

 **BOEING**  
COMPONENT  
MAINTENANCE MANUAL

TO: ALL HOLDERS OF DOOR INSTALLATION COMPONENTS – SIDE OF BODY (SOB)  
MAINTENANCE MANUAL 27-51-36

REVISION NO. 5 DATED JUL 01/05

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.

501

DESCRIPTION OF CHANGE

Clarified CHECK Section instructions.

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HIGHLIGHTS

01.1

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DOOR INSTALLATION COMPONENTS -  
SIDE OF BODY (SOB)

PART NUMBERS 113T2029-5,-6  
113T2030-3 THRU -6  
113T1293-5,-7,-9,-10

COMPONENT MAINTENANCE MANUAL  
WITH  
ILLUSTRATED PARTS LIST

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TITLE PAGE

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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 |
|-----------------|---------------|------------|----|-----------------|---------------|------------|----|
|                 |               |            |    |                 |               |            |    |

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113T2030  
113T1293

 **BOEING**  
COMPONENT  
MAINTENANCE MANUAL

TEMPORARY REVISION AND SERVICE BULLETIN RECORD

| BOEING<br>SERVICE<br>BULLETIN | BOEING<br>TEMPORARY<br>REVISION | OTHER<br>DIRECTIVE | DATE OF<br>INCORPORATION<br>INTO MANUAL |
|-------------------------------|---------------------------------|--------------------|-----------------------------------------|
| 767-27-0080R2                 |                                 | PRR B11528         | APR 01/91<br>APR 01/93                  |

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TR & SB RECORD

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\* = REVISED, ADDED OR DELETED

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\*[1] Special instructions not required. Use standard industry practices.

## 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                                      | 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 and a list of applicable standard Boeing practices.

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 parenthesis 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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DOOR ASSEMBLY - SIDE OF BODY (S.O.B.)

DESCRIPTION AND OPERATION

1. Description and Operation

A. The door assembly has three parts: Forward, Mid, and Aft. The fairing are made of fiberglass/kevlar/epoxy composite and have forward and aft hinge fittings. The door assembly is part of the body fairing and provides for smooth airflow around the inboard trailing edge flap, and is not operational by itself.

2. Leading Particulars (approximate)

Length -- 39 inches  
Width -- 8 inches  
Thickness -- 4 inches  
Weight -- 10 pounds

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DESCRIPTION & OPERATION

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CLEANING

CAUTION: DO NOT REMOVE DIRT FROM FIBERGLASS STRUCTURES WITH CLEANING AGENTS SUCH AS METHYLENE CHLORIDE, TRICHLOROETHYLENE AND TRICHLOROETHANE. CHLORONATED CLEANING AGENTS WILL DAMAGE FIBERGLASS STRUCTURES.

1,1,1, - TRICHLOROETHANE IS ONE OF THE SOLVENTS PERMITTED FOR USE WHEN YOU CLEAN COMPOSITE STRUCTURES. DO NOT PUT PARTS INTO THE SOLVENT OR LET THE SOLVENT BE ON THE PARTS FOR A LONG TIME OR DAMAGE MAY OCCUR. USE 1,1,1, TRICHLOROETHANE ONLY TO WIPE THE SURFACE.

1. Remove dirt from all but fiberglass parts by use of Standard Practices (Ref 20-30-03).
  - A. Clean bonded panel assemblies (75, 80, 120, 125, Fig. 1; 115, 120, Fig. 2).
  - B. Clean Teflon-lined and sealed bearings (165, Fig. 1; 135, 200, Fig. 2) per 20-30-01.

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CLEANING  
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CHECK

1. Check all parts for obvious defects using standard industry practices. If you find visible defects or suspect possible defects do a magnetic particle or penetrant check as specified below.
2. Do a penetrant check per 20-20-02 -- Fitting (170, 175, 210, 215, 235, 240, Fig. 1; 150, 155, 160, 165, 170, 175, Fig. 2) and Arm (140, 205, 210, Fig. 2) and Tube (275, Fig. 1; 215, Fig. 2).
3. Do a magnetic particle check per 20-20-01 -- Spring (265, 270, Fig. 1).
4. Do a check of the honeycomb structure:
  - A. Do a check of the honeycomb and the bonded parts for delamination, internal water, scratches, and contour damage.
    - (1) If you see delamination or contour damage, do an ultrasonic check or a tap test to find all of the damage.

NOTE: For a tap test, use a solid metal disk and refer to the 767 Non-Destructive Test Manual, Part 1, 51-05-01.
    - (2) Examine areas that you think contain water radiographically or by thermography as shown in the 767 Non-Destructive Test Manual, Part 9, 51-00-01.
  - B. Refer to 767 Structural Repair Manual Chapter 27 for allowable structural repair data.
5. Check spring (265, 270, Fig. 1) per Fig. 501.

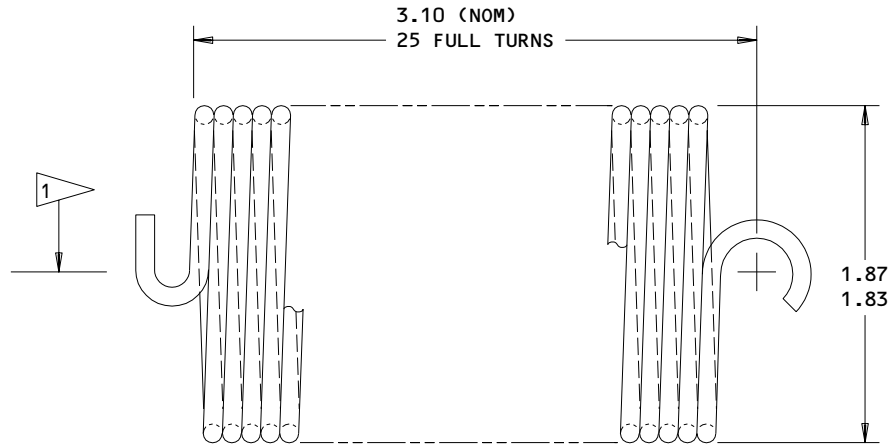
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CHECK


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113T2014-1 SHOWN  
113T2014-2 OPPOSITE

 MOMENT OF 7.2-5.8 INCH-POUNDS AT 360°.

ALL DIMENSIONS ARE IN INCHES

Spring Check  
Figure 501

838603

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CHECK  
01.101 Page 502  
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REPAIR – GENERAL

1. Content

- A. Instructions for repair, refinish, and replacement are divided into procedures as follows:

| <u>P/N</u> | <u>NAME</u>                 | <u>REPAIR</u> |
|------------|-----------------------------|---------------|
| 113T2010   | FITTING ASSY-TUBE END       | 1-1           |
| 113T2012   | ARM ASSY-FWD MAIN DOOR      | 2-1           |
| 113T2013   | ARM ASSY-CRANK MID DOOR AFT | 3-1           |
| 113T2015   | FITTING ASSY-AFT SUPPORT    | 4-1           |
| 113T2016   | LINK ASSY                   | 5-1           |
| 113T1293   | MISC PARTS REFINISH         | 6-1           |

2. Standard Practices

- A. Refer to these Standard Practices for details of the procedures in the repairs:
- B. 20-30-02 Protective Finish Removal  
20-30-03 General Cleaning Procedures  
20-41-01 Boeing Finish Code Explanation  
20-41-02 Chemical and Solvent Resistant Finish Application  
20-43-03 Alodizing  
20-50-03 Bearing Installation and Retention

3. Materials

NOTE: Equivalent alternatives can be used.

- A. Coating, Conductive -- BMS 10-21, type 1 (Ref 20-60-02)
- B. Enamel -- BMS 10-60 color gray gloss (Ref 20-60-02)
- C. Primer -- BMS 10-11, Type 1 (Ref 20-60-02)  
BMS 10-79, Type 2 (Ref 20-60-02)
- D. Sealant -- BMS 5-95 (Ref 20-60-04)

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- E. Surfacer -- Epocast 156 (Ref 20-60-02)  
Dexter 8-W-5 (Ref 20-60-02)
  
- F. Static Conditioner -- Dexter 28-C-1 (Ref 20-60-02)

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FITTING ASSEMBLY-TUBE END - REPAIR 1-1

113T2010-1, -2, -3

NOTE: Refer to REPAIR-GENERAL for applicable Standard Practices. For repair of surfaces which may only require restoration of original finish, refer to Refinish instructions.

1. Bushing Replacement (160, Fig. 1)

- A. Remove bushings.
- B. Install bushings per 20-50-03, but install with BMS 5-95 sealant.
- C. Machine bushing to dimensions shown in Fig. 601.
- D. Fillet seal bushing edges with BMS 5-95 sealant.

2. Bearing Replacement (140, 165, Fig. 1)

- A. Remove bearing.
- B. Install and roller swage bearing in place per 20-50-03.

3. Refinish

- A. Fitting (145, 170, 175, Fig. 1) -- Chromic acid anodize and apply one layer of BMS 10-11, type 1 primer (F-18.13), then apply BMS 10-60, color 707 gray gloss enamel (SRF-14.9813). Do not apply primer or enamel where noted in Fig. 601. Material: Al alloy

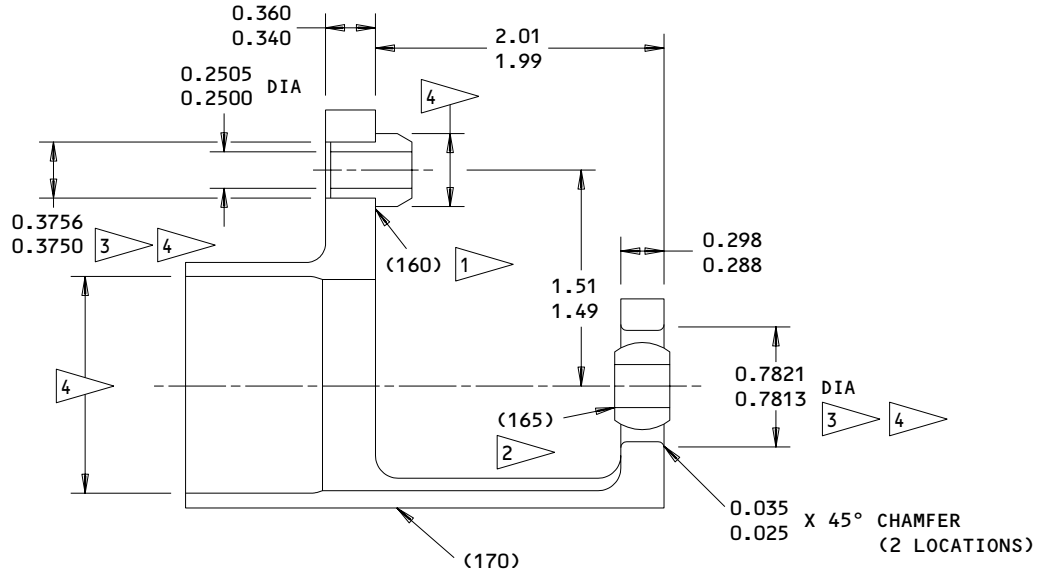
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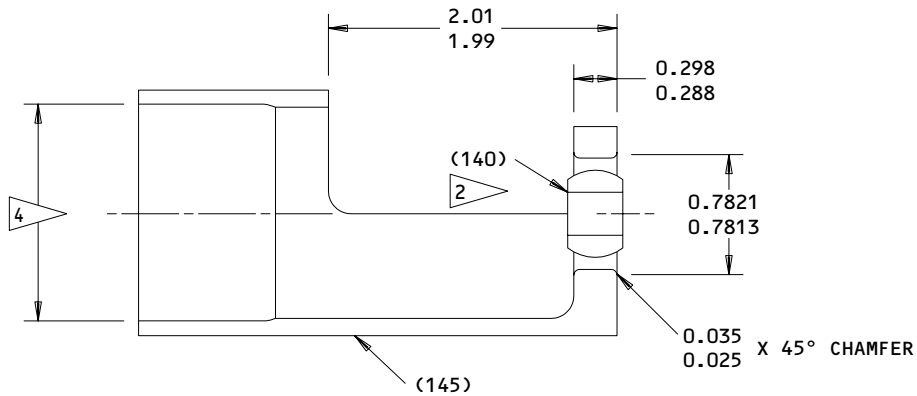
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113T2010-1,-2



113T2010-3

- 1 INSTALL BUSHING USING WET BMS 5-95 SEALANT PER 20-50-03.
- 2 INSTALL BEARING AND ROLLER SWAGE PER 20-50-03.
- 3 DO NOT PRIMER THIS SURFACE.
- 4 DO NOT PAINT THIS SURFACE.

