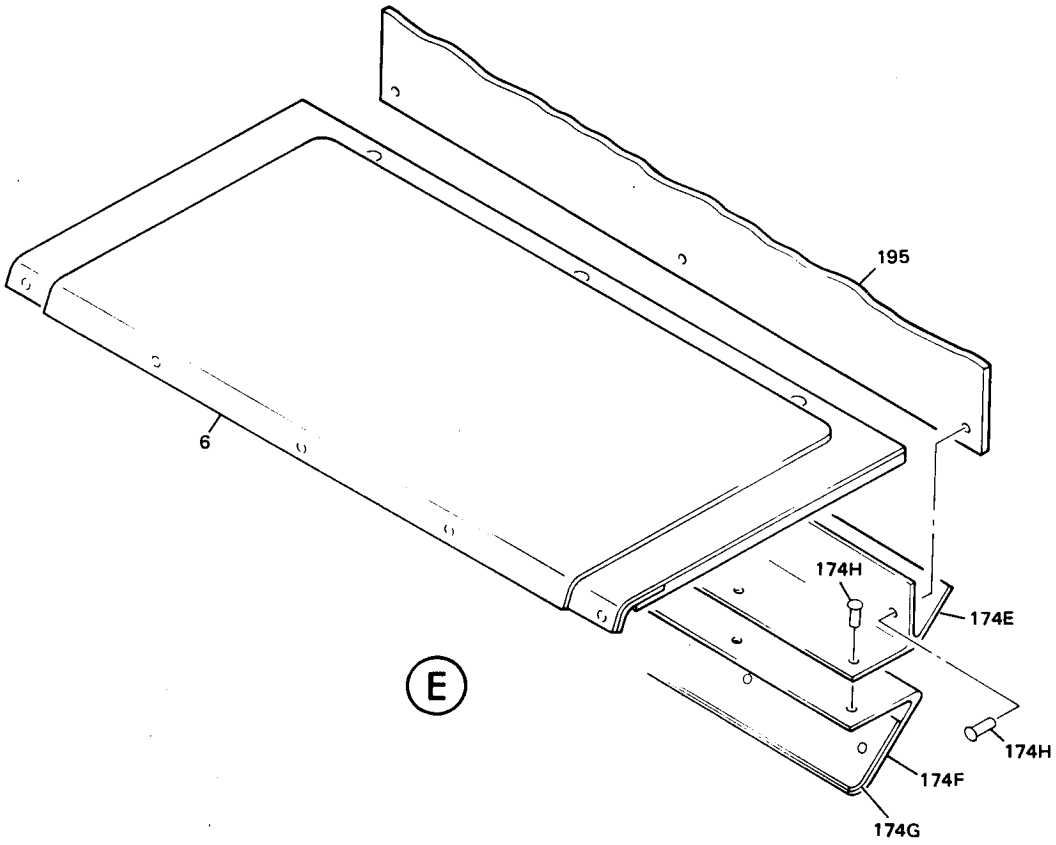
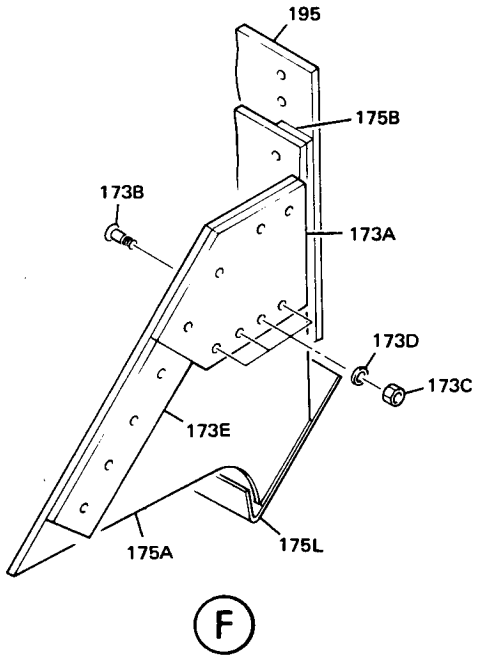
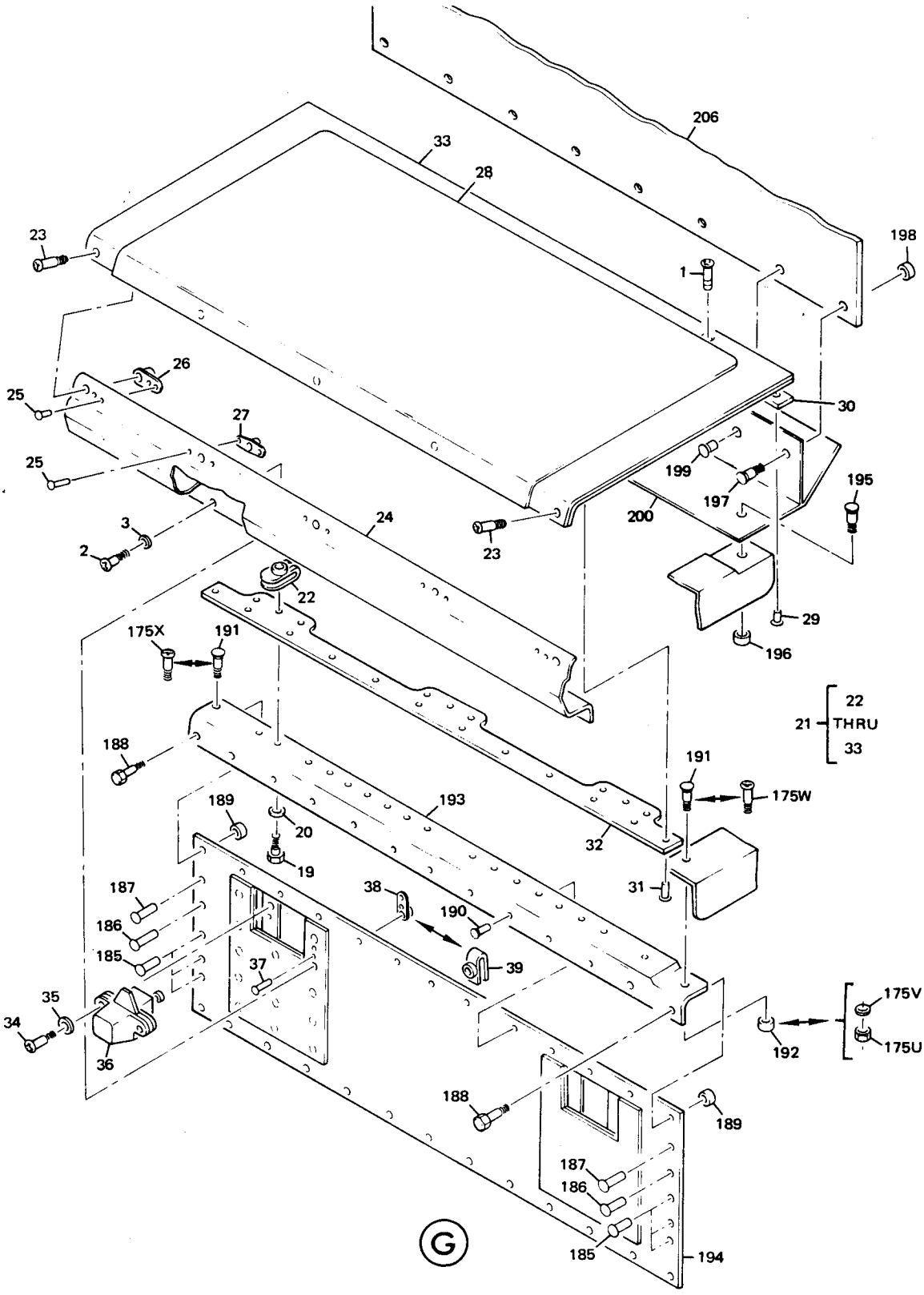
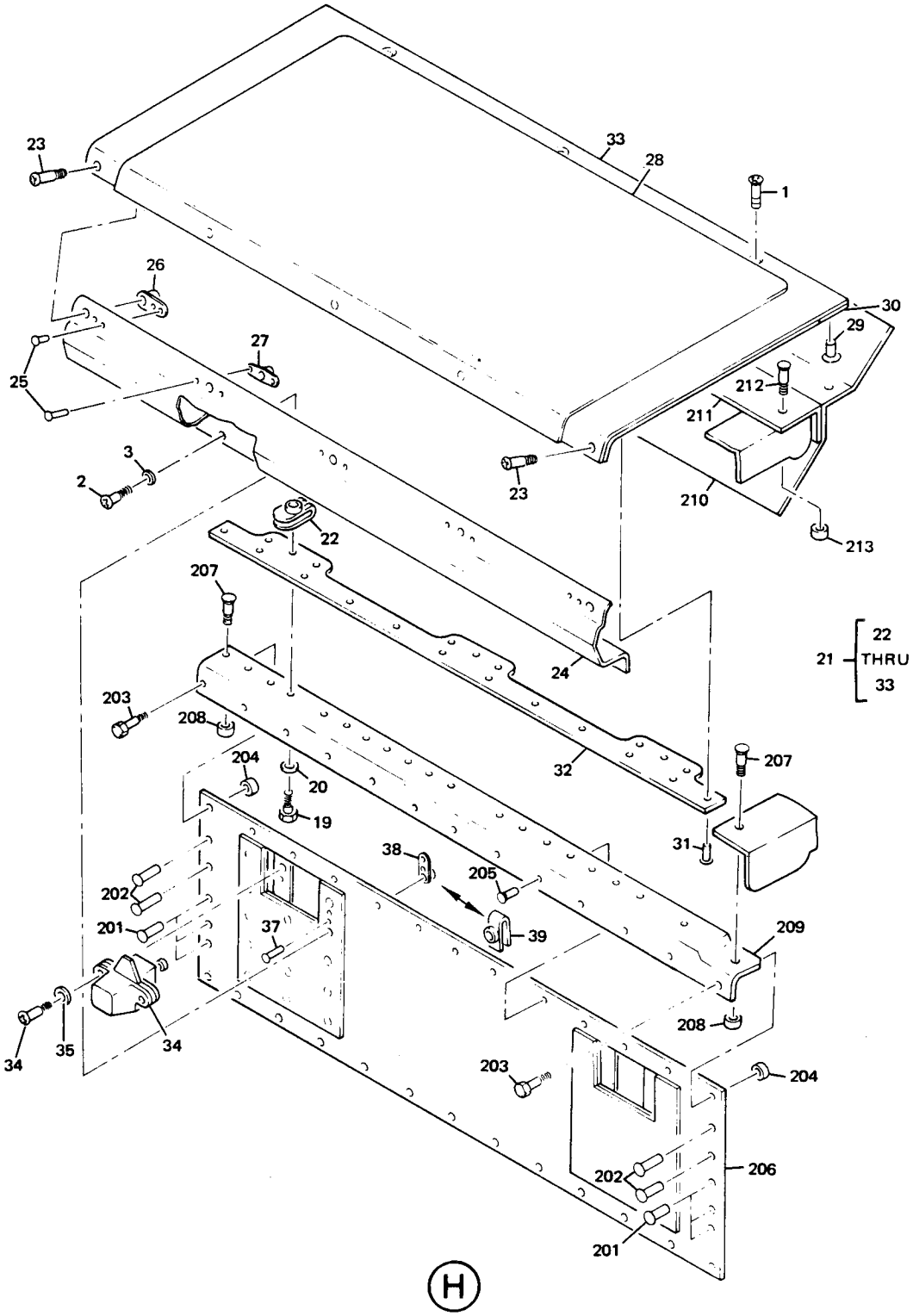




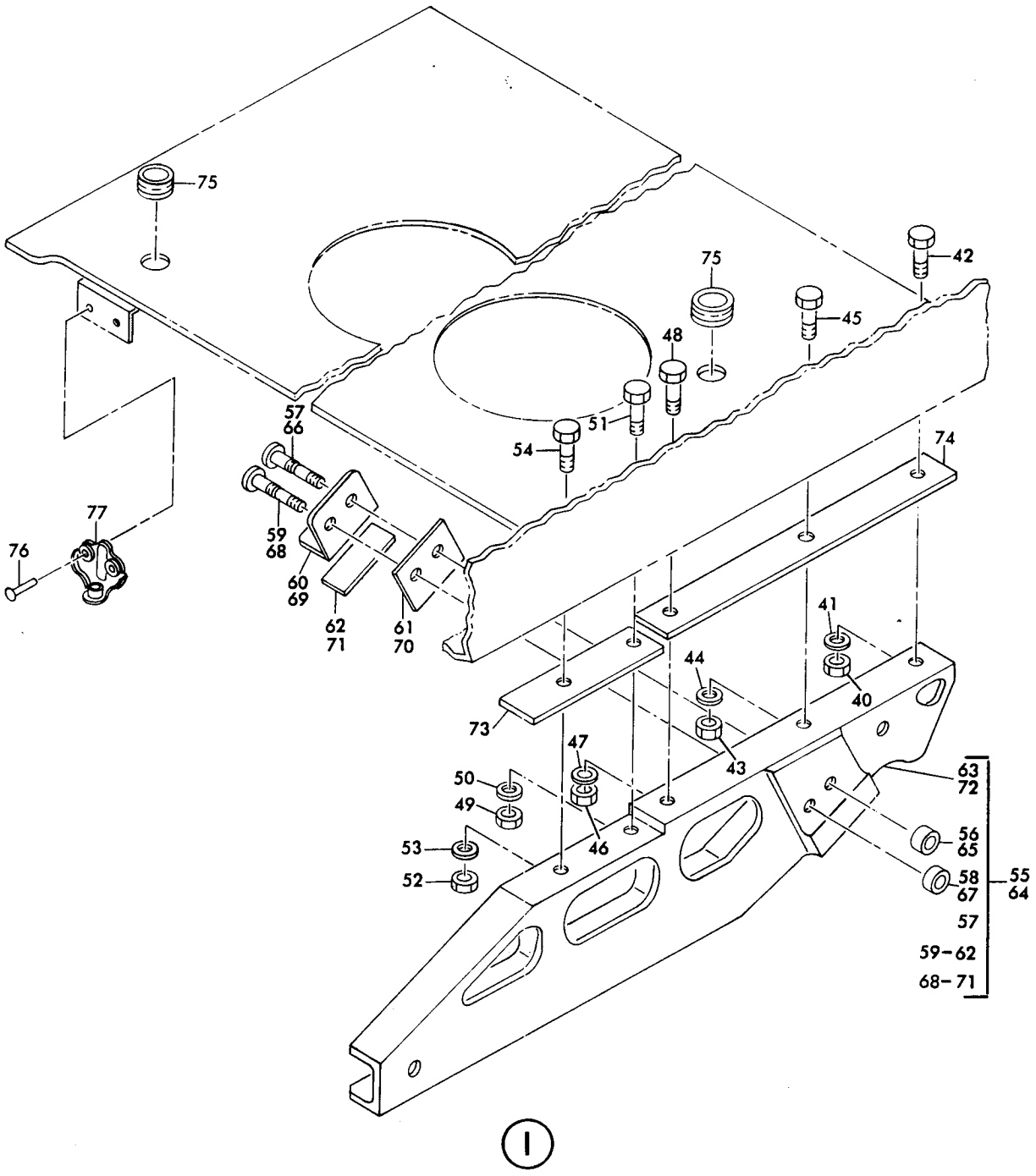
Upper Ladder Assembly
Figure 1110 (Sheet 6)



Upper Ladder Assembly
Figure 1110 (Sheet 7)



Upper Ladder Assembly
Figure 1110 (Sheet 8)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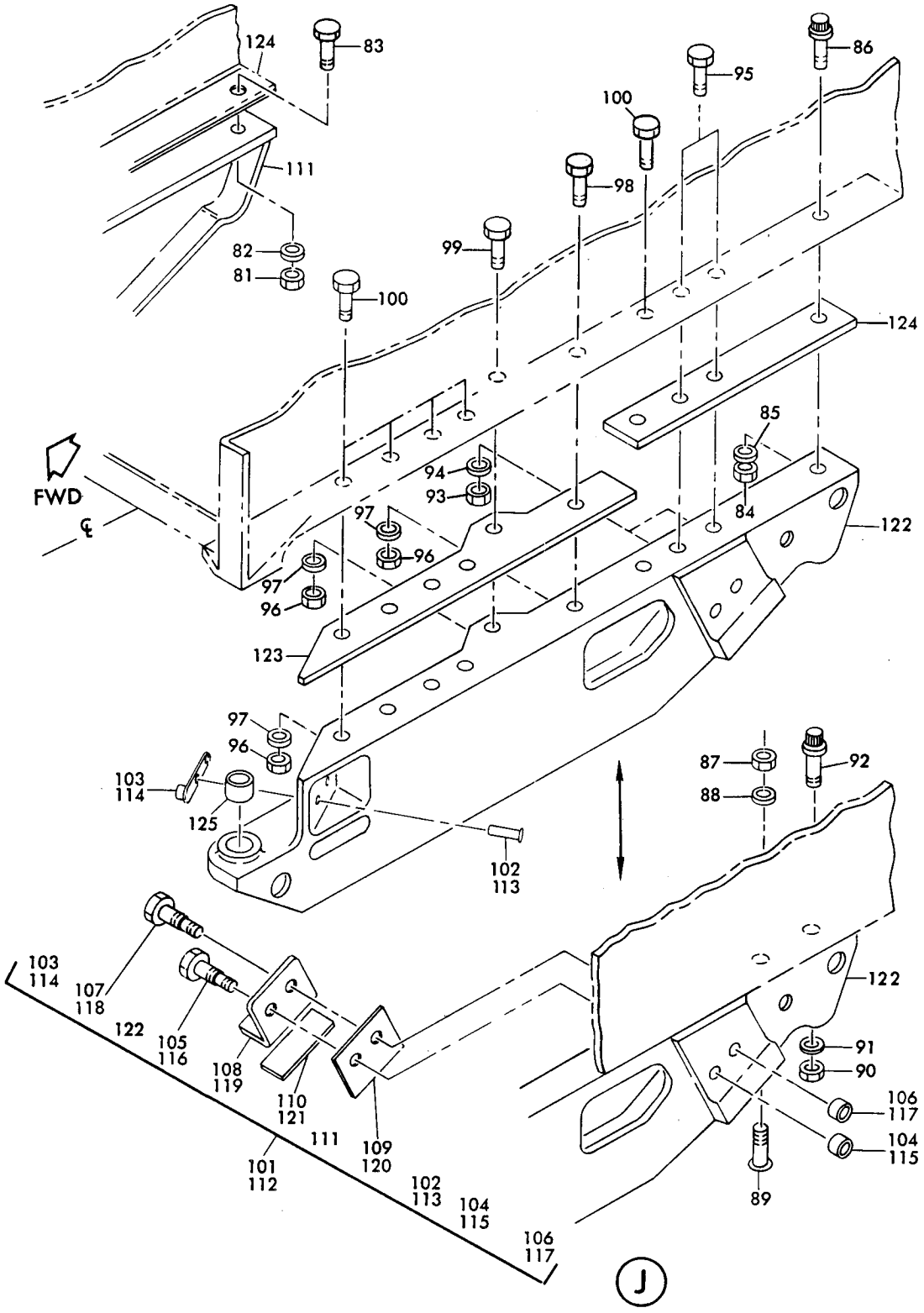
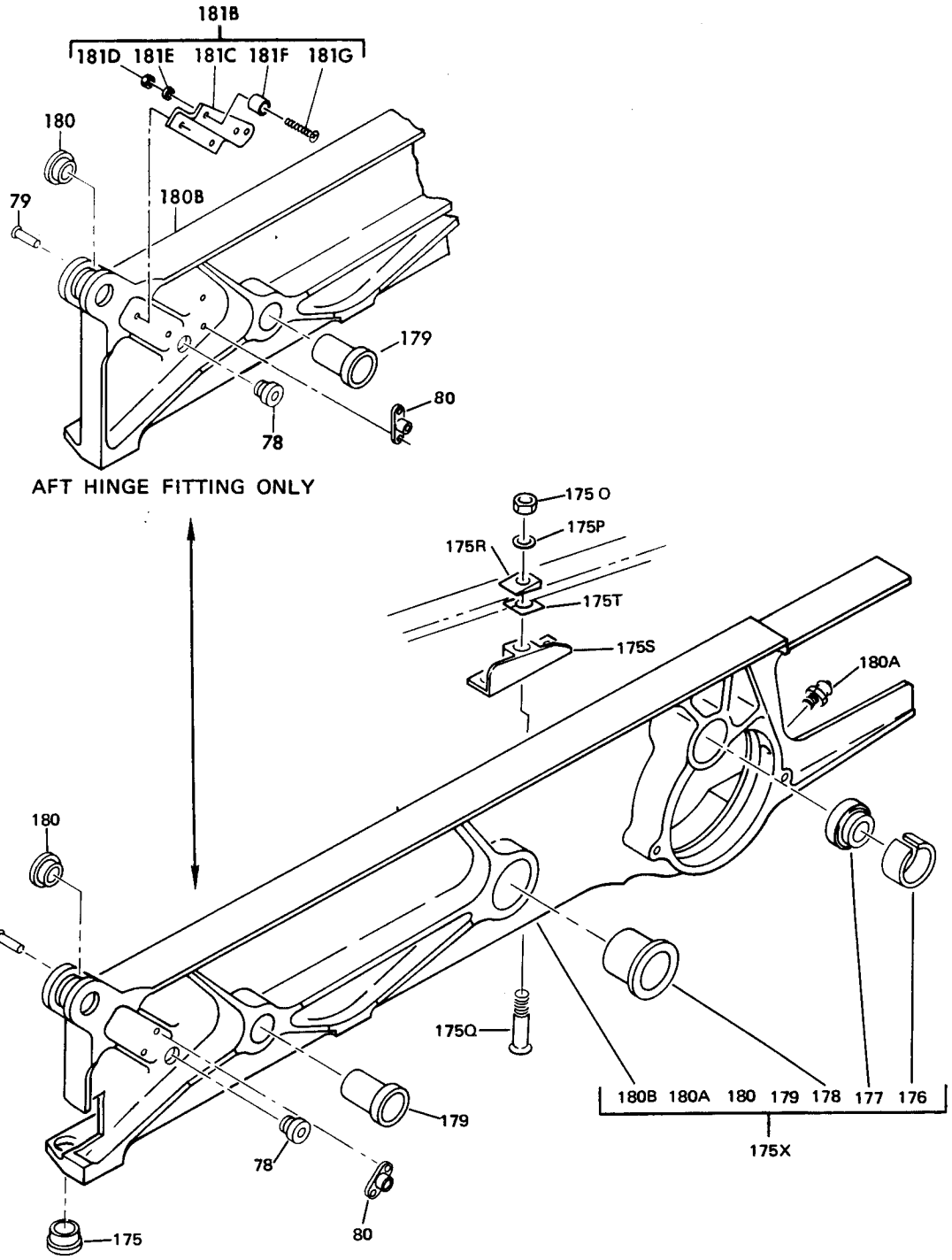


Upper Ladder Assembly
Figure 1110 (Sheet 10)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78
AFT HINGE FITTING ONLY
175 O
175P
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180B 180A 180 179 178 177 176
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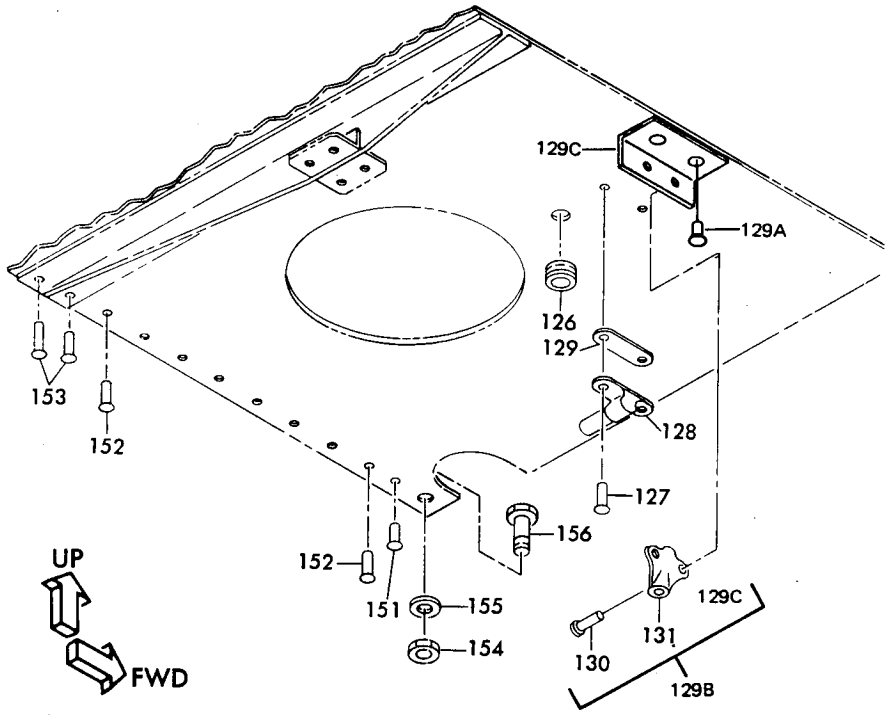
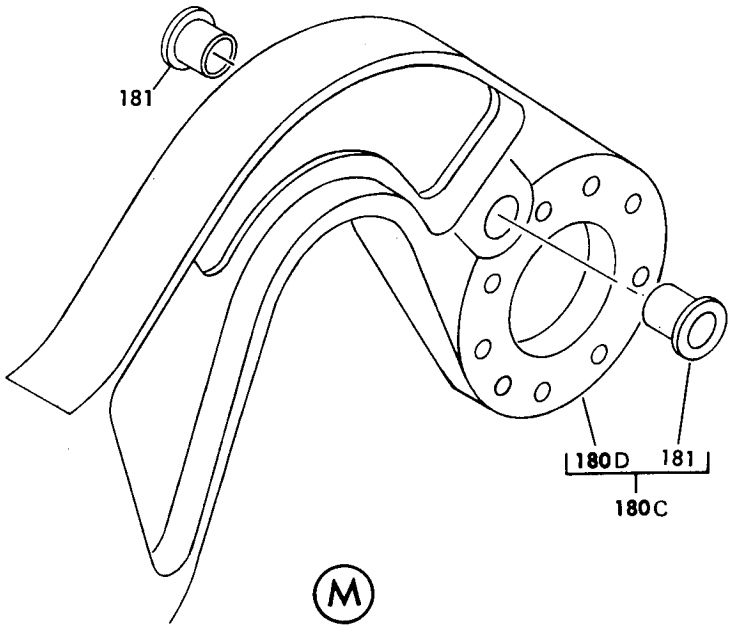




