

 **BOEING**
COMPONENT
MAINTENANCE MANUAL

TO: ALL HOLDERS OF NOSE LANDING GEAR FORWARD DOOR ASSEMBLY COMPONENT MAINTENANCE
MANUAL 32-22-42

REVISION NO. 5 DATED MAR 01/02

HIGHLIGHTS

All data that was in 767 CMM 32-22-41 is included in this CMM 32-22-42.

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 141T6910-59, -60 with changed structure details per PRR B13063-6.

1

TR & SB RECORD

1

1002-1007,1009-1020

REPAIR-GEN

Added clarifications and updated callouts.

601-602

REPAIR 1-1

601-602

701

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HIGHLIGHTS

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**NOSE LANDING GEAR
FORWARD DOOR ASSEMBLY**

**PART NUMBERS 141T6910-19 THRU -22,-27 THRU -36,
-39,-40,-47,-48,-55,-56,
-59,-60**

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
32-0048		PRR B10307 PRR C20024 PRR C20028 PRR C20030 PRR B11437 PRR B13063-6	APR 10/82 APR 10/82 APR 10/82 APR 10/82 OCT 10/87 MAR 01/02

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			*602	MAR 01/02	01.1
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1	OCT 01/87	01	601	NOV 01/98	01.1
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* = REVISED, ADDED OR DELETED

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*1016	MAR 01/02	01.1			
*1017	MAR 01/02	01.1			
*1018	MAR 01/02	01.1			
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*[1] Special instructions are not necessary. Use standard industry practices.

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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.

Verification:

Assembly Aug 12/82

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INTRODUCTION

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NOSE LANDING GEAR FORWARD DOOR ASSEMBLY

DESCRIPTION AND OPERATION

1. Description and Operation

- A. The nose landing gear forward door assembly includes: two hinge assemblies, a seal and retainer, all attached to a bonded assembly.
- B. The doors open as the nose gear is extended, and close behind the fully extended gear.

2. Leading Particulars (Approximate)

- A. Length -- 74 inches
- B. Width -- 22 inches
- C. Thickness -- 4 inches
- D. Weight -- 30 pounds (each)

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DESCRIPTION & OPERATION

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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 CAN BE USED TO CLEAN COMPOSITE COMPONENTS. DO NOT PUT PARTS IN THE SOLVENT OR LET SOLVENT STAY ON THE PARTS OR DAMAGE COULD OCCUR. USE 1,1, 1-TRICHLOROETHANE ONLY AS A WIPE SOLVENT.

1. Clean all parts by standard industry practices and the instructions in SOPM 20-30-03.

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CLEANING

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CHECK

NOTE: Refer to IPL Fig. 1 for item numbers.

1. Examine all parts for defects by standard industry practices. Refer to Fits and Clearances for design dimensions and wear limits.
2. Examine honeycomb and bonded parts for signs of delamination, internal water, scratches, and contour defects.
 - A. Ultrasonically examine for delamination.
 - B. Radiographically examine areas that could contain water to see how much damage there is.
 - C. Examine the edges of panel carefully for cuts and abrasions. Delamination starts easily from damage to an edge member.
3. Refer to Structural Repair Manual 52-80-00 for damage limits.
4. Penetrant check per 20-20-02 -- Hinges (45, 47, 102, 104).
5. Magnetic particle check per 20-20-01 -- Bearing plate (145).

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CHECK

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REPAIR – GENERAL1. Content

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

<u>P/N</u>	<u>NAME</u>	<u>REPAIR</u>
141T6981	HINGE ASSEMBLY	1-1
141T6913	HINGE ASSEMBLY	2-1
- -	MISCELLANEOUS PARTS REFINISH	3-1

2. Standard Practices

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

20-00-00	Introduction
20-10-06	Repair of Conductive Coatings
20-10-07	Machining of Titanium
20-20-02	Penetrant Methods of Inspection
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
20-42-05	Bright Cadmium Plating
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. Enamel -- BMS 10-11, type 2 BAC702 white (SOPM 20-60-02)

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- | B. Enamel -- BMS 10-60, BAC702 White (SOPM 20-60-02)
- | C. Primer -- BMS 10-11, type 1 (SOPM 20-60-02)
- | D. Primer -- BMS 10-79, Type 2 (SOPM 20-60-02)
- | E. Coating, Conductive -- BMS 10-21, Type 3 (SOPM 20-60-02)
- | F. Sealant -- BMS 5-95 (SOPM 20-60-04)

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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HINGE ASSEMBLY – REPAIR 1-1

141T6981-15, -16

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 in Fig. 601.

1. Bearing Replacement (Fig. 601)

- A. Remove the old bearing (85).
- B. If you find defects on the hole surfaces, refer to par. 3 for repair instructions.
- C. Install a replacement bearing and roller or anvil swage it (SOPM 20-50-03).
- D. Give the bearing a pushout load test of 2570 pounds.

2. Bushing Replacement (Fig. 601)

- A. Remove the old bushings (90, 95, 100).
- B. If you find defects on the hole surfaces, refer to par. 3 for repair instructions.
- C. Install replacement bushings by the shrink-fit method (SOPM 20-50-03).
- D. Fillet seal all around the bushing flanges with wet BMS 5-95 sealant.

3. Hole for Bearing (Fig. 601)

- A. Machine as required within repair limits to remove defects.
- B. Penetrant examine the surfaces.
- C. Make a repair sleeve (Fig. 602) as required to adjust for the material removed in step A.
- D. Install the sleeve and roller or anvil swage it (SOPM 20-50-03).
- E. Machine the sleeve bore to design dimensions. Be sure to restore the chamfers as shown.
- F. Make sure the lube passages are clear.

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G. Install a replacement bearing per par. 1.

4. Hole for Bushings (Fig. 601)

A. Machine as required, within repair limits, to remove defects.

B. Penetrant examine the surfaces.

C. Make oversize bushings (Fig. 603) as required to adjust for the material removed in step A.

D. Install the bushings per par. 2.C.D. above.

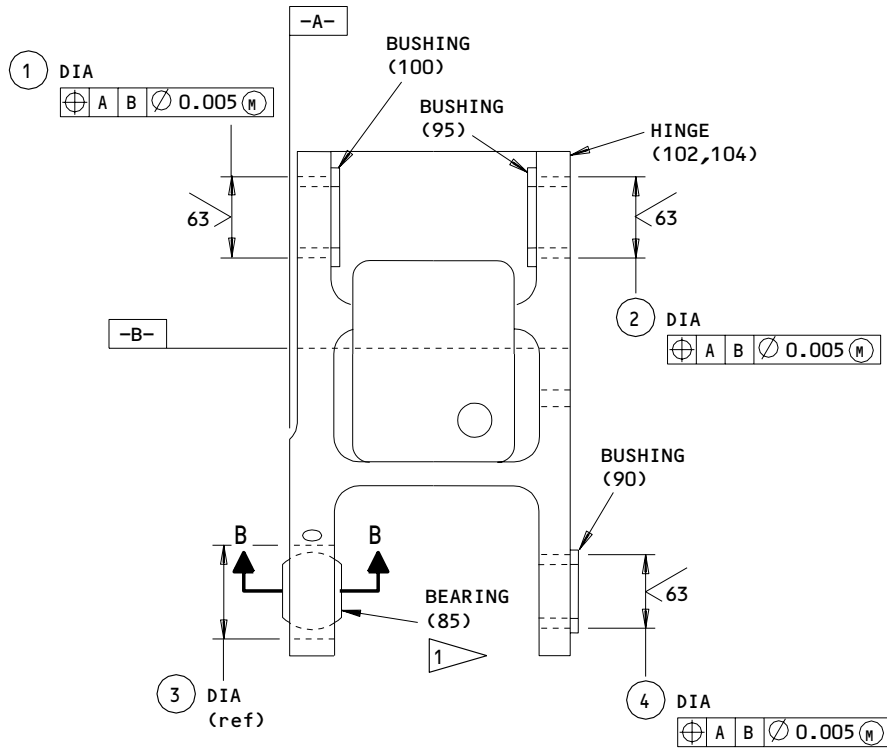
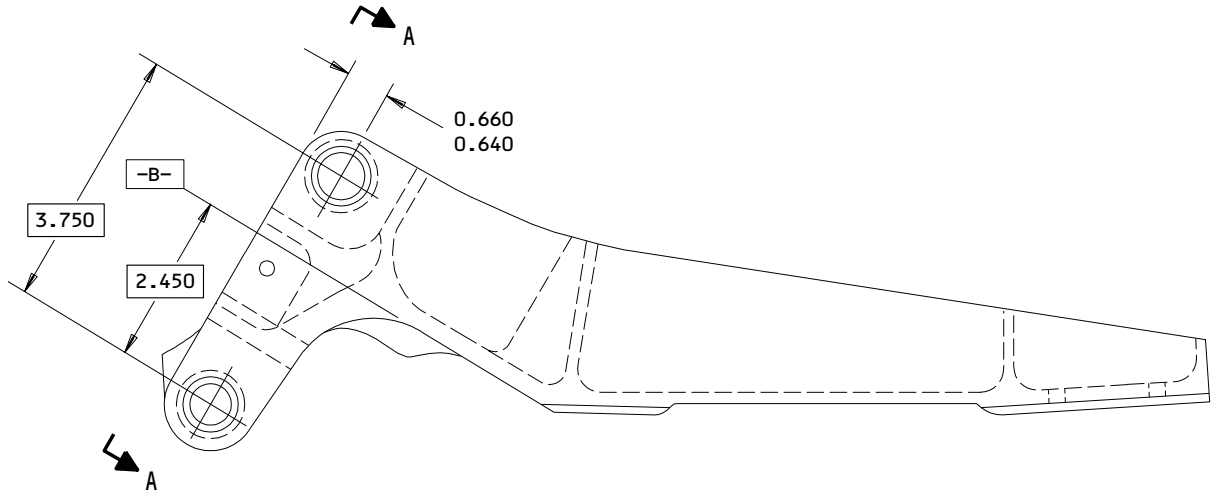
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A-A
 (ROTATED 26° CCW)
 141T6981-15,-16

