TO: ALL HOLDERS OF MID ENTRY/SERVICE DOOR HANDLE MECHANISM ASSEMBLY COMPONENT MAINTENANCE MANUAL 52-11-32

REVISION NO. 5 DATED NOV 01/03

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 to the Record of Revision Sheet.

CHAPTER/SECTION AND PAGE NO.	DESCRIPTION OF CHANGE
TITLE PAGE 1 702	Added the 143T6140-9, -10 top assemblies with new clutch assembly 143T6155-5.
TITLE PAGE 1 REPAIR-GEN 603 REPAIR 14-1 601-602 REPAIR 20-1 601-602 702	Added the 143T6140-15, -16 top assemblies with yellow lockout button 141T6538-10, and yellow handle assembly 141T6249-6.
301-305 501-503,505 REPAIR 2-1 601-602 REPAIR 9-1 601 REPAIR 13-1 601 REPAIR 23-1 601 REPAIR 25-1 601	Edited without technical change.

CHAPTER/SECTION AND PAGE NO.	DESCRIPTION OF CHANGE
REPAIR 28-1 601-602 702-705,707-719, 723,730-731, 735-738,741-742 802-804 1026-1028,1031,1034, 1036-1067,1072-1074, 1080-1080B	HIGHLIGHT CONTINUED FROM PREVIOUS PAGE
REPAIR 3-1 601-603 1002-1005,1007-1024, 1037-1067,1069, 1077-1079,1080A-1080B	Changed the repair instructions for the 141T6160-1, -5, -6 handle assemblies, and added optional handle details 141T6160-9, -10 and -11 in REPAIR 3-1.
REPAIR 5-1 601 1077-1079	Added optional material for lever 141T6193-3 in REPAIR 5-1.
REPAIR 22-1 601	Changed a bushing for sector assembly 141T6652-2 and removed the spotface instruction in REPAIR 22-1.
REPAIR 28-1 602-603	Changed REPAIR 28-1, Miscellaneous Parts Refinish, to add new parts and change other parts as necessary. Added Fig. 602 to REPAIR 28-1, which shows the part geometry and specified locations for the finish of the 143T6151-1, -3 housing.
702,723-731,735 801 1002-1005,1007-1024, 1030,1033,1037-1067, 1069-1071,1073-1074, 1077-1079,1080A-1080B	Changed the part orientation on the 141T6207-6 (672, IPL Fig. 1; IPL Fig. 3) lever assembly, to agree with engineering. Added a right-hand installation view of 141T6207-6 in IPL Fig. 1 and ASSEMBLY Fig. 707. Changed orientation of BACB30NR4K22 (674, 675, IPL Fig. 1; ASSEMBLY Fig. 707) bolts to agree with engineering.

CHAPTER/SECTION AND PAGE NO.	DESCRIPTION OF CHANGE
720-722 1032,1037-1067,1069, 1071,1073-1074, 1077-1079,1080A-1080B	Changed the location of the bushings (555, 558, IPL Fig. 1) and washers (540, 541, IPL Fig. 1), common to the bolts (537, IPL Fig. 1) and the sector assembly (438, IPL Fig. 1) to agree with engineering. Added a view to ASSEMBLY Fig. 706, that shows the location and quantity of the bushings and washers common to the bolts (537, IPL Fig. 1) and the sector assembly (438, IPL Fig. 1).

BOEING

COMPONENT
MAINTENANCE MANUAL

MID ENTRY/SERVICE DOOR HANDLE MECHANISM ASSEMBLY

PART NUMBERS 143T6140-3,-4,-7,-8,-9, -10,-15,-16

COMPONENT MAINTENANCE MANUAL
WITH
ILLUSTRATED PARTS LIST

304098

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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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
2. Record of Revisions
3. Temporary Revision & Service Bulletin Record
4. List of Effective Pages
5. Table of Contents
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.

MID ENTRY/SERVICE DOOR

HANDLE MECHANISM ASSEMBLY

DESCRIPTION AND OPERATION

1. Description

A. The door handle mechanism assembly consists of an inside handle assembly, external handle assembly, snubber, cam assembly, arming handle assembly, arming lever release system and warning flag arm all interconnected and mounted on a support assembly.

B. The inside handle assembly and external handle assembly are connected thru adjustable lug assemblies. The arming handle assembly connects to the arming lockout system thru a sector assembly and also connects to the cam assembly via a link assembly.

C. Two overcenter springs provide overcenter force while disarming the escape slide system from the exterior. Only one spring is used when operated from the interior.

2. Operation

A. The door handle mechanism provides a means to latch and unlatch the passenger/service door assembly. It also connects to the escape slide system which disarms the deployment of the slide during normal operation and deploys the slide in emergency situations.

B. During normal operation, the door is opened from inside the airplane as follows:

(1) The arming handle assembly is moved to the disarm position. This will disengage the escape slide system. The lever release button extends when the lever reaches the DISARMED position.

(2) The inside handle assembly is rotated upward to open the door. The external handle assembly should remain stowed during this operation.

C. During emergency operation, with the interior arm/disarm lever in the armed position, moving the inside handle assembly upward will open the door and deploy the escape slide.

D. Opening the door from the outside requires pushing the cam assembly inward which will disengage the escape slide system, then lifting the external handle assembly up to open the door.

E. The door may be latched from both inside or outside the airplane by moving either handle assembly to the closed position.

F. Arming the slide escape system can only be done from inside the airplane. To arm the system, push the lever release button and move the interior arm/disarm lever fully outboard.

G. An adjustable eccentric bushing located in the external handle assembly provides adjustment to reduce lost motion between inside and external handle assemblies.

H. To close the door using the external handle, a spring-loaded pin in the handle engages a hole in the external handle shaft.

3. Leading Particulars (approximate)

Height -- 30 inches
Width -- 15 inches
Depth -- 8 inches
Weight -- 35 pounds

DISASSEMBLY

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

1. Parts Replacement

NOTE: The following parts are recommended for replacement. Unless otherwise noted, actual replacement of parts may be based on in-service experience.

A. Cotter pin (471, 665J, IPL Fig. 1)

2. Disassembly of Handle Mechanism Assembly (IPL Fig. 1)

WARNING: RESTRAIN INSIDE AND OUTSIDE HANDLE ASSEMBLY (141 AND 945A) TO PREVENT PERSONNEL INJURY FROM INADVERTENT HANDLE TRAVEL.

A. Remove parts (78 thru 87) and bushings (120, 123) and remove snubber assembly (75).

NOTE: Refer to CMM 52-11-82 for details of snubber assembly (75).

B. Disconnect and remove handle assembly (141) and shaft assembly (174).

(1) Remove parts (6A thru 15) and separate lug assembly (30) from shaft assembly (174).

(2) Remove parts (18 thru 27) and separate lug assembly (57) from shaft assembly (924A).

(3) Remove bolts (42, 48), washers (45, 51, 54) and separate lug assemblies (30, 57).

NOTE: Do not disassemble lug assemblies (30, 57) unless necessary for repair or replacement.

(4) Remove bolt (96), washer (99) and remove adapter assembly (90) from shaft assembly (174).

NOTE: Do not disassemble adapter assembly (90) unless necessary for repair or replacement.

(5) For handle assemblies without clutch mechanism –

(a) Loosen nuts (138, 156). Back off screw (165) and remove adapter (171C). Remove screw (165), washer (168) and nut (171) from adapter (171C). Remove parts (132, 135, 138, 150, 153, 156) and remove handle assembly (141) and spacer (159).

NOTE: Do not disassemble handle assembly (141) unless necessary for repair or replacement.

(6) For handle assemblies with clutch mechanism (IPL Fig. 1 and 6) –

(a) Loosen nuts (148U, 156). Back off screw (160C) and remove bearings (159N), spacer (149), clutch assembly (148), and adapter (160J). Remove screw (160C), washer (160E) and nut (160G) from adapter (160J). Remove parts (150, 153, 156) and remove handle assembly (141B, 142A) and spacer (159).

(b) Disassemble handle assembly (141B, 142A, IPL Fig. 1; 1, 5, IPL Fig. 6) by removing pins (45, 50, IPL Fig. 6), spring (80, IPL Fig. 6), washers (75, IPL Fig. 6), and pawl assembly (55A, IPL Fig. 6).

NOTE: Do not disassemble handle assembly (141B, 142A, IPL Fig. 1; 1, 5, IPL Fig. 6) unless repair or replacement is necessary.

(7) Remove shaft assembly (174), bearings (186), washers (177, 180) and spring washer (183) from support assembly (984).

NOTE: Do not disassemble shaft assembly (174) unless necessary for repair or replacement.

C. Remove lever assembly (201A).

(1) Remove parts (189 thru 198) and disconnect lever assembly (201A) from link assembly (246).

(2) Remove parts (225 thru 231) and remove lever assembly (201A) from support assembly (984).

NOTE: Do not disassemble lever assembly (201A) unless necessary for repair or replacement.

D. Remove parts (234 thru 243) and remove link assembly (246).

E. Remove parts (258 thru 285) and remove link assembly (288).

F. Remove parts (300 thru 306) and remove lever assembly (309) from shaft (456).

G. Carefully remove parts (321 thru 330). Remove housing assembly (333), spring (342) and washers (345).

NOTE: Do not disassemble housing assembly (333) unless necessary for repair or replacement.

H. Remove parts (348 thru 357) and remove piston assembly (360) from sector assembly (438).

NOTE: Do not disassemble piston assembly (360) unless necessary for repair or replacement.

I. Remove ring (369), screw (372), spacer (375) and remove handle assembly (378) and lever assembly (387). Remove nut (390) and retainer (393) from lever (396).

NOTE: Do not disassemble handle assembly (378) unless necessary for repair or replacement.

J. Remove parts (399 thru 405) and remove adapter (408).

K. Remove parts (411 thru 417).

L. Remove bolt (432), washer (435).

M. Remove shaft (456), lever assembly (420) and sector assembly (438). Remove washers (459), spring washer (465) and bearings (468) from support assembly (984). Remove nut (441) and retainer (444) from sector (453).

N. Remove cotter pin (471), washers (474, 480), pin (477), spacers (483), spring (486) and lever assembly (489). Remove screw (516), spacer (519), washer (522) and button (525).

O. Remove setscrews (528) from support assembly (531).

P. Remove parts (537 thru 543, 555, 556, 558) and separate support assembly (531) from handle support assembly (984).

Q. Shaft (723A) removal.

WARNING: SPRING (585) IS PRELOADED. USE EXTREME CARE DURING REMOVAL OR INJURY TO PERSONNEL MAY RESULT.

(1) Remove nut (570), washer (564) and carefully free guide assembly (573) from bolt (561). Remove guide assembly (573) and spring (585). Remove bolt (561) and washer (567).

NOTE: Do not disassemble guide assembly (573) unless necessary for repair or replacement.

(2) Remove parts (588 thru 597) and remove guide assembly (600) from lever assembly (624).

NOTE: Do not disassemble guide assembly (600) unless necessary for repair or replacement.

(3) Remove parts (615 thru 621) and remove lever assembly (624). Remove bearing (720) and washers (714) from lever assembly (624).

NOTE: Do not disassemble lever assembly (624) unless necessary for repair or replacement.

(4) Remove nut (666C), washer (669) and lever assembly (672). Remove parts (675 thru 690) from lever assembly (672).

(5) Push cam assembly (645) inward to release handle assembly (945A). Move handle assembly (945A) up to expose cam assembly (645). Rotate cam assembly as required to gain access to bolt (636), washer (639), and nut (642). Remove parts (636 thru 642).

(6) Remove shaft (723A), cam assembly (645), crank (693), spacers (705 thru 711), washers (714), spring washer (717) and bearing (720) from support assembly (984).

(7) Remove parts (696 thru 702) from crank (693).

R. Remove parts (732A thru 747, 762, 765) and stop assembly (726, 729).

S. Remove shaft assembly (924A) and handle assembly (945A).

(1) Remove nut (879), washers (882, 885).

(2) Remove bolts (888), washers (891), retainer (894) and shim (897).

(3) With handle assembly (945A) in the open position, remove bolts (840), washers (843) and slide retainer (846) and spring (861) down. Remove pin (849).

(4) Remove bolt (825), bushings (831) and nut (828). Remove rod end assembly (870) with attached parts.

(5) Carefully remove shaft assembly (924A) and separate handle assembly (945A) from support assembly (984).

(6) Remove bearings (900, 921), washers (903, 909, 918), spacer (906), packing (912) and ring (915).

T. Remove bolt (768), washer (771), nut (774), roller assembly (780) and bushing (777) from support (801).

U. Remove bolts (789), washers (792), nuts (795), shim (798) and support (801) from handle assembly (945A).

V. Loosen nut (864) and remove shaft (858) and washer (867). Remove nut (864), retainer (846), and spring (861). Remove retainer (852), bushing (855) from handle assembly (945A).

NOTE: Note position of bushing (855) and retainer (852) to aid assembly.

W. Remove bolt (804), washer (807) and nut (810) and remove roller assembly (816) and bushing (813).

CAUTION: LEVERS (834A, 837A) ARE A MATCHED SET AND MUST BE KEPT TOGETHER WITH THE CLIP (833) TO MAKE SURE OF PROPER OPERATION AFTER ASSEMBLY. CLIP (833) IS INSTALLED WITH THE MATCHED SET OF 141T6280-1 (834A) AND 141T6280-2 (837A) LEVERS ONLY TO PREVENT BACKWARDS INSTALLATION OF THE LEVERS DURING ASSEMBLY.

LEVERS (834A, 837B) ARE A MATCHED SET AND MUST BE KEPT TOGETHER TO MAKE SURE OF PROPER OPERATION AFTER ASSEMBLY.

LEVERS (832B, 837L) ARE A MATCHED SET AND MUST BE KEPT TOGETHER WITH THE CLIP (831U) TO MAKE SURE OF PROPER OPERATION AFTER ASSEMBLY. CLIP (831U) IS INSTALLED WITH THE MATCHED SET OF 141T6280-1 (832B) AND 141T6280-2 (832L) LEVERS ONLY TO PREVENT BACKWARDS INSTALLATION OF THE LEVERS DURING ASSEMBLY.

LEVERS (832B, 832M) ARE A MATCHED SET AND MUST BE KEPT TOGETHER TO MAKE SURE OF PROPER OPERATION AFTER ASSEMBLY.

X. Separate levers (832B, 832L, 832M, 834A, 837A, 837B) and remove clip (831U, 833) and rod end assembly (870). Keep levers (832B, 832L, 832M, 834A, 837A, 837B) together as a matched set.

NOTE: Do not disassemble rod end assembly (870) unless necessary for repair or replacement.

Y. Remove parts (951 thru 981) from support assembly (984) as required.

NOTE: Note quantity of washers (956) for reference during assembly.

Do not disassemble support assembly (984) unless necessary for repair or replacement.

CLEANING

1. Clean all parts except sealed bearings using standard industry practices and information contained in 20-30-03.

2. Clean sealed bearings according to manufacturer's instructions.

CHECK

1. Check all parts for obvious defects in accordance with standard industry practices. Refer to Fits and Clearances for design dimensions.

2. Magnetic particle check per 20-20-01 the following listed parts.

   A. IPL Fig. 1

      (1) Lugs (39, 72)

      (2) Adapter (114, 117, 160J, 171C, 408)

      (3) Clutch (148V, 148X, 148Y)

      (4) Fitting (148W)

      (5) Levers (318, 396, 429, 633, 832B, 832L, 834A, 837A)

      (6) Spacer (149, 159, 159A, 906)

      (7) Spring (342, 486, 861, 961)

      (8) Handle (384)

      (9) Sector (453)

      (10) Shafts (456, 457, 723A, 858, 936A, 939A)

      (11) Cam (660, 663)

      (12) Crank (693)

      (13) Stop (756, 759)

      (14) Bushing (777)

      (15) Rollers (786, 822)

      (16) Support (801)

(17) Pin (849)

(18) Rod end (876)

(19) Bracket (983)

B. IPL Fig. 2

(1) Housing (45)

(2) Shaft (50)

C. IPL Fig. 6

(1) Pin (50)

(2) Pawl (70A)

3. Penetrant check per 20-20-02 the following listed parts.

A. IPL Fig. 1

(1) Handle (147)

(2) Levers (219, 222A)

(3) Links (255, 297)

(4) Housings (339, 612)

(5) Piston (366)

(6) Support (549, 552)

(7) Guide (582)

(8) Base (960)

(9) Pawl (962, 963)

B. IPL Fig. 3

(1) Lever (30)

C. IPL Fig. 4

(1) Cap (50)

(2) Handle (55A, 60A)

D. IPL Fig. 5

(1) Bracket (55)

(2) Terminal (135, 140)

(3) Support (160, 165)

E. IPL Fig. 6

(1) Handle (25, 30)

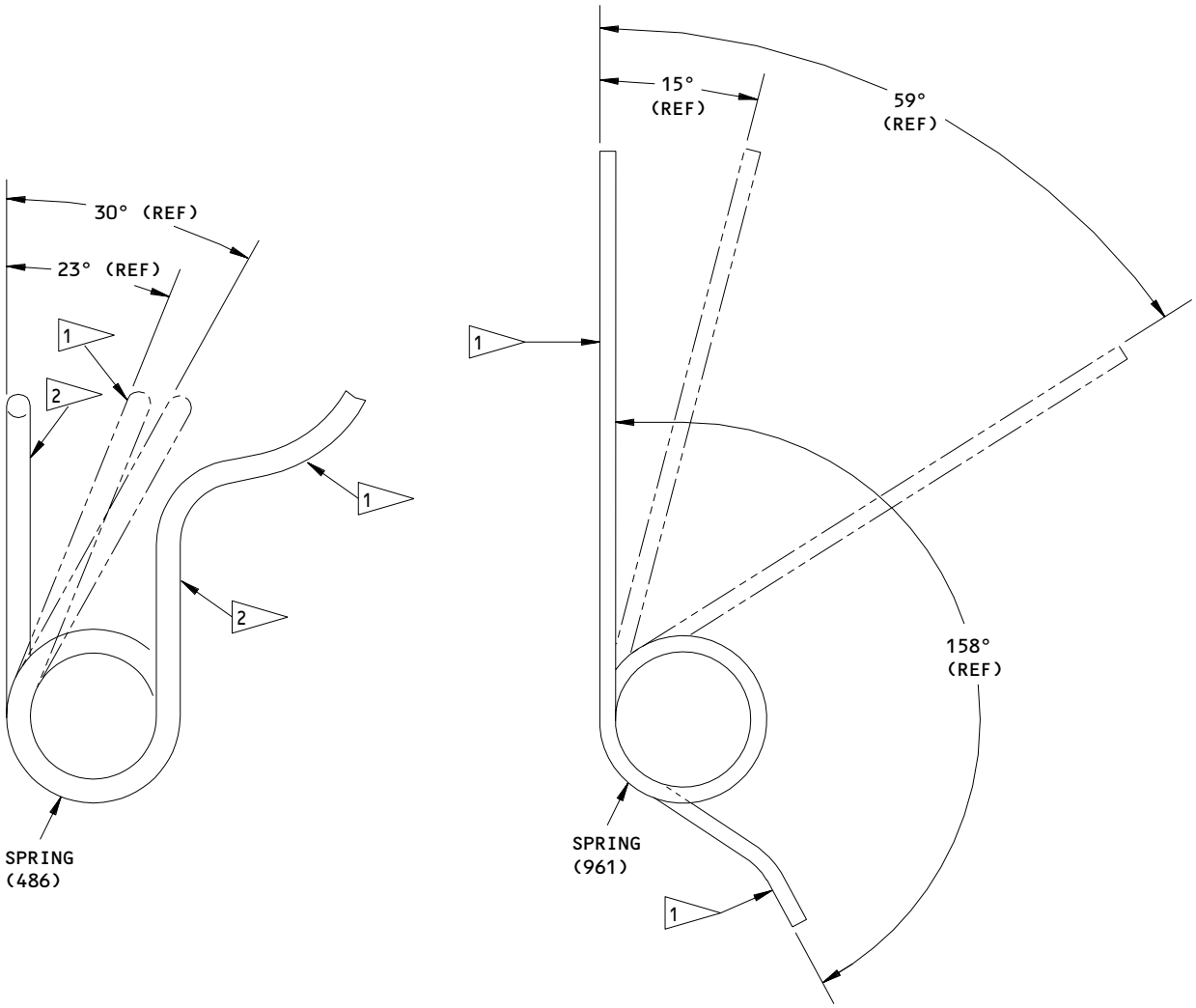
(2) Housing (85)

4. Check spring (861, IPL Fig. 1).

A. Compress spring to 0.79 inch. Check that load is 10.4-12.8 lbs.

B. Compress spring to 1.06 inch. Check that load is 5.1-6.3 lbs.

5. Check springs (486, 961) per Fig. 501.



ITEM NUMBER	TEST DEFLECTION (DEGREES)	ALLOWABLE MOMENT (POUND-INCHES)
486	23 30	8.44-10.32 11.12-13.36
961	15 59	0.135-0.165 0.567-0.693

1 POINT AND DIRECTION OF LOAD APPLICATION

2 AT REFERENCE POSITION, SPRING ARMS ARE PARALLEL

ITEM NUMBERS REFER TO IPL FIG. 1

Spring Check
Figure 501

REPAIR - GENERAL

1. Content

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

P/N	NAME	REPAIR
141T6133	SUPPORT, HANDLE	1-1
141T6159	HANDLE, EXTERNAL	2-1
141T6160	HANDLE, INSIDE LATCH	3-1
141T6188	STOP	4-1
141T6193	LEVER, FLAG DRIVE	5-1
141T6195	CAM	6-1
141T6196 141T6197	LUG	7-1
141T6200	CAM	8-1
141T6205	LEVER, OVERCENTER SPRING	9-1
141T6207	LEVER, CARRIER DRIVE	10-1
141T6221	SHAFT, PIVOT	11-1
141T6226	BUSHING, ADJUSTABLE	12-1
141T6228	SHAFT, PIVOT	13-1
141T6249	HANDLE	14-1
141T6271	LEVER, ARMING FLAG	15-1

P/N	NAME	REPAIR
141T6274	GUIDE, SPRING	16-1
141T6277	LINK	17-1
141T6287-3, -4	ROLLER	18-1
141T6287-5	ROD END	19-1
141T6538	BUTTON	20-1
141T6651	LEVER, LOCKOUT	21-1
141T6652	SECTOR, LOCKOUT	22-1
143T6141	FITTING, LOWER TERMINAL	23-1
143T6142	LEVER, GIRT DRIVE	24-1
143T6143	ADAPTER	25-1
69B13060	PISTON	26-1
69B13067	HOUSING	27-1
---	MISC. PARTS REFINISH	28-1
143T6156	CAM BRACKET	29-1

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 Finishes
20-30-03 General Cleaning Procedures
20-41-01 Decoding Table for Boeing Finish Codes
20-41-02 Application of Chemical and Solvent Resistant Finishes
20-42-03 Hard Chrome Plating
20-42-05 Bright Cadmium Plating
20-43-01 Chromic Acid Anodizing
20-43-03 Alodizing
20-44-01 Application of Special Purpose Coatings and Finishes
20-50-01 Bolt and Nut Installation
20-50-03 Bearing Installation and Retention
20-50-05 Application of Aluminum Foil and Other Markers
20-50-06 Installation of O-Rings and Teflon Seals
20-50-07 Lubrication
20-50-08 Application of Bonded Solid Film Lubricant

3. Materials

NOTE: Equivalent substitutes may be used.

A. Coating, abrasion-resistant teflon -- BMS 10-86, Type 1 (Ref 20-44-01, type 27)

B. Coating, Corona suppressive - Type 31 (Ref 20-44-01)

C. Compound, potting -- BMS 5-28, Type 5 (Ref 20-60-04)
-- BMS 5-28, Type 6 (Ref 20-60-04)

D. Enamel -- (Ref 20-60-02)
-- BMS 10-11, Type 2 Gloss, BAC702 white
-- BMS 10-60, Type 2 Gloss, BAC101 red
-- BMS 10-60, Type 2 Gloss, BAC702 white
-- BMS 10-60, Type 2 Gloss, BAC707 grey
-- BMS 10-78, clear baking
-- BMS 10-83, Type 2, BAC101 red
-- BMS 10-83, Type 2, BAC4533 green
-- BMS 10-83, Type 2, BAC302 yellow

E. Grease (Ref 20-60-03)
-- BMS 3-24
-- MIL-G-23827

F. Lubricant
-- BMS 3-8 (Ref 20-60-03)
-- Vitrolube 1220 (Ref 20-60-04)

G. Primer (Ref 20-60-02)
-- BMS 10-11, Type 1
-- BMS 10-79, Type 2

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

I. Coating, colored chemical (Ref 20-43-03)

4. Dimensioning Symbols

A. Standard True Position Dimensioning Symbols used in applicable repair procedures are shown in Fig. 601.

—	STRAIGHTNESS
▱	FLATNESS
⊥	PERPENDICULARITY (OR SQUARENESS)
//	PARALLELISM
○	ROUNDNESS
⌭	CYLINDRICITY
⌒	PROFILE OF A LINE
⌓	PROFILE OF A SURFACE
◎	CONCENTRICITY
⌯	SYMMETRY
∠	ANGULARITY
↗	RUNOUT
⌖	THEORETICAL EXACT POSITION OF A FEATURE (TRUE POSITION)
∅	DIAMETER
BASIC (BSC) OR [DIM]	A THEORETICALLY EXACT DIMENSION USED TO DESCRIBE SIZE, SHAPE OR LOCATION OF A FEATURE FROM WHICH PERMISSIBLE VARIATIONS ARE ESTABLISHED BY TOLERANCES ON OTHER DIMENSIONS OR NOTES.
[-A-]	DATUM
Ⓜ	MAXIMUM MATERIAL CONDITION (MMC)
Ⓢ	REGARDLESS OF FEATURE SIZE (RFS)
Ⓟ	PROJECTED TOLERANCE ZONE

EXAMPLES

[— | 0.002]	STRAIGHT WITHIN 0.002
[⊥ | B | 0.002]	PERPENDICULAR TO B WITHIN 0.002
[// | A | 0.002]	PARALLEL TO A WITHIN 0.002
[○ | 0.002]	ROUND WITHIN 0.002
[⌭ | 0.010]	CYLINDRICAL SURFACE MUST LIE BETWEEN TWO CONCENTRIC CYLINDERS, ONE OF WHICH HAS A RADIUS 0.010 INCH GREATER THAN THE OTHER
[⌒ | A | 0.006]	EACH LINE ELEMENT OF THE SURFACE AT ANY CROSS SECTION MUST LIE BETWEEN TWO PROFILE BOUNDARIES 0.006 INCH APART IN RELATION TO DATUM PLANE A
[⌓ | A | 0.020]	SURFACES MUST LIE WITHIN PARALLEL BOUNDARIES 0.02 INCH APART AND EQUALLY DISPOSED ABOUT TRUE PROFILE
[◎ | C | ∅ 0.0005]	CONCENTRIC TO C WITHIN 0.0005 DIAMETER (FULL INDICATOR MOVEMENT)
[⌯ | A | 0.010]	SYMMETRICAL WITH A WITHIN 0.010
[∠ | A | 0.005]	ANGULAR TOLERANCE 0.005 WITH A
[⌖ | B | ∅ 0.002 Ⓢ]	LOCATED AT TRUE POSITION WITHIN 0.002 DIA IN RELATION TO DATUM B, REGARDLESS OF FEATURE SIZE
[⊥ | A | ∅ 0.010 Ⓜ] [0.510 Ⓟ]	AXIS IS TOTALLY WITHIN A CYLINDER OF 0.010-INCH DIAMETER, PERPENDICULAR TO, AND EXTENDING 0.510-INCH ABOVE, DATUM A, MAXIMUM MATERIAL CONDITION
[2.000] OR 2.000 BSC	EXACT DIMENSION IS 2.000

True Position Dimensioning Symbols
Figure 601

HANDLE SUPPORT ASSEMBLY - REPAIR 1-1

141T6133-75, -76, -85, -86

NOTE: Refer to REPAIR-GEN for list of applicable standard practices. For repair of surfaces which may only require restoration of original finish, refer to Refinish instructions, Fig. 601.

Item numbers refer to IPL Fig. 5

1. Bushing (65 thru 95) Replacement

   A. Remove bushings.

   B. Install replacement bushings per 20-50-03 except use sealant, BMS 5-95.

   C. Fillet seal bushings with sealant.

2. Bracket Assembly (30) Replacement

   A. Remove bolts (35), collars (40) and bracket assembly (30).

   B. Install bracket assembly (30) with sealant and secure with bolts (35) and collars (40).

3. Nutplates (15, 20, 25) Replacement

   A. Remove rivets (10) and damaged nutplates.

   B. Install nutplates with sealant and secure with rivets (10).

4. Seals (145, 150, 155) Replacement

   A. Remove sealant and remove damaged seals.

   B. Install replacement seals with sealant and fillet seal. After fillet seal, verify that seals are not contaminated.

5. Fitting Assembly (100 or 105) Replacement

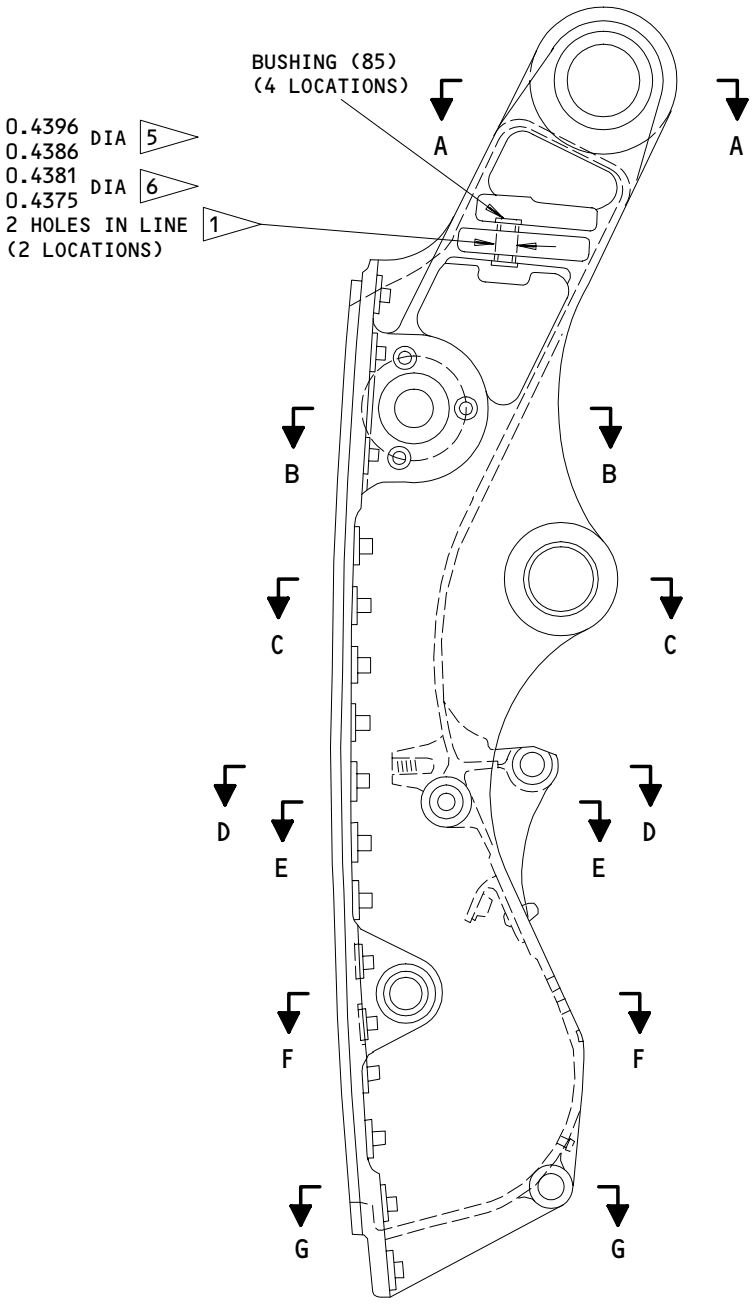
   A. Remove bushing (95).

   B. Remove bolts (110), washers (115), nuts (120), and fitting assembly (100 or 105).

C. Install fitting assembly (100 or 105) with sealant. Secure with bolts (110), washers (115), and nuts (120).

D. Install bushing (95) per 20-50-03 except use sealant.

E. Fillet seal bushing with sealant.

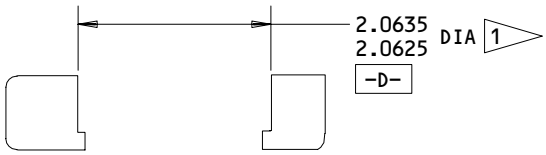


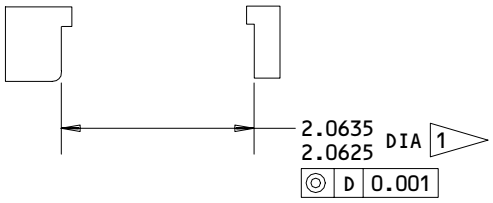
ITEM NUMBERS REFER TO IPL FIG. 5

ALL DIMENSIONS ARE IN INCHES

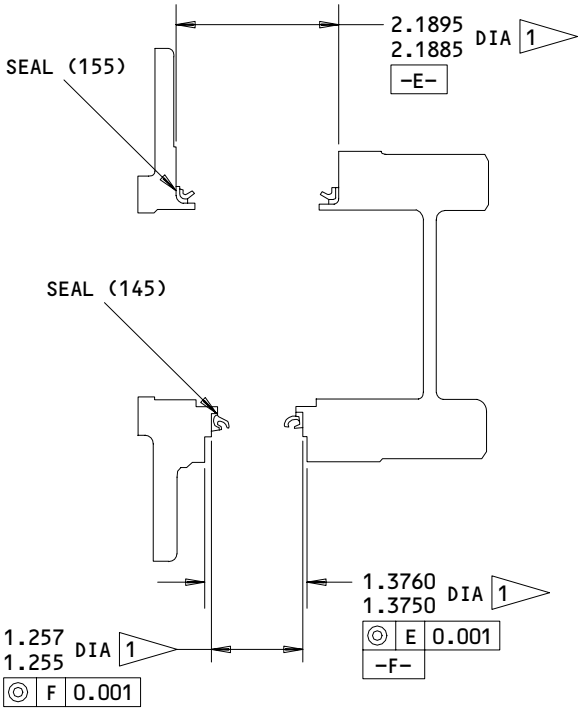
141T6133-75,-76,-85,-86
(FITTING ASSEMBLY (100) OMITTED FOR CLARITY)

Support Repair and Refinish
Figure 601 (Sheet 1)

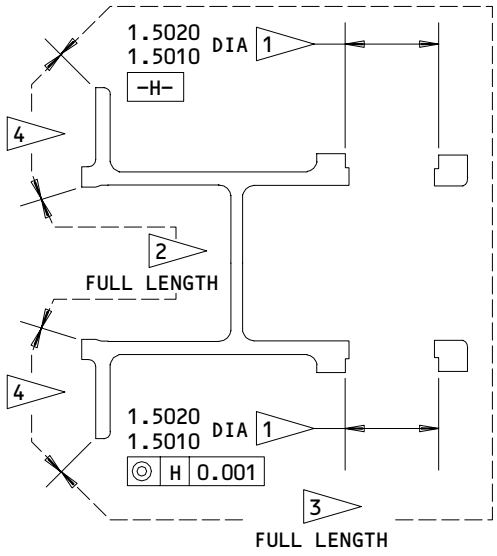




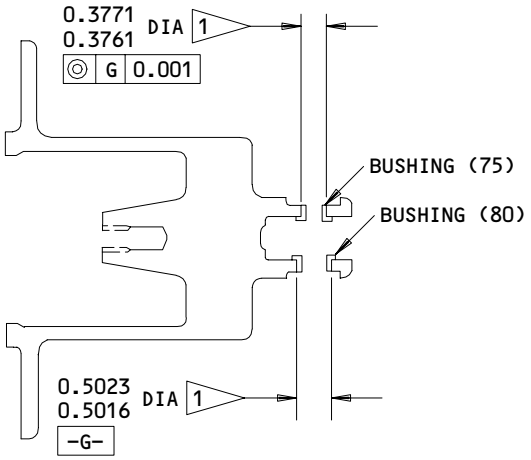
A-A



B-B



C-C



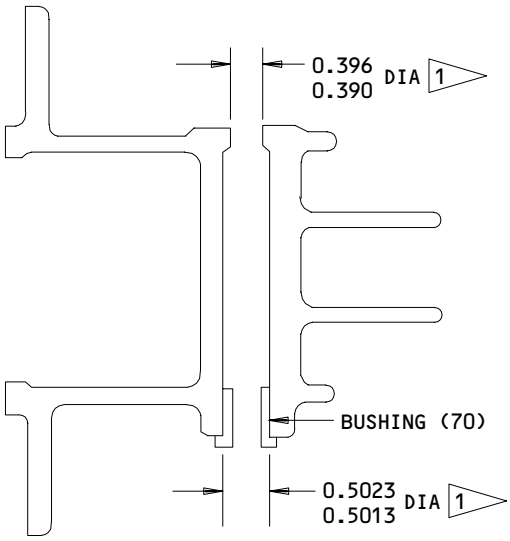
D-D

ITEM NUMBERS REFER TO IPL FIG. 5

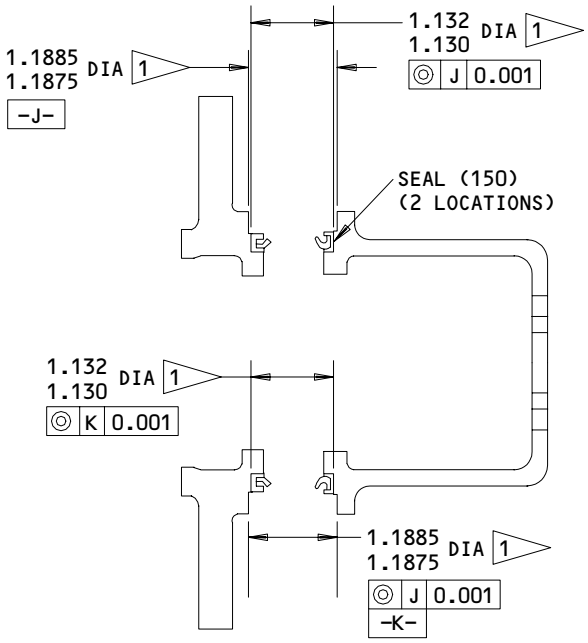
ALL DIMENSIONS ARE IN INCHES

141T6133-75,-76,-85,-86

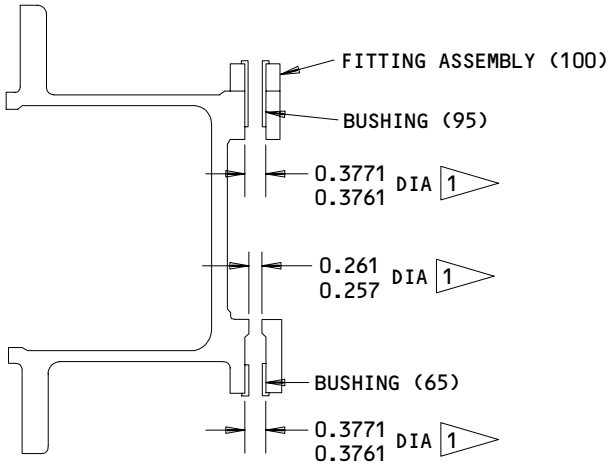
Support Repair and Refinish
Figure 601 (Sheet 2)



E-E



F-F



G-G

REFINISH

ANODIZE (F-17.05) ALL OVER AND APPLY 1 COAT OF PRIMER, BMS 10-79, TYPE 2 (F-19.46) EXCEPT AS NOTED BY 1

APPLY ENAMEL PER 2 3 4

1 OMIT PRIMER AND ENAMEL THESE SURFACES AND OMIT ENAMEL IN FASTENER HOLES

2 APPLY BMS 10-60, TYPE 2 GLOSS ENAMEL, BAC702 WHITE (F-19.39-702)

3 APPLY 1 COAT OF BMS 10-11, TYPE 2 GLOSS ENAMEL, BAC702 WHITE (SRF-14.905-702)

ITEM NUMBERS REFER TO IPL FIG. 5

MATERIAL: AL ALLOY

ALL DIMENSIONS ARE IN INCHES

4 APPLY BMS 10-60, TYPE 2 GLOSS ENAMEL, BAC707 GRAY (F-19.39-707)

5 141T6133-75,-76

6 141T6133-85,-86

141T6133-75,-76,-85,-86

Support Repair and Refinish
Figure 601 (Sheet 3)

EXTERNAL HANDLE ASSEMBLY - REPAIR 2-1

141T6159-11, -12

NOTE: Refer to REPAIR-GEN for list of applicable standard practices. For repair of surfaces which may only require restoration of original finish, refer to Refinish instructions, Fig. 601.

Item numbers refer to IPL Fig. 4.

1. Bushings (30, 45) Replacement (Fig. 601)

   A. Remove bushings.

   B. Install replacement bushing per 20-50-03 except use wet sealant, BMS 5-95.

   C. Machine bushing (30) to 0.01 inch maximum from bearing bore in handle (Fig. 601).

   D. Fillet seal bushings with sealant.

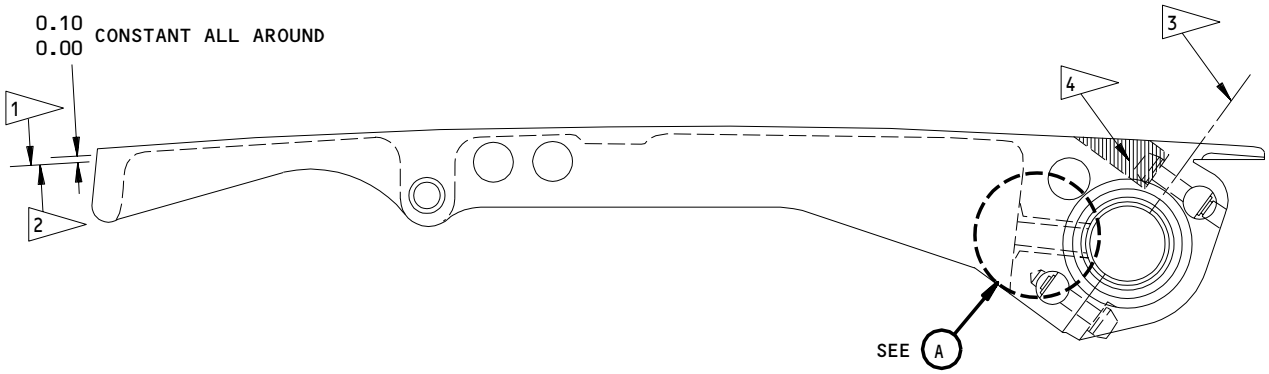
2. Bearings (40) Replacement

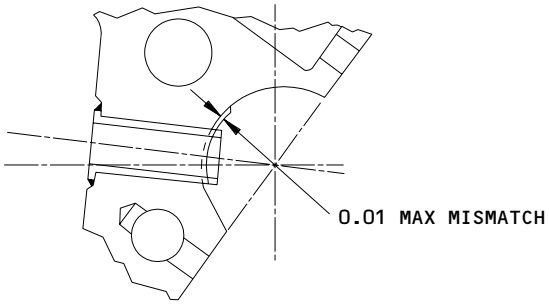
   A. Remove potting compound and remove bolts (10), washers (15) and cap (50). Remove bearings (40). Use care not to damage handle (55A, 60A) when removing potting compound.

   B. Refinish areas as required and reapply potting compound (Fig. 601).

   C. Apply light coat of grease, BMS 3-24 or MIL-G-23827 to all faying surfaces including outer face of bearings (40). Wipe off grease with dry cloth.

