

 **BOEING**  
COMPONENT  
MAINTENANCE MANUAL

TO: ALL HOLDERS OF MID ENTRY DOOR ASSEMBLY COMPONENT MAINTENANCE MANUAL 52-11-04

REVISION NO. 4 DATED MAR 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

TITLE PAGE

Added door assemblies 143T6121-31, -32, -45, -46 for a better fit.

1

1002-1016,1033-1059

TR & SB RECORD

Added clarifications and updated callouts.

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Deleted locations which are a static joint and do not wear.

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## MID ENTRY DOOR ASSEMBLY

PART NUMBERS 143T6121-1,-2,-31,-32,-45,-46

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



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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 &<br>Service Bulletin Record | 6. Introduction              |
|  | 7. Procedures & IPL Sections |

Refer to the Table of Contents for the page location of applicable sections.

The beginning of the REPAIR section includes a list of the separate repairs, 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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MID ENTRY DOOR ASSEMBLYDESCRIPTION AND OPERATION1. Description

A. The mid entry door assembly has a basic structure of single-piece forged beams and edge members covered with clad aluminum alloy skin, two lower rollers and support fittings, one upper support fitting, a handhold assembly, window assembly, track support assembly and support installation, and a pressure seal.

2. Operation

A. As the fuselage mounted handle mechanism is moved from the closed to open position, the upper edge of the door turns inboard and moves upward. The lower edge of the door moves inboard and upward as the lower rollers follow the tracks in the guide rails.

3. Leading Particulars (approximate)

Length -- 78 inches  
Width -- 47 inches  
Chord Height -- 12 inches  
Weight -- 98 pounds

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DISASSEMBLY

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

1. Use standard industry practices and these steps.
2. Temporarily attach or keep shims (65, 105, 170, 172, 460, 460A, 612, 614, 646A) to mating parts to help during assembly.
3. Make a note of the thickness of shims (614, 646A) to help during assembly.
4. Make a note of the number and position of washers (255, 370 IPL Fig. 1) to help during assembly.
5. To replace bearing in roller guide assembly (305), drill out rivet (310), then remove bolt (315).

CAUTION: DO NOT CLAMP ON THE END OF THE PIN TO REMOVE THE NUT. YOU COULD DAMAGE THE CADMIUM PLATE FINISH OR PIN MATERIAL.

6. To help remove the nut (70) from the centering pin (75), put a blunt metal object, 0.120 inch or smaller, through the hole in the spacer (95) and pin (75).

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DISASSEMBLY

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CHECK

- |1. Examine all parts for defects by standard industry practices.
- |2. Magnetic particle check (SOPM 20-20-01) -- pins (75, 340, 602 IPL Fig. 1), links (240, 355), bracket (558), fitting assembly (628, 630), bolts (315, 250, 365).
- |3. Penetrant check (SOPM 20-20-02) -- Plate (60), fittings (55, 165, 300, 598, 600, 608, 610).

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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>
141T6143	DOOR CLEVIS FITTING ASSY	1-1
141T6334	ROLLER ASSY	2-1
141T6586	FITTING ASSY	3-1
141T6628	BRACKET ASSY	4-1
143T6149	ROLLER SUPPORT ASSY	5-1
141T6176	GUIDE ASSY	6-1
143T6121	MID ENTRY DOOR ASSY	7-1
- - -	MISCELLANEOUS PARTS	8-1
- - -	REFINISH	

2. Standard Practices

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

20-00-00	Introduction
20-10-01	Repair and Refinish of High Strength Steel Parts
20-10-04	Grinding Chrome Plated Parts
20-30-01	Cleaning and Relubricating
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
20-42-03	Hard Chrome Plating
20-42-05	Bright Cadmium Plating
20-43-01	Chromic Acid Anodizing
20-43-03	Anodizing
20-50-01	Bolt and Nut Installation
20-50-02	Installation of Safetying Devices
20-50-03	Bearing and Bushing Replacement
20-50-08	Application of Dry Lubricants
20-60-02	Finishing Materials
20-60-03	Lubricants
20-60-04	Miscellaneous Materials

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3. Materials and Equipment

| NOTE: Equivalent substitutes can be used.

A. Coating -- Alodine 1200 (Ref 20-60-02)  
-- Alodine 1000 (Ref 20-60-02)

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

| C. Enamel (SOPM 20-60-02)

| (1) BMS 10-11, Type 2, BAC 702 White Gloss

| (2) BMS 10-60 BAC 707 Grey Gloss

| D. Lubricant, Solid Film (SOPM 20-50-08)

| (1) MIL-L-8937

| (2) BMS 3-8

| (3) Vitrolube 1220

| (4) MIL-L-46010

| E. Grease -- BMS 3-33 or BMS 3-24 (SOPM 20-60-03)

| 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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DOOR CLEVIS FITTING ASSEMBLY – REPAIR 1-1

141T6143-6

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

1. Bushing Replacement (45, 50 IPL Fig. 1)

- A. Remove the old bushings.
- B. Install replacement bushings by the shrink fit method (SOPM 20-50-03).

2. Refinish

- A. Fitting (55) -- Chromic acid anodize and apply BMS 10-11, Type 1 primer (F-18.13). Material: Al alloy.

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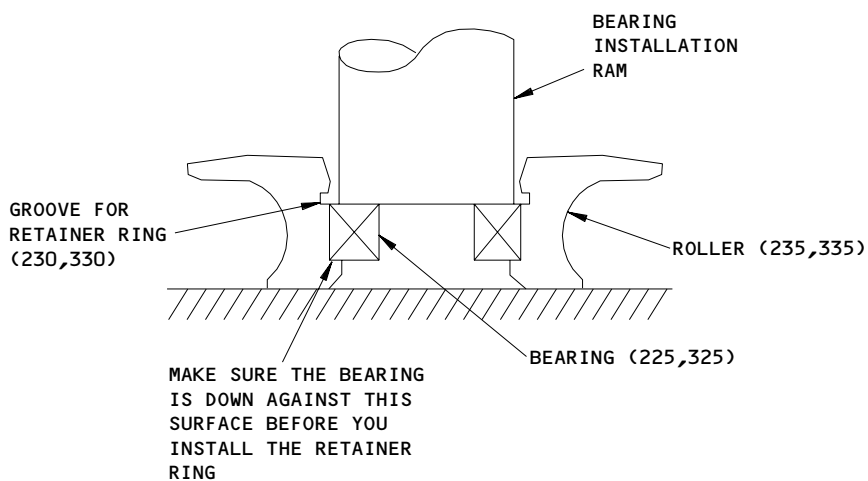
ROLLER ASSEMBLY – REPAIR 2-1

141T6334-1

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

1. Bearing Replacement (225, 325 IPL Fig. 1)

- A. Remove the old bearing.
- B. Press a replacement bearing into the roller (SOPM 20-50-03). Make sure the bearing is fully down before you install the retainer.
- C. Install the retainer ring.



ITEM NUMBERS REFER TO IPL FIG. 1

141T6334-1  
 Bearing Installation  
 Figure 601

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REPAIR 2-1

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FITTING ASSEMBLY – REPAIR 3-1

141T6586-11, -12, -17, -18

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

1. Bushing Replacement (596, IPL Fig. 1)

A. Remove the old bushings.

B. Install replacement bushings by the shrink fit method (SOPM 20-50-03).

2. Refinish

A. Fitting (508, 600) -- Passivate (F-17.25), which replaces F-17.09).  
Apply Vitrolube 1220 lubricant (F-19.83) to surfaces but not in the bore.  
Material: 15-5PH or 17-4PH CRES, 180-200 ksi.

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FAIL SAFE CABLE BRACKET ASSEMBLY – REPAIR 4-1

141T6628-1

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

1. Bushing Replacement (190, IPL Fig. 1)

- A. Remove the old bushing.
- B. Install a replacement bushing by the shrink fit method (SOPM 20-50-03).

2. Refinish

- A. Bracket (195) -- Chromic acid anodize (F-17.04). Apply BMS 10-11, Type 1 primer (F-20.02) to all surfaces but not in holes. Material: Al alloy.

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LOWER TRACK ROLLER SUPPORT ASSEMBLY – REPAIR 5-1

143T6149-1, -2

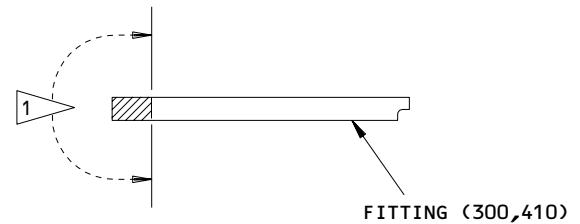
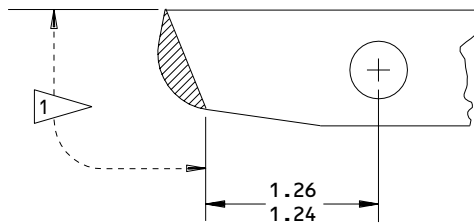
**NOTE:** Refer REPAIR-GEN for a list of applicable standard practices.

1. Bushing Replacement (290, 405 IPL Fig. 1)

- A. Remove the old bushing and the spacer.
- B. Install a replacement bushing, with the spacer (295) under the flange, by the shrink fit method (SOPM 20-50-03).

2. Fitting Refinish (Fig. 601)

- A. Passivate (F-17.25), which replaces F-17.09).
- B. Cadmium plate and apply BMS 10-11, Type 1 primer (F-16.01) unless shown.
- C. Apply Vitrolube 1220 lubricant (F-19.83) as shown.



1 DO NOT CADMIUM PLATE OR APPLY PRIMER.  
 APPLY VITROLUBE 1220 LUBRICANT (F-19.83)  
 TO CROSSHATCHED SURFACE

**REPAIR**  
 (SAME AS REFINISH)

125/ ALL MACHINED SURFACES UNLESS SHOWN  
 DIFFERENTLY

MATERIAL: AL ALLOY

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

143T6149-3,-4  
 Fitting Refinish  
 Figure 601

GUIDE ASSEMBLY – REPAIR 6-1

141T6176-4

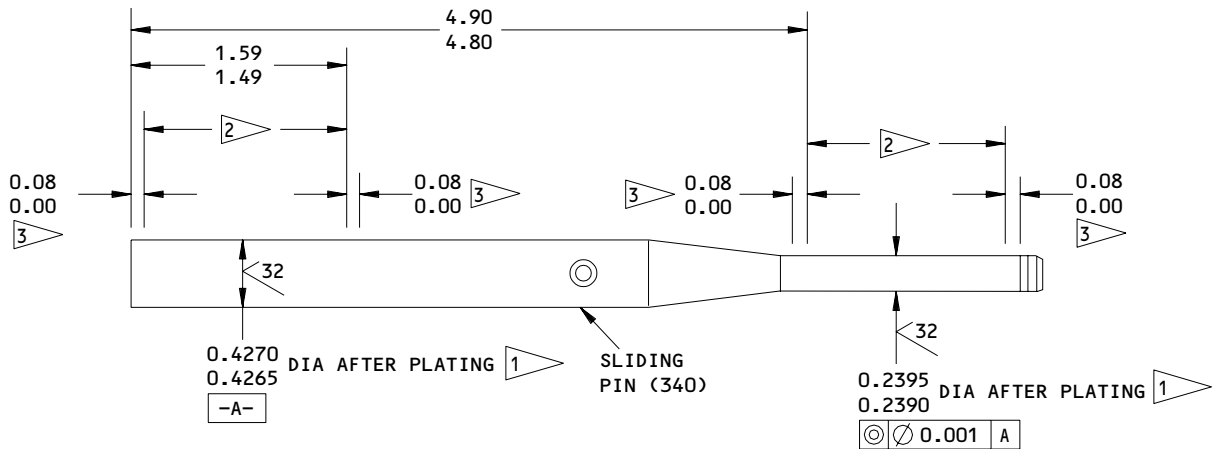
**NOTE:** Refer to REPAIR-GEN for a list of applicable standard practices.

1. Replacement (IPL Fig. 1)

- A. Use standard industry practices and these steps.
- B. Install bolt (315) with grease. Make sure it turns freely.
- C. Tighten bolt (315) to 25-35 pound-inches.
- D. Install rivet (310) and machine the manufactured and driven heads flush or 0.010 inch below the surface.

2. Refinish

- A. Bolt (315) -- Passivate (F-17.25, which replaces F-17.09). Material: 15-5PH CRES, 180-200 ksi.
- B. Sliding Pin (340) -- Passivate (F-17.25, which replaces F-17.09). Chrome plate (F-15.03), 0.001-0.0005 inch thick and grind to dimensions shown in Fig. 601. Material: 15-5 PH CRES, 180-200 ksi.



- 1 CHROME PLATE (F-15.03) 0.002 MINIMUM THICKNESS AFTER GRINDING
- 2 CHROME PLATE THIS AREA
- 3 CHROME PLATE RUNOUT

125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

MATERIAL: 15-5PH CRES, 180-200 KSI  
 ITEM NUMBERS REFER TO IPL FIG. 1  
 ALL DIMENSIONS ARE IN INCHES

141T6123-2  
 Pin Refinish  
 Figure 601

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MID ENTRY DOOR ASSEMBLY – REPAIR 7-1

143T6121-1, -2, -31, -32, -45, -46

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

1. Bushing Replacement (420, IPL Fig. 1)

- A. Remove the old bushing.
- B. Install a replacement bushing by the shrink fit method (SOPM 20-50-03).
- C. Fillet seal around the flange of the bushing with BMS 5-95 sealant.

2. Bearing Replacement (80, 85 IPL Fig. 1)

- A. Remove the old bearings.
- B. Install replacement bearings by the press fit method (SOPM 20-50-03) with wet BMS 5-95 sealant.

3. Door Assembly Refinish

- A. Chemical treat and apply BMS 10-11, Type 1 primer (F-21.121).
- B. Apply white BMS 10-11, Type 1 enamel (F-21.15). Apply this enamel only to areas that were painted white before. Give all other areas protection from overspray.

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MISCELLANEOUS PARTS - REPAIR 8-1

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
Fittings (165,648,650), Bracket (712), Tang (532), Plate (60), Spacer (90,95)	Al alloy	Chromic acid anodize and apply BMS 10-11, Type 1 primer (F-18.13) all over.
Links (240,355)	17-7PH or 15-5PH CRES, 150-170 ksi	Apply Type 6, Class 1 solid film lubricant (F-19.82) all over.
Bolt (250,365)	15-5PH CRES, 180-200 ksi	Cadmium plate and apply BMS 10-11 Type 1 primer (F-16.01) but not on the conical surface of the head. Apply Type 8, solid film lubricant (F-19.10) to the conical surface.
Washer (584), Bolt (586)	15-5PH CRES 150-180 ksi	Passivate (F-17.25, which replaces F-17.09)
Ring (520)	Al alloy	Chemical treat and apply BMS 10-11, Type 1 primer (F-18.06) all over.
Cover (480)	Al alloy	Chemical treat (F-17.40, which replaces F-14.05) all over. Chromic acid anodize and apply BMS 10-11, Type 1 primer (F-18.13) and BMS 10-60, BAC707 grey gloss enamel (F-14.9813, which replaces SRF-14.9813) unless shown in Fig. 602.

Refinish Details  
 Figure 601 (Sheet 1)

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IPL FIG. & ITEM	MATERIAL	FINISH
Spring (500)		Cadmium plate (F-15.06).
Pan (510)	Al alloy	Chromic acid anodize and apply BMS 10-11, Type 1 primer (F-18.13) and BMS 10-11, Type 2 enamel, BAC702 white gloss (F-21.03) all over.
Hinges (504,506)	Al alloy	Anodize (F-17.03). Apply BMS 10-11, Type 1 primer (F-20.02) all over.
Fitting Assy (616,618)	15-5PH CRES 180-200 ksi	141T6588-7,-8: Passivate (F-17.09). Apply Vitrolube 1220 lubricant (F-19.83) to exterior surfaces.  141T6588-13,-14: Apply solid film lubricant (F-19.10) all over.
Lifter Pin (602)	15-5PH CRES 180-200 ksi	Passivate (F-17.09) and apply Vitrolube 1220 lubricant (F-19.83) but not on threads.
Centering Pin (75)	15-5PH CRES 180 ksi minimum	Passivate (F-17.25), which replaces F-17.09). Design dimensions are shown in Fig. 603.
Bracket (739)	Al alloy	Chromic acid anodize and apply BMS 10-11, Type 1 primer (F-18.13) all over, but no primer in 0.190 inch holes.
Bracket (742,745)	15-5PH CRES 180-200 ksi	Passivate (F-17.25, which replaces F-17.09). Cadmium plate and apply BMS 10-11, Type 1 primer (F-16.01) to areas shown in Fig. 604.

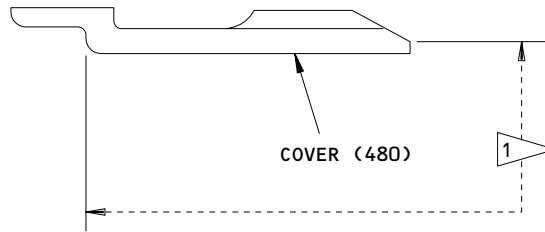
Refinish Details  
 Figure 601 (Sheet 2)

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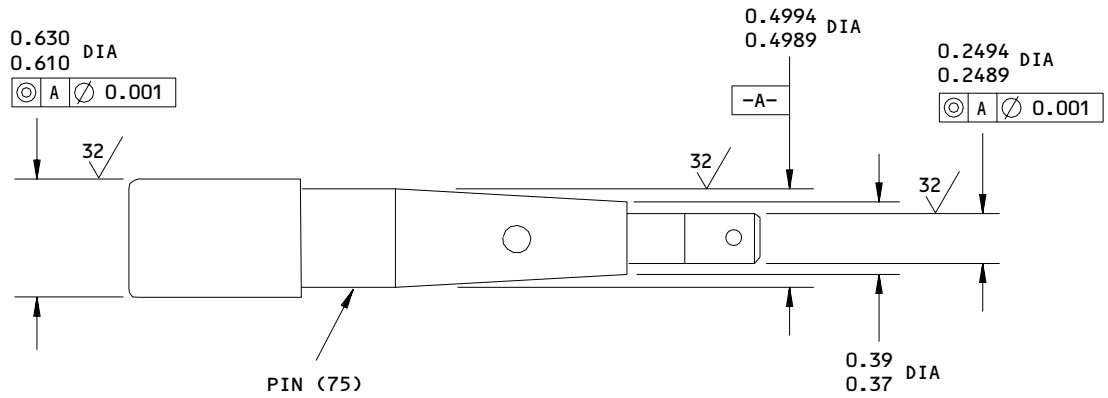


1 SKIN QUALITY SURFACE. NO PRIMER OR ENAMEL

ITEM NUMBERS REFER TO IPL FIG. 1

141T6299-501  
Cover Refinish  
Figure 602

266350



125/ ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

141T6599-1  
Pin Refinish  
Figure 603

266351

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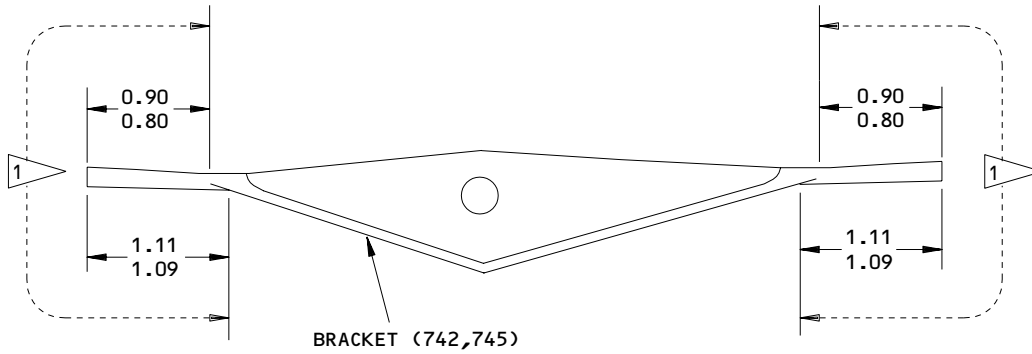
REPAIR 8-1

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01.1





1 CADMIUM PLATE AND APPLY BMS 10-11, TYPE 1  
PRIMER (F-16.01) ON THESE AREAS

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

416T2711-1,-2  
Refinish Details  
Figure 604

266353

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REPAIR 8-1

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ASSEMBLY1. Materials

| NOTE: Equivalent substitutes can be used.