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

Hinge Assembly Repair and Refinish
 Figure 601 (Sheet 1)

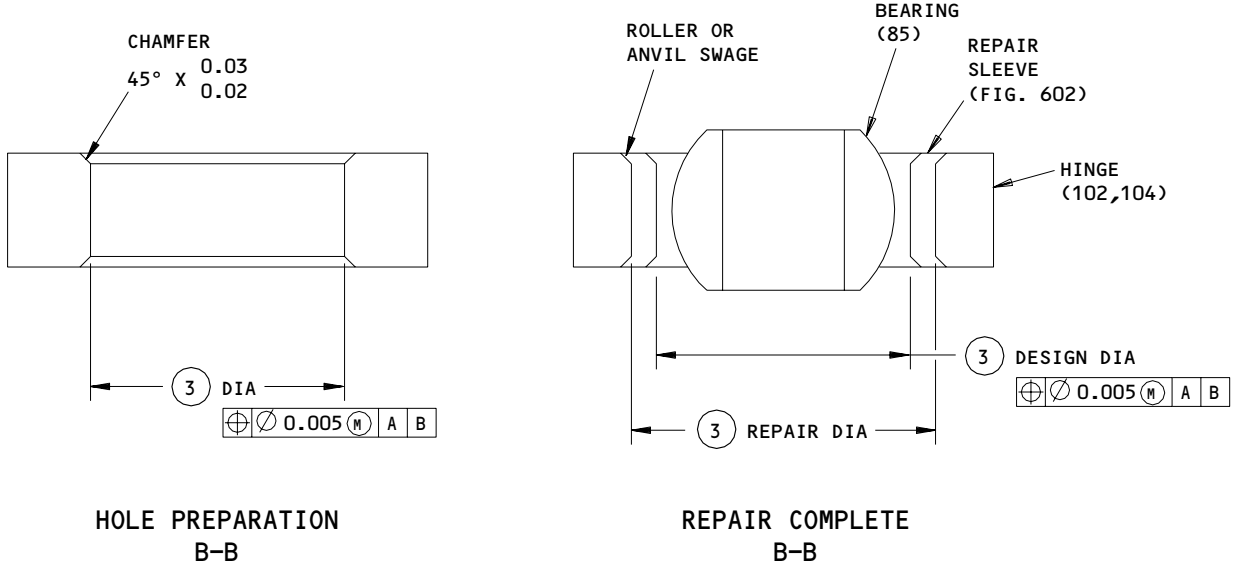
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REFERENCE NUMBER	①	②	③	④
DESIGN DIMENSION	0.8131 0.8126	0.8131 0.8126	0.9379 0.9374	0.6881 0.6876
REPAIR LIMIT	0.8731 ①	0.8731 ①	1.0579 ②	0.7481 ①

REFINISH

NO FINISH

- ① LIMIT FOR INSTALLATION OF OVERSIZE BUSHINGS (FIG. 603).
- ② LIMIT FOR INSTALLATION OF REPAIR SLEEVE (FIG. 602).

REPAIR

REF ① ②

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: TI-6AL-4V ALLOY

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

141T6981-15,-16

Hinge Assembly Repair and Refinish
 Figure 601 (Sheet 2)

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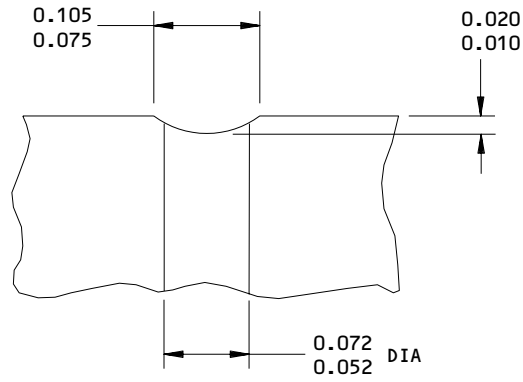
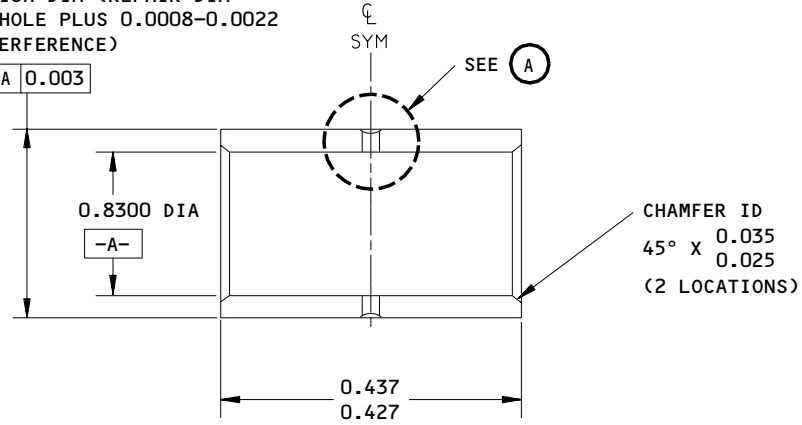
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FINISH DIA (REPAIR DIA
 OF HOLE PLUS 0.0008-0.0022
 INTERFERENCE)

ⓐ A 0.003



ⓐ

HOLE LOCATION ③ FIG. 601

63/ ALL MACHINED SURFACES UNLESS SHOWN
 DIFFERENTLY

MATERIAL: AL-NI-BRZ PER AMS 4640

FINISH: NO FINISH

ALL DIMENSIONS ARE IN INCHES

Repair Sleeve Details
 Figure 602

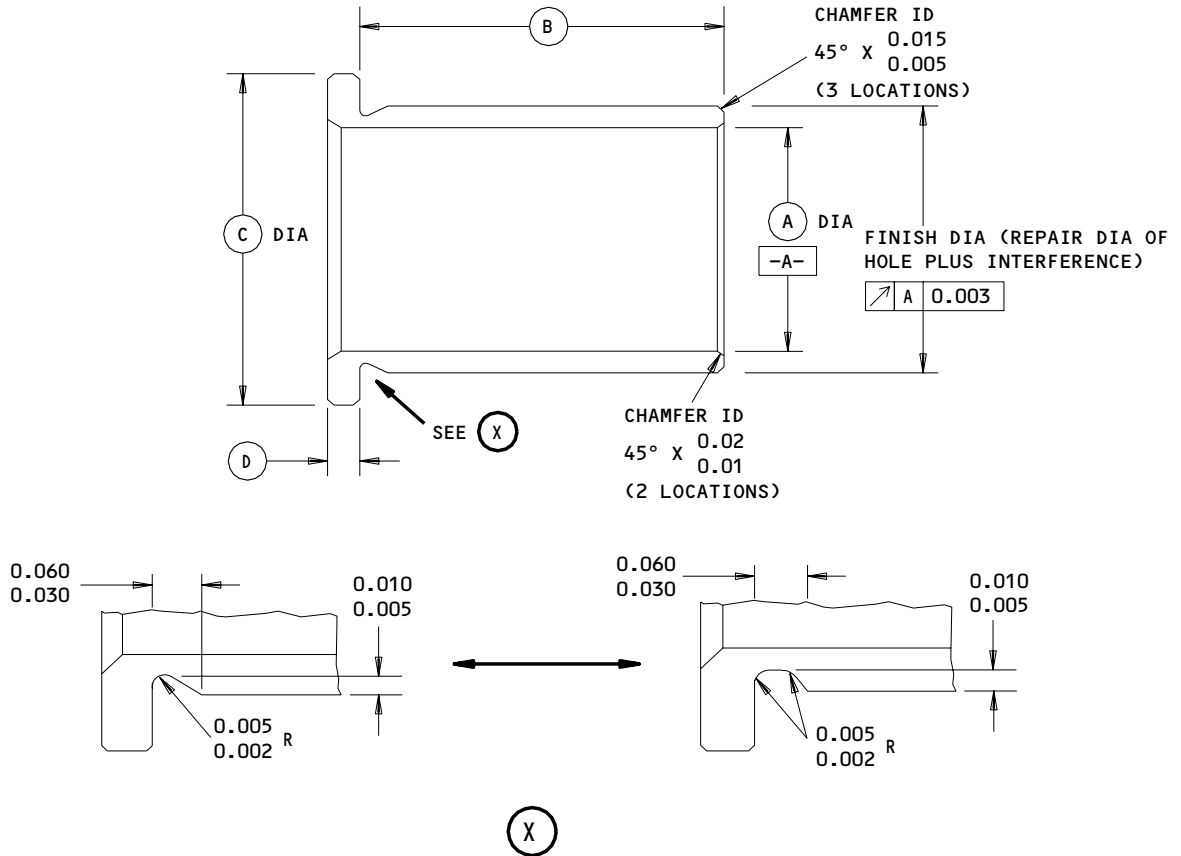
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HOLE LOCATION (IPL FIG. 1)	REPLACES BUSHING (IPL FIG. 1)	(A)	(B)	(C)	(D)	INTERFERENCE
(4)	(90) BACB28X9F029	0.5640 0.5625	0.290 0.285	0.822 0.802	0.062 0.057	0.0016 0.0001
(2)	(95) BACB28X10F029	0.6265 0.6250	0.290 0.285	1.010 0.990	0.062 0.057	0.0016 0.0001
(1)	(100) BACB28X10F038	0.6265 0.6250	0.380 0.375	1.010 0.990	0.062 0.057	0.0016 0.0001