ALL DIMENSIONS ARE IN INCHES  
 ITEM NUMBERS REFER TO IPL FIG. 1

113T2010-1,-2,-3  
 Bushing and Bearing Replacement  
 Figure 601

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ARM ASSEMBLY-FWD - REPAIR 2-1

113T2012-1

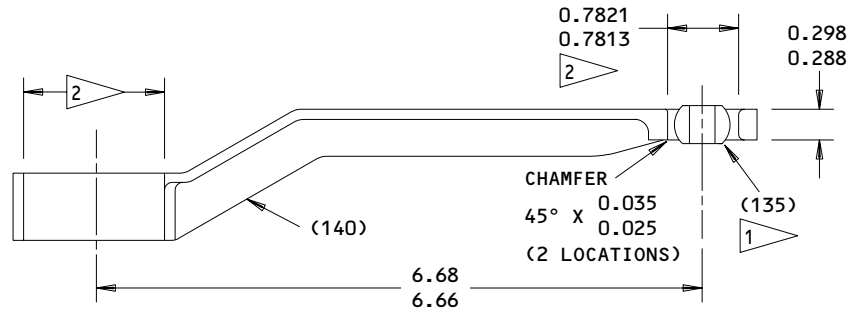
**NOTE:** Refer to REPAIR-GENERAL for applicable Standard Practices. For repair of surfaces which may only require restoration of original finish, refer to Refinish instructions.

1. Bearing Replacement (135, Fig. 2)

- A. Remove bearing.
- B. Install and roller swage bearing in place per 20-50-03.

2. Refinish

- A. Arm (140, Fig. 2) -- Chromic acid anodize and apply one layer of BMS 10-11, type 1 primer (F-18.13), then apply BMS 10-60, color 707 gray gloss enamel (SRF-14.98.13). Do not apply primer or enamel where noted in Fig. 601. Material: Al Alloy



ALL DIMENSIONS ARE IN INCHES  
ITEM NUMBERS REFER TO IPL FIG. 2

- 1 INSTALL BEARING AND ROLLER SWAGE PER 20-50-03.
- 2 DO NOT PRIMER OR PAINT THIS SURFACE.

113T2012-1  
Bearing Replacement  
Figure 601

ARM ASSEMBLY-CRANK MID DOOR AFT - REPAIR 3-1

113T2013-1, -2

NOTE: Refer to REPAIR-GENERAL for applicable Standard Practices. For repair of surfaces which may only require restoration of original finish, refer to Refinish instructions.

1. Bushing Replacement (195A, Fig. 1)

- A. Remove bushings.
- B. Install bushings per 20-50-03, but install with BMS 5-95 sealant.
- C. Machine bushing to dimensions shown in Fig. 601.
- D. Fillet seal bushing edges with BMS 5-95 sealant.

2. Bearing Replacement (200, Fig. 1)

- A. Remove bearing.
- B. Install and roller swage bearing in place per 20-50-03.

3. Refinish

- A. Fitting (205, 210, Fig. 2) -- Chromic acid anodize and apply one layer of BMS 10-11, type 1 primer (F-18.13), then apply BMS 10-60, color 707 gray gloss enamel (SRF-14.9813). Do not apply primer or enamel where noted in Fig. 601. Material: Al alloy

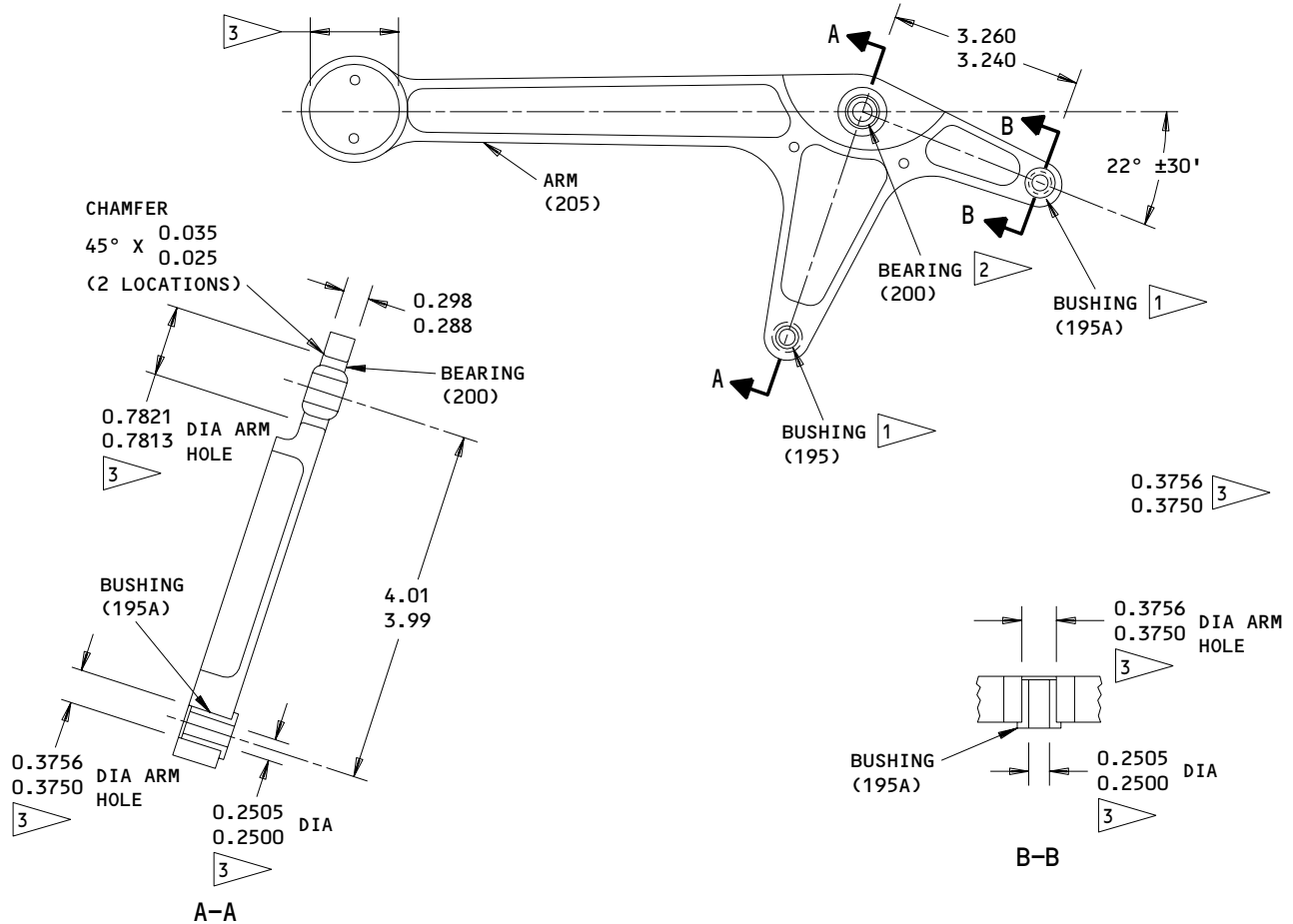
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- 1 INSTALL BUSHING WITH WET BMS 5-95 SEALANT PER 20-50-03.
- 2 INSTALL BEARING AND ROLLER SWAGE PER 20-50-03.
- 3 DO NOT PRIMER OR PAINT THIS SURFACE.

ALL DIMENSIONS ARE IN INCHES  
 ITEM NUMBERS REFER TO IPL FIG. 2

113T2013-1,-2  
 Bushing and Bearing Replacement  
 Figure 601

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FITTING ASSEMBLY-AFT SUPPORT - REPAIR 4-1

113T2015-1, -2

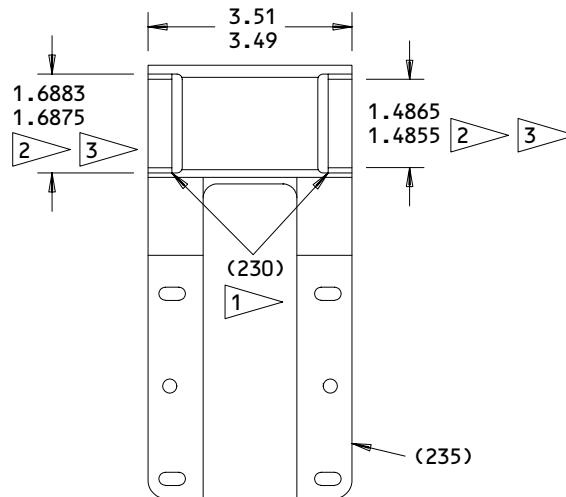
**NOTE:** Refer to REPAIR-GENERAL for applicable Standard Practices. For repair of surfaces which may only require restoration of original finish, refer to Refinish instructions.

1. Bushing Replacement (230, Fig. 1)

- A. Remove bushings.
- B. Install bushings per 20-50-03, but install with BMS 5-95 sealant.
- C. Machine bushing to dimensions shown in Fig. 601.
- D. Fillet seal bushing edges with BMS 5-95 sealant.

2. Refinish

- A. Fitting (235, 240, Fig. 1) -- Chromic acid anodize and apply one layer of BMS 10-11, type 1 primer (F-18.13), then apply BMS 10-60, color 707 gray gloss enamel (SRF-14.9813). Do not apply primer or enamel where noted in Fig. 601. Material: Al alloy



- 1 INSTALL BUSHING USING WET BMS 5-95 SEALANT PER 20-50-03.
- 2 DO NOT PAINT THIS SURFACE.
- 3 DIMENSION TYPICAL BOTH ENDS.

ALL DIMENSIONS ARE IN INCHES  
ITEM NUMBERS REFER TO IPL FIG. 1

113T2015-1,-2  
Bushing Replacement  
Figure 601

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FITTING ASSEMBLY-AFT SUPPORT - REPAIR 5-1

113T2016-1, -2

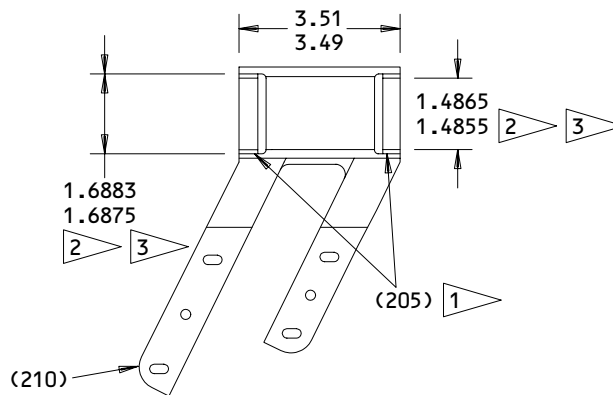
**NOTE:** Refer to REPAIR-GENERAL for applicable Standard Practices. For repair of surfaces which may only require restoration of original finish, refer to Refinish instructions.

