TO: ALL HOLDERS OF RAM AIR TURBINE ACCESS DOOR ASSY COMPONENT MAINTENANCE MANUAL 29-21-11

REVISION NO. 3 DATED APR 10/87

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 to the Record of Revision Sheet.

| CHAPTER/SECTION AND PAGE NO. | DESCRIPTION OF CHANGE |
|---|---|
| CONTENTS<br>1<br>401<br>501<br>REPAIR-GEN<br>601-602<br>701<br>1007-1008,1011-1012 | Corrected typographical errors, non-technical changes. |
| INTRODUCTION<br>1<br>701 | Deleted materials from ASSEMBLY section. |
| REPAIR-GEN<br>602<br>REPAIR 3-1<br>601-602 | Revised MISC. REFINISHING to include application of safety markings. |
| REPAIR-GEN<br>603 | Revised dimensioning symbols to latest standard. |
| 701-702 | Added bonding fastener item number identification. |
| 1006 | Revised item numbers to agree with IPL. |

BOEING

COMPONENT
MAINTENANCE MANUAL

# RAM AIR TURBINE ACCESS DOOR ASSEMBLY

# PART NUMBER 149T7771-15

COMPONENT MAINTENANCE MANUAL
WITH
ILLUSTRATED PARTS LIST

79821

REVISION RECORD

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

| REVISION NUMBER | REVISION DATE | DATE FILED | BY | REVISION NUMBER | REVISION DATE | DATE FILED | BY |
|---|---|---|---|---|---|---|---|
| | | | | | | | |

TEMPORARY REVISION AND SERVICE BULLETIN RECORD

| BOEING SERVICE BULLETIN | BOEING TEMPORARY REVISION | OTHER DIRECTIVE | DATE OF INCORPORATION INTO MANUAL |
|---|---|---|---|
| 11-1 | | | JUL 10/83 |

| PAGE | DATE | CODE |
|---|---|---|
| 29-21-11 | | |
| TITLE PAGE | | |
| 1 | JUL 10/83 | 01.1 |
| 2 | BLANK | |
| REVISION RECORD | | |
| 1 | JUL 10/83 | 01 |
| 2 | BLANK | |
| TR & SB RECORD | | |
| 1 | JUL 10/83 | 01.1 |
| 2 | BLANK | |
| LIST OF EFFECTIVE PAGES | | |
| *1 | APR 10/87 | 01 |
| THRU LAST PAGE | | |
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| INTRODUCTION | | |
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| DESCRIPTION & OPERATION | | |
| 1 | JUL 10/83 | 01 |
| 2 | BLANK | |
| DISASSEMBLY | | |
| 301 | JUL 10/83 | 01.1 |
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| CLEANING | | |
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| 402 | BLANK | |
| CHECK | | |
| *501 | APR 10/87 | 01.1 |
| 502 | BLANK | |

| PAGE | DATE | CODE |
|---|---|---|
| REPAIR-GENERAL | | |
| *601 | APR 10/87 | 01.1 |
| *602 | APR 10/87 | 01.1 |
| *603 | APR 10/87 | 01.1 |
| 604 | BLANK | |
| REPAIR 1-1 | | |
| 601 | JUL 10/83 | 01 |
| 602 | BLANK | |
| REPAIR 2-1 | | |
| 601 | JAN 10/85 | 01.1 |
| 602 | JAN 10/85 | 01.1 |
| REPAIR 3-1 | | |
| *601 | APR 10/87 | 01.1 |
| *602 | APR 10/87 | 01.1 |
| ASSEMBLY | | |
| *701 | APR 10/87 | 01.1 |
| *702 | APR 10/87 | 01.1 |
| ILLUSTRATED PARTS LIST | | |
| 1001 | JUL 10/83 | 01 |
| 1002 | JAN 10/85 | 01.1 |
| 1003 | JAN 10/85 | 01.1 |
| 1004 | BLANK | |
| 1005 | JAN 10/85 | 01.1 |
| *1006 | APR 10/87 | 01.1 |
| *1007 | APR 10/87 | 01.1 |
| *1008 | APR 10/87 | 01.1 |
| *1009 | APR 10/87 | 01.101 |
| *1010 | APR 10/87 | 01.101 |
| *1011 | APR 10/87 | 01.1 |
| *1012 | APR 10/87 | 01.1 |

* = REVISED, ADDED OR DELETED

TABLE OF CONTENTS

# INTRODUCTION

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

This manual is divided into separate sections:

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

Refer to the Table of Contents for the page location of applicable sections. An asterisked flagnote *[ ] in place of the page number indicates that no special instructions are provided since the function can be performed using standard industry practices.

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

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

All weights and measurements used in the manual are in English units, unless otherwise stated. When metric equivalents are given they will be in parentheses following the English units.

Design changes, optional parts, configuration differences and Service Bulletin modifications create alternate part numbers. These are identified in the Illustrated Parts List (IPL) by adding an alphabetical character to the basic item number. The resulting item number is called an alpha-variant. Throughout the manual, IPL basic item number references also apply to alpha-variants unless otherwise indicated.