63/ ALL MACHINED SURFACES, EXCEPT AS NOTED

MATERIAL: AL-NI-BR PER AMS 4640

FINISH: NO FINISH

ALL DIMENSIONS ARE IN INCHES

Oversize Bushing Details
 Figure 603

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REPAIR 1-1

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HINGE ASSEMBLY – REPAIR 2-1

141T6913-1, -2

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 in Fig. 601.

1. Bearing (40) Replacement (Fig. 601)

- A. Remove the old bearing.
- B. If you find defects on the hole surfaces, refer to par. 2 for repair instructions.
- C. Install a replacement bearing with wet BMS 5-95 sealant. Roller swage it per SOPM 20-50-03.
- D. Give the bearing a pushout load test of 1148 pounds.

2. Hole for Bearing (Fig. 601)

- A. Machine as required, within repair limits, to remove defects.
- B. Penetrant examine the surfaces.
- C. Make a repair sleeve (Fig. 602) as required to adjust for the material removed in step A.
- D. Install the sleeve and roller or anvil swage it per SOPM 20-50-03.
- E. Machine the sleeve bore to design dimensions. Be sure to restore the chamfers as shown.
- F. Make sure the lube passages are clear.

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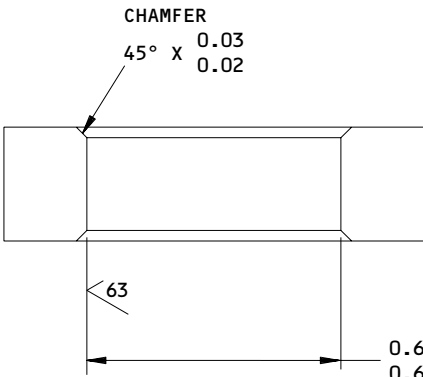
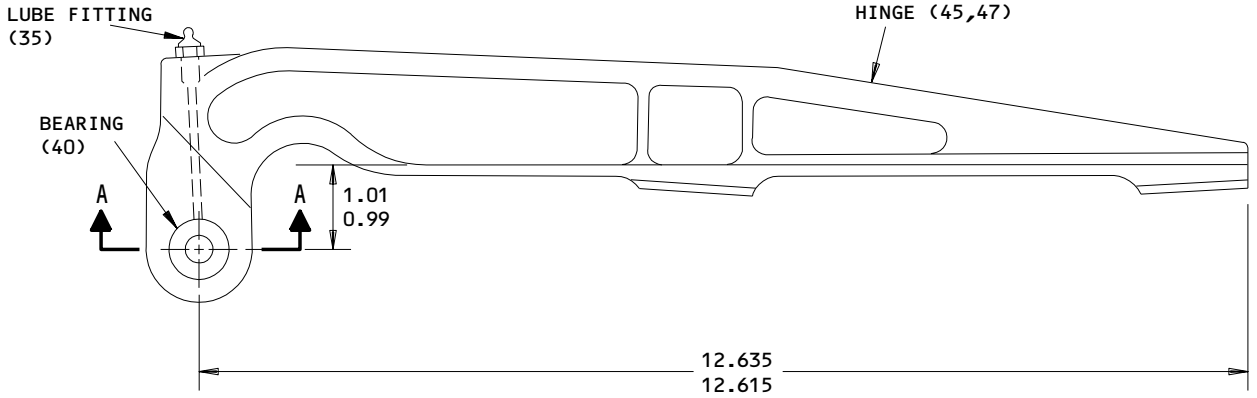
- | G. Install a replacement bearing per par. 1.

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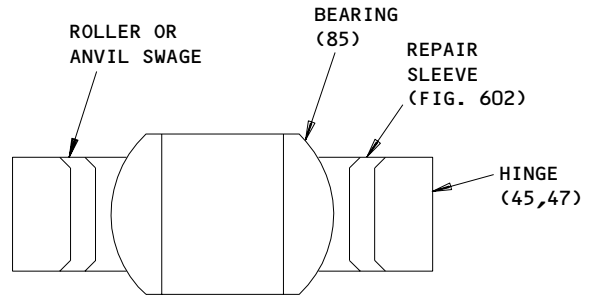
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**HOLE REPAIRS
 A-A**

0.6890 DESIGN DIA
 0.6885
 0.8140 MAX REPAIR DIA 1
⊕ ∅ 0.020 M



**REPAIR COMPLETE
 A-A**

REFINISH

CHROMIC ACID ANODIZE AND APPLY PRIMER BMS 10-11 TYPE 1 (F-18.13). APPLY ENAMEL BMS 10-11 TYPE 2 (F-21.17) BUT NOT IN HOLE FOR BEARING.

REPAIR

REF 1
 125 ✓ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

1 LIMIT FOR INSTALLATION OF REPAIR SLEEVE (FIG. 602).

141T6913-1,-2

**Hinge Assembly Repair and Refinish
 Figure 601**

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REPAIR 2-1

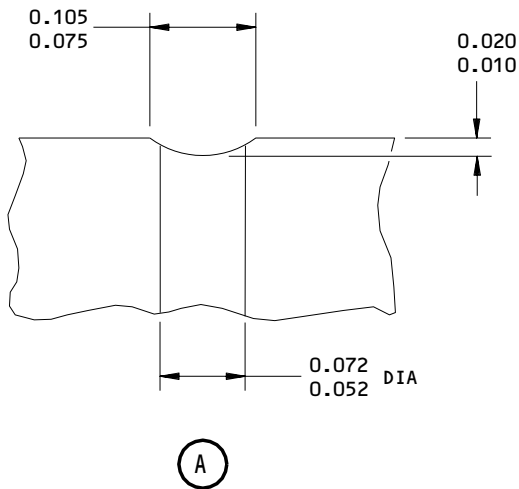
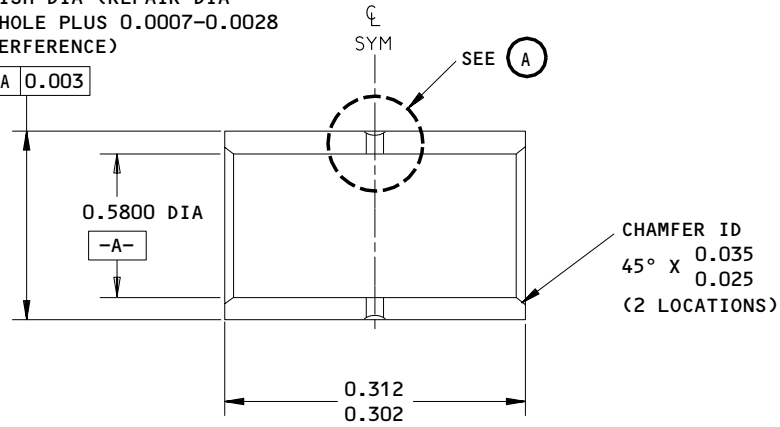
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FINISH DIA (REPAIR DIA
 OF HOLE PLUS 0.0007-0.0028
 INTERFERENCE)

Ⓢ A 0.003



HOLE FOR BEARING, FIG. 601

✓ 63/ ALL MACHINED SURFACES UNLESS SHOWN
 DIFFERENTLY

MATERIAL: AL-NI-BRZ PER AMS 4640

FINISH: NO FINISH

ALL DIMENSIONS ARE IN INCHES

Repair Sleeve Details
 Figure 602

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MISCELLANEOUS PARTS REFINISH – REPAIR 3-1

