TO: ALL HOLDERS OF RAM AIR EXHAUST ASSEMBLY COMPONENT MAINTENANCE MANUAL 21-53-11

REVISION NO. 9 DATED OCT 01/89

HIGHLIGHTS

Pages which have been added or revised are outlined below together with the highlights of the revision. Remove and insert the affected pages as listed and enter Revision No. and date on the Record of Revision Sheet.

CHAPTER/SECTION AND PAGE NO.	DESCRIPTION OF CHANGE
1005,1023	Changed nut part number from BACN10J3CM (Fig. 1, item 305) to BACN10JC3CM (Fig. 1, item 305A).

BOEING

COMPONENT
MAINTENANCE MANUAL

RAM AIR EXHAUST ASSEMBLY

PART NUMBER 213T3102-5 THRU -8

COMPONENT MAINTENANCE MANUAL
WITH
ILLUSTRATED PARTS LIST

59589

REVISION RECORD

- Retain this record in front of manual. On receipt of revision, insert revised pages in the manual, and enter revision number, date inserted and initial.

REVISION NUMBER	REVISION DATE	DATE FILED	BY	REVISION NUMBER	REVISION DATE	DATE FILED	BY

TEMPORARY REVISION AND SERVICE BULLETIN RECORD

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVE	DATE OF INCORPORATION INTO MANUAL

PAGE	DATE	CODE
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TITLE PAGE		
1	JAN 10/85	01.1
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LIST OF EFFECTIVE PAGES		
*1	OCT 01/89	01
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PAGE	DATE	CODE
ILLUSTRATED PARTS LIST		
1001	JUL 10/83	01
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*1005	OCT 01/89	01.1
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1013	JUL 10/83	01.1
1014	JAN 10/87	01.1
1015	APR 10/86	01.1
1016	APR 10/86	01.101
1017	JAN 10/85	01.1
1018	JAN 10/85	01.1
1019	JAN 10/85	01.1
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TABLE OF CONTENTS

*[1] Special instruction not required. Use standard industry practices and information contained in 20-30-03.

INTRODUCTION

The instructions in this manual provide the information necessary to perform maintenance functions ranging from simple checks and replacement to complete shop-type repair.

This manual is divided into separate sections:

1. Title Page
2. Record of Revisions
3. Temporary Revision & Service Bulletin Record
4. List of Effective Pages
5. Table of Contents
6. Introduction
7. Procedures & IPL Sections

Refer to the Table of Contents for the page location of applicable sections.

The beginning of the REPAIR section includes a list of the separate repairs, a list of applicable standard Boeing practices, and an explanation of the True Position Dimensioning symbols used.

An explanation of the use of the Illustrated Parts List is provided in the Introduction to that section.

All weights and measurements used in the manual are in English units, unless otherwise stated. When metric equivalents are given they will be in parentheses following the English units. Design changes, optional parts, configuration differences and Service Bulletin modifications create alternate part numbers. These are identified in the Illustrated Parts List (IPL) by adding an alphabetical character to the basic item number. The resulting item number is called an alpha-variant. Throughout the manual, IPL basic item number references also apply to alpha-variants unless otherwise indicated.

Verification:

Disassembly: February 17,1983
Assembly: February 17,1983

RAM AIR EXHAUST ASSEMBLY

DESCRIPTION AND OPERATION

1. The ram air exhaust door consists of an integral aluminum door hinged at the aft end to the ram air exhaust duct. A link assembly connects the door to a torque tube. The ram air exhaust door actuator controls the rotation of the torque tube. When the actuator retracts, the torque tube rotates. This causes the link assembly to rotate about the torque tube and the door to open. This allows ram air to exit to ambient. Extension of the actuator closes the door.

2. Leading Particulars (approximate)

Length -- 28 inches
Width -- 12 inches
Height -- 16 inches
Weight -- 16 pounds

DISASSEMBLY

NOTE: Disassemble this component only as necessary to complete fault isolation, determine the serviceability of parts, perform required repairs, and restore the unit to serviceable condition.

1. Disassemble Ram Air Exhaust Assembly (IPL, Fig. 1)

   NOTE: Do not remove bushing (160, 195, 270), bearing (100), rivet (273), inserts (350, 380) and nutplate (275) unless necessary for repair or replacement.

   A. Remove bolts (65), washers (70), and access door assembly (60) from duct assembly (415).

   B. Remove bolts (30, 35), washers (40, 45A), nuts (50), and actuator (55).

   C. Remove bolt (15), washers (20), nut (25), and jumper assembly (5) from actuator (55).

   CAUTION: ACTUATOR LINK ASSY (135), BELL CRANK ASSY (170) AND TORQUE TUBE (210) ARE MATCHED PARTS WHICH MUST BE INSTALLED IN ORIGINAL POSITION.

   D. Remove bolt (175), washers (180, 185), nut (190), bellcrank assembly (170), spacer (205) from torque tube (210).

   E. Remove bolts (110), washers (115, 120) and nuts (125) from actuator link assemblies (135).

   F. Remove bolts (90), washers (95) and retainer assemblies (85).

   G. Remove bolts (140), washers (145, 150) and nuts (155) from actuator link assemblies (135). Remove torque tube (210) from actuator link assemblies (135).

   H. Remove bolts (290), washers (295, 300), nuts (305), and door assy (255).

   I. Remove bolts (215), washers (220, 225), nuts (230), and rod assemblies (235).

   J. Remove rod ends (245) and nuts (240) from rods (250).

   K. Remove bolts (260), washers (265) and hinge assembly (285) from door (280).

L. Remove pin (310, 315) from half hinge (320, 325) then separate hinge half (320, 325).

M. Remove screws (370A), washers (375) and nuts (377). Remove mount assembly (365) from duct assembly (415).

N. Remove screws (340A), washers (345) and nuts (347). Remove housing assembly (335) from duct assembly (415D).

CHECK

1. Check all parts for obvious defects in accordance with standard industry practices. Refer to FITS AND CLEARANCES for design dimensions and wear limits.

2. Magnetic particle check per 20-20-01 -- link (165 or 165A), tube (210 or 210A), crank (200), rod (250).

3. Penetrant check per 20-20-02 -- retainer assembly (85), mount assembly (365 or 365A), housing retainer (355), housing (360), and door (280).

REPAIR - GENERAL

1. Contents

A. Repair, refinish, and replacement procedures are included in separate repair sections as follows:

P/N	NAME	REPAIR
213T3006	ACTUATOR LINK	1-1
213T3702	TORQUE TUBE	2-1
213T3703	BELLCRANK	3-1
213T3007	DOOR	4-1
69B03738	RETAINER	5-1
	MISC PARTS REFINISH	6-1
BAC27TEC0209	MARKER	7-1

2. Standard Practices

A. Refer to the following standard practices as applicable, for details of procedures in individual repairs.

20-10-01 Repair and Refinish of High Strength Steel Parts
20-10-02 Machining of Alloy Steel
20-10-04 Grinding of Chrome Plated Parts
20-30-02 Stripping of Protective Finishes
20-30-03 General Cleaning Procedures
20-41-01 Decoding Table for Boeing Finish Codes
20-41-02 Application of Chemical and Solvent Resistant Finishes
20-42-03 Hard Chrome Plating
20-42-05 Bright Cadmium Plating
20-43-01 Chromic Acid Anodizing
20-50-03 Bearing Installation and Retention
20-50-05 Application of Aluminum Foil and Other Markers

3. Materials

NOTE: Equivalent substitutes may be used.

A. Enamel -- BMS 10-60, BAC707, gloss grey (Ref 20-60-02)

B. Corrosion Preventive Compound -- MIL-C-11796 (Ref 20-60-02)

C. Primer -- BMS 10-11, type 1 (Ref 20-60-02)

D. Primer -- BMS 10-79 (Ref 20-60-02)

E. Lubricant -- MIL-L-8937 (Ref 20-60-03)

F. Corrosion Resistant Finish -- BMS 10-20, type 2 (Ref 20-60-02)

4. Dimensioning Symbols

A. Standard True Position Dimensioning Symbols used in applicable repair procedures are shown in Fig. 601.

—	STRAIGHTNESS
▱	FLATNESS
⊥	PERPENDICULARITY (OR SQUARENESS)
//	PARALLELISM
○	ROUNDNESS
⌭	CYLINDRICITY
⌒	PROFILE OF A LINE
⌓	PROFILE OF A SURFACE
◎	CONCENTRICITY
⌯	SYMMETRY
∠	ANGULARITY
↗	RUNOUT
⌖	THEORETICAL EXACT POSITION OF A FEATURE (TRUE POSITION)
∅	DIAMETER
BASIC (BSC) OR [DIM]	A THEORETICALLY EXACT DIMENSION USED TO DESCRIBE SIZE, SHAPE OR LOCATION OF A FEATURE FROM WHICH PERMISSIBLE VARIATIONS ARE ESTABLISHED BY TOLERANCES ON OTHER DIMENSIONS OR NOTES.
[-A-]	DATUM
Ⓜ	MAXIMUM MATERIAL CONDITION (MMC)
Ⓢ	REGARDLESS OF FEATURE SIZE (RFS)
Ⓟ	PROJECTED TOLERANCE ZONE