Verification:

Assembly: 04/10/87

# RAM AIR TURBINE ACCESS DOOR ASSEMBLY

## DESCRIPTION AND OPERATION

1. Description and Operation

   A. The ram air turbine access door assembly is an aramid/graphite epoxy honeycomb panel with three hinge fittings located along one lengthwise edge. A rubber seal and seal retainer run the length of the same edge. The door assembly provides access to the air turbine and actuator.

2. Leading Particulars (approximate)

   A. Length -- 53 inches

   B. Width -- 21 inches

   C. Height -- 6 inches

   D. Weight -- 16 pounds

## DISASSEMBLY

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

CAUTION: DO NOT REMOVE MORE THAN ONE HINGE ASSEMBLY (30, 85, 120, IPL FIG. 1) AT ONE TIME. TWO HINGE ASSEMBLIES ATTACHED TO DOOR ARE NECESSARY TO LOCATE A REPLACEMENT HINGE ASSEMBLY.

1. Remove one hinge assembly (30, 85, 120) only at any one time.

## CLEANING

CAUTION: DO NOT VAPOR DEGREASE GRAPHITE/ARAMID EPOXY STRUCTURES WITH CHLORINATED CLEANING AGENTS SUCH AS METHYLENE CHLORIDE, TRICHLOROETHYLENE, AND TRICHLOROETHANE. CHLORINATED CLEANING AGENTS WILL CAUSE DAMAGE TO GRAPHITE/ARAMID EPOXY STRUCTURES.

1,1,1-TRICHLOROETHANE IS ONE OF THE SOLVENTS ALLOWED FOR CLEANING COMPOSITE COMPONENTS. DO NOT SUBMERGE PARTS IN THE SOLVENT OR ALLOW STANDING SOLVENT ON THE PARTS OR DAMAGE MAY OCCUR. USE 1,1, 1-TRICHLOROETHANE ONLY AS A WIPE SOLVENT.

1. Clean all parts in accordance with standard industry practices (Ref 20-30-03) except for graphite/aramid epoxy structures.

2. Clean bond assembly (185A, IPL Fig. 1) using non-chlorinated cleaning agents only.

CHECK

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

2. Penetrant check per 20-20-02 -- hinges (80, 115, 150, IPL Fig. 1).

3. Check honeycomb and bonded parts for evidence of delamination, internal water, scratches, and contour defects.

   A. Examine for delamination ultrasonically.

   B. Examine areas suspected of containing water radiographically to determine extent of damage.

   C. Examine edges of panel carefully for cuts and abrasions. Delamination starts very easily from damage to an exposed edge of honeycomb panel.

4. Refer to 767 Structural Repair Manual 52-40-02 for allowable damage and repair data.

## REPAIR - GENERAL

1. Content

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

| P/N | NAME | REPAIR |
|---|---|---|
| 149T7775 | HINGE ASSEMBLY | 1-1 |
| 149T7776 | HINGE ASSEMBLY | 1-1 |
| 149T7777 | HINGE ASSEMBLY | 2-1 |
| - - | MISCELLANEOUS PARTS | 3-1 |

2. Standard Practices

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

20-10-05 Application and Finishing of Plasma Flame Sprayed Coatings
20-11-03 Repair of Electrical Terminations and Electrical Bonding Areas
20-30-02 Stripping of Protective Finishes
20-30-03 General Cleaning Procedures
20-41-01 Decoding Table for Boeing Finish Codes
20-41-02 Application of Chemical and Solvent Resistant Finishes
20-41-05 Application of Corrosion Inhibiting Compounds
20-43-01 Chromic Acid Anodizing
20-43-03 Alodizing
20-50-03 Bearing Installation and Retention
20-50-05 Application of Aluminum Foil and Other Markers
20-50-10 Application of Stencils, Insignia, Silk Screen, Part Numbering and Identification Markings
20-50-11 Application of Aerodynamic Smoothing Sealant
20-70-01 Protection, Storage, and Handling of Airplane Components

3. Materials

NOTE: Equivalent substitutes may be used.

A. Alodine 1200

B. Coating, flame spray (aluminum)-- BMS 10-67, type 7

C. Compound, corrosion preventive -- MIL-C-11796 (Ref 20-60-02)

D. Enamel -- BMS 10-11, type 2, BAC702 white gloss (Ref 20-60-02)

E. Enamel -- BMS 10-60, type 2, BAC102, red gloss (Ref 20-60-02)

F. Primer (Ref 20-60-02)

(1) BMS 10-11, type 1

(2) BMS 10-11, type 1 yellow

(3) BMS 10-79, type 2

G. Sealant -- BMS 5-95 (Ref 20-60-04)

## 4. Dimensioning Symbols

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

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

### EXAMPLES

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

True Position Dimensioning Symbols
Figure 601



79823

## HINGE ASSEMBLY - REPAIR 1-1

149T7775-3
149T7776-1

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

1. Bearing Replacement (110, 145, IPL Fig. 1)

   A. Remove bearing.

      NOTE: Bearing push-out load is 1096 pounds.

   B. Install bearing pr 20-50-03.

   C. Roller or anvil swage bearing per 20-50-03.

2. Refinish

   A. Hinge (115, 150) - - Chromic acid anodize. Apply one coat BMS 10-11, type 1 primer (F-18.13) plus one coat BMS 10-11, type 2 enamel, BAC702 white gloss (F-21.03) all over, except omit enamel from bearing hole. Material: Al alloy.