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
<p><u>Fig. 1</u></p> <p>Door Assy 141T6910-series</p> <p>Bonded Assy (140, 142) 141T6911-1, -2</p>		<p>Refinish exterior surface and edges by the operator's standard color scheme with BMS 10-11, Type 2 enamel.</p> <p>Exterior surface: Prepare the surface (SRF-14.672). Apply BMS 10-21, Type 3 conductive coating (SRF-14.685, which replaces SRF-14.68). Apply BMS 10-11, Type 1 primer (F-20.02).</p> <p>Interior and edges: Prepare the surface (SRF-14.672). Apply BMS 10-11, Type 1 primer (F-20.02) and BMS 10-11, Type 2 enamel, BAC 702 white gloss (F-21.17). Do not apply finish on bearing plate (145).</p>

Refinish Details
Figure 601 (Sheet 1)

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IPL FIG. & ITEM	MATERIAL	FINISH
Bonded Assy (140, 142) 141T6911-25 thru -30		Exterior surfaces: Prepare the surface (SRF-14.672). Apply BMS 10-21, Type 3 conductive coating (SRF-14.685, which replaces SRF-14.68). Apply BMS 10-79, Type 2 primer (F-19.46). Interior and edges: Prepare the surface (SRF-14.672). Apply BMS 10-11, Type 1 primer (F-20.02) and BMS 10-60 white enamel (SRF-14.9812). Do not apply finish to bearing plate (145).
Shim (25,65,70A) Seal retainer (125B,127A)	Aluminum alloy	Chemical treat (colored film) and apply BMS 10-11, Type 1 primer (F-18.06). Apply BMS 10-11, Type 2 enamel, BAC 702 white gloss (F-21.17).
Bearing Plate (145)	15-5PH CRES 180-200	Cadmium plate (F-15.02).
Bracket (106,106A, 106B,107,107A, 107B,160)	Aluminum alloy	Chromic acid anodize and apply BMS 10-11 primer (F-18.13). Apply BMS 10-60, 702 white gloss enamel (SRF-14.9812).
Edge protector (137,138)	304 CRES (Annealed) Optional: 321 CRES (Annealed)	Finish sand only the exterior surface with 180 grit per SOPM 20-30-03. Apply BMS 10-79, Type 2 primer (F-19.46).

Refinish Details
Figure 601 (Sheet 2)

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REPAIR 3-1

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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. Liquid Shim -- BMS 5-109, Type 2, Class 2, Grade A, or BMS 5-141
| (SOPM 20-60-04)
- | C. Sealant -- BMS 5-95 (SOPM 20-60-04)
- | D. Adhesive -- Type 44 (SOPM 20-50-12)
- | E. Adhesive -- Type 60 (SOPM 20-50-12)
- | F. Adhesive -- Type 70 (SOPM 20-50-12)
- | G. Adhesive -- Type 93 (SOPM 20-50-12)
- | H. Protective Finish, Clear -- Type 41 (SOPM 20-60-02)

2. Assembly (IPL Fig. 1)

CAUTION: USE ONLY TITANIUM OR CORROSION RESISTANT STEEL FASTENERS WITH GRAPHITE COMPOSITES. DO NOT USE ALUMINUM OR PLATED ALLOY STEEL FASTENERS, BECAUSE GALVANIC CORROSION WILL OCCUR.

- A. Use standard industry practices and these steps.
- B. Apply liquid shim between shims (25, 65, 70A) and bond assemblies (140, 142) as required. Shim thickness can be up to 0.15 inch.
- C. Install plug (135) in end of seal and bond with Type 60 adhesive per SOPM 20-50-12. Trim end of plug to match end of seal.
- D. Install bracket (160) on bonded assembly with Type 93 adhesive per SOPM 20-50-12 as shown in Fig. 701.
- E. Bond blocks (150, 152, 155, 157, 157A) to bonded assembly (140, 142) with Type 70 or 44 adhesive per SOPM 20-50-12. Maximum bondline thickness is 0.020 inch.

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- F. Apply BMS 5-95 sealant to bolts (15, 17, 55A) and install them. Make sure bolts (15 thru 18, 55A, 108, 111) are flush with the adjacent surface within 0.003 inch after installation. Then apply the sealant over the related washers and nuts. Do not apply sealant to bolts (55) shown in Fig. 702.
- G. Install plate (165) as shown in Fig. 703. Apply faying surface seal of BMS 5-95 sealant between plate and bond assembly (140). Apply Type 41 clear coating to all of the surface of plate and the filleted areas around it. Apply this coating out to 0.25 inch from the edges of the plate.

3. Lubrication

- A. Lubricate bearings (40, 85) with grease through fittings (35, 80).

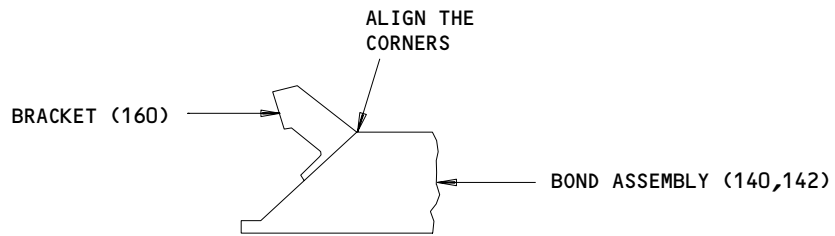
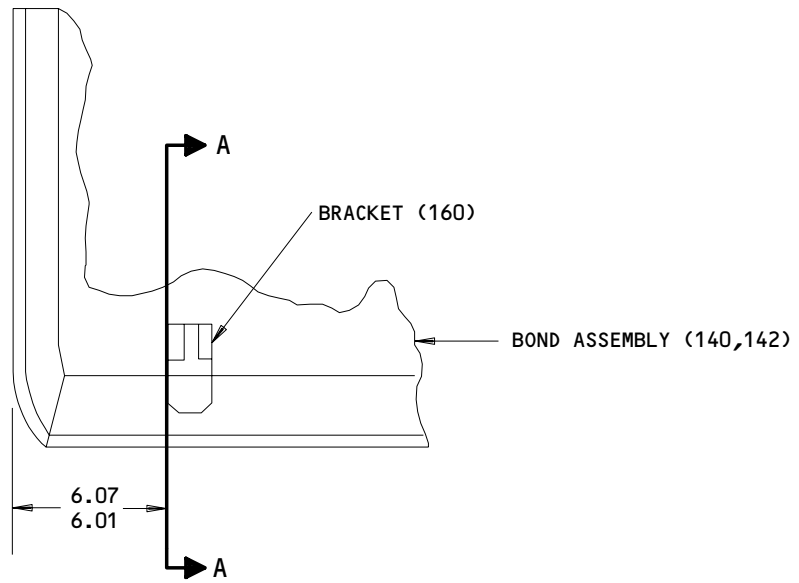
32-22-42

ASSEMBLY

01.1

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A-A

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

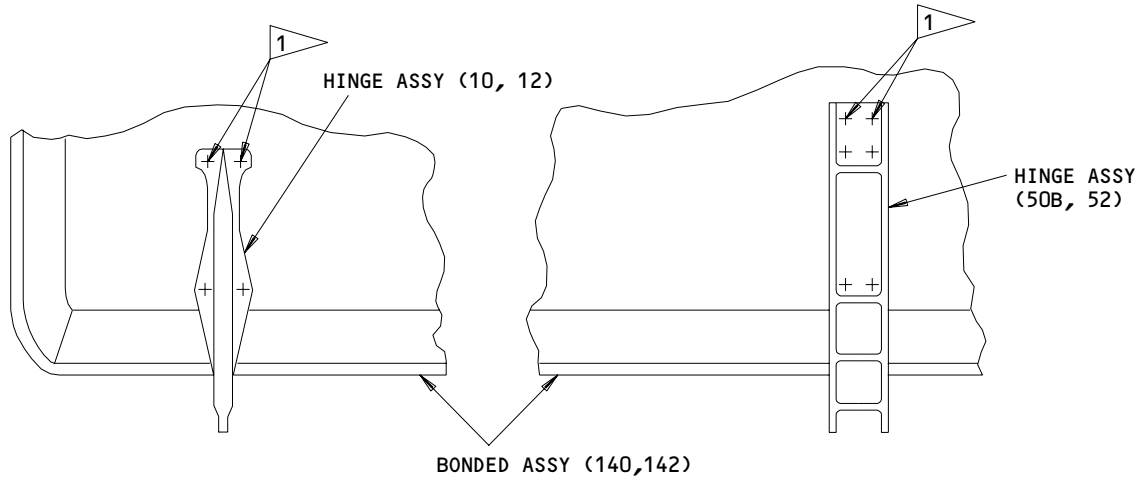
Bracket Installation
Figure 701

2263

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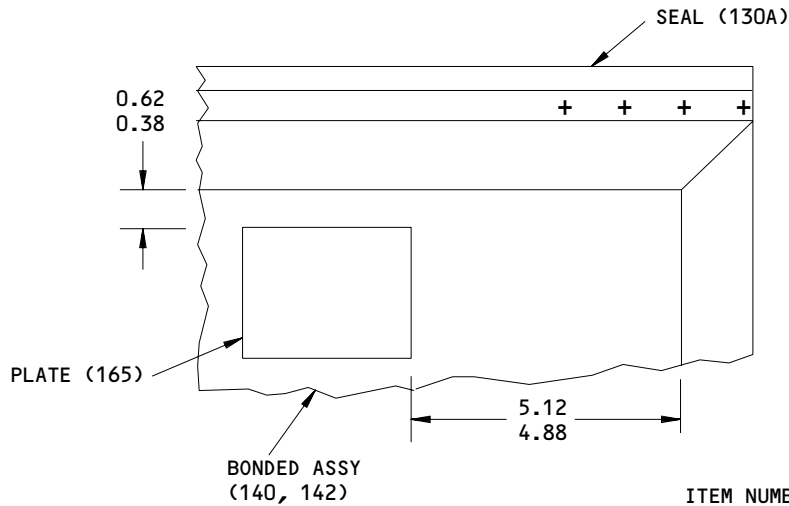
01.1