Upper Ladder Assembly
Figure 1110 (Sheet 12)

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1110					
	65-58168-1		UPPER LADDER ASSY	A	Ref
	65-58168-31		UPPER LADDER ASSY	B	Ref
1	BACB30LU3-9		. BOLT		12
1A	AN960PD10		. WASHER (SB 52-1045)		3
1B	BACN10JC3		. NUT (SB 52-1045)		3
2	NAS623-3-1		. BOLT		12
3	AN960PD10L		. WASHER		12
3A	NAS623-3-1		. BOLT *[1]		3
3B	AN960PD10L		. WASHER		3
3C	NAS623-3-2		. BOLT (SB 52-1045)		3
4	BACB30NE3-2		. BOLT (REPLS NAS1303-2)		3
5	AN960PD10L		. WASHER		3
5A	BACB30NE3-2		. BOLT *[1]		3
5B	AN960PD10L		. WASHER		3
5C	BACB30NE3-3		. BOLT (SB 52-1045)		3
6	65-58164-24		. TREAD ASSY *[1]	A	2
6	65-58164-3		. TREAD ASSY *[1]	A	2
6	65-58164-29		. TREAD ASSY (REPLS 65-58164-3 AND -24)	A	2
6	65-58164-29		. TREAD ASSY *[1]	B	2
6	65-58164-46		. TREAD ASSY (REPLS 65-58164-29)	B	2
7	BACN10FX2		. . NUT, CLIP		3
8	BACB30LU2-2		. . BOLT (USED ON 65-58164-29,-46)		5
9	69-56497-2		. . BULLNOSE (USED ON 65-58164-29, -46)		1
9	69-56497-1		DELETED		
10	MS20426D3		. . RIVET (USED ON 65-58164-29,-46)		1
11	BACN10KB08FR		. . NUTPLATE (REPLS NAS687A08K) USED ON 65-58164-29,-46)		2
12	BACN10JR08FR		. . NUTPLATE (REPLS NAS686A08K) (USED ON 65-58164-29,-46)		3
13	65-58164-36		. . NONSKID (USED ON 65-58164-29, -46)		1
13	65-58164-12		. . NONSKID (USED ON 65-58164-3,-24)		1
14	BACR15CE5D2		. . RIVET		12
15	65-58164-15		. . STRAP		1
16	BACR15DJ5-2		. . RIVET (USED ON 65-58164-3)		24
16	BACR15DJ5-2		. . RIVET (USED ON 65-58164-24,-29, -46)		18
17	69-52290-1		. . STRAP (USED ON 65-58164-24,-29, -46)		1
17	65-58164-16		. . STRAP (USED ON 65-58164-3)		1
18	65-58164-37		. . SPOTWELD ASSY (USED ON 65-58164-29)		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1110					
18	65-58164-43		. . SPOTWELD ASSY (USED ON 65-53164-46)		1
18	65-58164-8		. . SPOTWELD ASSY (USED ON 65-58164--3,-24)		1
19	BACB30NE3-1		. BOLT (REPLS NAS1303-1)		6
19	BACB30NE3-2		. BOLT (REPLS NAS1303-2)		6
20	AN960PD10L		. WASHER		6
21	65-58164-1		. TREAD ASSY *[1]	A	2
21	65-58164-22		. TREAD ASSY *[1]	A	2
21	65-58164-28		. TREAD ASSY (REPLS 65-58164 AND -22)	A	2
21	65-58164-28		. TREAD ASSY *[1]	B	1
21	65-58164-45		. TREAD ASSY (REPLS 65-58164-28)	B	1
22	BACN10FX2		. . NUT, CLIP		3
23	BACB30LU2-2		. . BOLT (USED ON 65-58164-28,-45)		5
24	69-56497-2		. . BULLNOSE (USED ON 65-58164-28, -45)		1
24	69-56497-1		DELETED		
25	MS20426D3		. . RIVET (USED ON 65-58164-28,-45)		10
26	BACN10KB08FR		. . NUTPLATE (REPLS NAS687A08K) (USED ON 65-58164-28,-45)		2
27	BACN10JR08FR		. . NUTPLATE (REPLS NAS686A08K) (USED ON 65-58164-28,-45)		3
28	65-58164-36		. . NONSKID (USED ON 65-58164-28,-45)		1
28	65-58164-12		. . NONSKID (USED ON 65-58164-1,-22)		1
29	BACR15CE5D2		. . RIVET		12
30	65-58164-15		. . STRAP		1
31	BACR15DJ5-2		. . RIVET (USED ON 65-58164-1)		24
31	BACR15DJ5-2		. . RIVET (USED ON 65-58164-22,-28, -45)		18
32	65-58164-16		. . STRAP (USED ON 65-58164-1)		1
32	69-52290-1		. . STRAP (USED ON 65-58164-22,-28, -45)		1
33	65-58164-37		. . SPOTWELD ASSY (USED ON 65-58164-28)		1
33	65-58164-43		. . SPOTWELD ASSY (USED ON 65-58164-45)		1
33	65-58164-8		. . SPOTWELD ASSY (USED ON 65-58164-1,-22)		1
34	NAS623-3-5		. BOLT		16
35	AN960PD10L		. WASHER		16
36	808512-401		. LIGHT, V92824		8
37	MS20426D3		. RIVET	A	32
37	MS20426D3		. RIVET	B	32

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1110					
38	BACN10KB3F		. NUTPLATE (REPLS BACN10FX1)		16
39	BACN10FX1		. NUT, CLIP *[1]	A	16
40	BACN10JC4		. NUT (REPLS NAS679A4W)		2
41	AN960C416L		. WASHER		2
42	NAS1104-7		. BOLT		2
43	BACN10BL4L		. NUT		4
44	MS20002-4		. WASHER		4
45	BACB30NE4-9		. BOLT (REPLS NAS1304-9)		4
46	BACN10JC4		. NUT (REPLS NAS679A4W)		2
47	AN960C416L		. WASHER		2
48	NAS1104-6		. BOLT		2
49	BACN10JC4		. NUT (REPLS NAS679A4W)		2
50	AN960C416L		. WASHER		2
51	NAS1104-9		. BOLT		2
52	BACN10JC4		. NUT (REPLS NAS679A4W)		2
53	AN960C416L		. WASHER		2
54	NAS1104-8		. BOLT		2
55	65-59346-1		. TRACK ASSY (FWD)		1
56	BACC30K8		. . COLLAR		1
57	BACB30GY8-6		. . LOCKBOLT		1
58	BACC30K6		. . COLLAR		1
59	BACB30GY6-6		. . LOCKBOLT		1
60	69-48715-1		. . INSERT		1
61	69-48715-3		. . SHIM, LAMINATED		1
62	BACS40R8B18		. . SHIM, LAMINATED		1
63	65-59346-3		. . TRACK		1
64	65-59346-2		. TRACK ASSY (AFT)		1
65	BACC30K8		. . COLLAR		1
66	BACB30GY8-6		. . LOCKBOLT		1
67	BACC30K6		. . COLLAR		1
68	BACB30GY6-6		. . LOCKBOLT		1
69	69-48715-2		. . INSERT		1
70	69-48715-3		. . SHIM, LAMINATED		1
71	BACS40R8B18		. . SHIM, LAMINATED		1
72	65-59346-4		. . TRACK		1
73	BACS40R12E42		. SHIM		2
74	BACS40R12C94		. SHIM		2
75	NAS1368N6A		. GROMMET		2
76	MS20470D4		. RIVET		6
77	BACN10MK3-45		. NUTPLATE		3
78	NAS1368N6B		. GROMMET (REPLS NAS1368N4B)		1
79	MS20426D3		. RIVET		2
80	BACN10MS3-6		. NUTPLATE		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1110					
81	BACN10CP4L		. NUT (USED ON FWD SIDE)		1
82	AN960D416L		. WASHER (USED ON FWD SIDE)		1
83	BACB30NE4-5		. BOLT (REPLS NAS1304-5)(USED ON FWD SIDE)		1
84	BACN10HC4		. NUT (USED ON AFT SIDE)		1
85	MS20002C4		. WASHER (USED ON AFT SIDE)		1
86	BACB30MT4T7		. BOLT (USED ON AFT SIDE)		1
87	BACN10JC3		. NUT (REPLS NAS679A3W) *[2]		1
88	AN960PD10		. WASHER *[2]		1
89	BACB30LU3-10		. BOLT *[2]		1
90	BACN10HC4		. NUT *[2]		1
91	MS20002C4		. WASHER *[2]		1
92	BACB30MT4T8		. BOLT *[2]		1
93	BACN10BL4L		. NUT		4
94	MS20002-4		. WASHER		4
95	BACB30NE4-6		. BOLT (REPLS NAS1304-6)		4
95	NAS1304-6		. BOLT		4
96	BACN10JC4		. NUT (REPLS NAS679A4W)		14
96	NAS679A4W		. NUT		14
97	AN960C416L		. WASHER		14
98	NAS1104-7		. BOLT		2
99	NAS1104-6		. BOLT		2
100	NAS1104-5		. BOLT		10
101	65-59345-1		. TRACK ASSY (FWD)		1
102	MS20426D3		. . RIVET		2
103	BACN10KB4		. . NUTPLATE		1
104	BACC30K6		. . COLLAR		1
105	BACB30GY6-6		. . LOCKBOLT		1
106	BACC30K8		. . COLLAR		1
107	BACB30GY8-6		. . LOCKBOLT		1
108	69-48715-1		. . INSERT		1
109	69-48715-3		. . SHIM, LAMINATED		1
110	BACS40R8B18		. . SHIM, LAMINATED		1
111	65-59345-3		. . TRACK		1
112	65-59345-2		. TRACK ASSY (AFT)		1
112	65-59345-6		. TRACK ASSY (AFT) *[1]	B	1
113	MS20426D3		. . RIVET		2
114	BACN10KB4		. . NUTPLATE		1
115	BACC30K6		. . COLLAR		1
116	BACB30GY6-6		. . LOCKBOLT		1
117	BACC30K8		. . COLLAR		1
118	BACB30GY8-6		. . LOCKBOLT		1
119	69-48715-2		. . INSERT		1
120	69-48715-3		. . SHIM, LAMINATED		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1110					
121	BACS40R8B18		. . SHIM, LAMINATED		1
122	65-59345-4		. . TRACK (USED ON 65-59345-2)		1
122	65-59345-8		. . TRACK (USED ON 65-59345-6)		1
123	BACS40R12C103		. SHIM		2
124	BACS40R12D75		. SHIM		2
125	BACB28Y8B43		. BUSHING		2
126	NAS1368N6A		. GROMMET		1
127	MS20470D3		. RIVET		2
128	BACN10DZ3-40		. NUT, SPACER PLATE		1
129	NAS463XDD416H		. SHIM, ANCHOR NUT		1
129A	BACR15BB5D		. RIVET (REPLS MS20470D5)		2
129B	69-25236-20		. BRACKET ASSY		1
129C	69-25236-11		. . BRACKET		1
130	BACR15BB4D		. . RIVET (REPLS MS20470D4)		2
131	BACN10MK3-45		. . NUTPLATE		1
132	MS20470D6		. RIVET	B	4
133	MS20470D5		. RIVET	B	7
134	BACN10JC3		. NUT (REPLS NAS679A3W)	B	4
135	NAS620-10		. WASHER	B	4
136	65-58168-33		. FILLER	B	2
137	NAS1103-6		. BOLT	B	4
138	69-55173-1		. BRACKET ASSY	B	1
139	BACB28W5B10		. . BUSHING		1
140	BACB28U5B20		. . BUSHING		1
141	MS20426A4		. . RIVET		4
142	69-55173-5		. . RUBSTRIP		2
143	NAS1080-6		. . COLLAR		2
144	BACB30DX6-4		. . LOCKBOLT		2
145	69-55173-6		. . ANGLE		2
146	BACR15CE6D		. . RIVET		2
147	69-55173-4		. . FILLER		1
148	MS20470D6		. . RIVET		3
149	69-55173-3		. . ANGLE		1
150	69-55173-2		. . ANGLE		1
150A	69-55174-3		. BRACKET	B	1
151	BACR15CE5D		. RIVET		2
152	MS20470D5		. RIVET		AR
153	MS20470D6		. RIVET	A	2
154	BACN10JC3		. NUT (REPLS NAS679A3W)		2
154	NAS679A3W		. NUT		2
155	AN960PD10		. WASHER		2
156	BACB30LU3-4		. BOLT		2
157	BACC30M6		. COLLAR		2
158	BACB30FN6-4		. LOCKBOLT		2

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1110					
159	BACR15CE5B		. RIVET		10
160	BACR15CE6D		. RIVET (PREFERRED TO BACR15DJ6-3)	B	1
160	BACR15DJ6-3		. RIVET (OPT TO BACR15CE6D)	B	1
161	65-61771-34		. ANGLE		1
162	MS20470D5		. RIVET		7
163	BACR15CE5D		. RIVET		5
164	MS20470D6		. RIVET	B	1
165	BACC30M6		. COLLAR		2
166	BACB30FM6-4		. LOCKBOLT		2
166A	BACR15BB5D		. RIVET (REPLS MS20470D5)		8
166B	BACB30FM6-5		. LOCKBOLT		2
166C	BACC30M6		. COLLAR		2
166D	BACR15CE5D		. RIVET		16
166E	BACR15CE6D		. RIVET		2
166F	65-61771-35		. ANGLE		1
167	65-58164-5		. RISER ASSY *[1]	A	1
167	65-58164-38		. RISER ASSY (REPLS 65-58164-5)	A	1
167	65-58164-38		. RISER ASSY *[1]	B	1
167	65-58164-53		. RISER ASSY (REPLS 65-58164-38)	B	1
168	MS20426D3		. . RIVET		8
169	BACN10JR3F		. . NUTPLATE (REPLS NAS686A3)		4
170	MS20470D5		. . RIVET (USED ON 65-58164-38)		28
171	65-58164-39		. . DOUBLER (USED ON 65-58164-38,-53)		2
172	65-58164-9		. . SPOTWELD ASSY (USED ON 65-58164-5,-38)		1
172	65-58164-44		. . SPOTWELD ASSY (USED ON 65-58164-53)		1
172A	BACB30LB6-5		. LOCKBOLT		2
172B	BACB30LA6-5		. LOCKBOLT		2
172C	BACB30FN6-3		. LOCKBOLT		4
172D	BACC30M6		. COLLAR		8
172E	BACR15CE5D		. RIVET		20
172F	69-49782-2		. TEE		1
172G	65-61771-33		. ANGLE		1
172H	65-61771-46		. STIFFENER		1
172I	BACN10JC4		. NUT (REPLS NAS679A4W)		4
172J	AN960C416L		. WASHER		4
172K	NAS1104-5		. BOLT		4
172L	BACR15BB5D		. RIVET (REPLS MS20470D5)		6
172M	65-61771-36		. ANGLE		1
172N	BACR15BE5D		. RIVET		4
172O	BACR15BB5D		. RIVET		6

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1110					
172P	65-58164-6		. RISER ASSY *[1]	A	1
172P	65-58164-33		. RISER ASSY (REPLS 65-58164-6)	A	1
172P	65-58164-33		. RISER ASSY *[1]	B	1
172P	65-58164-50		. RISER ASSY (REPLS 65-58164-33)	B	1
172Q	BACB30LA8-4		. BOLT, BLIND		2
172R	BACB30LB8-4		. BOLT, BLIND		2
173	MS20470D4		. RIVET		2
173A	65-85860-11		. SHIM (SB 52-1045)*[1]		2
173B	BACB30LL3-8		. BOLT (SB 52-1045)*[1]		8
173C	BACN10JC4		. NUT (SB 52-1045)*[1]		8
173D	AN960PD10		. WASHER (SB 52-1045)*[1]		8
173E	*[3]		. SHIM (REWORKED FROM 65-85860-5 BY SB 52-1045)*[1]		2
174	BACN10MK3-65		. NUTPLATE		1
174A	BACN10JC4		. NUT (SB 52-1067)		4
174B	AN960PD416L		. WASHER (SB 52-1067)		4
174C	NAS1104-4		. BOLT (SB 52-1067)		4
174D	65-58168-34		. ANGLE (SB 52-1067)		1
174E	69-49782-4		. TEE (DELETED BY SB 52-1067)		1
174F	65-61771-33		. ANGLE (DELETED BY SB 52-1067)		1
174G	65-61771-49		. STIFFENER (DELETED BY SB 52-1067)		1
174G	65-61771-50		. STIFFENER (DELETED BY SB 52-1067)		1
174H	BACR15BB5D		. RIVET (DELETED BY SB 52-1067)		6
174I	BACN10JC3		. NUT (SB 52-1045)		56
174J	AN960PD10		. WASHER (SB 52-1045)		56
174K	BACW10CT6CU		. WASHER (SB 52-1045)		14
174L	BACB30LL3-6		. BOLT (SB 52-1045) *[1]		16
174L	BACB30LL3-8		. BOLT (SB 52-1045) *[1]		16
174M	BACB30LL3-4		. BOLT (SB 52-1045)		10
174N	BACB30LK3-5		. BOLT (SB 52-1045)		6
174O	BACB30LL3-5		. BOLT (SB 52-1045)		6
174P	BACB30LL3-2		. BOLT (SB 52-1045)		18
174Q	BACB30LK3-3		. BOLT (SB 52-1045)		8
174R	65-85860-5		. SHIM (SB 52-1045)*[1]		2
174S	65-85860-9		. SHIM (SB 52-1045)		AR
174S	65-85860-6		. SHIM (SB 52-1045)		AR
174T	BACN10JC3		. NUT (SB 52-1045)		4
174U	AN960PD10		. WASHER (SB 52-1045)		4
174V	BACB30LK3-4		. BOLT (SB 52-1045)		2
174W	BACB30LL3-2		. BOLT (SB 52-1045)		2
174X	BACN10JR3F		. NUTPLATE		8
174Y	BACR15BA3D1		. RIVET		16

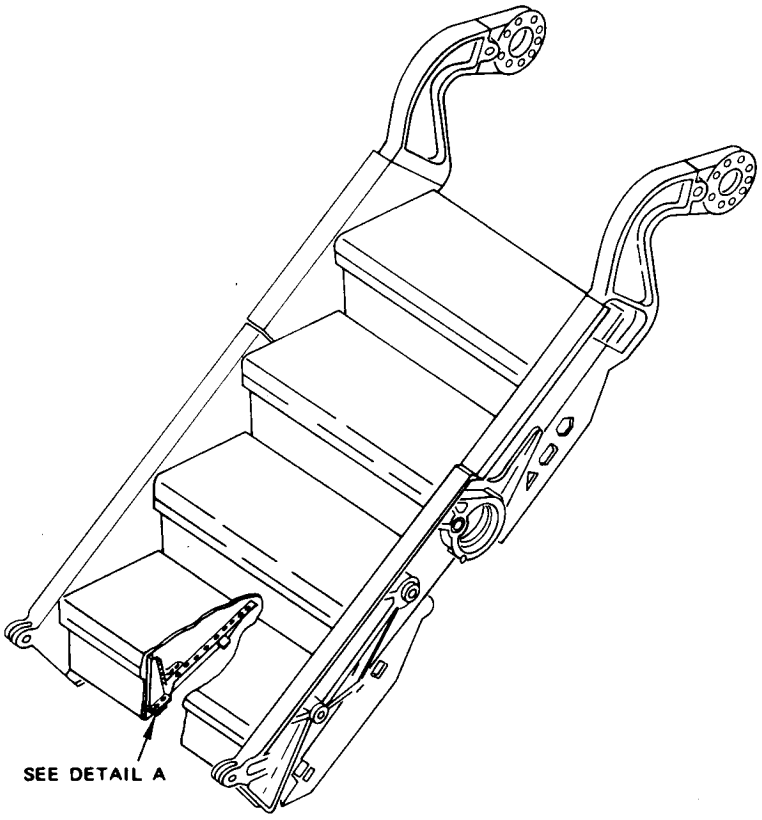
FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1110					
175	BACB28X8B21		. BUSHING		2
175A	65-85872-1		. REINFORCEMENT (SB 52-1045) (DELETED BY SB 52-1067)		1
175A	65-85872-14		. REINFORCEMENT (SB 52-1045) (DELETED BY SB 52-1067)		1
175B	BACS40R10C55F		. SHIM (SB 52-1045)		1
175C	BACN10JC4		. NUT (SB 52-1045)		2
175D	AN960-416		. WASHER (SB 52-1045)		2
175E	BACB30LK4-11		. BOLT (SB 52-1045)		2
175F	BACN10JC5		. NUT (SB 52-1045)		2
175G	AN960-516		. WASHER (SB 52-1045)		2
175H	BACB30LK5-5		. BOLT (SB 52-1045)		2
175I	BACN10JC3		. NUT (SB 52-1045)		15
175J	AN960C10		. WASHER (SB 52-1045)		15
175K	BACB30NE3-3		. BOLT (SB 52-1045)		15
175L	65-85872-11		. STIFFENER (SB 52-1045)*[1]		1
175M	BACS40R12B30F		. SHIM (SB 52-1045)		1
175N	65-85860-2		. SEPARATOR (SB 52-1045)		1
175O	BACN10JC4		. NUT (REPLS NAS679A4W)		1
175P	AN960PD416		. WASHER		1
175Q	BACB30LU4-22		. BOLT		1
175R	69-55957-2		. FILLER		1
175S	69-55957-1		. FITTING		1
175T	BACS40R7C8		. SHIM		1
175U	BACN10JC3		. NUT (SB 52-1045)		2
175V	AN960PD10		. WASHER (SB 52-1045)		2
175W	BACB30LK3-2		. BOLT (SB 52-1045)		2
175X	65-59344-1		. FITTING ASSY, HINGE (AFT) (REPLD BY 65C14993-7 or -16 PER SB 52-1067)		1
175X	65-59344-2		. FITTING ASSY, HINGE (FWD) (REPLD BY 65C14993-8 or -17 PER SB 52-1067)		1
175X	65-59344-5		. FITTING ASSY, HINGE (AFT) (REPLD BY 65C14993-7 or -16 PER SB 52-1067)		1
175X	65-59344-9		. FITTING ASSY, HINGE (AFT) (REPLD BY 65C14993-7 or -16 PER SB 52-1067)		1
175X	65-59344-10		. FITTING ASSY, HINGE (FWD) (REPLD BY 65C14993-8 or -17 PER SB 52-1067)		1