EXAMPLES

[— | 0.002]	STRAIGHT WITHIN 0.002
[⊥ | B | 0.002]	PERPENDICULAR TO B WITHIN 0.002
[// | A | 0.002]	PARALLEL TO A WITHIN 0.002
[○ | 0.002]	ROUND WITHIN 0.002
[⌭ | 0.010]	CYLINDRICAL SURFACE MUST LIE BETWEEN TWO CONCENTRIC CYLINDERS, ONE OF WHICH HAS A RADIUS 0.010 INCH GREATER THAN THE OTHER
[⌒ | A | 0.006]	EACH LINE ELEMENT OF THE SURFACE AT ANY CROSS SECTION MUST LIE BETWEEN TWO PROFILE BOUNDARIES 0.006 INCH APART IN RELATION TO DATUM PLANE A
[⌓ | A | 0.020]	SURFACES MUST LIE WITHIN PARALLEL BOUNDARIES 0.02 INCH APART AND EQUALLY DISPOSED ABOUT TRUE PROFILE
[◎ | C | ∅ 0.0005]	CONCENTRIC TO C WITHIN 0.0005 DIAMETER (FULL INDICATOR MOVEMENT)
[⌯ | A | 0.010]	SYMMETRICAL WITH A WITHIN 0.010
[∠ | A | 0.005]	ANGULAR TOLERANCE 0.005 WITH A
[⌖ | B | ∅ 0.002 Ⓢ]	LOCATED AT TRUE POSITION WITHIN 0.002 DIA IN RELATION TO DATUM B, REGARDLESS OF FEATURE SIZE
[⊥ | A | ∅ 0.010 Ⓜ] [0.510 Ⓟ]	AXIS IS TOTALLY WITHIN A CYLINDER OF 0.010-INCH DIAMETER, PERPENDICULAR TO, AND EXTENDING 0.510-INCH ABOVE, DATUM A, MAXIMUM MATERIAL CONDITION
[2.000] OR 2.000 BSC	EXACT DIMENSION IS 2.000

True Position Dimensioning Symbols
Figure 601

ACTUATOR LINK ASSEMBLY - REPAIR 1-1

213T3006-1, -4

NOTE: Refer to REPAIR-GEN for list of applicable standard practices.

1. Bushing Replacement (Ref IPL Fig. 1)

   A. Remove bushing (160).

   B. Install replacement bushing.

2. Refinish

   A. Link (165) -- passivate (F-17.09). Material: 15-5PH CRES, heat treated to 125-145 ksi.

TORQUE TUBE - REPAIR 2-1

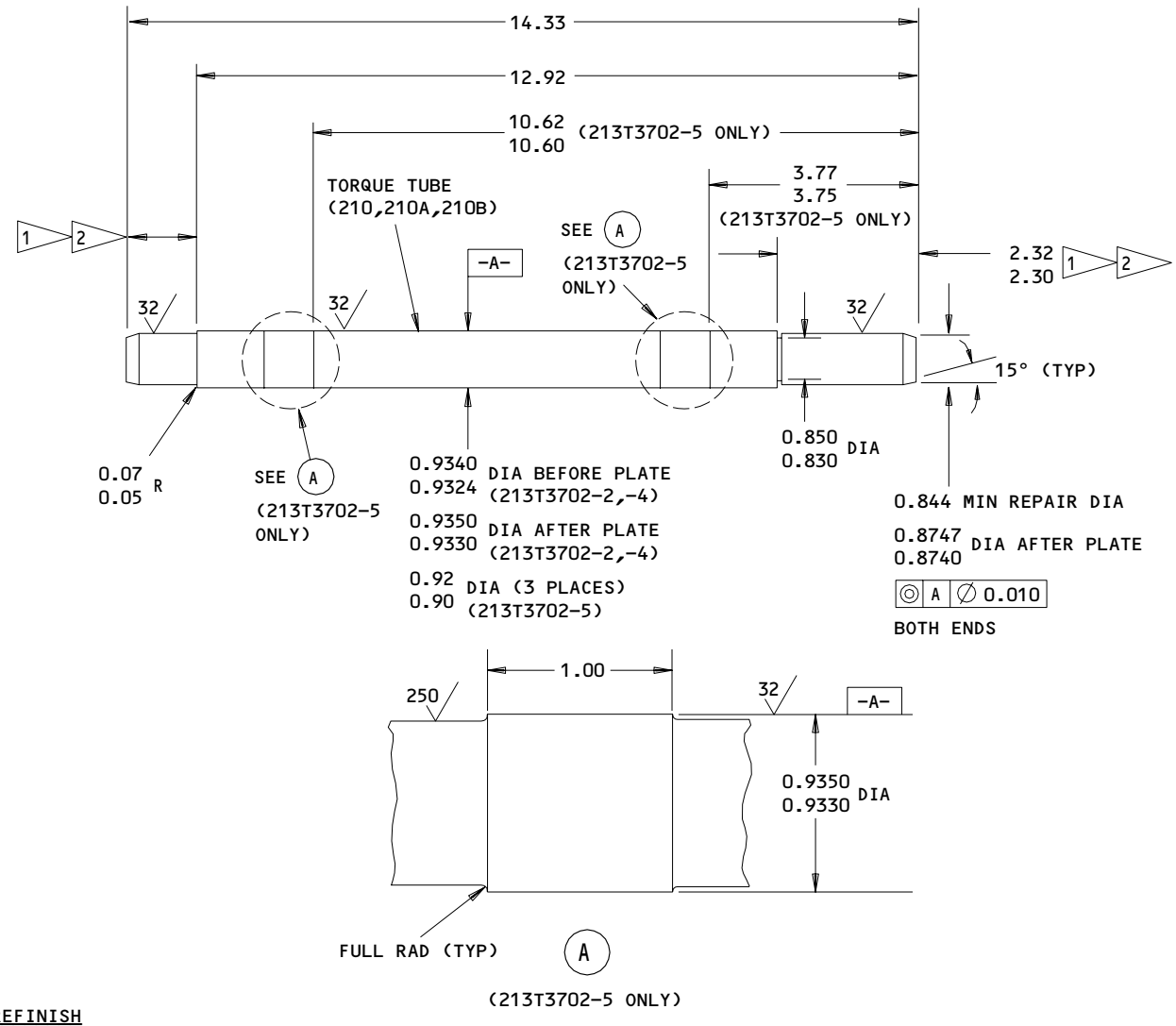
213T3702-2, -4, -5

NOTE: Refer to REPAIR-GEN for list of applicable standard practices. For repair of surfaces which may only require restoration of original finish, refer to Refinish Instructions, Fig. 601.

1. Repair (Fig. 601)

   A. Machine bearing seat as required, within repair limit shown to remove defects.

   B. Chrome plate build up repaired surface and grind to dimensions and finish shown.



REFINISH

TUBE (210) -- CADMIUM PLATE (F-16.04) ON TUBE EXTERIOR WITH THROW-IN ALLOWED ON TUBE INTERIOR. APPLY TWO COATS OF PRIMER BMS 10-11, TYPE 1 (F-20.03) PLUS CLEAN AND APPLY CORROSION PREVENTIVE COMPOUND MIL-C-11796, CLASS 1 (F-19.03) ON INTERIOR. APPLY ONE COAT OF PRIMER BMS 10-11, TYPE 1 (F-20.02) EXCEPT AS NOTED ON EXTERIOR.

TUBE (210A) -- CADMIUM PLATE (F-15.06) ON EXTERIOR. APPLY ONE COAT OF PRIMER BMS 10-11, TYPE 1 (F-20.02) ALL OVER EXTERIOR AND INTERIOR EXCEPT AS NOTED. RUNOUT OF (F-15.06) ALLOWED ON INTERIOR.

TUBE (210B) -- PASSIVATE (F-17.09)

1 NO PRIMER ON THIS SURFACE

REPAIR

2 BUILD UP WITH CHROME PLATE AND GRIND TO DIMENSION AND FINISH SHOWN. CHROME PLATE RUNOUT 0.00-0.08. STOP CHROME PLATE 0.00-0.02 FROM FILLET RADIUS OR EDGE

MATERIAL: TUBE (210,210A) -- 4340 STEEL, 125-145 KSI;
TUBE (210B) -- 15-5 PH CRES, 125-145 KSI

ALL DIMENSIONS ARE IN INCHES

ITEM NUMBERS REFER TO IPL FIG. 1

213T3702-2,-4,-5
Torque Tube Repair
Figure 601

59758

BELL CRANK ASSEMBLY - REPAIR 3-1

213T3703-1

NOTE: Refer to REPAIR-GEN for list of applicable standard practices.

1. Bushing Replacement (Ref IPL Fig. 1)

   A. Remove bushing (195).

   B. Install replacement bushing.

2. Refinish

   A. Crank (200) -- cadmium plate (0.0002 to 0.0004 inch) (F-15.02).
      Material: 15-5PH CRES, heat treated to 125-145 ksi.

DOOR ASSEMBLY - REPAIR 4-1

213T3007-1

NOTE: Refer to REPAIR-GEN for list of applicable standard practices.

1. Bushing Replacement (Ref IPL Fig. 1)

   A. Remove bushing (270).

   B. Install replacement bushing (270) per 20-50-03.

2. Refinish

   A. Door (280) -- chromic acid anodize, type 1, or sulfuric acid anodize type 2 (F-17.05). Apply one coat primer BMS 10-79, type 2 (F-19.46) all over except no primer in holes. Apply one coat BMS 10-60, type 2 BAC707 gray gloss enamel (F-19.39) on outside surface of flanges and lower (smooth) surface of door only. Material: Aluminum alloy.

RETAINER ASSEMBLY - REPAIR 5-1

69B03738-1

NOTE: Refer to REPAIR-GEN for list of applicable standard practices.

1. Bearing Replacement (Ref IPL Fig. 1)

   A. Remove bearing (100) from retainer (105).

   B. Install replacement bearing and roller swage. Bearing must be capable of withstanding 1000 pounds push out load without loosening or permanent shift of the bearing.