   D. Assemble bearings (40) and cap (50) with sealant, BMS 5-95 and secure cap with bolts (10) and washers (15).





A

REFINISH

CAP (50) AND HANDLE (55A,60A) -- CHROMIC ACID ANODIZE (F-17.04) AND APPLY 1 COAT OF BMS 10-79, TYPE 2 PRIMER (F-19.46). APPLY ENAMEL AS INDICATED PER 1 2 . OMIT PRIMER AND ENAMEL IN REAMED OR BORED HOLES. APPLY PRIMER PRIOR TO BUSHING MACHINING. CHEMICAL TREAT (F-17.10) MACHINED SURFACES AS REQUIRED AFTER BUSHING MACHINING

1 APPLY 1 COAT OF GLOSS ENAMEL, BMS 10-60, TYPE 2, BAC707 GRAY (F-19.34-707) THIS SIDE.

2 APPLY 1 COAT OF GLOSS ENAMEL, BMS 10-60, TYPE 2, BAC702 WHITE (F-19.39-702) THIS SIDE AND ON INTERIOR SURFACES.

3 CHEMICAL TREAT AND APPLY 2 COATS OF PRIMER BMS 10-11, TYPE 1 (F-18.03) THIS THIS SURFACE ON BOTH PARTS PRIOR TO BUSHING MACHINING

4 PRIOR TO PAINTING, FILL CAVITY WITH POTTING COMPOUND, BMS 5-28, TYPE 5, FINISH 250AA OR BETTER FLUSH WITH HANDLE HANDLE SURFACE. CHEMICAL TREAT (F-17.10) AS REQUIRED.

MATERIAL: AL ALLOY

ITEM NUMBERS REFER TO IPL FIG. 4

ALL DIMENSIONS ARE IN INCHES

141T6159-11,-12
Parts Replacement and Handle Refinish
Figure 601

INSIDE LATCH HANDLE ASSEMBLY - REPAIR 3-1

141T6160-1, -5, -6

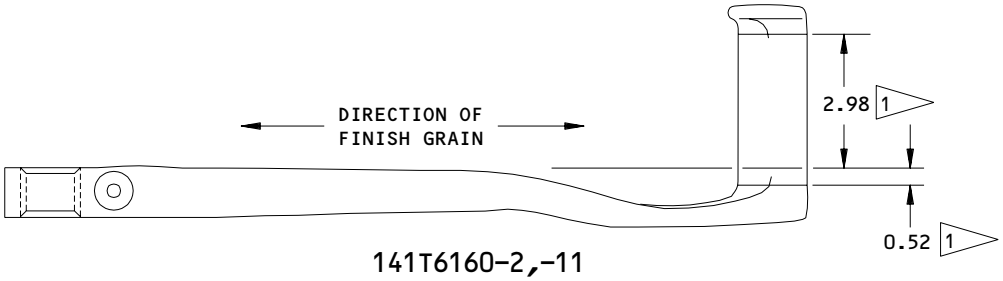
NOTE: Refer to REPAIR - GENERAL for a list of applicable standard practices. For repair of surfaces which may only require restoration of original finish, refer to Refinish instructions, Fig. 601 or Fig. 602, as applicable.

Item numbers refer to IPL Fig. 1 or IPL Fig. 6, as applicable.

1. Filler (144, IPL Fig. 1 and 35, IPL Fig. 6) Replacement

   A. Remove potting compound and filler (144, IPL Fig. 1 and 35, IPL Fig. 6) from the handle (147, IPL Fig. 1 and 25, 30, IPL Fig. 6).

   B. For the handle assembly 141T6160-1 (141, IPL Fig. 1), install the replacement filler (144, IPL Fig. 1) with potting compound, BMS 5-28, Type 5, as specified in BAC5432. For the handle assembly 141T6160-5 (15A, IPL Fig. 6) or 141T6160-6 (20A, IPL Fig. 6), install the replacement filler (35, IPL Fig. 6) with potting compound, BMS 5-28, Type 6, as specified in BAC5432. Fill the cavity with potting compound, full to the end, and trim flush to the handle to +0.00/-0.10 inch.



141T6160-2,-11

REFINISH

CHROMIC ACID ANODIZE (F-17.04) IN THE HOLE, SLOT AND SPLINE OF THE HANDLE (147).

APPLY SATIN FINISH WITH GRAIN DIRECTION AS SHOWN, AND APPLY TYPE 11 CLEAR COATING (F-14.231) ON ALL OF THE OUTER SURFACES OF THE HANDLE (147) AS SHOWN. DO NOT APPLY SATIN FINISH OR CLEAR COATING IN THE HOLES, SLOT, SPLINE, OR ON THE SURFACES SPECIFIED BY 1.

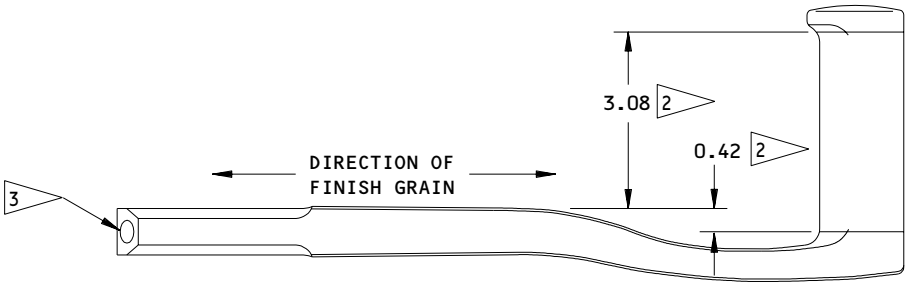
1 CHEMICAL TREAT AND APPLY BMS 10-11, TYPE 1 PRIMER (F-18.01), AND APPLY BMS 10-83, TYPE 2 ENAMEL, COLOR BAC101 RED (F-22.06-101) ON THE HANDLE GRIP AREA AS SHOWN

MATERIAL: AL ALLOY

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

141T6160-2,-11
Handle Refinish
Figure 601



141T6160-7,-9 SHOWN
141T6160-8,-10 OPPOSITE

REFINISH

APPLY SATIN FINISH WITH GRAIN DIRECTION AS SHOWN, AND APPLY TYPE 11 CLEAR COATING (F-14.231) ON ALL OF THE OUTER SURFACES OF THE HANDLE (25,30) AS SHOWN. DO NOT APPLY SATIN FINISH OR CLEAR COATING IN THE HOLES, OR ON THE SURFACES SPECIFIED BY 2 AND 3 .

2 CHEMICAL TREAT AND APPLY BMS 10-11, TYPE 1 PRIMER (F-18.01), AND APPLY BMS 10-83, TYPE 2 ENAMEL, COLOR BAC101 RED (F-22.06-101) ON THE HANDLE GRIP AREA AS SHOWN

3 CHEMICAL TREAT (F-17.10) IN THE HOLE AS SHOWN

MATERIAL: AL ALLOY

ITEM NUMBERS REFER TO IPL FIG. 6

ALL DIMENSIONS ARE IN INCHES

141T6160-7 thru -10
Handle Refinish
Figure 602

W39114

STOP ASSEMBLY - REPAIR 4-1

141T6188-5, -6

NOTE: Refer to REPAIR-GEN for list of applicable standard practices. For repair of surfaces which may only require restoration of original finish, refer to Refinish instructions.

Item numbers refer to IPL Fig. 1.

1. Bearing (753) Replacement

   A. Remove bearing (753) and ring (750).

   B. Install replacement bearing and ring per 20-50-03 except use wet sealant, BMS 5-95.

   C. Roller swage ring per 20-50-03.

   D. Check that maximum gap in ring is 0.062 inch and fill gap with sealant, BMS 5-95.

2. Refinish

   A. Stop (756 or 759) -- Passivate (F-17.09) all over. Material: 17-4PH CRES, 150 ksi min.

FLAG DRIVE LEVER ASSEMBLY - REPAIR 5-1

141T6193-1

NOTE: Refer to REPAIR-GEN for list of applicable standard practices. For repair of surfaces which may only require restoration of original finish, refer to Refinish instructions, Fig. 601.

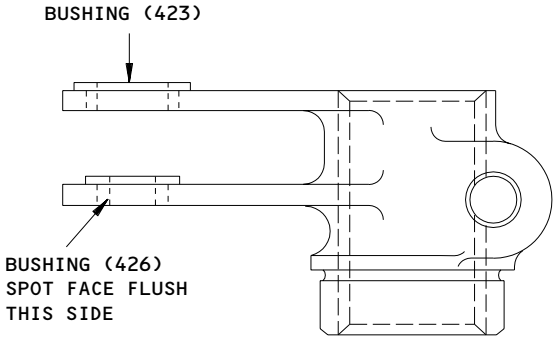
Item numbers refer to IPL Fig. 1.

1. Bushing Replacement (Fig. 601)

   A. Remove bushings.

   B. Install replacement bushings per 20-50-03 except use wet sealant, BMS 5-95.

   C. Spot face bushing flush as indicated.



REFINISH

LEVER (429) -- PASSIVATE (F-17.25, WHICH REPLACES F-17.09).

MATERIAL: 17-4PH CRES, 150 KSI MIN
(OPT 15-5PH CRES, 150-170 KSI

ITEM NUMBERS REFER TO IPL FIG. 1

Bushing Replacement and Lever Refinish
Figure 601

304106

CAM ASSEMBLY - REPAIR 6-1

141T6195-1, -2

NOTE: Refer to REPAIR-GEN for list of applicable standard practices. For repair of surfaces which may only require restoration of original finish, refer to Refinish instructions, Fig. 601.

Item numbers refer to IPL Fig. 1.

1. Parts Replacement (Fig. 601)

   A. Remove rivets (651) and separate lever (654), shim (657) and cam (660 or 663).

   B. Position parts (654 thru 660) as shown. If a replacement cam (660 or 663), lever (654) or shim (657) is being installed, drill 0.159-0.167 dia. rivet holes at locations shown. Adjust shim thickness as required by delamination to obtain dimensions indicated.

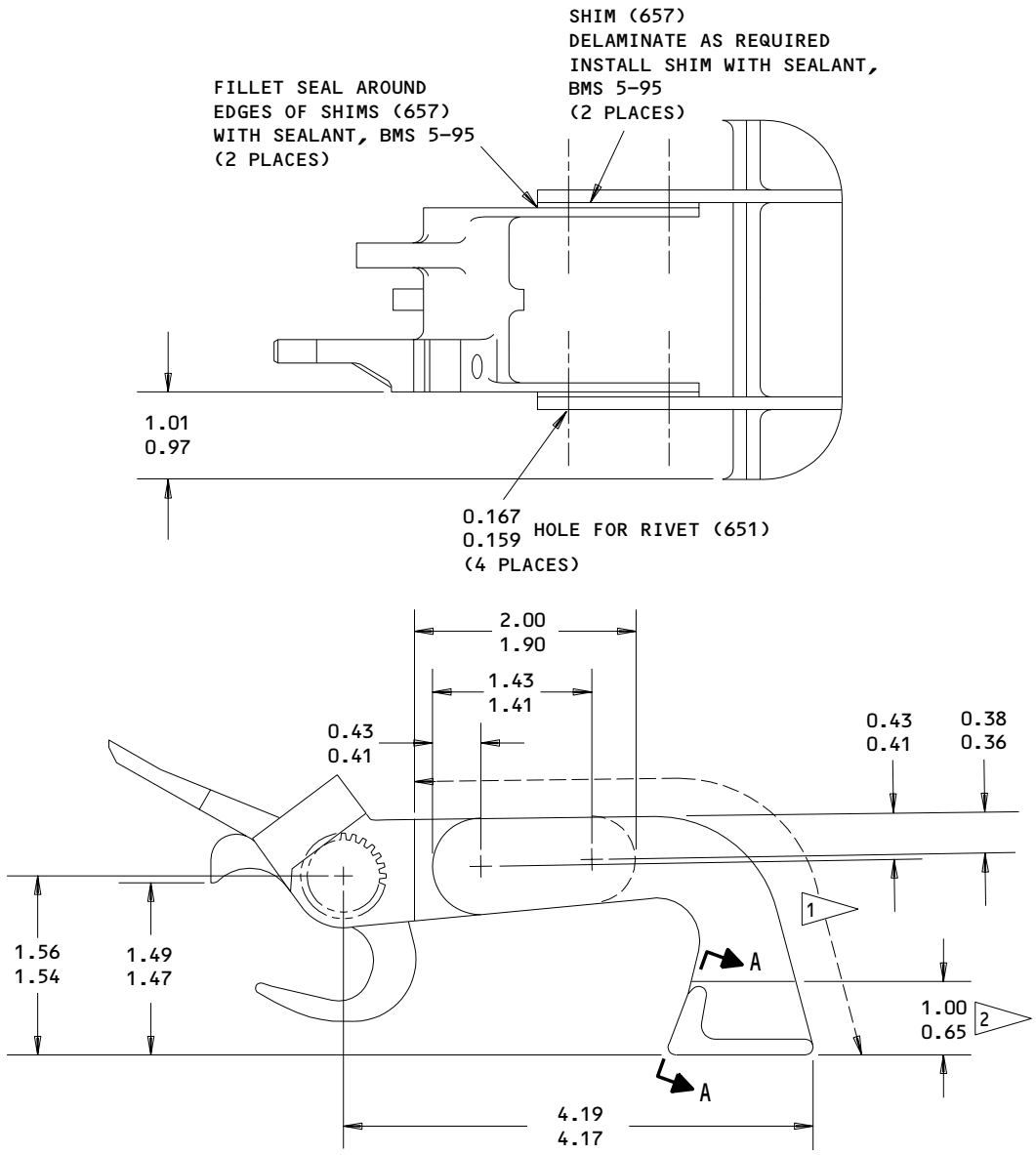
   C. Assemble parts (654 thru 660) and secure with rivet (651). Install shims (657) with wet sealant, BMS 5-95 on faying surfaces. Install rivets (651) with wet sealant, BMS 5-95 and squeeze drive. Fillet seal edges of shims (657) with sealant, BMS 5-95.

2. Marker Replacement

   A. Remove marker (665).

   B. Refinish cam assembly per Fig. 601.

   C. After complete drying of enamel, apply new marker per 20-50-05 in location shown (Fig. 601).



REFINISH

TOUCH UP UNPAINTED AREA (F-21.12) AND APPLY ENAMEL PER 1 2

1 APPLY 1 COAT BMS 10-79, TYPE 2 PRIMER AND BMS 10-60 TYPE 2 GLOSS ENAMEL, BAC702 WHITE (F-19.41-702) TO AREA INDICATED

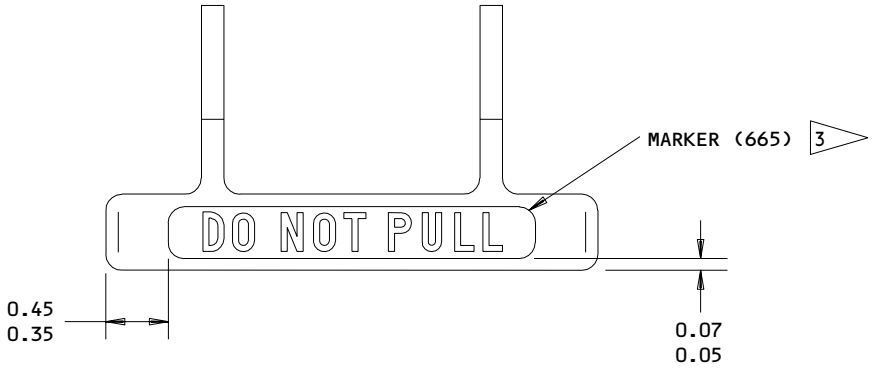
2 AFTER COMPLETION OF 1, APPLY 1 COAT BMS 10-79, TYPE 2 PRIMER AND BMS 10-60, TYPE 2 GLOSS ENAMEL, BAC101 RED (F-19.41-101) TO AREA INDICATED

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

141T6195-1,-2

Parts Replacement and Cam Assembly Refinish
Figure 601 (Sheet 1)



A-A

3 AFTER COMPLETION OF 1 AND 2 , APPLY ALUMINUM FOIL MARKER PER 20-50-05 IN LOCATION SHOWN

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

141T6195-1,-2

Parts Replacement and Cam Assembly Refinish
Figure 601 (Sheet 2)

304108

LUG ASSEMBLY - REPAIR 7-1

141T6196-3
141T6197-1

NOTE: Refer to REPAIR-GEN for list of applicable standard practices. For repair of surfaces which may only require restoration of original finish, refer to Refinish instructions.

Item numbers refer to IPL Fig. 1.

1. Bearing (36, 39) Replacement

   A. Remove bearing and ring.

   B. Install replacement bearing and ring per 20-50-03 except use wet sealant, BMS 5-95.

   C. Roller swage ring per 20-50-03.

   D. Check that maximum gap in ring is 0.062 inch. Fill gap in ring with sealant, BMS 5-95.

2. Refinish

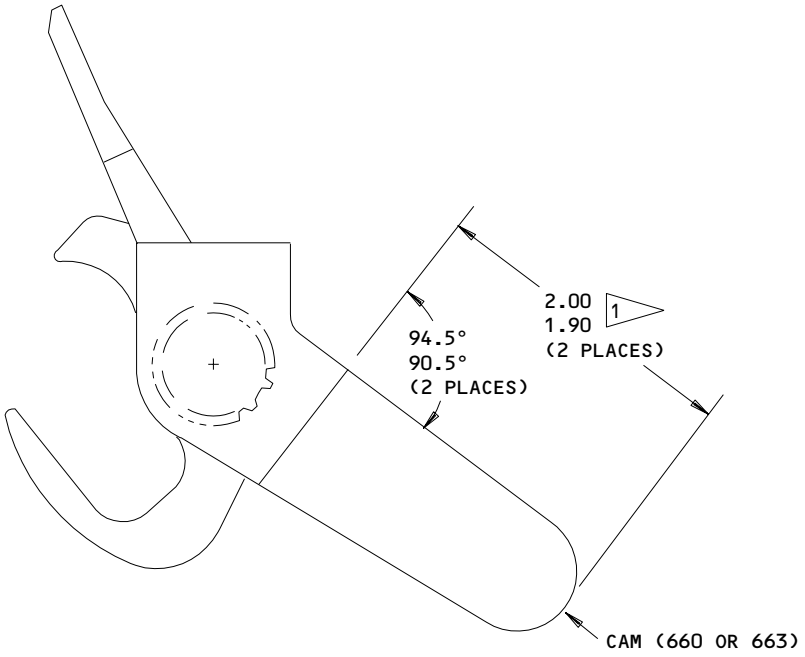
   A. Lug (39, 72) -- Passivate (F-17.09) all over. Material: 15-5PH CRES, 180-200 ksi.

CAM - REPAIR 8-1

141T6200-1, -2

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

CAM (660 OR 663) -- PASSIVATE (F-17.09) AND APPLY PRIMER PER 1

1 APPLY BMS 10-11, TYPE 1 PRIMER (F-20.03) TO BOTH SIDES AND EDGES OF TWO TABS

MATERIAL: 15-5PH CRES, 180-200 KSI

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

Cam Refinish
Figure 601

304109

OVERCENTER SPRING LEVER ASSEMBLY - REPAIR 9-1

141T6205-1

NOTE: Refer to REPAIR-GEN for list of applicable standard practices. For repair of surfaces which may only require restoration of original finish, refer to Refinish instructions, Fig. 601.

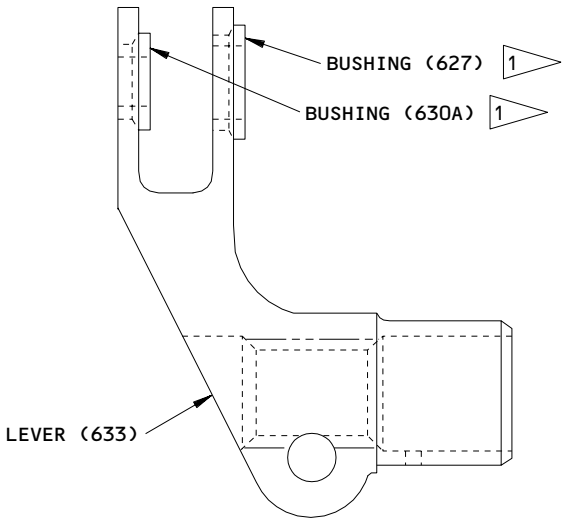
Item numbers refer to IPL Fig. 1.

1. Bushing (627, 630A) Replacement

A. Remove bushings.

B. Install replacement bushings per 20-50-03.

C. Spotface bushings as indicated (Fig. 601).



REFINISH

LEVER (633) -- PASSIVATE (F-17.25, WHICH REPLACES F-17.09).

MATERIAL: 17-4PH CRES, 150 KSI MIN. (OPT: 15-5PH CRES, 150-170 KSI)

ITEM NUMBERS REFER TO IPL FIG. 1

1 SPOTFACE FLUSH FAR SIDE

Bushing Replacement and Lever Refinish
Figure 601

303855

CARRIER DRIVE LEVER ASSEMBLY - REPAIR 10-1

141T6207-6

NOTE: Refer to REPAIR-GEN for list of applicable standard practices. For repair of surfaces which may only require restoration of original finish, refer to Refinish instructions.

Item numbers refer to IPL Fig. 3.

1. Bearing (15) Replacement

   A. Remove bearings.

   B. Install replacement bearings per 20-50-03 except use wet BMS 5-95 sealant.

2. Bushing (5, 10) Replacement

   A. Remove bushings.

   B. Install replacement bushings per 20-50-03 except use wet BMS 5-95 sealant.

   C. Fillet seal bushing flanges with sealant, BMS 5-95.

3. Refinish

   A. Lever (30) -- Anodize. Apply one layer of BMS 10-11, type 1 primer (F-18.04) all over. Material: Al alloy.

PIVOT SHAFT ASSEMBLY - REPAIR 11-1

141T6221-1

NOTE: Refer to REPAIR-GEN for list of applicable standard practices. For repair of surfaces which may only require restoration of original finish, refer to Refinish instructions, Fig. 601.

Item numbers refer to IPL Fig. 2.

1. Bushing (10, 15, 20) Replacement (Fig. 601)

   A. Remove bushings.

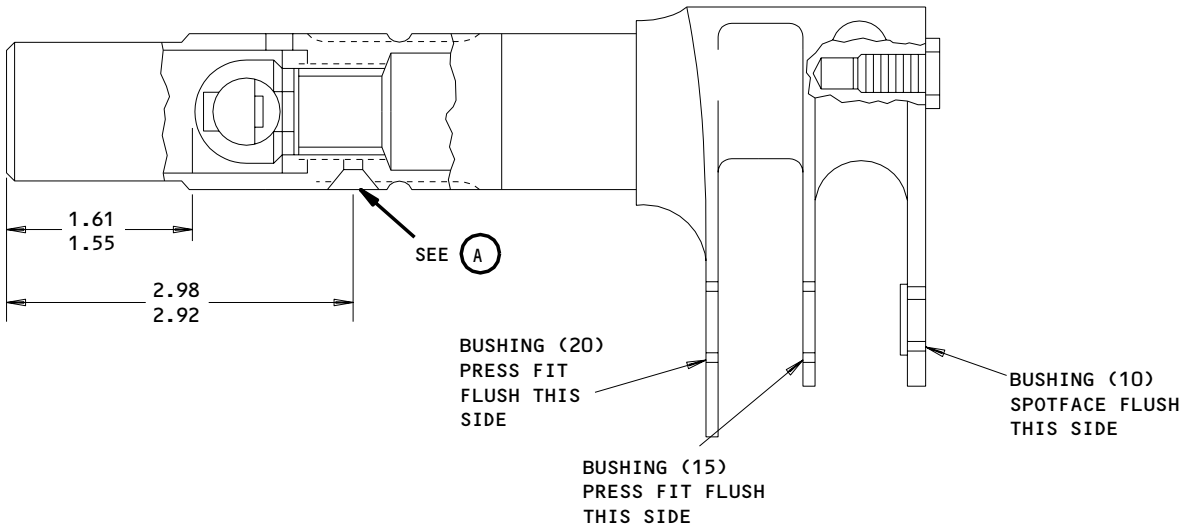
   B. Install replacement bushing per 20-50-03 and spot face as indicated.

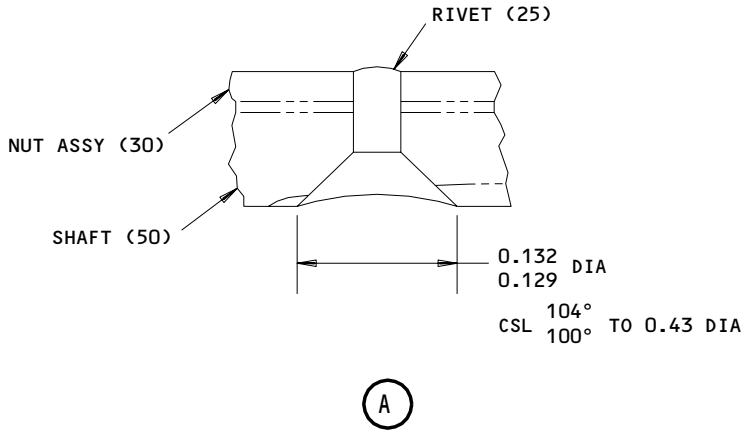
2. Nut Assembly (30) Replacement (Fig. 601)

   A. Drill out rivet (25) and unscrew nut assembly (30) from shaft (50).

   B. Install replacement nut assembly (30) and drill 0.129-0.132 inch diameter hole through one wall of shaft (50) and nut assembly. Countersink hole as indicated.

   C. Install rivet (25).





REFINISH

SHAFT (50) -- PASSIVATE (F-17.09)

MATERIAL: 15-5PH CRES, 180-200 KSI

ITEM NUMBERS REFER TO IPL FIG. 2

ALL DIMENSIONS ARE IN INCHES

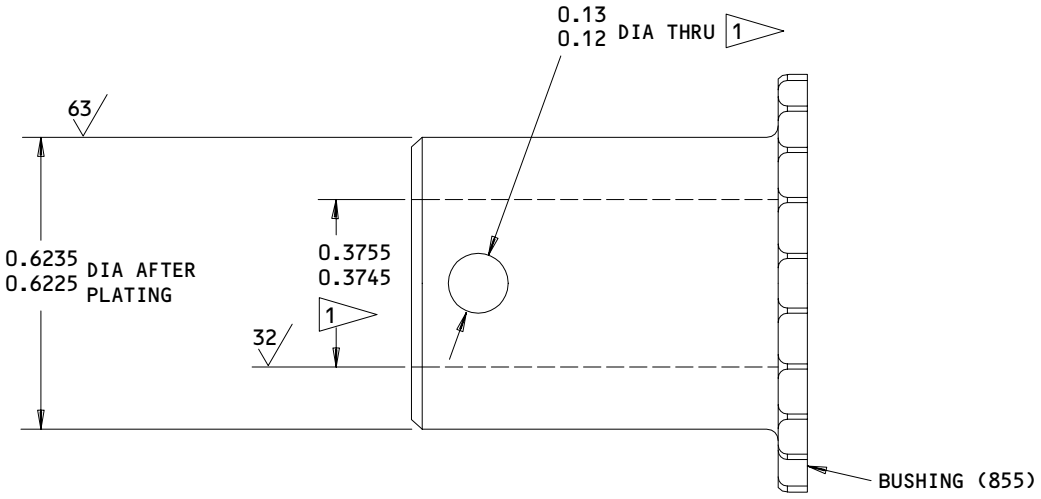
141T6221-1
Parts Replacement and Shaft Refinish
Figure 601

ADJUSTABLE BUSHING - REPAIR 12-1

141T6226-1

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

CADMIUM PLATE (F-15.06) ALL OVER EXCEPT AS NOTED

1 DO NOT PLATE THIS SURFACE

MATERIAL: BERYLLIUM COPPER

ITEM NUMBER REFERS TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

Bushing Refinish
Figure 601

303856

PIVOT SHAFT ASSEMBLY - REPAIR 13-1

141T6228-1, -2

NOTE: Refer to REPAIR-GEN for list of applicable standard practices. For repair of surfaces which may only require restoration of original finish, refer to Refinish instructions.

Item numbers refer to IPL Fig. 1.

1. Bushing (930, 933) Replacement

   A. Remove bushings.

   B. Install replacement bushings per 20-50-03 except use grease, BMS 3-24.

2. Refinish

   A. Shaft (936A, 939A) -- Passivate (F-17.09) all over. Material: 15-5PH CRES, 180-200 ksi.

HANDLE ASSEMBLY - REPAIR 14-1

141T6249-1, -6

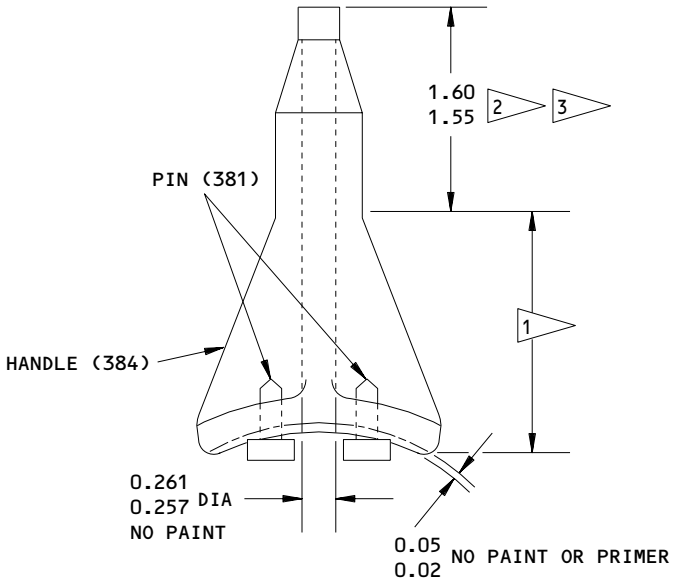
NOTE: Refer to REPAIR - GENERAL for a list of applicable standard practices. For repair of surfaces which may only require restoration of original finish, refer to Refinish instructions, Fig. 601.

Item numbers refer to IPL Fig. 1.

1. Pin (381) Replacement

   A. Remove damaged pin.

   B. Install new pin using BMS 5-95 sealant.



REFINISH

HANDLE (384) -- NO FINISH (F-25.01)
HANDLE ASSEMBLY (378A) -- APPLY PROTECTIVE COATING PER SOPM 20-44-01, TYPE 31 IN AREA INDICATED BY 1. APPLY BMS 10-83, TYPE 2, BAC4533 GREEN ENAMEL (F-22.06-4533) IN AREA INDICATED BY 2.

HANDLE ASSEMBLY (378) -- APPLY PROTECTIVE COATING PER SOPM 20-44-01, TYPE 31 AREA INDICATED BY 1. APPLY BMS 10-83, TYPE 2, BAC302 YELLOW ENAMEL (F-22.06-302) IN AREA INDICATED BY 3.

1 APPLY PROTECTIVE COATING HERE

2 APPLY GREEN ENAMEL HERE

3 APPLY YELLOW ENAMEL HERE

MATERIAL: 17-4PH CRES
PIN (381) 180-200 KSI
HANDLE (384) 180-220 KSI

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

141T6249-1,-6
Handle Refinish
Figure 601

ARMING FLAG LEVER ASSEMBLY - REPAIR 15-1

141T6271-31, -32

NOTE: Refer to REPAIR-GEN for list of applicable standard practices. For repair of surfaces which may only require restoration of original finish, refer to Refinish instructions, Fig. 601.

Item numbers refer to IPL Fig. 1.

1. Bushing (207, 210) Replacement (Fig. 601)

   A. Remove bushings.

   B. Install bushings per 20-50-03 except use wet sealant BMS 5-95.

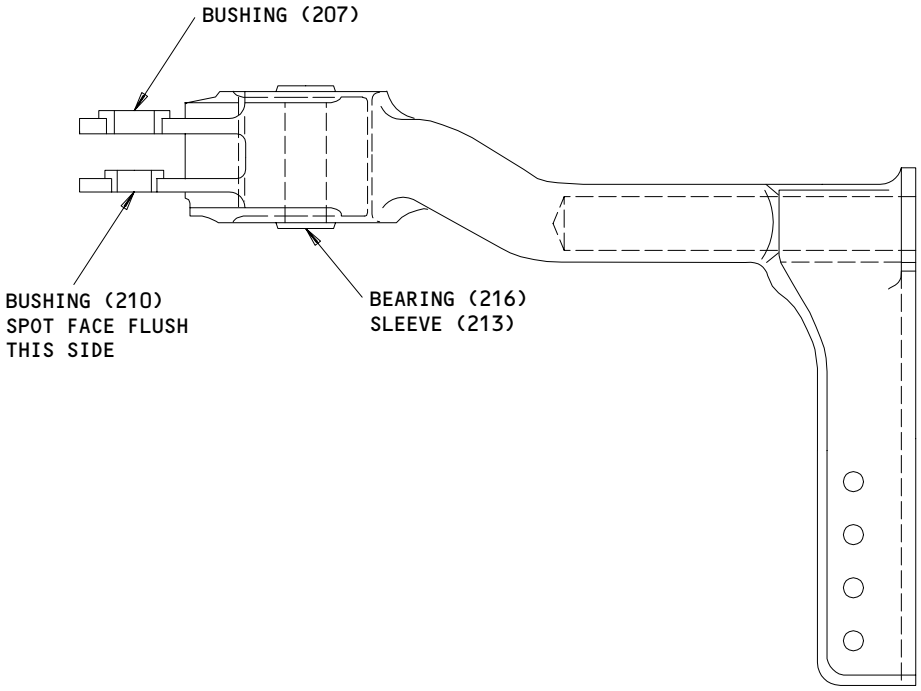
   C. Spot face bushing (210) as indicated.

   D. Fillet seal bushing flange with sealant, BMS 5-95.

2. Bearing (216) Replacement

   A. Remove bearing (216) and sleeve (213).

   B. Install replacement bearing and sleeve per 20-50-03 and roller swage sleeve per 20-50-03. Check that gap in sleeve after roller swage is 0.062 inch maximum.



REFINISH

LEVER (219 OR 222) -- CHROMIC ACID ANODIZE (F-17.04) AND APPLY 1 COAT OF BMS 10-11, TYPE 1 PRIMER (F-20.02) EXCEPT OMIT PRIMER IN BUSHING AND BEARING BORES

MATERIAL: AL ALLOY

ITEM NUMBERS REFER TO IPL FIG. 1

141T6271-31,-32

Bushing Replacement and Lever Refinish
Figure 601

304111

SPRING GUIDE - REPAIR 16-1

141T6274-1, -2

NOTE: Refer to REPAIR-GEN for list of applicable standard practices. For repair of surfaces which may only require restoration of original finish, refer to Refinish instructions.

Item numbers refer to IPL Fig. 1.

1. Bearing (606) Replacement

A. Remove bearing and sleeve (603).

B. Install replacement bearing and sleeve and roller swage per 20-50-03 except use wet sealant, BMS 5-95. Verify that gap in sleeve is 0.062 inch maximum. Fill gap with sealant.

2. Refinish

A. Guide (582) -- Flash hard coat of sulfuric acid anodize (F-17.03) 0.0002 inch thick except sulfuric acid hard anodize (F-17.06) from shoulder (0.960 diameter) to top of shaft (0.2495 diameter). Material: Al alloy.

B. Housing (612) -- Flash hard coat of sulfuric acid anodize (F-17.03) 0.0002 inch thick except sulfuric acid hard anodize (F-17.06) from shoulder (0.960 diameter) to tip of 0.540 O.D. Material: Al alloy.

LINK ASSEMBLY - REPAIR 17-1

141T6277-1, -2

NOTE: Refer to REPAIR-GEN for list of applicable standard practices. For repair of surfaces which may only require restoration of original finish, refer to Refinish instructions.

Item numbers refer to IPL Fig. 1.

1. Bearing (252 or 294) Replacement

   A. Remove bearing and sleeve (249 or 291).

   B. Install replacement bearing and sleeve and roller swage sleeve per 20-50-03. Check that gap in sleeve is 0.062 inch maximum.

2. Link Refinish

   A. Link (255, 297) -- Chromic acid anodize and apply 1 coat of primer, BMS 10-11, type 1 (F-18.13) all over. Material: Al alloy.

ROLLER ASSEMBLY - REPAIR 18-1

141T6287-3, -4

NOTE: Refer to REPAIR-GEN for list of applicable standard practices. For repair of surfaces which may only require restoration of original finish, refer to Refinish instructions.

Item numbers refer to IPL Fig. 1.

1. Bushing (783 or 819) Replacement

   A. Remove bushings.

   B. Install replacement bushings per 20-50-03.

2. Refinish

   A. Roller (786) -- Chrome plate (F-15.03) on OD and ends. Passivate (F-17.09) on ID. OD after plating shall be 0.505-0.510 inch and width of roller after plating shall be 0.290-0.300 inch (passivate (F-17.09) optional on ends). Material: 15-5PH CRES, 180-200 ksi.

   B. Roller (822) -- Chrome plate (F-15.03) on OD and ends. Passivate (F-17.09) on ID. OD after plating shall be 0.505-0.510 inch and width of roller after plating shall be 0.210-0.220 inch (passivate (F-17.09) optional on ends). Material: 15-5PH CRES, 180-200 ksi.

ROD END ASSEMBLY - REPAIR 19-1

141T6287-5

NOTE: Refer to REPAIR-GEN for list of applicable standard practices. For repair of surfaces which may only require restoration of original finish, refer to Refinish instructions.

Item numbers refer to IPL Fig. 1.

1. Bushing (873) Replacement

   A. Remove bushings.

   B. Install replacement bushings per 20-50-03.

2. Refinish

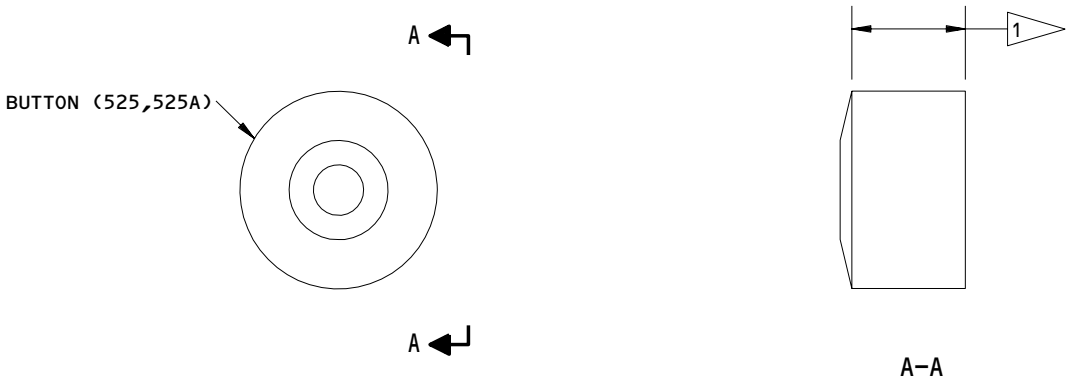
   A. Rod end (876) -- Passivate (F-17.09) all over. Material: 15-5PH CRES, 180-200 ksi.

BUTTON - REPAIR 20-1

141T6538-7, -10

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

BUTTON (525) -- APPLY ONE COAT BMS 10-11, TYPE 1 PRIMER (F-20.02) PLUS APPLY BMS 10-83, TYPE 2, BAC4533 GREEN ENAMEL (F-22.06-4533) TO CIRCUMFERENTIAL SURFACE NOTED

BUTTON (525A) -- APPLY ONE COAT BMS 10-11, TYPE 1 PRIMER (F-20.02) PLUS APPLY BMS 10-83, TYPE 2 BAC302 YELLOW ENAMEL (F-22.06-302) TO CIRCUMFERENTIAL SURFACE NOTED

1 APPLY PRIMER AND ENAMEL TO THIS SURFACE ONLY

MATERIAL: NYLON BAR, SPEC L-P-410

ITEM NUMBERS REFER TO IPL FIG. 1

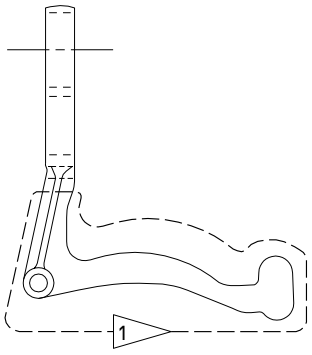
141T6538-7,-10
Button Refinish
Figure 601

LOCKOUT LEVER - REPAIR 21-1

141T6651-2

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

LEVER (513) -- APPLY 1 COAT OF BMS 10-11, TYPE 1 PRIMER (F-20.02) ALL OVER EXCEPT IN 0.250 INCH HOLE. APPLY VITROLUBE 1220 PER 20-50-08 0.0004-0.0007 INCH THICK IN AREA INDICATED BY 1 EXCEPT NO VITROLUBE PERMITTED IN 0.250 INCH HOLE

1 APPLY VITROLUBE TO THIS AREA

MATERIAL: 17-4PH CRES, 150-170 KSI

ITEM NUMBERS REFER TO IPL FIG. 1

Lever Refinish
Figure 601

304113

LOCKOUT SECTOR ASSEMBLY - REPAIR 22-1

141T6652-2

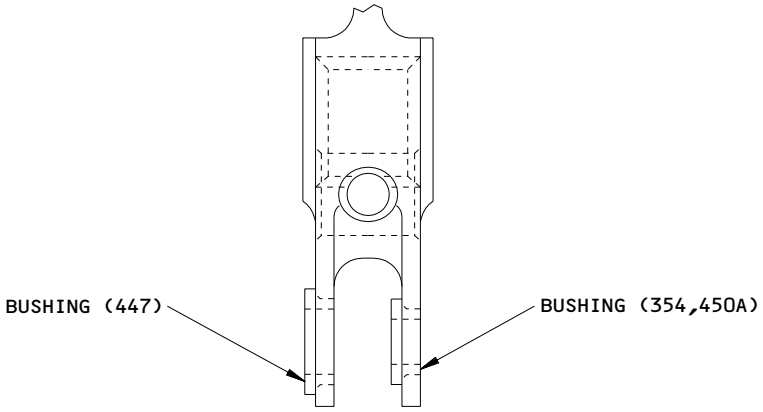
NOTE: Refer to REPAIR-GEN for list of applicable standard practices. For repair of surfaces which may only require restoration of original finish, refer to Refinish instructions, Fig. 601.

Item numbers refer to IPL Fig. 1.

1. Bushing (354, 447, 450A) Replacement (Fig. 601)

A. Remove bushings.

B. Install replacement bushings per 20-50-03.



REFINISH

SECTOR (453) -- PASSIVATE (F-17.25, WHICH REPLACES F-17.09).

MATERIAL: 17-4PH CRES, 180 KSI MIN
(OPT 15-5PH CRES, 180-200 KSI)

ITEM NUMBERS REFER TO IPL FIG. 1

Bushing Replacement and Sector Refinish
Figure 601

304114

LOWER TERMINAL FITTING ASSEMBLY - REPAIR 23-1

143T6141-1, -2

NOTE: Refer to REPAIR-GEN for list of applicable standard practices. For repair of surfaces which may only require restoration of original finish, refer to Refinish instructions, Fig. 601.

Item numbers refer to IPL Fig. 5.

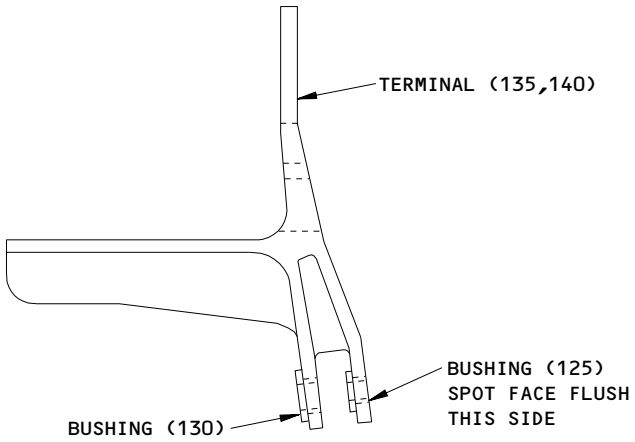
1. Bushing (125, 130) Replacement (Fig. 601)

   A. Remove bushings.

   B. Install bushings per 20-50-03 except use wet sealant BMS 5-95.

   C. Spot face bushing (125) as indicated.

   D. Fillet seal bushing flanges with sealant, BMS 5-95.



REFINISH

TERMINAL (135,140) -- CHROMIC ACID ANODIZE (F-17.04). APPLY ONE LAYER OF BMS 10-11, TYPE 1 PRIMER (F-20.02), EXCEPT OMIT PRIMER FROM BUSHING BORES

MATERIAL: AL ALLOY

ITEM NUMBERS REFER TO IPL FIG. 5

Bushing Replacement and Terminal Refinish
Figure 601

303859

GIRT DRIVE LEVER ASSEMBLY - REPAIR 24-1

143T6142-1

NOTE: Refer to REPAIR-GEN for list of applicable standard practices. For repair of surfaces which may only require restoration of original finish, refer to Refinish instructions.

Item numbers refer to IPL Fig. 1.