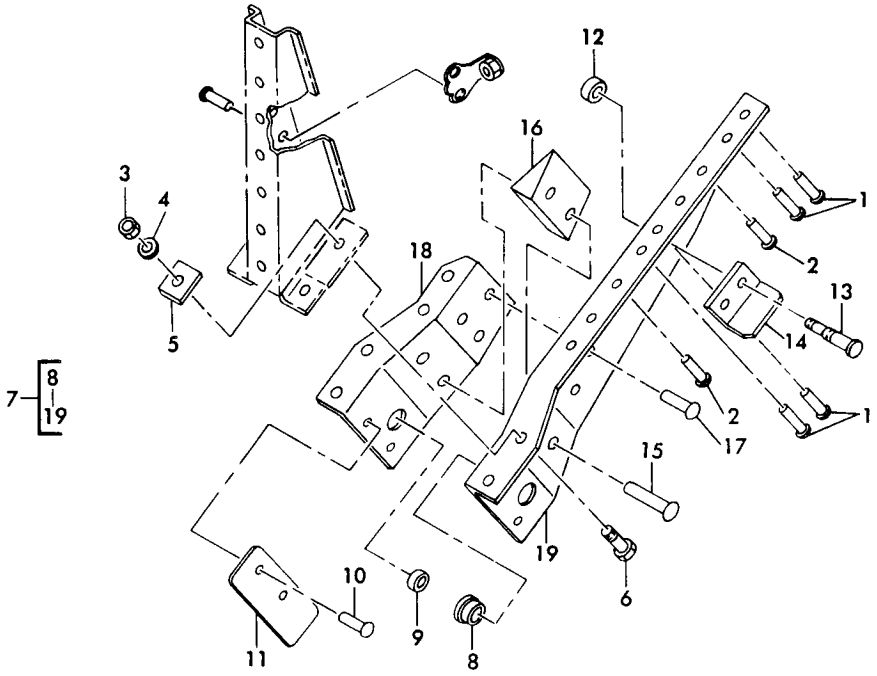
FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1110					
175X	65-59344-13		. FITTING ASSY, HINGE (AFT) (REPLD BY 65C14993-7 or -16 PER SB 52-1067		1
175X	65-59344-14		. FITTING ASSY, HINGE (FWD) (REPLD BY 65C14993-8 or -17 PER SB 52-1067)		1
175X	65C14993-7		. FITTING ASSY, HINGE (AFT) (OPT) (SB 52-1067)		1
175X	65C14993-8		. FITTING ASSY, HINGE (FWD) (OPT) (SB 52-1067)		1
175X	65C14993-16		. FTTING ASSY, HINGE (AFT) (OPT) (SB 52-1067)		1
175X	65C14993-17		. FITTING ASSY, HINGE (FWD) (OPT (SB 52-1067)		1
175X	65-59344-19		. FITTING ASSY, HINGE (AFT) (PREF)	B	1
175X	65-59344-20		. FITTING ASSY, HINGE (FWD) (PREF)	B	1
176	69-49723-1		. . RETAINER, RING		2
177	BACB10A685		. . BEARING		2
178	69-48220-1		. . BUSHING		2
179	BACB28W20B342		. . BUSHING		2
180	BACB28X6B20		. . BUSHING		4
180A	NAS516-1		. . FITTING, LUBRICATION		1
180B	65-59344-3		. . FITTING (USED ON 65-59344-1)		1
180B	65-59344-4		. . FITTING (USED ON 65-59344-2)		1
180B	65-59344-7		. . FITTING (USED ON 65-59344-5)		1
180B	65-59344-11		. . FITTING (USED ON 65-59344-9)		1
180B	65-59344-12		. . FITTING (USED ON 65-59344-10)		1
180B	65-59344-17		. . FITTING (USED ON 65-59344-13)		1
180B	65-59344-18		. . FITTING (USED ON 65-59344-14)		1
180B	*[3]		. . FITTING (USED ON 65C14993-7) (REWORKED FROM 65-59344-3, -7,-11,-17 PER SB 52-1067)		1
180B	*[3]		. . FITTING (USED ON 65C14993-8) (REWORKED FROM 65-59344-4, -12,-18 PER SB 52-1067)		1
180B	65-59344-21		. . FITTING (USED ON 65-59344-19 AND 65C14993-16)		1
180B	65-59344-22		. . FITTING (USED ON 65-59344-20 AND 65C14993-17)		1
180C	65-55755-5		. ARM ASSY, HINGE (AFT)(REPLD BY 65C14993-5 or -14 PER SB 52-1067)		1
180C	65-55755-6		. ARM ASSY, HINGE (FWD) (REPLD BY 65C14993-6 or -15 PER SB 52-1067)		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1110					
180C	65C14993-5		. ARM ASSY, HINGE (AFT)(OPT) (SB 52-1067)		1
180C	65C14993-6		. ARM ASSY, HINGE (FWD)(OPT) (SB 52-1067)		1
180C	65C14993-14		. ARM ASSY, HINGE (AFT)(OPT) (SB 52-1067)		1
180C	65C14993-15		. ARM ASSY, HINGE (FWD)(OPT) (SB 52-1067)		1
180C	65-55755-9		. ARM ASSY, HINGE (AFT)(PREF)	B	1
180C	65-55755-10		. ARM ASSY, HINGE (FWD)(PREF)	B	1
180D	65-55755-7		. . ARM (USED ON 65-55755-5)		1
180D	65-55755-8		. . ARM (USED ON 65-55755-6)		1
180D	*[3]		. . ARM (USED ON 65C14993-5) (REWORKED FROM 65-55755-5 PER SB 52-1067)		1
180D	*[3]		. . ARM (USED ON 65C14993-6) (REWORKED FROM 65-55755-6 PER SB 52-1067)		1
180D	65-55755-11		. . ARM (USED ON 65-55755-9 AND 65C14993-14)		1
180D	65-55755-12		. . ARM (USED ON 65-55755-10 AND 65C14993-15)		1
181	BACB28X16B75		. BUSHING		4
181A	BACR15CE51B		. RIVET (SB 24-1016)		2
181B	69-61351-1		. BRACKET ASSY (SB 24-1016)		1
181C	69-61351-2		. . BRACKET		1
181D	BACN10JC3		. . NUT		1
181E	AN960PD10		. . WASHER		1
181F	BACS18K10-33		. . SPACER		1
181G	BACB30LU3-9		. . BOLT		1
182	BACB30FN6-4		. LOCKBOLT		2
183	BACC30M6		. COLLAR		2
184	BACR15CE5B		. RIVET		6
185	BACR15BB5D		. RIVET		6
186	BACR15CE5D		. RIVET		2
187	BACR15CE5D		. RIVET *[1]		2
188	BACB30FM6-4		. LOCKBOLT *[1]		2
189	BACC30M6		. COLLAR *[1]		2
190	BACR15BB5D		. RIVET		6
191	BACB30FM6-2		. LOCKBOLT		2
192	BACC30M6		. COLLAR		2
193	65-58165-4		. ANGLE		1
194	65-58164-4		. RISER ASSY *[1]	A	1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1110					
194	65-58164-31		. RISER ASSY (REPLS 65-58164-4)	A	1
194	65-58164-31		. RISER ASSY *[1]	B	1
194	65-58164-48		. RISER ASSY (REPLS 65-58164-31)	B	1
195	BACB30FN6-3		. LOCKBOLT		2
196	BACC30M6		. COLLAR		2
197	BACB30FM6-2		. LOCKBOLT		2
198	BACC30M6		. COLLAR		2
199	BACR15CE5B		. RIVET		6
200	69-49782-3		. TEE		1
201	BACR15BB5D		. RIVET		6
202	BACR15CE5D		. RIVET		4
203	BACB30FM6-3		. LOCKBOLT		2
204	BACC30M6		. COLLAR		2
205	BACR15BB5D		. RIVET		6
206	65-58164-5		. RISER ASSY *[1]	A	1
206	65-58164-38		. RISER ASSY (REPLS 65-58164-5)	A	1
206	65-58164-38		. RISER ASSY *[1]	B	1
206	65-58164-53		. RISER ASSY (REPLS 65-58164-38)	B	1
207	BACB30FM6		. LOCKBOLT		2
208	BACC30M6		. COLLAR		2
209	65-58165-16		. ANGLE		1
210	65-61771-45		. CHANNEL		1
211	65-58168-23		. ANGLE		1
212	BACB30FM6-12		. LOCKBOLT		2
213	BACC30M6		. FILLER		2

*[1] LIMITED USE
*[2] USE ON AFT BEAM OF REWORKED ASSEMBLIES ONLY
*[3] NO BOEING ASSIGNED PART NUMBER



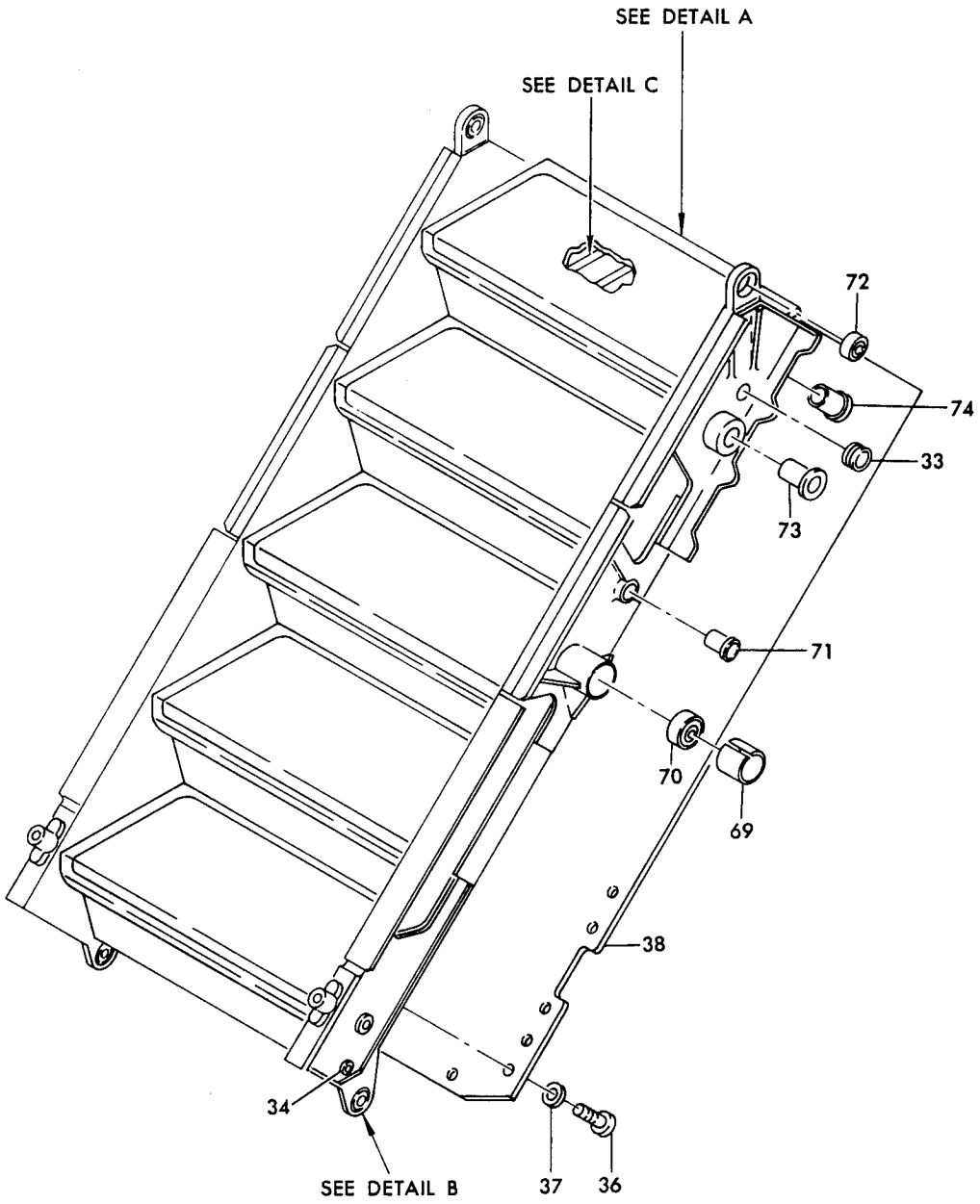


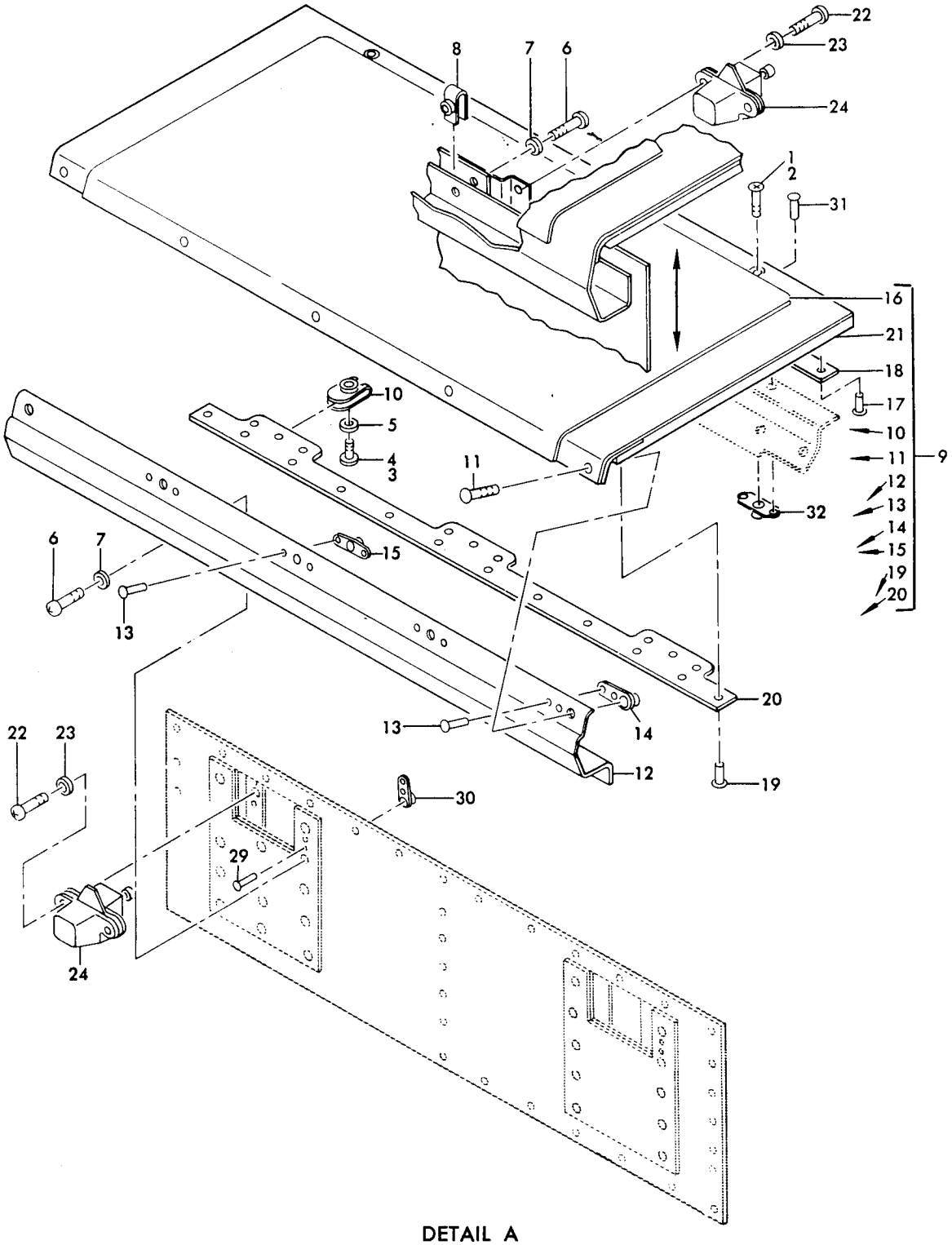
DETAIL A

Upper Ladder Assembly
Figure 1111

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1111	65-68957-1		UPPER LADDER ASSY		RF
1	MS20470D6		. RIVET		4
2	MS20470D5		. RIVET		7
3	BACN10JC3		. NUT (REPLS NAS679A3W)		4
3	NAS679A3W		. NUT		4
4	NAS620-10		. WASHER		4
5	65-68957-2		. FILLER		2
6	NAS1103-6		. BOLT		4
7	69-55173-1		. BRACKET ASSY		1
8	BACB28W5B10		. . BUSHING		1
9	BACB28U5B20		. . BUSHING		1
10	MS20426A4		. . RIVET		4
11	69-55173-5		. . RUBSTRIP		2
12	NAS1080-6		. . COLLAR		2
13	BACB30DX6-4		. . LOCKBOLT		2
14	69-55173-6		. . ANGLE		2
15	BACR15CE6D		. . RIVET		2
16	69-55173-4		. . FILLER		1
17	MS20470D6		. . RIVET		3
18	69-55173-3		. . ANGLE		1
19	69-55173-2		. . ANGLE		1
20	65-58168-1		. LADDER ASSY (FIG. 1110)		1

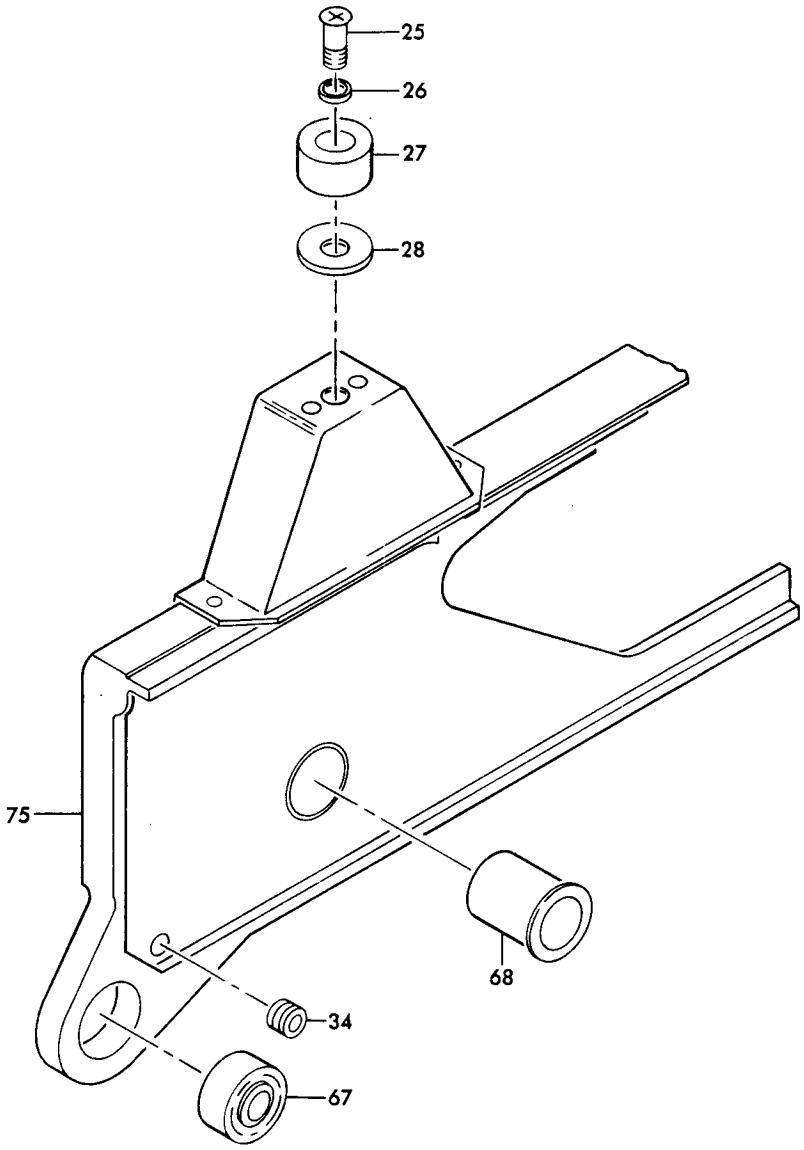
23. Exploded View



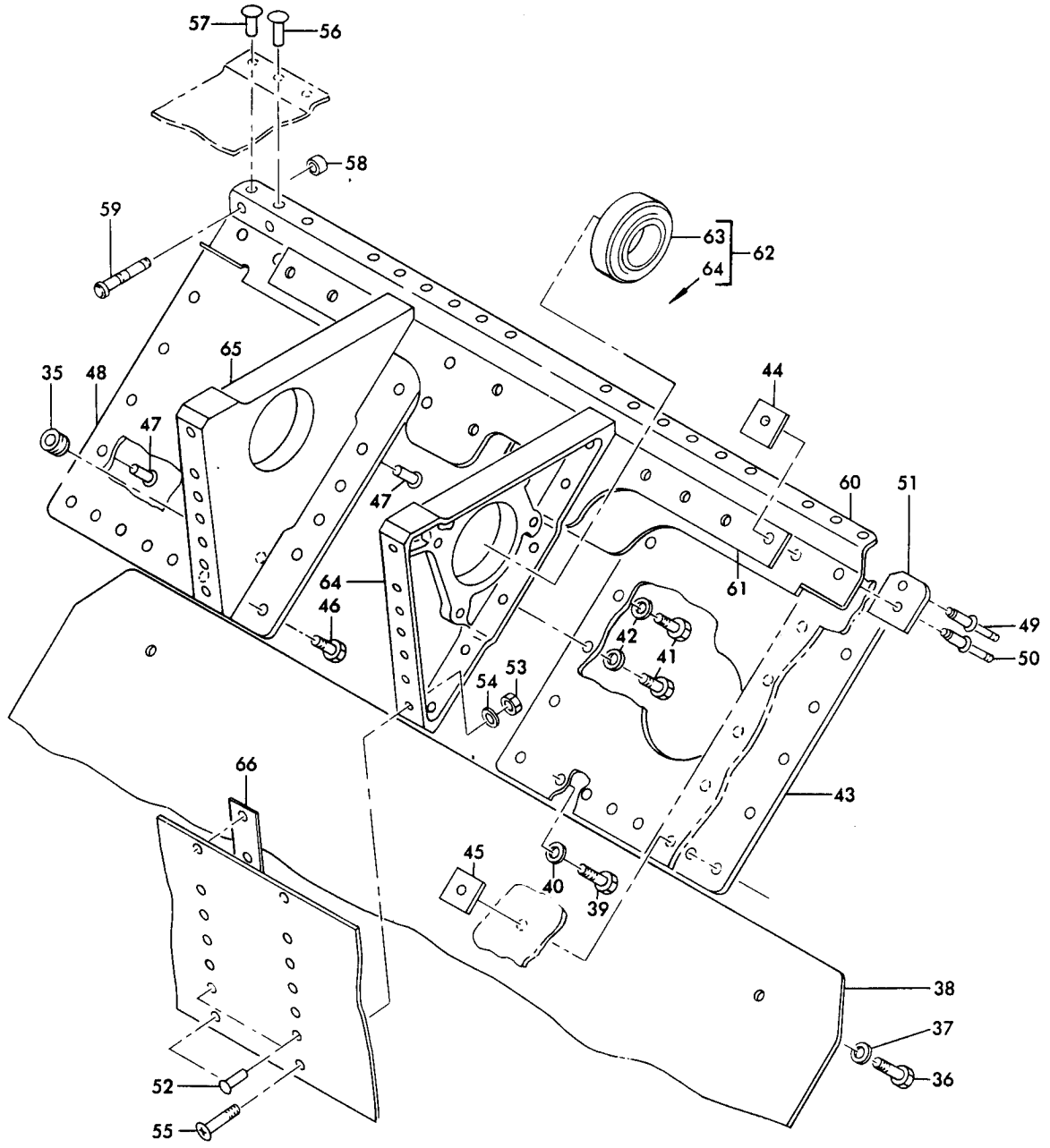


DETAIL A

Center Ladder Assembly
Figure 1112 (Sheet 2)



DETAIL B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DETAIL C

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1112					
	65-58169-30		CENTER LADDER ASSY	A	
	65-58169-1		CENTER LADDER ASSY	B	
1	BACB30LU3-9		. BOLT (USED WITH UPPER THREAD ASSY ONLY)	A	3
2	BACB30LU3-7		. BOLT (USED WITH 4 LOWER THREAD ASSY)	A	12
2	BACB30LU3-7		. BOLT	B	15
3	BACB30NE3-5		. BOLT (REPLS NAS1303-5) (USED WITH UPPER TREAD ASSY ONLY)	A	3
3	NAS1303-5		. BOLT (USED WITH UPPER TREAD ASSY ONLY)	A	3
4	BACB30NE3-2		. BOLT (REPLS NAS1303-2) (USED WITH 4 LOWER TREAD ASSY)	A	12
4	NAS1303-2		. BOLT	A	12
4	BACB30NE3-2		. BOLT (REPLS NAS1303-2)	A	15
4	NAS1303-2		. BOLT	B	15
5	AN960D10L		. WASHER		15
6	NAS623-3-1		. BOLT		20
7	AN960PD10L		. WASHER		20
8	BACN10FX2		. NUT, CLIP *[1]		20
9	65-58164-45		. TREAD ASSY (REPLS 65-58164-28)	A	5
9	65-58164-23		. TREAD ASSY *[1]		5
9	65-58164-22		. TREAD ASSY *[1]	B	5
9	65-58164-1		. TREAD ASSY *[1]	B	5
10	BACN10FX2		. . NUT, CLIP		3
11	BACB30LU2-2		. . BOLT (USED ON 65-58164-28-45)		5
12	69-56497-2		. . BULLNOSE (USED ON 65-58164-28-45)		1
12	69-56497-1		DELETED		
13	MS20426D3		. . RIVET (USED ON 65-58164-28-45)		AR
14	BACN10K08FR		. . NUTPLATE (REPLS NAS687A08K (USED ON 65-58164-28,-45)		2
15	BACN10JR-8FR		. . NUTPLATE (REPLS NA5686A08K) (USED ON 65-58164-28,-45)		3
16	65-58164-36		. . NON SKID (USED ON 65-58164-28, -45)		1
16	65-58164-12		. . NON SKID (USED ON 65-58164-1 AND -22)		1
17	BACR15CE5D2		. . RIVET		12
18	65-58164-15		. . STRAP		1
19	BACR15DJ5-2		. . RIVET (USED ON 65-58164-1)		24
19	BACR15DJ5-2		. . RIVET (USED ON 65-58164-22,-28, -45)		18
20	65-58164-16		. . STRAP USED ON 65-58164-1)		1