- | A. Adhesive -- Loctite 271 (SOPM 20-50-12)
- | B. Adhesive -- BMS 5-25 Type 2, grade 1 (SOPM 20-50-12)
- | C. Dry Lubricant -- MIL-L-8937 (SOPM 20-50-08)
- | D. Leveling Compound -- BMS 5-125, Type 1 (SOPM 20-60-04)
- | E. Grease -- BMS 3-33 or BMS 3-24 (SOPM 20-60-03)
- | F. Primer -- BMS 10-11, Type 1 (SOPM 20-60-02)
- | G. Sealant -- BMS 5-95 (SOPM 20-60-04)
- | H. Sealant -- BMS 5-32, class B (SOPM 20-60-04)

2. Equipment

| NOTE: Equivalent substitutes can be used.

- A. B52004-1 -- Door Seal Installation tool

3. Assembly (IPL Fig. 1)

| A. Use standard industry practices and these steps.

B. Guide Assembly (305)

- | (1) Apply grease to bolt (315). Put the bolt through the roller assembly (320) and tighten the bolt until the holes in the sliding pin (340) and the bolt are aligned.
- | (2) Install rivet (310) through the sliding pin and bolt. Machine the manufactured and driven heads of the rivet flush to 0.010 inch maximum below the surface.

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C. Handhold Assembly (465)

- (1) Apply Type 6, Class 1 solid film lubricant (F-19.81) to hinge pin (495)
- (2) Install pin (495) and crimp or stake each end of the hinge to hold the pin in position. Make sure the hinge operates freely.
- (3) Temporarily attach cover (480) in the well of the pan (510) until final assembly.

D. Carrier Support Assembly (570, 572)

- (1) Temporarily assemble fitting assembly (570, 572).
- (2) Look for a minimum dimension of 0.064 inch between fitting (608, 610) and fitting assembly (598, 600) per (Fig. 701).
- (3) Make sure that fitting assembly (592, 594) turns freely.

**CAUTION:** BE CAREFUL TO APPLY THE LOCTITE COMPOUND ONLY TO THE THREADS.

- (4) Remove screw (582) and apply Loctite 271 compound. Then install the screw and tighten it.
- (5) Tighten bolt (606) to 10-25 pound inches.
- (6) Adjust spring plunger (580) until the plunger touches the fitting assembly (598, 600), then turn the plunger down 1/2 turn more.

E. Mid Entry Door Assembly (1, 5)

**NOTE:** On the left-hand doors (1), support assemblies (570, 572) and fitting assemblies (616, 618) are as shown in IPL Fig. 1. On the right-hand doors (5), support assembly (570) is on the forward edge of the door; support assembly (572) is on the aft edge; fitting assembly (616) is on the forward edge; fitting assembly (618) is on the aft edge.

- (1) Install all non-aluminum fasteners with wet BMS 5-95 sealant.
- (2) Remove laminations of shim (105) if necessary (Fig. 702), to get 0.007-0.013 inch axial play in centering pin (75) to remove preload in bearings (85, 80).

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**BOEING**  
COMPONENT  
MAINTENANCE MANUAL

- (3) After shim delamination, apply grease between shim (105) and spacer (90, 95).
- (4) Install bolts (25), washers (30) and nuts (40). Because the nuts will be removed to adjust clevis (20) when the door is installed on the airplane, do not tighten the nuts now. Attach a tag to tell that these nuts are not tightened.
- (5) Install bolt (205) with grease. Be sure to fill the cavity under the washer (210) with grease.
- (6) Tighten nut (220) to 25-30 pound-inches. Make sure that roller assembly (200) turns freely.
- (7) Fill the cavity between the door frame structure and the lower track roller support assembly (360) with grease.
- (8) Install guide assembly (305) and apply grease over the full length of the sliding surfaces.  
  
**NOTE:** Guide assembly must slide freely approximately 0.060 inch fore and aft.
- (9) Apply BMS 5-95 sealant to rivets (512) and the mating holes in ring assembly (514) and the door structure. Install ring assembly, with a faying surface seal of BMS 5-95 sealant. Install rivets (512) so that the inboard side of the rivet is flush with the surface (+0.005/-0.000 inch).
- (10) Apply BMS 5-95 sealant to rivets (470) and the mating holes in the handhold assembly (465) and the door structure. Install the handhold assembly with a faying surface seal of BMS 5-95 sealant.
- (11) Remove laminations from replacement shims (646, 614) if necessary, to get the dimensions you found during disassembly. Then apply one coat of BMS 10-11, Type 1 primer to the shims.  
  
**NOTE:** Carrier support assemblies (570, 572) and fittings (648, 650) must be installed on the door in the same positions as they were removed.
- (12) Bond shim (614) to fitting (648, 650) with Type 54 adhesive (SOPM 20-50-12).

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(13) Install doorstops (455).

- (a) Temporarily assemble stops with shims (460).
- (b) Measure the perpendicular dimension from the external skin contour to the face of the stop at 5-inch intervals from the top to the bottom of the door. If the dimension is larger than 0.093 inch, remove 0.003-inch laminations from the full length of shim (460) to make the dimension be 0.093-0.097 inch throughout doorstop length.

**NOTE:** The shim must be of constant thickness throughout its length. Do not remove part of a lamination.

- (c) If you use shims, put the butt splice between shims at the approximate center of the door. Center the splice between fastener locations within  $\pm 0.010$  inch. Make the mismatch between the ends of delaminated shims 0.001 inch maximum. Cut the ends of the shims (460) flush and touch up with colored chemical coating (SOPM 20-43-03) and apply one coat of BMS 10-11, Type 1 primer.
- (d) Apply faying surface seal between the shim and stop and between the shim and door. Install fasteners (425, 440) with wet BMS 5-95.

(14) Install seal (15)

- (a) Put the seal all around the door edge, with the lip of the seal facing outward and approximately equal stretch along the length of the seal. Align the red location indicator marks, on the four corners of the seal and retainer, within 0.50 inch.

**CAUTION:** BE CAREFUL WHEN YOU INSTALL THE SEAL INTO THE RETAINER TO PREVENT DAMAGE TO THE SEAL. DO NOT TAP THE SEAL INTO THE RETAINER. YOU COULD BEND THE SEAL RETAINER LIPS.

- (b) Start on the upper corner of the door, with the location marks aligned, and push the seal under the lips of the seal retainer for approximately 4 inches. Use the B52004-1 door seal installation tool (Fig. 703).
- (c) Do step (B) again at the opposite upper corner, and again keep the location marks aligned within 0.50 inch.

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- (d) Push the seal into the retainer across the top of the door.
- (e) Push the seal into the retainer on the two lower corners of the door. Keep the marks aligned within 0.050 inch.
- (f) Put the seal into the retainer along the bottom of the door and then along the sides. Be careful not to put wrinkles in the seal. Wrinkles in the seal will not let the door seal correctly. This will decrease cabin pressurization and cause wind noises.

(15) Application of Sealant

- (a) Fill the edges of the exterior gap around the window flush with BMS 5-95, class B sealant (SOPM 20-50-11).
- (b) Apply weather fillet seal completely around the seal retainer per Fig. 704.
- (c) Apply pressure fillet seal completely around the seal retainer per Fig. 704.

**CAUTION:** ALL SEALANT MUST BE TACK-FREE BEFORE YOU APPLY THE LEVELING COMPOUND.

- (d) Application of leveling compound (Fig. 704).

**CAUTION:** BE SURE TO PUT THE DOOR IN THE UPRIGHT POSITION (BEAMS HORIZONTAL) OR WITH THE TOP OF THE DOOR TILTED SLIGHTLY FORWARD BEFORE YOU POUR IN THE COMPOUND.

- 1) Clean the area fully.

**CAUTION:** DO NOT MOVE THE DOOR DURING THE WORK LIFE OF THE COMPOUND.

- 2) Pour BMS 5-125, Type 1 leveling compound into the lowest pocket of the structure, as shown.

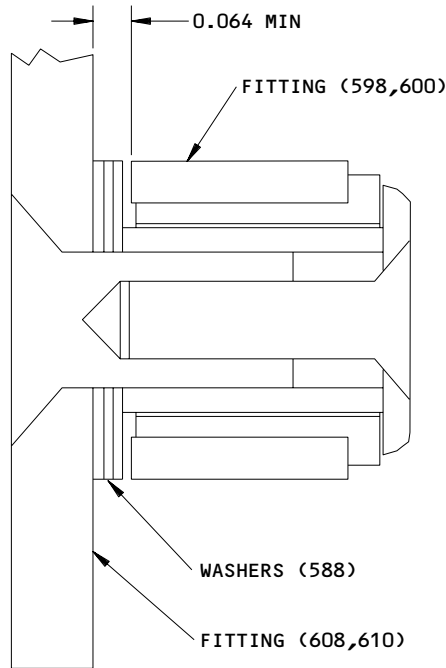
**52-11-04**

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4. Storage

- A. Give protection to the unit and put it away by standard industry practices.
- B. Tie the link (240, 355) in position to help prevent damage.



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

Fitting Clearance  
Figure 701

266476

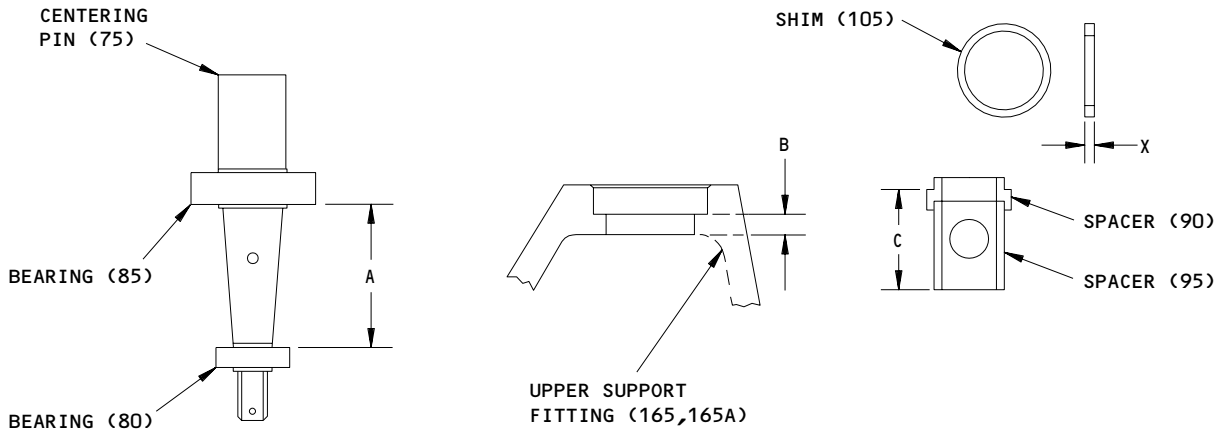
**52-11-04**

ASSEMBLY

01.1

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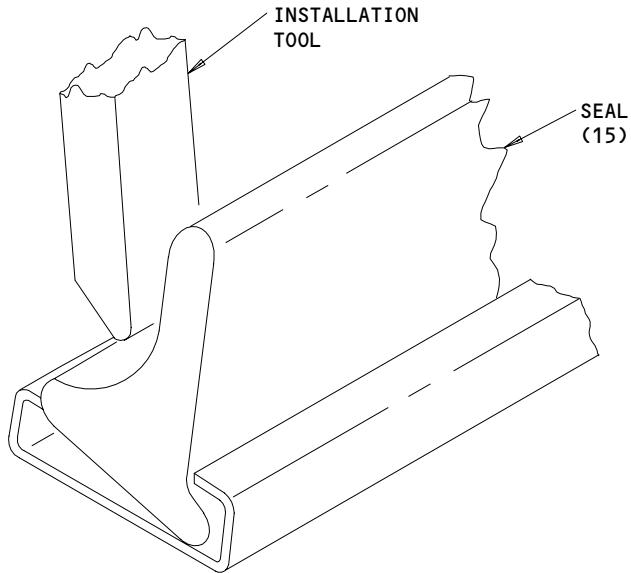


SHIM (105) THICKNESS  $X = A - B - C - 0.010$  INCH

ITEM NUMBERS REFER TO IPL FIG. 1

Shim Thickness Calculation  
Figure 702

266477



Seal Installation Procedure  
Figure 703

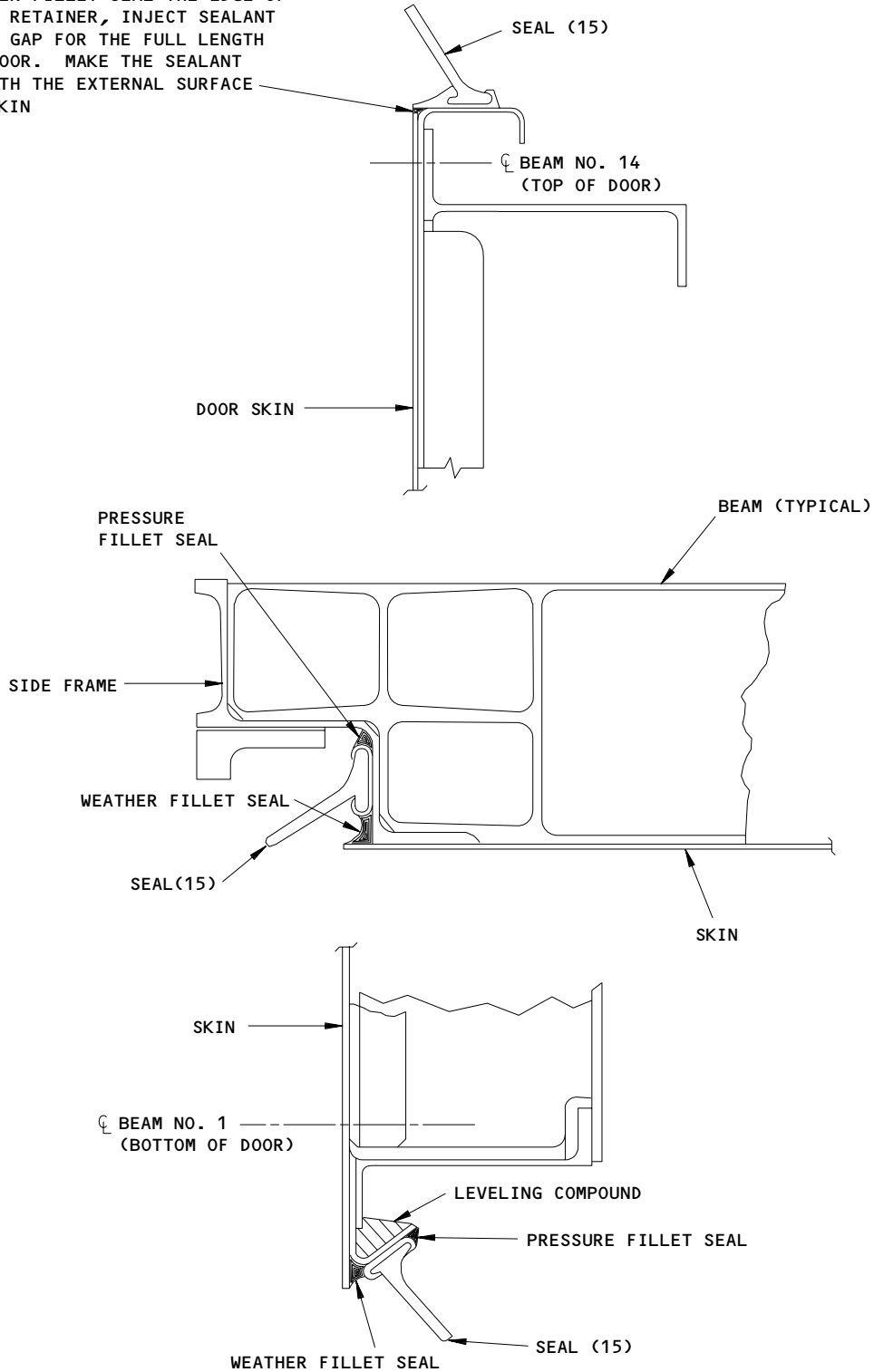
266478

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TO WEATHER FILLET SEAL THE EDGE OF THE SEAL RETAINER, INJECT SEALANT INTO THE GAP FOR THE FULL LENGTH OF THE DOOR. MAKE THE SEALANT FLUSH WITH THE EXTERNAL SURFACE OF THE SKIN



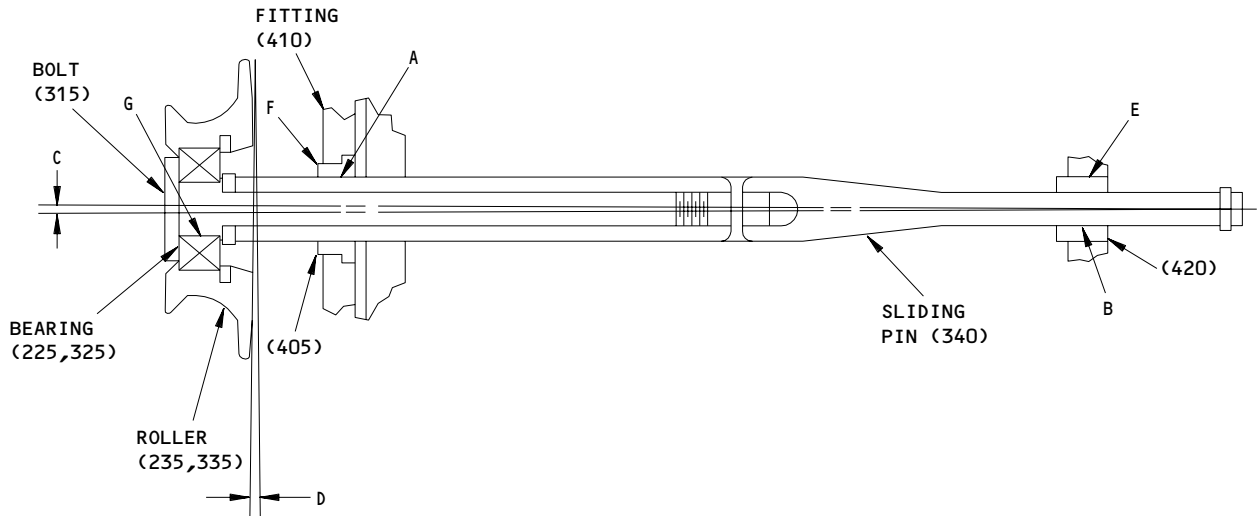
Sealant Application  
 Figure 704

**52-11-04**

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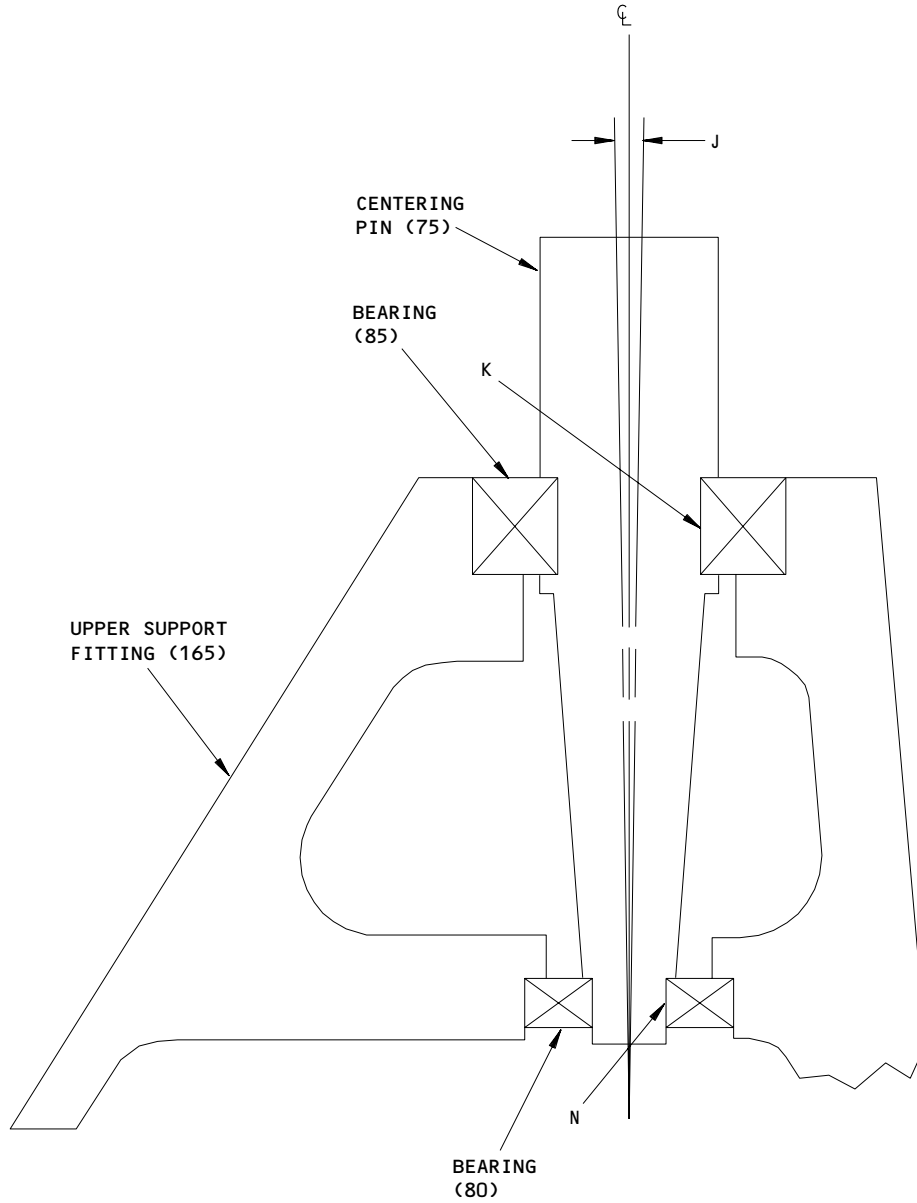
FITS AND CLEARANCES