## HINGE ASSEMBLY - REPAIR 2-1

149T7777-3

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

1. Bearing Replacement (65, IPL Fig. 1)

   A. Remove bearing.

      NOTE: Bearing push-out load is 2000 pounds.

   B. Install bearing per 20-50-03.

   C. Roller or anvil swage bearing per 20-50-03.

2. Bushing Replacement (55, 60)

   A. Remove bushings.

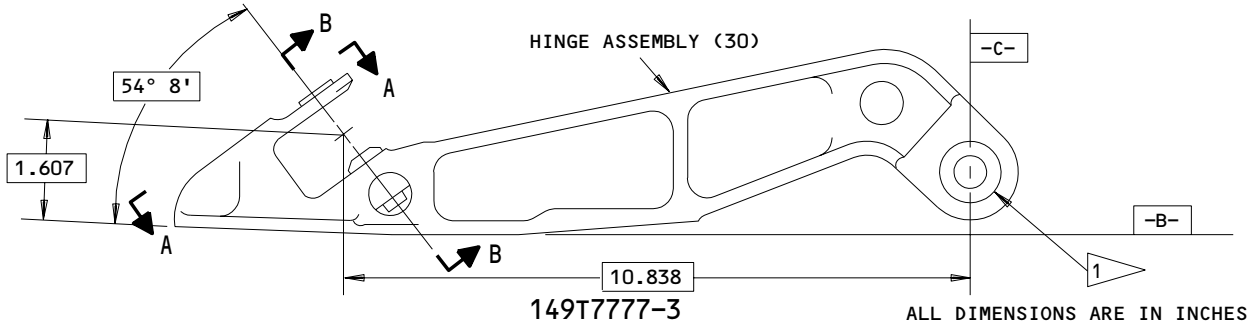
   B. Install bushings per 20-50-03.

   C. Machine bores of bushings per Fig. 601.

   D. Fillet seal around periphery of flanges of bushings using BMS 5-95 sealant.

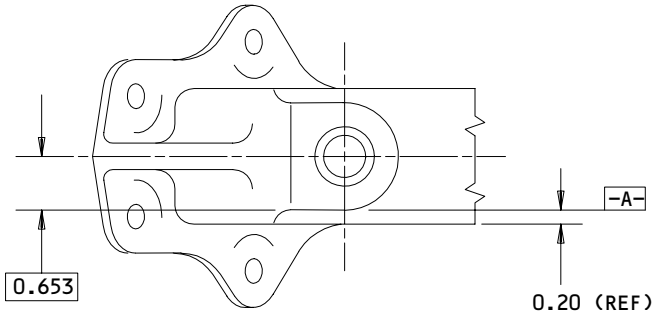
3. Refinish

   A. Hinge (80) -- Refinish per Fig. 601.

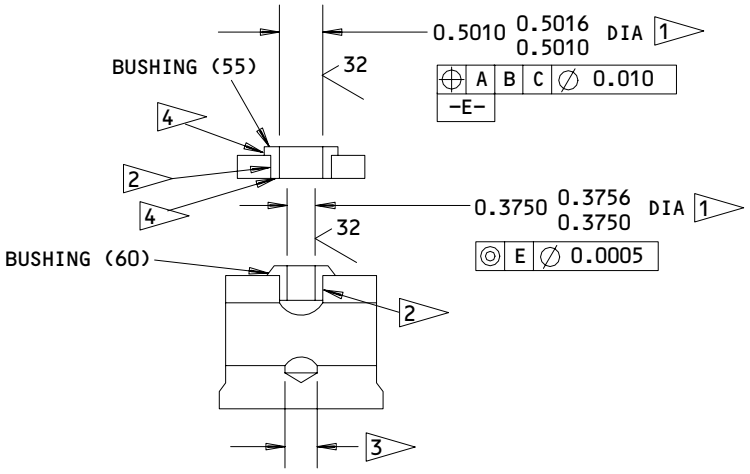



Hinge Refinish
Figure 601 (Sheet 1)

79939




A-A




B-B

REFINISH

HINGE (80) -- CHROMIC ACID ANODIZE, AND APPLY ONE COAT BMS 10-11, TYPE 1 PRIMER (F-18.13), PLUS APPLY ONE COAT BMS 10-11, TYPE 2 ENAMEL, BAC702 WHITE GLOSS (F-21.03) ALL OVER EXCEPT AS NOTED IN FLAGNOTES

