

 **BOEING**
COMPONENT
MAINTENANCE MANUAL

TO: ALL HOLDERS OF AFT DOOR BUSTLE ASSEMBLY COMPONENT MAINTENANCE MANUAL
52-11-23

REVISION NO. 2 DATED JUL 01/91

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 top assemblies 416T2047-6, -7.

1

TR & SB RECORD

1

1002-1003,1005-1009,

1013,1015-1016,1018,

1020-1029

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AFT DOOR BUSTLE ASSEMBLY

PART NUMBERS 416T2047-3,-5,-6,-7

COMPONENT MAINTENANCE MANUAL
WITH
ILLUSTRATED PARTS LIST

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TITLE PAGE

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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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REVISION RECORD

01

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TEMPORARY REVISION AND SERVICE BULLETIN RECORD

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVE	DATE OF INCORPORATION INTO MANUAL
		PRR B10689 PRR B11700-2 PRR B11700-502	JAN 10/85 JUL 01/91 JUL 01/91

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TR & SB RECORD

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 COMPONENT
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PAGE	DATE	CODE	PAGE	DATE	CODE
52-11-23			REPAIR 1-1		
			601	JAN 10/85	01
			602	BLANK	
TITLE PAGE			REPAIR 2-1		
*1	JUL 01/91	01.1	601	JAN 10/85	01
2	BLANK		602	BLANK	
REVISION RECORD			ASSEMBLY		
1	JAN 10/85	01	701	JAN 10/85	01
2	BLANK		702	JAN 10/85	01
TR & SB RECORD			ILLUSTRATED PARTS LIST		
*1	JUL 01/91	01.1	1001	JAN 10/85	01
2	BLANK		*1002	JUL 01/91	01.1
LIST OF EFFECTIVE PAGES			*1003	JUL 01/91	01.1
*1	JUL 01/91	01	*1004	JUL 01/91	01.1
THRU LAST PAGE			*1005	JUL 01/91	01.1
CONTENTS			*1006	JUL 01/91	01.1
1	JAN 10/85	01	*1007	JUL 01/91	01.1
2	BLANK		*1008	JUL 01/91	01.1
INTRODUCTION			*1009	JUL 01/91	01.1
1	JAN 10/85	01	*1010	JUL 01/91	01.1
2	BLANK		*1011	JUL 01/91	01.1
DESCRIPTION & OPERATION			*1012	JUL 01/91	01.1
1	JUL 10/85	01.1	*1013	JUL 01/91	01.1
2	BLANK		*1014	JUL 01/91	01.1
DISASSEMBLY			*1015	JUL 01/91	01.1
301	JAN 10/85	01	*1016	JUL 01/91	01.1
302	JAN 10/85	01	*1017	JUL 01/91	01.1
CHECK			*1018	JUL 01/91	01.1
501	JAN 10/85	01	*1019	JUL 01/91	01.1
502	BLANK		*1020	JUL 01/91	01.1
REPAIR-GENERAL			*1021	JUL 01/91	01.1
601	JAN 10/85	01	*1022	JUL 01/91	01.1
602	BLANK		*1023	JUL 01/91	01.1
			*1024	JUL 01/91	01.1
			*1025	JUL 01/91	01.1
			*1026	JUL 01/91	01.1
			*1027	JUL 01/91	01.1
			*1028	JUL 01/91	01.1
			*1029	JUL 01/91	01.1
			*1030	BLANK	

* = REVISED, ADDED OR DELETED

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 EFFECTIVE PAGES
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Check	501
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Assembly.	701
Fits and Clearances (not applicable)	
Special Tools (not applicable)	
Illustrated Parts List.	1001
* [1] Special instructions not required. 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.

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INTRODUCTION

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AFT DOOR BUSTLE ASSEMBLYDESCRIPTION AND OPERATION1. Description

A. The bustle assembly consists of tedlar covered honeycomb shell assemblies, latch assemblies, spring bracket assemblies, hinge assemblies and associated components.

2. Operation

A. The bustle is attached to the aft entry door to protect and provide decorative cover to the escape slide assembly. During slide deployment, the lower shell opens and allows the escape slide to drop out of the door as the entry door is raised in an emergency mode.

3. Leading Particulars (approximate)

Height -- 45 inches
Length -- 22 inches
Width -- 14 inches
Weight -- 16 pounds

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DESCRIPTION & OPERATION

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DISASSEMBLY1. Disassembly

CAUTION: THE BUSTLE ASSEMBLY CONSISTS OF APPEARANCE ITEMS. SPECIAL CARE MUST BE TAKEN TO PREVENT MARRING VISIBLE SURFACES.

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

A. Separate upper and lower shell assemblies (640, 655, IPL Fig. 1).

(1) Remove screws (470), washers (475), and anchor straps (495).

CAUTION: HOLD CABLE WHILE REMOVING SCREWS AND WASHERS TO PREVENT CABLE ASSEMBLY FROM SNAPPING WHEN SCREWS ARE REMOVED.

(2) 416T2042-3 assembly

(a) Rotate shells (640, 655) on hinge until hinge halves (580, 600) disengage and separate.

(b) Remove hinge half (600) and connection hinge (575) by removing bolts (585), screws (560, 590) and washers (565, 595).

(c) Remove hinge pin (603).

(3) 416T2042-5 assembly

(a) Remove screws (6023) and washers (602K) and separate upper and lower shells (640, 655).

(b) Remove hinge half (604) and connection hinge (577) by removing bolts (602), screws (602G, 602J) and washers (602K, 602P).

B. Remove screws (375), washers (380) and spring brackets (365).

C. Remove cotter pin (445), washer (455) and drilled shank pin (450).

D. Remove link (460) and springs (440).

E. Remove cotter pin (170), washer (180), drilled shank pin (175) and latch (185).

F. Remove screws (190) and clip (195).

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- G. Remove screws (200), washers (205) and leg latch housing (215).
- H. Remove viewport (60) by removing screw (5) and washer (10) and viewport retainer (50).
- I. Remove screws (280), washers (285), and handle (290, 295).

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DISASSEMBLY

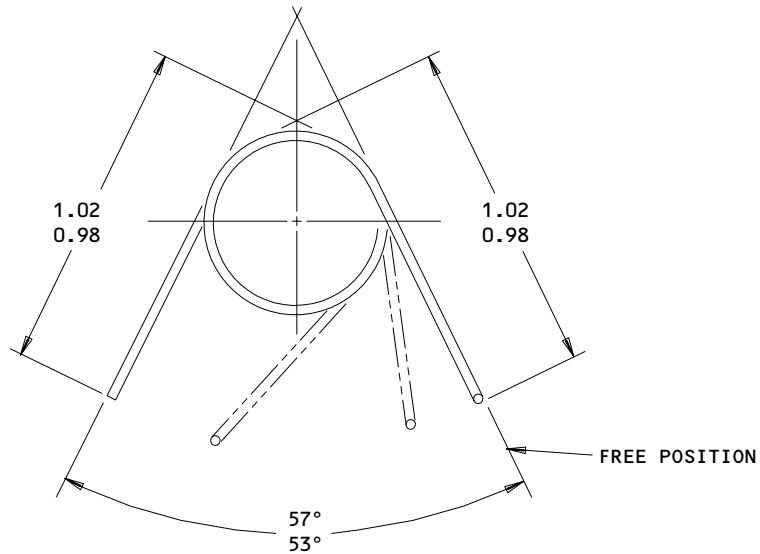
01

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CHECK

1. Check all parts for obvious defects using standard industry practices.
2. Penetrant check housing (215) and retainer (625) per 20-20-02.
3. Check spring (70, 75) per Fig. 501.



ITEM NO. FIG. 1	TEST DEFLECTION (DEGREE) (FROM FREE POSITION)	ALLOWABLE LOAD LIMIT (POUND-INCH)
70,75	15-19	0.072-0.088
	73-77	0.324-0.394

416T2305-1,-2
 Spring Check
 Figure 501

160384

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CHECK
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REPAIR – GENERAL

1. Repair and refinish procedures are included in separate repair section as follows:

<u>P/N</u>	<u>NAME</u>	<u>REPAIR</u>
416T2246	HOUSING	1-1
- -	MISC. PARTS REFINISH	2-1

2. Standard Practices

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

20-30-02 Stripping of Protective Finish
 20-30-03 Passivation
 20-41-01 Decoding Table for Boeing Finishing Codes
 20-41-02 Applications of Chemical and Solvent Resistant Finish
 20-42-05 Cadmium Plating
 20-50-08 Application of Solid Film Lubricant

3. Materials

NOTE: Equivalent substitute may be used.

- A. Primer -- BMS 10-11, type 1 (Ref 20-60-02)
 B. Dry Film Lube -- MIL-L-8937 (Ref 20-60-03)
 C. Dry Film Lube -- BMS 3-8 (Ref 20-60-03)
 D. Compound, potting -- BMS 5-28, types 9, 10, 18 (20-60-04)

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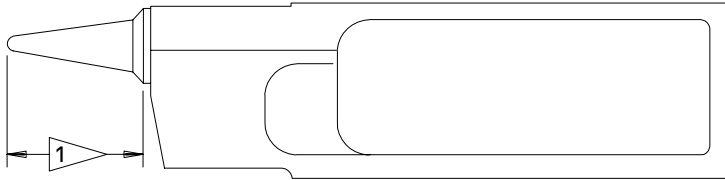
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
HOUSING - REPAIR 1-1

416T2246-5, -6

1. Plating Repair

NOTE: Repair consists of restoration of original finish. Refer to Refinish instructions, Fig. 601, and to REPAIR-GEN for list of applicable standard practices.