2. Refinish (Ref IPL Fig. 1)

   A. Retainer (105) -- apply one coat of primer BMS 10-11, type 1 (F-18.05) all over except outside diameter of retainer. Material: Aluminum alloy.

MISCELLANEOUS PARTS REFINISH - REPAIR 6-1

1. Repair of parts listed in Fig. 601 consists of restoration of the original finish.

IPL FIG. & ITEM	MATERIAL	FINISH
Fig. 1		
Duct assembly (415D, 415E)	Glass fabric	Apply one coat of BMS 10-20 type II corrosion resistant finish (F-19.04) inside of duct and lower surface mounting flange.
Half hinge (320, 325) Housing (360)	Al alloy	Chromic acid anodize and apply one coat of primer BMS 10-11, type 1 (F-18.13) all over except no primer in holes.
Rod (250)	15-5 PH CRES 150-170 ksi	Cadmium plate (F-15.02).
Hinge pin (315)	CRES	Apply solid film lubricant MIL-L-8937 (Ref 20-50-08).
Mount (385), retainer housing (355)	Al alloy	Chromic acid or sulfuric acid anodize (F-17.05) and apply one coat of primer BMS 10-11, type 1 (F-20.02) all over except in holes.
Mount (390)	Al alloy	Apply one coat of primer BMS 10-11, type 1 (F-18.06) all over except inside mount diameter hole.

Refinish Details
Figure 601

MARKER - REPAIR 7-1

BAC27TEC0209

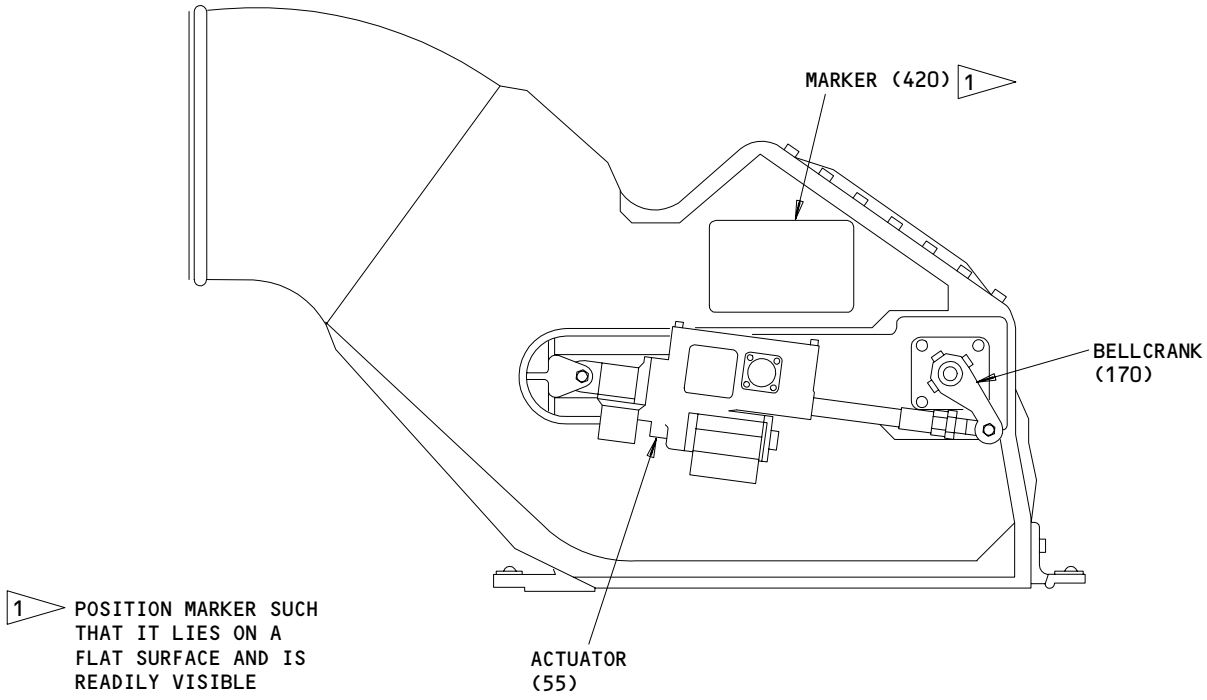
NOTE: Refer to REPAIR-GEN for list of applicable standard practices.

1. Marker Replacement (420, IPL Fig. 1)

   A. Remove damaged or defective marker.

   B. Clean surface of duct per 20-30-03.

   C. Install new marker per 20-50-05. Position marker as shown (Fig. 601).



Marker Application
Figure 601

222354

ASSEMBLY

1. Materials

NOTE: Equivalent substitutes may be used.

A. Sealant -- BMS 5-63 (Ref 20-60-04)

B. Corrosion Preventive Compound -- MIL-C-11796 (Ref 20-60-02)

C. Adhesive -- Type 60 (Ref 20-50-12)

2. Assembly (IPL Fig. 1)

A. Install housing assembly (335) on duct assembly (415D) using screws (340A), washers (345) and nuts (347).

B. Install mount assembly (365) on duct assembly (415D) using screws (370A), washers (375) and nuts (377).

C. Install retainer assembly (85) on mount assembly (365) using bolts (90) and washers (95).

CAUTION: ACTUATOR LINK ASSY (135), BELL CRANK ASSY (170) AND TORQUE TUBE (210) ARE MATCHED SET. ALL PARTS MUST BE INSTALLED IN ORIGINAL POSITION.

D. Insert torque tube (210) through housing assembly (335), actuator link assemblies (135) and into installed bearing (100). Install bolts (140), washers (145, 150) and nuts (155) with sealant.

E. Install retainer assembly (85) on housing assembly (335) with bolts (90) and washers (95).

F. Install spacer (205) and bellcrank assembly (170) on torque tube (210). Install bolt (175), washers (180, 185) and nut (190) with sealant.

G. With actuator (55) in fully extended position as determined by internal limit switch, measure distance between bearing centers. Adjust rod end as required to obtain 14.07-14.13 in. dimension, then tighten nut to 60 lb-in.

H. Place actuator (55) on bellcrank assembly (170) and mount assembly (365). Secure with bolt (30, 35), washers (40, 45A) and nuts (50).

I. Clean bonding area (Ref 20-11-03). Place jumper assembly (5) on actuator (55) and secure with bolt (15), washers (20) and nut (25).

J. Apply corrosion preventive compound to rod ends (245). Install rod ends (245) and nuts (240) on rods (250). Do not tighten nuts (240) in this step.

K. Install rod assemblies (235) on door (280) using bolts (215), washers (220, 225) and nuts (230). Install washer (225) with countersink against bolt head.

L. Attach hinge half (320, 325) together using pin (310, 315).

M. Install hinge half (320) on door (280) and secure with bolts (260) and washers (265).

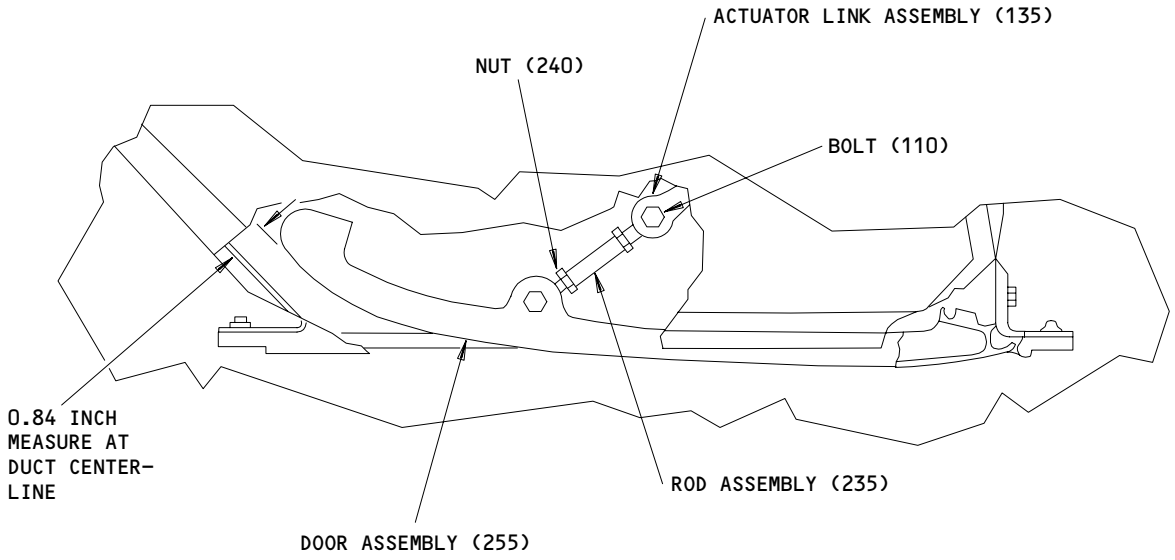
N. Install hinge half (325) on duct assembly (415D) using bolts (290), washers (195, 300) and nuts (305).

O. Insert bolts (110) and washers (120) through link assemblies (135) and rod assemblies (235) then check door adjustment per Fig. 701. If not correct, adjust both rod assemblies (235) as necessary and tighten nuts (240) to 60 lb-in. Install washers (115) and nuts (125). Do not induce bending in door when attaching final rod assembly (bolt must install without forcing door).

P. Bond gasket (75) to door assembly (80) per 20-50-12, type 60. Install access door assembly (60) on duct assembly (415D) with bolts (65) and washers (70).

