

 **BOEING**
COMPONENT
MAINTENANCE MANUAL

TO: ALL HOLDERS OF AFT NOSE LANDING GEAR DOOR STRUT ASSEMBLY COMPONENT
MAINTENANCE MANUAL 32-21-60

REVISION NO. 5 DATED JUL 01/04

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

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1
702-704

Incorporated 767-SL-52-036 to make sure lockwire is installed as specified in SOPM 20-50-02.

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Added clarifications and updated callouts.

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AFT NOSE LANDING GEAR DOOR STRUT ASSEMBLY

PART NUMBERS 141T6963-4 THRU -7

COMPONENT MAINTENANCE MANUAL
WITH
ILLUSTRATED PARTS LIST

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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



TEMPORARY REVISION AND SERVICE BULLETIN RECORD

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVE	DATE OF INCORPORATION INTO MANUAL
32-18 32-18, REV 1		PRR B13100-12 767-SL-52-036	JUL 10/84 APR 10/85 SEP 01/96 JUL 01/04

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* [1] Special instructions are not necessary. Use standard industry practices and the instructions in SOPM 20-30-01 and SOPM 20-30-03.

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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.

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INTRODUCTION

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AFT NOSE LANDING GEAR DOOR STRUT ASSEMBLY

DESCRIPTION AND OPERATION

1. The aft nose landing gear door strut assembly includes rod ends, bushings, bearings, bearing housing, tube, nuts and washers. The strut connects the aft door to the nose landing gear to open or close the door during gear extension or retraction.

2. Leading Particulars (approximate)

Length -- 19 inches

Diameter -- 2 inches

Weight -- 2 pounds

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DESCRIPTION & OPERATION

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DISASSEMBLY

NOTE: Disassemble this component only as necessary for fault isolation, to find the serviceability of parts, to do repairs and to put the unit back in serviceable condition.

1. Parts Replacement

NOTE: These parts are recommended for replacement. Replacement of other parts can be by in-service experience.

- A. Lockwire
- B. Ring (85)

2. Disassembly (IPL Fig. 1)

- A. Remove all lockwire
- B. Loosen nuts (30, 35) on rod ends (10, 15). Remove rod ends (10, 15), washers (40, 42, 45) as applicable, and nuts (30, 35). Do not remove bushings or bearing from rod ends.
- C. Turn the bearing (110) shaft to align the hole with the notch in the housing (114). Put a pin (1/8-diameter, 2 inches long) in the shaft hole to hold the shaft.
- D. Loosen nut (30) on bearing (110) shaft, then unscrew tube (120) and shaft. Separate tube (120) and rotary (50). Remove nut (30), washer (45). Do not disassemble tube assembly (120). Its parts are welded together.
- E. Rotary Assembly
 - (1) Loosen nut (60). Turn the nut up the threads to let you disengage the locking device (65) halves.
 - (2) Loosen and remove nut (55), locking device (65), nut (60).
 - (3) Remove setscrew (70) and washer (75).
 - (4) Remove pin from bearing (110) shaft. Slide bearing (110) out of housing (115). Remove washers (90, 95) and shim (105). Make a note of the thickness of shim (105) to help during assembly.

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- (5) Remove bushing (100) from housing (115).
- (6) Remove the ring (85) from the small diameter bore of the housing.
Do not remove the lube fitting (80) unless necessary for repair or replacement.

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DISASSEMBLY

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CHECK

- |1. Examine all parts for defects by standard industry practices.
2. Refer to Fits and Clearances for design dimensions and wear limits.
- |3. Magnetic particle check (SOPM 20-20-01) -- rod end (25), tube assembly (120).
- |4. Penetrant check (SOPM 20-20-02) -- nut (55), setscrew (70).

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CHECK

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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>
141T6971	ROD END ASSY	1-1, 1-2
141T6973-1	HOUSING	2-1
141T6973-3	BUSHING	3-1
141T6973-4	BEARING	4-1
- -	MISCELLANEOUS PARTS REFINISH	5-1

2. Standard Practices

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

| 20-00-00 Introduction
 | 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
 | 20-43-01 Chromic Acid Anodizing
 | 20-50-03 Bearing and Bushing Replacement
 | 20-60-02 Finishing Materials
 | 20-60-04 Miscellaneous Materials

3. Materials

NOTE: Equivalent substitutes can be used.

| A. Primer -- BMS 10-11, Type 1 (SOPM 20-60-02)

| B. Sealant -- BMS 5-95 (SOPM 20-60-04)

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REPAIR-GENERAL

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4. Dimensioning Symbols

- A. Standard True Position Dimensioning Symbols used in applicable repair procedures are shown in SOPM 20-00-00.