1 GROUND PER SOPM 20-10-06 THE CONDUCTIVE COATING ON THE EXTERIOR SURFACE OF THE DOOR TO THE HINGE FITTING AT THESE FASTENER LOCATIONS. DO NOT INSTALL THESE WITH BMS 5-95 SEALANT.

ITEM NUMBERS REFER TO IPL FIG. 1

Grounding of Hinges
 Figure 702



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

Installation of Identification Plate
 Figure 703

30396

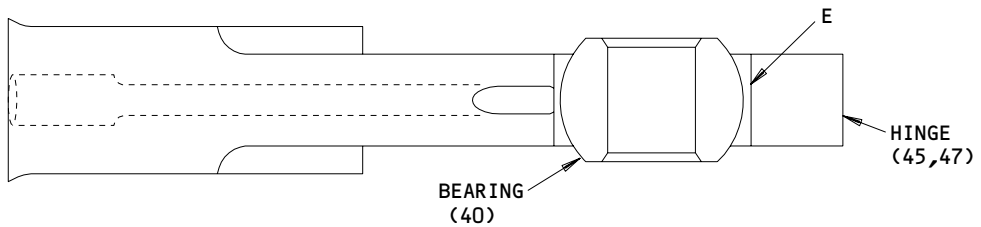
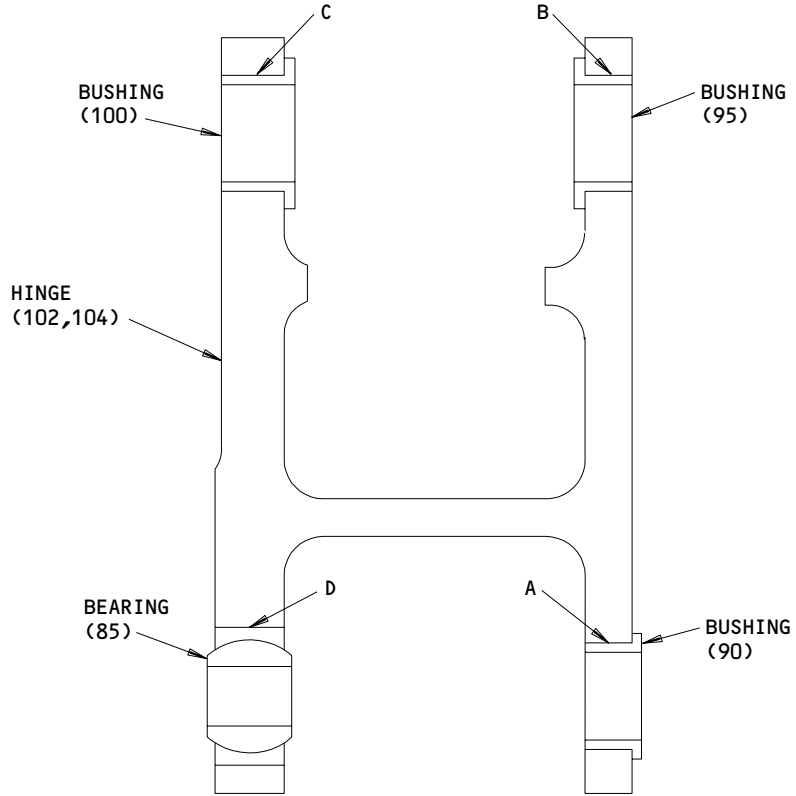
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ASSEMBLY
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01.1

FITS AND CLEARANCES




ALL DIMENSIONS ARE IN INCHES

Fits and Clearances
Figure 801 (Sheet 1)

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FITS AND CLEARANCES
01.1 Page 801
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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 102,104	0.6876	0.6881	-0.0016	-0.0001			0.000
	OD 90	0.6832	0.6892					
B	ID 102,104	0.8126	0.8131	-0.0016	-0.0001			0.000
	OD 95	0.8132	0.8142					
C	ID 102,104	0.8126	0.8131	-0.0016	-0.0001			0.000
	OD 100	0.8132	0.8142					
D	ID 102,104	0.9374	0.9379	-0.0001	0.0009			
	OD 85	0.9370	0.9375					
E	ID 45,47	0.6885	0.6890	0.0010	0.0020			
	OD 40	0.6870	0.6875					

ALL DIMENSIONS ARE IN INCHES



NEGATIVE VALUES ARE AN INTERFERENCE FIT

 Fits and Clearances
 Figure 801 (Sheet 2)

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 FITS AND CLEARANCES
 01.1 Page 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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ILLUSTRATED PARTS LIST

01

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VENDORS

S0352 NIPPON MINIATURE BEARING CO LTD
TOKYO, JAPAN

02758 NETWORKS ELECTRONIC CORP U S BEARING DIV
9750 DE SOTO AVENUE
CHATSWORTH, CALIFORNIA 91311-4409
FORMERLY U S BEARING DIV NETWORKS ELEC CORP

08524 DEUTSCH FASTENER CORP SEE CODE V97928

09455 BFM TRANSPORT DYNAMICS CORP
3131 WEST SEGERSTROM AVENUE PO BOX 1953
SANTA ANA, CALIFORNIA 92702-1953
FORMERLY TRANSPORT DYNAMICS AEROSPACE DIV, FABROID DIV
TRANSPORT DYNAMICS V17571 AND LEAR SEIGLER INC TRANSPORT
DIV V98076

15653 FAIRCHILD FASTENERS KAYNAR PRODUCTS DIV
800 S STATE COLLEGE BLVD
FULLERTON, CALIFORNIA 92831-3001
FORMERLY VK6405 MICRODOT AEROSP LTD; FORMERLY KAYNAR TECH
KAYNAR DIV

15860 NEW HAMPSHIRE BALL BEARINGS, INCORPORATED ASTRO DIVISION
155 LEXINGTON AVENUE
LACONIA, NEW HAMPSHIRE 03246-2937
FORMERLY ASTRO BEARING CORP, LOS ANGELES, CALIF.

16746 SPECLINE INCORPORATED
2230 MOUTON DR
CARSON CITY, NV 89706
FORMERLY IN SUN VALLEY, CAIFORNIA

50294 NEW HAMPSHIRE BALL BEARINGS INC
9727 DESOTO AVE PO BOX 2515
CHATSWORTH, CALIFORNIA 91311-4323
FORMERLY NIPPON MINATURE BEARING CORP V23589 AND NMB
AMERICA INC AND NMB INC

56644 AURORA BEARING CO
970 SOUTH LAKE STREET
AURORA, ILLINOIS 60506-5929

56878 SPS TECHNOLOGIES INC AEROSPACE AND INDUSTRIAL PRODUCTS DIV
HIGHLAND AVENUE
JENKINTOWN, PENNSYLVANIA 19046
FORMERLY STANDARD PRESSED STEEL

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ILLUSTRATED PARTS LIST
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BOEING
 COMPONENT
 MAINTENANCE MANUAL
VENDORS

60119 MONADNOCK CO THE
 18301 ARENTH AVENUE PO BOX 1222
 CITY OF INDUSTRY, CALIFORNIA 91749
 FORMERLY UNITED CARR FASTENER CORP VB0051 VB0056 VB0076
 FORMERLY TRW ELECTRONIC COMPONENTS CINCH-MONADNOCK DIV
 FORMERLY CINCH-MONADNOCK DIV OF TRW INC V76530

72962 HARVARD INDUSTRIES INC
 3 WERNER WAY SUITE 210
 LEBANON, NEW JERSEY 08833
 FORMERLY AMERACE CORP ESNA DIV
 FORMERLY ELASTIC STOP NUT IN UNION, NJ