**REFINISH:**

CHROMIC ACID ANODIZE TYPE 1, AND APPLY ONE COAT OF BMS 10-11 TYPE 1 PRIMER (F-18.13) EXCEPT AS NOTED BY 

 APPLY DRY LUBE FILM PER MIL-L-8937 OR BMS 3-8

REPAIR:

(SAME AS REFINISH)

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

416T2246-5,-6
 Housing Refinish
 Figure 601

MISCELLANEOUS PARTS REFINISH – REPAIR 2-1

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

IPL FIG. & ITEM	MATERIAL	FINISH
<u>Fig. 1</u>		
Retainer (20,25,625) Bracket (255,265,270,435) Link (460) Anchor strap (495) Hinge connection (575) Channel (675)	Al alloy	Chemical treat and apply one coat of BMS 10-11, type 1 primer (F-18.06).
Retainer (50)	17-7 PH CRES	Cadmium plate type 2, class 2 (F-15.06).
Spring (70,75)	17-7 PH CRES Wire	Passivate all over (F-17.09).
Insert (126)	15-5 PH CRES 150-170 ksi	Passivate all over (F-17.09).
Clip (195) Housing (215)	Al alloy	Chromic acid anodize type 1 and apply one coat of BMS 10-11, type 1 primer (F-18.13).
Spring (440)	Steel, music wire	Apply one coat of BMS 10-11 type 1 primer (F-20.02).
Hinge pin (555)	AISI 304 CRES	Passivate all over (F-17.09), and apply solid lubricant MIL-L-8937 to outside diameter.
Hinge half (580,600)	Al alloy	Chromic acid anodize all over (F-17.02).
Hinge half (604,604G)	Al alloy	Apply one coat of BMS 10-11 type 1 primer (F-20.02).

Refinish Details
Figure 601

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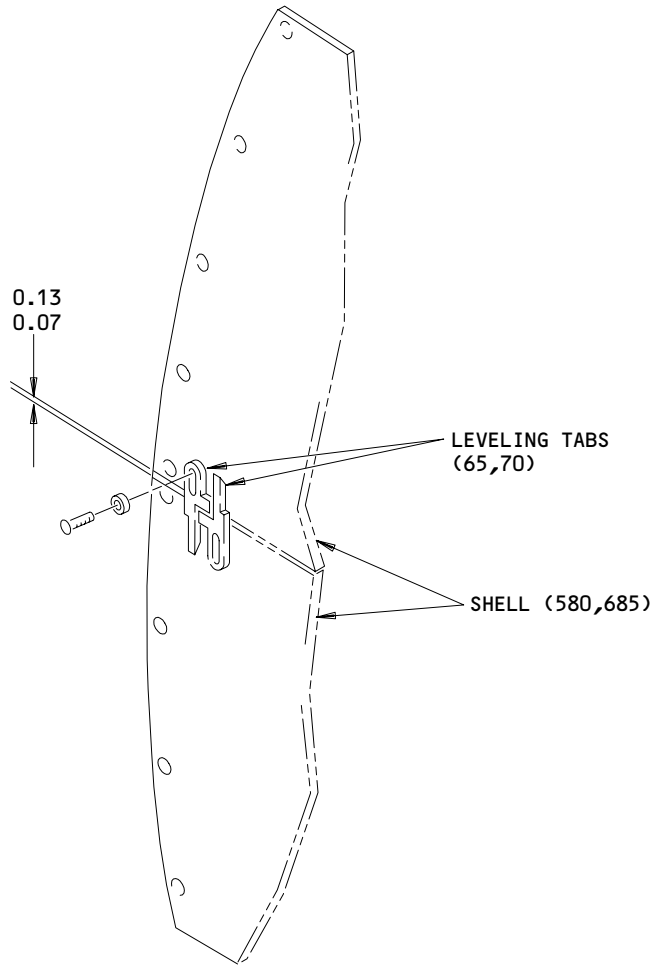
ASSEMBLY

1. Install channel (235, IPL Fig. 1) using washers (245) and screws (240).
2. 416T2047-3 assembly
 - A. Install hinge half (600) on shell (655) using screws (590), bolts (585) and washers (595).
 - B. Install connection hinge (575) and hinge half (580) on shell (640) using screws (560) and washers (565).
3. 416T2047-5, attach hinge (601) to shell (640) using bolts (585), screws (590) and washers (595).
4. Install viewport (60) using viewport retainer (50), washer (10) and screw (5).
5. Install leg latch housing (215) to housing (230) using washers (205) and screws (200).
6. Install clips (195) on housing (230) using screws (190).
7. Install latches (185) on housing (230) using drilled shank pin (175), washer (180), and cotter pin (170).
8. Install latches (150, 155) using washers (165), and screws (160).
9. Install spring (440) on bracket (365).
10. Attach link (460) to spring (440).
11. Attach cable (465) to link (465) using drilled shank pin (45G), washer (455), and cotter key (445).
12. Install spring bracket (365) using washers (386) and screws (375).
13. 416T2047-3 assembly; assemble shells (640, 655) by engaging hinge halves (580, 600).
14. 416T2047-5 assembly; assemble shells (640, 655) by attaching connection hinge (577) to shell (640) using screws (602J) and washers (602K).
15. Adjust leveling tabs (515, 530) per Fig. 701.

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Leveling Tab Adjustment
Figure 701

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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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VENDORS

06710 LAMSON AND SESSIONS CO THE VALLEY-TODECO
12975 BRADLEY AVENUE
SYLMAR, CALIFORNIA 91342-3830

06725 AIR INDUSTRIES CORPORATION
12570 KNOTT STREET
GARDEN GROVE, CALIFORNIA 92641-3932

06950 SCREWCORP VSI CORP AEROSPACE PRODUCTS DIV FAIRCHILD IND INC
13001 EAST TEMPLE AVE. PO BOX 730
CITY OF INDUSTRY, CALIFORNIA 91746-1417

08524 DEUTSCH FASTENER CORP SEE CODE V97928

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

11328 AEROQUIP CORP LINAIR DIV
651 WEST KNOX STREET
GARDENA, CALIFORNIA 90248-4409

15653 KAYNAR MICRODOT AEROSPACE FASTENING SYSTEM
800 SOUTH COLLEGE BLVD PO BOX 3001
FULLERTON, CALIFORNIA 92634-3001

17943 FEDERAL MANUFACTURING CORPORATION
6910 FARMDALE AVENUE
NORTH HOLLYWOOD, CALIFORNIA 91605-6210

26590 HOOD INDUSTRIES
4615 SHEPARD STREET
BAKERSFIELD, CALIFORNIA 93309

27624 PAUL R BRILES INC P.B. FASTENER DIV
1700 WEST 132ND STREET PO BOX 1157
GARDENA, CALIFORNIA 90249-2008

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

59157 LOOS AND COMPANY INCORPORATED
ROUTE 101 PO BOX 98
POMFRET, CONNECTICUT 06258

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VENDORS

65196 CABLEWARE TECHNOLOGY INC
 900 INDUSTRIAL BLVD. PO BOX 7515
 NAPLES, FLORIDA 33941

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

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

73439 AMSCO PRODUCTS CAMCAR DIV TEXTRON INC
 345 EAST MARSHALL STREET
 WYTHEVILLE, VIRGINIA 24382-3917

78189 ILLINOIS TOOL WORKS INC SHAKEPROOF DIVN
 ST CHARLES ROAD
 ELGIN, ILLINOIS 60120

80523 BABCOCK ACCO INC ACCO CONTROLS GROUP SUB OF BABCOCK INTL
 1014 ERIE STREET PO BOX 608
 ADRIAN, MICHIGAN 49221-0608

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

83014 HARTWELL CORPORATION
 900 SOUTH RICHFIELD ROAD
 PLACENTIA, CALIFORNIA 92670-6732

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

94222 SOUTHCO INCORPORATED
 210 NORTH BRINTON LAKE ROAD
 CONCORDVILLE, PENNSYLVANIA 19331

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

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VENDORS

97928

DEUTSCH FASTENER CORP
3969 PARAMONT BOULEVARD
LAKEWOOD, CALIFORNIA 90712-4193

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
AN960C10		1	310	3
		1	345	3
AN960C10L		1	10	14
		1	165	16
		1	205	8
		1	245	6
		1	285	8
		1	380	8
		1	390	4
		1	455	2
		1	475	4
		1	525	4
		1	565	10
AN960C3		1	485	2
BACB12FA3K6		1	111B	11
BACB30LH3-4		1	535	4
BACN10JC3		1	405	2
BACN10JC3M		1	210	4
BACR15BA4AD		1	570	14
		1	572	15
BACR15BB4AD		1	260	3
BACR15BB4D		1	430	4
BACR15CE4D		1	250	6
BACS12FA3C4		1	139	2
BACS12FA3C6		1	111A	11
BACS12FA3K4		1	6	2
		1	139A	2
BACS12N10-4		1	110	11
		1	138	2
BACS40R007E029F		1	327	2
		1	362	2
BACT14B2		1	481	2
BACW10P43AL		1	595	10
BACW10P43AL		1	602P	10
		1	610	2
BA3-2		1	481	2
BRH10A3		1	405	2
CA3105-1032-4		1	110	11
		1	138	2
HI2487-2		1	481	2
H10-3BAC		1	405	2
MS16562-1		1	604K	2
MS20253P1-240		1	65	1
MS20253P2-2990		1	603	1

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
MS20392-2C43		1	175	4
MS20392-2C9		1	450	2
MS20664C2		1	490	2
MS20667-2		1	480	2
MS21209F1-10P		1	225	8
MS24586-764		1	440	4
MS24665-132		1	445	2
MS24665-151		1	170	4
MS24693C270		1	95	2
NAS173BE4		1	415	4
NAS1836-3-07		1	315	4
		1	350	4
		1	645	41
		1	660	52
NAS514P1032-5		1	190	8
		1	307	1
		1	340	1
		1	510	4
NAS514P1032-6		1	112A	2
NAS603-24		1	120	2
NAS603-4		1	160	16
		1	280	8
		1	375	8
		1	470	4
		1	560	10
NAS603-4P		1	240	6
NAS603-5		1	5	16
		1	6A	2
		1	305	3
		1	335	3
		1	590	4
		1	602G	4
NAS603-9		1	520	4
NAS620-10L		1	15	2
NAS620C10L		1	180	12
NAS6603-32		1	385	2
NAS6703-20		1	200	4
NAS6703P4		1	605	2
NAS6703P5		1	585	6
		1	602	6
NS202101-02		1	405	2
RA2487-2		1	481	2
RMLH9075-3W		1	405	2
		1	670	16
SP1561-1032-4		1	110	11
		1	138	2

