

 **BOEING**  
COMPONENT  
MAINTENANCE MANUAL

TO: ALL HOLDERS OF RAM AIR INLET MODULATING DOOR ASSEMBLY COMPONENT MAINTENANCE  
MANUAL 21-53-12

REVISION NO. 5 DATED JUL 01/01

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

INTRODUCTION

Added technical clarification to the text paragraph.

1

DESCRIPTION & OPERATION

1

301

REPAIR-GEN

601

REPAIR 5-1

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REPAIR 7-1

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701

DESCRIPTION & OPERATION

Added new figure to the Description and Operation section.

2

501

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REPAIR 7-1

601-603

Added new repair procedure Repair 7-1 for 213T3705 to Repair section and then removed duplicate repair data for 213T3705 from Repair - General section.

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<u>CHAPTER/SECTION AND PAGE NO.</u>	<u>DESCRIPTION OF CHANGE</u>
REPAIR 4-1 602	Added technical clarification to the noted figure.
REPAIR 5-1 602	
REPAIR 6-1 602	
1014-1020,1034-1038	
1002-1005	Changed the Vendor Cage code to the most up-to-date information.
1006-1013,1021-1032, 1039-1044	Added assembly number 213T3705-5 to Illustrated Parts List.
1006-1013,1021-1032, 1039-1044	Added new Fig. 2 and the associated parts to Illustrated Parts List.

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# RAM AIR INLET MODULATING DOOR ASSEMBLY

## PART NUMBERS 213T3101-1 THRU -5

COMPONENT MAINTENANCE MANUAL  
WITH  
ILLUSTRATED PARTS LIST

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TITLE PAGE

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C43496



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

C43476

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TEMPORARY REVISION AND SERVICE BULLETIN RECORD

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

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TR & SB RECORD

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## INTRODUCTION

The instructions that are specified in this manual give the data necessary to do the maintenance functions that range from simple maintenance checks and part replacement to complete shop-type repair procedures.

This manual is divided into separate sections:

- |  |                              |
|--|------------------------------|
| 1. Title Page                                      | 4. List of Effective Pages   |
| 2. Record of Revisions                             | 5. Table of Contents         |
| 3. Temporary Revision &<br>Service Bulletin Record | 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.

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INTRODUCTION

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RAM AIR INLET MODULATING DOOR ASSEMBLY

DESCRIPTION AND OPERATION

1. Description

- A. The Ram Air Inlet Modulating Door Assembly is made up of a forward inlet door assembly and an aft inlet door assembly.
- B. A hinge assembly connects the forward inlet door assembly and an aft inlet door assembly together.

2. Operation

- A. The door assembly is controlled by a motor-operated linear actuator that is mounted on the aft bulkhead of the ram air duct cavity.
- B. The door assembly controls the amount of ram air that goes through the heat exchanger located in the airplane air conditioning system.

3. Leading Particulars (approximate)

- A. Length -- 47 inches
- B. Width -- 12 inches
- C. Height -- 2 inches
- D. Weight -- 9 pounds

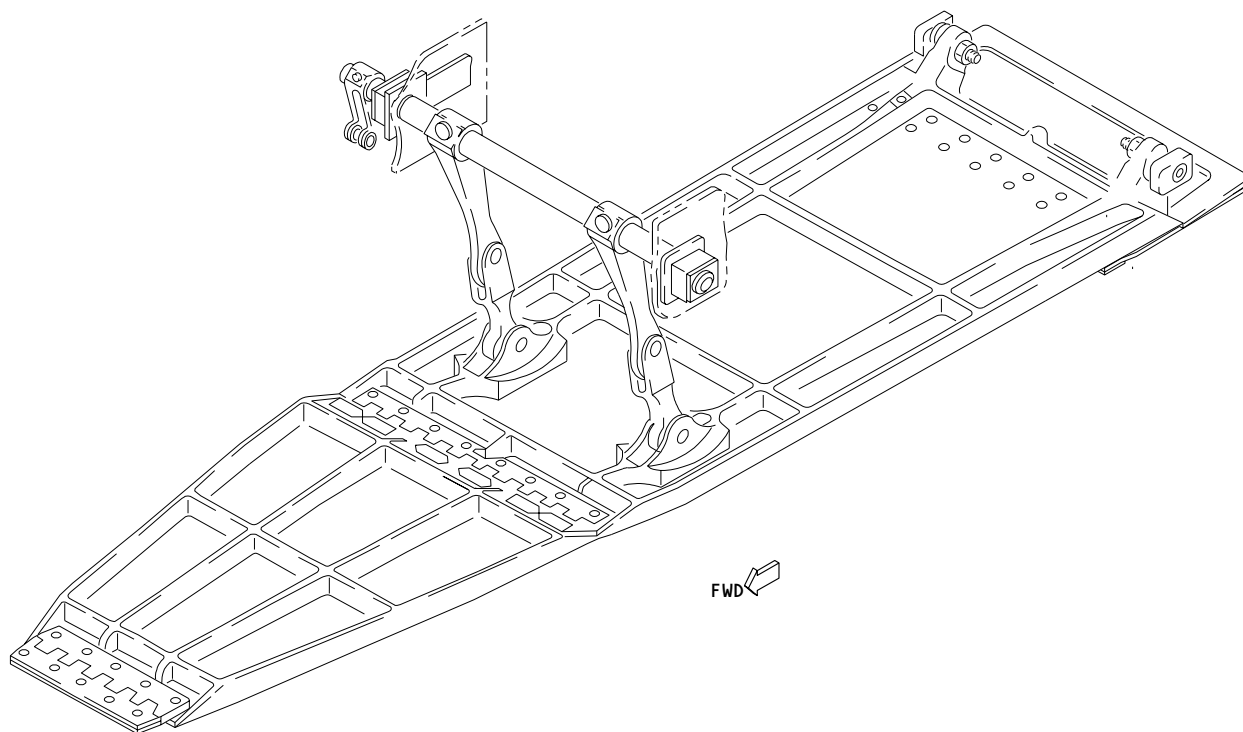
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Ram Air Inlet Modulating Door Assembly  
Figure 1

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DISASSEMBLY

NOTE: The Boeing Company recommends that you disassemble the ram air inlet modulating door assembly unit only when necessary to do the specified procedures that follow:

- to complete any type of fault isolation
- to find out if the parts are in a serviceable condition
- to make any necessary repairs to the assembly unit
- or to restore the assembly unit to a serviceable condition

1. Use standard industry practices for disassembly of this component, and the procedure in step 2.

CAUTION: TORQUE TUBE (385), ACTUATOR LINK ASSEMBLY (390) AND BELLCRANK ASSEMBLY (410) COMPRISE A MATCHED SET AND MUST BE KEPT TOGETHER FOR PROPER OPERATION AFTER ASSEMBLY.

2. Remove bolts (430), washers (435, 440) and nuts (445) from torque tube assembly (355).

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DISASSEMBLY

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CHECK1. Visual Check

A. Use standard industry procedures to examine all parts for defects.

2. Special Check

A. Do a penetrant check of the parts listed below as shown in SOPM 20-20-02.

(1) Door (225, 230)

(2) Link (330)

B. Do a magnetic particle check of the parts listed below as shown in SOPM 20-20-01.

(1) Link (400)

(2) Bellcrank (415)

(3) Torque Tube (IPL Fig. 1, 385, 385A, 385B) (IPL Fig. 2, 285, 285A, 285B)

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CHECK

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REPAIR – GENERAL1. Content

- A. Instructions for repair, refinish, and replacement are included in each REPAIR when applicable:

<u>PART NUMBER</u>	<u>NAME</u>	<u>REPAIR</u>
- - -	MISCELLANEOUS PARTS REFINISH	1-1
213T3009	AFT INLET DOOR ASSEMBLY	2-1
213T3008	LINK ASSEMBLY	3-1
213T3011	ACTUATOR LINK ASSEMBLY	4-1
213T3703	BELLCRANK ASSEMBLY	5-1
69B03738	RETAINER ASSEMBLY	6-1
213T3705	TORQUE TUBE	7-1

2. Standard Practices

- A. Refer to the Standard Overhaul Practices Manual (SOPM) to find the details of the procedures.

SOPM 20-30-02	Stripping of Protective Finishes
SOPM 20-30-03	General Cleaning Procedures
SOPM 20-41-01	Decoding Table for Boeing Finish Codes
SOPM 20-41-02	Application of Chemical and Solvent-Resistant Finishes
SOPM 20-41-03	Application of Corrosion Preventives to Interior of Closed End Tubes
SOPM 20-42-05	Bright Cadmium Plating
SOPM 20-43-01	Chromic Acid Anodizing
SOPM 20-43-03	Chemical Conversion Coatings for Aluminum
SOPM 20-50-03	Bearing Removal, Installation, and Retention

3. Materials

NOTE: Equivalent materials can be used.

- A. Sealant -- BMS 5-95 (SOPM 20-60-04)
- B. Enamel -- BMS 10-60, Boeing color 707 gray gloss (SOPM 20-60-02)
- C. Primer -- BMS 10-11, type 1 (SOPM 20-60-02)

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| D. Enamel -- BMS 10-11, type 2, color 702 white gloss

| 4. Dimensioning Symbols

| A. Standard true position dimensioning symbols used in applicable repair procedures are shown in Fig. 601.

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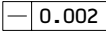
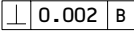

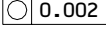
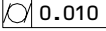
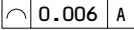
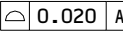
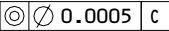
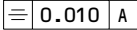
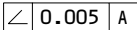
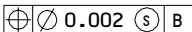
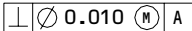



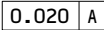
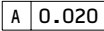
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- STRAIGHTNESS
- ▭ FLATNESS
- ⊥ PERPENDICULARITY (OR SQUARENESS)
- // PARALLELISM
- ROUNDNESS
- ⊙ CYLINDRICITY
- ⌒ PROFILE OF A LINE
- △ PROFILE OF A SURFACE
- ◎ CONCENTRICITY
- ≡ SYMMETRY
- ∠ ANGULARITY
- ↗ RUNOUT
- ↗ TOTAL RUNOUT
- ⊏ COUNTERBORE OR SPOTFACE
- ∇ COUNTERSINK

- ⊕ THEORETICAL EXACT POSITION OF A FEATURE (TRUE POSITION)
- ∅ DIAMETER
- S ∅ SPHERICAL DIAMETER
- R RADIUS
- SR SPHERICAL RADIUS
- ( ) REFERENCE
- BASIC (BSC) 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.
- DIM
- A- DATUM
- Ⓜ MAXIMUM MATERIAL CONDITION (MMC)
- Ⓛ LEAST MATERIAL CONDITION (LMC)
- Ⓢ REGARDLESS OF FEATURE SIZE (RFS)
- Ⓟ PROJECTED TOLERANCE ZONE
- FIM FULL INDICATOR MOVEMENT

**EXAMPLES**

<p> 0.002 STRAIGHT WITHIN 0.002</p> <p> 0.002 B PERPENDICULAR TO B WITHIN 0.002</p> <p> 0.002 A PARALLEL TO A WITHIN 0.002</p> <p> 0.002 ROUND WITHIN 0.002</p> <p> 0.010 CYLINDRICAL SURFACE MUST LIE BETWEEN TWO CONCENTRIC CYLINDERS, ONE OF WHICH HAS A RADIUS 0.010 INCH GREATER THAN THE OTHER</p> <p> 0.006 A EACH LINE ELEMENT OF THE SURFACE AT ANY CROSS SECTION MUST LIE BETWEEN TWO PROFILE BOUNDARIES 0.006 INCH APART RELATIVE TO DATUM PLANE A</p> <p> 0.020 A SURFACES MUST LIE WITHIN PARALLEL BOUNDARIES 0.02 INCH APART AND EQUALLY DISPOSED ABOUT TRUE PROFILE</p>	<p> 0.0005 C CONCENTRIC TO C WITHIN 0.0005 DIAMETER</p> <p> 0.010 A SYMMETRICAL WITH A WITHIN 0.010</p> <p> 0.005 A ANGULAR TOLERANCE 0.005 WITH A</p> <p> 0.002 S B LOCATED AT TRUE POSITION WITHIN 0.002 DIA RELATIVE TO DATUM B, REGARDLESS OF FEATURE SIZE</p> <p> 0.010 M A AXIS IS TOTALLY WITHIN A CYLINDER OF 0.010-INCH DIAMETER, PERPENDICULAR TO, AND EXTENDING 0.510-INCH ABOVE, DATUM A, MAXIMUM MATERIAL CONDITION</p> <p> 0.510 P</p> <p> 2.000 THEORETICALLY EXACT DIMENSION IS 2.000</p> <p>OR</p> <p> 2.000 BSC</p> <p> 0.020 A</p> <p> A 0.020</p>
---	---

**NOTE:** DATUM MAY APPEAR AT EITHER SIDE OF TOLERANCE FRAME

True Position Dimensioning Symbols  
 Figure 601

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REPAIR-GENERAL

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REFINISH OF OTHER PARTS - REPAIR 1-1

1. Instructions for the repair of the parts listed in Fig. 601 is for repair of the original finish.

IPL FIG. & ITEM	MATERIAL	FINISH
<u>Fig. 1</u>		
Doubler (10)	Aluminum alloy	Chemical treat (colored film) and one coat primer, BMS 10-11, type 1 (F-18.06).
Seal Assembly (15)		Apply one coat primer, BMS 10-11, type 1 (F-20.02) all over. Apply one coat BMS 10-60, Boeing color 707 gray gloss enamel (SRF-14.9813) on the exterior surfaces and edges except on surfaces that touch the door. Also, do not use primer or paint on rubber parts.
Strip (20)	17-7 PH CRES (optional 301 CRES omit heat treat)	Cadmium plate (F-15.06) (omit finish for optional 301 CRES).
Shim (30)	Aluminum alloy	Chromic acid anodize, type 1 and apply one coat primer, BMS 10-11, type 1 (F-18.13) all over.
Forward Hinge Assembly (95,120)		Chromic acid anodize, type 1 and apply one coat primer, BMS 10-11, type 1 (F-18.13) except no primer in the holes. Apply one coat BMS 10-60, Boeing color 707 gray gloss enamel (SRF-14.9813) on the exterior surfaces and edges except on surfaces that touch the door.

Refinish Details  
 Figure 601 (Sheet 1)

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IPL FIG. & ITEM	MATERIAL	FINISH
Aft Hinge Assembly (155,160)		Same finish as forward hinge assembly.
Forward Inlet Door (195)	Aluminum alloy	Anodize, type 1 (chromic acid) or type 2 (sulfuric acid) (F-17.05) and apply one coat BMS 10-11, type 1 primer (F-20.02) all over. Apply one coat BMS 10-60, Boeing color 707 gray gloss enamel (SRF-14.9813) on exterior surfaces as shown in Repair 2-1, Fig. 601.
Door (225,230)	Aluminum alloy	Anodize, type 1 (chromic acid) or type 2 (sulfuric acid) (F-17.05) and apply one coat BMS 10-11, type 1 primer (F-20.02) all over except do not use primer in the holes or on the bushings.
Spacer (425)	Cres	Passivate (F-17.25).

Refinish Details  
Figure 601 (Sheet 2)

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REPAIR 1-1

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AFT INLET DOOR ASSEMBLY – REPAIR 2-1

213T3009-1, -4

NOTE: Refer to REPAIR – GENERAL for the standard procedures used in the repair.

**1. Bushing Replacement (205, 210 IPL Fig. 1)**

- A. Remove the bushing.
- B. Install the bushing by the shrink-fit method specified in SOPM 20-50-03, except install the bushing with sealant, BMS 5-95.

**2. Bushing Replacement (215, 220, 170, IPL Fig. 1)**

- A. Remove the bushing.
- B. Install the bushing by the shrink-fit method specified in SOPM 20-50-03, except install the bushing with sealant, BMS 5-95.