1> OMIT ENAMEL FROM HOLE FOR BEARING

2> CHROMIC ACID ANODIZE (F-17.04) ONLY IN HOLES FOR BUSHINGS

3> BRUSH COAT ALL SURFACES IN HOLE WITH MIL-C-11796, CLASS 3 CORROSION PREVENTIVE COMPOUND

4> FILLET SEAL WITH BMS 5-95 SEALANT

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

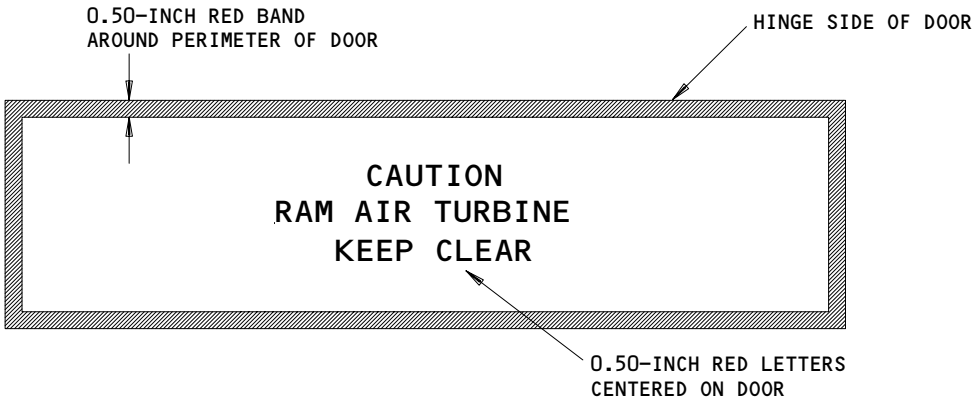
Hinge Refinish
Figure 601 (Sheet 2)

MISCELLANEOUS PARTS - REPAIR 3-1

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

| IPL FIG. & ITEM | MATERIAL | FINISH |
|---|---|---|
| Fig. 1 | | |
| Depressor (20), angle (180) | Al alloy | Chemically treat and apply one coat BMS 10-11, type 1 primer (F-18.06), plus apply one coat BMS 10-11, type 2 enamel, BAC702 white gloss (F-21.03) all over. |
| Bond assembly (185) | - - | Exterior (convex) surface only: Flame spray aluminum coating. Brush, swab, or spray colored chemical coating per 20-43-03 (F-17.10). Apply one coat BMS 10-79, type 2 primer (F-19.46). |
| Door assembly (1) | - - | Clean and apply alodine 1200 to any bare aluminum surfaces. Reactivate areas per 20-41-02. Touch up fastener heads, damaged paint and bared areas using BMS 10-11, type 1 yellow primer and BMS 10-11, type 2 enamel, BAC702 white gloss (F-21.12).<br><br>If removed, reapply safety markings by painting a red band around door perimeter and stencil caution information on door exterior (see Fig. 602). Use BMS 10-60, type 2, BAC 102 red gloss enamel or equivalent. |

Refinish Details
Figure 601




Safety Markings
Figure 602

91354

ASSEMBLY

1. Materials

NOTE: Equivalent substitutes may be used.

A. Adhesive -- BMS 10-26, type 3 (Ref 20-50-05)

B. Enamel (Ref 20-60-02)

(1) BMS 10-11, type 2, BAC701 black flat or BAC706 black semi-gloss

C. Sealant -- BMS 5-95 (Ref 20-60-04)

2. Assembly (IPL Fig. 1)

A. Use standard industry practices for assembly of this component, and additional procedures in following steps.

B. Assemble ram air turbine access door assembly.

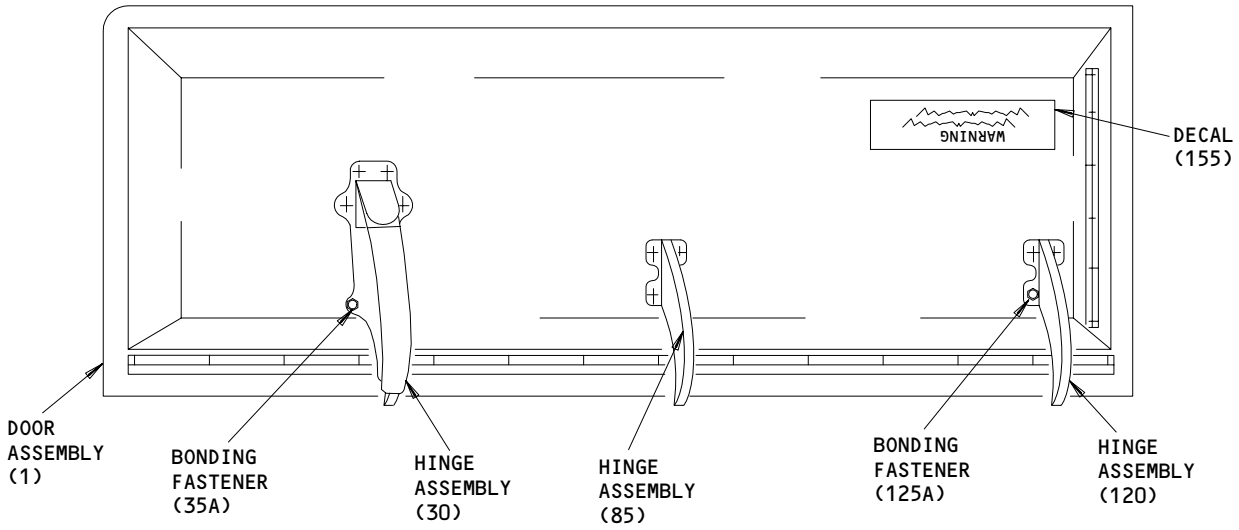
(1) Install hinge fittings (30, 85, 120) with bolts (5, 35, 90, 125, 160A) using wet BMS 5-95 sealant.

(2) Install bonding fasteners (35A, 125A) per Fig. 701 and check resistance values Of 0.5 milliohms per 20-11-03.