73134 IMO INDUSTRIES INC HEIM BEARINGS DIV
 60 ROUND HILL ROAD PO BOX 430
 FAIRFIELD, CONNECTICUT 06430
 FORMERLY INCOM INTL INC HEIM DIV; FORMERLY HEIM UNIVERSAL
 CORP INCOM INTL INC; FORMERLY HEIM DIV INCOM INTL

81376 SOUTHWEST PRODUCTS COMPANY
 2240 BUENA VISTA STREET
 IRVINDALE, CALIFORNIA 91706
 FORMERLY IN MONROVIA, CALIFORNIA 91016

95879 ALEMITE DIVISION OF STEWART WARNER CORP
 1826 DIVERSEY PARKWAY
 CHICAGO, ILLINOIS 60614-1540

97613 SARGENT CONTROLS & AEROSPACE/KAHR BEARING DIV
 5675 W BURLINGAME RD
 TUCSON, ARIZONA 85743
 FORMERLY AETNA STEEL PROD KAHR BEARING DIV V96579
 FORMERLY SARGENT IND KAHR BEARING DIV, BURBANK, CALIFORNIA

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 ILLUSTRATED PARTS LIST
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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
ABW5V5		1	40	1
		1	40	1
ABW7V5		1	85	1
AN960PD8L		1	109	3
		1	115	35
AW5VCRG		1	40	1
AW7VCRG		1	85	1
BACB10AB5		1	40	1
BACB10AB7		1	85	1
BACB28X10F029		1	95	1
BACB28X10F038		1	100	1
BACB28X9F029		1	90	1
BACB30LH2SU3		1	111	35
BACB30LH2SU5		1	108	3
BACB30NN4K41		1	18	1
BACB30NN4K42		1	17	1
BACB30NN4K43		1	16	1
BACB30NN4K44		1	15	1
BACB30NN4K46		1	55A	6
BACN10JC08CM		1	110	3
		1	120	35
BACN10MT4		1	30	4
		1	75	6
BACS40R14D27F		1	27	1
BACS40R18D29F		1	70A	1
BACW10CA104CCU		1	20	4
		1	60	6
BSSR5544		1	40	1
BSSR7272		1	85	1
BWG5-110		1	40	1
BWG7-110		1	85	1
HU5-134		1	40	1
HU7-134		1	85	1
H19700P4		1	30	4
		1	75	6
KWB5-20CRG		1	40	1
KWB7-20CRG		1	85	1
K29913-104NF		1	20	4
		1	60	6
MS27253-3		1	165	1
NAS1149DN816J		1	109A	3
		1	115A	35
NAS620A8L		1	115C	35
TLN1020-4N		1	30	4
		1	75	6
WC5G1		1	40	1
WC7G1		1	85	1

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 ILLUSTRATED PARTS LIST
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BOEING
 COMPONENT
 MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
WG5E		1	40	1
WG7E		1	85	1
141T6910-10		1	25	1
141T6910-11		1	65	1
141T6910-19		1	1D	RF
141T6910-20		1	5D	RF
141T6910-21		1	1E	RF
141T6910-22		1	5E	RF
141T6910-23		1	125B	1
141T6910-24		1	127A	1
141T6910-25		1	130A	1
141T6910-26		1	62	6
141T6910-27		1	1F	RF
141T6910-28		1	5F	RF
141T6910-29		1	1G	RF
141T6910-30		1	5G	RF
141T6910-31		1	1H	RF
141T6910-32		1	5H	RF
141T6910-33		1	1J	RF
141T6910-34		1	5J	RF
141T6910-35		1	1K	RF
141T6910-36		1	5K	RF
141T6910-39		1	1L	RF
141T6910-40		1	5L	RF
141T6910-42		1	132	1
141T6910-45		1	130B	1
141T6910-46		1	132A	1
141T6910-47		1	1M	RF
141T6910-48		1	5M	RF
141T6910-51		1	125C	1
141T6910-52		1	127B	1
141T6910-53		1	130C	1
141T6910-54		1	132B	1
141T6910-55		1	1N	RF
141T6910-56		1	5N	RF
141T6910-57		1	135A	2
141T6910-59		1	1P	RF
141T6910-60		1	5P	RF
141T6910-9		1	135	2
141T6911-1		1	140	1
141T6911-15		1	155	1
141T6911-16		1	157	1
141T6911-17		1	150	1
141T6911-18		1	152	1
141T6911-2		1	142	1

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 ILLUSTRATED PARTS LIST
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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
141T6911-25		1	140B	1
141T6911-26		1	142A	1
141T6911-27		1	140C	1
141T6911-28		1	142B	1
141T6911-29		1	140D	1
141T6911-30		1	142C	1
141T6911-31		1	157A	1
141T6911-55		1	140E	1
141T6911-56		1	142D	1
141T6911-57		1	170	1
141T6911-58		1	175	1
141T6911-59		1	190	1
141T6911-60		1	195	1
141T6911-61		1	180	1
141T6911-63		1	200	1
141T6913-1		1	10	1
141T6913-2		1	12	1
141T6913-4		1	45	1
141T6913-5		1	47	1
141T6981-15		1	50B	1
141T6981-16		1	52	1
141T6981-17		1	102	1
141T6981-18		1	104	1
141T6981-19		1	102A	1
141T6981-20		1	104A	1
141T6987-1		1	137	1
141T6987-2		1	138	1
1728B		1	35	1
		1	80	1
284T0444-1		1	160	1
284T0468-1		1	106	1
284T0468-2		1	107	1
284T0468-3		1	106A	1
284T0468-4		1	107A	1
284T0468-5		1	106B	1
284T0468-6		1	107B	1
284T0468-7		1	106C	1
284T0468-8		1	107C	1
52LH6073-048		1	30	4
		1	75	6
53488-428		1	30	4
		1	75	6
55283		1	40	1
55285		1	85	1
66-13873-6		1	185	2

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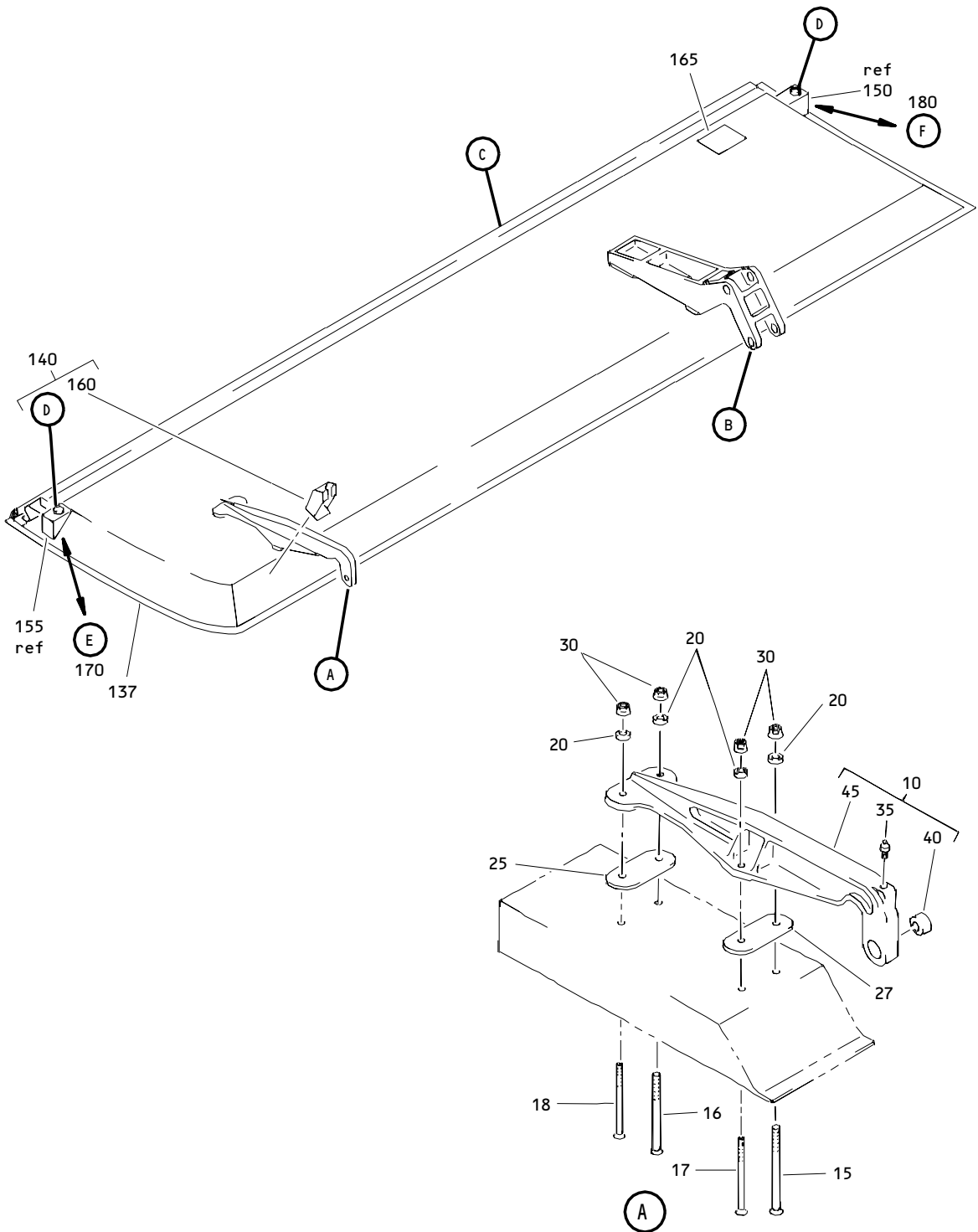
PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
70191-104U		1	20	4
		1	60	6
922010-4		1	20	4
		1	60	6
942010-4		1	20	4
		1	60	6