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
T6S1032J		1	405	2
416T2047-3SP		1	1	RF
416T2047-5SP		1	1A	RF
416T2047-6SP		1	1B	RF
416T2047-7SP		1	1C	RF
416T2158-10SP		1	105	1
416T2158-13SP		1	114	1
416T2158-15SP		1	114A	1
416T2159-13		1	540	2
416T2178-1		1	215A	8
416T2191-2		1	663	4
		1	675	8
416T2207-11SP		1	30	1
416T2207-12SP		1	35	1
416T2207-15SP		1	40	1
416T2207-16SP		1	45	1
416T2207-19SP		1	30A	1
416T2207-20SP		1	35A	1
416T2207-23SP		1	40A	1
416T2207-24SP		1	45A	1
416T2223-3		1	320	4
		1	355	4
416T2223-6		1	330	1
416T2223-7		1	300	1
416T2223-8		1	360	1
416T2223-9		1	325	1
416T2226-1SP		1	295	1
416T2226-2SP		1	290	1
416T2243-22SP		1	640	1
416T2243-23SP		1	655	1
416T2243-24		1	665	1
416T2243-27		1	650A	1
416T2243-28		1	665A	1
416T2243-34SP		1	640A	1
416T2243-35SP		1	655A	1
416T2243-38SP		1	655B	1
416T2243-39SP		1	640B	1
416T2243-4		1	650	1
416T2244-2		1	215	8
416T2245-4		1	195	4
416T2246-5		1	220A	4
416T2246-6		1	220	4
416T2246-7		1	230A	4
416T2246-8		1	230	4
416T2247-2SP		1	275	1

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
416T2248-4		1	615	1
416T2248-5		1	625	1
416T2256-1SP		1	140	4
416T2256-2SP		1	145	4
416T2259-2SP		1	55	1
416T2259-3SP		1	55A	1
416T2260-3SP		1	60	1
416T2262-1		1	115	2
416T2262-2		1	126	2
416T2262-3		1	127	2
416T2263-1		1	100	2
416T2272-1SP		1	135	1
416T2272-2SP		1	130	1
416T2272-7SP		1	137	1
416T2272-8SP		1	132	1
416T2273-1		1	580	2
416T2273-3		1	600	2
416T2274-1		1	575	2
416T2277-10		1	255	1
416T2277-6		1	270	1
416T2277-7		1	265	1
416T2277-9		1	235	1
416T2278-1		1	530	2
416T2278-2		1	515	2
416T2280-2		1	20	2
416T2280-4		1	25	2
416T2281-1		1	495	2
416T2281-2		1	460	2
416T2282-2		1	500	2
416T2282-3		1	465	2
416T2282-4		1	466	2
416T2282-5		1	487	2
416T2282-6		1	501	2
416T2284-11SP		1	545A	2
416T2284-7SP		1	550	1
416T2284-9SP		1	545	2
416T2289-1		1	505	2
416T2290-1		1	555	1
416T2291-8		1	150	2
416T2291-9		1	155	2
416T2298-1SP		1	60A	1
416T2303-1		1	50	1
416T2305-1		1	70	1
416T2305-2		1	75	1
416T2311-1		1	630	2

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
416T2800-16		1	365	2
416T2800-18		1	435	2
416T2800-19		1	420	2
416T2800-20		1	425	2
416T2800-22		1	365A	2
		1	370	2
416T2800-6		1	410	2
416T2800-7		1	395	2
416T2800-8		1	400	4
416T2831-2		1	113A	1
416T2832-1		1	577	1
416T2833-1		1	601	1
416T2833-2		1	604	1
416T2833-3		1	604G	1
8-04056-2		1	481	2
96-02		1	405	2

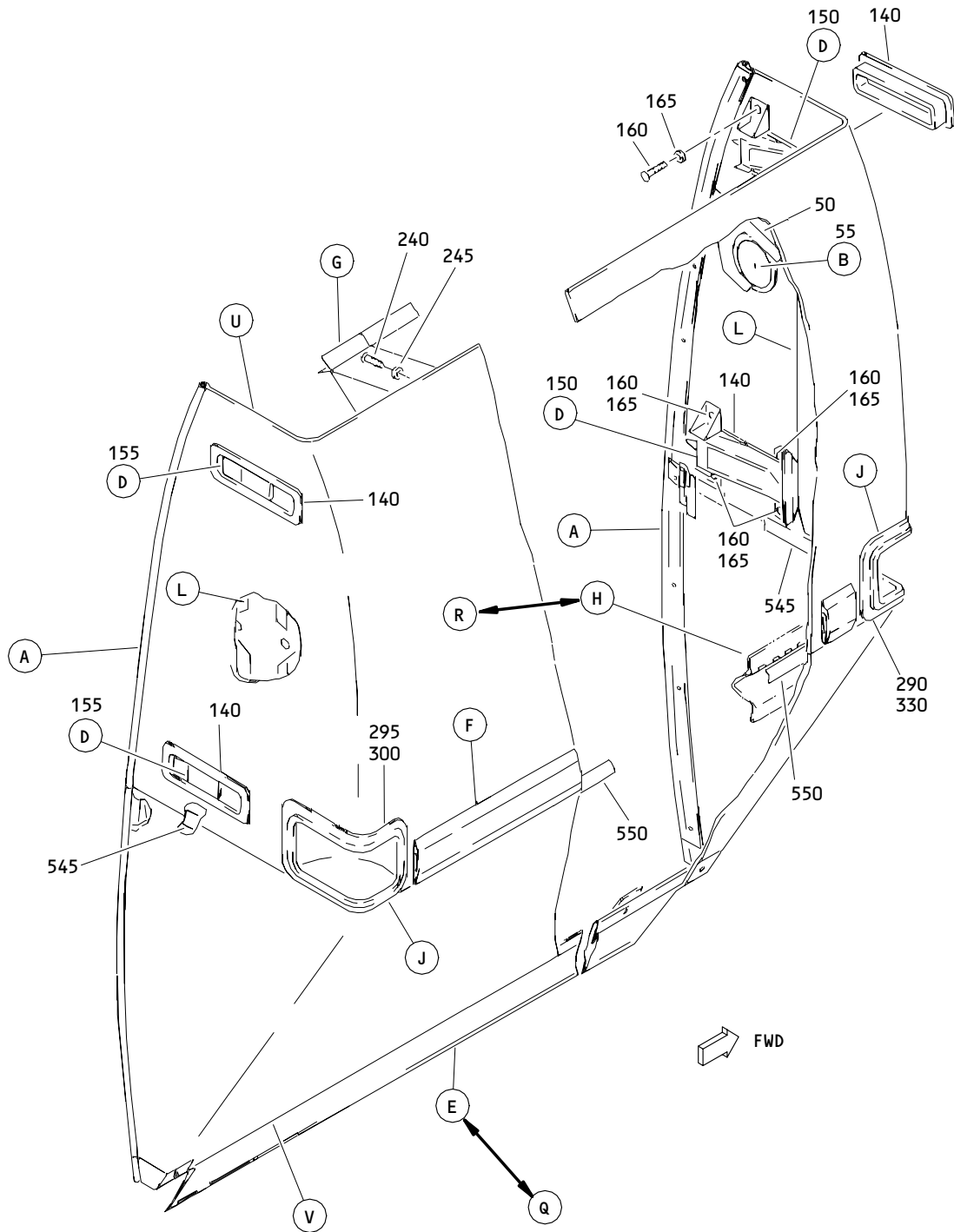
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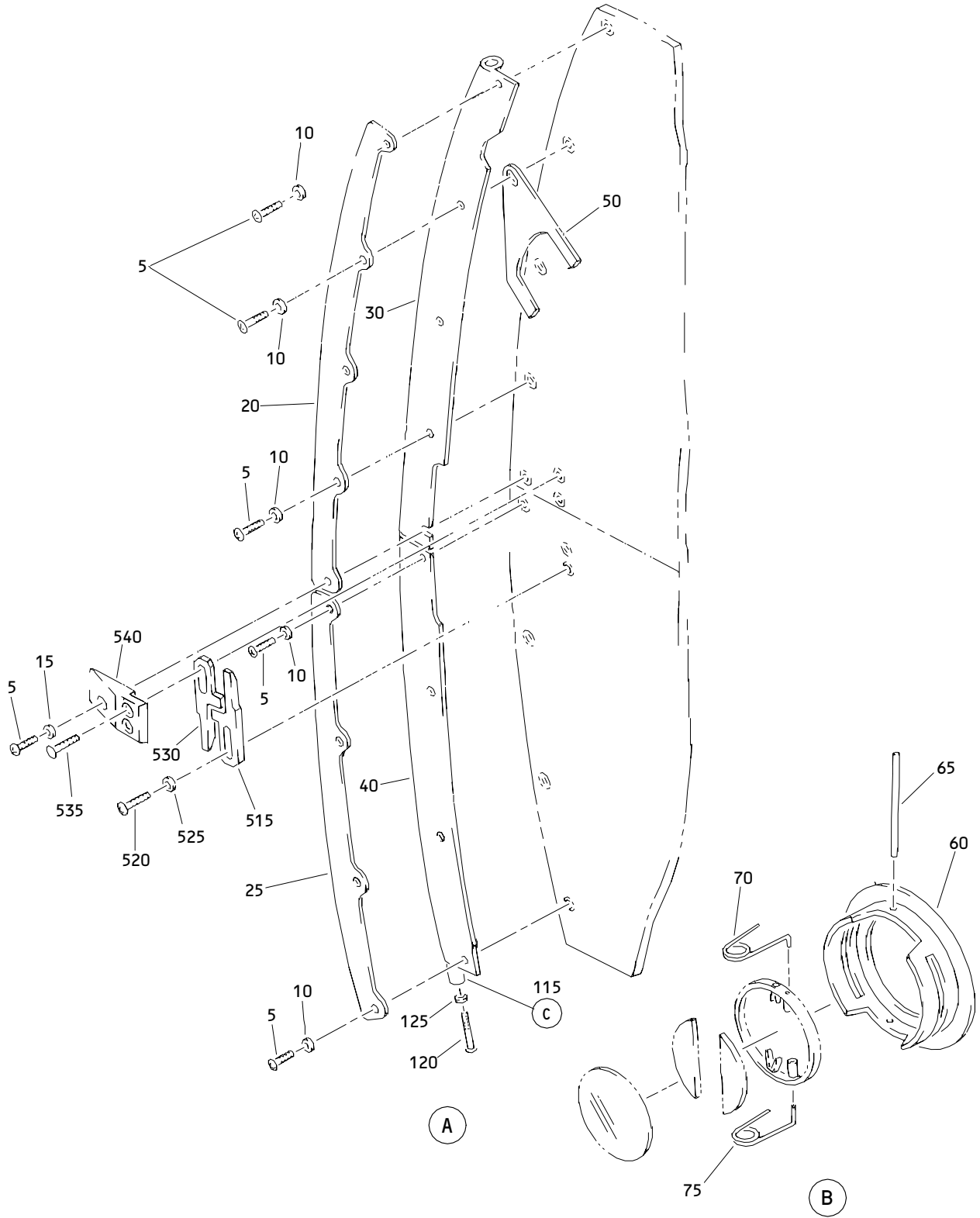