C. Machine bushings (215, 220) to the dimensions shown in Fig. 601.

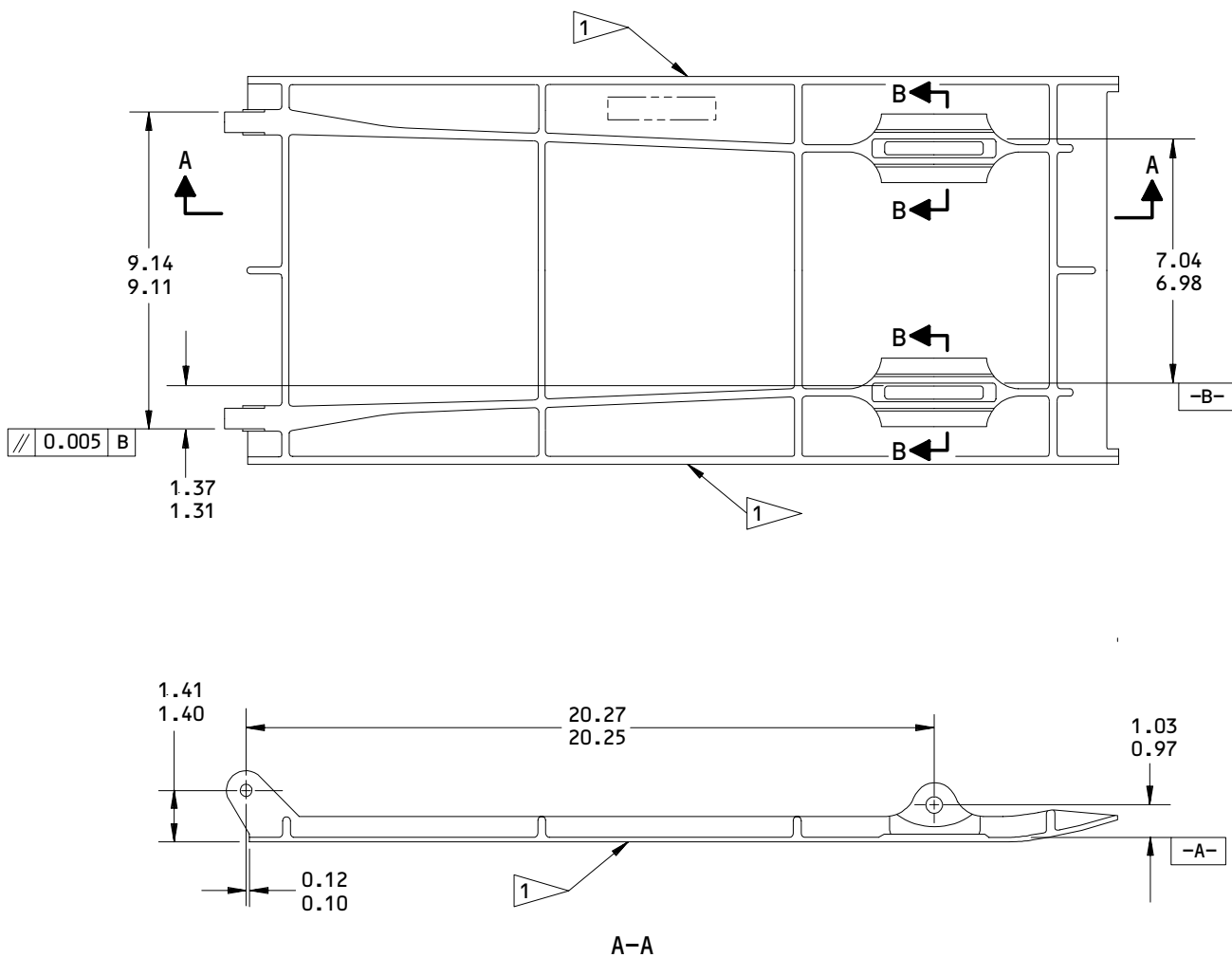
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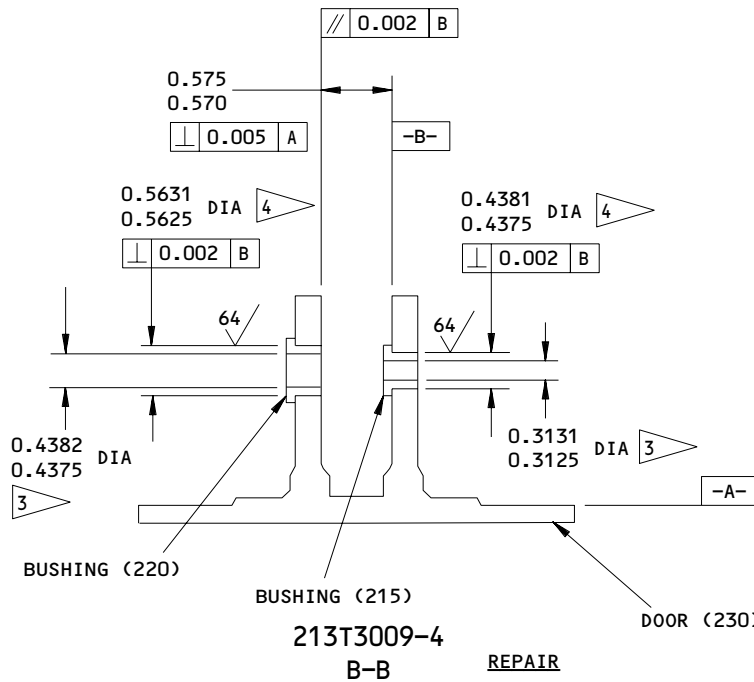
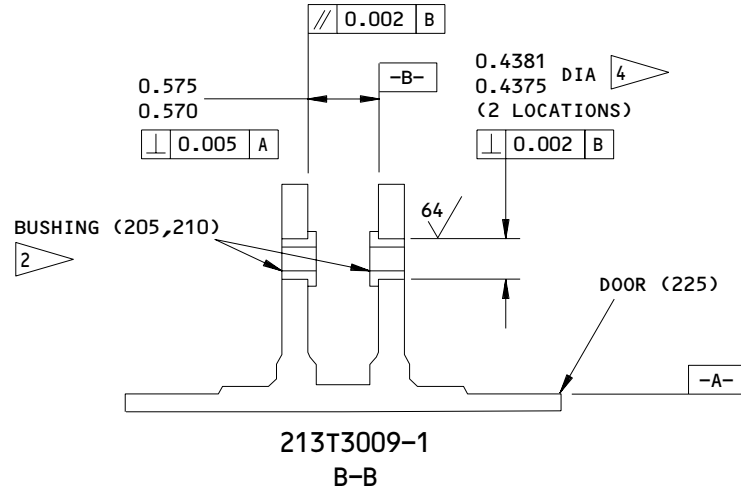
213T3009-1,-4  
 Aft Inlet Door Assembly Repair  
 Figure 601 (Sheet 1)

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REPAIR 2-1  
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**REFINISH**

ANODIZE (F-17.05) AND APPLY ONE COAT BMS 10-11, TYPE 1 PRIMER (F-20.02) BUT PUT NO PRIMER IN THE HOLES OR ON THE BUSHINGS. THEN APPLY BMS 10-60 BOEING COLOR 707 GRAY GLOSS ENAMEL (SRF-14.9813) ON THE EXTERIOR SURFACES AND EDGES ONLY. SEE 1

- 1 EXTERIOR SURFACES AND EDGES
- 2 DO NOT MACHINE INSIDE DIAMETER OF THIS BUSHING.
- 3 REAM DIAMETER  
BREAK SHARP EDGES: 0.03-0.05 R
- 4 FITTING DIMENSION

**REPAIR**

MATERIAL: ALUMINUM ALLOY  
 ITEM NUMBERS REFER TO IPL FIG. 1  
 ALL DIMENSIONS ARE IN INCHES

213T3009-1,-4  
 Aft Inlet Door Assembly Repair  
 Figure 601 (Sheet 2)

LINK ASSEMBLY – REPAIR 3-1

213T3008-1, -4

NOTE: Refer to REPAIR – GENERAL for the standard procedures listed in the repair.

**1. Bushing (345, 350) Replacement (IPL Fig. 1)**

- A. Remove the bushing.
- B. Install the bushing with sealant, BMS 5-95, by the shrink-fit method specified in SOPM 20-50-03.
- C. Ream bushings (345, 350) to the dimensions shown in Fig. 601.

**2. Bushing (340) Replacement (IPL Fig. 1)**

- A. Remove the bushing.
- B. Install the bushing per SOPM 20-50-03.

**3. Bearing (335) Replacement (IPL Fig. 1)**

- A. Remove the bearing.
- B. Install the bearing by the roller-swage method specified in SOPM 20-50-03.

**4. Bearing (336) Replacement (IPL Fig. 1)**

- A. Remove the bearing.
- B. Install the bearing with sealant, BMS 5-95, by the roller-swage method specified in SOPM 20-50-03.

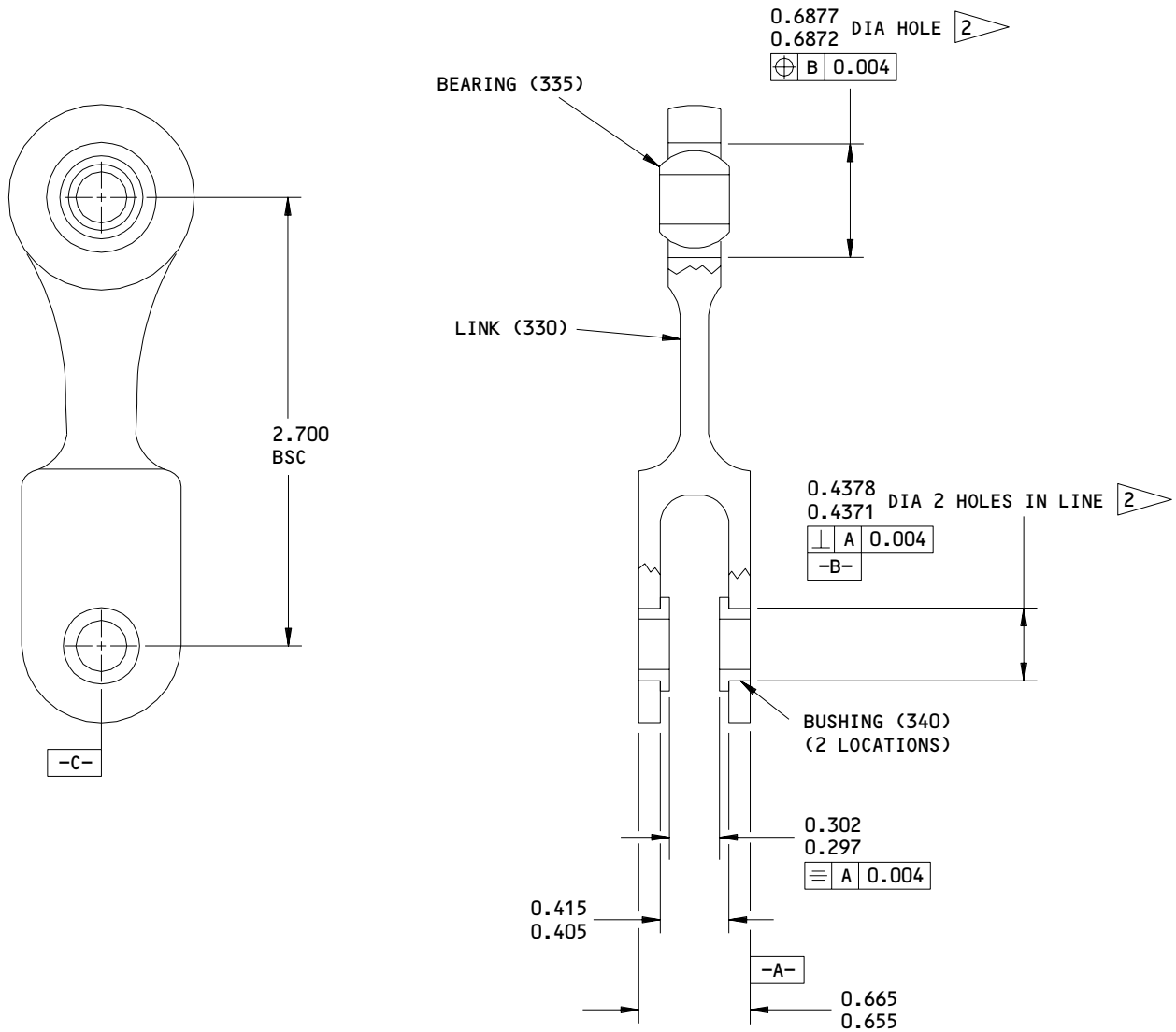
**21-53-12**

REPAIR 3-1

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213T3008-1

213T3008-1,-4  
 Link Assembly Repair  
 Figure 601 (Sheet 1)

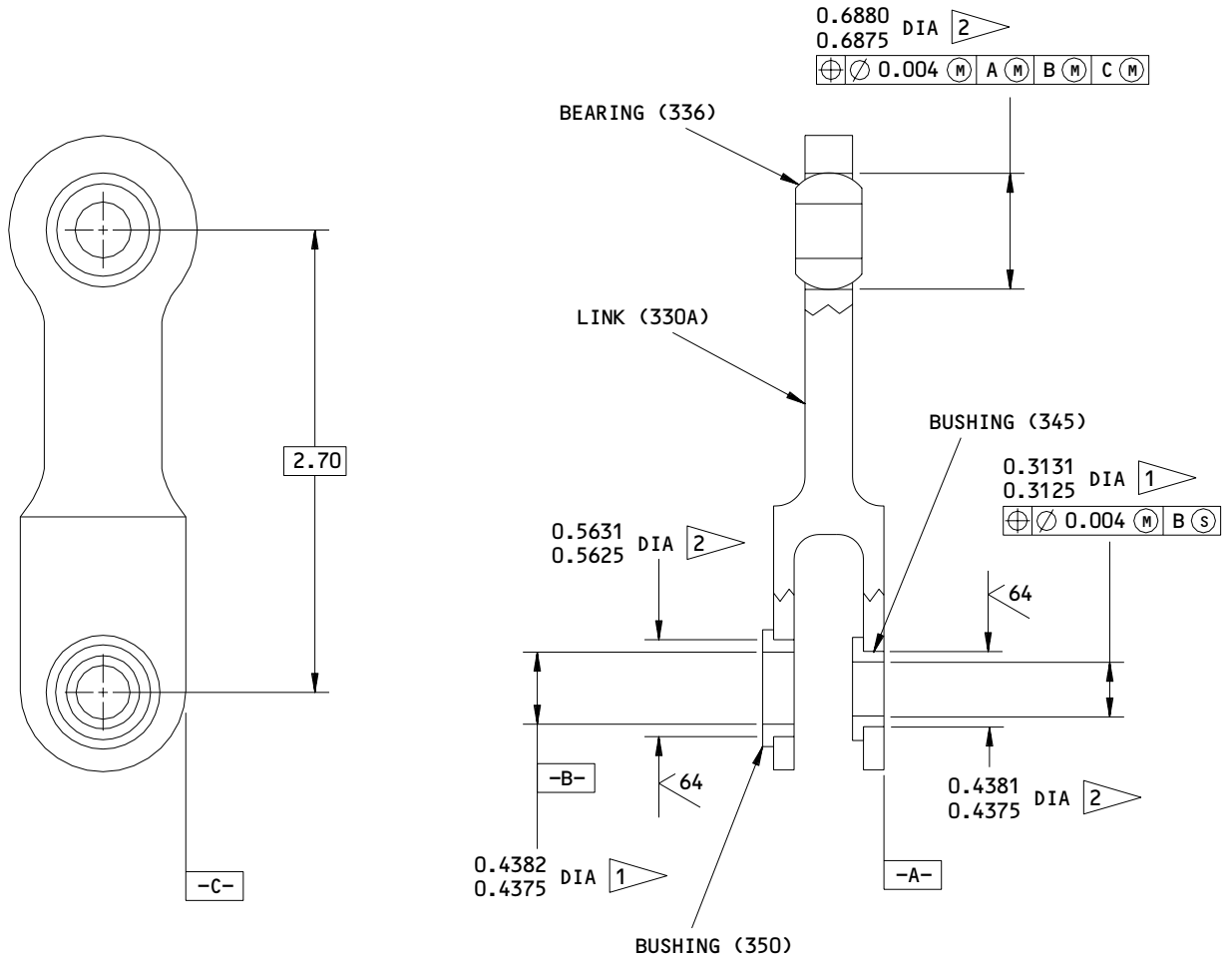
**21-53-12**

REPAIR 3-1

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213T3008-4

**REFINISH**

LINK (330, 213TT3008-2)--CHROMIC ACID ANODIZE, TYPE 1 (F-17.04) AND APPLY ONE COAT OF BMS 10-11, TYPE 1 PRIMER (F-20.02). NO PAINT IN HOLES.

LINK (330A, 213T3008-5)--ANODIZE AND APPLY ONE COAT OF BMS 10-11, TYPE 1 PRIMER (F-18.04). APPLY ONE COAT OF BMS 10-11, TYPE 2 ENAMEL (F-21.17). NO PAINT IN HOLES.



REAM DIAMETER

FITTING DIMENSION

**REPAIR**

(SAME AS REFINISH)

**MATERIAL:**

LINK (213T3008-2) 7075-T73  
 (OPTIONAL 7075-T7351)  
 LINK (213T3008-5) 7075-T7351

BREAK SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

213T3008-1,-4  
 Link Assembly Repair  
 Figure 601 (Sheet 2)

**21-53-12**

REPAIR 3-1

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ACTUATOR LINK ASSEMBLY - REPAIR 4-1

213T3011-1, -4

NOTE: Refer to REPAIR - GENERAL for the standard procedures used in the repair.

1. Bearing Replacement (405, IPL Fig. 1)

A. Remove the bearing.

B. Install the bearing by the roller-swage method specified in SOPM 20-50-03.

2. Bearing Replacement (406, IPL Fig. 1)

A. Remove the bearing.

B. Install the bearing with sealant, BMS 5-95, by the roller-swage method specified in SOPM 20-50-03.

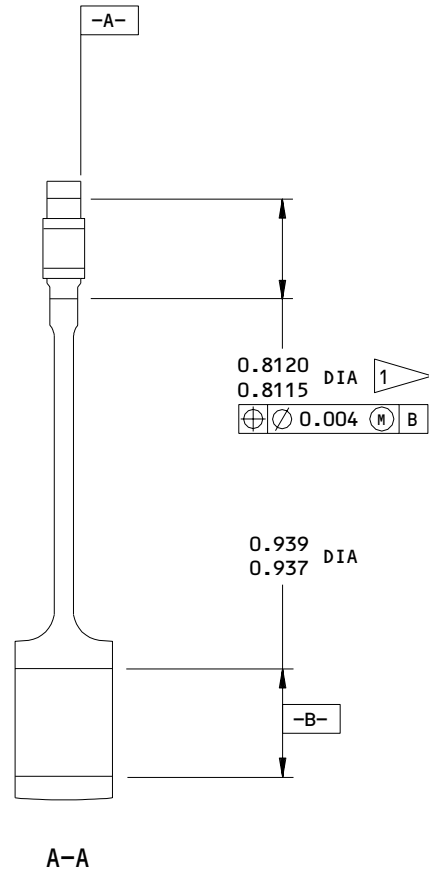
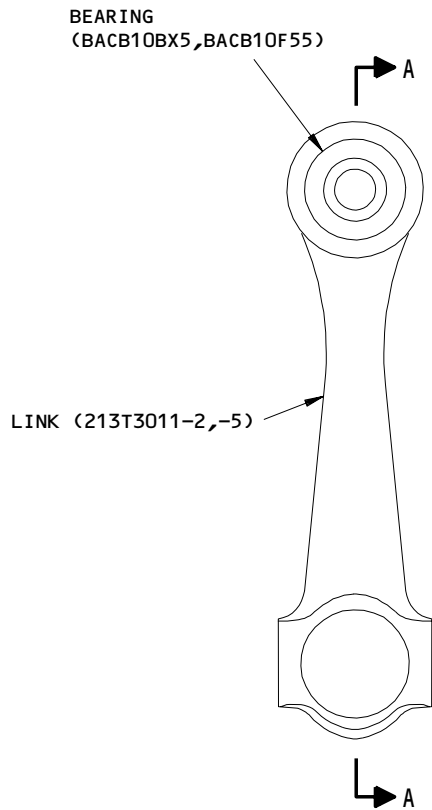
**21-53-12**

REPAIR 4-1

01.1

Page 601

Mar 01/95



**REFINISH**

PASSIVATE (F-17.09)

1 FITTING DIMENSION

**REPAIR**

MATERIAL: 15-5PH CRES (AMS 5659)  
 HEAT TREAT 125-145 KSI

BREAK SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

213T3011-1,-4  
 Actuator Link Assembly Repair  
 Figure 601

**21-53-12**

REPAIR 4-1

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BELLCRANK ASSEMBLY – REPAIR 5-1

213T3703-1, -8, -11

NOTE: Refer to REPAIR – GENERAL for the standard procedures used in the repair.

1. Bushing Replacement (420, 421, IPL Fig. 1)

A. Remove the bushing.

B. Install the bushing as given in SOPM 20-50-03.

C. Bushing face may be machined to obtain gap in Fig. 601.

(1) Minimum flange thickness after machining is 0.050 inch for bushing (421) and 0.055 inch for bushing (420).