3. Storage

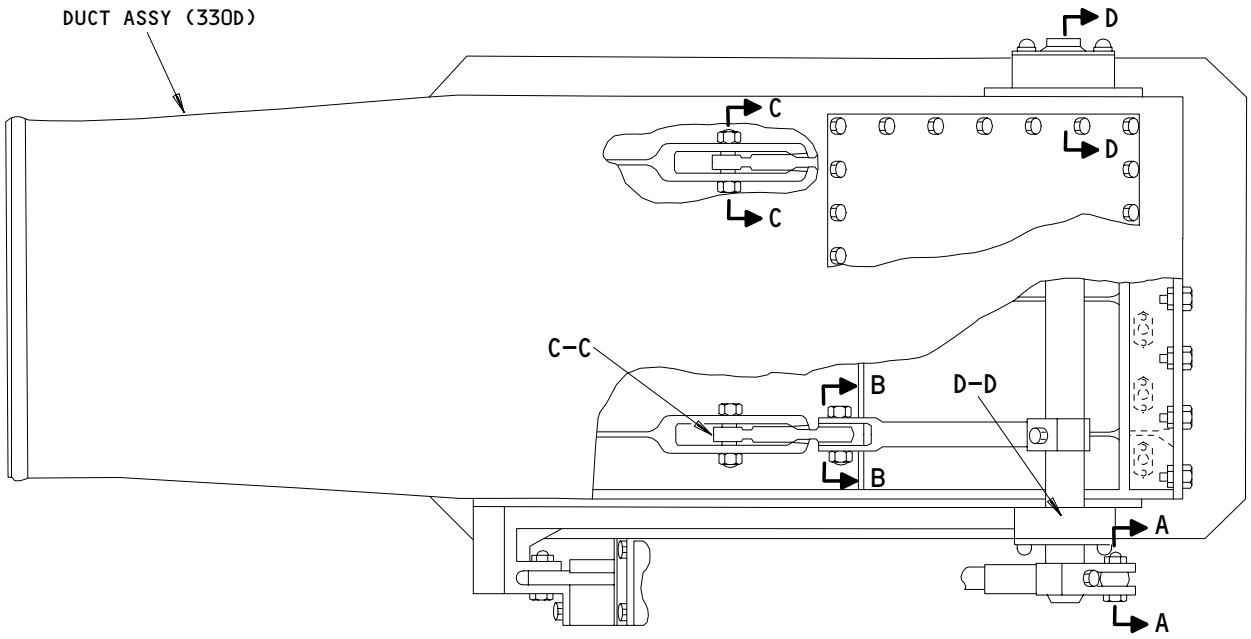
A. Prepare and store component in accordance with standard industry practices.

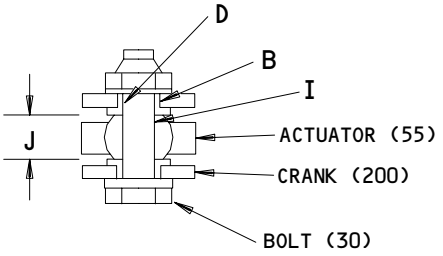


Door Adjustment
Figure 701

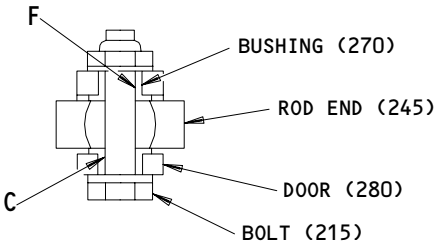
59759

FITS AND CLEARANCES

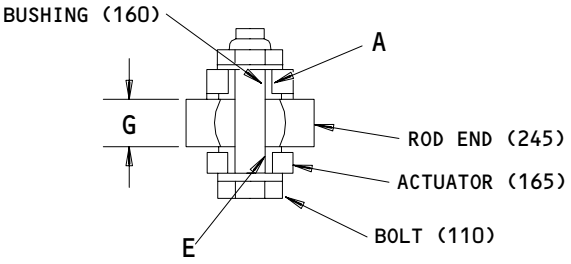




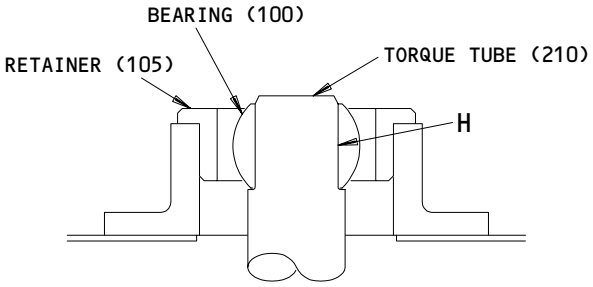
A-A



C-C



B-B



D-D

Fits and Clearances
Figure 801 (Sheet 1)

Ref Letter Fig.801	Mating Item No. IPL Fig.	Design Dimension				Service Wear Limit		
		Dimension		Assembly Clearance *[1]		Dimension		Maximum Clearance
		Min	Max	Min	Max	Min	Max	
A	ID 165 OD 160	0.3748 0.3756	0.3754 0.3761	-0.0013	-0.0002			
B	ID 200 OD 195	0.4373 0.4381	0.4379 0.4386	-0.0013	-0.0002			
C	ID 280 OD 270	0.3745 0.3756	0.3755 0.3761	-0.0016	-0.0001			
D	ID 195 OD 30	0.3110 0.3110	0.3140 0.3120	-0.0010	0.0030			
E	ID 160 OD 110	0.2500 0.2485	0.2515 0.2495	0.0005	0.0030			0.100
F	ID 270 OD 215	0.2485 0.2485	0.2515 0.2495	-0.0010	0.0030			
G	*[2] 160 *[3]	0.438	0.453	0.001	0.016	0.000	0.462	0.025
H	ID 100 OD 210	0.8745 0.8740	0.8755 0.8747	-0.0002	0.0015			0.005
I	ID 55 OD 30	0.3125 0.3110	0.3140 0.3120	0.0005	0.0030			0.010
J	*[2] 200 *[3]	0.375	0.395	0.000	0.022	0.000	0.395	0.022

*[1] NEGATIVE VALUES DENOTE INTERFERENCE FIT
*[2] WIDTH BETWEEN FLANGE FACES OF BUSHINGS
*[3] CLEARANCE BETWEEN BUSHING FLANGE AND BEARING CLAMPED IN LINK CLEVIS

ALL DIMENSIONS ARE IN INCHES

Fits and Clearances
Figure 801 (Sheet 2)

59592

FOR TORQUE VALUES OF STANDARD FASTENERS, REFER TO 20-50-01			
Item No. IPL Fig. 1	Name	Torque	
		Pound-Inches	Pound-Feet
240	Nut	60	
55	Actuator Nut	60	

Torque Table
Figure 802

ILLUSTRATED PARTS LIST

1. This section lists and illustrates replaceable or repairable component parts. The Illustrated Parts Catalog contains a complete explanation of the Boeing part numbering system.

2. Indentures show parts relationships as follows:

    Assembly
      Detail Parts for Assembly
      Subassembly
      Attaching Parts for Subassembly
        Detail Parts for Subassembly

    Detail Installation Parts (Included only if installation parts may be returned to shop as part of assembly)

3. One use code letter (A, B, C, etc.) is assigned in the EFF CODE column for each variation of top assembly. All listed parts are used on all top assemblies except when limitations are shown by use code letter opposite individual part entries.

4. Letter suffixes (alpha-variants) are added to item numbers for optional parts, Service Bulletin modification parts, configuration differences (except left- and right-hand parts), product improvement parts, and parts added between two sequential item numbers. The alpha-variant is not shown on illustrations when appearance and location of all variants of the part is the same.

5. Service Bulletin modifications are shown by the notations PRE SB XXXX and POST SB XXXX.

    A. When a new top assembly part number is assigned by Service Bulletin, the notations appear at the top assembly level only. The configuration differences at detail part level are then shown by use code letter.

    B. When the top assembly part number is not changed by the Service Bulletin, the notations appear at the detail part level.

6. Parts Interchangeability

Optional (OPT)	The parts are optional to and interchangeable with other parts having the same item number.
Supersedes, Superseded By (SUPSDS, SUPSD BY)	The part supersedes and is not interchangeable with the original part.
Replaces, Replaced By (REPLS, REPLD BY)	The part replaces and is interchangeable with, or is an alternate to, the original part.