NOTE: After installing hinge fittings (30, 85, 120) to door bond assembly (185), check straightness of hingeline.

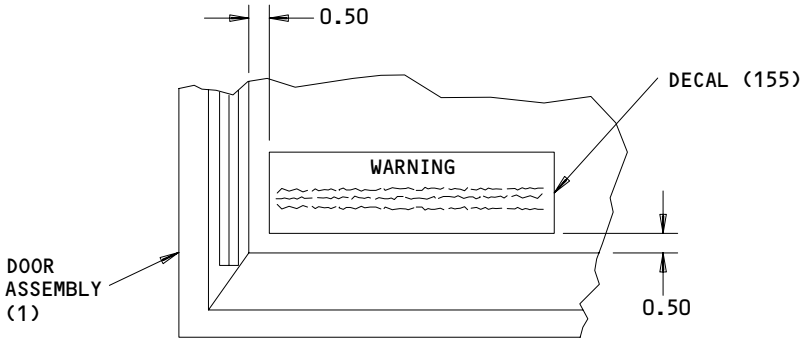
(3) Locate decal (155) per Fig. 702. Bond with BMS 10-26, type 3 adhesive per 20-50-05.

(4) Stencil identification number "198GR" per 20-50-10 on interior (concave) surface of bond assembly (185), as centrally located as possible. Use BMS 10-11, type 2 enamel, BAC701 black, flat or BAC706 black, semi-gloss. Make letters one-half (1/2) inch high.




Bonding Fastener Location
Figure 701

80949




ALL DIMENSIONS
ARE IN INCHES

Decal Location
Figure 702

79790

## 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 are 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 VALLEY-TODECO INCORPORATED
12975 BRADLEY AVENUE
SYLMAR,CALIFORNIA 91342

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

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

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

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

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

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

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

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

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

50294 NMB INC
9730 INDEPENDENCE AVENUE
CHATSWORTH, CALIFORNIA 91311

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

VENDORS

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

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

72962 AMERACE CORP ESNA DIV
2330 VAUXHALL ROAD
UNION, NEW JERSEY 07083
ESNA DIV OF AMERACE CORP SEE AMERACE CORP ESNA DIV
ELASTIC STOP NUT DIV AMERACE CORP SEE ESNA DIV AMERACE CORP

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

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

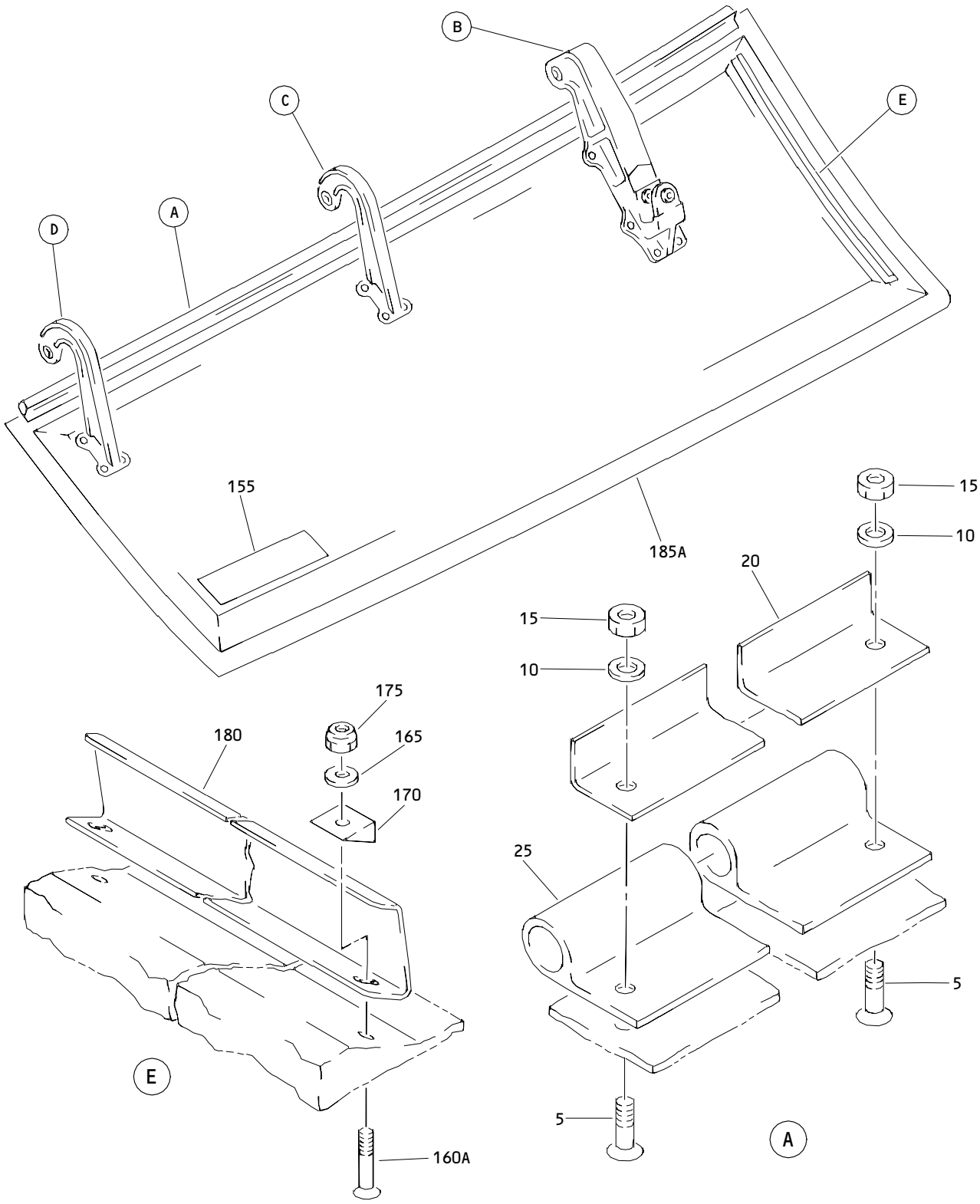
92215 VOI-SHAN DIV OF VSI CORP
8463 HIGUERA STREET
CULVER CITY, CALIFORNIA 90230