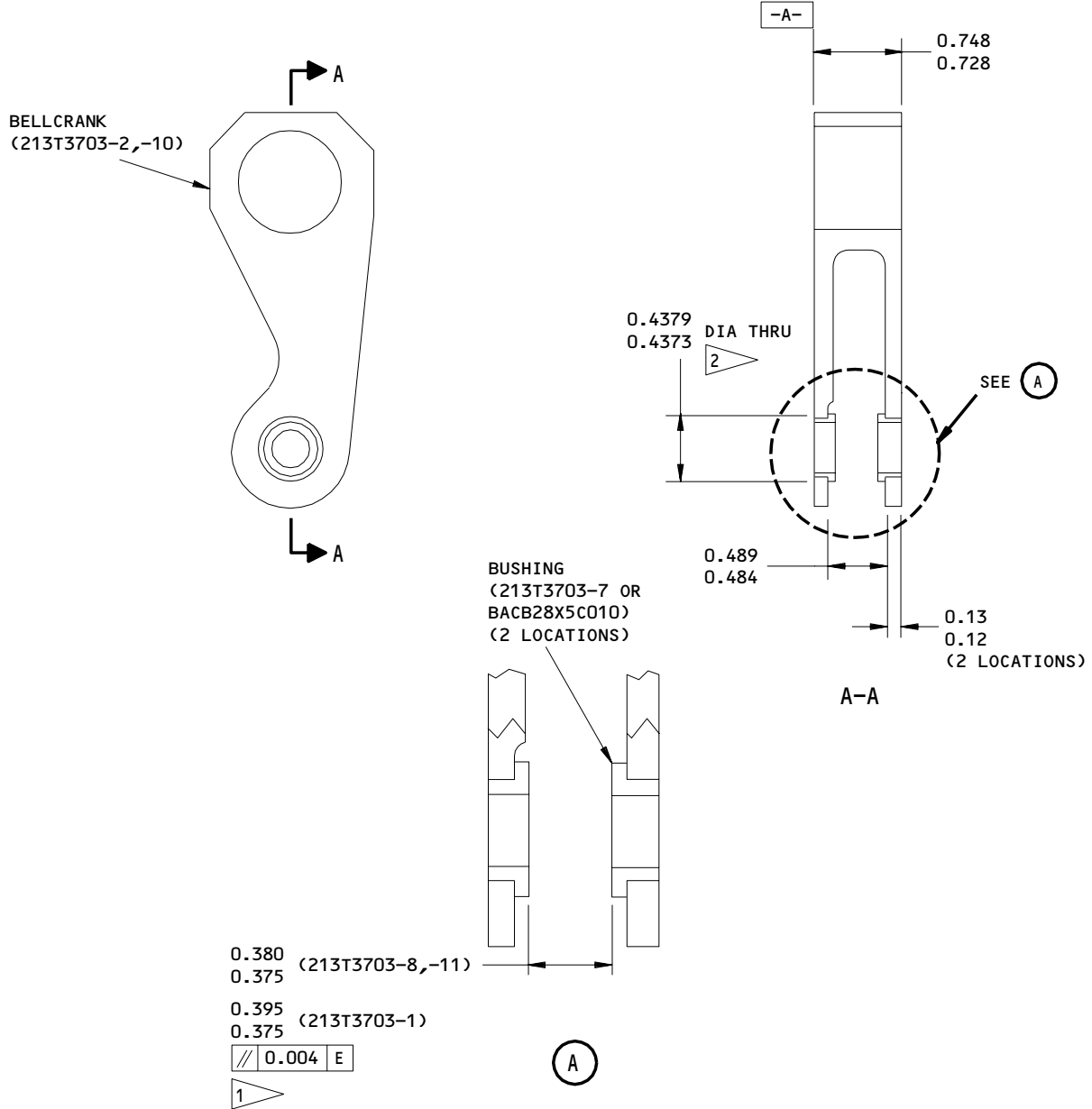
21-53-12

REPAIR 5-1

01.1

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**REFINISH**

CADMIUM PLATE (0.0002-0.0004 INCH THICK),  
TYPE 2, CLASS B (F-15.02).

- 1 IF NECESSARY, THE BUSHING FACE CAN BE MACHINED TO OBTAIN SPECIFIED GAP. THE MINIMUM FLANGE THICKNESS AFTER MACHINING IS 0.050 INCH FOR BUSHING (421) AND IS 0.055 INCH FOR BUSHING (420)
- 2 BELLCRANK DIMENSION

**REPAIR**

MATERIAL:  
 BELLCRANK (213T3703-2,-5),  
 15-15PH CRES, 125-145KSI  
 BELLCRANK (213T3703-10),  
 17-4PH CRES 130 KSI

BREAK SHARP EDGES

ALL DIMENSIONS ARE IN INCHES

213T3703-1,-8,-11  
 Bellcrank Assembly Repair  
 Figure 601

**21-53-12**

REPAIR 5-1

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RETAINER ASSEMBLY - REPAIR 6-1

69B03738-1

NOTE: Refer to REPAIR - GENERAL for the standard procedures used in the repair.

1. Bearing Replacement (470, IPL Fig. 1)

- A. Remove the bearing.
- B. Install the bearing by the roller-swage method specified in SOPM 20-50-03.
- C. After installation, the bearing (470) must withstand a push of 1000 pounds without loosening or permanent shift of the bearing.

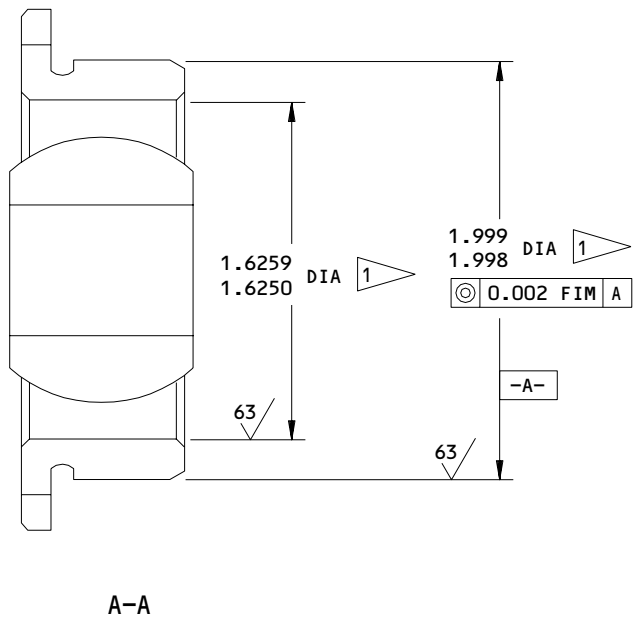
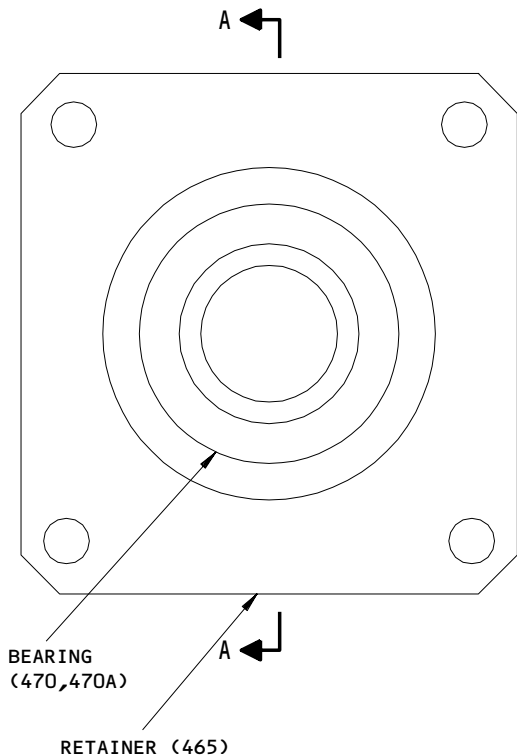
**21-53-12**

REPAIR 6-1

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**REFINISH**

TREAT SURFACE PER MIL-C-5541 OR MIL-A-8625, TYPE 1. APPLY ONE COAT OF BMS 10-11, TYPE 1 PRIMER (F-18.05).

1 OMIT PRIMER (18.05) ON THIS SURFACE

**REPAIR**

MATERIAL: 7075-T651

BREAK SHARP EDGES

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

69B03738-1  
 Retainer Assembly Repair  
 Figure 601

**21-53-12**

REPAIR 6-1

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TORQUE TUBE – REPAIR 7-1

213T3705-2, -4, -5

1. Torque Tube Refinish (IPL Fig. 1, 385; IPL Fig. 2, 285)
  - A. This repair consists of restoration of the initial finish.  
  
NOTE: See Fig. 601 (Sheet 1) for Refinish data and to REPAIR – GENERAL for the applicable standard practices necessary for this repair.
  - B. Apply cadmium plate (F-15.06) to all external surfaces where the initial cadmium plate was removed.
  - C. Apply one coat of BMS 10-11, Type 1 primer (F-20.02) on all internal and external surfaces, except as noted in Fig. 601.
2. Torque Tube Refinish (IPL Fig. 1, 385A; IPL Fig. 2, 285A)
  - A. This repair consists of restoration of the initial finish.  
  
NOTE: See Fig. 601 (Sheet 2) for Refinish data and to REPAIR – GENERAL for the applicable standard practices necessary for this repair.
  - B. Apply cadmium plate (F-16.04) to all external surfaces where the initial cadmium plate was removed.
  - C. Apply two coats of BMS 10-11, Type 1 primer (F-20.03) plus (F-19.03) on all internal surfaces.
  - D. Apply one coat of BMS 10-11, Type 1 primer (F-20.02) on all external surfaces, except as noted in Fig. 601.
3. Torque Tube Refinish (IPL Fig. 1, 385B; IPL Fig. 2, 285B)
  - A. This repair consists of restoration of the initial finish.  
  
NOTE: See Fig. 601 (Sheet 3) for Refinish data and to REPAIR – GENERAL for the applicable standard practices necessary for this repair.
  - B. Passivate (F-17.25) to all internal and external surfaces.

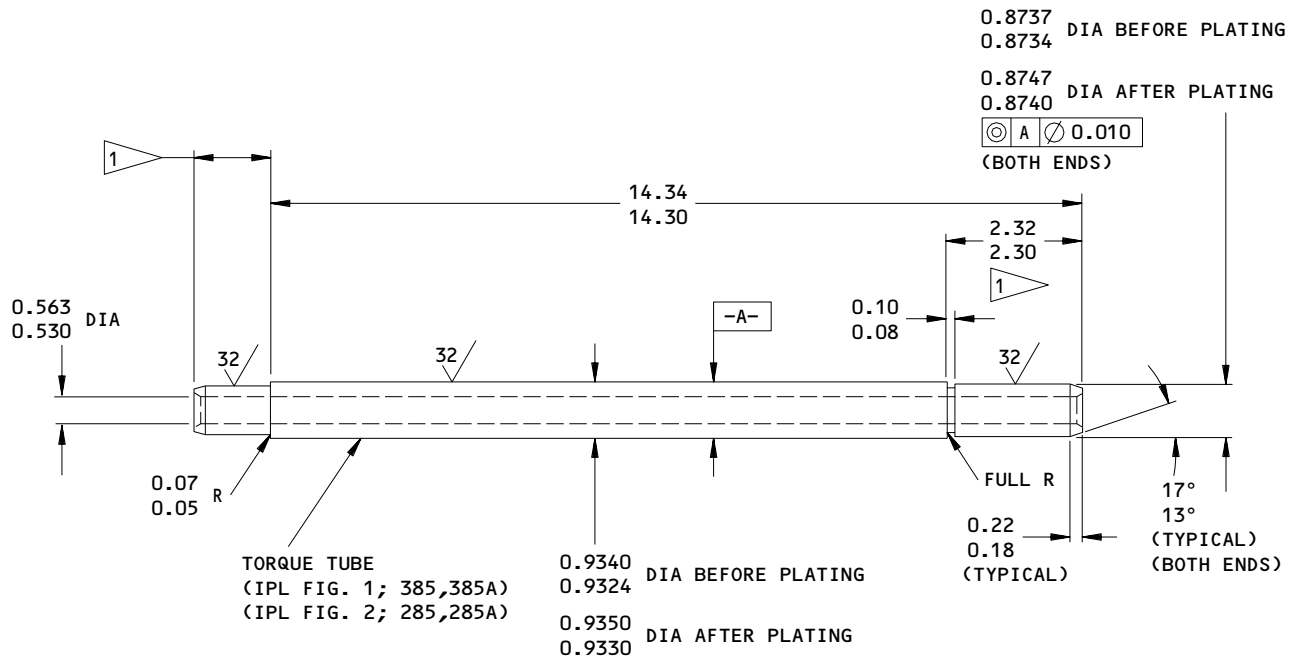
**21-53-12**

REPAIR 7-1

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213T3705-2,-4

**REFINISH:**

APPLY CADMIUM PLATE (F-16.04) TO ALL EXTERNAL SURFACES WHERE THE INITIAL CADMIUM PLATE WAS REMOVED. APPLY TWO COATS OF BMS 10-11, TYPE 1 PRIMER (F-20.03) PLUS (F-19.03) ON ALL INTERNAL SURFACES. APPLY ONE COAT OF BMS 10-11, TYPE 1 PRIMER (F-20.02) ON ALL EXTERNAL SURFACES, EXCEPT AS NOTED IN FLAGNOTE 1

**MATERIAL:**  
 4340 STEEL  
 HEAT TREAT 125-145 KSI

ALL DIMENSIONS ARE IN INCHES

1 NO PRIMER IN THIS AREA

213T3705-2,-4,-5  
 Torque Tube Refinish  
 Figure 601 (Sheet 1)

**21-53-12**

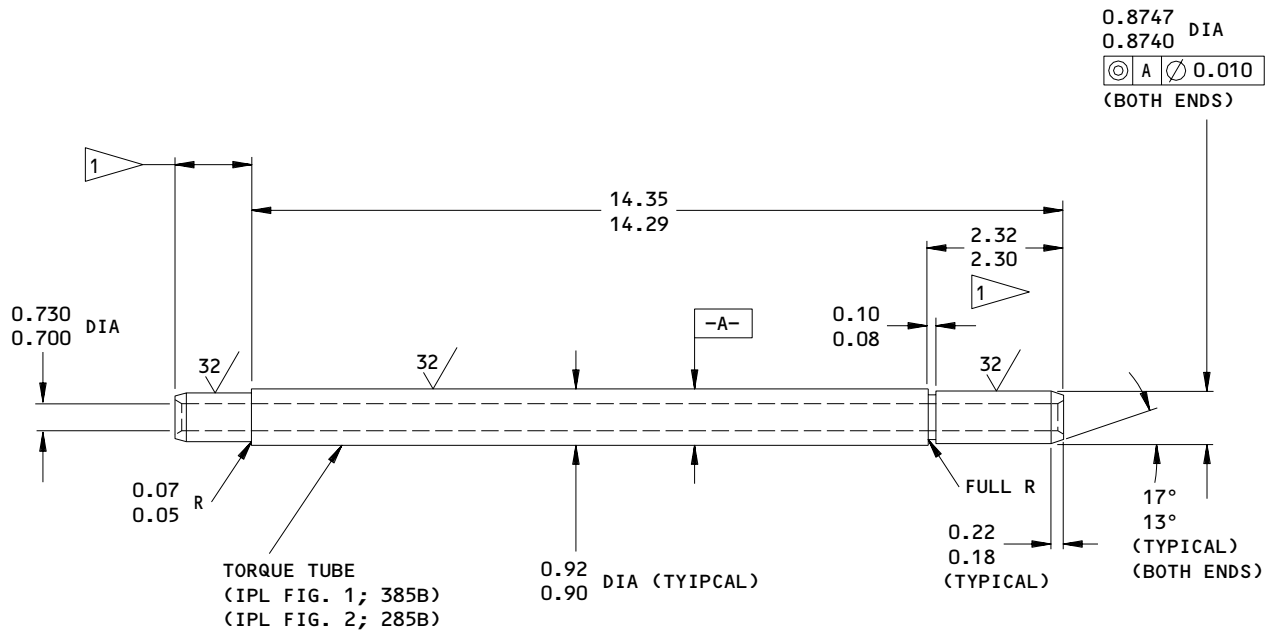
REPAIR 7-1

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213T3705-5

**REFINISH:**

PASSIVATE (F-17.25) TO ALL INTERNAL AND EXTERNAL SURFACES

**1** NO PRIMER IN THIS AREA

**MATERIAL:**

15-5 PH CRES (AMS5659)  
 HEAT TREAT 125-145 KSI

ALL DIMENSIONS ARE IN INCHES

213T3705-2,-4,-5  
 Torque Tube Refinish  
 Figure 601 (Sheet 2)

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REPAIR 7-1

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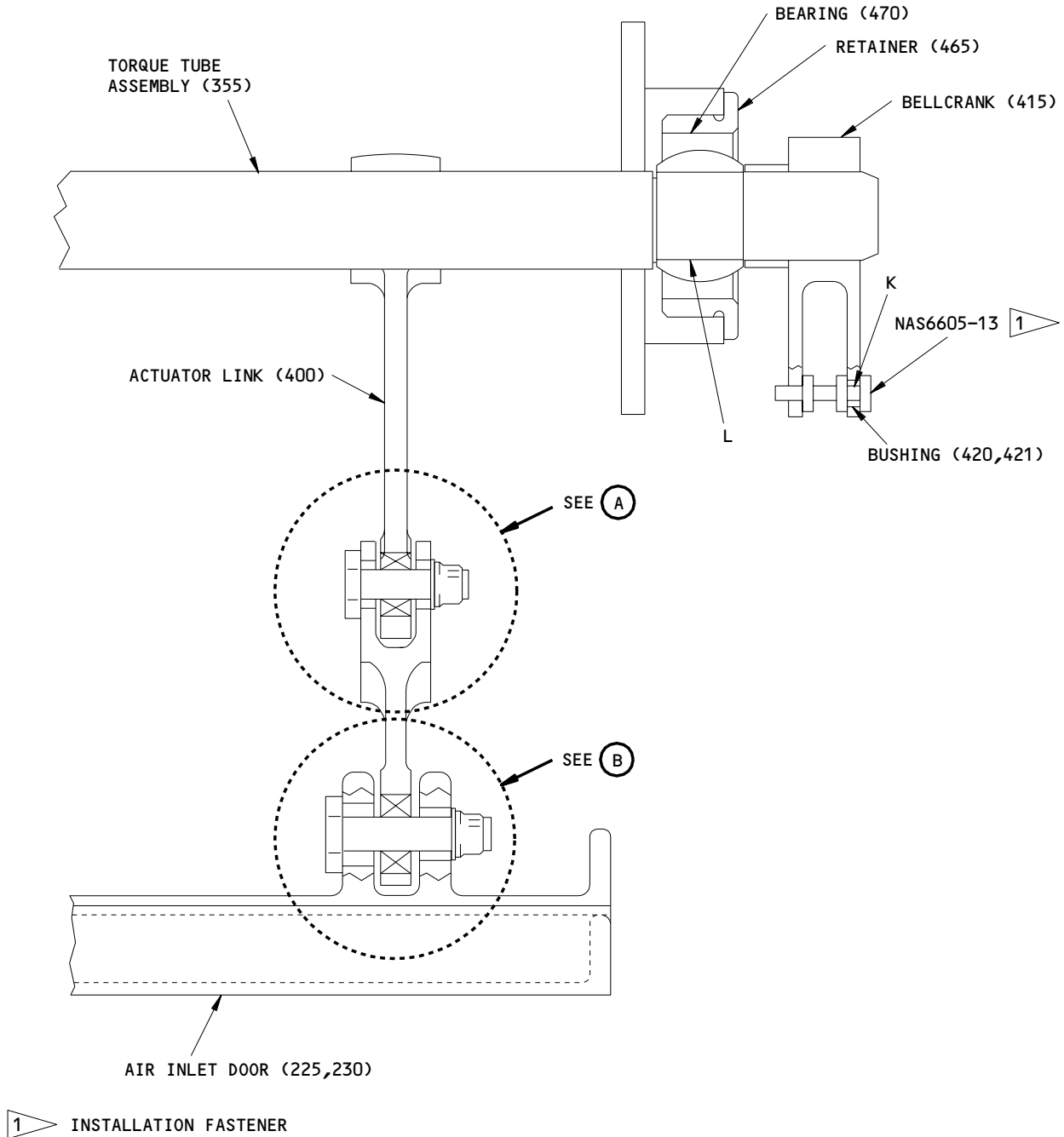
ASSEMBLY

1. Use standard industry practices for assembly of this component. Also, do the subsequent assembly procedures.
2. For ram air aft inlet door assemblies (1, 1A), assembly seal assembly (15) with the molded rubber aligned with the edge of the door.
3. Torque tube (385), actuator link assembly (390) and bellcrank assembly (410) are a matched set.
4. Install bolts (430), washers (435, 440) and nuts (445) loosely.
5. Final installation of fasteners occurs upon torque tube assembly (355) installation.

