

 **BOEING**
COMPONENT
MAINTENANCE MANUAL

TO: ALL HOLDERS OF SHOCK STRUT DOOR ASSEMBLY COMPONENT MAINTENANCE MANUAL
32-12-55

REVISION NO. 11 DATED DEC 01/97

HIGHLIGHTS

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

CHAPTER/SECTION

AND PAGE NO.

DESCRIPTION OF CHANGE

TITLE PAGE

Added door assemblies 113T8201-75SP thru -78SP with a stronger attach fitting.

1

REPAIR 2-1

601-602

602,1004-1012,

1021-1037

TR & SB RECORD

Identified parts changed per SB 32-0146.

1

602,1004-1012,

1021-1037

REPAIR-GEN

Added clarification to details.

601

REPAIR 1-1

601-602

REPAIR 2-1

601-602

REPAIR 3-1

601-603

REPAIR 4-1

601-602

32-12-55

HIGHLIGHTS

01.1

Page 1

Dec 01/97

SHOCK STRUT DOOR ASSEMBLY

PART NUMBERS 113T8201-47SP THRU -52SP,
-69SP THRU -78SP

COMPONENT MAINTENANCE MANUAL
WITH
ILLUSTRATED PARTS LIST

32-12-55

TITLE PAGE

Page 1

Dec 01/97

01.1



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


BOEING
 COMPONENT
 MAINTENANCE MANUAL

TEMPORARY REVISION AND SERVICE BULLETIN RECORD

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVE	DATE OF INCORPORATION INTO MANUAL
32-0101 32-0146		PRR B10537 PRR B10659 PRR C12219 PRR B12322	OCT 10/83 OCT 10/84 OCT 10/84 JUL 01/92 DEC 01/97

32-12-55

TR & SB RECORD

01.1

Page 1

Dec 01/97


BOEING
 COMPONENT
 MAINTENANCE MANUAL

PAGE	DATE	CODE	PAGE	DATE	CODE
32-12-55			REPAIR-GENERAL		
TITLE PAGE			*601	DEC 01/97	01.1
*1	DEC 01/97	01.1	602	SEP 01/94	01.1
2	BLANK		603	SEP 01/94	01.1
REVISION RECORD			604	BLANK	
1	JUL 10/83	01	REPAIR 1-1		
2	BLANK		*601	DEC 01/97	01.1
TR & SB RECORD			*602	DEC 01/97	01.1
*1	DEC 01/97	01.1	*603	DEC 01/97	01.101
2	BLANK		*604	DEC 01/97	01.101
LIST OF EFFECTIVE PAGES			REPAIR 2-1		
*1	DEC 01/97	01	*601	DEC 01/97	01.1
THRU LAST PAGE			*602	DEC 01/97	01.1
CONTENTS			*603	DEC 01/97	01.101
1	OCT 01/87	01.1	*604	BLANK	
2	BLANK		REPAIR 3-1		
INTRODUCTION			*601	DEC 01/97	01.1
1	SEP 01/94	01.1	*602	DEC 01/97	01.1
2	BLANK		*603	DEC 01/97	01.1
DESCRIPTION & OPERATION			*604	DEC 01/97	01.101
1	SEP 01/94	01.1	REPAIR 4-1		
2	BLANK		*601	DEC 01/97	01.1
DISASSEMBLY			*602	DEC 01/97	01.1
301	JUL 01/92	01.1	603	APR 10/86	01.1
302	BLANK		604	APR 10/86	01.1
CLEANING			REPAIR 5-1		
401	SEP 01/94	01.1	601	SEP 01/94	01.1
402	BLANK		602	BLANK	
CHECK			ASSEMBLY		
501	SEP 01/94	01.1	701	SEP 01/94	01.1
502	BLANK		702	SEP 01/94	01.1
			703	SEP 01/94	01.1
			704	SEP 01/94	01.1

* = REVISED, ADDED OR DELETED

32-12-55

 EFFECTIVE PAGES
 CONTINUED Page 1
 01 Dec 01/97

PAGE	DATE	CODE	PAGE	DATE	CODE
FITS AND CLEARANCES					
801	JUL 01/92	01.1			
802	JUL 01/92	01.1			
ILLUSTRATED PARTS LIST					
1001	JUL 10/83	01			
1002	OCT 01/87	01.1			
*1003	DEC 01/97	01.1			
*1004	DEC 01/97	01.1			
*1005	DEC 01/97	01.1			
*1006	DEC 01/97	01.1			
*1007	DEC 01/97	01.1			
*1008	DEC 01/97	01.1			
*1009	DEC 01/97	01.1			
*1010	DEC 01/97	01.1			
*1011	DEC 01/97	01.1			
*1012	DEC 01/97	01.1			
*1013	BLANK				
*1014	DEC 01/97	01.1			
*1015	DEC 01/97	01.1			
*1016	DEC 01/97	01.1			
*1017	DEC 01/97	01.1			
*1018	DEC 01/97	01.1			
*1019	DEC 01/97	01.1			
*1020	DEC 01/97	01.1			
*1021	DEC 01/97	01.1			
*1022	DEC 01/97	01.1			
*1023	DEC 01/97	01.1			
*1024	DEC 01/97	01.1			
*1025	DEC 01/97	01.1			
*1026	DEC 01/97	01.1			
*1027	DEC 01/97	01.1			
*1028	DEC 01/97	01.1			
*1029	DEC 01/97	01.1			
*1030	DEC 01/97	01.1			
*1031	DEC 01/97	01.1			
*1032	DEC 01/97	01.1			
*1033	DEC 01/97	01.1			
*1034	DEC 01/97	01.1			
*1035	DEC 01/97	01.1			
*1036	DEC 01/97	01.1			
*1037	DEC 01/97	01.1			
*1038	BLANK				

* = REVISED, ADDED OR DELETED

32-12-55

EFFECTIVE PAGES
 LAST PAGE Page 2
 01 Dec 01/97



TABLE OF CONTENTS

<u>Paragraph Title</u>	<u>Page</u>
Description and Operation.	1
Testing/Trouble Shooting (not applicable)	
Disassembly.	301
Cleaning	401
Check.	501
Repair	601
Assembly	701
Fits and Clearances.	801
Special Tools (not applicable)	
Illustrated Parts List	1001

32-12-55

CONTENTS

01.1

Page 1

Oct 01/87



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 &
Service Bulletin Record | 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 -- JUN 19/86

32-12-55

INTRODUCTION

01.1

Page 1

Sep 01/94



SHOCK STRUT DOOR ASSEMBLY

DESCRIPTION AND OPERATION

1. Description and Operation

A. The shock strut door assembly is a bonded panel assembly with a fairing assembly and five fitting assemblies. The door is attached to the main landing gear shock strut.

2. Leading Particulars (approximate)

Width -- 71 inches
Length -- 76 inches
Height -- 7 inches
Weight -- 67 pounds

32-12-55

DESCRIPTION & OPERATION

01.1

Page 1

Sep 01/94



DISASSEMBLY

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

1. Use standard industry practices for disassembly of this component, except for the following additional procedure.
- |2. Note thickness of shims (195, 275, IPL Fig. 1) for reference during assembly.

32-12-55

DISASSEMBLY

01.1

Page 301

Jul 01/92



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 with standard industry practices and the instructions in 20-30-03. Be careful not to use chlorinated cleaners on graphite/aramid epoxy structures.

32-12-55

CLEANING
Page 401
Sep 01/94

01.1

CHECK

- | 1. Examine components for defects with standard industry practices.
- | 2. Penetrant examine per 20-20-02 on fittings (165, 205A, 210A, 245A, 285B, 290B, IPL Fig. 1).
- | 3. Examine honeycomb and bonded parts for signs of delamination, water inside, scratches, and contour defects.
 - A. Examine for delamination ultrasonically.
 - | B. Radiographically examine areas that could contain water radiographically.
 - C. Examine edges of panel carefully for cuts and abrasions. Delamination starts very easily from damage to an edge member of honeycomb panel.
 - | D. Refer to 767 Structural Repair Manual, 52-80-02 for allowable damage data. Refer to SB 32-0114 for inspection and repair in the area of the inboard aft corner of the door.

32-12-55

CHECK

01.1

Page 501
Sep 01/94

REPAIR – GENERAL1. Content

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

<u>P/N</u>	<u>NAME</u>	<u>REPAIR</u>
113T8201-65	FITTING ASSEMBLY	1-1
113T8215-2	FITTING ASSEMBLY	1-1
113T8219	FITTING ASSEMBLY	1-1
113T8216	FITTING ASSEMBLY	2-1
113T8217	FITTING ASSEMBLY	3-1
113T8218	FITTING ASSEMBLY	4-1
113T8215-6	FITTING ASSEMBLY	4-1
- - -	MISCELLANEOUS PARTS REFINISH	5-1

2. Standard Practices

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

20-30-02 Stripping of Protective Finishes
 20-30-03 General Cleaning Procedures
 20-41-01 Decoding Table for Boeing Finish Codes
 20-43-01 Chromic Acid Anodizing
 20-50-03 Bearing Installation and Retention
 20-60-02 Finishing Materials
 20-60-04 Miscellaneous Materials

3. Materials

NOTE: Equivalent substitutes can be used.

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

32-12-55

REPAIR-GENERAL

01.1

Page 601

Dec 01/97

- | B. Enamel -- BMS 10-60, Type 2, BAC707 gray gloss (Ref 20-60-02)
- | C. Enamel -- BMS 10-60, Type 2, BAC7308 gray gloss (Ref 20-60-02)
- | D. Enamel -- BMS 10-60, Type 2, BAC7067 white gloss (Ref 20-60-02)
- E. Primer -- BMS 10-11, Type 1 (Ref 20-60-02)
- | F. Primer -- BMS 10-79, Type 2 (Ref 20-60-02)
- 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.

32-12-55

REPAIR-GENERAL

01.1

Page 602

Sep 01/94

BOEING

COMPONENT MAINTENANCE MANUAL

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

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

EXAMPLES

<p>— 0.002 STRAIGHT WITHIN 0.002</p> <p>⊥ 0.002 B PERPENDICULAR TO B WITHIN 0.002</p> <p>// 0.002 A PARALLEL TO A WITHIN 0.002</p> <p>○ 0.002 ROUND WITHIN 0.002</p> <p>⊘ 0.010 CYLINDRICAL SURFACE MUST LIE BETWEEN TWO CONCENTRIC CYLINDERS, ONE OF WHICH HAS A RADIUS 0.010 INCH GREATER THAN THE OTHER</p> <p>⌒ 0.006 A EACH LINE ELEMENT OF THE SURFACE AT ANY CROSS SECTION MUST LIE BETWEEN TWO PROFILE BOUNDARIES 0.006 INCH APART RELATIVE TO DATUM PLANE A</p> <p>△ 0.020 A SURFACES MUST LIE WITHIN PARALLEL BOUNDARIES 0.02 INCH APART AND EQUALLY DISPOSED ABOUT TRUE PROFILE</p>	<p>◎ ∅ 0.0005 C CONCENTRIC TO C WITHIN 0.0005 DIAMETER</p> <p>≡ 0.010 A SYMMETRICAL WITH A WITHIN 0.010</p> <p>∠ 0.005 A ANGULAR TOLERANCE 0.005 WITH A</p> <p>⊕ ∅ 0.002 Ⓢ B LOCATED AT TRUE POSITION WITHIN 0.002 DIA RELATIVE TO DATUM B, REGARDLESS OF FEATURE SIZE</p> <p>⊥ ∅ 0.010 Ⓜ A 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</p> <p>2.000 THEORETICALLY EXACT DIMENSION IS 2.000 OR 2.000 BSC</p> <p>0.020 A A 0.020</p>
<p>NOTE: DATUM MAY APPEAR AT EITHER SIDE OF TOLERANCE FRAME</p>	

True Position Dimensioning Symbols
Figure 601

32-12-55

REPAIR-GENERAL

01.1

Page 603

Sep 01/94

FITTING ASSEMBLY – REPAIR 1-1

113T8201-65
113T8215-2
113T8219-1, -4

NOTE: Refer to REPAIR-GENERAL for a list of applicable standard practices. Refer to IPL Fig. 1 for item numbers. For repair of surfaces which is only replacement of the original finish, refer to Refinish instructions, Fig. 601.

1. Bushing Replacement (Fig. 601)

- A. Remove the old bushings.
- B. If you find defects on the hole surfaces, refer to par. 2 for repair instructions.
- C. Install replacement bushings by the shrink-fit method of SOPM 20-50-03.
- D. Machine the bores of the bushings to design and finish.
- E. Fillet seal around the flanges of the bushings with BMS 5-95 sealant.

2. Holes for Bushings (Fig. 601)

- A. Machine as necessary, within repair limits, to remove defects.
- B. Penetrant examine per SOPM 20-20-02.
- C. Shot peen as indicated.
- D. Refinish as indicated.
- E. Make oversize bushings (Fig. 602, Fig. 603) to adjust for the material removed in step A.
- F. Install the bushings per par. 1 above.

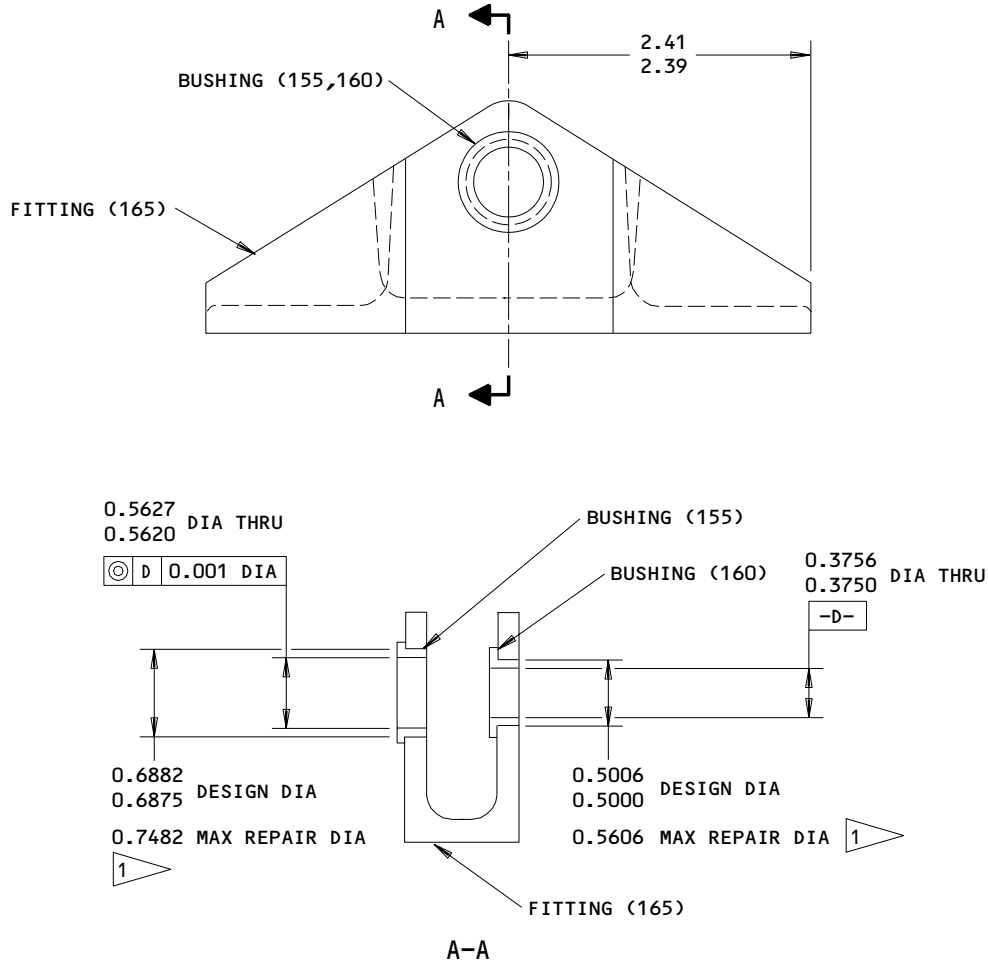
32-12-55

REPAIR 1-1

01.1

Page 601

Dec 01/97



REFINISH

FITTING 113T8215-5; 113T8219-2:
 CHROMIC ACID ANODIZE AND APPLY PRIMER
 BMS 10-11, TYPE 1 (F-18.13), BUT NO PRIMER
 IN BORES FOR BUSHINGS

FITTING 113T8219-5:
 CHROMIC ACID ANODIZE AND APPLY PRIMER
 BMS 10-11, TYPE 1 (F-18.13), AND ENAMEL
 BMS 10-11, TYPE 2 (F-21.03), BUT NO PRIMER
 OR ENAMEL IN BORES FOR BUSHINGS

FITTING ASSEMBLY 113T8201-65:
 AFTER BUSHINGS ARE INSTALLED IN THE BASIC
 FITTING, APPLY ENAMEL BMS 10-11, TYPE 2 BUT
 NOT ON BUSHINGS