1. Bushing Replacement (205, Fig. 1)

- A. Remove bushings.
- B. Install bushings per 20-50-03, but install with BMS 5-95 sealant.
- C. Machine bushing to dimensions shown in Fig. 601.
- D. Fillet seal bushing edges with BMS 5-95 sealant.

2. Refinish

- A. Fitting (210, 215, Fig. 1) -- Chromic acid anodize and apply one layer of BMS 10-11, type 1 primer (F-18.13), then apply BMS 10-60, color 707 gray gloss enamel (SRF-14.9813). Do not apply primer or enamel where noted in Fig. 601. Material: Al alloy



- 1 INSTALL BUSHING USING WET BMS 5-95 SEALANT PER 20-50-03.
- 2 DO NOT PAINT THIS SURFACE.
- 3 DIMENSION TYPICAL BOTH ENDS.

ALL DIMENSIONS ARE IN INCHES  
ITEM NUMBERS REFER TO IPL FIG. 1

113T2016-1,-2  
Bushing Replacement  
Figure 601

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LINK ASSEMBLY – REPAIR 6-1

113T1293-5, -7, -9, -10

**NOTE:** Refer to REPAIR-GENERAL for applicable Standard Practices. For repair of surfaces which may only require restoration of original finish, refer to Refinish instructions.

1. Rod End Replacement (25, 30, Fig. 3)

- A. Remove rod ends.
- B. Install rod ends and adjust as shown in Fig. 601.
- C. Lockwire per 20-50-02.

2. Refinish

- A. Link (35, 40, Fig. 3) -- Chemically treat exterior surfaces and apply one coat of BMS 10-11, type 1 primer per 20-41-02 (F-18.07), then apply BMS 10-60, color 707 gray gloss enamel (SRF-14.9813) to exterior surface only. Apply corrosion preventive compound to interior surfaces only (F-19.09). Material: Al Alloy

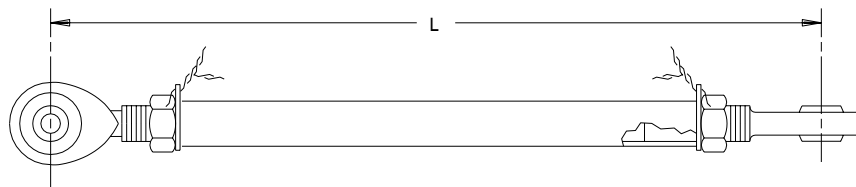
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| ITEM NO. | L<br>ROD LENGTH |       |
|----------|-----------------|-------|
|          | Min             | Max   |
| 1,1B     | 5.91            | 5.93  |
| 1A,5     | 11.69           | 11.71 |

ALL DIMENSIONS ARE IN INCHES  
 ITEM NUMBERS REFER TO IPL FIG. 3

113T1293-5,-7,-9,-10  
 Rod Assembly Adjustment  
 Figure 601

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113T1293



MISCELLANEOUS PARTS REFINISH – REPAIR 7-1

1. Repair of parts listed consists of restoration of original finish.

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| IPL FIG. & ITEM                   | MATERIAL                | FINISH                                                                                                                                                                                                                                                              |
|-----------------------------------|-------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <u>Fig. 1</u>                     |                         |                                                                                                                                                                                                                                                                     |
| Angle (55,60,100,105)             | Al Alloy                | Chromic acid anodize and apply one coat of BMS 10-11, type 1 primer (F-18.13).                                                                                                                                                                                      |
| Bonded Panel Assy (75,80,120,125) | Fiberglass/Kevlar Epoxy | Exterior surfaces and trimmed edges—prepare surface and apply Dexter 28-6-1 static conditioner. Apply Epocast 156 or Dexter 8-W-5 surfacer (SRF-14.672). Apply BMS 10-21, type 1 conductive coating (SRF-14.68). Apply one coat BMS 10-79, type 2 primer (F-19.46). |
| <u>Fig. 2</u>                     |                         |                                                                                                                                                                                                                                                                     |
| Angle (60,,65,70,75,85,90,95,100) | Al Alloy                | Chromic acid anodize and apply one coat of BMS 10-11, type 1 primer (F-18.13).                                                                                                                                                                                      |
| Metal Seal (105,110)              | 17-7 PH, 180-200 KSI    | Cadmium plate, type 2 and apply one coat of BMS 10-11, type 1 primer per 20-41-02 (F-16.01).                                                                                                                                                                        |
| Bonded Panel Assy (115,120)       | Fiberglass/Kevlar Epoxy | Exterior surfaces and trimmed edges—prepare surface and apply Dexter 28-6-1 static conditioner. Apply Epocast 156 or Dexter 8-W-5 surfacer (SRF-14.672). Apply BMS 10-21, type 1 conductive coating (SRF-14.68). Apply one coat BMS 10-79, type 2 primer (F-19.46). |
| Fitting (150,155,160,165,170,175) | Al Alloy                | Chromic acid anodize and apply one coat of BMS 10-11, type 1 primer (F-18.13). Then apply BMS 10-60, color 707 gray gloss enamel (SRF-14.9813). Do not apply primer or enamel in 1.5 inch hole.                                                                     |

Refinish Details  
Figure 601

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ASSEMBLY

1. Assembly (Fig. 1 thru 3)

- A. Use approved usual procedures for assembly of this component.

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ASSEMBLY  
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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.

VENDORS

06710 LAMSON AND SESSIONS CO THE VALLEY-TODECO  
12975 BRADLEY AVENUE  
SYLMAR, CALIFORNIA 91342-3830

06725 AIR INDUSTRIES CORPORATION  
12570 KNOTT STREET  
GARDEN GROVE, CALIFORNIA 92641-3932

06950 SCREWCORP VSI CORP AEROSPACE PRODUCTS DIV FAIRCHILD IND INC  
13001 EAST TEMPLE AVE PO BOX 730  
CITY OF INDUSTRY, CALIFORNIA 91746-1417

08524 DEUTSCH FASTENER CORP SEE CODE V97928

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

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

23294 AVALON MACHINE PRODUCTS INC  
15337 ALLEN STREET  
PARAMOUNT, CALIFORNIA 90723-4011

27624 PAUL R BRILES INC P.B. FASTENER DIV  
1700 WEST 132ND STREET PO BOX 1157  
GARDENA, CALIFORNIA 90249-2008

50294 NEW HAMPSHIRE BALL BEARINGS INC  
9730 INDEPENDENCE AVENUE PO BOX 2515  
CHATSWORTH, CALIFORNIA 91311-4323

50632 KAMATICS CORP SUB OF KAMAN CORP  
1335 BLUE HILLS ROAD  
BLOOMFIELD, CONNECTICUT 06002-1304

56878 SPS TECHNOLOGIES INC AEROSPACE AND INDUSTRIAL PRODUCTS DIV  
HIGHLAND AVENUE  
JENKINTOWN, PENNSYLVANIA 19046

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VENDORS

60516 WEST COAST AEROSPACE INC  
812 MIRAFLORES STREET  
SAN PEDRO, CALIFORNIA 90731-1439

70265 ALL POWER MANUFACTURING COMPANY  
13141 MOLETTE STREET  
SANTA FE SPRINGS, CALIFORNIA 90670-5523

73134 HEIM DIV INCOM INTERNATIONAL INC  
60 ROUND HILL ROAD PO BOX 430  
FAIRFIELD, CONNECTICUT 06430-5114

73197 HI-SHEAR TECHNOLOGY CORP  
2600 SKYPARK DRIVE  
TORRANCE, CALIFORNIA 90509

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

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

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

94892 MASTER MACHINE PRODUCTS CORPORATION  
1551 SOUTH PRIMROSE AVE  
MONROVIA, CALIFORNIA 91016-4542

97613 SARGENT INDUSTRIES KAHR BEARING DIVISION  
3010 NORTH SAN FERNANDO ROAD  
BURBANK, CALIFORNIA 91504-2524

97928 DEUTSCH FASTENER CORP  
3969 PARAMONT BOULEVARD  
LAKEWOOD, CALIFORNIA 90712-4193

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| PART NUMBER     | AIRLINE<br>PART NO. | FIG. | ITEM | TTL<br>REQ |
|-----------------|---------------------|------|------|------------|
| ADB5V301NC      |                     | 1    | 140  | 1          |
|                 |                     | 1    | 165  | 1          |
|                 |                     | 2    | 135  | 1          |
|                 |                     | 2    | 200  | 1          |
| ADNEL4-334W0    |                     | 3    | 25   | 1          |
|                 |                     | 3    | 25A  | 1          |
| AN960JD10L      |                     | 1    | 15   | 8          |
| ARNM4-101KC     |                     | 3    | 30   | 1          |
| ARNM4-101KLC    |                     | 3    | 25   | 1          |
|                 |                     | 3    | 25A  | 1          |
| BACB10FB05GC    |                     | 1    | 140  | 1          |
|                 |                     | 1    | 165  | 1          |
|                 |                     | 2    | 135  | 1          |
|                 |                     | 2    | 200  | 1          |
| BACB28AK04-015  |                     | 1    | 260  | 2          |
| BACB28AK04-030  |                     | 1    | 190  | 4          |
| BACB28AP04P047  |                     | 2    | 195A | 2          |
| BACB30FN5A3     |                     | 2    | 50   |            |
| BACB30FN5A4     |                     | 2    | 50A  | 19         |
| BACB30MY8K27    |                     | 1    | 245  | 2          |
| BACB30MY8K34    |                     | 1    | 180  | 2          |
| BACB30NN3K5     |                     | 1    | 10   | 8          |
| BACC30AG5       |                     | 2    | 55   | 19         |
| BACR15BA6AD     |                     | 2    | 20   | 10         |
| BACR15BB6AD     |                     | 1    | 130  | 8          |
|                 |                     | 2    | 130  | 4          |
|                 |                     | 2    | 190  | 3          |
|                 |                     | 1    | 50   | 4          |
| BACR15CE5B      |                     | 1    | 95   | 4          |
|                 |                     | 2    | 45   | 22         |
|                 |                     | 2    | 30   | 1          |
| BACS40R007B007F |                     | 2    | 25   | 2          |
| BACS40R007B022F |                     | 2    | 35   | 1          |
| BACS40R007B027F |                     | 2    | 40   | 1          |
| BACS40R007B032F |                     | 2    | 30   | 1          |
| BACS40R009B027F |                     | 1    | 30   | 1          |
| BACS40R009B036F |                     | 1    | 25   | 1          |
| BACS40R009B040F |                     | 1    | 35   | 2          |
| BACW10P250S     |                     | 1    | 250  | 2          |
| B30MY8K27       |                     | 1    | 245  | 2          |
| B30MY8K34       |                     | 1    | 180  | 2          |
| HL10VAZ8-27     |                     | 1    | 245  | 2          |
| HL10VAZ8-34     |                     | 1    | 180  | 2          |
| HL82-5APBW      |                     | 2    | 55   | 19         |
| HTFB05VC        |                     | 1    | 140  | 1          |
|                 |                     | 1    | 165  | 1          |
|                 |                     | 2    | 135  | 1          |
|                 |                     | 2    | 200  | 1          |