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REPAIR-GENERAL

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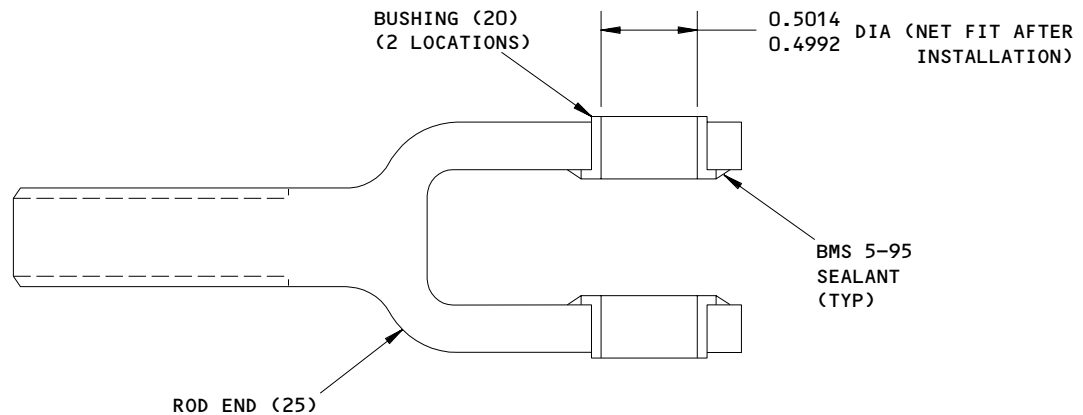
ROD END ASSEMBLY – REPAIR 1-1

141T6971-1, -3

1. Bushing Replacement (Fig. 601)

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

- A. Remove the old bushings.
- B. If you find defects on rod end surfaces, refer to REPAIR-GENERAL for repair instructions.
- C. Install replacement bushings by the shrink-fit method.
- D. Seal the bushings per Fig. 601.



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

141T6971-1,-3
 Bushing Replacement
 Figure 601

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REPAIR 1-1

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ROD END - REPAIR 1-2

141T6971-1

NOTE: Repair is only replacement of a worn or defective rod end. Refer to Fig. 601. Refer to REPAIR-GEN for a list of applicable standard practices.

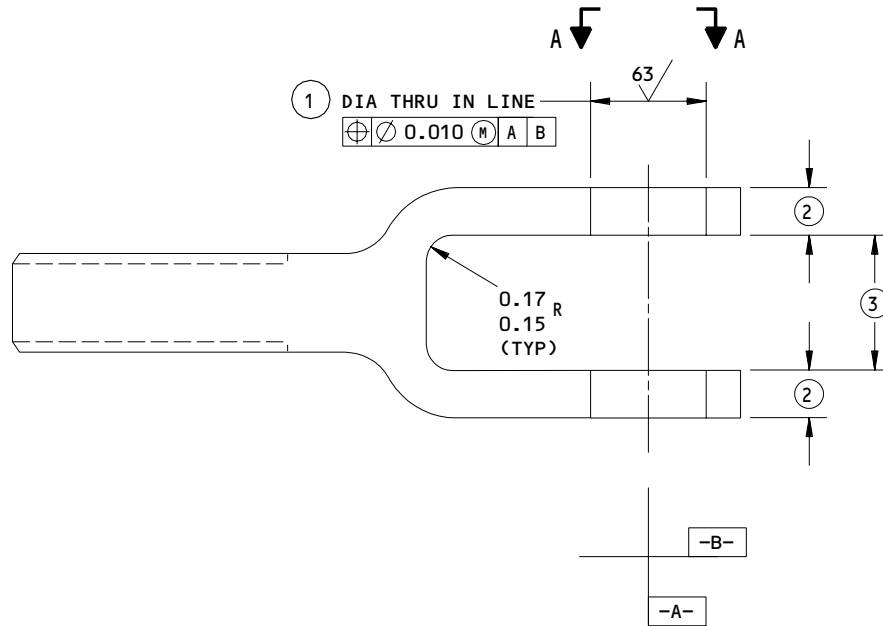
32-21-60

REPAIR 1-2

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A-A

	①	②	③
DESIGN DIM	0.6256 0.6250	0.260 0.240	0.6116 0.6066
REPAIR LIMIT	---	---	---

REFINISH

NO FINISH

REPAIR

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: 15-5PH CRES, 150-170 KSI

ALL DIMENSIONS ARE IN INCHES

141T6971-2
 Rod End Repair
 Figure 601

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REPAIR 1-2

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HOUSING - REPAIR 2-1

141T6973-1

NOTE: Repair is only replacement of a worn or defective housing. Refer to Fig. 601. Refer to REPAIR-GEN for a list of applicable standard practices.