94892 MASTER MACHINE PRODUCTS CORPORATION
2069 RANDOLPH STREET
HUNTINGTON PARK, CALIFORNIA 90255

97393 SHUR-LOK CORPORATION
2541 WHITE ROAD PO BOX 19584
IRVINE, CALIFORNIA 92713

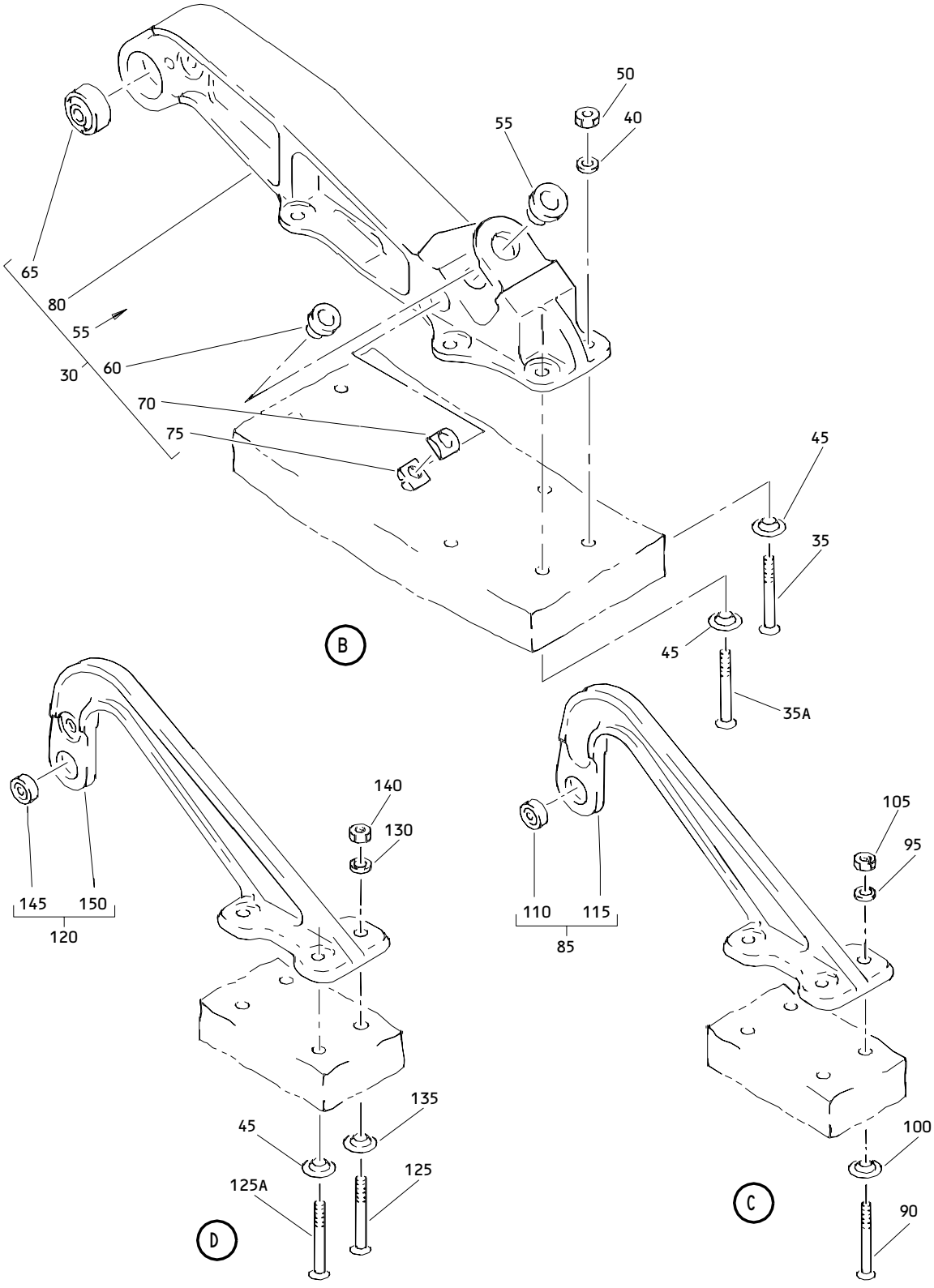
97613 SARGENT INDUSTRIES KAHR BEARING DIVISION
3010 NORTH SAN FERNANDO ROAD
BURBANK, CALIFORNIA 91503