1. Bushings (312, 315) Replacement

   A. Remove bushings.

   B. Install replacement bushings per 20-50-03.

2. Refinish

   A. Lever (318) -- Passivate (F-17.09). Material: 17-4 PH CRES, 150 ksi min.

ADAPTER ASSEMBLY - REPAIR 25-1

143T6143-1, -2

NOTE: Refer to REPAIR-GEN for list of applicable standard practices. For repair of surfaces which may only require restoration of original finish, refer to Refinish instructions, Fig. 601.

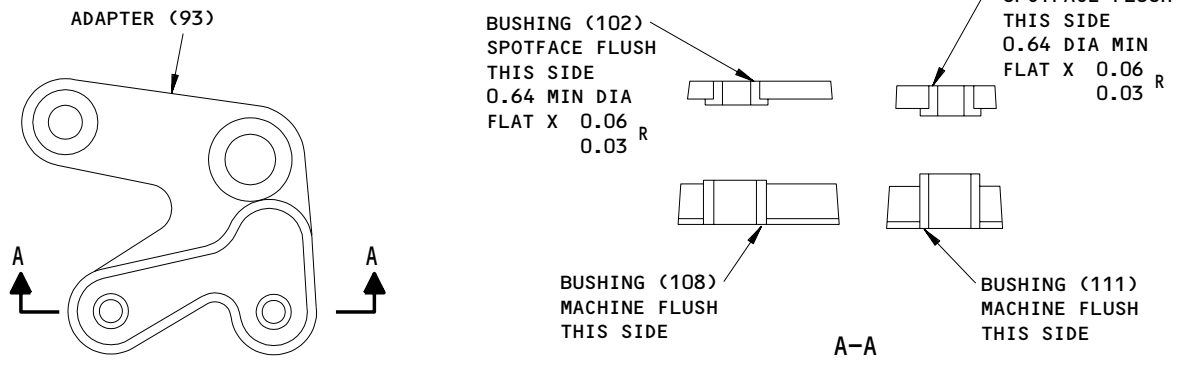
Item numbers refer to IPL Fig. 1.

1. Bushing (102, 105, 108, 111) Replacement

   A. Remove bushings.

   B. Install replacement bushings per 20-50-03.

   C. Spot face bushings as indicated (Fig. 601).



REFINISH

ADAPTER (93) -- PASSIVATE (F-17.25, WHICH REPLACES F-17.09).

MATERIAL: 15-5PH CRES, 180-200 KSI

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

Bushing Replacement and Adapter Refinish
Figure 601

303863

PISTON ASSEMBLY - REPAIR 26-1

69B13060-7

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

Item numbers refer to IPL Fig. 1.

1. Bearing (363) Replacement

A. Remove bearing.

B. Install replacement bearing and roller or anvil swage per 20-50-03.

HOUSING ASSEMBLY - REPAIR 27-1

69B13067-7

NOTE: Refer to REPAIR-GEN for list of applicable standard practices. For repair of surfaces which may only require restoration of original finish, refer to Refinish instructions.

Item numbers refer to IPL Fig. 1.

1. Bushing (336) Replacement

   A. Remove bushings.

   B. Install replacement bushings per 20-50-03.

2. Refinish

   A. Housing (339) -- Apply dry film lubricant, BMS 3-8 per 20-50-08 all over. Material: AISI 303 CRES.

MISCELLANEOUS PARTS REFINISH - REPAIR 28-1

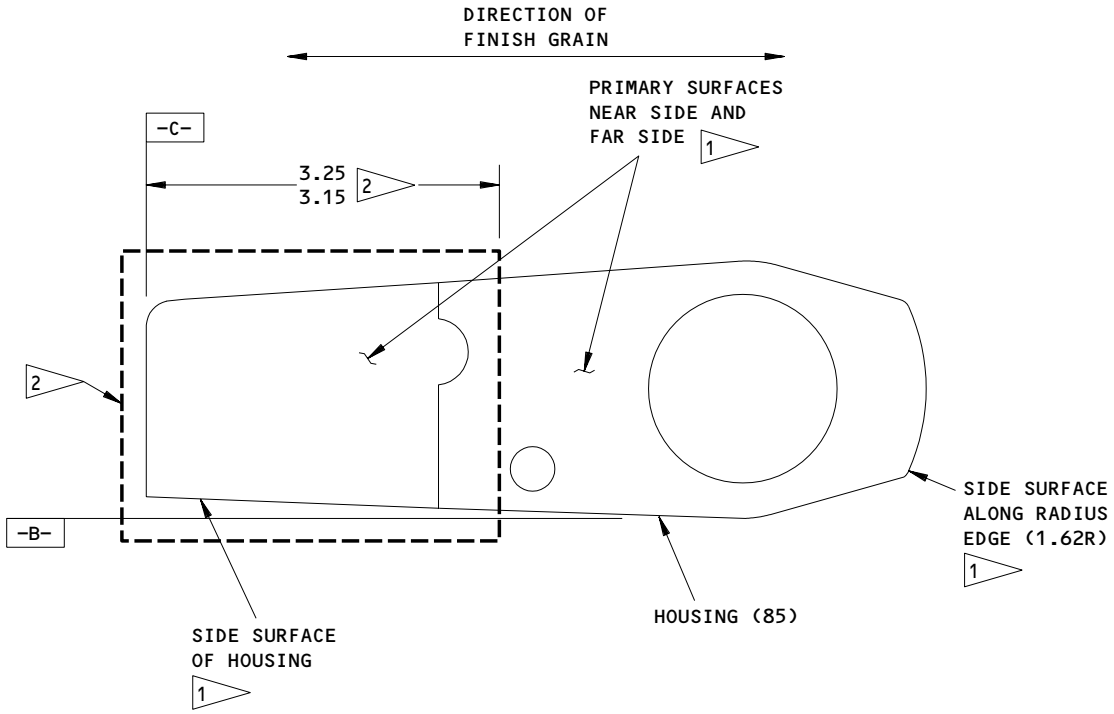
1. Repair of parts listed in Fig. 601 consists of restoration of the original finish.

IPL FIG. & ITEM	MATERIAL	FINISH
Fig. 1		
Clutch (148X), Fitting (148W), Spacer (149), Adapter (160J, 171C), Lever (396, 832B,834A,837A), Shafts (456,457, 723A,858), Pin (849), Spacer (906)	15-5PH CRES, 180-200 ksi	Passivate (F-17.09).
Spring (342,861, 961)	17-7PH CRES	Passivate (F-17.09).
Clutch (148V,148Y)	17-7PH CRES, 180-200 ksi	Passivate (F-17.09).
Spacer (159), Adapter (408), Crank (693)	17-4PH CRES, 150 ksi minimum (Opt: 15-5PH CRES, 150-170 ksi)	Passivate (F-17.09).
Support (549 or 552)	Al alloy	Anodize (F-17.05) and apply 1 coat of primer, BMS 10-11, type 1 (F-20.02) all over.
Support (801)	17-4PH CRES, 150 ksi minimum (Opt: 15-5PH CRES, 150-170 ksi)	Passivate (F-17.09).
Clip (831U,833)	302 or 304 annealed CRES sheet	Passivate (F-17.09).

Refinish Details
Figure 601 (Sheet 1)

IPL FIG. & ITEM	MATERIAL	FINISH
Fig. 1 (Cont)		
Base (960), Pawl (962,963)	Al alloy	Chromic acid anodize; apply one coat BMS 10-11, type 1 primer (F-18.13) all over. Prepare surface and apply white abrasion-resistant teflon coating BMS 10-86, type 1, per 20-44-01, type 27. Omit teflon coating from holes. Limit coating thickness to 0.01 inch maximum.
Fig. 2		
Housing (45)	15-5PH CRES, 180-200 ksi	Passivate (F-17.09).
Fig. 5		
Bracket (55)	Al alloy	Chromic acid anodize and apply 1 coat of primer, BMS 10-11, type 1 (F-18.13) all over.
Fig. 6		
Pawl (70A)	15-5PH CRES, 180-200 ksi	Passivate (F-17.09).
Housing (85)	(85 is 17-4PH CRES; 85A is 15-5PH CRES) 180-200 ksi	Apply a satin finish (F-14.802) to the outer surfaces of the housing as specified in Fig. 602. Passivate (F-17.25) all surfaces. Cadmium plate and apply BMS 10-11, Type 1 primer (F-16.01), and apply aluminized epoxy primer (F-14.963) on the inner surfaces of the housing in the area shown in Fig. 602, by flagnote 2.

Refinish Details
Figure 601 (Sheet 2)



1 APPLY A SATIN FINISH (F-14.802), WITH GRAIN DIRECTION AS SHOWN, ON THE OUTER SURFACES OF THE HOUSING, IN THE AREA SHOWN. A PARTIAL FINISH IS PERMITTED ON ALL OTHER OUTER SURFACES

2 CADMIUM PLATE AND APPLY BMS 10-11, TYPE 1 PRIMER (F-16.01), AND APPLY ALUMINIZED EPOXY PRIMER (F-14.963) ON THE INNER SURFACES OF THE HOUSING (85) IN THE AREA SHOWN

ITEM NUMBERS REFER TO IPL FIG. 6

ALL DIMENSIONS ARE IN INCHES

143T6151-1,-3
Housing Finish
Figure 602

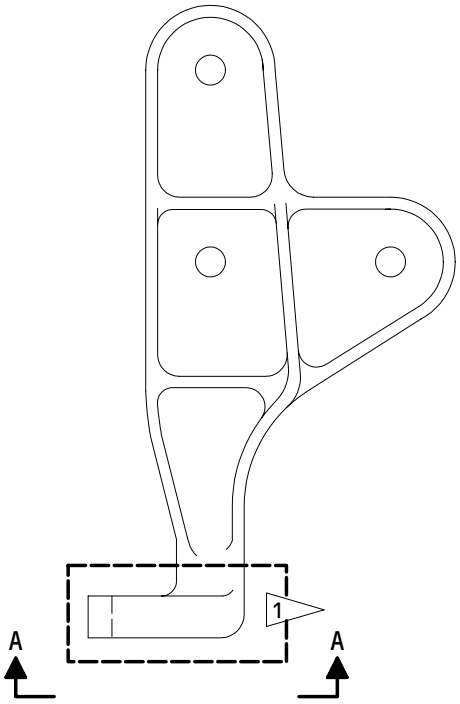
W28966

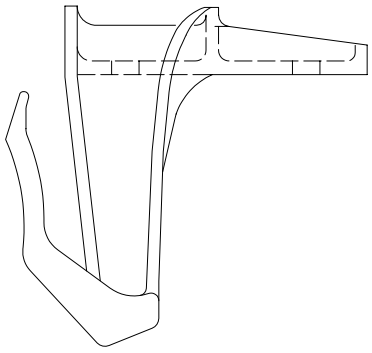
CAM BRACKET - REPAIR 29-1

143T6156-1, -2, -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.





A–A

REFINISH

CADIMUM PLATE AND APPLY ONE COAT OF BMS 10–11, TYPE 1 PRIMER (F–16.01) ALL OVER EXCEPT AS NOTED BY 1

MATERIAL: AISI 630 (17–4PH) 180–200 KSI

ALL DIMENSIONS ARE IN INCHES

1 NO PRIMER IN THIS AREA

Cam Bracket Assembly Refinish
Figure 601

ASSEMBLY

1. Materials

NOTE: Equivalent substitutes may be used.

A. Grease (Ref 20-60-03)
-- BMS 3-24
-- MIL-G-23827

B. Lockwire -- MS20995NC32

C. Primer -- BMS 10-11, Type 1 (Ref 20-60-02)

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

2. Assembly

NOTE: Unless otherwise indicated, tighten fasteners per 20-50-01.

A. Preassemble the following components (IPL Fig. 1).

(1) Assemble adapter assembly (90) to shaft assembly (174).

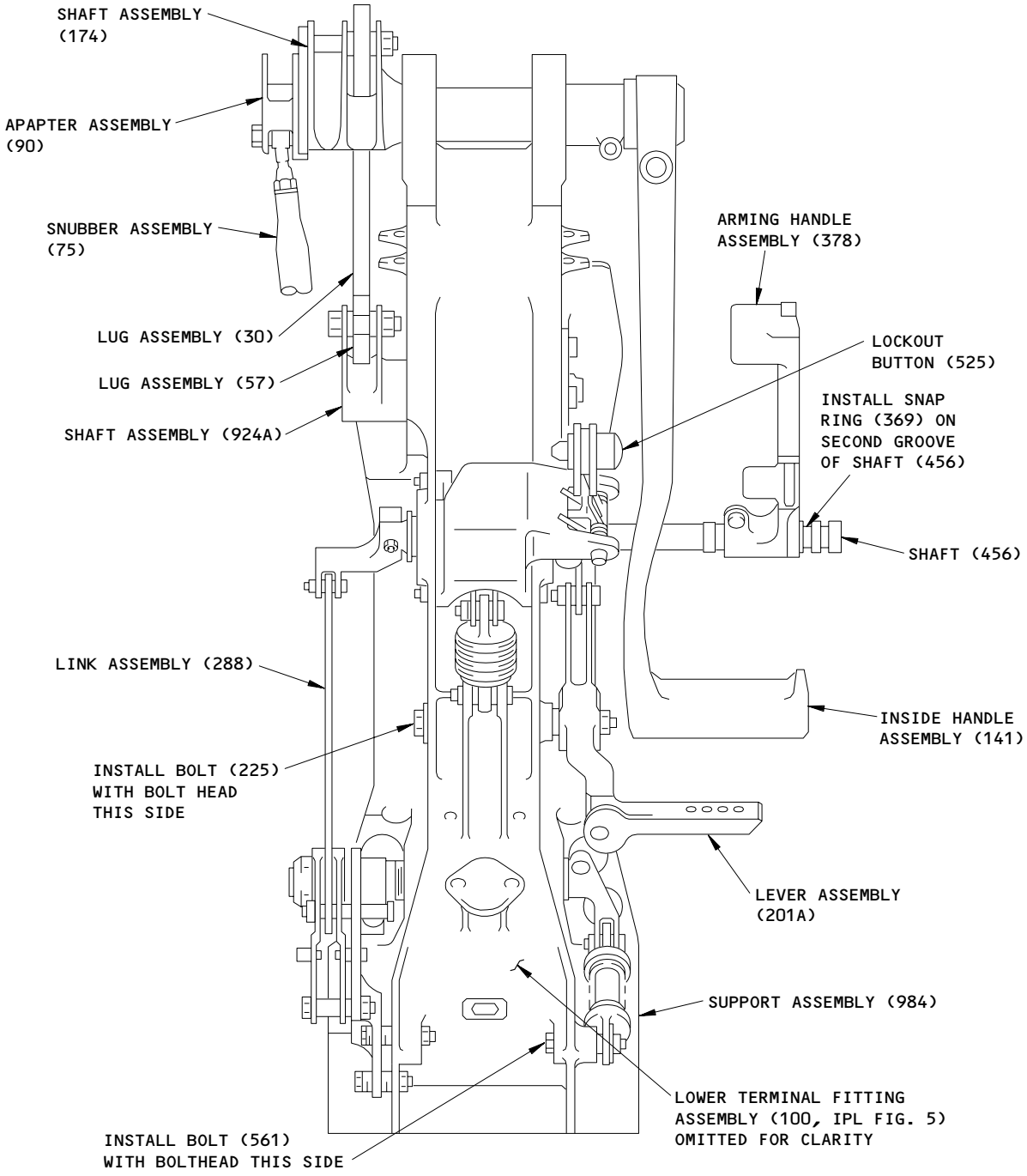
(a) Apply a light coat of grease MIL-G-23827 or BMS 3-24 to faying surfaces of adapter assembly (90) and shaft assembly (174). Wipe surfaces with dry cloth to remove grease. Do not use solvent.

(b) Assemble adapter assembly (90) to shaft assembly (174) with wet sealant.

(2) Assemble handle assembly (378), lever assembly (387) and adapter (408).

(a) Apply a light coat of grease, MIL-G-23827 to faying surfaces of lever assembly (387) and to serrated area of handle assembly (378) and adapter (408).

(b) Install lever assembly (387) and handle assembly (378) on adapter (408). Secure handle assembly (378) to lever assembly (387) with screw (372) and washer (375). Tighten screw (372) finger-tight.



ITEM NUMBERS REFER TO IPL FIG. 1

(VIEW IN THE OUTBOARD DIRECTION)
143T6140-3 ASSEMBLY SHOWN
143T6140-7,-9,-15 ASSEMBLIES EQUIVALENT
143T6140-4,-8,-10,-16 ASSEMBLIES ARE OPPOSITE

Handle Mechanism Assembly
Figure 701

(3) Assemble lug assemblies (30, 57).

(a) Apply a light coat of grease, MIL-G-23827 to serrated surfaces of lug assemblies (30, 57).

(b) Assemble lug assemblies (30, 57) and secure with bolts (42, 48) and washers (45, 51, 54). Assemble fasteners only to retain lug assemblies.

(4) Assemble roller assembly (816), levers (832B, 832L, 832M, 834A, 837A, 837B), clip (831U, 833), if applicable.

WARNING: MAKE SURE LEVERS (832B, 832L, 832M, 834A, 837A, 837B) ARE INSTALLED AS SHOWN IN FIG. 705. BACKWARDS INSTALLATION OF LEVERS WILL PREVENT DOOR OPENING DURING EMERGENCY EXIT.

CAUTION: LEVERS (834A, 837A) ARE A MATCHED SET AND MUST BE KEPT TOGETHER WITH THE CLIP (833) TO MAKE SURE OF PROPER OPERATION AFTER ASSEMBLY. CLIP (833) IS INSTALLED WITH THE MATCHED SET OF 141T6280-1 (834A) AND 141T6280-2 (837A) LEVERS ONLY TO PREVENT BACKWARDS INSTALLATION OF THE LEVERS DURING ASSEMBLY. SEE FIG. 705 FOR CORRECT ORIENTATION OF LEVERS (834A, 837A).

LEVERS (834A, 837B) ARE A MATCHED SET AND MUST BE KEPT TOGETHER TO MAKE SURE OF PROPER OPERATION AFTER ASSEMBLY.

LEVERS (832B, 837L) ARE A MATCHED SET AND MUST BE KEPT TOGETHER WITH CLIP (831U) TO MAKE SURE OF PROPER OPERATION AFTER ASSEMBLY. CLIP (831U) IS INSTALLED WITH THE MATCHED SET OF 141T6280-1 (832B) AND 141T6280-2 (832L) LEVERS ONLY TO PREVENT BACKWARDS INSTALLATION OF THE LEVERS DURING ASSEMBLY. SEE FIG. 705 FOR CORRECT ORIENTATION OF LEVERS (832B, 832L).

LEVERS (832B, 832M) ARE A MATCHED SET AND MUST BE KEPT TOGETHER TO MAKE SURE OF PROPER OPERATION AFTER ASSEMBLY.

(a) Assemble levers (832B, 832L, 832M, 834A, 837A, 837B) and rod end assembly (870) and install bushing (813) inside the roller assembly (816). Install clip (831U, 833), if applicable, around middle shaft between lever (832B, 834A) and lever (832L, 837A).

NOTE: 141T6103-1 (833) with 141T6280-1 (834A) and 141T6280-2 (837A) is optional to the matched set of 141T6280-1 (834A) and 141T6280-3 (837B).

NOTE: 141T6103-1 (831U) with 141T6280-1 (832B) and 141T6280-2 (832L) is optional to the matched set of 141T6280-1 (832B) and 141T6280-3 (832M).

(b) Apply a light coat of grease, MIL-G-23827 to threads and shank of bolt (804). Position roller assembly (816) between levers (832B, 832I, 832M, 834A, 837A, 837B) and install bolt (804), washer (807) and nut (810). Observe bolt (804) head direction regarding LH or RH handle assembly (945).

(5) Assemble roller assembly (780) and bushing (777) on support (801) and secure with bolt (768), washer (771), and nut (774).

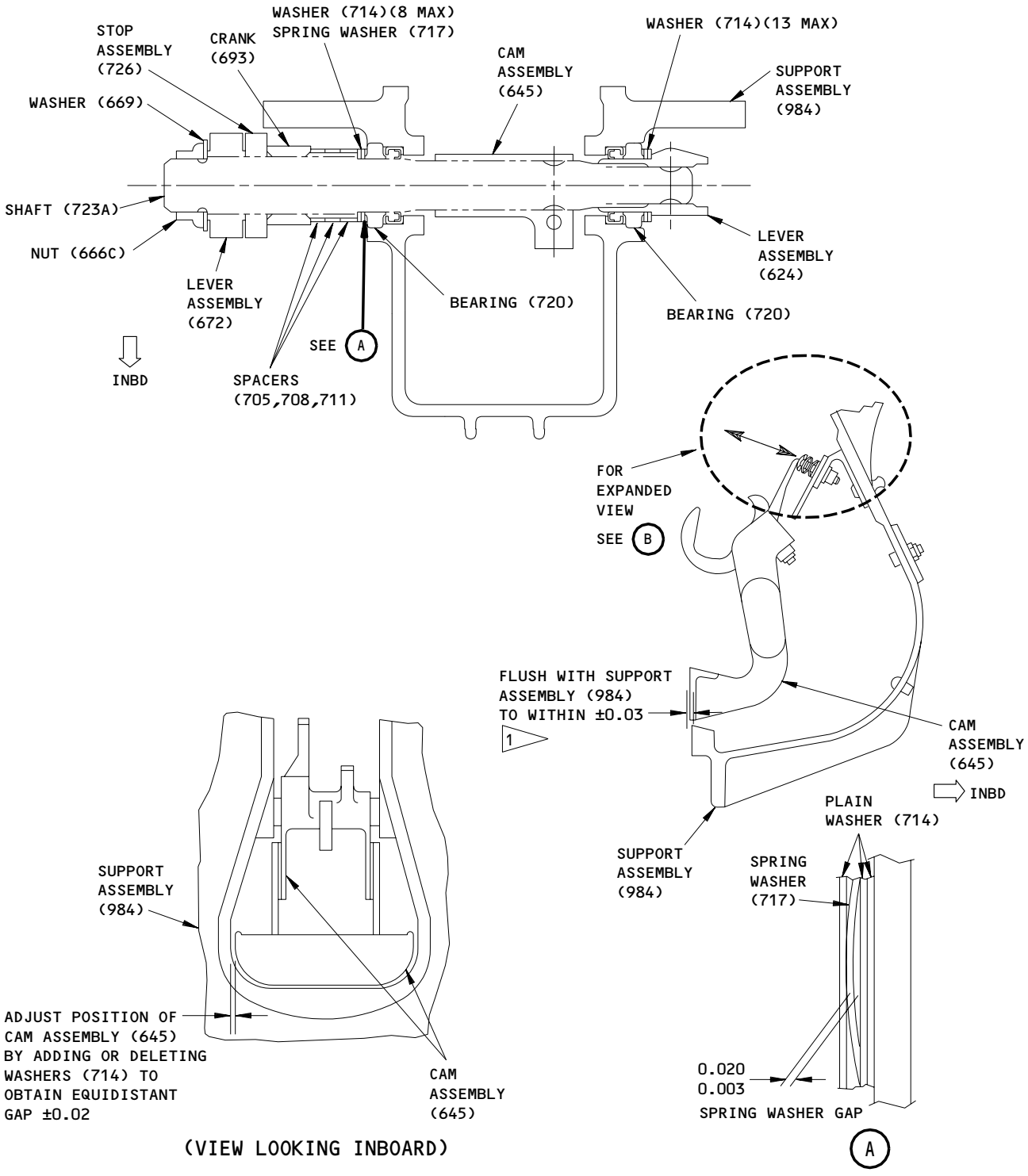
(6) Apply a light coat of grease, MIL-G-23827 to threads and shank of bolt (696) and install bolt (696), washers (699) and nut (702) on crank (693). Install 13 washers under bolt and 1 washer under nut. Tighten nut finger tight.

(7) Apply a light coat of grease, MIL-G-23827 to OD of bearings (186, 468, 720) and install in support assembly (984).

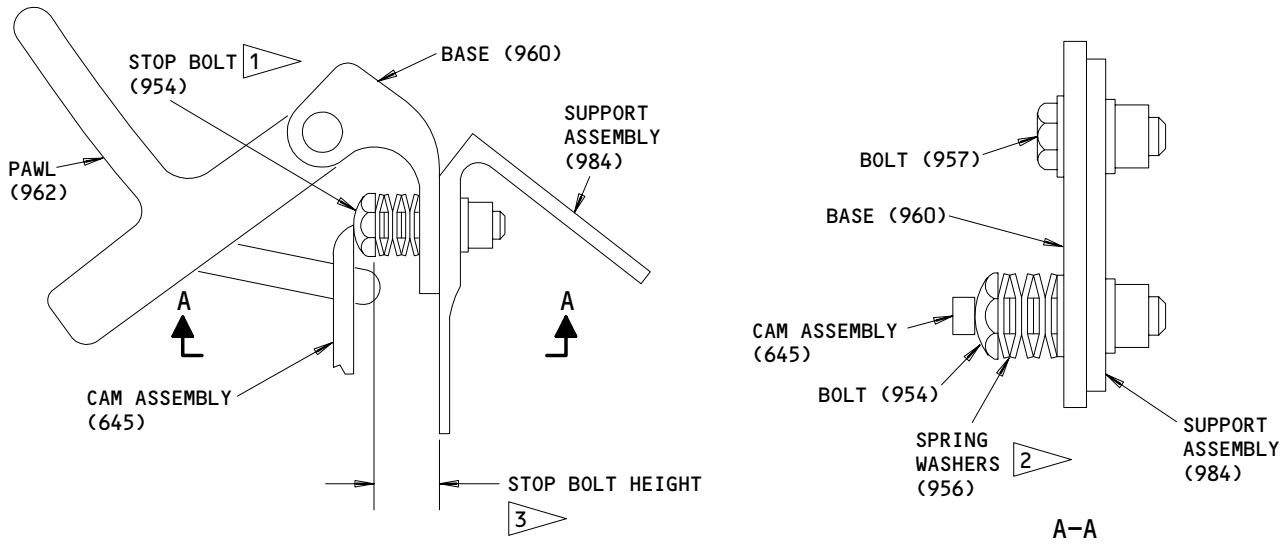
B. Assemble cam assembly (645) and shaft (723A) (Fig. 702).

(1) Apply a light coat of grease, MIL-G-23827 to splined areas of shaft (723A), cam assembly (645), washers (714), spring (717) and to splines and bearing flat of lever assembly (624). Install 2 washers (714) and 1 spring (717) on shaft (723A) up against the large splined end of shaft.

(2) Position cam assembly (645) in cavity of support assembly (984) and install shaft (723A). Push lever (654) of cam assembly inward to gain access to fastener hole in cam assembly.



Assembly Details – Cam Assembly
Figure 702 (Sheet 1)



ARMING SYSTEM EXTERNAL LOCK
(B)

1. ADJUST HEIGHT OF BOLT (954) AS REQUIRED TO OBTAIN FLUSHNESS INDICATED
2. NOTE POSITION OF WASHER ADJACENT TO BOLT HEAD, AND ALTERNATING POSITION OF ADDITIONAL WASHERS
3. FILL THIS DIMENSION WITH ANY COMBINATION OF WASHERS (956) TO PRODUCE DISARM LEVER FLUSHNESS AS SHOWN ON SHEET 1. MEASURE STOP BOLT (954) HEIGHT AFTER INSTALLING WASHERS (956) AND TIGHTEN BOLT TO 35–40 IN. –LBS TORQUE

Assembly Details – Cam Assembly
Figure 702 (Sheet 2)

306629

(3) Apply a thin film of grease, MIL-G-23827 to shank and threads of bolt (636) and install bolt (636) thru cam assembly (645).

(4) Check that cam assembly (645) is centered in the support assembly to within ±0.02 inch. Remove parts and add washers (714) as required, up to 8 washers, to center cam assembly.

(5) Install 2 washers (714) on bearing flat of lever assembly (624) and install lever assembly on shaft (723A). Adjust number of washers (714) as required so that bolt (615) can easily pass thru bolt hole in lever assembly and bolt cutout in shaft and spring (717) is slightly compressed (0.003-0.020 inch gap between spring and adjacent part). Install bolt (615), washer (618) and nut (621).

(6) Adjust cam assembly (645) external flushness.

(a) Coat pin (959A) and adjacent surfaces of items (960 thru 962) with MIL-G-23827 grease and assemble.

(b) Install base (960) and attached items on support assembly (984) using bolts (954, 957) and washers (958). Omit washers (955, 956) at this time.

(c) Adjust bolt (954) height so that cam assembly (645) is flush to contour of support assembly to within 0.03 inch over surface of cam assembly in the closed position.

(d) Measure stop bolt (954) height; remove bolt and install required number of spring washers (956) per Fig. 702. Also, install washers (955) under bolt head (954) and against base (960).

(7) Apply a light coat of grease, MIL-G-23827 to bearing I.D. and faying surfaces of guide assemblies (573, 600). Assemble spring (585) and guide assemblies (573, 600).

(8) Apply a light coat of grease, MIL-G-23827 to shank and threads of bolts (561, 588). Attach guide assembly (600) to lever assembly (624) with bolt (588), washer (594), bushing (591) and nut (597). Attach guide assembly (573) to support assembly (984) with bolt (561), washers (564, 567) and nut (570). Install bolt (561) with bolt head toward centerline of support assembly (984).

C. Assemble shaft assembly (924A) and external handle assembly (945A).

(1) Apply a light coat of grease, MIL-G-23827 to shank and threads of bolts (789) and install bolts in handle assembly (945A).

(2) Install plug (942) in shaft assembly (924A) with sealant and fillet seal plug to 0.18 inch minimum with sealant.

(3) Apply a light coat of grease, MIL-G-23827 to packing (912) and install in seal ring (915).

(4) Apply a light coat of grease, MIL-G-23827 to washers (885, 903, 909, 918), faying surfaces of shaft assembly (924A), spacer (906), seal ring (915) and bearings (900, 921) and I.D. of bearings in handle assembly (945A).

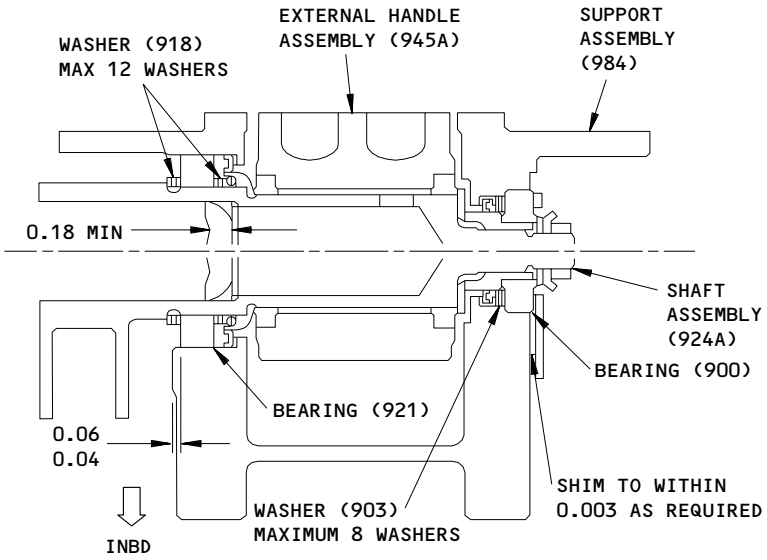
(5) Install bearing (921) with 5 washers (918) on each side on shaft assembly (924A). Install seal ring (915), spacer (906) on support assembly (984). Use care not to damage seal in support assembly (984) while installing seal ring (915).

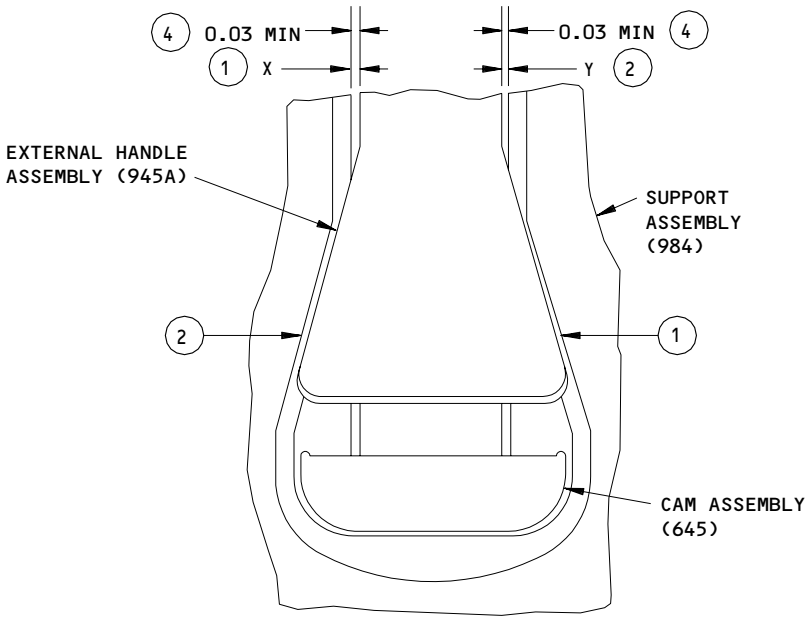
(6) Position external handle assembly (945A) and washer (909) in the cavity of support assembly (984) and install shaft assembly (924A) with attached parts. Install seven washers (903), bearing (900) on shaft assembly (924A). Install washers (882, 885) and nut (879). Tighten nut (879) finger tight to remove free play from bearing (900). Install retainer (894) and secure with bolts (888) and washers (891). Tighten bolts (888) finger tight to retain the bearing (900) in place.

(7) Install bolt (951), nut (952), washer (953). Close external handle assembly (945A) and note the height of the handle assembly. Adjust height of bolt (951) as required so that external handle assembly (945A) is flush with the contour of support assembly (984).

(8) Apply 20-50 pounds force to the external handle assembly (945A) to one side and measure gap between handle assembly and support assembly (984). Repeat the procedure with the same force ± 5 pounds on the other side. Determine the center location of the handle assembly (945A). Adjust the position of handle assembly by adding or deleting washers (903) behind bearing (900) as required up to maximum of 8 washers in place.

(9) Close handle assembly (945A) and check that there is 0.030 inch minimum gap all around handle assembly. If required, modify the centering of the handle assembly by adding or deleting washers (903). Adjust number of washers (918) between shaft assembly (924A) and bearing (921) as required so that outer race of bearing is 0.04-0.06 inch below surface of support assembly (984) (Fig. 701).





(VIEW LOOKING INBOARD)

(1) APPLY 20–50 LBS ON HANDLE ASSEMBLY (945A) AND MEASURE GAP "X"

(2) APPLY THE SAME FORCE AS (1) ±5 LBS AND MEASURE GAP "Y"

(3) GAP ADJUSTMENT = $\frac{X-Y}{2}$
ADJUST NUMBERS OF WASHER (903) AS REQUIRED. WASHER THICKNESS 0.016 INCH

(4) AFTER CENTERED POSITION IS OBTAINED, CHECK FOR 0.030 MINIMUM GAP ALL AROUND HANDLE ASSEMBLY. RELOCATE WASHERS (918) AS REQUIRED TO OBTAIN MINIMUM GAP

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

Assemble Shaft Assembly and External Handle Assembly
Figure 703

(10) Wrap lockwire around notch in pin (849) and insert pin into bushing hole in handle assembly (945A). Rotate shaft assembly (924A) as required to engage pin in slot in shaft assembly.

(11) Adjust bushing (855) to eliminate freeplay in shaft assembly (924A).

(a) Rotate shaft assembly (924A) until slot in shaft assembly contacts pin (849) and maintain this position.

(b) Install bushing (855) and retainer (852) in handle assembly (945A) and install shaft (858) thru bushing (855) into hole in shaft assembly (924A).

(c) Rotate bushing (855) and/or retainer (852) until free play in shaft assembly (924A) in minimized and shaft (858) can be removed and inserted with no interference or binding (Fig. 704).

(d) Check that the free play at the tip of the handle assembly (945A) is 0.25 inch maximum.

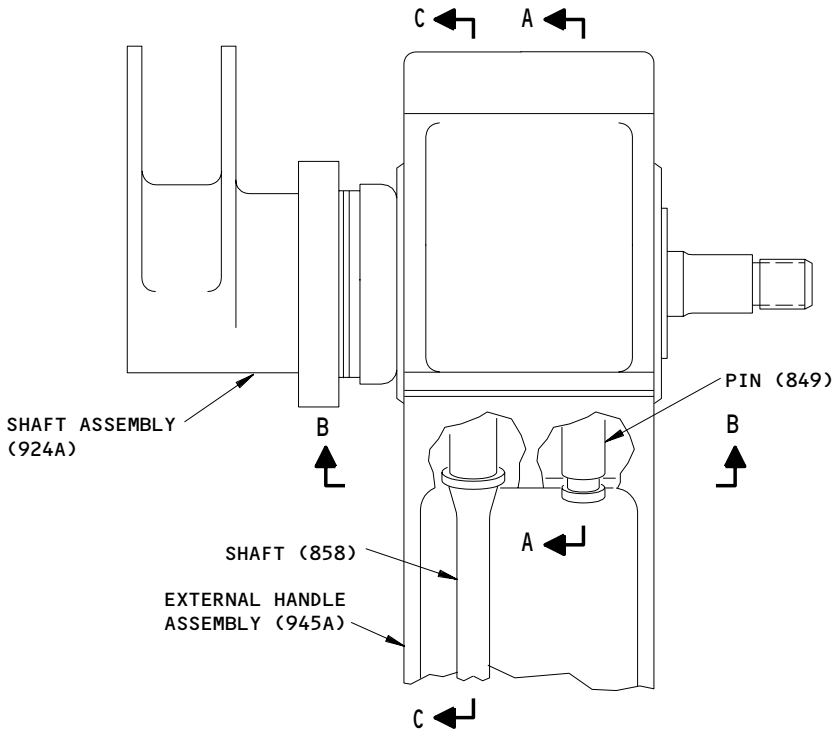
(e) Mark position of bushing (855), retainer (852) and shaft (858).

(f) Remove shaft (858), bushing (855), retainer (852) and pin (849) from handle assembly (945A). Remove lockwire from pin.

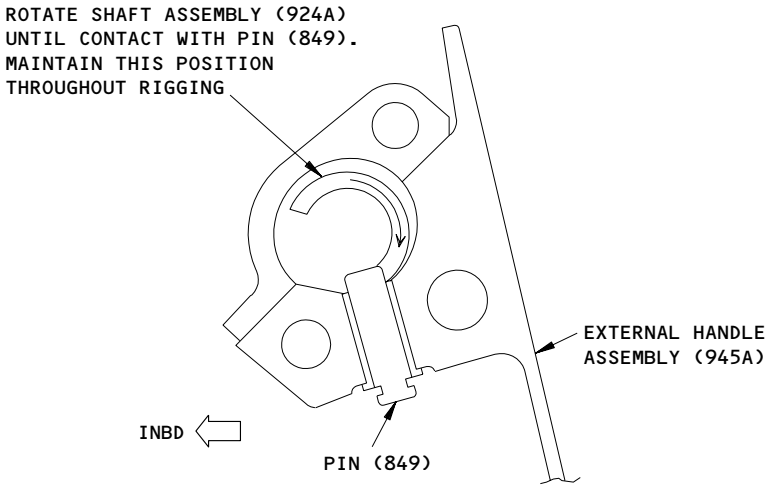
(12) Apply a light coat of grease, MIL-G-23827 to faying surfaces of pin (849) and shaft (858) and a light coat of grease, BMS 3-24 to all surfaces of bushing (855).

(13) Assemble shaft (858), washer (867) and nut (864) to rod end assembly (870) with preassembled parts.

(14) Install pin (849) in handle assembly (945A). Install retainer (852) on bushing (855) and install parts in handle assembly as marked. Install spring (861), shaft (858) and retainer (846) and secure retainer with bolt (840) and washers (843). Install spring (861) so that smaller diameter is toward centerline of shaft assembly (924A). Install shaft (858) as marked. Make sure to orient keyway on shaft (858) inboard or outboard for shaft alignment. If safety clip (831U, 833) is installed, orient keyway inboard.

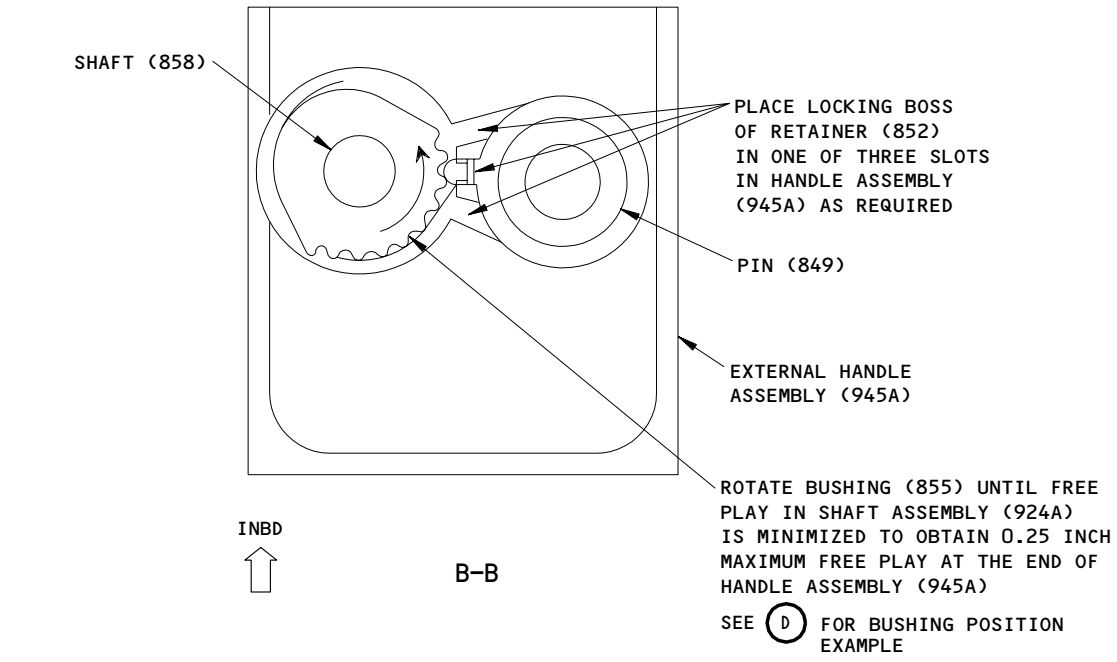


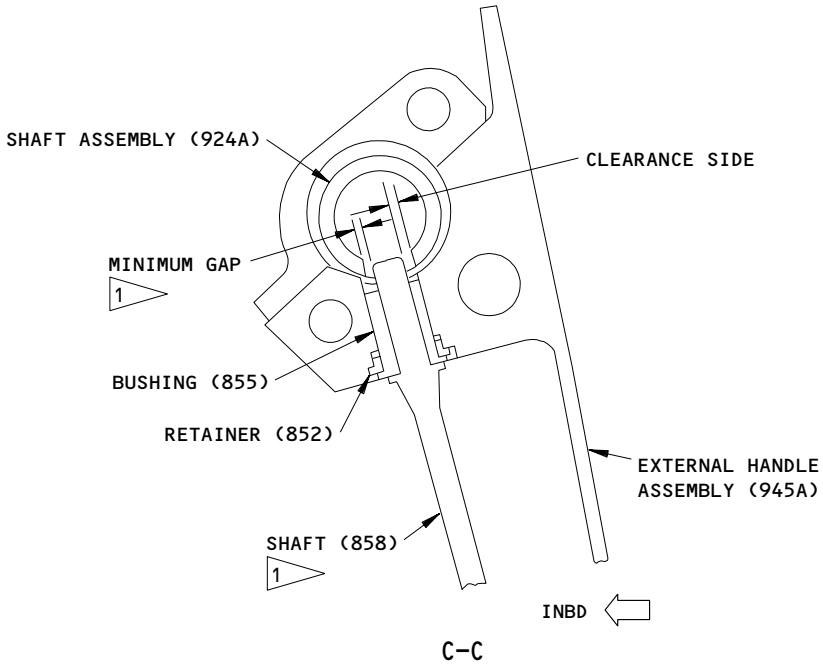
VIEW LOOKING OUTBOARD
(SUPPORT ASSEMBLY (984) OMITTED FOR CLARITY)



A-A

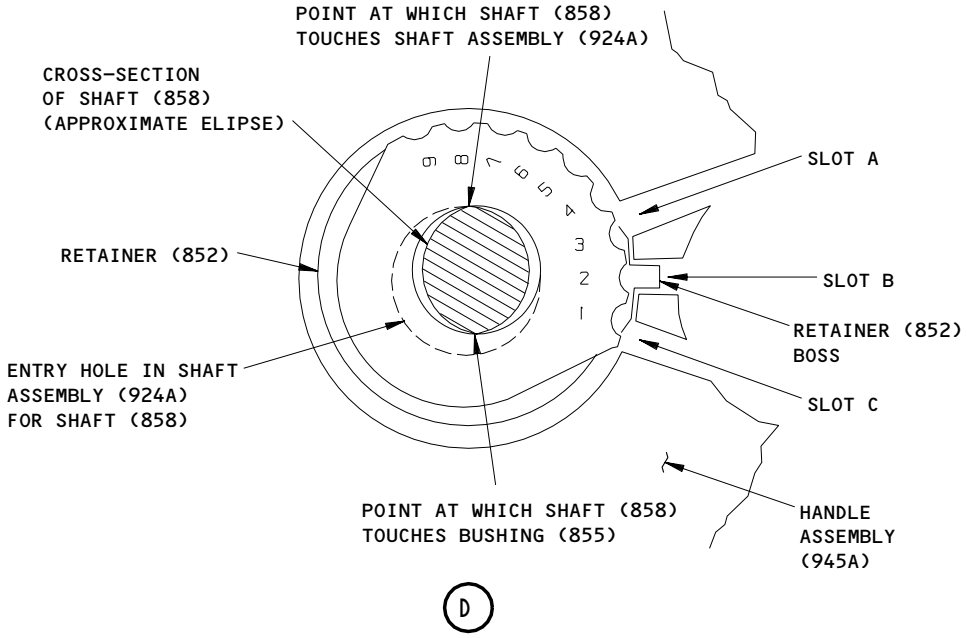
External Handle Assembly Rigging Details
Figure 704 (Sheet 1)





External Handle Assembly Rigging Details
Figure 704 (Sheet 2)

306874



D

EXAMPLE OF ADJUSTMENT OF BUSHING POSITION

NOTE: THE SLOTS IN THE HANDLE ASSEMBLY (945A) ARE 20 DEGREES APART. THE NOTCHES IN THE BUSHING (855) ARE 15 DEGREES APART.