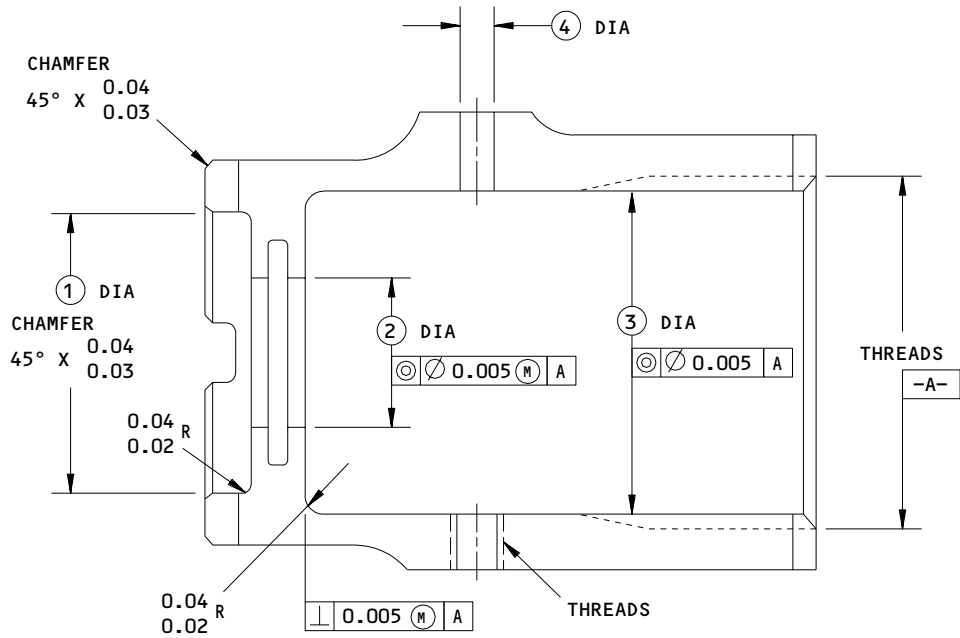
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REPAIR 2-1

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	①	②	③	④
DESIGN DIM	1.01 0.99	0.541 0.529	1.169 1.167	0.127 0.125
REPAIR LIMIT	---	---	---	---

REFINISH

NO FINISH

REPAIR

125/√ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: 15-5PH CRES, 150-170 KSI

ALL DIMENSIONS ARE IN INCHES

141T6973-1
Housing Repair
Figure 601

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REPAIR 2-1

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BUSHING - REPAIR 3-1

141T6973-3

NOTE: Repair is only replacement of a worn or defective bushing. Refer to Fig. 601. Refer to REPAIR-GEN for a list of applicable standard practices.

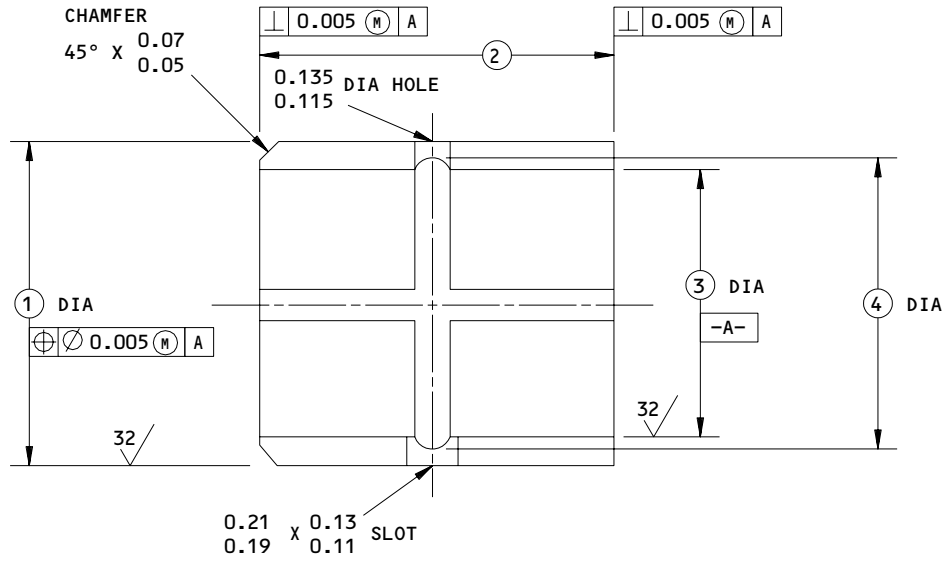
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REPAIR 3-1

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	1	2	3	4
DESIGN DIM	1.1600 1.1580	1.305 1.295	0.9710 0.9690	1.062 1.032
REPAIR LIMIT	---	---	---	---

REFINISH

NO FINISH

REPAIR

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: 15-5PH CRES, 150-170 KSI

ALL DIMENSIONS ARE IN INCHES

141T6973-3
 Housing Repair
 Figure 601

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REPAIR 3-1

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BEARING - REPAIR 4-1

141T6973-4

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

1. Shank Repair (Fig. 601)

- A. Machine as required, within repair limits, to remove defects.
- B. Shot-peen, build up with chrome plate and grind to design dimensions and finish.

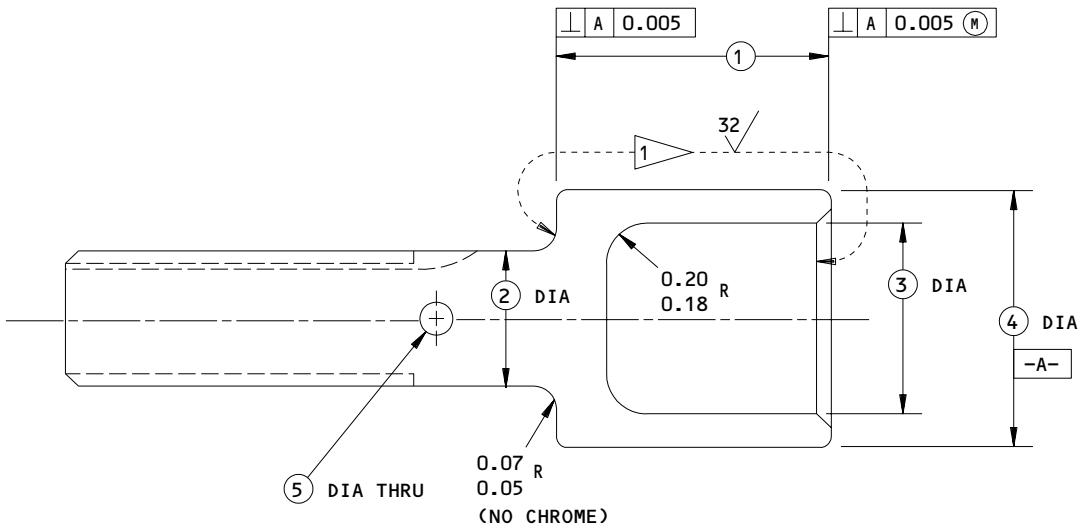
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REPAIR 4-1