Aft Door - Bustle Assembly
 Figure 1 (Sheet 1)

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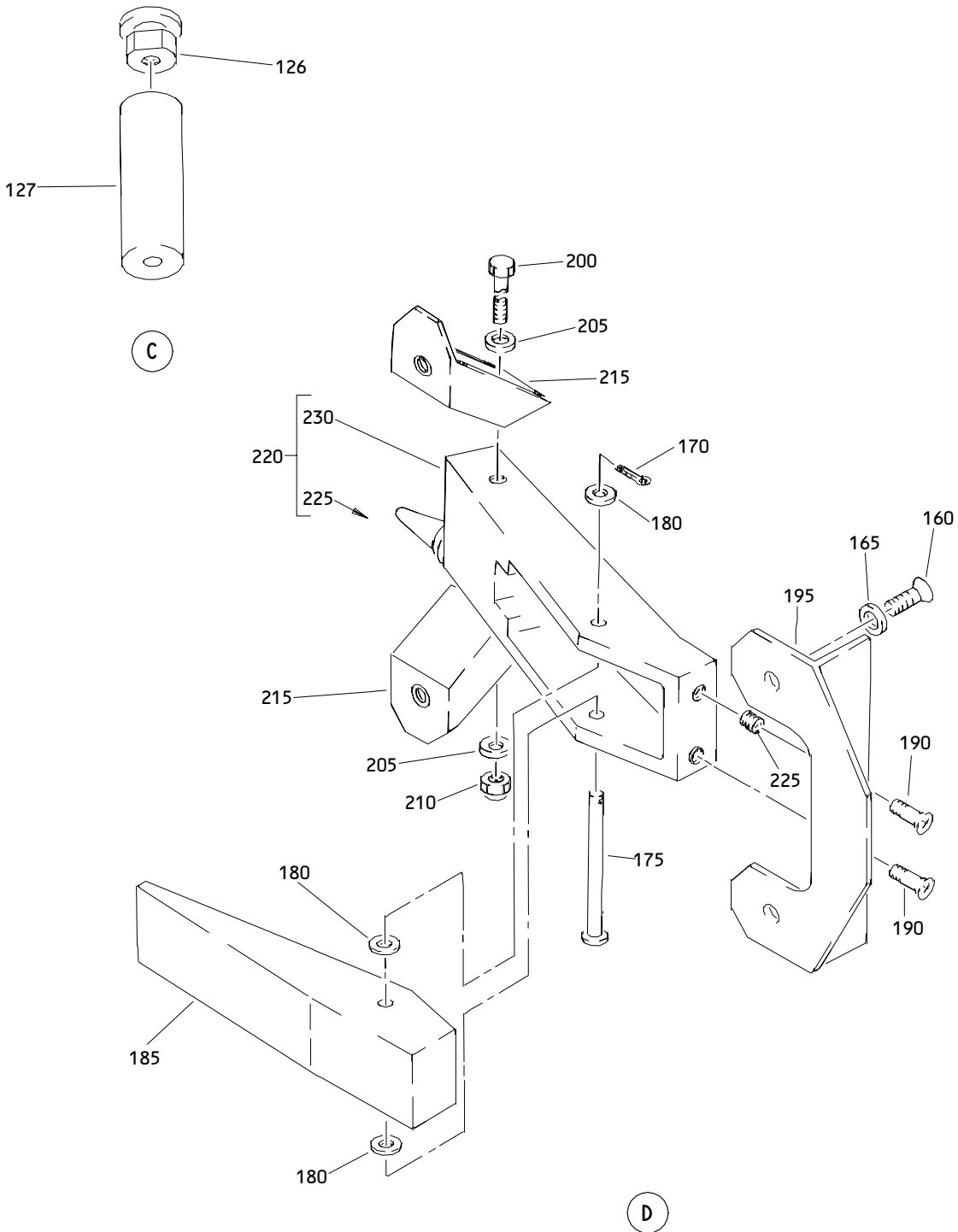
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Aft Door - Bustle Assembly
Figure 1 (Sheet 2)

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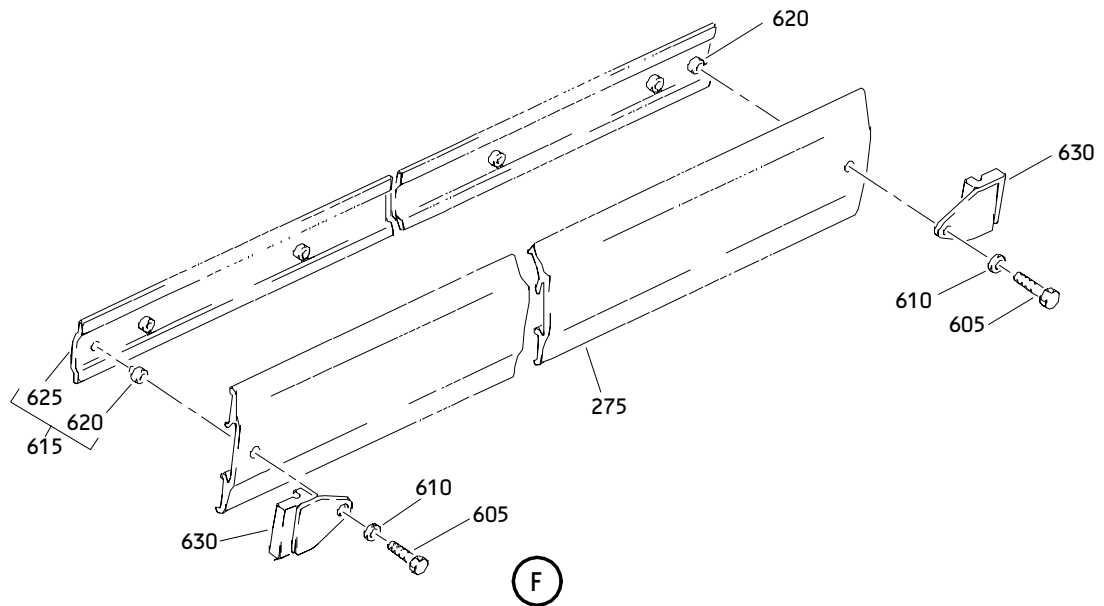
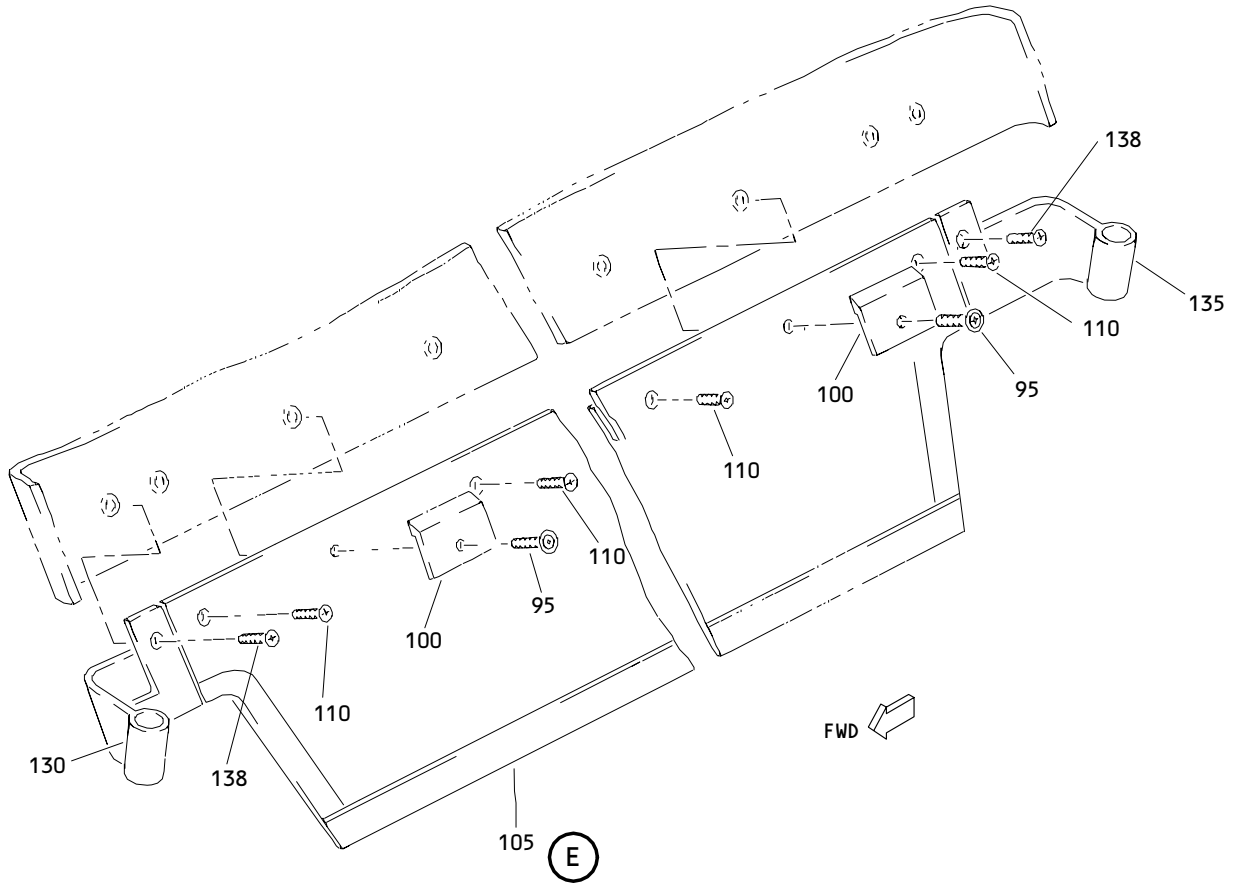


Aft Door - Bustle Assembly
 Figure 1 (Sheet 3)