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




Ram Air Turbine Access Door Assembly
Figure 1 (Sheet 1)

T73544




Ram Air Turbine Access Door Assembly
Figure 1 (Sheet 2)



T73545

| FIG. & ITEM | PART NO. | AIRLINE PART NUMBER | NOMENCLATURE 1234567 | EFF CODE | QTY PER ASSY |
|---|---|---|---|---|---|
| 01- | | | | | |
| -1 | 149T7771-1 | | DELETED | | |
| -1A | 149T7771-15 | | DOOR ASSY-RAM AIR TURB ACCESS | | RF |
| 5 | BACB30LH2-3 | | .BOLT (V06710) (SPEC BACB30LH2-3) (OPT BACB30LH2-3 (V06725)) (OPT BACB30LH2-3 (V06950)) (OPT BACB30LH2-3 (V08524)) (OPT BACB30LH2-3 (V17943)) (OPT BACB30LH2-3 (V27624)) (OPT BACB30LH2-3 (V80539)) (OPT BACB30LH2-3 (V92215)) (OPT BACB30LH2-3 (V97928)) | | 14 |
| 10 | AN960PD8L | | .WASHER | | 14 |
| 15 | BRH10C08D | | .NUT (V52828) (SPEC BACN10JC08CD) (OPT H51650-08BAC (V15653)) (OPT 102LH9075-82W (V72962)) | | 14 |
| 20 | 149T7771-7 | | .DEPRESSOR | | 1 |
| 25 | 149T7771-8 | | .SEAL- (MFD FROM EXTR RUBBER 10-60754-36 X 52.0 IN.) | | 1 |
| 30 | 149T7777-3 | | .HINGE ASSY | | 1 |

| FIG. & ITEM | PART NO. | AIRLINE PART NUMBER | NOMENCLATURE 1234567 | EFF CODE | QTY PER ASSY |
|---|---|---|---|---|---|
| 01- | | | | | |
| | | | ATTACHING PARTS | | |
| 35 | BACB30LR4-23 | | .BOLT<br>(V06710)<br>(SPEC BACB30LR4-23)<br>(OPT BACB30LR4-23 (V06725))<br>(OPT BACB30LR4-23 (V06950))<br>(OPT BACB30LR4-23 (V08524))<br>(OPT BACB30LR4-23 (V17943))<br>(OPT BACB30LR4-23 (V27624))<br>(OPT BACB30LR4-23 (V80539))<br>(OPT BACB30LR4-23 (V92215))<br>(OPT BACB30LR4-23 (V97928)) | | 5 |
| | | | ATTACHING PARTS | | |
| 35A | BACB30LR4-23 | | .BOLT<br>(V06710)<br>(SPEC BACB30LR4-23)<br>(OPT BACB30LR4-23 (V06725))<br>(OPT BACB30LR4-23 (V06950))<br>(OPT BACB30LR4-23 (V08524))<br>(OPT BACB30LR4-23 (V17943))<br>(OPT BACB30LR4-23 (V27624))<br>(OPT BACB30LR4-23 (V80539))<br>(OPT BACB30LR4-23 (V92215))<br>(OPT BACB30LR4-23 (V97928)) | | 1 |

| FIG. & ITEM | PART NO. | AIRLINE PART NUMBER | NOMENCLATURE 1234567 | EFF CODE | QTY PER ASSY |
|---|---|---|---|---|---|
| 01- | | | | | |
| 40 | BACW10BP4DP | | .WASHER<br>(V10630)<br>(SPEC BACW10BP4DP) | | 6 |
| 45 | BACW10UC14P | | DELETED | | 6 |
| 45A | BACW10UC416P | | .WASHER-<br>(V10630)<br>(SPEC BACW10UC416P) | | 6 |
| 50 | NAS1805-4N | | .NUT<br>-------*------- | | 6 |
| 55 | BACB28AM08B028A | | ..BUSHING<br>(V23294)<br>(SPEC BACB28AM08B028A)<br>(OPT BACB28AM08B028A<br>(V70265))<br>(OPT BACB28AM08B028A<br>(V94892)) | | 1 |
| 60 | 149T7786-1 | | ..BUSHING | | 1 |
| 65 | WHT08VSBC | | ..BEARING<br>(V50294)<br>(SPEC BACB10FE08C)<br>(OPT WRRS08B10GC<br>(V73134)) | | 1 |
| 70 | LH8065-064 | | ..NUT<br>(V72962)<br>(SPEC BACN10HC6)<br>(OPT SL414-6<br>(V97393)) | | 1 |
| 75 | SLR4027-6 | | ..RETAINER<br>(V97393)<br>(SPEC BACR10V6)<br>(OPT 2452-064RET<br>(V72962)) | | 1 |