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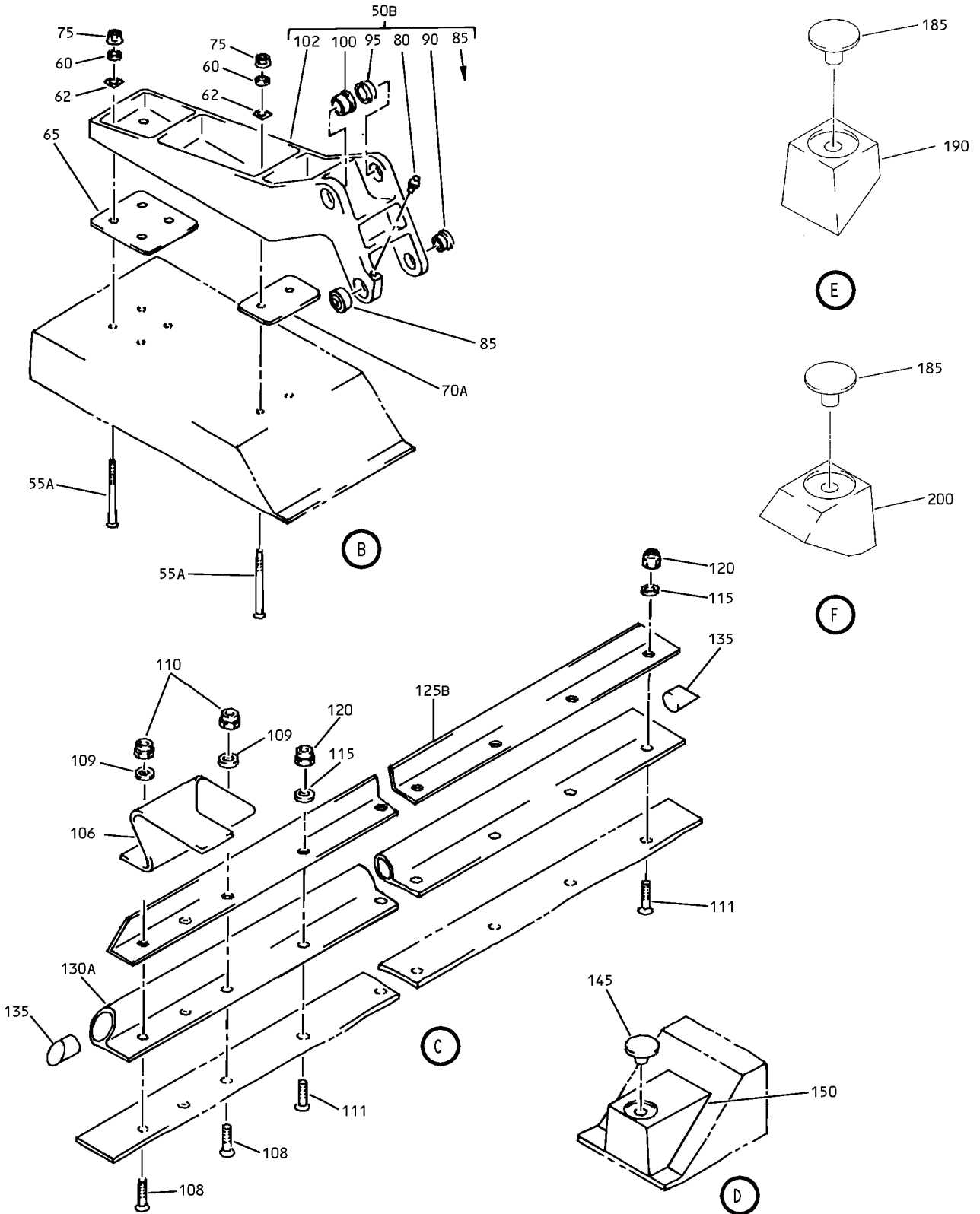
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Nose Landing Gear Forward Door Assembly
 Figure 1 (Sheet 1)

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Nose Landing Gear Forward Door Assembly
 Figure 1 (Sheet 2)

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BOEING
 COMPONENT
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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-1D	141T6910-19		DOOR ASSY-NLG FWD (LH)	A	RF
-1E	141T6910-21		DOOR ASSY-NLG FWD (LH)	B	RF
-1F	141T6910-27		DOOR ASSY-NLG FWD (LH)	E	RF
-1G	141T6910-29		DOOR ASSY-NLG FWD (LH)	G	RF
-1H	141T6910-31		DOOR ASSY-NLG FWD (LH)	J	RF
-1J	141T6910-33		DOOR ASSY-NLG FWD (LH)	L	RF
-1K	141T6910-35		DOOR ASSY-NLG FWD (LH)	N	RF
-1L	141T6910-39		DOOR ASSY-NLG FWD (LH)	Q	RF
-1M	141T6910-47		DOOR ASSY-NLG FWD (LH)	S	RF
R -1N	141T6910-55		DOOR ASSY-NLG FWD (LH)	U	RF
R -1P	141T6910-59		DOOR ASSY-NLG FWD (LH)	W	RF
-5D	141T6910-20		DOOR ASSY-NLG FWD (RH)	C	RF
-5E	141T6910-22		DOOR ASSY-NLG FWD (RH)	D	RF
-5F	141T6910-28		DOOR ASSY-NLG FWD (RH)	F	RF
-5G	141T6910-30		DOOR ASSY-NLG FWD (RH)	H	RF
-5H	141T6910-32		DOOR ASSY-NLG FWD (RH)	K	RF
-5J	141T6910-34		DOOR ASSY-NLG FWD (RH)	M	RF
-5K	141T6910-36		DOOR ASSY-NLG FWD (RH)	P	RF
-5L	141T6910-40		DOOR ASSY-NLG FWD (RH)	R	RF
-5M	141T6910-48		DOOR ASSY-NLG FWD (RH)	T	RF
R -5N	141T6910-56		DOOR ASSY-NLG FWD (RH)	V	RF
R -5P	141T6910-60		DOOR ASSY-NLG FWD (RH)	X	RF
10	141T6913-1		.HINGE ASSY	A,B,E ,G,J, L,N,Q ,S,U, W	1
-12	141T6913-2		.HINGE ASSY	C,D,F ,H,K, M,P,R ,T,V, X	1
15	BACB30NN4K44		ATTACHING PARTS .BOLT		1
16	BACB30NN4K43		.BOLT		1
17	BACB30NN4K42		.BOLT		1
18	BACB30NN4K41		.BOLT		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE	EFF CODE	QTY PER ASSY
			1234567		
01-20	K29913-104NF		.WASHER- (V15653) (SPEC BACW10CA104CCU) (OPT 70191-104U (V56878)) (OPT 922010-4 (V60119)) (OPT 942010-4 (V60119))		4
25	141T6910-10		.SHIM- (MFD FROM SH AL 2024T3 F18.06 F21.17 .090 X 1.4 X 2.7 QQA250/5		1
27 30	BACS40R14D27F H19700P4		.SHIM .NUT- (V15653) (SPEC BACN10MT4) (OPT TLN1020-4N (V08524)) (OPT 52LH6073-048 (V72962)) (OPT 53488-428 (V56878))		AR 4
35	1728B		-----*----- ..FITTING- (V95879)		1

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BOEING
 COMPONENT
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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-40	AW5VCRG		..BEARING-SPHER (V15860) (SPEC BACB10AB5) (OPT BSSR5544 (V81376)) (OPT KWB5-20CRG (V97613)) (OPT WG5E (V73134)) (OPT 55283 (V09455)) (OPT HU5-134 (V02758)) (OPT ABW5V5 (V50294)) (OPT BWG5-110 (V16746)) (OPT WC5G1 (V56644)) (OPT ABW5V5 (VS0352))		1
45	141T6913-4		..HINGE	A,B,E ,G,J, L,N,Q ,S,U, W	1
-47	141T6913-5		..HINGE	C,D,F ,H,K, M,P,R ,T,V, X	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-50B	141T6981-15		.HINGE ASSY	A,B,E ,G,J, L,N,Q ,S,U, W	1
-52	141T6981-16		.HINGE ASSY	C,D,F ,H,K, M,P,R ,T,V, X	1
55A 60	BACB30NN4K46 K29913-104NF		ATTACHING PARTS .BOLT .WASHER- (V15653) (SPEC BACW10CA104CCU) (OPT 70191-104U (V56878)) (OPT 922010-4 (V60119)) (OPT 942010-4 (V60119))		6 6
62 65	141T6910-26 141T6910-11		.FILLER .SHIM- (MFD FROM SH AL 2024T3 F18.06 F21.17 .090 X 3.0 X 2.9 QQA250/5		6 1
70A 75	BACS40R18D29F H19700P4		.SHIM .NUT- (V15653) (SPEC BACN10MT4) (OPT TLN1020-4N (V08524)) (OPT 52LH6073-048 (V72962)) (OPT 53488-428 (V56878)) -----*		AR 6
80	1728B		..FITTING- (V95879)		1