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| PART NUMBER      | AIRLINE<br>PART NO. | FIG. | ITEM | TTL<br>REQ |
|------------------|---------------------|------|------|------------|
| KNDB5-70         |                     | 1    | 140  | 1          |
|                  |                     | 1    | 165  | 1          |
|                  |                     | 2    | 135  | 1          |
|                  |                     | 2    | 200  | 1          |
|                  |                     | 2    | 200  | 1          |
| KSC145700BZ5GC   |                     | 1    | 140  | 1          |
|                  |                     | 1    | 165  | 1          |
|                  |                     | 2    | 135  | 1          |
|                  |                     | 2    | 200  | 1          |
|                  |                     | 2    | 200  | 1          |
| L8008K27         |                     | 1    | 245  | 2          |
| L8008K34         |                     | 1    | 180  | 2          |
| MS21042L3        |                     | 1    | 20   | 8          |
| MS21042L4        |                     | 1    | 185  | 2          |
|                  |                     | 1    | 255  | 2          |
| NAS1398D6-4      |                     | 2    | 145  | 9          |
| NAS509-6         |                     | 3    | 20   | 1          |
| NAS509L6         |                     | 3    | 15   | 1          |
| NAS513-6         |                     | 3    | 10   | 2          |
| NRRS05FBGC       |                     | 1    | 140  | 1          |
|                  |                     | 1    | 165  | 1          |
|                  |                     | 2    | 135  | 1          |
|                  |                     | 2    | 200  | 1          |
|                  |                     | 2    | 200  | 1          |
| S012T235-104-70  |                     | 3    | 30   | 1          |
| S012T235-104-780 |                     | 3    | 25   | 1          |
|                  |                     | 3    | 25A  | 1          |
|                  |                     | 3    | 25A  | 1          |
| WES05GC          |                     | 1    | 140  | 1          |
|                  |                     | 1    | 165  | 1          |
|                  |                     | 2    | 135  | 1          |
|                  |                     | 2    | 200  | 1          |
|                  |                     | 2    | 200  | 1          |
| 113T1293-5       |                     | 1    | 9    | RF         |
|                  |                     | 3    | 5    | RF         |
| 113T1293-6       |                     | 3    | 40   | 1          |
| 113T1293-7       |                     | 1    | 8    | RF         |
|                  |                     | 3    | 1    | RF         |
| 113T1293-8       |                     | 3    | 35   | 1          |

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| PART NUMBER  | AIRLINE<br>PART NO. | FIG. | ITEM | TTL<br>REQ |
|--------------|---------------------|------|------|------------|
| 113T1293-9   |                     | 1    | 8A   | RF         |
|              |                     | 3    | 1A   | RF         |
| 113T1293-10  |                     | 1    | 9A   | RF         |
|              |                     | 3    | 5A   | RF         |
| 113T1347-108 |                     | 1    | 205  | 2          |
|              |                     | 1    | 230  | 2          |
| 113T1347-109 |                     | 1    | 160  | 1          |
| 113T2010-1   |                     | 1    | 150  | 1          |
| 113T2010-2   |                     | 1    | 155  | 1          |
| 113T2010-3   |                     | 1    | 135  | 1          |
| 113T2010-5   |                     | 1    | 170  | 1          |
| 113T2010-6   |                     | 1    | 175  | 1          |
| 113T2010-7   |                     | 1    | 145  | 1          |
| 113T2012-1   |                     | 2    | 125  | 1          |
| 113T2012-2   |                     | 2    | 140  | 1          |
| 113T2013-1   |                     | 2    | 180  | 1          |
| 113T2013-2   |                     | 2    | 185  | 1          |
| 113T2013-3   |                     | 2    | 205  | 1          |
| 113T2013-4   |                     | 2    | 210  | 1          |
| 113T2014-1   |                     | 1    | 265  | 1          |
| 113T2014-2   |                     | 1    | 270  | 1          |
| 113T2015-1   |                     | 1    | 220  | 1          |
| 113T2015-2   |                     | 1    | 225  | 1          |
| 113T2015-3   |                     | 1    | 235  | 1          |
| 113T2015-4   |                     | 1    | 240  | 1          |
| 113T2016-1   |                     | 1    | 195  | 1          |
| 113T2016-2   |                     | 1    | 200  | 1          |
| 113T2016-3   |                     | 1    | 210  | 1          |
| 113T2016-4   |                     | 1    | 215  | 1          |
| 113T2018-3   |                     | 1    | 275  | 1          |
| 113T2018-4   |                     | 2    | 215  | 1          |
| 113T2019-1   |                     | 2    | 150  | 1          |
| 113T2019-2   |                     | 2    | 155  | 1          |
| 113T2020-1   |                     | 2    | 160  | 1          |
| 113T2020-2   |                     | 2    | 165  | 1          |
| 113T2021-1   |                     | 2    | 170  | 1          |
| 113T2021-2   |                     | 2    | 175  | 1          |
| 113T2022-10  |                     | 2    | 120  | 1          |
| 113T2022-11  |                     | 1    | 120  | 1          |
| 113T2022-12  |                     | 1    | 125  | 1          |
| 113T2022-13  |                     | 2    | 105  | 1          |
| 113T2022-14  |                     | 2    | 110  | 1          |
| 113T2022-15  |                     | 2    | 60   | 1          |
| 113T2022-16  |                     | 2    | 65   | 1          |
| 113T2022-17  |                     | 2    | 70   | 1          |
| 113T2022-18  |                     | 2    | 75   | 1          |
| 113T2022-19  |                     | 1    | 55   | 1          |

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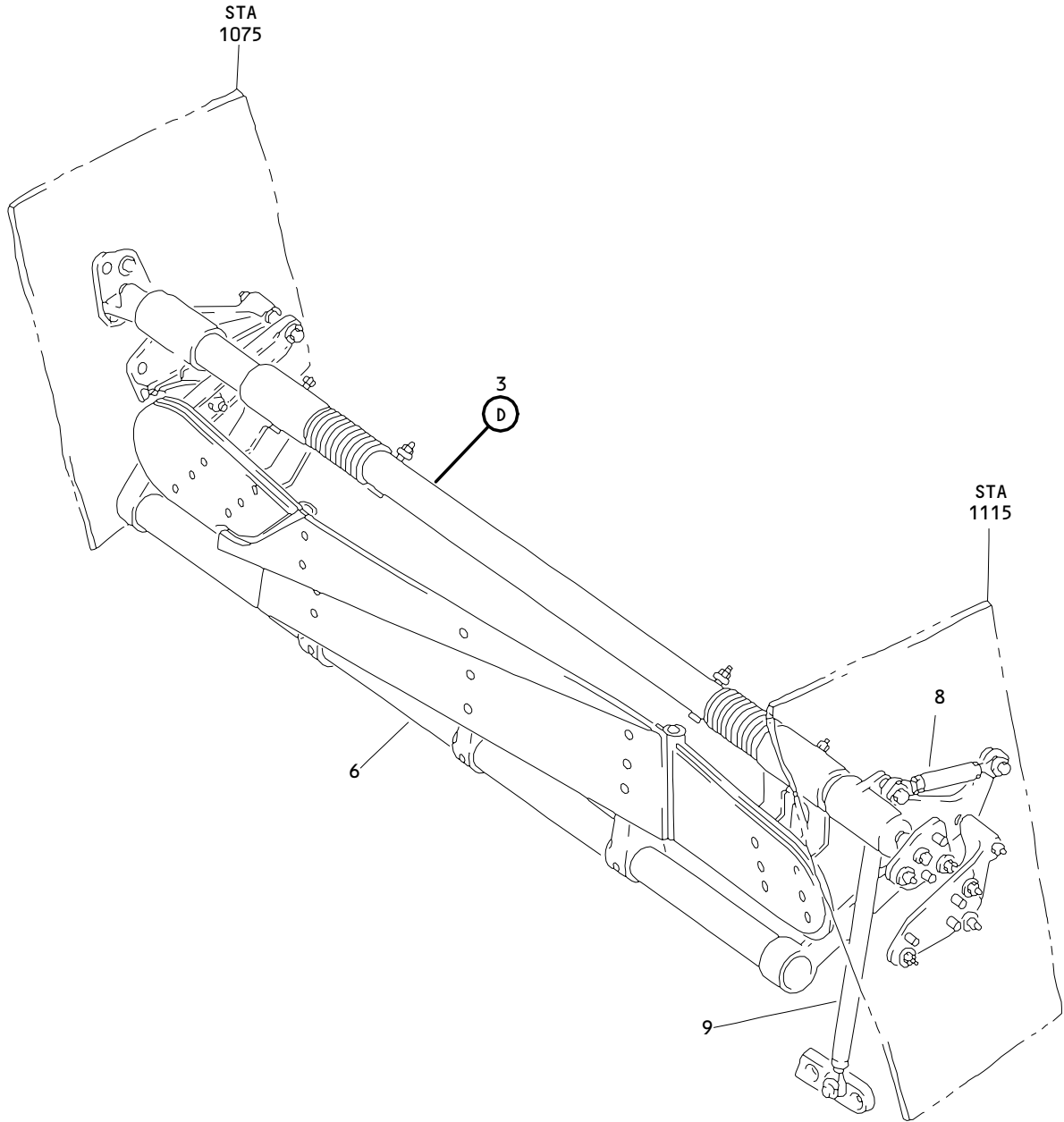
 **BOEING**  
COMPONENT  
MAINTENANCE MANUAL

| PART NUMBER | AIRLINE<br>PART NO. | FIG. | ITEM | TTL<br>REQ |
|-------------|---------------------|------|------|------------|
| 113T2022-20 |                     | 1    | 60   | 1          |
| 113T2022-21 |                     | 1    | 65   | 1          |
| 113T2022-22 |                     | 1    | 70   | 1          |
| 113T2022-23 |                     | 2    | 80   | 1          |
| 113T2022-24 |                     | 2    | 100  | 1          |
| 113T2022-28 |                     | 2    | 90   | 1          |
| 113T2022-29 |                     | 2    | 95   | 1          |
| 113T2022-31 |                     | 1    | 40   | 1          |
| 113T2022-32 |                     | 1    | 45   | 1          |
| 113T2022-33 |                     | 1    | 75   | 1          |
| 113T2022-34 |                     | 1    | 80   | 1          |
| 113T2022-35 |                     | 1    | 85   | 1          |
| 113T2022-36 |                     | 1    | 90   | 1          |
| 113T2022-37 |                     | 1    | 100  | 1          |
| 113T2022-38 |                     | 1    | 105  | 1          |
| 113T2022-39 |                     | 1    | 110  | 1          |
| 113T2022-40 |                     | 1    | 115  | 1          |
| 113T2022-41 |                     | 2    | 10   | 1          |
| 113T2022-42 |                     | 2    | 15   | 1          |
| 113T2022-43 |                     | 2    | 85   | 1          |
| 113T2022-45 |                     | 2    | 10A  | 1          |
| 113T2022-46 |                     | 2    | 15A  | 1          |
| 113T2022-47 |                     | 2    | 105A | 1          |
| 113T2022-48 |                     | 2    | 110A | 1          |
| 113T2022-49 |                     | 2    | 115A | 1          |
| 113T2022-50 |                     | 2    | 120A | 1          |
| 113T2022-9  |                     | 2    | 115  | 1          |
| 113T2029-5  |                     | 1    | 3    | RF         |
| 113T2029-6  |                     | 1    | 5    | RF         |
| 113T2030-3  |                     | 1    | 6    | RF         |
|             |                     | 2    | 1    | RF         |
| 113T2030-4  |                     | 1    | 7    | RF         |
|             |                     | 2    | 5    | RF         |
| 113T2030-5  |                     | 1    | 6A   | RF         |
|             |                     | 2    | 1A   | RF         |
| 113T2030-6  |                     | 1    | 7A   | RF         |
|             |                     | 2    | 5A   | RF         |