REPAIR

REF 1

125 ALL MACHINED SURFACES UNLESS SHOWN
 DIFFERENTLY

SHOT PEEN: 0.023-0.055 SHOT SIZE
 0.008 A2 INTENSITY

MATERIAL: AL ALLOY

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

1 LIMIT FOR INSTALLATION OF OVERSIZE
 BUSHINGS

113T8201-65; 113T8215-2
 113T8219-1,-4
 Fitting Repair and Refinish
 Figure 601

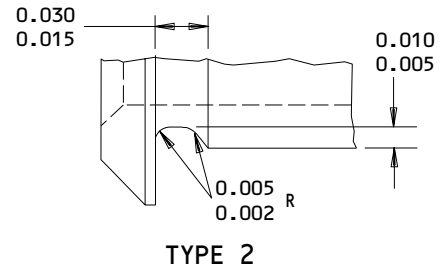
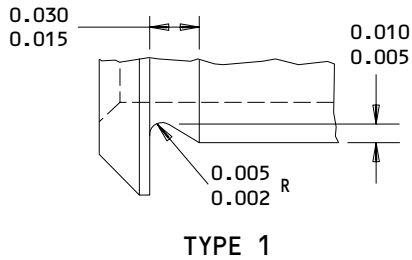
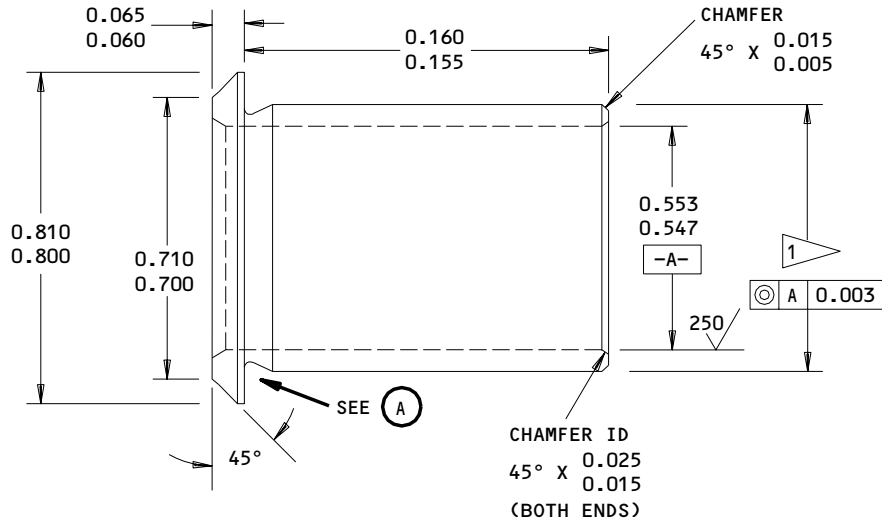
32-12-55

REPAIR 1-1

Page 602

Dec 01/97

01.1



UNDERCUT TYPE 1 OR TYPE 2 OPTIONAL



1 FINAL BUSHING OUTSIDE DIA EQUALS REPAIR
 DIA OF FITTING PLUS 0.0005-0.0018
 INTERFERENCE

63/ ALL MACHINED SURFACES, EXCEPT AS NOTED
 ANGULAR TOLERANCE, ±0.50 DEG
 MATERIAL: AL-NI-BR PER AMS 4640
 FINISH: CADMIUM PLATE PER 20-42-05, TYPE 2,
 CLASS 2.

ALL DIMENSIONS ARE IN INCHES
 DIMENSIONS APPLY AFTER PLATING

BUSHING REPLACEMENT FOR BUSHING (155, IPL FIG. 1)
 Oversize Bushing Details
 Figure 602

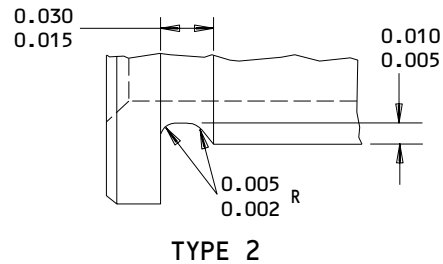
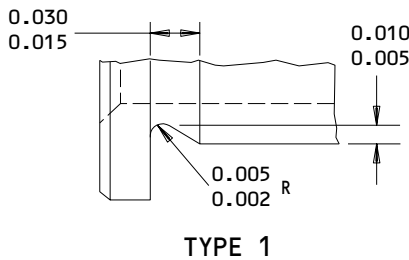
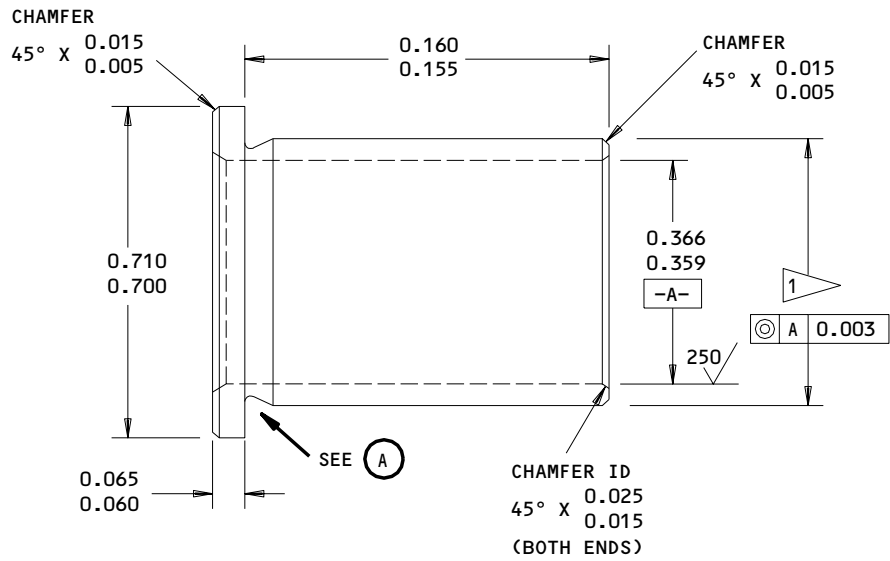
32-12-55

REPAIR 1-1

01.101

Page 603

Dec 01/97



UNDERCUT TYPE 1 OR TYPE 2 OPTIONAL

(A)

1 FINAL BUSHING OUTSIDE DIA EQUALS REPAIR DIA OF FITTING PLUS 0.0004-0.0016 INTERFERENCE

63/ ALL MACHINED SURFACES, EXCEPT AS NOTED
 ANGULAR TOLERANCE, ±0.50 DEG
 MATERIAL: 15-5PH CRES, HT TR 180-200 KSI
 FINISH: CADMIUM PLATE PER 20-42-05, TYPE 2, CLASS 2.
 ALL DIMENSIONS ARE IN INCHES
 DIMENSIONS APPLY AFTER PLATING

**BUSHING REPLACEMENT FOR BUSHING (160, IPL FIG. 1)
 Oversize Bushing Details
 Figure 603**

32-12-55

REPAIR 1-1

01.101

Page 604

Dec 01/97

FITTING ASSEMBLY – REPAIR 2-1

113T8216-5, -6, -11, -12, -15, -16, -19, -20

NOTE: Refer to REPAIR – GENERAL for a list of applicable standard practices. Refer to IPL Fig. 2 for item numbers. For repair which is only replacement of the original finish, refer to Refinish instructions in Fig. 601.

1. Bushing Replacement (Fig. 601)

- A. Remove the old bushing.
- B. If you find defects on the hole surfaces, refer to par. 2 for repair instructions.
- C. Install a replacement bushing by the shrink-fit method of SOPM 20-50-03.
- D. Machine the bore of the bushing to design dimensions and finish.
- E. Fillet seal around the flanges of the bushing with BMS 5-95 sealant.

2. Hole for Bushing (Fig. 601)

- A. Machine as required, within repair limits, to remove defects.
- B. Penetrant examine per SOPM 20-20-02.
- C. Shot peen as indicated.
- D. Refinish as indicated.
- E. Make an oversize bushing (Fig. 602) to adjust for the material removed in step A.
- F. Install the bushing per par. 1 above.

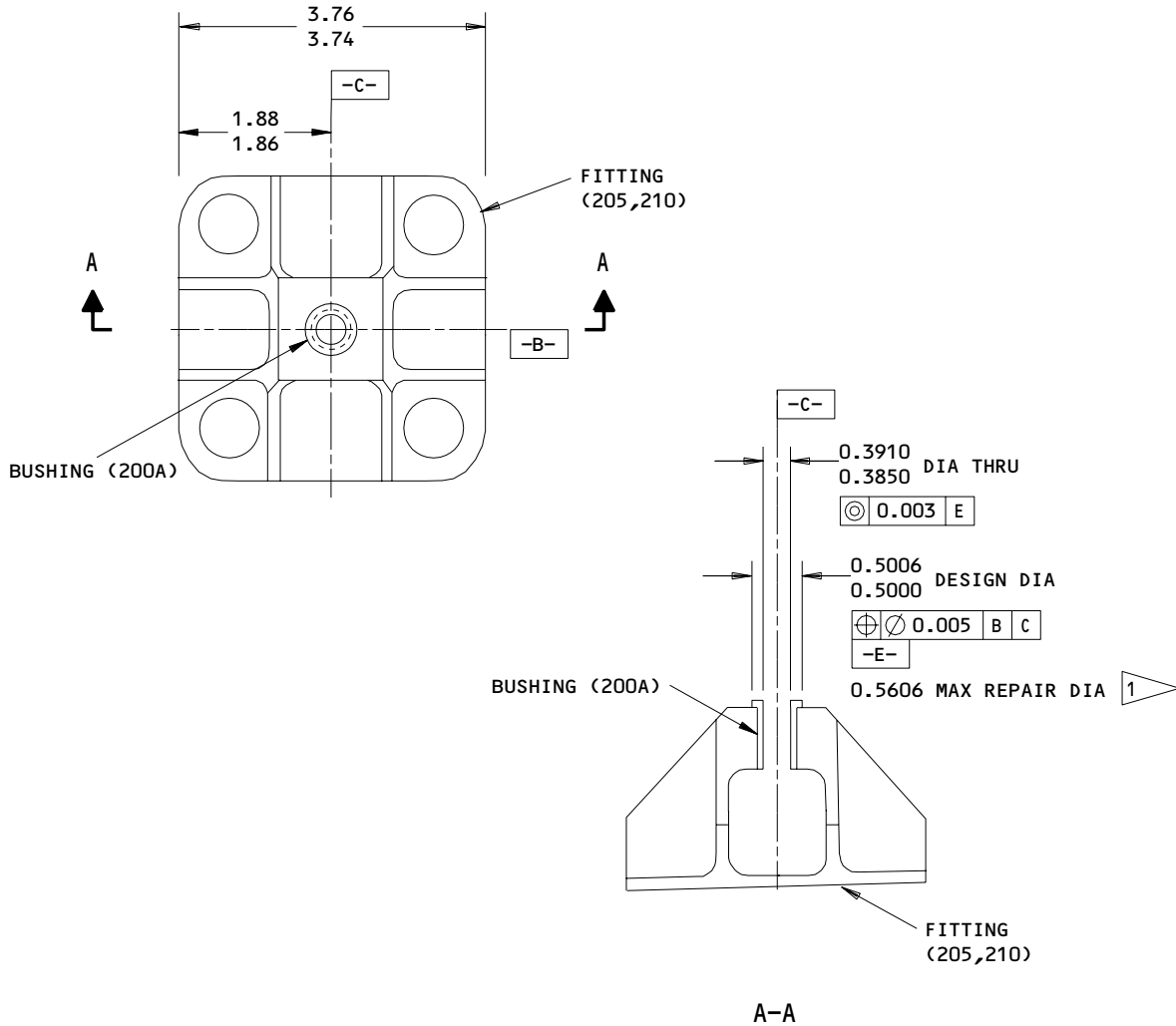
32-12-55

REPAIR 2-1

01.1

Page 601

Dec 01/97



REFINISH:

FITTINGS 113T8216-7,-8,-13,-14:
 CHROMIC ACID ANODIZE AND APPLY PRIMER
 BMS 10-11, TYPE 1 (F-18.13)

FITTINGS 113T8216-17,-18:
 CHROMIC ACID ANODIZE AND APPLY PRIMER
 BMS 10-11, TYPE 1 (F-18.13). APPLY ENAMEL
 BMS 10-11, TYPE 2 (F-21.03) BUT NOT IN THE
 HOLE FOR THE BUSHING

FITTINGS 113T8216-21,-22:
 CHROMIC ACID ANODIZE (F-17.02). APPLY PRIMER
 BMS 10-79, TYPE 2 (F-19.46). APPLY ENAMEL
 BMS 10-11, TYPE 2 (F-21.03) BUT NOT IN THE
 HOLE FOR THE BUSHING

REPAIR

REF 1

125 ✓ ALL MACHINED SURFACES UNLESS SHOWN
 DIFFERENTLY

SHOT PEEN: 0.023-0.055 SHOT SIZE
 0.006 A2 INTENSITY

MATERIAL: AL ALLOY

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

1 LIMIT FOR INSTALLATION OF OVERSIZE BUSHING

113T8216-5,-6,-11,-12,-15,-16,-19,-20
 Attach Fitting Repair and Refinish
 Figure 601

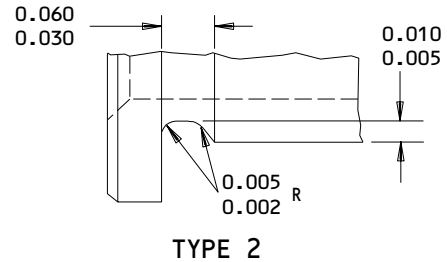
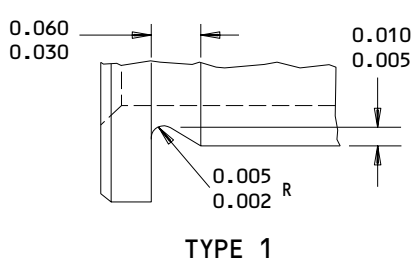
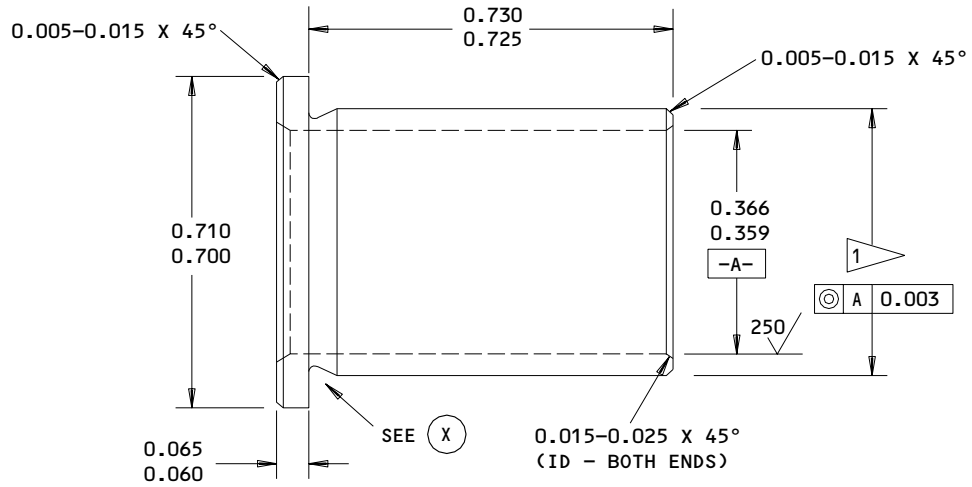
32-12-55

REPAIR 2-1

Page 602

Dec 01/97

01.1



UNDERCUT TYPE 1 OR TYPE 2 OPTIONAL

(X)

1 FINAL BUSHING OUTSIDE DIA EQUALS REPAIR DIA OF FITTING PLUS 0.0004-0.0016 INTERFERENCE

63/ ALL MACHINED SURFACES, EXCEPT AS NOTED
 ANGULAR TOLERANCE, ±0.50 DEG
 MATERIAL: 15-5PH CRES, 180-200 KSI
 FINISH: CADMIUM PLATE PER 20-42-05, TYPE 2, CLASS 2.
 ALL DIMENSIONS ARE IN INCHES
 DIMENSIONS APPLY AFTER PLATING

BUSHING REPLACEMENT FOR BUSHING (200A, IPL FIG. 1)
 Oversize Bushing Details
 Figure 602

32-12-55
 REPAIR 2-1
 Page 603
 Dec 01/97

01.101

FITTING ASSEMBLY – REPAIR 3-1

113T8217-11, -12, -15, -16, -19, -20, -23, -24

NOTE: Refer to REPAIR – GENERAL for a list of applicable standard practices. Refer to IPL Fig. 1 for item numbers. For repair of surfaces which is only replacement of the original finish, refer to Refinish instructions, Fig. 601.

1. Bushing Replacement (Fig. 601)

- A. Remove the old bushings.
- B. If you find defects on the hole surfaces, refer to par. 2 for repair instructions.
- C. Install replacement bushings by the shrink-fit method of SOPM 20-50-03.
- D. Machine the bores of the bushings to design dimensions and finish.
- E. Fillet seal around the flanges of the bushings with BMS 5-95 sealant.