| FIG. & ITEM | PART NO. | AIRLINE PART NUMBER | NOMENCLATURE 1234567 | EFF CODE | QTY PER ASSY |
|---|---|---|---|---|---|
| 01- | | | | | |
| 80 | 149T7777-4 | | ..HINGE | | 1 |
| 85 | 149T7776-1 | | .HINGE ASSY | | 1 |
| | | | ATTACHING PARTS | | |
| 90 | BACB30LR4-23 | | .BOLT | | 4 |
| | | | (V06710) | | |
| | | | (SPEC BACB30LR4-23) | | |
| | | | (OPT BACB30LR4-23 | | |
| | | | (V06725)) | | |
| | | | (OPT BACB30LR4-23 | | |
| | | | (V06950)) | | |
| | | | (OPT BACB30LR4-23 | | |
| | | | (V08524)) | | |
| | | | (OPT BACB30LR4-23 | | |
| | | | (V17943)) | | |
| | | | (OPT BACB30LR4-23 | | |
| | | | (V27624)) | | |
| | | | (OPT BACB30LR4-23 | | |
| | | | (V80539)) | | |
| | | | (OPT BACB30LR4-23 | | |
| | | | (V92215)) | | |
| | | | (OPT BACB30LR4-23 | | |
| | | | (V97928)) | | |
| 95 | BACW10BP4DP | | .WASHER | | 4 |
| | | | (V10630) | | |
| | | | (SPEC BACW10BP4DP) | | |
| 100 | BACW10UC416P | | .WASHER | | 4 |
| | | | (V10630) | | |
| | | | (SPEC BACW10UC416P) | | |
| 105 | NAS1805-4N | | .NUT | | 4 |
| | | | -------*------- | | |
| 110 | HT04VSBC | | ..BEARING | | 1 |
| | | | (V50294) | | |
| | | | (SPEC BACB10FC04C) | | |
| | | | (OPT NRRS04B10GC | | |
| | | | (V73134)) | | |
| | | | (OPT ADB4VNC | | |
| | | | (V15860)) | | |
| | | | (OPT KNDB4-66 | | |
| | | | (V97613)) | | |
| | | | (OPT KR4CNGBZC | | |
| | | | (V50632)) | | |

| FIG. & ITEM | PART NO. | AIRLINE PART NUMBER | NOMENCLATURE 1234567 | EFF CODE | QTY PER ASSY |
|---|---|---|---|---|---|
| 01- | | | | | |
| 115 | 149T7776-2 | | ..HINGE | | 1 |
| 120 | 149T7775-3 | | .HINGE ASSY | | 1 |
| | | | ATTACHING PARTS | | |
| 125 | BACB30LR4-23 | | .BOLT<br>(V06710)<br>(SPEC BACB30LR4-23)<br>(OPT BACB30LR4-23 (V06725))<br>(OPT BACB30LR4-23 (V06950))<br>(OPT BACB30LR4-23 (V08524))<br>(OPT BACB30LR4-23 (V17943))<br>(OPT BACB30LR4-23 (V27624))<br>(OPT BACB30LR4-23 (V80539))<br>(OPT BACB30LR4-23 (V92215))<br>(OPT BACB30LR4-23 (V97928)) | | 3 |
| 125A | BACB30LR4-23 | | .BOLT<br>(V06710)<br>(SPEC BACB30LR4-23)<br>(OPT BACB30LR4-23 (V06725))<br>(OPT BACB30LR4-23 (V06950))<br>(OPT BACB30LR4-23 (V08524))<br>(OPT BACB30LR4-23 (V17943))<br>(OPT BACB30LR4-23 (V27624))<br>(OPT BACB30LR4-23 (V80539))<br>(OPT BACB30LR4-23 (V92215))<br>(OPT BACB30LR4-23 (V97928)) | | 1 |

| FIG. & ITEM | PART NO. | AIRLINE PART NUMBER | NOMENCLATURE 1234567 | EFF CODE | QTY PER ASSY |
|---|---|---|---|---|---|
| 01- | | | | | |
| 130 | BACW10BP4DP | | .WASHER<br>(V10630)<br>(SPEC BACW10BP4DP) | | 4 |
| 135 | BACW10UC416P | | .WASHER<br>(V10630)<br>(SPEC BACW10UC416P) | | 4 |
| 140 | NAS1805-4N | | .NUT<br>-------*------- | | 4 |
| 145 | HT04VSBC | | ..BEARING<br>(V50294)<br>(SPEC BACB10FC04C)<br>(OPT NRRS04B10GC<br>(V73134))<br>(OPT ADB4VNC<br>(V15860))<br>(OPT KNDB4-66<br>(V97613))<br>(OPT KR4CNGBZC<br>(V50632)) | | 1 |
| 150 | 149T7775-4 | | ..HINGE | | 1 |
| 155 | BAC27TBY0022 | | .DECAL-WARNING FOR STORAGE OF R.A.T. INSTRUCTIONS LOCATED IN RIGHT HAND WHEEL WELL | | 1 |
| 160 | BACB30LH2-2 | | DELETED | | 6 |
| 160A | BACB30LH2-12 | | .BOLT | | 6 |
| 165 | AN960PD8L | | .WASHER | | 6 |
| 170 | BACF3T02N5-5 | | .FILLER | | 6 |
| 175 | BRH10C08D | | .NUT-<br>(V52828)<br>(SPEC BACN10JC08CD)<br>(OPT H51650-08BAC<br>(V15653))<br>(OPT 102LH9075-82W<br>(V72962)) | | 6 |
| 180 | 149T7789-1 | | .ANGLE | | 1 |
| 185 | 149T7771-11 | | DELETED | | |
| 185A | 149T7771-16 | | .BOND ASSY | | 1 |