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	①	②	③	④	⑤
DESIGN DIM	1.035 1.025	0.51 0.49	0.73 0.71	0.9665 0.9660	0.14 0.12
REPAIR LIMIT	---	---	---	0.9460 ②	---

REFINISH

PASSIVATE (F-17.25, WHICH REPLACES F-17.09) ALL OVER. CHROME PLATE AREAS SHOWN BY ①

- ① CHROME PLATE (F-15.03) THIS AREA
- ② LIMIT FOR CHROME PLATE BUILDUP AND GRIND TO DESIGN DIMENSION AND FINISH. PUT A 0.08 MAX PLATE RUNOUT AT EDGES

REPAIR

125 ✓ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

SHOT PEEN: 0.017-0.046 SHOT SIZE
 0.010 A2 INTENSITY

MATERIAL: 15-5PH CRES, 150-170 KSI

ALL DIMENSIONS ARE IN INCHES

141T6973-4
 Housing Repair and Refinish
 Figure 601

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REPAIR 4-1

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MISCELLANEOUS PARTS REFINISH – REPAIR 5-1

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

IPL FIG. & ITEM	MATERIAL	FINISH
<u>Fig. 1</u> Tube assy (120)		Passivate (F-17.25, which replaces (F-17.09)

Refinish Details
 Figure 601 (Sheet 1)

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REPAIR 5-1

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ASSEMBLY1. Materials

NOTE: Equivalent substitutes can be used.

A. Grease -- BMS 3-33 or MIL-G-23827 (SOPM 20-60-03)

B. Corrosion Preventive Compound -- MIL-C-16173, grade 2 (SOPM 20-60-02)

C. Lockwire -- MS20995C32 (SOPM 20-60-04)

2. Assembly

A. Rotary Assembly (Fig. 701)

- (1) Install ring (85) and lube fitting (80) in housing (115).
- (2) Install bushing (100) in housing (115), chamfered end first. Turn the bushing to align the long slot with the threaded hole. Make sure bushing (100) is at the bottom of the housing. Then install setscrew (70) with washer (75). Tighten to 20-25 lb-in.
- (3) Apply a layer of grease to the 32-microinch-finished face of washer (95), and the mating surface of bearing (110). Install the washer on the bearing.
- (4) Put shim (105) onto the shank of the bearing (110).
- (5) Install bearing (110), with assembled parts, into the bushing inside the housing.
- (6) Apply a layer of grease to the end of bearing (110), and to the 32-microinch finished face of washer (90). Install the washer on the end of bearing (110) inside bushing (100).
- (7) Make sure that bushing (100) and bearing (110) are at the bottom of housing (115). Measure the depth of washer (90) exposed face below exposed face of bushing (100). Adjust the thickness of shim (105) as necessary to make the depth be 0.003-0.006 inch.
- (8) Turn nut (60) onto nut (55). Engage the serrations of locking device (65) halves and slide these parts onto the shank of nut (55), and engage the internal tab with the keyway in nut (55) threads. Turn nut (60) up the threads of nut (55) to let you install nut (55) in housing (115).
- (9) Install nut (55) with assembled parts into housing (115). Tighten the nut (55) to 160-170 lb-in.

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- (10) Make sure the bearing (110) shaft turns freely. If it does not, disassemble parts and adjust the shim per step 2.A.(7).
- (11) Put the halves of locking device (65) against housing (115) and engage the serrations. Tighten nut (60) to 160-170 lb-in.
- (12) Make sure the bearing (110) shaft turns freely. Then apply grease at lube fitting (80). Install lockwire as shown (SOPM 20-50-02 and 767-SL-52-036).

B. Rod End (10)

- (1) Apply corrosion preventive compound to the internal threads of nut (55) and the external threads of rod end (10).
- (2) Turn nut (30) onto rod end (10) shank, then install washer (42) (if applicable) and washer (40).
- (3) Install rod end (10) into nut (55).

C. Rod End (15) and Tube (120)

- (1) Apply corrosion preventive compound to the internal threads of tube (120) and the external threads of rod end (15).
- (2) Turn nut (35) onto rod end (15) shank, then install washer (45).
- (3) Turn rod end (15) into tube (120), until you can see the end of the shank thru the hole in the tube.