2. Holes for Bushings (Fig. 601)

- A. Machine as required within repair limits, to remove defects.
- B. Penetrant examine per SOPM 20-20-02.
- C. Shot peen as indicated.
- D. Refinish as indicated.
- E. Make oversize bushings (Fig. 602) to adjust for the material removed in step A.
- F. Install the bushings per par. 1 above.

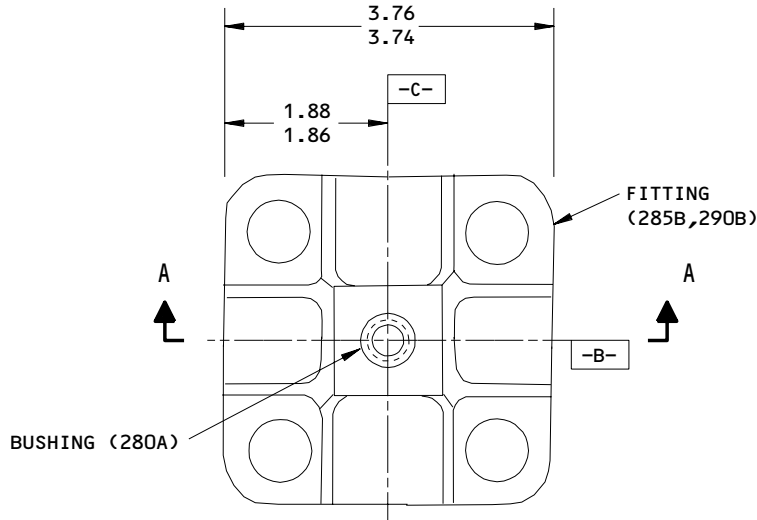
32-12-55

REPAIR 3-1

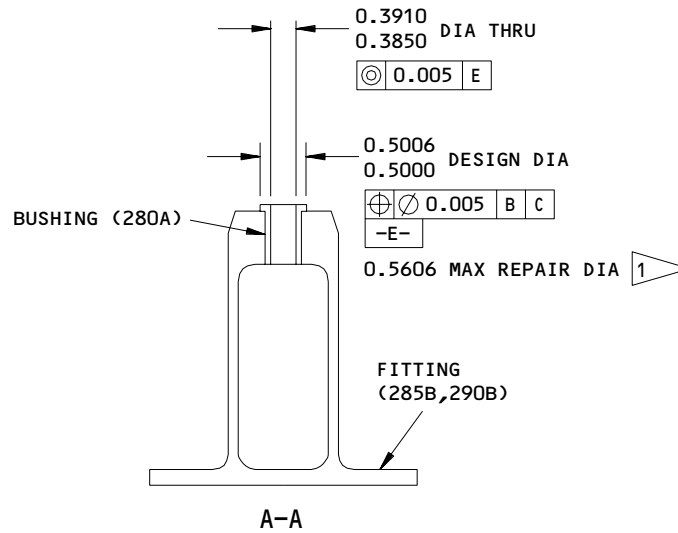
01.1

Page 601

Dec 01/97



113T8217-11, -12, -15, -16, -19, -20



113T8217-11, -12, -15, -16, -19, -20, -23, -24
 Fitting Repair and Refinish
 Figure 601 (Sheet 1)

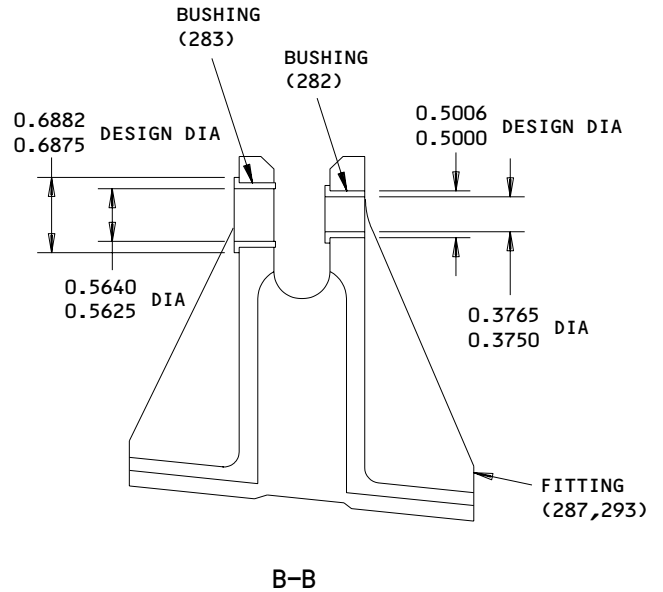
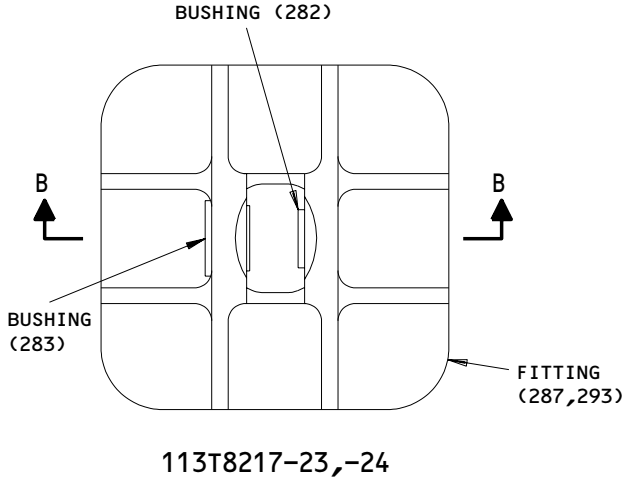
32-12-55

REPAIR 3-1

Page 602

Dec 01/97

01.1



REFINISH:

FITTINGS 113T8217-13,-14,-17,-18:
 CHROMIC ACID ANODIZE AND APPLY PRIMER
 BMS 10-11, TYPE 1 (F-18.13)

FITTINGS 113T8217-25,-26:
 CHROMIC ACID ANODIZE AND APPLY PRIMER
 BMS 10-11, TYPE 1 (F-18.13). APPLY
 ENAMEL BMS 10-11, TYPE 2 (F-18.13).
 APPLY ENAMEL BMS 10-11, TYPE 2 (F-21.03)
 BUT NOT IN THE HOLES FOR THE BUSHINGS

REPAIR

REF 1

125 ALL MACHINED SURFACES UNLESS SHOWN
 DIFFERENTLY

SHOT PEEN: 0.023-0.055 SHOT SIZE
 0.006 A2 INTENSITY

MATERIAL: AL ALLOY

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

1 LIMIT FOR INSTALLATION OF OVERSIZE
 BUSHINGS

113T8217-11,-12,-15,-16,-19,-20,-23,-24
 Fitting Repair and Refinish
 Figure 601 (Sheet 2)

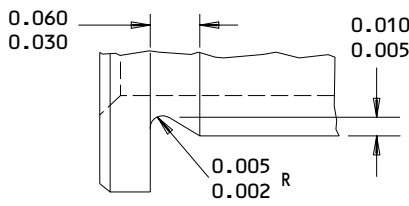
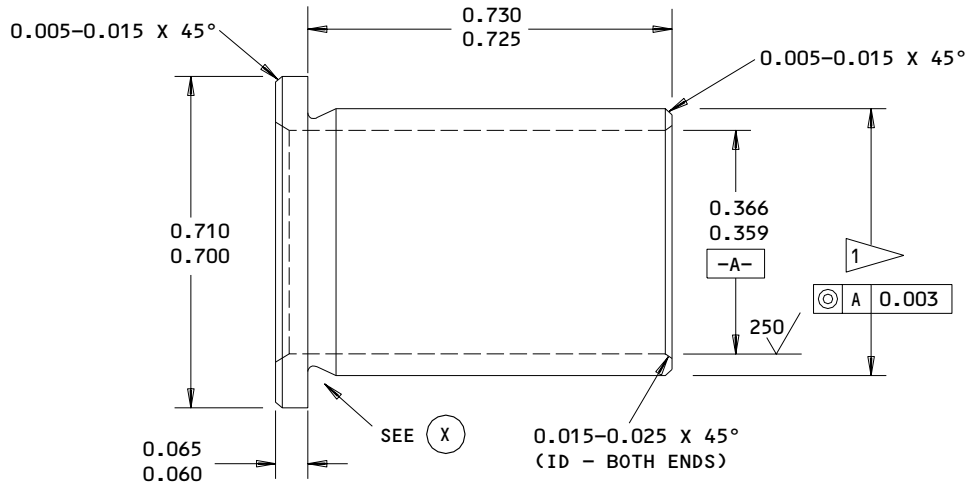
32-12-55

REPAIR 3-1

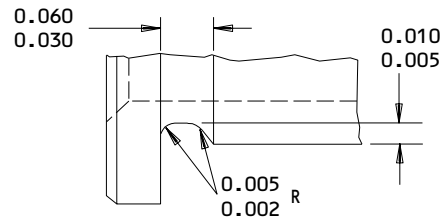
01.1

Page 603

Dec 01/97



TYPE 1



TYPE 2

UNDERCUT TYPE 1 OR TYPE 2 OPTIONAL

(X)

1 FINAL BUSHING OUTSIDE DIA EQUALS REPAIR DIA OF FITTING PLUS 0.0004-0.0016 INTERFERENCE

63/ ALL MACHINED SURFACES, EXCEPT AS NOTED
 ANGULAR TOLERANCE, ±0.50 DEG
 MATERIAL: 15-5PH CRES, HT TR 180-200 KSI
 FINISH: CADMIUM PLATE PER 20-42-05, TYPE 2, CLASS 2. PLATING IN BORE OPTIONAL
 ALL DIMENSIONS ARE IN INCHES
 DIMENSIONS APPLY AFTER PLATING

BUSHING REPLACEMENT FOR BUSHING (280A, IPL FIG. 1)
Oversize Bushing Details
Figure 602

32-12-55

REPAIR 3-1

01.101

Page 604

Dec 01/97

FITTING ASSEMBLY – REPAIR 4-1113T8215-6
113T8218-1

NOTE: Refer to REPAIR – GENERAL for a list of applicable standard practices. Refer to IPL Fig. 601 for item numbers. For repair of surfaces which is only replacement of the original finish, refer to Refinish instructions, Fig. 601.

1. Bushing Replacement (Fig. 601)

- A. Remove the old bushings.
- B. If you find defects on the hole surfaces, refer to par. 2 for repair instructions.
- C. Install replacement bushings by the shrink-fit method of SOPM 20-50-03.
- D. Machine the bores of the bushings to design dimensions and finish.
- E. Fillet seal around the flanges of the bushings with BMS 5-95 sealant.

2. Holes for Bushings (Fig. 601)

- A. Machine as required, within repair limits to remove defects.
- B. Penetrant examine per SOPM 20-20-02.
- C. Shot peen as indicated.
- D. Refinish as indicated.
- E. Make oversize bushings (Fig. 602, Fig. 603) to adjust for the material removed in step A.
- F. Install the bushings per par. 1 above.

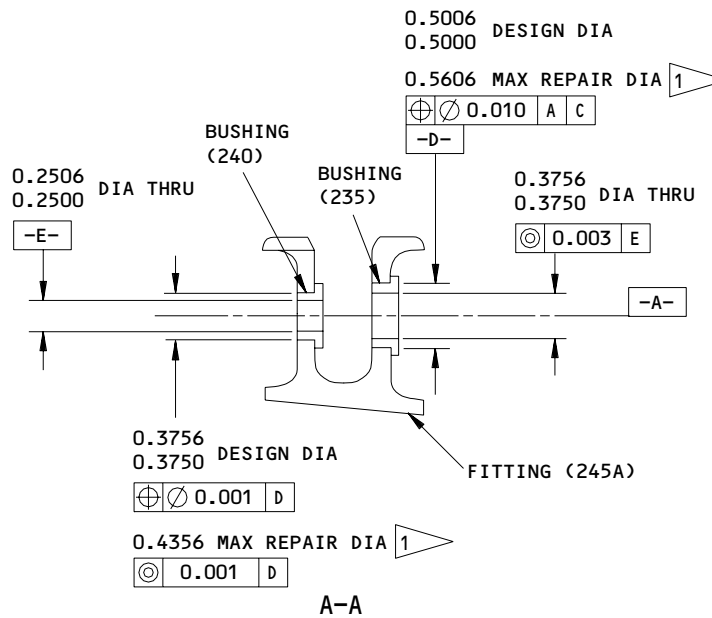
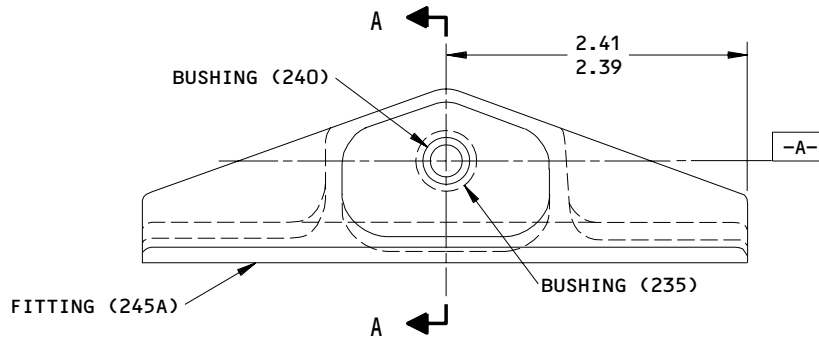
32-12-55

REPAIR 4-1

01.1

Page 601

Dec 01/97



REFINISH:

FITTINGS 113T8215-7, 113T8218-2:
 CHROMIC ACID ANODIZE AND APPLY PRIMER
 BMS 10-11, TYPE 1 (F-18.13). BUT NO
 PRIMER IN BORES FOR BUSHINGS

1 LIMIT FOR INSTALLATION OF OVERSIZE
 BUSHINGS

REPAIR

REF **1**
 125 ALL MACHINED SURFACES UNLESS SHOWN
 DIFFERENTLY

SHOT PEEN: 0.023-0.55 SHOT SIZE
 0.008 A2 INTENSITY

MATERIAL: AL ALLOY

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

113T8215-6
 113T8218-1
 Fitting Repair and Refinish
 Figure 601

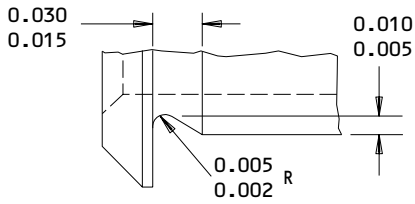
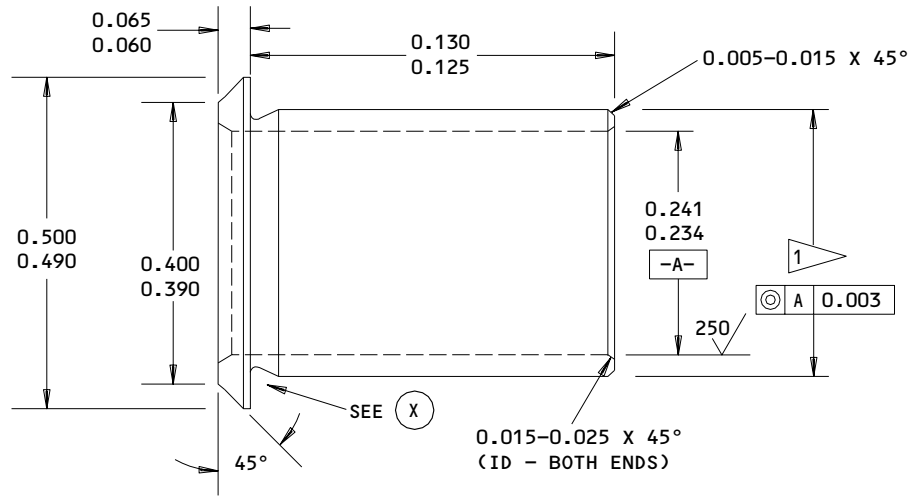
32-12-55

REPAIR 4-1

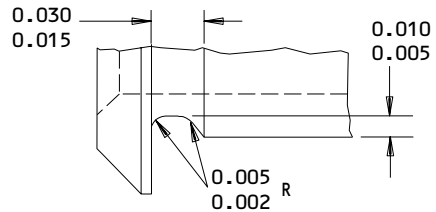
Page 602

Dec 01/97

01.1



TYPE 1



TYPE 2

UNDERCUT TYPE 1 OR TYPE 2 OPTIONAL

(X)

1 FINAL BUSHING OUTSIDE DIA EQUALS REPAIR
 DIA OF FITTING PLUS 0.0004-0.0016
 INTERFERENCE

63/ ALL MACHINED SURFACES, EXCEPT AS NOTED
 ANGULAR TOLERANCE, ±0.50 DEG
 MATERIAL: AL-NI-BR PER AMS 4640
 FINISH: CADMIUM PLATE PER 20-42-05, TYPE 2,
 CLASS 2.
 ALL DIMENSIONS ARE IN INCHES
 DIMENSIONS APPLY AFTER PLATING

BUSHING REPLACEMENT FOR BUSHING (235, IPL FIG. 1)
 Oversize Bushing Details
 Figure 602