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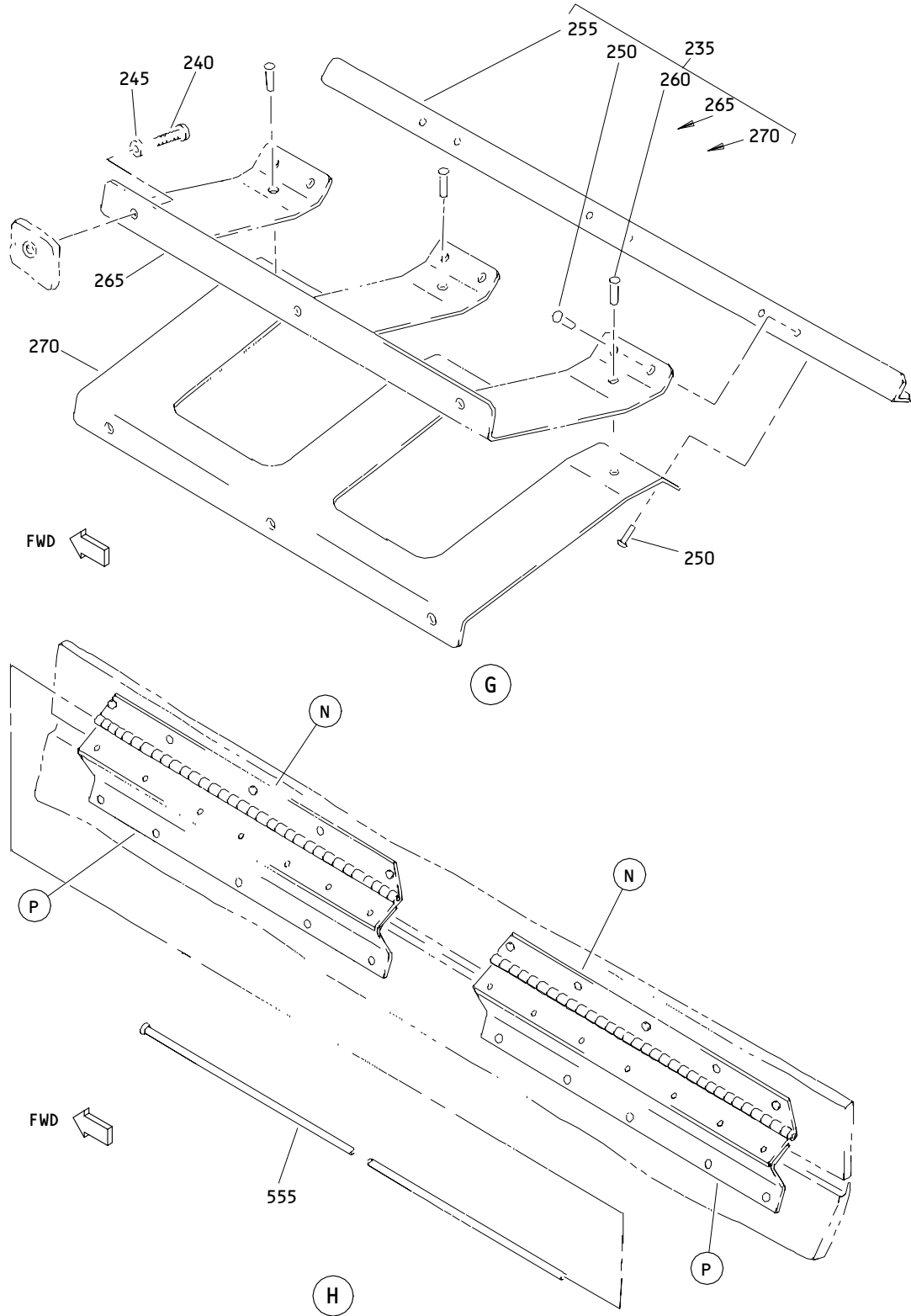
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 Figure 1 (Sheet 4)

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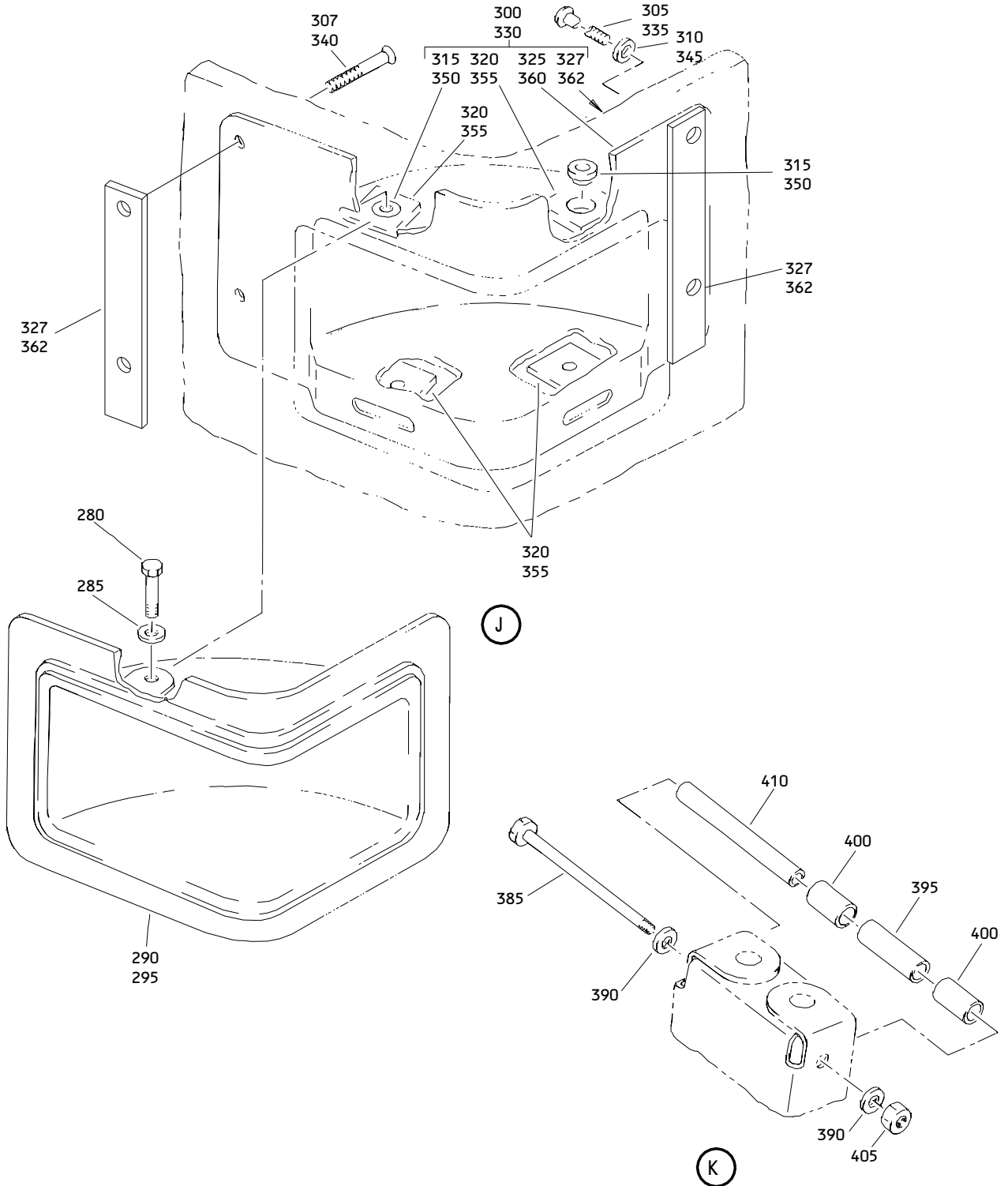
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Figure 1 (Sheet 5)

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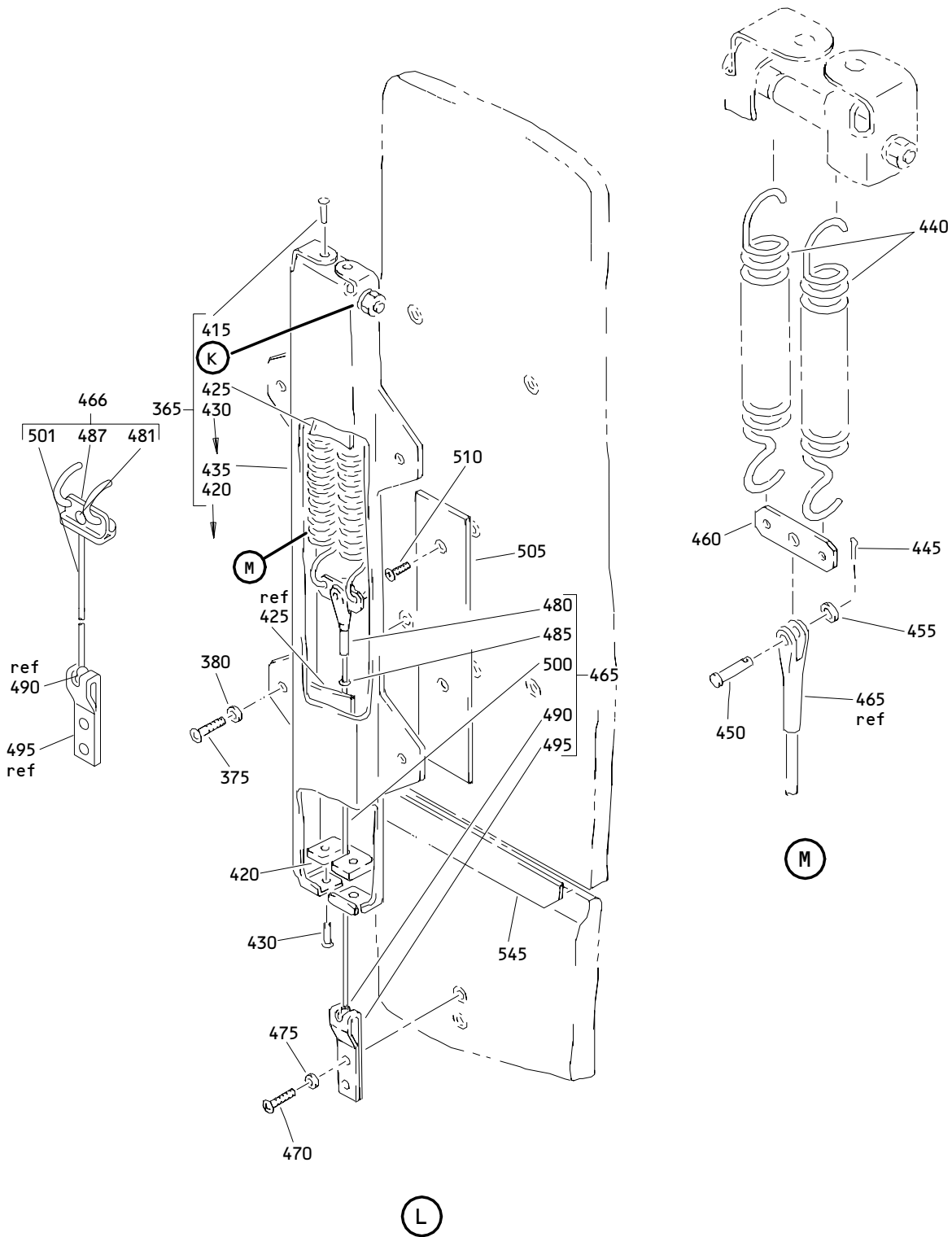
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Figure 1 (Sheet 6)