USUALLY, A 5 DEGREE OR 10 DEGREE ADJUSTMENT IS SUFFICIENT TO LET THE SHAFT (858) MOVE FREELY.

IN THIS EXAMPLE, THE RETAINER (852) AND BUSHING (855) ARE LOCATED AS SHOWN. EACH CHANGE IS MEASURED FROM THIS LOCATION.

IF THE SHAFT (858) DOES NOT MOVE FREELY THROUGH THE BUSHING (855) AND SHAFT ASSEMBLY (924A), PROCEED AS FOLLOWS:

1) CHANGE THE POSITIONS BY 5 DEGREES. MOVE THE RETAINER (852) BOSS TO SLOT C. MOVE THE BUSHING (855) TO NOTCH 1. SEE IF THE SHAFT (858) MOVES FREELY THROUGH THE BUSHING (855).

2) IF THE SHAFT (858) STILL DOES NOT MOVE FREELY, CHANGE THE POSITIONS BY 10 DEGREES. MOVE THE RETAINER (852) BOSS TO SLOT A. MOVE THE BUSHING (855) TO NOTCH 4. SEE IF THE SHAFT (858) MOVES FREELY.

3) IF THE SHAFT (858) STILL DOES NOT MOVE FREELY, CHANGE THE POSITIONS BY 15 DEGREES. MOVE THE RETAINER (852) BOSS TO SLOT B. MOVE THE BUSHING (855) TO NOTCH 3. SEE IF THE SHAFT (858) MOVES FREELY.

4) IF THE SHAFT (858) STILL DOES NOT MOVE FREELY, CHANGE THE POSITIONS BY 20 DEGREES. MOVE THE RETAINER (852) BOSS TO SLOT C. MOVE THE BUSHING (855) TO NOTCH 2. SEE IF THE SHAFT (858) MOVES FREELY.

1 SHAFT (858) MUST BE FREE TO MOVE THRU BUSHING (855) AND SHAFT ASSEMBLY (924A) WITHOUT INTERFERENCE. MAXIMUM FREEPLAY AT GRIP END OF EXTERNAL HANDLE ASSEMBLY (945A) IS 0.25 INCH. ADJUST BUSHING (855) AS NEEDED

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

External Handle Assembly Rigging Details
Figure 704 (Sheet 3)

(15) Apply a light coat of grease, MIL-G-23827 to threads and shank of bolt (825). Secure preassembled levers (832B, 832L, 832M, 834A, 837A, 837B) to handle assembly (945) with bolt (825), bushings (831) and nut (828). Install bolt (825) with bolt head towards outside of handle assembly.

(16) Close handle assembly (945A) and check position of handle assembly relative to support assembly (984). Adjust the length of shaft (858) in full turns as required so that roller assembly (816) just contact cam assembly (645) and shaft (858) disconnected from shaft assembly (924A) when the handle assembly (945A) is closed. Turn shaft (858) 2 full turns into rod end assembly (870). Check that there is no stored torque in spring (861) and tighten nut (864).

NOTE: Adjust shaft (858) in full turns so the position of shaft established per step (11) is not disturbed.

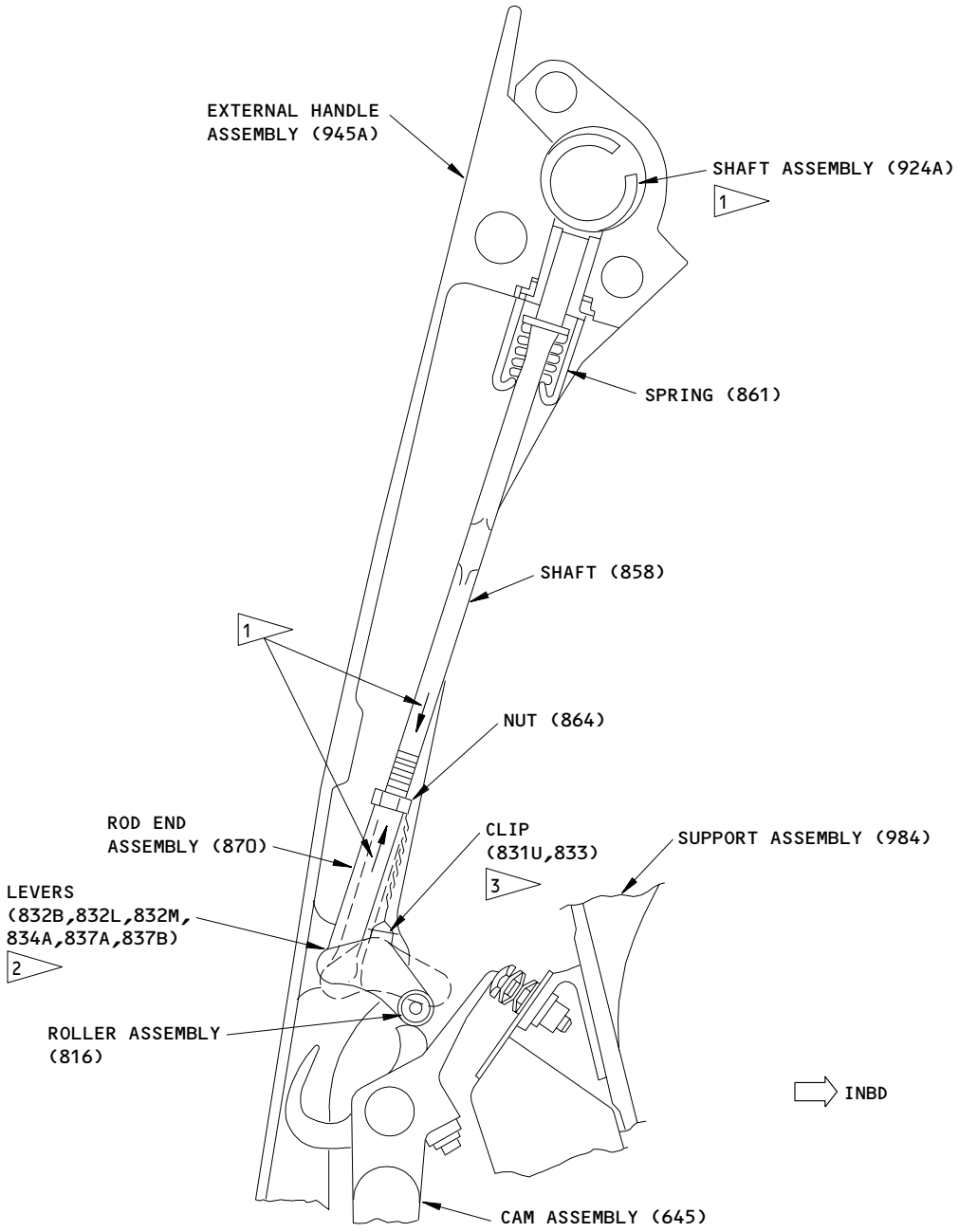
(17) Attach clip (831U, 833), if applicable, to shaft (858) with lockwire. Install lockwire using double-twist method such that it goes through washer (867), and nut (864). Make sure that the clip has free play and does not limit full motion of shaft.

(18) Install shim (798), support (801), washers (792), nuts (795) on handle assembly (945A). Adjust height of stop bolt (951) then adjust thickness of shim (798) so that roller assembly (780) just contacts cam assembly (645) when the handle assembly (945A) is closed. Tighten nut (952) to secure bolt (951). Also check that handle assembly is flush to within 0.03 inch with support assembly (984). Remove parts (792 thru 801).

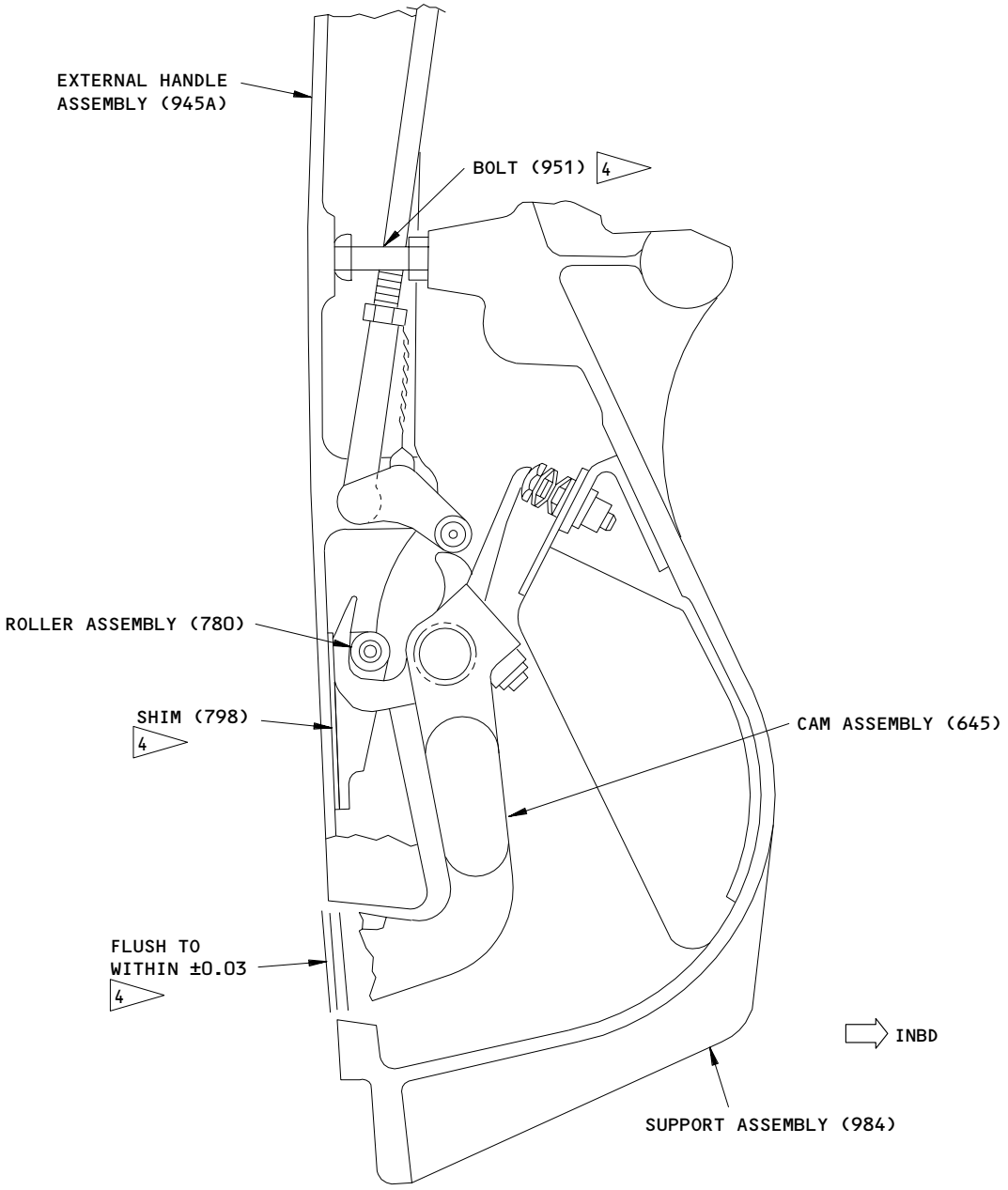
(19) Apply a light coat of grease, MIL-G-23827 or BMS 3-24 to faying surfaces of handle assembly (945A) and support (801). Wipe surfaces with dry cloth to remove grease (do not use solvent). Install support (801) and shim (798) adjusted per step (17) on handle assembly (945A) with sealant on faying surfaces and secure with washers (792) and nuts (795). Apply a bead of sealant to threads of bolts (789) before installing washers (792) and nut (795). Wipe off excess sealant.

(20) Remove bolts (888), washers (891) and retainer (894) and tighten nut (879) to 80-120 lb-in.

(21) Check position of bearing (900). If bearing (900) is below support assembly (984) surface, fill cavity with washers (903) to 0.016 inch above housing surface. If bearing (900) is above support assembly (984) surface, prepare shim (897) with thickness equal to or up to 0.016 inch less than the height of the bearing (900) above support assembly surface.



Final Adjustment of External Handle Assembly
Figure 705 (Sheet 1)



Final Adjustment of External Handle Assembly
Figure 705 (Sheet 2)

1 WITH SHAFT (858) DISENGAGED FROM SHAFT ASSEMBLY (924A), ROTATE SHAFT IN FULL TURNS INTO ROD END ASSEMBLY (870) UNTIL ROLLER ASSEMBLY (816) CONTACTS CAM ASSEMBLY (645). CHECK THAT THERE IS NO STORED TORQUE IN SPRING (861). TURN SHAFT (858) 2 ADDITIONAL TURNS INTO ROD END ASSEMBLY (870) AND TIGHTEN NUT (864)

2 INSTALL LEVERS (832B,832L,832M,834A,837A, 837B) AS SHOWN

3 MAKE SURE THAT THE CLIP (831U,833) AND LOCKWIRE DO NOT LIMIT FULL MOTION OF SHAFT (858)

4 ADJUST BOLT (951) AND SHIM (798) SO THAT ROLLER ASSEMBLY (780) CONTACTS CAM ASSEMBLY (645) WHEN THE HANDLE ASSEMBLY (945A) IS CLOSED AND HANDLE ASSEMBLY IS FLUSHED WITH SUPPORT ASSEMBLY (984) TO WITHIN ±0.03

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

Final Adjustment of External Handle Assembly
Figure 705 (Sheet 3)

W35478

(22) Apply a light coat of grease, MIL-G-23827 or BMS 3-24 to faying surfaces of retainer (894) and support assembly (984). Wipe off grease with dry cloth (do not use solvent). Assemble retainer (894) and shim (897) to support assembly (984) with wet sealant on faying surfaces. Install bolts (888) and washers (891) with wet sealant.

D. Assemble shaft (456) and associated components (Fig. 706).

(1) Assemble support assembly (531), sector assembly (438).

(a) Apply a light coat of grease, BMS 3-24 to OD of bushings (555, 556) and install bushings in support assembly (984).

(b) Apply a light coat of grease, BMS 3-24 to shank and threads of bolts (537).

(c) Position support assembly (531) on handle support assembly (984) and install bolts (537), washers (540, 541), bushing (558) and nuts (543). Tighten nuts (543) finger-tight.

(d) Apply a light coat of grease, MIL-G-23827 to splines of shaft (456) and lever assembly (420) and to washers (459) and spring (465). Install one washer (459) and spring (465) on shaft (456).

(e) Position sector assembly (531) and install shaft (456) thru support assemblies (531, 984). Install one washer (459) and lever assembly (420) on shaft (456) with split line in lever assembly aligned with missing tooth in shaft. Apply a light coat of grease, MIL-G-23827 to shank and threads of bolt (411) and install bolt (411), washer (414) and nut (417).

(f) Apply a light coat of grease, BMS 3-24 to shank and threads of bolt (432). Secure sector assembly (438) with bolt (432), washer (435). Tighten bolt (432) just enough to remove play between sector assembly and shaft (456).

(g) Check distance between sector assembly (438) and support assembly (531) and add or delete washers (541) between bushings (555, 556) and support assembly (531) to obtain dimension shown (Fig. 701).

(h) Tighten nuts (543) and measure distance between nut (543) and end of bolt (537) and add washers (541) under nut as required to obtain 0.17 inch maximum distance.

(2) Apply a light coat of grease, MIL-G-23827 to shank and threads of bolt (348). Install piston assembly (360) on sector assembly (438) and secure with bolt (348), washer (351A), bushing (354) and nut (357).

(3) Install washers (345) and spring (342) in housing assembly (333).

(4) Apply a light coat of grease, MIL-G-23827 to shank and threads of bolt (321). Mate piston assembly (360) and housing assembly (333) and secure housing assembly to support assembly with parts (321 thru 330).

(5) Apply a light coat of grease, MIL-G-23827 to splines of adapter (408). Install adapter with preassembled handle assembly (378) on shaft (456) at dimension indicated in Fig. 706.

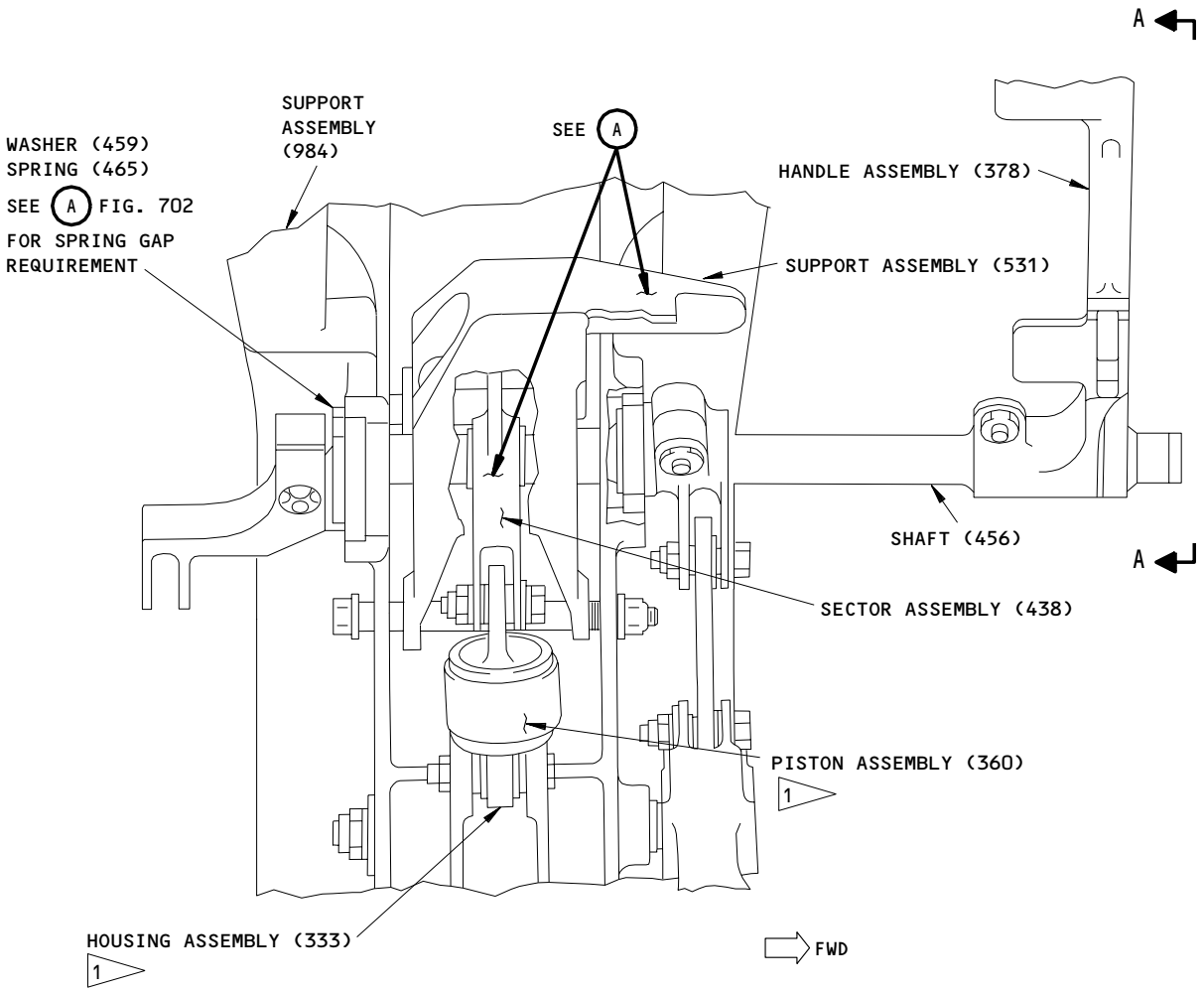
(6) Apply a light coat of grease, MIL-G-23827 to shank and threads of bolt (399) and install parts (399 thru 405). Install snapring (369).

NOTE: Final adjustment of handle assembly (378) will be done during installation on airplane.

(7) Apply a light coat of grease, MIL-G-23827 to shank and threads of bolt (225). Position lever assembly (201A) and install parts (225 thru 231) to secure. Install bolt (225) with bolthead away from lever assembly and washer (228) under bolthead.

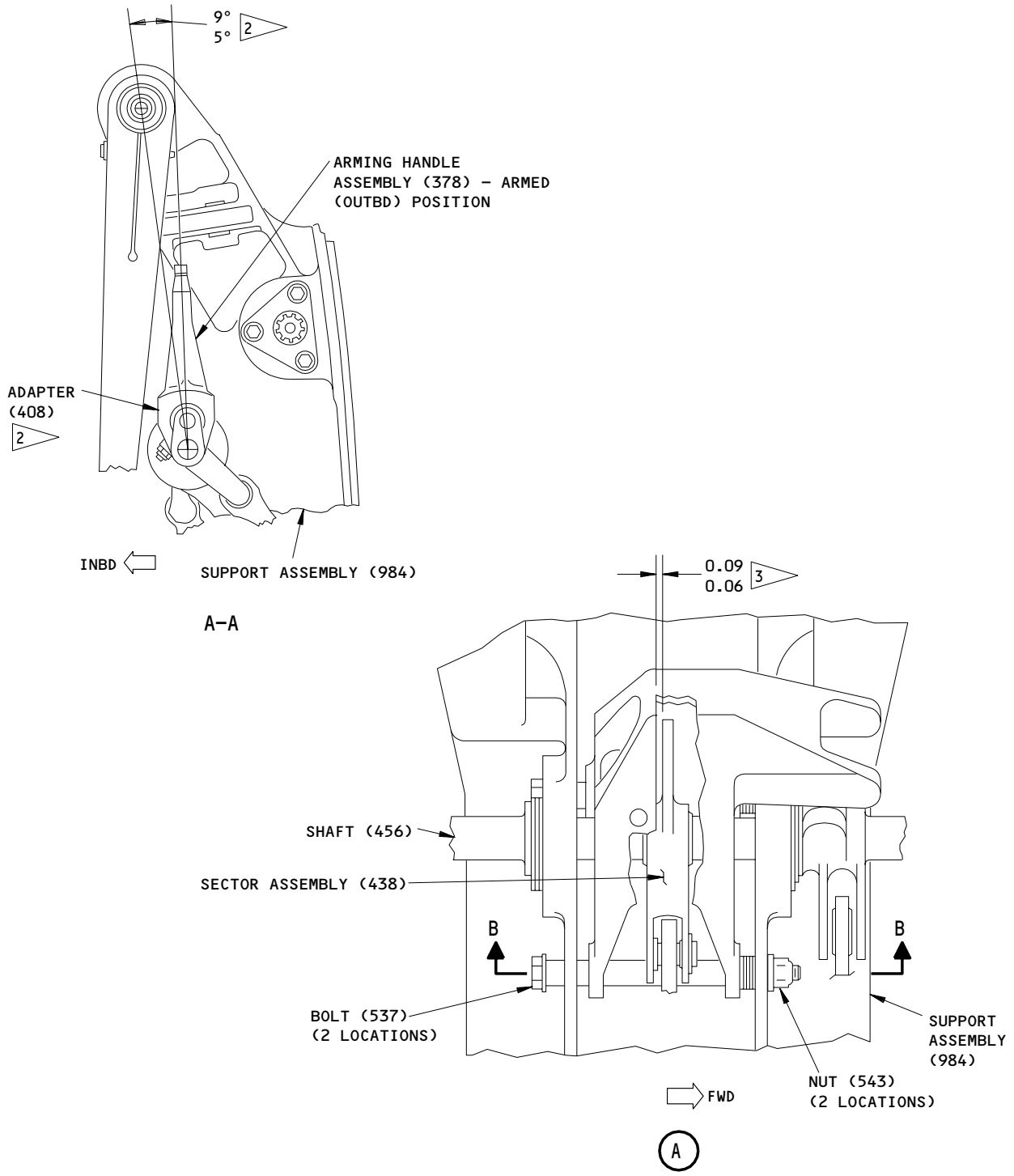
(8) Apply a light coat of grease, MIL-G-23827 to shank and threads of bolts (189, 234). Position link assembly (246) and secure with parts (189 thru 198, 234 thru 243).

(9) Apply a light coat of grease, MIL-G-23827 to shank and threads of bolt (300) and to splines of lever assembly (309).



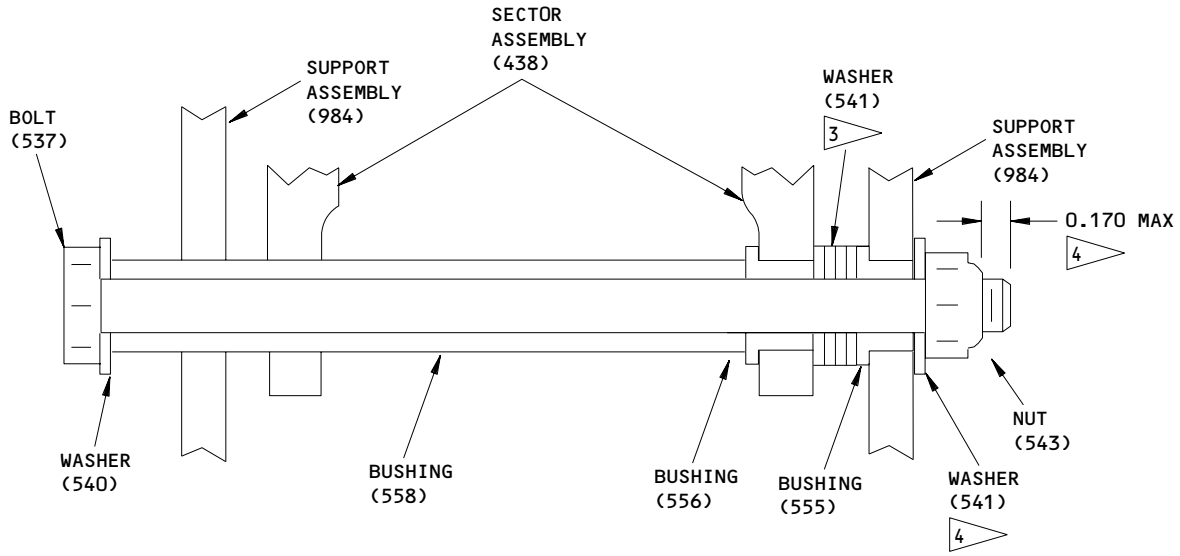
Assembly Details – Shaft and Arming Handle
Figure 706 (Sheet 1)

306878



NOTE: WASHER (541) THICKNESS = 0.016

Assembly Details – Shaft and Arming Handle
Figure 706 (Sheet 2)



B–B

FWD

NOTE: WASHER (541) THICKNESS IS 0.016

1. ALIGN PISTON ASSEMBLY (360) AND HOUSING ASSEMBLY (333) BY CHANGING QUANTITY OF WASHER (459) ON SHAFT (456)
2. WITH ARMING LINKAGE IN ARMED (OUTBOARD) POSITION, POSITION ADAPTER (408) AS SHOWN
3. ADJUST NUMBERS OF WASHERS (541) AS REQUIRED TO OBTAIN DIMENSION SHOWN (2 LOCATIONS)
4. ADD WASHERS (541) AS REQUIRED TO OBTAIN MAXIMUM DIMENSIONS SHOWN. USE A MAXIMUM OF TWO WASHERS (541) UNDER EACH NUT (543) (2 LOCATIONS)

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

Assembly Details – Shaft and Arming Handle
Figure 706 (Sheet 3)

W29056

(10) Install lever assembly (309) on shaft (456). Secure lever assembly with parts (300 thru 306).

E. Assemble stop assembly (726, 729) and lever assembly (672) (Fig. 707).

(1) Apply a light coat of grease, MIL-G-23827 on spacers (705, 708, 711) and install 2 spacers (708), 1 spacer (711) and 1 spacer (705) on shaft (723A).

(2) Apply a light coat of grease, MIL-G-23827 on splines of crank (693) and install crank on shaft (723A) at about 15 degrees inboard to the vertical line of the support assembly (984) with bolthead inboard.

(3) Apply a light coat of grease, MIL-G-23827 on shank and threads of bolt (675) and install parts (674 thru 690) on lever assembly (672).

NOTE: Use an appropriate 0.437 inch long bushing or spacer between lugs of lever assembly (672) for handling.

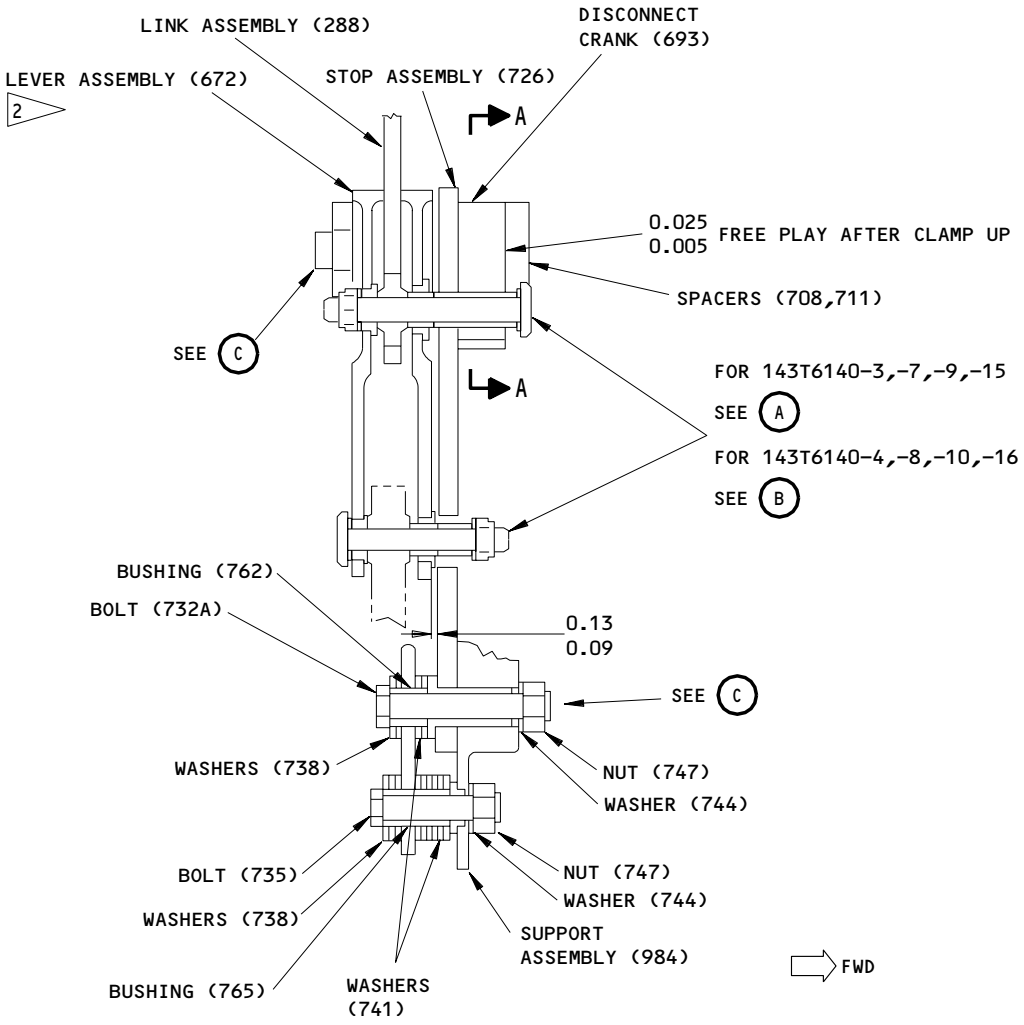
(4) Apply a light coat of grease, MIL-G-23827 to shank and threads of bolt (270, 271) and secure link assembly (288) to lever assembly (672) with parts (270 thru 285).

(5) Install stop assembly (726, 729).

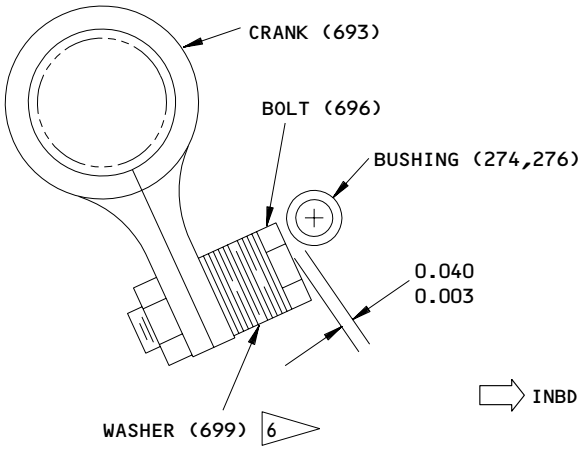
(a) Slide stop assembly (726, 729) and lever assembly (672) on shaft (723A).

(b) Secure stop assembly (726, 729) to support assembly (984) with parts (732A thru 747, 762, 765) as follows:

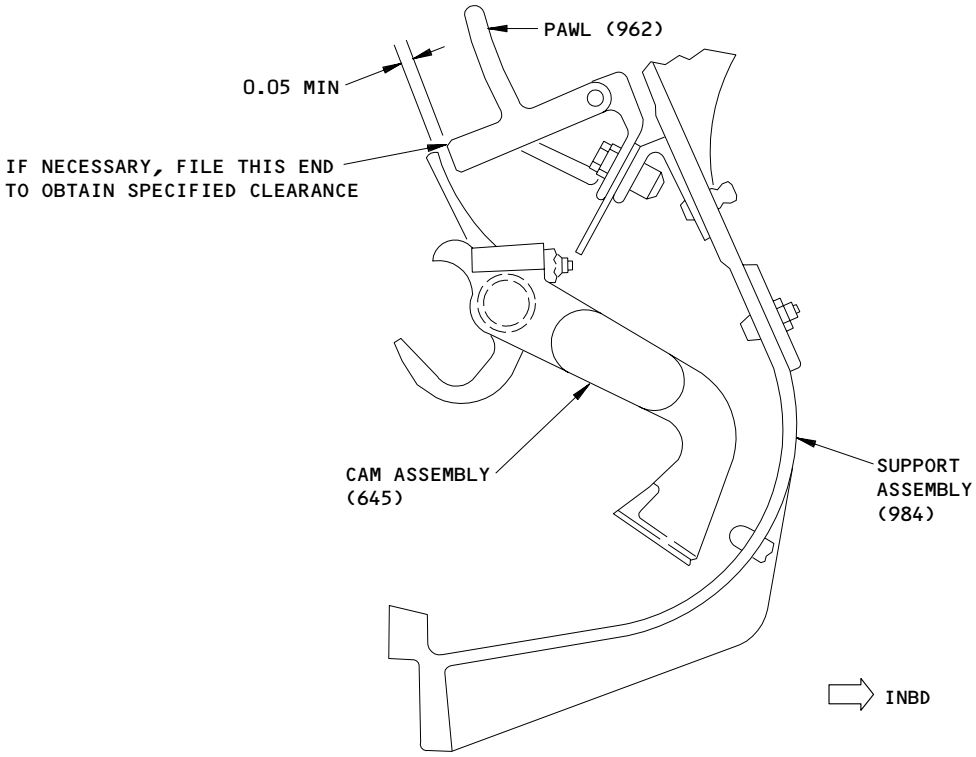
1) Apply a thin coat of grease, MIL-G-23827 to shank and threads of bolts (732A, 735).



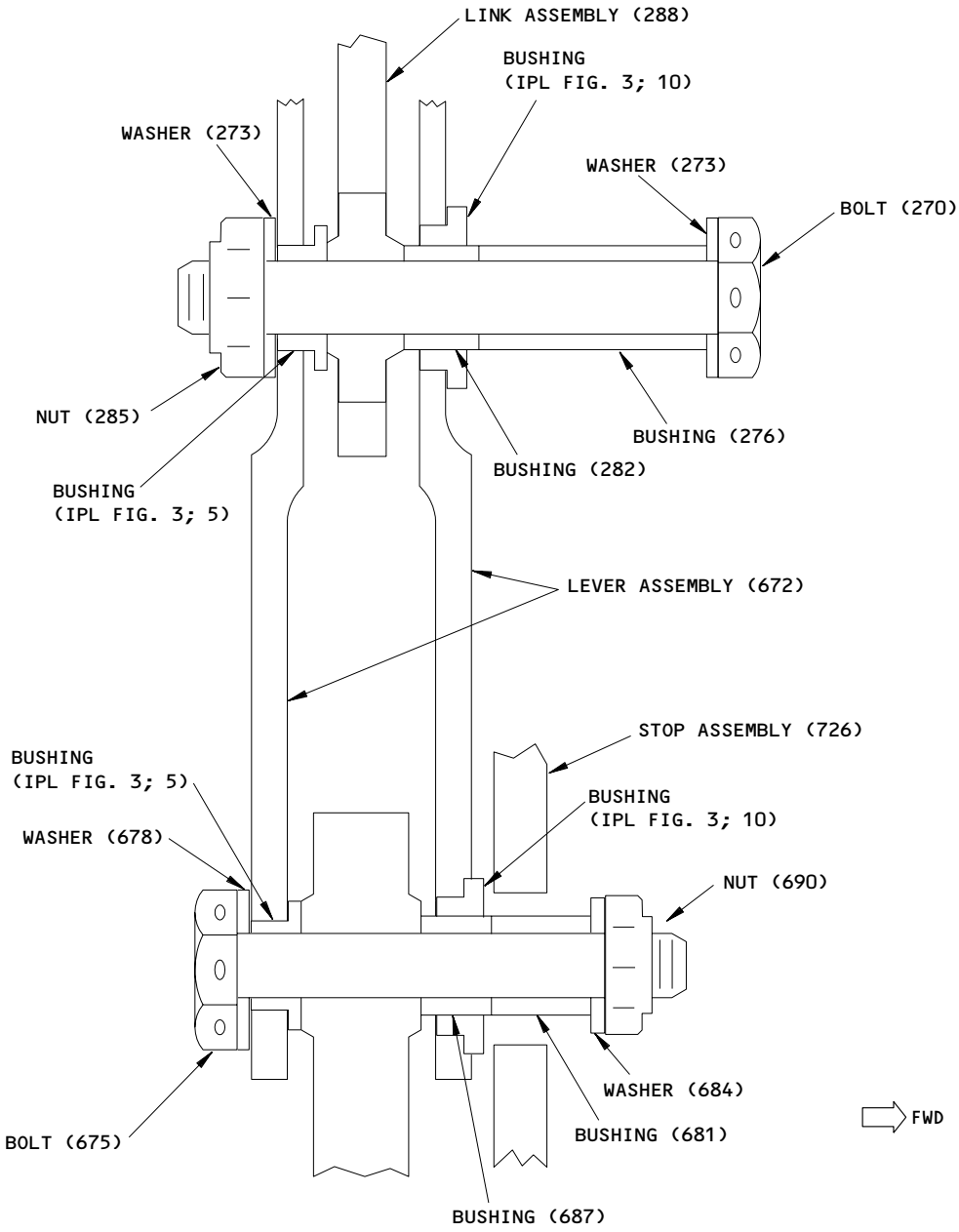
143T6140-3,-4,-7 thru -10,-15,-16
Assembly Details - Stop Assembly
Figure 707 (Sheet 1)



A-A



143T6140-3,-4,-7 thru -10,-15,-16
Assembly Details - Stop Assembly
Figure 707 (Sheet 2)

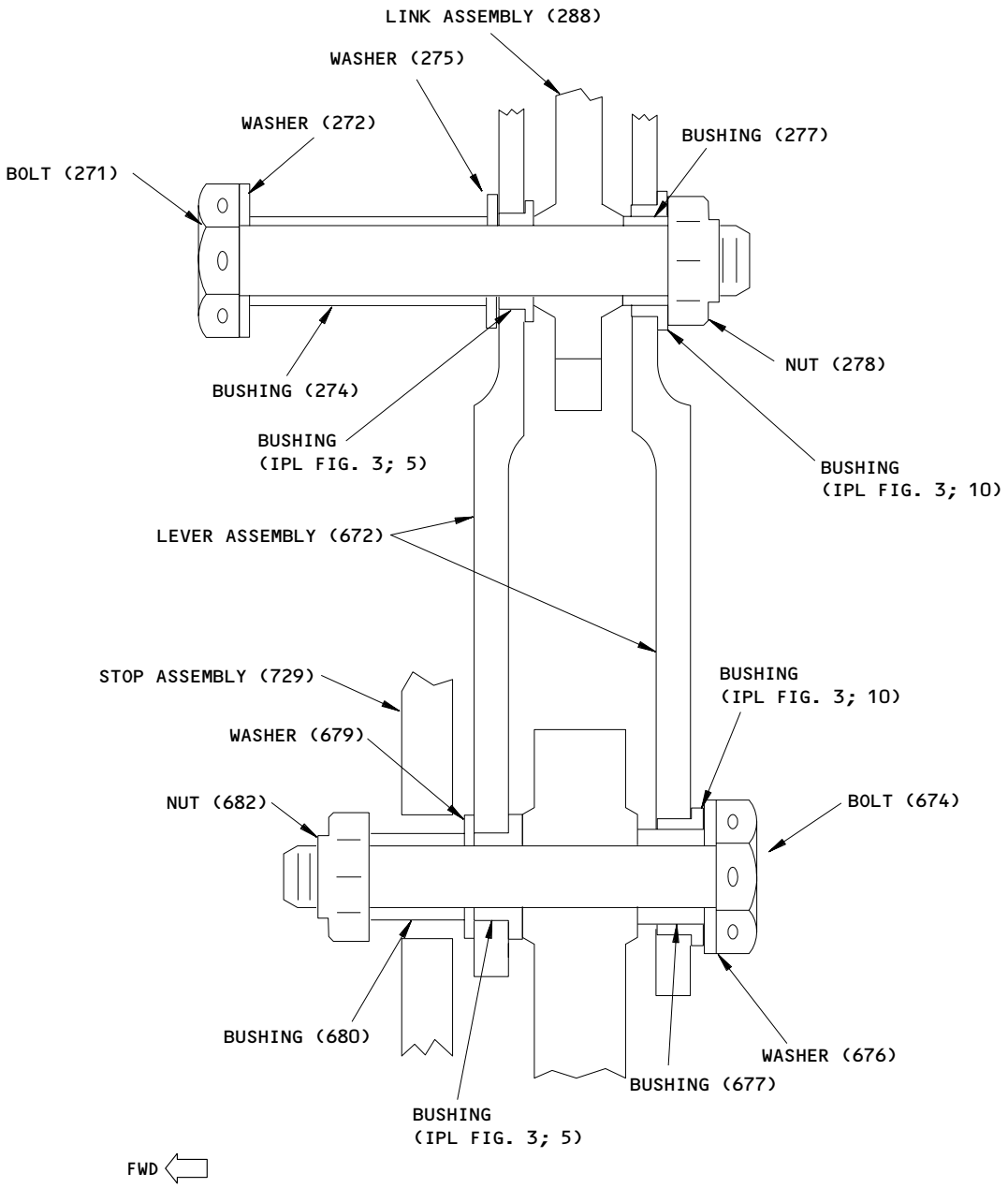


143T6140-3,-7,-9,-15

(A)

143T6140-3,-4,-7 thru -10,-15,-16
Assembly Details - Stop Assembly
Figure 707 (Sheet 3)

W29205

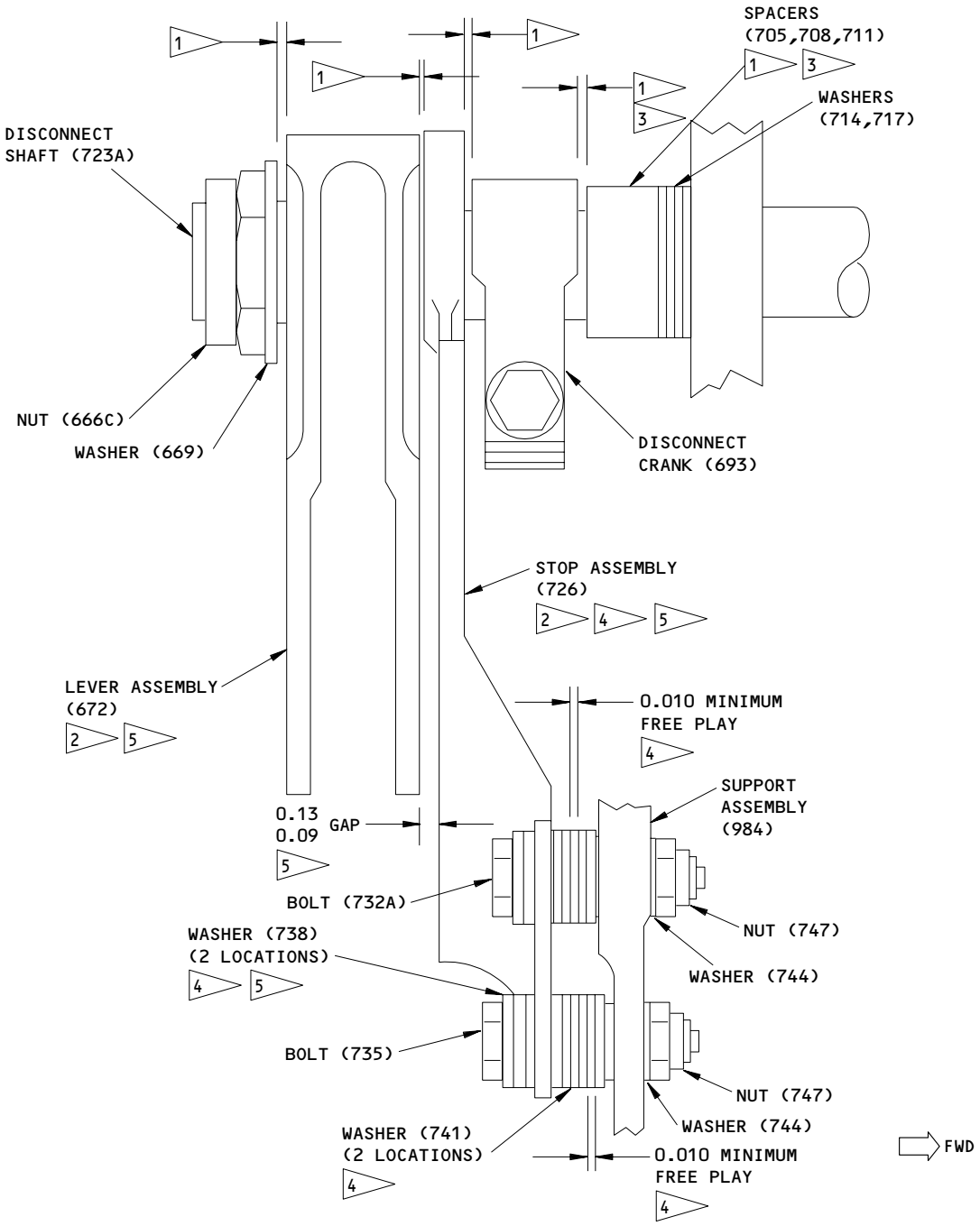


143T6140-4,-8,-10,-16

(B)

143T6140-3,-4,-7 thru -10,-15,-16
Assembly Details - Stop Assembly
Figure 707 (Sheet 4)

W29234



LINK ASSEMBLY AND OTHER STRUCTURES ARE OMITTED FOR CLARITY
143T6140-3,-7,-9,-15 SHOWN
143T6140-4,-8,-10,-16 OPPOSITE

C

143T6140-3,-4,-7 thru -10,-15,-16
Assembly Details - Stop Assembly
Figure 707 (Sheet 5)

1 ADJUST QUANTITY OF SPACERS (705,708,711) AS REQUIRED, TO PRODUCE 0.015–0.055 AXIAL FREE PLAY PRIOR TO CLAMP UP AT FOUR LOCATIONS NOTED

2 AFTER CLAMP UP, 0.01–0.03 AXIAL FLOAT IS REQUIRED

3 AFTER CLAMP UP, 0.005–0.025 FREE PLAY IS REQUIRED

4 MINIMUM FREE PLAY FOR THE STOP ASSEMBLY (726) IS 0.010. USE THE MAXIMUM NUMBER OF WASHERS (741) POSSIBLE

5 ADJUST QUANTITY OF WASHERS (738,741), AS REQUIRED, TO GET A GAP OF 0.09–0.13

6 ADD OR SUBTRACT WASHERS (699) TO OBTAIN DIMENSION SHOWN (WASHER THICKNESS 0.032 INCH) MAXIMUM 14 WASHERS

ITEM NUMBERS REFER TO IPL FIG. 1 UNLESS SHOWN DIFFERENTLY

ALL DIMENSIONS ARE IN INCHES

143T6140-3,-4,-7 thru -10,-15,-16
Assembly Details - Stop Assembly
Figure 707 (Sheet 6)

W35581

2) Install bolt (732A), bushing (762), 2 washers (738) between bolt head and stop assembly (726), 15 washers (741) between stop assembly and support assembly (984), 1 or 2 washers (744) and nut (747).