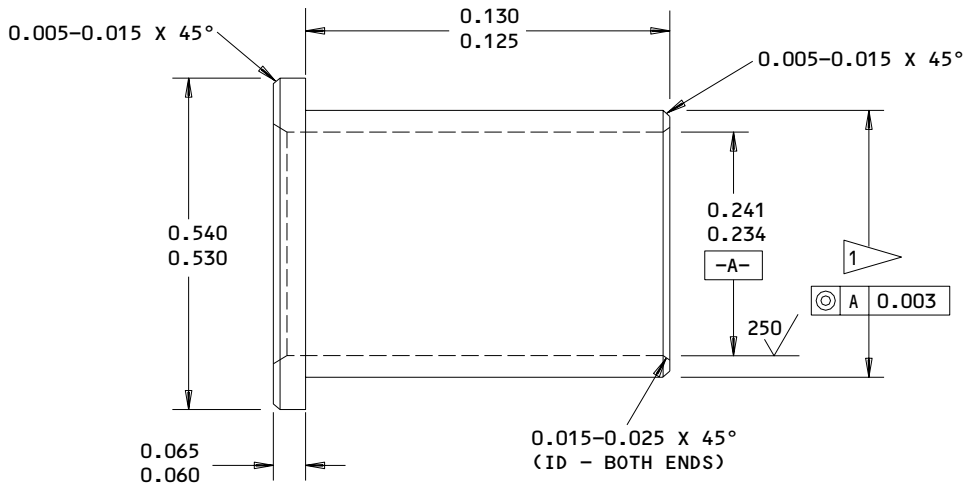
32-12-55

REPAIR 4-1

01.1

Page 603

Apr 10/86



1 FINAL BUSHING OUTSIDE DIA EQUALS REPAIR DIA OF FITTING PLUS 0.0003-0.0015 INTERFERENCE

63 ALL MACHINED SURFACES, EXCEPT AS NOTED
 ANGULAR TOLERANCE, ± 0.50 DEG
 MATERIAL: 15-5PH CRES, 180-200 KSI
 FINISH: CADMIUM PLATE PER 20-42-05, TYPE 2, CLASS 2. PLATING IN BORE OPTIONAL
 ALL DIMENSIONS ARE IN INCHES
 DIMENSIONS APPLY AFTER PLATING

**BUSHING REPLACEMENT FOR BUSHING (240, IPL FIG. 1)
 Oversize Bushing Details
 Figure 603**

32-12-55

REPAIR 4-1

01.1

Page 604

Apr 10/86


BOEING
 COMPONENT
 MAINTENANCE MANUAL
MISCELLANEOUS PARTS - REPAIR 5-1

NOTE: Repair of these parts is only replacement of the original finish. Refer to REPAIR-GEN for a list of applicable standard practices.

IPL FIG. & ITEM	MATERIAL	FINISH
<u>Fig. 1</u> Door assembly		Apply BMS 10-79, type 2 primer (F-19.46) all over. Apply BMS 10-11, type 2, BAC702 white gloss enamel (F-21.03) all over door interior but not on bushings or seals. Apply BMS 10-60, type gloss enamel (F-19.39-XXX) to exterior surface and edges to agree with the operator's color scheme.

Refinish Details
 Figure 601

32-12-55

REPAIR 5-1

01.1

Page 601

Sep 01/94

ASSEMBLY1. Materials

NOTE: Equivalent substitutes can be used.

A. Adhesive -- Type 41 (Ref 20-50-12)

B. Adhesive -- Type 93 (Ref 20-50-12)

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

D. Sealant -- BMS 5-142 (Ref 20-60-04)

2. Assembly (IPL Fig. 1)

A. Use standard industry practices and these special procedures.

B. Shock Strut Door Assembly 113T8201-47SP thru -50SP

- (1) Bond servicing chart (441A, 600A) to doubler (315, 320) in area shown (Fig. 701) using type 93 adhesive per 20-50-12. Fillet seal around edges of chart with BMS 5-95 sealant. Apply coating of Type 41 adhesive over entire surface of chart and filleted area and 0.25 inch beyond edge of chart.

NOTE: Apply no paint between faying surfaces of fitting assemblies (170, 175, 250, 255), shims (195, 275), and panel assemblies (305, 310).

- (2) Delaminate shims (195, 275) to thickness noted in disassembly.

NOTE: Do not use faying surface sealant between fittings (170, 175, 250, 255), and panel assemblies (305, 310).

- (3) Install bolts (180A, 260A) through panel assemblies (305, 310), shims (195, 275), and fittings (170, 175, 250, 255) using wet BMS 5-95 sealant. Tighten bolts (180A, 180B, 260A, 260B) to 60-95 inch-pounds. After 1-24 hours, tighten again to this torque value.
- (4) Fillet seal around the edge of fittings (170, 175, 250, 255) with BMS 5-142 sealant.
- (5) Apply faying surface seal of BMS 5-95 sealant between fitting assemblies (135, 215) and panel assemblies (305, 310).
- (6) Install bolts (140, 220) through panel assemblies (305, 310) and fitting assemblies (135, 215) with wet BMS 5-95 sealant.

32-12-55ASSEMBLY
Page 701
Sep 01/94

01.1

- (7) Install bonding fasteners (295, 300) per 20-11-03 and make sure that the resistance is less than 0.001 ohms.
- (8) Bond identification plate (445) to panel assembly (305, 310) per 20-50-10 shown in Fig. 701.

C. Shock Strut Door Assembly 113T8201-51SP, -52SP, -69SP thru -74SP

- (1) Bond servicing chart (442) to area shown (Fig. 702) with type 93 adhesive per 20-50-12. Fillet seal around edges of chart with BMS 5-95 sealant. Apply coating of Type 41 adhesive over entire surface of chart and filleted area, and 0.25 inch beyond edge of chart.

NOTE: Apply no paint between faying surfaces of fitting assemblies (170, 175, 250, 255), shims (195A, 275A), and panel assemblies (305, 310).

- (2) Delaminate shims (195A, 275A) to thickness noted in disassembly.

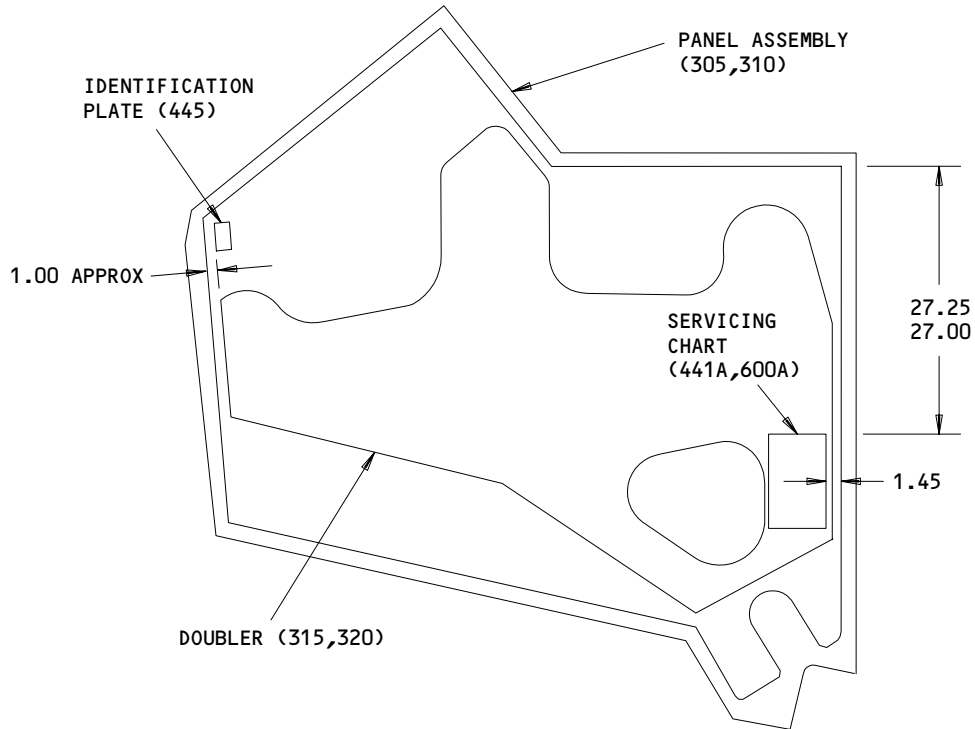
NOTE: Do not use faying surface sealant between fittings (170, 175, 250, 255), and panel assemblies (305, 310).

- (3) Install bolts (180C, 260C) through panel assemblies (305, 310), shims (195A, 275A), and fittings (170, 175, 250, 255) with wet BMS 5-95 sealant. Tighten bolts (180C, 260C) to 60-95 inch-pounds. After 1-24 hours, tighten again to this torque value.
- (4) Fillet seal around the edge of fittings (170, 175, 250, 255) with BMS 5-142 sealant.
- (5) Apply faying surface seal of BMS 5-95 sealant between fitting assemblies (135) and panel assemblies (305, 310).
- (6) Install bolts (140B) through panel assemblies (305, 310) and fitting assemblies (135) with wet BMS 5-95 sealant.
- (7) Install bonding fasteners (295, 300) per 20-11-03 and make sure the resistance is less than 0.001 ohms.
- (8) Bond identification plate (445A) to panel assembly (305) per 20-50-10 as shown in Fig. 702.

32-12-55

ASSEMBLY
Page 702
Sep 01/94

01.1



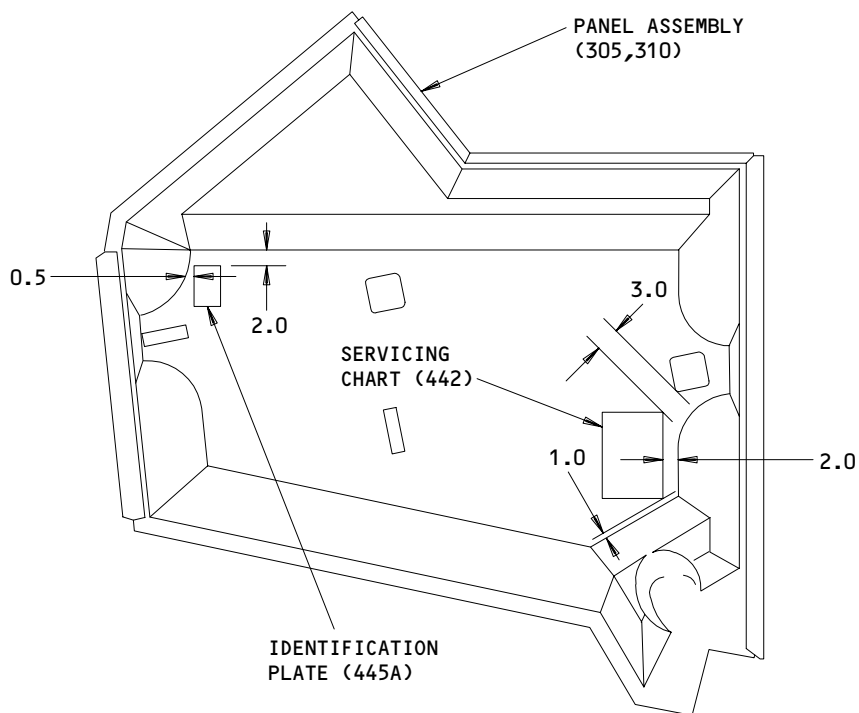
ITEM NUMBERS REFER TO IPL FIG. 1
ALL DIMENSIONS ARE IN INCHES

Plate and Servicing Chart Placement
Figure 701

32-12-55

ASSEMBLY
Page 703
Sep 01/94

01.1



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

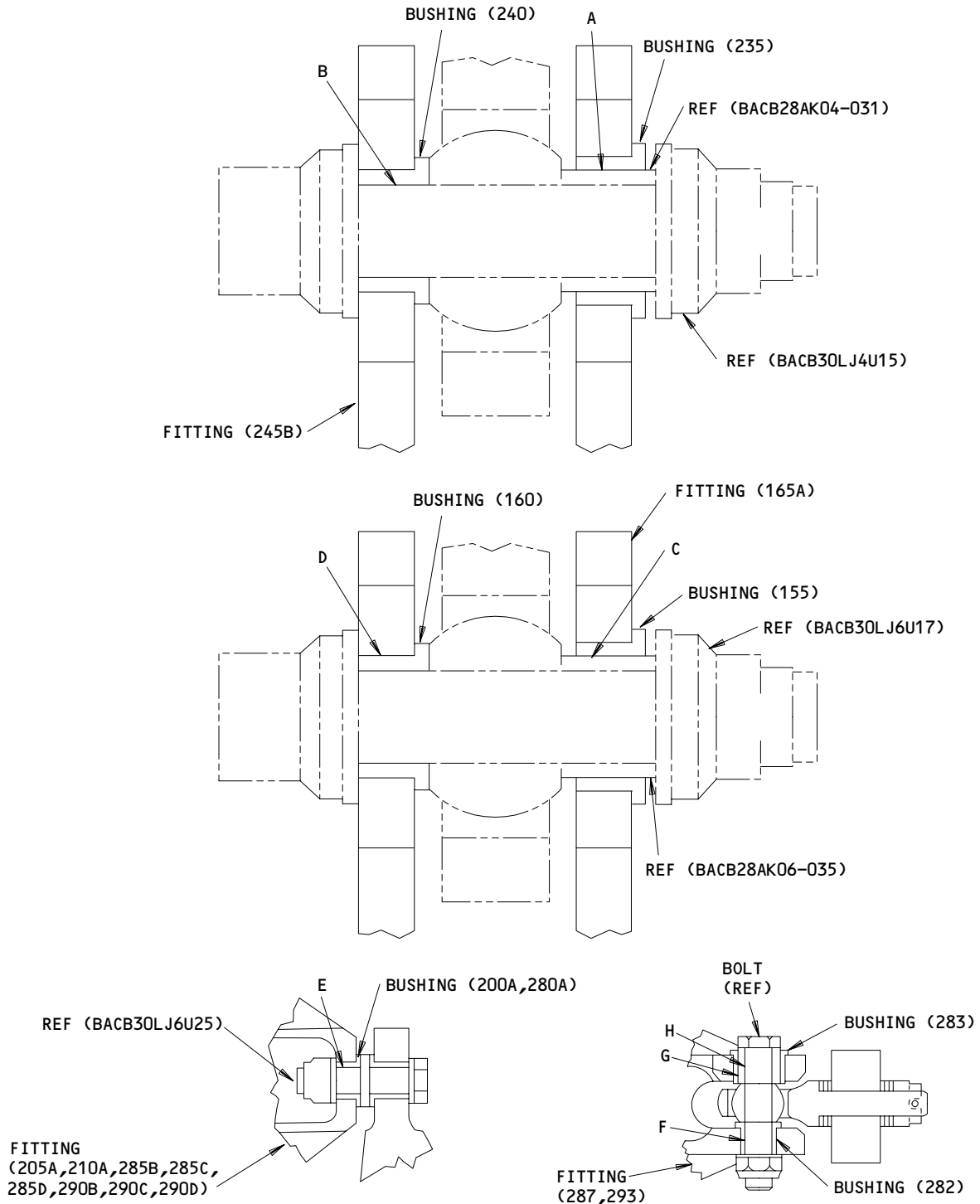
Plate and Servicing Chart Placement
Figure 702

32-12-55

ASSEMBLY
Page 704
Sep 01/94










01.1








FITS AND CLEARANCES



Fits and Clearances
Figure 801 (Sheet 1)

32-12-55

Ref Letter Fig.801	Mating Item No. IPL Fig.1	Design Dimension				Service Wear Limit		
		Dimension		Assembly Clearance		Dimension		Maximum Clearance
		Min	Max	Min	Max	Min	Max	
A	ID 235	0.3750	0.3756	0.0005	0.0016	0.3706	0.3795	0.0050
	OD 	0.3740	0.3745					
B	ID 240	0.2500	0.2506	0.0005	0.0021	0.2454	0.2547	0.0052
	OD 	0.2485	0.2495					
C	ID 155	0.5620	0.5627	0.0005	0.0017	0.5577	0.5665	0.0050
	OD 	0.5610	0.5615					
D	ID 160	0.3750	0.3756	0.0005	0.0016	0.3701	0.3800	0.0055
	OD 	0.3740	0.3745					
E	ID 200A,280A	0.3850	0.3910	0.0105	0.0170	0.3660	0.3995	0.0250
	OD 	0.3740	0.3745					
F	ID 282	0.3750	0.3765	0.0005	0.0025			
	OD 	0.3740	0.3745					
G	ID 283	0.5625	0.5640	0.0010	0.0030			
	OD 	0.5610	0.5615					
H	ID 	0.3750	0.3755	0.0005	0.0015			
	OD 	0.3740	0.3745					

-  BACB28AK04-031
-  BACB30LU4U15
-  BACB28AK06-35
-  BACB30LJ6U17
-  BACB30LJ6U25
-  BACB30LJ6U25
-  BACB28AK06-056

ALL DIMENSIONS ARE IN INCHES

Fits and Clearances
Figure 801 (Sheet 2)

32-12-55

FITS AND CLEARANCES
01.1 Page 802
Jul 01/92



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.