D. Tube and Rotary Assembly (Fig. 701)

- (1) Apply corrosion preventive compound to the internal threads of tube (120) and the external threads of bearing (110) shaft.
- (2) Turn the bearing (110) shaft to align the hole in the shaft with the notch in housing (115). Put a suitable pin (1/8-inch diameter, 2 inches long) to hold the shaft while you install and adjust the tube. Thread nut (30) onto shaft.
- (3) Turn the bearing (110) shaft into the tube (120) until you can see the end of the shaft thru the hole in the tube.

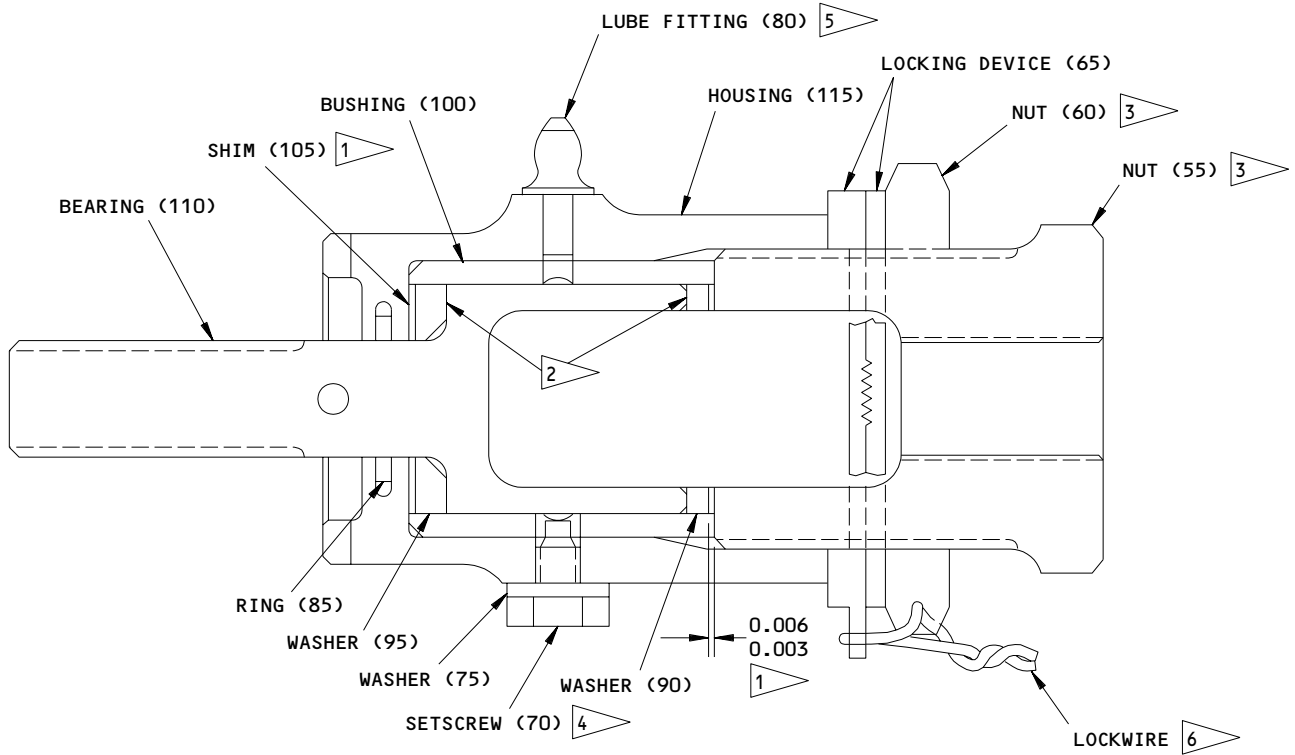
E. Adjust rod ends (10, 15), rotary (50) and tube (120) as necessary to get the final dimensions shown. Make sure you can see the ends of rod end (15) and bearing (110) shank are visible thru holes in tube (120), then tighten nuts (30, 35).