3) Install bolt (735), bushing (765), 3 washers (738) between bolthead and stop assembly (726), 20 washers (741) between stop assembly and support assembly (984), 1 or 2 washers (744) and nut (747).

4) Check that distance between stop assembly (726, 729) and lever assembly (672) is 0.09 to 0.13 inch and there is no preload of stop assembly against crank (693) or lever assembly (672). Adjust number of washers (738, 741) as required. Stack of washers (741) must have 0.010 minimum freeplay at both fastener locations.

(c) Prior to clamp up, check that free play at the following four locations is 0.015-0.055 inch. Adjust quantity of spacers (708, 711) as required.

1) between spacer (705) and crank (693)

2) between crank (693) and stop assembly (726, 729)

3) between stop assembly (726, 729) and lever assembly (672)

4) between lever assembly (672) and washer (669).

(d) After clamp up, check that free play between spacer (705) and crank (693) is 0.005-0.025 inch. Adjust quantity of spacers (708, 711) and washers (714) as required.

(e) Install washer (669), nut (666C). Tighten nut just enough to clamp lever assembly (672). After clamp up, check that lever assembly (672) axial float is 0.01-0.03 inch.

(6) Apply a thin coat of grease, MIL-G-23827 to shank and threads of bolt (258) and secure link assembly (288) to lever assembly (309) with parts (258 thru 267).

(7) With handle assembly (378) in armed position (handle assembly (378) moved outboard), check that there is 0.003 to 0.040 clearance between bolt (696) head and bushing (274, 276). Adjust as follows to obtain dimension indicated.

(a) If the gap is too wide or the bolt (696) head push the lever assembly (672) up too far, adjust as follows:

1) Disconnect link assembly (288) from lever assembly (309) by removing parts (258 thru 267).

2) Remove nut (666C), washer (669) and lever assembly (672) with attached link assembly (288).

3) Remove stop assembly (726, 729) by removing parts (732 thru 747, 762, 765). Note numbers of washers (738, 741) at each fastener locations.

4) Remove crank (693) and rotate one tooth at a time in the required direction to obtain close approximation of required dimension.

5) Reinstall parts removed per step 1), 2) and 3).

(b) For fine adjustment, transfer washers (699) from under bolthead (696) to under nut (702) as required. Tighten nut (702) after the adjustment is completed.

NOTE: Removing more than six washers (699) from under bolthead (696) will cause bolt (696) to strike bushing (274, 276) off-center.

(8) Tighten nut (666C); verify that nut run-on torque is 90-400 lb-in. If nut does not meet run-on torque requirement, replace nut. Tighten nut to 1700-2150 lb-in.

(9) Check that clearance between pawl (962) and cam assembly (645) after rigging disconnect crank (693) is a minimum of 0.05 inch. If necessary, file end of pawl (962) to achieve clearance (Fig. 707).

F. Assemble lever assembly (489) (Fig. 708).

(1) Rotate handle assembly (378) inboard (disarmed position) and maintain this position throughout step (a) thru (i).

(a) Install lever assembly (489), spacers (483) and pin (477) on support assembly (531). Do not install cotter pin (471), washers (474, 480) or spring (486) at this time.

(b) Apply a light pressure at the pivot point of lever assembly (489) in the direction tending to close the gap between lever assembly (489) and sector assembly (438). Note the distance of the gap.

(c) Add washers (480) between support assembly (531) and spacer (483) as required to obtain dimension between lever assembly (489) and sector assembly (438) indicated.

(d) Add washers (480) on the cotter pin side to fill gap between spacer (483) and support assembly (531). Do not use excessive amount of washers (480) or binding of lever movement will result.

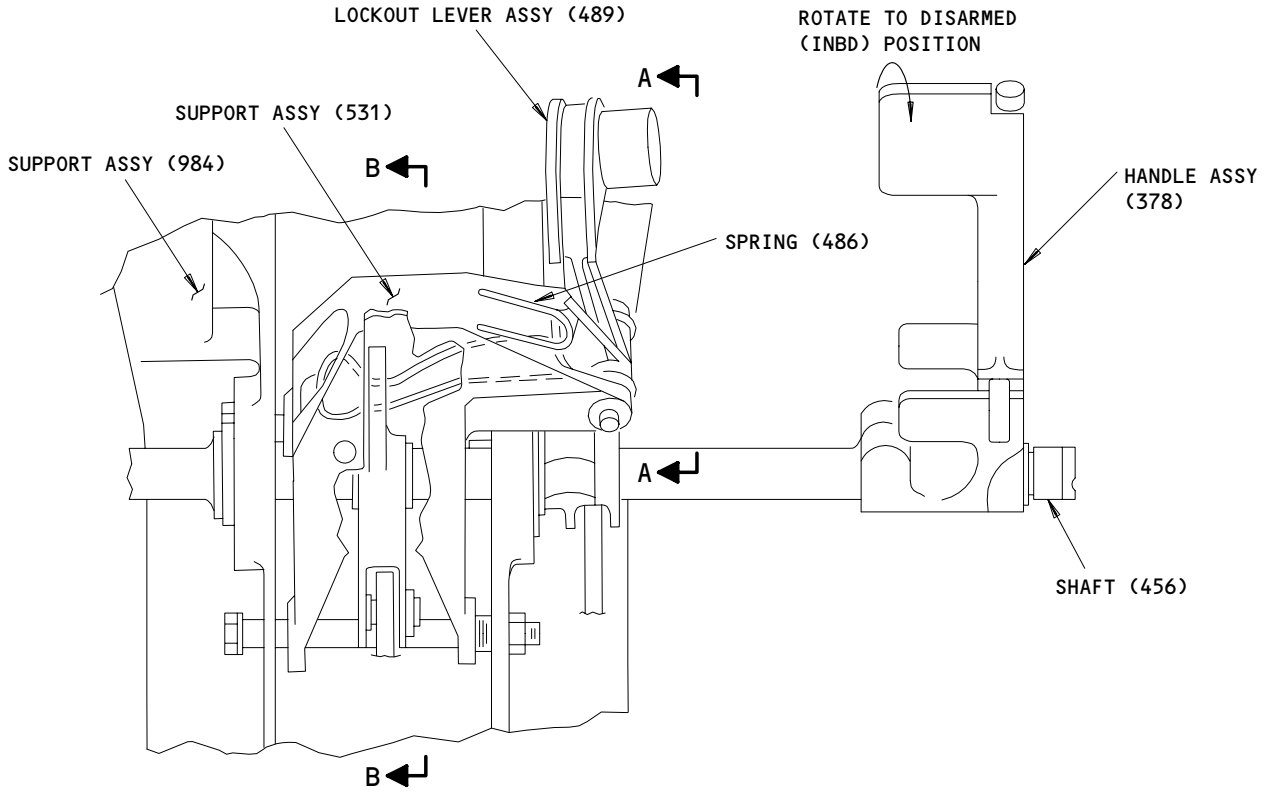
(e) Note amount of washers (480) at each location and remove parts installed in step (a).

(f) Apply wipe-on primer to spacer (483) (F-19.45; Ref 20-41-01) then apply a thin coat of grease, BMS 3-24 to O.D. of spacers (483).

(g) Install lever assembly (489), spring (486), spacers (483), washers (480) noted per step (e) and install pin (477).

(h) Recheck dimensions and adjust as required then install washer (474) and cotter pin (471). Install cotter pin per 20-50-02.

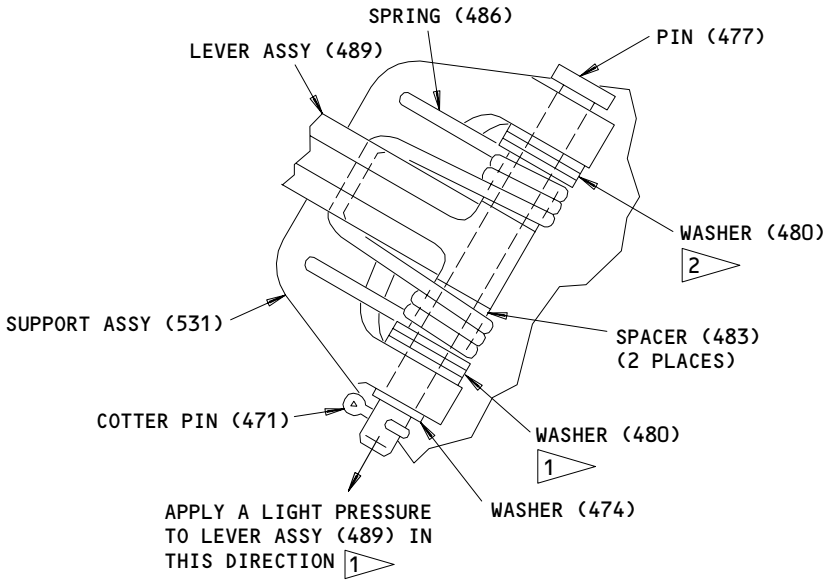
(i) Install setscrews (528) and adjust to dimensions shown.



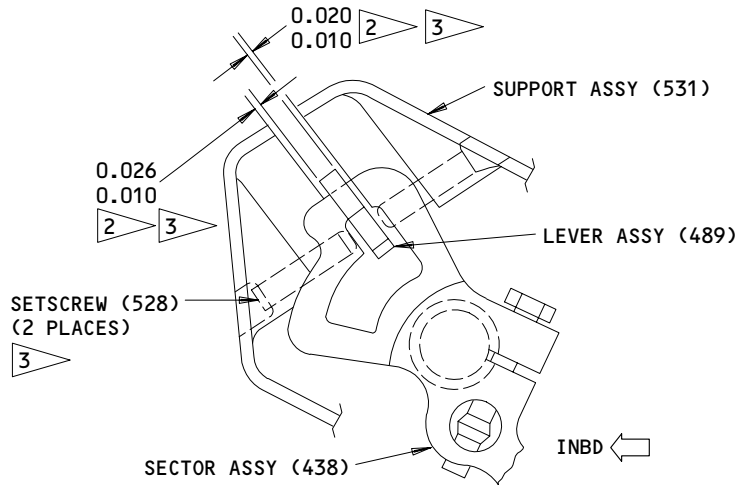
(VIEW LOOKING OUTBD)

ITEM NUMBERS REFER TO IPL FIG. 1

Assembly Details - Lockout Lever Assembly
Figure 708 (Sheet 1)



A–A



B–B

1 ADD WASHER (480) THIS SIDE TO OBTAIN SPECIFIED GAP BETWEEN SECTOR ASSY (438) AND LEVER ASSY (489). APPLY A LIGHT PRESSURE TO THE LEVER ASSY PIVOT POINT IN THE DIRECTION TENDING TO CLOSE THE GAP WHILE MEASURING

2 ADD WASHER (480) THIS SIDE TO FILL GAP BETWEEN SPACER (483) AND SUPPORT ASSY (531). CHECK THAT WASHERS DO NOT CAUSE BINDING IN LEVER ASSY (489) MOVEMENT (CHECK WITH SPRING (486) REMOVED)

3 ADJUST SETSCREWS (528) TO OBTAIN CLEARANCES SHOWN BETWEEN SETSCREWS AND LEVER ASSY (489)

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

Assembly Details – Lockout Lever Assembly
Figure 708 (Sheet 2)

G. Push lever assembly (489) toward center line of support assembly (984) and rotate handle assembly (378) from one position to the other and back. Check that spring (342) is preloaded in both positions. Add washer (345) as required such that 7-11 lbs. force is required to move handle assembly from one position to the other. Also check that there is no free play at each extreme position (lever assembly (672) resting against stop assembly (726, 729)).

H. Assemble shaft assembly (174) and inside handle assembly (141 , 141B, 142A).

(1) Apply a light coat of grease, MIL-G-23827 to shank and threads of bolt (96) and install bolts (96) and washer (99).

(2) Apply a light coat of grease, MIL-G-23827 to washers (177, 180), spring (183), and faying surfaces and splines of shaft assembly (174). Install washer (177) then install three washers (180) and one spring washer (183) with spring washer located between washers (180) on shaft assembly (174).

(3) Install shaft assembly (174) on support assembly (984) and rotate to approximate angular position as shown (Fig. 709).

(4) For handle assemblies without clutch mechanism (IPL Fig. 1) (Fig. 711)

(a) Install screw (165), washer (168), and nut (171) on adapter (171C). Do not tighten nut (171) up against adapter (162).

(b) Apply a light coat of grease, MIL-G-23827, to splines of handle assembly (141), spacer (159) and adapter (171C).

(c) Install spacer (159), handle assembly (141) and adapter (171C) on shaft assembly (174). Tighten screw (165).

NOTE: Final adjustment will be done upon installation on airplane.

(5) For handle assemblies with clutch mechanism (IPL Fig. 1, Fig. 6) (Fig. 711)

(a) Install screw (160C, IPL Fig. 1), washer (160E, IPL Fig. 1), and nut (160G, IPL Fig. 1) on adapter (160J, IPL Fig. 1). Do not tighten nut up against adapter.

(b) Assemble handle assembly (141B, 142A, IPL Fig. 1; 1, 5, IPL Fig. 6) by installing pawl assembly (55A, IPL Fig. 6) with washers (75, IPL Fig. 6) into the housing (85, IPL Fig. 6) with pin (50, IPL Fig. 6). Lock the pawl assembly (55A, IPL Fig. 6) into position with spring pin (45, IPL Fig. 6). Install spring pin with a light coat of MIL-G-23827 grease.

(c) Install spring (80, IPL Fig. 6) with grease, BMS 3-24, and adjust spring to obtain dimension shown in Fig. 712.

(d) Apply a light coat of grease, MIl-G-23827, to splines of handle assembly (141B, 142A, IPL Fig. 1; 1, 5, IPL Fig. 6), spacer (159, IPL Fig. 1), bearings (159N, IPL Fig. 1), clutch assembly (148, 148A, IPL Fig. 1), and adapter assembly (160, IPL Fig. 1).

(e) Install clutch assembly (148, 148A, IPL Fig. 1), spacer (159, IPL Fig. 1), bearings (159N, IPL Fig. 1), spacer (149, IPL Fig. 1), handle assembly (141B, 142A, IPL Fig. 1; 1, 5, IPL Fig. 6), and adapter assembly (160, IPL Fig. 1) on shaft assembly (174, IPL Fig. 1). Tighten screw (160C, IPL Fig. 1).

NOTE: FInal adjustment will be done upon installation on airplane.

(6) Check that there is a 0.003-0.020 inch clearance between waves of spring washer (183) and washers (180). Remove parts and adjust number of washers (180) as required.

(7) Apply a light coat of grease, MIL-G-23827 to shank and threads of bolts (132, 150, as applicable). Install parts (132 thru 138) on handle assembly (141) and parts (150 thru 156) on spacer (159). Tighten nuts (138, 156) finger-tight.

NOTE: Final tightening of nuts (138, 156) will be done upon installation on airplane.

I. Assemble lug assemblies (30, 57) (Fig. 709).

(1) With external handle assembly (945A) closed and latched (cam assembly (645) flushed with support assembly (984)), rotate shaft assembly (174) to dimension specified and rotate shaft assembly (924A) to the hard over position toward external handle assembly closed.

(2) Install preassembled lug assemblies (30, 57). Secure lug assembly (30) to shaft assembly with parts (6A thru 15) and secure lug assembly (57) to shaft assembly with parts (18 thru 27). Tighten nuts (15, 27) finger-tight.

(3) Install and adjust the snubber assembly (75) (Fig. 709A).

(a) Attach the snubber assembly (75) to the handle support assembly (984) with the bolt (81), washers (84) and nut (87).

(b) Adjust the top of the snubber assembly (75) by half turns until the bolt (78) temporarily installs freely into the adapter assembly (40).

NOTE: If the bolt (78) does not install freely, set the interconnecting linkage (Fig. 709) to the 0.50 inch upper limit.

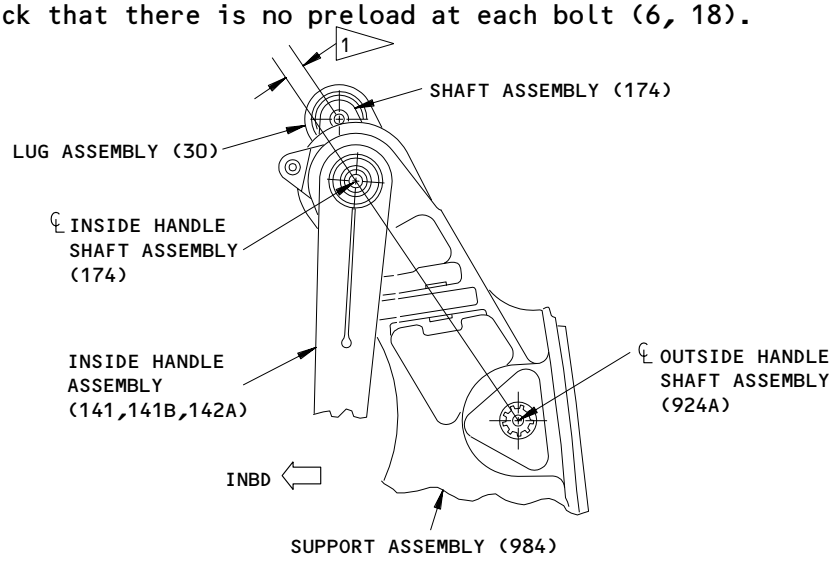
(c) Adjust the top of the snubber assembly (75) until its attach bolt hole center is slightly above (no more than 1/2 turn) the corresponding adapter bolt hole center.

(d) Compress the snubber assembly (75) slightly. Install the bolt (78), washers (84) and nut (87).

(4) Adjust serrated area between lug assemblies (30, 57) so that no preloading exists at each bolt (6A, 18). Tighten bolts (42, 48).

(5) Remove parts (6A thru 27) and reinstall with sealant, BMS 5-95.

(6) Check that there is no preload at each bolt (6, 18).



1 ROTATE SHAFT ASSEMBLY (174) TO 0.46-0.50 FOR INSTALLATION AND ADJUSTMENT OF LUG ASSEMBLIES (30,57) AND SNUBBER ASSEMBLY (75)

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

Assembly Details - Lug Assemblies
Figure 709

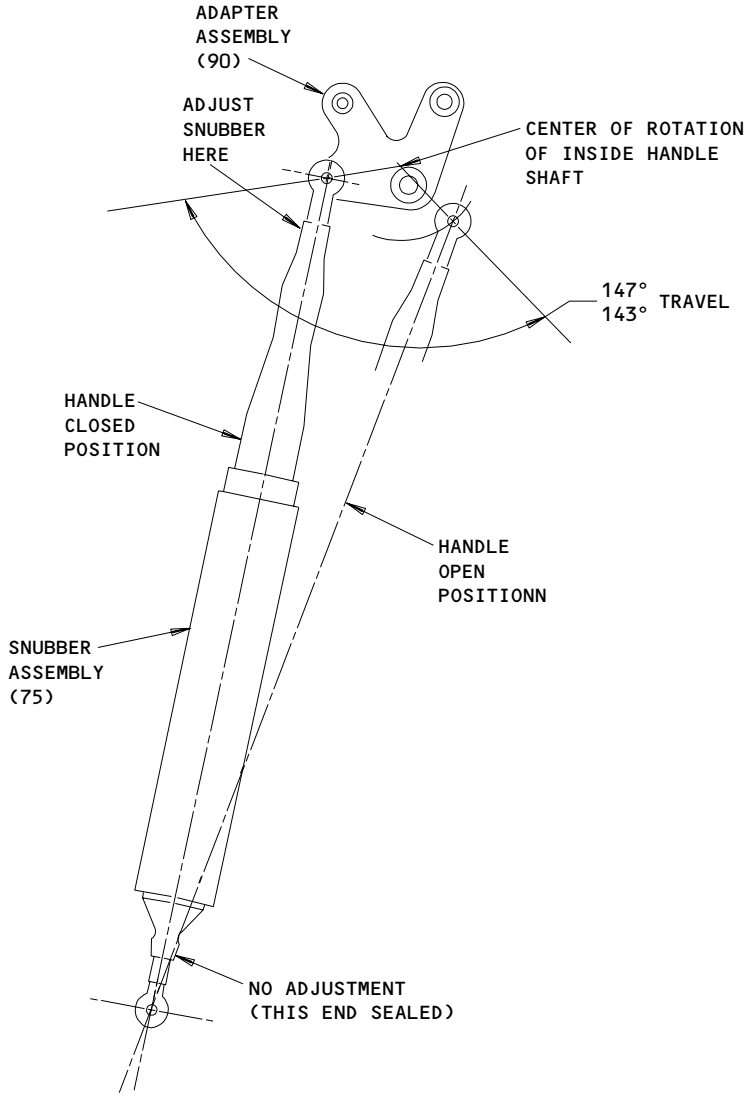
306904

J. Install button (525) and secure with screw (516), spacer (519) and washer (522). Use washers (522) as required to obtain distance indicated between tip of button (525) and handle assembly (141) (Fig. 710).

K. Install cam bracket (983) on handle support assembly (984) by securing with bolts (982A), washers (982C), and nuts (982E). Install fasteners with BMS 5-95 sealant (F-19.48).

L. Check that the operation of handle mechanism assembly is without any binding or roughness.

M. Bend tab of washer (882) to secure nut (879).

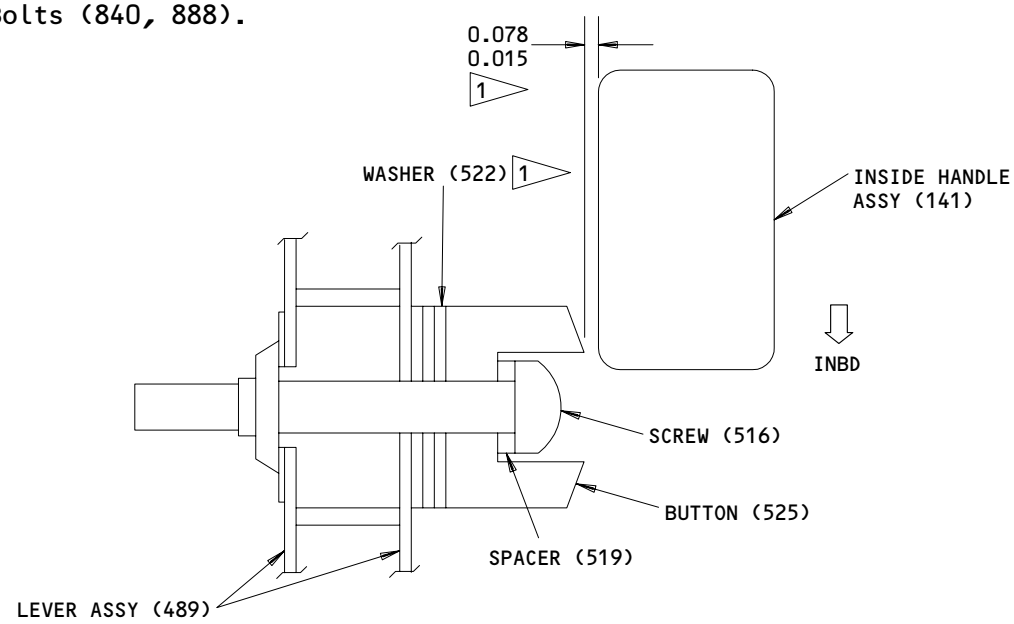


Snubber Installation
Figure 709A

N. Lockwire the following parts using double twist method (Ref 20-50-02) with MS20995NC32 lockwire.

(1) Nut (864) and washer (867).

(2) Bolts (840, 888).



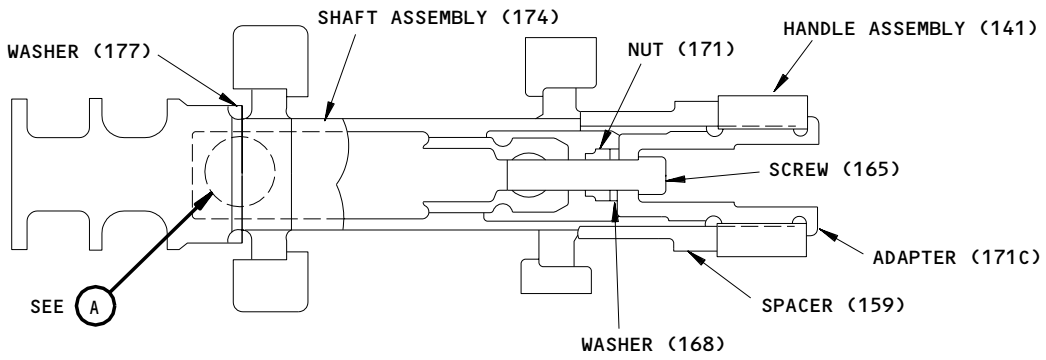
1 USE WASHER (522) AS REQUIRED TO OBTAIN DIM SHOWN (WASHER THICKNESS = 0.063)

ITEM NUMBERS REFER TO IPL FIG. 1

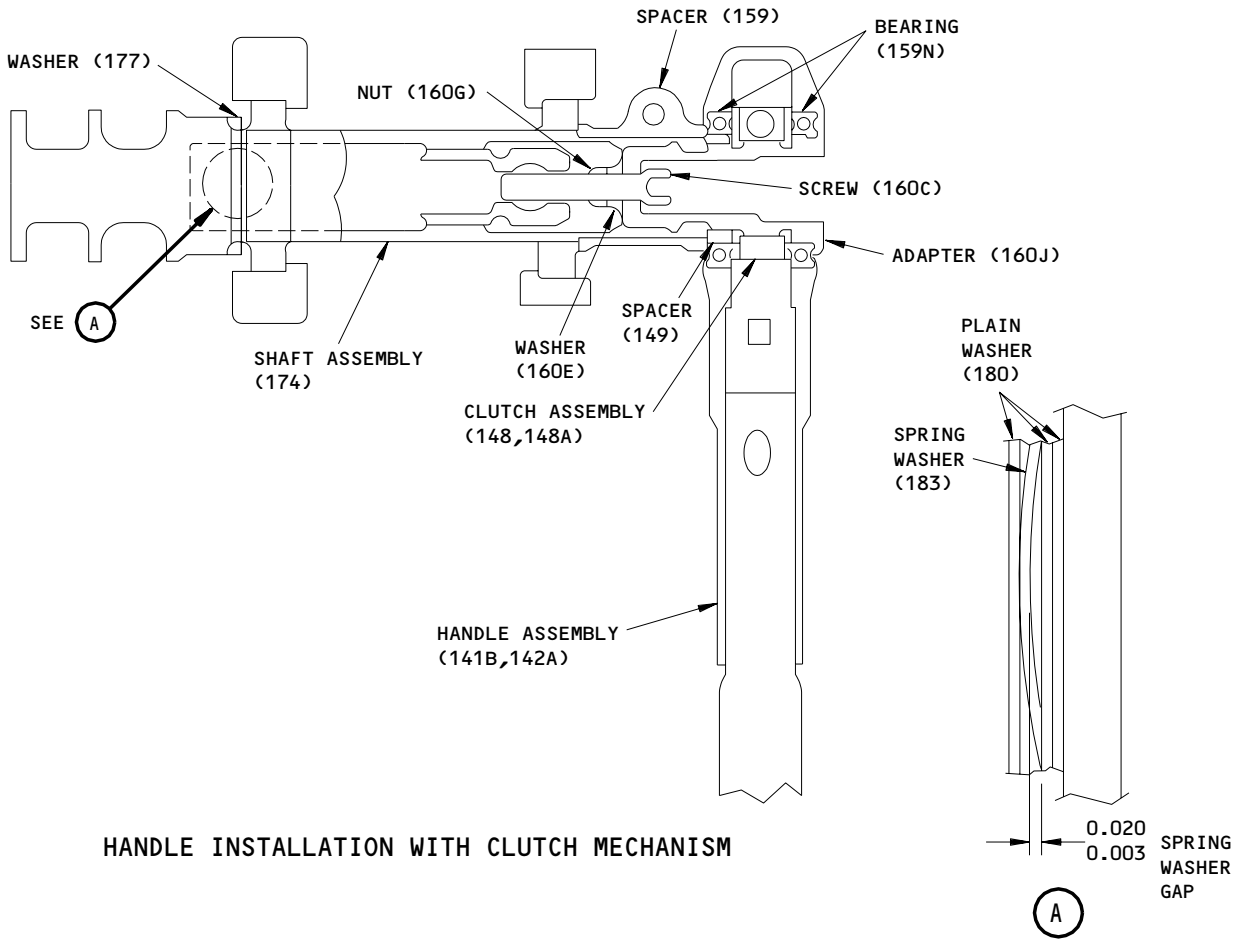
ALL DIMENSIONS ARE IN INCHES

Button (525) Installation
Figure 710

306906



HANDLE INSTALLATION WITHOUT CLUTCH MECHANISM

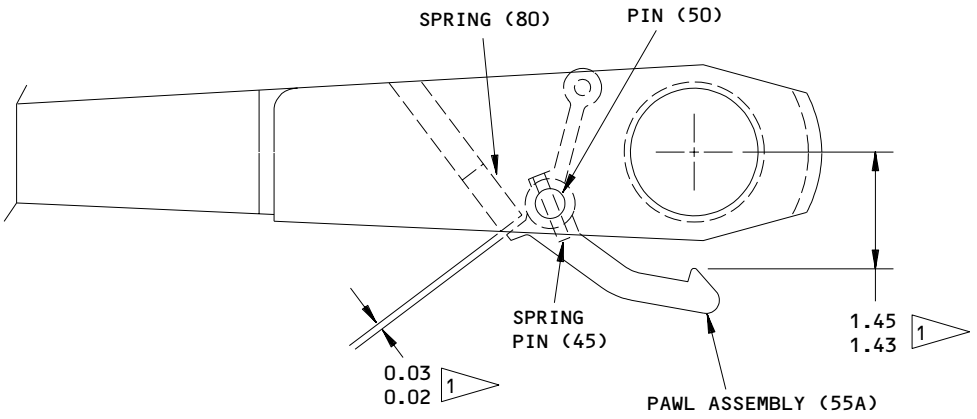


HANDLE INSTALLATION WITH CLUTCH MECHANISM

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

Assembly Details – Shaft Assembly and Inside Handle Assembly
Figure 711



1 ADJUST SPRING (80) CARTRIDGE TO DIMENSION SHOWN WHEN PAWL ASSEMBLY IS AT FULL OPEN POSITION

ALL DIMENSIONS ARE IN INCHES

ITEM NUMBERS REFER TO IPL FIG. 6

Inside Handle Assembly Adjustment
Figure 712

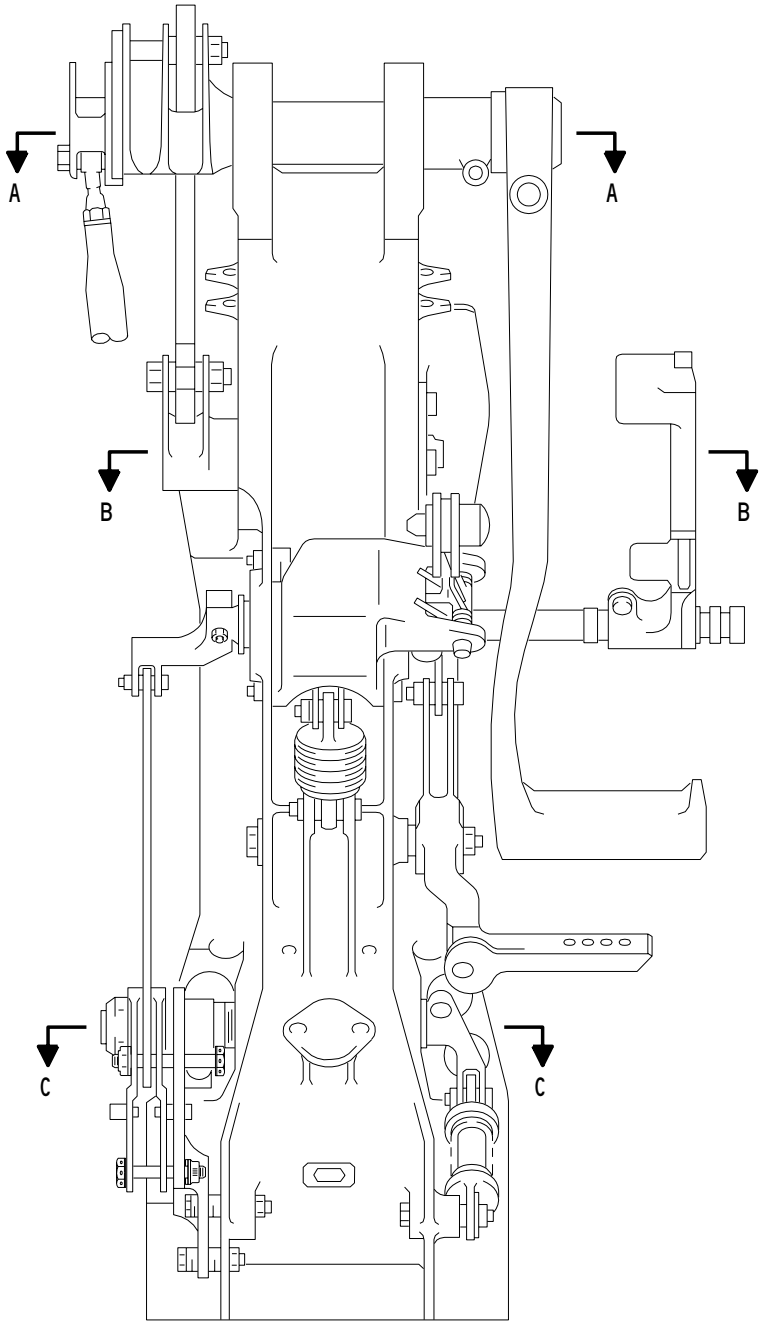
967948

3. Storage

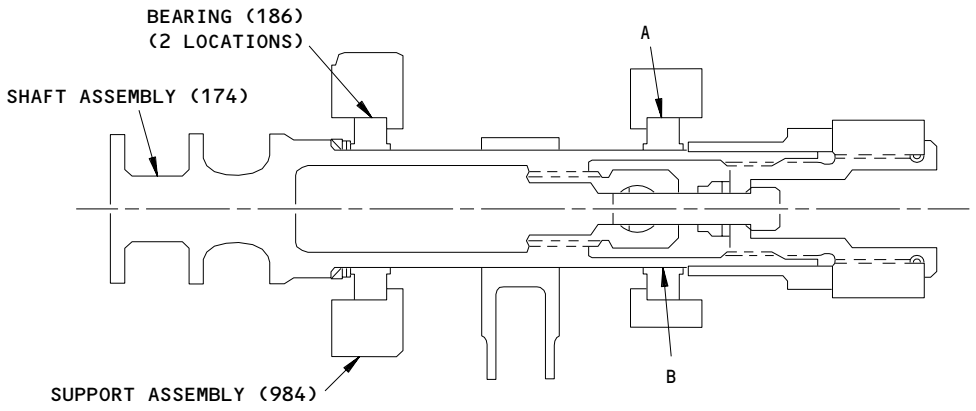
CAUTION: HANDLE ASSEMBLY (141, 141B, 142A) IS FREE TO ROTATE AND MUST BE RESTRAINED TO PREVENT DAMAGE TO PART OR INJURY TO PERSONNEL.

A. Secure handle assembly (141, 141B, 142A) to shaft (456) with tape or other suitable means.

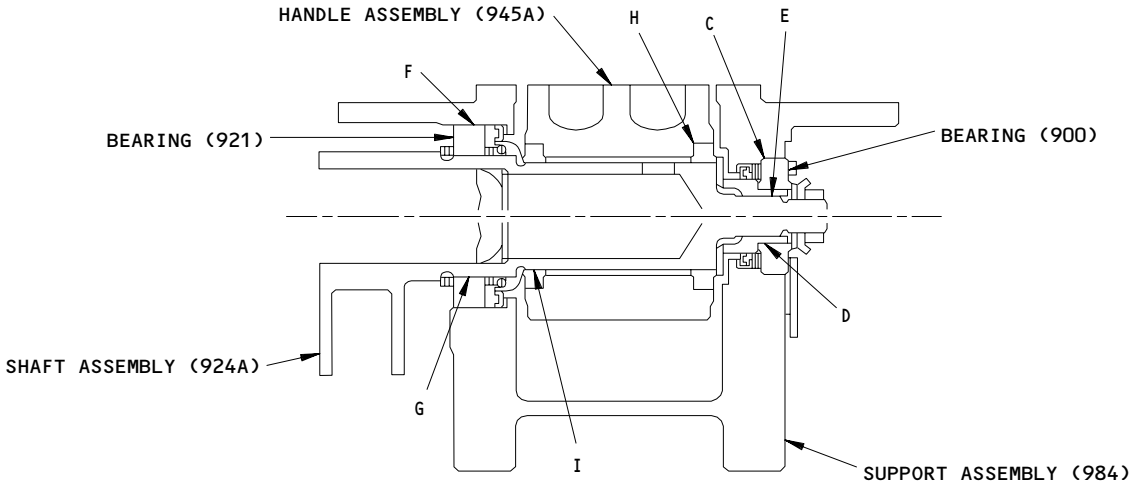
B. Use standard industry practices and information contained in 20-44-02 to store this component.