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 ILLUSTRATED PARTS LIST
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BOEING
 COMPONENT
 MAINTENANCE MANUAL

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-85	AW7VCRG		..BEARING-SPHER (V15860) (SPEC BACB10AB7) (OPT BSSR7272 (V81376)) (OPT KWB7-20CRG (V97613)) (OPT WG7E (V73134)) (OPT 55285 (V09455)) (OPT HU7-134 (V02758)) (OPT BWG7-110 (V16746)) (OPT ABW7V5 (V50294)) (OPT WC7G1 (V56644)) (OPT ABW7V5 (VS0352))		1
90	BACB28X9F029		..BUSHING-FLANGED		1
95	BACB28X10F029		..BUSHING-FLANGED		1
100	BACB28X10F038		..BUSHING-FLANGED		1
102	141T6981-17		..HINGE- (OPT ITEM 102A)	A,B,E ,G,J, L,N,Q ,S,U, W	1
-102A	141T6981-19		..HINGE- (OPT ITEM 102)	A,B,E ,G,J, L,N,Q ,S,U, W	1
-104	141T6981-18		..HINGE- (OPT ITEM 104A)	C,D,F ,H,K, M,P,R ,T,V, X	1
-104A	141T6981-20		..HINGE- (OPT ITEM 104)	C,D,F ,H,K, M,P,R ,T,V, X	1
106	284T0468-1		.BRACKET	A,B,E	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-106A	284T0468-3		.BRACKET	G	1
-106B	284T0468-5		.BRACKET	J,L	1
-106C	284T0468-7		.BRACKET	N,Q,S	1
				U,W	
-107	284T0468-2		.BRACKET	C,D,F	1
-107A	284T0468-4		.BRACKET	H	1
-107B	284T0468-6		.BRACKET	K,M	1
-107C	284T0468-8		.BRACKET	P,R,T	1
				V,X	
			ATTACHING PARTS		
108	BACB30LH2SU5		.BOLT		3
109	AN960PD8L		.WASHER	A-P	3
-109A	NAS1149DN816J		.WASHER	Q-X	3
110	BACN10JC08CM		.NUT		3
			-----*		
111	BACB30LH2SU3		.BOLT		35
115	AN960PD8L		.WASHER	A-K	35
-115A	NAS1149DN816J		.WASHER	Q-X	35
-115B	AN960PD8L		.WASHER-	L-P	35
			(OPT ITEM 115C)		
-115C	NAS620A8L		.WASHER-	L-P	35
			(OPT ITEM 115B)		
120	BACN10JC08CM		.NUT		35
125B	141T6910-23		.RETAINER-SEAL	A,B,E	1
				G,J	
				L,N,Q	
				S	
R -125C	141T6910-51		.RETAINER-SEAL	U,W	1
-127A	141T6910-24		.RETAINER-SEAL	C,D,F	1
				H,K	
				M,P,R	
				T	

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 01- -127B 130A	141T6910-52		.RETAINER-SEAL	V,X A-Q	1
	141T6910-25		.SEAL- (-25 R/B -42 OR -46, IW=1 FOR RH DOOR ONLY) (MFD FROM SHT RUBBER BAC1530-44 STOCK 74.2 IN F-25.01)		1
-130B	141T6910-45		.SEAL- (PART NUMBER 141T6910-9 TOGETHER WITH 141T6910-45 AND 141T6910-23 IS INTERCHANGEABLE ONE WAY FORWARD WITH PART NUMBER 141T6910-57 TOGETHER WITH 141T6910-53 AND 141T6910-51) (MFD FROM SHT RUBBER BAC1530-44 STOCK 74.2 IN F25.01)	S	1
R -130C	141T6910-53		.SEAL- (PART NUMBER 141T6910-9 TOGETHER WITH 141T6910-45 AND 141T6910-23 IS INTERCHANGEABLE ONE WAY FORWARD WITH PART NUMBER 141T6910-57 TOGETHER WITH 141T6910-53 AND 141T6910-51) (MFD FROM MOLDED PART BAC1530-212 STOCK 74.2 IN, F25.01)	U,W	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01- -132	141T6910-42		.SEAL- (-25 R/B -42 OR -46, IW=1 FOR RH DOOR ONLY)	R	1
-132A	141T6910-46		.SEAL- (-25 R/B -42 OR -46, IW=1 FOR RH DOOR ONLY) (141T6910-54 T/W QTY(2) 141T6910-57 PLUGS AND QTY (1) 141T6910-52 SEAL RETAINER CAN REPLACE BUT NOT BE REPLACED BY 141T6910-46 T/W QTY (2) 141T6910-9 PLUGS AND QTY (1) 141T6910-24 SEAL) (MFD FROM SHT RUBBER BAC1530-44 STOCK 74.2 IN F25.01)	T	1
R -132B	141T6910-54		.SEAL- (141T6910-54 T/W QTY(2) 141T6910-57 PLUGS AND QTY (1) 141T6910-52 SEAL RETAINER CAN REPLACE BUT NOT BE REPLACED BY 141T6910-46 T/W QTY (2) 141T6910-9 PLUGS AND QTY (1) 141T6910-24 SEAL) (MFD FROM SHT RUBBER BAC1530-44 STOCK 74.2 IN F25.01)	V,X	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-135	141T6910-9		.PLUG- (PART NUMBER 141T6910-9 TOGETHER WITH 141T6910-45 AND 141T6910-23 IS INTERCHANGEABLE ONE WAY FORWARD WITH PART NUMBER 141T6910-57 TOGETHER WITH 141T6910-53 AND 141T6910-51) (MFD FROM SHT SILICONE SPONGE RUBBER BMS1-23 0.500 DIA 1.000 IN F-25.01)	A-T	2
R -135A	141T6910-57		.PLUG- (PART NUMBER 141T6910-9 TOGETHER WITH 141T6910-45 AND 141T6910-23 IS INTERCHANGEABLE ONE WAY FORWARD WITH PART NUMBER 141T6910-57 TOGETHER WITH 141T6910-53 AND 141T6910-51) (MFD FROM SHT SILICONE SPONGE RUBBER BMS1-23 .38 OUTER DIA, 1 IN LENGTH F-25.01)	U-X	2
137	141T6987-1		.PROTECTOR-EDGE	L,N,Q ,S,U, W	1
-138	141T6987-2		.PROTECTOR-EDGE	M,P,R ,T,V, X	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
140	141T6911-1		.BONDED ASSY	A	1
-140B	141T6911-25		.BONDED ASSY	B	1
-140C	141T6911-27		.BONDED ASSY	E,G	1
-140D	141T6911-29		.BONDED ASSY	J,L,N ,Q,S, U	1
R -140E	141T6911-55		.BONDED ASSY	W	1
-142	141T6911-2		.BONDED ASSY	C	1
-142A	141T6911-26		.BONDED ASSY	D	1
-142B	141T6911-28		.BONDED ASSY	F,H	1
-142C	141T6911-30		.BONDED ASSY	K,M,P ,R,T, V	1
R -142D	141T6911-56		.BONDED ASSY	X	1
145	66-13873-6		DELETED		
150	141T6911-17		..BLOCK	A,B,E ,G,J, L,N,Q ,S,U	1
-152	141T6911-18		..BLOCK	C,D,F ,H,K, M,P,R ,T,V	1
155	141T6911-15		..BLOCK	A,B,E ,G	1
-157	141T6911-16		..BLOCK	C,D,F ,H	1
-157A	141T6911-31		..BLOCK	J-V	1
160	284T0444-1		..BRACKET		1
165	MS27253-3		.PLATE	A-V	1
R -165A	MS27253F3		.PLATE	W,X	1
R 170	141T6911-57		.BLOCK ASSY-STOP	W	1
R -175	141T6911-58		.BLOCK ASSY-STOP	X	1
R 180	141T6911-61		.BLOCK ASSY-STOP	W,X	1
R 185	66-13873-6		..PLATE-BRG	W,X	1
R 190	141T6911-59		..BLOCK-	W	1
			(USED ON ITEM 170)		
R -195	141T6911-60		..BLOCK-	X	1
			(USED ON ITEM 175)		
R 200	141T6911-63		..BLOCK-	W,X	1
			(USED ON ITEM 180)		

- Item Not Illustrated

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