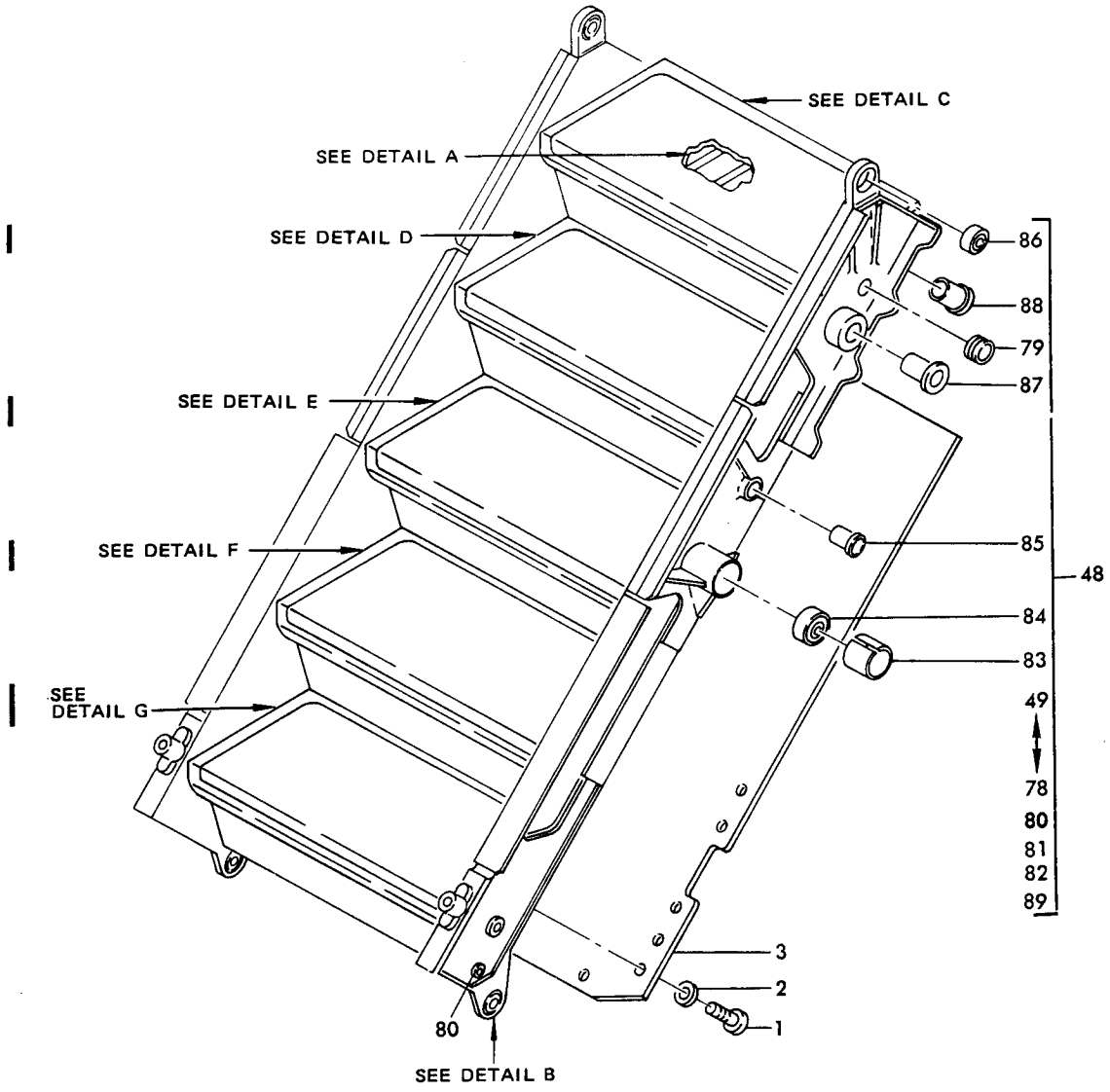
FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1112					
20	69-52290-1		. . STRAP (USED ON 65-58164-22 AND -28)		1
21	65-58165-43		. . SPOTWELD ASSY (USED ON 65-58164-45)		1
21	65-58164-37		. . SPOTWELD ASSY (USED ON 65-58164-28)		1
21	65-58164-8		. . SPOTWELD ASSY (USED ON 65-58164-1 AND -22)		1
22	NAS623-3-5		. BOLT		20
23	AN960PD10L		. WASHER		20
23	AN960C10L		. WASHER *[1]		20
24	808512-401		. LIGHT, V92824		10
25	NAS514P1032-10		. SCREW		2
26	69-59840-1		DELETED		
26	69-54840-1		. WASHER, COUNTERSUNK		2
27	69-50378-1		. BUMPER		2
28	BACW10P294AL		. WASHER		
29	MS20426D3		. RIVET		40
30	BACN10KB3F		. NUTPLATE		20
31	MS20426D3		. RIVET		30
32	BACN10JR3F		. NUTPLATE		15
33	NAS1368N6B		. GROMMET		2
34	NAS1368N4B		. GROMMET		1
35	NAS1368N8A		. GROMMET	A	1
35	NAS1368N6A		. GROMMET	B	1
36	NAS603-8P		. BOLT		AR
37	AN960PD10L		. WASHER		AR
38	65-63358-6		. COVER	A	1
38	65-63358-1		. COVER	B	1
39	BACB30NE3-7		. BOLT (REPLACES NAS1303-7)	A	20
39	NAS1303-7		. BOLT	A	20
40	AN960PD10L		. WASHER	A	20
41	BACB30NE3-2		. BOLT (REPLACES NAS1303-2)	A	2
41	NAS1303-2		. BOLT	A	2
42	AN960PD10L		. WASHER	A	2
43	65-58169-25		. WEB	A	1
44	65-58169-34		. FILLER (USED ON AFT SIDE)	A	1
45	65-58169-35		. FILLER (USED ON AFT SIDE)	A	1
46	BACB30NE3-7		. BOLT (REPLACES NAS1303-7)	A	4
46	NAS1303-7		. BOLT	A	4
47	MS20470D6		. RIVET	A	22
48	65-58169-26		. WEB	A	1
49	BACB30LA5-6		. BOLT, BLIND	A	2

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1112					
50	BACB30LB8-6		. BOLT, BLIND	A	2
51	65-58169-15		. FILLER	A	2
52	MS20470D5		. RIVET	A	12
53	BACN10JC3		. NUT	A	2
54	AN960PD10L		. WASHER	A	2
55	BACB30EL3-3		. BOLT	A	2
56	BACR15CE5D		. RIVET	A	16
57	MS20470D5		. RIVET	A	2
58	MAS1080-6		: COLLAR	A	2
59	BACB30DX6-2		. LOCKBOLT	A	2
60	69-55463-1		. ZEE	A	1
61	65-58169-32		. STRAP	A	1
62	65-68955-1		. FITTING ASSY	A	1
63	BACB10A553		. . BEARING		1
64	65-68955-2		. . FITTING		1
65	65-68958-1		. FITTING	A	1
66	BACS40A16-112		. SHIM	A	2
67	BACB10A691		. BEARING	A	2
68	BACB28W20B141		. BUSHING		2
69	69-49723-1		. RETAINER, RING		2
70	BACB10A685		. BEARING		2
71	BACB28W12B98		. BUSHING		2
72	BACB10A691		. BEARING		2
73	BACB28W20B195		. BUSHING		2
74	BACB28X12C119		. BUSHING		2
75			. LADDER ASSY STRUCTURE, CENTER		1

*[1] limited use

VENDORS

V92824 WEBER AIRCRAFT CORP., 2820 ONTARIO ST., BURBANK, CALIFORNIA 91503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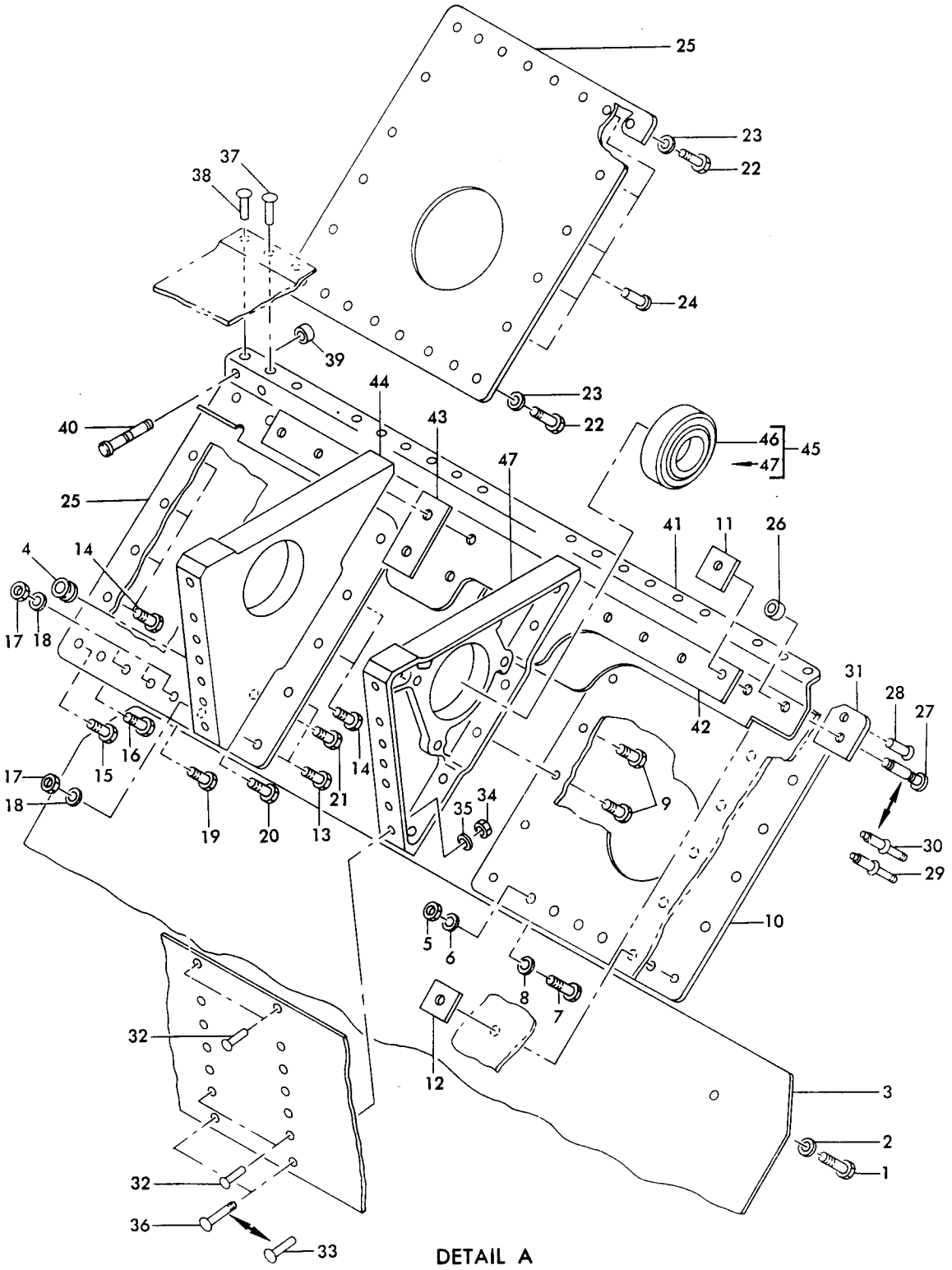
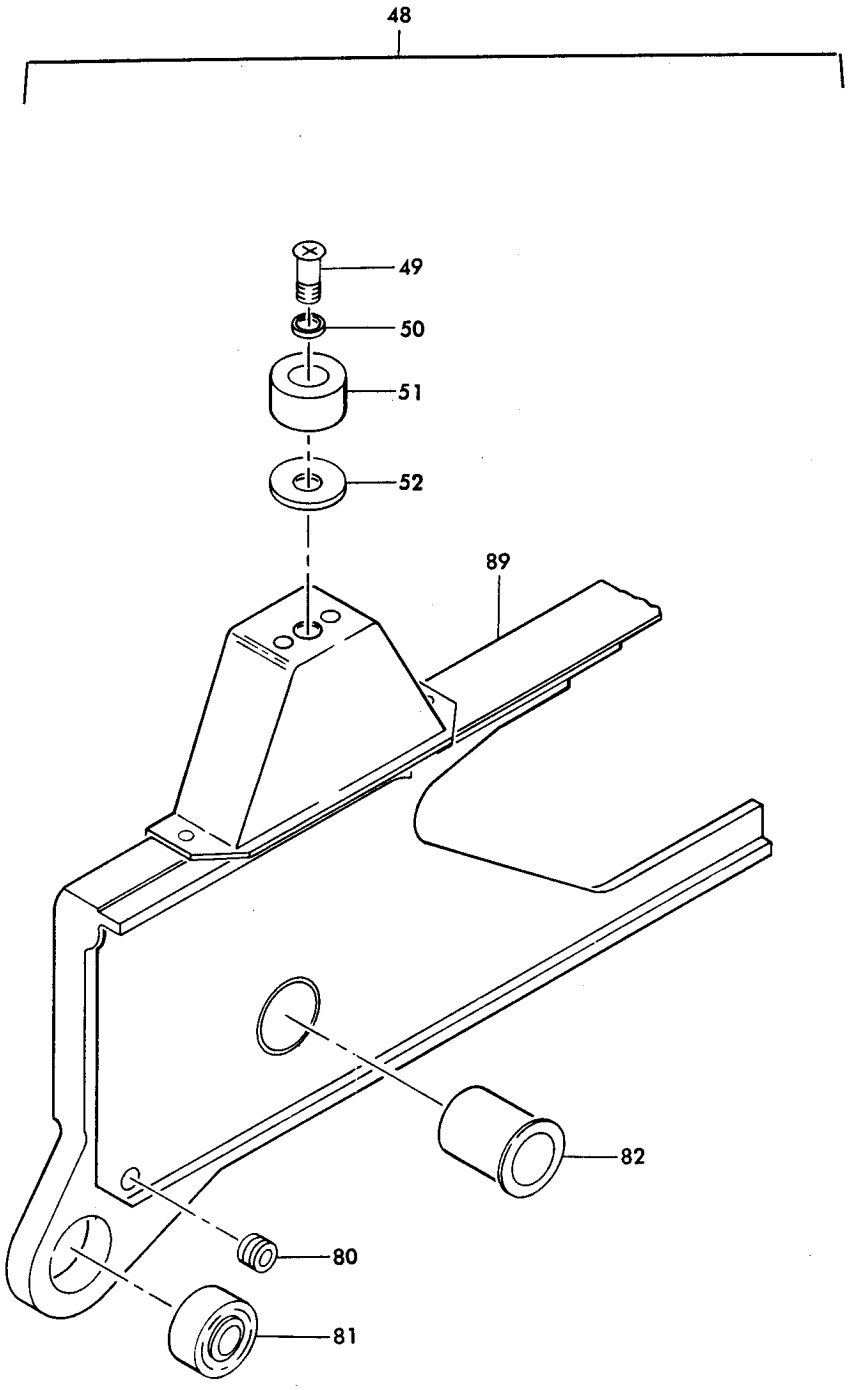
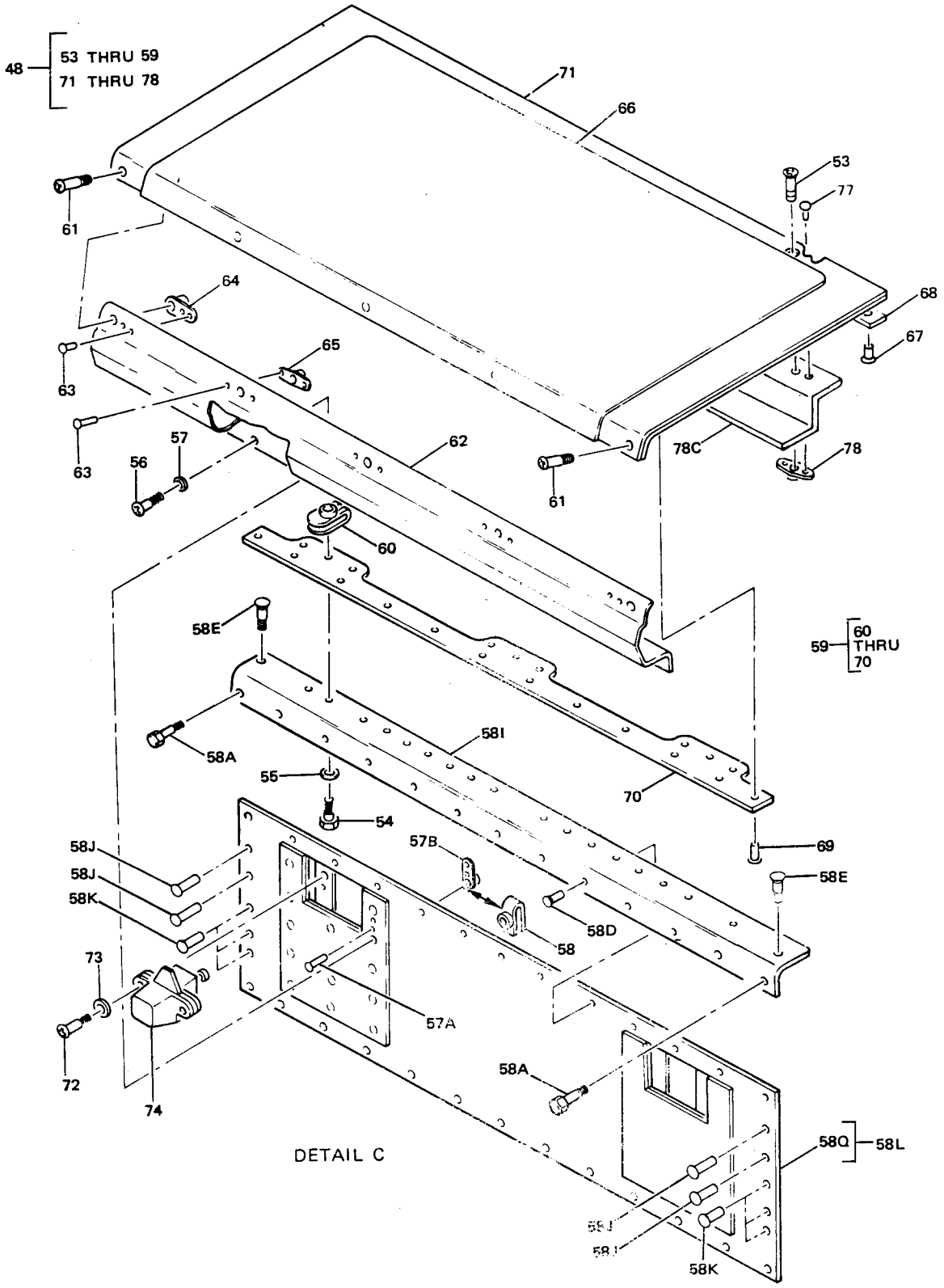


DETAIL A

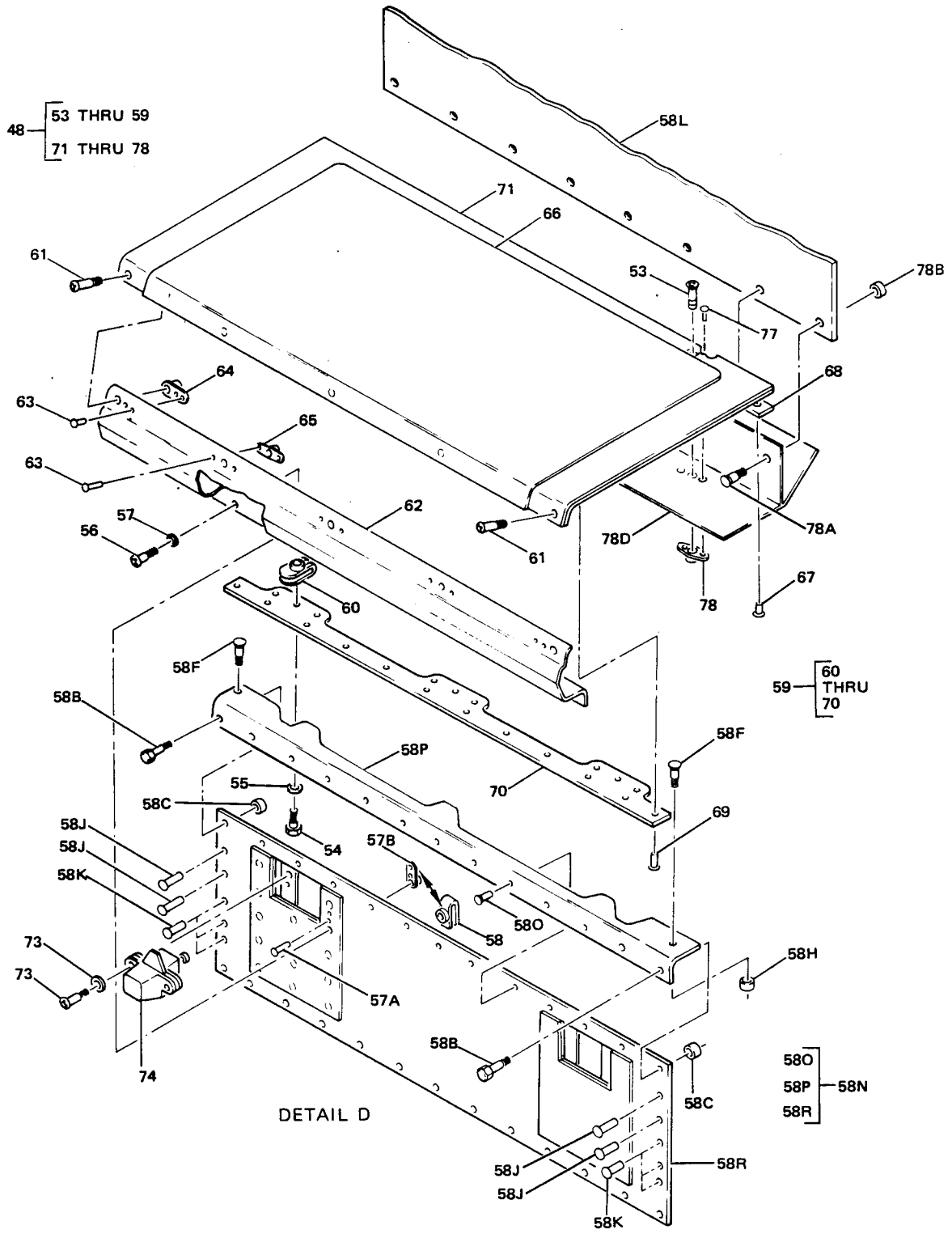
Center Ladder Assembly
Figure 1113 (Sheet 2)