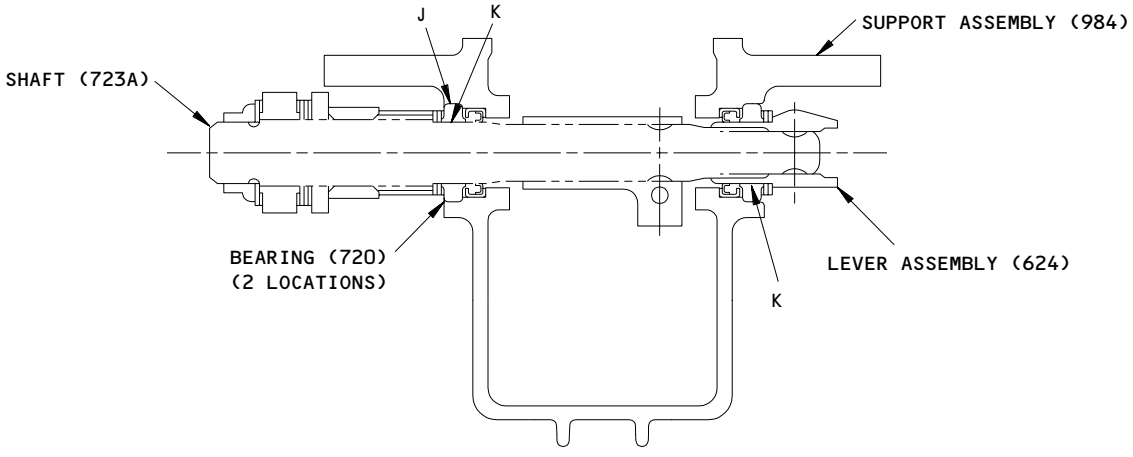
Fits and Clearances
Figure 801 (Sheet 1)



A–A



B–B



C–C

ITEM NUMBERS REFER TO IPL FIG. 1

Fits and Clearances
Figure 801 (Sheet 2)

306921

Ref Letter Fig.801	Mating Item No. IPL Fig. 1	Design Dimension				Service Wear Limit		
		Dimension		Assembly Clearance 1		Dimension		Maximum Clearance
		Min	Max	Min	Max	Min	Max	
A	ID 984 OD 186	2.0625 2.0615	2.0635 2.0625	0.0000	0.0020			0.0060
B	ID 186 OD 174	1.3120 1.310	1.3130 1.311	0.0010	0.0030			0.0070
C	ID 984 OD 900	1.3750 1.3745	1.3760 1.3750	0.0000	0.0015			0.0030
D	ID 900 OD 906	0.6245 0.6215	0.6250 0.6225	0.0020	0.0035			0.0045
E	ID 906 OD 924A	0.501 0.495	0.504 0.500	0.001	0.009			0.010
F	ID 984 OD 921	2.1885 2.1865	2.1895 2.1875	0.0010	0.0030			0.0040
G	ID 921 OD 924A	1.4370 1.4365	1.4380 1.4375	-0.0005	0.0015			0.0025
H	ID 50,55A 2 OD 40 2	1.7500 1.7490	1.7510 1.7500	0.0000	0.0020			0.0030
I	ID 40 2 OD 924A	1.3118 1.310	1.3132 1.311	0.0008	0.0032			0.0040
J	ID 984 OD 720	1.1875 1.1865	1.1885 1.1875	0.0000	0.0020			0.0040
K	ID 720 OD 624,723A	0.7493 0.747	0.7507 0.748	0.0013	0.0037			0.0057

1 NEGATIVE VALUES DENOTE INTERFERENCE FIT

2 IPL FIG. 4

ALL DIMENSIONS ARE IN INCHES

Fits and Clearances
Figure 801 (Sheet 3)

304115

FOR TORQUE VALUES OF STANDARD FASTENERS, REFER TO 20-50-01			
ITEM NO. IPL FIG. 1	NAME	TORQUE	
		POUND-INCHES	POUND-FEET
666C	NUT	1700-2150	
879	NUT	80-120	
954	BOLT	35-40	

Torque Table
Figure 802

304116

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.

VENDORS

K8455 RHP BEARINGS PLC RHP AEROSPACE
OLDENDS LANE
STONEHOUSE GL10 3RM UK

S0352 NIPPON MINIATURE BEARING CO LTD
TOKYO, JAPAN

0PTK6 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
RANCO DOMINQUEZ, 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

VENDORS

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

17446 HUCK MFG CO GOV CONTRACTS LOS ANGELES DIV SUB OF FED-MOGUL
900 WATSON CENTER ROAD
CARSON, CALIFORNIA 90745

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

30163 VALENTEC DAYRON INC
333 MAGUIRE BLVD PO BOX 140394
ORLANDO, FLORIDA 32814-0394

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

VENDORS

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

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

56878 SPS TECHNOLOGIES INC AEROSPACE AND INDUSTRIAL PRODUCTS DIV
HIGHLAND AVENUE
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

60380 TORRINGTON CO BEARINGS DIV SUBSIDIARY OF INGERSOLL-RAND CORP
59 FIELD STREET PO BOX 1008
TORRINGTON, CONNECTICUT 06790-4942
FORMERLY TORRINGTON BEARING COMPANY

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

VENDORS

62554 SIMMONDS MECAERO FASTENERS INC
1734 SEQUOIA AVENUE
ORANGE, CALIFORNIA 92668

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

75165 MANVILLE SALES CORP
717 17TH STREET
DENVER, COLORADO 80217
FORMERLY JOHNS-MANVILLE SALES CORP IN NEW YORK, NEW YORK

77896 REXNORD INC BEARING OPERATION
2400 CURTIS STREET
DOWNERS GROVE, ILLINOIS 60515-4005
FORMERLY SHAEFER BEARING DIV REX CHAINBELT
FORMERLY REX CHAINBELT INC BEARING DIV.

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

83086 NEW HAMPSHIRE BALL BEARINGS, INCORPORATED
ROUTE 202
PETERBOROUGH, NEW HAMPSHIRE 03458

83553 ASSOCIATED SPRING CORP BARNES GROUP
15001 SOUTH BROADWAY PO BOX 231
GARDENA, CALIFORNIA 90248-1819
FORMERLY V0389B

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

96906 MILITARY STANDARDS PROMULGATED BY MILITARY
DEPARTMENTS UNDER AUTHORITY OF DEFENSE
STANDARDIZATION MANUAL 4120 3-M

VENDORS

97393 SHUR-LOK CORPORATION
2541 WHITE ROAD PO BOX 19584
IRVINE, CALIFORNIA 92713
FORMERLY SHUR LOK CORP VB0060
FORMERLY IN SANTA ANA, CALIFORNIA 92714

97928 HUCK INTL INC
3969 PARAMOUNT BLVD
LAKEWOOD, CALIFORNIA 90712-4193

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
AN316C4R		1	952	1
AN960-1216L		1	669	1
AN960-416		1	153	1
		1	567	1
		1	594	1
		1	618	1
		1	843	2
		1	891	3
AN960-416L		1	135	1
		1	237	1
		1	261	1
		1	273	2
		1	303	1
		1	402	1
		1	414	1
		1	435	1
		1	474	1
		1	540	2
		1	541	1
		1	639	1
		1	678	1
		1	684	1
		1	699	14
AN960-516		1	160E	1
		1	168	1
AN960-616		1	9	1
		1	21	1
		1	45	1
		1	738	11
AN960-716		1	885	1
AN960C10		1	807	1
AN960C10L		1	771	1
AN960C416		1	792	3
AN960C416L		1	982C	3
AN960D10L		1	966	2
AN960KD416		1	84	4
		1	192	1
		1	324	1
		1	351A	1
		1	744	2
		1	956A	4

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
AN960KD416L		1	953	1
		1	955	1
		1	956B	4
		1	958	1
AN960KD616		1	228	1
AN960KD8		1	981	1
AN960KD8L		1	978	1
AN960PD416		5	115	4
AN970-4		1	564	1
ASR6-30		1	36	1
		1	69	1
BACB10AC4A		1	252	2
		1	294	2
		1	363	1
		1	579	1
		1	606	1
BACB10BW21		1	186	2
BACB10BW23		1	921	1
BACB10BX10		1	900	1
BACB10B79LT		6	65	1
BACB10CF12PP		1	720	2
BACB10CF14PP		1	753	1
		3	15	2
BACB10CF21PP		1	159N	2
		4	40	2
BACB10CG6		1	216	1
BACB10CK6		1	36	1
		1	69	1
BACB28AK04-026		1	240	1
		1	264	1
		1	354	1
		1	591	1
BACB28AK04-027		1	195	1
		1	282	1
BACB28AK04-028		1	687	1
BACB28AK04-030		1	123	1
BACB28AK04-040		1	762	1
BACB28AK04-050		1	120	1
BACB28AK04-070		1	765	1
BACB28AK04-075		1	327	1
BACB28AK04-258		1	558	2
BACB28AK06-021		1	12	2
BACB28AK06-028		1	24	1
BACB28X4C009		5	90	1
BACB28X4C010		1	630A	1
		3	5	2
BACB28X4C011		1	450A	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACB28X4C012		1	315	1
		1	426	1
BACB28X4C015		1	210	1
BACB28X4C020		5	125	1
BACB28X4C024		1	556	2
BACB28X4E015		1	102	1
BACB28X4E023		1	105	1
BACB28X4M010		1	555	2
BACB28X4M016		5	75	1
BACB28X4M050		5	65	1
BACB28X4M080		5	95	1
BACB28X5M024		5	85	4
BACB28X6C010		1	930	1
BACB28X6C016		2	10	1
BACB28X6M010		1	312	1
		1	423	1
		1	627	1
BACB28X6M012		1	207	1
		1	447	1
		3	10	2
BACB28X6M016		5	80	1
		5	130	1
BACB28X6M050		5	70	1
BACB28X6M109		4	30	1
BACB28X9M010		1	933	1
BACB28Y4C037		1	681	1
BACB28Y4C089		1	276	1
BACB28Y6E036		1	108	1
BACB28Y6E044		1	111	1
BACB28Y9M013		2	20	1
BACB28Y9M015		2	15	1
BACB30LE6U25		1	48	1
BACB30LK3-13		1	825	1
BACB30LL6-34		1	6A	1
BACB30LT6K18		1	18	1
BACB30MR4K10		4	10	4
BACB30MY5K5		5	35	2
BACB30NF4-2		1	96	1
BACB30NF4-4		1	957	1
BACB30NM3K12		1	768	1
BACB30NM3K8		1	804	1
BACB30NM4HK10		1	840	2
BACB30NM4HK2		1	888	3
BACB30NM4K12		1	615	1
BACB30NM4K14		1	150	1
		1	300	1
		1	399	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACB30NM4K14		1	411	1
		1	432	1
BACB30NM4K25		1	561	1
BACB30NM4K50		1	537	2
BACB30NM4K6		1	982A	3
BACB30NM6K12		1	42	1
BACB30NM6K70		1	225	1
BACB30NN4K14		1	636	1
BACB30NR4K10		1	588	1
		5	110	2
BACB30NR4K11		1	234	1
		1	258	1
		1	348	1
BACB30NR4K12		1	189	1
BACB30NR4K16		1	81	1
		1	321	1
		1	735	1
BACB30NR4K20		1	78	1
BACB30NR4K22		1	675	1
		1	732A	1
BACB30NR4K26		1	270	1
BACB30NT2K3		1	975	1
BACB30NT3K3		1	964	2
BACB30NW8K5		1	789	3
BACB30NX8K28		1	132	1
BACC30M5		5	40	2
BACN10HC4		1	148U	1
		1	391	1
		1	441	1
BACN10HC5		2	35	1
BACN10HC6		1	60	2
BACN10JC3CM		1	774	1
		1	810	1
BACN10JC4CM		1	795	3
BACN10JD112		1	666C	1
BACN10JP08A		5	25	1
BACN10JP08C		1	218	4
BACN10JP4DCM		5	50	2
BACN10JR4CM		1	501	1
BACN10YF42		5	15	22
BACN10YF43		5	20	14
BACN10YR3CD		1	969A	2
BACN10YR3CM		1	774A	1
		1	810A	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACN10YR4CD		1	87A	2
BACN10YR4CD		1	156A	1
		1	198A	1
		1	243A	1
		1	267A	1
		1	285A	1
		1	306A	1
		1	330A	1
		1	357A	1
		1	405A	1
		1	417A	1
		1	543A	2
		1	570A	1
		1	597A	1
		1	621A	1
		1	642A	1
		1	690A	1
		1	702A	1
		1	747A	2
BACN10YR4CM		1	795A	3
BACN10YR6CD		1	27A	1
		1	231A	1
BACP18T4K72		1	477	1
BACR10V4		1	389	1
		1	444	1
BACR10V5		2	40	1
BACR10V6		1	63	2
BACR15BA3AD		1	217	8
		1	498	2
		5	10A	74
		5	45	4
BACR15BA5D		6	10	5
BACR15BB4AD10		3	20	2
BACR15BB4B		1	492	2
BACR15CE5M		1	651	4
BACR15DR3		5	10	74
BACR15GA6		6	60	1
BACS18G50B		1	504	1
BACS40U4N2		1	986	1
BACS45A26		1	972	1
BACW10BN4AC		4	15	4
BACW10CA6CCS		1	51	1
BACW10CA6CVS		1	54	1
BACW10P115S		1	99	1
BACW10P121C		1	345	4
BACW10P129AM		1	522	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
BACW10P221S		1	741	10
BACW10P274G		6	75	4
BACW10P321S		1	480	2
BAC27TBY0033		1	665	1
BCREF5231		5	150	2
BCREF5232		5	145	1
BCREF5355		5	155	1
BRM200A08		5	25	1
BRM300A08		1	218	4
BR2000C4M		1	501	1
B0500-038S		1	956	4
B30MY5K5		5	35	2
B30NW8K5		1	789	3
B539-2TS		1	720	2
B539DD		1	720	2
B539DDFS101		1	720	2
B539DDFS428		1	720	2
B539FS101		1	720	2
B539SSG27		1	720	2
B540-2TS		1	753	1
		3	15	2
B540DD		1	753	1
		3	15	2
B540DDFS101		1	753	1
		3	15	2
B540DDFS428		1	753	1
		3	15	2
B540FS101		1	753	1
		3	15	2
B540SSG27		1	753	1
		3	15	2
B542-2TS		1	159N	2
		4	40	2

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
B542DD		1	159N	2
		4	40	2
B542DDFSS428		1	159N	2
		4	40	2
B542DDFS101		1	159N	2
		4	40	2
B542FS101		1	159N	2
		4	40	2
B542SSG27		1	159N	2
		4	40	2
DW6-1		1	216	1
HHKSP4A		1	252	2
		1	294	2
		1	363	1
		1	579	1
		1	606	1
HL10VAZ5-5		5	35	2
HL1012AZ8-28		1	132	1
HL11VAZ8-5		1	789	3
HL12VAZ8-28		1	132	1
HL70-5		5	40	2
HL79-5		5	40	2
H52732-3CD		1	969A	2
H52732-3CM		1	774A	1
		1	810A	1
H52732-4CD		1	87A	2
		1	156A	1
		1	198A	1
		1	243A	1
		1	267A	1
		1	285A	1
		1	306A	1
		1	330A	1
		1	357A	1
		1	405A	1
		1	417A	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
H52732-4CD		1	543A	2
		1	570A	1
		1	597A	1
		1	621A	1
		1	642A	1
		1	690A	1
		1	702A	1
		1	747A	2
H52732-4CM		1	795A	3
H52732-6CD		1	27A	1
		1	231A	1
KP10AFS428		1	900	1
KP21B		1	186	2
KP21BFS428		1	186	2
KP21BG27		1	186	2
KP21BLY196		1	186	2
KP21BSD610		1	186	2
KP21B2TS		1	186	2
KP23B		1	921	1
KP23BFS428		1	921	1
KP23BG27		1	921	1
KP23BLY196		1	921	1
KP23BSD610		1	921	1
KP23B2TS		1	921	1
KSP4A		1	252	2
		1	294	2
		1	363	1
		1	579	1
		1	606	1
KSP4AE9440A		1	252	2
		1	294	2
		1	363	1
		1	579	1
		1	606	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
KSP4AFS428		1	252	2
		1	294	2
		1	363	1
		1	579	1
		1	606	1
KSP4AG27		1	252	2
		1	294	2
		1	363	1
		1	579	1
		1	606	1
KSP4A2TS		1	252	2
		1	294	2
		1	363	1
		1	579	1
		1	606	1
K1001-4BAC		1	501	1
K29646-6S		1	54	1
K29913-6S		1	51	1
LH8065-048		1	148U	1
		1	391	1
		1	441	1
LH8065-054		2	35	1
LH8065-064		1	60	2
LLKP10A		1	900	1
LLKP21B		1	186	2
LLKP23B		1	921	1
L802-8K28		1	132	1
L803-8K5		1	789	3
MF19058-4-2BAC		5	15	22
MF19058-4-3BAC		5	20	14
MK1000-08BAC		5	25	1
MK3000-08BAC		1	218	4
MK4001-4BAC		5	50	2
MS16562-37		6	45	1
MS16624-1062		1	369	1
MS18066-69		1	528	2

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
MS19068-002		1	879	1
MS19070-002		1	882	1
MS20392-3C69		1	959A	1
MS21042L3		1	969	2
MS21042L4		1	87	2
		1	156	1
		1	198	1
		1	243	1
		1	267	1
		1	285	1
		1	306	1
		1	330	1
		1	357	1
		1	405	1
		1	417	1
		1	543	2
		1	570	1
		1	597	1
		1	621	1
MS21042L4		1	642	1
		1	690	1
		1	702	1
		1	747	2
		5	120	2
MS21042L5		1	160G	1
		1	171	1
MS21042L6		1	27	1
		1	231	1
MS21209F4-15P		1	546	2
MS24665-134		1	471	1
MS24665-376		1	665J	1
MS28775-127		1	912	1
MS51023-122		1	528A	2
NAS1329H4K200L		1	982E	3
		1	985A	3
NAS1330H4K211L		1	985	3
		5	27	3
NAS1351-4-76P		1	372	1
NAS1351-5-24P		1	165	1
NAS1351-524P		1	160C	1
NAS1351C4-24P		1	148H	1
NAS1351N4-24P		1	148B	1
NAS1394C4L		2	5	1
		4	35	2
		5	60	4

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
NAS1399MW4-5		2	25	1
NAS1805-3		1	828	1
NAS1805-4N		1	138	1
NAS1805-6		1	15	1
NAS42DD4-24		1	495	2
		3	25	2
NAS428-4-10		1	696	1
NAS428-4-12		1	951	1
NAS428-4-7		1	954	1
NAS43HT4-4		1	148S	1
		1	375	1
		1	519	1
NAS509-4C		1	864	1
NAS513-4		1	867	1
NAS577-4A		4	20	4
NAS578-4		4	25	4
NAS604-24P		1	516	1
NAS72-4E005		1	483	2
NNS57N003		6	80	1
NS103197-82		5	25	1
NS103199-82		1	218	4
NS103200SE048		5	50	2
NS103202SE048		1	501	1
PLH53CD		1	969A	2
PLH53CM		1	774A	1
		1	810A	1
PLH54CD		1	87A	2
		1	156A	1
		1	198A	1
		1	243A	1
		1	267A	1
		1	285A	1
		1	306A	1
		1	330A	1
		1	357A	1
		1	405A	1
		1	417A	1
		1	543A	2
		1	570A	1
		1	597A	1
		1	621A	1
		1	642A	1
		1	690A	1
		1	702A	1
		1	747A	2

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
PLH54CM		1	795A	3
PLH56CD		1	27A	1
		1	231A	1
PN3A		6	65	1
RMA9201M82		5	25	1
RMA9205M82		1	218	4
SAT1624A1501		1	468	2
SLR4027-4		1	389	1
		1	444	1
SLR4027-5		2	40	1
SLR4027-6		1	63	2
SL414-4		1	148U	1
		1	391	1
		1	441	1
SL414-5		2	35	1
SL414-6		1	60	2
TN11251212ALCAS		5	150	2
TN12501212ALCAS		5	145	1
TN21881214ALCAS		5	155	1
T339E		1	720	2
T340E		1	753	1
		3	15	2
T342E		1	159N	2
		4	40	2
T8076S832		5	25	1
T8078S832		1	218	4
T8083C428		5	50	2
T8089C428		1	501	1
VN102D1-048		1	501	1
VN202A1-82		5	25	1
VN203A1-82		1	218	4
VN204D1-048		5	50	2
109A9201-4		1	501	1
109A9209M4		5	50	2
141T6103-1		1	831U	1
		1	833	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
141T6133-75		1	987	1
		5	5	RF
141T6133-76		1	984	1
		5	1	RF
141T6133-77		5	165	1
141T6133-78		5	160	1
141T6133-85		1	987A	1
		5	5A	RF
141T6133-86		1	984B	1
		5	1A	RF
141T6133-93		5	165A	1
141T6133-94		5	160A	1
141T6159-11		1	948A	1
		4	5A	RF
141T6159-12		1	945A	1
		4	1A	RF
141T6159-15		4	60A	1
141T6159-16		4	55A	1
141T6159-7		4	50	1
141T6160-1		1	141	1
141T6160-2		1	147	1
141T6160-3		1	144	1
		6	35	1
141T6160-5		6	15A	1
141T6160-6		6	20A	1
141T6160-7		6	25	1
141T6160-8		6	30	1
141T6188-13		1	756	1
141T6188-14		1	759	1
141T6188-5		1	726	1
141T6188-6		1	729	1

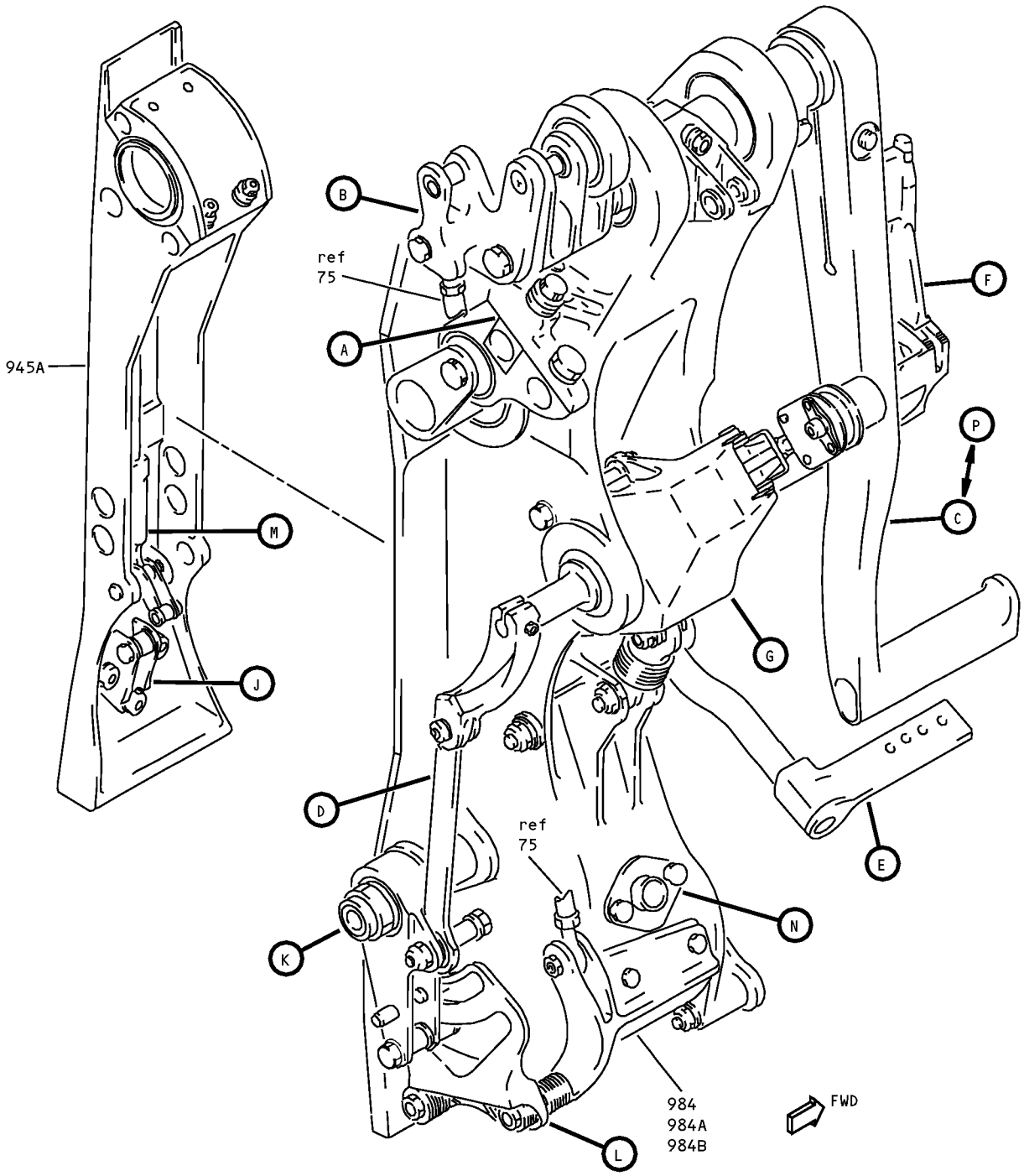
PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
141T6193-1		1	420	1
141T6193-3		1	429	1
141T6195-1		1	648	1
141T6195-2		1	645	1
141T6195-3		1	657	2
141T6196-2		1	39	1
141T6196-3		1	30	1
141T6197-1		1	57	1
141T6197-2		1	72	1
141T6198-2		1	456	1
141T6198-3		1	457	1
141T6199-2		1	723A	1
141T6200-1		1	663	1
141T6200-2		1	660	1
141T6201-3		1	705	1
141T6201-4		1	708	1
141T6201-5		1	711	1
141T6203-1		1	180	3
141T6203-2		1	183	1
141T6203-3		1	714	21
141T6203-4		1	717	1
141T6203-5		1	459	2
141T6203-6		1	465	1
141T6203-7		1	903	8
141T6203-8		1	918	12
141T6205-1		1	624	1
141T6205-2		1	633	1
141T6206-3		5	30	1
141T6206-4		5	55	1
141T6207-6		1	672	1
		3	1	RF
141T6207-8		3	30	1
141T6208-1		1	915	1
141T6210-1		1	654	1
141T6214-1		1	693	1
141T6215-1		1	159	1
141T6215-3		1	159A	1
141T6219-1		1	861	1
141T6220-3		1	408	1
141T6221-1		1	174	1
		2	1	RF

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
141T6221-4		2	50	1
141T6223-1		1	162	1
141T6223-2		1	160	1
		1	164	1
141T6223-3		1	160J	1
		1	171C	1
141T6224-1		2	45	1
141T6224-3		2	30	1
141T6225-1		1	177	1
141T6226-1		1	855	1
141T6228-1		1	927A	1
141T6228-2		1	924A	1
141T6228-3		1	939A	1
141T6228-4		1	936A	1
141T6229-1		1	906	1
141T6231-1		1	849	1
141T6232-1		1	852	1
141T6248-5		1	387	1
141T6248-6		1	396	1
141T6249-1		1	378A	1
141T6249-3		1	384	1
141T6249-4		1	381	2
141T6249-6		1	378	1
141T6258-3		1	585	1
141T6271-3		1	222A	1
141T6271-31		1	204A	1
141T6271-32		1	201A	1
141T6271-4		1	219A	1
141T6274-1		1	600	1
141T6274-2		1	573	1
141T6274-3		1	612	1
141T6274-4		1	582	1
141T6274-5		1	609	1
141T6277-1		1	288	1
141T6277-2		1	246	1
141T6277-3		1	297	1
141T6277-4		1	255	1
141T6280-1		1	832B	1
		1	834A	1
141T6280-2		1	832L	1
		1	837A	1
141T6280-3		1	832M	1
141T6280-3		1	837B	1
141T6282-1		1	894	1
141T6284-1		1	801	1
141T6286-1		1	798	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
141T6286-2		1	897	1
141T6287-1		1	831	2
141T6287-10		1	876	1
141T6287-14		1	783	2
		1	819	2
		1	873	2
141T6287-15		1	336	2
141T6287-16		4	45	2
141T6287-17		1	858	1
141T6287-2		1	813	1
141T6287-3		1	816	1
141T6287-4		1	780	1
141T6287-5		1	870	1
141T6287-7		1	822	1
141T6287-8		1	786	1
141T6287-9		1	777	1
141T6288-1		1	846	1
141T6500-1		1	909	1
141T6500-2		1	942	1
141T6521-1		1	33	1
		1	66	1
141T6521-3		1	213	1
141T6521-6		1	750	1
141T6538-10		1	525A	1
141T6538-7		1	525	1
141T6561-4		1	75	1
141T6649-1		1	534	1
141T6649-2		1	531	1
141T6649-3		1	552	1
141T6649-4		1	549	1
141T6650-1		1	486	1
141T6651-1		1	489	1
141T6651-2		1	513	1
141T6651-4		1	507	1
141T6651-5		1	510	1
141T6652-2		1	438	1
141T6652-5		1	453	1
141T6661-1		1	960	1
141T6662-1		1	963	1
141T6662-2		1	962	1
141T6663-1		1	961	1
143T6140-10		1	3B	RF
143T6140-15		1	1C	RF
143T6140-16		1	3C	RF
143T6140-19		1	831G	1
143T6140-20		1	831N	1

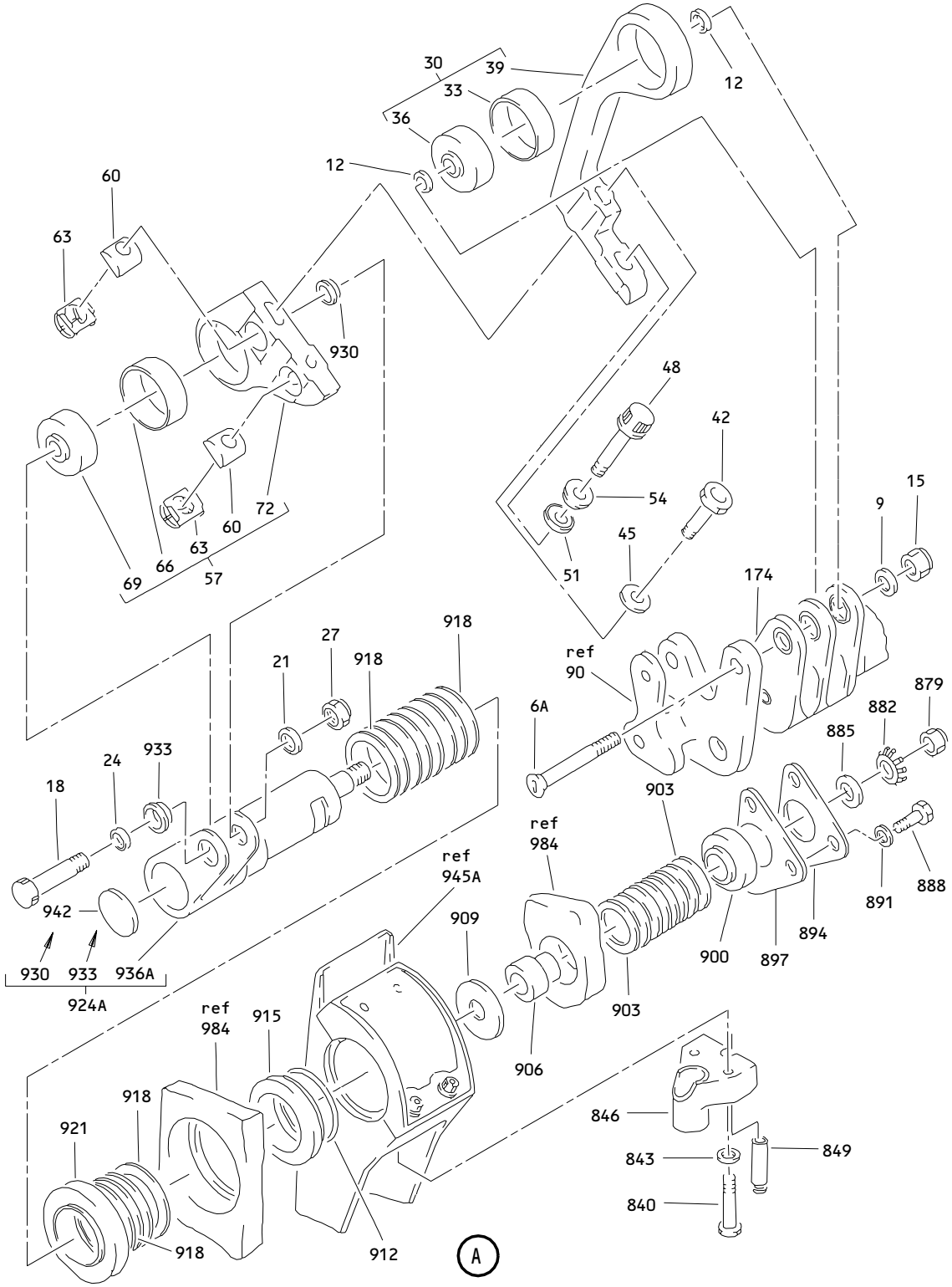
PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
143T6140-3		1	1	RF
143T6140-4		1	3	RF
143T6140-7		1	1A	RF
143T6140-8		1	3A	RF
143T6140-9		1	1B	RF
143T6141-1		5	100	1
143T6141-2		5	105	1
143T6141-3		5	135	1
143T6141-4		5	140	1
143T6142-1		1	309	1
143T6142-2		1	318	1
143T6143-1		1	90	1
143T6143-2		1	93	1
143T6143-3		1	114	1
143T6143-4		1	117	1
143T6150-1		1	141B	1
		6	1	RF
143T6150-2		1	142A	1
		6	5	RF
143T6151-1		6	85	1
143T6152-1		6	50	1
143T6152-2		6	40	1
143T6154-5		6	55A	1
143T6154-6		6	70A	1
143T6155-1		1	148	1
143T6155-2		1	148V	1
143T6155-4		1	148W	1
143T6155-5		1	148A	1
143T6155-6		1	148Y	1
143T6155-7		1	148X	1
143T6156-1		1	983C	1
143T6156-2		1	983	1
143T6156-5		1	983D	1
143T6156-6		1	983A	1
143T6157-1		1	149	1

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
2452-048RET		1	389	1
		1	444	1
2452-054RET		2	40	1
2452-064RET		1	63	2
295927-50		1	504	1
4AFS428		1	252	2
		1	294	2
		1	363	1
		1	579	1
		1	606	1
66014-5		5	40	2
69-38919-35		1	249	2
		1	291	2
		1	576	1
		1	603	1
69-38919-58		1	249A	2
		1	291A	2
		1	576A	1
		1	603A	1
69B13060-7		1	360	1
69B13060-8		1	366	1
69B13067-6		1	339	1
69B13067-7		1	333	1
69B14846-2		1	342	1
70186-6S		1	54	1
70189-6S		1	51	1
922005-6		1	54	1
922006-6		1	51	1
942005-6		1	54	1
942006-6		1	51	1
94263-428		1	148U	1
		1	391	1
		1	441	1
94263-524		2	35	1
94263-624		1	60	2

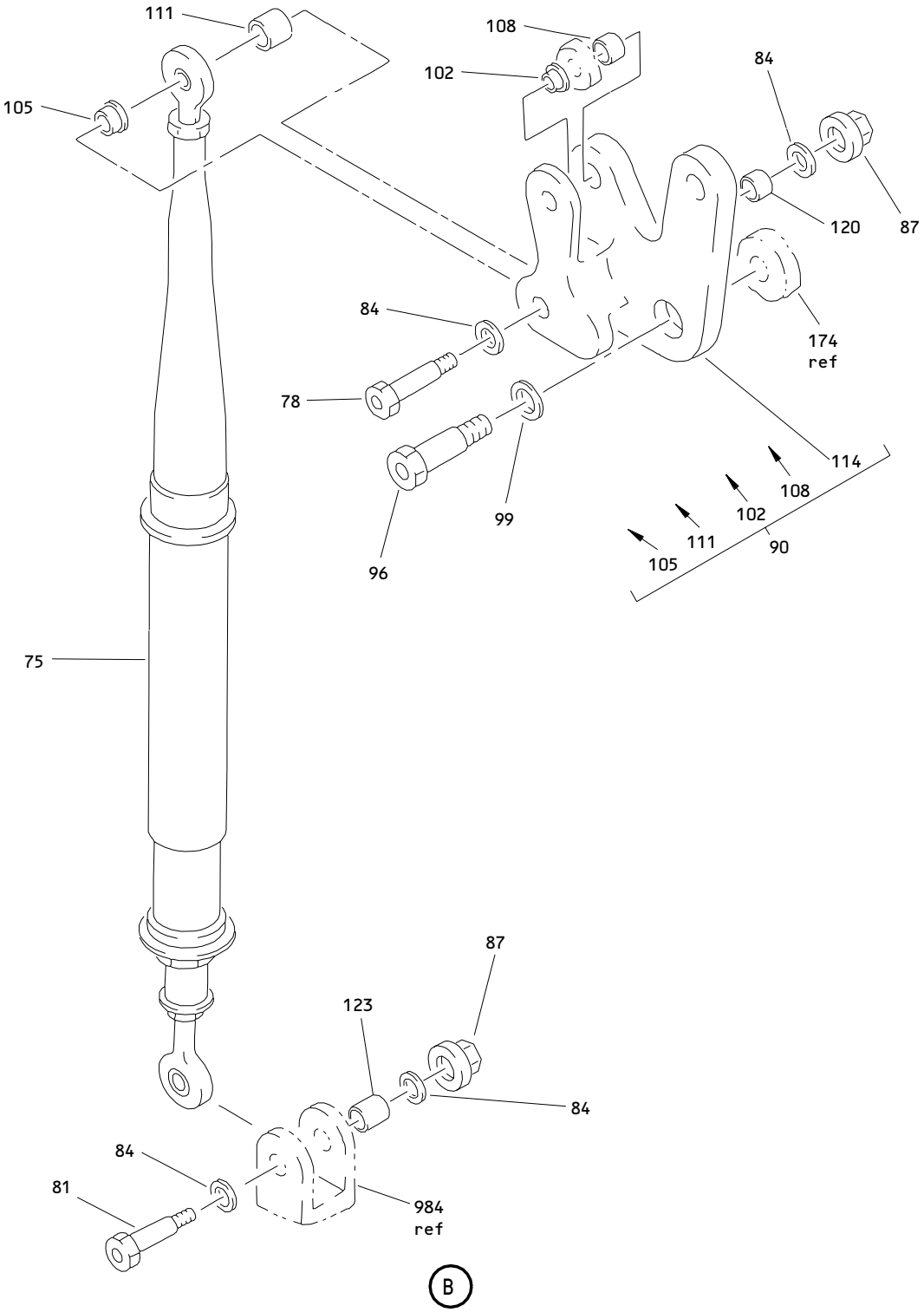


Mid-Entry and Service Door Handle Mechanism Assembly
Figure 1 (Sheet 1)

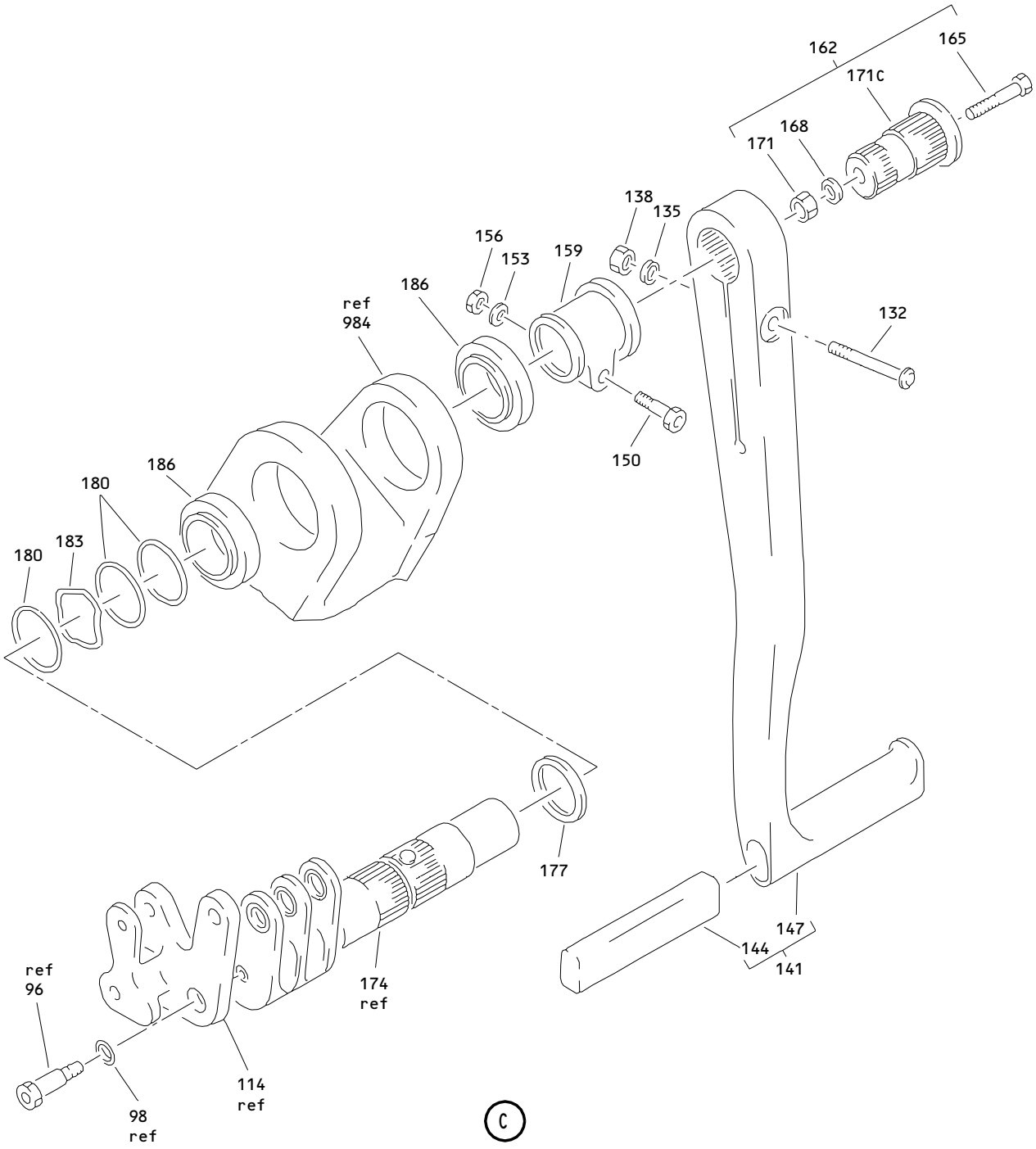
J00454



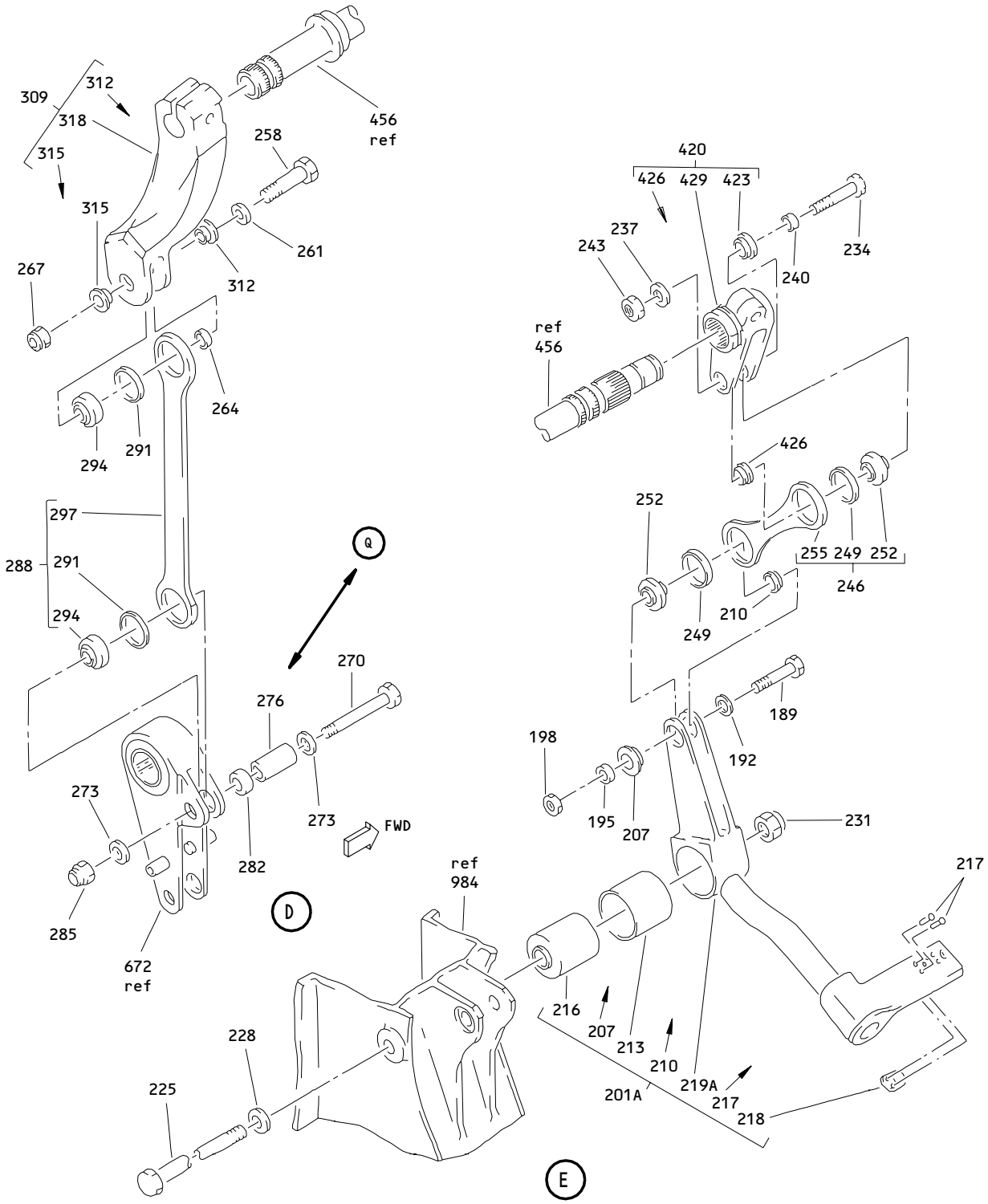
Mid-Entry and Service Door Handle Mechanism Assembly
Figure 1 (Sheet 2)