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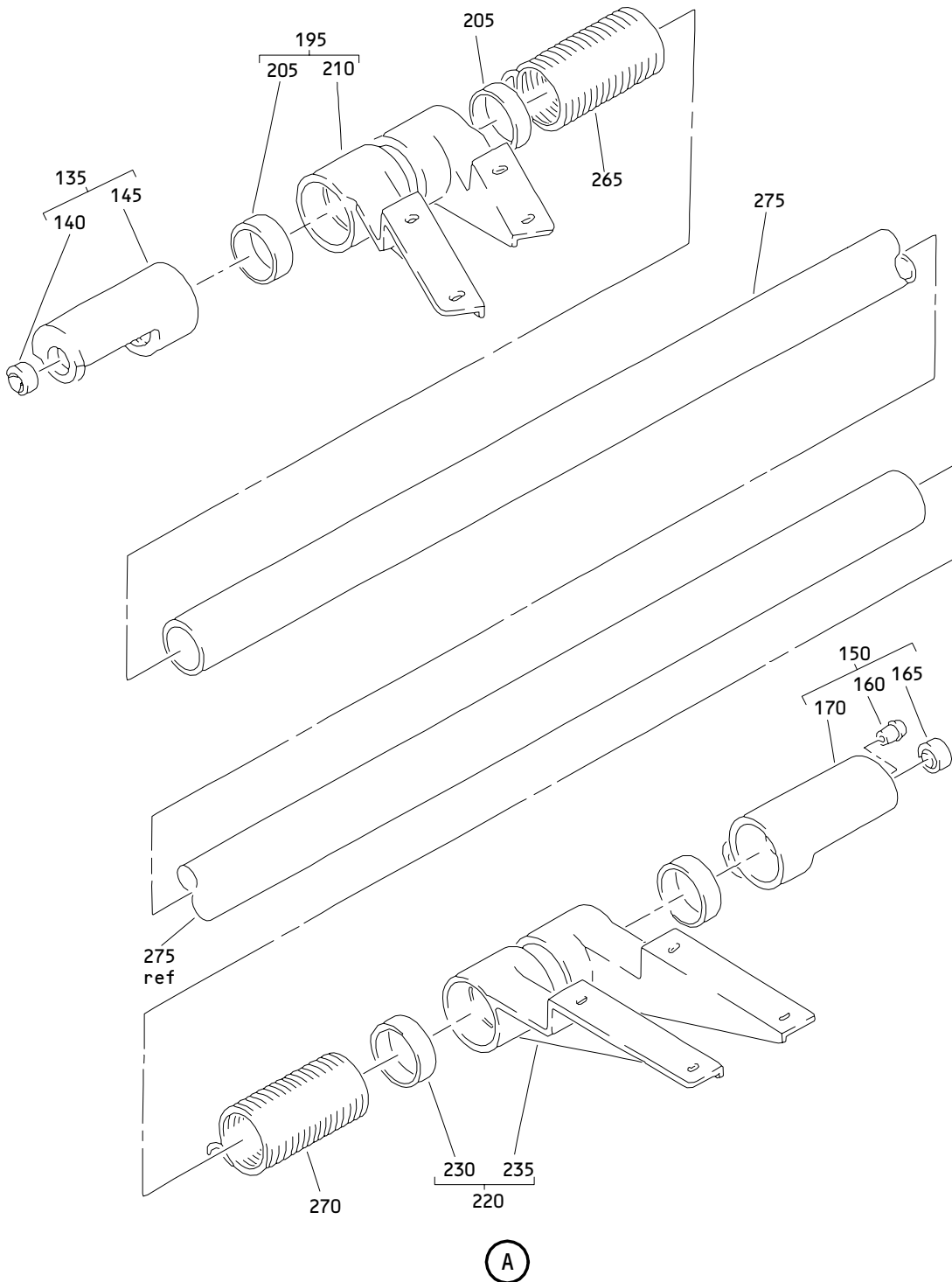


Side of Body Forward and Aft Door Assembly  
Figure 1 (Sheet 1)

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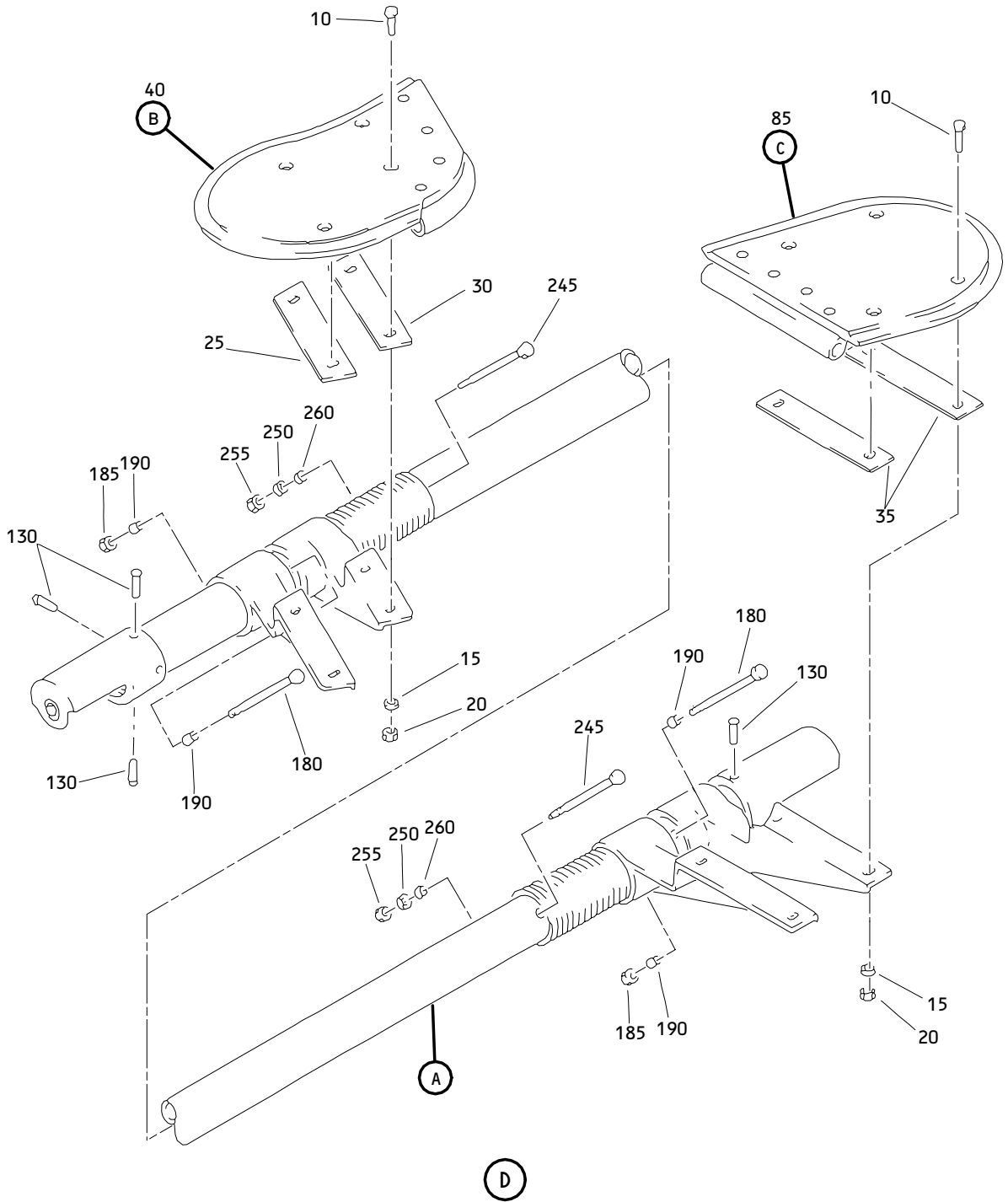
836888



Side of Body Forward and Aft Door Assembly  
 Figure 1 (Sheet 2)

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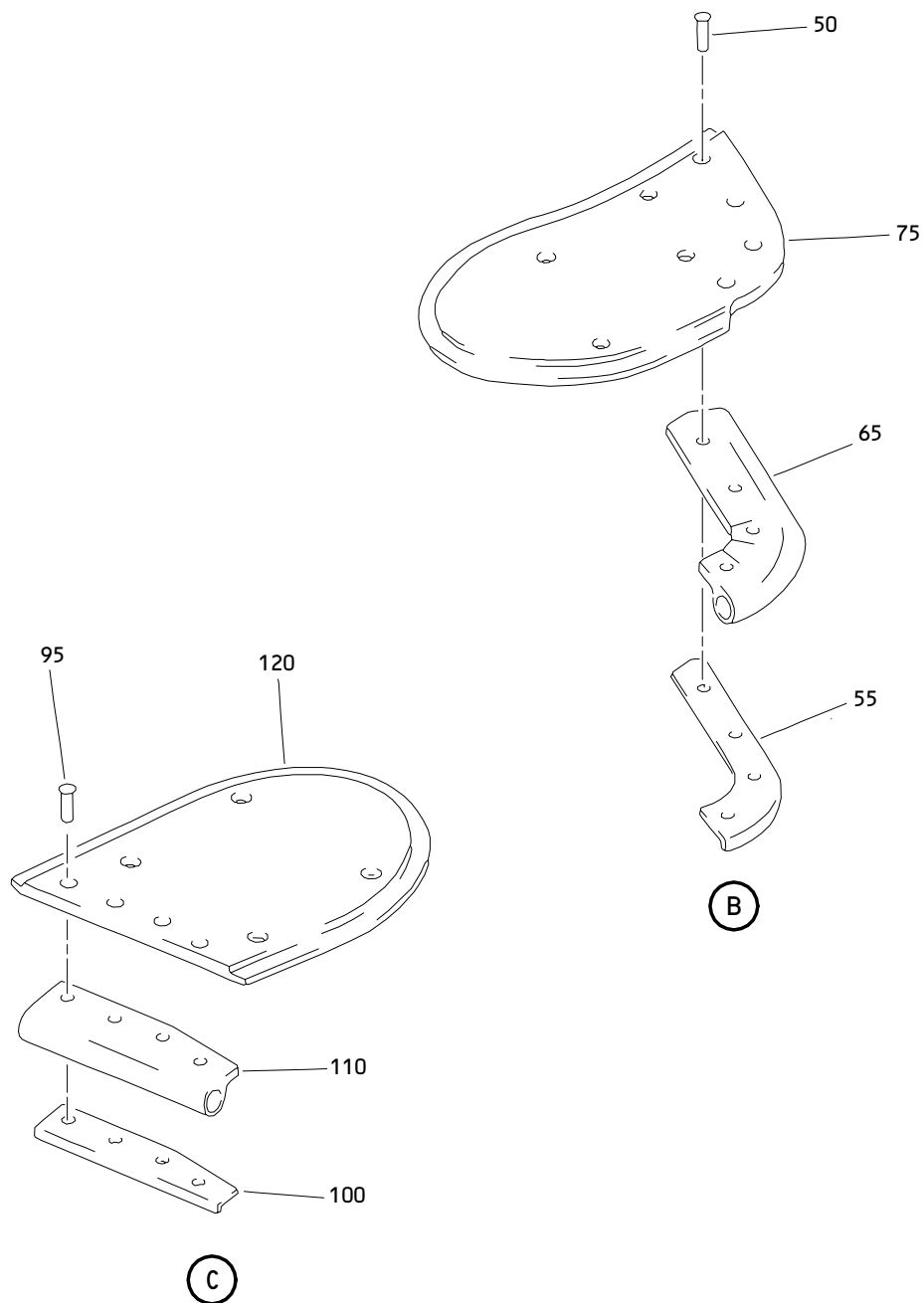
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Side of Body Forward and Aft Door Assembly  
Figure 1 (Sheet 3)