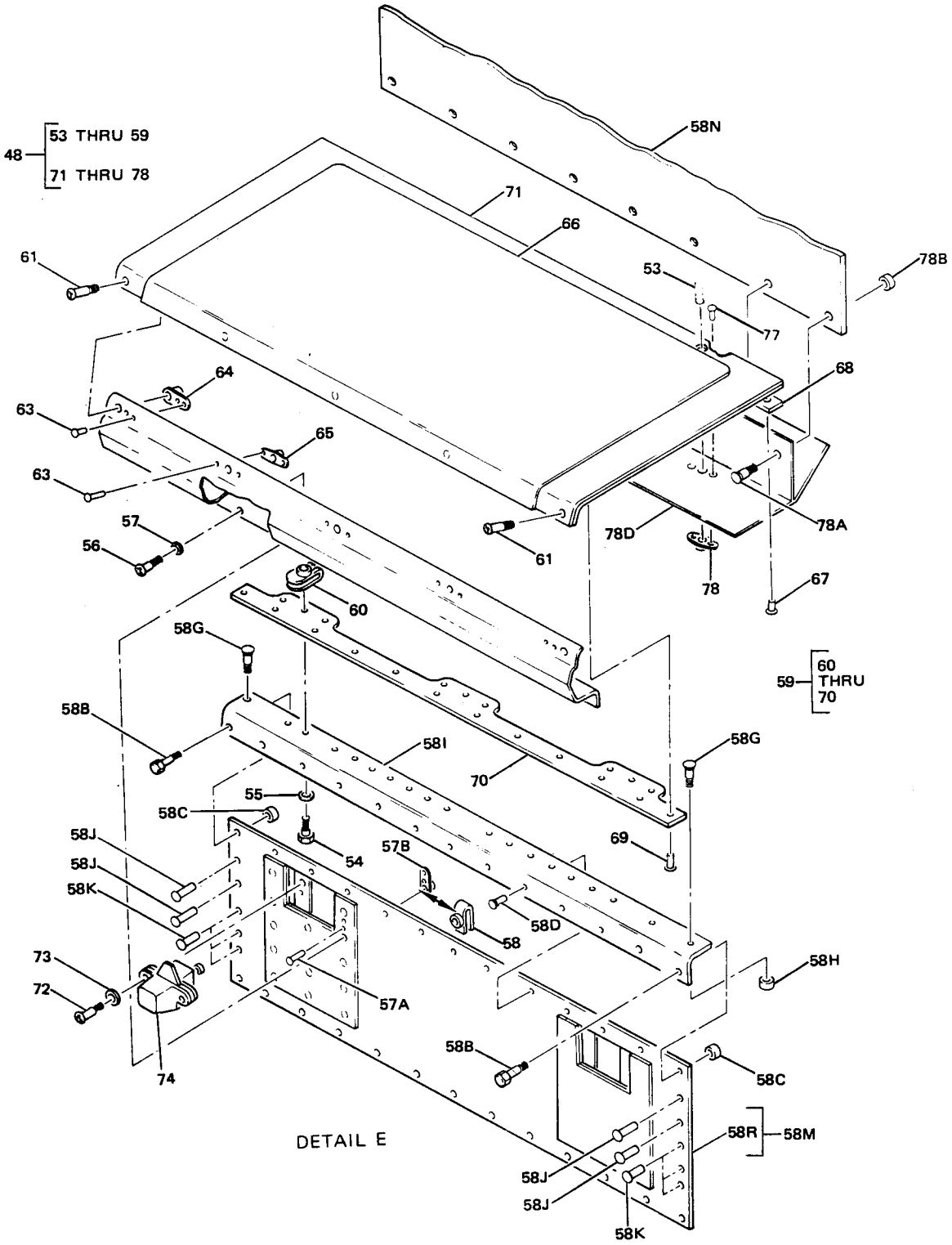
DETAIL B



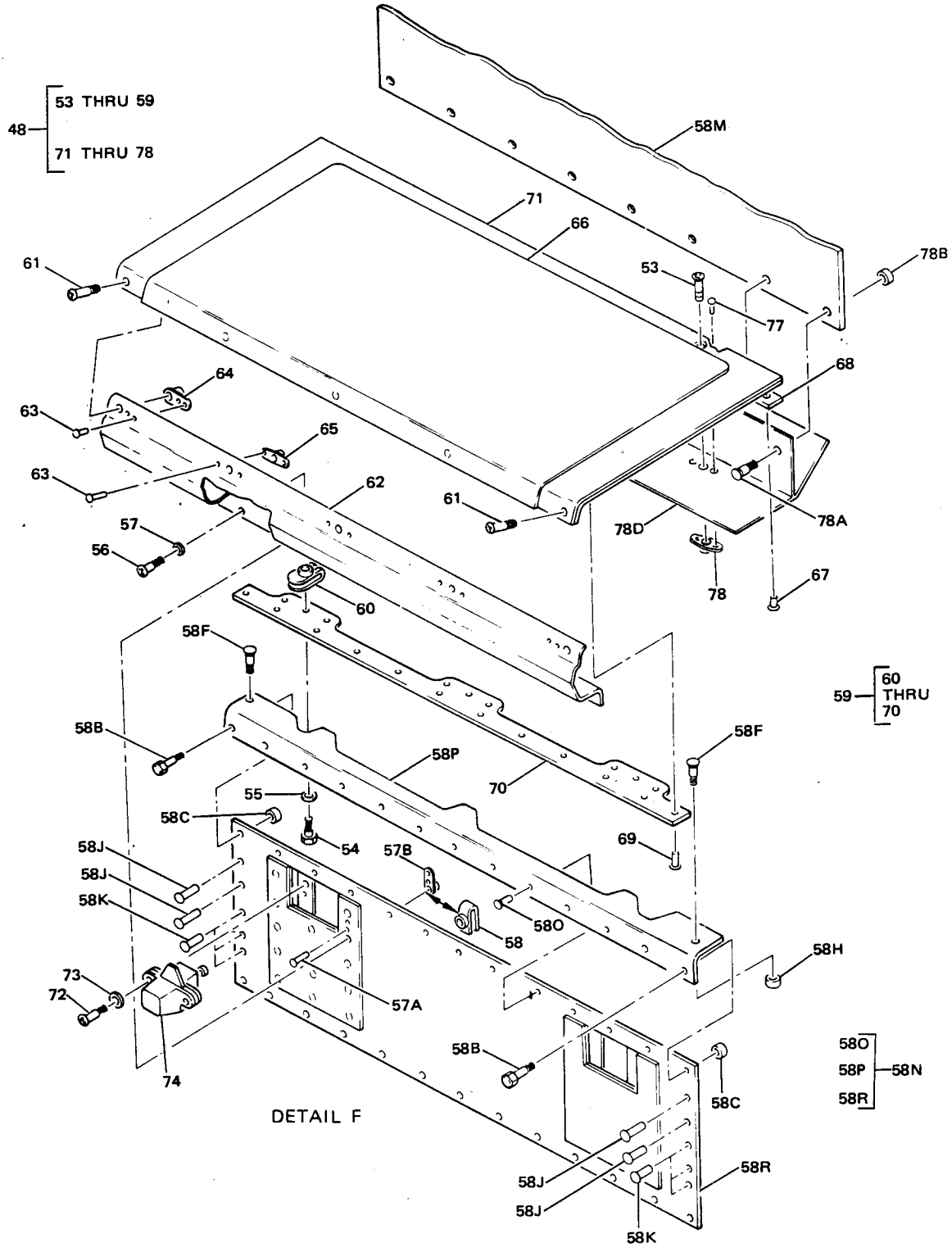
Center Ladder Assembly
Figure 1113 (Sheet 4)



Center Ladder Assembly
Figure 1113 (Sheet 5)



Center Ladder Assembly
Figure 1113 (Sheet 6)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DETAIL F
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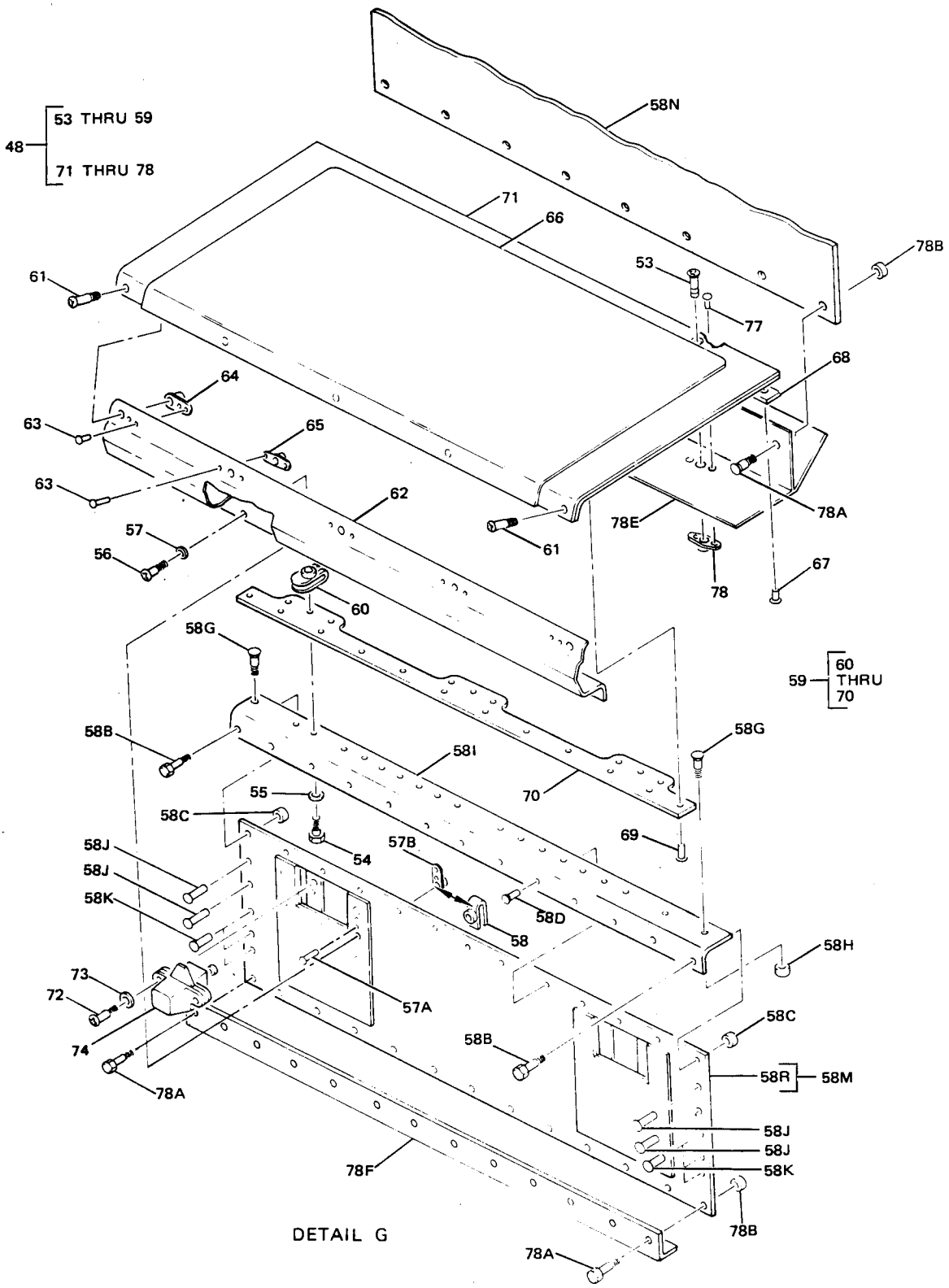


Center Ladder Assembly
Figure 1113 (Sheet 8)

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1113					
	65-68956-1		CENTER LADDER ASSEMBLY		
	65-68956-13		CENTER LADDER ASSEMBLY		
1	NAS603-8P		. BOLT		27
2	AN960PD10L		. WASHER		27
3	65-63358-6		. COVER		1
4	NAS1368N8A		. GROMMET		1
5	BACN10JC3		. NUT (REPLS NAS679A3W)		4
5	NAS679A3W		. NUT		4
6	AN960PD10		. WASHER		4
7	NAS1103-7		. BOLT		22
8	AN960PD10L		. WASHER		22
9	NAS1103-2		. BOLT		2
10	65-68956-3		. WEB		1
11	65-68956-14		. FILLER	B	1
12	65-68956-15		. FILLER	B	1
13	NAS1103-5		. BOLT	B	4
14	NAS1103-2		. BOLT	B	6
15	NAS1103-4		. BOLT	A	8
16	NAS1103-6		. BOLT	A	1
17	BACN10JC3		. NUT (REPLS NAS679A3W)	A	4
17	NAS679A3W		. NUT	A	4
18	AN960PD10L		. WASHER		4
19	NAS1103-6		. BOLT		2
20	NAS1103-4		. BOLT	A	2
21	NAS1103-3		. BOLT	A	1
22	NAS1103-7		. BOLT	B	4
23	AN960PD10L		. WASHER	B	4
24	MS20470D6		. RIVET	B	20
25	65-68956-4		. WEB		1
26	BACC30M8		. COLLAR	A	2
27	BACB30FM8-6		. LOCKBOLT	A	2
28	BACR15CE5D		. RIVET	A	2
29	BACB30LB8-6		. BOLT, BLIND	B	2
30	BACB30LA8-6		. BOLT, BLIND	B	2
31	65-58169-15		. FILLER		2
32	MS20470D5		. RIVET		12
33	BACR15CE5D		. RIVET	A	2
34	BACN10JC3		. NUT (REPLS NAS679A3W)	B	2
34	NAS679A3W		. NUT	B	2
35	AN960PD10L		. WASHER	B	2
36	BACB30EL3-3		. BOLT	B	2

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1113-					
37	BACR15CE5D		. RIVET		16
38	MS20470D5		. RIVET		2
39	NAS1080-6		. COLLAR		2
40	BACB30DX6-2		. LOCKBOLT		2
41	69-55463-1		. ZEE	B	1
41	69-55456-8		. ZEE	A	1
42	65-68956-6		. STRAP	2	
43	BACS40A16-44		. SHIM		AR
44	65-68959-1		. FITTING	B	1
44	65-68954-2		. FITTING	A	
45	65-68954-1		. FITTING ASSEMBLY		1
46	BACB10A553		. . BEARING		1
47	65-68954-3		. . FITTING		1
48	65-58169-1		. LADDER ASSEMBLY		1
49	NAS514P1032-10		. . SCREW		2
50	69-59840-1		DELETED		
50	69-54840-1		. . WASHER, COUNTERSUNK		2
51	69-50378-1		. . BUMPER		2
52	BACW10P294AL		. . WASHER		AR
53	BACB30LU3-7		. . BOLT		15
54	BACB30NE3-2		. . BOLT (REPLS NAS1303-2)		15
54	NAS1303-2		. . BOLT		15
55	AN960D10L		. . WASHER		15
56	NAS623-3-1		. . BOLT		20
57	AN960PD10L		. . WASHER		20
57A	MS20426D3		. . RIVET		40
57B	NAS687A3		. . NUTPLATE		20
58	BACN10FX2		. . NUT, CLIP *[1]		20
58A	BACB30LB6-3		. . BOLT, BLIND		2
58B	BACB30FM6-3		. . BOLT		8
58C	BACC30M6		. . COLLAR		8
58D	MS20470D5		. . RIVET		33
58E	BACB30LB6-4		. . BOLT, BLIND		2
58F	BACB30FM6-2		. . BOLT		4
58G	BACB30FM6-3		. . BOLT		4
58H	BACC30M6		. . COLLAR		8
58I	65-61771-23		. . ANGLE		3
58J	BACR15CE5		. . RIVET		20
58K	MS20470D5		. . RIVET		30
58L	65-58164-6		. . RISER ASSY		1
58M	65-58164-5		. . RISER ASSY (REPLD BY 65-58164-32)		2
58M	65-58164-32		. . RISER ASSY (REPLD BY 65-58164-5)		2

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1113-58N	65-58164-4		. . RISER ASSY (REPLD BY 65-58164-31)		2
58N	65-58164-31		. . RISER ASSY (REPLS 65-58164-4)		2
58O	MS20470D5		. . . RIVET (USED ON 65-58164-4,-31)		22
58P	65-58165-4		. . . ANGLE (USED ON 65-58164-4,-31)		2
58Q	65-58164-10		. . . SPOTWELD ASSY (USED ON 65-58164-6)		1
58R	65-58164-9		. . . SPOTWELD ASSY (USED ON 65-58164-4,-5,-31,-32)		4
59	65-58164-28		. . TREAD ASSY		5
59	65-58164-22		. . TREAD ASSY *[2]		5
59	65-58164-1		. . TREAD ASSY *[2]		5
60	BACN10FX2		. . . NUT, CLIP (USED ON 65-58164-28)		3
61	BACB30LU2-2		. . . BOLT (USED ON 65-58164-28)		5
62	69-56497-1		. . . BULLNOSE (USED ON 65-58164-28)		1
63	MS20426D3		. . . RIVET (USED ON 65-58164-28)		10
64	BACN10KB08FR		. . . NUTPLATE (USED ON 65-58164-28)		2
65	BACN10JR08FR		. . . NUTPLATE (USED ON 65-58164-28)		3
66	65-58164-36		. . . NONSKID (USED ON 65-58164-28)		1
66	65-58164-12		. . . NONSKID (USED ON 65-58164-1, -22)		1
67	BACR15CE5D2		. . . RIVET		12
68	65-58164-15		. . . STRAP		1
71	65-58164-37		. . . SPOTWELD ASSY (USED ON 65-58164-28)		1
71	65-58164-8		. . . SPOTWELD ASSY (USED ON 65-58164-1,-22)		1
72	NAS623-3-5		. . BOLT		20
73	AN960PD10L		. . WASHER		20
73	AN960C10L		. . WASHER *[1]		20
74	808512-401		. . LIGHT, V92824		10
77	MS20426D3		. . RIVET		30
78	NAS686A3		. . NUTPLATE		15
78A	BACB30FM6-3		. . BOLT		10
78B	BACC30M6		. . COLLAR		10
78C	65-61771-56		. . ZEE		1
78D	69-49782-1		. . TEE		3
78E	69-47982-3		. . TEE		1
78F	65-61771-25		. . ANGLE		1
79	NAS1368N6B		. . GROMMET		2
80	NAS1368N4B		. . GROMMET		1
81	BACB10A691		. . BEARING		2
82	BACB28W20B141		. . BUSHING		2
83	69-49723-1		. . RETAINER, RING		2

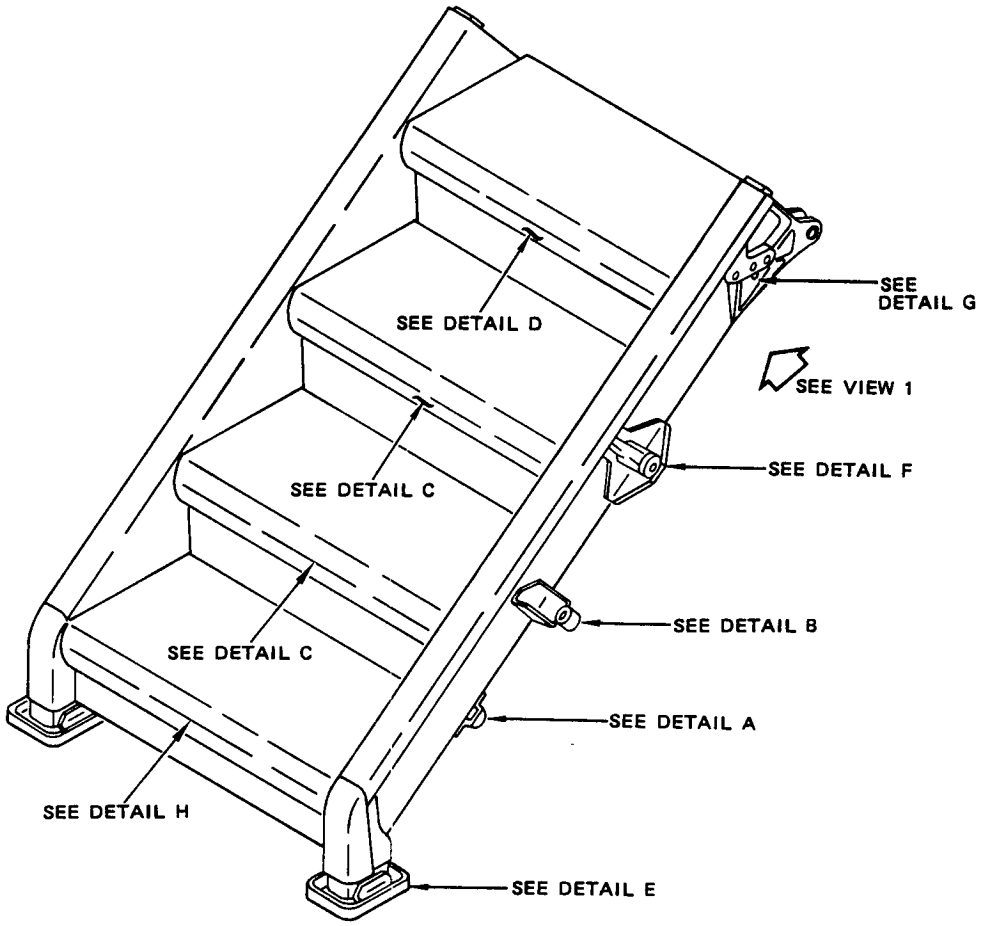
FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
84	BACB10A685		. . BEARING		2
85	BACB28W12B98		. . BUSHING		2
86	BACB10A691		. . BEARING		2
87	BACB28W20B195		. . BUSHING		2
88	BACB28X12C119		. . BUSHING		2
89			. . LADDER ASSEMBLY STRUCTURE, CENTER		1

A USED ON 65-68956-1
B USED ON 65-68956-13

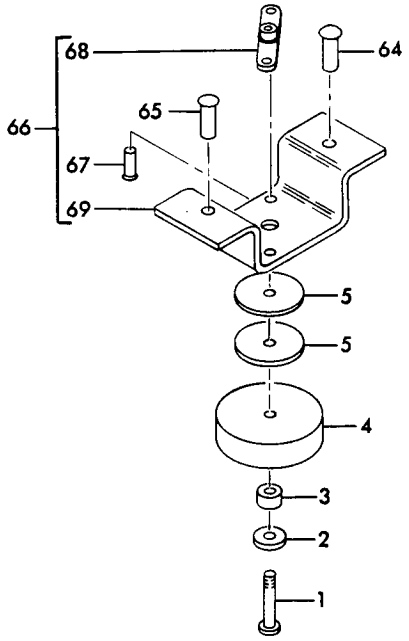
*[1] LIMITED USE ON EARLIER AIRPLANE MODELS ONLY
*[2] LIMITED USE

VENDORS

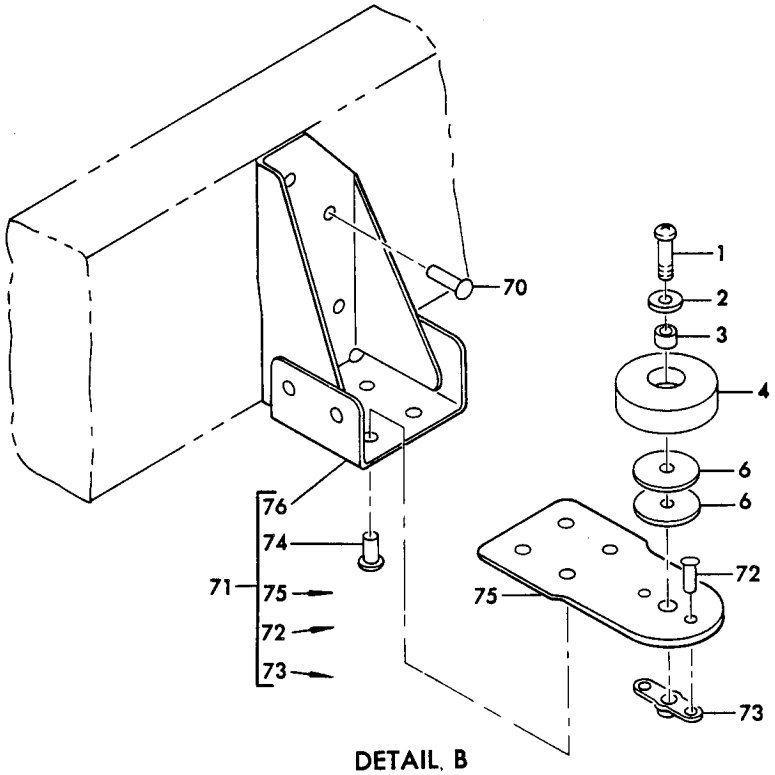
V92864 WEBER AIRCRAFT CORP., 2820 ONTARIO ST., BURBANK, CALIFORNIA 91503



Lower Ladder Assembly
Figure 1114 (Sheet 1)

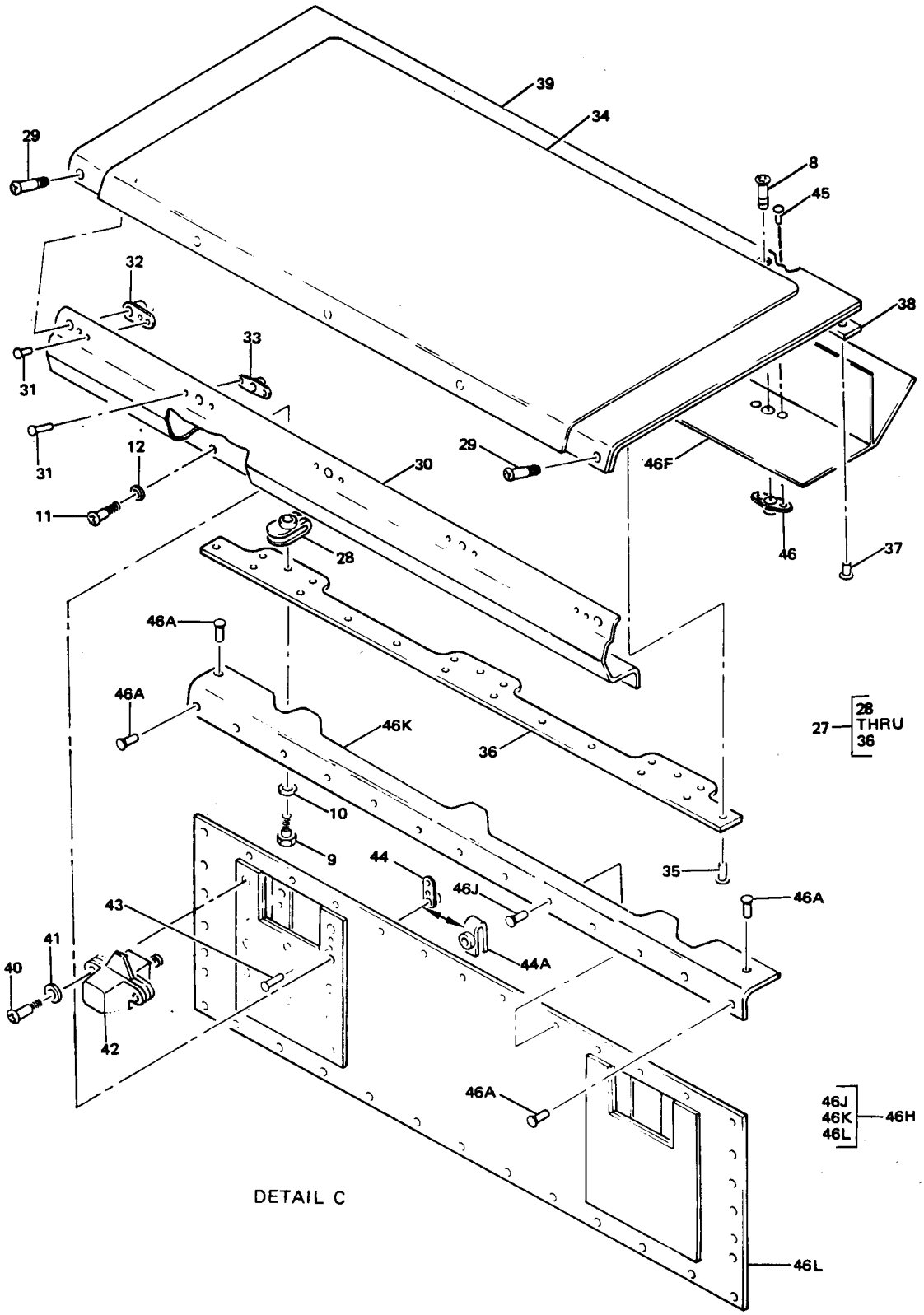


DETAIL A

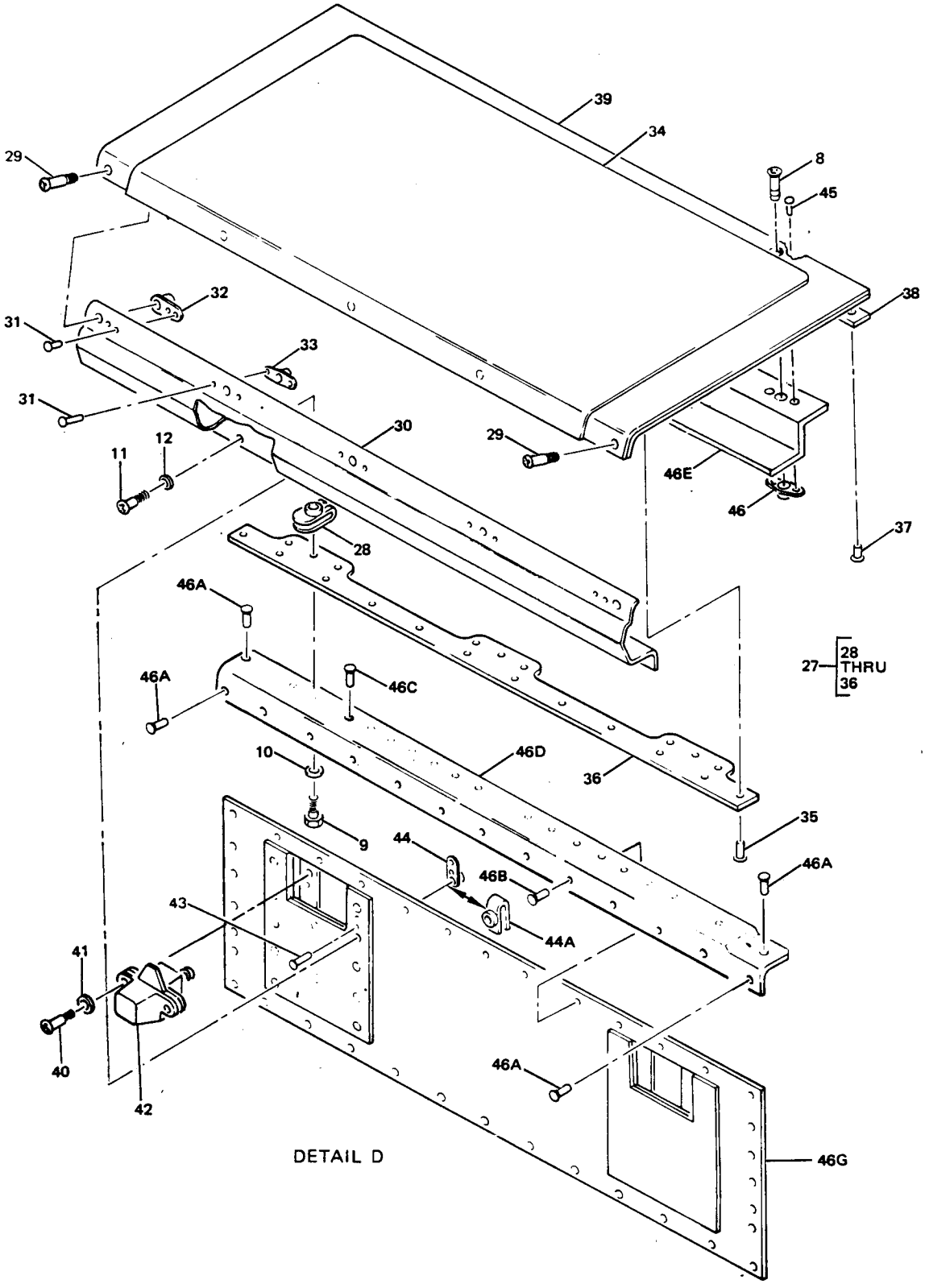


DETAIL B

Lower Ladder Assembly
Figure 1114 (Sheet 2)