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ASSEMBLY  
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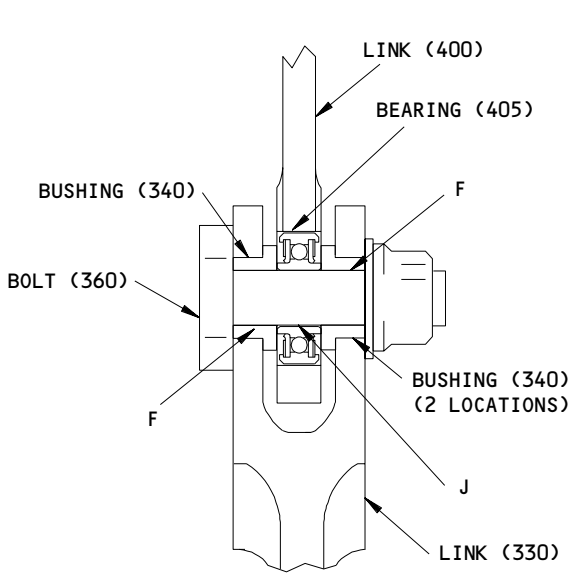
01.1



Fits and Clearances  
Figure 801 (Sheet 1)

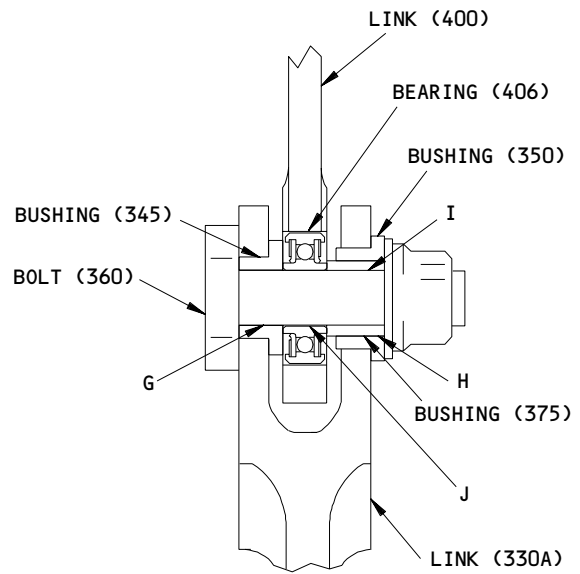
**21-53-12**

FITS AND CLEARANCES  
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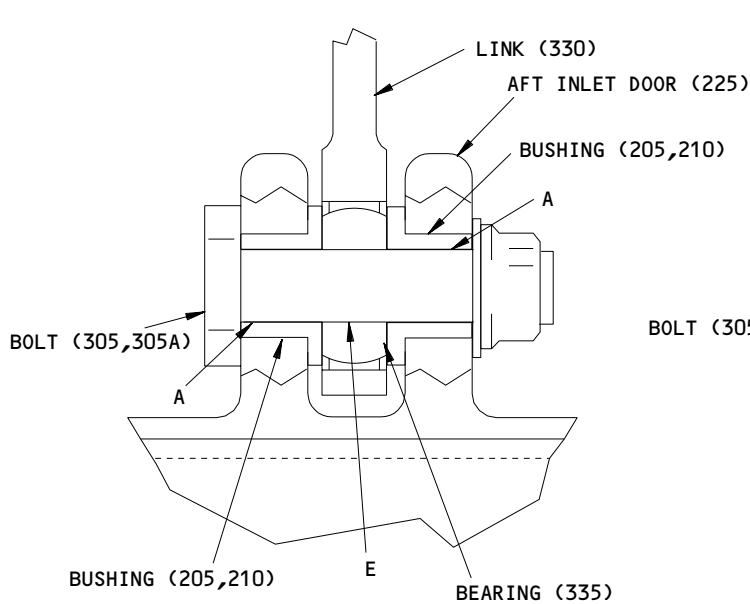
213T3009-1

(A)



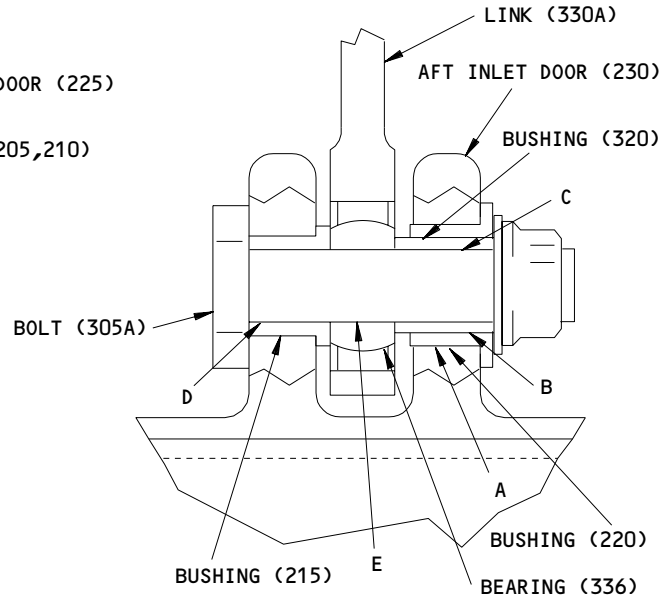
213T3009-4

(A)



213T3009-1

(B)



213T3009-4

(B)



1 INSTALLATION FASTENER

Fits and Clearances  
 Figure 801 (Sheet 2)



**21-53-12**

FITS AND CLEARANCES  
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**BOEING**  
 COMPONENT  
 MAINTENANCE MANUAL

REF LETTER	REF IPL		DESIGN DIMENSION*				SERVICE WEAR LIMIT*		
	FIG. 1, MATING ITEM NO.		DIMENSION		ASSEMBLY CLEARANCE		DIMENSION		MAXIMUM CLEARANCE
			MIN	MAX	MIN	MAX	MIN	MAX	
A	ID	205,210	0.3125	0.3140	0.0005	0.0030			
	OD	305A	0.3110	0.3120					
B	ID	220	0.4375	0.4382	0.0005	0.0017			
	OD	320	0.4365	0.4370					
C	ID	320	0.3125	0.3130	0.0005	0.0020			
	OD	305A	0.3110	0.3120					
D	ID	215	0.3125	0.3131	0.0005	0.0021			
	OD	305A	0.3110	0.3120					
E	ID	336	0.3120	0.3125	0.0000	0.0015			
	OD	305A	0.3110	0.3120					
F	ID	340	0.3125	0.3140	0.0005	0.0030			
	OD	360	0.3110	0.3120					
G	ID	345	0.3125	0.3131	0.0005	0.0021			
	OD	360	0.3110	0.3120					
H	ID	350	0.4375	0.4382	0.0005	0.0017			
	OD	375	0.4365	0.4370					
I	ID	375	0.3125	0.3130	0.0005	0.0020			
	OD	360	0.3110	0.3120					
J	ID	405,406	0.3120	0.3125	0.0000	0.0015			
	OD	360	0.3110	0.3120					
K	ID	420,421	0.3120	0.3125	0.0000	0.0015			
	OD	NAS6605-13 	0.3110	0.3120					
L	ID	470	0.8745	0.8755	-0.0002	0.0015			
	OD	355	0.8740	0.8747					

\* ALL DIMENSIONS ARE IN INCHES

-  INSTALLATION FASTENER  
 INTERFACE FIT

Fits and Clearances  
 Figure 801 (Sheet 3)

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FITS AND CLEARANCES  
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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.

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ILLUSTRATED PARTS LIST

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VENDORS

| K8455    NSK-RHP BEARINGS LTD AEROSPACE DIVISION  
|            OLDENDS LANE  
|            STONEHOUSE GL10 3RH UNITED KINGDOM

| OPTK6    SPS TECHNOLOGIES INCORPORATED  
|            5195 WEST 4700 PO BOX 18459  
|            KEARNS, UTAH 84118

| 06710    VALLEY-TODECO INC  
|            12975 BRADLEY AVENUE  
|            SYLMAR, CALIFORNIA 91342-3830

06725    AIR INDUSTRIES CORPORATION  
|            12570 KNOTT STREET  
|            GARDEN GROVE, CALIFORNIA 92841

| 10630    ANILLO INDUSTRIES, INCORPORATED  
|            2090 NORTH GLASSELL PO BOX 5586  
|            ORANGE, CALIFORNIA 92863-5586

| 11815    TEXTRON INCORPORATED TEXTRON AEROSPACE FASTENERS DIVISION  
|            1224 EAST WARNER AVENUE PO BOX 2157  
|            SANTA ANA, CALIFORNIA 92707-0157

| 15653    FAIRCHILD FASTENERS KAYNAR PRODUCTS DIVISION  
|            800 SOUTH STATE COLLEGE BOULEVARD  
|            FULLERTON, CALIFORNIA 92634-3001

15860    NEW HAMPSHIRE BALL BEARINGS, INCORPORATED ASTRO DIVISION  
|            155 LEXINGTON AVENUE  
|            LACONIA, NEW HAMPSHIRE 03246-2937

| 21335    TORRINGTON COMPANY  
|            59 FIELD STREET  
|            TORRINGTON, CONNECTICUT 06790-1008

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ILLUSTRATED PARTS LIST  
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**BOEING**  
COMPONENT  
MAINTENANCE MANUALVENDORS

27238 BRISTOL INDUSTRIES  
630 EAST LAMBERT ROAD PO BOX 630  
BREA, CALIFORNIA 92621-4119

27671 WESTSCOPE, INCORPORATED A TRIBOTECH DIVISION  
100 NAPA JUNCTION ROAD PO BOX 5030 WINE VALLEY UNIT  
NAPA, CALIFORNIA 94581-0030

30163 DSE INCORPORATED, DBA DAYRON  
6655 EAST COLBINAL DRIVE PO BOX 140394  
ORLANDO, FLORIDA 32814-0394

38443 MRC BEARINGS  
402 CHANDLER STREET  
JAMESTOWN, NEW YORK 14702-0280

40920 MPB INCORPORATION MINIATURE PRECISION BEARING DIVISION  
PRECISION PARK PO BOX 547  
KEENE, NEW HAMPSHIRE 03431

43991 FAG BEARING INCORPORATION  
200 PARK AVENUE PO BOX 1933  
DANBURY, CONNECTICUT 06813-1933

5M902 FAIRCHILD FASTENERS VOI-SHAN PRODUCTS  
SOUTHBAY OPERATIONS  
TORRANCE, CALIFORNIA 90505-5103

50632 KAMATICS CORPORATION, SUBDIVISION OF KAMAN CORPORATION  
1330 BLUE HILLS AVENUE  
BLOOMFIELD, CONNECTICUT 06002

52828 REPUBLIC FASTENER MANUFACTURING CORPORATION  
1300 RANCHO CONEJO BOULEVARD  
NEWBURY PARK, CALIFORNIA 91320-1405

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VENDORS

56878 SPS TECHNOLOGIES INCORPORATED  
AEROSPACE AND INDUSTRIAL PRODUCTS DIVISION 301 HIGHLAND AVENUE  
JENKINTOWN, PENNSYLVANIA 19046

60516 WEST COAST AEROSPACE INCORPORATED  
220 WEST E STREET  
WILMINGTON, CALIFORNIA 90744

62554 FAIRCHILD FASTENERS, SIMMONDS MECARDS FASTENER PRODUCTS  
3016 WEST LOMITA BOULEVARD  
TORRANCE, CALIFORNIA 90505-5103

72962 HARVARD INDUSTRIES INCORPORATED  
LEBANON, NEW JERSEY 08833

73134 ROLLER BEARING COMPANY OF AMERICA INC, HEIM BEARINGS DIVISION  
60 ROUND HILL ROAD PO BOX 430  
FAIRFIELD, CONNECTICUT 06430-0430

73197 HI-SHEAR CORPORATION  
2600 SKYPARK DRIVE  
TORRANCE, CALIFORNIA 90505

80539 SPS TECHNOLOGIES INCORPORATED AEROSPACE PRODUCTS DIVISION  
2701 SOUTH HARBOR BOULEVARD  
SANTA ANA, CALIFORNIA 92704-5803

83086 NEW HAMPSHIRE BALL BEARINGS, INCORPORATED  
175 JAFFREY ROAD  
PETERBOROUGH, NEW HAMPSHIRE 03458-1709

92215 FAIRCHILD FASTENERS DESIGN AND ENGINEERING CENTER  
3000 WEST LOMITA BLVD  
TORRANCE, CALIFORNIA 90505-5103

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ILLUSTRATED PARTS LIST  
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VENDORS

- | 97613 SARGENT CONTROLS AND AEROSPACE, KAHR BEARING DIVISION  
5675 WEST BURLINGAME ROAD PX BOX 730  
CORTARO, ARIZONA 85652-0730
  
- | 97928 HUCK INTERNATIONAL INCORPORATED  
3969 PARAMONT BOULEVARD  
LAKEWOOD, CALIFORNIA 90712-4193

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ILLUSTRATED PARTS LIST  
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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
ACMKP5AP510LY19		1	406	2
		2	300	2
ADW5VNC		1	336	1
		2	240	1
AN960-616		1	40	2
		2	35	2
AN960C416L		1	440	3
AN960PD516L		1	315	2
		1	370	2
BACB10BX5		1	405	2
BACB10FE05C		1	336	1
		2	240	1
BACB10FS5		1	406	2
		2	300	2
BACB10XT4MT		1	335	1
BACB28AK05-026		1	320	2
		1	375	2
		2	275	2
BACB28AK05-037		2	225A	2
BACB28AP05P012		1	345	1
		2	245	1
BACB28AP05P019		2	145	2
BACB28AT07B012C		1	350	1
		2	250	1
BACB28AT07B019C		2	150	2
BACB28A5C010		2	330	2
		2	365	2
BACB28X5C010		1	414	2
		1	421	2
		2	315	2
BACB28X5C012		1	340	2
BACB28X5F016		1	205	4
BACB28X5M016		1	210	4
BACB30LESK18		1	305A	2
		2	210	2

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 ILLUSTRATED PARTS LIST  
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**BOEING**  
 COMPONENT  
 MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACB30LE5K13		1	360A	2
		2	260	2
BACB30LU3-4		1	55	6
		2	50	6
BACB30NM4K23		1	430A	3
		2	380	3
BACB30NZ5K6		1	60	13
		2	55	13
BACC30BL5		1	70C	13
		2	60	13
BACC30M5		1	70A	13
BACC30M5F		1	75	13
BACN10BP5CD		1	365A	2
		2	265	2
BACN10CT10D		1	365	2
BACN10HR5CS		1	325A	2
		1	380A	2
		2	230	2
		2	280	2
BACN10JC4		1	445	3
BACN10JC5		1	325	2
		1	380	2
BACN10JC6		1	45	2
		2	40	2
BACN10JR3F		1	90	2
		2	75	2
BACN10KB3F		1	85	4
		2	70	4
BACN10YR4CM		1	445A	3
		2	395	3
BACR15BA3AD		2	65	12
BACR15BA3ADC		1	80A	12
BACR15BB5AD		1	5	16
		2	5	16
BACW10AT46AS		1	35	6
		2	30	6

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACW10BP5CD		1	310A	2
		2	215	2
BACW10BP5DP		1	315A	2
		1	370A	2
		2	220	2
		2	270	2
BACW10CT10D		1	310	2
BACW10CT8CU		1	435	3
		2	385	3
BH00303-5		1	325A	2
		1	380A	2
		2	230	2
		2	280	2
BH003035		1	325A	2
BH003035		1	380A	2
		2	230	2
		2	280	2
BMN5024CPD3-5		1	325A	2
		1	380A	2
		2	230	2
		2	280	2
BMN5024CPD35		1	325A	2
		1	380A	2
		2	230	2
		2	280	2
BRF100A3		1	85	4
		2	70	4
BRF200A3		1	90	2
		2	75	2
B10478		1	50A	2
		2	45A	2
CR59085		1	325A	2
		1	380A	2
		2	230	2
		2	280	2

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
CS205E		1	405	2
F2000-3		1	85	4
		2	70	4
F5000-3BAC		1	90	2
		2	75	2
HL523AZ5-6		1	60	13
HL70-5		1	70A	13
HL79-5		1	70A	13
HST11AG5-6		1	60C	13
		2	55	13
HST79-5		1	70C	13
		2	60	13
HST79CY5		1	70C	13
		2	60	13
H39953		1	325A	2
		1	380A	2
H39953-5		1	325A	2
		1	380A	2
		2	230	2
		2	280	2
H52732-4CM		1	445A	3
		2	395	3
KP5A		1	405	2
KR5CWGBZC		1	336	1
		2	240	1
KWDB5-39		1	336	1
		2	240	1
LLKP5A		1	405	2
L804-5K6		1	60	13
MS20253P4-540		1	105	1
		1	130	1
MS20253P4-540		2	90	1
MS20253P4-990		1	170	1
		2	120	1
MS51923-187		1	100	2
		1	125	2
		1	165	2
		2	85	2
		2	115	2