Fits and Clearances  
Figure 801 (Sheet 1)

**52-11-04**

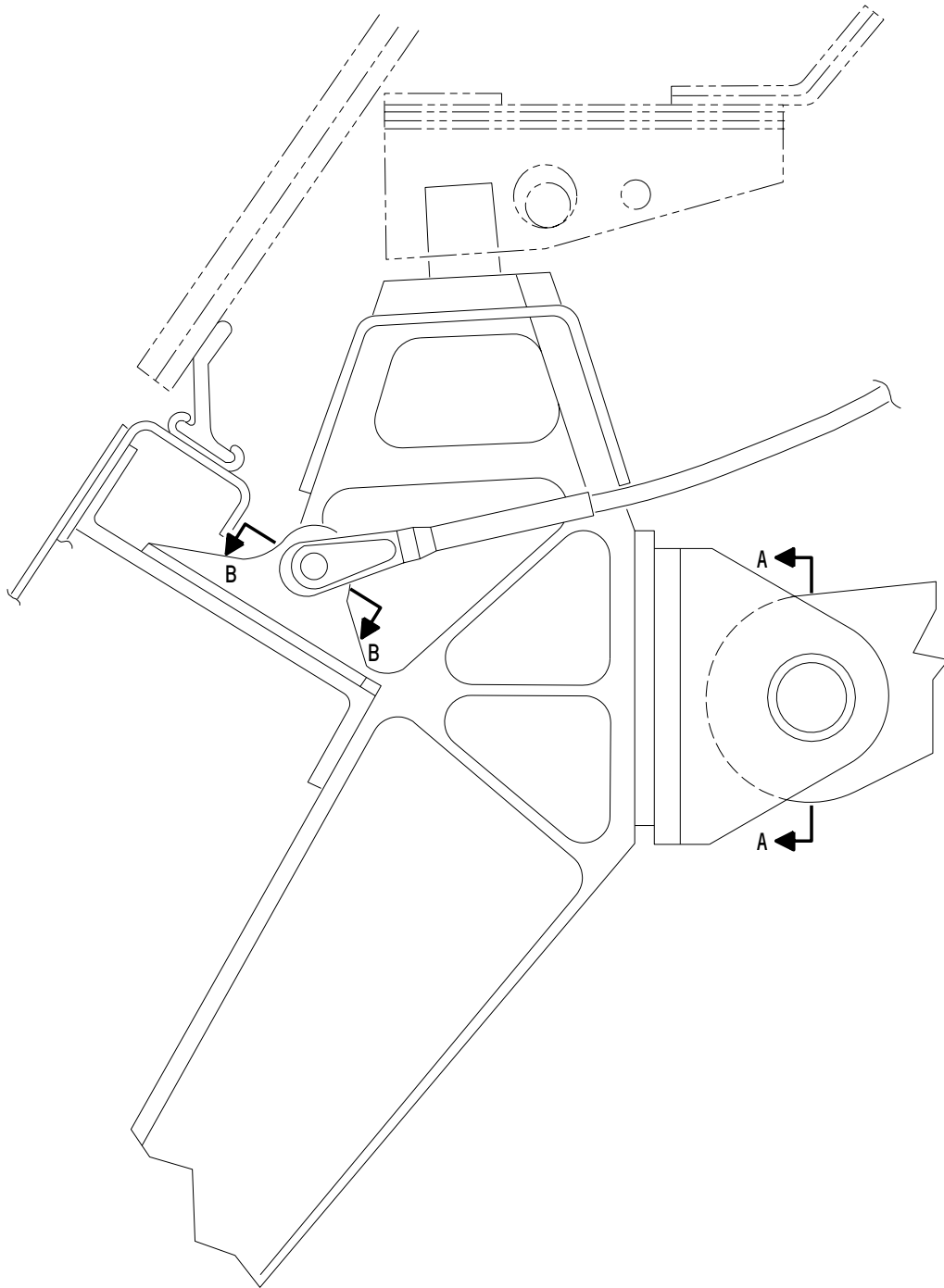
FITS AND CLEARANCES  
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Fits and Clearances  
Figure 801 (Sheet 2)

**52-11-04**

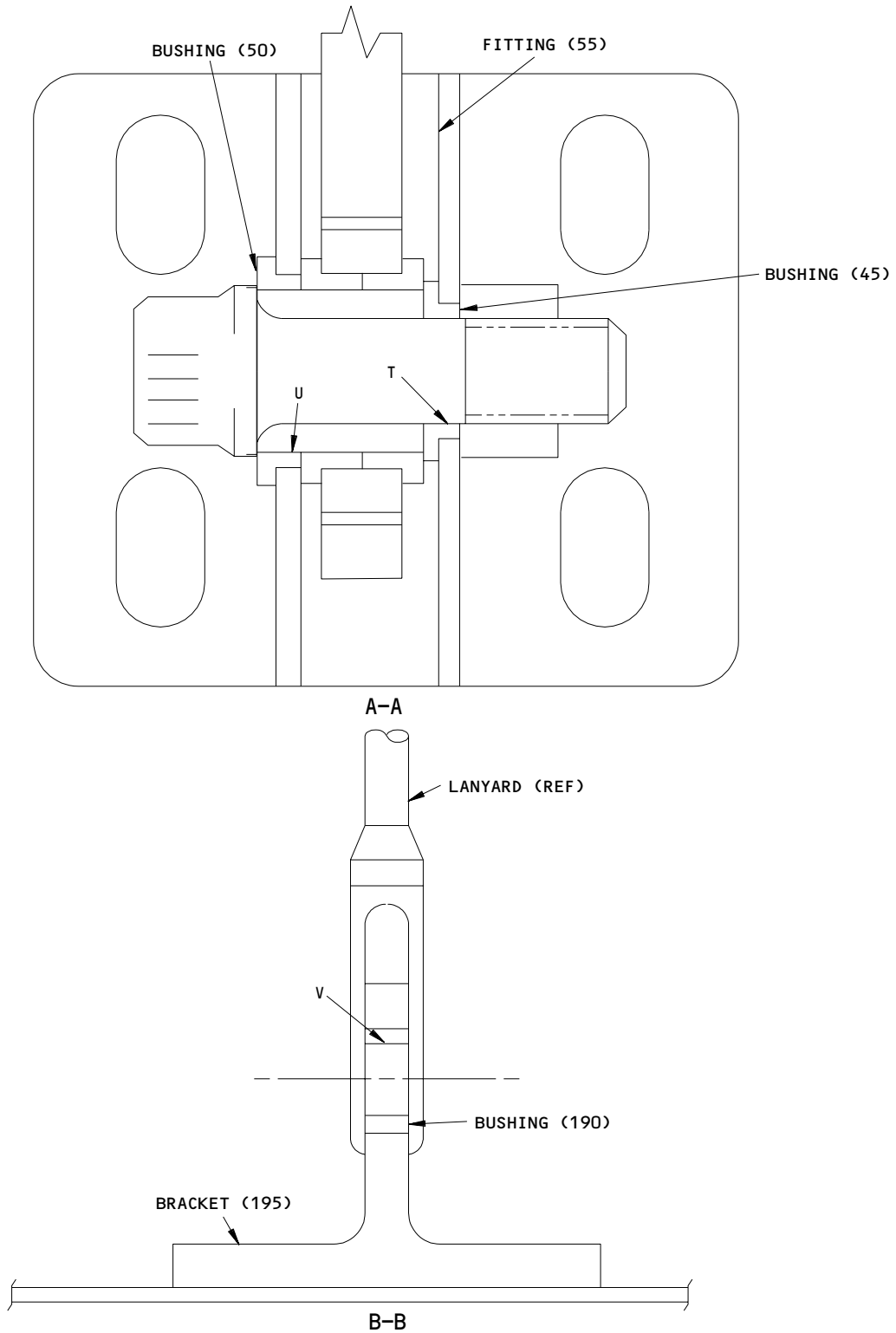
FITS AND CLEARANCES  
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Fits and Clearances  
Figure 801 (Sheet 3)

**52-11-04**

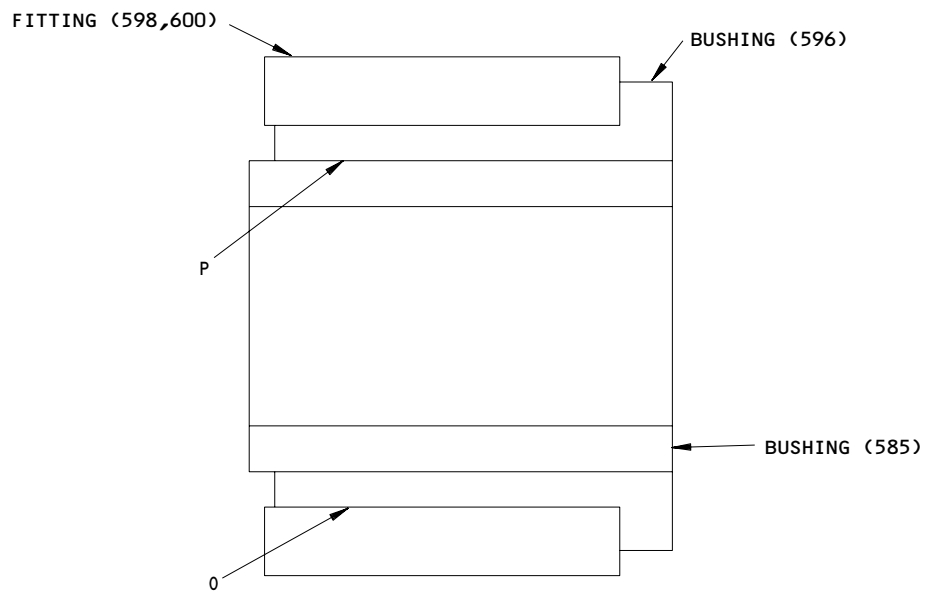
FITS AND CLEARANCES  
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Fits and Clearances  
Figure 801 (Sheet 4)

**52-11-04**








FITS AND CLEARANCES  
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Fits and Clearances  
Figure 801 (Sheet 5)

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FITS AND CLEARANCES  
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Ref Letter Fig.801	Mating Item No. IPL Fig.1	Design Dimension				Service Wear Limits		
		Dimension		Assembly Clearance 		Dimensions		Maximum Clearance
		Min	Max	Min	Max	Min	Max	
A	ID 405	0.4375	0.4390	0.0105	0.0125	0.4125	0.4520	0.0250
	OD 340	0.4265	0.4270					
B	ID 420	0.2500	0.2515	0.0105	0.0125	0.2400	0.2495	0.010
	OD 340	0.2390	0.2395					
C	305							
D	320							
E	ID 10	0.3750	0.3756	-0.0011	0.000			0.0000
	OD 420	0.3756	0.3761					
F	ID 410	0.5625	0.5631	-0.0013	0.0000			0.0000
	OD 405	0.5631	0.5638					
G	ID 225,325	0.2495	0.2500	-0.0002	0.0008	0.2479	0.2513	0.0016
	OD 315	0.2492	0.2497					
J	75							
K	ID 85	0.4995	0.5000	0.0001	0.0011	0.4973	0.5016	0.0022
	OD 75	0.4989	0.4994					
N	ID 80	0.2495	0.2500	0.0001	0.0011	0.2473	0.2516	0.0022
	OD 75	0.2489	0.2494					
P	ID 596	0.4380	0.4390	0.0010	0.0025	0.4330	0.4420	0.0050
	OD 585	0.4365	0.4370					
T	ID 45	0.3125	0.3140	0.0005	0.0025	0.3075	0.3170	0.0050
	OD 	0.3115	0.3120					
U	ID 50	0.4375	0.4390	0.0005	0.0025	0.4325	0.4420	0.0050
	OD 	0.4365	0.4370					
V	ID 190	0.2500	0.2515	0.0020	0.0055	0.2390	0.2590	0.0110
	OD 	0.2460	0.2480					

Fits and Clearances  
Figure 801 (Sheet 6)

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FITS AND CLEARANCES  
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- 1 > NEGATIVE VALUES ARE AN INTERFERENCE FIT
- 2 > 0.030 MAX FREEPLAY ON SHAFT
- 3 > 2° MAX FREEPLAY ON ROLLER
- 4 > 0.020 MAX FREEPLAY ON PIN
- 5 > BOLT BACB30LE5U21 (INSTALLATION PART)
- 6 > BUSHING BACB28AK05-040 (INSTALLATION PART)
- 7 > PIN MS20392-2C15 (INSTALLATION PART)

ALL DIMENSIONS ARE IN INCHES

Fits and Clearances  
Figure 801 (Sheet 7)

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FITS AND CLEARANCES  
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FITS AND CLEARANCES

|

FOR TORQUE VALUES OF STANDARD FASTENERS, REFER TO SOPM 20-50-01			
ITEM NO. FIG. 1	NAME	TORQUE	
		POUND-INCHES	POUND-FEET
220	Nut	25-30	
315	Bolt	25-35	
606	Nut	10-25	

Torque Table  
 Figure 802

**52-11-04**



SPECIAL TOOLS, FIXTURES AND EQUIPMENT

**NOTE:** Equivalent substitutes can be used.

1. B52004-1 -- Door Seal Installation Tool

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SPECIAL TOOLS

01.1

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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

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Jul 10/87

VENDORS

OPTK6 SPS TECHNOLOGIES INC AEROSPACE PRODUCTS DIV  
5195 W 4700 SPO BOX 18459  
KEARNS, UTAH 84118

01226 BARRY WRIGHT CORP VLIER ENG DIV  
2333 VALLEY STREET  
BURBANK, CALIFORNIA 91505-1336  
FORMERLY IN LOS ANGELES, CALIFORNIA  
FORMERLY VLIER ENG DIV OF BARRY WRIGHT CORP

06144 INDUSTRIAL TECTONICS BEARING CORP  
18301 SOUTH SANTA FE AVENUE  
RANCHO DOMINGUEZ, CALIFORNIA 90221  
FORMERLY IN COMPTON, CALIFORNIA

06725 AIR INDUSTRIES CORPORATION  
12570 KNOTT STREET  
GARDEN GROVE, CALIFORNIA 92641-3932  
FORMERLY AIR INDUSTRIES OF CALIF IN GARDENA, CALIF.

06950 SCREWCORP VSI AEROSPACE PRODUCTS DIV FAIRCHILD IND DIV  
13001 EAST TEMPLE AVENUE PO BOX 730  
CITY OF INDUSTRY, CALIFORNIA 91746-1417  
FORMERLY VB0096 AND VSI CORP SCREWCORP DIV  
FORMERLY IN CULVER CITY, CALIFORNIA

08524 DEUTSCH FASTENER CORP SEE CODE V97928

10630 ANILLO INDUSTRIES, INCORPORATED  
2090 NORTH GLASSELL  
ORANGE, CALIFORNIA 92667  
FORMERLY WESTERN WASHER DIV OF SENG CO V87487

11815 CHERRY AEROSPACE FASTENERS DIV OF TEXTRON  
1224 EAST WARNER AVENUE PO BOX 2157  
SANTA ANA, CALIFORNIA 92707-0157  
FORMERLY IN LOS ANGELES, CALIF , FORMERLY CHERRY FASTENERS  
TOWNSEND DIV OF TEXTRON INC V71087

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

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 **BOEING**  
COMPONENT  
MAINTENANCE MANUALVENDORS

17446 HUCK INTL INC AEROSPACE FASTENER DIV  
900 WATSON CENTER ROAD  
CARSON, CALIFORNIA 90745-4201  
FORMERLY V32134 REXNORD INC; FORMERLY V97928 HUCK INTL

21335 TORRINGTON CO FAFNIR BEARING DIV  
59 FIELD STREET  
TORRINGTON, CONNECTICUT 06790-1008  
FORMERLY FAFNIR BRG AND TEXTRON INC FAFNIR DIV IN  
NEW BRITAIN, CONNECTICUT

21760 SCHATZ MANUFACTURING CO  
FAIRVIEW AVENUE PO BOX 1191  
POUGHKEEPSIE, NEW YORK 12601  
FORMERLY FEDERAL BRG CO AND SCHATZ MFG CO V53268  
FORMERLY SCHATZ MFG CO

38443 MRC BEARINGS  
402 CHANDLER STREET  
JAMESTOWN, NEW YORK 14701-3802  
FORMERLY MARLIN-ROCKWELL CORP DIV TRW AND TRW INC

40920 MPB MINIATURE PRECISION BEARING DIV  
PRECISION PARK PO BOX 547  
KEENE, NEW HAMPSHIRE 03431  
FORMERLY MPB CORP AND MINIATURE BRG DIV MPB CORP

43991 FAG BEARING INCORPORATED  
118 HAMILTON AVENUE  
STAMFORD, CONNECTICUT 06904  
FORMERLY NORMA-HOFFMAN BEARING CORPORATION  
FORMERLY NORMA FAG BEARINGS CORPORATION

5M902 FAIRCHILD IND INC FAIRCHILD AEROSPACE FASTENER DIV  
3016 W LOMITA BLVD  
TORRANCE, CALIFORNIA 90505-5103  
FMLY IN REDONDO BEACH, CALIF

50744 KIRKHILL-TA CO/SFS DIV  
300 E CYPRESS STREET  
BREA, CALIFORNIA 92821-4007  
FORMERLY SFS IND; FORMERLY BURKE RUBBER SFS DIV

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

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VENDORS

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

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

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

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

71985 DOW-ELCO INCORPORATED  
1313 W OLYMPIC BOULEVARD, PO BOX 669  
MONTEBELLO, CALIFORNIA 90641-5010

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

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

80539 SPS TECHNOLOGIES INC AEROSPACE PRODUCTS DIV  
2701 SOUTH HARBOR BOULEVARD PO BOX 1259  
SANTA ANA, CALIFORNIA 92702-1259  
FORMERLY NUTT-SHEL DIV OF SPC WESTERN CO V80539  
AND STANDARD PRESSED STEEL WESTERN DIV V17279

80756 SPIROLOX DIV OF KAYDON CORP  
29 CASSENS COURT  
FENTON, MISSOURI 63026-2543  
FORMERLY RAMSEY CORP, TRW INC RAMSEY CORP IN MANCHESTER MO.