Mid-Entry and Service Door Handle Mechanism Assembly
Figure 1 (Sheet 3)

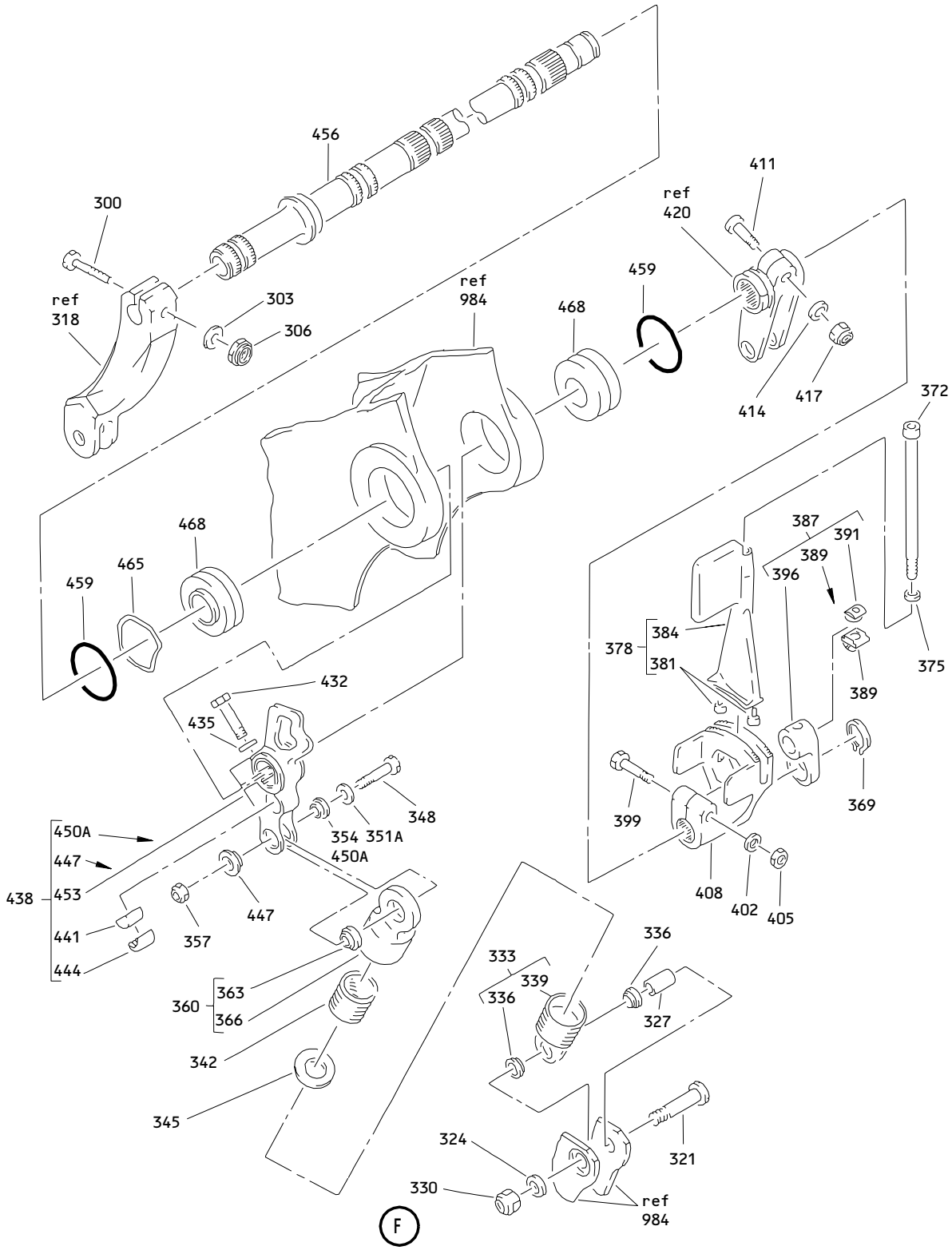


Mid-Entry and Service Door Handle Mechanism Assembly
Figure 1 (Sheet 4)

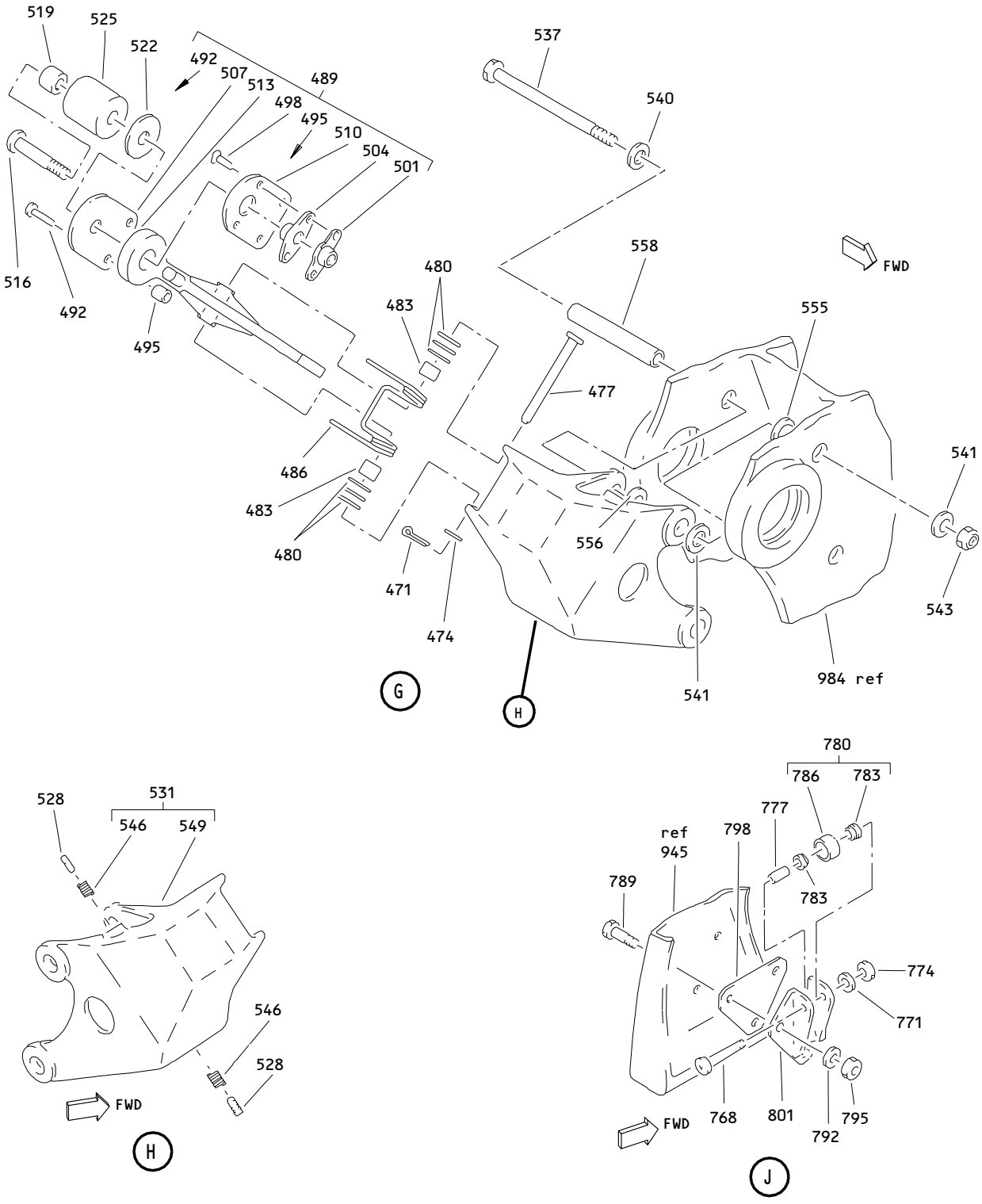


Mid-Entry and Service Door Handle Mechanism Assembly
Figure 1 (Sheet 5)

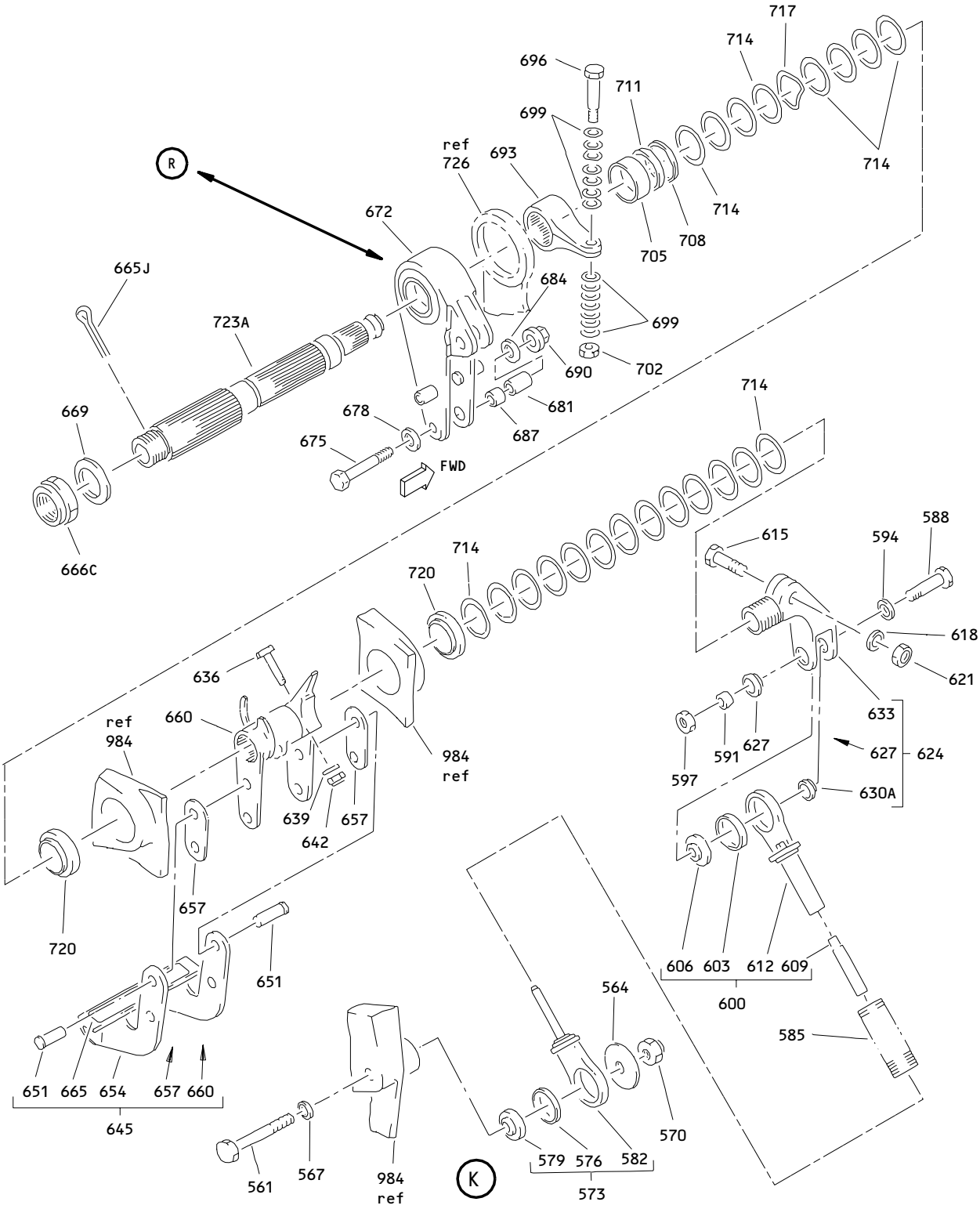
65900C



Mid-Entry and Service Door Handle Mechanism Assembly
Figure 1 (Sheet 6)

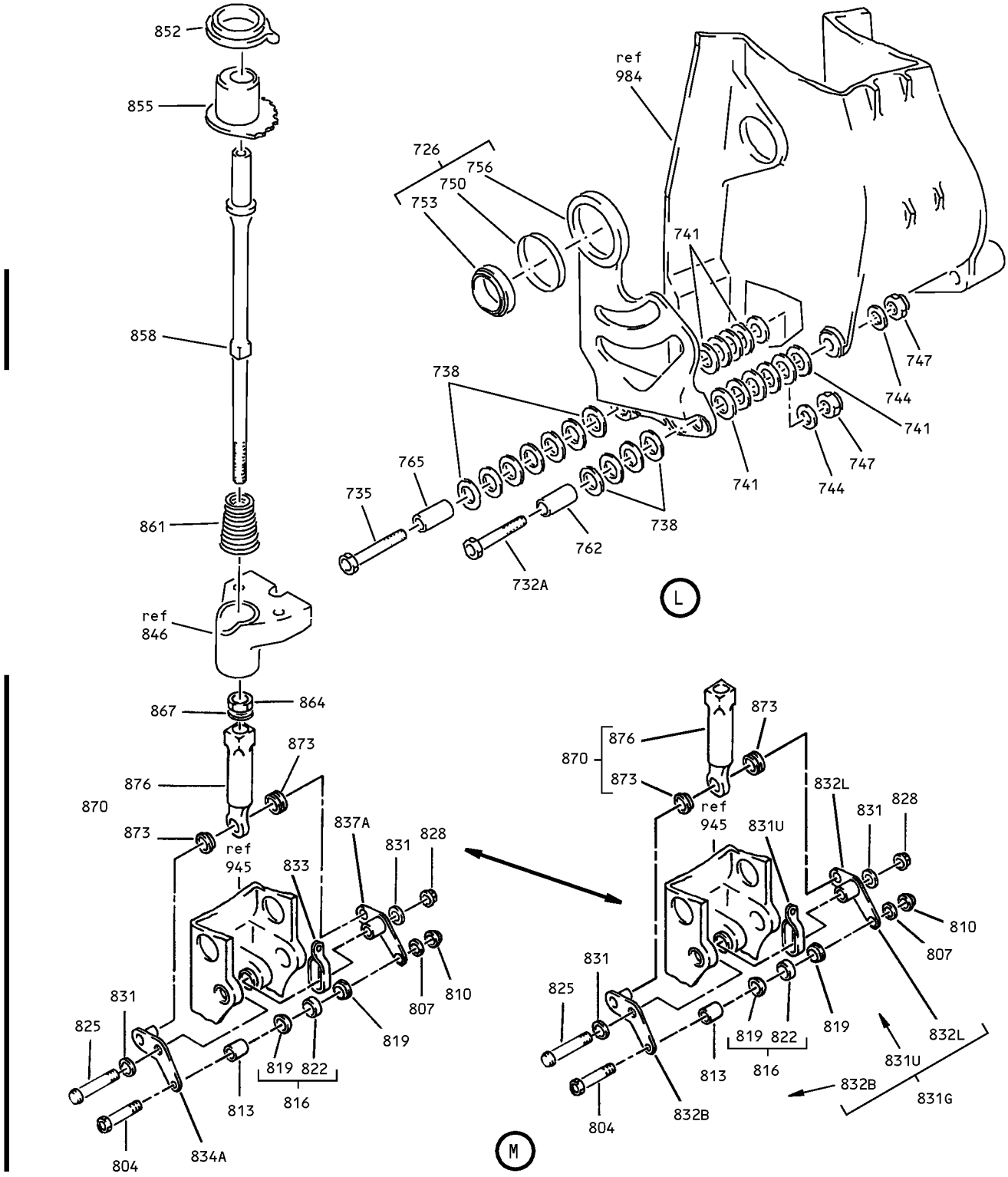


Mid-Entry and Service Door Handle Mechanism Assembly
Figure 1 (Sheet 7)



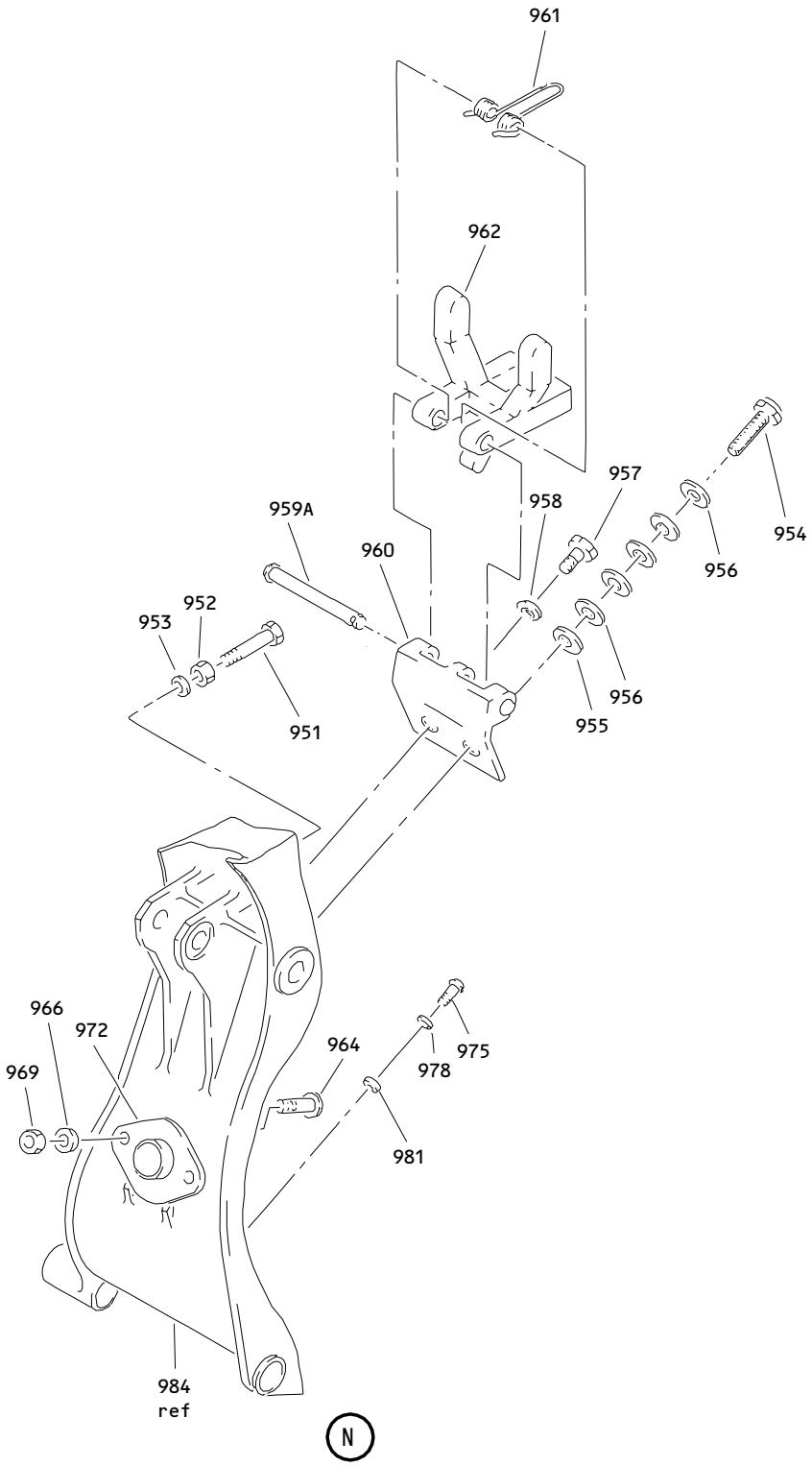
Mid-Entry and Service Door Handle Mechanism Assembly
Figure 1 (Sheet 8)

J00467

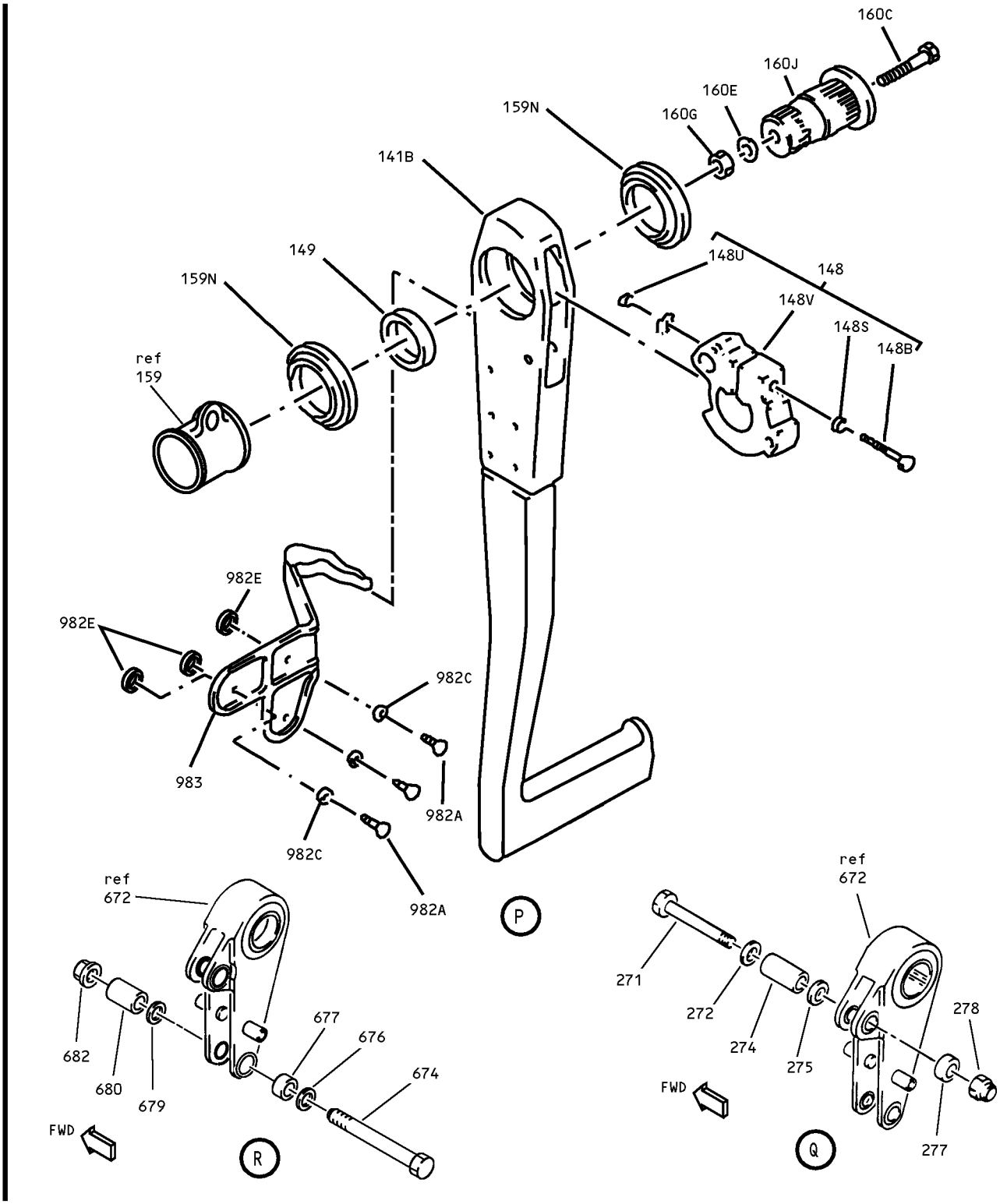


Mid-Entry and Service Door Handle Mechanism Assembly
Figure 1 (Sheet 9)

J00476



Mid-Entry and Service Door Handle Mechanism Assembly
Figure 1 (Sheet 10)



Mid-Entry and Service Door Handle Mechanism Assembly
Figure 1 (Sheet 11)

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	-1	143T6140-3		MECHANISM ASSY-MID ENTRY AND SVCE DOOR HANDLE (LH) (PRE SB 767-52-0058)	A	RF
	-1A	143T6140-7		MECHANISM ASSY-MID ENTRY AND SVCE DOOR HANDLE (LH) (POST SB 767-52-0058)	C	RF
	-1B	143T6140-9		MECHANISM ASSY-MID ENTRY AND SVCE DOOR HANDLE (LH)	E	RF
R	-1C	143T6140-15		MECHANISM ASSY-MID ENTRY AND SVCE DOOR HANDLE (LH)	G	RF
	-3	143T6140-4		MECHANISM ASSY-MID ENTRY AND SVCE DOOR HANDLE (RH) (PRE SB 767-52-0058)	B	RF
	-3A	143T6140-8		MECHANISM ASSY-MID ENTRY AND SVCE DOOR HANDLE (RH) (POST SB 767-52-0058)	D	RF
	-3B	143T6140-10		MECHANISM ASSY-MID ENTRY AND SVCE DOOR HANDLE (RH)	F	RF
R	-3C	143T6140-16		MECHANISM ASSY-MID ENTRY AND SVCE DOOR HANDLE (RH)	H	RF
	6	BACB30LL6-33		DELETED		
	6A	BACB30LL6-34		.BOLT		1
	9	AN960-616		.WASHER		1
	12	BACB28AK06-021		.BUSHING		2
	15	NAS1805-6		.NUT		1
	18	BACB30LT6K18		.BOLT		1
	21	AN960-616		.WASHER		1
	24	BACB28AK06-028		.BUSHING		1
	27	MS21042L6		.NUT	A-D	1
	-27A	H52732-6CD		.NUT- (V15653) (SPEC BACN10YR6CD) (OPT PLH56CD (V62554))	E-H	1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	30	141T6196-3		.LUG ASSY		1
	33	141T6521-1		..RING-SWAGE		1
R	36	ASR6-30		..BEARING- (VS0352) (SPEC BACB10CK6)		1
	39	141T6196-2		..LUG		1
	42	BACB30NM6K12		.BOLT		1
	45	AN960-616		.WASHER		1
	48	BACB30LE6U25		.BOLT		1
	51	K29913-6S		.WASHER- (V15653) (SPEC BACW10CA6CCS) (OPT 70189-6S (V56878)) (OPT 922006-6 (V60119)) (OPT 942006-6 (V60119))		1
	54	K29646-6S		.WASHER- (V15653) (SPEC BACW10CA6CVS) (OPT 70186-6S (V56878)) (OPT 922005-6 (V60119)) (OPT 942005-6 (V60119))		1
	57	141T6197-1		.LUG ASSY		1
	60	LH8065-064		..NUT- (V72962) (SPEC BACN10HC6) (OPT SL414-6 (V97393)) (OPT 94263-624 (V56878))		2
	63	SLR4027-6		..RETAINER- (V97393) (SPEC BACR10V6) (OPT 2452-064RET (V72962))		2
	66	141T6521-1		..RING-SWAGE		1
R	69	ASR6-30		..BEARING- (VS0352) (SPEC BACB10CK6)		1
	72	141T6197-2		..LUG		1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
75	141T6561-4		.SNUBBER ASSY-HANDLE MECH SPR/HYDR (REF CMM 52-11-82)		1
			ATTACHING PARTS		
78	BACB30NR4K20		.BOLT		1
81	BACB30NR4K16		.BOLT		1
84	AN960KD416		.WASHER		4
87	MS21042L4		.NUT	A-D	2
-87A	H52732-4CD		.NUT- (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))	E-H	2
			-------*-------		
90	143T6143-1		.ADAPTER ASSY	A,C,E,G	1
-93	143T6143-2		.ADAPTER ASSY	B,D,F,H	1
			ATTACHING PARTS		
96	BACB30NF4-2		.BOLT		1
99	BACW10P115S		.WASHER		1
			-------*-------		
102	BACB28X4E015		..BUSHING		1
105	BACB28X4E023		..BUSHING		1
108	BACB28Y6E036		..BUSHING		1
111	BACB28Y6E044		..BUSHING		1
114	143T6143-3		..ADAPTER	A,C,E,G	1
-117	143T6143-4		..ADAPTER	B,D,F,H	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
120	BACB28AK04-050		.BUSHING		1
123	BACB28AK04-030		.BUSHING		1
132	HL1012AZ8-28		.BOLT-	A,B	1
			(VOPTK6)		
			(SPEC BACB30NX8K28)		
			(OPT HL12VAZ8-28		
			(V73197))		
			(OPT HL12VAZ8-28		
			(V92215))		
			(OPT HL12VAZ8-28		
			(V97928))		
			(OPT L802-8K28		
			(V06725))		
			(OPT HL12VAZ8-28		
			(V56878))		
			(OPT HL1012AZ8-28		
			(V06725))		
			(OPT HL1012AZ8-28		
			(V06950))		
			(OPT HL1012AZ8-28		
			(V17446))		
			(OPT HL1012AZ8-28		
			(V56878))		
			(OPT HL1012AZ8-28		
			(V60516))		
			(OPT HL1012AZ8-28		
			(V73197))		
			(OPT HL1012AZ8-28		
			(V97928))		

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	135	AN960-416L		.WASHER	A,B	1
	138	NAS1805-4N		.NUT	A,B	1
	141	141T6160-1		.HANDLE ASSY	A,B	1
	-141A	141T6150-1		DELETED		
	-141B	143T6150-1		.HANDLE ASSY- (FOR DETAILS SEE FIG. 6)	C,E,G	1
	142	141T6150-2		DELETED		
	142A	143T6150-2		.HANDLE ASSY- (FOR DETAILS SEE FIG. 6)	D,F,H	1
	144	141T6160-3		..FILLER	A,B	1
	147	141T6160-2		..HANDLE (OPT ITEM 147A)	A,B	1
	147A	141T6160-11		..HANDLE (OPT ITEM 147)	A,B	1
	148	143T6155-1		.CLUTCH ASSY-*(1)	C,D	1
	-148A	143T6155-5		.CLUTCH ASSY-*(1)	E-H	1
R	148B	NAS1351N4-24P		..SCREW- (OPT ITEM 148H)	C-H	1
	148C	NAS1352C4-24		DELETED		
	148D	NAS1352C4-24P		DELETED		
	-148E	NAS1352C4-28		DELETED		

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	-148F	NAS1352N4-24P		DELETED		
	148G	NAS43HT4-4		DELETED		
R	-148H	NAS1351C4-24P		..SCREW- (OPT ITEM 148B)	C-H	1
	148J	BACR10VR		DELETED		
	148K	LH8065-048		DELETED		
	148L	BACNB10HC4		DELETED		
	148M	143T6155-2		DELETED		
	-148N	143T6155-4		DELETED		
	-148P	143T6155-7		DELETED		
	-148Q	143T6155-6		DELETED		
R	148S	NAS43HT4-4		..SPACER	C-H	1
R	148U	LH8065-048		..NUT- (V72962) (SPEC BACN10HC4) (OPT SL414-4 (V97393)) (OPT 94263-428 (V56878))	C-H	1
R	148V	143T6155-2		..CLUTCH- (OPT ITEM 148W)	C,D	1
R	-148W	143T6155-4		..FITTING- (OPT ITEM 148V)	C,D	1
R	-148X	143T6155-7		..CLUTCH-*(1) (OPT ITEM 148Y)	E-H	1
R	-148Y	143T6155-6		..CLUTCH-*(1) (OPT ITEM 148X)	E-H	1
	149	143T6157-1		.SPACER	C-H	1
	150	BACB30NM4K14		.BOLT		1
	153	AN960-416		.WASHER		1
	156	MS21042L4		.NUT	A-D	1
	-156A	H52732-4CD		.NUT- (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))	E-H	1
	159	141T6215-1		.SPACER	A,B	1
	-159A	141T6215-3		.SPACER	C-H	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
159N	B542DDFSS428		.BEARING- (V21335) (SPEC BACB10CF21PP) (OPT B542-2TS (V43991)) (OPT B542SSG27 (V30163)) (OPT T342E (VK8455)) (OPT B542DDFS101 (V06144)) (OPT B542DD (V38443)) (OPT B542FS101 (V06144))	C-H	2
-160	141T6223-2		.ADAPTER ASSY	C-H	1
160C	NAS1351-524P		..SCREW	C-H	1
160E	AN960-516		..WASHER	C-H	1
160G	MS21042L5		..NUT	C-H	1
160J	141T6223-3		..ADAPTER	C-H	1
162	141T6223-1		.ADAPTER	A,B	1
-164	141T6223-2		..ADAPTER ASSY	A,B	1
165	NAS1351-5-24P		...SCREW	A,B	1
168	AN960-516		...WASHER	A,B	1
171	MS21042L5		...NUT	A,B	1
171C	141T6223-3		...ADAPTER	A,B	1
174	141T6221-1		.SHAFT ASSY- (FOR DETAILS SEE FIG. 2)		1
177	141T6225-1		.WASHER		1
180	141T6203-1		.WASHER		3
183	141T6203-2		.WASHER-SPRING		1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
186	KP21B		.BEARING- (V38443) (SPEC BACB10BW21) (OPT KP21B2TS (V43991)) (OPT LLKP21B (V38443)) (OPT KP21BG27 (V30163)) (OPT KP21BFS428 (V21335)) (OPT KP21BLY196 (V40920)) (OPT KP21BSD610 (V83086))		2
189	BACB30NR4K12		.BOLT		1
192	AN960KD416		.WASHER		1
195	BACB28AK04-027		.BUSHING		1
198	MS21042L4		.NUT	A-D	1
-198A	H52732-4CD		.NUT- (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))	E-H	1
201	141T6271-34		DELETED		
201A	141T6271-32		.LEVER ASSY	A,C,E,G	1
-204	141T6271-33		DELETED		
-204A	141T6271-31		.LEVER ASSY	B,D,F,H	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
207	BACB28X6M012		..BUSHING		1
210	BACB28X4C015		..BUSHING		1
213	141T6521-3		..SLEEVE		1
216	GDW6SD610		..BEARING- (V83086) (SPEC BACB10CG6) (OPT GDW6TT (V43991)) (OPT DW6-1 (V38443)) (OPT GDW6FS428 (V21335))		1
217	BACR15BA3AD		..RIVET- (SIZE DETERMINE ON INST)		8
218	BRM300A08		..NUTPLATE- (V52828) (SPEC BACN10JP08C) (OPT MK3000-08BAC (V15653)) (OPT NS103199-82 (V80539)) (OPT RMA9205M82 (V72962)) (OPT T8078S832 (V11815)) (OPT VN203A1-82 (V92215))		4
219	141T6271-14		DELETED		
219A	141T6271-4		..LEVER	A,C,E,G	1
-222	141T6271-13		DELETED		
-222A	141T6271-3		..LEVER	B,D,F,H	1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	225	BACB30NM6K70		.BOLT		1
	228	AN960KD616		.WASHER		1
	231	MS21042L6		.NUT	A-D	1
	-231A	H52732-6CD		.NUT-	E-H	1
				(V15653)		
				(SPEC BACN10YR6CD)		
				(OPT PLH56CD		
				(V62554))		
	234	BACB30NR4K11		.BOLT		1
	237	AN960-416L		.WASHER		1
	240	BACB28AK04-026		.BUSHING		1
	243	MS21042L4		.NUT	A-D	1
	-243A	H52732-4CD		.NUT-	E-H	1
				(V15653)		
				(SPEC BACN10YR4CD)		
				(OPT PLH54CD		
				(V62554))		
	246	141T6277-2		.LINK ASSY		1
	249	69-38919-35		..SLEEVE-		2
				(MFD FROM AL SH 6061-0		
				QQ-A-250/11 F25.01 OPTL		
				AL TUBING 6061-0		
				WW-T-700/6 .063IN		
				.374IN)		
				(OPT ITEM 249A)		
R	-249A	69-38919-58		..SLEEVE-		2
				(MFD FROM 6061-0 SHT PER		
				QQ-A-250/11 OR 6061-0		
				TUBING PER WW-T-700/6		
				OPTIONAL MATERIAL -		
				6061-T6 ROD PER		
				QQ-A-225/8, ANNEAL TO		
				6061-0 AFTER MACHINING)		
				(OPT ITEM 249)		

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
252	KSP4A		..BEARING- (V38443) (SPEC BACB10AC4A) (OPT HHKSP4A (V38443)) (OPT KSP4AE944OA (V21335)) (OPT KSP4AFS428 (V21335)) (OPT KSP4A2TS (V43991)) (OPT KSP4AG27 (V30163)) (OPT 4AFS428 (V21335))		2
255	141T6277-4		..LINK		1
258	BACB30NR4K11		.BOLT		1
261	AN960-416L		.WASHER		1
264	BACB28AK04-026		.BUSHING		1
267	MS21042L4		.NUT	A-D	1
-267A	H52732-4CD		.NUT- (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))	E-H	1
270	BACB30NR4K26		.BOLT	A,C, E,G	1
271	BACB30NR4K26		.BOLT	B,D, F,H	1
272	AN960-416L		.WASHER	B,D, F,H	1
273	AN960-416L		.WASHER	A,C, E,G	2

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	274	BACB28Y4C089		.BUSHING	B,D, F,H	1
	275	AN960-416L		.WASHER	B,D, F,H	1
	276	BACB28Y4C089		.BUSHING	A,C, E,G	1
	277	BACB28AK04-027		.BUSHING	B,D, F,H	1
	278	MS21042L4		.NUT	B,D	1
	278A	BACN10YR4CD		.NUT	F,H	
	282	BACB28AK04-027		.BUSHING	A,C, E,G	1
	285	MS21042L4		.NUT	A,C	1
	285A	BACN10YR4CD		.NUT	E,G	1
	288	141T6277-1		.LINK ASSY		1
	291	69-38919-35		..SLEEVE- (MFD FROM AL SH 6061-O QQ-A-250/11 F25.01 OPTL AL TUBING 6061-O WW-T-700/6 .063IN 0374IN) (OPT ITEM 291A)		2
R	-291A	69-38919-58		..SLEEVE- (MFD FROM 6061-O SHT PER QQ-A-250/11 OR 6061-O TUBING PER WW-T-700/6 OPTIONAL MATERIAL - 6061-T6 ROD PER QQ-A-225/8, ANNEAL TO 6061-O AFTER MACHINING) (OPT ITEM 291)		2

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
294	KSP4A		..BEARING- (V38443) (SPEC BACB10AC4A) (OPT HHKSP4A (V38443)) (OPT KSP4AE944OA (V21335)) (OPT KSP4AFS428 (V21335)) (OPT KSP4A2TS (V43991)) (OPT KSP4AG27 (V30163)) (OPT 4AFS428 (V21335))		2
297	141T6277-3		..LINK		1
300	BACB30NM4K14		.BOLT		1
303	AN960-416L		.WASHER		1
306	MS21042L4		.NUT	A-D	1
-306A	H52732-4CD		.NUT- (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))	E-H	1
309	143T6142-1		.LEVER ASSY-GIRT DRIVE		1
312	BACB28X6M010		..BUSHING		1
315	BACB28X4C012		..BUSHING		1
318	143T6142-2		..LEVER		1
321	BACB30NR4K16		.BOLT		1
324	AN960KD416		.WASHER		1
327	BACB28AK04-075		.BUSHING		1
330	MS21042L4		.NUT	A-D	1
-330A	H52732-4CD		.NUT- (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))	E-H	1
333	69B13067-7		.HOUSING ASSY		1
336	141T6287-15		..BUSHING		2
339	69B13067-6		..HOUSING		1
342	69B14846-2		.SPRING		1
345	BACW10P121C		.WASHER		4

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
348	BACB30NR4K11		.BOLT		1
351	AN960-416L		DELETED		
351A	AN960KD416		.WASHER		1
354	BACB28AK04-026		.BUSHING		1
357	MS21042L4		.NUT	A-D	1
-357A	H52732-4CD		.NUT- (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))	E-H	1
360	69B13060-7		.PISTON ASSY		1
363	KSP4A		..BEARING- (V38443) (SPEC BACB10AC4A) (OPT HHKSP4A (V38443)) (OPT KSP4AE9440A (V21335)) (OPT KSP4AFS428 (V21335)) (OPT KSP4A2TS (V43991)) (OPT KSP4AG27 (V30163)) (OPT 4AFS428 (V21335))		1
366	69B13060-8		..PISTON		1
369	MS16624-1062		.RING		1
372	NAS1351-4-76P		.SCREW		1
375	NAS43HT4-4		.SPACER		1
378	141T6249-6		.HANDLE ASSY-YELLOW	G,H	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-378A	141T6249-1		.HANDLE ASSY-GREEN	A-F	1
381	141T6249-4		..PIN		2
384	141T6249-3		..HANDLE		1
387	141T6248-5		.LEVER ASSY		1
389	SLR4027-4		..RETAINER- (V97393) (SPEC BACR10V4) (OPT 2452-048RET (V72962))		1
391	LH8065-048		..NUT- (V72962) (SPEC BACN10HC4) (OPT SL414-4 (V97393)) (OPT 94263-428 (V56878))		1
396	141T6248-6		..LEVER		1
399	BACB30NM4K14		.BOLT		1
402	AN960-416L		.WASHER		1
405	MS21042L4		.NUT	A-D	1
-405A	H52732-4CD		.NUT- (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))	E-H	1
408	141T6220-3		.ADAPTER		1
411	BACB30NM4K14		.BOLT		1
414	AN960-416L		.WASHER		1
417	MS21042L4		.NUT	A-D	1
-417A	H52732-4CD		.NUT- (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))	E-H	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
420	141T6193-1		.LEVER ASSY		1
423	BACB28X6M010		..BUSHING		1
426	BACB28X4C012		..BUSHING		1
429	141T6193-3		..LEVER		1
432	BACB30NM4K14		.BOLT		1
435	AN960-416L		.WASHER		1
438	141T6652-2		.SECTOR ASSY		1
441	LH8065-048		..NUT- (V72962) (SPEC BACN10HC4) (OPT SL414-4 (V97393)) (OPT 94263-428 (V56878))		1
444	SLR4027-4		..RETAINER- (V97393) (SPEC BACR10V4) (OPT 2452-048RET (V72962))		1
447	BACB28X6M012		..BUSHING		1
450	BACB28X4C012		DELETED		
450A	BACB28X4C011		..BUSHING		1
453	141T6652-5		..SECTOR		1
456	141T6198-2		.SHAFT	A,C,E,G	1
-457	141T6198-3		.SHAFT	B,D,F,H	1
459	141T6203-5		.WASHER		2
465	141T6203-6		.WASHER-SPRING		1
468	SAT1624A1501		.BEARING- (V77896)		2
471	MS24665-134		.PIN-COTTER		1
474	AN960-416L		.WASHER		1
477	BACP18T4K72		.PIN-FLATHEAD		1
480	BACW10P321S		.WASHER		AR
483	NAS72-4E005		.SPACER		2
486	141T6650-1		.SPRING		1
489	141T6651-1		.LEVER ASSY		1
492	BACR15BB4B		..RIVET- (SIZE DETERMINE ON INST)		2
495	NAS42DD4-24		..SPACER		2