VENDORS

00779 AMP, INCORPORATED
PO BOX 3608
HARRISBURG, PENNSYLVANIA 17105

06710 VALLEY-TODECO INCORPORATED
12975 BRADLEY AVENUE
SYLMAR,CALIFORNIA 91342

06725 AIR INDUSTRIES CORPORATION
12570 KNOTT STREET
GARDEN GROVE, CALIFORNIA 92641

06950 VSI CORP SCREWCORP DIV
13001 EAST TEMPLE AVENUE
CITY OF INDUSTRY, CALIFORNIA 91746

08524 DEUTSCH FASTENER CORPORATION
PO BOX 92925 7001 WEST IMPERIAL HIGHWAY
LOS ANGELES, CALIFORNIA 90045

09455 LEAR SIEGLER INC TRANSPORT DYNAMICS DIV
PO BOX 1953 3131 WEST SEGERSTROM STREET
SANTA ANA, CALIFORNIA 92702

10630 ANILLO INDUSTRIES, INCORPORATED
2090 NORTH GLASSELL
ORANGE, CALIFORNIA 92667

15653 KAYNAR MFG COMPANY INC KAYLOCK DIV
PO BOX 3001 800 SOUTH STATE COLLEGE BLVD
FULLERTON, CALIFORNIA 92634

15860 NEW HAMPSHIRE BALL BEARINGS, INCORPORATED ASTRO DIVISION
155 LEXINGTON AVENUE
LACONIA, NEW HAMPSHIRE 03246

17943 FEDERAL MANUFACTURING CORPORATION
6910 FARMDALE AVENUE
NORTH HOLLYWOOD, CALIFORNIA 91605

21335 TEXTRON INC FAFNIR BEARING DIVISION
37 BOOTH STREET
NEW BRITAIN, CONNECTICUT 06050

VENDORS

23294 AVALON MACHINE PRODUCTS INC
15337 ALLEN STREET
PARAMOUNT, CALIFORNIA 90723

27624 PAUL R BRILES INC P.B. FASTENER DIV
1700 WEST 132ND STREET PO BOX 1157
GARDENA, CALIFORNIA 90249

50294 NMB INC
9730 INDEPENDENCE AVENUE
CHATSWORTH, CALIFORNIA 91311

52828 REPUBLIC FASTENER MFG CORP
1300 RANCHO CONEJO BLVD
NEWBURY PARK, CALIFORNIA 91320

56878 SPS TECHNOLOGIES INC
HIGHLAND AVENUE
JENKINTOWN, PENNSYLVANIA 19046

70265 ALL POWER MANUFACTURING COMPANY
13141 MOLETTE STREET
SANTE FE SPRINGS, CALIFORNIA 90670

71087 BOOTS ACFT NUT DIV TOWNSEND CO SEE TEXTRON INC CHERRY
FASTENER TOWNSEND DIV V11815

72962 AMERACE CORP ESNA DIV
2330 VAUXHALL ROAD
UNION, NEW JERSEY 07083

73134 HEIM DIV INCOM INTERNATIONAL INC
60 ROUND HILL ROAD
FAIRFIELD, CONNETICUT 06430

73197 HI-SHEAR CORPORATION
2600 SKYPARK DRIVE
TORRANCE, CALIFORNIA 90509

77896 REXNORD INC. BEARING DIVISION
2400 CURTIS STREET
DOWNERS GROVE, ILLINOIS 60515

VENDORS

79500 WESTINGHOUSE ELECTRIC CORP HQ
WESTINGHOUSE BLDG GATEWAY CENTER
PITTSBURG, PENNSYLVANIA 15222

79550 WHITAKER CABLE CORPORATION
2801 ROCKCREEK PARKWAY
NORTH KANSAS CITY, MISSOURI 64116

80539 SPS TECHNOLOGIES INC AEROSPACE PRODUCTS DIV
2701 SOUTH HARBOR BOULEVARD PO BOX 1259
SANTA ANA, CALIFORNIA 92702

81376 SOUTHWEST PRODUCTS COMPANY
2240 BUENA VISTA
IRVINDALE, CALIFORNIA 91706

90255 DAHLSTROM INDUSTRIES INC
9508 WINONA AVENUE
SCHILLER PARK, ILLINOIS 60176

91812 JANCO CORPORATION
3111 WINONA AVENUE,PO BOX 3038
BURBANK, CALIFORNIA 91504

92215 VOI-SHAN DIV OF VSI CORP
8463 HIGUERA STREET
CULVER CITY, CALIFORNIA 90230

93907 TESTRON INC CAMCAR DIV
600 18TH AVENUE
ROCKFORD, ILLINOIS 61101

97613 SARGENT INDUSTRIES KAHR BEARING DIVISION
3010 NORTH SAN FERNANDO ROAD
BURBANK, CALIFORNIA 91503

97928 LITTON FASTENING SYSTEMS DIV OF LITTON SYSTEMS INC
3969 PARAMONT BOULEVARD
LAKEWOOD, CALIFORNIA 90712

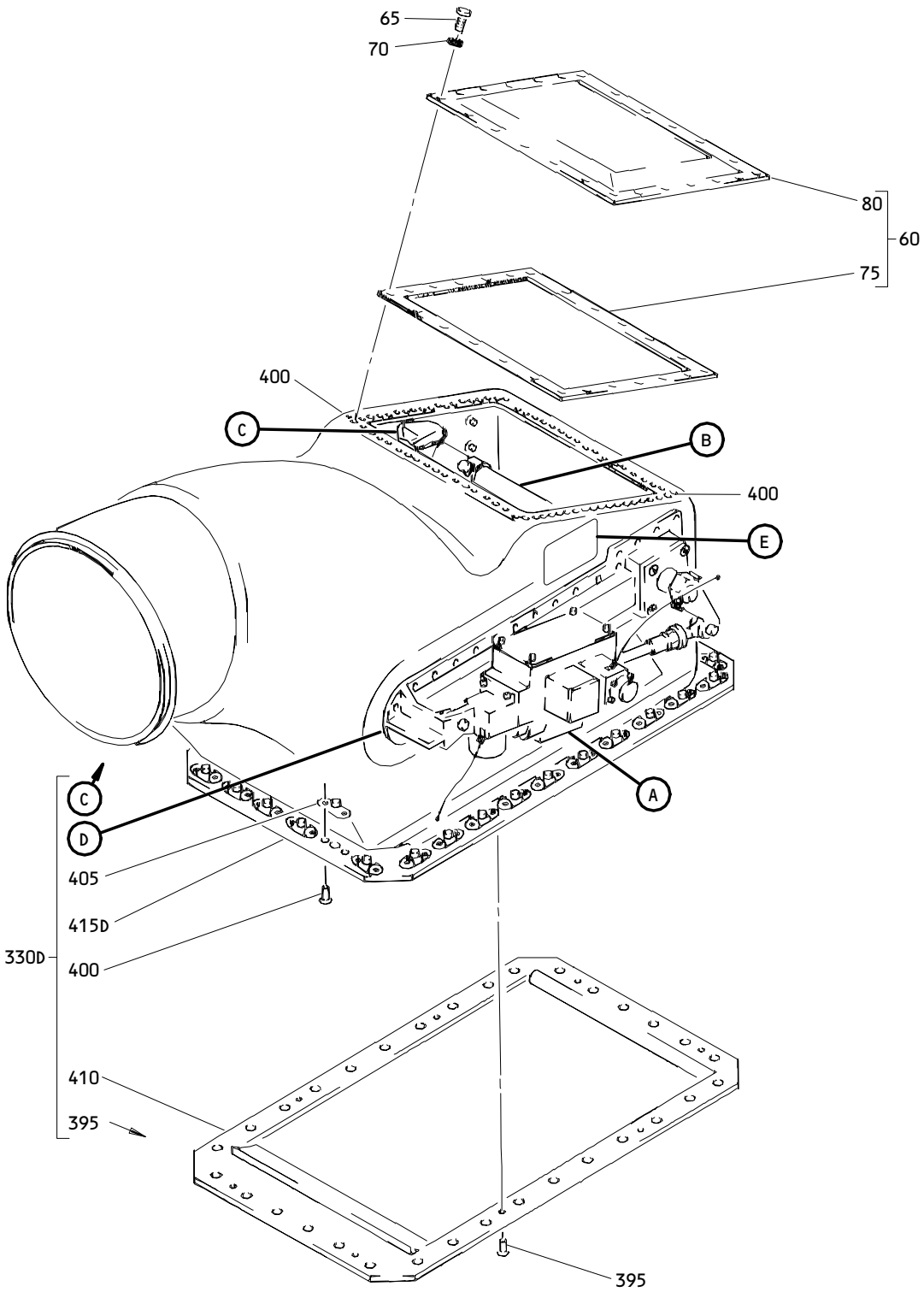
PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
ABWT14V102		1	100	2
AN316C5R		1	240	4
AN960-516L		1	40	2
AN960C416L		1	115	2
		1	145	2
		1	180	1
AN960D10L		1	20	3
AN960PD10		1	95	8
AN960PD10L		1	70	24
		1	295	7
AN960PD416L		1	220	2
AN960PD8		1	345	8
		1	375	34
BACB28X4F010		1	160	4
		1	270	4
BACB28X5C010		1	195	2
		1	195A	2
BACB30LK3-3		1	90	8
BACB30NM3K3		1	65	24
BACB30NM3K3		1	260	6
		1	290	7
BACB30NM4K14		1	110	2
		1	215	2
BACB30NM4K14		1	215	2
BACJ40A20-7		1	5	1
BACN10JC08		1	347	8
		1	377	34
BACN10JC4		1	125	2
		1	155	2
		1	190	1
		1	230	2
BACN10JC5		1	50	2
BACN10JR3CFM		1	405	56
BACN10JR3F		1	275	6
BACN10JC3CM		1	305A	7
BACR15BA3AD		1	400	112
BACR15BA4AD		1	395	8
BACR15DR3		1	273	12
BACW10BN3AC		1	265	6
		1	265	6
		1	300	7

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACW10CT10		1	45	
BACW10CT10C		1	45A	2
BACW10CT8C		1	120	2
BACW10CT8CU		1	150	2
		1	185	1
BACW10CT8D		1	225	2
BAC27TEC0209		1	420	1
BLFR14-082		1	100	2
BRF200C3M		1	405	56
BRH10-08		1	347	8
		1	377	34
BRH10-3		1	25	1
BRH10-4		1	125	2
		1	155	2
		1	190	1
		1	230	2
BRH10-5		1	50	2
F5000-3BAC		1	275	6
F5001-3BAC		1	405	56
H10-08BAC		1	347	8
		1	377	34
H10-4BAC		1	125	2
		1	155	2
		1	190	1
		1	230	2
H10-5BAC		1	50	2
KWB14N12		1	100	2
MILB81935-1-4		1	245	4
MS20253P4-940		1	315	1
MS21209F1-20		1	350	4
		1	380	4
MS51923-187		1	310	2
NAS1801-3-7		1	15	1
NAS514P832-8		1	340	
		1	370	
NAS514P832-9		1	340A	8
		1	370A	34
NAS6604-23		1	140	2
		1	175	1