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Side of Body Forward and Aft Door Assembly  
Figure 1 (Sheet 4)

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 **BOEING**  
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| FIG. & ITEM | PART NO.   | AIRLINE PART NUMBER | NOMENCLATURE<br>1234567                                       | EFF CODE | QTY PER ASSY |
|-------------|------------|---------------------|---------------------------------------------------------------|----------|--------------|
| 01-         |            |                     | INSTL COMPONENTS-S.O.B.<br>DOOR                               |          |              |
| 3           | 113T2029-5 |                     | DOOR ASSY-S.O.B. FWD AND<br>AFT (LH) *[1]                     | A        | RF           |
| -5          | 113T2029-6 |                     | DOOR ASSY-S.O.B. FWD AND<br>AFT (RH)                          | B        | RF           |
| 6           | 113T2030-3 |                     | DOOR ASSY-S.O.B. MID (LH)<br>(FOR DETAILS SEE FIG. 2)         | C        | RF           |
| -6A         | 113T2030-5 |                     | DOOR ASSY-S.O.B. MID (LH)<br>(FOR DETAILS SEE FIG. 2)<br>*[1] | G        | RF           |
| -7          | 113T2030-4 |                     | DOOR ASSY-S.O.B. MID (RH)<br>(FOR DETAILS SEE FIG. 2)         | D        | RF           |
| -7A         | 113T2030-6 |                     | DOOR ASSY-S.O.B. MID (RH)<br>(FOR DETAILS SEE FIG. 2)         | H        | RF           |
| 8           | 113T1293-7 |                     | LINK ASSY-<br>(FOR DETAILS SEE FIG. 3)                        | E        | RF           |
| -8A         | 113T1293-9 |                     | LINK ASSY-<br>(FOR DETAILS SEE FIG. 3)                        | I        | RF           |

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| FIG. & ITEM | PART NO.        | AIRLINE PART NUMBER | NOMENCLATURE<br>1234567                                                                                                                                                                                                                                                                                                                                                            | EFF CODE | QTY PER ASSY |
|-------------|-----------------|---------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------|--------------|
| 01-9        | 113T1293-5      |                     | LINK ASSY-<br>(FOR DETAILS SEE FIG. 3)                                                                                                                                                                                                                                                                                                                                             | F        | RF           |
| -9A         | 113T1293-10     |                     | LINK ASSY-<br>(FOR DETAILS SEE FIG. 3)                                                                                                                                                                                                                                                                                                                                             | J        | RF           |
| 10          | BACB30NN3K5     |                     | .BOLT-<br>(V06710)<br>(SPEC BACB30NN3K5)<br>(OPT BACB30NN3K5<br>(V06725))<br>(OPT BACB30NN3K5<br>(V06950))<br>(OPT BACB30NN3K5<br>(V08524))<br>(OPT BACB30NN3K5<br>(V27624))<br>(OPT BACB30NN3K5<br>(V56878))<br>(OPT BACB30NN3K5<br>(V73197))<br>(OPT BACB30NN3K5<br>(V80539))<br>(OPT BACB30NN3K5<br>(V92215))<br>(OPT BACB30NN3K5<br>(V93907))<br>(OPT BACB30NN3K5<br>(V97928)) |          | 8            |
| 15          | AN960JD10L      |                     | .WASHER                                                                                                                                                                                                                                                                                                                                                                            |          | 8            |
| 20          | MS21042L3       |                     | .NUT                                                                                                                                                                                                                                                                                                                                                                               |          | 8            |
| 25          | BACS40R009B036F |                     | .SHIM                                                                                                                                                                                                                                                                                                                                                                              |          | 1            |
| 30          | BACS40R009B027F |                     | .SHIM                                                                                                                                                                                                                                                                                                                                                                              |          | 1            |
| 35          | BACS40R009B040F |                     | .SHIM                                                                                                                                                                                                                                                                                                                                                                              |          | 2            |
| 40          | 113T2022-31     |                     | .DOOR ASSY                                                                                                                                                                                                                                                                                                                                                                         | A        | 1            |
| -45         | 113T2022-32     |                     | .DOOR ASSY                                                                                                                                                                                                                                                                                                                                                                         | B        | 1            |
| 50          | BACR15CE5B      |                     | ..RIVET-<br>(SIZE DETERMINE ON INST)                                                                                                                                                                                                                                                                                                                                               |          | 4            |
| 55          | 113T2022-19     |                     | ..ANGLE                                                                                                                                                                                                                                                                                                                                                                            | A        | 1            |
| -60         | 113T2022-20     |                     | ..ANGLE                                                                                                                                                                                                                                                                                                                                                                            | B        | 1            |
| 65          | 113T2022-21     |                     | ..SEAL-<br>(MFD FROM 10-60754-36<br>4.10 IN. LONG)                                                                                                                                                                                                                                                                                                                                 | A        | 1            |

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| FIG. & ITEM | PART NO.    | AIRLINE PART NUMBER | NOMENCLATURE<br>1234567                                                                                                                                                                                    | EFF CODE | QTY PER ASSY |
|-------------|-------------|---------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------|--------------|
| 01-<br>-70  | 113T2022-22 |                     | ..SEAL-<br>(MFD FROM 10-60754-36<br>4.10 IN. LONG)                                                                                                                                                         | B        | 1            |
| 75          | 113T2022-33 |                     | ..PANEL ASSY-BONDED                                                                                                                                                                                        | A        | 1            |
| -80         | 113T2022-34 |                     | ..PANEL ASSY-BONDED                                                                                                                                                                                        | B        | 1            |
| 85          | 113T2022-35 |                     | .DOOR ASSY                                                                                                                                                                                                 | A        | 1            |
| -90         | 113T2022-36 |                     | .DOOR ASSY                                                                                                                                                                                                 | B        | 1            |
| 95          | BACR15CE5B  |                     | ..RIVET-<br>(SIZE DETERMINE ON INST)                                                                                                                                                                       |          | 4            |
| 100         | 113T2022-37 |                     | ..ANGLE                                                                                                                                                                                                    | A        | 1            |
| -105        | 113T2022-38 |                     | ..ANGLE                                                                                                                                                                                                    | B        | 1            |
| 110         | 113T2022-39 |                     | ..SEAL-<br>(MFD FROM 10-60754-36<br>4.10 IN. LONG)                                                                                                                                                         | A        | 1            |
| -115        | 113T2022-40 |                     | ..SEAL-<br>(MFD FROM 10-60754-36<br>4.10 IN. LONG)                                                                                                                                                         | B        | 1            |
| 120         | 113T2022-11 |                     | ..PANEL ASSY-BONDED                                                                                                                                                                                        | A        | 1            |
| -125        | 113T2022-12 |                     | ..PANEL ASSY-BONDED                                                                                                                                                                                        | B        | 1            |
| 130         | BACR15BB6AD |                     | .RIVET-<br>(SIZE DETERMINE ON INST)                                                                                                                                                                        |          | 8            |
| 135         | 113T2010-3  |                     | .FITTING ASSY                                                                                                                                                                                              |          | 1            |
| 140         | ADB5V301NC  |                     | ..BEARING-<br>(V15860)<br>(SPEC BACB10FB05GC)<br>(OPT HTFB05VC<br>(V50294))<br>(OPT KNDB5-70<br>(V97613))<br>(OPT KSC145700BZ5GC<br>(V50632))<br>(OPT NRRS05FBGC<br>(V73134))<br>(OPT WES05GC<br>(V73134)) |          | 1            |
| 145         | 113T2010-7  |                     | ..FITTING                                                                                                                                                                                                  |          | 1            |
| 150         | 113T2010-1  |                     | .FITTING ASSY                                                                                                                                                                                              | A        | 1            |
| -155        | 113T2010-2  |                     | .FITTING ASSY                                                                                                                                                                                              | B        | 1            |

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| FIG. & ITEM | PART NO.       | AIRLINE PART NUMBER | NOMENCLATURE<br>1234567                                                                                                                                                                                    | EFF CODE | QTY PER ASSY |
|-------------|----------------|---------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------|--------------|
| 01-160      | 113T1347-109   |                     | ..BUSHING                                                                                                                                                                                                  |          | 1            |
| 165         | ADB5V301NC     |                     | ..BEARING-<br>(V15860)<br>(SPEC BACB10FB05GC)<br>(OPT HTFB05VC<br>(V50294))<br>(OPT KNDB5-70<br>(V97613))<br>(OPT KSC145700BZ5GC<br>(V50632))<br>(OPT NRRS05FBGC<br>(V73134))<br>(OPT WES05GC<br>(V73134)) |          | 1            |
| 170         | 113T2010-5     |                     | ..FITTING                                                                                                                                                                                                  | A        | 1            |
| -175        | 113T2010-6     |                     | ..FITTING                                                                                                                                                                                                  | B        | 1            |
| 180         | HL10VAZ8-34    |                     | .BOLT-<br>(V56878)<br>(SPEC BACB30MY8K34)<br>(OPT HL10VAZ8-34<br>(V73197))<br>(OPT HL10VAZ8-34<br>(V92215))<br>(OPT HL10VAZ8-34<br>(V08524))<br>(OPT L8008K34<br>(V06725))<br>(OPT B30MY8K34<br>(V08524))  |          | 2            |
| 185         | MS21042L4      |                     | .NUT                                                                                                                                                                                                       |          | 2            |
| 190         | BACB28AK04-030 |                     | .BUSHING-<br>(V23294)<br>(SPEC BACB28AK04-030)<br>(OPT BACB28AK04-030<br>(V70265))<br>(OPT BACB28AK04-030<br>(V94892))                                                                                     |          | 4            |
| 195         | 113T2016-1     |                     | .FITTING ASSY-SUPPORT                                                                                                                                                                                      | A        | 1            |
| -200        | 113T2016-2     |                     | .FITTING ASSY-SUPPORT                                                                                                                                                                                      | B        | 1            |
| 205         | 113T1347-108   |                     | ..BUSHING                                                                                                                                                                                                  |          | 2            |
| 210         | 113T2016-3     |                     | ..FITTING                                                                                                                                                                                                  | A        | 1            |
| -215        | 113T2016-4     |                     | ..FITTING                                                                                                                                                                                                  | B        | 1            |
| 220         | 113T2015-1     |                     | .FITTING ASSY-SUPPORT                                                                                                                                                                                      | A        | 1            |
| -225        | 113T2015-2     |                     | .FITTING ASSY-SUPPORT                                                                                                                                                                                      | B        | 1            |
| 230         | 113T1347-108   |                     | ..BUSHING                                                                                                                                                                                                  |          | 2            |

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113T2029  
113T2030  
113T1293