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
NAS1080D5		1	70	13
NAS149C0432R		1	440A	3
		2	390	3
NAS6604-23		1	430	3
NAS6605-12		1	360	2
NAS6605-17		1	305	2
NS103185-02		2	70	4
NS103203-02		1	90	2
		2	75	2
PACMKP5AA3908		1	406	2
		2	300	2
PLH54CM		1	445A	3
		2	395	3
RMF9201-3		1	90	2
		2	75	2
RMF9207-3		1	85	4
		2	70	4
SL705095		1	325A	2
		1	380A	2
SL7059C524		2	230	2
		2	280	2
SSMKP5ASD705		1	406	2
		2	300	2
T8091S1032		1	90	2
		2	75	2
T8114S1032S		1	85	4
		2	70	4
VN151A1-02		1	85	4
		2	70	4
VN152A1-02		1	90	2
		2	75	2
WES05B10GC		1	336	1
		2	240	1
WHT05VSBC		1	336	1
		2	240	1
WRRS05B10GC		1	336	1
		2	240	1
213T3008-1		1	300	RF
213T3008-2		1	330	1
213T3008-4		1	300A	RF
		2	205	RF
213T3008-5		1	330A	1
		2	235	1
213T3009-1		1	200A	1
213T3009-2		1	225	1
213T3009-4		2	140	1

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
213T3009-5		2	160	1
213T3011-1		1	390	2
213T3011-2		1	400	1
		2	295	2
213T3011-4		1	390A	2
		2	290	2
213T3011-5		1	400A	1
		2	295A	2
213T3101-1		1	1	RF
		2	1	RF
213T3107-1		1	355	1
		2	255	1
213T3108-1		1	155	1
213T3108-2		1	185	1
213T3108-3		1	175	1
213T3108-4		1	160	1
		2	110	1
213T3108-5		1	190	1
		2	130	1
213T3108-6		1	180	1
		2	125	1
213T3108-7		2	110A	1
213T3109-1		1	95	1
213T3109-16		2	80B	1
213T3109-2		1	115	1
213T3109-3		1	110	1
213T3109-4		1	120	1
		2	80	1
213T3109-5		1	150	1
		2	95	1
213T3109-6		1	140	1
		2	100	1
213T3109-7		1	120A	1
		2	80A	1
213T3109-8		1	145	1
		2	100A	1
213T3109-9		1	135	1
		2	95A	1
213T3110-1		1	15	1
		2	10	1
213T3110-2		1	20	1
		2	15	1
213T3110-3		1	25	1
		2	20	1
213T3401-1		1	10	1

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
213T3703-1		1	410	1
		2	325	1
213T3703-10		1	415B	1
		2	310	1
213T3703-11		1	410B	1
		2	305	1
213T3703-14		1	411	1
		2	345	1
213T3703-15		1	413	1
		2	360	1
213T3703-2		1	412P	1
		1	415	1
		2	335	1
		2	355	1
213T3703-4		2	320	1
213T3703-5		1	414P	1
		2	370	1
213T3703-7		1	412	2
		2	350	2
213T3703-8		1	410A	1
		2	340	1
213T3704-1		1	425	1
		2	375	1
213T3705-2		1	385	1
		2	285	1
213T3705-4		1	385A	1
		2	285A	1
213T3705-5		1	385B	1
		2	285B	1
213T3706-1		1	30	1
213T3706-1		2	25	1
231T3010-1		1	195	1
		2	135	1
60B97215-2		1	50A	2
		2	45A	2

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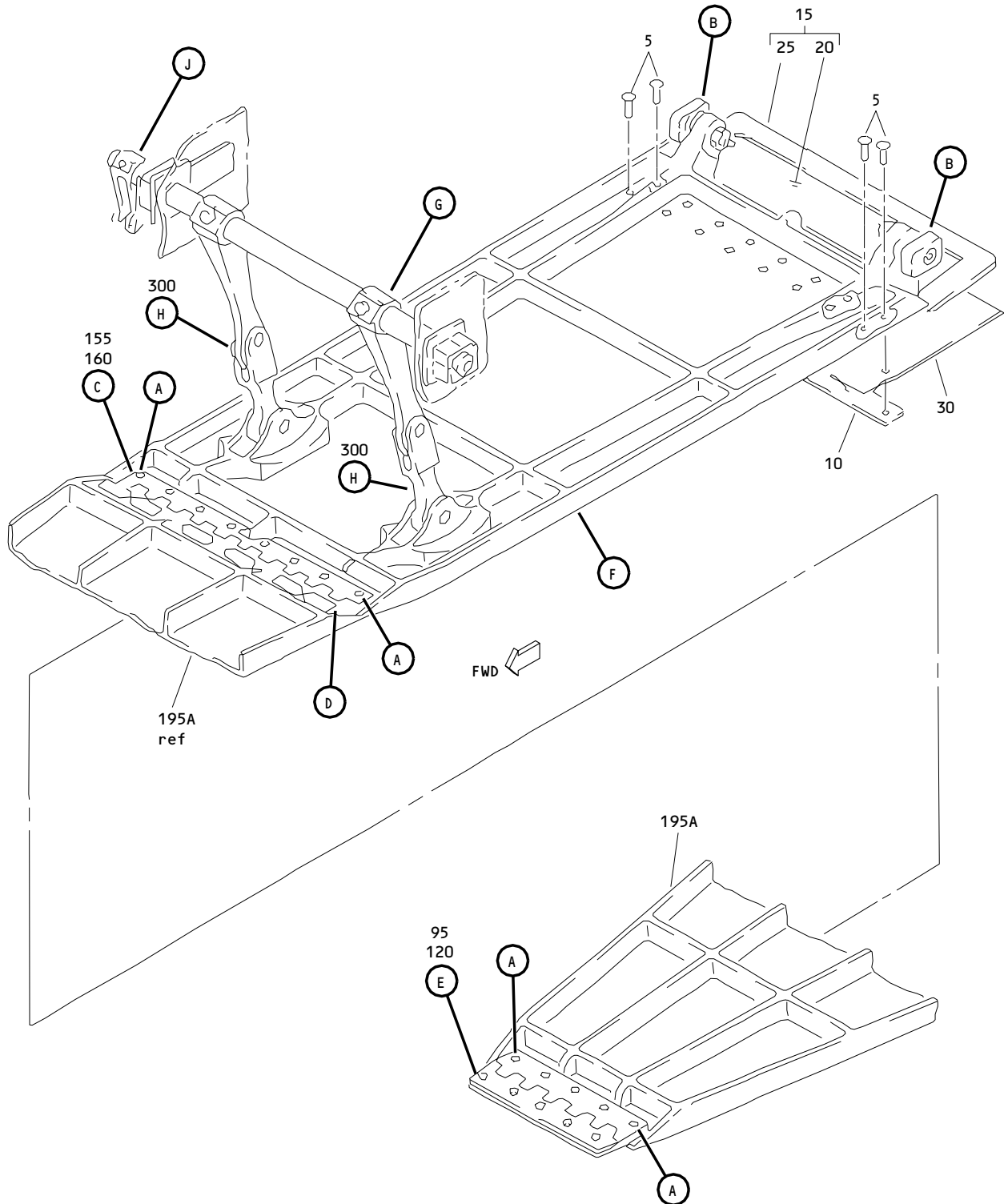
PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
66014-5 67832AS524		1	70A	13
		1	325A	2
		1	380A	2
		2	230	2
		2	280	2

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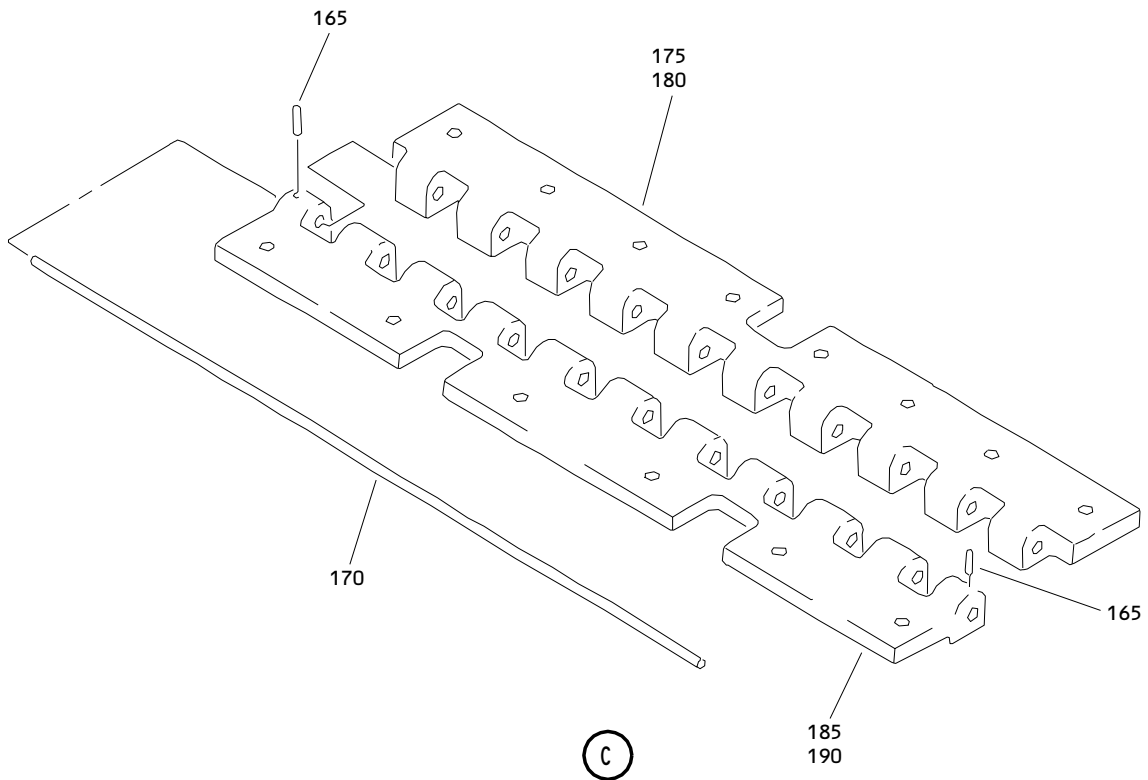
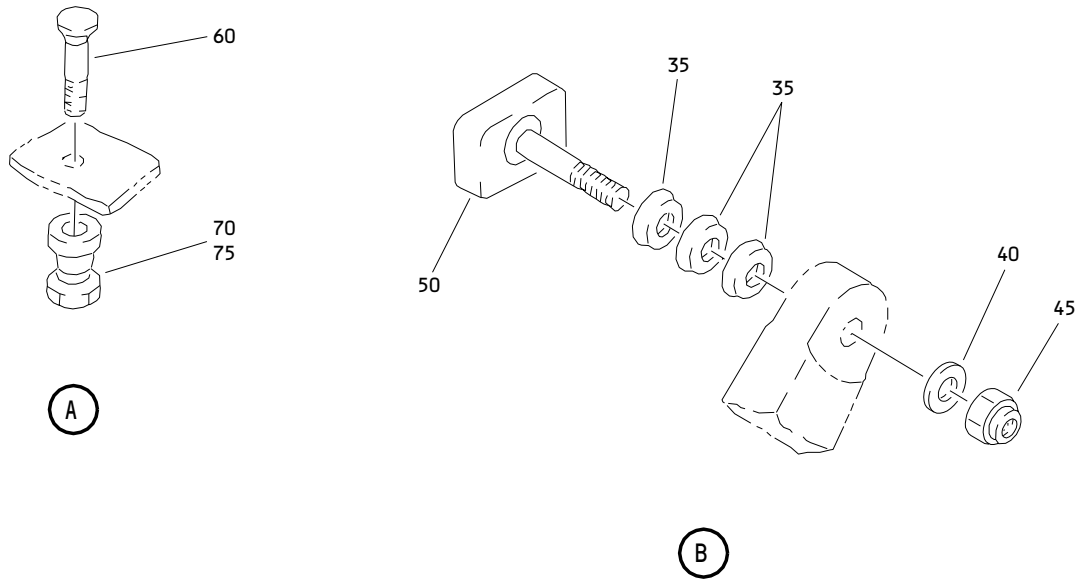
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Ram Air Inlet Modulating Door Assembly  
 Figure 1 (Sheet 1)

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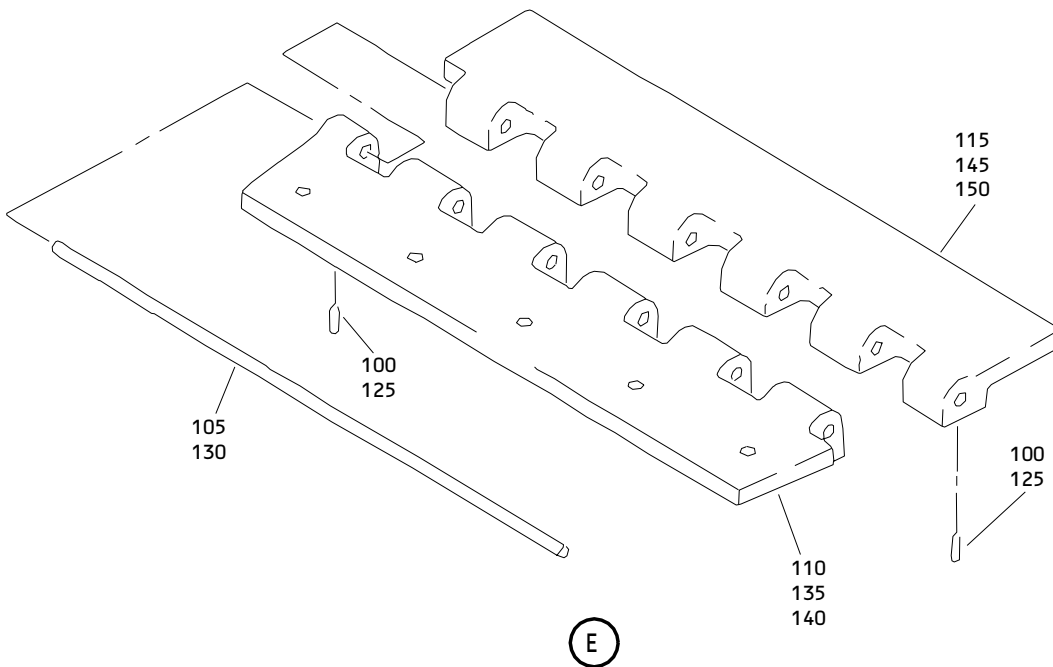
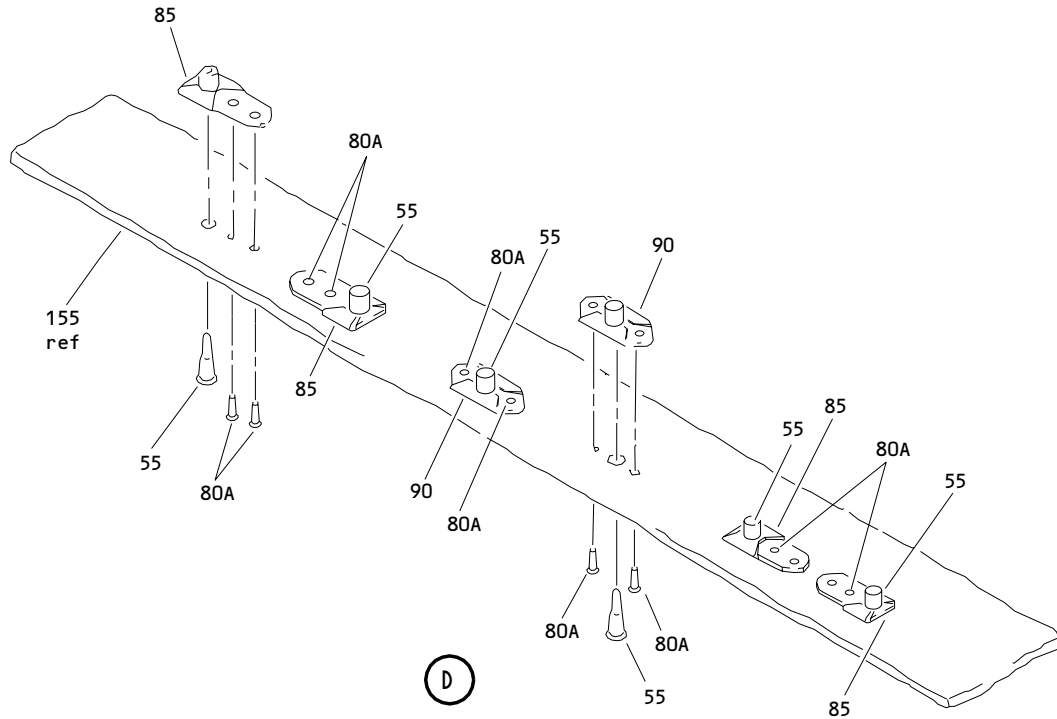
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Figure 1 (Sheet 2)