83086 NEW HAMPSHIRE BALL BEARING, INC HITECH DIVISION  
172 JAFFREY ROAD  
PETERBOROUGH, NEW HAMPSHIRE 03458

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ILLUSTRATED PARTS LIST  
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VENDORS

92215 FAIRCHILD IND INC FAIRCHILD AEROSPACE FASTENER DIV  
3010 W LOMITA BLVD  
TORRANCE, CALIFORNIA 90505-5102  
FORMERLY VOI-SHAN IN CULVER CITY, CALIF

97928 SEE V17446 HUCK INTL  
SEE V17446 HUCK INTL  
HUCK INTL SEE V17446 HUCK INTL

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
AN42BC5		1	686	2
AN960C10		1	689	2
AN960JD10		1	430	86
AN960PD416L		1	604	2
AS46-3		1	445	2
BACB10BX04		1	85B	1
BACB10BX08		1	80B	1
BACB28AK05-061		1	585	2
BACB28AR07A050		1	596	2
BACB28X4C091		1	290A	1
BACB28X5C023		1	45	1
BACB28X7M017		1	405	1
BACB28X7M023		1	50	1
BACB28Y4M016		1	190	1
BACB30LH3-5		1	582A	2
BACB30LR3PU5		1	582	2
BACB30MR4K13		1	25	4
BACB30MY5K2		1	748	6
BACB30MY6K3		1	145	4
		1	632	4
BACB30MY6K4		1	155	1
		1	265	3
		1	380	3
		1	634	6
		1	638	6
BACB30MY6K5		1	270	1
		1	385	1
		1	642	4
BACB30MY6K6		1	150	3
		1	640	2
		1	715	4

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACB30MY6K7		1	718	10
BACB30MY6K8		1	706	2
		1	721	10
BACB30MY8K8		1	280	1
		1	395	1
BACB30NM4K10		1	574	4
BACB30NN4K8		1	620	4
BACB30NT3K6		1	425	86
BACB30NT3K8		1	440	2
BACB30NX6K11		1	122	3
BACB30NX6K13		1	115A	1
BACB30NX6K4		1	180	4
BACB30NX6K7		1	110	2
BACC30AG6		1	160	8
BACC30AG6		1	644	6
		1	709	2
BACC30M5		1	751	6
BACC30M6		1	275	4
		1	390	4
		1	636	10
		1	645	6
		1	730	16
BACC30M8		1	285	1
		1	400	1
BACC30X6		1	185	4
BACC30X6S		1	140	6
BACF3T04H26S14		1	736	1
BACN10JC3		1	435	86
BACN10JC3CM		1	692	2
BACN10JC4		1	606	2
BACN10JC4CD		1	70A	1
BACN10JR3F		1	518	4
BACN10MT3		1	450	2
BACN11AG4		1	220A	1
BACR15BA3AD		1	310	1
		1	516	8
BACR15BA4AD		1	415	1

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACR15BB4AD		1	543	96
		1	566	20
BACR15BB4ADC		1	545	79
BACR15CE5KE		1	490	4
BACR15CE6KE		1	475	2
BACR15FT5KEC		1	547	8
BACR15FT6KE		1	695	16
BACR15FV6KE		1	470	22
		1	512	24
BACS40R007E020F		1	170A	1
BACS40R008E025F		1	646B	2
BACS40R014D026F		1	614A	2
BACS40R027C032F		1	65A	1
BACW10AU3		1	445	2
BACW10CA3CC		1	135	6
		1	724	10
BACW10CA3CV		1	130	6
		1	727	10
BACW10P115S		1	590	2
BACW10P163A		1	588	6
BRF200A3		1	518	4
BRH10A3		1	435	86
BRH10A4		1	606	2
BRH10C3M		1	692	2
BRH10C4D		1	70A	1
B30MY5K2		1	748	6
B30MY6K3		1	145	4
		1	632	4
B30MY6K4		1	155	1
		1	265	3
		1	380	3
		1	634	6
		1	638	6
B30MY6K5		1	270	1
		1	385	1
		1	642	4
B30MY6K7		1	718	10
B30MY6K8		1	706	2
		1	721	10
B30MY8K8		1	280	1
		1	395	1
DE786		1	670	10
F5000-3BAC		1	518	4
HL10VAZ5-2		1	748	6

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 COMPONENT  
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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
HL10VAZ6-3		1	145	4
		1	632	4
HL10VAZ6-4		1	155	1
		1	265	3
		1	380	3
		1	634	6
		1	638	6
HL10VAZ6-5		1	270	1
		1	385	1
		1	642	4
HL10VAZ6-6		1	150	3
		1	640	2
		1	715	4
HL10VAZ6-7		1	718	10
HL10VAZ6-8		1	706	2
		1	721	10
HL10VAZ8-8		1	280	1
		1	395	1
HL1012AZ6-11		1	122	3
HL1012AZ6-13		1	115A	1
HL1012AZ6-4		1	180	4
HL1012AZ6-7		1	110	2
HL1187-6		1	185	4
HL1187DU6		1	140	6
HL12VAZ6-11		1	122	3
HL12VAZ6-13		1	115A	1
HL12VAZ6-4		1	180	4
HL12VAZ6-7		1	110	2
HL70-5		1	751	6
HL79-5		1	751	6
HL79-6		1	275	4
		1	390	4
		1	636	10
		1	645	6
		1	730	16

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
HL79-8		1	285	1
		1	400	1
HL82-6APBW		1	160	8
		1	644	6
		1	709	2
HL87-6		1	185	4
HL87DU6		1	140	6
H01-3BAC		1	692	2
H10-3BAC		1	435	86
H10-4BAC		1	606	2
H19700P3		1	450	2
H51650-4BAC		1	70A	1
KP04A		1	85B	1
KP04AFS428		1	85B	1
KP04ALY196		1	85B	1
KP04ANJC8		1	85B	1
KP04ASD610		1	85B	1
KP04A2TS		1	85B	1
KP08A		1	80B	1
KP08ALY196		1	80B	1
KP08ANJC		1	80B	1
KP08ASD610		1	80B	1
KP08A2TS		1	80B	1
KP4AE		1	85B	1
KP4AP		1	85B	1
KP8AE		1	80B	1
KP8AFS428		1	80B	1
KP8AP		1	80B	1
KP8E		1	80B	1
KP8P		1	80B	1
K19701P3		1	445	2
K29646-3		1	130	6
		1	727	10
K29913-3		1	135	6
		1	724	10

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
LLKP04A		1	85B	1
LLKP08A		1	80B	1
L8006K6		1	150	3
		1	640	2
		1	715	4
L802-6K11		1	122	3
L802-6K13		1	115A	1
L802-6K4		1	180	4
L802-6K7		1	110	2
MS16632-4023		1	345	1
MS16633-4025		1	345A	1
MS20253P2-350		1	495	1
MS27253F4		1	675	1
MS27641-4		1	85	1
MS27641-4G		1	225	1
		1	325	1
MS27641-8		1	80	1
NAS1149C0463R		1	210A	3
NAS1149D0416J		1	255A	4
		1	370A	4
NAS1149D0463P		1	576A	8
NAS1149E0432P		1	622A	4
NAS1149E0463P		1	30A	4
NAS1149F0463P		1	100A	1
NAS1805-4L		1	40A	4
		1	260A	1
		1	375A	1
		1	578A	4
		1	624A	4
NAS42DD4-63		1	502	1
NAS43HT6-3		1	295	1
NNS62N003		1	580	2
NS103203-02		1	518	4
NS202101-02		1	435	86

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
NS202101-048		1	606	2
NS202101SE02		1	692	2
NS202486-048		1	70A	1
RMF9201-3		1	518	4
RMLH9075-3W		1	435	86
RMLH9075-4W		1	606	2
RRN75S		1	230	1
		1	330	1
SF15-120-19		1	15B	1
		1	564P	1
SF15-120-7		1	15	1
S140T263-19		1	564P	1
S140T263-7		1	15	1
S411T100-101		1	670	10
S411T100-107		1	670A	10
TLN1020-3N		1	450	2
TLN1020L3W		1	445	2
T6C1032JM		1	692	2
T6C428JCD		1	70A	1
T6S1032J		1	435	86
T6S428J		1	606	2
T8091S1032		1	518	4
VN152A1-02		1	518	4
VN303A02		1	435	86
VN303A048		1	606	2
VN303D02		1	692	2
102LH9075-4W		1	70A	1
109LH9075-3W		1	692	2
141T6123-2		1	340	1
141T6127-3		1	514	1
141T6127-4		1	520	1
141T6127-5		1	514A	1
141T6127-6		1	520A	1
141T6141-6		1	355	1
141T6141-7		1	240	1
141T6142-1		1	60	1
141T6142-6		1	60A	1
141T6143-5		1	55	1
141T6143-6		1	20	1
141T6143-7		1	35	2
141T6147-7		1	455A	2
141T6176-4		1	305	1
141T6235-1		1	460	2
		1	464	2
141T6235-2		1	461	4
		1	463	4

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
141T6255-3		1	250	1
		1	365	1
141T6290-2		1	500	2
141T6290-3		1	485	1
141T6290-5		1	504	1
141T6290-501		1	465	1
141T6290-7		1	506	1
141T6291-1		1	510	1
141T6299-501		1	480	1
141T6334-1		1	200	1
		1	320	1
141T6334-2		1	235	1
		1	335	1
141T6501-2		1	508A	1
141T6545-7		1	612	2
141T6586-11		1	592	1
141T6586-12		1	594	1
141T6586-13		1	598	1
141T6586-14		1	600	1
141T6586-17		1	592A	1
141T6586-18		1	594A	1
141T6586-19		1	598A	1
141T6586-20		1	600A	1
141T6587-10		1	610	1
141T6587-9		1	608	1
141T6588-13		1	616A	1
141T6588-14		1	618A	1
141T6588-15		1	628B	1
141T6588-16		1	630B	1
141T6588-19		1	616C	1
141T6588-20		1	618C	1

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
141T6588-21		1	628C	1
141T6588-22		1	630C	1
141T6588-3		1	628	1
141T6588-4		1	630	1
141T6588-7		1	616	1
141T6588-8		1	618	1
141T6589-1		1	626	2
141T6589-2		1	626A	2
141T6591-10		1	572	1
141T6591-9		1	570	1
141T6592-4		1	602	2
141T6599-1		1	75	1
141T6616-4		1	90	1
141T6616-5		1	95	1
141T6625-1		1	584	2
141T6626-1		1	586	2
141T6628-1		1	175	1
141T6628-3		1	195	1
141T6631-1		1	105	1
141T6640-2		1	205	1
141T6640-502		1	205A	1
141T6641-1		1	420	1
141T6642-1		1	315	1
143T6121-1		1	1	RF
143T6121-17		1	557	1
143T6121-18		1	555	1
143T6121-19		1	559	1
143T6121-2		1	5	RF
143T6121-20		1	553	1
143T6121-21		1	561	1
143T6121-22		1	551	1
143T6121-23		1	562P	1
143T6121-24		1	563P	1
143T6121-25		1	563	1
143T6121-3		1	10	1

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
143T6121-31		1	1A	RF
143T6121-32		1	5A	RF
143T6121-33		1	10A	1
143T6121-34		1	462	2
143T6121-43		1	10B	1
143T6121-45		1	1B	RF
143T6121-46		1	5B	RF
143T6128-1		1	165	1
143T6128-3		1	165A	1
143T6128-5		1	165C	1
143T6128-7		1	165B	1
143T6149-1		1	245	1
143T6149-2		1	360	1
143T6149-3		1	300	1
143T6149-4		1	410	1
143T6182-3		1	648A	1
143T6182-4		1	650A	1
416T2191-1		1	698	2
416T2192-1		1	733	10
416T2195-2		1	739	4
416T2197-501		1	701	1
416T2197-502		1	703	1
416T2204-9		1	712	6
416T2309-1		1	754	4
416T2710-1		1	680	1
416T2710-2		1	683	1
416T2711-1		1	742	2
416T2711-2		1	745	2
52LH6073-02		1	450	2
53488-1032		1	450	2
53488W1032		1	445	2
6073-0		1	445	2
66014-5		1	751	6
66014-6		1	275	4
		1	390	4
		1	636	10
		1	645	6
		1	730	16

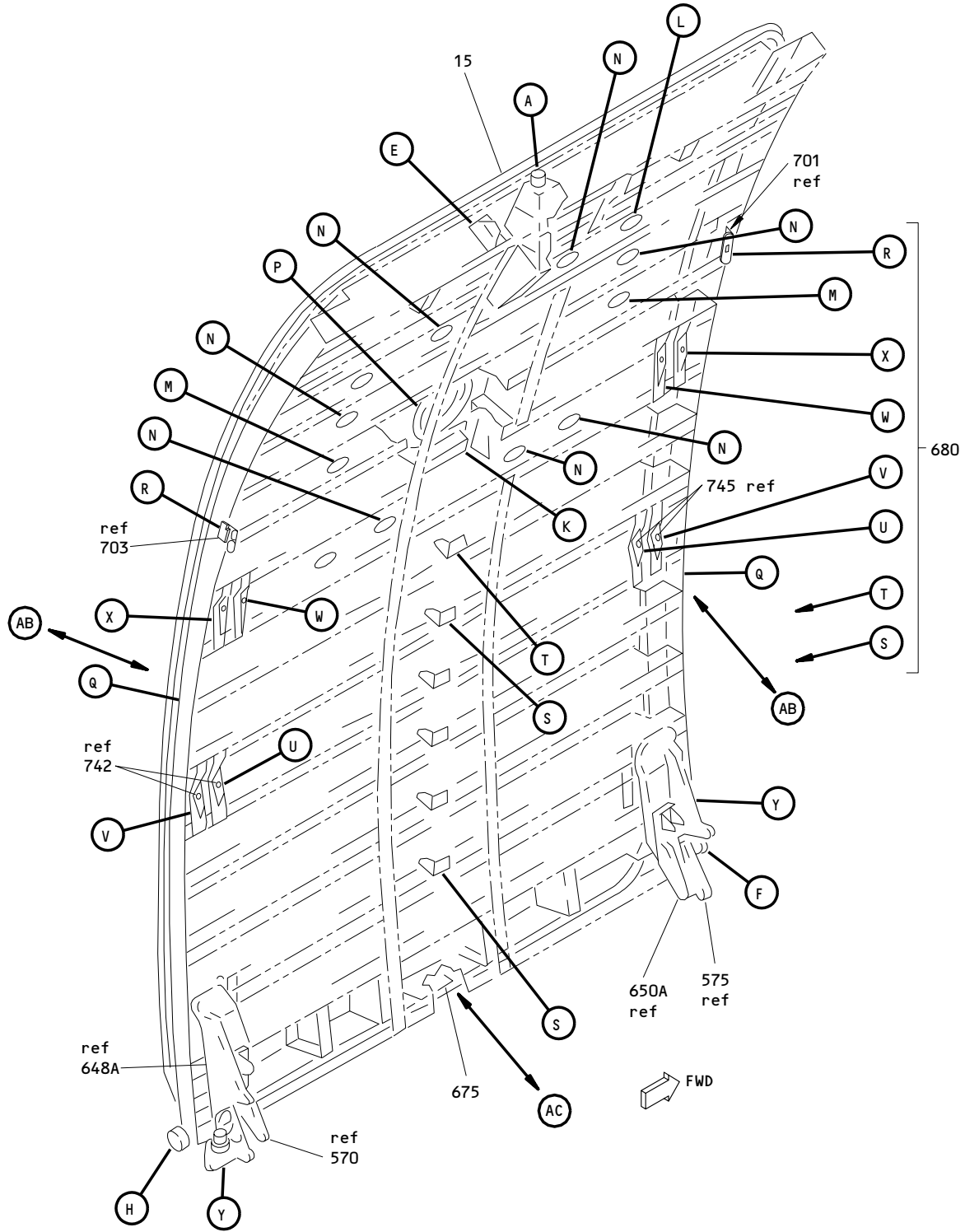
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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
66014-8		1	285	1
		1	400	1
70188-3		1	130	6
		1	727	10
70191-3		1	135	6
		1	724	10
922007-3		1	130	6
		1	727	10
922008-3		1	135	6
		1	724	10
942007-3		1	130	6
		1	727	10
942008-3		1	135	6
		1	724	10
96-02		1	435	86
96-048		1	606	2
97E02		1	692	2

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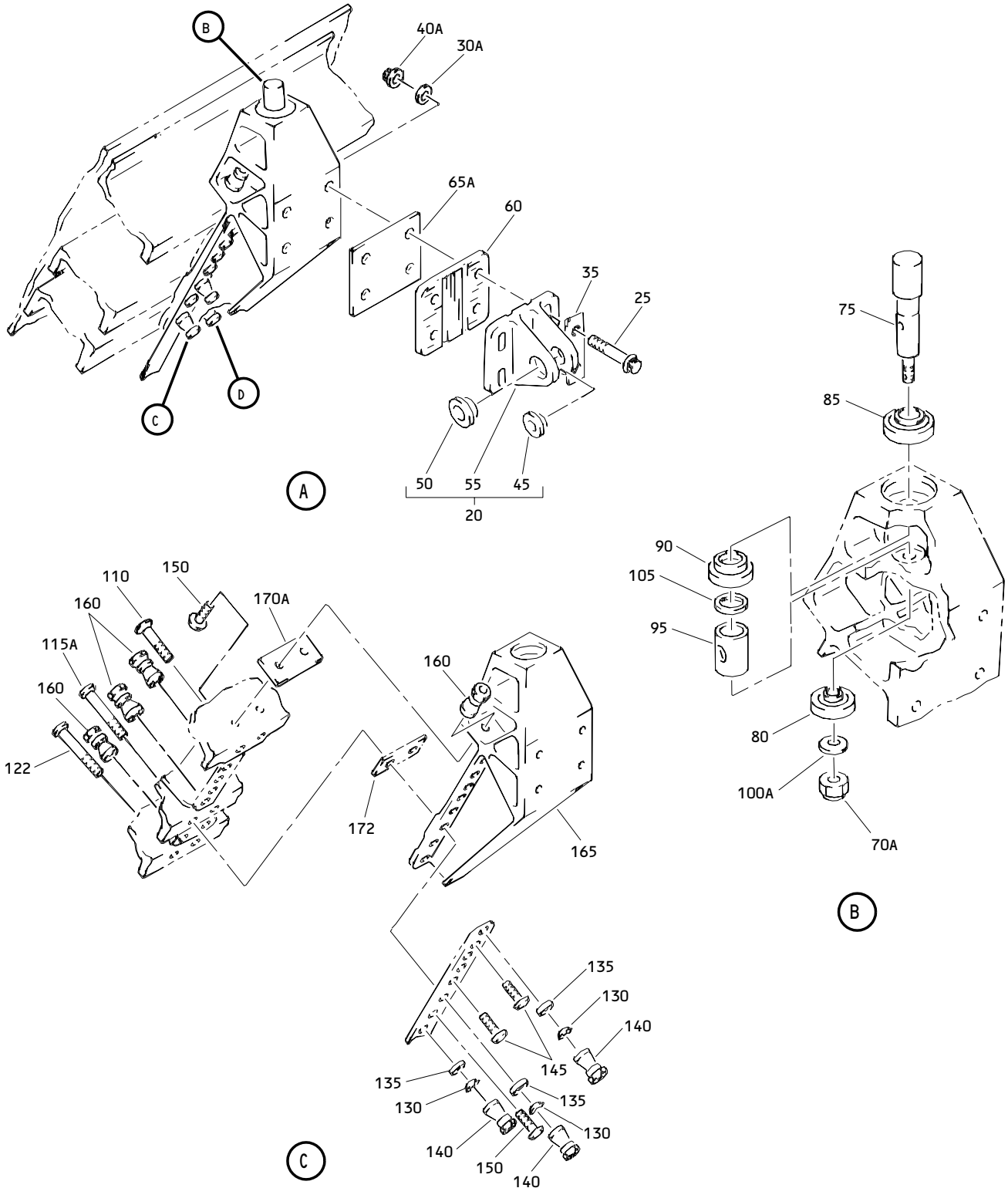