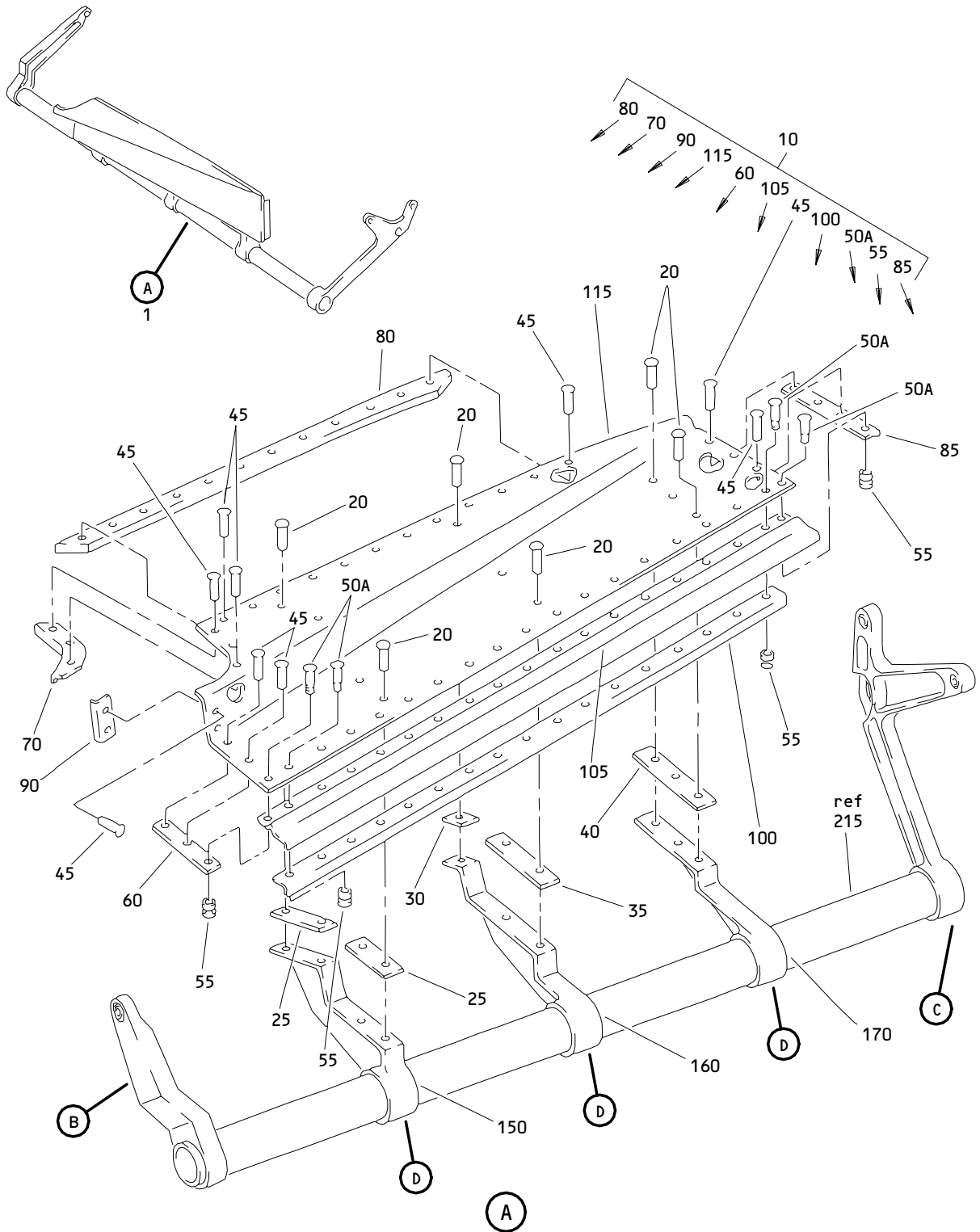
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| FIG. & ITEM | PART NO.       | AIRLINE PART NUMBER | NOMENCLATURE<br>1234567                                                                                                                                                                                   | EFF CODE | QTY PER ASSY |
|-------------|----------------|---------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------|--------------|
| 01-         |                |                     |                                                                                                                                                                                                           |          |              |
| 235         | 113T2015-3     |                     | ..FITTING                                                                                                                                                                                                 | A        | 1            |
| -240        | 113T2015-4     |                     | ..FITTING                                                                                                                                                                                                 | B        | 1            |
| 245         | HL10VAZ8-27    |                     | .BOLT-<br>(V56878)<br>(SPEC BACB30MY8K27)<br>(OPT HL10VAZ8-27<br>(V73197))<br>(OPT HL10VAZ8-27<br>(V92215))<br>(OPT HL10VAZ8-27<br>(V08524))<br>(OPT L8008K27<br>(V06725))<br>(OPT B30MY8K27<br>(V08524)) |          | 2            |
| 250         | BACW10P250S    |                     | .WASHER-<br>(V10630)<br>(SPEC BACW10P250S)                                                                                                                                                                |          | 2            |
| 255         | MS21042L4      |                     | .NUT                                                                                                                                                                                                      |          | 2            |
| 260         | BACB28AK04-015 |                     | .BUSHING-<br>(V23294)<br>(SPEC BACB28AK04-015)<br>(OPT BACB28AK04-015<br>(V70265))<br>(OPT BACB28AK04-015<br>(V94892))                                                                                    |          | 2            |
| 265         | 113T2014-1     |                     | .SPRING                                                                                                                                                                                                   |          | 1            |
| 270         | 113T2014-2     |                     | .SPRING                                                                                                                                                                                                   |          | 1            |
| 275         | 113T2018-3     |                     | .TUBE-DRIVE                                                                                                                                                                                               |          | 1            |

\*[1] POST SB 767-27-0080R3 FOR (PRE SB PARTS CONTAINED IN CMM 27-51-89)

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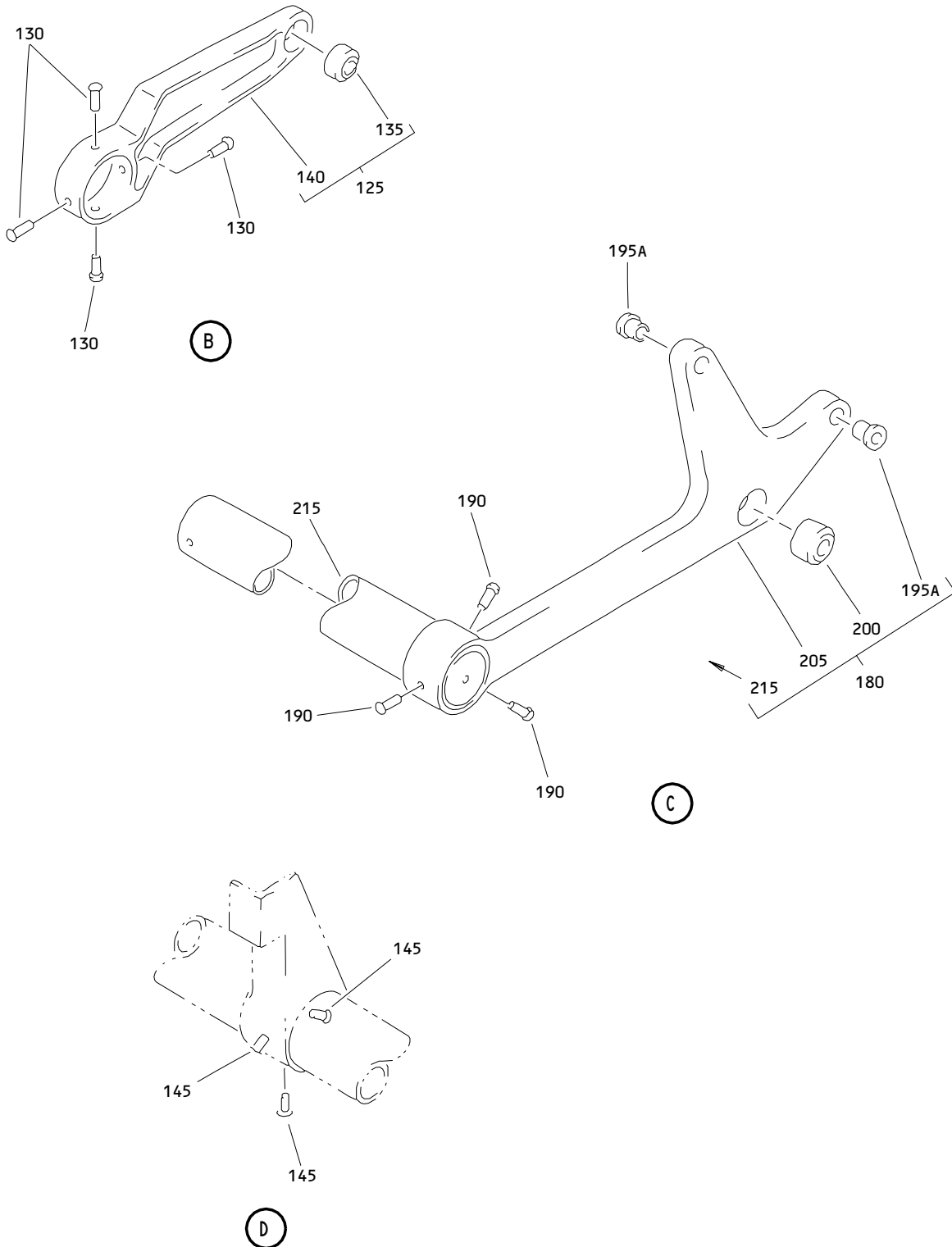
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Side of Body Mid Door Assembly  
Figure 2 (Sheet 1)

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Side of Body Mid Door Assembly  
 Figure 2 (Sheet 2)

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113T2030  
113T1293

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| FIG. & ITEM | PART NO.        | AIRLINE PART NUMBER | NOMENCLATURE<br>1234567           | EFF CODE | QTY PER ASSY |
|-------------|-----------------|---------------------|-----------------------------------|----------|--------------|
| 02-1        | 113T2030-3      |                     | DOOR ASSY-S.O.B. MID (LH)         | C        | RF           |
| -1A         | 113T2030-5      |                     | DOOR ASSY-S.O.B. MID (LH)<br>*[1] | G        | RF           |
| -5          | 113T2030-4      |                     | DOOR ASSY-S.O.B. MID (RH)         | D        | RF           |
| -5A         | 113T2030-6      |                     | DOOR ASSY-S.O.B. MID (RH)         | H        | RF           |
| 10          | 113T2022-41     |                     | .DOOR ASSY                        | C        | 1            |
| -10A        | 113T2022-45     |                     | .DOOR ASSY                        | G        | 1            |
| -15         | 113T2022-42     |                     | .DOOR ASSY                        | D        | 1            |
| -15A        | 113T2022-46     |                     | .DOOR ASSY                        | H        | 1            |
| 20          | BACR15BA6AD     |                     | ATTACHING PARTS<br>.RIVET-        | C,D,     | 10           |
|             |                 |                     | (SIZE DETERMINE ON INST)          | G,H      |              |
| 25          | BACS40R007B022F |                     | .SHIM                             | C,D,     | 2            |
|             |                 |                     |                                   | G,H      |              |
| 30          | BACS40R007B007F |                     | .SHIM                             | C,D,     | 1            |
|             |                 |                     |                                   | G,H      |              |
| 35          | BACS40R007B027F |                     | .SHIM                             | C,D,     | 1            |
|             |                 |                     |                                   | G,H      |              |
| 40          | BACS40R007B032F |                     | .SHIM                             | C,D,     | 1            |
|             |                 |                     |                                   | G,H      |              |
| 45          | BACR15CE5B      |                     | -----*-----<br>..RIVET-           | C,D,     | 22           |
|             |                 |                     | (SIZE DETERMINE ON INST)          | G,H      |              |
| 50          | BACB30FN5A3     |                     | DELETED                           |          |              |
| 50A         | BACB30FN5A4     |                     | ..BOLT                            | C,D,     | 19           |
|             |                 |                     |                                   | G,H      |              |
| 55          | HL82-5APBW      |                     | ..COLLAR-                         | C,D,     | 19           |
|             |                 |                     | (V73197)                          | G,H      |              |
|             |                 |                     | (SPEC BACC30AG5)                  |          |              |
|             |                 |                     | (OPT HL82-5APBW                   |          |              |
|             |                 |                     | (V56878))                         |          |              |