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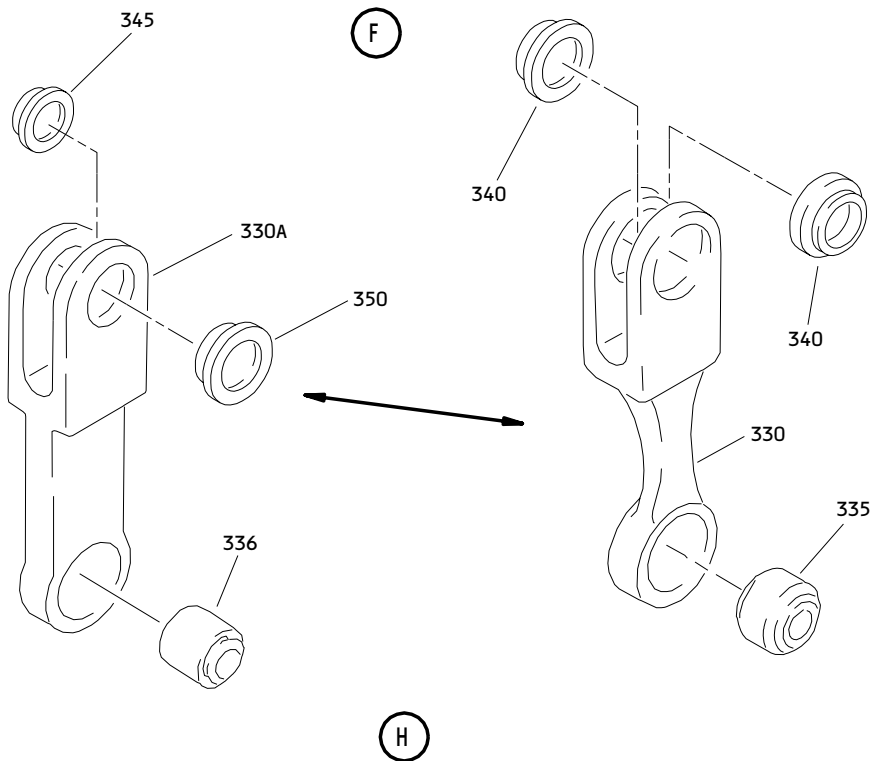
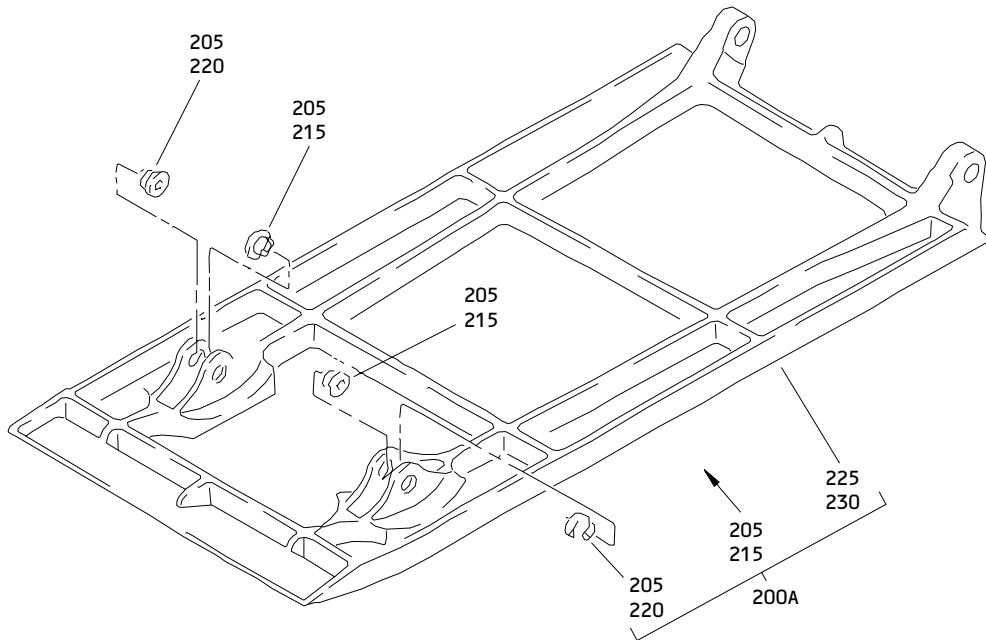
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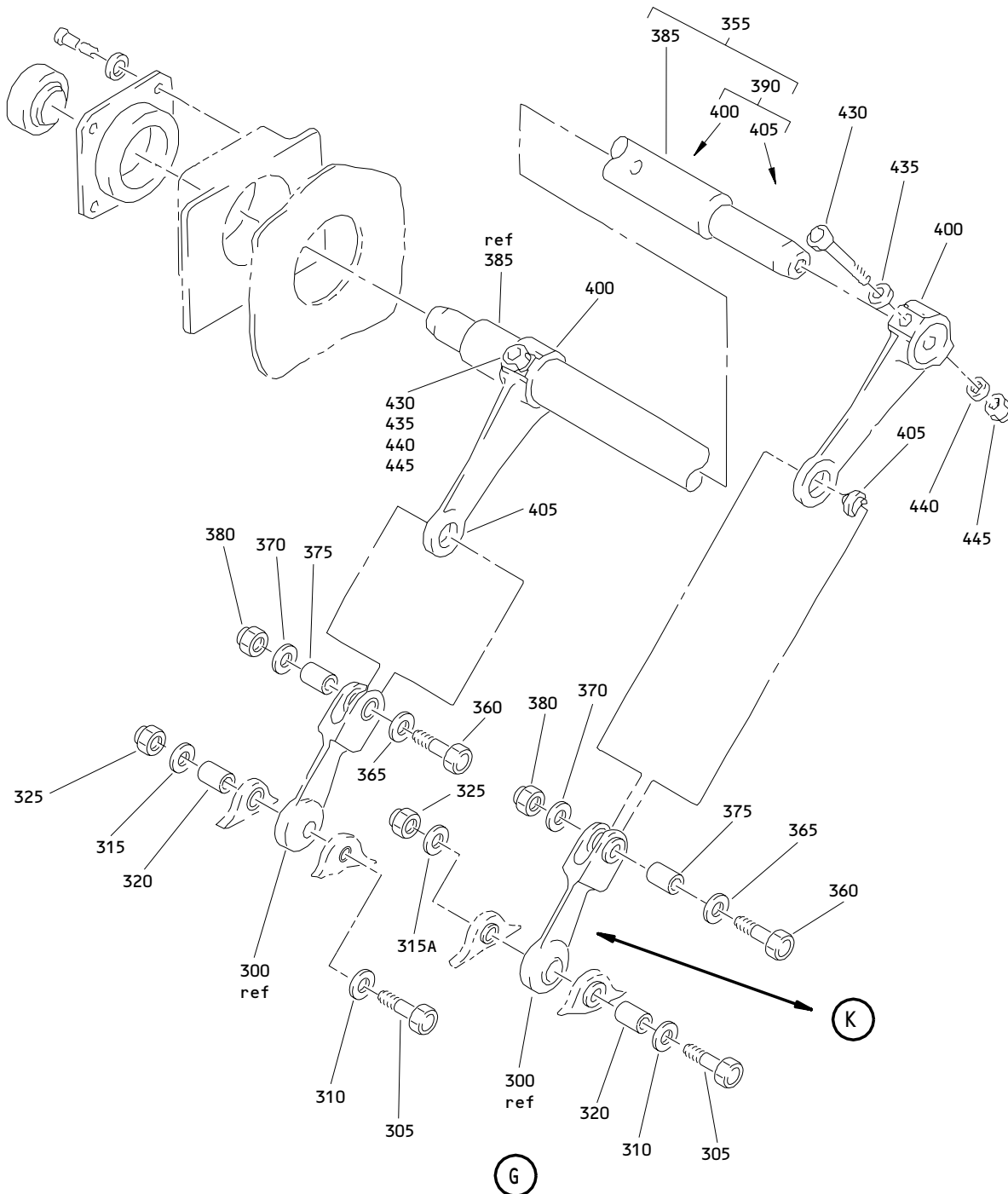
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Ram Air Inlet Modulating Door Assembly  
Figure 1 (Sheet 4)

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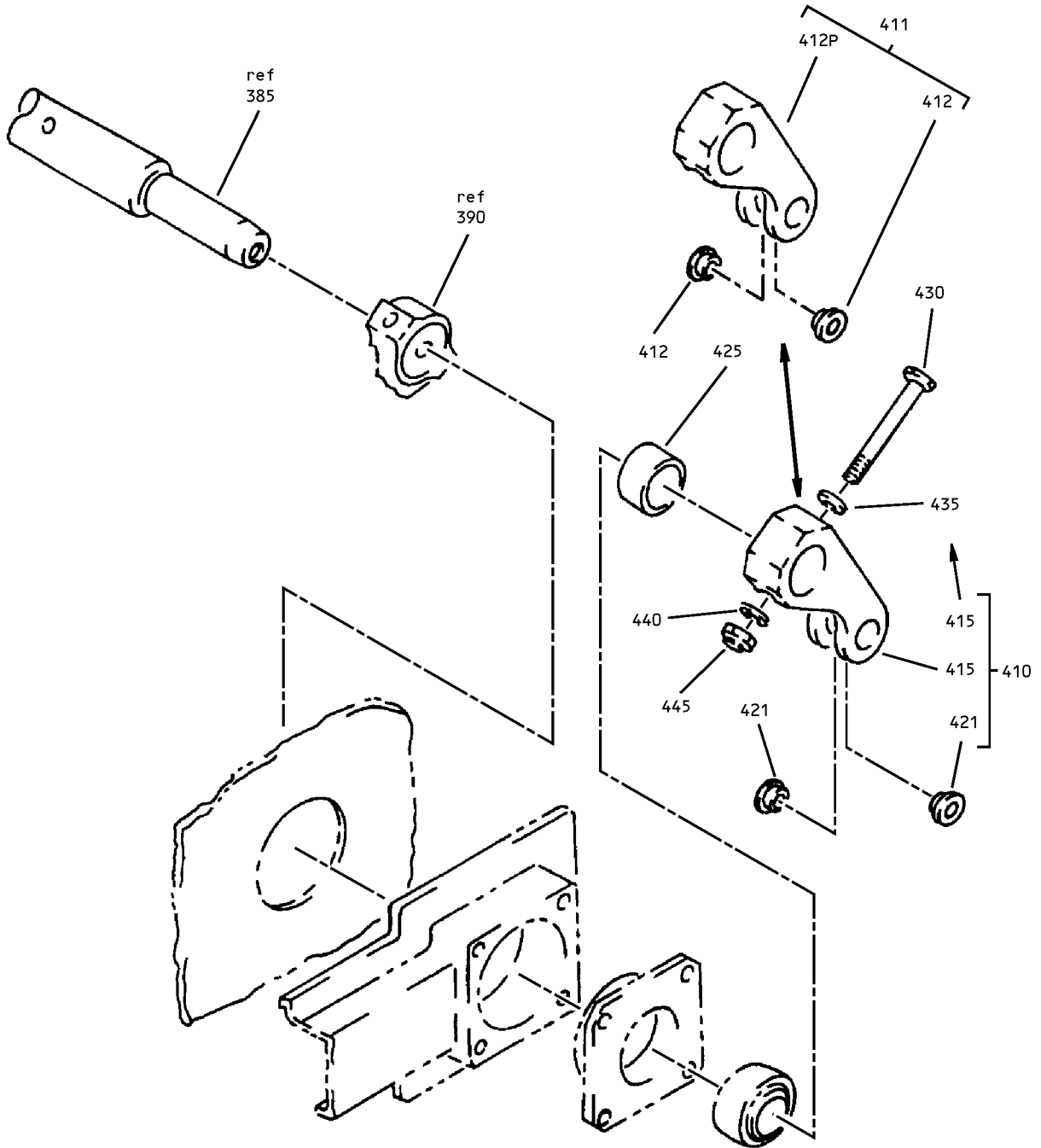
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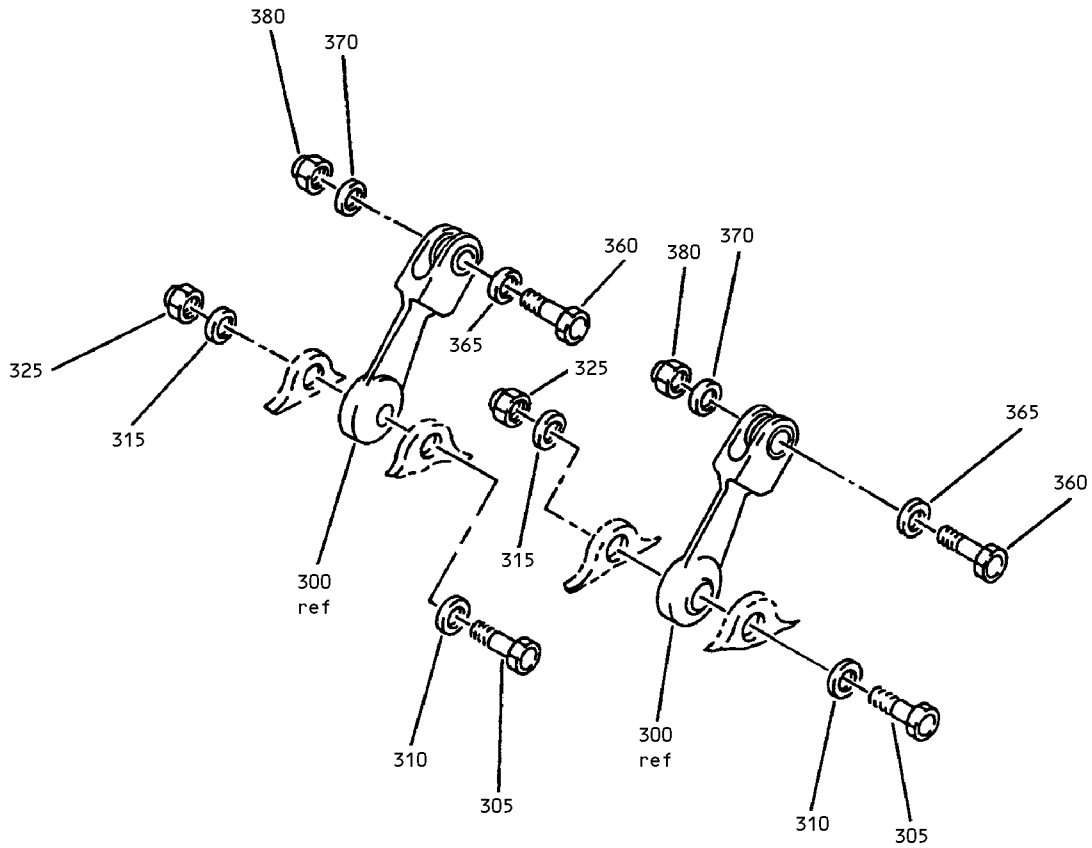
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Ram Air Inlet Modulating Door Assembly  
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Figure 1 (Sheet 7)

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-1	213T3101-1		DOOR ASSY-MODULATING AIR INLET RAM	A	RF
-1A	213T3101-2		DOOR ASSY-MODULATING AIR INLET RAM	B	RF
-1B	213T3101-3		DOOR ASSY-MODULATING AIR INLET RAM	C	RF
-1C	213T3101-4		DOOR ASSY-MODULATING AIR INLET RAM	D	RF
-1D	213T3101-5		DOOR ASSY-MODULATING AIR INLET RAM (FOR DETAILS SEE FIG. 2)	E	RF
5	BACR15BB5AD		.RIVET	A,B	16
10	213T3401-1		.DOUBLER	A,B	1
15	213T3110-1		.SEAL ASSY	A,B	1
20	213T3110-2		..STRIP	A,B	1
25	213T3110-3		..SEAL	A,B	1
30	213T3706-1		.SHIM	A,B	1
35	BACW10AT46AS		.WASHER- (V10630) (SPEC BACW10AT46AS)	A-D	6
40	AN960-616		.WASHER	A-D	2
45	BACN10JC6		.NUT	A-D	2
50	W750221		DELETED		
R 50A	B10478		.BLOCK- (V55231) (SPEC 60B97215-2)	A-D	2
55	BACB30LU3-4		.BOLT	A-D	6
60	HL523AZ5-6		.BOLT- (V56878) (SPEC BACB30NZ5K6) (OPT L804-5K6 (V06725)) (OPT HL523AZ5-6 (V92215)) (OPT HL523AZ5-6 (V97928)) (OPT HL523AZ5-6 (V0PTK6)) (OPT HL523AZ5-6 (V73197)) (OPT HL523AZ5-6 (V60516)) (OPT HL523AZ5-6 (V06725))	D	13

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01- -60A -60B	HST11AG5-6 HL523AZ5-6		DELETED .BOLT-*(1),*(2) (V56878) (SPEC BACB30NZ5K6) (OPT L804-5K6 (V06725)) (OPT HL523AZ5-6 (V92215)) (OPT HL523AZ5-6 (V97928)) (OPT HL523AZ5-6 (V0PTK6)) (OPT HL523AZ5-6 (V73197)) (OPT HL523AZ5-6 (V60516)) (OPT HL523AZ5-6 (V06725))	A-C	13
-60C	HST11AG5-6		.BOLT-*(2) (V06725) (SPEC BACB30VU5K6) (OPT HST11AG5-6 (V73197)) (OPT HST11AG5-6 (V0PTK6)) (OPT HST11AG5-6 (V56878))	A-C	13
-60D -60E	HL523AZ5-6 HST11AG5-6		DELETED DELETED		

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01- 65 70 -70A	2L426YE5-6 NAS1080D5 HL70-5		DELETED .COLLAR .COLLAR- (V56878) (SPEC BACC30M5) (OPT HL70-5 (V73197)) (OPT HL70-5 (V92215)) (OPT 66014-5 (V56878)) (OPT HL79-5 (V5M902))	A-C D	13 13
-70B	HL70-5		.COLLAR-*(1), *(2) (V56878) (SPEC BACC30M5) (OPT HL70-5 (V73197)) (OPT HL70-5 (V92215)) (OPT 66014-5 (V56878)) (OPT HL79-5 (V5M902))	A-C	13
-70C	HST79CY5		.COLLAR-*(2) (V73197) (SPEC BACC30BL5) (OPT HST79-5 (V92215)) (OPT HST79-5 (V56878)) (OPT HST79-5 (V5M902))	A-C	13
-70D	HL70-5		DELETED		
-70E	HST79CY5		DELETED		