Mid Entry Door Assembly  
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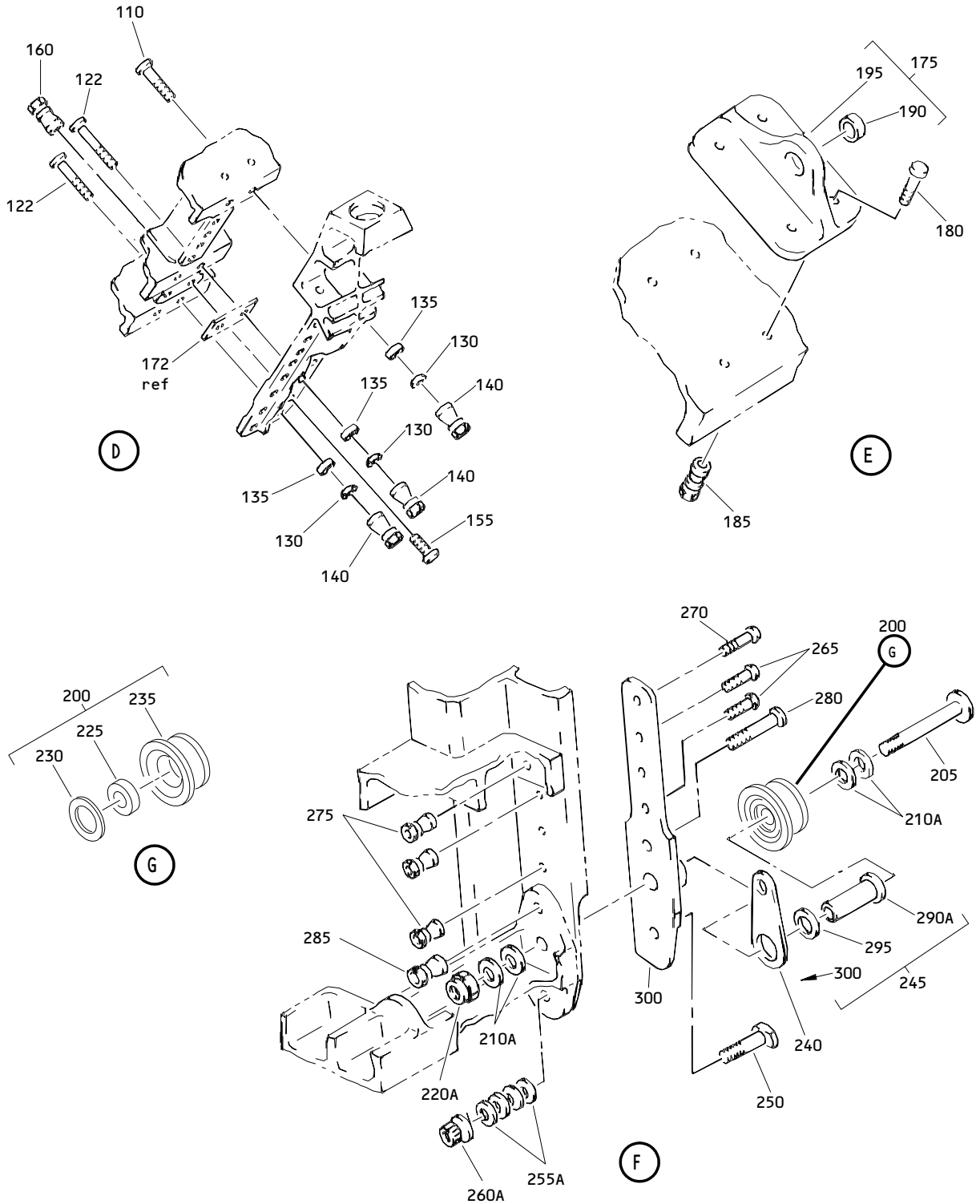
**COMPONENT  
MAINTENANCE MANUAL**



**Mid Entry Door Assembly  
Figure 1 (Sheet 2)**

**52-11-04**

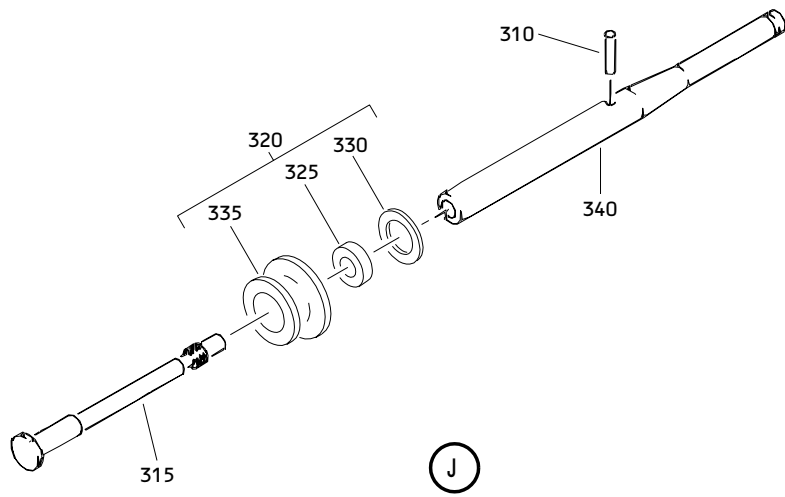
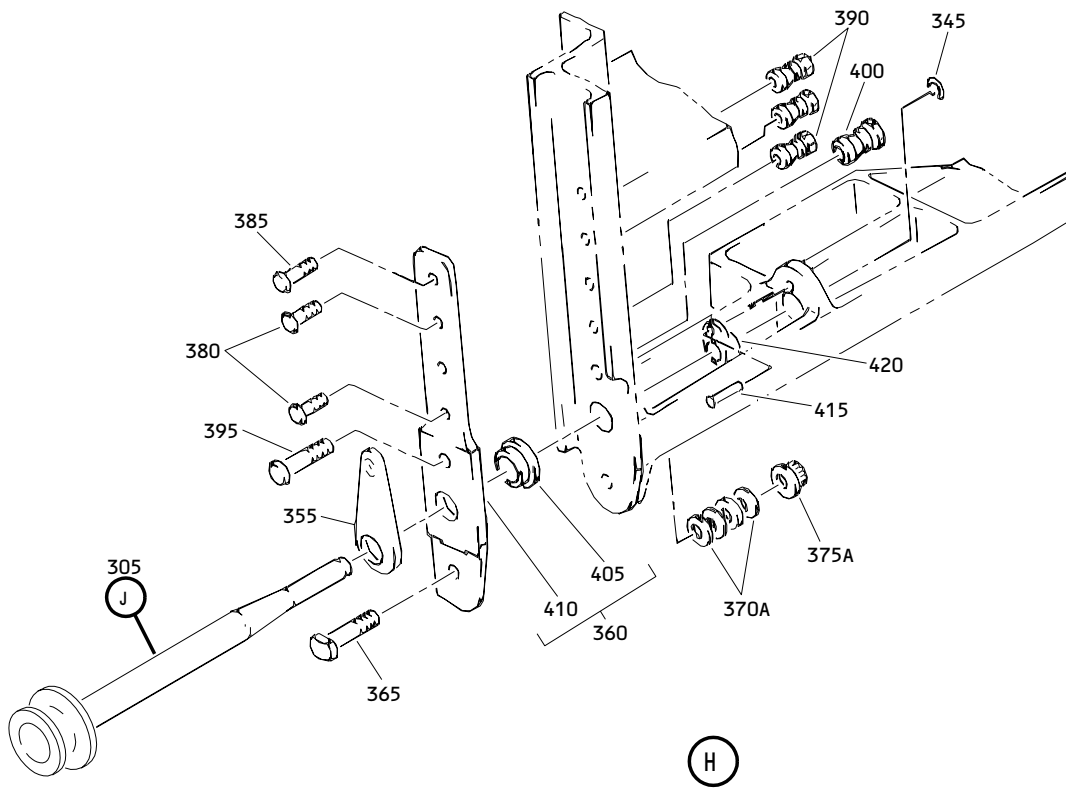
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Mid Entry Door Assembly  
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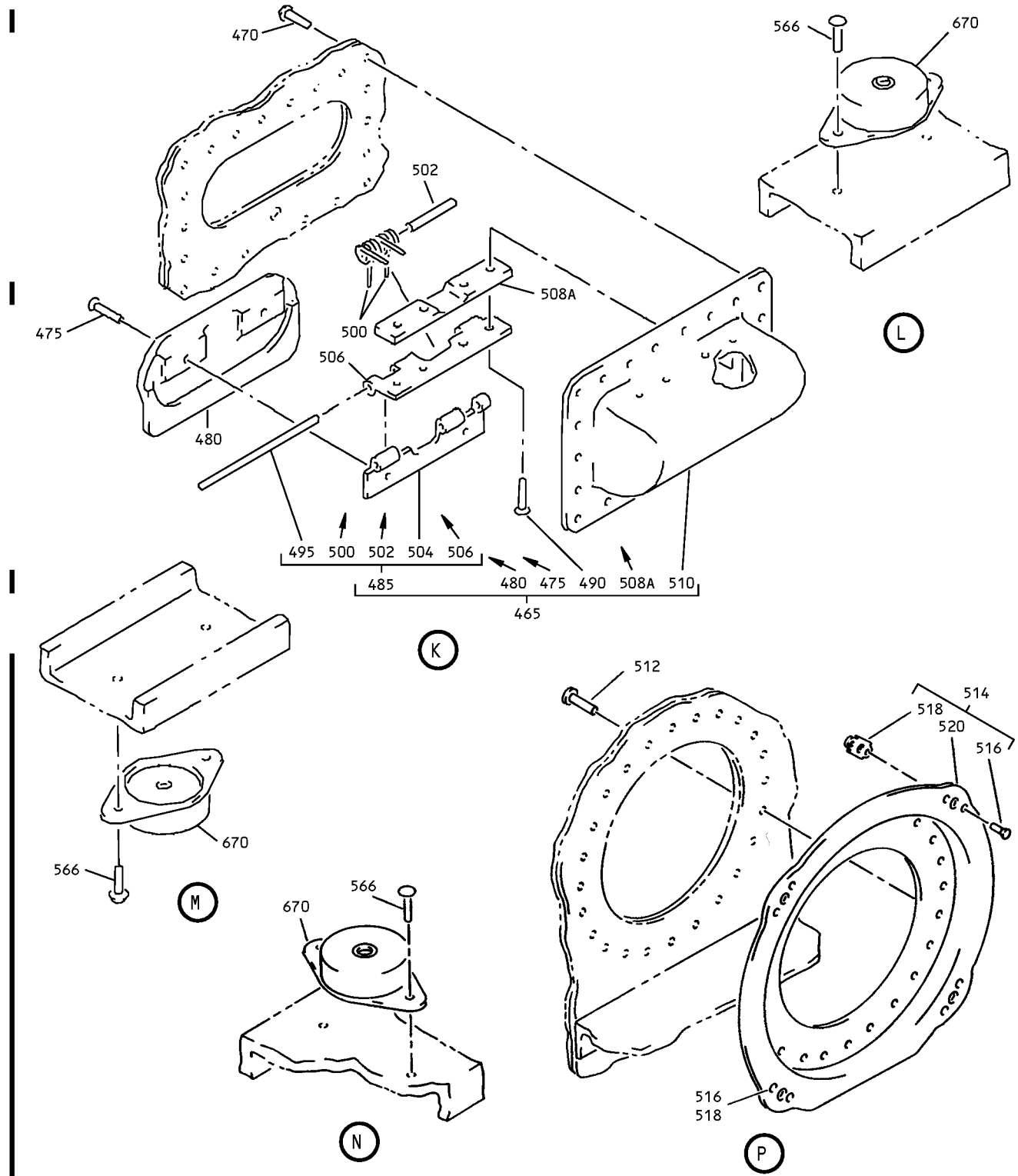
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Mid Entry Door Assembly  
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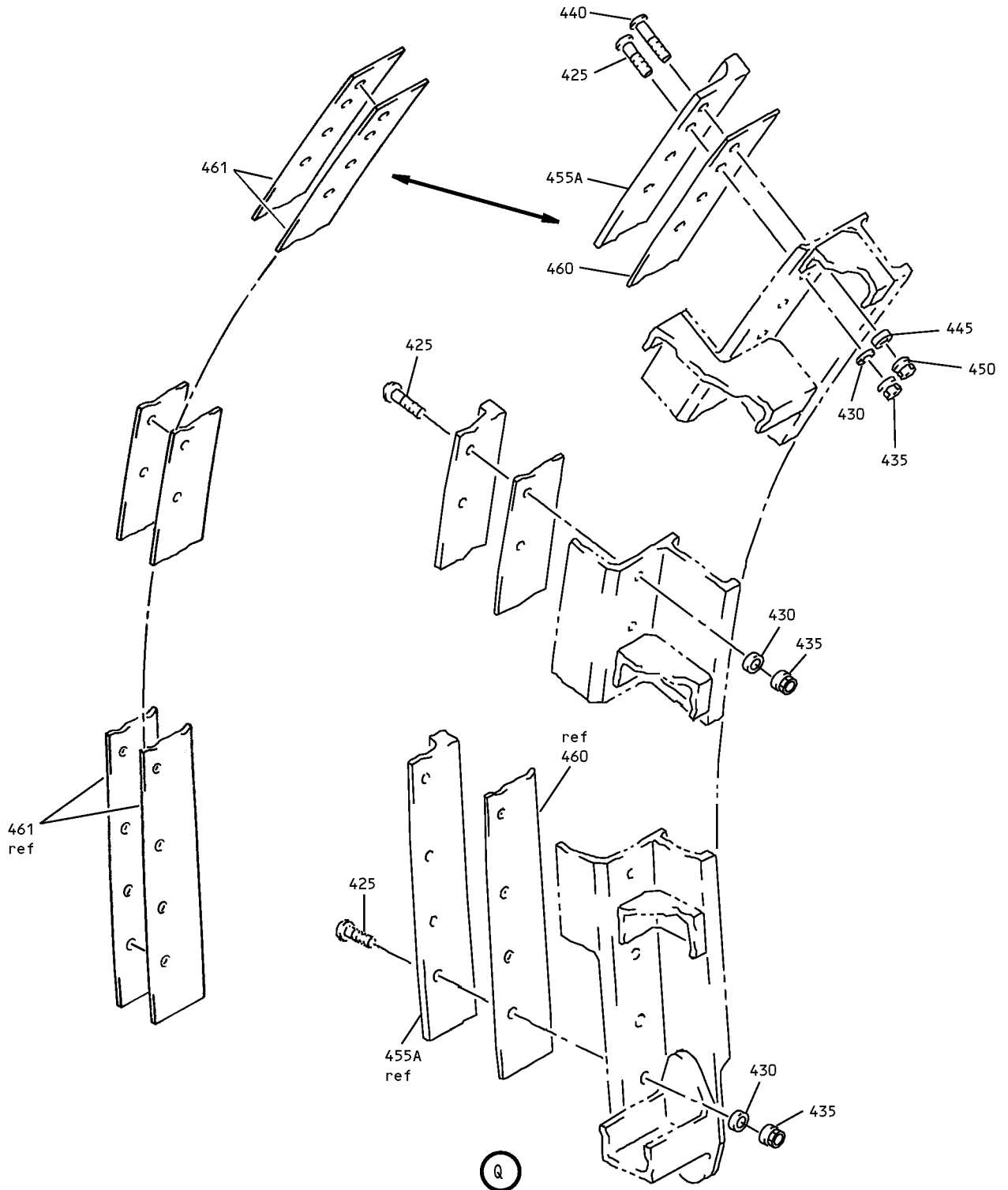
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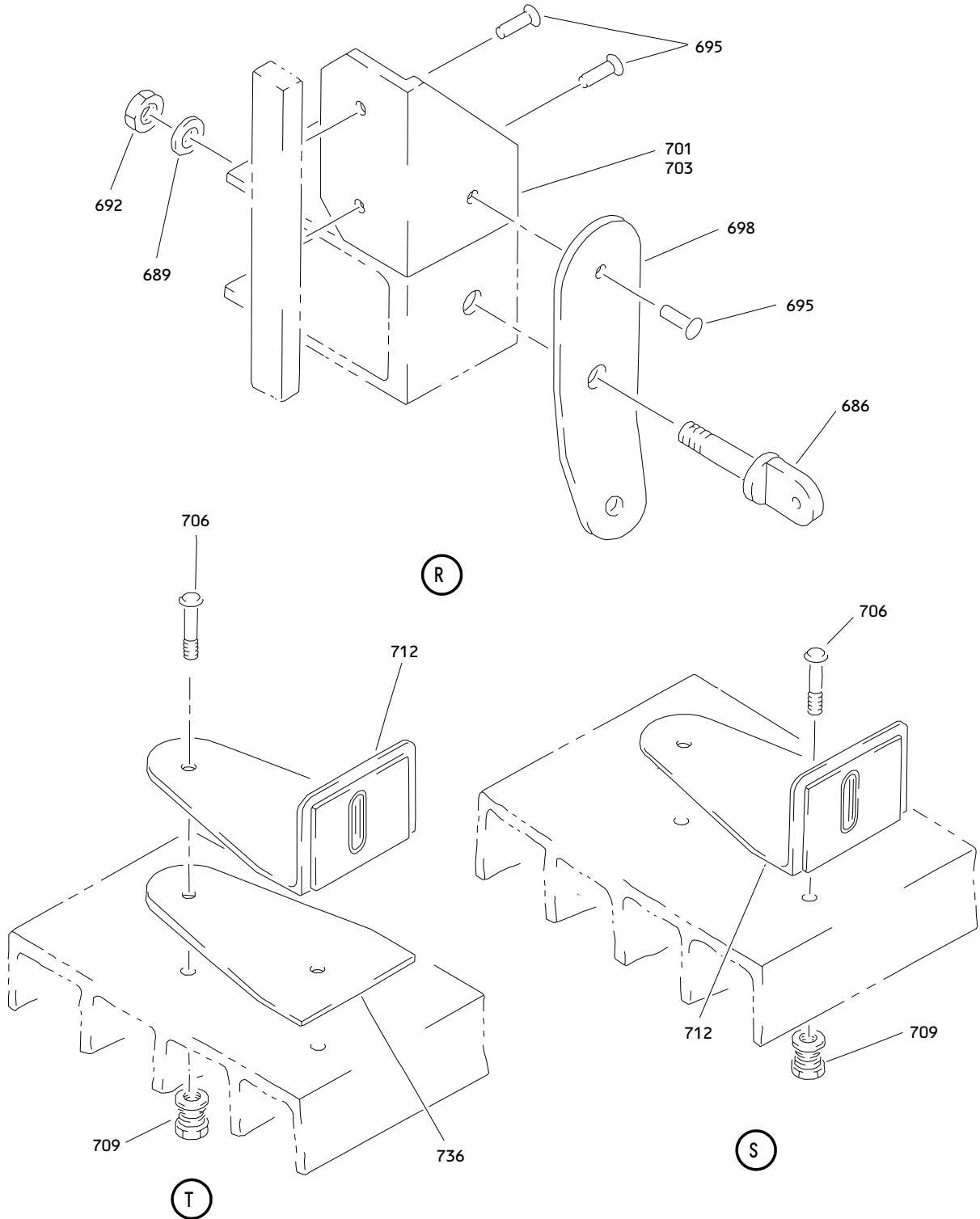


Mid Entry Door Assembly  
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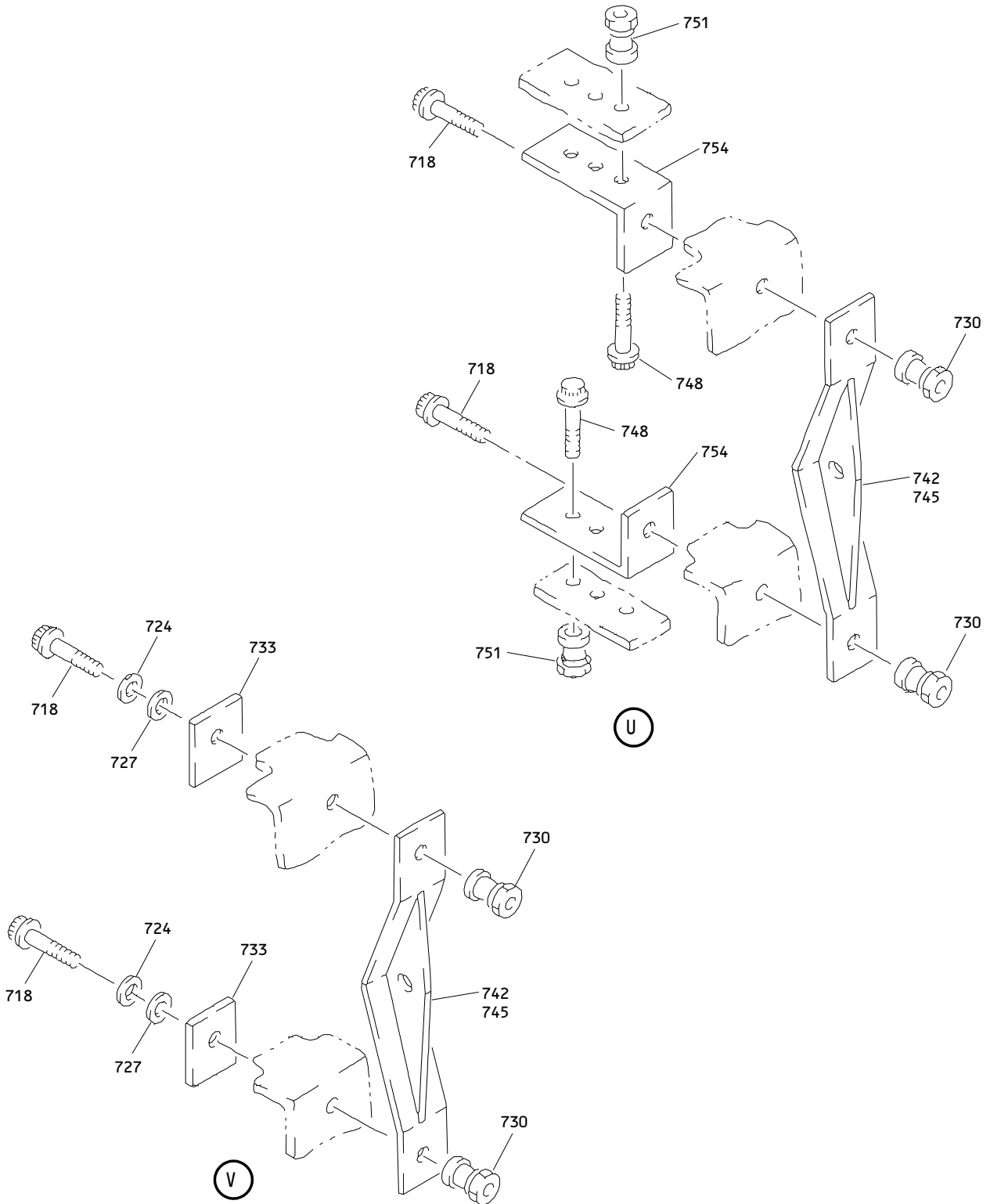