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| FIG. & ITEM | PART NO.    | AIRLINE PART NUMBER | NOMENCLATURE<br>1234567                                                                                                                                                                                    | EFF CODE    | QTY PER ASSY |
|-------------|-------------|---------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------|--------------|
| 02-60       | 113T2022-15 |                     | ..ANGLE                                                                                                                                                                                                    | C,G         | 1            |
| -65         | 113T2022-16 |                     | ..ANGLE                                                                                                                                                                                                    | D,H         | 1            |
| 70          | 113T2022-17 |                     | ..ANGLE                                                                                                                                                                                                    | C,G         | 1            |
| -75         | 113T2022-18 |                     | ..ANGLE                                                                                                                                                                                                    | D,H         | 1            |
| 80          | 113T2022-23 |                     | ..STIFFENER                                                                                                                                                                                                | C,D,<br>G,H | 1            |
| 85          | 113T2022-43 |                     | ..ANGLE                                                                                                                                                                                                    | C,D<br>G,H  | 1            |
| 90          | 113T2022-28 |                     | ..ANGLE                                                                                                                                                                                                    | C,G         | 1            |
| -95         | 113T2022-29 |                     | ..ANGLE                                                                                                                                                                                                    | D,H         | 1            |
| 100         | 113T2022-24 |                     | ..ANGLE                                                                                                                                                                                                    | C,D<br>G,H  | 1            |
| 105         | 113T2022-13 |                     | ..SEAL-METAL                                                                                                                                                                                               | C           | 1            |
| -105A       | 113T2022-47 |                     | ..SEAL-METAL                                                                                                                                                                                               | G           | 1            |
| -110        | 113T2022-14 |                     | ..SEAL-METAL                                                                                                                                                                                               | D           | 1            |
| -110A       | 113T2022-48 |                     | ..SEAL-METAL                                                                                                                                                                                               | H           | 1            |
| 115         | 113T2022-9  |                     | ..PANEL ASSY-BONDED                                                                                                                                                                                        | C           | 1            |
| -115A       | 113T2022-49 |                     | ..PANEL ASSY-BONDED                                                                                                                                                                                        | G           | 1            |
| -120        | 113T2022-10 |                     | ..PANEL ASSY-BONDED                                                                                                                                                                                        | D           | 1            |
| -120A       | 113T2022-50 |                     | ..PANEL ASSY-BONDED                                                                                                                                                                                        | H           | 1            |
| 125         | 113T2012-1  |                     | .ARM ASSY-FWD                                                                                                                                                                                              | C,D,<br>G,H | 1            |
| 130         | BACR15BB6AD |                     | ATTACHING PARTS<br>.RIVET-<br>(SIZE DETERMINE ON INST)<br>-----*-----                                                                                                                                      | C,D,<br>G,H | 4            |
| 135         | ADB5V301NC  |                     | ..BEARING-<br>(V15860)<br>(SPEC BACB10FB05GC)<br>(OPT HTFB05VC<br>(V50294))<br>(OPT KNDB5-70<br>(V97613))<br>(OPT KSC145700BZ5GC<br>(V50632))<br>(OPT NRRS05FBGC<br>(V73134))<br>(OPT WES05GC<br>(V73134)) | C,D,<br>G,H | 1            |

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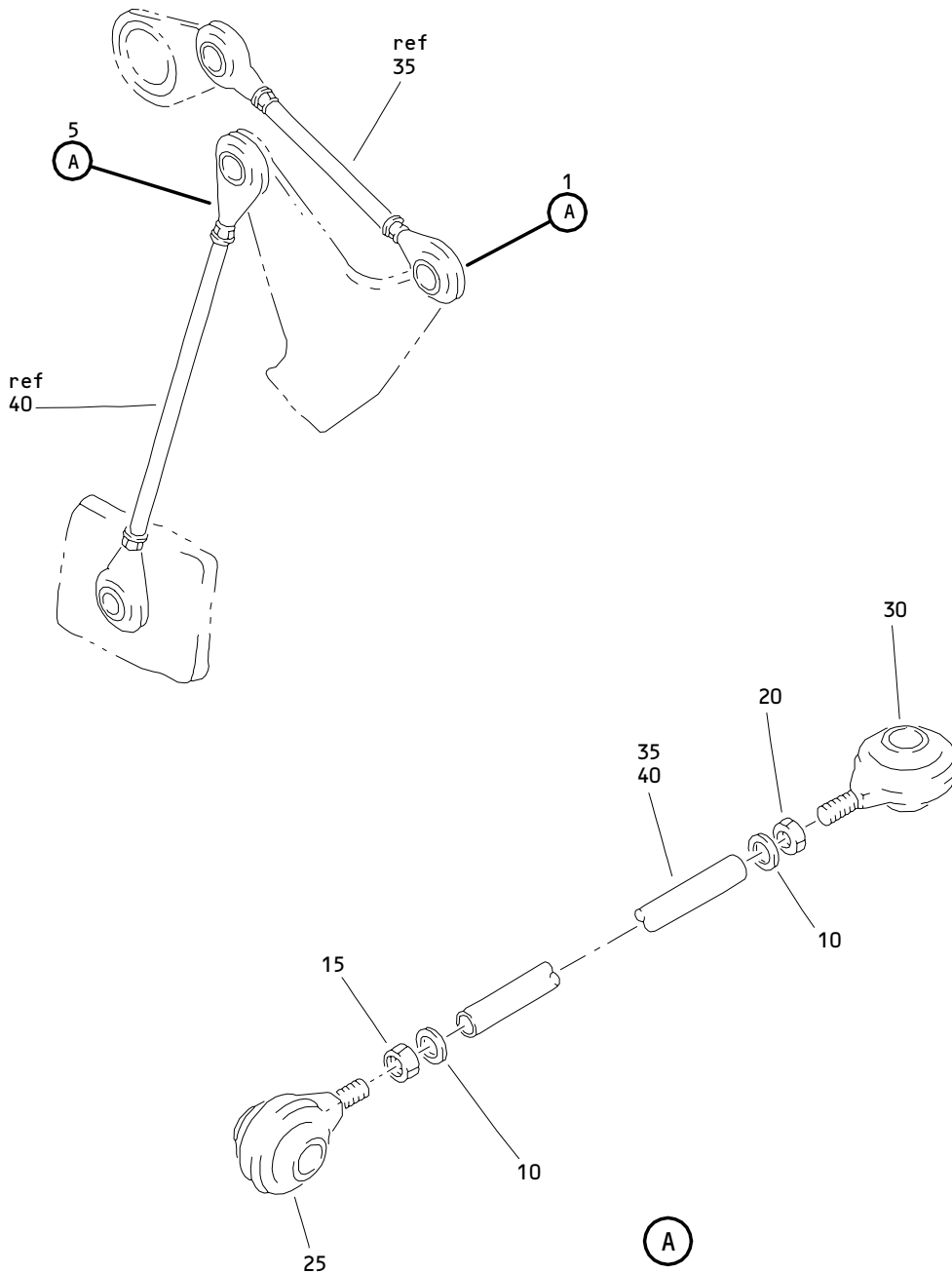
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| FIG. & ITEM | PART NO.       | AIRLINE PART NUMBER | NOMENCLATURE<br>1234567                                                                                                                                                                                    | EFF CODE    | QTY PER ASSY |
|-------------|----------------|---------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------|--------------|
| 02-140      | 113T2012-2     |                     | ..ARM                                                                                                                                                                                                      | C,D,<br>G,H | 1            |
| 145         | NAS1398D6-4    |                     | .RIVET                                                                                                                                                                                                     | C,D,<br>G,H | 9            |
| 150         | 113T2019-1     |                     | .FITTING-FWD RIB SPRT                                                                                                                                                                                      | C,G         | 1            |
| -155        | 113T2019-2     |                     | .FITTING-FWD RIB SPRT                                                                                                                                                                                      | D,H         | 1            |
| 160         | 113T2020-1     |                     | .FITTING-MID RIB SPRT                                                                                                                                                                                      | C,G         | 1            |
| -165        | 113T2020-2     |                     | .FITTING-MID RIB SPRT                                                                                                                                                                                      | D,H         | 1            |
| 170         | 113T2021-1     |                     | .FITTING-AFT RIB SPRT                                                                                                                                                                                      | C,G         | 1            |
| -175        | 113T2021-2     |                     | .FITTING-AFT RIB SPRT                                                                                                                                                                                      | D,H         | 1            |
| 180         | 113T2013-1     |                     | .ARM ASSY-AFT                                                                                                                                                                                              | C,G         | 1            |
| -185        | 113T2013-2     |                     | .ARM ASSY-AFT                                                                                                                                                                                              | D,H         | 1            |
| 190         | BACR15BB6AD    |                     | ATTACHING PARTS<br>.RIVET-<br>(SIZE DETERMINE ON INST)<br>-----*-----                                                                                                                                      | C,D,<br>G,H | 3            |
| 195         | BACB28AP047    |                     | DELETED                                                                                                                                                                                                    |             |              |
| 195A        | BACB28AP04P047 |                     | ..BUSHING                                                                                                                                                                                                  | C,D,<br>G,H | 2            |
| 200         | ADB5V301NC     |                     | ..BEARING-<br>(V15860)<br>(SPEC BACB10FB05GC)<br>(OPT HTFB05VC<br>(V50294))<br>(OPT KNDB5-70<br>(V97613))<br>(OPT KSC145700BZ5GC<br>(V50632))<br>(OPT NRRS05FBGC<br>(V73134))<br>(OPT WES05GC<br>(V73134)) | C,D,<br>G,H | 1            |
| 205         | 113T2013-3     |                     | ..ARM                                                                                                                                                                                                      | C,G         | 1            |
| -210        | 113T2013-4     |                     | ..ARM                                                                                                                                                                                                      | D,H         | 1            |
| 215         | 113T2018-4     |                     | ..TUBE                                                                                                                                                                                                     | C,D,<br>G,H | 1            |

\*[1] POST SB 767-27-0080R2 FOR (PRE SB PARTS, CONTAINED IN CMM 27-51-89)

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Side of Body Door Link Assembly  
 Figure 3

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| FIG. & ITEM | PART NO.     | AIRLINE PART NUMBER | NOMENCLATURE<br>1234567                                                                   | EFF CODE | QTY PER ASSY |
|-------------|--------------|---------------------|-------------------------------------------------------------------------------------------|----------|--------------|
| 03-1        | 113T1293-7   |                     | .LINK ASSY                                                                                | E        | RF           |
| -1A         | 113T1293-9   |                     | .LINK ASSY                                                                                | I        | RF           |
| 5           | 113T1293-5   |                     | .LINK ASSY                                                                                | F        | RF           |
| -5A         | 113T1293-10  |                     | .LINK ASSY                                                                                | J        | RF           |
| 10          | NAS513-6     |                     | .WASHER                                                                                   | E,F      | 2            |
| 15          | NAS509L6     |                     | .NUT                                                                                      | E,F      | 1            |
| 20          | NAS509-6     |                     | .NUT                                                                                      | E,F      | 1            |
| 25          | ADNEL4-334W0 |                     | .BEARING-ROD END<br>(V15860)<br>(SPEC S012T235-104-780)<br>(OPT ARNM4-101KLC<br>(V50294)) |          | 1            |
| -25A        | ARNM4-101KLC |                     | .BEARING-ROD END<br>(V50294)<br>(SPEC S012T235-104-780)<br>(OPT ADNEL4-334W0<br>(V15860)) |          | 1            |
| 30          | ARNM4-101KC  |                     | .BEARING-ROD END<br>(V50294)<br>(SPEC S012T235-104-70)                                    |          | 1            |
| 35          | 113T1293-8   |                     | .LINK                                                                                     | E        | 1            |
| 40          | 113T1293-6   |                     | .LINK                                                                                     | F        | 1            |

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