F. Remove the pin from the shaft of bearing (110). Install lockwire as shown (SOPM 20-50-02 and 767-SL-52-036).

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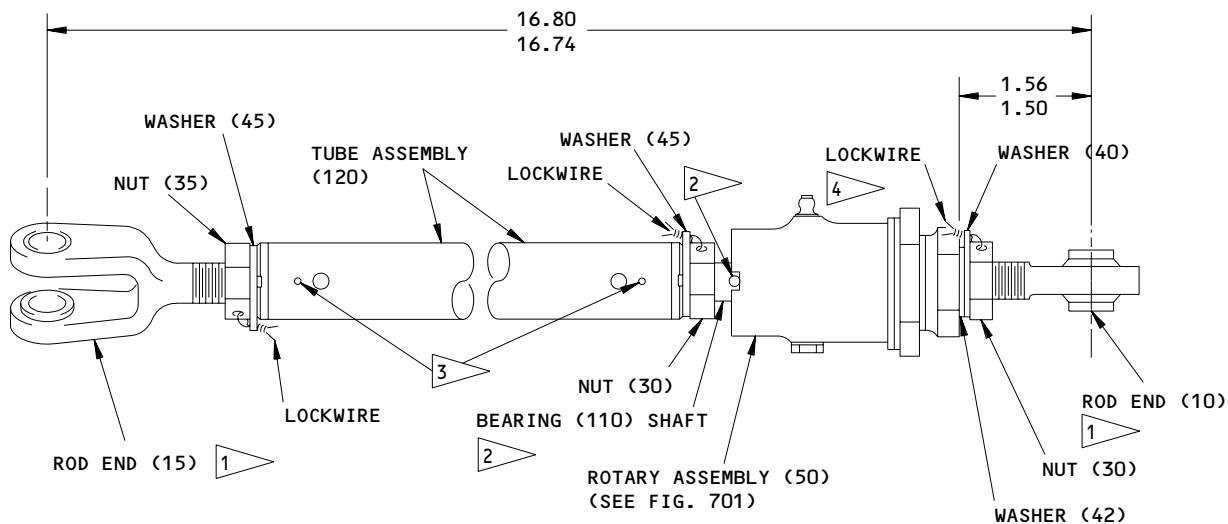
- 1 ▷ ADJUST THE SHIM TO GET THIS GAP AS SHOWN
- 2 ▷ PUT THE 32 MICROINCHES FACE OF WASHERS (90,95) TOWARD BEARING (110). LUBRICATE THE MATING SURFACES OF WASHERS AND BEARING WITH GREASE BEFORE INSTALLATION
- 3 ▷ TIGHTEN TO 160-170 POUND-INCHES
- 4 ▷ TIGHTEN TO 20-25 POUND-INCHES
- 5 ▷ APPLY GREASE AFTER ASSEMBLY IS COMPLETE
- 6 ▷ INSTALL LOCKWIRE PER SOPM 20-50-02 (767-SL-52-036)

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

141T6972-1,-2
 Rotary Assembly Details
 Figure 701

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 ASSEMBLY
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- 1 ASSEMBLE WITH A THIN LAYER OF CORROSION PREVENTIVE COMPOUND ON THE INTERNAL AND EXTERNAL MATING THREADS
- 2 PUT SOMETHING IN THIS HOLE TO HOLD THE SHAFT WHILE YOU ADJUST THE TUBE
- 3 AFTER THE FINAL LENGTH ADJUSTMENT, MAKE SURE YOU CAN SEE THE END OF BEARING (110) SHAFT AND THE END OF CLEVIS ROD END (15) THRU THESE HOLES
- 4 INSTALL LOCKWIRE PER SOPM 20-50-02 (767-SL-52-036)