32-12-55

ILLUSTRATED PARTS LIST

01

Page 1001

Jul 10/83

7. Boeing Proprietary Color-Coded Parts

- A. Color-coded parts are identified with an alpha "SP" suffix. This entry represents consolidation of all color codes applicable for a given usage. Orders for color-coded parts should include the registry number of the airplane for which the parts are ordered.

32-12-55

ILLUSTRATED PARTS LIST
01.1 Page 1002
Oct 01/87

**BOEING**
COMPONENT
MAINTENANCE MANUALVENDORS

11815 CHERRY AEROSPACE FASTENERS DIV OF TEXTRON
1224 EAST WARNER AVE, P.O. BOX 2157
SANTA ANA, CALIFORNIA 92707-0157

15653 KAYNAR TECHNOLOGY KAYNAR DIV
800 SOUTH STATE COLLEGE BLVD, P.O. BOX 3001
FULLERTON, CALIFORNIA 92634-3001

52828 REPUBLIC FASTENER MFG CORP
1300 RANCHO CONEJO BLVD
NEWBURY PARK, CALIFORNIA 91320-1405

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

72962 ELASTIC STOP NUT A DIV OF HARTFORD INDUSTRIES INC
2330 VAUXHALL ROAD
UNION, NEW JERSEY 07083-5038

80539 SPS TECHNOLOGIES INC AEROSPACE PRODUCTS DIV
2701 SOUTH HARBOR BLVD, P.O. BOX 1259
SANTA ANA, CALIFORNIA 92702-1259

92215 FAIRCHILD IND INC FAIRCHILD AEROSPACE FASTENER DIVISION
3010 W LOMITA BLVD
TORRANCE, CALIFORNIA 90505-5102

32-12-55ILLUSTRATED PARTS LIST
01.1 Page 1003
Dec 01/97

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
AN3DD3A		1	430	13
		1	585	13
AN315D3R		1	440	13
		1	595	13
AN960JD10		1	72	3
AN960JD10L		1	20A	13
AN960PD10L		1	435	13
		1	590	13
AN960PD516		1	145	4
		1	185	4
		1	225	2
		1	265	4
BACB28AM06B013A		1	235	1
BACB28AM09B016A		1	155	2
BACB28AP04P013		1	240	1
BACB28AP06P016		1	160	2
BACB28AP06P073		1	200A	1
		1	280A	1
BACB28X6C035		1	282	1
BACB28X9C038		1	283	1
BACB30NN3K3		1	15	13
BACB30NN5K44		1	140	4
		1	220	2
BACB30NN5K47		1	180A	4
		1	260A	4
BACB30NT3K2		1	71	3
BACB30NU3K2		1	301B	5
BACB30VF08K2		1	40C	9
		1	55C	13
		1	70C	20
BACB30VF3K2		1	301A	5
BACB30VG10K44		1	140B	4
BACB30VG10K47		1	180C	4
		1	260C	4
BACN10JC08		1	42	9
		1	57	13
		1	70R	20

32-12-55

 ILLUSTRATED PARTS LIST
 01.1 Page 1004
 Dec 01/97


BOEING
 COMPONENT
 MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACN10JC3		1	25	13
		1	73	3
		1	301Q	5
BACN10JC5		1	150	4
		1	190	4
		1	230	2
		1	270	4
BACN10JD6ASU		1	810	1
BACR15BA4D		1	295	14
BACR15BA5AD3		1	40A	9
		1	55A	13
		1	70A	20
BACR15BB4D		1	300	14
BACR15FT5D		1	74	3
BACS40R038C038F		1	195	1
		1	275	1
BACS40R038E038F		1	195A	1
		1	275A	1
BACW10BP2NDP		1	41	9
		1	56	13
		1	70J	20
BAC27TLG0004		1	301J	5
		1	441A	1
		1	442	1
BAC27TLG004		1	600A	1
BRH10A08		1	42	9
		1	57	13
		1	70R	20
BRH10A3		1	25	13
		1	73	3
		1	301Q	5
H10-08BAC		1	42	9
		1	57	13
		1	70R	20

32-12-55

ILLUSTRATED PARTS LIST

01.1

Page 1005

Dec 01/97

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
H10-3BAC		1	25	13
		1	73	3
		1	301Q	5
MS27253F3		1	445	1
NAS1149D0563J		1	185A	4
NAS1149E0632P		1	265B	4
NAS1149E0663P		1	805	1
NAS1399MW6		1	302	1
NS202101-02		1	25	13
		1	73	3
		1	301Q	5
NS202101-82		1	42	9
		1	57	13
		1	70R	20
RMLH9075-3W		1	25	13
		1	73	3
		1	301Q	5
RMLH9075-82W		1	42	9
		1	57	13
		1	70R	20
T6S1032J		1	25	13
		1	73	3
		1	301Q	5
T6S832J		1	42	9
		1	57	13
		1	70R	20
VN303A02		1	25	13
		1	73	3
		1	301Q	5
VN303A82		1	42	9
		1	57	13
		1	70R	20
113T8201-17		1	60A	1
113T8201-18		1	65A	1

32-12-55

 ILLUSTRATED PARTS LIST
 01.1 Page 1006
 Dec 01/97


BOEING
 COMPONENT
 MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
113T8201-31		1	130G	1
113T8201-32		1	130K	1
113T8201-33		1	130N	1
113T8201-37		1	10B	1
113T8201-39		1	30A	1
113T8201-40		1	35A	1
113T8201-47SP		1	1D	RF
113T8201-48SP		1	5D	RF
113T8201-49SP		1	1E	RF
113T8201-5		1	45	1
113T8201-50SP		1	5E	RF
113T8201-51SP		1	1F	RF
113T8201-52SP		1	5F	RF
113T8201-53		1	51	1
113T8201-54		1	51A	1
113T8201-55		1	66	1
113T8201-56		1	66A	1
113T8201-57		1	60B	1
113T8201-58		1	65B	1
113T8201-59		1	45A	1
113T8201-6		1	50	1
113T8201-60		1	50A	1
113T8201-61		1	30B	1
113T8201-62		1	35B	1
113T8201-63		1	10C	1
113T8201-65		1	135C	2
113T8201-69SP		1	1G	RF
113T8201-70SP		1	5G	RF
113T8201-71SP		1	1H	RF
113T8201-72SP		1	5H	RF
113T8201-73SP		1	1J	RF
113T8201-74SP		1	5J	RF
113T8201-75SP		1	1K	RF
113T8201-76SP		1	5K	RF
113T8201-77G		1	1L	RF

32-12-55

ILLUSTRATED PARTS LIST

01.1

Page 1007

Dec 01/97

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
113T8201-78G		1	5L	RF
113T8202-10		1	355	1
		1	510	1
113T8202-11		1	325	1
		1	480	1
113T8202-12		1	330	1
		1	485	1
113T8202-13		1	370	1
		1	525	1
113T8202-14		1	375	1
		1	530	1
113T8202-15		1	380	1
		1	535	1
113T8202-16		1	385	1
		1	540	1
113T8202-17		1	390	1
		1	545	1
113T8202-18		1	395	1
		1	550	1
113T8202-19		1	400	1
		1	555	1
113T8202-20		1	405	1
		1	560	1
113T8202-21		1	410	1
		1	565	1
113T8202-22		1	415	1
		1	570	1
113T8202-23		1	420	1
		1	575	1
113T8202-24		1	425	1
		1	580	1
113T8202-37		1	370A	1
		1	525A	1
113T8202-38		1	375A	1
		1	530A	1

32-12-55

 ILLUSTRATED PARTS LIST
 01.1 Page 1008
 Dec 01/97


BOEING
 COMPONENT
 MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
113T8202-39		1	380A	1
		1	535A	1
113T8202-40		1	385A	1
		1	540A	1
113T8202-41		1	390A	1
		1	545A	1
113T8202-42		1	395A	1
		1	550A	1
113T8202-43		1	400A	1
		1	555A	1
113T8202-44		1	405A	1
		1	560A	1
113T8202-45		1	410A	1
		1	565A	1
113T8202-46		1	415A	1
		1	570A	1
113T8202-47		1	420A	1
		1	575A	1
113T8202-48		1	425A	1
		1	580A	1
113T8202-5		1	495	1
113T8202-51		1	460	1
113T8202-52		1	465	1
113T8202-53		1	360A	1
		1	515	1
113T8202-54		1	365A	1
		1	520	1
113T8202-6		1	500	1
113T8202-61		1	305A	1
113T8202-62		1	310A	1
113T8202-63		1	450	1
113T8202-64		1	455	1
113T8202-65		1	340A	1

32-12-55

 ILLUSTRATED PARTS LIST
 01.1 Page 1009
 Dec 01/97

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
113T8202-66		1	345A	1
113T8202-69		1	360B	1
113T8202-7		1	315	1
		1	470	1
113T8202-70		1	365B	1
113T8202-71		1	305B	1
113T8202-72		1	310B	1
113T8202-8		1	320	1
		1	475	1
113T8202-9		1	350	1
113T8202-9		1	505	1
113T8211-1		1	335	5
		1	490	5
113T8215-2		1	135	2
113T8215-5		1	165	2
113T8215-6		1	215B	1
113T8215-7		1	245B	1
113T8216-11		1	170B	1
113T8216-12		1	175B	1
113T8216-13		1	205B	1
113T8216-14		1	210B	1
113T8216-15		1	170D	1
113T8216-16		1	175D	1
113T8216-17		1	205C	1
113T8216-18		1	210C	1
113T8216-19		1	170E	1
113T8216-20		1	175E	1
113T8216-21		1	205D	1
113T8216-22		1	210D	1
113T8216-5		1	170A	1
113T8216-6		1	175A	1
113T8216-7		1	205A	1
113T8216-8		1	210A	1
113T8217-11		1	250B	1
113T8217-12		1	255B	1

32-12-55

 ILLUSTRATED PARTS LIST
 01.1 Page 1010
 Dec 01/97


BOEING
 COMPONENT
 MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
113T8217-13		1	285B	1
113T8217-14		1	290B	1
113T8217-15		1	250C	1
113T8217-16		1	255C	1
113T8217-17		1	285C	1
113T8217-18		1	290C	1
113T8217-19		1	250E	1
113T8217-20		1	255E	1
113T8217-21		1	285D	1
113T8217-22		1	290D	1
113T8217-23		1	250F	1
113T8217-24		1	255F	1
113T8217-25		1	287	1
113T8217-26		1	293	1
113T8218-1		1	215A	1
113T8218-2		1	245A	1
113T8219-1		1	135A	2
113T8219-2		1	165A	2
113T8219-4		1	135B	2
113T8219-5		1	165B	2
113T8221-1		1	305C	1
113T8221-2		1	310C	1
113T8221-31		1	305D	1
113T8221-32		1	310D	1
113T8221-57		1	305E	1
113T8221-58		1	310E	1
113T8223-63		1	131B	1
113T8223-64		1	132B	1
113T8223-65		1	131C	1
113T8223-66		1	132C	1
113T8224-3		1	303B	1
113T8224-4		1	304	1
96-02		1	25	13
		1	73	3
		1	301Q	5

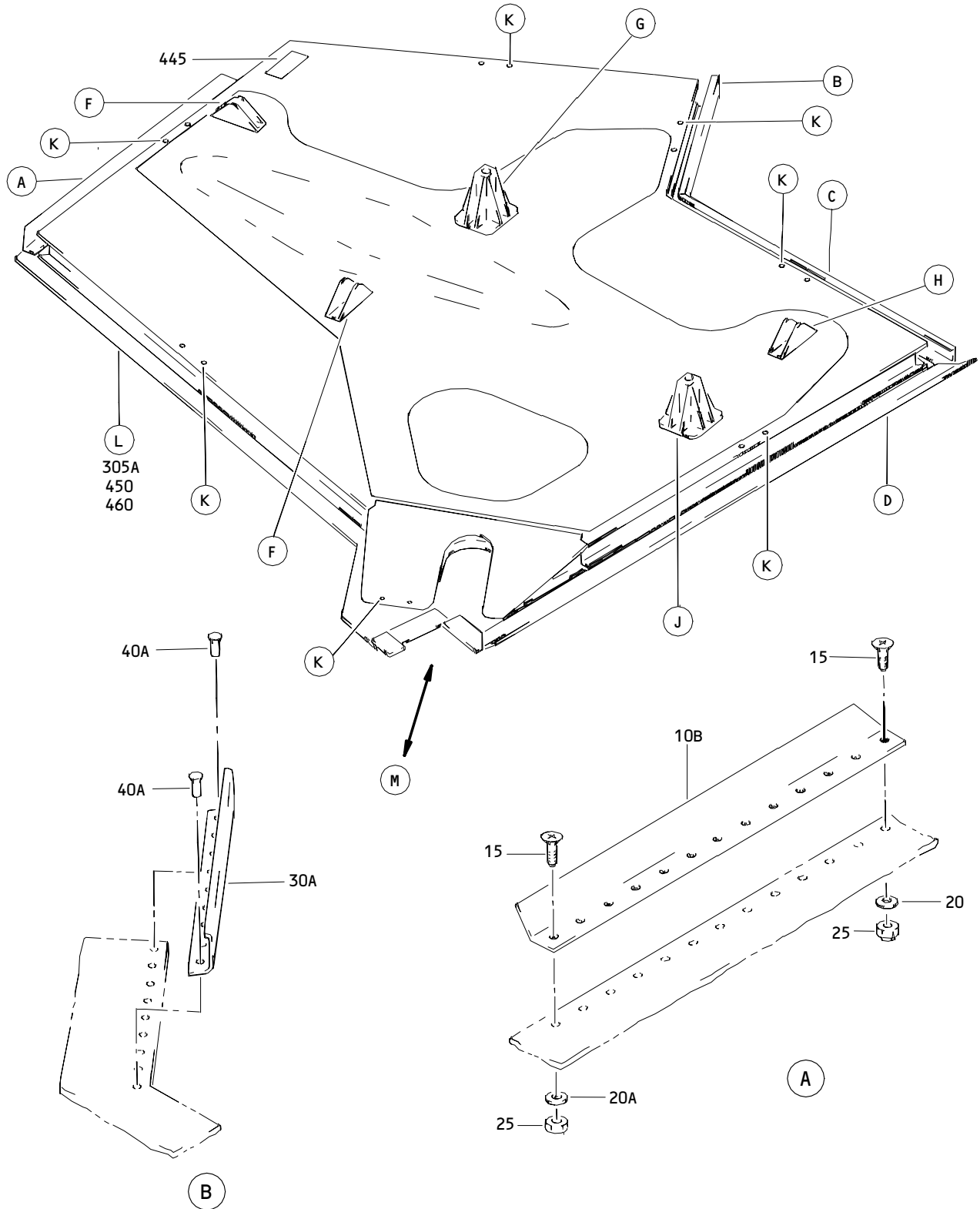
32-12-55

 ILLUSTRATED PARTS LIST
 01.1 Page 1011
 Dec 01/97

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
96-82		1	42	9
		1	57	13
		1	70R	20

32-12-55

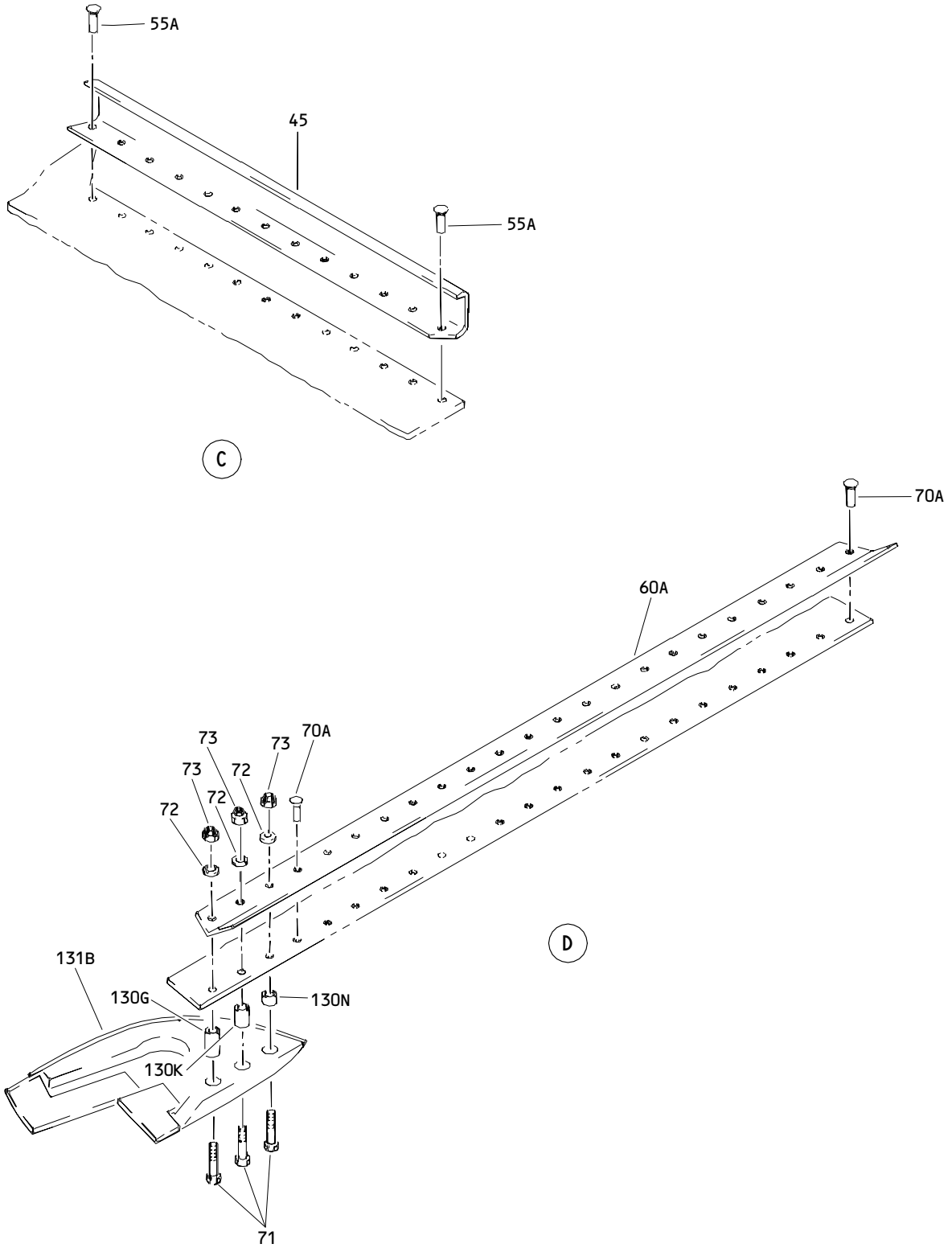
ILLUSTRATED PARTS LIST
01.1 Page 1012
Dec 01/97