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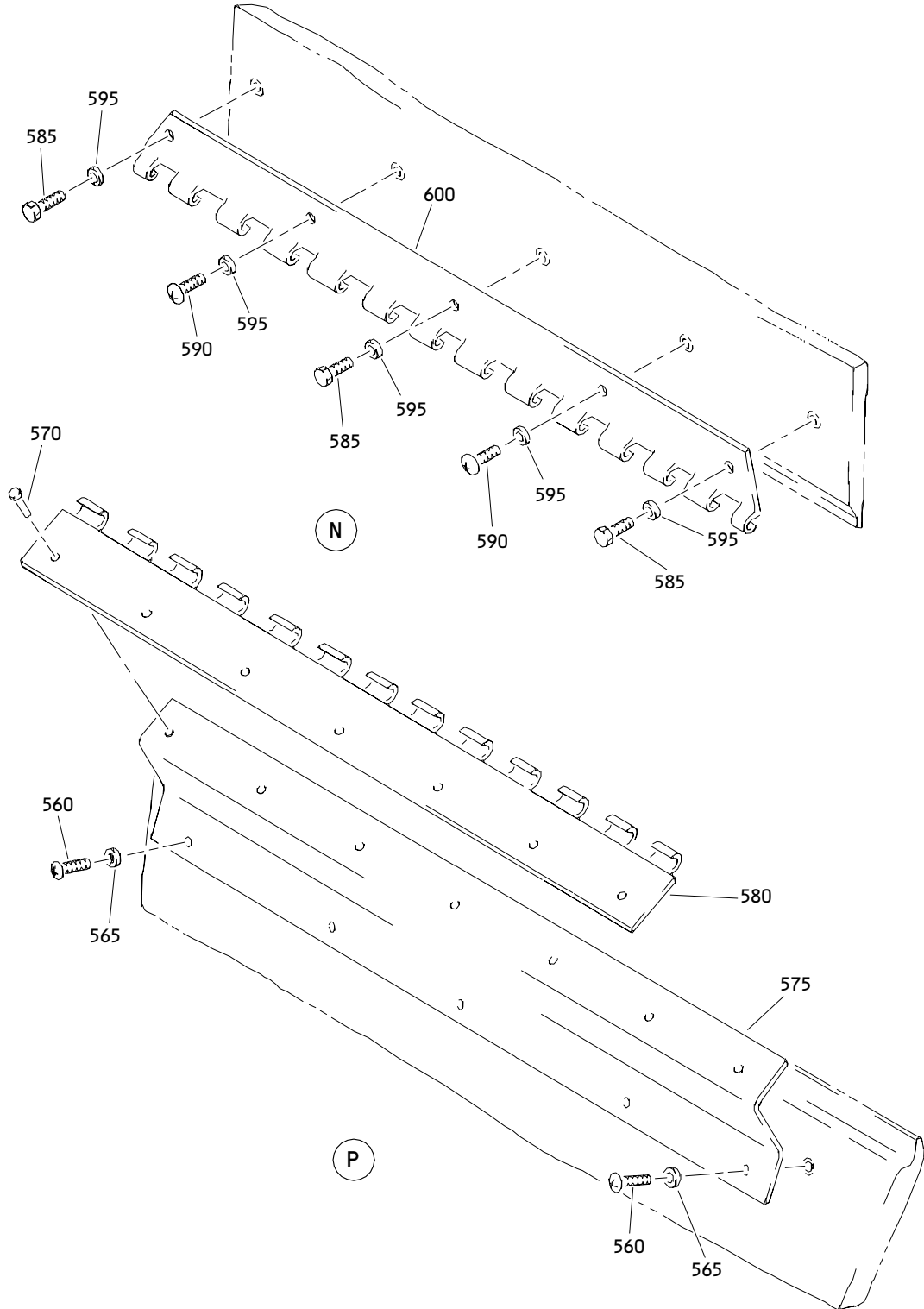
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(L)
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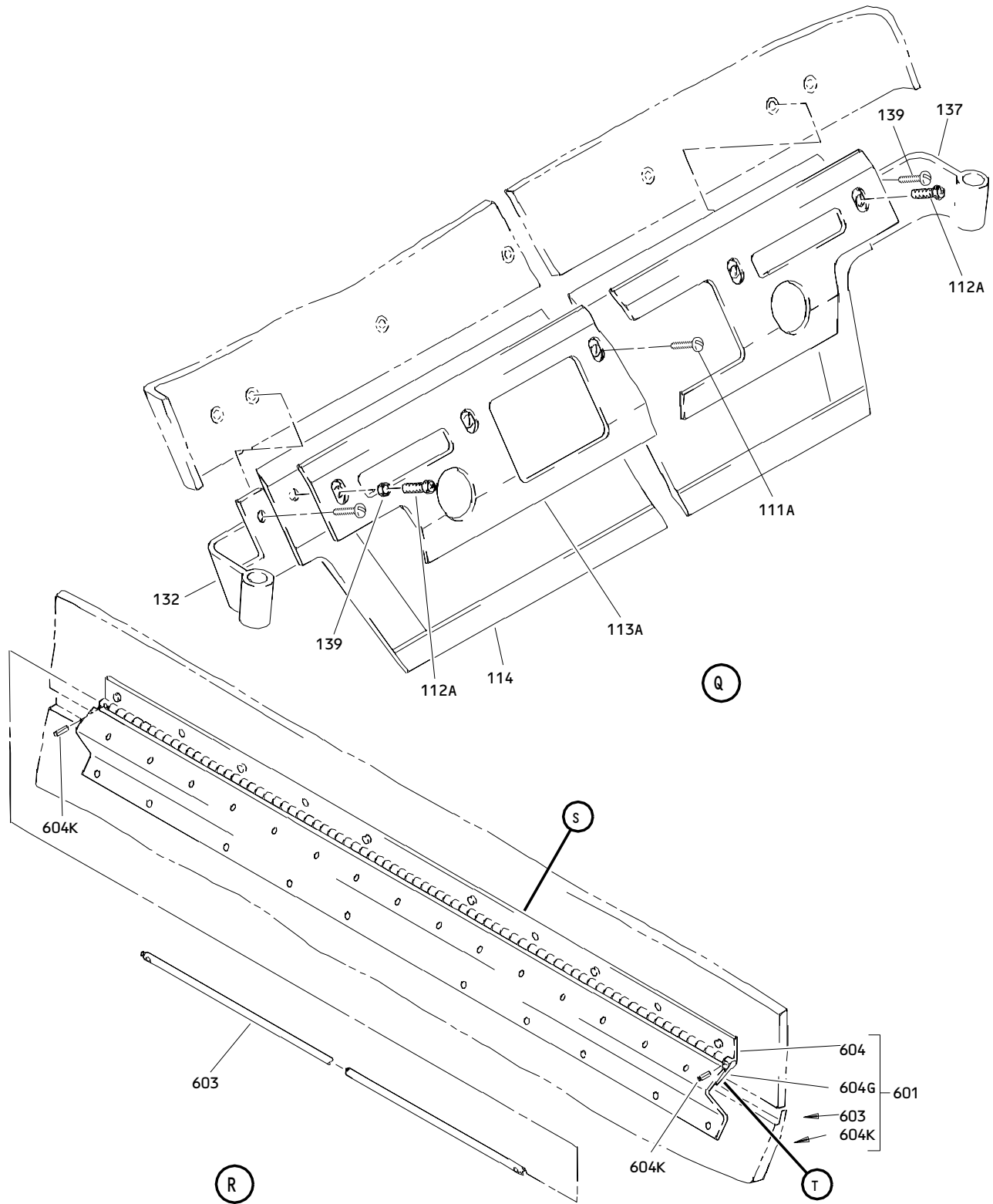
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Aft Door - Bustle Assembly
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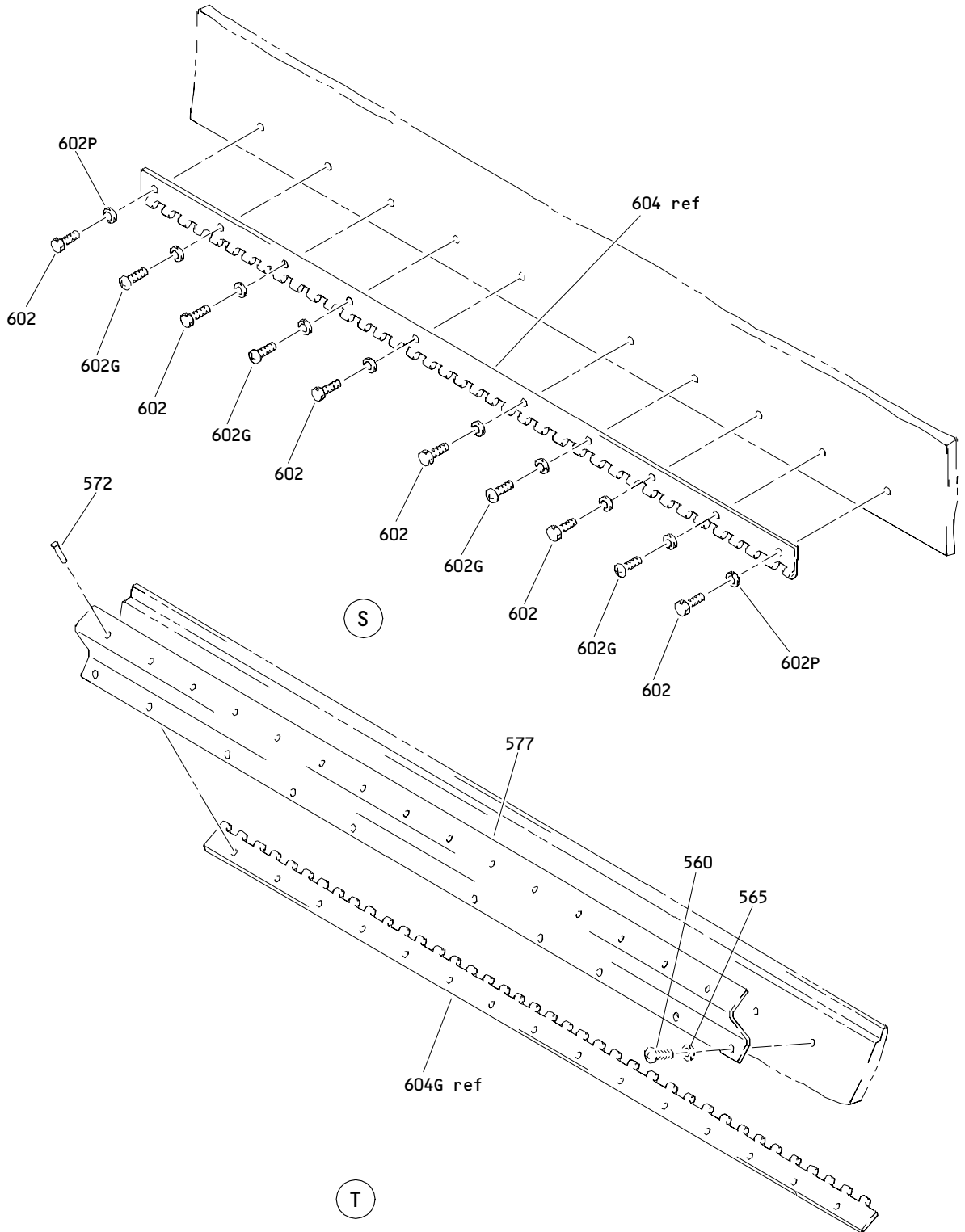
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Aft Door - Bustle Assembly
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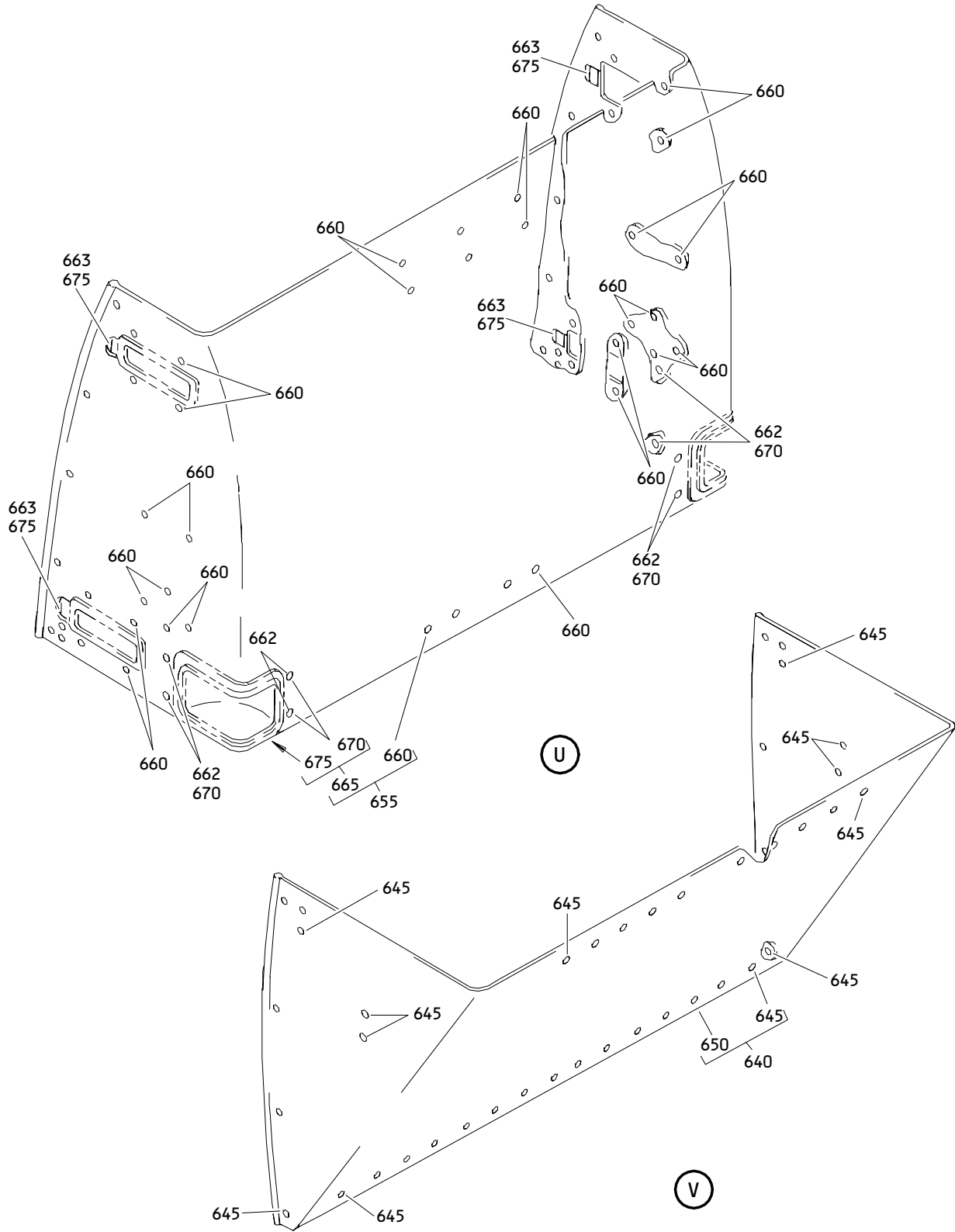
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Aft Door - Bustle Assembly
 Figure 1 (Sheet 11)