Mid Entry Door Assembly  
Figure 1 (Sheet 7)

**52-11-04**

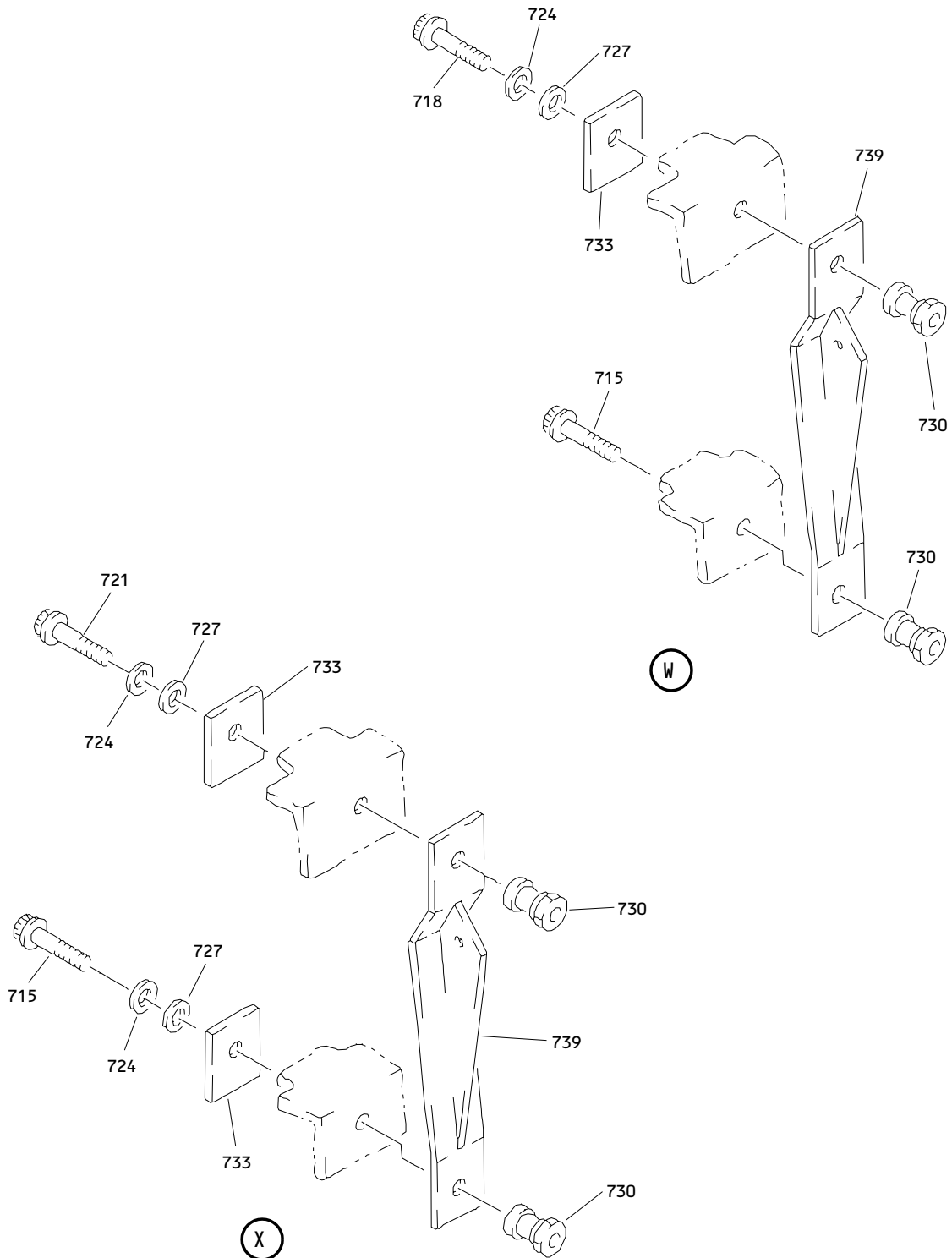
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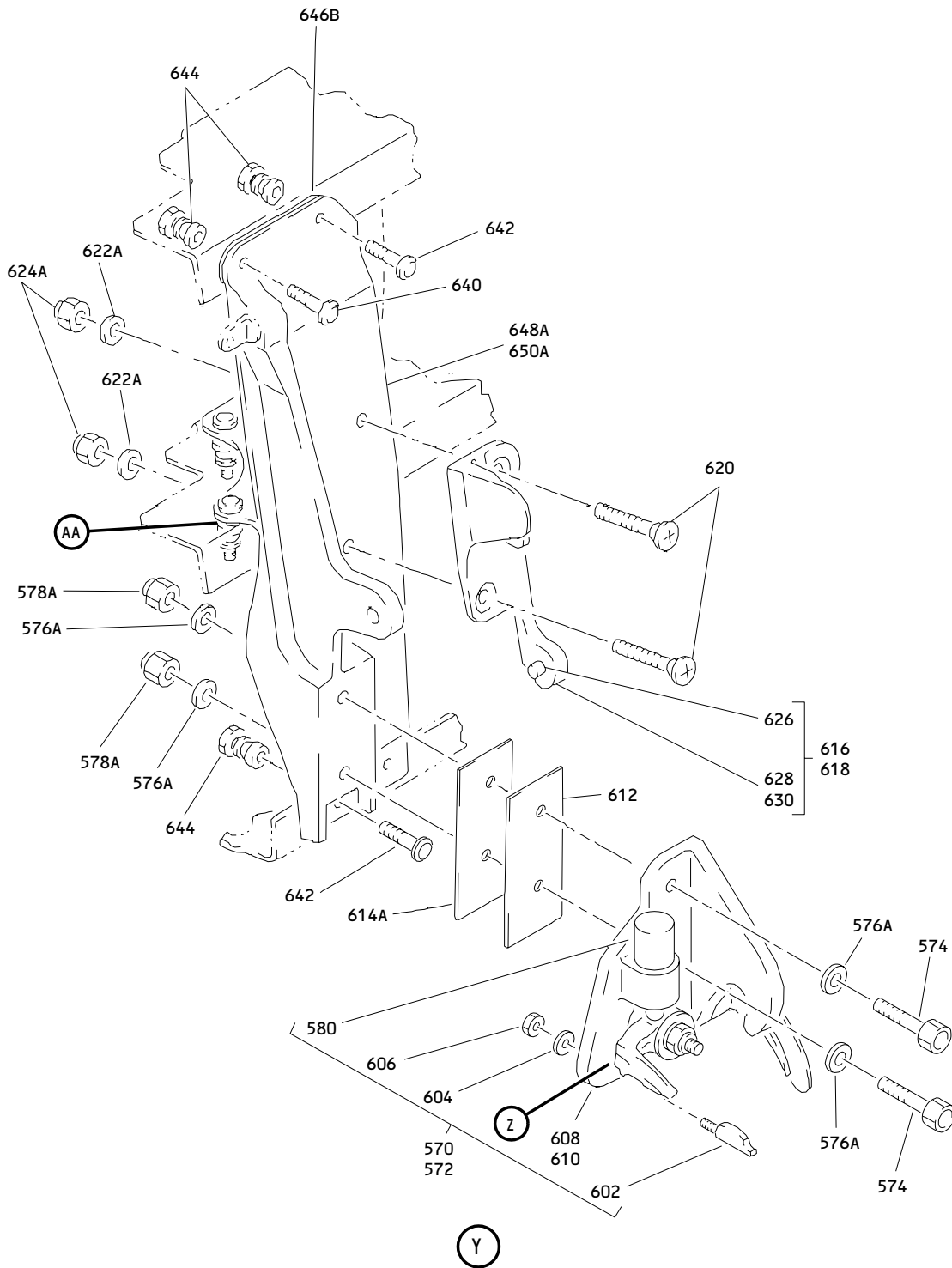
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Mid Entry Door Assembly  
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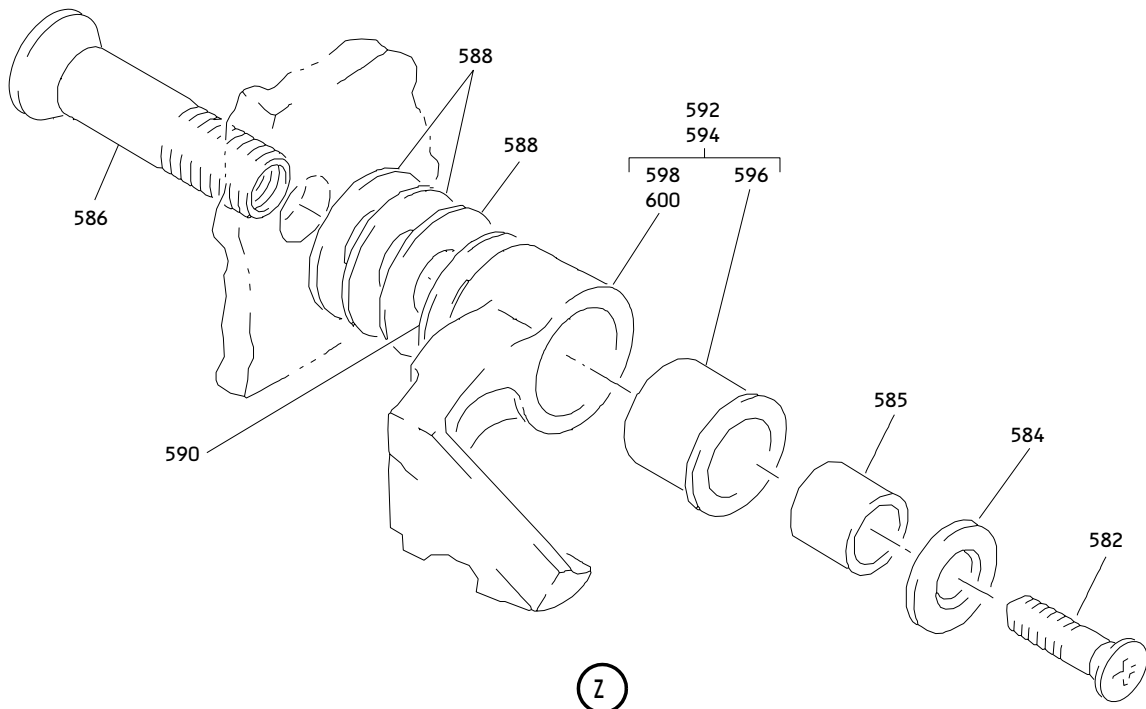
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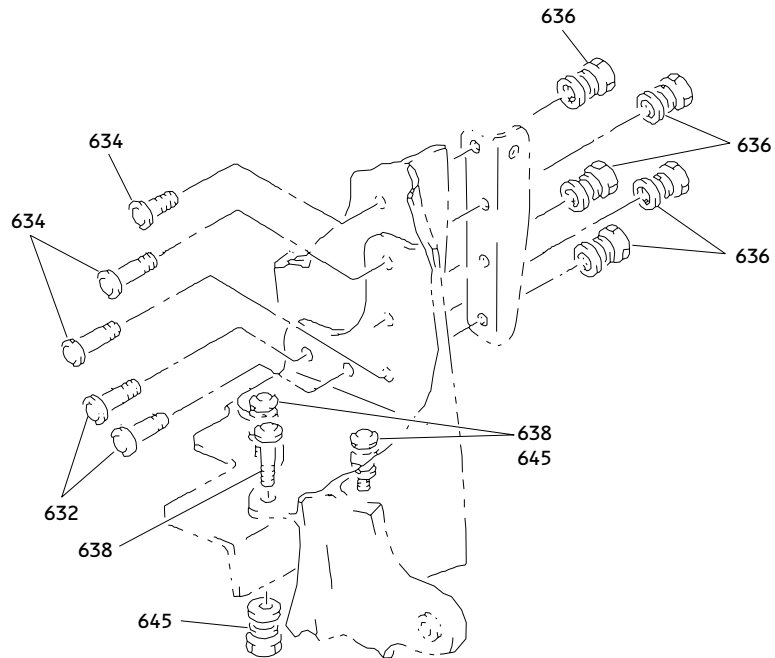
Mid Entry Door Assembly  
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(Z)