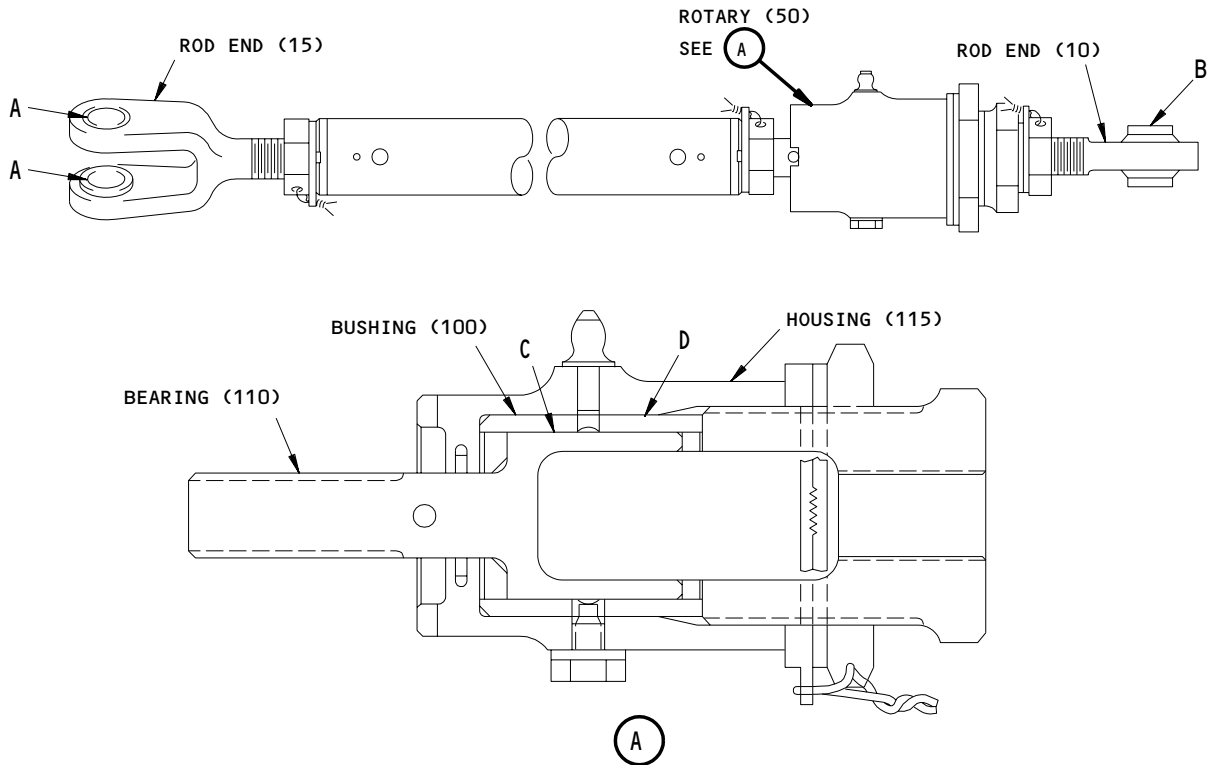
ITEM NUMBERS REFER TO IPL FIG. 1
 ALL DIMENSIONS ARE IN INCHES

Door Strut Assembly Details
 Figure 702

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FITS AND CLEARANCES



Ref Letter Fig.801	Mating Item No. IPL Fig.1	Design Dimensions				Service Wear Limit		
		Dimensions		Assembly Clearance		Dimensions		Maximum Clearance
		Min	Max	Min	Max	Min	Max	
A	ID 20	0.4992	0.5014	-0.0003	0.0029			
	OD 1	0.4985	0.4995					
B	ID 10	0.5615	0.5635					
C	ID 100	0.9690	0.9710	0.0025	0.0050	0.9640	0.9730	0.0040
	OD 110	0.9660	0.9665					
D	ID 115	1.1670	1.1690	0.0070	0.0110			
	OD 100	1.1580	1.1600					

1 BOLT 162T4018-5 (INSTALLATION PART)
 ALL DIMENSIONS ARE IN INCHES

Fits and Clearances
 Figure 801

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FOR TORQUE VALUES OF STANDARD FASTENERS, REFER TO SOPM 20-50-01			
ITEM NO. IPL FIG. 1	NAME	TORQUE	
		POUND-INCHES	POUND-FEET
55	NUT	160-170	
60	NUT	160-170	
75	SETSCREW	20-25	

Torque Table
 Figure 802

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ILLUSTRATED PARTS LIST

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

2. Indentures show parts relationships as follows:

Assembly

Detail Parts for Assembly

Subassembly

Attaching Parts for Subassembly

Detail Parts for Subassembly

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

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

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

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

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

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

6. Parts Interchangeability

Optional
(OPT)

The parts are optional to and interchangeable with other parts having the same item number.

Supersedes, Superseded By
(SUPSDS, SUPSD BY)

The part supersedes and is not interchangeable with the original part.

Replaces, Replaced By
(REPLS, REPLD BY)

The part replaces and is interchangeable with, or is an alternate to, the original part.

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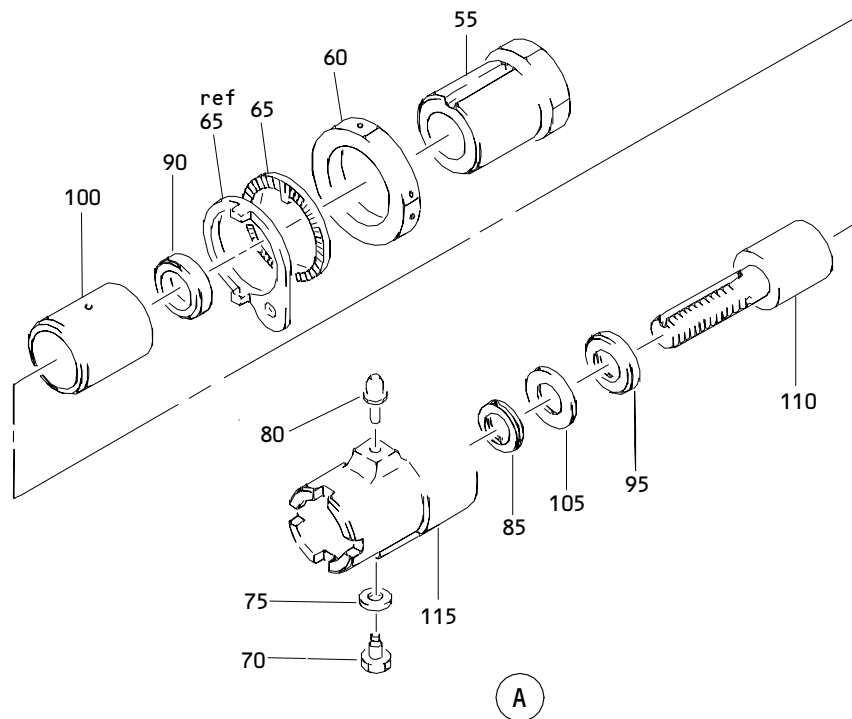
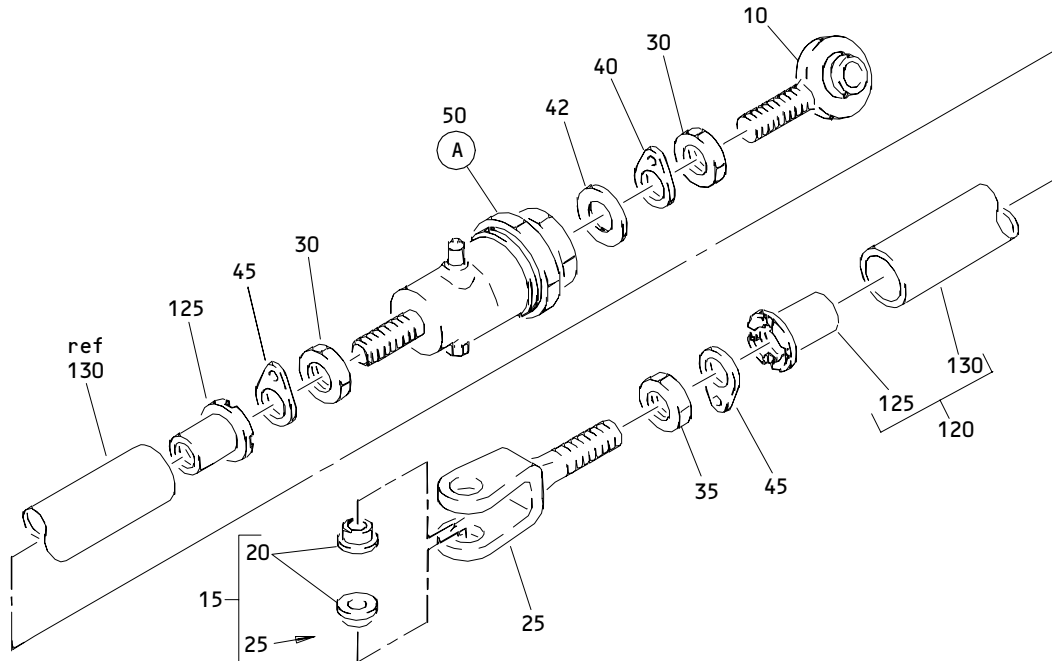
Jul 10/84