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 01-					
R -1	416T2047-3SP		BUSTLE ASSY-AFT DOOR	A	RF
-1A	416T2047-5SP		BUSTLE ASSY-AFT DOOR	B	RF
R -1B	416T2047-6SP		BUSTLE ASSY-AFT DOOR	C	RF
R -1C	416T2047-7SP		BUSTLE ASSY-AFT DOOR	D	RF
R 5	NAS603-5		.SCREW		16
R 6	BACS12FA3K4		.SCREW-	A-C	2
			(OPT ITEM 6A)		
R -6A	NAS603-5		.SCREW-	A-C	2
			(OPT ITEM 6)		
R -6B	BACS12FA3K4		.SCREW	D	2
R 10	AN960C10L		.WASHER		14
15	NAS620-10L		.WASHER		2
20	416T2280-2		.RETAINER		2
25	416T2280-4		.RETAINER		2
30	416T2207-11SP		.SEAL	A	1
-30A	416T2207-19SP		.SEAL	B-D	1
-35	416T2207-12SP		.SEAL	A	1
-35A	416T2207-20SP		.SEAL	B-D	1
40	416T2207-15SP		.SEAL	A	1
-40A	416T2207-23SP		.SEAL	B-D	1
-45	416T2207-16SP		.SEAL	A	1
-45A	416T2207-24SP		.SEAL	B-D	1
50	416T2303-1		.RETAINER-VIEWPORT		1
55	416T2259-2SP		.VIEWPORT ASSY-SLIDE PRESSURE GAUGE (OPT ITEM 55A)	A	1
-55A	416T2259-3SP		.VIEWPORT ASSY-SLIDE PRESSURE GAUGE (OPT ITEM 55)	A	1
R -55B	416T2259-2SP		.VIEWPORT ASSY-SLIDE	B-D	1
60	416T2260-3SP		..BEZEL-		1
			(USED ON ITEM 55)		
-60A	416T2298-1SP		..BEZEL-	A	1
			(USED ON ITEM 55A)		
65	MS20253P1-240		..PIN-HINGE		1
70	416T2305-1		..SPRING		1
75	416T2305-2		..SPRING		1
95	MS24693C270		.SCREW	A	2
100	416T2263-1		.STRIP-RUB	A	2
105	416T2158-10SP		.SEAL ASSY-BLADE	A	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
R 110	CA3105-1032-4		ATTACHING PARTS .SCREW- (V73439) (SPEC BACS12N10-4) (OPT CA3105-1032-4 (V78189)) (OPT SP1561-1032-4 (V73439)) -----*	A	11
R 111	BACS12FA3C7		DELETED		
R 111A	BACS12FA3C6		.SCREW	B	11
R -111B	BACB12FA3K6		.SCREW	C,D	11
R 112	AN960-10L		DELETED		
R 112A	NAS514P1032-6		.SCREW	B-D	2
R 113	416T2831-1		DELETED		
R 113A	416T2831-2		.STIFFENER-BLADE SEAL	B-D	1
R 114	416T2158-13SP		.SEAL ASSY-BLADE (OPT ITEM 114A)	B-D	1
R -114A	416T2158-15SP		.SEAL ASSY-BLADE (OPT ITEM 114)	B-D	1
R 115	416T2262-1		.PLUG ASSY	A	2
R 120	NAS603-24		ATTACHING PARTS .SCREW	A	2
R 125	AN960-10L		.WASHER -----*	A	2
R 126	416T2262-2		..INSERT	A	1
R 127	416T2262-3		..MOLDING	A	1
R 130	416T2272-2SP		.SEAL ASSY-CORNER	A	1
R 132	416T2272-8SP		.SEAL ASSY-CORNER	B-D	1
R 135	416T2272-1SP		.SEAL ASSY-CORNER	A	1
R 137	416T2272-7SP		.SEAL ASSY-CORNER	B-D	1
R 138	CA3105-1032-4		ATTACHING PARTS .SCREW- (V73439) (SPEC BACS12N10-4) (OPT CA3105-1032-4 (V78189)) (OPT SP1561-1032-4 (V73439))	A	2
R 139	BACS12FA3C4		.SCREW -----*	B	2
R -139A	BACS12FA3K4		.SCREW	C,D	2
R 140	416T2256-1SP		.BEZEL-LATCH (REPLD BY ITEM 145)	A	4
R -140A	416T2256-1SP		DELETED		