Shock Strut Door Assembly
 Figure 1 (Sheet 1)

32-12-55

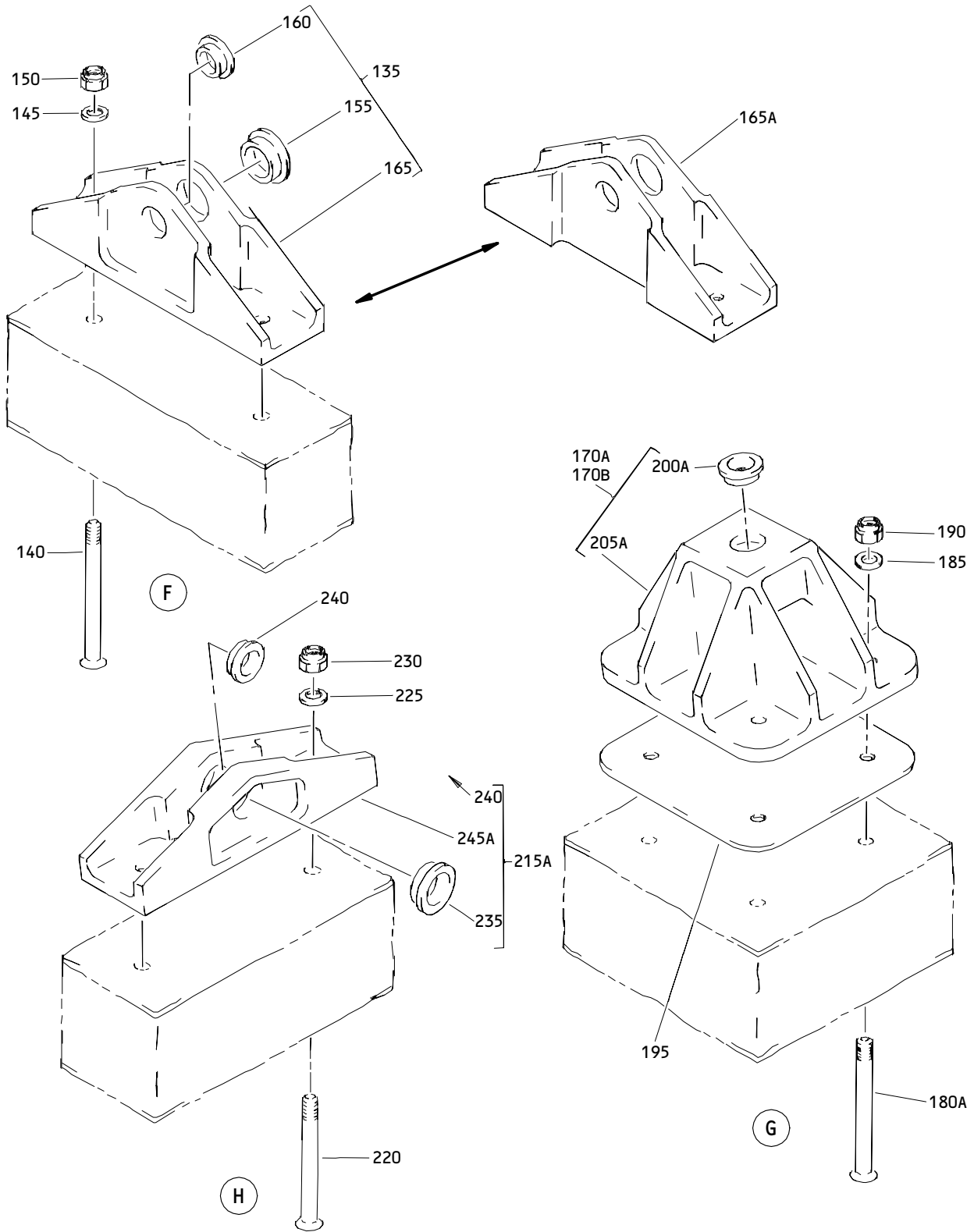
ILLUSTRATED PARTS LIST
 01.1 Page 1014
 Dec 01/97



Door Assembly Shock Strut
Figure 1 (Sheet 2)

32-12-55

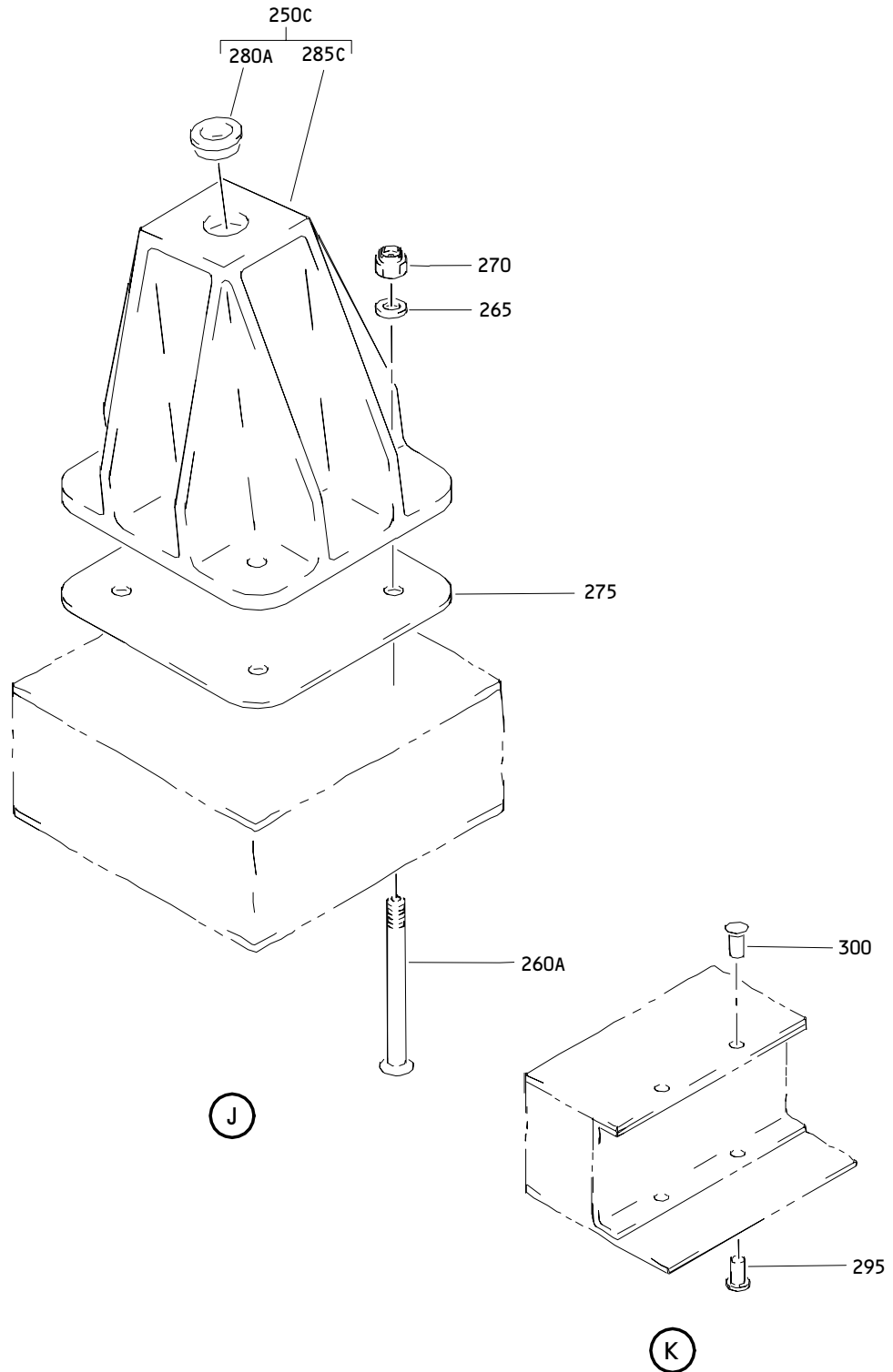
ILLUSTRATED PARTS LIST
01.1 Page 1015
Dec 01/97



Shock Strut Door Assembly
Figure 1 (Sheet 3)

32-12-55

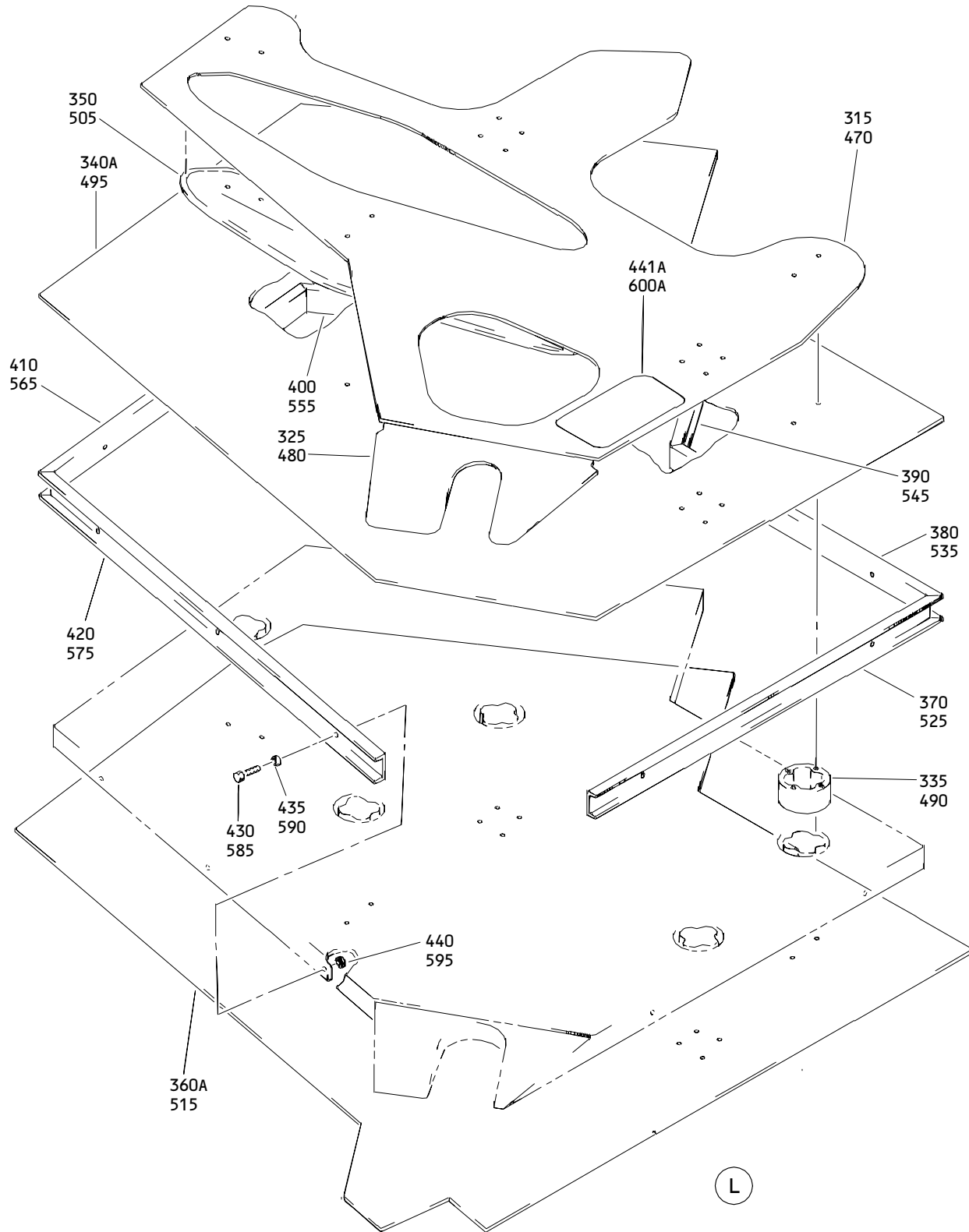
ILLUSTRATED PARTS LIST
 01.1 Page 1016
 Dec 01/97



Shock Strut Door Assembly
Figure 1 (Sheet 4)

32-12-55

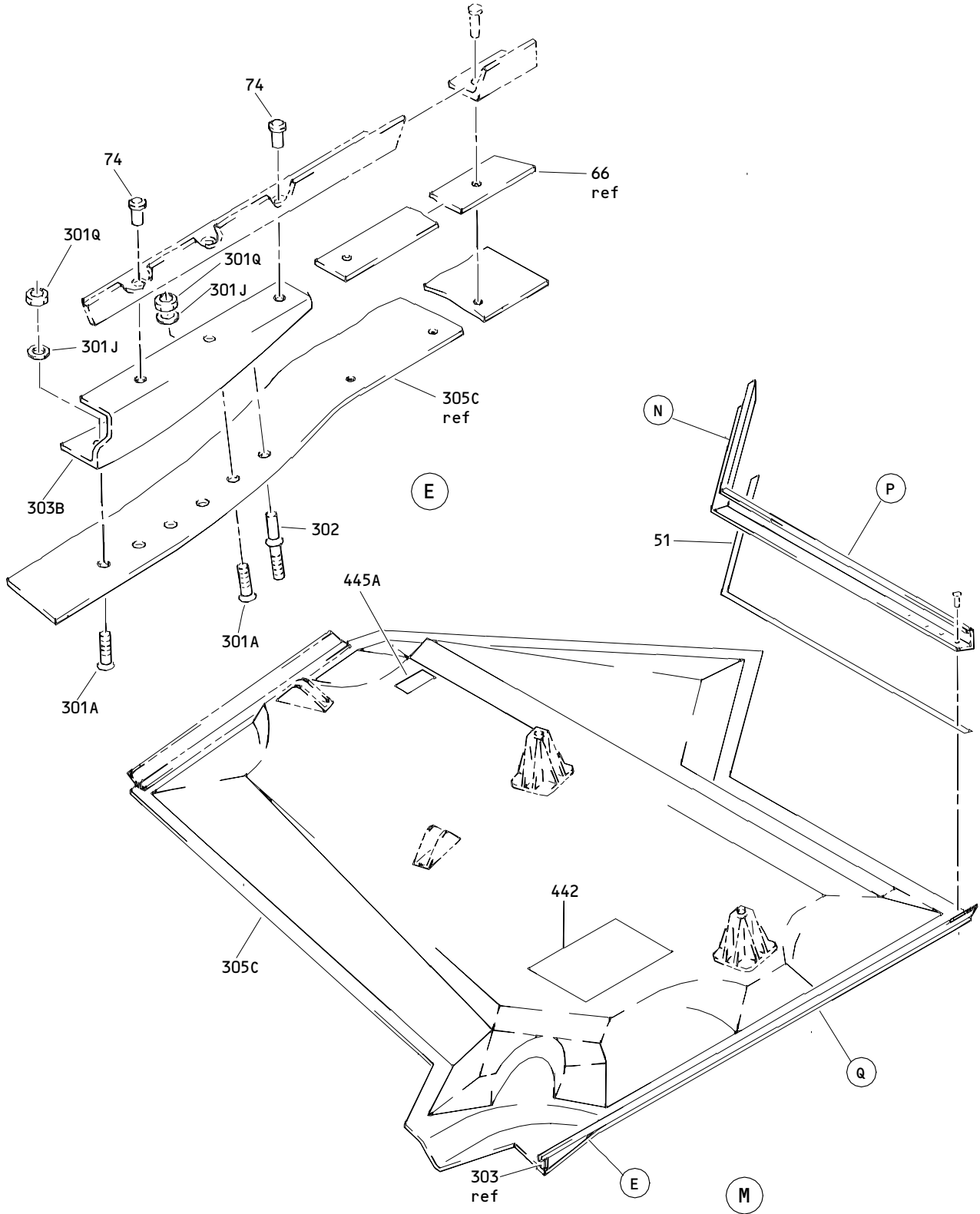
ILLUSTRATED PARTS LIST
01.1 Page 1017
Dec 01/97