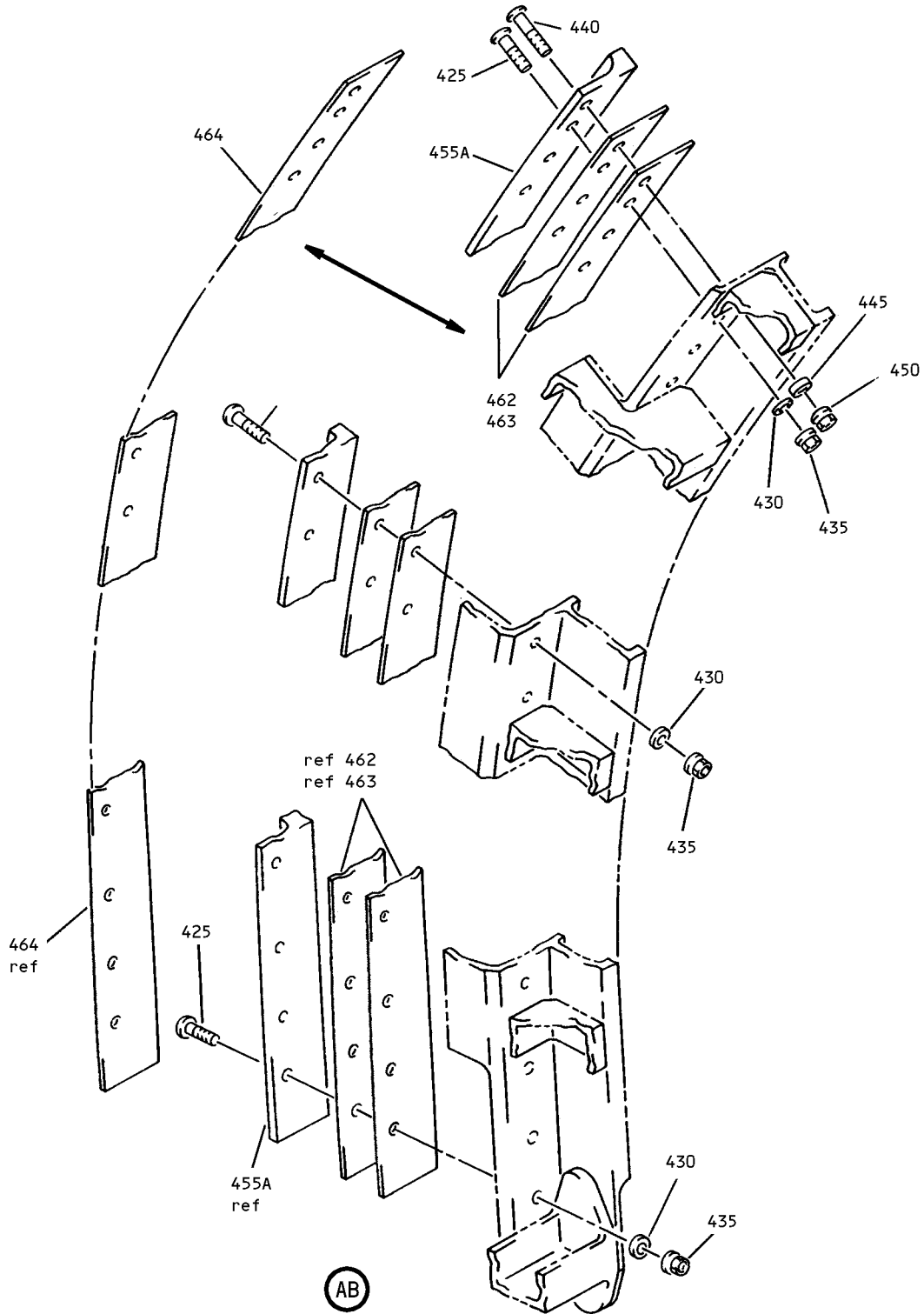


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**52-11-04**

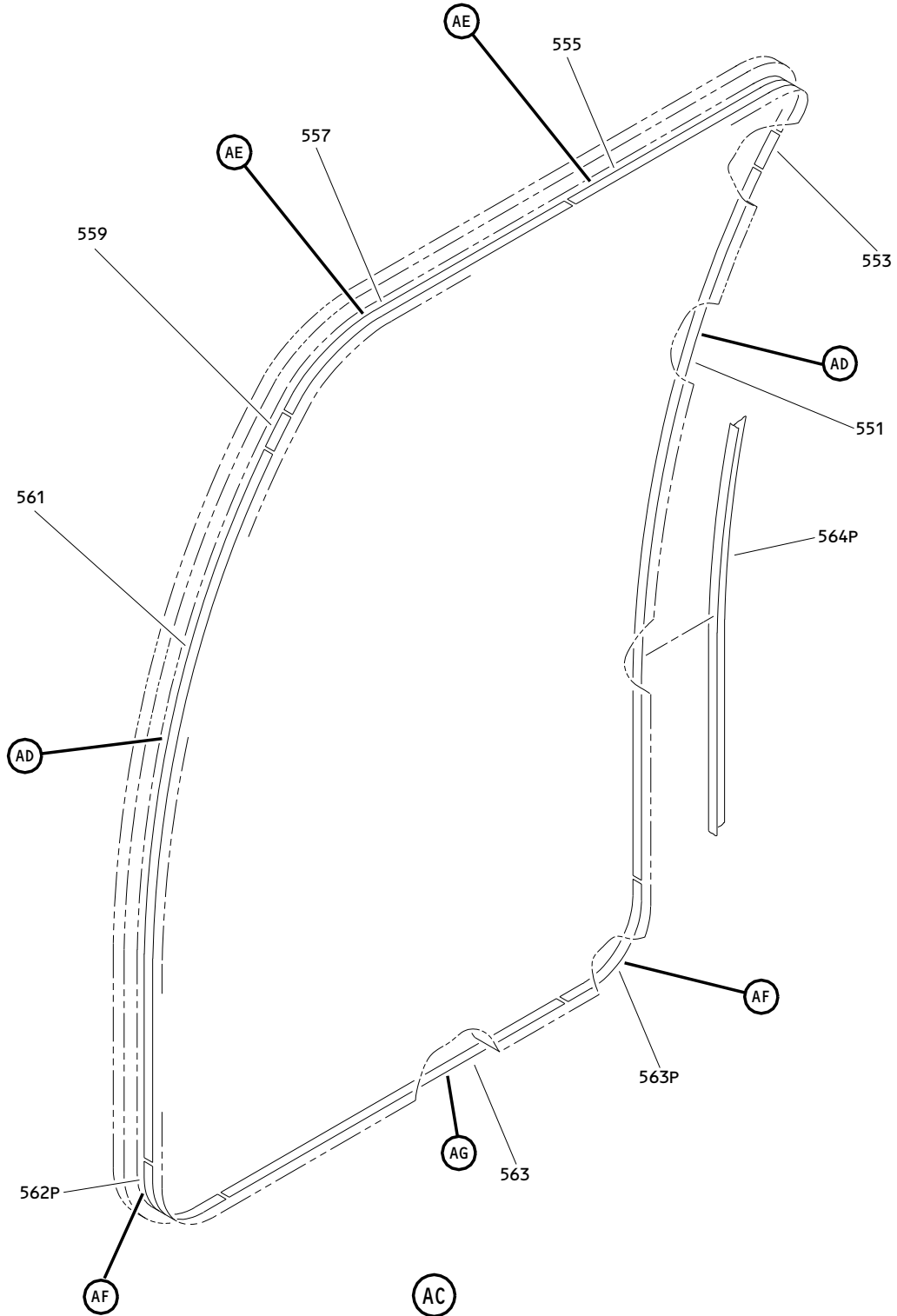
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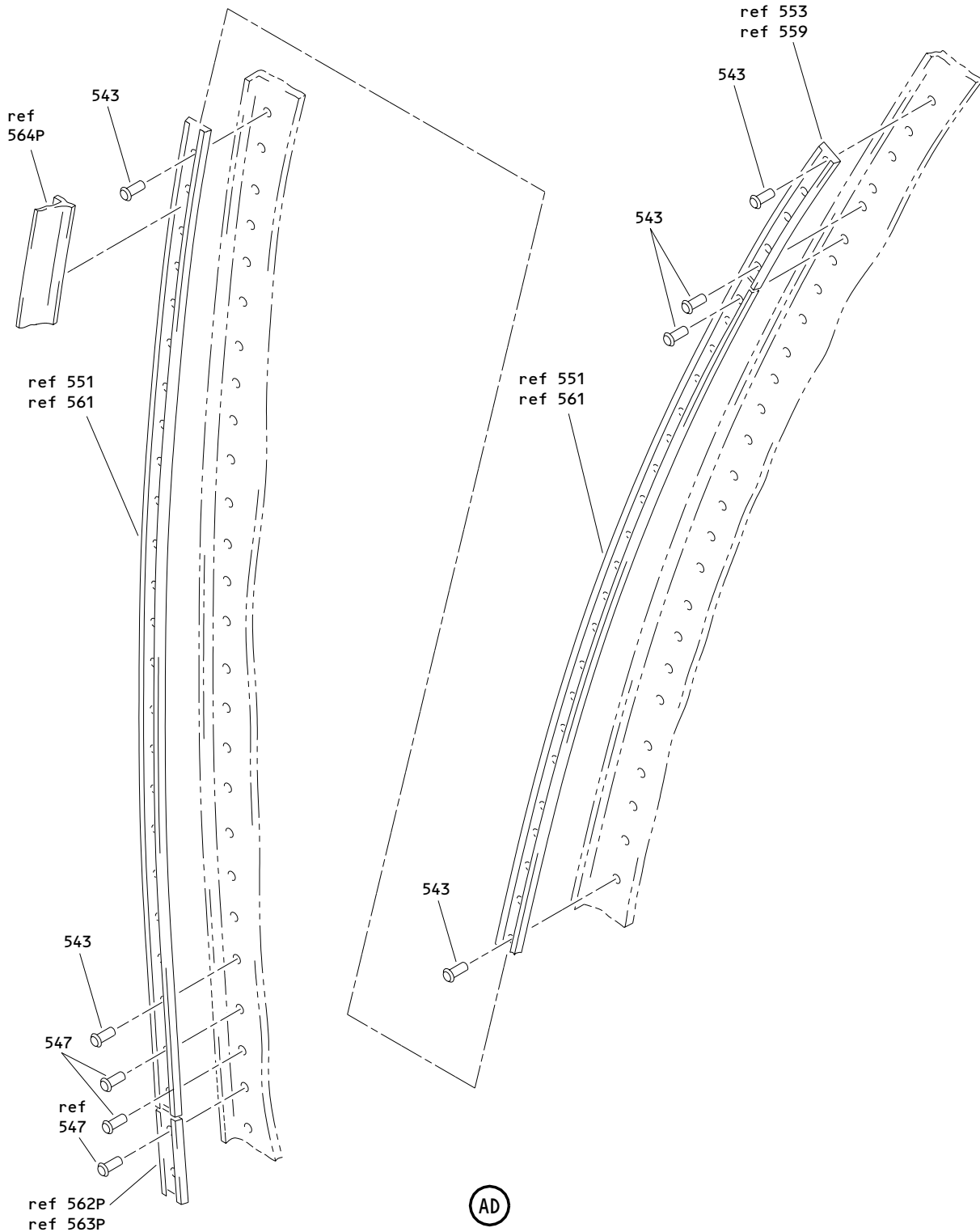
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Figure 1 (Sheet 13)

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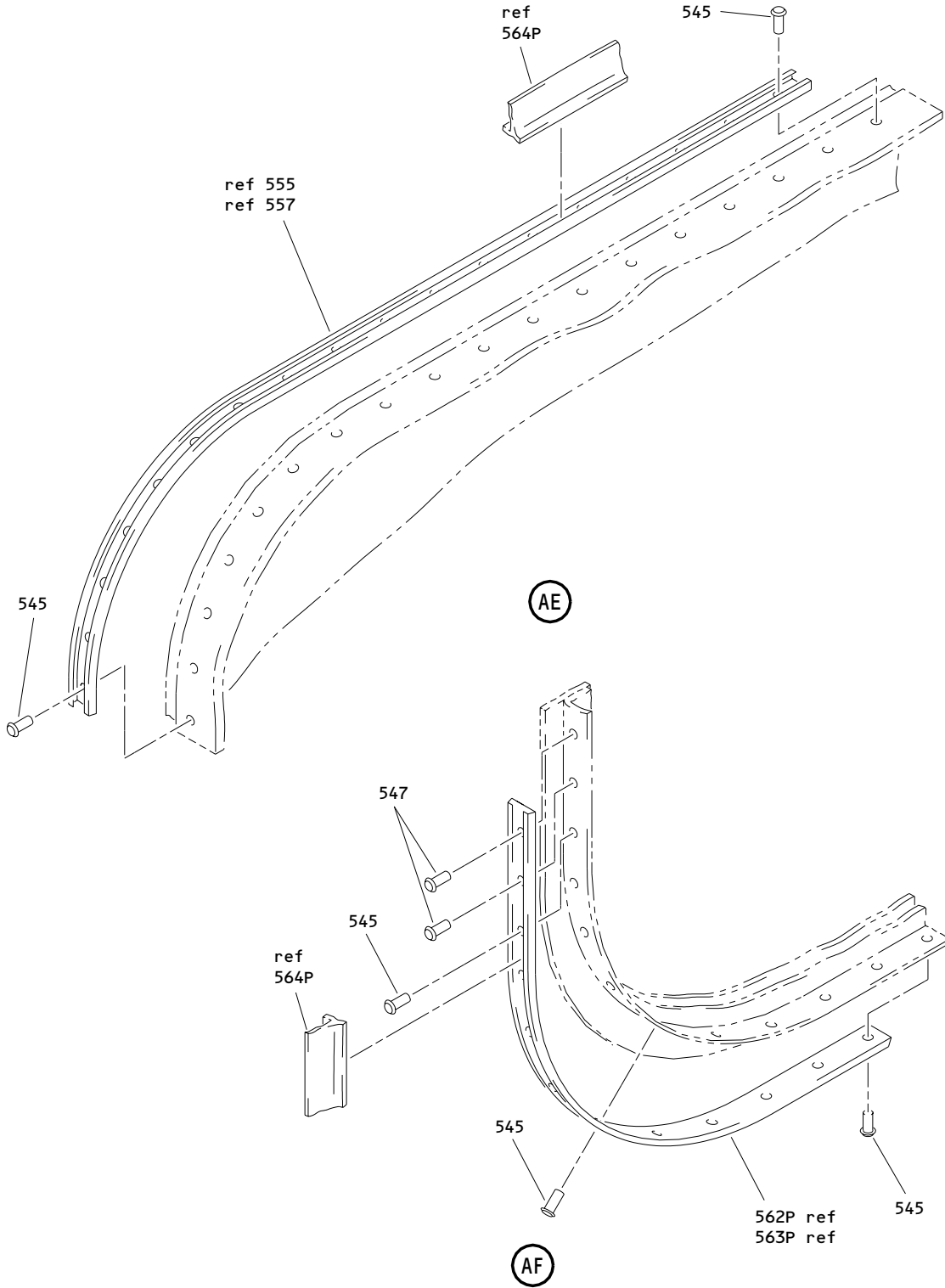


Mid Entry Door Assembly  
Figure 1 (Sheet 14)

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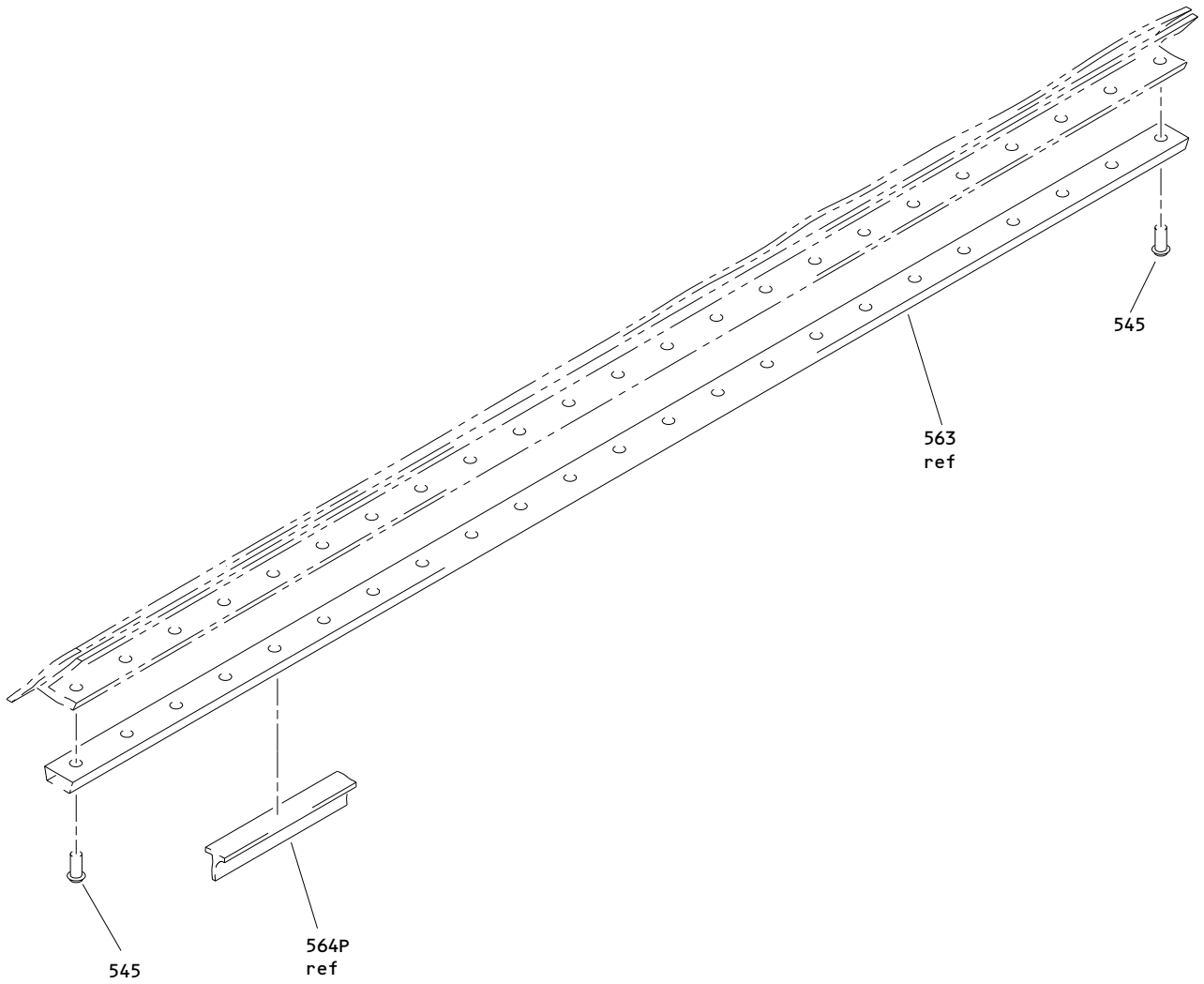




Mid Entry Door Assembly  
Figure 1 (Sheet 15)

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Mid Entry Door Assembly  
Figure 1 (Sheet 16)

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01- -1	143T6121-1		DOOR ASSY-MID ENTRY DOOR (LH)	A	RF
R -1A	143T6121-31		DOOR ASSY-MID ENTRY DOOR (LH)	C	RF
R -1B	143T6121-45		DOOR ASSY-MID ENTRY DOOR (LH)	E	RF
-5	143T6121-2		DOOR ASSY-MID ENTRY DOOR (RH)	B	RF
R -5A	143T6121-32		DOOR ASSY-MID ENTRY DOOR (RH)	D	RF
R -5B	143T6121-46		DOOR ASSY-MID ENTRY DOOR (RH)	F	RF
-10	143T6121-3		.STRUCTURE ASSY	A,B	1
R -10A	143T6121-33		.STRUCTURE ASSY	C,D	1
R -10B	143T6121-43		.STRUCTURE ASSY	E,F	1
-12	143T6121-4		DELETED		
15	SF15-120-7		..SEAL-PRESSURE (V50744) (SPEC S140T263-7) (OPT ITEM 15B)	A,B	1
-15A	S140T263-19		DELETED		
R -15B	SF15-120-19		..SEAL-PRESSURE (V50744) (SPEC S140T263-19) (OPT ITEM 15)	A,B	1
R -15C	SF15-120-19		..SEAL-PRESSURE (V50744) (SPEC S140T263-19)	C-F	1
20	141T6143-6		..FITTING ASSY-CLEVIS ATTACHING PARTS		1
25	BACB30MR4K13		..BOLT		4
30	AN960JD416		DELETED		
R 30A	NAS1149E0463P		..WASHER		4

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
35	141T6143-7		..WASHER		2
40	NAS1804-4		DELETED		
R 40A	NAS1805-4L		..NUT		4
			-----*		
45	BACB28X5C023		...BUSHING		1
50	BACB28X7M023		...BUSHING		1
55	141T6143-5		...FITTING		1
60	141T6142-1		..PLATE-SERRATED	A-D	1
R -60A	141T6142-6		..PLATE-SERRATED	E,F	1
65	BACS40R27C32F		DELETED		
R 65A	BACS40R027C032F		..SHIM		1
70	BACN10JC4		DELETED		
R 70A	BRH10C4D		..NUT-		1
			(V52828)		
			(SPEC BACN10JC4CD)		
			(OPT T6C428JCD		
			(V11815))		
			(OPT NS202486-048		
			(V80539))		
			(OPT 102LH9075-4W		
			(V72962))		
			(OPT H51650-4BAC		
			(V15653))		

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
75	141T6599-1		..PIN-CENTERING		1
80	MS27641-8		..BEARING	A-D	1
R -80A	MS27641-8		..BEARING-	E,F	1
			(OPT ITEM 80B)		
R -80B	KP8AFS428		..BEARING-	E,F	1
			(V21335)		
			(SPEC BACB10BX08)		
			(OPT KP8E		
			(V21760))		
			(OPT KP8AP		
			(V21760))		
			(OPT KP8AE		
			(V21760))		
			(OPT KP8P		
			(V21760))		
			(OPT KP08ANJC		
			(V06144))		
			(OPT KP08ASD610		
			(V83086))		
			(OPT KP08ALY196		
			(V40920))		
			(OPT KP08A		
			(V38443))		
			(OPT LLKP08A		
			(V38443))		
			(OPT KP08A2TS		
			(V43991))		
			(OPT ITEM 80A)		
85	MS27641-4		..BEARING	A-D	1
R -85A	MS27641-4		..BEARING-	E,F	1
			(OPT ITEM 85B)		

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 01- -85B	KP04ANJC8		..BEARING- (V06144) (SPEC BACB10BX04) (OPT KP04ALY196 (V40920)) (OPT KP04AFS428 (V21335)) (OPT KP04A2TS (V43991)) (OPT LLKP04A (V38443)) (OPT KP04A (V38443)) (OPT KP4AE (V21760)) (OPT KP4AP (V21760)) (OPT KP04ASD610 (V83086)) (OPT ITEM 85A)	E,F	1
90	141T6616-4		..SPACER		1
95	141T6616-5		..SPACER		1
100	AN960-416		DELETED		
R 100A	NAS1149F0463P		..WASHER		1
105	141T6631-1		..SHIM		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE	EFF CODE	QTY PER ASSY
			1234567		
01-110	HL1012AZ6-7		..BOLT- (V97928) (SPEC BACB30NX6K7) (OPT HL12VAZ6-7 (V73197)) (OPT HL12VAZ6-7 (V92215)) (OPT HL12VAZ6-7 (V97928)) (OPT L802-6K7 (V06725)) (OPT HL12VAZ6-7 (V56878)) (OPT HL1012AZ6-7 (V0PTK6)) (OPT HL1012AZ6-7 (V06725)) (OPT HL1012AZ6-7 (V06950)) (OPT HL1012AZ6-7 (V17446)) (OPT HL1012AZ6-7 (V56878)) (OPT HL1012AZ6-7 (V60516)) (OPT HL1012AZ6-7 (V73197))		2
115	HL12VAZ6-10		DELETED		

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE	EFF CODE	QTY PER ASSY
01-115A	HL1012AZ6-13		1234567 ..BOLT- (V97928) (SPEC BACB30NX6K13) (OPT HL12VAZ6-13 (V73197)) (OPT HL12VAZ6-13 (V92215)) (OPT HL12VAZ6-13 (V97928)) (OPT L802-6K13 (V06725)) (OPT HL1012AZ6-13 (V0PTK6)) (OPT HL1012AZ6-13 (V06725)) (OPT HL1012AZ6-13 (V06950)) (OPT HL1012AZ6-13 (V17446)) (OPT HL1012AZ6-13 (V56878)) (OPT HL1012AZ6-13 (V60516)) (OPT HL1012AZ6-13 (V73197)) (OPT HL12VAZ6-13 (V56878))		1
120	HL12VAZ6-9		DELETED		

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-122	HL1012AZ6-11		..BOLT- (V97928) (SPEC BACB30NX6K11) (OPT HL12VAZ6-11 (V73197)) (OPT HL12VAZ6-11 (V92215)) (OPT HL12VAZ6-11 (V97928)) (OPT L802-6K11 (V06725)) (OPT HL12VAZ6-11 (V56878)) (OPT HL1012AZ6-11 (V0PTK6)) (OPT HL1012AZ6-11 (V06725)) (OPT HL1012AZ6-11 (V06950)) (OPT HL1012AZ6-11 (V17446)) (OPT HL1012AZ6-11 (V56878)) (OPT HL1012AZ6-11 (V60516)) (OPT HL1012AZ6-11 (V73197))		3
125 130	HL12VAZ6-8 K29646-3		DELETED ..WASHER- (V15653) (SPEC BACW10CA3CV) (OPT 70188-3 (V56878)) (OPT 922007-3 (V60119)) (OPT 942007-3 (V60119))		6

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-135	K29913-3		..WASHER- (V15653) (SPEC BACW10CA3CC) (OPT 70191-3 (V56878)) (OPT 922008-3 (V60119)) (OPT 942008-3 (V60119))		6
140	HL1187DU6		..COLLAR- (V5M902) (SPEC BACC30X6S) (OPT HL87DU6 (V73197)) (OPT HL87DU6 (V92215)) (OPT HL1187DU6 (V56878)) (OPT HL1187DU6 (V92215)) (OPT HL87DU6 (V56878)) (OPT HL1187DU6 (V73197))		6
145	HL10VAZ6-3		..BOLT- (V60516) (SPEC BACB30MY6K3) (OPT B30MY6K3 (V97928))		4