VENDORS

- 15860 NEW HAMPSHIRE BALL BEARINGS, INC.
ASTRO DIVISION
155 LEXINGTON DRIVE
LACONIA, NEW HAMPSHIRE 03246-2993
- 95879 ALEMITE DIVISION OF STEWART-WARNER CORP.
4701 PARK ROAD
CHARLOTTE, NORTH CAROLINA, 28209
OR
1826 DIVERSEY PARKWAY
CHICAGO, ILLINOIS 60614-1540

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Aft Nose Landing Gear Door Strut Assembly
 Figure 1

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BOEING
 COMPONENT
 MAINTENANCE MANUAL

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-1	141T6963-4		STRUT ASSY-AFT NLG DOOR	A	RF
-1A	141T6963-5		STRUT ASSY-AFT NLG DOOR	B	RF
-1B	141T6963-6		STRUT ASSY-AFT NLG DOOR	C	RF
-1C	141T6963-7		STRUT ASSY-AFT NLG DOOR	D	RF
10	ARY7CRAJFW		.END-ROD (V15860) (OPT ITEMS 10A,10B,10C)	ABC	1
-10A	ARY7-8		.END-ROD (V15860) (OPT ITEMS 10,10B,10C)	ABC	1
-10B	ARYM7CRAJFW		.END-ROD (V15860) (OPT ITEMS 10,10A,10C)	ABC	1
-10C	ARYM7-101		.END-ROD (V15860) (OPT ITEMS 10,10A,10B)	ABC	1
-10D	ARY7-8		.END-ROD (V15860) (OPT ITEM 10E)	D	1
-10E	ARY7-101		.END-ROD (V15860) (OPT ITEM 10D)	D	1
15	141T6971-1		.END ASSY-ROD	AB	1
-15A	141T6971-3		.END ASSY-ROD	CD	1
20	BACB28X8C028		..BUSHING- (USED ON ITEM 15)		2
-20A	BACB28X8C027		..BUSHING (USED ON ITEM 15A)		2
25	141T6971-2		..END-ROD		1
30	NAS509-8C		.NUT		2
35	NAS509L8C		.NUT		1
40	NAS513-8		.WASHER (PRE SB 32-18)	A	1
-40A	141T6973-11		.WASHER (POST SB 32-18)	A	1
-40B	141T6973-11		.WASHER	BCD	1
42	AN960C816		.WASHER (PRE SB 32-18)	A	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
45	NAS513-8		.WASHER		2
50	141T6972-1		.ROTARY ASSY	A	1
-50A	141T6972-2		.ROTARY ASSY	BCD	1
55	141T6973-2		..NUT (USED ON ITEM 50) (PRE SB 32-18)		1
-55A	141T6973-10		..NUT (USED ON ITEM 50) (POST SB 32-18)		1
-55B	141T6973-10		..NUT (USED ON ITEM 50A)		1
60	141T6973-9		..NUT		1
65	NAS1193E20C		..LOCKING DEVICE		1
70	141T6973-7		..SETSCREW		1
75	AN960C10		..WASHER		1
80	1736		..FITTING-LUBE (V95879)		1
85	MS28782-10		..RING		1
90	141T6973-5		..WASHER-THRUST		1
95	141T6973-6		..WASHER-THRUST		1
100	141T6973-3		..BUSHING		1
105	141T6973-8		..SHIM		1
110	141T6973-4		..BEARING		1
115	141T6973-1		..HOUSING-BRG		1
120	141T6966-7		.TUBE ASSY		1
125	141T6966-3		..END-TUBE		2
130	141T6966-8		..TUBE		1

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