Shock Strut Door Assembly
Figure 1 (Sheet 5)

32-12-55

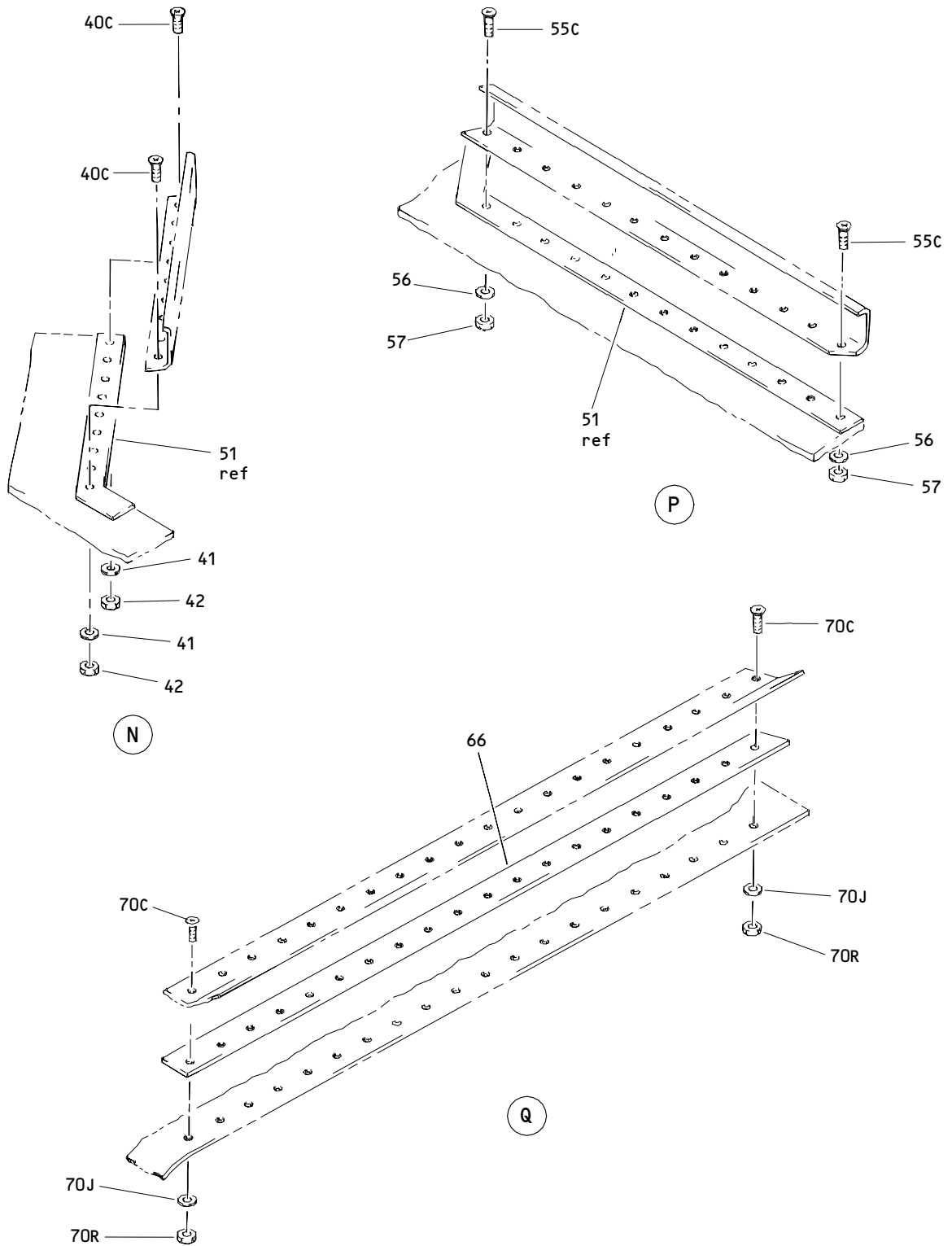
ILLUSTRATED PARTS LIST
01.1 Page 1018
Dec 01/97



Shock Strut Door Assembly
Figure 1 (Sheet 6)

32-12-55

ILLUSTRATED PARTS LIST
01.1 Page 1019
Dec 01/97



Shock Strut Door Assembly
 Figure 1 (Sheet 7)

32-12-55

ILLUSTRATED PARTS LIST
 01.1 Page 1020
 Dec 01/97


BOEING
 COMPONENT
 MAINTENANCE MANUAL

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-1	113T8201-1SP		DELETED		
-1A	113T8201-19SP		DELETED		
-1B	113T8201-43SP		DELETED		
-1C	113T8201-41		DELETED		
R -1D	113T8201-47SP		DOOR ASSY-SHOCK STRUT (LH)	A	RF
R -1E	113T8201-49SP		DOOR ASSY-SHOCK STRUT (LH)	C	RF
R -1F	113T8201-51SP		DOOR ASSY-SHOCK STRUT (LH) (PRE SB 767-32-0101)	E	RF
-1G	113T8201-69SP		DOOR ASSY-SHOCK STRUT (LH)	G	RF
-1H	113T8201-71SP		DOOR ASSY-SHOCK STRUT (LH) (POST SB 767-32-0101)	J	RF
-1J	113T8201-73SP		DOOR ASSY-SHOCK STRUT (LH) (PRE SB 767-32-0146)	L	RF
R -1K	113T8201-75SP		DOOR ASSY-SHOCK STRUT (LH) (POST SB 767-32-0146)	N	RF
R -1L	113T8201-77G		DOOR ASSY-SHOCK STRUT (LH)	Q	RF
-5	113T8201-2SP		DELETED		
-5A	113T8201-20SP		DELETED		
-5B	113T8201-44SP		DELETED		
-5C	113T8201-42		DELETED		
R -5D	113T8201-48SP		DOOR ASSY-SHOCK STRUT (RH)	B	RF
R -5E	113T8201-50SP		DOOR ASSY-SHOCK STRUT (RH)	D	RF
R -5F	113T8201-52SP		DOOR ASSY-SHOCK STRUT (RH) (PRE SB 767-32-0101)	F	RF
-5G	113T8201-70SP		DOOR ASSY-SHOCK STRUT (RH)	H	RF
-5H	113T8201-72SP		DOOR ASSY-SHOCK STRUT (RH) (POST SB 767-32-0101)	K	RF
-5J	113T8201-74SP		DOOR ASSY-SHOCK STRUT (RH) (PRE SB 767-32-0146)	M	RF
R -5K	113T8201-76SP		DOOR ASSY-SHOCK STRUT (RH) (POST SB 767-32-0146)	P	RF
R -5L	113T8201-78G		DOOR ASSY-SHOCK STRUT (RH)	R	RF
10	113T8201-9		DELETED		
10A	113T8201-16		DELETED		
R 10B	113T8201-37		.DEPRESSOR-SEAL	A-D	1
R -10C	113T8201-63		.DEPRESSOR-SEAL	E-R	1
-10D	113T8201-64		DELETED		
			ATTACHING PARTS		
R 15	BACB30NN3K3		.BOLT		13
20	AN960PD10L		DELETED		
R 20A	AN960JD10L		.WASHER		13

32-12-55

ILLUSTRATED PARTS LIST

01.1

Page 1021

Dec 01/97

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 01-25	H10-3BAC		.NUT- (V15653) (SPEC BACN10JC3) (OPT NS202101-02 (V80539)) (OPT RMLH9075-3W (V72962)) (OPT T6S1032J (V71087)) (OPT VN303A02 (V92215)) (OPT 96-02 (V80539)) (OPT BRH10A3 (V52828)) -----*-----		13
R 30	113T8201-7		DELETED		
R 30A	113T8201-39		.DEPRESSOR-SEAL	A,C	1
R -30B	113T8201-61		.DEPRESSOR-SEAL	E,G,J L,N, Q	1
R -35	113T8201-8		DELETED		
R -35A	113T8201-40		.DEPRESSOR-SEAL	B,D	1
R -35B	113T8201-62		.DEPRESSOR-SEAL	F,H,K M,P, R	1
R 40	BACR15BA3AD9		ATTACHING PARTS DELETED		
R 40A	BACR15BA5AD3		.RIVET	A-D	9
R -40B	BACR15CE5M		DELETED		
R 40C	BACB30VF08K2		.BOLT	E-R	9
R 41	BACW10BP2NDP		.WASHER	E-P	9

32-12-55

 ILLUSTRATED PARTS LIST
 01.1 Page 1022
 Dec 01/97


BOEING
 COMPONENT
 MAINTENANCE MANUAL

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 01-42	H10-08BAC		.NUT- (V15653) (SPEC BACN10JC08) (OPT NS202101-82 (V80539)) (OPT RMLH9075-82W (V72962)) (OPT T6S832J (V71087)) (OPT VN303A82 (V92215)) (OPT 96-82 (V80539)) (OPT BRH10A08 (V52828)) (OPT T6S832J (V11815)) -----*-----	E-R	9
R 45	113T8201-5		.DEPRESSOR-SEAL	A,C	1
R -45A	113T8201-59		.DEPRESSOR-SEAL	E,G,J ,L,N, Q	1
R -50	113T8201-6		.DEPRESSOR-SEAL	B,D	1
R -50A	113T8201-60		.DEPRESSOR-SEAL	F,H,K ,M,P, R	1
51	113T8201-53		.PROTECTOR-EDGE	E,G,J ,L,N, Q	1

32-12-55

 ILLUSTRATED PARTS LIST
 01.1 Page 1023
 Dec 01/97

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 01-51A	113T8201-54		.PROTECTOR-EDGE	F,H,K M,P, R	1
			ATTACHING PARTS DELETED		
R 55	BACR15BA3AD9		.RIVET	A-D	13
R 55A	BACR15BA5AD3		DELETED		
R -55B	BACR15CE5M		.BOLT	E-R	13
R 55C	BACB30VF08K2		.WASHER	E-R	13
R 56	BACW10BP2NDP		.NUT-	E-R	13
R 57	H10-08BAC		(V15653) (SPEC BACN10JC08) (OPT NS202101-82 (V80539)) (OPT RMLH9075-82W (V72962)) (OPT T6S832J (V71087)) (OPT VN303A82 (V92215)) (OPT 96-82 (V80539)) (OPT BRH10A08 (V52828)) (OPT T6S832J (V11815))		
			-----*		
R 60	113T8201-3		DELETED		
R 60A	113T8201-17		.DEPRESSOR-SEAL	A,C	1
R -60B	113T8201-57		.DEPRESSOR-SEAL	E,G,J L,N, Q	1
			DELETED		
R -65	113T8201-4		.DEPRESSOR-SEAL	B,D	1
R -65A	113T8201-18		.DEPRESSOR-SEAL	F,H,K M,P, R	1
R -65B	113T8201-58				

32-12-55

 ILLUSTRATED PARTS LIST
 01.1 Page 1024
 Dec 01/97


BOEING
 COMPONENT
 MAINTENANCE MANUAL

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 01-66	113T8201-55		.PROTECTOR-EDGE	E,G,J L,N, Q	1
R -66A	113T8201-56		.PROTECTOR-EDGE	F,H,K M,P, R	1
R 70	BACR15BA3AD9		ATTACHING PARTS DELETED		
R 70A	BACR15BA5AD3		.RIVET	A-D	20
R -70B	BACR15CE5M		DELETED		
R 70C	BACB30VF08K2		.BOLT	E-R	20
R 70J	BACW10BP2NDP		.WASHER	E-R	20
R 70R	H10-08BAC		.NUT- (V15653) (SPEC BACN10JC08) (OPT NS202101-82 (V80539)) (OPT RMLH9075-82W (V72962)) (OPT T6S832J (V71087)) (OPT VN303A82 (V92215)) (OPT 96-82 (V80539)) (OPT BRH10A08 (V52828)) (OPT T6S832J (V11815))	E-R	20

32-12-55

ILLUSTRATED PARTS LIST

01.1

Page 1025

Dec 01/97

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R R R	01- 71 72 73	BACB30NT3K2 AN960JD10 H10-3BAC	.BOLT .WASHER .NUT- (V15653) (SPEC BACN10JC3) (OPT NS202101-02 (V80539)) (OPT RMLH9075-3W (V72962)) (OPT T6S1032J (V71087)) (OPT VN303A02 (V92215)) (OPT 96-02 (V80539)) (OPT BRH10A3 (V52828))	A-D A-D A-D	3 3 3
	74	BACR15FT5D	.RIVET- (SIZE DETERMINE ON INST) -----*	E-R	3
	75	113T8201-11	DELETED ATTACHING PARTS		
	80	BACB30NN3K4	DELETED		
	85	H10-3BAC	DELETED		
	90	113T8201-14	DELETED		
	95	113T8201-12	DELETED		
	100	BACB30NN3K4	DELETED		
	105	H10-3BAC	DELETED		
	110	113T8201-15	DELETED		
	115	113T8201-13	DELETED		
	120	BACB30NN3K4	DELETED		
	125	AN960PD10L	DELETED		
	130	H10-3BAC	DELETED		

32-12-55

 ILLUSTRATED PARTS LIST
 01.1 Page 1026
 Dec 01/97


BOEING
 COMPONENT
 MAINTENANCE MANUAL

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
R 130G	113T8201-31		.PLUG	A-D	1
R 130K	113T8201-32		.PLUG	A-D	1
R 130N	113T8201-33		.PLUG	A-D	1
131	113T8223-1		DELETED		
131A	113T8223-51		DELETED		
R 131B	113T8223-63		.FAIRING	A	1
R -131C	113T8223-65		.FAIRING	C	1
-132	113T8223-2		DELETED		
-132A	113T8223-52		DELETED		
R -132B	113T8223-64		.FAIRING	B	1
R -132C	113T8223-66		.FAIRING	D	1
132G	BACB30NN3K2		DELETED		
132H	AN960PD10L		DELETED		
132J	H10-3BAC		DELETED		
132K	113T8223-41		DELETED		
132L	113T8223-43		DELETED		
133	113T8223-15		DELETED		
133A	113T8223-37		DELETED		
134	113T8223-17		DELETED		
134A	113T8223-39		DELETED		
134G	113T8223-49		DELETED		
-134H	113T8223-50		DELETED		
R 135	113T8215-2		.FITTING ASSY- (OPT ITEM 135A)	A-D	2
R -135A	113T8219-1		.FITTING ASSY- (OPT ITEM 135)	A-D	2
R -135B	113T8219-4		.FITTING ASSY- (OPT ITEM 135C)	E-R	2
R -135C	113T8201-65		.FITTING ASSY- (OPT ITEM 135B)	E-R	2
-135G	113T8219-1		DELETED		
R 140	BACB30NN5K44		.BOLT	A-D	4
-140A	HL860VAP10-44		DELETED		
-140B	BACB30VG10K44		.BOLT	E-R	4
R 145	AN960PD516		.WASHER		4
R 150	BACN10JC5		.NUT		4
			-----*		
R 155	BACB28AM09B016A		..BUSHING		1
R 160	BACB28AP06P016		..BUSHING		1

32-12-55

 ILLUSTRATED PARTS LIST
 01.1 Page 1027
 Dec 01/97



COMPONENT
MAINTENANCE MANUAL

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 01-165	113T8215-5		..FITTING- (USED ON ITEMS 135, 135C)		1
R 165A	113T8219-2		..FITTING- (USED ON ITEM 135A)	A-D	1
R -165B	113T8219-5		..FITTING- (USED ON ITEM 135B)	E-R	1
R 170A	113T8216-1		DELETED		
R 170A	113T8216-5		.FITTING ASSY- (OPT ITEM 170B)	A,C	1
R 170B	113T8216-11		.FITTING ASSY- (OPT ITEM 170A)	A,C	1
R -170C	113T8216-5		DELETED		
R -170D	113T8216-15		.FITTING ASSY- (PRE SB 767-32-0146)	E,G,J ,L	1
R -170E	113T8216-19		.FITTING ASSY- (POST SB 767-32-0146)	N,Q	1
R -175A	113T8216-2		DELETED		
R -175A	113T8216-6		.FITTING ASSY- (OPT ITEM 175B)	B,D	1
R -175B	113T8216-12		.FITTING ASSY- (OPT ITEM 175A)	B,D	1
R -175C	113T8216-6		DELETED		
R -175D	113T8216-16		.FITTING ASSY- (PRE SB 767-32-0146)	F,H,K ,M	1
R -175E	113T8216-20		.FITTING ASSY- (POST SB 767-32-0146)	P,R	1
R 180A	BACB30NN5K44		ATTACHING PARTS DELETED		
R 180A	BACB30NN5K47		.BOLT	A-D	4
R -180B	HL860VAP10-47		DELETED		
R -180C	BACB30VG10K47		.BOLT	E-R	4
R 185	AN960PD516		.WASHER- (PRE SB 767-32-0146)		4
R -185A	NAS1149D0563J		.WASHER- (POST SB 767-32-0146)		4
R 190	BACN10JC5		.NUT		4
R 195	BACS40R038C038F		.SHIM	A-D	1
R -195A	BACS40R038E038F		.SHIM	E-R	1
R 200A	BACB28AP06P030		-----*----- DELETED		
R 200A	BACB28AP06P073		..BUSHING		1
R 205A	113T8216-3		DELETED		
R 205A	113T8216-7		..FITTING- (USED ON ITEM 170A)	A,C	1