Lower Ladder Assembly
Figure 1114 (Sheet 3)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46E
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37
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46A
27
28
THRU
36
46A
46C
46D
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36
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46A
46B
43
44A
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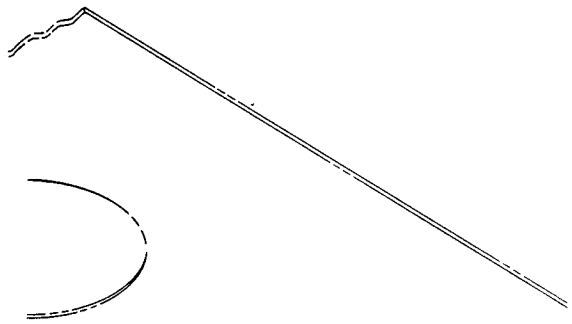
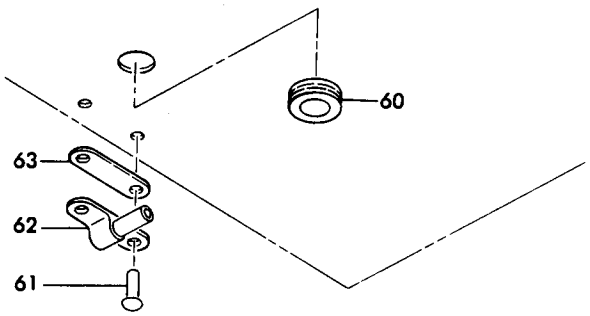
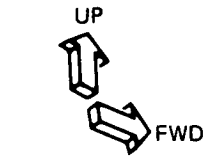
42
46A
46G

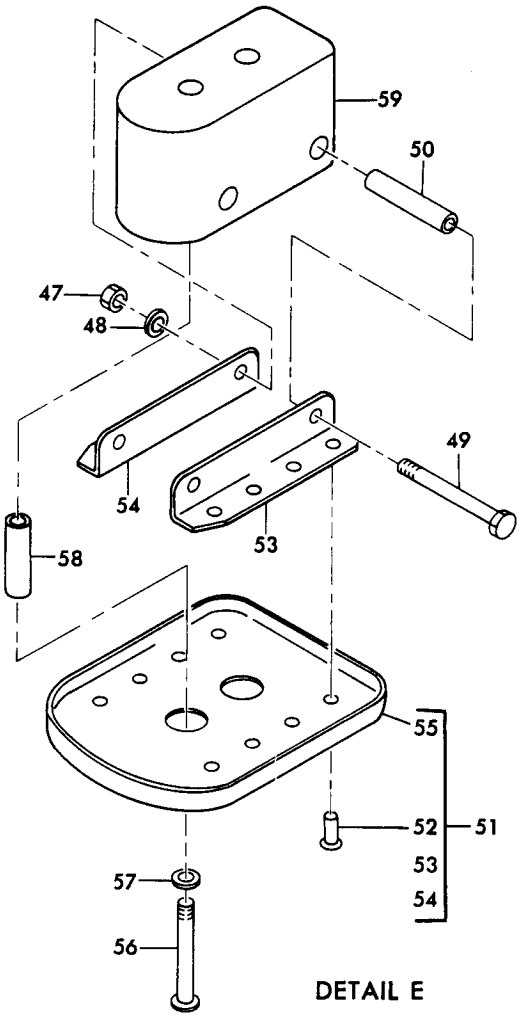
DETAIL D



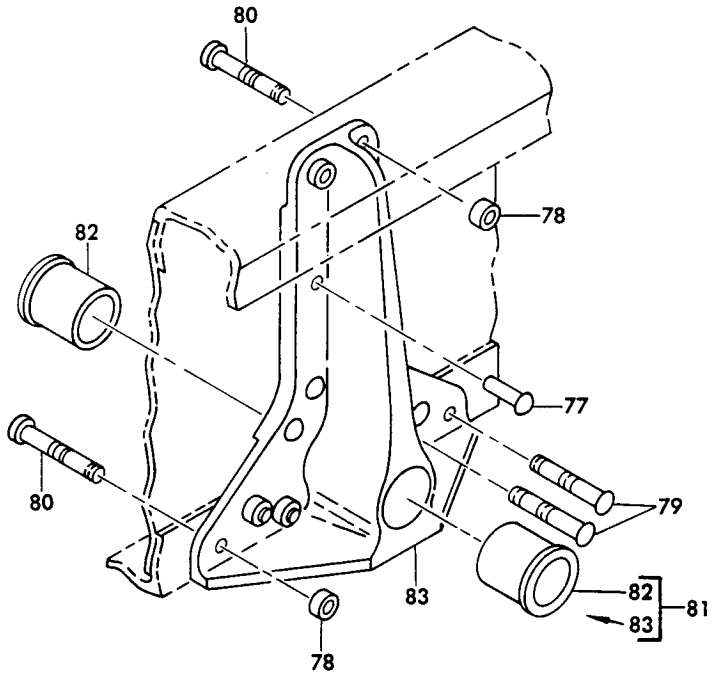




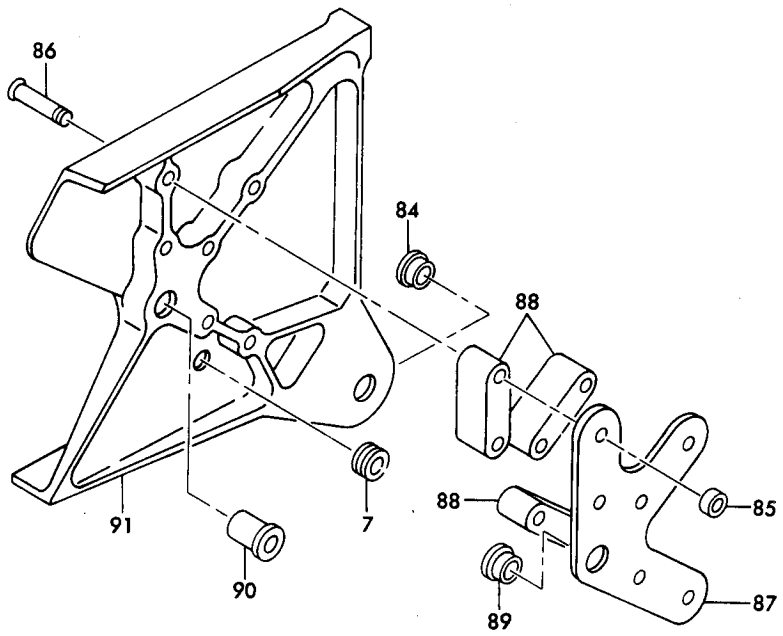
VIEW 1



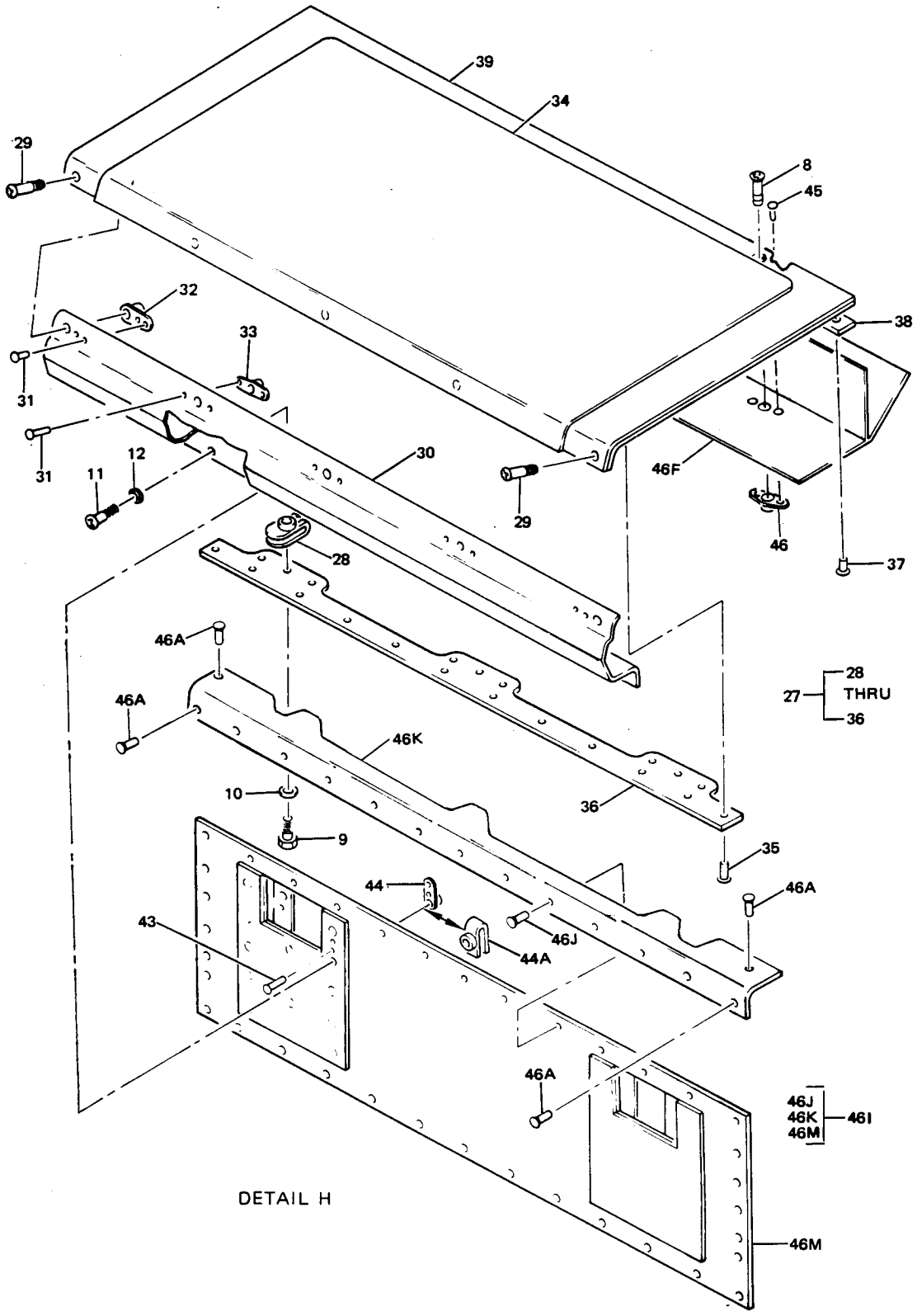
DETAIL E



DETAIL F



DETAIL G



Lower Ladder Assembly
Figure 1114 (Sheet 7)

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1114-					
	65-58170-1		LOWER LADDER ASSY		
1	NAS603-13P		. SCREW		4
2	AN960C10		. WASHER		4
3	NAS43DD3-12		. SPACER		4
4	69-50378-1		. BUMPER		4
5	BACW10P91L		. WASHER		AR
6	69-50377-6		. SHIM		AR
7	NAS1368N4B		. GROMMET		1
8	BACB30LU3-7		. BOLT		12
9	BACB30NE3-1		. BOLT (REPLACES NAS1303-1)		12
9	NAS1303-1		. BOLT		12
10	AN960PD10L		. WASHER *[1]		12
10	AN960D10L		. WASHER *[2]		12
11	NAS623-3-1		. BOLT		16
12	AN960PD10L		. WASHER		16
14	65-58164-45		. TREAD ASSY		3
14	65-58164-28		. TREAD ASSY *[3]		3
14	65-58164-1		. TREAD ASSY *[3]		3
14	65-58164-22		. TREAD ASSY *[3]		3
15	BACN10FX2		. . NUT, CLIP		3
16	BACB30LU2-2		. . BOLT (USED ON 65-58164-28,-45)		5
17	69-56497-2		. . BULLNOSE (USED ON 65-58164-28, -45)		1 1
17	69-56497-1		DELETED		
18	MS20426D3		. . RIVET (USED ON 65-58164-28,-45)		10
19	BACN10KB08FR		. . NUTPLATE (REPLS NAS687A08K) (USED ON 65-58164-28,-45)		2
20	BACN10JR08FR		. . NUTPLATE (REPLS NAS686A08K) (USED ON 65-58164-28,-45)		3
21	65-58164-36		. . NON SKID (USED ON 65-58164-28, -45)		1
21	65-58164-12		. . NON SKID (USED ON 65-58164-1 AND -22)		1
22	BACR15DJ5-2		. . RIVET (USED ON 65-58164-1)		24
22	BACR15DJ5-2		. . RIVET (USED ON 65-58164-22,-28, -45)		18
23	65-58164-16		. . STRAP (USED ON 65-58164-1)		1
23	69-52290-1		. . STRAP (USED ON 65-58164-22 AND -28)		1
24	BACR15CE5D2		. . RIVET		12
25	65-58164-15		. . STRAP		1
26	65-58164-43		. . SPOTWELD ASSY (USED ON 65-58164-45)		1

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1114-					
26	65-58164-37		. . SPOTWELD ASSY (USED ON 65-58164-28)		1
26	65-58164-8		. . SPOTWELD ASSY (USED ON 65-58164-1 and -22)		1
27	65-58164-47		. TREAD ASSY		1
27	65-58164-30		. TREAD ASSY *[3]		1
27	65-58164-23		. TREAD ASSY *[3]		1
27	65-58164-2		. TREAD ASSY *[3]		1
28	BACN10FX2		. . NUT, CLIP		3
29	BACB30LU2-2		. . BOLT (USED ON 65-58164-30,-47)		5
30	69-56497-2		. . BULLNOSE (USED ON 65-58164-30,-47)		1
30	69-56497-1		DELETED		
31	MS20426D3		. . RIVET (USED ON 65-58164-30)		10
32	BACN10KB08FR		. . NUTPLATE (REPLS NAS687A08K) (USED ON 65-58164-30,-47)		2
33	BACN10JR08FR		. . NUTPLATE (REPLS NAS686A08K) (USED ON 65-58164-30,-47)		3
34	65-58164-36		. . NONSKID (USED ON 65-58164-30, -47)		1
34	65-58164-12		. . NONSKID (USED ON 65-58164-2, -23)		1
35	BACR15DJ5-2		. . RIVET (USED ON 65-58164-2)		24
35	BACR15DJ5-2		. . RIVET (USED ON 65-58164-23,-30, -47)		18
36	65-58164-16		. . STRAP (USED ON 65-58164-2)		1
36	69-52290-1		. . STRAP (USED ON 65-58164-23,-30)		1
37	BACR15CE5D2		. . RIVET		12
38	65-58164-15		. . STRAP		1
39	65-58164-43		. . SPOTWELD ASSY (USED ON 65-58164-47)		1
39	65-58164-37		. . SPOTWELD ASSY (USED ON 65-58164-30)		1
39	65-58164-8		. . SPOTWELD ASSY (USED ON 65 58164-2,-23)		1
40	NAS623-3-5		. BOLT		12
41	AN960PD10L		. WASHER		12
42	808512-401		. LIGHT, V92824		6
43	MS20426D3		. RIVET		32
44	BACN10KB3F		. NUTPLATE (REPLS NAS687A3)		16
44	NAS687A3		. NUTPLATE		16
44A	BACN10FX2		. NUT, CLIP *[3]		16
45	MS20426D3		. RIVET		24
46	BACN10JR3F		. NUTPLATE (REPLS NAS686A3)		12
46	NAS686A3		. NUTPLATE		12
46A	MS20470D6		. RIVET		16
46B	MS20470D5		. RIVET		11

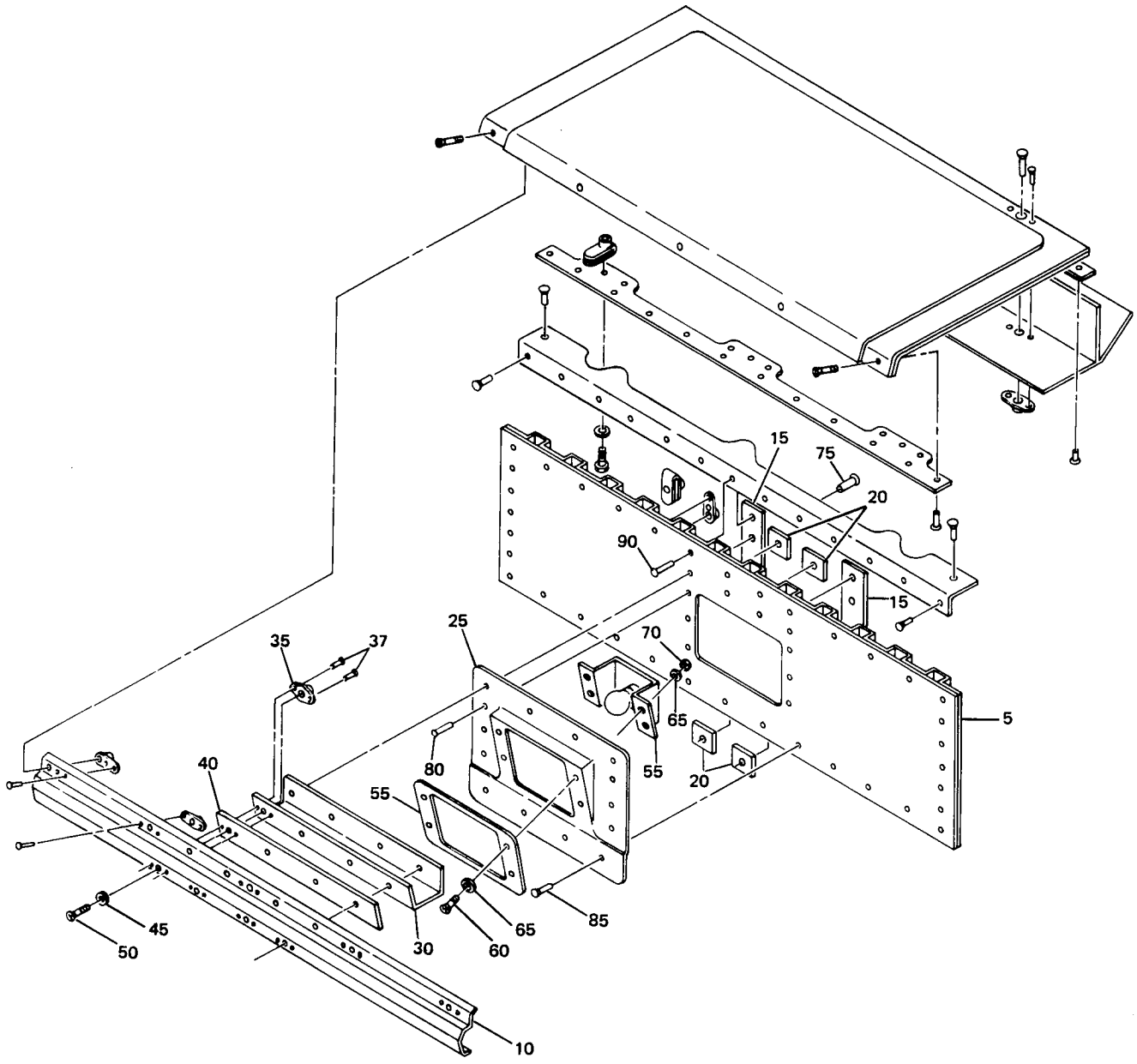
FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1114-					
46C	BACR15CE6		. RIVET		18
46D	65-58165-6		. ANGLE		1
46E	65-61771-17		. ZEE		1
46F	69-49782-1		. TEE		3
46G	65-58164-49		. RISER ASSY		1
46G	65-58164-32		. RISER ASSY *[3]		1
46G	65-58164-5		. RISER ASSY *[3]		1
46H	65-58164-48		. RISER ASSY		2
46H	65-58164-31		. RISER ASSY *[3]		2
46H	65-58164-4		. RISER ASSY *[3]		2
46I	65-58164-7		. RISER ASSY		1
46I	65-58164-35		. RISER ASSY *[3]		1
46I	65-58164-52		. RISER ASSY *[3]		1
46J	MS20470D5		. . RIVET		33
46K	65-58165-4		. . ANGLE (USED ON 65-58164-4,-7, -31,-35,-48,-52)		3
46L	65-58164-44		. . SPOTWELD ASSY (USED ON 65-58164-48,-49)		3
46L	65-48164-9		. . SPOTWELD ASSY (USED ON 65-58164-4,-5,-31,-32)		3
46M	65-58164-41		. . SPOTWELD ASSY (USED ON 65-58164-52)		1
46M	65-58164-11		. . SPOTWELD ASSY (USED ON 65-58164-7,-35)		1
47	BACN10JC3		. NUT (REPLS NAS679A3W)		4
47	NAS679A3W		. NUT		4
48	AN960C10		. WASHER		4
49	NAS1103-27		. BOLT		4
50	NAS43DD3-96		. SPACER		4
51	65-61727-1		. SCUFF PLATE ASSY		2
52	MS20427M4		. . RIVET		AR
53	65-61727-3		. . SCUFF ANGLE		1
54	65-61727-4		. . SCUFF ANGLE		1
55	65-61727-2		. . SCUFF PLATE		1
56	NAS623-3-26		. BOLT		4
57	AN960C10L		. WASHER		4
58	NAS43DD3-83		. SPACER		4
59	65-61728-1		. PAD, FOOT		2
60	NAS1368N6A		. GROMMET		1
61	MS20470D5		. . RIVET		2
62	BACN10DZ3-40		. . NUT, SPACER PLATE		1
63	NAS463XDD416H		. . SHIM, ANCHOR NUT		2
64	MS20470D5		. RIVET		2
65	BACR15CE5D		. RIVET		2
66	69-50376-1		. SUPPORT ASSY		2
67	MS20426D3		. RIVET		2