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-150	L8006K6		..BOLT- (V06725) (SPEC BACB30MY6K6) (OPT HL10VAZ6-6 (VOPTK6))		3
155	HL10VAZ6-4		..BOLT- (V60516) (SPEC BACB30MY6K4) (OPT B30MY6K4 (V97928))		1
160	HL82-6APBW		..COLLAR- (V5M902) (SPEC BACC30AG6) (OPT HL82-6APBW (V92215)) (OPT HL82-6APBW (V56878)) (OPT HL82-6APBW (V73197))		8
165	143T6128-1		..FITTING-UPR SPRT (OPT ITEM 165A)	A-D	1
-165A	143T6128-3		..FITTING-UPR SPRT (OPT ITEM 165)	A-D	1
R -165B	143T6128-7		..FITTING-UPR SPRT (OPT ITEM 165C)	E,F	1
R -165C	143T6128-5		..FITTING-UPR SPRT (OPT ITEM 165B)	E,F	1
170	BACS40R07E20F		DELETED		
R 170A	BACS40R007E020F		..SHIM		1
175	141T6628-1		..BRACKET ASSY-FAIL SAFE CABLE		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01- 180	HL1012AZ6-4		ATTACHING PARTS ..BOLT- (V97928) (SPEC BACB30NX6K4) (OPT HL12VAZ6-4 (V73197)) (OPT HL12VAZ6-4 (V92215)) (OPT HL12VAZ6-4 (V97928)) (OPT L802-6K4 (V06725)) (OPT HL12VAZ6-4 (V56878)) (OPT HL1012AZ6-4 (V0PTK6)) (OPT HL1012AZ6-4 (V06725)) (OPT HL1012AZ6-4 (V06950)) (OPT HL1012AZ6-4 (V17446)) (OPT HL1012AZ6-4 (V56878)) (OPT HL1012AZ6-4 (V60516)) (OPT HL1012AZ6-4 (V73197))		4
185	HL1187-6		..COLLAR- (V5M902) (SPEC BACC30X6) (OPT HL87-6 (V73197)) (OPT HL87-6 (V92215)) (OPT HL1187-6 (V56878)) (OPT HL1187-6 (V92215)) (OPT HL87-6 (V56878)) (OPT HL1187-6 (V73197)) -----*		4
190	BACB28Y4M016		...BUSHING		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
195	141T6628-3		...BRACKET		1
200	141T6334-1		..ROLLER ASSY ATTACHING PARTS		1
205	141T6640-2		..BOLT- (LIMITED) (OPT ITEM 205A)	A,B	1
-205A	141T6640-502		..BOLT- (LIMITED) (OPT ITEM 205)	A,B	1
R -205B	141T6640-502		..BOLT	C-F	1
-207	141T6640-2		DELETED		
-207A	141T6640-502		DELETED		
210	AN960C416		DELETED		
R 210A	NAS1149C0463R		..WASHER		3
215	AN960C416L		DELETED		
220	BACN10JC4		DELETED		
R 220A	BACN11AG4		..NUT -----*-----		1
225	MS27641-4G		...BEARING		1
230	RRN75S		...RING-RTNR (V80756)		1
235	141T6334-2		...ROLLER		1
R 240	141T6141-7		..LINK-LWR ROLLER		1
245	143T6149-1		..SUPPORT ASSY-LWR TRACK ROLLER ATTACHING PARTS		1
250	141T6255-3		..BOLT		1
255	AN960JD416L		DELETED		
R 255A	NAS1149D0416J		..WASHER		AR
260	NAS1804-4		DELETED		
R 260A	NAS1805-4L		..NUT		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-265	HL10VAZ6-4		..BOLT- (V60516) (SPEC BACB30MY6K4) (OPT B30MY6K4 (V97928))		3
270	HL10VAZ6-5		..BOLT- (V60516) (SPEC BACB30MY6K5) (OPT B30MY6K5 (V97928))		1
275	HL79-6		..COLLAR- (V5M902) (SPEC BACC30M6) (OPT HL79-6 (V73197)) (OPT HL79-6 (V92215)) (OPT 66014-6 (V56878)) (OPT HL79-6 (V56878))		4
280	HL10VAZ8-8		..BOLT- (V60516) (SPEC BACB30MY8K8) (OPT B30MY8K8 (V97928))		1
285	HL79-8		..COLLAR- (V5M902) (SPEC BACC30M8) (OPT HL79-8 (V73197)) (OPT HL79-8 (V92215)) (OPT 66014-8 (V56878)) (OPT HL79-8 (V56878)) -----*		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
R 290	BACB28X4C095		DELETED		
R 290A	BACB28X4C091		...BUSHING		1
295	NAS43HT6-3		...SPACER		1
300	143T6149-3		...FITTING		1
305	141T6176-4		..GUIDE ASSY		1
310	BACR15BA3AD		...RIVET-		1
			(SIZE DETERMINE ON INST)		
315	141T6642-1		...BOLT		1
320	141T6334-1		...ROLLER ASSY		1
325	MS27641-4G		....BEARING		1
330	RRN75S		....RING-RTNR		1
			(V80756)		
335	141T6334-2		....ROLLER		1
340	141T6123-2		...PIN-SLIDING		1
345	MS16632-4023		..RING-		1
			(OPT ITEM 345A)		
-345A	MS16633-4025		..RING-		1
			(OPT ITEM 345)		
R 355	141T6141-6		..LINK-LWR ROLLER		1
360	143T6149-2		..SUPPORT ASSY-LWR TRACK		1
			ROLLER		
			ATTACHING PARTS		
365	141T6255-3		..BOLT		1
370	AN960JD416L		DELETED		
R 370A	NAS1149D0416J		..WASHER		AR
375	NAS1804-4		DELETED		
R 375A	NAS1805-4L		..NUT		1
380	HL10VAZ6-4		..BOLT-		3
			(V60516)		
			(SPEC BACB30MY6K4)		
			(OPT B30MY6K4		
			(V97928))		
385	HL10VAZ6-5		..BOLT-		1
			(V60516)		
			(SPEC BACB30MY6K5)		
			(OPT B30MY6K5		
			(V97928))		

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-390	HL79-6		..COLLAR- (V5M902) (SPEC BACC30M6) (OPT HL79-6 (V73197)) (OPT HL79-6 (V92215)) (OPT 66014-6 (V56878)) (OPT HL79-6 (V56878))		4
395	HL10VAZ8-8		..BOLT- (V60516) (SPEC BACB30MY8K8) (OPT B30MY8K8 (V97928))		1
400	HL79-8		..COLLAR- (V5M902) (SPEC BACC30M8) (OPT HL79-8 (V73197)) (OPT HL79-8 (V92215)) (OPT 66014-8 (V56878)) (OPT HL79-8 (V56878)) -----*		1
405	BACB28X7M017		...BUSHING		1
410	143T6149-4		...FITTING		1
415	BACR15BA4AD		..RIVET- (SIZE DETERMINE ON INST)		1
420	141T6641-1		..BUSHING		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01- 425 430 435	BACB30NT3K6 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))		86 86 86
440 445	BACB30NT3K8 AS46-3		..BOLT ..WASHER- (V10630) (SPEC BACW10AU3) (OPT K19701P3 (V15653)) (OPT 53488W1032 (V56878)) (OPT 6073-0 (V72962)) (OPT TLN1020L3W (V08524))		2 2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-450	H19700P3		..NUT- (V15653) (SPEC BACN10MT3) (OPT TLN1020-3N (V08524)) (OPT 52LH6073-02 (V72962)) (OPT 53488-1032 (V56878))		2
R 455	141T6147-4		DELETED		
R 455A	141T6147-7		..STOP-DOOR		2
460	141T6235-1		..SHIM- (ITEM 460 (QTY 1) OPT TO ITEM 461 (QTY 2))	A,B	2
-460A	141T6235-2		DELETED		
R 461	141T6235-2		..SHIM- (ITEM 460 (QTY 1) OPT TO ITEM 461 (QTY 2))	A,B	4
R 462	143T6121-34		..KIT ASSY-SUB (OPT ITEM 464)	C-F	2
R 463	141T6235-2		...SHIM	C-F	2
R 464	141T6235-1		..SHIM- (OPT ITEM 462)	C-F	2
465	141T6290-501		..HANDHOLD ASSY ATTACHING PARTS		1
470	BACR15FV6KE		..RIVET- (SIZE DETERMINE ON INST) -----*		22
475	BACR15CE6KE		...RIVET- (SIZE DETERMINE ON INST)		2
480	141T6299-501		...COVER		1
485	141T6290-3		...HINGE ASSY ATTACHING PARTS		1
490	BACR15CE5KE		...RIVET- (SIZE DETERMINE ON INST) -----*		4
495	MS20253P2-350		....PIN-HINGE		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
500	141T6290-2		....SPRING		2
502	NAS42DD4-63		....SPACER		1
504	141T6290-5		....HINGE		1
506	141T6290-7		....HINGE		1
508	141T6501-1		DELETED		
R 508A	141T6501-2		...FILLER		1
510	141T6291-1		...PAN		1
512	BACR15FV6KE		..RIVET-		24
			(SIZE DETERMINE ON INST)		
514	141T6127-3		..RING ASSY-SPRT		1
			(OPT ITEM 514A)		
R -514A	141T6127-5		..RING ASSY-SPRT		1
			(OPT ITEM 514)		
516	BACR15BA3AD		...RIVET-		8
			(SIZE DETERMINE ON INST)		
518	F5000-3BAC		...NUTPLATE-		4
			(V15653)		
			(SPEC BACN10JR3F)		
			(OPT NS103203-02		
			(V80539))		
			(OPT RMF9201-3		
			(V72962))		
			(OPT T8091S1032		
			(V11815))		
			(OPT VN152A1-02		
			(V92215))		
			(OPT BRF200A3		
			(V52828))		
520	141T6127-4		...RING-		1
			(USED ON ITEM 514)		
R -520A	141T6127-6		...RING-		1
			(USED ON ITEM 514A)		
522	416T2710-1		DELETED		
-523	416T2710-2		DELETED		
524	AN42BC5		DELETED		
526	AN960C10		DELETED		
528	H01-3BAC		DELETED		
530	BACR15FT6KE		DELETED		
532	416T2191-1		DELETED		
534	416T2197-1		DELETED		
534A	416T2197-501		DELETED		
536	416T2197-2		DELETED		
536A	416T2197-502		DELETED		
538	416T2204-9		DELETED		
540	HL10V6-6		DELETED		

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
R 542	HL10VAZ6-7		DELETED		
R 543	BACR15BB4AD		..RIVET- (SIZE DETERMINE ON INST)		96
R 544	HL10VAZ6-8		DELETED		
R 545	BACR15BB4ADC		..RIVET- (SIZE DETERMINE ON INST)		79
R 546	BACW10BA3CC		DELETED		
R 547	BACR15FT5KEC		..RIVET- (SIZE DETERMINE ON INST)		8
R 548	BACW10BA3CV		DELETED		
R 549	BACR15FT6KEC		DELETED		
R 550	HL79-6		DELETED		
R 551	143T6121-22		..RETAINER-SEAL		1
R 552	416T2192-1		DELETED		
R 553	143T6121-20		..RETAINER-SEAL		1
R 554	BACF3T04H26S14		DELETED		
R 555	143T6121-18		..RETAINER-SEAL		1
R 556	416T2195-2		DELETED		
R 557	143T6121-17		..RETAINER-SEAL		1
R 558	416T2711-1		DELETED		
R 559	143T6121-19		..RETAINER-SEAL		1
R 560	HL10VAZ5-2		DELETED		
R 561	143T6121-21		..RETAINER-SEAL		1
R 562	HL70-5		DELETED		
R 562P	143T6121-23		..RETAINER-SEAL		1
R 563	143T6121-25		..RETAINER-SEAL		1
R 563P	143T6121-24		..RETAINER-SEAL		1
R 564	416T2309-1		DELETED		
R -564P	SF15-120-19		..SEAL-PRESSURE (V50744) (SPEC S140T263-19)		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
566	BACR15BB4AD		..RIVET- (SIZE DETERMINE ON INST)		20
568	DE786		DELETED		
570	141T6591-9		..SUPPORT ASSY-CARRIER		1
572	141T6591-10		..SUPPORT ASSY-CARRIER ATTACHING PARTS		1
574	BACB30NM4K10		..BOLT		4
576	AN960JD416L		DELETED		
R 576A	NAS1149D0463P		..WASHER		8
578	NAS1804-4		DELETED		
R 578A	NAS1805-4L		..NUT -----*-----		4
580	NNS62N003		...PLUNGER-SPR (V01226)		1
582	BACB30LR3PU5		...SCREW- (OPT ITEM 582A)		1
-582A	BACB30LH3-5		...BOLT- (OPT ITEM 582)		1
584	141T6625-1		...WASHER		1
585	BACB28AK05-061		...BUSHING		1
586	141T6626-1		...BOLT		1
588	BACW10P163A		...WASHER		3
590	BACW10P115S		...WASHER		1
592	141T6586-11		...FITTING ASSY- (OPT ITEM 592A) (USED ON ITEM 570)		1
-592A	141T6586-17		...FITTING ASSY- (OPT ITEM 592) (USED ON ITEM 570)		1
594	141T6586-12		...FITTING ASSY- (OPT ITEM 594A) (USED ON ITEM 572)		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01- -594A	141T6586-18		...FITTING ASSY- (OPT ITEM 594) (USED ON ITEM 572)		1
596	BACB28AR07A050		....BUSHING		1
598	141T6586-13		....FITTING- (USED ON ITEM 592)		1
-598A	141T6586-19		....FITTING- (USED ON ITEM 592A)		1
600	141T6586-14		....FITTING- (USED ON ITEM 594)		1
-600A	141T6586-20		....FITTING- (USED ON ITEM 594A)		1
602	141T6592-4		...PIN-LIFT		1
604	AN960PD416L		...WASHER		1
606	BRH10A4		...NUT- (V52828) (SPEC BACN10JC4) (OPT T6S428J (V11815)) (OPT 96-048 (V80539)) (OPT VN303A048 (V92215)) (OPT RMLH9075-4W (V72962)) (OPT NS202101-048 (V80539)) (OPT H10-4BAC (V15653))		1
608	141T6587-9		...FITTING- (USED ON ITEM 570)		1
610	141T6587-10		...FITTING- (USED ON ITEM 572)		1
612	141T6545-7		..SHIM		2
614	BACS40R14D26F		DELETED		
R 614A	BACS40R014D026F		..SHIM		2
616	141T6588-7		..FITTING ASSY- (LIMITED) (OPT ITEM 616A)	A,B	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-616A	141T6588-13		..FITTING ASSY- (LIMITED) (OPT ITEM 616)	A,B	1
R -616B	141T6588-13		..FITTING ASSY- (OPT ITEM 616C)	C-F	1
R -616C	141T6588-19		..FITTING ASSY- (OPT ITEM 616B)	C-F	1
-617	141T6588-7		DELETED		
618	141T6588-8		..FITTING ASSY- (LIMITED) (OPT ITEM 618A)	A,B	1
-618A	141T6588-14		..FITTING ASSY- (LIMITED) (OPT ITEM 618)	A,B	1
R -618B	141T6588-14		..FITTING ASSY- (OPT ITEM 618C)	C-F	1
R -618C	141T6588-20		..FITTING ASSY- (OPT ITEM 618B)	C-F	1
-619	141T6588-8		DELETED		
620	BACB30NN4K8		ATTACHING PARTS ..BOLT		4
622	AN960JD416L		DELETED		
R 622A	NAS1149E0432P		..WASHER		4
624	NAS1804-4		DELETED		
R 624A	NAS1805-4L		..NUT -----*-----		4
626	141T6589-1		...PIN-GUIDE (USED ON ITEMS 616, 618)	A,B	1
-626A	141T6589-2		...PIN-GUIDE (USED ON ITEMS 616A, 616B, 616C, 618A, 618B, 618C)		1
628	141T6588-3		...FITTING- (USED ON ITEM 616)	A,B	1
-628A	141T6588-3		DELETED		
-628B	141T6588-15		...FITTING- (USED ON ITEMS 616A, 616B)		1
R -628C	141T6588-21		...FITTING- (USED ON ITEM 616C)	C-F	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-630	141T6588-4		...FITTING- (USED ON ITEM 618)	A,B	1
-630A	141T6588-4		DELETED		
-630B	141T6588-16		...FITTING- (USED ON ITEMS 618A, 618B)		1
R -630C	141T6588-22		...FITTING- (USED ON ITEM 618C)	C-F	1
632	HL10VAZ6-3		..BOLT- (V60516) (SPEC BACB30MY6K3) (OPT B30MY6K3 (V97928))		4
634	HL10VAZ6-4		..BOLT- (V60516) (SPEC BACB30MY6K4) (OPT B30MY6K4 (V97928))		6
636	HL79-6		..COLLAR- (V5M902) (SPEC BACC30M6) (OPT HL79-6 (V73197)) (OPT HL79-6 (V92215)) (OPT 66014-6 (V56878)) (OPT HL79-6 (V56878))		10

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-638	HL10VAZ6-4		..BOLT- (V60516) (SPEC BACB30MY6K4) (OPT B30MY6K4 (V97928))		6
640	L8006K6		..BOLT- (V06725) (SPEC BACB30MY6K6) (OPT HL10VAZ6-6 (VOPTK6))		2
642	HL10VAZ6-5		..BOLT- (V60516) (SPEC BACB30MY6K5) (OPT B30MY6K5 (V97928))		4
644	HL82-6APBW		..COLLAR- (V5M902) (SPEC BACC30AG6) (OPT HL82-6APBW (V92215)) (OPT HL82-6APBW (V56878)) (OPT HL82-6APBW (V73197))		6
645	HL79-6		..COLLAR- (V5M902) (SPEC BACC30M6) (OPT HL79-6 (V73197)) (OPT HL79-6 (V92215)) (OPT 66014-6 (V56878)) (OPT HL79-6 (V56878))		6

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
R 646	BACS40R08C25F		DELETED		
646A	BACS40R08E25F		DELETED		
R 646B	BACS40R008E025F		..SHIM		2
648	143T6182-1		DELETED		
648A	143T6182-3		..FITTING-SLIDE PACK CARRIER ADPTR		1
650	143T6182-2		DELETED		
650A	143T6182-4		..FITTING-SLIDE PACK CARRIER ADPTR		1
670	DE786		.SHOCKMOUNT- (V71985) (SPEC S411T100-101) (OPT DE820 (V71985))		10
R -670A	DE820		.SHOCKMOUNT- (V71985) (SPEC S411T100-107) (SPEC S411T100-101) (OPT DE786 (V71985))		10
675	MS27253F4		.PLATE		1
680	416T2710-1		.SUPPORT INSTL-ESCAPE SLIDE BUSTLE	A,C,E	1
-683	416T2710-2		.SUPPORT INSTL-ESCAPE SLIDE BUSTLE	B,D,F	1
686	AN42BC5		..EYEBOLT		2
689	AN960C10		..WASHER		2
692	BRH10C3M		..NUT- (V52828) (SPEC BACN10JC3CM) (OPT T6C1032JM (V11815)) (OPT 97E02 (V80539)) (OPT 109LH9075-3W (V72962)) (OPT VN303D02 (V92215)) (OPT NS202101SE02 (V80539)) (OPT H01-3BAC (V15653))		2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-695	BACR15FT6KE		..RIVET- (SIZE DETERMINE ON INST)		16
698	416T2191-1		..TANG-CABLE ATTACH		2
701	416T2197-501		..CLIP-CABLE TANG		1
703	416T2197-502		..CLIP-CABLE TANG		1
706	HL10VAZ6-8		..BOLT- (V60516) (SPEC BACB30MY6K8) (OPT B30MY6K8 (V97928))		2
709	HL82-6APBW		..COLLAR- (V5M902) (SPEC BACC30AG6) (OPT HL82-6APBW (V92215)) (OPT HL82-6APBW (V56878)) (OPT HL82-6APBW (V73197))		2
712	416T2204-9		..BRACKET ASSY		6
715	L8006K6		..BOLT- (V06725) (SPEC BACB30MY6K6) (OPT HL10VAZ6-6 (VOPTK6))		4
718	HL10VAZ6-7		..BOLT- (V60516) (SPEC BACB30MY6K7) (OPT B30MY6K7 (V97928))		10
721	HL10VAZ6-8		..BOLT- (V60516) (SPEC BACB30MY6K8) (OPT B30MY6K8 (V97928))		10

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-724	K29913-3		..WASHER- (V15653) (SPEC BACW10CA3CC) (OPT 70191-3 (V56878)) (OPT 922008-3 (V60119)) (OPT 942008-3 (V60119))		10
727	K29646-3		..WASHER- (V15653) (SPEC BACW10CA3CV) (OPT 70188-3 (V56878)) (OPT 922007-3 (V60119)) (OPT 942007-3 (V60119))		10
730	HL79-6		..COLLAR- (V5M902) (SPEC BACC30M6) (OPT HL79-6 (V73197)) (OPT HL79-6 (V92215)) (OPT 66014-6 (V56878)) (OPT HL79-6 (V56878))		16
733	416T2192-1		..FILLER		10
736	BACF3T04H26S14		..FILLER		1
739	416T2195-2		..BRACKET-UPR STRUT		4
742	416T2711-1		..BRACKET-LWR STRUT		2
745	416T2711-2		..BRACKET-LWR STRUT		2
748	HL10VAZ5-2		..BOLT- (V60516) (SPEC BACB30MY5K2) (OPT B30MY5K2 (V97928))		6

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01- 751	HL79-5		..COLLAR- (V5M902) (SPEC BACC30M5) (OPT HL70-5 (V73197)) (OPT HL70-5 (V92215)) (OPT 66014-5 (V56878)) (OPT HL70-5 (V56878))		6
754	416T2309-1		..CLIP-BRKT SPRT		4

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