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R	01-75	BACC30M5F	.COLLAR	A-D	13
	80	BACR15BA3FADC	DELETED		
	80A	BACR15BA3ADC	.RIVET	A-D	12
	85	BRF100A3	.NUTPLATE- (V52828) (SPEC BACN10KB3F) (OPT F2000-3 (V15653)) (OPT RMF9207-3 (V72962)) (OPT T8114S1032S (V11815)) (OPT VN151A1-02 (V92215)) (OPT F2000-3 (V15653))	A-D	4
	90	F5000-3BAC	.NUTPLATE- (V15653) (SPEC BACN10JR3F) (OPT NS103203-02 (V80539)) (OPT RMF9201-3 (V72962)) (OPT T8091S1032 (V11815)) (OPT VN152A1-02 (V92215)) (OPT BRF200A3 (V52828))	A-D	2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
95	213T3109-1		.HINGE ASSY	A	1
100	MS51923-187		..PIN	A	2
105	MS20253P4-540		..PIN	A	1
110	213T3109-3		..HINGE HALF	A	1
115	213T3109-2		..HINGE HALF	A	1
120	213T3109-4		.HINGE ASSY-FWD (OPT ITEM 120A)	B-D	1
-120A	213T3109-7		.HINGE ASSY-FWD (OPT ITEM 120)	B-D	1
-120B	213T3109-4		DELETED		
-120C	213T3109-7		DELETED		
-120D	213T3109-16		DELETED		
125	MS51923-187		..PIN	B-D	2
130	MS20253P4-540		..PIN	B-D	1
135	213T3109-9		..HINGE HALF- (USED ON ITEM 120A)	B-D	1
140	213T3109-6		..HINGE HALF- (USED ON ITEM 120)	B-D	1
145	213T3109-8		..HINGE HALF- (USED ON ITEM 120A)	B-D	1
150	213T3109-5		..HINGE HALF- (USED ON ITEM 120)	B-D	1
155	213T3108-1		.HINGE ASSY-AFT	A	1
160	213T3108-4		.HINGE ASSY-AFT	B-D	1
-160A	213T3108-4		DELETED		
-160B	213T3108-7		DELETED		
165	MS51923-187		..PIN	A-D	2
170	MS20253P4-990		..PIN	A-D	1
175	213T3108-3		..HINGE HALF	A	1
180	213T3108-6		..HINGE HALF	B-D	1
185	213T3108-2		..HINGE HALF	A	1
190	213T3108-5		..HINGE HALF	B-D	1
195	231T3010-1		.DOOR ASSY-INLET FWD	A-D	1
200	231T3009-1		DELETED		
200A	213T3009-1		.DOOR ASSY-INLET AFT	A-D	1
-200B	213T3009-4		DELETED		
205	BACB28X5F016		..BUSHING- (OPT ITEM 210)	A-D	4
-210	BACB28X5M016		..BUSHING- (OPT ITEM 205)	A-D	4
215	BACB28AP05P019		DELETED		
220	BACB28AT07B019C		DELETED		
225	213T3009-2		..DOOR-MACHINED	A-D	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-230	213T3009-5		DELETED INSTALLATION PARTS		
300	213T3008-1		LINK ASSY- (USED WITH ITEMS 305, 310, 315, 325, 330, 335, 340)	A-D	RF
-300A	213T3008-4		LINK ASSY-*(3) (USED WITH ITEMS 305A, 310A, 315A, 320, 325A, 330A, 336, 345, 350)	A-D	RF
-300B	213T3008-4		DELETED ATTACHING PARTS		
305	NAS6605-17		BOLT- (USED WITH ITEM 300)	A-D	2
-305A	BACB30LESK18		BOLT- (USED WITH ITEM 300A)	A-D	2
310	BACW10CT10D		WASHER- (USED WITH ITEM 300)	A-D	2
-310A	BACW10BP5CD		WASHER- (USED WITH ITEM 300A)	A-D	2
315	AN960PD516L		WASHER- (USED WITH ITEM 300)	A-D	2
-315A	BACW10BP5DP		WASHER- (USED WITH ITEM 300A)	A-D	2
320	BACB28AK05-026		BUSHING- (USED WITH ITEM 300A)	A-D	2
325	BACN10JC5		NUT- (USED WITH ITEM 300)	A-D	2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01- -325A	H39953-5		NUT- (V15653) (SPEC BACN10HR5CS) (OPT 67832AS524 (V56878)) (OPT BMN5024CPD3-5 (V97928)) (OPT BH00303-5 (V27238)) (OPT BH003035 (V27238)) (OPT BMN5024CPD35 (V97928)) (OPT CR59085 (V62554)) (OPT H39953 (V15653)) (OPT SL705095 (V11815)) (USED WITH ITEM 300A)	A-D	2
330	213T3008-2		*----- .LINK- (USED ON ITEM 300)	A-D	1
330A	213T3008-5		.LINK- (USED ON ITEM 300A)	A-D	1
335	BACB10XT4MT		.BEARING- (USED ON ITEM 300)	A-D	1
336	WES05B10GC		.BEARING- (V73134) (SPEC BACB10FE05C) (OPT ADW5VNC (V15860)) (OPT KR5CWGBZC (V50632)) (OPT KWDB5-39 (V97613)) (OPT WRRS05B10GC (V73134)) (OPT WHT05VSBC (VS0352)) (USED ON ITEM 300A)	A-D	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-340	BACB28X5C012		.BUSHING- (USED ON ITEM 300)	A-D	2
345	BACB28AP05P012		.BUSHING- (USED ON ITEM 300A)	A-D	1
350	BACB28AT07B012C		.BUSHING- (USED ON ITEM 300A)	A-D	1
355	213T3107-1		TORQUE TUBE ASSY- (OPT ITEM 355A) (USED WITH ITEM 360, 365, 370, 380)	A-D	1
-355A	213T3107-3		TORQUE TUBE ASSY-*(3) (OPT ITEM 355) (USED WITH ITEMS 360A, 365A, 370A, 375, 380A)	A-D	1
-355B	213T3107-3		DELETED ATTACHING PARTS		
360	NAS6605-12		BOLT- (USED WITH ITEM 355)	A-D	2
-360A	BACB30LE5K13		BOLT- (USED WITH ITEMS 355A, 355B)	A-D	2
365	BACN10CT10D		WASHER- (USED WITH ITEM 355)	A-D	2
-365A	BACN10BP5CD		WASHER- (USED WITH ITEMS 355A, 355B)	A-D	2
370	AN960PD516L		WASHER- (USED WITH ITEM 355)	A-D	2
-370A	BACW10BP5DP		WASHER- (USED WITH ITEMS 355A, 355B)	A-D	2
R 375	BACB28AK05-026		BUSHING- (USED WITH ITEMS 355A, 355B)	A-D	2
380	BACN10JC5		NUT- (USED WITH ITEM 355)	A-D	2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01- -380A	H39953-5		NUT- (V15653) (SPEC BACN10HR5CS) (OPT 67832AS524 (V56878)) (OPT BMN5024CPD3-5 (V97928)) (OPT BH00303-5 (V27238)) (OPT BH003035 (V27238)) (OPT BMN5024CPD35 (V97928)) (OPT CR59085 (V62554)) (OPT H39953 (V15653)) (OPT SL705095 (V11815)) (USED WITH ITEMS 355A, 355B)	A-D	2
385	213T3705-2		-----* .TORQUE TUBE--*(4) (OPT ITEMS 385A, 385B)	A-D	1
-385A	213T3705-4		.TORQUE TUBE--*(4) (OPT ITEMS 385, 385B)	A-D	1
-385B	213T3705-5		.TORQUE TUBE--*(4) (OPT ITEMS 385, 385A)	A-D	1
390	213T3011-1		.ACTUATOR LINK ASSY--*(4) (USED ON ITEM 355) (OPT ITEM 390A)	A-D	2
-390A	213T3011-4		.ACTUATOR LINK ASSY--*(4) (USED ON ITEM 355) (OPT ITEM 390)	A-D	2
-390B	213T3011-4		.ACTUATOR LINK ASSY--*(4) (USED ON ITEMS 355A, 355B)	A-D	2
400	213T3011-2		..LINK- (OPT ITEM 400A)	A-D	1
R -400A	213T3011-5		..LINK-HOGOUT (OPT ITEM 400)	A-D	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-405	KP5AFS428		..BEARING- (V21335) (SPEC BACB10BX5) (OPT KP5A2TS (V43991)) (OPT LLKP5A (V38443)) (OPT KP5AG27 (V30163)) (OPT KP5A (V38443)) (OPT KP5ALY196 (V40920)) (OPT KP5ASD610 (V83086)) (OPT CS205E (VK8455)) (USED ON ITEM 390)	A-D	1
-406	SSMKP5ASD705		..BEARING- (V83086) (SPEC BACB10FS5) (OPT ACMKP5AP510LY19 (V40920)) (OPT PACMKP5AA3908 (V21335)) (USED ON ITEMS 390A, 390B)	A-D	1
R 410	213T3703-1		.CRANK ASSY-*(4) (OPT ITEMS 410A, 410B) (USED ON ITEM 355)	A-D	1
R -410A	213T3703-8		.CRANK ASSY-*(4) (OPT ITEMS 410, 410B) (USED ON ITEM 355)	A-D	1
-410B	213T3703-11		.CRANK ASSY- (OPT ITEMS 410, 410A) (USED ON ITEM 355)	A-D	1
R 411	213T3703-14		..KIT ASSY-SUBSTITUTE (OPT ITEM 413) (USED ON ITEM 410A)	A-D	1
R 412	213T3703-7		...BUSHING	A-D	2
R 412P	213T3703-2		...CRANK	A-D	1
R -413	213T3703-15		..KIT ASSY-SUBSTITUTE (OPT ITEM 411) (USED ON ITEM 410A)	A-D	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 01-					
R -414	BACB28X5C010		...BUSHING	A-D	2
R -414P	213T3703-5		...CRANK	A-D	1
415	213T3703-2		..CRANK- (USED ON ITEM 410)	A-D	1
-415A	213T3703-2		DELETED		
-415B	213T3703-10		..CRANK- (USED ON ITEMS 410B, 410C)	A-D	1
-415C	213T3703-5		DELETED		
420	213T3703-7		DELETED		
421	BACB28X5C010		..BUSHING- (USED ON ITEMS 410, 410B, 410C)	A-D	2
-421A	BACB28X5C010		DELETED		
425	213T3704-1		.SPACER	A-D	1
430	NAS6604-23		.BOLT- (USED ON ITEM 355)	A-D	3
-430A	BACB30NM4K23		.BOLT- (USED ON ITEMS 355A, 355B)	A-D	3
435	BACW10CT8CU		.WASHER	A-D	3
440	AN960C416L		.WASHER- (USED ON ITEM 355)	A-D	3
-440A	NAS149C0432R		.WASHER- (USED ON ITEMS 355A, 355B)	A-D	3
445	BACN10JC4		.NUT- (USED ON ITEM 355)	A-D	3
-445A	H52732-4CM		.NUT- (V15653) (SPEC BACN10YR4CM) (OPT PLH54CM (V62554)) (USED ON ITEMS 355A, 355B)	A-D	3

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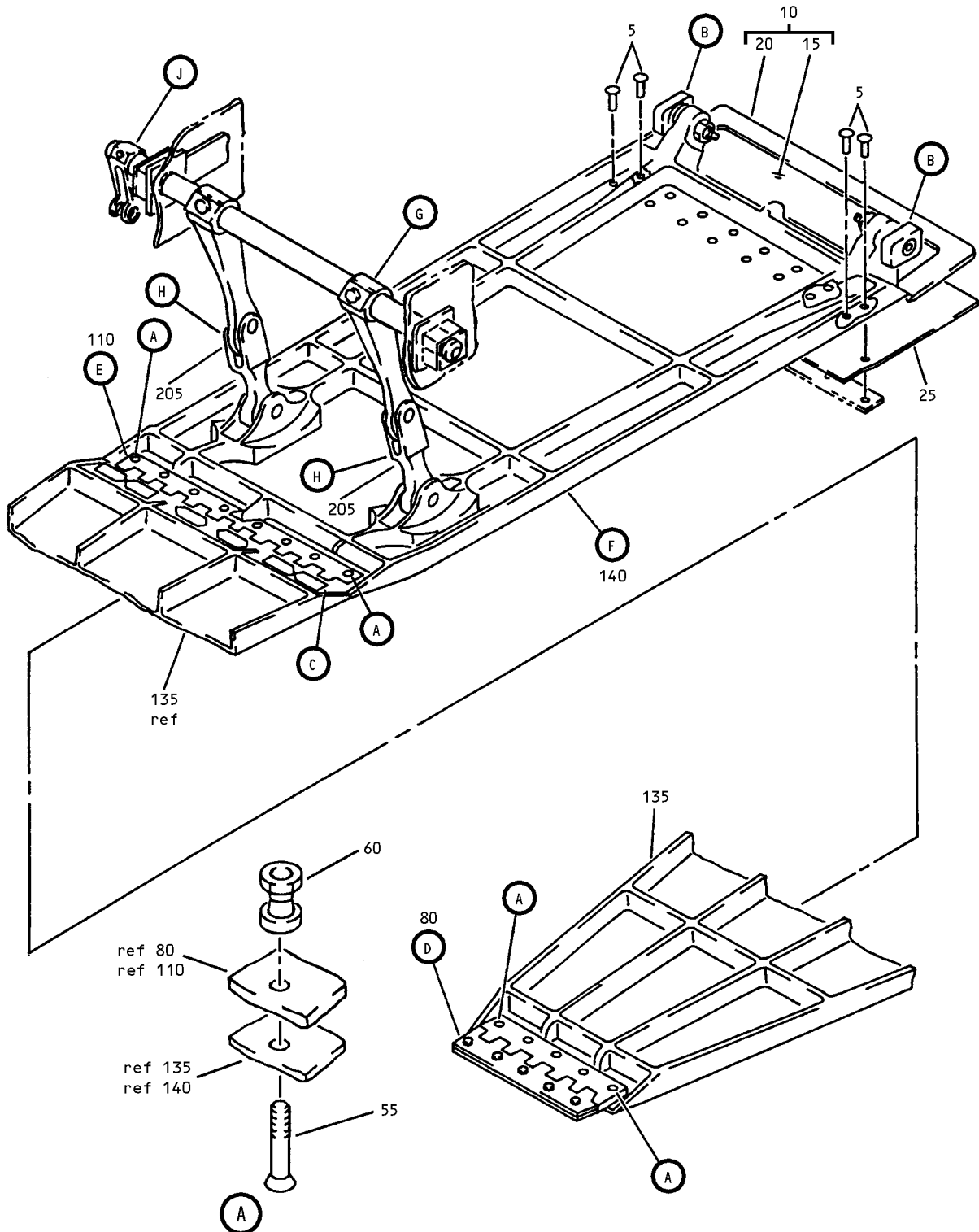
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			1234567		
01-					
450	69B03738-1		DELETED		
455	BACB30LK3-3		DELETED		
460	NAS1149D0363J		DELETED		
465	69B03738-2		DELETED		
470	10-60545-77		DELETED		
-470A	MS14103-14		DELETED		
R			BOEING LETTER HISTORY		

- Item Not Illustrated

- \* (1) SERVICE LETTER 767-SL-21-42-A
- \* (2) SERVICE LETTER 767-SL-21-42-B
- \* (3) SERVICE LETTER 767-SL-21-50
- \* (4) ITEMS 385, 390 AND 410 ARE A MATCHED SET. SEE ABOVE FOR DETAILS OF TORQUE TUBE ASSEMBLY (ITEM 355) BREAKDOWN.