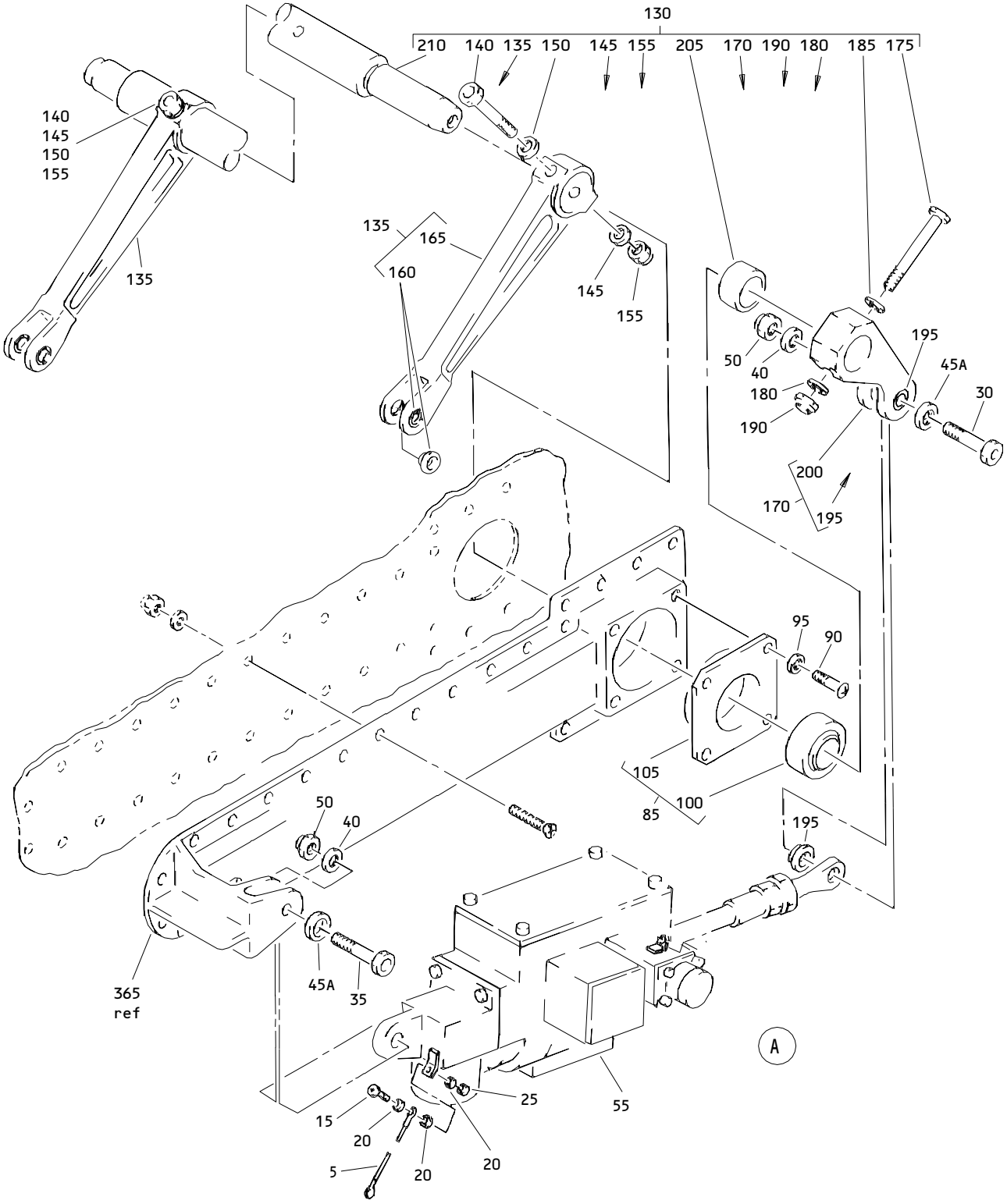
PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
NAS6605-13		1	30	1
NAS6605-14		1	35	1
NHL14V201		1	100	2
NS103203-02		1	275	6
NS103203SE02		1	405	56
NS103203SE02		1	25	2
NS202101-02		1	125	2
NS202101-048		1	155	2
		1	190	1
		1	230	2
NS202101-82		1	347	8
		1	377	34
RMF9201-3		1	275	6
RMLH9075-5W		1	50	2
RMLH9075-82W		1	347	8
		1	377	34
SBSH28ATC52-2		1	100	
S210T130-40		1	55	1
S210T130-56		1	55A	1
S210T130-9		1	55B	
TGA114D		1	100	2
T6S428J		1	125	2
		1	155	2
		1	190	1
		1	230	2
T6S524J		1	50	2
T6S832J		1	347	8
		1	377	34
T8091S1032		1	275	6
T8092C1032		1	405	56
VN152A1-02		1	275	6
VN152D1-02		1	405	56
VN303A048		1	125	2
		1	155	2
		1	190	1
		1	230	2

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
VN303A82		1	347	8
		1	377	34
WRG14BACH		1	100	2
109F9201-3		1	405	56
176364		1	100	2
213T3006-1		1	135	2
213T3006-2		1	165	2
213T3006-4		1	135A	2
213T3006-5		1	165A	2
213T3007-1		1	255	1
213T3007-2		1	280	1
213T3012-1		1	365	1
		1	365B	
213T3012-2		1	365A	
213T3012-3		1	385	1
213T3012-5		1	390	
213T3100-1		1	330	
213T3100-10		1	330C	
213T3100-11		1	415B	
213T3100-12		1	415C	
213T3100-14		1	330D	1
213T3100-15		1	330E	1
213T3100-16		1	415D	1
213T3100-17		1	415E	1
213T3100-2		1	330A	
213T3100-3		1	415	
213T3100-4		1	415A	
213T3100-9		1	330B	
213T3102-1		1	1	
213T3102-2		1	1A	
213T3102-5		1	1B	RF
213T3102-6		1	1C	RF
213T3102-7		1	1D	RF
213T3102-8		1	1E	RF
213T3102-5001		1	2A	
213T3102-5002		1	2B	
213T3102-5003		1	3A	
213T3102-5004		1	3B	
213T3103-1		1	130	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
213T3104-1		1	285	1
213T3104-2		1	320	1
213T3104-3		1	325	1
213T3105-1		1	235	2
213T3105-2		1	250	2
213T3106-1		1	60	1
213T3106-2		1	80	1
213T3400-2		1	410	1
213T3405-2		1	75	1
213T3701-1		1	335	1
		1	335B	
213T3701-2		1	335A	
213T3701-3		1	355	1
213T3701-4		1	360	
213T3702-2		1	210A	1
213T3702-4		1	210	1
213T3702-5		1	210B	1
213T3703-1		1	170	1
213T3703-2		1	200	1
		1	200A	1
213T3703-5		1	200B	1
213T3703-7		1	195B	2
213T3703-8		1	170A	1
213T3704-1		1	205	1
2022432-3		1	55	1
2022432-4		1	55A	1
69B03738-1		1	85	2
69B03738-2		1	105	2
96-048		1	125	2
		1	155	2
		1	190	1
		1	230	2
96-054		1	50	2
96-82		1	347	8
		1	377	34