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1114-					
68	BACN10JR3		. NUTPLATE		1
69	69-50376-3		. SUPPORT		1
70	MS20470D5		. RIVET		10
71	69-50377-1		. BRACKET ASSY, BUMPER SUPPORT (USED ON AFT SIDE)		1
71	69-50377-2		. BRACKET ASSY, BUMPER SUPPORT (USED ON FORE SIDE)		1
72	MS20426D3		. . RIVET		2
73	BACN10JR3		. . NUTPLATE		1
74	MS20470D5		. . RIVET		8
75	69-50377-5		. . BASE		1
76	69-50377-3		. . BRACKET		1
77	MS20470D6		. RIVET		AR
78	BACC30K6		. COLLAR		AR
79	BACB30GY6-5		. LOCKBOLT		4
80	BACB30GW6-5		. LOCKBOLT		AR
81	65-59626-1		. FITTING ASSY, SUPPORT (USED ON AFT SIDE)		1
81	65-59626-2		. FITTING ASSY, SUPPORT (USED ON FORE SIDE)		1
82	BACB28X12B90		. . BUSHING		2
83	65-59626-3		. . FITTING (USED ON 65-59626-1)		1
83	65-59626-4		. . FITTING (USED ON 65-59626-2)		1
84	BACB28X6B20		. BUSHING		4
85	NAS1080-8		. COLLAR		6
86	BACB30DY8-6		. LOCKBOLT		6
87	69-46651-1		. PLATE, CLEVIS		2
88	69-46651-2		. SPACER		6
89	BACB28X6B10		. BUSHING		2
90	BACB28X6B67		. BUSHING		2
91			. LADDER ASSY STRUCTURE		1

*[1] Used with tread assembly (14), P/N 65-58164-28
*[2] Used with tread assembly (14), P/N 65-58164-1 and -22
*[3] Limited use

VENDORS

V92824 WEBER AIRCRAFT DIVISION OF KIDDLE WALTER AND COMPANY, INC., 2820 ONTARIO STREET, BURBANK, CALIFORNIA 91505



NOTE: SEE FIGURE 1114 FOR ITEMS NOT CALLED OUT

Aft Airstair Assembly (Rework)
Figure 1115

FIG. & ITEM NO.	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1 2 3 4 5 6 7	USE CODE	QTY PER ASSY
1115-					
	65C31295-1		AFT AIRSTAIR ASSY		
5	65C31295-2		. RISER ASSY		1
10	65C31295-3		. BULLNOSE		1
15	65C31295-4		. RADIUS FILLER		2
20	65C31295-5		. RADIUS FILLER		4
25	65C31306-1		. FITTING		1
30	69-76268-1		. CLIP		1
35	BACN10JN3CM		. NUTPLATE		4
37	BACR15BA3AD		. RIVET		8
40	BACS40R08E65F		. SHIM - LAMINATED		1
45	NAS620-10L		. WASHER		4
50	NAS623-3-2		. BOLT		4
55	10-1180-3		. LIGHT - EMERGENCY		1
60	NAS601-6		. BOLT		4
65	NAS620-6L		. WASHER		8
70	MS21042L06		. NUT		4
75	BACR15FT6D		. RIVET		4
80	BACR15FT5D		. RIVET		6
85	BACR15FT6D		. RIVET		4
90	BACR15CE6D		. RIVET		2

Part No.	Fig. and Index No.	Qty. per Assy
AN310-6		AR
AN310-7		AR
AN310C4		AR
AN316-10		AR
AN316-4		AR
AN316-8		AR
AN316-8R		AR
AN316-9		AR
AN316-9R		AR
AN320-12		AR
AN320-4		AR
AN320-5		AR
AN320-6		AR
AN320-7		AR
AN320-8		AR
AN320C10		AR
AN320C6		AR
AN320D10		AR
AN320D12		AR
AN320D18		AR
AN320D20		AR
AN43BC4		AR
AN960-10		AR
AN960-10L		AR
AN960-1216		AR
AN960-1216L		AR
AN960-1616L		AR
AN960-416		AR
AN960-416L		AR
AN960-516		AR
AN960-616		AR
AN960-716		AR
AN960-816		AR
AN960C10		AR
AN960C10L		AR
AN960C416		AR
AN960C416L		AR
AN960D10L		AR
AN960D416		AR
AN960D416L		AR
AN960PD10		AR
AN960PD10L		AR
AN960PD1016		AR
AN960PD1216		AR
AN960PD1616L		AR
AN960PD1816		AR
AN960PD2016		AR
AN960PD416		AR
AN960PD516		AR
AN960PD616		AR
AN960PD616L		AR
AN960PD816L		AR
B100EU5-2CD	1102-98	8
B100EU5-2CD	1102-136	4
B100EU5-2CD	1102-184	4
B100EU5-2CD	1102-186	4
B100EU6-2CD	1102-124	8
B100EU6-3CD	1102-86	16
B100EU6-3CD	1102-145	8
B100EU6-4CD	1102-70	4
B100EU6-4CD	1102-115	4
B100EU6-4CD	1102-163	4
B100EU6-4CD	1102-194	4
B100EU8-4	1102-117	8
B100EU8-4CD	1102-72	8
B100EU8-4CD	1102-165	8
B100EU8-4CD	1102-202	8
B100EU8-4CD	1102-206	6
B100EU8-4CD	1102-208	4
B100EU8-4CD	1102-212	6
BACB10A27DD	1102-97	2
BACB10A27DD	1102-135	2
BACB10A543	1102-57	2
BACB10A543	1102-63	2
BACB10A543	1102-68	2
BACB10A543	1102-85	2
BACB10A543	1102-104	2
BACB10A543	1102-114	2
BACB10A543	1102-143	2
BACB10A543	1102-154	2
BACB10A543	1102-162	2
BACB10A543	1102-174	2
BACB10A543	1102-193	2
BACB10A553	1109-125	2
BACB10A553	1109-131	1
BACB10A553	1112-63	1
BACB10A553	1113-46	1
BACB10A685	1102-25	1
BACB10A685	1102-45	1
BACB10A685	1102-52	1
BACB10A685	1102-74	1
BACB10A685	1109-43	2
BACB10A685	1109-52	1
BACB10A685	1110-177	2
BACB10A685	1112-70	2

Part No.	Fig. and Index No.	Qty. per Assy
BACB10A685	1113-84	2
BACB10A686	1102-6	1
BACB10A686	1102-204	1
BACB10A687	1109-17	2
BACB10A687	1109-22	1
BACB10A687	1109-68	2
BACB10A687	1109-74	1
BACB10A687	1109-86	2
BACB10A687	1109-91	1
BACB10A691	1112-67	2
BACB10A691	1112-72	2
BACB10A691	1113-81	2
BACB10A691	1113-86	2
BACB10A692	1107-10	2
BACB10A692	1107-20	1
BACB10A832	1106-10	1
BACB10AC5	1106-23	1
BACB10AC6	1109-7	2
BACB10AC8	1109-73	1
BACB10AF8K5H	1108-3	4
BACB10AF8K6H	1108-3	4
BACB10AF7F3H	1107-15	2
BACB10B135	1107-27	2
BACB10B135	1109-139	4
BACB10BH62F6	1107-15	2
BACB10BH64TK8	1108-3	4
BACB10C134	1102-120	1
BACB10C134	1102-168	1
BACB10C134	1109-133	1
BACB10C134H	1109-133	1
BACB10C240H	1101-21	1
BACB10C59H	1102-36	1
ACB10C94	1109-129	1
BACB10C94H	1109-90	1
BACB10C94H	1109-129	1
BACB28U5B20	1110-140	1
BACB28U5B20	1111-9	1
BACB28W12B98	1112-71	2
BACB28W12B98	1113-85	2
BACB28W20B141	1112-68	2
BACB28W20B141	1113-82	2
BACB28W20B195	1112-73	2
BACB28W20B195	1113-87	2
BACB28W20B342	1110-179	2
BACB28W5B10	1110-139	1
BACB28W5B10	1111-8	1
BACB28W5B15	1106-16	2
BACB28W5B21	1102-181	1
BACB28W6B19	1109-92	2
BACB28X10B48	1108-40	1
BACB28X10B48	1108-46	1
BACB28X10B48	1108-62	1
BACB28X10B48	1108-66	1
BACB28X12B90	1114-82	2
BACB28X12C119	1112-74	2
BACB28X12C119	1113-88	2
BACB28X16B75	1110-181	4
BACB28X3B23	1102-181	1
BACB28X4B10	1102-14	2
BACB28X4B10	1102-18	2
BACB28X4B10	1102-39	2
BACB28X4B19	1108-38	1
BACB28X4B19	1108-44	1
BACB28X4B24	1108-37	1
BACB28X4B24	1108-43	1
BACB28X6B10	1114-89	2
BACB28X6B12	1102-78	1
BACB28X6B12	1102-88	1
BACB28X6B12	1102-126	1
BACB28X6B12	1102-147	1
BACB28X6B12	1102-210	1
BACB28X6B12	1102-214	1
BACB28X6B20	1110-180	4
BACB28X6B20	1114-84	4
BACB28X6B7	1114-90	2
BACB28X8B21	1110-175	2
BACB28X8B38	1108-39	1
BACB28X8B38	1108-45	1

Part No.	Fig. and Index No.	Qty. per Assy.
BACB28X8B38	1108-61	1
BACB28X8B38	1108-65	1
BACB28Y8B43	1110-125	2
BACB30DX6-2	1112-59	2
BACB30DX6-2	1113-40	2
BACB30DX6-4	1104-11	2
BACB30DX6-4	1110-144	2
BACB30DX6-4	1111-13	2
BACB30DY8-6	1114-86	6
BACB30EF3-2	1102-54	1
BACB30EF3-2	1102-58	1
BACB30EF3-2	1102-64	1
BACB30EF3-2	1102-80	1
BACB30EF3-2	1102-101	1
BACB30EF3-2	1102-109	1
BACB30EF3-2	1102-138	1
BACB30EF3-2	1102-151	1
BACB30EF3-2	1102-157	1
BACB30EF3-2	1102-170	1
BACB30EF3-2	1102-188	1
BACB30EL3-3	1112-55	2
BACB30EL3-3	1113-36	2
BACB30FM6-12	1110-212	2
BACB30FM6-2	1110-191	2
BACB30FM6-2	1110-197	2
BACB30FM6-2	1110-207	2
BACB30FM6-2	1113-58F	4
BACB30FM6-3	1110-203	2
BACB30FM6-3	1113-58B	8
BACB30FM6-3	1113-58G	4
BACB30FM6-3	1113-78A	10
BACB30FM6-4	1108-28	34
BACB30FM6-4	1108-30	2
BACB30FM6-4	1108-54	28
BACB30FM6-4	1110-166	2
BACB30FM6-4	1110-188	2
BACB30FM6-5	1108-32	4
BACB30FM6-5	1108-55	4
BACB30FM6-5	1110-166B	2
BACB30FM8-5	1108-30	2
BACB30FM8-6	1113-27	2
BACB30FN6-3	1110-172C	4
BACB30FN6-3	1110-195	2
BACB30FN6-4	1110-158	2
BACB30FN6-4	1110-182	2
BACB30GW6-4	1105-11	1
BACB30GW6-4	1105-15	3

Part No.	Fig. and Index No.	Qty. per Assy.
BACB30GW6-5	1104-8	2
BACB30GW6-5	1114-80	AR
BACB30GW8	1103-9	4
BACB30GY6-5	1114-79	4
BACB30GY6-6	1110-59	1
BACB30GY6-6	1110-68	1
BACB30GY6-6	1110-105	1
BACB30GY6-6	1110-116	1
BACB30GY8-6	1110-57	1
BACB30GY8-6	1110-66	1
BACB30GY8-6	1110-107	1
BACB30GY8-6	1110-118	1
BACB30LA5-2	1102-98	8
BACB30LA5-2	1102-136	4
BACB30LA5-2	1102-184	4
BACB30LA5-2	1102-186	4
BACB30LA5-6	1112-49	2
BACB30LA6-2	1102-124	8
BACB30LA6-3	1102-86	16
BACB30LA6-3	1102-145	8
BACB30LA6-4	1102-70	4
BACB30LA6-4	1102-115	4
BACB30LA6-4	1102-163	4
BACB30LA6-4	1102-194	4
BACB30LA6-4	1108-52	8
BACB30LA6-5	1110-172B	2
BACB30LA8-4	1102-72	8
BACB30LA8-4	1102-117	8
BACB30LA8-4	1102-165	8
BACB30LA8-4	1102-202	8
BACB30LA8-4	1102-206	6
BACB30LA8-4	1102-208	4
BACB30LA8-4	1102-212	6
BACB30LA8-4	1110-172Q	2
BACB30LA8-6	1113-30	2
BACB30LB6-3	1109-34	4
BACB30LB6-3	1109-36	4
BACB30LB6-3	1113-58A	2
BACB30LB6-4	1113-58E	2
BACB30LB6-5	1110-172A	2
BACB30LB8-4	1110-172R	2
BACB30LB8-6	1112-50	2
BACB30LB8-6	1113-29	2
BACB30LJ6D23	1109-62	2
BACB30LJ6D26	1109-4	2
BACB30LK3-2	1110-175W	
BACB30LK3-3	1110-174Q	8

Part No.	Fig. and Index No.	Qty. per Assy.
BACB30LK3-4	1110-174V	2
BACB30LK3-5	1110-174N	6
BACB30LK5-3	1110-175H	2
BACB30LK4-11	1110-175E	2
BACB30LL3-2	1110-174P	18
BACB30LL3-2	1110-174W	2
BACB30LL3-4	1110-174M	10
BACB30LL3-5	1110-174O	6
BACB30LL3-6	1110-174L	16
BACB30LL3-8	1110-173B	8
BACB30LL3-8	1110-174L	16
BACB30LU2-2	1103-1	29
BACB30LU2-2	1104-1	21
BACB30LU2-2	1105-1	24
BACB30LU2-2	1110-8	5
BACB30LU2-2	1110-23	5
BACB30LU2-2	1112-11	5
BACB30LU2-2	1113-61	5
BACB30LU2-2	1114-16	5
BACB30LU2-2	1114-29	5
BACB30LU3-9	1110-181G	1
BACB30LU3-10	1110-89	1
BACB30LU3-14	1102-92	2
BACB30LU3-14	1102-130	2
BACB30LU3-22	1109-158	3
BACB30LU3-4	1105-3	1
BACB30LU3-4	1110-156	2
BACB30LU3-7	1102-92	2
BACB30LU3-7	1102-130	2
BACB30LU3-7	1112-2	12
BACB30LU3-7	1112-2	15
BACB30LU3-7	1113-53	15
BACB30LU3-7	1114-8	12
BACB30LU3-9	1102-179	1
BACB30LU3-9	1110-1	12
BACB30LU3-9	1112-1	3
BACB30LU4-22	1110-175Q	1
BACB30LU4-5	1107-30	6
BACB30LU6-10	1108-35	2
BACB30MT4T7	1110-86	1
BACB30MT4T7	1110-92	1
BACB30MT6-44	1109-144	2
BACB30MT7-48	1109-107	1
BACB30NE3-1	1110-19	6

Part No.	Fig. and Index No.	Qty. per Assy.
BACB30NE3-1	1114-9	12
BACB30NE3-2	1110-4	3
BACB30NE3-2	1110-5A	3
BACB30NE3-2	1110-19	6
BACB30NE3-2	1112-4	12
BACB30NE3-2	1112-4	15
BACB30NE3-2	1112-41	2
BACB30NE3-2	1113-54	15
BACB30NE3-3	1110-5C	3
BACB30NE3-3	1110-175K	15
BACB30NE3-3	1110-175K	15
BACB30NE3-5	1112-3	3
BACB30NE3-7	1112-39	20
BACB30NE3-7	1112-46	4
BACB30NE4-5	1110-83	1
BACB30NE4-6	1110-95	4
BACB30NE4-7	1108-5	24
BACB30NE4-9	1110-45	4
BACB30NE5-9	1109-154	4
BACB30NE6D20	1101-29	4
BACB30NE6D22	1101-29	1
BACC30K6	1104-7	2
BACC30K6	1105-10	1
BACC30K6	1105-14	3
BACC30K6	1110-58	1
BACC30K6	1110-67	1
BACC30K6	1110-104	1
BACC30K6	1110-115	1
BACC30K6	1114-78	AR
BACC30K8	1103-8	4
BACC30K8	1110-56	1
BACC30K8	1110-65	1
BACC30K8	1110-106	1
BACC30K8	1110-117	1
BACC30M6	1108-27	34
BACC30M6	1108-29	2
BACC30M6	1108-31	4
BACC30M6	1108-53	AR
BACC30M6	1110-157	2
BACC30M6	1110-165	2
BACC30M6	1110-166C	2
BACC30M6	1110-172D	8
BACC30M6	1110-183	2
BACC30M6	1110-189	2

Part No.	Fig. and Index No.	Qty. per Assy.
BACC30M6	1110-192	2
BACC30M6	1110-196	2
BACC30M6	1110-198	2
BACC30M6	1110-204	2
BACC30M6	1110-208	2
BACC30M6	1110-213	2
BACC30M6	1113-58C	8
BACC30M6	1113-58H	8
BACC30M6	1113-78B	10
BACC30M8	1108-29	2
BACC30M8	1113-26	2
BACN10BL4L	1110-43	4
BACN10BL4L	1110-93	4
BACN10CP4L	1110-81	1
BACN10DZ3-40	1110-128	1
BACN10DZ3-40	1114-62	1
BACN10FX1	1110-39	16
BACN10FX2	1110-7	3
BACN10FX2	1110-22	3
BACN10FX2	1112-8	20
BACN10FX2	1112-10	3
BACN10FX2	1113-58	20
BACN10FX2	1113-60	3
BACN10FX2	1114-15	3
BACN10FX2	1114-28	3
BACN10FX2	1114-44A	16
BACN10FX81	1103-5	13
BACN10FX81	1104-4	2
BACN10FX81	1105-6	22
BACN10GW10	1108-15	4
BACN10GW5	1109-152	4
BACN10HC4	1110-84	1
BACN10HC4	1110-90	1
BACN10HR6	1109-142	2
BACN10HR7	1109-105	1
BACN10JC3	1102-90	2
BACN10JC3	1102-128	2
BACN10JC3	1102-177	1
BACN10JC3	1102-196	2
BACN10JC3	1108-33	2
BACN10JC3	1109-156	3
BACN10JC3	1110-1B	3
BACN10JC3	1110-87	1
BACN10JC3	1110-134	4
BACN10JC3	1110-154	2
BACN10JC3	1110-174I	56
BACN10JC3	1110-174T	4

Part No.	Fig. and Index No.	Qty. per Assy.
BACN10JC3	1110-175I	15
BACN10JC3	1110-175U	2
BACN10JC3	1110-181D	1
BACN10JC3	1111-3	4
BACN10JC3	1112-53	2
BACN10JC3	1113-5	4
BACN10JC3	1113-17	4
BACN10JC3	1113-34	2
BACN10JC3	1114-47	4
BACN10JC4	1106-1	1
BACN10JC4	1110-40	2
BACN10JC4	1110-46	2
BACN10JC4	1110-49	2
BACN10JC4	1110-52	2
BACN10JC4	1110-96	14
BACN10JC4	1110-172I	4
BACN10JC4	1110-173C	8
BACN10JC4	1110-174A	4
BACN10JC4	1110-175C	2
BACN10JC4	1110-175 O	1
BACN10JC4C	1107-28	6
BACN10JC5	1110-175F	2
BACN10JC6	1102-41	1
BACN10JD104	1101-8	2
BACN10JD104	1101-13	2
BACN10JD104	1102-9	2
BACN10JD104	1102-32	1
BACN10JD105	1106-12	1
BACN10JD105	1106-19	1
BACN10JD106	1102-28	1
BACN10JD106AU	1109-2	4
BACN10JD106AU	1109-10	2
BACN10JD106AU	1109-25	2
BACN10JD106AU	1109-46	2
BACN10JD106AU	1109-55	2
BACN10JD106AU	1109-60	2
BACN10JD107	1107-13	2
BACN10JD108	1107-6	2
BACN10JD110AU	1109-95	2
BACN10JD112		
BACN10JD112	1102-48	1
BACN10JD112	1107-24	2
BACN10JD4AU	1107-17	1
BACN10JD6	1101-27	4

Part No.	Fig. and Index No.	Qty. per Assy
BACN10JD6	1102-21	1
BACN10JD7	1107-13	2
BACN10JN3CM	1115-35	4
BACN10JP4B	1108-10	2
BACN10JP4B	1108-24	4
BACN10JR08F	1103-28	14
BACN10JR08F	1104-20	13
BACN10JR08F	1105-22	2
BACN10JR08FR	1110-12	3
BACN10JR08FR	1110-27	3
BACN10JR08FR	1112-15	3
BACN10JR08FR	1113-65	3
BACN10JR08FR	1114-20	3
BACN10JR08FR	1114-33	3
BACN10JR3	1114-68	1
BACN10JR3	1114-73	1
BACN10JR3F	1105-20	1
BACN10JR3F	1110-169	4
BACN10JR3F	1110-174X	8
BACN10JR3F	1112-32	15
BACN10JR3F	1113-78	15
BACN10JR3F	1114-46	12
BACN10JR4F	1108-9	4
BACN10KB08FR	1110-11	2
BACN10KB08FR	1110-26	2
BACN10KB08FR	1112-14	2
BACN10KB08FR	1113-64	2
BACN10KB08FR	1114-19	3
BACN10KB08FR	1114-32	2
BACN10KB3F	1110-38	16
BACN10KB3F	1112-30	20
BACN10KB3F	1113-76	20
BACN10KB3F	1114-44	16
BACN10KB4	1110-103	1
BACN10KB4	1110-114	1
BACN10MK3-45	1110-77	3
BACN10MK3-45	1110-131	1
BACN10MK3-65	1110-174	1
BACN10MS3-6	1110-80	1
BACN10NL16T	1102-2	AR
BACR15BA3AD	1115-37	8
BACR15BA3D1	1110-174Y	16
BACR15BA8	1102-216	4
BACR15BB4D	1110-130	2
BACR15BB5D	1110-129A	2
BACR15BB5D	1110-166A	8
BACR15BB5D	1110-172L	6
BACR15BB5D	1110-172O	6
BACR15BB5D	1110-174H	6

Part No.	Fig. and Index No.	Qty. per Assy
BACR15BB5D	1110-185	6
BACR15BB5D	1110-190	6
BACR15BB5D	1110-201	6
BACR15BB5D	1110-205	6
BACR15BE5D	1110-172N	4
BACR15CE5	1113-58J	20
BACR15CE5B	1110-159	AR
BACR15CE5B	1110-181A	2
BACR15CE5B	1110-184	6
BACR15CE5B	1110-199	6
BACR15CE5D	1104-17	2
BACR15CE5D	1110-151	2
BACR15CE5D	1110-163	5
BACR15CE5D	1110-166D	16
BACR15CE5D	1110-172E	20
BACR15CE5D	1110-187	2
BACR15CE5D	1110-186	2
BACR15CE5D	1110-202	4
BACR15CE5D	1112-56	16
BACR15CE5D	1113-28	2
BACR15CE5D	1113-33	2
BACR15CE5D	1113-37	16
4BACR15CE5D	1114-65	2
BACR15CE5D2	1110-14	12
BACR15CE5D2	1110-29	12
BACR15CE5D2	1112-17	AR
BACR15CE5D2	1113-67	60
BACR15CE5D2	1114-22	AR
BACR15CE5D2	1114-24	AR
BACR15CE5D2	1114-35	AR
BACR15CE5D2	1114-37	AR
BACR15CE6	1114-46C	18
BACR15CE6D	1110-146	2
BACR15CE6D	1110-166E	2
BACR15CE6D	1110-172F	2
BACR15CE6D	1111-15	2
BACR15CE6D	1110-60	1
BACR15CE6D	1115-90	2
BACR15DJ5-2	1110-16	AR
BACR15DJ5-2	1110-31	AR
BACR15DJ5-2	1112-19	AR
BACR15DJ5-2	1113-69	AR
BACR15DJ5P2	1108-50	18
BACR15DJ5P2	1108-56	52
BACR15DJ5P2	1108-70	36
BACR15DJ6-3	1110-160	1
BACR15FT6D	1115-75	4
BACR15FT5D	1115-80	6
BACR15FT6D	1115-85	4

Part No.	Fig. and Index No.	Qty. per Assy
BACS18K10-33	1110-181F	1
BACS40A16-112	1112-66	2
BACS40A16-44	1113-43	AR
BACS40R08E13	1107-33	4
BACS40R08E65F	1115-40	1
BACS40R09B14	1108-48	4
BACS40R09B14	1108-58	2
BACS40R09B14	1108-68	2
BACS40R09C14	1108-49	4
BACS40R09C14	1108-59	2
BACS40R09C14	1108-69	2
BACS40R10C55F	1110-175B	1
BACS40R12B30F	1110-175M	1
BACS40R12C103	1110-123	2
BACS40R12C94	1110-74	2
BACS40R12D75	1110-124	2
BACS40R12E42	1110-73	2
BACS40R7C8	1110-175T	1
BACS40R8B18	1110-62	1
BACS40R8B18	1110-71	1
BACS40R8B18	1110-110	1
BACS40R8B18	1110-121	1
BACW10CT6CU	1110-174K	14
BACW10P237S	1102-95	1
BACW10P237S	1102-133	1
BACW10P254C	1102-23	1
BACW10P254C	1102-43	1
BACW10P294AL	1112-28	AR
BACW10P294AL	1113-52	AR
BACW10P42S	1102-198	4
BACW10P91L	1114-5	AR
BACW10UD10	1105-4	1
BACW10UD8	1103-2	29
BACW10UD8	1104-2	21
BACW10UD8	1105-2	24
BR4M9	1101-18	1
GRR4H10-2	1101-21	1
HP1017100-2	1106-4	1
HP1017100-3	1106-4	1
J6256-22	1108-21	4
MS10968-092		AR
MS19070-092		AR
MS20002-10		AR
MS20002-4		AR