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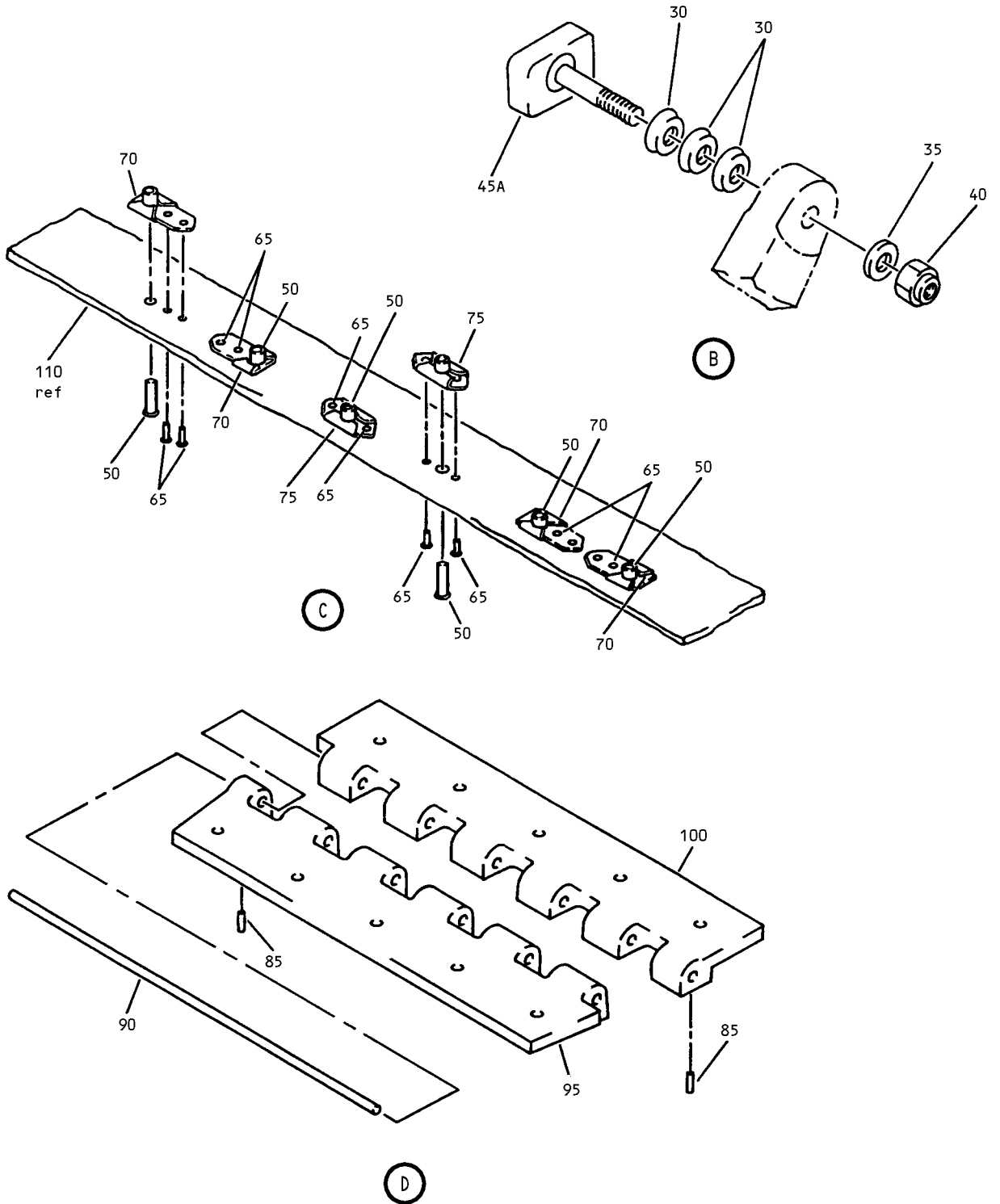
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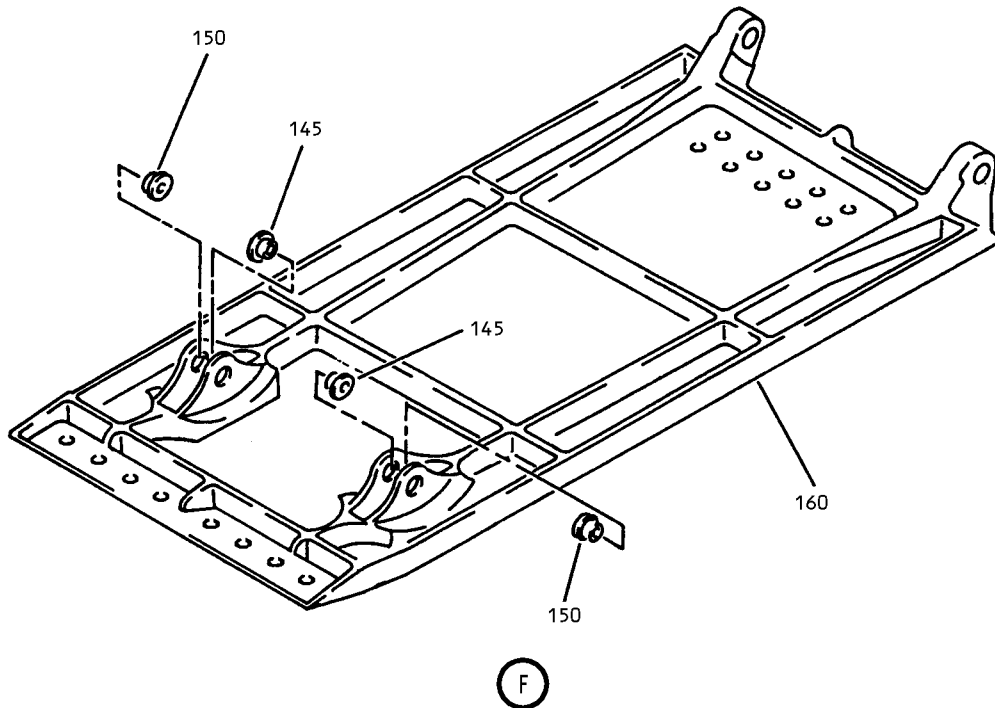
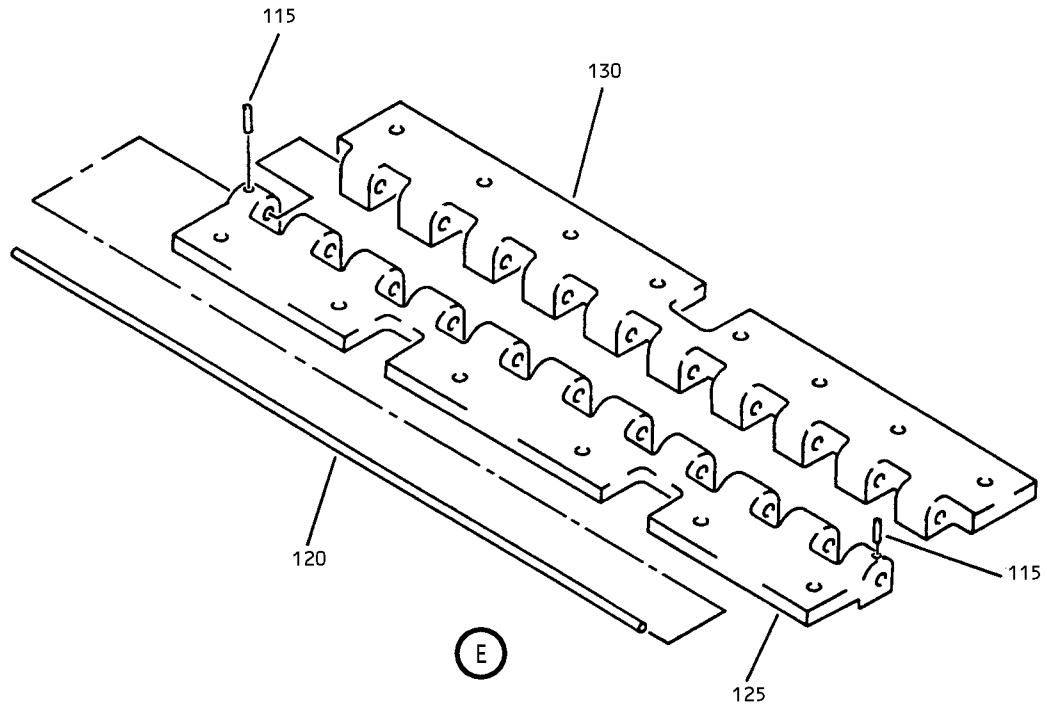
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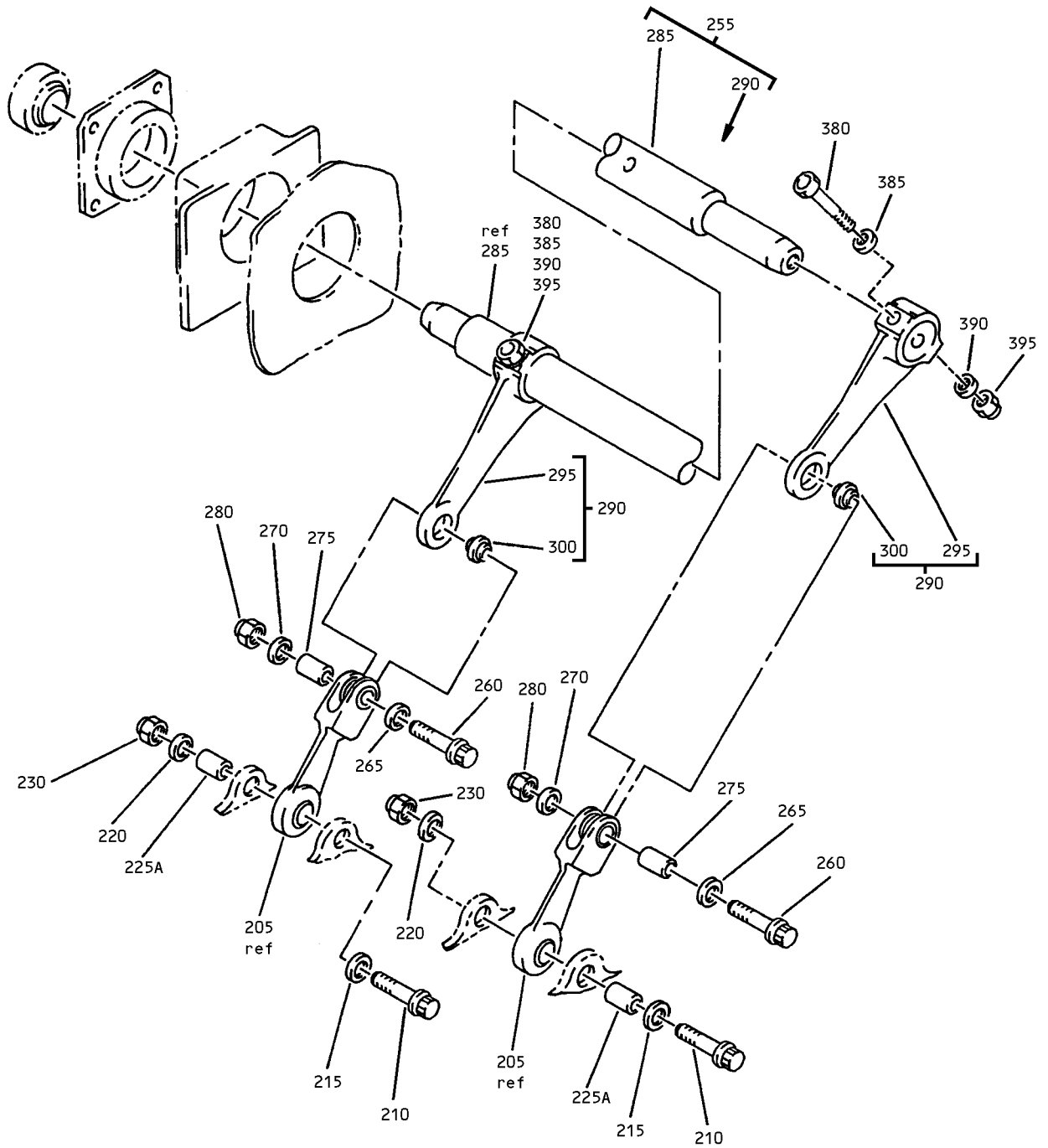


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Figure 2 (Sheet 3)

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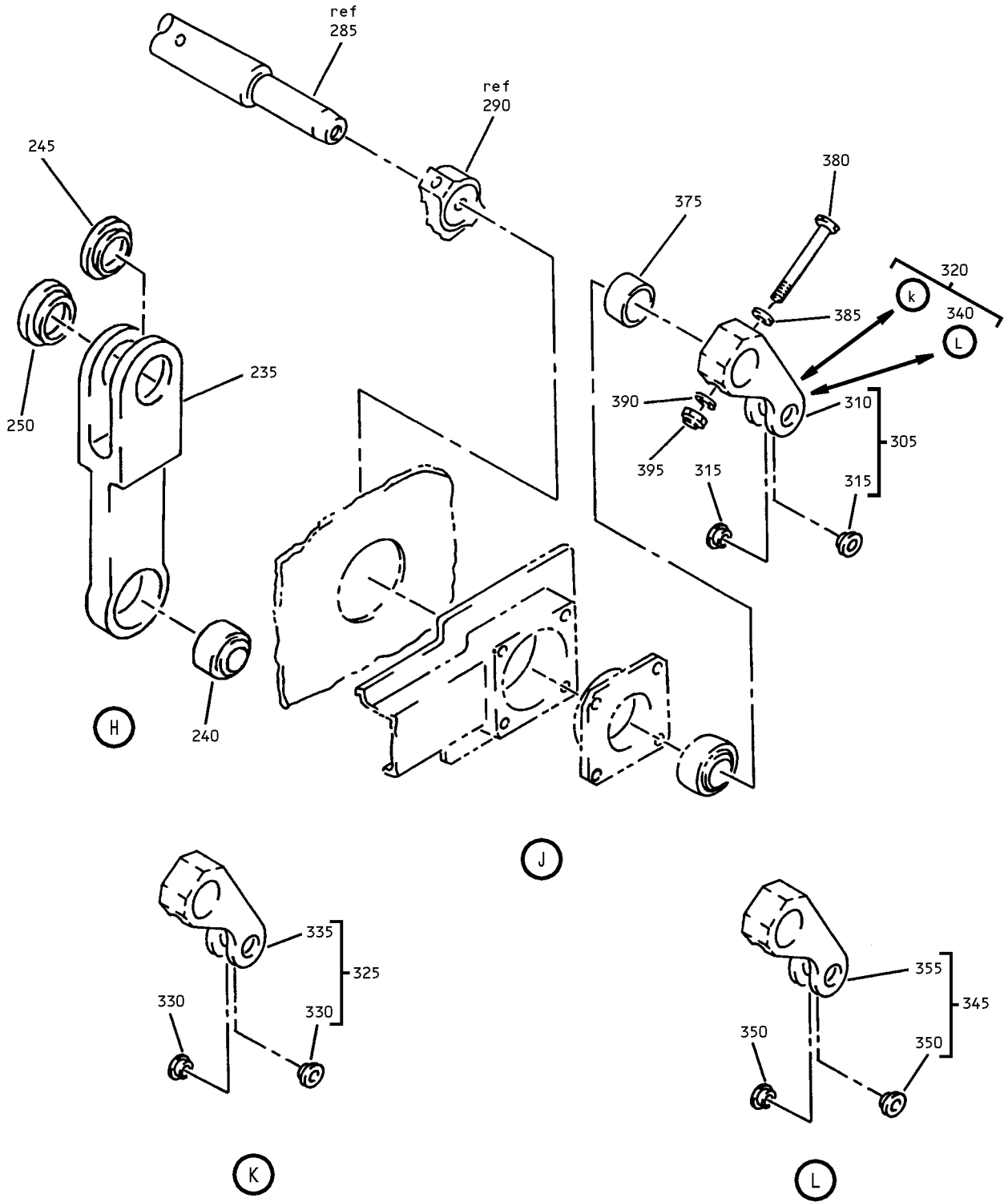




Ram Air Inlet Modulating Door Assembly  
Figure 2 (Sheet 4)

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Ram Air Inlet Modulating Door Assembly  
 Figure 2 (Sheet 5)

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 02- -1	213T3101-5		DOOR ASSY-MODULATING AIR INLET RAM	E	RF
R 5	BACR15BB5AD		.RIVET- (SIZE DETERMINE ON INST)	E	16
R 10	213T3110-1		.SEAL ASSY	E	1
R 15	213T3110-2		..STRIP	E	1
R 20	213T3110-3		..SEAL	E	1
R 25	213T3706-1		.SHIM	E	1
R 30	BACW10AT46AS		.WASHER- (V10630) (SPEC BACW10AT46AS)	E	6
R 35	AN960-616		.WASHER	E	2
R 40	BACN10JC6		.NUT	E	2
R 45	W750221		DELETED		
R 45A	B10478		.BLOCK- (V55231) (SPEC 60B97215-2)	E	2
R 50	BACB30LU3-4		.BOLT	E	6
R 55	HST11AG5-6		.BOLT-*(2) (V06725) (SPEC BACB30VU5K6) (OPT HST11AG5-6 (V73197)) (OPT HST11AG5-6 (VOPTK6)) (OPT HST11AG5-6 (V56878))	E	13
R 60	HST79CY5		.COLLAR- (V73197) (SPEC BACC30BL5) (OPT HST79-5 (V92215)) (OPT HST79CY5 (V56878)) (OPT HST79CY5 (V5M902))	E	13
R 65	BACR15BA3AD		.RIVET- (SIZE DETERMINE ON INST)	E	12

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 02-70	BRF100A3		.NUTPLATE- (V52828) (SPEC BACN10KB3F) (OPT NS103185-02 (V80539)) (OPT RMF9207-3 (V72962)) (OPT T8114S1032S (V11815)) (OPT VN151A1-02 (V92215)) (OPT F2000-3 (V15653))	E	4
R 75	F5000-3BAC		.NUTPLATE- (V15653) (SPEC BACN10JR3F) (OPT NS103203-02 (V80539)) (OPT RMF9201-3 (V72962)) (OPT VN152A1-02 (V92215)) (OPT T8091S1032 (V11815)) (OPT BRF200A3 (V52828))	E	2
R 80	213T3109-4		.HINGE ASSY-FWD (OPT ITEMS 80A, 80B)	E	1
R -80A	213T3109-7		.HINGE ASSY-FWD (OPT ITEMS 80, 80B)	E	1
R -80B	213T3109-16		.HINGE ASSY-FWD (OPT ITEMS 80, 80A)	E	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-					
R 85	MS51923-187		..PIN	E	2
R 90	MS20253P4-540		..PIN	E	1
R 95	213T3109-5		..HINGE HALF- (USED ON ITEM 80)	E	1
R -95A	213T3109-9		..HINGE HALF- (USED ON ITEMS 80A, 80B)	E	1
R 100	213T3109-6		..HINGE HALF- (USED ON ITEM 80)	E	1
R -100A	213T3109-8		..HINGE HALF- (USED ON ITEMS 80A,80B)	E	1
R 110	213T3108-4		.HINGE ASSY-AFT (OPT ITEM 110A)	E	1
R -110A	213T3108-7		.HINGE ASSY-AFT (OPT ITEM 110)	E	1
R 115	MS51923-187		..PIN-SPRING	E	2
R 120	MS20253P4-990		..PIN	E	1
R 125	213T3108-6		..HINGE HALF	E	1
R 130	213T3108-5		..HINGE HALF	E	1
R 135	231T3010-1		.DOOR ASSY-INLET FWD	E	1
R 140	213T3009-4		.DOOR ASSY-INLET AFT	E	1
R 145	BACB28AP05P019		..BUSHING	E	2
R 150	BACB28AT07B019C		..BUSHING	E	2
R 160	213T3009-5		..DOOR-MACHINED	E	1
R			INSTALLATION PARTS	E	
R 205	213T3008-4		LINK ASSY	E	RF
R			ATTACHING PARTS		
R 210	BACB30LESK18		BOLT	E	2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	02-				
R	215	BACW10BP5CD	WASHER	E	2
R	220	BACW10BP5DP	WASHER	E	2
	225	BACB28AK05-026	DELETED		
R	225A	BACB28AK05-037	BUSHING	E	2
R	230	H39953-5	NUT- (V15653) (SPEC BACN10HR5CS) (OPT BMN5024CPD3-5 (V97928)) (OPT 67832AS524 (V56878)) (OPT BMN5024CPD3-5 (V97928)) (OPT BH00303-5 (V27238)) (OPT SL7059C524 (V11815)) (OPT BH003035 (V27238)) (OPT BMN5024CPD35 (V97928)) (OPT CR59085 (V62554))	E	2
			-----*		
R	235	213T3008-5	.LINK	E	1
R	240	WES05B10GC	.BEARING- (V73134) (SPEC BACB10FE05C) (OPT ADW5VNC (V15860)) (OPT KR5CWGBZC (V50632)) (OPT KWDB5-39 (V97613)) (OPT WRRS05B10GC (V73134)) (OPT WHT05VSBC (VS0352))	E	1
R	245	BACB28AP05P012	.BUSHING	E	1
R	250	BACB28AT07B012C	.BUSHING	E	1
R	255	213T3107-3	TORQUE TUBE ASSY-*(3)	E	1
			ATTACHING PARTS		
R	260	BACB30LE5K13	BOLT	E	2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R	02-265	BACN10BP5CD	WASHER	E	2
R	270	BACW10BP5DP	WASHER	E	2
R	275	BACB28AK05-026	BUSHING	E	2
R	280	H39953-5	NUT- (V15653) (SPEC BACN10HR5CS) (OPT BMN5024CPD3-5 (V97928)) (OPT 67832AS524 (V56878)) (OPT BMN5024CPD3-5 (V97928)) (OPT BH00303-5 (V27238)) (OPT SL7059C524 (V11815)) (OPT BH003035 (V27238)) (OPT BMN5024CPD35 (V97928)) (OPT CR59085 (V62554))	E	2
R	285	213T3705-2	-----*----- .TORQUE TUBE-*(4) (OPT ITEMS 285A, 285B)	E	1
R	-285A	213T3705-4	.TORQUE TUBE-*(4) (OPT ITEMS 285, 285B)	E	1
R	-285B	213T3705-5	.TORQUE TUBE-*(4) (OPT ITEMS 285, 285A)	E	1
R	290	213T3011-4	.ACTUATOR LINK ASSY-*(4)	E	2
R	295	213T3011-2	..LINK- (OPT ITEM 295A)	E	1
R	-295A	213T3011-5	..LINK-HOGOUT (OPT ITEM 295)	E	1
R	300	SSMKP5ASD705	..BEARING- (V83086) (SPEC BACB10FS5) (OPT ACMKP5AP510LY19 (V40920)) (OPT PACMKP5AA3908 (V21335))	E	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 02-305	213T3703-11		.CRANK ASSY-*(4) (OPT ITEM 320)	E	1
R 310	213T3703-10		..CRANK	E	1
R 315	BACB28X5C010		..BUSHING	E	2
R 320	213T3703-4		.KIT ASSY-SUBSTITUTE (OPT ITEM 305)	E	1
R 325	213T3703-1		..CRANK ASSY-BELL (MATCHED SET)	E	1
R 330	BACB28A5C010		...BUSHING	E	2
R 335	213T3703-2		...CRANK	E	1
R 340	213T3703-8		..CRANK ASSY-BELL	E	1
R 345	213T3703-14		...KIT ASSY-SUBSTITUTE (OPT ITEM 360)	E	1
R 350	213T3703-7		....BUSHING	E	2
R 355	213T3703-2		....CRANK	E	1
R -360	213T3703-15		...KIT ASSY-SUBSTITUTE (OPT ITEM 345)	E	1
R -365	BACB28A5C010		....BUSHING	E	2
R -370	213T3703-5		....CRANK	E	1
R 375	213T3704-1		.SPACER	E	1
R 380	BACB30NM4K23		.BOLT	E	3
R 385	BACW10CT8CU		.WASHER	E	3
R 390	NAS149C0432R		.WASHER	E	3
R 395	H52732-4CM		.NUT- (V15653) (SPEC BACN10YR4CM) (OPT PLH54CM (V62554))	E	3

- Item Not Illustrated

\*(2) SERVICE LETTER 767-SL-21-42-B

\*(3) SERVICE LETTER 767-SL-21-50

\*(4) ITEMS 285, 290 AND 305 ARE A MATCHED SET. SEE ABOVE FOR DETAILS OF TORQUE TUBE ASSEMBLY (ITEM 355) BREAKDOWN.

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