32-12-55


BOEING
 COMPONENT
 MAINTENANCE MANUAL

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 01- -205B	113T8216-13		..FITTING- (USED ON ITEM 170B)	A,C	1
R -205C	113T8216-17		..FITTING	E,G,J L	1
R -205D	113T8216-21		..FITTING	N,Q	1
-210	113T8216-4		DELETED		
R -210A	113T8216-8		..FITTING- (USED ON ITEM 175A)	B,D	1
R -210B	113T8216-14		..FITTING- (USED ON ITEM 175B)	B,D	1
R -210C	113T8216-18		..FITTING	F,H,K M	1
R -210D	113T8216-22		..FITTING	P,R	1
215	113T8215-1		DELETED		
R 215A	113T8218-1		.FITTING ASSY- (OPT ITEM 215B)	A-D	1
R -215B	113T8215-6		.FITTING ASSY- (OPT ITEM 215A)	A-D	1
-215C	113T8218-1		DELETED		
R 220	BACB30NN5K44		ATTACHING PARTS		
R 225	AN960PD516		.BOLT	A-D	2
R 230	BACN10JC5		.WASHER	A-D	2
			.NUT	A-D	2
			-----*-----		
R 235	BACB28AM06B013A		..BUSHING	A-D	1
R 240	BACB28AP04P013		..BUSHING	A-D	1
245	113T8215-4		DELETED		
R 245A	113T8218-2		..FITTING- (USED ON ITEM 215A)	A-D	1
R -245B	113T8215-7		..FITTING- (USED ON ITEM 215B)	A-D	1

32-12-55

ILLUSTRATED PARTS LIST

01.1

Page 1029

Dec 01/97

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
	250	113T8217-1	DELETED		
	250A	113T8217-5	DELETED		
R	-250B	113T8217-11	.FITTING ASSY- (OPT ITEM 250C)	A,C	1
R	250C	113T8217-15	.FITTING ASSY- (OPT ITEM 250B)	A,C	1
	-250D	113T8217-15	DELETED		
R	-250E	113T8217-19	.FITTING ASSY- (PRE SB 767-32-0101)	E	1
	-250F	113T8217-23	.FITTING ASSY	G,J,L N,Q	1
	-250G	113T8217-23	.FITTING ASSY- (POST SB 767-32-0101)	J	1
	-255	113T8217-2	DELETED		
	-255A	113T8217-6	DELETED		
R	-255B	113T8217-12	.FITTING ASSY- (OPT ITEM 255C)	B,D	1
R	-255C	113T8217-16	.FITTING ASSY- (OPT ITEM 255B)	B,D	1
	-255D	113T8217-16	DELETED		
R	-255E	113T8217-20	.FITTING ASSY- (PRE SB 767-32-0101)	F	1
	-255F	113T8217-24	.FITTING ASSY	H,K,M P,R	1
	-255G	113T8217-24	.FITTING ASSY- (POST SB 767-32-0101)	J	1
	260	BACB30NN5K44	ATTACHING PARTS		
R	260A	BACB30NN5K47	DELETED		
	-260B	HL860VAP10-47	.BOLT	A-D	4
	-260C	BACB30VG10K47	DELETED		
R	265	AN960PD516	.BOLT	E-R	4
			.WASHER- (PRE SB 767-32-0101)	A-H, K-R	4

32-12-55

 ILLUSTRATED PARTS LIST
 01.1 Page 1030
 Dec 01/97


BOEING
 COMPONENT
 MAINTENANCE MANUAL

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 01- -265A	AN960PD516		.WASHER- (OPT ITEM 265B) (POST SB 767-32-0101)	J	4
R -265B	NAS1149E0632P		.WASHER- (OPT ITEM 265A) (POST SB 767-32-0101)	J	4
R 270	BACN10JC5		.NUT		4
R 275	BACS4OR038C038F		.SHIM- (POST SB 767-32-0101)	A-D	1
R -275A	BACS4OR038E038F		.SHIM- (PRE SB 767-32-0101)	E-R	1
			-----*		
R 280 280A	BACB28AP06P030 BACB28AP06P073		DELETED ..BUSHING- (USED ON ITEMS 250B, 250C, 250E, 255B, 255C, 255E)	A-F	1
-280B 282	BACB2AP06P073 BACB28X6C035		DELETED ..BUSHING- (USED ON ITEMS 250F, 250G, 255F, 255G)	E-R	1
	283	BACB28X9C038	..BUSHING- (USED ON ITEMS 250F, 250G, 255F, 255G)	E-R	1
	285	113T8217-3	DELETED		
	285A	113T8217-7	DELETED		
R -285B	113T8217-13		..FITTING- (USED ON ITEM 250B)	A,B	1
R 285C	113T8217-17		..FITTING- (USED ON ITEM 250C)	A,C	1
R -285D	113T8217-21		..FITTING- (USED ON ITEM 250E)	E	1

32-12-55

 ILLUSTRATED PARTS LIST
 01.1 Page 1031
 Dec 01/97

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-287	113T8217-25		..FITTING- (USED ON ITEMS 250F, 250G)	E,G,J ,L,N, Q	1
-290	113T8217-4		DELETED		
-290A	113T8217-8		DELETED		
R -290B	113T8217-14		..FITTING- (USED ON ITEM 255B)	B,D	1
R -290C	113T8217-18		..FITTING- (USED ON ITEM 255C)	B,D	1
R -290D	113T8217-22		..FITTING- (USED ON ITEM 255E)	F	1
-293	113T8217-26		..FITTING- (USED ON ITEMS 255F, 255G)	F,H,K ,M,P, R	1
295	BACR15BA4D		.RIVET- (SIZE DETERMINE ON INST)	A-D	14
300	BACR15BB4D		.RIVET- (SIZE DETERMINE ON INST)	A-D	14
301	BACR15CE6M		DELETED		
R 301A	BACB30VF3K2		.BOLT- (OPT ITEM 301B)	E-R	5
-301B	BACB30NU3K2		.BOLT- (OPT ITEM 301A)	E-R	5
R 301J	BACW10BP2NDP		.WASHER	E-R	5
R 301Q	H10-3BAC		.NUT- (V15653) (SPEC BACN10JC3) (OPT NS202101-02 (V80539)) (OPT RMLH9075-3W (V72962)) (OPT T6S1032J (V71087)) (OPT VN303A02 (V92215)) (OPT 96-02 (V80539)) (OPT BRH10A3 (V52828))	E-R	5

32-12-55

 ILLUSTRATED PARTS LIST
 01.1 Page 1032
 Dec 01/97


BOEING
 COMPONENT
 MAINTENANCE MANUAL

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 01-302	NAS1399MW6		.RIVET- (SIZE DETERMINE ON INST)	E-R	1
R -303A	113T8224-1		DELETED		
R 303B	113T8224-2		DELETED		
R -304	113T8224-3		.CHANNEL	E,G,J L,N, Q	1
R -304	113T8224-4		.CHANNEL	F,H,K M,P, R	1
R 305	113T8202-1		DELETED		
R 305A	113T8202-61		.PANEL ASSY- (OPT ITEM 450)	A	1
R -305B	113T8202-71		.PANEL ASSY	C	1
R 305C	113T8221-1		.PANEL ASSY	E,J	1
R -305D	113T8221-31		.PANEL ASSY	G	1
R -305E	113T8221-57		.PANEL ASSY	L,N,Q	1
R -310	113T8202-2		DELETED		
R -310A	113T8202-62		.PANEL ASSY- (OPT ITEM 455)	B	1
R -310B	113T8202-72		.PANEL ASSY	D	1
R -310C	113T8221-2		.PANEL ASSY	F,K	1
R -310D	113T8221-32		.PANEL ASSY	H	1
R -310E	113T8221-58		.PANEL ASSY	M,P,R	1
R 315	113T8202-7		..DOUBLER	A,C	1
R -320	113T8202-8		..DOUBLER	B,D	1
R 325	113T8202-11		..CORNER-PAN	A,C	1
R -330	113T8202-12		..CORNER-PAN	B,D	1
R 335	113T8211-1		..FITTING		5

32-12-55

ILLUSTRATED PARTS LIST

01.1

Page 1033

Dec 01/97

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-			DELETED		
R 340	113T8202-5		DELETED		
R 340A	113T8202-65		..PANEL-INNER	A,C	1
-345	113T8202-6		DELETED		
R -345A	113T8202-66		..PANEL-INNER	B,D	1
R 350	113T8202-9		..PAN CENTER	A,C	1
R -355	113T8202-10		..PAN CENTER	B,D	1
360	113T8202-3		DELETED		
R 360A	113T8202-53		..PANEL-OUTER	A	1
R -360B	113T8202-69		..PANEL-OUTER	C	1
-365	113T8202-4		DELETED		
R -365A	113T8202-54		..PANEL-OUTER	B	1
R -365B	113T8202-70		..PANEL-OUTER	D	1
R 370	113T8202-13		..PROTECTOR-EDGE	A,C	1
			(OPT ITEM 370A)		
R -370A	113T8202-37		..PROTECTOR-EDGE	A,C	1
			(OPT ITEM 370)		
R -375	113T8202-14		..PROTECTOR-EDGE	B,D	1
			(OPT ITEM 375A)		
R -375A	113T8202-38		..PROTECTOR-EDGE	B,D	1
			(OPT ITEM 375)		
R 380	113T8202-15		..PROTECTOR-EDGE	A,C	1
			(OPT ITEM 380A)		
R -380A	113T8202-39		..PROTECTOR-EDGE	A,C	1
			(OPT ITEM 380)		
R -385	113T8202-16		..PROTECTOR-EDGE	B,D	1
			(OPT ITEM 385A)		
R -385A	113T8202-40		..PROTECTOR-EDGE	B,D	1
			(OPT ITEM 385)		
R 390	113T8202-17		..PROTECTOR-EDGE	A,C	1
			(OPT ITEM 390A)		
R -390A	113T8202-41		..PROTECTOR-EDGE	A,C	1
			(OPT ITEM 390)		
R -395	113T8202-18		..PROTECTOR-EDGE	B,D	1
			(OPT ITEM 395A)		

32-12-55

 ILLUSTRATED PARTS LIST
 01.1 Page 1034
 Dec 01/97


BOEING
 COMPONENT
 MAINTENANCE MANUAL

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 01-395A	113T8202-42		..PROTECTOR-EDGE (OPT ITEM 395)	B,D	1
R 400	113T8202-19		..PROTECTOR-EDGE (OPT ITEM 400A)	C	1
R -400A	113T8202-43		..PROTECTOR-EDGE (OPT ITEM 400)	C	1
R -400B	113T8202-19		..PROTECTOR-EDGE	A	1
R -405	113T8202-20		..PROTECTOR-EDGE (OPT ITEM 405A)	D	1
R -405A	113T8202-44		..PROTECTOR-EDGE (OPT ITEM 405)	D	1
R -405B	113T8202-20		..PROTECTOR-EDGE	B	1
R 410	113T8202-21		..PROTECTOR-EDGE (OPT ITEM 410A)	A,C	1
R -410A	113T8202-45		..PROTECTOR-EDGE (OPT ITEM 410)	A,C	1
R -415	113T8202-22		..PROTECTOR-EDGE (OPT ITEM 415A)	B,D	1
R -415A	113T8202-46		..PROTECTOR-EDGE (OPT ITEM 415)	B,D	1
R 420	113T8202-23		..PROTECTOR-EDGE (OPT ITEM 420A)	A,C	1
R -420A	113T8202-47		..PROTECTOR-EDGE (OPT ITEM 420)	A,C	1
R -425	113T8202-24		..PROTECTOR-EDGE (OPT ITEM 425A)	B,D	1
R -425A	113T8202-48		..PROTECTOR-EDGE (OPT ITEM 425) ATTACHING PARTS	B,D	1
R 430	AN3DD3A		..BOLT	A-D	13
R 435	AN960PD10L		..WASHER	A-D	13
R 440	AN315D3R		..NUT -----*-----	A-D	13
R 441	BAC27TLG0001		DELETED		
R 441A	BAC27TLG0004		..NAMEPLATE	A-D	1
R 442	BAC27TLG004		..NAMEPLATE	E-R	1
R 445	MS27253F3		..PLATE	A-D	1
R 445A	MS27253F3		..PLATE	E-R	1
R 450	113T8202-63		..PANEL ASSY-(REWORK) (OPT ITEM 305A)	A	1
R -455	113T8202-64		..PANEL ASSY-(REWORK) (OPT ITEM 310A)	B	1

32-12-55

 ILLUSTRATED PARTS LIST
 01.1 Page 1035
 Dec 01/97

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
R 460	113T8202-51		..PANEL ASSY	A	1
R -465	113T8202-52		..PANEL ASSY	B	1
R 470	113T8202-7		...DOUBLER	A	1
R -475	113T8202-8		...DOUBLER	B	1
R 480	113T8202-11		...CORNER-PAN	A	1
R -485	113T8202-12		...CORNER-PAN	B	1
R 490	113T8211-1		...FITTING	A,B	5
R 495	113T8202-5		...PANEL-INNER	A	1
R -500	113T8202-6		...PANEL-INNER	B	1
R 505	113T8202-9		...PAN CENTER	A	1
R -510	113T8202-10		...PAN CENTER	B	1
R 515	113T8202-53		...PANEL-OUTER	A	1
R -520	113T8202-54		...PANEL-OUTER	B	1
R 525	113T8202-13		...PROTECTOR-EDGE (OPT ITEM 525A)	A	1
R -525A	113T8202-37		...PROTECTOR-EDGE (OPT ITEM 525)	A	1
R -530	113T8202-14		...PROTECTOR-EDGE (OPT ITEM 530A)	B	1
R -530A	113T8202-38		...PROTECTOR-EDGE (OPT ITEM 530)	B	1
R 535	113T8202-15		...PROTECTOR-EDGE (OPT ITEM 535A)	A	1
R -535A	113T8202-39		...PROTECTOR-EDGE (OPT ITEM 535A)	A	1
R -540	113T8202-16		...PROTECTOR-EDGE (OPT ITEM 540A)	B	1
-540A	113T8202-40		...PROTECTOR-EDGE (OPT ITEM 540)	B	1
R 545	113T8202-17		...PROTECTOR-EDGE (OPT ITEM 545A)	A	1
R -545A	113T8202-41		...PROTECTOR-EDGE (OPT ITEM 545)	A	1
R -550	113T8202-18		...PROTECTOR-EDGE (OPT ITEM 550A)	B	1
R -550A	113T8202-42		...PROTECTOR-EDGE (OPT ITEM 550)	B	1
R 555	113T8202-19		...PROTECTOR-EDGE (OPT ITEM 555A)	A	1
R -555A	113T8202-43		...PROTECTOR-EDGE (OPT ITEM 555)	A	1

32-12-55

 ILLUSTRATED PARTS LIST
 01.1 Page 1036
 Dec 01/97


BOEING
 COMPONENT
 MAINTENANCE MANUAL

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 01-560	113T8202-20		...PROTECTOR-EDGE (OPT ITEM 560A)	B	1
R -560A	113T8202-44		...PROTECTOR-EDGE (OPT ITEM 560)	B	1
R 565	113T8202-21		...PROTECTOR-EDGE (OPT ITEM 565A)	A	1
R -565A	113T8202-45		...PROTECTOR-EDGE (OPT ITEM 565)	A	1
R -570	113T8202-22		...PROTECTOR-EDGE (OPT ITEM 570A)	B	1
R -570A	113T8202-46		...PROTECTOR-EDGE (OPT ITEM 570)	B	1
R 575	113T8202-23		...PROTECTOR-EDGE (OPT ITEM 575A)	A	1
R -575A	113T8202-47		...PROTECTOR-EDGE (OPT ITEM 575)	A	1
R -580	113T8202-24		...PROTECTOR-EDGE (OPT ITEM 580A)	B	1
R -580A	113T8202-48		...PROTECTOR-EDGE (OPT ITEM 580) ATTACHING PARTS	B	1
R 585	AN3DD3A		...BOLT	A,B	13
R 590	AN960PD10L		...WASHER	A,B	13
R 595	AN315D3R		...NUT -----*-----	A,B	13
R 600	BAC27TLG0004		DELETED		
R 600A	BAC27TLG004		...NAMEPLATE	A,B	1
R -805	NAS1149E0663P		INSTALLATION PARTS WASHER- (POST SB 767-32-0101)		1
R 810	BACN10JD6ASU		NUT- (POST SB 767-32-0101)		1

32-12-55

 ILLUSTRATED PARTS LIST
 01.1 Page 1037
 Dec 01/97