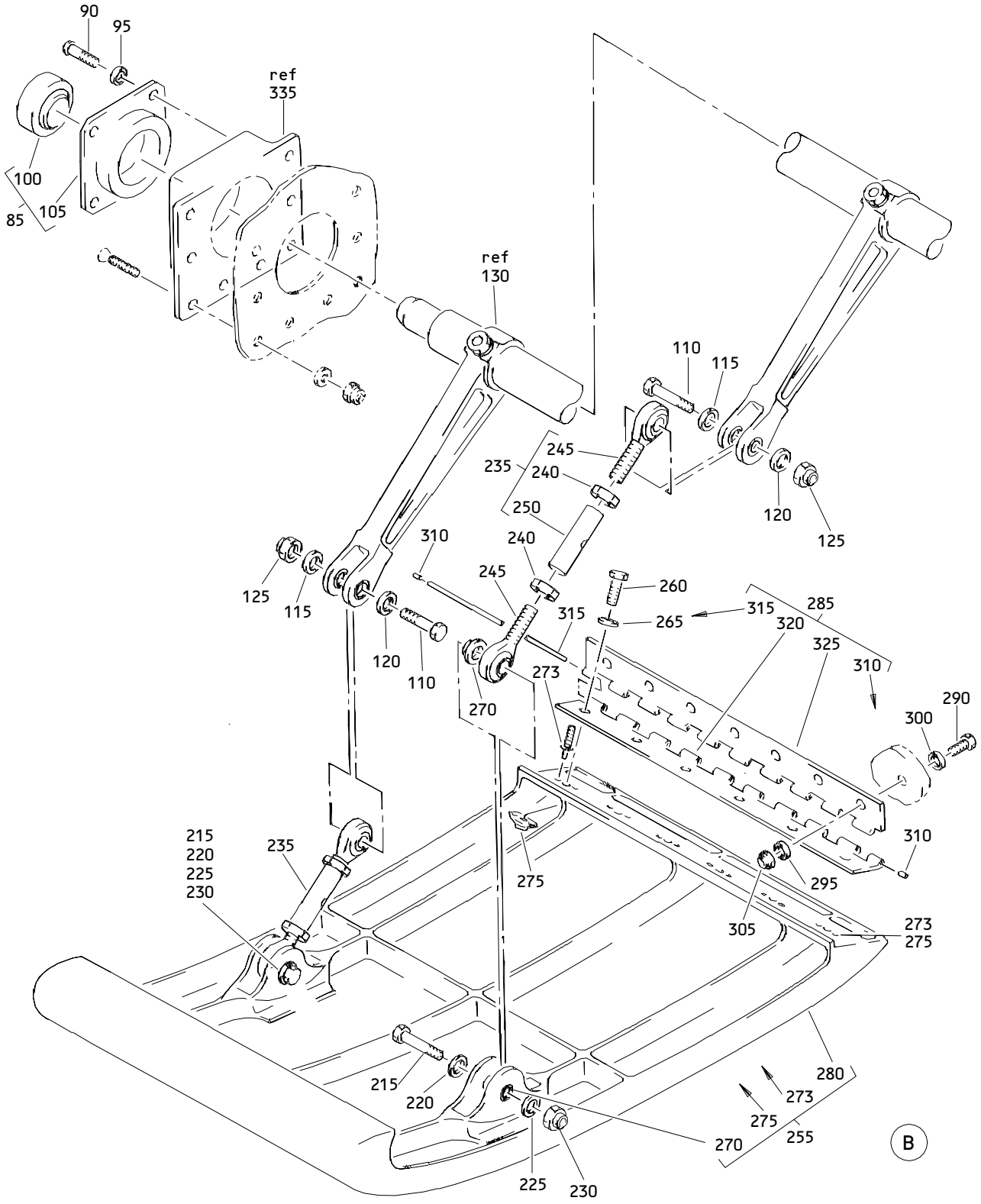


Ram Air Exhaust Assembly
Figure 1 (Sheet 1)



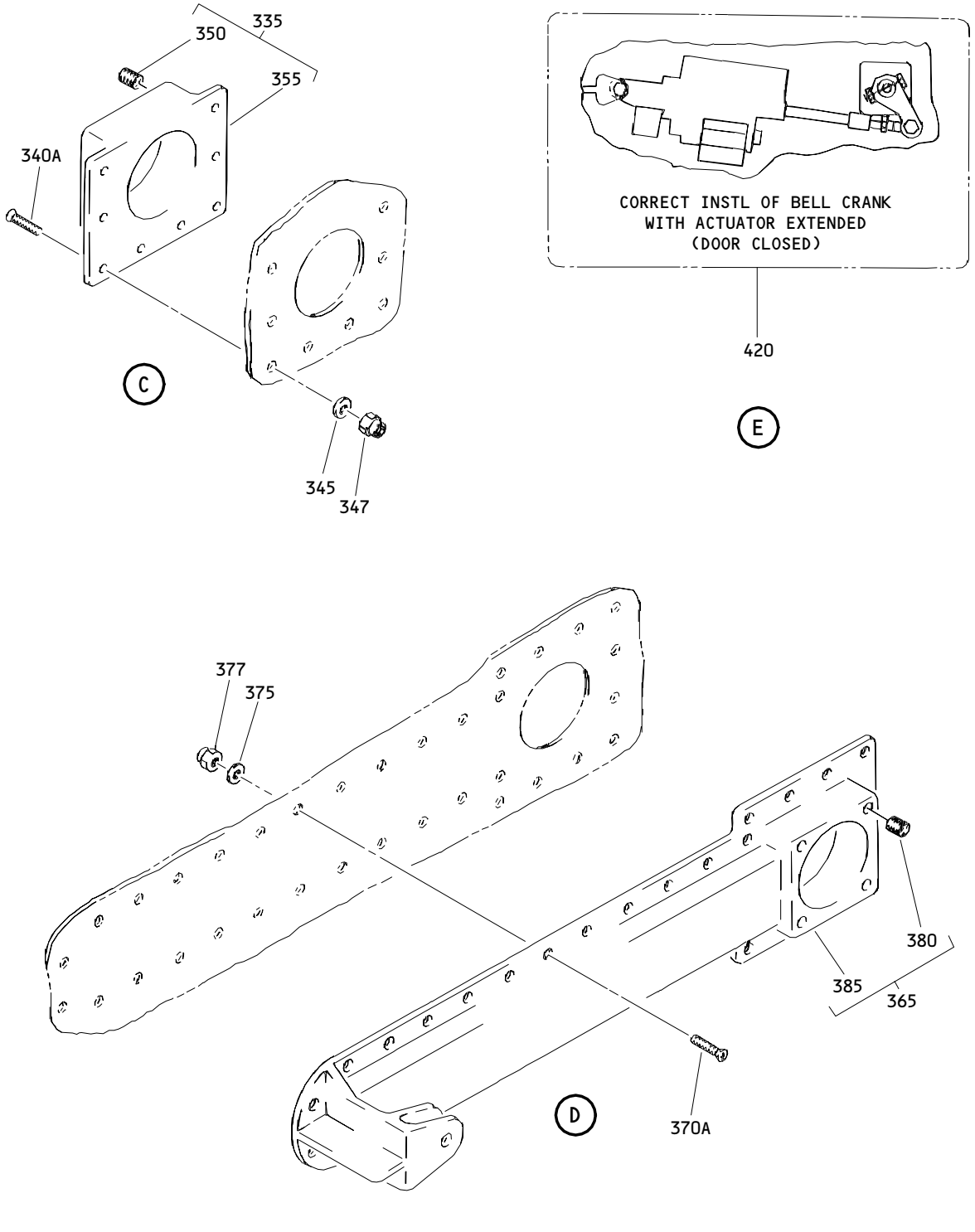
Ram Air Exhaust Assembly
Figure 1 (Sheet 2)

T64905



Ram Air Exhaust Assembly
Figure 1 (Sheet 3)

T64907



Ram Air Exhaust Assembly
Figure 1 (Sheet 4)

U15127

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-1	213T3102-1		DELETED		
-1A	213T3102-2		DELETED		
-1B	213T3102-5		EXHAUST ASSY-RAM AIR	A	RF
-1C	213T3102-6		EXHAUST ASSY-RAM AIR	B	RF
-1D	213T3102-7		EXHAUST ASSY-RAM AIR	C	RF
-1E	213T3102-8		EXHAUST ASSY-RAM AIR	D	RF
-2A	213T3102-5001		DELETED		
-2B	213T3102-5002		DELETED		
-3A	213T3102-5003		DELETED		
-3B	213T3102-5004		DELETED		
5	740A20-7		.JUMPER ASSY- (V91812) (SPEC BACJ40A20-7) (OPT CE7E (V79500)) (OPT CE7E (V79550)) (OPT 30363 (V00779))		1
10	740A20-10		DELETED ATTACHING PARTS		
15	NAS1801-3-7		.BOLT		1
20	AN960D10L		.WASHER		3
25	BRH10-3		.NUT- (V52828) (SPEC BACN10JC3) (OPT H10-3BAC (V15653)) (OPT NS202101-02 (V80539)) (OPT RMLH9075-3W (V72962)) (OPT T6S1032J (V71087)) (OPT VN303A02 (V92215)) (OPT 96-02 (V80539)) -------*-------		1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
30	NAS6605-13		.BOLT		1
35	NAS6605-14		.BOLT		1
40	AN960-516L		.WASHER		2
45	BACW10CT10		DELETED		
45A	BACW10CT10C		.WASHER (V10630) (SPEC BACW10CT10C)		2
50	BRH10-5		.NUT- (V52828) (SPEC BACN10JC5) (OPT H10-5BAC (V15653)) (OPT RMLH9075-5W (V72962)) (OPT T6S524J (V71087)) (OPT 96-054 (V80539))		2
55	2022432-3		.ACTUATOR- (V70210) (SPEC S210T130-40)	AB	1
-55A	2022432-4		.ACTUATOR- (V70210) (SPEC S210T130-56)	CD	1
55B	S210T130-9		DELETED		
60	213T3106-1		.DOOR ASSY-ACCESS		1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-			ATTACHING PARTS		
65	BACB30NM3K3		.BOLT- (V06710) (SPEC BACB30NM3K3) (OPT BACB30NM3K3 (V06725)) (OPT BACB30NM3K3 (V06950)) (OPT BACB30NM3K3 (V08524)) (OPT BACB30NM3K3 (V27624)) (OPT BACB30NM3K3 (V56878)) (OPT BACB30NM3K3 (V73197)) (OPT BACB30NM3K3 (V80539)) (OPT BACB30NM3K3 (V92215)) (OPT BACB30NM3K3 (V93907)) (OPT BACB30NM3K3 (V97928))		24
70	AN960PD10L		.WASHER -------*-------		24
75	213T3405-2		..GASKET		1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
80	213T3106-2		..DOOR ASSY		1
85	69B03738-1		.RETAINER ASSY		2
			ATTACHING PARTS		
90	BACB30LK3-3		.BOLT-		8
			(V06710)		
			(SPEC BACB30LK3-3)		
			(OPT BACB30LK3-3 (V06725))		
			(OPT BACB30LK3-3 (V06950))		
			(OPT BACB30LK3-3 (V08524))		
			(OPT BACB30LK3-3 (V17943))		
			(OPT BACB30LK3-3 (V27624))		
			(OPT BACB30LK3-3 (V80539))		
			(OPT BACB30LK3-3 (V92215))		
			(OPT BACB30LK3-3 (V97928))		
95	AN960PD10		.WASHER		8
			-------*-------		
100	ABWT14V102		..BEARING-SPHER		1
			(V50294)		
			(SPEC 10-60545-77)		
			(OPT BLFR14-082 (V81376))		
			(OPT KWB14N12 (V97613))		
			(OPT NHL14V201 (V15860))		
			(OPT SBSH28ATC52-2 (V21335))		
			(OPT TGA114D (V77896))		
			(OPT WRG14BACH (V73134))		
			(OPT 176364 (V09455))		