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MS20002C10		AR
MS20002C12		AR
MS20002C4		AR
MS20002C6		AR
MS20002C7		AR
MS20010-34		AR
MS20426A4		AR
MS20426D3		AR
MS20426D5		AR
MS20426D8		AR
MS20427M4		AR
MS20470D3		AR
MS20470D4		AR
MS20470D5		AR
MS20470D6		AR
MS21042L06		AR
MS24665-134		AR
MS24665-287		AR
MS24665-304		AR
MS24665-357		AR
MS24665-359		AR
MS24665-360		AR
MS24665-362		AR
MS24665-376		AR
MS27111-3		AR
MS27111-5		AR
MS27253F1		AR
MS51966-67		AR
NAS1080-6		AR
NAS1080-8		AR
NAS1103-2		AR
NAS1103-27		AR
NAS1103-3		AR
NAS1103-35		AR
NAS1103-4		AR
NAS1103-5		AR
NAS1103-6		AR
NAS1103-7		AR
NAS1104-11		AR
NAS1104-16D		AR
NAS1104-18D		AR
NAS1104-4		AR

Part No.	Fig. and Index No.	Qty. per Assy
NAS1104-5		AR
NAS1104-6		AR
NAS1104-7		AR
NAS1104-8		AR
NAS1104-9		AR
NAS1105-15D		AR
NAS1105-16D		AR
NAS1106-32D		AR
NAS1108-36		AR
NAS1110-26D		AR
NAS1112-57D		AR
NAS1303-1		AR
NAS1303-2		AR
NAS1303-5		AR
NAS1303-7		AR
NAS1304-5		AR
NAS1304-6		AR
NAS1304-7		AR
NAS1304-9		AR
NAS1305-9		AR
NAS1306-20D		AR
NAS1306-22D		AR
NAS1368N4B		AR
NAS1368N6A		AR
NAS1368N6B		AR
NAS1368N8A		AR
NAS1398D6-4		AR
NAS43DD3-12		AR
NAS43DD3-16		AR
NAS43DD3-83		AR
NAS43DD3-96		AR
NAS43DD6-16		AR
NAS43HT12-42		AR
NAS43HT12-46		AR
NAS43HT12-59		AR
NAS43HT16-66		AR
NAS43HT3-38		AR
NAS43HT8-21		AR
NAS463XDD416H		AR
NAS514P1032-10		AR
NAS516-1		AR
NAS601-6		AR
NAS603-13P		AR
NAS603-8P		AR
NAS620-10		AR
NAS620-10L		AR
NAS620-6L		AR
NAS623-3-1		AR
NAS623-3-2		AR
NAS623-3-26		AR
NAS623-3-5		AR
NAS679A3		AR
NAS679A3W		AR
NAS679A4W		AR
NAS679A6		AR
NAS679C4W		AR
NAS684A08		AR
NAS686A3		AR
NAS687A3		AR
NAS75-6-107		AR
NAS76A3-10		AR
NAS76A6-008P		AR
NAS77A6-8P	1101-31A	1
RR4M9E6531	1101-18	1
YD109B	1109-160	2
YD109N	1109-160	2
YS211B	1109-21	1
YS211B	1109-51	2
YS211B	1109-72	1
YS211B	1109-111	1
10-1180-3	1115-55	1
10-61237-1	1106-4	1
10-61237-2	1106-4	1
65-55755-10	1110-180C	1
65-55755-11	1110-180D	1
65-55755-12	1110-180D	1
65-55755-5	1110-180C	1
65-55755-6	1110-180C	1
65-55755-7	1110-180D	1
65-55755-8	1110-180D	1
65-55755-9	1110-180C	1
65-56632-1	1101	
65-56632-2	1101	
65-58164-1	1110-21	2
65-58164-1	1112-9	5
65-58164-1	1113-59	5
65-58164-1	1114-14	3
65-58164-10	1113-58Q	1
65-58164-11	1114-46M	1
65-58164-12	1110-13	1
65-58164-12	1110-28	1
65-58164-12	1112-16	1
65-58164-12	1113-66	5

Part No.	Fig. and Index No.	Qty. per Assy.
65-58164-12	1114-21	3
65-58164-12	1114-34	1
65-58164-15	1110-15	1
65-58164-15	1110-30	1
65-58164-15	1112-18	5
65-58164-15	1113-68	5
65-58164-15	1114-25	3
65-58164-15	1114-38	1
65-58164-16	1110-17	1
65-58164-16	1112-20	1
65-58164-16	1114-23	1
65-58164-16	1114-36	1
65-58164-2	1114-27	1
65-58164-22	1110-21	2
65-58164-22	1112-9	5
65-58164-22	1113-59	5
65-58164-22	1114-14	3
65-58164-23	1114-27	1
65-58164-24	1110-6	2
65-58164-28	1110-21	2
65-58164-28	1112-9	5
65-58164-28	1113-59	5
65-58164-28	1114-14	3
65-58164-29	1110-6	2
65-58164-3	1110-6	2
65-58164-30	1114-27	1
65-58164-31	1110-194	1
65-58164-31	1113-58N	2
65-58164-31	1114-46H	2
65-58164-32	1113-58M	2
65-58164-32	1114-46G	1
65-58164-33	1110-172P	1
65-58164-35	1114-46I	1
65-58164-36	1110-13	1
65-58164-36	1110-28	1
65-58164-36	1112-16	1
65-58164-36	1113-66	1
65-58164-36	1114-21	1
65-58164-36	1114-34	1
65-58164-37	1110-18	1
65-58164-37	1110-33	1
65-58164-37	1112-21	5
65-58164-37	1113-71	5
65-58164-37	1114-26	3
65-58164-37	1114-39	1

Part No.	Fig. and Index No.	Qty. per Assy.
65-58164-38	1110-167	2
65-58164-38	1110-206	1
65-58164-39	1110-171	2
65-58164-4	1110-194	1
65-58164-4	1113-58N	2
65-58164-4	1114-46H	2
65-58164-41	1114-46M	1
65-58164-43	1110-18	1
65-58164-43	1110-33	1
65-58164-43	1112-21	1
65-58164-43	1114-26	1
65-58164-43	1114-39	1
65-58164-44	1110-172	1
65-58164-44	1114-46L	3
65-58164-45	1110-21	1
65-58164-45	1112-9	5
65-58164-45	1114-14	3
65-58164-46	1110-6	2
65-58164-47	1114-27	1
65-58164-48	1110-194	1
65-58164-48	1114-46H	2
65-58164-49	1114-46G	1
65-58164-5	1110-167	2
65-58164-5	1110-206	1
65-58164-5	1113-58M	2
65-58164-5	1114-46G	1
65-58164-50	1110-172P	1
65-58164-52	1114-46I	1
65-58164-53	1110-167	1
65-58164-53	1110-206	1
65-58164-6	1110-172P	1
65-58164-6	1113-58L	1
65-58164-7	1114-46I	1
65-58164-8	1110-18	1
65-58164-8	1110-33	1
65-58164-8	1112-21	5
65-58164-8	1113-71	5
65-58164-8	1114-26	3
65-58164-8	1114-39	1
65-58164-9	1110-172	1
65-58164-9	1113-58R	4
65-58164-9	1114-46L	3
65-58165-4	1110-193	1
65-58165-4	1113-58P	2
65-58165-4	1114-46K	3

Part No.	Fig. and Index No.	Qty. per Assy.
65-58165-6	1110-209	1
65-58165-6	1114-46D	1
65-58168-1	1101-32	1
65-58168-1	1110	
65-58168-1	1111-20	1
65-56168-23	1110-211	1
65-58168-31	1110	
65-58168-31	1101-32	1
65-58168-33	1110-136	2
65-58168-34	1110-174D	1
65-58169-1	1101-33	1
65-58169-1	1112	
65-58169-1	1113-48	1
65-58169-15	1112-51	2
65-58169-15	1113-31	2
65-58169-25	1112-43	1
65-58169-26	1112-48	1
65-58169-30	1101-33	1
65-58169-30	1112	
65-58169-32	1112-61	1
65-58169-34	1112-44	1
65-58169-35	1112-45	1
65-58170-1	1101-34	1
65-58170-1	1114	
65-58229-1	1101-1	1
65-58229-1	1102	
65-58229-10	1102-122	1
65-58229-11	1102-84	1
65-58229-12	1102-173	1
65-58229-13	1102-132	1
65-58229-14	1102-94	1
65-58229-15	1102-122	1
65-58229-16	1102-144	1
65-58229-2	1101	1
65-58229-2	1102	
65-58229-3	1102-192	1
65-58229-4	1102-161	1
65-58229-5	1102-113	1
65-58229-6	1102-69	1
65-58229-7	1102-218	1
65-58229-8	1102-207	1
65-58229-9	1102-142	1
65-58232-1	1102-25	1
65-58232-1	1109	
65-58232-2	1109-141	AR
65-59344-1	1110-175X	1
65-59344-10	1110-175X	1

Part No.	Fig. and Index No.	Qty. per Assy.
65-59344-11	1110-180B	1
65-59344-12	1110-180B	1
65-59344-13	1110-175X	1
65-59344-14	1110-175X	1
65-59344-17	1110-180B	1
65-59344-18	1110-180B	1
65-59344-19	1110-175X	1
65-59344-2	1110-175X	1
65-59344-20	1110-175X	1
65-59344-21	1110-180B	1
65-59344-22	1110-180B	1
65-59344-3	1110-180B	1
65-59344-4	1110-180B	1
65-59344-5	1110-175X	1
65-59344-7	1110-180B	1
65-59344-9	1110-175X	1
65-59345-1	1110-101	1
65-59345-2	1110-112	1
65-59345-3	1110-111	1
65-59345-4	1110-122	1
65-59345-6	1110-112	1
65-59345-8	1110-122	1
65-59346-1	1110-55	1
65-59346-2	1110-64	1
65-59346-3	1110-63	1
65-59346-3	1111-83	1
65-59346-4	1110-72	1
65-59358-1	1109-19	1
65-59358-2	1109-19	1
65-59358-3	1109-23	1
65-59358-4	1109-23	1
65-59606-1	1102-217	1
65-59607-1	1102-107	1
65-59607-2	1102-107	1
65-59620-1	1109-70	1
65-59620-2	1109-70	1
65-59620-3	1109-76	1
65-59620-4	1109-76	1
65-59620-5	1109-75	1
65-59626-1	1114-81	1
65-59626-2	1114-81	1
65-59626-3	1114-83	1
65-59626-4	1114-83	1
65-59635-1	1109-88	2
65-59635-3	1109-93	1
65-59652-1	1109-28	2
65-59652-2	1109-33	1
65-59652-3	1109-33	1
65-59673-1	1101-24	1

Part No.	Fig. and Index No.	Qty. per Assy.
65-59673-1	1108	
65-59681-1	1108-64	1
65-59681-2	1108-60	1
65-59681-3	1108-67	1
65-59681-4	1108-63	1
65-60515-1	1109-127	2
65-60515-2	1109-135	1
65-60516-1	1109-109	1
65-60516-2	1109-113	1
65-60517-1	1109-162	1
65-60518-1	1109-146A	1
65-60518-2	1109-146A	1
65-60519-1	1109-146	1
65-60519-2	1109-146	1
65-60520-1	1107-16	1
65-60520-2	1107-16	1
65-60520-3	1107-22	1
65-60520-4	1107-22	1
65-60521-1	1109-155	2
65-60523-1	1102-49	1
65-60523-2	1109-49	1
65-60523-3	1109-53	1
65-60523-4	1109-53	1
65-60590-1	1101-6	1
65-60590-1	1107	
65-60591-1	1107-31	1
65-60591-2	1107-31	1
65-61336-1	1101-17	2
65-61336-2	1102-23	1
65-61349-1	1108-36	1
65-61349-2	1108-42	1
65-61349-3	1108-41	1
65-61349-4	1108-47	1
65-61727-1	1114-51	2
65-61727-2	1114-55	1
65-61727-3	1114-53	1
65-61727-4	1114-54	1
65-61728-1	1114-59	2
65-61771-17	1114-46E	1
65-61771-23	1113-58I	3
65-61771-25	1113-78F	1
65-61771-33	1110-172G	1
65-61771-33	1110-174F	1
65-61771-34	1110-161	1
65-61771-35	1110-166F	1
65-61771-36	1110-172M	1
65-61771-45	1110-210	1

Part No.	Fig. and Index No.	Qty. per Assy.
65-61771-46	1110-172H	1
65-61771-49	1110-174G	1
65-61771-50	1110-174G	1
65-61771-56	1113-78C	1
65-61780-1	1101-4	1
65-61780-1	1105	
65-61780-11	1103-3	1
65-61780-12	1103-3	1
65-61780-13	1103-4	1
65-61780-14	1103-4	1
65-61780-2	1101-4	1
65-61780-2	1105	
65-61780-24	1104-22	1
65-61780-25	1104-3	1
65-61780-26	1104-3	1
65-61780-27	1103-3	1
65-61780-28	1103-3	1
65-61780-29	1103-3	1
65-61780-3	1101-3	1
65-61780-3	1104	
65-61780-31	1103-29	1
65-61780-32	1103-29	1
65-61780-33	1103-30	1
65-61780-34	1103-30	1
65-61780-37	1103-4	1
65-61780-38	1103-4	1
65-61780-39	1103-3	1
65-61780-4	1101-3	1
65-61780-4	1104	
65-61780-40	1103-3	1
65-61780-41	1103-32	1
65-61780-42	1103-32	1
65-61780-43	1103-33	1
65-61780-44	1103-33	1
65-61780-45	1103-34	1
65-61780-46	1103-34	1
65-61780-47	1103-35	1
65-61780-48	1103-35	1
65-61780-49	1103-36	1
65-61780-5	1101-2	1
65-61780-5	1103	
65-61780-50	1103-36	1
65-61780-53	1103-38	1
65-61780-54	1103-38	1
65-61780-55	1103-39	1
65-61780-56	1103-39	1
65-61780-57	1103-40	1
65-61780-58	1103-40	1
65-61780-6	1101-2	1
65-61780-6	1103	

Part No.	Fig. and Index No.	Qty. per Assy
65-61780-61	1103-41	1
65-61780-62	1103-41	1
65-61780-63	1103-37	1
65-61780-64	1103-37	1
65-61780-7	1105-5	1
65-61780-8	1105-5	1
65-63358-1	1112-38	1
65-63358-6	1112-38	1
65-63358-6	1113-3	1
65-63365-1	1108-57	4
65-63365-2	1108-51	2
65-63365-2	1108-71	2
65-68950-1	1101-5	1
65-68950-1	1106	
65-68950-2	1101-5	1
65-68950-2	1106	
65-68951-1	1106-22	1
65-68951-2	1106-24	1
65-68952-1	1106-15	1
65-68952-2	1106-17	1
65-68953-1	1106-7	1
65-68953-2	1106-7	1
65-68954-1	1113-44	1
65-68954-2	1113-44	1
65-68954-3	1113-47	1
65-68955-1	1112-62	1
65-68955-2	1112-64	1
65-68956-1	1101-33	1
65-68956-1	1113	
65-68956-13	1101-33	1
65-68956-13	1113	
65-68956-14	1113-11	1
65-68956-15	1113-12	1
65-68956-3	1113-10	1
65-68956-4	1113-25	1
65-68956-6	1113-42	2
65-68956-8	1113-41	1
65-68957-1	1101-32	1
65-68957-1	1111	
65-68957-2	1111-5	2
65-68958-1	1112-65	1
65-68959-1	1113-44	1
65-85860-11	1110-173A	2
65-85860-2	1110-175N	1
65-85860-5	1110-175R	1
65-85860-6	1110-174S	AR
65-85860-9	1110-174S	AR
65-85872-1	1110-175A	1
65-85872-11	1110-175L	1
65-85872-14	1110-175A	1
65C14993-14	1110-180C	1
65C14993-15	1110-180C	1
65C14993-16	1110-175X	1
65C14993-17	1110-175X	1
65C14993-5	1110-180C	1
65C14993-6	1110-180C	1
65C14993-7	1110-175X	1
65C14993-8	1110-175X	1
65C31295-1	1115	
65C31295-2	1115-5	1
65C31295-3	1115-10	1
65C31295-4	1115-15	2
65C31295-5	1115-20	4
66-15508-1	1101-22	1
69-25236-11	1110-129C	1
69-25236-20	1110-129B	1
69-46262-1	1109-6	2
69-46262-2	1109-8	1
69-46280-1	1102-38	1
69-46280-2	1102-40	1
69-46281-1	1102-17	1
69-46281-2	1102-19	1
69-46282-1	1102-13	1
69-46282-2	1102-15	1
69-46650-1	1109-58	2
69-46651-1	1114-87	2
69-46651-2	1114-88	2
69-46607-1	1102-12	1
69-46607-2	1102-35	1
69-46682-1	1109-126	2
69-46684-1	1109-18	2
69-46684-2	1109-69	2
69-46684-3	1109-87	2
69-46684-4	1109-44	2
69-46684-5	1109-63	2
69-46804-1	1102-195	1
69-46805-1	1102-203	1
69-46805-2	1102-205	1
69-46806-1	1102-164	1
69-46807-1	1102-166	1
69-46807-2	1102-166	1
69-46807-3	1102-169	1
69-46807-4	1102-169	1
69-46808-1	1102-116	1
69-46808-2	1102-116	1
69-46809-1	1102-118	1
69-46809-2	1102-118	1

Part No.	Fig. and Index No.	Qty. per Assy.
69-46809-3	1102-121	1
69-46809-4	1102-121	1
69-46810-1	1102-71	1
69-46810-2	1102-71	1
69-46811-1	1102-77	1
69-46811-2	1102-79	1
69-46812-1	1102-73	1
69-46812-2	1102-75	1
69-46813-1	1102-93	1
69-46813-1	1102-131	1
69-46813-2	1102-93	1
69-46813-2	1102-131	1
69-46814-1	1102-213	1
69-46814-2	1102-215	1
69-46815-1	1102-209	1
69-46815-2	1102-211	1
69-46816-1	1102-146	1
69-46816-2	1102-148	1
69-46817-1	1102-125	1
69-46817-2	1102-127	1
69-46817-3	1102-125	1
69-46817-4	1102-127	1
69-46818-1	1102-87	2
69-46818-3	1102-87	2
69-46818-4	1102-89	1
69-46819-1	1102-59	1
69-46819-1	1102-65	1
69-46819-1	1102-81	1
69-46819-1	1102-110	1
69-46819-1	1102-139	1
69-46819-1	1102-158	1
69-46819-1	1102-189	1
69-46819-2	1102-55	1
69-46819-3	1102-24	1
69-46819-3	1102-44	1
69-46820-1	1102-185	1
69-46820-2	1102-185	1
69-46821-1	1102-187	1
69-46821-2	1102-187	1
69-46822-1	1102-99	1
69-46822-1	1102-137	1
69-46822-2	1102-99	1
69-46822-2	1102-137	1
69-46823-1	1102-4	1
69-46824-1	1102-180	1
69-46824-2	1102-180	1

Part No.	Fig. and Index No.	Qty. per Assy.
69-46824-3	1102-182	1
69-46824-4	1102-182	1
69-46825-1	1102-100	1
69-46826-1	1102-62	1
69-46827-1	1102-103	1
69-46827-1	1102-153	1
69-46827-1	1102-172	1
69-46827-2	1102-61	1
69-46827-2	1102-67	1
69-46827-2	1102-83	1
69-46827-2	1102-112	1
69-46827-2	1102-141	1
69-46827-2	1102-160	1
69-46827-2	1102-191	1
69-46827-3	1102-56	1
69-46828-1	1102-96	1
69-46828-1	1102-134	1
69-46873-2	1109-99	1
69-46874-1	1109-104	1
69-46874-2	1109-31	1
69-46875-1	1109-100	1
69-46876-1	1109-101	1
69-46884-1	1109-29	1
69-46884-2	1109-37	1
69-46885-1	1109-35	1
69-46893-1	1109-38	1
69-46893-2	1109-38	1
69-46899-1	1109-159	1
69-47442-1	1109-32	2
69-47442-1	1109-103	1
69-47442-2	1109-30	1
69-47442-2	1109-102	1
69-47531-1	1109-5	2
69-47531-2	1109-12	2
69-47531-2	1109-27	2
69-47531-3	1109-48	2
69-47531-3	1109-57	2
69-47531-4	1102-30	1
69-47800-1	1109-16	2
69-47800-2	1109-67	2
69-47800-3	1109-85	2
69-47800-4	1109-42	2
69-47807-1	1109-121	2
69-47810-1	1109-132	1
69-47811-1	1109-134	1

Part No.	Fig. and Index No.	Qty. per Assy.
69-47811-2	1109-130	1
69-47811-3	1109-112	1
69-48220-1	1110-178	2
69-48710-1	1108-22	4
69-48710-2	1108-25	1
69-48711-1	1108-14	8
69-48712-1	1108-7	4
69-48712-2	1108-11	1
69-48715-1	1110-60	1
69-48715-1	1110-108	1
69-48715-2	1110-69	1
69-48715-2	1110-119	1
69-48715-3	1110-61	1
69-48715-3	1110-70	1
69-48715-3	1110-109	1
69-48715-3	1110-120	1
69-48729-1	1109-120	1
69-48737-1	1109-140	4
69-48738-1	1109-137	4
69-48739-1	1101-138	4
69-48740-1	1109-116	1
69-48740-1	1109-149	2
69-48740-1	1109-151	2
69-48740-2	1109-115	1
69-48740-2	1109-148	1
69-48740-2	1109-150	1
69-48740-3	1109-122	2
69-48740-3	1109-124	2
69-48740-4	1109-123	1
69-48740-5	1109-114	1
69-48740-5	1109-147	1
69-48740-5	1109-161	2
69-48910-1	1107-26	2
69-48922-1	1101-17	2
69-48922-2	1101-23	1
69-48947-1	1102-21	1
69-48995-1	1102-201	1
69-48996-1	1102-123	4
69-48996-2	1102-108	8
69-48996-3	1102-123	4
69-48997-1	1102-20	1
69-49723-1	1110-176	2
69-49723-1	1112-69	2
69-49723-1	1113-83	2
69-49749-1	1107-4	2
69-49762-1	1108-17	3

Part No.	Fig. and Index No.	Qty. per Assy.
69-49762-2	1108-4	4
69-49762-4	1108-26	4
69-49762-5	1108-18	1
69-49782-1	1113-78D	3
69-49782-1	1114-46F	3
69-49782-2	1110-172F	1
69-49782-3	1110-200	1
69-49782-3	1113-78E	1
69-49782-4	1110-174E	1
69-49787-1	1103-20	1
69-49787-2	1103-20	1
69-49787-3	1103-24	1
69-49787-4	1103-18	1
69-49787-4	1103-18A	1
69-49787-4	1103-18B	1
69-49787-5	1103-22	1
69-49787-6	1103-18A	1
69-49787-6	1103-18B	1
69-49788-1	1103-16	1
69-49788-2	1103-7	1
69-49788-2	1103-14	2
69-49788-3	1103-12	1
69-49788-4	1103-12	1
69-49788-5	1105-12	1
69-49788-6	1105-12	1
69-49789-1	1103-10	2
69-49789-1	1104-12	4
69-49789-1	1105-16	6
69-49789-2	1105-8	1
69-49789-3	1105-18	1
69-49789-4	1105-18	1
69-50376-1	1114-66	2
69-50376-3	1114-69	1
69-50377-1	1114-71	1
69-50377-2	1114-71	1
69-50377-3	1114-76	1
69-50377-5	1114-75	1
69-50377-6	1114-6	AR
69-50378-1	1112-27	2
69-50378-1	1113-51	2
69-50378-1	1114-4	4
69-50392-1	1104-6	1
69-50392-2	1104-6	1
69-50392-3	1104-14	1
69-50392-4	1104-14	1
69-50392-5	1104-16	1
69-50392-6	1104-16	1

Part No.	Fig. and Index No.	Qty. per Assy
69-50392-8	1104-18	1
69-50392-9	1104-18	1
69-52255-1	1101-31	1
69-52290-1	1110-17	1
69-52290-1	1110-32	1
69-52290-1	1112-20	5
69-52290-1	1113-70	5
69-52290-1	1114-23	3
69-52290-1	1114-36	1
69-54383-1	1102-150	1
69-54840-1	1112-26	2
69-54840-1	1113-50	2
69-55164-1	1106-9	1
69-55164-2	1106-8	1
69-55173-1	1110-138	1
69-55173-1	1111-7	1
69-55173-2	1110-150	1
69-55173-2	1111-19	1
69-55173-3	1110-149	1
69-55173-3	1111-18	1
69-55173-4	1110-147	1
69-55173-4	1111-16	1
69-55173-5	1110-142	2
69-55173-5	1111-11	2
69-55173-6	1110-145	2
69-55173-6	1110-14	2
69-55174-3	1110-150A	1
69-55463-1	1112-60	1
69-55463-1	1113-41	1
69-55957-1	1110-175S	1
69-55957-2	1110-175R	1
69-56497-1	1113-62	5
69-56497-2	1110-9	1
69-56497-2	1110-24	1
69-56497-2	1112-12	1
69-56497-2	1114-17	3
69-56497-2	1114-30	1
69-61351-1	1110-189B	1
69-61351-2	1110-181C	1
69-68808-2	1103-42	1
69-68808-3	1103-31	1
69-68808-4	1103-31	1
69-76268-1	1115-30	1
808512-401	1110-36	8
808512-401	1112-24	10
808512-401	1113-74	10
808512-401	1114-42	6

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