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
498	BACR15BA3AD		..RIVET- (SIZE DETERMINE ON INST)		2
501	BR2000C4M		..NUTPLATE- (V52828) (SPEC BACN10JR4CM) (OPT K1001-4BAC (V15653)) (OPT NS103202SE048 (V80539)) (OPT T8089C428 (V11815)) (OPT VN102D1-048 (V92215)) (OPT 109A9201-4 (V72962))		1
504	295927-50		..SPACER- (V60119) (SPEC BACS18G5OB)		1
507	141T6651-4		..PLATE		1
510	141T6651-5		..PLATE		1
513	141T6651-2		..LEVER		1
516	NAS604-24P		.SCREW		1
519	NAS43HT4-4		.SPACER		1
522	BACW10P129AM		.WASHER		AR
525	141T6538-7		.BUTTON-LOCKOUT GREEN	A-F	1
R -525A	141T6538-10		.BUTTON-LOCKOUT YELLOW	G,H	1
528	MS18066-69		.SETSCREW- (OPT ITEM 528A)		2
R -528A	MS51023-122		.SETSCREW- (OPT ITEM 528)		2
531	141T6649-2		.SUPPORT ASSY	A,C,E,G	1
-534	141T6649-1		.SUPPORT ASSY	B,D,F,H	1
			ATTACHING PARTS		
537	BACB30NM4K50		.BOLT		2
540	AN960-416L		.WASHER		2
541	AN960-416L		.WASHER		AR
543	MS21042L4		.NUT	A-D	2
-543A	H52732-4CD		.NUT- (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))	E-H	2
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	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	546	MS21209F4-15P		..INSERT		2
	549	141T6649-4		..SUPPORT	A,C,E,G	1
	-552	141T6649-3		..SUPPORT	B,D,F,H	1
	555	BACB28X4M010		.BUSHING		2
	556	BACB28X4C024		.BUSHING		2
	558	BACB28AK04-258		.BUSHING		2
	561	BACB30NM4K25		.BOLT		1
	564	AN970-4		.WASHER		1
	567	AN960-416		.WASHER		1
	570	MS21042L4		.NUT	A-D	1
	-570A	H52732-4CD		.NUT- (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))	E-H	1
	573	141T6274-2		.GUIDE ASSY		1
	576	69-38919-35		..SLEEVE- (MFD FROM AL SH 6061-O QQ-A-250/11 F25.01 OPTL AL TUBING 6061-O WW-T-700/6 .063IN .374IN) (OPT ITEM 576A)		1
R	-576A	69-38919-58		..SLEEVE- (MFD FROM 6061-O SHT PER QQ-A-250/11 OR 6061-O TUBING PER WW-T-700/6 OPTIONAL MATERIAL - 6061-T6 ROD PER QQ-A-225/8, ANNEAL TO 6061-O AFTER MACHINING) (OPT ITEM 576)		1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
579	KSP4A		..BEARING- (V38443) (SPEC BACB10AC4A) (OPT HHKSP4A (V38443)) (OPT KSP4AE944OA (V21335)) (OPT KSP4AFS428 (V21335)) (OPT KSP4A2TS (V43991)) (OPT KSP4AG27 (V30163)) (OPT 4AFS428 (V21335))		1
582	141T6274-4		..GUIDE		1
585	141T6258-3		.SPRING		1
588	BACB30NR4K10		.BOLT		1
591	BACB28AK04-026		.BUSHING		1
594	AN960-416		.WASHER		1
597	MS21042L4		.NUT	A-D	1
-597A	H52732-4CD		.NUT- (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))	E-H	1
600	141T6274-1		.GUIDE ASSY		1
603	69-38919-35		..SLEEVE- (MFD FROM AL SH 6061-O QQ-A-250/11 F25.01 OPTL AL TUBING 6061-O WW-T-700/6 .063IN .374IN) (OPT ITEM 603A)		1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R	01- -603A	69-38919-58		..SLEEVE- (MFD FROM 6061-0 SHT PER QQ-A-250/11 OR 6061-0 TUBING PER WW-T-700/6 OPTIONAL MATERIAL - 6061-T6 ROD PER QQ-A-225/8, ANNEAL TO 6061-0 AFTER MACHINING) (OPT ITEM 603)		1
	606	KSP4A		..BEARING- (V38443) (SPEC BACB10AC4A) (OPT HHKSP4A (V38443)) (OPT KSP4AE9440A (V21335)) (OPT KSP4AFS428 (V21335)) (OPT KSP4A2TS (V43991)) (OPT KSP4AG27 (V30163)) (OPT 4AFS428 (V21335))		1
	609	141T6274-5		..BUSHING		1
	612	141T6274-3		..HOUSING		1
	615	BACB30NM4K12		.BOLT		1
	618	AN960-416		.WASHER		1
	621	MS21042L4		.NUT	A-D	1
	-621A	H52732-4CD		.NUT- (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))	E-H	1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	624	141T6205-1		.LEVER ASSY		1
	627	BACB28X6M010		..BUSHING		1
	630	BACB28X4C013		DELETED		
R	630A	BACB28X4C010		..BUSHING		1
	633	141T6205-2		..LEVER		1
	636	BACB30NN4K14		.BOLT		1
	639	AN960-416L		.WASHER		1
	642	MS21042L4		.NUT	A-D	1
	-642A	H52732-4CD		.NUT- (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))	E-H	1
	645	141T6195-2		.CAM ASSY	A,C,E,G	1
	-648	141T6195-1		.CAM ASSY	B,D,F,H	1
	651	BACR15CE5M		..RIVET- (SIZE DETERMINE ON INST)		4
	654	141T6210-1		..LEVER		1
	657	141T6195-3		..SHIM		2
	660	141T6200-2		..CAM	A,C,E,G	1
	-663	141T6200-1		..CAM	B,D,F,H	1
	665	BAC27TBY0033		..MARKER		1
	665J	MS24665-376		.PIN-COTTER		1
	666	BMN4122C1D2-12		DELETED		
	666A	BMN4122C1D2-12		DELETED		
	-666B	BACN10YR12CM		DELETED		
	666C	BACN10JD112		.NUT		1
	669	AN960-1216L		.WASHER		1
	672	141T6207-6		.LEVER ASSY-CARRIER DRIVE (FOR DETAILS SEE FIG. 3)		1
	674	BACB30NR4K22		.BOLT	B,D,F,H	1
	675	BACB30NR4K22		.BOLT	A,C,E,G	1
	676	AN960-416L		.WASHER	B,D,F,H	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
677	BACB28AK04-028		.BUSHING	B,D, F,H	1
678	AN960-416L		.WASHER	A,C, E,G	1
679	AN960-416L		.WASHER	B,D, F,H	1
680	BACB28Y4C037		.BUSHING	B,D, F,H	1
681	BACB28Y4C037		.BUSHING	A,C, E,G	1
682	MS21042L4		.NUT	B,D	1
682A	BACN10YR4CD		.NUT	F,H	
684	AN960-416L		.WASHER	A,C, E,G	1
687	BACB28AK04-028		.BUSHING	A,C, E,G	1
690	MS21042L4		.NUT	A,C	1
-690A	H52732-4CD		.NUT- (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))	E,G	1
693	141T6214-1		.CRANK		1
696	NAS428-4-10		.BOLT		1
699	AN960-416L		.WASHER		14
702	MS21042L4		.NUT	A-D	1
-702A	H52732-4CD		.NUT- (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))	E-H	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
705	141T6201-3		.SPACER		AR
708	141T6201-4		.SPACER		AR
711	141T6201-5		.SPACER		AR
714	141T6203-3		.WASHER		21
717	141T6203-4		.WASHER-SPRING		1
720	B539DDFS428		.BEARING- (V21335) (SPEC BACB10CF12PP) (OPT B539DDFS101 (V06144)) (OPT T339E (VK8455)) (OPT B539SSG27 (V30163)) (OPT B539DD (V38443)) (OPT B539-2TS (V43991)) (OPT B539FS101 (V06144))		2
723	141T6199-1		DELETED		
723A	141T6199-2		.SHAFT		1
726	141T6188-5		.STOP ASSY	A,C,E,G	1
-729	141T6188-6		.STOP ASSY	B,D,F,H	1
			ATTACHING PARTS		
732	BACB30NR4K15		DELETED		
732A	BACB30NR4K22		.BOLT		1
735	BACB30NR4K16		.BOLT		1
738	AN960-616		.WASHER		11
741	BACW10P221S		.WASHER		10
744	AN960KD416		.WASHER		2
747	MS21042L4		.NUT	A-D	2
-747A	H52732-4CD		.NUT- (V15653) (SPEC BACN10YR4CD) (OPT PLH54CD (V62554))	E-H	2
			-------*-------		
750	141T6521-6		..RING		1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
753	B540DDFS428		..BEARING- (V21335) (SPEC BACB10CF14PP) (OPT B540-2TS (V43991)) (OPT B540SSG27 (V30163)) (OPT T340E (VK8455)) (OPT B540DDFS101 (V06144)) (OPT B540DD (V38443)) (OPT B540FS101 (V06144))		1
756	141T6188-13		..STOP	A,C,E,G	1
-759	141T6188-14		..STOP	B,D,F,H	1
762	BACB28AK04-040		.BUSHING		1
765	BACB28AK04-070		.BUSHING		1
768	BACB30NM3K12		.BOLT		1
771	AN960C10L		.WASHER		1
774	BACN10JC3CM		.NUT	A-D	1
-774A	H52732-3CM		.NUT- (V15653) (SPEC BACN10YR3CM) (OPT PLH53CM (V62554))	E-H	1
777	141T6287-9		.BUSHING		1
780	141T6287-4		.ROLLER ASSY		1
783	141T6287-14		..BUSHING		2
786	141T6287-8		..ROLLER		1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
789	HL11VAZ8-5		.BOLT- (V56878) (SPEC BACB30NW8K5) (OPT B30NW8K5 (V97928)) (OPT HL11VAZ8-5 (V73197)) (OPT HL11VAZ8-5 (V92215)) (OPT HL11VAZ8-5 (V97928)) (OPT L803-8K5 (V06725)) (OPT HL11VAZ8-5 (VOPTK6)) (OPT HL11VAZ8-5 (V60516))		3
792	AN960C416		.WASHER		3
795	BACN10JC4CM		.NUT	A-D	3
-795A	H52732-4CM		.NUT- (V15653) (SPEC BACN10YR4CM) (OPT PLH54CM (V62554))	E-H	3
798	141T6286-1		.SHIM		1
801	141T6284-1		.SUPPORT		1
804	BACB30NM3K8		.BOLT		1
807	AN960C10		.WASHER		1
810	BACN10JC3CM		.NUT	A-D	1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
	-810A	H52732-3CM		.NUT- (V15653) (SPEC BACN10YR3CM) (OPT PLH53CM (V62554))	E-H	1
	813	141T6287-2		.BUSHING		1
	816	141T6287-3		.ROLLER ASSY		1
	819	141T6287-14		..BUSHING		2
	822	141T6287-7		..ROLLER		1
	825	BACB30LK3-13		.BOLT		1
	828	NAS1805-3		.NUT		1
	831	141T6287-1		.BUSHING		2
R	831G	143T6140-19		.KIT ASSY-SUB (OPT ITEM 831N)	E-H	1
R	-831N	143T6140-20		.KIT ASSY-SUB (OPT ITEM 831G)	E-H	1
R	831U	141T6103-1		..CLIP- (USED ON ITEM 831G)	E-H	1
	-832	143T6140-5001		DELETED		
	-832A	143T6140-5002		DELETED		
R	832B	141T6280-1		..LEVER-(MATCHED SET) (USED ON ITEMS 831G, 831N)	E-H	1
R	832L	141T6280-2		..LEVER-(MATCHED SET) (USED ON ITEM 831G)	E-H	1
R	-832M	141T6280-3		..LEVER-(MATCHED SET) (USED ON ITEM 831N)	E-H	1
R	833	141T6103-1		.CLIP- (ITEM 833 WITH ITEMS 834A AND 837A IS OPT TO THE MATCHED SET OF ITEMS 834A AND 837B)	A-D	1

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	01-					
R	-833A	141T6103-1		.CLIP- (POST SB 767-52A0057)	A-C	1
	834	141T6280-1		DELETED		
R	834A	141T6280-1		.LEVER-(MATCHED PART) (ITEM 833 WITH ITEMS 834A AND 837A IS OPT TO THE MATCHED SET OF ITEMS 834A AND 837B)	A-D	1
	837	141T6280-2		DELETED		
R	837A	141T6280-2		.LEVER-(MATCHED PART) (ITEM 833 WITH ITEMS 834A AND 837A IS OPT TO THE MATCHED SET OF ITEMS 834A AND 837B)	A-D	1
R	-837B	141T6280-3		.LEVER-(MATCHED PART) (ITEM 833 WITH ITEMS 834A AND 837A IS OPT TO THE MATCHED SET OF ITEMS 834A AND 837B)	A-D	1
	838	141T6103-1		DELETED		
	838H	141T6280-1		DELETED		
	839	141T6280-2		DELETED		
	-839A	141T6280-3		DELETED		
	840	BACB30NM4HK10		.BOLT		2
	843	AN960-416		.WASHER		2
	846	141T6288-1		.RETAINER		1
	849	141T6231-1		.PIN		1
	852	141T6232-1		.RETAINER		1
	855	141T6226-1		.BUSHING		1
	858	141T6287-17		.SHAFT		1
	861	141T6219-1		.SPRING		1
	864	NAS509-4C		.NUT		1
	867	NAS513-4		.WASHER		1
	870	141T6287-5		.END ASSY-ROD		1
	873	141T6287-14		..BUSHING		2
	876	141T6287-10		..END		1
	879	MS19068-002		.NUT		1
	882	MS19070-002		.WASHER		1
	885	AN960-716		.WASHER		1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
888	BACB30NM4HK2		.BOLT		3
891	AN960-416		.WASHER		3
894	141T6282-1		.RETAINER		1
897	141T6286-2		.SHIM		1
900	KP10AFS428		.BEARING- (V21335) (SPEC BACB10BX10) (OPT KP10A2TS (V43991)) (OPT LLKP10A (V38443))		1
903	141T6203-7		.WASHER		8
906	141T6229-1		.SPACER		1
909	141T6500-1		.WASHER		1
912	MS28775-127		.PACKING		1
915	141T6208-1		.RING-SEAL		1
918	141T6203-8		.WASHER		12
921	KP23B		.BEARING- (V38443) (SPEC BACB10BW23) (OPT KP23B2TS (V43991)) (OPT LLKP23B (V38443)) (OPT KP23BG27 (V30163)) (OPT KP23BFS428 (V21335)) (OPT KP23BLY196 (V40920)) (OPT KP23BSD610 (V83086))		1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
924	141T6228-6		DELETED		
924A	141T6228-2		.SHAFT ASSY-PIVOT	A,C,E,G	1
-927	141T6228-5		DELETED		
-927A	141T6228-1		.SHAFT ASSY-PIVOT	B,D,F,H	1
930	BACB28X6C010		..BUSHING		1
933	BACB28X9M010		..BUSHING		1
936	141T6228-8		DELETED		
936A	141T6228-4		..SHAFT	A,C,E,G	1
-939	141T6228-7		DELETED		
-939A	141T6228-3		..SHAFT	B,D,F,H	1
942	141T6500-2		.PLUG		1
945	141T6159-14		DELETED		
945A	141T6159-12		.HANDLE ASSY- (FOR DETAILS SEE FIG. 4)	A,C,E,G	1
-948	141T6159-13		DELETED		
-948A	141T6159-11		.HANDLE ASSY- (FOR DETAILS SEE FIG. 4)	B,D,F,H	1
951	NAS428-4-12		.BOLT		1
952	AN316C4R		.NUT		1
953	AN960KD416L		.WASHER		1
954	NAS428-4-7		.BOLT		1
955	AN960KD416L		.WASHER		1
956	B0500-038S		.WASHER- (V83553) (OPT ITEMS 956A, 956B)		AR

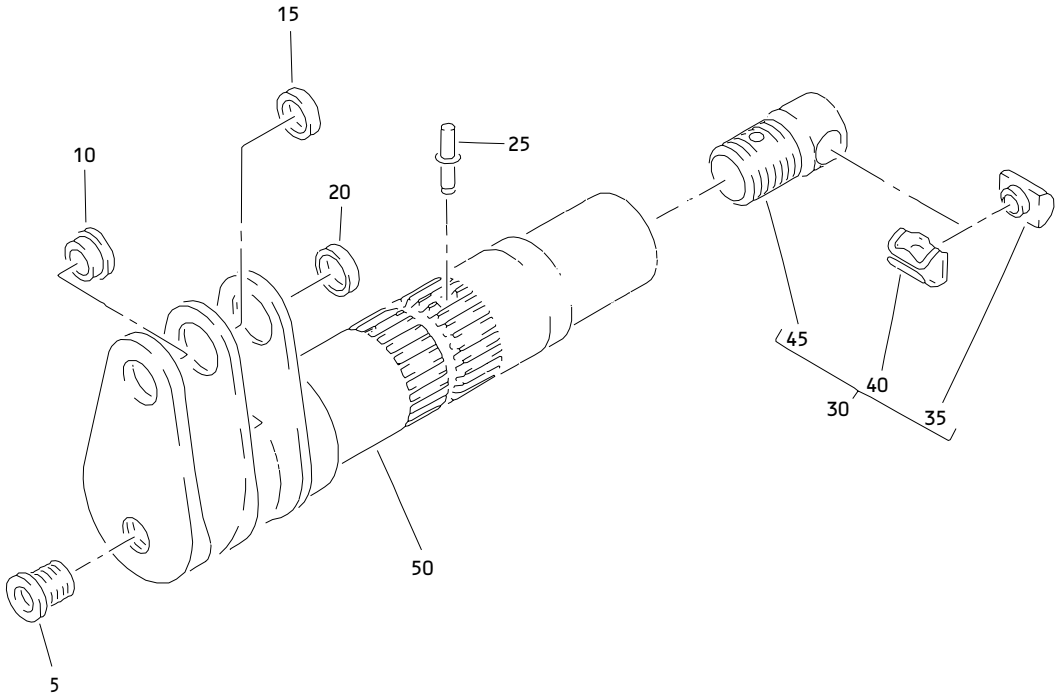
FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-956A	AN960KD416		.WASHER- (OPT ITEMS 956, 956B)		AR
-956B	AN960KD416L		.WASHER- (OPT ITEMS 956, 956A)		AR
957	BACB30NF4-4		.BOLT		1
958	AN960KD416L		.WASHER		1
959	141T6136-25		DELETED		
959A	MS20392-3C69		.PIN-DRILLED SHANK (V96906)		1
960	141T6661-1		.BASE-ARMING SYS EXTERNAL LOCK		1
961	141T6663-1		.SPRING-ARMING SYS EXTERNAL LOCK TORSION		1
962	141T6662-2		.PAWL-ARMING SYS EXTERNAL LOCK	A,C,E,G	1
-963	141T6662-1		.PAWL-ARMING SYS EXTERNAL LOCK	B,D,F,H	1
964	BACB30NT3K3		.BOLT		2
966	AN960D10L		.WASHER		2
969	MS21042L3		.NUT	A-D	2
-969A	H52732-3CD		.NUT- (V15653) (SPEC BACN10YR3CD) (OPT PLH53CD (V62554))	E-H	2
972	BACS45A26		.SEAL		1
975	BACB30NT2K3		.BOLT		1
978	AN960KD8L		.WASHER		1
981	AN960KD8		.WASHER		1
982	BACB30NM4K12		DELETED		
982A	BACB30NM4K6		.BOLT	C-H	3
982C	AN960C416L		.WASHER	C-H	3
982E	NAS1329H4K200L		.NUT- (ITEM 982E WITH ITEM 984A OPT TO ITEM 984B) (USED WITH 984A)	C	3
983	143T6156-2		.BRACKET-CAM (OPT ITEM 983A)	C,E,G	1
-983A	143T6156-6		.BRACKET-CAM (OPT ITEM 983)	C,E,G	1
-983C	143T6156-1		.BRACKET-CAM (OPT ITEM 983D)	D,F,H	1
-983D	143T6156-5		.BRACKET-CAM (OPT ITEM 983C)	D,F,H	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
984	141T6133-76		.SUPPORT ASSY-HANDLE (FOR DETAILS SEE FIG. 5)	A	1
984A	141T6133-76		.SUPPORT ASSY-HANDLE (LIMITED) (ITEM 982E WITH ITEM 984A OPT TO ITEM 984B) (FOR DETAILS SEE FIG. 5)	C	1
984B	141T6133-86		.SUPPORT ASSY-HANDLE (LIMITED) (ITEM 982E WITH ITEM 984A OPT TO ITEM 984B) (FOR DETAILS SEE FIG. 5)	C	1
-984C	141T6133-86		.SUPPORT ASSY-HANDLE (FOR DETAILS SEE FIG. 5)	E,G	1
985	NAS1330H4K211L		.NUT-*(2) (LIMITED)	C,D	3
-985A	NAS1329H4K200L		.NUT-*(2) (LIMITED)	C,D	3
986	BACS40U4N2		.SHIM-*(2) (LIMITED)	C,D	AR
-987	141T6133-75		.SUPPORT ASSY-HANDLE (FOR DETAILS SEE FIG. 5)	B	1
-987A	141T6133-85		.SUPPORT ASSY-HANDLE (FOR DETAILS SEE FIG. 5)	D,F,H	1

- Item Not Illustrated

*(1) TOP ASSEMBLIES 143T6140-7 AND -8 PRODUCTION UNITS USE CLUTCH ASSEMBLY 143T6155-1. TOP ASSEMBLIES 143T6140-3 AND -4 THAT WERE REWORKED TO 143T6140-7 AND -8 PER SERVICE BULLETIN 767-52-0058 USE CLUTCH ASSEMBLY 143T6155-5

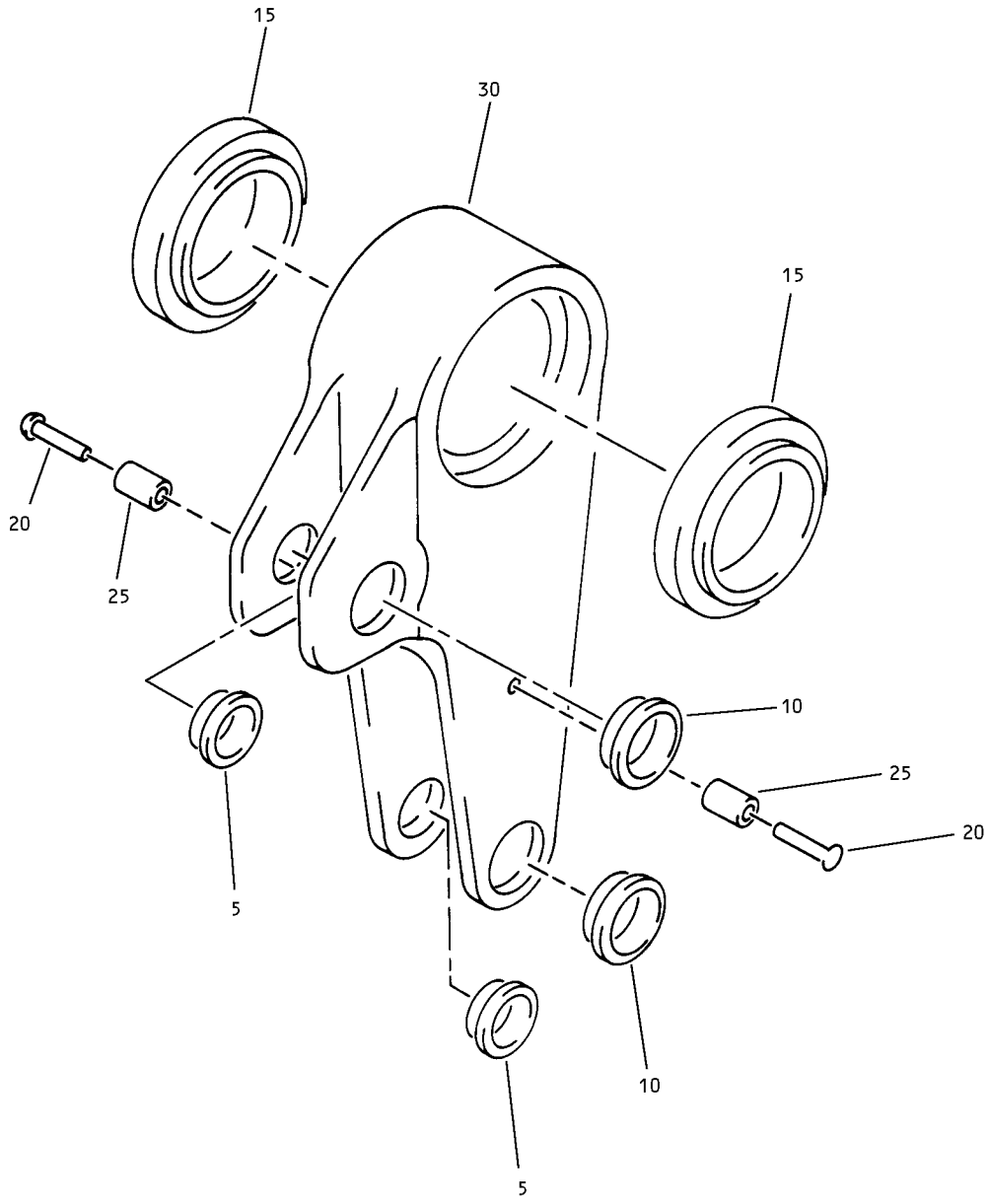
*(2) THESE COMONENTS ARE BONDED TO MECHANISM ASSEMBLIES MID ENTRY AND SERVICE DOOR HANDLE THAT WERE REWORKED FROM 143T6140-3 AND -4 TO 143T6140-7 AND -8 PER SERVICE BULLETIN 767-52-0058



Inside Handle Shaft Assembly
Figure 2

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
02-					
-1	141T6221-1		SHAFT ASSY-INSIDE HANDLE PIVOT		RF
5	NAS1394C4L		.INSERT		1
10	BACB28X6C016		.BUSHING		1
15	BACB28Y9M015		.BUSHING		1
20	BACB28Y9M013		.BUSHING		1
25	NAS1399MW4-5		.RIVET		1
30	141T6224-3		.NUT ASSY		1
35	LH8065-054		..NUT- (V72962) (SPEC BACN10HC5) (OPT SL414-5 (V97393)) (OPT 94263-524 (V56878))		1
40	SLR4027-5		..RETAINER- (V97393) (SPEC BACR10V5) (OPT 2452-054RET (V72962))		1
45	141T6224-1		..HOUSING		1
50	141T6221-4		.SHAFT		1

- Item Not Illustrated

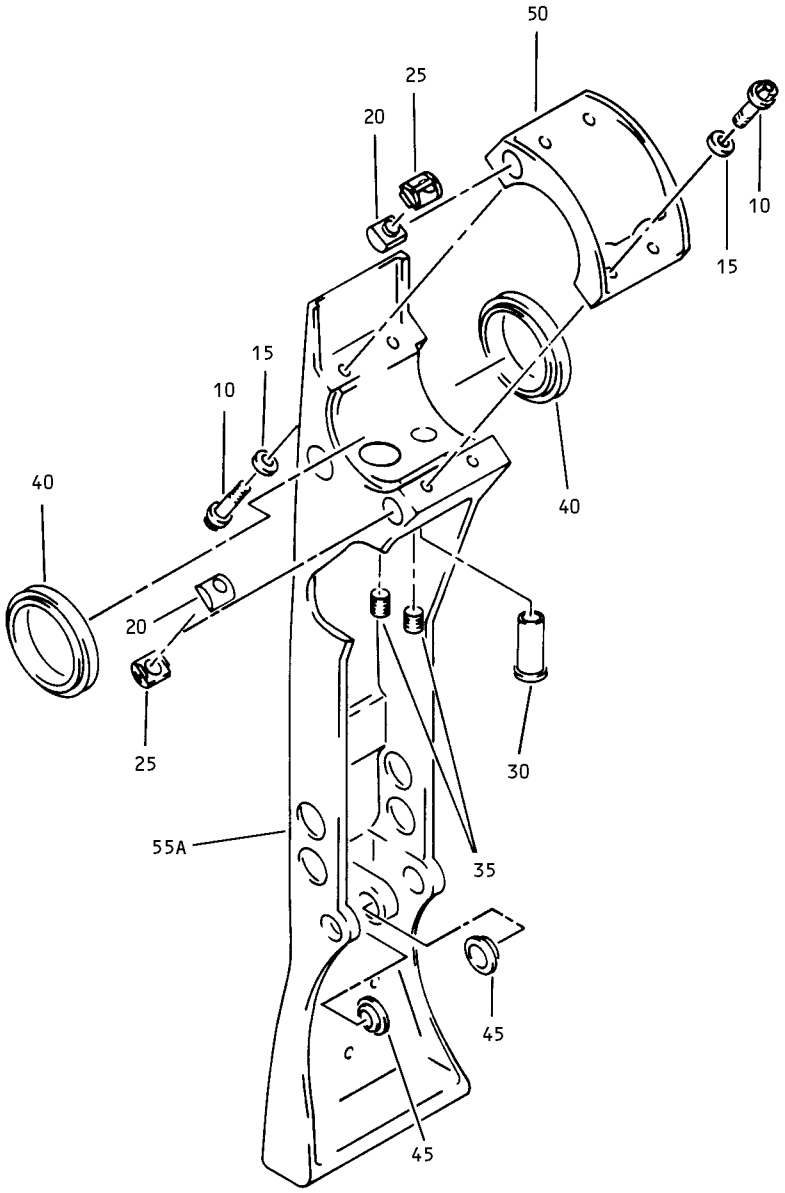


Carrier Drive Lever Assembly
Figure 3

J00479

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
03-					
-1	141T6207-6		LEVER ASSY-CARRIER DRIVE		RF
5	BACB28X4C010		.BUSHING		2
10	BACB28X6M012		.BUSHING		2
15	B540DDFS428		.BEARING- (V21335) (SPEC BACB10CF14PP) (OPT B540-2TS (V43991)) (OPT B540SSG27 (V30163)) (OPT T340E (VK8455)) (OPT B540DDFS101 (V06144)) (OPT B540DD (V38443)) (OPT B540FS101 (V06144))		2
20	BACR15BB4AD10		.RIVET		2
25	NAS42DD4-24		.SPACER		2
30	141T6207-8		.LEVER		1

- Item Not Illustrated

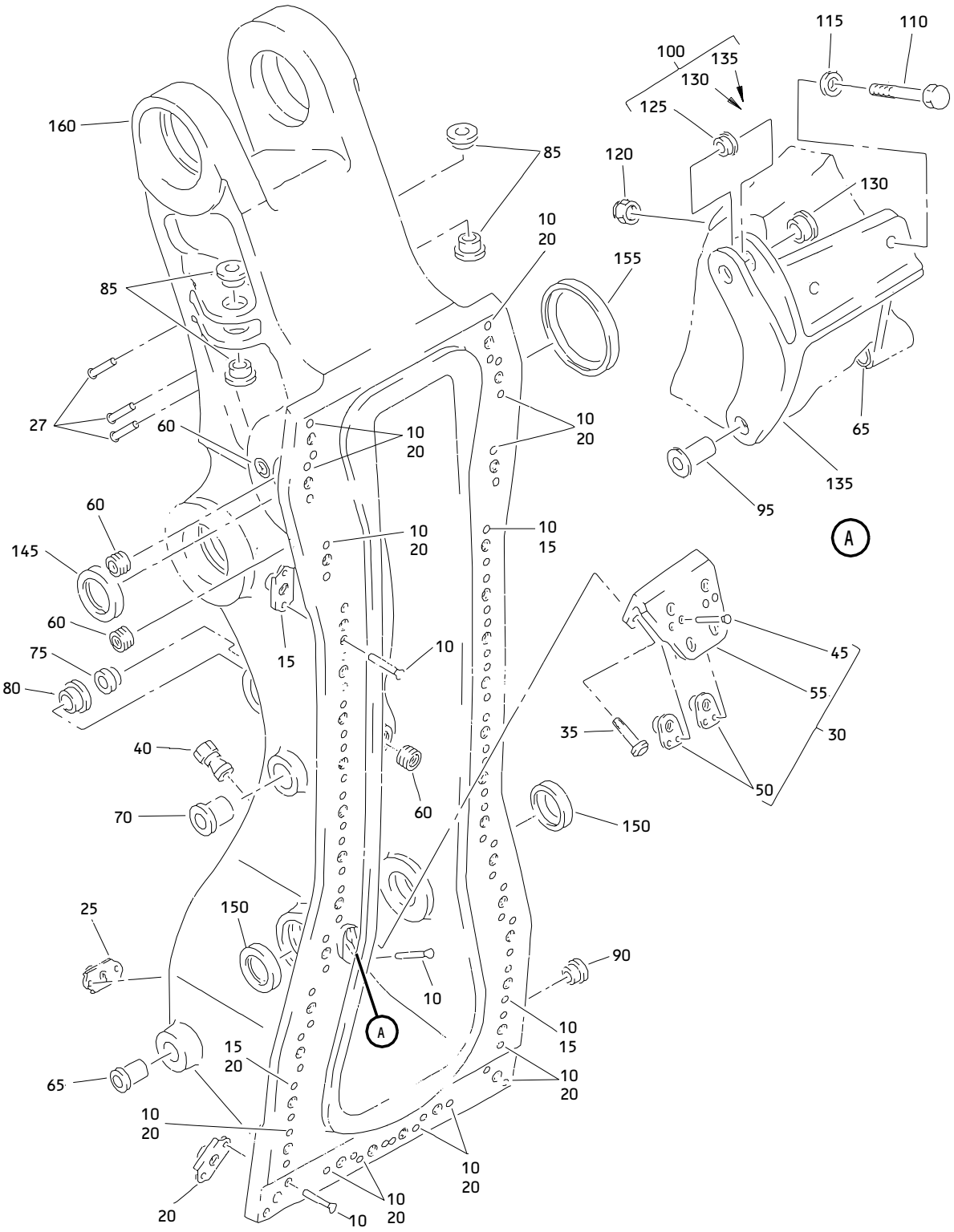


Exit Handle Assembly
Figure 4

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
04-					
-1	141T6159-14		DELETED		
-1A	141T6159-12		HANDLE ASSY-EXT	A,C,E,G	RF
-5	141T6159-13		DELETED		
-5A	141T6159-11		HANDLE ASSY-EXT	B,D,F,H	RF
10	BACB30MR4K10		.BOLT		4
15	BACW10BN4AC		.WASHER		4
20	NAS577-4A		.NUT		4
25	NAS578-4		.RETAINER		4
30	BACB28X6M109		.BUSHING		1
35	NAS1394C4L		.INSERT		2
40	B542DDFSS428		.BEARING- (V21335) (SPEC BACB10CF21PP) (OPT B542-2TS (V43991)) (OPT B542SSG27 (V30163)) (OPT T342E (VK8455)) (OPT B542DDFS101 (V06144)) (OPT B542DD (V38443)) (OPT B542FS101 (V06144))		2
45	141T6287-16		.BUSHING		2
50	141T6159-7		.CAP-(MATCHED PART)		1
55	141T6159-18		DELETED		
55A	141T6159-16		.HANDLE-(MATCHED PART)	A,C,E,G	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
04-					
-60	141T6159-17		DELETED		
-60A	141T6159-15		.HANDLE-(MATCHED PART)	B,D,F,H	1

- Item Not Illustrated



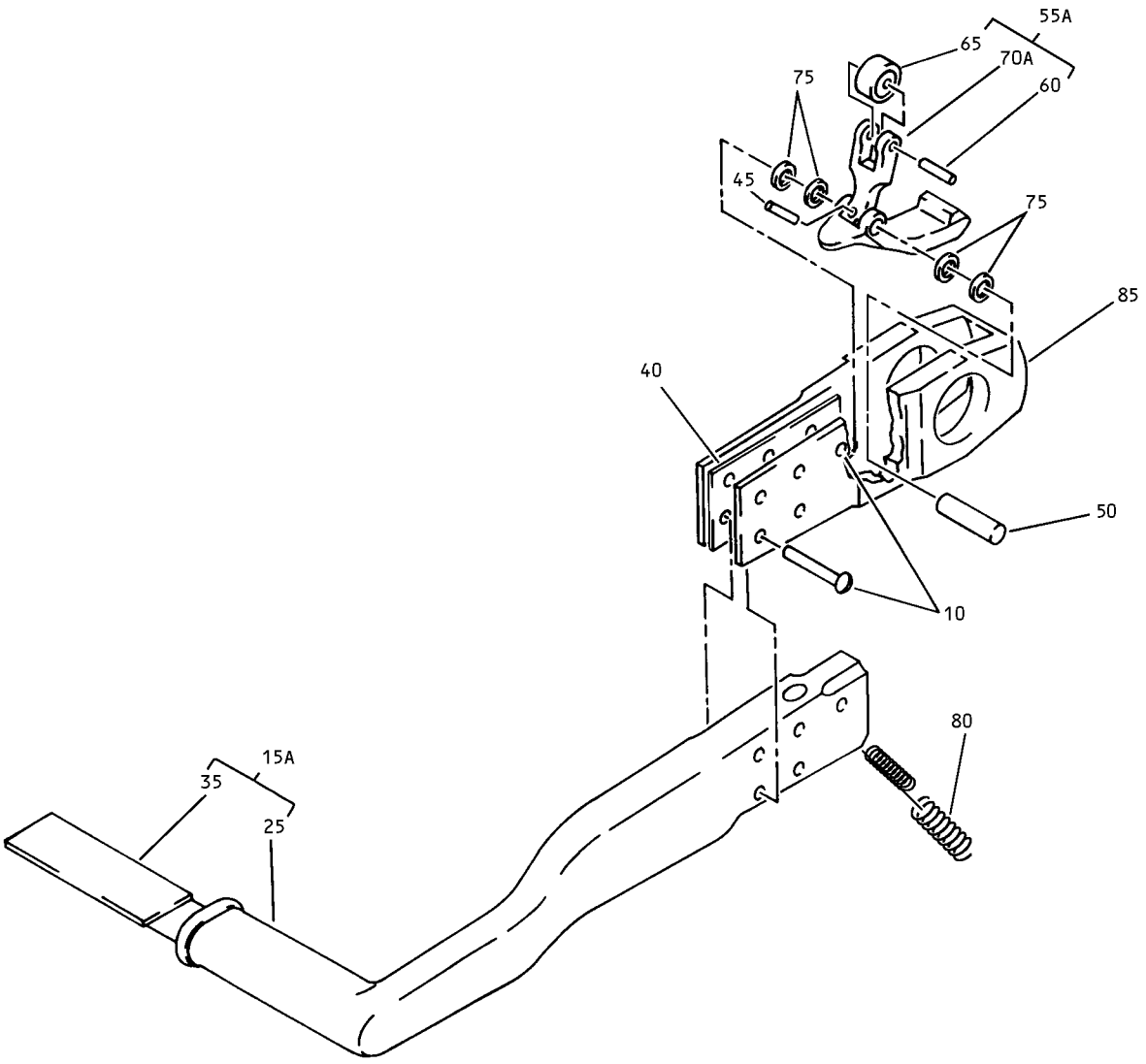
Handle Support Assembly
Figure 5

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
05-					
-1	141T6133-76		SUPPORT ASSY-HANDLE	A,C	RF
-1A	141T6133-86		SUPPORT ASSY-HANDLE	C,E,G	RF
-5	141T6133-75		SUPPORT ASSY-HANDLE	B	RF
-5A	141T6133-85		SUPPORT ASSY-HANDLE	D,F,H	RF
10	BACR15DR3		.RIVET- (SIZE DETERMINE ON INST) (OPT ITEM 10A)	A,B	74
-10A	BACR15BA3AD		.RIVET- (SIZE DETERMINE ON INST) (OPT ITEM 10)	A,B	74
-10B	BACR15DR3		.RIVET- (SIZE DETERMINE ON INST)	C-H	74
15	MF19058-4-2BAC		.NUTPLATE- (V15653) (SPEC BACN10YF42)		22
20	MF19058-4-3BAC		.NUTPLATE- (V15653) (SPEC BACN10YF43)		14
25	BRM200A08		.NUTPLATE- (V52828) (SPEC BACN10JP08A) (OPT MK1000-08BAC (V15653)) (OPT NS103197-82 (V80539)) (OPT RMA9201M82 (V72962)) (OPT T8076S832 (V11815)) (OPT VN202A1-82 (V92215))		1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
05-					
27	NAS1330H4K211L		.NUT	C-H	3
30	141T6206-3		.BRACKET ASSY-STOP BOLT ATTACHING PARTS		1
35	HL10VAZ5-5		.BOLT- (V60516) (SPEC BACB30MY5K5) (OPT B30MY5K5 (V97928))		2
40	HL70-5		.COLLAR- (V56878) (SPEC BACC30M5) (OPT HL70-5 (V73197)) (OPT HL70-5 (V92215)) (OPT 66014-5 (V56878)) (OPT HL79-5 (V5M902)) -------*-------		2
45	BACR15BA3AD		..RIVET- (SIZE DETERMINE ON INST)		4
50	MK4001-4BAC		..NUTPLATE- (V15653) (SPEC BACN10JP4DCM) (OPT NS103200SE048 (V80539)) (OPT T8083C428 (V11815)) (OPT VN204D1-048 (V92215)) (OPT 109A9209M4 (V72962))		2
55	141T6206-4		..BRACKET		1
60	NAS1394C4L		.INSERT		4
65	BACB28X4M050		.BUSHING		1
70	BACB28X6M050		.BUSHING		1
75	BACB28X4M016		.BUSHING		1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
05-					
80	BACB28X6M016		.BUSHING		1
85	BACB28X5M024		.BUSHING		4
90	BACB28X4C009		.BUSHING		1
95	BACB28X4M080		.BUSHING		1
100	143T6141-1		.FITTING ASSY-LWR TERM.	A,C,E,G	1
-105	143T6141-2		.FITTING ASSY-LWR TERM.	B,D,F,H	1
			ATTACHING PARTS		
110	BACB30NR4K10		.BOLT		2
115	AN960PD416		.WASHER		4
120	MS21042L4		.NUT		2
			-------*-------		
125	BACB28X4C020		..BUSHING		1
130	BACB28X6M016		..BUSHING		1
135	143T6141-3		..TERMINAL	A,C,E,G	1
-140	143T6141-4		..TERMINAL	B,D,F,H	1
145	BCREF5232		.SEAL- (V75165) (TN12501212ALCASTEFBU)		1
150	BCREF5231		.SEAL- (V75165) (TN11251212ALCASTEFBU)		2
155	BCREF5355		.SEAL- (V75165) (TN21881214ALCASTEFBU)		1
160	141T6133-78		.SUPPORT- (USED ON ITEM 1)	A,C	1
-160A	141T6133-94		.SUPPORT- (USED ON ITEM 1A)	C,E,G	1
-165	141T6133-77		.SUPPORT	B	1
-165A	141T6133-93		.SUPPORT	D,F,H	1

- Item Not Illustrated



Handle Assembly
Figure 6

967740

	FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
	06-					
	-1	143T6150-1		HANDLE ASSY	C,E,G	RF
	-5	143T6150-2		HANDLE ASSY	D,F,H	RF
	10	BACR15BA5D		.RIVET- (SIZE DETERMINE ON INST)	C-H	5
	15	141T6150-5		DELETED		
	15A	141T6160-5		.HANDLE ASSY	C,E,G	1
	-20	141T6150-6		DELETED		
	-20A	141T6160-6		.HANDLE ASSY	D,F,H	1
	25	141T6160-7		..HANDLE (OPT ITEM 25A)	C,E,G	1
	25A	141T6160-9		..HANDLE (OPT ITEM 25)	C,E,G	1
	-30	141T6160-8		..HANDLE (OPT ITEM 30A)	D,F,H	1
	30A	141T6160-10		..HANDLE (OPT ITEM 30)	D,F,H	1
	35	141T6160-3		..FILLER	C-H	1
	40	143T6152-2		.SHIM	C-H	1
	45	MS16562-37		.PIN-SPR	C-H	1
	50	143T6152-1		.PIN	C-H	1
	55	143T6154-1		DELETED		
R	55A	143T6154-5		.PAWL ASSY	C-H	1
	60	BACR15GA6		..RIVET- (SIZE DETERMINE ON INST)	C-H	1
R	65	PN3A		..BEARING-ROLLER (V60380) (SPEC BACB10B79LT) (OPT PN3ALT (V60380))	C-H	1

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
06-					
70	143T6154-2		DELETED		
70A	143T6154-6		..PAWL	C-H	1
75	BACW10P274G		.WASHER	C-H	AR
80	NNS57N003		.SPRING- (V01226)	C-H	1
85	143T6151-1		.HOUSING- (OPT ITEM 85A)	C-H	1
-85A	143T6151-3		.HOUSING- (OPT ITEM 85)	C-H	1

- Item Not Illustrated