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
105	69B03738-2		..RETAINER		1
110	BACB30NM4K14		.BOLT-		2
			(V06710)		
			(SPEC BACB30NM4K14)		
			(OPT BACB30NM4K14 (V06725))		
			(OPT BACB30NM4K14 (V06950))		
			(OPT BACB30NM4K14 (V08524))		
			(OPT BACB30NM4K14 (V27624))		
			(OPT BACB30NM4K14 (V56878))		
			(OPT BACB30NM4K14 (V73197))		
			(OPT BACB30NM4K14 (V80539))		
			(OPT BACB30NM4K14 (V92215))		
			(OPT BACB30NM4K14 (V93907))		
			(OPT BACB30NM4K14 (V97928))		
115	AN960C416L		.WASHER		2
120	BACW10CT8C		.WASHER-		2
			(V10630)		
			(SPEC BACW10CT8C)		
125	BRH10-4		.NUT-		2
			(V52828)		
			(SPEC BACN10JC4)		
			(OPT H10-4BAC (V15653))		
			(OPT NS202101-048 (V80539))		
			(OPT RMLH9075-4W (V72962))		
			(OPT T6S428J (V71087))		
			(OPT VN303A048 (V92215))		
			(OPT 96-048 (V80539))		

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
130	213T3103-1		.TUBE ASSY-TORQUE		1
135	213T3006-1		..LINK ASSY-ACTR (MATCHED SET) (OPT ITEM 135A)		2
-135A	213T3006-4		..LINK ASSY-ACTR (MATCHED SET) (OPT ITEM 135) ATTACHING PARTS		2
140	NAS6604-23		..BOLT		2
145	AN960C416L		..WASHER		2
150	BACW10CT8CU		..WASHER- (V10630) (SPEC BACW10CT8CU)		2
155	BRH10-4		..NUT- (V52828) (SPEC BACN10JC4) (REFER TO ITEM 125 FOR OPTIONAL PARTS) -------*-------		2
160	BACB28X4F010		...BUSHING- (V23294) (SPEC BACB28X4F010) (OPT BACB28X4F010 (V70265))		2
165	213T3006-2		...LINK- (USED ON ITEM 135)		1
-165A	213T3006-5		...LINK- (USED ON ITEM 135A)		1
170	213T3703-1		..CRANK ASSY-BELL (MATCHED SET) (OPT ITEM 170A)		1
-170A	213T3703-8		..CRANK ASSY-BELL (MATCHED SET) (OPT ITEM 170) ATTACHING PARTS		1
175	NAS6604-23		..BOLT		1
180	AN960C416L		..WASHER		1
185	BACW10CT8CU		..WASHER- (V10630) (SPEC BACW10CT8CU)		1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
190	BRH10-4		..NUT-		1
			(V62828)		
			(SPEC BACN10JC4)		
			(REFER TO ITEM 125 FOR OPTIONAL PARTS)		
			-------*-------		
195	BACB28X5C010		...BUSHING-		2
			(USED ON ITEM 170)		
			(V23294)		
			(SPEC BACB28X5C010)		
195A	BACB28X5C010		...BUSHING		2
			(USED WITH ITEM 200A ON ITEM 170A)		
			(OPT BACB28X5C010 (V70265))		
			(OPT BACB28X5C010 (V90255))		
195B	213T3703-7		...BUSHING		2
			(USED WITH ITEM 200A ON ITEM 170A)		
200	213T3703-2		...CRANK		1
200A	213T3703-2		...CRANK		1
			(OPT TO ITEM 200B)		
			(USED WITH ITEM 195B ON ITEM 170A)		
200B	213T3703-5		...CRANK		1
			(OPT TO ITEM 200A)		
			(USED WITH ITEM 195A ON ITEM 170A)		
205	213T3704-1		..SPACER		1
210	213T3702-4		..TUBE-TORQUE (MATCHED SET)		1
			(OPT ITEMS 210A, 210B)		
-210A	213T3702-2		..TUBE-TORQUE (MATCHED SET)		1
			(OPT ITEMS 210, 210B)		
210B	213T3702-5		..TUBE-TORQUE (MATCHED SET)		1
			(OPT ITEMS 210, 210A)		
215	BACB30NM4K14		.BOLT-		2
			(V06710)		
			(SPEC BACB30NM4K14)		
			(REFER TO ITEM 110 FOR OPTIONAL PARTS)		

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
220	AN960PD416L		.WASHER		2
225	BACW10CT8D		.WASHER-		2
230	BRH10-4		.NUT-		2
			(V52828)		
			(SPEC BACN10JC4)		
			(REFER TO ITEM 125 FOR OPTIONAL PARTS)		
235	213T3105-1		.ROD ASSY		2
240	AN316C5R		..NUT		2
245	MILB81935-1-4		..ROD END		2
250	213T3105-2		..ROD		1
255	213T3007-1		.DOOR ASSY-EXHAUST		1
			ATTACHING PARTS		
260	BACB30NM3K3		.BOLT-		6
			(V06710)		
			(SPEC BACB30NM3K3)		
			(REFER TO ITEM 65 FOR OPTIONAL PARTS)		
265	BACW10BN3AC		.WASHER-		6
			(V10630)		
			(SPEC BACW10BN3AC)		
			-------*-------		
270	BACB28X4F010		..BUSHING-		4
			(V23294)		
			(SPEC BACB28X4F010)		
			(REFER TO ITEM 160 FOR OPTIONAL PARTS)		
273	BACR15DR3		..RIVET		12
275	F5000-3BAC		..NUTPLATE-		6
			(V15653)		
			(SPEC BACN10JR3F)		
			(OPT NS103203-02 (V80539))		
			(OPT RMF9201-3 (V72962))		
			(OPT T8091S1032 (V71087))		
			(OPT VN152A1-02 (V92215))		

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
280	213T3007-2		..DOOR		1
285	213T3104-1		.HINGE ASSY		1
			ATTACHING PARTS		
290	BACB30NM3K3		.BOLT-		7
			(V06710)		
			(SPEC BACB30NM3K3)		
			(REFER TO ITEM 65		
			FOR OPTIONAL PARTS)		
295	AN960PD10L		.WASHER		7
300	BACW10BN3AC		.WASHER-		7
			(V10630)		
			(SPEC BACW10BN3AC)		
305	BACN10J3CM		.DELETED		
305A	BACN10JC3CM		.NUT		7
			-------*-------		
310	MS51923-187		..PIN		2
315	MS20253P4-940		..PIN		1
320	213T3104-2		..HINGE HALF		1
325	213T3104-3		..HINGE HALF		1
330	213T3100-1		DELETED		
-330A	213T3100-2		DELETED		
-330B	213T3100-9		DELETED		
-330C	213T3100-10		DELETED		
330D	213T3100-14		.DUCT ASSY-	AC	1
-330E	213T3100-15		.DUCT ASSY-	BD	1
335	213T3701-1		..HOUSING ASSY-		1
-335A	213T3701-2		DELETED		
-335B	213T3701-1		DELETED		
			ATTACHING PARTS		
340	NAS514P832-8		DELETED		
340A	NAS514P832-9		..SCREW		8

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
345	AN960PD8		..WASHER		8
347	BRH10-08		..NUT-		8
			(V52828)		
			(SPEC BACN10JC08)		
			(OPT H10-08BAC		
			(V15653))		
			(OPT NS202101-82		
			(V80539))		
			(OPT RMLH9075-82W		
			(V72962))		
			(OPT T6S832J		
			(V71087))		
			(OPT VN303A82		
			(V92215))		
			(OPT 96-82		
			(V80539))		
			-------*-------		
350	MS21209F1-20		...INSERT		4
355	213T3701-3		...RETAINER-HSG		1
-360	213T3701-4		DELETED		
365	213T3012-1		..MOUNT ASSY		1
-365A	213T3012-2		DELETED		
-365B	213T3012-1		DELETED		
			ATTACHING PARTS		
370	NAS514P832-8		DELETED		
370A	NAS514P832-9		..SCREW		34
375	AN960PD8		..WASHER		34
377	BRH10-08		..NUT-		34
			(V52828)		
			(SPEC BACN10JC08)		
			(REFER TO ITEM 347		
			FOR OPTIONAL PARTS)		
			-------*-------		

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
380	MS21209F1-20		...INSERT		4
385	213T3012-3		...MOUNT		1
-390	213T3012-5		DELETED		
395	BACR15BA4AD		..RIVET		8
400	BACR15BA3AD		..RIVET		112
405	BRF200C3M		..NUTPLATE- (V52828) (SPEC BACN10JR3CFM) (OPT F5001-3BAC (V15653)) (OPT NS103203SE02 (V80539)) (OPT T8092C1032 (V71087)) (OPT VN152D1-02 (V92215)) (OPT 109F9201-3 (V72962))		56
410	213T3400-2		..FRAME		1
415	213T3100-3		DELETED		
-415A	213T3100-4		DELETED		
-415B	213T3100-11		DELETED		
-415C	213T3100-12		DELETED		
415D	213T3100-16		..DUCT ASSY	AC	1
-415E	213T3100-17		..DUCT ASSY	BD	1
420	BAC27TEC0209		.MARKER, AL. FOIL	CD	1