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-145	416T2256-2SP		.BEZEL-LATCH (REPLS ITEM 140)	A	4
-145A	416T2256-2SP		.BEZEL-LATCH	B-D	4
150	416T2291-8		.LATCH ASSY		2
155	416T2291-9		.LATCH ASSY		2
			ATTACHING PARTS		
160	NAS603-4		.SCREW		16
165	AN960C10L		.WASHER		16
			-----*-----		
170	MS24665-151		..PIN-COTTER		1
175	MS20392-2C43		..PIN-DRILLED SHANK		1
180	NAS620C10L		..WASHER		3
185	H2950-5		..LATCH- (V83014)		1
190	NAS514P1032-5		..SCREW		2
195	416T2245-4		..CLIP-LWR		1
200	NAS6703-20		..BOLT		1
205	AN960C10L		..WASHER		2
210	BACN10JC3M		..NUT		1
215	416T2244-2		..HOUSING-LEG (OPT ITEM 215A)		2
-215A	416T2178-1		..HOUSING-LEG (OPT ITEM 215)		2
220	416T2246-6		..HOUSING ASSY- (USED ON ITEM 155)		1
220A	416T2246-5		..HOUSING ASSY- (USED ON ITEM 150)		1
225	MS21209F1-10P		...INSERT		2
230	416T2246-8		...HOUSING- (USED ON ITEM 220)		1
230A	416T2246-7		...HOUSING- (USED ON ITEM 220A)		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01- 235	416T2277-9		.CHANNEL ASSY-LATCH LOCKOUT ATTACHING PARTS		1
240	NAS603-4P		.SCREW		6
245	AN960C10L		.WASHER -----*-----		6
250	BACR15CE4D		..RIVET- (SIZE DETERMINE ON INST)		6
255	416T2277-10		..BRACKET		1
260	BACR15BB4AD		..RIVET- (SIZE DETERMINE ON INST)		3
265	416T2277-7		..BRACKET		1
270	416T2277-6		..BRACKET		1
R 275	416T2247-2SP		.STRIP-RUB		1
-275A	416T2247-3SP		DELETED		
280	NAS603-4		.SCREW		8
285	AN960C10L		.WASHER		8
290	416T2226-2SP		.HANDLE-DECORATIVE COVER		1
-290A	416T2226-4SP		DELETED		
295	416T2226-1SP		.HANDLE-DECORATIVE COVER		1
-295A	416T2226-3SP		DELETED		
300	416T2223-7		.HANDLE ASSY ATTACHING PARTS		1
305	NAS603-5		.SCREW		3
307	NAS514P1032-5		.SCREW		1
310	AN960C10		.WASHER -----*-----		3
315	NAS1836-3-07		..INSERT		4
320	416T2223-3		..BOSS		4
325	416T2223-9		..HANDLE		1
R 327	BACS40R007E029F		.SHIM		2
330	416T2223-6		.HANDLE ASSY ATTACHING PARTS		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
335	NAS603-5		.SCREW		3
340	NAS514P1032-5		.SCREW		1
345	AN960C10		.WASHER		3
			-----*-----		
350	NAS1836-3-07		..INSERT		4
355	416T2223-3		..BOSS		4
360	416T2223-8		..HANDLE		1
R 362	BACS40R007E029F		.SHIM		2
365	416T2800-16		.BRACKET ASSY-SPRING (REPLD BY ITEM 370)	A	2
R -365A	416T2800-22		.BRACKET ASSY-SPRING	B-D	2
-370	416T2800-22		.BRACKET ASSY-SPRING (REPLS ITEM 365)	A	2
			ATTACHING PARTS		
375	NAS603-4		.SCREW		8
380	AN960C10L		.WASHER		8
			-----*-----		
385	NAS6603-32		..BOLT		1
390	AN960C10L		..WASHER		2
395	416T2800-7		..SPACER		1
400	416T2800-8		..SPACER		2
405	H10-3BAC		..NUT-		1
			(V15653)		
			(SPEC BACN10JC3)		
			(OPT NS202101-02		
			(V80539))		
			(OPT RMLH9075-3W		
			(V72962))		
			(OPT T6S1032J		
			(V71087))		
			(OPT VN303A02		
			(V92215))		
			(OPT 96-02		
			(V80539))		
			(OPT BRH10A3		
			(V52828))		

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
410	416T2800-6		..SLEEVE		1
415	NAS173BE4		..RIVET-		2
			(SIZE DETERMINE ON INST)		
420	416T2800-19		..FAIRLEAD		1
425	416T2800-20		..PAD-		1
			(USED ON ITEM 370)		
430	BACR15BB4D		..RIVET-		2
			(SIZE DETERMINE ON INST)		
435	416T2800-18		..BRACKET		1
440	MS24586-764		.SPRING		4
445	MS24665-132		.PIN-COTTER		2
450	MS20392-2C9		.PIN-DRILLED SHANK		2
455	AN960C10L		.WASHER		2
460	416T2281-2		.LINK	A	2
R -460A	416T2281-2		.LINK-	B	2
			(THE COMBINATION OF ITEMS 460A AND 465A OPT TO ITEM 466. ITEM 466 IS PREFERRED PART)		
465	416T2282-3		.CABLE ASSY	A	2
R -465A	416T2282-3		.CABLE ASSY-	B	2
			(THE COMBINATION OF ITEMS 460A AND 465A OPT TO ITEM 466. ITEM 466 IS PREFERRED PART)		
R 466	416T2282-4		.CABLE ASSY-	B	2
			(THE COMBINATION OF ITEMS 460A AND 465A OPT TO ITEM 466. ITEM 466 IS PREFERRED PART)		
R -466A	416T2282-4		.CABLE ASSY	C,D	2
			ATTACHING PARTS		
470	NAS603-4		.SCREW		4
475	AN960C10L		.WASHER		4
			-----*-----		

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-480	MS20667-2		..TERMINAL- (USED ON ITEM 465A)	B	1
R 481	BA3-2		..TERMINAL- (V59157) (SPEC BACT14B2) (OPT HI2487-2 (V26590)) (OPT HT200-2 (V83014)) (OPT RA2487-2 (V80523)) (OPT BA3-1-2 (V59157)) (OPT 8-04056-2 (V11328)) (OPT BA3-2 (V65196)) (USED ON ITEM 466)	B-D	1
485	AN960C3		..WASHER- (USED ON ITEM 465A)	B	1
R 487	416T2282-5		..LINK- (USED ON ITEM 466)	B-D	1
490	MS20664C2		..BALL END		1
495	416T2281-1		..STRAP-ANCHOR		1
500	416T2282-2		..CABLE- (USED ON ITEM 465A)	B	1
R 501	416T2282-6		..CABLE- (USED ON ITEM 466)	B-D	1
505	416T2289-1		.PAD ASSY-BRG ATTACHING PARTS		2
510	NAS514P1032-5		.SCREW -----*		4
515	416T2278-2		.TAB ASSY-LEVELING ATTACHING PARTS		2
520	NAS603-9		.SCREW		4
525	AN960C10L		.WASHER -----*		4
530	416T2278-1		.TAB ASSY-LEVELING		2

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
535	BACB30LH3-4		ATTACHING PARTS .BOLT- (V06710) (SPEC BACB30LH3-4) (OPT BACB30LH3-4 (V06725)) (OPT BACB30LH3-4 (V06950)) (OPT BACB30LH3-4 (V08524)) (OPT BACB30LH3-4 (V17943)) (OPT BACB30LH3-4 (V27624)) (OPT BACB30LH3-4 (V80539)) (OPT BACB30LH3-4 (V92215)) (OPT BACB30LH3-4 (V97928)) -----*		4
540	416T2159-13		.RAMP		2
545	416T2284-9SP		.SEAL- (REPLD BY ITEM 545A)	A	2
-545A	416T2284-11SP		.SEAL- (REPLS ITEM 545)	A	2
-545B	416T2284-9SP		DELETED		
-545C	416T2284-11SP		.SEAL	B-D	2
550	416T2284-7SP		.SEAL		1
555	416T2290-1		.PIN-HINGE	A	1
560	NAS603-4		.SCREW		10
565	AN960C10L		.WASHER		10
570	BACR15BA4AD		.RIVET- (SIZE DETERMINE ON INST)	A	14
572	BACR15BA4AD		.RIVET- (SIZE DETERMINE ON INST)	B-D	15
575	416T2274-1		.CONNECTION-HINGE	A	2
577	416T2832-1		.CONNECTION-HINGE	B-D	1
580	416T2273-1		.HINGE HALF	A	2
585	NAS6703P5		.BOLT	A	6
590	NAS603-5		.SCREW	A	4
595	BACW10P43AL		.WASHER- (V10630) (SPEC BACW10P43AL)	A	10
600	416T2273-3		.HINGE HALF	A	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
01-601	416T2833-1		.HINGE ASSY ATTACHING PARTS	B-D	1
602	NAS6703P5		.BOLT	B-D	6
602G	NAS603-5		.SCREW	B-D	4
602P	BACW10P43AL		.WASHER- (V10630) (SPEC BACW10P43AL) -----*	B-D	10
603	MS20253P2-2990		..PIN	B-D	1
604	416T2833-2		..HINGE HALF	B-D	1
604G	416T2833-3		..HINGE HALF	B-D	1
604K	MS16562-1		..PIN-SPRING	B-D	2
605	NAS6703P4		.BOLT		2
610	BACW10P43AL		.WASHER- (V10630) (SPEC BACW10P43AL)		2
615	416T2248-4		.RETAINER ASSY-RUBSTRIP		1
620	74-13-210-24		..INSERT- (V94222)		8
625	416T2248-5		..RETAINER		1
630	416T2311-1		.BLOCK ASSY-SPRT		2
640	416T2243-22SP		.SHELL ASSY	A,B	1
R -640A	416T2243-34SP		.SHELL ASSY	C	1
R -640B	416T2243-39SP		.SHELL ASSY	D	1
645	NAS1836-3-07		..INSERT		41
650	416T2243-4		..SHELL ASSY- (OPT ITEM 650A)	A,B	1
-650A	416T2243-27		..SHELL ASSY- (OPT ITEM 650)	A,B	1
655	416T2243-23SP		.SHELL ASSY	A,B	1
R -655A	416T2243-35SP		.SHELL ASSY	C	1
R -655B	416T2243-38SP		.SHELL ASSY	D	1
660	NAS1836-3-07		..INSERT		52
R 662	SL618-3A		..INSERT- (V97393)	C,D	8
R 663	416T2191-2		..CHANNEL	C,D	4
665	416T2243-24		..SHELL ASSY- (OPT ITEM 665A)	A,B	1
-665A	416T2243-28		..SHELL ASSY- (OPT ITEM 665)	A,B	1
670	SL618-3A		...INSERT- (V97393)	A,B	8
675	416T2191-2		...CHANNEL	A,B	4

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